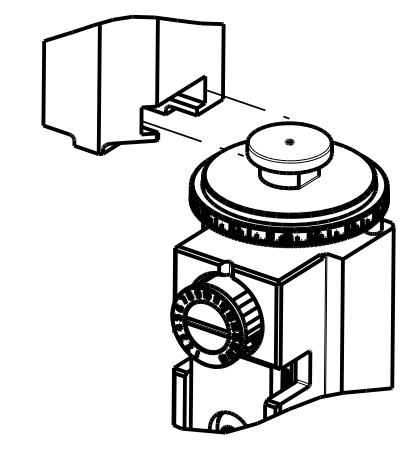


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151701-1	D	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2151701-2	E	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
5-2151701-1	D	SEAL STRIPPER CRIMPER TERMINATING UNIT	MECHANICAL
5-2151701-2	E	SEAL STRIPPER CRIMPER TERMINATING UNIT	PNEUMATIC
7-2151701-1	D	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2151701-2	E	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2151701-7	B	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.29 mm [.090]	F
INSUL	3.43 mm [.135]	O

APPLICATOR INSTRUCTIONS
408-35042

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: TAB 1.6 x 0.6mm			
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE		
3.70-4.30 mm [.146-.169 IN]	1.95-2.4mm [.077-.094 IN]		
TERMINAL APPLICATION SPECIFICATION			
114-18082			
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE SEAL	TE SEAL
1703278-2	1703278-5		964972-1
			2112323-1

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.50mm2	1.50+/-0.05 [.059+/- .002]	10.1

- 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 ITEMS 180. 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 APPLY TORO-SEAL IN ALLEN SOCKET TO FILL HOLE AFTER FLAT HD HAS BEEN ADJUSTED TO CORRECT HEIGHT AT QUALIFICATION. APPLY #1-23419-5 LOC-TITE TO THREADS.
- 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.

LOC	DIST	REV	DATE	BY	CHKD	APPROV
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		D	19JUN2016	JAH	JDG	
		E	19MAR2021	FJ	GB	

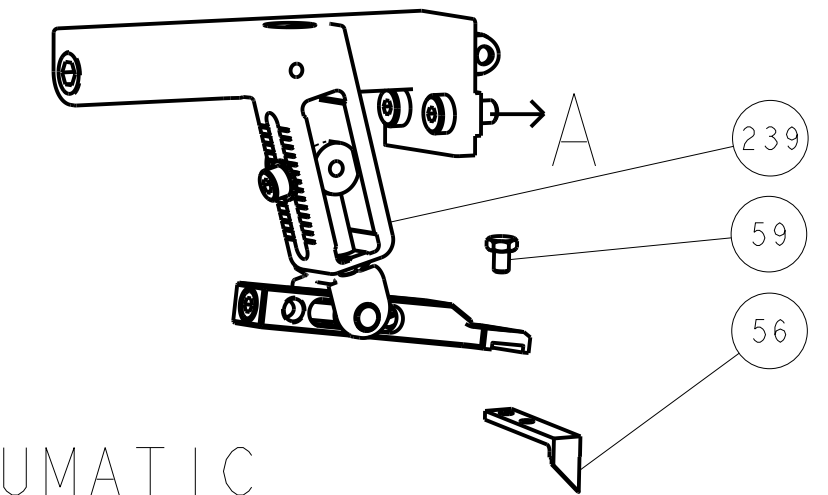
QTY	UNIT	DESCRIPTION	DATE	BY	CHKD	APPROV
-	-	1803515-3				
-	-	2-1803583-1				
-	1	2119641-1				
-	1	2119082-5				
-	1	2079764-1				
-	1	2119083-1				
-	1	7-18023-7				
-	-	2119580-1				
-	1	2844940-1				
-	-	4-1722335-3				
-	-	1-5018030-0				
-	-	1-1752354-9				
-	-	993111-1				
-	-	5-22280-0				
-	-	1752353-3				
-	-	1901680-2				
-	REF	994970-2				
-	1	2844908-1				
-	1	2844907-1				
-	1	455888-4				
-	1	1803607-3				
-	1	2119740-1				
-	2	2168078-1				
-	1	2168083-2				
-	1	5-18022-5				
-	1	985575-3				
-	1	1338685-1				
-	4	2168083-3				
-	2	2-2168083-5				
-	1	1803382-6				
-	1	18023-9				
-	-	2119652-1				
-	-	2119653-1				
-	1	1803583-9				
-	1	1803515-1				
-	1	1803602-1				
-	1	1-1752356-8				
-	2	2079383-5				
-	2	3-2844962-0				
-	1	2844992-2				
-	1	455888-4				
-	1	1320928-2				
-	1	2168083-2				
-	2	1-18028-2				
-	1	2119533-1				
-	1	2119806-1				
-	1	3-22280-3				
-	1	1-356885-4				
-	1	2119805-1				
-	1	318707-1				
1	2	1633132-9				
-	1	3-240641-0				
-	-	-				
-	1	2119781-1				
-	1	238011-4				
1	2	4-1722335-9				
-	1	455888-6				
1	2	4-456406-7				

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

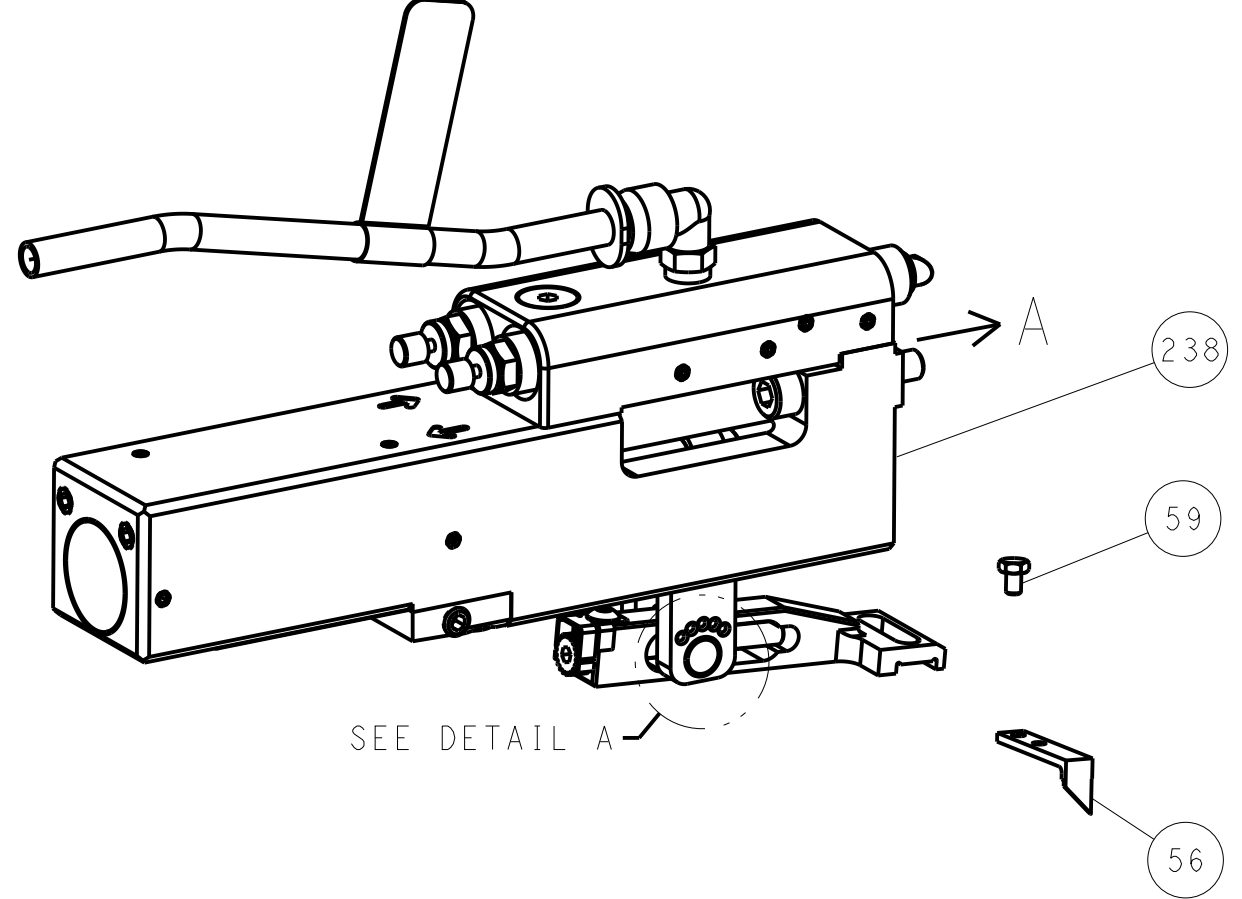
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mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±
MATERIAL:		FINISH:		APPROV. S. XI 03JUL2012	
WEIGHT:		SCALE:		NAME: Ocean Side Feed Applicator	
Customer Accessible Production Drawing		SCALE: 1:2		SHEET 1 OF 4	

LOC	DIST	REV	DATE	BY	APPV
A	66				

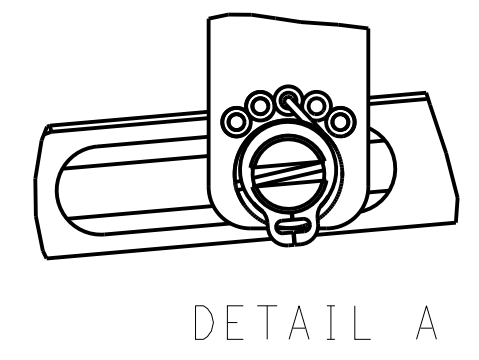
FEED TYPE MECHANICAL



PNEUMATIC

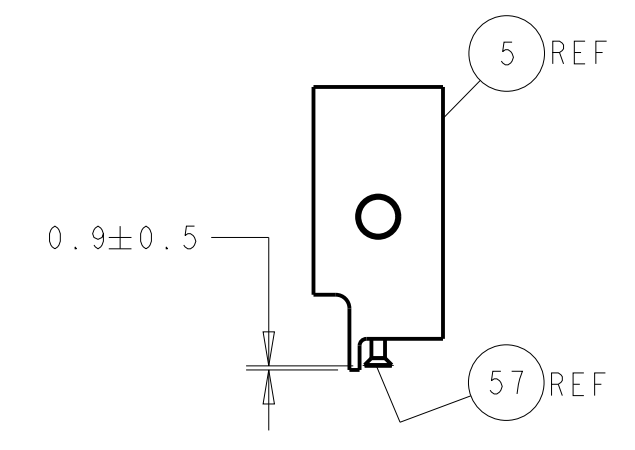
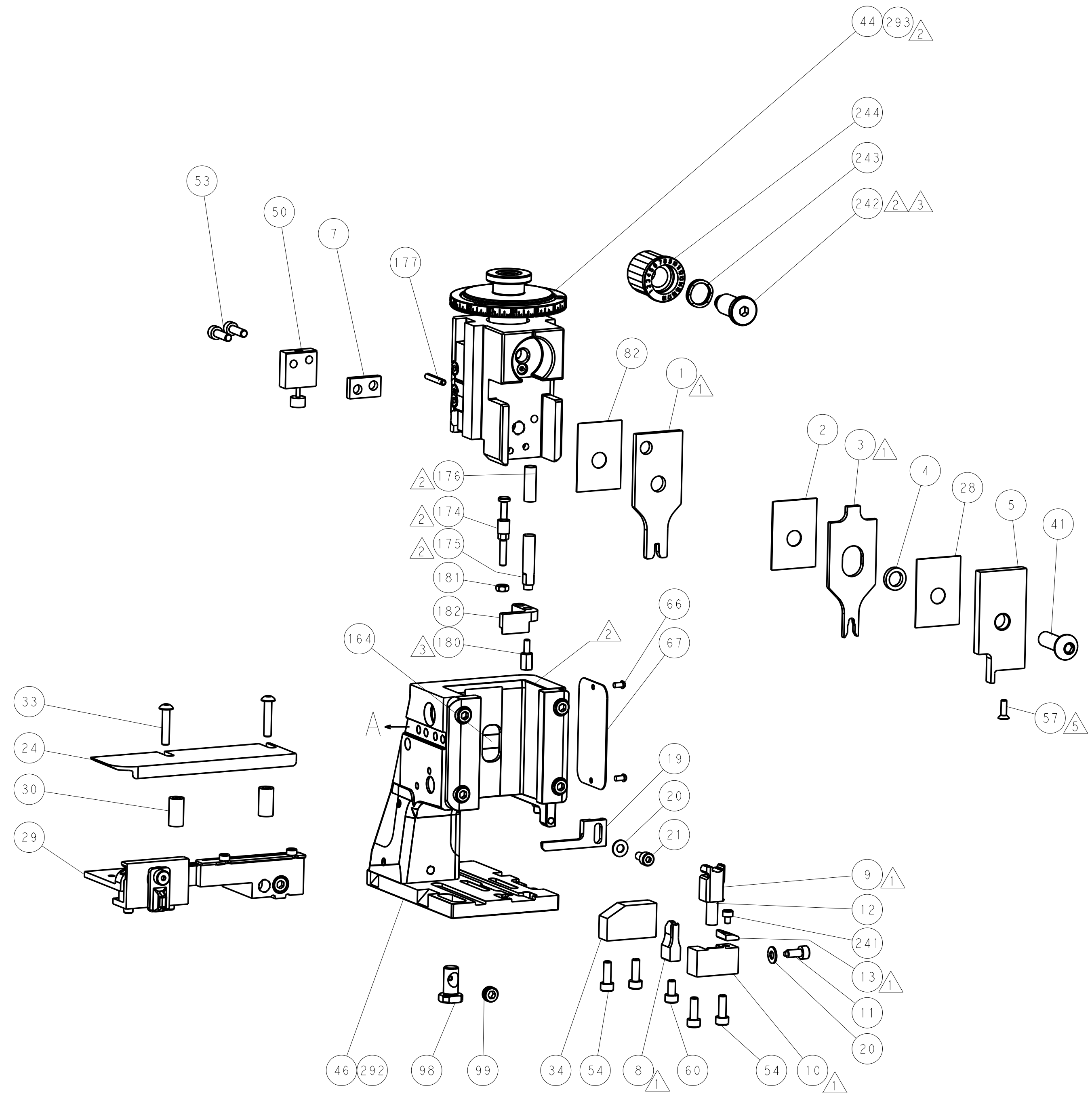
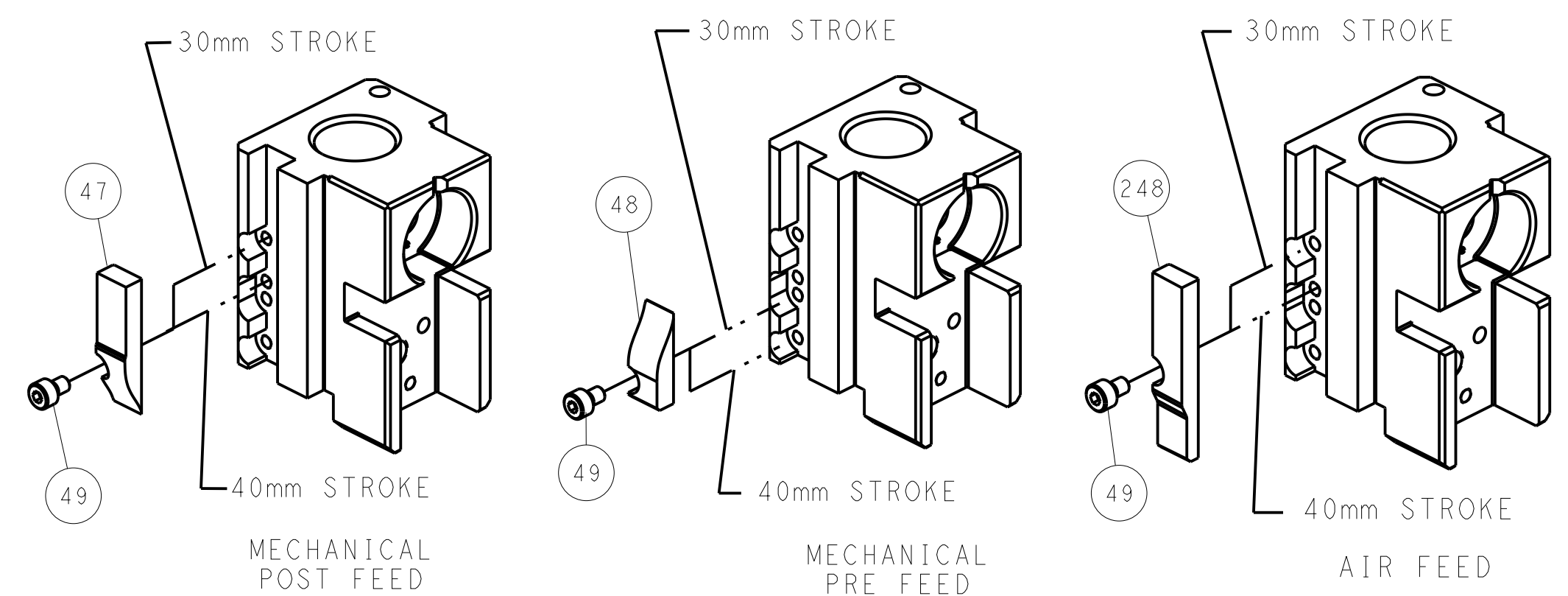


FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)

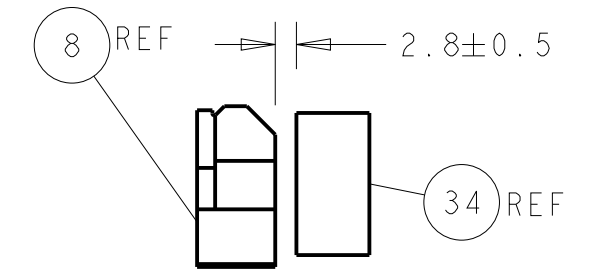


DETAIL A

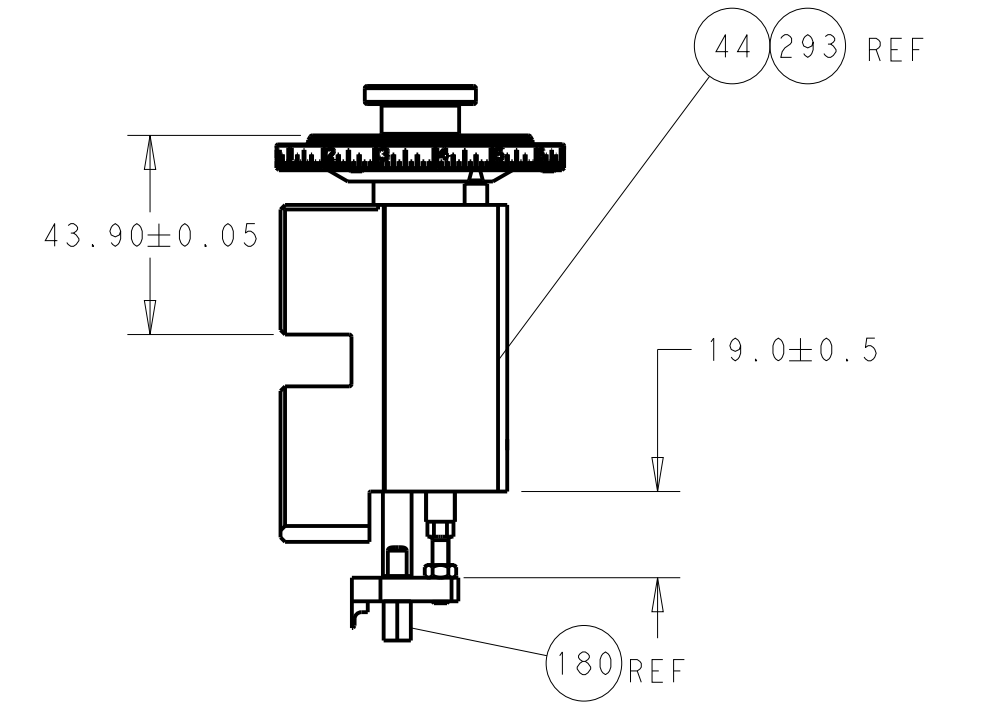
CAM POSITIONS



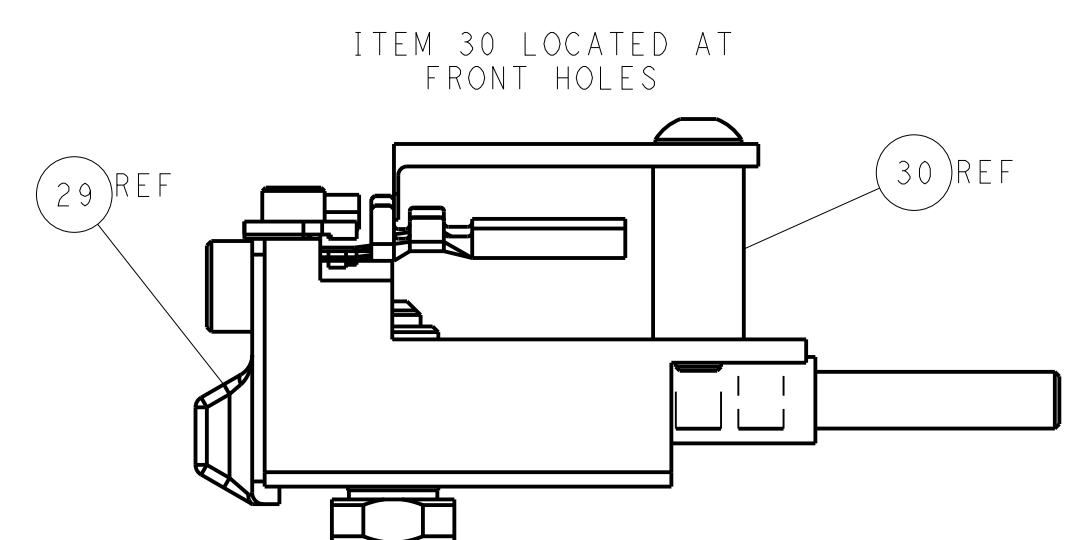
SHEAR DEPRESSOR DETAIL



TERMINAL SUPPORT LOCATION



RAM AND HOLDDOWN SET-UP



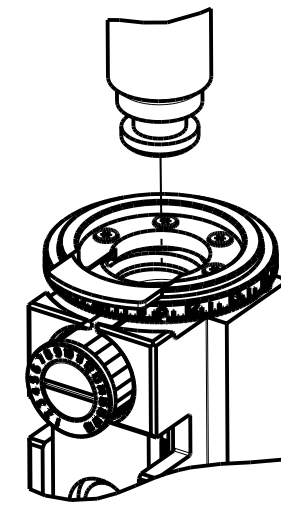
FEED TRACK POSITION GUIDE BY INSULATION BARREL

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

DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		DWN: A. HUANG 03JUL2012 CHK: S. XI 03JUL2012 APVD: S. XI 03JUL2012 PRODUCT SPEC APPLICATION SPEC WEIGHT SCALE: 1:2 SHEET 2 OF 4 REV E		NAME: Ocean Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2151701 RESTRICTED TO:	
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THIS DRAWING IS UNPUBLISHED.	RELEASED FOR PUBLICATION		
COPYRIGHT © BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.			
PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2151701-1	D	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2151701-2	E	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151701-7	B	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.29 mm [.090]	F
INSUL	3.43 mm [.135]	O
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: TAB 1.6 x 0.6mm			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
3.70-4.30 mm [1.46-.169 IN]		∅ 1.95-2.4mm [1.077-.094 IN]	
TERMINAL APPLICATION SPECIFICATION	114-18082		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE SEAL	TE SEAL
1703278-2	1703278-5		964972-1
			2112323-1
			SEAL INSULATION DIAMETER RANGE
			1.9-2.4 mm
			2.2-2.4 mm

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.50mm ²	1.50 +/- 0.05 [1.059 +/- .020]	10.1

- 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 APPLY TORO-SEAL IN ALLEN SOCKET TO FILL HOLE AFTER FLAT HD HAS BEEN ADJUSTED TO CORRECT HEIGHT AT QUALIFICATION. APPLY #1-23419-5 LOC-TITE TO THREADS.
- 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.

LOC	DIST	REV	LTN	DESCRIPTION	DATE	OWN	APVD
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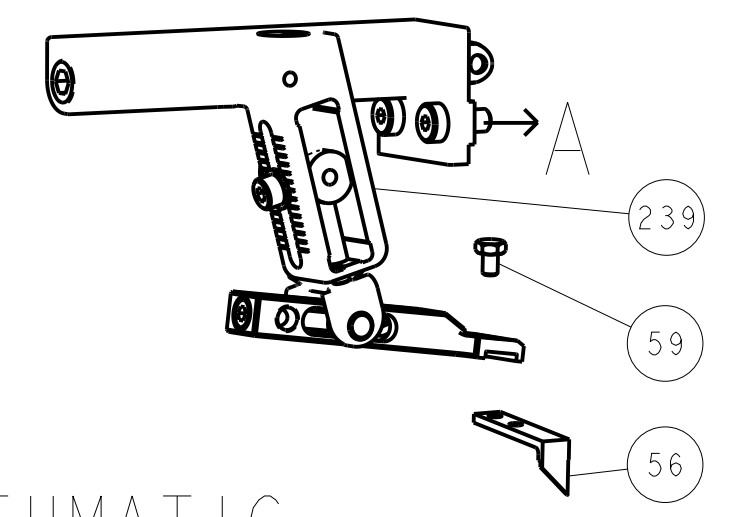
-	1	1	2119082-5	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
-	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	1	-	2844940-1	AIR FEED MODULE	238
-	REF	REF	994970-2	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	1803516-1	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
-	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	985575-3	SCR, FLT SKT HD CAP M3 X 10.0	57
-	1	1	1338685-1	PAWL, FEED	56
-	2	2	2-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 14	53
-	1	1	1803382-6	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	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
-	1	1	1-1752356-8	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	2844992-2	ASSEMBLY, STRIP GUIDE	29
-	1	1	455888-4	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	318707-1	FLOATING SHEAR, FRONT	9
1	1	1	1633132-9	ANVIL, COMBINATION .090	8
-	1	1	3-240641-0	SPACER	7
-	-	-	-	-	6
-	1	1	2119781-1	DEPRESSOR, SHEAR	5
-	1	1	238011-4	BLOCK, CRIMPER SPACER	4
1	1	1	4-1722335-9	CRIMPER, INSULATION O	3
-	1	1	455888-6	SPACER, CRIMPER	2
1	1	1	4-456406-7	CRIMPER, WIRE PREMIUM	1
-77	-22	-21	PART NO	DESCRIPTION	ITEM NO

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

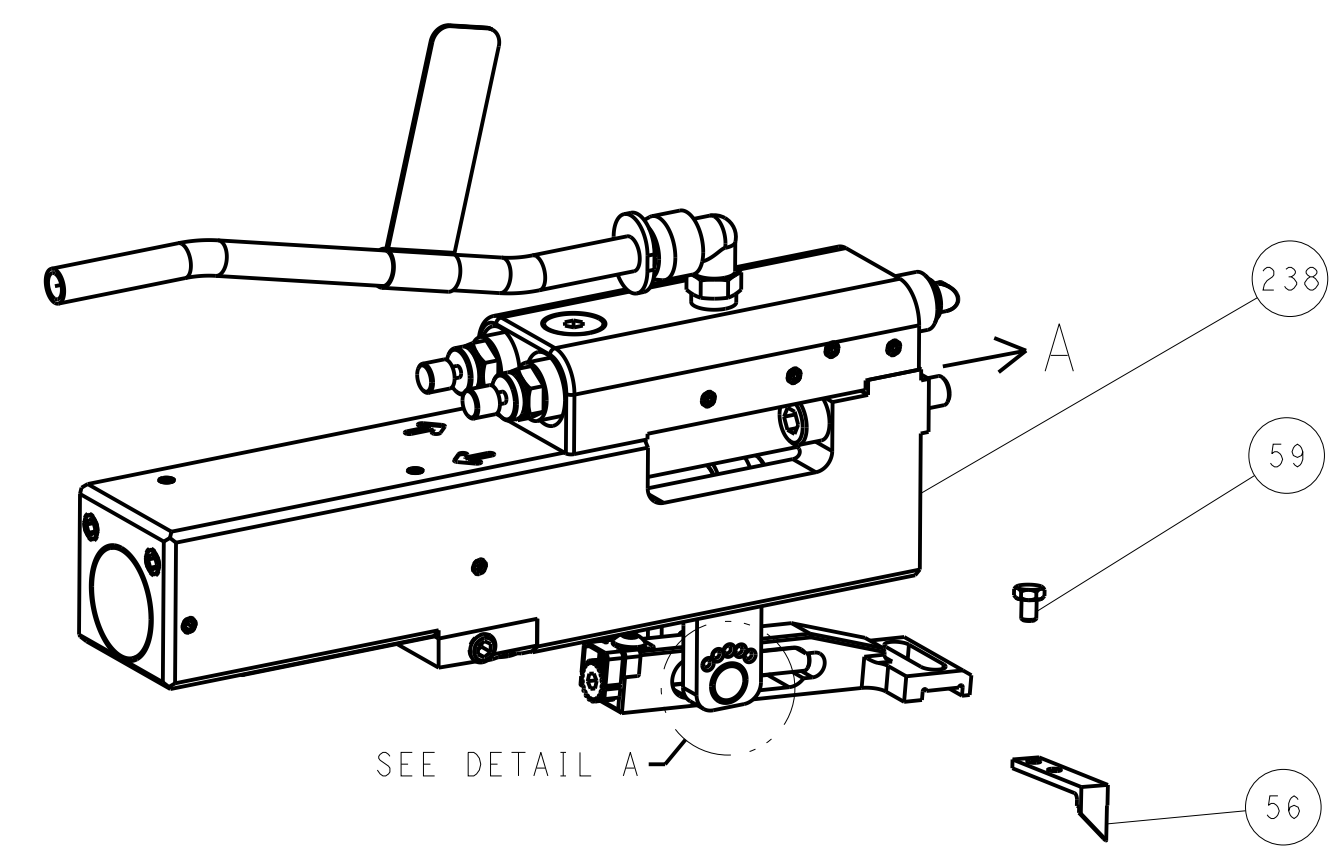
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mm	0 PLC ±	1 PLC ±	2 PLC ±	CHK: S. XI 03JUL2012	TE Connectivity Harrisburg, PA 17105-3608
	3 PLC ±	4 PLC ±	ANGLES ±	APVD: S. XI 03JUL2012	NAME: Ocean Side Feed Applicator
MATERIAL:	FINISH:	WEIGHT:	SCALE:	SIZE: A1	CAGE CODE: 00779
			1:2	DRAWING NO: 2151701	RESTRICTED TO: Customer Accessible Production Drawing
			SHEET 3 OF 4	REV E	

LOC	DIST	REV	DATE	BY	APP'D
A	66				

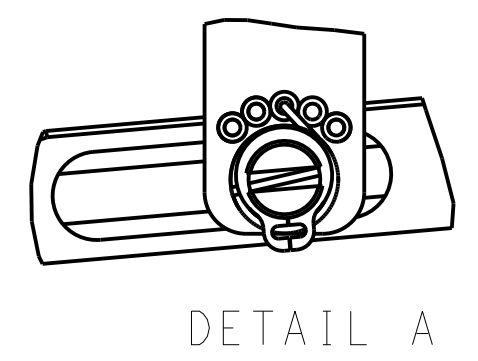
FEED TYPE MECHANICAL



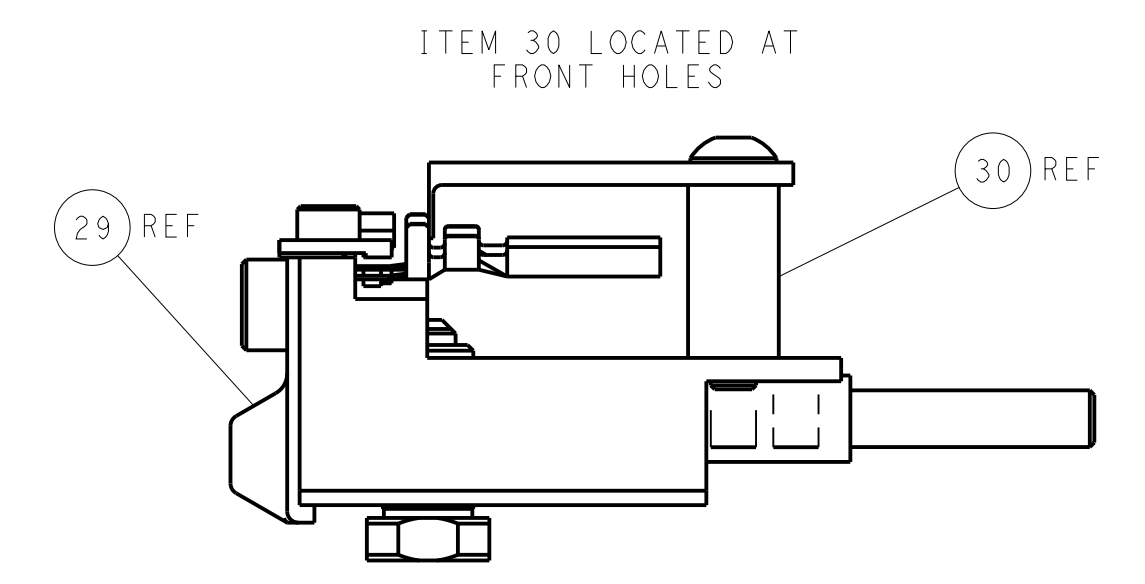
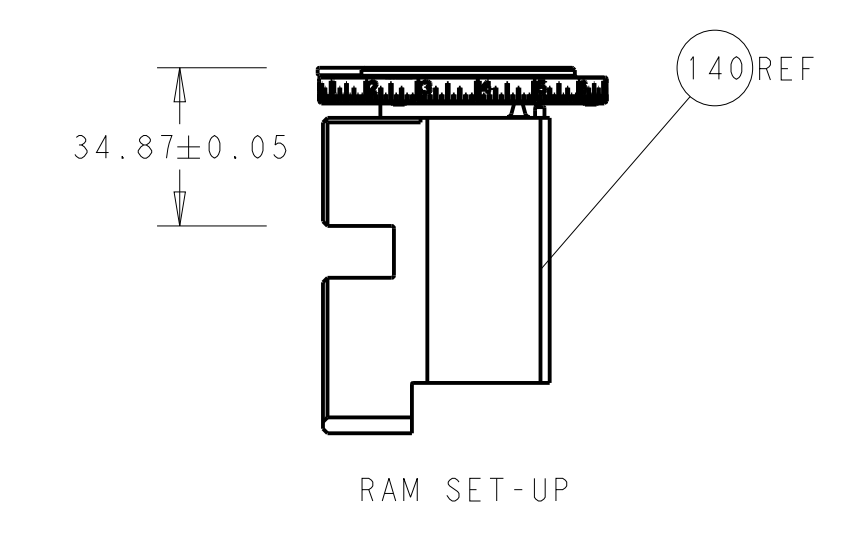
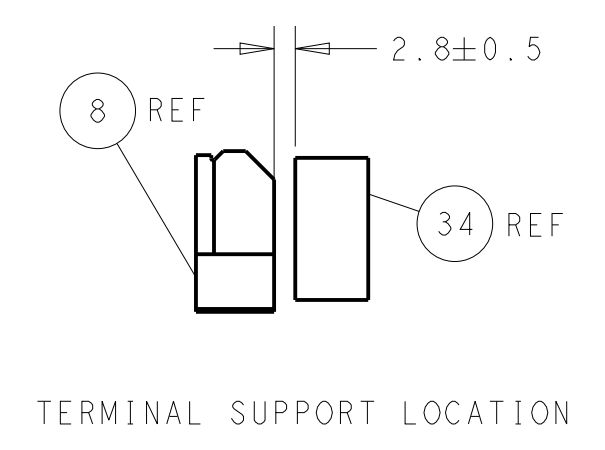
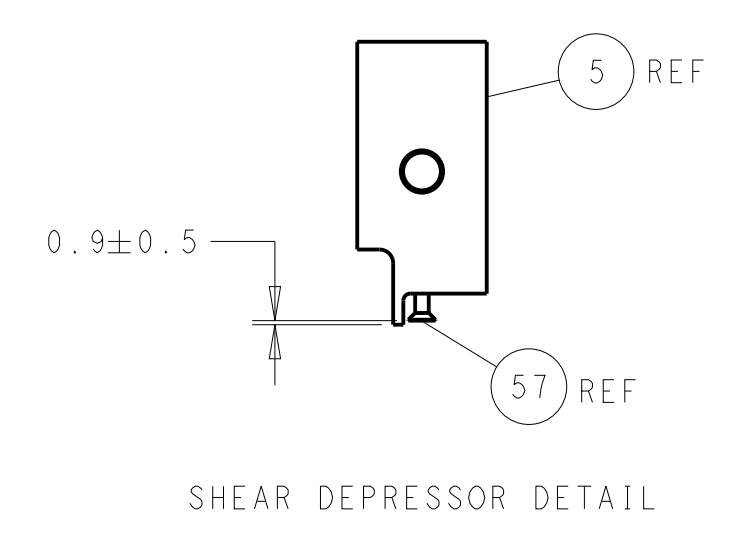
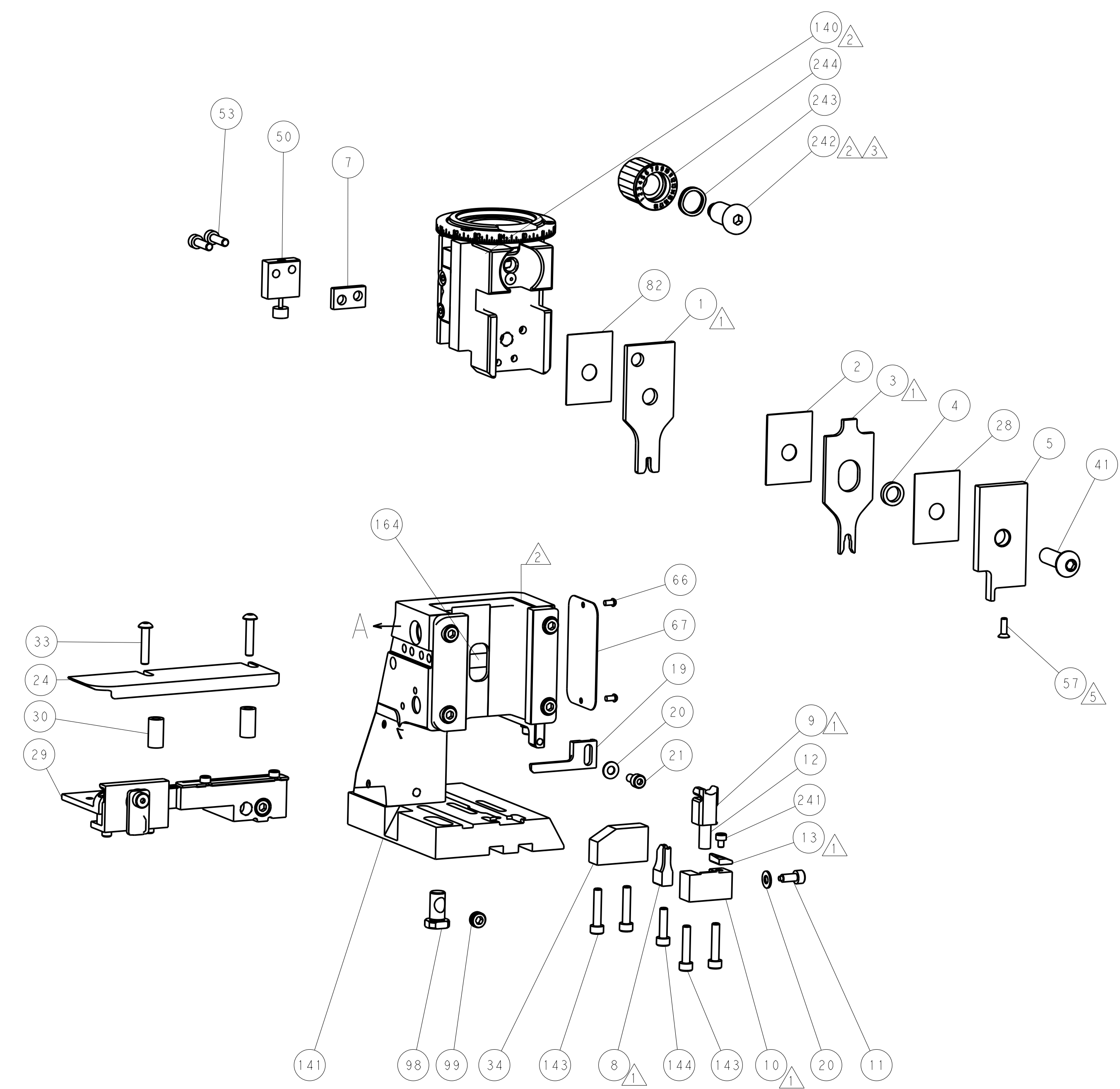
PNEUMATIC



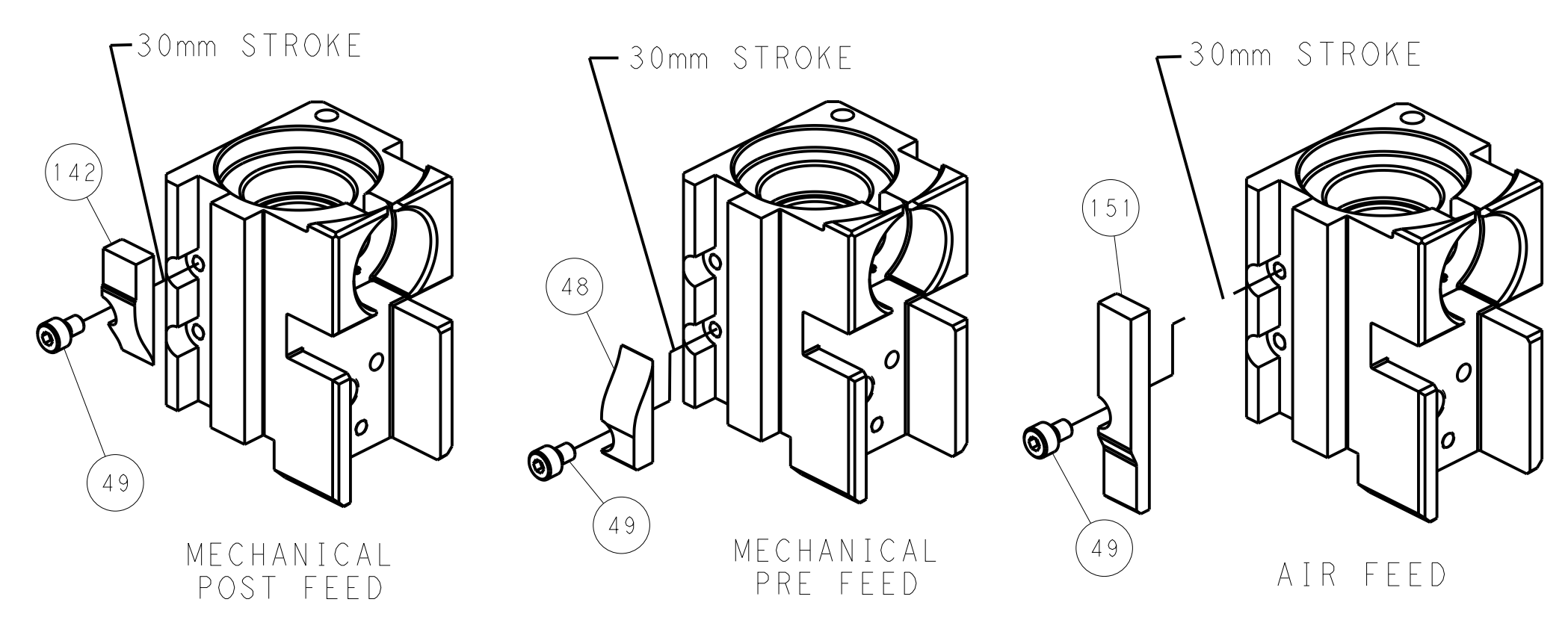
FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



DETAIL A



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 ±		DWN: H. HUANG 03JUL2012 CHK: S. XI 03JUL2012 APP'D: S. XI 03JUL2012		NAME: Ocean Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2151701		RESTRICTED TO: - SCALE: 1:2 SHEET: 4 OF 4 REV: E	
MATERIAL: - FINISH: -				WEIGHT: - PRODUCT SPEC: - APPLICATION SPEC: -		CUSTOMER ACCESSIBLE PRODUCTION DRAWING		SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION	