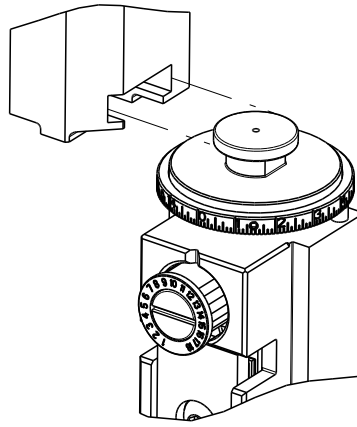
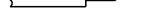


8		7	
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20		20	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151740-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2151740-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151740-1	B	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2151740-2	B	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2151740-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.40 mm [.055]	F
INSUL	1.78 mm [.070]	O
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: REC CONTACT ASSY S RANGE CLEAN BODY 025 CONNECTOR			
WIRE STRIP LENGTH			INSULATION DIAMETER RANGE
4.50-5.00 mm [.177-.197 IN]			Ø1.10-1.70 mm [.043-.067 IN]
TERMINAL APPLICATION SPECIFICATION		114-5278	-
		-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
1717148-1			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.50mm2	0.88+/-0.03 [.035+/- .001]	7.8
0.30mm2	0.79+/-0.03 [.031+/- .001]	8.8



- 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.

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

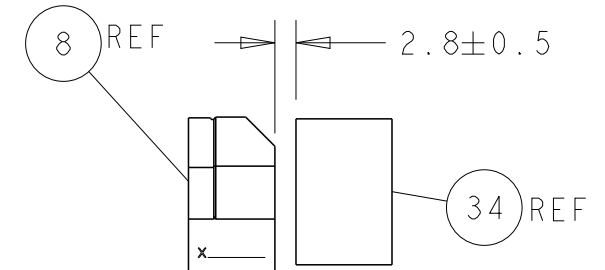
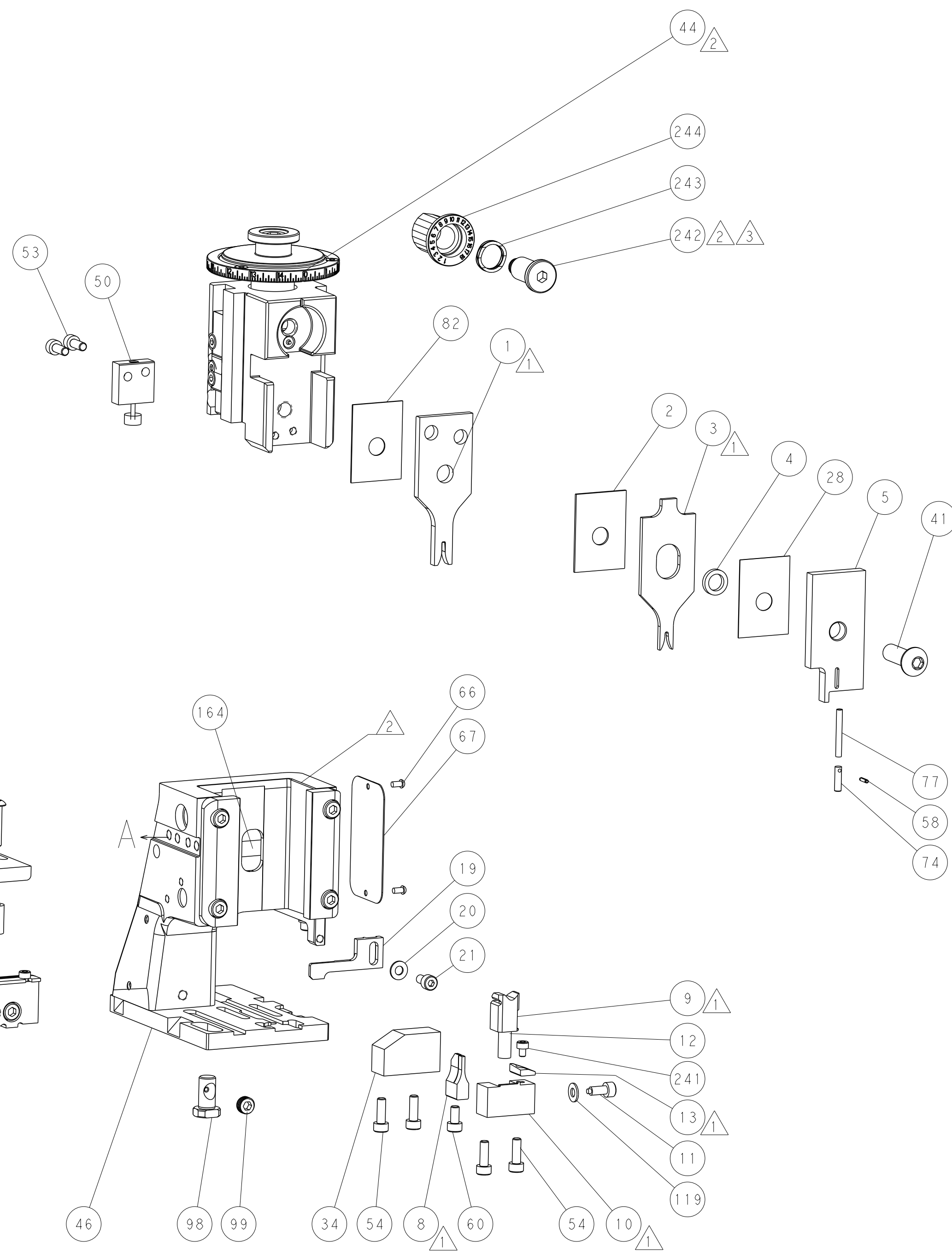
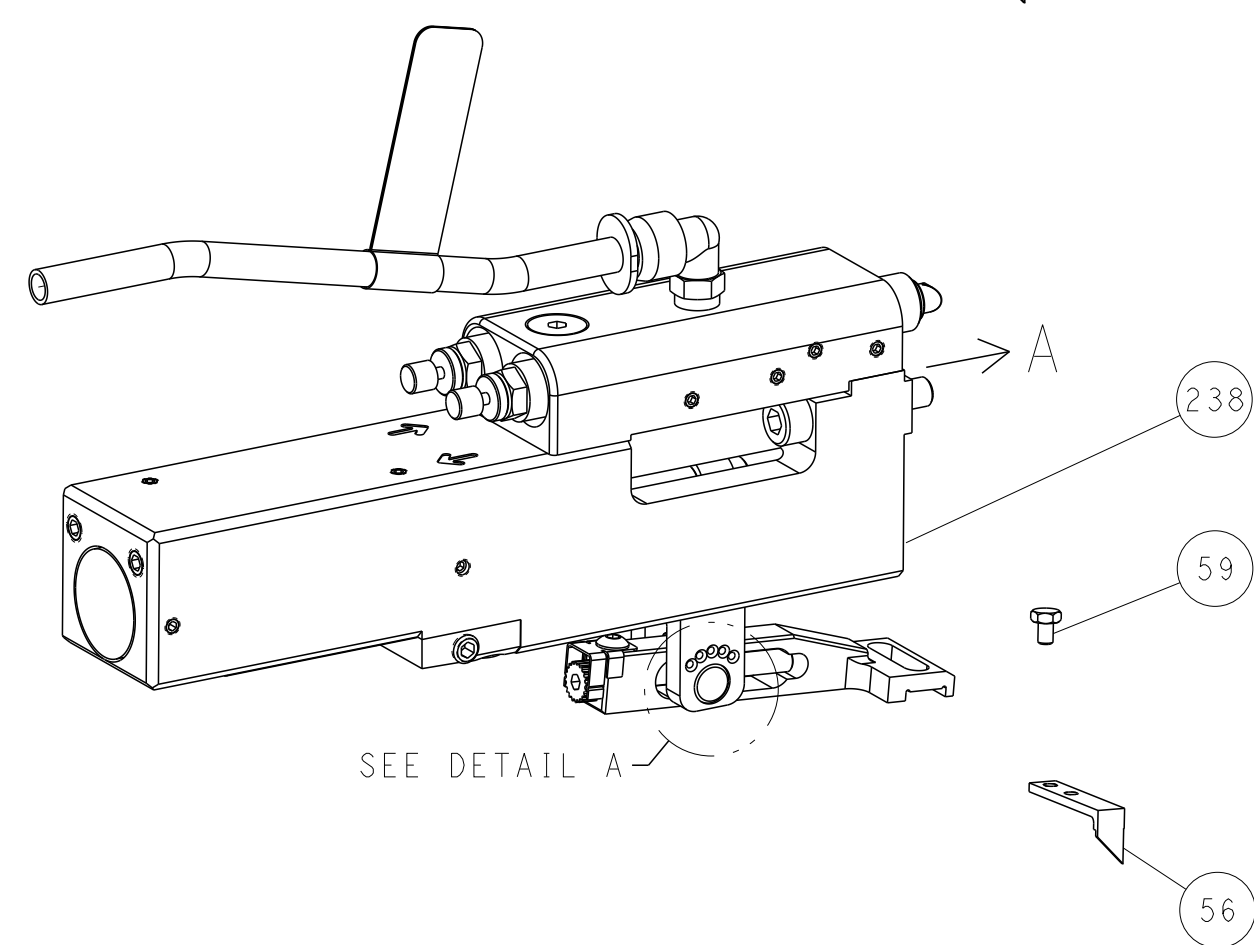
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		A		RELEASED	25OCT2012	YY	SX
		B		ECR-20-001690	05FEB2020	TB	RK

	-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248
	-	1	1	1	1	2119082-6	CAM, SNAIL, INSULATION ADJUSTMENT	244
	-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
3	-	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	119
	-	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	5-547505-2	SPRING, COMPRESSION	77
	-	1	1	1	1	854769-4	HOLDER, INS	74
	-	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	21028-2	PIN, SLOTTED SPRING .062 X .250	58
	-	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	1752356-3	SUPPORT, TERMINAL	34
	-	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
	-	2	2	2	2	2-2844962-4	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
	-	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	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	5-1333201-5	ANVIL, COMBINATION	8
	-	-	-	-	-	-	-	7
	-	-	-	-	-	-	-	6
	-	1	1	1	1	2119780-9	DEPRESSOR, SHEAR	5
	-	1	1	1	1	1-238011-0	BLOCK, CRIMPER SPACER	4
1	1	2	2	1	1	6-2119784-8	CRIMPER, INSULATION O PREMIUM	3
	-	1	1	1	1	455888-9	SPACER, CRIMPER	2
1	1	2	2	1	1	1276940-5	CRIMPER, SPECIAL	1
	-77	-72	-71	-2	-1	PART NO	DESCRIPTION	ITEM NO

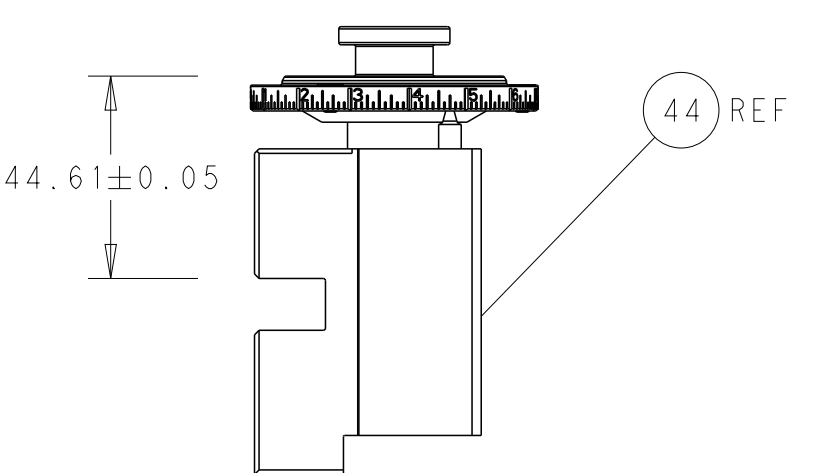
THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. THE USER SHALL BE RESPONSIBLE FOR OBTAINING THE LATEST EDITION.				DWN Y. YIN	20AUG2012	TE Connectivity Harrisburg, PA 17105-3608	
CHK G. BAILEY				APVD S. XI	20AUG2012	NAME Ocean Side Feed Applicator	
DIMENSIONS: mm				TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.01 1 PLC ±.01 2 PLC ±.01 3 PLC ±.01 4 PLC ±.01 ANGLES ±.01 FINISH		PRODUCT SPEC APPLICATION SPEC	
MATERIAL -				WEIGHT -		SIZE A	
Customer Accessible Production Drawing				SCALE 1:2		SHEET 1 OF 4	
						REV B	

SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

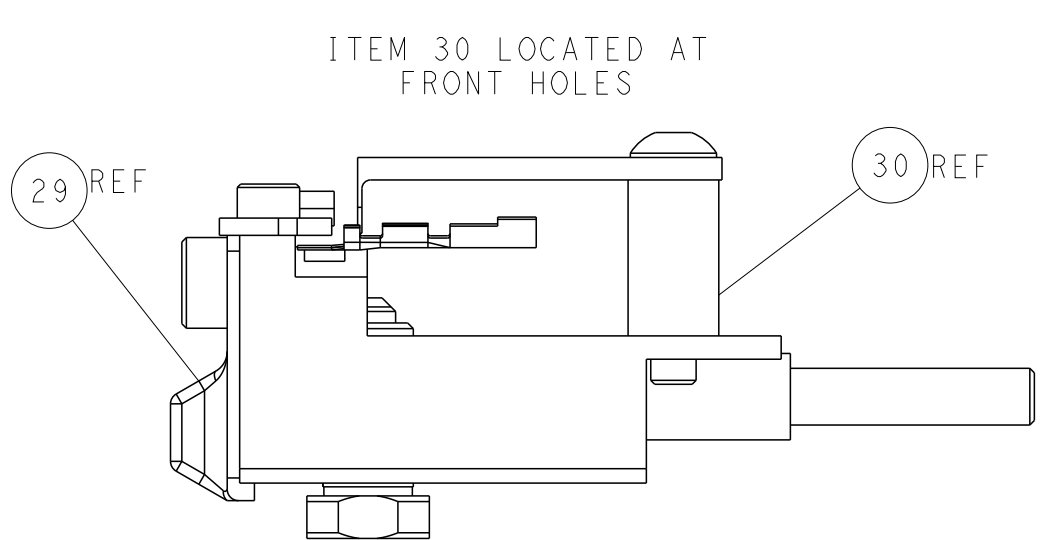
PNEUMATIC



TERMINAL SUPPORT LOCATION



RAM SET-UP

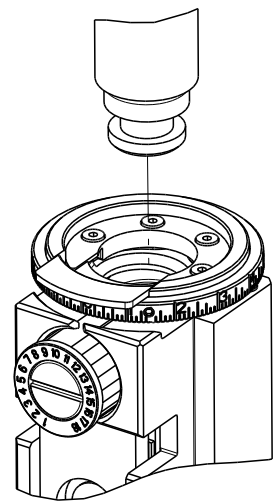


FEED TRACK POSITION
GUIDE BY INS. BARREL

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

[illegible]

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(C) COPYRIGHT 20 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.				
PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	
2-2151740-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL	
2-2151740-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	
7-2151740-7	A	CRIMP TOOLING KIT	-	



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.40 mm [.055]	F
INSUL	1.78 mm [.070]	O
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: REC CONTACT ASSY S RANGE CLEAN BODY 025 CONNECTOR			
WIRE STRIP LENGTH 4.50-5.00 mm [.177-.197 IN]		INSULATION DIAMETER RANGE Ø1.10-1.70 mm [.043-.067 IN]	
TERMINAL APPLICATION 		114-5278	
SPECIFICATION		-	
TERMINALS APPLIED			
TE TERMINAL 1717148-1	TE TERMINAL	TE TERMINAL	TE TERMINAL

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING 
0.50mm2		0.88+/-0.03 [0.035+/-0.001]		7.8
0.30mm2		0.79+/-0.03 [0.031+/-0.001]		8.8



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.

[illegible]

	-	1	1	2119082-6	CAM, SNAIL, INSULATION ADJUSTMENT	244
	-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
3	-	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	455888-5	SPACER, CRIMPER	82
	-	1	1	5-547505-2	SPRING, COMPRESSION	77
	-	1	1	854769-4	HOLDER, INS	74
	-	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	21028-2	PIN, SLOTTED SPRING .062 X .250	58
	-	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	1752356-3	SUPPORT, TERMINAL	34
	-	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
	-	2	2	2-2844962-4	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
	-	1	1	1-18028-2	WASHER, FLAT, REG M4	20
	-	1	1	2119533-1	STRIPPER, SIDE FEED	19
1	-	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	5-1333201-5	ANVIL, COMBINATION	8
	-	-	-	-	-	7
	-	-	-	-	-	6
	-	1	1	2119780-9	DEPRESSOR, SHEAR	5
	-	1	1	1-238011-0	BLOCK, CRIMPER SPACER	4
1	1	1	1	6-2119784-8	CRIMPER, INSULATION O PREMIUM	3
	-	1	1	455888-9	SPACER, CRIMPER	2
1	1	1	1	1276940-5	CRIMPER, SPECIAL	1

THIS DRAWING IS A CONTROLLED DOCUMENT FOR WHICH ELECTRICAL INFORMATION SHOULD BE OBTAINED FROM THE LATEST VERSION.		OWN 20AUG2012 T.YIN CHK 20AUG2012 G.BAILEY APP 20AUG2012 S.XI		 TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± ANGLES ± FINISH		NAME Ocean Side Feed Applicator PRODUCT SPEC APPLICATION SPEC	
MATERIAL -		WEIGHT -		SIZE CODE DRAWING NO RESTRICTED TO A 00779 C=2151740 -	
Customer Accessible Production Drawing				SCALE 1:2 SHEET 3 OF 4 REV B	

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

AMP 4805 REV 31MAR2000

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	-	-	-	

D

C

B

A

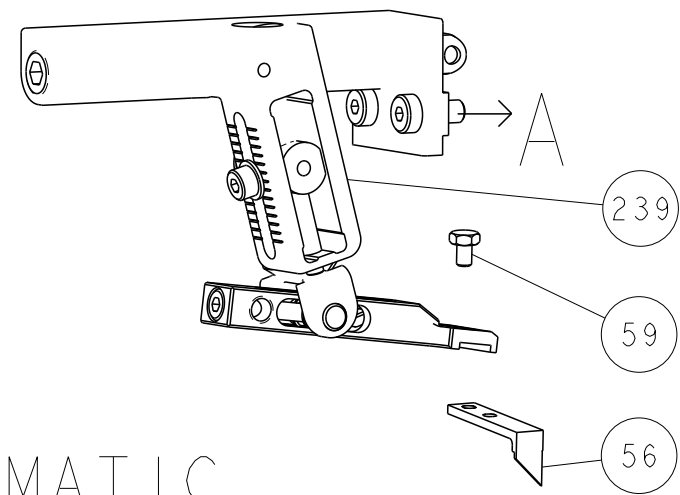
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C

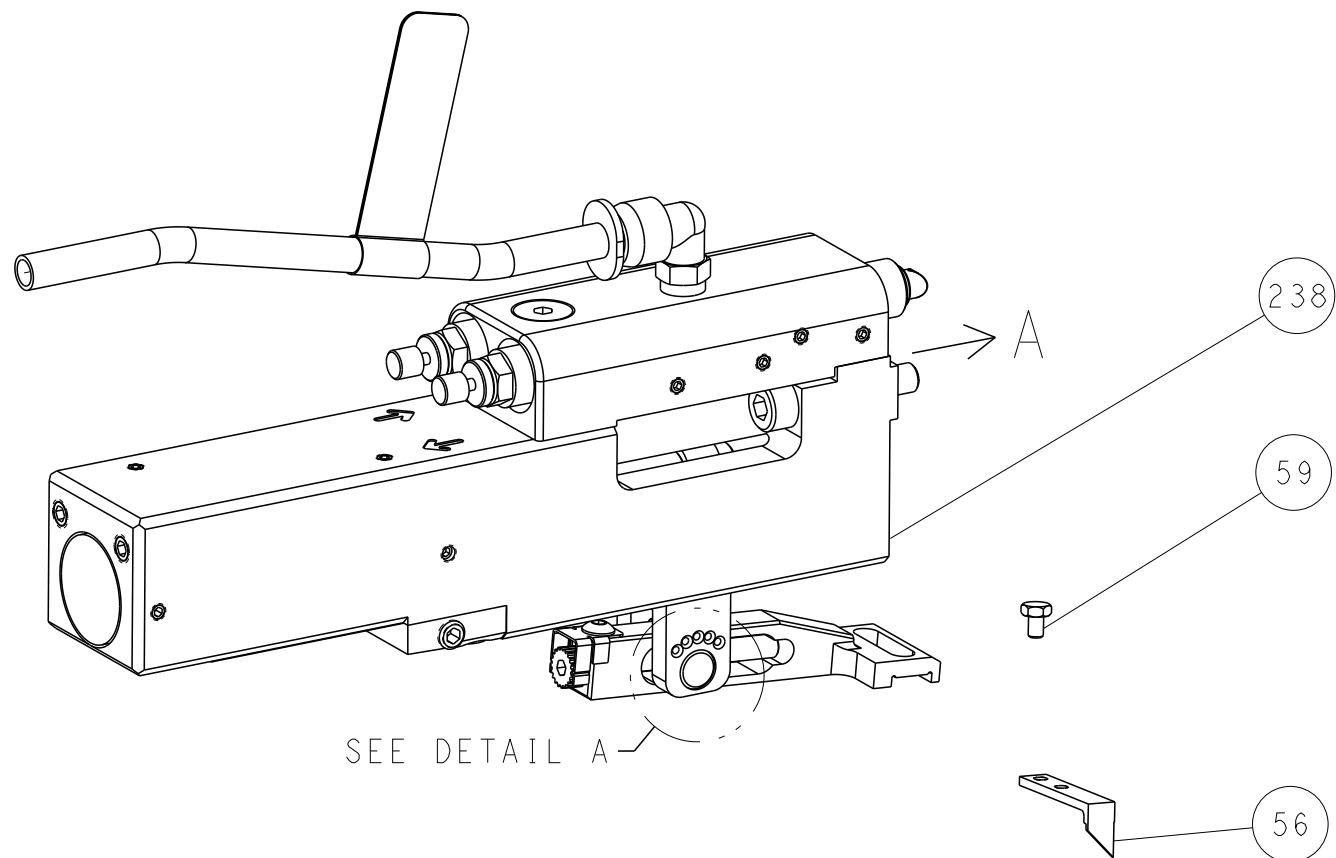
B

A

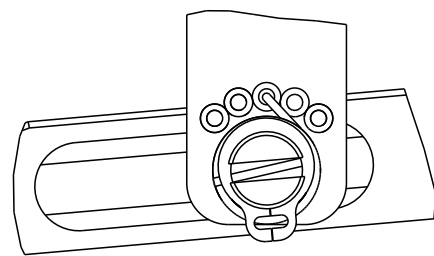
FEED TYPE MECHANICAL



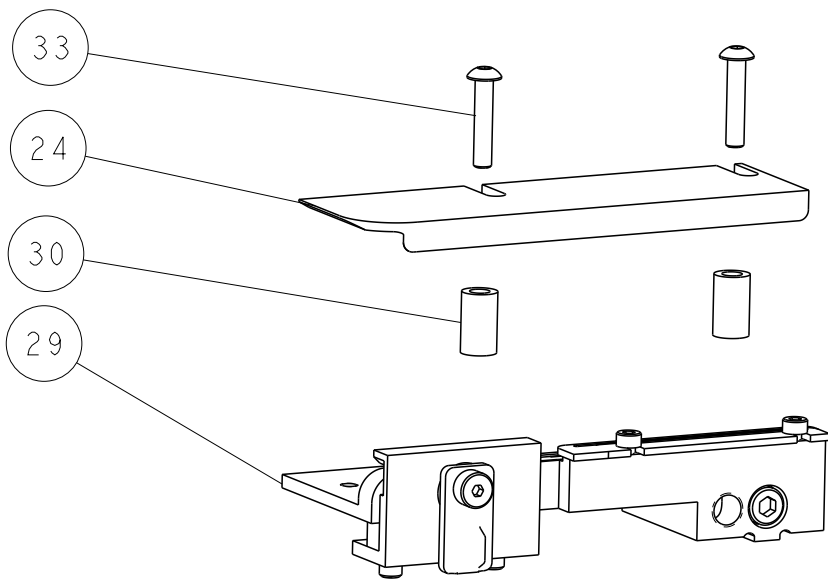
PNEUMATIC



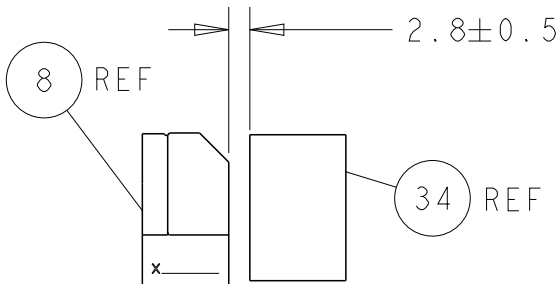
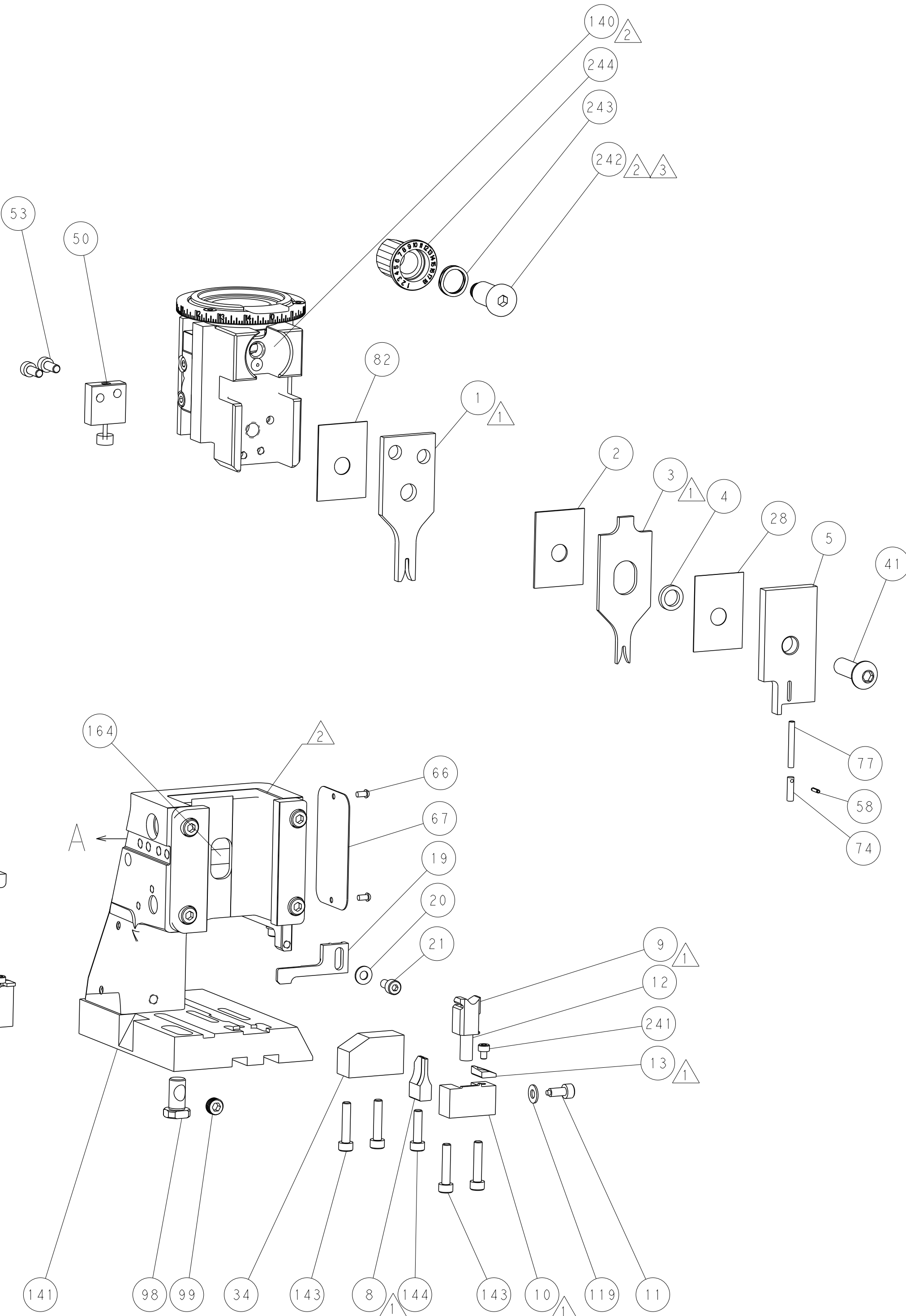
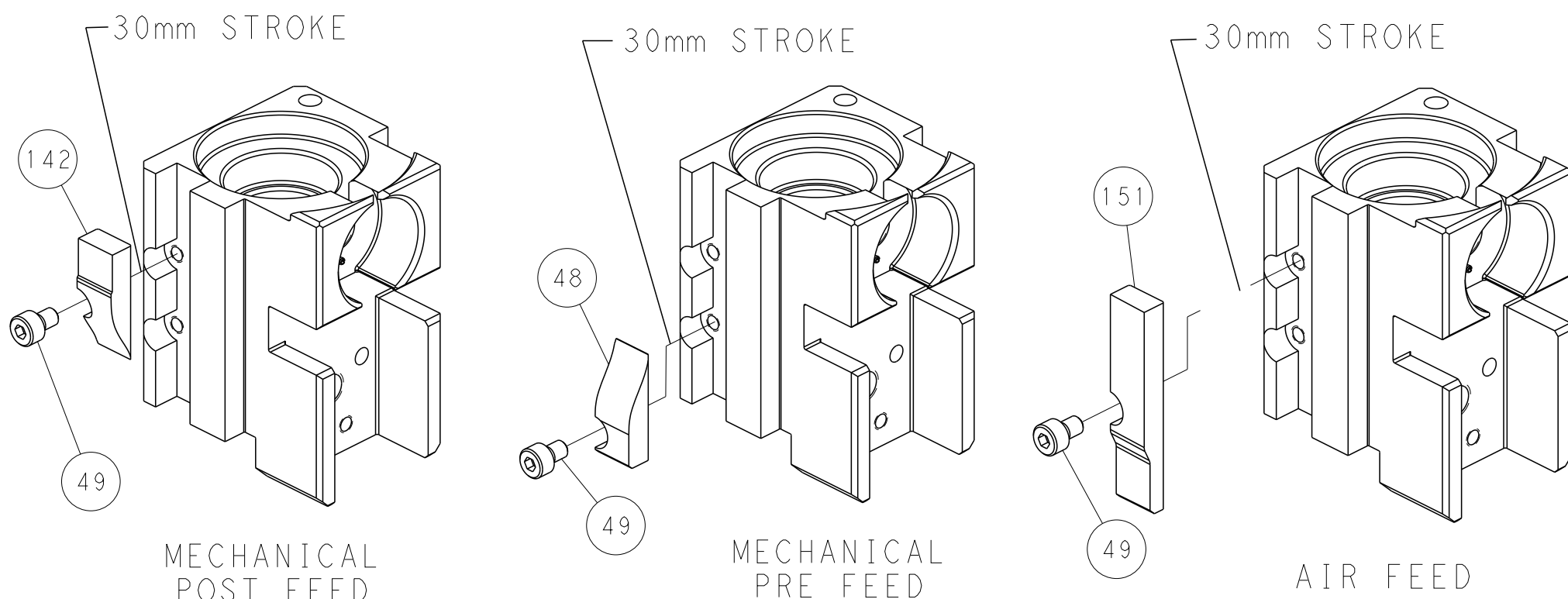
FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



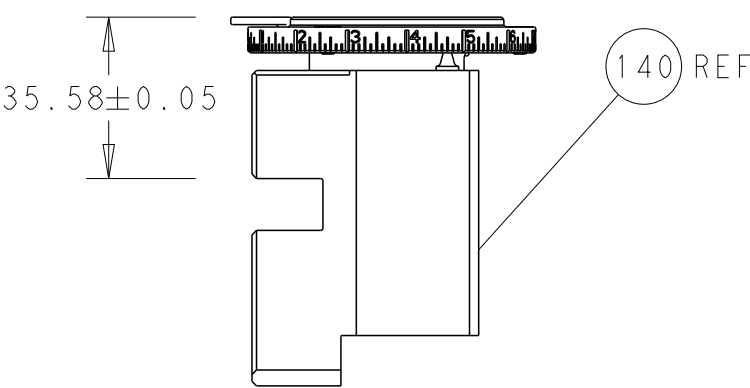
DETAIL A



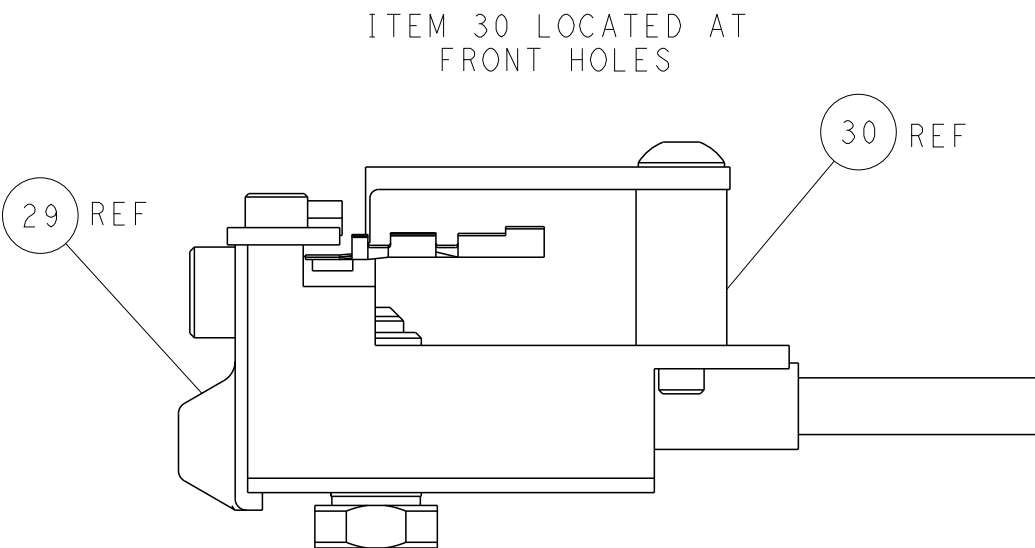
CAM POSITIONS



TERMINAL SUPPORT LOCATION



RAM SET-UP



FEED TRACK POSITION
GUIDE BY INS. 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 20AUG2012				NAME				Ocean Side Feed Applicator			
APVD S. XI 20AUG2012				PRODUCT SPEC				SIZE CAGE CODE DRAWING NO			
APPLICATION SPEC				WEIGHT				A1 00779 C=2151740			
MATERIAL				Customer Accessible Production Drawing				SCALE 1:2 SHEET 4 OF 4 REV B			

Mouser Electronics

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[TE Connectivity:](#)

[2-2151740-1](#)