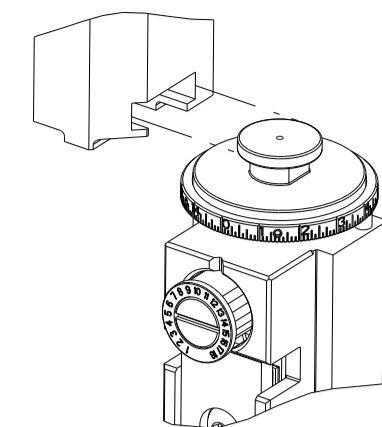


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151083-1	K	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2151083-2	K	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151083-1	K	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2151083-2	K	MECHANICAL AND CRIMP TOOLING KIT	PNEUMATIC
7-2151083-7	H	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



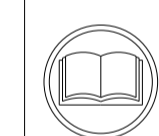
APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.40 mm [.055]	F
INSUL	1.78 mm [.070]	F

APPLICATOR INSTRUCTIONS
408-35042

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: DYNAMIC D1000 SERIES REC CONTACT			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
1.70-2.30 mm [.067-.091 IN]		Ø1.40-2.20 mm [.055-.087 IN]	
TERMINAL APPLICATION SPECIFICATION	114-5377	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
1827572-2	1871731-1	1903114-2	1903122-1

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: HD1 CONTACT 2L SIZE			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
1.70-2.30 mm [.067-.091 IN]		Ø1.40-2.20 mm [.055-.087 IN]	
TERMINAL APPLICATION SPECIFICATION	114-78021	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
2316663-4	2316670-4		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
18 AWG OR 0.86mm ²	1.15+/-0.03 [.045+/- .001]	4.8
20 AWG OR 0.52mm ²	1.00+/-0.03 [.039+/- .001]	6.3
22 AWG OR 0.35mm ²	0.85+/-0.03 [.033+/- .001]	7.8



- 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 ITEMS 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.
- USE TERMINAL SUPPORT 7-1752356-4 (ITEM 234) FOR TERMINAL 2316663-4. USE TERMINAL SUPPORT 8-1752356-7 (ITEM 34) FOR ALL OTHER TERMINALS.

***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.

ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

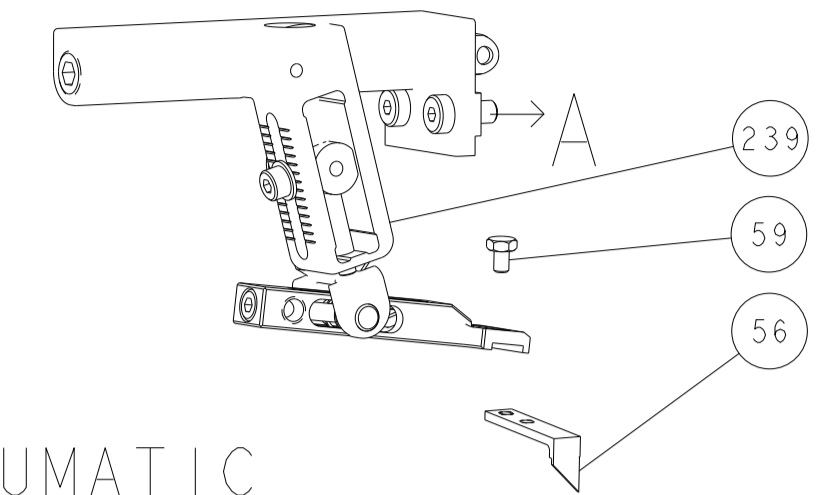
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		H		ECR-20-014197	06OCT2020	JWC	RK
		J		ECR-22-151337	02SEP2022	FZ	GB
		K		ECR-23-165048	31JAN2023	TB	TE

-	1	1	1	1	1803945-4	TONKER	300	
-	1	1	1	1	1-22278-9	SPRING, COMPRESSION	299	
-	2	2	2	2	4-18032-3	SCR, SET, FLT PNT, M3 X 6.0	298	
-	1	1	1	1	1803944-1	SPACER, TONKER	297	
-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248	
-	1	1	1	1	2119082-4	CAM, SNAIL, INSULATION ADJUSTMENT	244	
-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243	
-	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242	
-	1	1	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241	
-	-	1	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239	
-	1	-	1	-	2844940-1	AIR FEED MODULE	238	
-	1	1	1	1	7-1752356-4	SUPPORT, TERMINAL	234	
-	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164	
-	1	1	1	1	1-18028-2	WASHER, FLAT, REG M4	119	
-	1	1	1	1	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113	
-	1	1	1	1	2844908-1	SCREW, LOCKING	99	
-	1	1	1	1	2844907-1	POST, LOCKING	98	
-	1	1	1	1	455888-6	SPACER, CRIMPER	82	
-	1	1	1	1	5-547505-2	SPRING, COMPRESSION	77	
-	1	1	1	1	854769-4	HOLDER, INS	74	
-	1	1	1	1	1803607-3	DOCUMENTATION PACKAGE	71	
-	1	1	1	1	2119740-1	TAG, IDENTIFICATION	67	
-	2	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66	
-	1	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	60	
-	1	1	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59	
-	1	1	1	1	21028-2	PIN, SLOTTED SPRING .062 X .250	58	
-	1	1	1	1	1338685-1	PAWL, FEED	56	
-	4	4	4	4	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	54	
-	2	2	2	2	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	53	
-	1	2	1	2	18023-9	SCR, SKT HD CAP M4 X 6.0	49	
-	-	1	-	1	2119652-1	FEED CAM, PRE FEED	48	
-	-	1	-	1	2119653-1	FEED CAM, POST FEED	47	
-	1	1	1	1	1803583-9	APPLICATOR BASIC ASSEMBLY, SF	46	
-	1	1	1	1	1803515-1	RAM ASSEMBLY, SF ATLANTIC	44	
-	1	1	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41	
-	1	1	1	1	8-1752356-7	SUPPORT, TERMINAL	34	
-	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33	
-	2	2	2	2	2-2844962-4	SPACER, CYLINDRICAL, STRIP GUIDE	30	
-	1	1	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29	
-	1	1	1	1	455888-3	SPACER, CRIMPER	28	
-	1	1	1	1	1320928-2	STRIP GUIDE	24	
-	1	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21	
-	1	1	1	1	1-18028-2	WASHER, FLAT, REG M4	20	
-	1	1	1	1	2119533-1	STRIPPER, SIDE FEED	19	
-	1	1	1	1	2119806-1	INSERT, SHEAR	13	
-	1	1	1	1	3-22280-3	SPRING, COMPRESSION	12	
-	1	1	1	1	1-356885-4	STOP, SHEAR	11	
-	1	1	1	1	2119805-1	SHEAR HOLDER, FRONT	10	
-	1	1	1	1	1803095-6	FLOATING SHEAR, FRONT	9	
-	1	2	2	1	1	3-1729372-5	ANVIL	8
-	1	1	1	1	1-2119780-1	DEPRESSOR, SHEAR	5	
-	1	1	1	1	238011-6	BLOCK, CRIMPER SPACER	4	
-	1	2	2	1	1	2-1803384-6	CRIMPER, INSULATION F	3
-	1	1	1	1	455888-5	SPACER, CRIMPER	2	
-	1	2	2	1	1	4-1633730-4	CRIMPER, WIRE	1

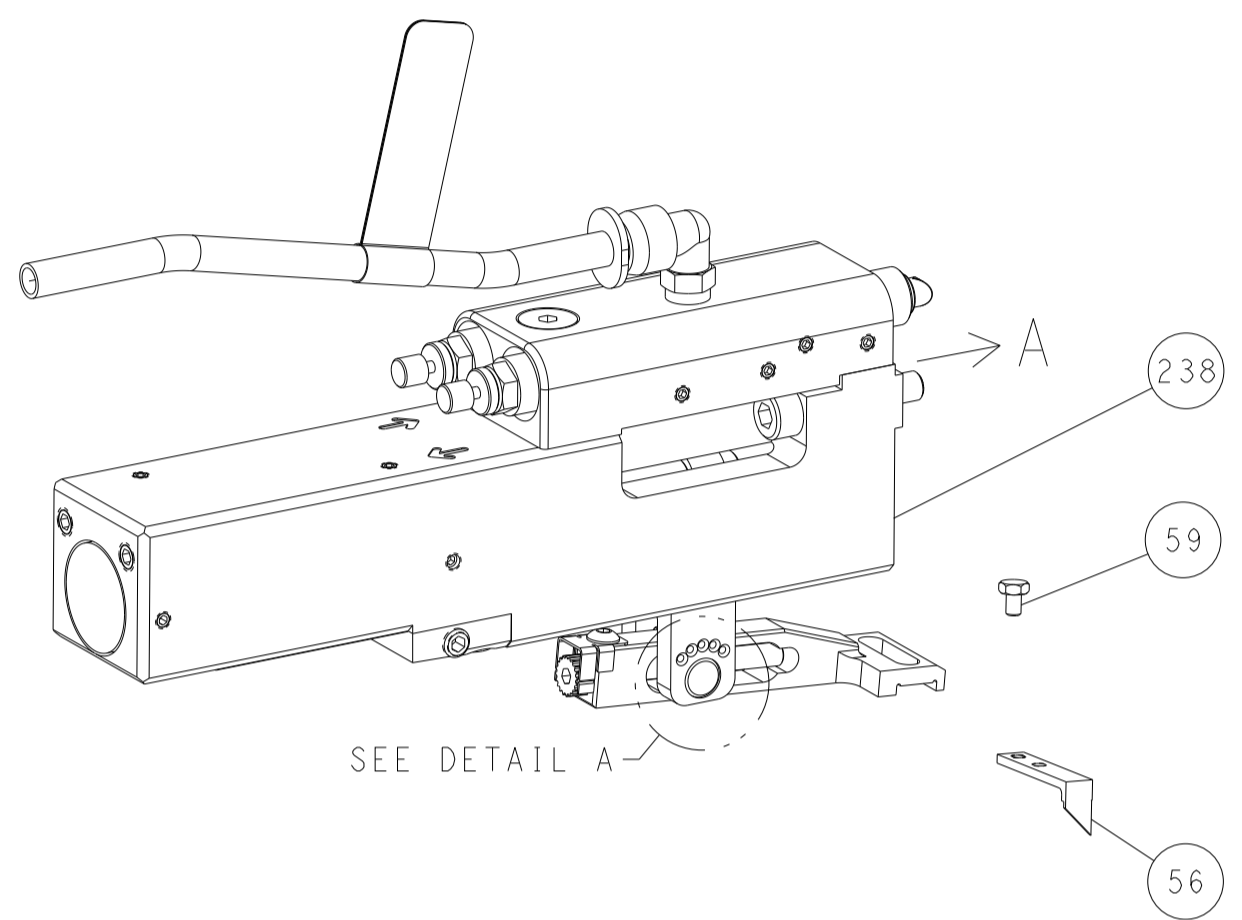
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		OWN	DATE	DESCRIPTION		ITEM NO
mm	0 PLC ±	1 PLC ±	2 PLC ±	H. HUANG	31AUG2011	TE Connectivity		
	3 PLC ±	4 PLC ±	ANGLES ±	CHK		Harrisburg, PA 17105-3608		
	FINISH			APVD	31AUG2011	NAME		
				S. XI		Ocean Side Feed		
				PRODUCT SPEC		Applicator		
				APPLICATION SPEC		SIZE	CAGE CODE	DRAWING NO
						A1	00779	2151083
				WEIGHT		Customer Accessible Production Drawing		SCALE
						1:2		SHEET 1 OF 4
								REV K

LOC	DIST	REVISIONS					
A	66	P	LTN	DESCRIPTION	DATE	DWN	APVD
		-		SEE SHEET 1		-	-

FEED TYPE MECHANICAL



PNEUMATIC

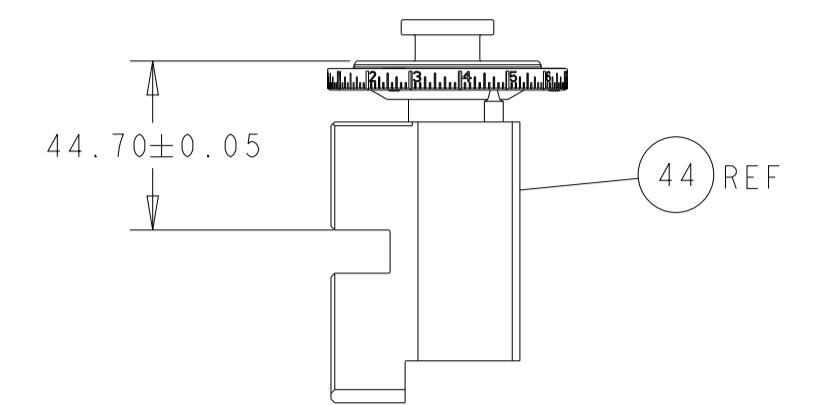
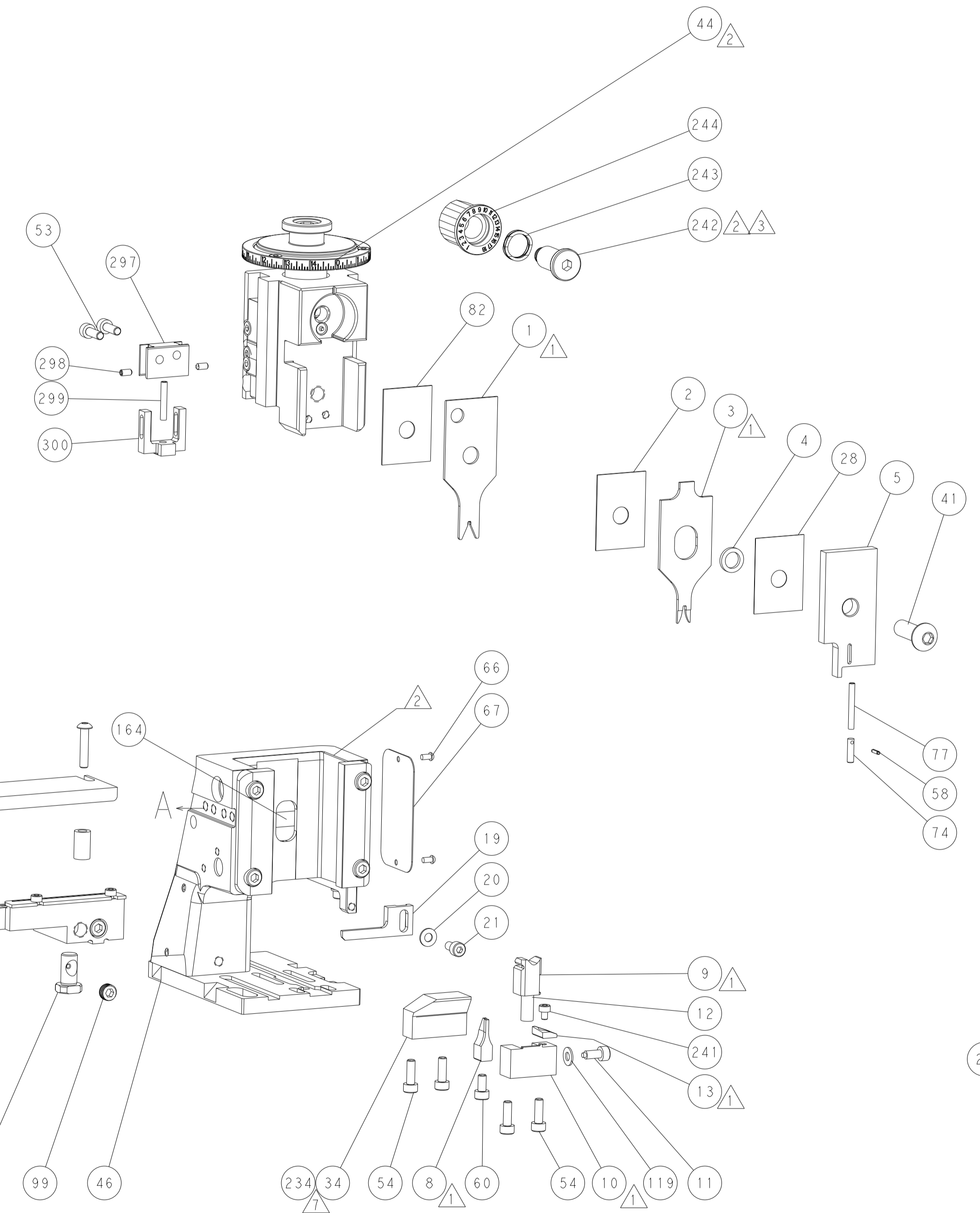
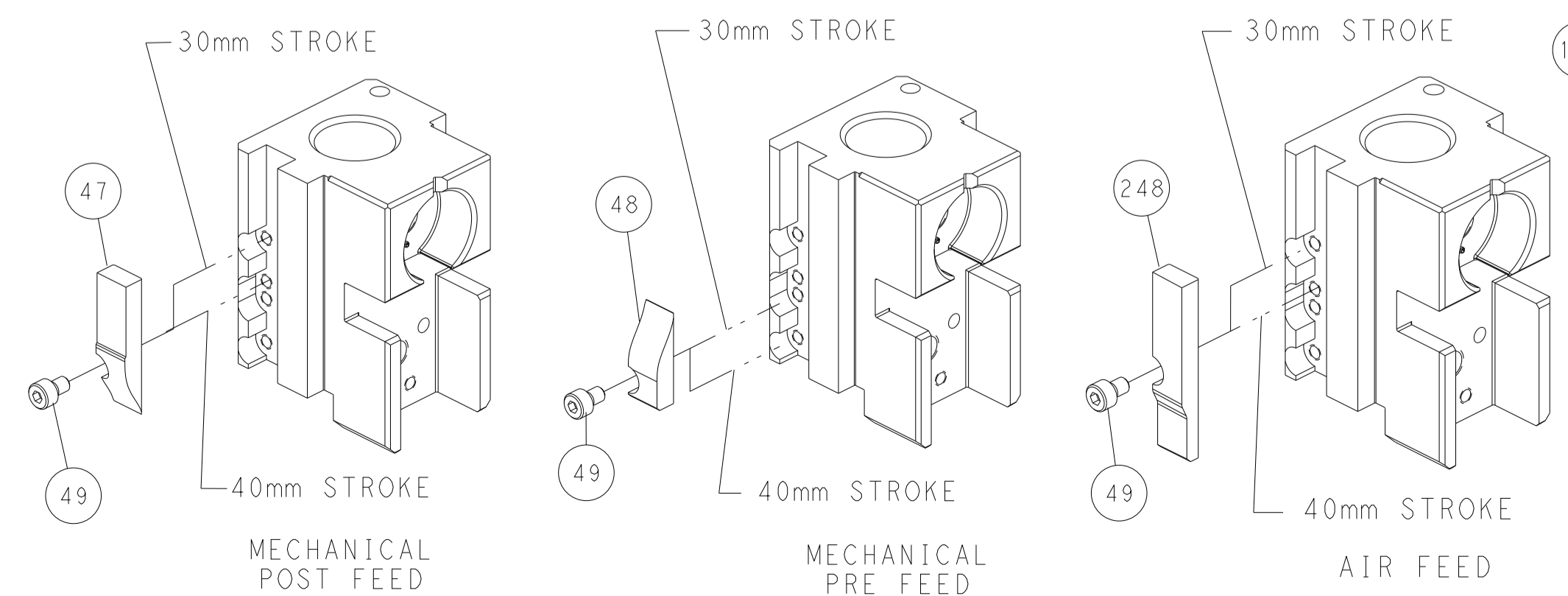


FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)

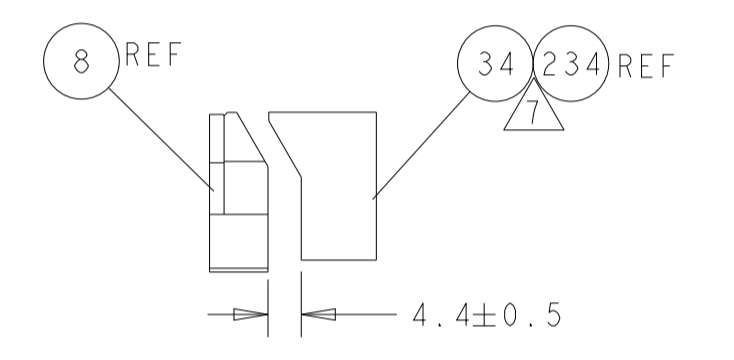


DETAIL A

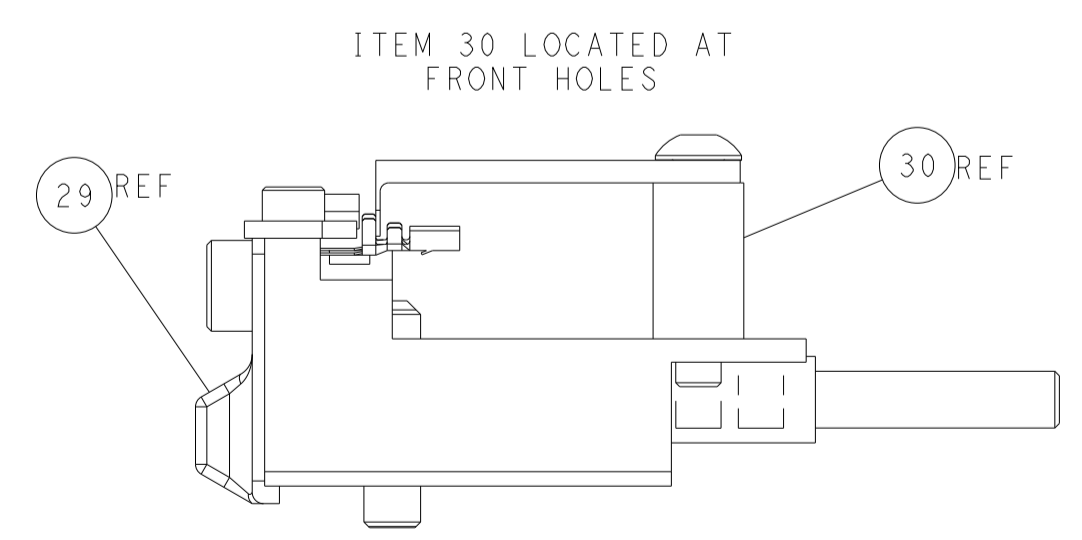
CAM POSITIONS



RAM SET-UP



TERMINAL SUPPORT LOCATION



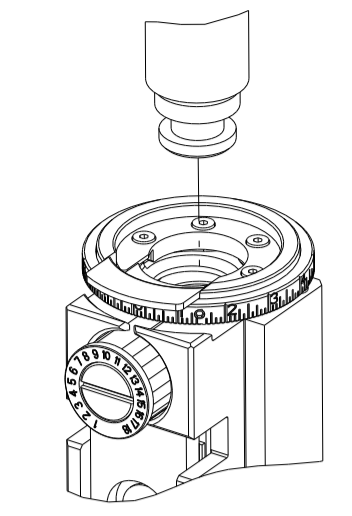
FEED TRACK POSITION GUIDE BY INSULATION BARREL

ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

<small>THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.</small>		DWN: R. HUANG CHK: S. XI APVD: S. XI PRODUCT SPEC: 31AUG2011 APPLICATION SPEC:	DATE: 31AUG2011 NAME: Ocean Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2151083 RESTRICTED TO:
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH:	WEIGHT: Customer Accessible Production Drawing SCALE: 1:2 SHEET: 2 of 4 REV: K	TE Connectivity Harrisburg, PA 17105-3608	

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2151083-1	K	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2151083-2	K	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151083-7	H	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.40 mm [.055]	F
INSUL	1.78 mm [.070]	F
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: DYNAMIC D1000 SERIES REC CONTACT			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
1.70-2.30 mm [.067-.091 IN]		Ø1.40-2.20 mm [.055-.087 IN]	
TERMINAL APPLICATION SPECIFICATION	114-5377	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
1827572-2	1871731-1	1903114-2	1903122-1

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: HD1 CONTACT 2L SIZE			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
1.70-2.30 mm [.067-.091 IN]		Ø1.40-2.20 mm [.055-.087 IN]	
TERMINAL APPLICATION SPECIFICATION	114-78021	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
2316663-4	2316670-4		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
18 AWG OR 0.86mm2	1.15+/-0.03 [.045+/-0.001]	4.8
20 AWG OR 0.52mm2	1.00+/-0.03 [.039+/-0.001]	6.3
22 AWG OR 0.35mm2	0.85+/-0.03 [.033+/-0.001]	7.8

- 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 ITEMS 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.
- USE TERMINAL SUPPORT 7-1752356-4 (ITEM 234) FOR TERMINAL 2316663-4.
USE TERMINAL SUPPORT 8-1752356-7 (ITEM 34) FOR ALL OTHER TERMINALS.

***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.

PACIFIC VERSION
Shown on sheets 3 of 4 & 4 of 4
(Atlantic version shown on sheets 1 of 4 & 2 of 4)

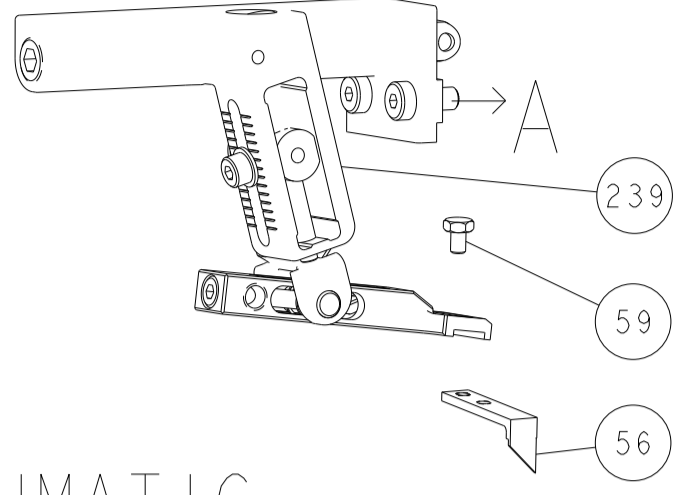
LOC	DIST	REVISIONS					
A	66	P	LTN	DESCRIPTION	DATE	OWN	APVD
-	-	-	-	SEE SHEET 1	-	-	-

-	1	1	1803945-4	TONKER			300
-	1	1	1-22278-9	SPRING, COMPRESSION			299
-	2	2	4-18032-3	SCR, SET, FLT PNT, M3 X 6.0			298
-	1	1	1803944-1	SPACER, TONKER			297
-	1	1	2119082-4	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
	1	1	7-1752356-4	SUPPORT, TERMINAL			234
-	REF	REF	994970-2	COUNTER, MAGNETIC			164
-	1	-	2119641-2	FEED CAM, AIR FEED			151
-	1	1	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16			144
-	4	4	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20			143
-	-	1	2119653-2	FEED CAM, POST FEED			142
-	1	1	1-1803583-0	APPLICATOR BASIC ASSEMBLY, SF			141
-	1	1	1803516-1	RAM ASSEMBLY, SF PACIFIC			140
-	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	455888-6	SPACER, CRIMPER			82
-	1	1	5-547505-2	SPRING, COMPRESSION			77
-	1	1	854769-4	HOLDER, INS			74
-	1	1	1803607-3	DOCUMENTATION PACKAGE			71
-	1	1	2119740-1	TAG, IDENTIFICATION			67
-	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188			66
-	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0			59
-	1	1	21028-2	PIN, SLOTTED SPRING .062 X .250			58
-	1	1	1338685-1	PAWL, FEED			56
-	2	2	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0			53
-	1	2	18023-9	SCR, SKT HD CAP M4 X 6.0			49
-	-	1	2119652-1	FEED CAM, PRE FEED			48
-	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)			41
	1	1	8-1752356-7	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	455888-3	SPACER, CRIMPER			28
-	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	2119533-1	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	2119805-1	SHEAR HOLDER, FRONT			10
	1	1	1803095-6	FLOATING SHEAR, FRONT			9
	1	1	3-1729372-5	ANVIL			8
-	1	1	1-2119780-1	DEPRESSOR, SHEAR			5
-	1	1	238011-6	BLOCK, CRIMPER SPACER			4
	1	1	2-1803384-6	CRIMPER, INSULATION F			3
-	1	1	455888-5	SPACER, CRIMPER			2
	1	1	4-1633730-4	CRIMPER, WIRE			1
-	77	-22	-21	PART NO			

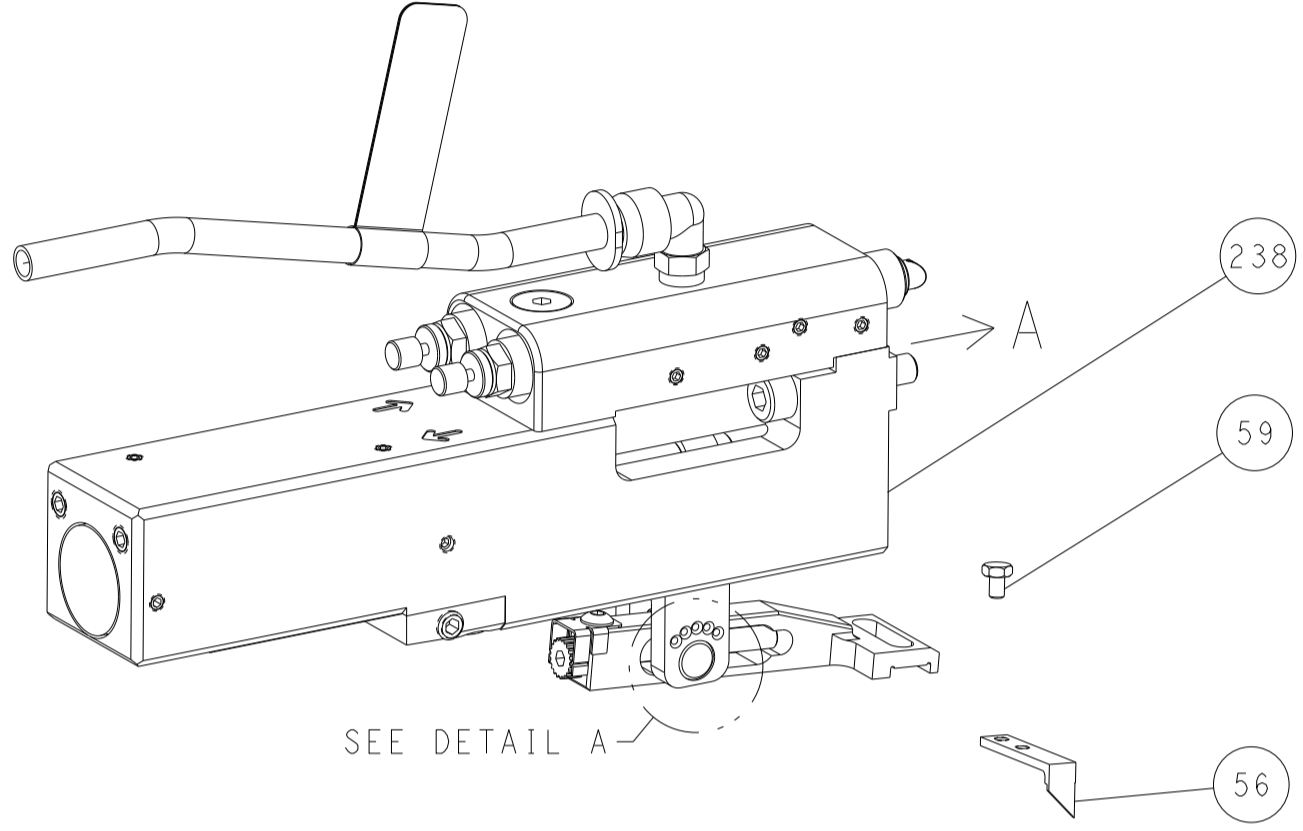
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		MATERIAL:		FINISH:	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES ±	FINISH ±
APVD: S. XI 31AUG2011		APVD: S. XI 31AUG2011		WEIGHT: -		SCALE: 1:2	
CUSTOMER ACCESSIBLE PRODUCTION DRAWING		SCALE: 1:2		SHEET: 3 OF 4		REV: K	

LOC	DIST	REVISIONS			
A	66	REV	DATE	BY	APPD
-	SEE SHEET 1	-	-	-	-

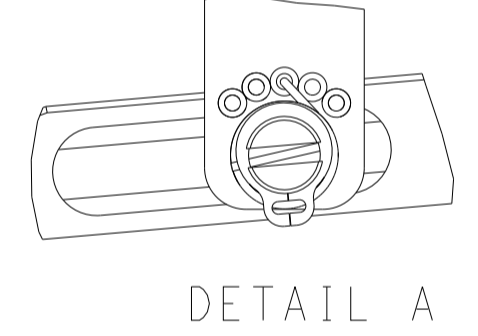
FEED TYPE MECHANICAL



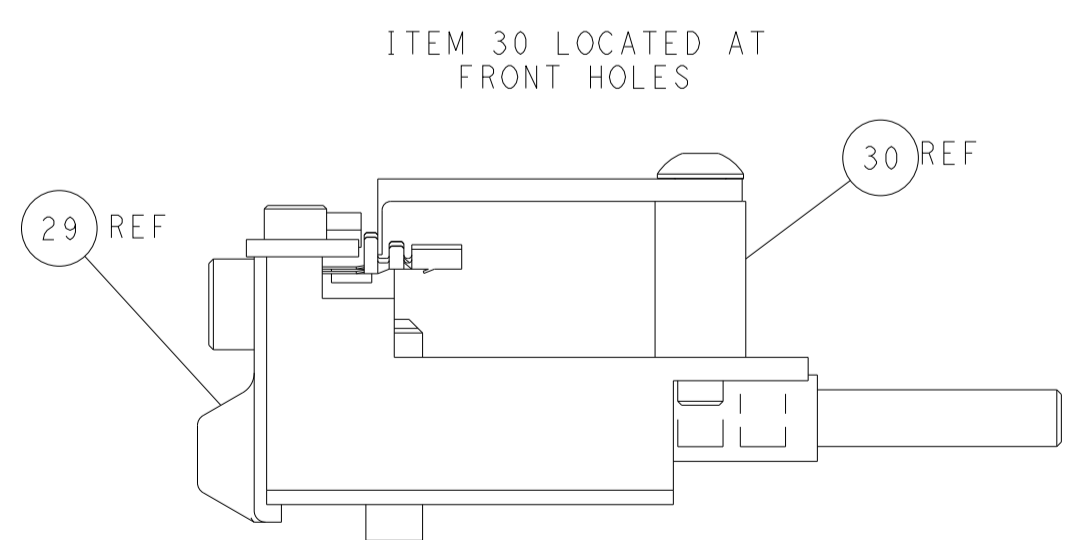
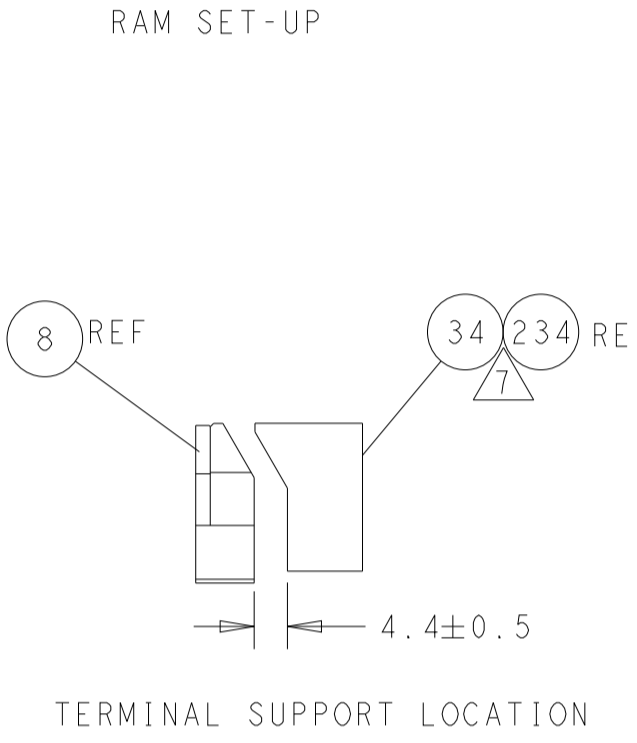
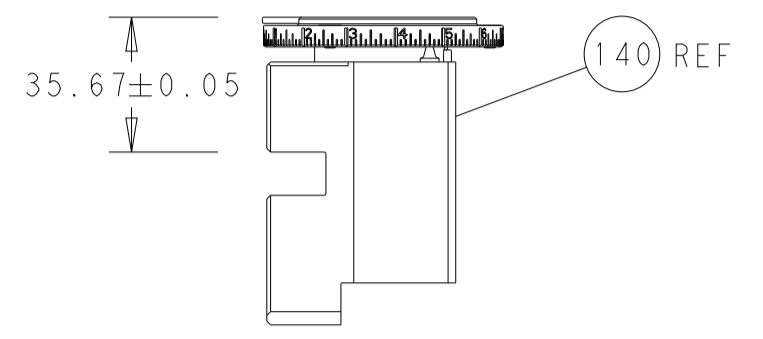
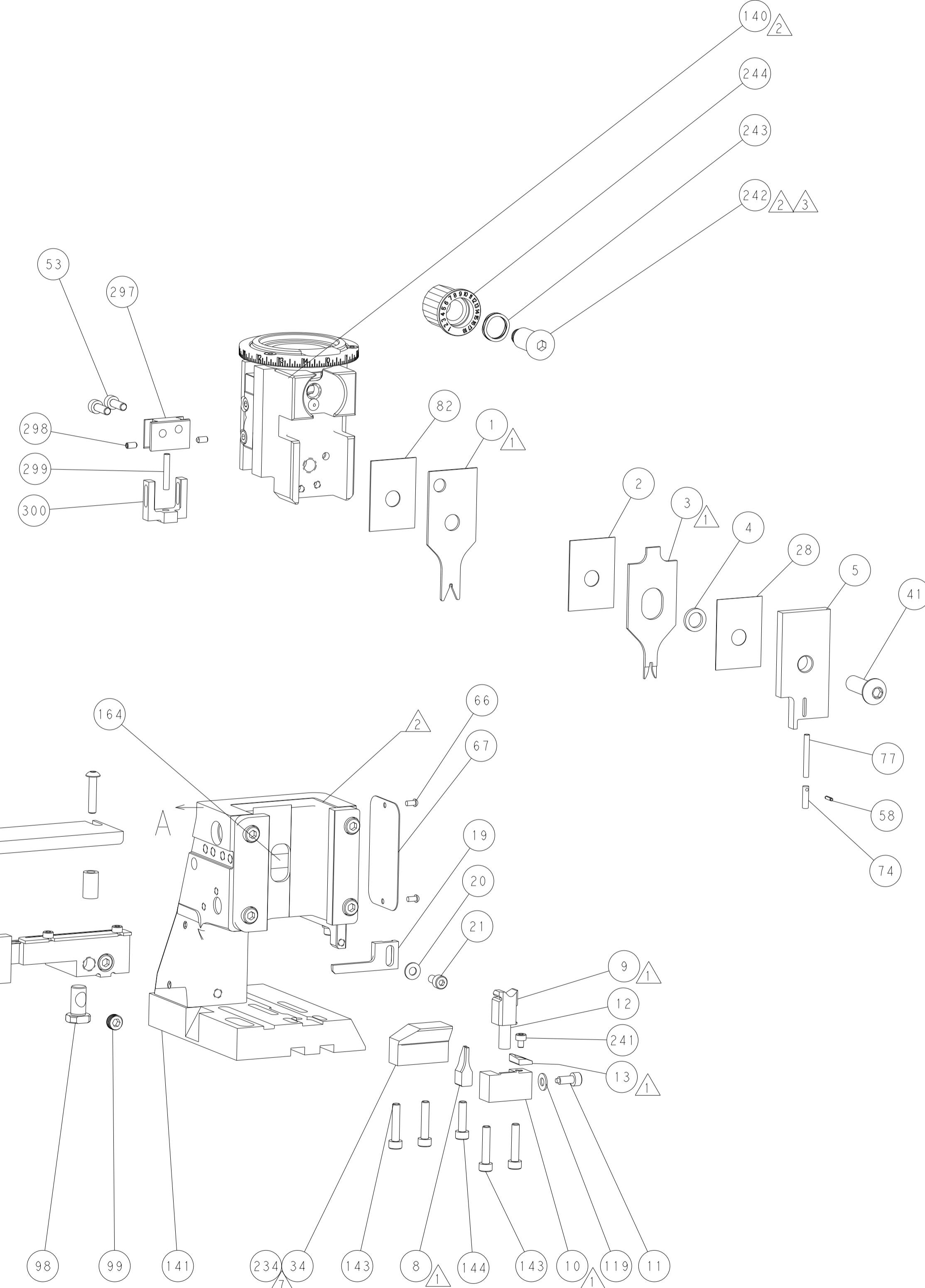
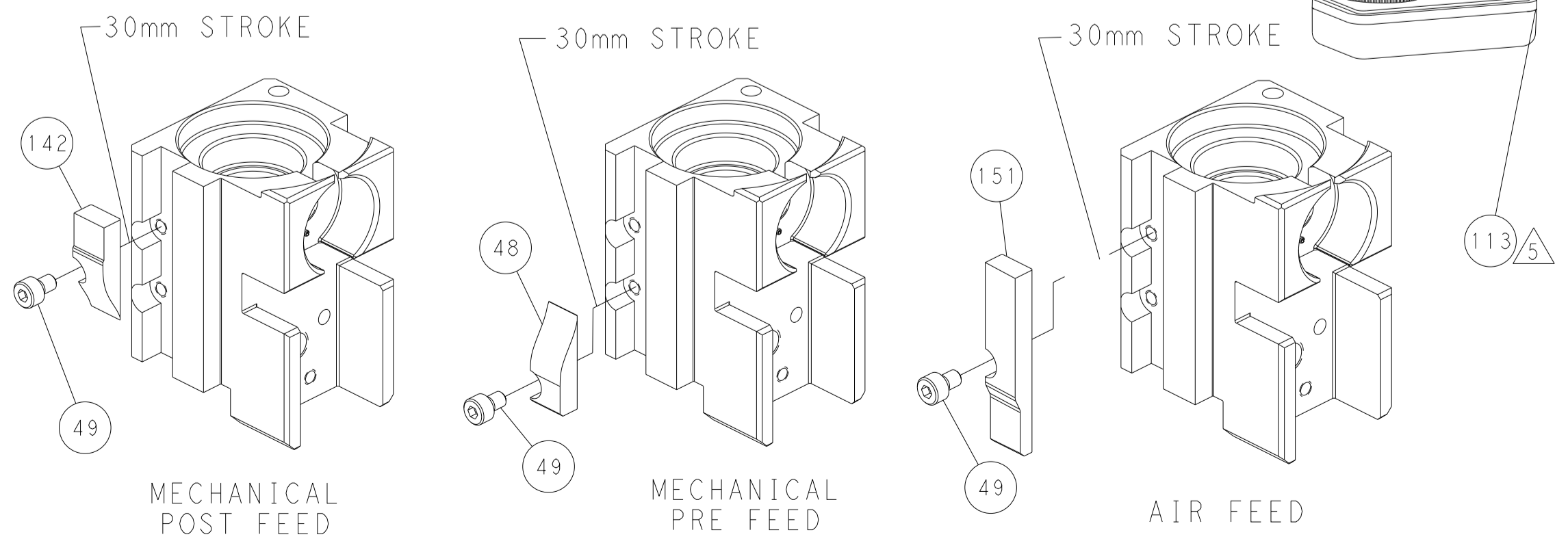
PNEUMATIC



FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



CAM POSITIONS



PACIFIC VERSION
 Shown on sheets 3 of 4 & 4 of 4
 (Atlantic version shown on sheets 1 of 4 & 2 of 4)

DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH ±		DWN: H. HUANG 31AUG2011 CHK: S. XI 31AUG2011 APVD: S. XI 31AUG2011 PRODUCT SPEC APPLICATION SPEC WEIGHT: A1 00779 SCALE: 1:2 SHEET: 4 OF 4 REV: K	
MATERIAL:		NAME: Ocean Side Feed Applicator SIZE: CAGE CODE: DRAWING NO: 2151083 RESTRICTED TO:		CUSTOMER ACCESSIBLE PRODUCTION DRAWING	