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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151112-1	E	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2151112-2	F	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
5-2151112-1	E	SEAL STRIPPER CRIMPER TERMINATING UNIT	MECHANICAL
5-2151112-2	F	SEAL STRIPPER CRIMPER TERMINATING UNIT	PNEUMATIC
7-2151112-1	E	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2151112-2	F	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2151112-7	A	CRIMP TOOLING KIT	-

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.78 mm [.070]	F
INSUL	3.56 mm [.140]	F
APPLICATOR INSTRUCTIONS 408-35042		

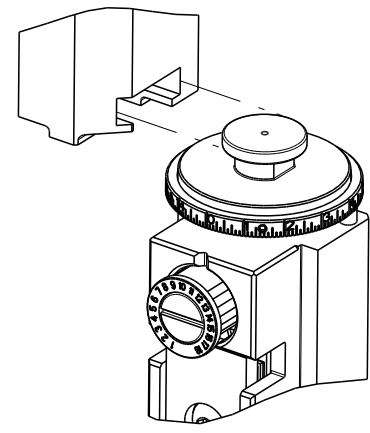
TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: MINI UNIVERSAL PIN AND SOCKET CONTACT TERMINAL			
WIRE STRIP LENGTH 3.20-3.70 mm [1.26-.146 IN]		INSULATION DIAMETER RANGE Ø2.00-3.20 mm [0.079-.126 IN]	
TERMINAL APPLICATION SPECIFICATION		114-5050	
TERMINAL SPECIFICATION		-	
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
171636-1	171637-1	171637-2	171637-3
171637-4	5171637-3		

WIRE SIZE			CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING 
0.51+0.51mm ²			1.30+/- 0.05 [.051+/- .002]		7.0
16 AWG			1.30+/- 0.05 [.051+/- .002]		7.0
18 AWG			1.21+/- 0.05 [.048+/- .002]		8.1
20 AWG			1.06+/- 0.05 [.042+/- .002]		9.9



1. RECOMMENDED SPARE PARTS
2. REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
3. APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 180. 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. TERMINAL LUBRICANT IS RECOMMENDED.
6. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.

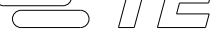
ATLANTIC VERSION TERMINATOR
INTERFACE ADAPTER



*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.

2				1					
LOC	DIST	REVISIONS							
A	66	P	LTR	DESCRIPTION			DATE	DRN	APVD
			C	ECR-17-006202			01MAY2017	TB	TE
			D	ECR-18-011637			20JUL2018	JAH	YY
			E	ECR-19-001734			01FEB2019	FZ	YV
			F	ECR-21-001237			31JAN2021	TB	RR

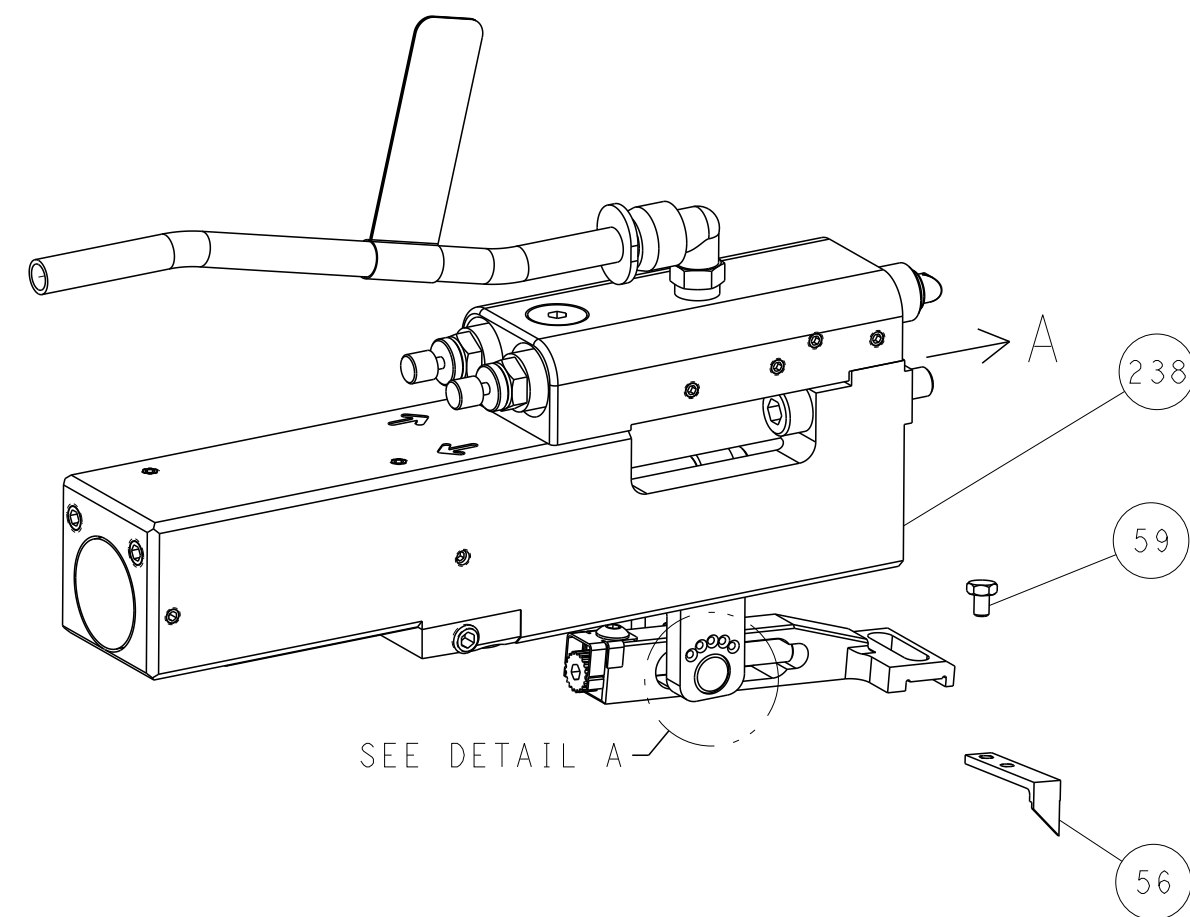
	-	-	-	1	-	-	-	1803515-3	RAM ASSEMBLY, SF ATLANTIC	293
	-	-	-	1	1	-	-	2-1803583-1	APPLICATOR BASIC ASSEMBLY, SF	292
	-	1	-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248
	-	1	1	1	1	1	1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244
	-	1	1	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
3	-	1	1	1	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	18
3	-	-	-	1	1	-	-	1-1752354-7	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
5	-	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	455888-6	SPACER, CRIMPER	82
	-	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	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	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	53
	-	1	1	1	1	1	1	1803382-6	HOLD DOWN, SPRING LOADED	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	1752356-3	SUPPORT, TERMINAL	34
	-	2	2	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
	-	2	2	2	2	2	2	2-2844962-6	SPACER, CYLINDRICAL, STRIP GUIDE	30
	-	1	1	1	1	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29
	-	1	1	1	1	1	1	455888-5	SPACER, CRIMPER	28
	-	1	1	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	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	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	1	2119805-1	SHEAR HOLDER, FRONT	10
1	-	1	1	1	1	1	1	1803095-1	FLOATING SHEAR, FRONT	9
1	1	2	2	1	1	1	1	1338692-2	ANVIL, COMBINATION .070	8
	-	1	1	1	1	1	1	6-240641-4	SPACER	7
	-	1	1	1	1	1	1	2119757-8	DEPRESSOR, SHEAR	5
	-	1	1	1	1	1	1	238011-8	BLOCK, CRIMPER SPACER	4
1	1	2	2	1	1	1	1	2-2119582-4	CRIMPER, INSULATION F PREMIUM	3
	-	1	1	1	1	1	1	455888-3	SPACER, CRIMPER	2
1	1	2	2	1	1	1	1	2-456404-5	CRIMPER, WIRE PREMIUM	1

-77 -72 -71 -52 -51 -2 -1							PART NO		DESCRIPTION					ITEM NO		
THIS DRAWING IS A CONTROLLED DOCUMENT FOR ETCO ELECTRONICS CORPORATION IT IS SUBJECT TO THE SAME CONTRACTS AND SUPPLEMENTAL QUANTIFICATION SHOULD BE CONTACTED FOR THE LATEST REVISION.							DWN	110C12011	 TE Connectivity Harrisburg, PA 17105-3608							
							CHK	110C12011								
							APVD	110C12011								
DIMENSIONS:							TOLERANCES UNLESS OTHERWISE SPECIFIED:		NAME	Ocean Side Feed Applicator -						
mm									PRODUCT SPEC							
							0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± ±		APPLICATION SPEC							
MATERIAL	FINISH						WEIGHT	-	A	00779	CAGE CODE	DRAWING NO		G=2151112	RESTRICTED TO	
-	-						-							-		
Customer Accessible Production Drawing									SCALE	1:2	SHEET	1	OF	4	REV F	

SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

AMP 4805 REV 31MAR2000

PNEUMATIC



Exploded view diagram of a mechanical assembly. The diagram shows the main body (164) and various components including a base (113), a handle (19), a trigger (20), a trigger guard (21), a trigger spring (24), a trigger pin (29), a trigger pin spring (30), a trigger pin spring cap (33), a trigger pin spring cap cap (34), a trigger pin spring cap cap (35), a trigger pin spring cap cap (36), a trigger pin spring cap cap (37), a trigger pin spring cap cap (38), a trigger pin spring cap cap (39), a trigger pin spring cap cap (40), a trigger pin spring cap cap (41), a trigger pin spring cap cap (42), a trigger pin spring cap cap (43), a trigger pin spring cap cap (44), a trigger pin spring cap cap (45), a trigger pin spring cap cap (46), a trigger pin spring cap cap (47), a trigger pin spring cap cap (48), a trigger pin spring cap cap (49), a trigger pin spring cap cap (50), a trigger pin spring cap cap (51), a trigger pin spring cap cap (52), a trigger pin spring cap cap (53), a trigger pin spring cap cap (54).

Assembly notes:

- 113 5
- 164 2
- 176 2
- 174 2
- 175 2
- 181
- 182
- 180 3
- 24 2
- 29 3
- 30 2
- 33 2
- 34 2
- 35 2
- 36 2
- 37 2
- 38 2
- 39 2
- 40 2
- 41 2
- 42 2
- 43 2
- 44 2
- 45 2
- 46 2
- 47 2
- 48 2
- 49 2
- 50 2
- 51 2
- 52 2
- 53 2
- 54 2



Diagram illustrating the front view of the device assembly, showing the front cover (29) and the front panel (30).

30mm STROKE

47

49

40mm STROKE

MECHANICAL POST FEED

30mm STROKE

48

49

40mm STROKE

MECHANICAL PRE FEED

30mm STROKE

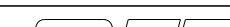
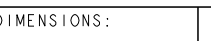
248

49

40mm STROKE

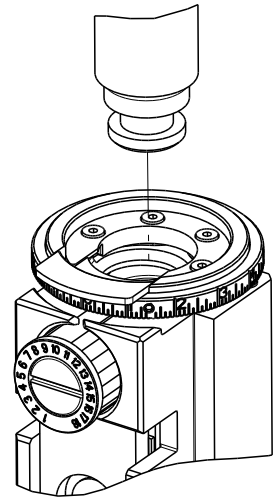
AIR FEED

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

THIS DRAWING IS A CONTROLLED DOCUMENT FROM TFCO. TFCO'S POLICY OF INFORMATION CONTROL IS TO BE MAINTAINED THROUGHOUT THE PRODUCT'S LIFECYCLE. INFORMATION SHOULD BE CONTROLLED FOR THE LATEST REVISION.		DWN 110CT2011 Y.YIN CHK G.BAILEY 110CT2011 APVD S.XI 110CT2011		 TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		NAME Ocean Side Feed Applicator	
		PRODUCT SPEC - APPLICATION SPEC -		SIZE A1	
MATERIAL FINISH - -		WEIGHT -		CAGE CODE 00779	
		DRAWING NO C-2151112		RESTRICTED TO -	
		SCALE 1:2		SHEET 2 OF 4	
		REV F			

8		7	
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20		20	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2151112-1	E	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2151112-2	F	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151112-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.78 mm [.070]	F
INSUL	3.56 mm [.140]	F
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: MINI UNIVERSAL PIN AND SOCKET CONTACT TERMINAL			
WIRE STRIP LENGTH 3.20-3.70 mm [.126-.146 IN]		INSULATION DIAMETER RANGE Ø2.00-3.20 mm [.079-.126 IN]	
TERMINAL APPLICATION SPECIFICATION		114-5050 - -	
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
171636-1	171637-1	171637-2	171637-3
171637-4	5171637-3		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.51+0.51mm ²	1.30+/-0.05 [.051+/- .002]	7.0
16 AWG	1.30+/-0.05 [.051+/- .002]	7.0
18 AWG	1.21+/-0.05 [.048+/- .002]	8.1
20 AWG	1.06+/-0.05 [.042+/- .002]	9.9

-  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				
		P	LTR	DESCRIPTION	DATE	OWN
A	66	-	-	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	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113
-	1	1	2844908-1	SCREW, LOCKING	99
-	1	1	2844907-1	POST, LOCKING	98
-	1	1	455888-6	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	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	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	2-2844962-6	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29
-	1	1	455888-5	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	1803095-1	FLOATING SHEAR, FRONT	9
-	1	1	1338692-2	ANVIL, COMBINATION .070	8
-	1	1	6-240641-4	SPACER	7
-	1	1	2119757-8	DEPRESSOR, SHEAR	5
-	1	1	238011-8	BLOCK, CRIMPER SPACER	4
-	1	1	2-2119582-4	CRIMPER, INSULATION F PREMIUM	3
-	1	1	455888-3	SPACER, CRIMPER	2
-	1	1	2-456404-5	CRIMPER, WIRE PREMIUM	1

- 77 - 22 - 21			PART NO		DESCRIPTION			ITEM NO
DRAWN BY Y. YIN				11OCT2011	 TE Connectivity Harrisburg, PA 17105-3608			
CHECKED BY G. BAILEY				11OCT2011				
APPROVED BY S. XI				11OCT2011	NAME			
PRODUCT SPEC				Ocean Side Feed				
-				Applicator				
APPLICATION SPEC				-				
SIZE				CASE CODE	DRAWING NO	RESTRICTED TO		
A1				00779	C=2151112	-		
Customer Accessible Production Drawing				SCALE	1:2	SHEET	3	OF
							4	REV
								F

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

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

D

C

B

A

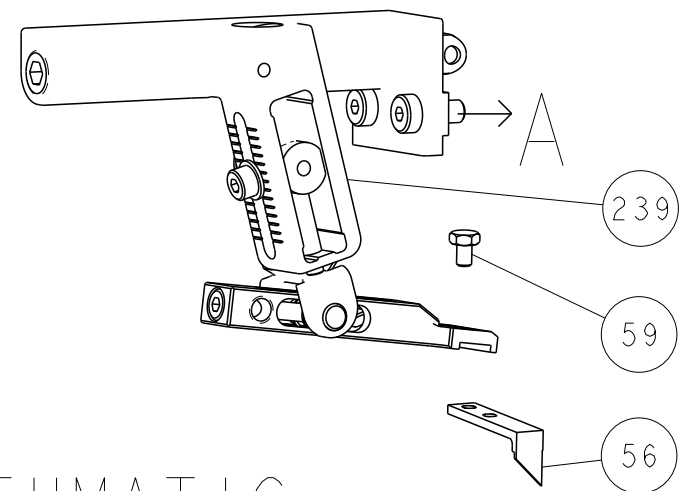
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C

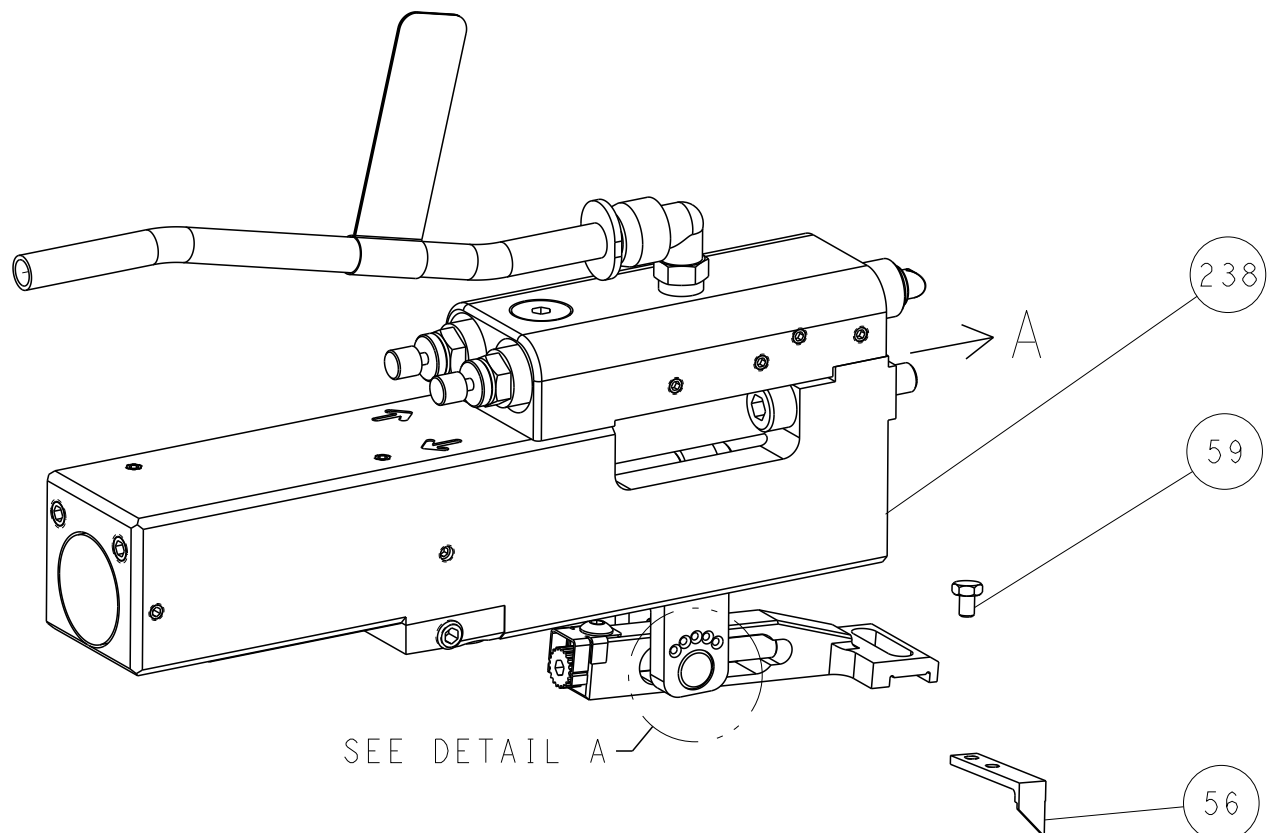
B

A

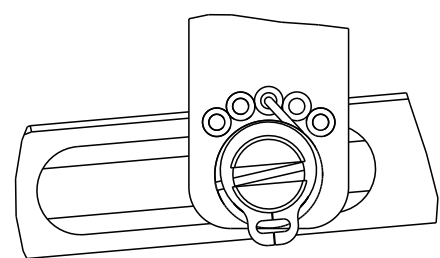
FEED TYPE MECHANICAL



PNEUMATIC

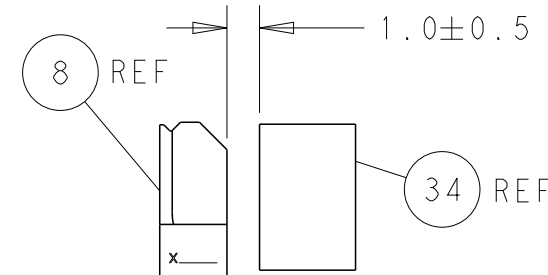
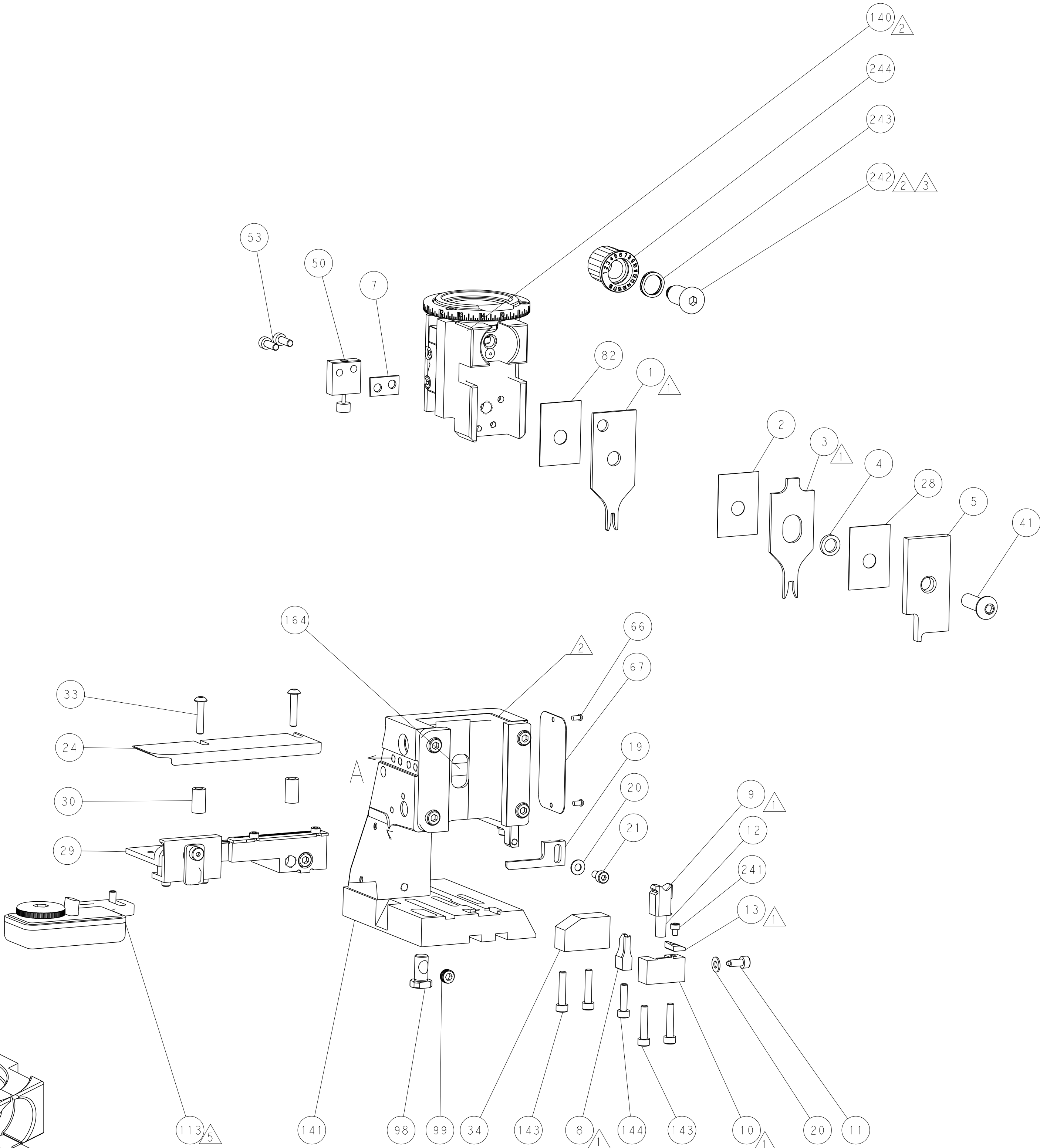
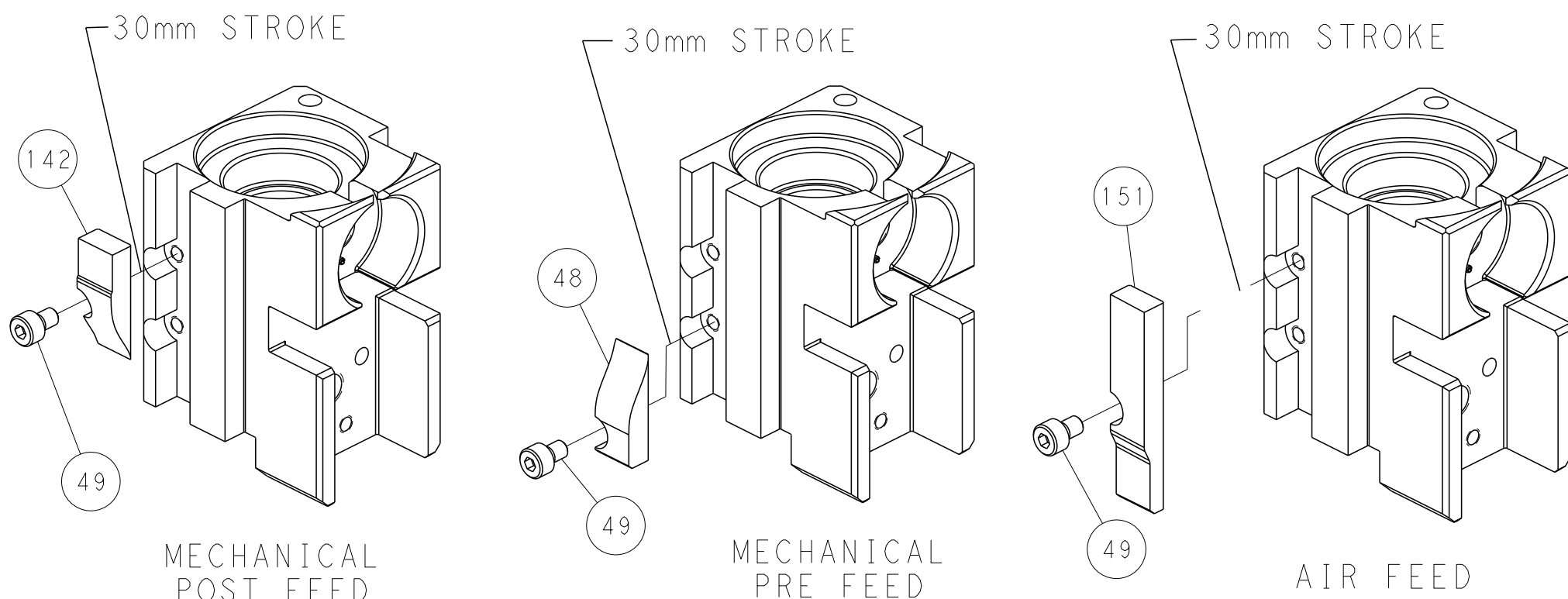


FEED SPRING SETTING POSITION
(SHOWN FROM REAR SIDE)

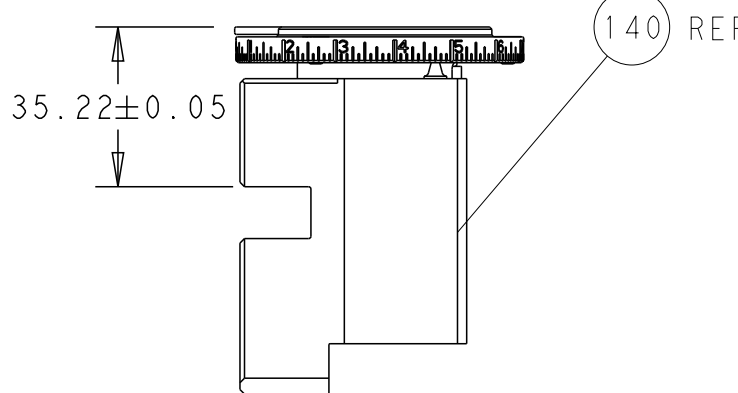


DETAIL A

CAM POSITIONS

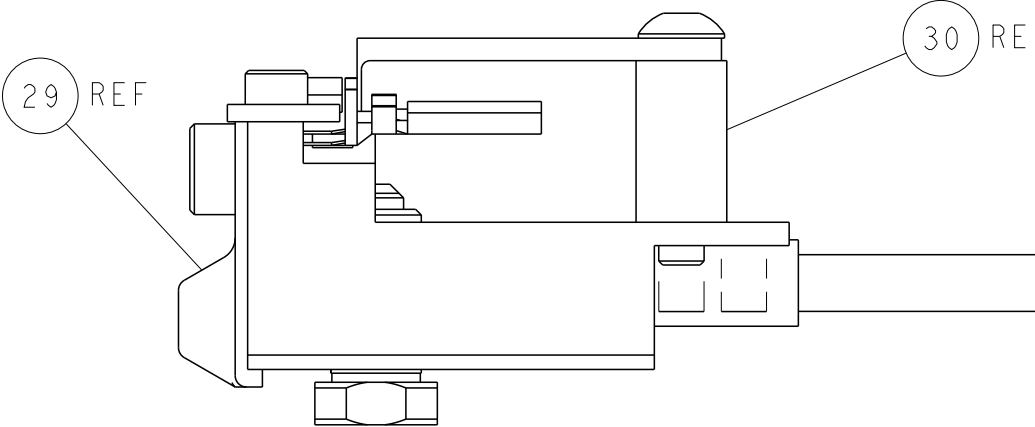


TERMINAL SUPPORT LOCATION



RAM SET-UP

ITEM 30 LOCATED AT
FRONT HOLES



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)

THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. ANY MODIFICATION OR REVISIONS SHOULD BE CONTACTED FOR THE LATEST VERSION.				DWN Y. YIN	11OCT2011	 TE Connectivity Harrisburg, PA 17105-3608		
				CHK G. BAILEY	11OCT2011			
				APVD S. XI	11OCT2011	NAME Ocean Side Feed Applicator		
DIMENSIONS: mm				TOLERANCES UNLESS OTHERWISE SPECIFIED:		PRODUCT SPEC		
						APPLICATION SPEC		
MATERIAL				FINISH		WEIGHT		
						Customer Accessible Production Drawing		
						SCALE 1:2		
						SHEET 4 OF 4		
						REV F		

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

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