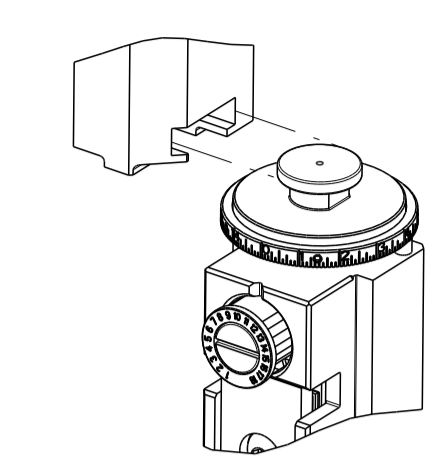


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151956-1	G	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2151956-2	G	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151956-1	G	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2151956-2	G	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2151956-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.98 mm [.078]	F
INSUL	3.70 mm [.146]	O

APPLICATOR INSTRUCTIONS
408-35042

TERMINAL DATA: SUMITOMO TERMINAL SUMITOMO CRIMP SPECIFICATION				
TERMINAL NAME: TERMINAL				
WIRE STRIP LENGTH	TERMINAL INSULATION DIAMETER RANGE	TE SEAL	SUMITOMO SEAL	SEAL INSULATION DIAMETER RANGE
4.40-5.20 mm [.173-.205 IN]	Ø1.80-2.90 mm [.071-.114 IN]	1949371-1	7160-8234	1.7-2.7mm
TERMINAL APPLICATION SPECIFICATION	SUMITOMO SPEC Rev -	1949636-1	7165-0119	2.0-2.9mm
TERMINALS APPLIED		1572283-1	7165-0118	1.5-2.0mm

TERMINAL DATA: SUMITOMO TERMINAL SUMITOMO CRIMP SPECIFICATION				
TERMINAL NAME: TERMINAL				
WIRE STRIP LENGTH	TERMINAL INSULATION DIAMETER RANGE	TE SEAL	SUMITOMO SEAL	SEAL INSULATION DIAMETER RANGE
4.40-5.20 mm [.173-.205 IN]	Ø1.80-2.90 mm [.071-.114 IN]	1832684-1	1500-0106	1.7-2.7mm
TERMINAL APPLICATION SPECIFICATION	SUMITOMO SPEC Rev -	1949636-1	7165-0119	2.0-2.9mm
TERMINALS APPLIED		1572283-1	7165-0118	1.5-2.0mm

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.25mm2	1.50+/-0.05 [.059+/- .002]	4.0
0.85mm2	1.40+/-0.05 [.055+/- .002]	4.9
0.50mm2	1.25+/-0.05 [.049+/- .002]	6.7
0.30mm2	1.10+/-0.05 [.043+/- .002]	8.6

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.25mm2	1.30+/-0.05 [.051+/- .002]	5.2
0.85mm2	1.20+/-0.05 [.047+/- .002]	6.3
0.50mm2	1.10+/-0.05 [.043+/- .002]	7.6
0.30mm2	0.95+/-0.05 [.037+/- .002]	9.4

TERMINAL DATA: SUMITOMO TERMINAL SUMITOMO CRIMP SPECIFICATION				
TERMINAL NAME: TERMINAL				
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE	TE SEAL	SUMITOMO SEAL	SEAL INSULATION DIAMETER RANGE
4.40-5.20 mm [.173-.205 IN]	Ø1.80-2.90 mm [.071-.114 IN]	1949371-1	7160-8234	Ø1.7-2.7mm
TERMINAL APPLICATION SPECIFICATION	SUMITOMO SPEC Rev -	1949636-1	7165-0119	
TERMINALS APPLIED		1572692-1	1500-0110	

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.25mm2	1.30+/-0.05 [.051+/- .002]	5.1
0.85mm2	1.20+/-0.05 [.047+/- .002]	6.1
0.75mm2	1.20+/-0.05 [.047+/- .002]	6.2
0.50mm2	1.10+/-0.05 [.043+/- .002]	7.5
0.30mm2	0.95+/-0.05 [.037+/- .002]	9.2

- 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. 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.
- 6. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- 7. TERMINAL LUBRICANT IS RECOMMENDED.

*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	LTN	DESCRIPTION	DATE	OWN	APVD
		D		ECR-21-005103	22JUL2021	JWC	RK
		E		ECR-21-118872	27OCT2021	FJ	RK
		F		ECR-23-166540	16FEB2023	JWC	TE
		G		ECR-23-193352	23NOV2023	FZ	TE

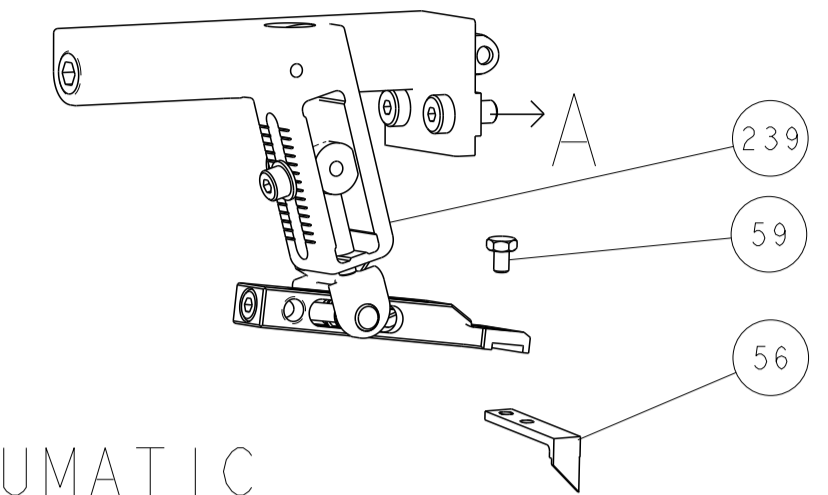
-	1	1	1	1	1803945-4	TONKER	300	
-	1	1	1	1	22278-9	SPRING, COMPRESSION	299	
-	2	2	2	2	4-18032-3	SCR, SET, FLT PNT, M3 X 6.0	298	
-	1	1	1	1	1803944-1	SPACER, TONKER	297	
-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248	
-	1	1	1	1	2119082-8	CAM, SNAIL, INSULATION ADJUSTMENT	244	
-	1	1	1	1	2079764-1	WASHER, WAVE 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	
-	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	455888-4	SPACER, CRIMPER -	82	
-	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	985575-3	SCR, FLT SKT HD CAP M3 X 10.0	57	
-	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	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	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	2-1752356-0	SUPPORT, TERMINAL	34	
-	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33	
-	2	2	2	2	3-2844962-0	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	318707-1	FLOATING SHEAR, FRONT	9	
-	1	2	2	1	1	4-1633711-9	ANVIL, COMBINATION	8
-	1	1	1	1	4-240641-6	SPACER	7	
-	-	-	-	-	-	-	6	
-	1	1	1	1	2119781-1	DEPRESSOR, SHEAR	5	
-	1	1	1	1	238011-4	BLOCK, CRIMPER SPACER	4	
-	1	2	2	1	1	2-1803018-9	CRIMPER, INSULATION O	3
-	1	1	1	1	1-455888-2	SPACER, CRIMPER -	2	
-	1	2	2	1	1	3-1633305-0	CRIMPER, WIRE PREMIUM	1

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		APPROVED:		NAME:	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES ±	FINISH
MATERIAL		WEIGHT		SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
				A1	00779	2151956	

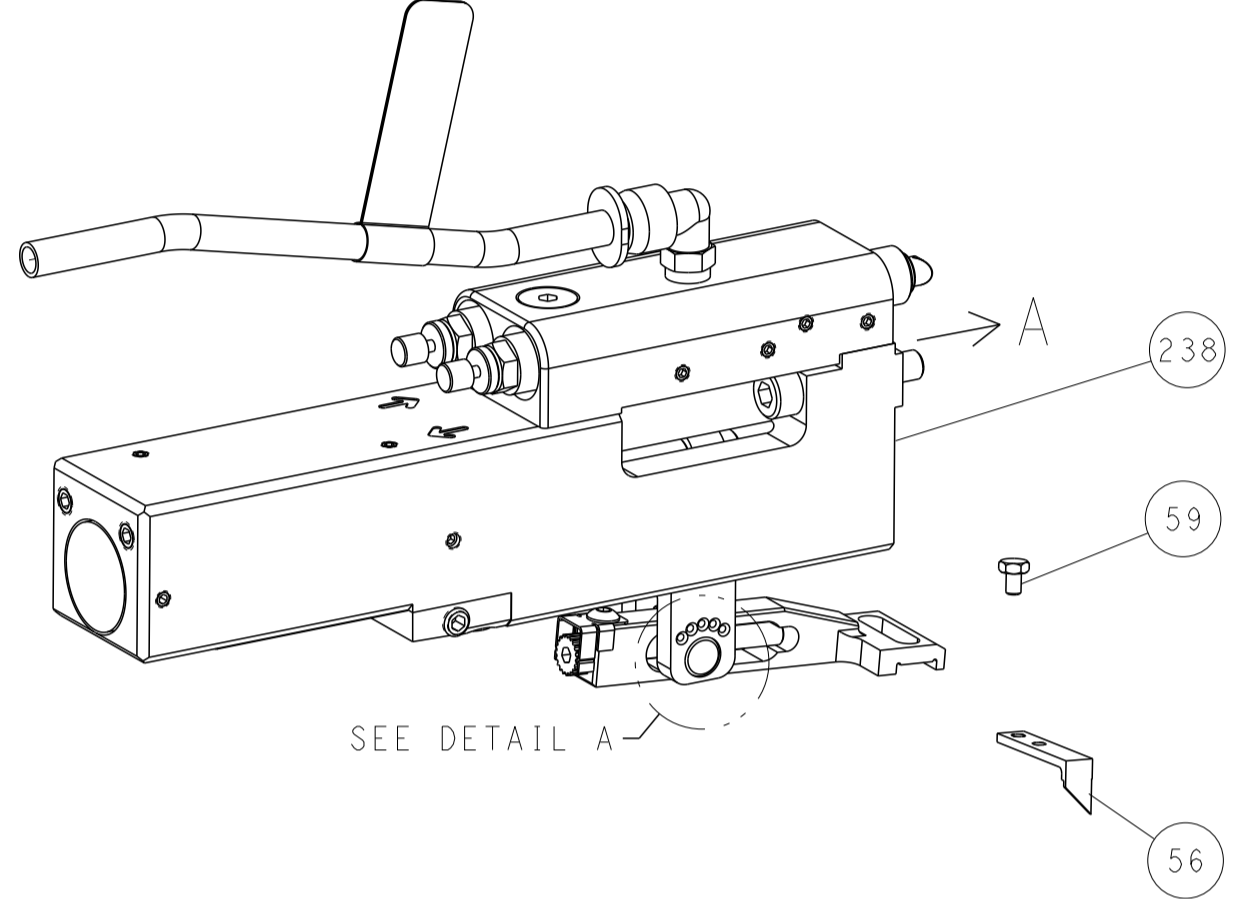
Customer Accessible Production Drawing SCALE 1:2 SHEET 1 OF 4 REV G

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

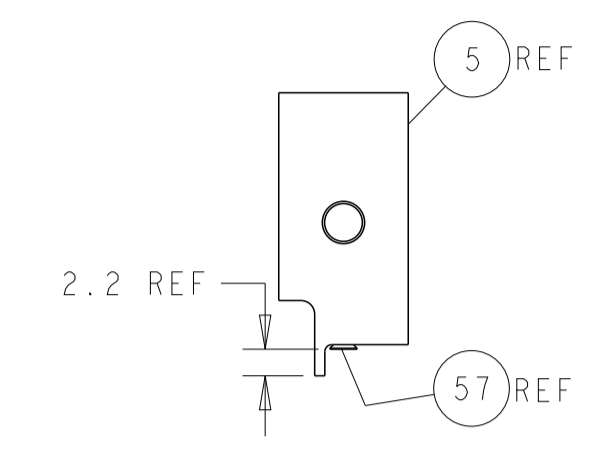
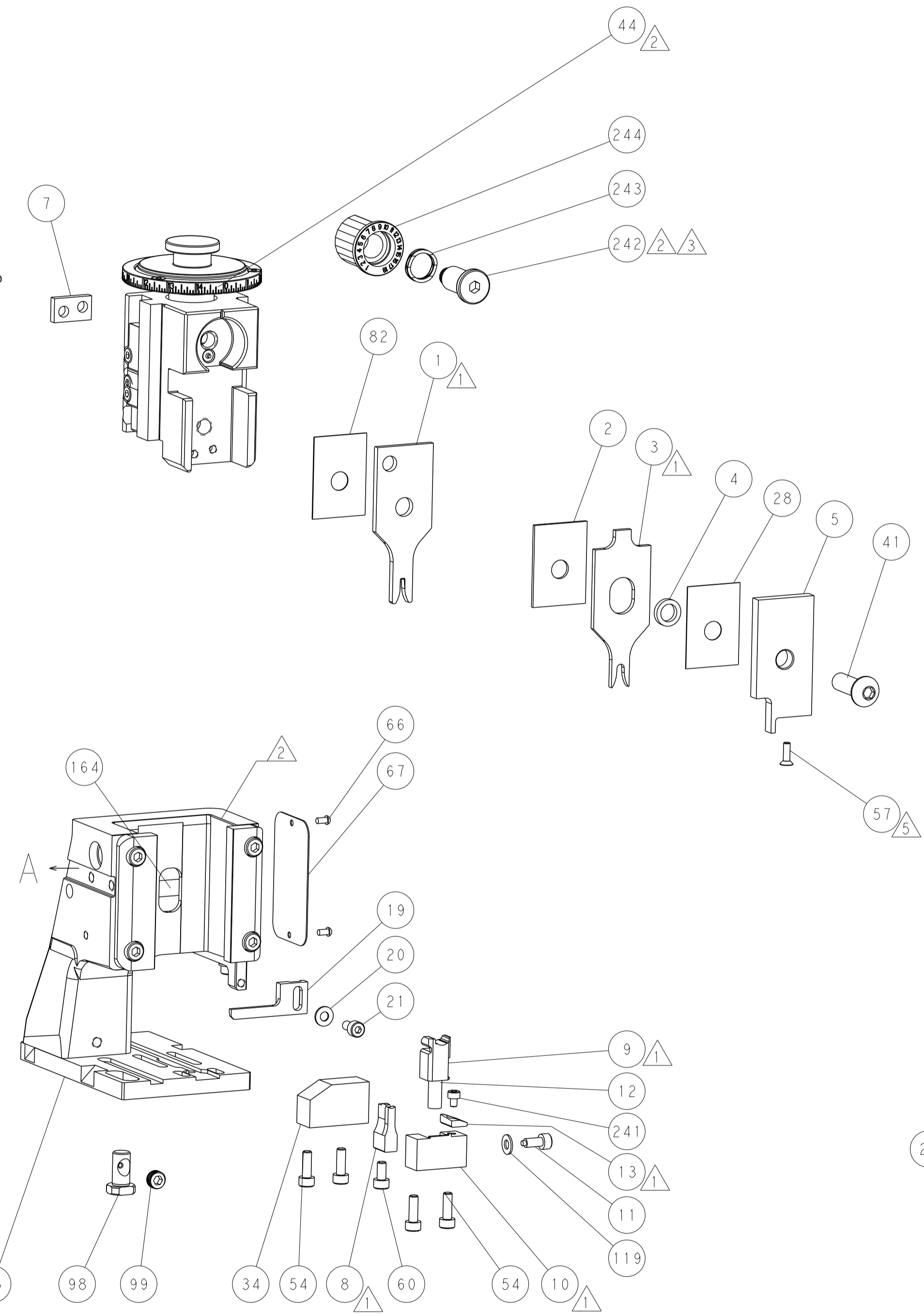
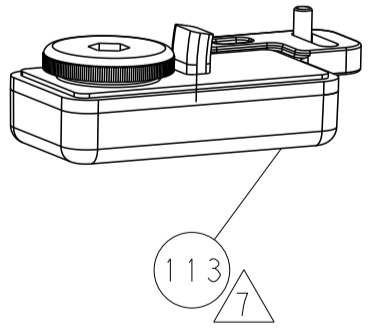
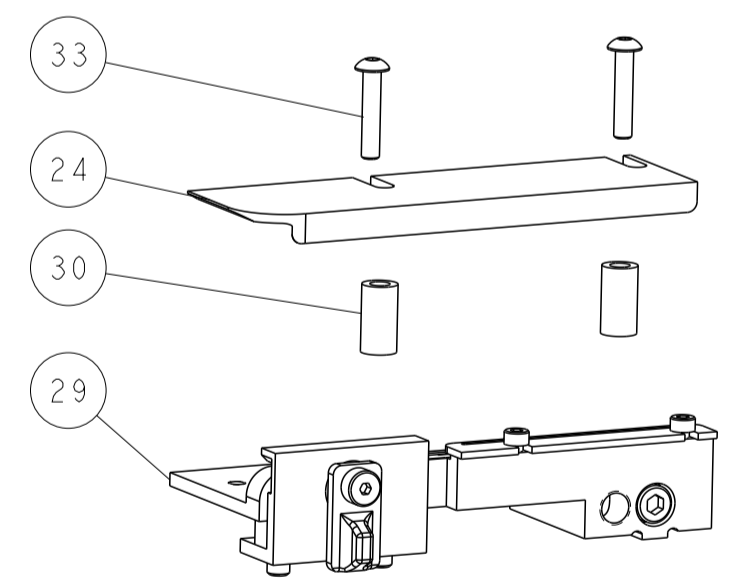
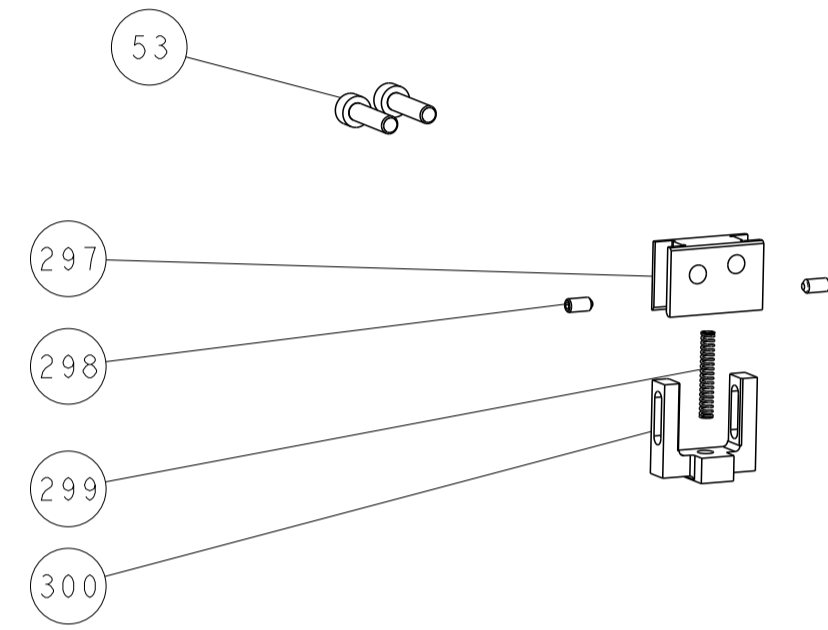
FEED TYPE MECHANICAL



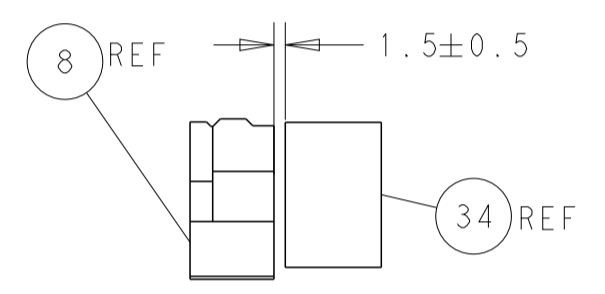
PNEUMATIC



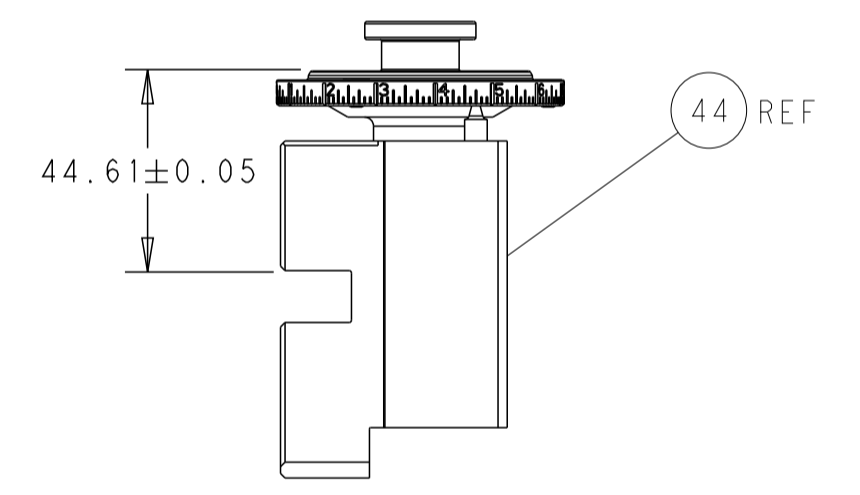
FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



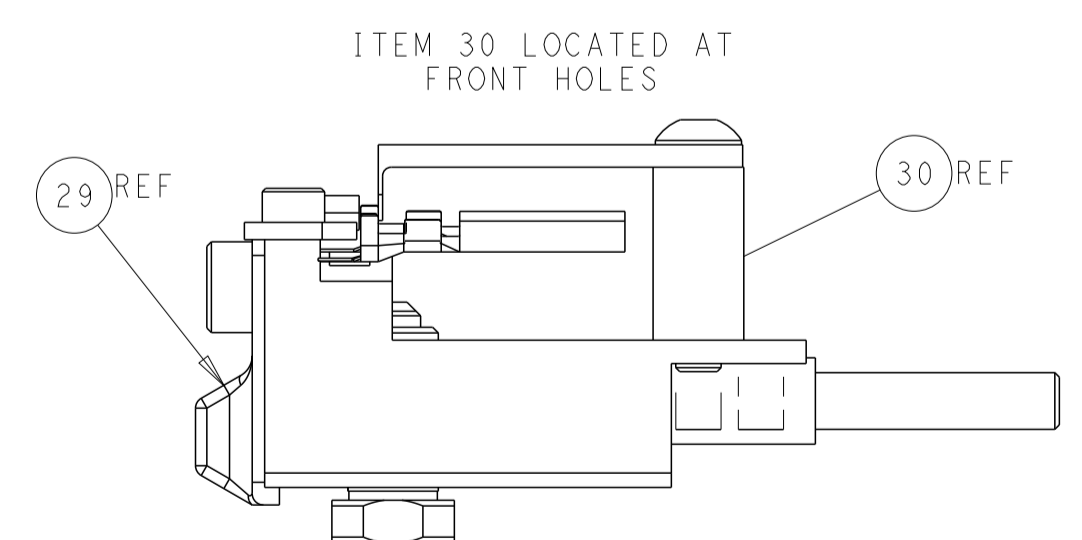
SHEAR DEPRESSOR DETAIL



TERMINAL SUPPORT LOCATION

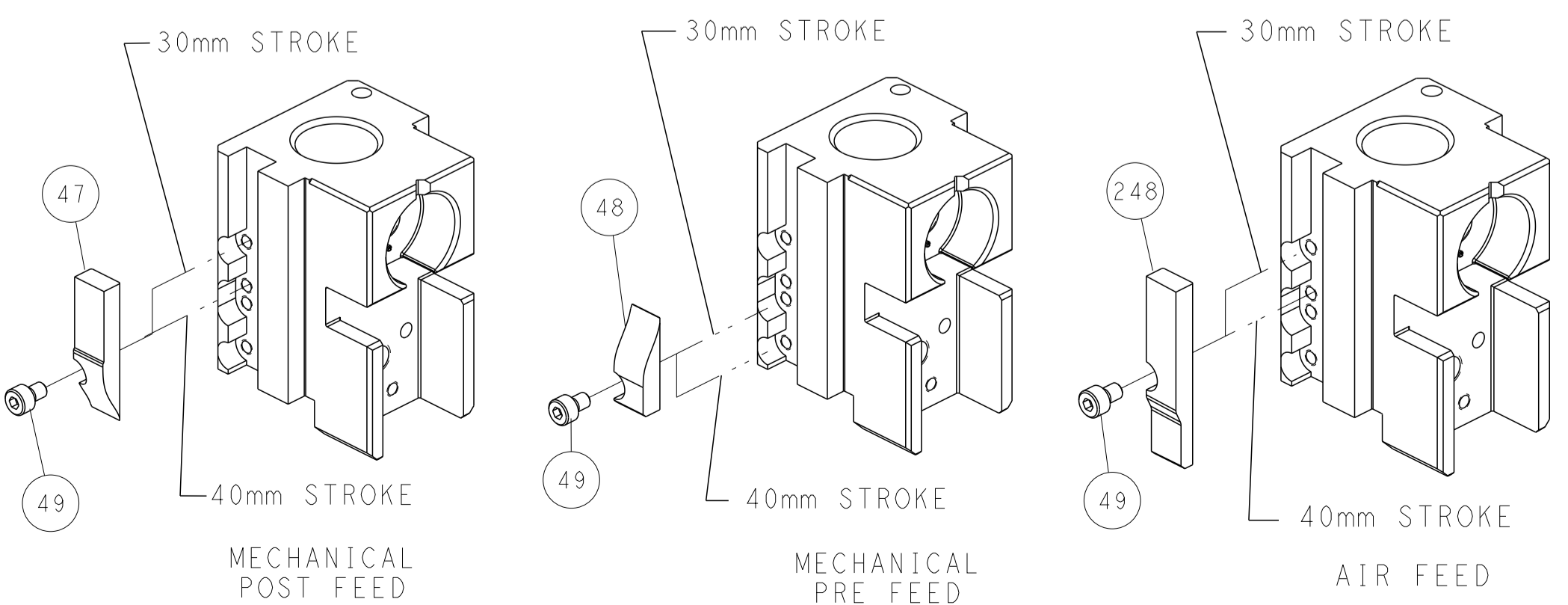


RAM SET-UP



FEED TRACK POSITION GUIDE BY INSULATION BARREL

CAM POSITIONS



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DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH	DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH	WEIGHT: - SCALE: 1:2 SHEET: 2 OF 4 REV: G	RESTRICTED TO: -	CUSTOMER ACCESSIBLE PRODUCTION DRAWING