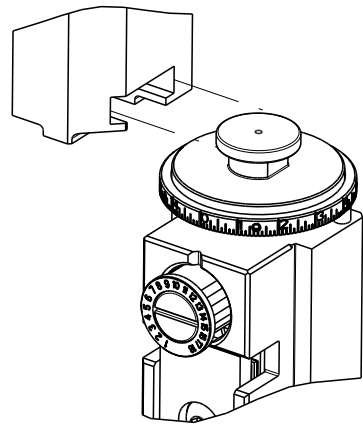
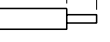


8		7	
THIS DRAWING IS UNPUBLISHED.		RELEASED FOR PUBLICATION	
20		20	
© COPYRIGHT 20		BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.	
PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151223-1	E	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2151223-2	E	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151223-1	E	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2151223-2	E	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2151223-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.70 mm [.067]	F
INSUL	3.00 mm [.118]	O
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: .040 III SEALED CONTACT, TAB(S)			
WIRE STRIP LENGTH			TERMINAL INSULATION DIAMETER RANGE
4.00-4.50 mm [.157-.177 IN]			Ø1.40-1.70 mm [.055-.067 IN]
TERMINAL APPLICATION SPECIFICATION	114-5227	-	-
TERMINALS APPLIED		TERMINALS APPLIED	
TE TERMINAL	TE TERMINAL	TE SEAL	TE SEAL
316834-1		286523-1	
316834-2			
316834-3			

SEAL INSULATION DIAMETER RANGE
1.4-1.7 mm

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.50mm2	1.26+/-0.05 [.050+/- .002]	7.9
0.5 f	1.21+/-0.05 [.048+/- .002]	8.5
0.30mm2	1.17+/-0.05 [.046+/- .002]	8.9



- 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.
- UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- APPLY TORQ-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.
- TERMINAL LUBRICANT IS RECOMMENDED.

*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)

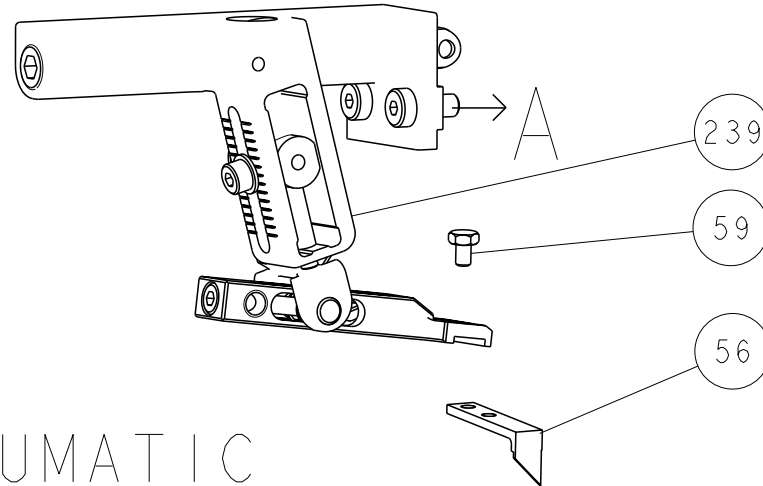
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			D	ECR-20-004228	20MAR2020	FZ	TE
			E	ECR-20-008865	22JUN2020	JWC	RK

-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248
-	1	1	1	1	2119082-4	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
3	-	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
7	-	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	455888-5	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
6	-	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	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	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	690753-6	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	1803515-1	RAM ASSEMBLY, SF ATLANTIC	44
-	1	1	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	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	3-2844962-0	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29
-	1	1	1	1	455888-3	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
-	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	1-356885-4	STOP, SHEAR	11
1	-	1	1	1	2119805-1	SHEAR HOLDER, FRONT	10
1	-	1	1	1	1803095-6	FLOATING SHEAR, FRONT -	9
1	1	2	2	1	1-1633138-2	ANVIL, COMBINATION	8
-	1	1	1	1	240641-5	SPACER	7
-	-	-	-	-	-	-	6
-	1	1	1	1	2119781-1	DEPRESSOR, SHEAR	5
-	1	1	1	1	2-238011-2	BLOCK, CRIMPER SPACER	4
1	1	2	2	1	3-2119784-2	CRIMPER, INSULATION O PREMIUM	3
-	1	1	1	1	455888-6	SPACER, CRIMPER	2
1	1	2	2	1	2-568176-3	CRIMPER, WIRE	1
-	77	72	71	-2	-1	PART NO	ITEM NO

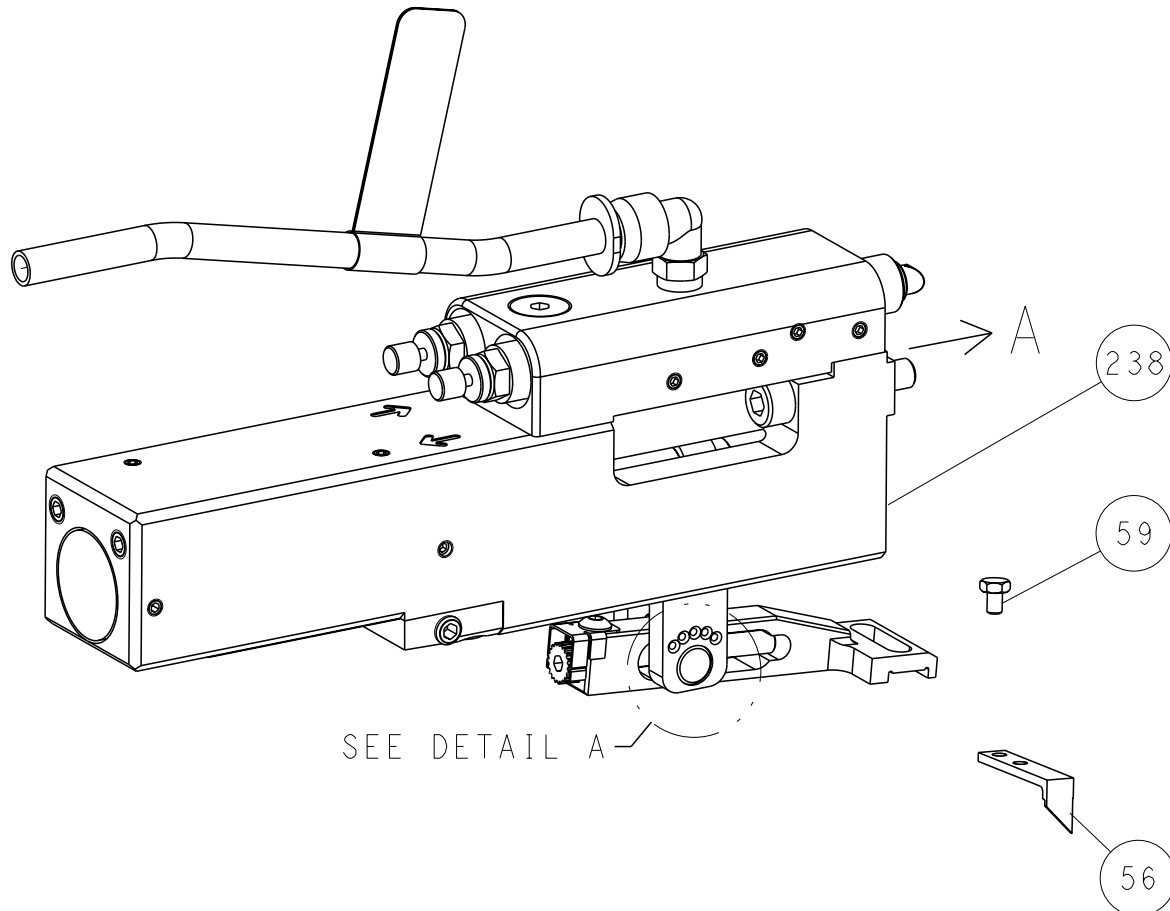
THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE AND TO BE CONTROLLED BY THE ENGINEERING ORGANIZATION. IT SHOULD BE CONTACTED FOR THE LATEST REVISION.				DWN HOFFNER 22SEP2015	 TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS:				CHK T.ELBIN 23SEP2015		NAME
mm				APVD T.ELBIN 23SEP2015		
TOLERANCES UNLESS OTHERWISE SPECIFIED:				PRODUCT SPEC		Ocean Side Feed Applicator
0 PLC ±				APPLICATION SPEC		
1 PLC ±				FINISH		
2 PLC ±				WEIGHT		
3 PLC ±				MATERIAL		SIZE CASE CODE DRAWING NO RESTRICTED TO
4 PLC ±				Customer Accessible Production Drawing		
ANGLES				FINISH		
FINISH				SCALE 1:2	SHEET 1 OF 4 REV E	
-						

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

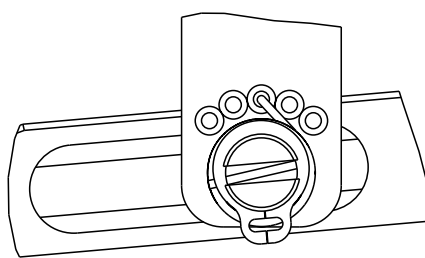
FEED TYPE MECHANICAL



PNEUMATIC

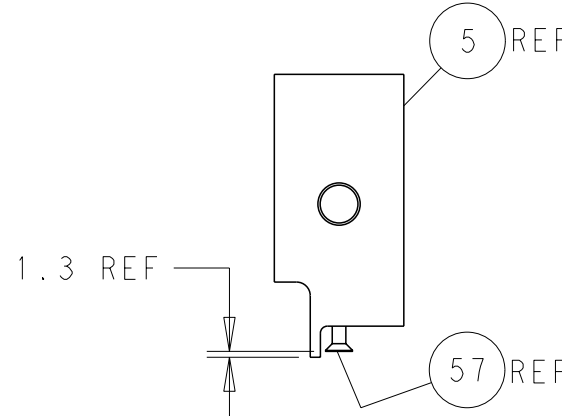
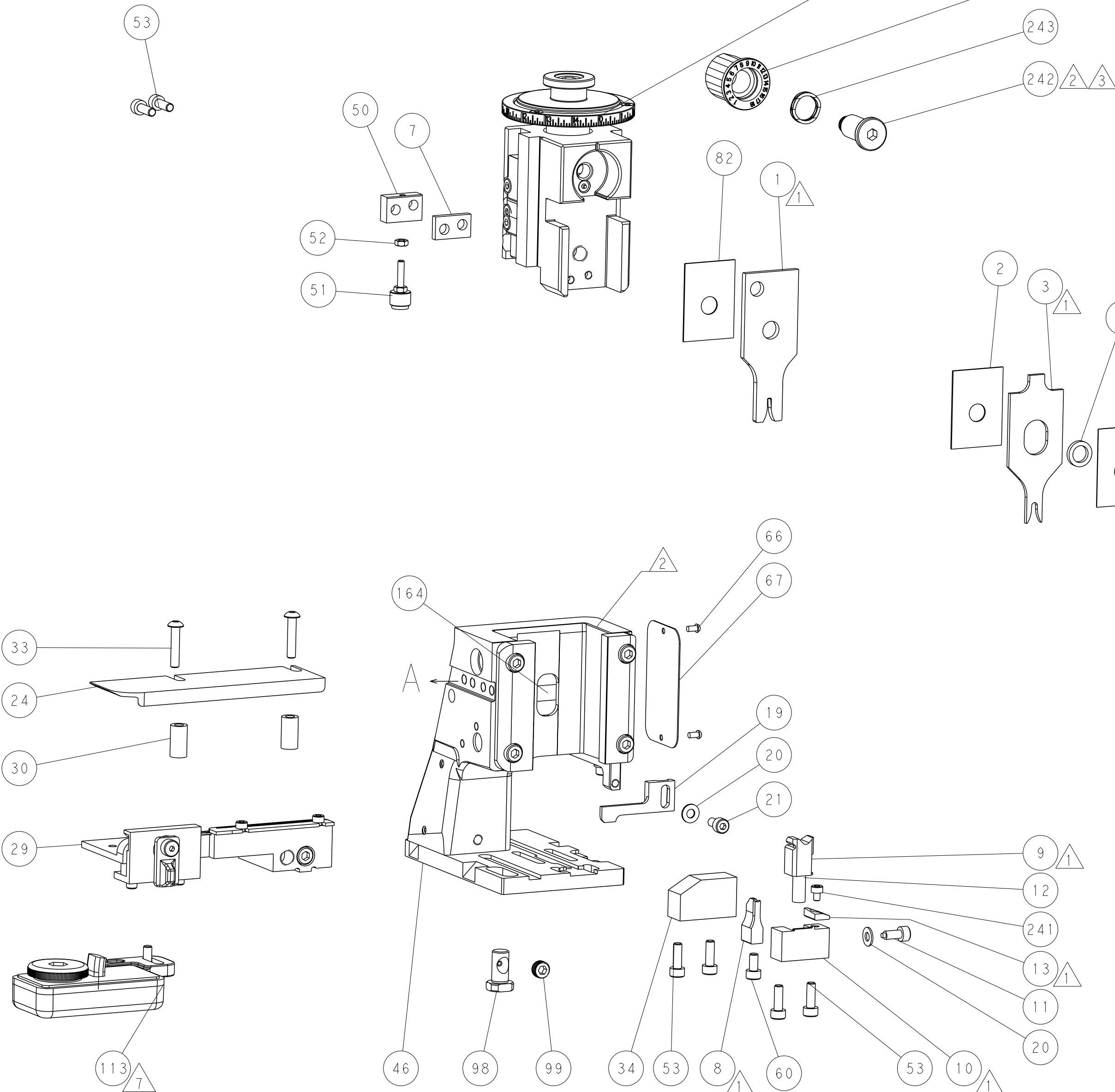
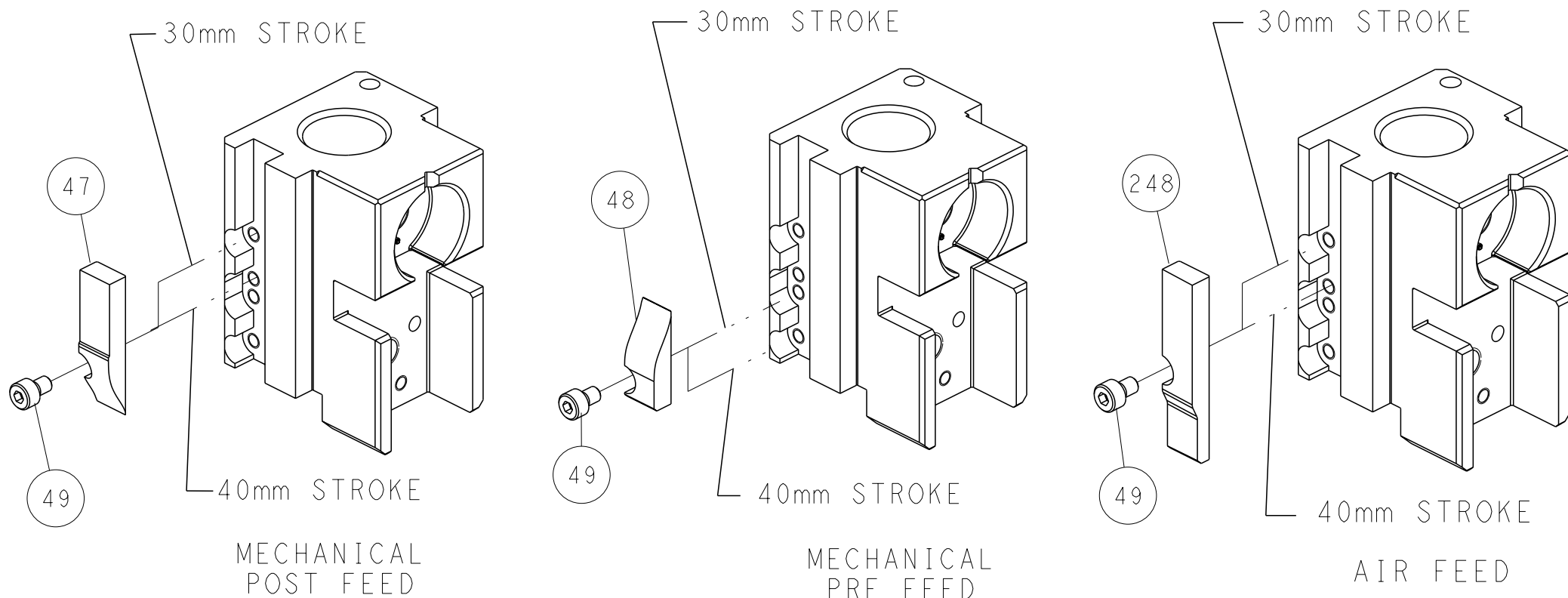


FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)

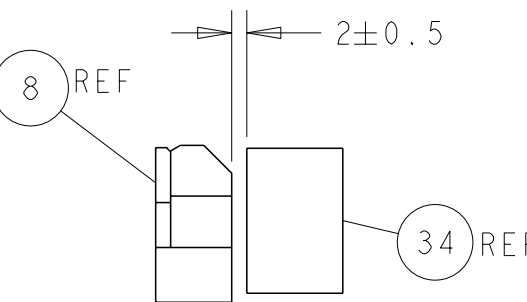


DETAIL A

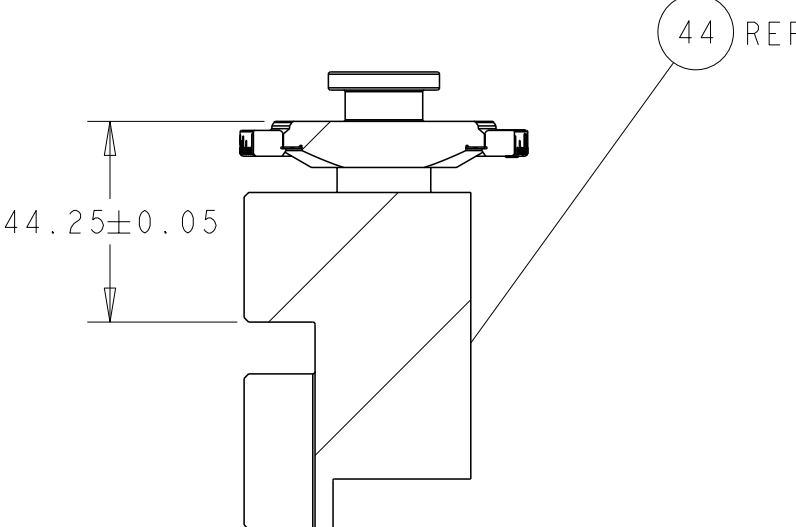
CAM POSITIONS



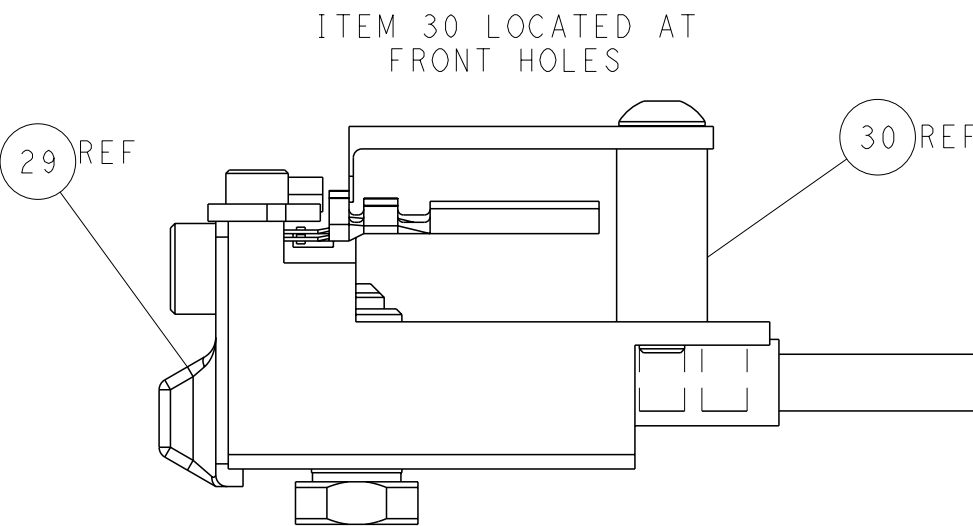
SHEAR DEPRESSOR DETAIL



TERMINAL SUPPORT LOCATION



RAM SET-UP



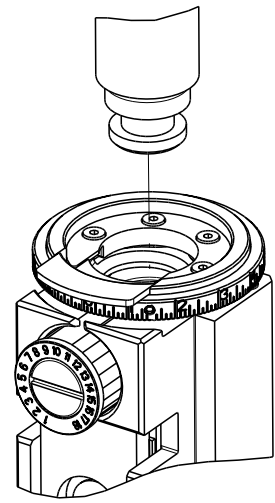
FEED TRACK POSITION
GUIDE BY INSULATION BARREL

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

1. THIS DRAWING IS A CONTROL DOCUMENT FOR THE MANUFACTURING CORPORATION OF THE CUSTOMER. IT IS THE PROPERTY OF THE CUSTOMER AND IS NOT TO BE REPRODUCED OR COPIED FOR ANY OTHER PURPOSE.				DWN		22SEP2015		 TE Connectivity Harrisburg, PA 17105-3608			
				OFFNER		23SEP2015					
DIMENSIONS:				TOLERANCES UNLESS OTHERWISE SPECIFIED:							
mm											
				0 PLC ±							
				1 PLC ±							
				2 PLC ±							
				3 PLC ±							
				4 PLC ±							
ANGLES ±				±							
FINISH											
MATERIAL				WEIGHT							
-				-							
				SIZE		CAGE CODE		DRAWING NO			
				A		00779		C=2151223			
				Customer Accessible Production Drawing						SCALE 1:2 SHEET 2 of 4 REV E	

8		7	
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20		20	
© COPYRIGHT 20		BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.	
PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2151223-1	E	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2151223-2	E	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151223-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.70 mm [.067]	F
INSUL	3.00 mm [.118]	O
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: .040 III SEALED CONTACT, TAB(S)			
WIRE STRIP LENGTH 4.00-4.50 mm [.157-.177 IN]		 TERMINAL INSULATION DIAMETER RANGE Ø1.40-1.70 mm [.055-.067 IN]	
TERMINAL APPLICATION SPECIFICATION 		114-5227	-
		-	-
TERMINALS APPLIED 			
TE TERMINAL	TE TERMINAL	TE SEAL	TE SEAL
316834-1		286523-1	
316834-2			
316834-3			

SEAL INSULATION DIAMETER RANGE
1.4-1.7 mm

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.50mm2	1.26+/-0.05 [.050+/- .002]	7.9
0.5 f	1.21+/-0.05 [.048+/- .002]	8.5
0.30mm2	1.17+/-0.05 [.046+/- .002]	8.9



- 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.
- 6 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.
- 7 TERMINAL LUBRICANT IS RECOMMENDED.

*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)

2		1						
LOC	DIST	REVISIONS						
A	66	P	LTR	DESCRIPTION	DATE	DWN	APVD	
		-		SEE SHEET 1	-	-	-	

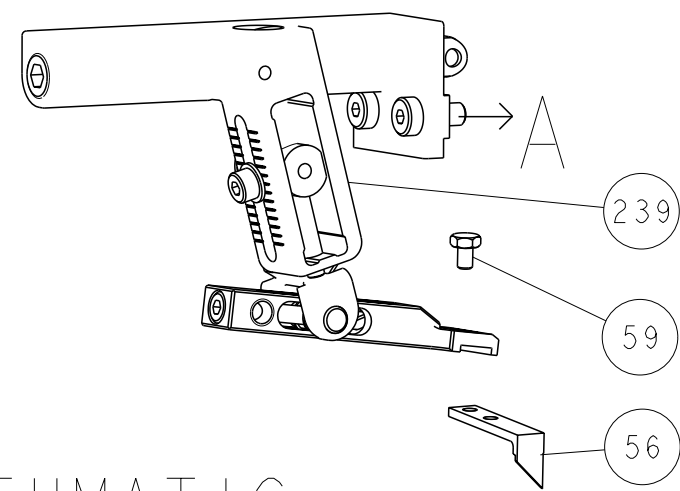
-	1	1	2119082-4	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
-	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	1	-	2844940-1	AIR FEED MODULE	238
-	REF	REF	994970-2	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	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113
-	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	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	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	53
-	1	1	5018030-1	NUT, HEX, REG, RoHS, M3	52
-	1	1	811242-5	BUMPER, HOLD DOWN	51
-	1	1	690753-6	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	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
-	1	1	2-1752356-0	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	455888-3	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	2119533-1	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	1803095-6	FLOATING SHEAR, FRONT	9
-	1	1	1-1633138-2	ANVIL, COMBINATION	8
-	1	1	240641-5	SPACER	7
-	-	-	-	-	6
-	1	1	2119781-1	DEPRESSOR, SHEAR	5
-	1	1	2-238011-2	BLOCK, CRIMPER SPACER	4
-	1	1	3-2119784-2	CRIMPER, INSULATION O PREMIUM	3
-	1	1	455888-6	SPACER, CRIMPER	2
-	1	1	2-568176-3	CRIMPER, WIRE	1

-77	-22	-21	PART NO	DESCRIPTION	ITEM NO
OWN			HOFFNER	22SEP2015	
CHK			T.ELBIN	23SEP2015	
APVD			T.ELBIN	23SEP2015	
PRODUCT SPEC			NAME		
APPLICATION SPEC			Ocean Side Feed Applicator		
MATERIAL			SIZE	CAGE CODE	DRAWING NO
FINISH			A1	00779	2151223
Customer Accessible Production Drawing			SCALE	1:2	SHEET 3 OF 4
			REV	E	

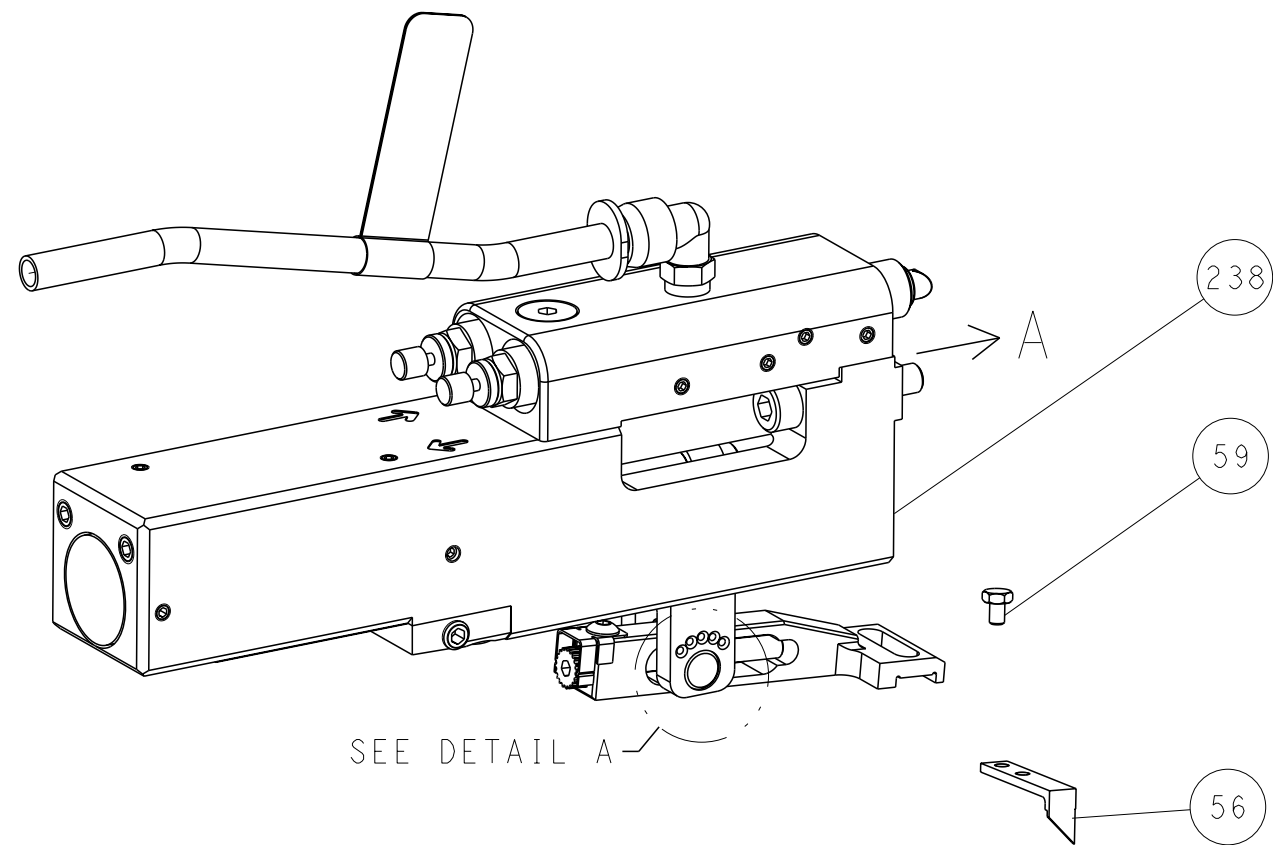
SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

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

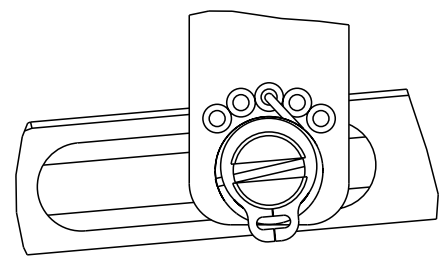
FEED TYPE MECHANICAL



PNEUMATIC

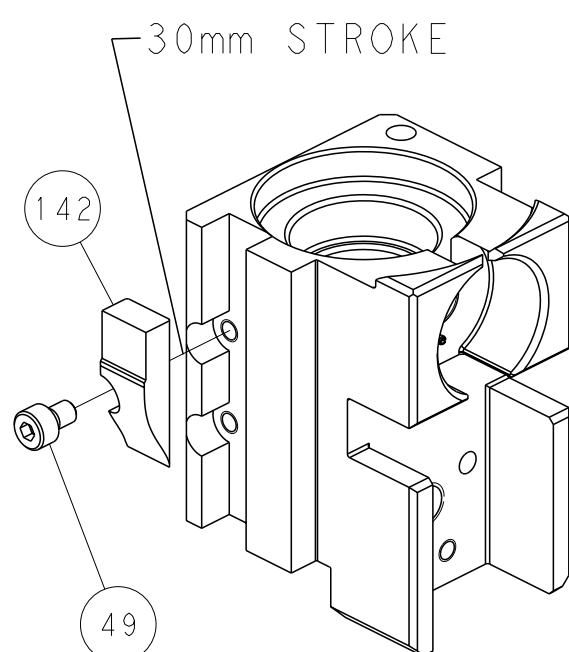


FEED SPRING SETTING POSITION
(SHOWN FROM REAR SIDE)

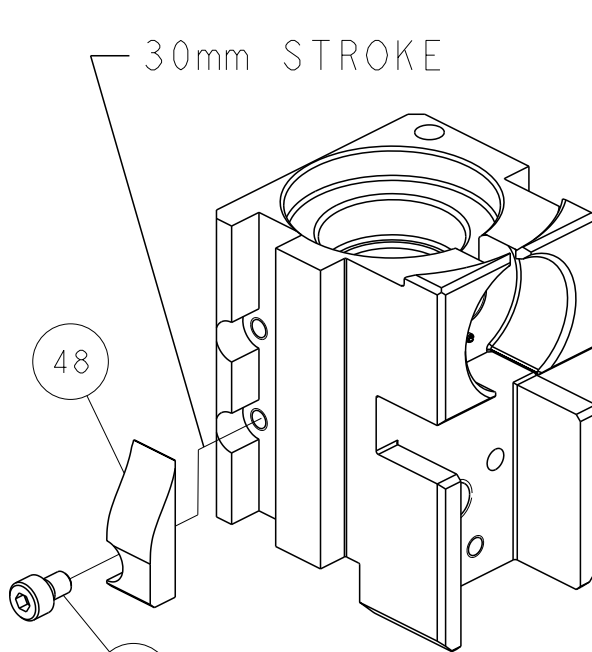


DETAIL A

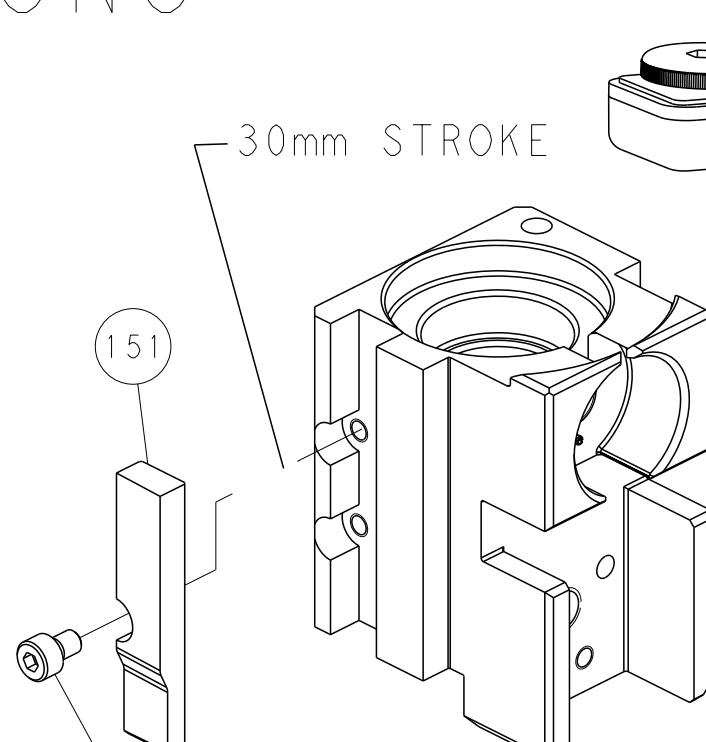
CAM POSITIONS



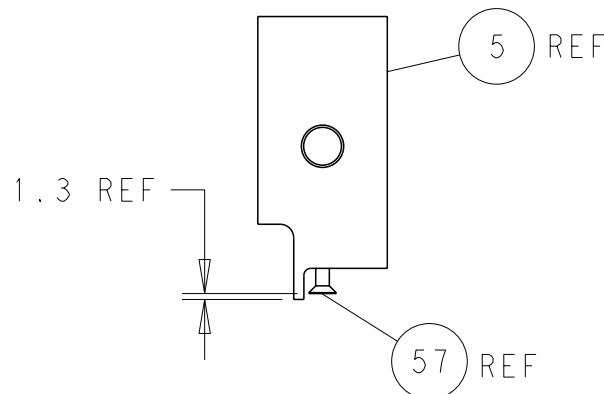
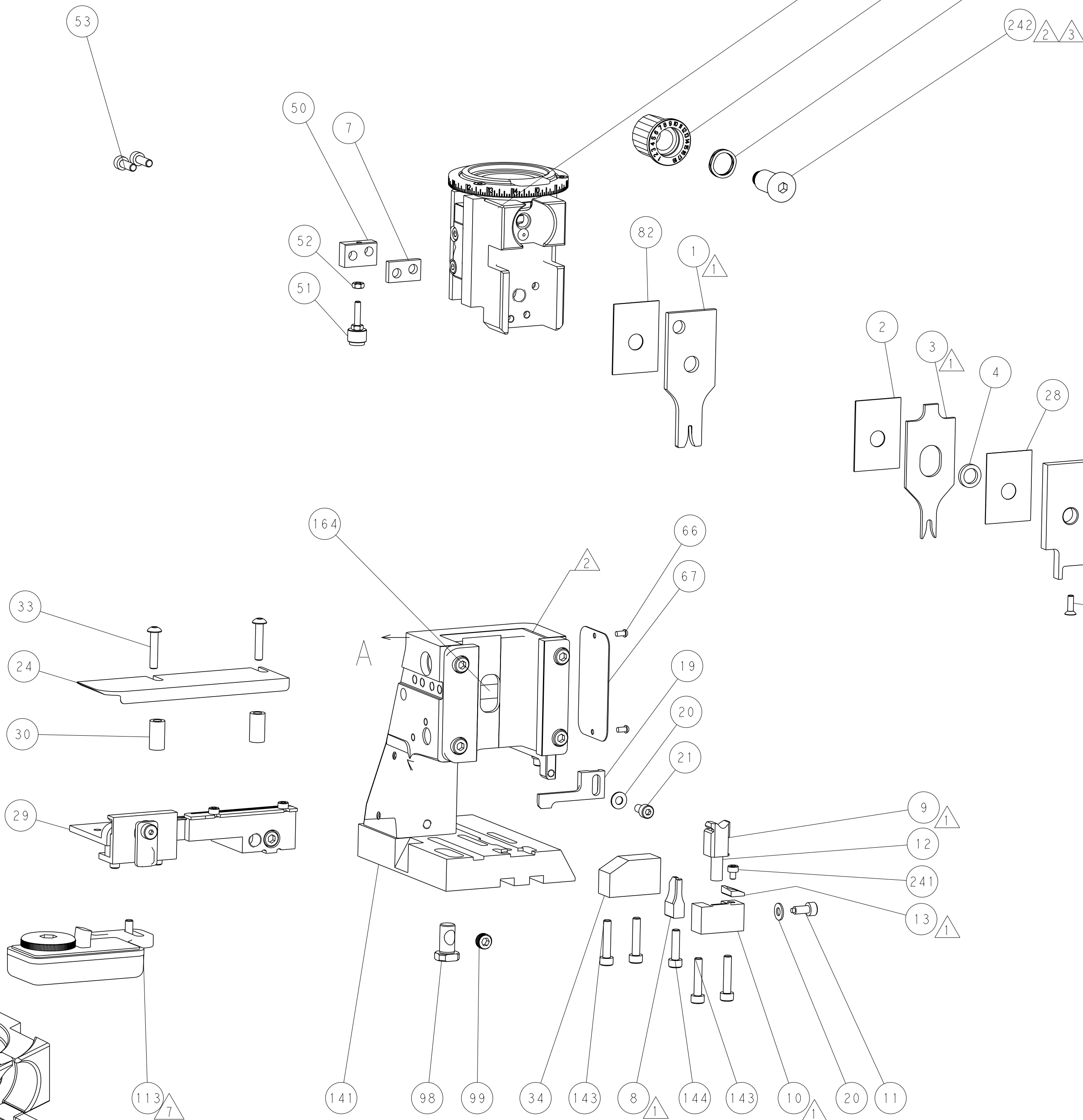
MECHANICAL
POST FEED



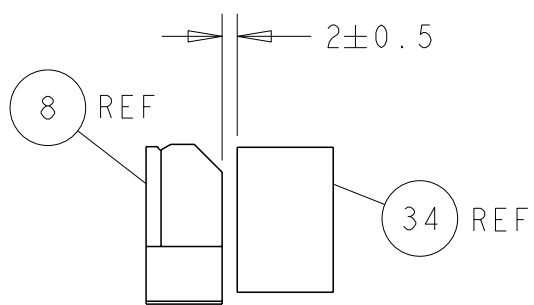
MECHANICAL
PRE FEED



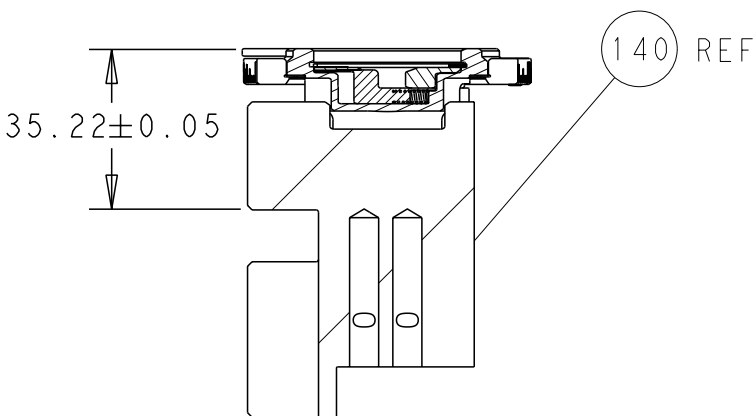
AIR FEED



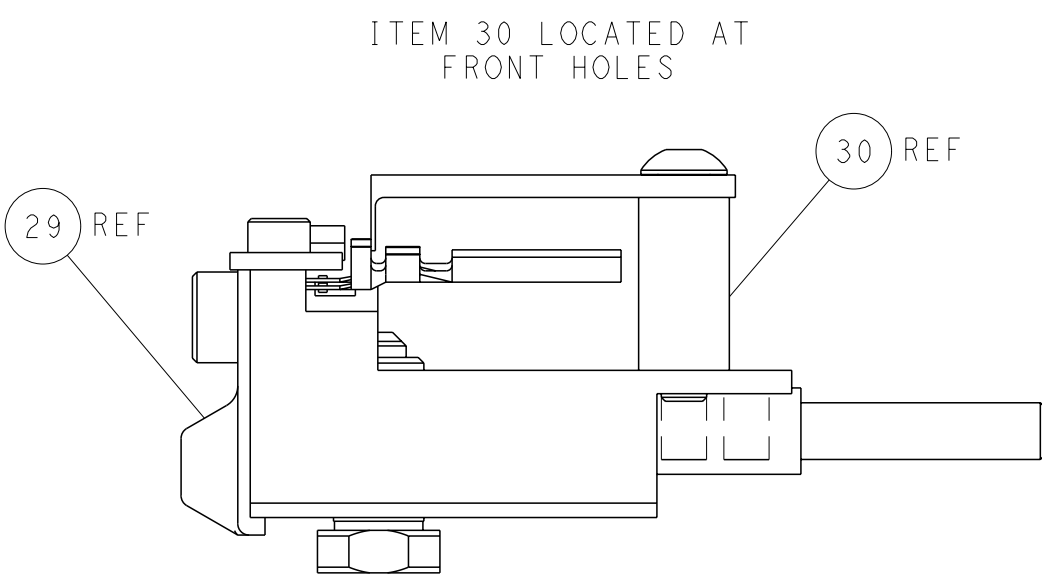
SHEAR DEPRESSOR DETAIL



TERMINAL SUPPORT LOCATION



RAM 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 A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE AND TO CONTROL AND ENGINEERING ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST REVISION.		DWN HOFFNER	22SEP2015	TE Connectivity Harrisburg, PA 17105-3608	
		CHK T.ELBIN	23SEP2015		
		APVD T.ELBIN	23SEP2015	NAME Ocean Side Feed Applicator	
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH -		PRODUCT SPEC APPLICATION SPEC SIZE CAGE CODE DRAWING NO RESTRICTED TO	
MATERIAL -		WEIGHT -		A1 00779 ©=2151223	
		Customer Accessible Production Drawing		SCALE 1:2 SHEET 4 OF 4 REV E	

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

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