

8

7

THIS DRAWING IS UNPUBLISHED.

RELEASED FOR PUBLICATION

2011

© COPYRIGHT 2011

BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.

PART NUMBER

REVISION

DESCRIPTION

FEED TYPE

2151034-2

J

FINE CRIMP HEIGHT ADJUST

PNEUMATIC

7-2151034-2

J

PNEUMATIC AND CRIMP TOOLING KIT

PNEUMATIC

7-2151034-7

A

CRIMP TOOLING KIT

-

APPLICATOR DATA

CRIMP

SIZE

TYPE

WIRE

.176 [4.47 mm]

Ø

INSUL

-

-

APPLICATOR INSTRUCTIONS

408-35042

TERMINAL DATA: TE TERMINAL

TE CRIMP SPECIFICATION

TERMINAL NAME: FULLY INSULATED FASTON

WIRE STRIP LENGTH

INSULATION DIAMETER RANGE

.265-.297 IN [6.73-7.54 mm]

Ø

TERMINAL APPLICATION SPECIFICATION

114-2123

-

-

-

-

-

-

TERMINALS APPLIED

TE TERMINAL

TE TERMINAL

TE TERMINAL

TE TERMINAL

2-520102-1

5-520183-2

2-520274-2

2-520102-2

9-520183-2

2-521144-2

2-520181-2

2-520193-2

2-520261-2

2-520181-4

9-520193-2

9-520261-2

5-520181-2

2-521102-2

2-520263-2

9-520181-2

2-521104-2

2-520263-4

2-520183-2

2-521308-2

5-520263-2

2-520183-4

2-521406-2

GROUP 1

GROUP 2

WIRE SIZE

CRIMP HEIGHT INCH [mm]

CRIMP HEIGHT REFERENCE SETTING

Ø SOLDER

18, (2)22, or (1)20+(1)22

0.070+/-0.002 [1.78+/-0.05]

6.4

.125 IN [3.175mm]

20 or 22

0.065+/-0.002 [1.65+/-0.05]

8.3

.125 IN [3.175mm]

RECOMMENDED SPARE PARTS

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

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.

TO CONVERT THE APPLICATOR TO A NON-CARRIER CUTTING STYLE, REMOVE ITEM 13 AND ATTACH TO THE LOCATION ON THE BACK SIDE OF THE HOUSING. REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.

ITEM 7 MUST BE REMOVED IF APPLICATOR IS USED ON BENCH MACHINE.

ITEMS 5 AND 9 OR ITEMS 10 AND 22 ARE REQUIRED WHEN RUNNING ON A LEADMAKER. ITEM 42 OR 43 REQUIRED WHEN RUNNING ON A BENCH MACHINE.

FEED ADJUSTMENT MAY BE REQUIRED WHEN SWITCHING TERMINALS.

GROUP 1 TERMINALS: Ø.135 IN [3.43mm] MAX INSULATION
GROUP 2 TERMINALS: Ø.200 IN [5.08mm] MAX INSULATION

USE ITEMS 5, 9, OR 42 WITH GROUP 1 TERMINALS
USE ITEMS 10, 22, OR 43 WITH GROUP 2 TERMINALS

TO CHECK CRIMP HEIGHT, CRIMP SOLDER (Ø.12 IN [3.05mm] 60/40 SOLID CORE) AND MEASURE AT CENTER OF SLUG.

IT MAY BE NECESSARY TO MODIFY THE T-TERMINATING/K-PRESS BASE PLATE BEFORE USE BY ADDING A 10-32 HOLE TO RELOCATE THE FORWARD STOP AS SHOWN.

ITEMS 253 AND 255 MUST BE INSTALLED IN THE G-TERMINATING UNIT CHIP RELIEF HOLE BEFORE INSTALLING THE APPLICATOR.

ITEM 257, REQUIRED IF APPLICATOR IS RUN ON T-TERMINATING UNIT/K-PRESS. GUARD, ITEM 256, REQUIRED IF APPLICATOR IS BEING USED ON G-TERMINATOR.

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER

ATLANTIC VERSION

Shown on sheets 1 of 4 & 2 of 4

(Pacific version shown on sheets 3 of 4 & 4 of 4)

LOC

DIST

REV

A

66

REV

DATE

OWN

APPD

F

12NOV2018

JAH

CT

G

09JAN2019

FJ

YY

H

23JAN2019

MZ

CT

J

28MAR2019

LG

TE

REF

REF

462992-5

GUARD ASSY

257

REF

REF

679532-1

INSERT, GUARD

256

1

1

189728-1

BRACKET, SPACER

255

1

1

568681-1

SPACER, BASE PLATE

253

1

1

2119641-1

FEED CAM, AIR FEED

248

1

1

18023-1

SCR, SKT HD CAP M3 X 5.0

241

1

1

2844940-2

AIR FEED MODULE

238

1

1

1-18028-0

WASHER, FLAT, REG M8

192

REF

REF

994970-2

COUNTER, MAGNETIC

164

1

1

1-22281-8

SPRING, COMPRESSION

121

1

1

2844908-1

SCREW, LOCKING

99

1

1

2844907-1

POST, LOCKING

98

1

1

1-690438-0

FRONT STRIP GUIDE

96

4

4

2168083-1

SCR, SKT HD CAP, RoHS, M3 X 8.0

95

1

1

2168083-6

SCR, SKT HD CAP, RoHS, M5 X 65

93

1

1

455888-4

SPACER, CRIMPER

82

1

1

240641-6

SPACER

81

1

1

1803607-3

DOCUMENTATION PACKAGE

71

1

1

2161332-2

DEPRESSOR, WIRE FUNNEL

70

1

1

2161331-1

SPACER, WIRE FUNNEL DEPRESSOR

69

2

2

1-18028-4

WASHER, FLAT, REG M3

68

1

1

2119740-1

TAG, IDENTIFICATION

67

2

2

2168078-1

SCREW, DRIVE, RH, RoHS, 2 x .188

66

2

2

2-18032-5

SCR, SET, FLT PNT, M5 X 20.0

61

1

1

2079383-4

SCR, BHSC, RoHS (M4 X 8)

60

1

1

5-18022-5

SCR, HEX HD CAP, M4 X 6.0

59

1

1

462427-2

FINGER, FEED

56

4

4

2168400-1

SHCS, LOW HEAD, RoHS, M4 X 12

54

2

2

2168083-8

SCR, SKT HD CAP, RoHS, M4 X 16

53

1

1

18023-9

SCR, SKT HD CAP M4 X 6.0

49

1

1

1-1803583-9

APPLICATOR BASIC ASSEMBLY, SF

46

1

1

1803515-1

RAM ASSEMBLY, SF ATLANTIC

44

1

1

462433-7

SUPPORT, INSULATION

43

1

1

462433-6

SUPPORT, INSULATION

42

1

1

1803602-1

SCR, BHSC, RoHS (M8 X 25)

41

2

2

5-22278-1

SPRING, COMPRESSION

33

2

2

1-2168083-4

SCR, SKT HD CAP, RoHS, M4 X 5

30

1

1

2161336-2

PLATE, REAR STRIP GUIDE

29

2

2

22281-9

SPRING, COMPRESSION

27

1

1

356835-1

LEVER, DRAG RELEASE

26

1

1

240792-1

DRAG, TERMINAL

25

1

1

684042-4

GUIDE, STRIP, FRONT

24

1

1

980371-4

SCR, SKT HD SHLDR 5.0 DIA X 6.0

23

1

1

462431-6

WIRE FUNNEL

22

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

463460-3

HOLD DOWN, TERMINAL

18

1

1

469542-3

REAR FLOATING SHEAR

17

4

4

1-2168083-1

SCR, SKT HD CAP, RoHS, M3 X 6

16

1

1

2161335-2

SHEAR PLATE, REAR

15

1

1

2119862-2

SHEAR HOLDER, REAR

14

1

1

2280441-1

INSERT, SHEAR

13

1

1

3-22280-3

SPRING, COMPRESSION

12

1

1

356885-4

STOP, SHEAR

11

1

1

462843-6

TERMINAL SUPPORT

10

1

1

462843-5

TERMINAL SUPPORT

9

1

2

1

464291-4

ANVIL, SAND-BLASTED 22-18

8

1

1

803925-2

GUIDE, CARRIER SCRAP

7

1

1

2-690468-5

DEPRESSOR SHEAR, REAR

6

1

1

462431-1

WIRE FUNNEL

5

1

1

238011-1

BLOCK, CRIMPER SPACER

4

1

2

1

464290-1

CRIMPER, SEMI-FLAT 22-18

1

-77-72-2

PART NO

DESCRIPTION

ITEM NO

OWN

D. WEAVER

21OCT2011

CHK

G. HOFENER

21OCT2011

APPD

T. ELBIN

21OCT2011

DIMENSIONS:

mm

0 PLC

1 PLC

2 PLC

3 PLC

4 PLC

ANGLES

FINISH

±

±

±

±

±

±

±

MATERIAL

-

NAME

OCEAN SIDE FEED APPLICATOR

SIZE

CAGE CODE

DRAWING NO

RESTRICTED TO

WEIGHT

00779

©=2151034

-

Customer Accessible Production Drawing

SCALE

1:1

SHEET

1

OF

4

REV

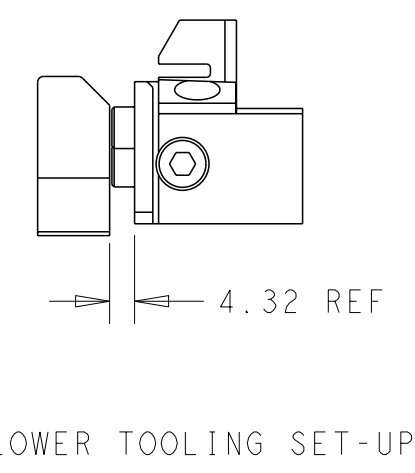
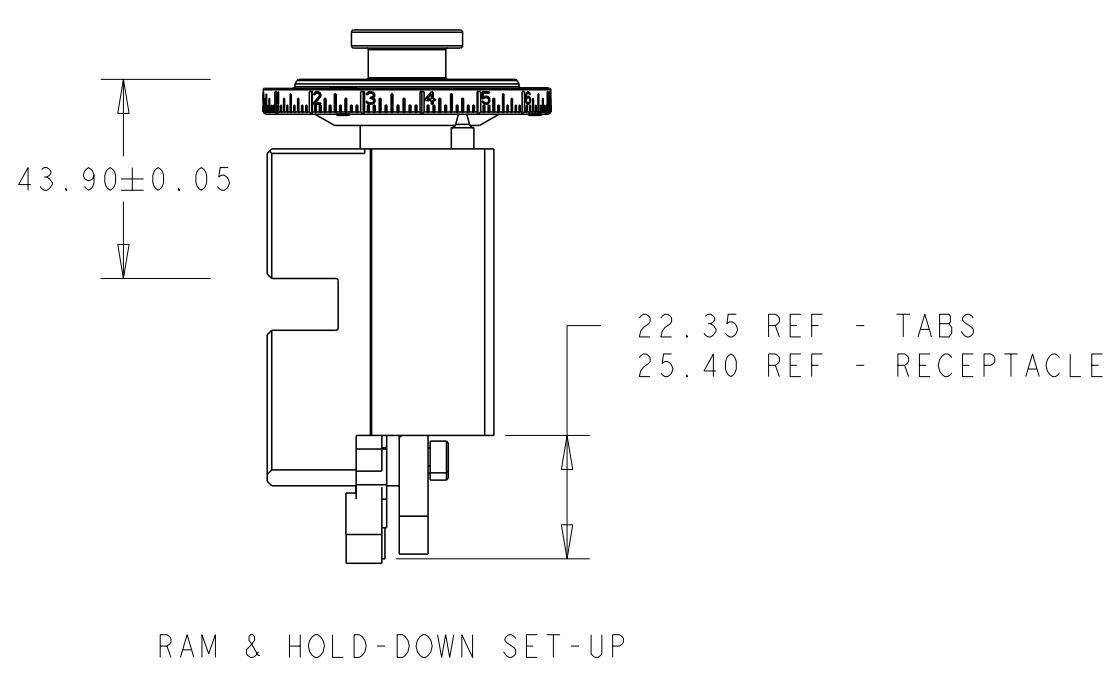
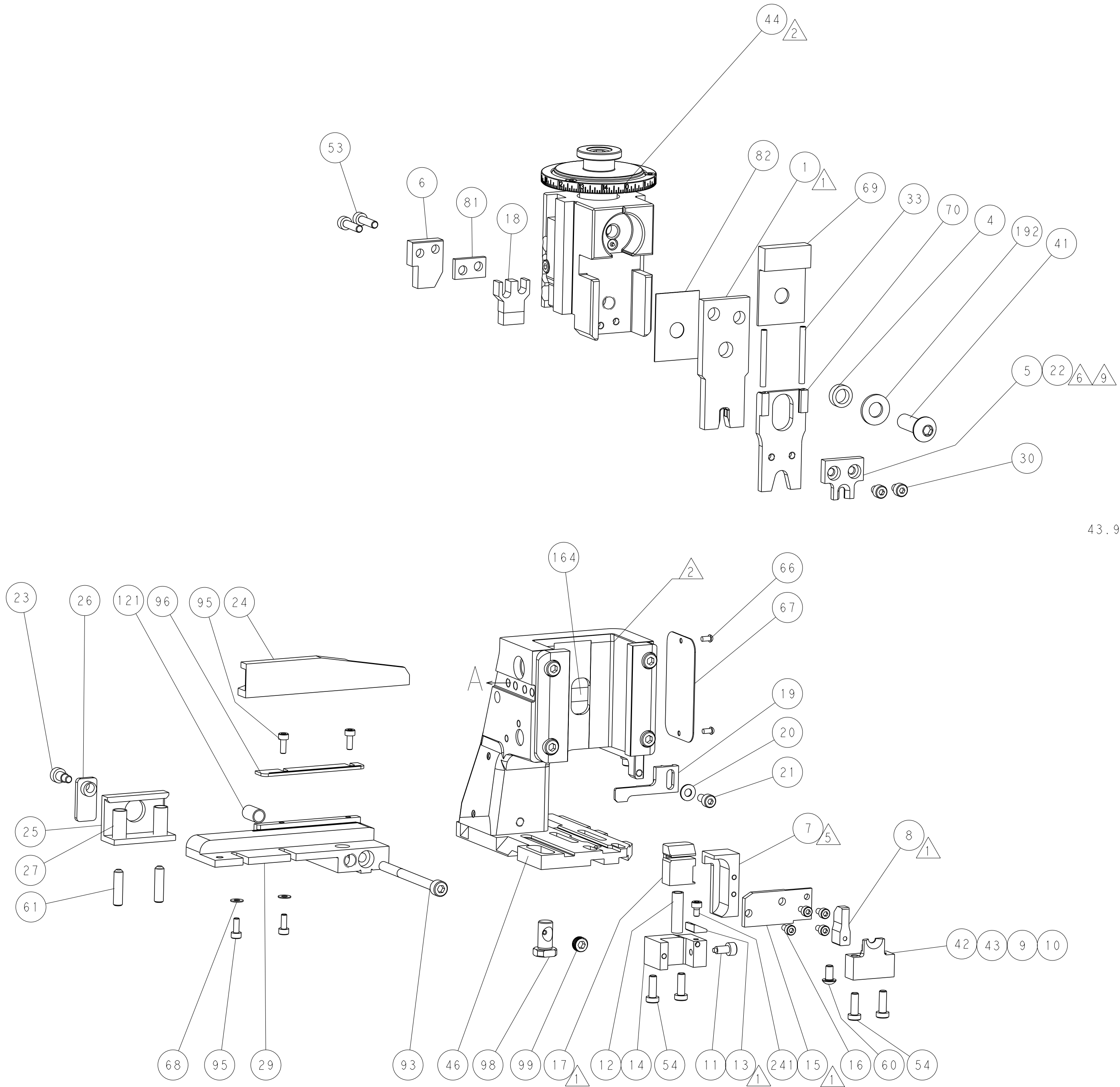
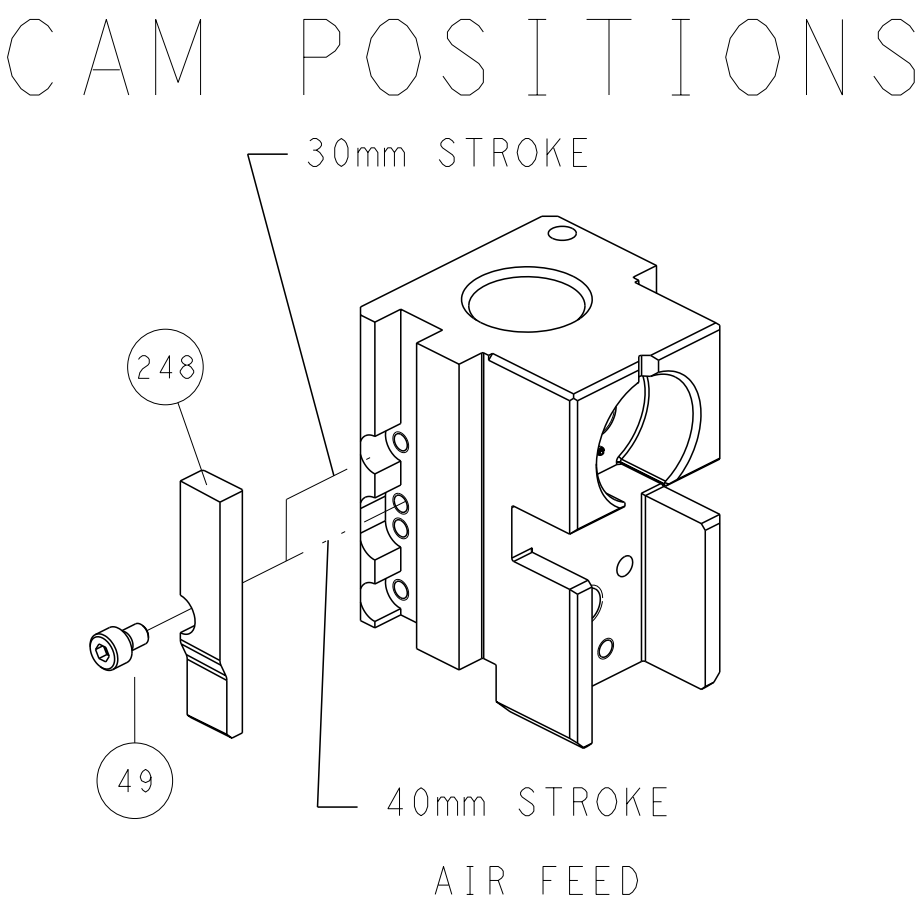
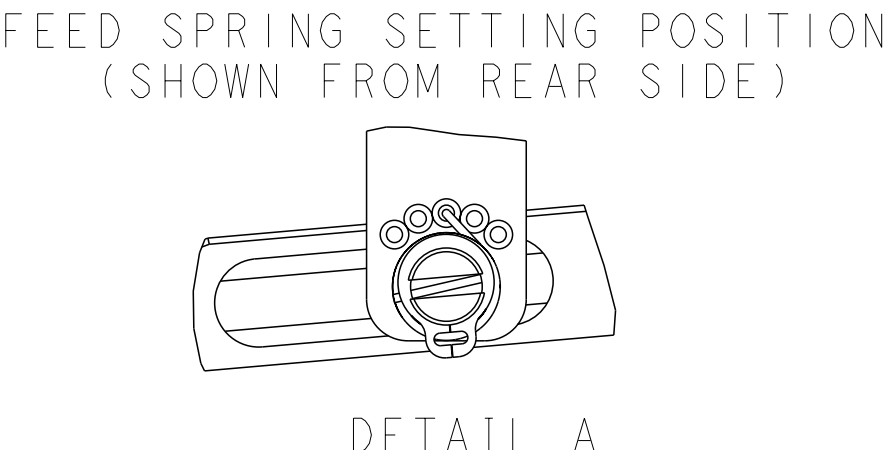
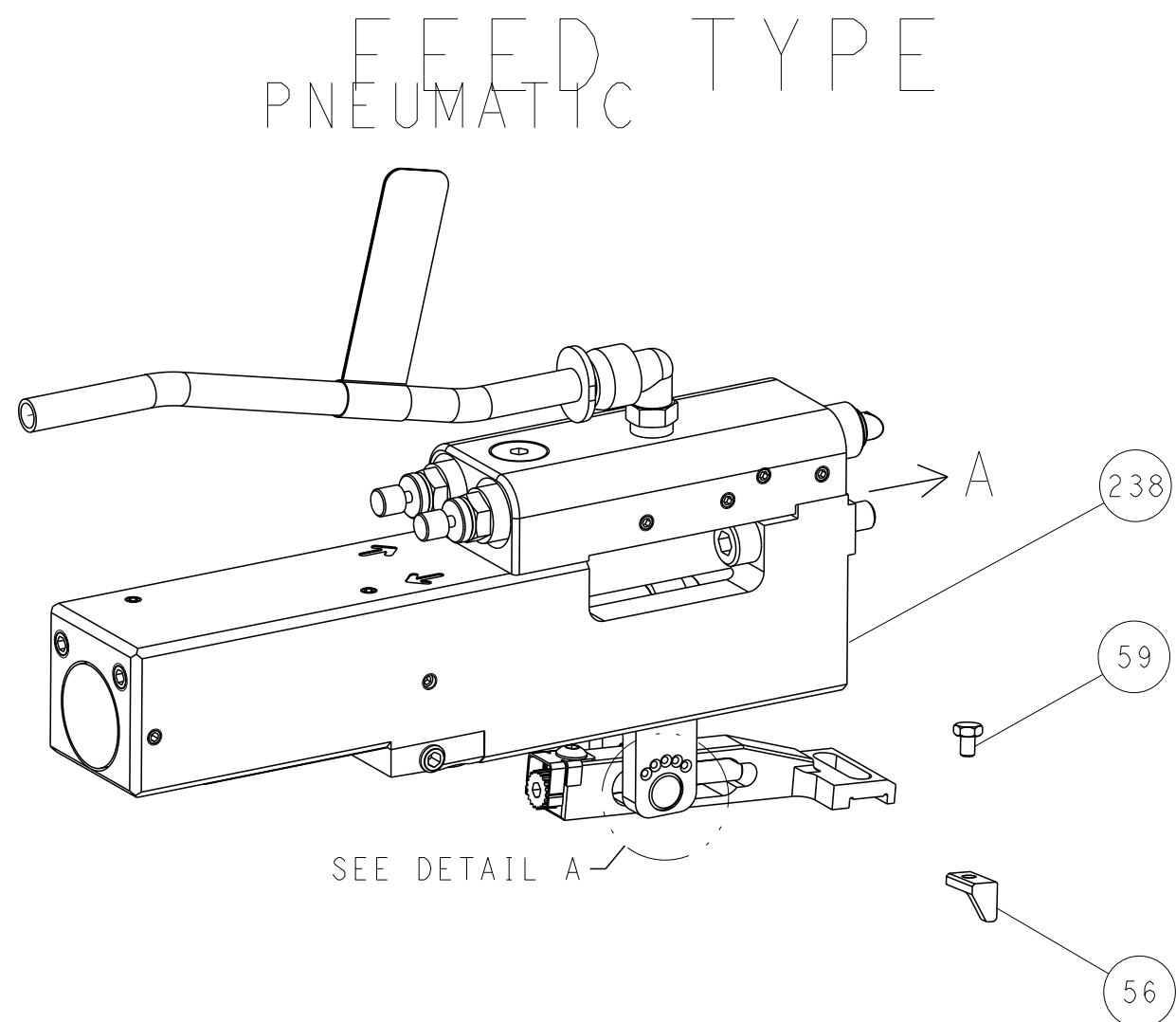
J

TE Connectivity

Harrisburg, PA 17105-3608

AMP 4805 REV 31MAR2000

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



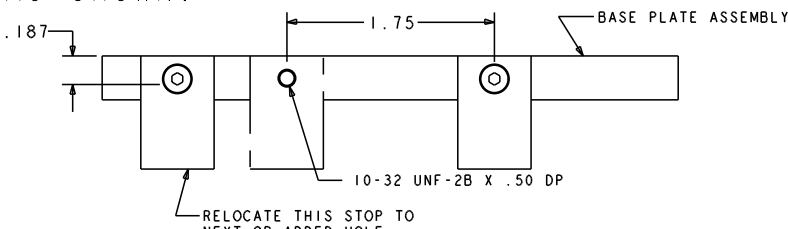
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

1111 DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION IT IS SUBJECT TO CHANGE AND TO CONTROL AND ENGINEERING DISCRETION SHALL BE CONTACTED FOR THE LATEST REVISION		DWN B. WEAVER 21OCT2011	TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm		CHK G. HOFENER 21OCT2011		
TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		APVD T. ELBIN 21OCT2011	NAME OCEAN SIDE FEED APPLICATOR	
MATERIAL -		PRODUCT SPEC	SIZE A1	
		APPLICATION SPEC	CAGE CODE 00779	
		WEIGHT -	DRAWING NO 2151034	
		Customer Accessible Production Drawing	RESTRICTED TO -	
		SCALE 1:1	SHEET 2 of 4	
			REV J	

GROUP 1 



16. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.



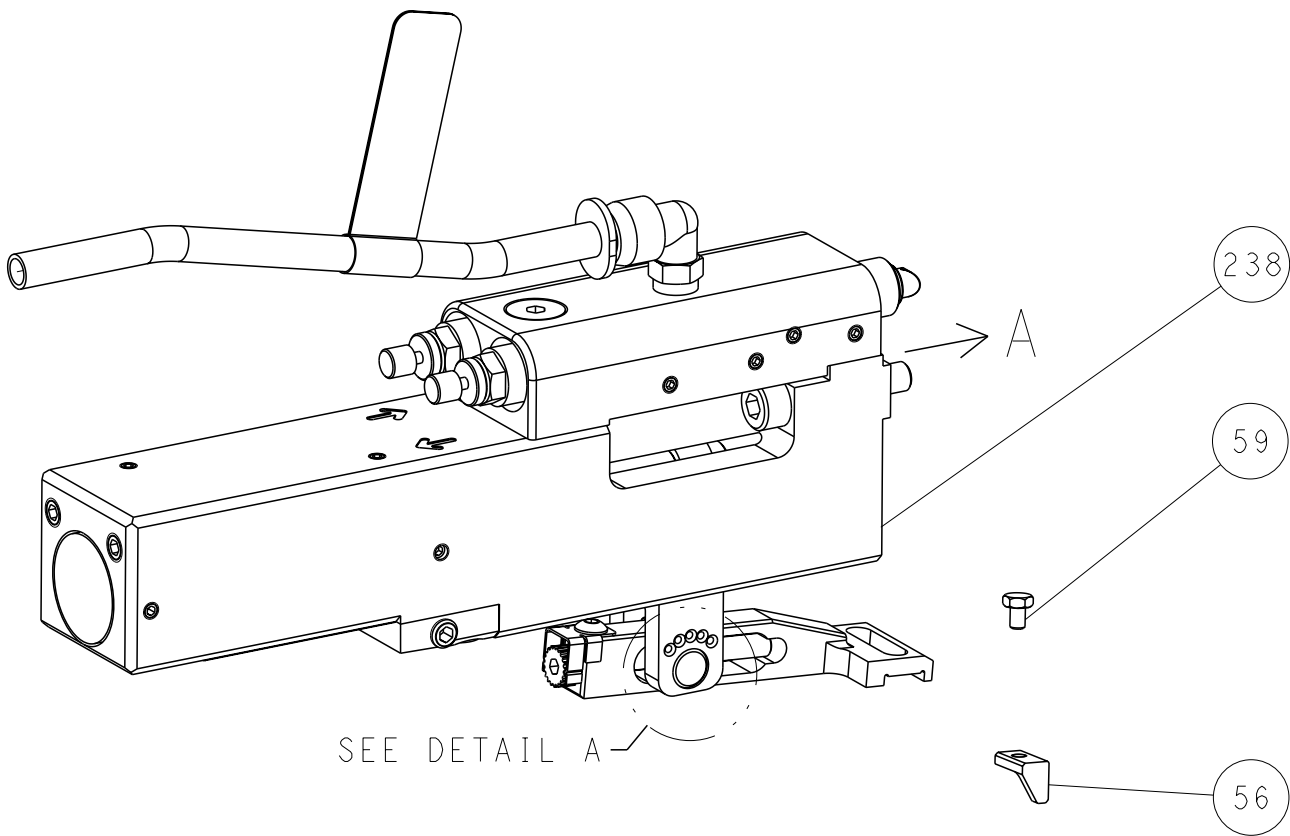
- PACIFIC VERSION
Shown on sheets 3 of 4 & 4 of 4
(Atlantic version shown on sheets 1 of 4 & 2 of 4)

43	-	REF	462992-5	GUARD ASSY	257
3	-	REF	679532-1	INSERT, GUARD	256
12	-	1	189728-1	BRACKET, SPACER	255
12	-	1	568681-1	SPACER, BASE PLATE	253
	-	1	18023-1	SCR, SKT HD CAP M3 X 5.0	241
	-	1	2844940-2	AIR FEED MODULE	238
	-	1	1-18028-0	WASHER, FLAT, REG M8	192
	-	REF	994970-2	COUNTER, MAGNETIC	164
	-	1	2119641-2	FEED CAM, AIR FEED	151
	-	1	2079383-8	SCR, BHSC, RoHS (M4 X 16)	144
	-	4	2168400-5	SHCS, LOW HEAD, RoHS, M4 X 20	142
	-	1	2-1803583-0	APPLICATOR BASIC ASSEMBLY, SF	140
	-	1	1803516-1	RAM ASSEMBLY, SF PACIFIC	140
	-	1	1-22281-8	SPRING, COMPRESSION	121
	-	1	2844908-1	SCREW, LOCKING	99
	-	1	2844907-1	POST, LOCKING	98
	-	1	1-690438-0	FRONT STRIP GUIDE	96
	-	4	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	95
	-	1	2168083-6	SCR, SKT HD CAP, RoHS, M5 X 65	93
	-	1	455888-4	SPACER, CRIMPER	82
	-	1	240641-6	SPACER	81
	-	1	1803607-3	DOCUMENTATION PACKAGE	71
	-	1	2161332-2	DEPRESSOR, WIRE FUNNEL	70
	-	1	2161331-1	SPACER, WIRE FUNNEL DEPRESSOR	69
	-	2	1-18028-4	WASHER, FLAT, REG M3	68
	-	1	2119740-1	TAG, IDENTIFICATION	67
	-	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
	-	2	2-18032-5	SCR, SET, FLT PNT, M5 X 20.0	61
	-	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
	-	1	462427-2	FINGER, FEED	56
	-	2	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	53
	-	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49
9	-	1	462433-7	SUPPORT, INSULATION	43
9	-	1	462433-6	SUPPORT, INSULATION	42
	-	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
	-	2	5-22278-1	SPRING, COMPRESSION	33
	-	2	1-2168083-4	SCR, SKT HD CAP, RoHS, M4 X 5	30
	-	1	2161336-2	PLATE, REAR STRIP GUIDE	29
	-	2	22281-9	SPRING, COMPRESSION	27
	-	1	356835-1	LEVER, DRAG RELEASE	26
	-	1	240792-1	DRAG, TERMINAL	25
	-	1	684042-4	GUIDE, STRIP, FRONT	24
	-	1	980371-4	SCR, SKT HD SHLDR 5.0 DIA X 6.0	23
6	-	1	462431-6	WIRE FUNNEL	22
	-	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
	-	1	1-18028-2	WASHER, FLAT, REG M4	20
	-	1	2119533-1	STRIPPER, SIDE FEED	19
	-	1	463460-3	HOLD DOWN, TERMINAL	18
1	-	1	469542-3	REAR FLOATING SHEAR	17
	-	4	1-2168083-1	SCR, SKT HD CAP, RoHS, M3 X 6	16
1	-	1	2161335-2	SHEAR PLATE, REAR	15
	-	1	2119862-2	SHEAR HOLDER, REAR	14
1	-	1	2280441-1	INSERT, SHEAR	13
	-	1	3-22280-3	SPRING, COMPRESSION	12
	-	1	356885-4	STOP, SHEAR	11
9	-	1	462843-6	TERMINAL SUPPORT	10
9	-	1	462843-5	TERMINAL SUPPORT	9
1	1	1	464291-4	ANVIL, SAND-BLASTED 22-18	8
5	-	1	803925-2	GUIDE, CARRIER SCRAP	7
	-	1	2-690468-5	DEPRESSOR SHEAR, REAR	6
6	-	1	462431-1	WIRE FUNNEL	5
	-	1	238011-1	BLOCK, CRIMPER SPACER	4
1	1	1	464290-1	CRIMPER, SEMI-FLAT 22-18	1

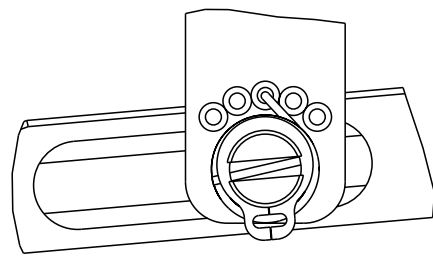
SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

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

FEED TYPE
PNEUMATIC

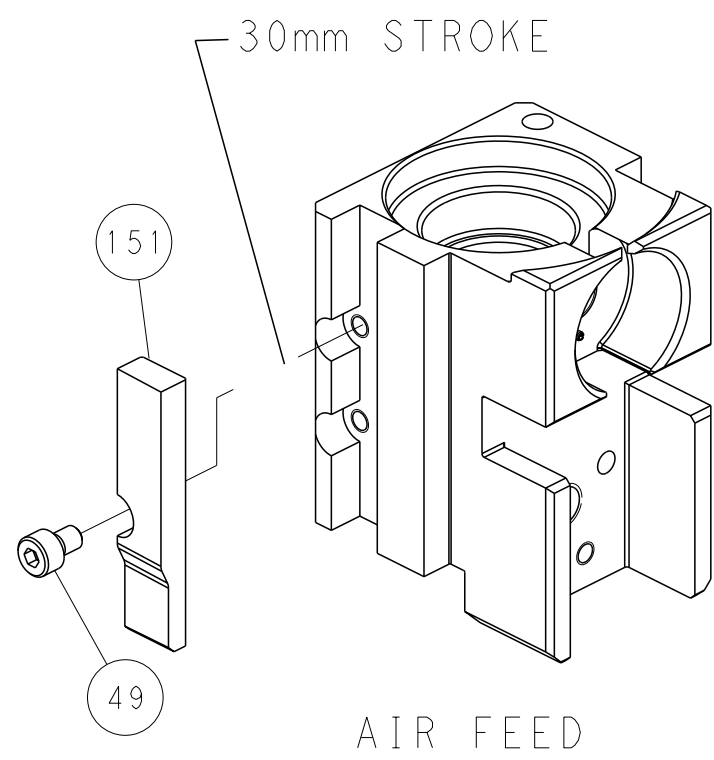


FEED SPRING SETTING POSITION
(SHOWN FROM REAR SIDE)

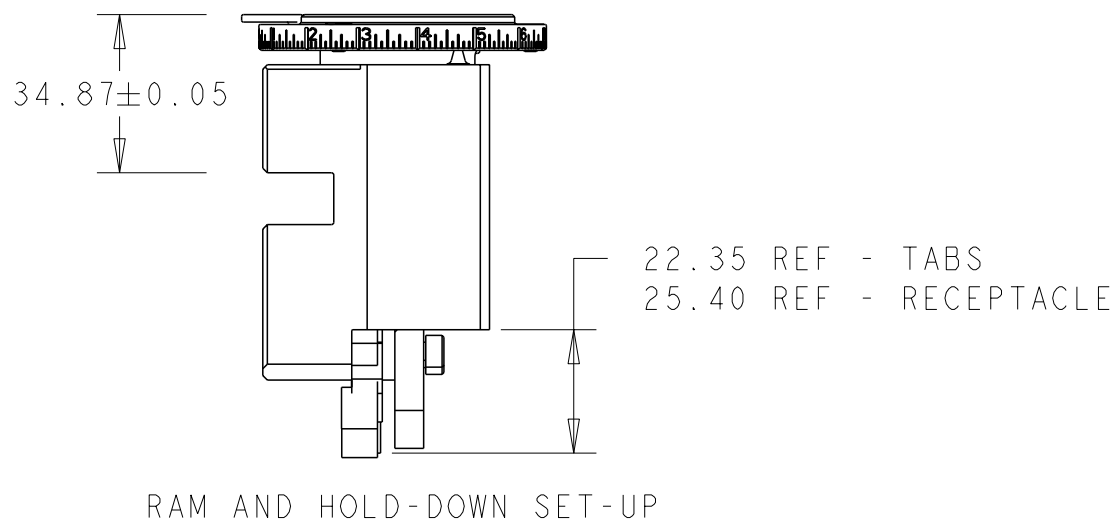
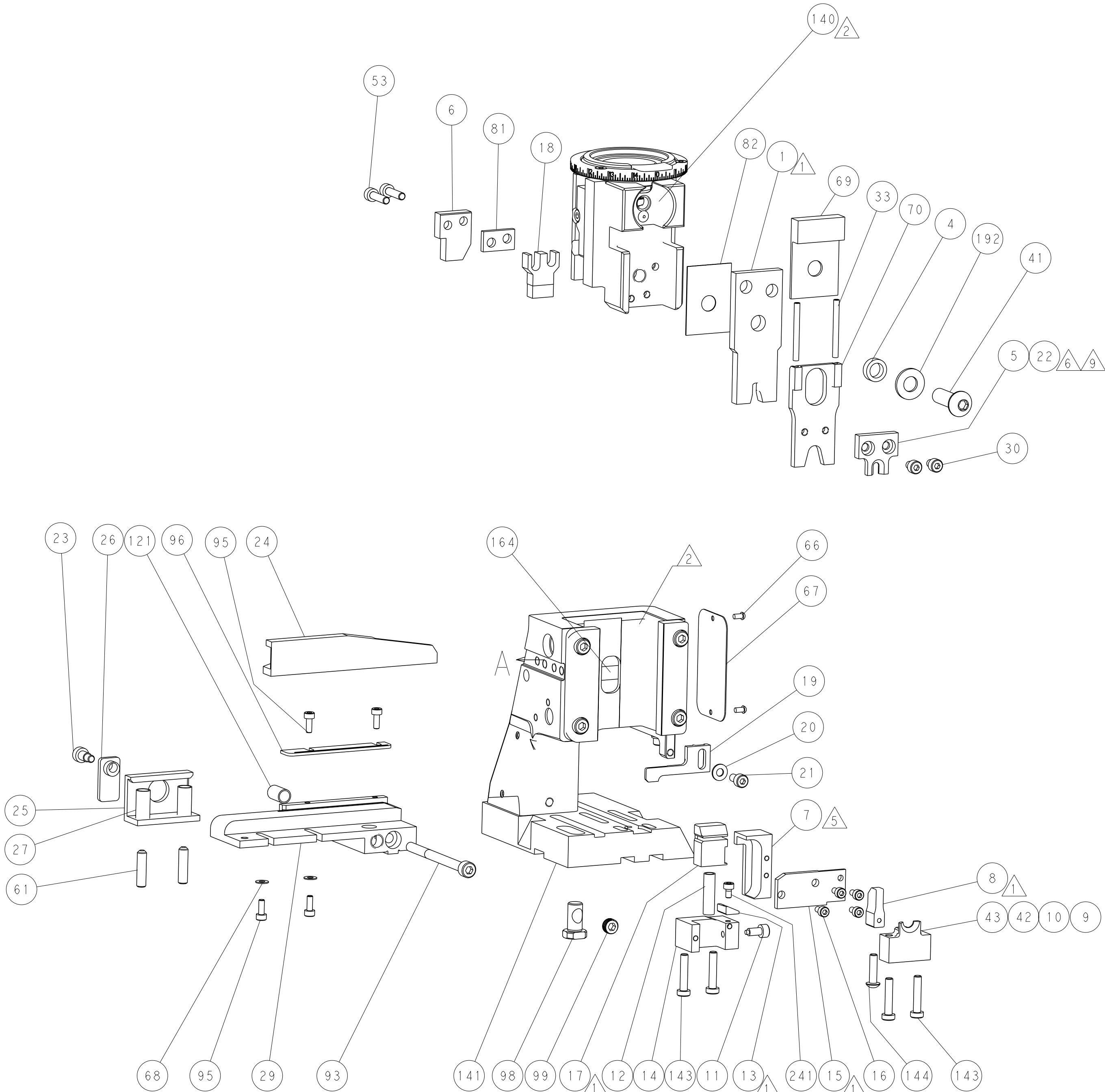


DETAIL A

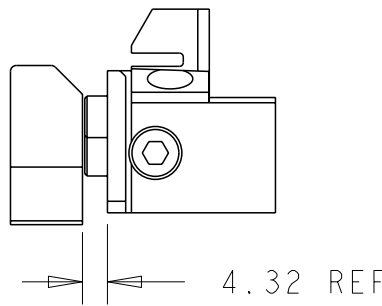
CAM POSITION



AIR FEED



RAM AND HOLD-DOWN SET-UP



LOWER TOOLING SET-UP

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

1111 BEARING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION IT IS SUBJECT TO CHANGE AND TO CONTROL AND ENGINEERING ORGANIZATION SHALL BE CONTACTED FOR THE LATEST REVISION		DWN B. WEAVER 21OCT2011	 TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm		CHK G. HOFENER 21OCT2011		
TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH ±		APVD T. ELBIN 21OCT2011	NAME OCEAN SIDE FEED APPLICATOR	
MATERIAL -		PRODUCT SPEC -	SIZE A1	
		APPLICATION SPEC -	CAGE CODE 00779	
		WEIGHT -	DRAWING NO C=2151034	
		Customer Accessible Production Drawing	RESTRICTED TO -	
		SCALE 1:1	SHEET 4	
			OF 4	
			REV J	

Mouser Electronics

Authorized Distributor

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

[TE Connectivity:](#)

[2151034-2](#)