

8	7	6	5	4	3	2	1
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE				
2151791-1	F	FINE CRIMP HEIGHT ADJUST	MECHANICAL				
2151791-2	F	FINE CRIMP HEIGHT ADJUST	PNEUMATIC				
5-2151791-1	F	SEAL STRIPPER CRIMPER TERMINATING UNIT	MECHANICAL				
5-2151791-2	F	SEAL STRIPPER CRIMPER TERMINATING UNIT	PNEUMATIC				
7-2151791-1	F	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL				
7-2151791-2	F	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC				
7-2151791-7	A	CRIMP TOOLING KIT	-				

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.37 mm [.054]	F
INSUL	1.40 mm [.055]	F
APPLICATOR INSTRUCTIONS 408-35042		

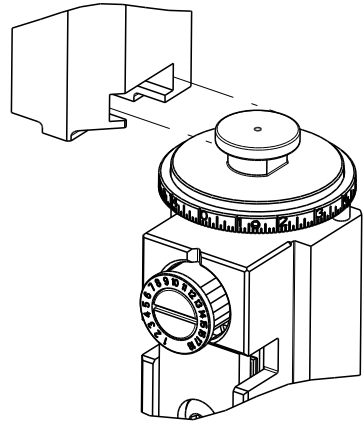
TERMINAL DATA: JST TERMINAL		JST CRIMP SPECIFICATION	
TERMINAL NAME: TERMINAL, INTERLOCK			
WIRE STRIP LENGTH 2.10-2.10 mm [.083-.083 IN]		INSULATION DIAMETER RANGE Ø1.00-1.50 mm [.039-.059 IN]	
TERMINAL APPLICATION SPECIFICATION		HM-0003(CHM-1-070) Rev R6	
TERMINALS APPLIED			
TE TERMINAL		JST TERMINAL	TE TERMINAL
286828-1		SPHD-001T-P0.5	

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
22 AWG	0.75+/-0.05 [.030+/- .002]	8.2
24 AWG	0.70+/-0.05 [.028+/- .002]	8.7
26 AWG	0.65+/-0.05 [.026+/- .002]	9.2



- 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. APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 180.
- 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.
6. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.

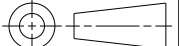
ATLANTIC VERSION TERMINATOR
INTERFACE ADAPTER



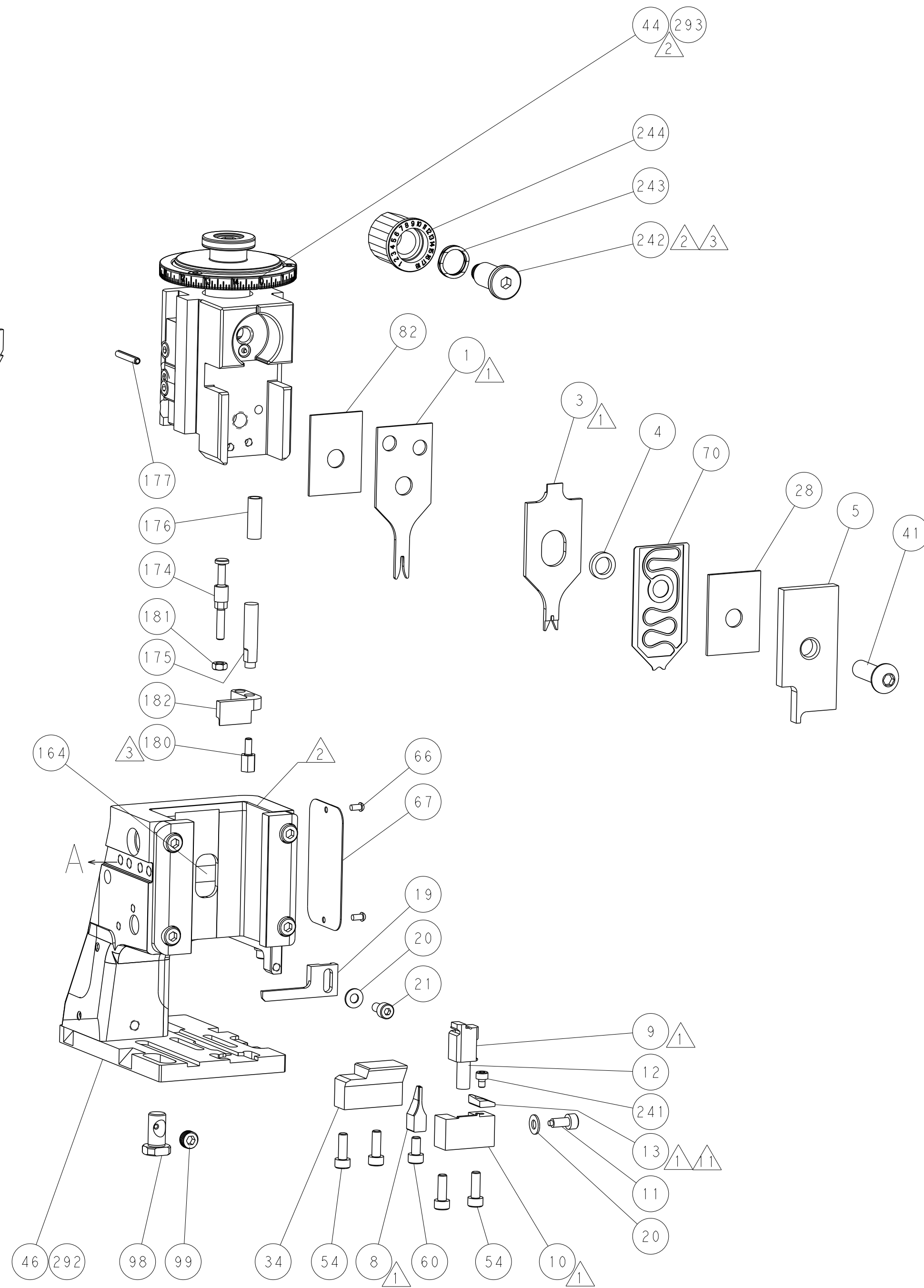
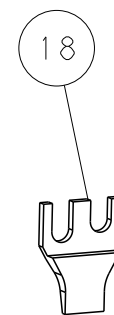
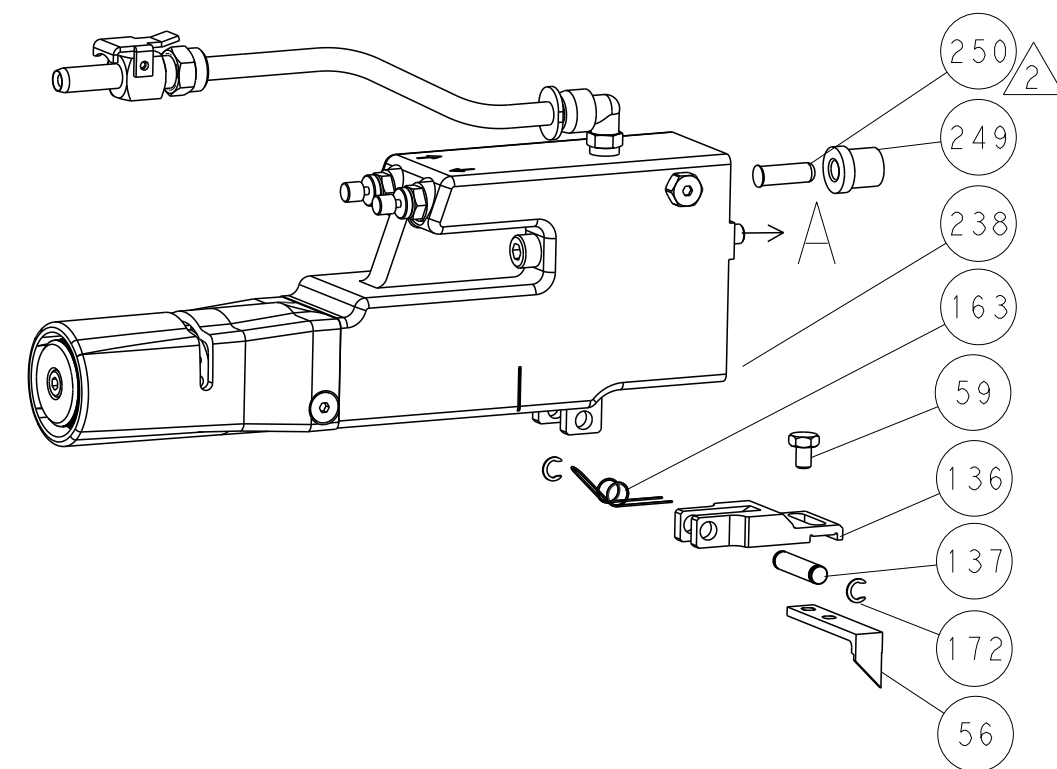
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

LOC	DIST	REVISIONS			
A	66	P	LTR	DESCRIPTION	DATE
		D		ECR-16-015375	31OCT2016
		E		ECR-17-003885	17MAR2017
		F		ECR-18-015499	02OCT2018

-	-	-	1	1	-	-	1803515-3	RAM ASSEMBLY, SF ATLANTIC	293
-	-	-	1	1	-	-	2-1803583-1	APPLICATOR BASIC ASSEMBLY, SF	292
-	1	-	1	-	1	-	2119640-1	PUSH ROD, AIR FEED	250
-	1	-	1	-	1	-	1803259-1	BUSHING, FLANGED	249
-	1	-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248
-	1	1	1	1	1	1	2119082-5	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	-	2063440-1	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	-	-	1-1752354-5	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
-	2	-	2	-	2	-	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172
-	REF	REF	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	1	-	1	-	1	-	240638-1	SPRING, FEED FINGER	163
-	1	-	1	-	1	-	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854	137
-	1	-	1	-	1	-	2119799-1	HOLDER,FEED FINGER, AF	136
-	1	1	1	1	1	1	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113
-	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	455888-9	SPACER, CRIMPER	82
-	1	1	1	1	1	1	1803607-1	DOCUMENTATION PACKAGE	71
-	1	1	1	1	1	1	2119791-9	DEPRESSOR, WIRE	70
-	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	1338685-1	PAWL, FEED	56
-	4	4	4	4	4	4	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	54
-	2	2	-	-	2	2	1-2168083-4	SCR, SKT HD CAP, RoHS, M4 X 5	53
-	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	2-1752356-6	SUPPORT, TERMINAL	34
-	2	2	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	2	2	2	2	2-2844962-4	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	1	1	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29
-	1	1	1	1	1	1	1-455888-2	SPACER, CRIMPER	28
-	1	1	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	1	1	2	2	1-18028-2	WASHER, FLAT, REG M4	20
-	1	1	-	-	1	1	2119533-2	STRIPPER, SIDE FEED	19
-	1	1	-	-	1	1	2-690518-4	HOLD DOWN, TERMINAL	18
-	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	1633861-1	SHEAR, FLOATING	9
1	2	2	1	1	1	1	2-1633927-5	ANVIL, COMBINATION	8
-	-	-	-	-	-	-	-	-	7
-	-	-	-	-	-	-	-	-	6
-	1	1	1	1	1	1	1-2119757-0	DEPRESSOR, SHEAR	5
-	1	1	1	1	1	1	1-238011-0	BLOCK, CRIMPER SPACER	4
1	2	2	1	1	1	1	2-1633962-8	CRIMPER, INSULATION F PREMIUM	3
-	-	-	-	-	-	-	-	-	2
1	2	2	1	1	1	1	4-1633738-6	CRIMPER, WIRE	1

-77-72-71-52-51-2-1				PART NO		DESCRIPTION				ITEM NO					
THIS DRAWING IS A CONTROLLED DOCUMENT FOR YOUR ELECTRONIC COMPONENTS. IT IS SUBJECT TO CHANGE WITHOUT NOTICE AND WITHOUT LIABILITY. THE USER SHALL BE RESPONSIBLE FOR THE LATEST EDITION. SHOULD BE CONTACTED FOR THE LATEST REVISION.						OWN L. ZHANG 12OCT2012		 TE Connectivity Harrisburg, PA 17105-3608							
						CHK L. ZHANG 12OCT2012									
DIMENSIONS:						APVD S. XI 12OCT2012		NAME		Ocean Side Feed Applicator -					
mm						PRODUCT SPEC									
						APPLICATION SPEC									
						SIZE		CASE CODE							
						DRAWING NO		RESTRICTED TO							
						MATERIAL		FINISH							
						WEIGHT									
						A1		00779						©=2151791	
Customer Accessible Production Drawing						SCALE		1:2						SHEET 1 OF 4	
														REV F	

PNEUMATIC



30mm STROKE

47

49

40mm STROKE

MECHANICAL POST FEED

30mm STROKE

48

49

40mm STROKE

MECHANICAL PRE FEED

30mm STROKE

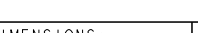
248

49

40mm STROKE

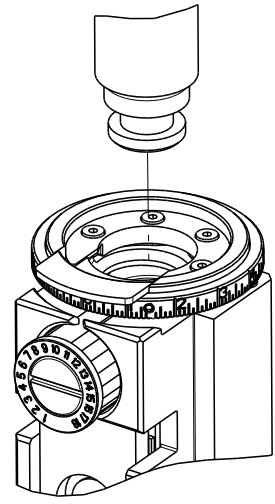
AIR FEED

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

THIS DRAWING IS A CONTROLLED DOCUMENT FROM TFCO. ANY REVISIONS, MODIFICATIONS, OR ALTERATIONS TO THIS DOCUMENT SHOULD BE SUBMITTED FOR THE LATEST REVISIONS.		DWN 120CT2012 CHK L. ZHANG 120CT2012 APVD S. XI 120CT2012		 TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		NAME Ocean Side Feed Applicator	
		PRODUCT SPEC APPLICATION SPEC		SIZE CAGE CODE DRAWING NO A1 00779 C=251791	
MATERIAL FINISH		WEIGHT		RESTRICTED TO -	
		Customer Accessible Production Drawing		SCALE 1:2 SHEET 2 OF 4 REV F	

8		7	
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20		20	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2151791-1	F	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2151791-2	F	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151791-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.37 mm [.054]	F
INSUL	1.40 mm [.055]	F
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: JST TERMINAL		JST CRIMP SPECIFICATION	
TERMINAL NAME: TERMINAL, INTERLOCK			
WIRE STRIP LENGTH 2.10-2.10 mm [.083-.083 IN]		INSULATION DIAMETER RANGE Ø1.00-1.50 mm [.039-.059 IN]	
TERMINAL APPLICATION SPECIFICATION HM-0003(CHM-1-070) Rev R6			
TERMINALS APPLIED			
TE TERMINAL	JST TERMINAL	TE TERMINAL	JST TERMINAL
286828-1	SPHD-001T-P0.5		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
22 AWG	0.75+/-0.05 [.030+/-0.002]	8.2
24 AWG	0.70+/-0.05 [.028+/-0.002]	8.7
26 AWG	0.65+/-0.05 [.026+/-0.002]	9.2



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

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

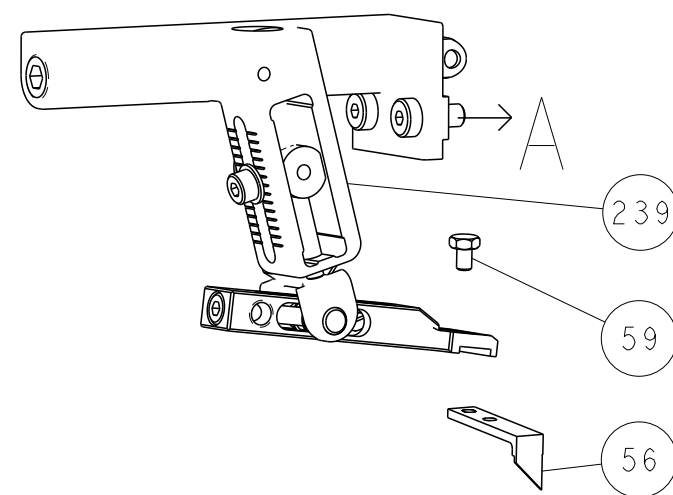
LOC		DIST		REVISONS			
A		66		DESCRIPTION	DATE	OWN	APVD
				SEE SHEET 1	-	-	-

3	-	1	-	2119640-1	PUSH ROD, AIR FEED	250
	-	1	-	1803259-1	BUSHING, FLANGED	249
	-	1	1	2119082-5	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	
5	-	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	455888-9	SPACER, CRIMPER	82
	-	1	1	1803607-1	DOCUMENTATION PACKAGE	71
	-	1	1	2119791-9	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	1-2168083-4	SCR, SKT HD CAP, RoHS, M4 X 5	53	
-	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	2-1752356-6	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	1-455888-2	SPACER, CRIMPER	28	
-	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	2119533-2	STRIPPER, SIDE FEED	19	
1	-	1	1	2-690518-4	HOLD DOWN, TERMINAL	18
	-	1	1	2119806-1	INSERT, SHEAR	13
	-	1	1	3-22280-3	SPRING, COMPRESSION	12
1	-	1	1	1-356885-4	STOP, SHEAR	11
	-	1	1	2119805-1	SHEAR HOLDER, FRONT	10
1	-	1	1	1633861-1	SHEAR, FLOATING	9
	1	1	1	2-1633927-5	ANVIL, COMBINATION	8
-	-	-	-	-	7	
-	-	-	-	-	6	
-	1	1	1	1-2119757-0	DEPRESSOR, SHEAR	5
-	1	1	1	1-238011-0	BLOCK, CRIMPER SPACER	4
1	1	1	1	2-1633962-8	CRIMPER, INSULATION F PREMIUM	3
	-	-	-	-	-	2
1	1	1	1	4-1633738-6	CRIMPER, WIRE	1

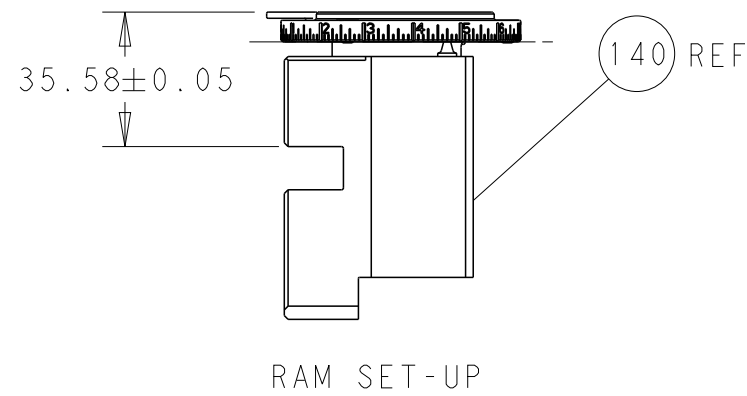
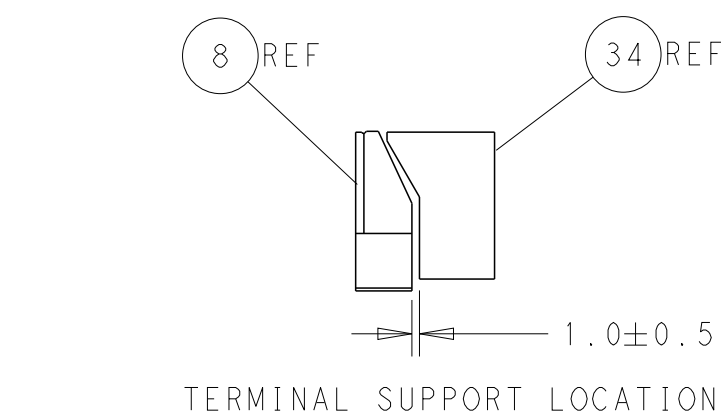
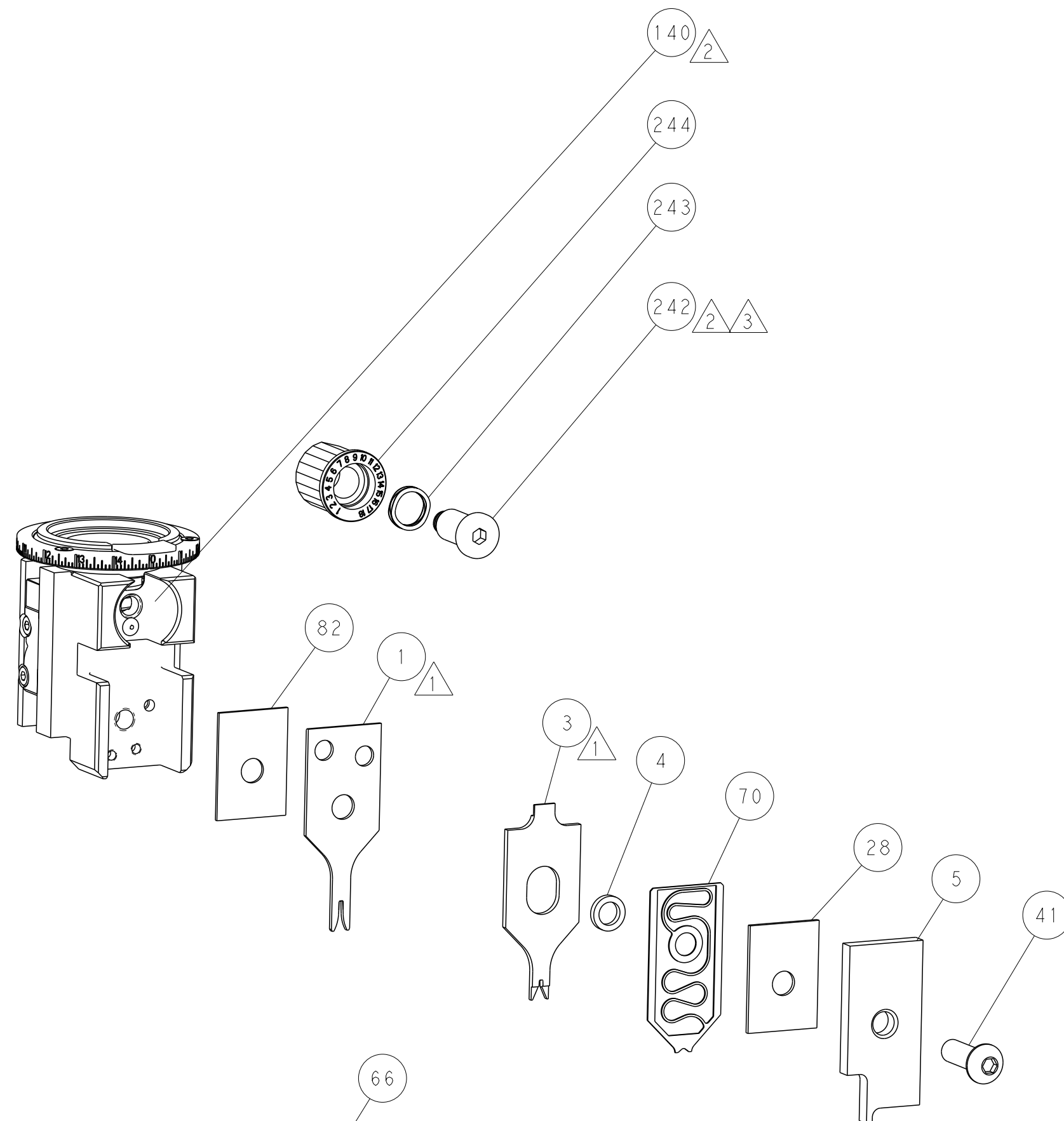
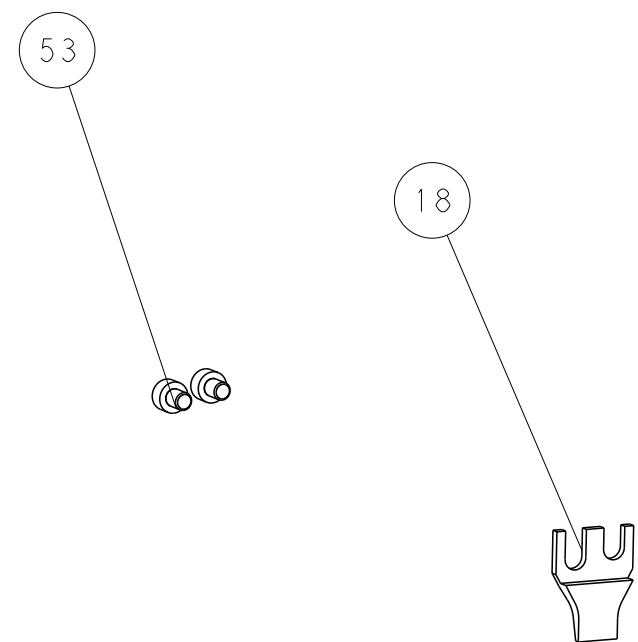
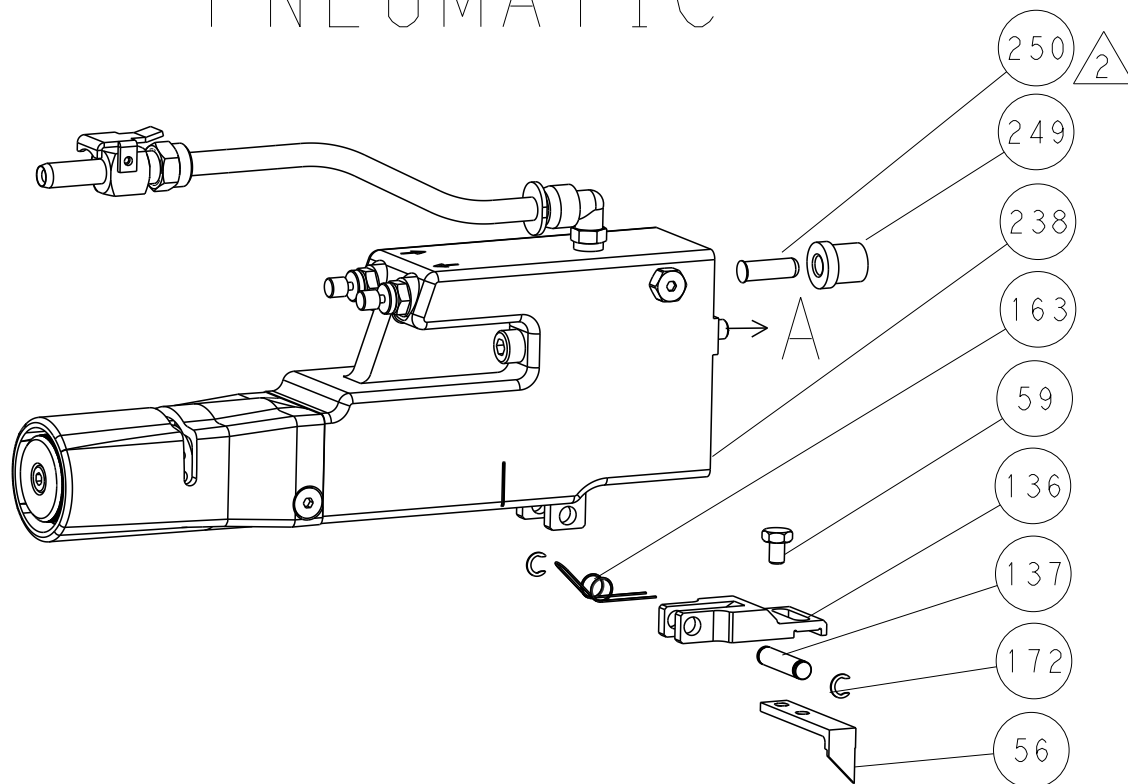
-77	-22	-21	PART NO	DESCRIPTION	ITEM NO	
OWN			12OCT2012	 TE Connectivity Harrisburg, PA 17105-3608		
CHK			12OCT2012			
CHK			12OCT2012			
APVD			12OCT2012			
DIMENSIONS:			PRODUCT SPEC	NAME Ocean Side Feed Appliator		
mm			APPLICATION SPEC			
TOLERANCES UNLESS OTHERWISE SPECIFIED:			WEIGHT	SIZE	CAGE CODE	
0 PLC			-	1	00779	
1 PLC			-	2	00779	
2 PLC			-	3	00779	
3 PLC			-	4	00779	
4 PLC			-	5	00779	
ANGLES			-	6	00779	
FINISH			-	7	00779	
MATERIAL			-	8	00779	
Customer Accessible Production Drawing			SCALE	1:2	SHEET 3 OF 4	
			REV	F		

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

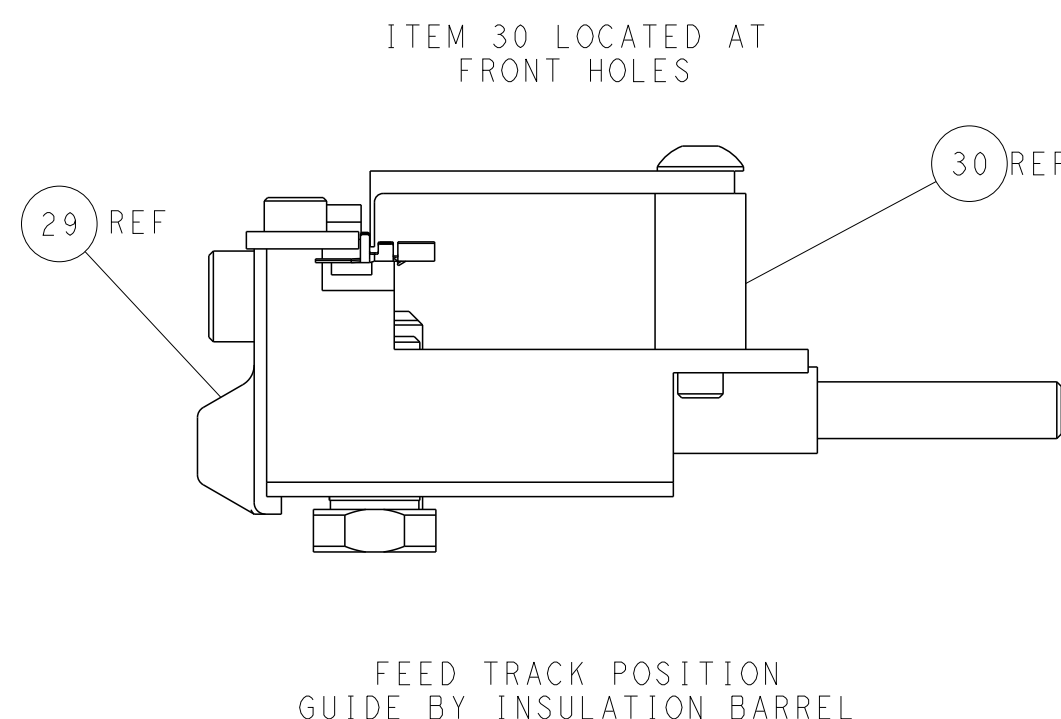
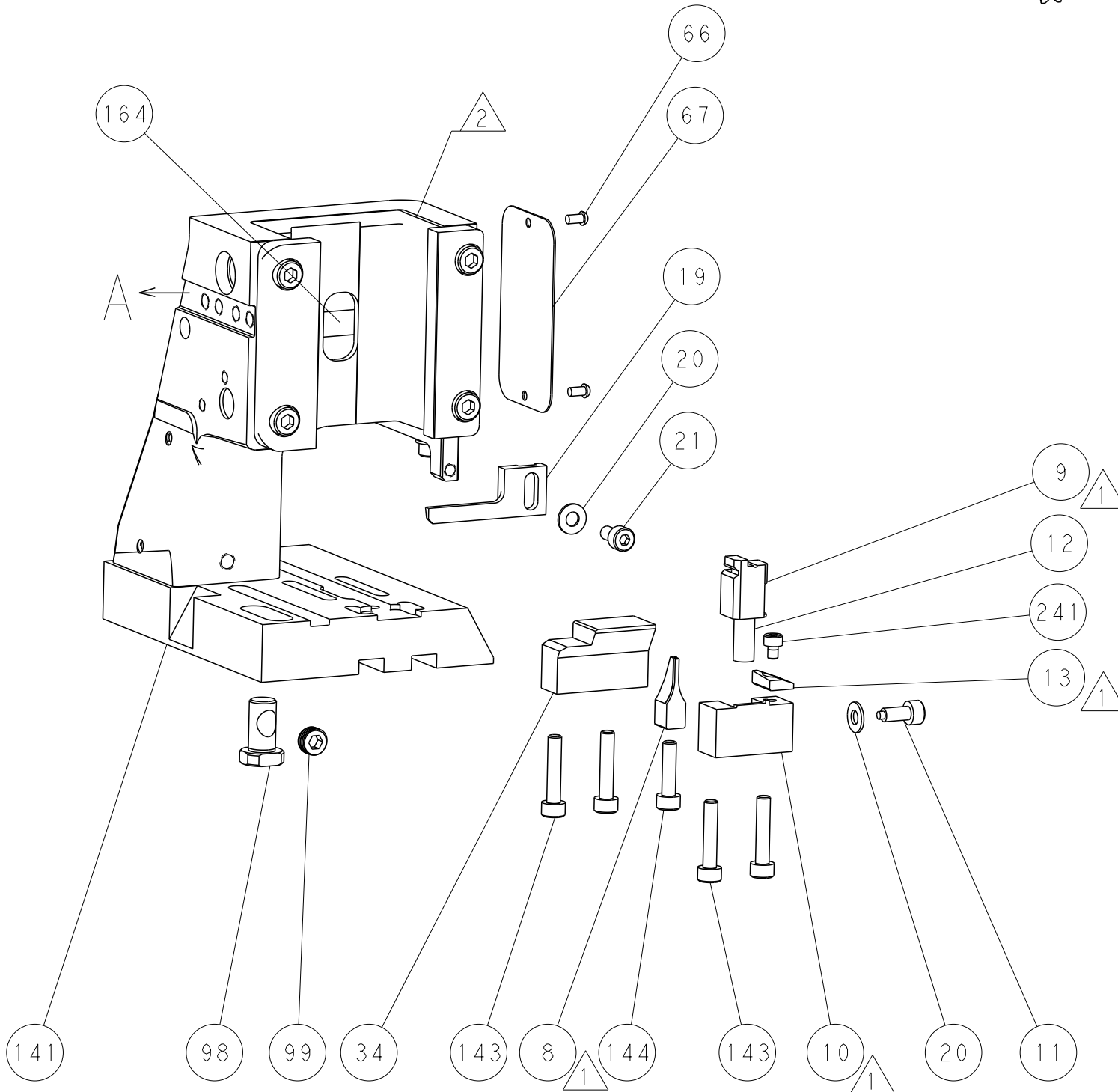
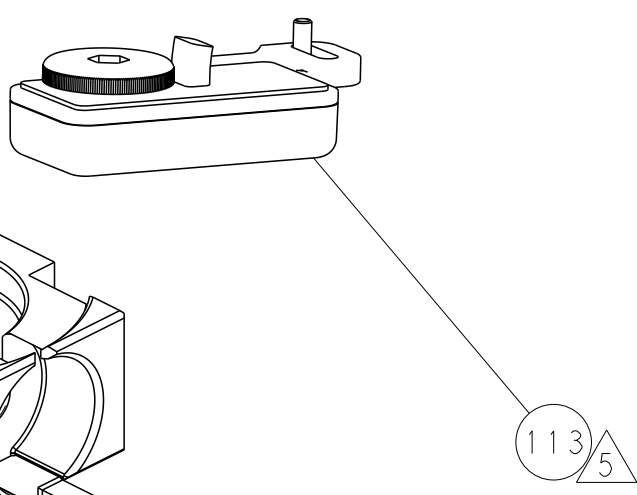
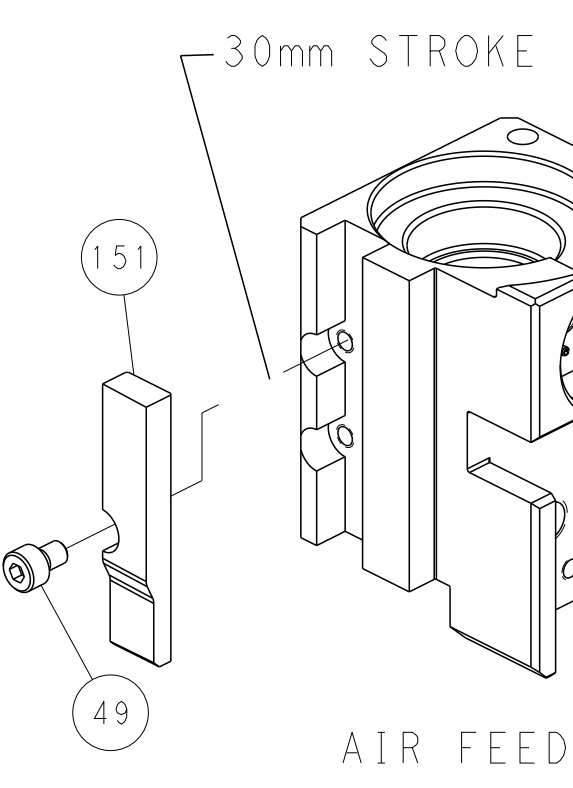
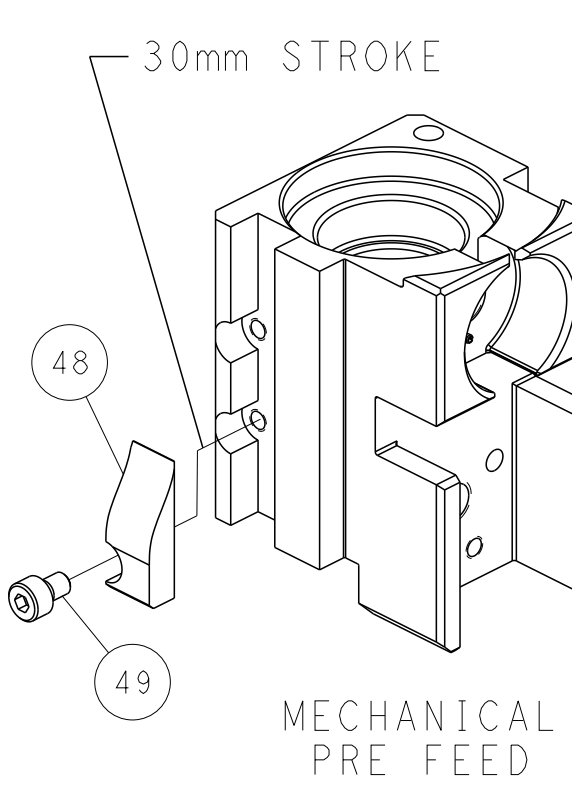
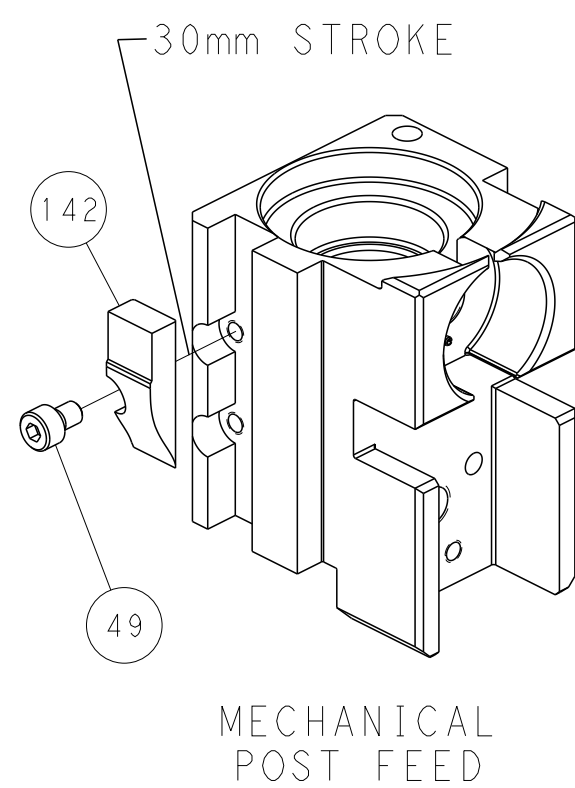
FEED TYPE MECHANICAL



PNEUMATIC



CAM POSITIONS



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

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				CHK	L. ZHANG	12OCT2012													
DIMENSIONS:		TOLERANCES, UNLESS OTHERWISE SPECIFIED:		APVD	S. XI	12OCT2012	NAME		Ocean Side Feed Applicator										
mm				PRODUCT SPEC															
		0 PLC ±		APPLICATION SPEC			SIZE		CAGE CODE		DRAWING NO		RESTRICTED TO						
		2 PLC ±																	
		2 PLC ±																	
		2 PLC ±																	
		4 PLC ±																	
ANGLES ±				WEIGHT		A 00779		C=2151791											
MATERIAL		FINISH						SCALE		1:2		SHEET		4 OF 4		REV		F	
Customer Accessible Production Drawing																			