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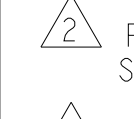
PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151023-1	G	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2151023-2	H	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
5-2151023-1	G	SEAL STRIPPER CRIMPER TERMINATING UNIT	MECHANICAL
5-2151023-2	H	SEAL STRIPPER CRIMPER TERMINATING UNIT	PNEUMATIC
7-2151023-1	G	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2151023-2	H	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2151023-7	A	CRIMP TOOLING KIT	-

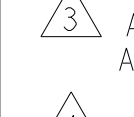
APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.03 mm [.080]	F
INSUL	3.05 mm [1.20]	O
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: PIN ASSEMBLY .062 TYPE			
WIRE STRIP LENGTH .141-.171 IN [3.58-4.34 mm]		INSULATION DIAMETER RANGE Ø.080-.100 IN [2.03-2.54 mm]	
TERMINAL APPLICATION SPECIFICATION			
(A)114-10004		-	
(B)114-10007		-	
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
(A) 66098-6	(A) 66098-7	(A) 66098-8	(A) 66098-9
(A) 66100-6	(A) 66100-7	(A) 66100-8	(A) 66100-9
(B) 66579-2	(B) 66579-4	(B) 66579-7	(B) 66580-2
(B) 66580-4	(B) 66580-7	(A) 1-66098-8	(A) 1-66100-9

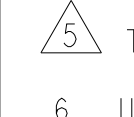
WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
16 AWG OR 1.50mm2	1.42+/-0.05 [.056+/- .002]	3.6
18 AWG	1.30+/-0.05 [.051+/- .002]	4.9
0.75mm or 1.00mm	1.30+/-0.05 [.051+/- .002]	4.9

- 

RECOMMENDED SPARE PARTS
- 

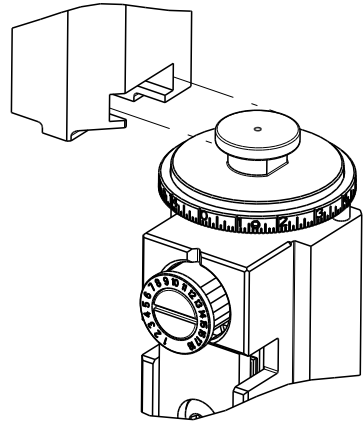
REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- 

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

TERMINAL LUBRICANT IS RECOMMENDED.
6. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.

ATLANTIC VERSION TERMINATOR
INTERFACE ADAPTER



TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: STRIP ASSY .062 SOCKET TYPE			
WIRE STRIP LENGTH .141-.171 IN [3.58-4.34 mm]		 INSULATION DIAMETER RANGE Ø.080-.100 IN [2.03-2.54 mm]	
TERMINAL APPLICATION SPECIFICATION	-	-	-
 (C)114-19000	-	-	-
TERMINALS APPLIED 			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
(C) 163081-7	(C) 163081-8	(C) 1-163081-1	(C) 1-163081-3
(C) 1-163081-5	(C) 1-163081-7	(C) 163083-7	(C) 163083-8
(C) 1-163083-1	(C) 1-163083-2	(C) 1-163083-4	(C) 163766-1
(C) 163766-2	(C) 163766-4	(C) 163767-4	(C) 163767-5
(C) 164161-3	(C) 164161-4	(C) 164161-7	(C) 164161-9
(C) 1-164161-1	(C) 1-164161-3	(C) 1-164161-5	(C) 1-164161-7

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
16 AWG OR 1.50mm2	1.40+/-0.05 [.055+/- .002]	3.8
1.00mm2	1.32+/-0.05 [.052+/- .002]	4.7
18 AWG OR 0.75mm2	1.27+/-0.05 [.050+/- .002]	5.1

*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.

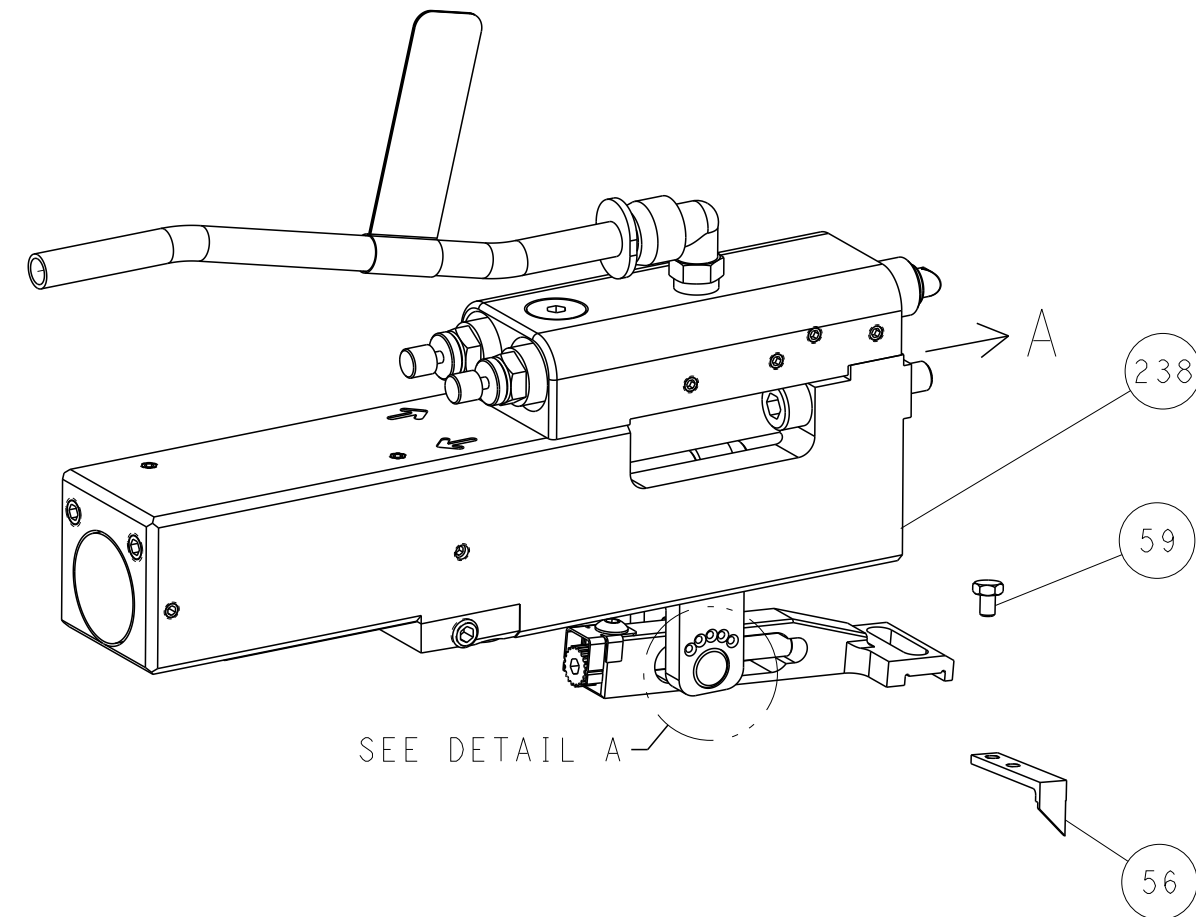
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

2		1						
LOC	DIST	REVISIONS						
A	66	P	LTR	DESCRIPTION		DATE	DWN	APVD
		E		ECR-17-009013		22JUNE2017	TB	TE
		F		ECR-17-010757		25JUL2017	YY	CT
		G		ECR-18-007495		18MAY2018	JAH	JDG
		H		ECR-20-014625		15OCT2020	TB	RK

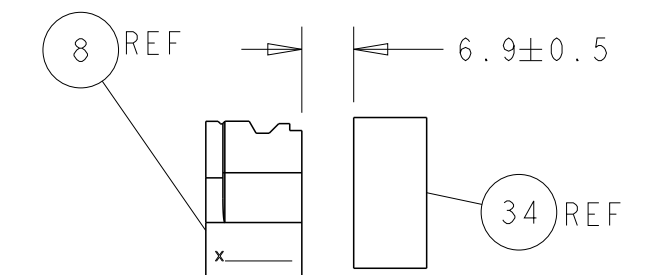
-	-	-	1	1	-	-	1803515-3	RAM ASSEMBLY, SF ATLANTIC	293
-	-	-	1	1	-	-	2-1803583-1	APPLICATOR BASIC ASSEMBLY, SF	292
-	1	-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248
-	1	1	1	1	1	1	2119082-4	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	1	1	1	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
-	-	1	-	1	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	1	-	1	-	1	-	2844940-1	AIR FEED MODULE	238
-	-	-	1	1	-	-	4-1722335-3	STRIPPER, SIDE FEED	182
-	-	-	1	1	-	-	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	181
-	-	-	1	1	-	-	2-1752354-3	STANDOFF,HOLD-DOWN	180
-	-	-	1	1	-	-	993111-1	PIN, SLOTTED SPRING 3.0 X 20.0	177
-	-	-	1	1	-	-	5-22280-0	SPRING, COMPRESSION	176
-	-	-	1	1	-	-	1752353-3	GUIDE PIN,HOLDDOWN	175
-	-	-	1	1	-	-	1901680-2	GUIDE PIN,HOLDDOWN	174
-	REF	REF	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	1	1	1	1	1	1	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113
-	1	1	1	1	1	1	2844908-1	SCREW, LOCKING	99
-	1	1	1	1	1	1	2844907-1	POST, LOCKING	98
-	1	1	1	1	1	1	455888-5	SPACER, CRIMPER	82
-	1	1	1	1	1	1	5-547505-2	SPRING, COMPRESSION	77
-	1	1	1	1	1	1	854769-4	HOLDER, INS	74
-	1	1	1	1	1	1	1803607-3	DOCUMENTATION PACKAGE	71
-	1	1	1	1	1	1	2119740-1	TAG,IDENTIFICATION	67
-	2	2	2	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	1	1	1	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	60
-	1	1	1	1	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	1	1	1	1	1	1	21028-2	PIN, SLOTTED SPRING .062 X .250	58
-	1	1	1	1	1	1	1338685-1	PAWL, FEED	56
-	4	4	4	4	4	4	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	54
-	2	2	2	2	2	2	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	53
-	1	1	1	1	1	1	5018030-1	NUT, HEX, REG, RoHS, M3	52
-	1	1	1	1	1	1	811242-5	BUMPER, HOLD DOWN	51
-	1	1	1	1	1	1	690753-2	SPACER, TONKER	50
-	1	2	1	2	1	2	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	-	1	-	1	-	1	2119652-1	FEED CAM, PRE FEED	48
-	-	1	-	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	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
-	1	1	1	1	1	1	1752356-2	SUPPORT, TERMINAL	34
-	2	2	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	2	2	2	2	2-2844962-8	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	1	1	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29
-	1	1	1	1	1	1	455888-3	SPACER, CRIMPER	28
-	1	1	1	1	1	1	1320928-6	STRIP GUIDE	24
-	1	1	-	-	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
-	2	2	1	1	2	2	1-18028-2	WASHER, FLAT, REG M4	20
-	1	1	-	-	1	1	2119533-1	STRIPPER, SIDE FEED	19
-	1	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	1-356885-4	STOP, SHEAR	11
-	1	1	1	1	1	1	2119805-1	SHEAR HOLDER, FRONT	10
-	1	1	1	1	1	1	1803095-1	FLOATING SHEAR, FRONT -	9
1	2	2	1	1	1	1	1333228-1	ANVIL	8
-	1	1	1	1	1	1	240641-3	SPACER	7
-	-	-	-	-	-	-	-	-	6
-	1	1	1	1	1	1	2119780-9	DEPRESSOR, SHEAR	5
-	1	1	1	1	1	1	2-238011-2	BLOCK, CRIMPER SPACER	4
1	2	2	1	1	1	1	2119784-7	CRIMPER, INSULATION O PREMIUM	3
-	1	1	1	1	1	1	455888-2	SPACER, CRIMPER	2
1	2	2	1	1	1	1	1-456405-5	CRIMPER, WIRE PREMIUM	1

-77	-72	-71	-52	-51	-2	-1	PART NO	DESCRIPTION	ITEM NO
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DIMENSIONS:							CHK S. XI 16NOV2011	NAME	
mm							APVD J. CRUZ 16NOV2011	Ocean Side Feed Applicator	
0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±							PRODUCT SPEC	SIZE	
MATERIAL							APPLICATION SPEC	CAGE CODE	
-							WEIGHT	DRAWING NO	
-							Customer Accessible Production Drawing	A1 00779 ©=2151023	
-							SCALE	SHEET 1 OF 4	
-							REV	H	

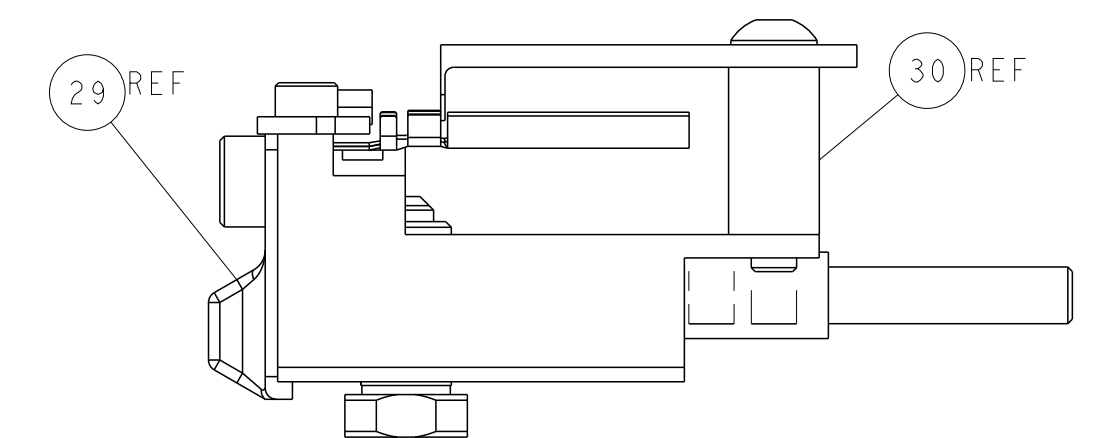
PNEUMATIC



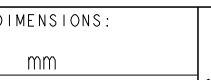
CAM POSITIONS



ITEM 30 LOCATED AT
REAR HOLES



FEED TRACK POSITION GUIDE BY WIRE BARREL

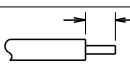
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DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		NAME Ocean Side Feed Applicator -	
		WEIGHT -		SIZE CAGE CODE DRAWING NO A1 00779 C-2151023	
MATERIAL FINISH		RESTRICTED TO -		SCALE 1:2 SHEET 2 of 4 REV H	
Customer Accessible Production Drawing					

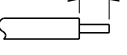
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20		20	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2151023-1	G	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2151023-2	H	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151023-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.03 mm [.080]	F
INSUL	3.05 mm [.120]	O
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: PIN ASSEMBLY .062 TYPE			
WIRE STRIP LENGTH .141-.171 IN [3.58-4.34 mm]			INSULATION DIAMETER RANGE Ø.080-.100 IN [2.03-2.54 mm]
TERMINAL APPLICATION SPECIFICATION 		(A)114-10004	-
		(B)114-10007	-
TERMINALS APPLIED 			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
(A) 66098-6	(A) 66098-7	(A) 66098-8	(A) 66098-9
(A) 66100-6	(A) 66100-7	(A) 66100-8	(A) 66100-9
(B) 66579-2	(B) 66579-4	(B) 66579-7	(B) 66580-2
(B) 66580-4	(B) 66580-7	(A) 1-66098-8	(A) 1-66100-9
WIRE SIZE 	CRIMP HEIGHT mm [INCH] 		CRIMP HEIGHT REFERENCE SETTING 
16 AWG OR 1.50mm ²	1.42+/- 0.05 [.056+/- .002]		3.6
18 AWG	1.30+/- 0.05 [.051+/- .002]		4.9
0.75mm or 1.00mm	1.30+/- 0.05 [.051+/- .002]		4.9

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: STRIP ASSY .062 SOCKET TYPE			
WIRE STRIP LENGTH .141-.171 IN [3.58-4.34 mm]			INSULATION DIAMETER RANGE Ø.080-.100 IN [2.03-2.54 mm]
TERMINAL APPLICATION SPECIFICATION		-	-
(C)114-19000		-	-
TERMINALS APPLIED 			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
(C) 1-163081-7	(C) 1-163081-8	(C) 1-163081-1	(C) 1-163081-3
(C) 1-163081-5	(C) 1-163081-7	(C) 1-163083-7	(C) 1-163083-8
(C) 1-163083-1	(C) 1-163083-2	(C) 1-163083-4	(C) 1-163766-1
(C) 1-163766-2	(C) 1-163766-4	(C) 1-163767-4	(C) 1-163767-5
(C) 1-164161-3	(C) 1-164161-4	(C) 1-164161-7	(C) 1-164161-9
(C) 1-164161-1	(C) 1-164161-3	(C) 1-164161-5	(C) 1-164161-7
WIRE SIZE 	CRIMP HEIGHT mm [INCH] 	CRIMP HEIGHT REFERENCE SETTING 	
16 AWG OR 1.50mm2	1.40+/- .05 [.055+/- .002]	3.8	
1.00mm2	1.32+/- .05 [.052+/- .002]	4.7	
18 AWG OR 0.75mm2	1.27+/- .05 [.050+/- .002]	5.1	



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

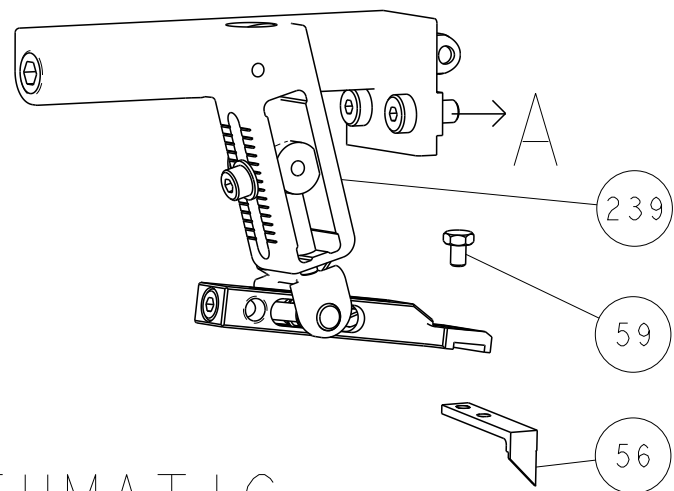
-	1	1	2119082-4	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
-	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	1	-	2844940-1	AIR FEED MODULE	238
-	REF	REF	994970-2	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	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113
-	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	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	53
-	1	1	5018030-1	NUT, HEX, REG, RoHS, M3	52
-	1	1	811242-5	BUMPER, HOLD DOWN	51
-	1	1	690753-2	SPACER, TONKER	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	1752356-2	SUPPORT, TERMINAL	34
-	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	2-2844962-8	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29
-	1	1	455888-3	SPACER, CRIMPER	28
-	1	1	1320928-6	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	1803095-1	FLOATING SHEAR, FRONT -	9
-	1	1	1333228-1	ANVIL	8
-	1	1	240641-3	SPACER	7
-	-	-	-	-	6
-	1	1	2119780-9	DEPRESSOR, SHEAR	5
-	1	1	2-238011-2	BLOCK, CRIMPER SPACER	4
-	1	1	2119784-7	CRIMPER, INSULATION O PREMIUM	3
-	1	1	455888-2	SPACER, CRIMPER	2
-	1	1	1-456405-5	CRIMPER, WIRE PREMIUM	1

-77	-22	-21	PART NO	DESCRIPTION	ITEM NO
			TE Connectivity Harrisburg, PA 17105-3608		
			Ocean Side Feed Applicator		
			-		
			SIZE CASE CODE DRAWING NO RESTRICTED TO		
			A1 00779 C=2151023		
			Customer Accessible Production Drawing		
			SCALE 1:2 SHEET 3 OF 4 REV H		

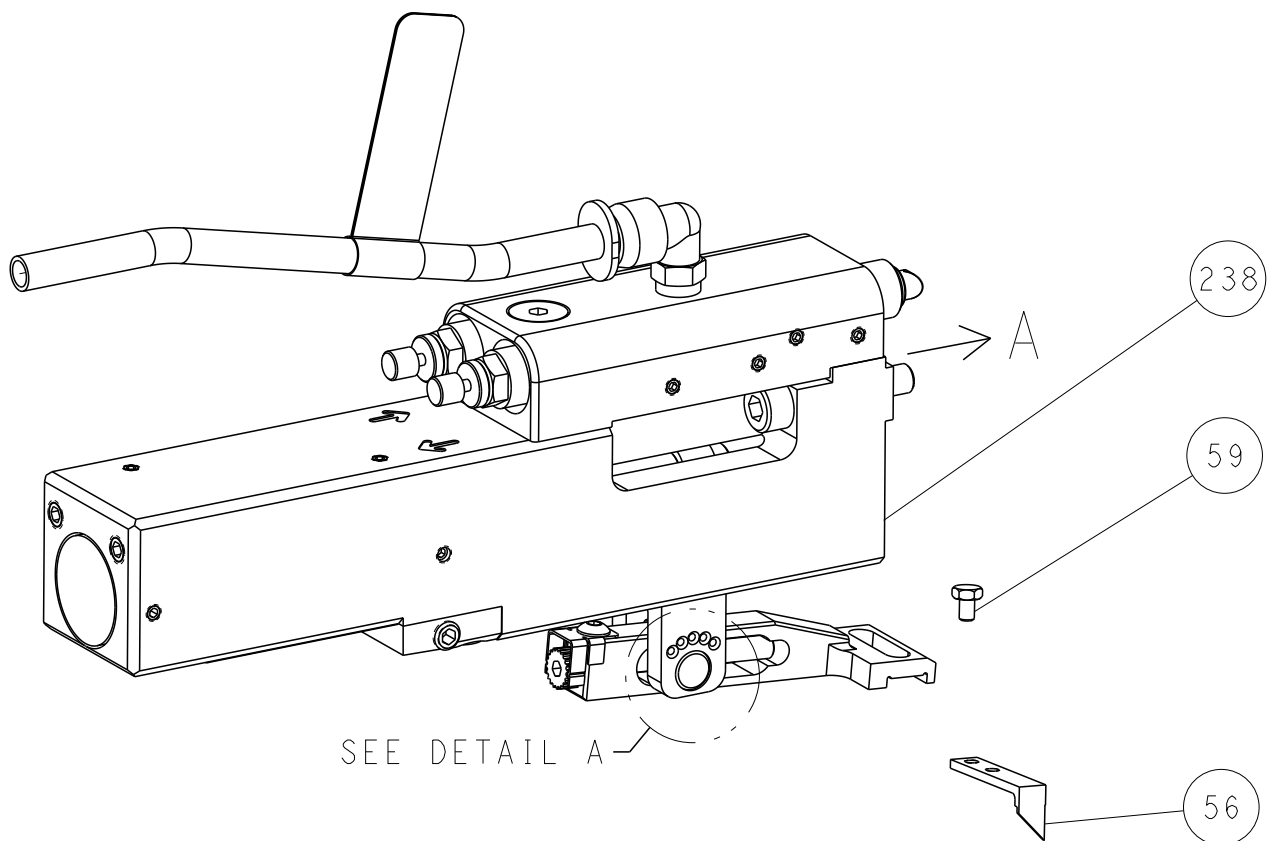
SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

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

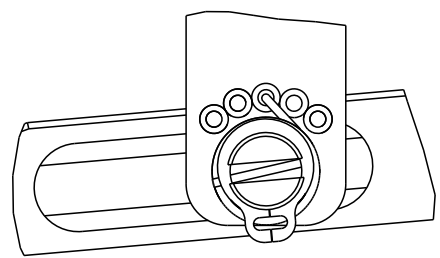
FEED TYPE
MECHANICAL



PNEUMATIC

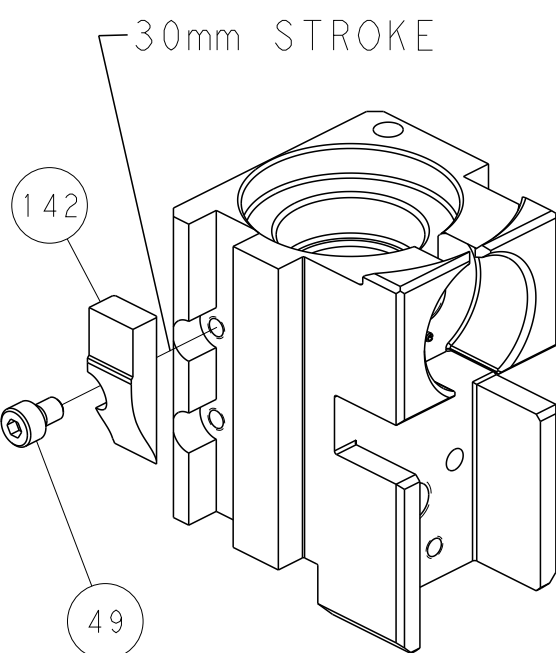


FEED SPRING SETTING POSITION
(SHOWN FROM REAR SIDE)

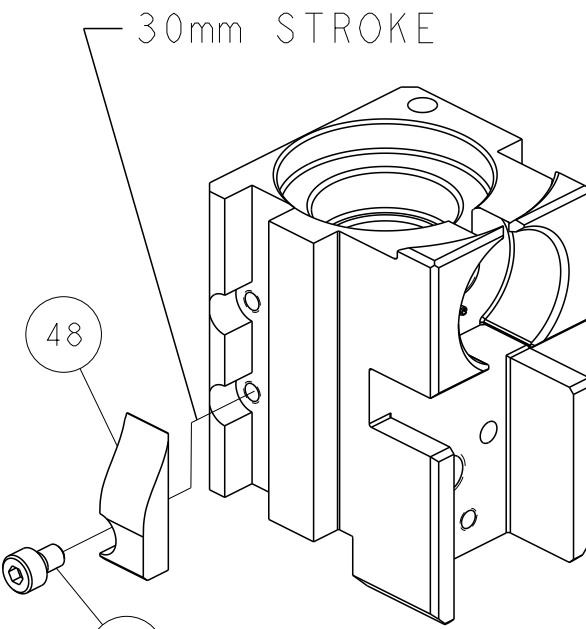


DETAIL A

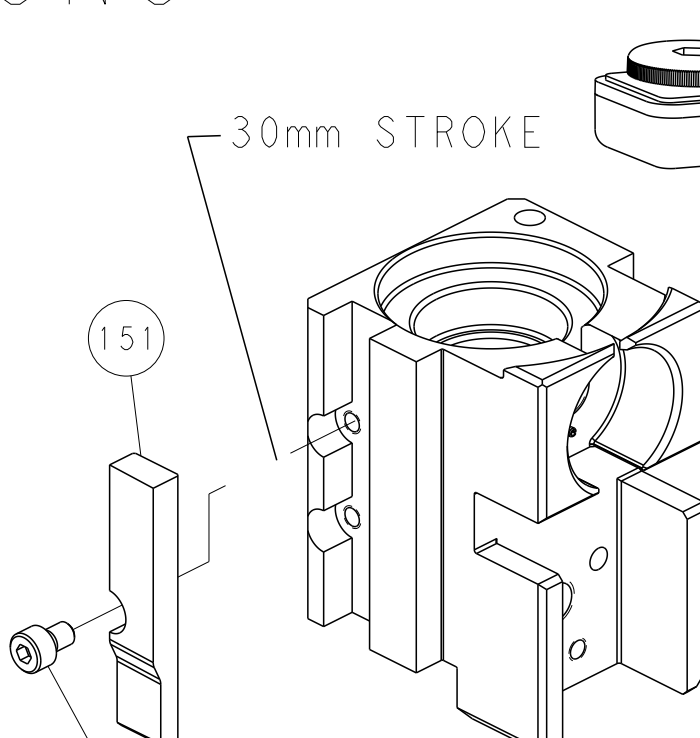
CAM POSITIONS



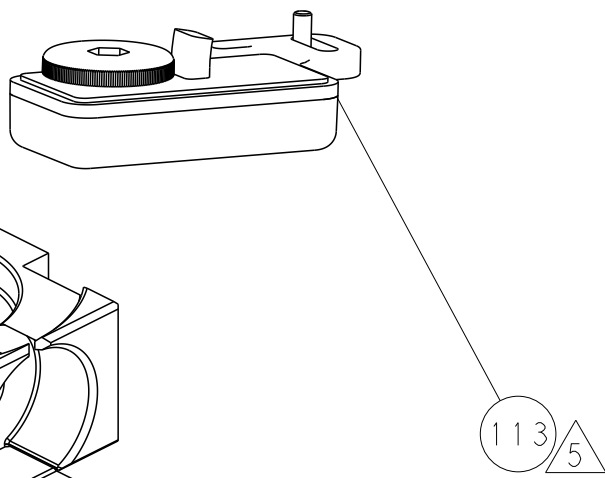
MECHANICAL
POST FEED



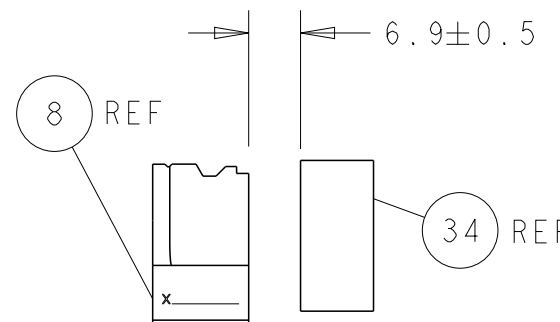
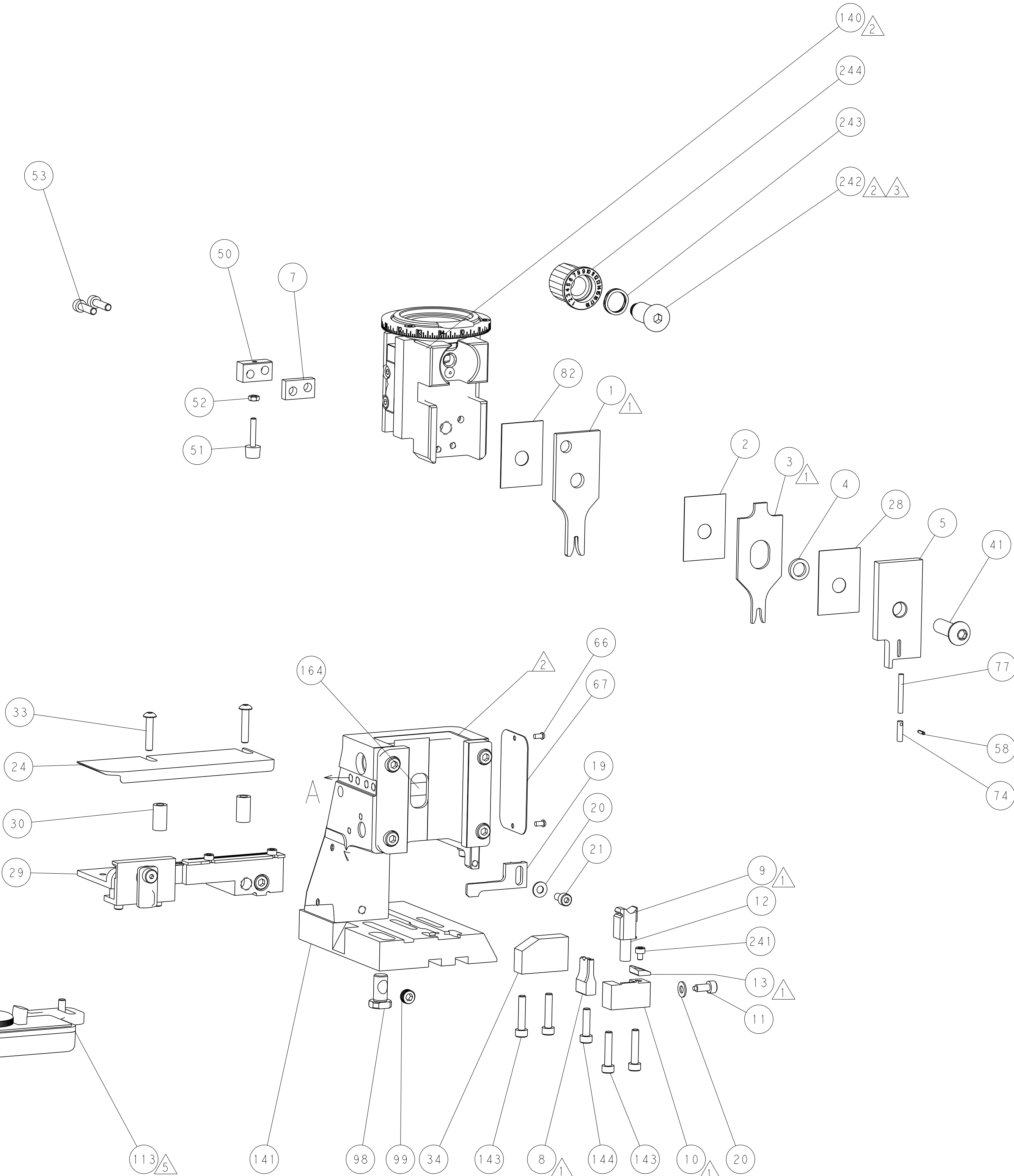
MECHANICAL
PRE FEED



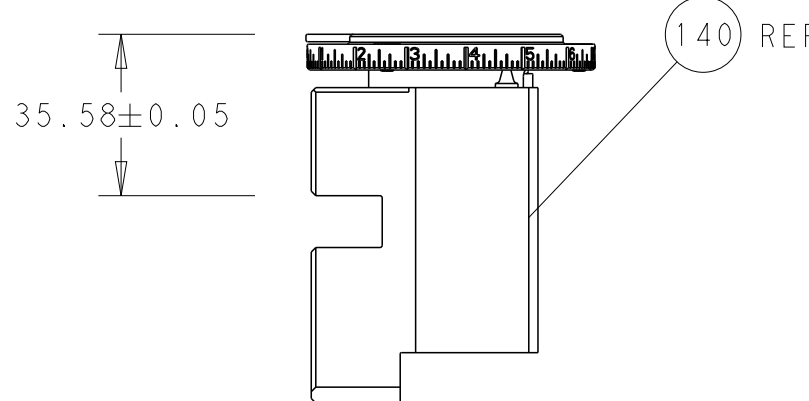
AIR FEED



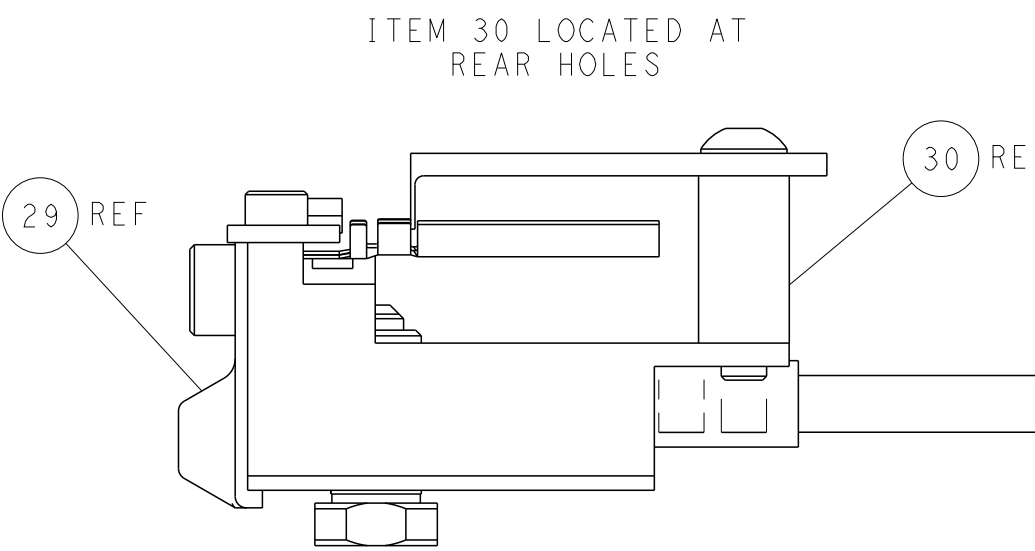
PACIFIC VERSION
Shown on sheets 3 of 4 & 4 of 4
(Atlantic version shown on sheets 1 of 4 & 2 of 4)



TERMINAL SUPPORT LOCATION



RAM SET-UP



FEED TRACK POSITION
GUIDE BY WIRE BARREL

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DIMENSIONS: mm		CHK S. XI	16NOV2011		
TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH -		APVD J. CRUZ	16NOV2011	NAME Ocean Side Feed Applicator	
MATERIAL -		PRODUCT SPEC APPLICATION SPEC		SIZE A1	
		WEIGHT -		CAGE CODE 00779	
		Customer Accessible Production Drawing		SCALE 1:2	
				SHEET 4	
				OF 4	
				REV H	

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

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