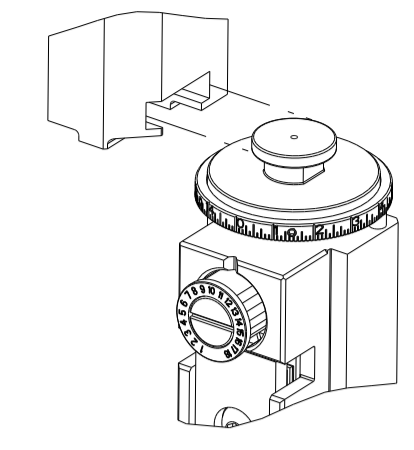


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151783-2	E	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151783-2	E	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2151783-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA

CRIMP	SIZE	TYPE
WIRE	2.79 mm [.110]	F
INSUL	6.60 mm [.260]	O

APPLICATOR INSTRUCTIONS 408-35042

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION

TERMINAL NAME: TAB 5.8 X 0.8 ASSY

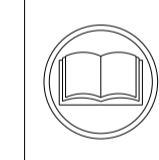
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE
5.20-5.80 mm [.205-.228 IN]	∅ 6.0 mm MAX [.236 IN MAX]

TERMINAL APPLICATION SPECIFICATION 114-18052

TERMINALS APPLIED

TE TERMINAL	TE TERMINAL	TE SEAL	TE SEAL	SEAL INSULATION DIAMETER RANGE
1-962918-1	2-962918-1	963244-1		∅2.50-3.00
1-962918-2	2-962918-2			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
2.50mm2	1.97+/-0.05 [.078+/- .002]	5.5
2.00mm2	1.83+/-0.05 [.072+/- .002]	7.1
1.50mm2	1.69+/-0.05 [.067+/- .002]	8.6



- 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 PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- 6 APPLY TORO-SEAL IN ALLEN SOCKET TO FILL HOLE AFTER FLAT HD HAS BEEN ADJUSTED TO CORRECT HEIGHT AT QUALIFICATION. APPLY #1-23419-5 LOC-TITE TO THREADS.
- 7. 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					
		P	LTN	DESCRIPTION	DATE	OWN	APVD
A	66	B		ECR-18-007338	18MAY2018	YY	JDG
		C		ECR-18-019432	12DEC2018	JAH	TE
		D		ECR-19-008981	07JUN2019	TB	TE
		E		ECR-23-189349	11OCT2023	FZ	TE

-	1	1	2119641-1	FEED CAM, AIR FEED	248
-	1	1	2119082-8	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	1	2844940-2	AIR FEED MODULE	238
-	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	1	1	1-22281-8	SPRING, COMPRESSION	121
-	1	1	455888-4	SPACER, CRIMPER	120
-	1	1	1-18028-2	WASHER, FLAT, REG M4	119
-	1	1	2844908-1	SCREW, LOCKING	99
-	1	1	2844907-1	POST, LOCKING	98
-	1	1	2-690438-8	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	1803607-3	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	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	985575-3	SCR, FLT SKT HD CAP M3 X 10.0	57
-	1	1	1338685-1	PAWL, FEED	56
-	4	4	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	54
-	2	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	53
-	1	1	1803382-2	HOLD DOWN, SPRING LOADED	50
-	1	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	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	1-1752356-1	SUPPORT, TERMINAL	34
-	2	2	2079383-8	SCR, BHSC, RoHS (M4 X 16)	33
-	2	2	2-2844962-1	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	1-2844938-8	PLATE, STRIP GUIDE	29
-	1	1	455888-4	SPACER, CRIMPER	28
-	2	2	22283-1	SPRING, COMPRESSION	27
-	1	1	356835-1	LEVER, DRAG RELEASE	26
-	1	1	240792-2	DRAG, TERMINAL	25
-	1	1	1320928-2	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
-	1	1	1-18028-2	WASHER, FLAT, REG M4	20
-	1	1	2119533-1	STRIPPER, SIDE FEED	19
-	1	1	2119806-2	INSERT, SHEAR	13
-	1	1	3-22280-3	SPRING, COMPRESSION	12
-	1	1	1-356885-5	STOP, SHEAR	11
-	1	1	2119805-4	SHEAR HOLDER, FRONT	10
-	1	1	1-318707-2	FLOATING SHEAR, FRONT	9
-	1	2	1-1333229-2	ANVIL, COMBINATION	8
-	-	-	-	-	7
-	-	-	-	-	6
-	1	1	2119781-6	DEPRESSOR, SHEAR	5
-	1	1	2-238011-1	BLOCK, CRIMPER SPACER	4
-	1	2	2-2119784-5	CRIMPER, INSULATION O PREMIUM	3
-	1	1	1-455888-0	SPACER, CRIMPER	2
-	1	2	456408-3	CRIMPER, WIRE PREMIUM	1

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

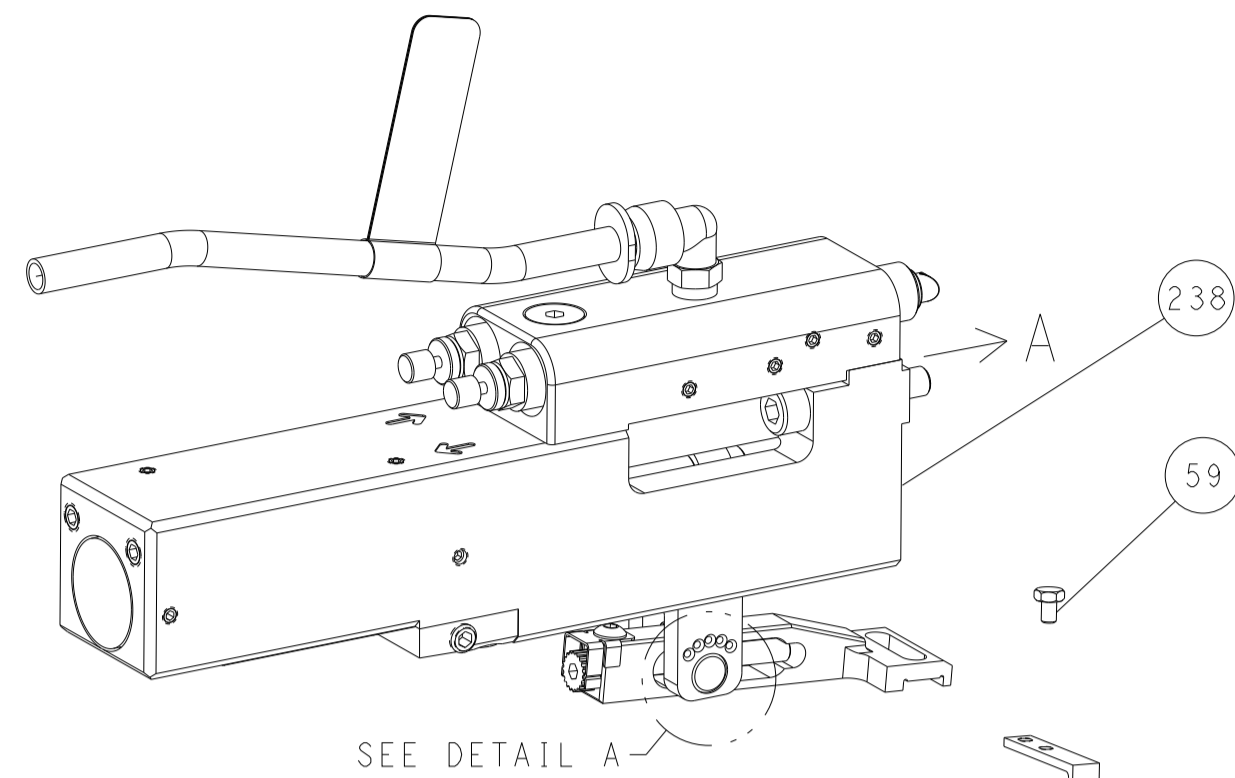
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mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES	FINISH			A1	00779	1	4	E	

Customer Accessible Production Drawing

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

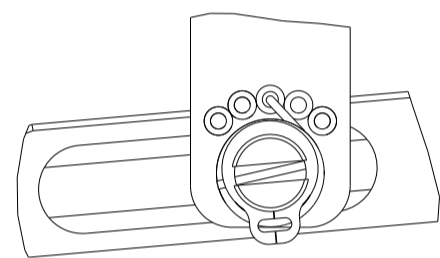
FEED TYPE

PNEUMATIC

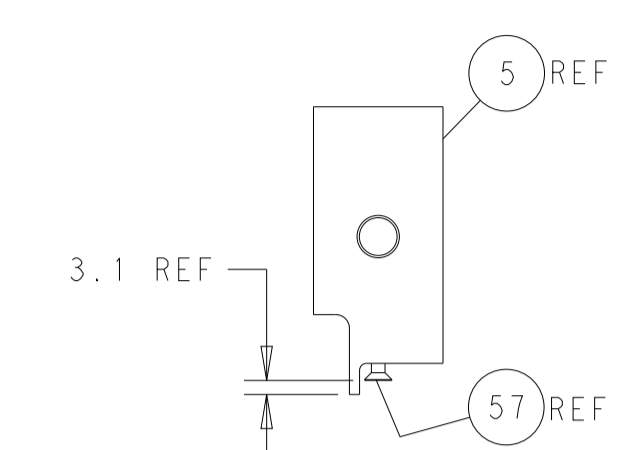
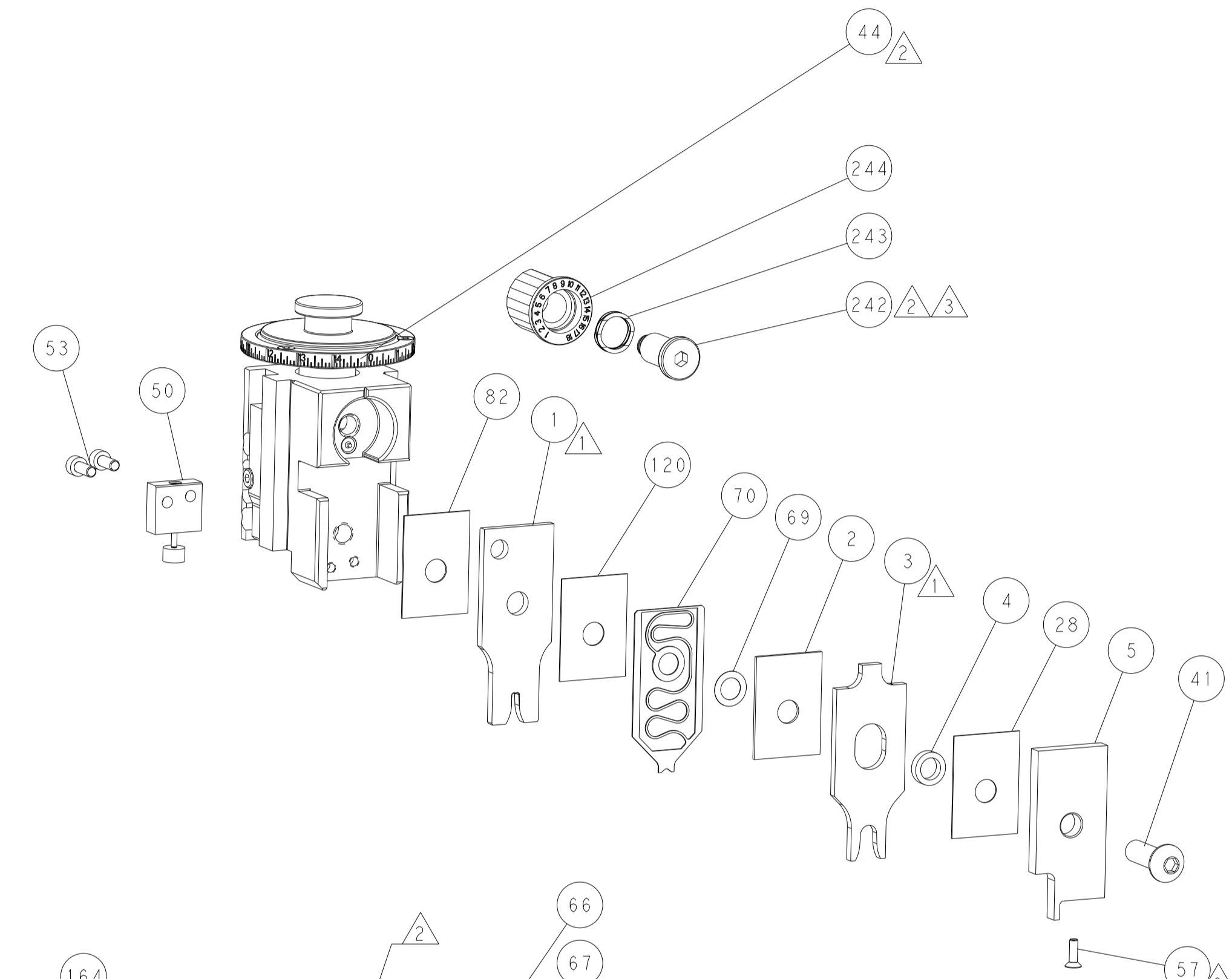


SEE DETAIL A

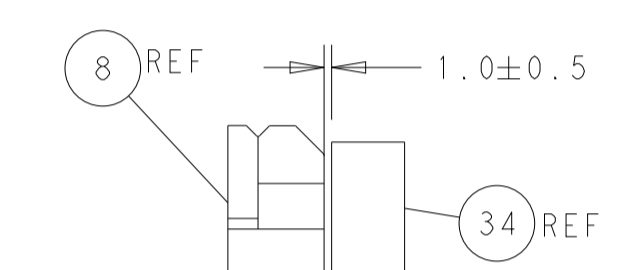
FEED SPRING SETTING POSITION
(SHOWN FROM REAR SIDE)



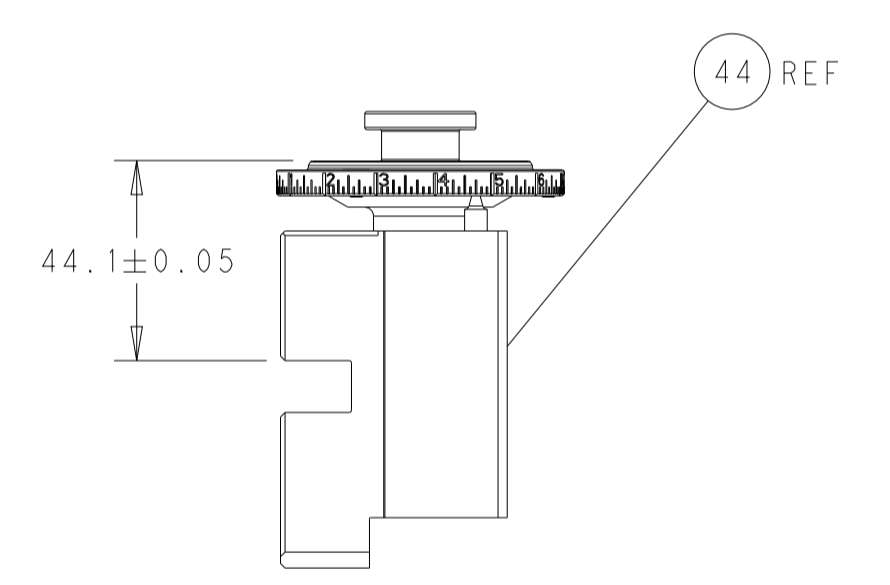
DETAIL A



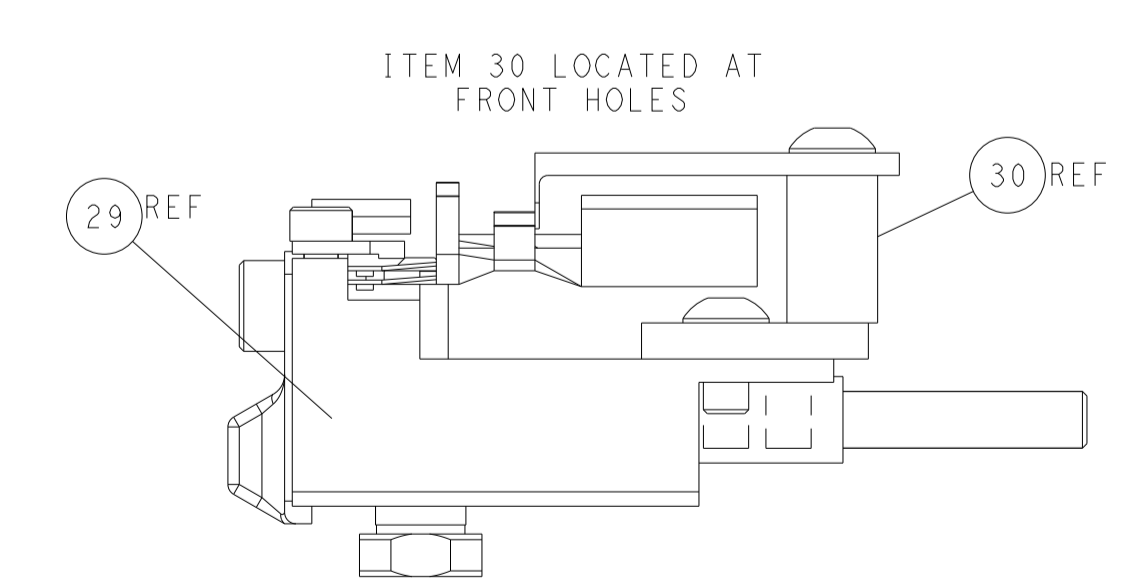
SHEAR DEPRESSOR DETAIL



TERMINAL SUPPORT LOCATION

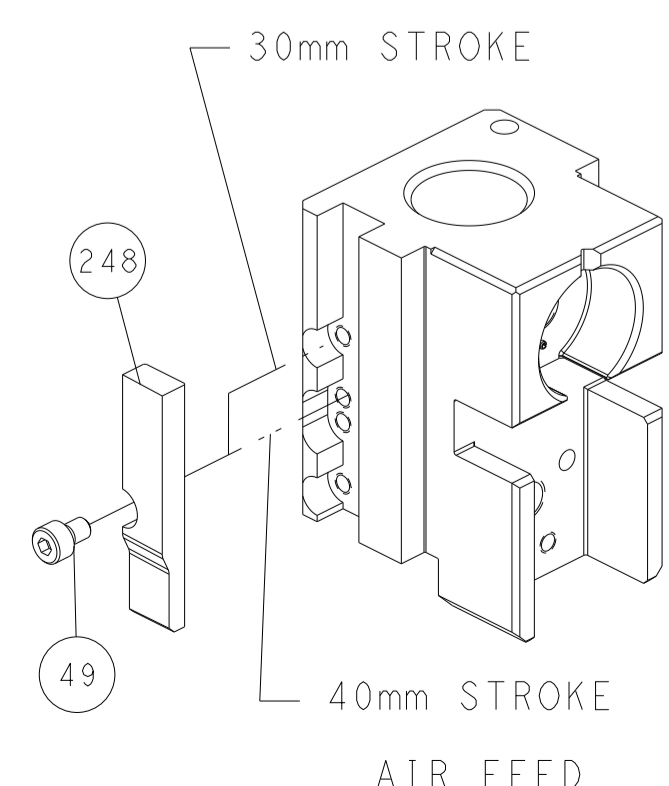


RAM SET-UP



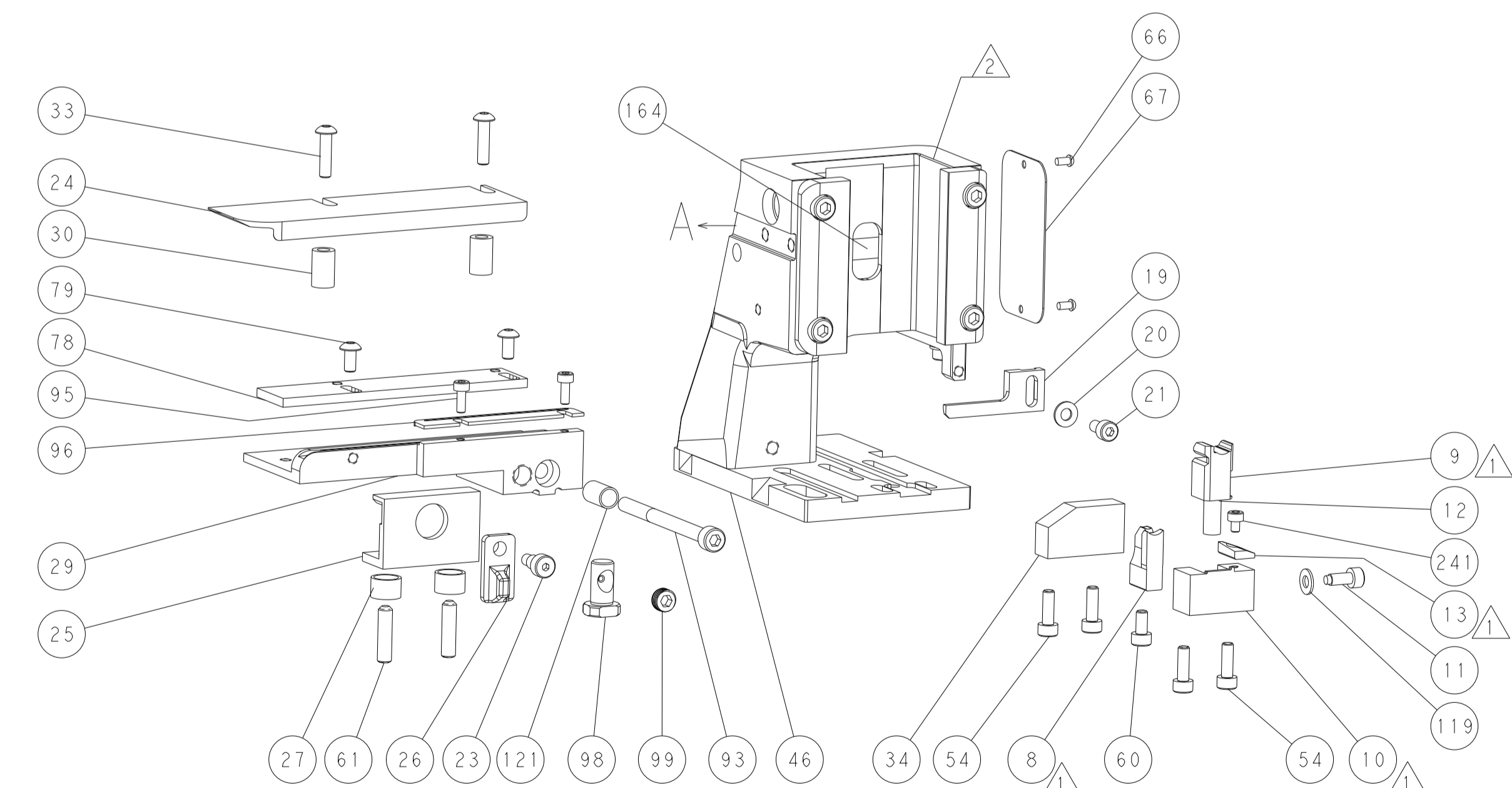
FEED TRACK POSITION
GUIDE BY WIRE BARREL

CAM POSITION



30mm STROKE

40mm STROKE
AIR FEED

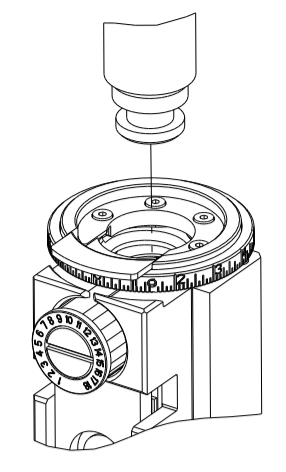


ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN Y. YIN 15OCT2012		TE Connectivity	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	Harrisburg, PA 17105-3608	
MATERIAL:		FINISH:		CHK G. BAILEY 15OCT2012		NAME	
				S. XI 15OCT2012		Ocean Side Feed Applicator	
				APVD		SIZE CAGE CODE DRAWING NO RESTRICTED TO	
				PRODUCT SPEC		A1 00779 C=2151783	
				APPLICATION SPEC		Customer Accessible Production Drawing	
				WEIGHT		SCALE 1:2 SHEET 2 OF 4 REV E	

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2151783-2	E	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151783-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
 INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.79 mm [1.110]	F
INSUL	6.60 mm [1.260]	O
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: TAB 5.8 X 0.8 ASSY			
WIRE STRIP LENGTH 5.20-5.80 mm [1.205-.228 IN]		INSULATION DIAMETER RANGE Ø 6.0 mm MAX [1.236 IN MAX]	
TERMINAL APPLICATION SPECIFICATION	114-18052	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE SEAL	TE SEAL
1-962918-1	2-962918-1	963244-1	
1-962918-2	2-962918-2		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
2.50mm2	1.97 +/- 0.05 [1.078 +/- .002]	5.5
2.00mm2	1.83 +/- 0.05 [1.072 +/- .002]	7.1
1.50mm2	1.69 +/- 0.05 [1.067 +/- .002]	8.6

- 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 PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- 6 APPLY TORO-SEAL IN ALLEN SOCKET TO FILL HOLE AFTER FLAT HD HAS BEEN ADJUSTED TO CORRECT HEIGHT AT QUALIFICATION. APPLY #1-23419-5 LOC-TITE TO THREADS.
- 7. 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					
		P	LTN	DESCRIPTION	DATE	OWN	APVD
A	66	-	-	SEE SHEET 1	-	-	-

-	1	2119082-8	CAM, SNAIL, INSULATION ADJUSTMENT	244	
-	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243	
-	1	2119083-1	RETAINER, INSULATION DIAL	242	
-	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241	
-	1	2844940-2	AIR FEED MODULE	238	
-	REF	994970-2	COUNTER, MAGNETIC	164	
-	1	2119641-2	FEED CAM, AIR FEED	151	
-	1	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	144	
-	4	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	143	
-	1	1-1803583-0	APPLICATOR BASIC ASSEMBLY, SF	141	
-	1	1803516-1	RAM ASSEMBLY, SF PACIFIC	140	
-	1	1-22281-8	SPRING, COMPRESSION	121	
-	1	455888-4	SPACER, CRIMPER	120	
-	1	1-18028-2	WASHER, FLAT, REG M4	119	
-	1	2844908-1	SCREW, LOCKING	99	
-	1	2844907-1	POST, LOCKING	98	
-	1	2-690438-8	FRONT STRIP GUIDE	96	
-	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	95	
-	1	2168083-6	SCR, SKT HD CAP, RoHS, M5 X 65	93	
-	1	455888-5	SPACER, CRIMPER	82	
-	2	2079383-4	SCR, BHSC, RoHS (M4 X 8)	79	
-	1	1803096-1	EXTENSION PLATE	78	
-	1	1803607-3	DOCUMENTATION PACKAGE	71	
-	1	2119791-5	DEPRESSOR, WIRE	70	
-	1	2119943-1	WASHER, SPACER	69	
-	1	2119740-1	TAG IDENTIFICATION	67	
-	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66	
-	2	2-18032-5	SCR, SET, FLT PNT, M5 X 20.0	61	
-	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59	
-	1	985575-3	SCR, FLT SKT HD CAP M3 X 10.0	57	
-	1	1338685-1	PAWL, FEED	56	
-	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	53	
-	1	1803382-2	HOLD DOWN, SPRING LOADED	50	
-	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49	
-	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41	
-	1	1-1752356-1	SUPPORT, TERMINAL	34	
-	2	2079383-8	SCR, BHSC, RoHS (M4 X 16)	33	
-	2	2-2844962-1	SPACER, CYLINDRICAL, STRIP GUIDE	30	
-	1	1-2844938-8	PLATE, STRIP GUIDE	29	
-	1	455888-4	SPACER, CRIMPER	28	
-	2	22283-1	SPRING, COMPRESSION	27	
-	1	356835-1	LEVER, DRAG RELEASE	26	
-	1	240792-2	DRAG, TERMINAL	25	
-	1	1320928-2	STRIP GUIDE	24	
-	1	980371-4	SCR, SKT HD SHLDR 5.0 DIA X 6.0	23	
-	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21	
-	1	1-18028-2	WASHER, FLAT, REG M4	20	
-	1	2119533-1	STRIPPER, SIDE FEED	19	
-	1	2119806-2	INSERT, SHEAR	13	
-	1	3-22280-3	SPRING, COMPRESSION	12	
-	1	1-356885-5	STOP, SHEAR	11	
-	1	2119805-4	SHEAR HOLDER, FRONT	10	
-	1	1-318707-2	FLOATING SHEAR, FRONT	9	
-	1	1	2-1333229-2	ANVIL, COMBINATION	8
-	-	-	-	7	
-	-	-	-	6	
-	1	2119781-6	DEPRESSOR, SHEAR	5	
-	1	2-238011-1	BLOCK, CRIMPER SPACER	4	
-	1	1	2-2119784-5	CRIMPER, INSULATION O PREMIUM	3
-	1	1	1-455888-0	SPACER, CRIMPER	2
-	1	1	456408-3	CRIMPER, WIRE PREMIUM	1
-	77	-22	PART NO	DESCRIPTION	ITEM NO

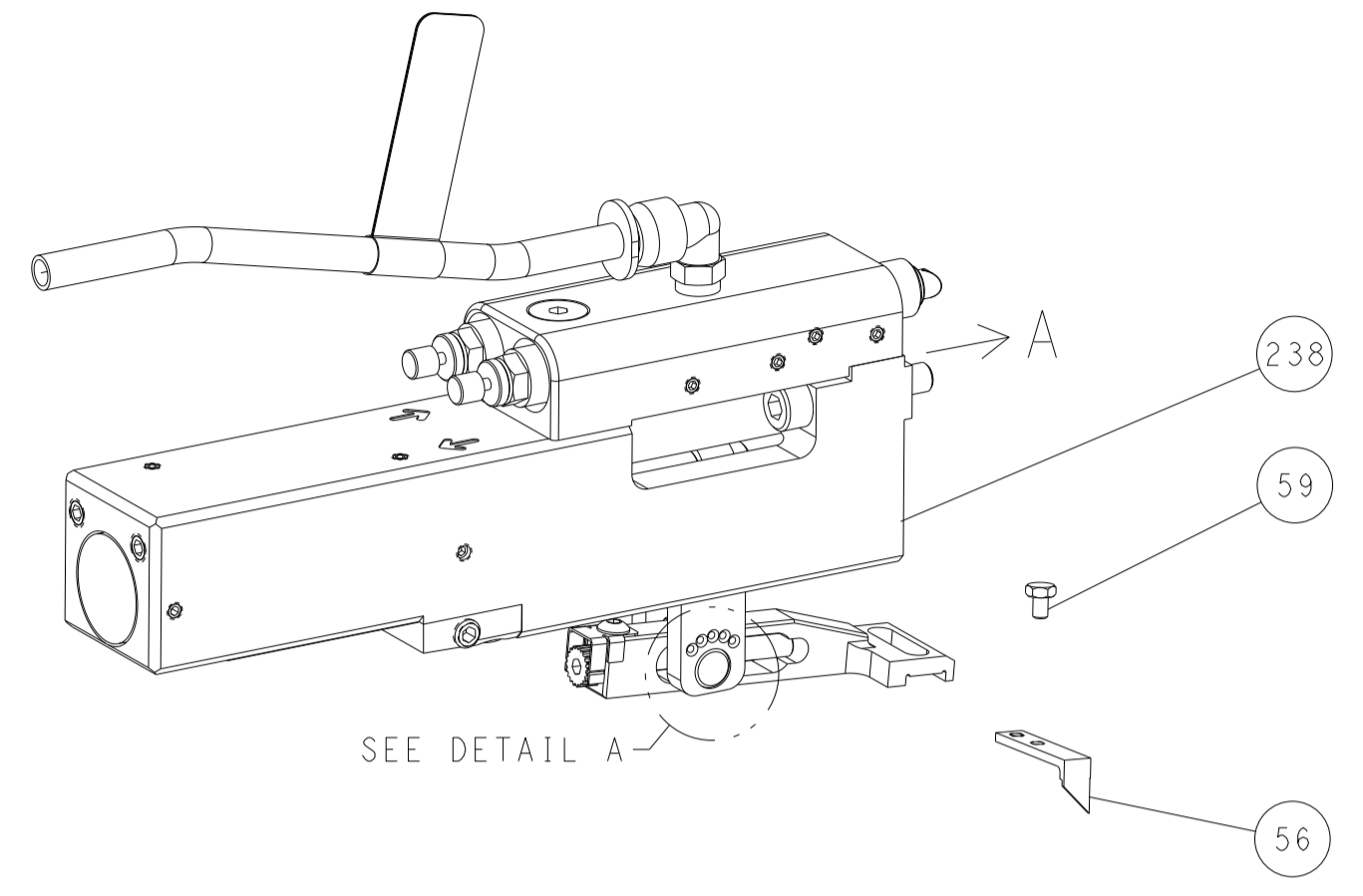
PACIFIC VERSION
 Shown on sheets 3 of 4 & 4 of 4
 (Atlantic version shown on sheets 1 of 4 & 2 of 4)

DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DRAWN: Y. YIN 15OCT2012		CHK: G. BAILEY 15OCT2012		APVD: S. XI 15OCT2012		NAME: Ocean Side Feed Applicator	
0 PLC ±		1 PLC ±		2 PLC ±		3 PLC ±		4 PLC ±		RESTRICTED TO	
ANGLES		FINISH		WEIGHT		SCALE		SHEET		REV	
MATERIAL		-		-		A 00779		C=2151783		E	
Customer Accessible Production Drawing				SCALE: 1:2		SHEET 3 OF 4					

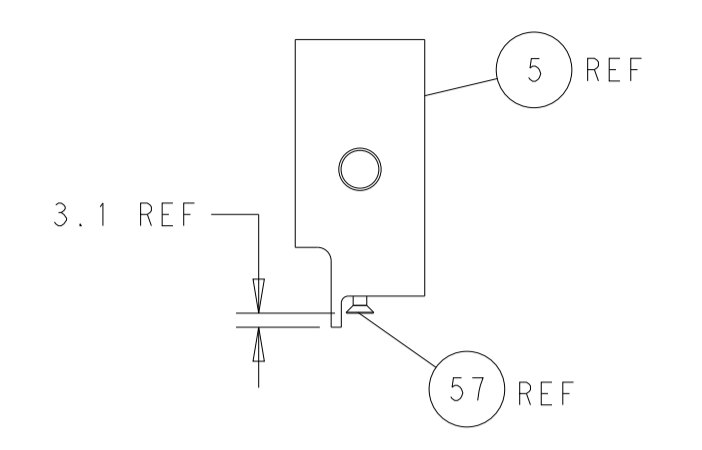
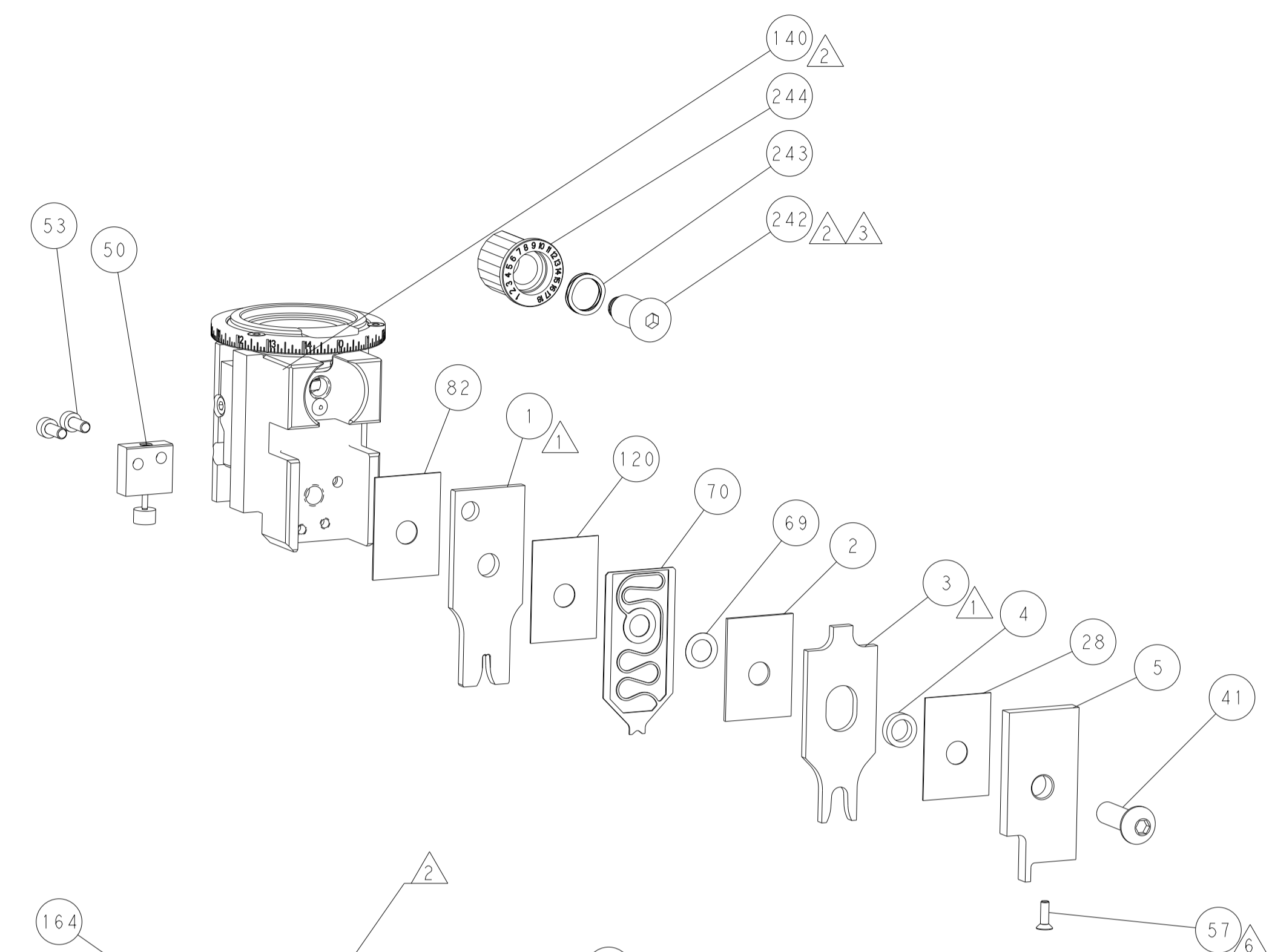
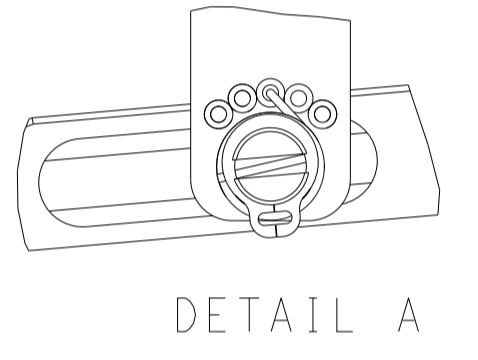
LOC	DIST	REVISIONS					
		P	LTN	DESCRIPTION	DATE	OWN	APVD
A	66	-	-	SEE SHEET 1	-	-	-

FEED TYPE

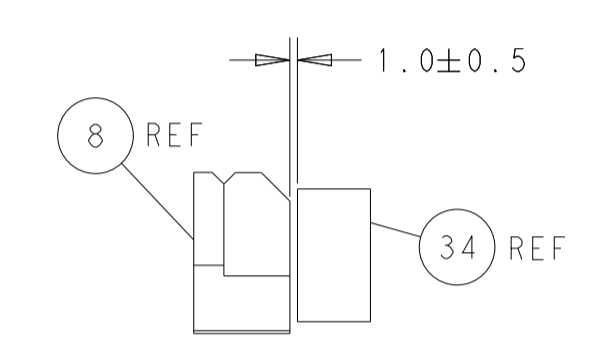
PNEUMATIC



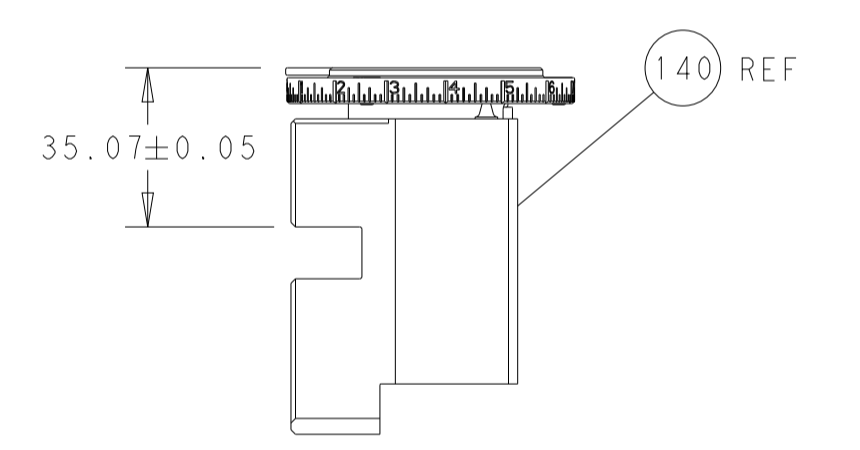
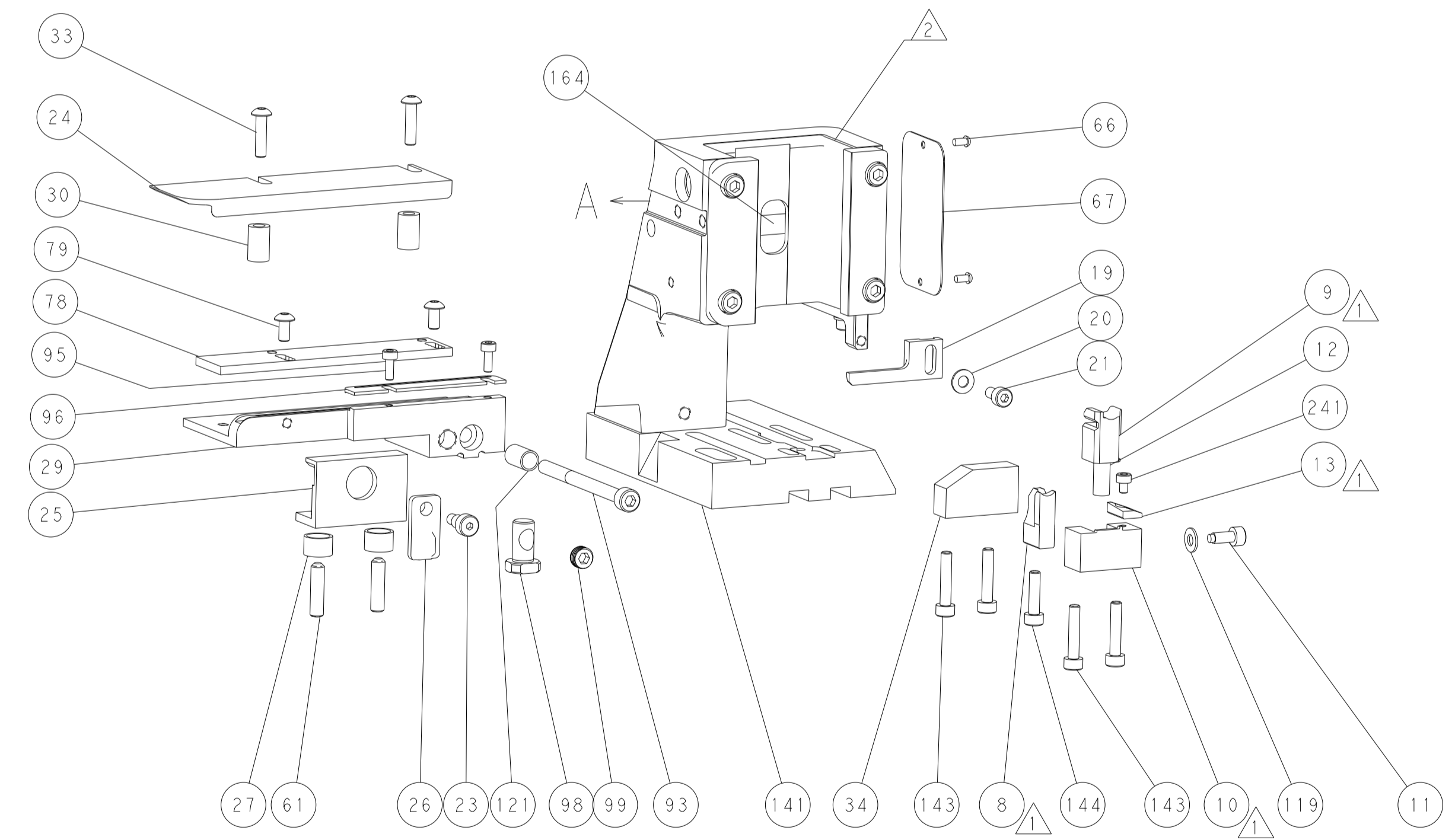
FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



SHEAR DEPRESSOR DETAIL

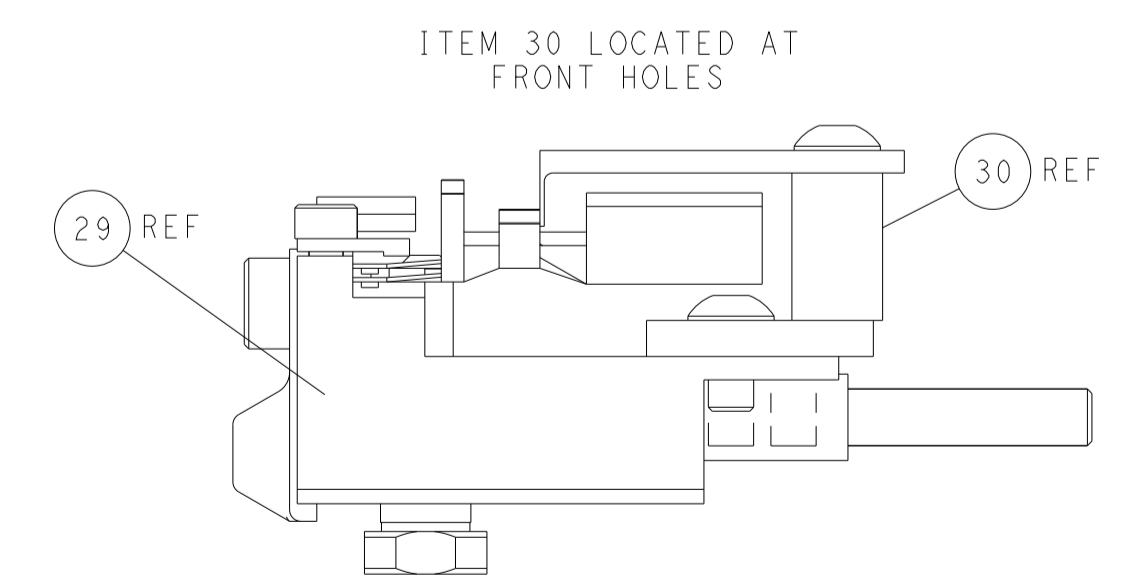
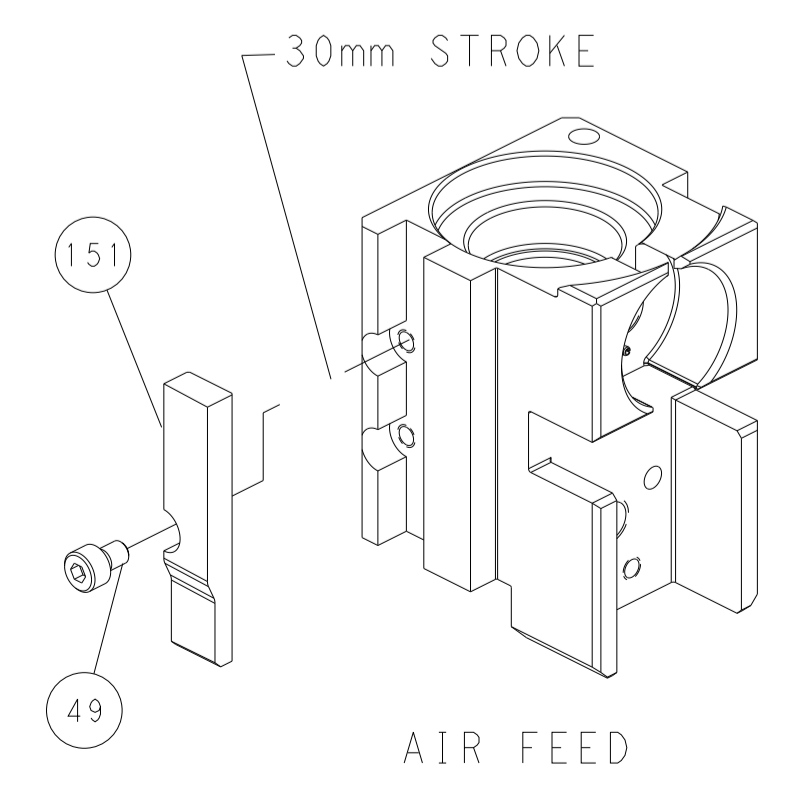


TERMINAL SUPPORT LOCATION



RAM SET-UP

CAM POSITION



FEED TRACK POSITION GUIDE BY WIRE BARREL

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

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN Y. YIN 15OCT2012		TE Connectivity Harrisburg, PA 17105-3608	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±		
MATERIAL	FINISH	WEIGHT	SCALE	SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
			1:2	A1	00779	©=2151783	
Customer Accessible Production Drawing				SHEET 4 OF 4		REV E	