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20		20	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151328-1	F	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2151328-2	G	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151328-1	F	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2151328-2	G	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2151328-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.02 mm [.040]	F
INSUL	2.90 mm [1.14]	O
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: MQS EDS SOCKET			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
3.25-3.55 mm [1.28-.140 IN]		Ø	
TERMINAL APPLICATION SPECIFICATION	114-18025	-	-
	-	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE SEAL	TE SEAL
2141826-1	2141830-1	967067-2	
2141826-5	2141830-2		
2141830-3			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.17mm2	0.70+/-0.02 [.0276+/- .0008]	10.4
0.13mm2	0.68+/-0.02 [.0268+/- .0008]	10.7



- 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 APPLY TORQ-SEAL IN ALLEN SOCKET TO FILL HOLE AFTER FLAT HD HAS BEEN ADJUSTED TO CORRECT HEIGHT AT QUALIFICATION. APPLY #1-23419-5 LOC-TITE TO THREADS.
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.

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

LOC	DIST	REVISONS			
A	66	P	LTR	DESCRIPTION	DATE
			D2	ECR-15-013464	14SEP2015
			E	ECR-16-013436	21SEP2016
			F	ECR-18-008123	27MAY2018
			G	ECR-19-010979	15JUL2019

-	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
-	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	1-18028-2	WASHER, FLAT, REG M4	119
-	1	1	1	1	2844908-1	SCREW, LOCKING	99
-	1	1	1	1	2844907-1	POST, LOCKING	98
-	1	1	1	1	455888-6	SPACER, CRIMPER	82
-	1	1	1	1	1803607-3	DOCUMENTATION PACKAGE	71
-	1	1	1	1	2119791-5	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	985575-3	SCR, FLT SKT HD CAP M3 X 10.0	57
-	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	2-1752356-0	SUPPORT, TERMINAL	34
-	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	2	2	2-2844962-6	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
-	1	1	1	1	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	318707-1	FLOATING SHEAR, FRONT	9
-	1	2	2	1	1333332-6	ANVIL, COMBINATION, SPECIAL	8
-	1	1	1	1	2-240641-8	SPACER	7
-	1	1	1	1	2119781-1	DEPRESSOR, SHEAR	5
-	1	1	1	1	3-238011-8	BLOCK, CRIMPER SPACER	4
-	1	2	2	1	1633996-2	CRIMPER, INSULATION SPECIAL	3
-	1	2	2	1	4-1633738-0	CRIMPER, WIRE	1

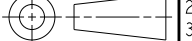
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DIMENSIONS:		CHK	-	-	NAME		
mm	TOLERANCES UNLESS OTHERWISE SPECIFIED:	APVD	S. XI	24AUG2011	Ocean Side Feed Applicator -		
	0 PLC ±	PRODUCT SPEC		SIZE			
	1 PLC ±	APPLICATION SPEC		CAGE CODE			
	2 PLC ±	FINISH		DRAWING NO			
	3 PLC ±	MATERIAL		RESTRICTED TO			
	4 PLC ±	WEIGHT		A1 00779			
	ANGLES	Customer Accessible Production Drawing		SCALE			
	FINISH	1:2		SHEET 1 OF 4			
MATERIAL		REV		G			

Diagram of the front of the machine. Callout 239 points to the front plate, 59 points to a screw, and 56 points to a bracket.

30mm STROKE

47

49

40mm STROKE

MECHANICAL POST FEED

30mm STROKE

48

49

40mm STROKE

MECHANICAL PRE FEED

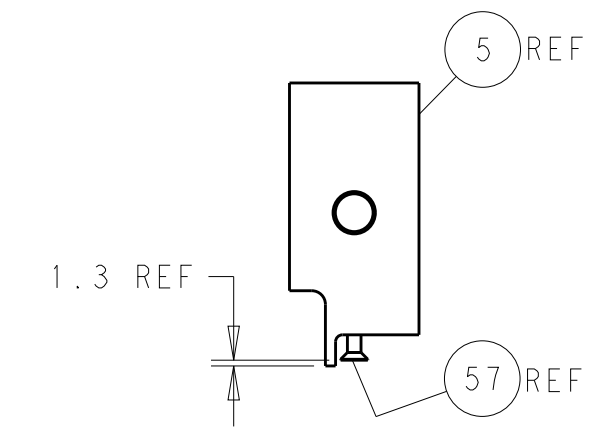
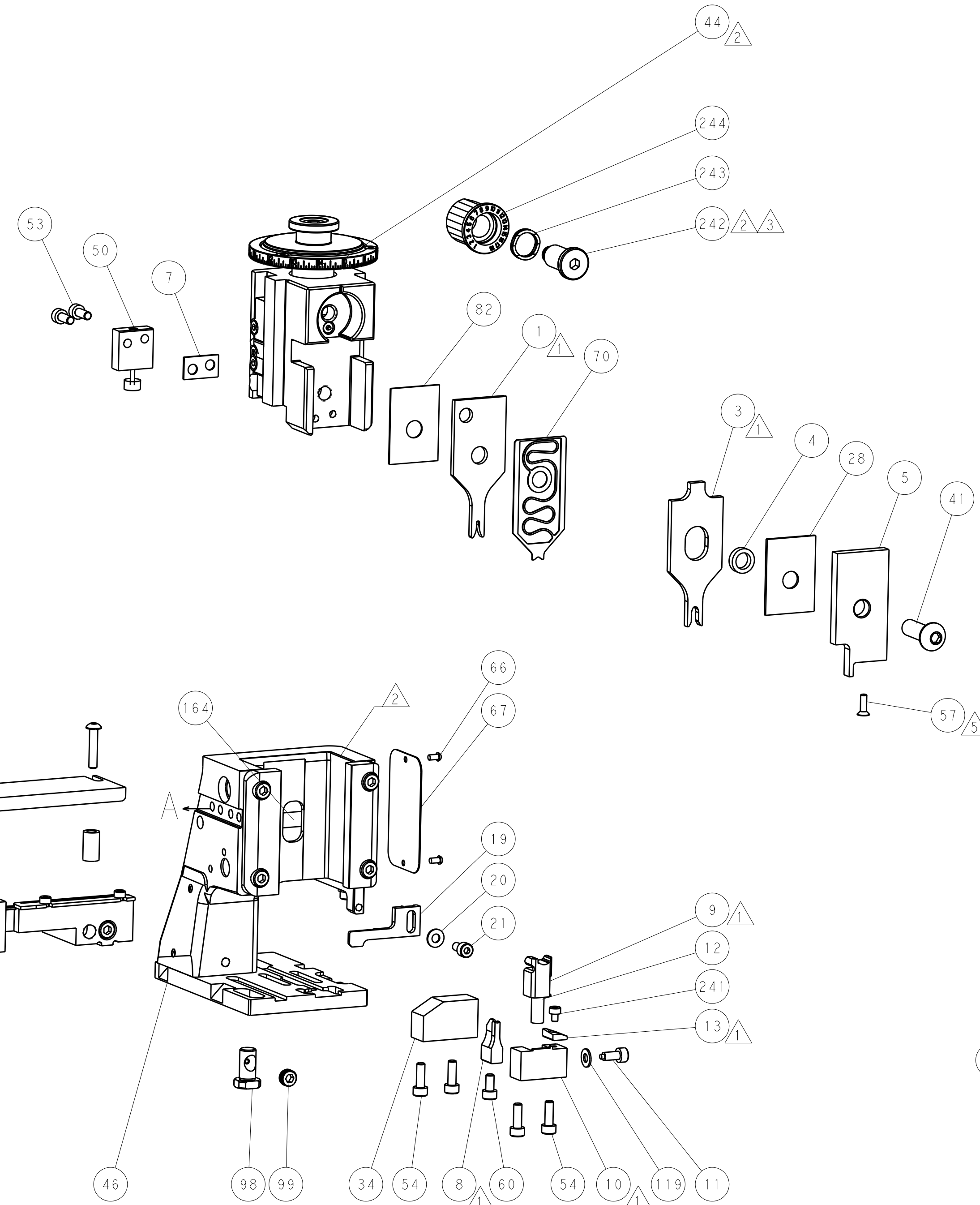
30mm STROKE

248

49

40mm STROKE

AIR FEED



ITEM 30 LOCATED AT FRONT HOLES

29 REF

30 REF

ATLANTIC VERSION
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 FOR THE ENGINEERING CORPORATION IT IS SUBJECT TO CHANGE AND THE CONTROLLING ENGINEERING CORPORATION MAY BE CONTROLLED FOR THE PURPOSE OF PREVENTING MISUSE		DWN CHK K. HUANG 24 AUG 2011		TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.1 1 PLC ±.1 2 PLC ±.1 3 PLC ±.1 4 PLC ±.1 ANGLES ±.1		NAME APVD S. XI 24 AUG 2011 Ocean Side Feed Applicator	
MATERIAL FINISH		WEIGHT		SIZE CAGE CODE DRAWING NO A1 00779 C=2151328	
		Customer Accessible Production Drawing		RESTRICTED TO SCALE 1:2 SHEET 2 OF 4 REV G	

8		7	
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20		20	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2151328-1	F	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2151328-2	G	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151328-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.02 mm [.040]	F
INSUL	2.90 mm [.114]	O
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: MQS EDS SOCKET			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
3.25-3.55 mm [.128-.140 IN]		Ø	
TERMINAL APPLICATION SPECIFICATION	114-18025	-	-
	-	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE SEAL	TE SEAL
2141826-1	2141830-1	967067-2	
2141826-5	2141830-2		
2141830-3			

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING
0.17mm2		0.70+/-0.02 [.0276+/- .0008]		10.4
0.13mm2		0.68+/-0.02 [.0268+/- .0008]		10.7



- 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 APPLY TORQ-SEAL IN ALLEN SOCKET TO FILL HOLE AFTER FLAT HD HAS BEEN ADJUSTED TO CORRECT HEIGHT AT QUALIFICATION. APPLY #1-23419-5 LOC-TITE TO THREADS.
6. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.

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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	2119082-4	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	-	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	1-18028-2	WASHER, FLAT, REG M4	119
-	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	2119791-5	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
5	-	1	985575-3	SCR, FLT SKT HD CAP M3 X 10.0	57
-	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	2-1752356-0	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	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
-	1	1	1-18028-2	WASHER, FLAT, REG M4	20
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1	-	1	2119806-1	INSERT, SHEAR	13
-	1	1	3-22280-3	SPRING, COMPRESSION	12
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1	-	1	318707-1	FLOATING SHEAR, FRONT	9
1	1	1	1333332-6	ANVIL, COMBINATION, SPECIAL	8
-	1	1	2-240641-8	SPACER	7
-	1	1	2119781-1	DEPRESSOR, SHEAR	5
-	1	1	3-238011-8	BLOCK, CRIMPER SPACER	4
1	1	1	1633996-2	CRIMPER, INSULATION SPECIAL	3
1	1	1	4-1633738-0	CRIMPER, WIRE	1

-77	-22	-21	PART NO	DESCRIPTION	ITEM NO
DWN R. HUANG			24AUG2011	STE TE Connectivity Harrisburg, PA 17105-3608	
CHK -			-	NAME Ocean Side Feed Applicator	
APVD S. XI			24AUG2011	SIZE CAGE CODE DRAWING NO	
DIMENSIONS: mm			0 PLC 1 PLC 2 PLC 3 PLC 4 PLC	TOLERANCES UNLESS OTHERWISE SPECIFIED: ± ± ± ± ±	
MATERIAL -			FINISH -	WEIGHT -	
Customer Accessible Production Drawing			SCALE 1:2	SHEET 3	REV G

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

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

D

C

B

A

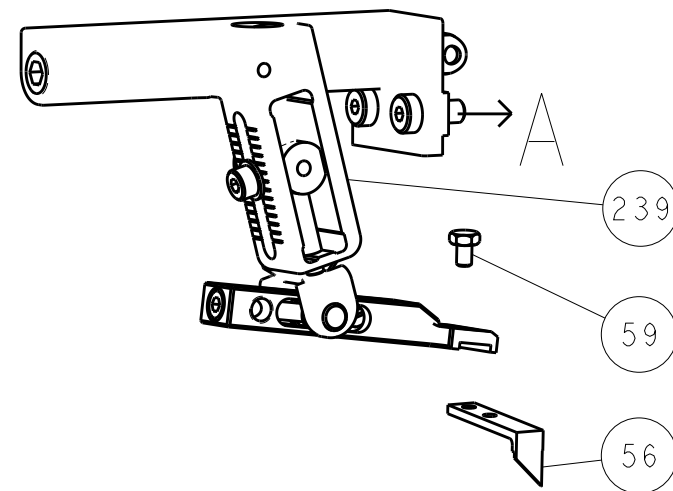
D

C

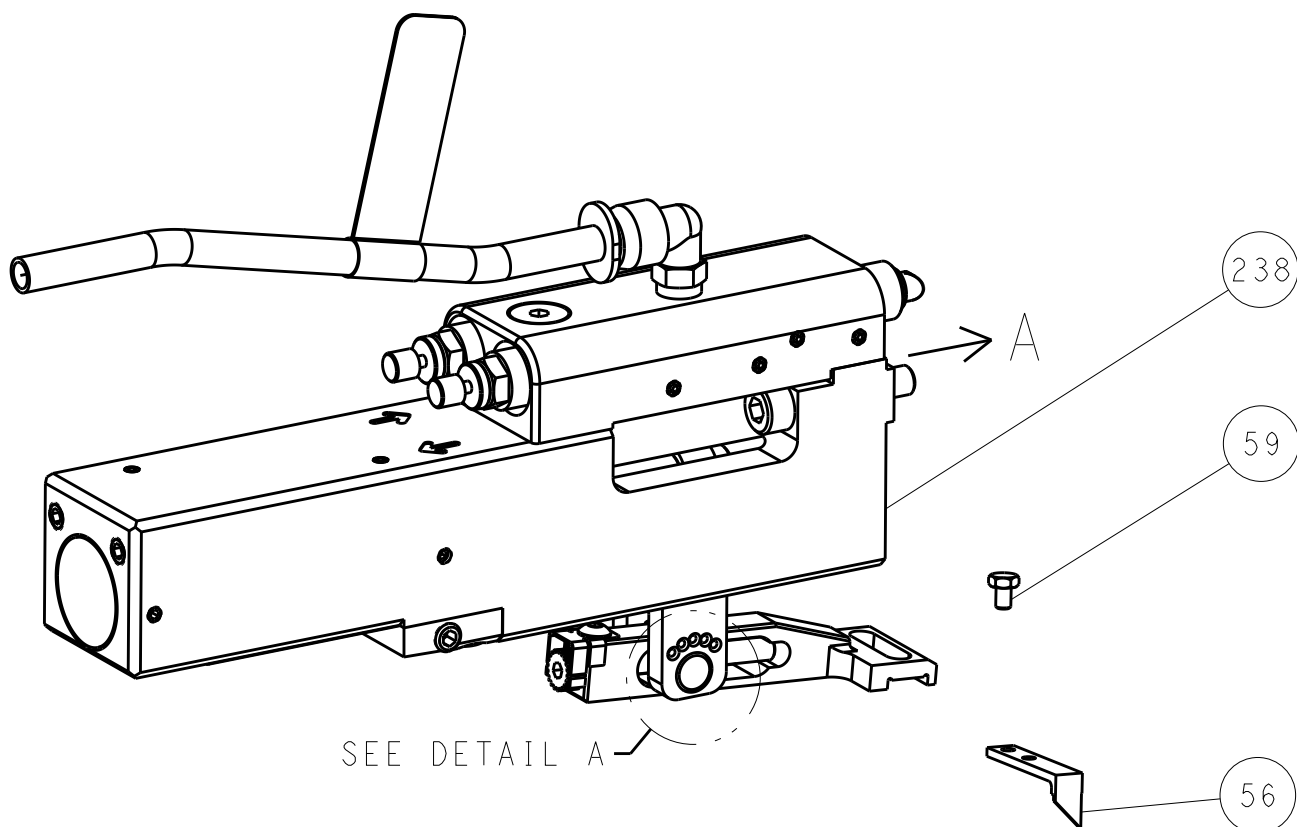
B

A

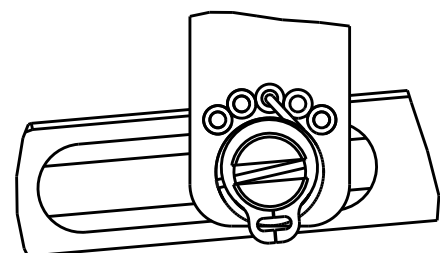
FEED TYPE MECHANICAL



PNEUMATIC

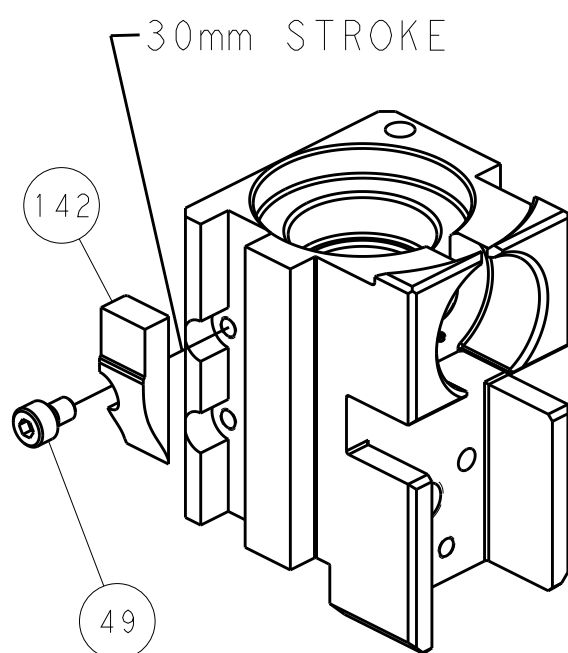


FEED SPRING SETTING POSITION
(SHOWN FROM REAR SIDE)

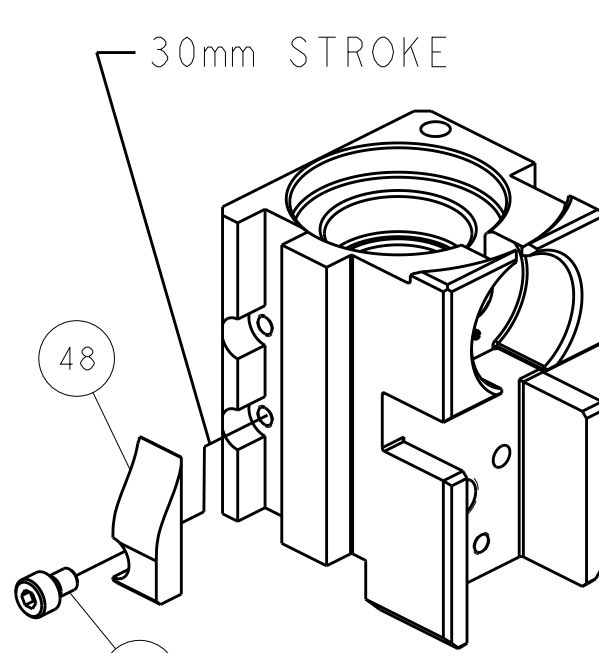


DETAIL A

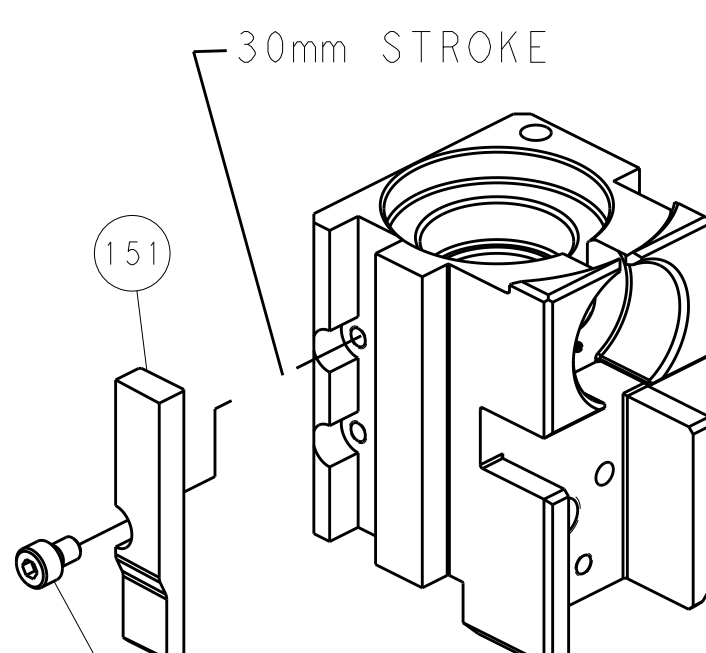
CAM POSITIONS



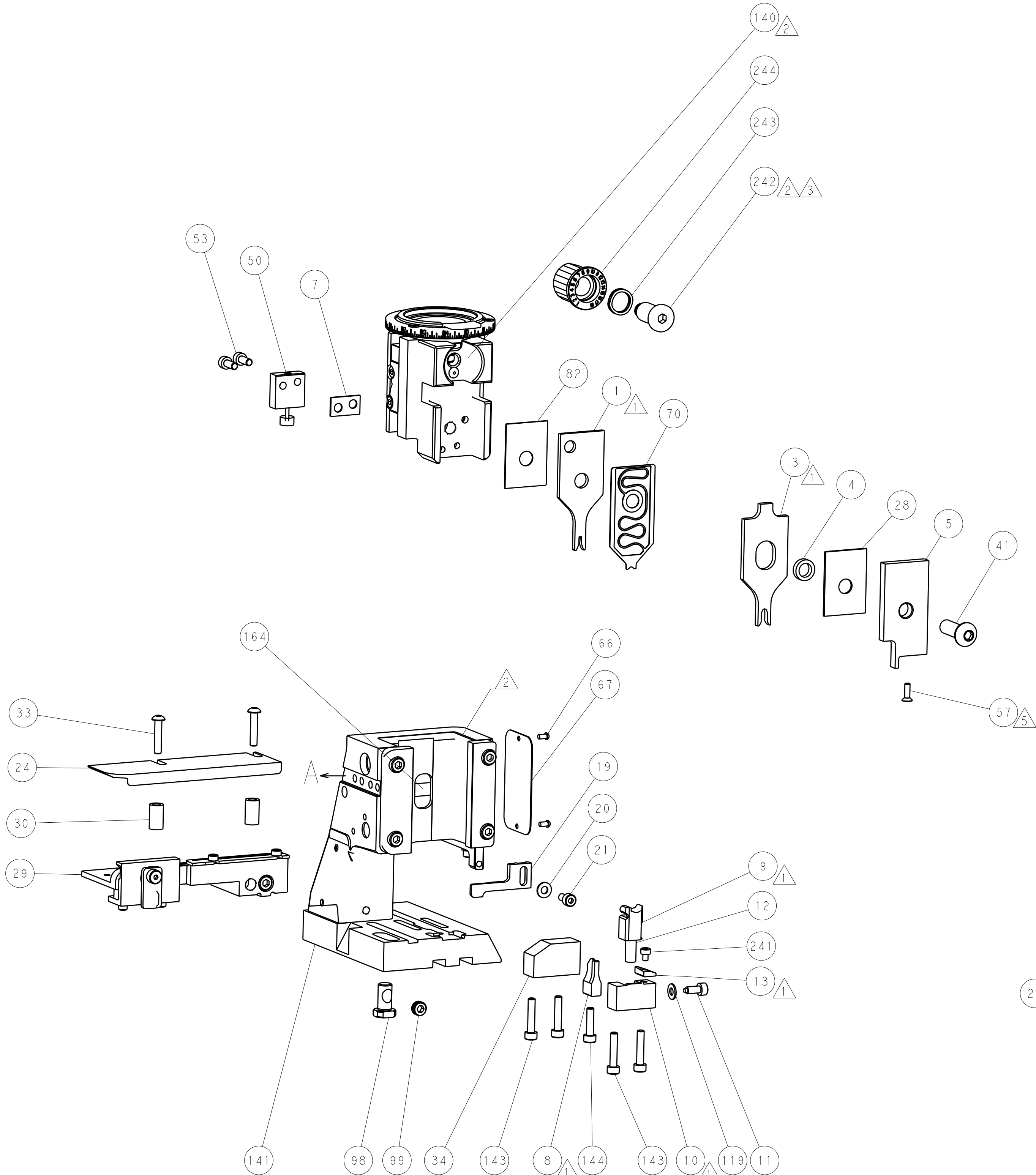
MECHANICAL
POST FEED



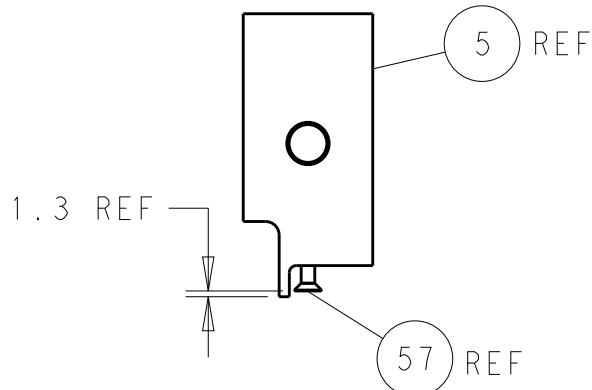
MECHANICAL
PRE FEED



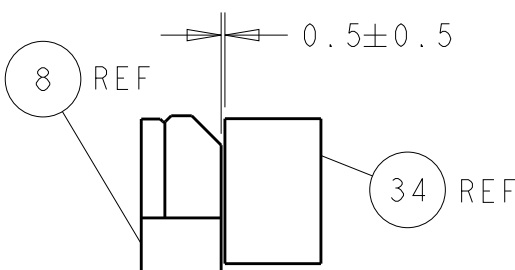
AIR FEED



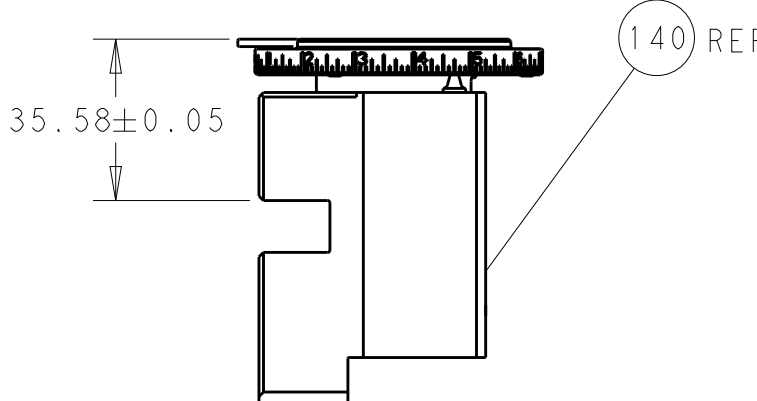
PACIFIC VERSION
Shown on sheets 3 of 4 & 4 of 4
(Atlantic version shown on sheets 1 of 4 & 2 of 4)



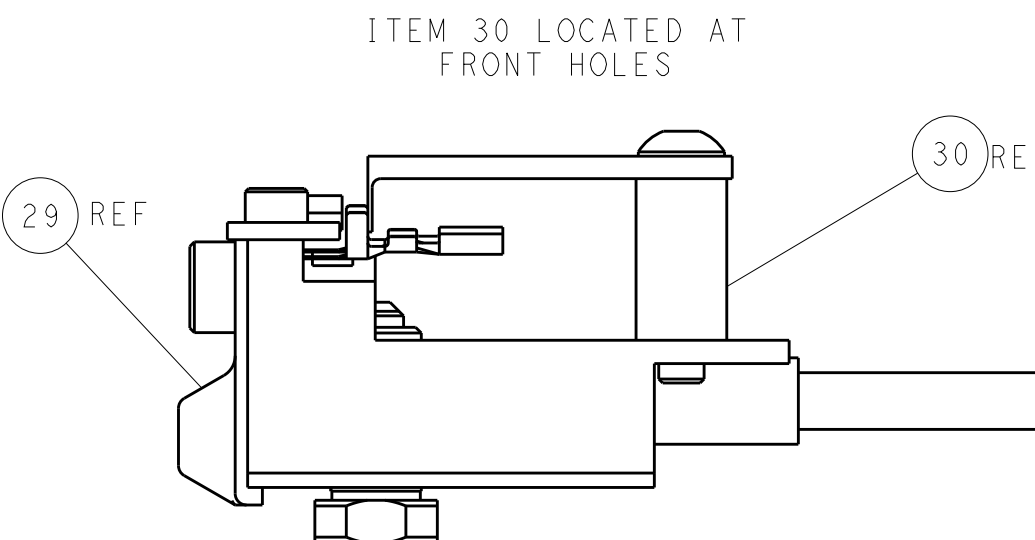
SHEAR DEPRESSOR DETAIL



TERMINAL SUPPORT LOCATION



RAM SET-UP



FEED TRACK POSITION
GUIDE BY INSULATION BARREL

1ST PUBLISHED BY: COMPANY LOGO FOR TYCO ELECTRONICS CORPORATION IT IS SUBJECT TO CHANGE AND WITHOUT WARRANTY OF ANY KIND. THE USER SHALL BE RESPONSIBLE FOR THE LATEST VERSION.		DWN K. HUANG	24AUG2011	TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm		CHK S. XI	24AUG2011		
TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.1 1 PLC ±.1 2 PLC ±.1 3 PLC ±.1 4 PLC ±.1 ANGLES ±.1 FINISH		APVD S. XI	24AUG2011	NAME Ocean Side Feed Applicator	
MATERIAL		PRODUCT SPEC		SIZE A1	
		APPLICATION SPEC		CAGE CODE 00779	
		WEIGHT		DRAWING NO 2151328	
		Customer Accessible Production Drawing		RESTRICTED TO G	
		SCALE	1:2	SHEET 4 OF 4	

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

Mouser Electronics

Authorized Distributor

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

[TE Connectivity:](#)

[2151328-2](#)