


8		7	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151519-1	D	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2151519-2	E	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
3-2151519-2	E	FINE CRIMP HEIGHT ADJUST	DOUBLE ACTING PNEUMATIC WITH SENSORS
7-2151519-1	D	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2151519-2	E	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2151519-7	A	CRIMP TOOLING KIT	-

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.57 mm [.062]	F
INSUL	3.30 mm [.130]	O
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: HPF 1.5mm SENSORCONTACT ASSEMBLY AND BODY			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
4.20-4.60 mm [.165-.181 IN]		Ø 1.40-1.90 mm [.055-.075 IN]	
TERMINAL APPLICATION SPECIFICATION		114-18912	
			

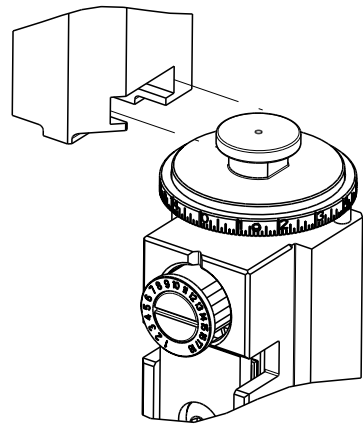
TERMINALS APPLIED				SEAL INSULATION DIAMETER RANGE
TE TERMINAL	TE TERMINAL	TE SEAL	TE SEAL	
1563623-2	2325198-3	9-963530-1	963530-1	
2292290-1		9-964971-1	964971-1	
2208362-3		967067-1		

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING
0.50mm2		0.99+/-0.03 [.039+/- .001]		8.5



- 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.
6. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- TERMINAL LUBRICANT IS RECOMMENDED.
- THIS APPLICATOR IS EQUIPPED WITH THE DOUBLE ACTING FEED WITH SENSORS AND IS APPLICATION SPECIFIC. IT DOES NOT REQUIRE ITEMS 49 & 248.

ATLANTIC VERSION TERMINATOR
INTERFACE ADAPTER

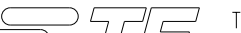



***WARNING**
ON INSTALLATION, SET WIRE DISC TO CRIMP HEIGHT REFERENCE SETTING FOR LARGEST WIRE SIZE. CRIMP HEIGHT REFERENCE SETTINGS GREATER THAN THE VALUE SHOWN MAY CAUSE DAMAGE TO THE CRIMP TOOLING. REFER TO THE INSTRUCTION SHEET FOR PROPER SETUP AND ADJUSTMENTS.

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

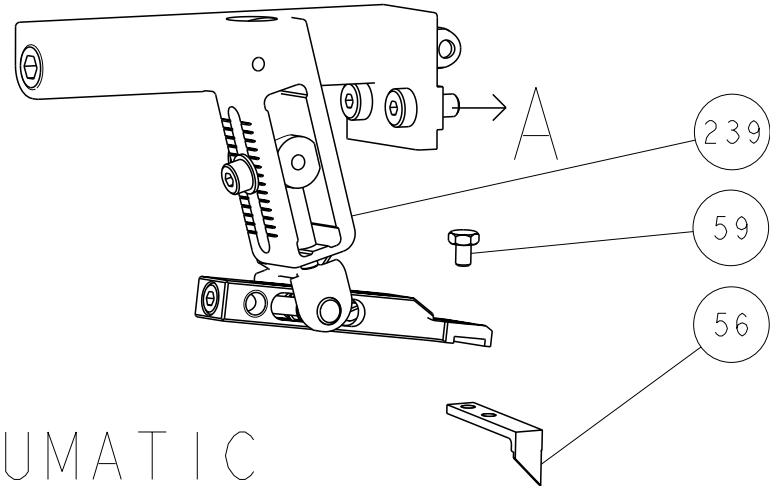
LOC	DIST	REVISIONS				
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			D	ECR-19-010474	03JUL2019	TB
			E	ECR-19-011319	18JUL2019	FJ
			E1	ECR-20-010242	20JUL2020	FZ
A	66		E2	ECR-21-001818	11FEB2021	JWC

8	-	-	-	1	-	-	2844950-1	AIR FEED MODULE	290
	-	1	-	-	1	-	2119641-1	FEED CAM, AIR FEED	248
3	-	1	1	1	1	1	2119082-7	CAM, SNAIL, INSULATION ADJUSTMENT	244
	-	1	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
7	-	1	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
	-	1	1	1	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
7	-	-	1	-	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
	-	1	-	-	1	-	2844940-1	AIR FEED MODULE	238
7	-	REF	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
	-	1	1	1	1	1	1-18028-2	WASHER, FLAT, REG M4	119
7	-	1	1	1	1	1	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113
	-	1	1	1	1	1	2844908-1	SCREW, LOCKING	99
5	-	1	1	1	1	1	2844907-1	POST, LOCKING	98
	-	1	1	1	1	1	455888-4	SPACER, CRIMPER	82
5	-	1	1	1	1	1	1803607-3	DOCUMENTATION PACKAGE	71
	-	1	1	1	1	1	2119740-1	TAG,IDENTIFICATION	67
5	-	2	2	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
	-	1	1	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	60
5	-	1	1	1	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
	-	1	1	1	1	1	985575-3	SCR, FLT SKT HD CAP M3 X 10.0	57
8	-	1	1	1	1	1	1338685-1	PAWL, FEED	56
	-	4	4	4	4	4	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	54
8	-	2	2	2	2	2	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	53
	-	1	1	1	1	1	5018030-1	NUT, HEX, REG, RoHS, M3	52
8	-	1	1	1	1	1	811242-5	BUMPER, HOLD DOWN	51
	-	1	1	1	1	1	690753-2	SPACER, TONKER	50
8	-	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	-	-	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	1	1803515-1	RAM ASSEMBLY, SF ATLANTIC	44
	-	1	1	1	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
1	-	1	1	1	1	1	1752356-6	SUPPORT, TERMINAL	34
	-	2	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
1	-	2	2	2	2	2	3-2844962-0	SPACER, CYLINDRICAL, STRIP GUIDE	30
	-	1	1	1	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29
1	-	1	1	1	1	1	1-455888-0	SPACER, CRIMPER	28
	-	1	1	1	1	1	1320928-2	STRIP GUIDE	24
1	-	1	1	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
	-	1	1	1	1	1	1-18028-2	WASHER, FLAT, REG M4	20
1	-	1	1	1	1	1	2119533-1	STRIPPER, SIDE FEED	19
	-	1	1	1	1	1	2119806-1	INSERT, SHEAR	13
1	-	1	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	1	1	2119805-1	SHEAR HOLDER, FRONT	10
	-	1	1	1	1	1	318707-1	FLOATING SHEAR, FRONT	9
1	1	2	2	1	1	1	1333332-2	ANVIL, COMBINATION, SPECIAL	8
	-	1	1	1	1	1	2-240641-9	SPACER	7
1	-	-	-	-	-	-	-	-	6
	-	1	1	1	1	1	2119781-1	DEPRESSOR, SHEAR	5
1	-	1	1	1	1	1	238011-4	BLOCK, CRIMPER SPACER	4
	1	2	2	1	1	1	2-1633996-7	CRIMPER, INSULATION SPECIAL	3
1	-	1	1	1	1	1	1-455888-3	SPACER, CRIMPER	2
	1	2	2	1	1	1	1-456403-5	CRIMPER, WIRE PREMIUM	1
1	-77	-72	-71	-32	-2	-1	PART NO	DESCRIPTION	ITEM NO

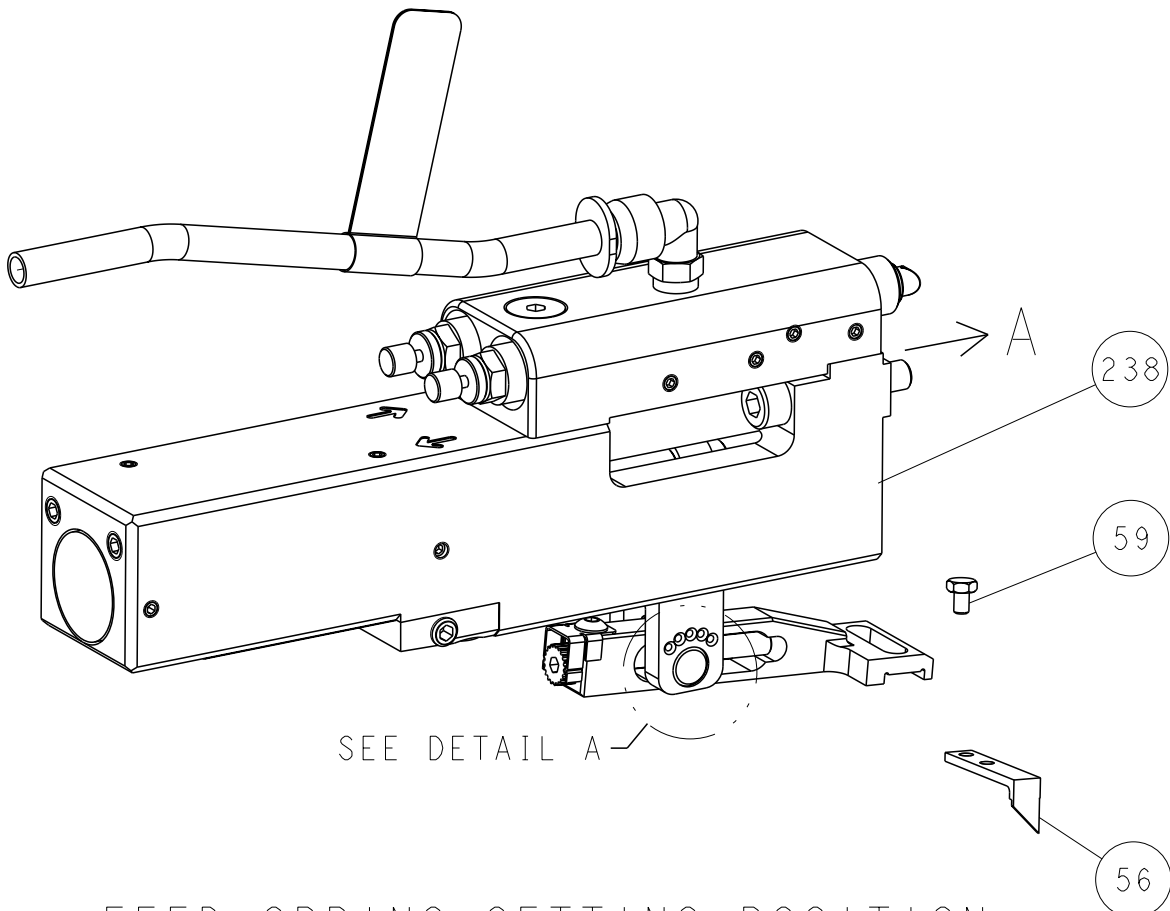
THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE AND TO BE CONTROLLED BY THE ENGINEERING ORGANIZATION. IT SHOULD BE CONTACTED FOR THE LATEST REVISION.		DWN	Y. YIN	14MAR2013	 TE Connectivity Harrisburg, PA 17105-3608	
		CHK	G. BAILEY	14MAR2013		
		APVD	J. GUO	14MAR2013		
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:			NAME	
mm		0 PLC ± 2 PLC ± 3 PLC ± 4 PLC ±			Ocean Side Feed Applicator	
		ANGLES ±				
MATERIAL		FINISH			SIZE CASE CODE DRAWING NO	
-		-			A1 00779 ©=2151519	
					RESTRICTED TO	
					Customer Accessible Production Drawing	
					SCALE 1:2 SHEET 1 OF 4 REV E2	

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

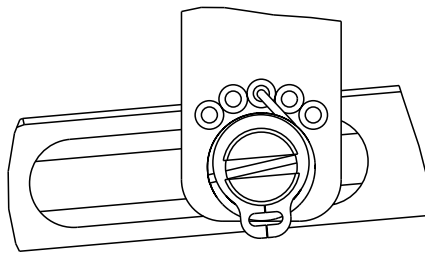
FEED TYPE MECHANICAL



PNEUMATIC

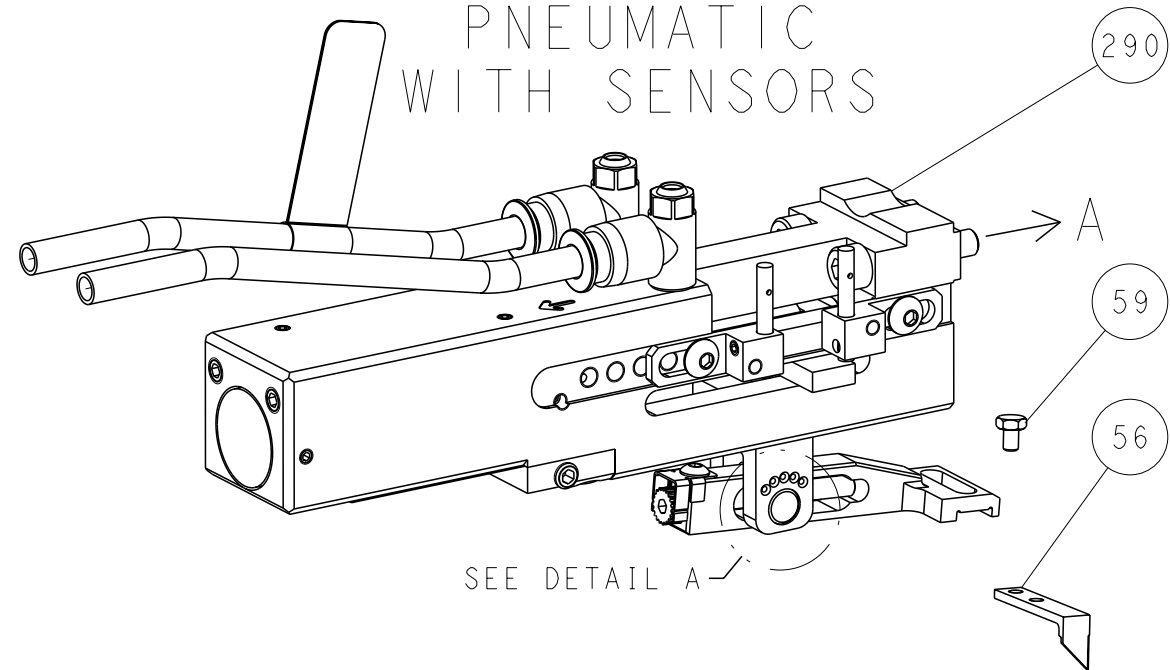


FEED SPRING SETTING POSITION
(SHOWN FROM REAR SIDE)

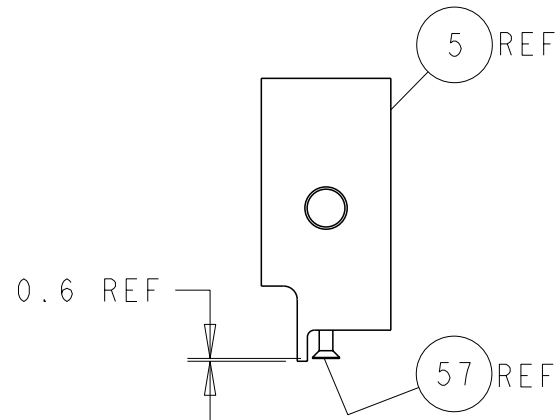
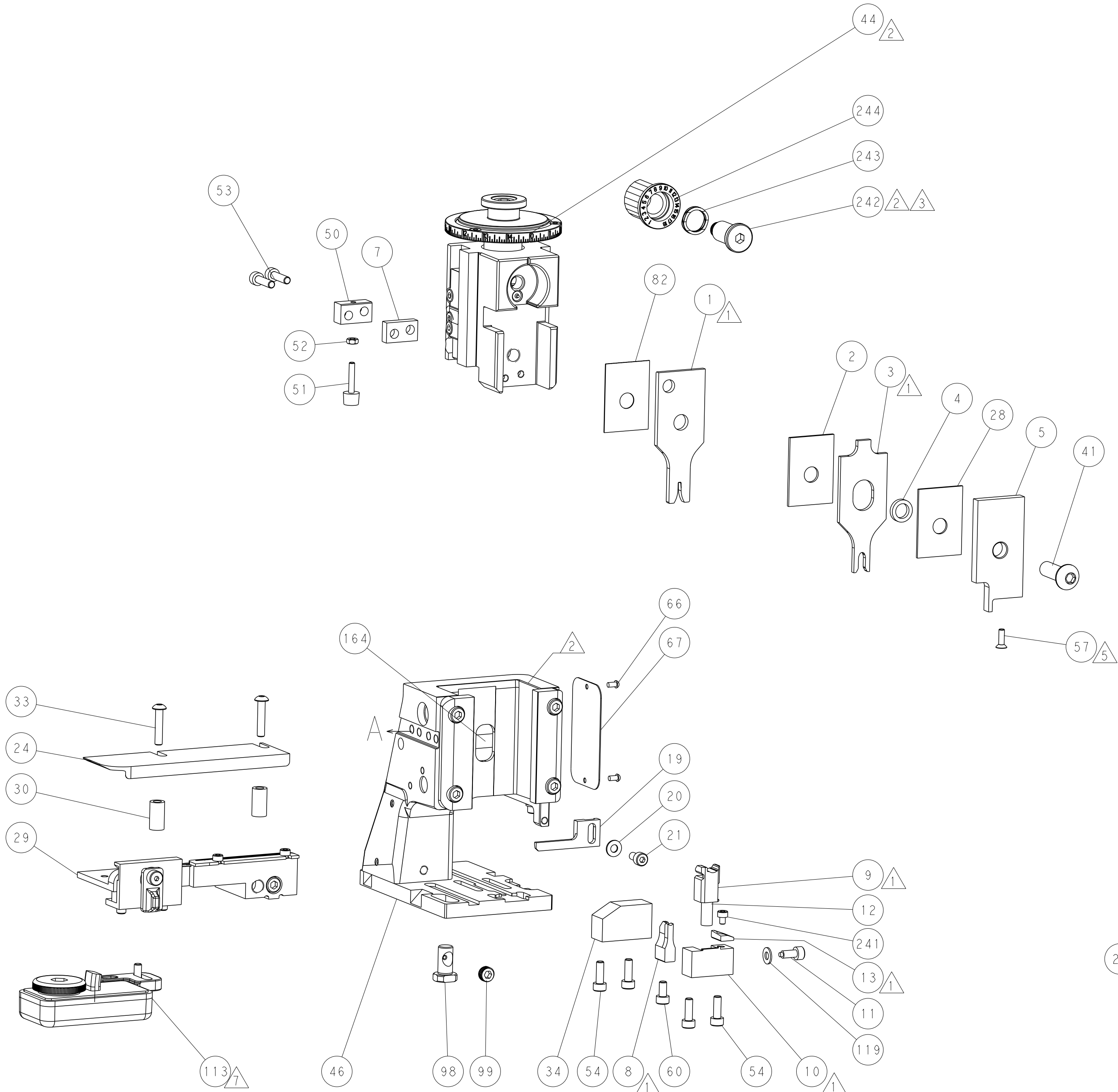
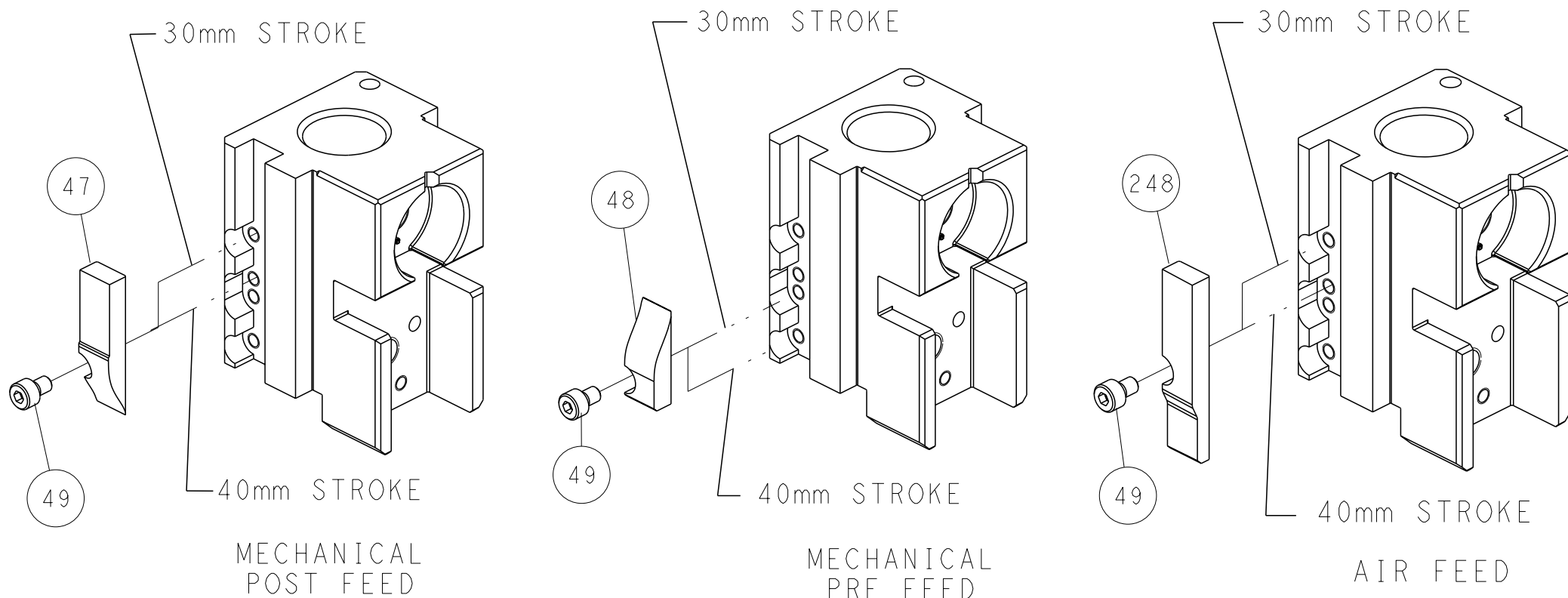


DETAIL A

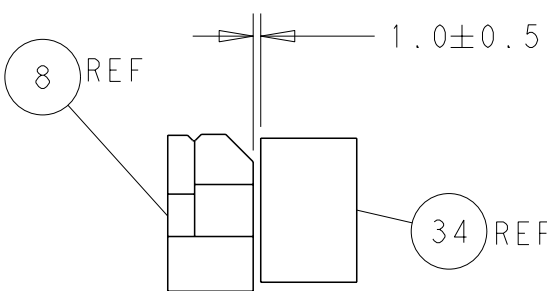
DOUBLE ACTING PNEUMATIC WITH SENSORS



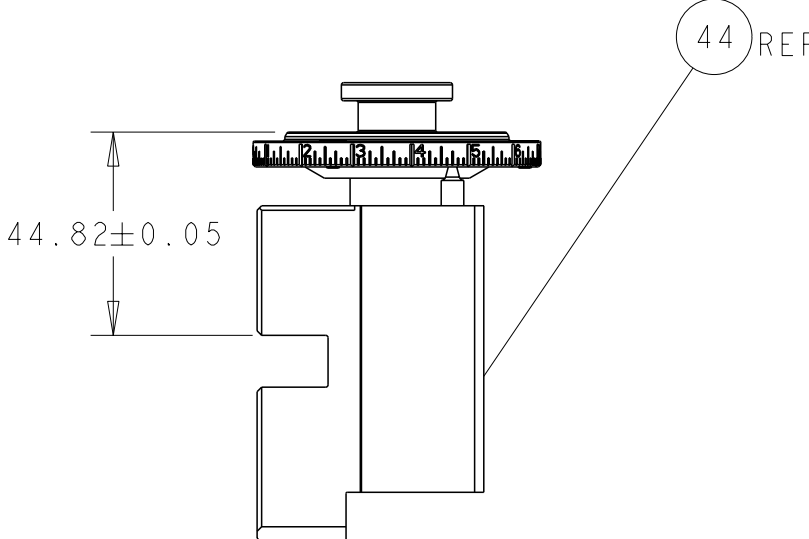
CAM POSITIONS



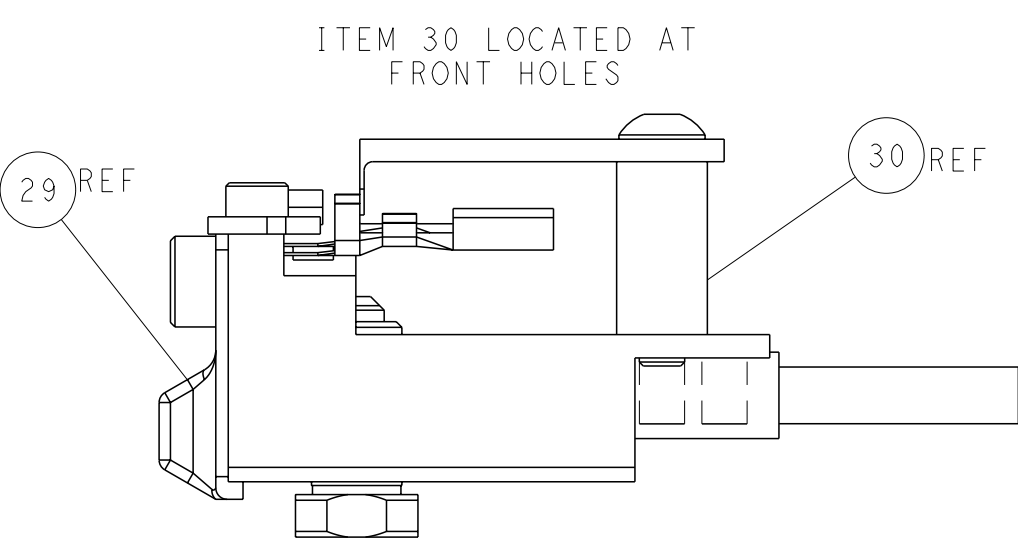
SHEAR DEPRESSOR DETAIL



TERMINAL SUPPORT LOCATION




RAM SET-UP



FEED TRACK POSITION
GUIDE BY INSULATION BARREL

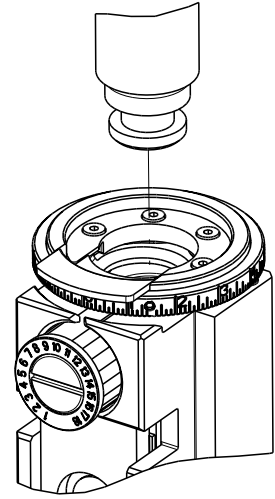
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

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	Y. YIN	14MAR2013	 TE Connectivity Harrisburg, PA 17105-3608	Ocean Side Feed Applicator		
				CHK	G. BAILEY	14MAR2013				
				APVD	U. GUO	14MAR2013				
				PRODUCT SPEC						
DIMENSIONS:				TOLERANCES UNLESS OTHERWISE SPECIFIED:			NAME		SIZE	
mm				0 PLC ±			APPLICATION SPEC		CAGE CODE	
				1 PLC ±					DRAWING NO	
				2 PLC ±					RESTRICTED TO	
				3 PLC ±						
				4 PLC ±						
				ANGLES						
FINISH				-			WEIGHT		A 00779 C=215159	
MATERIAL				-						
							Customer Accessible Production Drawing		SCALE 1:2 SHEET 2 of 4 REV E2	

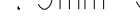

SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

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20		20	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2151519-1	D	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2151519-2	E	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
4-2151519-2	E	FINE CRIMP HEIGHT ADJUST	DOUBLE ACTING PNEUMATIC WITH SENSORS 8
7-2151519-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.57 mm [.062]	F
INSUL	3.30 mm [.130]	O
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: HPF 1.5mm SENSORCONTACT ASSEMBLY AND BODY			
WIRE STRIP LENGTH 4.20-4.60 mm [.165-.181 IN]			INSULATION DIAMETER RANGE Ø 1.40-1.90 mm [.055-.075 IN]
TERMINAL APPLICATION SPECIFICATION 		114-18912	- -
		-	-

TERMINALS APPLIED 4				SEAL INSULATION DIAMETER RANGE
TE TERMINAL	TE TERMINAL	TE SEAL	TE SEAL	
1563623-2	2325198-3	9-963530-1	963530-1	
2292290-1		9-964971-1	964971-1	
2208362-3		967067-1		

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING 4
0.50mm2		0.99+/-0.03 [.039+/-0.001]		8.5



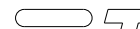

- 1 RECOMMENDED SPARE PARTS
- 2 REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- 3 APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242.
- 4 CRIMP HEIGHT REFERENCE SETTING WAS THE SETTING USED WHEN THE APPLICATOR WAS QUALIFIED AT THE FACTORY. ADJUSTMENT MAY BE NECESSARY WHEN RUNNING APPLICATOR IN THE FIELD.
- 5 APPLY 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.
6. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- 7 TERMINAL LUBRICANT IS RECOMMENDED.
- 8 THIS APPLICATOR IS EQUIPPED WITH THE DOUBLE ACTING FEED WITH SENSORS AND IS APPLICATION SPECIFIC. IT DOES NOT REQUIRE ITEMS 49 & 151.

*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	-	-	-

3	-	1	-	-	2844950-1	AIR FEED MODULE	290
	-	1	1	1	2119082-7	CAM, SNAIL, INSULATION ADJUSTMENT	244
	-	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
8	-	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
7	-	-	1	-	2844940-1	AIR FEED MODULE	238
	-	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
	-	-	1	-	2119641-2	FEED CAM, AIR FEED	151
8	-	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
7	-	1	1	1	1-1803583-0	APPLICATOR BASIC ASSEMBLY, SF	141
	-	1	1	1	1803516-1	RAM ASSEMBLY, SF PACIFIC	140
	-	1	1	1	1-18028-2	WASHER, FLAT, REG M4	119
8	-	1	1	1	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113
	-	1	1	1	2844908-1	SCREW, LOCKING	99
	-	1	1	1	2844907-1	POST, LOCKING	98
5	-	1	1	1	455888-4	SPACER, CRIMPER	82
	-	1	1	1	1803607-3	DOCUMENTATION PACKAGE	71
	-	1	1	1	2119740-1	TAG,IDENTIFICATION	67
8	-	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
7	-	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
8	-	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
7	-	-	-	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
8	-	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
	-	2	2	2	3-2844962-0	SPACER, CYLINDRICAL, STRIP GUIDE	30
	-	1	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29
7	-	1	1	1	1-455888-0	SPACER, CRIMPER	28
	-	1	1	1	1320928-2	STRIP GUIDE	24
	-	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
8	-	1	1	1	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
7	-	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
8	-	1	1	1	318707-1	FLOATING SHEAR, FRONT	9
	1	1	1	1	1333332-2	ANVIL, COMBINATION, SPECIAL	8
	-	1	1	1	2-240641-9	SPACER	7
7	-	-	-	-	-	-	6
	-	1	1	1	2119781-1	DEPRESSOR, SHEAR	5
	-	1	1	1	238011-4	BLOCK, CRIMPER SPACER	4
8	1	1	1	1	2-1633996-7	CRIMPER, INSULATION SPECIAL	3
	-	1	1	1	1-455888-3	SPACER, CRIMPER	2
	1	1	1	1	1-456403-5	CRIMPER, WIRE PREMIUM	1
-77 -42 -22 -21		PART NO					ITEM NO
		DESCRIPTION					

THIS DRAWING IS A CONTROLLED DOCUMENT FOR TEO ELECTRONICS CORPORATION IT IS SUBJECT TO CHANGE AND TO BE USED ONLY FOR THE SPECIFIED APPLICATION. SHOULD BE CONTACTED FOR THE LATEST REVISION.				DWN Y. YIN 14MAR2013	 TE Connectivity Harrisburg, PA 17105-3608			
DIMENSIONS: mm				CHK G. BAILEY 14MAR2013				
				APVD U. GUO 14MAR2013	NAME Ocean Side Feed Applicator			
TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±				PRODUCT SPEC - APPLICATION SPEC -	SIZE A1			
MATERIAL -				WEIGHT -	CAGE CODE 00779			
				FINISH -	DRAWING NO C-2151519			
				RESTRICTED TO -				
				Customer Accessible Production Drawing				
				SCALE 1:2				
				SHEET 3				
				OF 4				
				REV E2				

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

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

D

C

B

A

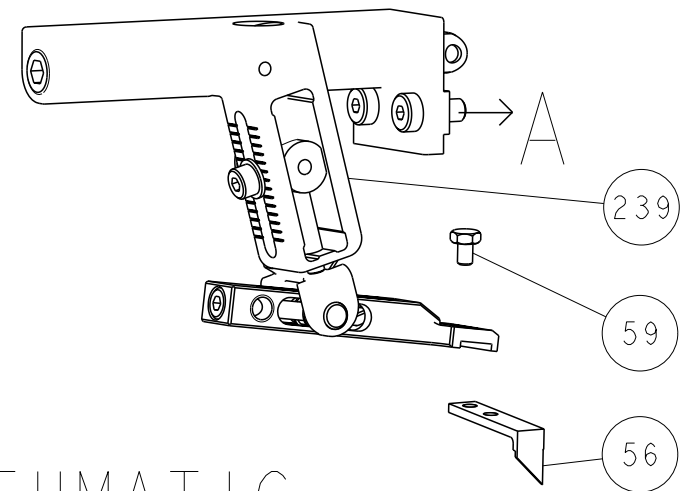
D

C

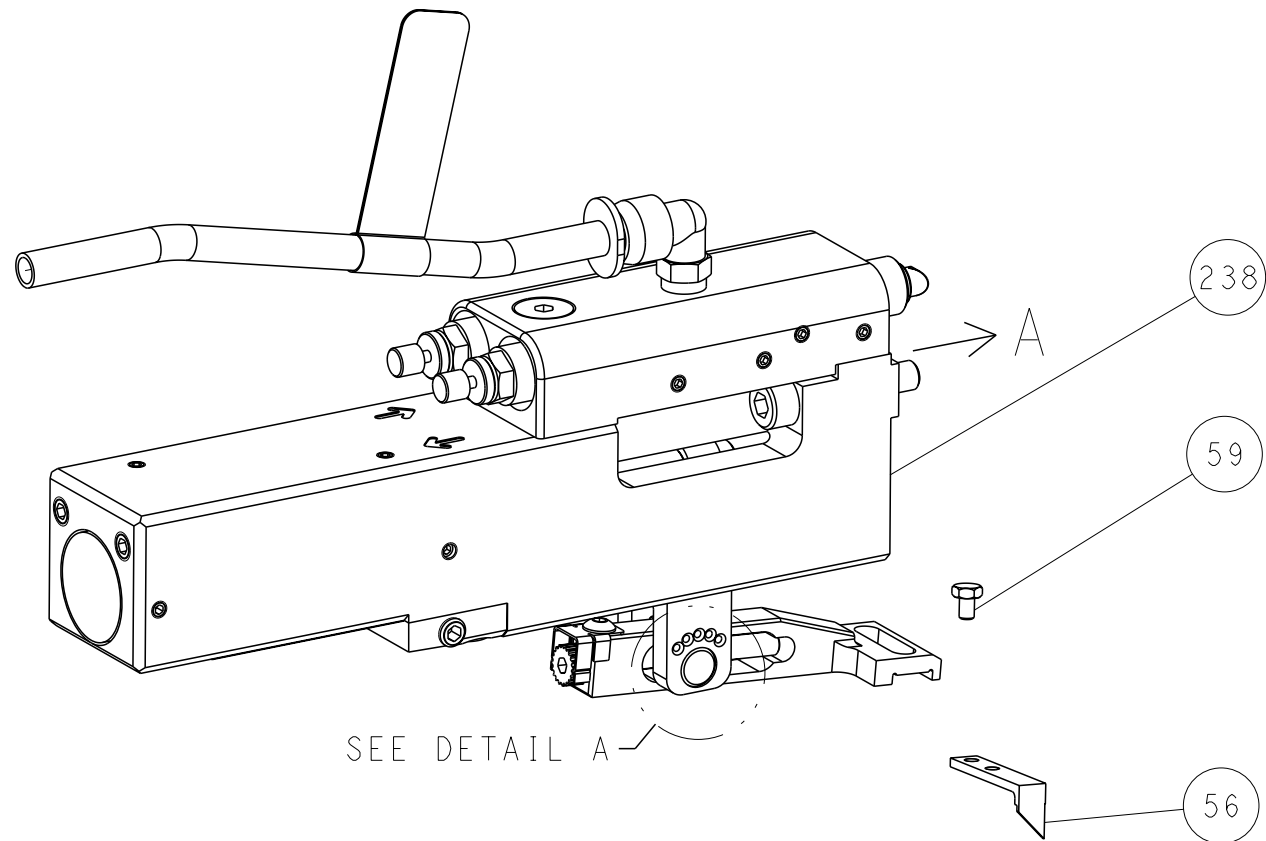
B

A

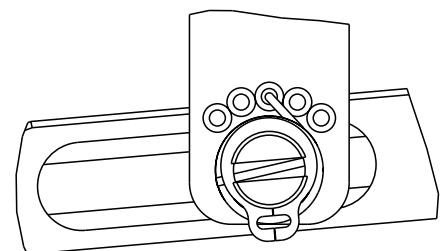
FEED TYPE MECHANICAL



PNEUMATIC

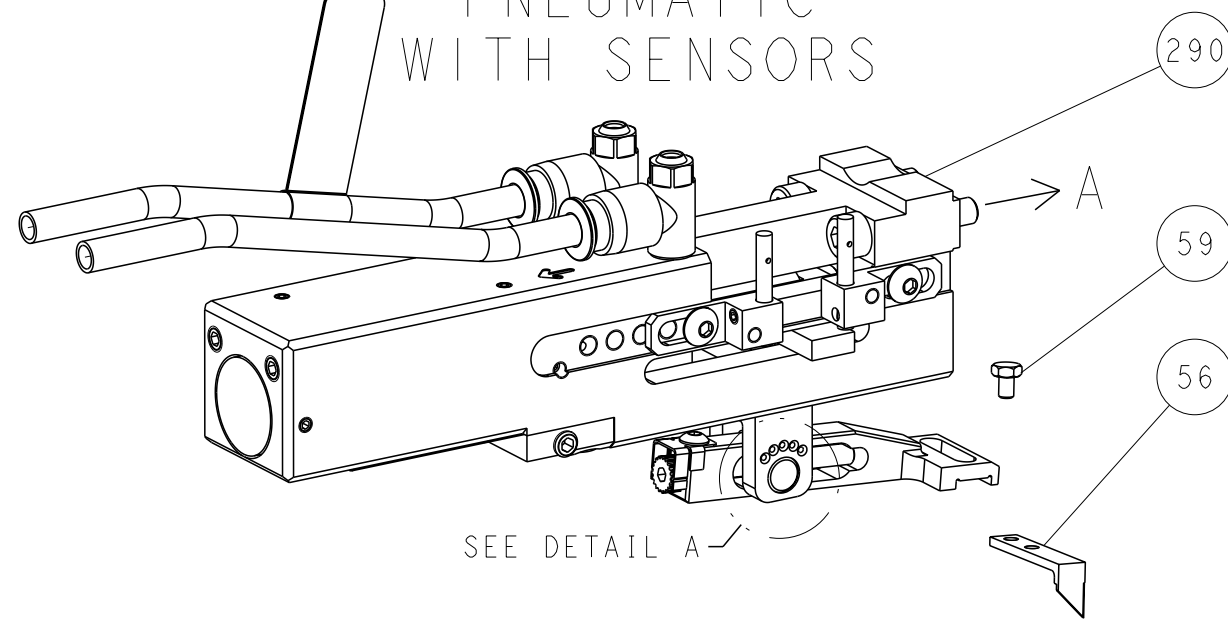


FEED SPRING SETTING POSITION
(SHOWN FROM REAR SIDE)



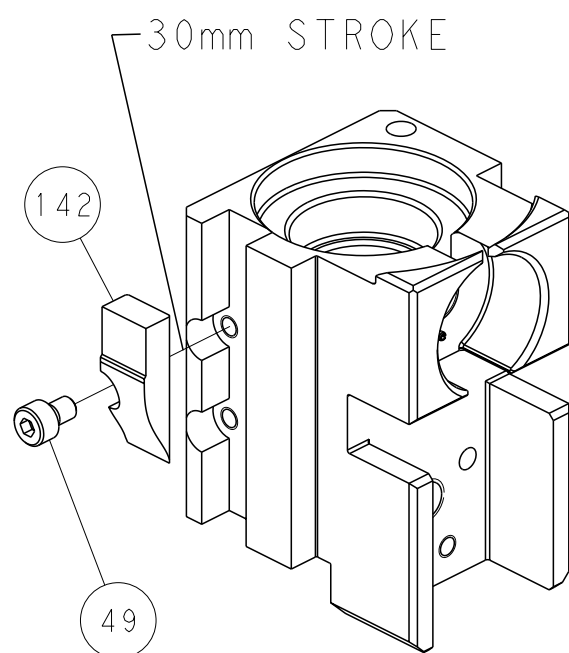
DETAIL A

DOUBLE ACTING PNEUMATIC WITH SENSORS

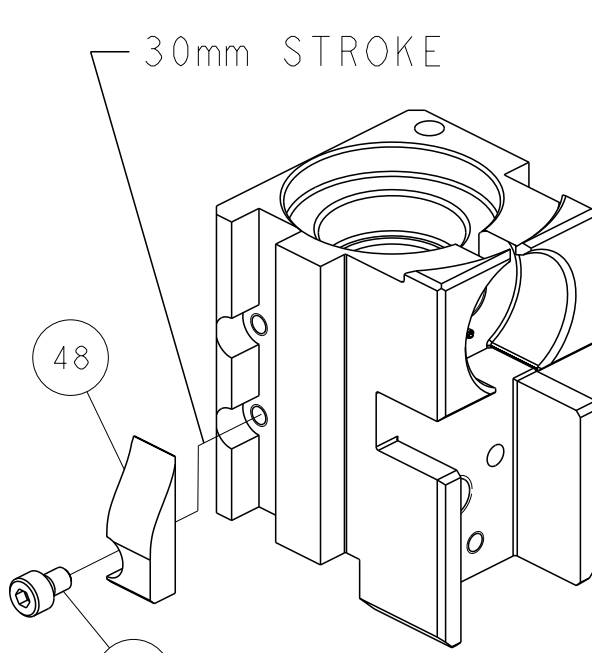


SEE DETAIL A

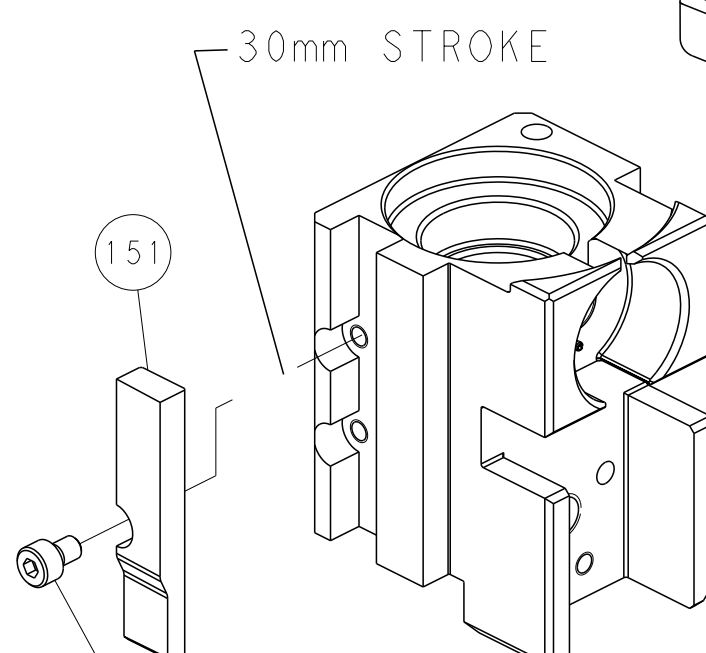
CAM POSITIONS



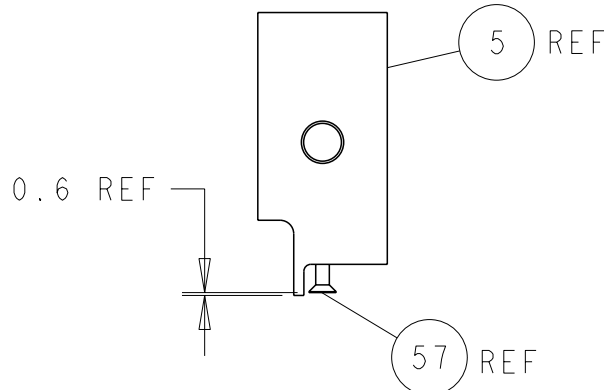
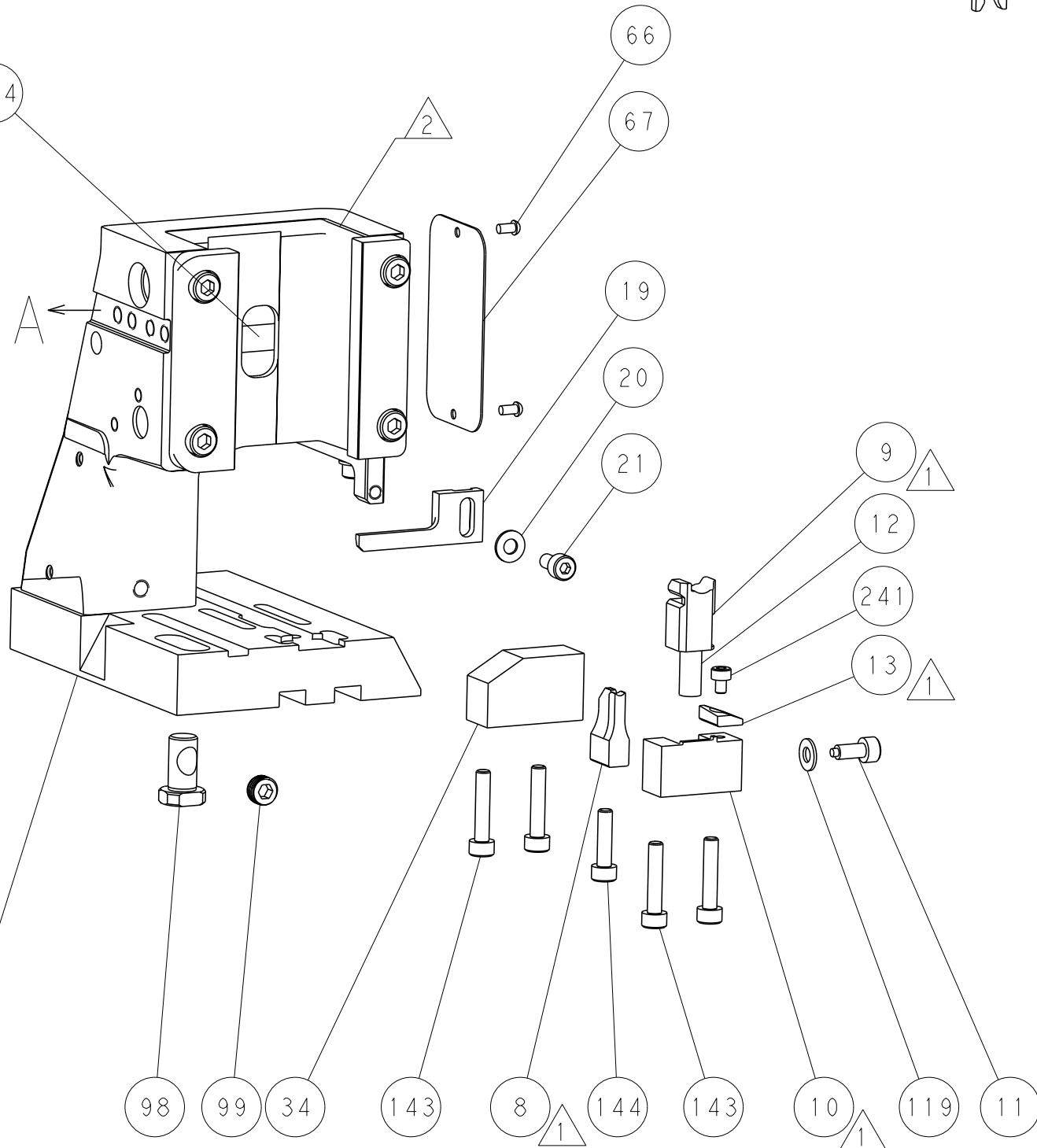
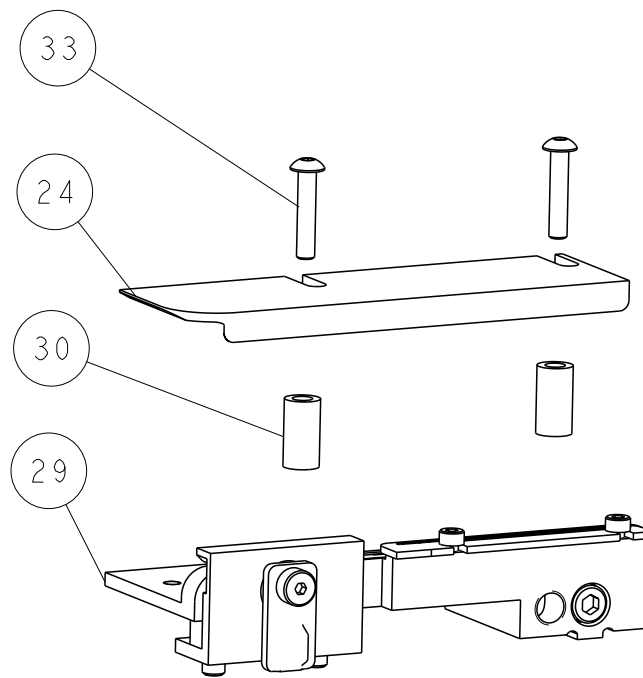
MECHANICAL
POST FEED



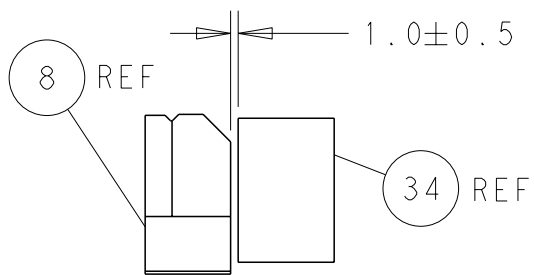
MECHANICAL
PRE FEED



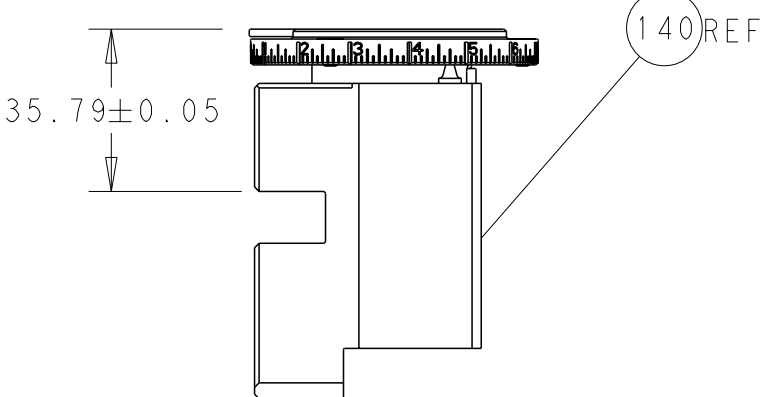
AIR FEED



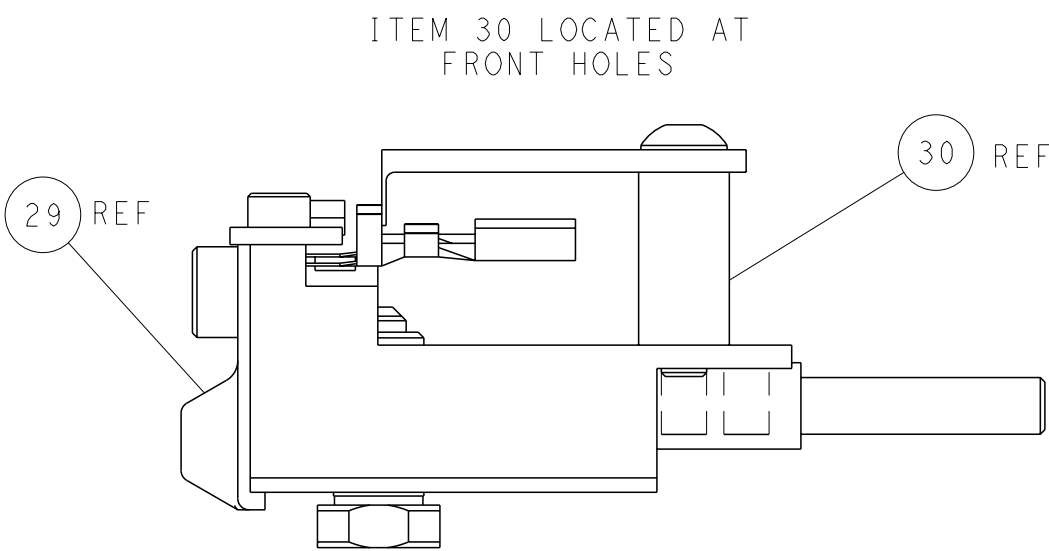
SHEAR DEPRESSOR DETAIL



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)

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				CHK	G. BAILEY	14MAR2013			
				APVD	U. GUO	14MAR2013	NAME		
				PRODUCT SPEC			Ocean Side Feed Applicator		
				APPLICATION SPEC			-		
				WEIGHT			SIZE		
				-			A1 00779 C=2151519		
				Customer Accessible Production Drawing			SCALE		
				1:2			SHEET 4 OF 4		
							REV E2		

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

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