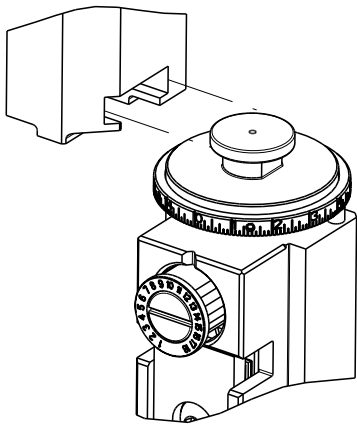
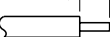


8		7	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151580-1	F	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2151580-2	G	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151580-1	F	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2151580-2	G	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2151580-7	D	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.57 mm [.062]	F
INSUL	1.70 mm [.067]	F
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: CONTACT, FEMALE, 0.64MM, TIN PLATED			
WIRE STRIP LENGTH			INSULATION DIAMETER RANGE
3.96-4.75 mm [.156-.187 IN]			Ø1.32-2.13 mm [.052-.084 IN]
TERMINAL APPLICATION SPECIFICATION 		114-13006	-
		-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
638551-1	1326028-1	1326028-3	1488208-1
1488208-3	1488220-1		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
18 AWG	1.20+/-0.05 [.047+/- .002]	7.2
0.75mm2	1.15+/-0.05 [.045+/- .002]	7.6
20 AWG OR 0.50mm2	1.07+/-0.05 [.042+/- .002]	8.3



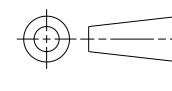
1. RECOMMENDED SPARE PARTS
2. REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
3. APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242.
4. CRIMP HEIGHT REFERENCE SETTING WAS THE SETTING USED WHEN THE APPLICATOR WAS QUALIFIED AT THE FACTORY. ADJUSTMENT MAY BE NECESSARY WHEN RUNNING APPLICATOR IN THE FIELD.
5. 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.

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

2		1					
LOC	DIST	REVISIONS					
A	66	P	LTR	DESCRIPTION	DATE	DWN	APVD
			D	ECR-17-007215	18MAY2017	KH	CT
			E	ECR-18-008204	29MAY2018	KH	JDG
			F	ECR-20-000363	10JAN2020	MZ	YY
			G	ECR-20-001908	10FEB2020	JWC	GB

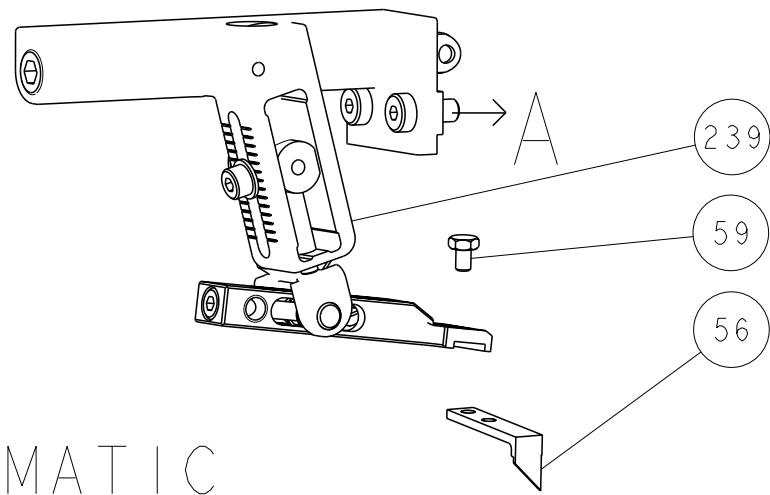
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-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248
-	1	1	1	1	2119082-5	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	1	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
-	-	1	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	1	-	1	-	2844940-1	AIR FEED MODULE	238
-	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	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	2119791-9	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	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	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	1752356-6	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	2844992-7	ASSEMBLY, STRIP GUIDE	29
-	1	1	1	1	1320928-6	STRIP GUIDE	24
-	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
-	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	1-356885-5	STOP, SHEAR	11
-	1	1	1	1	2119805-1	SHEAR HOLDER, FRONT	10
-	1	1	1	1	1803095-3	FLOATING SHEAR, FRONT -	9
-	1	2	2	1	1-1333202-8	ANVIL, COMBINATION	8
-	-	-	-	-	-	-	7
-	-	-	-	-	-	-	6
-	1	1	1	1	2119757-8	DEPRESSOR, SHEAR	5
-	1	1	1	1	238011-9	BLOCK, CRIMPER SPACER	4
-	1	2	2	1	3-1633962-0	CRIMPER, INSULATION F PREMIUM	3
-	1	1	1	1	455888-3	SPACER, CRIMPER	2
-	1	2	2	1	2-456403-1	CRIMPER, WIRE PREMIUM	1
-	77	-72	-71	-2	-1	PART NO	ITEM NO
						DESCRIPTION	

THIS DRAWING IS A CONTROLLED DOCUMENT FOR TFC ELECTRONICS CORPORATION IT IS TO BE USED TO CONTROL THE MANUFACTURING ORGANIZATION AND SHOULD BE CONTACTED FOR THE LATEST REVISION.				DWN K. HUANG 28MAR2013	 TE Connectivity Harrisburg, PA 17105-3608								
				CHK L. ZHANG 28MAR2013									
				APVD J. GUO 28MAR2013									
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		NAME		Ocean Side Feed Applicator							
mm		0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ±		PRODUCT SPEC									
		FINISH ±		APPLICATION SPEC									
MATERIAL		FINISH		WEIGHT									
-		-		-		SIZE		CAGE CODE		DRAWING NO		RESTRICTED TO	
				A		00779		C=		2151580		-	
Customer Accessible Production Drawing						SCALE		1:2		SHEET		1 of 4	
												REV G	

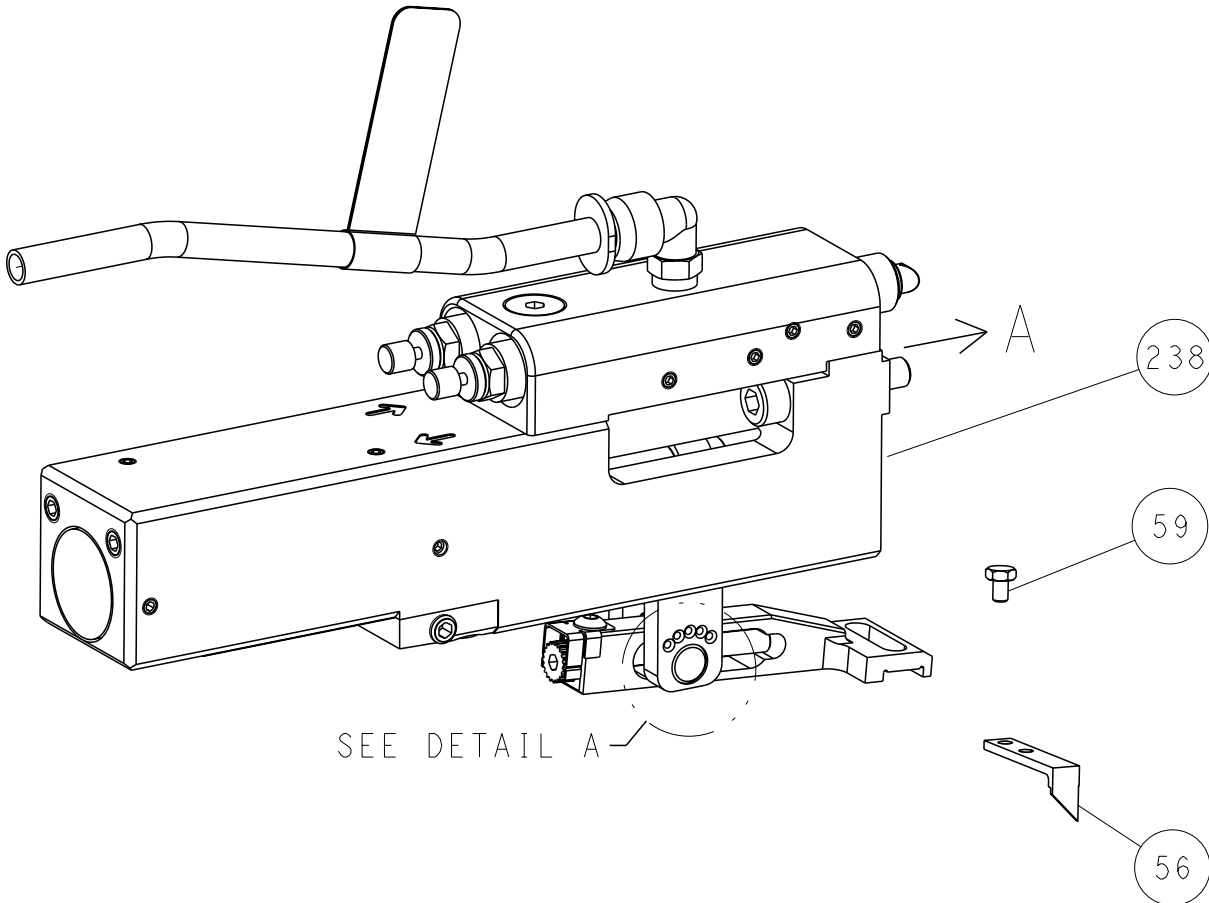
SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

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

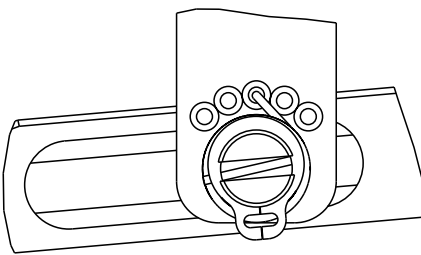
FEED TYPE MECHANICAL



PNEUMATIC

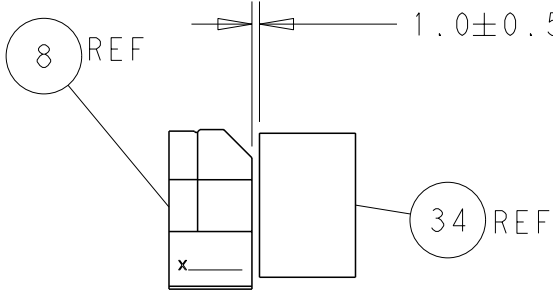
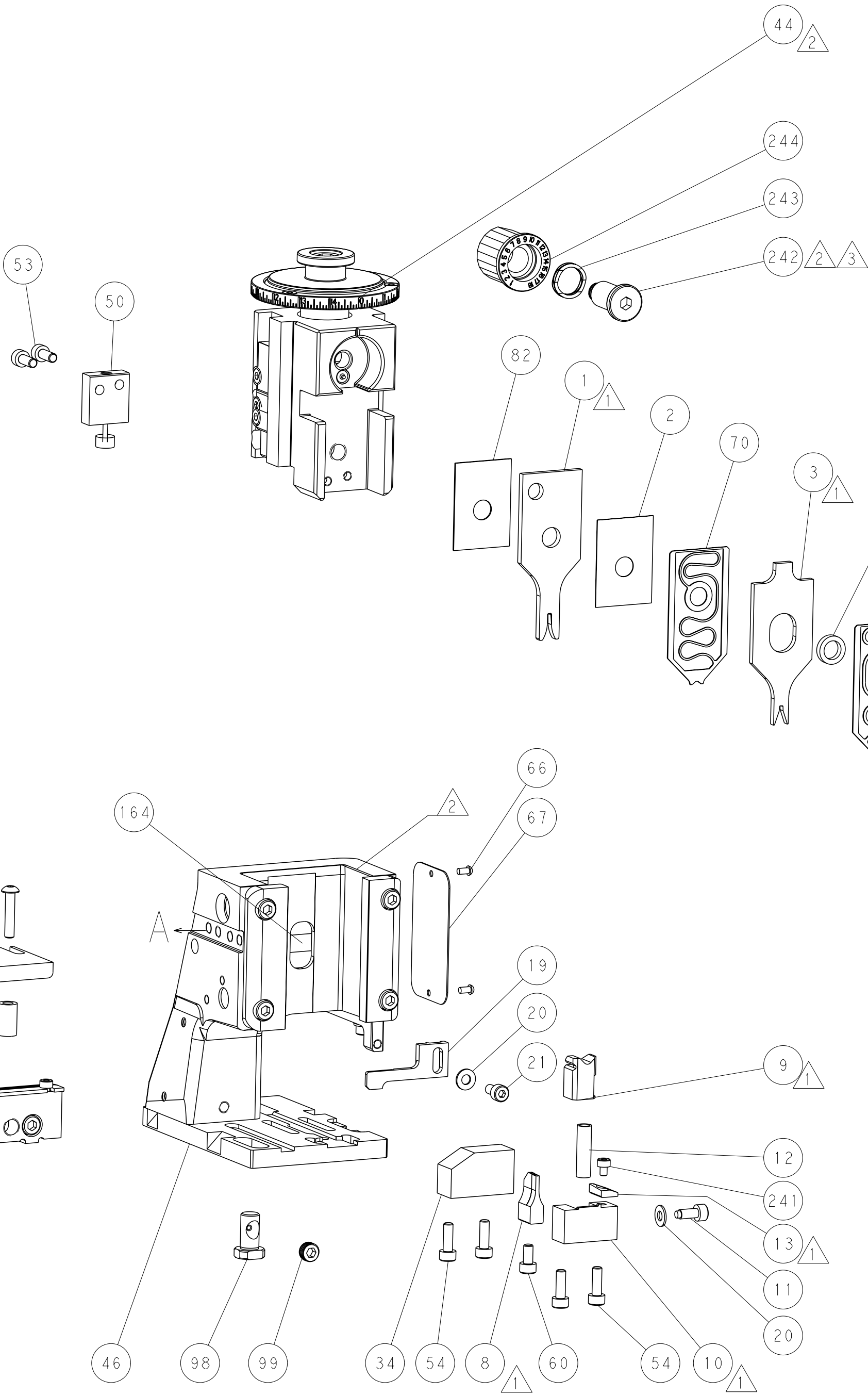
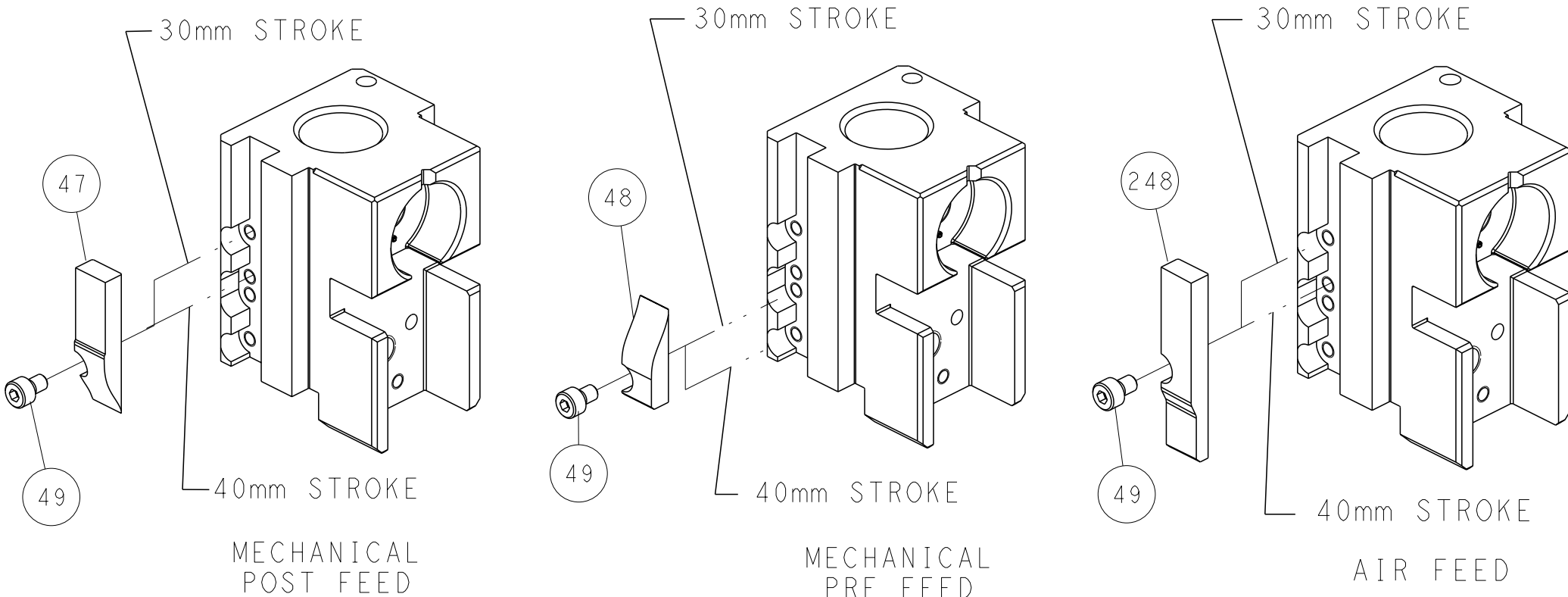


FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)

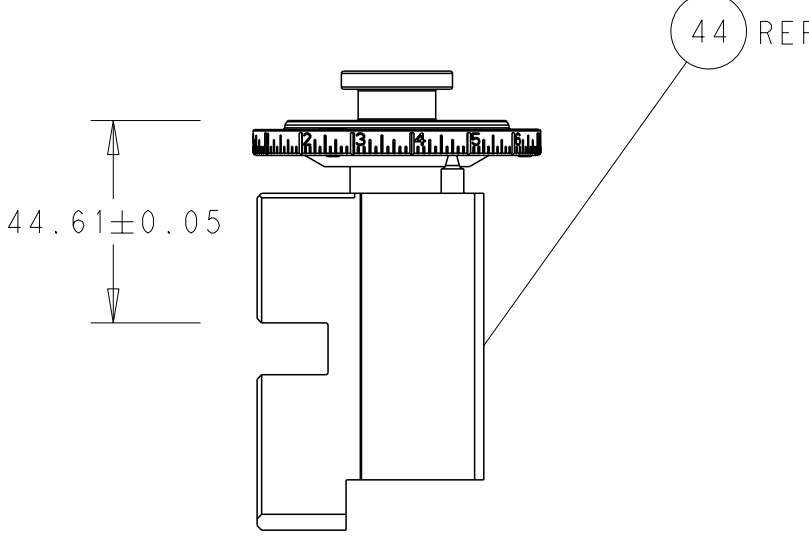


DETAIL A

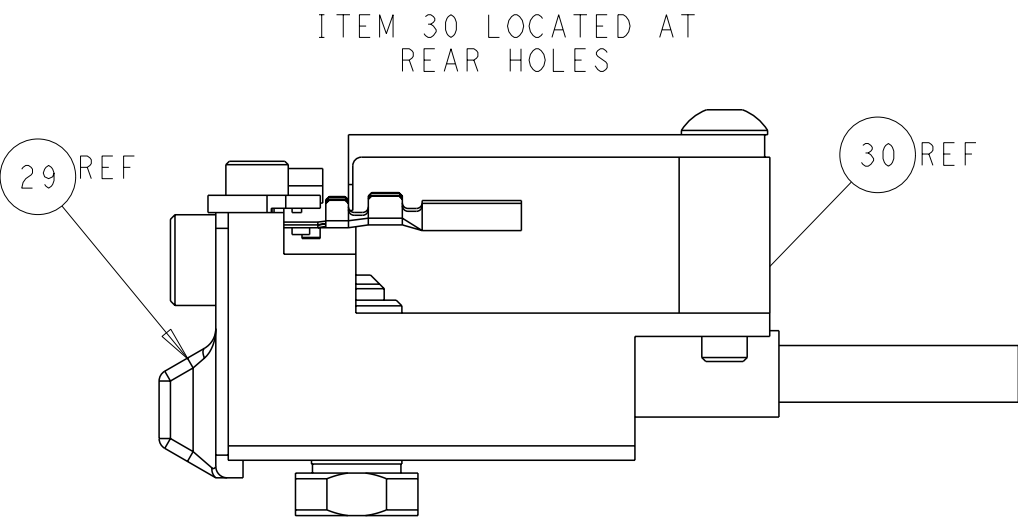
CAM POSITIONS



TERMINAL SUPPORT LOCATION



RAM SET-UP



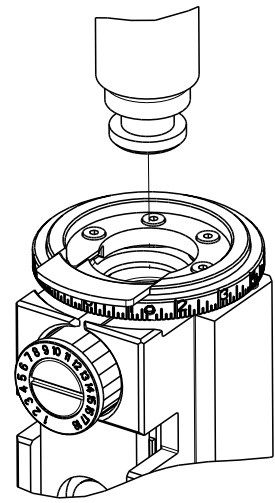
FEED TRACK POSITION
GUIDE BY INSULATION BARREL

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

1111 DRAWING IS A CONTROLLED DOCUMENT FOR YOUR ELECTRONICS CORPORATION 1111 IS SUBJECT TO CHANGE AND TO CONTROL THE ENGINEERING ORGANIZATION SHALL BE CONTACTED FOR THE LATEST REVISION				DWN K. HUANG 28MAR2013	TE Connectivity Harrisburg, PA 17105-3608		
CHK L. ZHANG 28MAR2013				APVD U. GUO 28MAR2013	NAME Ocean Side Feed Applicator		
DIMENSIONS: mm				PRODUCT SPEC	SIZE A1		
TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH ±				APPLICATION SPEC	CAGE CODE DRAWING NO 00779 C=2151580		
MATERIAL -				WEIGHT -	RESTRICTED TO -		
Customer Accessible Production Drawing				SCALE 1:2	SHEET 2 of 4		
					REV G		

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20		20	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2151580-1	F	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2151580-2	G	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151580-7	D	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.57 mm [.062]	F
INSUL	1.70 mm [.067]	F
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: CONTACT, FEMALE, 0.64MM, TIN PLATED			
WIRE STRIP LENGTH 3.96-4.75 mm [.156-.187 IN]			INSULATION DIAMETER RANGE Ø1.32-2.13 mm [.052-.084 IN]
TERMINAL APPLICATION SPECIFICATION		114-13006	-
TERMINAL APPLICATION SPECIFICATION		-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
638551-1	1326028-1	1326028-3	1488208-1
1488208-3	1488220-1		

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING	
18 AWG		1.20+/-0.05 [.047+/- .002]		7.2	
0.75mm2		1.15+/-0.05 [.045+/- .002]		7.6	
20 AWG OR 0.50mm2		1.07+/-0.05 [.042+/- .002]		8.3	



- △ 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.
5. 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	#	LYR	DESCRIPTION	DATE	DWN
			-	SEE SHEET 1	-	-

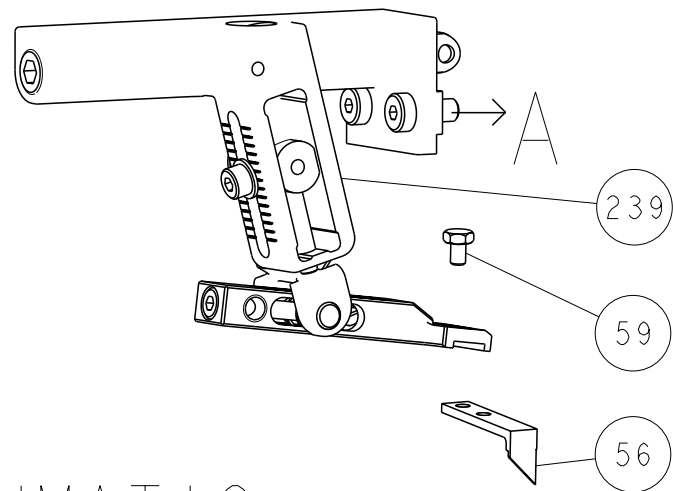
-	1	1	2119791-7	DEPRESSOR, WIRE	286
-	1	1	2119082-5	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
△	-	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
-	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	1	-	2844940-1	AIR 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	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	2119791-9	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	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	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	1752356-6	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	2844992-7	ASSEMBLY, STRIP GUIDE	29
-	1	1	1320928-6	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	2119533-1	STRIPPER, SIDE FEED	19
△	-	1	2119806-1	INSERT, SHEAR	13
-	1	1	3-22280-3	SPRING, COMPRESSION	12
-	1	1	1-356885-5	STOP, SHEAR	11
△	-	1	2119805-1	SHEAR HOLDER, FRONT	10
△	-	1	1803095-3	FLOATING SHEAR, FRONT -	9
△	1	1	1-1333202-8	ANVIL, COMBINATION	8
-	-	-	-	-	7
-	-	-	-	-	6
-	1	1	2119757-8	DEPRESSOR, SHEAR	5
-	1	1	238011-9	BLOCK, CRIMPER SPACER	4
△	1	1	3-1633962-0	CRIMPER, INSULATION F PREMIUM	3
-	1	1	455888-3	SPACER, CRIMPER	2
△	1	1	2-456403-1	CRIMPER, WIRE PREMIUM	1
-77	-22	-21	PART NO	DESCRIPTION	ITEM NO

THIS DRAWING IS CONTROLLED DOCUMENT FOR THE ELECTRICAL CONSTRUCTION IT IS SUBJECT TO CHANGE AND TO BE USED IN CONFORMANCE WITH THE LATEST REVISION SHOULD BE CONTACTED FOR THE LATEST REVISION		DWN H. HUANG 28MAR2013	STE TE Connectivity Harrisburg, PA 17105-3608		
DIMENSIONS: mm		CHK L. ZHANG 28MAR2013	NAME Ocean Side Feed Applicator		
TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		APVD J. GUO 28MAR2013	PRODUCT SPEC		
MATERIAL -		FINISH -	APPLICATION SPEC		
		WEIGHT -	SIZE A1		
		Customer Accessible Production Drawing			RESTRICTED TO -
		SCALE 1:2			REV G
		SHEET 3			OF 4
					REV G

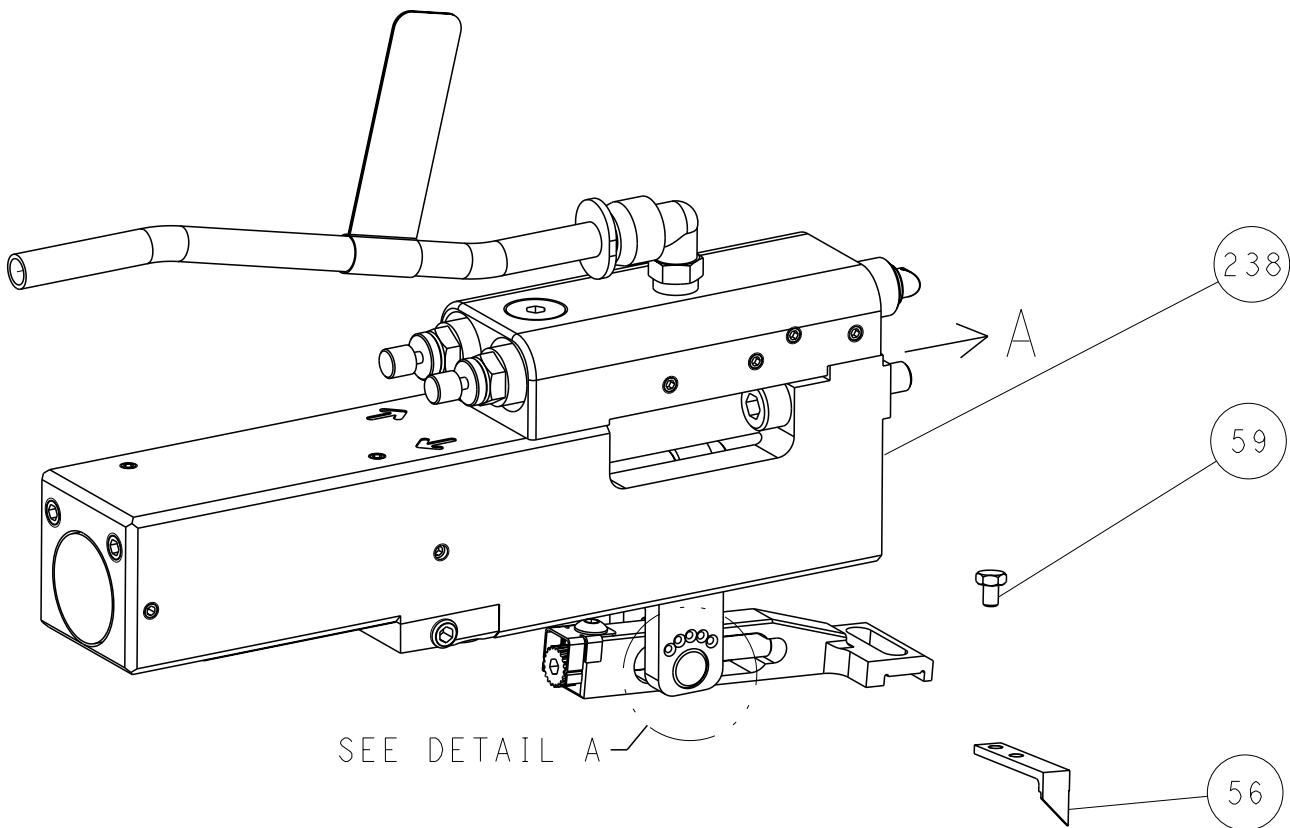
SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

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

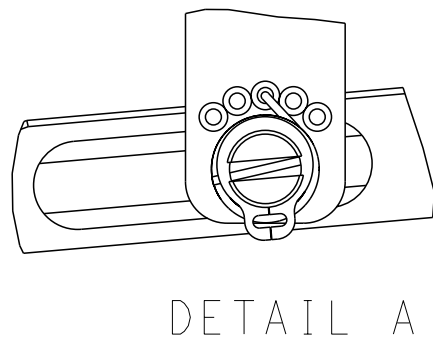
FEED TYPE MECHANICAL



PNEUMATIC

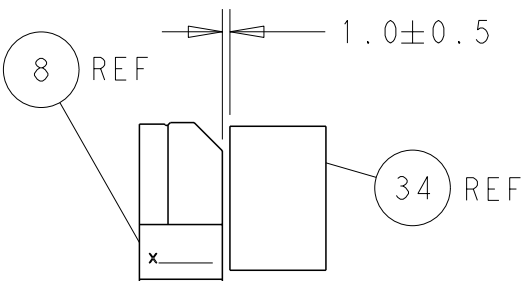
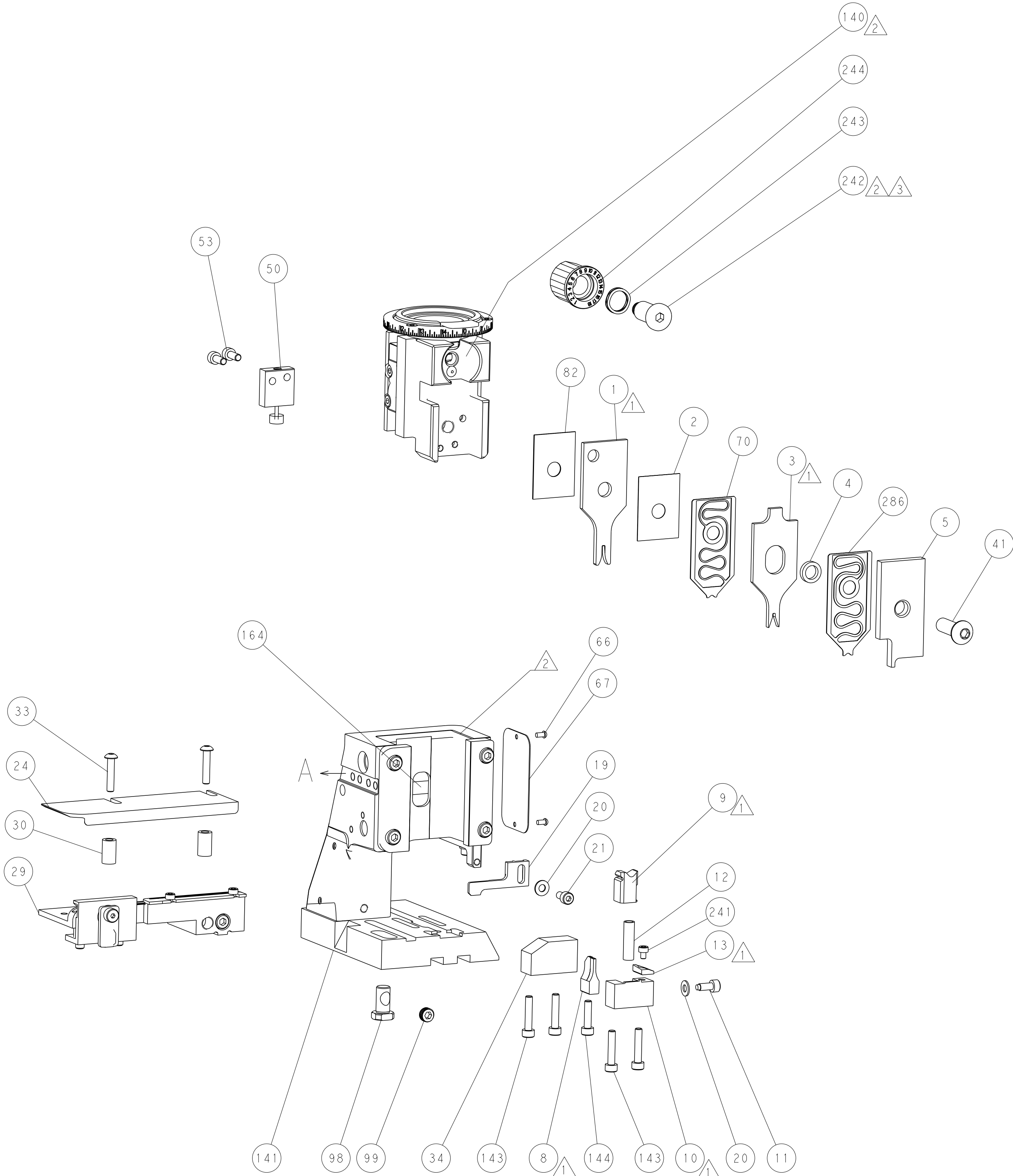
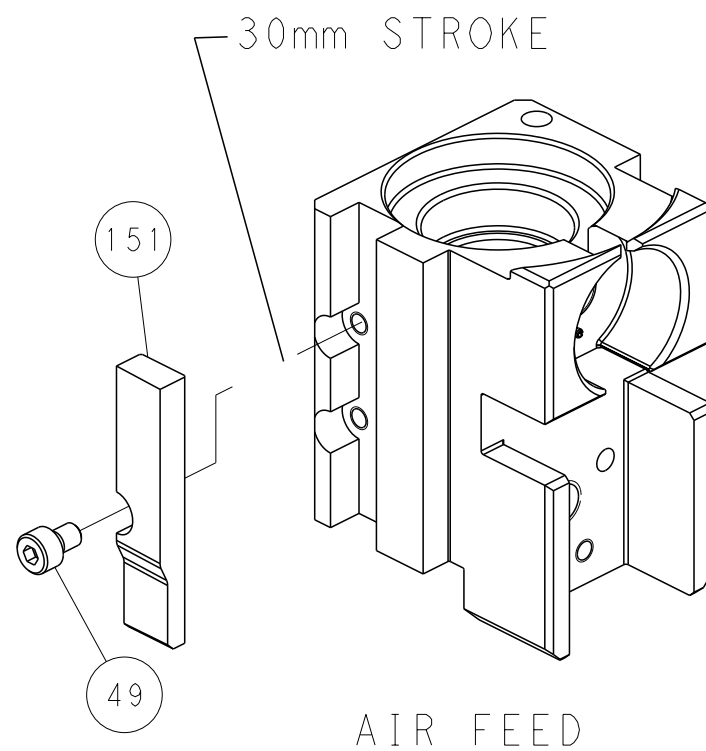
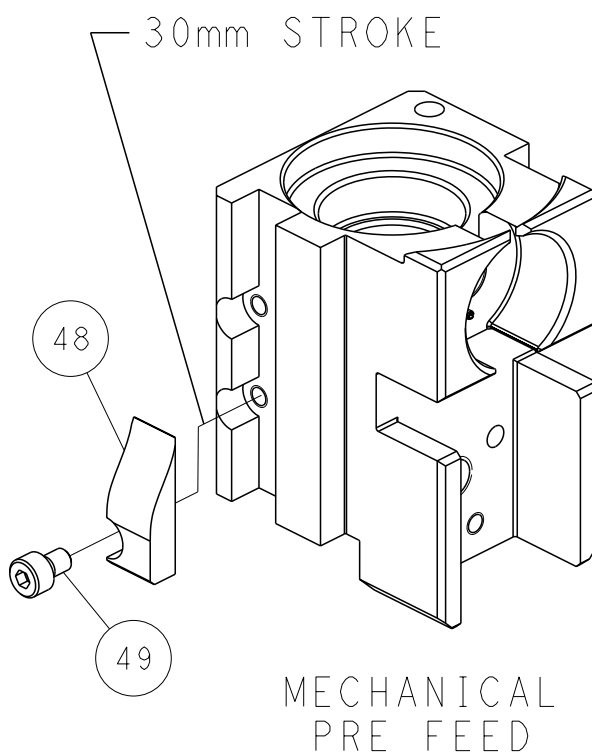
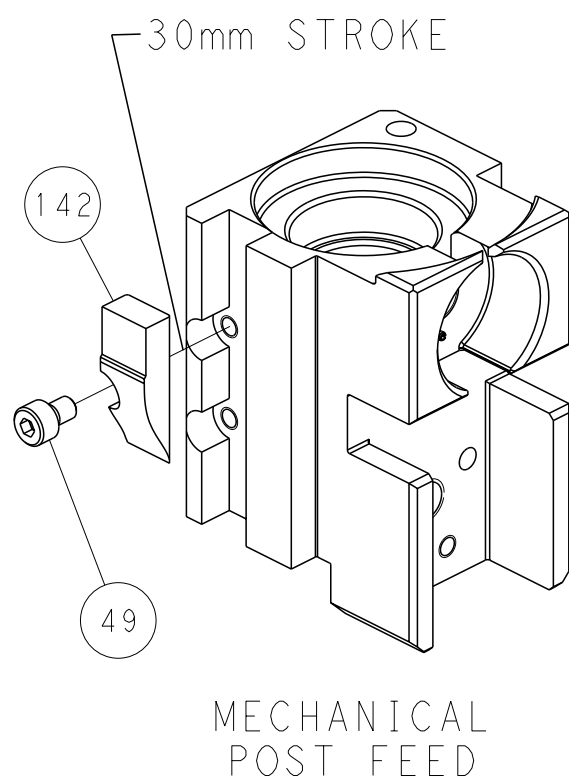


FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)

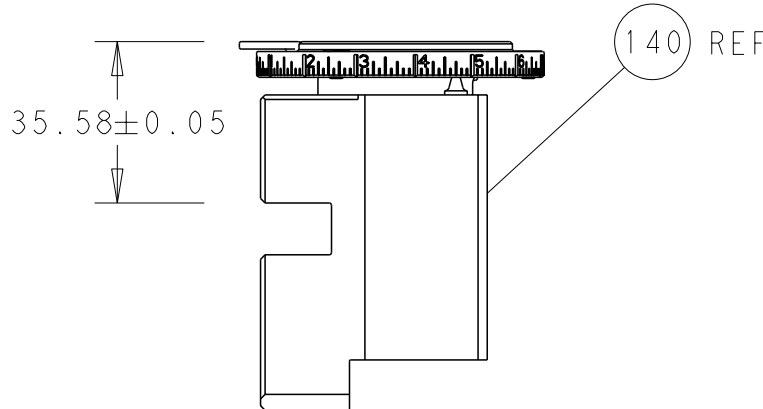


DETAIL A

CAM POSITIONS

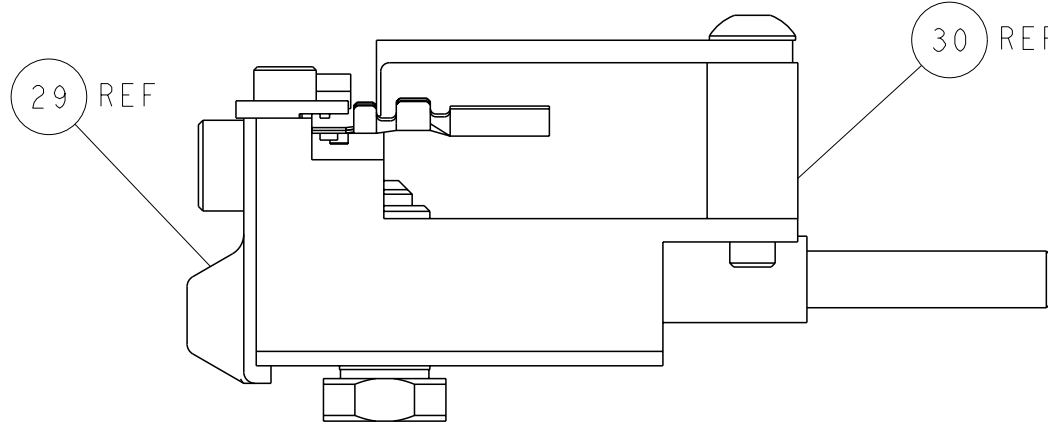


TERMINAL SUPPORT LOCATION



RAM SET-UP

ITEM 30 LOCATED AT
REAR HOLES



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)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN K. HUANG 28MAR2013		STE TE Connectivity Harrisburg, PA 17105-3608	
mm		0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		CHK L. ZHANG 28MAR2013		NAME Ocean Side Feed Applicator	
MATERIAL		FINISH		APVD U. GUO 28MAR2013		SIZE A1	
				PRODUCT SPEC		CAGE CODE 00779	
				APPLICATION SPEC		DRAWING NO C=2151580	
				WEIGHT		RESTRICTED TO	
				Customer Accessible Production Drawing		SCALE 1:2	
						SHEET 4	
						OF 4	
						REV G	

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION