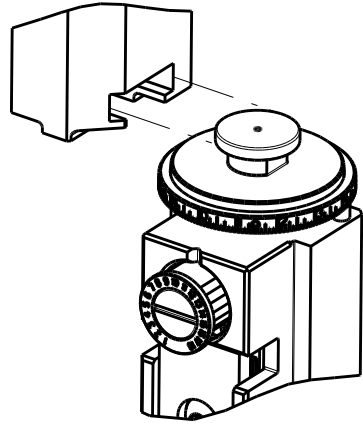
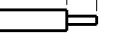


8		7	
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2011		2011	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151185-1	E	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2151185-2	E	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151185-1	E	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2151185-2	E	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2151185-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.78 mm [.070]	F
INSUL	2.03 mm [.080]	BX
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: .070 SERIES RECEPTACLE CONTACT			
WIRE STRIP LENGTH			INSULATION DIAMETER RANGE
3.50-4.50 mm [.138-.177 IN]			Ø1.40-1.90 mm [.055-.075 IN]
TERMINAL APPLICATION SPECIFICATION	(A)114-5091	-	-
	(B)114-5091-3	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
173630-1 (A)	173630-7 (A)	175186-1 (B)	
173630-2 (A)	1-173630-2 (A)		
173630-6 (A)			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.30mm2	1.03+/-0.05 [.041+/- .002]	6.5
0.20mm2	0.96+/-0.05 [.038+/- .002]	7.4



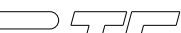
- 1 RECOMMENDED SPARE PARTS
- 2 REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- 3 APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242.
- 4 CRIMP HEIGHT REFERENCE SETTING WAS THE SETTING USED WHEN THE APPLICATOR WAS QUALIFIED AT THE FACTORY. ADJUSTMENT MAY BE NECESSARY WHEN RUNNING APPLICATOR IN THE FIELD.
5. 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.

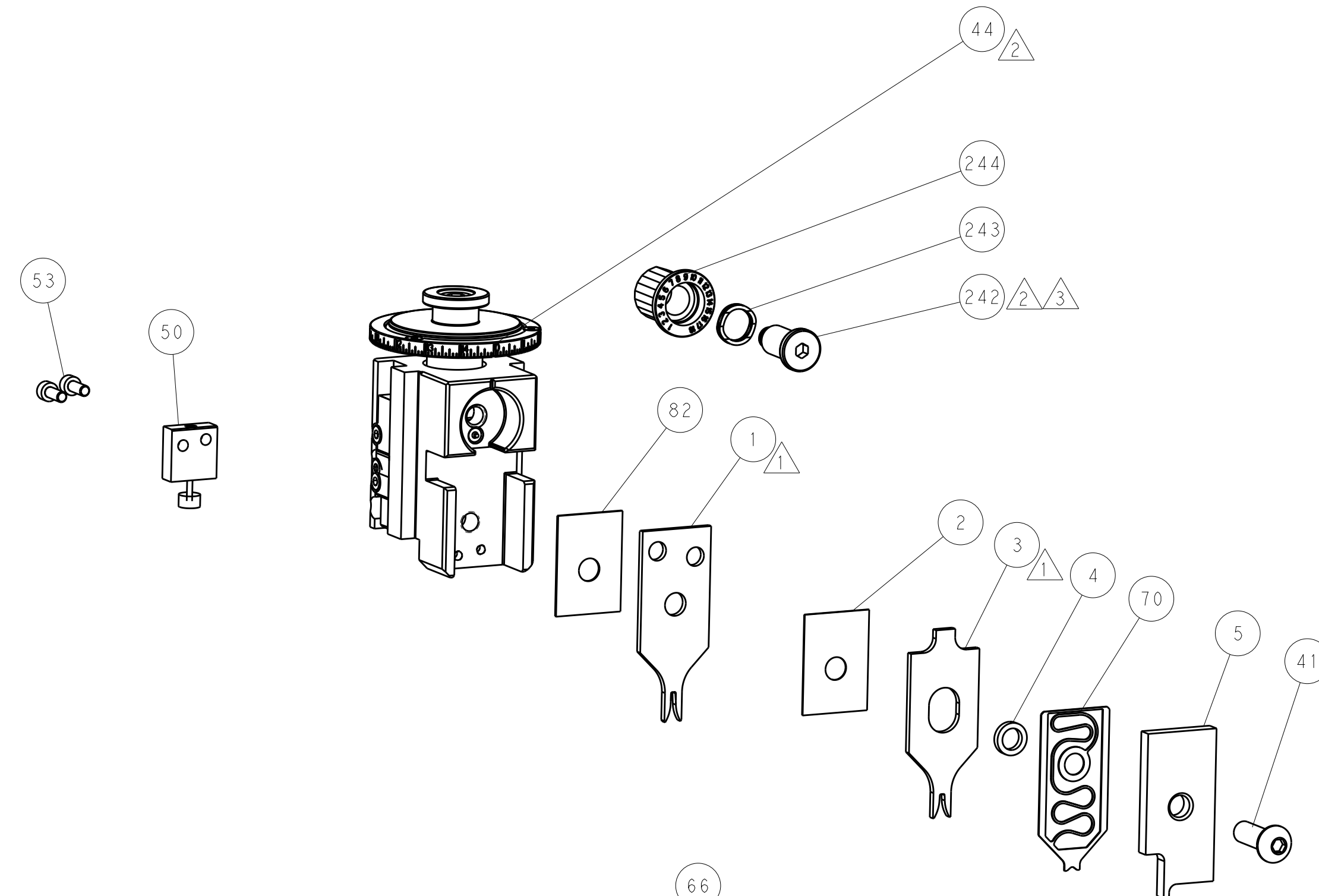
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

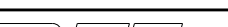
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LOC	DIST	REVISIONS					
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		B		ECR-15-005050	31MAR2015	KH	GB
		C		ECR-16-007113	17MAY2016	KH	JDG
		D		ECR-18-007515	16MAY2018	KH	LG
		E		ECR-18-008880	26 JUN2018	YY	CT

-	1	-	1	-	2119640-1	PUSH ROD, AIR FEED	250
-	1	-	1	-	1803259-1	BUSHING, FLANGED	249
-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248
-	1	1	1	1	2119082-2	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	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	-	2063440-1	AIR FEED MODULE	238
-	2	-	2	-	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172
-	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	1	-	1	-	240638-1	SPRING, FEED FINGER	163
-	1	-	1	-	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854	137
-	1	-	1	-	2119799-1	HOLDER,FEED FINGER, AF	136
-	1	1	1	1	2844908-1	SCREW, LOCKING	99
-	1	1	1	1	2844907-1	POST, LOCKING	98
-	1	1	1	1	455888-6	SPACER, CRIMPER	82
-	1	1	1	1	1803607-1	DOCUMENTATION PACKAGE	71
-	1	1	1	1	2119791-5	DEPRESSOR, WIRE	70
-	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	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	3-1752356-4	SUPPORT, TERMINAL	34
-	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	2	2	3-2844962-2	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29
-	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	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	1803095-3	FLOATING SHEAR, FRONT -	9
1	2	2	1	1	1333203-9	ANVIL, COMBINATION	8
-	-	-	-	-	-	-	7
-	-	-	-	-	-	-	6
-	1	1	1	1	2119757-8	DEPRESSOR, SHEAR	5
-	1	1	1	1	238011-4	BLOCK, CRIMPER SPACER	4
1	2	2	1	1	1633988-2	CRIMPER, INSULATION BOX PREMIUM	3
-	1	1	1	1	455888-4	SPACER, CRIMPER	2
1	2	2	1	1	3-456404-2	CRIMPER, WIRE PREMIUM	1
-77	-72	-71	-2	-1	PART NO	DESCRIPTION	ITEM NO

THIS DRAWING IS A CONTROLLED DOCUMENT OF THE PRO ELECTRONICS CORPORATION IT IS UNPUBLISHED. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. ANY CHANGES TO THIS DOCUMENT SHALL BE CONTACTED FOR THE LATEST EDITION.				DWN	B. WEAVER	09NOV2011	 TE Connectivity Harrisburg, PA 17105-3608				
				CHK	G. HOFFNER	09NOV2011					
				APVD	T. ELBIN	09NOV2011	NAME				
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:						PRODUCT SPEC - APPLICATION SPEC - Ocean Side Feed Applicator -			
mm		0 PLC ±									
		1 PLC ±									
		2 PLC ±									
		3 PLC ±									
		4 PLC ±									
		ANGLES									
		FINISH									
MATERIAL		WEIGHT									
		Customer Accessible Production Drawing									
		SCALE									
		SHEET									
		REV									

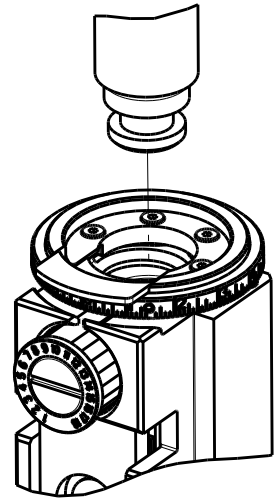
PNEUMATIC



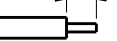
1253. DRAWING IS A CONTROLLED DOCUMENT FOR THIS ELECTRONIC SUBSCRIPTION IT IS SUBJECT TO THE SAME TERMS AND CONDITIONS AS THE ORIGINAL DRAWING IT SHOULD BE CONTROLLED BY THE LATEST VERSION		DWN B. WEAVER 09NOV2011	 TE Connectivity Harrisburg, PA 17105-3608			
DIMENSIONS: mm		CDR G. HOFNER 09NOV2011				
TOLERANCES, UNLESS OTHERWISE SPECIFIED:		APVD T. FIRN 09NOV2011				
		NAME Ocean Side Feed Applicator				
MATERIAL -	FINISH -	WEIGHT -	SIZE A1	CADL CODE 00779	DRAWING NO C-2151185	RESTRICTED TO -
Customer Accessible Production Drawing				SCALE 1:2	SHEET 2 OF 4	REV F

8		7	
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2011		2011	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2151185-1	E	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2151185-2	E	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151185-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.78 mm [.070]	F
INSUL	2.03 mm [.080]	BX
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: .070 SERIES RECEPTACLE CONTACT			
WIRE STRIP LENGTH 3.50-4.50 mm [.138-.177 IN]			INSULATION DIAMETER RANGE Ø1.40-1.90 mm [.055-.075 IN]
TERMINAL APPLICATION SPECIFICATION 	(A)114-5091	-	-
	(B)114-5091-3	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
173630-1 (A)	173630-7 (A)	175186-1 (B)	
173630-2 (A)	1-173630-2 (A)		
173630-6 (A)			

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING	
0.30mm2		1.03+/-0.05 [.041+/- .002]		6.5	
0.20mm2		0.96+/-0.05 [.038+/- .002]		7.4	



- 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. 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)

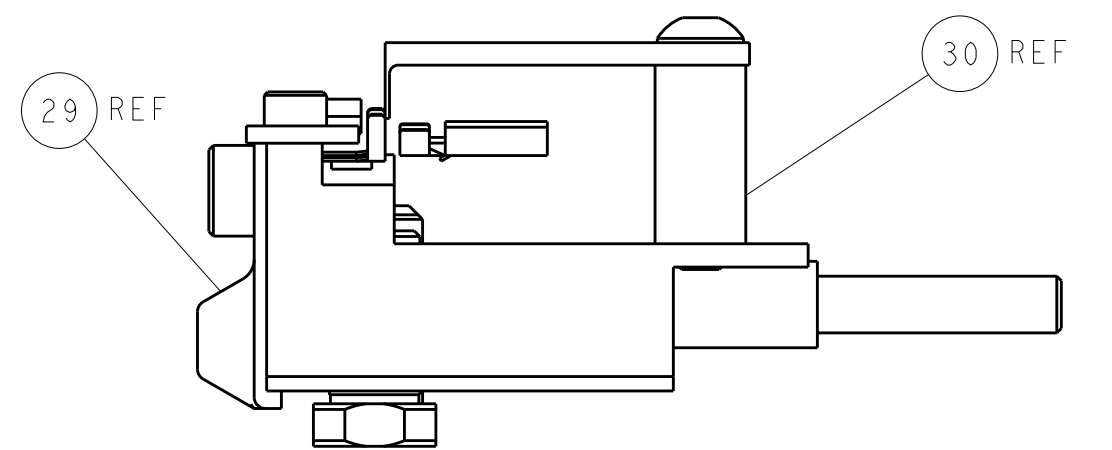
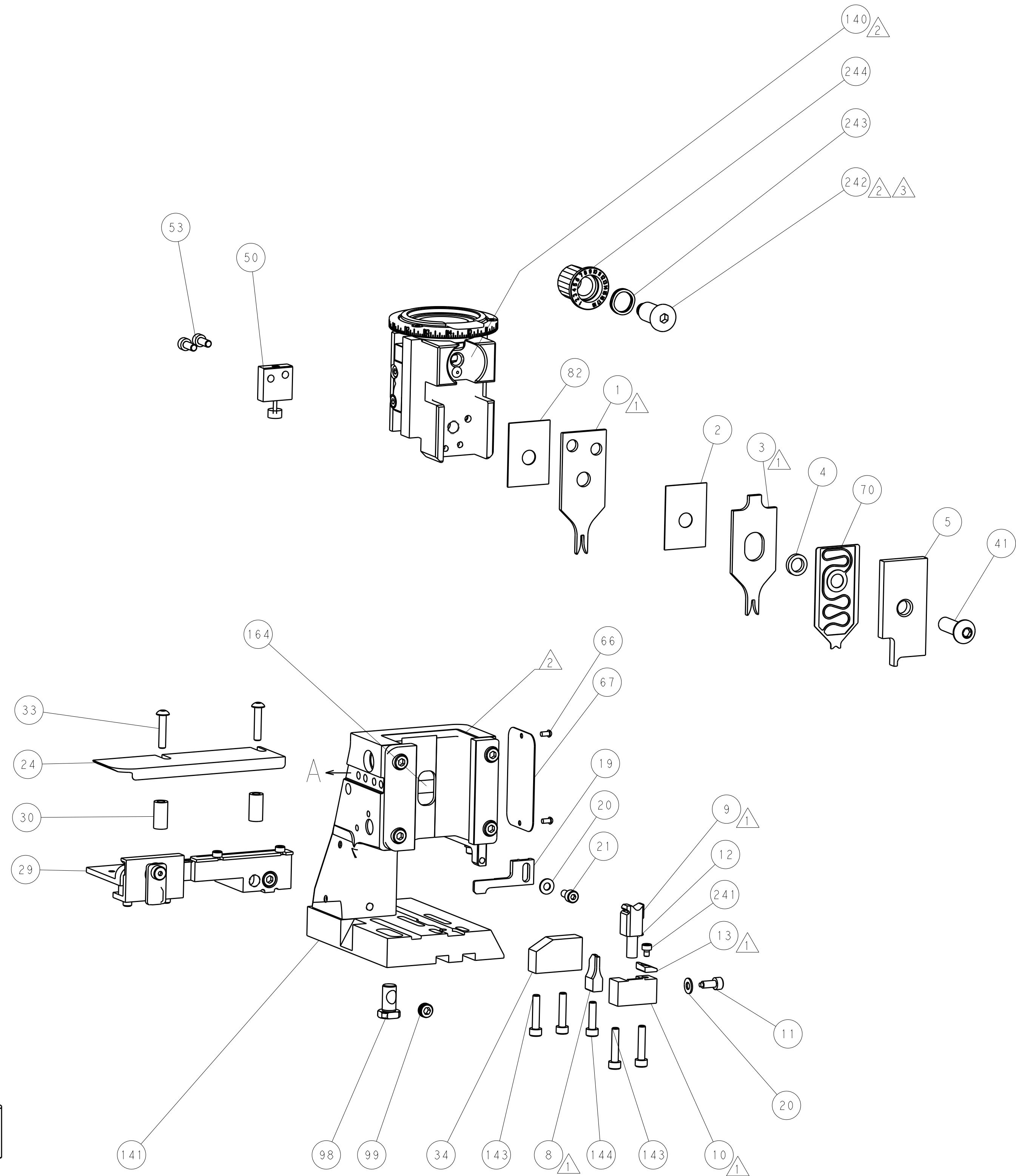
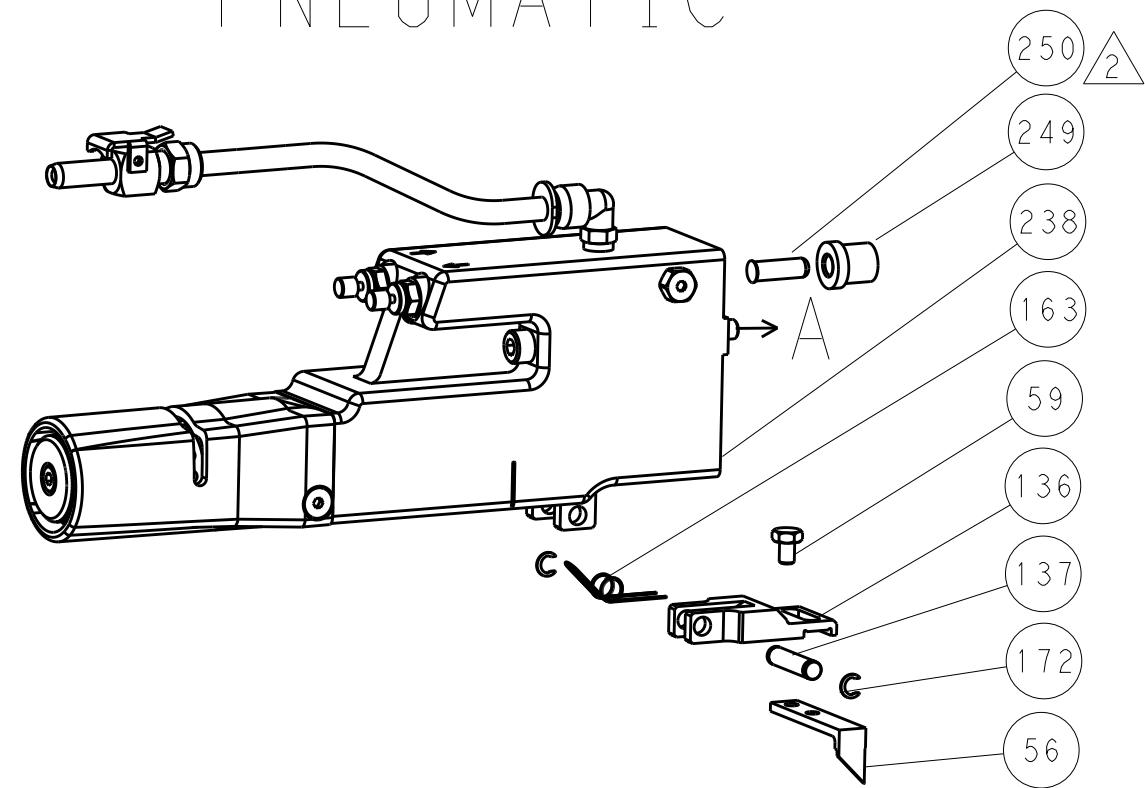
LOC	DIST	REVISIONS					
A	66	P	LTR	DESCRIPTION	DATE	DWN	APVD
			-	SEE SHEET 1	-	-	-

-	1	-	2119640-1	PUSH ROD, AIR FEED	250
-	1	-	1803259-1	BUSHING, FLANGED	249
-	1	1	2119082-2	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	-	2063440-1	AIR FEED MODULE	238
-	2	-	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172
-	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	1	-	240638-1	SPRING, FEED FINGER	163
-	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	-	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854	137
-	1	-	2119799-1	HOLDER,FEED FINGER, AF	136
-	1	1	2844908-1	SCREW, LOCKING	99
-	1	1	2844907-1	POST, LOCKING	98
-	1	1	455888-6	SPACER, CRIMPER	82
-	1	1	1803607-1	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	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	3-1752356-4	SUPPORT, TERMINAL	34
-	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	3-2844962-2	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	1803095-3	FLOATING SHEAR, FRONT -	9
1	1	1	1333203-9	ANVIL, COMBINATION	8
-	-	-	-	-	7
-	-	-	-	-	6
-	1	1	2119757-8	DEPRESSOR, SHEAR	5
-	1	1	238011-4	BLOCK, CRIMPER SPACER	4
1	1	1	1633988-2	CRIMPER, INSULATION BOX PREMIUM	3
-	1	1	455888-4	SPACER, CRIMPER	2
1	1	1	3-456404-2	CRIMPER, WIRE PREMIUM	1

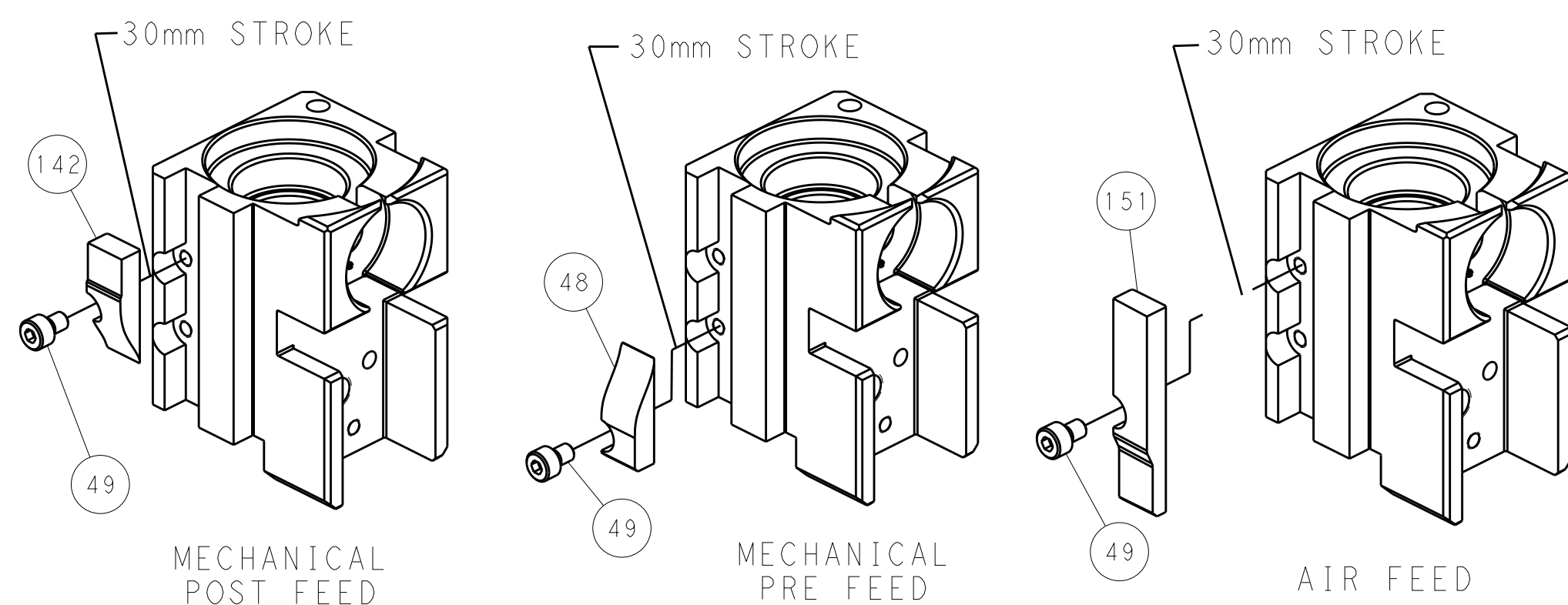
-77	-22	-21	PART NO	DESCRIPTION		ITEM NO
ALL PRODUCT ELECTRONIC CORPORATION 10000 WILSON ROAD LITETZ, NEBRASKA			OWN B. WEAVER	09NOV2011	 TE Connectivity Harrisburg, PA 17105-3608	
			CHK G. HOFFNER	09NOV2011		
			APVD T. ELBIN	09NOV2011		
			NAME			
TOLERANCES UNLESS OTHERWISE SPECIFIED:			PRODUCT SPEC		Ocean Side Feed Applicator	
			APPLICATION SPEC			
LC ±			SIZE		CAGE CODE	DRAWING NO
LC ±			A 00779			
LC ±			C=2151185			
LC ±						
LES ±			WEIGHT		RESTRICTED TO	
SH ±			Customer Accessible Production Drawing		REV E	
			SCALE		SHEET 3 OF 4	
			1:2			

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

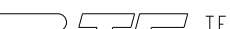
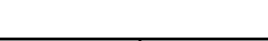
PNEUMATIC



CAM POSITIONS



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

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DIMENSIONS:		TOLERANCES, UNLESS OTHERWISE SPECIFIED:		NAME	
mm		0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		Ocean Side Feed Applicator	
		PRODUCT SPEC		SIZE CASE CODE DRAWING NO	
MATERIAL		FINISH		APPLICATION SPEC	
-		-		A1 00779 C=2151185	
WEIGHT		-		RESTRICTED TO	
-		-		-	
Customer Accessible Production Drawing				SCALE 1:2 SHEET 4 OF 4 REV E	