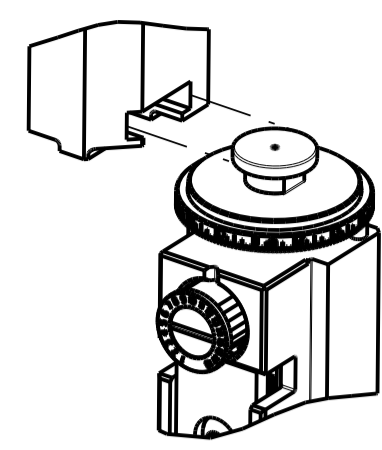


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151576-1	D	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2151576-2	D	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
5-2151576-1	D	SEAL STRIPPER CRIMPER TERMINATING UNIT	MECHANICAL
5-2151576-2	D	SEAL STRIPPER CRIMPER TERMINATING UNIT	PNEUMATIC
7-2151576-1	D	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2151576-2	D	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2151576-7	B	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.54 mm [.100]	F
INSUL	5.08 mm [.200]	O

APPLICATOR INSTRUCTIONS
408-35042

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: POWER QUADLOK, SOCKET CONTACT, SWS			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
4.70-5.30 mm [.185-.209 1N]		∅ -	
TERMINAL APPLICATION SPECIFICATION	114-18141-1	-	-

TERMINALS APPLIED				SEAL INSULATION DIAMETER RANGE
TE TERMINAL	TE TERMINAL	TE SEAL	TE SEAL	SEAL INSULATION DIAMETER RANGE
968121-2	968133-2	967607-1		∅ 2.2-3.0 mm
968121-4	968133-5			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
2.50mm2	1.99 +/- 0.05 [.078 +/- .002]	6.3
1.50mm2	1.69 +/- 0.05 [.067 +/- .002]	9.5

- 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 THIS APPLICATOR DOES NOT CUT CARRIER STRIP.
- 6 APPLY TORQ-SEAL IN ALLEN SOCKET TO FILL HOLE AFTER FLAT HD HAS BEEN ADJUSTED TO CORRECT HEIGHT AT QUALIFICATION.
- 7 TERMINAL LUBRICANT IS RECOMMENDED.
- 8. 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)

LOC	DIST	REVISIONS			
A	66	REV	DATE	BY	APPV
		A	RELEASED	10APR2013	KH SX
		B	ECR-17-004650	31MAR2017	TB TE
		C	ECR-17-008475	12JUN2017	TB TE
		D	ECR-21-005260	11MAY2021	FJ YY

-	-	-	1	1	-	-	1803515-3	RAM ASSEMBLY, SF ATLANTIC	293
-	-	-	1	1	-	-	3-1803583-7	APPLICATOR BASIC ASSEMBLY, SF	292
-	1	-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248
-	1	1	1	1	1	1	2119082-7	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	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	-	-	1-1752354-8	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	1-690438-0	FRONT STRIP GUIDE	96
-	1	1	1	1	1	1	455888-5	SPACER, CRIMPER	82
-	1	1	1	1	1	1	1803607-3	DOCUMENTATION PACKAGE	71
-	1	1	1	1	1	1	2119791-6	DEPRESSOR, WIRE	70
-	1	1	1	1	1	1	2119943-1	WASHER, SPACER	69
-	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	5018030-1	NUT, HEX, REG, RoHS, M3	58
-	1	1	1	1	1	1	1-2168083-3	SCR, SKT HD CAP, RoHS, M3 X 16	57
-	1	1	1	1	1	1	1-1338683-6	FEED PAWL	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	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	53
-	1	1	1	1	1	1	5018030-1	NUT, HEX, REG, RoHS, M3	52
-	1	1	1	1	1	1	811242-5	BUMPER, HOLD DOWN	51
-	1	1	1	1	1	1	690753-2	SPACER, TONKER	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	1-1803583-7	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	1-1752356-2	SUPPORT, TERMINAL	34
-	2	2	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	2	2	2	2	3-2844962-0	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	1	1	1	1	2844992-6	ASSEMBLY, STRIP GUIDE	29
-	1	1	1	1	1	1	1-455888-0	SPACER, CRIMPER	28
-	2	2	2	2	2	2	22283-1	SPRING, COMPRESSION	27
-	1	1	1	1	1	1	240792-1	DRAG, TERMINAL	25
-	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	3-22280-3	SPRING, COMPRESSION	12
-	1	1	1	1	1	1	1-356885-3	STOP, SHEAR	11
-	1	1	1	1	1	1	1-2119805-1	SHEAR HOLDER, FRONT	10
-	1	1	1	1	1	1	318059-9	FLOATING SHEAR, FRONT	9
1	2	2	1	1	1	1	4-1333206-9	ANVIL, COMBINATION .100	8
-	1	1	1	1	1	1	7-240641-1	SPACER	7
-	-	-	-	-	-	-	-	-	6
-	1	1	1	1	1	1	1803080-1	DEPRESSOR, SHEAR	5
-	1	1	1	1	1	1	2-238011-1	BLOCK, CRIMPER SPACER	4
1	2	2	1	1	1	1	2-1633996-3	CRIMPER, INSULATION SPECIAL	3
-	1	1	1	1	1	1	1-455888-1	SPACER, CRIMPER	2
1	2	2	1	1	1	1	1803454-4	CRIMPER, WIRE	1

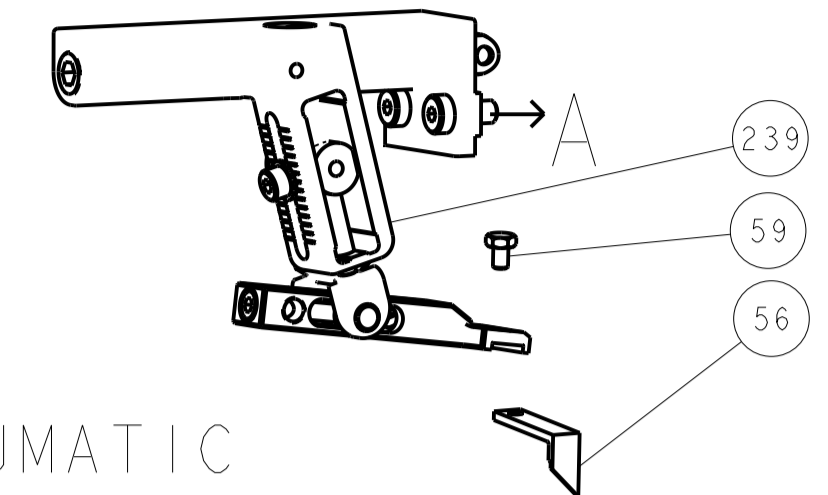
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mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES ±	FINISH

OWN	CHK	DATE	NAME
H. HUANG	S. XI	31JAN2013	S. XI
APV	DATE	NAME	
S. XI	31JAN2013	S. XI	
PRODUCT SPEC	APPLICATION SPEC	SIZE	CAGE CODE
		A1	00779
WEIGHT	SCALE	SHEET	REV
	1:2	1 of 4	D

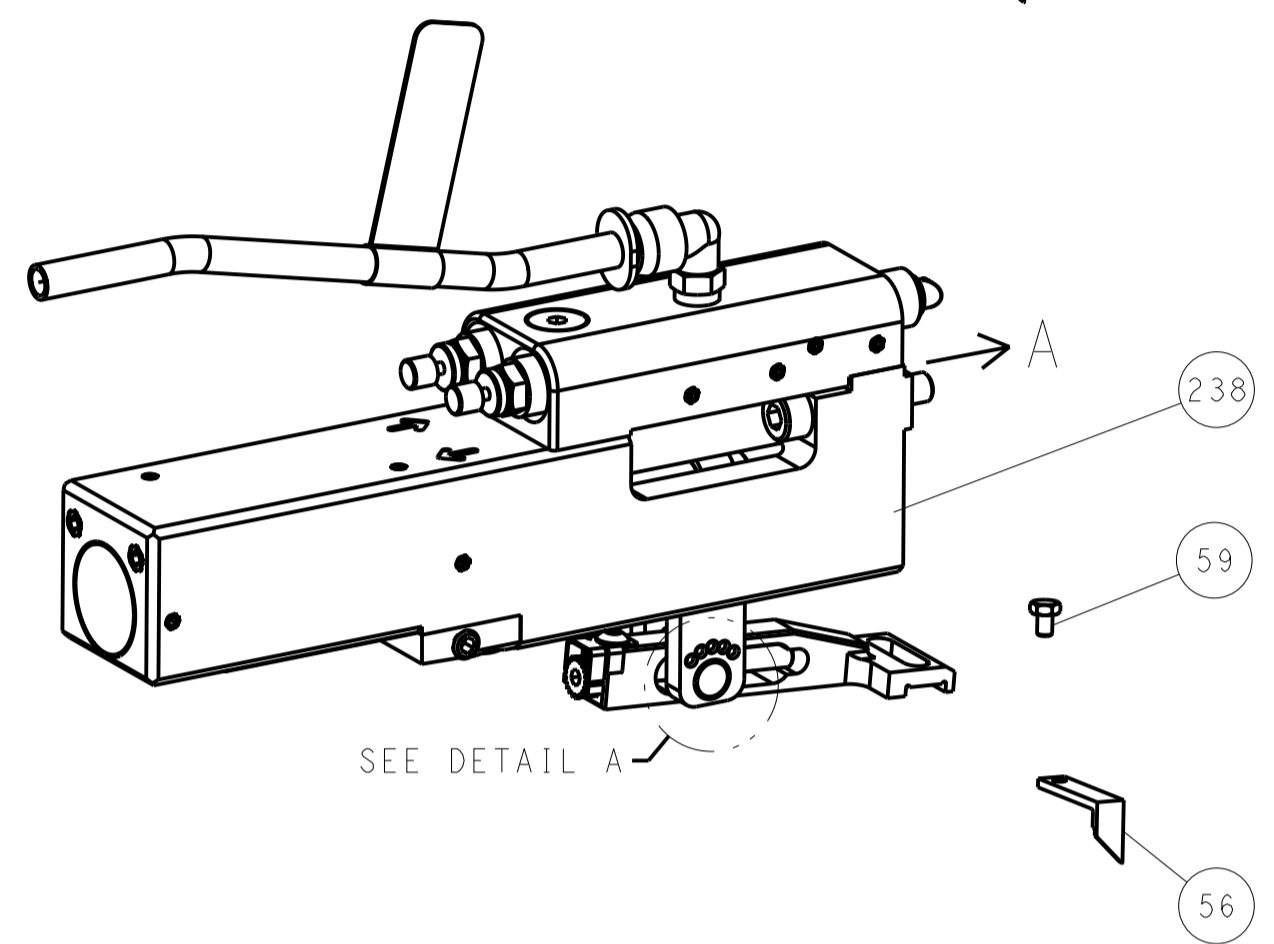
Customer Accessible Production Drawing

LOC	DIST	REV	DATE	BY	APP'D
A	66				

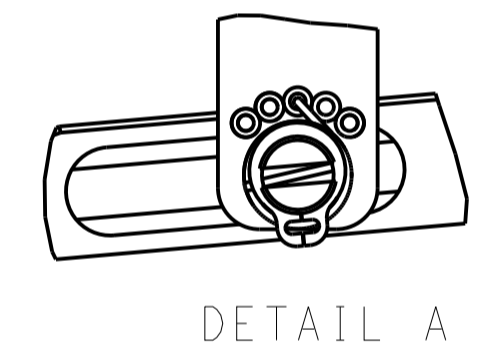
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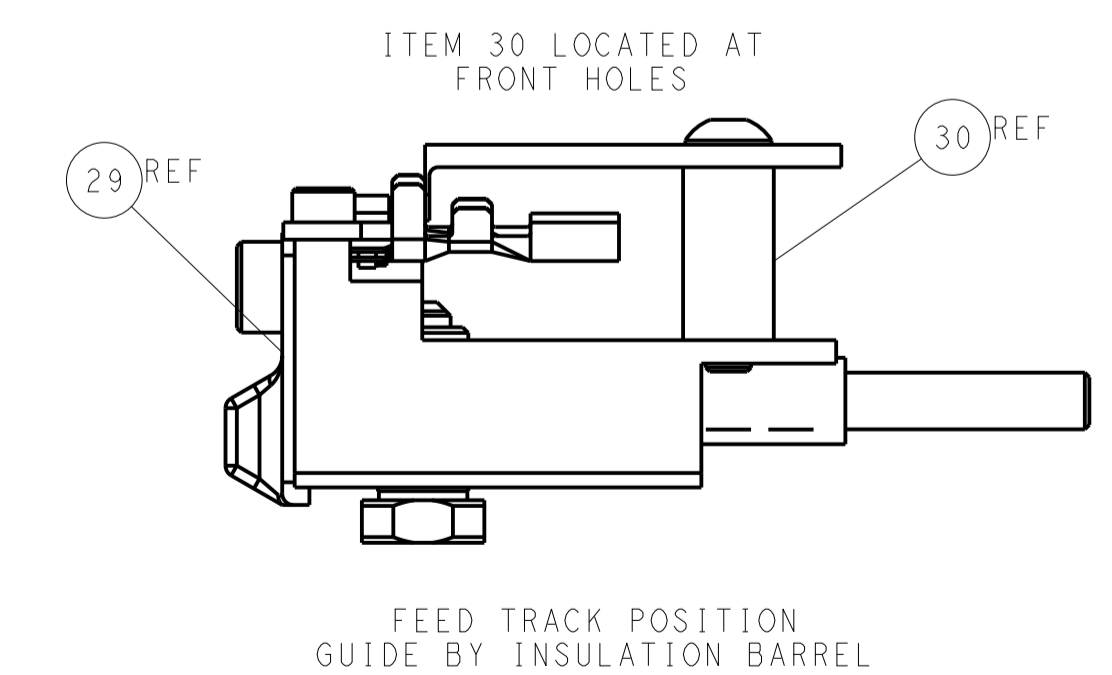
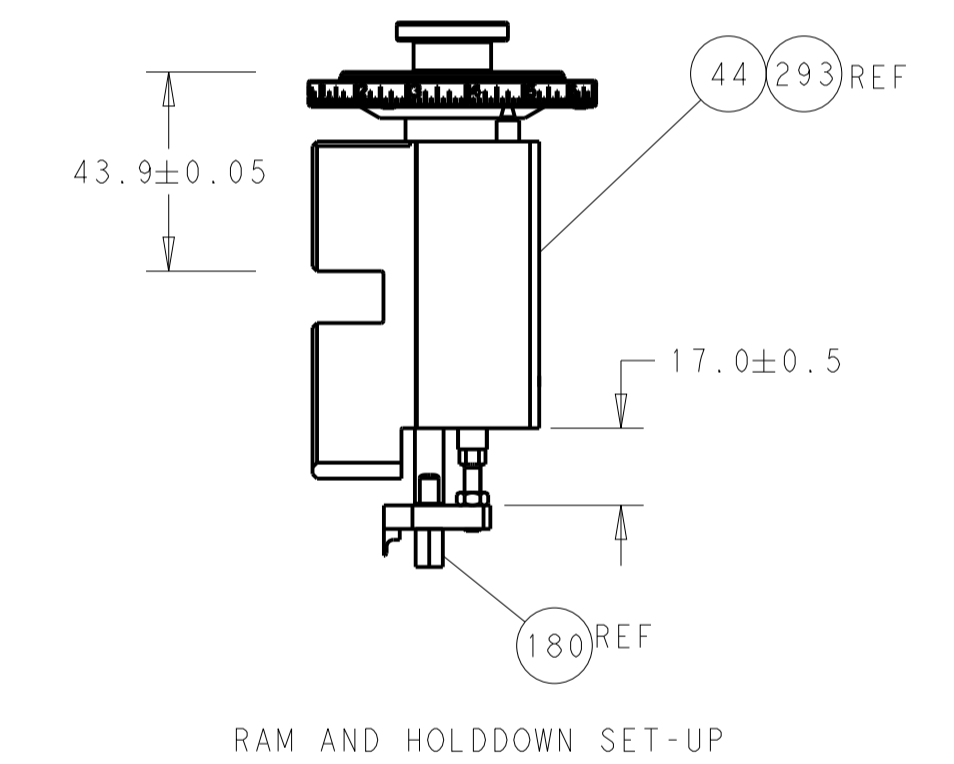
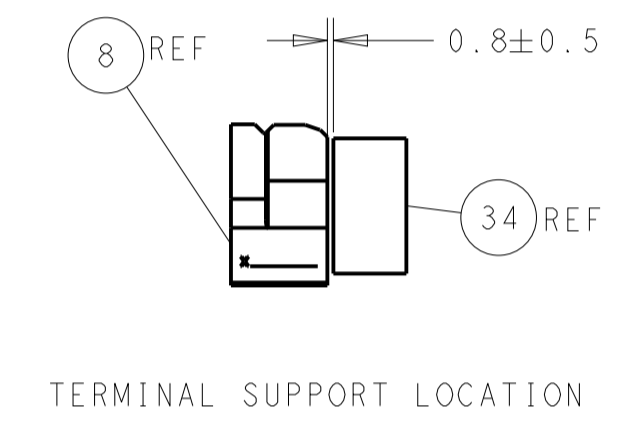
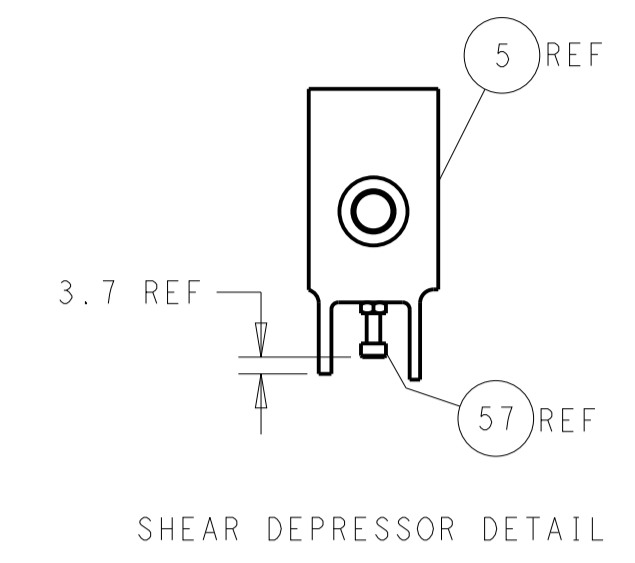
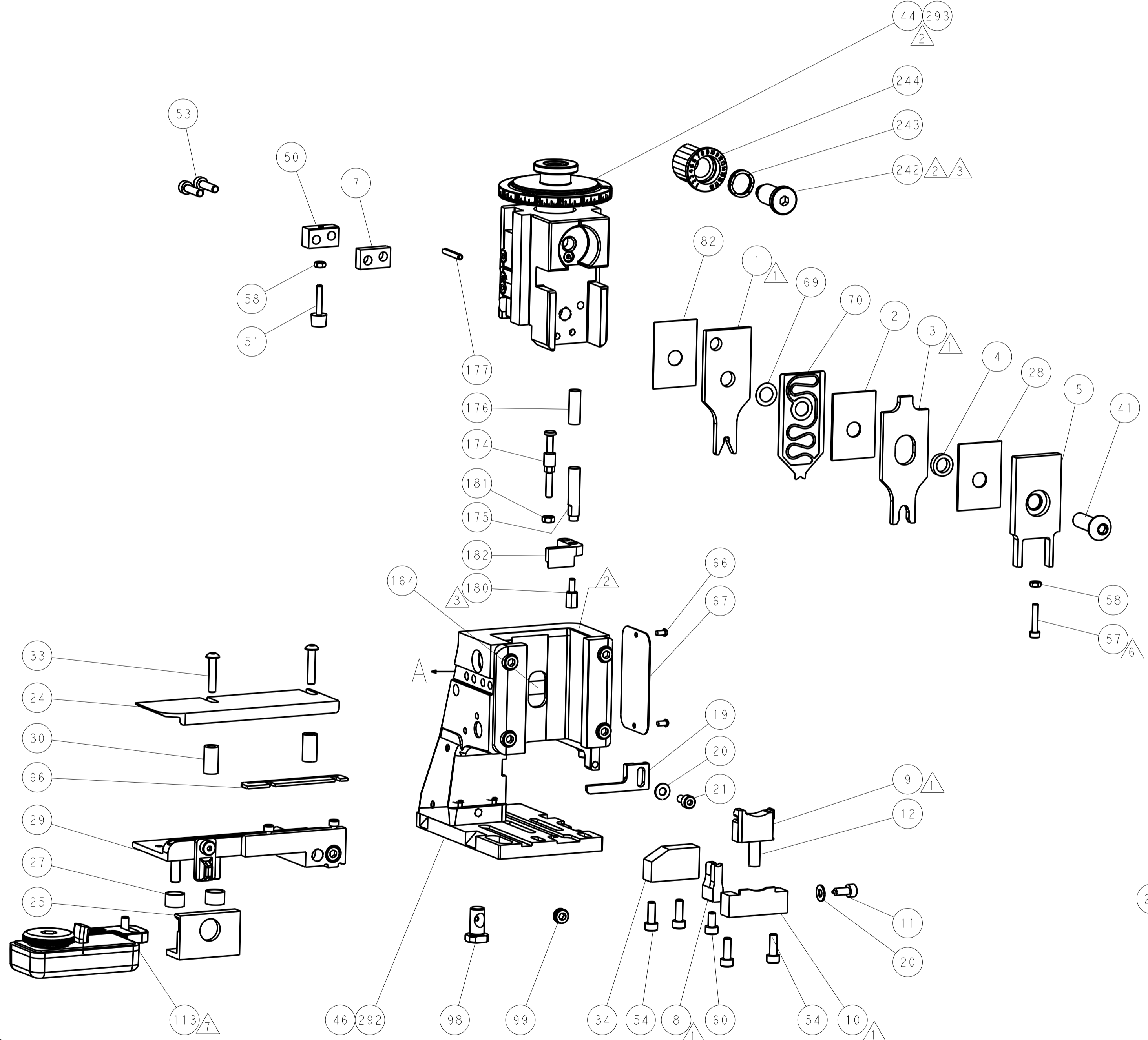
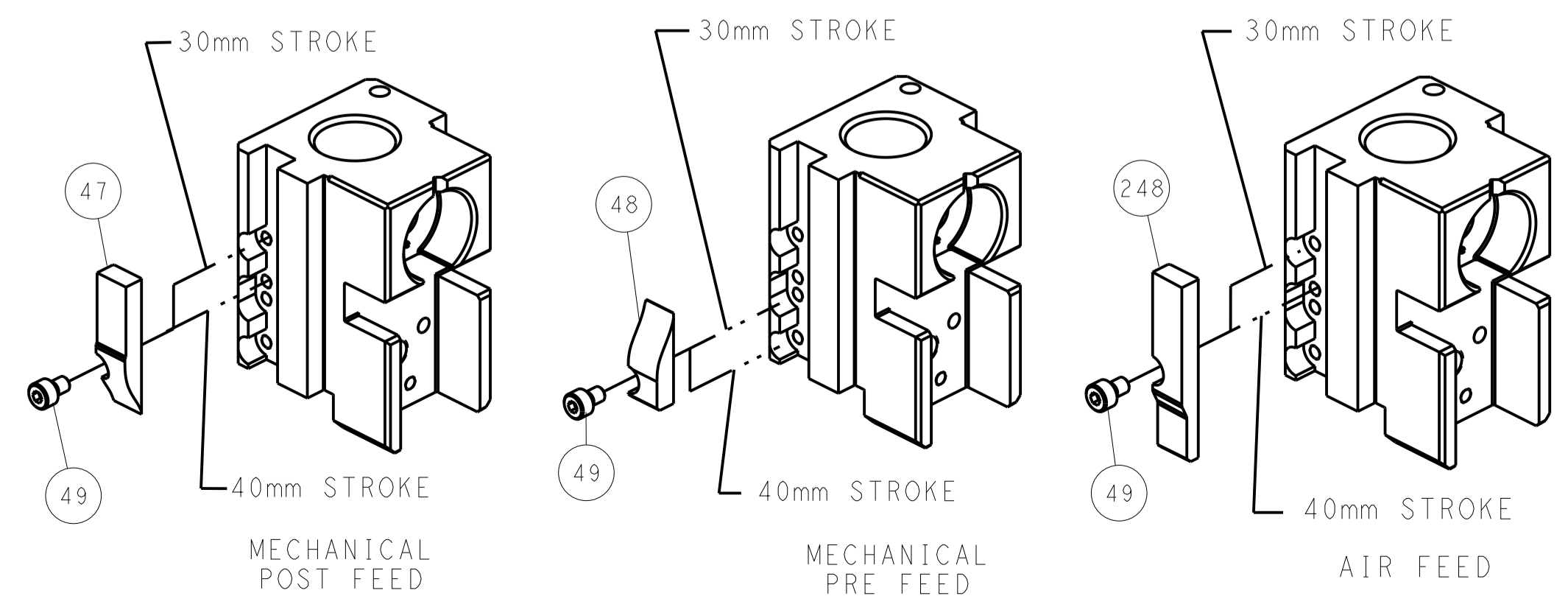
PNEUMATIC



FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



CAM POSITIONS

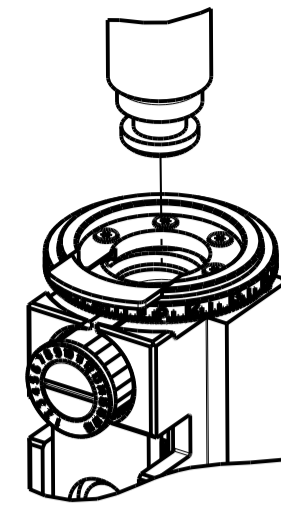


ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN R. HUANG 31 JAN 2013		TE Connectivity Harrisburg, PA 17105-3608
mm	0 PLC	±		CHK S. XI 31 JAN 2013	NAME Ocean Side Feed Applicator	
	1 PLC	±		APP'D S. XI 31 JAN 2013	PRODUCT SPEC	RESTRICTED TO
	2 PLC	±			APPLICATION SPEC	
	3 PLC	±			WEIGHT	
	4 PLC	±			SCALE	
	ANGLES	±			Customer Accessible Production Drawing	
MATERIAL	FINISH				SIZE A11	
					CAGE CODE 00779	
					DRAWING NO. 2151576	
					SHEET 2 OF 4	
					REV D	

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2151576-1	D	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2151576-2	D	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151576-7	B	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.54 mm [.100]	F
INSUL	5.08 mm [.200]	O

APPLICATOR INSTRUCTIONS
408-35042

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: POWER QUADLOK, SOCKET CONTACT, SWS			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
4.70-5.30 mm [1.85-.209 IN]		-	
TERMINAL APPLICATION SPECIFICATION	114-18141-1	-	-

TERMINALS APPLIED				SEAL INSULATION DIAMETER RANGE
TE TERMINAL	TE TERMINAL	TE SEAL	TE SEAL	SEAL INSULATION DIAMETER RANGE
968121-2	968133-2	967607-1		∅ 2.2-3.0 mm
968121-4	968133-5			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
2.50mm2	1.99+/-0.05 [1.078+/-0.002]	6.3
1.50mm2	1.69+/-0.05 [1.067+/-0.002]	9.5



- 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 THIS APPLICATOR DOES NOT CUT CARRIER STRIP.
- 6 APPLY TORO-SEAL IN ALLEN SOCKET TO FILL HOLE AFTER FLAT HD HAS BEEN ADJUSTED TO CORRECT HEIGHT AT QUALIFICATION.
- 7 TERMINAL LUBRICANT IS RECOMMENDED.
- 8. 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.

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				

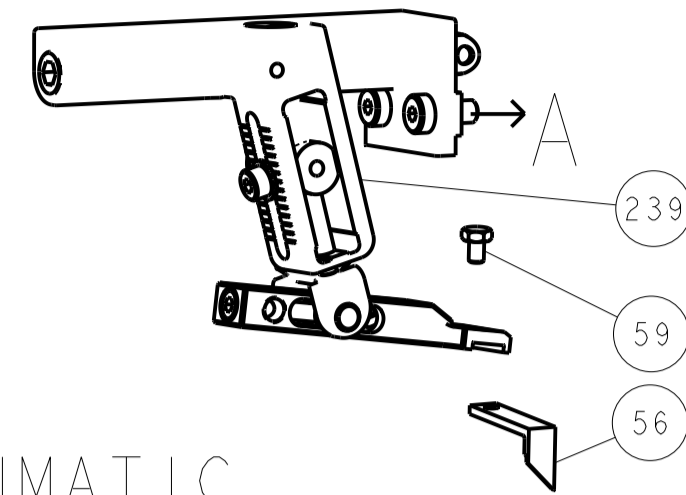
REV	DATE	DESCRIPTION	DATE	BY	APPV
-	1	1	2119082-7	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	1	-	2844940-1	AIR FEED MODULE	238
-	REF	REF	994970-2	COUNTER, MAGNETIC	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	1-1803583-8	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	1-690438-0	FRONT STRIP GUIDE	96
-	1	1	455888-5	SPACER, CRIMPER	82
-	1	1	1803607-3	DOCUMENTATION PACKAGE	71
-	1	1	2119791-6	DEPRESSOR, WIRE	70
-	1	1	2119943-1	WASHER, SPACER	69
-	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	5018030-1	NUT, HEX, REG, RoHS, M3	58
-	1	1	1-2168083-3	SCR, SKT HD CAP, RoHS, M3 X 16	57
-	1	1	1-1338683-6	FEED PAWL	56
-	2	2	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	53
-	1	1	5018030-1	NUT, HEX, REG, RoHS, M3	52
-	1	1	811242-5	BUMPER, HOLD DOWN	51
-	1	1	690753-2	SPACER, TONKER	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	1-1752356-2	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	2844992-6	ASSEMBLY, STRIP GUIDE	29
-	1	1	1-455888-0	SPACER, CRIMPER	28
-	2	2	22283-1	SPRING, COMPRESSION	27
-	1	1	240792-1	DRAG, TERMINAL	25
-	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	3-22280-3	SPRING, COMPRESSION	12
-	1	1	1-356885-3	STOP, SHEAR	11
-	1	1	1-2119805-1	SHEAR HOLDER, FRONT	10
-	1	1	318059-9	FLOATING SHEAR, FRONT	9
1	1	1	4-1333206-9	ANVIL, COMBINATION .100	8
-	1	1	7-240641-1	SPACER	7
-	-	-	-	-	6
-	1	1	1803080-1	DEPRESSOR, SHEAR	5
-	1	1	2-238011-1	BLOCK, CRIMPER SPACER	4
1	1	1	2-1633996-3	CRIMPER, INSULATION SPECIAL	3
-	1	1	1-455888-1	SPACER, CRIMPER	2
1	1	1	1803454-4	CRIMPER, WIRE	1

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		MATERIAL:		FINISH:	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES	

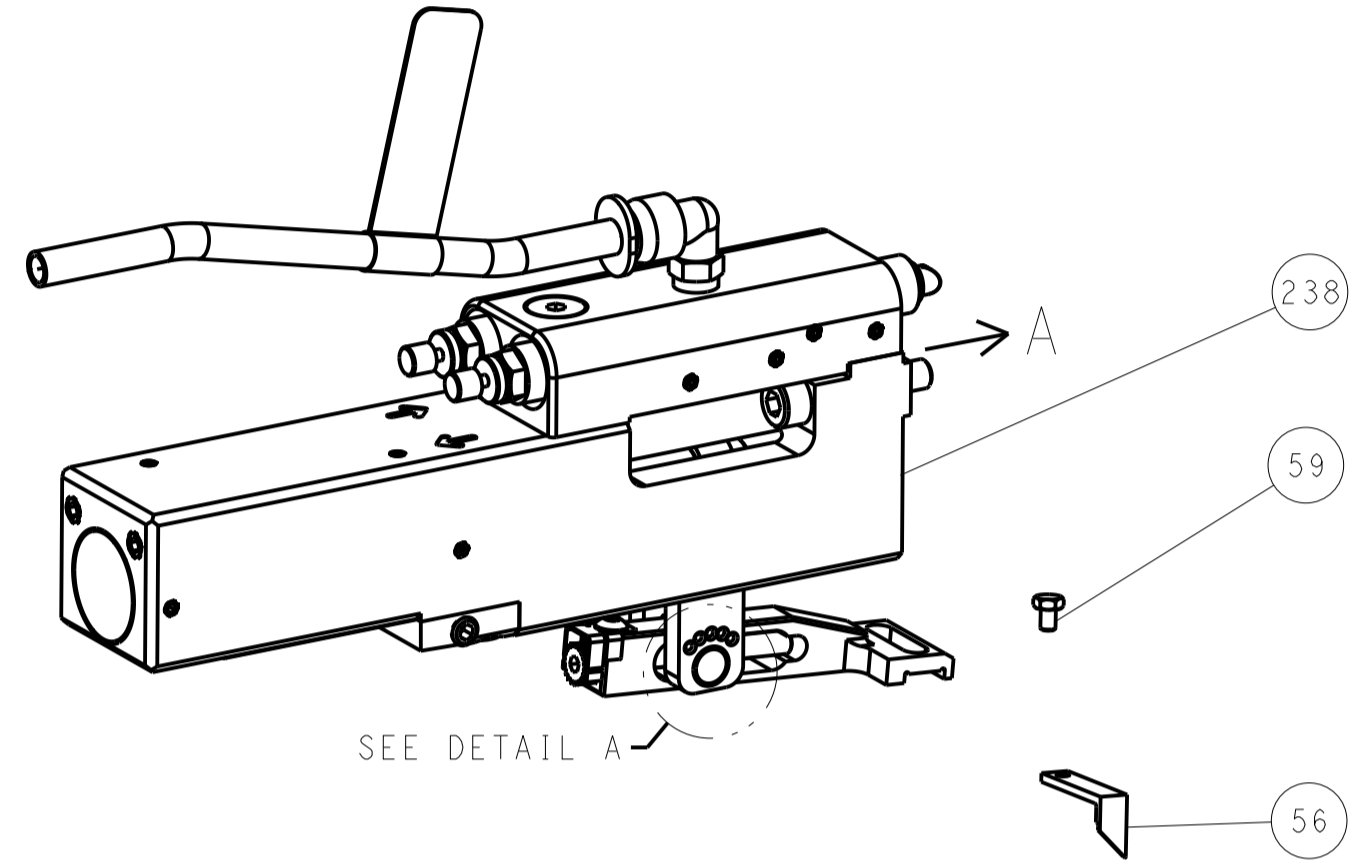
CHK	H. HUANG	31JAN2013
APPV	S. XI	31JAN2013
NAME	Ocean Side Feed Applicator	
SIZE	CAGE CODE	DRAWING NO
A1	00779	2151576
Customer Accessible Production Drawing		SCALE 1:2 SHEET 3 OF 4 REV D

LOC	DIST	REV	DATE	BY	APPV
A	66				
REVISIONS			DESCRIPTION	DATE	DWN
			SEE SHEET 1		

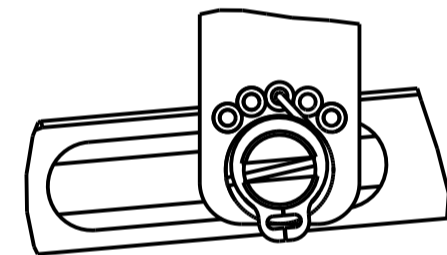
FEED TYPE MECHANICAL



PNEUMATIC

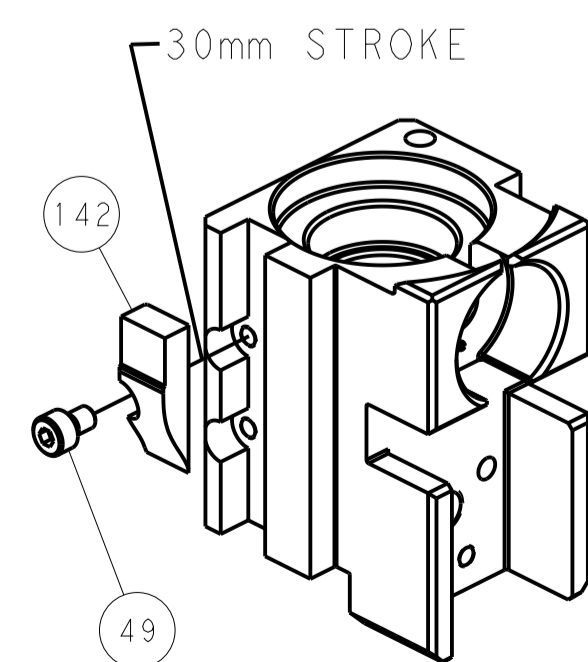


FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)

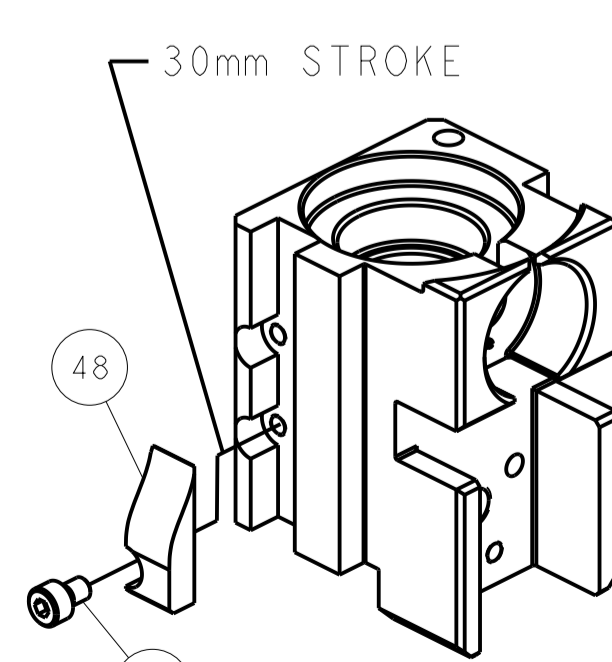


DETAIL A

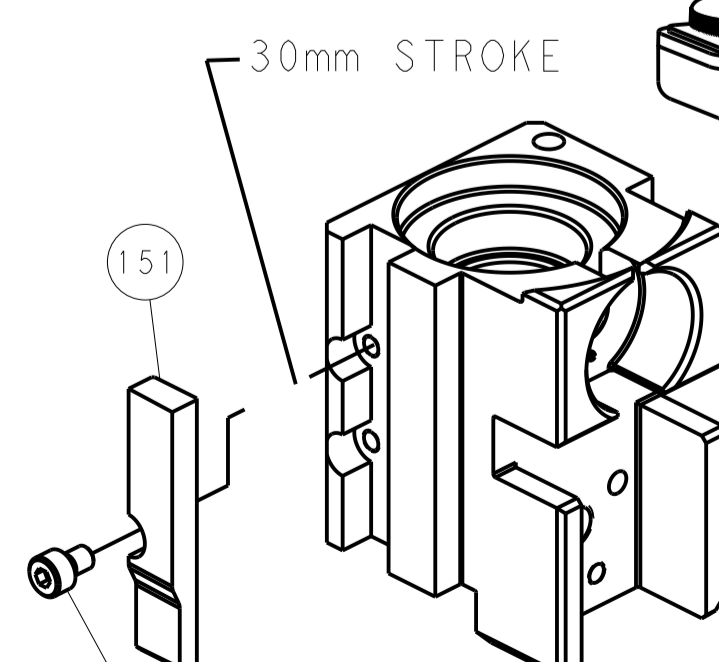
CAM POSITIONS



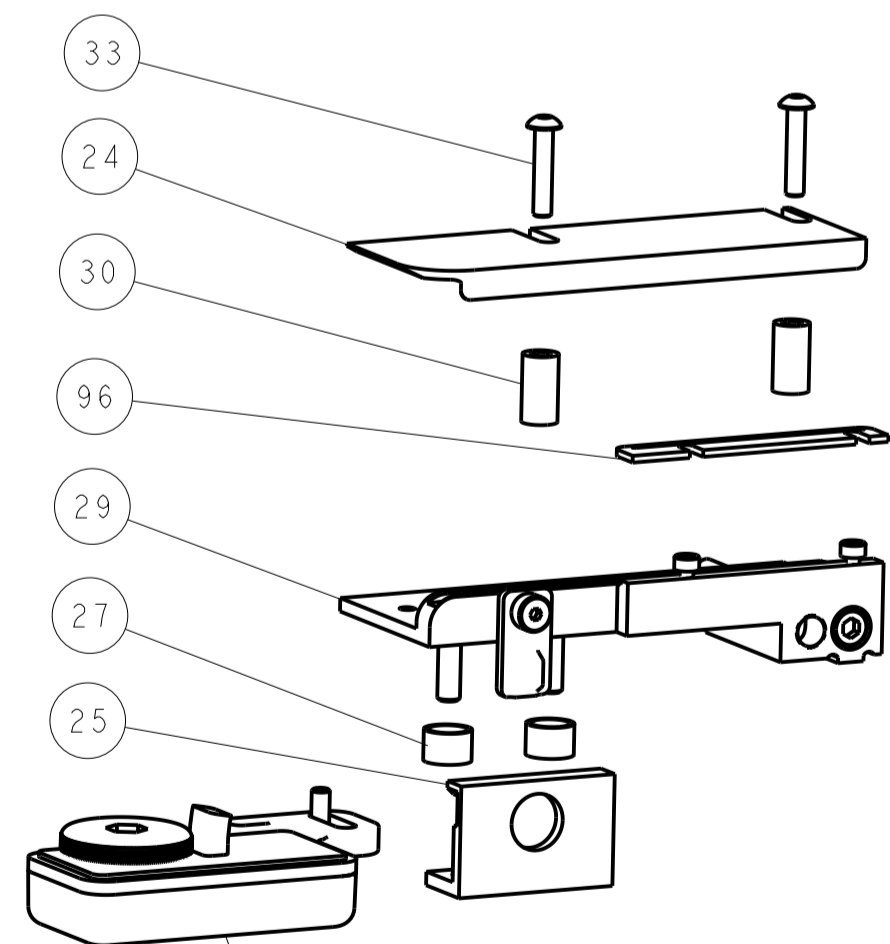
MECHANICAL
POST FEED



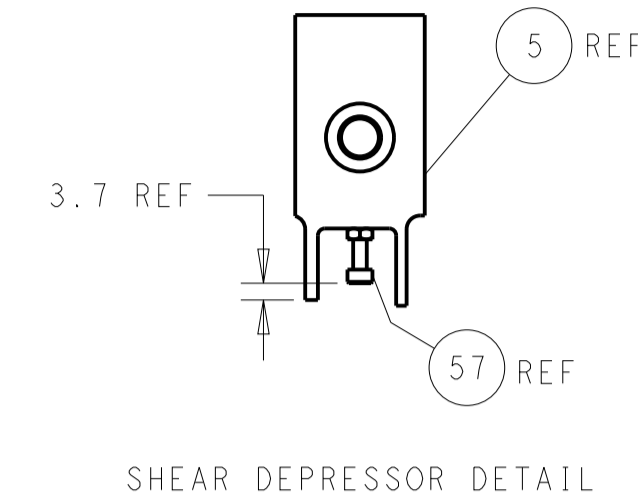
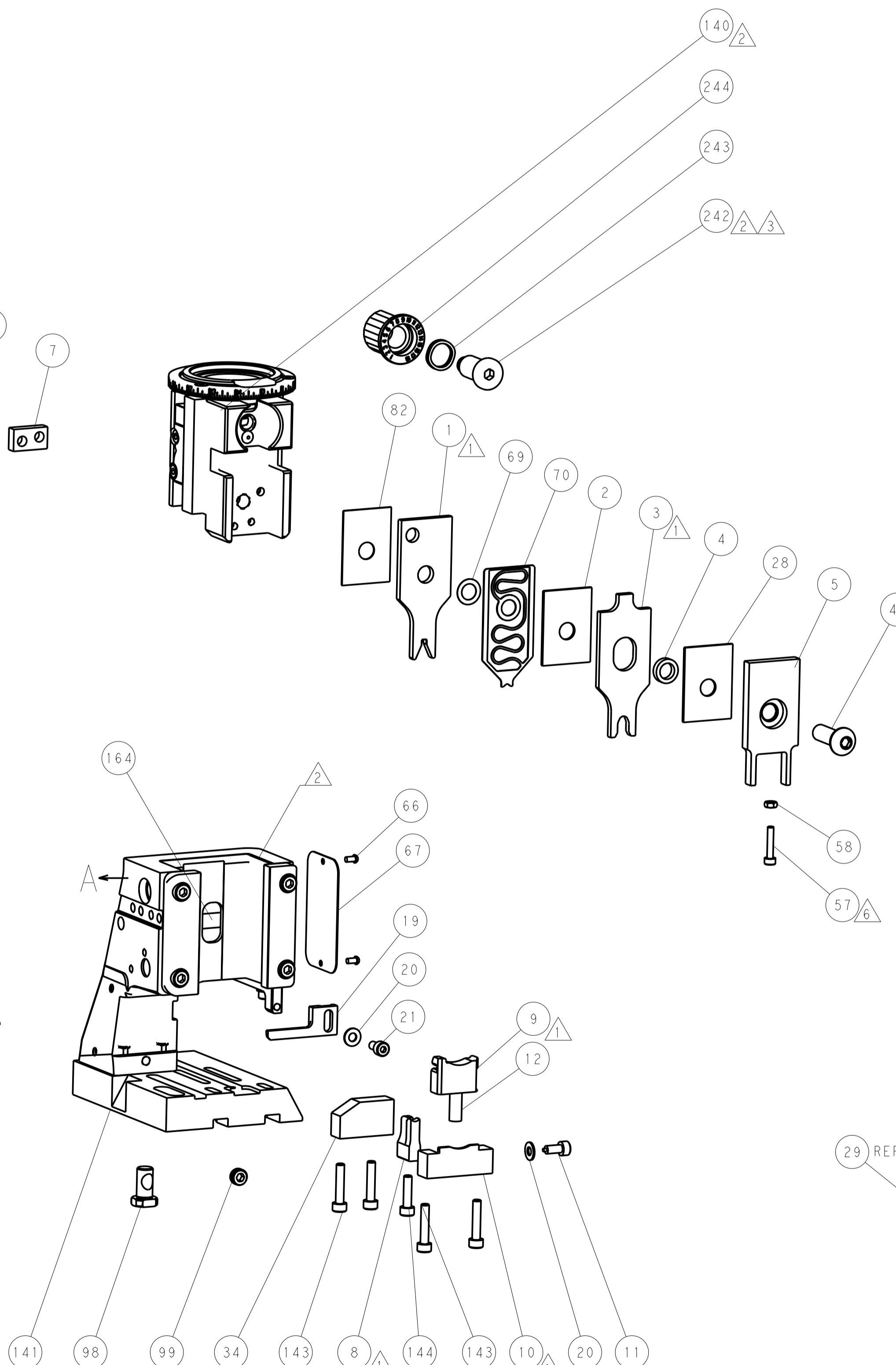
MECHANICAL
PRE FEED



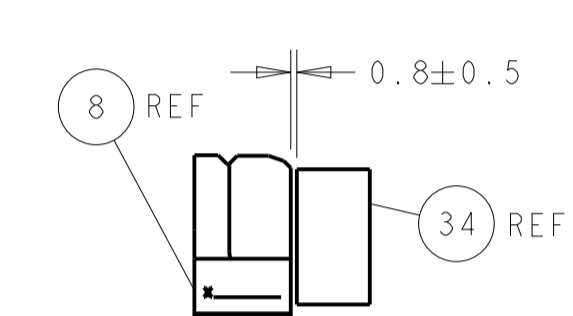
AIR FEED



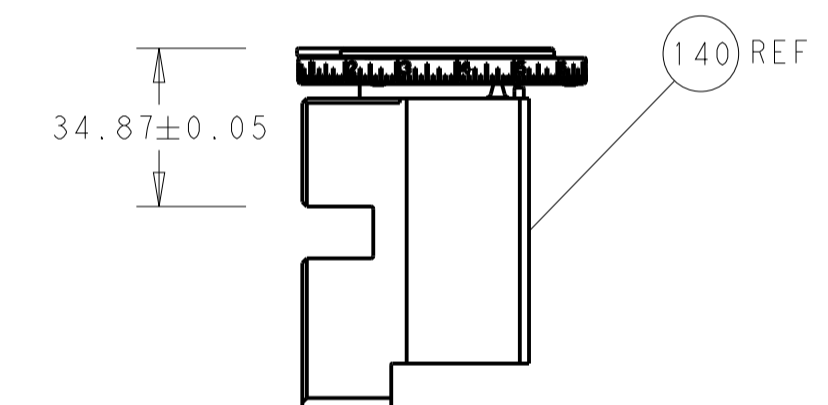
PACIFIC VERSION
 Shown on sheets 3 of 4 & 4 of 4
 (Atlantic version shown on sheets 1 of 4 & 2 of 4)



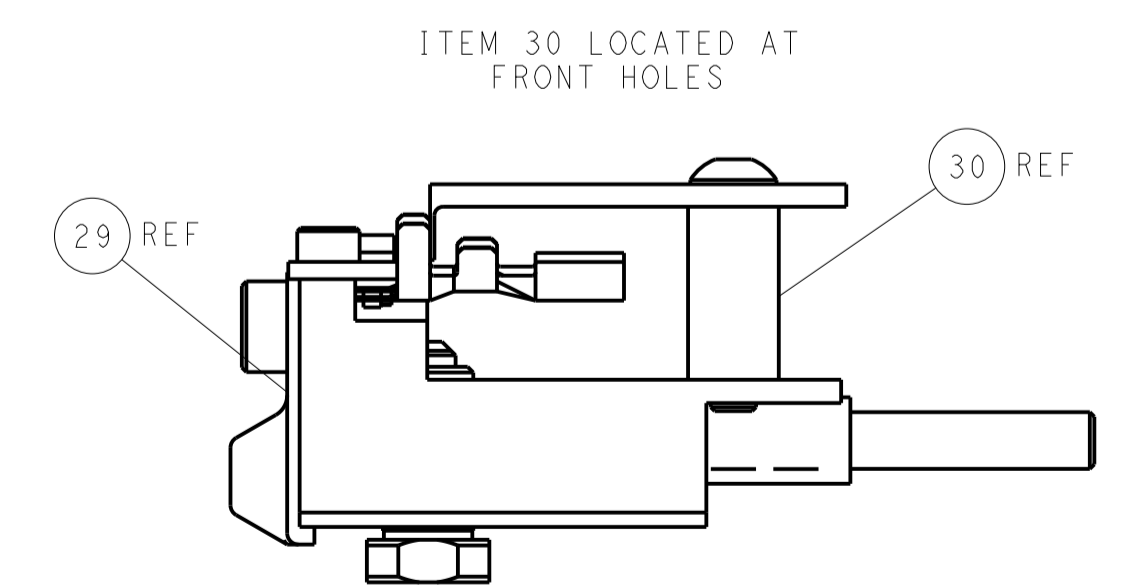
SHEAR DEPRESSOR DETAIL



TERMINAL SUPPORT LOCATION



RAM SET-UP



FEED TRACK POSITION
GUIDE BY INSULATION BARREL

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN: H. HUANG 31JAN2013		TE Connectivity	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	5 PLC ±	Harrisburg, PA 17105-3608
MATERIAL:	FINISH:	WEIGHT:	SCALE:	SIZE:	CAGE CODE:	DRAWING NO:	RESTRICTED TO:
			1:2	A1	00779	2151576	
Customer Accessible Production Drawing				SHEET 4 OF 4		REV D	