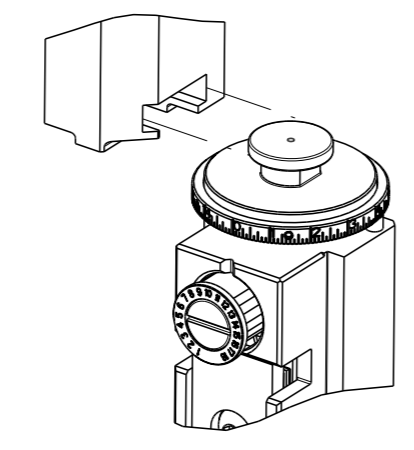


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151527-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2151527-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151527-1	C	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2151527-2	C	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2151527-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.57 mm [.062]	F
INSUL	1.57 mm [.062]	F

APPLICATOR INSTRUCTIONS  
408-35042

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: WIRE TO WIRE TIN PLATED			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
4.80-5.60 mm [.189-.220 IN]		Ø1.20-1.65 mm [.047-.065 IN]	
TERMINAL APPLICATION SPECIFICATION	114-6063		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
638174-4			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
22 AWG OR 0.35mm2	1.12+/-0.05 [.044+/-0.002]	6.8



- 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 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.

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

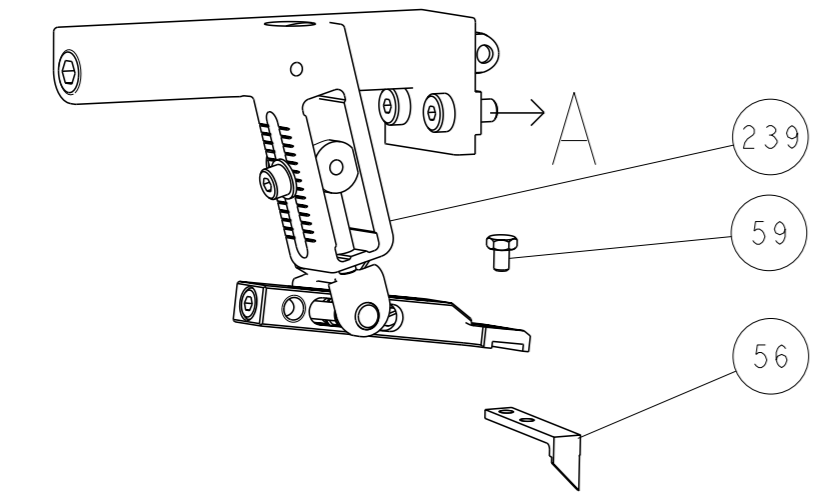
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A				RELEASED	15AUG2016	MR	TE
B				ECR-18-019622	17DEC2018	MZ	KZ
C				ECR-19-000947	18JAN2019	JAH	CT

REV	DATE	BY	CHK	DESCRIPTION	ITEM NO		
-	1	-	1	2119640-1	PUSH ROD, AIR FEED	250	
-	1	-	1	1803259-1	BUSHING, FLANGED	249	
-	1	-	1	2119641-1	FEED CAM, AIR FEED	248	
-	1	1	1	2119082-1	CAM, SNAIL, INSULATION ADJUSTMENT	244	
-	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243	
-	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242	
-	1	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241	
-	-	1	-	2119580-1	MECHANICAL FEED ASSEMBLY	239	
-	1	-	1	2063440-1	AIR FEED MODULE	238	
-	2	-	2	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172	
-	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164	
-	1	-	1	240638-1	SPRING, FEED FINGER	163	
-	1	-	1	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854	137	
-	1	-	1	2119799-1	HOLDER, FEED FINGER, AF	136	
-	1	1	1	1-22281-8	SPRING, COMPRESSION	121	
-	1	1	1	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113	
-	1	1	1	2844908-1	SCREW, LOCKING	99	
-	1	1	1	2844907-1	POST, LOCKING	98	
-	1	1	1	1-690438-0	FRONT STRIP GUIDE	96	
-	2	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	95	
-	1	1	1	2168083-6	SCR, SKT HD CAP, RoHS, M5 X 65	93	
-	1	1	1	455888-5	SPACER, CRIMPER	82	
-	2	2	2	2079383-4	SCR, BHSC, RoHS (M4 X 8)	79	
-	1	1	1	1803096-1	EXTENSION PLATE	78	
-	1	1	1	5-547505-2	SPRING, COMPRESSION	77	
-	1	1	1	854769-4	HOLDER, INS	74	
-	1	1	1	1803607-1	DOCUMENTATION PACKAGE	71	
-	1	1	1	2119791-5	DEPRESSOR, WIRE	70	
-	1	1	1	2119943-1	WASHER, SPACER	69	
-	1	1	1	2119740-1	TAG, IDENTIFICATION	67	
-	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66	
-	2	2	2	2-18032-5	SCR, SET, FLT PNT, M5 X 20.0	61	
-	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	60	
-	1	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59	
-	1	1	1	21028-2	PIN, SLOTTED SPRING .062 X .250	58	
-	1	1	1	1338685-1	PAWL, FEED	56	
-	4	4	4	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	54	
-	2	2	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	53	
-	1	1	1	5018030-1	NUT, HEX, REG, RoHS, M3	52	
-	1	1	1	811242-5	BUMPER, HOLD DOWN	51	
-	1	1	1	690753-2	SPACER, TONKER	50	
-	1	2	1	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	1	1803583-9	APPLICATOR BASIC ASSEMBLY, SF	46	
-	1	1	1	1803515-1	RAM ASSEMBLY, SF ATLANTIC	44	
-	1	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41	
-	1	1	1	1752356-1	SUPPORT, TERMINAL	34	
-	2	2	2	2079383-8	SCR, BHSC, RoHS (M4 X 16)	33	
-	2	2	2	1-2844962-3	SPACER, CYLINDRICAL, STRIP GUIDE	30	
-	1	1	1	2844938-1	PLATE, STRIP GUIDE	29	
-	1	1	1	455888-5	SPACER, CRIMPER	28	
-	2	2	2	22283-1	SPRING, COMPRESSION	27	
-	1	1	1	356835-1	LEVER, DRAG RELEASE	26	
-	1	1	1	240792-1	DRAG, TERMINAL	25	
-	1	1	1	1320928-4	STRIP GUIDE	24	
-	1	1	1	980371-4	SCR, SKT HD SHLDR 5.0 DIA X 6.0	23	
-	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21	
-	2	2	2	1-18028-2	WASHER, FLAT, REG M4	20	
-	1	1	1	2119533-1	STRIPPER, SIDE FEED	19	
-	1	1	1	2119806-1	INSERT, SHEAR	13	
-	1	1	1	3-22280-3	SPRING, COMPRESSION	12	
-	1	1	1	1-356885-4	STOP, SHEAR	11	
-	1	1	1	2119805-1	SHEAR HOLDER, FRONT	10	
-	1	1	1	318707-1	FLOATING SHEAR, FRONT	9	
-	1	2	2	1	5-1633918-5	ANVIL, COMBINATION	8
-	-	-	-	-	-	7	
-	-	-	-	-	-	6	
-	1	1	1	2119780-9	DEPRESSOR, SHEAR	5	
-	1	1	1	6-238011-7	BLOCK, CRIMPER SPACER	4	
-	1	2	2	1	7-1803187-9	CRIMPER, INSULATION F	3
-	1	1	1	455888-4	SPACER, CRIMPER	2	
-	1	2	2	1	3-456403-8	CRIMPER, WIRE PREMIUM	1
-	77	72	71	-2	-1	PART NO	

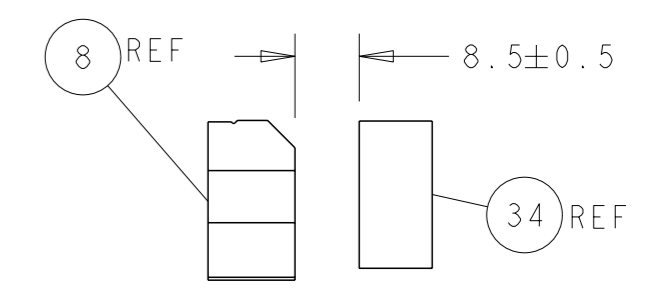
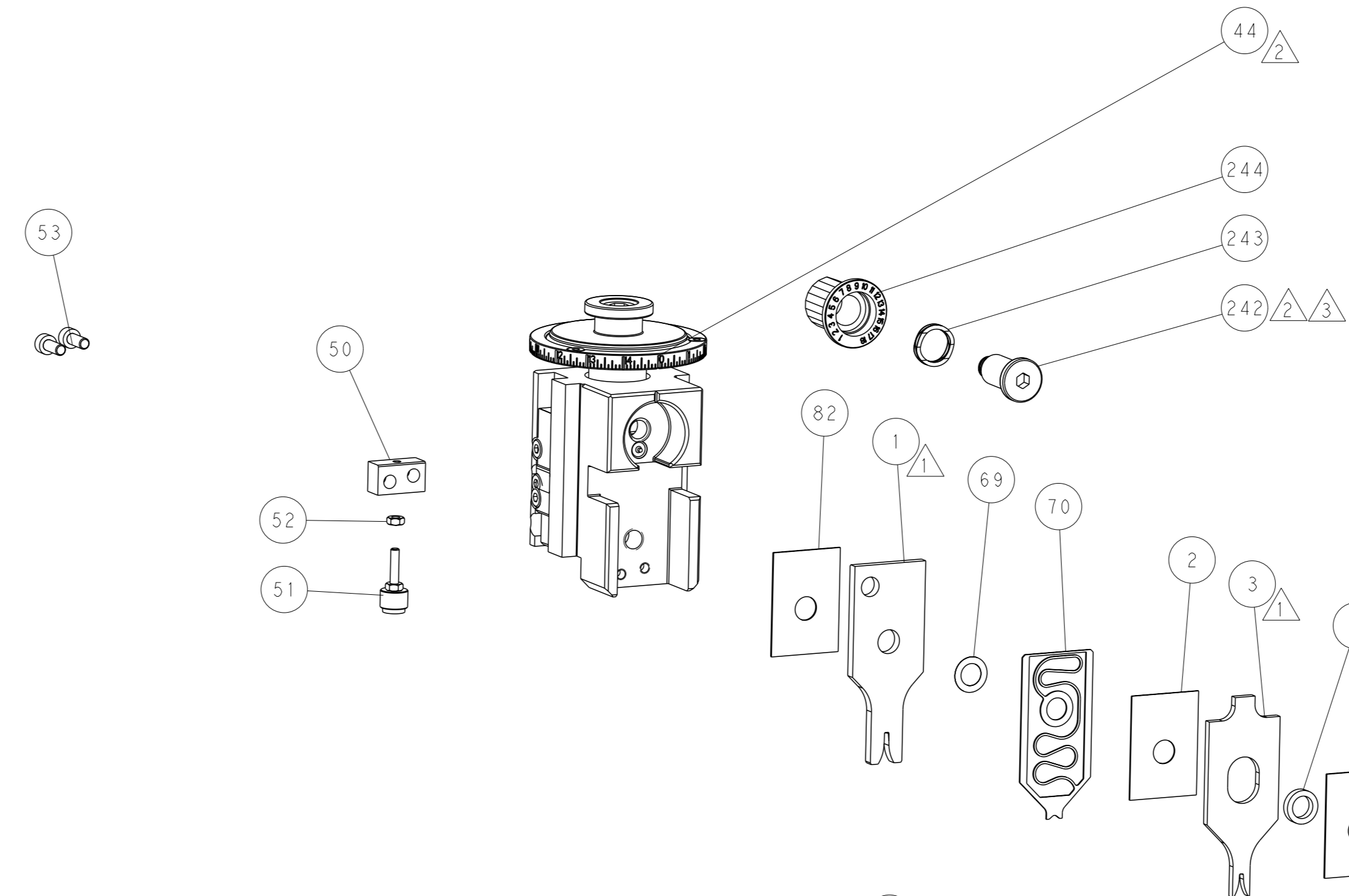
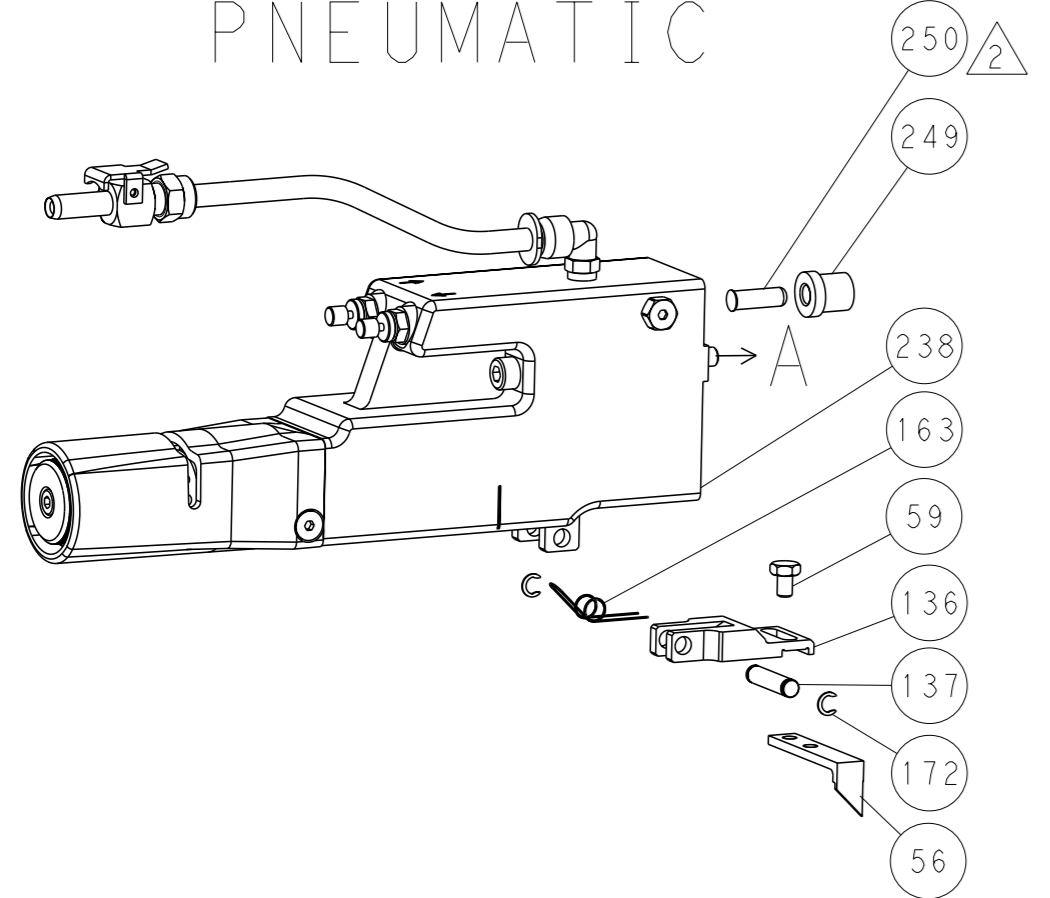
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DATE		NAME	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES ±	FINISH
MATERIAL				WEIGHT	SCALE	SHEET	REV
Customer Accessible Production Drawing				SCALE 1:2	SHEET 1 of 4	REV C	

LOC	DIST	REVISIONS			
A	66	REV	DATE	OWN	APVD
-	-	SEE SHEET 1	-	-	-

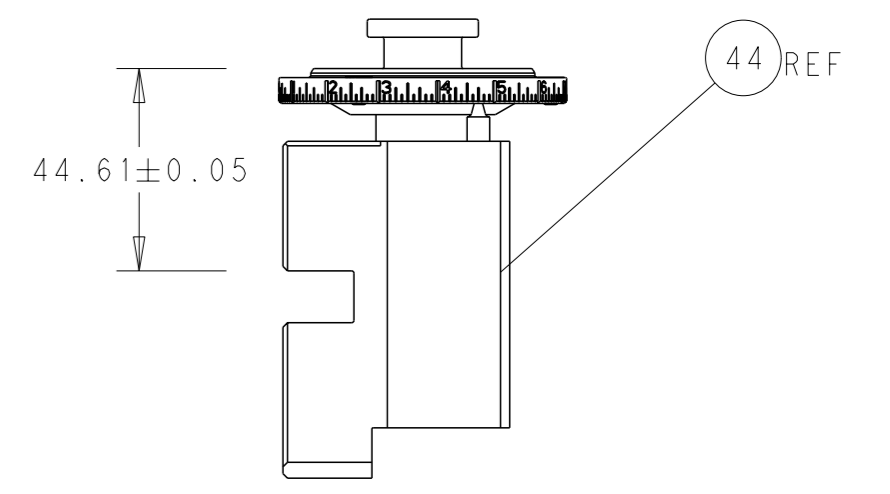
# FEED TYPE MECHANICAL



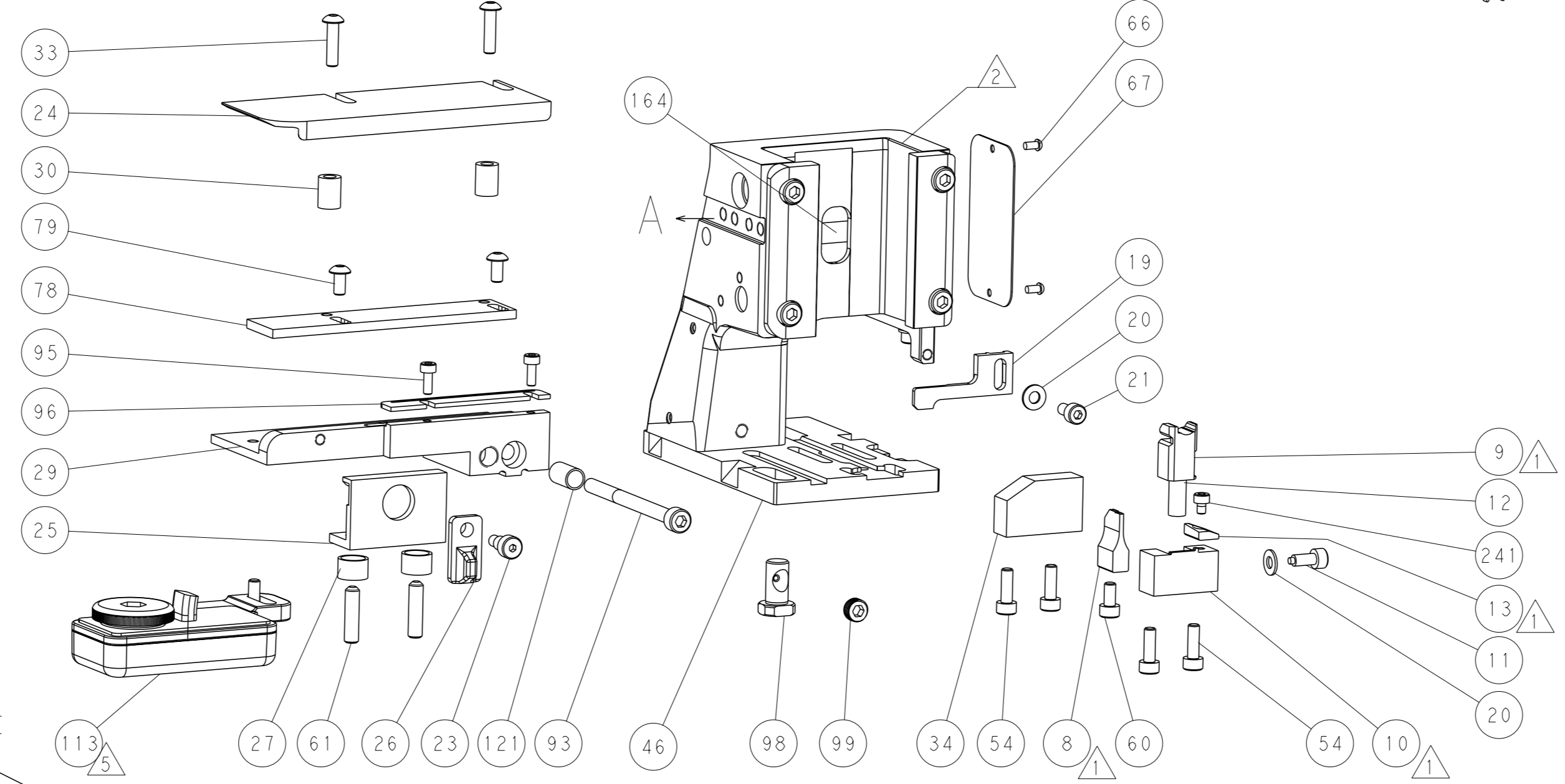
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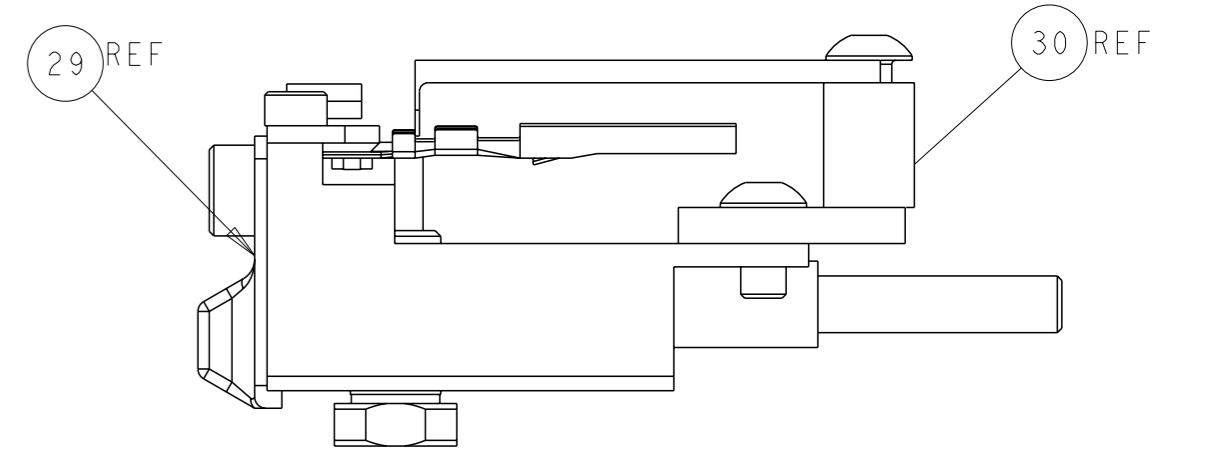
TERMINAL SUPPORT LOCATION



RAM SET-UP

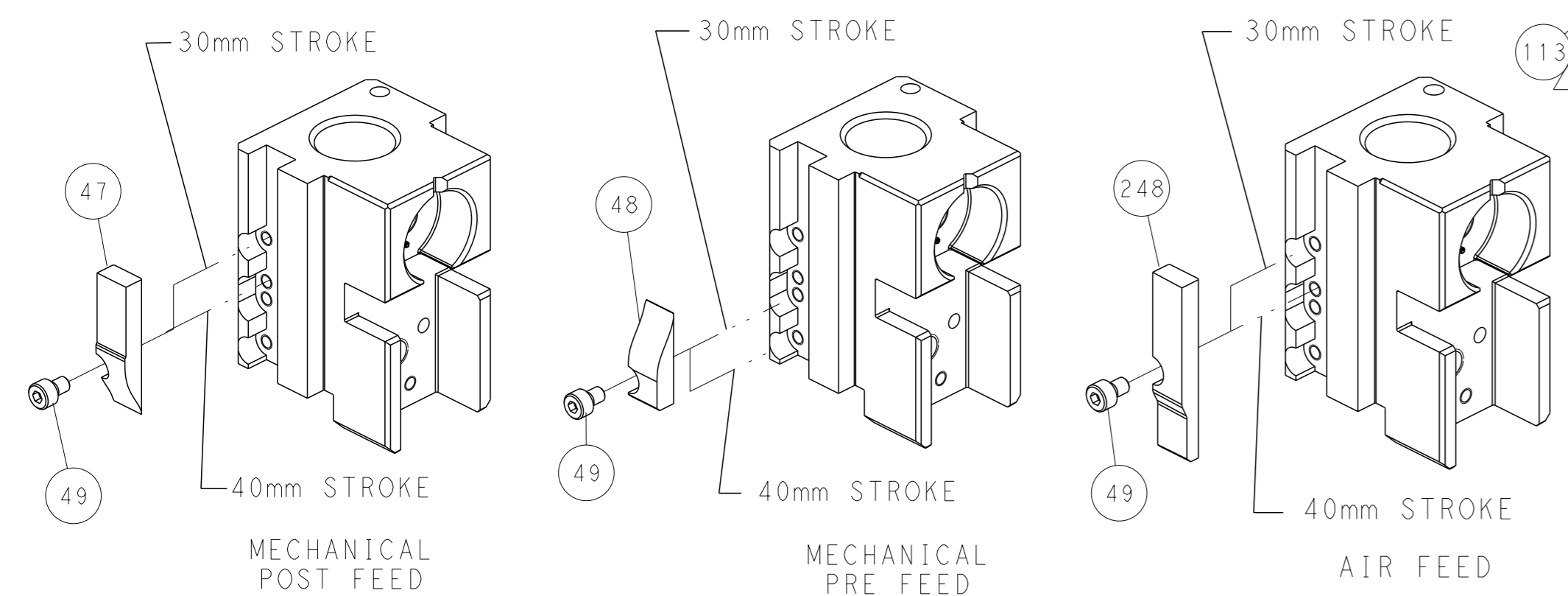


ITEM 30 LOCATED AT REAR HOLES



FEED TRACK POSITION GUIDE BY INSULATION BARREL

# CAM POSITIONS

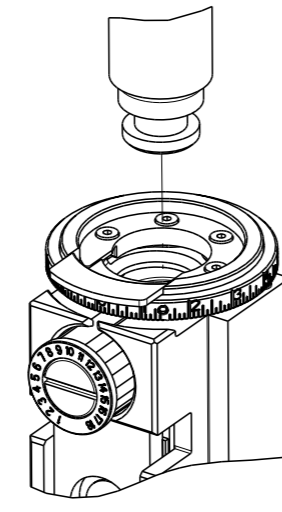


**ATLANTIC VERSION**  
 Shown on sheets 1 of 4 & 2 of 4  
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

<small>THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE AND THE CONTROL AND RESISTING DISPOSITION SHOULD BE CONTACTED FOR THE LATEST REVISION.</small>		OWN: J. HOU 15JUN2016 CHK: L. ZHANG 15JUN2016 APVD: L. ZHANG 15JUN2016	TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH ±		NAME: Ocean Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: ©=2151527	RESTRICTED TO: - SCALE: 1:2 SHEET: 2 of 4 REV: C
MATERIAL: - FINISH: -		WEIGHT: - Customer Accessible Production Drawing	SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

THIS DRAWING IS UNPUBLISHED.	RELEASED FOR PUBLICATION	20	
COPYRIGHT 20 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.			
PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2151527-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2151527-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151527-7	A	CRIMP TOOLING KIT	-

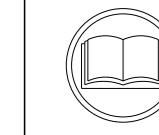
PACIFIC VERSION TERMINATOR  
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.57 mm [.062]	F
INSUL	1.57 mm [.062]	F
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION
TERMINAL NAME: WIRE TO WIRE TIN PLATED		
WIRE STRIP LENGTH 4.80-5.60 mm [.189-.220 IN]		INSULATION DIAMETER RANGE Ø1.20-1.65 mm [.047-.065 IN]
TERMINAL APPLICATION SPECIFICATION 114-6063		
TERMINALS APPLIED		
TE TERMINAL	TE TERMINAL	TE TERMINAL
638174-4		

WIRE SIZE 22 AWG OR 0.35mm2	CRIMP HEIGHT mm [INCH] 1.12+/-0.05 [.044+/-0.02]	CRIMP HEIGHT REFERENCE SETTING 6.8
--------------------------------	--	---------------------------------------



- 1 RECOMMENDED SPARE PARTS
- 2 REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- 3 APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242.
- 4 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.
- 5 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	P	LYR	DESCRIPTION	DATE
		-	-	SEE SHEET 1	-

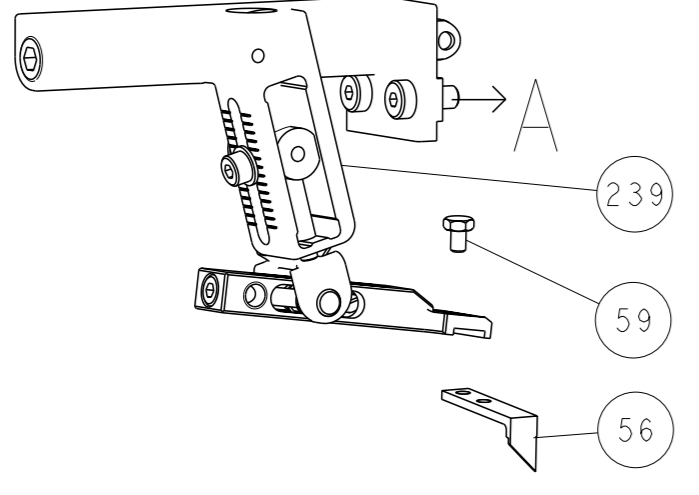
-	1	-	2119640-1	PUSH ROD, AIR FEED	250
-	1	-	1803259-1	BUSHING, FLANGED	249
-	1	1	2119082-1	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
-	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	1	-	2063440-1	AIR FEED MODULE	238
-	2	-	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172
-	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	1	-	240638-1	SPRING, FEED FINGER	163
-	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	-	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854	137
-	1	-	2119799-1	HOLDER, FEED FINGER, AF	136
-	1	1	1-22281-8	SPRING, COMPRESSION	121
-	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	1-690438-0	FRONT STRIP GUIDE	96
-	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	95
-	1	1	2168083-6	SCR, SKT HD CAP, RoHS, M5 X 65	93
-	1	1	455888-5	SPACER, CRIMPER	82
-	2	2	2079383-4	SCR, BHSC, RoHS (M4 X 8)	79
-	1	1	1803096-1	EXTENSION PLATE	78
-	1	1	5-547505-2	SPRING, COMPRESSION	77
-	1	1	854769-4	HOLDER, INS	74
-	1	1	1803607-1	DOCUMENTATION PACKAGE	71
-	1	1	2119791-5	DEPRESSOR, WIRE	70
-	1	1	2119943-1	WASHER, SPACER	69
-	1	1	2119740-1	TAG, IDENTIFICATION	67
-	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	2	2	2-18032-5	SCR, SET, FLT PNT, M5 X 20.0	61
-	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	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	53
-	1	1	5018030-1	NUT, HEX, REG, RoHS, M3	52
-	1	1	811242-5	BUMPER, HOLD DOWN	51
-	1	1	690753-2	SPACER, TONKER	50
-	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	1752356-1	SUPPORT, TERMINAL	34
-	2	2	2079383-8	SCR, BHSC, RoHS (M4 X 16)	33
-	2	2	1-2844962-3	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	2844938-1	PLATE, STRIP GUIDE	29
-	1	1	455888-5	SPACER, CRIMPER	28
-	2	2	22283-1	SPRING, COMPRESSION	27
-	1	1	356835-1	LEVER, DRAG RELEASE	26
-	1	1	240792-1	DRAG, TERMINAL	25
-	1	1	1320928-4	STRIP GUIDE	24
-	1	1	980371-4	SCR, SKT HD SHLDR 5.0 DIA X 6.0	23
-	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
-	2	2	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	318707-1	FLOATING SHEAR, FRONT	9
1	1	1	5-1633918-5	ANVIL, COMBINATION	8
-	-	-	-	-	7
-	-	-	-	-	6
-	1	1	2119780-9	DEPRESSOR, SHEAR	5
-	1	1	6-238011-7	BLOCK, CRIMPER SPACER	4
1	1	1	7-1803187-9	CRIMPER, INSULATION F	3
-	1	1	455888-4	SPACER, CRIMPER	2
1	1	1	3-456403-8	CRIMPER, WIRE PREMIUM	1

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		OWN	J. HOU	15JUN2016	NAME	Ocean Side Feed Applicator
mm	0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ±	±	±	CHK	L. ZHANG	15JUN2016		
MATERIAL:		FINISH:		APVD	L. ZHANG	15JUN2016	SIZE	CAGE CODE
				PRODUCT SPEC			00779	DRAWING NO
				APPLICATION SPEC			©=2151527	RESTRICTED TO
				WEIGHT			Customer Accessible Production Drawing	SCALE
							1:2	SHEET 3 OF 4
							REV	C

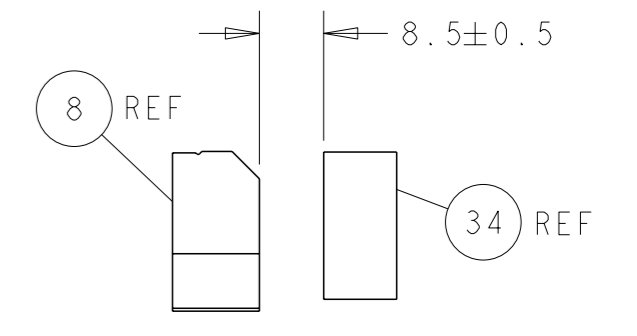
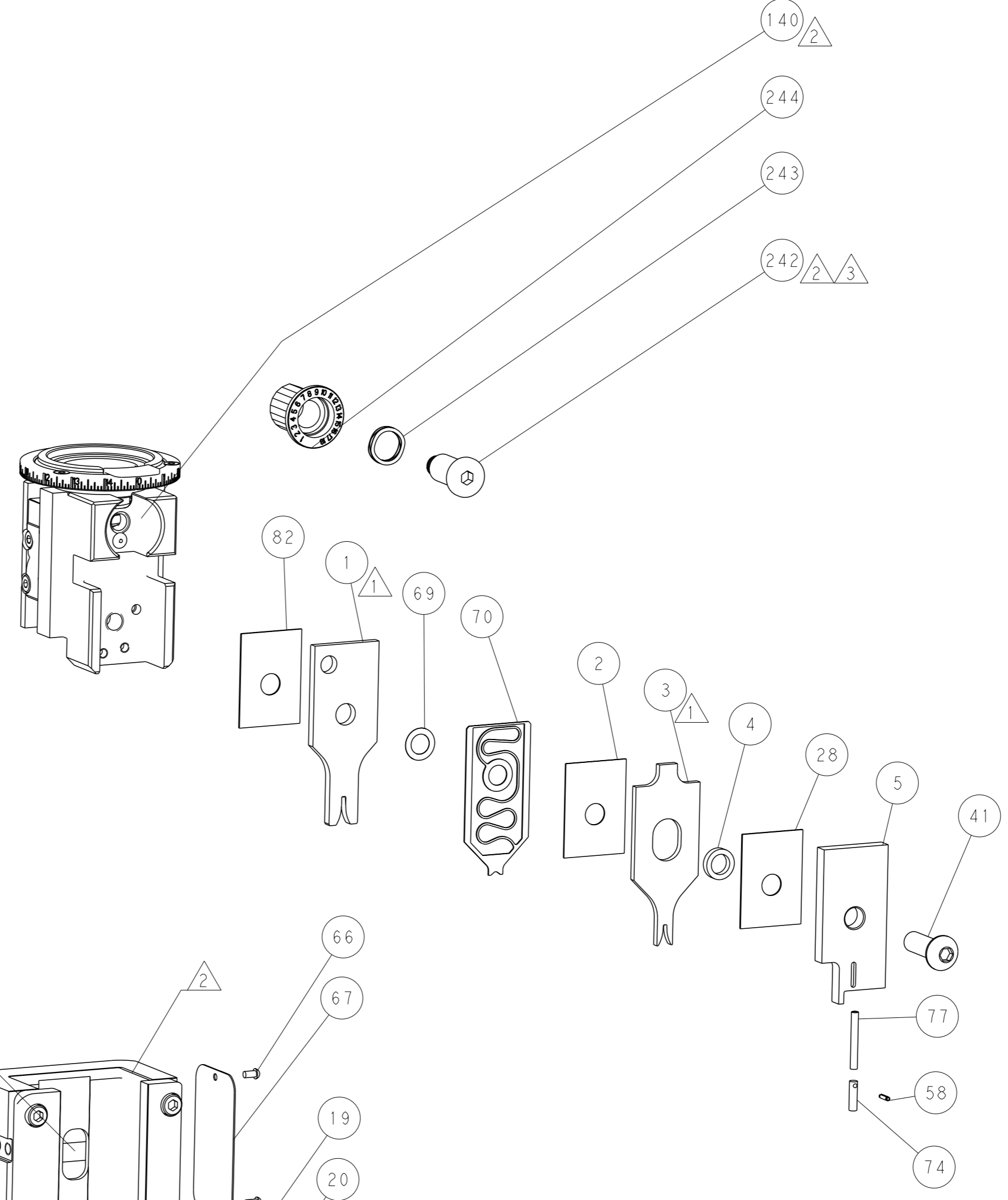
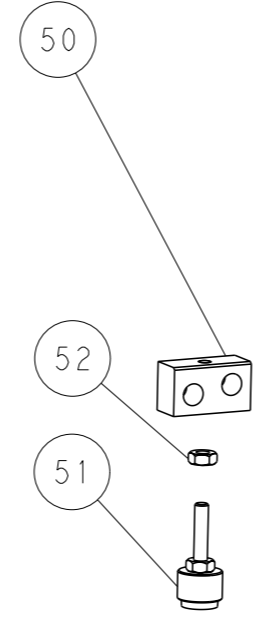
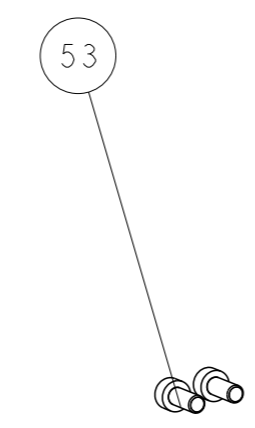
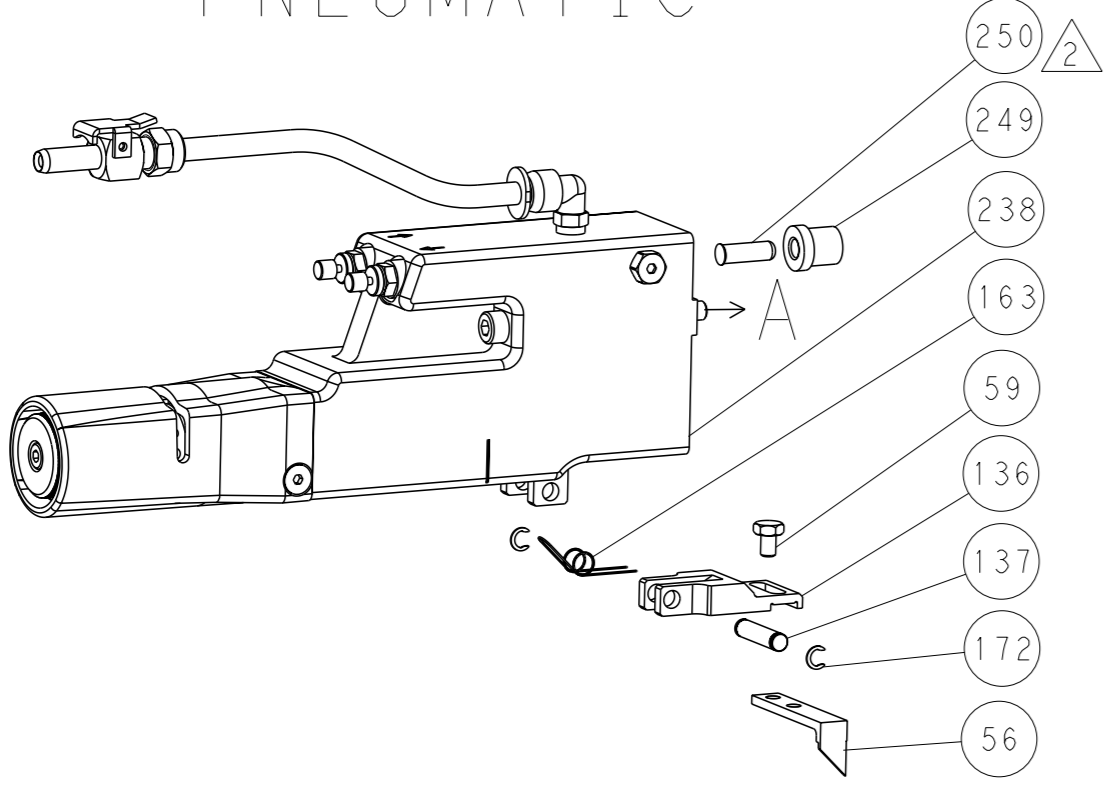
PACIFIC VERSION  
Shown on sheets 3 of 4 & 4 of 4  
(Atlantic version shown on sheets 1 of 4 & 2 of 4)

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

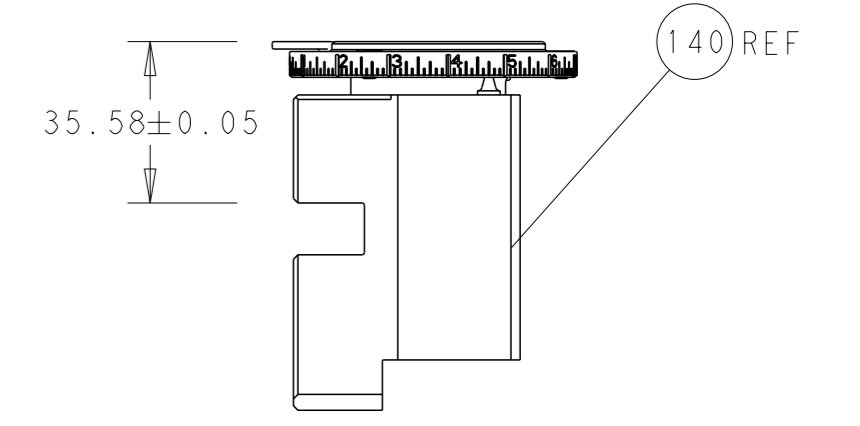
# FEED TYPE MECHANICAL



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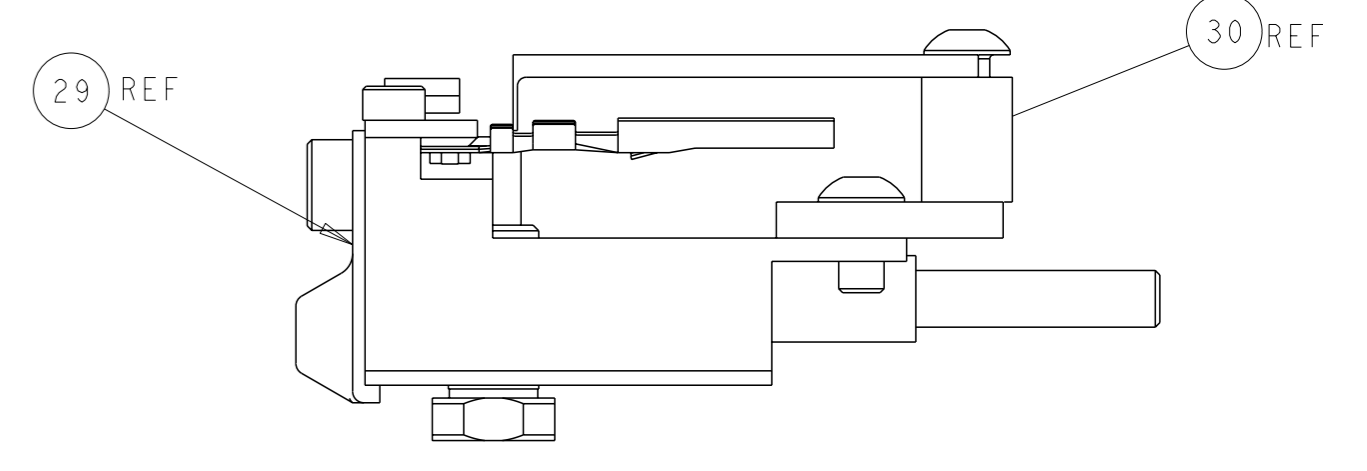


TERMINAL SUPPORT LOCATION



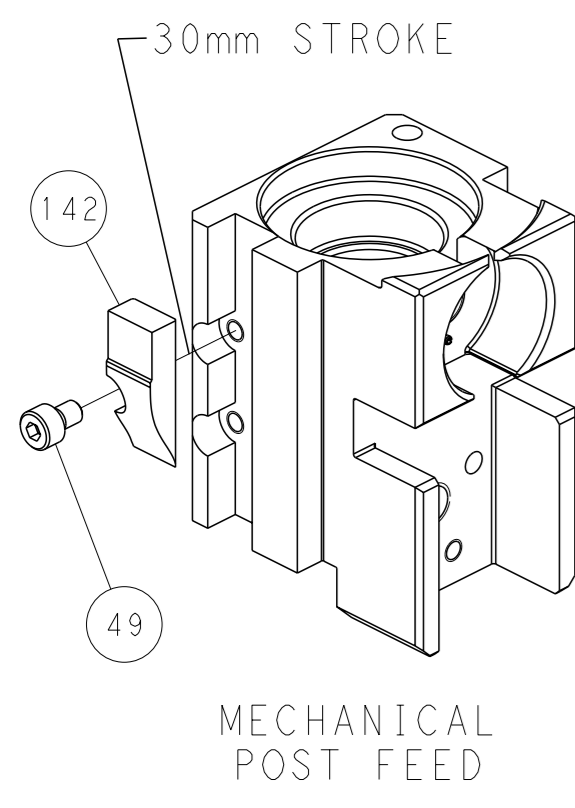
RAM SET-UP

ITEM 30 LOCATED AT REAR HOLES

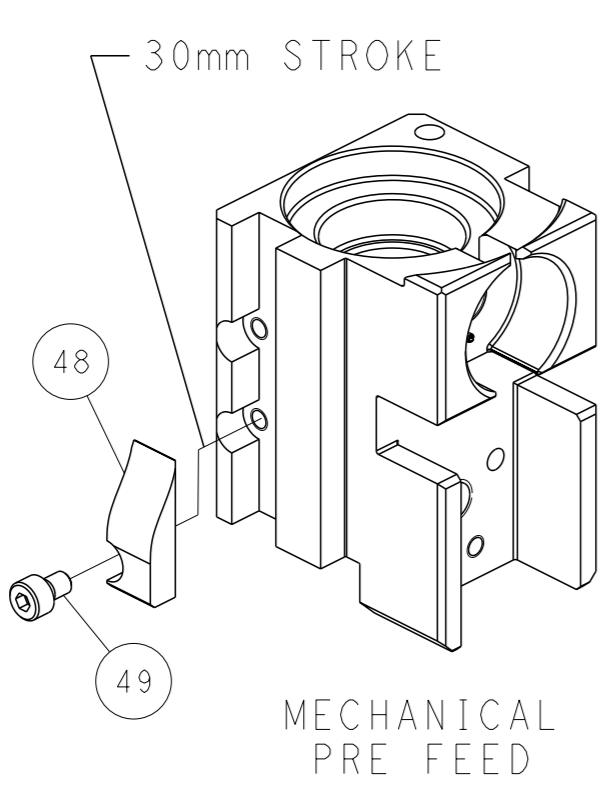


FEED TRACK POSITION GUIDE BY INSULATION BARREL

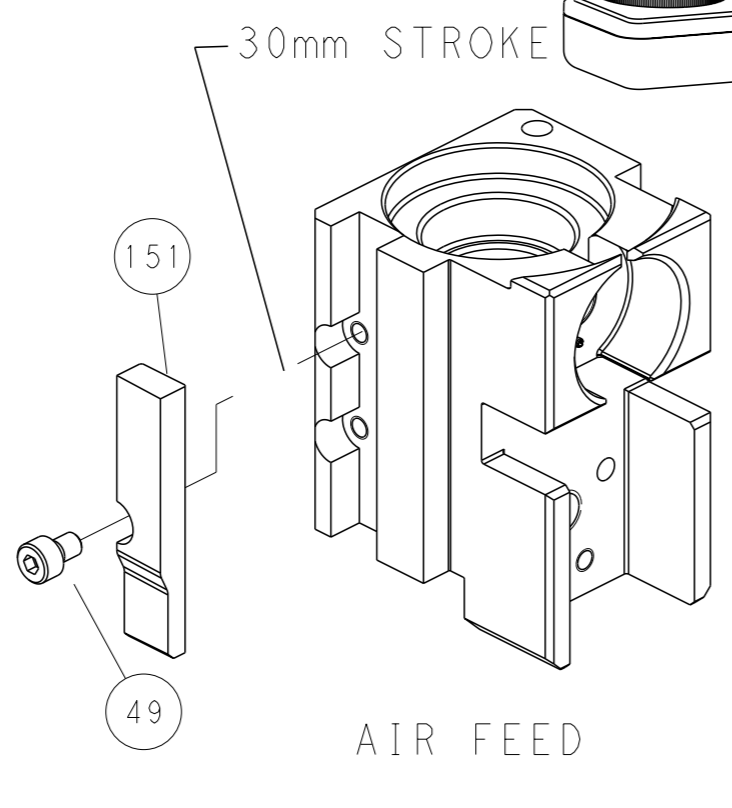
# CAM POSITIONS



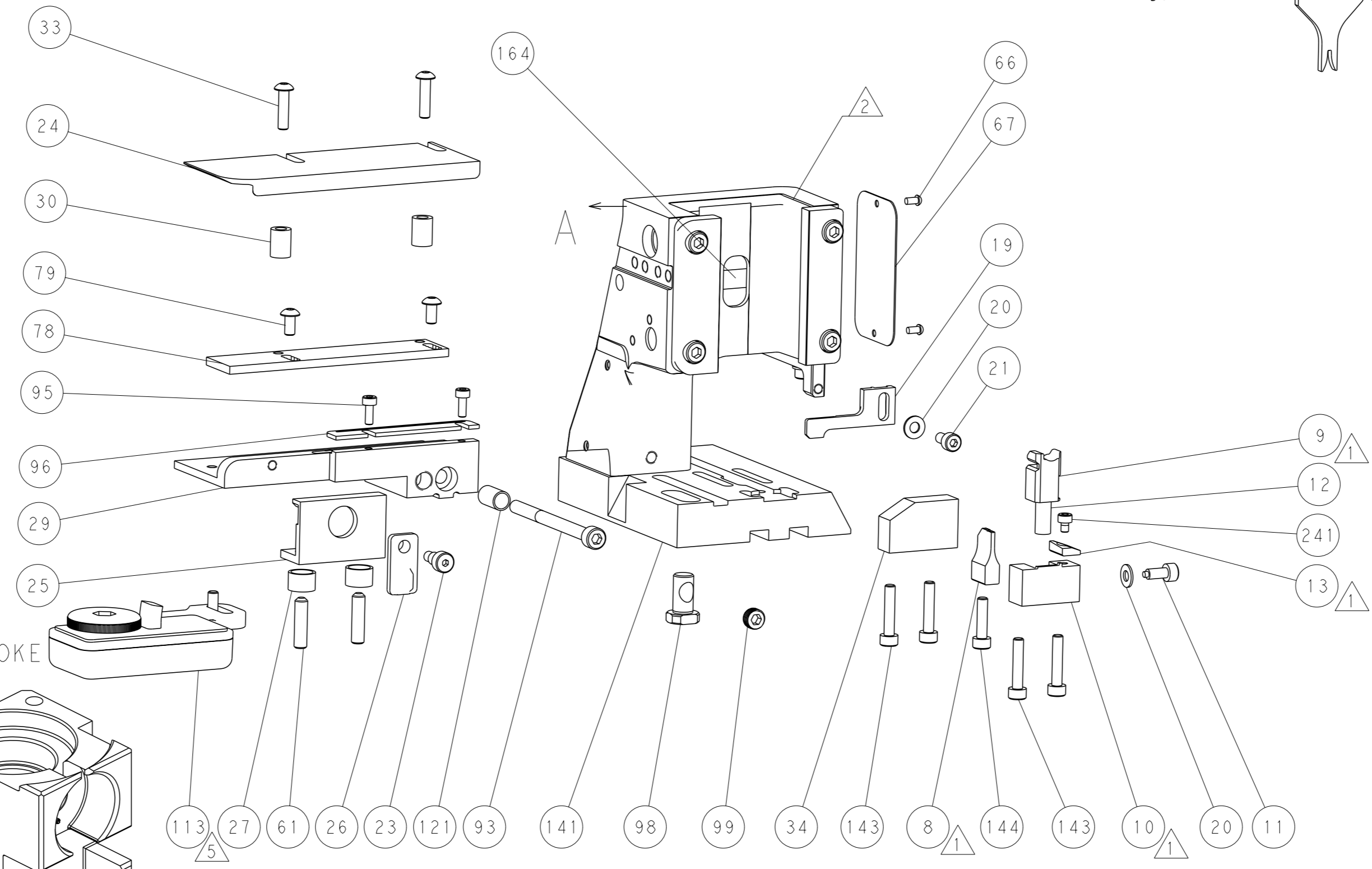
MECHANICAL POST FEED



MECHANICAL PRE FEED



AIR FEED



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

<small>THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE AND THE CONTROLLING ENGINEERING ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST REVISION.</small>		DWN J. HOU 15JUN2016 CHK L. ZHANG 15JUN2016 APVD L. ZHANG 15JUN2016	TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH ±		NAME Ocean Side Feed Applicator APPLICATION SPEC SIZE CAGE CODE DRAWING NO. A1 00779 C=2151527 WEIGHT Customer Accessible Production Drawing	RESTRICTED TO SCALE 1:2 SHEET 4 OF 4 REV C