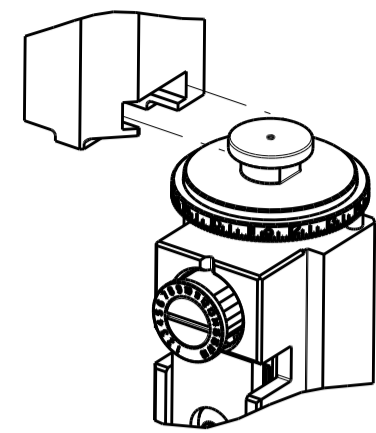


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151540-1	M	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2151540-2	M	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
3-2151540-2	M	FINE CRIMP HEIGHT ADJUST	DOUBLE ACTING PNEUMATIC WITH SENSORS Δ
7-2151540-1	M	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2151540-2	M	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2151540-7	J	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.40 mm [.055]	F
INSUL	1.78 mm [.070]	O

APPLICATOR INSTRUCTIONS 408-35042

TERMINAL DATA: SIEMENS TERMINAL TE CRIMP SPECIFICATION
 TERMINAL NAME: FEMALE TERMINAL

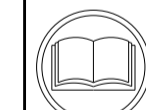
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE
4.10-4.70 mm [.161-.185 IN]	\varnothing 1.10-1.40 mm [.043-.055 IN]

TERMINAL APPLICATION SPECIFICATION 114-13060

TERMINALS APPLIED Δ

TE TERMINAL	SIEMENS TERMINAL	TE TERMINAL	SIEMENS TERMINAL
1393364-1	V23540X7000Y10	1-1438299-0	
1393367-1	V23540X7000Y11	1393364-2	
1438299-2	V23540X7000Y31	1393367-2	
1438299-1	V23540X7000Y30		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING Δ
0.35mm2	0.97 +/- 0.04 [.038 +/- .002]	7.7
22 AWG	0.95 +/- 0.04 [.037 +/- .002]	7.9
0.22mm2	0.89 +/- 0.04 [.035 +/- .002]	8.7



- Δ 1 RECOMMENDED SPARE PARTS
- Δ 2 REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- Δ 3 APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242.
- Δ 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.
- Δ 5 THIS APPLICATOR IS EQUIPPED WITH THE DOUBLE ACTING FEED WITH SENSORS AND IS APPLICATION SPECIFIC AND DOES NOT REQUIRE ITEMS 49 & 248.
- 6. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- Δ 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.

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

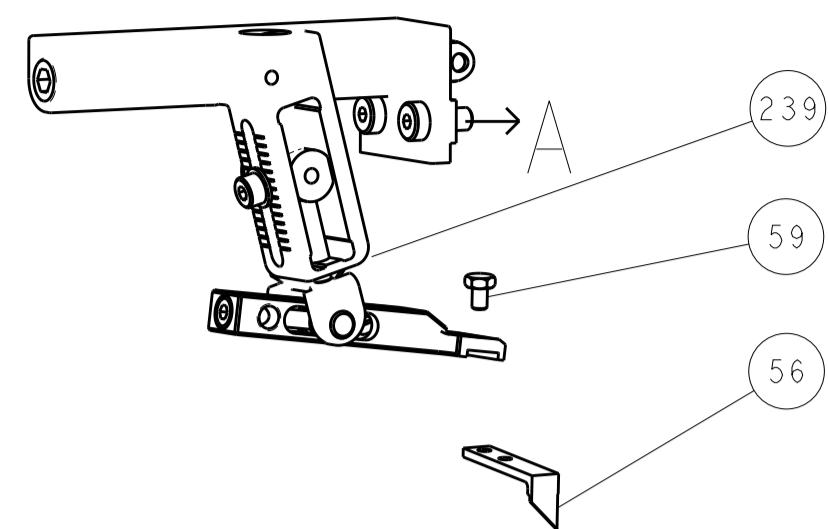
LOC	DIST	REVISIONS					
A	66	P	LTN	DESCRIPTION	DATE	OWN	APVD
		J		ECR-18-018200	27NOV2018	RK	CT
		K		ECR-19-000253	08JAN2019	MZ	YY
		L		ECR-19-006162	16APR2019	LG	TE
		M		ECR-20-005952	24APR2020	MZ	YY

-	-	-	1	-	-	2844950-1	AIR FEED MODULE	290
-	1	1	1	1	1	2119791-5	DEPRESSOR, WIRE	286
-	1	1	1	1	1	1633782-2	FENCE	267
-	1	-	-	1	-	2119641-1	FEED CAM, AIR FEED	248
-	1	1	1	1	1	2119082-8	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	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	-	2844940-1	AIR FEED MODULE	238
-	REF	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	1	1	1	1	1	1-22281-8	SPRING, COMPRESSION	121
-	1	1	1	1	1	1-18028-2	WASHER, FLAT, REG M4	119
-	1	1	1	1	1	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113
-	1	1	1	1	1	2844908-1	SCREW, LOCKING	99
-	1	1	1	1	1	2844907-1	POST, LOCKING	98
-	1	1	1	1	1	2168083-6	SCR, SKT HD CAP, RoHS, M5 X 6.5	93
-	1	1	1	1	1	455888-4	SPACER, CRIMPER	82
-	1	1	1	1	1	1803607-3	DOCUMENTATION PACKAGE	71
-	4	4	4	4	4	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	69
-	1	1	1	1	1	2-690438-2	FRONT STRIP GUIDE	68
-	1	1	1	1	1	2119740-1	TAG, IDENTIFICATION	67
-	2	2	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	2	2	2	2	2	2-18032-5	SCR, SET, FLT PNT, M5 X 20.0	61
-	1	1	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	60
-	1	1	1	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	1	1	1	1	1	1338685-1	PAWL, FEED	56
-	4	4	4	4	4	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	54
-	2	2	2	2	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	53
-	1	1	1	1	1	1803382-1	HOLD DOWN, SPRING LOADED	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	1	1803583-9	APPLICATOR BASIC ASSEMBLY, SF	46
-	1	1	1	1	1	1803515-1	RAM ASSEMBLY, SF ATLANTIC	44
-	1	1	1	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
-	1	1	1	1	1	1-1752356-8	SUPPORT, TERMINAL	34
-	2	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	2	2	2	2-2844962-6	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	1	1	1	2844938-5	PLATE, STRIP GUIDE	29
-	2	2	2	2	2	22281-8	SPRING, COMPRESSION	27
-	1	1	1	1	1	356835-1	LEVER, DRAG RELEASE	26
-	1	1	1	1	1	240792-2	DRAG, TERMINAL	25
-	1	1	1	1	1	1320928-6	STRIP GUIDE	24
-	1	1	1	1	1	980371-4	SCR, SKT HD SHLDR 5.0 DIA X 6.0	23
-	1	1	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
-	1	1	1	1	1	1-18028-2	WASHER, FLAT, REG M4	20
-	1	1	1	1	1	2119533-1	STRIPPER, SIDE FEED	19
-	1	1	1	1	1	2119806-1	INSERT, SHEAR	13
-	1	1	1	1	1	3-22280-3	SPRING, COMPRESSION	12
-	1	1	1	1	1	1-356885-4	STOP, SHEAR	11
-	1	1	1	1	1	2119805-1	SHEAR HOLDER, FRONT	10
-	1	1	1	1	1	1-318707-4	FLOATING SHEAR, FRONT	9
-	1	2	2	1	1	1-1333201-9	ANVIL, COMBINATION	8
-	-	-	-	-	-	-	-	7
-	-	-	-	-	-	-	-	6
-	1	1	1	1	1	2119757-2	DEPRESSOR, SHEAR	5
-	1	1	1	1	1	2-238011-2	BLOCK, CRIMPER SPACER	4
-	1	2	2	1	1	3-1633966-0	CRIMPER, INSULATION O	3
-	1	1	1	1	1	455888-7	SPACER, CRIMPER	2
-	1	2	2	1	1	3-1803224-5	CRIMPER, WIRE	1

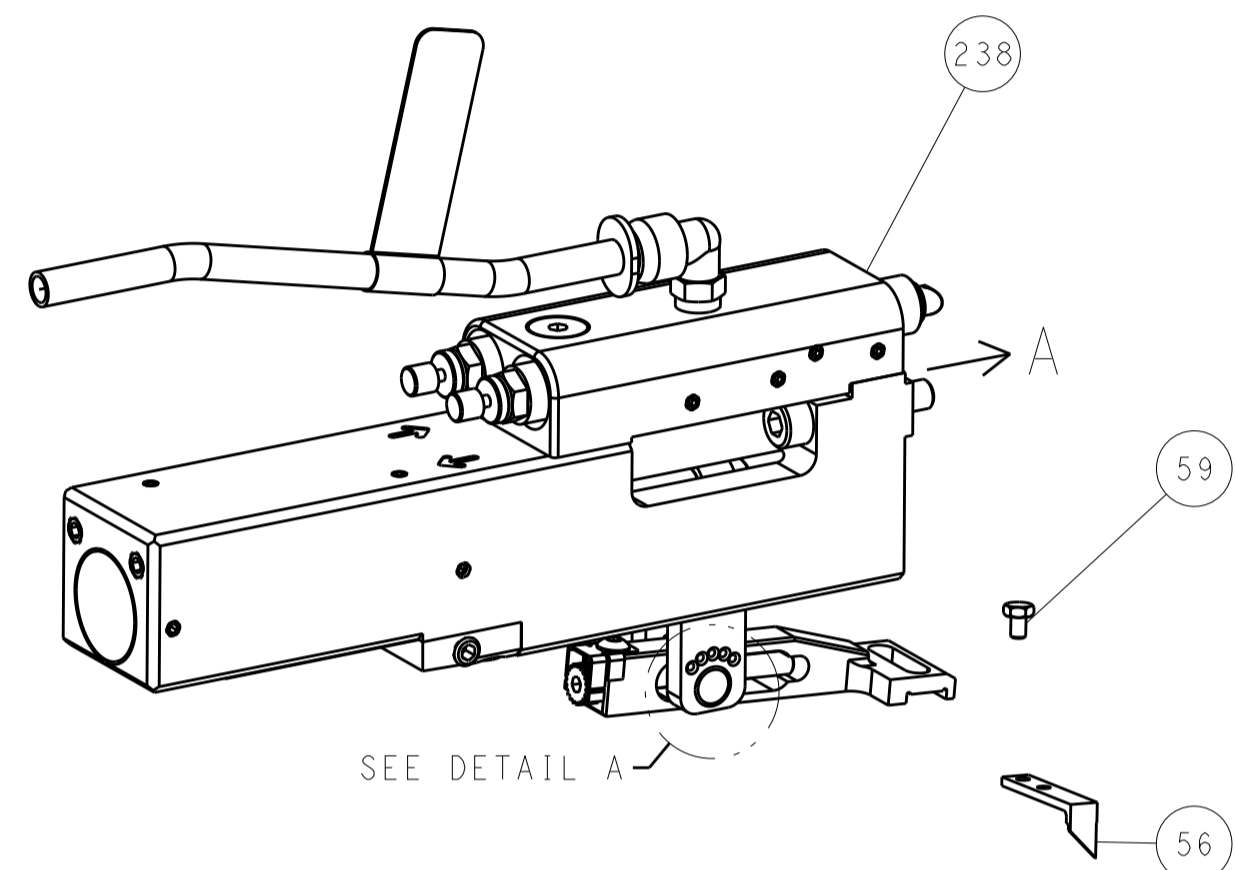
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DATE	CHK	APVD	NAME
mm	0 PLC ±	1 PLC ±	2 PLC ±	14NOV2011	STAKEM	T. ERLIN	Ocean Side Feed Applicator
	3 PLC ±	4 PLC ±	ANGLES ±	14NOV2011	G. BAILEY		
MATERIAL	FINISH	WEIGHT	SCALE	CUSTOMER ACCESSIBLE PRODUCTION DRAWING		SHEET 1 OF 4	

LOC		DIST		REVISIONS			
A	66	P	LTM	DESCRIPTION	DATE	DMN	APVD
		-		SEE SHEET 1			

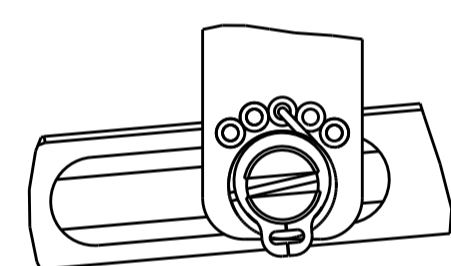
FEED TYPE MECHANICAL



PNEUMATIC

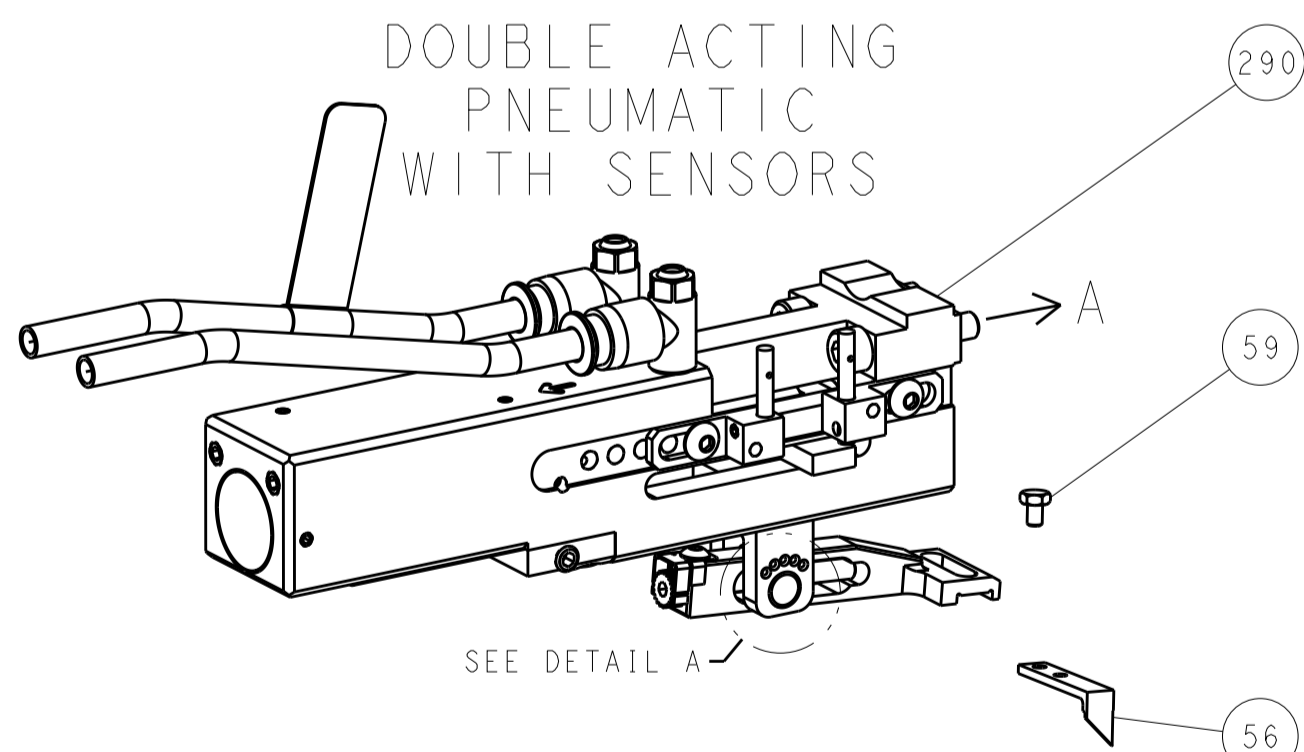


FEED SPRING SETTING POSITION
(SHOWN FROM REAR SIDE)

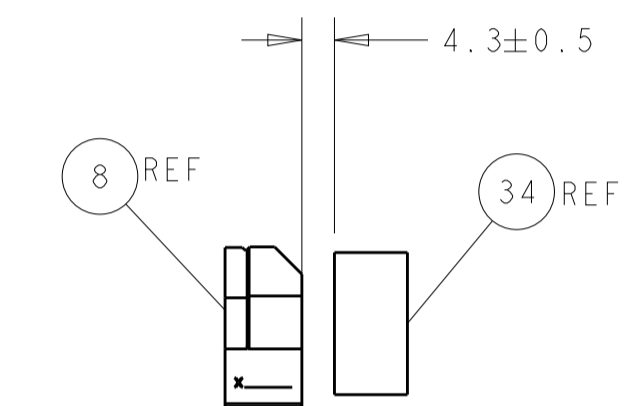
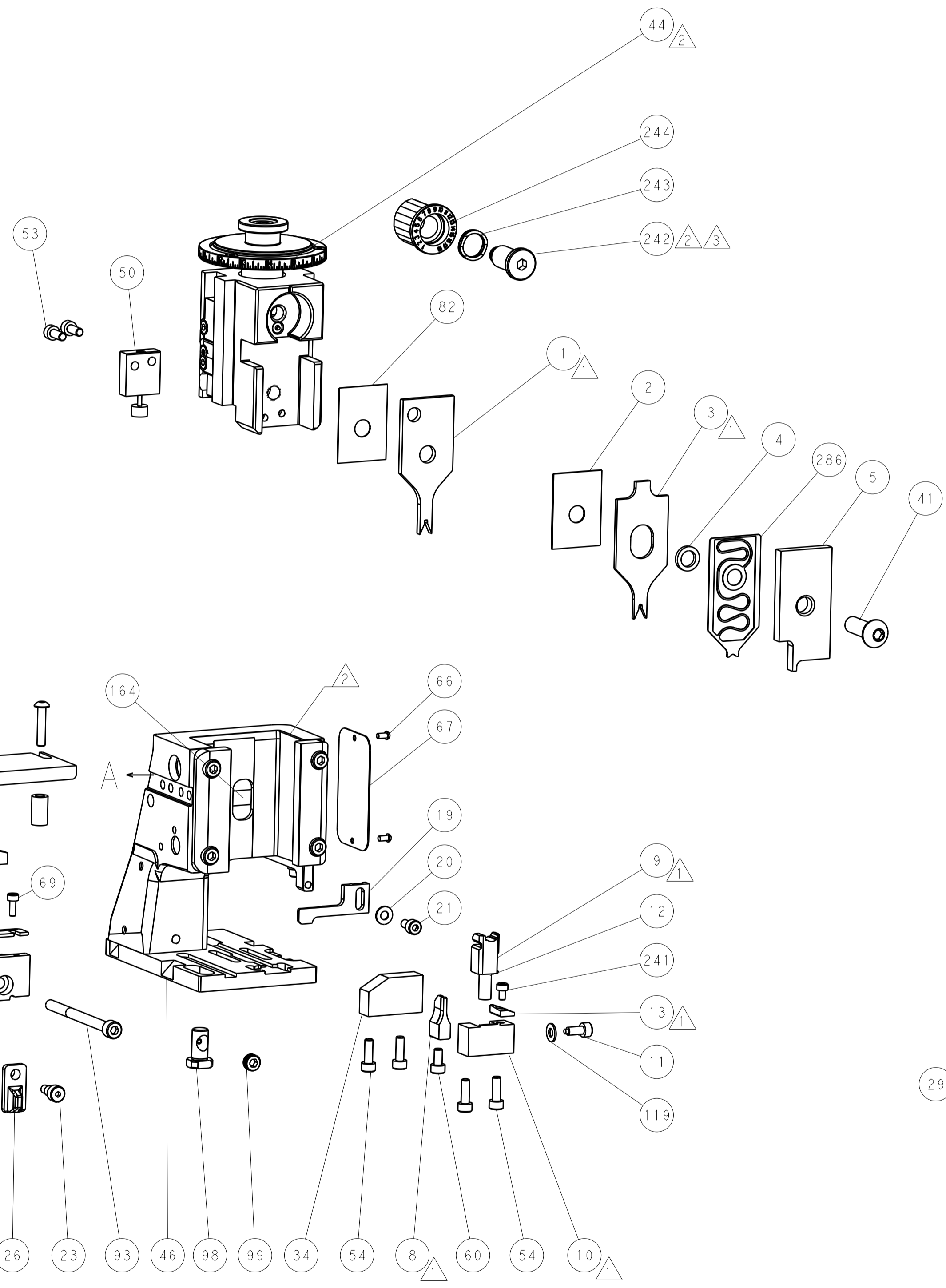
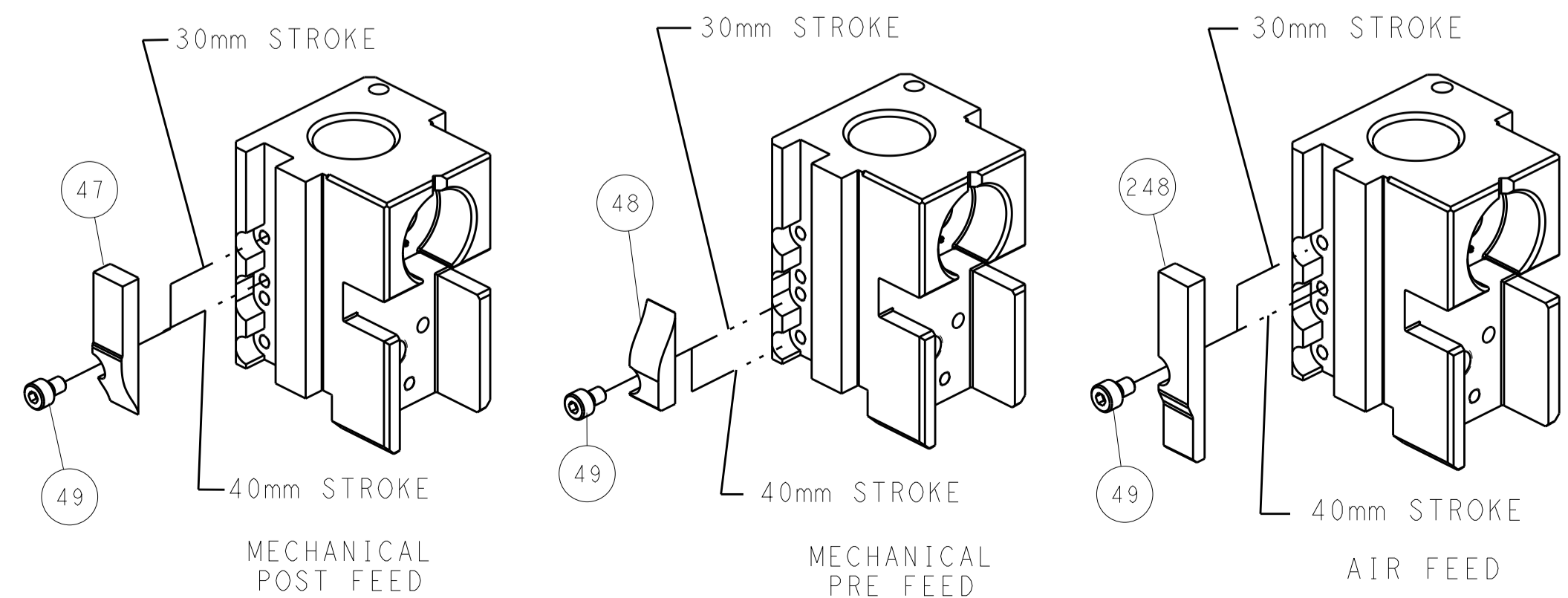


DETAIL A

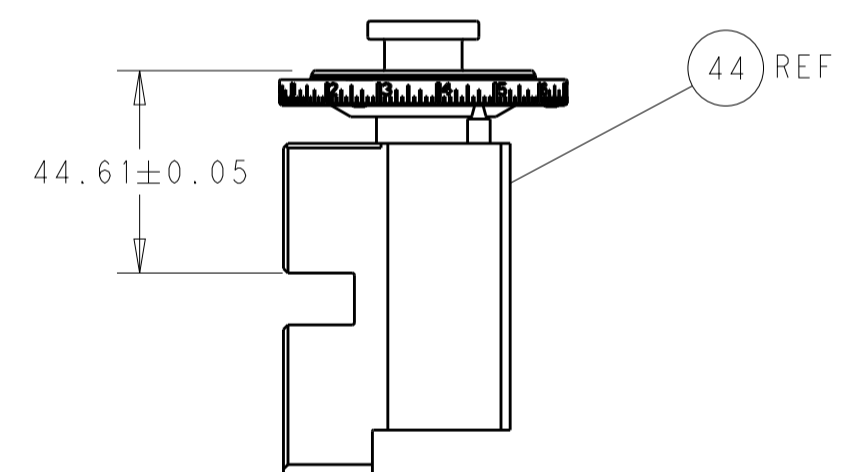
DOUBLE ACTING PNEUMATIC WITH SENSORS



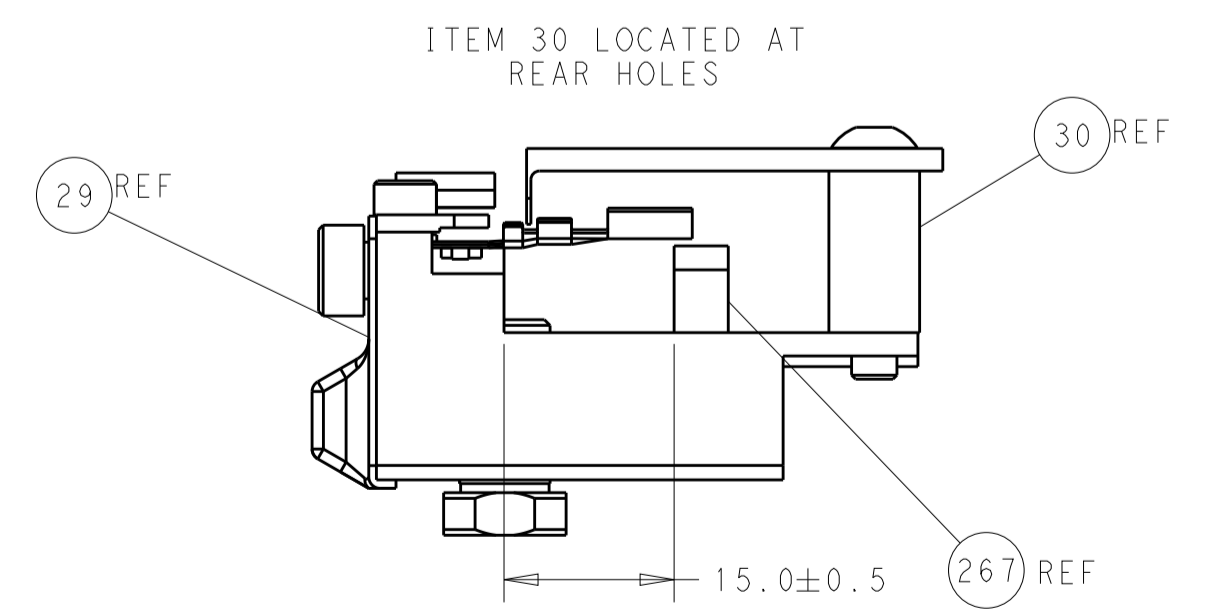
CAM POSITIONS



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)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG: R. STAKEM 14NOV2011		TE Connectivity	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	APVD: T. ELBIN 14NOV2011	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 M	

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2151540-1	M	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2151540-2	M	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
4-2151540-2	M	FINE CRIMP HEIGHT ADJUST	DOUBLE ACTING PNEUMATIC WITH SENSORS
7-2151540-7	J	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.40 mm [.055]	F
INSUL	1.78 mm [.070]	O

APPLICATOR INSTRUCTIONS
408-35042

TERMINAL DATA: SIEMENS TERMINAL TE CRIMP SPECIFICATION			
TERMINAL NAME: FEMALE TERMINAL			
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE	TERMINAL APPLICATION SPECIFICATION	TERMINALS APPLIED
4.10-4.70 mm [1.61-.185 IN]	Ø1.10-1.40 mm [.043-.055 IN]	114-13060	
TE TERMINAL	SIEMENS TERMINAL	TE TERMINAL	SIEMENS TERMINAL
1393364-1	V23540X7000Y10	1-1438299-0	
1393367-1	V23540X7000Y11	1393364-2	
1438299-2	V23540X7000Y31	1393367-2	
1438299-1	V23540X7000Y30		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.35mm ²	0.97+/-0.04 [.038+/-0.002]	7.7
22 AWG	0.95+/-0.04 [.037+/-0.002]	7.9
0.22mm ²	0.89+/-0.04 [.035+/-0.002]	8.7

- 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 THIS APPLICATOR IS EQUIPPED WITH THE DOUBLE ACTING FEED WITH SENSORS AND IS APPLICATION SPECIFIC AND DOES NOT REQUIRE ITEMS 49 & 248.
- 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	REV	DATE	BY	APPV
A	66				

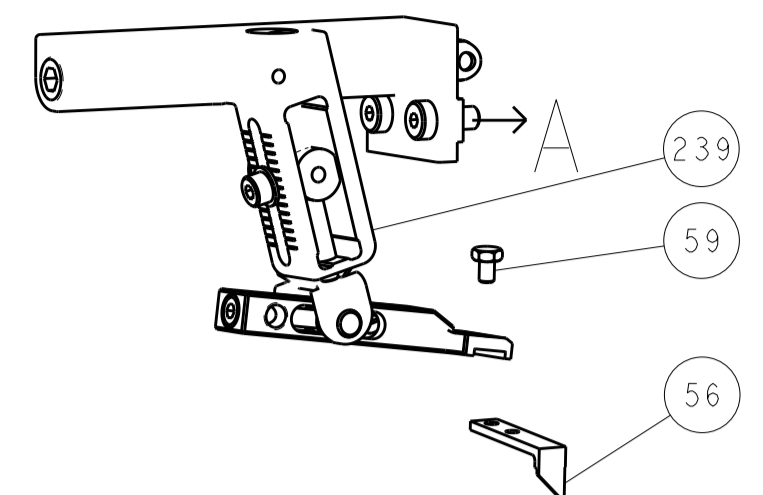
REV	DATE	BY	APPV	DESCRIPTION	ITEM NO
-	-	-	-	2844950-1 AIR FEED MODULE	290
-	-	-	-	2119791-5 DEPRESSOR, WIRE	286
-	-	-	-	1633782-2 FENCE	267
-	-	-	-	2119082-8 CAM, SNAIL, INSULATION ADJUSTMENT	244
-	-	-	-	2079764-1 WASHER, WAVE SPRING, CREST-TO-CREST	243
-	-	-	-	2119083-1 RETAINER, INSULATION DIAL	242
-	-	-	-	18023-1 SCR, SKT HD CAP M3 X 5.0	241
-	-	-	-	2119580-1 MECHANICAL FEED ASSEMBLY	239
-	-	-	-	2844940-1 AIR FEED MODULE	238
-	-	-	-	994970-2 COUNTER, MAGNETIC	164
-	-	-	-	2119641-2 FEED CAM, AIR FEED	151
-	-	-	-	2168083-8 SCR, SKT HD CAP, RoHS, M4 X 16	144
-	-	-	-	2168083-9 SCR, SKT HD CAP, RoHS, M4 X 20	143
-	-	-	-	2119653-2 FEED CAM, POST FEED	142
-	-	-	-	1-1803583-0 APPLICATOR BASIC ASSEMBLY, SF	141
-	-	-	-	1803516-1 RAM ASSEMBLY, SF PACIFIC	140
-	-	-	-	1-22281-8 SPRING, COMPRESSION	121
-	-	-	-	1-18028-2 WASHER, FLAT, REG M4	119
-	-	-	-	2119955-1 ASSY, LUBRICATOR, SIDE FEED	113
-	-	-	-	2844908-1 SCREW, LOCKING	99
-	-	-	-	2844907-1 POST, LOCKING	98
-	-	-	-	2168083-6 SCR, SKT HD CAP, RoHS, M5 X 65	93
-	-	-	-	455888-4 SPACER, CRIMPER	82
-	-	-	-	1803607-3 DOCUMENTATION PACKAGE	71
-	-	-	-	2168083-1 SCR, SKT HD CAP, RoHS, M3 X 8.0	69
-	-	-	-	2-690438-2 FRONT STRIP GUIDE	68
-	-	-	-	2119740-1 TAG IDENTIFICATION	67
-	-	-	-	2168078-1 SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	-	-	-	2-18032-5 SCR, SET, FLT PNT, M5 X 20.0	61
-	-	-	-	5-18022-5 SCR, HEX HD CAP, M4 X 6.0	59
-	-	-	-	1338685-1 PAWL, FEED	56
-	-	-	-	1-2168083-0 SCR, SKT HD CAP, RoHS, M4 X 10	53
-	-	-	-	1803382-1 HOLD DOWN, SPRING LOADED	50
-	-	-	-	18023-9 SCR, SKT HD CAP M4 X 6.0	49
-	-	-	-	2119652-1 FEED CAM, PRE FEED	48
-	-	-	-	1803602-1 SCR, BHSC, RoHS (M8 X 25)	41
-	-	-	-	1-1752356-8 SUPPORT, TERMINAL	34
-	-	-	-	2079383-5 SCR, BHSC, RoHS (M4 X 20)	33
-	-	-	-	2-2844962-6 SPACER, CYLINDRICAL, STRIP GUIDE	30
-	-	-	-	2844938-5 PLATE, STRIP GUIDE	29
-	-	-	-	22281-8 SPRING, COMPRESSION	27
-	-	-	-	356835-1 LEVER, DRAG RELEASE	26
-	-	-	-	240792-2 DRAG, TERMINAL	25
-	-	-	-	1320928-6 STRIP GUIDE	24
-	-	-	-	980371-4 SCR, SKT HD SHLDR 5.0 DIA X 6.0	23
-	-	-	-	2168083-2 SCR, SKT HD CAP, RoHS, M4 X 8.0	21
-	-	-	-	1-18028-2 WASHER, FLAT, REG M4	20
-	-	-	-	2119533-1 STRIPPER, SIDE FEED	19
-	-	-	-	2119806-1 INSERT, SHEAR	13
-	-	-	-	3-22280-3 SPRING, COMPRESSION	12
-	-	-	-	1-356885-4 STOP, SHEAR	11
-	-	-	-	2119805-1 SHEAR HOLDER, FRONT	10
-	-	-	-	1-318707-4 FLOATING SHEAR, FRONT	9
-	-	-	-	1-1333201-9 ANVIL, COMBINATION	8
-	-	-	-	-	7
-	-	-	-	-	6
-	-	-	-	2119757-2 DEPRESSOR, SHEAR	5
-	-	-	-	2-238011-2 BLOCK, CRIMPER SPACER	4
-	-	-	-	3-1633966-0 CRIMPER, INSULATION O	3
-	-	-	-	455888-7 SPACER, CRIMPER	2
-	-	-	-	3-1803224-5 CRIMPER, WIRE	1

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

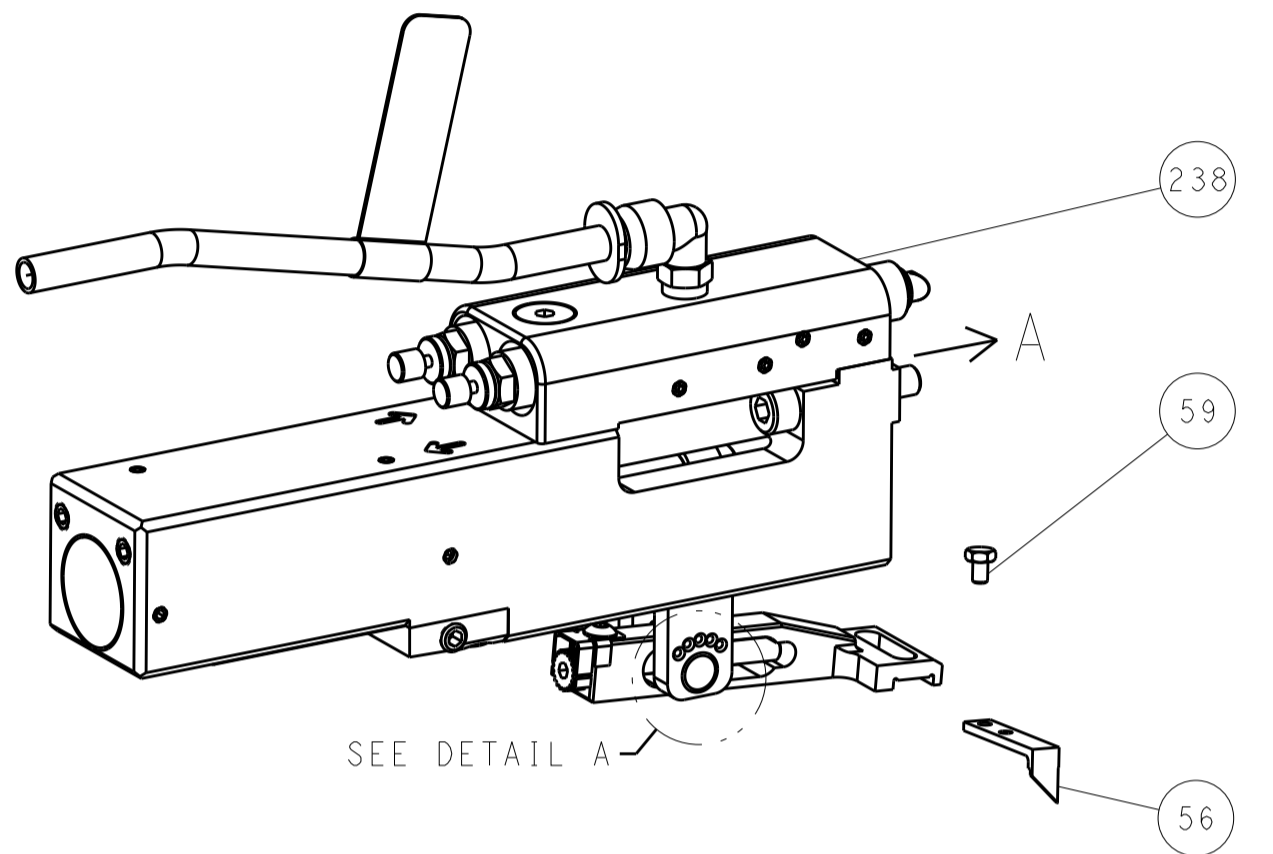
DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH		DWG: STAKEM 14NOV2011 CHK: G. BAILEY 14NOV2011 APPV: T. ERLIN 14NOV2011		NAME: Ocean Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2151540 SCALE: 1:2 SHEET: 3 OF 4 REV: M	
MATERIAL:				CUSTOMER ACCESSIBLE PRODUCTION DRAWING			

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

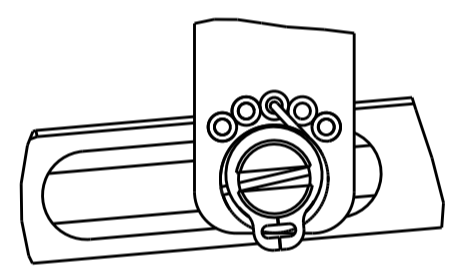
FEED TYPE MECHANICAL



PNEUMATIC

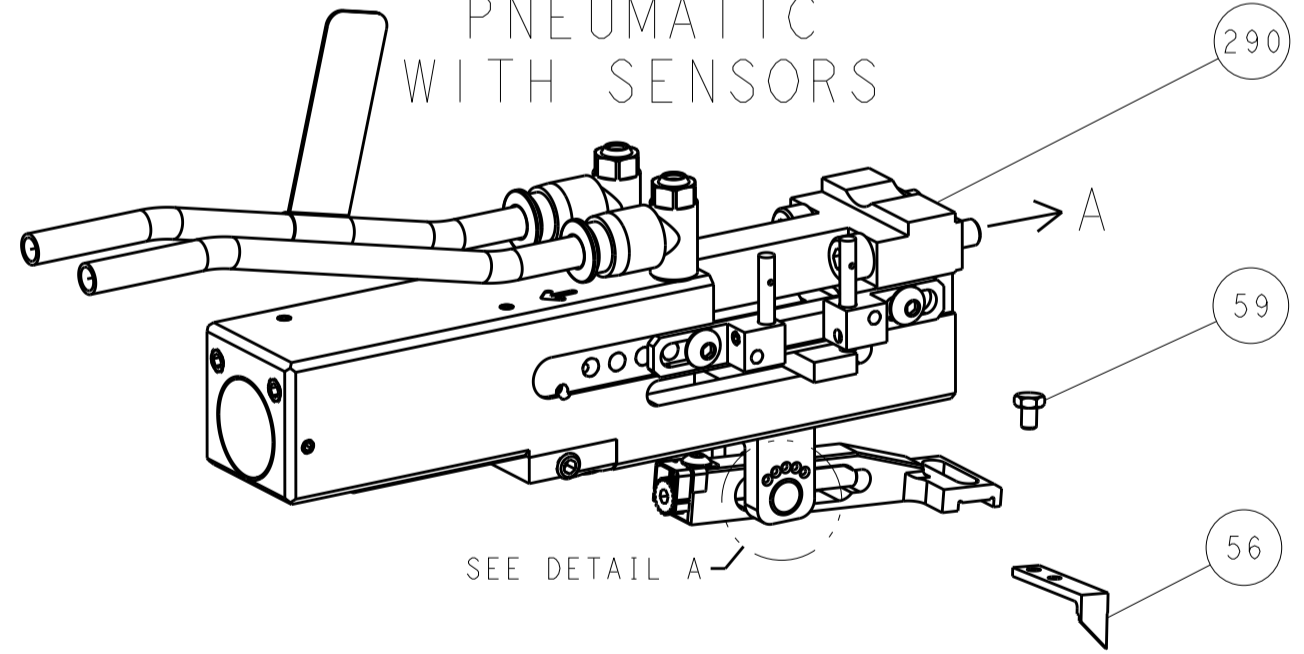


FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



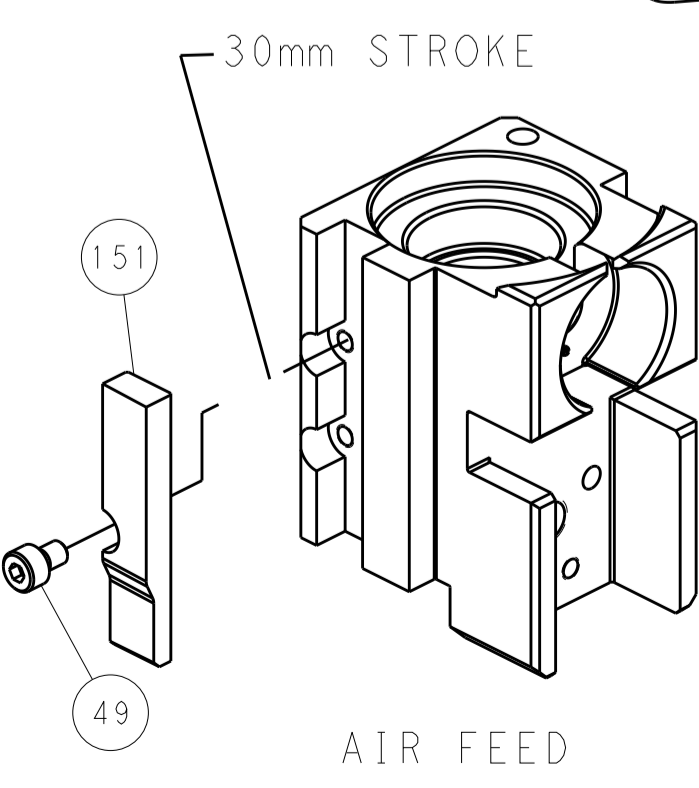
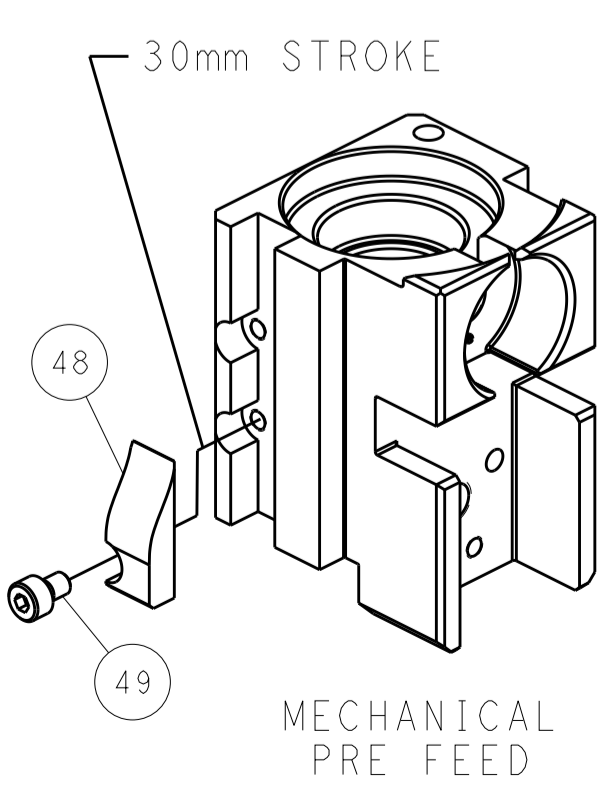
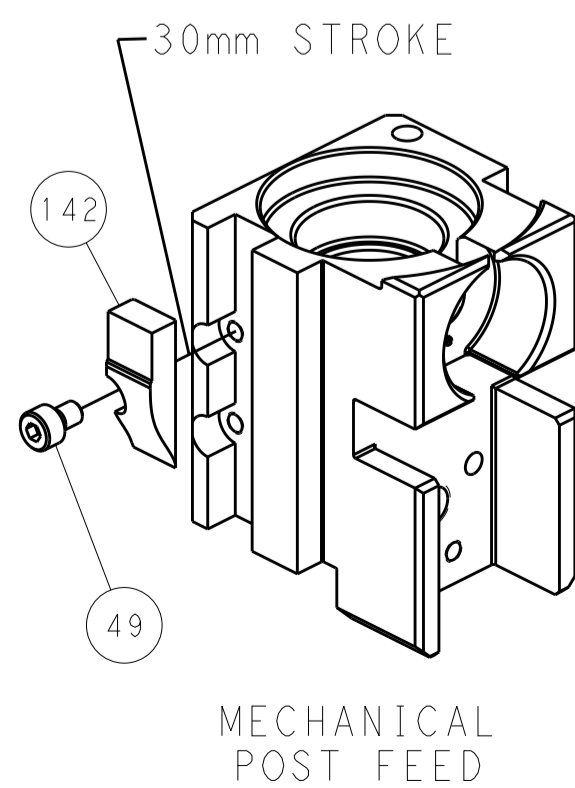
DETAIL A

DOUBLE ACTING PNEUMATIC WITH SENSORS

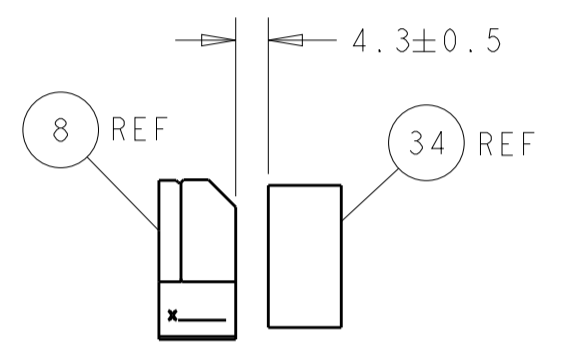
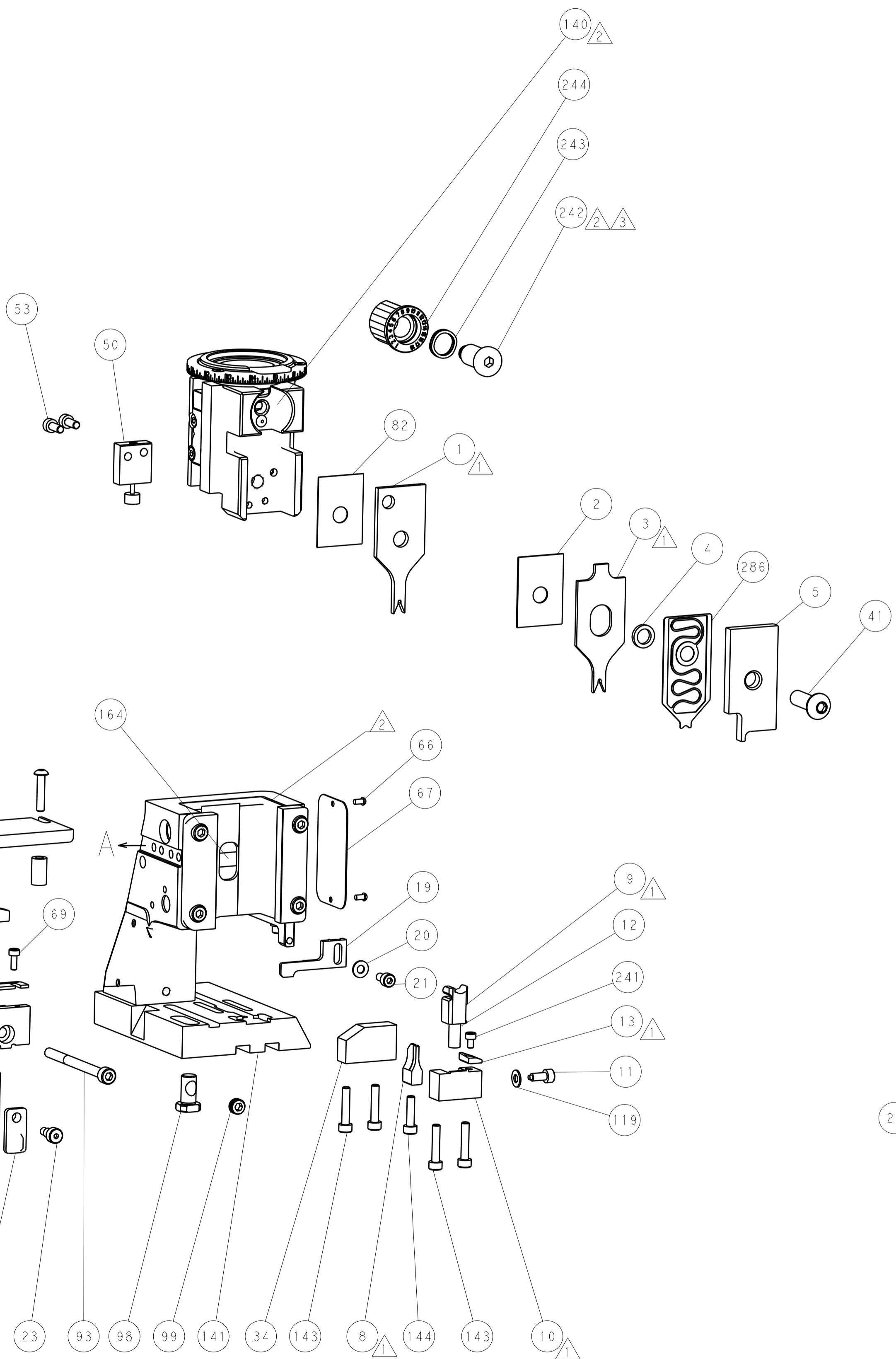


SEE DETAIL A

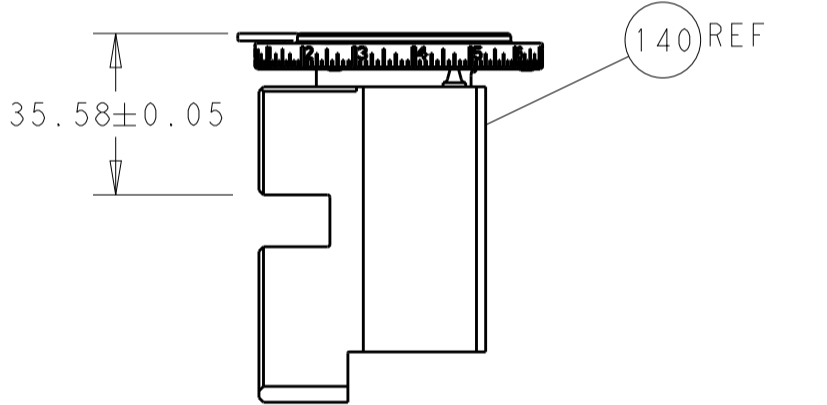
CAM POSITIONS



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

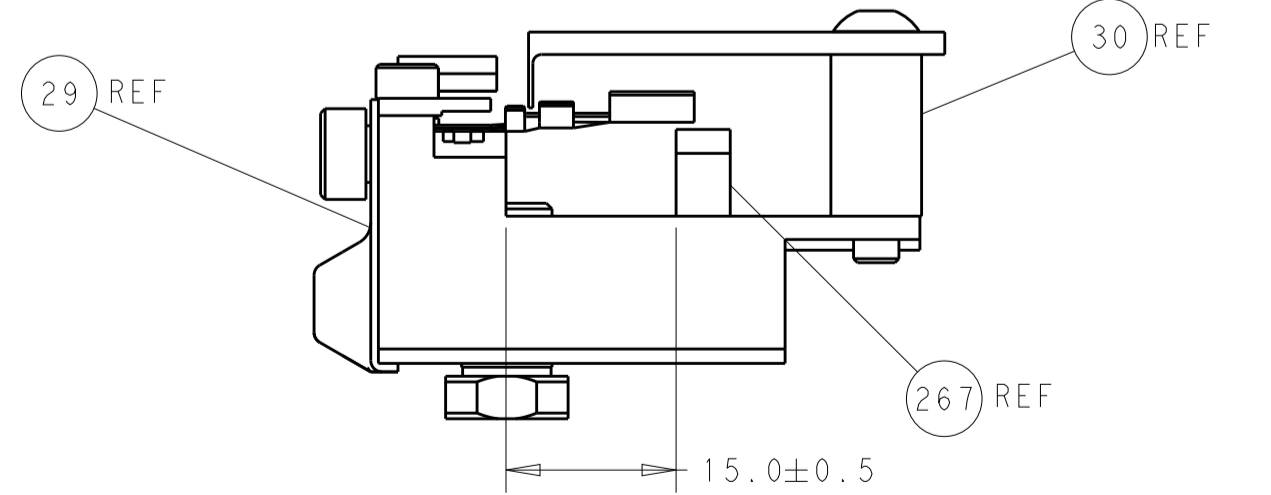


TERMINAL SUPPORT LOCATION



RAM SET-UP

ITEM 30 LOCATED AT REAR HOLES



FEED TRACK POSITION GUIDE BY INSULATION BARREL

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN: R. STAKEM 14NOV2011		TE Connectivity	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	5 PLC ±	Harrisburg, PA 17105-3608
MATERIAL:		FINISH:		CHK: G. BAILEY 14NOV2011		NAME: Ocean Side Feed Applicator	
APVD: T. ELBIN 14NOV2011		PRODUCT SPEC:		APVD: T. ELBIN 14NOV2011		SIZE: CAGE CODE: DRAWING NO: RESTRICTED TO	
APPLICATION SPEC:		WEIGHT:		A1 00779		SCALE: 1:2 SHEET 4 OF 4 REV M	
CUSTOMER ACCESSIBLE PRODUCTION DRAWING		SCALE: 1:2		SHEET 4 OF 4		REV M	