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20		20	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151843-1	E	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2151843-2	E	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151843-1	E	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2151843-2	E	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2151843-7	B	CRIMP TOOLING KIT	-

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.57 mm [.062]	F
INSUL	2.03 mm [.080]	O
APPLICATOR INSTRUCTIONS 408-35042		

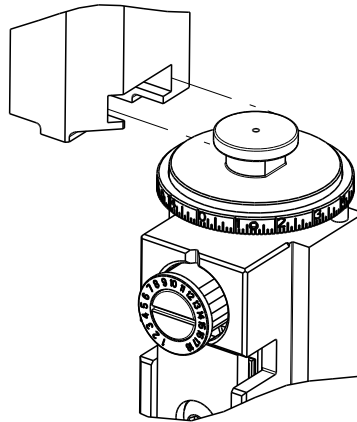
TERMINAL DATA: HIROSE TERMINAL HIROSE CRIMP SPECIFICATION			
TERMINAL NAME: SOCKET			
WIRE STRIP LENGTH 2.00-2.50 mm [.079-.098 IN]		INSULATION DIAMETER RANGE Ø1.20-1.90 mm [.047-.075 IN]	
TERMINAL APPLICATION SPECIFICATION	NONE	-	-
TERMINALS APPLIED			
TE TERMINAL 286890-1	HIROSE TERMINAL DF1B-2022SCFA	TE TERMINAL 286890-2	HIROSE TERMINAL DF1B-2022SCF

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
20 AWG	0.88+/-0.03 [.035+/- .001]	7.9
22 AWG	0.82+/-0.03 [.032+/- .001]	9.0
24 AWG	0.77+/-0.03 [.030+/- .001]	9.2



- 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. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.



ATLANTIC VERSION TERMINATOR  
INTERFACE ADAPTER



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		P			LTR			DESCRIPTION		DATE		DWN		APVD	
							C			ECR-16-005015		06APR2016		MR		CT	
							D			ECR-19-004658		24MAR2019		TB		CT	
							E			ECR-23-185304		25AUG2023		JWC		TE	

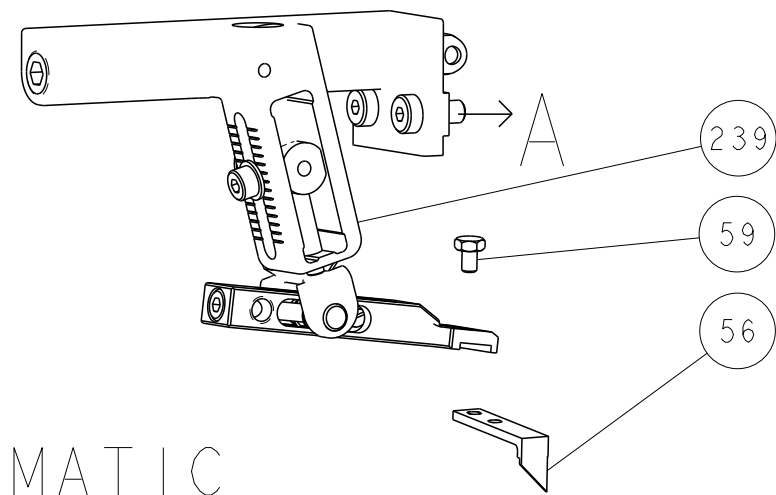
1	-	1	1	1	1	2280441-1	INSERT, SHEAR	282
	-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248
	-	1	1	1	1	2119082-8	CAM, SNAIL, INSULATION ADJUSTMENT	244
3	-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
	-	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
	-	2	2	2	2	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
	-	-	1	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
	-	1	-	1	-	2844940-1	AIR FEED MODULE	238
	-	1	1	1	1	356885-4	STOP, SHEAR	237
	-	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
	-	1	1	1	1	2844908-1	SCREW, LOCKING	99
	-	1	1	1	1	2844907-1	POST, LOCKING	98
	-	1	1	1	1	455888-7	SPACER, CRIMPER	82
	-	1	1	1	1	8-240641-8	SPACER	81
	-	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
	-	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	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	53
	-	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
	-	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
	-	2	2	2	2	2-2844962-3	SPACER, CYLINDRICAL, STRIP GUIDE	30
	-	1	1	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29
	-	1	1	1	1	1-455888-0	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
	-	2	2	2	2	1-18028-2	WASHER, FLAT, REG M4	20
	-	1	1	1	1	2119533-1	STRIPPER, SIDE FEED	19
	-	1	1	1	1	1-690518-9	HOLD DOWN, TERMINAL	18
1	-	1	1	1	1	690463-1	FLOATING SHEAR, REAR	17
	-	2	2	2	2	1-2168083-1	SCR, SKT HD CAP, RoHS, M3 X 6	16
1	-	1	1	1	1	1-690464-4	SHEAR PLATE, REAR	15
1	-	1	1	1	1	2119862-1	SHEAR HOLDER, REAR	14
1	-	1	1	1	1	2119806-1	INSERT, SHEAR	13
	-	2	2	2	2	3-22280-3	SPRING, COMPRESSION	12
	-	1	1	1	1	1-356885-4	STOP, SHEAR	11
1	-	1	1	1	1	2119805-1	SHEAR HOLDER, FRONT	10
1	-	1	1	1	1	1803095-6	FLOATING SHEAR, FRONT	9
	1	2	2	1	1	1803336-5	ANVIL, COMBINATION	8
	-	1	1	1	1	1-240641-9	SPACER	7
	-	1	1	1	1	690468-1	DEPRESSOR SHEAR, REAR	6
	-	1	1	1	1	2119757-4	DEPRESSOR, SHEAR	5
	-	1	1	1	1	2-238011-5	BLOCK, CRIMPER SPACER	4
1	1	2	2	1	1	1803329-1	CRIMPER, INSULATION O PREMIUM	3
	-	1	1	1	1	455888-7	SPACER, CRIMPER	2
1	1	2	2	1	1	1-1803325-1	CRIMPER, WIRE F -	1
	-77	-72	-71	-2	-1	PART NO	DESCRIPTION	ITEM NO

THE INFORMATION ON THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE WITHOUT NOTICE AND WITHOUT LIABILITY. IT IS THE RESPONSIBILITY OF THE USER TO OBTAIN THE LATEST EDITION.										DWN R. STAKEM 28DEC2012		 TE Connectivity Harrisburg, PA 17105-3608	
										CHK G. BAILEY 28DEC2012			
DIMENSIONS: mm				TOLERANCES UNLESS OTHERWISE SPECIFIED:						NAME			
				0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH ±						Ocean Side Feed Applicator -			
MATERIAL -				APPLICATION SPEC						RESTRICTED TO			
				WEIGHT -						SIZE A1			
				Customer Accessible Production Drawing						CAGE CODE 00779			
				SCALE 1:2						DRAWING NO C-2151843			
				SHEET 1 OF 4						REV E			

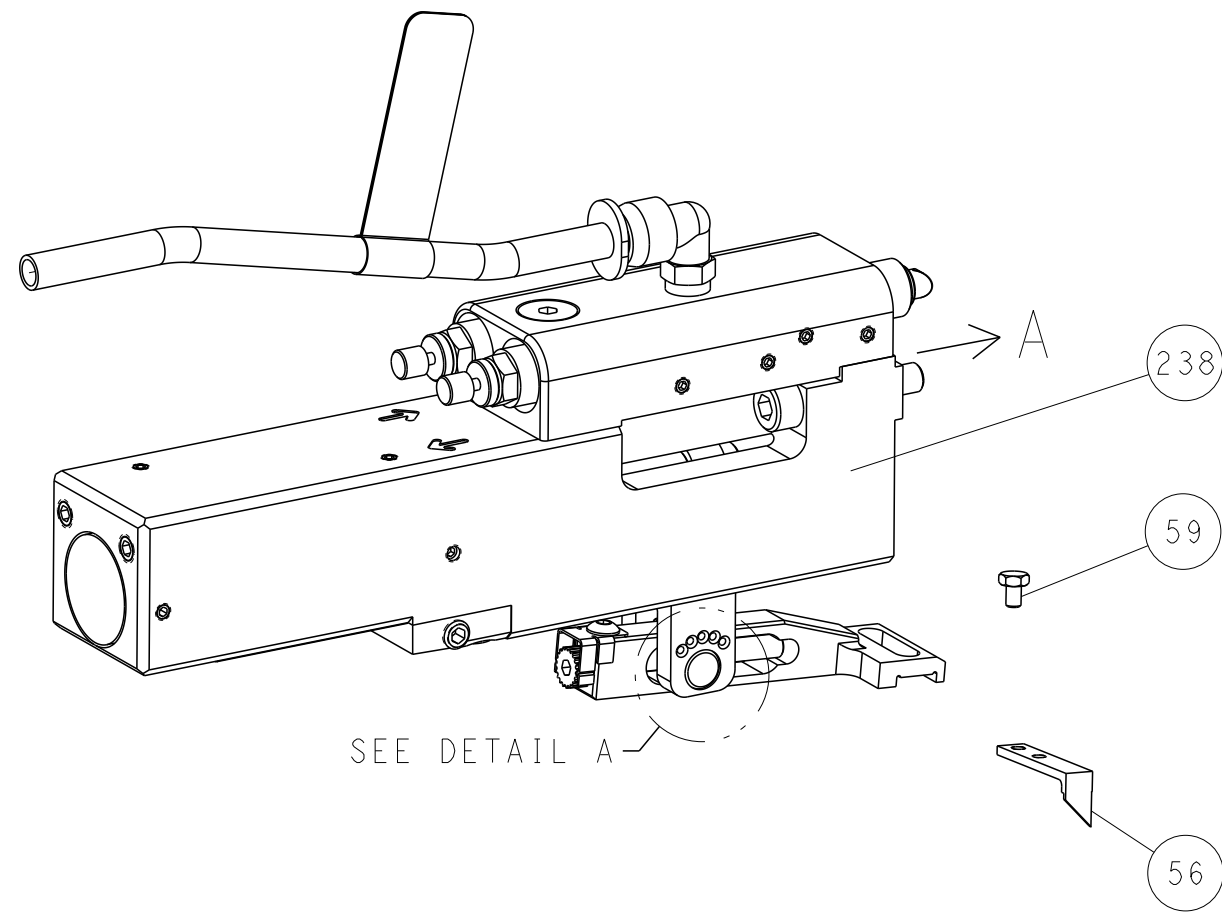
SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

LOC	DIST	REVISIONS						
		P	LTR	DESCRIPTION	DATE	DWN	APVD	
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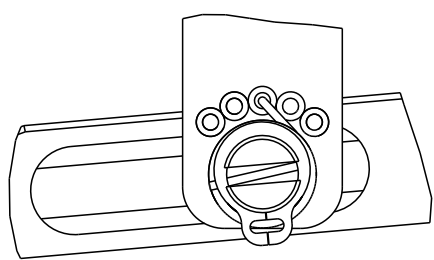
FEED TYPE  
MECHANICAL



PNEUMATIC

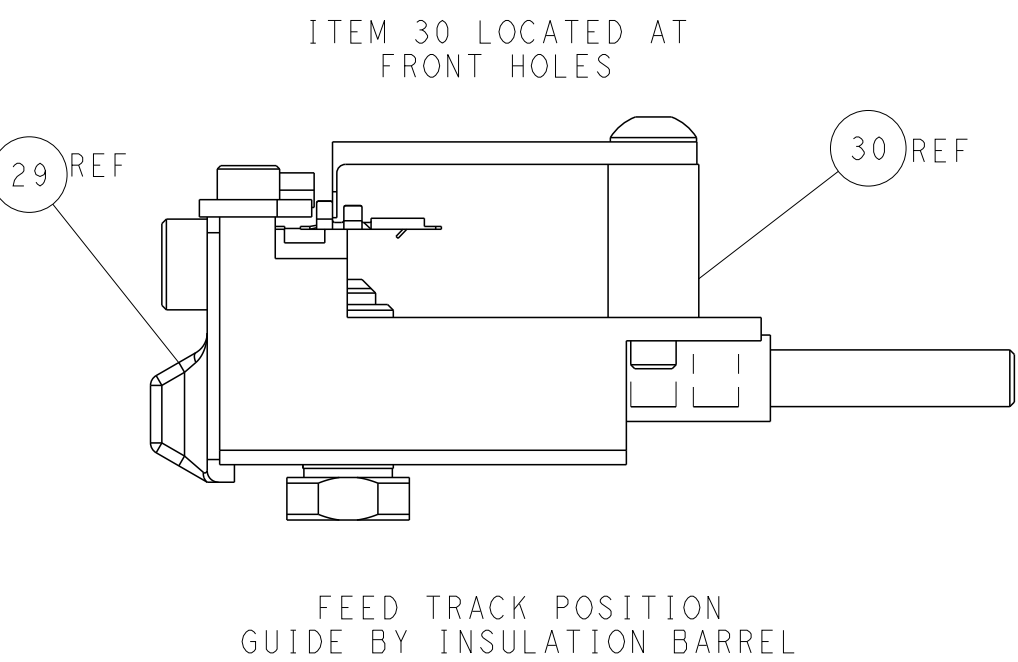
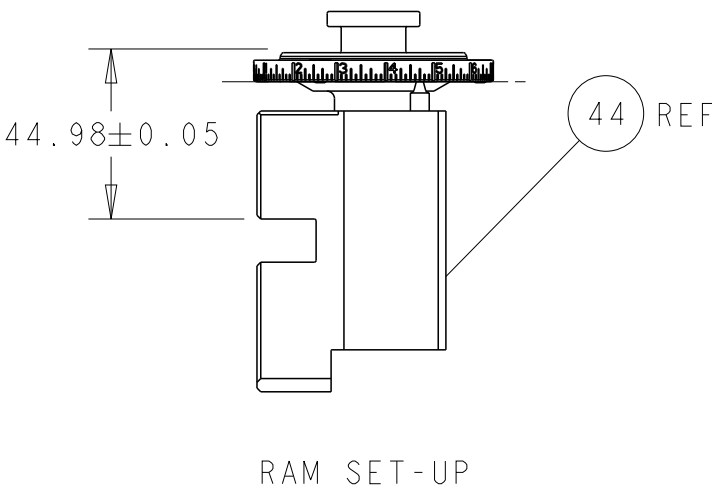
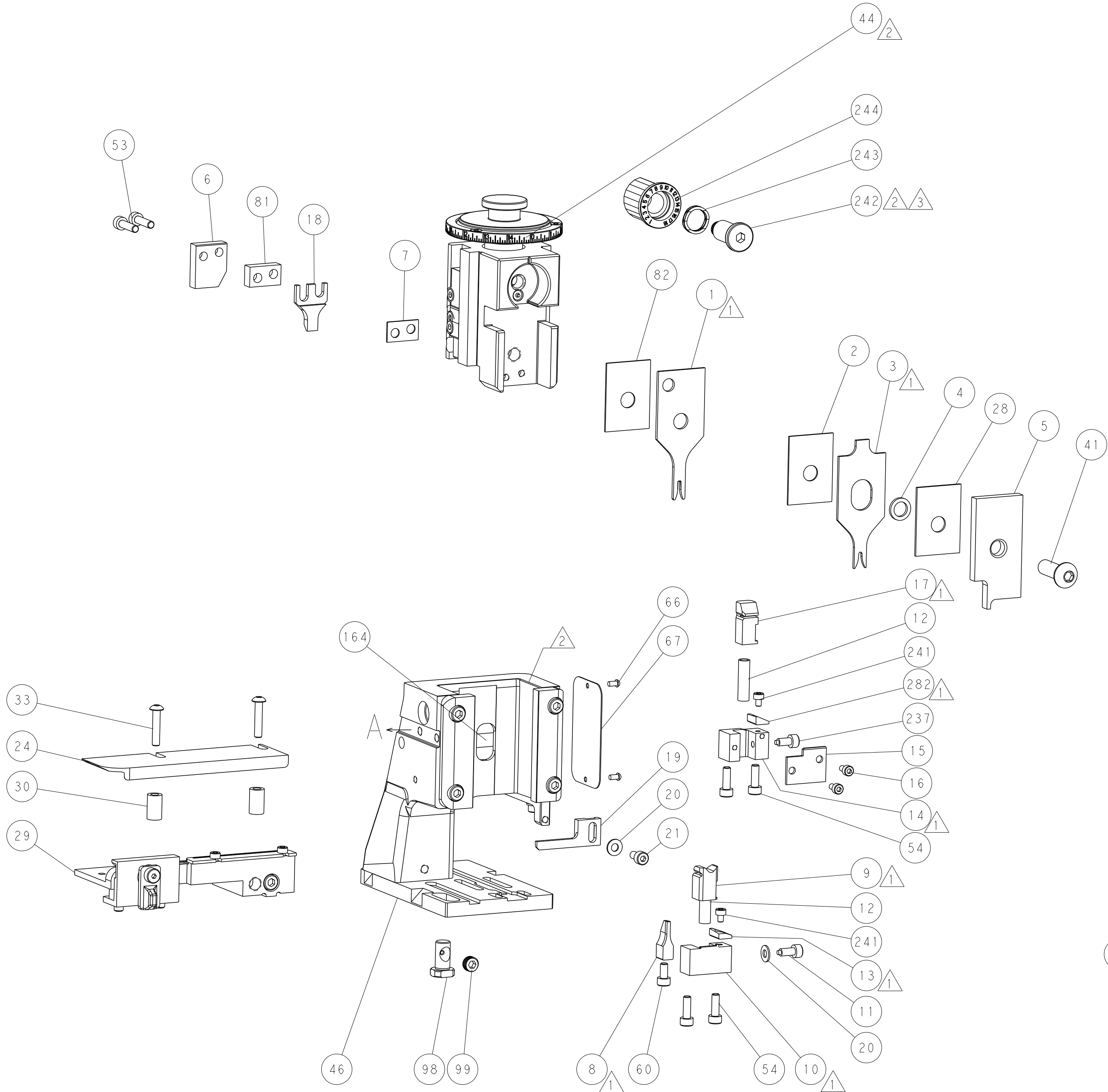
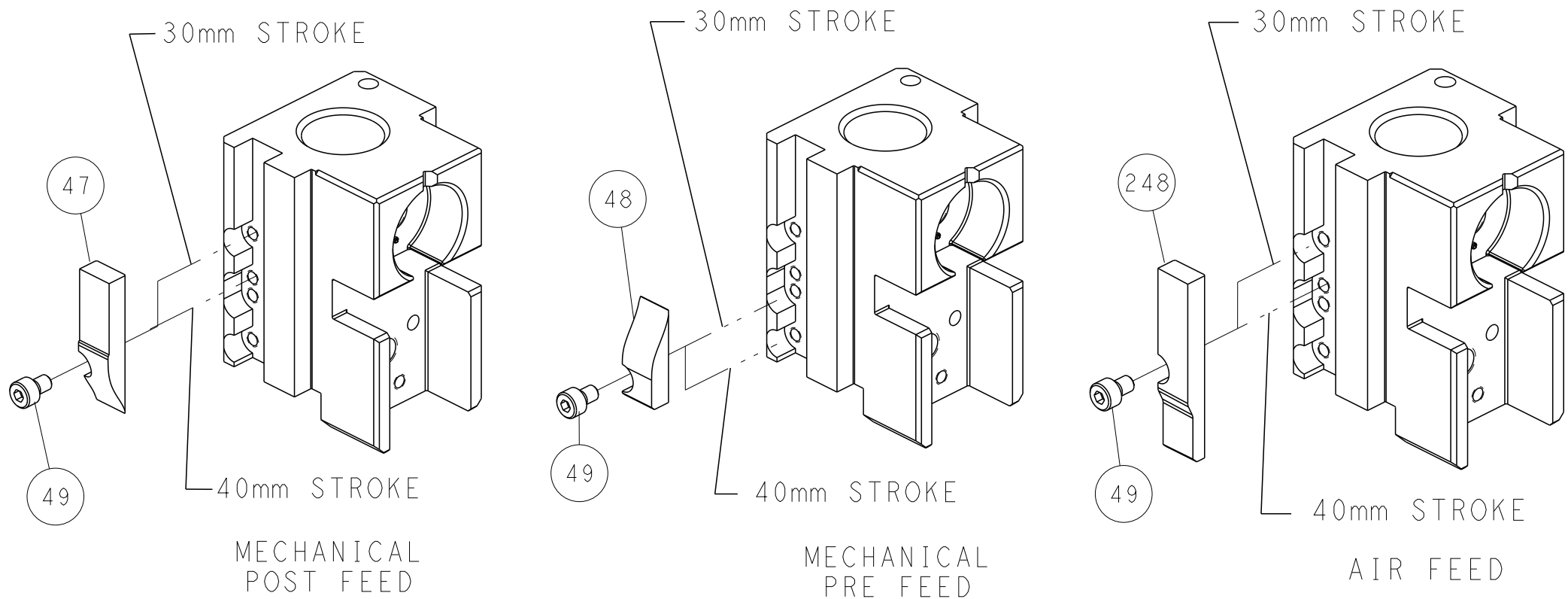


FEED SPRING SETTING POSITION  
(SHOWN FROM REAR SIDE)



DETAIL A

CAM POSITIONS

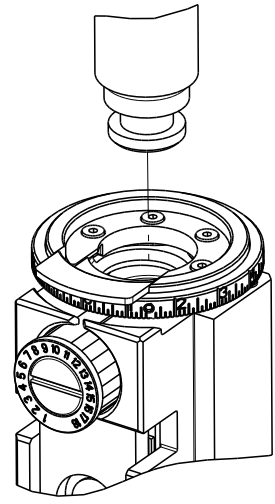


ATLANTIC VERSION  
Shown on sheets 1 of 4 & 2 of 4  
(Pacific version shown on sheets 3 of 4 & 4 of 4)

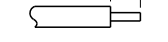

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DIMENSIONS:				TOLERANCES UNLESS OTHERWISE SPECIFIED:				NAME: Ocean Side Feed Applicator			
mm				0 PLC ±.1 1 PLC ±.1 2 PLC ±.1 3 PLC ±.1 4 PLC ±.1 ANGLES ±.1 FINISH				SIZE: A1			
MATERIAL: -				WEIGHT: -				CAGE CODE: 00779			
Customer Accessible Production Drawing				SCALE: 1:1				SHEET: 1 of 4			
								REV: E			

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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2151843-1	E	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2151843-2	E	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151843-7	B	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR  
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.57 mm [.062]	F
INSUL	2.03 mm [.080]	O
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: HIROSE TERMINAL		HIROSE CRIMP SPECIFICATION	
TERMINAL NAME: SOCKET			
WIRE STRIP LENGTH 2.00-2.50 mm [.079-.098 IN]		 INSULATION DIAMETER RANGE Ø1.20-1.90 mm [.047-.075 IN]	
TERMINAL APPLICATION SPECIFICATION	 NONE	-	-
TERMINALS APPLIED			
TE TERMINAL	HIROSE TERMINAL	TE TERMINAL	HIROSE TERMINAL
286890-1	DF1B-2022SCFA	286890-2	DF1B-2022SCF

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING
20 AWG		0.88+/-0.03 [.035+/-0.001]		7.9
22 AWG		0.82+/-0.03 [.032+/-0.001]		9.0
24 AWG		0.77+/-0.03 [.030+/-0.001]		9.2



- 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.
5. 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)

2		1					
LOC	DIST	REVISIONS					
A	66	P	LTR	DESCRIPTION	DATE	DWN	APVD
		-		SEE SHEET 1	-	-	-

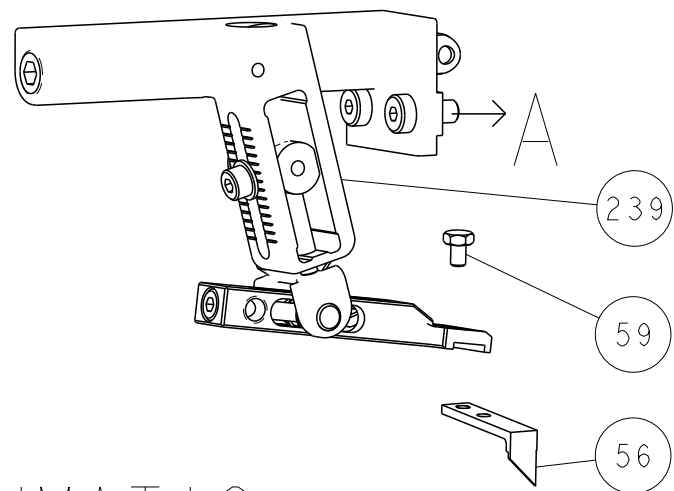
	-	1	1	2280441-1	INSERT, SHEAR	282
	-	1	1	2119082-8	CAM, SNAIL, INSULATION ADJUSTMENT	244
	-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
	-	1	1	2119083-1	RETAINER, INSULATION DIAL	242
	-	2	2	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
	-	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
	-	1	-	2844940-1	AIR FEED MODULE	238
	-	1	1	356885-4	STOP, SHEAR	237
	-	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	455888-7	SPACER, CRIMPER	82
	-	1	1	8-240641-8	SPACER	81
	-	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	1338685-1	PAWL, FEED	56
	-	2	2	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	53
	-	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
	-	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	1-455888-0	SPACER, CRIMPER	28
	-	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	1-690518-9	HOLD DOWN, TERMINAL	18
	-	1	1	690463-1	FLOATING SHEAR, REAR	17
	-	2	2	1-2168083-1	SCR, SKT HD CAP, RoHS, M3 X 6	16
	-	1	1	1-690464-4	SHEAR PLATE, REAR	15
	-	1	1	2119862-1	SHEAR HOLDER, REAR	14
	-	1	1	2119806-1	INSERT, SHEAR	13
	-	2	2	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	1803336-5	ANVIL, COMBINATION	8
	-	1	1	1-240641-9	SPACER	7
	-	1	1	690468-1	DEPRESSOR SHEAR, REAR	6
	-	1	1	2119757-4	DEPRESSOR, SHEAR	5
	-	1	1	2-238011-5	BLOCK, CRIMPER SPACER	4
	1	1	1	1803329-1	CRIMPER, INSULATION O PREMIUM	3
	-	1	1	455888-7	SPACER, CRIMPER	2
	1	1	1	1-1803325-1	CRIMPER, WIRE F -	1

-77	-22	-21	PART NO	DESCRIPTION	ITEM NO
CHK A. STAKEM G. BAILEY			28DEC2012 28DEC2012	STE TE Connectivity Harrisburg, PA 17105-3608	
APVD T. ELBIN			28DEC2012	NAME Ocean Side Feed Applicator	
DIMENSIONS: mm			TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH	SIZE A	
MATERIAL -			WEIGHT -	CAGE CODE 00779	
Customer Accessible Production Drawing			SCALE 1:1	SHEET 1 OF 4	
				REV E	

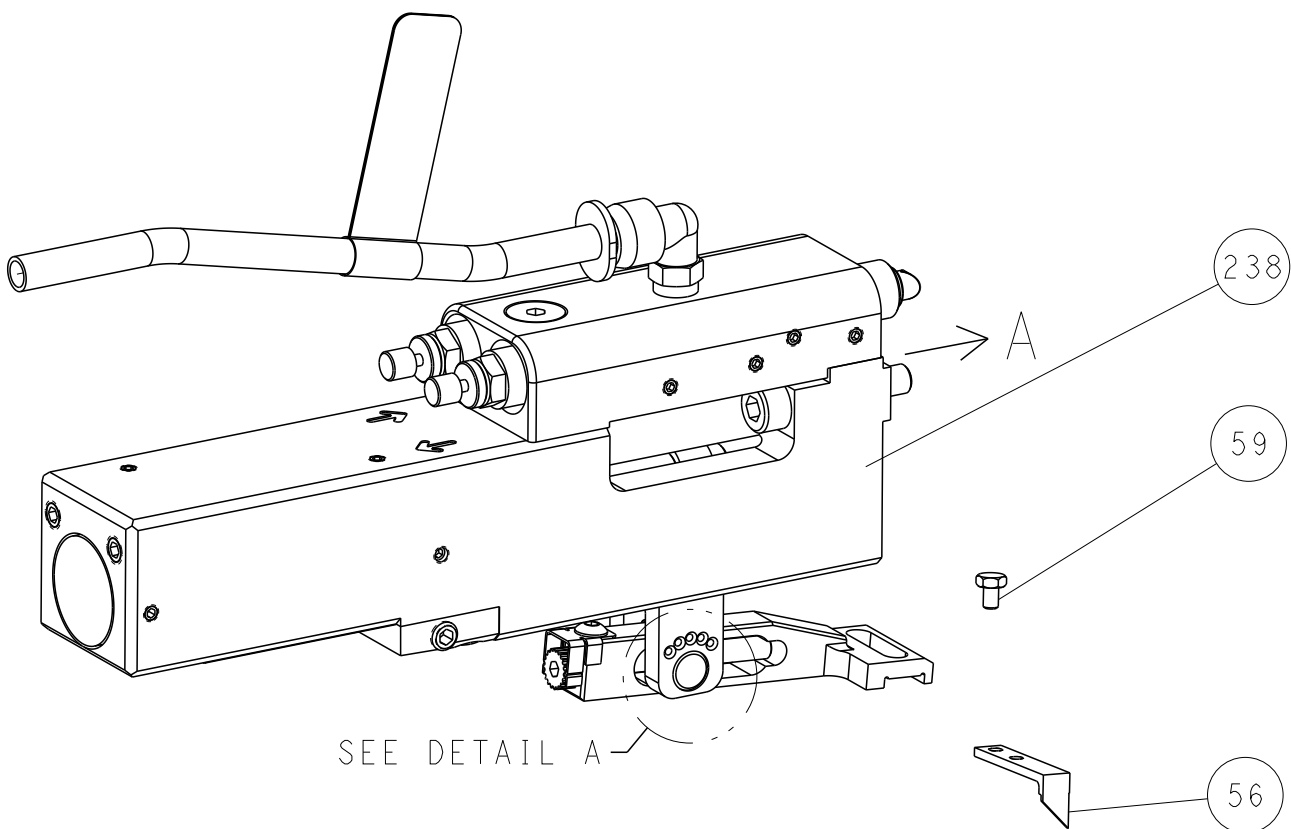
SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

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

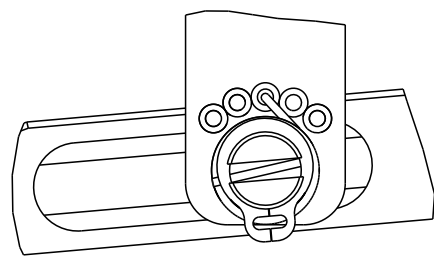
FEED TYPE  
MECHANICAL



PNEUMATIC

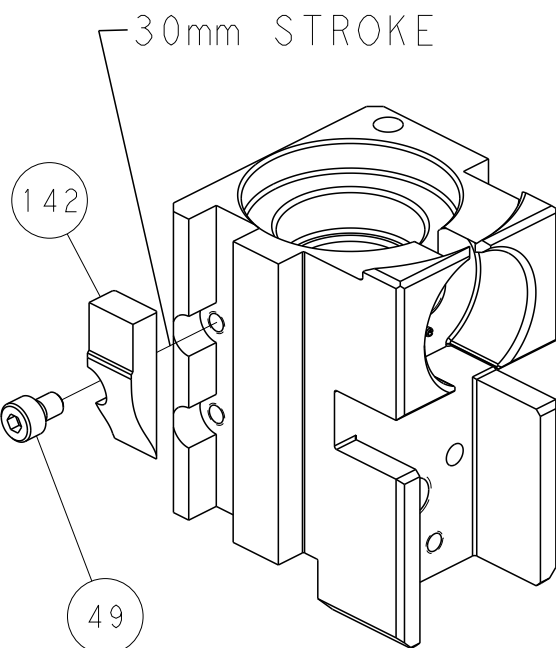


FEED SPRING SETTING POSITION  
(SHOWN FROM REAR SIDE)

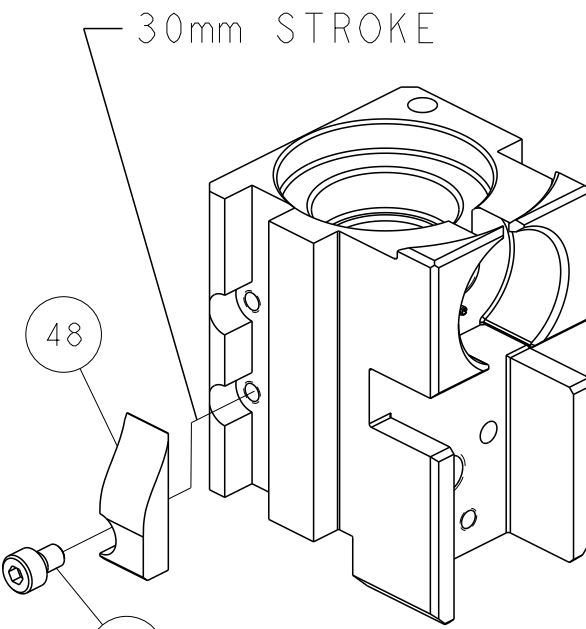


DETAIL A

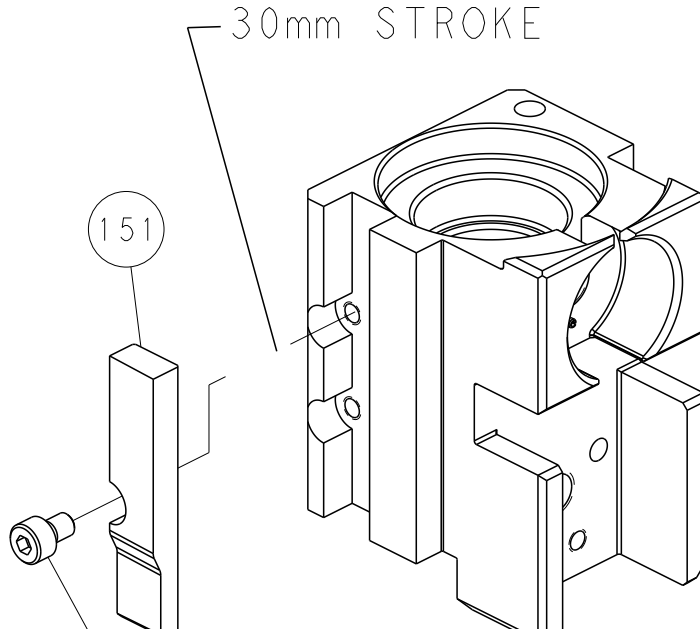
CAM POSITIONS



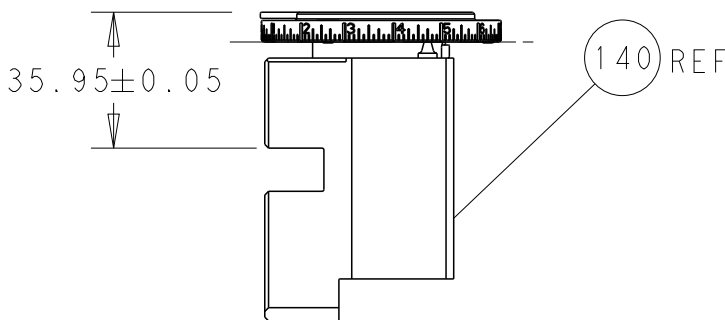
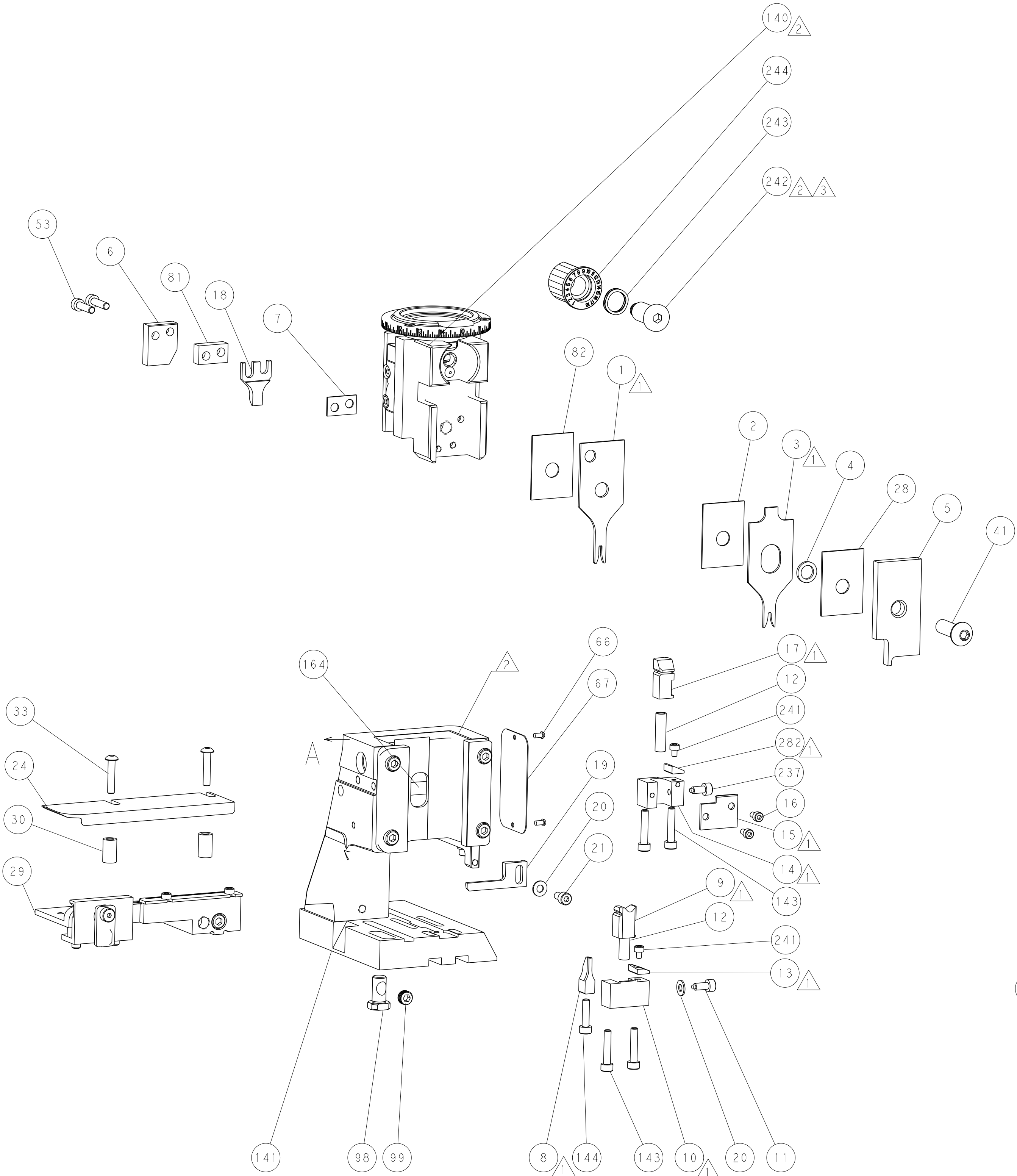
MECHANICAL  
POST FEED



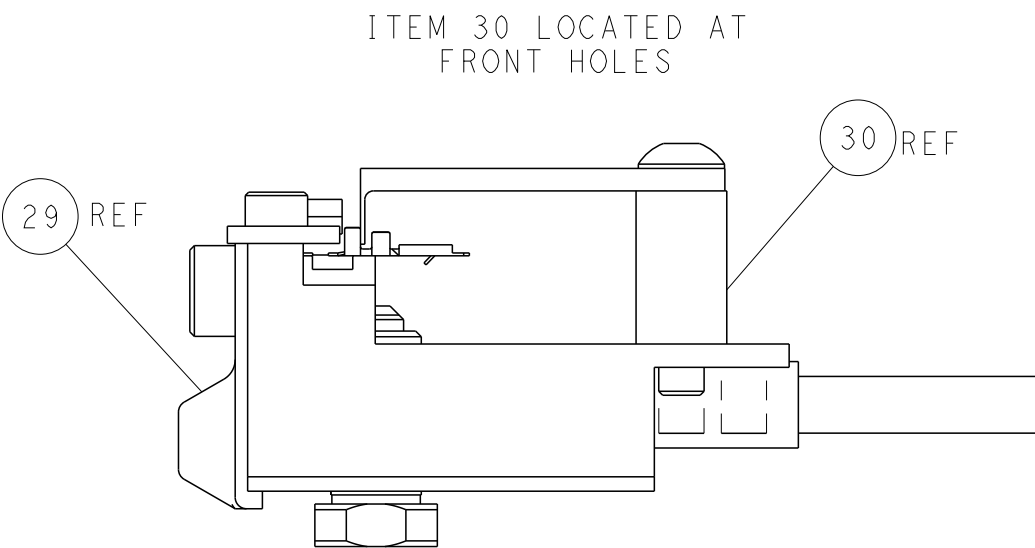
MECHANICAL  
PRE FEED



AIR FEED




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)

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				CHK	G. BAILEY	28DEC2012					
				APVD	T. ELBIN	28DEC2012	NAME Ocean Side Feed Applicator -				
				PRODUCT SPEC							
				APPLICATION SPEC							
				WEIGHT							
				Customer Accessible Production Drawing							
				SCALE							
				SHEET							
				REV							