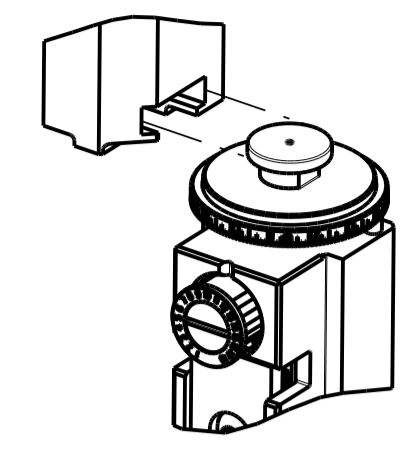


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151065-1	F	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2151065-2	G	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
5-2151065-1	F	SEAL STRIPPER CRIMPER TERMINATING UNIT	MECHANICAL
5-2151065-2	G	SEAL STRIPPER CRIMPER TERMINATING UNIT	PNEUMATIC
7-2151065-1	F	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2151065-2	G	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2151065-7	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: JUNIOR POWER TIMER CONTACT

WIRE STRIP LENGTH	INSULATION DIAMETER RANGE
3.20-3.80 mm [.126-.150 IN]	Ø1.00-1.60 mm [.039-.063 IN]

TERMINAL APPLICATION SPECIFICATION (A) 114-18050 (B) 114-18051

TERMINALS APPLIED

TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
(A) 964280-1	(A) 964280-2	(B) 2-964292-1	(A) 2-964280-1
(A) 964280-6	(B) 1-964292-3		

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION

TERMINAL NAME: 2.8X0.8mm FLAT CONTACT

WIRE STRIP LENGTH	INSULATION DIAMETER RANGE
3.20-3.80 mm [.126-.150 IN]	Ø1.15-1.60 mm [.045-.063 IN]

TERMINAL APPLICATION SPECIFICATION (A) 114-18050 (B) 114-18051

TERMINALS APPLIED

TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
(A) 2141892-2	(A) 2-2141892-1	(B) 1-2141874-3	(B) 2-2141874-1

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.50mm2	1.12+/-0.03 [.044+/- .001]	5.7
0.35mm2	1.05+/-0.03 [.041+/- .001]	6.4
0.25mm2	1.00+/-0.03 [.039+/- .001]	7.1
0.22mm2	0.98+/-0.03 [.039+/- .001]	7.3

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.35mm2	1.08+/-0.03 [.043+/- .001]	6.2

- 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. 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.

LOC	DIST	REV	LTN	DESCRIPTION	DATE	OWN	APPV
A	66	F		ECR-18-008304	30MAY2018	JAH	JDG
		G		ECR-19-011449	21JUL2019	TB	TE
		G1		ECR-21-000576	20JAN2021	FZ	YY
		G2		ECR-21-003462	22MAR2021	FJ	GB

-	-	-	1	1	-	-	1803515-3	RAM ASSEMBLY, SF ATLANTIC	293
-	-	-	1	1	-	-	2-1803583-1	APPLICATOR BASIC ASSEMBLY, SF	292
-	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
-	1	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	-	-	4-1722335-3	STRIPPER, SIDE FEED	182
-	-	-	1	1	-	-	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	181
-	-	-	1	1	-	-	2-1752354-3	STANDOFF, HOLD-DOWN	180
-	-	-	1	1	-	-	993111-1	PIN, SLOTTED SPRING 3.0 X 20.0	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	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113
-	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	455888-5	SPACER, CRIMPER	82
-	2	2	2	2	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	79
-	1	1	1	1	1	1	1633782-2	FENCE	78
-	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	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	53
-	1	1	1	1	1	1	1803382-6	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	1803515-1	RAM ASSEMBLY, SF ATLANTIC	44
-	1	1	1	1	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
-	1	1	1	1	1	1	1-1752356-7	SUPPORT, TERMINAL	34
-	2	2	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	2	2	2	2	2-2844962-8	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	1	1	1	1	2844992-2	ASSEMBLY, STRIP GUIDE	29
-	1	1	1	1	1	1	455888-5	SPACER, CRIMPER	28
-	1	1	1	1	1	1	1320928-6	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	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	2119805-1	SHEAR HOLDER, FRONT	10
-	1	1	1	1	1	1	454276-5	FLOATING SHEAR, FRONT	9
1	2	2	1	1	1	1	1333202-5	ANVIL, COMBINATION	8
-	1	1	1	1	1	1	4-240641-2	SPACER	7
-	1	1	1	1	1	1	2119757-4	DEPRESSOR, SHEAR	5
-	1	1	1	1	1	1	238011-9	BLOCK, CRIMPER SPACER	4
1	2	2	1	1	1	1	1-2119784-8	CRIMPER, INSULATION O PREMIUM	3
-	1	1	1	1	1	1	455888-3	SPACER, CRIMPER	2
1	2	2	1	1	1	1	1-456403-3	CRIMPER, WIRE PREMIUM	1

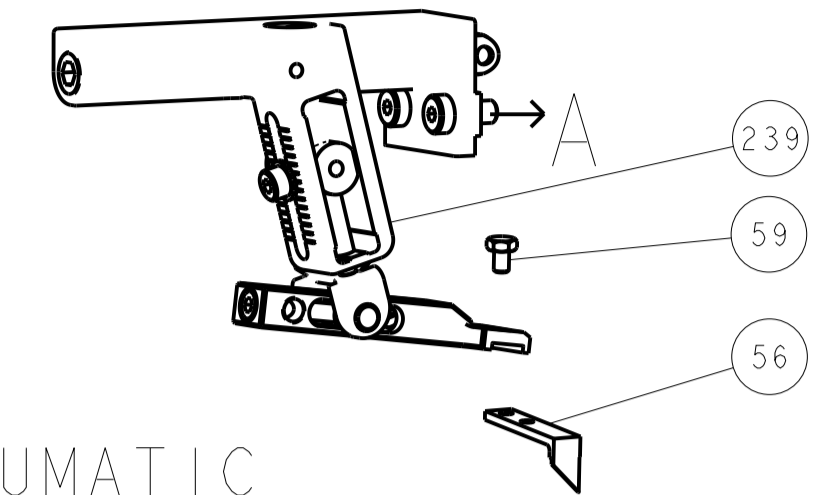
ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DRAWING NO	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±
	ANGLES	FINISH		WEIGHT	
MATERIAL		FINISH		SCALE	
Customer Accessible Production Drawing		SCALE 1:2		SHEET 1 OF 4	

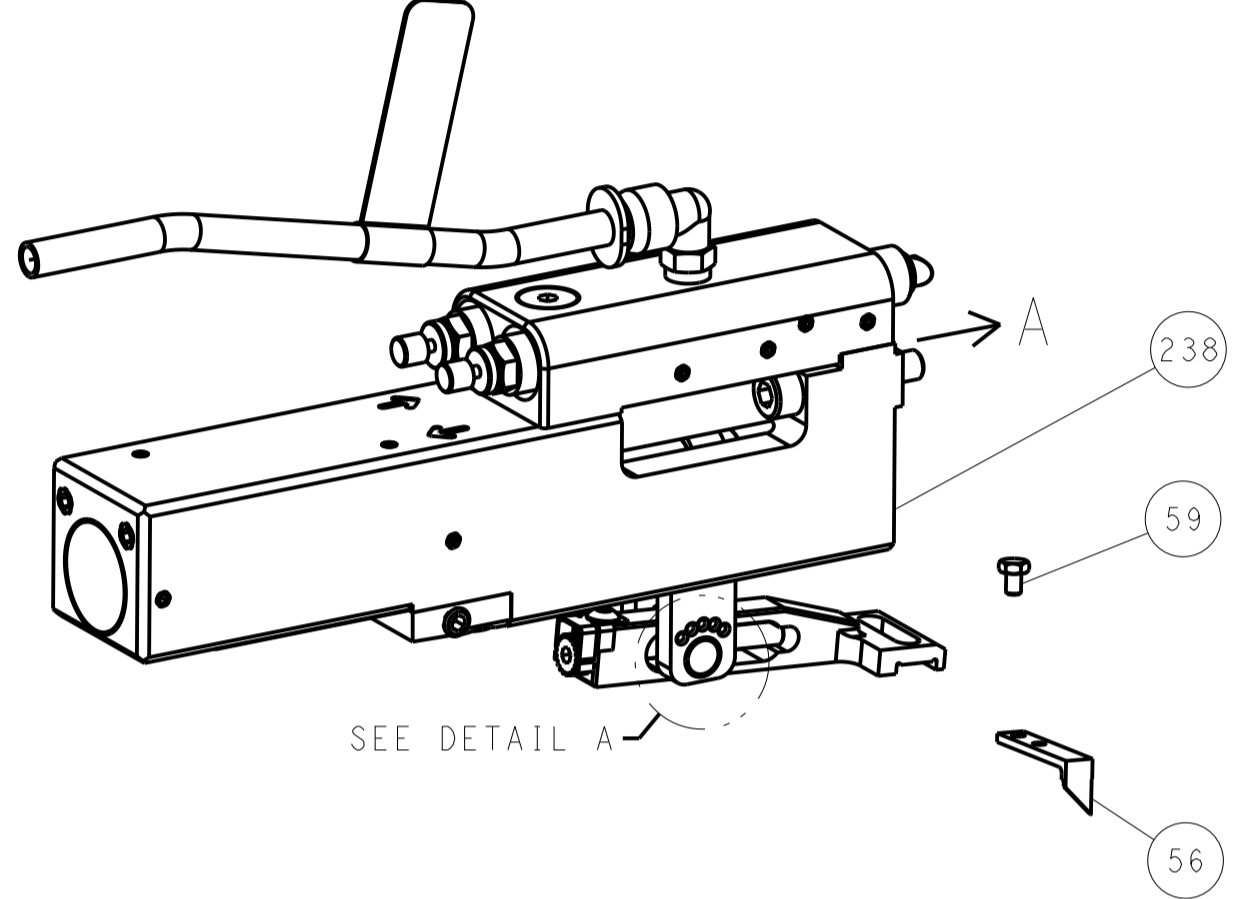
APPROVED: S. XI 26APR2011
 CHECKED: I. CRUZ 26APR2011
 PRODUCT SPEC: Ocean Side Feed Applicator
 APPLICATION SPEC: -
 SIZE: A1 00779 ©=2151065
 RESTRICTED TO: -
 REV: G2

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

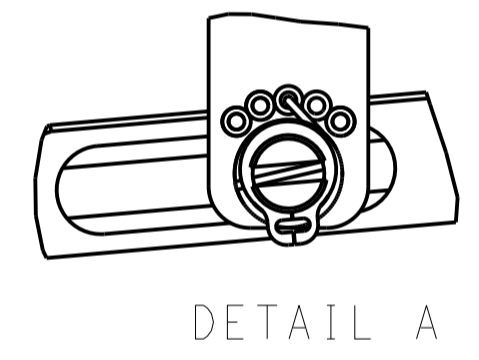
FEED TYPE MECHANICAL



PNEUMATIC

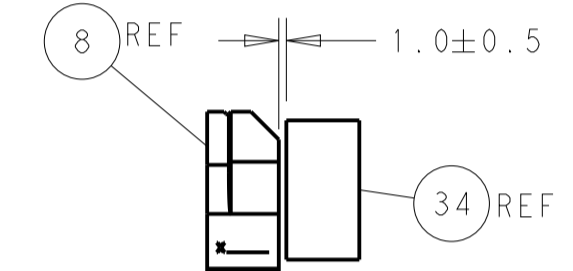
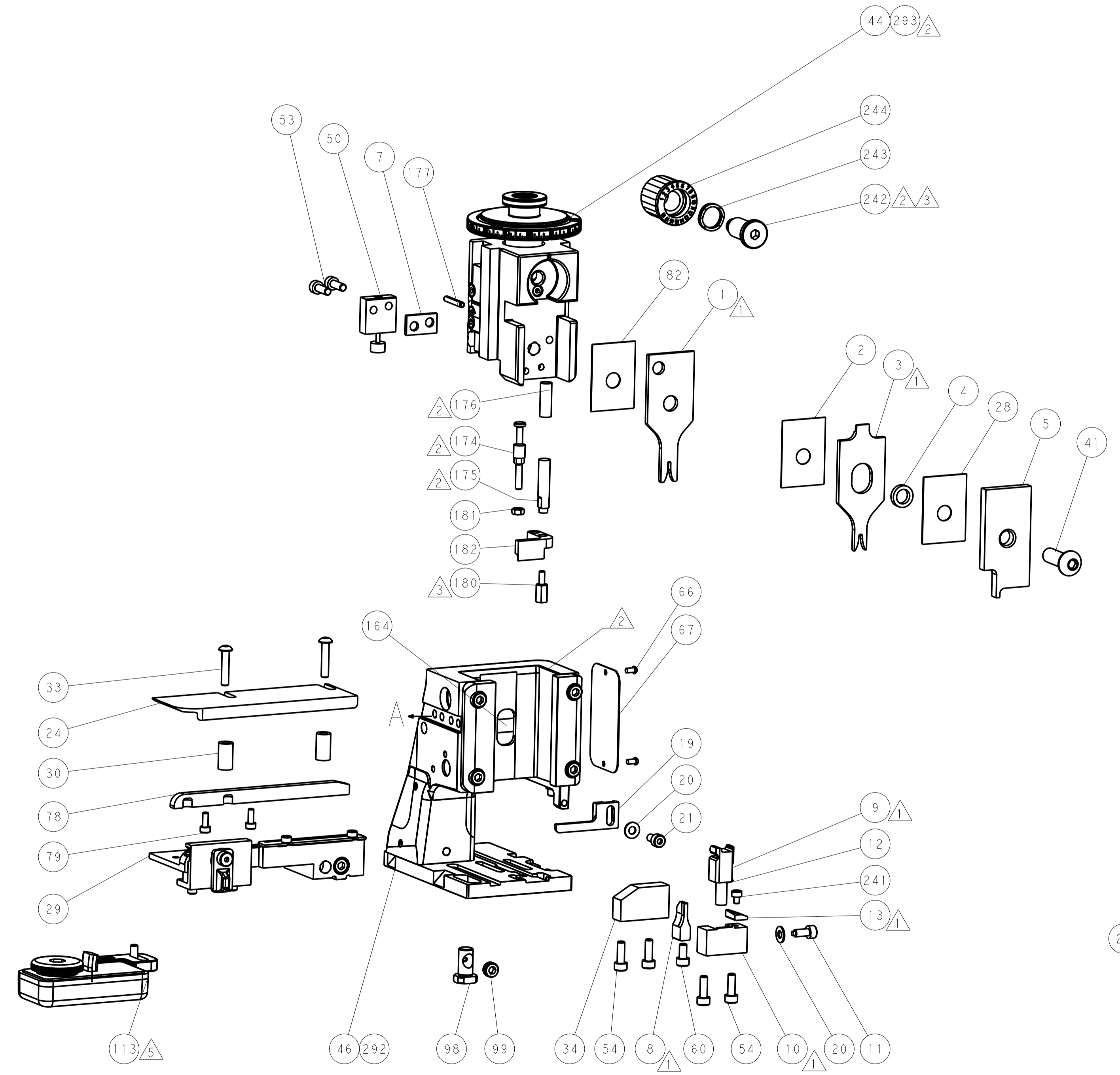
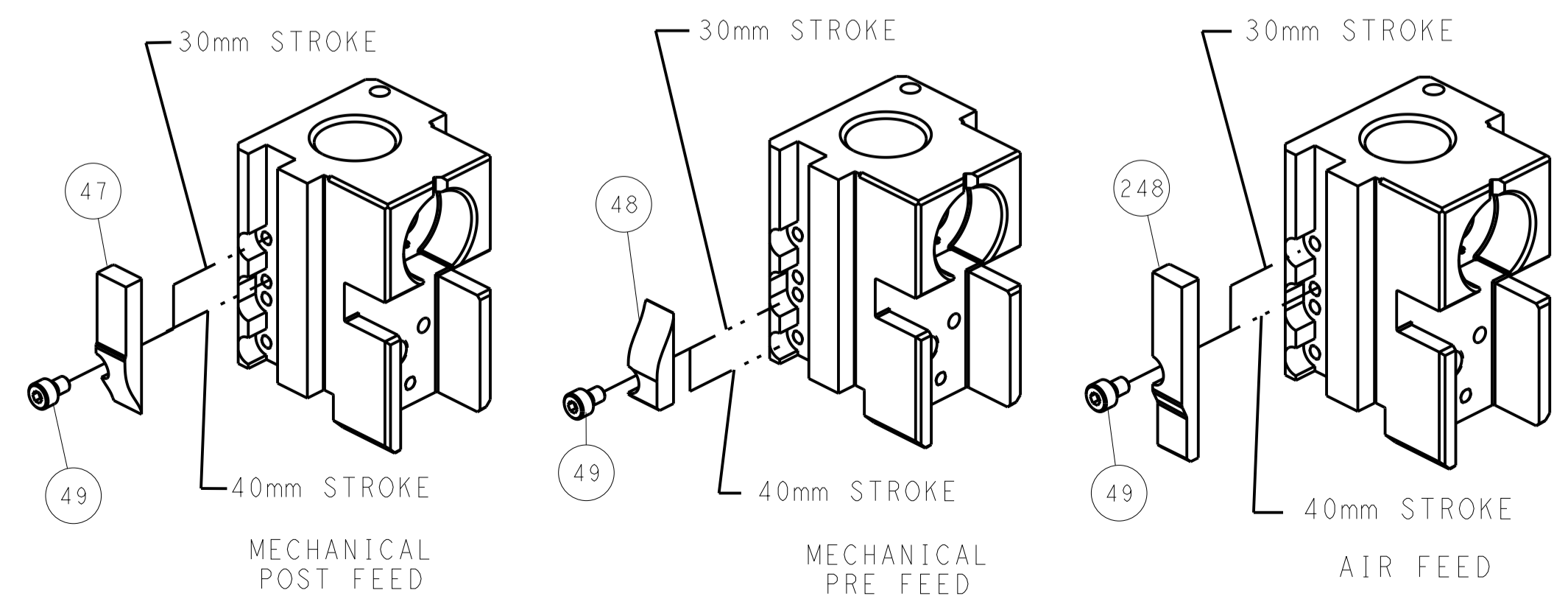


FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)

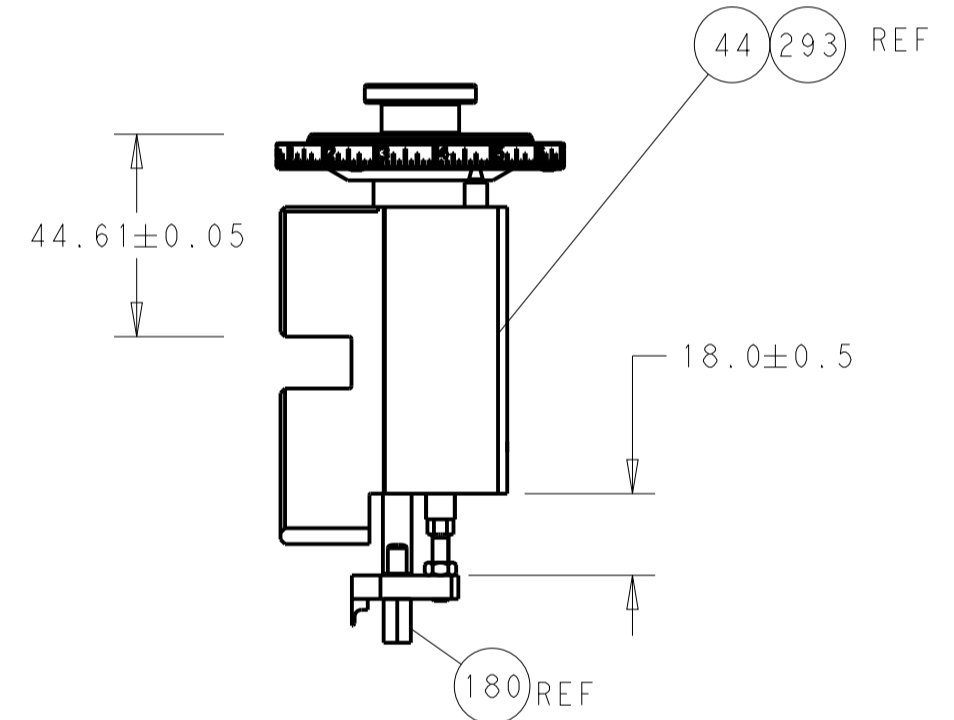


DETAIL A

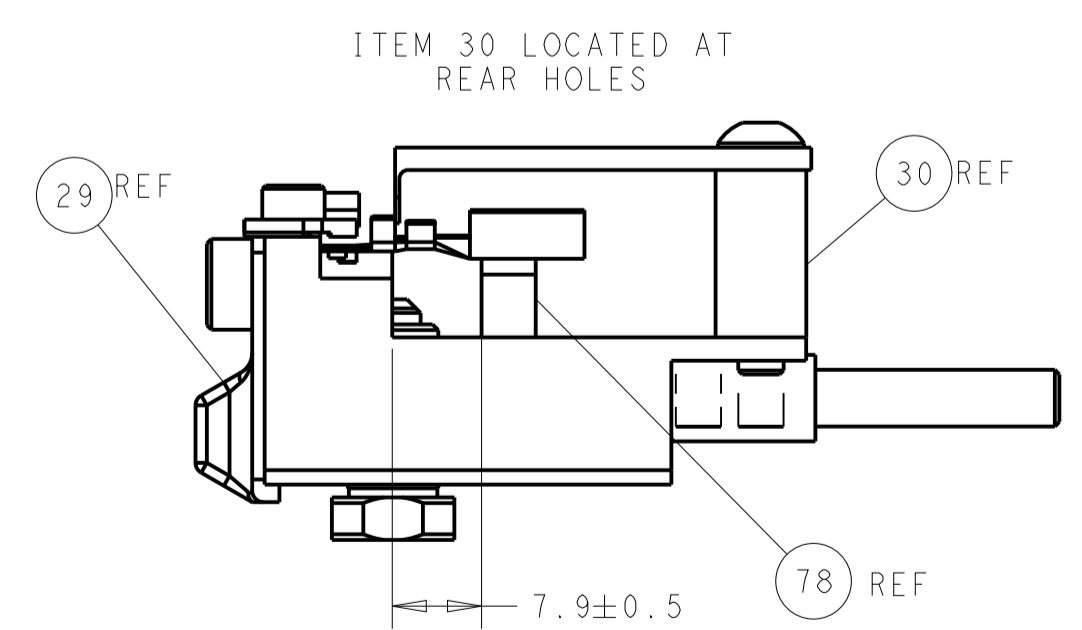
CAM POSITIONS



TERMINAL SUPPORT LOCATION



RAM AND HOLDDOWN SET-UP



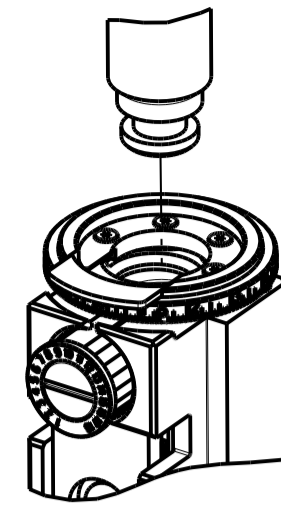
FEED TRACK POSITION GUIDE BY INSULATION BARREL

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

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG: C.CHEN 26APR2011		TE Connectivity	
mm	0 PLC	±		CHK: S.XI 26APR2011	NAME: Ocean Side Feed Applicator		Harrisburg, PA 17105-3608
	1 PLC	±		APVD: J.CRUZ 26APR2011	SIZE: A1		CAGE CODE: 00779
	2 PLC	±		PRODUCT SPEC:	DRAWING NO: 2151065		RESTRICTED TO:
	3 PLC	±		APPLICATION SPEC:	SCALE: 1:2		SHEET 2 OF 4
	4 PLC	±		WEIGHT:	REV: G2		
MATERIAL:	FINISH:			Customer Accessible Production Drawing			

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2151065-1	F	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2151065-2	G	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151065-7	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: JUNIOR POWER TIMER CONTACT			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
3.20-3.80 mm [1.26-.150 IN]		Ø1.00-1.60 mm [1.039-.063 IN]	
TERMINAL APPLICATION SPECIFICATION	(A) 114-18050	-	-
	(B) 114-18051	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
(A) 964280-1	(A) 964280-2	(B) 2-964292-1	(A) 2-964280-1
(A) 964280-6	(B) 1-964292-3		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: 2.8X0.8mm FLAT CONTACT			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
3.20-3.80 mm [1.26-.150 IN]		Ø1.15-1.60 mm [1.045-.063 IN]	
TERMINAL APPLICATION SPECIFICATION	(A) 114-18050	-	-
	(B) 114-18051	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
(A) 2141892-2	(A) 2-2141892-1	(B) 1-2141874-3	(B) 2-2141874-1

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.50mm2	1.12+/-0.03 [1.044+/-0.011]	5.7
0.35mm2	1.05+/-0.03 [1.041+/-0.011]	6.4
0.25mm2	1.00+/-0.03 [1.039+/-0.011]	7.1
0.22mm2	0.98+/-0.03 [1.039+/-0.011]	7.3

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.35mm2	1.08+/-0.03 [1.043+/-0.011]	6.2



- 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.

ENTRY LEVEL APPLICATOR		ITEM SUBSTITUTION LIST		
PART NUMBER	SAME AS	ITEM	ITEM DESCRIPTION	SUBSTITUTE PART NUMBER
8-2151065-1	2151065-1	1	WIRE CRIMPER	1-1803547-3
8-2151065-2	2151065-2	3	INSULATION CRIMPER	1-1803604-8
9-2151065-1	2-2151065-1	46	BASIC SUB -ASSEMBLY	1803940-9
9-2151065-2	2-2151065-2	141	BASIC SUB -ASSEMBLY	1-1803940-0
			LUBRICATOR	DELETE

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

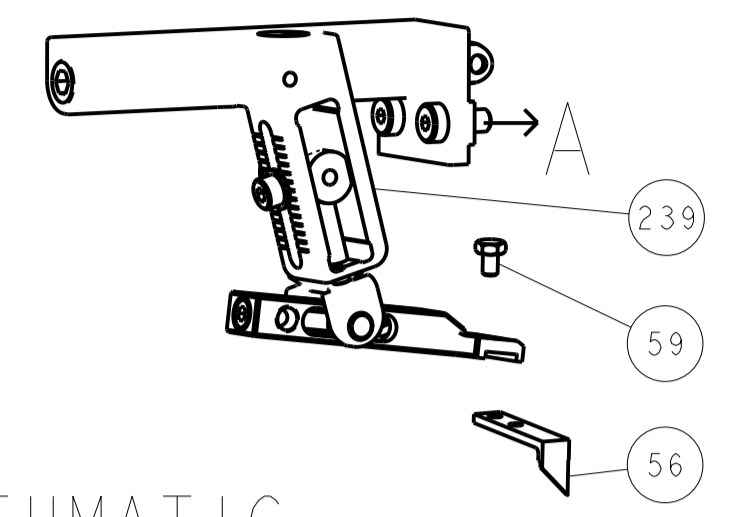
-	1	1	2119082-5	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
-	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	1	-	2844940-1	AIR FEED MODULE	238
-	REF	REF	994970-2	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	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
-	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	79
-	1	1	1633782-2	FENCE	78
-	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	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	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	1-1752356-7	SUPPORT, TERMINAL	34
-	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	2-2844962-8	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	2844992-2	ASSEMBLY, STRIP GUIDE	29
-	1	1	455888-5	SPACER, CRIMPER	28
-	1	1	1320928-6	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	454276-5	FLOATING SHEAR, FRONT	9
-	1	1	1333202-5	ANVIL, COMBINATION	8
-	1	1	4-240641-2	SPACER	7
-	1	1	2119757-4	DEPRESSOR, SHEAR	5
-	1	1	238011-9	BLOCK, CRIMPER SPACER	4
-	1	1	1-2119784-8	CRIMPER, INSULATION O PREMIUM	3
-	1	1	455888-3	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)

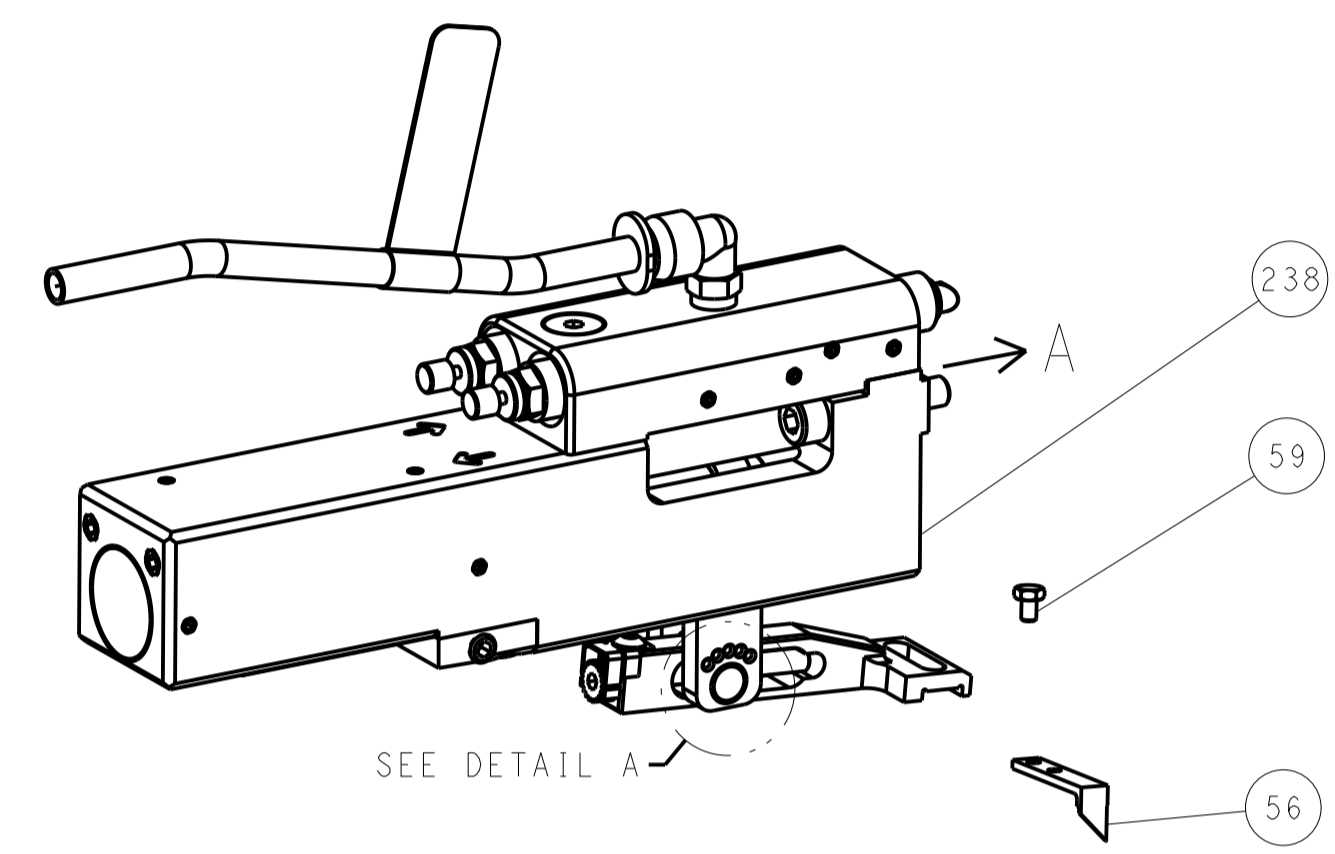
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN C.CHEN 26APR2011		TE Connectivity Harrisburg, PA 17105-3608	
0 PLC ±		1 PLC ±		CHK S.XI 26APR2011		NAME Ocean Side Feed Applicator	
2 PLC ±		3 PLC ±		APVD I.CRUZ 26APR2011		SIZE CAGE CODE DRAWING NO RESTRICTED TO	
4 PLC ±		ANGLES ±		PRODUCT SPEC		A1 00779 C=2151065	
MATERIAL		FINISH		APPLICATION SPEC		WEIGHT	
				Customer Accessible Production Drawing		SCALE 1:2 SHEET 3 OF 4 REV G2	

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

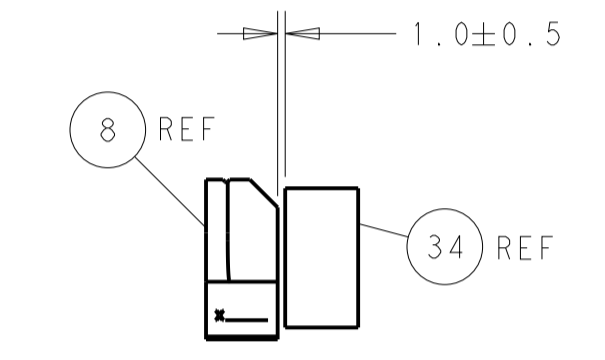
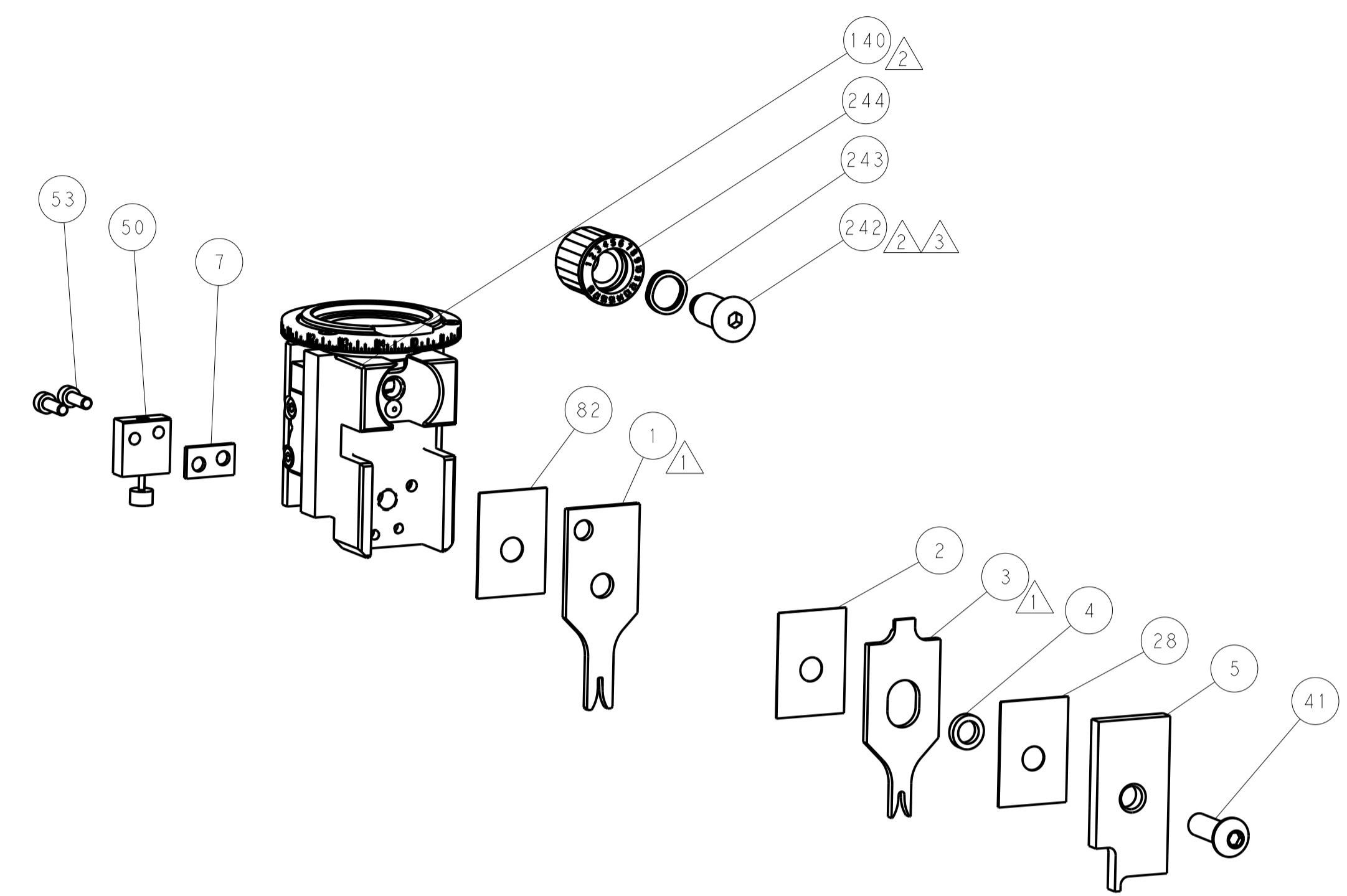
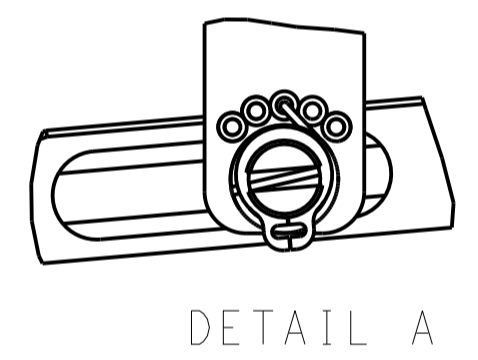
FEED TYPE MECHANICAL



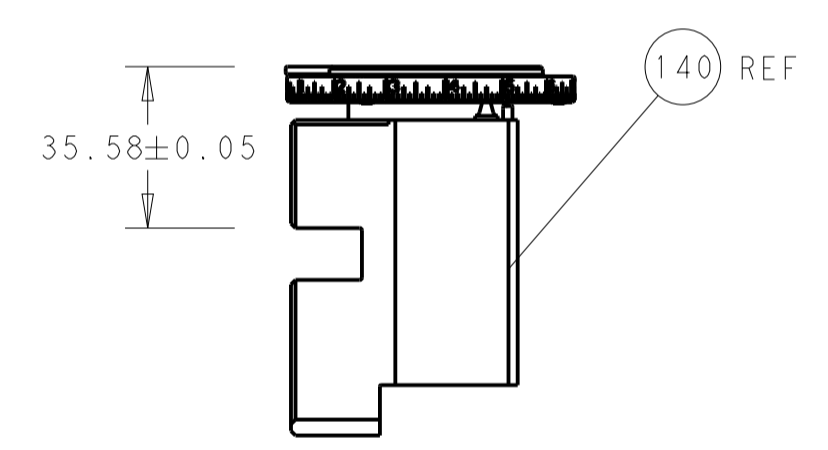
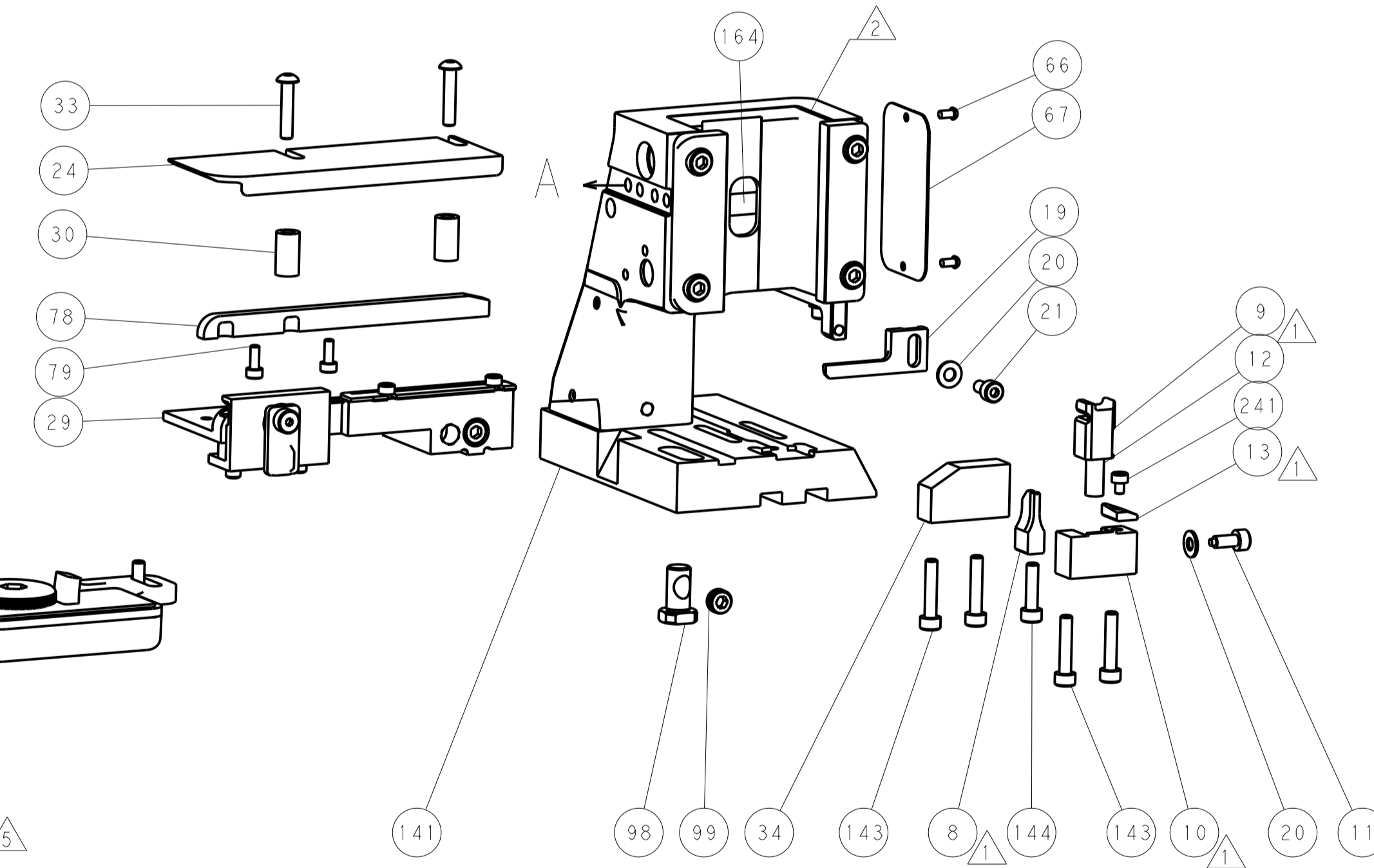
PNEUMATIC



FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)

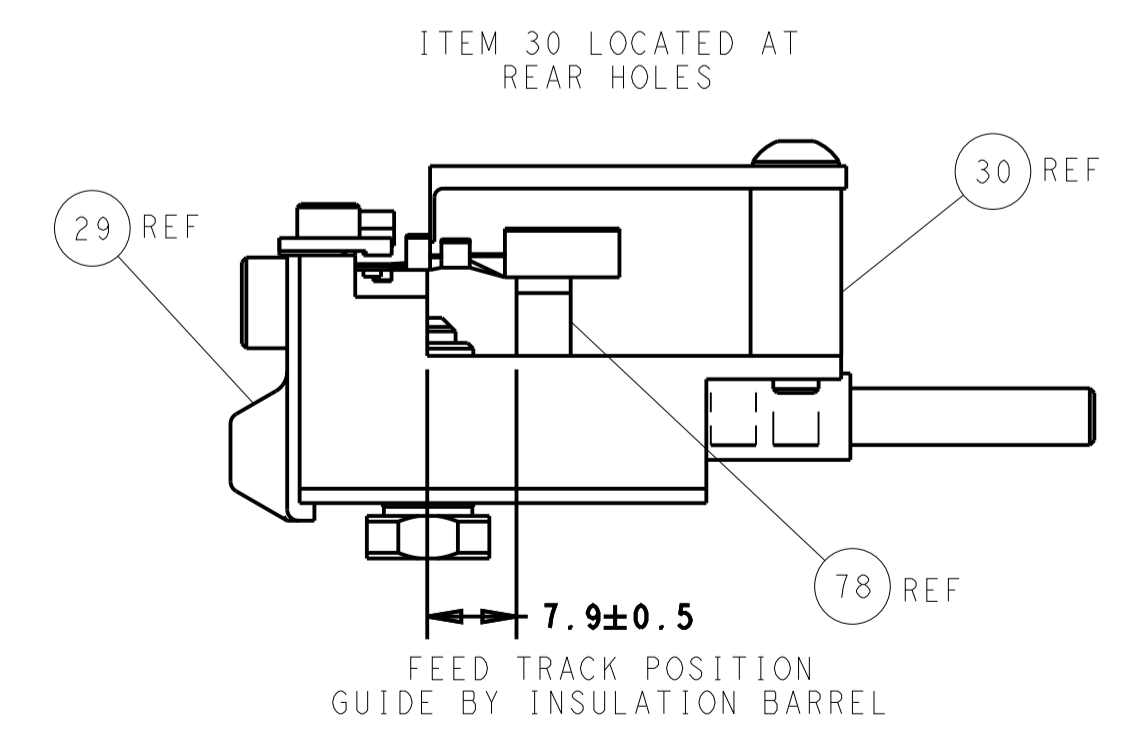
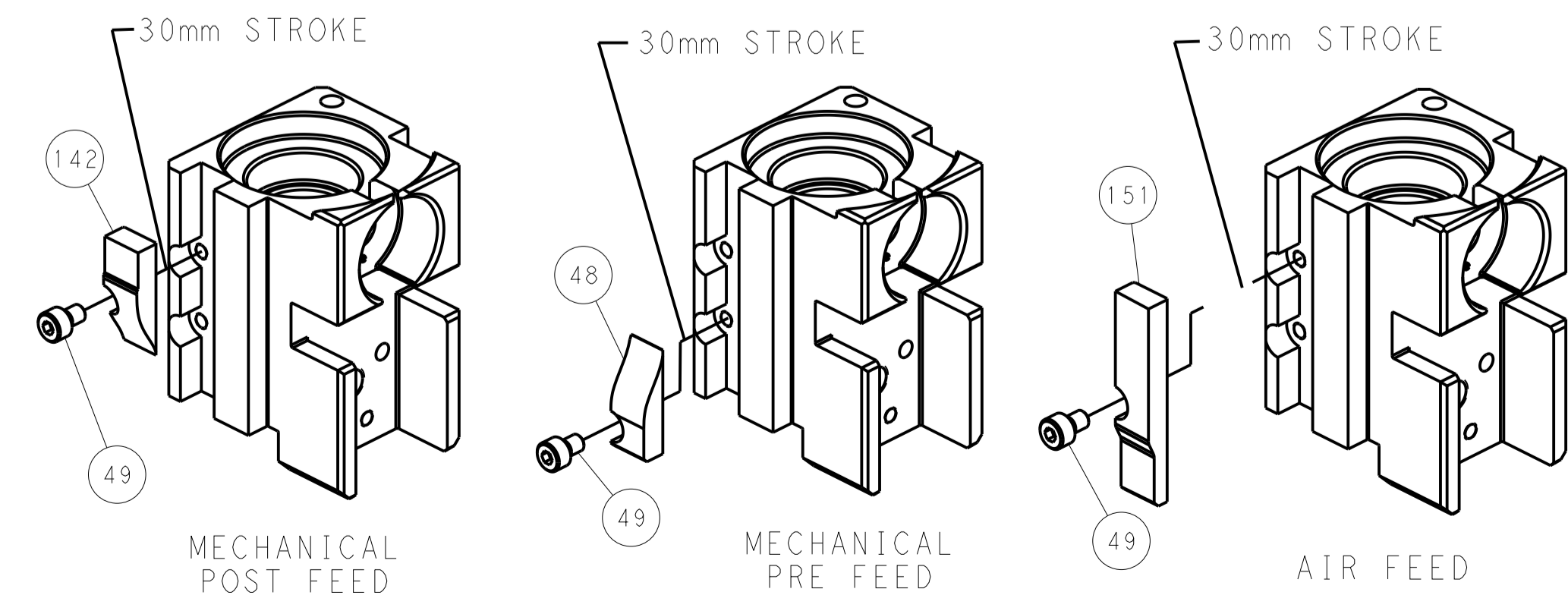


TERMINAL SUPPORT LOCATION



RAM SET-UP

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: C. CHEN 26APR2011 CHK: S. XI 26APR2011 APVD: J. CRUZ 26APR2011		NAME: TE Connectivity Harrisburg, PA 17105-3608 Ocean Side Feed Applicator	
MATERIAL:		FINISH:		PRODUCT SPEC: APPLICATION SPEC:		SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2151065	
WEIGHT:		FINISH:		RESTRICTED TO:		SCALE: 1:2 SHEET: 4 of 4 REV: G2	