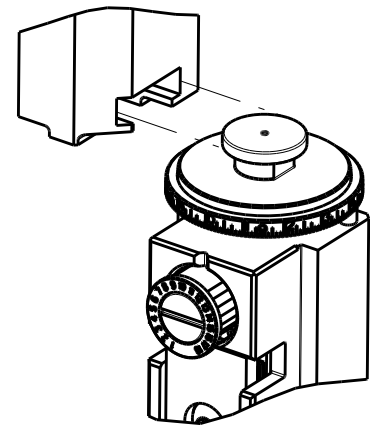


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PART NUMBER	REVISION	DESCRIPTION		FEED TYPE	
2151524-2	Z	FINE CRIMP HEIGHT ADJUST		PNEUMATIC	
3-2151524-2	Z	FINE CRIMP HEIGHT ADJUST		DOUBLE ACTING PNEUMATIC WITH SENSORS	
5-2151524-2	Z	SEAL STRIPPER CRIMPER TERMINATING UNIT		PNEUMATIC	
7-2151524-2	Z	PNEUMATIC AND CRIMP TOOLING KIT		PNEUMATIC	
7-2151524-7	V	CRIMP TOOLING KIT		-	



ATLANTIC VERSION TERMINATOR
INTERFACE ADAPTER

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.07 mm [.042]	F
INSUL	1.27 mm [.050]	O
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: NANO MOS TERMINAL			
WIRE STRIP LENGTH 3.50-3.80 mm [.138-.150 IN]		INSULATION DIAMETER RANGE Ø1.20-1.30 mm [.047-.051 IN]	
TERMINAL APPLICATION SPECIFICATION		114-18858	
TERMINALS APPLIED		5 7	
TE TERMINAL 2-1703930-1	TE TERMINAL 2-1703930-2	TE TERMINAL 2-1703930-4	TE TERMINAL

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING
0.35mm ²		0.78+/- .02 [.0307+/- .0008]		9.6



- △ RECOMMENDED SPARE PARTS
 - △ REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
 - △ APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 180
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.
 - △ PRODUCTION ONLY ALLOWED WITH TOOLS WITH PNEUMATIC FEED. MECHANICAL FEED IS NOT ALLOWED.
 - △ THIS APPLICATOR IS EQUIPPED WITH THE DOUBLE ACTING FEED WITH SENSORS AND IS APPLICATION SPECIFIC AND DOES NOT REQUIRE ITEM 49 & 248.
 - △ TERMINAL LUBRICANT IS RECOMMENDED.
8. 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.

LOC	DIST	REVISIONS						
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			W	ECR-19-001463	29JAN2019	FZ	YY	
			W1	ECR-19-001727	01FEB2019	FZ	YY	
			Y	ECR-19-004653	26MAR2019	LG	TE	
			Z	ECR-19-011557	23JUL2019	FZ	RK	

	-	-	1	-	-	1803515-3	RAM ASSEMBLY, SF ATLANTIC	293
	-	-	1	-	-	2-1803583-1	APPLICATOR BASIC ASSEMBLY SF	292
	-	-	-	1	-	2844950-1	AIR FEED MODULE	290
	-	1	1	-	1	2119641-1	FEED CAM, AIR FEED	248
	-	1	1	1	1	2119082-3	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
	-	1	1	-	1	2844940-1	AIR FEED MODULE	238
	-	-	1	-	-	4-1722335-3	STRIPPER, SIDE FEED	182
3	-	-	1	-	-	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	181
	-	-	1	-	-	1-1752354-6	STANDOFF,HOLD-DOWN	180
	-	-	1	-	-	993111-1	PIN, SLOTTED SPRING 3.0 X 20.0	177
	-	-	1	-	-	5-22280-0	SPRING, COMPRESSION	176
	-	-	1	-	-	1752353-3	GUIDE PIN,HOLDDOWN	175
	-	-	1	-	-	1901680-2	GUIDE PIN,HOLDDOWN	174
	-	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
	-	1	1	1	1	1-22281-8	SPRING, COMPRESSION	121
7	-	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
	-	2	2	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	96
	-	1	1	1	1	1-690438-0	FRONT STRIP GUIDE	95
	-	1	1	1	1	2168083-6	SCR, SKT HD CAP, RoHS, M5 X 65	93
	-	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	2-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 14	53
	-	1	1	1	1	1803382-6	HOLD DOWN, SPRING LOADED	50
	-	1	1	-	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49
	-	1	-	1	1	1803583-9	APPLICATOR BASIC ASSEMBLY, SF	46
	-	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	2-18032-5	SCR, SET, FLT PNT, M5 X 20.0	36
	-	1	1	1	1	1752356-1	SUPPORT, TERMINAL	34
	-	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
	-	1	1	1	1	2-1722335-1	THREAD BOLT GEWINDEBOLZEN	31
	-	2	2	2	2	2-2844962-3	SPACER, CYLINDRICAL, STRIP GUIDE	30
	-	1	1	1	1	2844938-1	PLATE, STRIP GUIDE	29
	-	2	2	2	2	22283-1	SPRING, COMPRESSION	27
	-	1	1	1	1	356835-1	LEVER, DRAG RELEASE	26
	-	1	1	1	1	1803142-1	DRAW, TERMINAL	25
	-	1	1	1	1	1320928-2	STRIP GUIDE	24
	-	1	1	1	1	980371-4	SCR, SKT HD SHLDR 5.0 DIA X 6.0	23
	-	1	-	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
	-	2	1	2	2	1-18028-2	WASHER, FLAT, REG M4	20
	-	1	-	1	1	2119533-1	STRIPPER, SIDE FEED	19
	-	1	1	1	1	3-22280-3	SPRING, COMPRESSION	12
	-	1	1	1	1	2-519000-1	SCR, SKT HD CAP M4 X 10.0	11
1	-	1	1	1	1	2119805-1	SHEAR HOLDER, FRONT	10
	-	1	1	1	1	1803095-7	FLOATING SHEAR, FRONT -	9

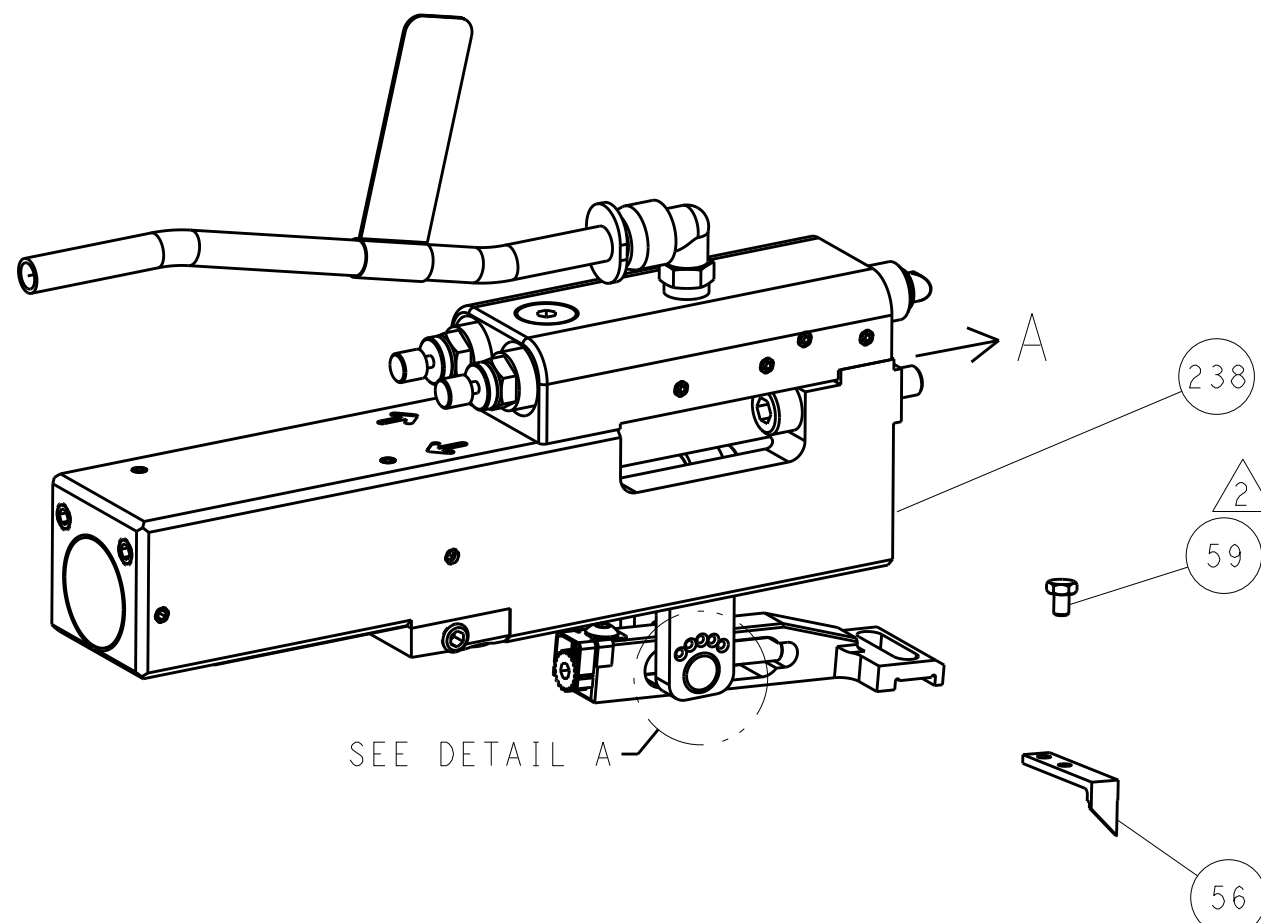
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SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

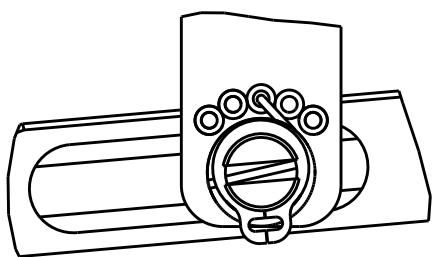
LOC	DIST	REVISIONS				
		P	LTR	DESCRIPTION	DATE	DWN
A	66	-	-	SEE SHEET 1	-	-

FEED TYPE

PNEUMATIC

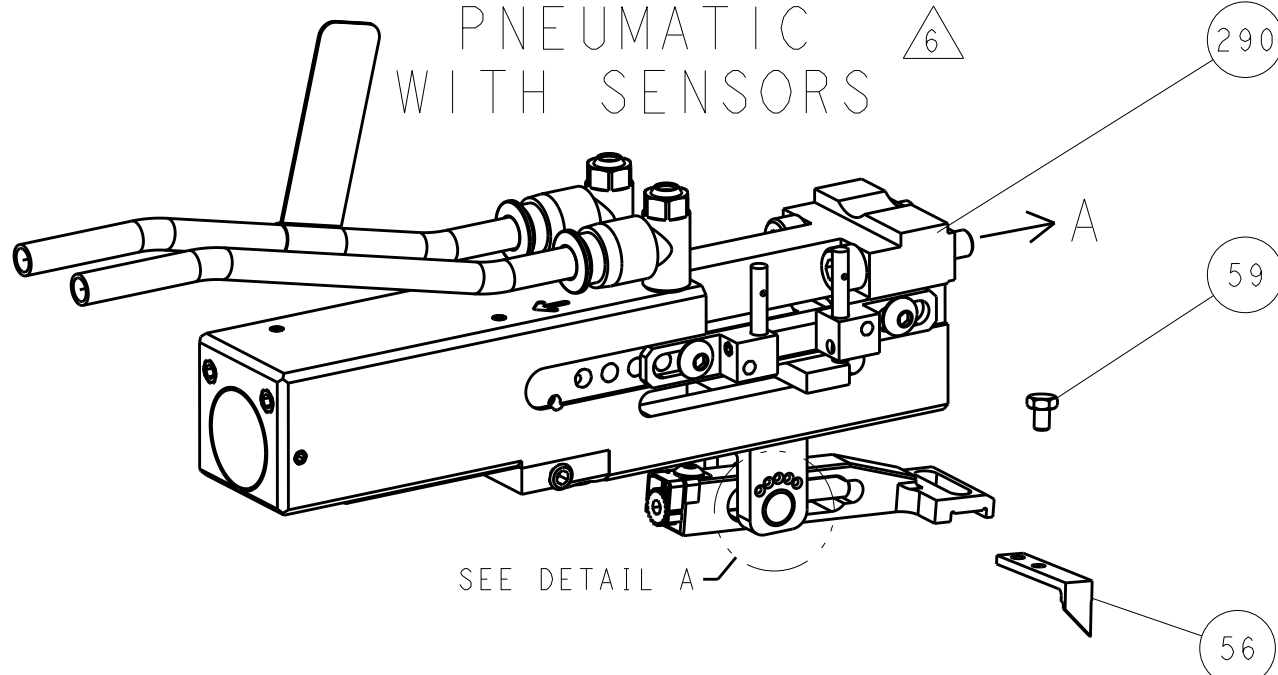


FEED SPRING SETTING POSITION
(SHOWN FROM REAR SIDE)



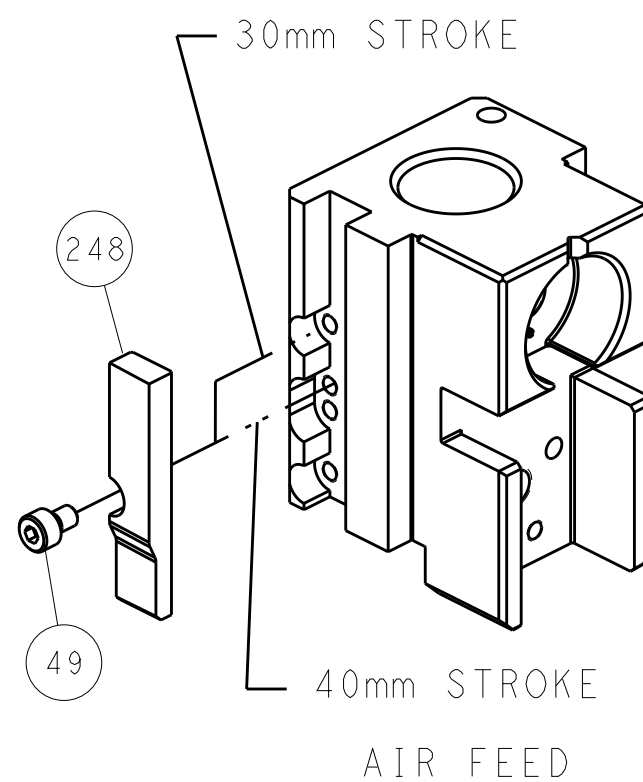
DETAIL A

DOUBLE ACTING
PNEUMATIC
WITH SENSORS

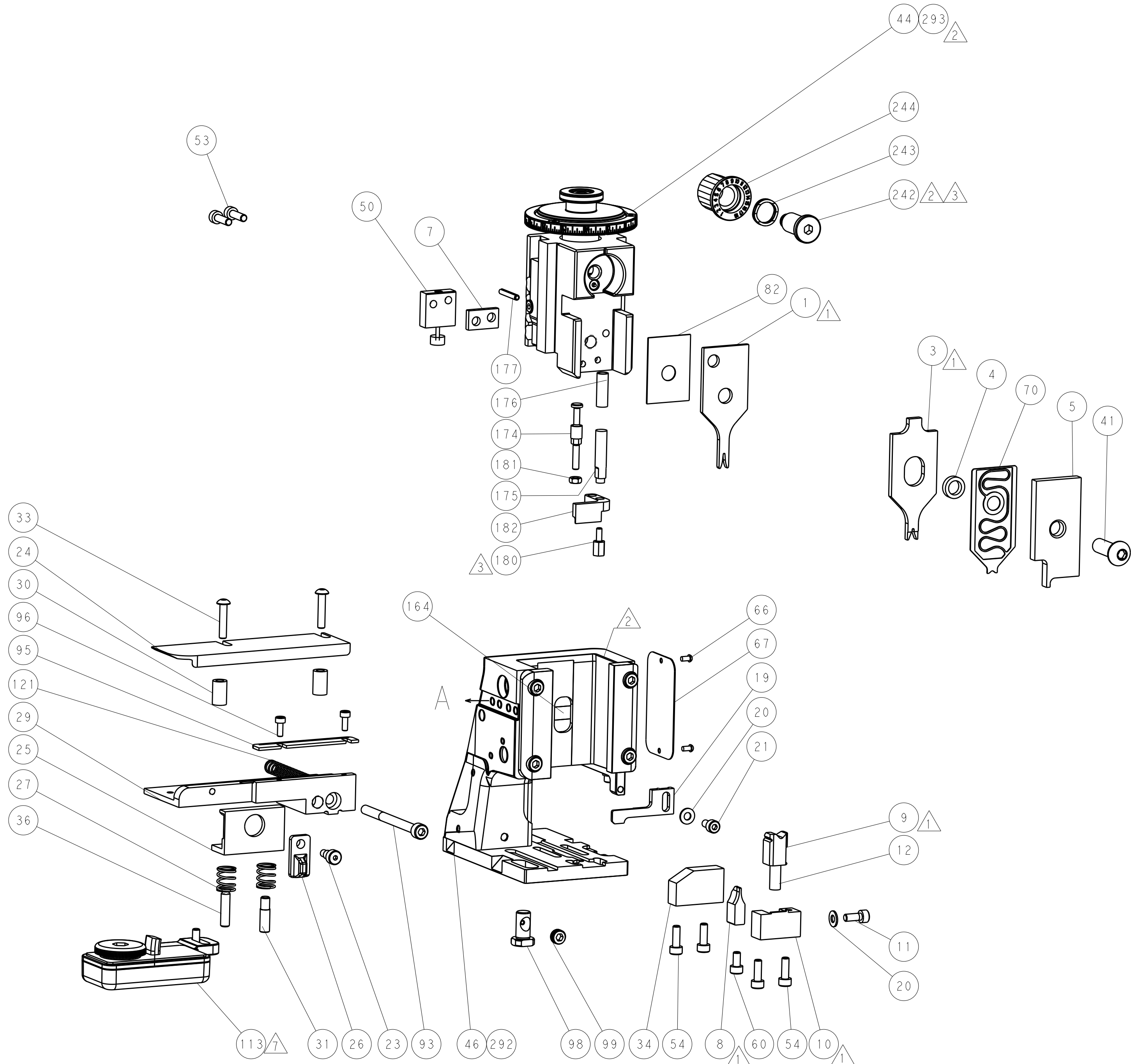


SEE DETAIL A

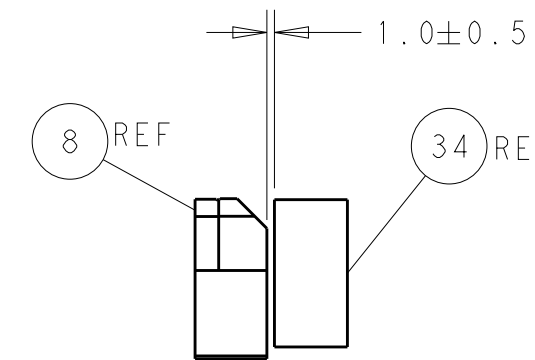
CAM POSITION



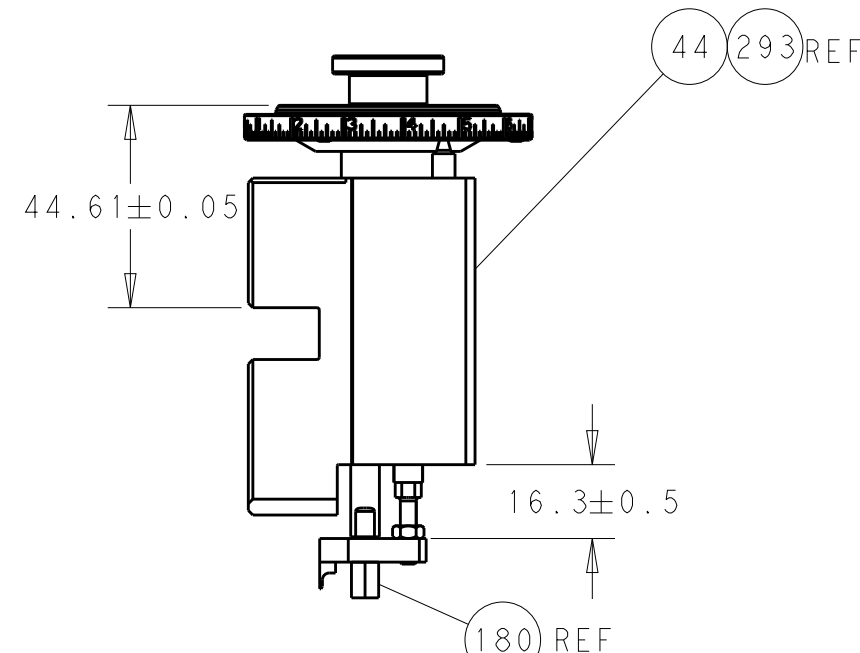
AIR FEED



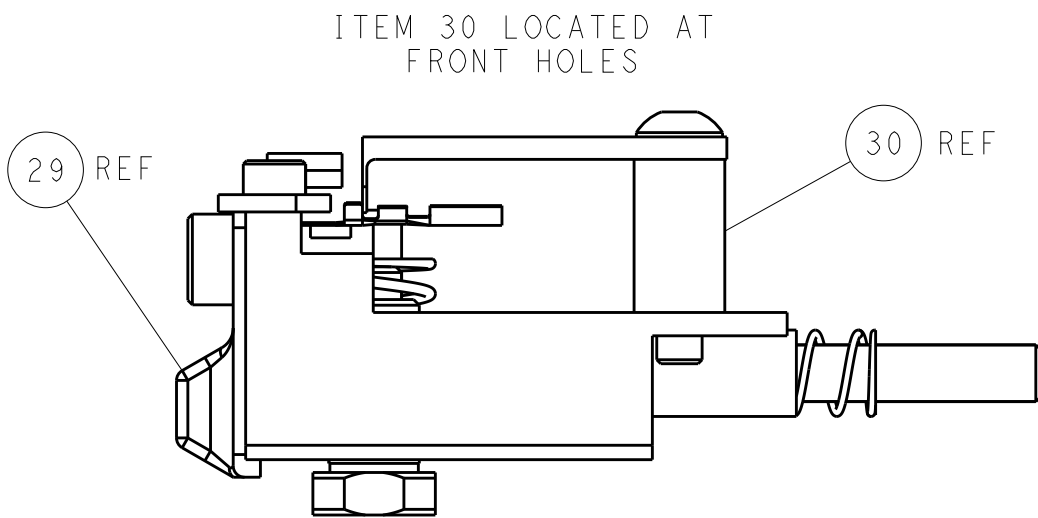
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)



TERMINAL SUPPORT LOCATION



RAM AND HOLDDOWN SET-UP



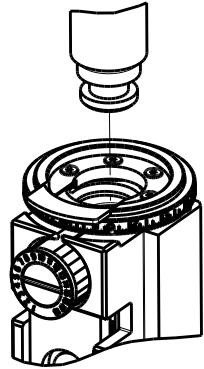
FEED TRACK POSITION
GUIDE BY INSULATION BARREL

THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. ANY CHANGES TO THIS DRAWING SHOULD BE CONTACTED FOR THE LATEST REVISION.		DWN B. WEAVER 01JUN2011	TE Connectivity Harrisburg, PA 17105-3608	
		CHK G. HOFNER 01JUN2011		
		APVD T. ELBIN 01JUN2011	NAME Ocean Side Feed Applicator	
DIMENSIONS: mm		0 PLC 1 PLC 2 PLC 3 PLC 4 PLC ANGLES FINISH	PRODUCT SPEC APPLICATION SPEC	SIZE A1
MATERIAL -		WEIGHT -	CAGE CODE 00779	DRAWING NO. 2151524
		Customer Accessible Production Drawing		SCALE 1:2
		SHEET 2		OF 4
		REV Z		

SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

8		7	
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2011		2011	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2151524-2	Z	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
4-2151524-2	Z	FINE CRIMP HEIGHT ADJUST	DOUBLE ACTNG PNEUMATIC WITH SENSORS
7-2151524-7	V	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.07 mm [.042]	F
INSUL	1.27 mm [.050]	O
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: NANO MQS TERMINAL			
WIRE STRIP LENGTH 3.50-3.80 mm [.138-.150 IN]		INSULATION DIAMETER RANGE Ø1.20-1.30 mm [.047-.051 IN]	
TERMINAL APPLICATION SPECIFICATION		(A)114-18858	
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
2-1703930-1	2-1703930-2	2-1703930-4	

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.35mm2	0.78+/- .02 [.0307+/- .0008]	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. PRODUCTION ONLY ALLOWED WITH TOOLS WITH PNEUMATIC FEED. MECHANICAL FEED IS NOT ALLOWED.
6. THIS APPLICATOR IS EQUIPPED WITH THE DOUBLE ACTING FEED WITH SENSORS AND IS APPLICATION SPECIFIC AND DOES NOT REQUIRE ITEM 49 & 151.
7. TERMINAL LUBRICANT IS RECOMMENDED.
8. 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	OWN	APVD
		-		SEE SHEET 1	-	-	-

-	1	-	2844950-1	AIR FEED MODULE	290
-	1	1	2119082-3	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	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	1	1-1803583-0	APPLICATOR BASIC ASSEMBLY, SF	141
-	1	1	1803516-1	RAM ASSEMBLY, SF PACIFIC	140
-	1	1	1-22281-8	SPRING, COMPRESSION	121
-	1	1	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113
-	1	1	2844908-1	SCREW, LOCKING	99
-	1	1	2844907-1	POST, LOCKING	98
-	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	96
-	1	1	1-690438-0	FRONT STRIP GUIDE	95
-	1	1	2168083-6	SCR, SKT HD CAP, RoHS, M5 X 65	93
-	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	2-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 14	53
-	1	1	1803382-6	HOLD DOWN, SPRING LOADED	50
-	-	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
-	1	1	2-18032-5	SCR, SET, FLT PNT, M5 X 20.0	36
-	1	1	1752356-1	SUPPORT, TERMINAL	34
-	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	1	1	2-1722335-1	THREAD BOLT GEWINDEBOLZEN	31
-	2	2	2-2844962-3	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	2844938-1	PLATE, STRIP GUIDE	29
-	2	2	22283-1	SPRING, COMPRESSION	27
-	1	1	356835-1	LEVER, DRAG RELEASE	26
-	1	1	1803142-1	DRAG, TERMINAL	25
-	1	1	1320928-2	STRIP GUIDE	24
-	1	1	980371-4	SCR, SKT HD SHLDR 5.0 DIA X 6.0	23
-	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	3-22280-3	SPRING, COMPRESSION	12
-	1	1	2-519000-1	SCR, SKT HD CAP M4 X 10.0	11
-	1	1	2119805-1	SHEAR HOLDER, FRONT	10
-	1	1	1803095-1	FLOATING SHEAR, FRONT	9
-	1	1	6-1633620-7	ANVIL, COMBINATION	8
-	1	1	5-240641-2	SPACER	7
-	1	1	2119757-4	DEPRESSOR, SHEAR	5
-	1	1	3-238011-8	BLOCK, CRIMPER SPACER	4
-	1	1	1803143-6	CRIMPER, INSULATION O	3
-	1	1	2-1333281-7	CRIMPER, WIRE PREMIUM	1

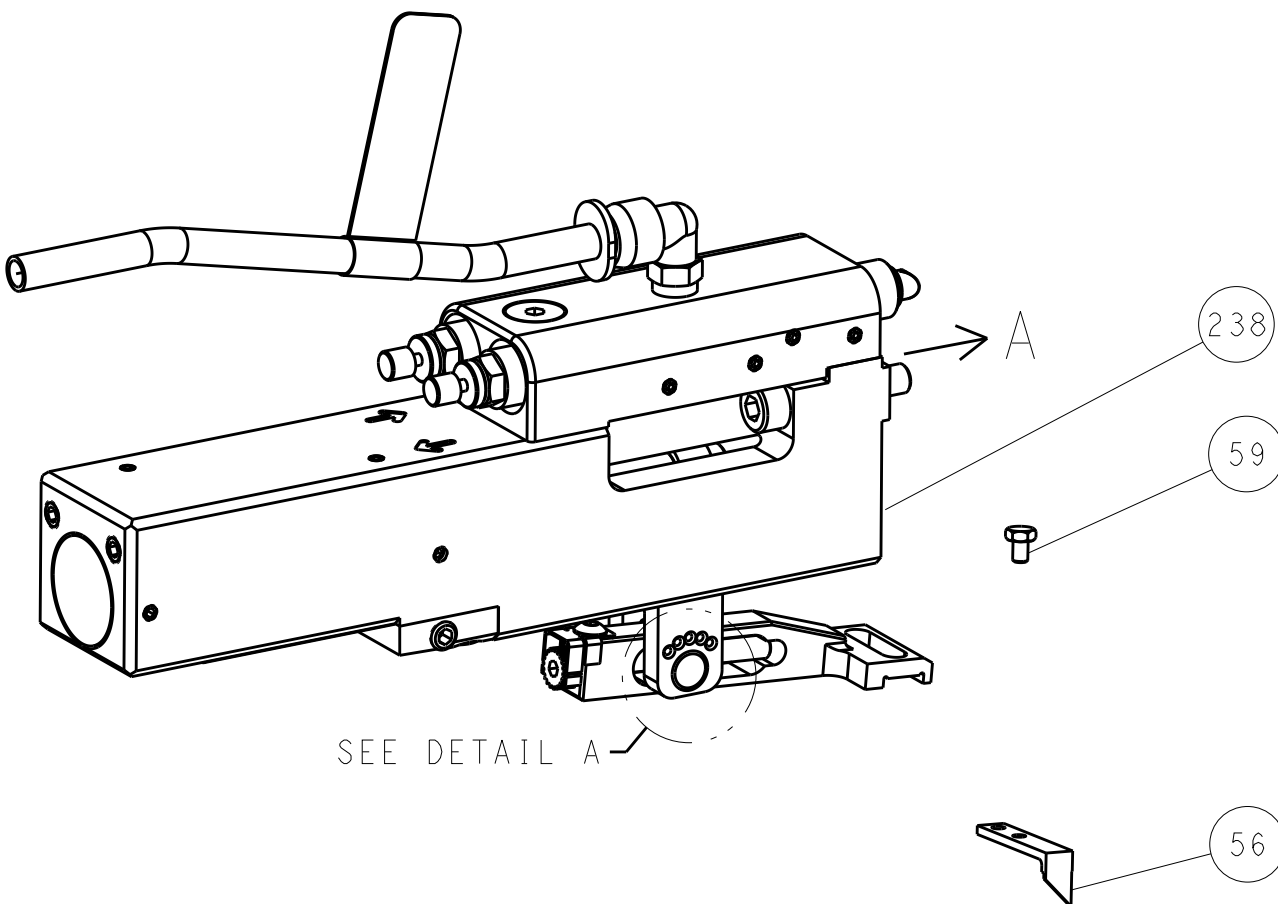
-77	-42	-22	PART NO	DESCRIPTION	ITEM NO
			OWN: B. WEAVER 01JUN2011 CHK: G. HOFFNER 01JUN2011 APVD: T. ELBIN 01JUN2011		
			TE Connectivity Harrisburg, PA 17105-3608		
			NAME: Ocean Side Feed Applicator		
			SIZE: 00779 C=2151524		
			Customer Accessible Production Drawing		
			SCALE: 1:2 SHEET 3 OF 4 REV Z		

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

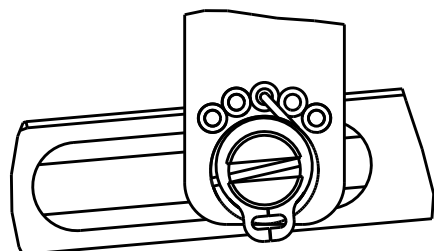
LOC		DIST		REVISONS			
A	66	P	LTR	DESCRIPTION	DATE	DWN	APVD
		-		SEE SHEET 1	-	-	-

FEED TYPE

PNEUMATIC

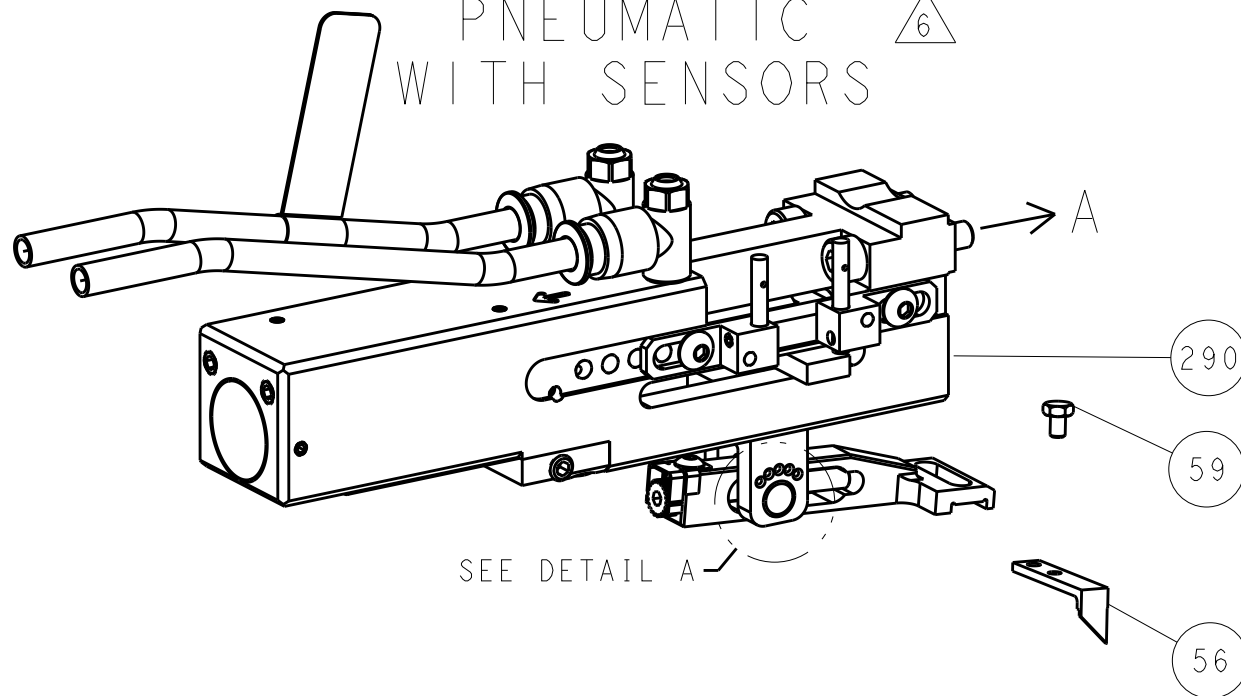


FEED SPRING SETTING POSITION
(SHOWN FROM REAR SIDE)

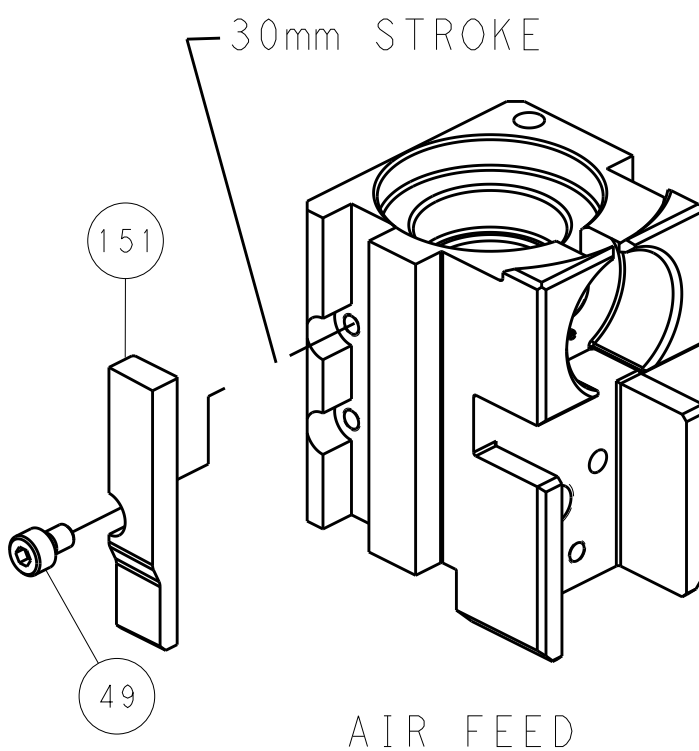


DETAIL A

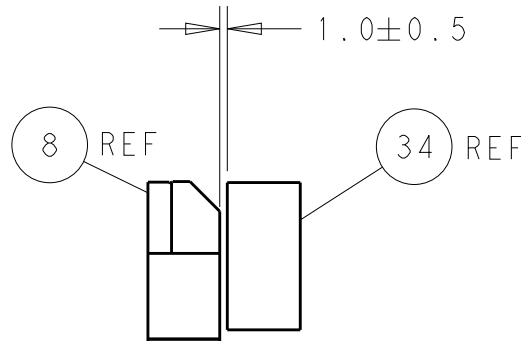
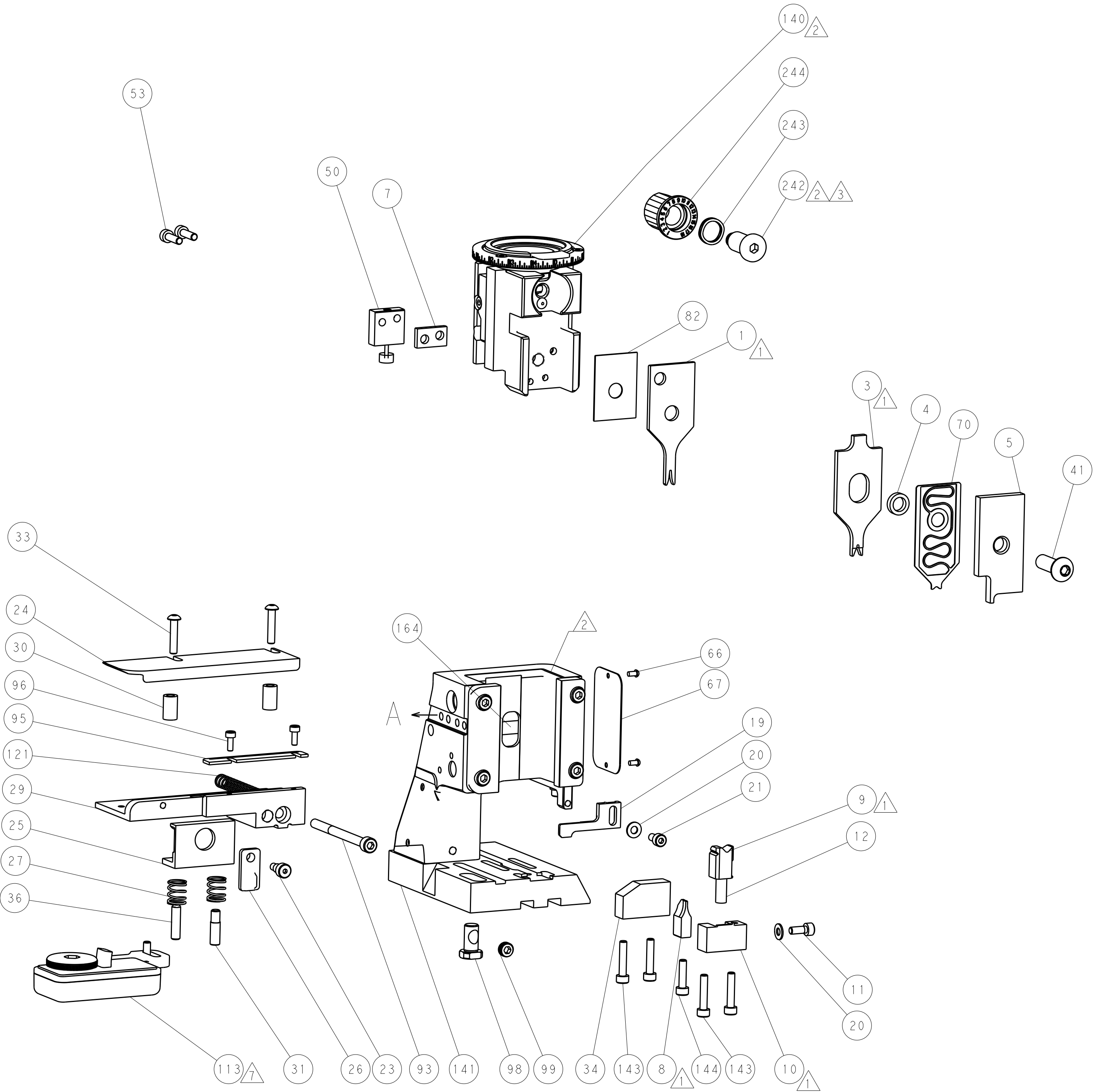
DOUBLE ACTING
PNEUMATIC
WITH SENSORS



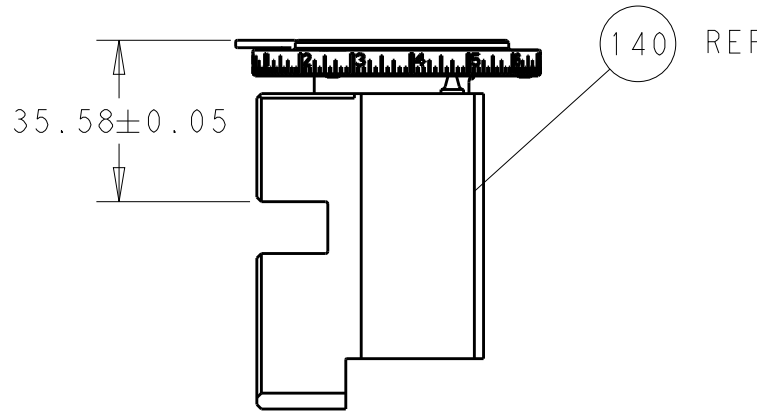
CAM POSITION



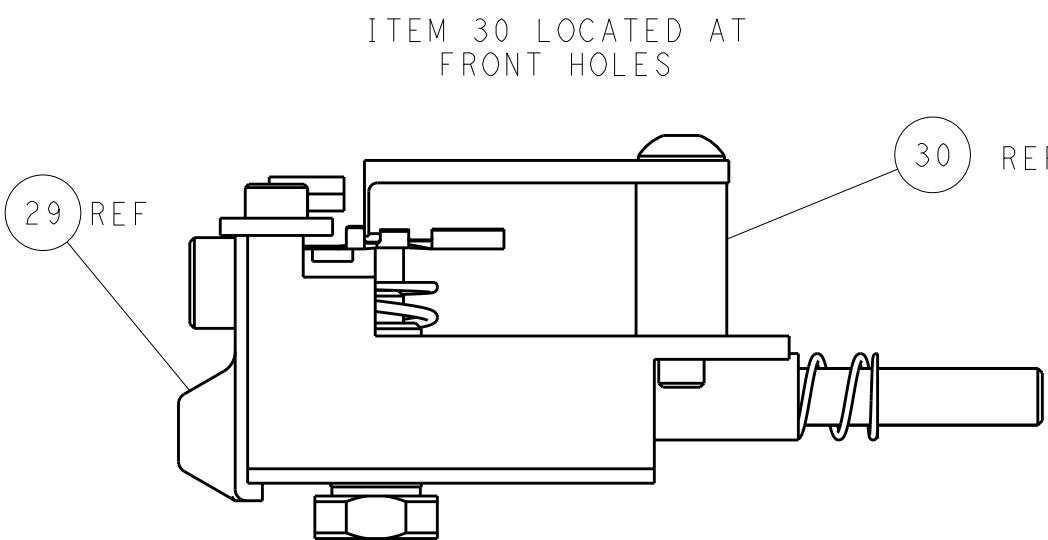
AIR FEED



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)

1. THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE WITHOUT NOTICE AND ANY MODIFICATION OR REVISION SHOULD BE CONTACTED FOR THE LATEST VERSION.		DWN B. WEAVER 01JUN2011	TE Connectivity Harrisburg, PA 17105-3608	
2. DIMENSIONS: mm		CHK G. HOFENER 01JUN2011		
3. TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.1 1 PLC ±.1 2 PLC ±.1 3 PLC ±.1 4 PLC ±.1 ANGLES ±.1		APVD T. ELBIN 01JUN2011	NAME Ocean Side Feed Applicator	
MATERIAL -		PRODUCT SPEC -	SIZE A1	
		APPLICATION SPEC -	CAGE CODE 00779	
		WEIGHT -	DRAWING NO. 2151524	
		Customer Accessible Production Drawing	SCALE 1:2	
			SHEET 4	
			OF 4	
			REV Z	