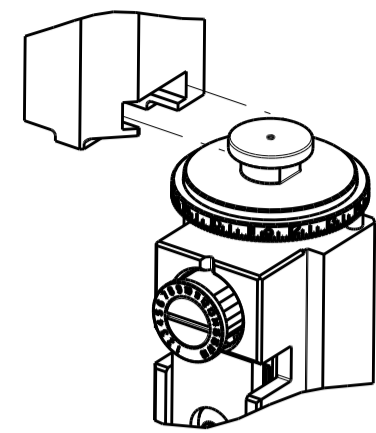


| PART NUMBER | REVISION | DESCRIPTION | FEED TYPE |
|-------------|----------|----------------------------------|------------|
| 2151660-1 | D | FINE CRIMP HEIGHT ADJUST | MECHANICAL |
| 2151660-2 | E | FINE CRIMP HEIGHT ADJUST | PNEUMATIC |
| 7-2151660-1 | D | MECHANICAL AND CRIMP TOOLING KIT | MECHANICAL |
| 7-2151660-2 | E | PNEUMATIC AND CRIMP TOOLING KIT | PNEUMATIC |
| 7-2151660-7 | C | CRIMP TOOLING KIT | - |

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



| APPLICATOR DATA | | |
|-----------------|----------------|------|
| CRIMP | SIZE | TYPE |
| WIRE | 1.06 mm [.042] | F |
| INSUL | 1.40 mm [.055] | F |

APPLICATOR INSTRUCTIONS 408-35042

| TERMINAL DATA: HARTING TERMINAL | | TE CRIMP SPECIFICATION | |
|--|------|------------------------------|--|
| TERMINAL NAME: D-SUB, STAMPED MALE, STAMPED FEMALE | | | |
| WIRE STRIP LENGTH | | INSULATION DIAMETER RANGE | |
| 2.06-2.07 mm [.081-.081 IN] | | Ø0.50-0.75 mm [.020-.030 IN] | |
| TERMINAL APPLICATION SPECIFICATION | NONE | | |

| TERMINALS APPLIED | | | |
|-------------------|------------------|-------------|------------------|
| TE TERMINAL | HARTING TERMINAL | TE TERMINAL | HARTING TERMINAL |
| 2113271-1 | 09670007156 | 2113272-1 | 09670007256 |
| 2113271-2 | 09670007157 | 2113272-2 | 09670007257 |
| 2113271-3 | 09670007158 | 2113272-3 | 09670007258 |
| 2113271-4 | 09670007146 | 2113272-4 | 09670007246 |
| 2113271-5 | 09670007147 | 2113272-5 | 09670007247 |
| 2113271-6 | 09670007148 | 2113272-6 | 09670007248 |
| 2113271-7 | 09670007166 | 2113272-7 | 09670007266 |
| 2113271-8 | 09670007167 | 2113272-8 | 09670007267 |
| 2113271-9 | 09670007168 | 2113272-9 | 09670007268 |

| WIRE SIZE | CRIMP HEIGHT mm [INCH] | CRIMP HEIGHT REFERENCE SETTING |
|----------------------|----------------------------|--------------------------------|
| 0.10 or 0.14 or 0.25 | 0.75+/-0.05 [.030+/-0.002] | 7.8 |

- 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. 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 | | | |
|-----|------|---------------|-----------|-----|------|
| P | LTN | DESCRIPTION | DATE | OWN | APVD |
| B1 | | ECR-13-015972 | 12OCT2013 | YY | UG |
| C | | ECR-16-008051 | 03JUN2016 | JH | TE |
| D | | ECR-19-001786 | 02FEB2019 | TB | CT |
| E | | ECR-19-011464 | 24JUL2019 | FJ | TE |

| | | | | | | | | |
|---|-----|-----|-----|-----|-------------|-------------------------------------|-------------|---------|
| - | 1 | - | 1 | - | 2119641-1 | FEED CAM, AIR FEED | 248 | |
| - | 1 | 1 | 1 | 1 | 2119082-1 | 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 | 2844908-1 | SCREW, LOCKING | 99 | |
| - | 1 | 1 | 1 | 1 | 2844907-1 | POST, LOCKING | 98 | |
| - | 1 | 1 | 1 | 1 | 455888-3 | SPACER, CRIMPER | 82 | |
| - | 1 | 1 | 1 | 1 | 1803607-3 | DOCUMENTATION PACKAGE | 71 | |
| - | 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 | 1-2168083-0 | SCR, SKT HD CAP, RoHS, M4 X 10 | 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 | 3-1752356-4 | SUPPORT, TERMINAL | 34 | |
| - | 2 | 2 | 2 | 2 | 2079383-5 | SCR, BHSC, RoHS (M4 X 20) | 33 | |
| - | 2 | 2 | 2 | 2 | 2-2844962-3 | 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 | |
| - | 2 | 2 | 2 | 2 | 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 | 1633861-1 | SHEAR, FLOATING | 9 | |
| - | 1 | 2 | 2 | 1 | 1633916-3 | ANVIL, COMBINATION | 8 | |
| - | - | - | - | - | - | - | 7 | |
| - | - | - | - | - | - | - | 6 | |
| - | 1 | 1 | 1 | 1 | 2119757-8 | DEPRESSOR, SHEAR | 5 | |
| - | 1 | 1 | 1 | 1 | 3-238011-7 | BLOCK, CRIMPER SPACER | 4 | |
| - | 1 | 2 | 2 | 1 | 7-1803187-2 | CRIMPER, INSULATION F | 3 | |
| - | 1 | 1 | 1 | 1 | 455888-5 | SPACER, CRIMPER | 2 | |
| - | 1 | 2 | 2 | 1 | 456401-5 | CRIMPER, WIRE .042 F PREMIUM | 1 | |
| - | 77 | -72 | -71 | -2 | -1 | PART NO | DESCRIPTION | ITEM NO |

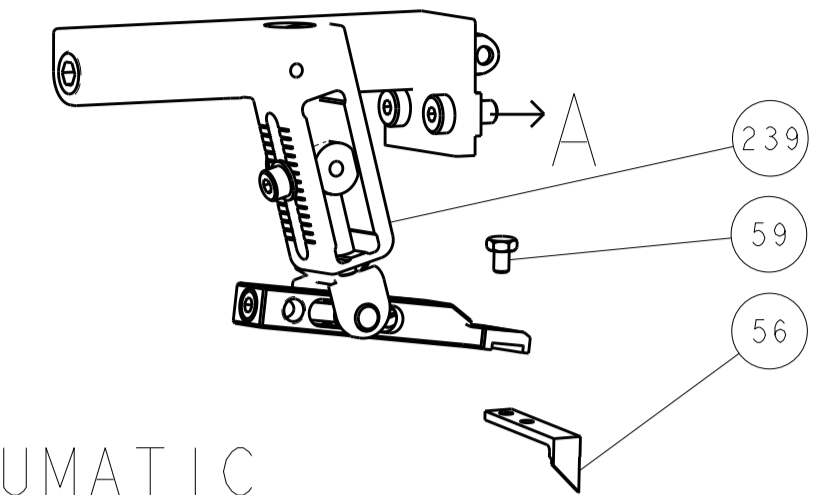
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

| DIMENSIONS: | | TOLERANCES UNLESS OTHERWISE SPECIFIED: | | MATERIAL: | | FINISH: | | WEIGHT: | | SCALE: | | SHEET: | | REV: | |
|-------------|---------|--|---------|-----------|---------|---------|--------|---------|--|--------|-------|--------|----|------|---|
| mm | 0 PLC ± | 1 PLC ± | 2 PLC ± | 3 PLC ± | 4 PLC ± | ANGLES | FINISH | | | A1 | 00779 | 1 | of | 4 | E |

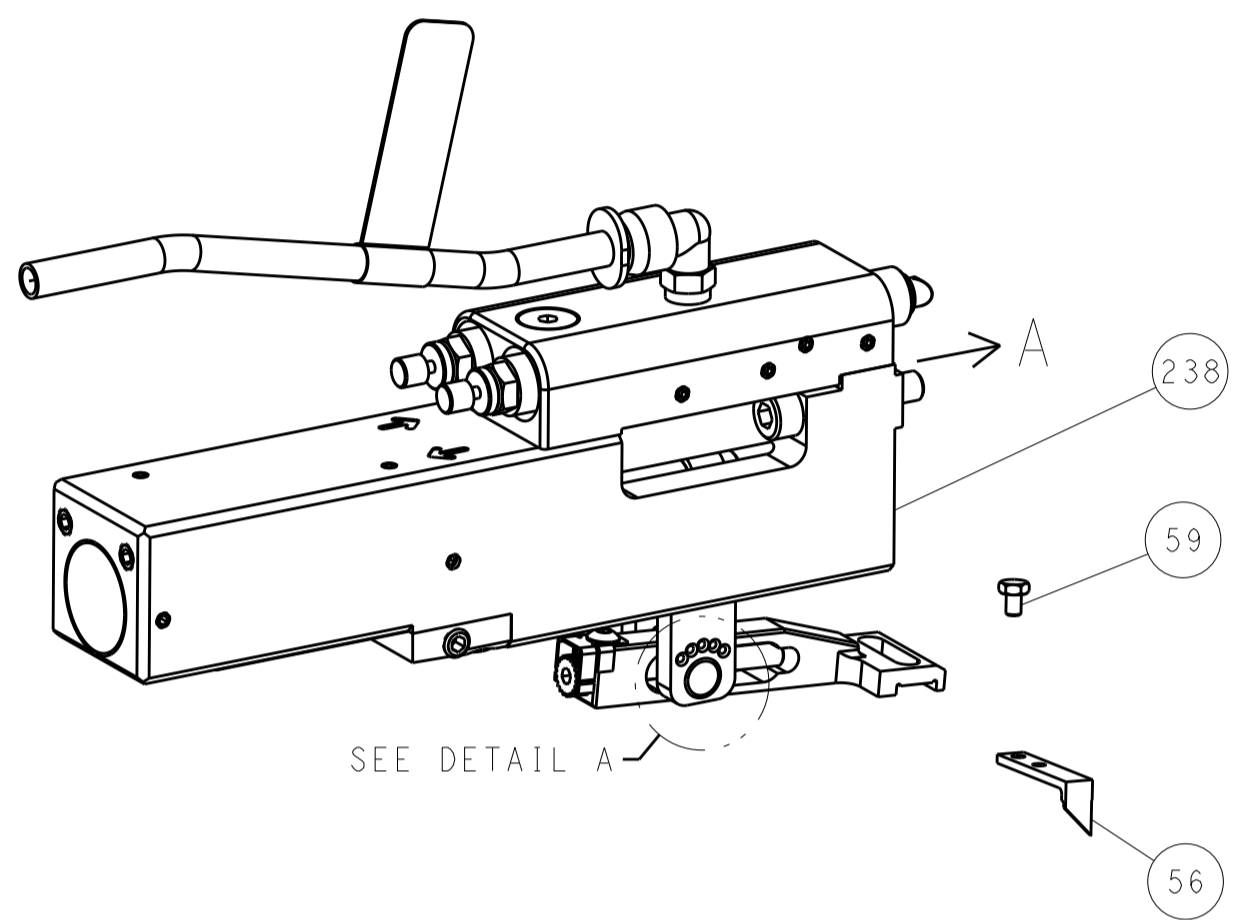
Customer Accessible Production Drawing

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

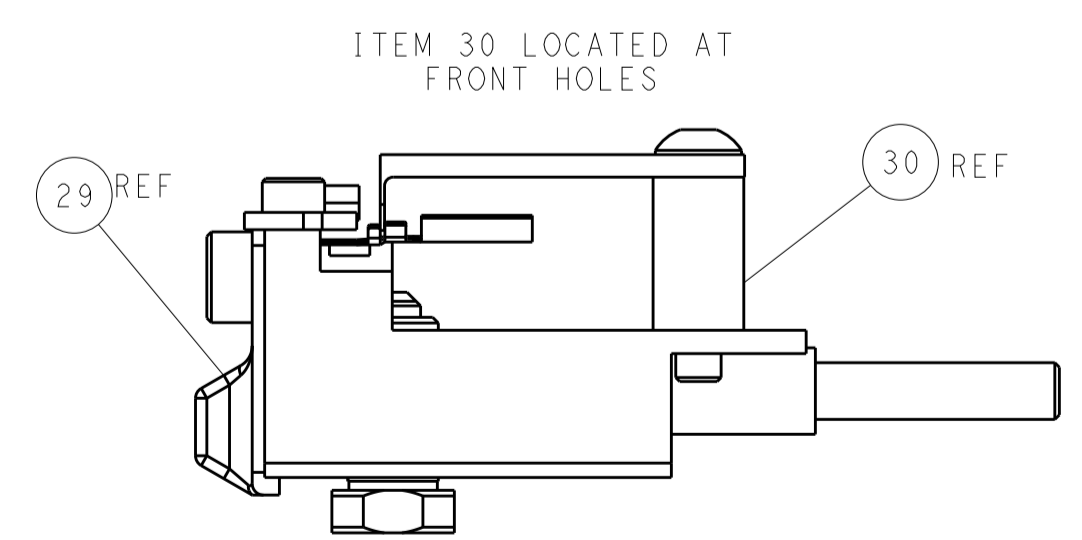
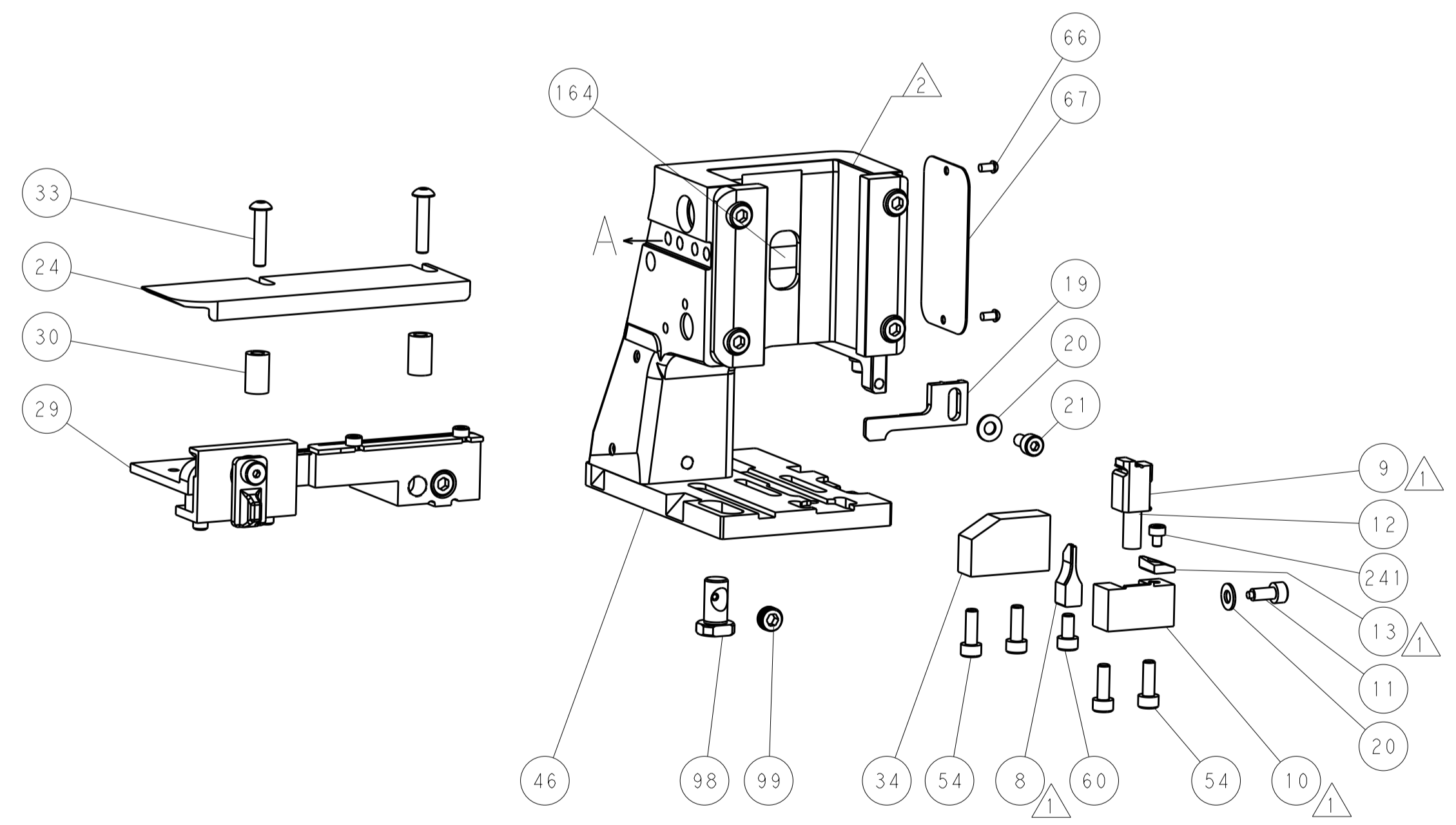
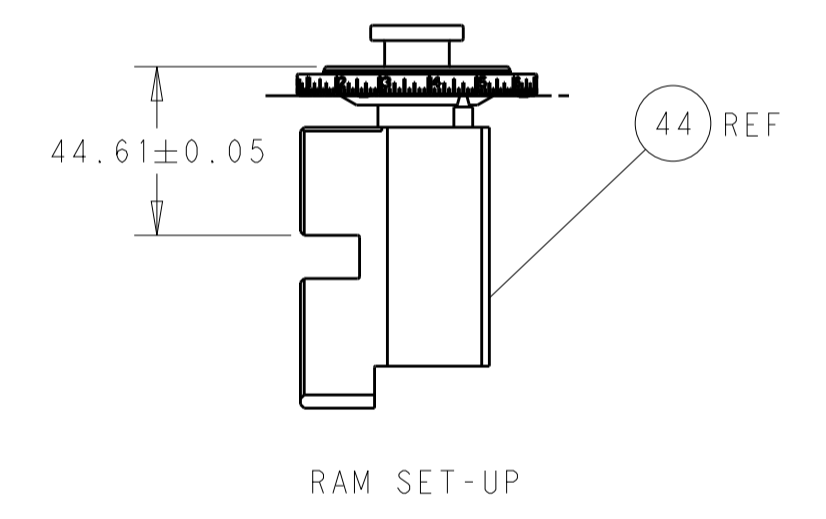
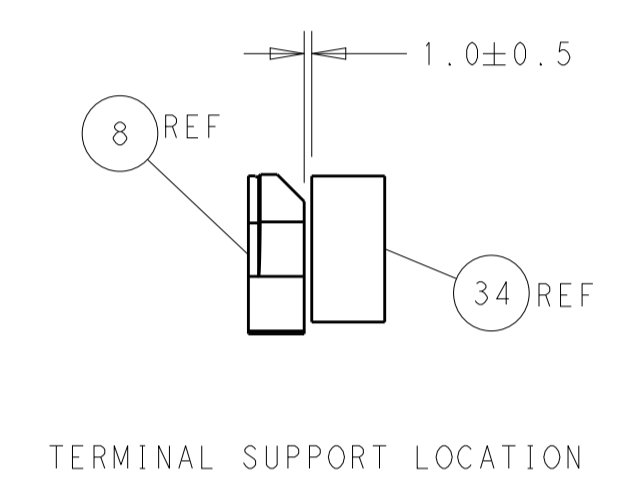
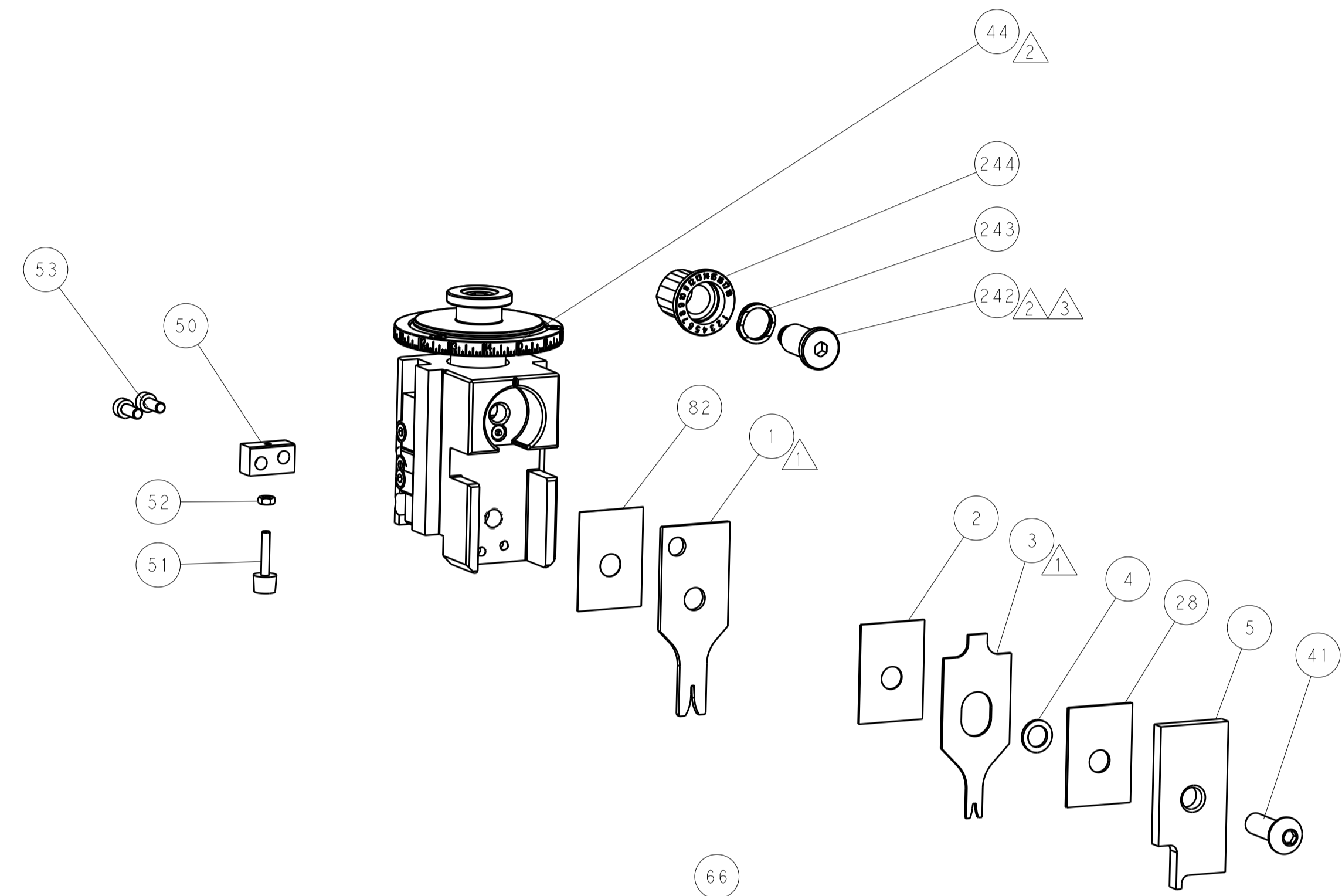
FEED TYPE MECHANICAL



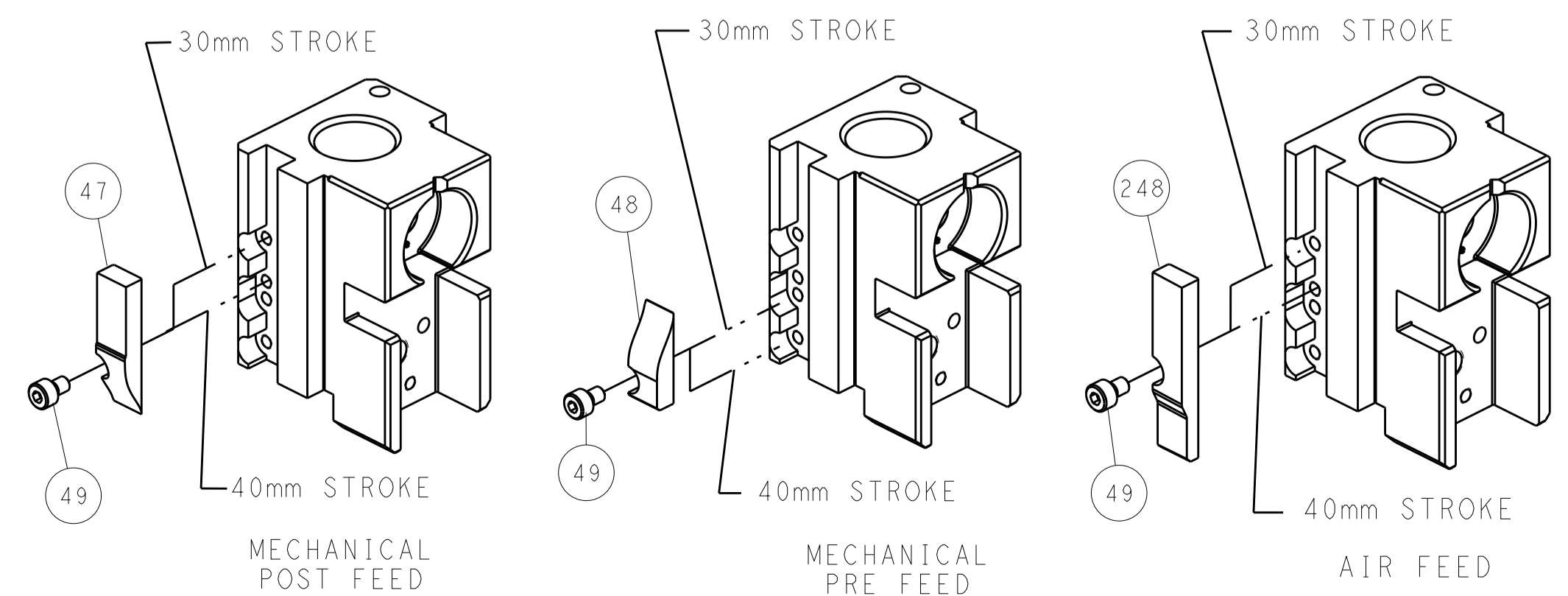
PNEUMATIC



FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



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: STAKEM 30JULY2012 | | TE Connectivity | |
| mm | 0 PLC ± | 1 PLC ± | 2 PLC ± | 3 PLC ± | 4 PLC ± | Harrisburg, PA 17105-3608 | |
| MATERIAL: | | FINISH: | | APVD: T. ELBIN 30JULY2012 | | NAME: Ocean Side Feed Applicator | |
| Customer Accessible Production Drawing | | SCALE: 1:2 | | SHEET 2 OF 4 | | REV E | |

| PART NUMBER | REVISION | DESCRIPTION | FEED TYPE |
|-------------|----------|--------------------------|------------|
| 2-2151660-1 | D | FINE CRIMP HEIGHT ADJUST | MECHANICAL |
| 2-2151660-2 | E | FINE CRIMP HEIGHT ADJUST | PNEUMATIC |
| 7-2151660-7 | C | CRIMP TOOLING KIT | - |

PACIFIC VERSION TERMINATOR
 INTERFACE ADAPTER



| APPLICATOR DATA | | |
|-----------------|----------------|------|
| CRIMP | SIZE | TYPE |
| WIRE | 1.06 mm [.042] | F |
| INSUL | 1.40 mm [.055] | F |

APPLICATOR INSTRUCTIONS
 408-35042

| TERMINAL DATA: HARTING TERMINAL TE CRIMP SPECIFICATION | |
|--|---|
| TERMINAL NAME: D-SUB, STAMPED MALE, STAMPED FEMALE | |
| WIRE STRIP LENGTH 2.06-2.07 mm [.081-.081 IN] | INSULATION DIAMETER RANGE Ø0.50-0.75 mm [.020-.030 IN] |
| TERMINAL APPLICATION SPECIFICATION NONE | |

| TERMINALS APPLIED | | | |
|-------------------|------------------|-------------|------------------|
| TE TERMINAL | HARTING TERMINAL | TE TERMINAL | HARTING TERMINAL |
| 2113271-1 | 09670007156 | 2113272-1 | 09670007256 |
| 2113271-2 | 09670007157 | 2113272-2 | 09670007257 |
| 2113271-3 | 09670007158 | 2113272-3 | 09670007258 |
| 2113271-4 | 09670007146 | 2113272-4 | 09670007246 |
| 2113271-5 | 09670007147 | 2113272-5 | 09670007247 |
| 2113271-6 | 09670007148 | 2113272-6 | 09670007248 |
| 2113271-7 | 09670007166 | 2113272-7 | 09670007266 |
| 2113271-8 | 09670007167 | 2113272-8 | 09670007267 |
| 2113271-9 | 09670007168 | 2113272-9 | 09670007268 |

| WIRE SIZE | CRIMP HEIGHT mm [INCH] | CRIMP HEIGHT REFERENCE SETTING |
|----------------------|----------------------------|--------------------------------|
| 0.10 or 0.14 or 0.25 | 0.75+/-0.05 [.030+/-0.002] | 7.8 |



- 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. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.

| LOC | DIST | REV | DATE | BY | APPV |
|-----|------|-----|------|----|------|
| A | 66 | - | - | - | - |

| REV | DATE | BY | APPV | DESCRIPTION | ITEM NO |
|-----|------|-----|-------------|-------------------------------------|---------|
| - | 1 | 1 | 2119082-1 | 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 | 2844908-1 | SCREW, LOCKING | 99 |
| - | 1 | 1 | 2844907-1 | POST, LOCKING | 98 |
| - | 1 | 1 | 455888-3 | SPACER, CRIMPER | 82 |
| - | 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 | 5-18022-5 | SCR, HEX HD CAP, M4 X 6.0 | 59 |
| - | 1 | 1 | 1338685-1 | PAWL, FEED | 56 |
| - | 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 | 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 | 3-1752356-4 | SUPPORT, TERMINAL | 34 |
| - | 2 | 2 | 2079383-5 | SCR, BHSC, RoHS (M4 X 20) | 33 |
| - | 2 | 2 | 2-2844962-3 | 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 |
| - | 2 | 2 | 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 | 1633861-1 | SHEAR, FLOATING | 9 |
| - | 1 | 1 | 1633916-3 | ANVIL, COMBINATION | 8 |
| - | - | - | - | - | 7 |
| - | - | - | - | - | 6 |
| - | 1 | 1 | 2119757-8 | DEPRESSOR, SHEAR | 5 |
| - | 1 | 1 | 3-238011-7 | BLOCK, CRIMPER SPACER | 4 |
| - | 1 | 1 | 7-1803187-2 | CRIMPER, INSULATION F | 3 |
| - | 1 | 1 | 455888-5 | SPACER, CRIMPER | 2 |
| - | 1 | 1 | 456401-5 | CRIMPER, WIRE .042 F PREMIUM | 1 |

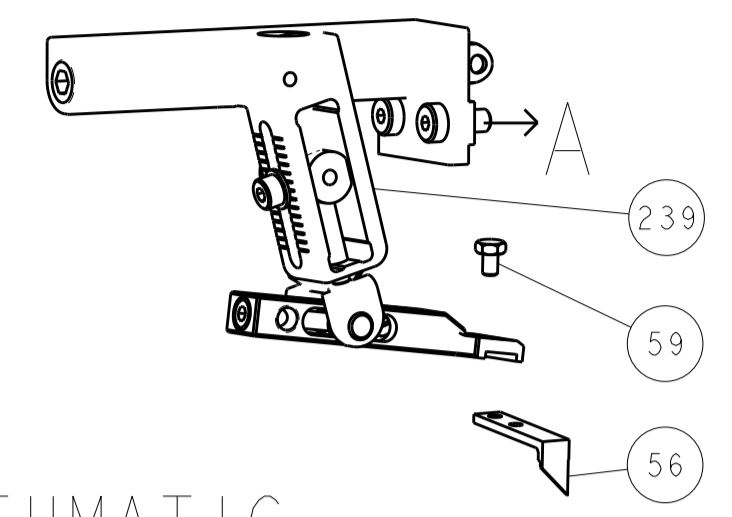
***WARNING**
 ON INSTALLATION, SET WIRE DISC TO CRIMP HEIGHT REFERENCE SETTING FOR LARGEST WIRE SIZE. CRIMP HEIGHT REFERENCE SETTINGS GREATER THAN THE VALUE SHOWN MAY CAUSE DAMAGE TO THE CRIMP TOOLING. REFER TO THE INSTRUCTION SHEET FOR PROPER SETUP AND ADJUSTMENTS.

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

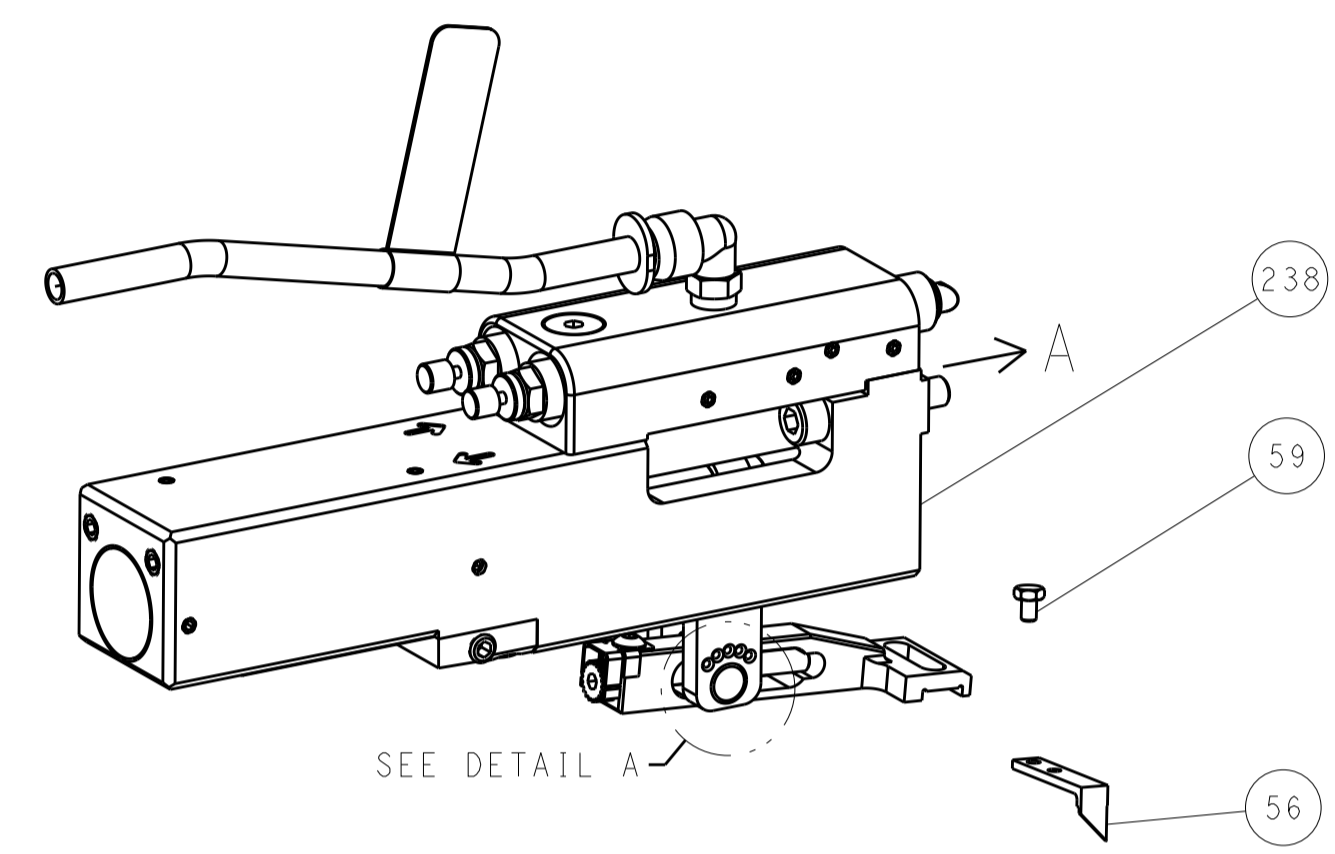
| | | | | | | | |
|-----------------------|--|---|--|--|--|--|--|
| DIMENSIONS: mm | | TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH | | DWG: STAKEM 30JULY2012 CHK: G. BAILEY 30JULY2012 APVD: T. ERLIN 30JULY2012 | | NAME: Ocean Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2151660 SCALE: 1:2 SHEET: 3 OF 4 REV: E | |
| MATERIAL: - | | FINISH: - | | WEIGHT: - | | RESTRICTED TO: - | |

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

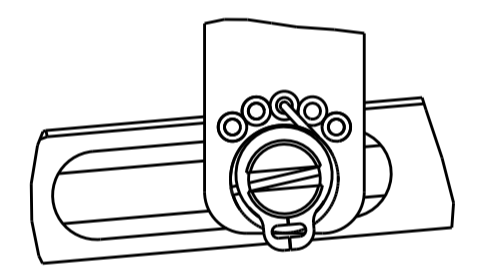
FEED TYPE MECHANICAL



PNEUMATIC

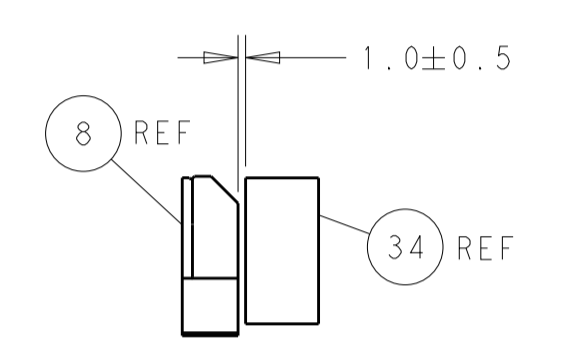
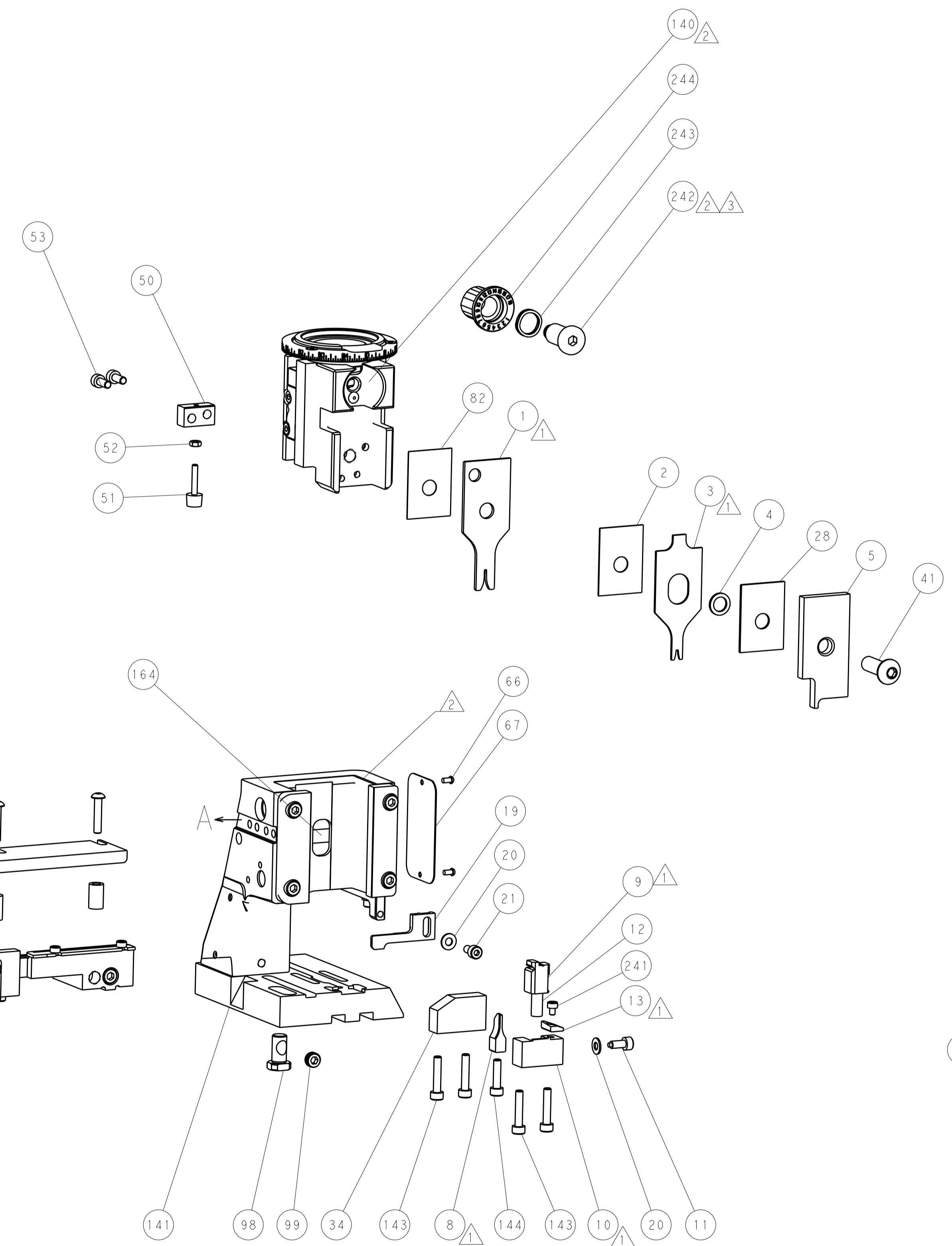
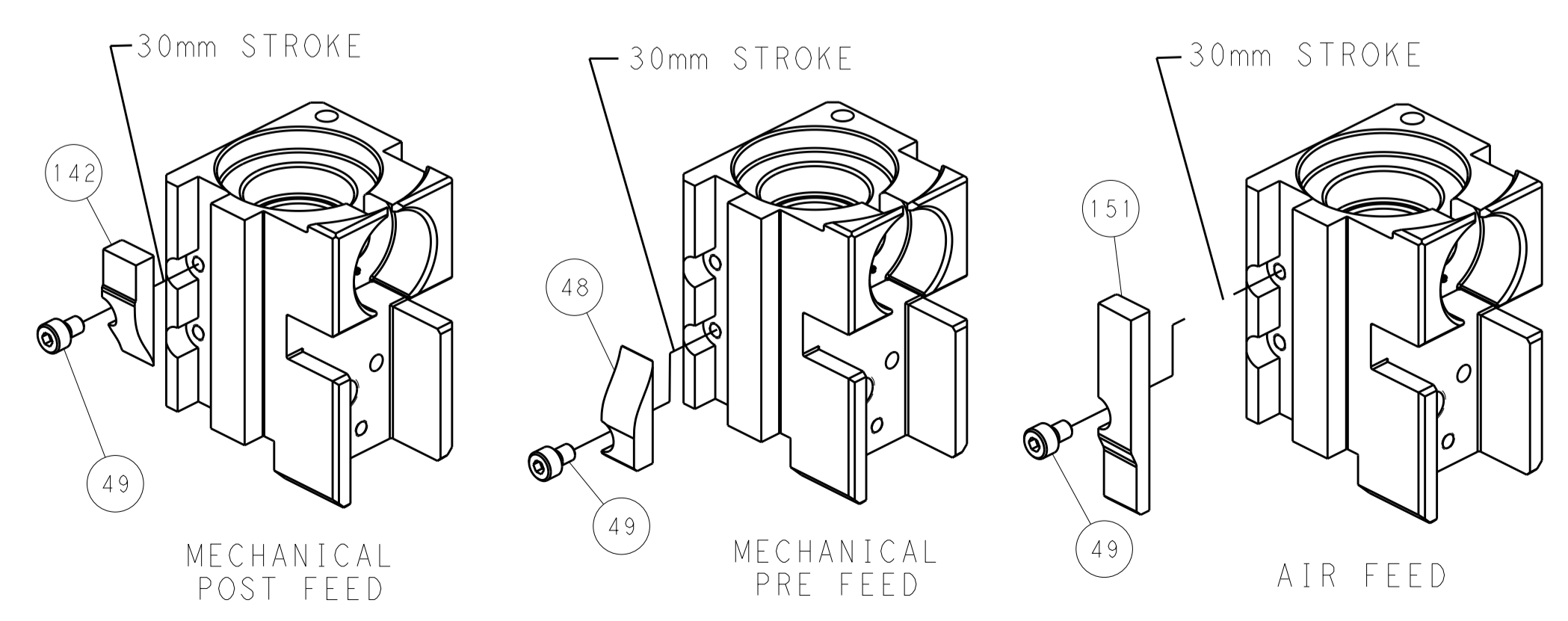


FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)

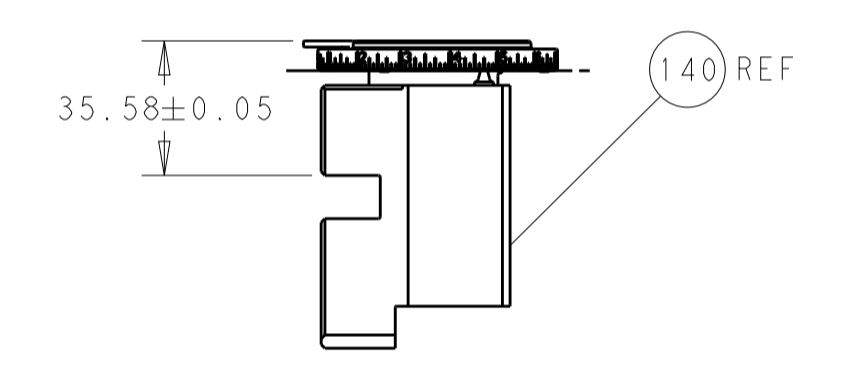


DETAIL A

CAM POSITIONS

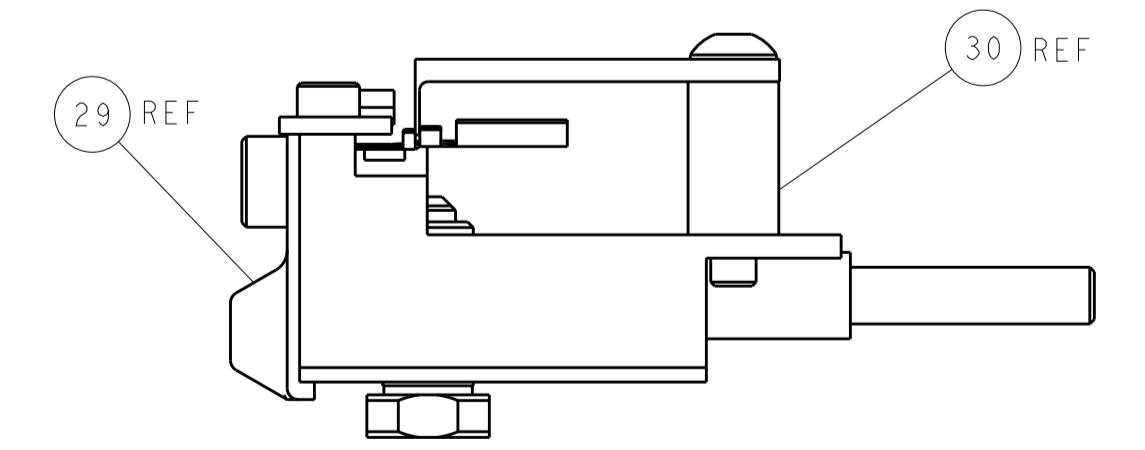


TERMINAL SUPPORT LOCATION



RAM SET-UP

ITEM 30 LOCATED AT FRONT HOLES



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)

| | | | | | | | |
|-------------|---------|--|---------|---------------------------|---------|--|---------------------------|
| DIMENSIONS: | | TOLERANCES UNLESS OTHERWISE SPECIFIED: | | DWN: STAKEM 30JULY2012 | | TE Connectivity | |
| mm | 0 PLC ± | 1 PLC ± | 2 PLC ± | 3 PLC ± | 4 PLC ± | 5 PLC ± | Harrisburg, PA 17105-3608 |
| MATERIAL: | | FINISH: | | CHK: G. BAILEY 30JULY2012 | | NAME: Ocean Side Feed Applicator | |
| | | | | APVD: T. ELBIN 30JULY2012 | | SIZE: CAGE CODE: DRAWING NO: RESTRICTED TO | |
| | | | | PRODUCT SPEC: | | A1 00779 ©=2151660 | |
| | | | | APPLICATION SPEC: | | Customer Accessible Production Drawing | |
| | | | | WEIGHT: | | SCALE: 1:2 SHEET 4 OF 4 REV E | |