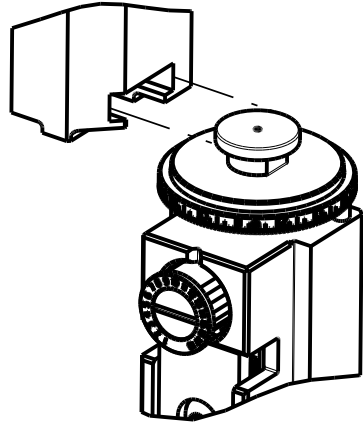
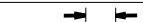


8		7	
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20		20	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151388-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2151388-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151388-1	B	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2151388-2	C	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2151388-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.57 mm [.062]	F
INSUL	3.05 mm [1.20]	O
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: ELO 0.63 SEALED TERMINAL			
WIRE STRIP LENGTH			TERMINAL INSULATION DIAMETER RANGE
3.70-3.90 mm [1.46-.154 IN]		Ø 2.60 mm MAX [1.02 IN MAX]	
TERMINAL APPLICATION SPECIFICATION		114-18432	
		-	-
-		-	-
TERMINALS APPLIED			
TE TERMINAL		TE TERMINAL	TE SEAL
2-1411573-1		1393457-1	TE SEAL
			SEAL INSULATION DIAMETER RANGE
			Ø 1.4-2.0mm

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.75mm2	1.17+/-0.03 [1.046+/-0.001]	4.5
0.50mm2	1.06+/-0.03 [1.042+/-0.001]	5.6



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

*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
							DWN
							APVD
				A		RELEASED	12APR2013
				B		ECR-19-002929	22FEB2019
				C		ECR-20-016831	26NOV2020
							FL
							FZ
							TE

-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248
-	1	1	1	1	2119082-9	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	2844908-1	SCREW, LOCKING	99
-	1	1	1	1	2844907-1	POST, LOCKING	98
-	1	1	1	1	455888-5	SPACER, CRIMPER	82
-	1	1	1	1	1803607-3	DOCUMENTATION PACKAGE	71
-	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	2-2844962-8	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29
-	1	1	1	1	455888-3	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
-	2	2	2	2	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	5-1333202-2	ANVIL, COMBINATION	8
-	-	-	-	-	-	-	7
-	-	-	-	-	-	-	6
-	1	1	1	1	2119781-1	DEPRESSOR, SHEAR	5
-	1	1	1	1	238011-4	BLOCK, CRIMPER SPACER	4
-	1	2	2	1	1633965-2	CRIMPER, INSULATION O PREMIUM	3
-	1	1	1	1	455888-3	SPACER, CRIMPER	2
-	1	2	2	1	4-657555-9	CRIMPER, WIRE PREMIUM	1
-	77	72	71	-2	-1	PART NO	ITEM NO
-	-	-	-	-	-	DESCRIPTION	

THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE AND THE USER SHALL BE RESPONSIBLE FOR VERIFYING THE LATEST REVISION. IF IT IS SUBJECT TO CHANGE, THE USER SHALL BE RESPONSIBLE FOR VERIFYING THE LATEST REVISION. IF IT IS SUBJECT TO CHANGE, THE USER SHALL BE RESPONSIBLE FOR VERIFYING THE LATEST REVISION.				DWN	29SEP2012	 TE Connectivity Harrisburg, PA 17105-3608			
				CHK	29SEP2012				
				S.XI	29SEP2012				
				APVD	29SEP2012				
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		NAME		Ocean Side Feed Applicator -			
mm				PRODUCT SPEC					

Diagram of the front of the microscope. Callout numbers 239, 59, and 56 point to the eyepiece, objective lenses, and base respectively.

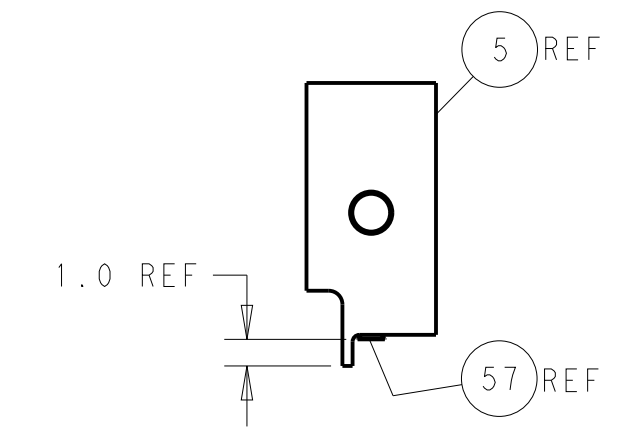
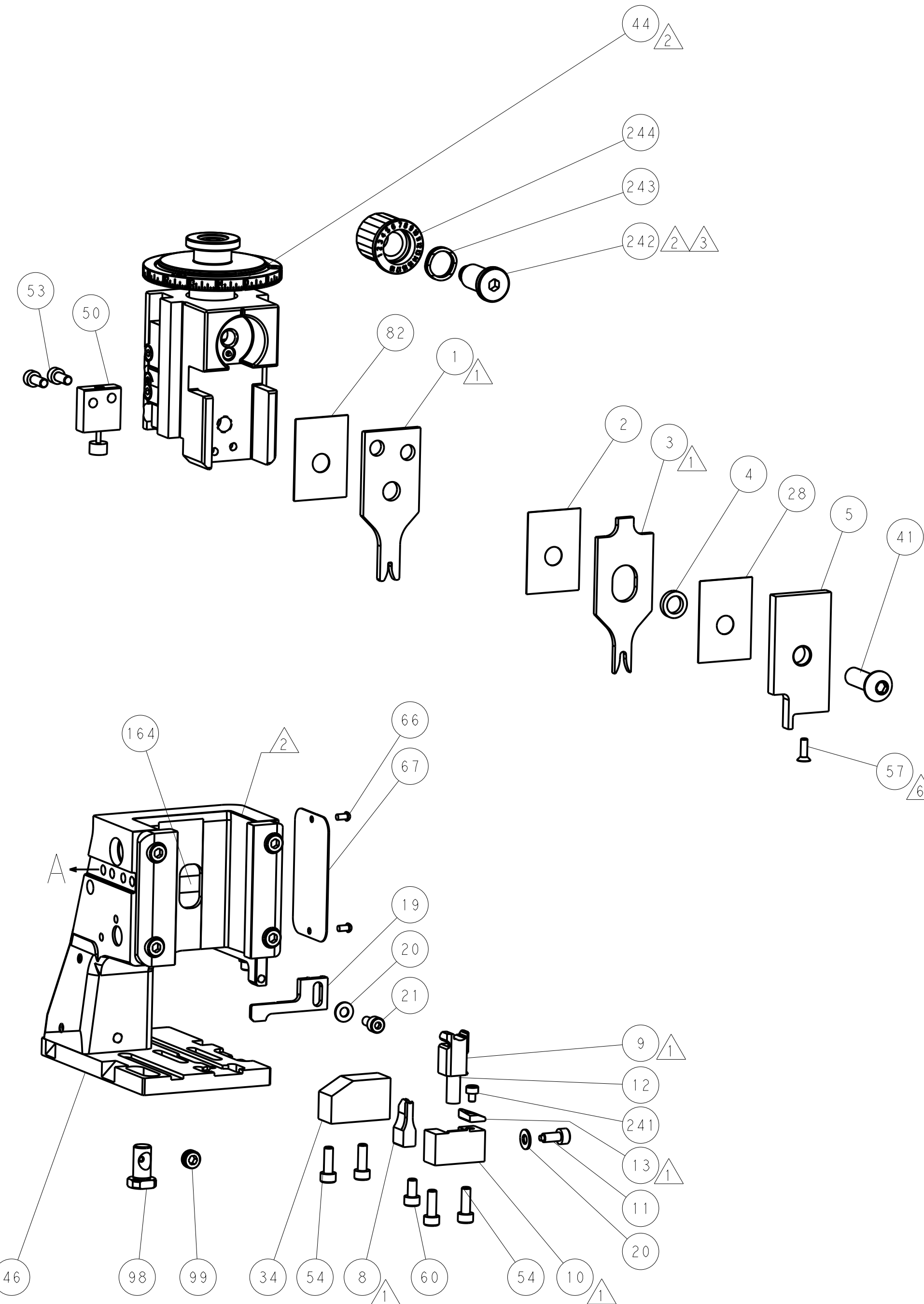
Diagram illustrating the front view of the machine assembly. Key components and callouts include:

- 238: Hose assembly with a handle.
- 59: Pin or fastener.
- 56: Bracket or support piece.
- SEE DETAIL A: Indicated by an arrow pointing to the front of the main body.

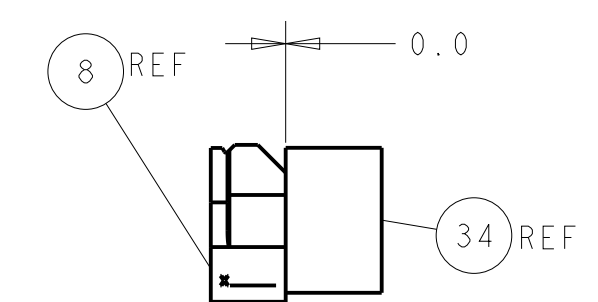
DETAIL A

The diagrams illustrate the installation of the mechanical post feed unit for three different machine configurations:

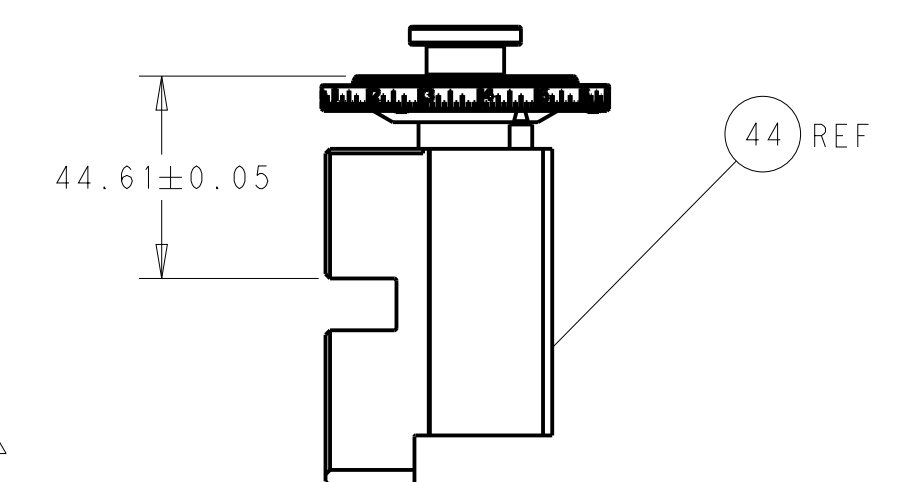
- MECHANICAL POST FEED:** Shows the unit with a 30mm stroke and a 40mm stroke adjustment. The unit is labeled 47, and the adjustment screw is labeled 49.
- MECHANICAL PRE FEED:** Shows the unit with a 30mm stroke and a 40mm stroke adjustment. The unit is labeled 48, and the adjustment screw is labeled 49.
- AIR FEED:** Shows the unit with a 30mm stroke and a 40mm stroke adjustment. The unit is labeled 248, and the adjustment screw is labeled 49.



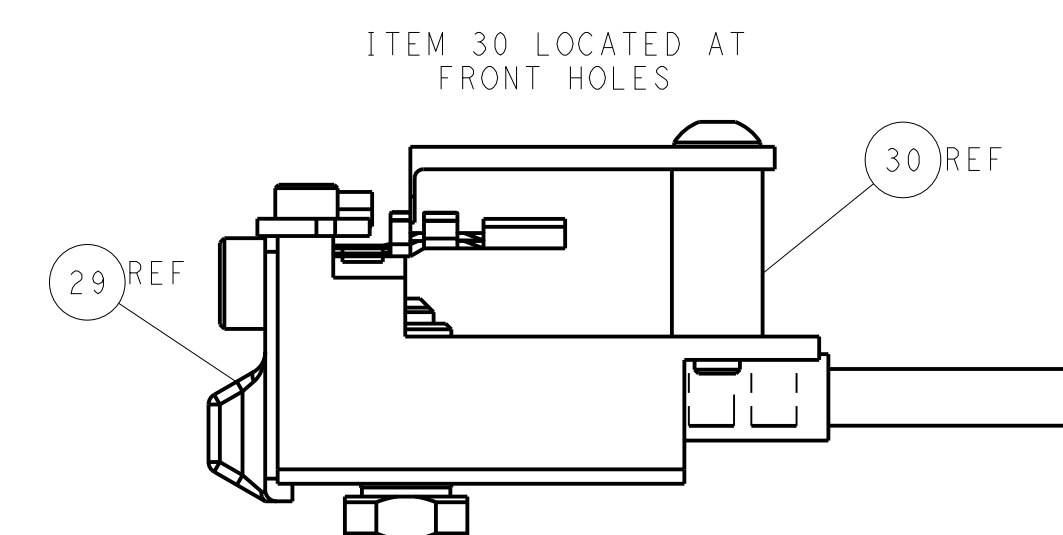
SHEAR DEPRESSOR DETAIL



TERMINAL SUPPORT LOCATION

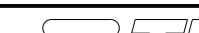
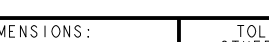


RAM SET-UP



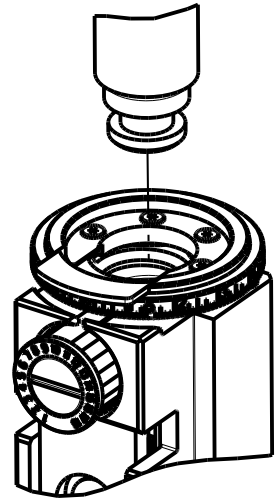
FEED TRACK POSITION
GUIDE BY INS BARREL

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 CONFIDENTIAL DOCUMENT FOR TECHNICAL SERVICES CORPORATION IT IS SUBJECT TO CHANGE AND THE CONTROLLING ENGINEERING ORGANIZATION SHOULD BE CONSULTED FOR THE LATEST REVISION		DWN C CHEN 29SEP2012	 TE Connectivity Harrisburg, PA 17105-3608			
DIMENSIONS: mm		CHK S_XI 29SEP2012				
TOLERANCES UNLESS OTHERWISE SPECIFIED:		APVD J CRUZ 29SEP2012	NAME Ocean Side Feed Applicator			
		PRODUCT SPEC -				
ANGLES 4 P.L.C. ±.		APPLICATION SPEC -				
MATERIAL -	FINISH -	WEIGHT -			SIZE A1	CAGE CODE 00779
Customer Accessible Production Drawing			SCALE 1-2	SHEET 2 of 4	REV C	

8		7	
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20		20	
© COPYRIGHT 20 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.			
PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2151388-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2151388-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151388-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.57 mm [.062]	F
INSUL	3.05 mm [.120]	O
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: ELO 0.63 SEALED TERMINAL			
WIRE STRIP LENGTH 3.70-3.90 mm [.146-.154 IN]		TERMINAL INSULATION DIAMETER RANGE Ø 2.60 mm MAX [.102 IN MAX]	
TERMINAL APPLICATION SPECIFICATION 114-18432			
TERMINAL APPLICATION SPECIFICATION			
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE SEAL	TE SEAL
2-1411573-1		1393457-1	
		SEAL INSULATION DIAMETER RANGE Ø 1.4-2.0mm	

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.75mm2	1.17+/-0.03 [.046+/-0.001]	4.5
0.50mm2	1.06+/-0.03 [.042+/-0.001]	5.6



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

*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		DESCRIPTION	DATE	DWN	APVD
				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	2844908-1	SCREW, LOCKING	99
-	1	1	2844907-1	POST, LOCKING	98
-	1	1	455888-5	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	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	2-2844962-8	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29
-	1	1	455888-3	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	318707-1	FLOATING SHEAR, FRONT	9
1	1	1	5-1333202-2	ANVIL, COMBINATION	8
-	-	-	-	-	7
-	-	-	-	-	6
-	1	1	2119781-1	DEPRESSOR, SHEAR	5
-	1	1	238011-4	BLOCK, CRIMPER SPACER	4
1	1	1	1633965-2	CRIMPER, INSULATION O PREMIUM	3
-	1	1	455888-3	SPACER, CRIMPER	2
1	1	1	4-657555-9	CRIMPER, WIRE PREMIUM	1

-77	-22	-21	PART NO	DESCRIPTION	ITEM NO
			OWN G. CHEN CHK S. XI APVD J. CRUZ		
			29SEP2012 29SEP2012 29SEP2012		
			TE Connectivity Harrisburg, PA 17105-3608		
			NAME Ocean Side Feed Applicator		
			SIZE 00779		
			CAGE CODE 2151388		
			DRAWING NO 2151388		
			RESTRICTED TO -		
			Customer Accessible Production Drawing		
			SCALE 1:2		
			SHEET 3		
			OF 4		
			REV C		

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

Diagram illustrating the front view of the machine assembly, showing the front plate (238) and front plate bracket (59). An arrow points to the front plate bracket (59) with the label "SEE DETAIL A". A small pin (56) is shown separately, likely for the front plate bracket.

DETAIL A

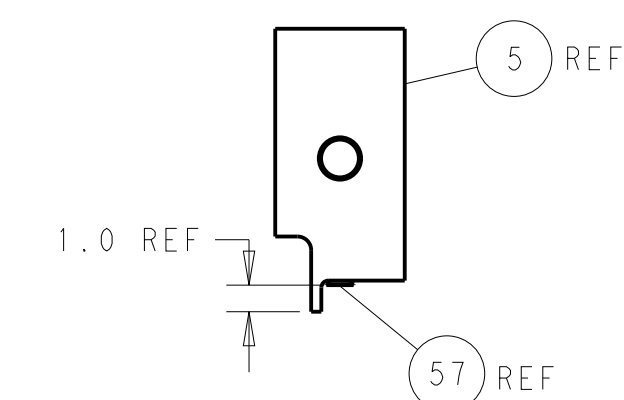
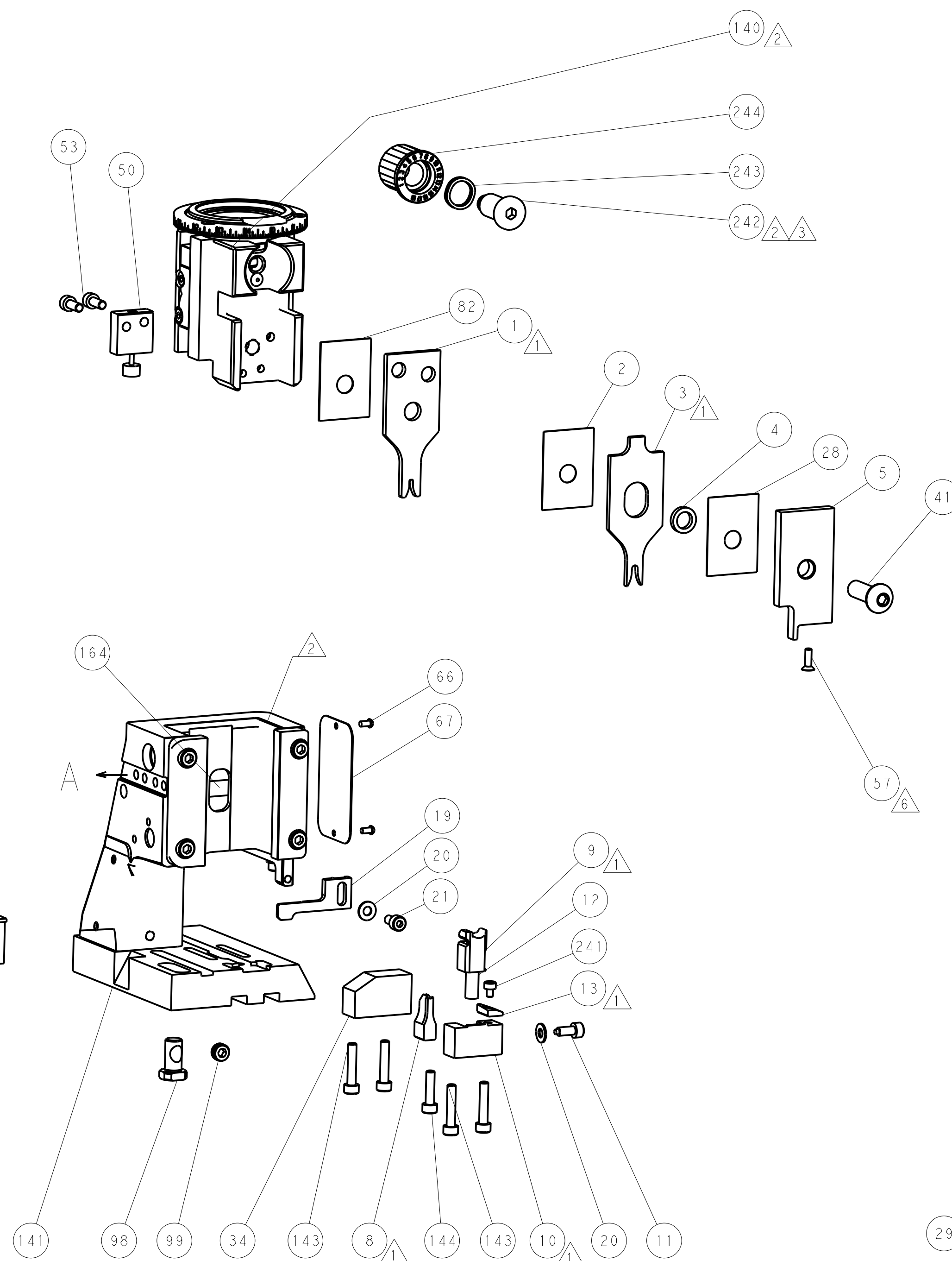
30mm STROKE

3mm GAP

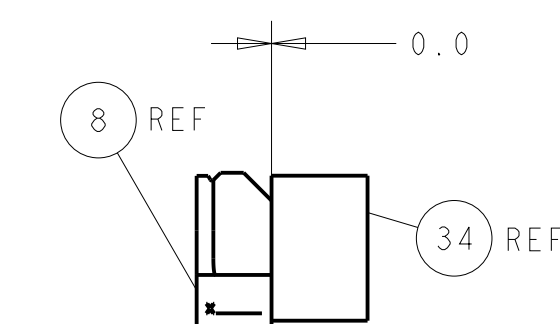
MECHANICAL POST FEED

MECHANICAL PRE FEED

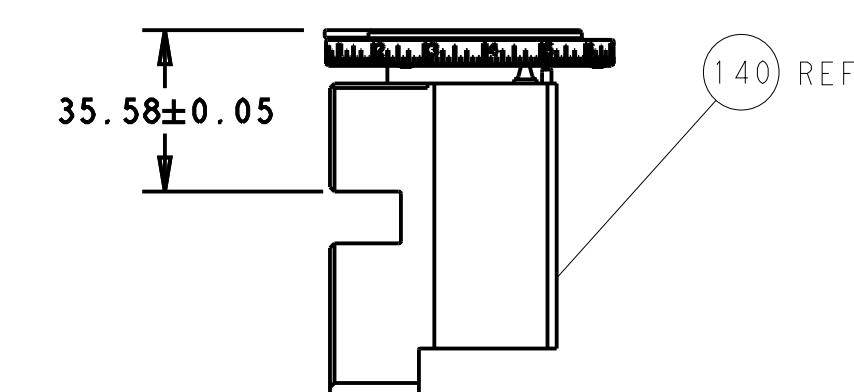
AIR FEED



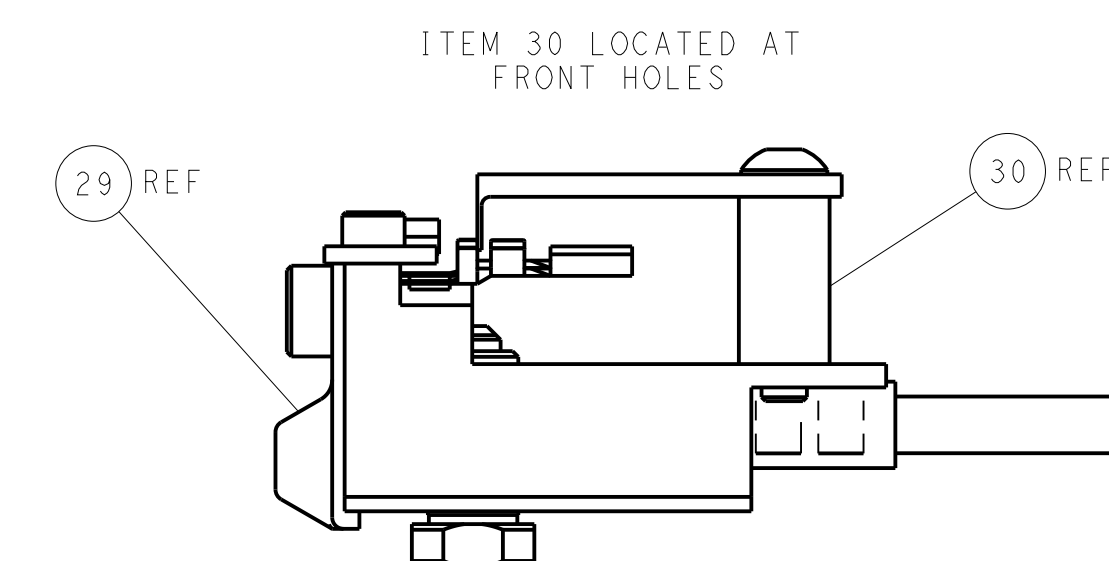
SHEAR DEPRESSOR DETAIL



TERMINAL SUPPORT LOCATION



RAM SET-UP



FEED TRACK POSITION
GUIDE BY INS 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 TECHNICAL SERVICES CORPORATION IT IS SUBJECT TO CHANGE AND THE CONTROLLING ENGINEERING ORGANIZATION SHALL BE NOTIFIED FOR THE LATEST REVISION		DWN E CHEN 29SEP2012		 TE Connectivity Harrisburg, PA 17105-3608	
CHK S.XI 29SEP2012		APVD L CRUZ 29SEP2012			
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		NAME Ocean Side Feed Applicator	
		0 PLC ±.1 1 PLC ±.1 2 PLC ±.1 3 PLC ±.1 4 PLC ±.1 ANGLES FINISH		PRODUCT SPEC - APPLICATION SPEC - WEIGHT -	
MATERIAL -		FINISH -		SIZE A 1	
				CAGE CODE 00779	
				DRAWING NO C=2151388	
				RESTRICTED TO -	
Customer Accessible Production Drawing				SCALE 1:2 SHEET A OF A REV C	

Mouser Electronics

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

[TE Connectivity:](#)

[2151388-1](#)