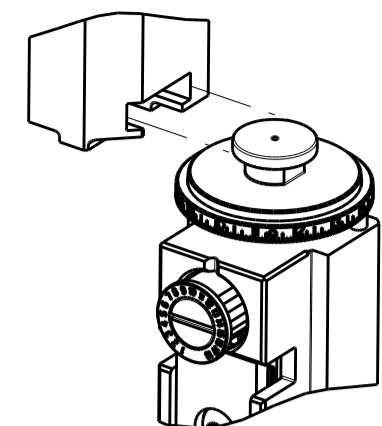


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151824-2	D	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151824-2	D	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2151824-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



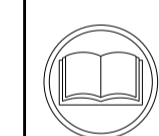
APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	5.40 mm [.213]	F
INSUL	9.75 mm [.384]	O

APPLICATOR INSTRUCTIONS
408-35042

TERMINAL DATA: LEAR TERMINAL		G&H CRIMP SPECIFICATION	
TERMINAL NAME: FLAT CONTACT			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
8.69-9.47 mm [.342-.373 IN]		Ø4.70-5.10 mm [.185-.201 IN]	
TERMINAL APPLICATION SPECIFICATION	NONE		

TERMINALS APPLIED				SEAL INSULATION DIAMETER RANGE
TE TERMINAL	LEAR TERMINAL	TE SEAL	VW SEAL	
1572974-1	28459306189	1949052-1	0211172A	4.0-4.3

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
10.00mm2	3.30+/-0.10 [.130+/- .004]	6.3
6.00mm2	3.00+/-0.05 [.118+/- .002]	9.3



- 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. PLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 180.
- 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 TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- 6. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- 7 APPLY TORO-SEAL IN ALLEN SOCKET TO FILL HOLE AFTER SOCKET HD HAS BEEN ADJUSTED TO CORRECT HEIGHT AT QUALIFICATION. APPLY #1-23419-5 LOC-TITE TO THREADS.
- 8 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.

LOC	DIST	REVISIONS					
		P	LTN	DESCRIPTION	DATE	OWN	APVD
A	66			RELEASED	03APR2013	CC	TE
				ECR-17-005884	25APR2017	AW	GB
				ECR-19-007970	19MAY2019	TB	TE
				ECR-19-012538	09AUG2019	MZ	YY

-	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	265
-	1	1	1633782-3	FENCE	264
-	2	2	22281-8	SPRING, COMPRESSION	263
-	1	1	240792-1	DRAG, TERMINAL	262
-	1	1	2-690438-2	FRONT STRIP GUIDE	261
-	1	1	2119640-1	PUSH ROD, AIR FEED	250
-	1	1	2079988-1	BUSHING, LCHS-12, MISUMI	249
-	1	1	2119641-1	FEED CAM, AIR FEED	248
-	1	1	2119082-9	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	2063440-3	AIR FEED MODULE	238
3	-	1	2-1752354-7	STANDOFF, HOLD-DOWN	180
-	1	1	993111-8	PIN, SLOTTED SPRING 3.0 X 12.0	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
-	2	2	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172
-	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	2844908-1	SCREW, LOCKING	99
-	1	1	2844907-1	POST, LOCKING	98
-	1	1	455888-5	SPACER, CRIMPER	82
-	2	2	2079383-4	SCR, BHSC, RoHS (M4 X 8)	79
-	1	1	1803096-1	EXTENSION PLATE	78
-	1	1	1803607-1	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
8	-	1	1-2168083-3	SCR, SKT HD CAP, RoHS, M3 X 16	57
7	-	1	1-1338683-1	FEED PAWL	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	1901681-2	HOLDDOWN, TERMINAL	51
-	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	1803602-2	SCR, BHSC, RoHS (M8 X 40)	41
-	1	1	1752356-7	SUPPORT, TERMINAL	34
-	2	2	1-2079383-3	SCR, BHSC, RoHS (M4 X 25)	33
-	2	2	3-2844962-7	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	2844992-5	ASSEMBLY, STRIP GUIDE	29
-	1	1	1-455888-0	SPACER, CRIMPER	28
-	1	1	1320928-4	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	1803013-1	STRIPPER, SIDE FEED	19
-	1	1	3-22280-3	SPRING, COMPRESSION	12
-	1	1	1-356885-4	STOP, SHEAR	11
-	1	1	2-2119805-5	SHEAR HOLDER, FRONT	10
-	1	1	1-318059-5	FLOATING SHEAR, FRONT	9
1	2	1	1-1633930-5	ANVIL, COMBINATION	8
-	-	-	-	-	7
-	-	-	-	-	6
-	1	1	1803080-1	DEPRESSOR, SHEAR	5
-	1	1	238011-3	BLOCK, CRIMPER SPACER	4
1	2	1	4-1633965-7	CRIMPER, INSULATION O PREMIUM	3
-	1	1	1-455888-8	SPACER, CRIMPER	2
1	2	1	6-1633609-9	CRIMPER, WIRE	1

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		MATERIAL:		FINISH:	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES ±	

OWN	C. CHEN	18DEC2012
CHK	S. XI	18DEC2012
APVD	J. CRUZ	18DEC2012
PRODUCT SPEC		
APPLICATION SPEC		
SIZE	CAGE CODE	DRAWING NO
A1	00779	2151824
Customer Accessible Production Drawing		
SCALE	1:2	SHEET 1 OF 4
REV	D	

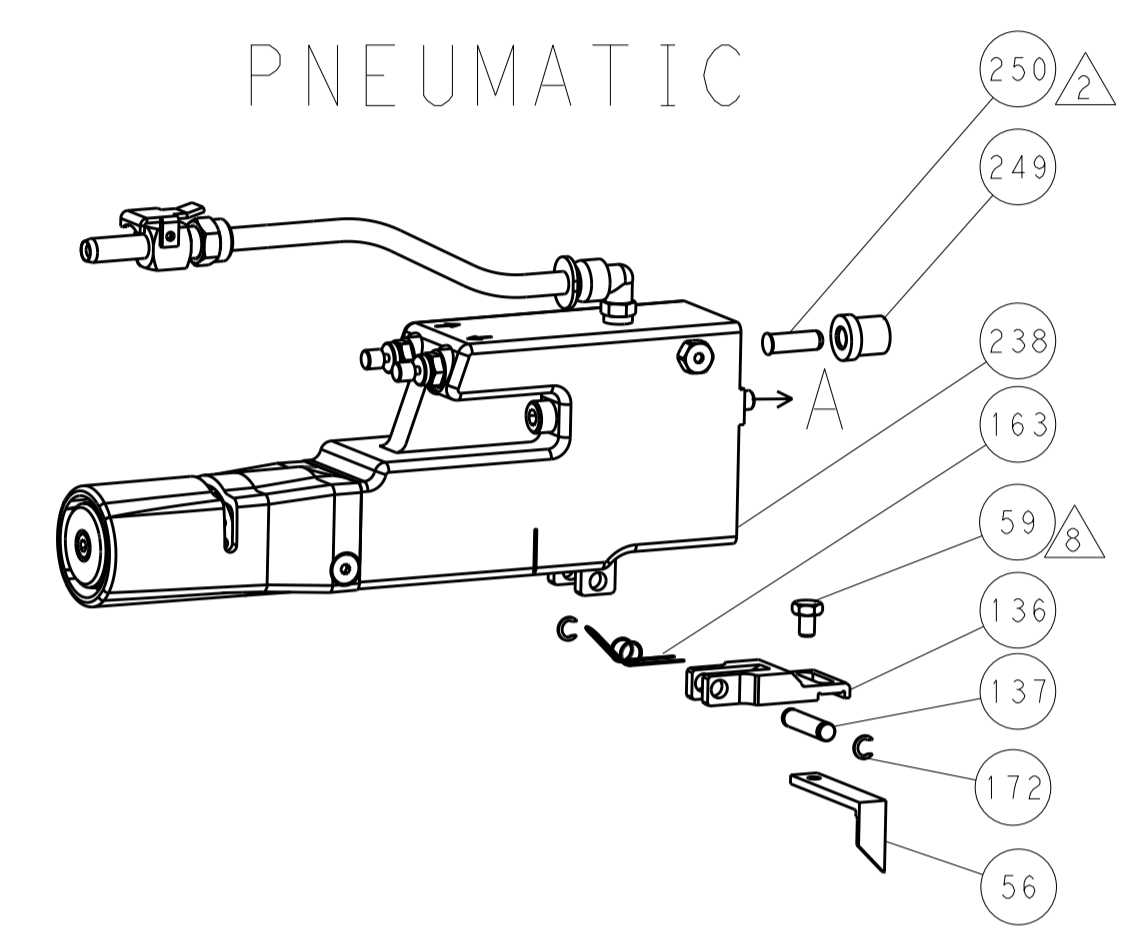
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

LOC	DIST	REV	DATE	BY	APPV
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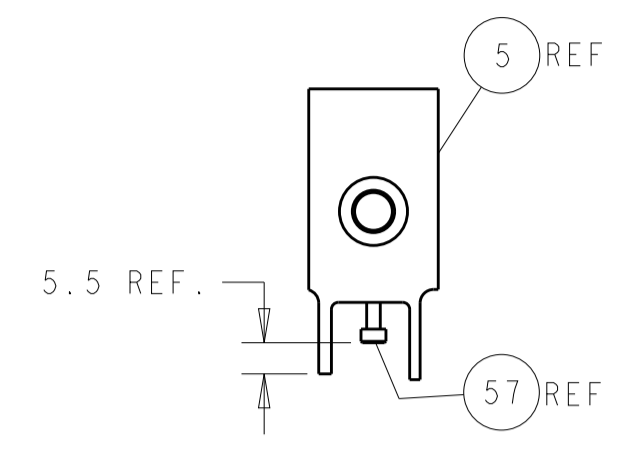
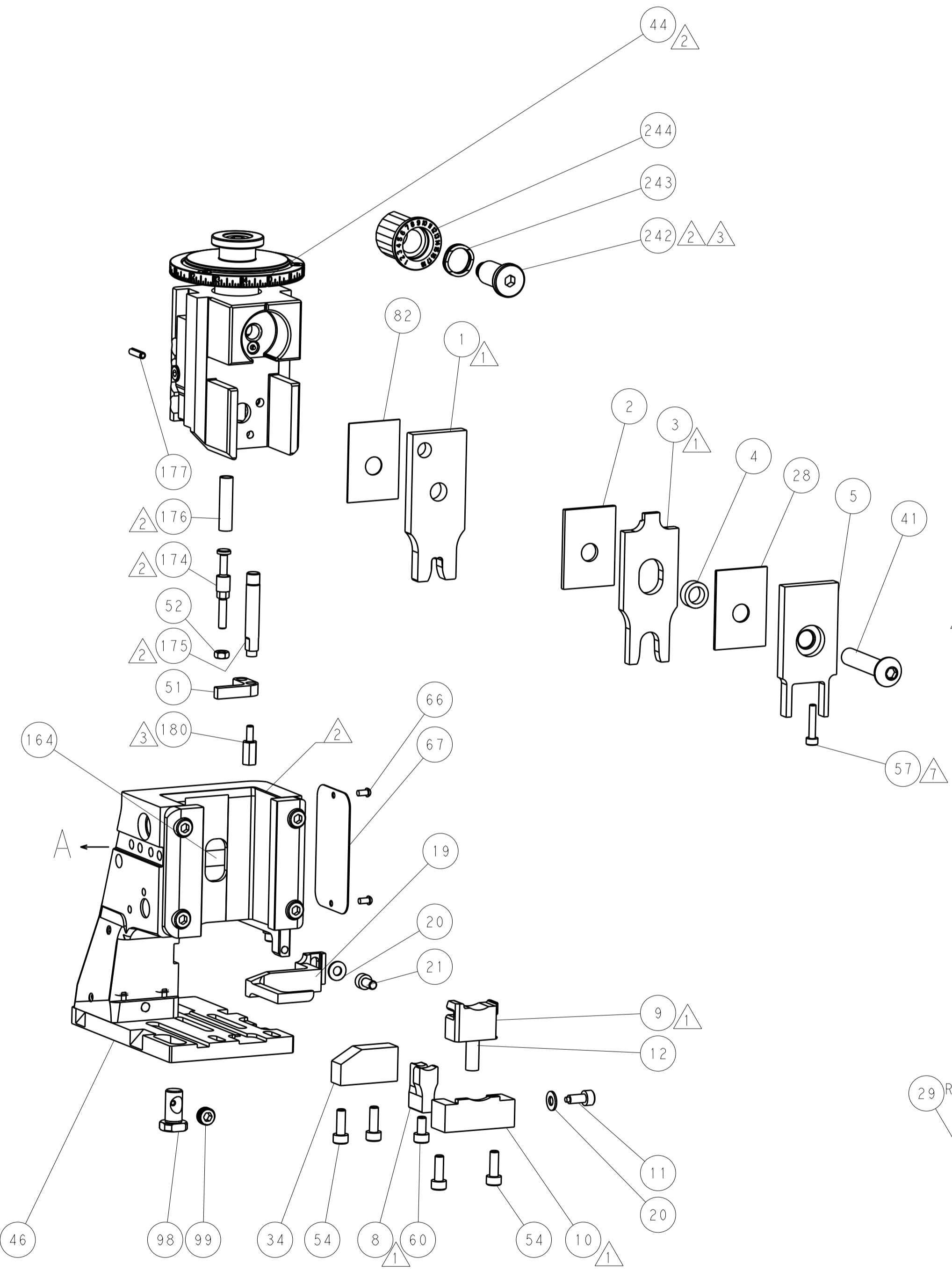
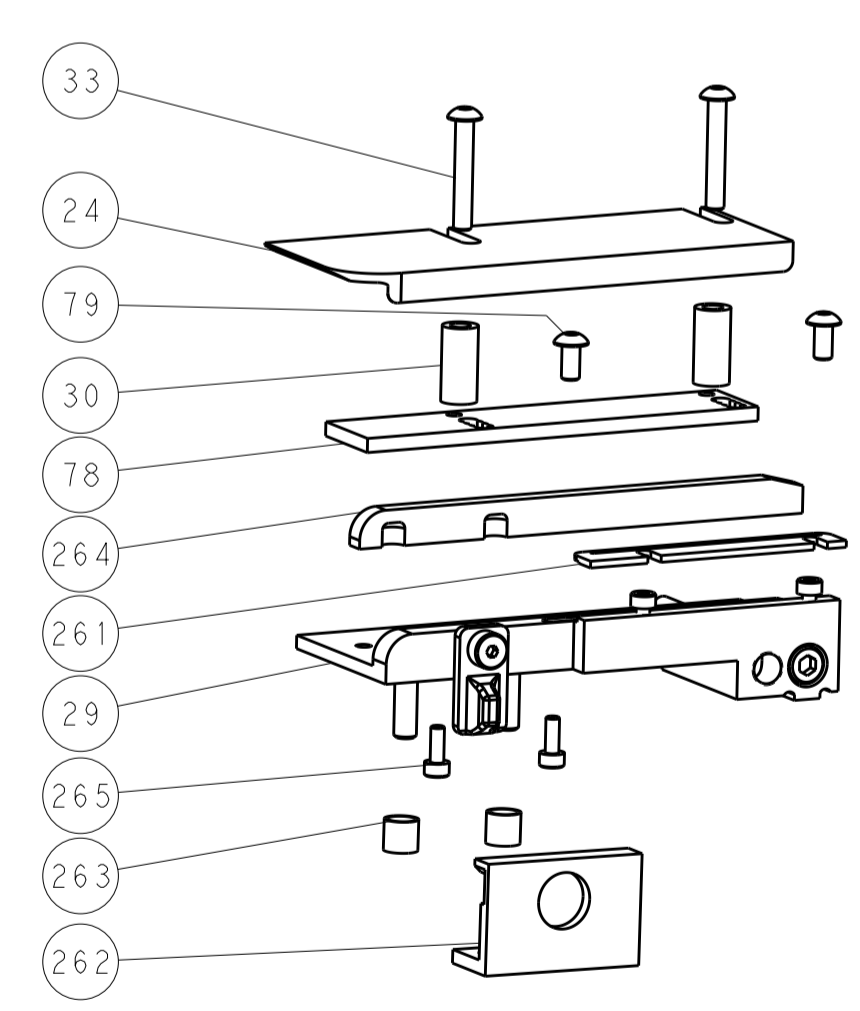
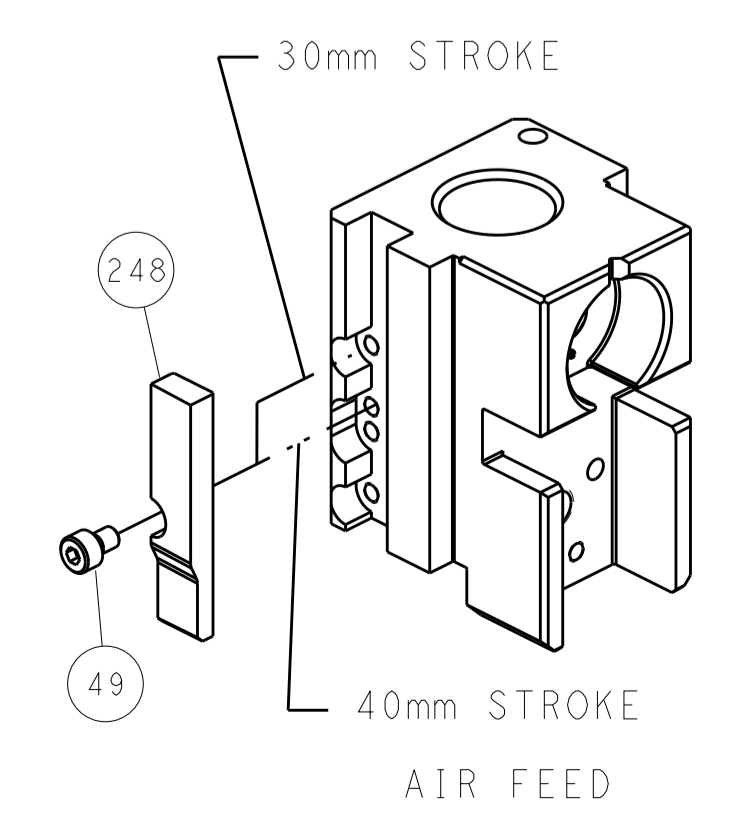
REVISIONS			
REV	DATE	BY	APPV
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-	-	-	-

FEED TYPE

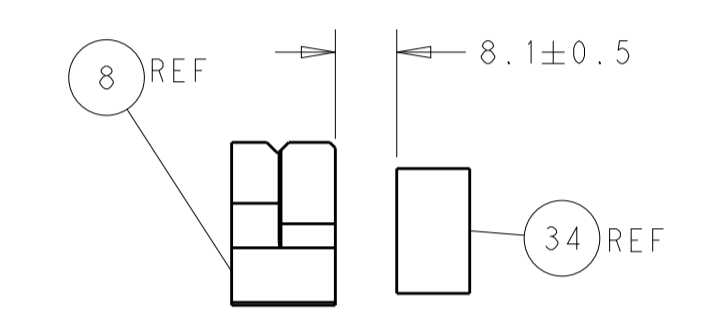
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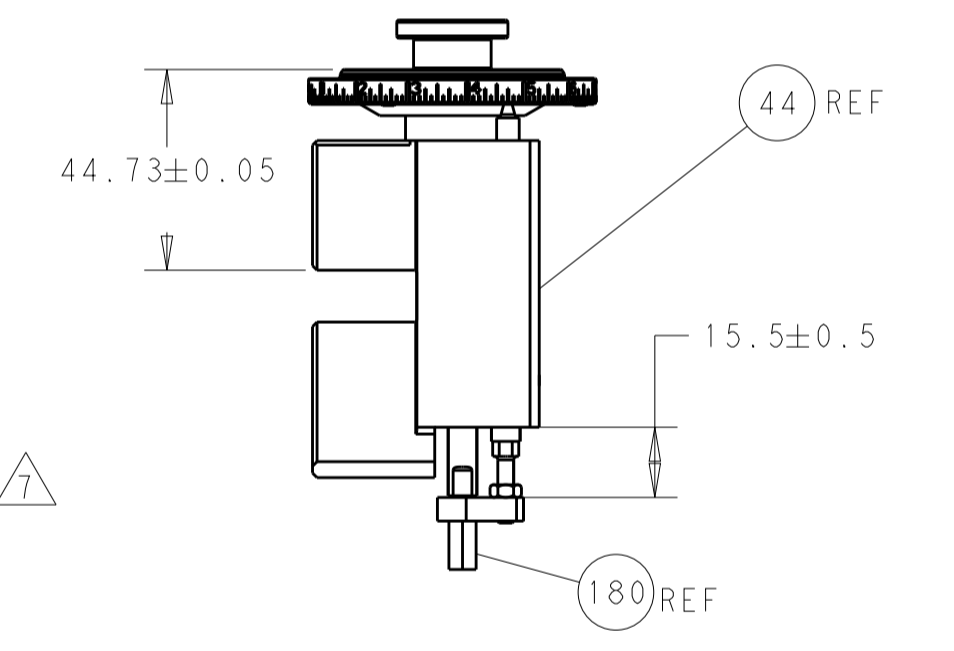
CAM POSITION



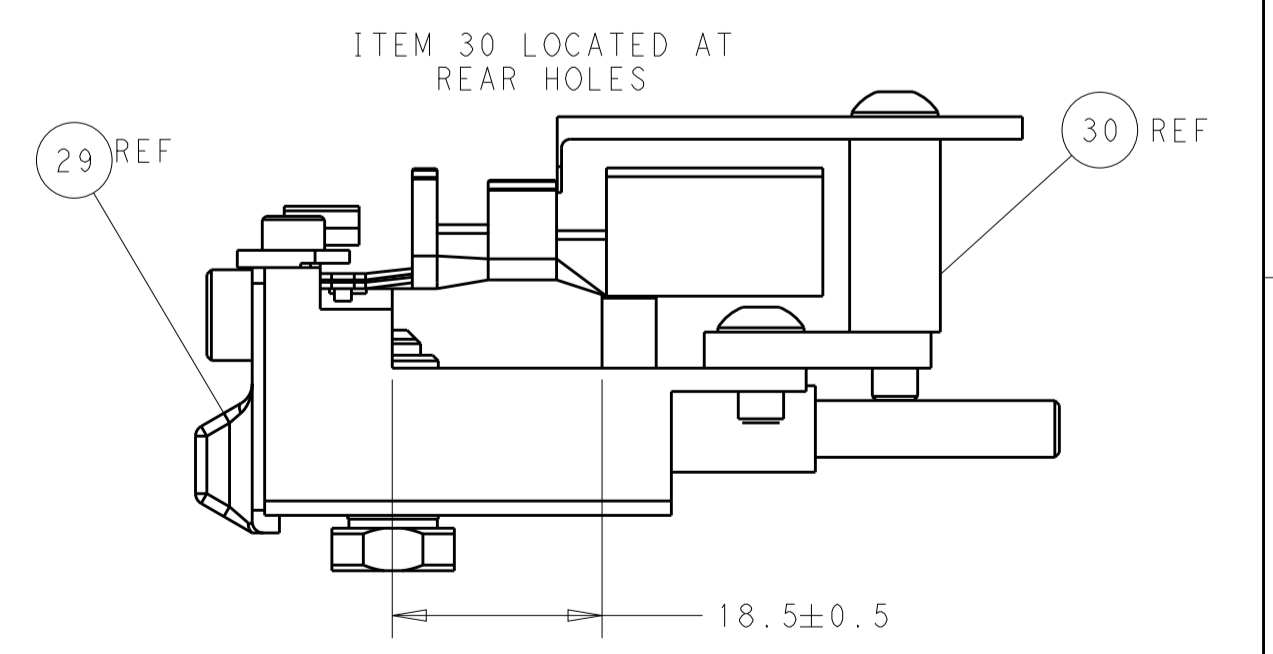
SHEAR DEPRESSOR DETAIL



TERMINAL SUPPORT LOCATION



RAM AND HOLDDOWN SET-UP



FEED TRACK POSITION GUIDE BY WIRE 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:		DWN C. CHEN 18DEC2012		TE Connectivity	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	Harrisburg, PA 17105-3608	
MATERIAL:		FINISH:		CHK S. XI 18DEC2012		NAME	
				APVD J. CRUZ 18DEC2012		Ocean Side Feed Applicator	
				PRODUCT SPEC		SIZE CAGE CODE DRAWING NO	
				APPLICATION SPEC		A1 00779 C=2151824	
				WEIGHT		RESTRICTED TO	
				Customer Accessible Production Drawing		SCALE 1:2 SHEET 2 OF 4 REV D	

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2151824-2	D	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151824-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER

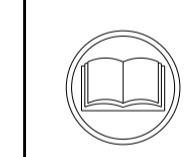


APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	5.40 mm [.213]	F
INSUL	9.75 mm [.384]	O
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: LEAR TERMINAL		G&H CRIMP SPECIFICATION	
TERMINAL NAME: FLAT CONTACT			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
8.69-9.47 mm [.342-.373 IN]		∅4.70-5.10 mm [.185-.201 IN]	
TERMINAL APPLICATION SPECIFICATION	NONE		

TERMINALS APPLIED				SEAL INSULATION DIAMETER RANGE
TE TERMINAL	LEAR TERMINAL	TE SEAL	LEAR SEAL	
1572974-1	28459306189	1949052-1	0211172A	4.0-4.3

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
10.00mm ²	3.30+/-0.10 [.130+/- .004]	6.3
6.00mm ²	3.00+/-0.05 [.118+/- .002]	9.3



- 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. APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 180.
- 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 TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- 6 UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- 7 APPLY TORO-SEAL IN ALLEN SOCKET TO FILL HOLE AFTER SOCKET HD HAS BEEN ADJUSTED TO CORRECT HEIGHT AT QUALIFICATION. APPLY #1-23419-5 LOC-TITE TO THREADS.
- 8 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.

LOC	DIST	REV	DATE	BY	APPV
A	66				

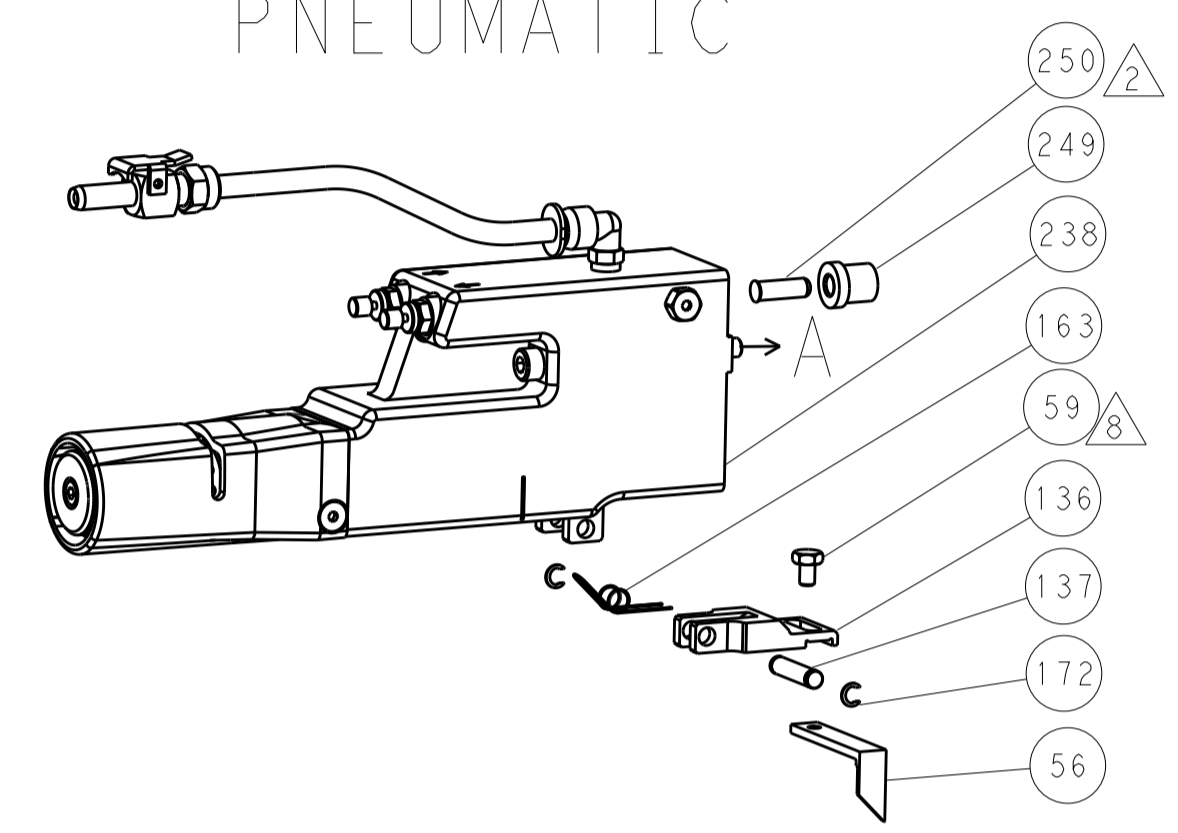
REVISIONS					
REV	DATE	DESCRIPTION	DATE	BY	APPV
-	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0		265
-	1	1633782-3	FENCE		264
-	2	22281-8	SPRING, COMPRESSION		263
-	1	240792-1	DRAG, TERMINAL		262
-	1	2-690438-2	FRONT STRIP GUIDE		261
-	1	2119640-1	PUSH ROD, AIR FEED		250
-	1	2079988-1	BUSHING, LCH5-12, MISUMI		249
-	1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT		244
-	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST		243
3	-	2119083-1	RETAINER, INSULATION DIAL		242
-	1	2063440-3	AIR FEED MODULE		238
3	-	2-1752354-7	STANDOFF,HOLD-DOWN		180
-	1	993111-8	PIN, SLOTTED SPRING 3.0 X 12.0		177
-	1	8-22280-7	SPRING, COMPRESSION		176
-	1	1752353-2	GUIDE PIN,HOLDDOWN		175
-	1	1901680-2	GUIDE PIN,HOLDDOWN		174
-	2	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT		172
-	REF	994970-2	COUNTER, MAGNETIC		164
-	1	240638-1	SPRING, FEED FINGER		163
-	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	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854		137
-	1	2119799-1	HOLDER,FEED FINGER, AF		136
-	1	2844908-1	SCREW, LOCKING		99
-	1	2844907-1	POST, LOCKING		98
-	1	455888-5	SPACER, CRIMPER		82
-	2	2079383-4	SCR, BHSC, RoHS (M4 X 8)		79
-	1	1803096-1	EXTENSION PLATE		78
-	1	1803607-1	DOCUMENTATION PACKAGE		71
-	1	2119740-1	TAG,IDENTIFICATION		67
-	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188		66
8	-	5-18022-5	SCR, HEX HD CAP, M4 X 6.0		59
7	-	1-2168083-3	SCR, SKT HD CAP, RoHS, M3 X 16		57
-	1	1-1338683-1	FEED PAWL		56
-	1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5		52
-	1	1901681-2	HOLDDOWN, TERMINAL		51
-	1	18023-9	SCR, SKT HD CAP M4 X 6.0		49
-	1	1803602-2	SCR, BHSC, RoHS (M8 X 40)		41
-	1	1752356-7	SUPPORT, TERMINAL		34
-	2	1-2079383-3	SCR, BHSC, RoHS (M4 X 25)		33
-	2	3-2844962-7	SPACER, CYLINDRICAL, STRIP GUIDE		30
-	1	2844992-5	ASSEMBLY, STRIP GUIDE		29
-	1	1-455888-0	SPACER, CRIMPER		28
-	1	1320928-4	STRIP GUIDE		24
-	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		19
-	1	3-22280-3	SPRING, COMPRESSION		12
-	1	1-356885-4	STOP, SHEAR		11
1	-	2-2119805-5	SHEAR HOLDER, FRONT		10
1	-	1-318059-5	FLOATING SHEAR, FRONT		9
1	1	1-1633930-5	ANVIL, COMBINATION		8
-	-	-	-		7
-	-	-	-		6
-	1	1803080-1	DEPRESSOR, SHEAR		5
-	1	238011-3	BLOCK, CRIMPER SPACER		4
1	1	4-1633965-7	CRIMPER, INSULATION O PREMIUM		3
-	1	1-455888-8	SPACER, CRIMPER		2
1	1	6-1633609-9	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)

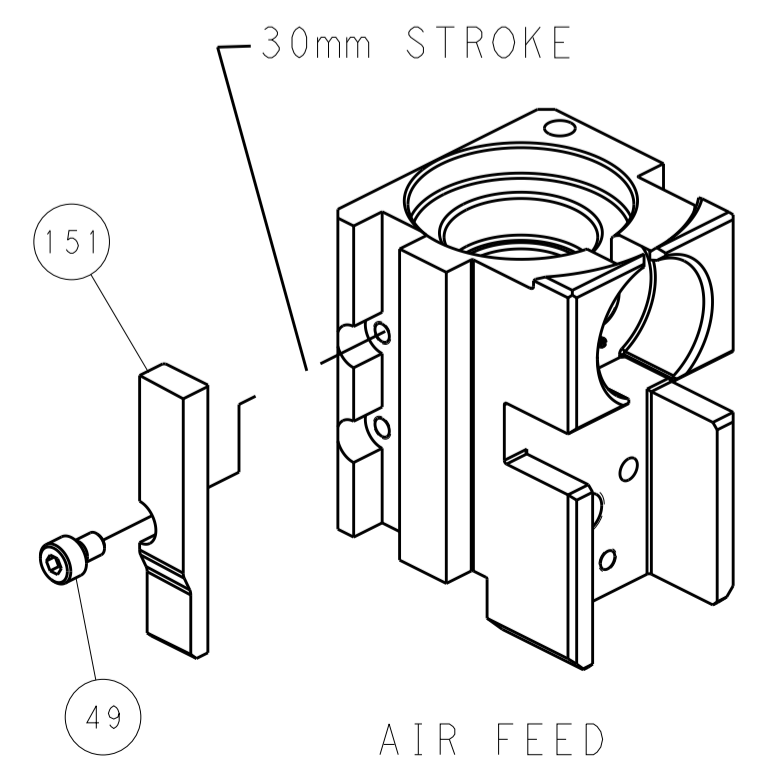
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mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	NAME: Ocean Side Feed Applicator	
MATERIAL:		FINISH:		APVD: I. CRUZ 18DEC2012		SIZE: A1 00779 C=2151824	
Customer Accessible Production Drawing		SCALE: 1:2		SHEET: 3 OF 4		REV: D	

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

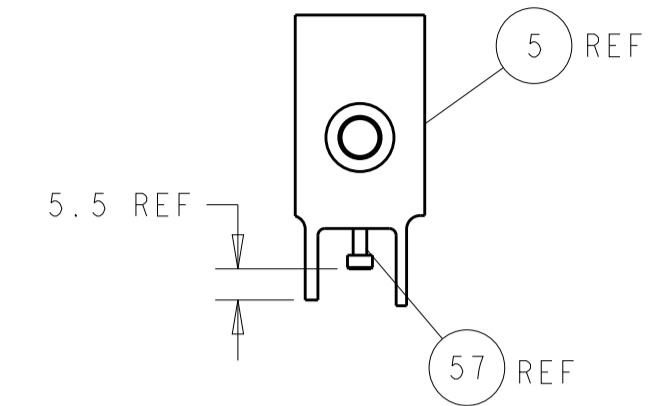
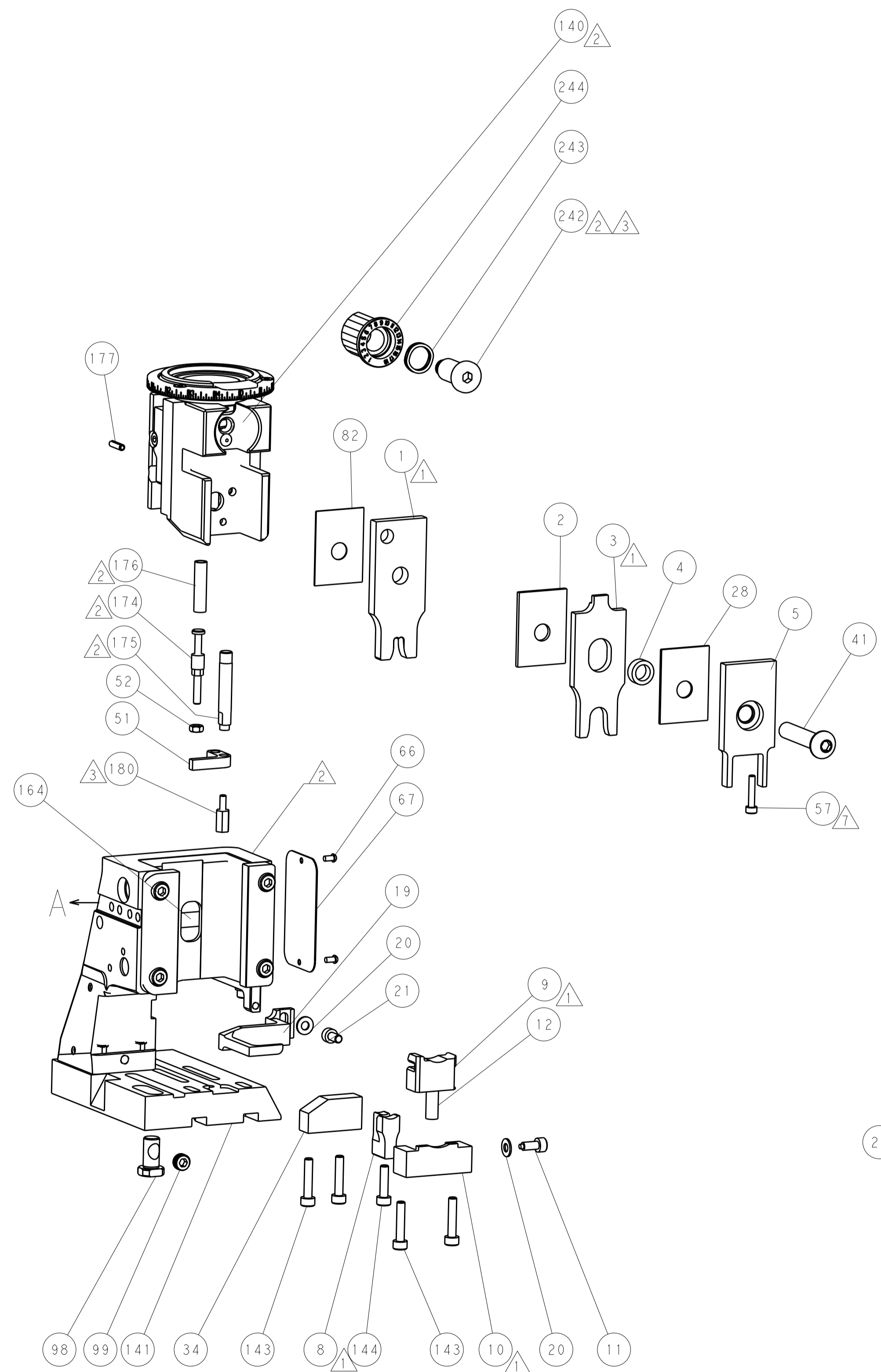
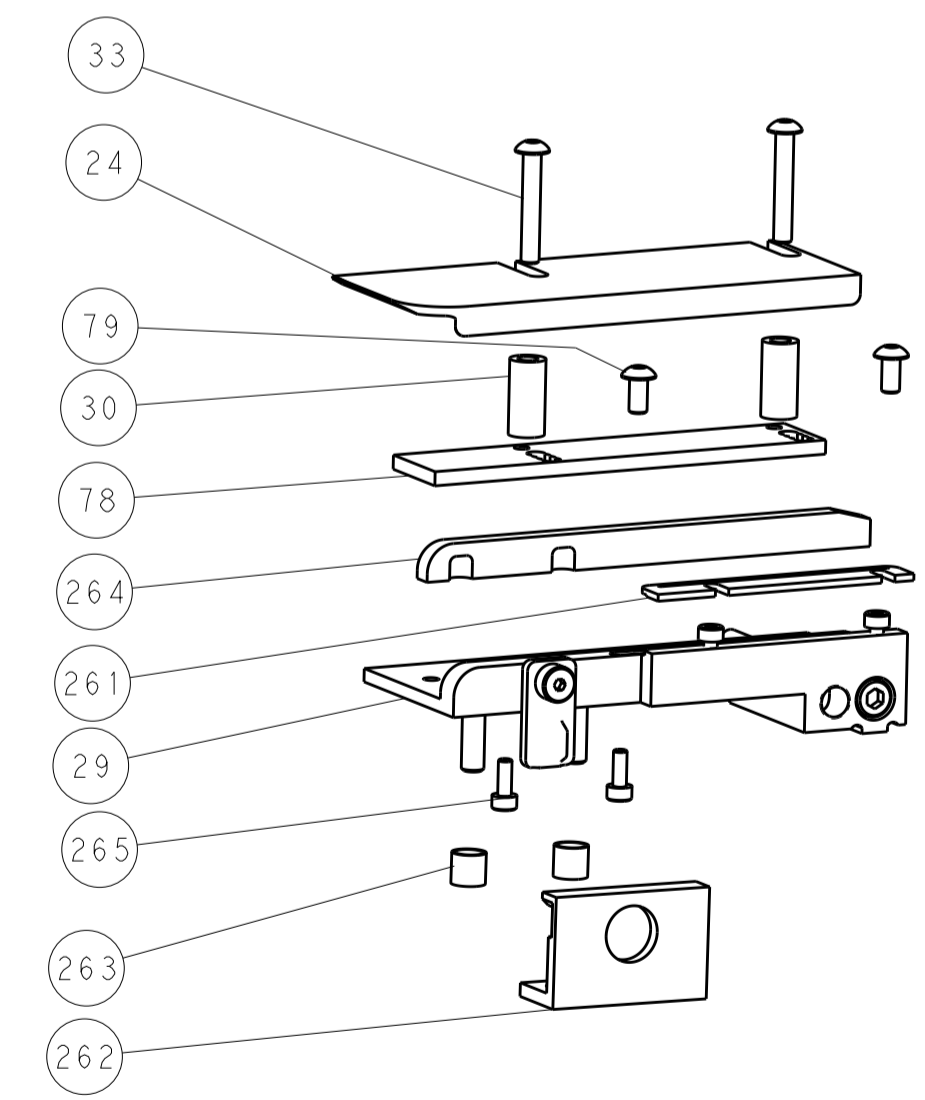
FEED TYPE PNEUMATIC



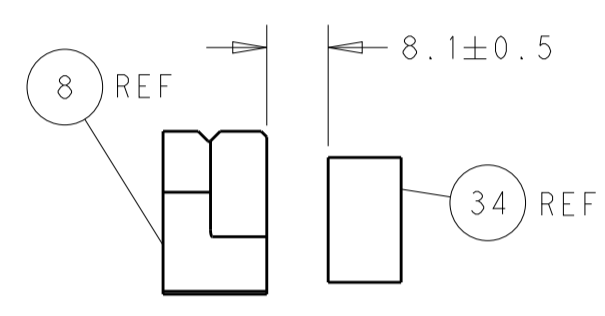
CAM POSITION



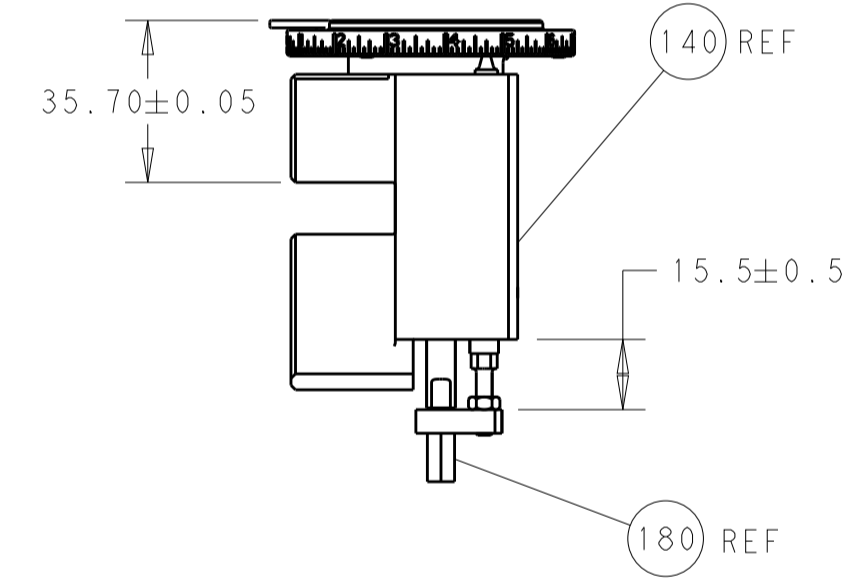
AIR FEED



SHEAR DEPRESSOR DETAIL

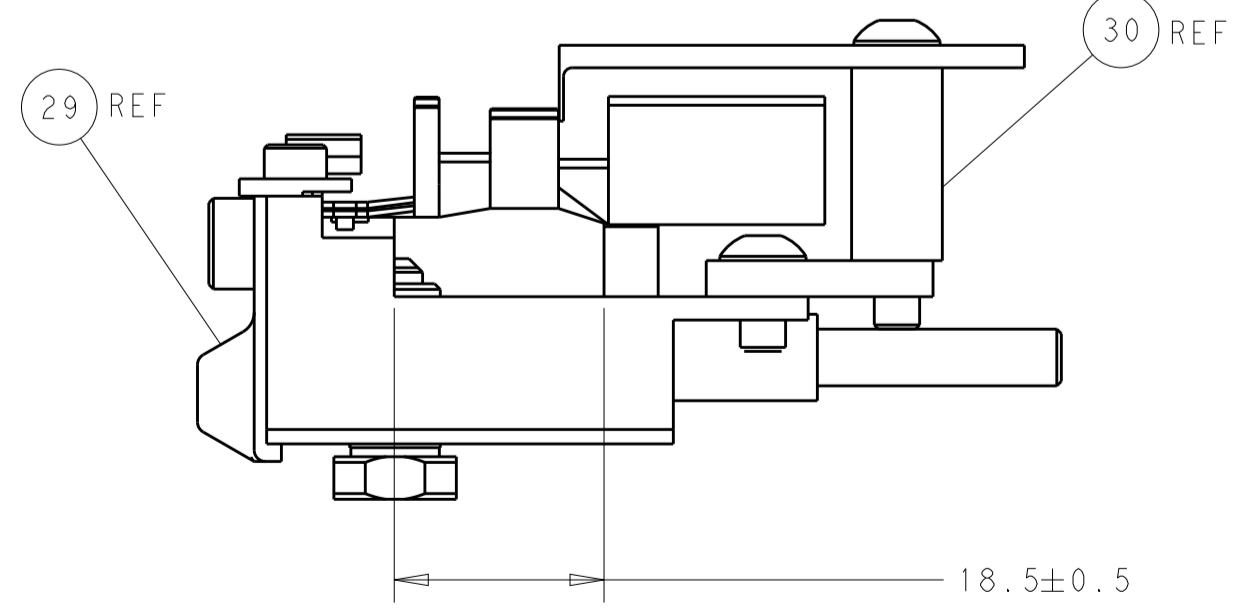


TERMINAL SUPPORT LOCATION



RAM AND HOLDDOWN SET-UP

ITEM 30 LOCATED AT REAR HOLES



FEED TRACK POSITION GUIDE BY WIRE BARREL

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

<small>THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION. IT IS THE POLICY OF TYCO ELECTRONICS CORPORATION TO CONTINUE TO IMPROVE ITS PRODUCTS WITHOUT NOTICE. THEREFORE, THIS DRAWING IS SUBJECT TO CHANGE WITHOUT NOTICE AND WITHOUT OBLIGATION TO BE CONTACTED FOR THE LATEST REVISION.</small>		DWN: C. CHEN 18DEC2012 CHK: S. XI 18DEC2012 APVD: J. CRUZ 18DEC2012	TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		NAME: Ocean Side Feed Applicator PRODUCT SPEC: APPLICATION SPEC: WEIGHT: SCALE: 1:2	RESTRICTED TO: SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2151824 SHEET 4 OF 4 REV D