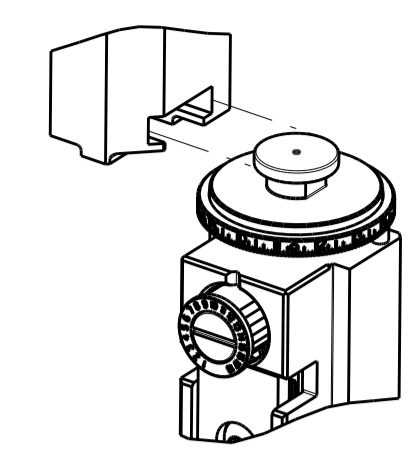


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151928-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2151928-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151928-1	B	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2151928-2	B	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2151928-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.40 mm [.055]	F
INSUL	3.43 mm [.135]	O

APPLICATOR INSTRUCTIONS 408-35042

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: MQS 1mm SOCKET CONTACT, SWS			
WIRE STRIP LENGTH		TERMINAL INSULATION DIAMETER RANGE	
3.45-3.75 mm [.136-.148 IN]		2.40-2.60mm [.094-.102 IN]	
TERMINAL APPLICATION SPECIFICATION	114-18231		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE SEAL	SEAL INSULATION DIAMETER RANGE
1670448-2		967067-1	1.4- 2.1mm

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.50mm2	1.01 +/- 0.03 [.040 +/- .001]	7.5
0.35mm2	0.92 +/- 0.03 [.036 +/- .001]	8.4

- 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 INSULATION CRIMP HEIGHT 2.8mm MAX, CRIMP WIDTH 3.6mm MAX.
7. 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)

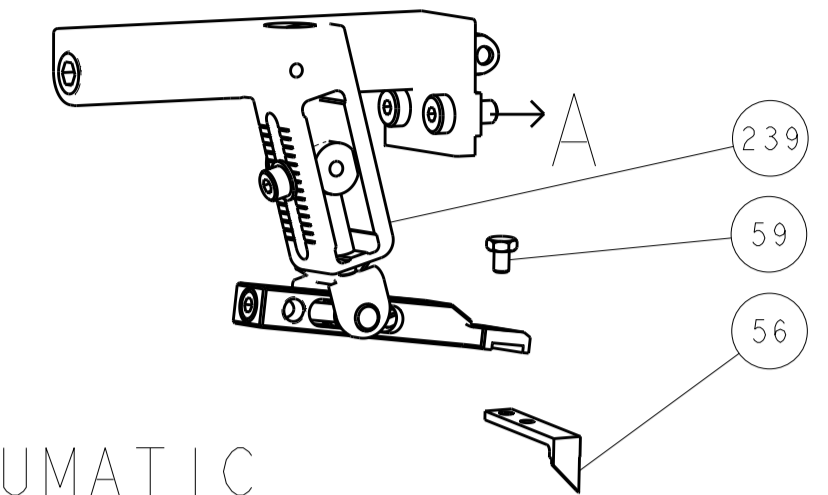
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		B	ECR-19-013243	23AUG2019	FZ TE

-	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	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	53	
-	1	1	1	1	5018030-1	NUT, HEX, REG, RoHS, M3	52	
-	1	1	1	1	811242-5	BUMPER, HOLD DOWN	51	
-	1	1	1	1	690753-2	SPACER, TONKER	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	2844992-1	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	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	1	2	2	1	1-1633128-3	ANVIL, COMBINATION .055	8	
-	1	1	1	1	4-240641-2	SPACER	7	
-	-	-	-	-	-	-	6	
-	1	1	1	1	2119781-1	DEPRESSOR, SHEAR	5	
-	1	1	1	1	3-238011-5	BLOCK, CRIMPER SPACER	4	
1	1	2	2	1	1-1633996-4	CRIMPER, INSULATION SPECIAL	3	
-	1	1	1	1	455888-6	SPACER, CRIMPER	2	
1	1	2	2	1	3-456402-5	CRIMPER, WIRE PREMIUM	1	
-	77	72	71	2	-1	PART NO	DESCRIPTION	ITEM NO

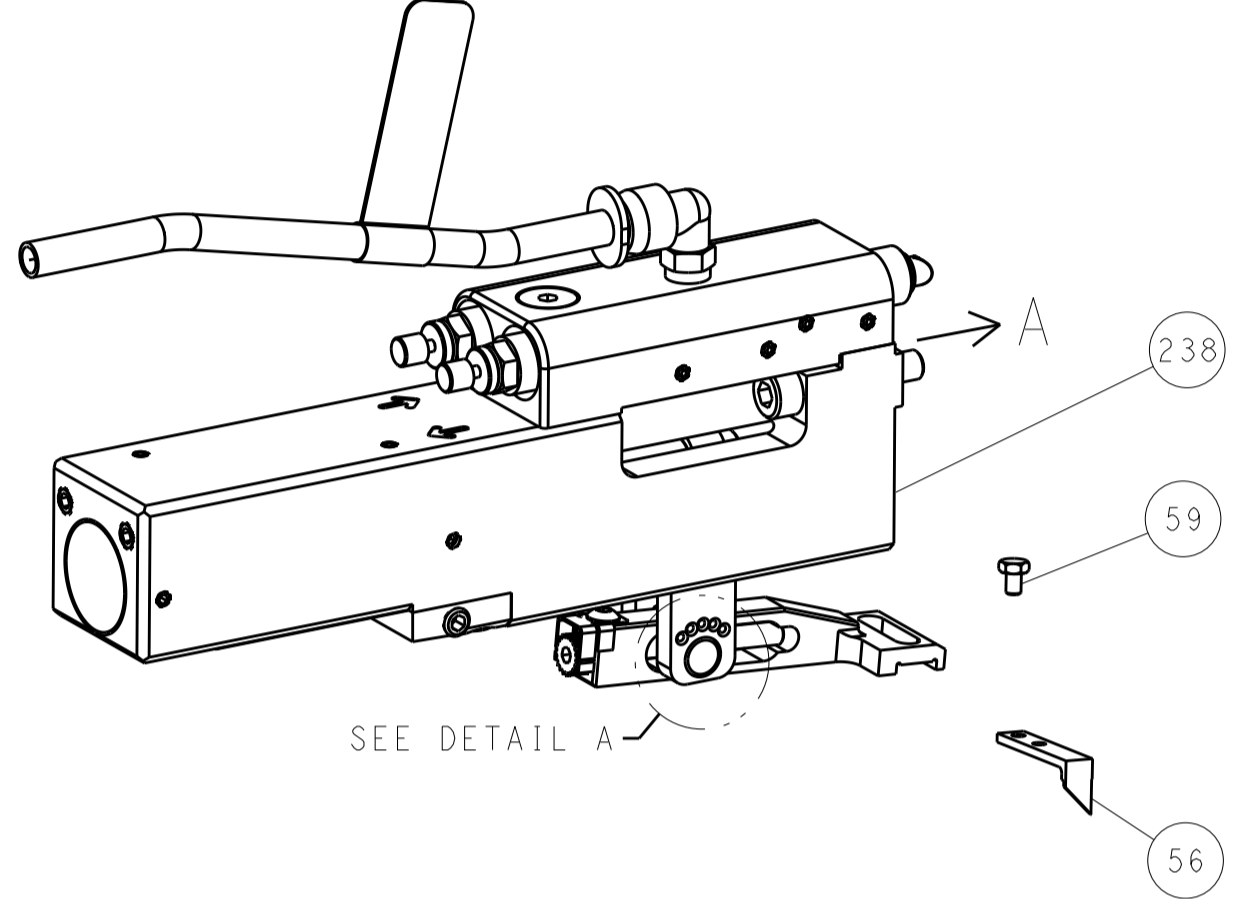
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mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES ±	FINISH			Customer Accessible Production Drawing	SCALE 1:2
APPLICATOR DATA		TERMINAL DATA		WIRE STRIP LENGTH		TERMINAL INSULATION DIAMETER RANGE		TERMINAL APPLICATION SPECIFICATION		TERMINALS APPLIED	
APPLICATOR INSTRUCTIONS 408-35042		114-18231		3.45-3.75 mm [.136-.148 IN]		2.40-2.60mm [.094-.102 IN]		114-18231		1670448-2, 967067-1, 1.4- 2.1mm	

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

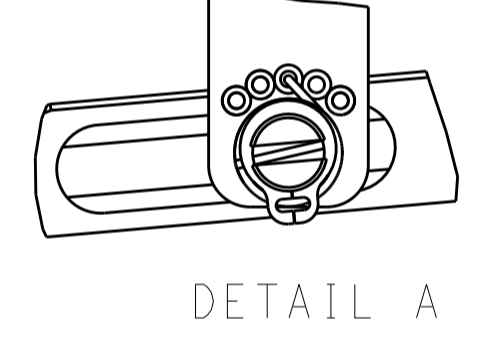
FEED TYPE MECHANICAL



PNEUMATIC

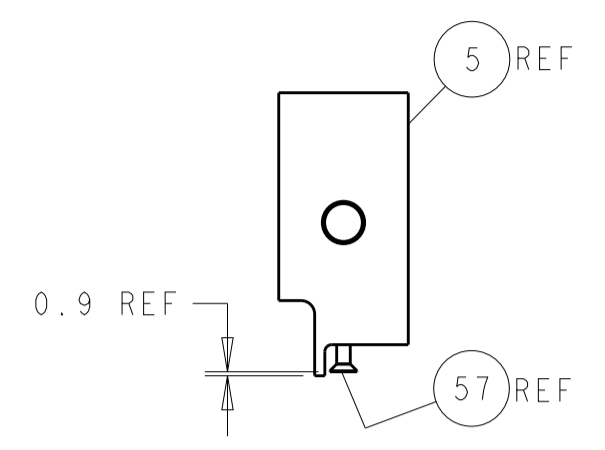
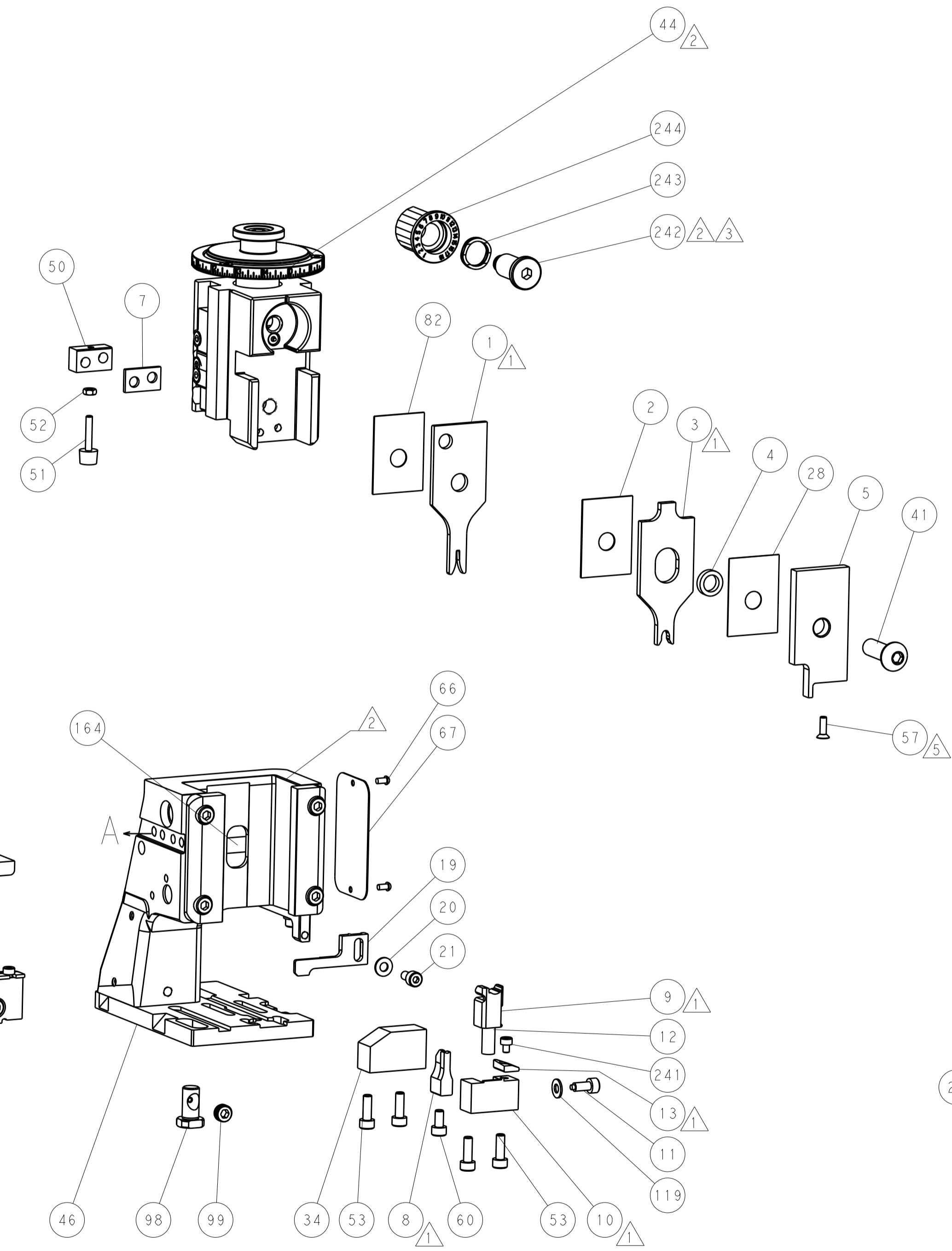
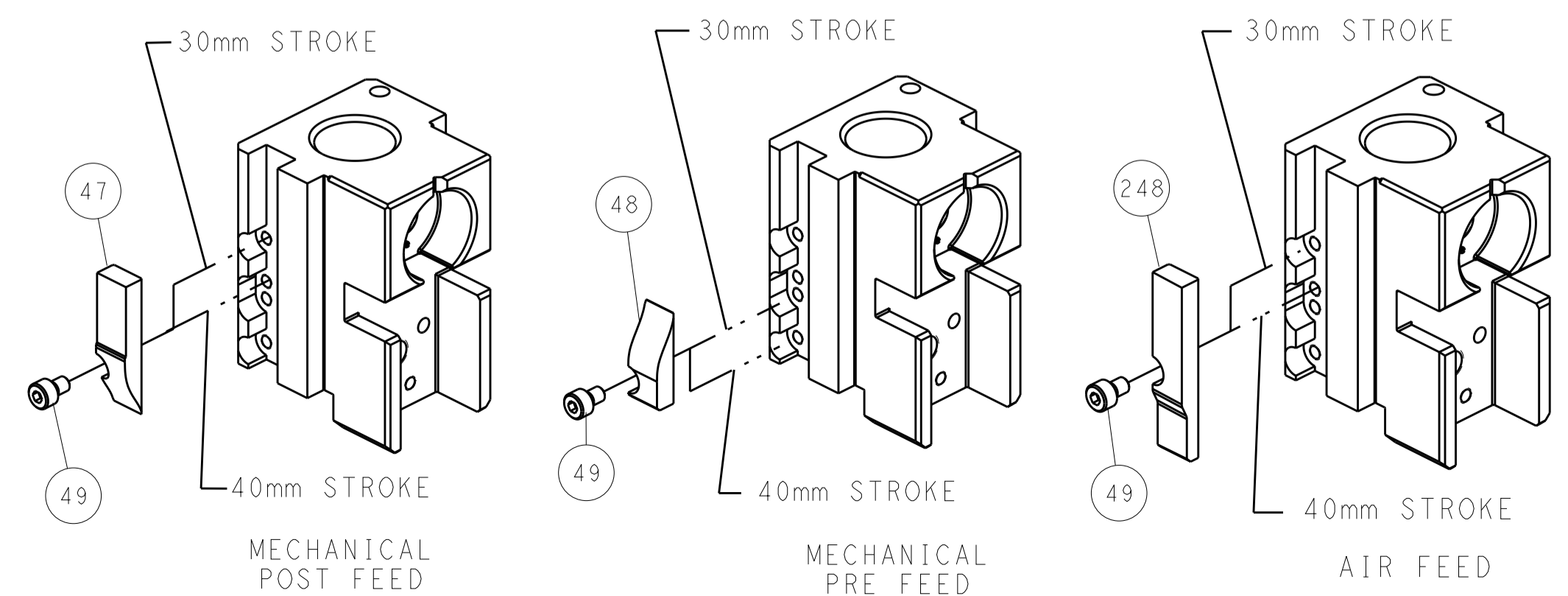


FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)

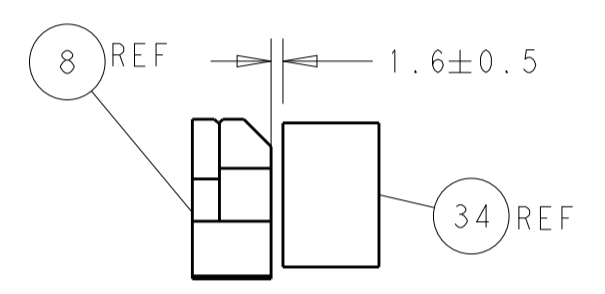


DETAIL A

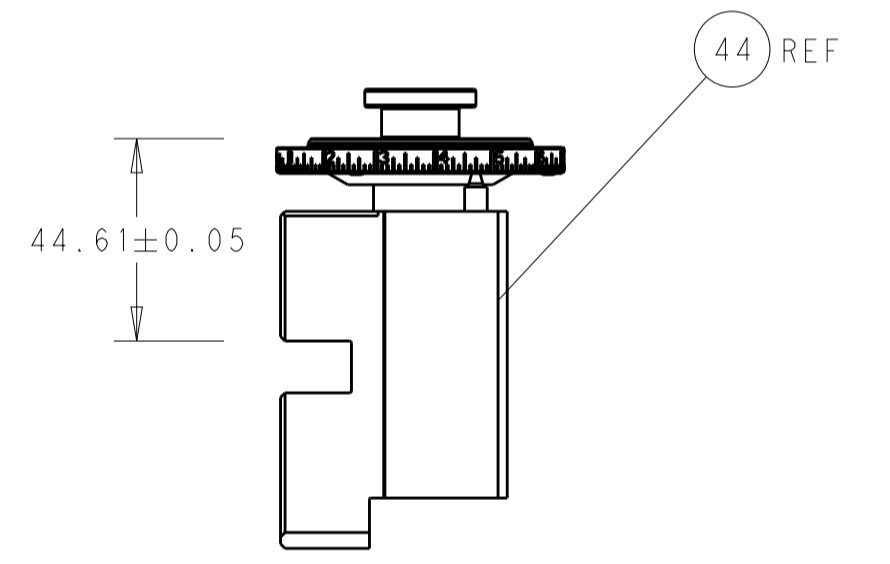
CAM POSITIONS



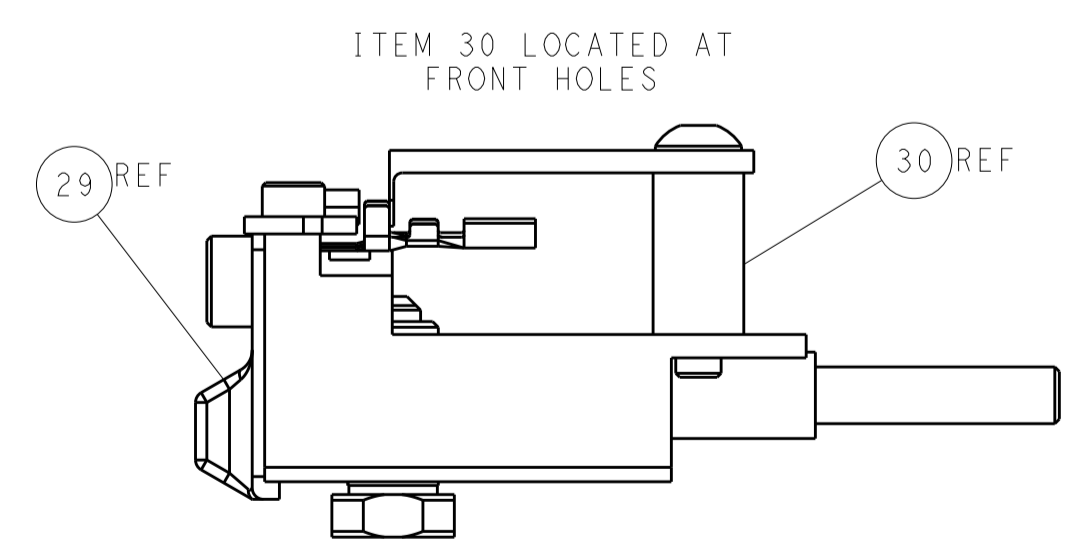
SHEAR DEPRESSOR DETAIL



TERMINAL SUPPORT LOCATION



RAM 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)

<small>THE INFORMATION CONTAINED HEREIN IS UNCLASSIFIED EXCEPT WHERE SHOWN OTHERWISE. IT IS SUBJECT TO CHANGE AND WITHOUT WARRANTY. REVISIONS SHOULD BE CONTACTED FOR THE LATEST REVISION.</small>		DWN: H. HUANG 17APR2013 CHK: L. ZHANG 17APR2013 APVD: H. GUO 17APR2013	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 SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2151928	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
2-2151928-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2151928-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151928-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.40 mm [.055]	F
INSUL	3.43 mm [.135]	O

APPLICATOR INSTRUCTIONS
408-35042

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: MQS 1mm SOCKET CONTACT, SWS			
WIRE STRIP LENGTH	TERMINAL INSULATION DIAMETER RANGE		
3.45-3.75 mm [1.36-.148 IN]	∅ 2.40-2.60mm [1.094-.102 IN]		
TERMINAL APPLICATION SPECIFICATION	114-18231		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE SEAL	TE SEAL
1670448-2		967067-1	
			SEAL INSULATION DIAMETER RANGE
			1.4- 2.1mm

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.50mm2	1.01+/-0.03 [1.040+/-0.001]	7.5
0.35mm2	0.92+/-0.03 [1.036+/-0.001]	8.4

- 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 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 INSULATION CRIMP HEIGHT 2.8mm MAX, CRIMP WIDTH 3.6mm MAX.
- 7. 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					
		P	LTN	DESCRIPTION	DATE	OWN	APVD
A	66	-	-	SEE SHEET 1	-	-	-

-	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	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
-	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	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	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	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	2844992-1	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	1-1633128-3	ANVIL, COMBINATION .055	8
-	1	1	4-240641-2	SPACER	7
-	-	-	-	-	6
-	1	1	2119781-1	DEPRESSOR, SHEAR	5
-	1	1	3-238011-5	BLOCK, CRIMPER SPACER	4
-	1	1	1-1633996-4	CRIMPER, INSULATION SPECIAL	3
-	1	1	455888-6	SPACER, CRIMPER	2
-	1	1	3-456402-5	CRIMPER, WIRE PREMIUM	1

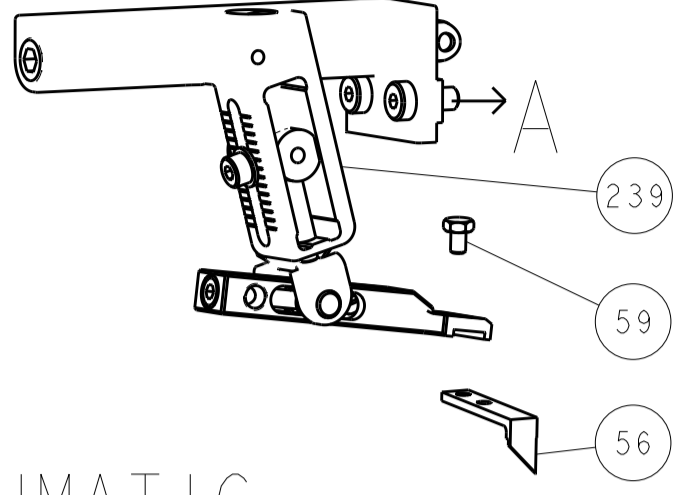
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		MATERIAL:		FINISH:	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES ±	FINISH ±

OWN	CHK	APVD	DATE	NAME	SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
H. HUANG	L. ZHANG	J. GUO	17APR2013	NAME	A1	00779	2151928	

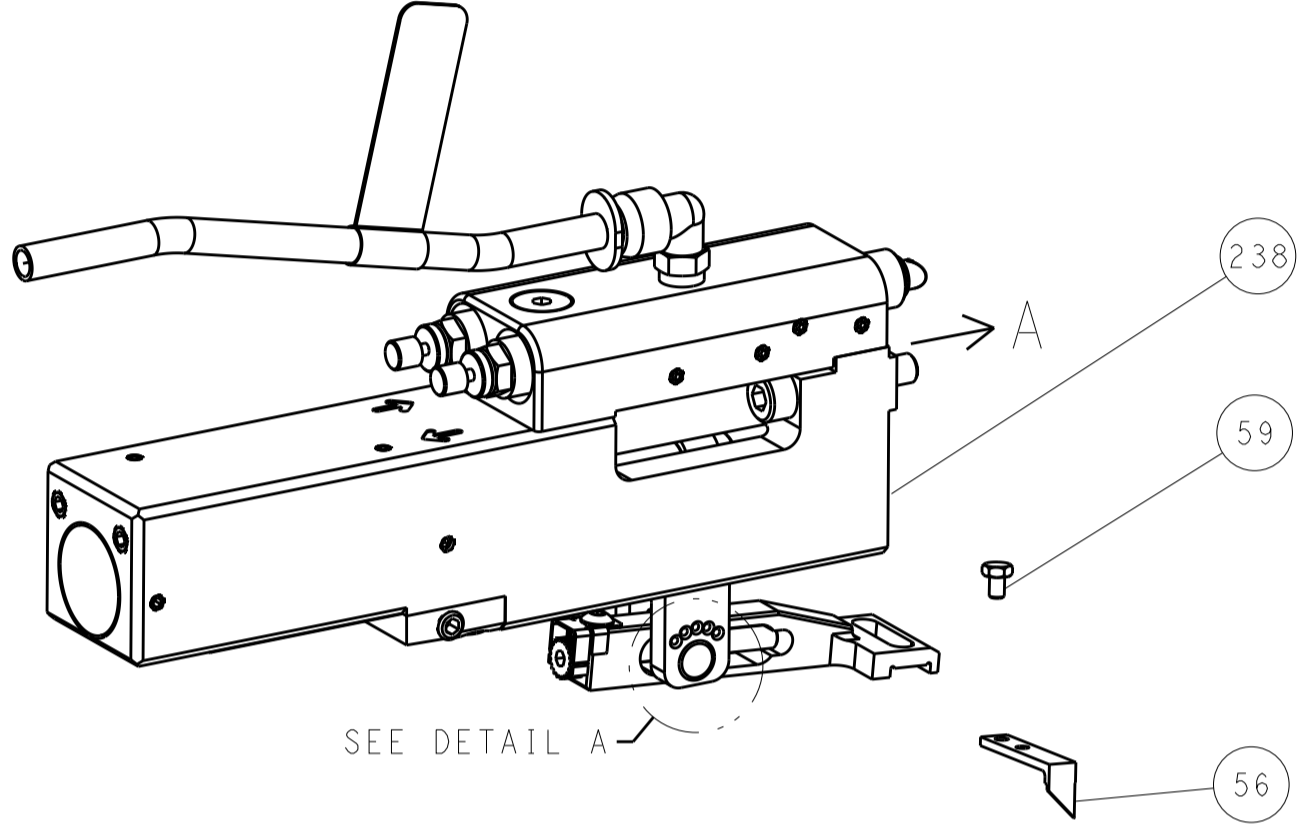
Customer Accessible Production Drawing SCALE 1:2 SHEET 3 OF 4 REV B

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

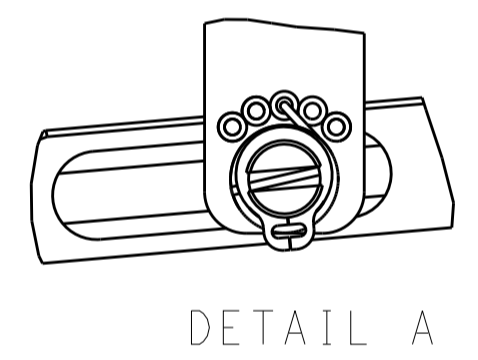
FEED TYPE MECHANICAL



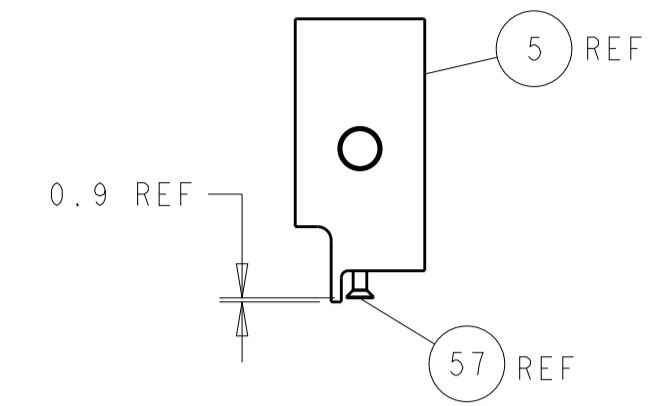
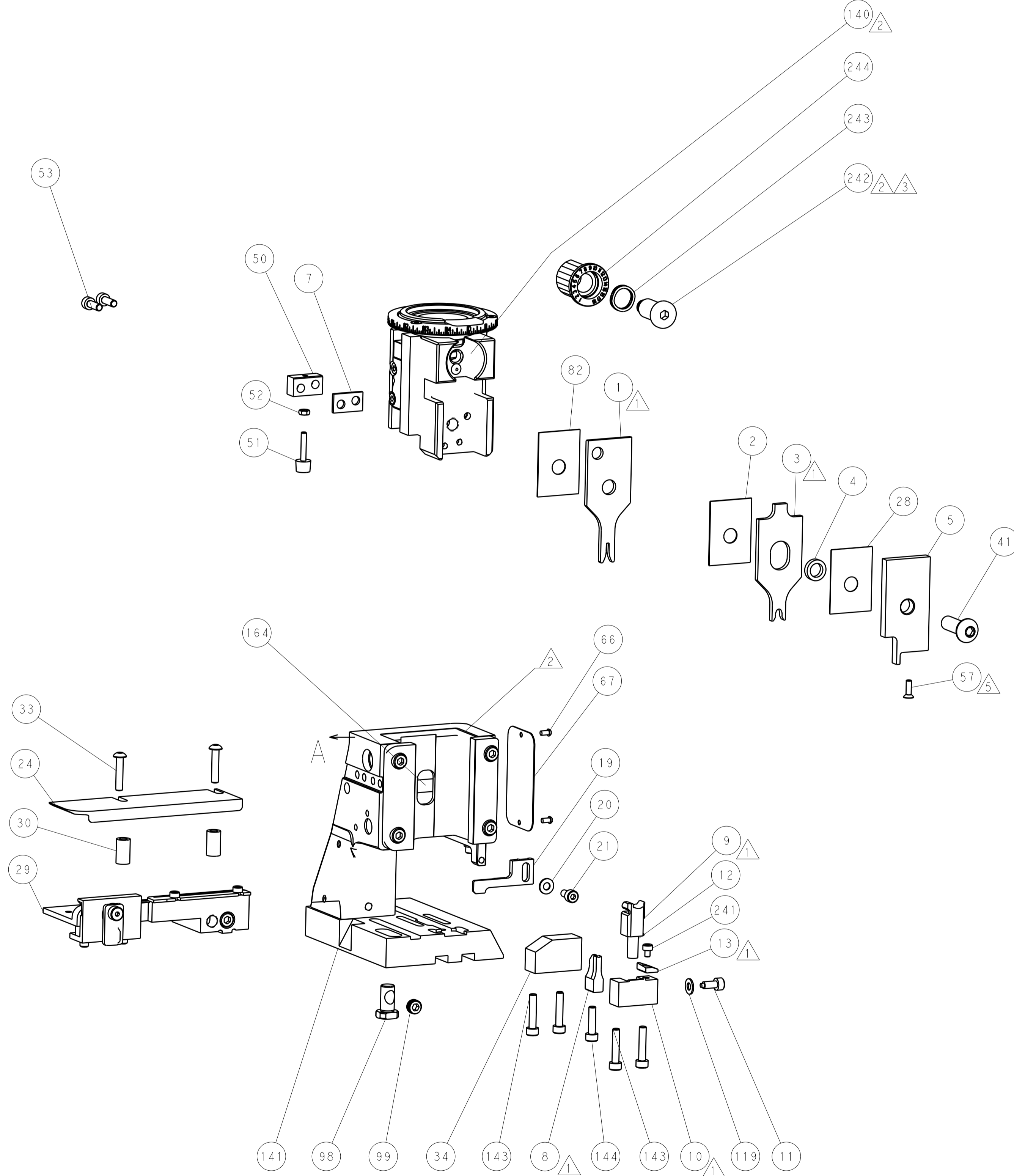
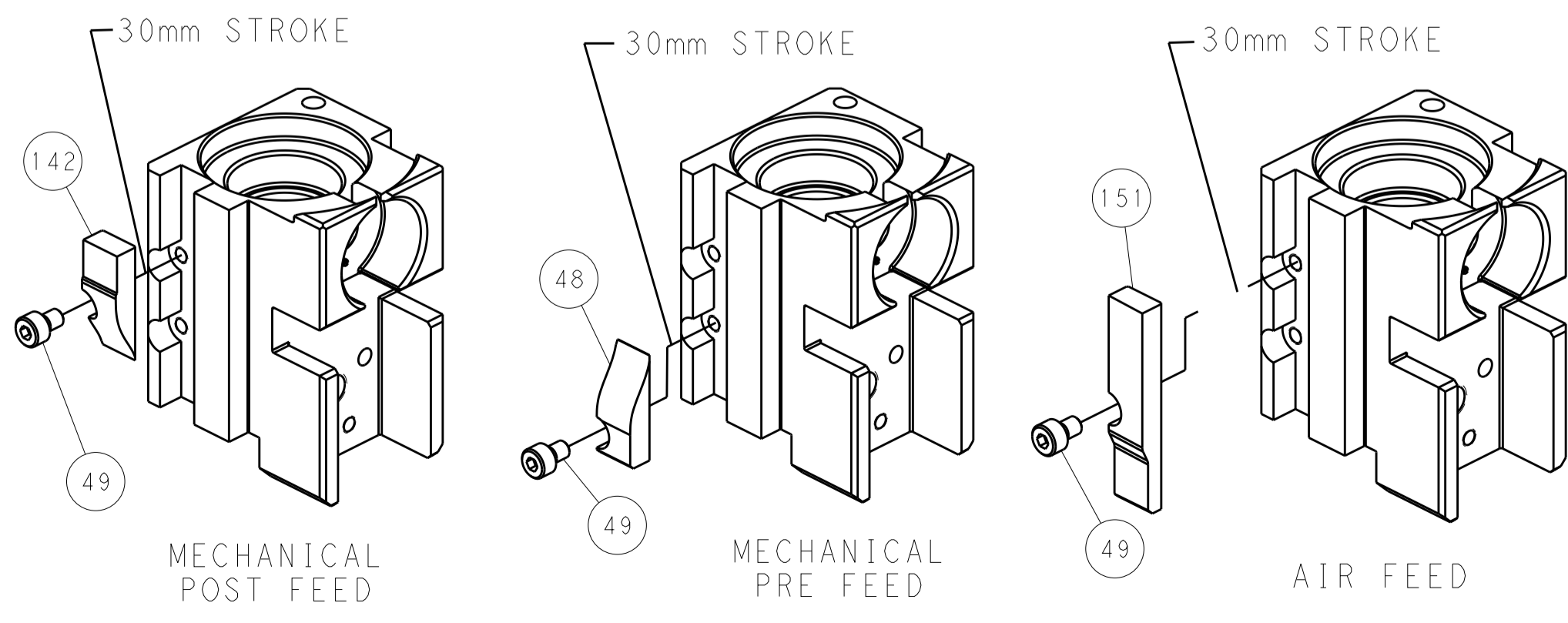
PNEUMATIC



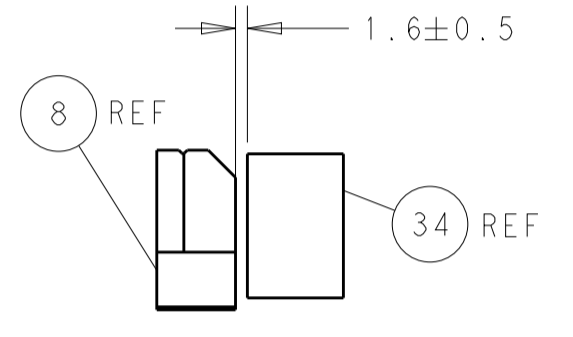
FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



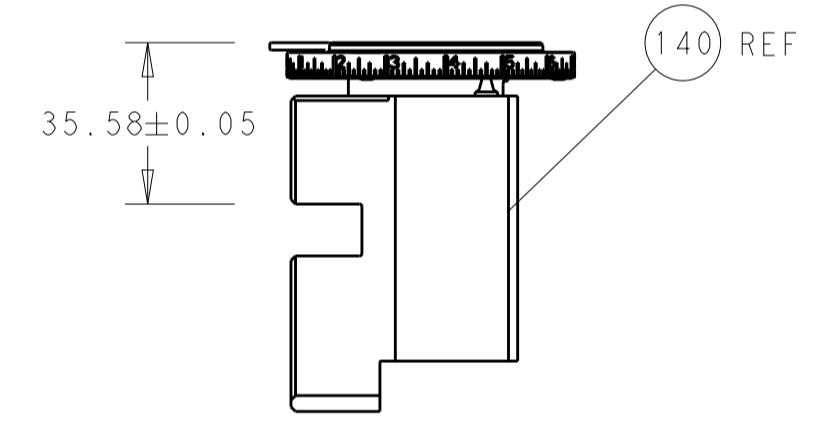
CAM POSITIONS



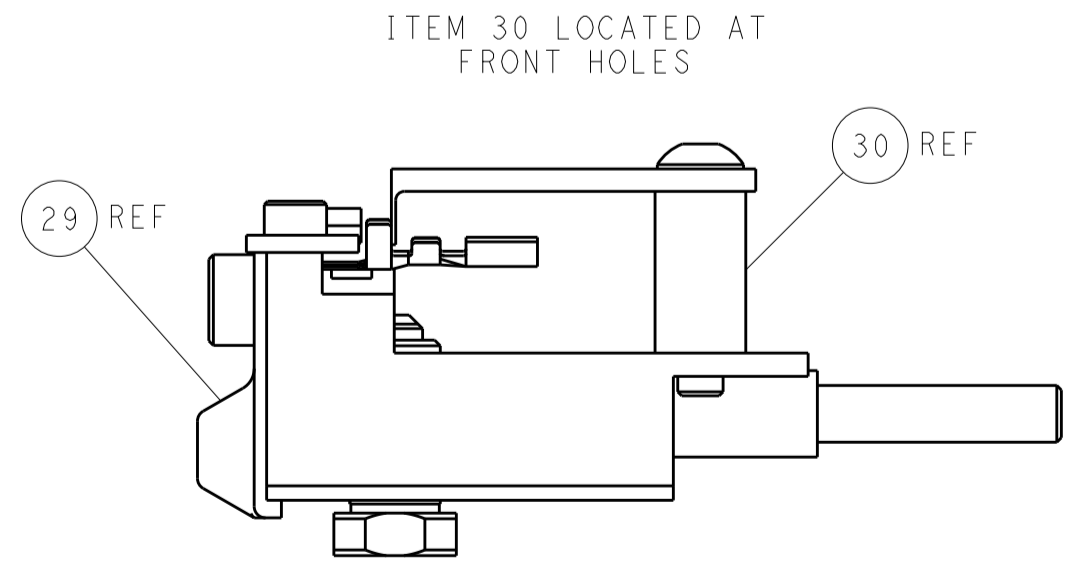
SHEAR DEPRESSOR DETAIL



TERMINAL SUPPORT LOCATION



RAM SET-UP



FEED TRACK POSITION GUIDE BY 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: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		DWG: H. HUANG 17APR2013 CHK: L. ZHANG 17APR2013 APVD: H. GUO 17APR2013		TE Connectivity Harrisburg, PA 17105-3608	
MATERIAL:		FINISH:		PRODUCT SPEC:		NAME: Ocean Side Feed Applicator	
WEIGHT:		SCALE: 1:2		SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2151928		RESTRICTED TO:	
CUSTOMER ACCESSIBLE PRODUCTION DRAWING		SHEET 4 OF 4		REV B		SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION	