

| PART NUMBER | REVISION | DESCRIPTION | FEED TYPE |
|-------------|----------|----------------------------------|------------|
| 2151852-1 | E | FINE CRIMP HEIGHT ADJUST | MECHANICAL |
| 2151852-2 | E | FINE CRIMP HEIGHT ADJUST | PNEUMATIC |
| 7-2151852-1 | E | MECHANICAL AND CRIMP TOOLING KIT | MECHANICAL |
| 7-2151852-2 | E | PNEUMATIC AND CRIMP TOOLING KIT | PNEUMATIC |
| 7-2151852-7 | A | CRIMP TOOLING KIT | - |

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



| APPLICATOR DATA | | |
|-----------------|----------------|------|
| CRIMP | SIZE | TYPE |
| WIRE | 2.79 mm [.110] | F |
| INSUL | 4.06 mm [.160] | F |

APPLICATOR INSTRUCTIONS 408-35042

| TERMINAL DATA: TE TERMINAL | | TE CRIMP SPECIFICATION | |
|--|-------------|------------------------------|-------------|
| TERMINAL NAME: GRACE INERTIA CONNECTOR 6.2MM PITCH | | | |
| WIRE STRIP LENGTH | | INSULATION DIAMETER RANGE | |
| 4.60-5.20 mm [.181-.205 IN] | | Ø2.00-3.75 mm [.079-.148 IN] | |
| TERMINAL APPLICATION SPECIFICATION | 114-5356 | | |
| TERMINALS APPLIED ⁵ | | | |
| TE TERMINAL | TE TERMINAL | TE TERMINAL | TE TERMINAL |
| 1746971-1 | 1746973-1 | | |

| WIRE SIZE | CRIMP HEIGHT mm [INCH] | CRIMP HEIGHT REFERENCE SETTING |
|-----------|----------------------------|--------------------------------|
| 14 AWG | 1.79+/-0.05 [.070+/- .002] | 6.7 |
| 16 AWG | 1.54+/-0.05 [.061+/- .002] | 9.3 |

- 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.
- TERMINAL LUBRICANT IS RECOMMENDED.
- 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)

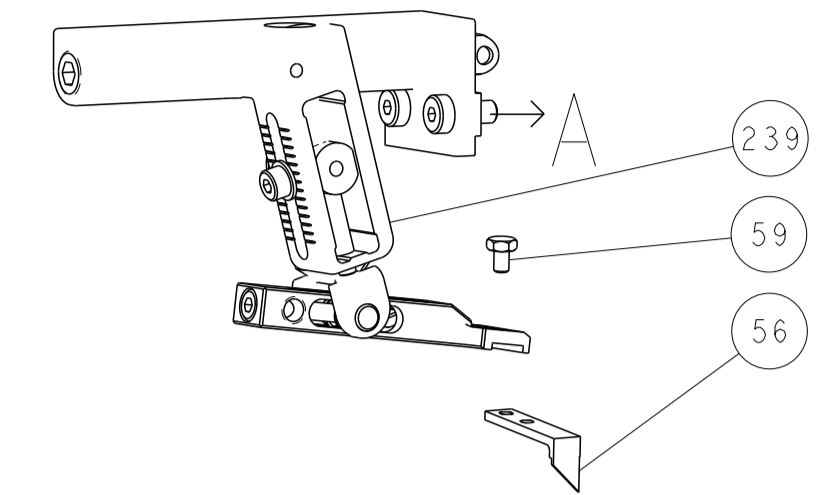
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|-----|------|-----------|-----|---------------|-----------|-----|------|
| A | 66 | P | LTN | DESCRIPTION | DATE | OWN | APVD |
| | | B | | ECR-13-019053 | 06DEC2013 | KH | TE |
| | | C | | ECR-17-007157 | 17MAY2017 | TB | TE |
| | | D | | ECR-19-004322 | 20MAR2019 | LG | TE |
| | | E | | ECR-22-145237 | 6JUL2022 | LG | JAH |

| | | | | | | | | |
|--------------|-----|-----|-----|-----|-------------|-------------------------------------|-------------------------------|---|
| - | 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 | |
| ³ | - | 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 | - | - | 2119580-1 | MECHANICAL FEED ASSEMBLY | 239 | |
| - | 1 | - | 1 | - | 2844940-1 | AIR FEED MODULE | 238 | |
| - | REF | REF | REF | REF | 994970-2 | COUNTER, MAGNETIC | 164 | |
| ⁵ | - | 1 | 1 | 1 | 1-18028-2 | WASHER, FLAT, REG M4 | 119 | |
| - | 1 | 1 | 1 | 1 | 2119955-1 | ASSY, LUBRICATOR, SIDE FEED | 113 | |
| - | 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 | 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 | - | - | 2119652-1 | FEED CAM, PRE FEED | 48 | |
| - | - | 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 | 1752356-3 | SUPPORT, TERMINAL | 34 | |
| - | 2 | 2 | 2 | 2 | 2079383-5 | SCR, BHSC, RoHS (M4 X 20) | 33 | |
| - | 2 | 2 | 2 | 2 | 3-2844962-0 | 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 | 1803095-6 | FLOATING SHEAR, FRONT | 9 | |
| ¹ | 1 | 2 | 2 | 1 | 1 | 3-1633134-5 | ANVIL, COMBINATION .110 | 8 |
| - | - | - | - | - | - | - | 7 | |
| - | - | - | - | - | - | - | 6 | |
| - | 1 | 1 | 1 | 1 | 2119757-6 | DEPRESSOR, SHEAR | 5 | |
| - | 1 | 1 | 1 | 1 | 238011-4 | BLOCK, CRIMPER SPACER | 4 | |
| ¹ | 1 | 2 | 2 | 1 | 1 | 1-1633961-4 | CRIMPER, INSULATION F PREMIUM | 3 |
| - | 1 | 1 | 1 | 1 | 455888-4 | SPACER, CRIMPER | 2 | |
| ¹ | 1 | 2 | 2 | 1 | 1 | 456408-6 | CRIMPER, WIRE PREMIUM | 1 |

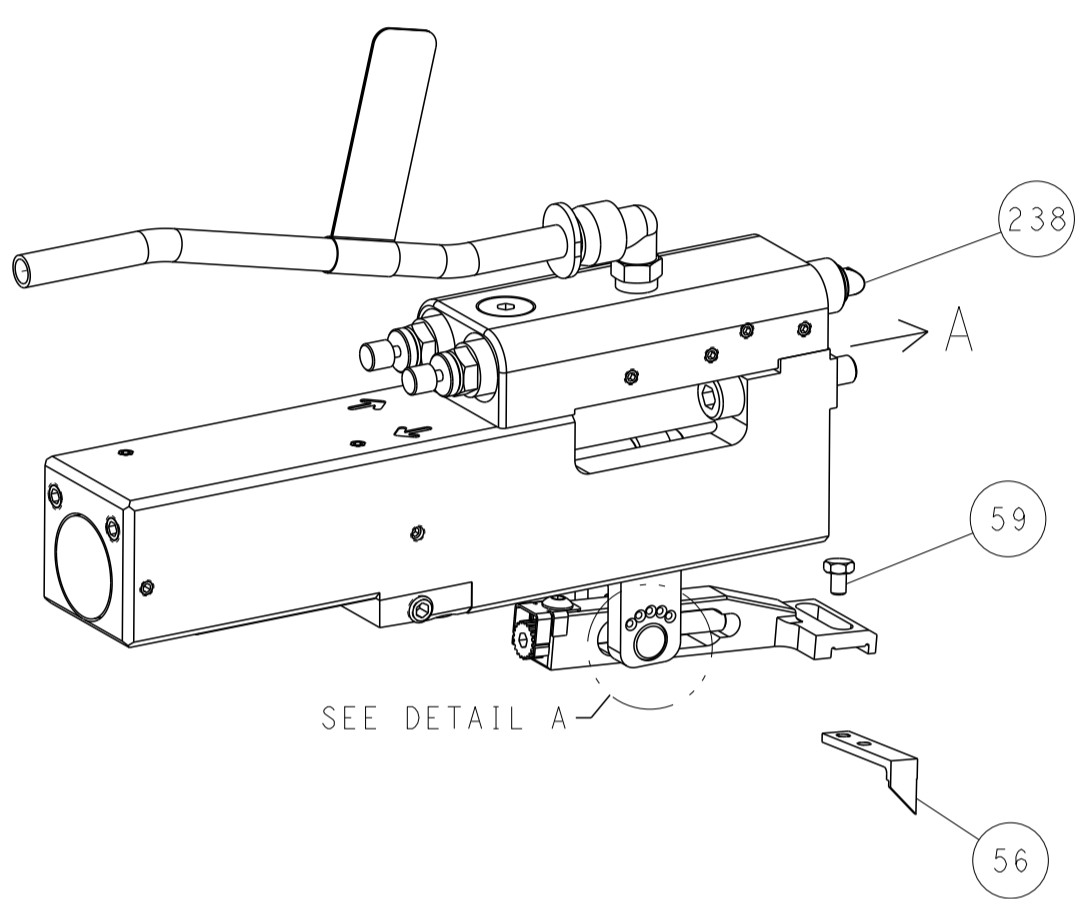
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|-------------|---------|--|----------|--------|-----------|-----------|--|--|
| mm | 0 PLC ± | 1 PLC ± | 2 PLC ± | Y. YIN | G. BAILEY | 27DEC2012 | Ocean Side Feed Applicator | |
| | 3 PLC ± | 4 PLC ± | ANGLES ± | APVD | S. XI | 27DEC2012 | Customer Accessible Production Drawing | |
| MATERIAL | FINISH | WEIGHT | SCALE | SHEET | | REV | E | |
| | | | 1:2 | 1 OF 4 | | | | |

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

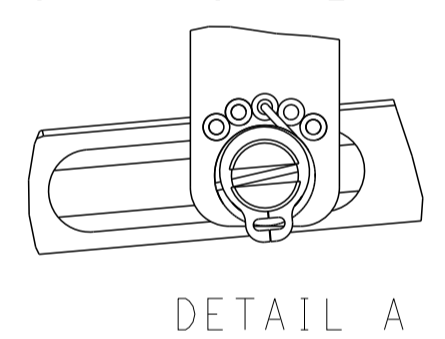
FEED TYPE MECHANICAL



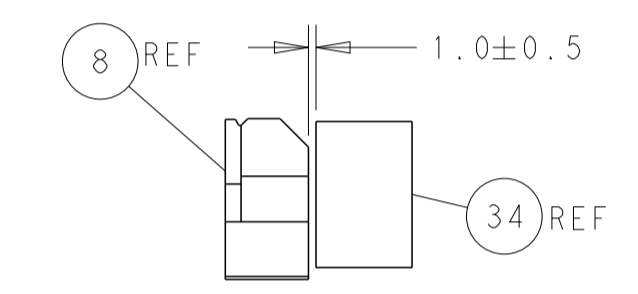
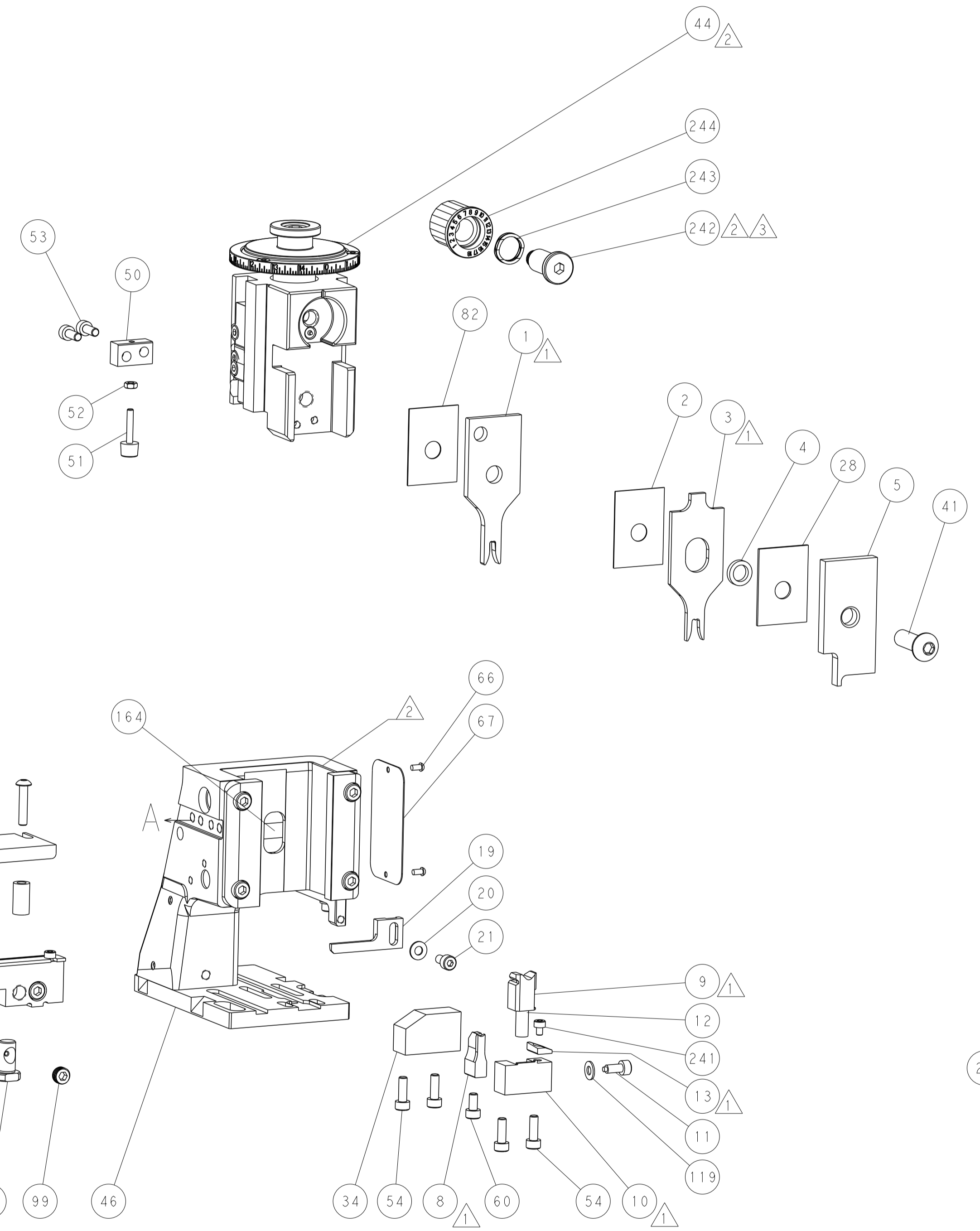
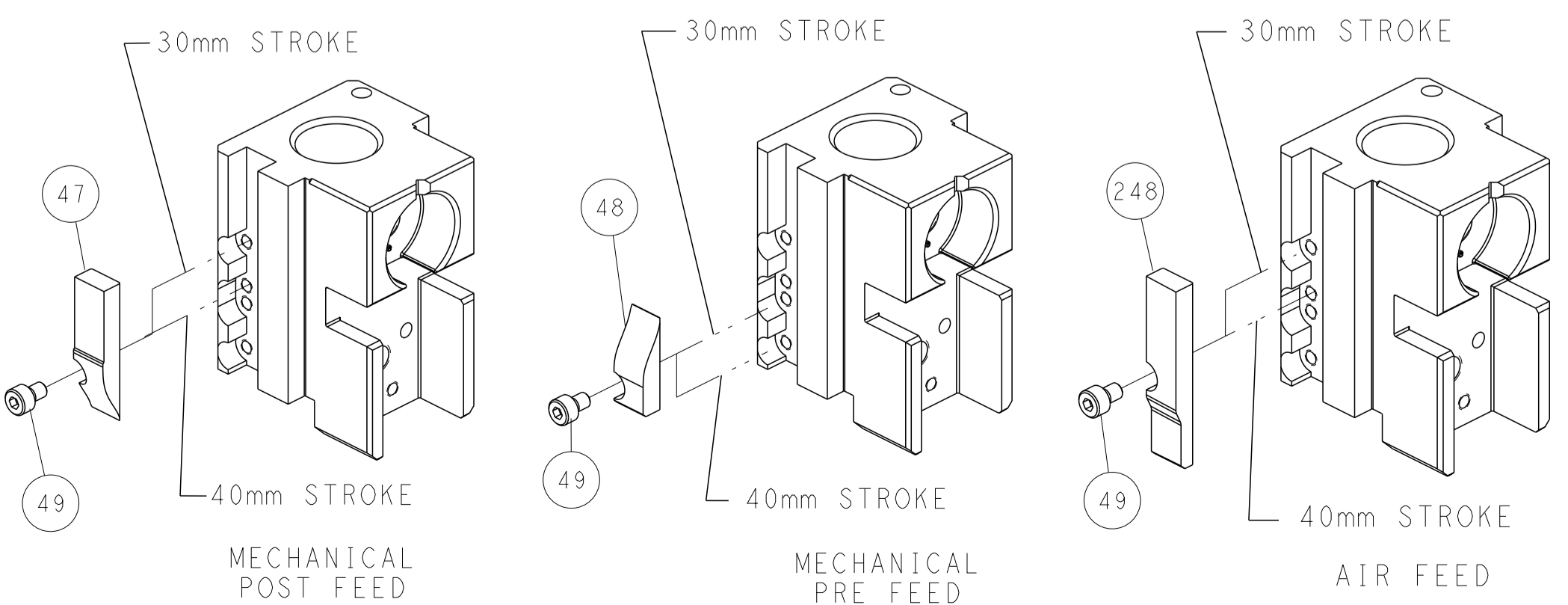
PNEUMATIC



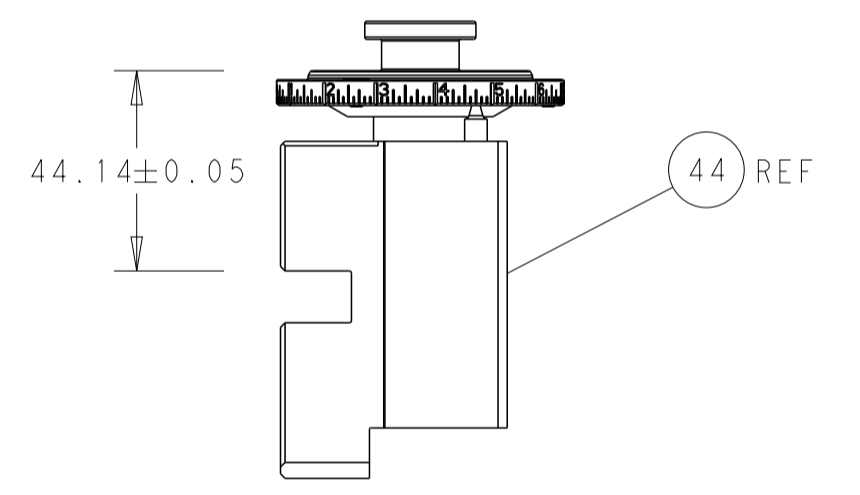
FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



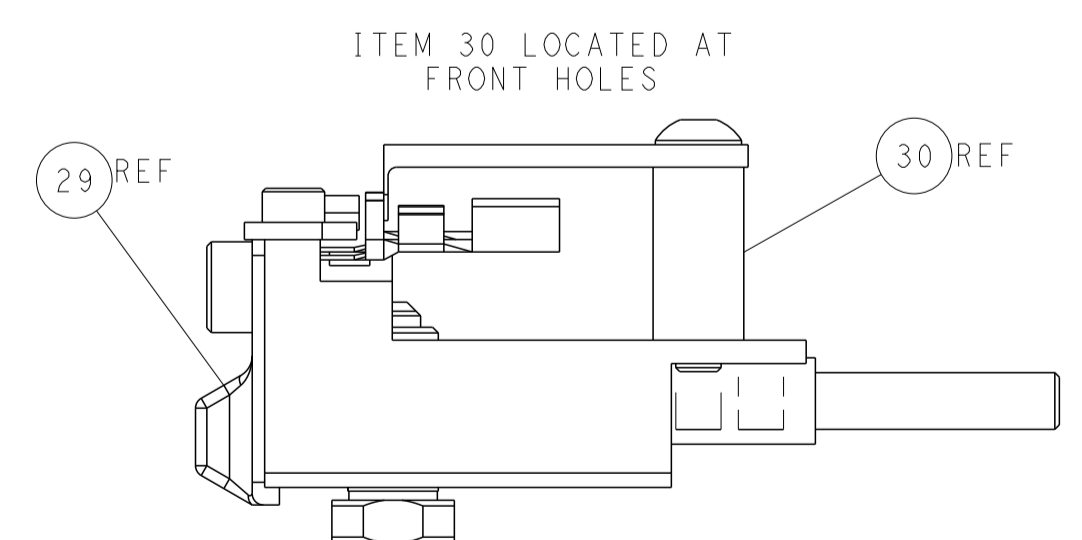
CAM POSITIONS



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: | | DWN Y. YIN 27DEC2012 | | TE Connectivity | |
| mm | 0 PLC ± | 1 PLC ± | 2 PLC ± | 3 PLC ± | 4 PLC ± | Harrisburg, PA 17105-3608 | |
| MATERIAL: | | FINISH: | | CHK G. BAILEY 27DEC2012 | | NAME Ocean Side Feed Applicator | |
| | | | | APVD S. XI 27DEC2012 | | SIZE CAGE CODE DRAWING NO RESTRICTED TO | |
| | | | | PRODUCT SPEC | | A1 00779 ©=2151852 | |
| | | | | APPLICATION SPEC | | Customer Accessible Production Drawing | |
| | | | | WEIGHT | | SCALE 1:2 SHEET 2 OF 4 REV E | |

| PART NUMBER | REVISION | DESCRIPTION | FEED TYPE |
|-------------|----------|--------------------------|------------|
| 2-2151852-1 | E | FINE CRIMP HEIGHT ADJUST | MECHANICAL |
| 2-2151852-2 | E | FINE CRIMP HEIGHT ADJUST | PNEUMATIC |
| 7-2151852-7 | A | CRIMP TOOLING KIT | - |

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



| APPLICATOR DATA | | |
|-----------------|----------------|------|
| CRIMP | SIZE | TYPE |
| WIRE | 2.79 mm [.110] | F |
| INSUL | 4.06 mm [.160] | F |

APPLICATOR INSTRUCTIONS
408-35042

| | | | |
|--|-------------|------------------------------|-------------|
| TERMINAL DATA: TE TERMINAL | | TE CRIMP SPECIFICATION | |
| TERMINAL NAME: GRACE INERTIA CONNECTOR 6.2MM PITCH | | | |
| WIRE STRIP LENGTH | | INSULATION DIAMETER RANGE | |
| 4.60-5.20 mm [.181-.205 IN] | | ∅2.00-3.75 mm [.079-.148 IN] | |
| TERMINAL APPLICATION SPECIFICATION | 114-5356 | - | - |
| TERMINALS APPLIED | | | |
| TE TERMINAL | TE TERMINAL | TE TERMINAL | TE TERMINAL |
| 1746971-1 | 1746973-1 | | |

| WIRE SIZE | CRIMP HEIGHT mm [INCH] | CRIMP HEIGHT REFERENCE SETTING |
|-----------|----------------------------|--------------------------------|
| 14 AWG | 1.79+/-0.05 [.070+/-0.002] | 6.7 |
| 16 AWG | 1.54+/-0.05 [.061+/-0.002] | 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.
- 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 LUBRICANT IS RECOMMENDED.
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)

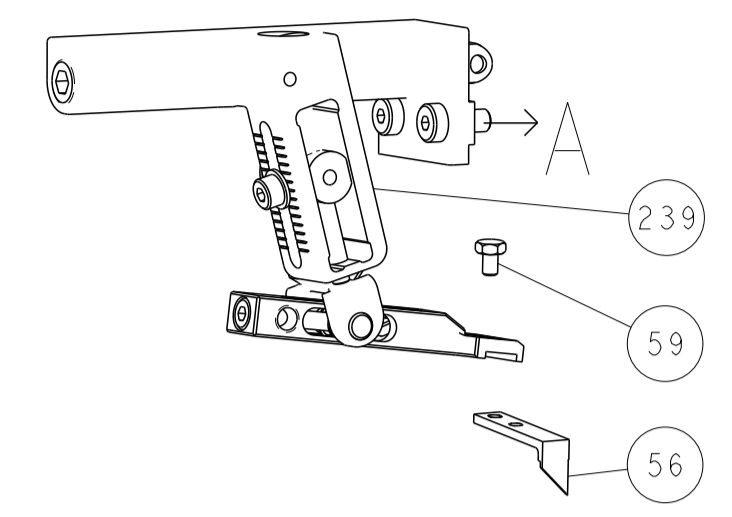
| LOC | DIST | REVISIONS | | | | | |
|-----|------|-----------|-----|-------------|------|-----|------|
| | | P | LTN | DESCRIPTION | DATE | OWN | APVD |
| A | 66 | - | - | SEE SHEET 1 | - | - | - |

| | | | | | |
|---|-----|-----|-------------|-------------------------------------|-----|
| - | 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 | 2119955-1 | ASSY, LUBRICATOR, SIDE FEED | 113 |
| - | 1 | 1 | 2844908-1 | SCREW, LOCKING | 99 |
| - | 1 | 1 | 2844907-1 | POST, LOCKING | 98 |
| - | 1 | 1 | 455888-5 | 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 | 1752356-3 | SUPPORT, TERMINAL | 34 |
| - | 2 | 2 | 2079383-5 | SCR, BHSC, RoHS (M4 X 20) | 33 |
| - | 2 | 2 | 3-2844962-0 | 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 | 1803095-6 | FLOATING SHEAR, FRONT | 9 |
| - | 1 | 1 | 3-1633134-5 | ANVIL, COMBINATION .110 | 8 |
| - | - | - | - | - | 7 |
| - | - | - | - | - | 6 |
| - | 1 | 1 | 2119757-6 | DEPRESSOR, SHEAR | 5 |
| - | 1 | 1 | 238011-4 | BLOCK, CRIMPER SPACER | 4 |
| - | 1 | 1 | 1-1633961-4 | CRIMPER, INSULATION F PREMIUM | 3 |
| - | 1 | 1 | 455888-4 | SPACER, CRIMPER | 2 |
| - | 1 | 1 | 456408-6 | CRIMPER, WIRE PREMIUM | 1 |

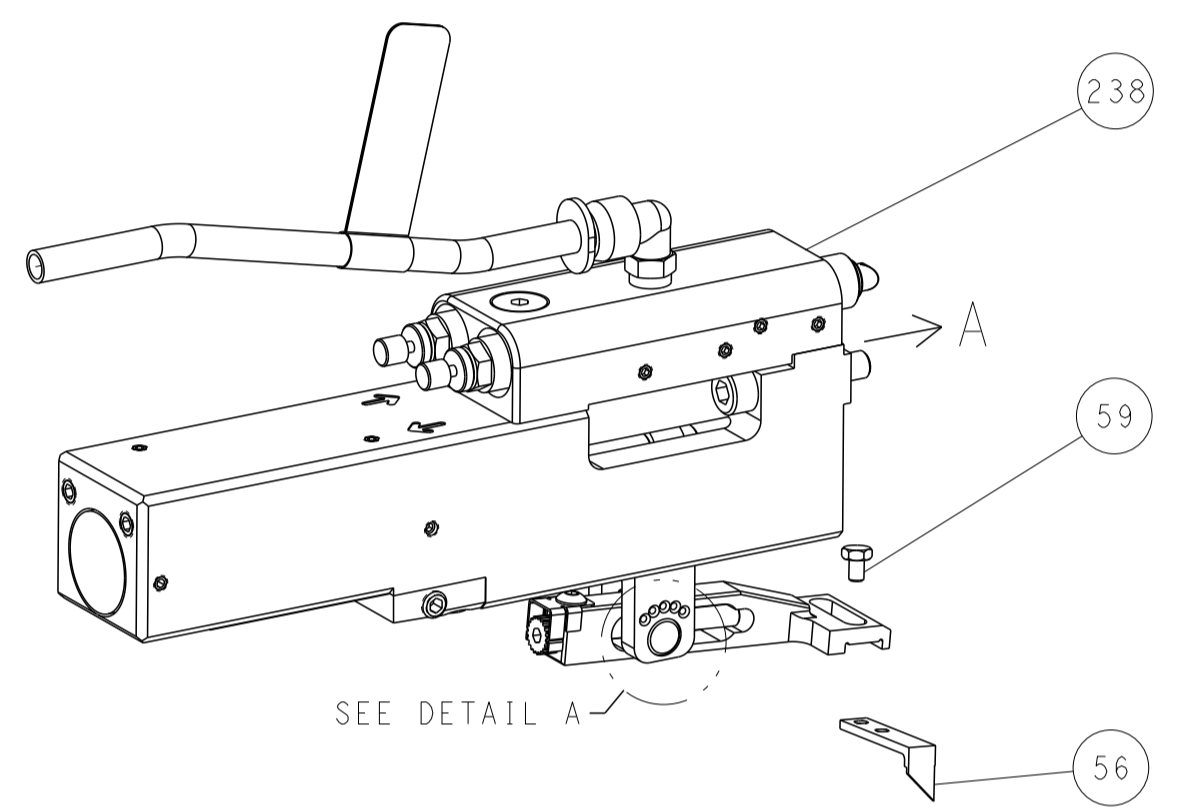
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|-------------|--------|--|--|-----------|--|---------|--|---------|--|--------|--|--------|--|------|--|
| mm | 0 PLC | ± | | | | | | | | | | | | | |
| | 1 PLC | ± | | | | | | | | | | | | | |
| | 2 PLC | ± | | | | | | | | | | | | | |
| | 3 PLC | ± | | | | | | | | | | | | | |
| | 4 PLC | ± | | | | | | | | | | | | | |
| | ANGLES | ± | | | | | | | | | | | | | |

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

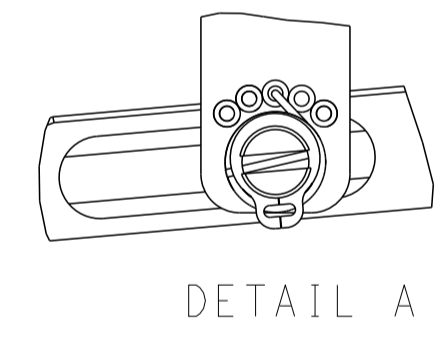
FEED TYPE MECHANICAL



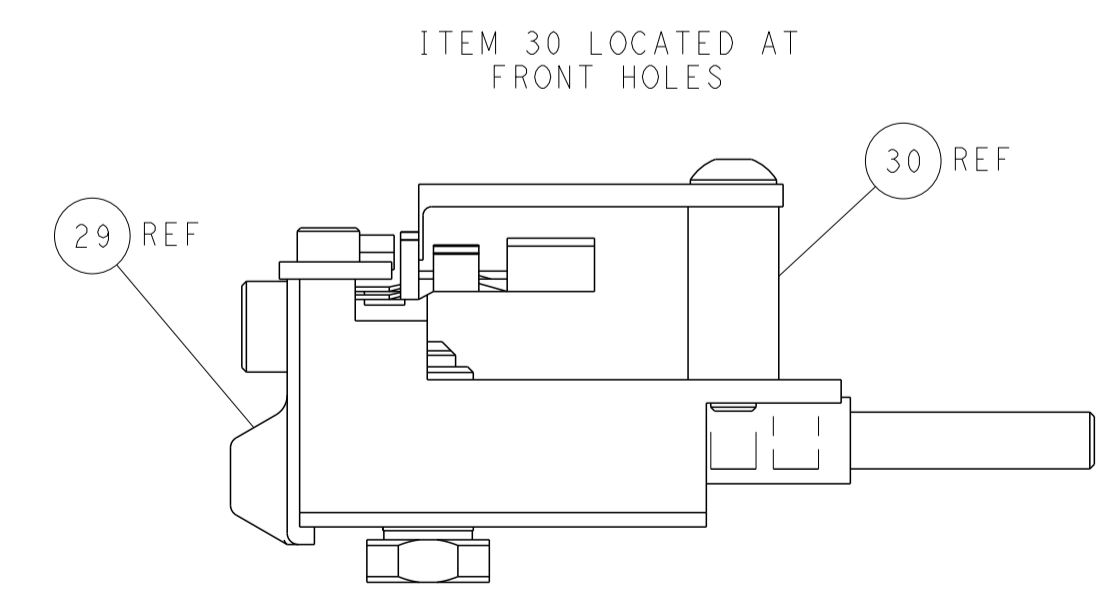
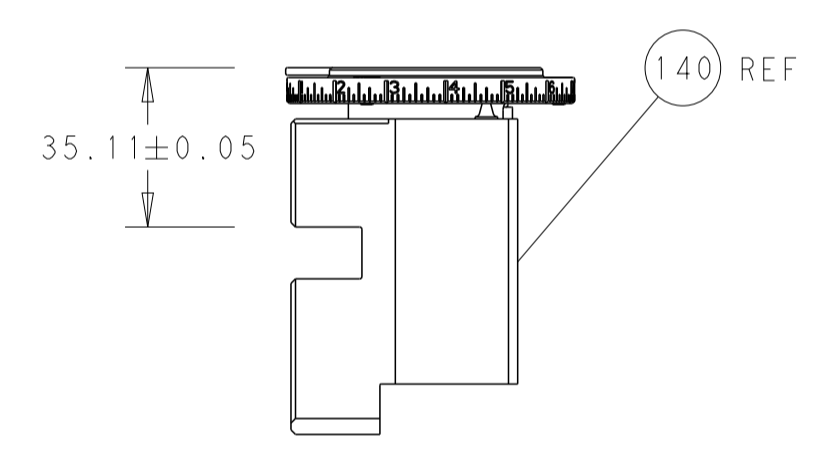
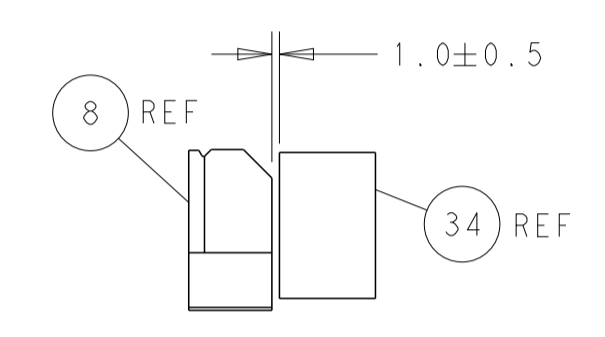
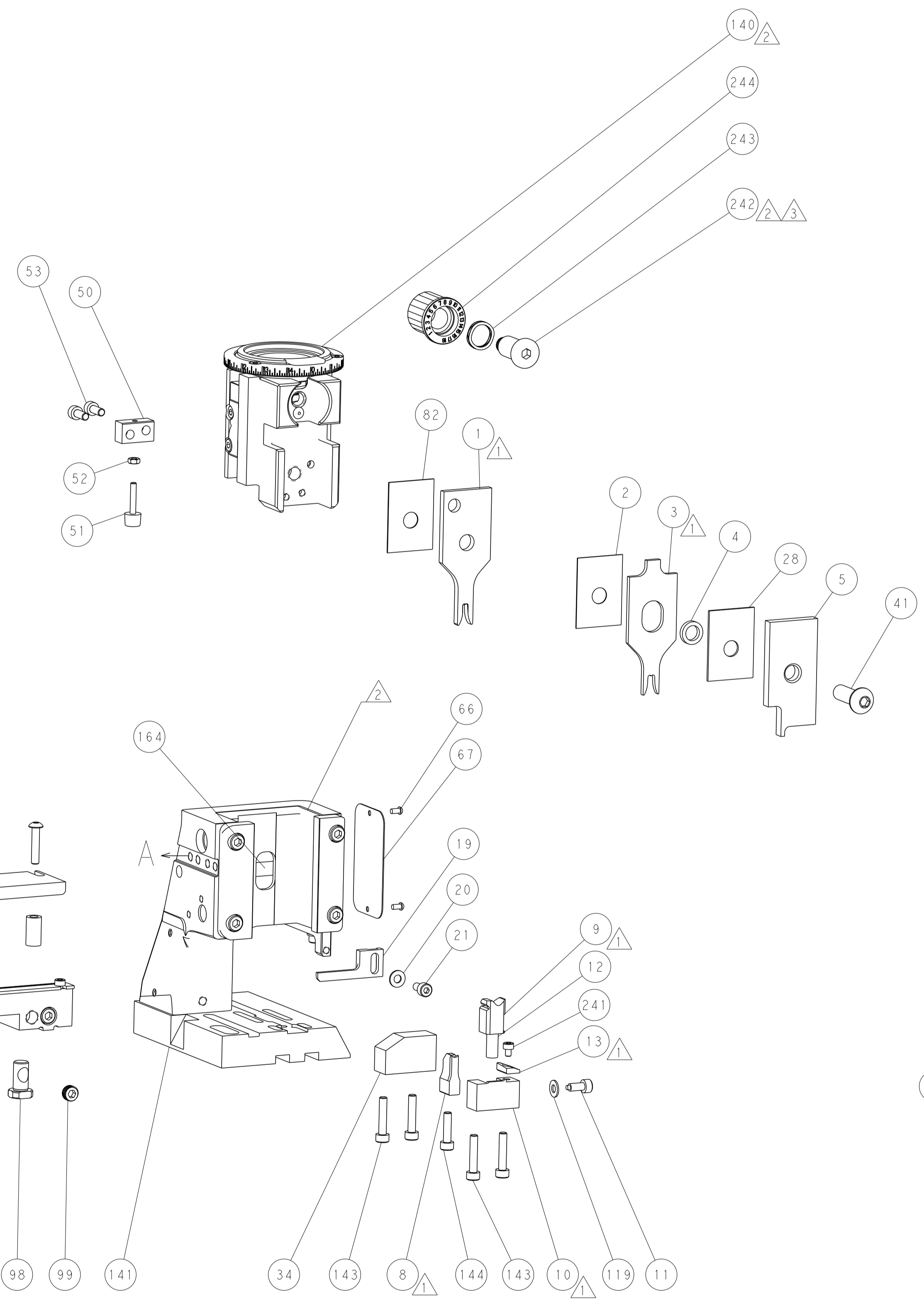
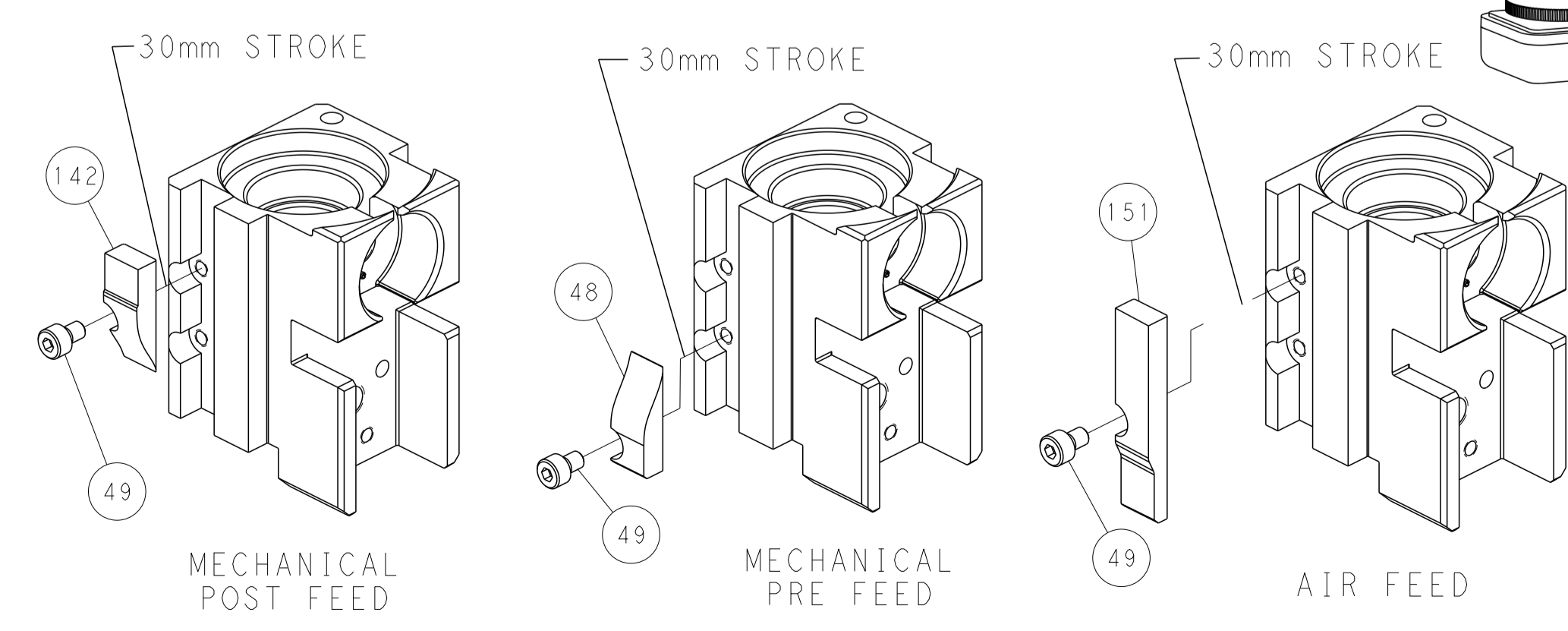
PNEUMATIC



FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



CAM POSITIONS



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 | | DWN Y. YIN 27DEC2012 CHK G. BAILEY 27DEC2012 APVD S. XI 27DEC2012 NAME Ocean Side Feed Applicator SIZE CAGE CODE DRAWING NO. RESTRICTED TO A1 00779 ©=2151852 Customer Accessible Production Drawing SCALE 1:2 SHEET 4 OF 4 REV E | |
|-----------------------|--|---|--|---|--|