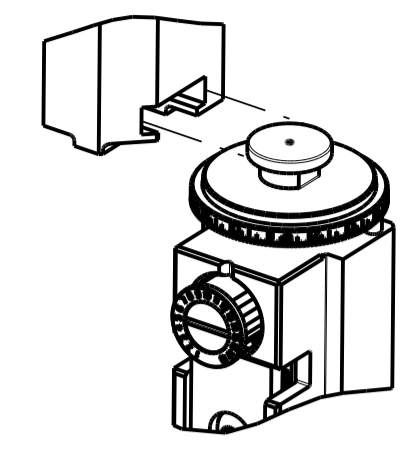


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151616-1	G	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2151616-2	G	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
5-2151616-1	G	SEAL STRIPPER CRIMPER TERMINATING UNIT	MECHANICAL
5-2151616-2	G	SEAL STRIPPER CRIMPER TERMINATING UNIT	PNEUMATIC
7-2151616-1	G	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2151616-2	G	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2151616-7	D	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.40 mm [.055]	F
INSUL	1.78 mm [.070]	F

APPLICATOR INSTRUCTIONS 408-35042

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: PLUG CONTACT, CRIMP SNAP, 20-24 AWG, MICRO MATE-N-LOK			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
2.90-3.53 mm [.114-.139 IN]		Ø0.89-1.52 mm [.035-.060 IN]	
TERMINAL APPLICATION SPECIFICATION	114-13000		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
794608-1	794608-3	1-794608-0	1-794608-2
794608-2	794608-4	1-794608-1	

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
20 AWG	0.89+/-0.05 [.035+/-0.002]	6.2
22 AWG	0.79+/-0.05 [.031+/-0.002]	7.1
24 AWG	0.69+/-0.05 [.027+/-0.002]	8.2

- RECOMMENDED SPARE PARTS
 - REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
 - APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 180. 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.
 - 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.

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

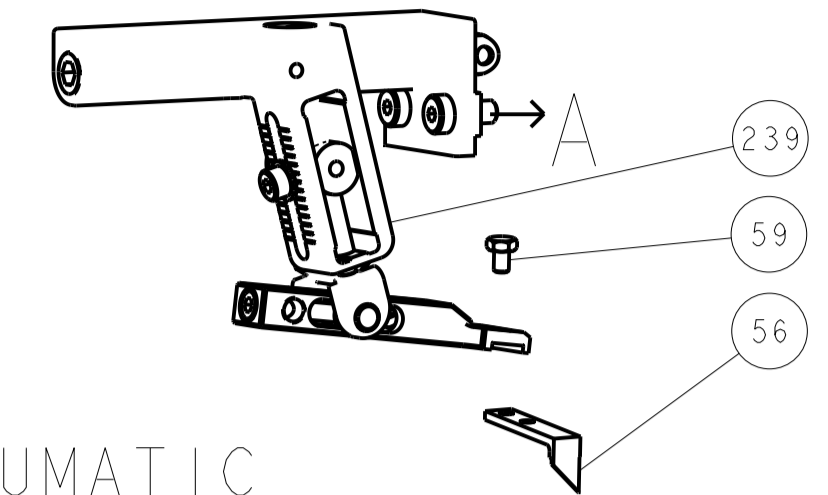
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		F	10JUL2019	FZ	TE	
		F1	29MAR2021	FJ	TE	
		G	13MAY2021	FJ	TE	

QTY	DESCRIPTION	DATE	BY	CHKD	APPVD
-	1803515-3	RAM ASSEMBLY, SF ATLANTIC			293
-	2-1803583-1	APPLICATOR BASIC ASSEMBLY, SF			292
-	2119791-5	DEPRESSOR, WIRE			286
-	2119641-1	FEED CAM, AIR FEED			248
-	2119082-8	CAM, SNAIL, INSULATION ADJUSTMENT			244
-	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST			243
-	2119083-1	RETAINER, INSULATION DIAL			242
-	7-18023-7	SCR, SKT HD CAP M3 X 4.0			241
-	2119580-1	MECHANICAL FEED ASSEMBLY			239
-	2844940-1	AIR FEED MODULE			238
-	1803237-8	STRIPPER, SIDE FEED			182
-	1-5018030-0	NUT, HEX, REG, RoHS, M3.5			181
-	1-1752354-6	STANDOFF, HOLD-DOWN			180
-	993111-1	PIN, SLOTTED SPRING 3.0 X 20.0			177
-	5-22280-0	SPRING, COMPRESSION			176
-	1752353-3	GUIDE PIN, HOLDDOWN			175
-	1901680-2	GUIDE PIN, HOLDDOWN			174
-	994970-2	COUNTER, MAGNETIC			164
-	2119955-1	ASSY, LUBRICATOR, SIDE FEED			113
-	2844908-1	SCREW, LOCKING			99
-	2844907-1	POST, LOCKING			98
-	455888-4	SPACER, CRIMPER			82
-	1803607-3	DOCUMENTATION PACKAGE			71
-	2119791-5	DEPRESSOR, WIRE			70
-	2119740-1	TAG, IDENTIFICATION			67
-	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188			66
-	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0			60
-	5-18022-5	SCR, HEX HD CAP, M4 X 6.0			59
-	1338685-1	PAWL, FEED			56
-	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0			54
-	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0			53
-	1803382-6	HOLD DOWN, SPRING LOADED			50
-	18023-9	SCR, SKT HD CAP M4 X 6.0			49
-	2119652-1	FEED CAM, PRE FEED			48
-	2119653-1	FEED CAM, POST FEED			47
-	1803583-9	APPLICATOR BASIC ASSEMBLY, SF			46
-	1803515-1	RAM ASSEMBLY, SF ATLANTIC			44
-	1803602-1	SCR, BHSC, RoHS (M8 X 25)			41
-	1752356-2	SUPPORT, TERMINAL			34
-	2079383-5	SCR, BHSC, RoHS (M4 X 20)			33
-	2-2844962-3	SPACER, CYLINDRICAL, STRIP GUIDE			30
-	2844992-1	ASSEMBLY, STRIP GUIDE			29
-	1320928-2	STRIP GUIDE			24
-	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0			21
-	1-18028-2	WASHER, FLAT, REG M4			20
-	2119533-1	STRIPPER, SIDE FEED			19
-	2119806-1	INSERT, SHEAR			13
-	3-22280-3	SPRING, COMPRESSION			12
-	1-356885-4	STOP, SHEAR			11
-	2119805-1	SHEAR HOLDER, FRONT			10
-	1803095-6	FLOATING SHEAR, FRONT			9
-	1-1803250-9	ANVIL, COMBINATION			8
-	240641-7	SPACER			7
-	-	-			6
-	2119757-4	DEPRESSOR, SHEAR			5
-	2-238011-0	BLOCK, CRIMPER SPACER			4
-	1-2119582-2	CRIMPER, INSULATION F PREMIUM			3
-	455888-1	SPACER, CRIMPER			2
-	2-456402-4	CRIMPER, WIRE PREMIUM			1

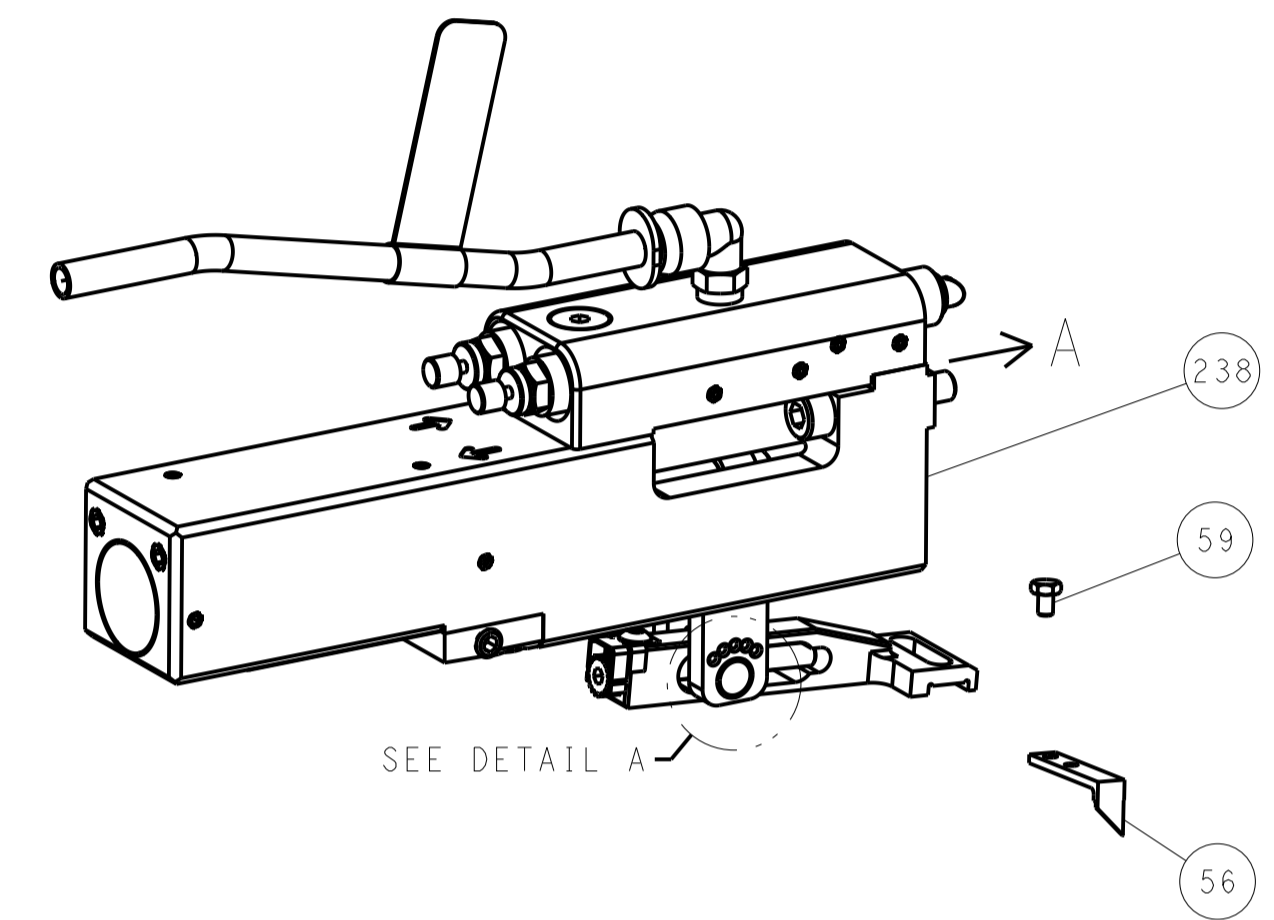
DIMENSIONS: mm 	TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH	DWN: HOFFNER 2/24/2012 CHK: T. ELBIN 2/27/2012 APPVD: T. ELBIN 2/27/2012	NAME: Ocean Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2151616 SCALE: 1:2 SHEET: 1 of 4 REV: G
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LOC	DIST	REV	DATE	BY	APP'D
A	66				

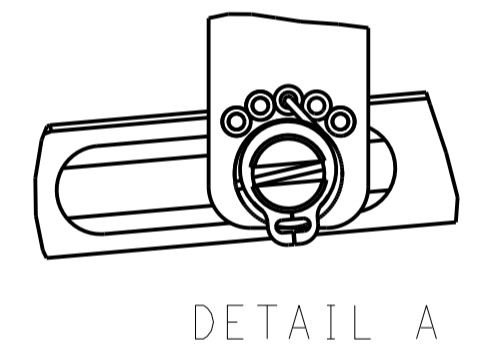
FEED TYPE MECHANICAL



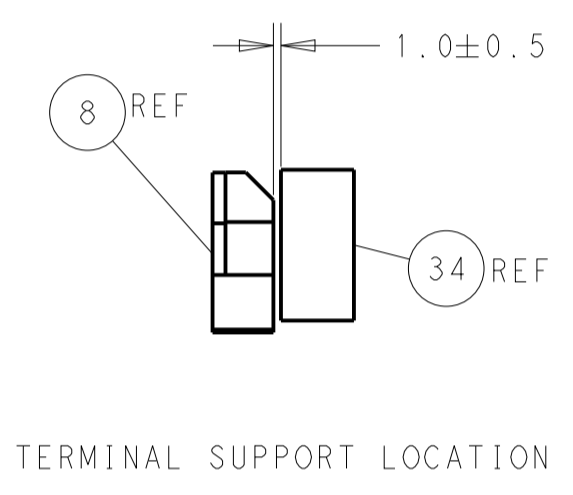
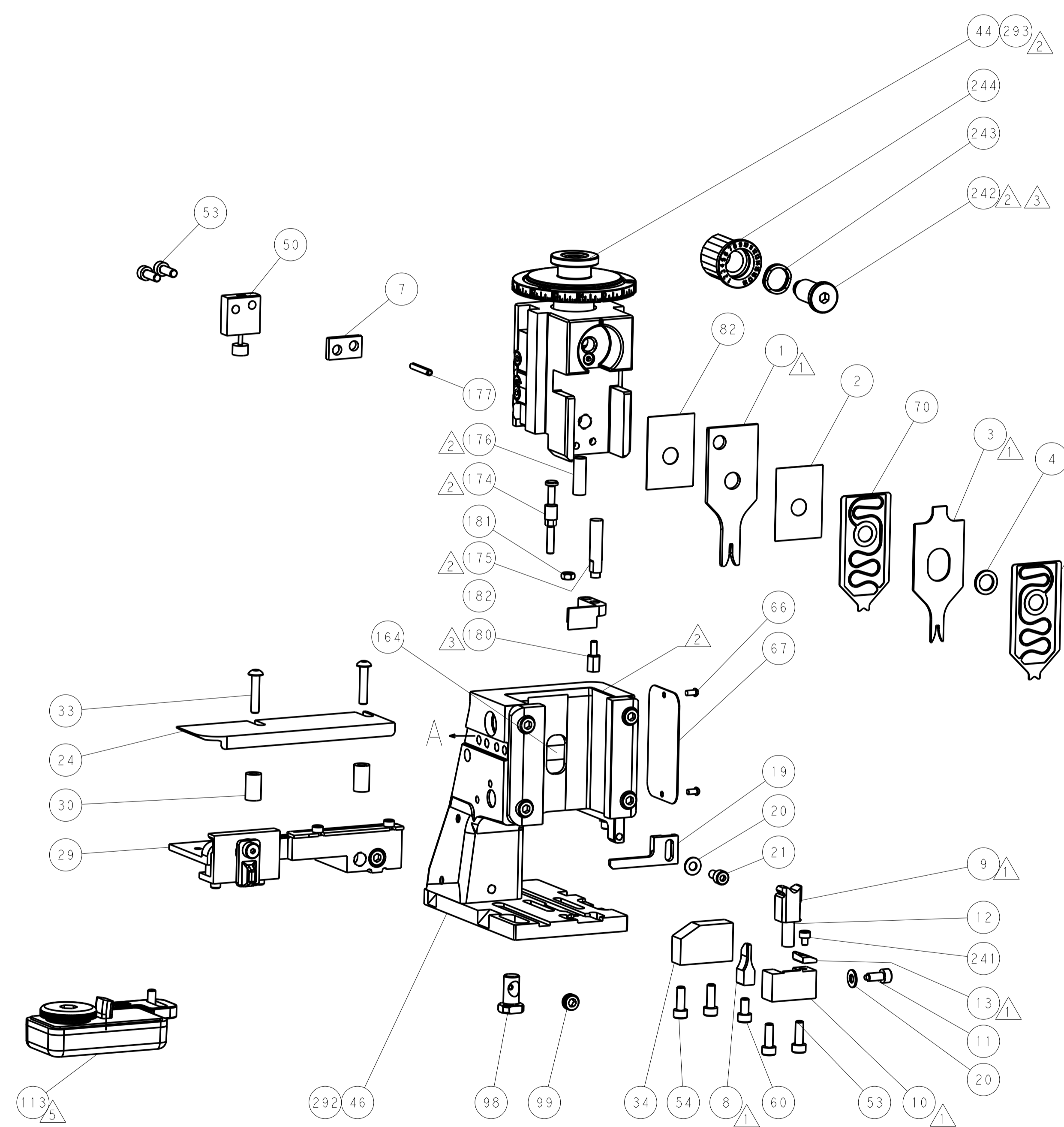
PNEUMATIC



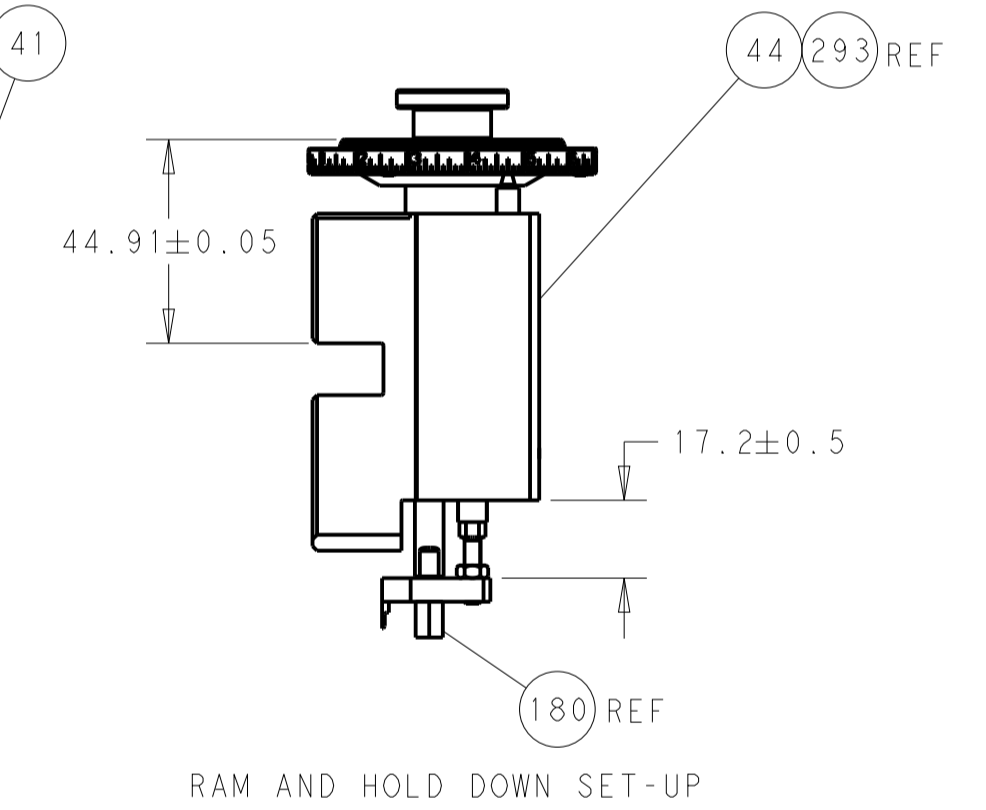
FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



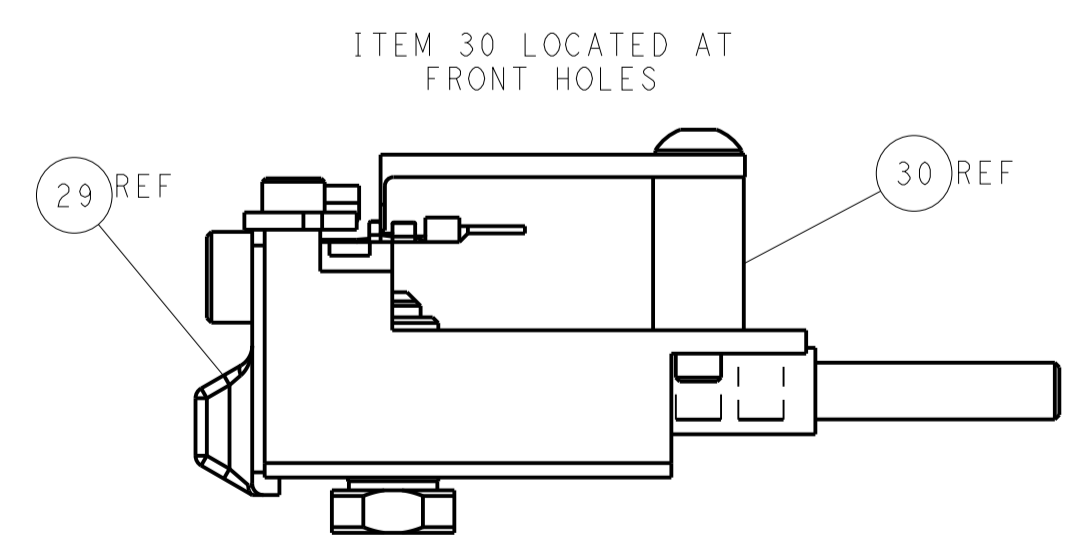
DETAIL A



TERMINAL SUPPORT LOCATION

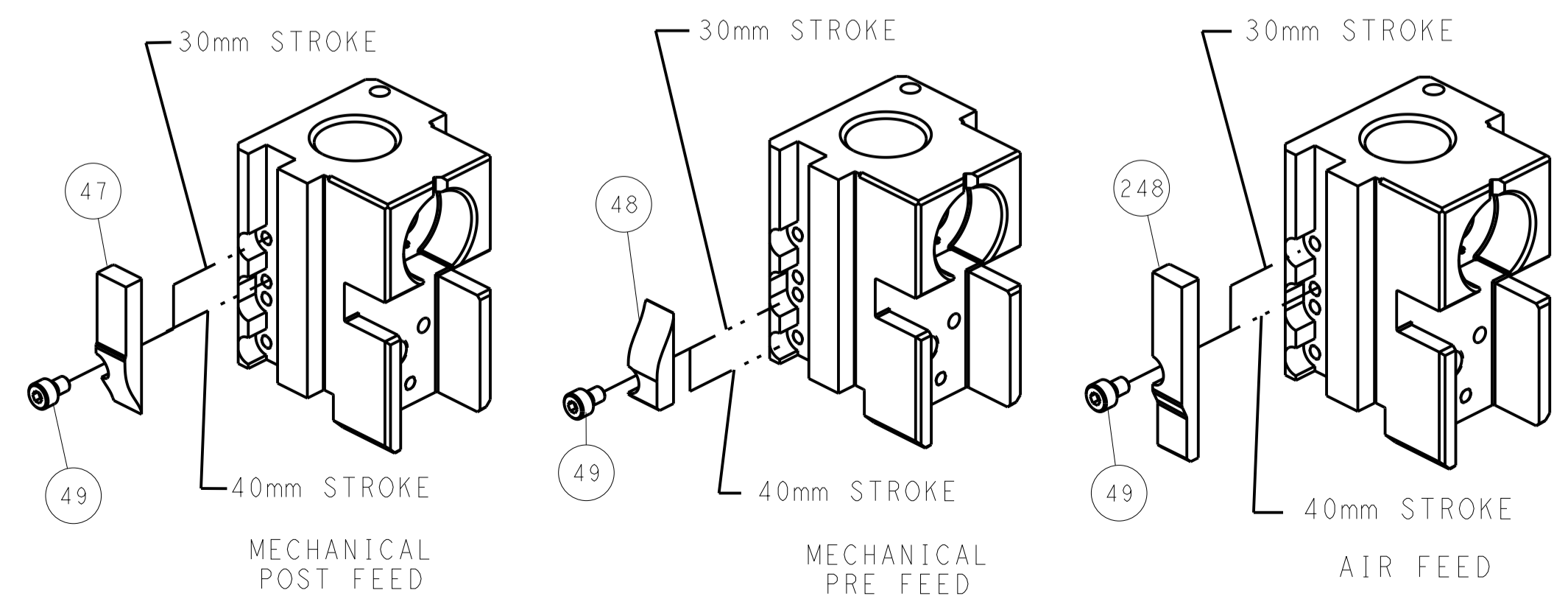


RAM AND HOLD DOWN SET-UP



FEED TRACK POSITION GUIDE BY INSULATION BARREL

CAM POSITIONS

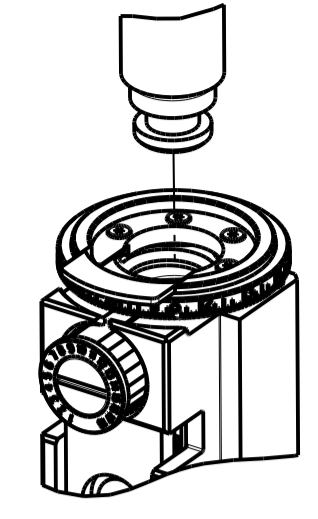


ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		DWN: HOFFNER 2/24/2012 CHK: T. ELBIN 2/27/2012 APVD: T. ELBIN 2/27/2012	NAME: Ocean Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2151616	RESTRICTED TO: G SCALE: 1:2 SHEET: 2 of 4 REV: G
MATERIAL: - FINISH: -		WEIGHT: - CUSTOMER ACCESSIBLE PRODUCTION DRAWING	TE Connectivity Harrisburg, PA 17105-3608	

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2151616-1	G	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2151616-2	G	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151616-7	D	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
 INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.40 mm [.055]	F
INSUL	1.78 mm [.070]	F

APPLICATOR INSTRUCTIONS
 408-35042

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: PLUG CONTACT, CRIMP SNAP, 20-24 AWG, MICRO MATE-N-LOK			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
2.90-3.53 mm [.114-.139 IN]		∅0.89-1.52 mm [.035-.060 IN]	
TERMINAL APPLICATION SPECIFICATION	114-13000	-	-
TERMINALS APPLIED ³			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
794608-1	794608-3	1-794608-0	1-794608-2
794608-2	794608-4	1-794608-1	

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
20 AWG	0.89 +/- 0.05 [.035 +/- .002]	6.2
22 AWG	0.79 +/- 0.05 [.031 +/- .002]	7.1
24 AWG	0.69 +/- 0.05 [.027 +/- .002]	8.2

- 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.

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

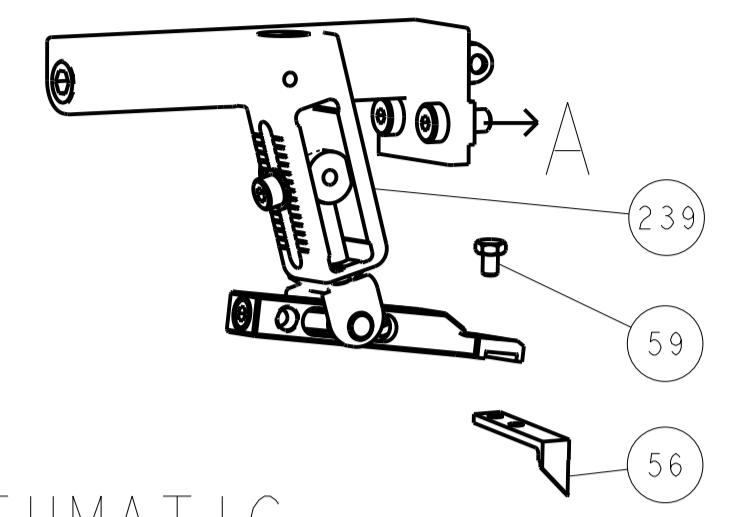
LOC	DIST	REV	DATE	BY	APPV
A	66	-	-	-	-

REV	DATE	BY	APPV	DESCRIPTION	ITEM NO
-	1	1	2119791-5	DEPRESSOR, WIRE	286
-	1	1	2119082-8	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
⁵	-	1	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113
-	1	1	2844908-1	SCREW, LOCKING	99
-	1	1	2844907-1	POST, LOCKING	98
-	1	1	455888-4	SPACER, CRIMPER	82
-	1	1	1803607-3	DOCUMENTATION PACKAGE	71
-	1	1	2119791-5	DEPRESSOR, WIRE	70
-	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	1752356-2	SUPPORT, TERMINAL	34
-	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	2-2844962-3	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29
-	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	1803095-6	FLOATING SHEAR, FRONT	9
¹	1	1	1-1803250-9	ANVIL, COMBINATION	8
-	1	1	240641-7	SPACER	7
-	-	-	-	-	6
-	1	1	2119757-4	DEPRESSOR, SHEAR	5
-	1	1	2-238011-0	BLOCK, CRIMPER SPACER	4
¹	1	1	1-2119582-2	CRIMPER, INSULATION F PREMIUM	3
-	1	1	455888-1	SPACER, CRIMPER	2
¹	1	1	2-456402-4	CRIMPER, WIRE PREMIUM	1
-77	-22	-21	PART NO	DESCRIPTION	ITEM NO

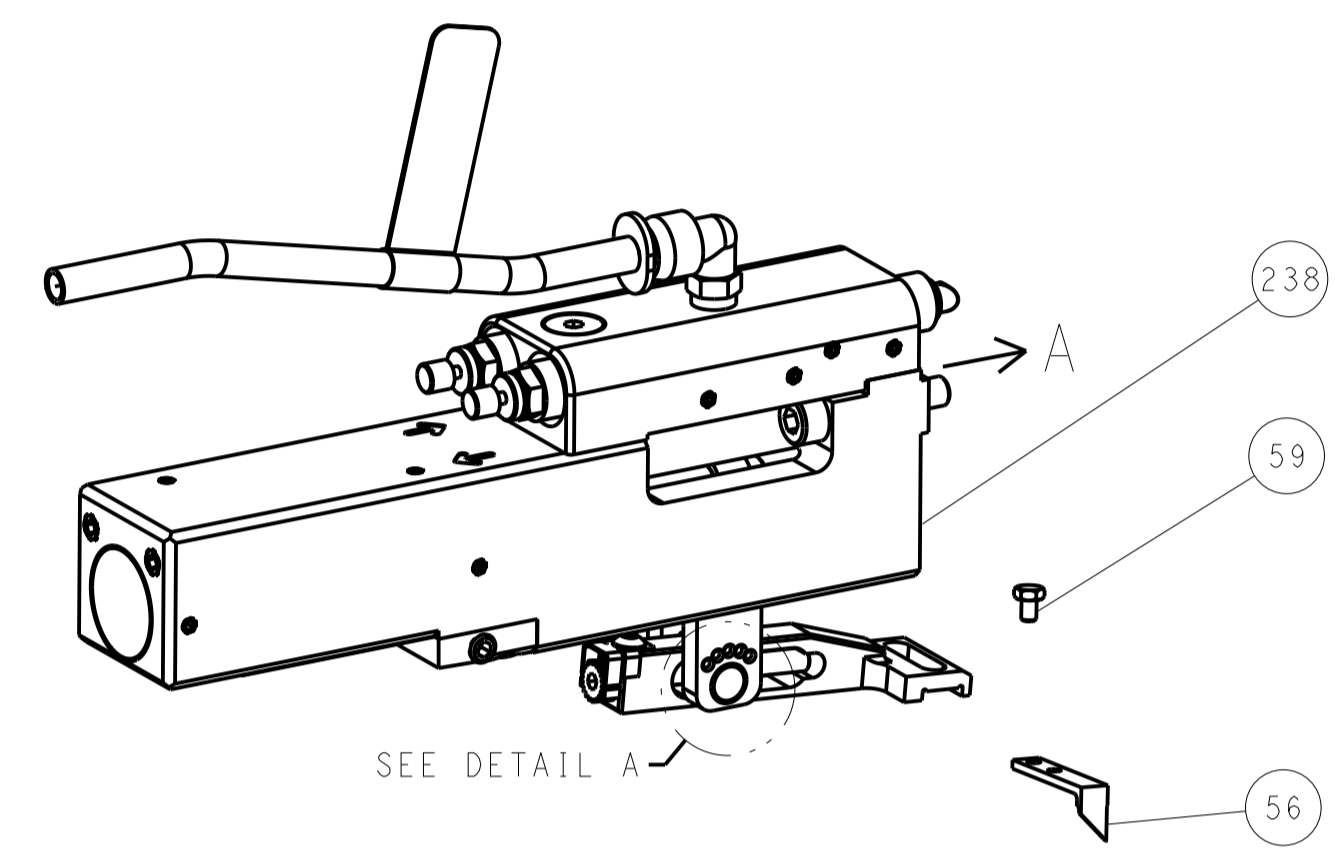
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG: 2/24/2012		CHK: 2/21/2012		APPV: 2/21/2012		NAME: T. ELBIN	
0 PLC	±	0.00	±	0.00	±	0.00	±	0.00	±	TE Connectivity Harrisburg, PA 17105-3608	
1 PLC	±	0.01	±	0.01	±	0.01	±	0.01	±	Ocean Side Feed Applicator	
2 PLC	±	0.02	±	0.02	±	0.02	±	0.02	±	SIZE: CAGE CODE: DRAWING NO: RESTRICTED TO	
3 PLC	±	0.03	±	0.03	±	0.03	±	0.03	±	A1 00779 C=2151616	
4 PLC	±	0.04	±	0.04	±	0.04	±	0.04	±	SCALE: 1:2 SHEET 3 OF 4 REV G	
ANGLES	±	0.01	±	0.01	±	0.01	±	0.01	±	CUSTOMER ACCESSIBLE PRODUCTION DRAWING	

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

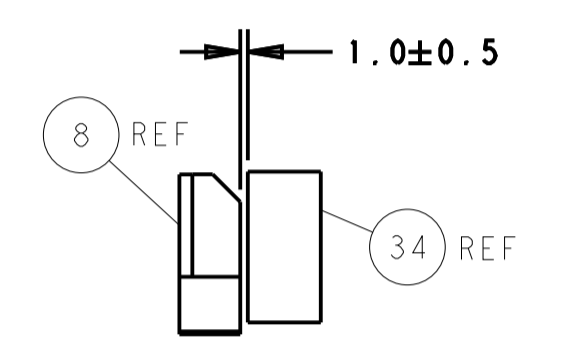
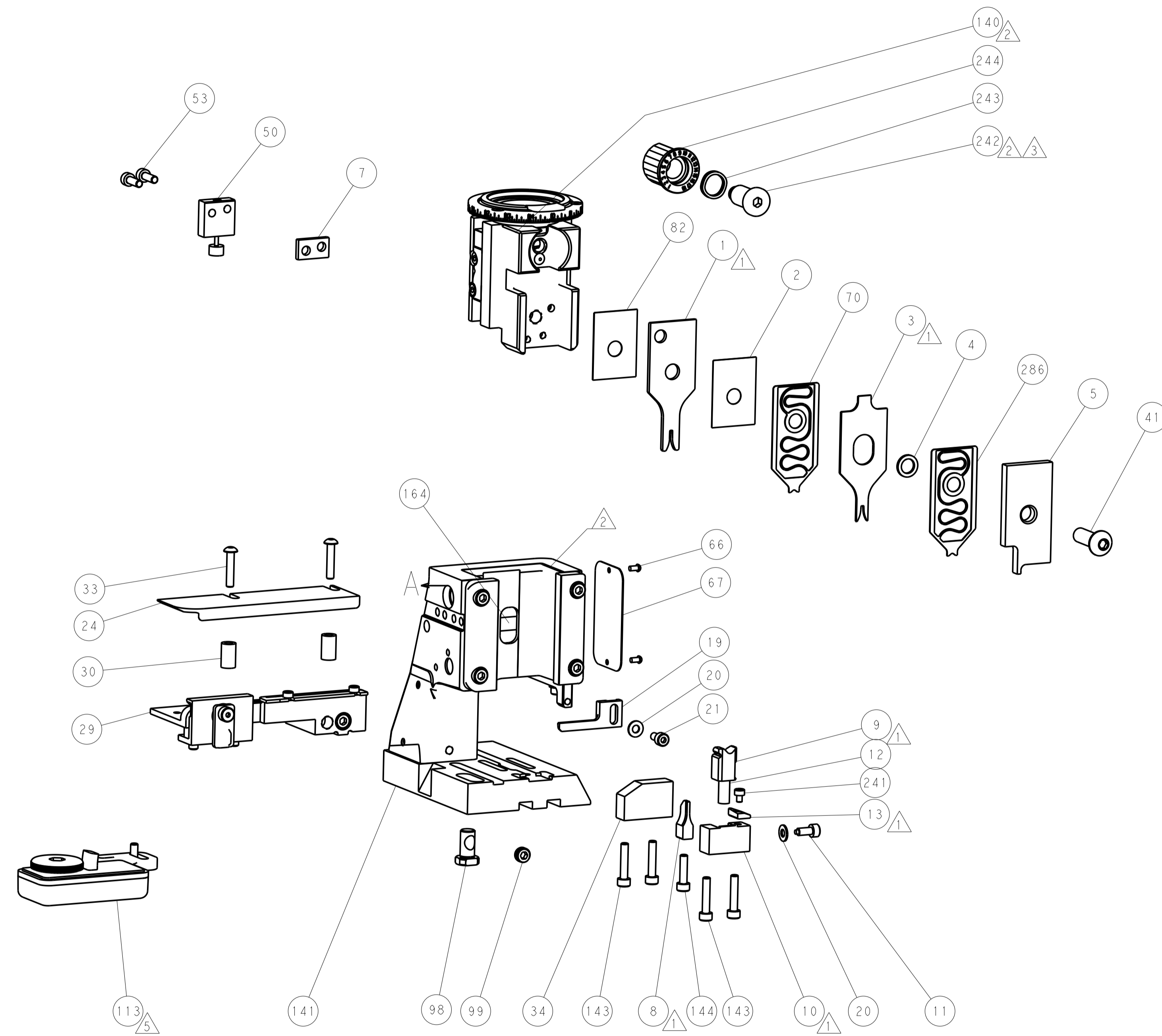
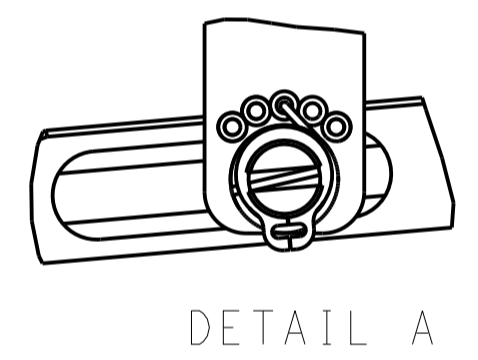
FEED TYPE MECHANICAL



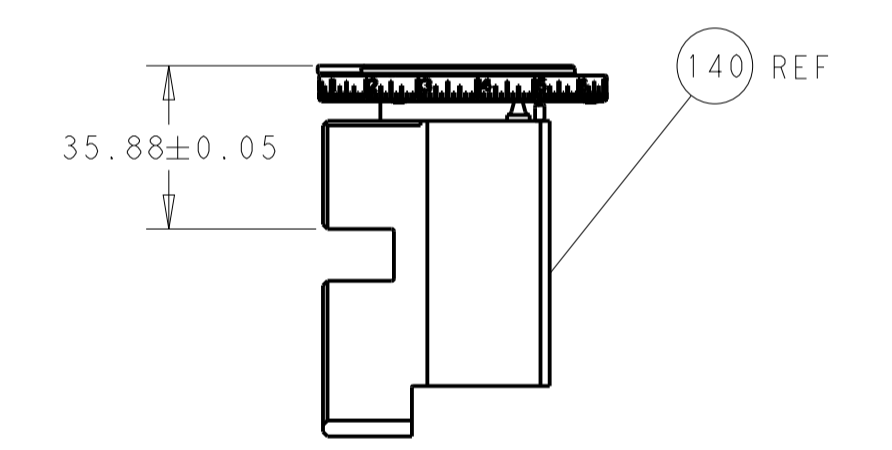
PNEUMATIC



FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)

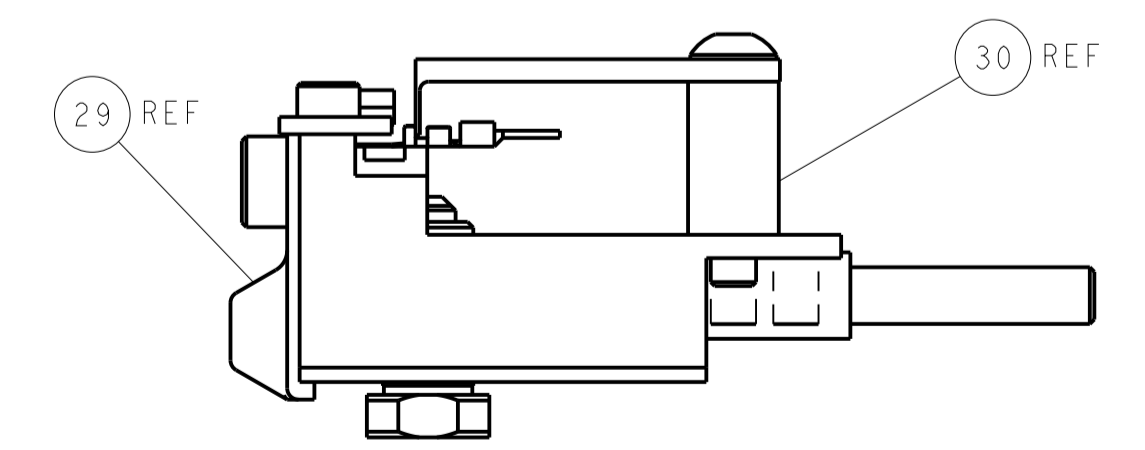


TERMINAL SUPPORT LOCATION



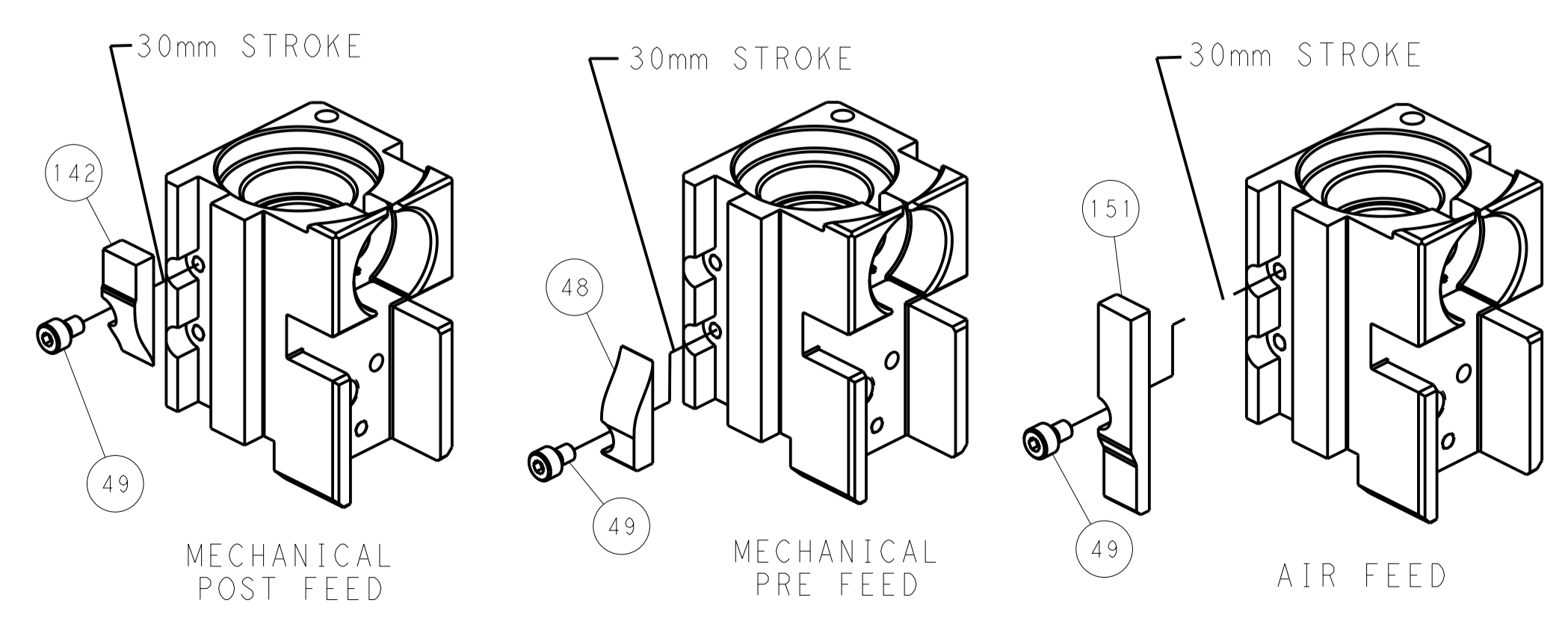
RAM SET-UP

ITEM 30 LOCATED AT FRONT HOLES



FEED TRACK POSITION GUIDE BY INSULATION BARREL

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:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN HOFFNER 2/24/2012		TE Connectivity	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	Harrisburg, PA 17105-3608	
MATERIAL:		FINISH:		APVD T. ELBIN 2/27/2012		NAME	
				PRODUCT SPEC		Ocean Side Feed Applier	
				APPLICATION SPEC		SIZE CAGE CODE DRAWING NO	
				WEIGHT		A 00779 C=2151616	
				CUSTOMER ACCESSIBLE PRODUCTION DRAWING		RESTRICTED TO	
				SCALE 1:2		SHEET 4 OF 4 REV G	