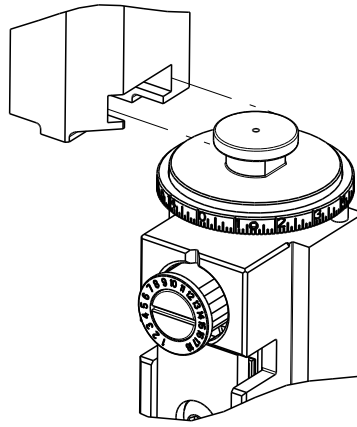


8		7	
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20		20	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151764-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2151764-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151764-1	B	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2151764-2	B	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2151764-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.40 mm [.055]	F
INSUL	2.10 mm [.083]	O
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: MOLEX TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: MOX 0.635mm		RECEPTACLE TERMINAL	
WIRE STRIP LENGTH 2.60-3.30 mm [.102-.130 IN]		INSULATION DIAMETER RANGE Ø1.10-1.91 mm [.043-.075 IN]	
TERMINAL APPLICATION SPECIFICATION		ATS-638666000	
-		-	
-		-	
TERMINALS APPLIED			
TE TERMINAL	MOLEX TERMINAL	TE TERMINAL	MOLEX TERMINAL
1949017-1	0986581211	1949017-3	0986581231
1949017-2	0986581221		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
20 AWG OR 0.60mm2	0.96+/-0.05 [.038+/- .002]	6.3
0.50mm2	0.90+/-0.05 [.035+/- .002]	6.9
22 AWG OR 0.35mm2	0.82+/-0.05 [.032+/- .002]	7.9
0.22mm2	0.79+/-0.03 [.031+/- .001]	8.2



- 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.

LOC		DIST		REVISIONS					
A		66		P	LTR	DESCRIPTION	DATE	OWN	APVD
					A	RELEASED	05NOV2012	LG	TE
					B	ECR-19-018033	19NOV2019	TB	RK

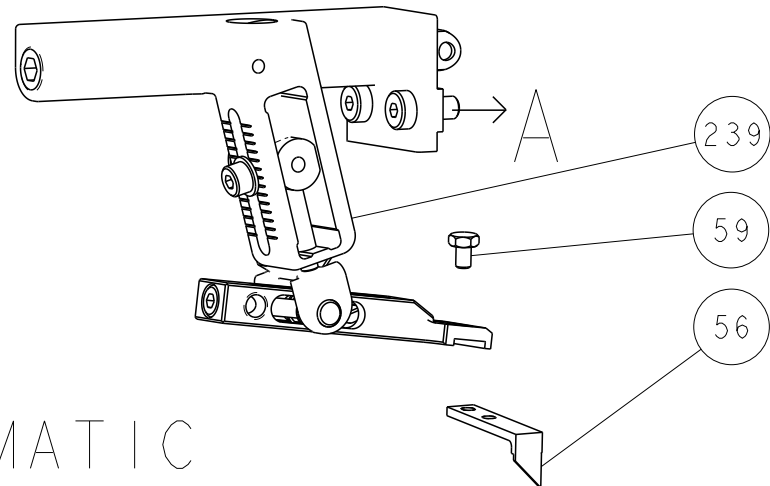
-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248
-	1	1	1	1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	1	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
-	-	1	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	1	-	1	-	2844940-1	AIR FEED MODULE	238
-	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	1	1	1	1	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	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	1752356-6	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	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
-	2	2	2	2	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	1633917-8	ANVIL, COMBINATION	8
-	-	-	-	-	-	-	7
-	-	-	-	-	-	-	6
-	1	1	1	1	2119757-8	DEPRESSOR, SHEAR	5
-	1	1	1	1	5-238011-5	BLOCK, CRIMPER SPACER	4
1	1	2	2	1	4-1633965-5	CRIMPER, INSULATION O PREMIUM	3
-	1	1	1	1	455888-6	SPACER, CRIMPER	2
1	1	2	2	1	2-456402-3	CRIMPER, WIRE PREMIUM	1
-	77	-72	-71	-2	-1	PART NO	ITEM NO

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DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		NAME		Ocean Side Feed Applicator			
0 PLC 1 PLC 2 PLC 3 PLC 4 PLC		± ± ± ± ±		PRODUCT SPEC		-			
ANGLES		±		APPLICATION SPEC		-			
FINISH		-		WEIGHT		-			
MATERIAL		-		SCALE		1:2			
-		-		SHEET		1 OF 4			
-		-		REV		B			

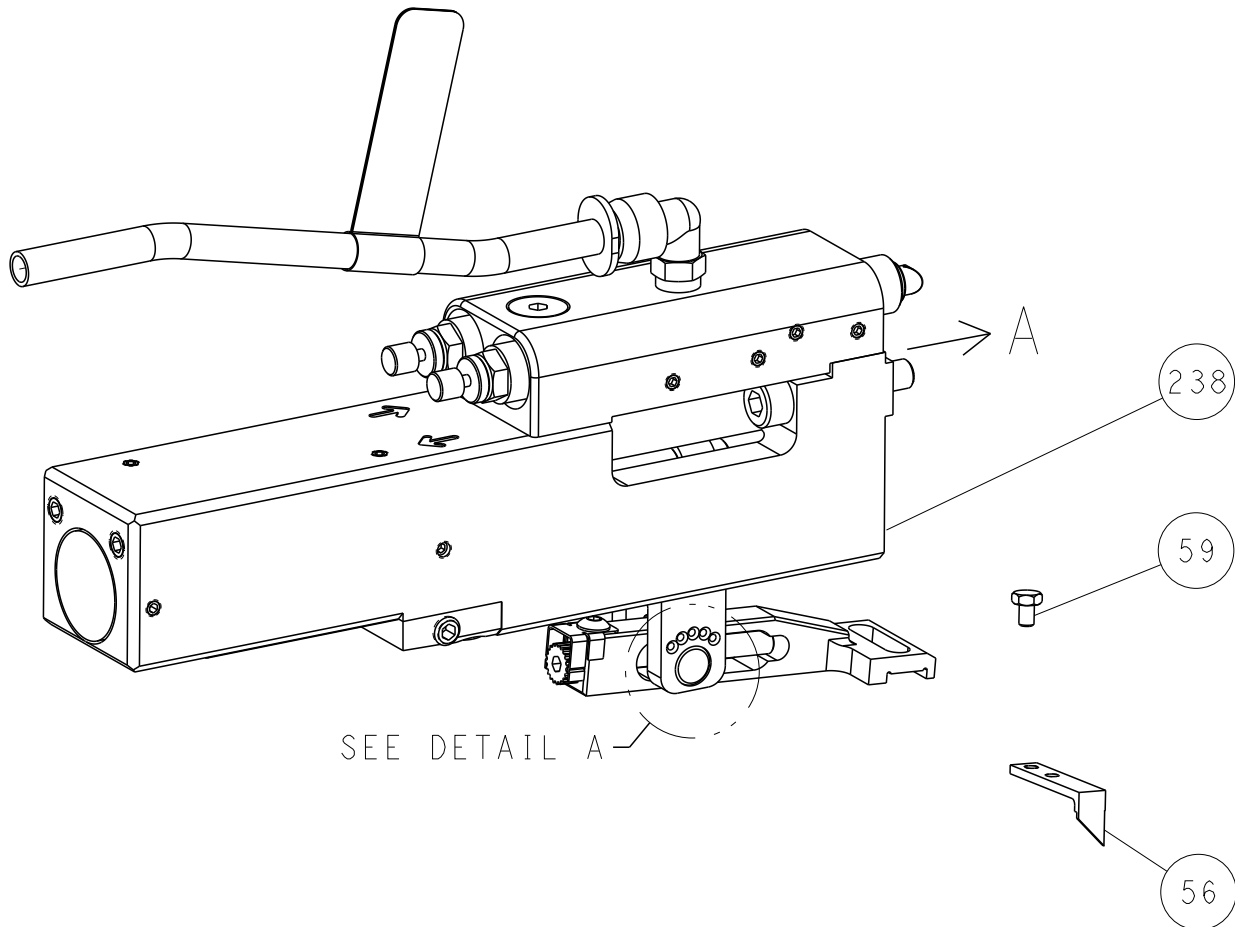
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

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

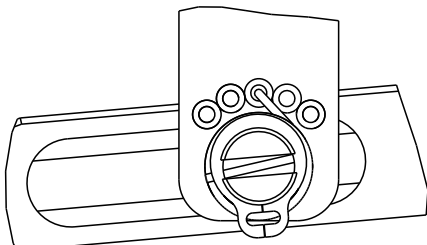
FEED TYPE MECHANICAL



PNEUMATIC

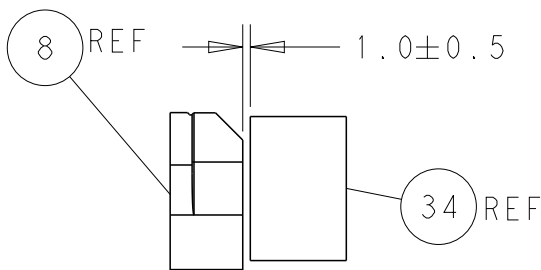
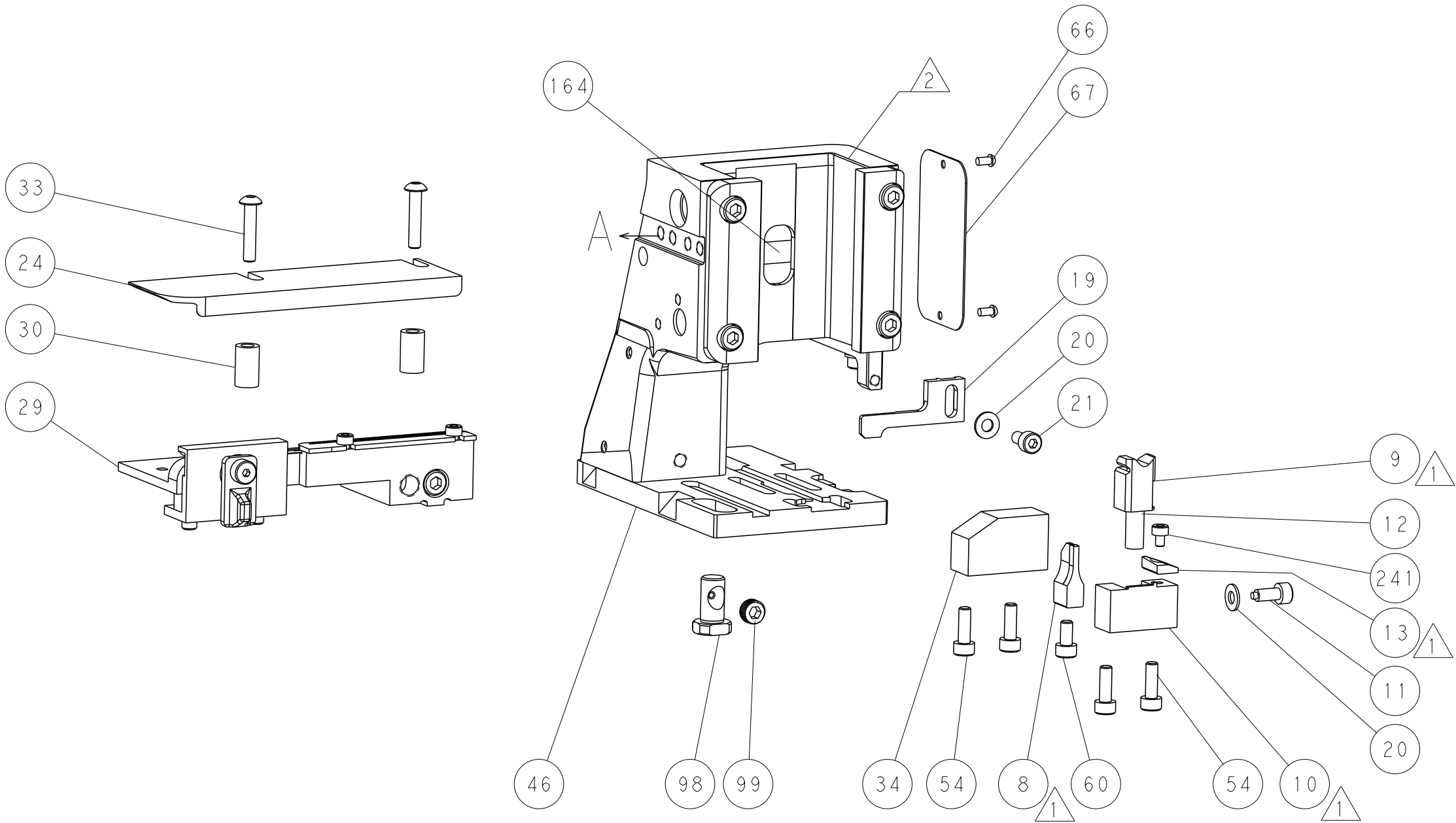
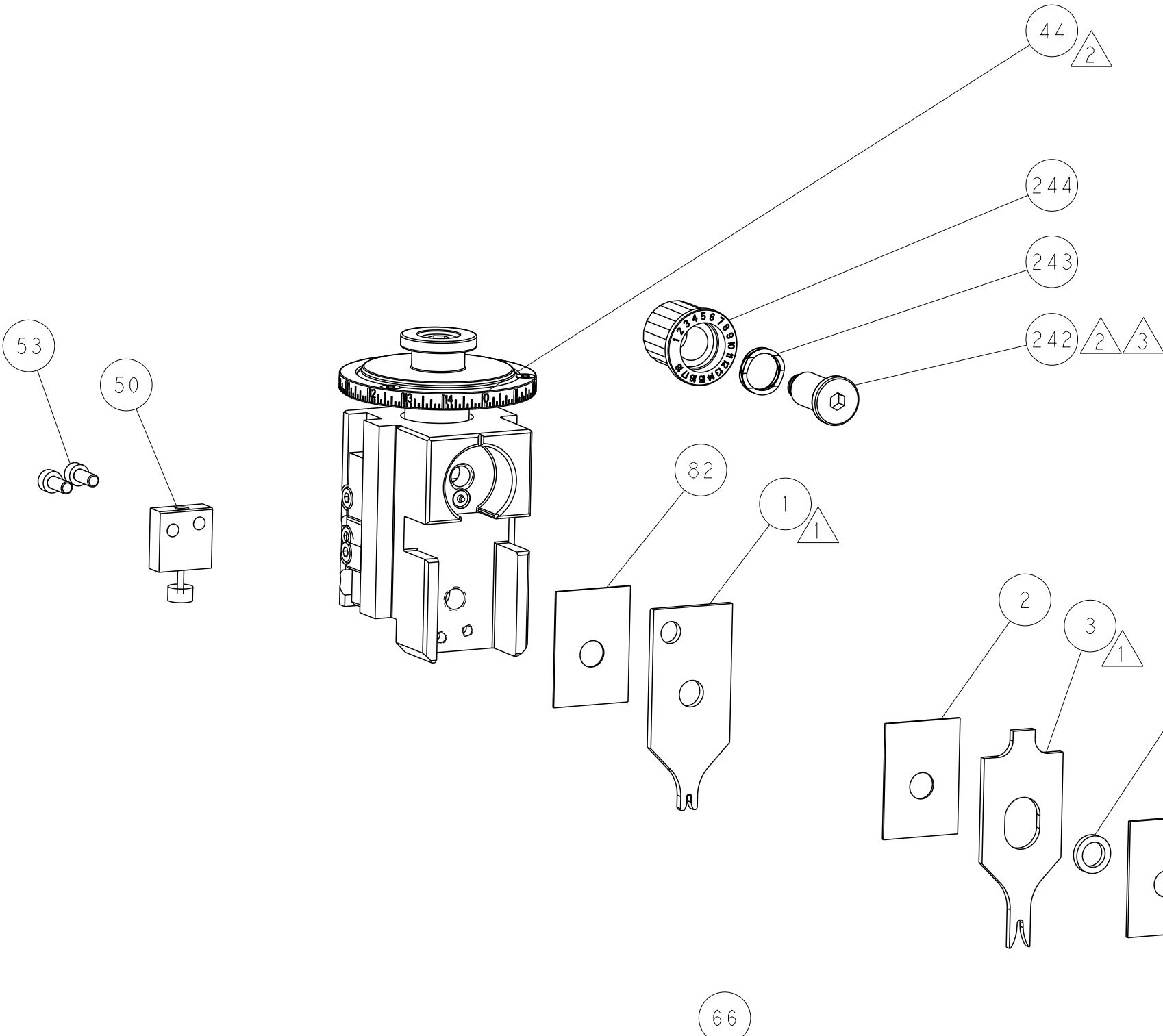
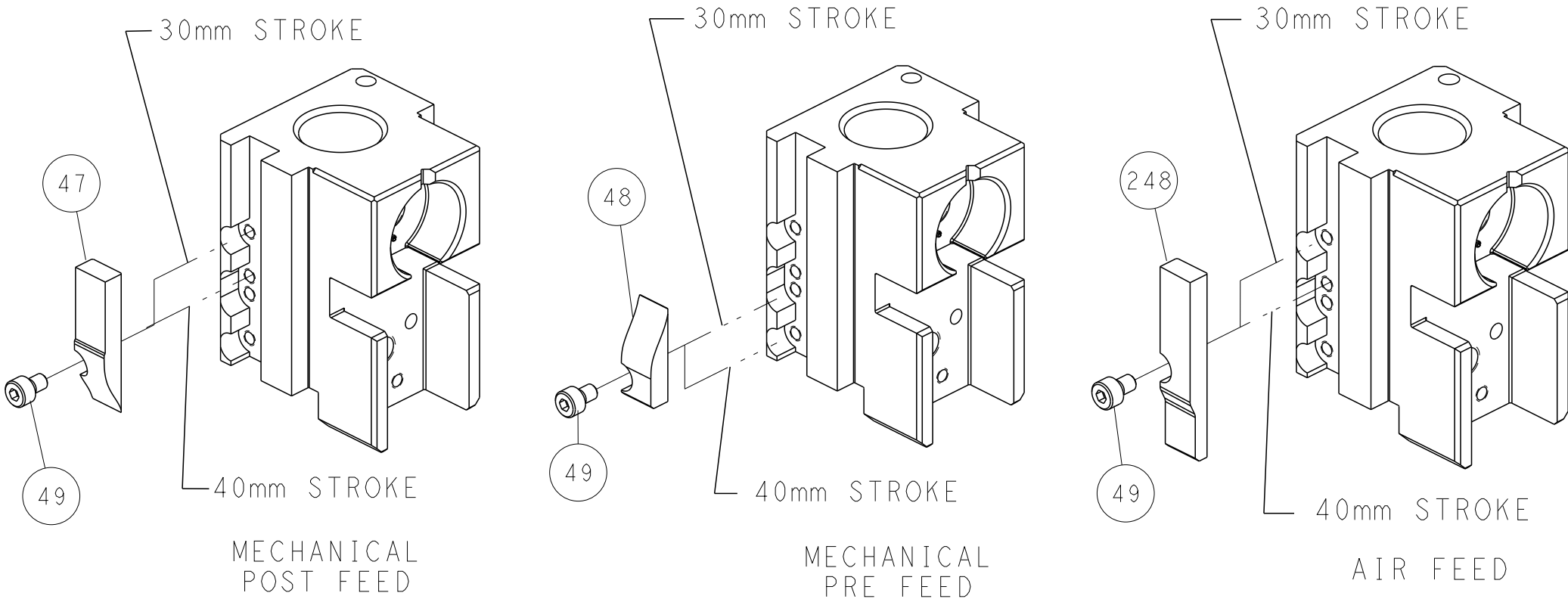


FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)

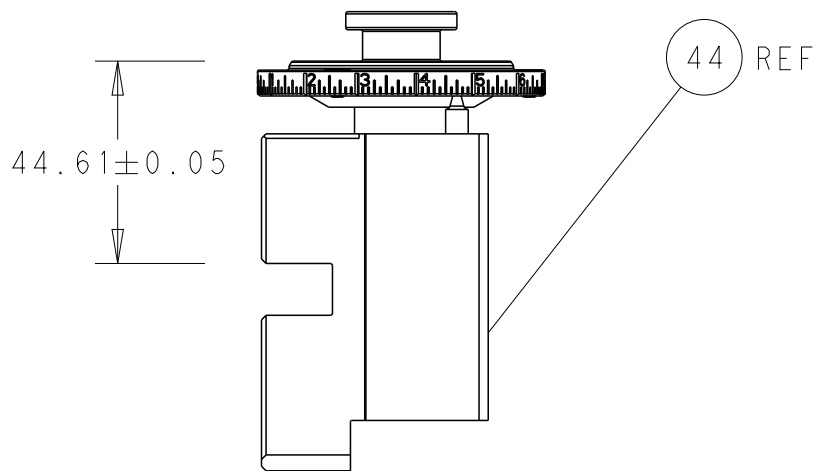


DETAIL A

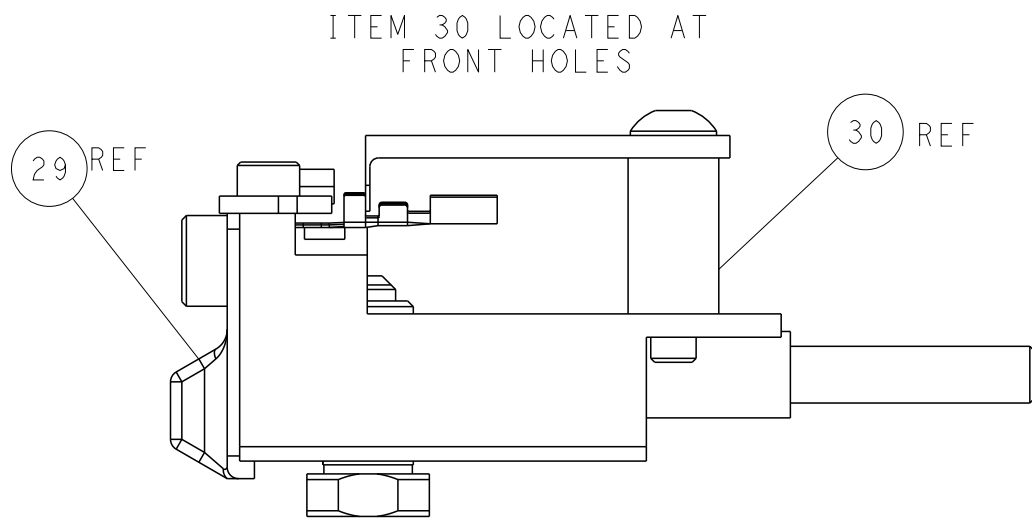
CAM POSITIONS



TERMINAL SUPPORT LOCATION



RAM SET-UP



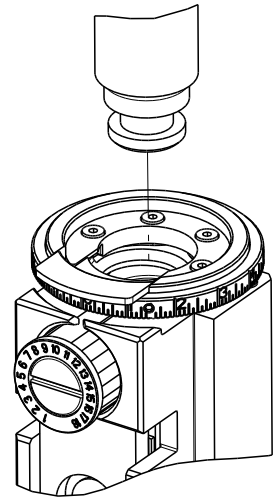
FEED TRACK POSITION
GUIDE BY INSULATION BARREL

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

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN R.O.WILSON 26SEP2012		TE Connectivity	
mm		0 PLC ±		CHK K.J.STAKEM 28SEP2012		Harrisburg, PA 17105-3608	
		1 PLC ±		APVD T.L.ELBIN 28SEP2012		NAME Ocean Side Feed	
		2 PLC ±		PRODUCT SPEC		Applicator	
		3 PLC ±		APPLICATION SPEC		SIZE	
		4 PLC ±		ANGLES		CAGE CODE	
		FINISH		WEIGHT		DRAWING NO	
MATERIAL				Customer Accessible Production Drawing		RESTRICTED TO	
				SCALE 1:2		SHEET 2 OF 4	
						REV B	

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PART NUMBER	REVISION	DESCRIPTION
2-2151764-1	B	FINE CRIMP HEIGHT ADJUST
2-2151764-2	B	FINE CRIMP HEIGHT ADJUST
7-2151764-7	A	CRIMP TOOLING KIT
		FEED TYPE
		MECHANICAL
		PNEUMATIC
		-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.40 mm [.055]	F
INSUL	2.10 mm [.083]	O
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: MOLEX TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: MOX 0.635mm		RECEPTACLE TERMINAL	
WIRE STRIP LENGTH 2.60-3.30 mm [.102-.130 IN]		INSULATION DIAMETER RANGE Ø1.10-1.91 mm [.043-.075 IN]	
TERMINAL APPLICATION SPECIFICATION ATS-638666000		-	
TERMINAL APPLICATION SPECIFICATION -		-	
TERMINALS APPLIED			
TE TERMINAL	MOLEX TERMINAL	TE TERMINAL	MOLEX TERMINAL
1949017-1	0986581211	1949017-3	0986581231
1949017-2	0986581221		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
20 AWG OR 0.60mm2	0.96+/-0.05 [.038+/- .002]	6.3
0.50mm2	0.90+/-0.05 [.035+/- .002]	6.9
22 AWG OR 0.35mm2	0.82+/-0.05 [.032+/- .002]	7.9
0.22mm2	0.79+/-0.03 [.031+/- .001]	8.2



- 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.
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	REVISONS			
A	66	P	LTR	DESCRIPTION	DATE
		-		SEE SHEET 1	-

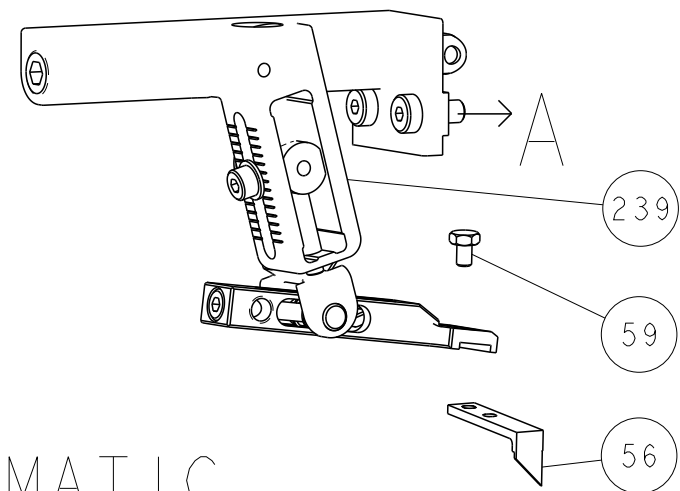
-	1	1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
-	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	1	-	2844940-1	AIR FEED MODULE	238
-	REF	REF	994970-2	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	2844908-1	SCREW, LOCKING	99
-	1	1	2844907-1	POST, LOCKING	98
-	1	1	455888-5	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	1752356-6	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	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
-	2	2	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	1633917-8	ANVIL, COMBINATION	8
-	-	-	-	-	7
-	-	-	-	-	6
-	1	1	2119757-8	DEPRESSOR, SHEAR	5
-	1	1	5-238011-5	BLOCK, CRIMPER SPACER	4
-	1	1	4-1633965-5	CRIMPER, INSULATION O PREMIUM	3
-	1	1	455888-6	SPACER, CRIMPER	2
-	1	1	2-456402-3	CRIMPER, WIRE PREMIUM	1
-77	-22	-21	PART NO	DESCRIPTION	ITEM NO

THIS DRAWING IS A CONTROLLED DOCUMENT AND THE FOLLOWING INFORMATION IS SUBJECT TO COMPANY'S CONTROL AND THE FOLLOWING ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST REVISION.		OWN R. O. WILSON CHK K. J. STAKEM APVD T. L. ELBIN	26SEP2012 28SEP2012 28SEP2012	TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		NAME Ocean Side Feed Applicator	
0 PLC 1 PLC 2 PLC 3 PLC 4 PLC ANGLES FINISH		± ± ± ± ± ± ±		PRODUCT SPEC APPLICATION SPEC	
MATERIAL -		WEIGHT -		SIZE A	
				CAGE CODE 00779	
				DRAWING NO 2151764	
				RESTRICTED TO -	
				Customer Accessible Production Drawing	
				SCALE 1:2	
				SHEET 3	
				OF 4	
				REV B	

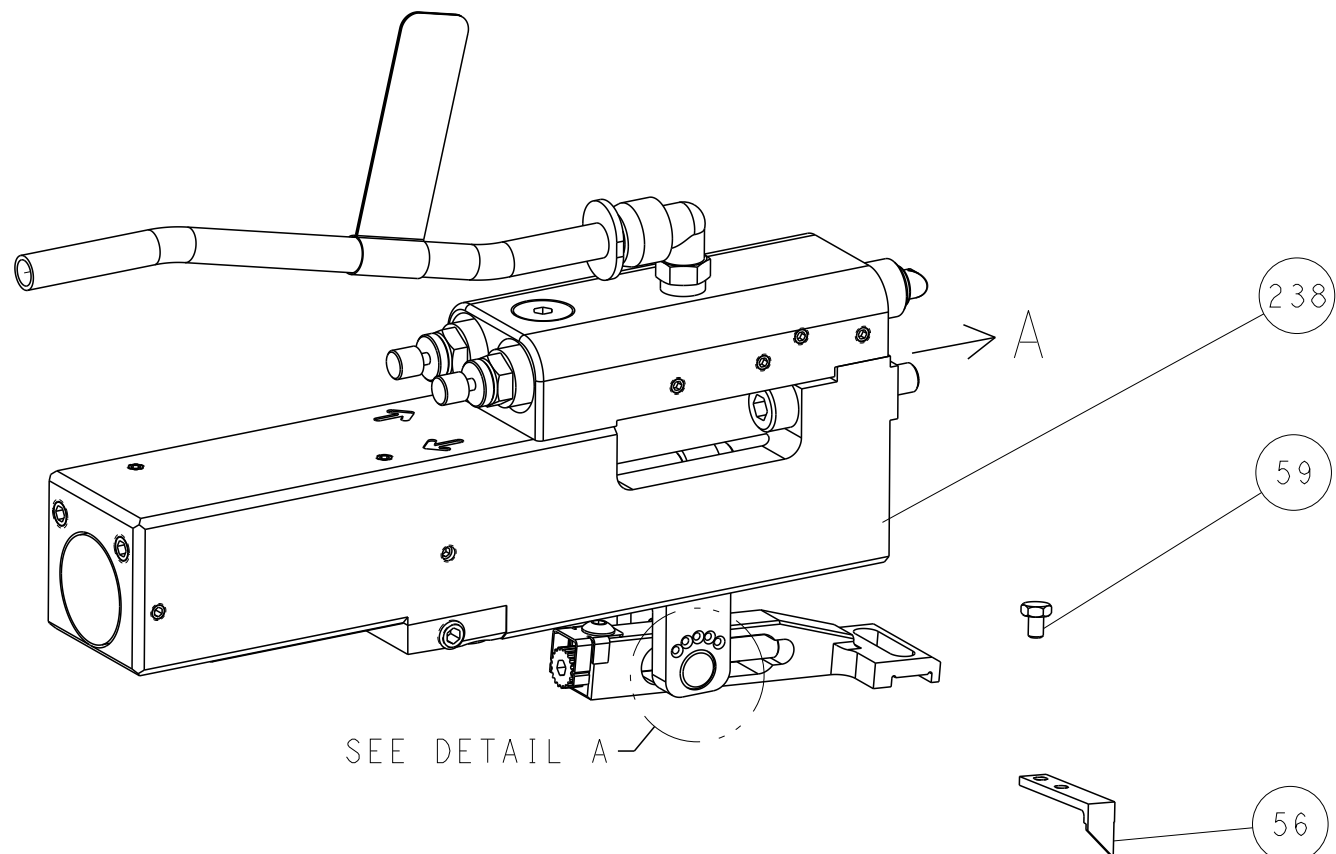
SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

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

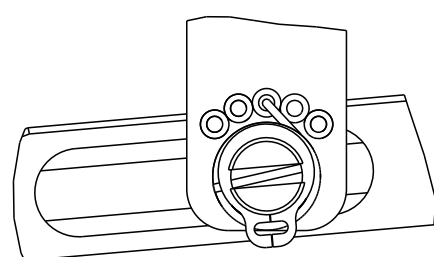
FEED TYPE MECHANICAL



PNEUMATIC

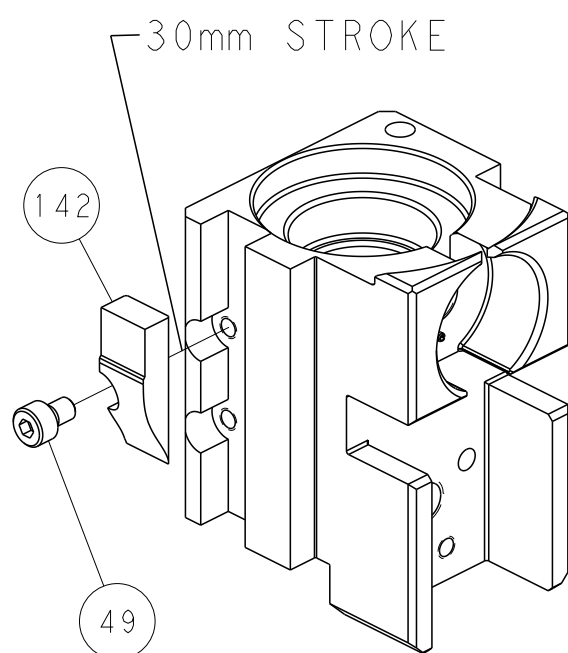


FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)

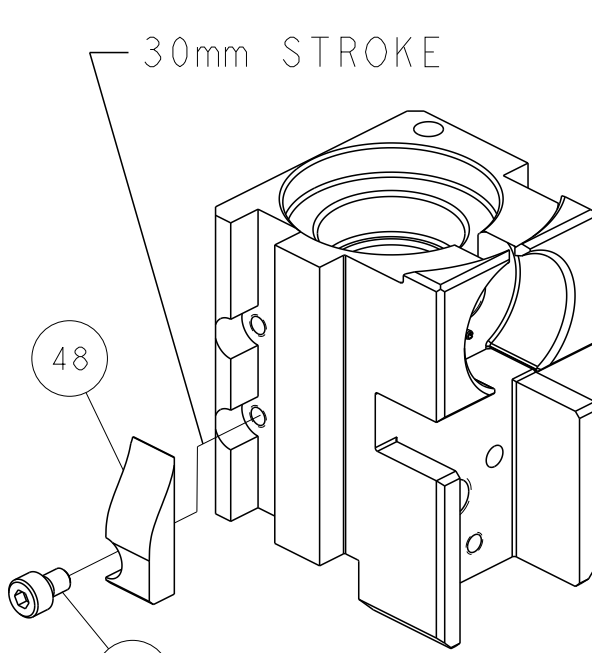


DETAIL A

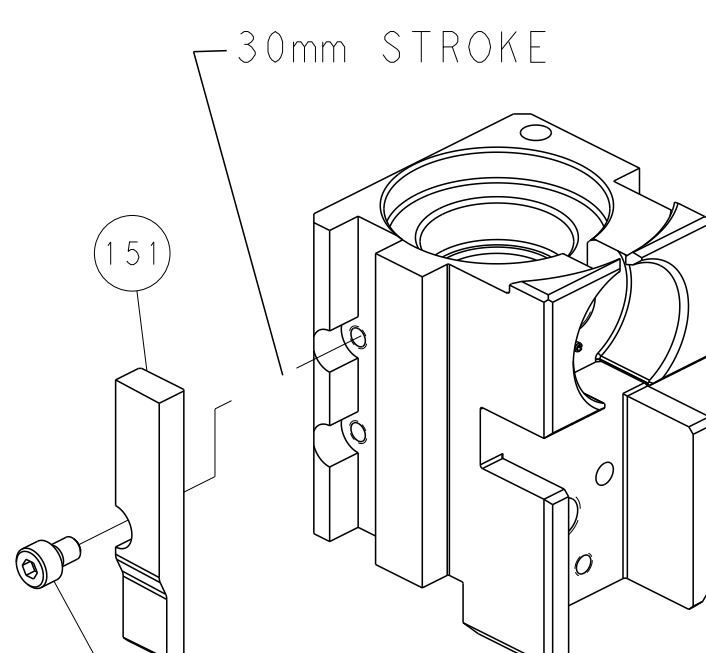
CAM POSITIONS



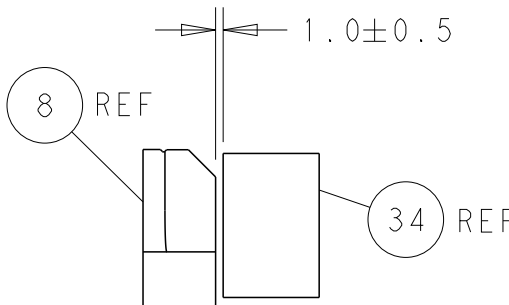
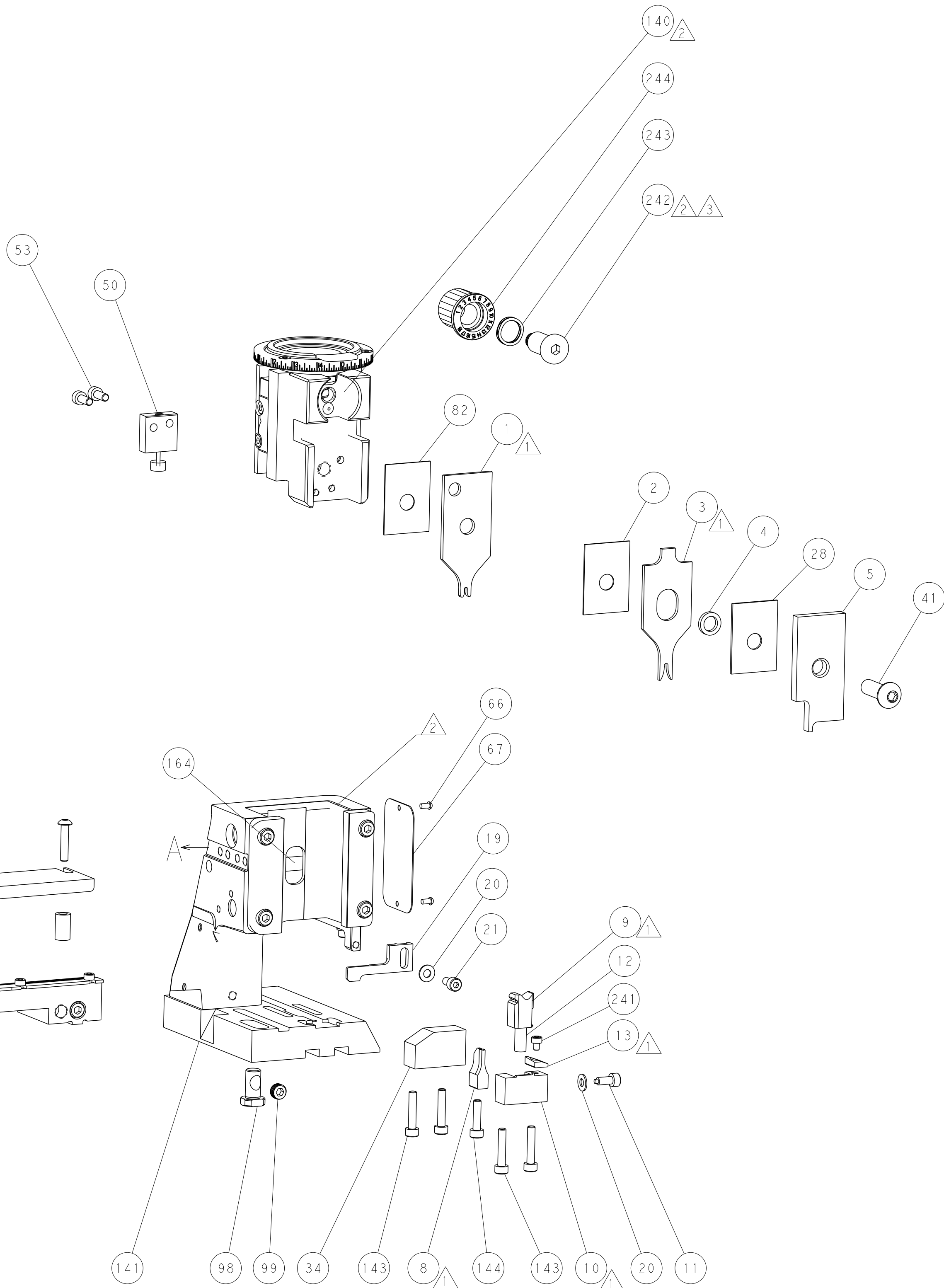
MECHANICAL
POST FEED



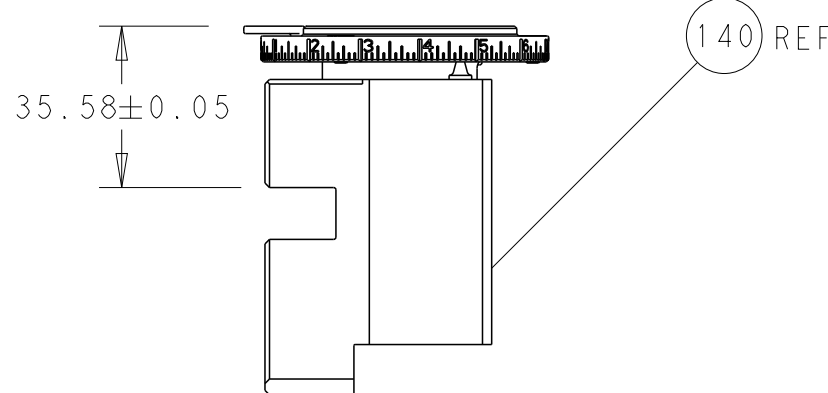
MECHANICAL
PRE FEED



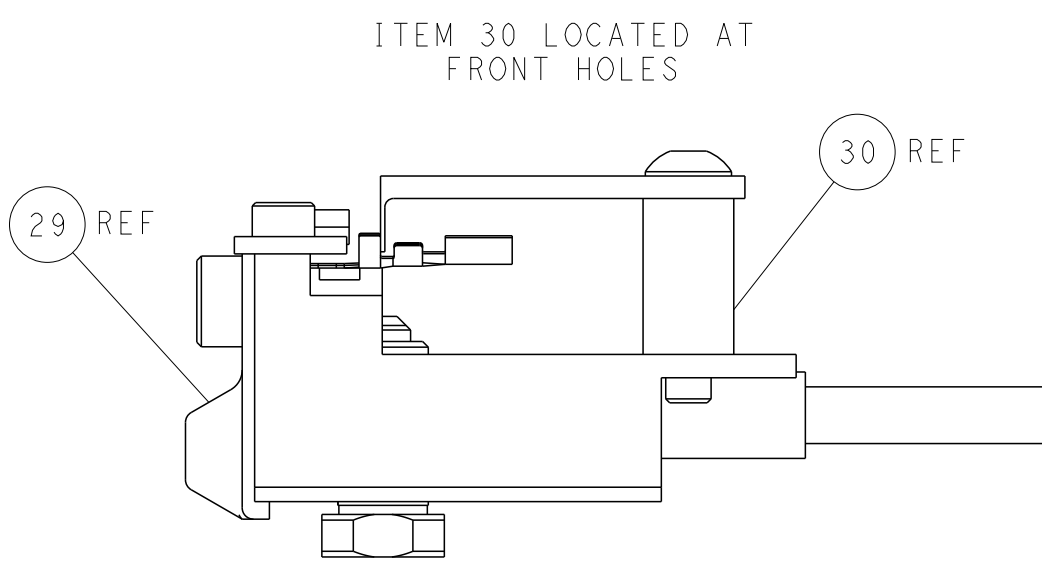
AIR FEED



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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DIMENSIONS: mm		CHK K.J. STAKEM 28SEP2012	NAME Ocean Side Feed Applicator	
TOLERANCES UNLESS OTHERWISE SPECIFIED:		APVD T.L. ELBIN 28SEP2012	SIZE A1	
0 PLC ±.005		PRODUCT SPEC	CAGE CODE 00779	
1 PLC ±.005		APPLICATION SPEC	DRAWING NO 2151764	
2 PLC ±.005		WEIGHT	RESTRICTED TO	
3 PLC ±.005		Customer Accessible Production Drawing	SCALE 1:2	
4 PLC ±.005		SCALE 1:2	SHEET 4	
ANGLES FINISH		REV B	OF 4	

Mouser Electronics

Authorized Distributor

Click to View Pricing, Inventory, Delivery & Lifecycle Information:

[TE Connectivity:](#)

[2-2151764-1](#)