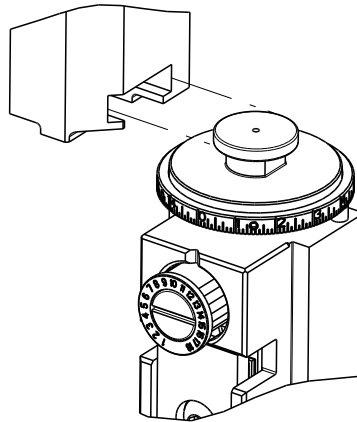
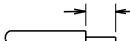


8		7	
THIS DRAWING IS UNPUBLISHED.		RELEASED FOR PUBLICATION	
20		20	
COPYRIGHT 20 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.			
PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151232-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2151232-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151232-1	C	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2151232-2	C	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2151232-7	B	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.57 mm [.062]	F
INSUL	2.29 mm [.090]	OV
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: 1.6 CIRCULAR CONTACT			
WIRE STRIP LENGTH 3.90-4.70 mm [.154-.185 IN]			INSULATION DIAMETER RANGE Ø1.15-1.40 mm [.045-.055 IN]
TERMINAL APPLICATION SPECIFICATION 		114-20121	-
		-	-
TERMINALS APPLIED			
TE TERMINAL 1437709-3	TE TERMINAL 1437709-6	TE TERMINAL 1437709-9	TE TERMINAL 1-1437709-1
1-1437709-4			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.35mm2	1.03+/-0.03 [.041+/- .001]	8.5
0.30mm2	1.00+/-0.03 [.039+/- .001]	8.8
0.22mm2	0.96+/-0.03 [.038+/- .001]	9.1



- 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.
APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 180
- 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.

*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	REVISIONS				
		P	LTR	DESCRIPTION	DATE	DWN
A	66		A	RELEASED	25SEP2013	KH
			B	ECR-17-001554	02FEB2017	TB
			C	ECR-21-122968	02DEC2021	JWC

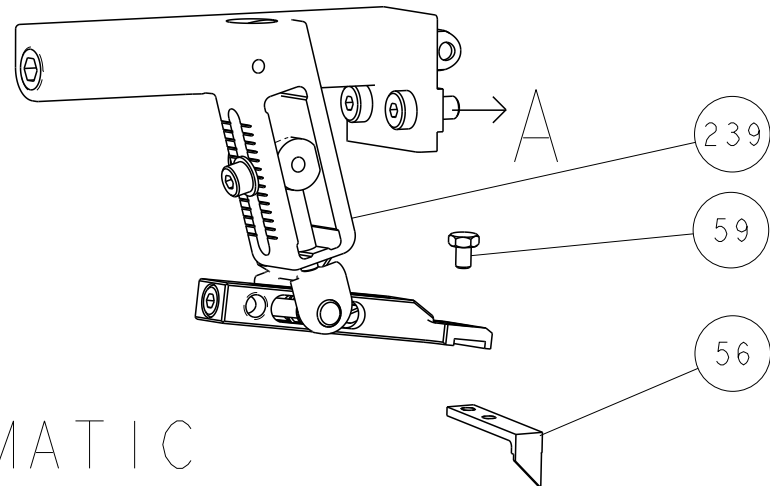
-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248
-	1	1	1	1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	1	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
-	-	1	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	1	-	1	-	2844940-1	AIR FEED MODULE	238
-	1	1	1	1	2-1752354-0	STANDOFF,HOLD-DOWN	180
-	1	1	1	1	9931111-1	PIN, SLOTTED SPRING 3.0 X 20.0	177
-	1	1	1	1	8-22280-7	SPRING, COMPRESSION	176
-	1	1	1	1	1752353-2	GUIDE PIN,HOLDDOWN	175
-	1	1	1	1	1901680-2	GUIDE PIN,HOLDDOWN	174
-	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	455888-4	SPACER, CRIMPER	82
-	1	1	1	1	1803607-1	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	1338685-1	PAWL, FEED	56
-	4	4	4	4	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	54
-	1	1	1	1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52
-	1	1	1	1	1901681-1	HOLDDOWN, TERMINAL	51
-	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	1803515-3	RAM ASSEMBLY, SF ATLANTIC	44
-	1	1	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
-	1	1	1	1	1-1752356-3	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	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	462006-6	FLOATING SHEAR, FRONT	9
1	2	2	1	1	8-1333202-4	ANVIL, COMBINATION	8
-	-	-	-	-	-	-	7
-	-	-	-	-	-	-	6
-	1	1	1	1	2119757-8	DEPRESSOR, SHEAR	5
-	1	1	1	1	238011-4	BLOCK, CRIMPER SPACER	4
1	1	2	1	1	1633963-6	CRIMPER, INSULATION OVERLAP PREMIUM	3
-	1	1	1	1	455888-4	SPACER, CRIMPER	2
1	2	2	1	1	1-456403-5	CRIMPER, WIRE PREMIUM	1
-77-72-71	-2	-1			PART NO	DESCRIPTION	ITEM NO

THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. ANY ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST EDITION.				DWN R. HUANG 20AUG2013	TE Connectivity Harrisburg, PA 17105-3608						
CHK L. ZHANG 20AUG2013				APVD J. GUO 20AUG2013	NAME Ocean Side Feed Applicator						
DIMENSIONS: mm				TOLERANCES UNLESS OTHERWISE SPECIFIED:							
				PRODUCT SPEC							
				-							
				APPLICATION SPEC							
				-							
				SIZE CAGE CODE DRAWING NO							
RESTRICTED TO											
MATERIAL				WEIGHT							
-				A1 00779 C=2151232							
Customer Accessible Production Drawing				SCALE 1:2 SHEET 1 OF 4 REV C							

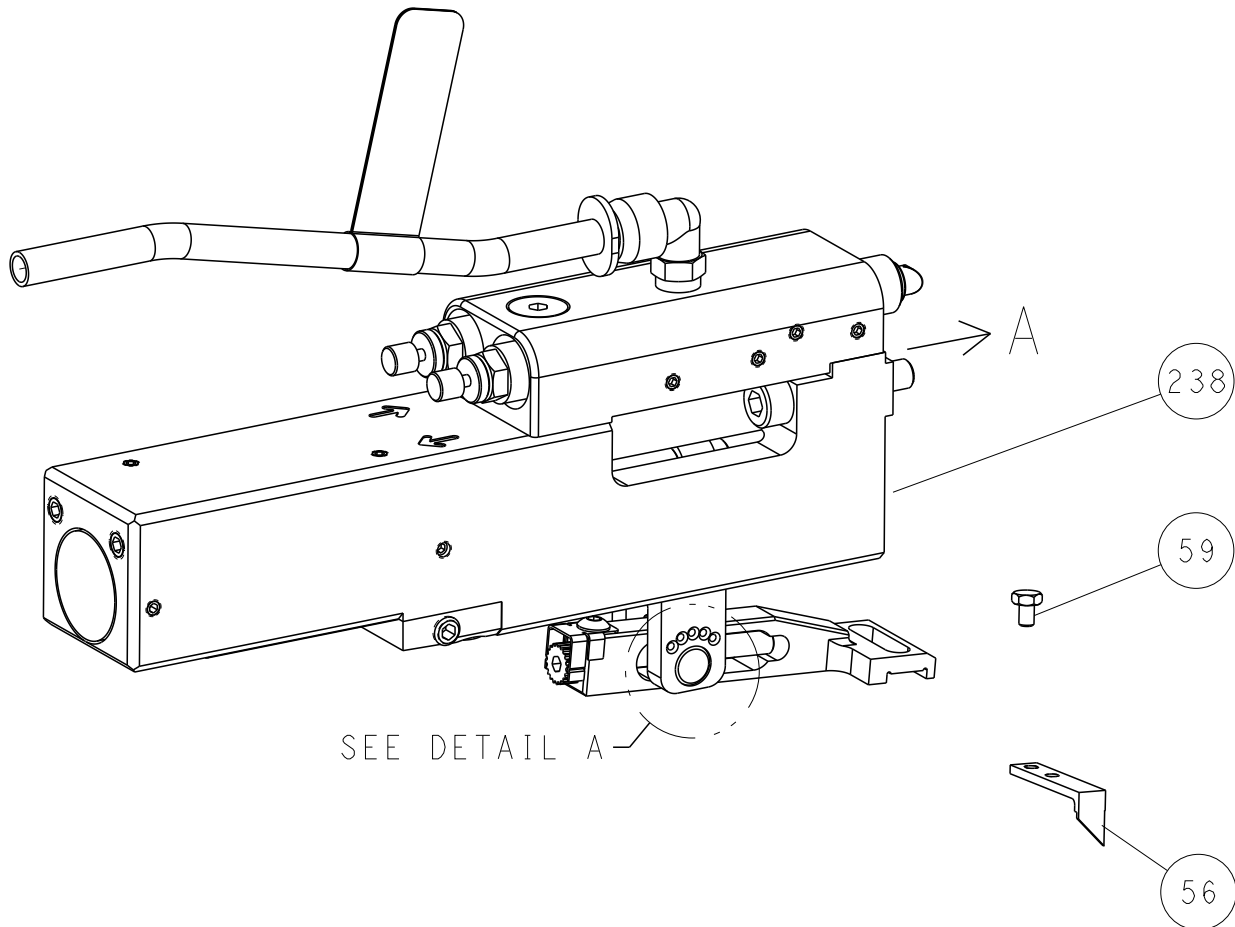
SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

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

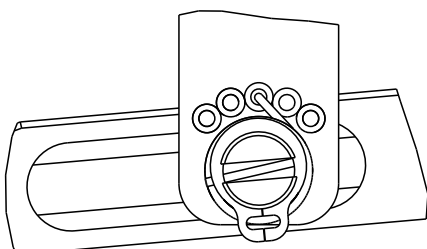
FEED TYPE MECHANICAL



PNEUMATIC

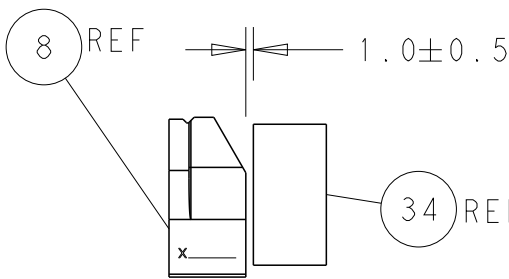
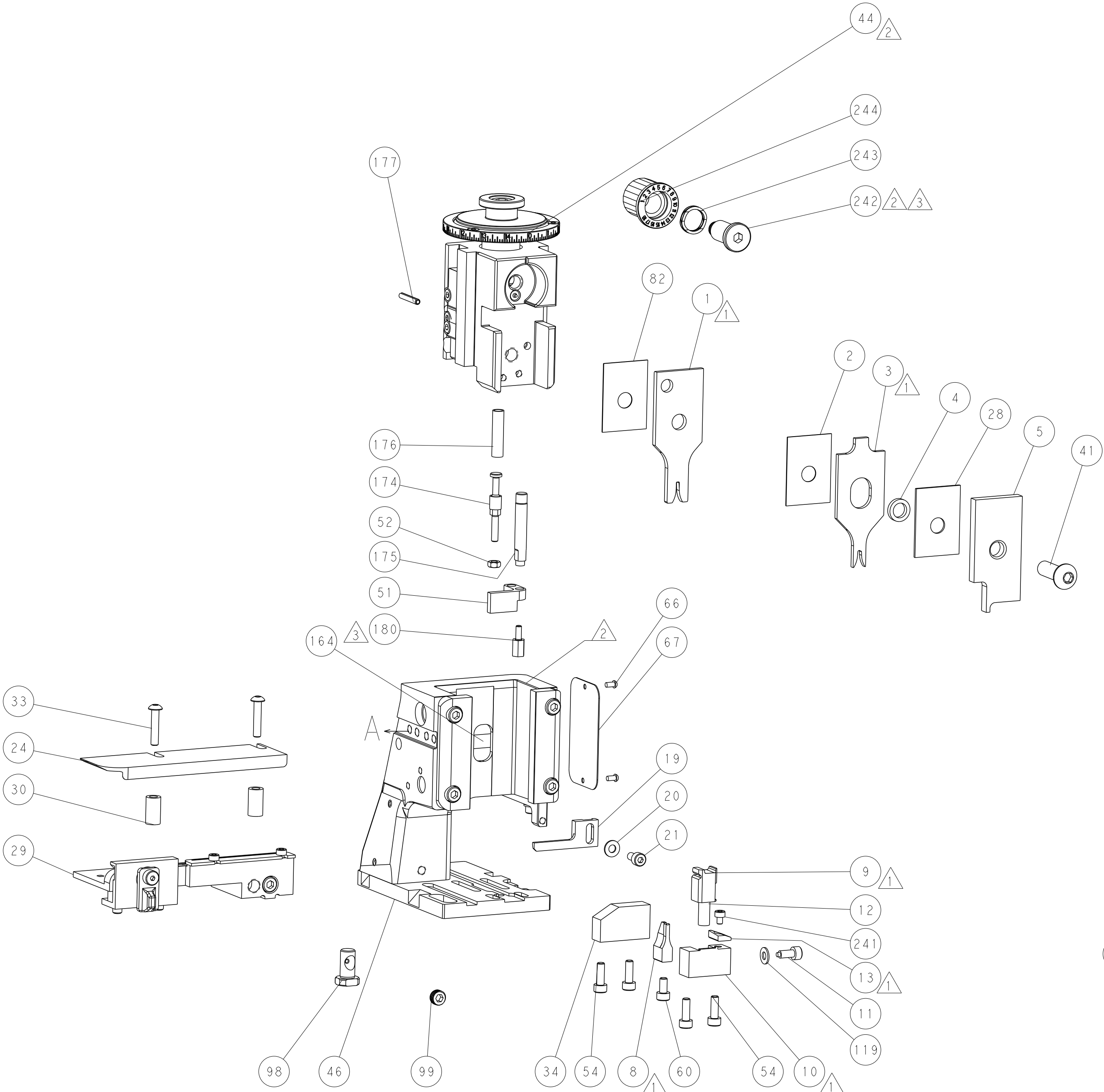
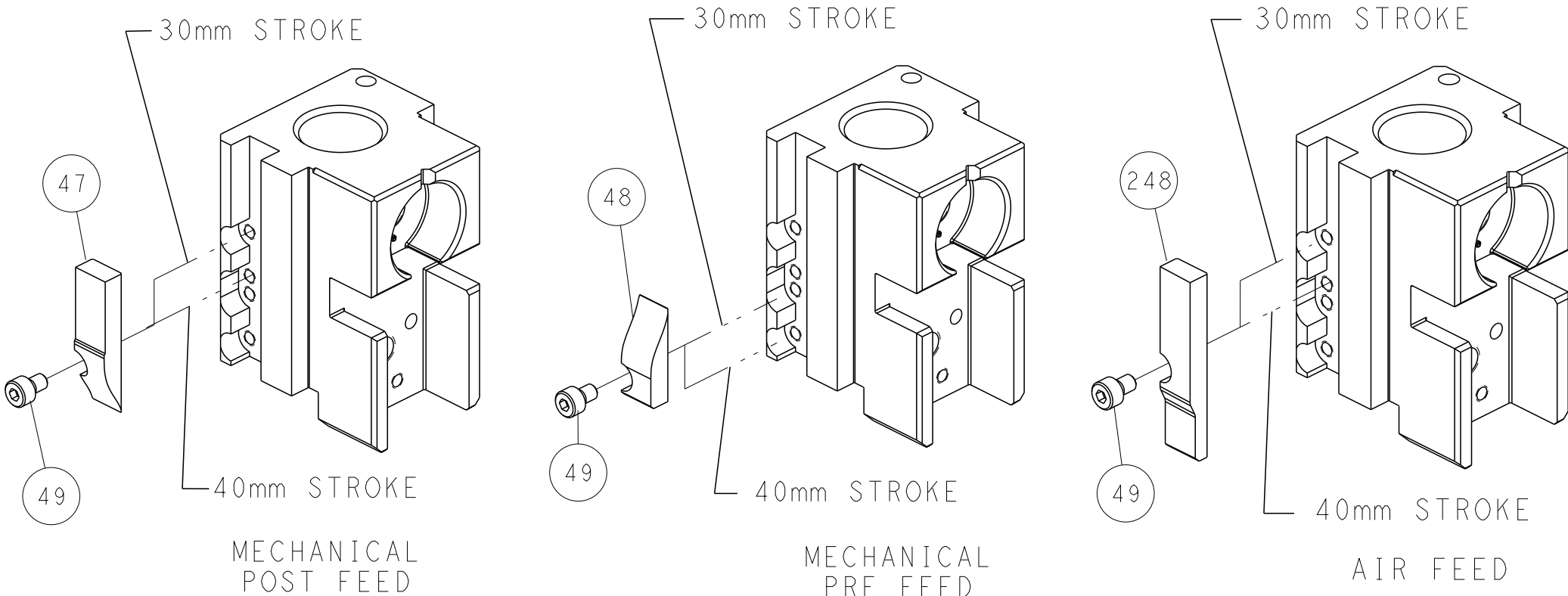


FEED SPRING SETTING POSITION
(SHOWN FROM REAR SIDE)

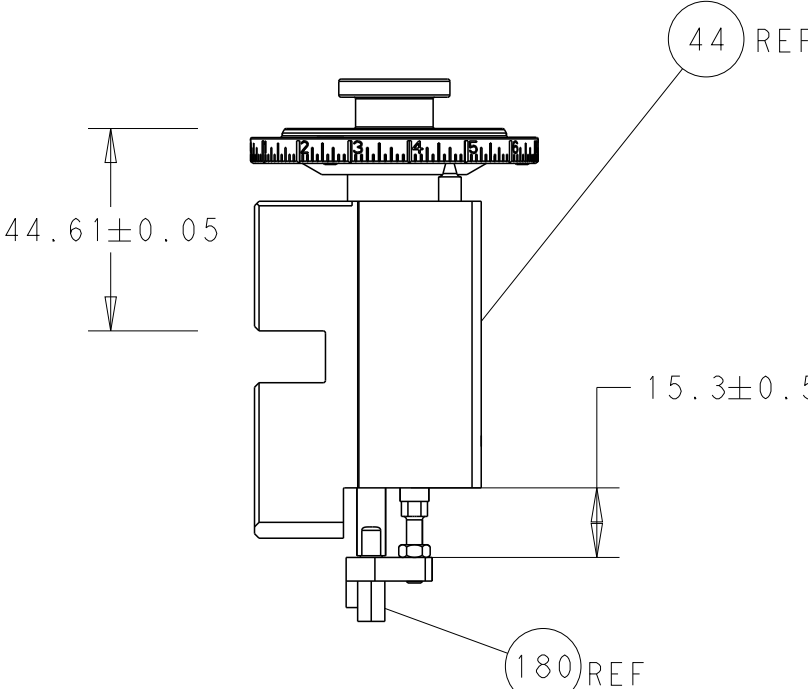


DETAIL A

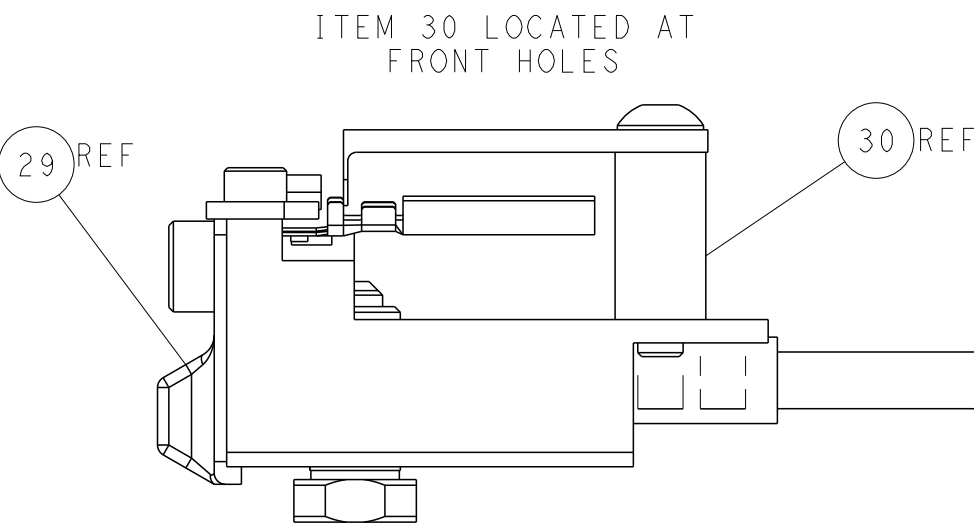
CAM POSITIONS



TERMINAL SUPPORT LOCATION



RAM AND HOLDDOWN SET-UP



FEED TRACK POSITION
GUIDE BY INSULATION BARREL

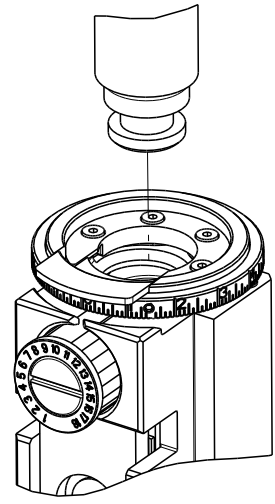
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. IT IS THE RESPONSIBILITY OF THE USER TO VERIFY THE DIMENSIONS AND TOLERANCES OF THE PARTS AND ASSEMBLY BEFORE USE.				DWN: K. HUANG 20AUG2013 CHK: L. ZHANG 20AUG2013 APVD: J. GUO 20AUG2013				TE Connectivity Harrisburg, PA 17105-3608			
DIMENSIONS:				TOLERANCES UNLESS OTHERWISE SPECIFIED:				NAME: Ocean Side Feed Applicator			
mm				0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH				SIZE: A1			
MATERIAL: -				WEIGHT: -				CAGE CODE: 00779			
								DRAWING NO: C-2151232			
								RESTRICTED TO: -			
								Customer Accessible Production Drawing			
								SCALE: 1:2			
								SHEET: 2 OF 4			
								REV: C			

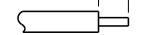
SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

8		7	
THIS DRAWING IS UNPUBLISHED.		RELEASED FOR PUBLICATION	
20		20	
COPYRIGHT 20		BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.	
PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2151232-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2151232-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151232-7	B	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.57 mm [.062]	F
INSUL	2.29 mm [.090]	OV
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: 1.6 CIRCULAR CONTACT			
WIRE STRIP LENGTH			INSULATION DIAMETER RANGE
3.90-4.70 mm [.154-.185 IN]			Ø1.15-1.40 mm [.045-.055 IN]
TERMINAL APPLICATION SPECIFICATION	114-20121	-	-
	-	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
1437709-3	1437709-6	1437709-9	1-1437709-1
1-1437709-4			

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING	
0.35mm2		1.03+/-0.03 [.041+/-0.001]		8.5	
0.30mm2		1.00+/-0.03 [.039+/-0.001]		8.8	
0.22mm2		0.96+/-0.03 [.038+/-0.001]		9.1	



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. APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 180
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.

*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)

2		1					
LOC	DIST	REVISIONS					
A	66	P	LTR	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
3	-	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
3	-	1	1	2-1752354-0	STANDOFF, HOLD-DOWN	180
	-	1	1	9931111-1	PIN, SLOTTED SPRING 3.0 X 20.0	177
	-	1	1	8-22280-7	SPRING, COMPRESSION	176
	-	1	1	1752353-2	GUIDE PIN, HOLDDOWN	175
	-	1	1	1901680-2	GUIDE PIN, HOLDDOWN	174
	-	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	455888-4	SPACER, CRIMPER	82
	-	1	1	1803607-1	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
	-	1	1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52
	-	1	1	1901681-1	HOLDDOWN, TERMINAL	51
	-	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	1-1752356-3	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	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
	-	1	1	2119533-1	STRIPPER, SIDE FEED	19
1	-	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	462006-6	FLOATING SHEAR, FRONT	9
1	1	1	1	8-1333202-4	ANVIL, COMBINATION	8
	-	-	-	-	-	7
	-	-	-	-	-	6
	-	1	1	2119757-8	DEPRESSOR, SHEAR	5
	-	1	1	238011-4	BLOCK, CRIMPER SPACER	4
1	1	1	1	1633963-6	CRIMPER, INSULATION OVERLAP PREMIUM	3
	-	1	1	455888-4	SPACER, CRIMPER	2
1	1	1	1	1-456403-5	CRIMPER, WIRE PREMIUM	1
-77	-22	21	PART NO		DESCRIPTION	ITEM NO

THIS DOCUMENT IS A CONTROLLED DOCUMENT AND THE INFORMATION CONTAINED HEREIN IS THE PROPERTY OF THE COMPANY. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. THE COMPANY SHALL BE CONTACTED FOR THE LATEST EDITION.		DWN R. HUANG CHK L. ZHANG APVD J. GUO	20AUG2013 20AUG2013 20AUG2013	TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		NAME	
mm		0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH ±		Ocean Side Feed Applicator	
MATERIAL		WEIGHT		SIZE CASE CODE DRAWING NO	
-		-		A1 00779 C=2151232	
Customer Accessible Production Drawing		SCALE		SHEET 3 OF 4	
				REV C	

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

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

D

C

B

A

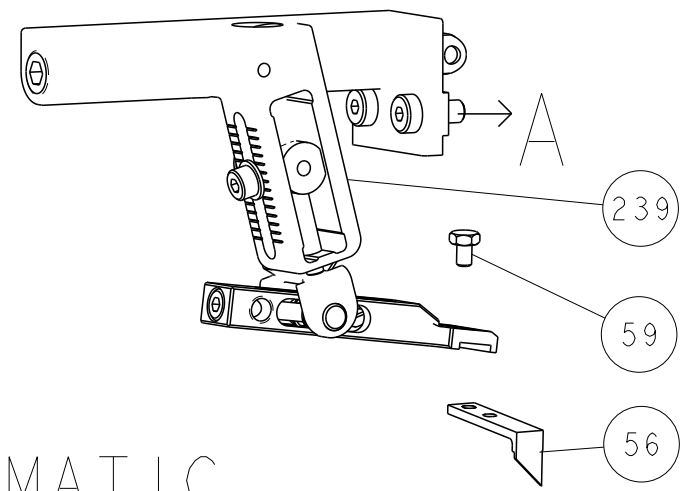
D

C

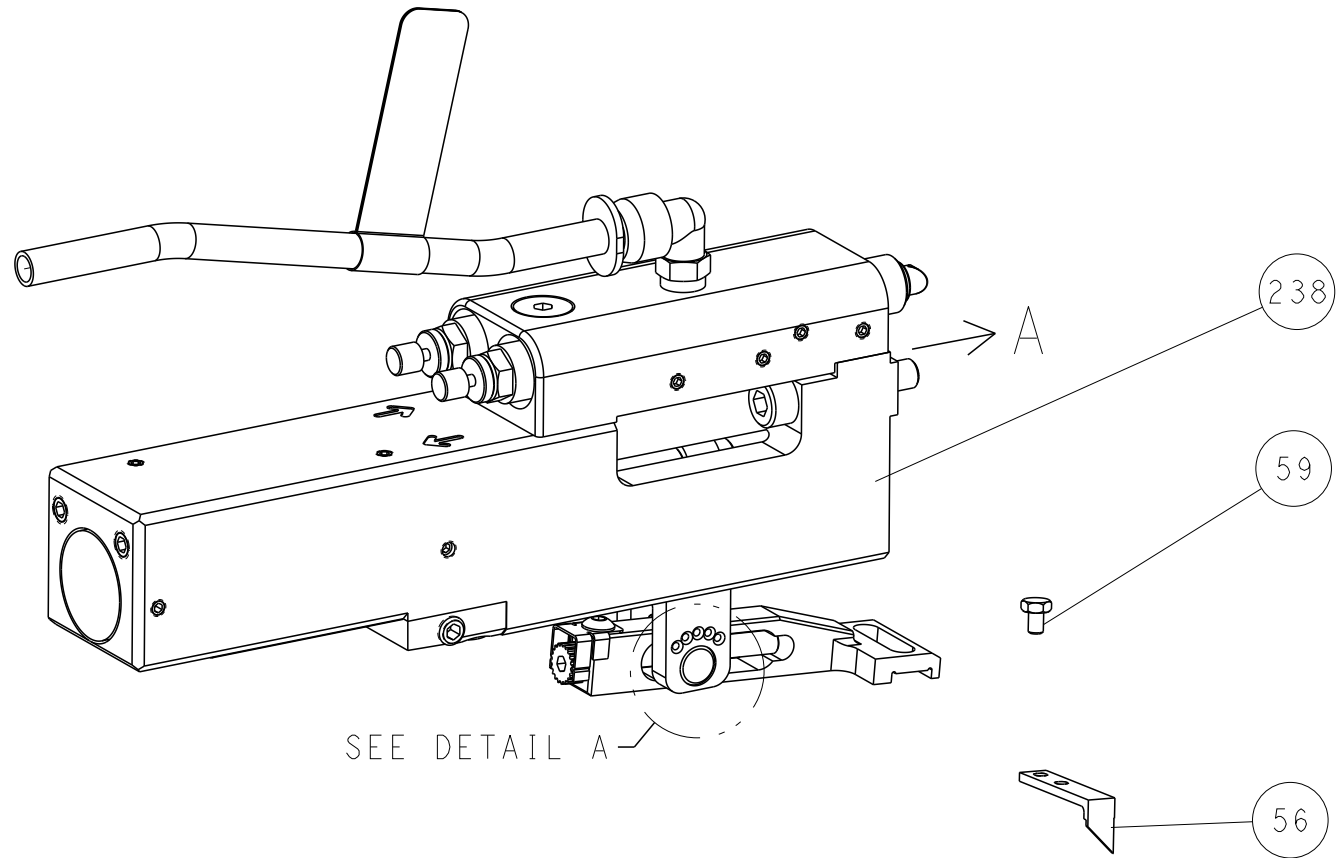
B

A

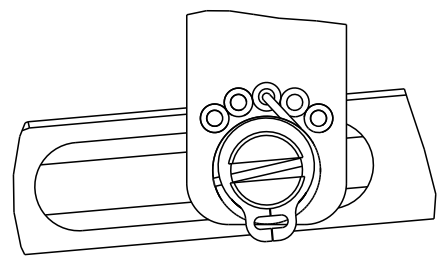
FEED TYPE MECHANICAL



PNEUMATIC

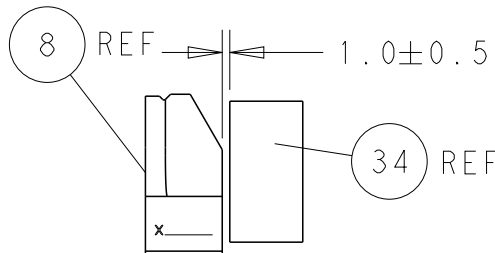
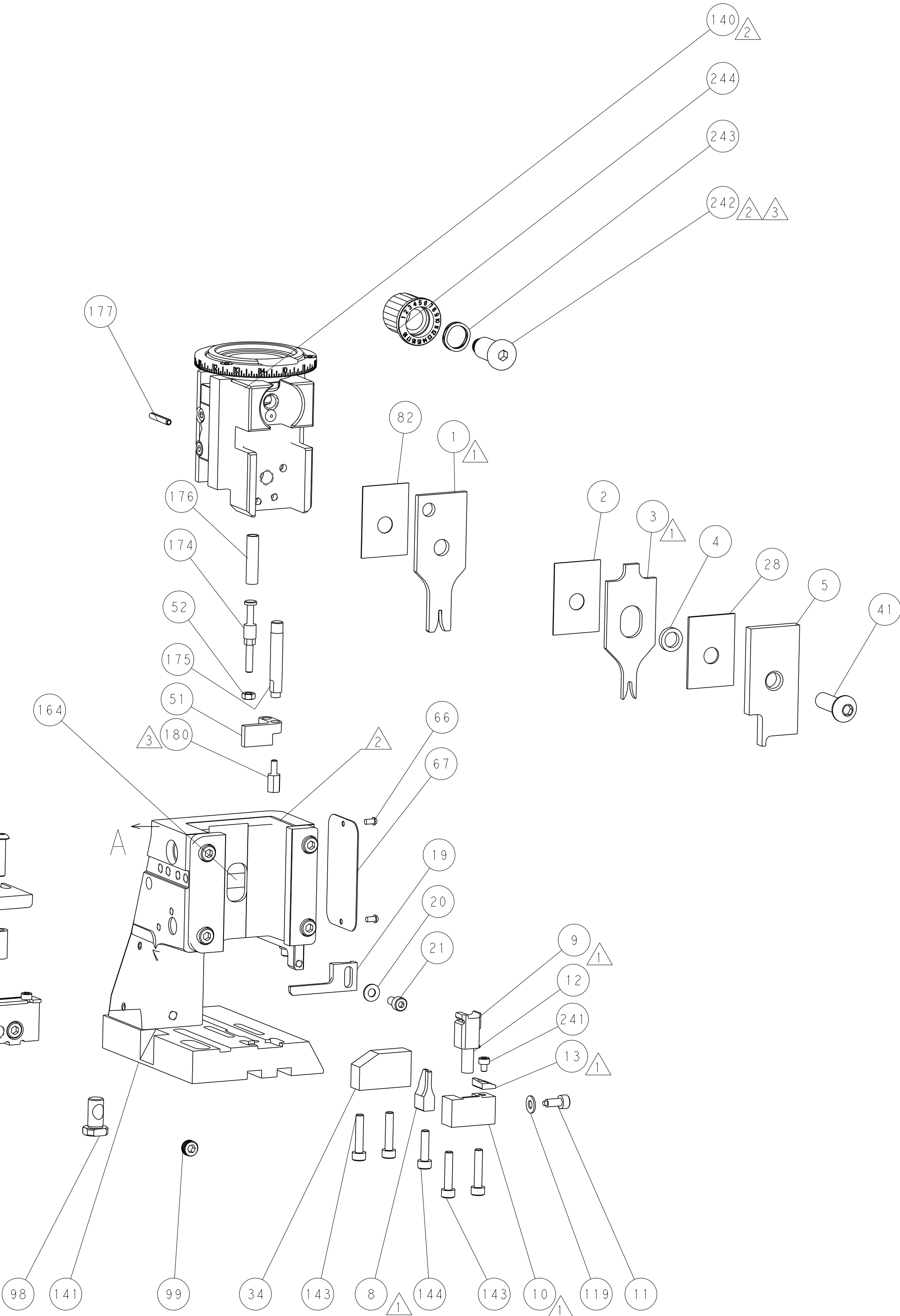
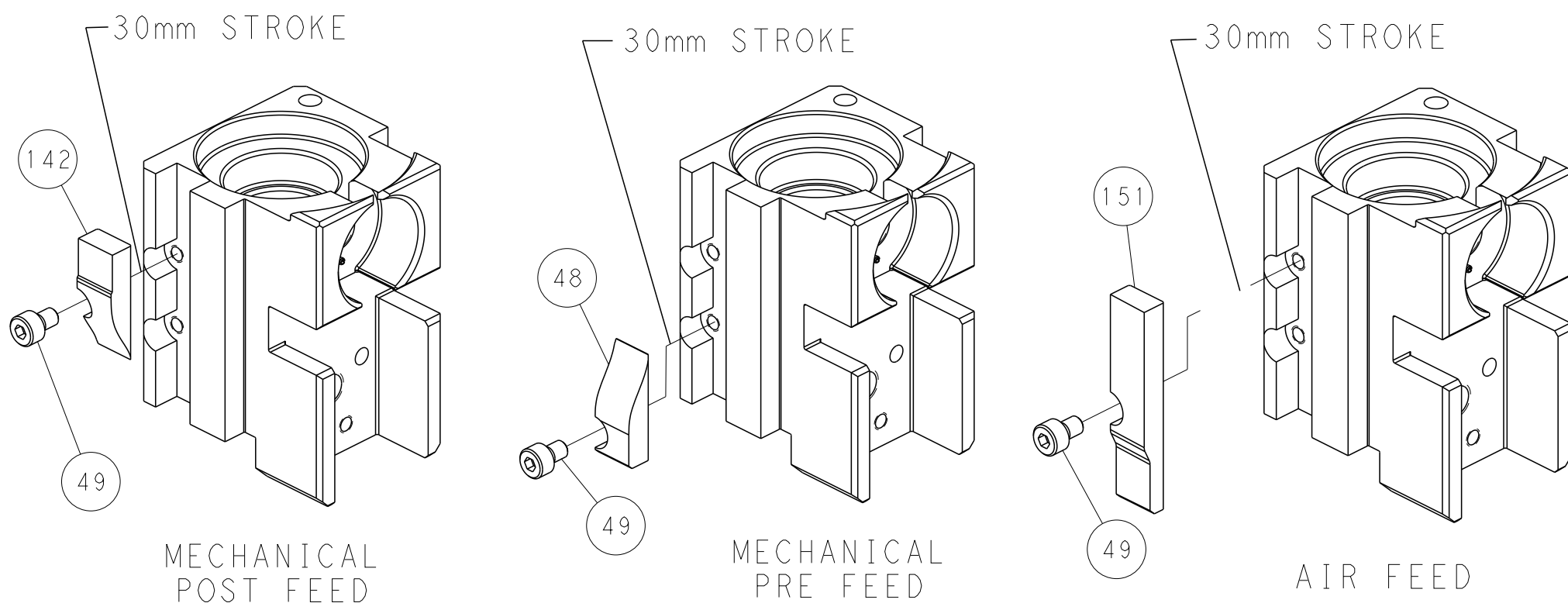


FEED SPRING SETTING POSITION
(SHOWN FROM REAR SIDE)

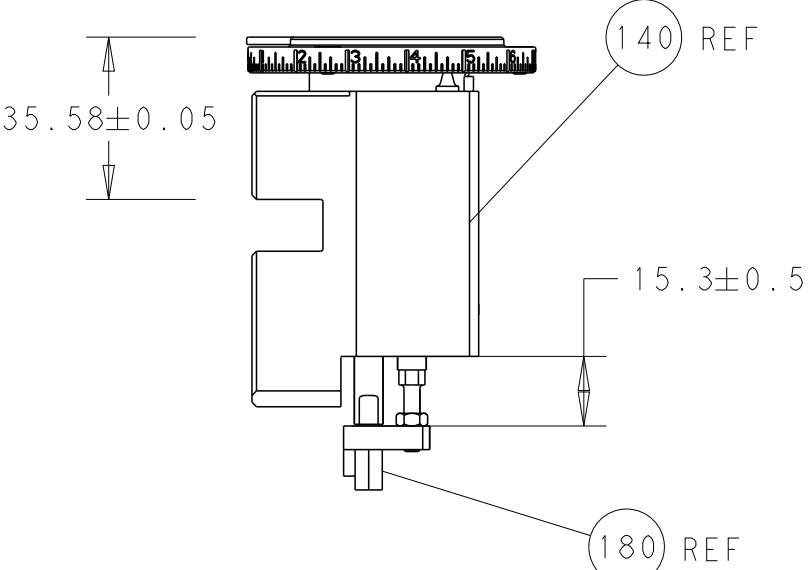


DETAIL A

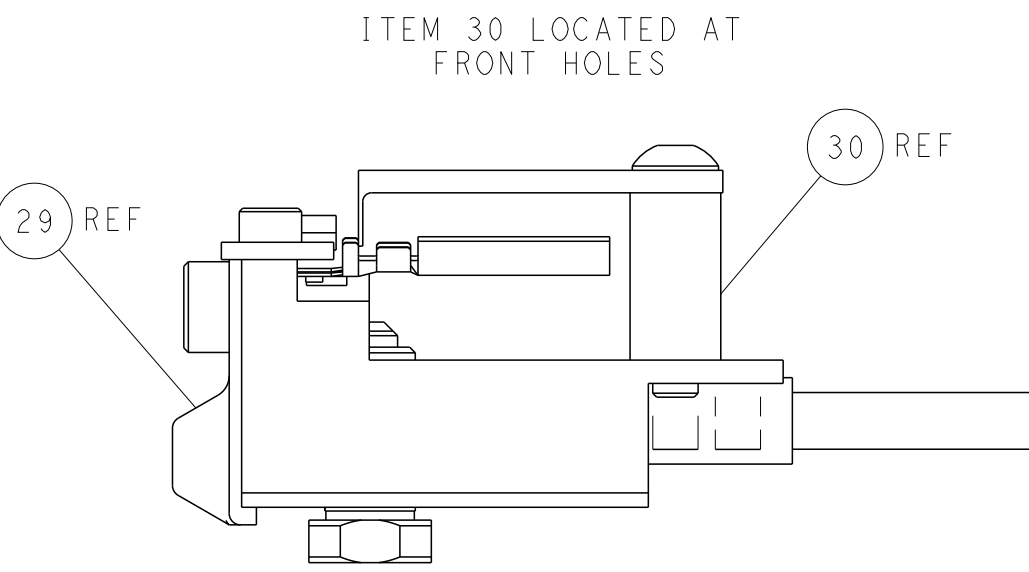
CAM POSITIONS



TERMINAL SUPPORT LOCATION

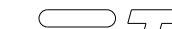


RAM AND HOLDDOWN SET-UP



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 CHANGES TO THIS DRAWING SHOULD BE CONTACTED FOR THE LATEST REVISION.				DWN K. HUANG 20AUG2013	 TE Connectivity Harrisburg, PA 17105-3608												
				CHK L. ZHANG 20AUG2013													
				APVD J. GUO 20AUG2013	NAME Ocean Side Feed Applicator												
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		PRODUCT SPEC -		APPLICATION SPEC -		SIZE A		CAGE CODE 00779		DRAWING NO C-2151232		RESTRICTED TO -			
		0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH -		-		-		-		-		-		-			
MATERIAL -		-		-		-		-		-		-		-			
Customer Accessible Production Drawing										SCALE 1:2		SHEET 4		OF 4		REV C	

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

Mouser Electronics

Authorized Distributor

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

[TE Connectivity:](#)

[7-2151232-7](#)