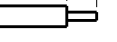


8		7	
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20		20	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151074-1	M	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2151074-2	M	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151074-1	M	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2151074-2	M	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2151074-7	L	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.03 mm [.080]	F
INSUL	3.30 mm [1.130]	F
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: AMP POWER DOUBLE LOCK CONTACT			
WIRE STRIP LENGTH 3.00-4.00 mm [1.18-.157 IN]			INSULATION DIAMETER RANGE Ø1.80-3.10 mm [0.071-.122 IN]
TERMINAL APPLICATION SPECIFICATION 		(A)114-5175 (B)114-61016	- -
TERMINALS APPLIED 			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
(A) 177915-1	(A) 177915-9	(A) 177917-1	(A) 1-177917-1
(A) 177915-2	(A) 5-177915-1	(A) 177917-2	(A) 1-177917-2
(B) 1743729-1			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
16 AWG OR 1.27mm2	1.29+/-0.05 [1.051+/-0.002]	5.3
18 AWG OR 0.89mm2	1.15+/-0.05 [1.045+/-0.002]	6.5
20 AWG OR 0.51mm2	1.05+/-0.05 [1.041+/-0.002]	7.6



- 1 RECOMMENDED SPARE PARTS
- 2 REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- 3 PLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 180. 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.
- 7 ITEM 34 IS APPLY FOR FEMALE TERMINAL 177915 & 1743729; ITEM 36 IS APPLY FOR MALE TERMINAL 177917.

*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
		J		ECR-17-004390	28MAR2017	TB	TE
		K		ECR-18-014299	10SEP2018	FZ	KZ
		L		ECR-20-005624	20APR2020	MZ	YY
		M		ECR-20-009461	02JUL2020	FJ	RK

-	1	1	1	1	1803078-4	SPACER, PRECISION	261
-	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
-	1	1	1	1	1-1752354-3	STANDOFF,HOLD-DOWN	180
-	1	1	1	1	1803043-9	CRIMPER, SPECIAL PREMIUM	178
-	1	1	1	1	6-993111-6	PIN, SLOTTED SPRING 3.0 X 14.0	177
-	1	1	1	1	8-22280-7	SPRING, COMPRESSION	176
-	1	1	1	1	1752353-2	GUIDE PIN,HOLDDOWN	175
-	1	1	1	1	1901680-2	GUIDE PIN,HOLDDOWN	174
-	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	1	1	1	1	1-18028-2	WASHER, FLAT, REG M4	119
-	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
-	1	1	1	1	1-455888-6	SPACER, CRIMPER	82
-	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
-	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
-	1	1	1	1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52
-	1	1	1	1	1-1901681-9	HOLDDOWN, TERMINAL	51
-	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	4-1752356-2	SUPPORT, TERMINAL	36
-	1	1	1	1	1752356-3	SUPPORT, TERMINAL	34
-	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	2	2	3-2844962-0	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29
-	1	1	1	1	1-455888-0	SPACER, CRIMPER	28
-	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
-	1	1	1	1	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	1-356885-4	STOP, SHEAR	11
-	1	1	1	1	2119805-1	SHEAR HOLDER, FRONT	10
-	1	1	1	1	1803095-1	FLOATING SHEAR, FRONT	9
-	1	2	2	1	7-1633131-1	ANVIL, COMBINATION .080	8
-	1	1	1	1	2119757-5	DEPRESSOR, SHEAR	5
-	1	1	1	1	2-238011-1	BLOCK, CRIMPER SPACER	4
-	1	2	2	1	2119582-1	CRIMPER, INSULATION F PREMIUM	3
-	1	1	1	1	455888-1	SPACER, CRIMPER	2
-	1	2	2	1	6-456405-6	CRIMPER, WIRE PREMIUM	1
-77-72-71	-2	-1			PART NO	DESCRIPTION	ITEM NO

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				CHK	G. BAILEY	16DEC2010	NAME			
				APVD	J. CRUZ	16DEC2010	Ocean Side Feed Applicator			
DIMENSIONS:				TOLERANCES UNLESS OTHERWISE SPECIFIED:			PRODUCT SPEC			
mm							APPLICATION SPEC			
				0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±			SIZE			
MATERIAL				FINISH			WEIGHT			
-				-			A1 00779 C=2151074			
							Customer Accessible Production Drawing			
							SCALE 1:2 SHEET 1 OF 4 REV M			

THIS DRAWING IS A CONFIDENTIAL DOCUMENT FOR TFCO INDUSTRIES CORPORATION IT IS SUBJECT TO CHANGE AND THE CONTROLLING ENGINEERING ORGANIZATION SHOULD BE NOTIFIED FOR THE LATEST REVISION		DWN G. HOFNER 15DEC2010 CKM G. BAILEY 16DEC2010 APVU L. CRUZ 16DEC2010		TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		NAME Ocean Side Feed Applicator	
		PRODUCT SPEC - APPLICATION SPEC -		SIZE A 00779	
MATERIAL -		FINISH -		DRAWING NO C=2151074	
WEIGHT -		RESTRICTED TO -		SCALE 1:2 SHEET 2 OF 4 REV M	
Customer Accessible Production Drawing					

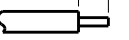
SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

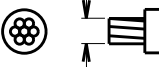
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2151074-1	M	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2151074-2	M	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151074-7	L	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.03 mm [.080]	F
INSUL	3.30 mm [.130]	F
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: AMP POWER DOUBLE LOCK CONTACT			
WIRE STRIP LENGTH 3.00-4.00 mm [.118-.157 IN]			INSULATION DIAMETER RANGE Ø1.80-3.10 mm [.071-.122 IN]
TERMINAL APPLICATION SPECIFICATION	(A)114-5175	-	-
	(B)114-61016	-	-
TERMINALS APPLIED 			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
(A) 177915-1	(A) 177915-9	(A) 177917-1	(A) 1-177917-1
(A) 177915-2	(A) 5-177915-1	(A) 177917-2	(A) 1-177917-2
(B) 1743729-1			

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING 
16 AWG OR 1.27mm2		1.29+/-0.05 [.051+/-0.002]		5.3
18 AWG OR 0.89mm2		1.15+/-0.05 [.045+/-0.002]		6.5
20 AWG OR 0.51mm2		1.05+/-0.05 [.041+/-0.002]		7.6



-  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.
-  TERMINAL LUBRICANT IS RECOMMENDED.
6. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
-  ITEM 34 IS APPLY FOR FEMALE TERMINAL 177915 & 1743729; ITEM 36 IS APPLY FOR MALE TERMINAL 177917.

*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)

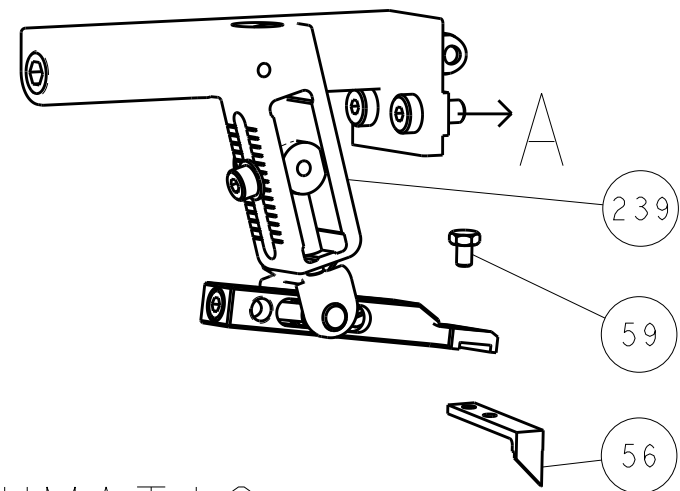
LOC	DIST	REVISIONS					
A	66	P	LTR	DESCRIPTION	DATE	DWN	APVD
			-	SEE SHEET 1	-	-	-

-	1	1	1803078-4	SPACER, PRECISION	261
-	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
-	1	1	1-1752354-3	STANDOFF,HOLD-DOWN	180
-	1	1	1803043-9	CRIMPER, SPECIAL PREMIUM	178
-	1	1	6-993111-6	PIN, SLOTTED SPRING 3.0 X 14.0	177
-	1	1	8-22280-7	SPRING, COMPRESSION	176
-	1	1	1752353-2	GUIDE PIN,HOLDDOWN	175
-	1	1	1901680-2	GUIDE PIN,HOLDDOWN	174
-	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	1-18028-2	WASHER, FLAT, REG M4	119
-	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	1-455888-6	SPACER, CRIMPER	82
-	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	1338685-1	PAWL, FEED	56
-	1	1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52
-	1	1	1-1901681-9	HOLDDOWN, TERMINAL	51
-	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	4-1752356-2	SUPPORT, TERMINAL	36
-	1	1	1752356-3	SUPPORT, TERMINAL	34
-	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	3-2844962-0	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29
-	1	1	1-455888-0	SPACER, CRIMPER	28
-	1	1	1320928-2	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	2119533-1	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	1803095-1	FLOATING SHEAR, FRONT	9
-	1	1	7-1633131-1	ANVIL, COMBINATION .080	8
-	1	1	2119757-5	DEPRESSOR, SHEAR	5
-	1	1	2-238011-1	BLOCK, CRIMPER SPACER	4
-	1	1	2119582-1	CRIMPER, INSULATION F PREMIUM	3
-	1	1	455888-1	SPACER, CRIMPER	2
-	1	1	6-456405-6	CRIMPER, WIRE PREMIUM	1

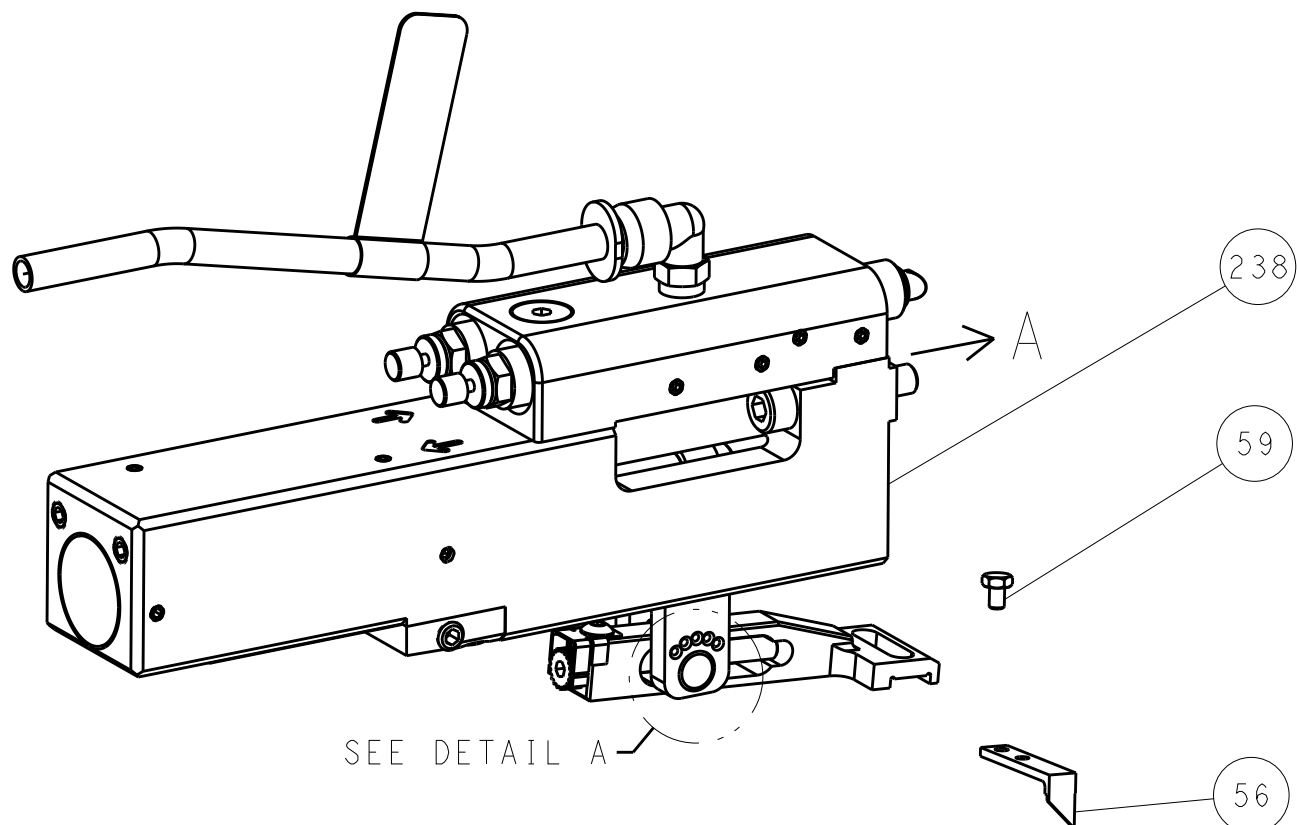
-77	-22	-21	PART NO	DESCRIPTION	ITEM NO
DWN G. HOFFNER 15DEC2010			TE Connectivity Harrisburg, PA 17105-3608		
CHK G. BAILEY 16DEC2010			NAME		
APVD J. CRUZ 16DEC2010			Ocean Side Feed Applicator		
PRODUCT SPEC			SIZE CAGE CODE DRAWING NO		
APPLICATION SPEC			00779 ©=2151074		
MATERIAL			Customer Accessible Production Drawing		
FINISH			SCALE 1:2 SHEET 3 OF 4 REV M		

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

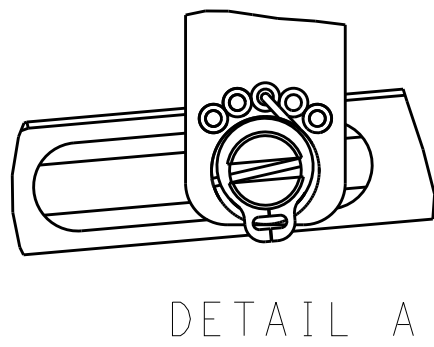
FEED TYPE MECHANICAL



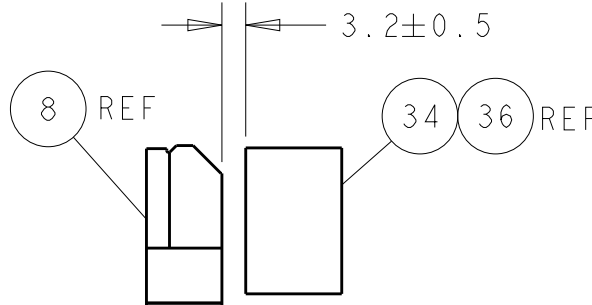
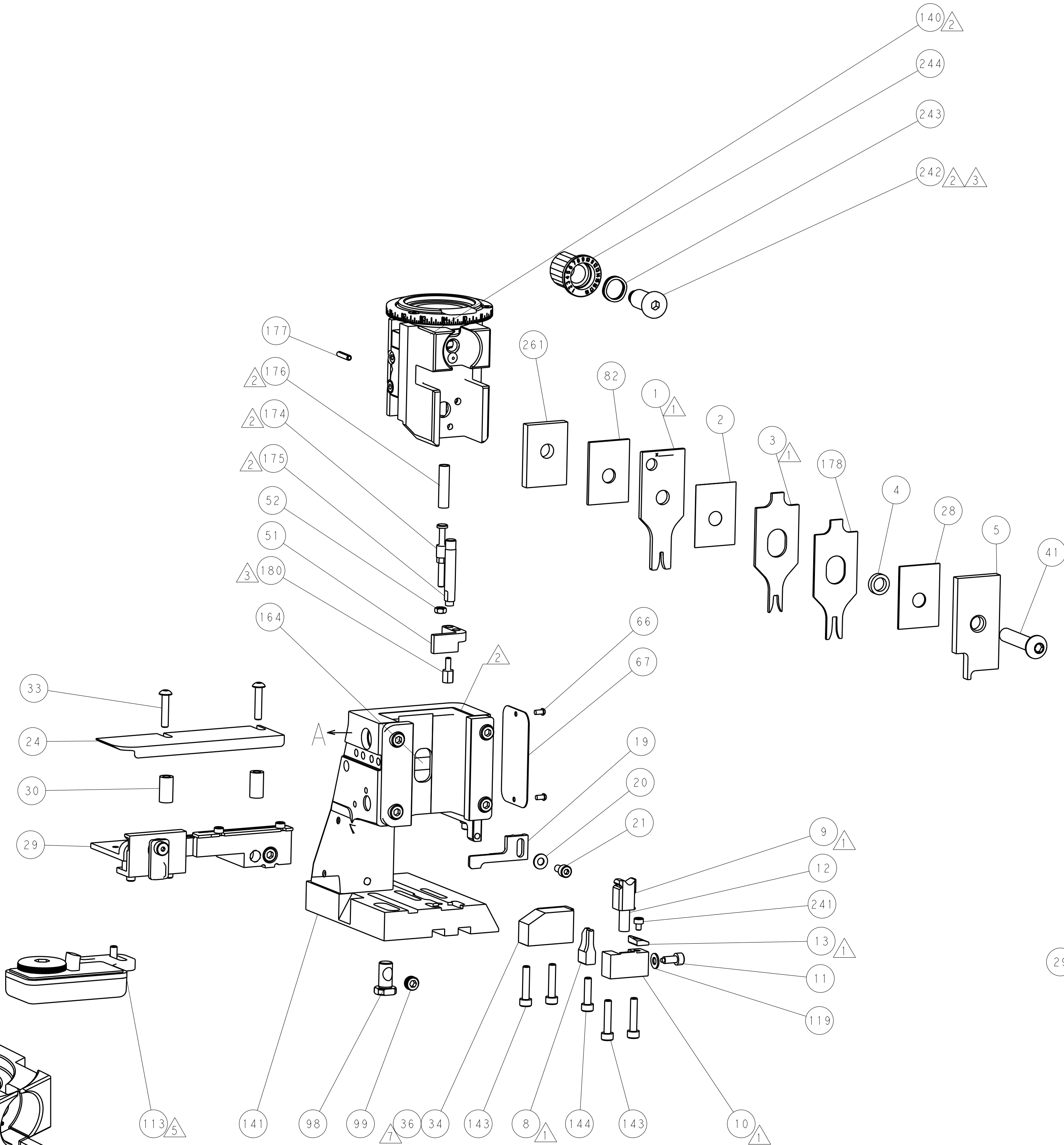
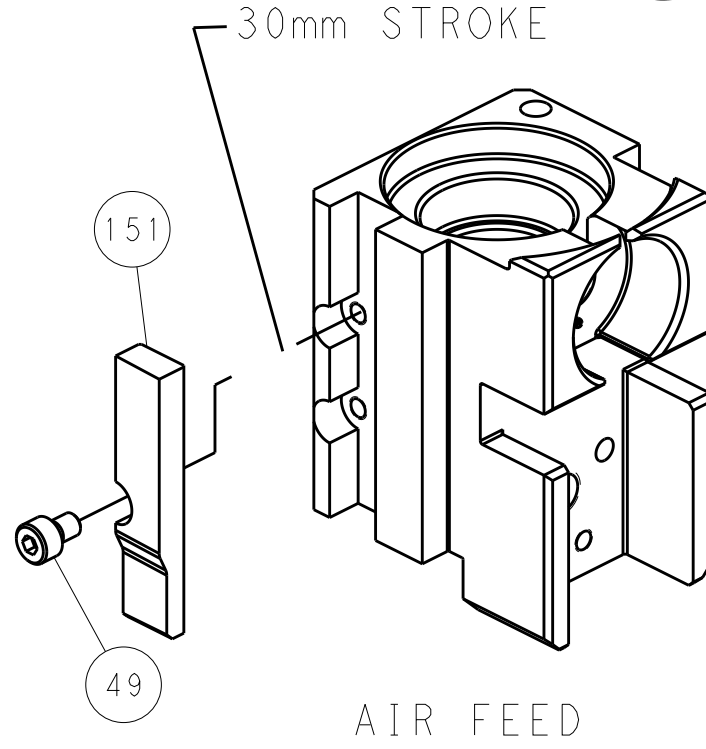
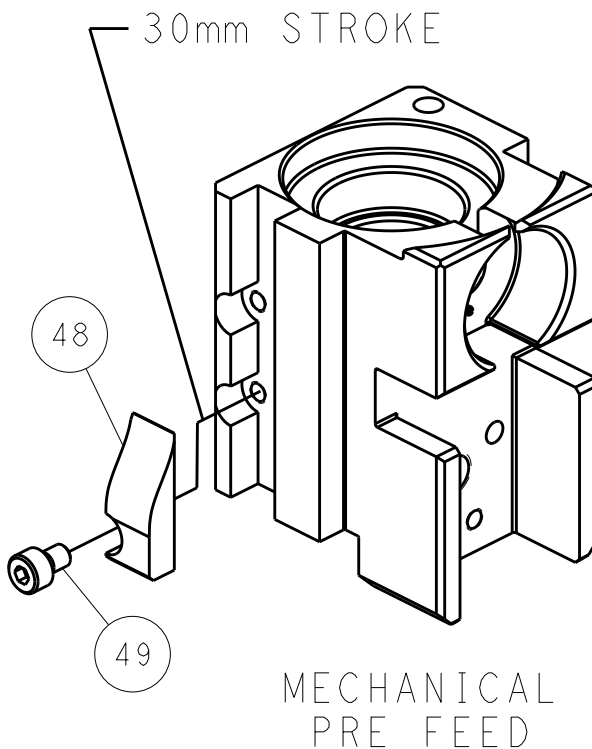
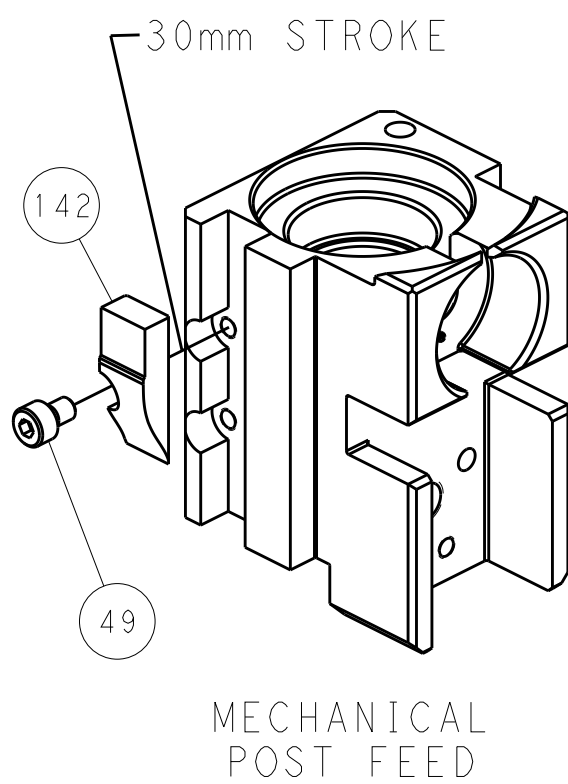
PNEUMATIC



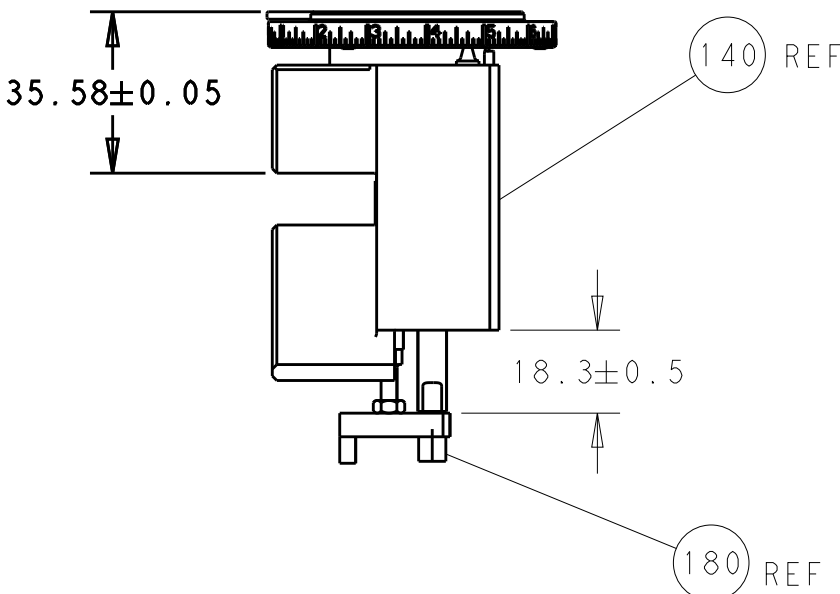
FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



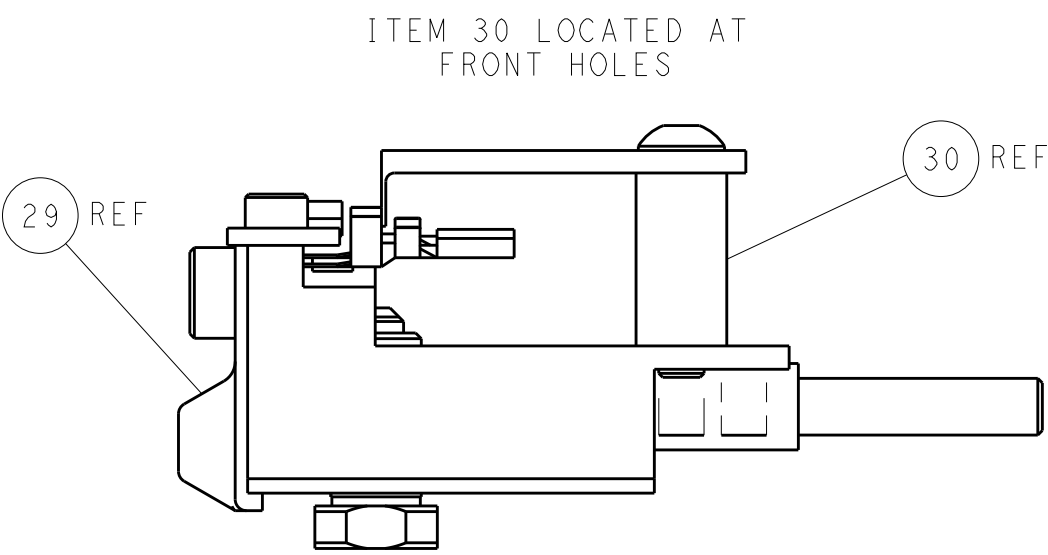
CAM POSITIONS



TERMINAL SUPPORT LOCATION



RAM AND HOLDDOWN 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)

THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. ANY CHANGES TO THIS DRAWING SHOULD BE CONTACTED FOR THE LATEST VERSION.		OWN G. HOFFNER CHK G. BAILEY APVD I. CRUZ	15DEC2010 16DEC2010 16DEC2010	NAME Ocean Side Feed Applicator
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		SIZE A1
0 PLC 1 PLC 2 PLC 3 PLC 4 PLC		± ± ± ± ±		CAGE CODE 00779
MATERIAL -		FINISH -		DRAWING NO. 2151074
		WEIGHT -		RESTRICTED TO -
		Customer Accessible Production Drawing		SCALE 1:2
				SHEET 4
				OF 4
				REV M

Mouser Electronics

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[TE Connectivity:](#)

[2151074-1](#)