

8	7	6	5	4	3	2	1
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE				
2151345-1	E	FINE CRIMP HEIGHT ADJUST	MECHANICAL				
2151345-2	E	FINE CRIMP HEIGHT ADJUST	PNEUMATIC				
5-2151345-1	E	SEAL STRIPPER CRIMPER TERMINATING UNIT	MECHANICAL				
5-2151345-2	E	SEAL STRIPPER CRIMPER TERMINATING UNIT	PNEUMATIC				
7-2151345-1	E	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL				
7-2151345-2	E	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC				
7-2151345-7	A	CRIMP TOOLING KIT	-				

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.54 mm [.100]	F
INSUL	4.30 mm [.170]	O
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: 1.50mm CONTACT SOCKET			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
5.20-5.80 mm [.205-.228 IN]		Ø	
 TERMINAL APPLICATION SPECIFICATION	(A)114-18020	-	-
	(B)114-18040	-	-

TERMINALS APPLIED				SEAL INSULATION Ø RANGE
TE TERMINAL	TE TERMINAL	TE SEAL	TE SEAL	
(A) 929968-1	(B) 929990-1		(A) 828921-1	2.1-3.0
(A) 929968-7	(B) 929990-3		(A) 828921-2	2.1-3.0
(A) 929975-1	(B) 929990-4		(B) 828904-1	1.2-2.1
(A) 929975-4	(B) 929990-7		(B) 828904-2	1.2-2.1
(A) 929975-7	(B) 1-929990-0		(B) 828904-3	1.2-2.1
(A) 929975-8	(B) 1703014-1		(B) 828905-1	2.2-3.0
(B) 1703050-1	(B) 1703014-4			
(B) 1-1719188-0				

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
2.50mm2	1.97+/-0.03 [.078+/- .001]	5.1
2.00mm2	1.82+/-0.03 [.072+/- .001]	6.8
1.50mm2	1.67+/-0.03 [.066+/- .001]	8.5
16 AWG	1.58+/-0.03 [.062+/- .001]	9.6



- 1

RECOMMENDED SPARE PARTS
- 2

REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- 3

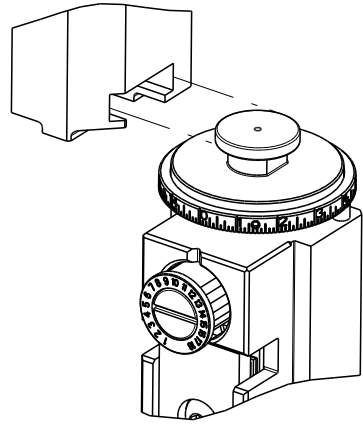
APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242. APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 180.
- 4

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.

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

ATLANTIC VERSION TERMINATOR
INTERFACE ADAPTER



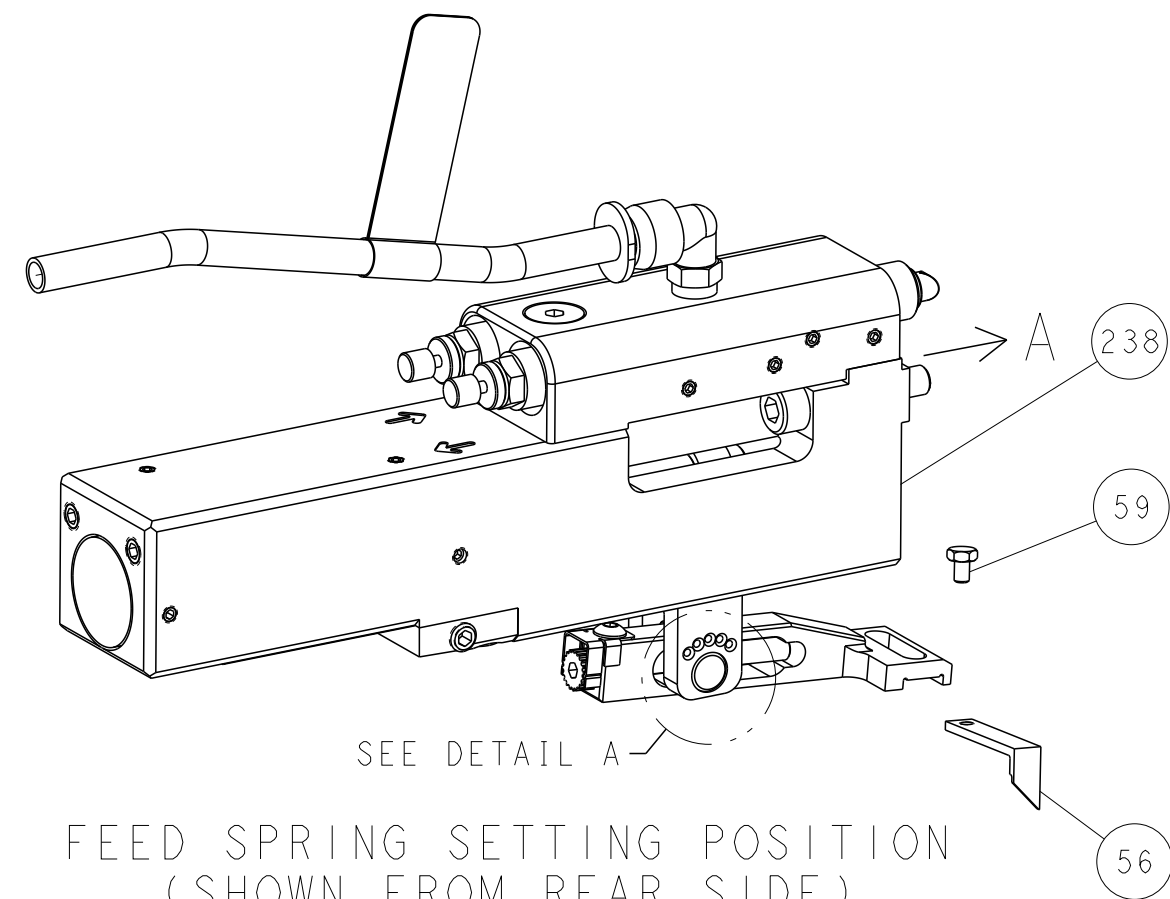
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

LOC	DIST	REVISIONS				
A	66	P	LTR	DESCRIPTION	DATE	DWN
			B1	ECR-15-017017	20NOV2015	JH
			C	ECR-18-011578	19JUL2018	TB
			D	ECR-19-009410	15JUN2019	TB
			E	ECR-19-010592	05JUL2019	TB

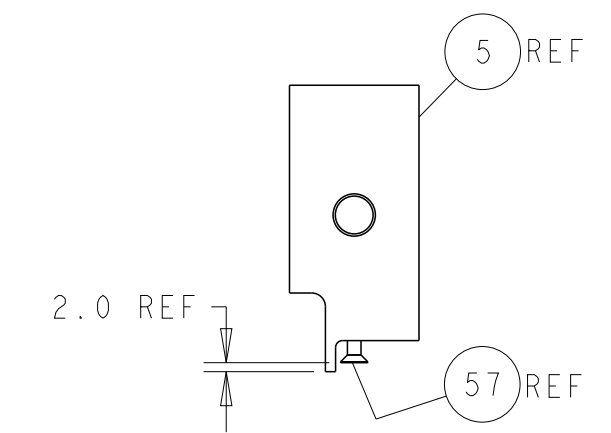
-	-	-	1	1	-	-	1803515-3	RAM ASSEMBLY, SF ATLANTIC	293
-	-	-	1	1	-	-	2-1803583-1	APPLICATOR BASIC ASSEMBLY, SF	292
-	1	-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248
-	1	1	1	1	1	1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	1	1	1	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
-	-	1	-	1	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	1	-	1	-	1	-	2844940-1	AIR FEED MODULE	238
-	-	-	1	1	-	-	4-1722335-3	STRIPPER, SIDE FEED	182
-	-	-	1	1	-	-	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	181
-	-	-	1	1	-	-	1-1752354-9	STANDOFF,HOLD-DOWN	180
-	-	-	1	1	-	-	9931111-1	PIN, SLOTTED SPRING 3.0 X 20.0	177
-	-	-	1	1	-	-	5-22280-0	SPRING, COMPRESSION	176
-	-	-	1	1	-	-	1752353-3	GUIDE PIN,HOLDDOWN	175
-	-	-	1	1	-	-	1901680-2	GUIDE PIN,HOLDDOWN	174
-	REF	REF	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	1	1	1	1	1	1	2844908-1	SCREW, LOCKING	99
-	1	1	1	1	1	1	2844907-1	POST, LOCKING	98
-	1	1	1	1	1	1	455888-5	SPACER, CRIMPER	82
-	1	1	1	1	1	1	1803607-3	DOCUMENTATION PACKAGE	71
-	1	1	1	1	1	1	2119791-9	DEPRESSOR, WIRE	70
-	1	1	1	1	1	1	2119943-1	WASHER, SPACER	69
-	1	1	1	1	1	1	2119740-1	TAG,IDENTIFICATION	67
-	2	2	2	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	1	1	1	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	60
-	1	1	1	1	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	1	1	1	1	1	1	985575-3	SCR, FLT SKT HD CAP M3 X 10.0	57
-	1	1	1	1	1	1	1338683-8	FEED PAWL	56
-	4	4	4	4	4	4	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	54
-	2	2	2	2	2	2	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	53
-	1	1	1	1	1	1	1803382-6	HOLD DOWN, SPRING LOADED	50
-	1	2	1	2	1	2	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	-	1	-	1	-	1	2119652-1	FEED CAM, PRE FEED	48
-	-	1	-	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	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
-	1	1	1	1	1	1	1752356-6	SUPPORT, TERMINAL	34
-	2	2	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	2	2	2	2	3-2844962-3	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	1	1	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29
-	1	1	1	1	1	1	455888-3	SPACER, CRIMPER	28
-	1	1	1	1	1	1	1320928-6	STRIP GUIDE	24
-	1	1	-	-	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
-	2	2	1	1	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	1	2119806-1	INSERT, SHEAR	13
-	1	1	1	1	1	1	3-22280-3	SPRING, COMPRESSION	12
-	1	1	1	1	1	1	1-356885-4	STOP, SHEAR	11
-	1	1	1	1	1	1	2119805-1	SHEAR HOLDER, FRONT	10
-	1	1	1	1	1	1	318707-1	FLOATING SHEAR, FRONT	9
1	2	2	1	1	1	1	1-1333206-6	ANVIL, COMBINATION .100	8
-	1	1	1	1	1	1	6-240641-5	SPACER	7
-	-	-	-	-	-	-	-	-	6
-	1	1	1	1	1	1	2119781-5	DEPRESSOR, SHEAR	5
-	1	1	1	1	1	1	2-238011-1	BLOCK, CRIMPER SPACER	4
1	2	2	1	1	1	1	1633996-8	CRIMPER, INSULATION SPECIAL	3
-	1	1	1	1	1	1	455888-6	SPACER, CRIMPER	2
1	2	2	1	1	1	1	456407-6	CRIMPER, WIRE PREMIUM	1

-77	-72	-71	-52	-51	-2	-1	PART NO	DESCRIPTION	ITEM NO
THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. THE USER SHALL BE RESPONSIBLE FOR OBTAINING THE LATEST EDITION.							DWN Y. YIN 09NOV2011	TE Connectivity Harrisburg, PA 17105-3608	
CHK G. BAILEY 09NOV2011							APVD S. XI 09NOV2011	NAME Ocean Side Feed Applicator	
DIMENSIONS: mm							PRODUCT SPEC	SIZE CASE CODE DRAWING NO	
TOLERANCES UNLESS OTHERWISE SPECIFIED:							APPLICATION SPEC	RESTRICTED TO	
0 PLC ±							1 PLC ±	A1 00779 ©=2151345	
2 PLC ±							3 PLC ±	CUSTOMER ACCESSIBLE PRODUCTION DRAWING	
4 PLC ±							ANGLES FINISH	SCALE 1:2	
MATERIAL							WEIGHT	SHEET 1 OF 4	
								REV E	

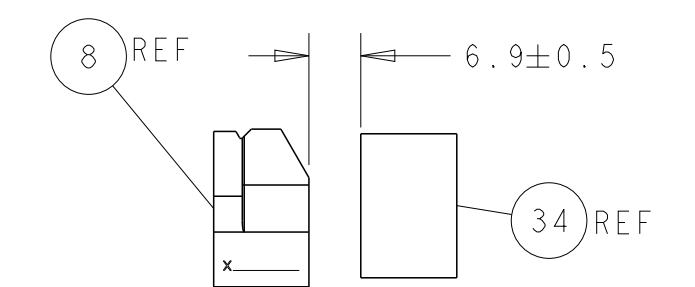
PNEUMATIC



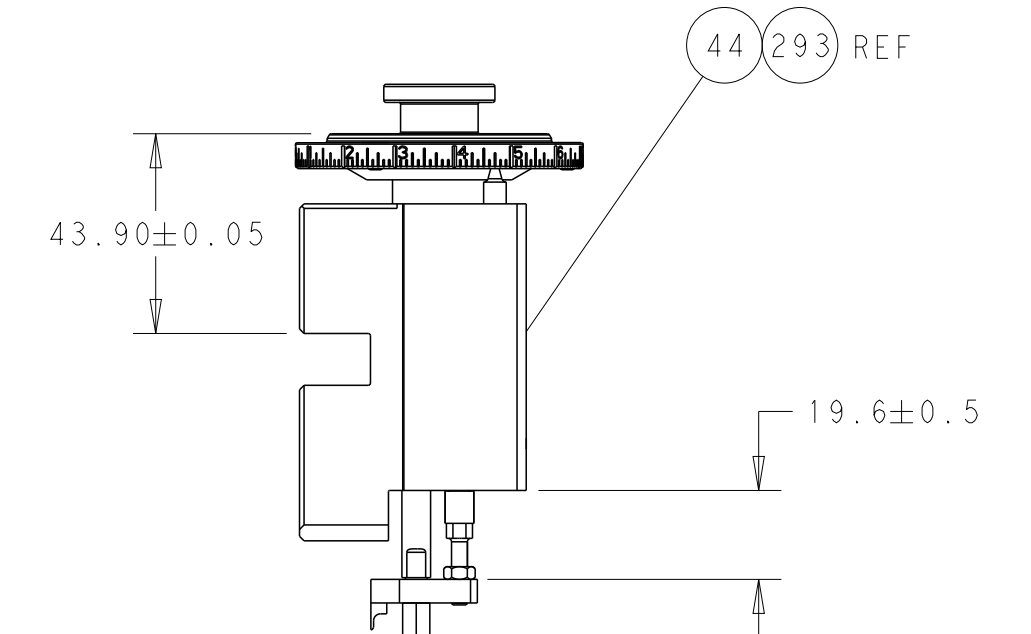
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)



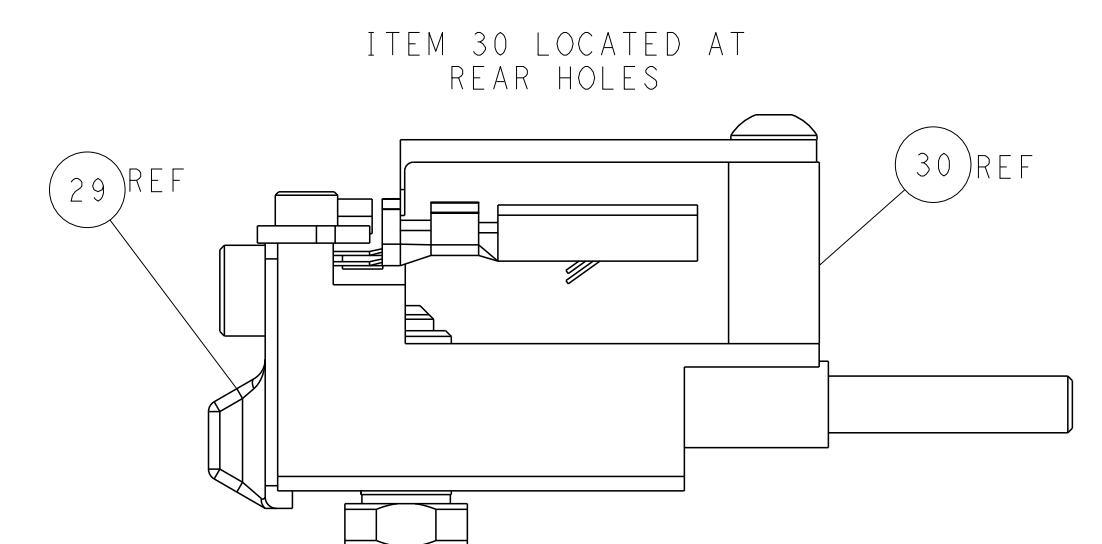
SHEAR DEPRESSOR DETAIL



TERMINAL SUPPORT LOCATION



RAM SET-UP

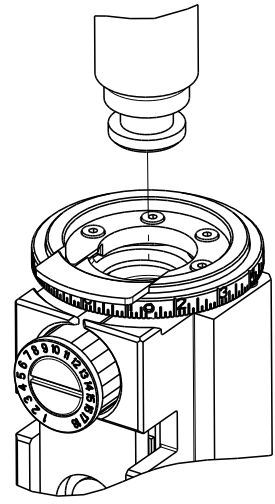


FEED TRACK POSITION
GUIDE BY INSULATION BARREL

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DIMENSIONS:		CHK G. BAILEY 09NOV2011			
TOLERANCES UNLESS OTHERWISE SPECIFIED:		APV S.XI 09NOV2011		NAME Ocean Side Feed Applicator	
mm		PRODUCT SPEC			
		APPLICATION SPEC -		SIZE A	
MATERIAL		WEIGHT		CAGE CODE 00779	
FINISH		ANGLES		DRAWING NO C=2151345	
-		-		RESTRICTED TO 1 OF 4	
-		-		SCALE 1:2	
-		-		SHEET 2 OF 4	
-		-		REV F	
CUSTOMER ACCESSIBLE PRODUCTION DRAWING					

8		7	
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20		20	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2151345-1	E	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2151345-2	E	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151345-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.54 mm [.100]	F
INSUL	4.30 mm [.170]	O
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: 1.50mm CONTACT SOCKET			
WIRE STRIP LENGTH 5.20-5.80 mm [.205-.228 IN]			INSULATION DIAMETER RANGE Ø
 TERMINAL APPLICATION SPECIFICATION	(A)114-18020	-	-
	(B)114-18040	-	-

TERMINALS APPLIED				SEAL INSULATION Ø RANGE
TE TERMINAL	TE TERMINAL	TE SEAL	TE SEAL	
(A) 929968-1	(B) 929990-1		(A) 828921-1	2.1-3.0
(A) 929968-7	(B) 929990-3		(A) 828921-2	2.1-3.0
(A) 929975-1	(B) 929990-4		(B) 828904-1	1.2-2.1
(A) 929975-4	(B) 929990-7		(B) 828904-2	1.2-2.1
(A) 929975-7	(B) 1-929990-0		(B) 828904-3	1.2-2.1
(A) 929975-8	(B) 1703014-1		(B) 828905-1	2.2-3.0
(B) 1703050-1	(B) 1703014-4			
(B) 1-1719188-0				

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
2.50mm2	1.97+/-0.03 [.078+/- .001]	5.1
2.00mm2	1.82+/-0.03 [.072+/- .001]	6.8
1.50mm2	1.67+/-0.03 [.066+/- .001]	8.5
16 AWG	1.58+/-0.03 [.062+/- .001]	9.6



- 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. 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	2119082-9	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	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	2119791-9	DEPRESSOR, WIRE	70
-	1	1	2119943-1	WASHER, SPACER	69
-	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
5	-	1	985575-3	SCR, FLT SKT HD CAP M3 X 10.0	57
-	1	1	1338683-8	FEED PAWL	56
-	2	2	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	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	1752356-6	SUPPORT, TERMINAL	34
-	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	3-2844962-3	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29
-	1	1	455888-3	SPACER, CRIMPER	28
-	1	1	1320928-6	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	318707-1	FLOATING SHEAR, FRONT	9
1	1	1	1-1333206-6	ANVIL, COMBINATION .100	8
-	1	1	6-240641-5	SPACER	7
-	-	-	-	-	6
-	1	1	2119781-5	DEPRESSOR, SHEAR	5
-	1	1	2-238011-1	BLOCK, CRIMPER SPACER	4
1	1	1	1633996-8	CRIMPER, INSULATION SPECIAL	3
-	1	1	455888-6	SPACER, CRIMPER	2
1	1	1	456407-6	CRIMPER, WIRE PREMIUM	1

-77-22-21			PART NO		DESCRIPTION				ITEM NO			
DOCUMENT FOR THE TWO ELECTRONICS CORPORATION FOR THE USE OF THE CUSTOMER. THIS DOCUMENT IS NOT TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, INCLUDING PHOTOCOPYING, RECORDING, OR BY ANY INFORMATION STORAGE AND RETRIEVAL SYSTEM, WITHOUT THE WRITTEN PERMISSION OF THE TWO ELECTRONICS CORPORATION.			OWN Y. YIN		09NOV2011		 TE Connectivity Harrisburg, PA 17105-3608					
			CHK G. BAILEY		09NOV2011							
			APVD S. XI		09NOV2011		NAME					
TOLERANCES UNLESS OTHERWISE SPECIFIED:			PRODUCT SPEC		Ocean Side Feed							
			-		Applicator							
			-		-							
			APPLICATION SPEC									
			-									
0 PLC ±					SIZE		CAGE CODE		DRAWING NO		RESTRICTED TO	
1 PLC ±												
2 PLC ±												
3 PLC ±												
4 PLC ±												
ANGLES ±												
FINISH					A1		00779		C=2151345			

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

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

D

C

B

A

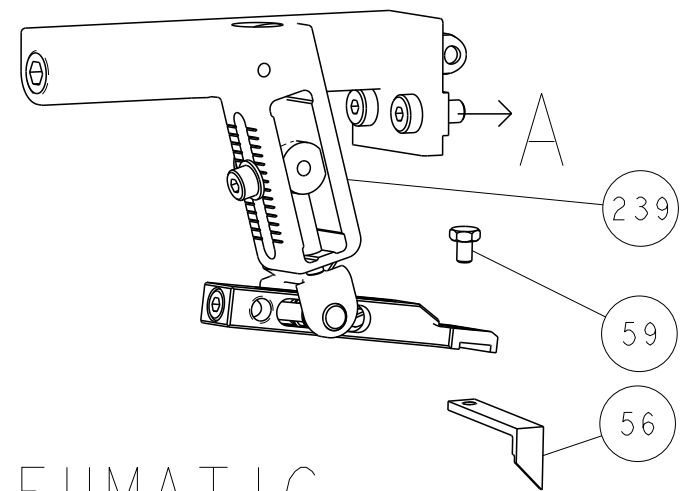
D

C

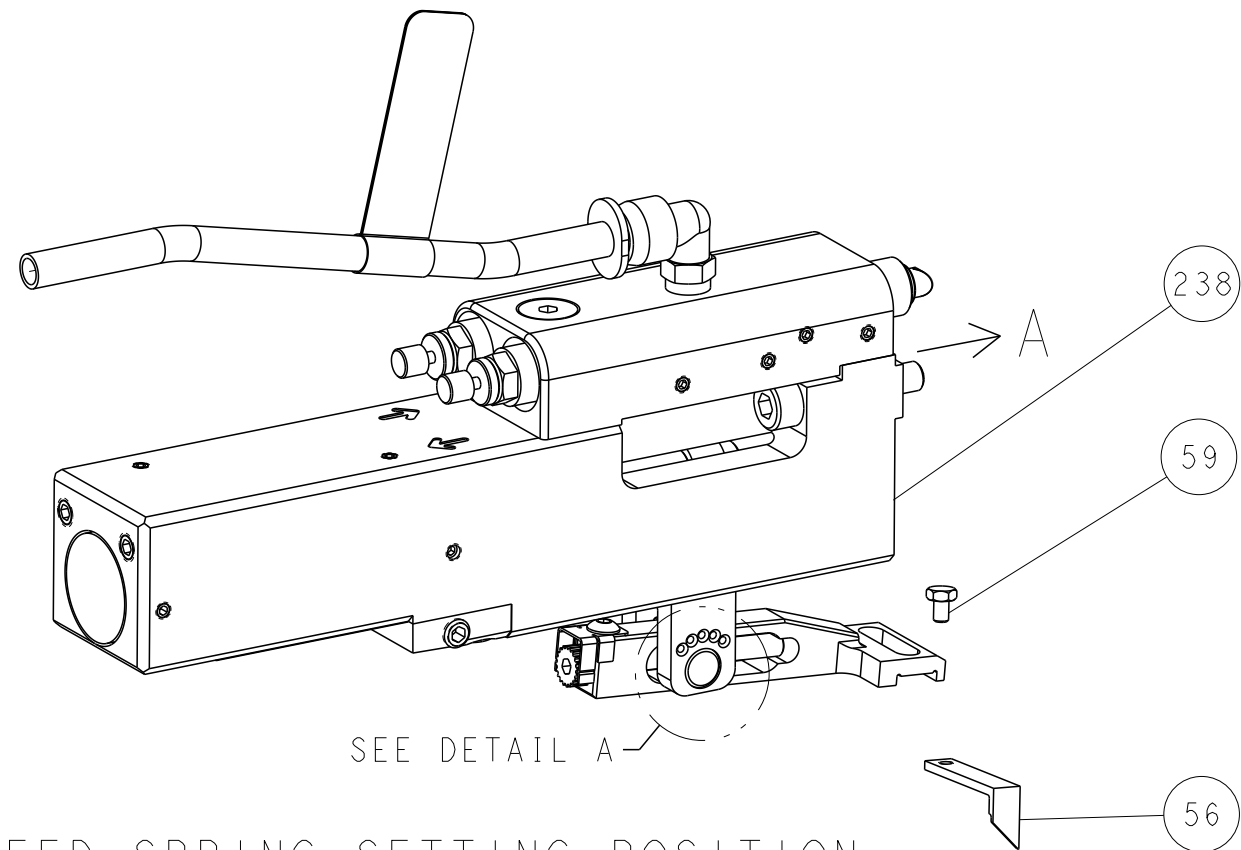
B

A

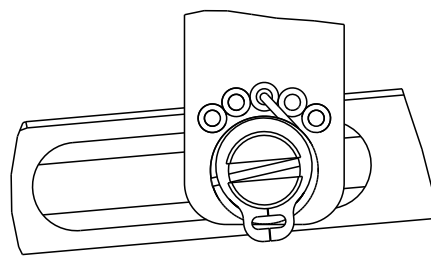
FEED TYPE MECHANICAL



PNEUMATIC

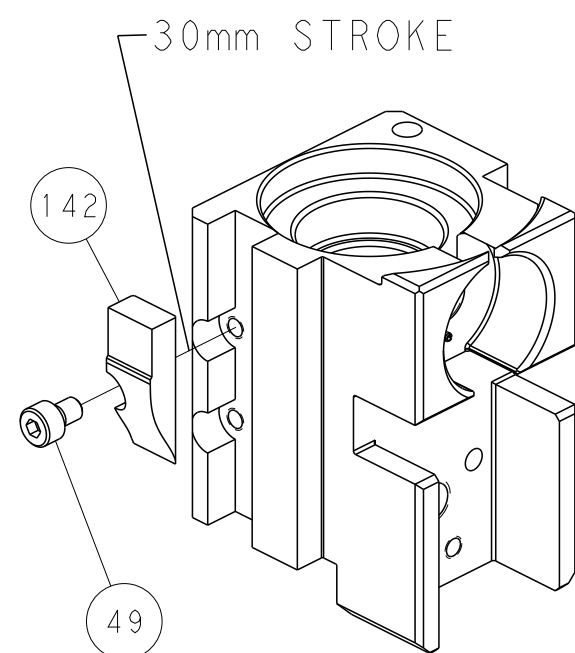


FEED SPRING SETTING POSITION
(SHOWN FROM REAR SIDE)

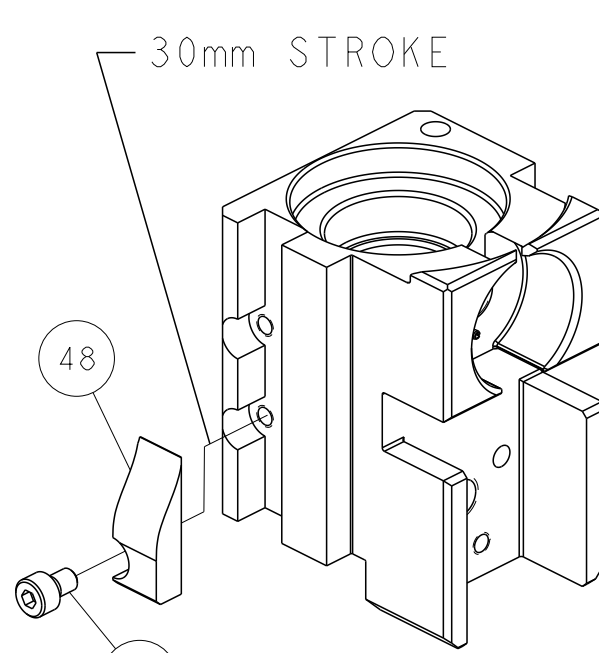


DETAIL A

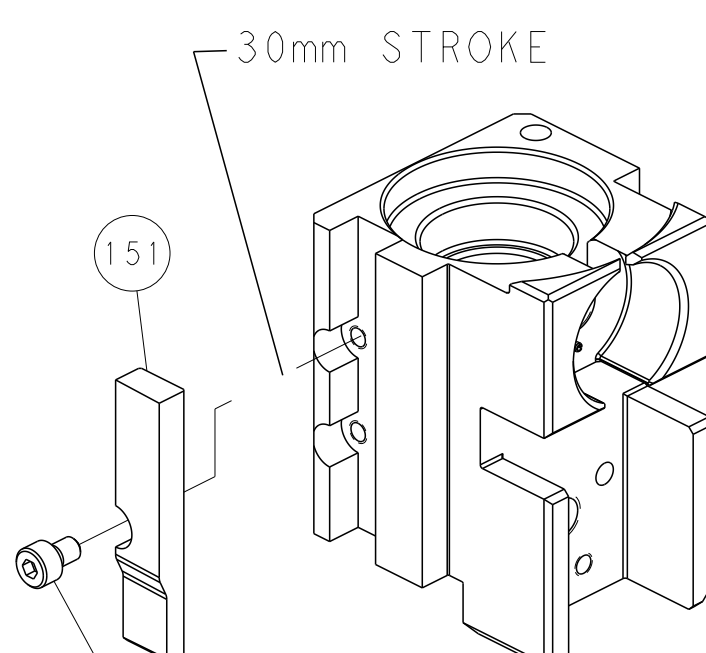
CAM POSITIONS



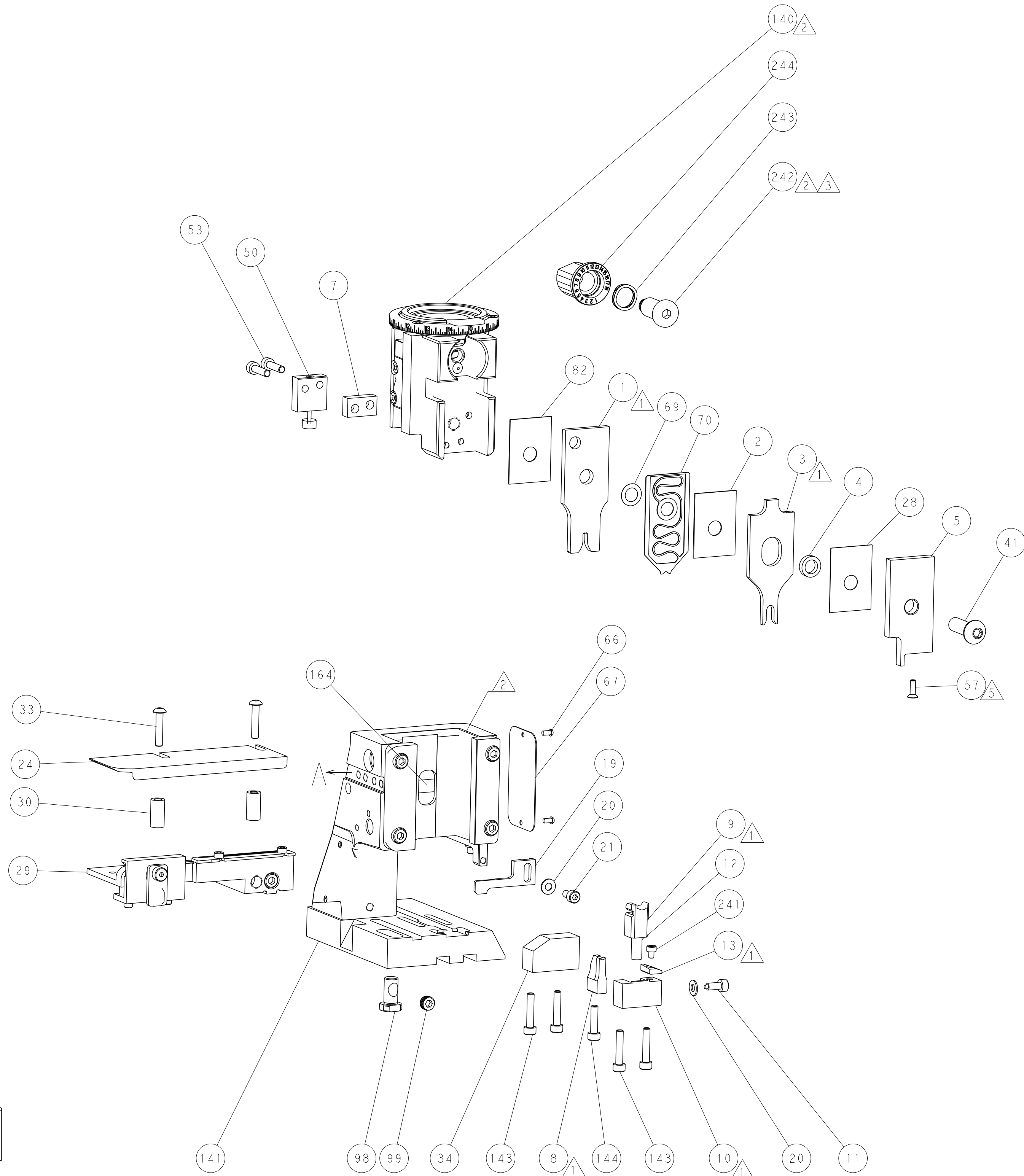
MECHANICAL
POST FEED



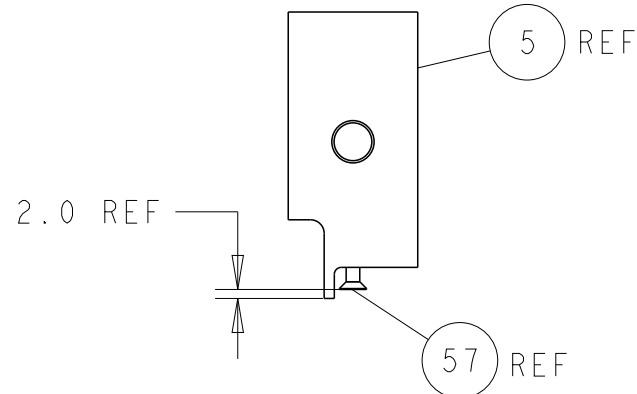
MECHANICAL
PRE FEED



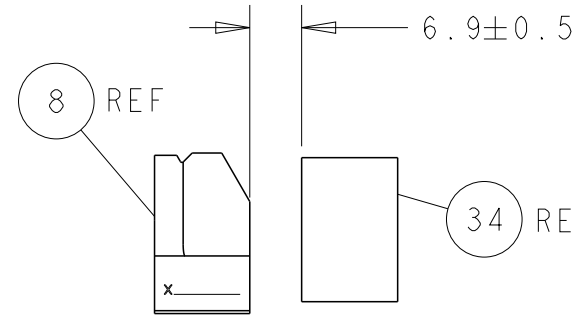
AIR FEED



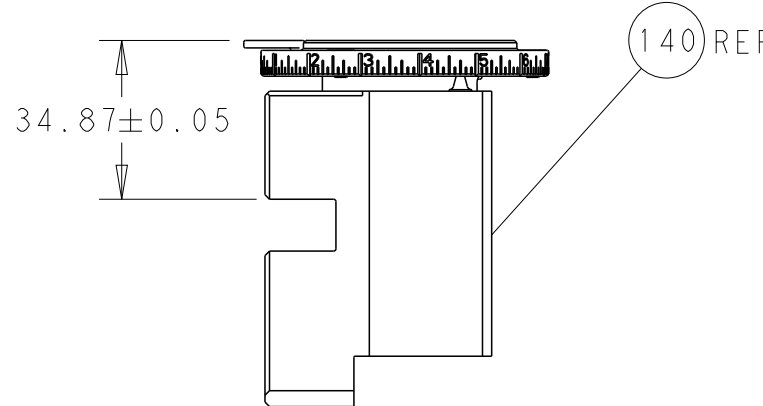
PACIFIC VERSION
Shown on sheets 3 of 4 & 4 of 4
(Atlantic version shown on sheets 1 of 4 & 2 of 4)



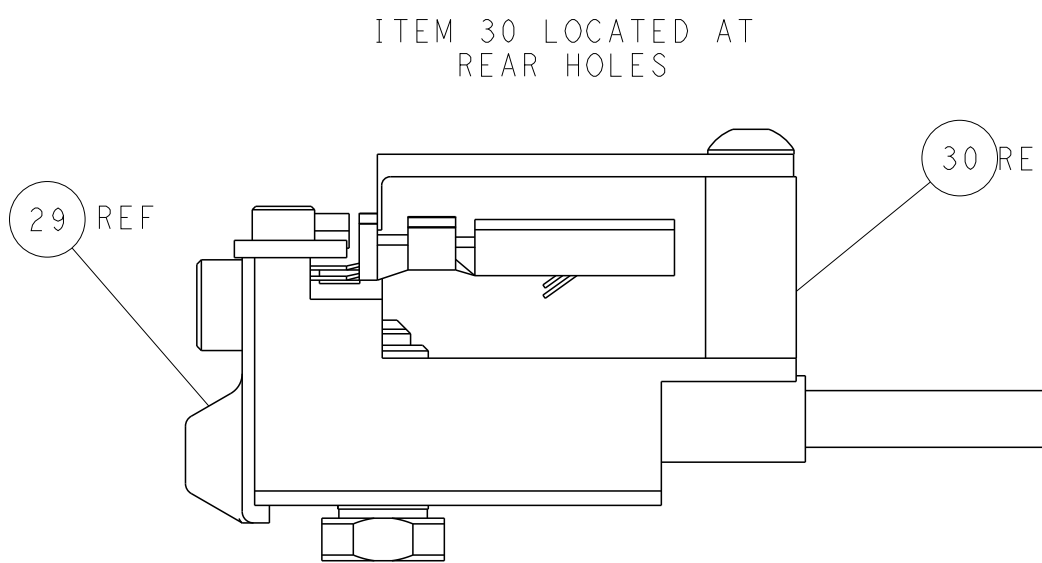
SHEAR DEPRESSOR DETAIL



TERMINAL SUPPORT LOCATION



RAM SET-UP



FEED TRACK POSITION
GUIDE BY INSULATION BARREL

THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. THE USER SHALL BE RESPONSIBLE FOR THE LATEST VERSION.		DWN Y. YIN	09NOV2011	 TE Connectivity Harrisburg, PA 17105-3608	
CHK G. BAILEY		09NOV2011	NAME		
APVD S. XI		09NOV2011	PRODUCT SPEC	Ocean Side Feed Applicator	
			APPLICATION SPEC		
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		SIZE A1	CAGE CODE 00779
		0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH ±		DRAWING NO C=2151345	RESTRICTED TO REV E
MATERIAL -		WEIGHT -		CUSTOMER ACCESSIBLE PRODUCTION DRAWING	
		SCALE 1:2		SHEET 4	OF 4