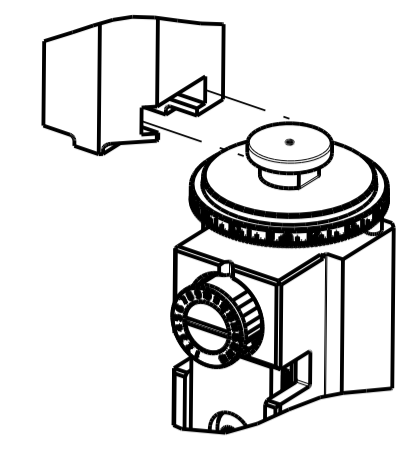


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151665-1	F	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2151665-2	F	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151665-1	F	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2151665-2	F	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2151665-7	B	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.27 mm [.050]	F
INSUL	1.83 mm [.072]	O

APPLICATOR INSTRUCTIONS 408-35042

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: GET FEMALE TERMINAL, 1.2MM 0.2 STOCK SHEET			
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE		
3.30-3.70 mm [.130-.146 IN]	Ø1.10-1.65 mm [.043-.065 IN]		
TERMINAL APPLICATION SPECIFICATION	114-18774		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
1719957-1	1924878-1	1924878-2	

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.35mm2	0.82 +/- 0.03 [.032 +/- .001]	9.2
22 AWG	0.80 +/- 0.03 [.031 +/- .001]	9.4
0.22mm2	0.74 +/- 0.03 [.029 +/- .001]	10.0
2X0.13mm2	0.74 +/- 0.03 [.029 +/- .001]	10.0

- 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)

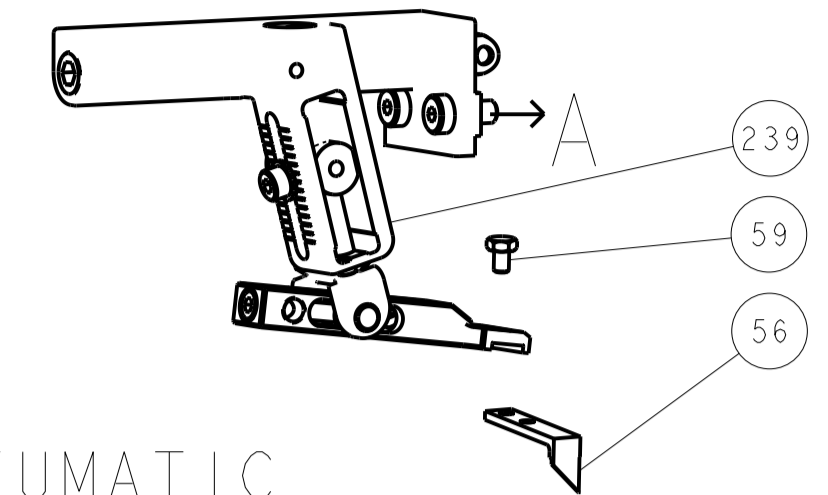
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		E	ECR-20-000365	10JAN2020	FJ RK
		F	ECR-20-016298	16NOV2020	TB TE
		F1	ECR-21-006079	07JUN2021	LJ YY

-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248
-	1	1	1	1	2119082-9	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
-	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	1	1	1	1	2844908-1	SCREW, LOCKING	99
-	1	1	1	1	2844907-1	POST, LOCKING	98
-	1	1	1	1	455888-5	SPACER, CRIMPER	82
-	1	1	1	1	5-547505-2	SPRING, COMPRESSION	77
-	1	1	1	1	854769-4	HOLDER, INS	74
-	1	1	1	1	1803607-3	DOCUMENTATION PACKAGE	71
-	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	21028-2	PIN, SLOTTED SPRING .062 X .250	58
-	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	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	53
-	1	1	1	1	1803382-6	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	1752356-6	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	2844992-4	ASSEMBLY, STRIP GUIDE	29
-	1	1	1	1	455888-3	SPACER, CRIMPER	28
-	1	1	1	1	240792-2	DRAG, TERMINAL	25
-	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	318707-1	FLOATING SHEAR, FRONT	9
-	1	2	2	1	1803055-1	ANVIL, COMBINATION	8
-	-	-	-	-	-	-	6
-	1	1	1	1	2119780-4	DEPRESSOR, SHEAR	5
-	1	1	1	1	1-238011-7	BLOCK, CRIMPER SPACER	4
-	1	2	2	1	5-2119784-1	CRIMPER, INSULATION O PREMIUM	3
-	1	1	1	1	455888-4	SPACER, CRIMPER	2
-	1	2	2	1	1803125-1	CRIMPER, WIRE	1
-	77	-72	-71	-2	-1	PART NO	ITEM NO

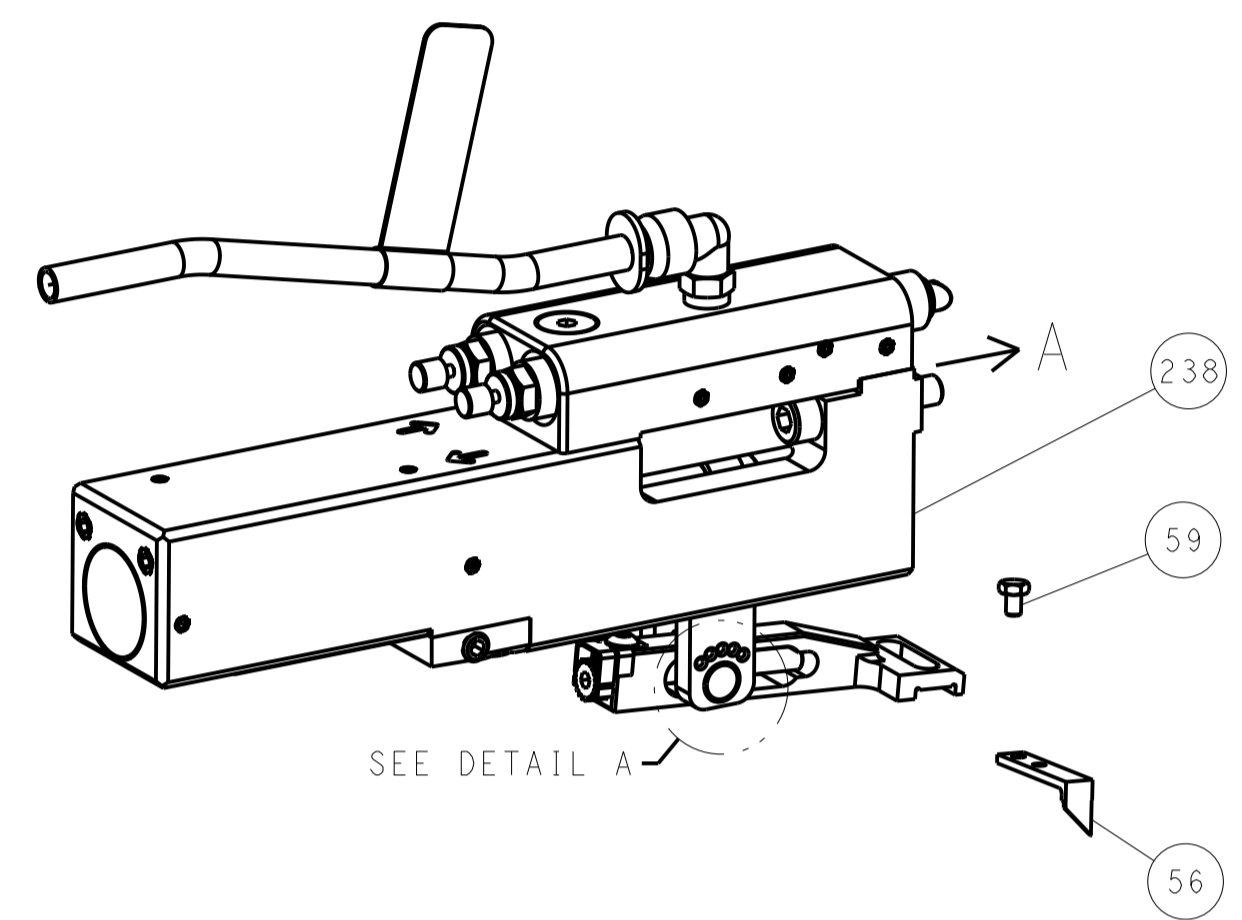
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG: Y. YIN 10MAY2012		TE Connectivity Harrisburg, PA 17105-3608	
mm		0 PLC ±		CHK: G. BAILEY 10MAY2012		NAME: Ocean Side Feed Applicator	
APVD: S. XI 10MAY2012		1 PLC ±		PRODUCT SPEC		SIZE: CAGE CODE: DRAWING NO: RESTRICTED TO	
APPLICATION SPEC		2 PLC ±		WEIGHT		A1 00779 ©=2151665	
MATERIAL		3 PLC ±		SCALE: 1:2		SHEET 1 OF 4	
FINISH		4 PLC ±		REV: F1		Customer Accessible Production Drawing	
ANGLES		±		REV: F1		SCALE: 1:2 SHEET 1 OF 4	

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

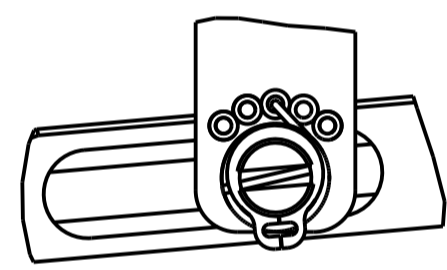
FEED TYPE MECHANICAL



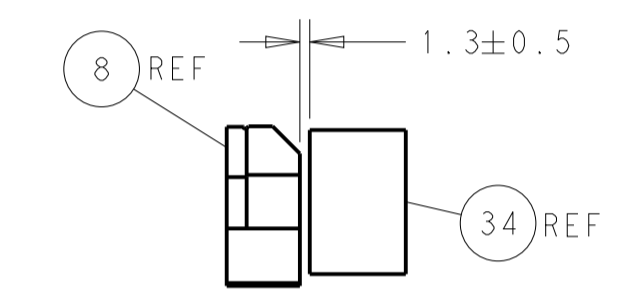
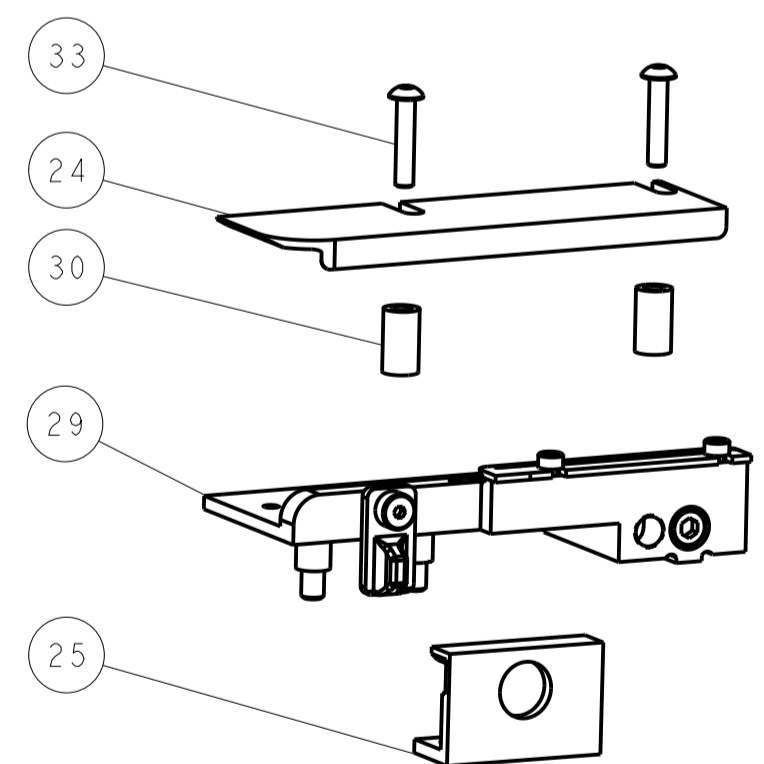
PNEUMATIC



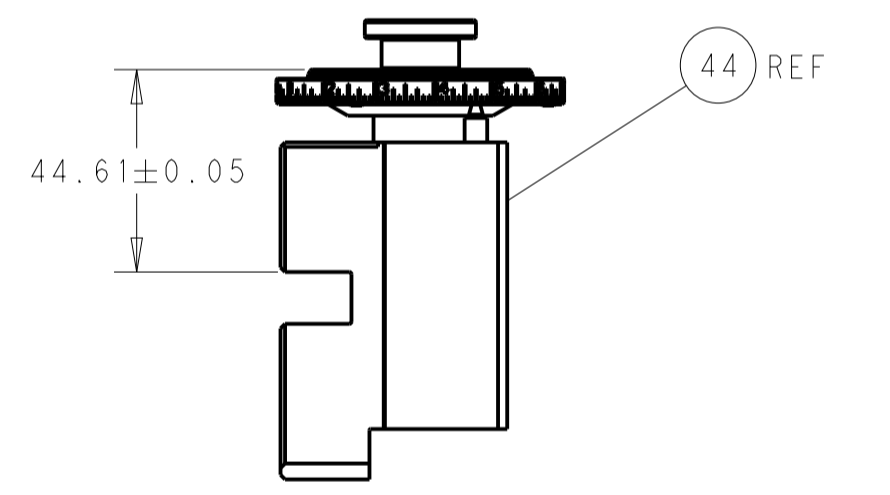
FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



DETAIL A

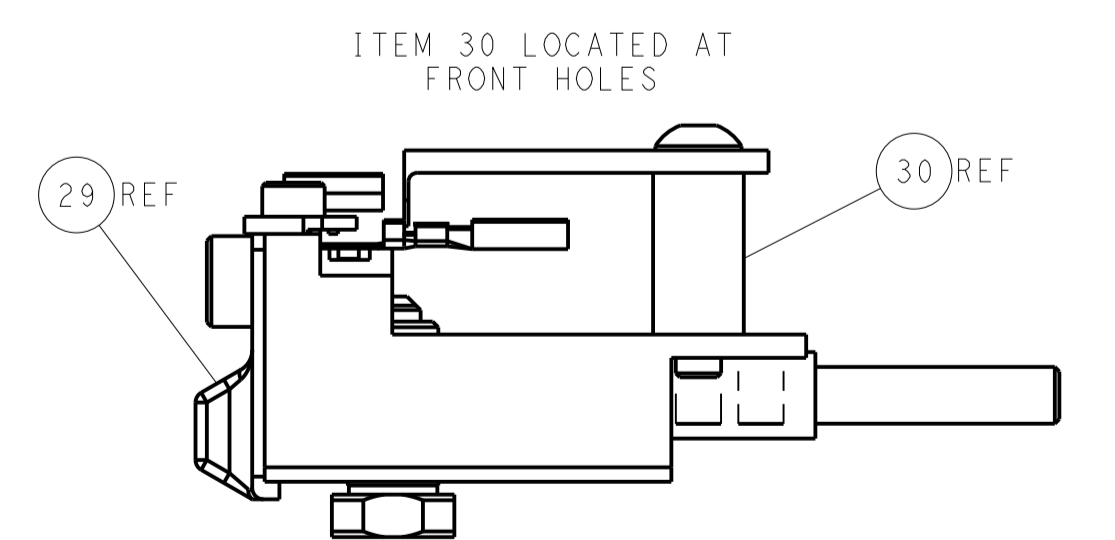
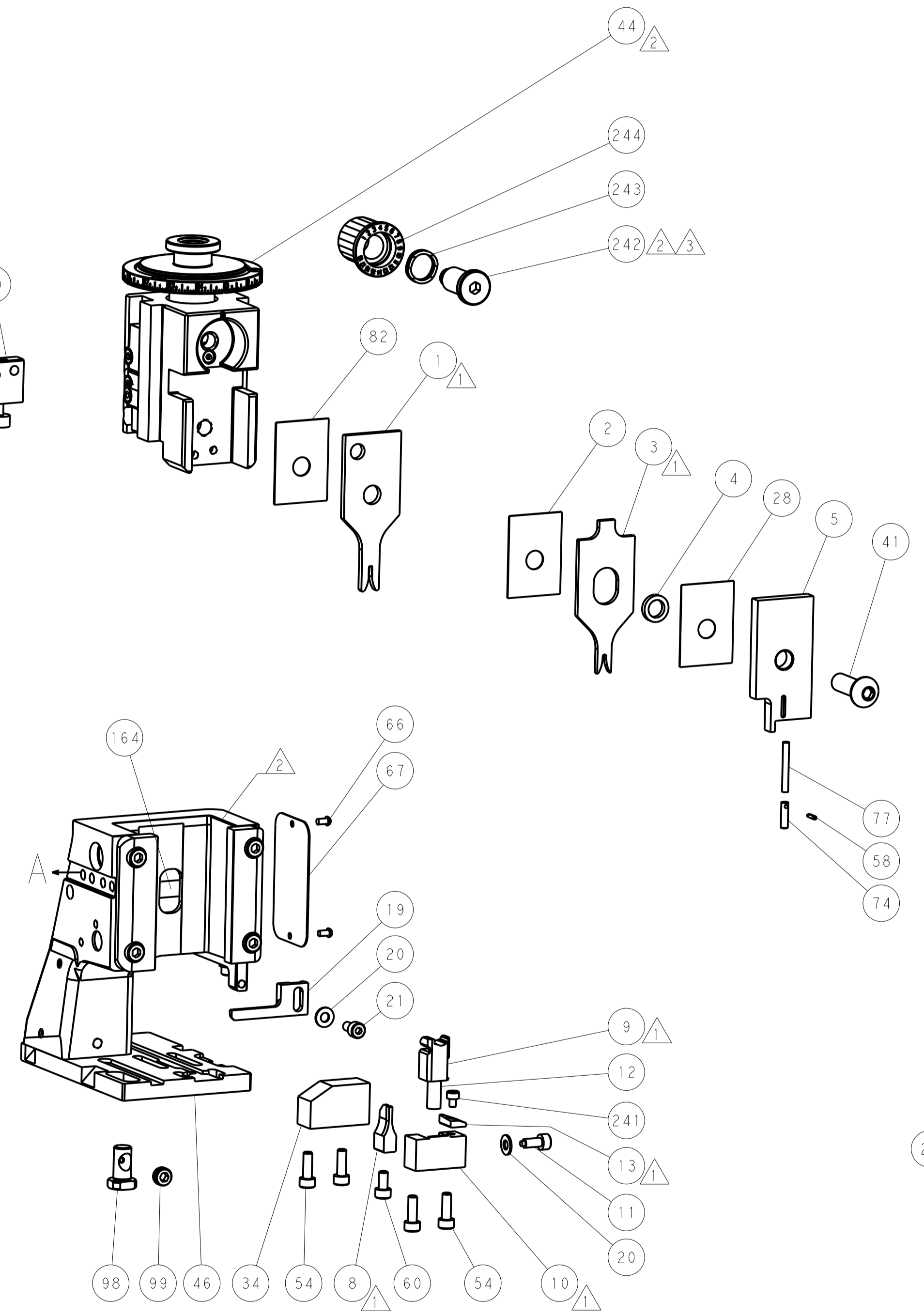
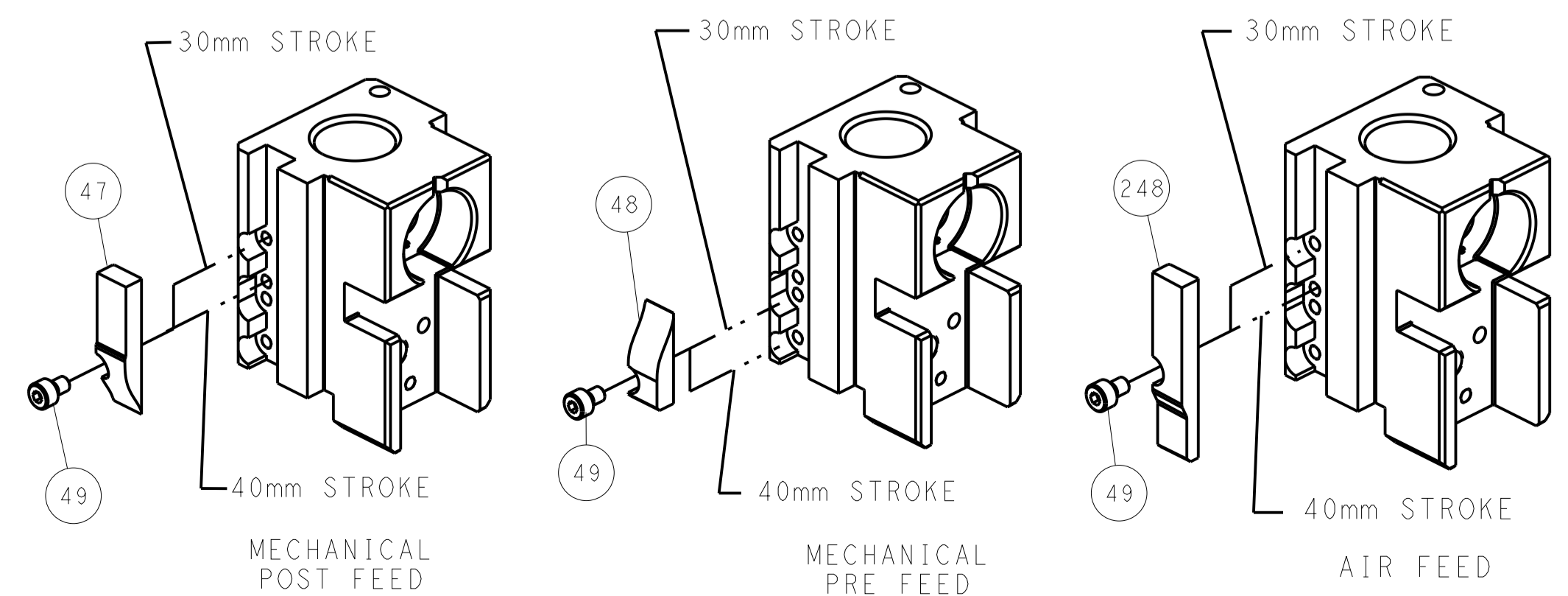


TERMINAL SUPPORT LOCATION



RAM SET-UP

CAM POSITIONS



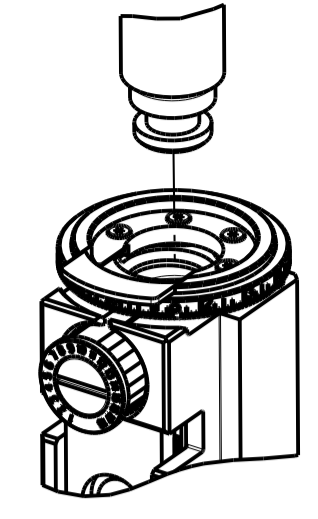
FEED TRACK POSITION GUIDE BY INSULATION BARREL

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

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN: T.Y. YIN 10MAY2012		TE Connectivity	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	Harrisburg, PA 17105-3608	
MATERIAL:		FINISH:		CHK: G. BAILEY 10MAY2012		NAME: Ocean Side Feed Applicator	
				S. XI 10MAY2012		SIZE: CAGE CODE: DRAWING NO: A1 00779 ©=2151665	
				APVD: S. XI 10MAY2012		RESTRICTED TO: Customer Accessible Production Drawing	
				WEIGHT:		SCALE: 1:2 SHEET 2 OF 4 REV: F1	

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2151665-1	F	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2151665-2	F	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151665-7	B	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
 INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.27 mm [.050]	F
INSUL	1.83 mm [.072]	O

APPLICATOR INSTRUCTIONS
 408-35042

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: GET FEMALE TERMINAL, 1.2MM 0.2 STOCK SHEET			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
3.30-3.70 mm [.130-.146 IN]		Ø1.10-1.65 mm [.043-.065 IN]	
TERMINAL APPLICATION SPECIFICATION	114-18774		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
1719957-1	1924878-1	1924878-2	

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.35mm2	0.82 +/- 0.03 [.032 +/- .001]	9.2
22 AWG	0.80 +/- 0.03 [.031 +/- .001]	9.4
0.22mm2	0.74 +/- 0.03 [.029 +/- .001]	10.0
2X0.13mm2	0.74 +/- 0.03 [.029 +/- .001]	10.0

- 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.

ENTRY LEVEL APPLICATOR		ITEM SUBSTITUTION LIST		
PART NUMBER	SAME AS	ITEM	ITEM DESCRIPTION	SUBSTITUTE PART NUMBER
8-2151665-1	2151665-1	1	WIRE CRIMPER	1803531-1
8-2151665-2	2151665-2	3	INSULATION CRIMPER	5-1803604-1
9-2151665-1	2-2151665-1	46	BASIC SUB -ASSEMBLY	1803940-9
9-2151665-2	2-2151665-2	141	BASIC SUB -ASSEMBLY	1-1803940-0
			LUBRICATOR	DELETE

***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.

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

LOC	DIST	REV	DATE	BY	APPV
A	66				

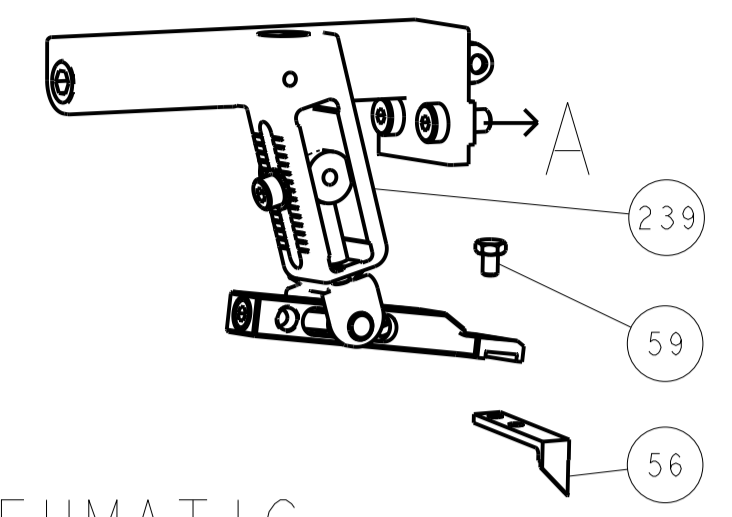
REV	DATE	BY	APPV	DESCRIPTION	ITEM NO
-	1	1		2119082-9 CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1		2079764-1 WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1		2119083-1 RETAINER, INSULATION DIAL	242
-	1	1		7-18023-7 SCR, SKT HD CAP M3 X 4.0	241
-	-	1		2119580-1 MECHANICAL FEED ASSEMBLY	239
-	1	-		2844940-1 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		455888-5 SPACER, CRIMPER	82
-	1	1		5-547505-2 SPRING, COMPRESSION	77
-	1	1		854769-4 HOLDER, INS	74
-	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		21028-2 PIN, SLOTTED SPRING .062 X .250	58
-	1	1		1338685-1 PAWL, FEED	56
-	2	2		1-2168083-0 SCR, SKT HD CAP, RoHS, M4 X 10	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		1752356-6 SUPPORT, TERMINAL	34
-	2	2		2079383-5 SCR, BHSC, RoHS (M4 X 20)	33
-	2	2		2-2844962-6 SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1		2844992-4 ASSEMBLY, STRIP GUIDE	29
-	1	1		455888-3 SPACER, CRIMPER	28
-	1	1		240792-2 DRAG, TERMINAL	25
-	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		1803055-1 ANVIL, COMBINATION	8
-	-	-		-	6
-	1	1		2119780-4 DEPRESSOR, SHEAR	5
-	1	1		1-238011-7 BLOCK, CRIMPER SPACER	4
-	1	1		5-2119784-1 CRIMPER, INSULATION O PREMIUM	3
-	1	1		455888-4 SPACER, CRIMPER	2
-	1	1		1803125-1 CRIMPER, WIRE	1

DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG: Y. YIN 10MAY2012		CHK: G. BAILEY 10MAY2012		APVD: S. XI 10MAY2012		NAME: Ocean Side Feed Applicator	
0 PLC	±	1 PLC	±	2 PLC	±	3 PLC	±	4 PLC	±	SIZE: A1	CAGE CODE: 00779
MATERIAL:		FINISH:		WEIGHT:		SCALE: 1:2		SHEET: 3 OF 4		REV: F1	

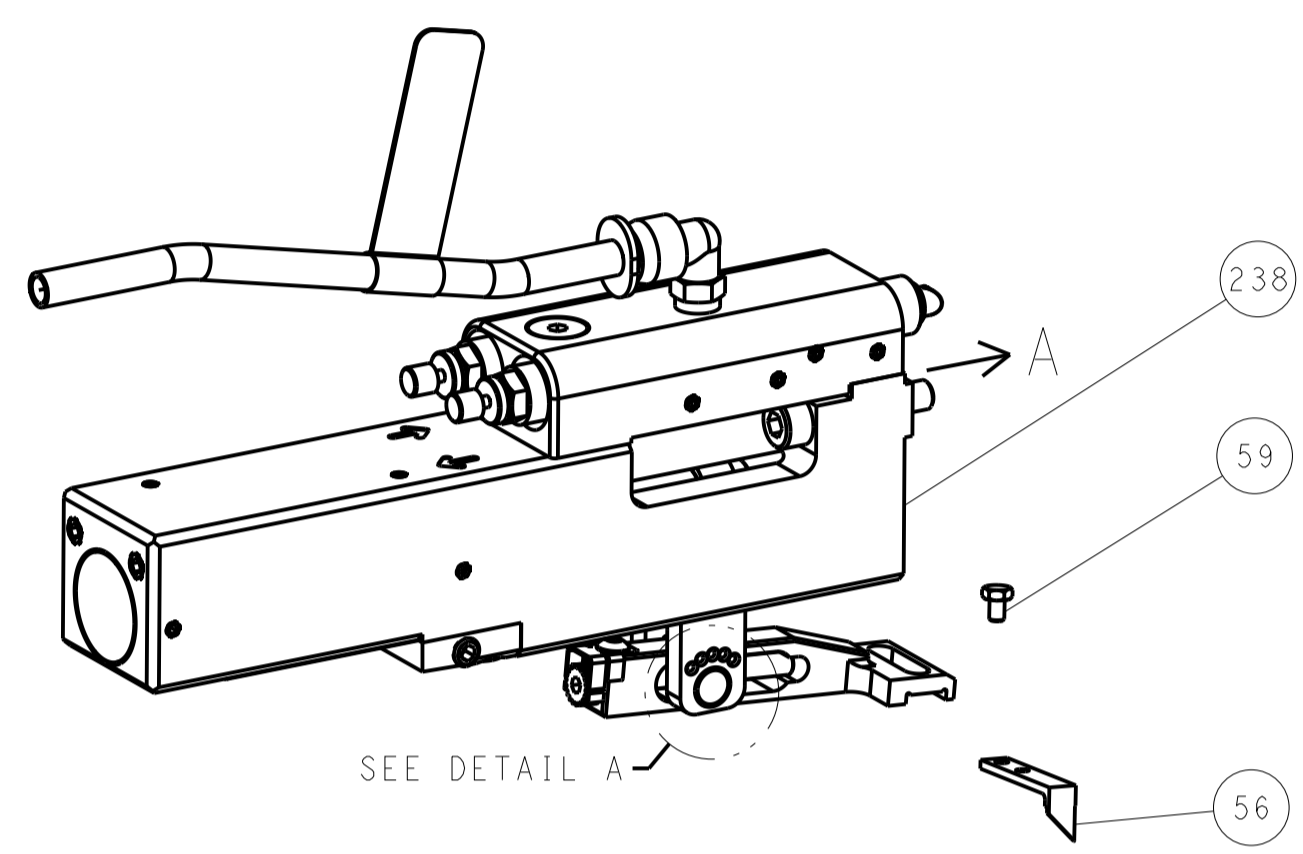
Customer Accessible Production Drawing

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

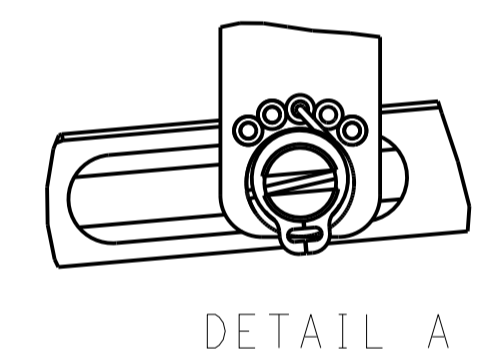
FEED TYPE MECHANICAL



PNEUMATIC

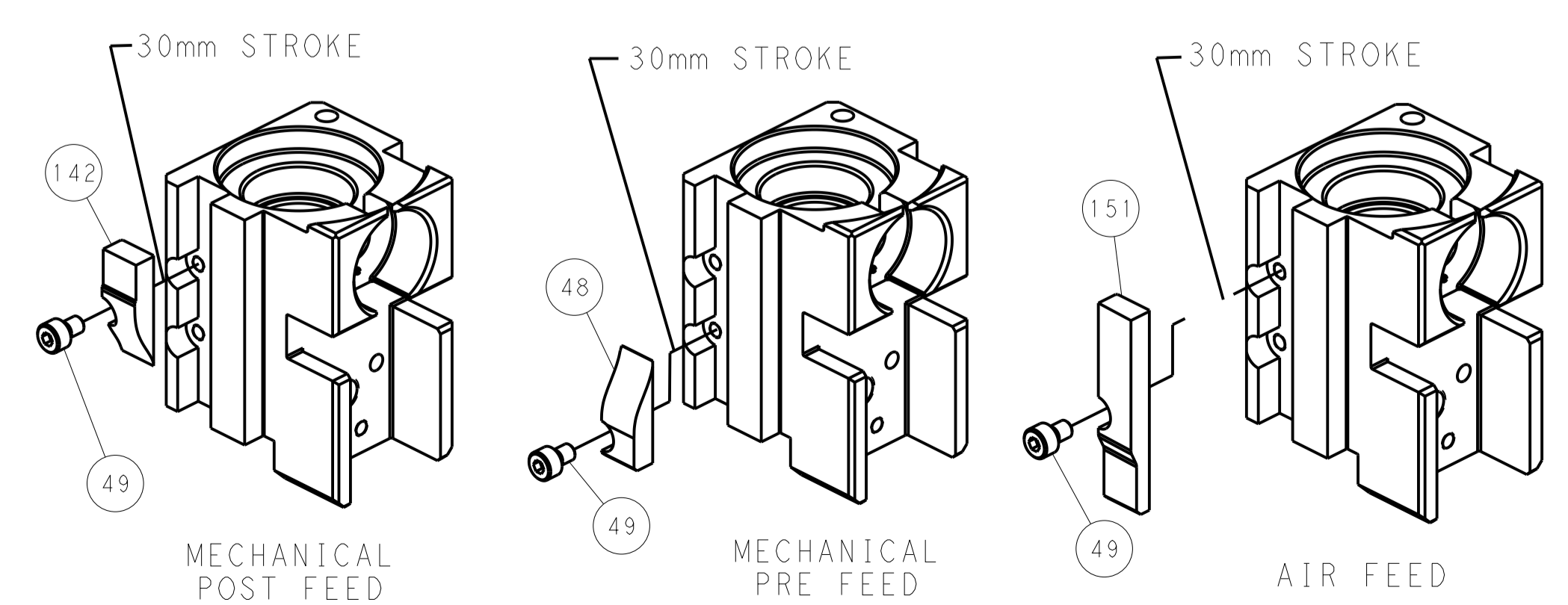


FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



DETAIL A

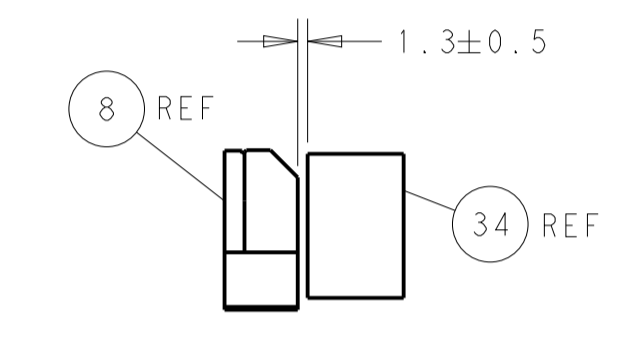
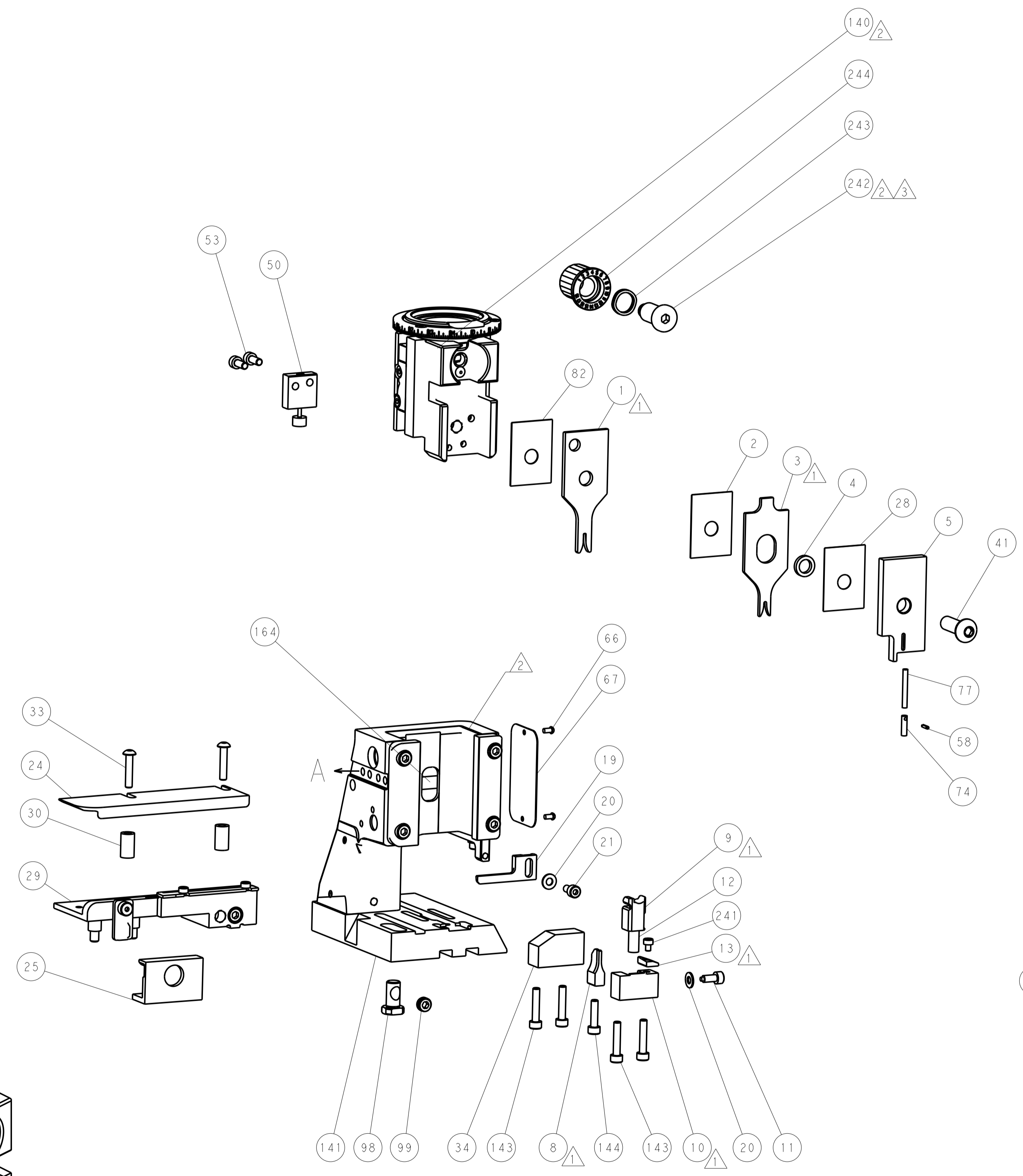
CAM POSITIONS



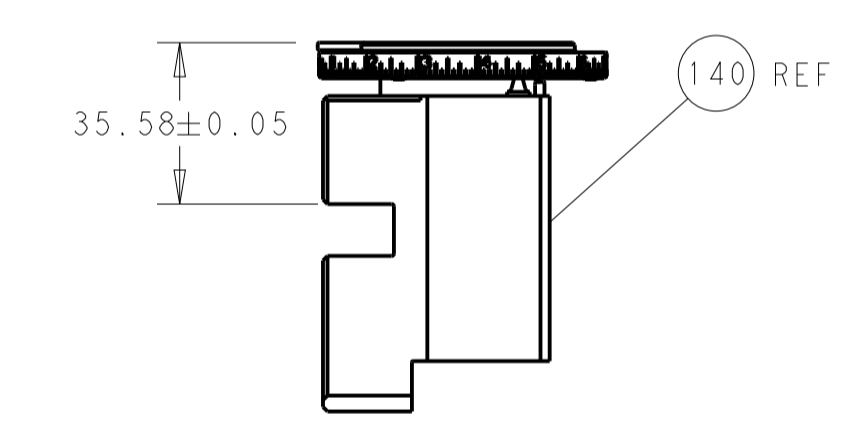
MECHANICAL
POST FEED

MECHANICAL
PRE FEED

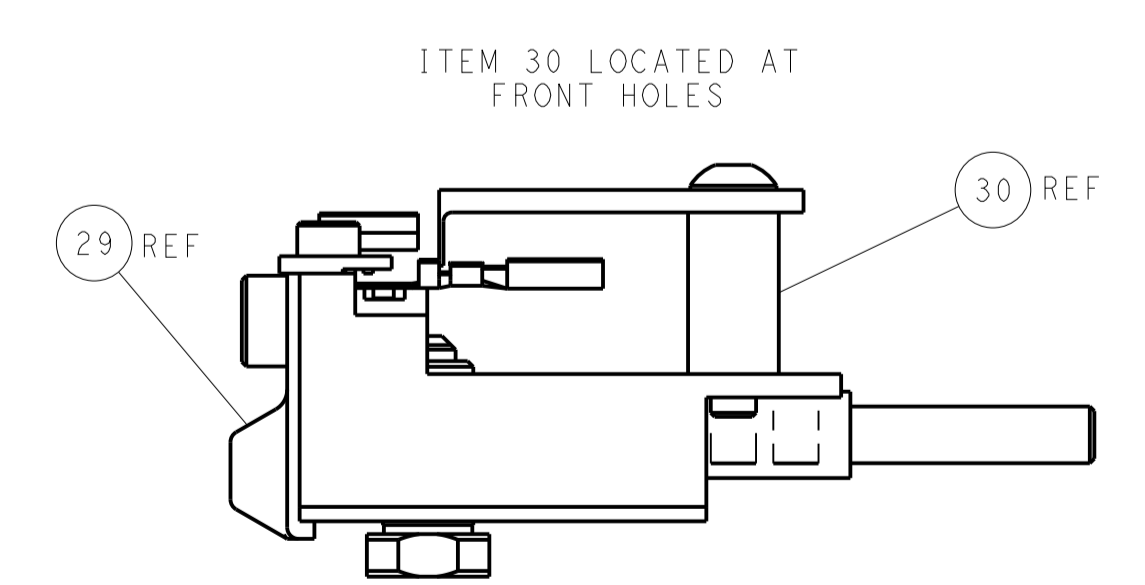
AIR FEED



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)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN Y. YIN 10MAY2012		TE Connectivity Harrisburg, PA 17105-3608	
mm	0 PLC	±		CHK G. BAILEY 10MAY2012	NAME	Ocean Side Feed Applicator	
	1 PLC	±		APVD S. XI 10MAY2012	PRODUCT SPEC	RESTRICTED TO	
	2 PLC	±			APPLICATION SPEC	SIZE CAGE CODE DRAWING NO	
	3 PLC	±				A1 00779 ©=2151665	
	4 PLC	±			WEIGHT	SCALE 1:2 SHEET 4 OF 4 REV 1	
	ANGLES	±			MATERIAL	Customer Accessible Production Drawing	