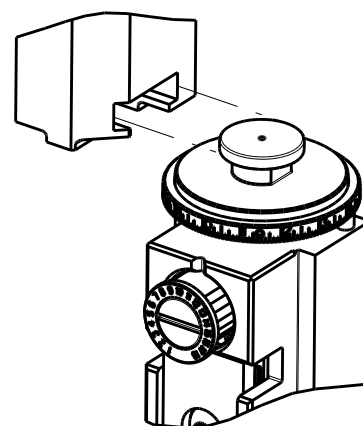


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PART NUMBER	REVISION	DESCRIPTION		FEED TYPE
2151427-1	B	FINE CRIMP HEIGHT ADJUST		MECHANICAL
2151427-2	B	FINE CRIMP HEIGHT ADJUST		PNEUMATIC
7-2151427-1	B	MECHANICAL AND CRIMP TOOLING KIT		MECHANICAL
7-2151427-2	B	PNEUMATIC AND CRIMP TOOLING KIT		PNEUMATIC
7-2151427-7	A	CRIMP TOOLING KIT		-



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.40 mm [.055]	F
INSUL	2.03 mm [.080]	O
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: RECEPTACLE .058 DIA P.C. CONTACT			
WIRE STRIP LENGTH 3.10-3.40 mm [.122-.134 IN]		INSULATION DIAMETER RANGE Ø1.15-1.77 mm [.045-.070 IN]	
TERMINAL APPLICATION SPECIFICATION		114-1008 - -	
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
60598-3	60598-4	60598-7	60598-9
61622-1			

WIRE SIZE			CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING
20 AWG			1.04+/-0.05 [0.041+/-0.002]		7.3
22 AWG			0.94+/-0.05 [0.037+/-0.002]		8.4
24 AWG			0.86+/-0.05 [0.034+/-0.002]		9.4



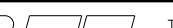
* WARNING

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)

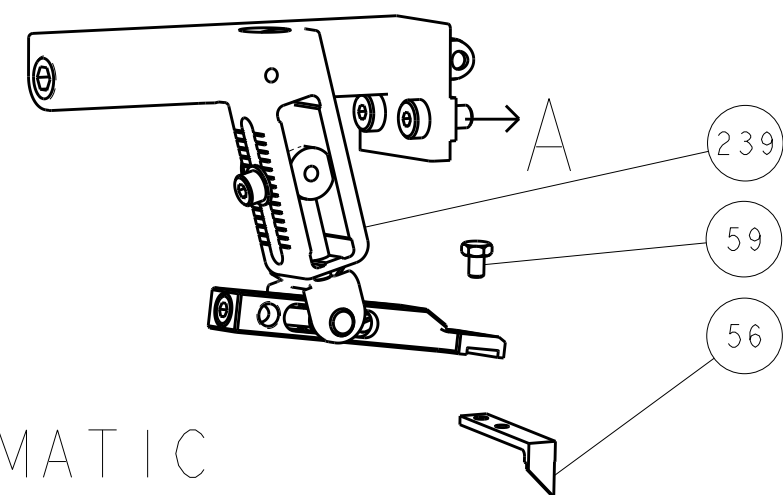
LOC	DIST	REVISIONS					
A	66						
		P	LTR	DESCRIPTION	DATE	DRN	APVD
			I	DEVELOPMENT	09DEC2011	XZ	SX
			A	RELEASED	27AUG2013	BH	TE
			B	ECR-19-011960	30JUL2019	FJ	TE

3	-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	242
	-	1	1	1	1	2119082-9	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	1-18028-2	WASHER, FLAT, REG M4	11
	-	1	1	1	1	2844908-1	SCREW, LOCKING	99
	-	1	1	1	1	2844907-1	POST, LOCKING	98
	-	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
	-	2	2	2	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	53
-	1	1	1	1	1803382-6	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	1752356-5	SUPPORT, TERMINAL	34	
-	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33	
-	2	2	2	2	2-2844962-6	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	1803095-6	FLOATING SHEAR, FRONT -	9	
1	2	2	1	1	2-1633128-9	ANVIL, COMBINATION .055	8	
-	-	-	-	-	-	-	7	
-	-	-	-	-	-	-	6	
-	1	1	1	1	2119757-8	DEPRESSOR, SHEAR	5	
-	1	1	1	1	2-238011-5	BLOCK, CRIMPER SPACER	4	
1	2	2	1	1	2-1633965-1	CRIMPER, INSULATION O PREMIUM	3	
-	1	1	1	1	455888-4	SPACER, CRIMPER	2	
1	2	2	1	1	3-456402-0	CRIMPER, WIRE PREMIUM	1	
-77	-72	-71	-2	-1	PART NO	DESCRIPTION	ITEM NO	

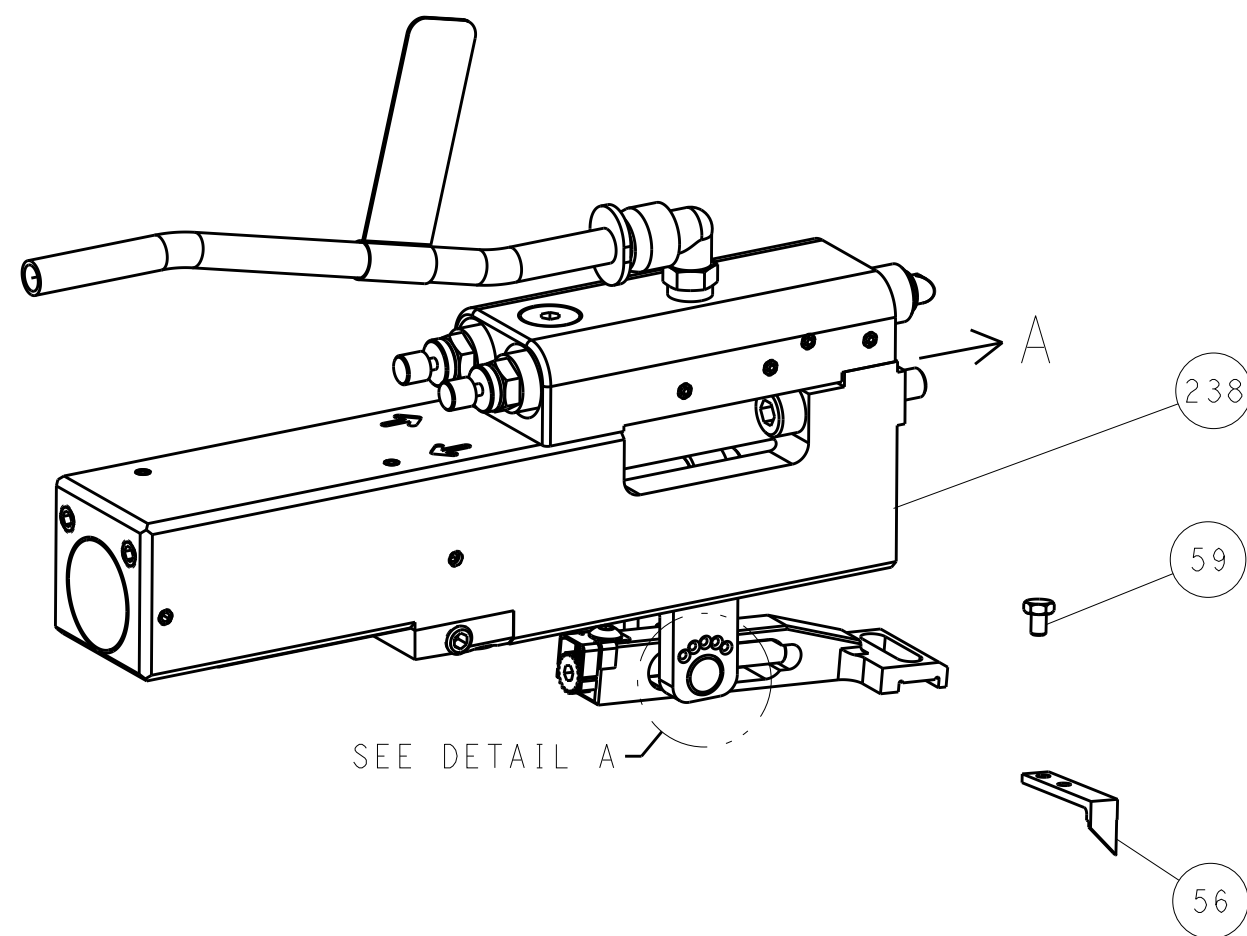
1. THIS DRAWING IS THE PROPERTY OF THE COMPANY AND IS NOT TO BE REPRODUCED OR COPIED IN ANY MANNER WITHOUT THE WRITTEN PERMISSION OF THE COMPANY. IT IS TO BE USED FOR THE MANUFACTURE OF THE PARTS SPECIFIED HEREON ONLY. IT IS TO BE KEPT IN THE COMPANY'S FILES FOR THE LATEST VERSION.		DWN 09DEC2011 C.K. ZHAO CHK 09DEC2011 T. ELBIN APPR 09DEC2011 S. XI		 TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm		TOLERANCES, UNLESS OTHERWISE SPECIFIED:		NAME Ocean Side Feed Applicator	
				PRODUCT SPEC	
				APPLICATION SPEC	
MATERIAL		FINISH		SIZE	CAGE CODE
-		-		A1	00779
				DRAWING NO C=2151427	
				RESTRICTED TO -	
				Customer Accessible Production Drawing	
				SCALE 1:2	SHEET 1 OF 4
				REV B	

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

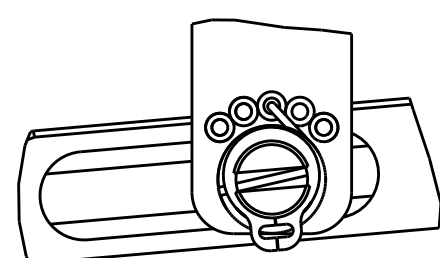
FEED TYPE MECHANICAL



PNEUMATIC

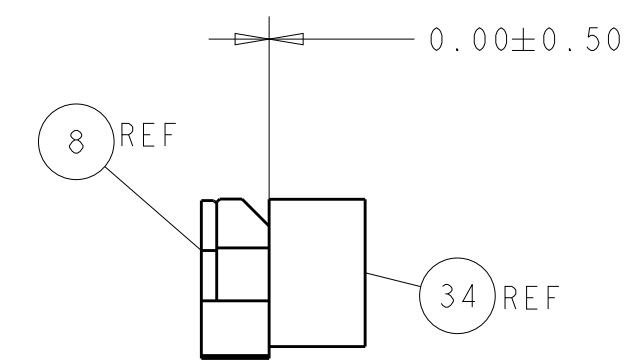
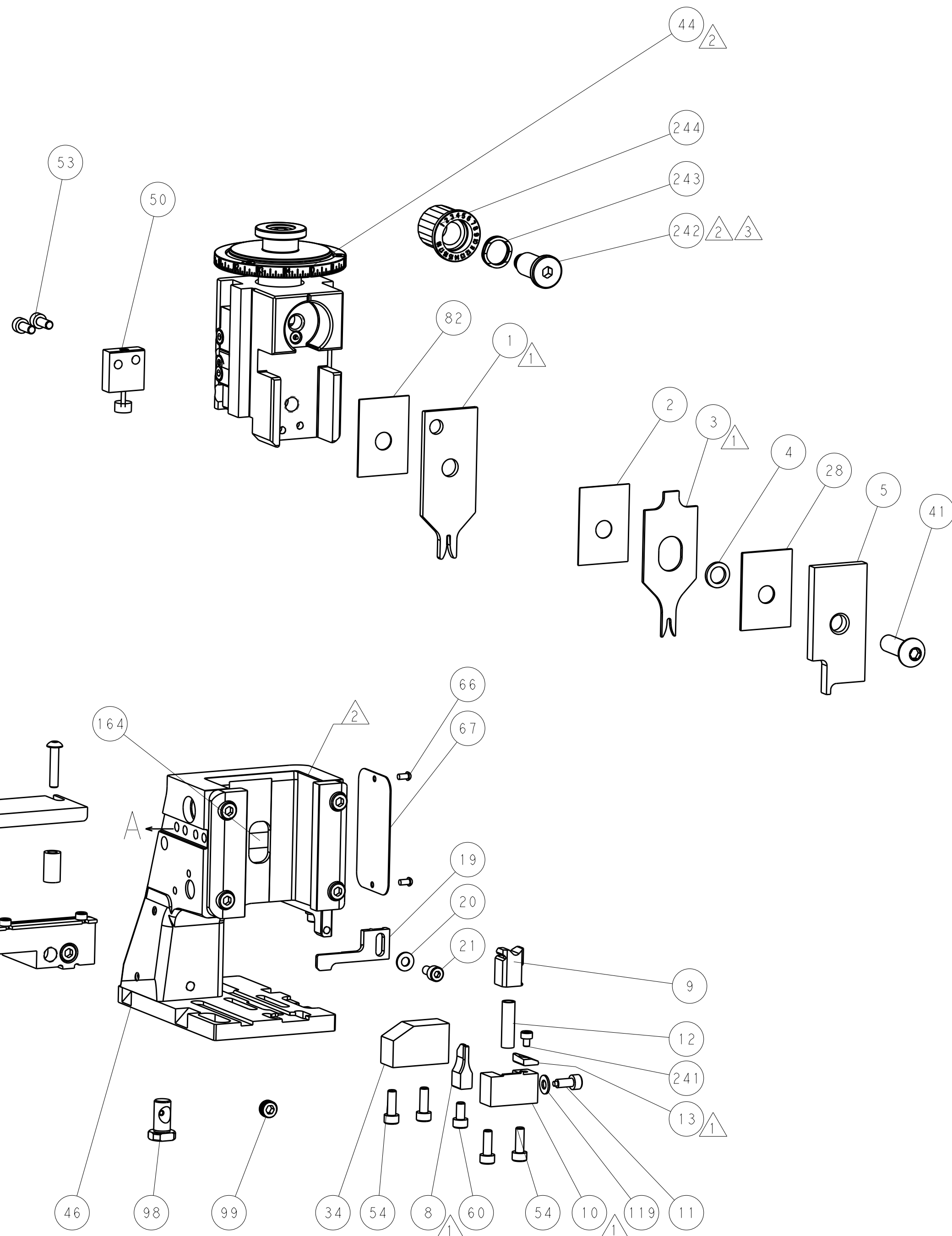
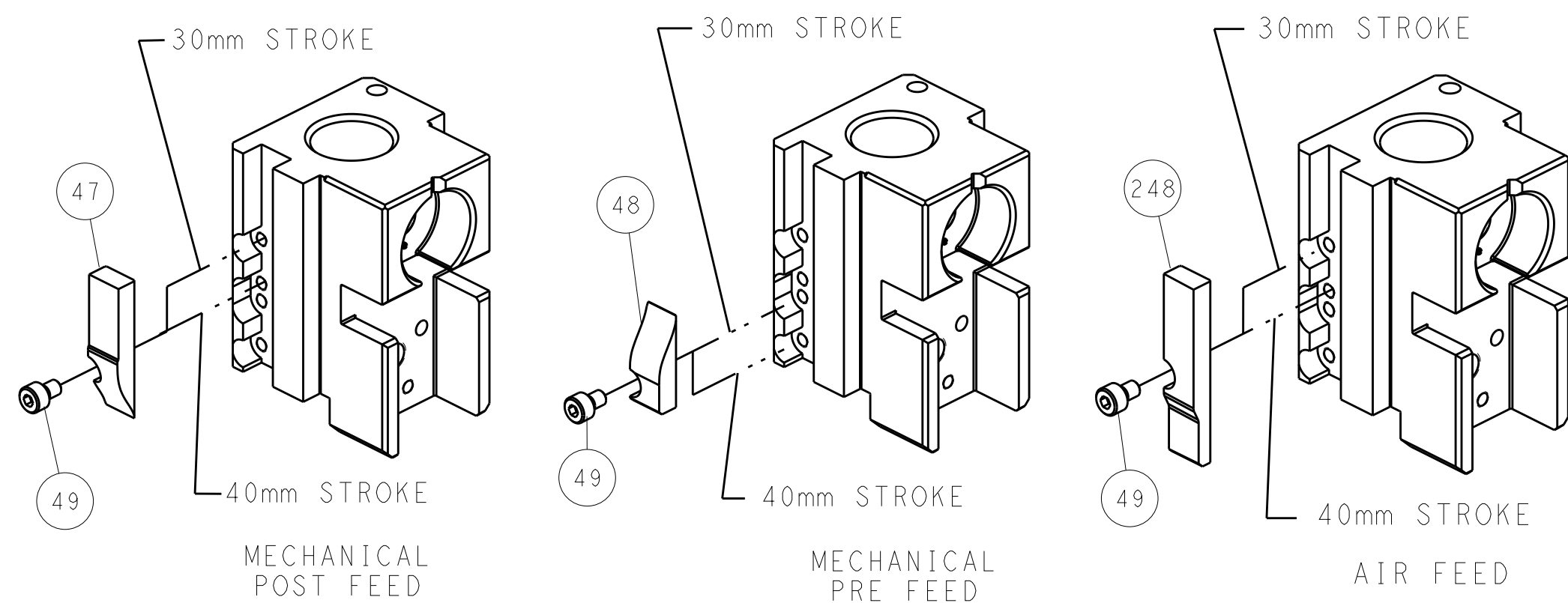


FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)

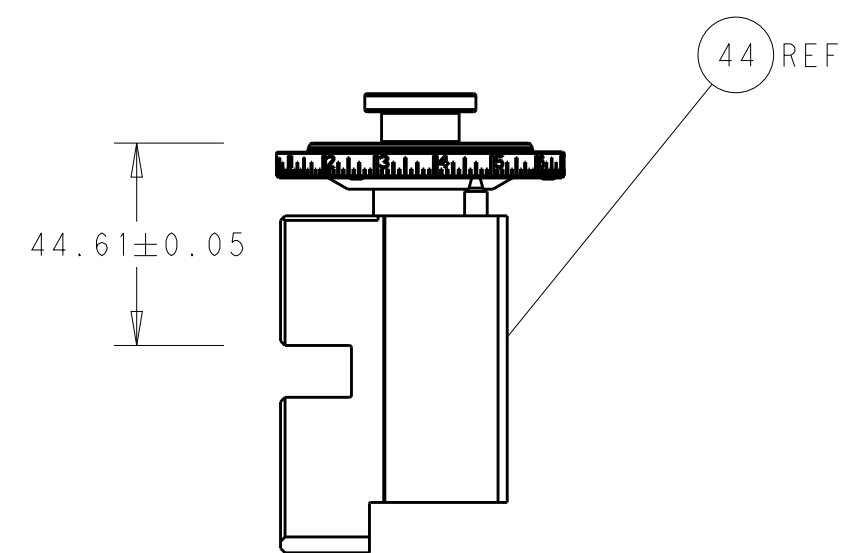


DETAIL A

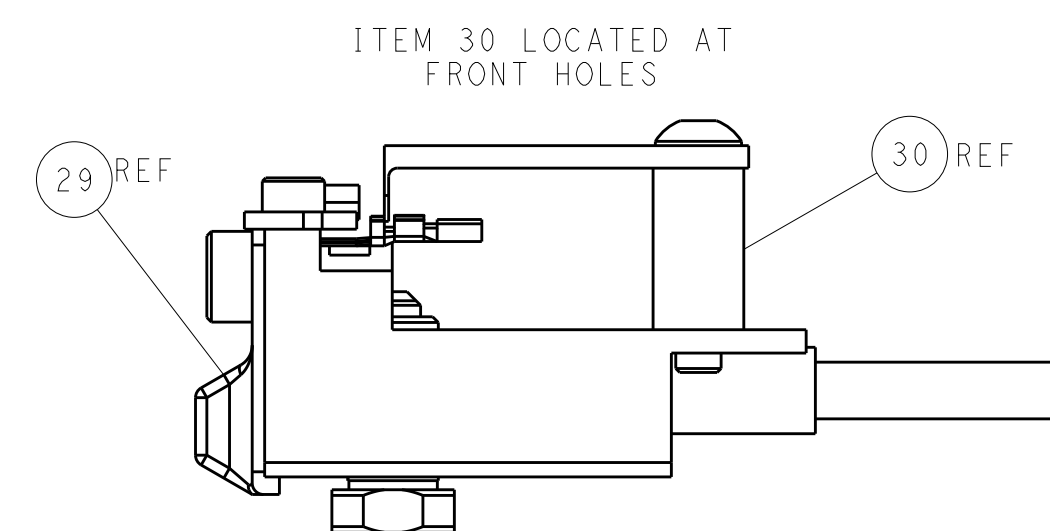
CAM POSITIONS



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)

DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN X.ZHAO 09DEC2011		CHK T.ELBIN 09DEC2011		APVD S.XI 09DEC2011		NAME	
0 PLC ±.5		1 PLC ±0.5		2 PLC ±0.13		3 PLC ±0.013		4 PLC ±0.001		PRODUCT SPEC	
ANGLES FINISH		WEIGHT		Customer Accessible Production Drawing		SCALE 1:2		SHEET 2 OF 4		REV B	
MATERIAL		FINISH		SIZE		CAGE CODE		DRAWING NO		RESTRICTED TO	
-		-		A1		00779		C=2151427		-	

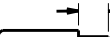
SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

8			7		
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20			20		
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PART NUMBER		REVISION		DESCRIPTION	
FEED TYPE					
2-2151427-1		B		FINE CRIMP HEIGHT ADJUST	
MECHANICAL					
2-2151427-2		B		FINE CRIMP HEIGHT ADJUST	
PNEUMATIC					
7-2151427-7		A		CRIMP TOOLING KIT	
-					

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.40 mm [.055]	F
INSUL	2.03 mm [.080]	O
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: RECEPTACLE .058 DIA P.C. CONTACT			
WIRE STRIP LENGTH 3.10-3.40 mm [.122-.134 IN]			INSULATION DIAMETER RANGE Ø1.15-1.77 mm [.045-.070 IN]
TERMINAL APPLICATION SPECIFICATION	114-1008	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
60598-3	60598-4	60598-7	60598-9
61622-1			

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING
20 AWG		1.04+/-0.05 [.041+/-0.002]		7.3
22 AWG		0.94+/-0.05 [.037+/-0.002]		8.4
24 AWG		0.86+/-0.05 [.034+/-0.002]		9.4



- 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.

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	2119082-9	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	1-18028-2	WASHER, FLAT, REG M4	119
-	1	1	2844908-1	SCREW, LOCKING	99
-	1	1	2844907-1	POST, LOCKING	98
-	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
-	2	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	53
-	1	1	1803382-6	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	1752356-5	SUPPORT, TERMINAL	34
-	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	2-2844962-6	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	1803095-6	FLOATING SHEAR, FRONT	9
1	1	1	2-1633128-9	ANVIL, COMBINATION .055	8
-	-	-	-	-	7
-	-	-	-	-	6
-	1	1	2119757-8	DEPRESSOR, SHEAR	5
-	1	1	2-238011-5	BLOCK, CRIMPER SPACER	4
1	1	1	2-1633965-1	CRIMPER, INSULATION O PREMIUM	3
-	1	1	455888-4	SPACER, CRIMPER	2
1	1	1	3-456402-0	CRIMPER, WIRE PREMIUM	1

-77	-22	-21	PART NO	DESCRIPTION	ITEM NO
			OWN X,ZHAO 09DEC2011 CHK T,ELBIN 09DEC2011 S,XI 09DEC2011 APVD		
			TE Connectivity Harrisburg, PA 17105-3608		
			NAME Ocean Side Feed Applicator		
			SIZE A		
			CAGE CODE 00779		
			DRAWING NO 2151427		
			RESTRICTED TO -		
			Customer Accessible Production Drawing		
			SCALE 1:2		
			SHEET 3		
			OF 4		
			REV B		

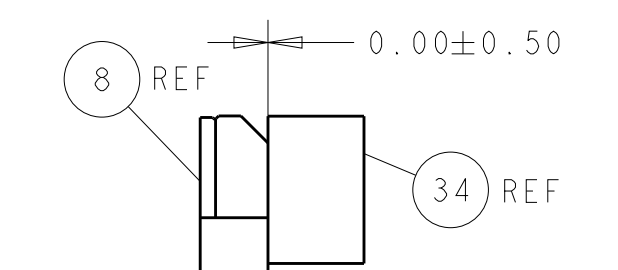
SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

PNEUMATIC

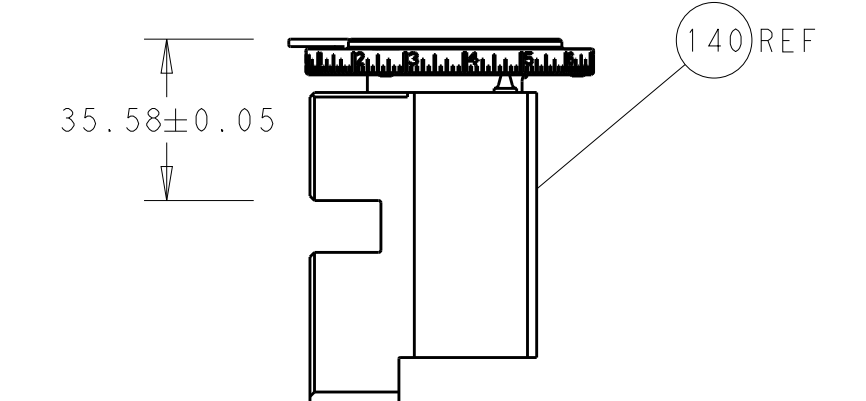


The diagrams illustrate three types of mechanical feed systems:

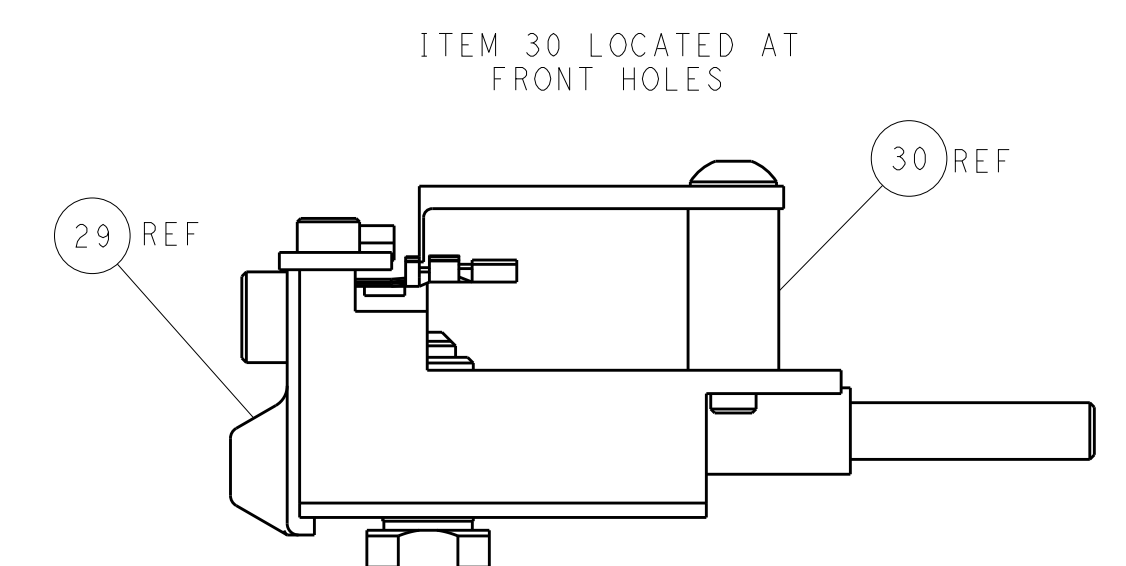
- MECHANICAL POST FEED:** Shows a 30mm stroke. Callouts include 1.42 (a small rectangular component) and 49 (a cylindrical component).
- MECHANICAL PRE FEED:** Shows a 30mm stroke. Callouts include 48 (a small rectangular component) and 49 (a cylindrical component).
- AIR FEED:** Shows a 30mm stroke. Callouts include 151 (a small rectangular component) and 49 (a cylindrical component).



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 TONY IT IS SUBJECT TO CHANGE AND THE CONTROL IN AN ENGINEERING ORGANIZATION SHOULD BE CONFIRMED FOR THE LATEST REVISION		DWN X ZHAO 09DEC2011 CHK ELBIN 09DEC2011 S XI 09DEC2011	 TE Connectivity Harrisburg, PA 17105-3608			
DIMENSIONS: mm	TOLERANCES, UNLESS OTHERWISE SPECIFIED: 0 PLC ±.1 1 PLC ±0.5 2 PLC ±0.13 3 PLC ±0.013 4 PLC ±0.0001 ANGLES ±.1	NAME Ocean Side Feed Applicator				
		APVD PRODUCT SPEC - APPLICATION SPEC -	SIZE A1	CASE CODE 00779	DRAWING NO C-2151427	RESTRICTED TO -
MATERIAL -	FINISH -	WEIGHT -	Customer Accessible Production Drawing			
			SCALE 1:2	SHEET 1	OF 1	REV B

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[2151427-2](#)