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20		20	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151440-1	D	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2151440-2	D	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151440-1	D	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2151440-2	D	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2151440-7	B	CRIMP TOOLING KIT	-

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.00 mm [.039]	F
INSUL	1.60 mm [.063]	F
APPLICATOR INSTRUCTIONS 408-35042		

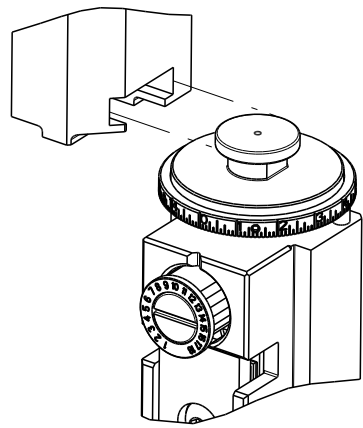
TERMINAL DATA: MOLEX TERMINAL		MOLEX CRIMP SPECIFICATION	
TERMINAL NAME: SL FEMALE CRIMP TERMINAL			
WIRE STRIP LENGTH 3.17-3.56 mm [.125-.140 IN]		 INSULATION DIAMETER RANGE Ø1.01-1.52 mm [.040-.060 IN]	
TERMINAL APPLICATION SPECIFICATION		ATS-63900-3100 Rev D	
		-	-
TERMINALS APPLIED			
TE TERMINAL	MOLEX TERMINAL	TE TERMINAL	MOLEX TERMINAL
286784-1	16-02-0069	1572377-1	16-02-0119
286784-2	16-02-0082	1572377-2	16-02-1113
286784-3	16-02-0083	1572377-3	16-02-1112

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
24 AWG	0.815+/-0.025 [.032+/- .001]	5.5
26 AWG	0.765+/-0.025 [.030+/- .001]	5.9
28 AWG	0.735+/-0.025 [.029+/- .001]	6.1
30 AWG	0.685+/-0.025 [.027+/- .001]	6.6



- 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 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
				B		RELEASED	20NOV2013
				B1		ECR-14-004176	20MAR2014
				C		ECR-18-012444	06AUG2018
				D		ECR-18-016100	11OCT2018

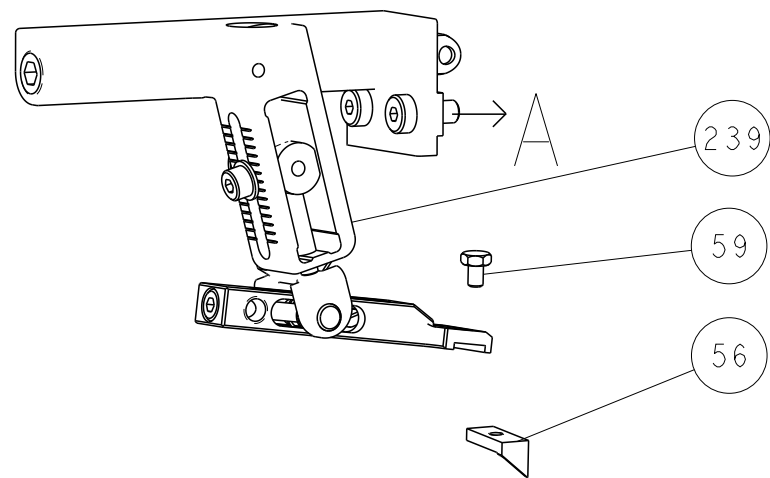
1	-	1	1	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	283
	-	1	1	1	1	2280441-1	INSERT, SHEAR	282
	-	1	-	1	-	2119640-1	PUSH ROD, AIR FEED	250
	-	1	-	1	-	1803259-1	BUSHING, FLANGED	249
	-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248
3	-	1	1	1	1	2119082-4	CAM, SNAIL, INSULATION ADJUSTMENT	244
	-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
	-	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
	-	1	1	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
	-	-	1	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
5	-	1	-	1	-	2063440-1	AIR FEED MODULE	238
	-	1	1	1	1	356885-4	STOP, SHEAR	237
	-	2	-	2	-	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172
	-	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
	-	1	-	1	-	240638-1	SPRING, FEED FINGER	163
5	-	1	-	1	-	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854	137
	-	1	-	1	-	2119799-1	HOLDER,FEED FINGER, AF	136
	-	1	1	1	1	8-1655316-7	SCR, SKT HD CAP, M5 X 65	124
	-	1	1	1	1	2119955-5	ASSY, LUBRICATOR, SIDE FEED	113
	-	1	1	1	1	2844908-1	SCREW, LOCKING	99
5	-	1	1	1	1	2844907-1	POST, LOCKING	98
	-	1	1	1	1	1-22281-8	SPRING, COMPRESSION	96
	-	1	1	1	1	980371-4	SCR, SKT HD SHLDR 5.0 DIA X 6.0	83
	-	1	1	1	1	1-455888-0	SPACER, CRIMPER	82
	-	1	1	1	1	7-240641-1	SPACER	81
5	-	1	1	1	1	1803607-1	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
	-	4	4	4	4	4-1655316-4	SCR, SKT HD CAP, M3 X 8.0	65
5	-	2	2	2	2	2-18032-5	SCR, SET, FLT PNT, M5 X 20.0	61
	-	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	1338683-1	FEED PAWL	56
	-	4	4	4	4	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	54
5	-	2	2	2	2	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	53
	-	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
5	-	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	2305692-1	PLATE, REAR STRIP GUIDE	29
	-	2	2	2	2	1-22284-0	SPRING, COMPRESSION	27
	-	1	1	1	1	356835-1	LEVER, DRAG RELEASE	26
5	-	1	1	1	1	240792-1	DRAG, TERMINAL	25
	-	1	1	1	1	1-690487-7	GUIDE, FRONT STRIP	24
	-	1	1	1	1	690438-1	FRONT STRIP GUIDE	23
	-	1	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
	-	2	2	2	2	1-18028-2	WASHER, FLAT, REG M4	20
5	-	1	1	1	1	2119533-1	STRIPPER, SIDE FEED	19
	-	1	1	1	1	690518-1	HOLD DOWN, TERMINAL	18
	-	1	1	1	1	690463-6	FLOATING SHEAR, REAR	17
	-	2	2	2	2	1-2168083-1	SCR, SKT HD CAP, RoHS, M3 X 6	16
	-	1	1	1	1	2-690464-0	SHEAR PLATE, REAR	15
5	-	1	1	1	1	2119862-1	SHEAR HOLDER, REAR	14
	-	1	1	1	1	2119806-1	INSERT, SHEAR	13
	-	2	2	2	2	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
5	-	1	1	1	1	1803095-6	FLOATING SHEAR, FRONT -	9
	1	2	2	1	1	6-1633139-6	ANVIL, COMBINATION	8
	-	-	-	-	-	-	-	7
	-	1	1	1	1	1-690468-8	DEPRESSOR SHEAR, REAR	6
	-	1	1	1	1	2119757-4	DEPRESSOR, SHEAR	5
5	-	1	1	1	1	238011-9	BLOCK, CRIMPER SPACER	4
	1	2	2	1	1	2-1803017-4	CRIMPER, INSULATION F	3
	-	-	-	-	-	-	-	2
	1	2	2	1	1	2-1633860-5	CRIMPER, WIRE	1
	-77-72-71	-2	-1			PART NO	DESCRIPTION	ITEM NO

THIS DOCUMENT IS UNPUBLISHED. IT IS SUBJECT TO CHANGE WITHOUT NOTICE AND WITHOUT NOTICE TO THE USER. IT IS SUBJECT TO CHANGE WITHOUT NOTICE AND WITHOUT NOTICE TO THE USER. IT IS SUBJECT TO CHANGE WITHOUT NOTICE AND WITHOUT NOTICE TO THE USER.		OWN C. CHEN CHK S. XI APVD I. CRUZ	30MAY2012 30MAY2012 30MAY2012	TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH		NAME Ocean Side Feed Applicator	
MATERIAL		WEIGHT		SIZE CASE CODE DRAWING NO A1 00779 ©=2151440	
		Customer Accessible Production Drawing		SCALE 1:2 SHEET 1 OF 4 REV D	

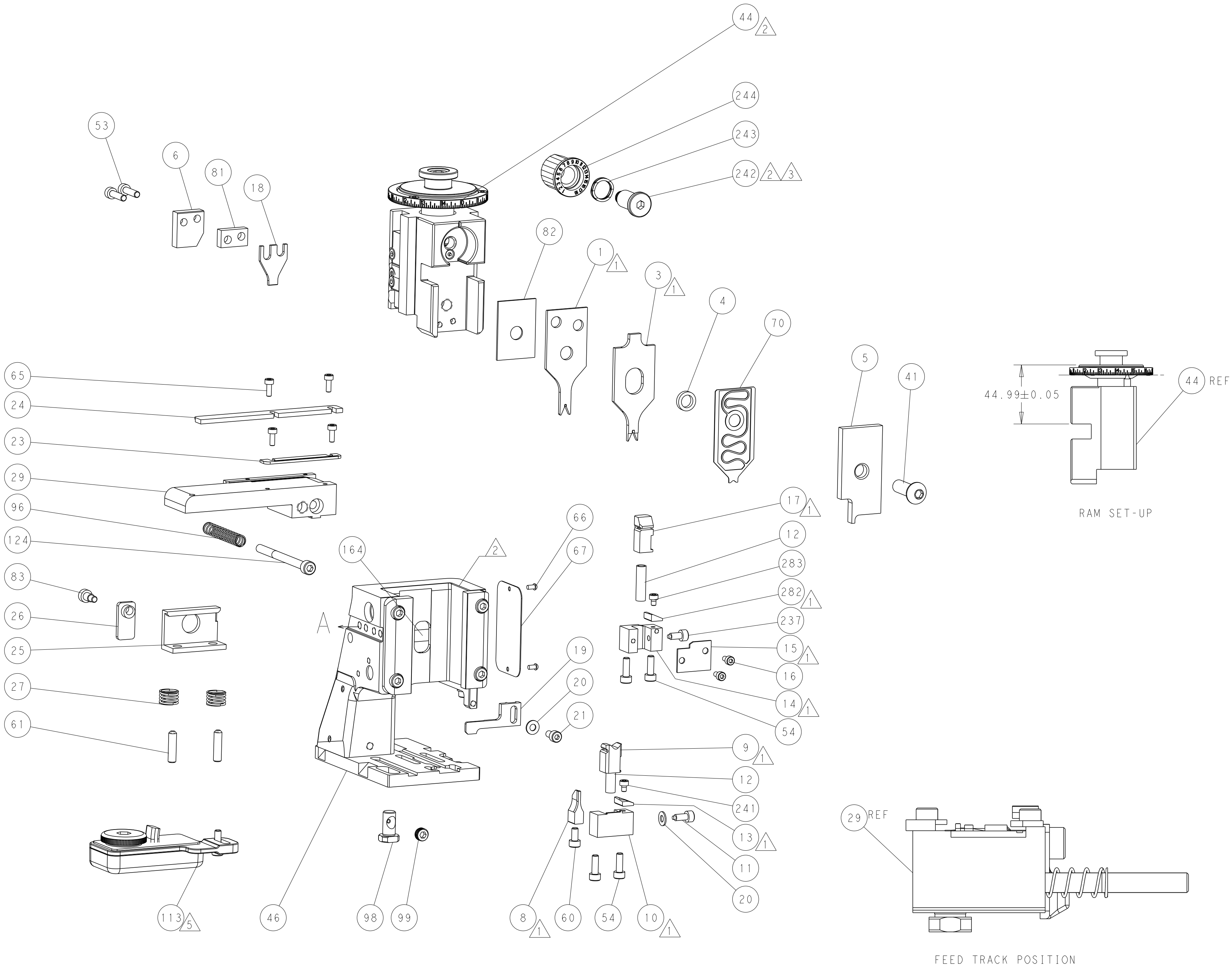
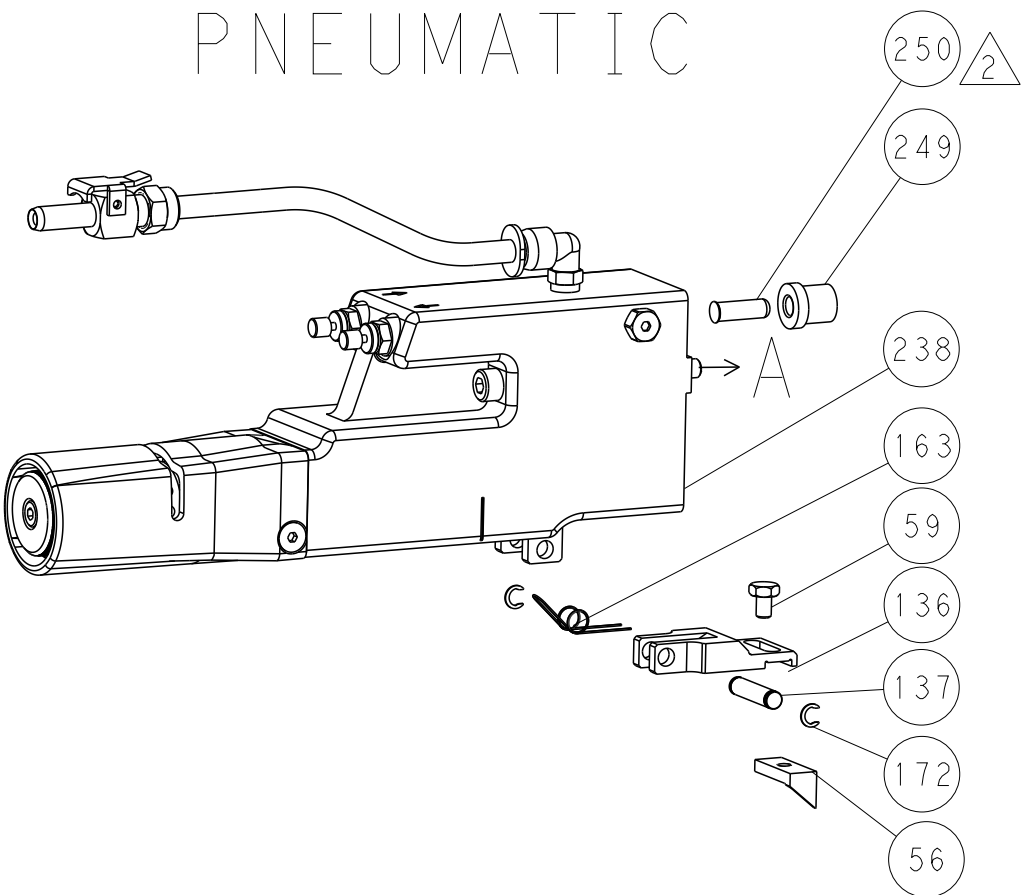
SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

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

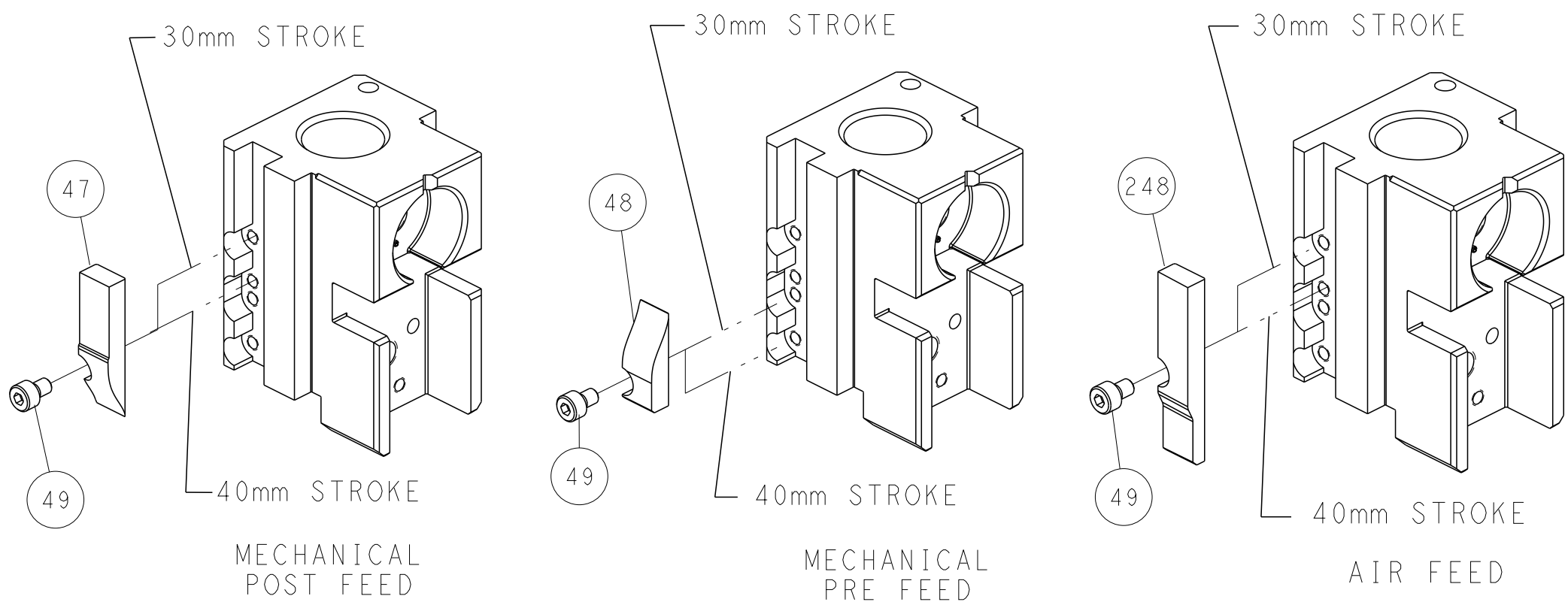
FEED TYPE
MECHANICAL



PNEUMATIC



CAM POSITIONS

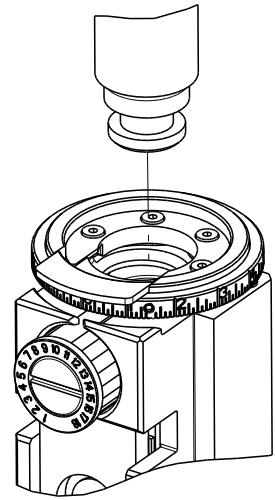


ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

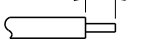
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CHK				C. CHEN	30MAY2012	NAME		
APVD				S. XI	30MAY2012	Ocean Side Feed Applicator		
PRODUCT SPEC				APPLICATION SPEC		SIZE	CAGE CODE	DRAWING NO
APPLICATION SPEC				WEIGHT		A1	00779	©=2151440
MATERIAL				Customer Accessible Production Drawing		SCALE	1:2	SHEET 2 of 4
FINISH				RESTRICTED TO		REV D		

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20		20	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2151440-1	D	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2151440-2	D	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151440-7	B	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.00 mm [.039]	F
INSUL	1.60 mm [.063]	F
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: MOLEX TERMINAL		MOLEX CRIMP SPECIFICATION	
TERMINAL NAME: SL FEMALE CRIMP TERMINAL			
WIRE STRIP LENGTH 3.17-3.56 mm [.125-.140 IN]		 INSULATION DIAMETER RANGE Ø1.01-1.52 mm [.040-.060 IN]	
TERMINAL APPLICATION SPECIFICATION		ATS-63900-3100 Rev D	
		-	-
-		-	-
TERMINALS APPLIED 			
TE TERMINAL	MOLEX TERMINAL	TE TERMINAL	MOLEX TERMINAL
286784-1	16-02-0069	1572377-1	16-02-0119
286784-2	16-02-0082	1572377-2	16-02-1113
286784-3	16-02-0083	1572377-3	16-02-1112

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
24 AWG	0.815+/-0.025 [.032+/- .001]	5.5
26 AWG	0.765+/-0.025 [.030+/- .001]	5.9
28 AWG	0.735+/-0.025 [.029+/- .001]	6.1
30 AWG	0.685+/-0.025 [.027+/- .001]	6.6



- 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.

*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
					-	SEE SHEET 1	-

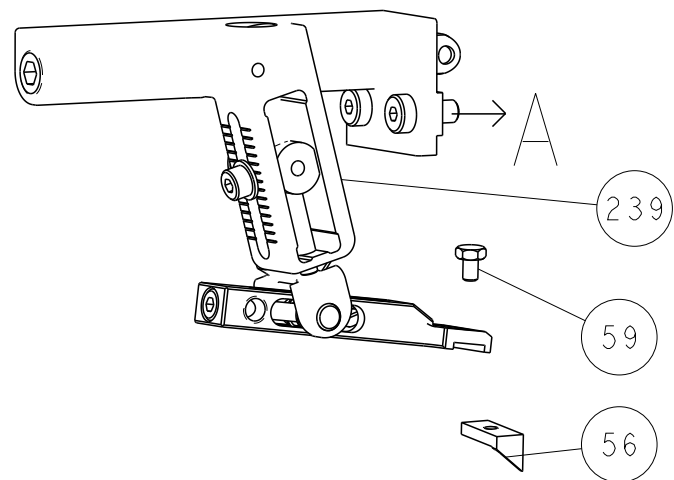
	-	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	283
	-	1	1	2280441-1	INSERT, SHEAR	282
	-	1	-	2119640-1	PUSH ROD, AIR FEED	250
	-	1	-	1803259-1	BUSHING, FLANGED	249
	-	1	1	2119082-4	CAM, SNAIL, INSULATION ADJUSTMENT	244
	-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
	-	1	1	2119083-1	RETAINER, INSULATION DIAL	242
	-	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
	-	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
	-	1	-	2063440-1	AIR FEED MODULE	238
	-	1	1	356885-4	STOP, SHEAR	237
	-	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
	-	1	1	8-1655316-7	SCR, SKT HD CAP, M5 X 65	124
	-	1	1	2119955-5	ASSY, LUBRICATOR, SIDE FEED	113
	-	1	1	2844908-1	SCREW, LOCKING	99
	-	1	1	2844907-1	POST, LOCKING	98
	-	1	1	1-22281-8	SPRING, COMPRESSION	96
	-	1	1	980371-4	SCR, SKT HD SHLDR 5.0 DIA X 6.0	83
	-	1	1	1-455888-0	SPACER, CRIMPER	82
	-	1	1	7-240641-1	SPACER	81
	-	1	1	1803607-1	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
	-	4	4	4-1655316-4	SCR, SKT HD CAP, M3 X 8.0	65
	-	2	2	2-18032-5	SCR, SET, FLT PNT, M5 X 20.0	61
	-	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
	-	1	1	1338683-1	FEED PAWL	56
	-	2	2	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	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	2305692-1	PLATE, REAR STRIP GUIDE	29
	-	2	2	1-22284-0	SPRING, COMPRESSION	27
	-	1	1	356835-1	LEVER, DRAG RELEASE	26
	-	1	1	240792-1	DRAG, TERMINAL	25
	-	1	1	1-690487-7	GUIDE, FRONT STRIP	24
	-	1	1	690438-1	FRONT STRIP GUIDE	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	690518-1	HOLD DOWN, TERMINAL	18
	-	1	1	690463-6	FLOATING SHEAR, REAR	17
	-	2	2	1-2168083-1	SCR, SKT HD CAP, RoHS, M3 X 6	16
	-	1	1	2-690464-0	SHEAR PLATE, REAR	15
	-	1	1	2119862-1	SHEAR HOLDER, REAR	14
	-	1	1	2119806-1	INSERT, SHEAR	13
	-	2	2	3-22280-3	SPRING, COMPRESSION	12
	-	1	1	1-356885-4	STOP, SHEAR	11
	-	1	1	2119805-1	SHEAR HOLDER, FRONT	10
	-	1	1	1803095-6	FLOATING SHEAR, FRONT	9
	1	1	1	6-1633139-6	ANVIL, COMBINATION	8
	-	-	-	-	-	7
	-	1	1	1-690468-8	DEPRESSOR SHEAR, REAR	6
	-	1	1	2119757-4	DEPRESSOR, SHEAR	5
	-	1	1	238011-9	BLOCK, CRIMPER SPACER	4
	1	1	1	2-1803017-4	CRIMPER, INSULATION F	3
	-	-	-	-	-	2
	1	1	1	2-1633860-5	CRIMPER, WIRE	1

-77 -22 -21			PART NO		DESCRIPTION			ITEM NO							
DESIGNED FOR THE ELECTRONIC CORPORATION AND CONTROL AND ENGINEERING DEPARTMENT FOR THE LATEST REVISION.															
DWN		30MAY2012		 TE Connectivity Harrisburg, PA 17105-3608											
CHK		30MAY2012													
S.XI															
APVD		30MAY2012		NAME	Ocean Side Feed Applicator										
PRODUCT SPEC															
APPLICATION SPEC															
MATERIAL															
FINISH															
WEIGHT															
Customer Accessible Production Drawing				SCALE					1:2	SHEET	3	OF	4	REV	D
0 PLC		±													
1 PLC		±													
2 PLC		±													
3 PLC		±													
4 PLC		±													
ANGLES		±													

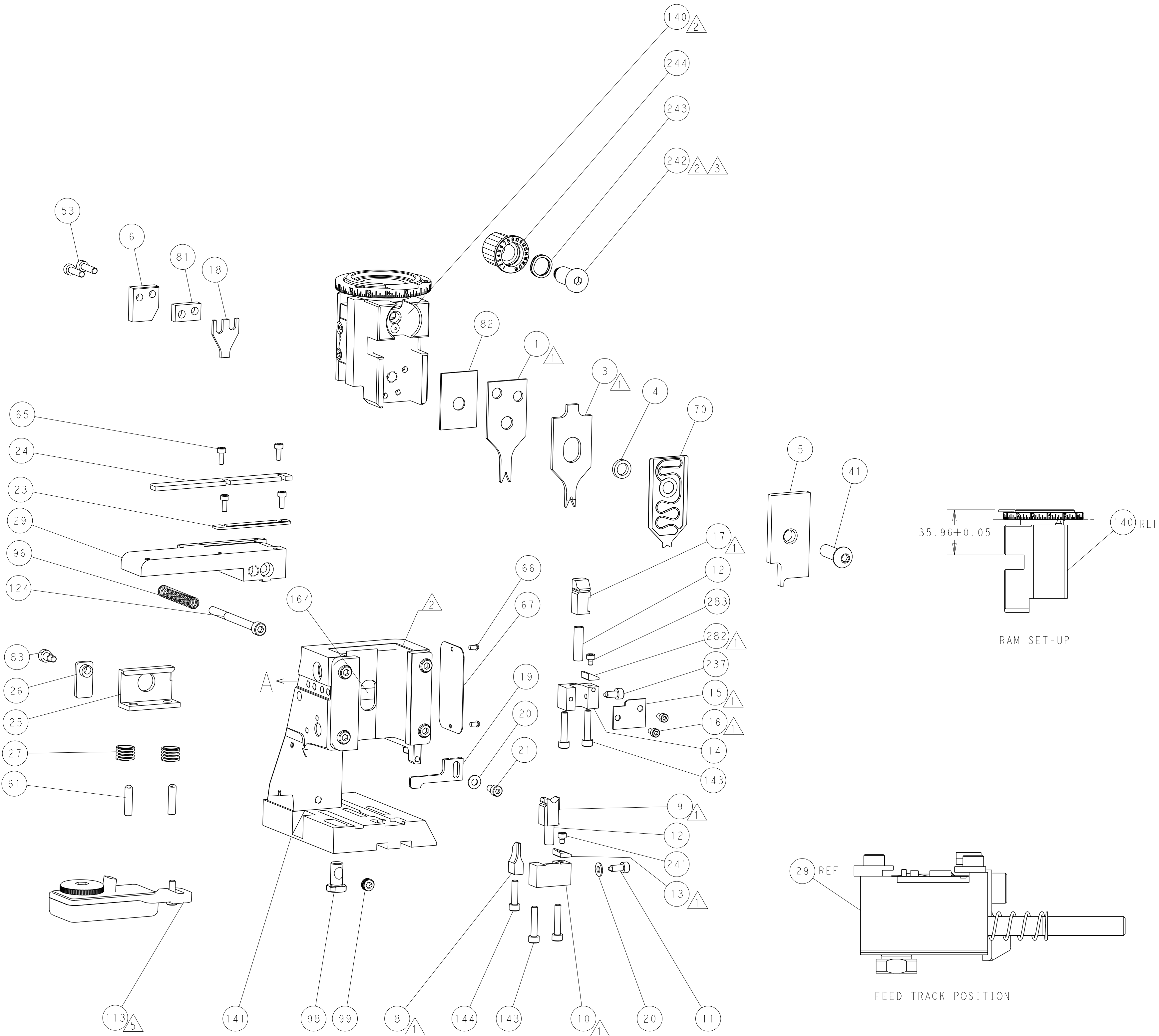
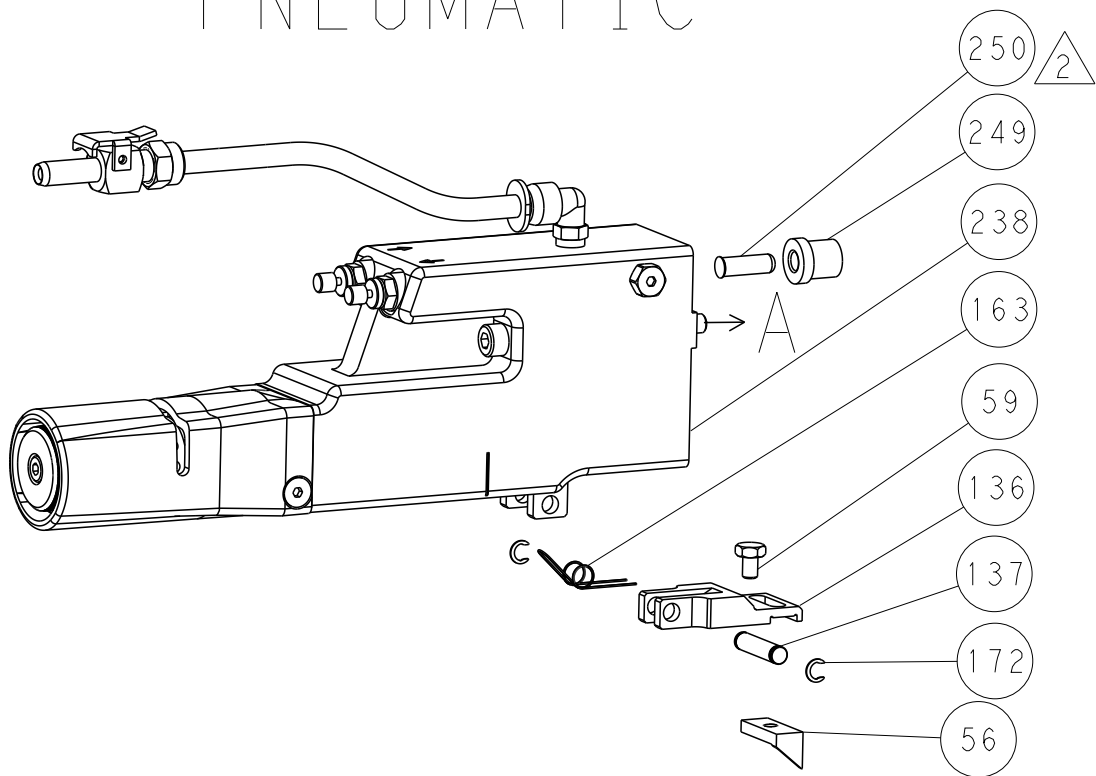
SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

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

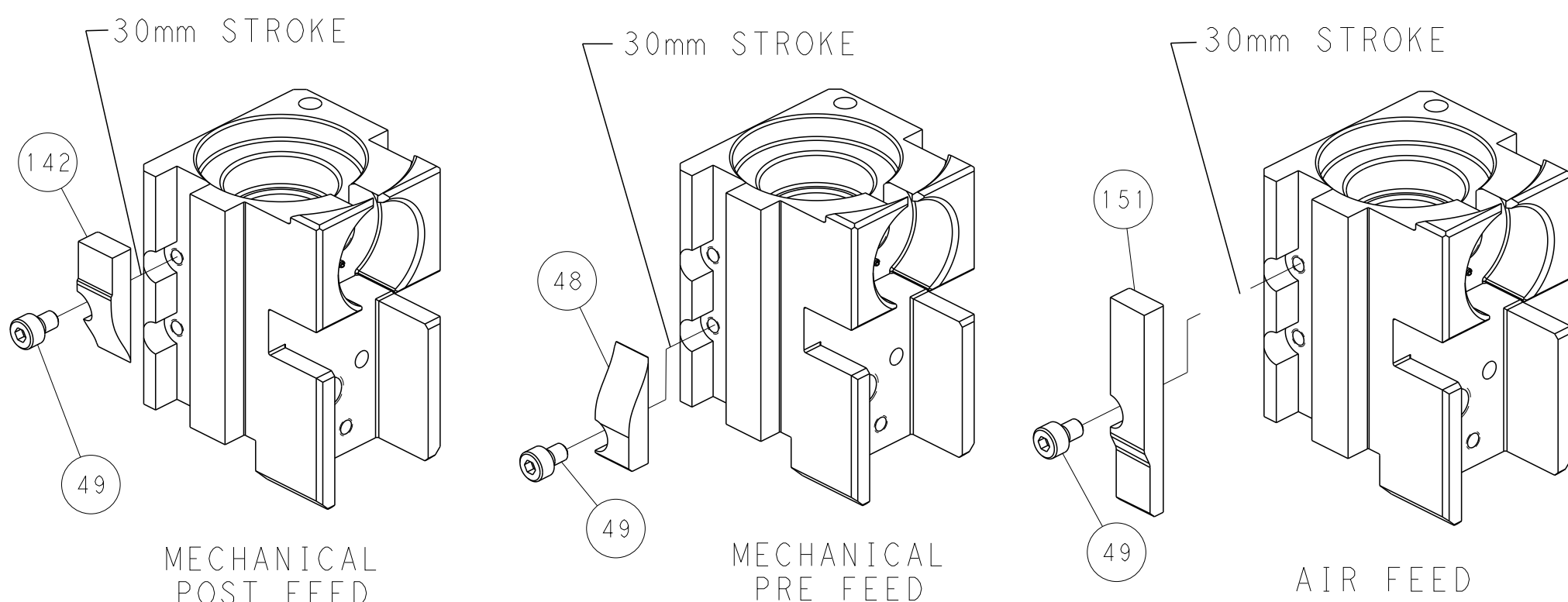
FEED TYPE
MECHANICAL



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)

THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. THE USER SHALL BE RESPONSIBLE FOR THE LATEST VERSION.		DWN C. CHEN 30MAY2012	STE TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm		CHK S. XI 30MAY2012	NAME Ocean Side Feed Applicator	
TOLERANCES UNLESS OTHERWISE SPECIFIED:		APVD J. CRUZ 30MAY2012	SIZE A	
0 PLC ±.0005 1 PLC ±.0005 2 PLC ±.0005 3 PLC ±.0005 4 PLC ±.0005 ANGLES ±.0005 FINISH -		PRODUCT SPEC APPLICATION SPEC WEIGHT -	CAGE CODE 00779	
MATERIAL -		Customer Accessible Production Drawing	SCALE 1:2	SHEET 4 OF 4
		REV D		