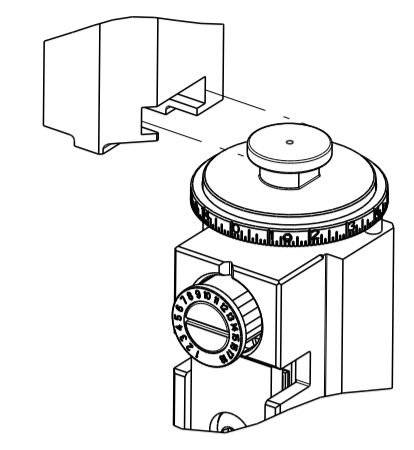


| PART NUMBER | REVISION | DESCRIPTION              | FEED TYPE  |
|-------------|----------|--------------------------|------------|
| 2151088-1   | N        | FINE CRIMP HEIGHT ADJUST | MECHANICAL |
| 2151088-2   | N        | FINE CRIMP HEIGHT ADJUST | PNEUMATIC  |
| 7-2151088-7 | F        | CRIMP TOOLING KIT        | -          |

ATLANTIC VERSION TERMINATOR  
INTERFACE ADAPTER



| APPLICATOR DATA |                |      |
|-----------------|----------------|------|
| CRIMP           | SIZE           | TYPE |
| WIRE            | 1.00 mm [.039] | F    |
| INSUL           | 1.07 mm [.042] | F    |

APPLICATOR INSTRUCTIONS  
408-35042

| TERMINAL DATA: TE TERMINAL                   |              | TE CRIMP SPECIFICATION       |              |
|--|--------------|------------------------------|--------------|
| TERMINAL NAME: MINI CT CONNECTOR 1.5MM PITCH |              |                              |              |
| WIRE STRIP LENGTH                            |              | INSULATION DIAMETER RANGE    |              |
| 1.90-2.30 mm [.075-.091 IN]                  |              | Ø0.85-1.05 mm [.033-.041 IN] |              |
| TERMINAL APPLICATION SPECIFICATION           | (A)114-5245  | -                            | -            |
| TERMINALS APPLIED                            |              |                              |              |
| TE TERMINAL                                  | TE TERMINAL  | TE TERMINAL                  | TE TERMINAL  |
| (A) 353907-1                                 | (A) 353907-2 | (A) 353907-3                 | (A) 353907-4 |

| TERMINAL DATA: TE TERMINAL                   |               | TE CRIMP SPECIFICATION       |              |
|--|---------------|------------------------------|--------------|
| TERMINAL NAME: MINI CT CONNECTOR 1.5MM PITCH |               |                              |              |
| WIRE STRIP LENGTH                            |               | INSULATION DIAMETER RANGE    |              |
| 1.90-2.30 mm [.075-.091 IN]                  |               | Ø0.95-0.95 mm [.037-.037 IN] |              |
| TERMINAL APPLICATION SPECIFICATION           | (B)114-5245-1 | -                            | -            |
| TERMINALS APPLIED                            |               |                              |              |
| TE TERMINAL                                  | TE TERMINAL   | TE TERMINAL                  | TE TERMINAL  |
| (B) 353907-1                                 | (B) 353907-2  | (B) 353907-3                 | (B) 353907-4 |

| WIRE SIZE                     | CRIMP HEIGHT mm [INCH]     | CRIMP HEIGHT REFERENCE SETTING |
|-------------------------------|----------------------------|--------------------------------|
| 24 AWG OR 0.23mm <sup>2</sup> | 0.75+/-0.03 [.030+/- .001] | 9.2                            |
| 26 AWG OR 0.14mm <sup>2</sup> | 0.69+/-0.03 [.027+/- .001] | 9.9                            |
| 28 AWG OR 0.09mm <sup>2</sup> | 0.64+/-0.03 [.025+/- .001] | 10.4                           |

| WIRE SIZE                     | CRIMP HEIGHT mm [INCH]     | CRIMP HEIGHT REFERENCE SETTING |
|-------------------------------|----------------------------|--------------------------------|
| 27 AWG OR 0.12mm <sup>2</sup> | 0.69+/-0.03 [.027+/- .001] | 8.1                            |

- RECOMMENDED SPARE PARTS
- REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242.
- CRIMP HEIGHT REFERENCE SETTING WAS THE SETTING USED WHEN THE APPLICATOR WAS QUALIFIED AT THE FACTORY. ADJUSTMENT MAY BE NECESSARY WHEN RUNNING APPLICATOR IN THE FIELD.
- TERMINAL LUBRICANT IS RECOMMENDED.
- 6. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.

**\*WARNING**  
ON INSTALLATION, SET WIRE DISC TO CRIMP HEIGHT REFERENCE SETTING FOR LARGEST WIRE SIZE. CRIMP HEIGHT REFERENCE SETTINGS GREATER THAN THE VALUE SHOWN MAY CAUSE DAMAGE TO THE CRIMP TOOLING. REFER TO THE INSTRUCTION SHEET FOR PROPER SETUP AND ADJUSTMENTS.

| LOC | DIST | REVISIONS |               |           |        |
|-----|------|-----------|---------------|-----------|--------|
| A   | 66   | REV       | DATE          | BY        | CHK    |
|     |      | K         | ECR-17-006862 | 11MAY2017 | TB CT  |
|     |      | L         | ECR-18-006127 | 21APR2018 | TB JDG |
|     |      | M         | ECR-18-014248 | 07SEP2018 | KH JS  |
|     |      | N         | ECR-24-207909 | 06MAY2024 | TB RK  |

|   |     |     |             |                                     |     |
|---|-----|-----|-------------|-------------------------------------|-----|
| - | 1   | -   | 2119641-1   | FEED CAM, AIR FEED                  | 248 |
| - | 1   | 1   | 2119082-1   | CAM, SNAIL, INSULATION ADJUSTMENT   | 244 |
| - | 1   | 1   | 2079764-1   | WASHER, WAVE SPRING, CREST-TO-CREST | 243 |
|   | 1   | 1   | 2119083-1   | RETAINER, INSULATION DIAL           | 242 |
| - | 1   | 1   | 7-18023-7   | SCR, SKT HD CAP M3 X 4.0            | 241 |
| - | -   | 1   | 2119580-1   | MECHANICAL FEED ASSEMBLY            | 239 |
| - | 1   | -   | 2844940-1   | AIR FEED MODULE                     | 238 |
| - | REF | REF | 994970-2    | COUNTER, MAGNETIC                   | 164 |
| - | 1   | 1   | 1-18028-2   | WASHER, FLAT, REG M4                | 119 |
|   | 1   | 1   | 2119955-1   | ASSY, LUBRICATOR, SIDE FEED         | 113 |
| - | 1   | 1   | 2844908-1   | SCREW, LOCKING                      | 99  |
| - | 1   | 1   | 2844907-1   | POST, LOCKING                       | 98  |
| - | 1   | 1   | 1-455888-5  | SPACER, CRIMPER                     | 82  |
| - | 1   | 1   | 1803607-3   | DOCUMENTATION PACKAGE               | 71  |
| - | 1   | 1   | 1-2119791-3 | DEPRESSOR, WIRE                     | 70  |
| - | 1   | 1   | 2119740-1   | TAG, IDENTIFICATION                 | 67  |
| - | 2   | 2   | 2168078-1   | SCREW, DRIVE, RH, RoHS, 2 x .188    | 66  |
| - | 1   | 1   | 2168083-2   | SCR, SKT HD CAP, RoHS, M4 X 8.0     | 60  |
| - | 1   | 1   | 5-18022-5   | SCR, HEX HD CAP, M4 X 6.0           | 59  |
| - | 1   | 1   | 1338685-1   | PAWL, FEED                          | 56  |
| - | 4   | 4   | 2168083-3   | SCR, SKT HD CAP, RoHS, M4 X 12.0    | 54  |
| - | 1   | 2   | 18023-9     | SCR, SKT HD CAP M4 X 6.0            | 49  |
| - | -   | 1   | 2119652-1   | FEED CAM, PRE FEED                  | 48  |
| - | -   | 1   | 2119653-1   | FEED CAM, POST FEED                 | 47  |
| - | 1   | 1   | 1803583-9   | APPLICATOR BASIC ASSEMBLY, SF       | 46  |
| - | 1   | 1   | 1803515-1   | RAM ASSEMBLY, SF ATLANTIC           | 44  |
| - | 1   | 1   | 1803602-1   | SCR, BHSC, RoHS (M8 X 25)           | 41  |
| - | 1   | 1   | 2-1752356-6 | SUPPORT, TERMINAL                   | 34  |
| - | 2   | 2   | 2079383-5   | SCR, BHSC, RoHS (M4 X 20)           | 33  |
| - | 2   | 2   | 2-2844962-4 | SPACER, CYLINDRICAL, STRIP GUIDE    | 30  |
| - | 1   | 1   | 2844992-1   | ASSEMBLY, STRIP GUIDE               | 29  |
| - | 1   | 1   | 1320928-2   | STRIP GUIDE                         | 24  |
| - | 1   | 1   | 2168083-2   | SCR, SKT HD CAP, RoHS, M4 X 8.0     | 21  |
| - | 1   | 1   | 1-18028-2   | WASHER, FLAT, REG M4                | 20  |
| - | 1   | 1   | 2119533-3   | STRIPPER, SIDE FEED                 | 19  |
|   | 1   | 1   | 2119806-1   | INSERT, SHEAR                       | 13  |
| - | 1   | 1   | 3-22280-3   | SPRING, COMPRESSION                 | 12  |
| - | 1   | 1   | 1-356885-4  | STOP, SHEAR                         | 11  |
|   | 1   | 1   | 1-2119805-5 | SHEAR HOLDER, FRONT                 | 10  |
|   | 1   | 1   | 1803095-6   | FLOATING SHEAR, FRONT               | 9   |
|   | 1   | 1   | 2-1803055-1 | ANVIL, COMBINATION                  | 8   |
| - | 1   | 1   | 2119757-3   | DEPRESSOR, SHEAR                    | 5   |
| - | 1   | 1   | 2-238011-2  | BLOCK, CRIMPER SPACER               | 4   |
|   | 1   | 1   | 4-1803017-4 | CRIMPER, INSULATION F               | 3   |
|   | 1   | 1   | 3-1633730-5 | CRIMPER, WIRE                       | 1   |

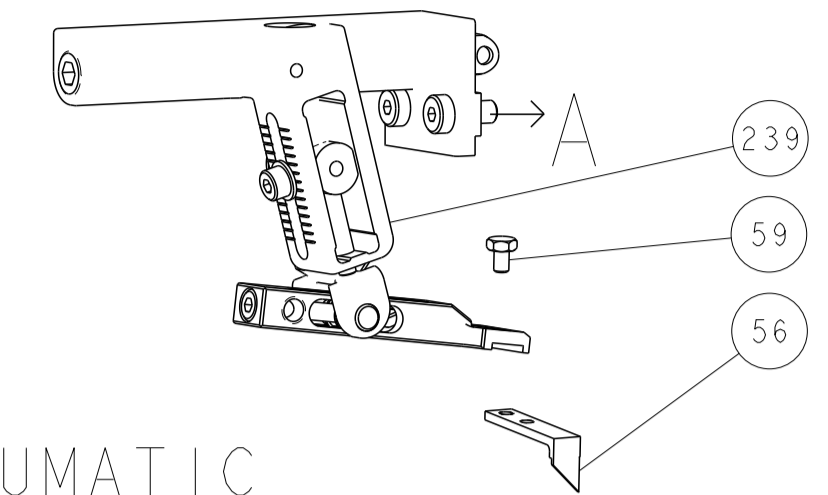
| DIMENSIONS: |         | TOLERANCES UNLESS OTHERWISE SPECIFIED: |         | MATERIAL: |         |
|-------------|---------|--|---------|-----------|---------|
| mm          | 0 PLC ± | 1 PLC ±                                | 2 PLC ± | 3 PLC ±   | 4 PLC ± |
|             | ANGLES  | FINISH                                 |         |           |         |

| REV | DATE      | BY      | CHK | DESCRIPTION                | ITEM NO |
|-----|-----------|---------|-----|----------------------------|---------|
| 1   | 10MAR2011 | C. CHEN |     | TE Connectivity            |         |
| 2   | 10MAR2011 | S. XI   |     | Harrisburg, PA 17105-3608  |         |
| 3   | 10MAR2011 | J. CRUZ |     | OCEAN SIDE FEED APPLICATOR |         |

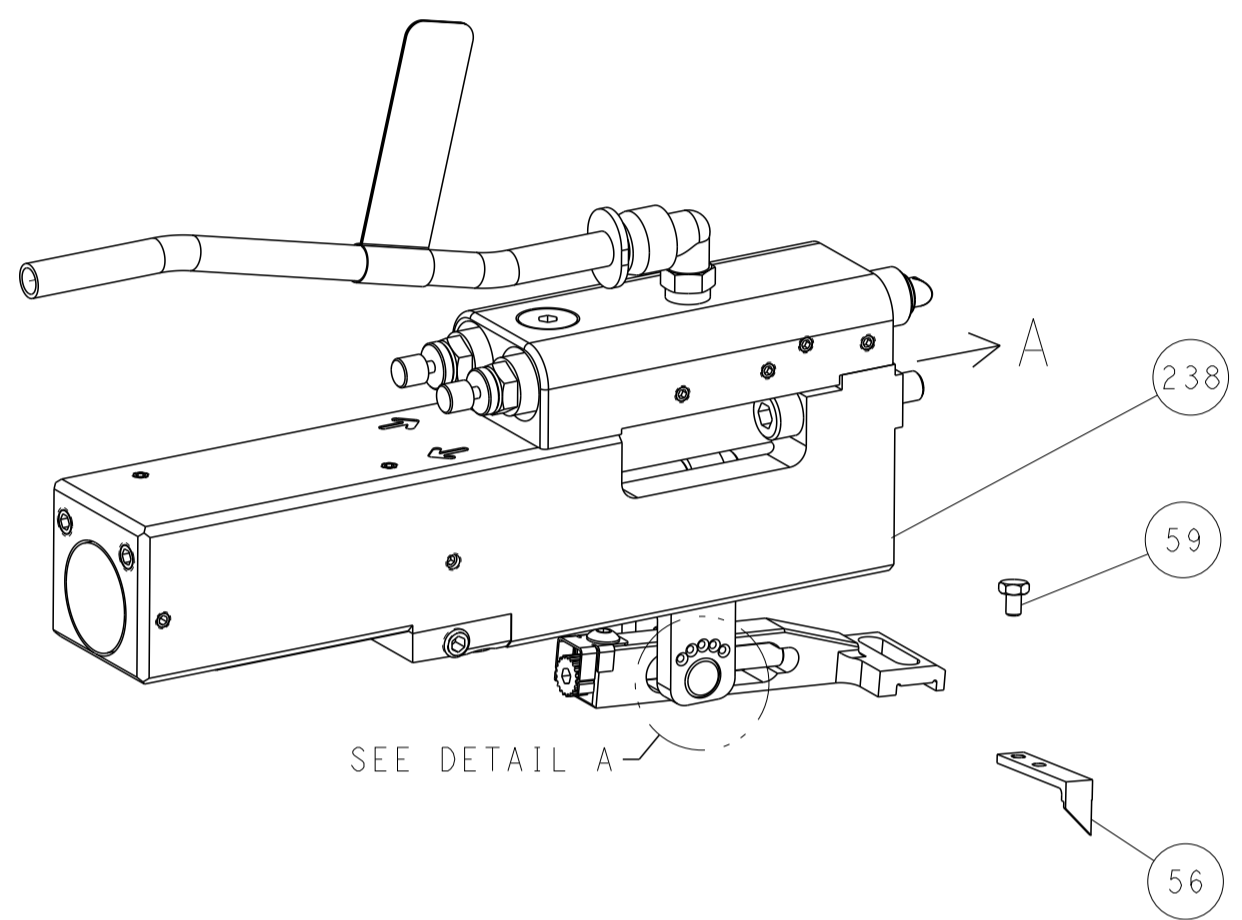
Customer Accessible Production Drawing SCALE 1:2 SHEET 1 OF 4 REV N

| LOC | DIST | REVISIONS |     |             |      |     |      |
|-----|------|-----------|-----|-------------|------|-----|------|
| A   | 66   | P         | LYN | DESCRIPTION | DATE | OWN | APVD |
| -   | -    | -         | -   | SEE SHEET 1 | -    | -   | -    |
|     |      |           |     |             |      |     |      |
|     |      |           |     |             |      |     |      |

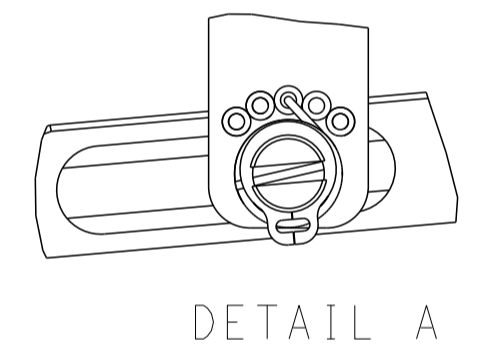
# FEED TYPE MECHANICAL



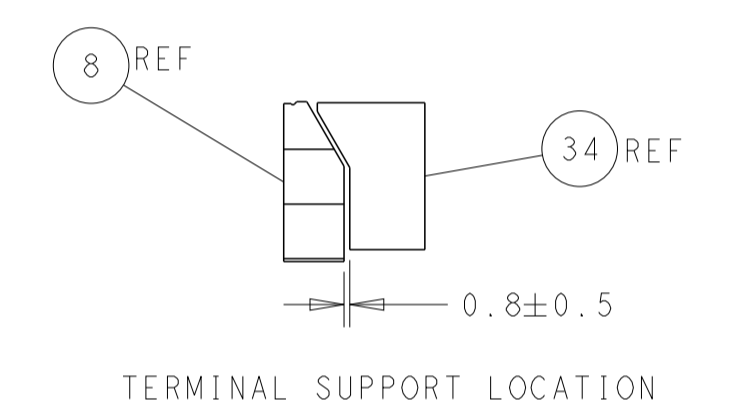
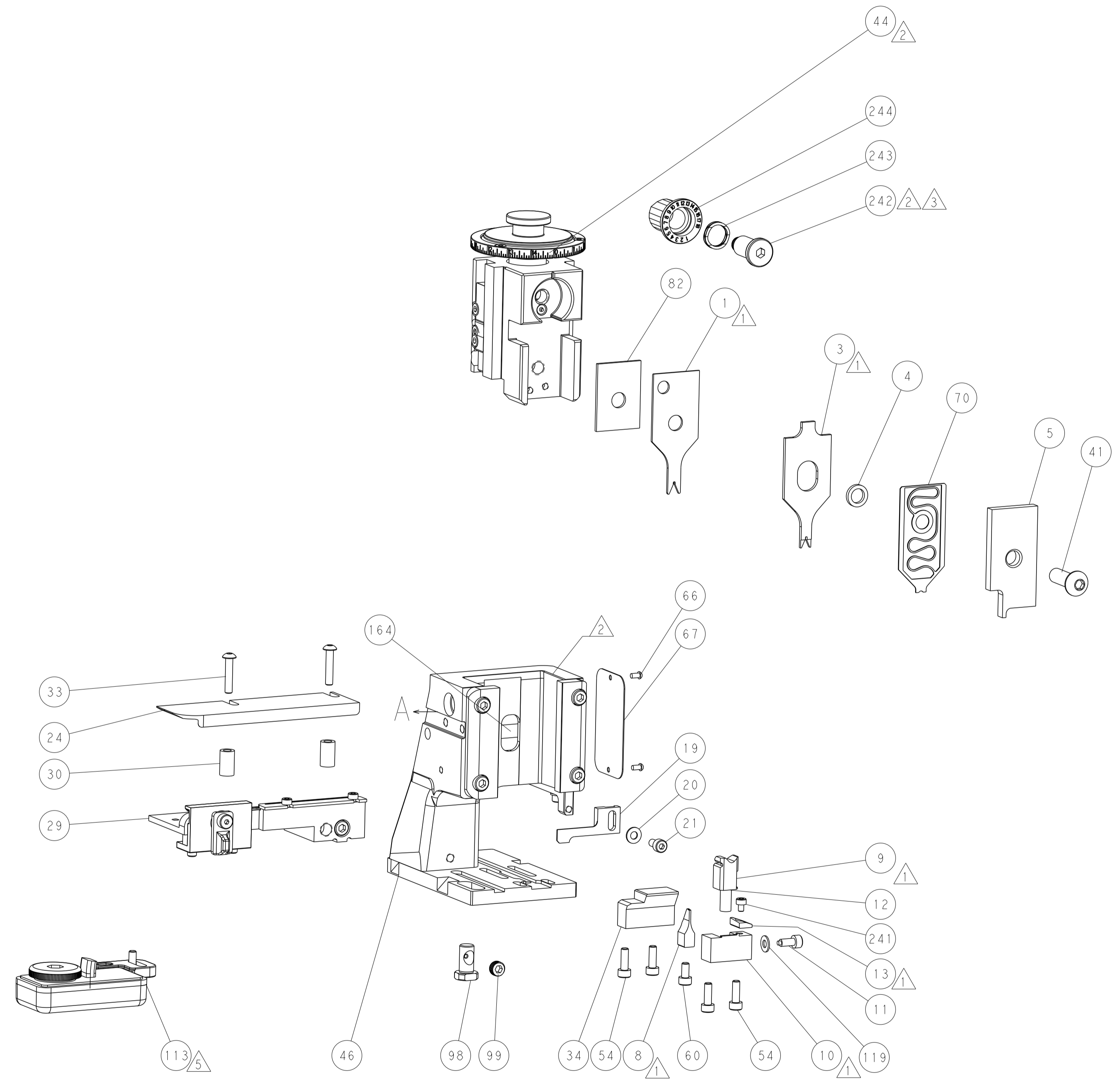
## PNEUMATIC



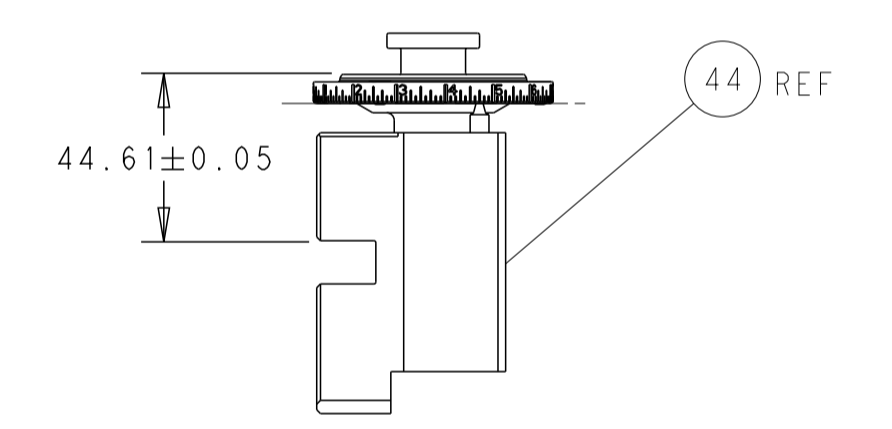
## FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



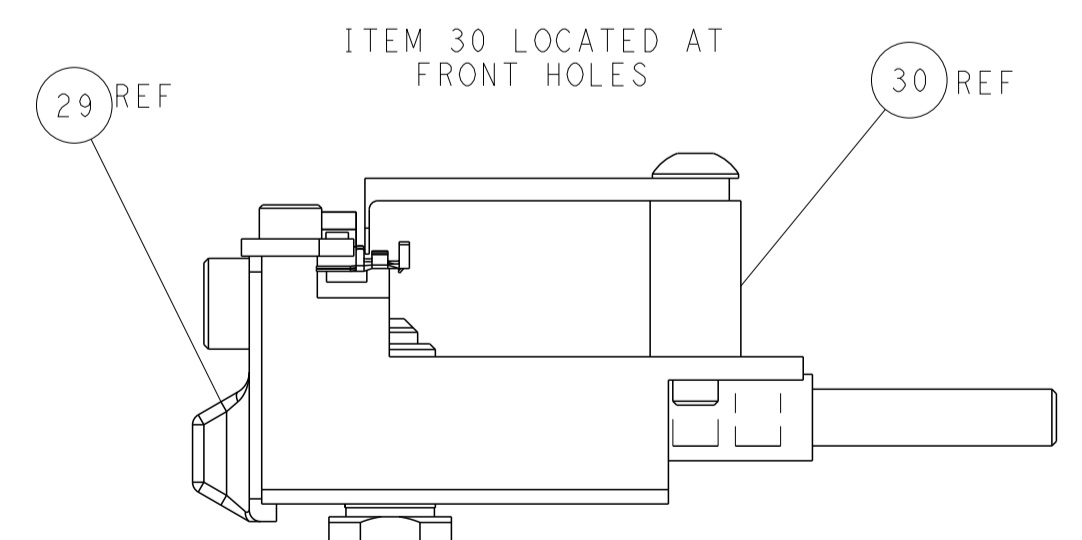
DETAIL A



TERMINAL SUPPORT LOCATION

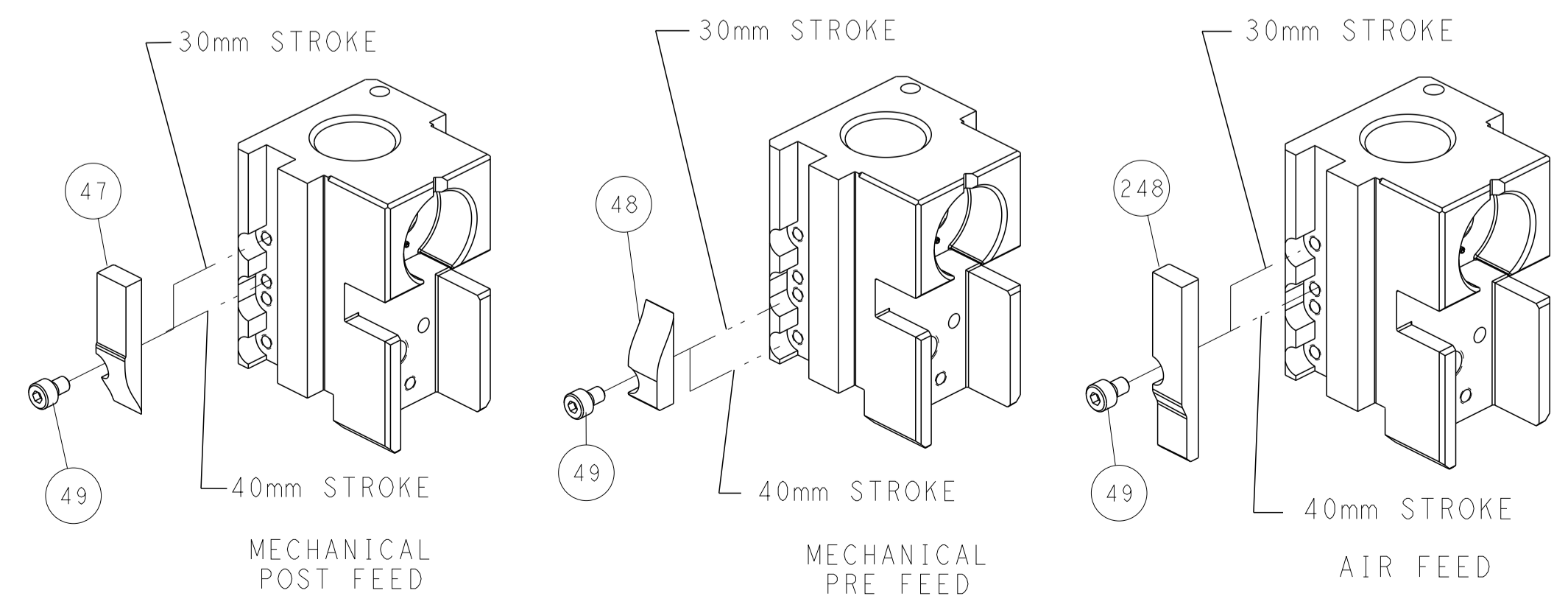


RAM SET-UP



FEED TRACK POSITION GUIDE BY INSULATION BARREL

# CAM POSITIONS



|   |   |   |   |  |
|---|---|---|---|--|
| <small>THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.</small>            |   | DWN: C. CHEN 10MAR2011<br>CHK: S. XI 10MAR2011<br>APVD: J. CRUZ 10MAR2011 | NAME: OCEAN SIDE FEED APPLICATOR<br>SIZE: A1<br>CAGE CODE: 00779<br>DRAWING NO: C=2151088 | TE Connectivity<br>Harrisburg, PA 17105-3608 |
| DIMENSIONS: mm<br>TOLERANCES UNLESS OTHERWISE SPECIFIED:<br>0 PLC ±<br>1 PLC ±<br>2 PLC ±<br>3 PLC ±<br>4 PLC ±<br>ANGLES ±<br>FINISH | DIMENSIONS: mm<br>TOLERANCES UNLESS OTHERWISE SPECIFIED:<br>0 PLC ±<br>1 PLC ±<br>2 PLC ±<br>3 PLC ±<br>4 PLC ±<br>ANGLES ±<br>FINISH | WEIGHT: -<br>SCALE: 1:2<br>SHEET: 2 OF 4<br>REV: N                        | RESTRICTED TO: -  | CUSTOMER ACCESSIBLE PRODUCTION DRAWING       |