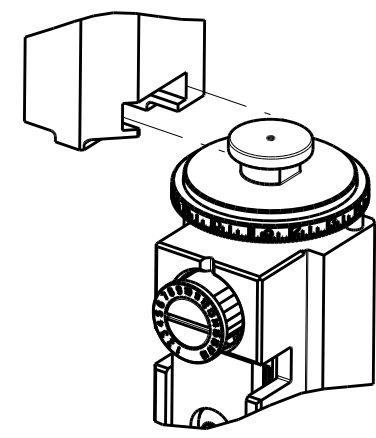


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151396-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2151396-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151396-1	C	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2151396-2	C	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2151396-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.34 mm [.092]	F
INSUL	4.83 mm [.190]	F

APPLICATOR INSTRUCTIONS  
408-35042

TERMINAL DATA: JST TERMINAL		JST CRIMP SPECIFICATION	
TERMINAL NAME: VL CONNECTOR			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
5.00-5.50 mm [.197-.217 IN]		Ø1.90-3.40 mm [.075-.134 IN]	
TERMINAL APPLICATION SPECIFICATION	HM-0106 Rev R4		
TERMINALS APPLIED			
TE TERMINAL	JST TERMINAL	TE TERMINAL	JST TERMINAL
1572905-1	SVF-61T-P2.0	286971-1	SVM-61T-P2.0

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.75+1.25 (18+16AWG)	1.60+/-0.05 [.063+/-0.002]	2.5
14 AWG OR 2.00mm2	1.60+/-0.05 [.063+/-0.002]	2.6
0.5+1.25 (20+16AWG)	1.55+/-0.05 [.061+/-0.002]	3.1
0.75+0.75 (18+18AWG)	1.50+/-0.05 [.059+/-0.002]	3.6
0.5+0.75 (20+18AWG)	1.45+/-0.05 [.057+/-0.002]	4.1
16 AWG OR 1.25mm2	1.45+/-0.05 [.057+/-0.002]	4.0
0.5+0.5 (20+20AWG)	1.35+/-0.05 [.053+/-0.002]	5.1
18 AWG OR 0.75mm2	1.25+/-0.05 [.049+/-0.002]	6.3
20 AWG OR 0.50mm2	1.10+/-0.05 [.043+/-0.002]	7.9



- 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 CUT TO LENGTH AT ASSEMBLY.
- 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)

LOC	DIST	REVISIONS					
A	66	P	LTN	DESCRIPTION	DATE	OWN	APVD
		B		ECR-15-010983	24JUL2015	XZ	TE
		C		ECR-19-006306	18APR2019	FJ	TE

-	1	1	1	1	455888-1	SPACER, CRIMPER	263	
-	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	1	2119082-9	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	18023-1	SCR, SKT HD CAP M3 X 5.0	241	
-	-	1	-	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	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	1-18028-2	WASHER, FLAT, REG M4	119	
-	1	1	1	1	2844908-1	SCREW, LOCKING	99	
-	1	1	1	1	2844907-1	POST, LOCKING	98	
-	1	1	1	1	455888-1	SPACER, CRIMPER	82	
-	1	1	1	1	1803607-1	DOCUMENTATION PACKAGE	71	
-	1	1	1	1	2119791-9	DEPRESSOR, WIRE	70	
-	1	1	1	1	2119943-1	WASHER, SPACER	69	
-	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	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	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	53	
-	1	1	1	1	5018030-1	NUT, HEX, REG, RoHS, M3	52	
-	1	1	1	1	811242-5	BUMPER, HOLD DOWN	51	
-	1	1	1	1	690753-2	SPACER, TONKER	50	
-	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	1752356-1	SUPPORT, TERMINAL	34	
-	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33	
-	2	2	2	2	2-2844962-8	SPACER, CYLINDRICAL, STRIP GUIDE	30	
-	1	1	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29	
-	1	1	1	1	1-455888-0	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	1803095-1	FLOATING SHEAR, FRONT	9	
1	2	2	1	1	1-1633927-0	ANVIL, COMBINATION	8	
-	-	-	-	-	-	-	6	
-	1	1	1	1	2119757-8	DEPRESSOR, SHEAR	5	
-	1	1	1	1	1-238011-7	BLOCK, CRIMPER SPACER	4	
1	2	2	1	1	3-1633961-1	CRIMPER, INSULATION F PREMIUM	3	
-	1	1	1	1	455888-4	SPACER, CRIMPER	2	
1	2	2	1	1	1673600-2	CRIMPER, WIRE	1	
-	77	-72	-71	-2	-1	PART NO	DESCRIPTION	ITEM NO

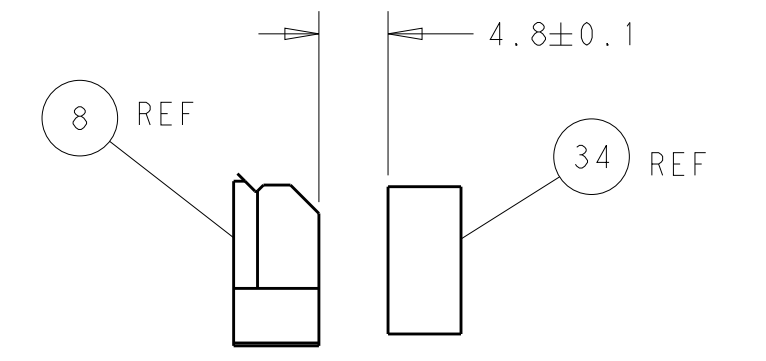
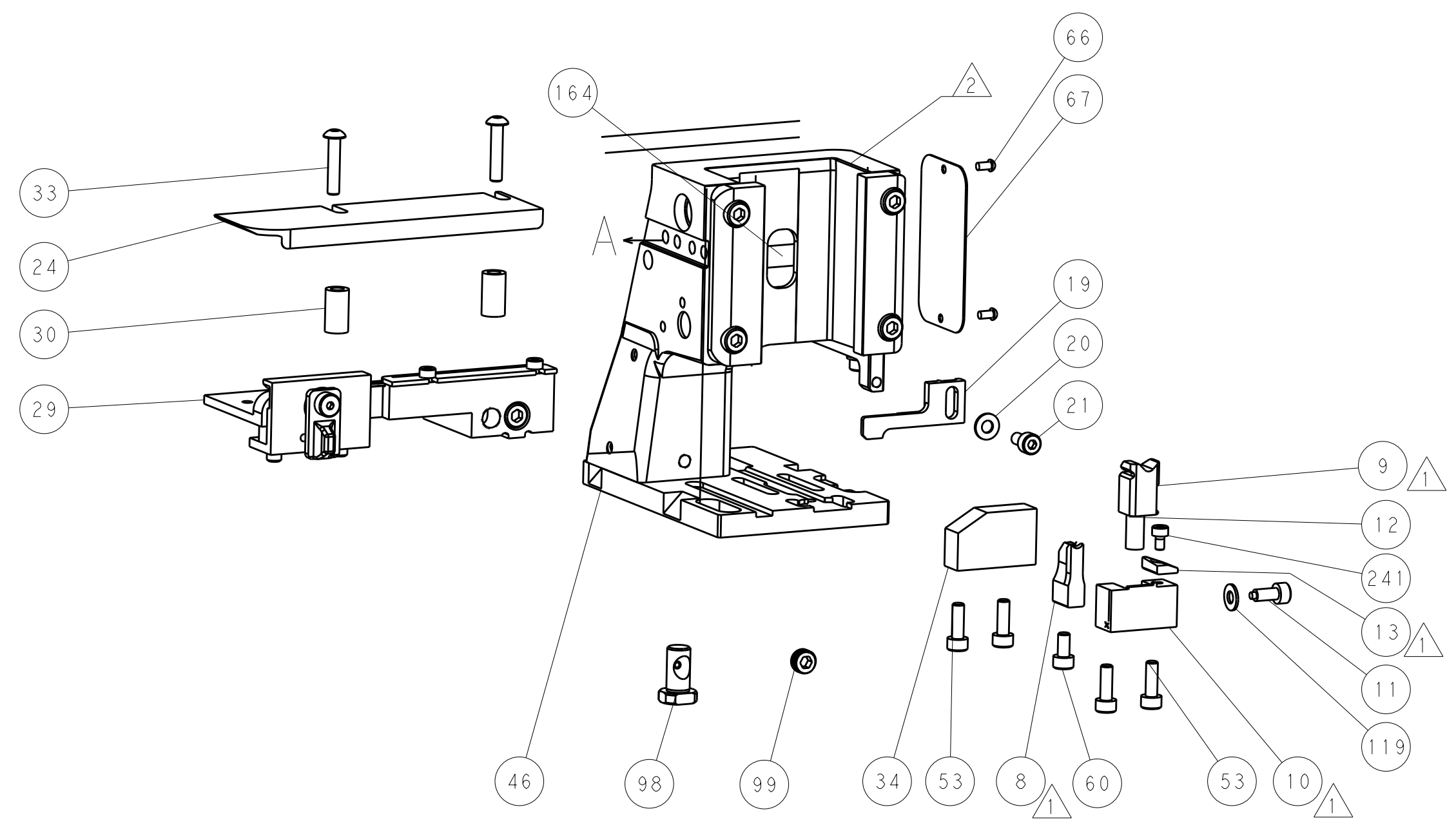
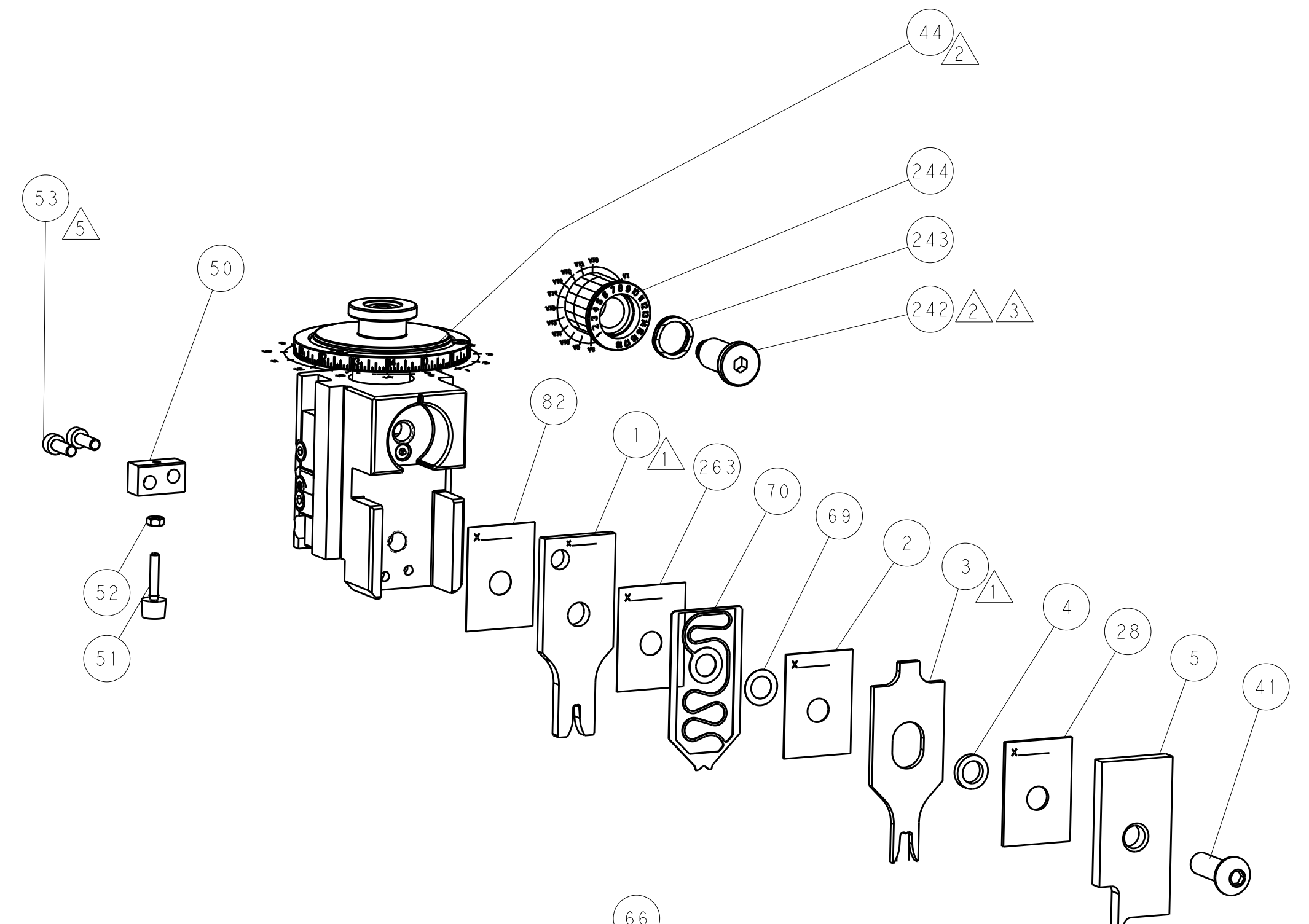
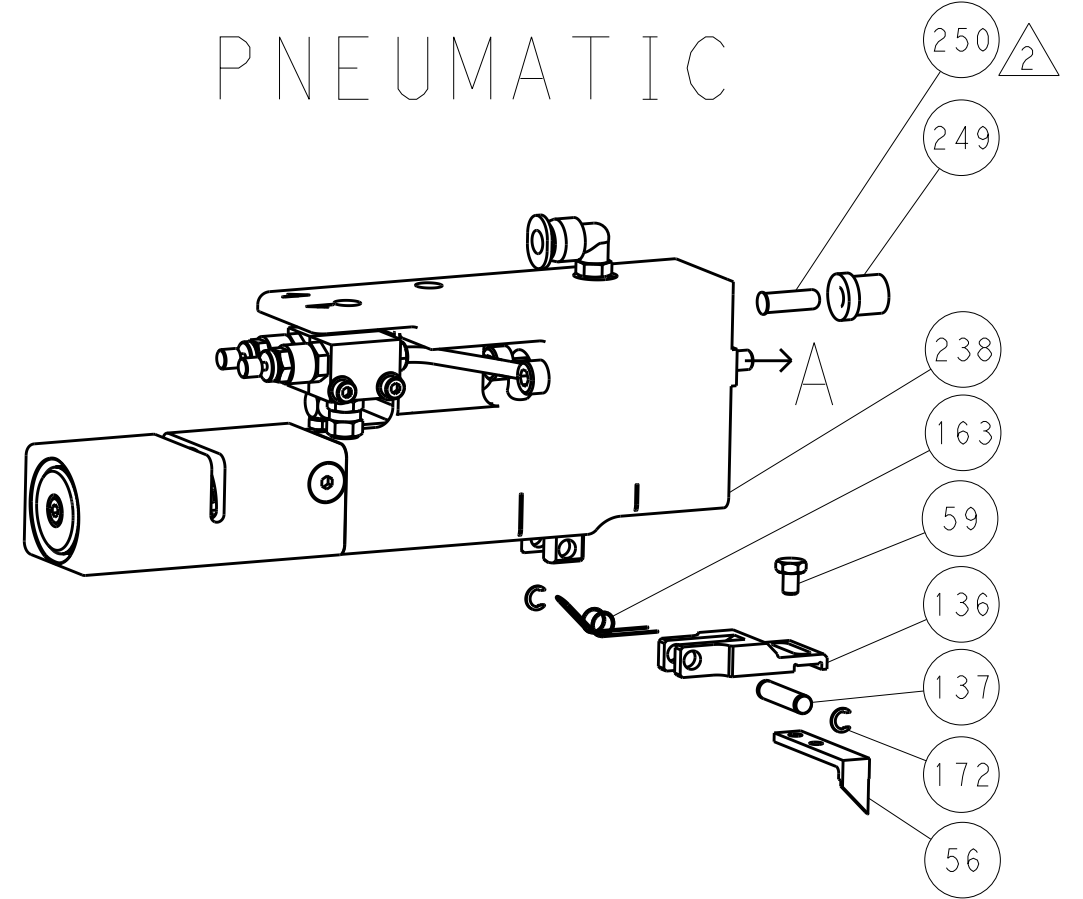
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mm		0 PLC ±.5		CHK: T. ELBIN 21MAR2012		NAME: Ocean Side Feed Applicator	
		1 PLC ±0.5		APVD: M. CLIFFORD 21MAR2012		SIZE: A1	
		2 PLC ±0.13		PRODUCT SPEC:		CAGE CODE: 00779	
		3 PLC ±0.013		APPLICATION SPEC:		DRAWING NO: 2151396	
		4 PLC ±0.001		WEIGHT:		SCALE: 1:2	
		ANGLES ±.0001		CUSTOMER ACCESSIBLE PRODUCTION DRAWING		SHEET 1 OF 4	
MATERIAL:		FINISH:		REVISIONS:		REV C	

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

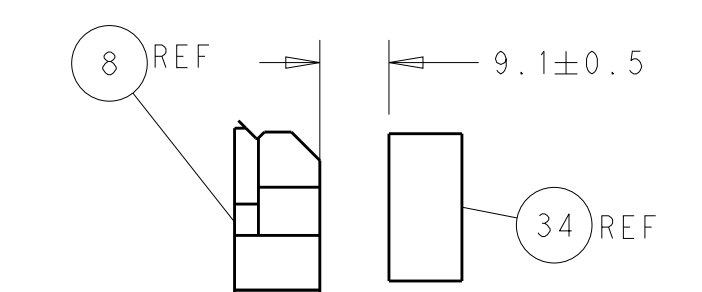
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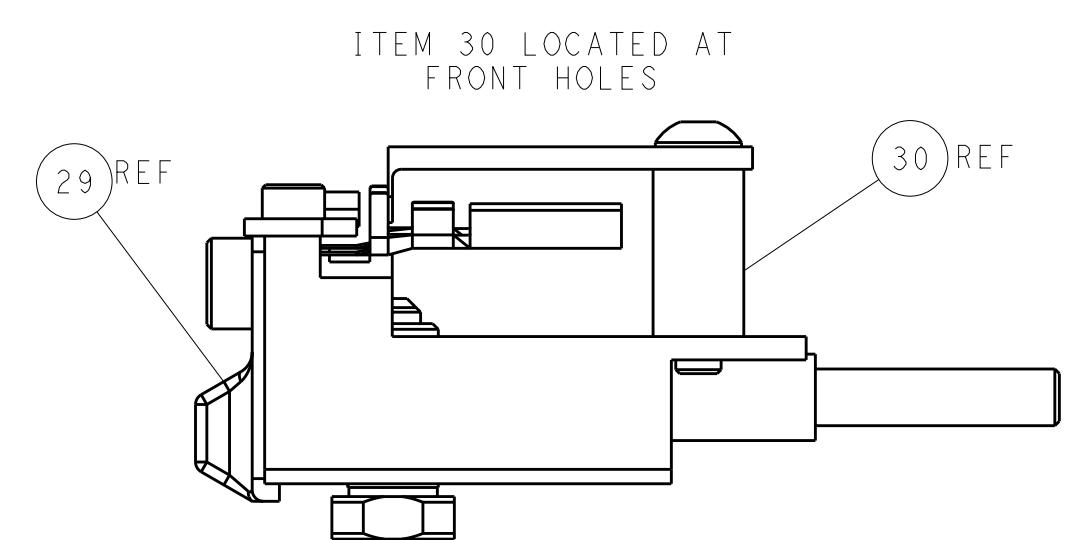
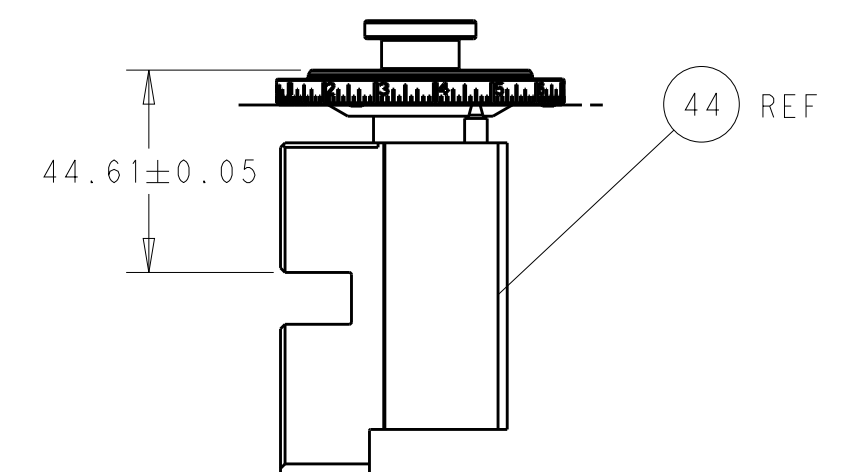
### PNEUMATIC



TERMINAL SUPPORT LOCATION  
FOR TERMINAL 1572905-1

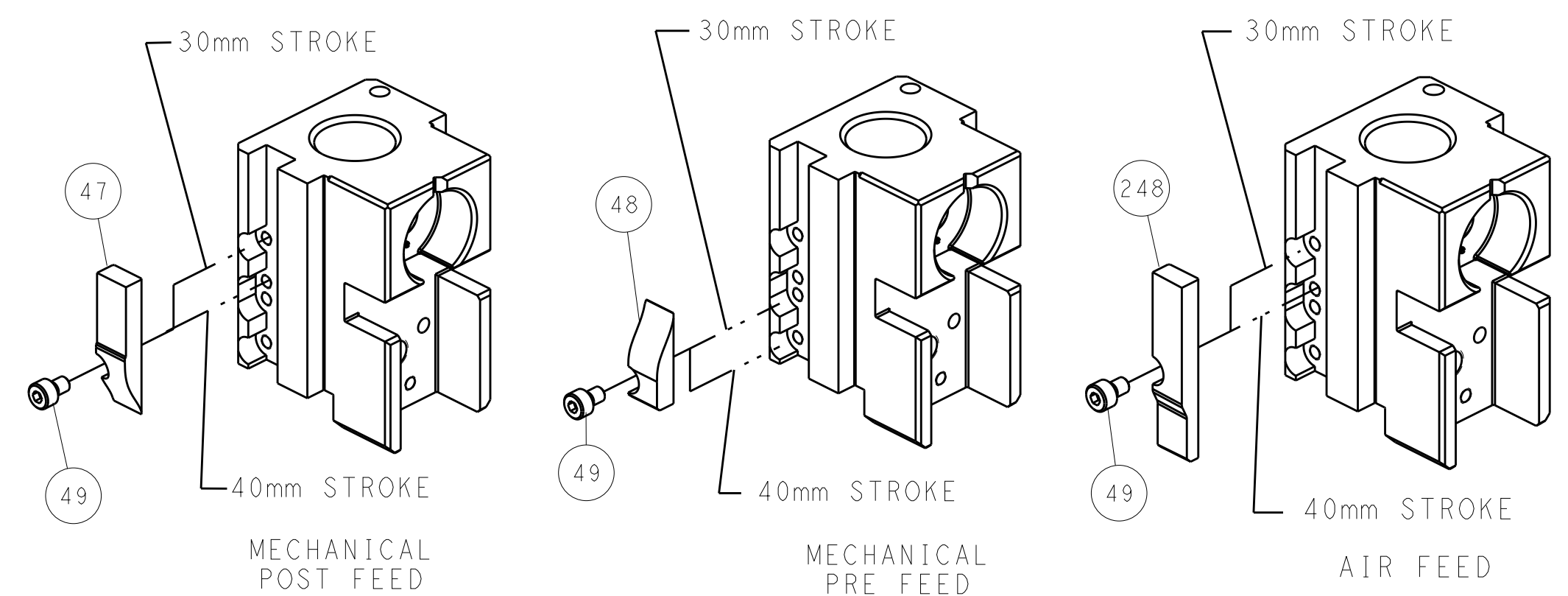


TERMINAL SUPPORT LOCATION  
FOR TERMINAL 286971-1



FEED TRACK POSITION  
GUIDE BY INSULATION BARREL

### CAM POSITIONS

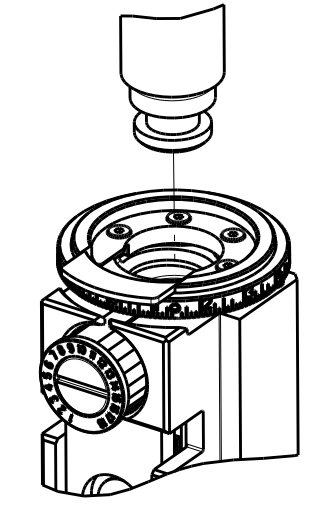


**ATLANTIC VERSION**  
 Shown on sheets 1 of 4 & 2 of 4  
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN BOB HIGMAN 21MAR2012		TE Connectivity	
mm	0 PLC ±0.5	1 PLC ±0.5	2 PLC ±0.13	3 PLC ±0.013	4 PLC ±0.001	APVD T. ELBIN 21MAR2012	Harrisburg, PA 17105-3608
MATERIAL:		FINISH:		NAME Ocean Side Feed Applicator		RESTRICTED TO	
CUSTOMER ACCESSIBLE PRODUCTION DRAWING		SCALE 1:2		SHEET 2 OF 4		REV C	

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2151396-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2151396-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151396-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR  
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.34 mm [.092]	F
INSUL	4.83 mm [.190]	F

APPLICATOR INSTRUCTIONS  
408-35042

TERMINAL DATA: JST TERMINAL		JST CRIMP SPEC	
TERMINAL NAME: VL CONNECTOR			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
5.00-5.50 mm [1.97-.217 IN]		Ø1.90-3.40 mm [0.075-.134 IN]	
TERMINAL APPLICATION SPECIFICATION	HM-0106 Rev R4		
TERMINALS APPLIED			
TE TERMINAL	JST TERMINAL	TE TERMINAL	JST TERMINAL
1572905-1	SVF-61T-P2.0	286971-1	SVM-61T-P2.0

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.75+1.25 (18+16AWG)	1.60+/-0.05 [0.063+/-0.002]	2.5
14 AWG OR 2.00mm2	1.60+/-0.05 [0.063+/-0.002]	2.6
0.5+1.25 (20+16AWG)	1.55+/-0.05 [0.061+/-0.002]	3.1
0.75+0.75 (18+18AWG)	1.50+/-0.05 [0.059+/-0.002]	3.6
0.5+0.75 (20+18AWG)	1.45+/-0.05 [0.057+/-0.002]	4.1
16 AWG OR 1.25mm2	1.45+/-0.05 [0.057+/-0.002]	4.0
0.5+0.5 (20+20AWG)	1.35+/-0.05 [0.053+/-0.002]	5.1
18 AWG OR 0.75mm2	1.25+/-0.05 [0.049+/-0.002]	6.3
20 AWG OR 0.50mm2	1.10+/-0.05 [0.043+/-0.002]	7.9

- ⚠ 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.
  - ⚠ CUT TO LENGTH AT ASSEMBLY.
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.

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

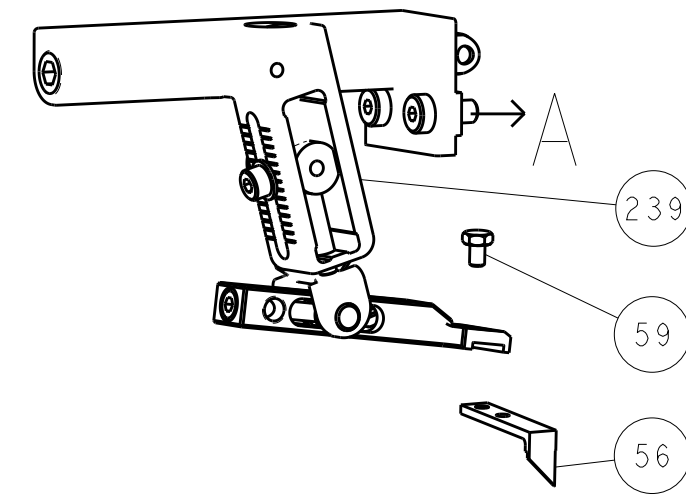
LOC	DIST	REV	DATE	BY	APPV
A	66				

REV	DATE	DESCRIPTION	DATE	BY	APPV
-	1	1	455888-1	SPACER, CRIMPER	263
-	1	-	2119640-1	PUSH ROD, AIR FEED	250
-	1	-	1803259-1	BUSHING, FLANGED	249
-	1	1	2119082-9	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	18023-1	SCR, SKT HD CAP M3 X 5.0	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	1-18028-2	WASHER, FLAT, REG M4	119
-	1	1	2844908-1	SCREW, LOCKING	99
-	1	1	2844907-1	POST, LOCKING	98
-	1	1	455888-1	SPACER, CRIMPER	82
-	1	1	1803607-1	DOCUMENTATION PACKAGE	71
-	1	1	2119791-9	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
-	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	1	1	1338685-1	PAWL, FEED	56
-	2	2	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	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	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	2-2844962-8	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29
-	1	1	1-455888-0	SPACER, CRIMPER	28
-	1	1	1320928-2	STRIP GUIDE	24
-	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	2119806-1	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	1803095-1	FLOATING SHEAR, FRONT	9
-	-	-	1-1633927-0	ANVIL, COMBINATION	8
-	-	-	-	-	6
-	1	1	2119757-8	DEPRESSOR, SHEAR	5
-	1	1	1-238011-7	BLOCK, CRIMPER SPACER	4
-	1	1	3-1633961-1	CRIMPER, INSULATION F PREMIUM	3
-	1	1	455888-4	SPACER, CRIMPER	2
-	1	1	1673600-2	CRIMPER, WIRE	1

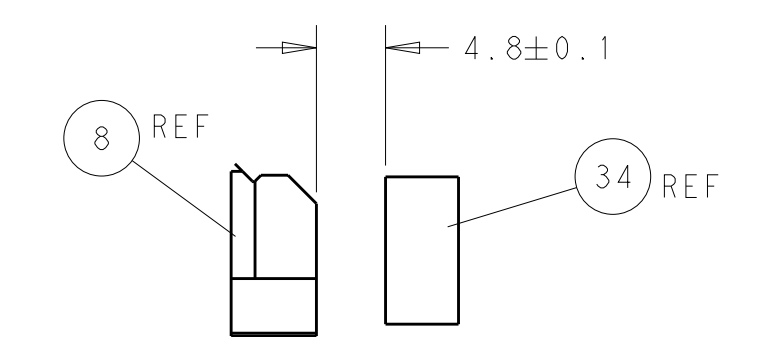
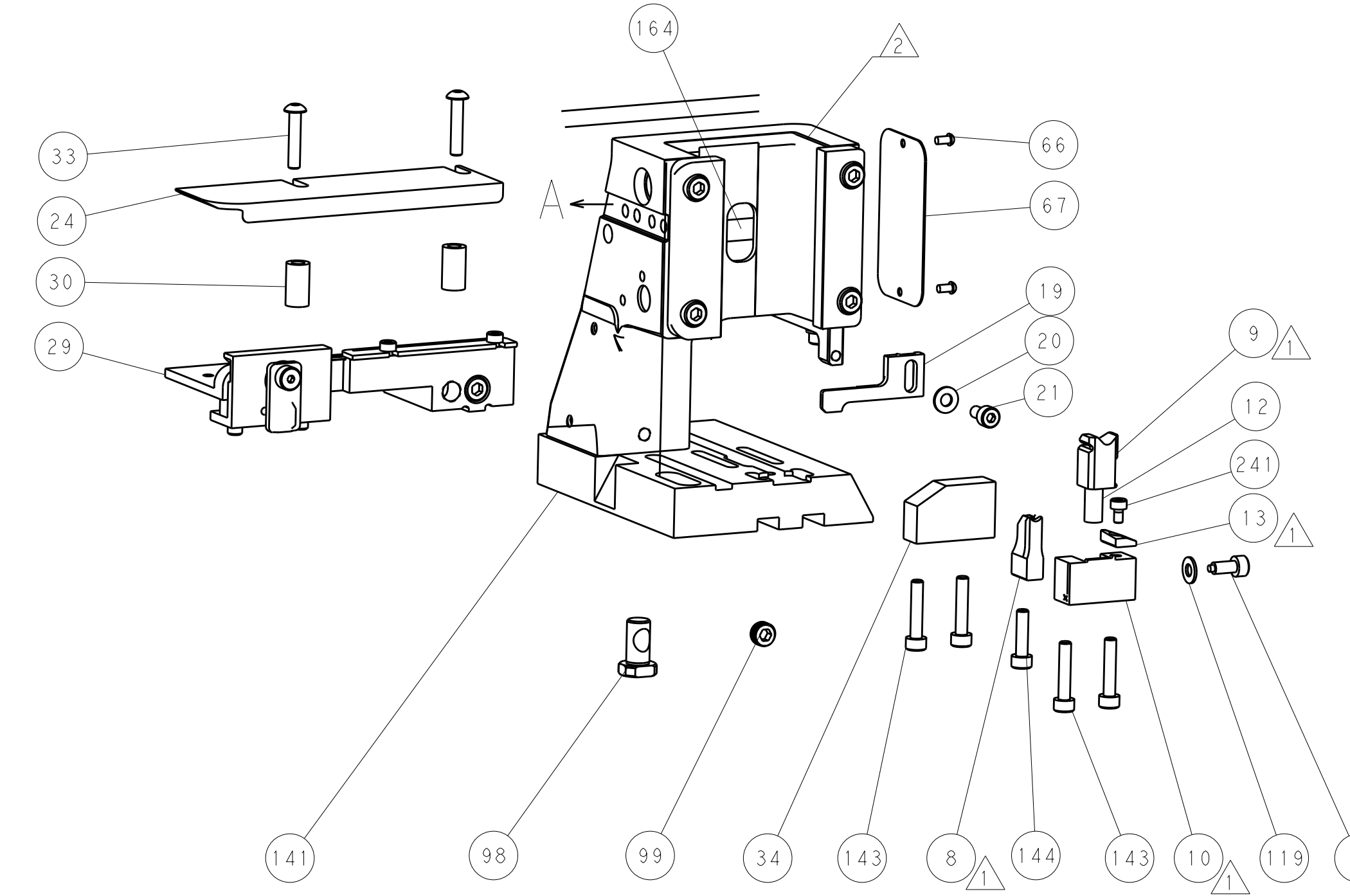
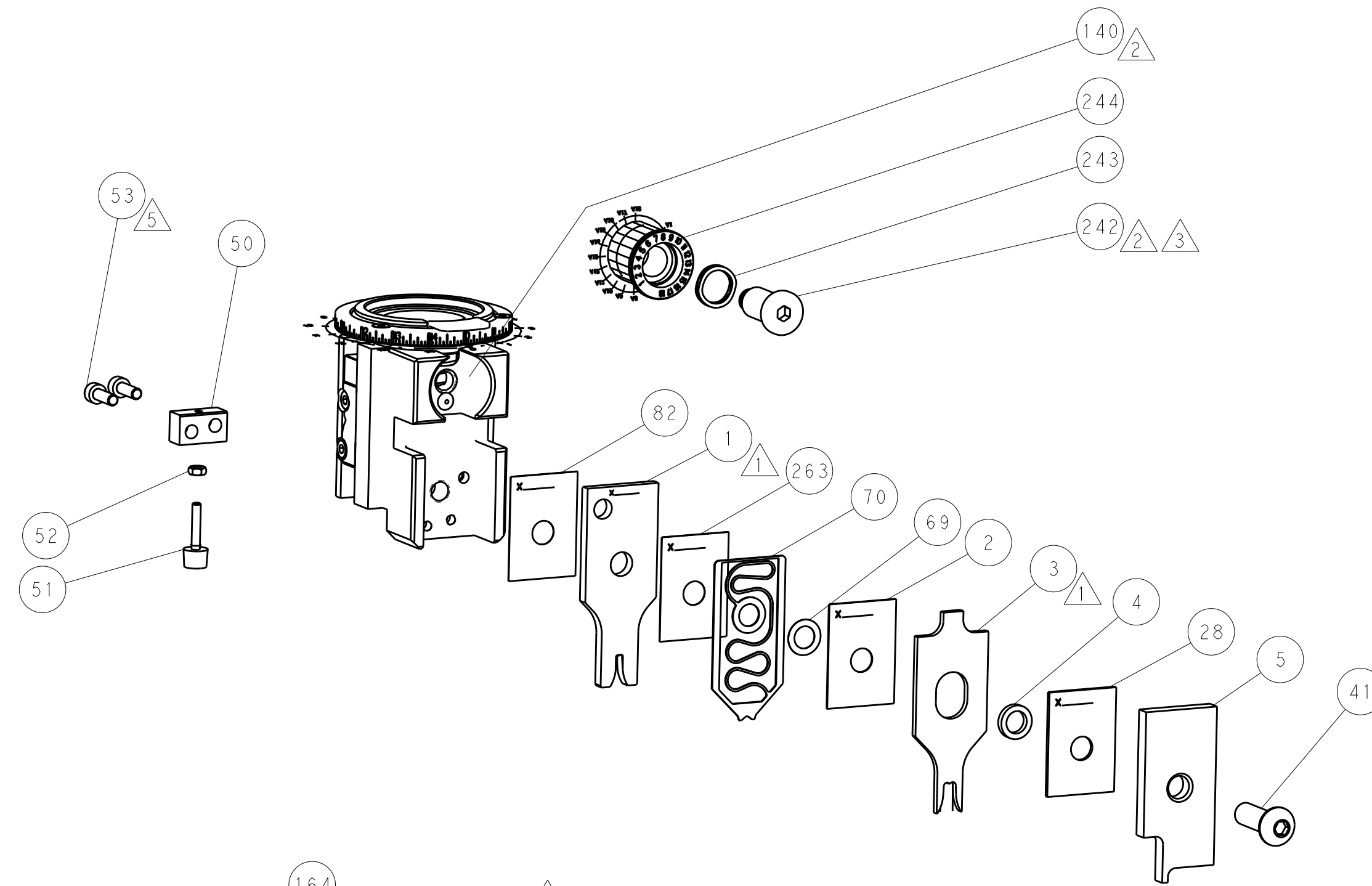
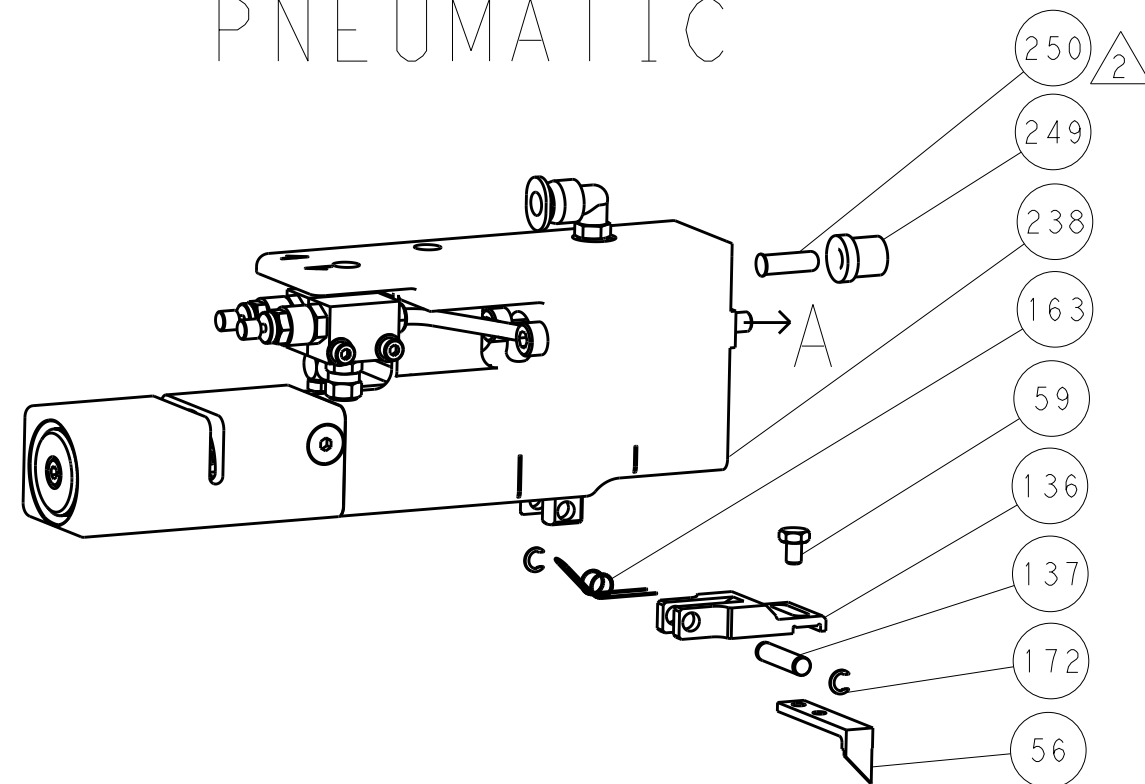
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG: BOB HIGMAN 21MAR2012		TE Connectivity Harrisburg, PA 17105-3608	
mm	0 PLC ±.5 1 PLC ±0.5 2 PLC ±0.13 3 PLC ±0.013 4 PLC ±0.001	mm	ANGLES ±.1	CHK: T. ELBIN 21MAR2012	NAME: Ocean Side Feed Applicator		
MATERIAL:		FINISH:		APV: M. CLIFFORD 21MAR2012	SIZE: A1 00779 C=2151396		
CUSTOMER ACCESSIBLE PRODUCTION DRAWING				SCALE: 1:2	SHEET: 3 OF 4	REV: C	

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

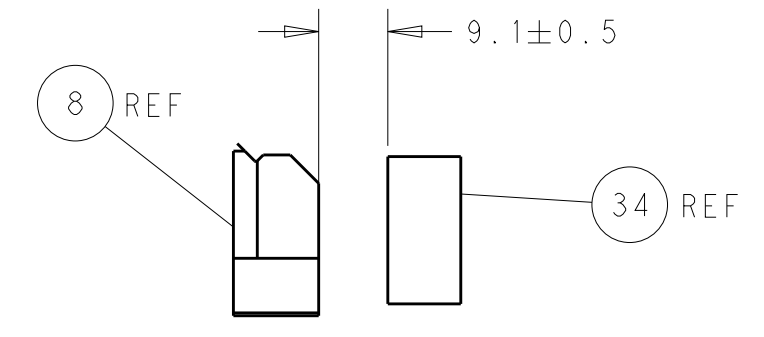
# FEED TYPE MECHANICAL



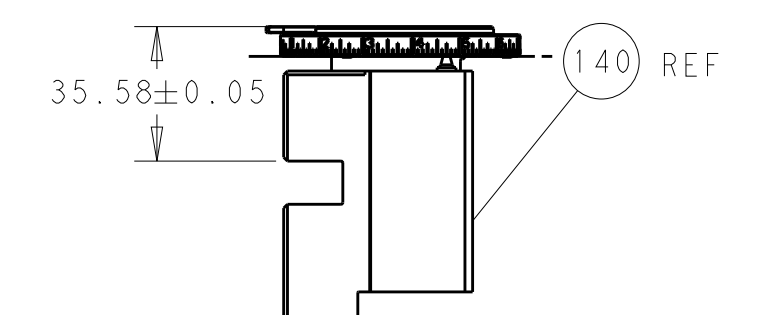
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TERMINAL SUPPORT LOCATION  
FOR TERMINAL 1572905-1

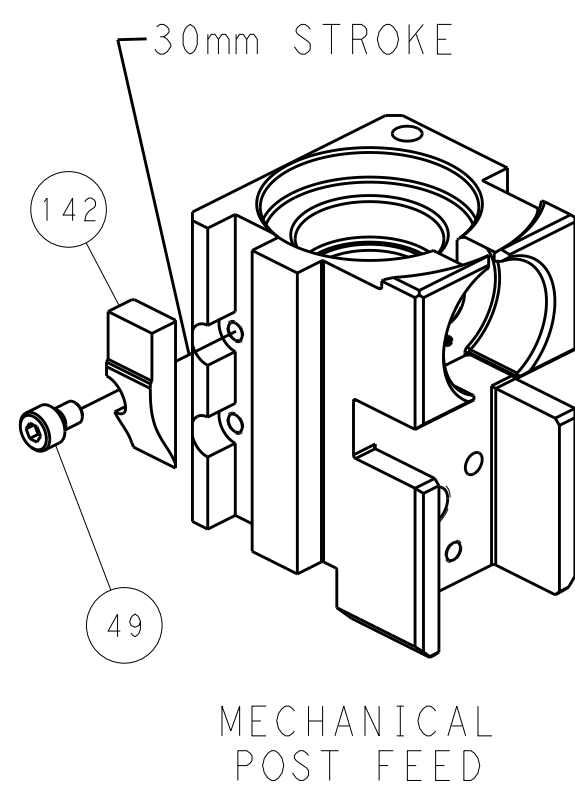


TERMINAL SUPPORT LOCATION  
FOR TERMINAL 286971-1

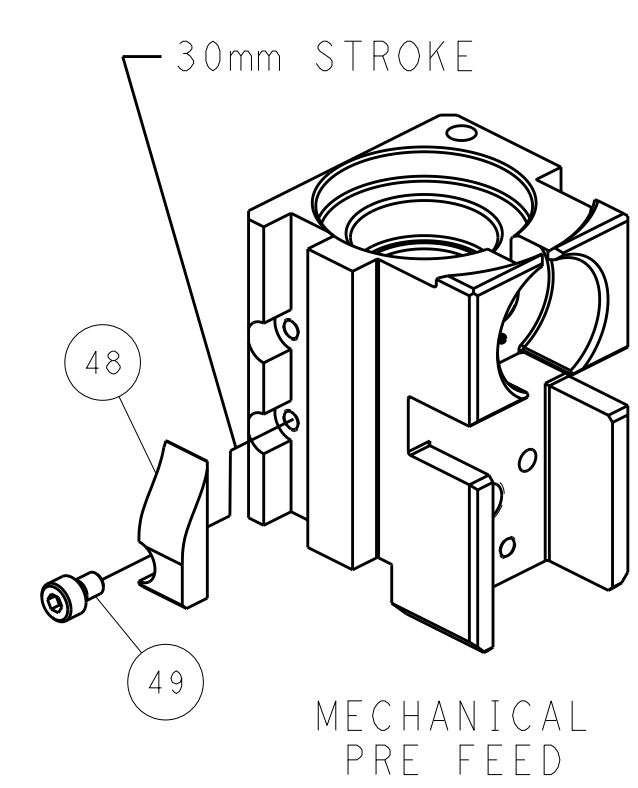


RAM SET-UP

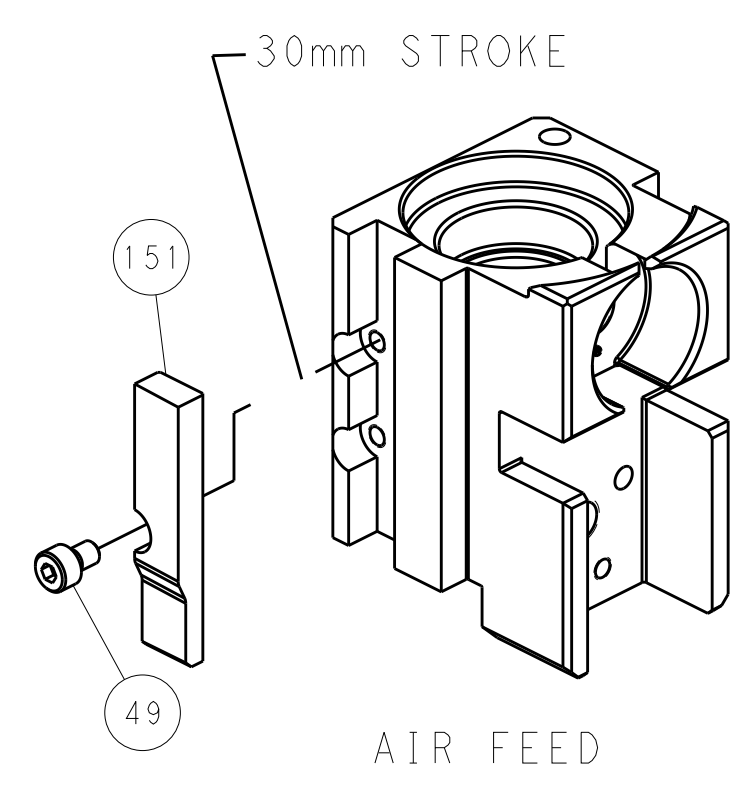
# CAM POSITIONS



MECHANICAL  
POST FEED

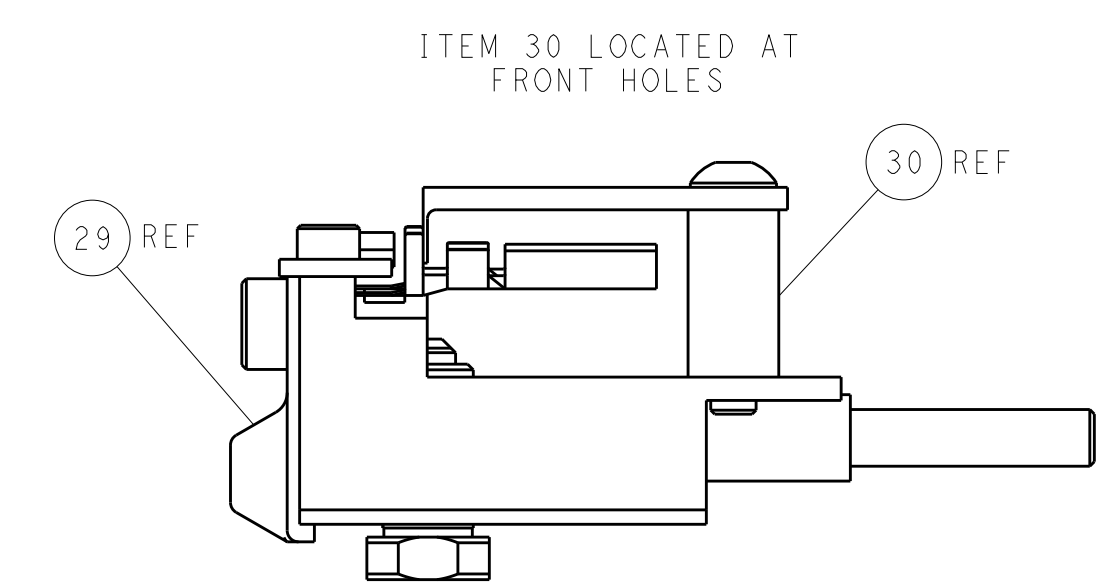


MECHANICAL  
PRE FEED



AIR FEED

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



FEED TRACK POSITION  
GUIDE BY INSULATION BARREL

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DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.5 1 PLC ±0.5 2 PLC ±0.13 3 PLC ±0.013 4 PLC ±0.001 ANGLES ±.1	PRODUCT SPEC: APPLICATION SPEC: WEIGHT: MATERIAL:	NAME: Ocean Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2151396 SCALE: 1:2 SHEET: 4 of 4 REV: C	RESTRICTED TO: