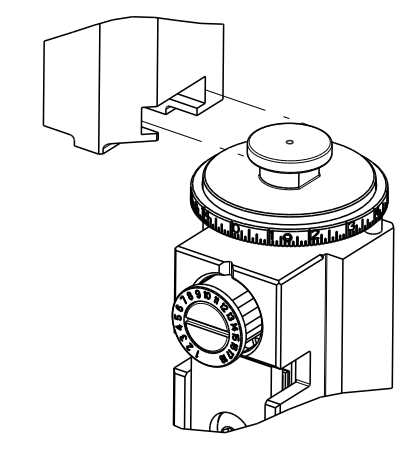


| PART NUMBER | REVISION | DESCRIPTION              | FEED TYPE  |
|-------------|----------|--------------------------|------------|
| 2151110-1   | F        | FINE CRIMP HEIGHT ADJUST | MECHANICAL |
| 2151110-2   | F        | FINE CRIMP HEIGHT ADJUST | PNEUMATIC  |
| 7-2151110-7 | A        | CRIMP TOOLING KIT        | -          |

ATLANTIC VERSION TERMINATOR  
 INTERFACE ADAPTER



APPLICATOR DATA

| CRIMP | SIZE           | TYPE |
|-------|----------------|------|
| WIRE  | 0.90 mm [.035] | F    |
| INSUL | 1.45 mm [.057] | F    |

APPLICATOR INSTRUCTIONS  
 408-35042

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION

TERMINAL NAME: DYNAMIC D 1000 SERIES CONTACT S SIZE

| WIRE STRIP LENGTH           | INSULATION DIAMETER RANGE   |
|-----------------------------|-----------------------------|
| 1.70-2.30 mm [.067-.091 IN] | Ø.60-1.20 mm [.024-.047 IN] |

TERMINAL APPLICATION SPECIFICATION (A)114-5377 (B)114-78021

TERMINALS APPLIED

| TE TERMINAL   | TE TERMINAL   | TE TERMINAL   | TE TERMINAL   |
|---------------|---------------|---------------|---------------|
| (A) 1827569-2 | (A) 1903111-2 | (B) 2316663-1 | (B) 2316670-1 |

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION

TERMINAL NAME: DYNAMIC D 1000 SERIES CONTACT S SIZE

| WIRE STRIP LENGTH           | INSULATION DIAMETER RANGE   |
|-----------------------------|-----------------------------|
| 1.70-2.30 mm [.067-.091 IN] | Ø.60-1.20 mm [.024-.047 IN] |

TERMINAL APPLICATION SPECIFICATION (A)114-5377

TERMINALS APPLIED

| TE TERMINAL   | TE TERMINAL   | TE TERMINAL | TE TERMINAL |
|---------------|---------------|-------------|-------------|
| (A) 2367817-1 | (A) 2367819-1 |             |             |

| WIRE SIZE            | CRIMP HEIGHT mm [INCH]     | CRIMP HEIGHT REFERENCE SETTING |
|----------------------|----------------------------|--------------------------------|
| 0.08-0.10mm2 (28AWG) | 0.57+/-0.03 [.022+/- .001] | 6.0                            |
| 0.05-0.06mm2 (30AWG) | 0.54+/-0.03 [.021+/- .001] | 6.2                            |

| WIRE SIZE            | CRIMP HEIGHT mm [INCH]      | CRIMP HEIGHT REFERENCE SETTING |
|----------------------|-----------------------------|--------------------------------|
| 0.08-0.10mm2 (28AWG) | 0.55+/-0.025 [.021+/- .001] | 6.2                            |
| 0.05-0.06mm2 (30AWG) | 0.52+/-0.03 [.020+/- .001]  | 6.2                            |

- 1. RECOMMENDED SPARE PARTS
- 2. REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- 3. APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 180. 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. 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 | REV | LTN | DESCRIPTION   | DATE      | OWN | APVD |
|-----|------|-----|-----|---------------|-----------|-----|------|
| A   | 66   |     |     |               |           |     |      |
|     |      | C   |     | ECR-18-006942 | 09MAY2018 | MZ  | JDG  |
|     |      | D   |     | ECR-18-010739 | 09JUL2018 | FZ  | KZ   |
|     |      | E   |     | ECR-21-006826 | 12JUL2021 | FZ  | RK   |
|     |      | F   |     | ECR-24-217191 | 07AUG2024 | AB  | MINI |

|   |     |     |             |                                     |     |
|---|-----|-----|-------------|-------------------------------------|-----|
| - | 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 |
| 3 | -   | 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 |
| - | 2   | 2   | 1-2079383-0 | SCR, BHSC, RoHS (M3 X 6)            | 230 |
| 3 | -   | 1   | 2-1752354-0 | STANDOFF, HOLD-DOWN                 | 180 |
| - | 1   | 1   | 1633764-7   | HOLD DOWN, TERMINAL                 | 179 |
| - | 1   | 1   | 993111-1    | PIN, SLOTTED SPRING 3.0 X 20.0      | 177 |
| - | 1   | 1   | 8-22280-7   | SPRING, COMPRESSION                 | 176 |
| - | 1   | 1   | 1752353-2   | GUIDE PIN, HOLDDOWN                 | 175 |
| - | 1   | 1   | 1901680-2   | GUIDE PIN, HOLDDOWN                 | 174 |
| - | REF | REF | 994970-2    | COUNTER, MAGNETIC                   | 164 |
| - | 1   | 1   | 2844908-1   | SCREW, LOCKING                      | 99  |
| - | 1   | 1   | 2844907-1   | POST, LOCKING                       | 98  |
| - | 1   | 1   | 1-455888-5  | SPACER, CRIMPER -                   | 82  |
| - | 1   | 1   | 1962431-2   | SPRING, COMPRESSION                 | 77  |
| - | 1   | 1   | 854769-4    | HOLDER, INS                         | 74  |
| - | 1   | 1   | 1803607-3   | DOCUMENTATION PACKAGE               | 71  |
| - | 1   | 1   | 2119791-9   | 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   | 21028-2     | PIN, SLOTTED SPRING .062 X .250     | 58  |
| - | 1   | 1   | 1338685-1   | PAWL, FEED                          | 56  |
| - | 4   | 4   | 2168083-3   | SCR, SKT HD CAP, RoHS, M4 X 12.0    | 54  |
| - | 1   | 1   | 1-5018030-0 | NUT, HEX, REG, RoHS, M3.5           | 52  |
| - | 1   | 1   | 1901681-8   | HOLDDOWN, TERMINAL                  | 51  |
| - | 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   | 1803515-3   | RAM ASSEMBLY, SF ATLANTIC           | 44  |
| - | 1   | 1   | 1803602-1   | SCR, BHSC, RoHS (M8 X 25)           | 41  |
| - | 1   | 1   | 1-1752356-7 | 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   | 455888-5    | SPACER, CRIMPER -                   | 28  |
| - | 1   | 1   | 1320928-2   | STRIP GUIDE -                       | 24  |
| - | 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   | 2119533-4   | 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   | 1633861-1   | SHEAR, FLOATING                     | 9   |
| 1 | 1   | 1   | 2-1729372-7 | ANVIL                               | 8   |
| - | 1   | 1   | 2119780-4   | DEPRESSOR, SHEAR -                  | 5   |
| - | 1   | 1   | 5-238011-6  | BLOCK, CRIMPER SPACER               | 4   |
| 1 | 1   | 1   | 3-1633962-2 | CRIMPER, INSULATION F PREMIUM       | 3   |
| 1 | 1   | 1   | 1-1633713-3 | CRIMPER, WIRE PREMIUM               | 1   |

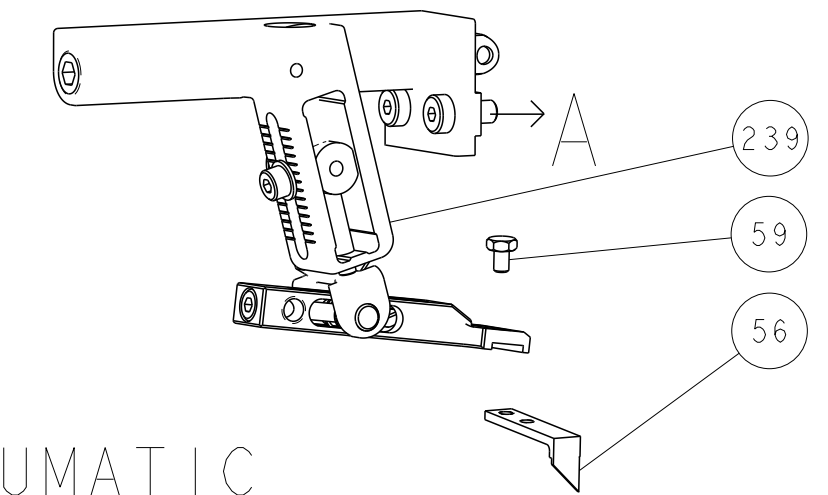
| ITEM NO | PART NO | DESCRIPTION |
|---------|---------|-------------|
| -77     | -2      | -1          |

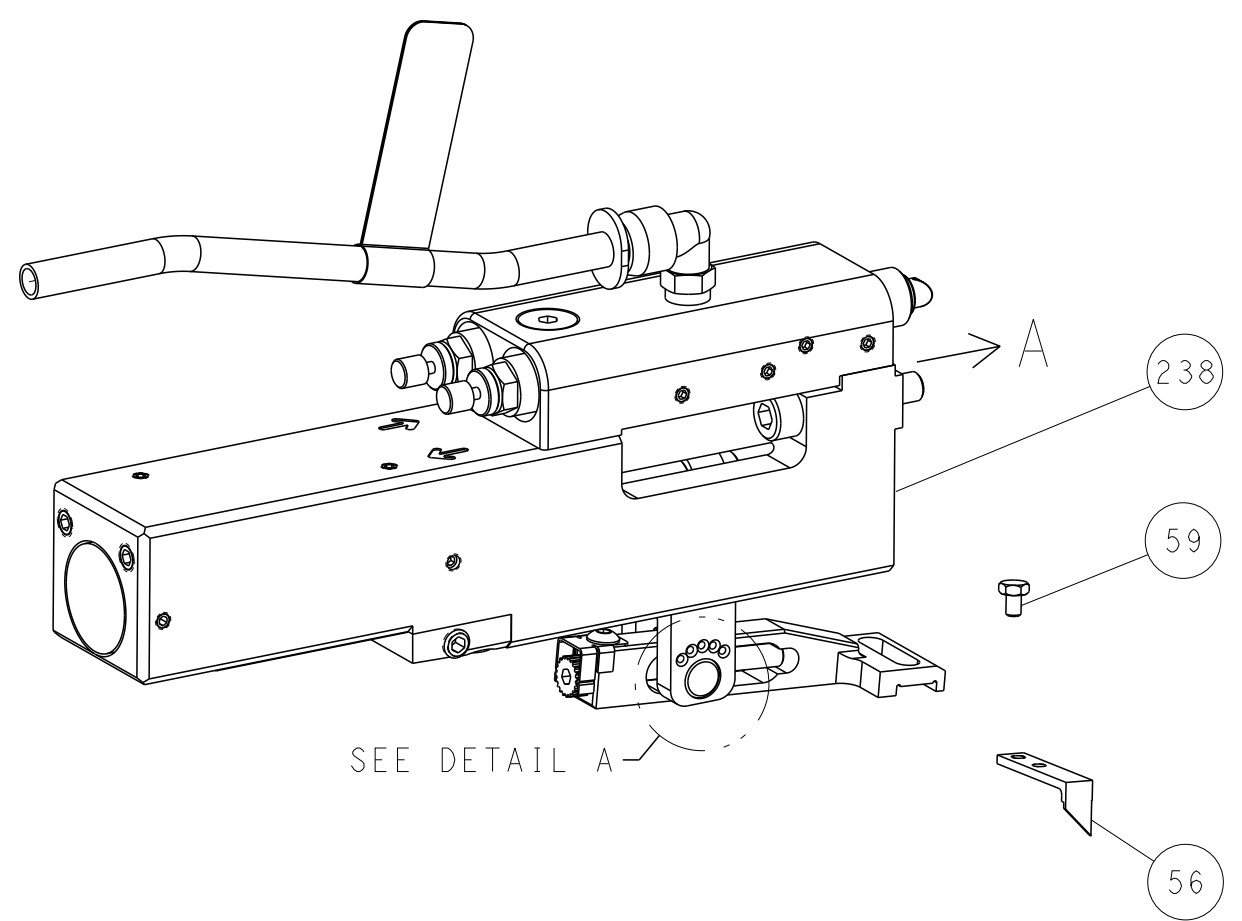
|  |  |  |  |
|--|--|--|--|
| DIMENSIONS: mm<br>0 PLC ±<br>1 PLC ±<br>2 PLC ±<br>3 PLC ±<br>4 PLC ±<br>ANGLES ±<br>MATERIAL FINISH |  | TOLERANCES UNLESS OTHERWISE SPECIFIED:<br>±<br>±<br>±<br>±<br>±<br>±   |  |
| DWN C. CHEN 02JUN2011<br>CHK S. XI 02JUN2011<br>APVD J. CRUZ 02JUN2011                               |  | NAME OCEAN SIDE FEED APPLICATOR<br>SIZE CAGE CODE DRAWING NO RESTRICTED TO<br>A1 00779 C=2151110<br>SCALE 1:2 SHEET 1 OF 4 REV F |  |

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

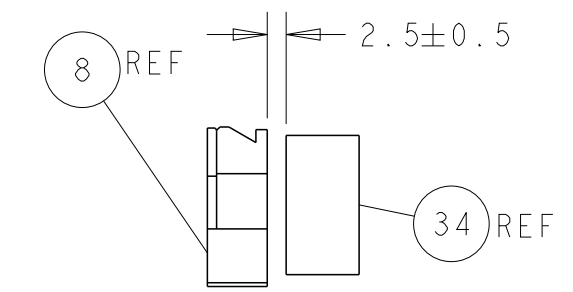
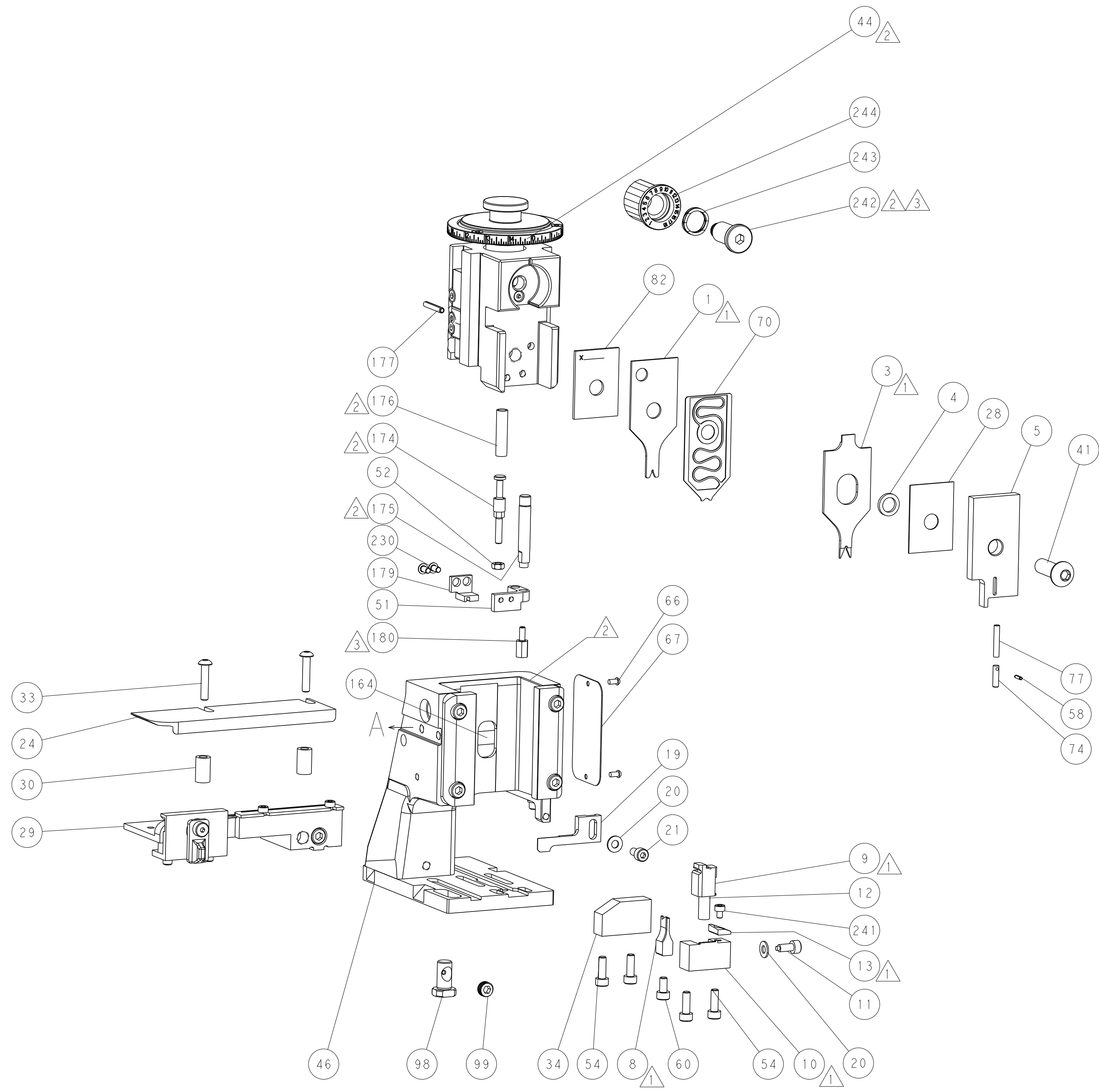
# FEED TYPE MECHANICAL



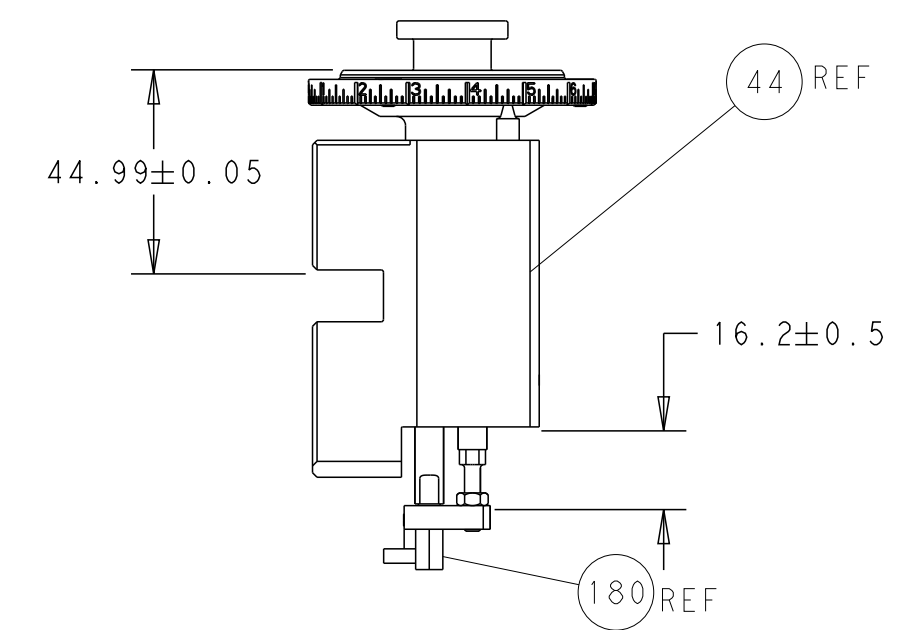
## PNEUMATIC



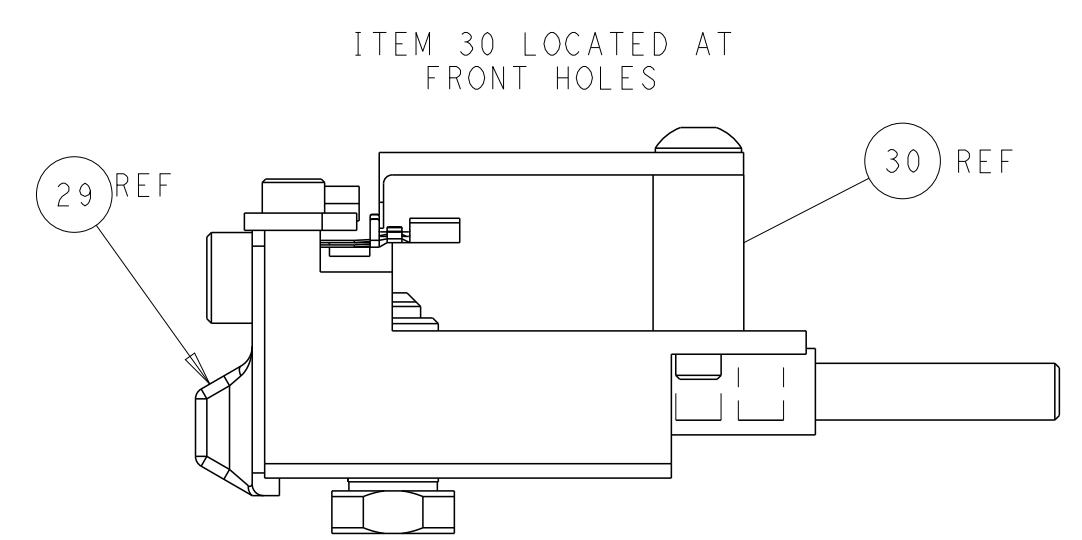
## FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



TERMINAL SUPPORT LOCATION

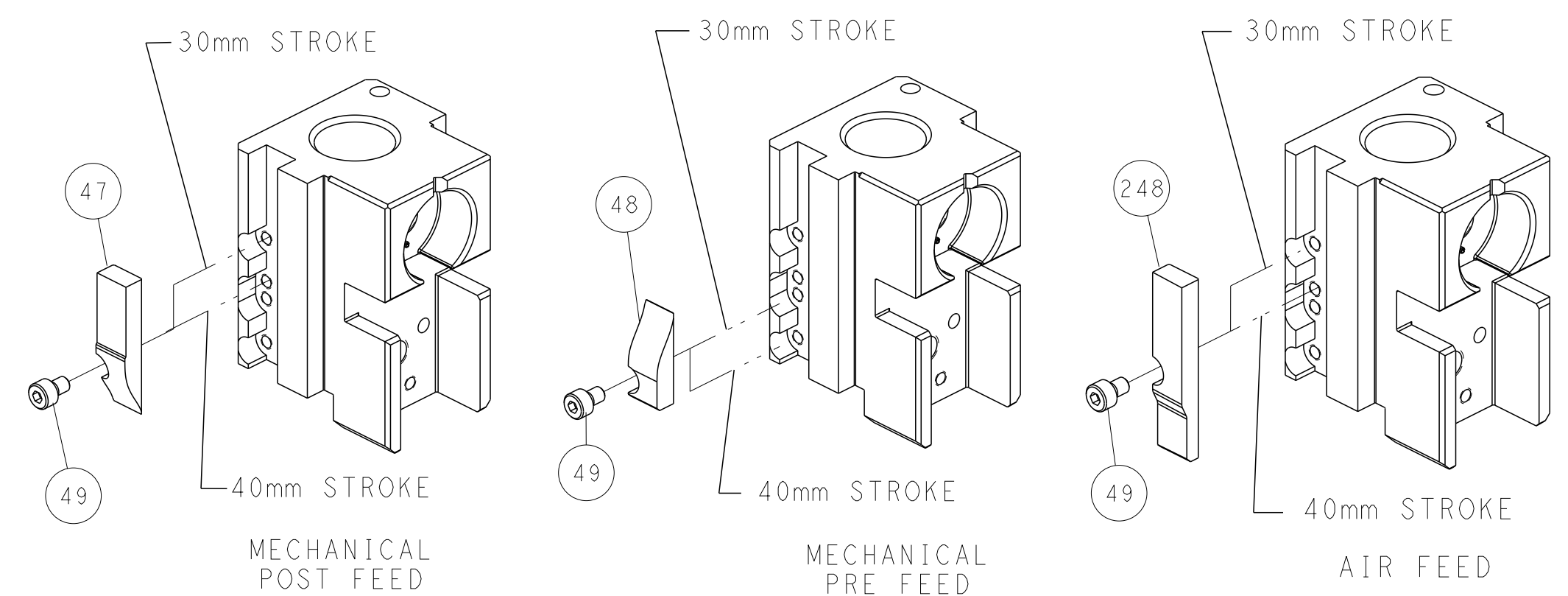


HOLDDOWN AND RAM SET-UP



FEED TRACK POSITION GUIDE BY INSULATION BARREL

# CAM POSITIONS



| DIMENSIONS:                            |         | TOLERANCES UNLESS OTHERWISE SPECIFIED: |  | DWG  |              | TE Connectivity            |  |
|--|---------|--|--|--|--------------|----------------------------|--|
| mm                                     | 0 PLC   | ±                                      |  | C. CHEN                                    | 02JUN2011    | Harrisburg, PA 17105-3608  |  |
|  | 1 PLC   | ±                                      |  | S. XI                                      | 02JUN2011    | OCEAN SIDE FEED APPLICATOR |  |
|  | 2 PLC   | ±                                      |  | APVD: J. CRUZ 02JUN2011                    |              |                            |  |
|  | 3 PLC   | ±                                      |  | PRODUCT SPEC                               |              |                            |  |
|  | 4 PLC   | ±                                      |  | APPLICATION SPEC                           |              |                            |  |
|  | ANGLES  | ±                                      |  | SIZE: CAGE CODE: DRAWING NO: RESTRICTED TO |              |                            |  |
| MATERIAL:                              | FINISH: |  |  | WEIGHT:                                    |              | A1 00779 ©=2151110         |  |
| Customer Accessible Production Drawing |         |  |  | SCALE: 1:2                                 | SHEET 2 OF 4 | REV F                      |  |