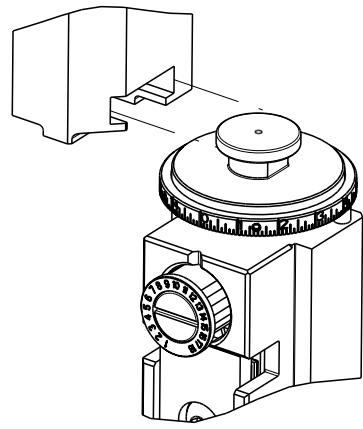
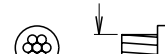


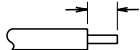
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151477-1	J	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2151477-2	K	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
3-2151477-2	K	FINE CRIMP HEIGHT ADJUST	DOUBLE ACTING PNEUMATIC WITH SENSORS
5-2151477-1	J	SEAL STRIPPER CRIMPER TERMINATING UNIT	MECHANICAL
5-2151477-2	K	SEAL STRIPPER CRIMPER TERMINATING UNIT	PNEUMATIC
7-2151477-1	J	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2151477-2	K	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2151477-7	A	CRIMP TOOLING KIT	-

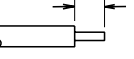
ATLANTIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.40 mm [.055]	F
INSUL	3.18 mm [.125]	O
APPLICATOR INSTRUCTIONS 408-35042		

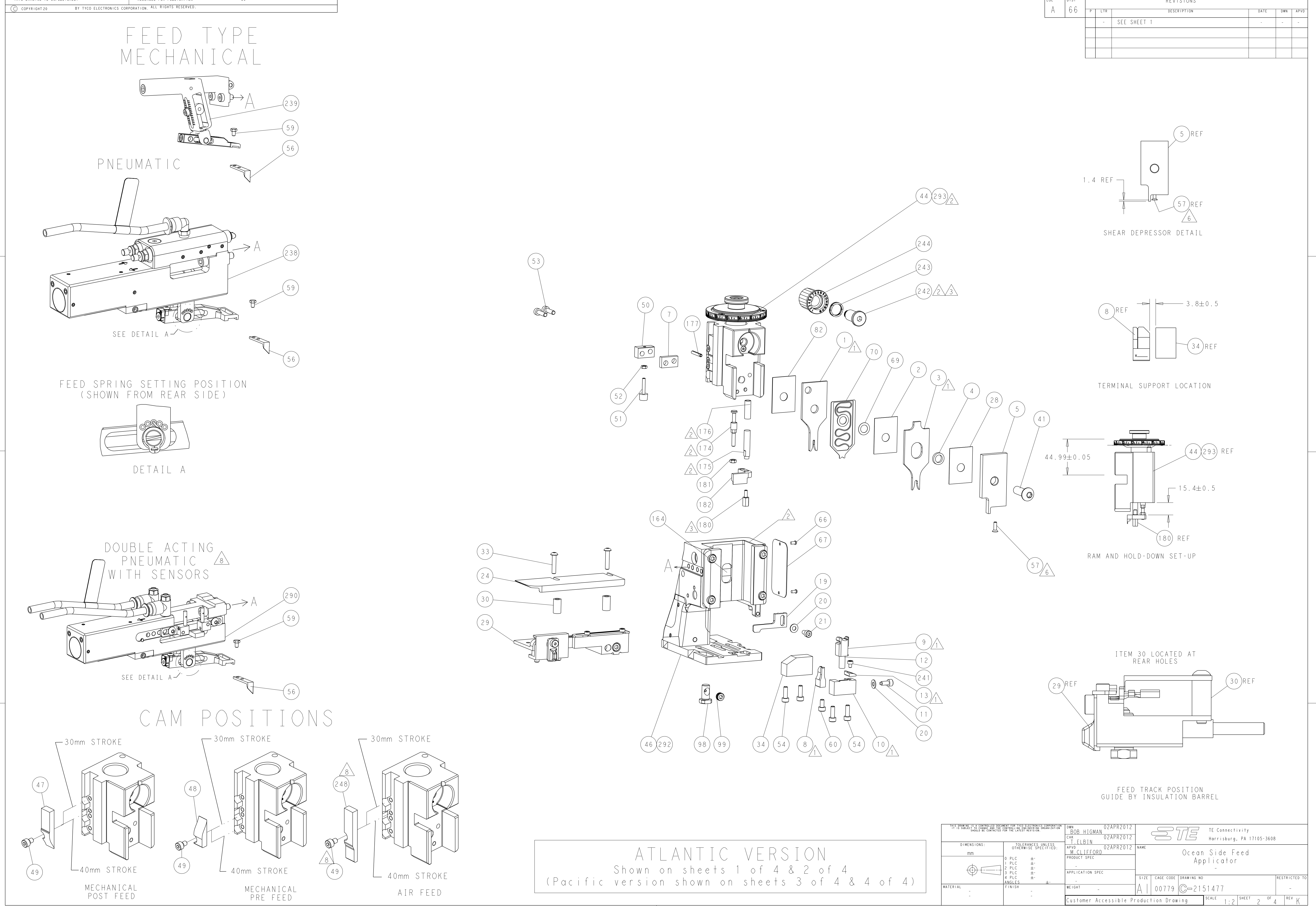
TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: TAB CONTACT 1.2MM			
WIRE STRIP LENGTH			INSULATION DIAMETER RANGE
3.30-3.90 mm [.130-.154 IN]			
TERMINAL APPLICATION SPECIFICATION		114-18464	-
		-	-
		-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE SEAL	TE SEAL
1718760-1	1718760-2	967067-1	963142-2
1718760-3			
WIRE SIZE		CRIMP HEIGHT mm [INCH]	
0.75mm2		1.05+/-0.03 [.041+/- .001]	CRIMP HEIGHT REFERENCE SETTING 
20 AWG OR 0.50mm2		0.93+/-0.03 [.037+/- .001]	5.9
			7.2

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: TAB CONTACT 1.2MM			
WIRE STRIP LENGTH			INSULATION DIAMETER RANGE
3.30-3.90 mm [.130-.154 IN]		Ø	
TERMINAL APPLICATION SPECIFICATION	 114-18464	-	-
	-	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE SEAL	TE SEAL
2141116-1	2208328-3	967067-1	963142-2
2141116-3			
WIRE SIZE	 ↓ 	CRIMP HEIGHT mm [INCH]	 ↓ 
0.75mm2		0.98+/-0.03 [.039+/- .001]	6.8
20 AWG OR 0.50mm2		0.93+/-0.03 [.037+/- .001]	7.2

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: TAB CONTACT 1.2MM			
WIRE STRIP LENGTH			INSULATION DIAMETER RANGE
3.30-3.90 mm [.130-.154 IN]		∅	
TERMINAL APPLICATION SPECIFICATION			-
			-
TERMINALS APPLIED			
TE TERMINAL		TE TERMINAL	TE SEAL
1718760-1		1718760-2	967067-1
WIRE SIZE		CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING 
20 AWG (19 / 0.203 mm)			6.7
0.61mm2			6.7

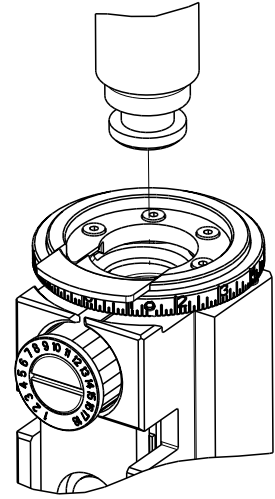
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		P	LYR	DESCRIPTION		DATE	DWN
							APVD
		H1		ECR-16-015428		4NOV2016	RS
		H2		ECR-17-001637		04FEB2017	KH
A	66	J		ECR-18-005917		18APR2018	JAH
		K		ECR-19-005438		04APR2019	LG

-	-	-	1	1	-	-	-	1803515-3	RAM ASSEMBLY, SF ATLANTIC	293
-	-	-	1	1	-	-	-	2-1803583-1	APPLICATOR BASIC ASSEMBLY, SF	292
-	-	-	-	-	1	-	-	2844950-1	AIR FEED MODULE	290
-	1	-	1	-	-	1	-	2119641-1	FEED CAM, AIR FEED	248
-	1	1	1	1	1	1	1	2119082-4	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1	1	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	1	1	1	1	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
-	-	1	-	1	-	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	1	-	1	-	-	1	-	2844940-1	AIR FEED MODULE	238
-	-	-	1	1	-	-	-	4-1722335-3	STRIPPER, SIDE FEED	182
-	-	-	1	1	-	-	-	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	181
-	-	-	1	1	-	-	-	2-1752354-0	STANDOFF,HOLD-DOWN	180
-	-	-	1	1	-	-	-	993111-1	PIN, SLOTTED SPRING 3.0 X 20.0	177
-	-	-	1	1	-	-	-	5-22280-0	SPRING, COMPRESSION	176
-	-	-	1	1	-	-	-	1752353-3	GUIDE PIN,HOLDDOWN	175
-	-	-	1	1	-	-	-	1901680-2	GUIDE PIN,HOLDDOWN	174
-	REF	REF	REF	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	1	1	1	1	1	1	1	2844908-1	SCREW, LOCKING	99
-	1	1	1	1	1	1	1	2844907-1	POST, LOCKING	98
-	1	1	1	1	1	1	1	455888-5	SPACER, CRIMPER	82
-	1	1	1	1	1	1	1	1803607-3	DOCUMENTATION PACKAGE	71
-	1	1	1	1	1	1	1	2119791-5	DEPRESSOR, WIRE	70
-	1	1	1	1	1	1	1	2119943-1	WASHER, SPACER	69
-	1	1	1	1	1	1	1	2119740-1	TAG,IDENTIFICATION	67
-	2	2	2	2	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	1	1	1	1	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	60
-	1	1	1	1	1	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	1	1	1	1	1	1	1	985575-3	SCR, FLT SKT HD CAP M3 X 10.0	57
-	1	1	1	1	1	1	1	1338685-1	PAWL, FEED	56
-	4	4	4	4	4	4	4	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	54
-	2	2	2	2	2	2	2	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	53
-	1	1	1	1	1	1	1	5018030-1	NUT, HEX, REG, RoHS, M3	52
-	1	1	1	1	1	1	1	811242-5	BUMPER, HOLD DOWN	51
-	1	1	1	1	1	1	1	690753-2	SPACER, TONKER	50
-	1	2	1	2	-	1	2	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	-	1	-	1	-	-	1	2119652-1	FEED CAM, PRE FEED	48
-	-	1	-	1	-	-	1	2119653-1	FEED CAM, POST FEED	47
-	1	1	-	-	1	1	1	1803583-9	APPLICATOR BASIC ASSEMBLY, SF	46
-	1	1	-	-	1	1	1	1803515-1	RAM ASSEMBLY, SF ATLANTIC	44
-	1	1	1	1	1	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
-	1	1	1	1	1	1	1	1752356-6	SUPPORT, TERMINAL	34
-	2	2	2	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	2	2	2	2	2	2-2844962-8	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	1	1	1	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29
-	1	1	1	1	1	1	1	455888-3	SPACER, CRIMPER	28
-	1	1	1	1	1	1	1	1320928-6	STRIP GUIDE	24
-	1	1	-	-	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
-	2	2	1	1	2	2	2	1-18028-2	WASHER, FLAT, REG M4	20
-	1	1	-	-	1	1	1	2119533-1	STRIPPER, SIDE FEED	19
-	1	1	1	1	1	1	1	2119806-1	INSERT, SHEAR	13
-	1	1	1	1	1	1	1	3-22280-3	SPRING, COMPRESSION	12
-	1	1	1	1	1	1	1	1-356885-4	STOP, SHEAR	11
-	1	1	1	1	1	1	1	2119805-1	SHEAR HOLDER, FRONT	10
-	1	1	1	1	1	1	1	318707-1	FLOATING SHEAR, FRONT	9
1	2	2	1	1	1	1	1	7-1333201-4	ANVIL, COMBINATION	8
-	1	1	1	1	1	1	1	5-240641-0	SPACER	7
-	-	-	-	-	-	-	-	-	-	6
-	1	1	1	1	1	1	1	2-2119781-4	DEPRESSOR, SHEAR	5
-	1	1	1	1	1	1	1	238011-4	BLOCK, CRIMPER SPACER	4
1	2	2	1	1	1	1	1	1633965-1	CRIMPER, INSULATION O PREMIUM	3
-	1	1	1	1	1	1	1	455888-3	SPACER, CRIMPER	2
1	2	2	1	1	1	1	1	1-456402-7	CRIMPER, WIRE PREMIUM	1

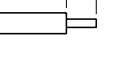


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PART NUMBER	REVISION	DESCRIPTION		FEED TYPE	
2-2151477-1	J	FINE CRIMP HEIGHT ADJUST		MECHANICAL	
2-2151477-2	K	FINE CRIMP HEIGHT ADJUST		PNEUMATIC	
4-2151477-2	K	FINE CRIMP HEIGHT ADJUST		DOUBLE ACTING PNEUMATIC WITH SENSORS	
7-2151477-7	A	CRIMP TOOLING KIT		-	

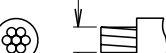
PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.40 mm [.055]	F
INSUL	3.18 mm [1.25]	O
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: TAB CONTACT 1.2MM			
WIRE STRIP LENGTH			INSULATION DIAMETER RANGE
3.30-3.90 mm [.130-.154 IN]		$\varnothing$	
TERMINAL APPLICATION SPECIFICATION		114-18464	- -
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE SEAL	TE SEAL
1718760-1	1718760-2	967067-1	963142-2
1718760-3			
WIRE SIZE		CRIMP HEIGHT mm [INCH]	
0.75mm ²		1.05+/-0.03 [.041+/- .001]	
20 AWG OR 0.50mm ²		0.93+/-0.03 [.037+/- .001]	

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: TAB CONTACT 1.2MM			
WIRE STRIP LENGTH			INSULATION DIAMETER RANGE
3.30-3.90 mm [.130-.154 IN]		Ø	
TERMINAL APPLICATION SPECIFICATION	 114-18464	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE SEAL	TE SEAL
2141116-1	2208328-3	967067-1	963142-2
2141116-3			
WIRE SIZE	 CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING 
0.75mm2	0.98+/-0.03 [.039+/- .001]		6.8
20 AWG OR 0.50mm2	0.93+/-0.03 [.037+/- .001]		7.2

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: TAB CONTACT 1.2MM			
WIRE STRIP LENGTH 3.30-3.90 mm [.130-.154 IN]		INSULATION DIAMETER RANGE Ø 	
TERMINAL APPLICATION SPECIFICATION  		- -	
TERMINALS APPLIED			
TE TERMINAL 1718760-1	TE TERMINAL 1718760-2	TE SEAL 1718760-3	TE SEAL 967067-1
WIRE SIZE  20 AWG (19 / 0.203 mm) 0.61mm2	CRIMP HEIGHT mm [INCH]  0.99+/-0.03 [.039+/- .001] 0.99+/-0.03 [.039+/- .001]	CRIMP HEIGHT REFERENCE SETTING  6.7 6.7	

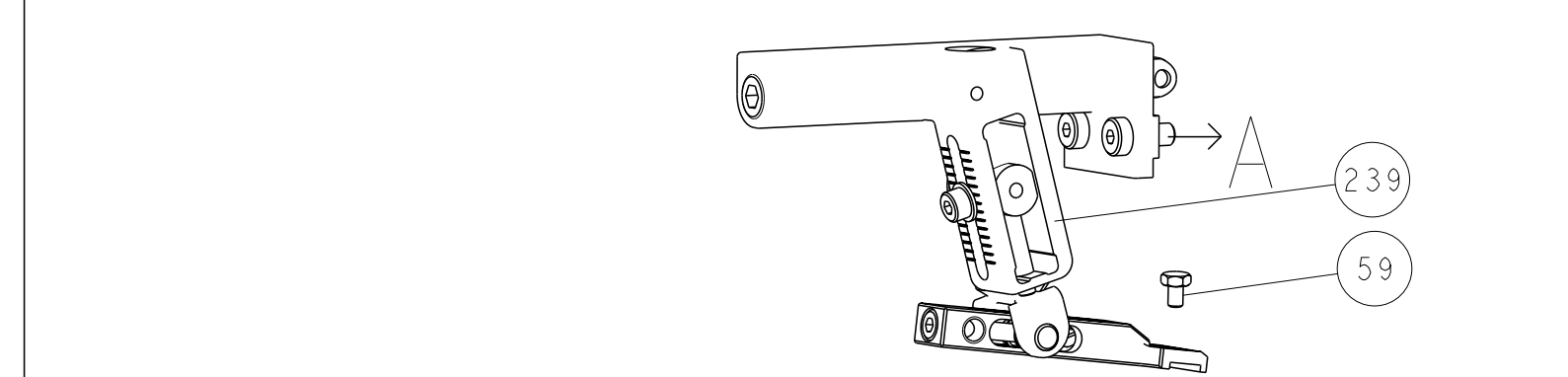
-	1	-	-	2844950-1	AIR FEED MODULE	290
-	1	1	1	2119082-4	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
-	-	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	-	1	-	2844940-1	AIR FEED MODULE	238
-	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	-	1	-	2119641-2	FEED CAM, AIR FEED	151
-	1	1	1	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	144
-	4	4	4	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	143
-	-	-	1	2119653-2	FEED CAM, POST FEED	142
-	1	1	1	1-1803583-0	APPLICATOR BASIC ASSEMBLY, SF	141
-	1	1	1	1803516-1	RAM ASSEMBLY, SF PACIFIC	140
-	1	1	1	2844908-1	SCREW, LOCKING	99
-	1	1	1	2844907-1	POST, LOCKING	98
-	1	1	1	455888-5	SPACER, CRIMPER	82
-	1	1	1	1803607-3	DOCUMENTATION PACKAGE	71
-	1	1	1	2119791-5	DEPRESSOR, WIRE	70
-	1	1	1	2119943-1	WASHER, SPACER	69
-	1	1	1	2119740-1	TAG,IDENTIFICATION	67
-	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	1	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	1	1	1	985575-3	SCR, FLT SKT HD CAP M3 X 10.0	57
-	1	1	1	1338685-1	PAWL, FEED	56
-	2	2	2	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	53
-	1	1	1	5018030-1	NUT, HEX, REG, RoHS, M3	52
-	1	1	1	811242-5	BUMPER, HOLD DOWN	51
-	1	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	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
-	1	1	1	1752356-6	SUPPORT, TERMINAL	34
-	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	2	2-2844962-8	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29
-	1	1	1	455888-3	SPACER, CRIMPER	28
-	1	1	1	1320928-6	STRIP GUIDE	24
-	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
-	2	2	2	1-18028-2	WASHER, FLAT, REG M4	20
-	1	1	1	2119533-1	STRIPPER, SIDE FEED	19
-	1	1	1	2119806-1	INSERT, SHEAR	13
-	1	1	1	3-22280-3	SPRING, COMPRESSION	12
-	1	1	1	1-356885-4	STOP, SHEAR	11
-	1	1	1	2119805-1	SHEAR HOLDER, FRONT	10
-	1	1	1	318707-1	FLOATING SHEAR, FRONT	9
1	1	1	1	7-1333201-4	ANVIL, COMBINATION	8
-	1	1	1	5-240641-0	SPACER	7
-	-	-	-	-	-	6
-	1	1	1	2-2119781-4	DEPRESSOR, SHEAR	5
-	1	1	1	238011-4	BLOCK, CRIMPER SPACER	4
1	1	1	1	1633965-1	CRIMPER, INSULATION O PREMIUM	3
-	1	1	1	455888-3	SPACER, CRIMPER	2
1	1	1	1	1-456402-7	CRIMPER, WIRE PREMIUM	1
-77	-42	-22	-21	PART NO	DESCRIPTION	ITEM NO

- 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.
- THIS APPLICATOR APPLIES TERMINAL WITH A SEAL.
- | | |
|----------|-----------|
| SEAL P/N | INS. Ø |
| 967067-1 | 1.4-2.1mm |
| 963142-2 | 0.9-1.3mm |
- 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.
- THIS CRIMP PARAMETER IS PROVIDED TO MEET A CUSTOM AND UNIQUE CUSTOMER REQUIREMENT. IT HAS BEEN EVALUATED AND IS CONDITIONALLY SPECIFIED BY TE CONNECTIVITY. THIS CUSTOMIZED CRIMP PARAMETER IS NOT LISTED AS AN APPROVED APPLICATION WITHIN A TE CONNECTIVITY APPLICATION SPECIFICATION; HOWEVER, IT HAS BEEN VALIDATED ACCORDING TO TE CONNECTIVITY SPECIFICATIONS 109-18079 (TEST GROUP 1) AND 114-18022. **TE CONNECTIVITY EXPRESSLY DISCLAIMS ANY AND ALL WARRANTIES THAT THE PRODUCT WILL PERFORM SIMILARLY TO VALIDATED AND APPROVED APPLICATIONS, AS STATED WITHIN TE CONNECTIVITY APPLICATION SPECIFICATIONS, INCLUDING BUT NOT LIMITED TO IMPLIED WARRANTIES OF MERCHANTABILITY OR FITNESS FOR PARTICULAR PURPOSE.** AS SUCH, IT IS HIGHLY RECOMMENDED THAT THE CUSTOMER PERFORM FURTHER DETAILED EVALUATION TO ASSESS PRODUCT PERFORMANCE IN THE SPECIFIC APPLICATION.
- THIS APPLICATOR IS EQUIPED WITH THE DOUBLE ACTING PNEUMATIC FEED WITH SENSORS, AND IS APPLICATION SPECIFIC AND DOES NOT REQUIRE ITEMS 49 & 151.
9. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.

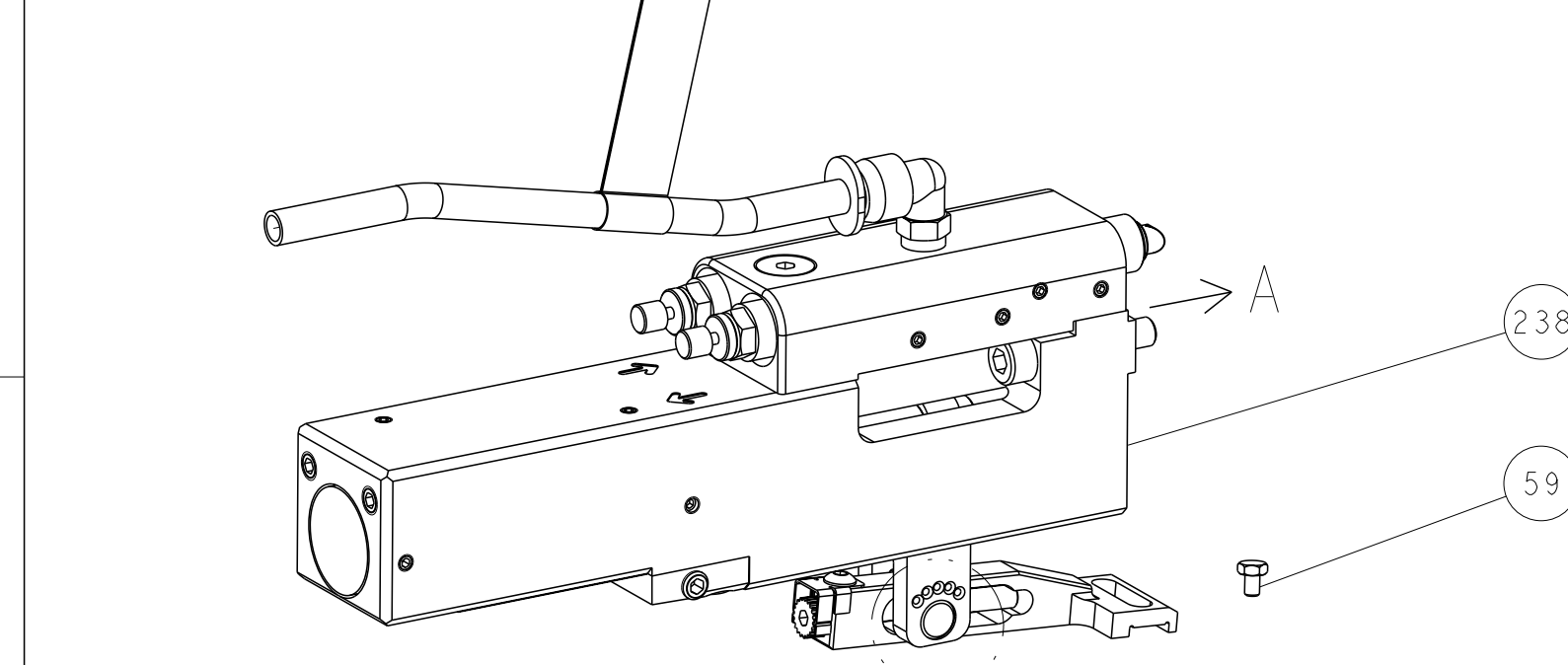
PACIFIC VERSION
Shown on sheets 3 of 4 & 4 of 4
(Atlantic version shown on sheets 1 of 4 & 2 of 4)

DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		NAME Ocean Side Feed Applicator	
0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ±		± ± ± ± ±		SIZE 00779	
MATERIAL		FINISH		RESTRICTED TO	
-		-		-	
Customer Accessible Production Drawing		SCALE		REV K	
1:2		SHEET 3 OF 4			

FEED TYPE MECHANICAL

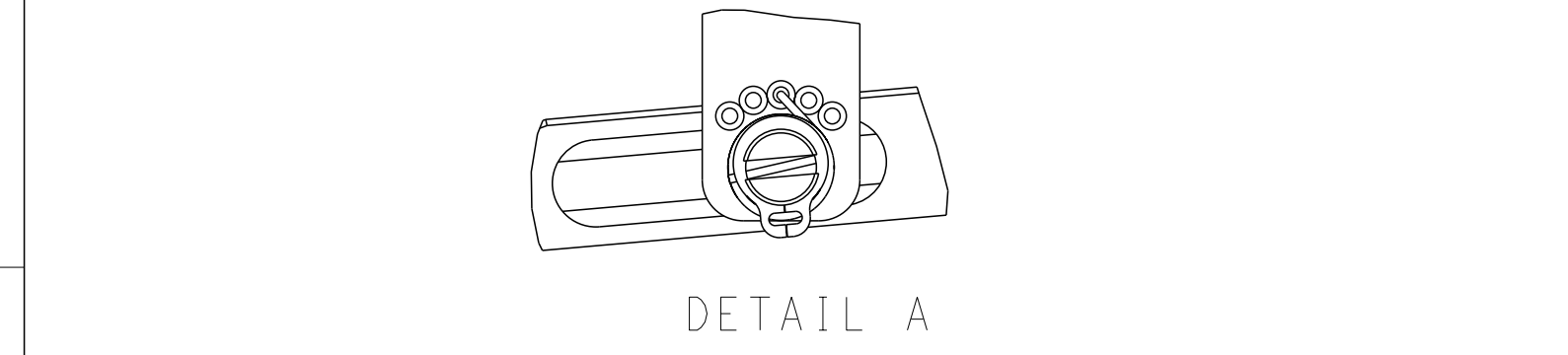


PNEUMATIC

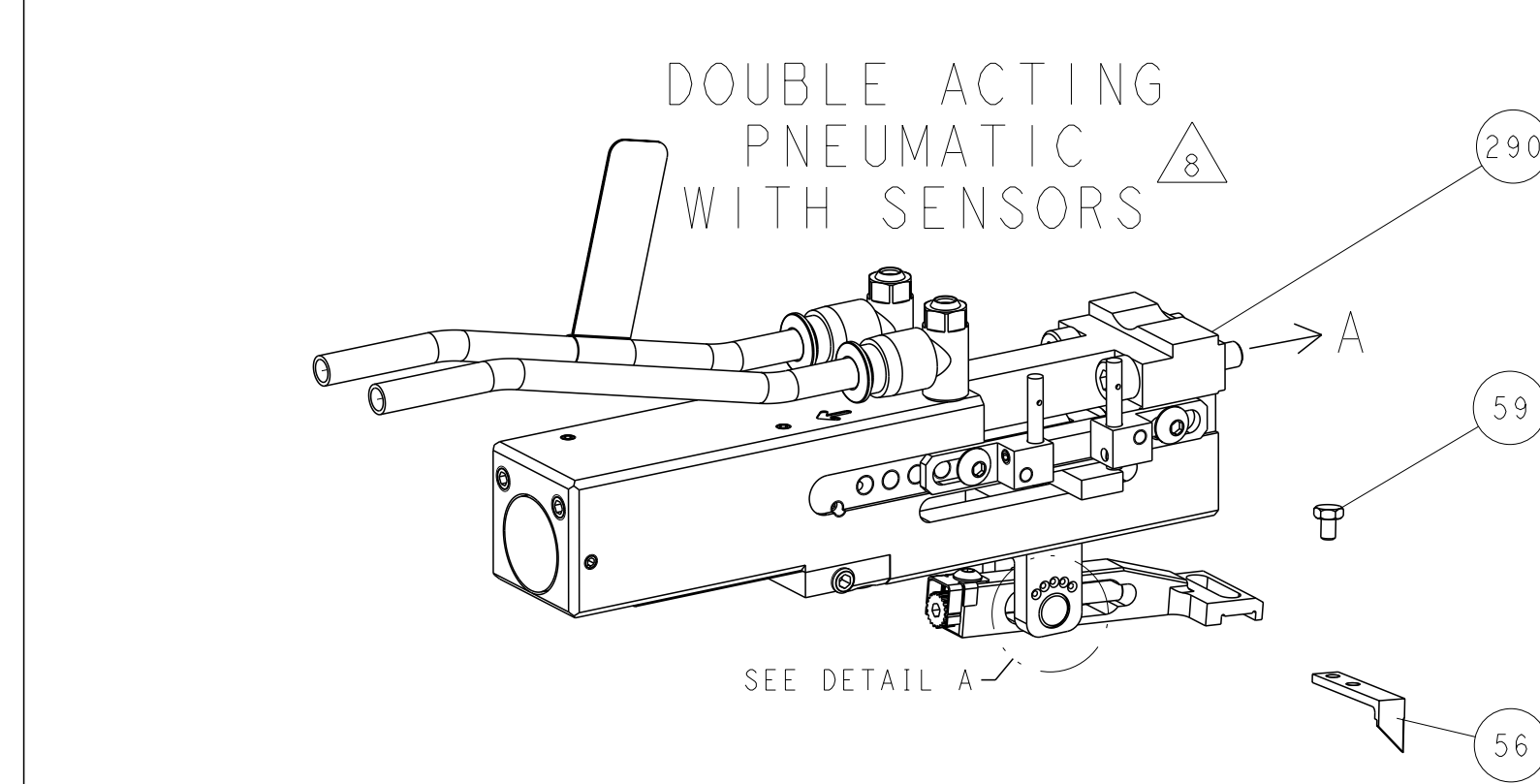


SEE DETAIL A

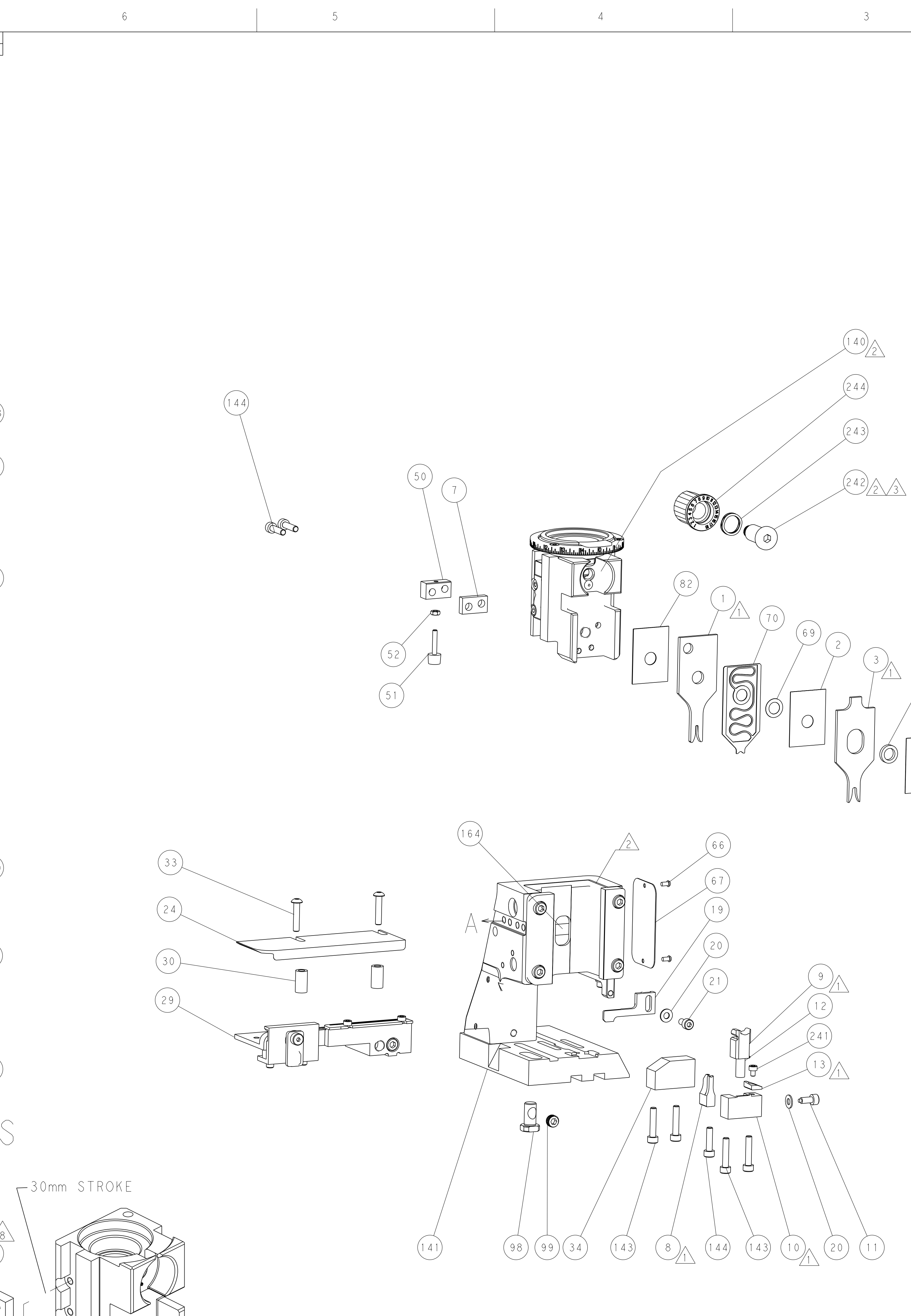
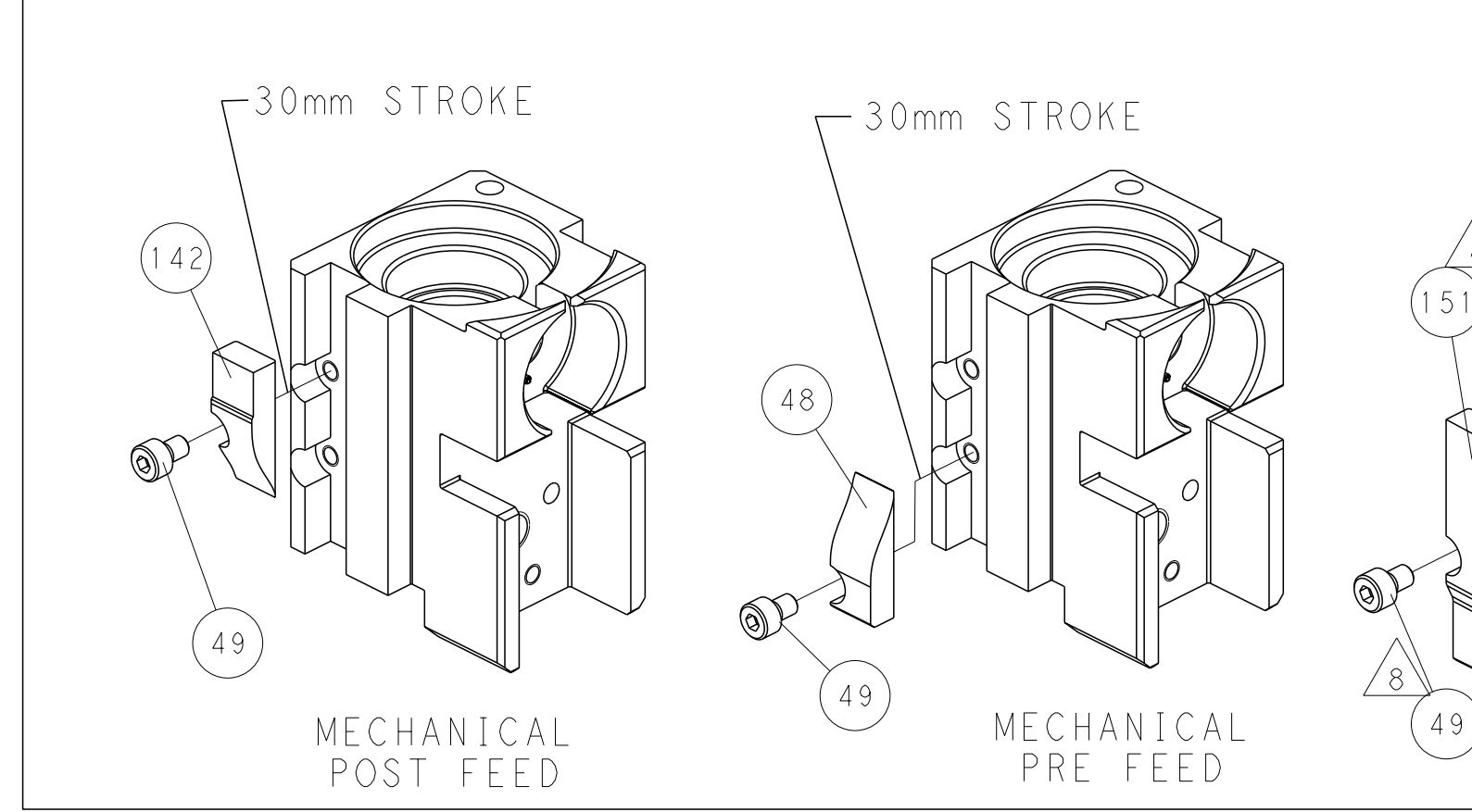
FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



DOUBLE ACTING PNEUMATIC WITH SENSORS

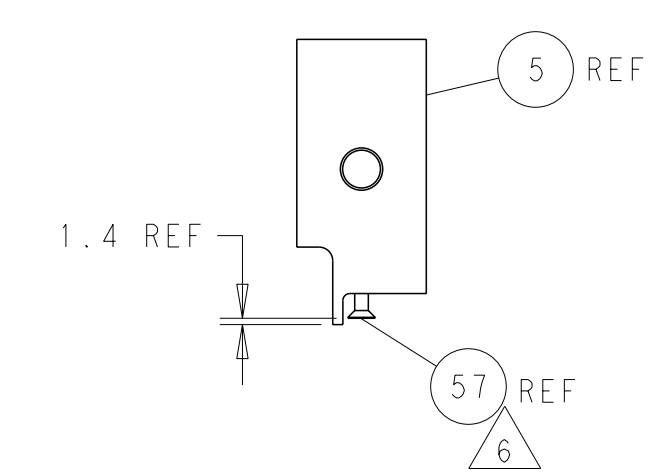


CAM POSITIONS

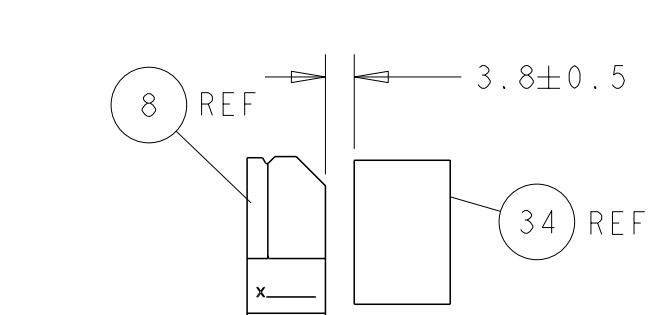


PACIFIC VERSION
Shown on sheets 3 of 4 & 4 of 4
(Atlantic version shown on sheets 1 of 4 & 2 of 4)

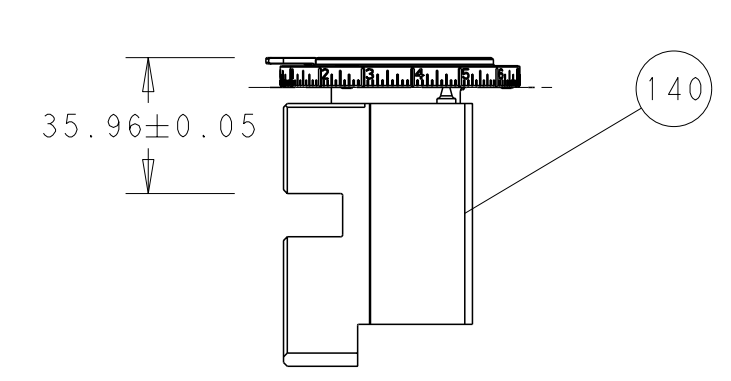
LOC		DIST		REVISIONS				
A		66		REV	DESCRIPTION	DATE	DWN	APVD
				-	SEE SHEET 1	-	-	-



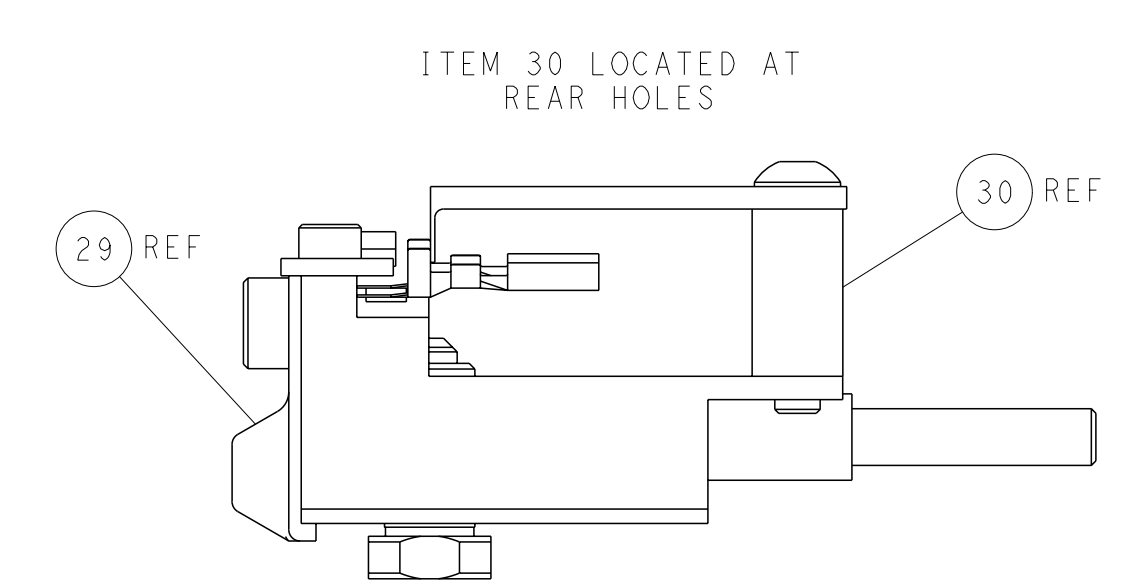
SHEAR DEPRESSOR DETAIL



TERMINAL SUPPORT LOCATION



RAM SET-UP



FEED TRACK POSITION GUIDE BY INSULATION BARREL

THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE AND TO THE CONTROL AND ENGINEERING ORGANIZATION. SHOULD BE CONTACTED FOR THE LATEST REVISION.				DWN: BOB HIGMAN 02APR2012 CHK: T. ELBIN 02APR2012 APVD: M. CLIFFORD 02APR2012 NAME: Ocean Side Feed Applicator	
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		TE Connectivity Harrisburg, PA 17105-3608	
mm				Ocean Side Feed Applicator	
		0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		APVD: M. CLIFFORD 02APR2012 PRODUCT SPEC - APPLICATION SPEC -	
MATERIAL		FINISH		SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2151477 RESTRICTED TO: -	
Customer Accessible Production Drawing				SCALE: 1:2 SHEET 4 OF 4 REV: K	

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

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