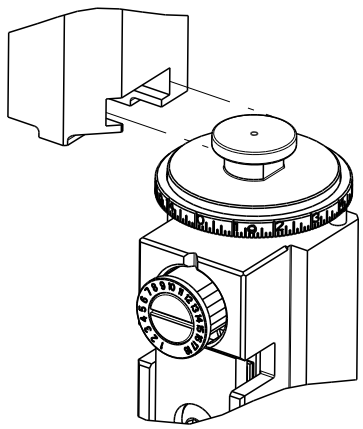
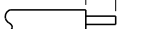


8		7	
THIS DRAWING IS UNPUBLISHED.		RELEASED FOR PUBLICATION	
20		20	
© COPYRIGHT 20 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.			
PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151927-2	E	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151927-2	E	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2151927-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	4.20 mm [1.165]	F
INSUL	6.20 mm [1.244]	OV
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: 8mm NGI TAB			
WIRE STRIP LENGTH			INSULATION DIAMETER RANGE
6.50-7.50 mm [1.256-.295 IN]			
TERMINAL APPLICATION SPECIFICATION	114-15112	-	-
		-	-
TERMINALS APPLIED 			
TE TERMINAL		TE TERMINAL	TE SEAL
1544332-1			1544316-1
			SEAL INSULATION DIAMETER RANGE
			3.35-4.30

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
6.00mm2	2.95+/-0.05 [1.116+/-0.002]	5.3
5.00mm2	2.80+/-0.05 [1.110+/-0.002]	7.2
4.00mm2	2.65+/-0.05 [1.104+/-0.002]	8.6
3.00mm2	2.50+/-0.05 [1.098+/-0.002]	10.2



- 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 PITCH NOT COMPATIBLE WITH MECHANICAL FEED..
6. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- APPLY TORQ-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.
- CUT TO LENGTH AT ASSEMBLY.

*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)

2		1							
LOC	DIST	REVISIONS							
A	66	P	LTR	DESCRIPTION			DATE	DWN	APVD
		B		ECR-18-018046			16NOV2018	TB	CT
		C		ECR-19-008843			05JUN2019	FJ	TE
		D		ECR-19-012934			16AUG2019	FJ	TE
		E		ECR-22-130189			21FEB2022	TB	RK

3	-	1	1	1803078-1	SPACER, PRECISION	259	
	-	1	1	2119641-1	FEED CAM, AIR FEED	248	
	-	1	1	2119082-6	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	2844940-2	AIR FEED MODULE	238	
	-	REF	REF	994970-2	COUNTER, MAGNETIC	164	
	-	1	1	2844908-1	SCREW, LOCKING	99	
	-	1	1	2844907-1	POST, LOCKING	98	
8	-	1	1	455888-6	SPACER, CRIMPER	82	
	-	2	2	2079383-4	SCR, BHSC, RoHS (M4 X 8)	79	
	-	1	1	1803096-1	EXTENSION PLATE	78	
7	-	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	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	985575-5	SCR, FLT SKT HD CAP M3 X 16.0	57	
	-	1	1	1-1338683-1	FEED PAWL	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	5018030-1	NUT, HEX, REG, RoHS, M3	52	
	-	1	1	811242-5	BUMPER, HOLD DOWN	51	
	-	1	1	690753-2	SPACER, TONKER	50	
	-	1	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49	
	-	1	1	1-1803583-7	APPLICATOR BASIC ASSEMBLY, SF	46	
	-	1	1	1803515-2	RAM ASSEMBLY, SF ATLANTIC	44	
1	-	1	1	1803602-2	SCR, BHSC, RoHS (M8 X 40)	41	
	-	1	1	1-1752356-9	SUPPORT, TERMINAL	34	
	-	2	2	2079383-8	SCR, BHSC, RoHS (M4 X 16)	33	
	-	2	2	2-2844962-6	SPACER, CYLINDRICAL, STRIP GUIDE	30	
	-	1	1	2844992-5	ASSEMBLY, STRIP GUIDE	29	
	-	1	1	455888-3	SPACER, CRIMPER	28	
	-	2	2	22281-8	SPRING, COMPRESSION	27	
	-	1	1	240792-1	DRAG, TERMINAL	25	
	-	1	1	1320928-4	STRIP GUIDE	24	
	-	1	1	1-690438-0	FRONT STRIP GUIDE	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	1803013-1	STRIPPER, SIDE FEED	18	
	-	1	1	3-22280-3	SPRING, COMPRESSION	12	
	-	1	1	1-356885-3	STOP, SHEAR	11	
	-	1	1	1-2119805-2	SHEAR HOLDER, FRONT	10	
	-	1	1	1-318059-0	FLOATING SHEAR, FRONT	9	
	-	1	2	1	4-1633927-9	ANVIL, COMBINATION	8
	-	-	-	-	-	7	
	-	-	-	-	-	6	
	-	1	1	1803080-1	DEPRESSOR, SHEAR	5	
-	1	1	4-238011-4	BLOCK, CRIMPER SPACER	4		
-	1	2	1	1803111-1	CRIMPER, INSULATION OVERLAP PREMIUM	3	
-	1	1	1	2-455888-2	SPACER, CRIMPER	2	
-	1	2	1	4-1633730-8	CRIMPER, WIRE	1	

1
1
1

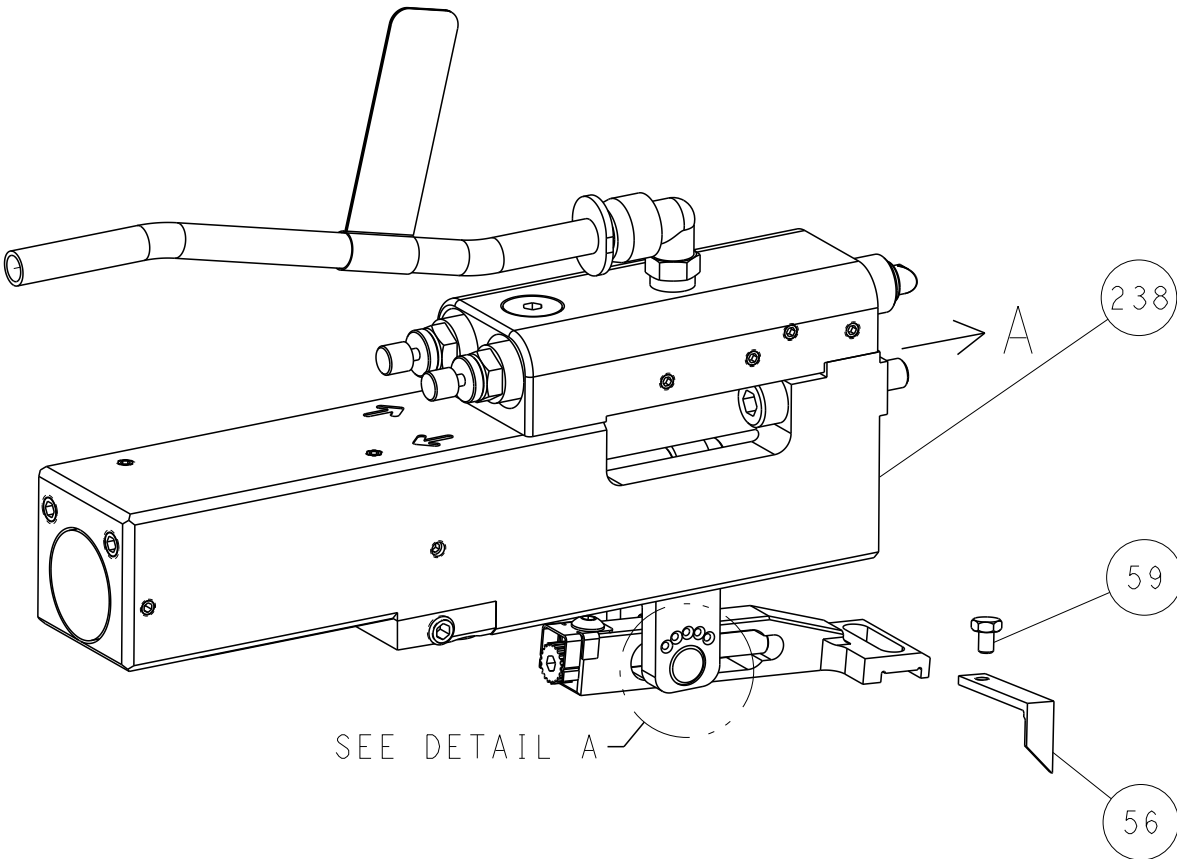
1
1

THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. THE USER SHALL BE RESPONSIBLE FOR THE LATEST EDITION.		DWN	13JUN2013	TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS:		CHK	13JUN2013	NAME	
mm		APVD	13JUN2013	Ocean Side Feed Applicator	
TOLERANCES UNLESS OTHERWISE SPECIFIED:		PRODUCT SPEC		SIZE	
0 PLC ±		APPLICATION SPEC		CAGE CODE	
1 PLC ±		WEIGHT		DRAWING NO	
2 PLC ±		MATERIAL		00779	
3 PLC ±		FINISH		2151927	
4 PLC ±		SCALE		1:2	
ANGLES		SHEET		1 OF 4	
RESTRICTED TO		REV		E	

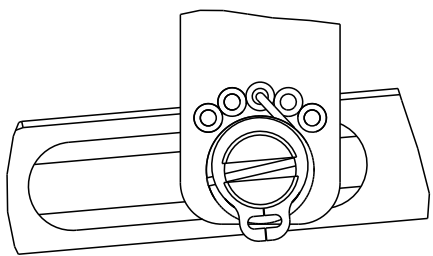
SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

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

FEED TYPE
PNEUMATIC

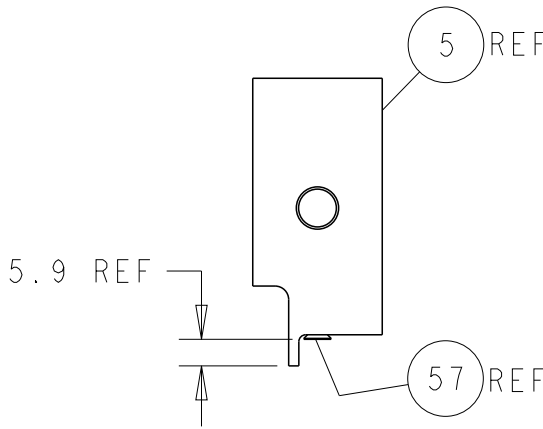
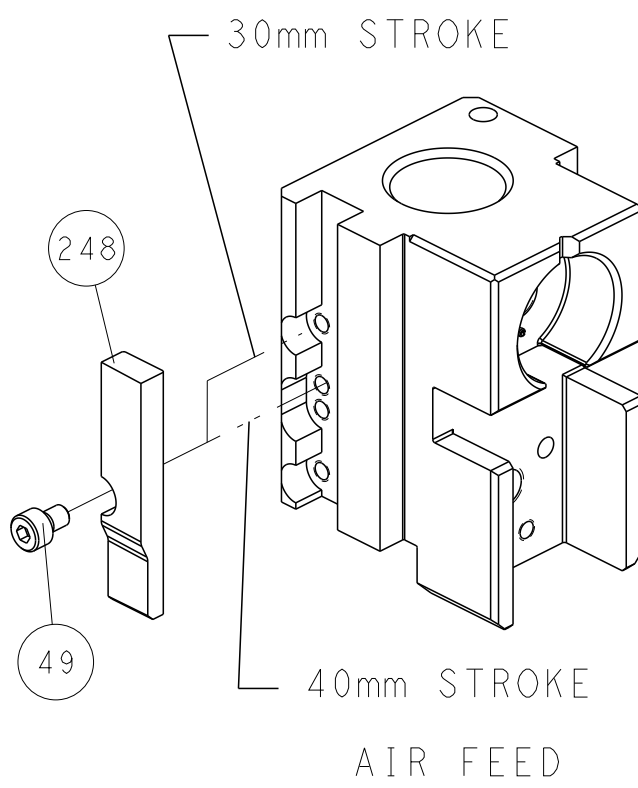


FEED SPRING SETTING POSITION
(SHOWN FROM REAR SIDE)

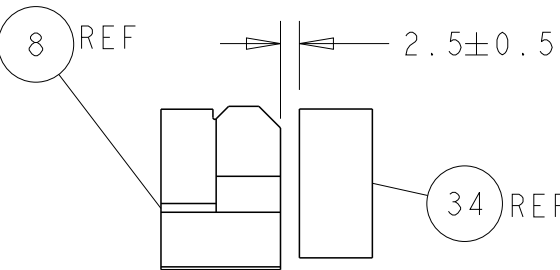


DETAIL A

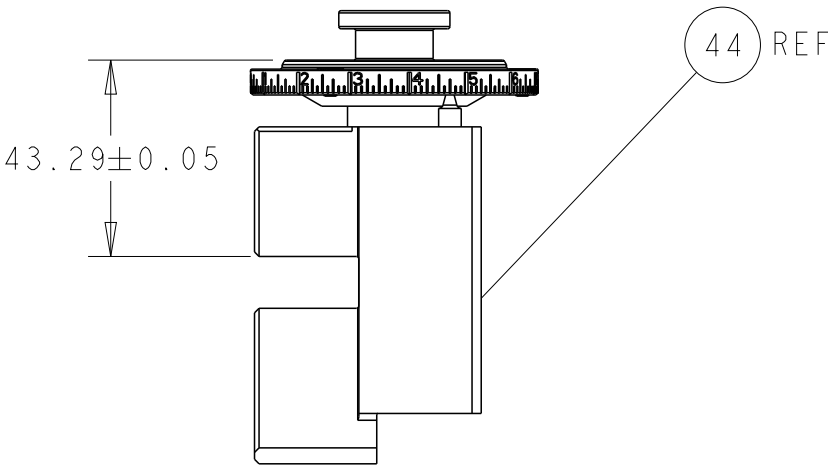
CAM POSITION



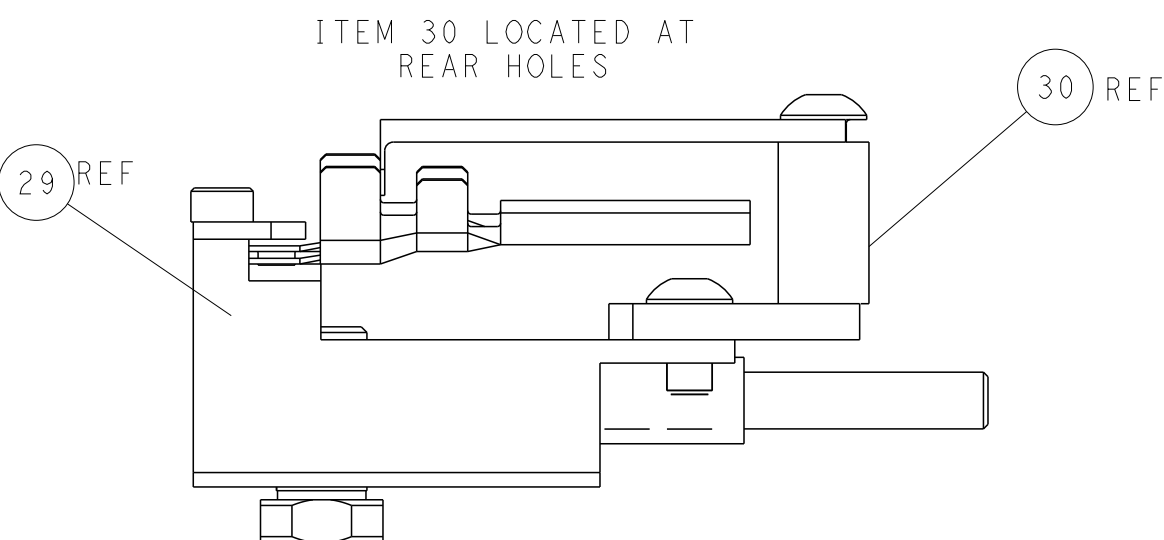
SHEAR DEPRESSOR DETAIL



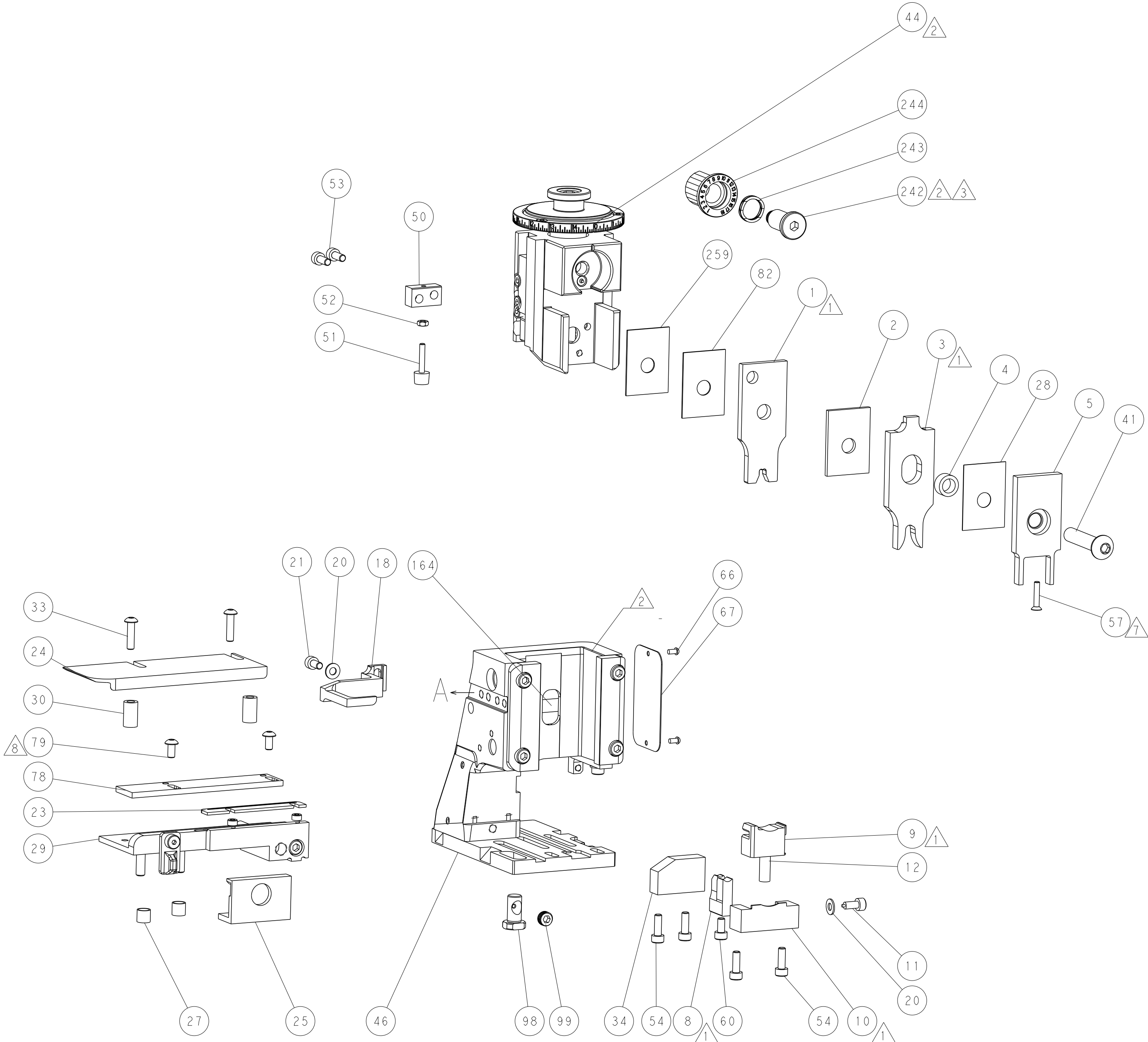
TERMINAL SUPPORT LOCATION



RAM SET-UP



FEED TRACK POSITION
GUIDE BY INSULATION BARREL



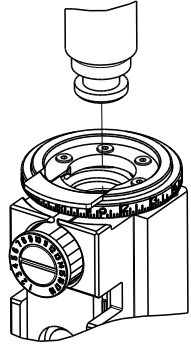
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. IT IS THE RESPONSIBILITY OF THE USER TO CONTACT THE ORGANIZATION FOR THE LATEST REVISION.				OWN	13JUN2013	TE Connectivity Harrisburg, PA 17105-3608		
				CHKD	13JUN2013			
				APVD	13JUN2013			
				PRODUCT SPEC				
				APPLICATION SPEC				
				WEIGHT	-			
				SCALE	1:2			
				SHEET	2			
				REV	E			

SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

8	7
THIS DRAWING IS UNPUBLISHED.	
RELEASED FOR PUBLICATION 20	
COPYRIGHT 20 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.	
PART NUMBER	REVISION
DESCRIPTION	FEED TYPE
2-2151927-2	E
FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151927-7	A
CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	4.20 mm [.165]	F
INSUL	6.20 mm [.244]	OV
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: 8mm NGI TAB			
WIRE STRIP LENGTH 6.50-7.50 mm [.256-.295 IN]		INSULATION DIAMETER RANGE Ø	
TERMINAL APPLICATION SPECIFICATION 114-15112		-	-
TERMINALS APPLIED △5		-	-
TE TERMINAL 1544332-1	TE TERMINAL	TE SEAL	TE SEAL 1544316-1
			SEAL INSULATION DIAMETER RANGE 3.35-4.30

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
6.00mm2	2.95+/-0.05 [.116+/- .002]	5.3
5.00mm2	2.80+/-0.05 [.110+/- .002]	7.2
4.00mm2	2.65+/-0.05 [.104+/- .002]	8.6
3.00mm2	2.50+/-0.05 [.098+/- .002]	10.2

*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.

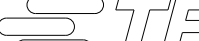


- RECOMMENDED SPARE PARTS
- REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242.
- CRIMP HEIGHT REFERENCE SETTING WAS THE SETTING USED WHEN THE APPLICATOR WAS QUALIFIED AT THE FACTORY. ADJUSTMENT MAY BE NECESSARY WHEN RUNNING APPLICATOR IN THE FIELD.
- TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED..
- UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- APPLY TORQ-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.
- CUT TO LENGTH AT ASSEMBLY.

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

LOC		DIST		REVISONS				
A		66		P	LTR	DESCRIPTION	DATE	DWN
				-		SEE SHEET 1	-	-

-	1	1803078-1	SPACER, PRECISION	259
-	1	2119082-6	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
3	1	2119083-1	RETAINER, INSULATION DIAL	242
-	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	1-1803583-8	APPLICATOR BASIC ASSEMBLY, SF	141
-	1	1803516-2	RAM ASSEMBLY, SF PACIFIC	140
-	1	2844908-1	SCREW, LOCKING	99
-	1	2844907-1	POST, LOCKING	98
-	1	455888-6	SPACER, CRIMPER	82
8	2	2079383-4	SCR, BHSC, RoHS (M4 X 8)	79
-	1	1803096-1	EXTENSION PLATE	78
-	1	1803607-3	DOCUMENTATION PACKAGE	71
-	1	2119740-1	TAG, IDENTIFICATION	67
-	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
7	1	985575-5	SCR, FLT SKT HD CAP M3 X 16.0	57
-	1	1-1338683-1	FEED PAWL	56
-	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	53
-	1	5018030-1	NUT, HEX, REG, RoHS, M3	52
-	1	811242-5	BUMPER, HOLD DOWN	51
-	1	690753-2	SPACER, TONKER	50
-	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	1	1803602-2	SCR, BHSC, RoHS (M8 X 40)	41
-	1	1-1752356-9	SUPPORT, TERMINAL	34
-	2	2079383-8	SCR, BHSC, RoHS (M4 X 16)	33
-	2	2-2844962-6	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	2844992-5	ASSEMBLY, STRIP GUIDE	29
-	1	455888-3	SPACER, CRIMPER	28
-	2	22281-8	SPRING, COMPRESSION	27
-	1	240792-1	DRAG, TERMINAL	25
-	1	1320928-4	STRIP GUIDE	24
-	1	1-690438-0	FRONT STRIP GUIDE	23
-	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
-	2	1-18028-2	WASHER, FLAT, REG M4	20
-	1	1803013-1	STRIPPER, SIDE FEED	18
-	1	3-22280-3	SPRING, COMPRESSION	12
-	1	1-356885-3	STOP, SHEAR	11
1	1	1-2119805-2	SHEAR HOLDER, FRONT	10
1	1	1-318059-0	FLOATING SHEAR, FRONT	9
1	1	4-1633927-9	ANVIL, COMBINATION	8
-	-	-	-	7
-	-	-	-	6
-	1	1803080-1	DEPRESSOR, SHEAR	5
-	1	4-238011-4	BLOCK, CRIMPER SPACER	4
1	1	1803111-1	CRIMPER, INSULATION OVERLAP PREMIUM	3
-	1	2-455888-2	SPACER, CRIMPER	2
1	1	4-1633730-8	CRIMPER, WIRE	1

-77	-22	PART NO	DESCRIPTION				ITEM NO
OWN		13JUN2013	 TE Connectivity				
CHK		13JUN2013					
APVD		13JUN2013	NAME				
PRODUCT SPEC							
APPLICATION SPEC							
MATERIAL		SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO		
-		A1	00779	C=2151927	-		
Customer Accessible Production Drawing			SCALE	1:2	SHEET	3	OF 4
			REV	E			

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

THIS DRAWING IS A CONTROLLED DOCUMENT FOR TEO ELECTRONICS CORPORATION IT IS SUBJECT TO THE COMPANY'S PATENT RIGHTS AND ANY REUSE OR REPRODUCTION SHOULD BE FOR THE LATEST REVISION.		DWN 13JUN2013		TE Connectivity	
		CNR 13JUN2013		Harrisburg, PA 17105-3608	
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		NAME	
mm		APVD 13JUN2013		Ocean Side Fed	
		PRODUCT SPEC		Appliator	
0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		APPLICATION SPEC		-	
FINISH		WEIGHT		RESTRICTED TO	
-		-		-	
		A 00779		C=2151927	
		Customer Accessible Production Drawing		SCALE 1:2 SHEET 4 OF 4 REV E	