

8		7	
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20		20	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151865-1	G	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2151865-2	G	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151865-1	G	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2151865-2	G	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2151865-7	D	CRIMP TOOLING KIT	-

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.27 mm [.050]	F
INSUL	1.45 mm [.057]	F
APPLICATOR INSTRUCTIONS 408-35042		

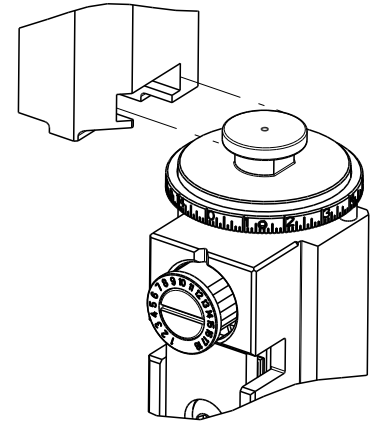
TERMINAL DATA: HIROSE TERMINAL		HIROSE CRIMP SPECIFICATION	
TERMINAL NAME: CRIMPING CONTACT for SOCKET			
WIRE STRIP LENGTH 1.70-2.30 mm [.067-.091 IN]		INSULATION DIAMETER RANGE Ø1.20-1.45 mm [.047-.057 IN]	
TERMINAL APPLICATION SPECIFICATION		039527-5-11	
TERMINALS APPLIED		△	
TE TERMINAL	HIROSE TERMINAL	TE TERMINAL	HIROSE TERMINAL
1572122-1	DF11-22SCF	1572122-2	DF11-22SCFA

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
22 AWG	0.67+/-0.03 [.026+/- .001]	9.5



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. APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 180.
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.

ATLANTIC VERSION TERMINATOR
INTERFACE ADAPTER

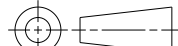


*WARNING
ON INSTALLATION, SET WIRE DISC TO CRIMP HEIGHT REFERENCE SETTING FOR LARGEST WIRE SIZE. CRIMP HEIGHT REFERENCE SETTINGS GREATER THAN THE VALUE SHOWN MAY CAUSE DAMAGE TO THE CRIMP TOOLING, REFER TO THE INSTRUCTION SHEET FOR PROPER SETUP AND ADJUSTMENTS.

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

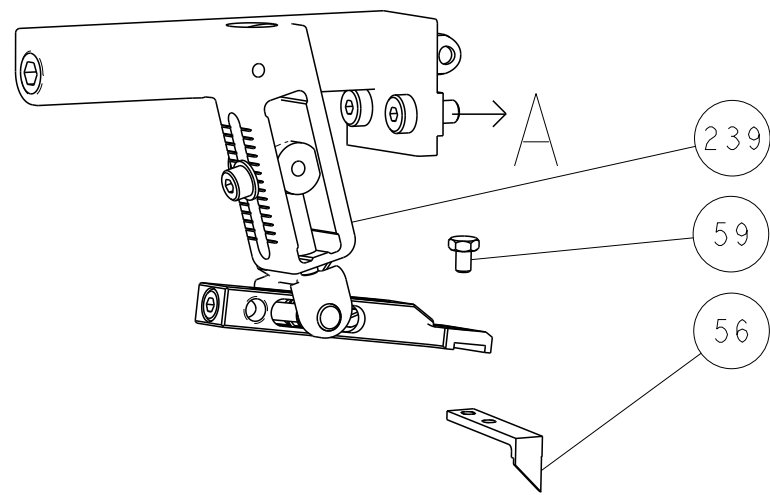
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		F		ECR-18-008630	05JUN2018	VLA	JDG
		G		ECR-19-005124	29MAR2019	TB	GB

-	1	-	1	-	2119640-1	PUSH ROD, AIR FEED	250
-	1	-	1	-	1803259-1	BUSHING, FLANGED	249
-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248
-	1	1	1	1	2119082-4	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
3	-	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	-	2063440-1	AIR FEED MODULE	238
3	-	1	1	1	1-1752354-4	STANDOFF,HOLD-DOWN	180
-	1	1	1	1	9931111-1	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
-	2	-	2	-	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172
-	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	1	-	1	-	240638-1	SPRING, FEED FINGER	163
-	1	-	1	-	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854	137
-	1	-	1	-	2119799-1	HOLDER,FEED FINGER, AF	136
5	-	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	1-455888-3	SPACER, CRIMPER	82
-	1	1	1	1	22278-8	SPRING, COMPRESSION	77
-	1	1	1	1	854769-4	HOLDER, INS	74
-	1	1	1	1	1803607-1	DOCUMENTATION PACKAGE	71
-	1	1	1	1	2119791-9	DEPRESSOR, WIRE	70
-	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	1-2079383-0	SCR, BHSC, RoHS (M3 X 6)	53
-	1	1	1	1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52
-	1	1	1	1	1901681-8	HOLDDOWN, TERMINAL	51
-	1	1	1	1	1-1633764-5	HOLD DOWN, TERMINAL	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	2-1752356-5	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	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	2119533-9	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	1803095-3	FLOATING SHEAR, FRONT	9
1	1	2	2	1	1803335-3	ANVIL, COMBINATION	8
-	-	-	-	-	-	-	7
-	-	-	-	-	-	-	6
-	1	1	1	1	2119780-2	DEPRESSOR, SHEAR	5
-	1	1	1	1	2-238011-0	BLOCK, CRIMPER SPACER	4
1	1	2	2	1	1-1803326-3	CRIMPER, INSULATION F	3
-	1	1	1	1	455888-4	SPACER, CRIMPER	2
1	1	2	2	1	1-1803323-1	CRIMPER, WIRE PREMIUM	1

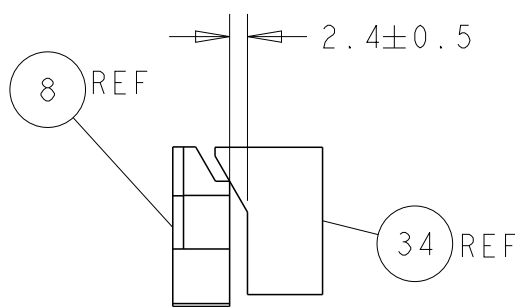
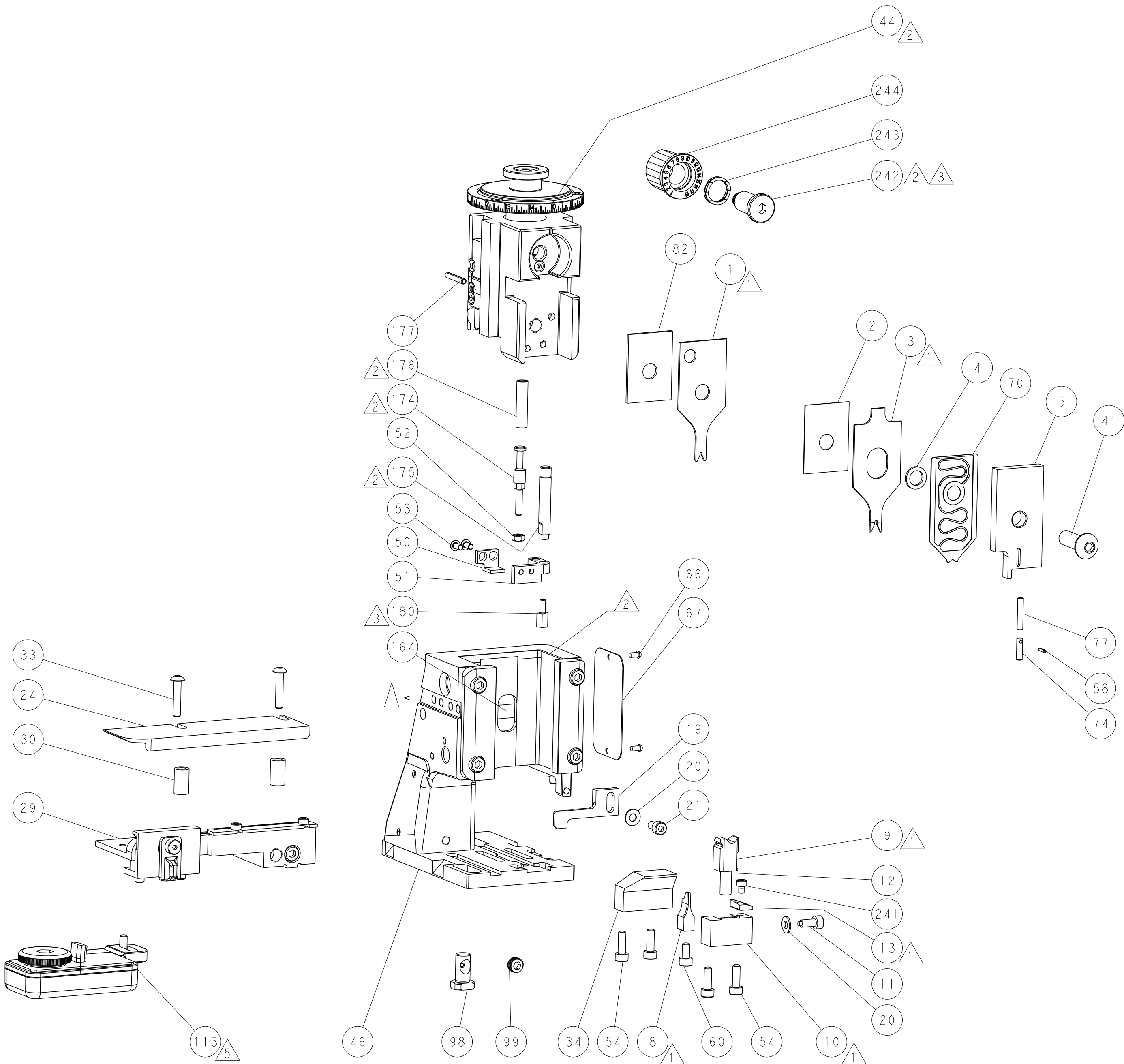
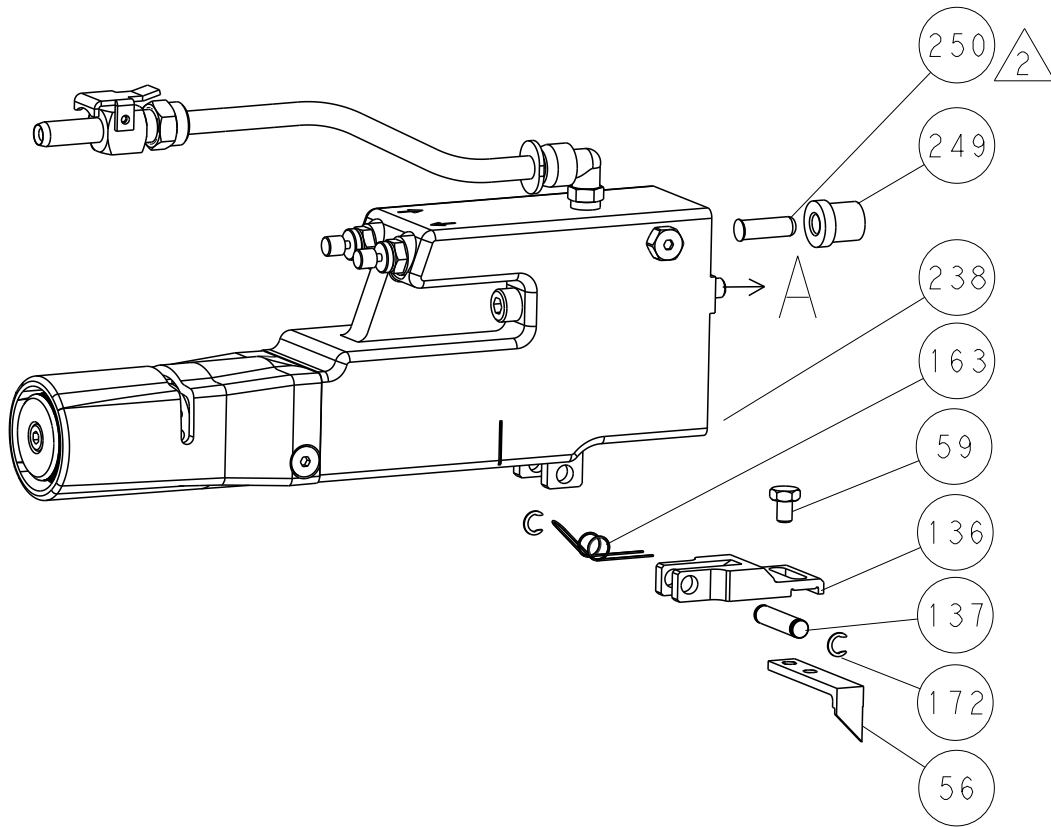
-77 -72 -71 -2 -1					PART NO		DESCRIPTION			ITEM NO
THIS DOCUMENT IS UNPUBLISHED. IT IS SUBJECT TO CHANGE WITHOUT NOTICE AND THE USER'S ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST EDITION.					DWN	31JAN2013		TE Connectivity Harrisburg, PA 17105-3608		
					CHK	01FEB2013				
					K.J. STAKEM	01FEB2013				
					T.L. ELBIN	01FEB2013				
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:			NAME					
mm							Ocean Side Feed Applicator			
		0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±			PRODUCT SPEC					
		FINISH ±			APPLICATION SPEC					
					WEIGHT -		SIZE	CASE CODE	DRAWING NO	RESTRICTED TO
							A1	00779	C=2151865	-
CUSTOMER DRAWING							SCALE	1:2	SHEET	1 OF 4
									REV	G

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

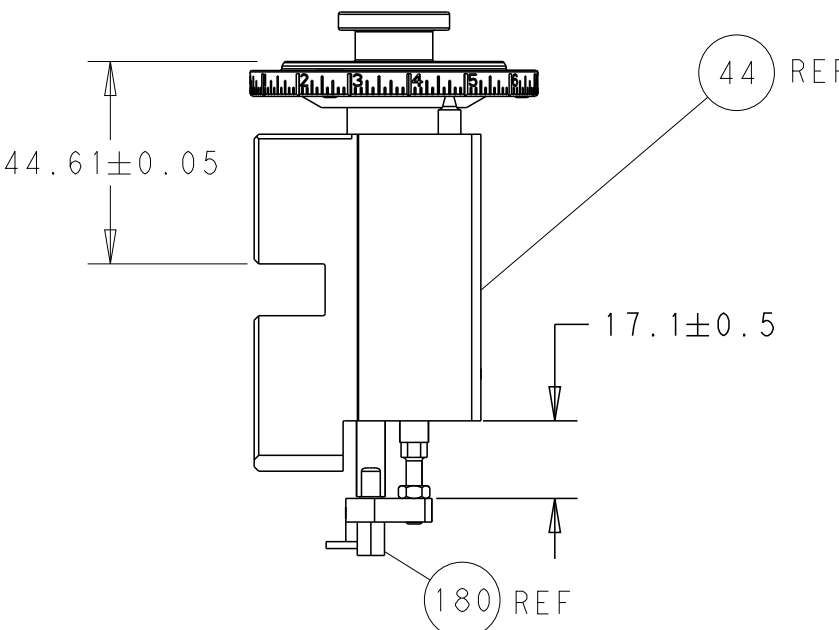
FEED TYPE
MECHANICAL



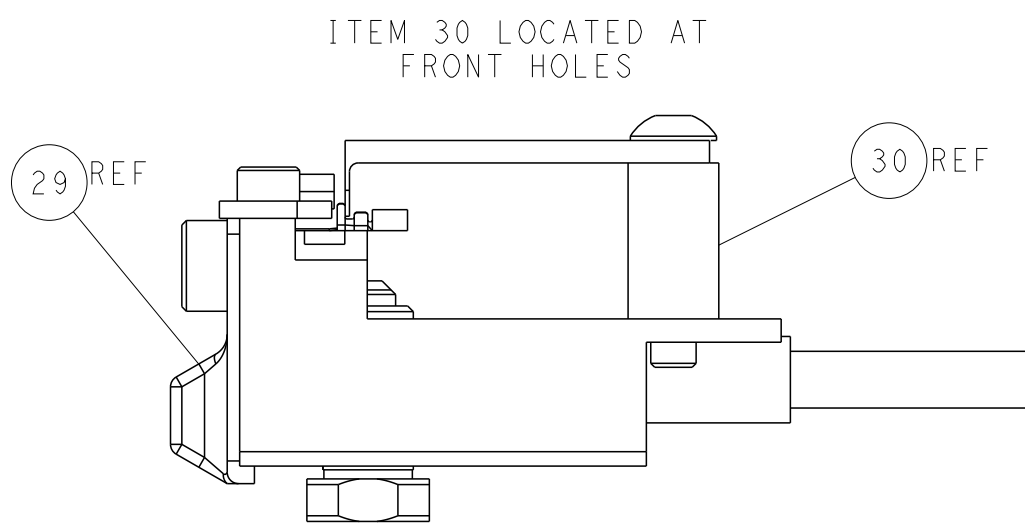
PNEUMATIC



TERMINAL SUPPORT LOCATION

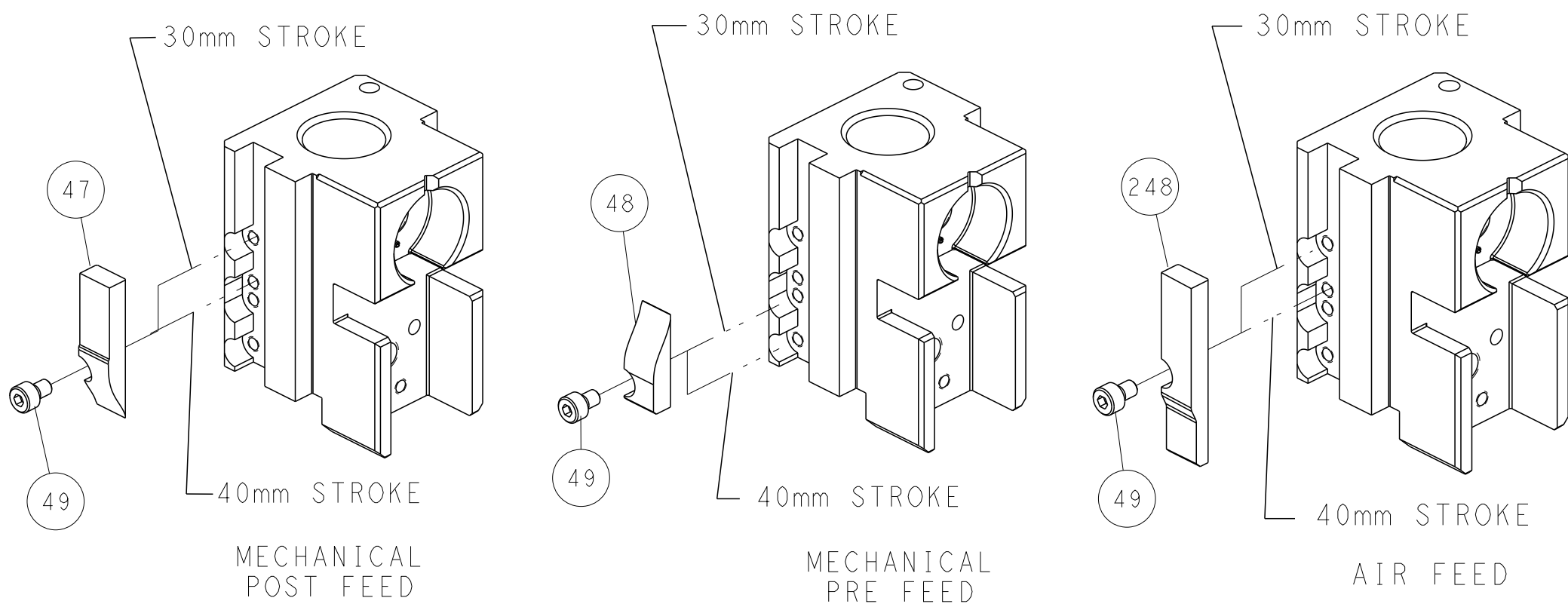


RAM & HOLDDOWN SET-UP



FEED TRACK POSITION
GUIDE BY INSULATION BARREL

CAM POSITIONS



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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DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		NAME Ocean Side Feed Applicator	
0 PLC 1 PLC 2 PLC 3 PLC 4 PLC		± ± ± ± ±		PRODUCT SPEC	
MATERIAL -		FINISH -		APPLICATION SPEC	
				SIZE A1	
				CAGE CODE 00779	
				DRAWING NO C-2151865	
				RESTRICTED TO -	
				CUSTOMER DRAWING	
				SCALE 1:2	
				SHEET 2 of 4	
				REV G	

SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2151865-1	G	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2151865-2	G	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151865-7	D	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.27 mm [.050]	F
INSUL	1.45 mm [.057]	F
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: HIROSE TERMINAL HIROSE CRIMP SPECIFICATION			
TERMINAL NAME: CRIMPING CONTACT for SOCKET			
WIRE STRIP LENGTH 1.70-2.30 mm [.067-.091 IN]		INSULATION DIAMETER RANGE Ø1.20-1.45 mm [.047-.057 IN]	
TERMINAL APPLICATION SPECIFICATION	039527-5-11	-	-
TERMINALS APPLIED			
TE TERMINAL	HIROSE TERMINAL	TE TERMINAL	HIROSE TERMINAL
1572122-1	DF11-22SCF	1572122-2	DF11-22SCFA

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
22 AWG	0.67+/-0.03 [.026+/- .001]	9.5



- 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. APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 180.
- 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.

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	-	2119640-1	PUSH ROD, AIR FEED	250
-	1	-	1803259-1	BUSHING, FLANGED	249
-	1	1	2119082-4	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
3	-	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	-	2063440-1	AIR FEED MODULE	238
3	-	1	1-1752354-4	STANDOFF,HOLD-DOWN	180
-	1	1	9931111-1	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
-	2	-	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172
-	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	1	-	240638-1	SPRING, FEED FINGER	163
-	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	-	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854	137
-	1	-	2119799-1	HOLDER,FEED FINGER, AF	136
5	-	1	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113
-	1	1	2844908-1	SCREW, LOCKING	99
-	1	1	2844907-1	POST, LOCKING	98
-	1	1	1-455888-3	SPACER, CRIMPER	82
-	1	1	22278-8	SPRING, COMPRESSION	77
-	1	1	854769-4	HOLDER, INS	74
-	1	1	1803607-1	DOCUMENTATION PACKAGE	71
-	1	1	2119791-9	DEPRESSOR, WIRE	70
-	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	1-2079383-0	SCR, BHSC, RoHS (M3 X 6)	53
-	1	1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52
-	1	1	1901681-8	HOLDDOWN, TERMINAL	51
-	1	1	1-1633764-5	HOLD DOWN, TERMINAL	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	2-1752356-5	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	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	2119533-9	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	1803095-3	FLOATING SHEAR, FRONT -	9
1	1	1	1803335-3	ANVIL, COMBINATION	8
-	-	-	-	-	7
-	-	-	-	-	6
-	1	1	2119780-2	DEPRESSOR, SHEAR	5
-	1	1	2-238011-0	BLOCK, CRIMPER SPACER	4
1	1	1	1-1803326-3	CRIMPER, INSULATION F	3
-	1	1	455888-4	SPACER, CRIMPER	2
1	1	1	1-1803323-1	CRIMPER, WIRE PREMIUM	1

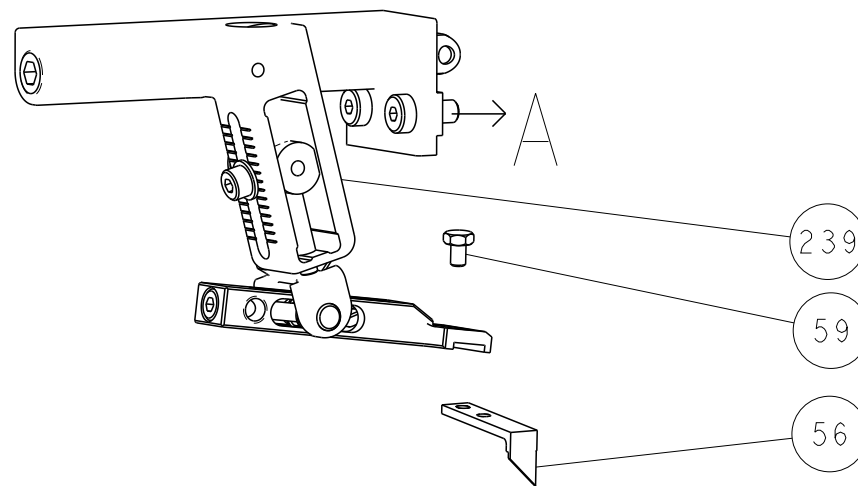
-77	-22	-21	PART NO	DESCRIPTION	ITEM NO
THIS DOCUMENT IS A CONTROLLED DOCUMENT AND THE INFORMATION CONTAINED HEREIN IS THE PROPERTY OF THE COMPANY. IT IS SUBJECT TO CHANGE WITHOUT NOTICE AND THE USER SHALL BE CONTACTED FOR THE LATEST EDITION.			OWN R.O.WILSON CHK K.J.STAKEM APVD T.L.ELBIN	31JAN2013 01FEB2013 01FEB2013	TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm			NAME Ocean Side Feed Applicator		
TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH			PRODUCT SPEC APPLICATION SPEC		
MATERIAL			SIZE A1		
CUSTOMER DRAWING			SCALE 1:2		
			SHEET 3		
			OF 4		
			REV G		

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

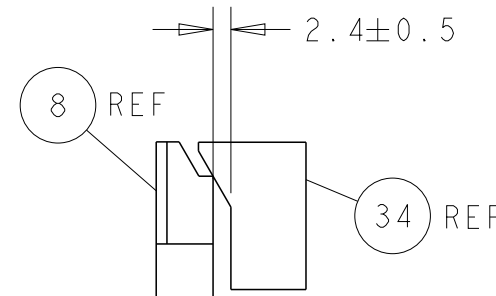
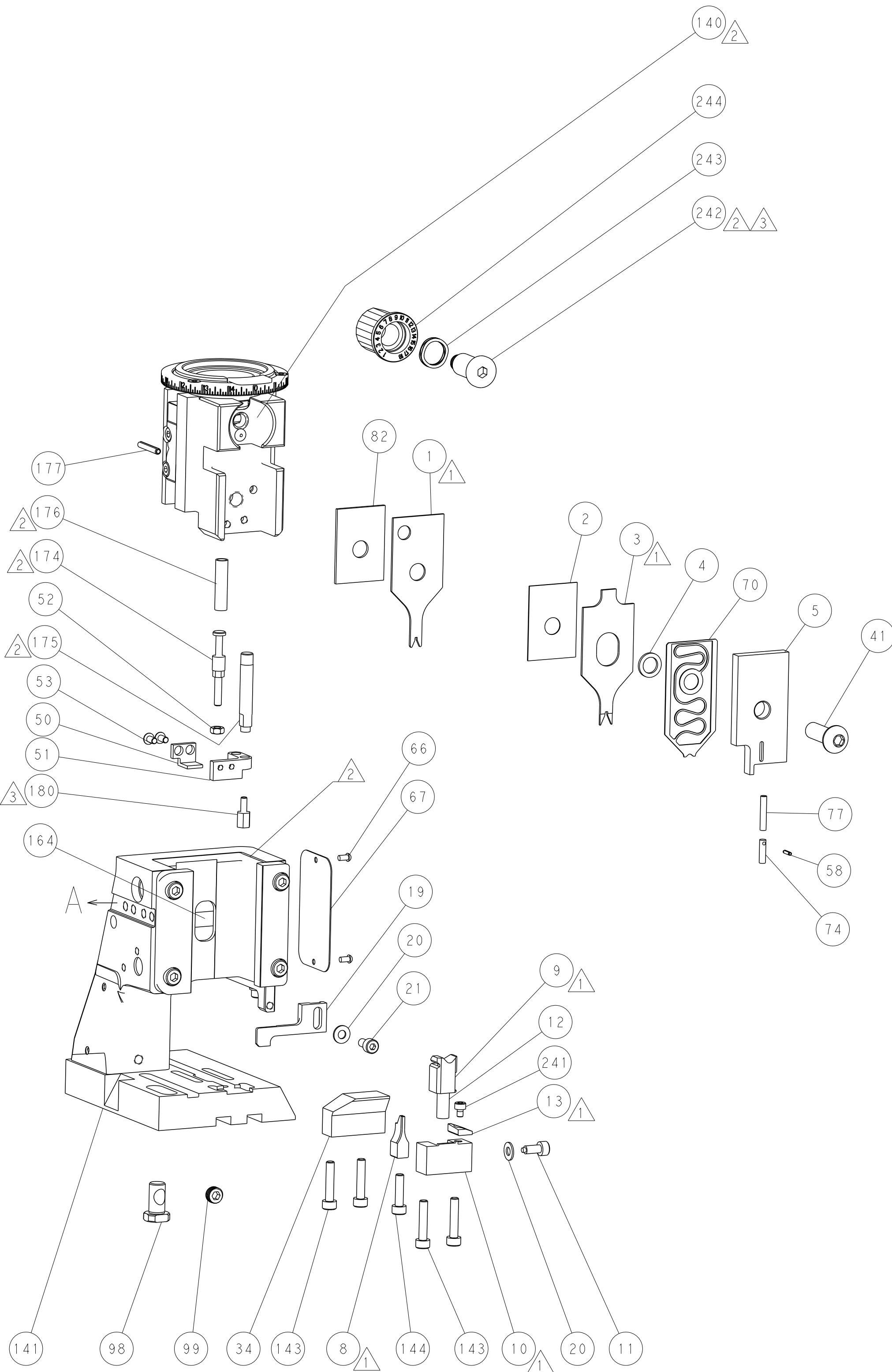
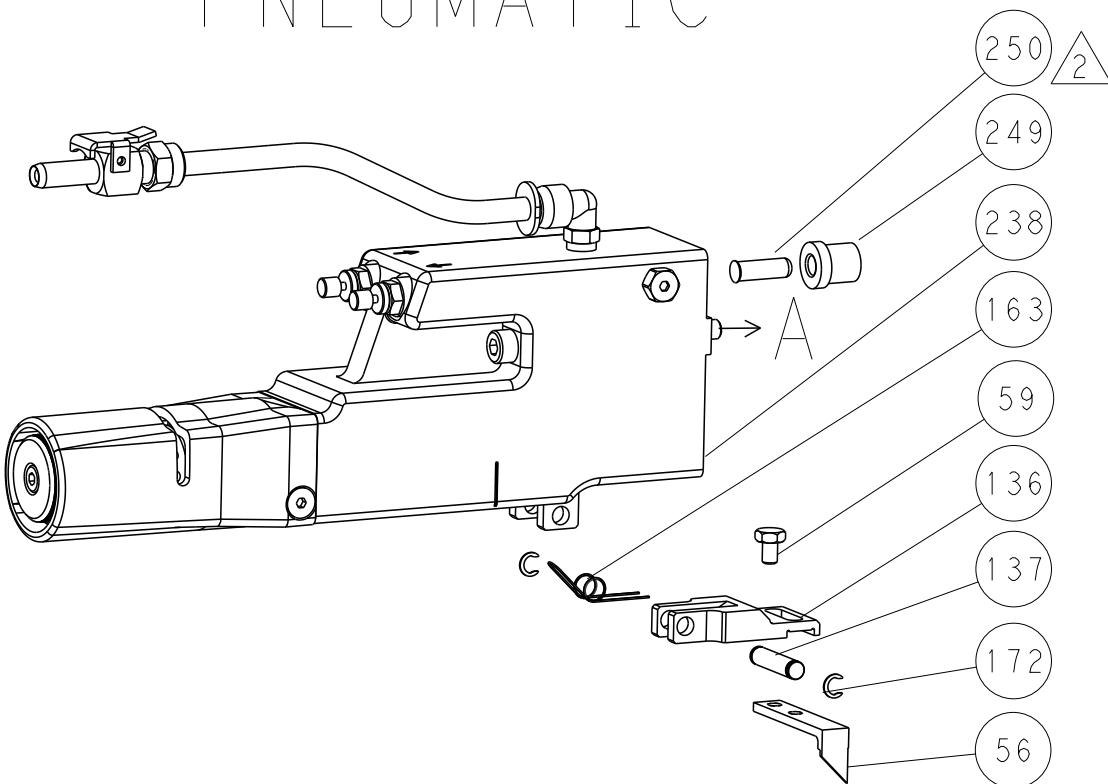
LOC		DIST		REVISIONS				
A	66	P	LTR	DESCRIPTION		DATE	DWN	APVD
		-	-	SEE SHEET 1		-	-	-

FEED TYPE

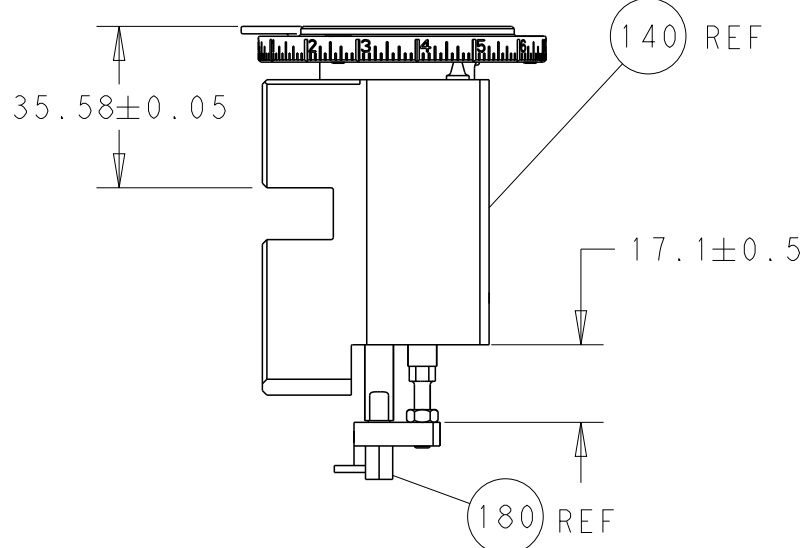
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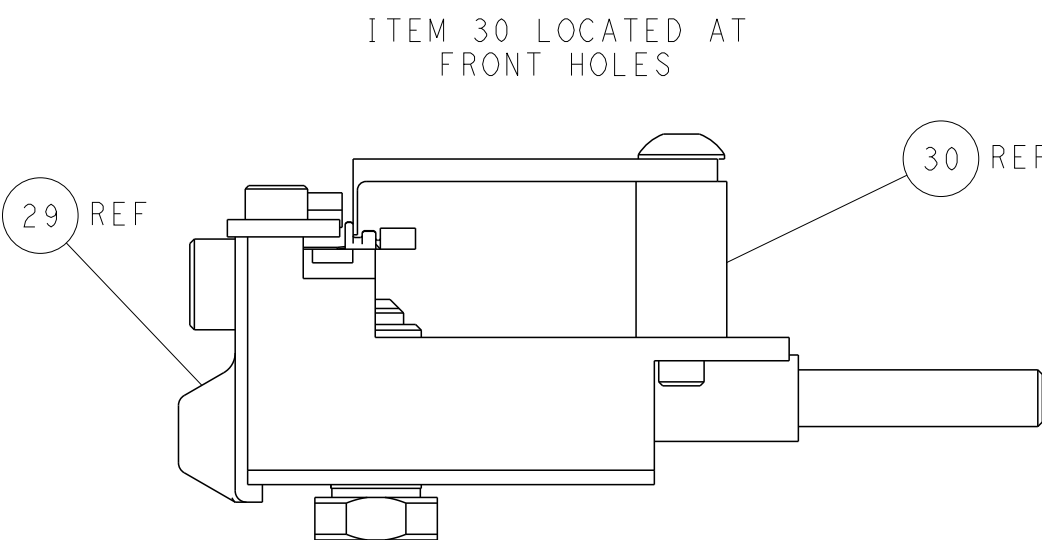
PNEUMATIC



TERMINAL SUPPORT LOCATION

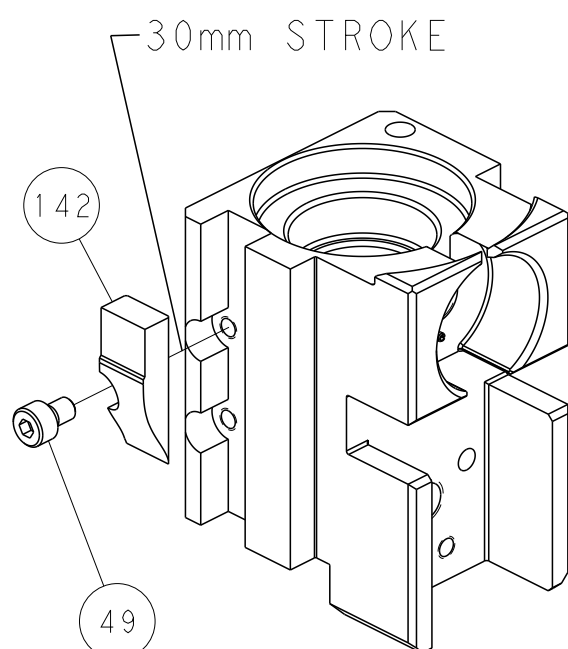


RAM & HOLDDOWN SET-UP

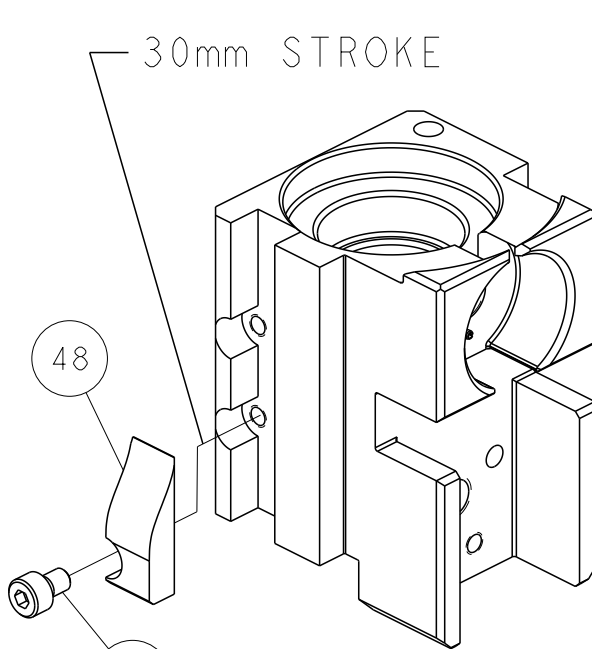


FEED TRACK POSITION GUIDE BY INSULATION BARREL

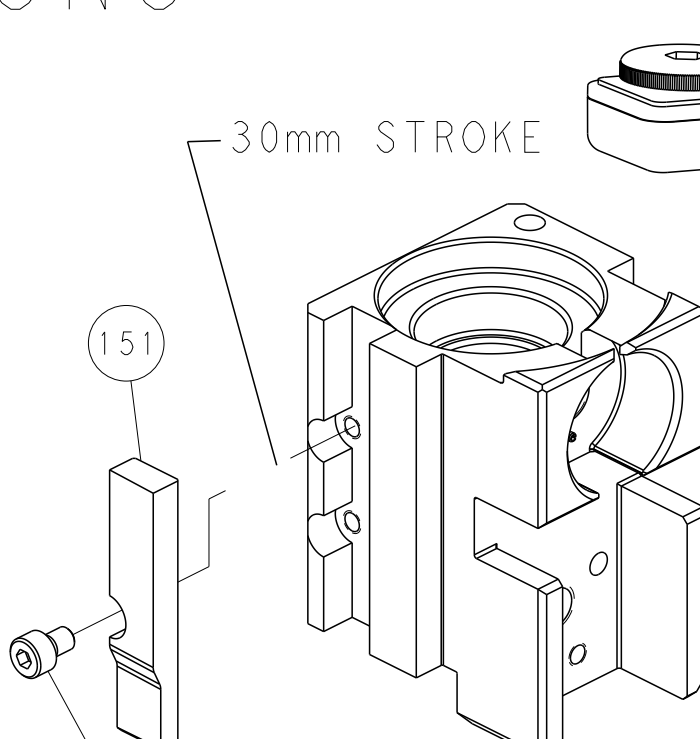
CAM POSITIONS



MECHANICAL POST FEED



MECHANICAL PRE FEED



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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DIMENSIONS:				TOLERANCES UNLESS OTHERWISE SPECIFIED:		PRODUCT SPEC		APPLICATION SPEC		SIZE	
mm				0 PLC ±		1 PLC ±		2 PLC ±		3 PLC ±	
				4 PLC ±		5 PLC ±		6 PLC ±		7 PLC ±	
				ANGLES		FINISH		WEIGHT		SCALE	
MATERIAL				-		-		-		1:2	
CUSTOMER DRAWING				-		-		-		SHEET 4 OF 4	
										REV G	

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