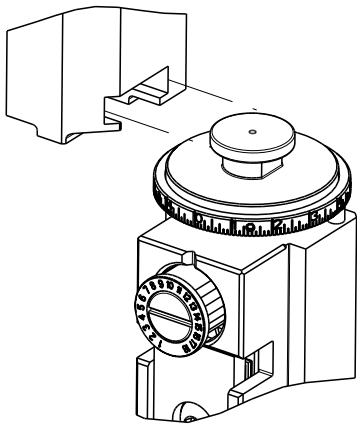
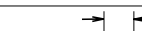


8		7	
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20		20	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151655-1	H	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2151655-2	H	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151655-1	H	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2151655-2	H	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2151655-7	D	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.27 mm [.050]	F
INSUL	-	-
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: ROSENBERGER TERMINAL		ROSENBERGER CRIMP SPECIFICATION	
TERMINAL NAME: CENTER CONTACT			
WIRE STRIP LENGTH 2.80-3.20 mm [.110-.126 IN]			INSULATION DIAMETER RANGE Ø -
TERMINAL APPLICATION SPECIFICATION (A)ROSENBERGER MA-59V046 Rev d00		-	-
TERMINAL APPLICATION SPECIFICATION (B)ROSENBERGER MA-59V058 Rev w00		-	-
TERMINALS APPLIED 			
TE TERMINAL (A) 1-2177286-2	ROSENBERGER TERMINAL (A) 59K13D-1M4/20E	TE TERMINAL (B) 2113703-1	ROSENBERGER TERMINAL (B) 59S10L-1M4/20E

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
RTK031	0.99+/-0.03 [.039+/- .001]	8.0



- 1 RECOMMENDED SPARE PARTS
- 2 REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- 3 APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 50.
- 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.

*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)

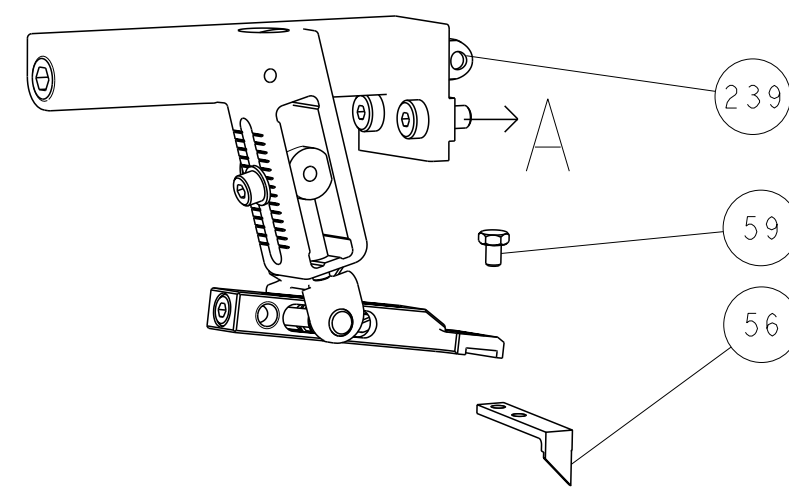
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LOC	DIST	REVISIONS							
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		G		ECR-19-014655			19SEP2019	MZ	KR
		H		ECR-20-004401			25MAR2020	JWC	GB
		H1		ECR-20-012866			10SEP2020	JWC	GB

-	2	2	2	2	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	294
-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248
-	-	1	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	1	-	1	-	2844940-1	AIR FEED MODULE	238
-	1	1	1	1	993111-1	PIN, SLOTTED SPRING 3.0 X 20.0	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	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	455888-7	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
-	2	2	2	2	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	1901681-1	HOLDDOWN, TERMINAL	51
-	1	1	1	1	1-1752354-1	STANDOFF,HOLD-DOWN	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	1803515-3	RAM ASSEMBLY, SF ATLANTIC	44
-	1	1	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
-	1	1	1	1	1-1752356-9	SUPPORT, TERMINAL	34
-	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	2	2	2-2844962-3	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	2119533-2	STRIPPER, SIDE FEED	19
-	1	1	1	1	3-22280-3	SPRING, COMPRESSION	12
-	1	1	1	1	356885-5	STOP, SHEAR	11
-	1	1	1	1	1552193-1	HOLDER, SHEAR	10
-	1	1	1	1	1338293-4	SHEAR, FLOATING	9
1	2	2	1	1	6-1633933-3	ANVIL, COMBINATION	8
-	-	-	-	-	-	-	7
-	-	-	-	-	-	-	6
-	1	1	1	1	1-2119757-6	DEPRESSOR, SHEAR	5
-	-	-	-	-	-	-	4
-	-	-	-	-	-	-	3
-	-	-	-	-	-	-	2
1	2	2	1	1	4-1633738-3	CRIMPER, WIRE	1
-77-72-71	-2	-1	PART NO		DESCRIPTION		ITEM NO

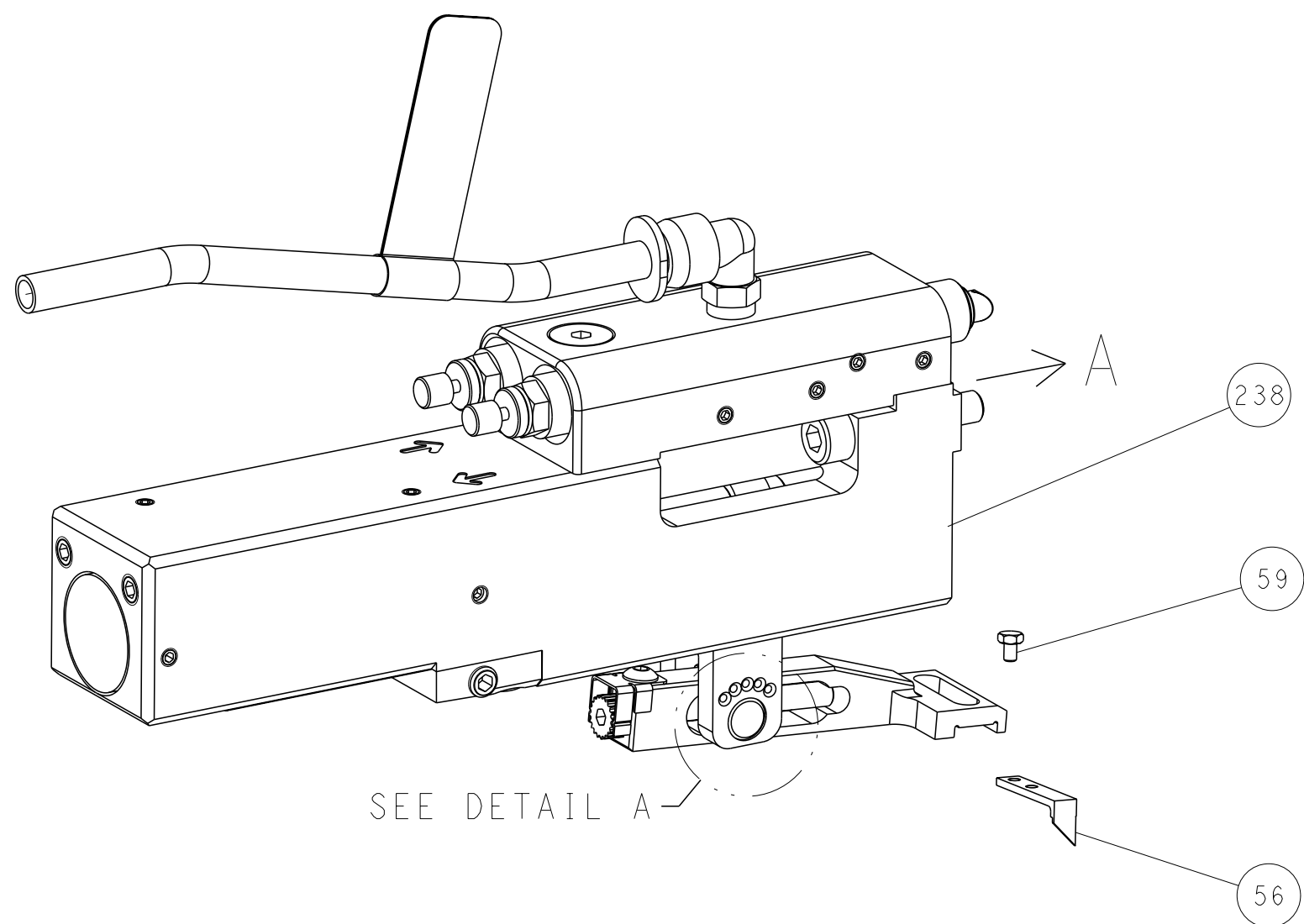
THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE AND TO BE OBSOLETE WITHOUT NOTICE. FOR THE LATEST REVISION, CONTACT THE ENGINEERING ORGANIZATION.				DWN R. STAKEM 07MAY2012	TE Connectivity Harrisburg, PA 17105-3608		
DIMENSIONS: mm				CHK G. BAILEY 07MAY2012			
TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±				APVD T. ELBIN 07MAY2012	NAME Ocean Side Feed Applicator		
MATERIAL -				PRODUCT SPEC -	SIZE A1		
FINISH -				APPLICATION SPEC -	CAGE CODE 00779		
WEIGHT -				RESTRICTED TO -	DRAWING NO 2151655		
Customer Accessible Production Drawing				SCALE 1:2	SHEET 1	OF 4	REV H1

SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

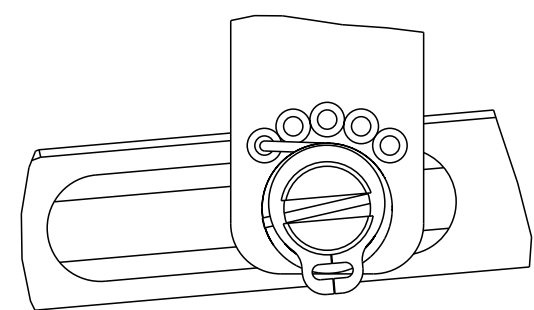
FEED TYPE MECHANICAL



PNEUMATIC

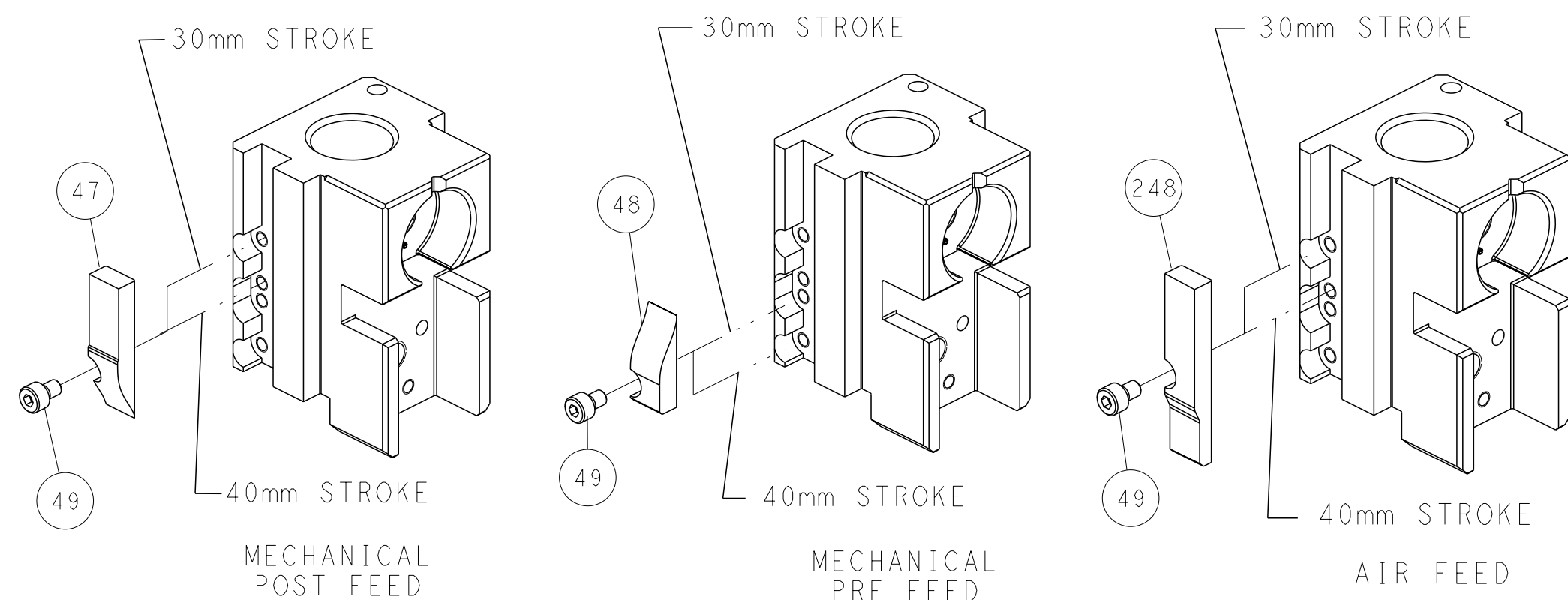


FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)

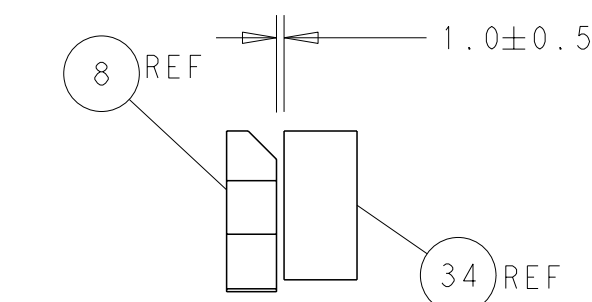


DETAIL A

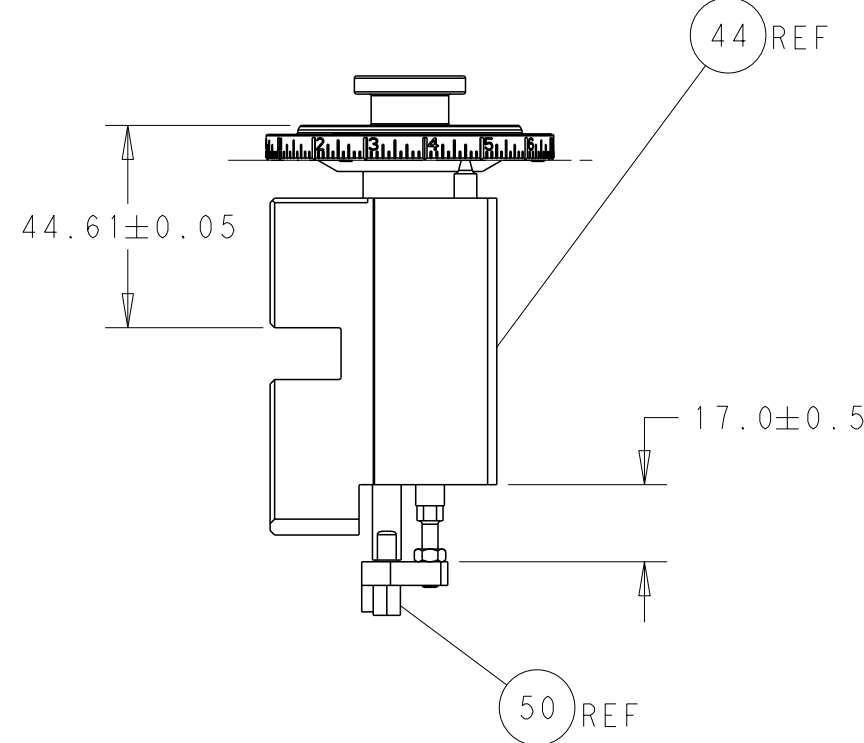
CAM POSITIONS



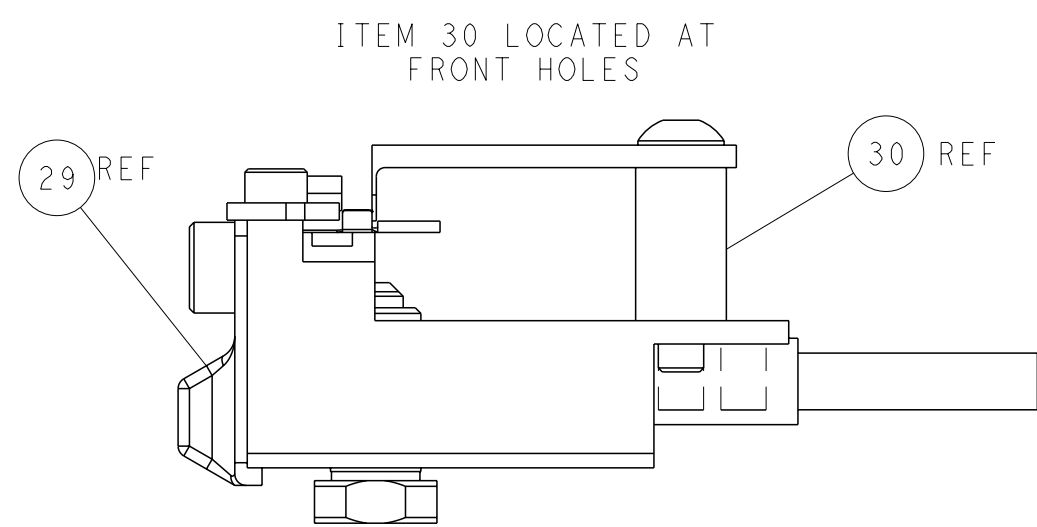
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)



TERMINAL SUPPORT LOCATION



RAM AND HOLDDOWN SET-UP

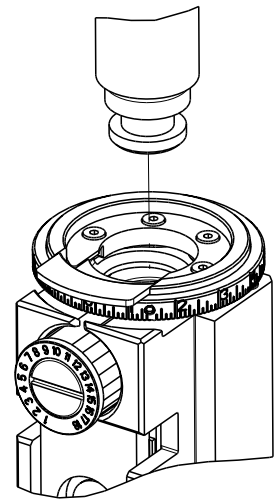


FEED TRACK POSITION
GUIDE BY WIRE BARREL

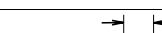
THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE AND TO THE CONTROL AND ENGINEERING ORGANIZATION. SHOULD BE CONTACTED FOR THE LATEST REVISION.		OWN K. STAKEM 07MAY2012	NAME Ocean Side Feed Applicator	RESTRICTED TO -
DIMENSIONS: mm		CHK G. BAILEY 07MAY2012	SIZE A1	CAGE CODE 00779
TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH ±		APVD T. ELBIN 07MAY2012	DRAWING NO C=2151655	REV H1
MATERIAL -		PRODUCT SPEC -	SCALE 1:2	SHEET 2 of 4
Customer Accessible Production Drawing		WEIGHT -	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
2-2151655-1	H	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2151655-2	H	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151655-7	D	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.27 mm [.050]	F
INSUL	-	-
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: ROSENBERGER TERMINAL		ROSENBERGER CRIMP SPECIFICATION	
TERMINAL NAME: CENTER CONTACT			
WIRE STRIP LENGTH 2.80-3.20 mm [.110-.126 IN]			INSULATION DIAMETER RANGE Ø -
TERMINAL APPLICATION SPECIFICATION (A)ROSENBERGER MA_59V046 Rev d00		-	-
TERMINAL APPLICATION SPECIFICATION (B)ROSENBERGER MA_59V058 Rev w00		-	-
TERMINALS APPLIED 			
TE TERMINAL (A) 1-2177286-2	ROSENBERGER TERMINAL (A) 59K13D-1M4/20E	TE TERMINAL (B) 2113703-1	ROSENBERGER TERMINAL (B) 59S10L-1M4/20E

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
RTK031	0.99+/-0.03 [.039+/- .001]	8.0



- 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 50.
- 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.

***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	-	-	-	

-	2	2	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	295
-	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	1	-	2844940-1	AIR FEED MODULE	238
-	1	1	993111-1	PIN, SLOTTED SPRING 3.0 X 20.0	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
-	2	2	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	455888-7	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	1901681-1	HOLDDOWN, TERMINAL	51
-	1	1	1-1752354-1	STANDOFF,HOLD-DOWN	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	1-1752356-9	SUPPORT, TERMINAL	34
-	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	2-2844962-3	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	2119533-2	STRIPPER, SIDE FEED	19
-	1	1	3-22280-3	SPRING, COMPRESSION	12
-	1	1	356885-5	STOP, SHEAR	11
-	1	1	1552193-1	HOLDER, SHEAR	10
-	1	1	1338293-4	SHEAR, FLOATING	9
1	1	1	6-1633933-3	ANVIL, COMBINATION	8
-	-	-	-	-	7
-	-	-	-	-	6
-	1	1	1-2119757-6	DEPRESSOR, SHEAR	5
-	-	-	-	-	4
-	-	-	-	-	3
-	-	-	-	-	2
1	1	1	4-1633738-3	CRIMPER, WIRE	1
-77	-22	-21	PART NO	DESCRIPTION	ITEM NO

THIS DRAWING IS CONTROLLED DOCUMENT FOR THE ELECTRONIC INDUSTRY. IT IS SUBJECT TO CHANGE AND TO BE USED IN CONFORMANCE WITH THE LATEST REVISION. SHOULD BE CONTACTED FOR THE LATEST REVISION.		DWN R. STAKEM 07MAY2012	TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm		CHK G. BAILEY 07MAY2012	NAME Ocean Side Feed Applicator	
TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		APVD T. ELBIN 07MAY2012	PRODUCT SPEC	
MATERIAL		APPLICATION SPEC		SIZE A1
FINISH		WEIGHT		CAGE CODE 00779
Customer Accessible Production Drawing		SCALE 1:2		DRAWING NO 2151655
SHEET 3 OF 4		REV H1		RESTRICTED TO

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

[illegible]

DETAIL A

30mm STROKE

142

49

MECHANICAL POST FEED

30mm STROKE

48

49

MECHANICAL PRE FEED

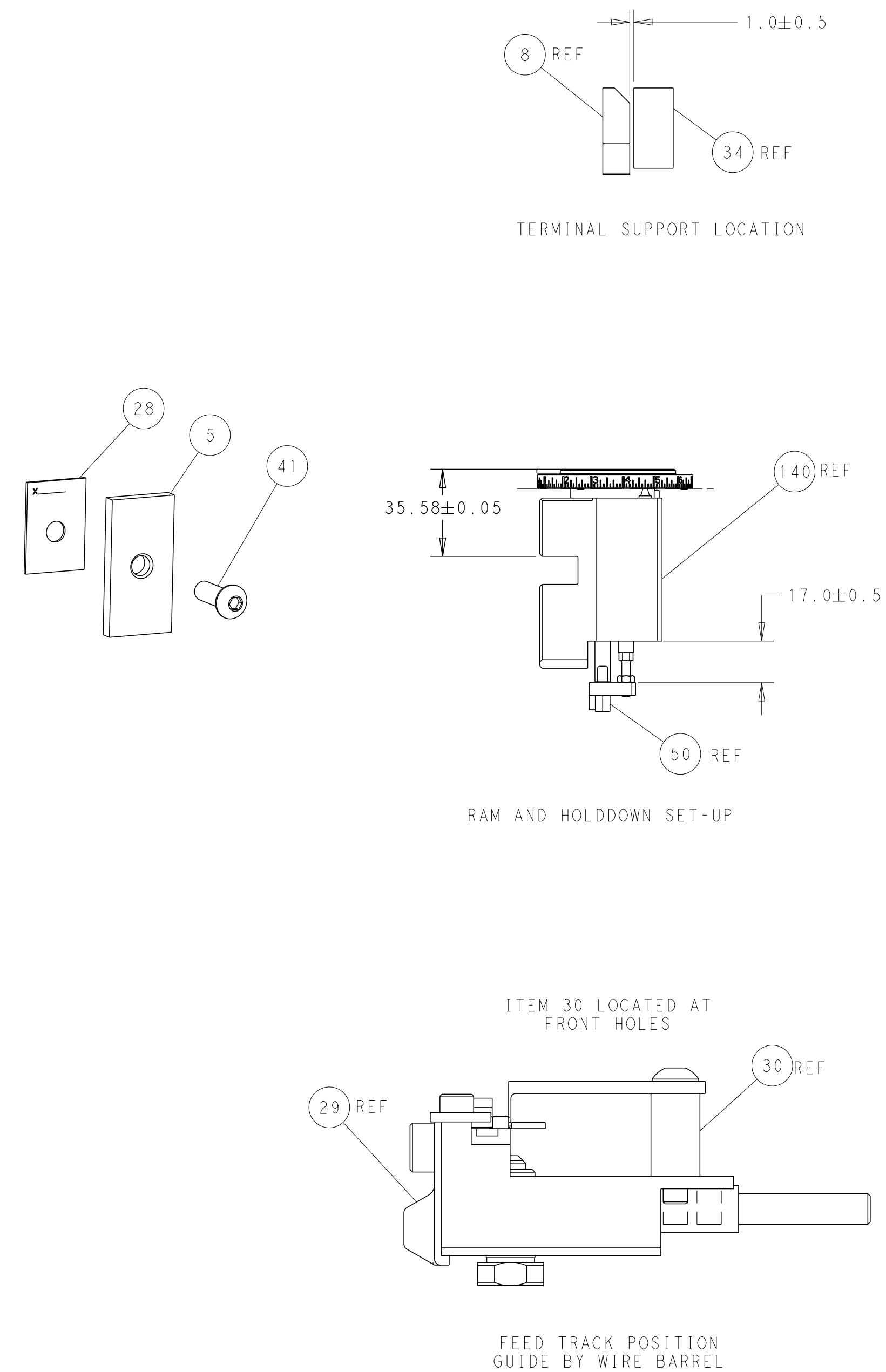
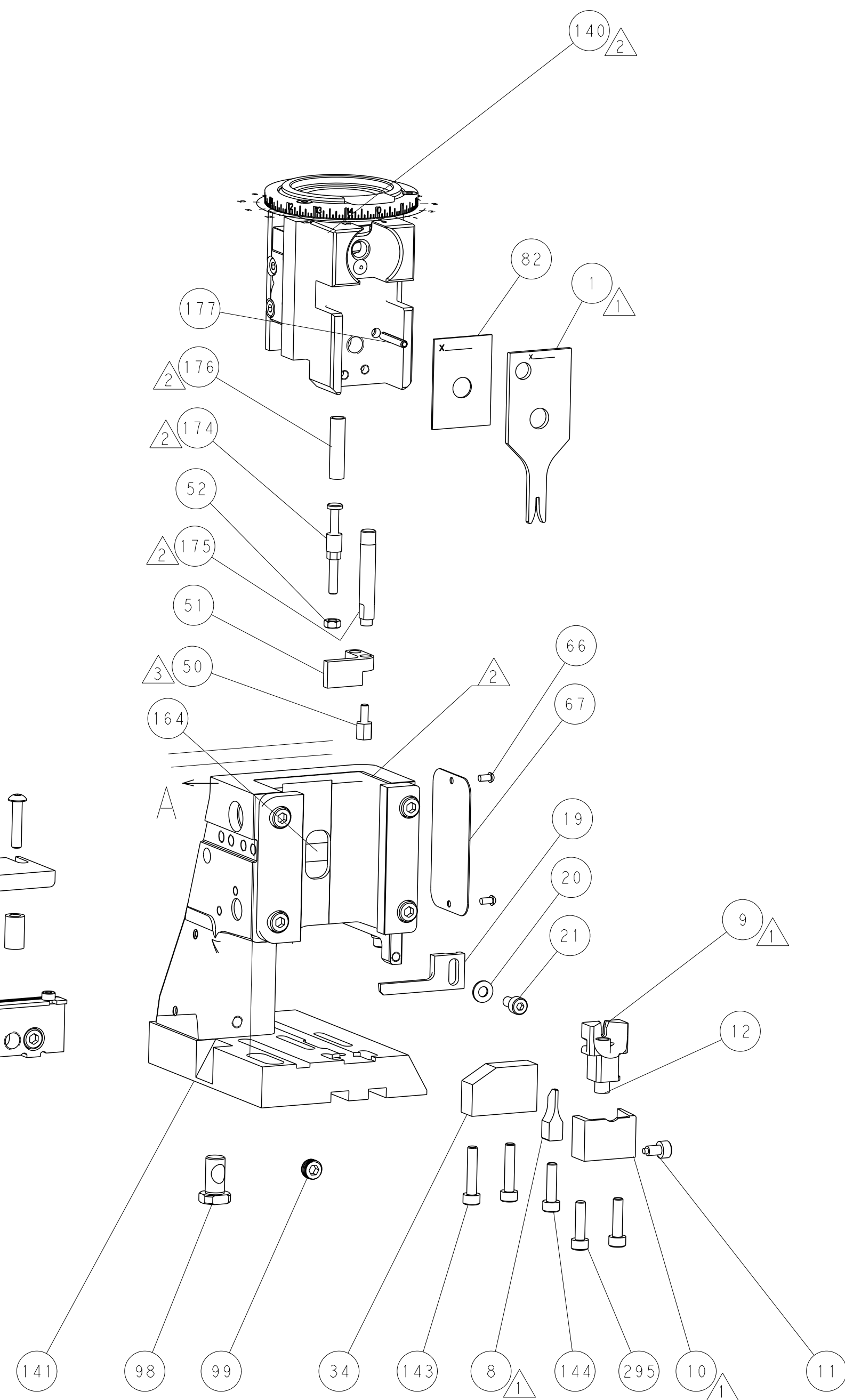
FRONT COVER

30mm STROKE

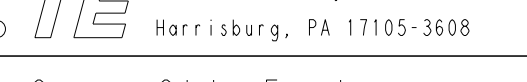
113

49

AIR FEED



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 07MAY2012			
DIMENSIONS:						TOLERANCES UNLESS OTHERWISE SPECIFIED:		NAME	
mm						APVD T. ELBRIN 07MAY2012			
						PRODUCT SPEC			
						-			
						APPLICATION SPEC			
MATERIAL						WEIGHT		RESTRICTED TO	
-						-		-	
						SIZE		CAGE CODE	DRAWING NO
						A 		00779	C=2151655
Customer Accessible Production Drawing						SCALE		1:2	SHEET 4 OF 4 REV H

Mouser Electronics

Authorized Distributor

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[TE Connectivity:](#)

[2151655-2](#)