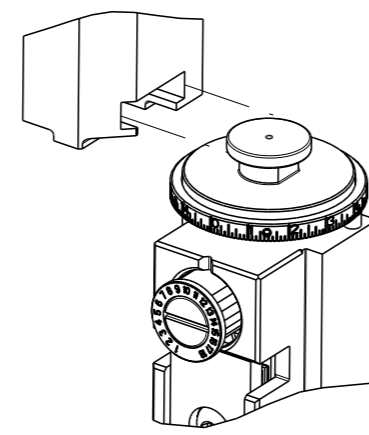


| PART NUMBER | REVISION | DESCRIPTION                      | FEED TYPE  |
|-------------|----------|----------------------------------|------------|
| 2151612-1   | D        | FINE CRIMP HEIGHT ADJUST         | MECHANICAL |
| 2151612-2   | D        | FINE CRIMP HEIGHT ADJUST         | PNEUMATIC  |
| 7-2151612-1 | D        | MECHANICAL AND CRIMP TOOLING KIT | MECHANICAL |
| 7-2151612-2 | D        | PNEUMATIC AND CRIMP TOOLING KIT  | PNEUMATIC  |
| 7-2151612-7 | D        | CRIMP TOOLING KIT                | -          |

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER

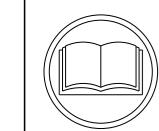


| APPLICATOR DATA |                |      |
|-----------------|----------------|------|
| CRIMP           | SIZE           | TYPE |
| WIRE            | 1.96 mm [.077] | F    |
| INSUL           | 2.67 mm [.105] | F    |

APPLICATOR INSTRUCTIONS  
408-35042

| TERMINAL DATA: DELPHI TERMINAL DELPHI CRIMP SPECIFICATION |                              |             |                 |
|---|------------------------------|-------------|-----------------|
| TERMINAL NAME: TERMINAL                                   |                              |             |                 |
| WIRE STRIP LENGTH   | INSULATION DIAMETER RANGE    |             |                 |
| 5.01-5.02 mm [.197-.198 IN]                               | Ø1.96-2.64 mm [.077-.104 IN] |             |                 |
| TERMINAL APPLICATION SPECIFICATION                        | DELPHI SPECIFICATION         |             |                 |
|   |                              |             |                 |
| TERMINALS APPLIED   |                              |             |                 |
| TE TERMINAL   | DELPHI TERMINAL              | TE TERMINAL | DELPHI TERMINAL |
| 1642331-1   | 12110844                     |             |                 |

| WIRE SIZE | CRIMP HEIGHT mm [INCH]      | CRIMP HEIGHT REFERENCE SETTING |
|-----------|-----------------------------|--------------------------------|
| 1.00mm2   | 1.50+/-0.05 [1.059+/-0.002] | 8.7                            |
| 0.80mm2   | 1.40+/-0.05 [1.055+/-0.002] | 9.6                            |



- 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.

**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 |     |               |           |     |      |
|-----|------|-----------|-----|---------------|-----------|-----|------|
|     |      | #         | LY# | DESCRIPTION   | DATE      | OWN | APVD |
| A   | 66   | A         |     | RELEASED      | 24APR2012 | LG  | GB   |
|     |      | B         |     | ECR-19-004659 | 24MAR2019 | TB  | CT   |
|     |      | C         |     | ECR-19-006699 | 26APR2019 | MZ  | TE   |
|     |      | D         |     | ECR-19-006948 | 30APR2019 | LG  | TE   |

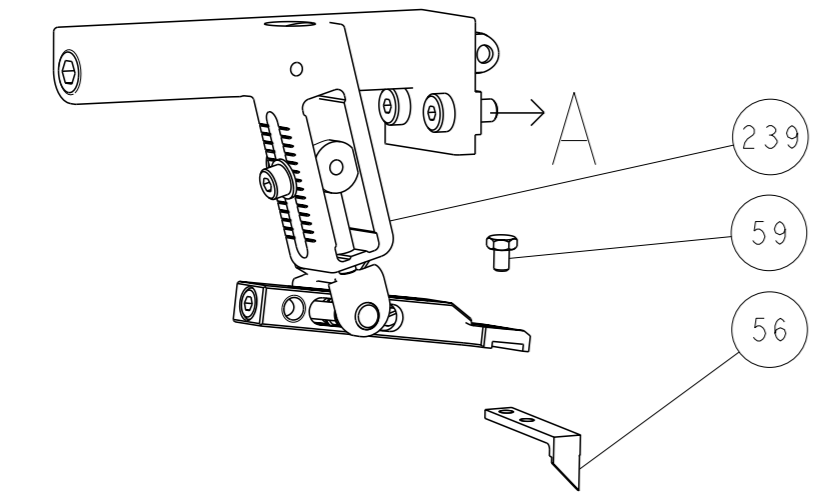
|   |     |     |     |     |             |                                     |         |
|---|-----|-----|-----|-----|-------------|-------------------------------------|---------|
| - | 1   | -   | 1   | -   | 2119640-1   | PUSH ROD, AIR FEED                  | 250     |
| - | 1   | -   | 1   | -   | 1803259-1   | BUSHING, FLANGED                    | 249     |
| - | 1   | -   | 1   | -   | 2119641-1   | FEED CAM, AIR FEED                  | 248     |
| - | 1   | 1   | 1   | 1   | 2119082-8   | 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   | 18023-1     | SCR, SKT HD CAP M3 X 5.0            | 241     |
| - | -   | 1   | -   | 1   | 2119580-1   | MECHANICAL FEED ASSEMBLY            | 239     |
| - | 1   | -   | 1   | -   | 2063440-1   | AIR FEED MODULE                     | 238     |
| - | 2   | -   | 2   | -   | 21045-3     | RING, RETAIN, EXTERN, 3/16 CRESCENT | 172     |
| - | REF | REF | 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   | 1   | 1   | 455888-9    | SPACER, CRIMPER                     | 120     |
| - | 1   | 1   | 1   | 1   | 2844908-1   | SCREW, LOCKING                      | 99      |
| - | 1   | 1   | 1   | 1   | 2844907-1   | POST, LOCKING                       | 98      |
| - | 1   | 1   | 1   | 1   | 455888-6    | SPACER, CRIMPER                     | 82      |
| - | 1   | 1   | 1   | 1   | 1803607-1   | DOCUMENTATION PACKAGE               | 71      |
| - | 1   | 1   | 1   | 1   | 2119791-9   | DEPRESSOR, WIRE                     | 70      |
| - | 1   | 1   | 1   | 1   | 2119943-1   | WASHER, SPACER                      | 69      |
| - | 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   | 2-2168083-5 | SCR, SKT HD CAP, RoHS, M4 X 14      | 53      |
| - | 1   | 1   | 1   | 1   | 1803382-2   | 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   | 1752356-1   | SUPPORT, TERMINAL                   | 34      |
| - | 2   | 2   | 2   | 2   | 2079383-5   | SCR, BHSC, RoHS (M4 X 20)           | 33      |
| - | 2   | 2   | 2   | 2   | 2-2844962-6 | 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   | 454276-5    | FLOATING SHEAR, FRONT               | 9       |
| - | 1   | 2   | 2   | 1   | 1633928-5   | ANVIL, COMBINATION                  | 8       |
| - | 1   | 1   | 1   | 1   | 240641-1    | SPACER                              | 7       |
| - | -   | -   | -   | -   | -           | -                                   | 6       |
| - | 1   | 1   | 1   | 1   | 2119757-8   | DEPRESSOR, SHEAR                    | 5       |
| - | 1   | 1   | 1   | 1   | 2-238011-1  | BLOCK, CRIMPER SPACER               | 4       |
| - | 1   | 2   | 2   | 1   | 3-1633961-5 | CRIMPER, INSULATION F PREMIUM       | 3       |
| - | 1   | 1   | 1   | 1   | 455888-3    | SPACER, CRIMPER                     | 2       |
| - | 1   | 2   | 2   | 1   | 1633305-1   | CRIMPER, WIRE PREMIUM               | 1       |
| - | 77  | -72 | -71 | -2  | -1          | PART NO                             | ITEM NO |

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

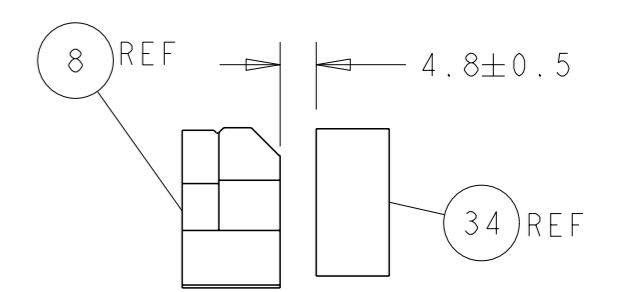
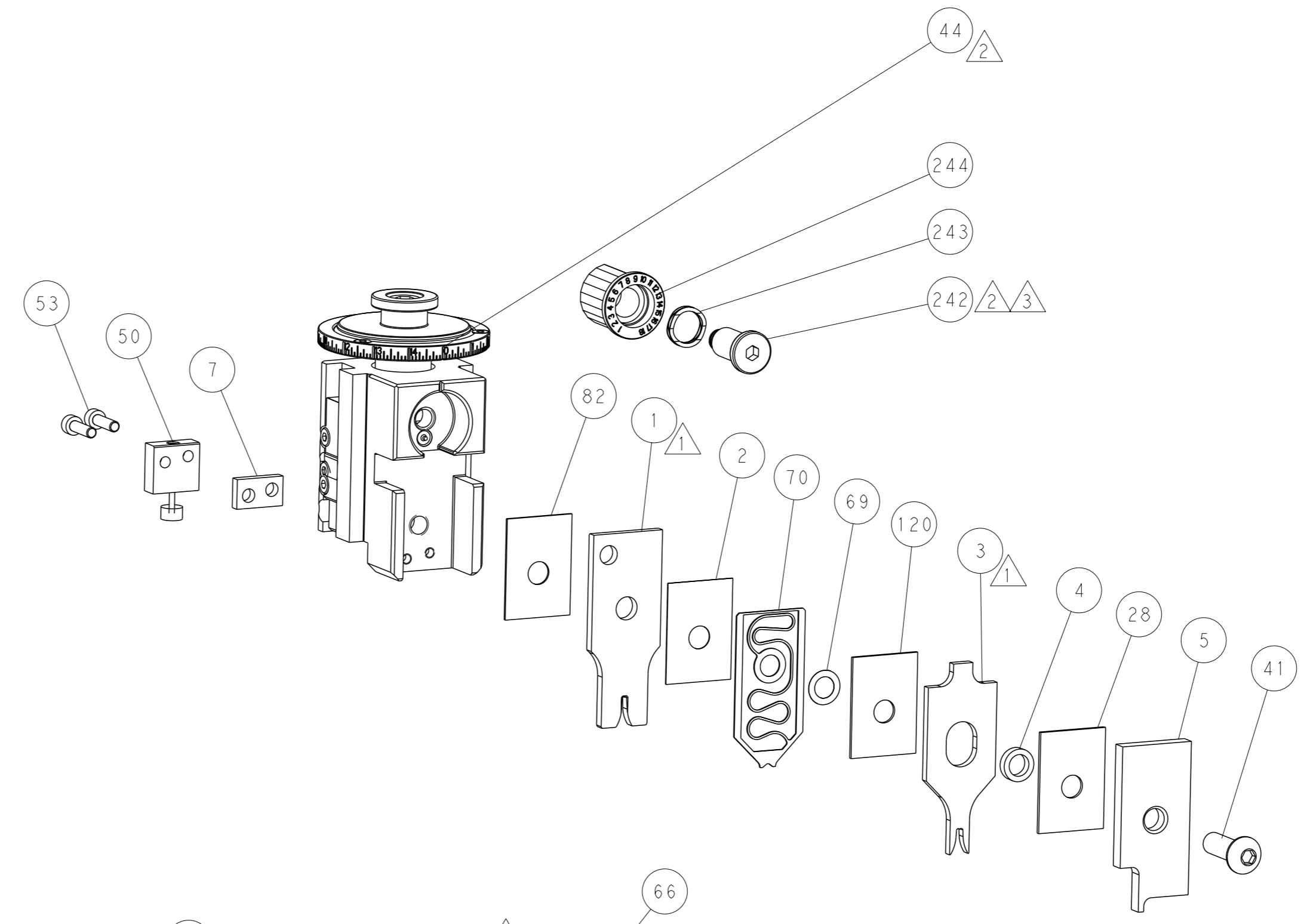
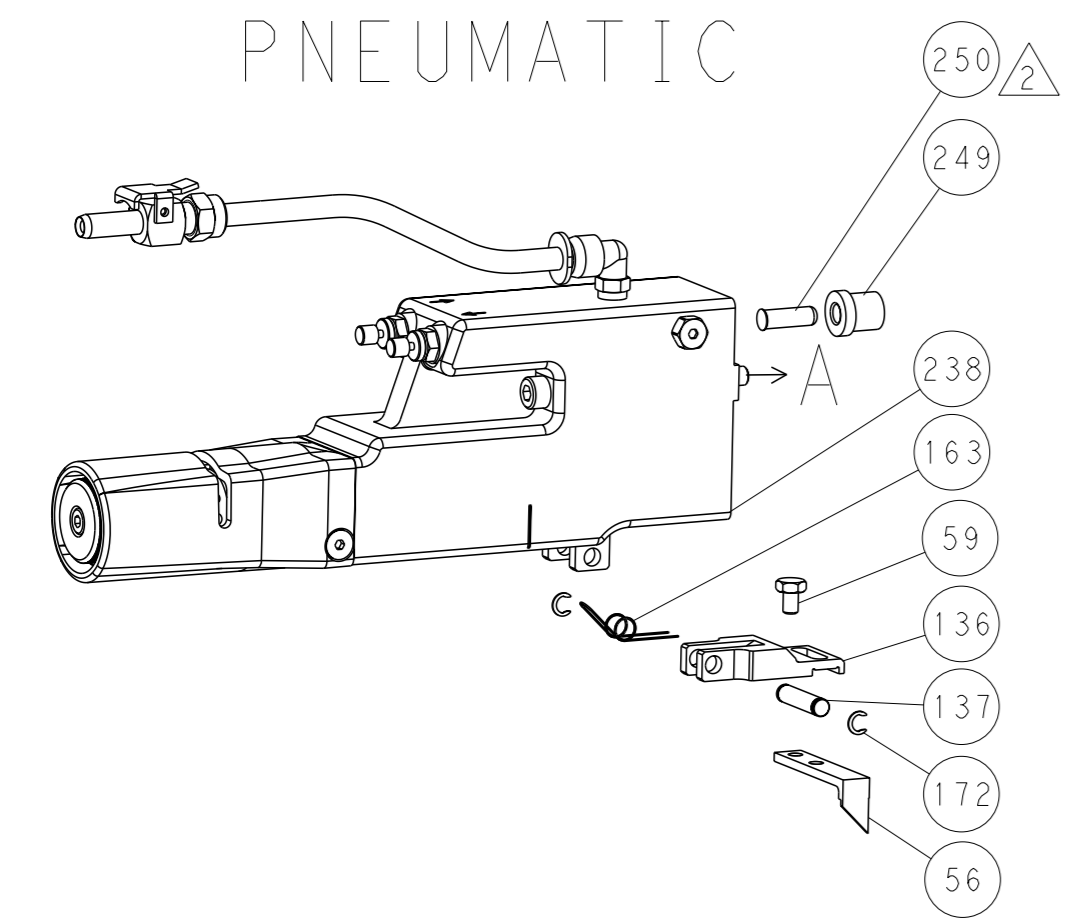
|  |                            |              |
|--|----------------------------|--------------|
| OWN                                    | Y. YIN                     | 15FEB2012    |
| CHK                                    | G. BAILEY                  | 15FEB2012    |
| APVD                                   | S. XI                      | 15FEB2012    |
| NAME                                   | Ocean Side Feed Applicator |              |
| SIZE                                   | CAGE CODE                  | DRAWING NO   |
| A1                                     | 00779                      | 2151612      |
| CUSTOMER ACCESSIBLE PRODUCTION DRAWING |                            |              |
| SCALE                                  | 1:2                        | SHEET 1 OF 4 |
| REV                                    | D                          |              |

| LOC | DIST | REV | DESCRIPTION | DATE | OWN | APVD |
|-----|------|-----|-------------|------|-----|------|
| A   | 66   |     | SEE SHEET 1 |      |     |      |

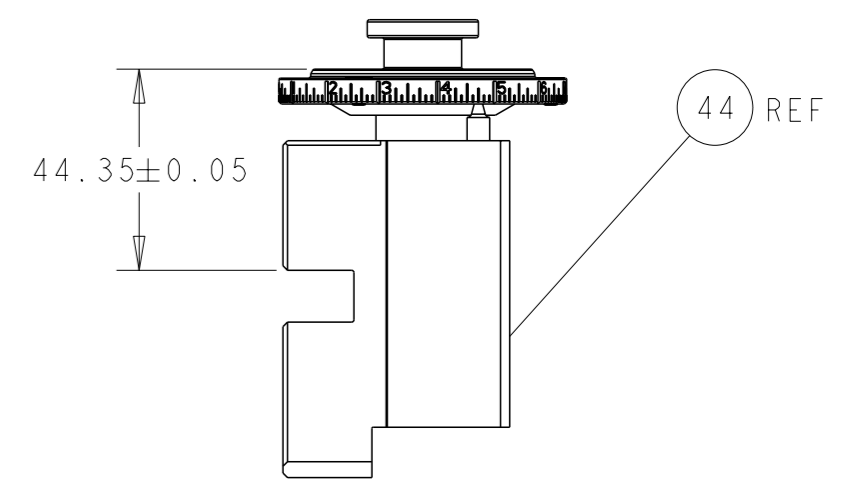
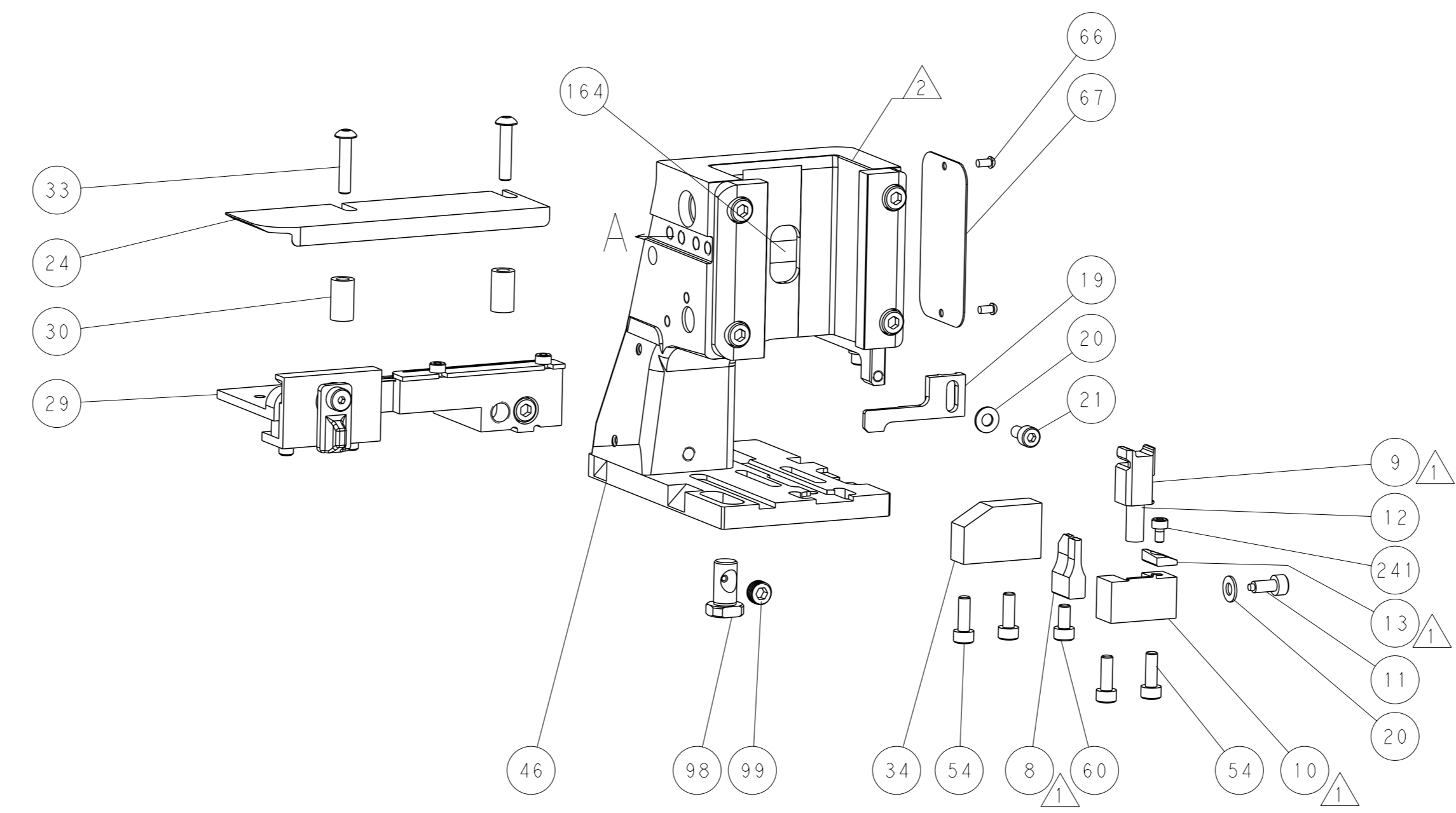
### FEED TYPE MECHANICAL



### PNEUMATIC

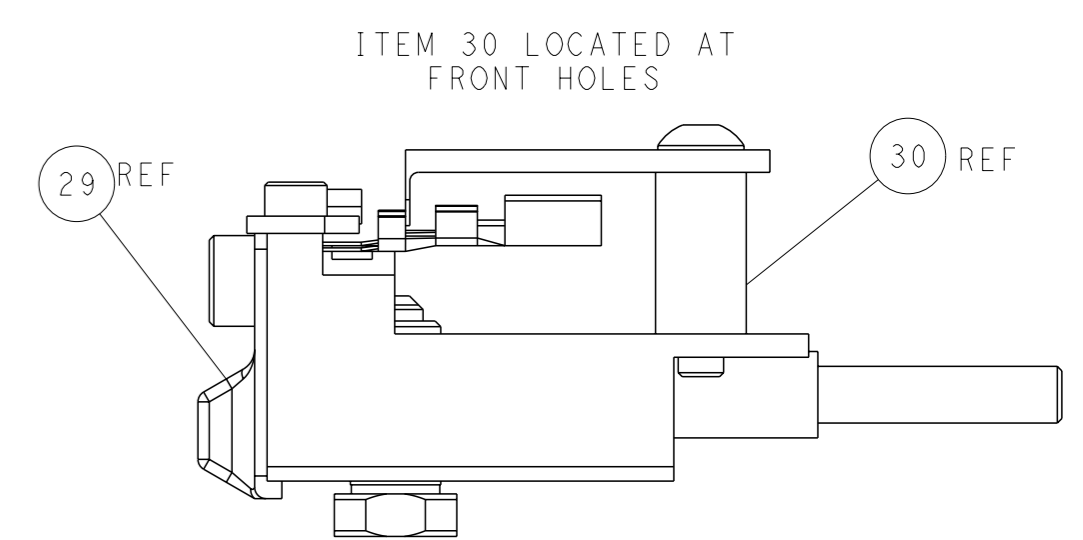
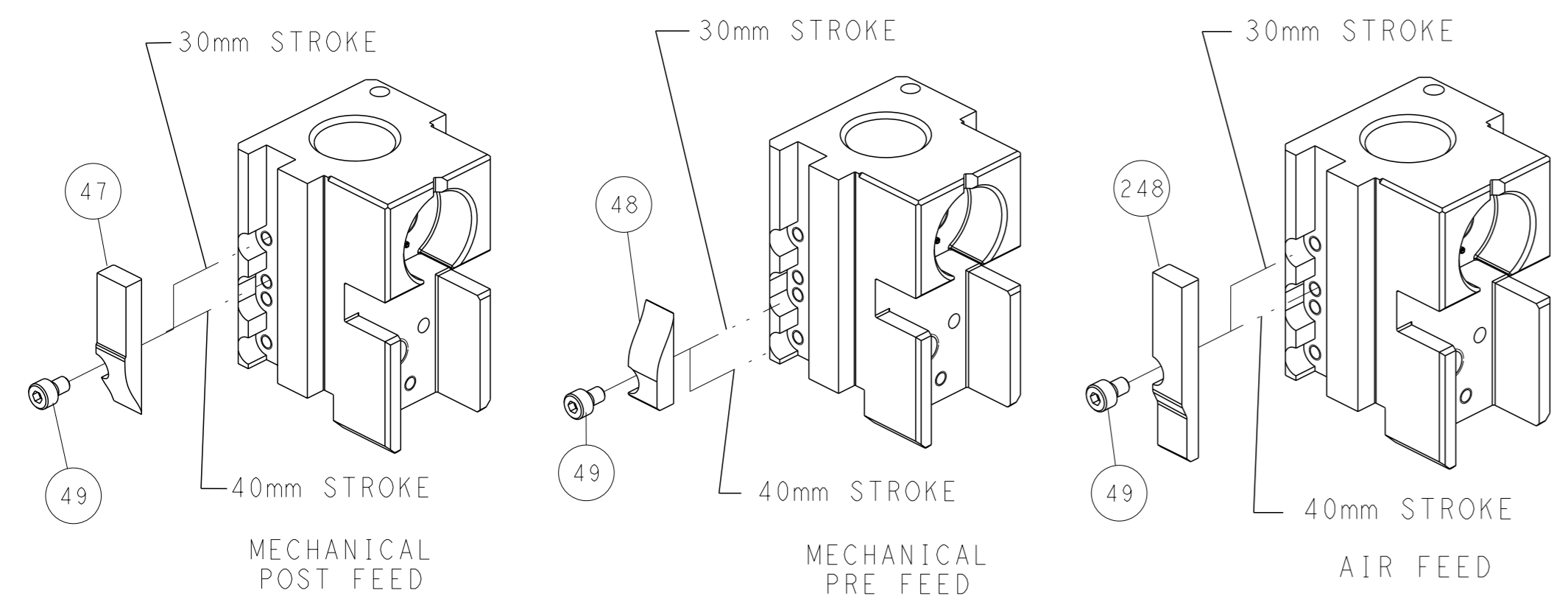


TERMINAL SUPPORT LOCATION



RAM SET-UP

### CAM POSITIONS



FEED TRACK POSITION  
GUIDE BY INSULATION BARREL

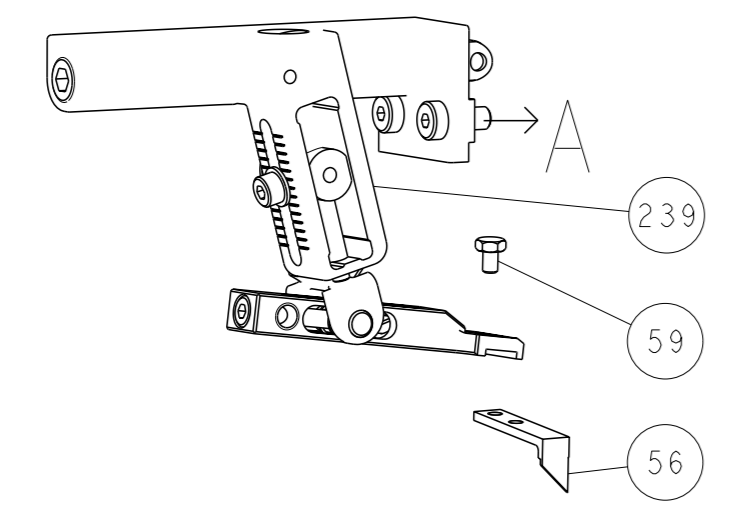
**ATLANTIC VERSION**  
 Shown on sheets 1 of 4 & 2 of 4  
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

|                       |  |   |  |   |  |  |  |                |  |
|-----------------------|--|---|--|---|--|--|--|----------------|--|
| DIMENSIONS:<br>mm<br> |  | TOLERANCES UNLESS OTHERWISE SPECIFIED:<br>0 PLC ±<br>1 PLC ±<br>2 PLC ±<br>3 PLC ±<br>4 PLC ±<br>ANGLES ± |  | OWN: Y. YIN 15FEB2012<br>CHK: G. BAILEY 15FEB2012<br>APVD: S. XI 15FEB2012<br>PRODUCT SPEC<br>APPLICATION SPEC<br>WEIGHT: -<br>CUSTOMER ACCESSIBLE PRODUCTION DRAWING |  | NAME: Ocean Side Feed Applicator<br>SIZE: A1<br>CAGE CODE: 00779<br>DRAWING NO: 2151612<br>SCALE: 1:2<br>SHEET: 2 of 4<br>REV: D |  | RESTRICTED TO: |  |
|-----------------------|--|---|--|---|--|--|--|----------------|--|

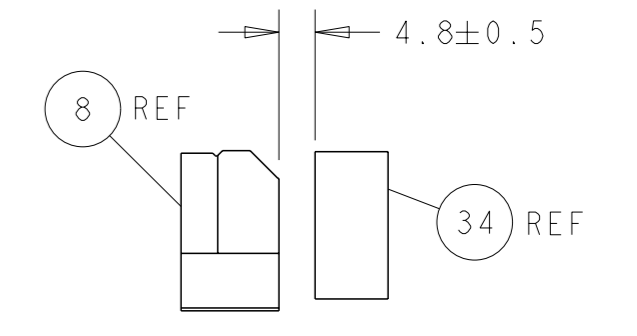
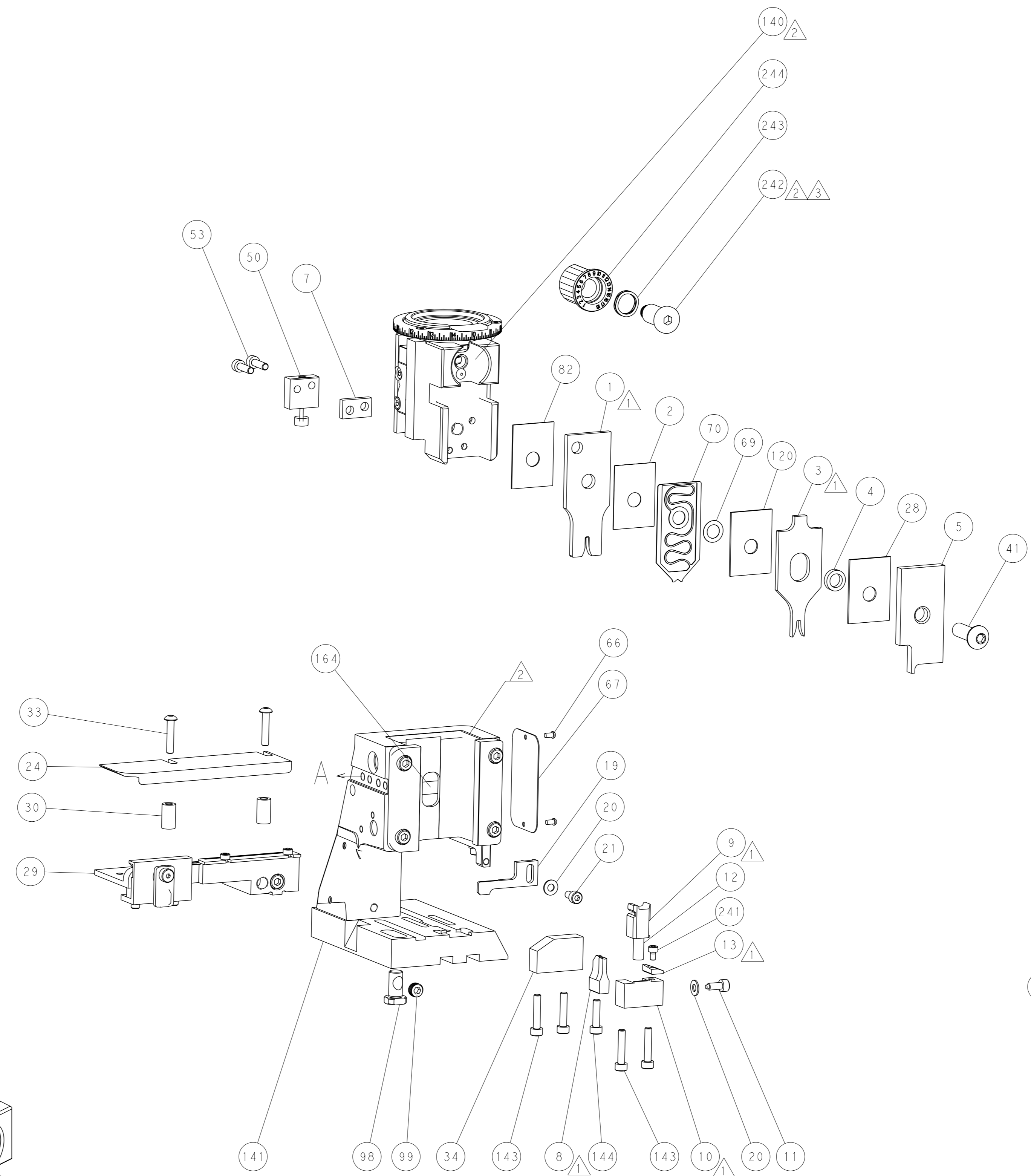
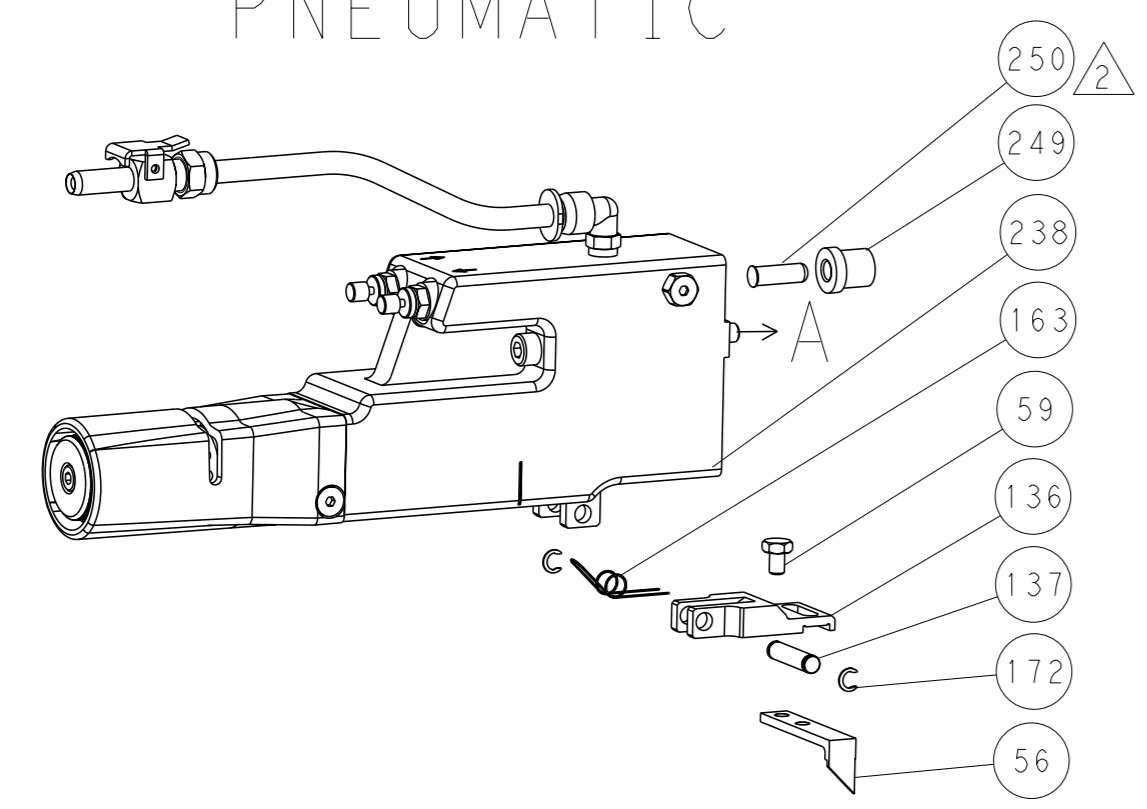


| LOC |    | DIST |     | REVISIONS   |      |     |      |
|-----|----|------|-----|-------------|------|-----|------|
| A   | 66 | P    | LYR | DESCRIPTION | DATE | OWN | APVD |
|     |    | -    |     | SEE SHEET 1 | -    | -   | -    |

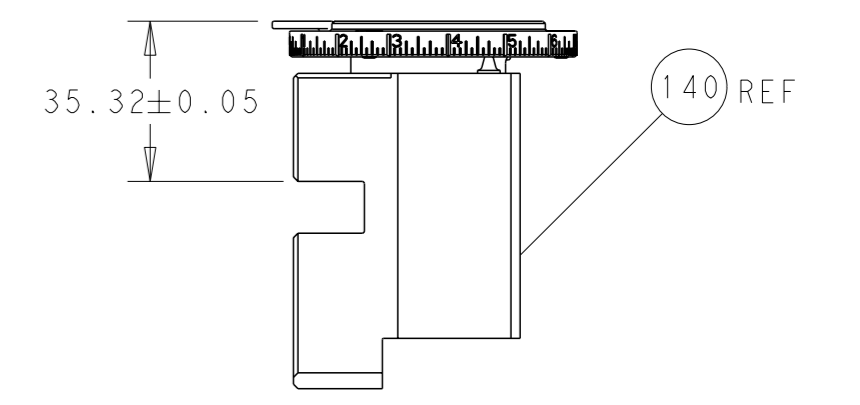
# FEED TYPE MECHANICAL



# PNEUMATIC

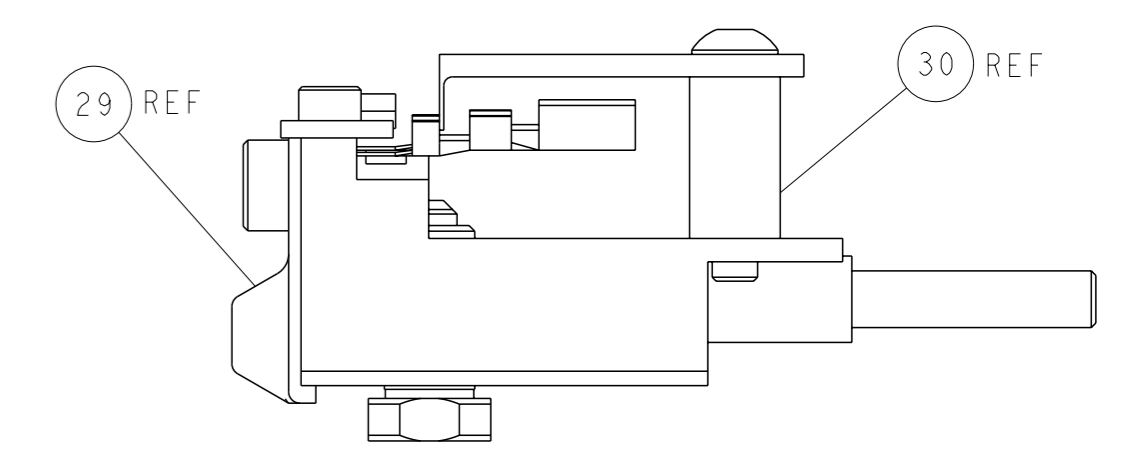


TERMINAL SUPPORT LOCATION



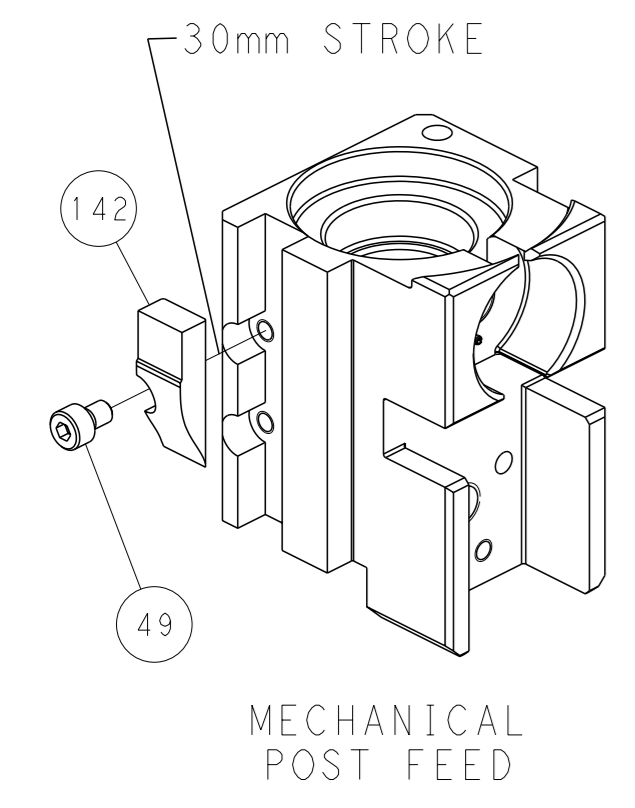
RAM SET-UP

ITEM 30 LOCATED AT FRONT HOLES

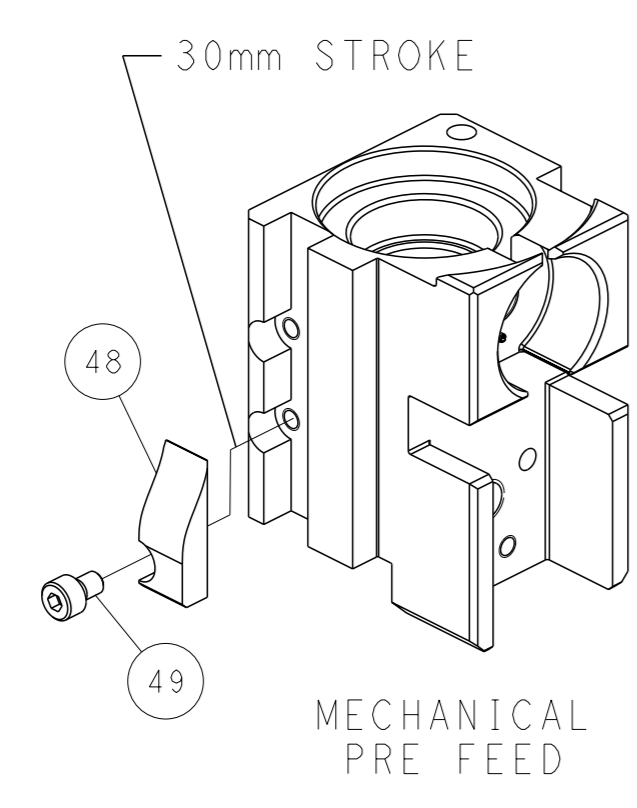


FEED TRACK POSITION GUIDE BY INSULATION BARREL

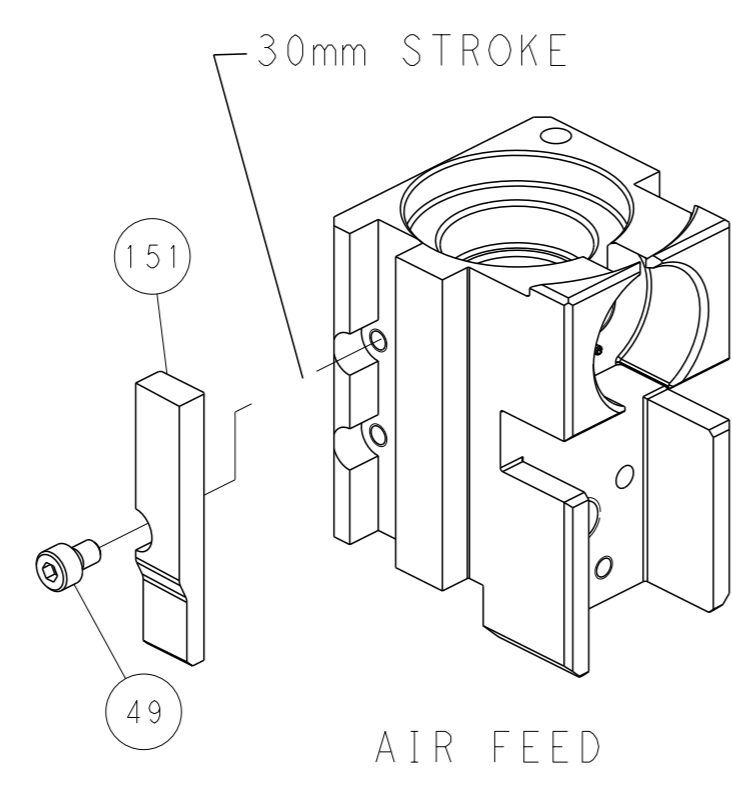
# CAM POSITIONS



MECHANICAL POST FEED



MECHANICAL PRE FEED



AIR FEED

**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 A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE AND THE USER MUST CONTACT THE ORGANIZATION WHOSE BY CONTACTS FOR THE LATEST REVISION.</small> |  | OWN: Y. YIN 15FEB2012<br>CHK: G. BAILEY 15FEB2012<br>APVD: S. XI 15FEB2012 | TE Connectivity<br>Harrisburg, PA 17105-3608 |
| DIMENSIONS: mm<br>TOLERANCES UNLESS OTHERWISE SPECIFIED:<br>0 PLC ±<br>1 PLC ±<br>2 PLC ±<br>3 PLC ±<br>4 PLC ±<br>ANGLES FINISH ±   | NAME: Ocean Side Feed Applicator<br>APPLICATION SPEC: -<br>SIZE: A1<br>CAGE CODE: 00779<br>DRAWING NO: C=2151612 | WEIGHT: -<br>SCALE: 1:2<br>SHEET: 4 of 4<br>REV: D                         | RESTRICTED TO: -                             |
| MATERIAL: -  |  | CUSTOMER ACCESSIBLE PRODUCTION DRAWING                                     |  |

# Mouser Electronics

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