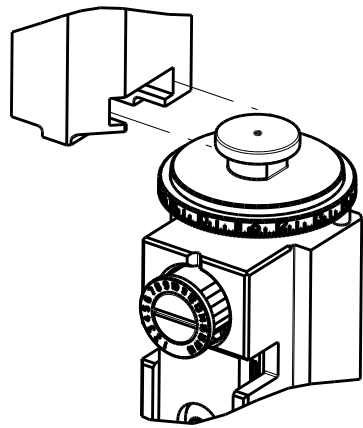


8		7	
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20		20	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151730-1	E	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2151730-2	E	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151730-1	E	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2151730-2	E	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2151730-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.03 mm [.080]	F
INSUL	4.25 mm [1.67]	O
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: 2.8mm BLADE, SEALED			
WIRE STRIP LENGTH 5.50-5.51 mm [.217-.217 IN]		INSULATION DIAMETER RANGE Ø1.20-2.70 mm [.047-.106 IN]	
TERMINAL APPLICATION SPECIFICATION		114-13013	

TERMINALS APPLIED				SEAL INSULATION DIAMETER RANGE
TE TERMINAL	TE TERMINAL	TE SEAL	YAZAKI SEAL	
1326031-8	1326032-9	1949064-1	7158-3113-40	1.2-2.7 mm
		1949064-2	7158-3112-70	1.2-2.7 mm

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
18 AWG	1.37+/-0.05 [.054+/- .002]	4.1
1.00mm2	1.30+/-0.05 [.051+/- .002]	4.9
0.75mm2	1.22+/-0.05 [.048+/- .002]	6.0



- 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 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.
- 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
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			D	ECR-15-016622			12NOV2015	KH	JT
			E	ECR-19-014658			20SEP2019	FZ	TE
			E1	ECR-20-002411			19FEB2020	MZ	YY

3	-	1	1	1	1	2-455888-9	SPACER, CRIMPER	259
	-	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
	-	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	318563-1	GUARD, FRONT CHIP	119
-	1	1	1	1	2844908-1	SCREW, LOCKING	99	
-	1	1	1	1	2844907-1	POST, LOCKING	98	
-	1	1	1	1	1-455888-7	SPACER, CRIMPER	82	
-	1	1	1	1	985575-1	SCR, FLT SKT HD CAP M3 X 6.0	81	
-	1	1	1	1	224405-2	DEPRESSOR, WIRE	80	
-	2	2	2	2	18024-6	SCR, BTN SKT HD CAP (M4 X 8.0)	79	
-	1	1	1	1	1803096-1	EXTENSION PLATE	78	
-	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	
5	-	1	1	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
	-	1	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	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	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	1803515-2	RAM ASSEMBLY, SF ATLANTIC	44	
-	1	1	1	1	1803602-2	SCR, BHSC, RoHS (M8 X 40)	41	
-	1	1	1	1	2-1752356-0	SUPPORT, TERMINAL	34	
-	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33	
-	2	2	2	2	1-2844962-8	SPACER, CYLINDRICAL, STRIP GUIDE	30	
-	1	1	1	1	2844992-4	ASSEMBLY, STRIP GUIDE	29	
-	1	1	1	1	455888-3	SPACER, CRIMPER	28	
-	1	1	1	1	240792-2	DRAG, TERMINAL	25	
-	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	
-	1	1	1	1	1-18028-2	WASHER, FLAT, REG M4	20	
-	1	1	1	1	2119533-2	STRIPPER, SIDE FEED	19	
1	-	1	1	1	1	2119806-1	INSERT, SHEAR	13
	-	1	1	1	1	3-22280-3	SPRING, COMPRESSION	12
1	-	1	1	1	1	1-356885-4	STOP, SHEAR	11
	-	1	1	1	1	2119805-1	SHEAR HOLDER, FRONT	10
1	-	1	1	1	1	318707-1	FLOATING SHEAR, FRONT	9
	1	2	2	1	1	1-1633927-6	ANVIL, COMBINATION	8
-	-	-	-	-	-	-	-	7
-	-	-	-	-	-	-	-	6
-	1	1	1	1	1	2119781-1	DEPRESSOR, SHEAR	5
-	1	1	1	1	1	2-238011-1	BLOCK, CRIMPER SPACER	4
1	1	2	2	1	1	6-2119784-2	CRIMPER, INSULATION O PREMIUM	3
	-	1	1	1	1	1-455888-9	SPACER, CRIMPER	2
1	1	2	2	1	1	1-856313-7	CRIMPER, WIRE	1
	-77	-72	-71	-2	-1	PART NO	DESCRIPTION	ITEM NO

THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. ANY CHANGES TO THIS DRAWING SHALL BE CONTACTED FOR THE LATEST REVISION.		DWN Y. YIN 25JUL2012	TE Connectivity Harrisburg, PA 17105-3608	
CHK G. BAILEY 25JUL2012		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 00779	
MATERIAL		WEIGHT	DRAWING NO 2151730	
		Customer Accessible Production Drawing	SCALE 1:2	
			SHEET 1 OF 4	
			REV E1	

AIR FEED



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20		20	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2151730-1	E	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2151730-2	E	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151730-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.03 mm [.080]	F
INSUL	4.25 mm [.167]	O
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: 2.8mm BLADE, SEALED			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
5.50-5.51 mm [.217-.217 IN]			
TERMINAL APPLICATION SPECIFICATION		114-13013	
-		-	
-		-	

TERMINALS APPLIED				SEAL INSULATION DIAMETER RANGE
TE TERMINAL	TE TERMINAL	TE SEAL PN	YAZAKI PN	
1326031-8	1326032-9	1949064-1	7158-3113-40	1.2-2.7 mm
		1949064-2	7158-3112-70	1.2-2.7 mm

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
18 AWG	1.37+/-0.05 [.054+/- .002]	4.1
1.00mm2	1.30+/-0.05 [.051+/- .002]	4.9
0.75mm2	1.22+/-0.05 [.048+/- .002]	6.0



- 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.

*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	2-455888-9	SPACER, CRIMPER	259
-	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	1803516-2	RAM ASSEMBLY, SF PACIFIC	140
-	1	1	318563-1	GUARD, FRONT CHIP	119
-	1	1	2844908-1	SCREW, LOCKING	99
-	1	1	2844907-1	POST, LOCKING	98
-	1	1	1-455888-7	SPACER, CRIMPER	82
-	1	1	985575-1	SCR, FLT SKT HD CAP M3 X 6.0	81
-	1	1	224405-2	DEPRESSOR, WIRE	80
-	2	2	18024-6	SCR, BTN SKT HD CAP (M4 X 8.0)	79
-	1	1	1803096-1	EXTENSION PLATE	78
-	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	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	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	1803602-2	SCR, BHSC, RoHS (M8 X 40)	41
-	1	1	2-1752356-0	SUPPORT, TERMINAL	34
-	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	1-2844962-8	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	2844992-4	ASSEMBLY, STRIP GUIDE	29
-	1	1	455888-3	SPACER, CRIMPER	28
-	1	1	240792-2	DRAG, TERMINAL	25
-	1	1	1320928-6	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	2119533-2	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	1-1633927-6	ANVIL, COMBINATION	8
-	-	-	-	-	7
-	-	-	-	-	6
-	1	1	2119781-1	DEPRESSOR, SHEAR	5
-	1	1	2-238011-1	BLOCK, CRIMPER SPACER	4
-	1	1	6-2119784-2	CRIMPER, INSULATION O PREMIUM	3
-	1	1	1-455888-9	SPACER, CRIMPER	2
-	1	1	1-856313-7	CRIMPER, WIRE	1

-77	-22	-21	PART NO	DESCRIPTION	ITEM NO
			DWN Y. YIN 25JUL2012	TE Connectivity Harrisburg, PA 17105-3608	
			CHK G. BAILEY 25JUL2012		
			APVD S. XI 25JUL2012	NAME Ocean Side Feed Applicator	
			PRODUCT SPEC	SIZE CAGE CODE DRAWING NO RESTRICTED TO	
			APPLICATION SPEC		
			WEIGHT	A1 00779 ©=2151730	
			Customer Accessible Production Drawing	SCALE 1:2	SHEET 3 OF 4 REV E1

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

D

C

B

A

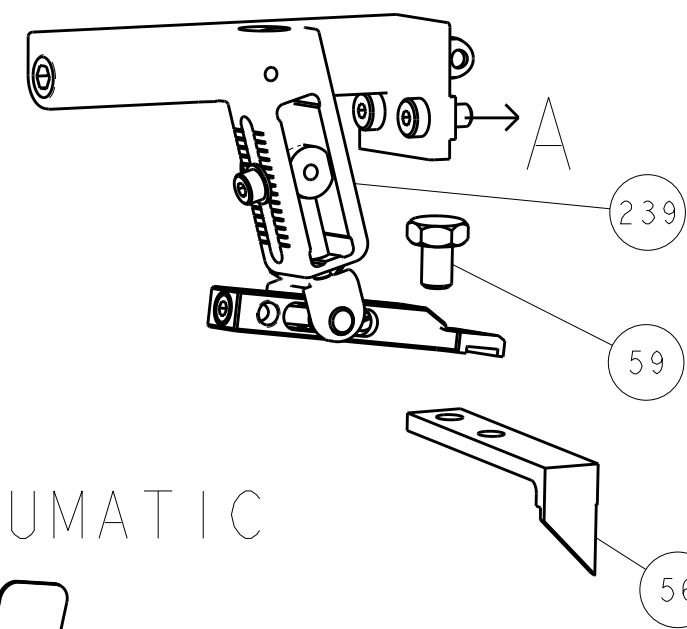
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C

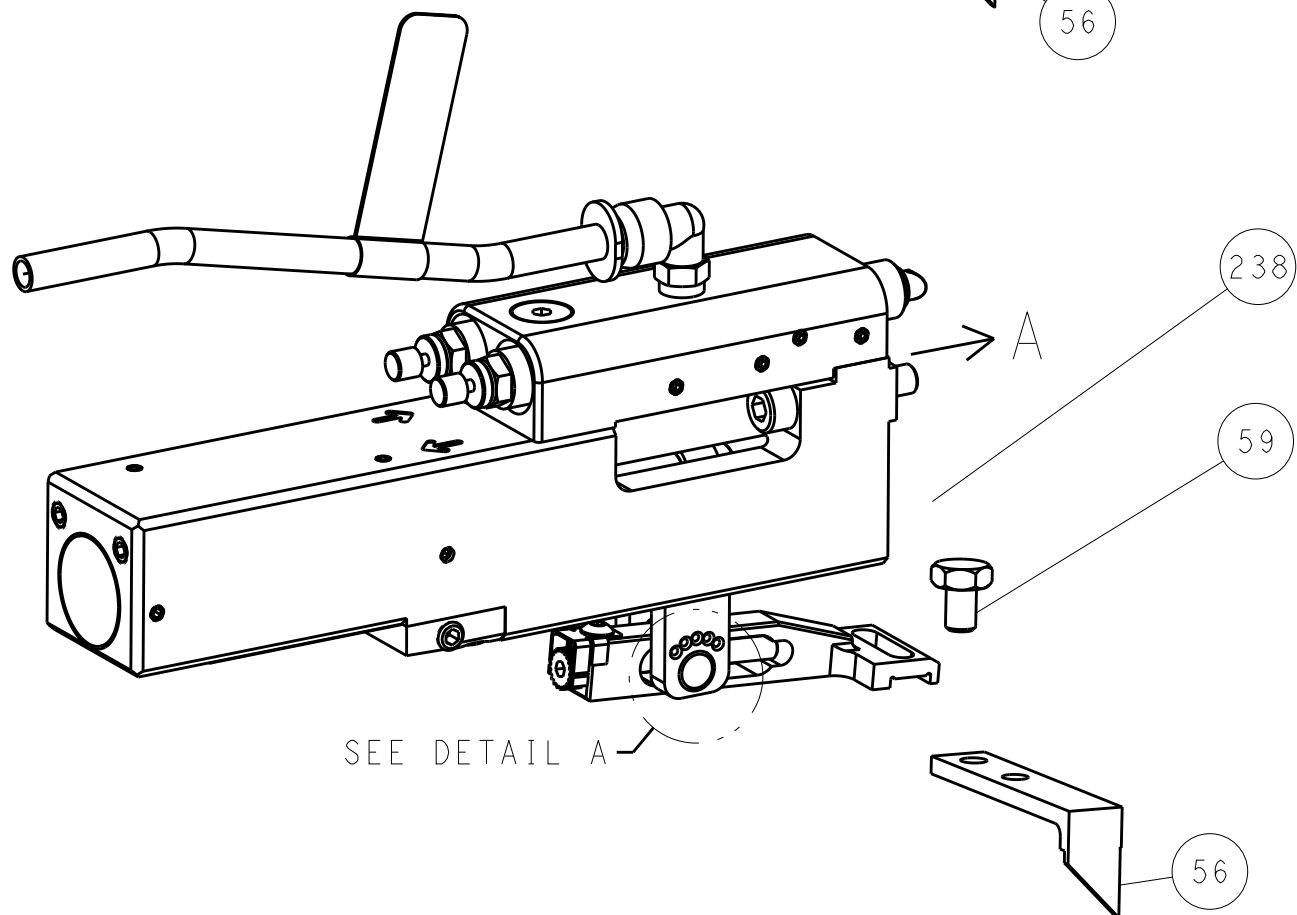
B

A

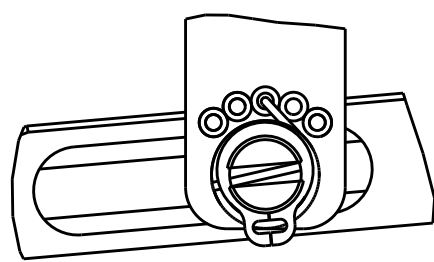
FEED TYPE MECHANICAL



PNEUMATIC

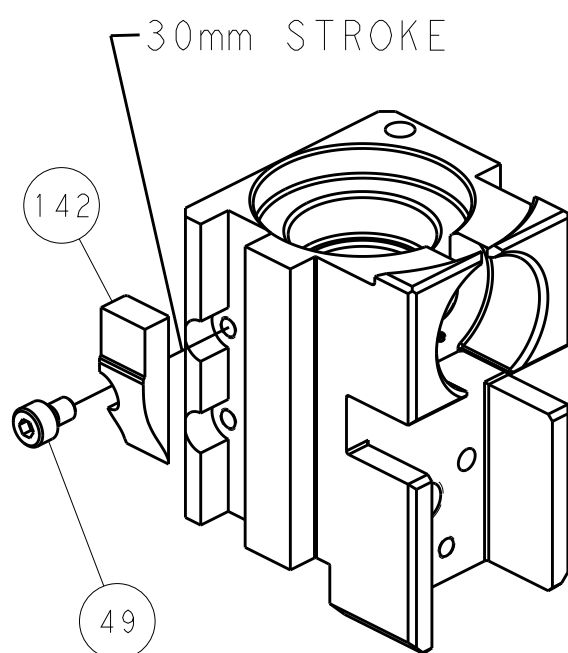


FEED SPRING SETTING POSITION
(SHOWN FROM REAR SIDE)

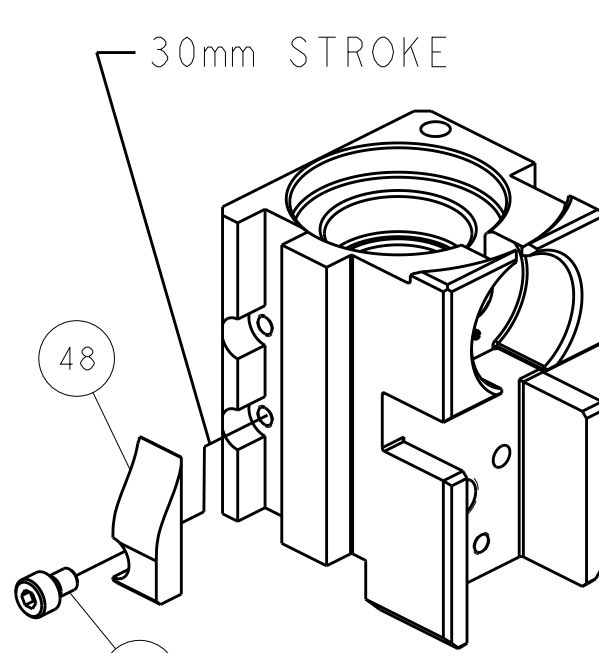


DETAIL A

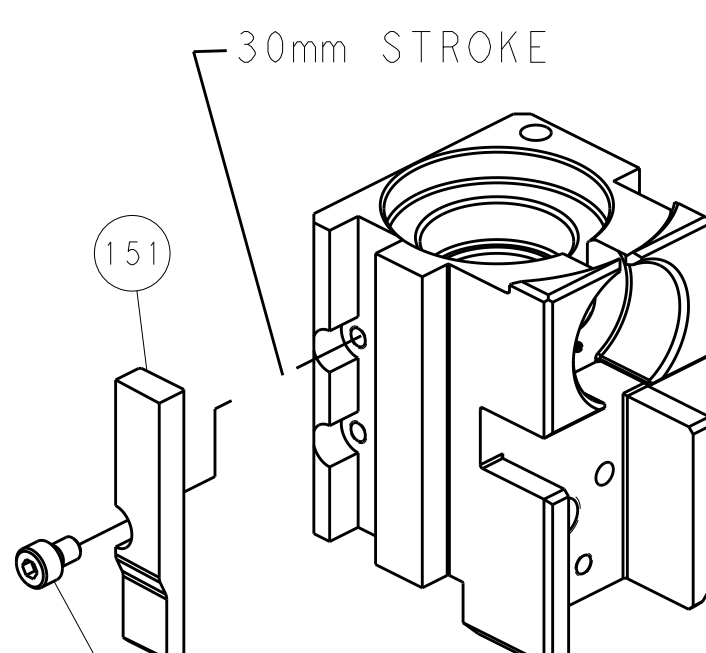
CAM POSITIONS



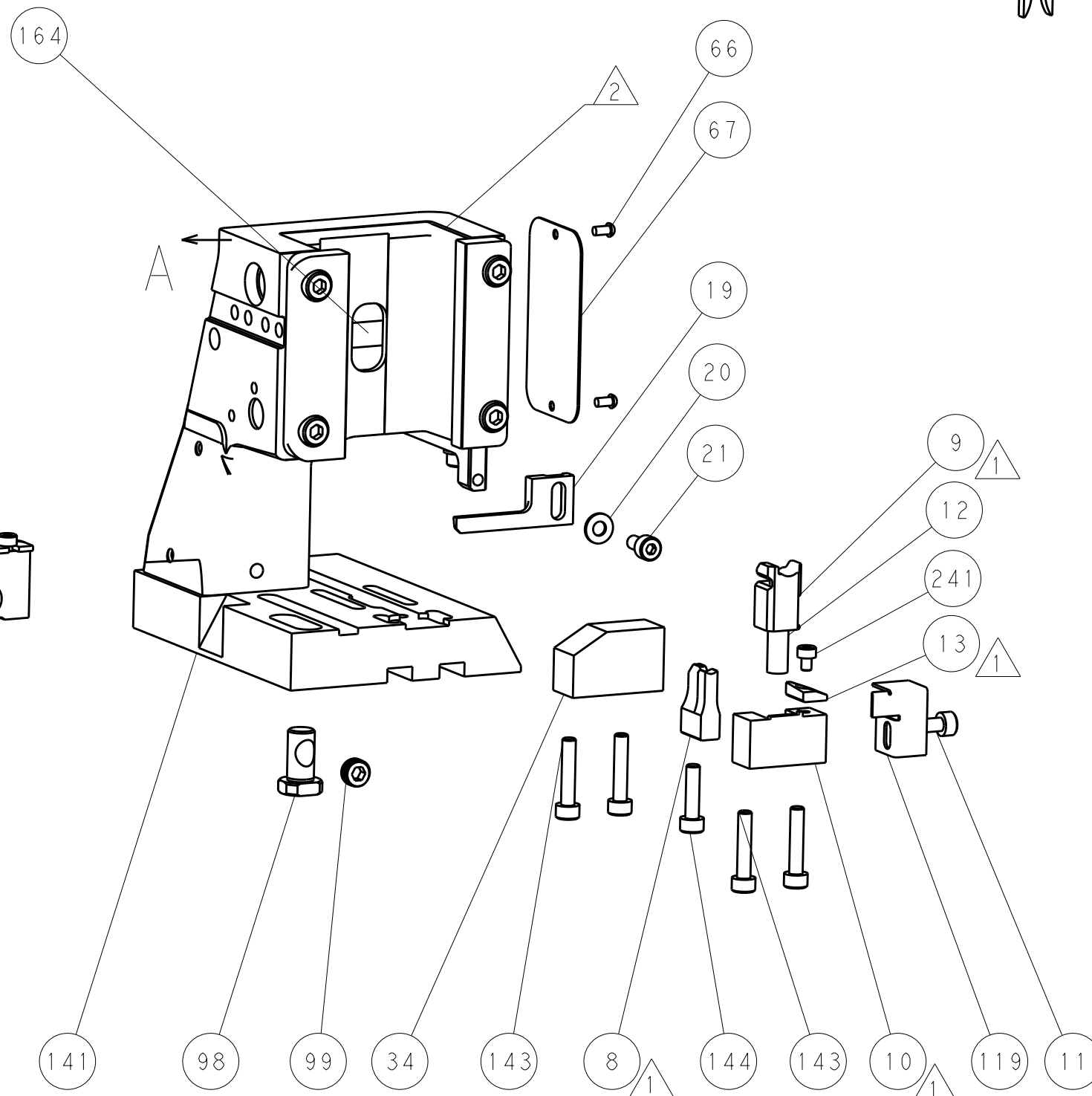
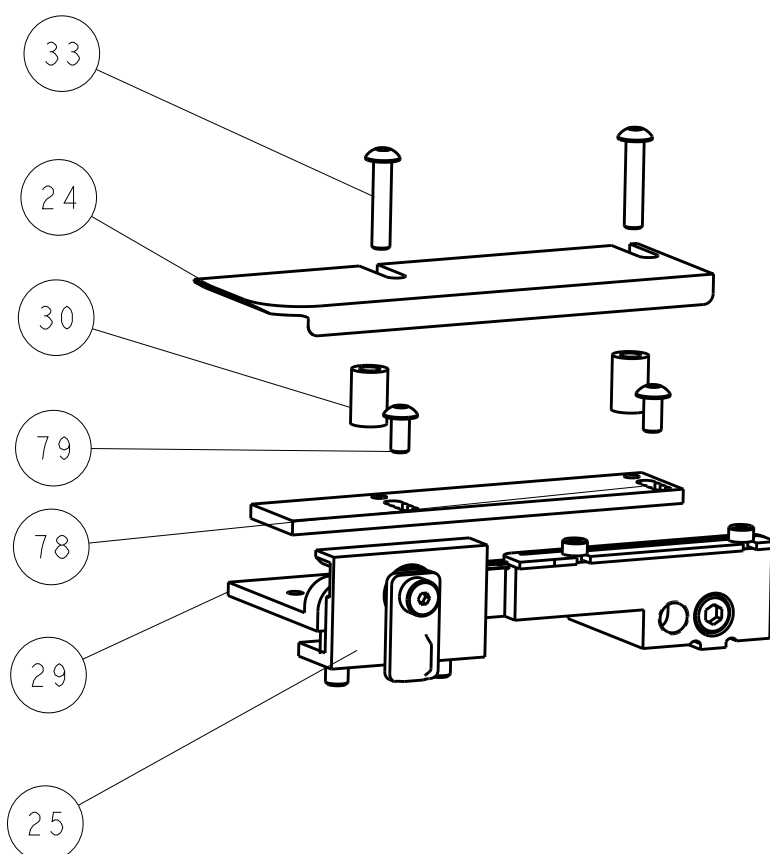
MECHANICAL
POST FEED



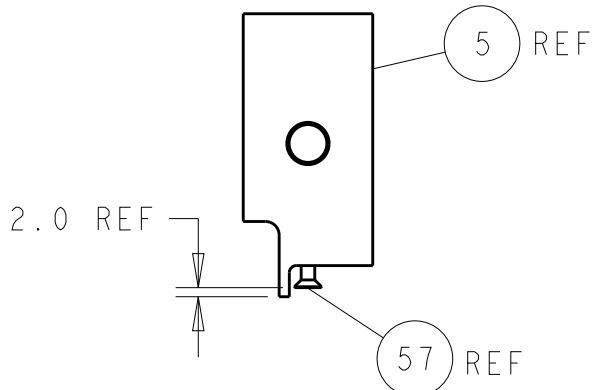
MECHANICAL
PRE FEED



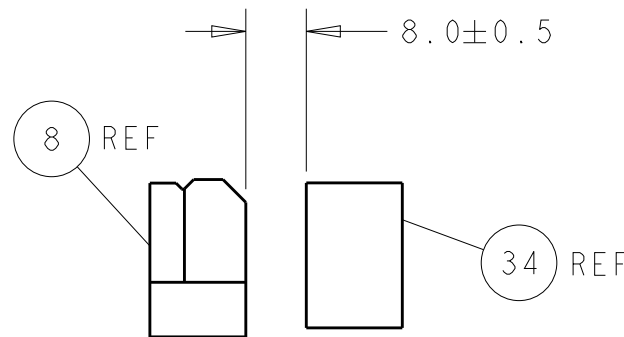
AIR FEED



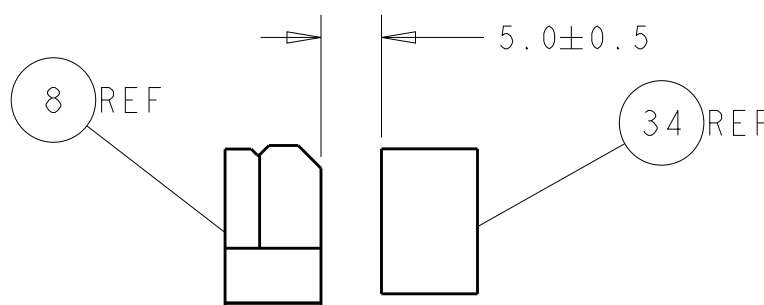
PACIFIC VERSION
Shown on sheets 3 of 4 & 4 of 4
(Atlantic version shown on sheets 1 of 4 & 2 of 4)



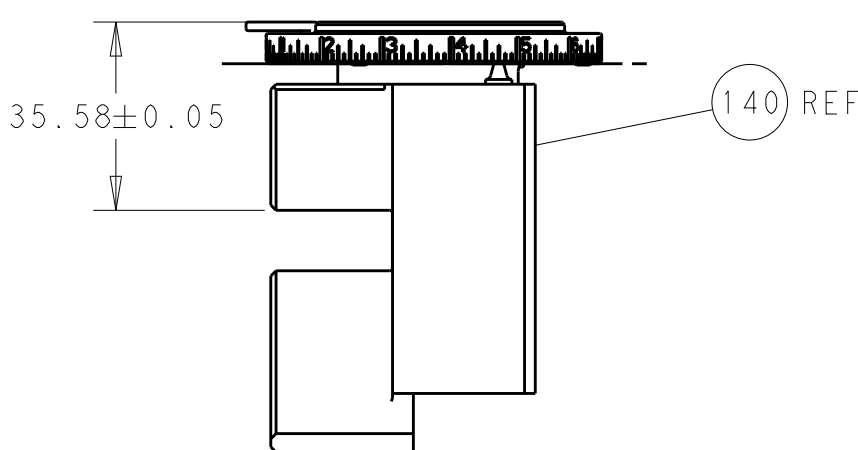
SHEAR DEPRESSOR DETAIL



TERMINAL SUPPORT LOCATION FOR
BLADE TERMINAL P/N 1326031-8

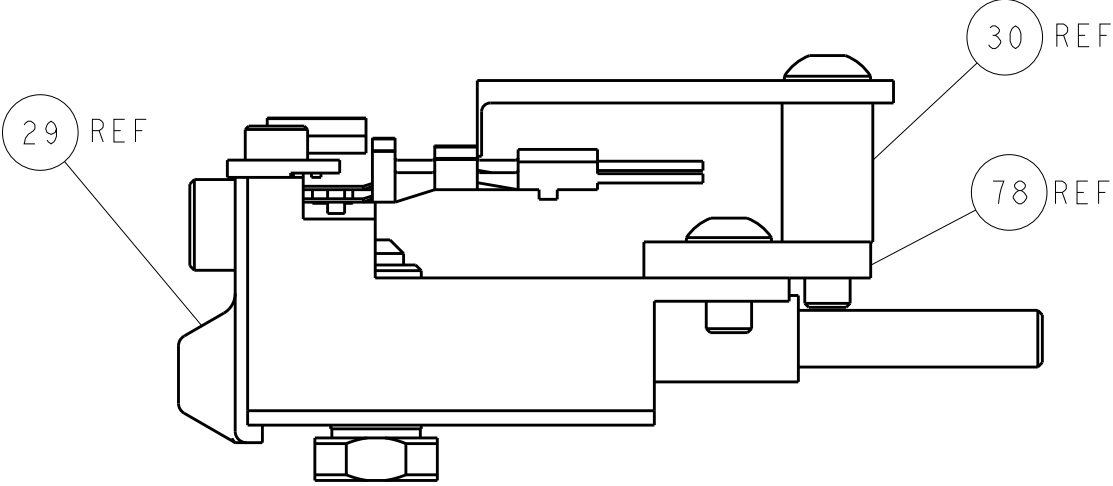


TERMINAL SUPPORT LOCATION FOR
RECEPTACLE TERMINAL P/N 1326032-9



RAM SET-UP

ITEM 78 LOCATED AT
FRONT HOLES



FEED TRACK POSITION
GUIDE BY WIRE BARREL

1ST PUBLISHED BY: COMPANY LOGO FOR TYCO ELECTRONICS CORPORATION IT IS SUBJECT TO CHANGE AND WITHOUT WARRANTY OF ANY KIND. THE USER SHALL BE RESPONSIBLE FOR THE LATEST VERSION.		DWN Y. YIN 25JUL2012	TE Connectivity Harrisburg, PA 17105-3608	
CHK G. BAILEY 25JUL2012		APVD S. XI 25JUL2012	NAME Ocean Side Feed Applicator	
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		RESTRICTED TO
0 PLC ±		1 PLC ±		SIZE
2 PLC ±		3 PLC ±		CAGE CODE
4 PLC ±		5 PLC ±		DRAWING NO
MATERIAL		FINISH		00779
WEIGHT		SCALE		1:1
Customer Accessible Production Drawing		SHEET		4 OF 4
		REV		E1

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION