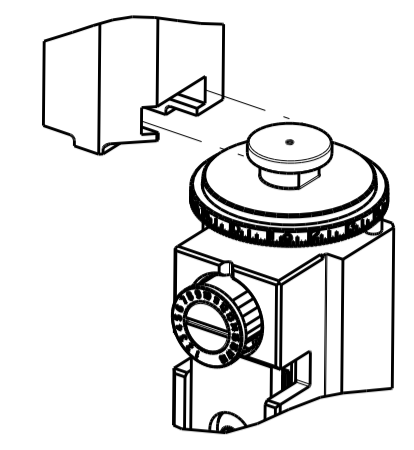


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151881-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2151881-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151881-1	B	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2151881-2	B	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2151881-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.29 mm [.090]	F
INSUL	3.68 mm [.145]	O

APPLICATOR INSTRUCTIONS 408-35042

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: .070 RECEPTACLE ECONOSEAL			
WIRE STRIP LENGTH		TERMINAL INSULATION DIAMETER RANGE	
4.00-4.50 mm [.157-.177 IN]		1.85-2.70 mm [.073-.106 IN]	
TERMINAL APPLICATION SPECIFICATION	114-3040		

TERMINALS APPLIED				SEAL INSULATION DIAMETER RANGE
TE TERMINAL	TE TERMINAL	TE SEAL	TE SEAL	
345806-1		347874-1		1.6-2.4 mm
175104-2		347875-1		2.7 mm MAX
344113-1		172888-2	1-172888-3	2.0-2.6 mm

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
2.00mm2	1.70 +/- 0.05 [.067 +/- .002]	4.2
1.50mm2	1.50 +/- 0.05 [.059 +/- .002]	6.3
1.00mm2	1.32 +/- 0.05 [.052 +/- .002]	8.4
0.75mm2	1.22 +/- 0.05 [.048 +/- .002]	9.4

- 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.

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

LOC	DIST	REV	DATE	BY	APPV
A	66	A	18DEC2013	LG	TE
		A1	08JAN2015	YY	UG
		B	12MAY2020	FZ	TE

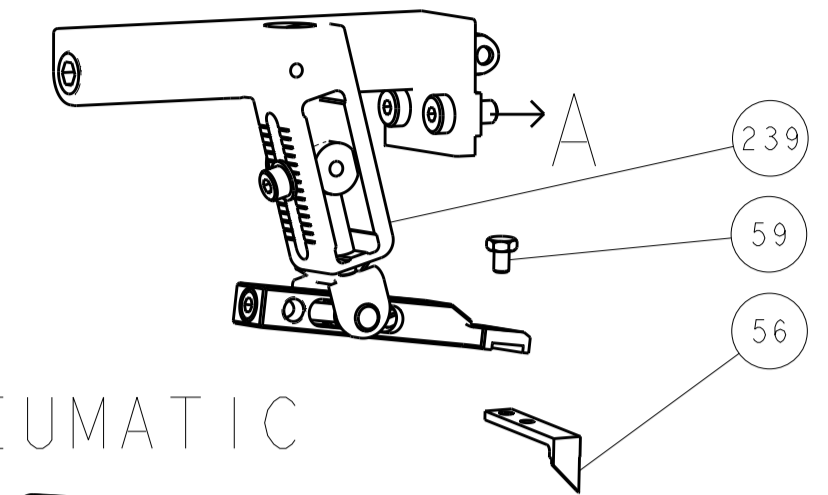
QTY	REF	REF	REF	REF	REF	DESCRIPTION	ITEM NO
-	1	-	1	-		2119641-1 FEED CAM, AIR FEED	248
-	1	1	1	1		2119082-7 CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	1		2079764-1 WASHER, WAVE SPRING, CREST-TO-CREST	243
3	-	1	1	1		2119083-1 RETAINER, INSULATION DIAL	242
-	1	1	1	1		7-18023-7 SCR, SKT HD CAP M3 X 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		1-18028-2 WASHER, FLAT, REG M4	119
-	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		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
5	-	1	1	1		985575-3 SCR, FLT SKT HD CAP M3 X 10.0	57
-	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		1752356-3 SUPPORT, TERMINAL	34
-	2	2	2	2		2079383-5 SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	2	2		3-2844962-0 SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	1	1		2844992-1 ASSEMBLY, STRIP GUIDE	29
-	1	1	1	1		455888-3 SPACER, CRIMPER	28
-	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
-	1	1	1	1		1-18028-2 WASHER, FLAT, REG M4	20
-	1	1	1	1		2119533-1 STRIPPER, SIDE FEED	19
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		2119805-1 SHEAR HOLDER, FRONT	10
1	-	1	-	1		318707-1 FLOATING SHEAR, FRONT	9
1	2	2	1	1		1333205-9 ANVIL, COMBINATION	8
-	-	-	-	-		-	7
-	-	-	-	-		-	6
-	1	1	1	1		2119781-1 DEPRESSOR, SHEAR	5
-	1	1	1	1		2-238011-2 BLOCK, CRIMPER SPACER	4
1	2	2	1	1		3-2119784-8 CRIMPER, INSULATION O PREMIUM	3
-	1	1	1	1		455888-9 SPACER, CRIMPER	2
1	2	2	1	1		3-456406-3 CRIMPER, WIRE PREMIUM	1

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

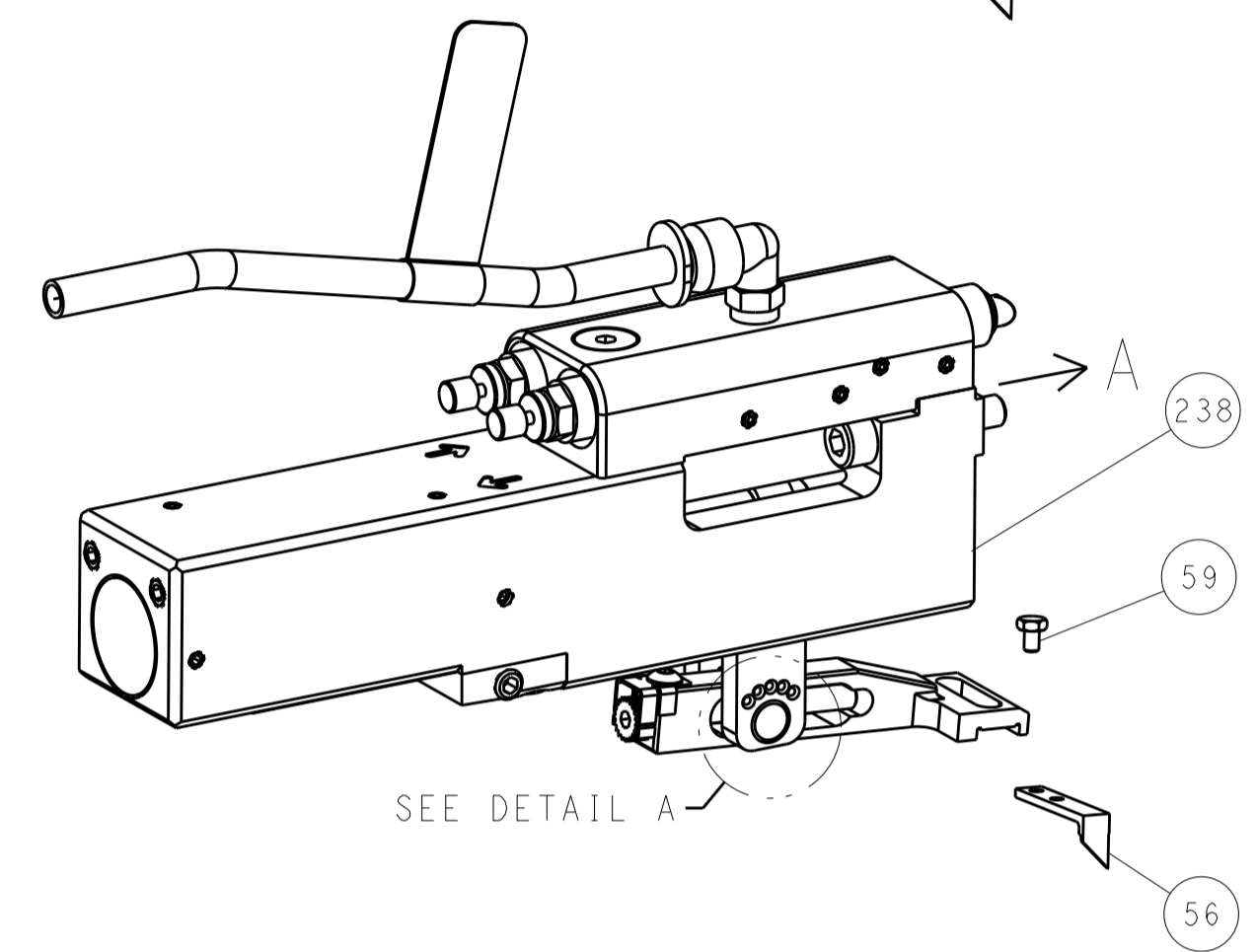
OWN	C. CHEN	25FEB2013	NAME	Ocean Side Feed Applicator	
CHK	S. XI	25FEB2013	SIZE	CAGE CODE	DRAWING NO
APPV	J. CRUZ	25FEB2013	SCALE	1:2	SHEET 1 OF 4
Customer Accessible Production Drawing			REV	B	

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

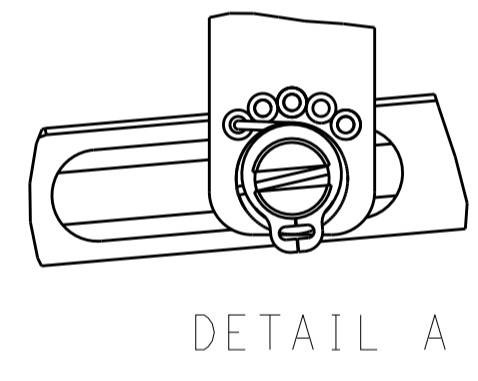
FEED TYPE MECHANICAL



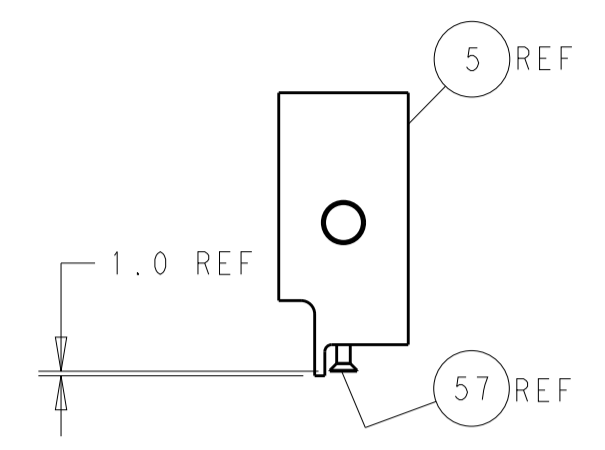
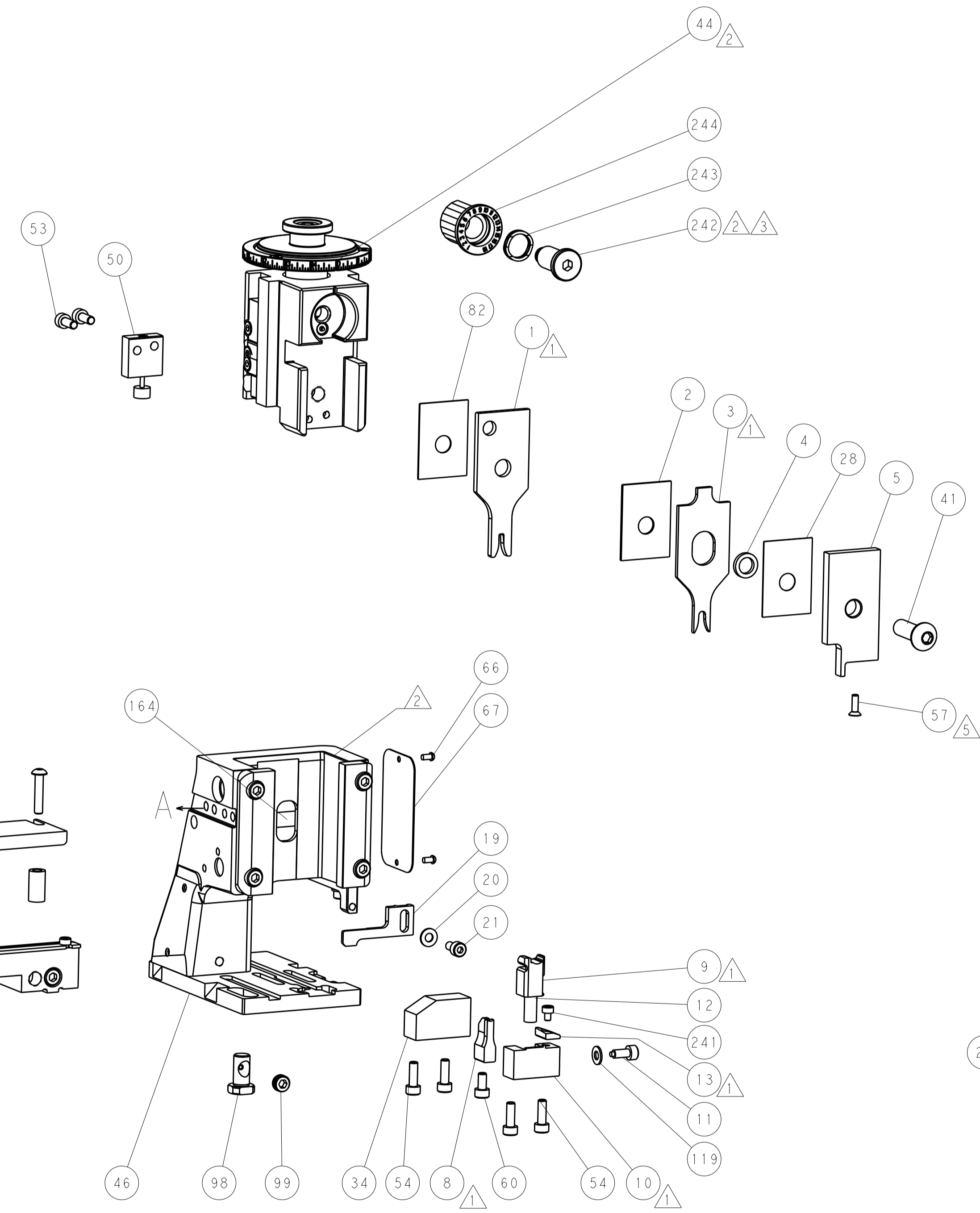
PNEUMATIC



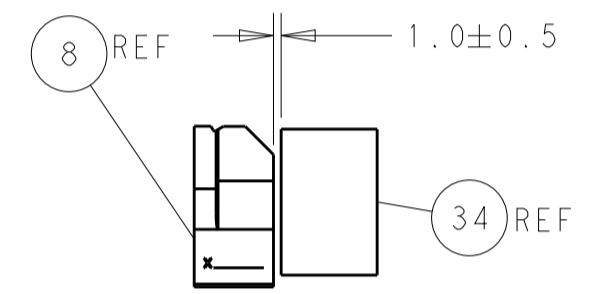
FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



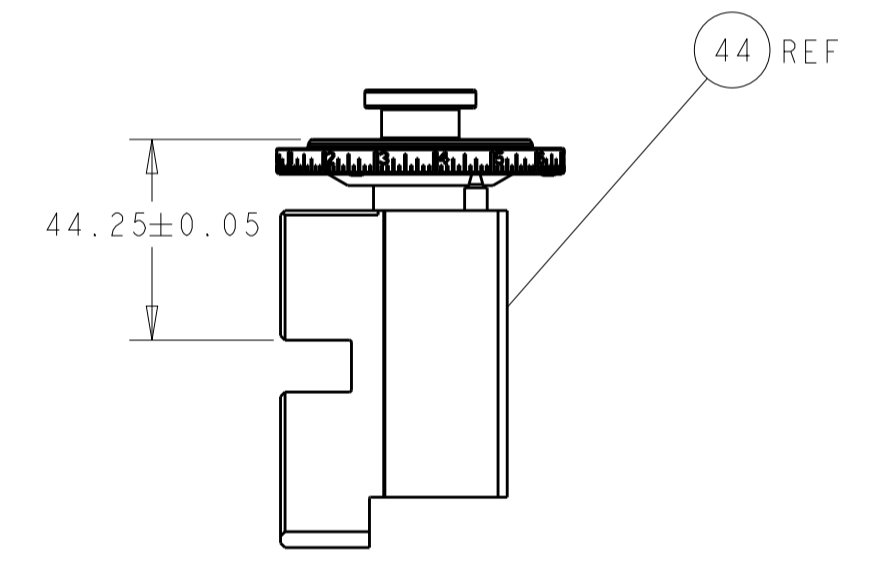
CAM POSITIONS



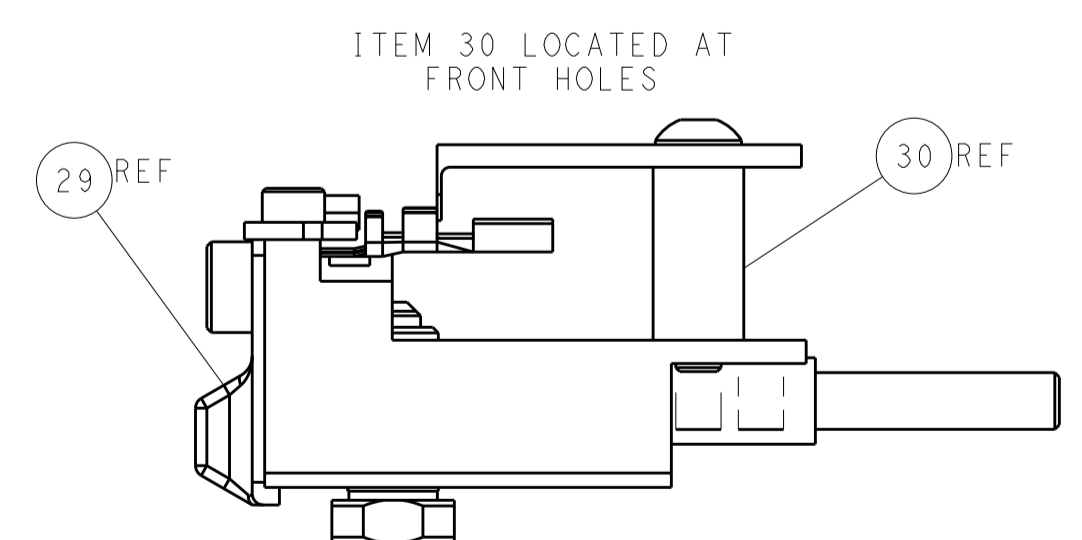
SHEAR DEPRESSOR DETAIL



TERMINAL SUPPORT LOCATION



RAM SET-UP



FEED TRACK POSITION GUIDE BY WIRE BARREL

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

<small>THE INFORMATION CONTAINED HEREON IS UNCLASSIFIED EXCEPT WHERE SHOWN OTHERWISE. IT IS THE PROPERTY OF TYCO ELECTRONICS CORPORATION AND IS LOANED TO YOUR ORGANIZATION UNDER THE PROVISIONS OF A LICENSE. IT IS TO BE CONTROLLED AND NOT REPRODUCED OR DISSEMINATED OUTSIDE YOUR ORGANIZATION UNLESS BY CONTACT WITH THE ISSUING OFFICE.</small>		DWN: C.CHEN 25FEB2013 CHK: S.XI 25FEB2013 APVD: J.CRUZ 25FEB2013	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 PRODUCT SPEC: APPLICATION SPEC: SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2151881	RESTRICTED TO: SCALE: 1:2 SHEET: 2 of 4 REV: B
MATERIAL: FINISH:		WEIGHT: Customer Accessible Production Drawing	SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2151881-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2151881-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151881-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.29 mm [.090]	F
INSUL	3.68 mm [.145]	O
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: .070 RECEPTACLE ECONOSEAL			
WIRE STRIP LENGTH 4.00-4.50 mm [.157-.177 IN]		TERMINAL INSULATION DIAMETER RANGE Ø1.85-2.70 mm [.073-.106 IN]	
TERMINAL APPLICATION SPECIFICATION	114-3040	-	-

TERMINALS APPLIED				
TE TERMINAL	TE TERMINAL	TE SEAL	TE SEAL	SEAL INSULATION DIAMETER RANGE
345806-1		347874-1		1.6-2.4 mm
175104-2		347875-1		2.7 mm MAX
344113-1		172888-2	1-172888-3	2.0-2.6 mm

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
2.00mm2	1.70 +/- 0.05 [.067 +/- .002]	4.2
1.50mm2	1.50 +/- 0.05 [.059 +/- .002]	6.3
1.00mm2	1.32 +/- 0.05 [.052 +/- .002]	8.4
0.75mm2	1.22 +/- 0.05 [.048 +/- .002]	9.4

- 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.

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

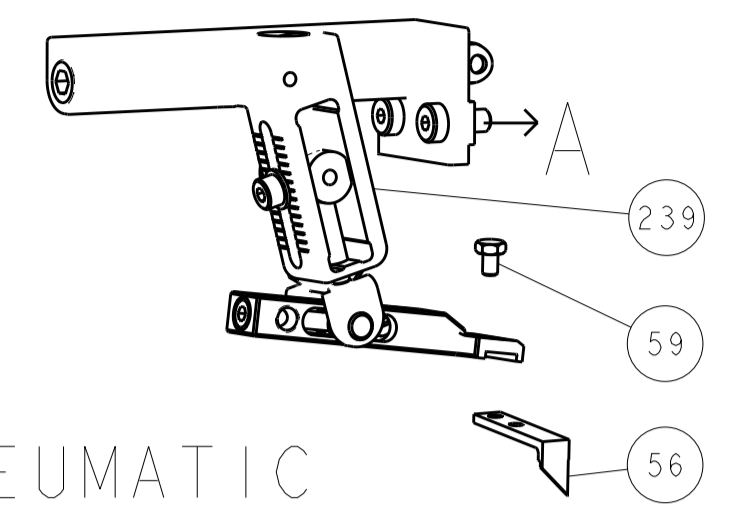
LOC	DIST	REVISIONS			
A	66	REV	DATE	BY	APPD
		-	SEE SHEET 1	-	-

-	1	1	2119082-7	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
3	-	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	1-18028-2	WASHER, FLAT, REG M4	119
-	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
5	-	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	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	1752356-3	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	1320928-2	STRIP GUIDE	24
-	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
-	1	1	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	1333205-9	ANVIL, COMBINATION	8
-	-	-	-	-	7
-	-	-	-	-	6
-	1	1	2119781-1	DEPRESSOR, SHEAR	5
-	1	1	2-238011-2	BLOCK, CRIMPER SPACER	4
1	1	1	3-2119784-8	CRIMPER, INSULATION O PREMIUM	3
-	1	1	455888-9	SPACER, CRIMPER	2
1	1	1	3-456406-3	CRIMPER, WIRE PREMIUM	1

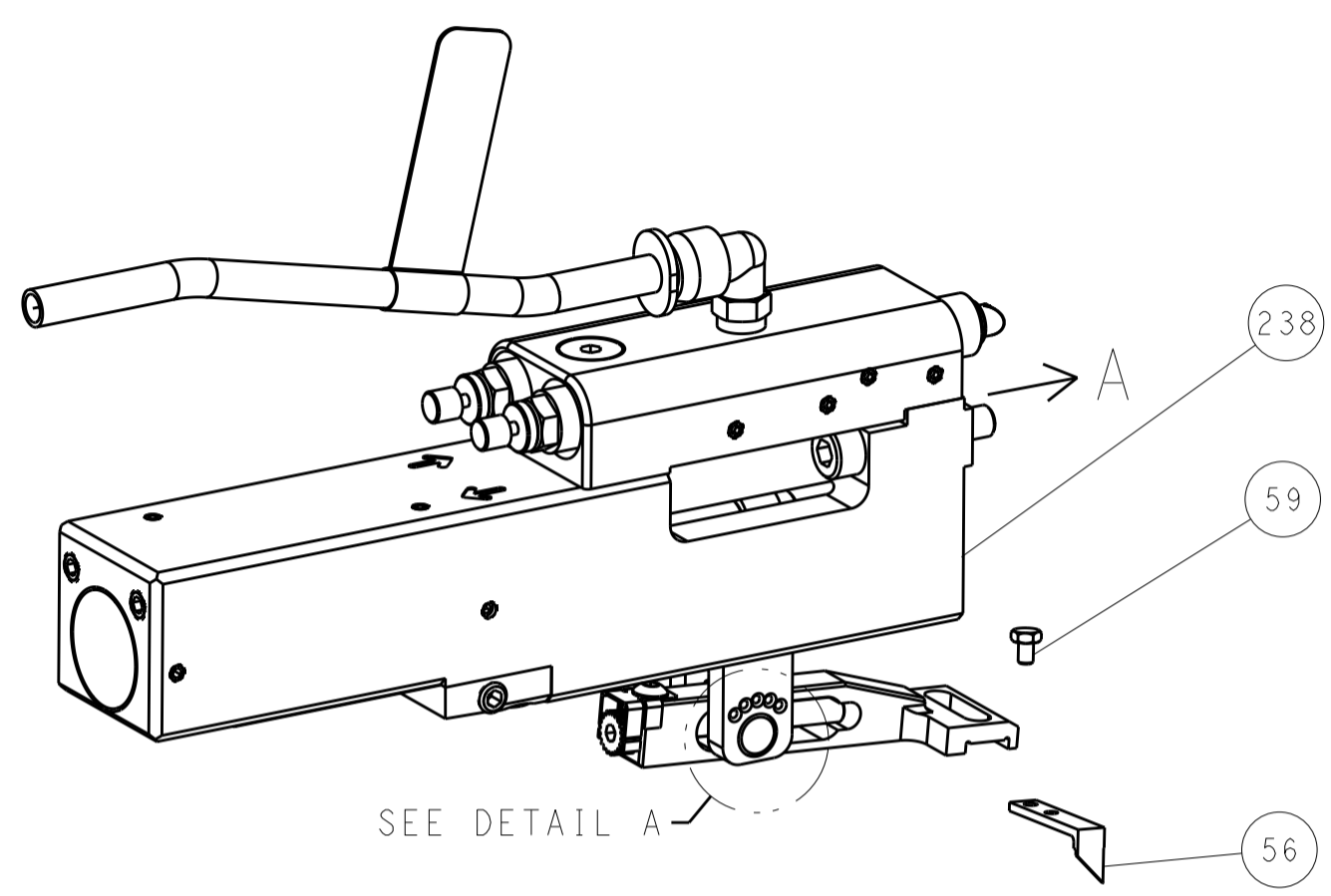
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG: C.CHEN 25FEB2013		REV: S.XI 25FEB2013		NAME: Ocean Side Feed Applicator	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	APVD: J. CRUZ 25FEB2013	PRODUCT SPEC	SIZE: A1	CAGE CODE: 00779
	ANGLES	FINISH	WEIGHT	SCALE: 1:2	SHEET: 3 OF 4	REV: B	Customer Accessible Production Drawing		

LOC	DIST	REV	DATE	BY	APPV
A	66				

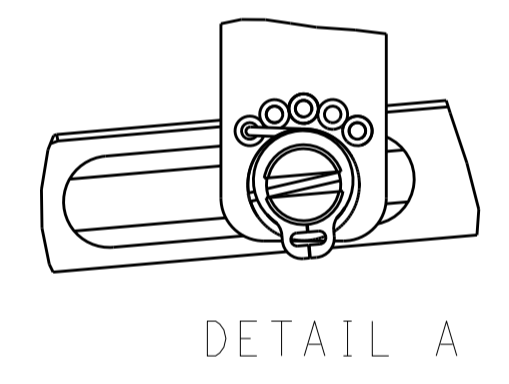
FEED TYPE MECHANICAL



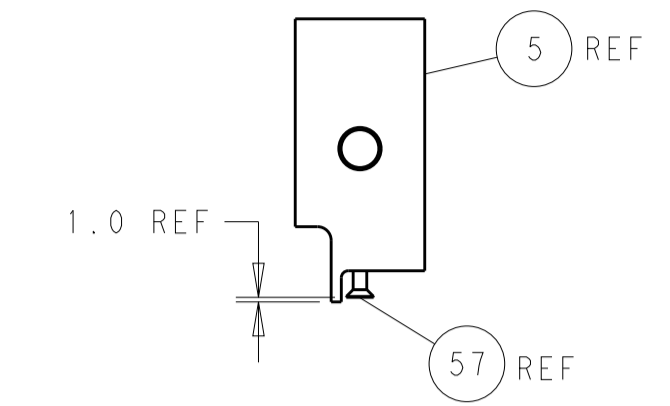
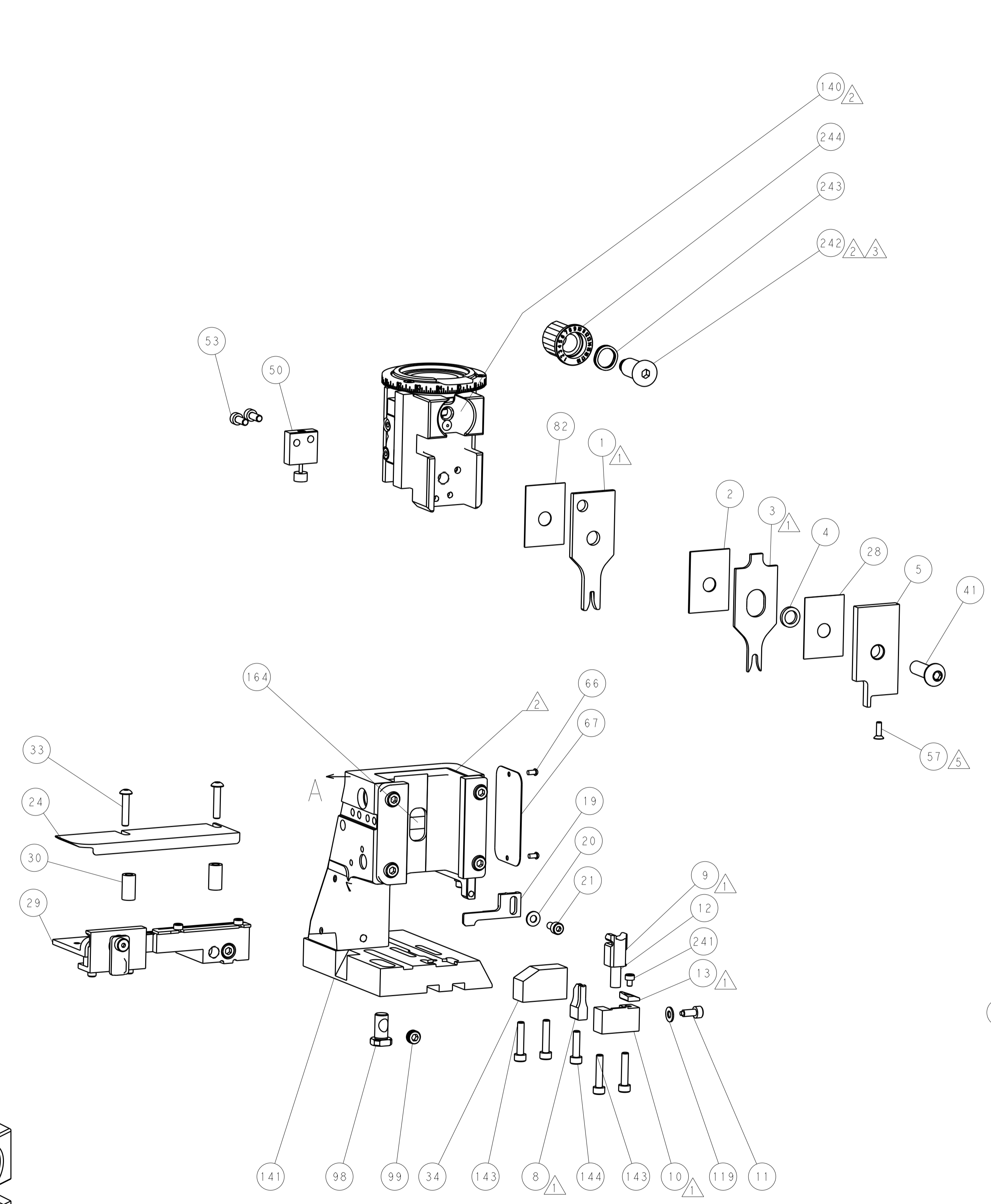
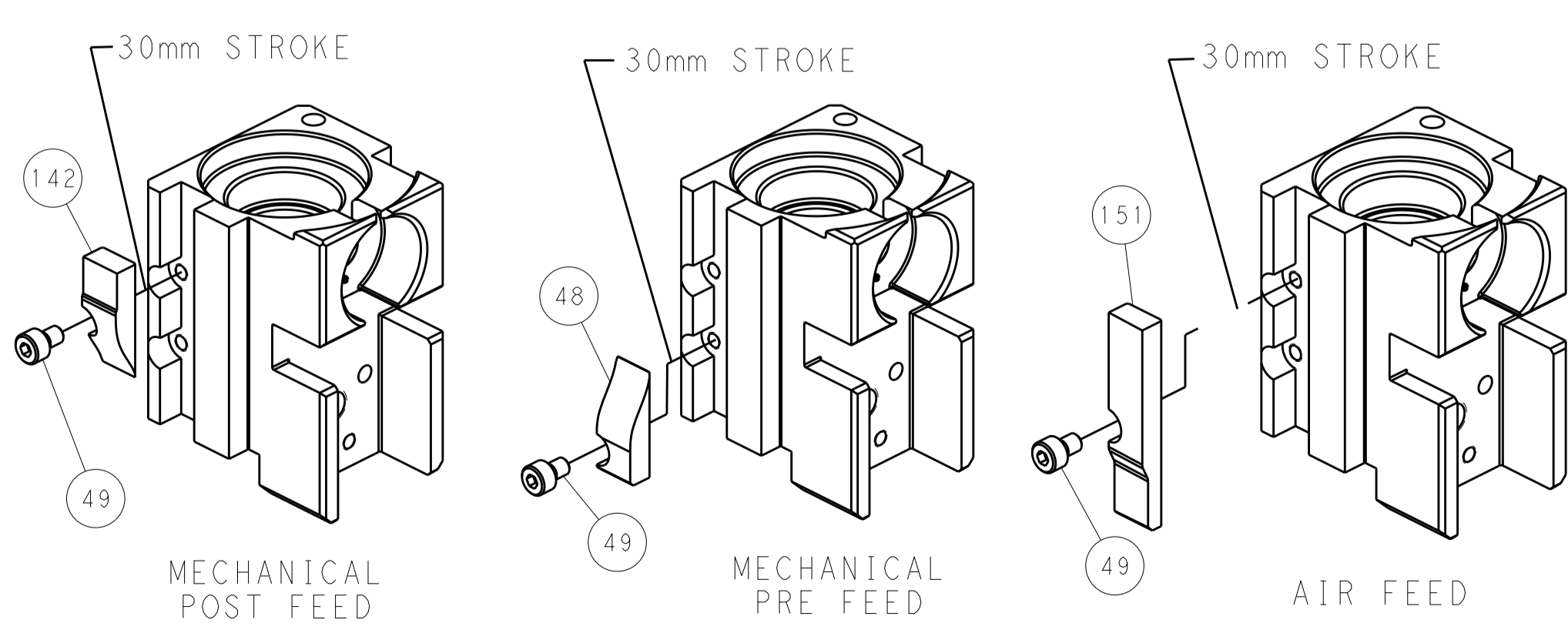
PNEUMATIC



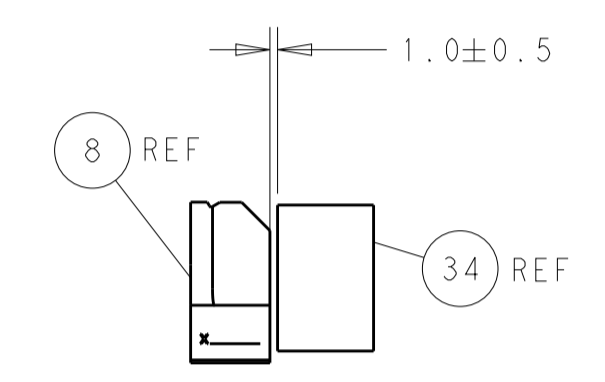
FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



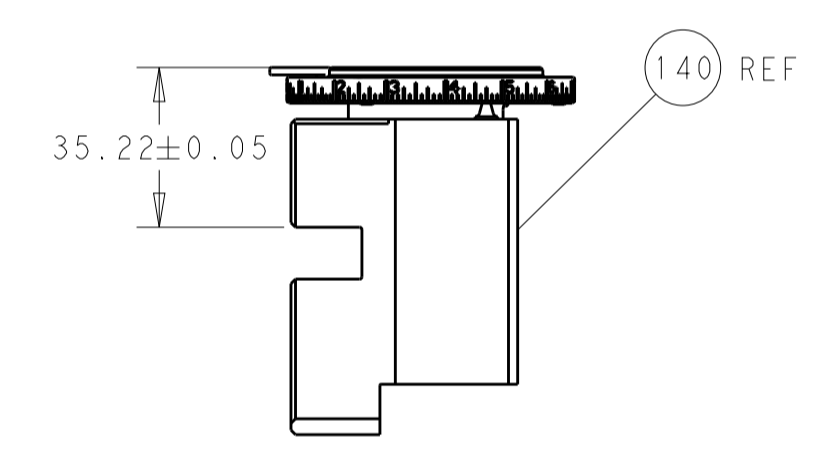
CAM POSITIONS



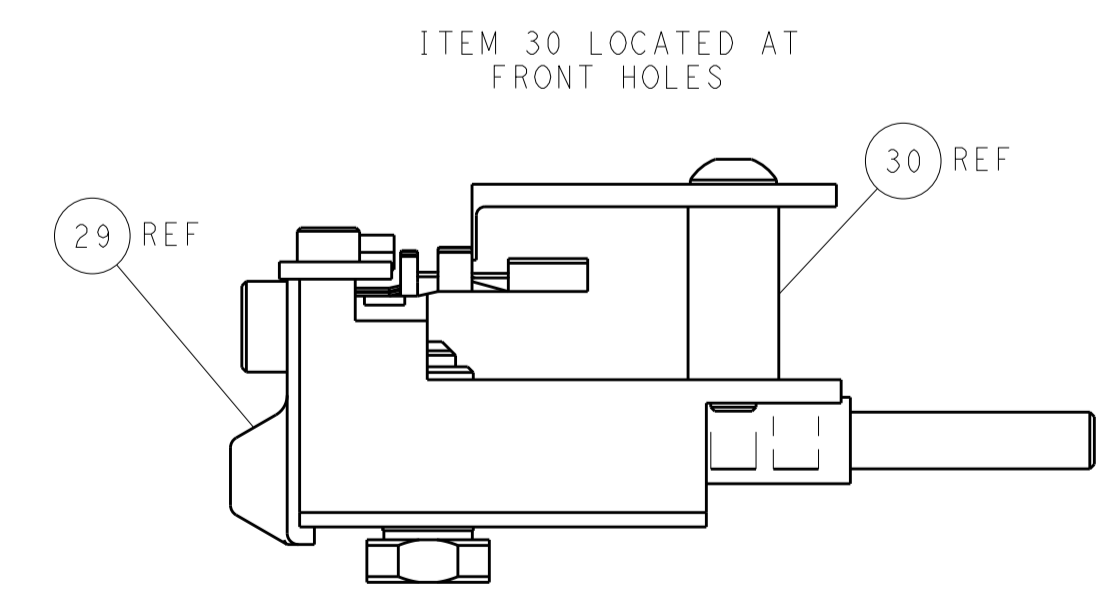
SHEAR DEPRESSOR DETAIL



TERMINAL SUPPORT LOCATION



RAM SET-UP



FEED TRACK POSITION GUIDE BY WIRE BARREL

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. RELEASED FOR PUBLICATION. IT IS THE PROPERTY OF TYCO ELECTRONICS CORPORATION. IT IS TO BE USED ONLY FOR THE PURPOSES AND LIMITATIONS SPECIFIED HEREIN. SHOULD BE CONTACTED FOR THE LATEST REVISION.</small>		DWN: C.CHEN 25FEB2013 CHK: S.XI 25FEB2013 APVD: J.CRUZ 25FEB2013	NAME: TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± MATERIAL: - FINISH: -	PRODUCT SPEC: - APPLICATION SPEC: - WEIGHT: - SCALE: 1:2	SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2151881	RESTRICTED TO: - SHEET: 4 OF 4 REV: B