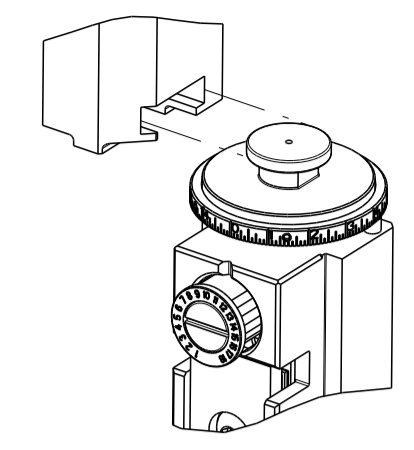


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151430-1	H	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2151430-2	H	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151430-1	H	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2151430-2	H	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2151430-7	H	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.00 mm [.039]	F
INSUL	1.40 mm [.055]	F

APPLICATOR INSTRUCTIONS 408-35042

TERMINAL DATA: MOLEX TERMINAL		MOLEX CRIMP SPECIFICATION	
TERMINAL NAME: 2.00mm PITCH MILLI-GRID TERMINAL			
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE		
1.30-1.80 mm [.051-.071 IN]	Ø0.80-1.40 mm [.031-.055 IN]		
TERMINAL APPLICATION SPECIFICATION	ATS-639005200 Rev. -		
TERMINALS APPLIED			
TE TERMINAL	MOLEX TERMINAL	TE TERMINAL	MOLEX TERMINAL
994698-1	50394-8052	1642397-1	50212-8000
994698-2	50394-8051	1949068-1	50394-8053
621528-1	50394-8051	1949068-2	50394-8054
1642396-1	50394-8051		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
24 AWG OR 0.20mm <sup>2</sup>	0.64 +/- 0.05 [.025 +/- .002]	8.6
26 AWG OR 0.12mm <sup>2</sup>	0.61 +/- 0.05 [.024 +/- .002]	8.9
28 AWG OR 0.08mm <sup>2</sup>	0.58 +/- 0.05 [.023 +/- .002]	9.2
30 AWG OR 0.05mm <sup>2</sup>	0.56 +/- 0.05 [.022 +/- .002]	9.4

- 1. RECOMMENDED SPARE PARTS.
- 2. REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- 3. APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 50. 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. 30 AWG / 0.05mm<sup>2</sup> WIRE SIZE IS NOT RECOMMENDED BY TE. BUT CAN BE USED AT CUSTOMERS DISCRETION.
- 6. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- 7. USE TERMINAL SUPPORT LOCATION SHOWN FOR TERMINALS WITH LOCKING LANCE.

**\*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.

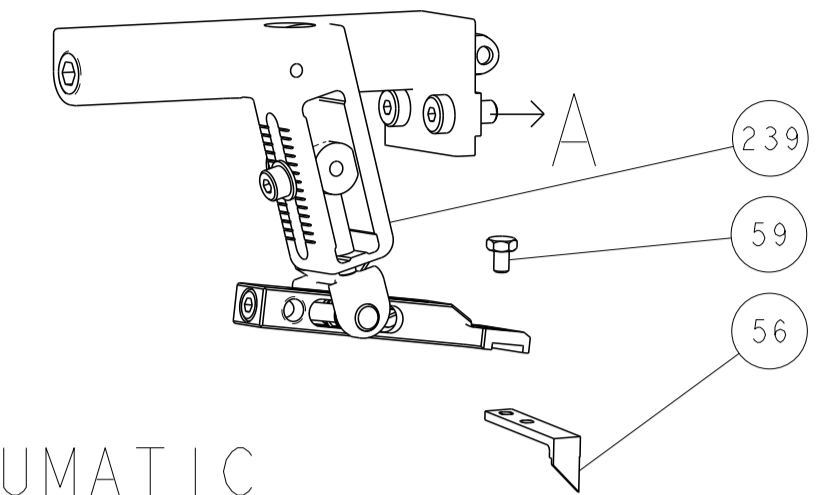
LOC	DIST	REVISIONS			
P	LTN	DESCRIPTION	DATE	OWN	APPD
A	66	E	ECR-18-007653	17MAY2018	AW CT
		F	ECR-18-015728	03OCT2018	JAH CT
		G	ECR-21-121975	24NOV2021	JWC TE
		H	ECR-24-200140	14FEB2024	TB GB

-	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	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	
-	2	2	2	2	1-2079383-0	SCR, BHSC, RoHS (M3 X 6)	230	
-	1	1	1	1	1-1976053-0	LOCATER BLOCK, TERMINAL	179	
-	1	1	1	1	993111-1	PIN, SLOTTED SPRING 3.0 X 20.0	177	
-	1	1	1	1	-	TEC Standard Metric Part Template	176	
-	1	1	1	1	1752353-2	GUIDE PIN, HOLDDOWN	175	
-	1	1	1	1	1901680-2	GUIDE PIN, HOLDDOWN	174	
-	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	1-455888-7	SPACER, CRIMPER -	82	
-	1	1	1	1	1803607-3	DOCUMENTATION PACKAGE	71	
-	1	1	1	1	2-2119791-2	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	
-	1	1	1	1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52	
-	1	1	1	1	1901681-4	HOLDDOWN, TERMINAL	51	
-	1	1	1	1	1752354-7	STANDOFF, HOLD-DOWN	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	1803515-3	RAM ASSEMBLY, SF ATLANTIC	44	
-	1	1	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41	
-	1	1	1	1	2-1752356-5	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	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	2119533-3	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	1-356885-3	STOP, SHEAR	11	
-	1	1	1	1	2119805-1	SHEAR HOLDER, FRONT -	10	
-	1	1	1	1	1803095-6	FLOATING SHEAR, FRONT -	9	
-	1	2	2	1	1	4-1803756-4	ANVIL, COMBINATION	8
-	-	-	-	-	-	-	7	
-	-	-	-	-	-	-	6	
-	1	1	1	1	2119757-5	DEPRESSOR, SHEAR	5	
-	1	1	1	1	2-238011-0	BLOCK, CRIMPER SPACER	4	
-	1	2	2	1	1	5-1803223-0	CRIMPER, INSULATION F PREMIUM -	3
-	1	1	1	1	455888-3	SPACER, CRIMPER -	2	
-	1	2	2	1	1	5-1490019-0	CRIMPER, WIRE PREMIUM	1

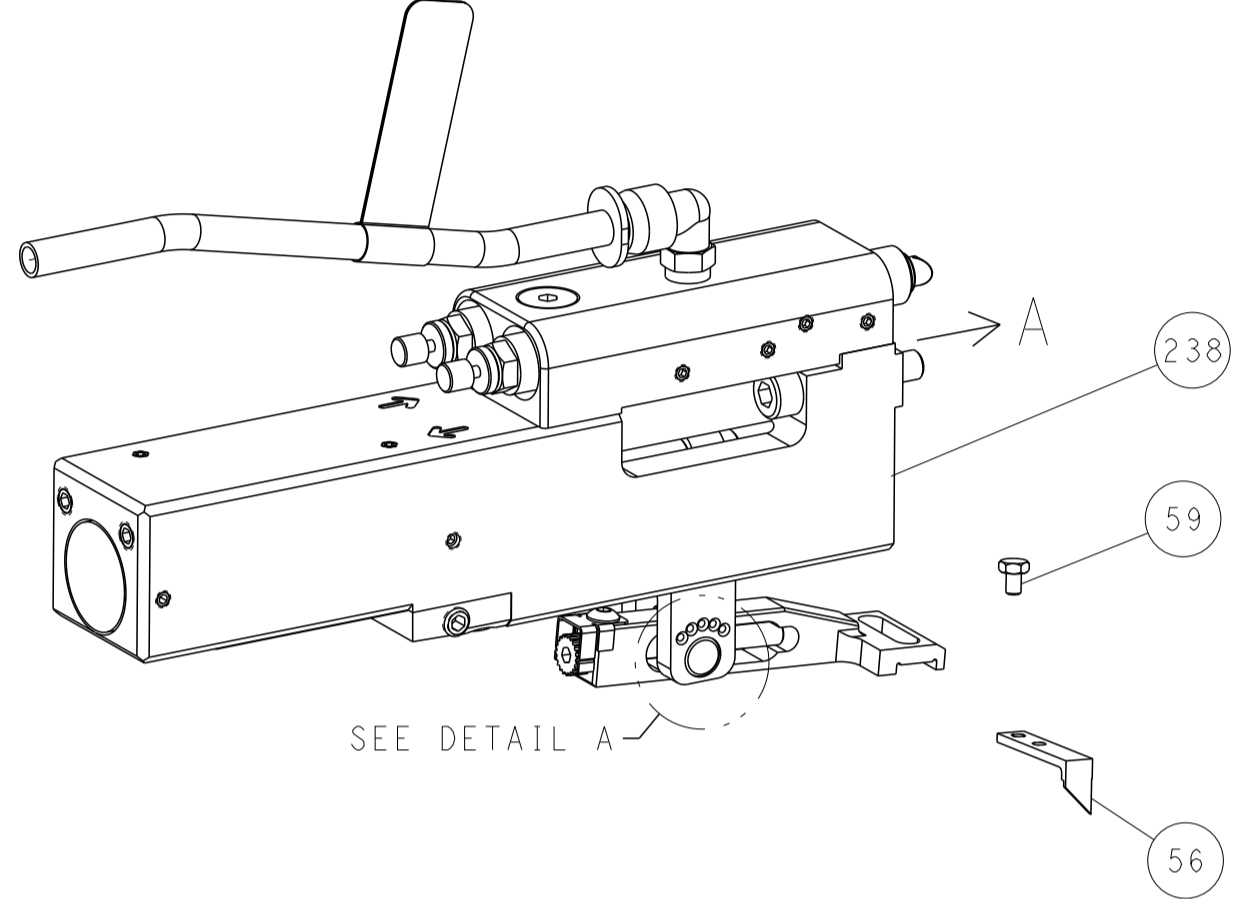
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG: X.ZHAO 11MAY2012		TE Connectivity	
mm		0 PLC ±		CHK: T.ELBIN 11MAY2012		Harrisburg, PA 17105-3608	
Ø		1 PLC ±		APPD: S.XI 11MAY2012		NAME: Ocean Side Feed Applicator	
H		2 PLC ±		PRODUCT SPEC		SIZE: CAGE CODE: DRAWING NO: RESTRICTED TO	
D		3 PLC ±		APPLICATION SPEC		A   00779 C=2151430	
R		4 PLC ±		WEIGHT		SCALE: 1:2 SHEET 1 OF 4 REV H	
ANGLES		FINISH		MATERIAL		Customer Accessible Production Drawing	

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

# FEED TYPE MECHANICAL



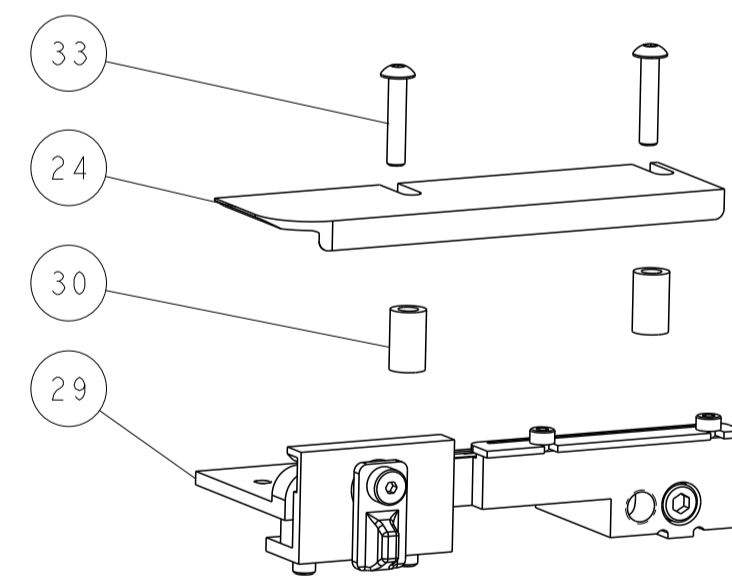
## PNEUMATIC



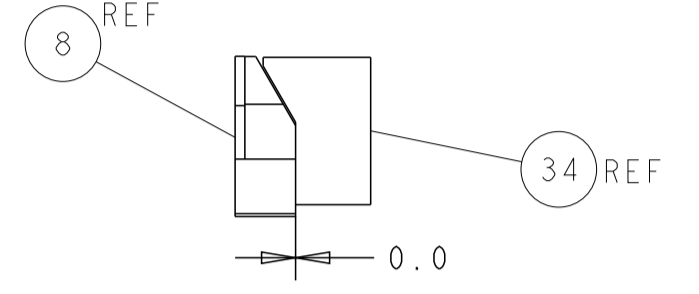
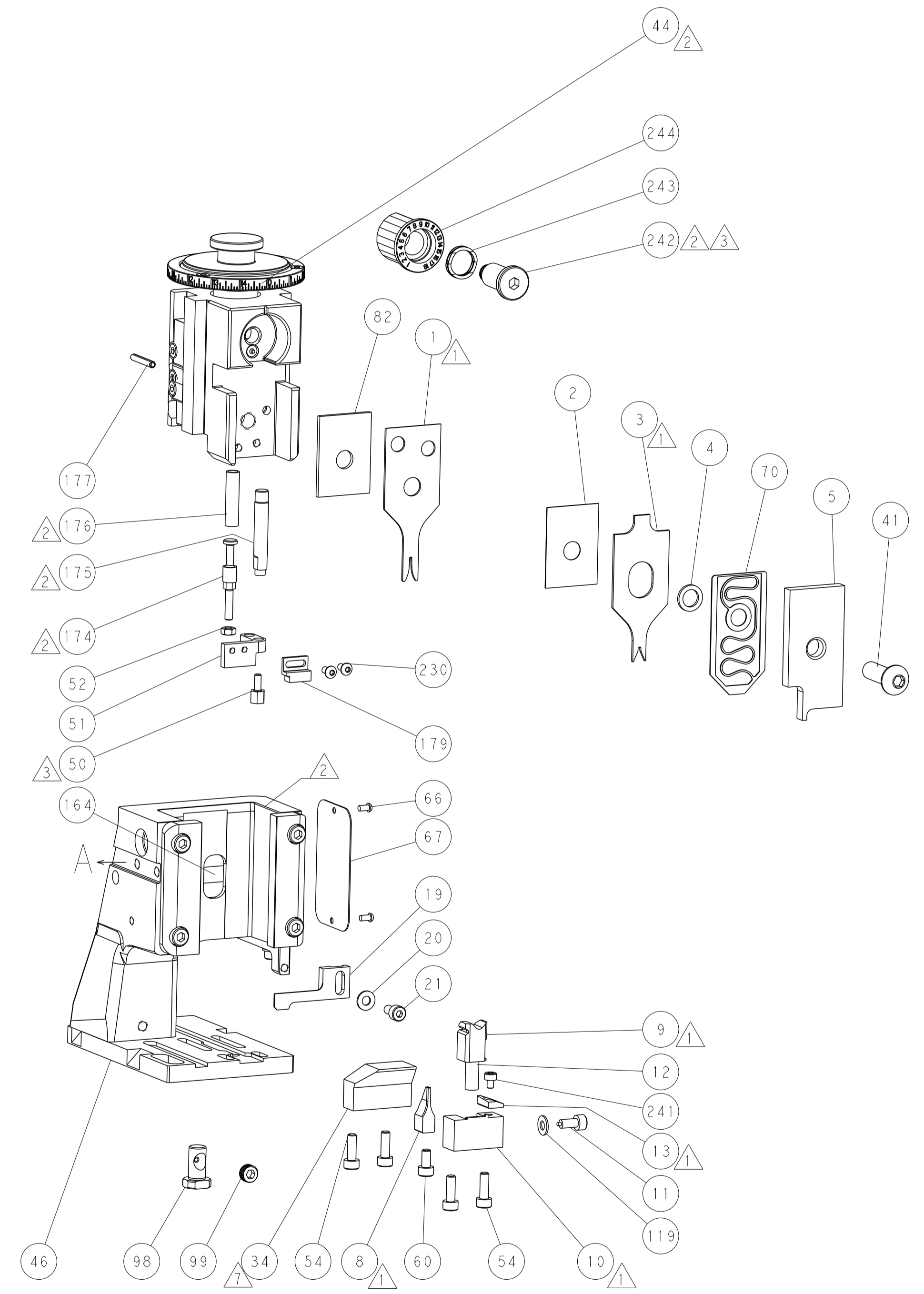
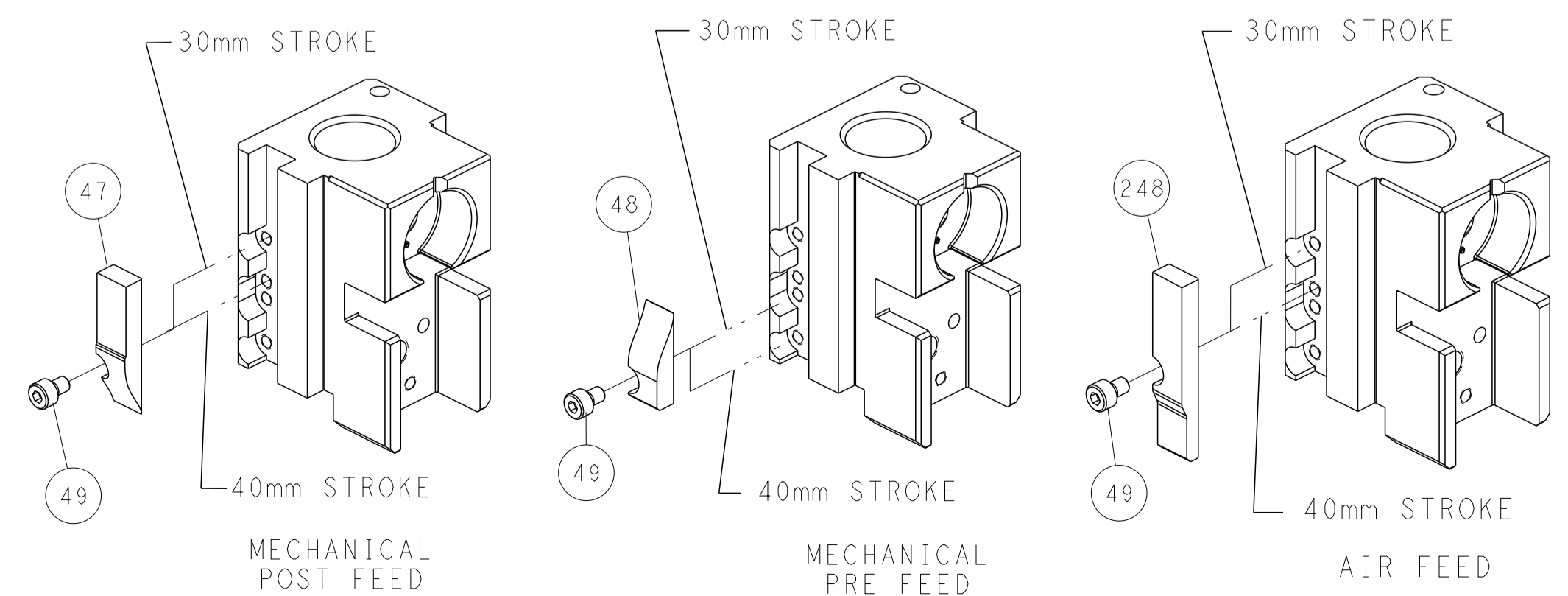
## FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



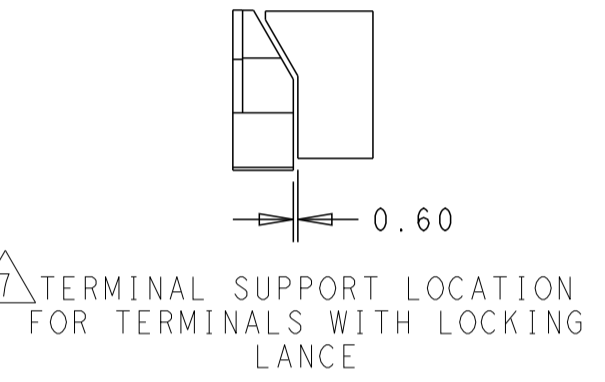
DETAIL A



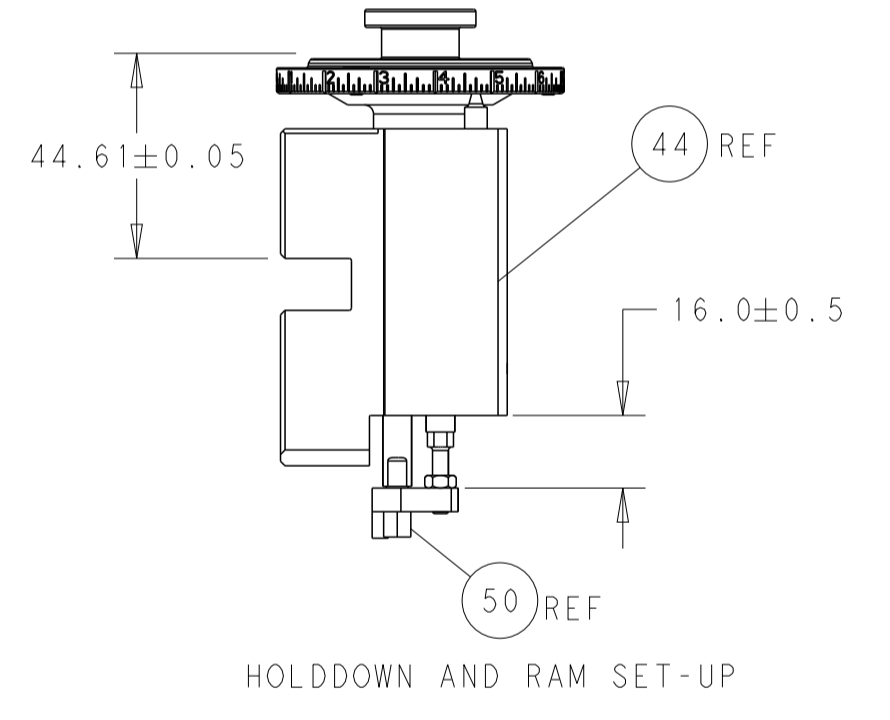
# CAM POSITIONS



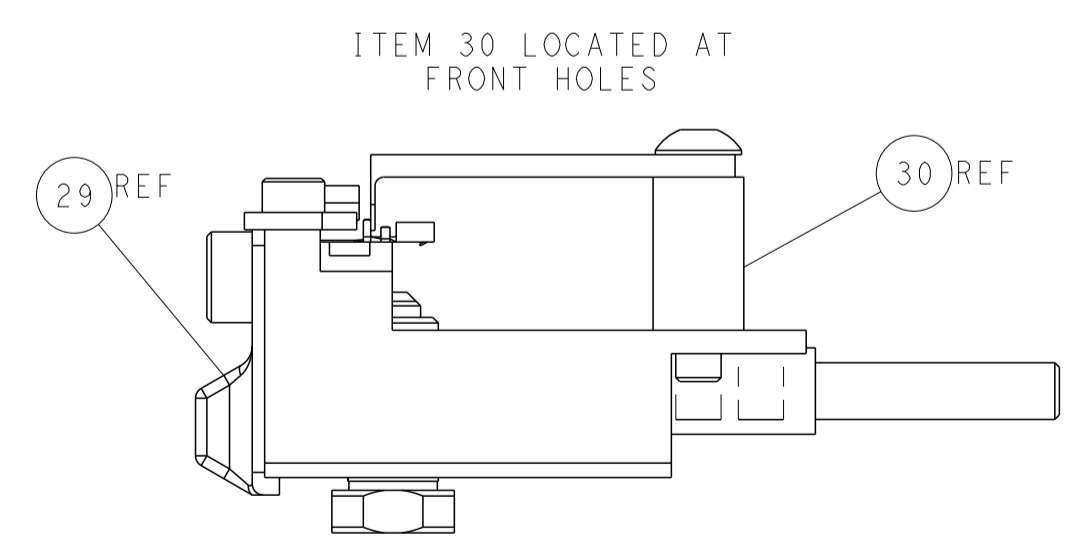
TERMINAL SUPPORT LOCATION



TERMINAL SUPPORT LOCATION FOR TERMINALS WITH LOCKING LANCE



HOLDDOWN AND RAM SET-UP



FEED TRACK POSITION GUIDE BY INSULATION BARREL

DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH		DWN X.ZHAO 11MAY2012 CHK T.ELBIN 11MAY2012 APVD S.XI 11MAY2012 PRODUCT SPEC APPLICATION SPEC WEIGHT Customer Accessible Production Drawing		NAME Ocean Side Feed Applicator SIZE CAGE CODE DRAWING NO A1 00779 C=2151430 SCALE 1:2 SHEET 2 OF 4 REV H	
MATERIAL:				RESTRICTED TO:		SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION	