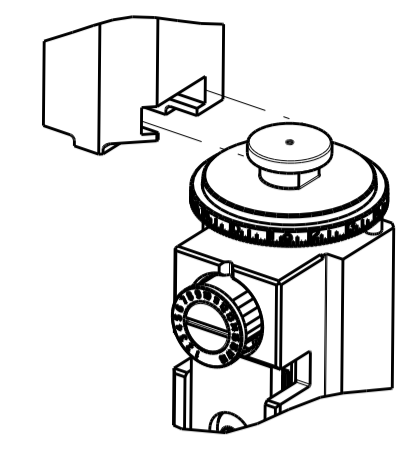


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151596-1	F	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2151596-2	G	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
5-2151596-1	F	SEAL STRIPPER CRIMPER TERMINATING UNIT	MECHANICAL
5-2151596-2	G	SEAL STRIPPER CRIMPER TERMINATING UNIT	PNEUMATIC
7-2151596-1	F	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2151596-2	G	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2151596-7	B	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.27 mm [.050]	F
INSUL	3.05 mm [.120]	O

APPLICATOR INSTRUCTIONS 408-35042

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: TAB CONTACT 1.2 MM - SWS			
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE		
3.00-3.60 mm [.118-.142 IN]	∅ 2.60 mm MAX		
TERMINAL APPLICATION SPECIFICATION	114-18464		

TERMINALS APPLIED				
TE TERMINAL	TE TERMINAL	TE SEAL	TE SEAL	CABLE DIAMETER
1718758-1	2141114-1		967067-1	∅ 1.4-2.1mm
1718758-2	2141114-3		967067-2	∅ 0.9-1.4mm
1718758-3	2208327-3		963142-2	∅ 0.9-1.4mm

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.35mm ²	0.84 +/- 0.03 [.033 +/- .001]	5.4
22 AWG	0.83 +/- 0.03 [.033 +/- .001]	5.5
0.25mm ²	0.78 +/- 0.03 [.031 +/- .001]	6.3
24 AWG	0.75 +/- 0.03 [.030 +/- .001]	6.6

- 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 TORQ-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	CHK	APP'D
A	66	E	24AUG2018	MP		GB
		F	20MAR2019	FZ		YY
		G	01APR2019	JAH		CT
		G1	03JUL2019	FZ		GS

QTY	DESCRIPTION	DATE	BY	CHK	APP'D
-	1803515-3				
-	2-1803583-1				
-	2119641-1				
-	2119082-9				
-	2079764-1				
-	2119083-1				
-	7-18023-7				
-	2119580-1				
-	2844940-1				
-	4-1722335-3				
-	1-5018030-0				
-	1-1752354-6				
-	993111-1				
-	5-22280-0				
-	1752353-3				
-	1901680-2				
-	994970-2				
-	2844908-1				
-	2844907-1				
-	455888-5				
-	1803607-3				
-	2119740-1				
-	2168078-1				
-	2168083-2				
-	5-18022-5				
-	985575-3				
-	1338685-1				
-	2168083-3				
-	2-2168083-5				
-	1803382-6				
-	18023-9				
-	2119652-1				
-	2119653-1				
-	1803583-9				
-	1803515-1				
-	1803602-1				
-	1752356-6				
-	2079383-5				
-	3-2844962-0				
-	2844992-1				
-	455888-3				
-	1320928-6				
-	2168083-2				
-	1-18028-2				
-	2119533-1				
-	2119806-1				
-	3-22280-3				
-	1-356885-4				
-	2119805-1				
-	318707-1				
-	3-1333225-9				
-	240641-3				
-	-				
-	2119781-2				
-	238011-4				
-	1-1633996-5				
-	455888-8				
-	1-1673600-0				

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

ITEM NO	PART NO	DESCRIPTION
-77	-72	-71
-52	-51	-2
-1		

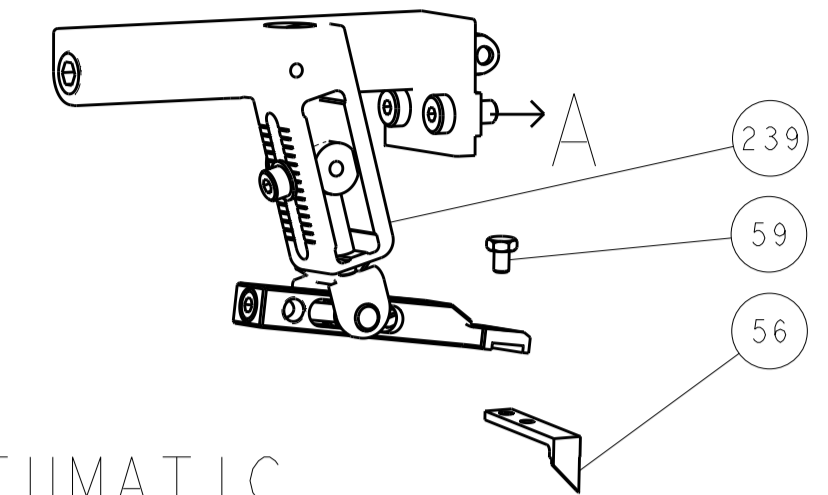
CHK	H. HUANG	27JUL2012
CHK	S. XI	27JUL2012
APP'D	S. XI	27JUL2012

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

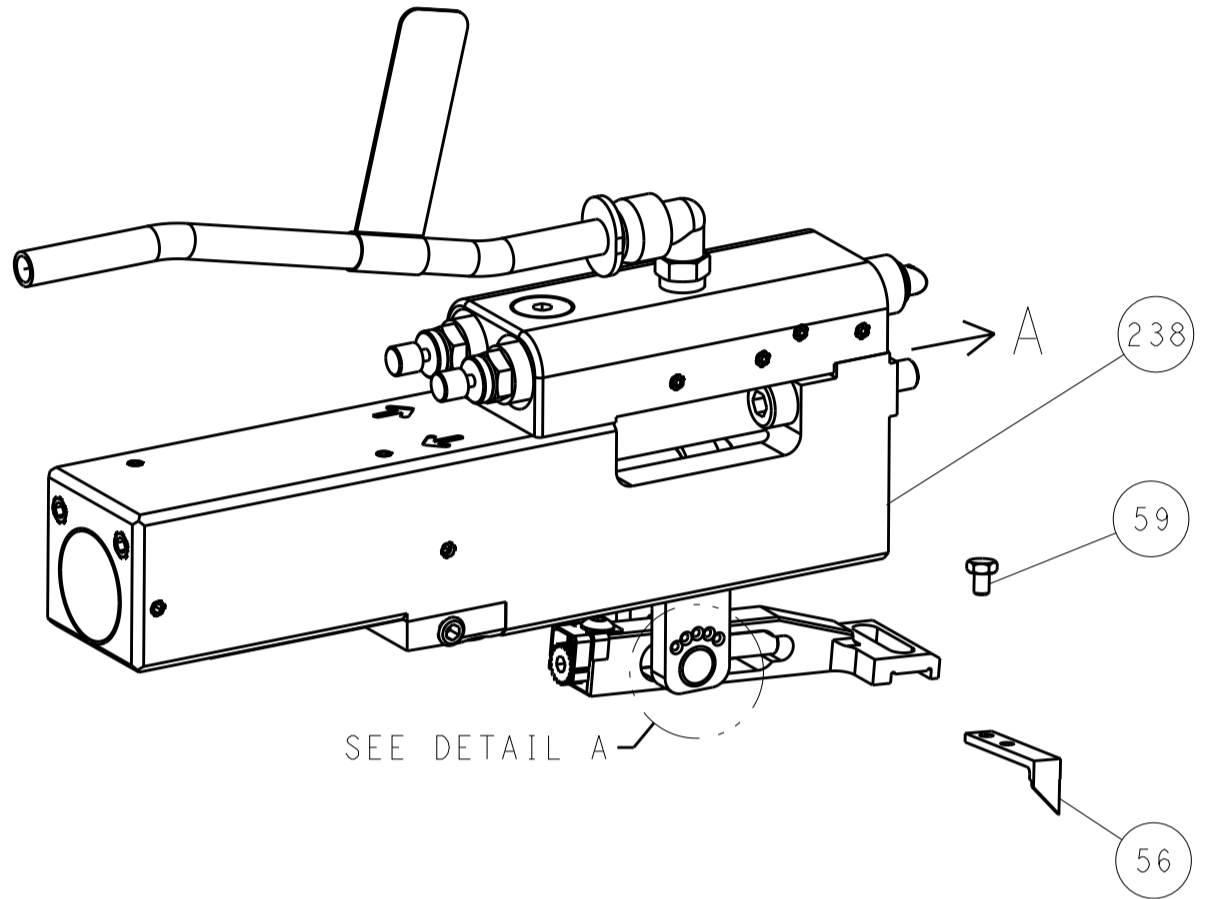
NAME	Ocean Side Feed Applicator	
SIZE	CAGE CODE	DRAWING NO
A1	00779	2151596
Customer Accessible Production Drawing		
SCALE	SHEET	REV
1:2	1 of 4	G1

LOC	DIST	REV	DATE	BY	CHK	APPV
A	66					

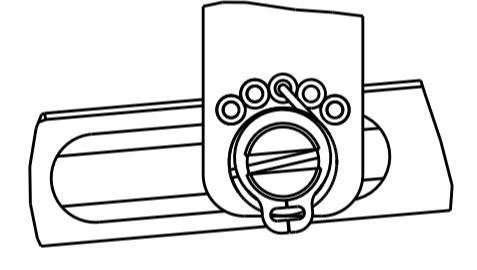
FEED TYPE MECHANICAL



PNEUMATIC

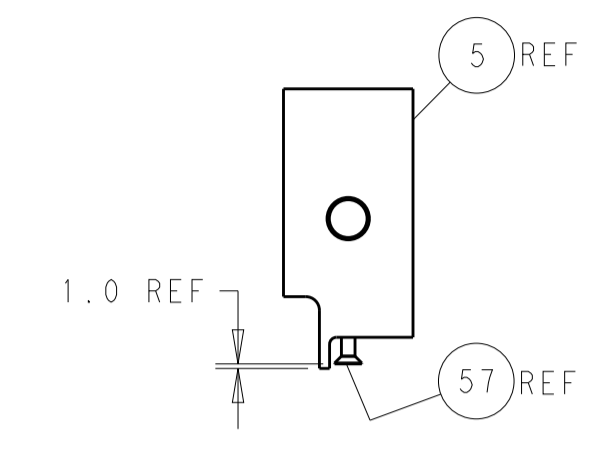
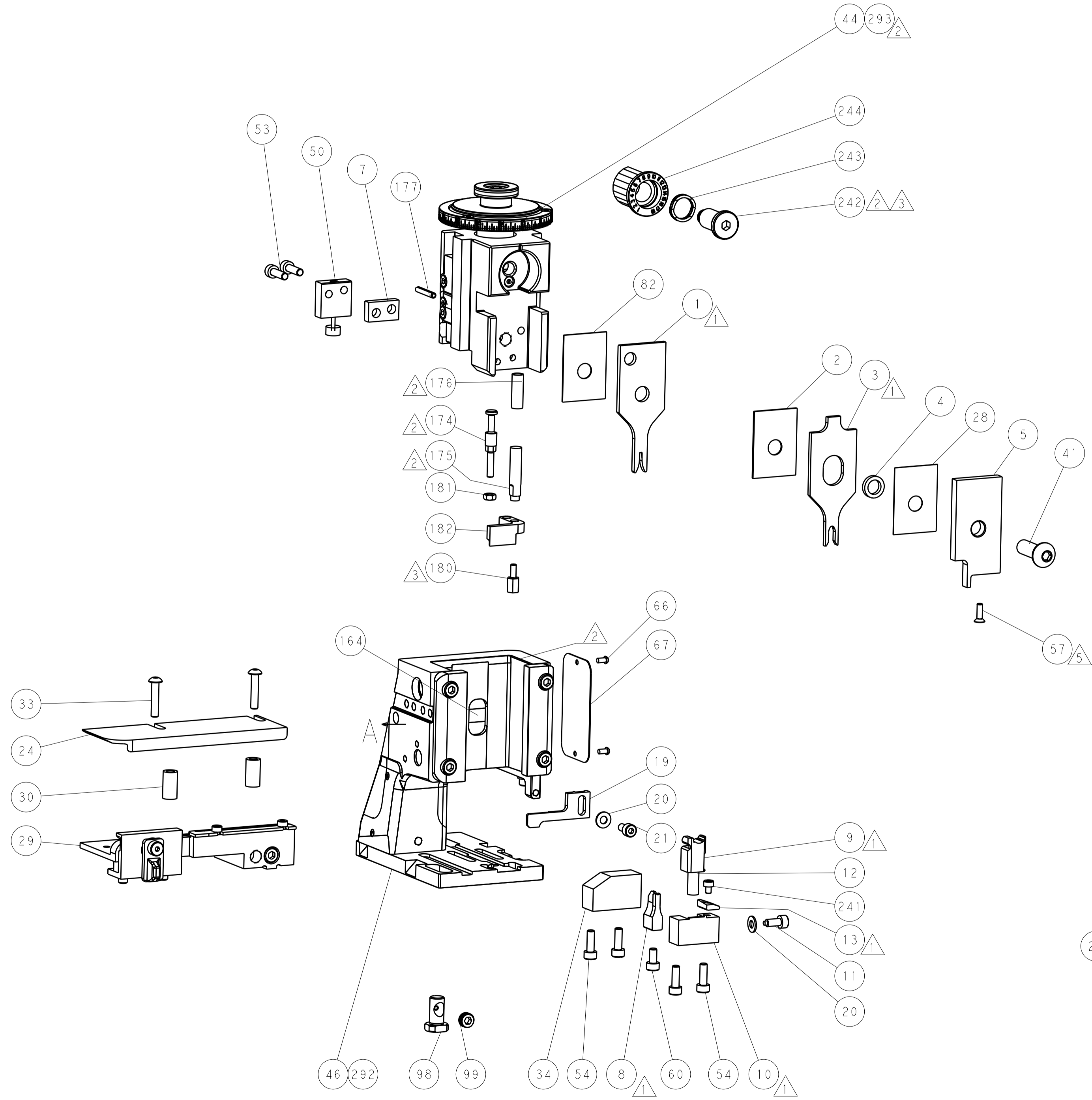
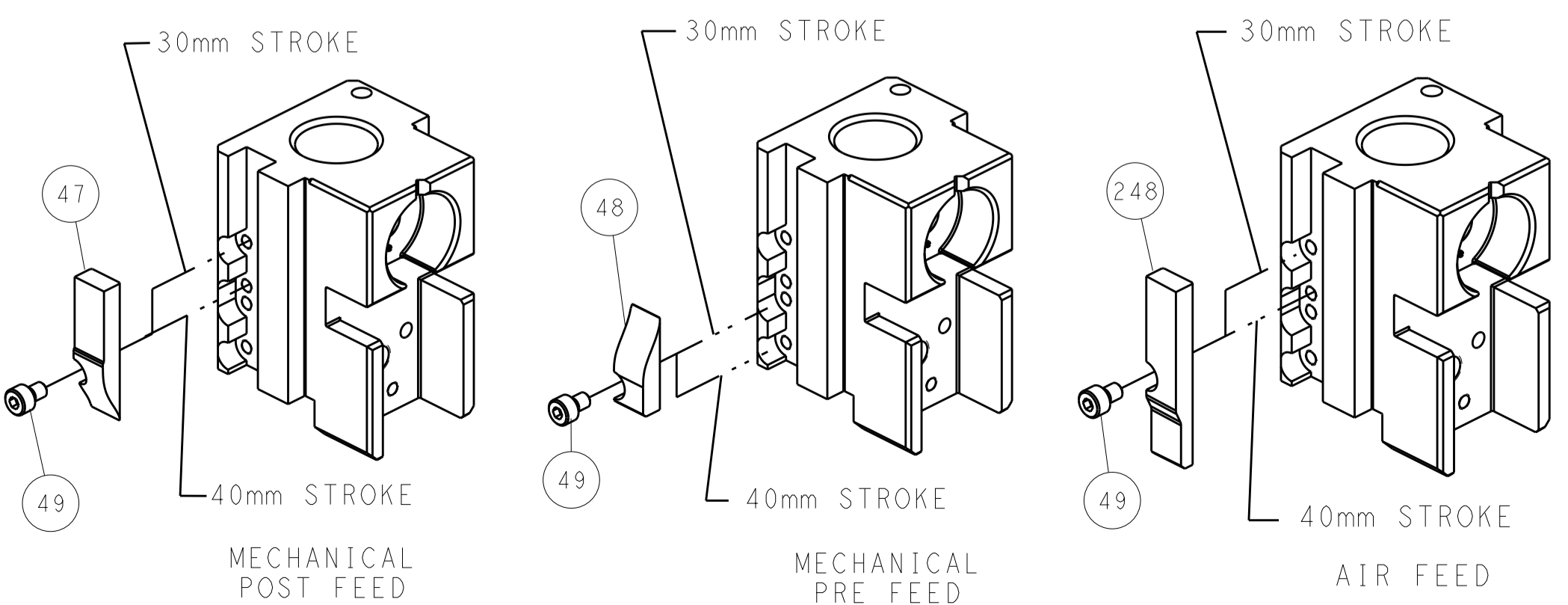


FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)

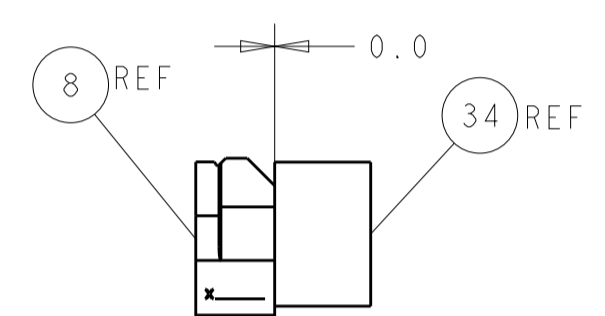


DETAIL A

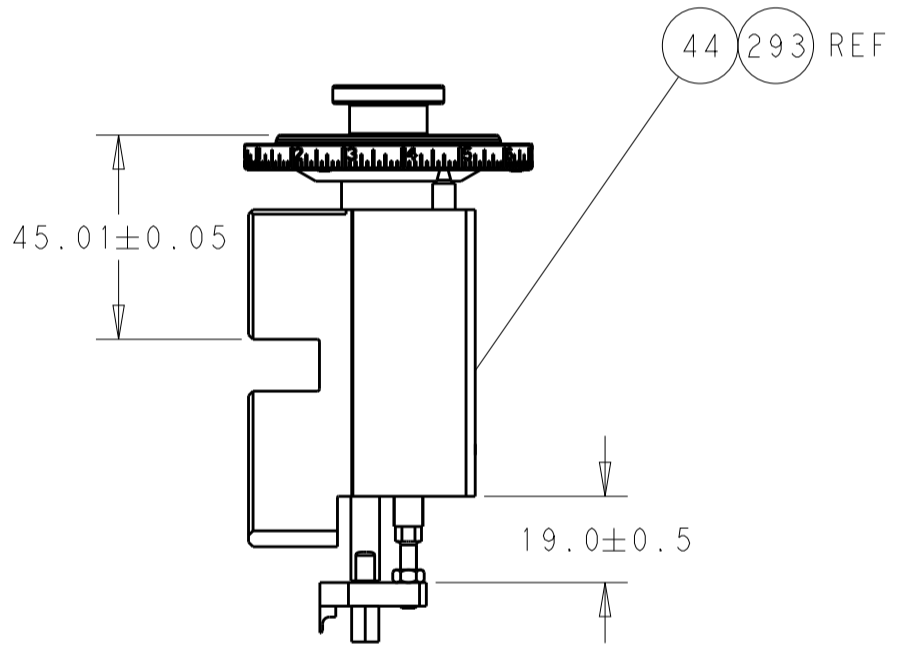
CAM POSITIONS



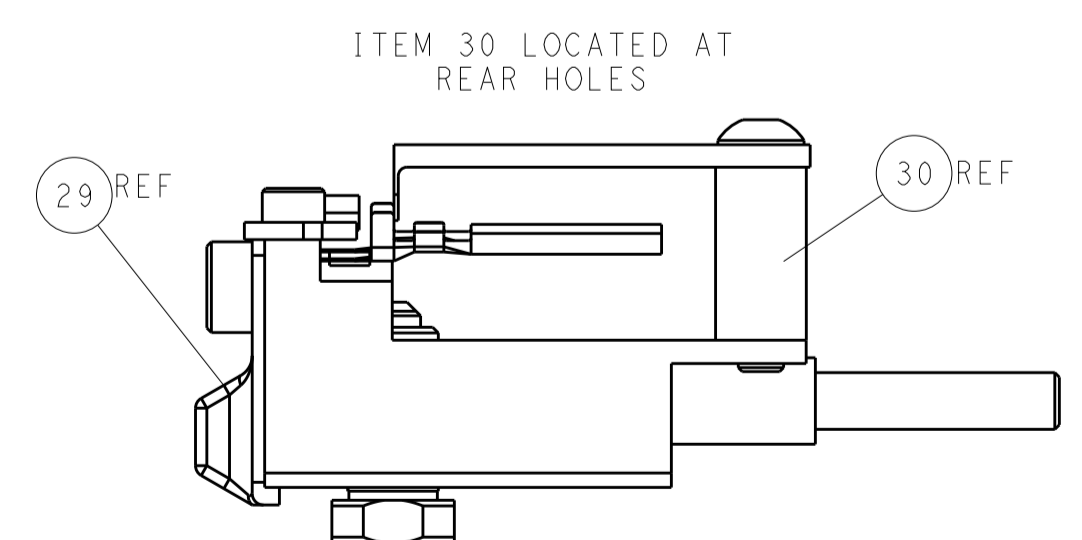
SHEAR DEPRESSOR DETAIL



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:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG		REV	
mm	0 PLC	±		H. HUANG	27JUL2012	NAME	TE Connectivity
	1 PLC	±		S. XI	27JUL2012	PRODUCT SPEC	Harrisburg, PA 17105-3608
	2 PLC	±		S. XI	27JUL2012	APPLICATION SPEC	
	3 PLC	±				SIZE	CAGE CODE DRAWING NO
	4 PLC	±				WEIGHT	A1 00779 ©=2151596
	ANGLES	±				RESTRICTED TO	
MATERIAL	FINISH					Customer Accessible Production Drawing	SCALE 1:2 SHEET 2 OF 4 REV G1

THIS DRAWING IS UNPUBLISHED.	RELEASED FOR PUBLICATION		
COPYRIGHT © BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.			
PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2151596-1	F	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2151596-2	G	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151596-7	B	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.27 mm [.050]	F
INSUL	3.05 mm [.120]	O
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION		
TERMINAL NAME: TAB CONTACT 1.2 MM - SWS				
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE		
3.00-3.60 mm [1.18-.142 IN]		∅ 2.60 mm MAX		
TERMINAL APPLICATION SPECIFICATION	114-18464	-	-	
TERMINALS APPLIED				
TE TERMINAL	TE TERMINAL	TE SEAL	TE SEAL	CABLE DIAMETER
1718758-1	2141114-1		967067-1	∅ 1.4-2.1mm
1718758-2	2141114-3		967067-2	∅ 0.9-1.4mm
1718758-3	2208327-3		963142-2	∅ 0.9-1.4mm

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.35mm2	0.84 +/- 0.03 [0.033 +/- .001]	5.4
22 AWG	0.83 +/- 0.03 [0.033 +/- .001]	5.5
0.25mm2	0.78 +/- 0.03 [0.031 +/- .001]	6.3
24 AWG	0.75 +/- 0.03 [0.030 +/- .001]	6.6

- 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.
- APPLY TORQ-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	REVISIONS					
A	66	P	LTN	DESCRIPTION	DATE	OWN	APVD
		-	-	SEE SHEET 1	-	-	-

-	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	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	1752356-6	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	2844992-1	ASSEMBLY, STRIP GUIDE	29
-	1	1	455888-3	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	318707-1	FLOATING SHEAR, FRONT	9
	1	1	3-1333225-9	ANVIL, COMBINATION	8
-	1	1	240641-3	SPACER	7
-	-	-	-	-	6
-	1	1	2119781-2	DEPRESSOR, SHEAR	5
-	1	1	238011-4	BLOCK, CRIMPER SPACER	4
	1	1	1-1633996-5	CRIMPER, INSULATION SPECIAL	3
-	1	1	455888-8	SPACER, CRIMPER	2
	1	1	1-1673600-0	CRIMPER, WIRE	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)

<small>THIS DRAWING IS UNPUBLISHED. IT IS THE PROPERTY OF TYCO ELECTRONICS CORPORATION. IT IS TO BE USED ONLY FOR THE PURPOSES SPECIFIED HEREIN. IT IS TO BE RETURNED TO TYCO ELECTRONICS CORPORATION IF IT IS NOT BEING USED FOR THE PURPOSES SPECIFIED HEREIN. IT IS TO BE DESTROYED IF IT IS NOT BEING USED FOR THE PURPOSES SPECIFIED HEREIN.</small>		DWN H. HUANG CHK S. XI APVD S. XI 27JUL2012	TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±	NAME Ocean Side Feed Applicator
MATERIAL: - FINISH: -		WEIGHT: - SCALE: 1:2 SHEET 3 OF 4 REV: G1	SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2151596 RESTRICTED TO: -
Customer Accessible Production Drawing		SCALE: 1:2 SHEET 3 OF 4 REV: G1	

