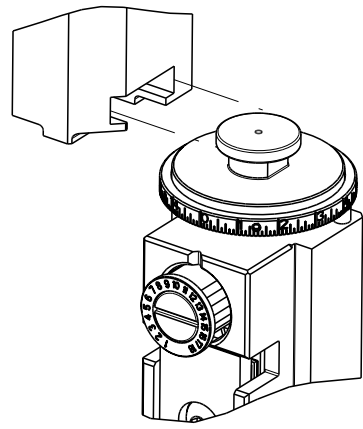


8	7	6	5	4	3	2	1
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE				
2151518-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL				
2151518-2	D	FINE CRIMP HEIGHT ADJUST	PNEUMATIC				
7-2151518-1	C	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL				
7-2151518-2	D	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC				
7-2151518-7	B	CRIMP TOOLING KIT	-				

ATLANTIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.40 mm [.055]	F
INSUL	3.30 mm [.130]	O
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: TE TERMINAL					TE CRIMP SPECIFICATION
TERMINAL NAME: HPF 1.5 MM SENSORKONTACT					
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE			
3.75-4.05 mm [.148-.159 IN]		Ø			
TERMINAL APPLICATION SPECIFICATION		114-18912			
		-			
		-			
TERMINALS APPLIED					5
TE TERMINAL	TE TERMINAL	TE SEAL	TE SEAL	INSULATION RANGE	
1563621-2	2296545-2	1-2290339-3		Ø 1.2-1.6mm	
2208363-3	2292289-1		967067-2	Ø 0.9-1.4mm	

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.35mm2	0.89+/-0.03 [.035+/- .001]	8.2



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

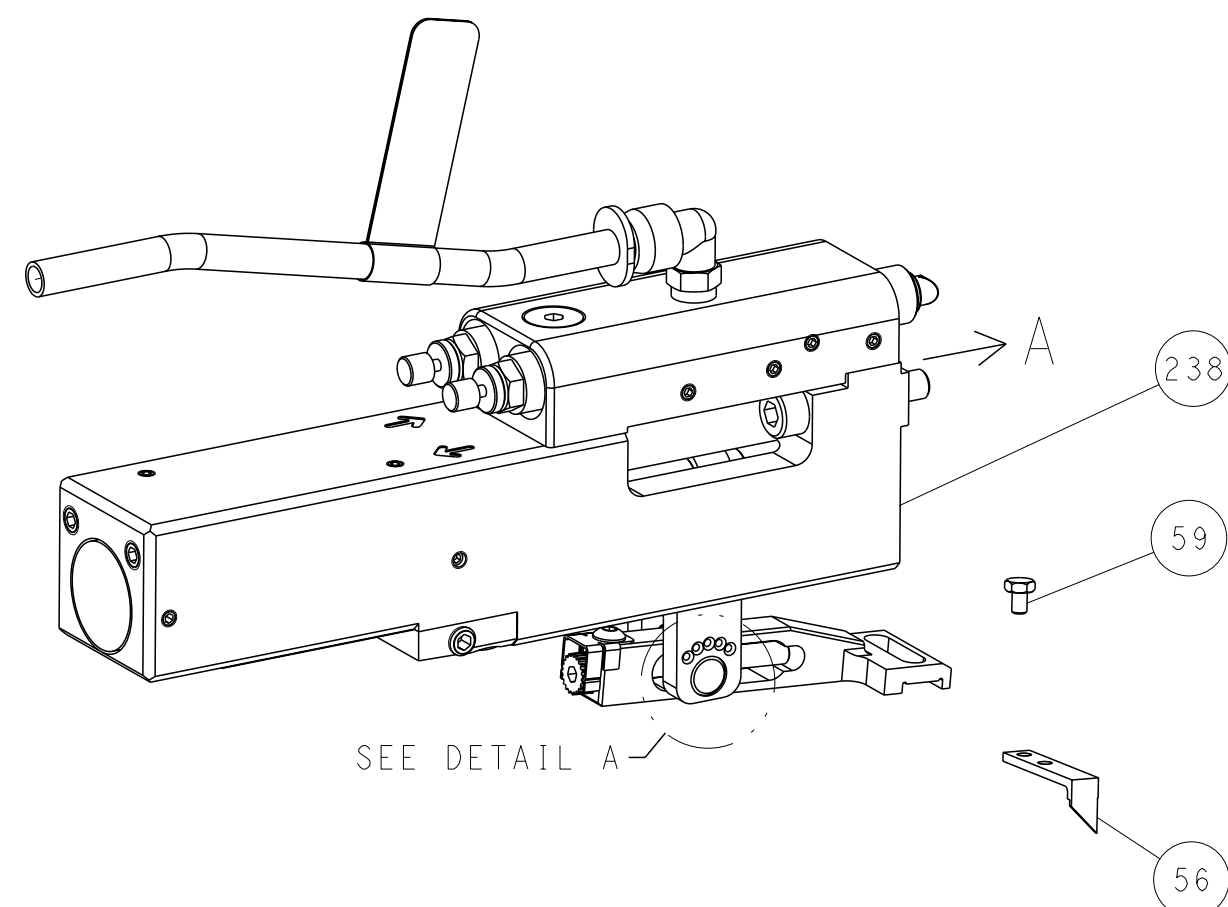
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			C	ECR-18-006179	23APR2018	TB
			D	ECR-19-011319	18JUL2019	FJ
			D1	ECR-21-001818	17FEB2021	JWC

-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248
-	1	1	1	1	2119082-8	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	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113
-	1	1	1	1	2844908-1	SCREW, LOCKING	99
-	1	1	1	1	2844907-1	POST, LOCKING	98
-	1	1	1	1	455888-7	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	1752356-6	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
-	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	1	1333332-1	ANVIL, COMBINATION, SPECIAL	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	1	2-1633996-7	CRIMPER, INSULATION SPECIAL	3
-	1	1	1	1	1-455888-3	SPACER, CRIMPER	2
1	2	2	1	1	5-1633860-6	CRIMPER, WIRE	1
-77	-72	-71	-2	-1	PART NO	DESCRIPTION	ITEM NO

THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE AND TO BE CONTROLLED BY THE ENGINEERING ORGANIZATION. IT SHOULD BE CONTACTED FOR THE LATEST REVISION.				OWN	X. ZHAO	14MAR2013	TE Connectivity Harrisburg, PA 17105-3608				
				CHK	L. ZHANG	14MAR2013					
				APVD	L. ZHANG	14MAR2013	NAME Ocean Side Feed Applicator -				
DIMENSIONS:				PRODUCT SPEC							
mm				APPLICATION SPEC							
				FINISH							
MATERIAL				WEIGHT		SIZE					
						A1 00779 C=2151518					
						Customer Accessible Production Drawing					
						SCALE 1:2 SHEET 1 of 4 REV D1					

SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

PNEUMATIC



DETAIL A

30mm STROKE

40mm STROKE

MECHANICAL POST FEED

30mm STROKE

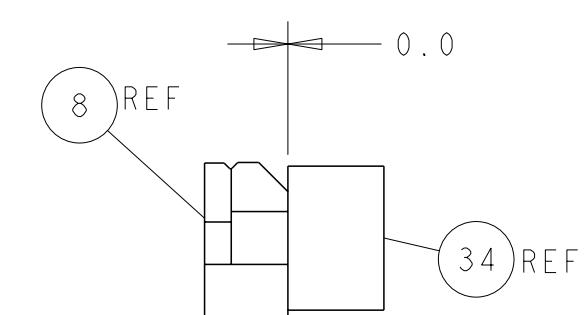
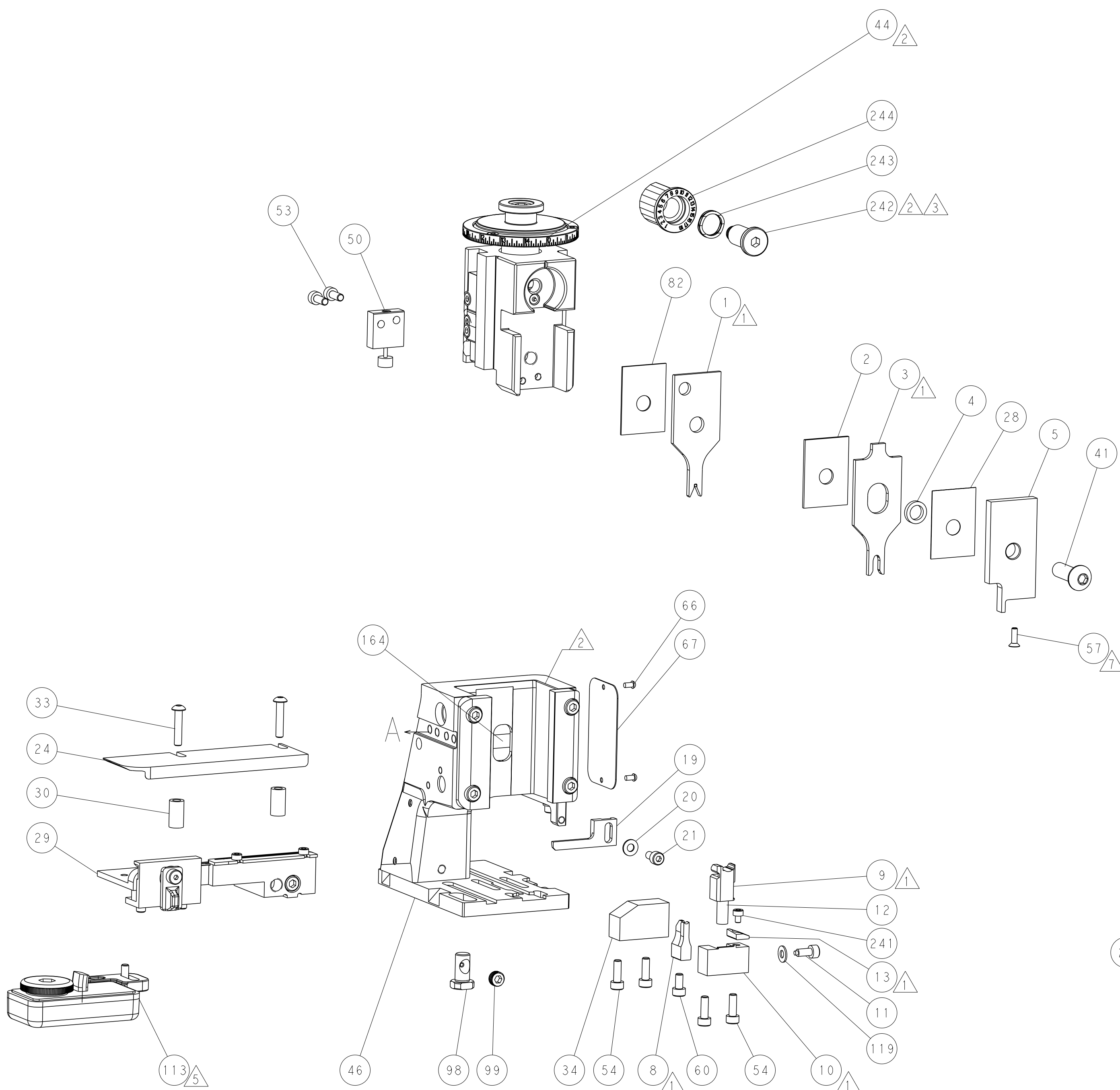
40mm STROKE

MECHANICAL PRE FEED

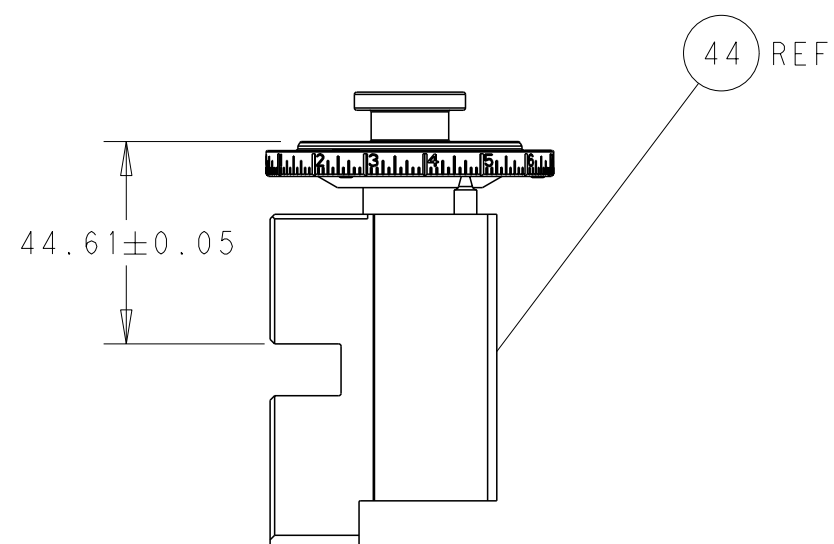
30mm STROKE

40mm STROKE

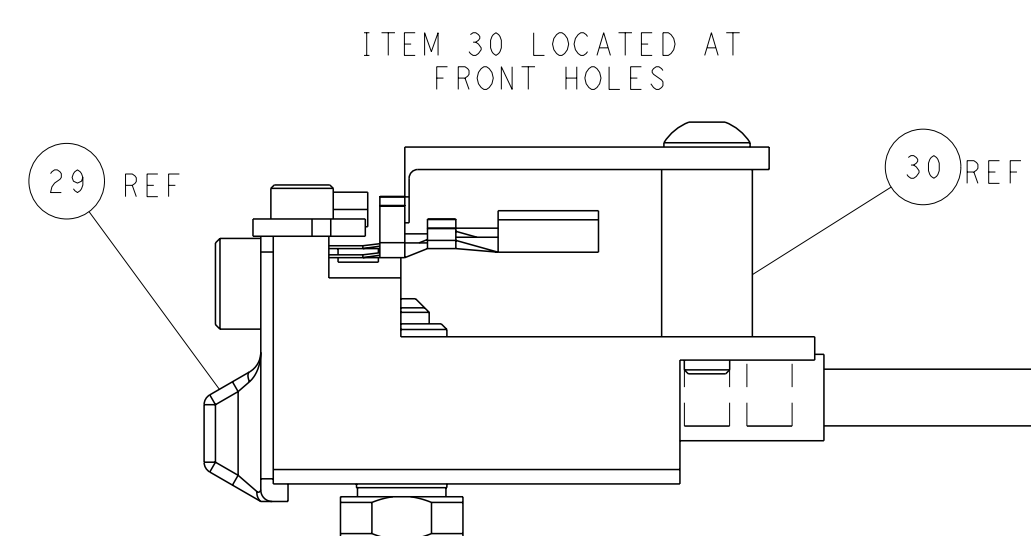
AIR FEED



TERMINAL SUPPORT LOCATION

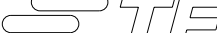


RAM SET-UP



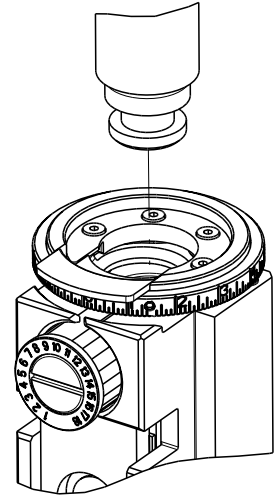
FEED TRACK POSITION
GUIDE BY INSULATION BARREL

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 CONTROLLED DOCUMENT FOR TATE ELECTRONICS CORPORATION 1715 JOURNAL RD. TATE ELECTRONICS CORPORATION SHOULD BE CONTACTED FOR THE LATEST REVISION		DWN 14MAR2013 CHK X_ZHAO 14MAR2013 APVD L_ZHANG 14MAR2013		 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=2151518	
				RESTRICTED TO -	
Customer Accessible Production Drawing				SCALE 1:2 SHEET 2 of 4 REV D	

8		7	
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20		20	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2151518-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2151518-2	D	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151518-7	B	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.40 mm [.055]	F
INSUL	3.30 mm [1.30]	O
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: HPF 1.5 MM SENSORKONTACT			
WIRE STRIP LENGTH 3.75-4.05 mm [1.48-.159 IN]			INSULATION DIAMETER RANGE Ø
TERMINAL APPLICATION SPECIFICATION		114-18912	- - -

TERMINALS APPLIED				
TE TERMINAL	TE TERMINAL	TE SEAL	TE SEAL	INSULATION RANGE
1563621-2	2296545-2	1-2290339-3	964971-1	Ø 1.2-1.6mm
2208363-3	2292289-1		967067-2	Ø 0.9-1.4mm

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.35mm2	0.89+/-0.03 [1.035+/-1.001]	8.2



- 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

TERMINAL LUBRICANT IS RECOMMENDED.
- 6

UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- 7

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)

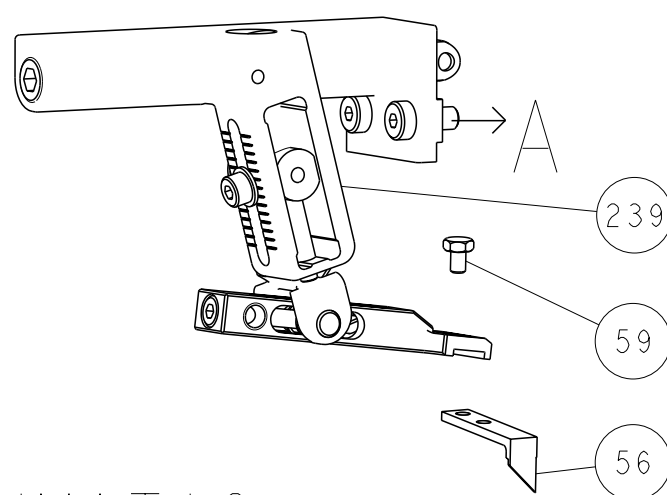
LOC	DIST	REVISIONS				
		#	LYR	DESCRIPTION	DATE	OWN
A	66	-	-	SEE SHEET 1	-	-

-	1	1	2119082-8	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
5	-	1	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113
-	1	1	2844908-1	SCREW, LOCKING	99
-	1	1	2844907-1	POST, LOCKING	98
-	1	1	455888-7	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
7	-	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	1752356-6	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
-	1	1	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	1333332-1	ANVIL, COMBINATION, SPECIAL	8
-	-	-	-	-	7
-	-	-	-	-	6
-	1	1	2119781-1	DEPRESSOR, SHEAR	5
-	1	1	238011-4	BLOCK, CRIMPER SPACER	4
1	1	1	2-1633996-7	CRIMPER, INSULATION SPECIAL	3
-	1	1	1-455888-3	SPACER, CRIMPER	2
1	1	1	5-1633860-6	CRIMPER, WIRE	1

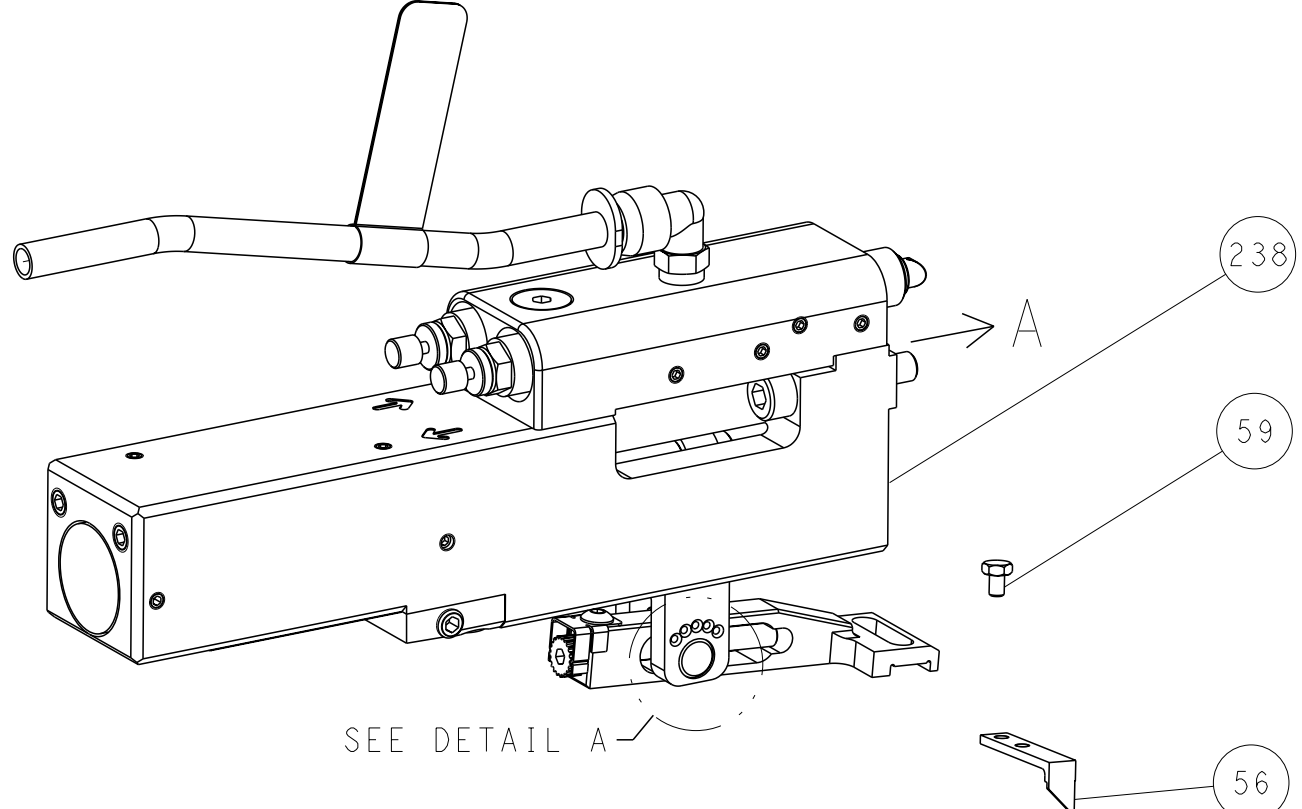
THIS DRAWING IS A CONTROLLED DOCUMENT FOR THE ELECTRICAL CONSTRUCTION OF THE PRODUCT. IT IS SUBJECT TO CHANGE AND TO THE CONTROL OF THE ENGINEERING ORGANIZATION. IT SHOULD BE CONTACTED FOR THE LATEST REVISION.		OWN X. ZHAO CHK L. ZHANG APVD I. ZHANG	14MAR2013 14MAR2013 14MAR2013	TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH *		NAME Ocean Side Feed Applicator	
MATERIAL -		WEIGHT -		SIZE A1	
				CAGE CODE 00779	
				DRAWING NO 2151518	
				RESTRICTED TO -	
				Customer Accessible Production Drawing	
				SCALE 1:2	
				SHEET 3	
				OF 4	
				REV D1	

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

FEED TYPE
MECHANICAL

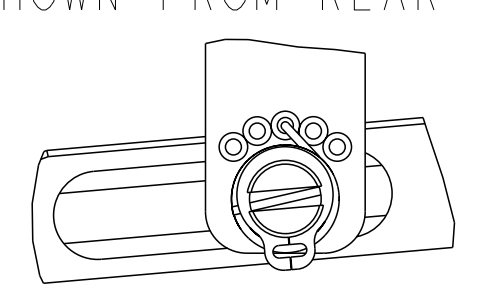


PNEUMATIC



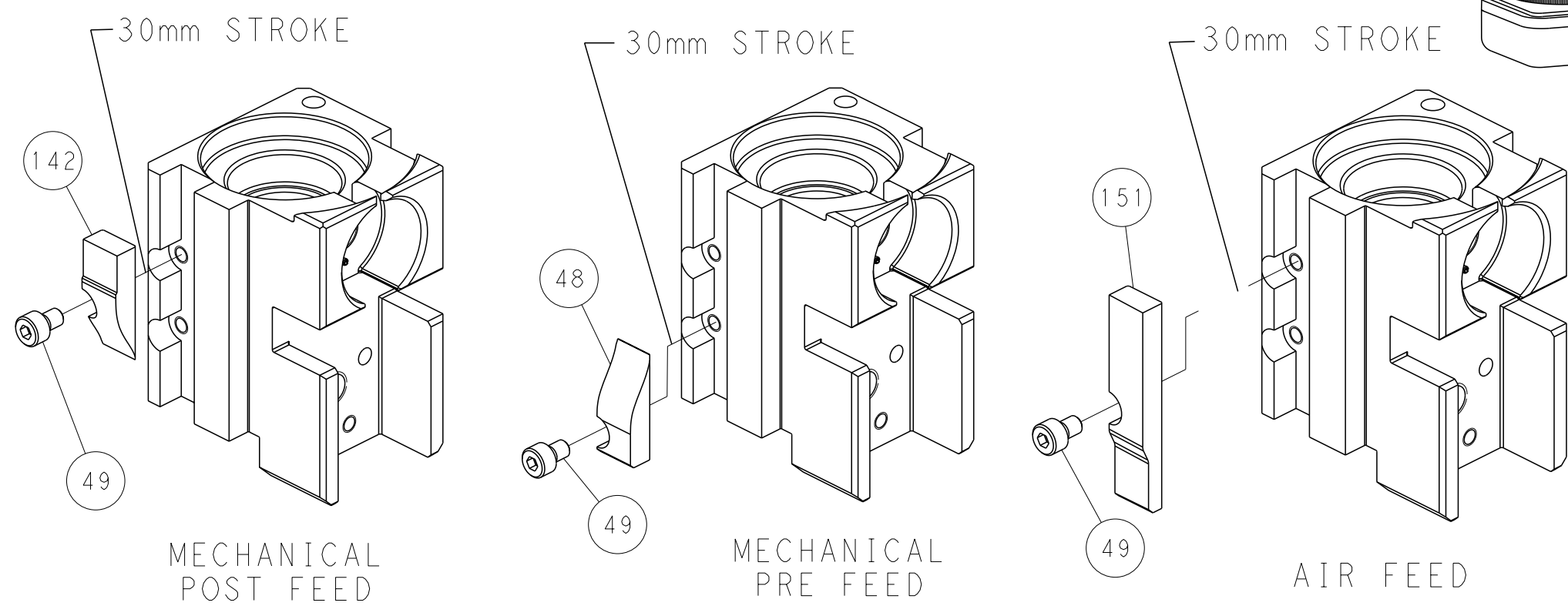
SEE DETAIL A

FEED SPRING SETTING POSITION
(SHOWN FROM REAR SIDE)



DETAIL A

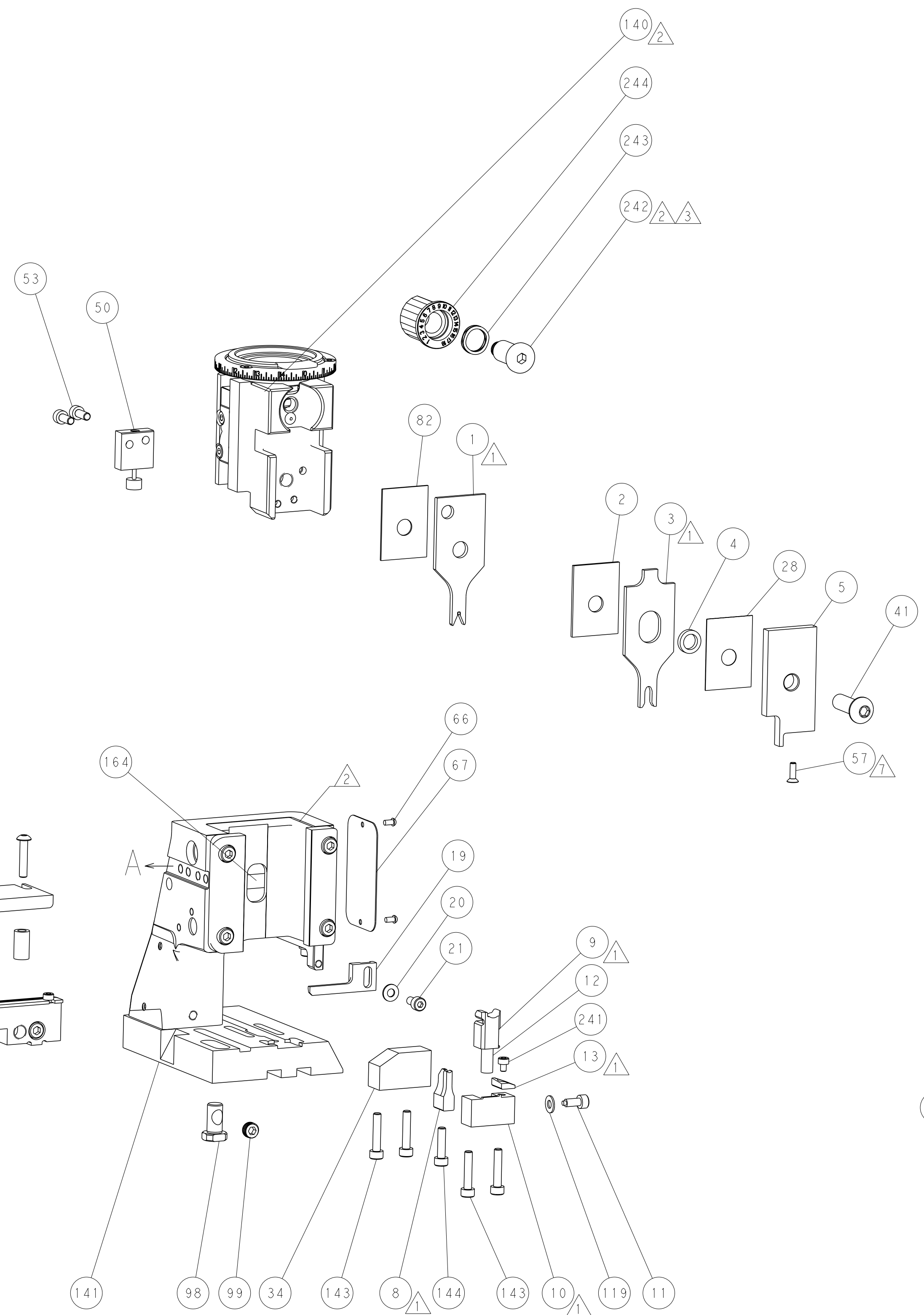
CAM POSITIONS



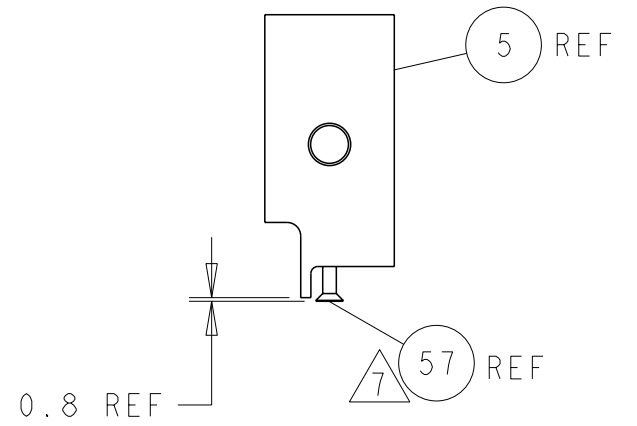
MECHANICAL
POST FEED

MECHANICAL
PRE FEED

AIR FEED



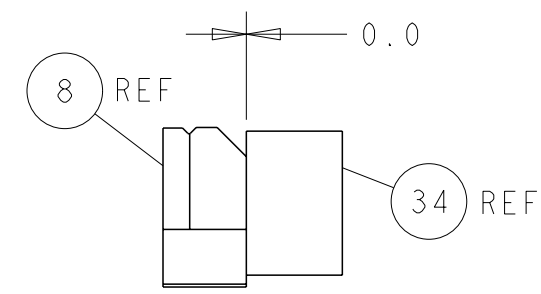
SHEAR DEPRESSOR DETAIL



0.8 REF

SHEAR DEPRESSOR DETAIL

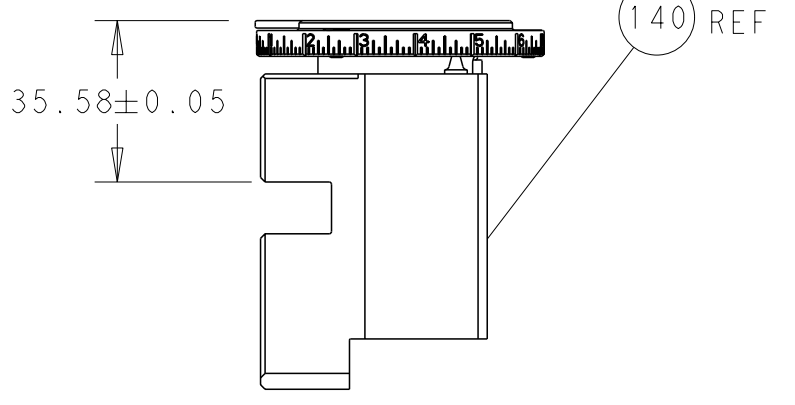
TERMINAL SUPPORT LOCATION



0.0

TERMINAL SUPPORT LOCATION

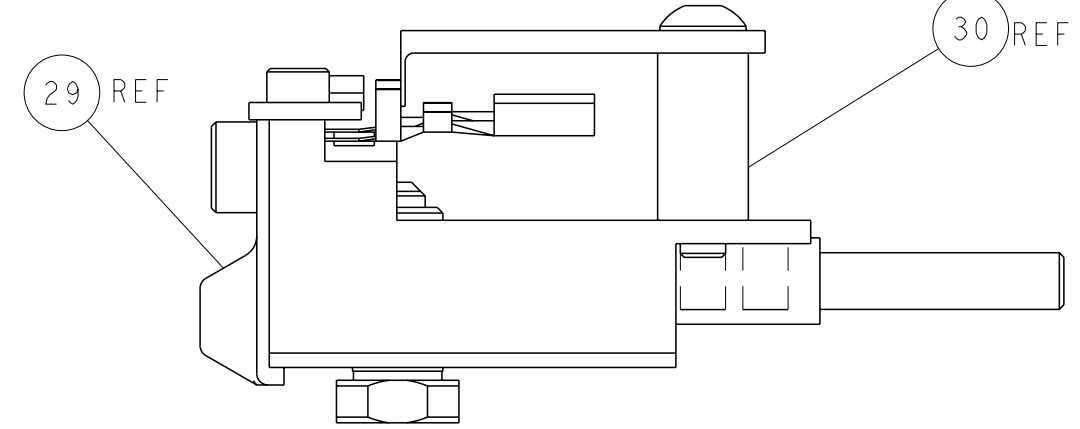
RAM SET-UP



35.58±0.05

RAM SET-UP

FEED TRACK POSITION
GUIDE BY INSULATION BARREL



29 REF

30 REF

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)

DIMENSIONS:

mm

TOLERANCES UNLESS
OTHERWISE SPECIFIED:

0 PLC ±

1 PLC ±

2 PLC ±

3 PLC ±

4 PLC ±

ANGLES ±

FINISH *

MATERIAL

-

DWN X. ZHAO 14MAR2013

CHK L. ZHANG 14MAR2013

APVD L. ZHANG 14MAR2013

PRODUCT SPEC

APPLICATION SPEC

WEIGHT

Customer Accessible Production Drawing

NAME Ocean Side Feed Applicator

SIZE A1

CAGE CODE 00779

DRAWING NO. C=2151518

SCALE 1:2

SHEET 4

OF 4

REV D1

TE Connectivity

Harrisburg, PA 17105-3608

AMF 4805 REV 31MAR2000

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

Mouser Electronics

Authorized Distributor

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

[TE Connectivity:](#)

[7-2151518-7](#)