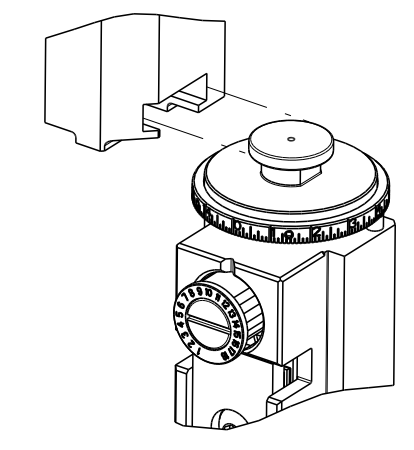


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151785-1	G	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2151785-2	G	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151785-1	G	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2151785-2	G	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2151785-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.98 mm [.078]	F
INSUL	2.59 mm [.102]	F

APPLICATOR INSTRUCTIONS 408-35042

TERMINAL DATA: DELPHI TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: TAXI TERM			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
.185-.217 IN [4.70-5.51 mm]		Ø.067-.089 IN [1.70-2.26 mm]	
TERMINAL APPLICATION SPECIFICATION	NONE		
TERMINALS APPLIED			
TE TERMINAL	DELPHI TERMINAL	TE TERMINAL	DELPHI TERMINAL
286751-1	15304711	1572784-1	15304723

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.00mm2	1.40 +/- 0.05 [0.055 +/- .002]	4.1
0.80mm2	1.25 +/- 0.05 [0.049 +/- .002]	6.0

- 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.
- WHEN RUNNING SOCKET TERMINAL 286751-1 USE SET UP SHOWN ON EXPLODED VIEW ON SHEET 2 FOR ITEMS 7 & 81. DIMENSION 3.30±0.50 [0.130±0.019] ON TERMINAL SUPPORT VIEW APPLIES TO SOCKET TERMINAL 286751-1 ONLY.
- WHEN RUNNING PIN TERMINAL 1572784-1 SWITCH POSITION OF ITEMS 7 & 81 SHOWN ON EXPLODED VIEW ON SHEET 2. DIMENSION 8.89±0.50 [0.350±0.019] ON TERMINAL SUPPORT VIEW APPLIES TO PIN TERMINAL 1572784-1 ONLY.
- 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	REVISIONS					
A	66	P	LTN	DESCRIPTION	DATE	OWN	APVD
		D		ECR-17-009523	29JUN2017	TB	TE
		E		ECR-18-008507	08JUN2018	YY	TE
		F		ECR-18-013950	04SEP2018	FL	TE
		G		ECR-23-187845	21SEP2023	JWC	ROY

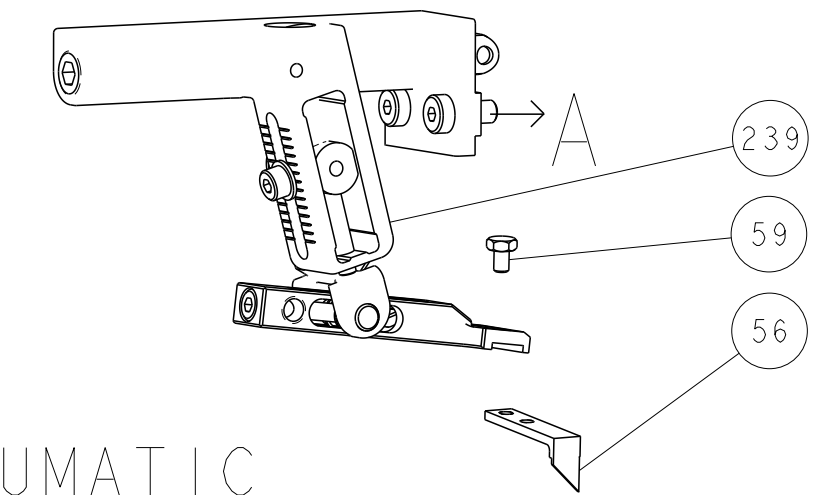
-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248	
-	1	1	1	1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244	
-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243	
-	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242	
-	1	1	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241	
-	-	1	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239	
-	1	-	1	-	2844940-1	AIR FEED MODULE	238	
-	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164	
-	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	455888-5	SPACER, CRIMPER	82	
-	1	1	1	1	5-240641-5	SPACER	81	
-	1	1	1	1	1803607-3	DOCUMENTATION PACKAGE	71	
-	1	1	1	1	2119791-9	DEPRESSOR, WIRE	70	
-	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	1-2168083-2	SCR, SKT HD CAP, RoHS, M4 X 25	53	
-	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	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	1752356-6	SUPPORT, TERMINAL	34	
-	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33	
-	2	2	2	2	2-2844962-4	SPACER, CYLINDRICAL, STRIP GUIDE	30	
-	1	1	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29	
-	1	1	1	1	1320928-4	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	1803095-3	FLOATING SHEAR, FRONT	9	
1	2	2	1	1	4-1633620-9	ANVIL, COMBINATION	8	
-	1	1	1	1	1-240641-8	SPACER	7	
-	-	-	-	-	-	-	6	
-	1	1	1	1	2119757-4	DEPRESSOR, SHEAR	5	
-	1	1	1	1	238011-4	BLOCK, CRIMPER SPACER	4	
1	2	2	1	1	1-1803016-7	CRIMPER, INSULATION F	3	
-	1	1	1	1	455888-4	SPACER, CRIMPER	2	
1	2	2	1	1	2-1490019-4	CRIMPER, WIRE PREMIUM	1	
-	77	-72	-71	-2	-1	PART NO	DESCRIPTION	ITEM NO

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

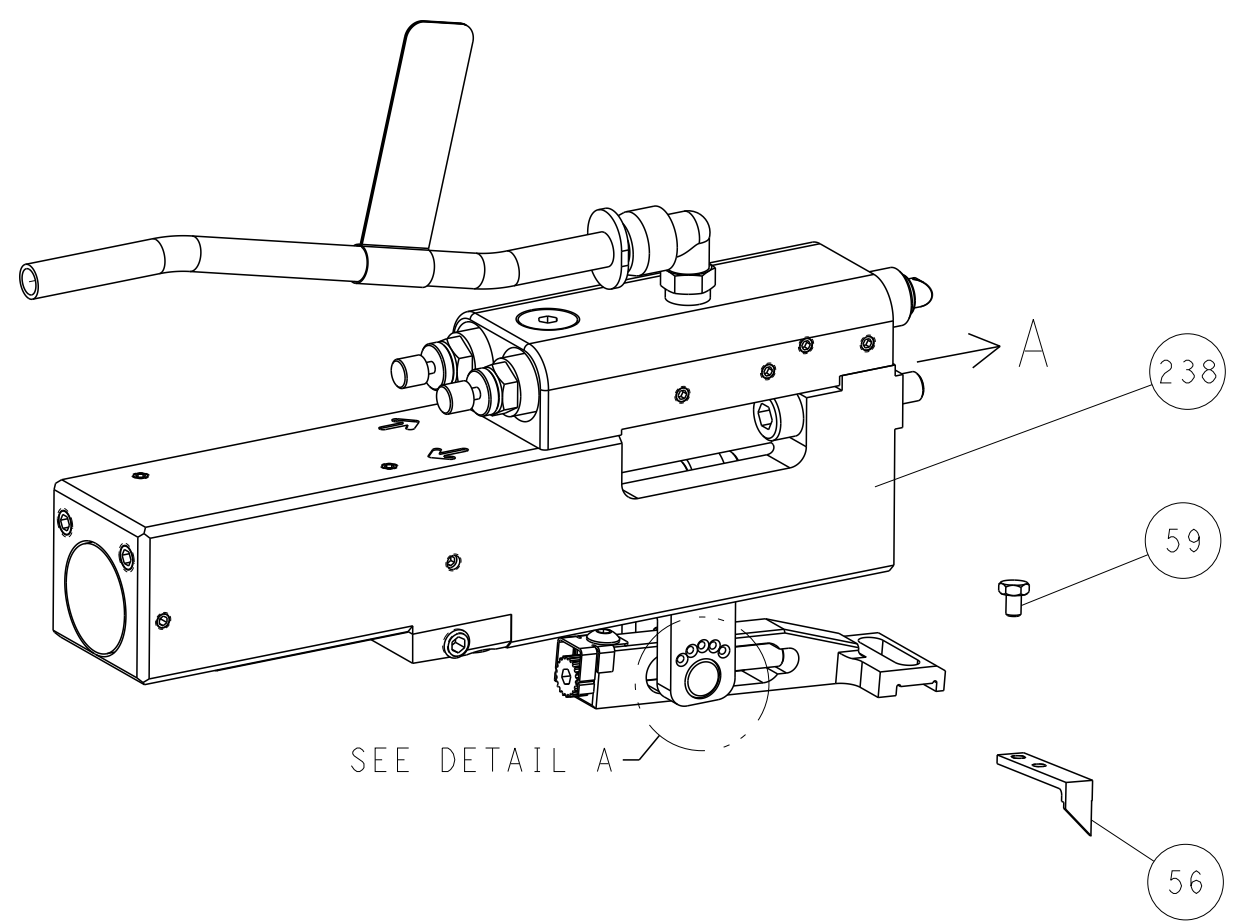
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN C. CHEN 12OCT2012		TE Connectivity	
mm		0 PLC ±		CHK S. XI 12OCT2012		Harrisburg, PA 17105-3608	
		1 PLC ±		APVD J. CRUZ 12OCT2012		NAME Ocean Side Feed	
		2 PLC ±		PRODUCT SPEC		Applicator	
		3 PLC ±		APPLICATION SPEC		SIZE CAGE CODE DRAWING NO RESTRICTED TO	
		4 PLC ±		MATERIAL		A1 00779 C=2151785	
		ANGLES		FINISH		WEIGHT	
						Customer Accessible Production Drawing SCALE 1:2 SHEET 1 OF 4 REV G	

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

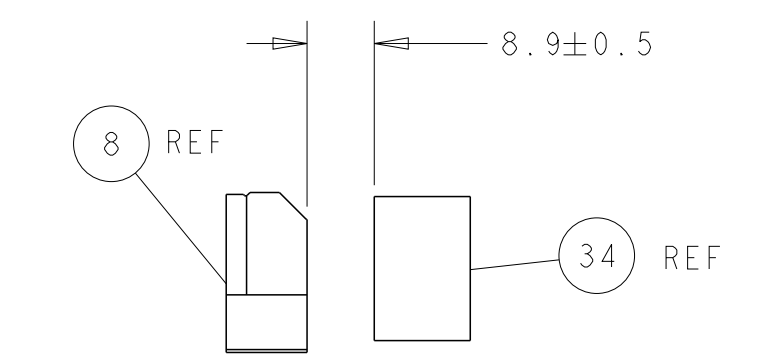
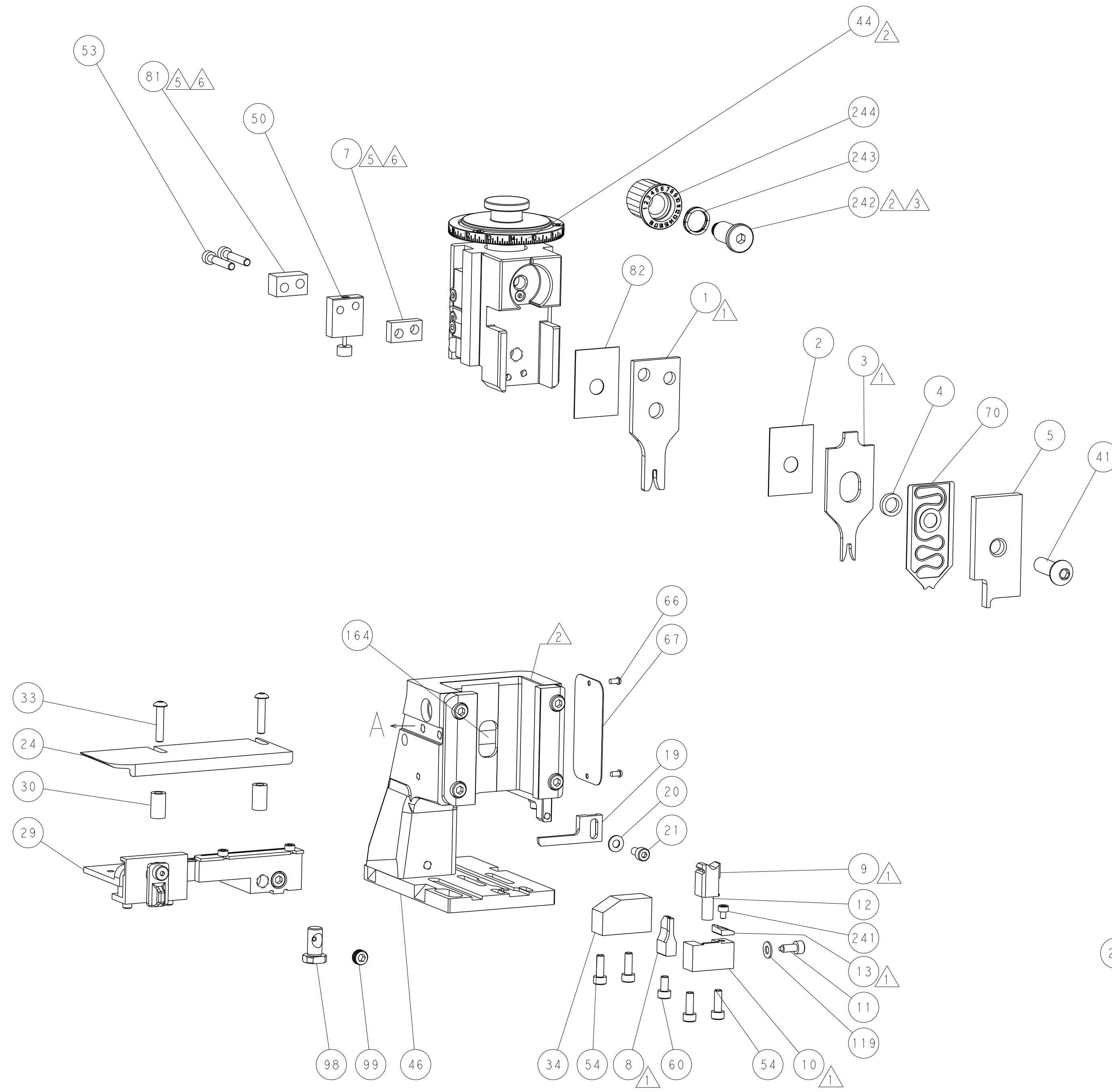
FEED TYPE MECHANICAL



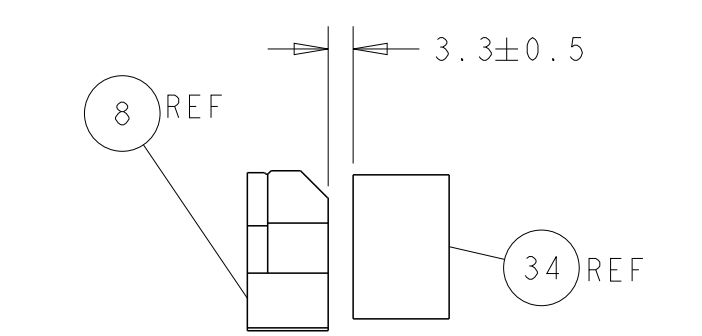
PNEUMATIC



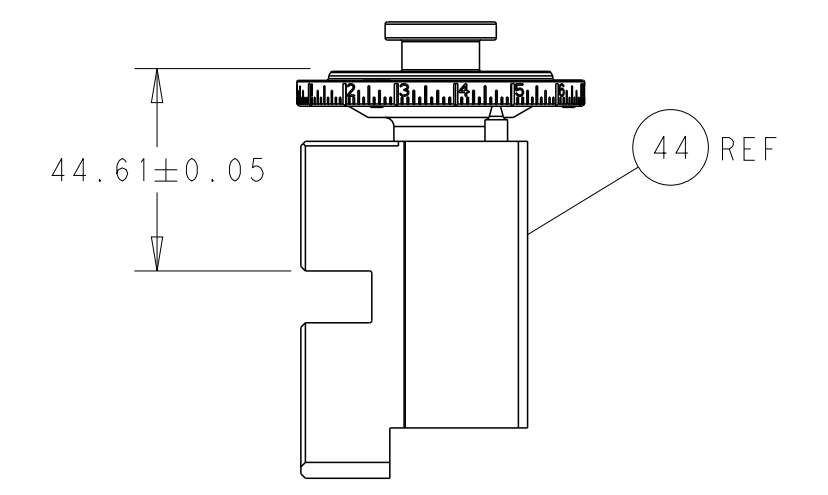
FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



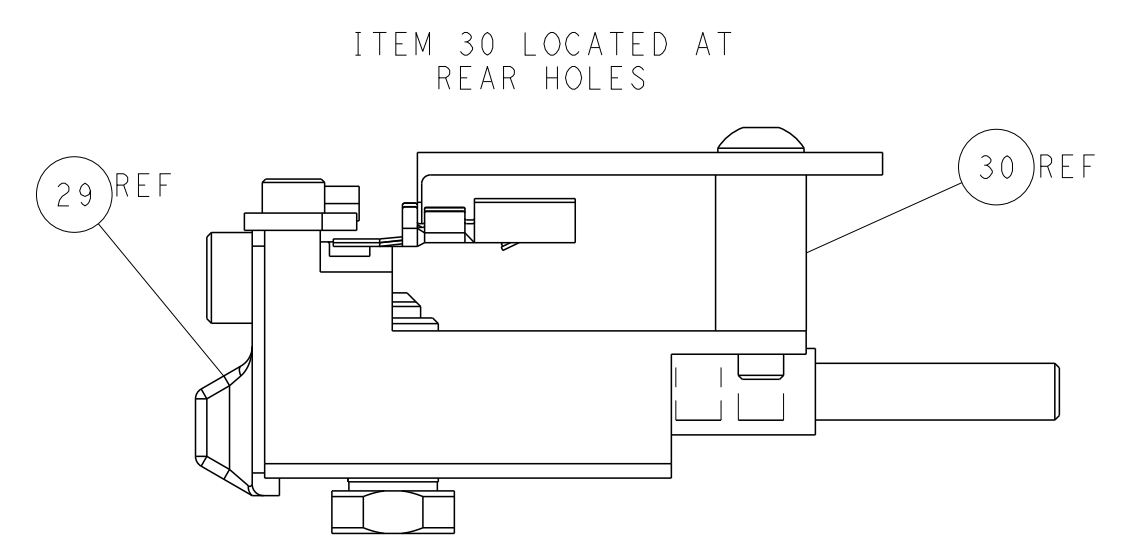
TERMINAL SUPPORT LOCATION FOR PIN TERMINAL 1572784-1 ONLY



TERMINAL SUPPORT LOCATION FOR SOCKET TERMINAL 286751-1 ONLY

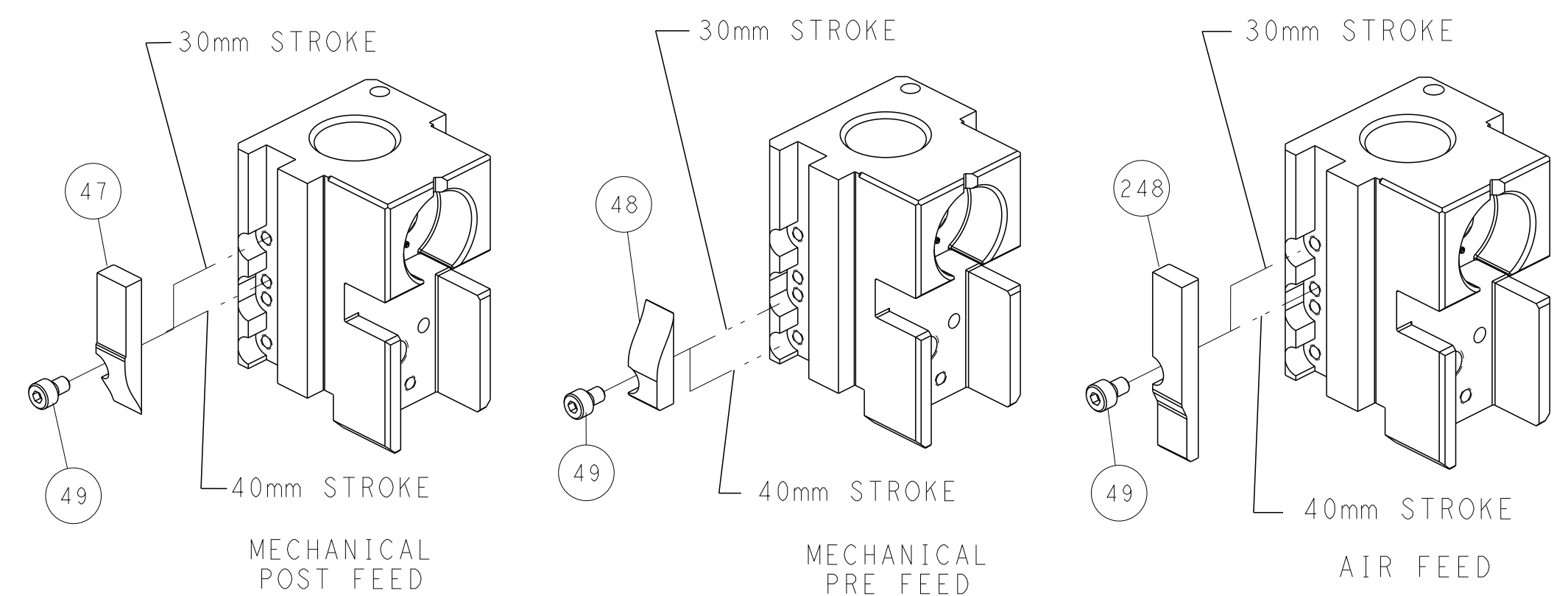


RAM SET-UP



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: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH		DWN C. CHEN 12OCT2012 CHK S. XI 12OCT2012 APVD J. CRUZ 12OCT2012 PRODUCT SPEC APPLICATION SPEC WEIGHT Customer Accessible Production Drawing		NAME Ocean Side Feed Applicator SIZE CAGE CODE DRAWING NO. RESTRICTED TO A1 00779 C=2151785 SCALE 1:2 SHEET 2 OF 4 REV G	
--------------------	--	---	--	--	--	---	--

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2151785-1	G	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2151785-2	G	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151785-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.98 mm [.078]	F
INSUL	2.59 mm [.102]	F

APPLICATOR INSTRUCTIONS
408-35042

TERMINAL DATA: DELPHI TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: TAXI TERM			
WIRE STRIP LENGTH .185-.217 IN [4.70-5.51 mm]		INSULATION DIAMETER RANGE Ø.067-.089 IN [1.70-2.26 mm]	
TERMINAL APPLICATION SPECIFICATION NONE			
TERMINALS APPLIED			
TE TERMINAL	DELPHI TERMINAL	TE TERMINAL	DELPHI TERMINAL
286751-1	15304711	1572784-1	15304723

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.00mm2	1.40+/-0.05 [.055+/-0.002]	4.1
0.80mm2	1.25+/-0.05 [.049+/-0.002]	6.0



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. WHEN RUNNING SOCKET TERMINAL 286751-1 USE SET UP SHOWN ON EXPLODED VIEW ON SHEET 2 FOR ITEMS 7 & 81. DIMENSION 3.30±0.50 [0.130±0.019] ON TERMINAL SUPPORT VIEW APPLIES TO SOCKET TERMINAL 286751-1 ONLY.
6. WHEN RUNNING PIN TERMINAL 1572784-1 SWITCH POSITION OF ITEMS 7 & 81 SHOWN ON EXPLODED VIEW ON SHEET 2. DIMENSION 8.89±0.50 [0.350±0.019] ON TERMINAL SUPPORT VIEW APPLIES TO PIN TERMINAL 1572784-1 ONLY.
7. 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	REVISIONS					
A	66	P	LTN	DESCRIPTION	DATE	DWN	APVD
-	-	-	-	SEE SHEET 1	-	-	-

-	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	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
-	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	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	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	455888-5	SPACER, CRIMPER	82
-	1	1	5-240641-5	SPACER	81
-	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	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	1	1	1338685-1	PAWL, FEED	56
-	2	2	1-2168083-2	SCR, SKT HD CAP, RoHS, M4 X 25	53
-	1	1	1803382-1	HOLD DOWN, SPRING LOADED	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	1752356-6	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	1320928-4	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	1803095-3	FLOATING SHEAR, FRONT	9
-	1	1	4-1633620-9	ANVIL, COMBINATION	8
-	1	1	1-240641-8	SPACER	7
-	-	-	-	-	6
-	1	1	2119757-4	DEPRESSOR, SHEAR	5
-	1	1	238011-4	BLOCK, CRIMPER SPACER	4
-	1	1	1-1803016-7	CRIMPER, INSULATION F	3
-	1	1	455888-4	SPACER, CRIMPER	2
-	1	1	2-1490019-4	CRIMPER, WIRE PREMIUM	1
-	77	22	21	PART NO	ITEM NO

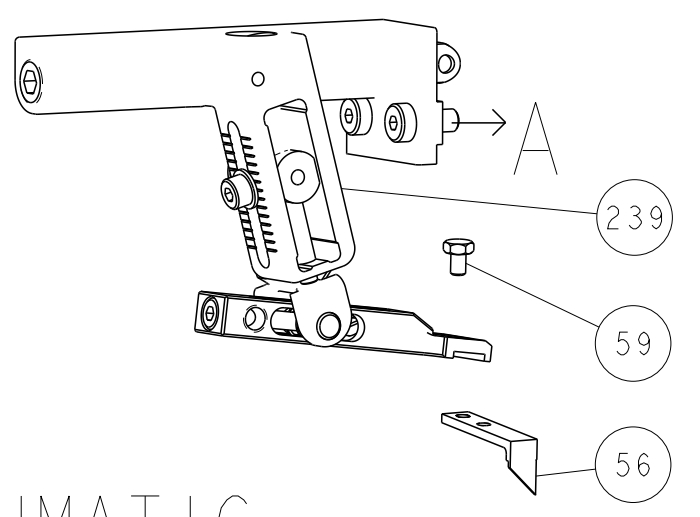
PACIFIC VERSION
Shown on sheets 3 of 4 & 4 of 4
(Atlantic version shown on sheets 1 of 4 & 2 of 4)

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

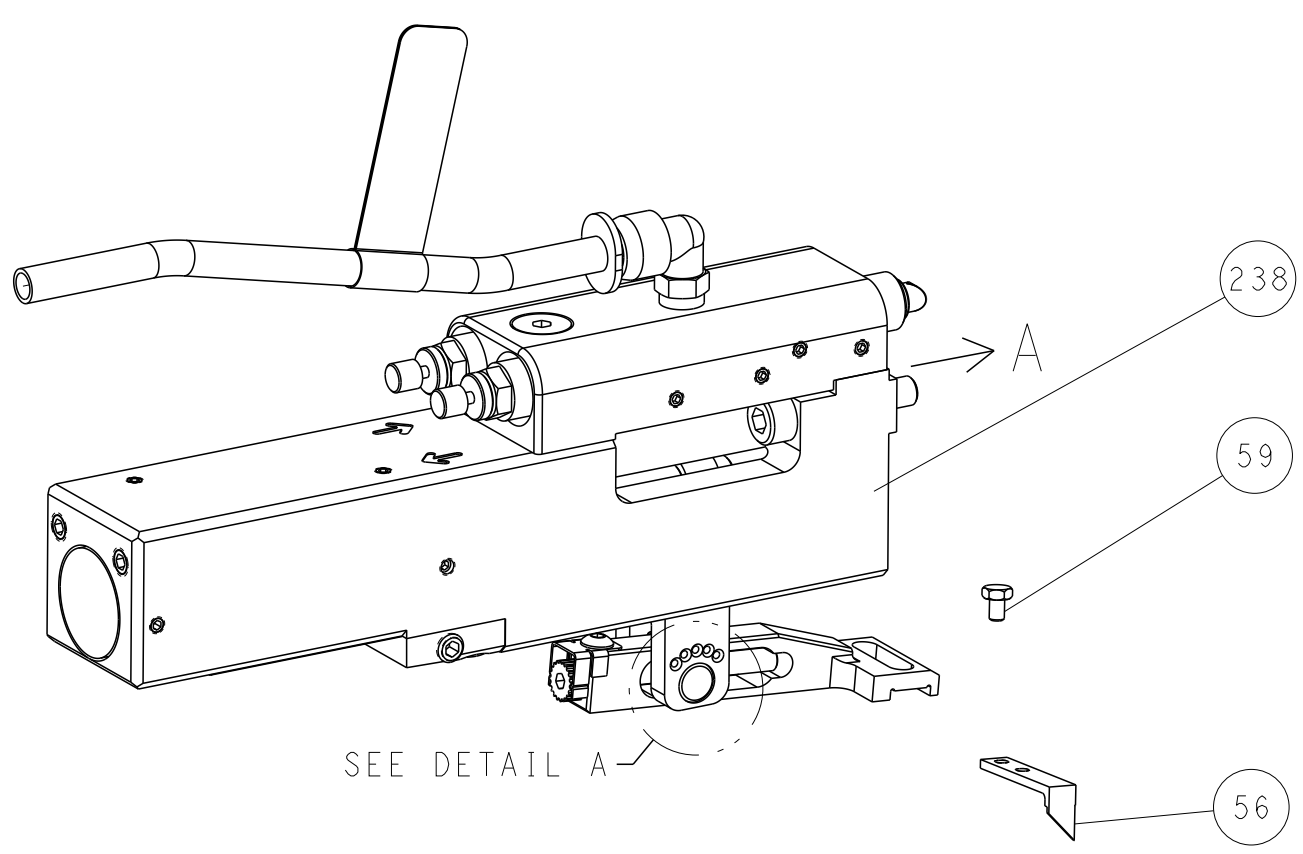
APVD	C. CHEN	12OCT2012	CHK	S. XI	12OCT2012	NAME	TE Connectivity Harrisburg, PA 17105-3608
APVD	J. CRUZ	12OCT2012	PRODUCT SPEC			NAME	Ocean Side Feed Applicator
SIZE	A1	CAGE CODE	00779	DRAWING NO	2151785	RESTRICTED TO	
Customer Accessible Production Drawing				SCALE	1:2	SHEET	3 OF 4

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

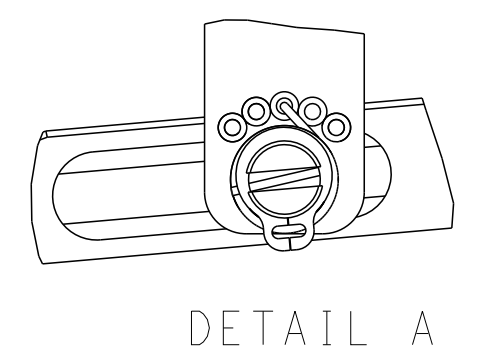
FEED TYPE MECHANICAL



PNEUMATIC

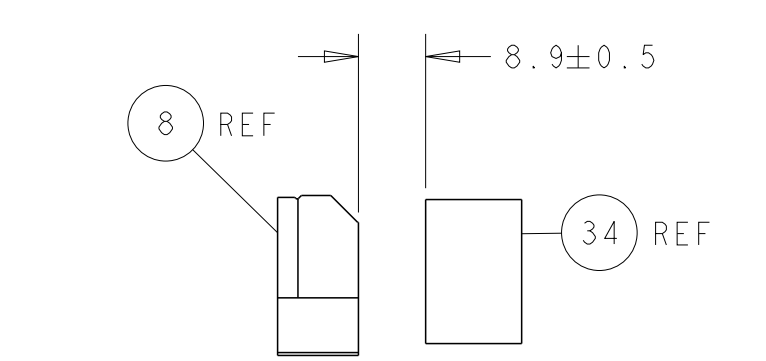
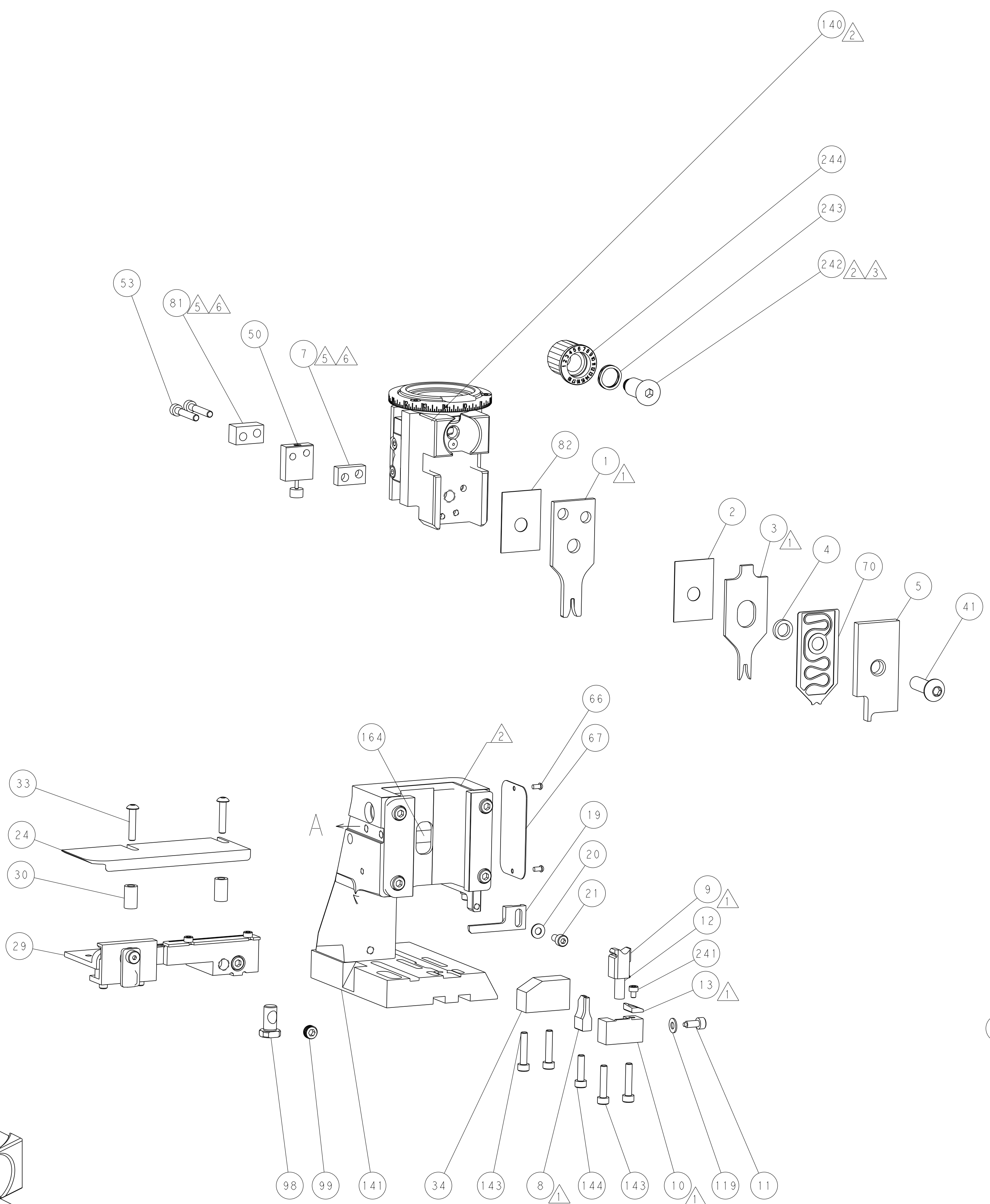
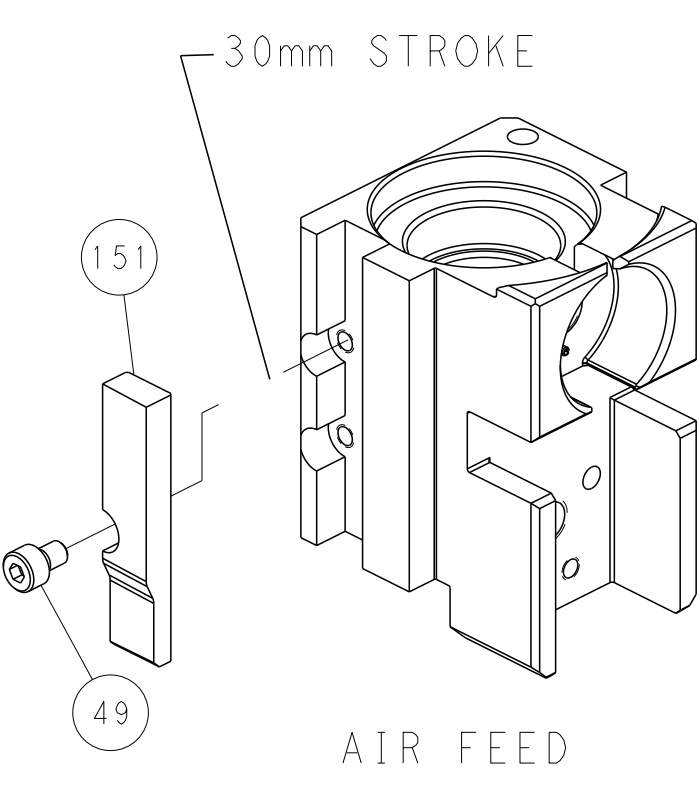
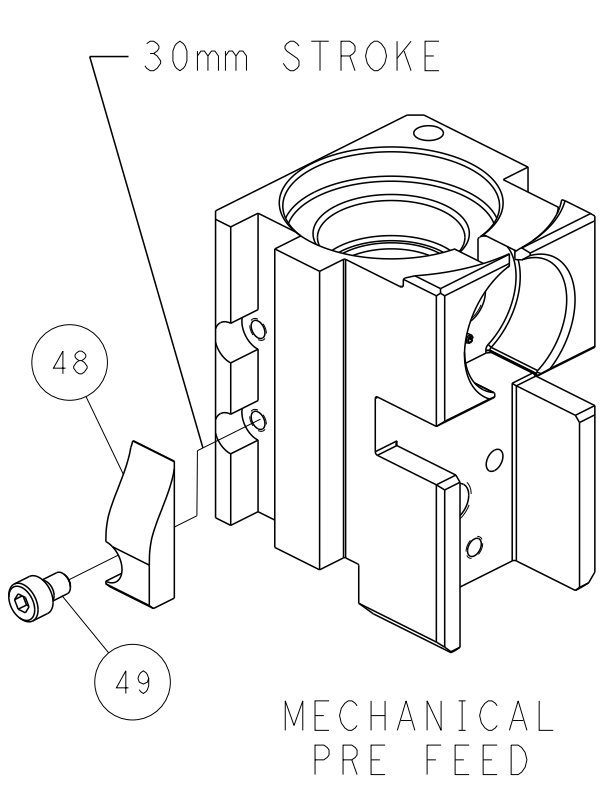
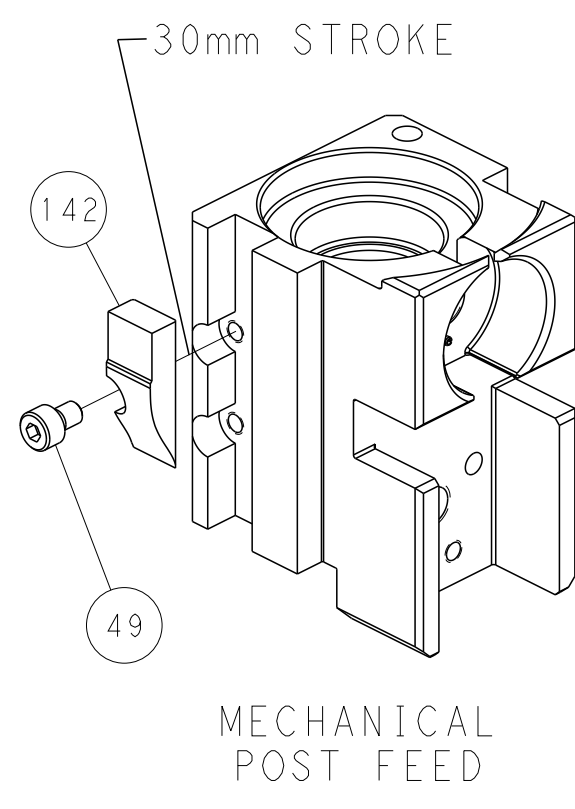


FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)

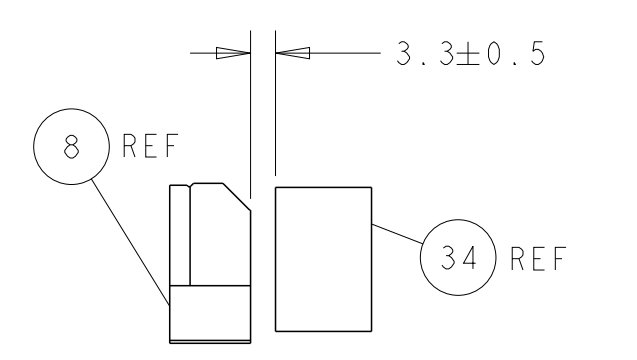


DETAIL A

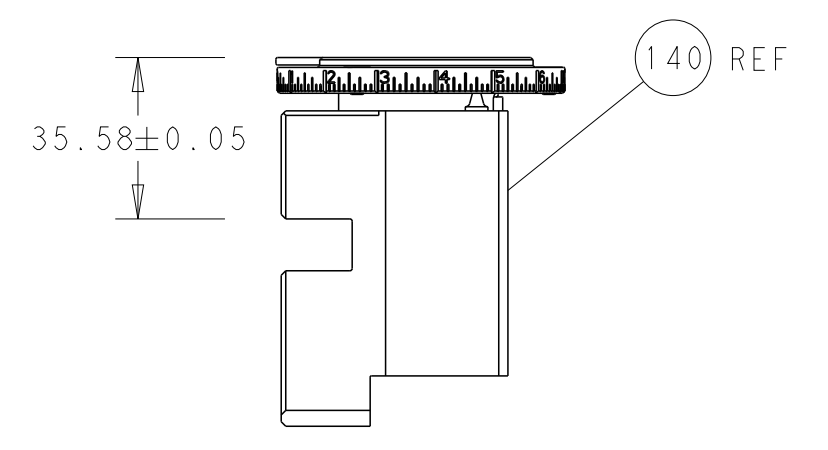
CAM POSITIONS



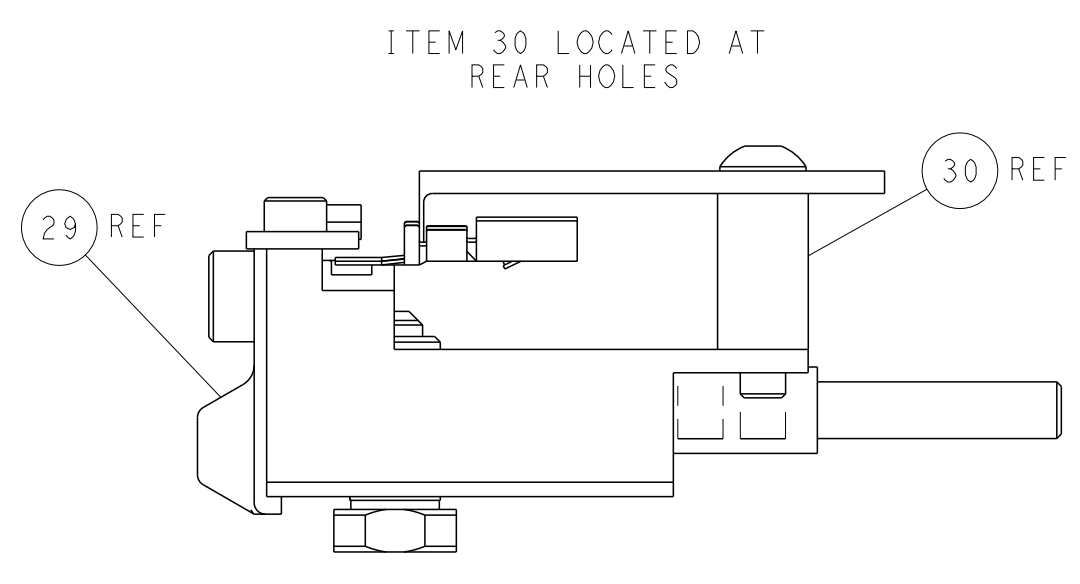
TERMINAL SUPPORT LOCATION FOR PIN TERMINAL 1572784-1 ONLY



TERMINAL SUPPORT LOCATION FOR SOCKET TERMINAL 286751-1 ONLY



RAM SET-UP



FEED TRACK POSITION GUIDE BY INSULATION 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 OUR PRODUCTS. THE INFORMATION CONTAINED HEREIN IS SUBJECT TO CHANGE WITHOUT NOTICE. CONTACT YOUR TYCO REPRESENTATIVE FOR THE LATEST REVISION.</small>		DWN: C. CHEN 12OCT2012 CHK: S. XI 12OCT2012 APVD: J. CRUZ 12OCT2012	TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH	PRODUCT SPEC APPLICATION SPEC WEIGHT SCALE: 1:2	NAME: Ocean Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2151785 SHEET 4 OF 4	RESTRICTED TO: G