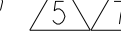


8	7
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RELEASED FOR PUBLICATION	
20	
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PART NUMBER	REVISION
2151437-1	D
2151437-2	E
7-2151437-1	D
7-2151437-2	E
7-2151437-7	C
DESCRIPTION	
FEED TYPE	
FINE CRIMP HEIGHT ADJUST	
MECHANICAL	
FINE CRIMP HEIGHT ADJUST	
PNEUMATIC	
MECHANICAL AND CRIMP TOOLING KIT	
MECHANICAL	
PNEUMATIC AND CRIMP TOOLING KIT	
PNEUMATIC	
CRIMP TOOLING KIT	
-	

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.40 mm [.055]	F
INSUL	1.40 mm [.055]	OV
APPLICATOR INSTRUCTIONS		
408-35042		

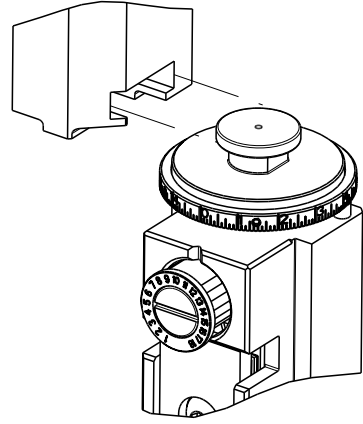
TERMINAL DATA: SUMITOMO TERMINAL		SUMITOMO CRIMP SPECIFICATION	
TERMINAL NAME: 0.64 UNSEALED TERMINAL, L			
WIRE STRIP LENGTH			INSULATION DIAMETER RANGE
4.00-4.50 mm [.157-.177 IN]			Ø 1.78mm MAX [.070 IN MAX]
TERMINAL APPLICATION SPECIFICATION		(A)COMP06001486 Rev T--272-A	
		-	
TERMINALS APPLIED			
TE TERMINAL	SUMITOMO TERMINAL	TE TERMINAL	SUMITOMO TERMINAL
(A) 1832148-1	(A) 8100-3623	(A) 1832152-1	(A) 8100-3625

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.50mm2	1.05+/-0.05 [.041+/- .002]	8.9
0.30mm2	0.95+/-0.05 [.037+/- .002]	9.5



- 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 TERMINAL LUBRICANT IS RECOMMENDED.
6. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- 1 FEED ADJUSTMENTS MAY BE REQUIRED WHEN SWITCHING TERMINALS.

ATLANTIC VERSION TERMINATOR
INTERFACE ADAPTER



TERMINAL DATA: SUMITOMO TERMINAL		SUMITOMO CRIMP SPECIFICATION	
TERMINAL NAME: 0.64 UNSEALED TERMINAL, M			
WIRE STRIP LENGTH			INSULATION DIAMETER RANGE
4.00-4.50 mm [.157-.177 IN]		Ø 1.00-1.40mm [.039-.055 IN]	
TERMINAL APPLICATION SPECIFICATION			
 (B) COMP06001486 Rev T-272E-D			
TERMINALS APPLIED  			
TE TERMINAL	SUMITOMO TERMINAL	TE TERMINAL	SUMITOMO TERMINAL
(B) 2318384-1	(B) 8100-3624	(B) 1949379-1	(B) 8100-3622
(B) 2318384-2	(B) 8100-3628	(B) 1949379-2	(B) 8100-3626

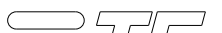
WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.35mm2	0.90+/-0.05 [.035+/- .002]	8.8
0.22mm2	0.80+/-0.05 [.031+/- .002]	10.0

*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)

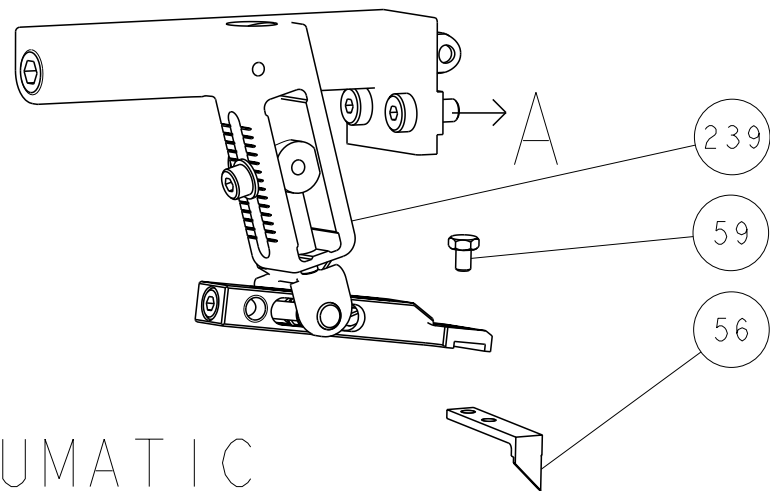
LOC	DIST	REVISIONS				
A	66	P	LYR	DESCRIPTION	DATE	DWN
						APVD
		C		ECR-17-016318	06NOV2017	TB
		C1		ECR-18-000654	17JAN2018	YY
		D		ECR-18-007061	08MAY2018	TB
		E		ECR-19-017903	19NOV2019	FJ

	-	1	-	1		2119641-1	FEED CAM, AIR FEED	248
	-	1	1	1	1	2119082-4	CAM, SNAIL, INSULATION ADJUSTMENT	244
	-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
3	-	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	-	2844940-1	AIR FEED MODULE	238
	-	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
5	-	1	1	1	1	1-18028-2	WASHER, FLAT, REG M4	119
	-	1	1	1	1	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113
	-	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	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	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	53
	-	1	1	1	1	1803382-1	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	1752356-3	SUPPORT, TERMINAL	34
	-	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
	-	2	2	2	2	2-2844962-4	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
	-	1	1	1	1	1-18028-2	WASHER, FLAT, REG M4	20
1	-	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	1	2119805-1	SHEAR HOLDER, FRONT	10
1	-	1	1	1	1	1803095-3	FLOATING SHEAR, FRONT -	9
1	1	2	2	1	1	7-1633139-5	ANVIL, COMBINATION	8
	-	1	1	1	1	5-240641-2	SPACER	7
	-	-	-	-	-	-	-	6
	-	1	1	1	1	2119757-4	DEPRESSOR, SHEAR	5
	-	1	1	1	1	238011-4	BLOCK, CRIMPER SPACER	4
1	1	2	2	1	1	4-16333964-6	CRIMPER, INSULATION OVERLAP PREMIUM	3
	-	-	-	-	-	-	-	2
1	1	2	2	1	1	6-1333281-9	CRIMPER, WIRE PREMIUM	1
	-77	-72	-71	-2	-1	PART NO	DESCRIPTION	ITEM NO

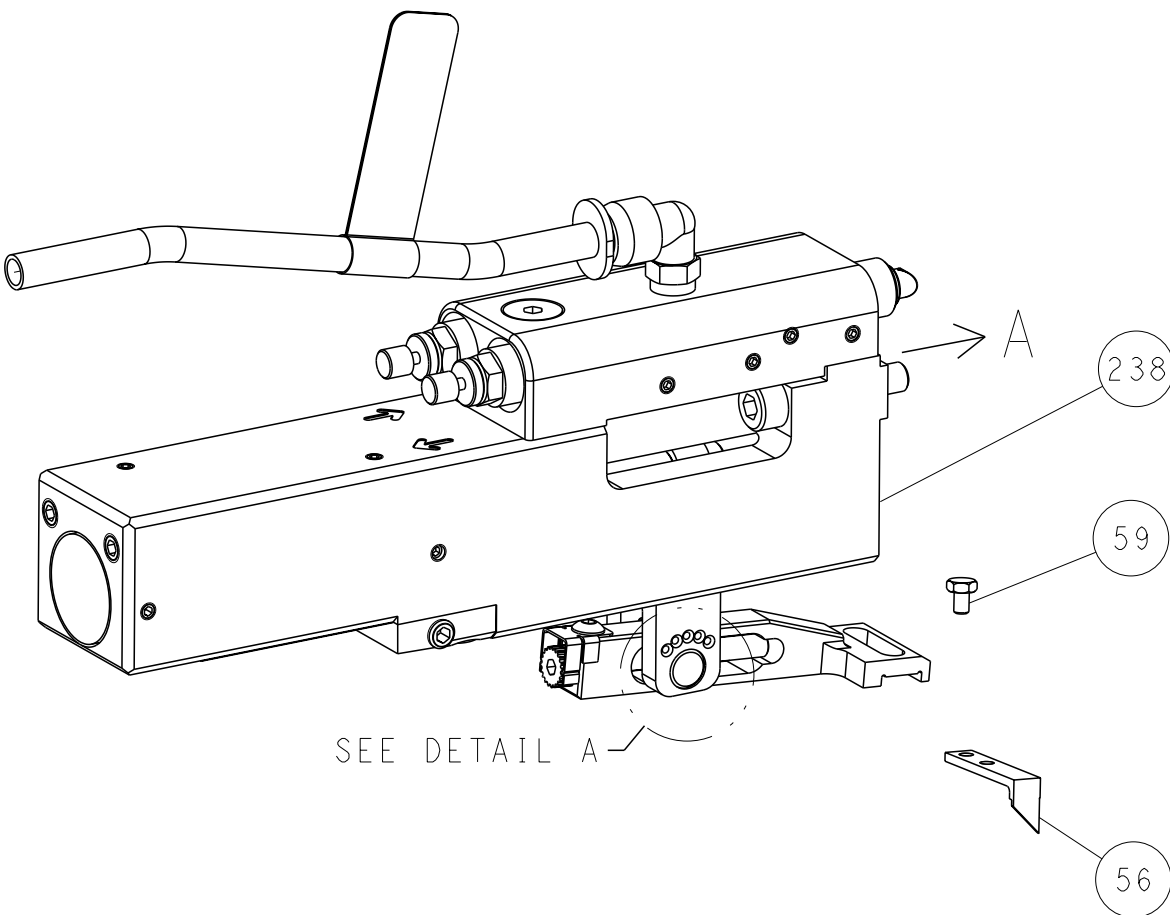
THIS DRAWING IS A CONTROLLED DOCUMENT FOR TFCO ELECTRONICS CORPORATION IT IS SUBJECT TO CHANGE AND TO BE CONTROLLED BY THE ENGINEERING ORGANIZATION IT SHOULD BE CONTACTED FOR THE LATEST REVISION.				DWN K. HUANG CHK -	17MAY2012 -	 TE Connectivity Harrisburg, PA 17105-3608				
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		APVD S. XI	17MAY2012	NAME	Ocean Side Feed Applicator			
mm				PRODUCT SPEC						
		0 PLC ±		APPLICATION SPEC						
		1 PLC ±								
		2 PLC ±								
		3 PLC ±								
		4 PLC ±								
ANGLES		±								
FINISH				WEIGHT		-				SIZE
MATERIAL							A1	00779	C=2151437	-
Customer Accessible Production Drawing						SCALE	1:2	SHEET	1 of 4	REV E

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

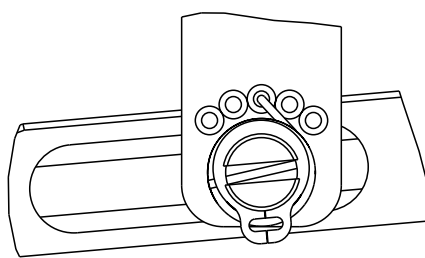
FEED TYPE MECHANICAL



PNEUMATIC

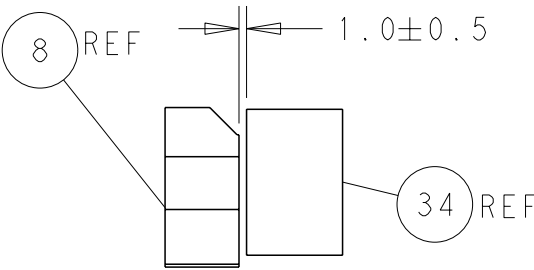
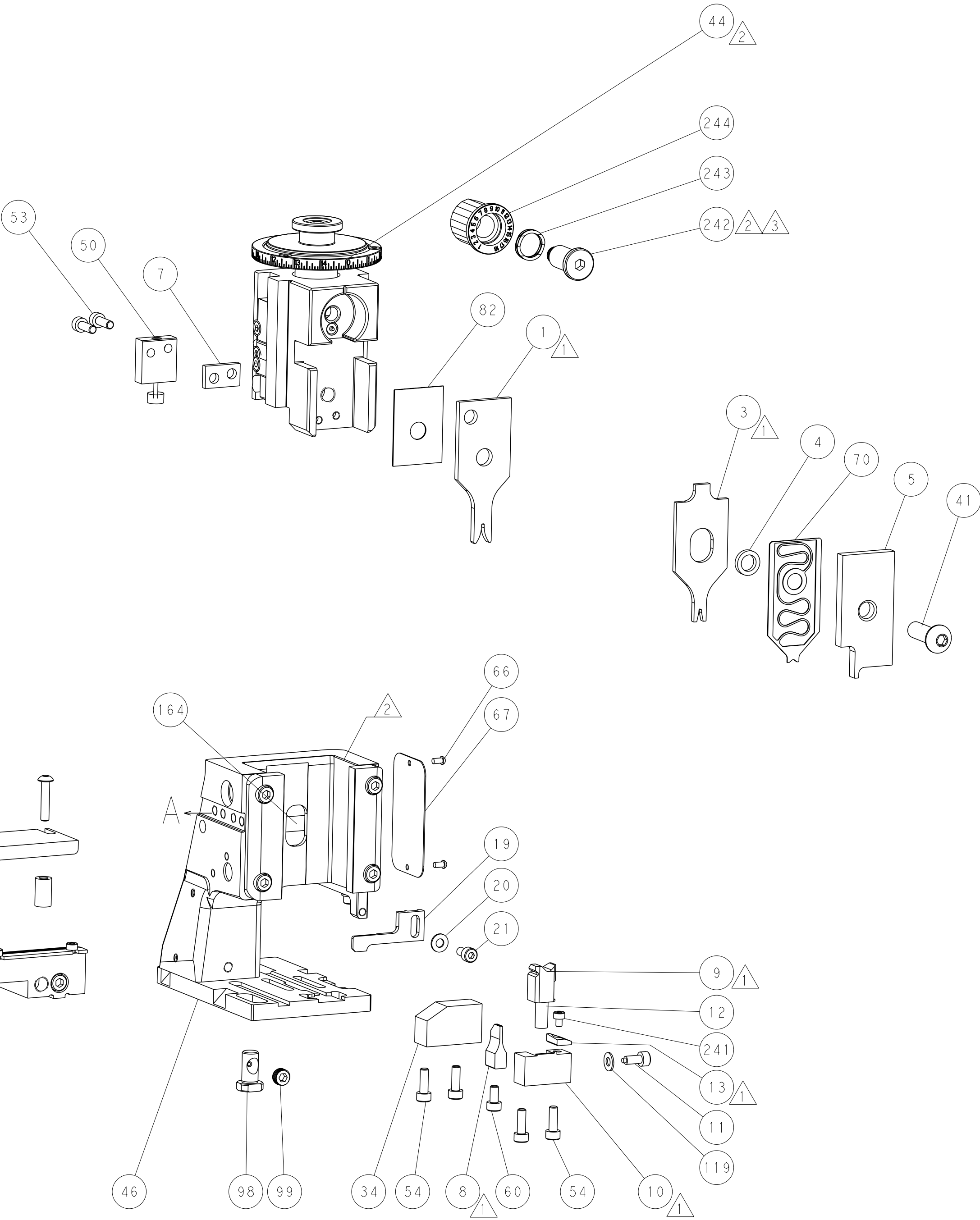
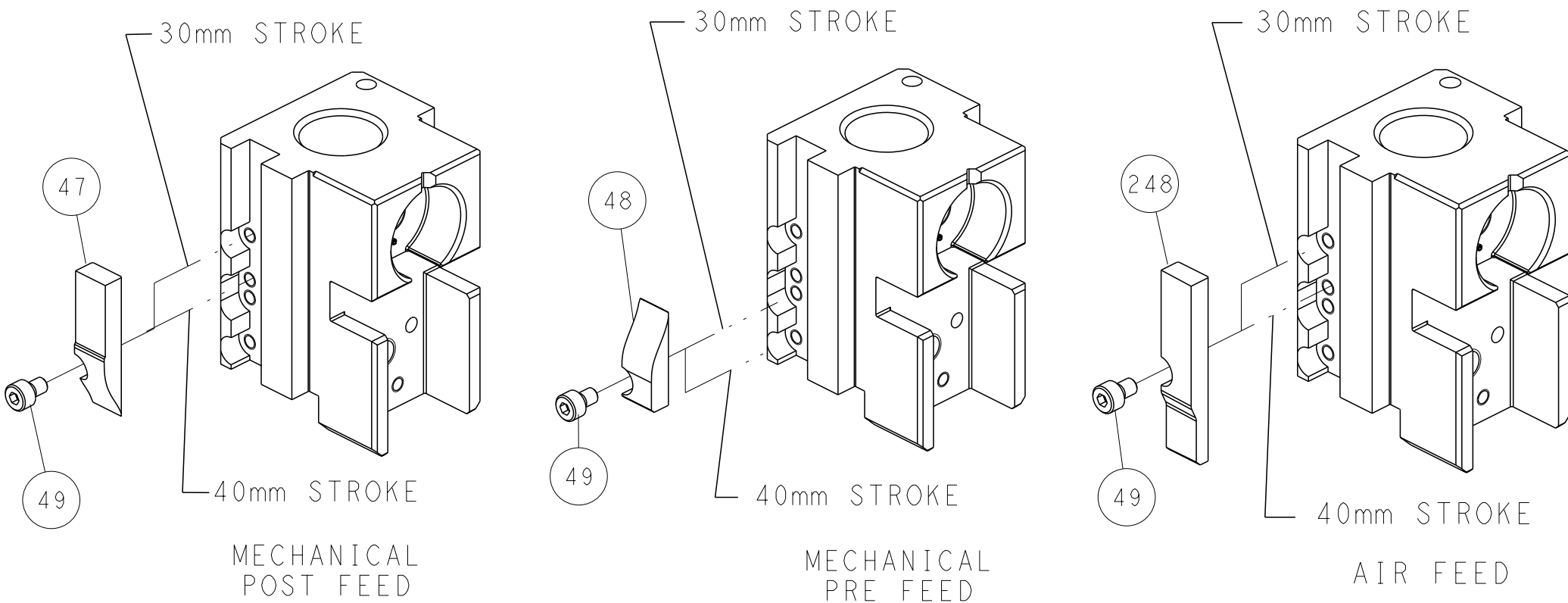


FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)

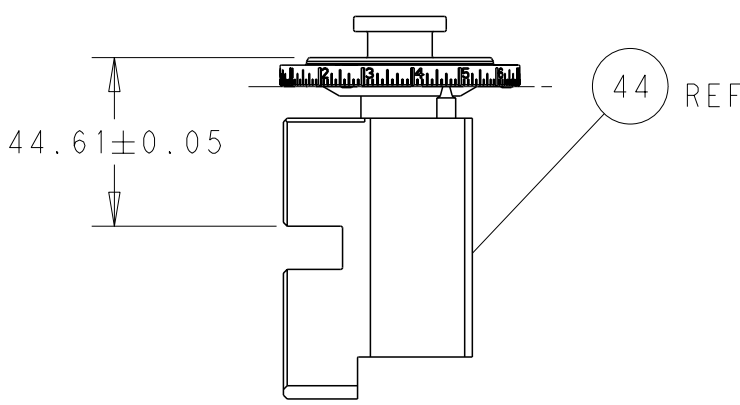


DETAIL A

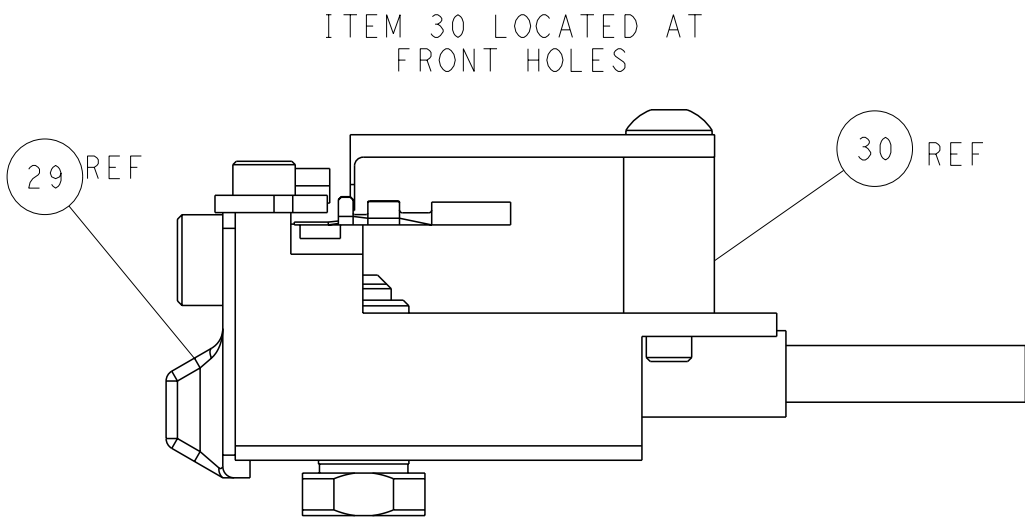
CAM POSITIONS



TERMINAL SUPPORT LOCATION



RAM SET-UP



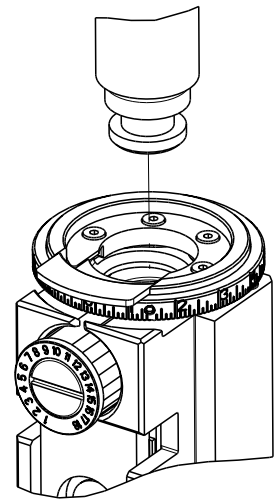
FEED TRACK POSITION
GUIDE BY INSULATION BARREL

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

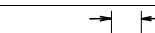
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DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		CHK -	-		NAME	Ocean Side Feed Applicator							
		0 PLC	±	APVD S. XI	17MAY2012	PRODUCT SPEC		-							
		1 PLC	±	APPLICATION SPEC		-		-							
		2 PLC	±	SIZE		CAGE CODE	DRAWING NO	RESTRICTED TO							
		3 PLC	±	A		00779	©=2151437	-							
MATERIAL -		4 PLC	±	WEIGHT -		Customer Accessible Production Drawing		SCALE	1:2	SHEET	2	OF	4	REV	E
		ANGLES	±												
		FINISH	-												

8		7	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2151437-1	D	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2151437-2	E	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151437-7	C	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.40 mm [.055]	F
INSUL	1.40 mm [.055]	OV
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: SUMITOMO TERMINAL SUMITOMO CRIMP SPECIFICATION			
TERMINAL NAME: 0.64 UNSEALED TERMINAL, L			
WIRE STRIP LENGTH 4.00-4.50 mm [.157-.177 IN]		 INSULATION DIAMETER RANGE Ø 1.78mm MAX [.070 IN MAX]	
TERMINAL APPLICATION SPECIFICATION (A)COMP06001486 Rev T--272-A		-	
		-	
TERMINALS APPLIED  			
TE TERMINAL (A) 1832148-1	SUMITOMO TERMINAL (A) 8100-3623	TE TERMINAL (A) 1832152-1	SUMITOMO TERMINAL (A) 8100-3625

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.50mm2	1.05+/-0.05 [.041+/- .002]	8.9
0.30mm2	0.95+/-0.05 [.037+/- .002]	9.5

TERMINAL DATA: SUMITOMO TERMINAL		SUMITOMO CRIMP SPECIFICATION	
TERMINAL NAME: 0.64 UNSEALED TERMINAL, M			
WIRE STRIP LENGTH			INSULATION DIAMETER RANGE
4.00-4.50 mm [.157-.177 IN]			Ø 1.00-1.40mm [.039-.055 IN]
TERMINAL APPLICATION SPECIFICATION		COMP06001486 Rev T--272E-D	
			
TERMINALS APPLIED  			
TE TERMINAL	SUMITOMO TERMINAL	TE TERMINAL	SUMITOMO TERMINAL
2318384-1	8100-3624	1949379-1	8100-3622
2318384-2	8100-3628	1949379-2	8100-3626

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.35mm2	0.90+/-0.05 [.035+/- .002]	8.8
0.22mm2	0.80+/-0.05 [.031+/- .002]	10.0

*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.

LOC	DIST	REVISONS			
A	66	P	LYR	DESCRIPTION	DATE
		-		SEE SHEET 1	-

-	1	1	2119082-4	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	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113
-	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	2119791-5	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	1803382-1	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	1752356-3	SUPPORT, TERMINAL	34
-	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	2-2844962-4	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
-	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	1803095-3	FLOATING SHEAR, FRONT -	9
-	1	1	7-1633139-5	ANVIL, COMBINATION	8
-	1	1	5-240641-2	SPACER	7
-	-	-	-	-	6
-	1	1	2119757-4	DEPRESSOR, SHEAR	5
-	1	1	238011-4	BLOCK, CRIMPER SPACER	4
-	1	1	4-1633964-6	CRIMPER, INSULATION OVERLAP PREMIUM	3
-	-	-	-	-	2
-	1	1	6-1333281-9	CRIMPER, WIRE PREMIUM	1
-77	-22	-21	PART NO	DESCRIPTION	ITEM NO



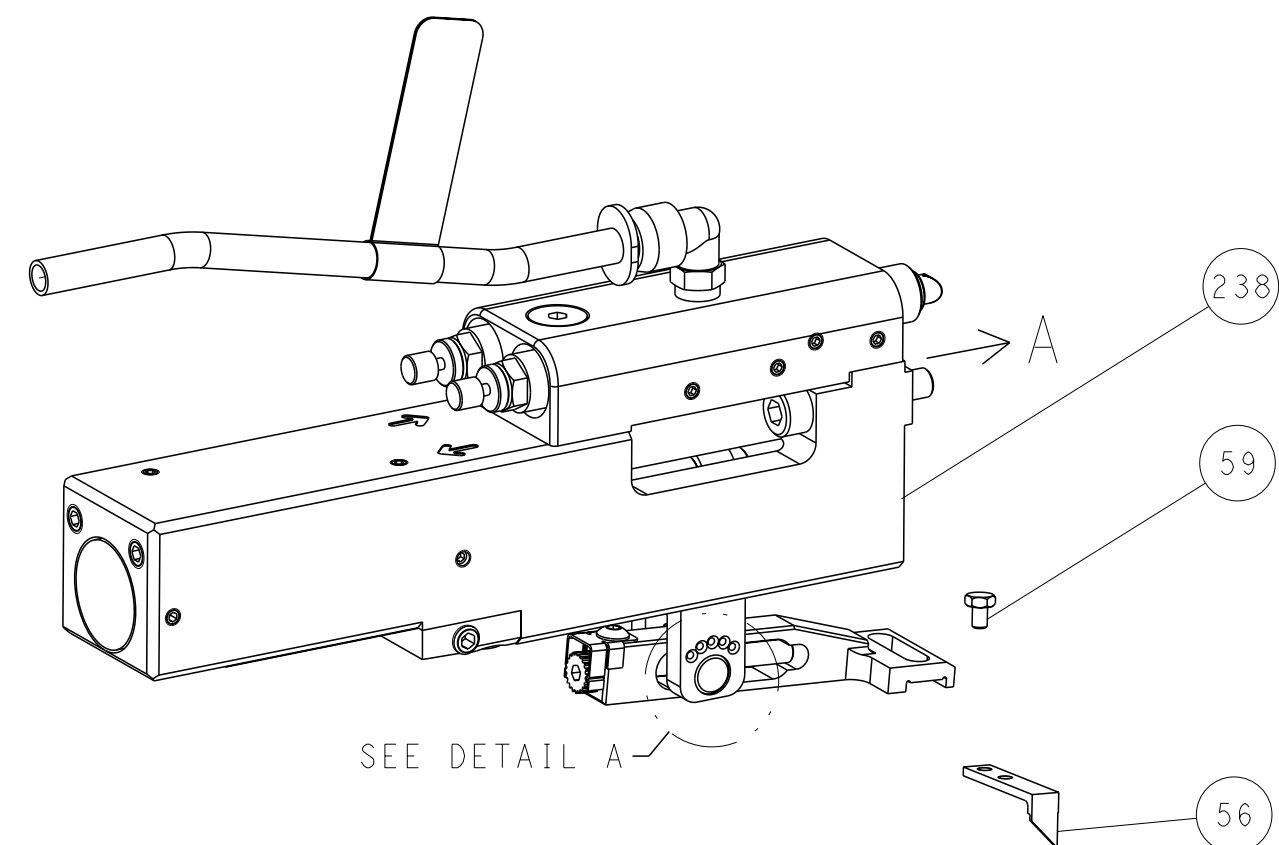
- RECOMMENDED SPARE PARTS
- REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242.
- CRIMP HEIGHT REFERENCE SETTING WAS THE SETTING USED WHEN THE APPLICATOR WAS QUALIFIED AT THE FACTORY. ADJUSTMENT MAY BE NECESSARY WHEN RUNNING APPLICATOR IN THE FIELD.
- TERMINAL LUBRICANT IS RECOMMENDED.
- UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- FEED ADJUSTMENTS MAY BE REQUIRED WHEN SWITCHING TERMINALS.

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

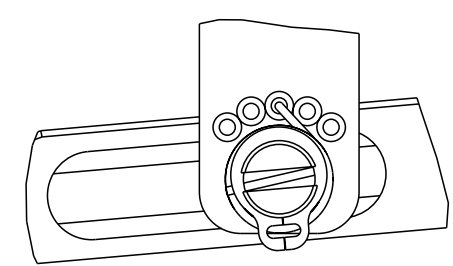
THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE AND TO BE CONTROLLED BY THE ENGINEERING DEPARTMENT. ANY CHANGES SHOULD BE CONTACTED FOR THE LATEST REVISION.		OWN R. HUANG	17MAY2012	TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm		CHK -	-	NAME Ocean Side Feed Applicator	
TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		APVD S. YI	17MAY2012	SIZE 00779	
MATERIAL -		PRODUCT SPEC -	-	CAGE CODE 2151437	
FINISH -		APPLICATION SPEC -	-	DRAWING NO 2151437	
-		WEIGHT -	-	RESTRICTED TO -	
-		Customer Accessible Production Drawing	SCALE 1:2	SHEET 3	REV E

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

PNEUMATIC

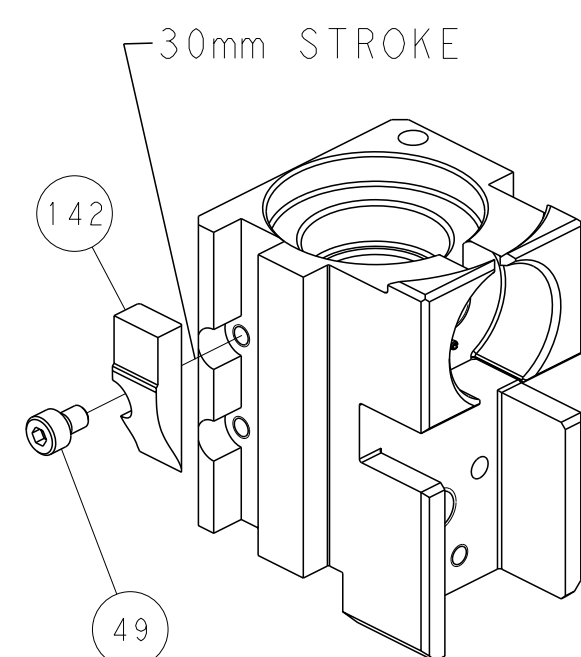


FEED SPRING SETTING POSITION
(SHOWN FROM REAR SIDE)

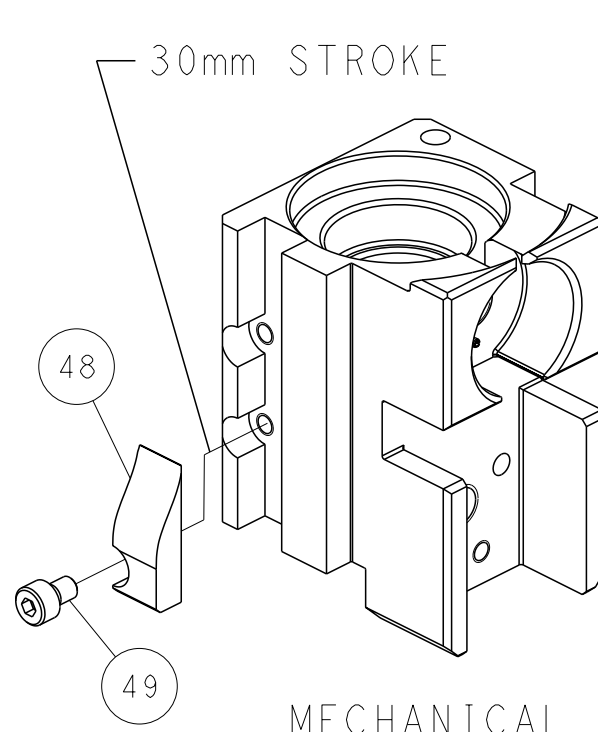


DETAIL A

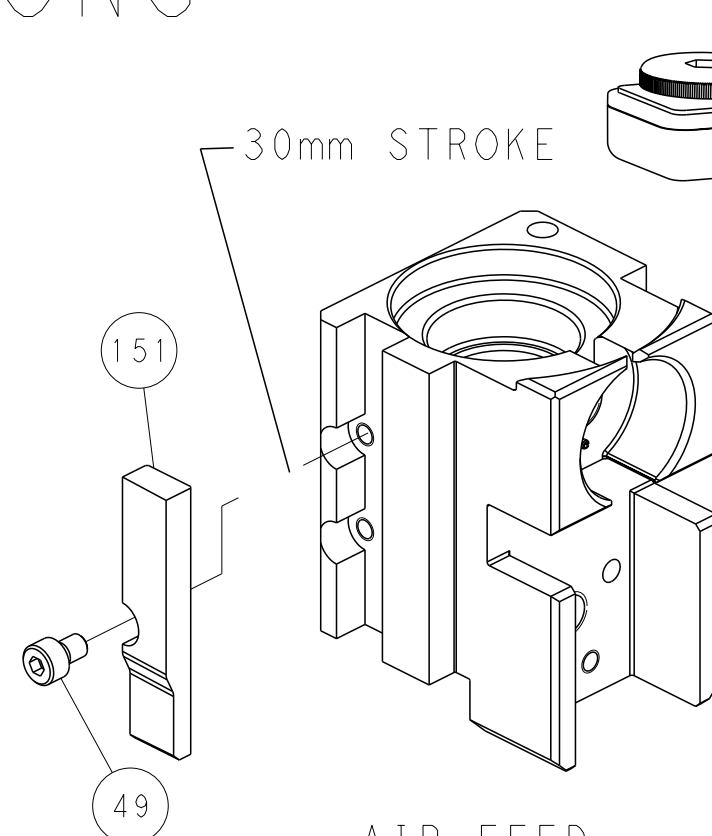
CAM POSITIONS



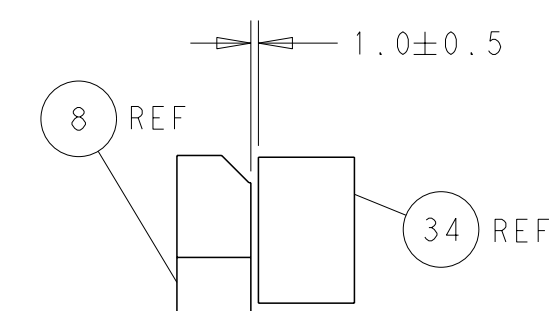
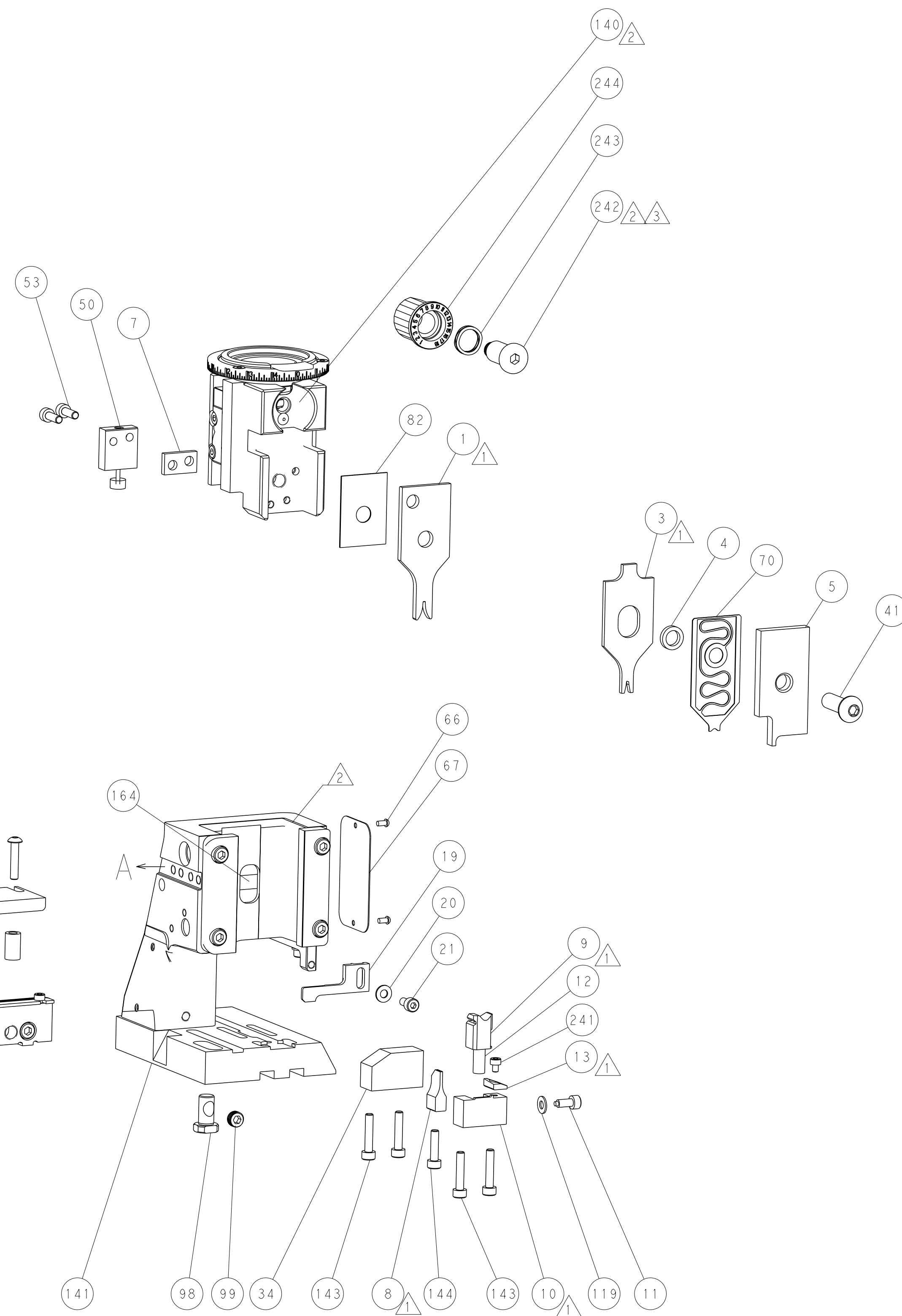
MECHANICAL
POST FEED



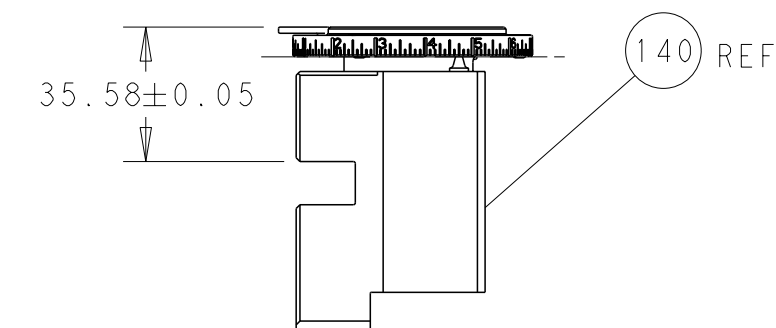
MECHANICAL
PRE FEED



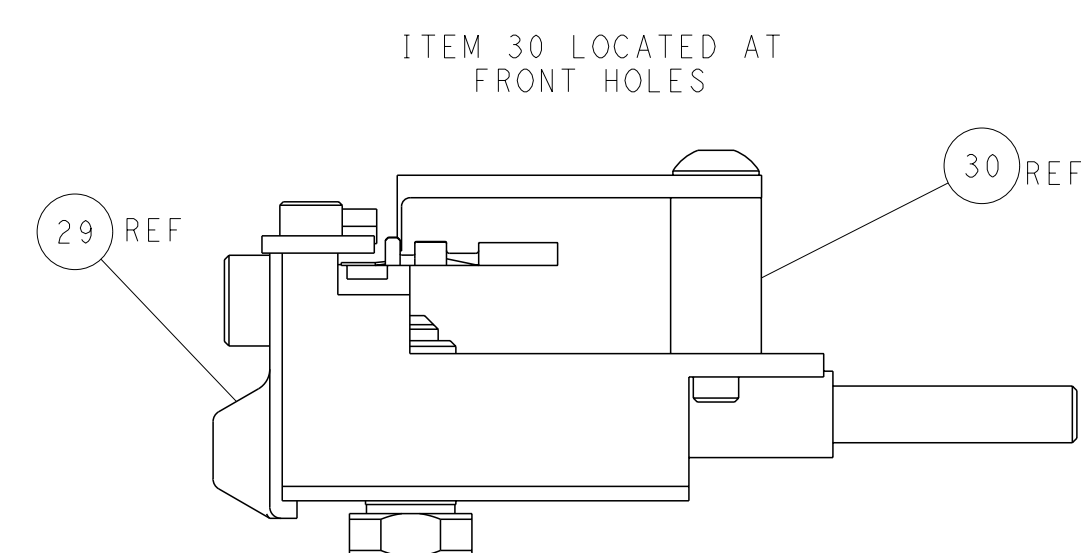
AIR FEED



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)

THIS DRAWING IS A CONTROLLED DOCUMENT FOR TFCO-ELECTRONICS CORPORATION IT IS SUBJECT TO THE PROPERTIES AND SPECIFICATIONS OF THE ORGANIZATION IT SHOULD BE CONTACTED FOR THE LATEST REVISION		DWN 17MAY2012 CHK -		 TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED: APVD 17MAY2012 S.XI PRODUCT SPEC - APPLICATION SPEC -		NAME Ocean Side Feed Applicator -	
		0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		SIZE CAGE CODE DRAWING NO RESTRICTED TO	
MATERIAL -		FINISH -		WEIGHT - A1 00779 C=2151437 -	
Customer Accessible Production Drawing				SCALE 1:2 SHEET 4 OF 4 REV F	