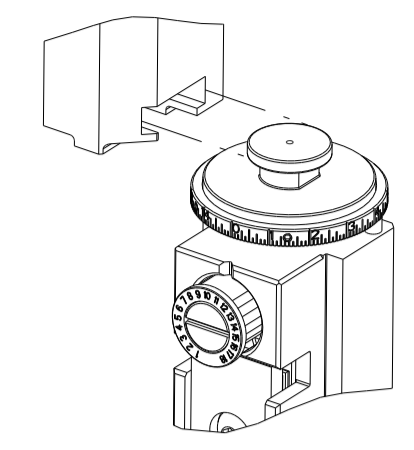


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151921-1	E	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2151921-2	E	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
5-2151921-1	E	SEAL STRIPPER CRIMPER TERMINATING UNIT	MECHANICAL
5-2151921-2	E	SEAL STRIPPER CRIMPER TERMINATING UNIT	PNEUMATIC
7-2151921-1	E	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2151921-2	E	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2151921-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.57 mm [.062]	F
INSUL	2.29 mm [.090]	O

APPLICATOR INSTRUCTIONS 408-35042

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: TAB 2.8 x 0.8			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
3.20-3.80 mm [.126-.150 IN]		Ø1.10-1.60 mm [.043-.063 IN]	
TERMINAL APPLICATION SPECIFICATION	114-18051		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
1-963860-1	1-963860-2	1-963860-3	2-963860-1
2-963860-2	2-963860-3		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: TAB 2.8 x 0.8			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
3.20-3.80 mm [.126-.150 IN]		Ø1.20-1.60 mm [.047-.063 IN]	
TERMINAL APPLICATION SPECIFICATION	114-18051		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
5-963860-1	5-963860-2	5-963860-3	

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.50mm2	1.12 +/- 0.03 [.044 +/- .001]	6.7
0.35mm2	1.05 +/- 0.03 [.041 +/- .001]	7.4
0.25mm2	1.00 +/- 0.03 [.039 +/- .001]	7.9
0.20mm2	0.98 +/- 0.03 [.039 +/- .001]	8.2

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.50mm2	1.07 +/- 0.03 [.042 +/- .001]	7.2
0.35mm2	1.00 +/- 0.03 [.039 +/- .001]	7.9

- 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. APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 180.
- 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.
- 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)

LOC	DIST	REVISIONS					
A	66	P	LTN	DESCRIPTION	DATE	OWN	APVD
		D		ECR-19-005806	10APR2019	LG	TE
		D1		ECR-19-015254	30SEP2019	FZ	RR
		E		ECR-20-005757	21APR2020	FZ	GB
		E1		ECR-22-160824	09DEC2022	FZ	JAH

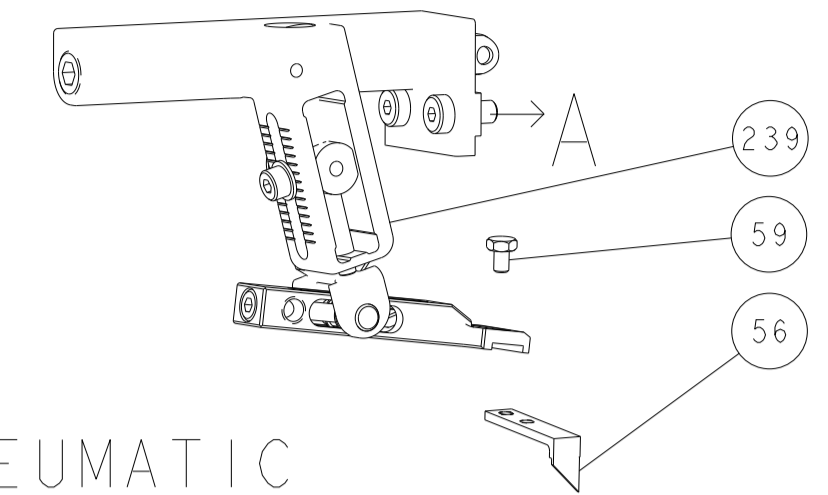
-	-	-	1	1	-	-	2-1803583-1	APPLICATOR BASIC ASSEMBLY, SF	292
-	1	1	1	1	1	1	1803078-4	SPACER, PRECISION	259
-	1	-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248
-	1	1	1	1	1	1	2119082-5	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
3	-	1	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	1	1	1	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
-	-	1	-	1	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	1	-	1	-	1	-	2844940-1	AIR FEED MODULE	238
-	-	-	1	1	-	-	1803237-3	STRIPPER, SIDE FEED	182
3	-	-	1	1	-	-	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	181
-	-	-	1	1	-	-	2-1752354-3	STANDOFF, HOLD-DOWN	180
-	-	-	1	1	-	-	6-993111-6	PIN, SLOTTED SPRING 3.0 X 14.0	177
-	-	-	1	1	-	-	5-22280-0	SPRING, COMPRESSION	176
-	-	-	1	1	-	-	1752353-3	GUIDE PIN, HOLDDOWN	175
-	-	-	1	1	-	-	1901680-2	GUIDE PIN, HOLDDOWN	174
-	REF	REF	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	1	1	1	1	1	1	2844908-1	SCREW, LOCKING	99
-	1	1	1	1	1	1	2844907-1	POST, LOCKING	98
-	1	1	1	1	1	1	455888-4	SPACER, CRIMPER	82
-	2	2	2	2	2	2	18024-6	SCR, BTN SKT HD CAP (M4 X 8.0)	79
-	1	1	1	1	1	1	1803096-1	EXTENSION PLATE	78
-	2	2	2	2	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	77
-	1	1	1	1	1	1	1633782-2	FENCE	76
-	1	1	1	1	1	1	1803607-3	DOCUMENTATION PACKAGE	71
-	1	1	1	1	1	1	2119740-1	TAG, IDENTIFICATION	67
-	2	2	2	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	1	1	1	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	60
-	1	1	1	1	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	1	1	1	1	1	1	1338685-1	PAWL, FEED	56
-	4	4	4	4	4	4	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	54
-	2	2	2	2	2	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	53
-	1	1	1	1	1	1	1803382-2	HOLD DOWN, SPRING LOADED	50
-	1	2	1	2	1	2	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	-	1	-	1	-	1	2119652-1	FEED CAM, PRE FEED	48
-	-	1	-	1	-	1	2119653-1	FEED CAM, POST FEED	47
-	1	1	-	-	1	1	1803583-9	APPLICATOR BASIC ASSEMBLY, SF	46
-	1	1	1	1	1	1	1803515-2	RAM ASSEMBLY, SF ATLANTIC	44
-	1	1	1	1	1	1	1803602-2	SCR, BHSC, RoHS (M8 X 40)	41
-	1	1	1	1	1	1	1-1752356-6	SUPPORT, TERMINAL	34
-	2	2	2	2	2	2	2079383-8	SCR, BHSC, RoHS (M4 X 16)	33
-	2	2	2	2	2	2	1-2844962-4	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	1	1	1	1	2844992-2	ASSEMBLY, STRIP GUIDE	29
-	1	1	1	1	1	1	1-455888-5	SPACER, CRIMPER	28
-	1	1	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
-	2	2	1	1	2	2	1-18028-2	WASHER, FLAT, REG M4	20
-	1	1	-	-	1	1	2119533-1	STRIPPER, SIDE FEED	19
1	1	1	1	1	1	1	2119806-1	INSERT, SHEAR	13
-	1	1	1	1	1	1	3-22280-3	SPRING, COMPRESSION	12
-	1	1	1	1	1	1	1-356885-4	STOP, SHEAR	11
1	1	1	1	1	1	1	2119805-5	SHEAR HOLDER, FRONT	10
1	1	1	1	1	1	1	1-454276-2	FLOATING SHEAR, FRONT	9
1	2	2	1	1	1	1	1633216-2	ANVIL, COMBINATION	8
-	-	-	-	-	-	-	-	-	7
-	-	-	-	-	-	-	-	-	6
-	1	1	1	1	1	1	2119757-1	DEPRESSOR, SHEAR	5
-	1	1	1	1	1	1	238011-9	BLOCK, CRIMPER SPACER	4
1	1	2	1	1	1	1	1-2119784-8	CRIMPER, INSULATION O PREMIUM	3
-	1	1	1	1	1	1	455888-5	SPACER, CRIMPER	2
1	2	2	1	1	1	1	1-456403-3	CRIMPER, WIRE PREMIUM	1

ITEM NO	PART NO	DESCRIPTION	ITEM NO
-77	-72	-71	-52
-51	-2	-1	

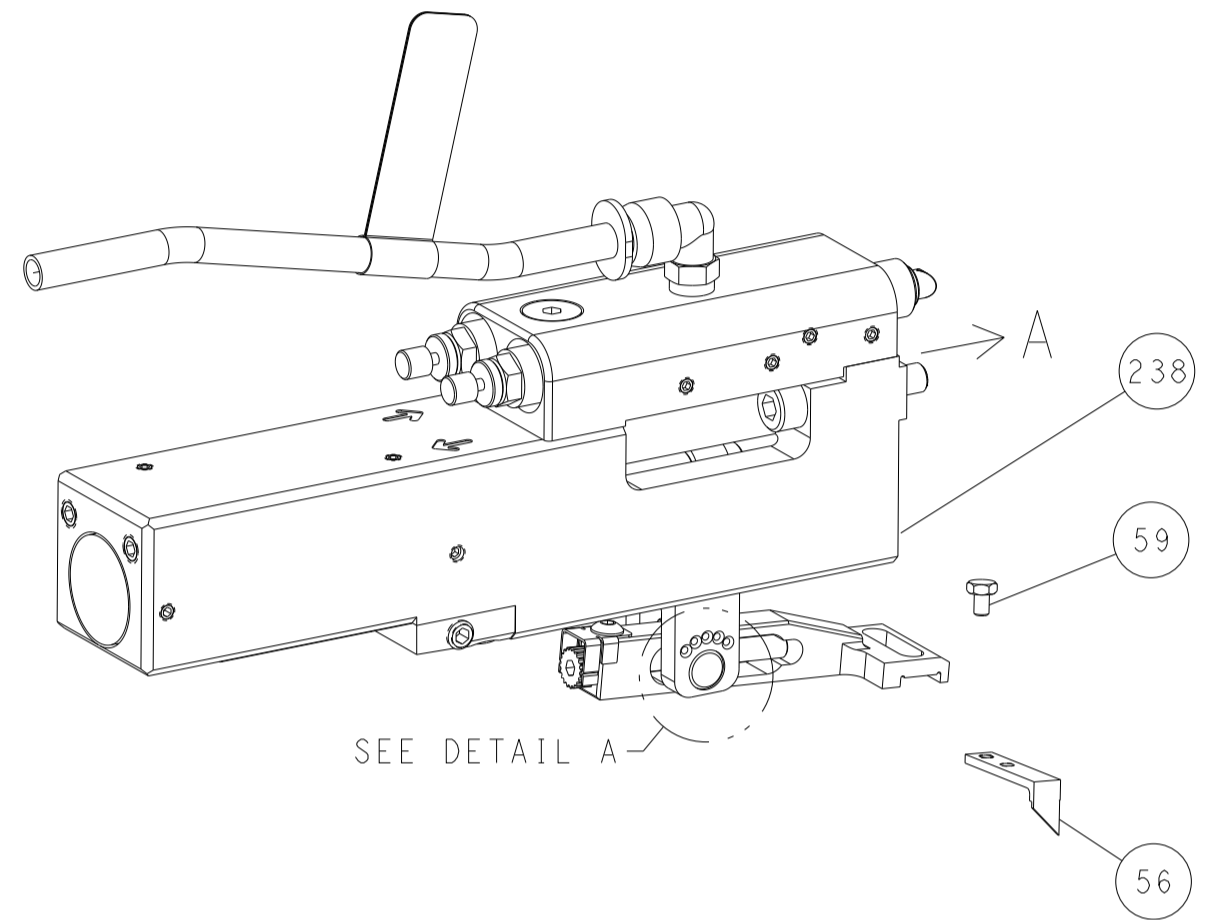
OWN	H. HUANG	09APR2013	TE Connectivity Harrisburg, PA 17105-3608			
CHK	L. ZHANG	09APR2013				
APVD	J. GUO	09APR2013				
NAME	Ocean Side Feed Applicator					
DIMENSIONS:	TOLERANCES UNLESS OTHERWISE SPECIFIED:		SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
mm	0 PLC	±	A1	00779	2151921	
	1 PLC	±				
	2 PLC	±				
	3 PLC	±				
	4 PLC	±				
	ANGLES	±				
MATERIAL	FINISH		WEIGHT			
Customer Accessible Production Drawing			SCALE	1:2	SHEET	1 of 4
			REV	E1		

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

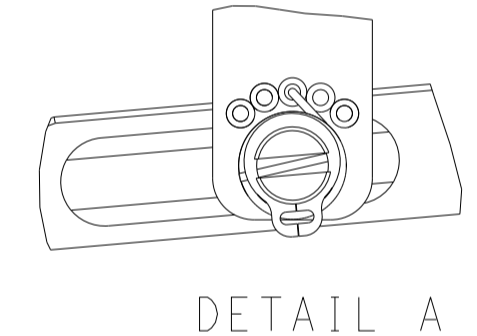
# FEED TYPE MECHANICAL



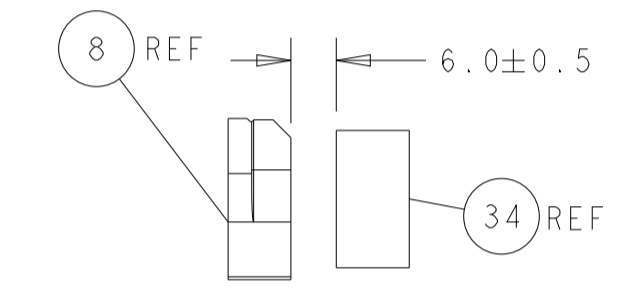
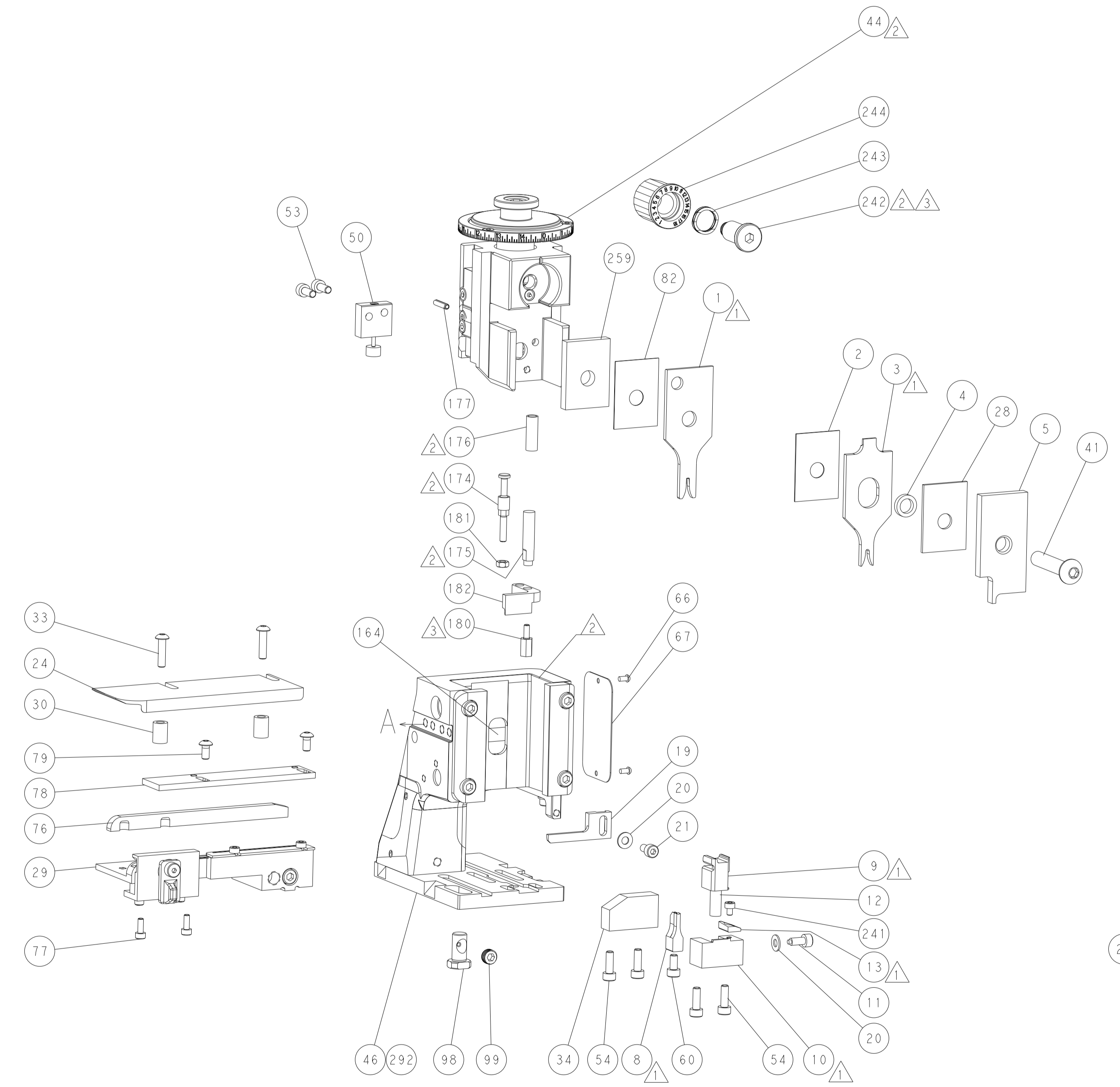
## PNEUMATIC



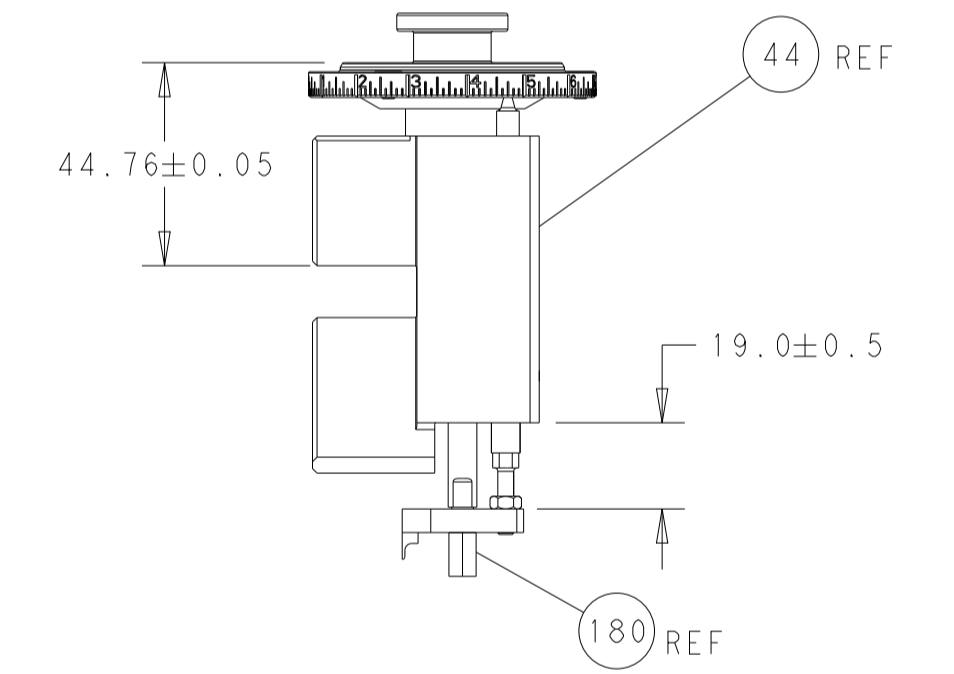
## FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



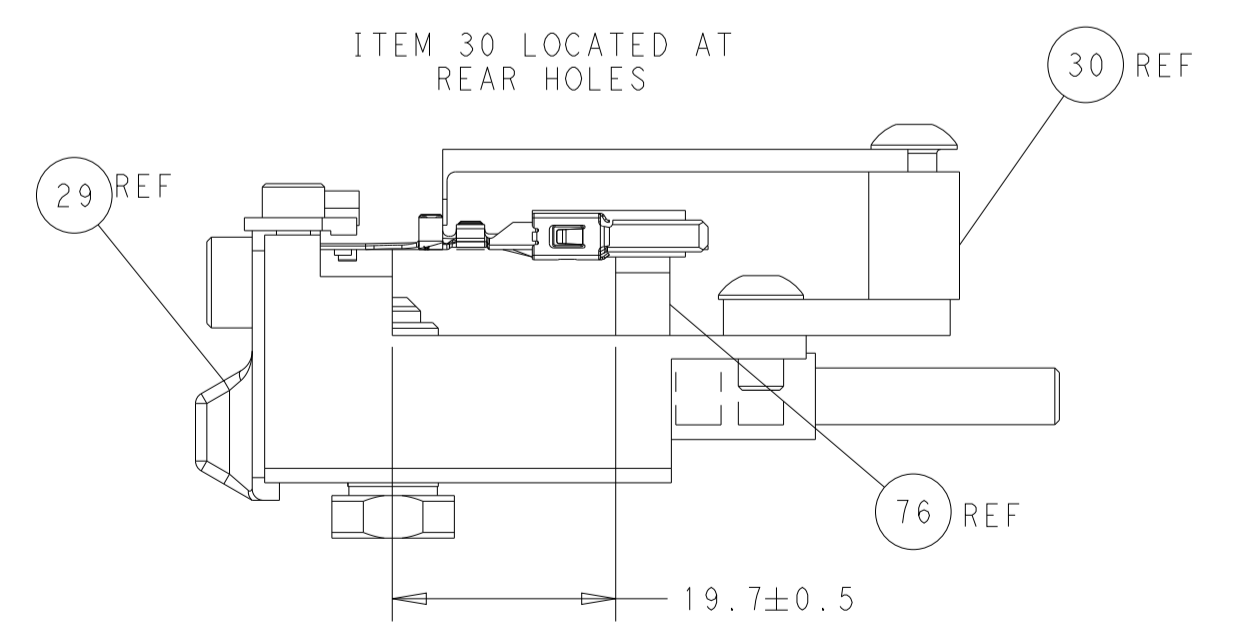
DETAIL A



TERMINAL SUPPORT LOCATION

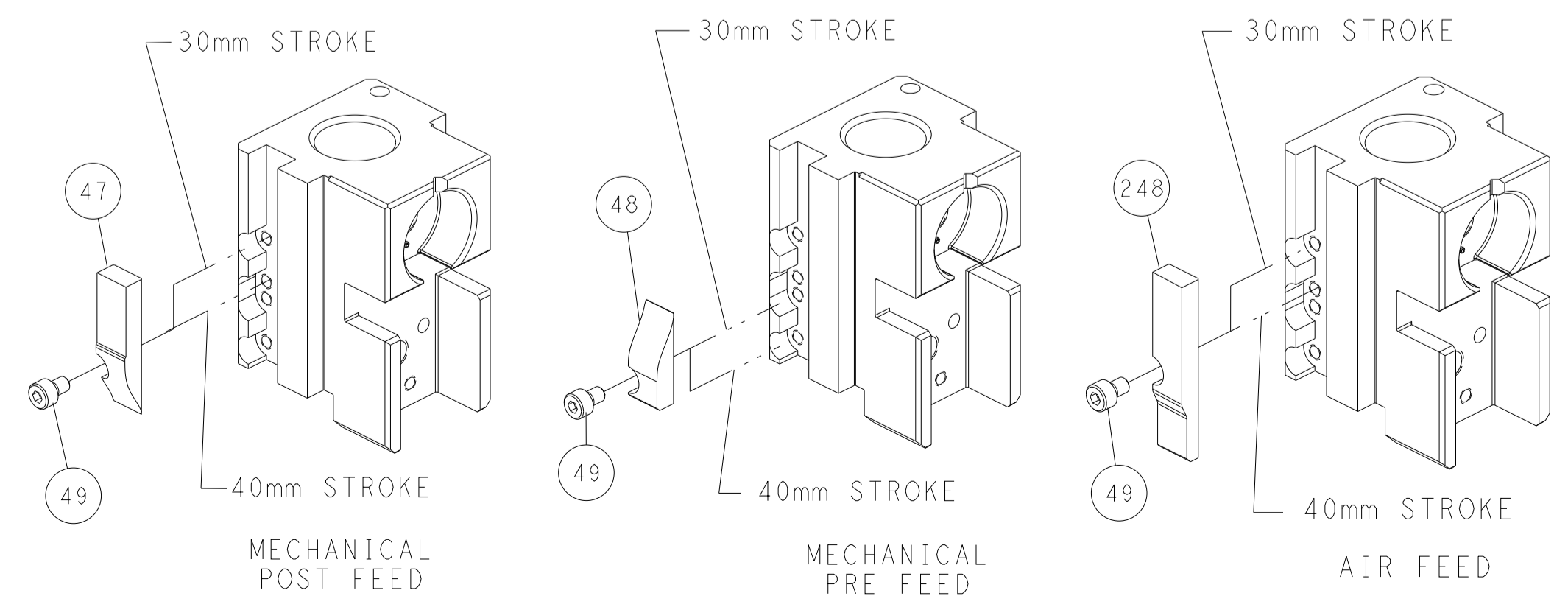


RAM AND HILD-DOWN SET-UP



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:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG		REV	
mm	0 PLC	±		H. HUANG	09APR2013	STE TE Connectivity	
	1 PLC	±		L. ZHANG	09APR2013	Harrisburg, PA 17105-3608	
	2 PLC	±		U. GUO	09APR2013	NAME	
	3 PLC	±				Ocean Side Feed	
	4 PLC	±				Applicator	
	ANGLES	±				SIZE	CAGE CODE
	FINISH	±				A1	00779
						DRAWING NO	©=2151921
						RESTRICTED TO	
						Customer Accessible Production Drawing	SCALE
						1:2	SHEET 2 OF 4
						REV	E1

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2151921-1	E	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2151921-2	E	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151921-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR  
 INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.57 mm [.062]	F
INSUL	2.29 mm [.090]	O
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: TAB 2.8 x 0.8			
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE		
3.20-3.80 mm [.126-.150 IN]	Ø1.20-1.60 mm [.043-.063 IN]		
TERMINAL APPLICATION SPECIFICATION	114-18051	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
1-963860-1	1-963860-2	1-963860-3	2-963860-1
2-963860-2	2-963860-3		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: TAB 2.8 x 0.8			
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE		
3.20-3.80 mm [.126-.150 IN]	Ø1.20-1.60 mm [.047-.063 IN]		
TERMINAL APPLICATION SPECIFICATION	114-18051	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
5-963860-1	5-963860-2	5-963860-3	

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.50mm2	1.12+/-0.03 [.044+/- .001]	6.7
0.35mm2	1.05+/-0.03 [.041+/- .001]	7.4
0.25mm2	1.00+/-0.03 [.039+/- .001]	7.9
0.20mm2	0.98+/-0.03 [.039+/- .001]	8.2

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.50mm2	1.07+/-0.03 [.042+/- .001]	7.2
0.35mm2	1.00+/-0.03 [.039+/- .001]	7.9

- 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.
- 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
-	-	-	-	SEE SHEET 1	-	-	-

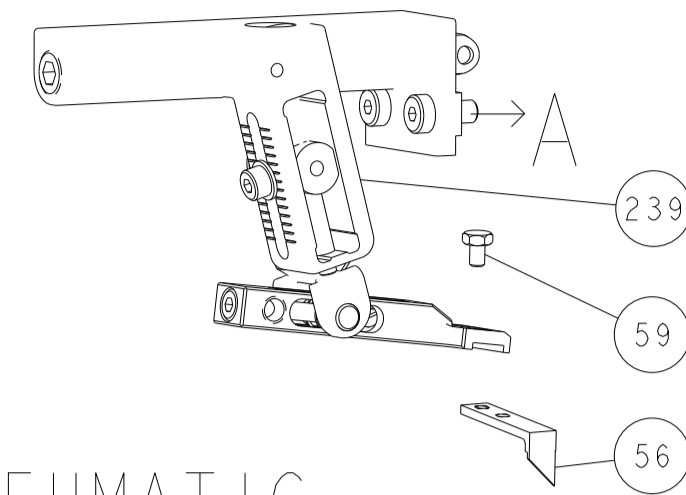
-	1	1	1803078-4	SPACER, PRECISION	259
-	1	1	2119082-5	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
-	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	1	-	2844940-1	AIR 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	1803516-2	RAM ASSEMBLY, SF PACIFIC	140
-	1	1	2844908-1	SCREW, LOCKING	99
-	1	1	2844907-1	POST, LOCKING	98
-	1	1	455888-4	SPACER, CRIMPER	82
-	2	2	18024-6	SCR, BTN SKT HD CAP (M4 X 8.0)	79
-	1	1	1803096-1	EXTENSION PLATE	78
-	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	77
-	1	1	1633782-2	FENCE	76
-	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	1803382-2	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	1803602-2	SCR, BHSC, RoHS (M8 X 40)	41
-	1	1	1-1752356-6	SUPPORT, TERMINAL	34
-	2	2	2079383-8	SCR, BHSC, RoHS (M4 X 16)	33
-	2	2	1-2844962-4	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	2844992-2	ASSEMBLY, STRIP GUIDE	29
-	1	1	1-455888-5	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	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	2119805-5	SHEAR HOLDER, FRONT	10
-	1	1	1-454276-2	FLOATING SHEAR, FRONT	9
-	1	1	1633216-2	ANVIL, COMBINATION	8
-	-	-	-	-	7
-	-	-	-	-	6
-	1	1	2119757-1	DEPRESSOR, SHEAR	5
-	1	1	238011-9	BLOCK, CRIMPER SPACER	4
-	1	1	1-2119784-8	CRIMPER, INSULATION O PREMIUM	3
-	1	1	455888-5	SPACER, CRIMPER	2
-	1	1	1-456403-3	CRIMPER, WIRE PREMIUM	1

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

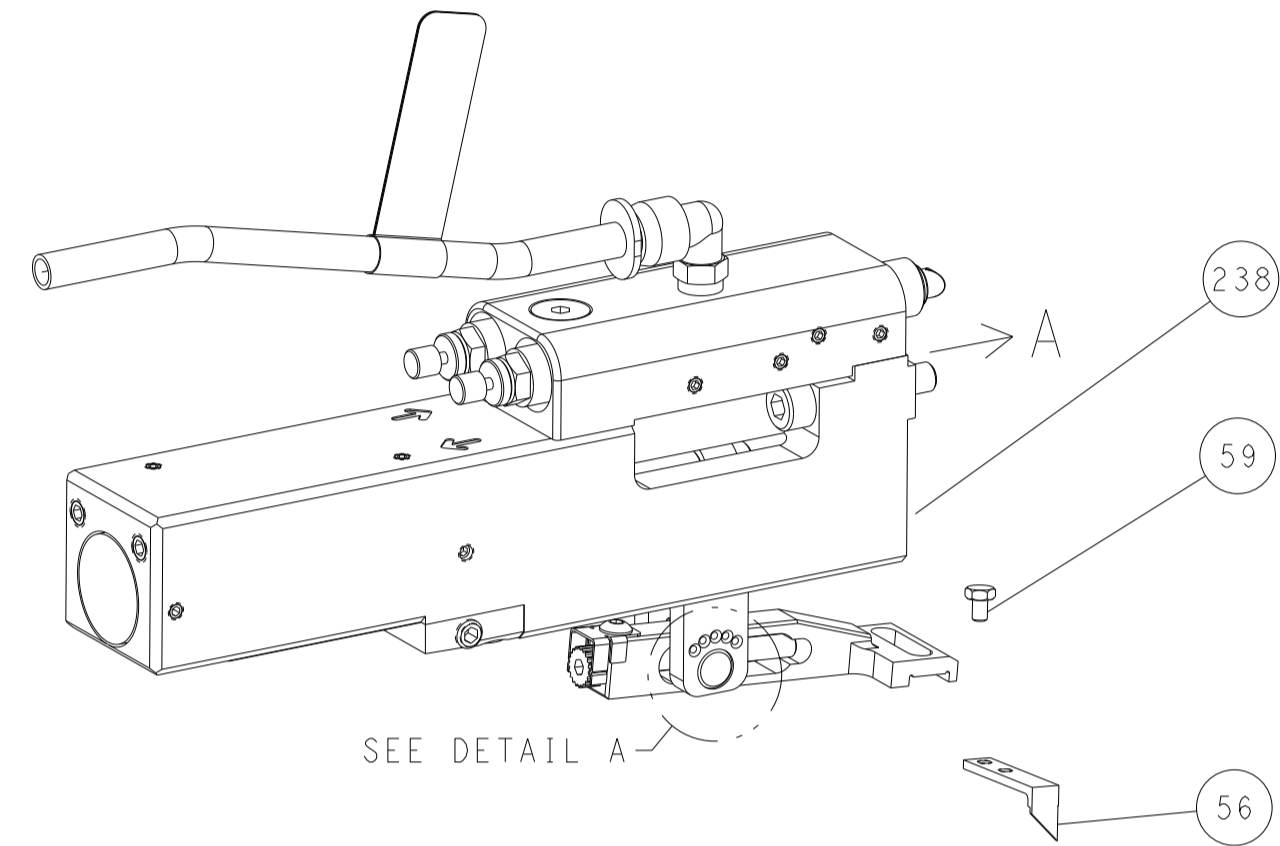
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG: H. HUANG 09APR2013		CHK: L. ZHANG 09APR2013		APVD: U. GUO 09APR2013		NAME: Ocean Side Feed Applicator	
0 PLC ±		1 PLC ±		2 PLC ±		3 PLC ±		4 PLC ±		SIZE: A1	
ANGLES		FINISH		WEIGHT		SCALE: 1:2		SHEET: 3 OF 4		REV: E1	
Customer Accessible Production Drawing										Customer Accessible Production Drawing	

LOC	DIST	REVISIONS			
A	66	REV	DATE	BY	APPV
-	-	SEE SHEET 1	-	-	-

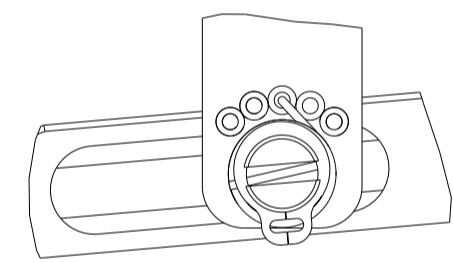
# FEED TYPE MECHANICAL



## PNEUMATIC

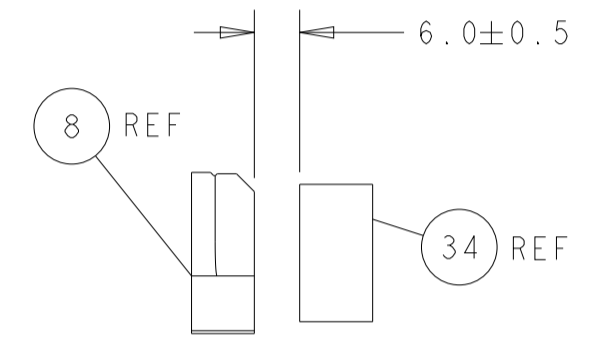
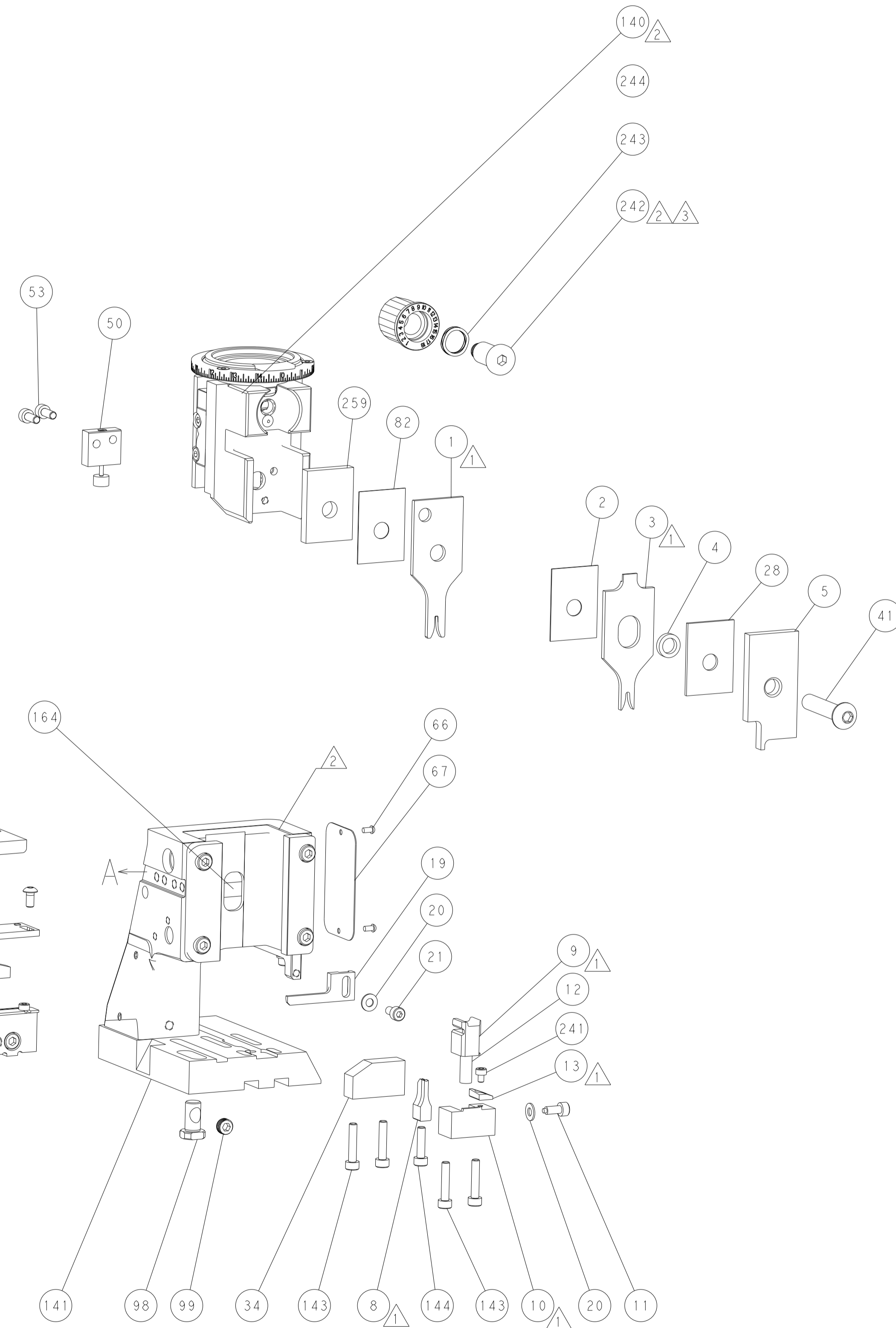
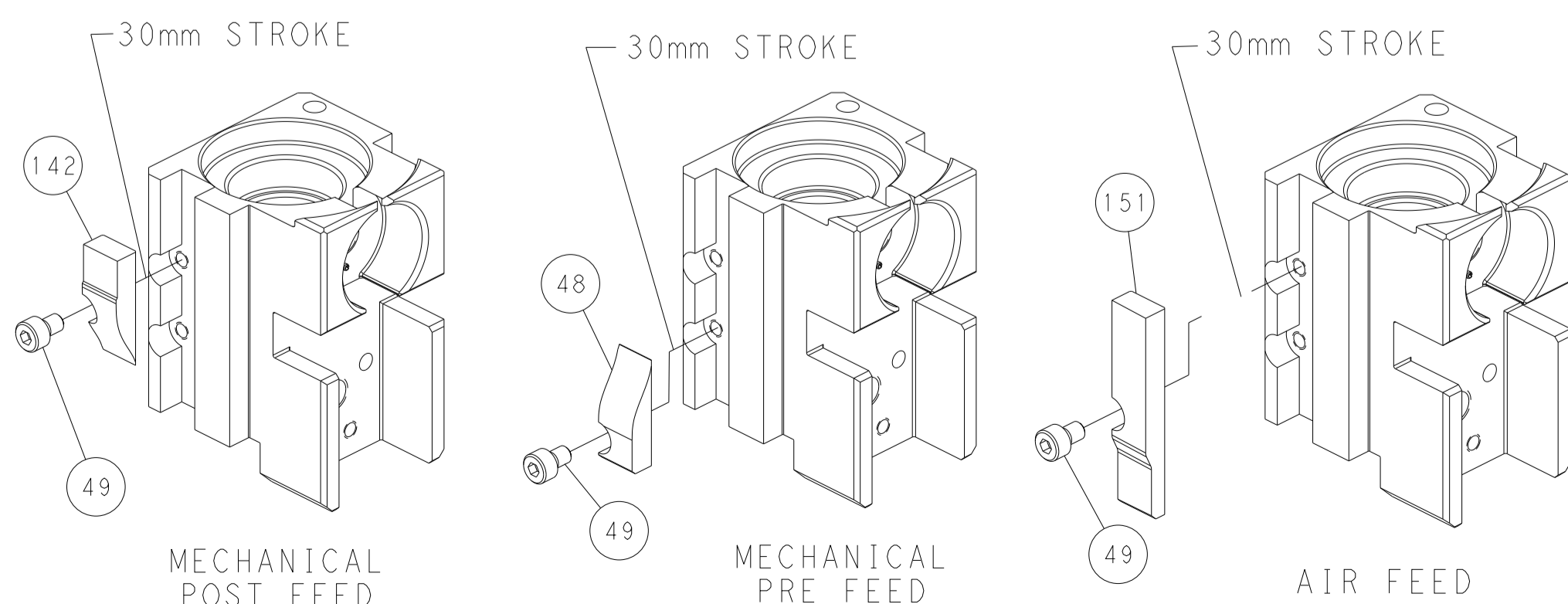


### FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)

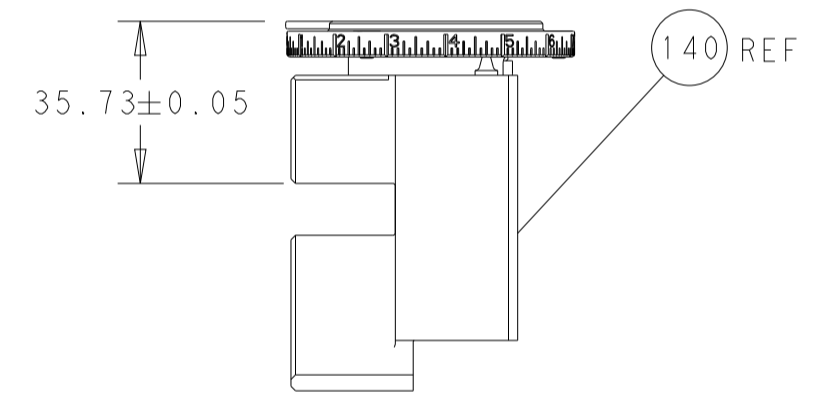


DETAIL A

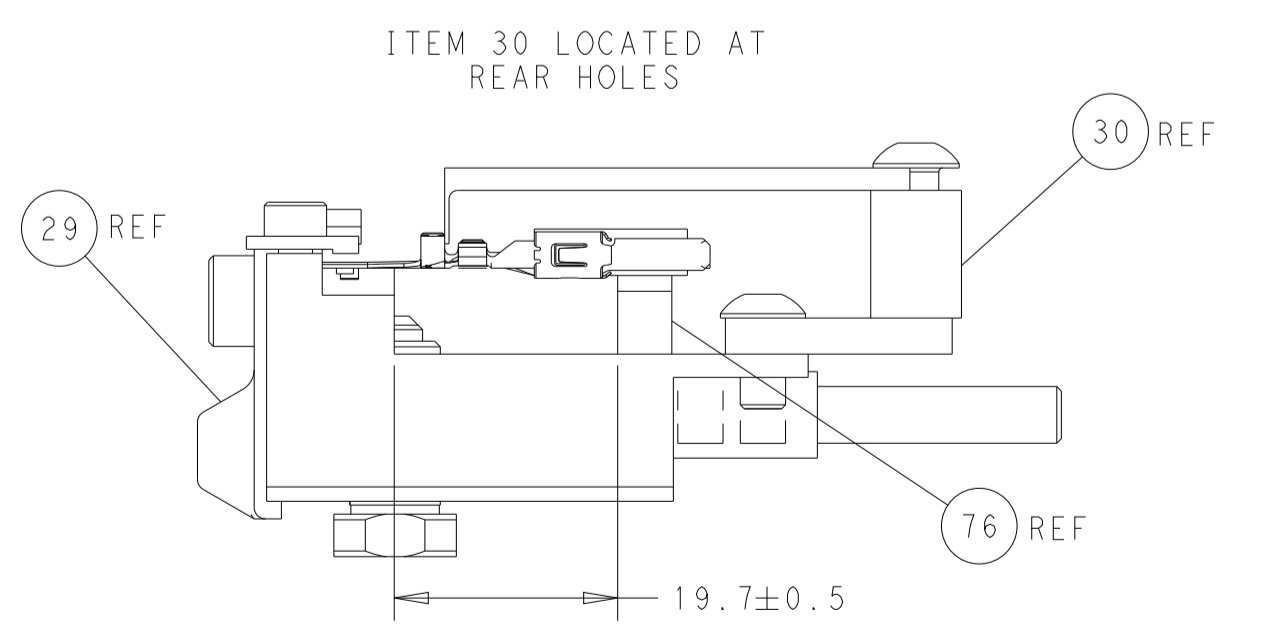
## CAM POSITIONS



TERMINAL SUPPORT LOCATION



RAM SET-UP



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)

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DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH ±		NAME: Ocean Side Feed Applicator APPLICATION SPEC:	SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2151921
MATERIAL:		WEIGHT:	RESTRICTED TO: Customer Accessible Production Drawing SCALE: 1:2 SHEET: 4 OF 4 REV: E1