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20		20	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151519-1	D	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2151519-2	E	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151519-1	D	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2151519-2	E	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2151519-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.57 mm [.062]	F
INSUL	3.30 mm [1.30]	O
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: HPF 1.5mm SENSORKONTAKT ASSEMBLY AND BODY			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
4.20-4.60 mm [1.65-.181 IN]		Ø	
TERMINAL APPLICATION SPECIFICATION		114-18912	-
		-	-

TERMINALS APPLIED				
TE TERMINAL	TE TERMINAL	TE SEAL	TE SEAL	INSULATION RANGE
1563623-2		9-963530-1	963530-1	Ø1.4-1.9 mm
		9-964971-1	964971-1	Ø1.2-1.6 mm
2208362-3		967067-1		Ø1.4-2.1 mm

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING
0.50mm2		0.99+/-0.03 [1.039+/-1.001]		8.5



- 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 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. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- 1 TERMINAL LUBRICANT IS RECOMMENDED.

*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)

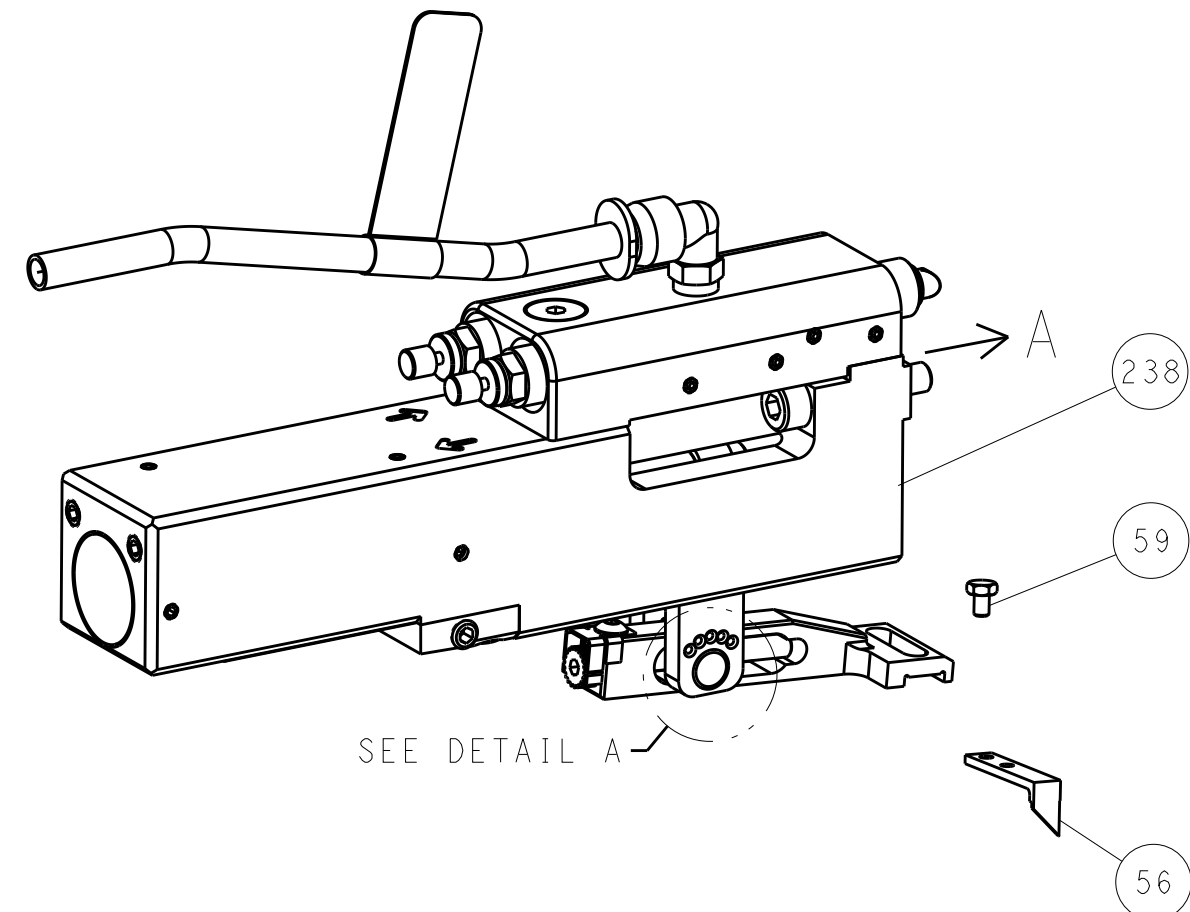
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A	66		B	ECR-14-012177	13AUG2014	YY
			C	ECR-18-006922	06MAY2018	TB
			D	ECR-19-010474	03JUL2019	TB
			E	ECR-19-011319	18JUL2019	FJ

-	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
7	-	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	455888-4	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	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	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	3-2844962-0	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
-	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	1333332-2	ANVIL, COMBINATION, SPECIAL	8
-	1	1	1	1	2-240641-9	SPACER	7
-	-	-	-	-	-	-	6
-	1	1	1	1	2119781-1	DEPRESSOR, SHEAR	5
-	1	1	1	1	238011-4	BLOCK, CRIMPER SPACER	4
1	1	2	2	1	2-1633996-7	CRIMPER, INSULATION SPECIAL	3
-	1	1	1	1	1-455888-3	SPACER, CRIMPER	2
1	1	2	2	1	1-456403-5	CRIMPER, WIRE PREMIUM	1
-	77	-72	-71	-2	-1	PART NO	ITEM NO

THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. THE USER SHALL BE CONTACTED FOR THE LATEST EDITION.		DWN Y. YIN 14MAR2013	TE Connectivity Harrisburg, PA 17105-3608	
CHK G. BAILEY 14MAR2013		APVD J. GUO 14MAR2013	NAME Ocean Side Feed Applicator	
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.001 1 PLC ±.001 2 PLC ±.001 3 PLC ±.001 4 PLC ±.001 ANGLES ±.001		SIZE CAGE CODE DRAWING NO RESTRICTED TO
MATERIAL -		FINISH -		WEIGHT -
Customer Accessible Production Drawing		SCALE 1:2	SHEET 1 OF 4	REV E

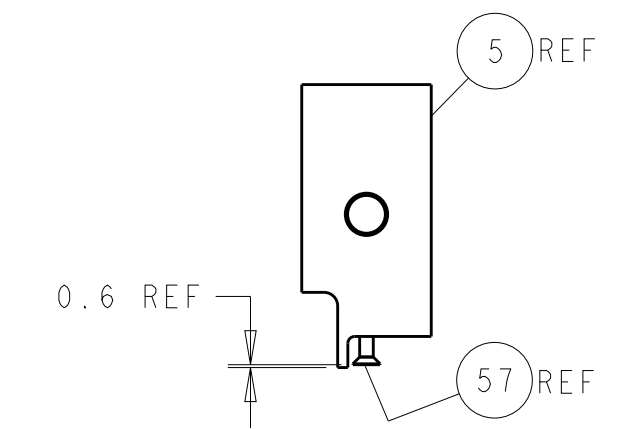
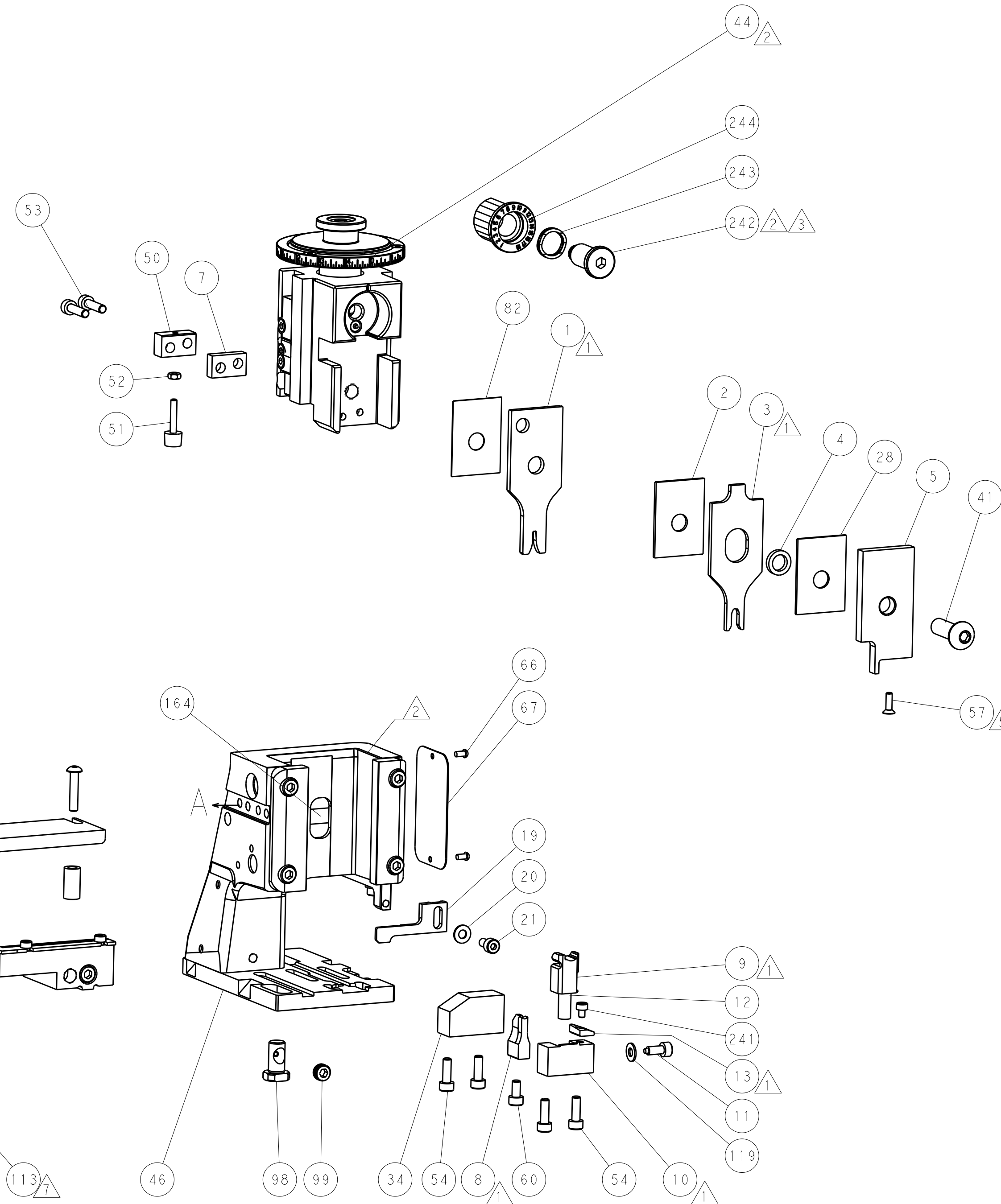
SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

PNEUMATIC



The diagrams illustrate the mechanical post feed mechanism for three different feed types: Mechanical Post Feed, Mechanical Pre Feed, and Air Feed. Each diagram shows a 30mm stroke and a 40mm stroke, with callouts 47, 48, 49, and 248.

- MECHANICAL POST FEED:** Shows a 30mm stroke and a 40mm stroke. Callout 47 points to the post, and callout 49 points to the base.
- MECHANICAL PRE FEED:** Shows a 30mm stroke and a 40mm stroke. Callout 48 points to the post, and callout 49 points to the base.
- AIR FEED:** Shows a 30mm stroke and a 40mm stroke. Callout 248 points to the post, and callout 49 points to the base.



Technical drawing of a mechanical part. The drawing shows a cross-section of a component with a central rectangular feature. A dimension line indicates a width of 1.0 ± 0.5 . A feature is labeled with a circled number 8 and the text REF. Another feature is labeled with a circled number 34 and the text REF.

Technical drawing of a mechanical part. A dimension line indicates a height of 44.61 ± 0.05 . A callout circle labeled "44 REF" points to the top surface of the part.

ITEM 30 LOCATED AT FRONT HOLES

29 REF

30 REF

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

THIS DRAWING IS A CONFIDENTIAL DOCUMENT FOR TFCO INDUSTRIES CORPORATION IT IS SUBJECT TO CHANGE AND THE CONTROLLING ENGINEERING ORGANIZATION SHOULD BE NOTIFIED FOR THE LATEST REVISION		DWN Y YIN 14MAR2013 CHK G.BAILEY 14MAR2013 APPV U.GUO 14MAR2013		 TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.1 1 PLC ±.1 2 PLC ±.1 3 PLC ±.1 4 PLC ±.1 ANGLES ±.1		NAME Ocean Side Feed Applicator	
		PRODUCT SPEC - APPLICATION SPEC -		SIZE A 1	
MATERIAL -		FINISH -		CAGE CODE 00779	
WEIGHT -		DRAWING NO C=2151519		RESTRICTED TO -	
Customer Accessible Production Drawing				SCALE 1:2 SHEET 2 OF 4 REV F	

8		7	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2151519-1	D	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2151519-2	E	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151519-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.57 mm [.062]	F
INSUL	3.30 mm [.130]	O
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: HPF 1.5mm SENSORCONTACT ASSEMBLY AND BODY			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
4.20-4.60 mm [.165-.181 IN]		Ø	
TERMINAL APPLICATION SPECIFICATION		114-18912	
114-18912		-	
-		-	

TERMINALS APPLIED				
TE TERMINAL	TE TERMINAL	TE SEAL	TE SEAL	INSULATION RANGE
1563623-2		9-963530-1	963530-1	Ø1.4-1.9 mm
2208362-3		9-964971-1	964971-1	Ø1.2-1.6 mm
2208362-3		967067-1		Ø1.4-2.1 mm

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.50mm2	0.99+/-0.03 [.039+/- .001]	8.5



- 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.
- 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.
- UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- TERMINAL LUBRICANT IS RECOMMENDED.

*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)

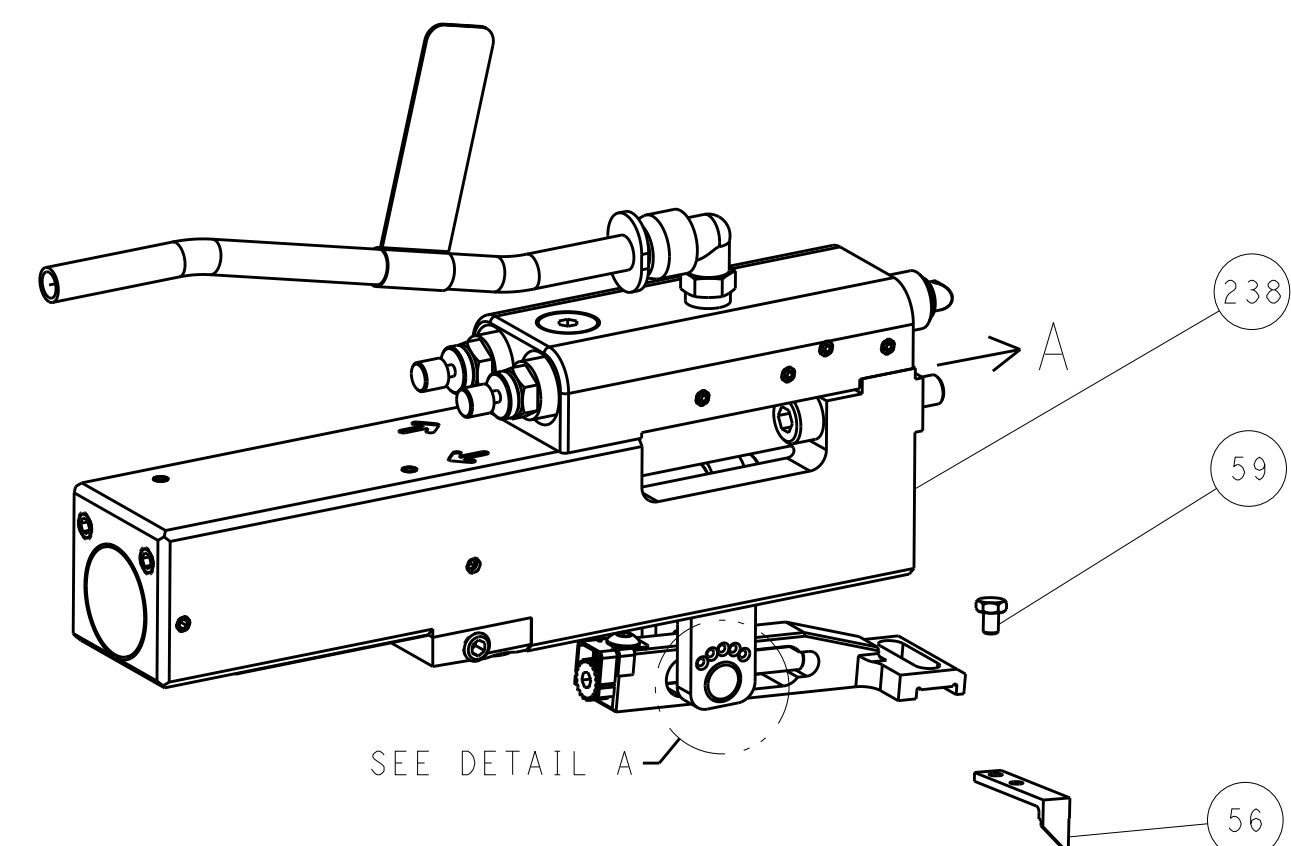
LOC		DIST		REVISONS			
A				DESCRIPTION	DATE	OWN	APVD
				SEE SHEET 1	-	-	-

-	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	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113
-	1	1	2844908-1	SCREW, LOCKING	99
-	1	1	2844907-1	POST, LOCKING	98
-	1	1	455888-4	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	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	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	3-2844962-0	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
-	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	1333332-2	ANVIL, COMBINATION, SPECIAL	8
-	1	1	2-240641-9	SPACER	7
-	-	-	-	-	6
-	1	1	2119781-1	DEPRESSOR, SHEAR	5
-	1	1	238011-4	BLOCK, CRIMPER SPACER	4
1	1	1	2-1633996-7	CRIMPER, INSULATION SPECIAL	3
-	1	1	1-455888-3	SPACER, CRIMPER	2
1	1	1	1-456403-5	CRIMPER, WIRE PREMIUM	1
-77	-22	-21	PART NO	DESCRIPTION	ITEM NO

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DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		NAME Ocean Side Feed Applicator	
MATERIAL -		FINISH -		SIZE A	
				CAGE CODE 00779	
				DRAWING NO 2151519	
				RESTRICTED TO -	
				Customer Accessible Production Drawing	
				SCALE 1:2	
				SHEET 3	
				OF 4	
				REV E	

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

Diagram illustrating the front view of the microscope assembly. Callouts 239, 59, and 56 point to the eyepiece, objective, and stage components respectively.



DETAIL A

30mm STROKE

142

49

MECHANICAL POST FEED

30mm STROKE

48

49

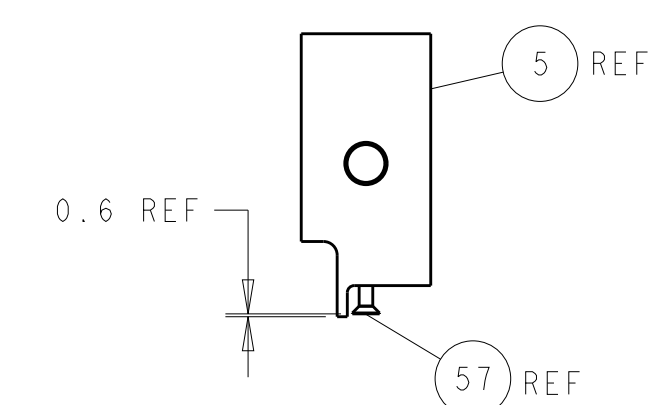
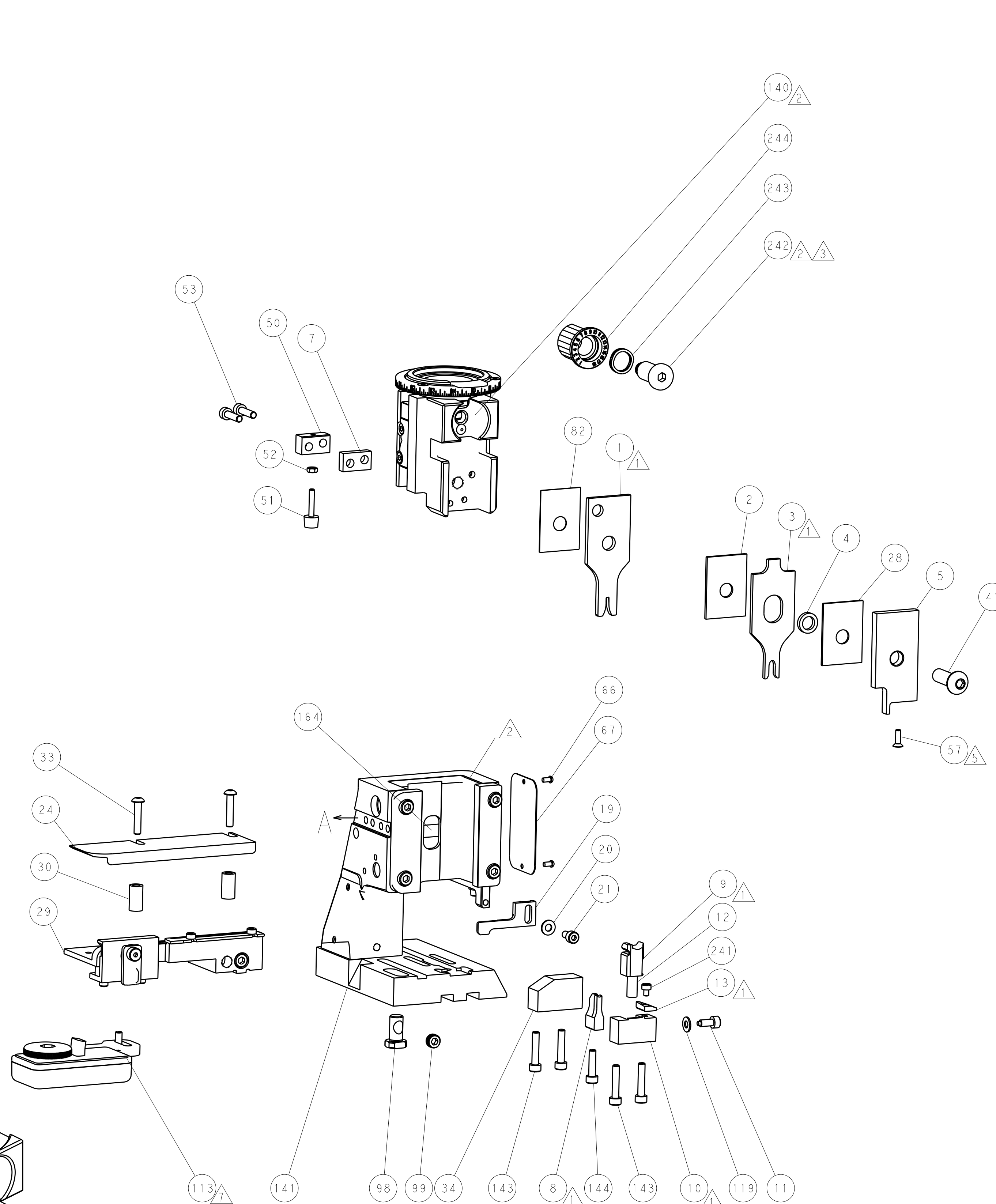
MECHANICAL PRE FEED

30mm STROKE

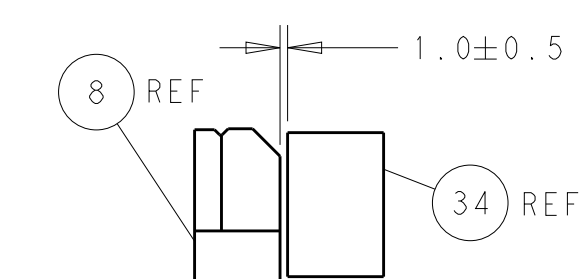
151

49

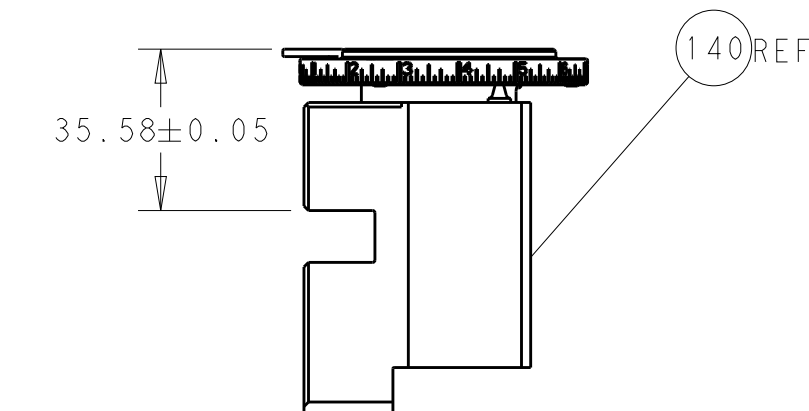
AIR FEED



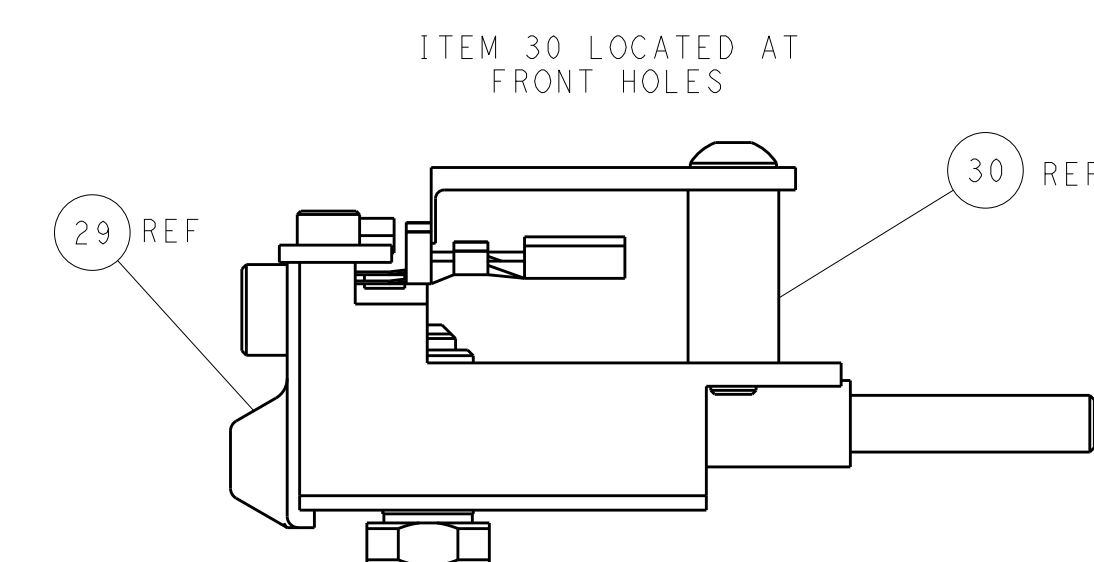
SHEAR DEPRESSOR DETAIL



TERMINAL SUPPORT LOCATION

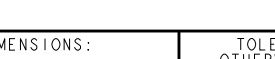


RAM SET-UP



FEED TRACK POSITION
GUIDE BY INSULATION BARREL

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: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±. 1 PLC ±. 2 PLC ±. 3 PLC ±. 4 PLC ±. ANGLES ±. MATERIAL - FINISH -		NAME Ocean Side Feed Applicator -	
		PRODUCT SPEC - APPLICATION SPEC -		SIZE A 1	
MATERIAL - FINISH -		WEIGHT -		CAGE CODE 00779	
MATERIAL - FINISH -		WEIGHT -		DRAWING NO C=2151519	
MATERIAL - FINISH -		WEIGHT -		RESTRICTED TO -	
MATERIAL - FINISH -		WEIGHT -		SCALE 1:2 SHEET A OF A REV F	
Customer Accessible Production Drawing					