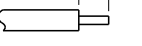


8		7	
THIS DRAWING IS UNPUBLISHED.		RELEASED FOR PUBLICATION	
20		20	
© COPYRIGHT 20 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.			
PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151430-1	F	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2151430-2	G	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151430-1	F	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2151430-2	G	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2151430-7	A	CRIMP TOOLING KIT	-

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.00 mm [.039]	F
INSUL	1.40 mm [.055]	F
APPLICATOR INSTRUCTIONS 408-35042		

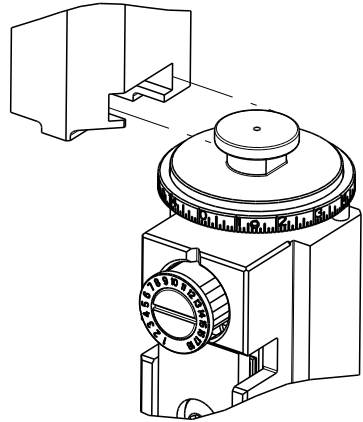
TERMINAL DATA: MOLEX TERMINAL		MOLEX CRIMP SPECIFICATION	
TERMINAL NAME: 2.00mm PITCH MILLI-GRID TERMINAL			
WIRE STRIP LENGTH			INSULATION DIAMETER RANGE
1.30-1.80 mm [.051-.071 IN]			Ø0.80-1.40 mm [.031-.055 IN]
TERMINAL APPLICATION SPECIFICATION	 ATS-639005200 Rev -	-	-
	-	-	-
TERMINALS APPLIED			
TE TERMINAL	MOLEX TERMINAL	TE TERMINAL	MOLEX TERMINAL
994698-1	50394-8052	1642397-1	50212-8000
994698-2	50394-8051	1949068-1	50394-8053
621528-1	50394-8051	1949068-2	50394-8054
1642396-1	50394-8051		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
24 AWG OR 0.20mm2	0.64+/-0.05 [.025+/- .002]	8.6
26 AWG OR 0.12mm2	0.61+/-0.05 [.024+/- .002]	8.9
28 AWG OR 0.08mm2	0.58+/-0.05 [.023+/- .002]	9.2
30 AWG OR 0.05mm2	0.56+/-0.05 [.022+/- .002]	9.4



- 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 ITEM 50. 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 30 AWG / 0.05mm² WIRE SIZE IS NOT RECOMMENDED BY TE. BUT CAN BE USED AT CUSTOMERS DISCRETION.
6. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- 7 USE TERMINAL SUPPORT LOCATION SHOWN FOR TERMINALS WITH LOCKING LANCE.

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.

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

2		1							
LOC	DIST	REVISIONS							
A	66	P	LTR	DESCRIPTION			DATE	DWN	APVD
			D	ECR-18-006969			09MAY2018	FL	JD
			E	ECR-18-007653			17MAY2018	AW	CT
			F	ECR-18-015728			03OCT2018	JAH	CT
			G	ECR-21-121975			24NOV2021	JWC	TE

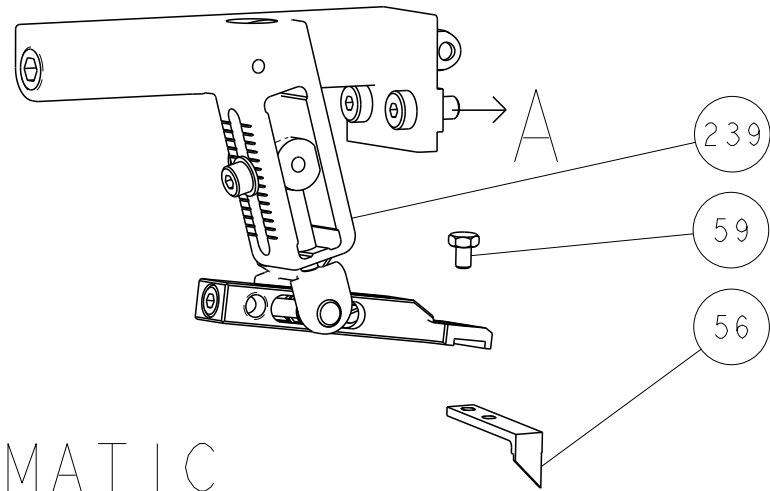
-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248
-	1	1	1	1	2119082-8	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	1	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
-	-	1	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	1	-	1	-	2844940-1	AIR FEED MODULE	238
-	2	2	2	2	1-2079383-0	SCR, BHSC, RoHS (M3 X 6)	230
-	1	1	1	1	1-1976053-0	LOCATER BLOCK, TERMINAL	179
-	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	1-455888-7	SPACER, CRIMPER	82
-	1	1	1	1	1803607-3	DOCUMENTATION PACKAGE	71
-	1	1	1	1	2-2119791-2	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	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	1901681-4	HOLDDOWN, TERMINAL	51
-	1	1	1	1	1752354-7	STANDOFF,HOLD-DOWN	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	1803515-3	RAM ASSEMBLY, SF ATLANTIC	44
-	1	1	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
-	1	1	1	1	2-1752356-5	SUPPORT, TERMINAL	34
-	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	2	2	2-2844962-3	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29
-	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	2119533-3	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	1-356885-3	STOP, SHEAR	11
-	1	1	1	1	2119805-1	SHEAR HOLDER, FRONT	10
-	1	1	1	1	1803095-6	FLOATING SHEAR, FRONT	9
1	2	2	1	1	7-1633139-3	ANVIL, COMBINATION	8
-	-	-	-	-	-	-	7
-	-	-	-	-	-	-	6
-	1	1	1	1	2119757-5	DEPRESSOR, SHEAR	5
-	1	1	1	1	2-238011-0	BLOCK, CRIMPER SPACER	4
1	2	2	1	1	5-1803223-0	CRIMPER, INSULATION F PREMIUM	3
-	1	1	1	1	455888-3	SPACER, CRIMPER	2
1	2	2	1	1	5-1490019-0	CRIMPER, WIRE PREMIUM	1

THIS DRAWING IS A CONTROLLED DOCUMENT FOR FRED ELECTRONICS CORPORATION IT IS UNPUBLISHED. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. THE USER SHOULD BE CONTACTED FOR THE LATEST REVISION.										DWN X, ZHAO 11MAY2012		 TE Connectivity Harrisburg, PA 17105-3608											
DIMENSIONS: mm  TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH										CHK T, ELBIN 11MAY2012				NAME									
										APVD S, XI 11MAY2012										Ocean Side Feed Applicator			
PRODUCT SPEC										-		SIZE		CAGE CODE		DRAWING NO		RESTRICTED TO					
APPLICATION SPEC										-		A		00779		©=2151430		-					
WEIGHT										-		Customer Accessible Production Drawing											
MATERIAL										-		SCALE		1:2		SHEET		1 of 4		REV		G	

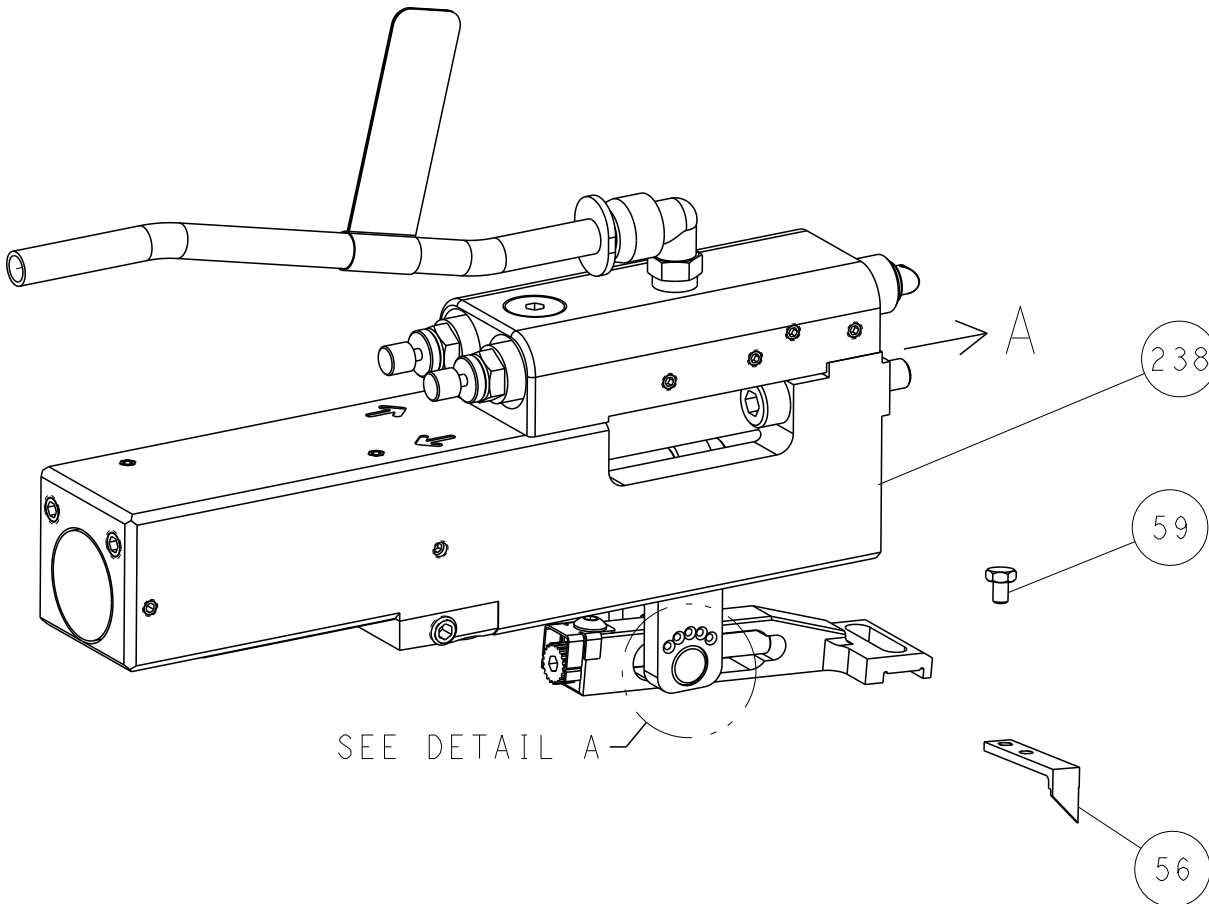
SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

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

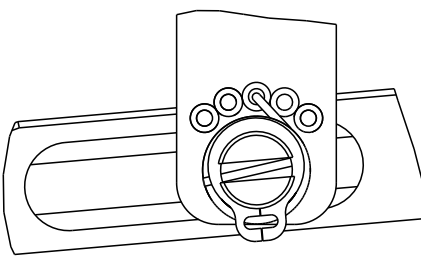
FEED TYPE MECHANICAL



PNEUMATIC

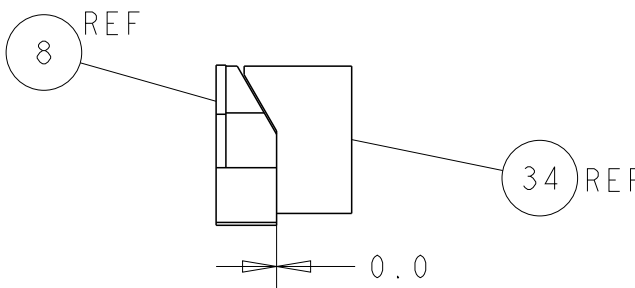
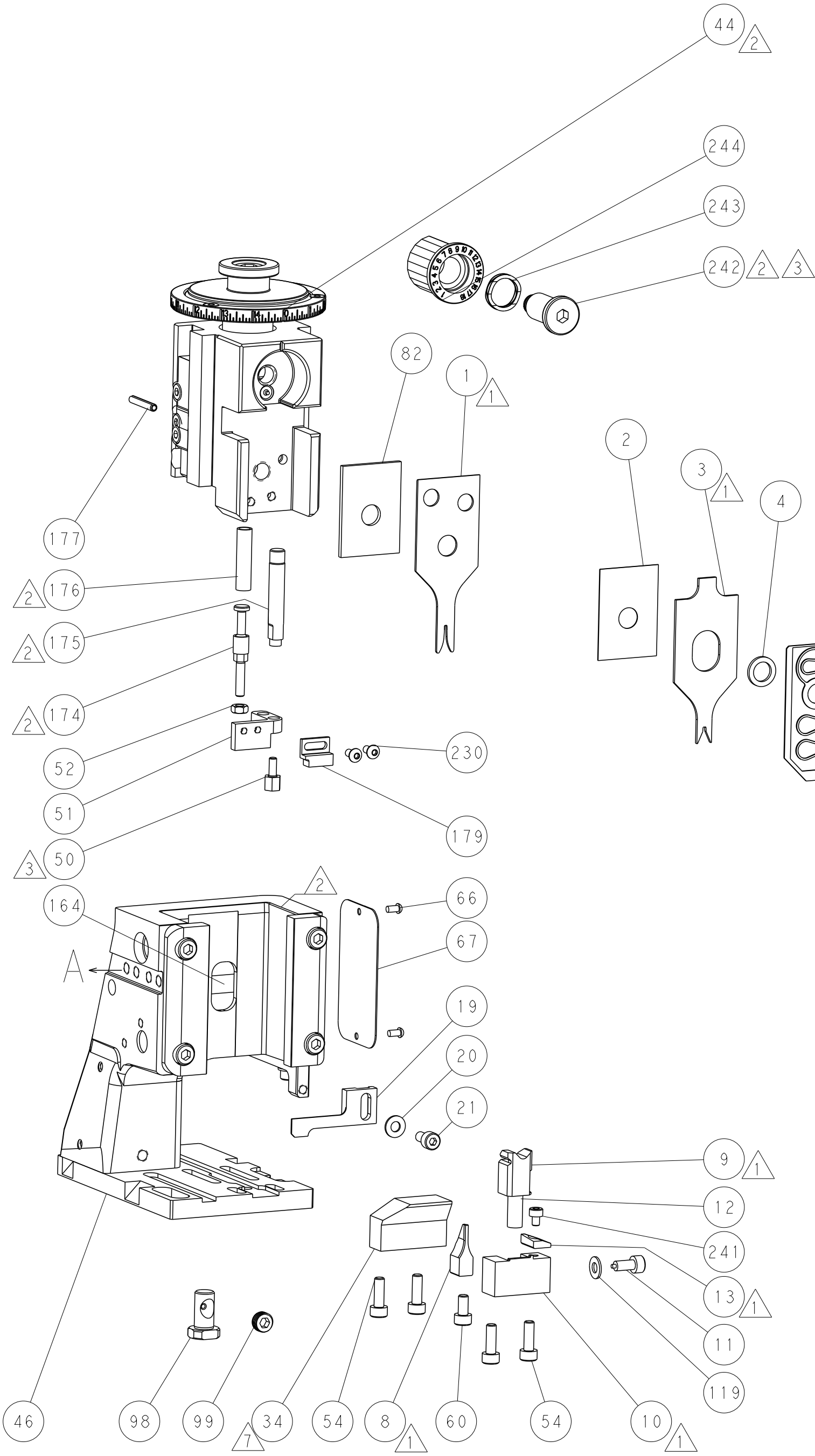
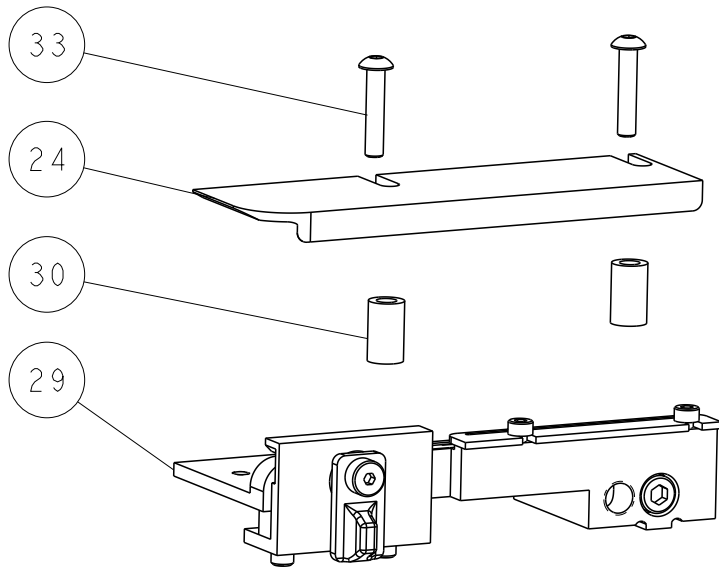
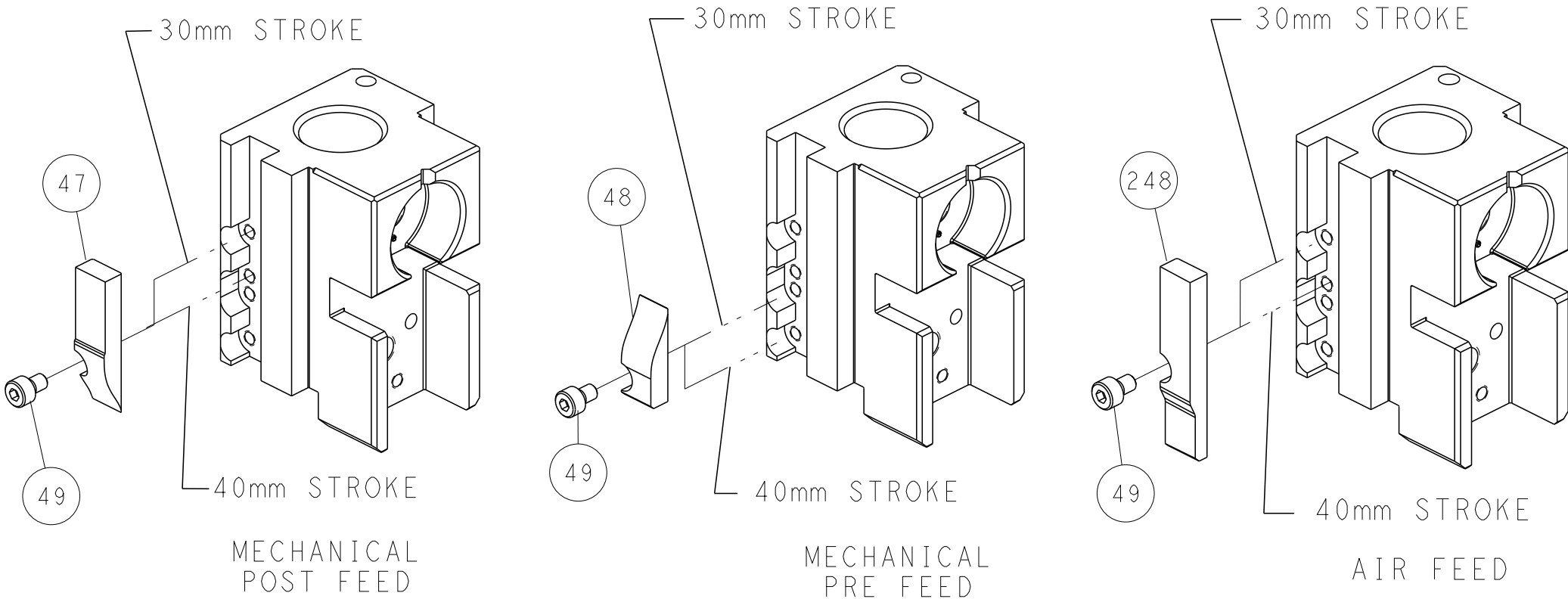


FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)

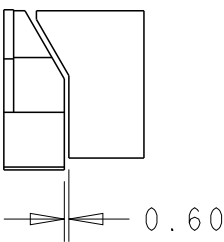


DETAIL A

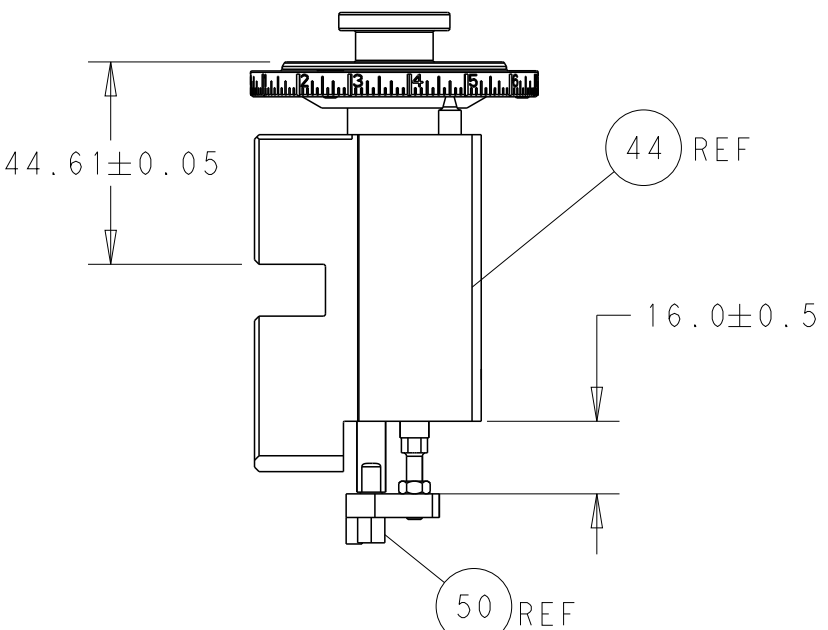
CAM POSITIONS



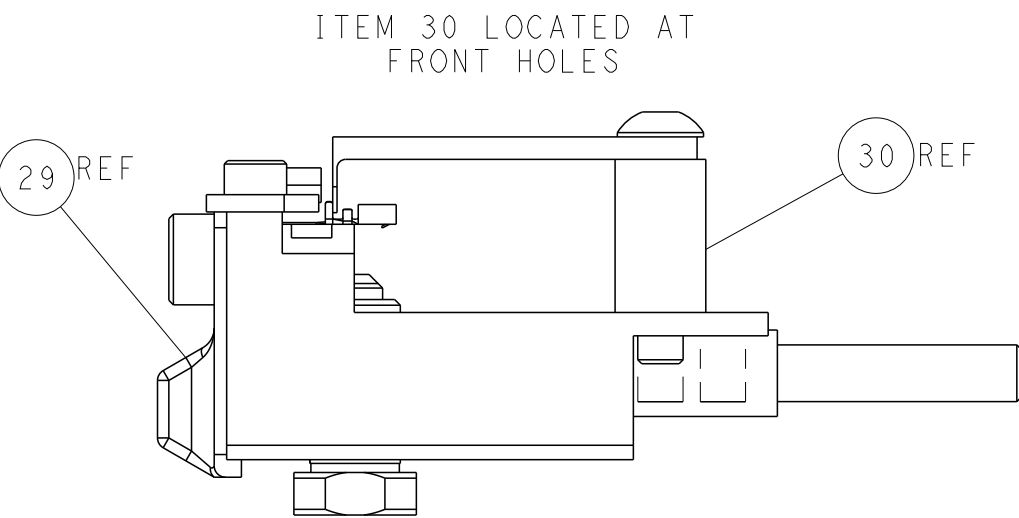
TERMINAL SUPPORT LOCATION



TERMINAL SUPPORT LOCATION
FOR TERMINALS WITH LOCKING
LANCE

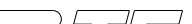


HOLDDOWN AND RAM SET-UP



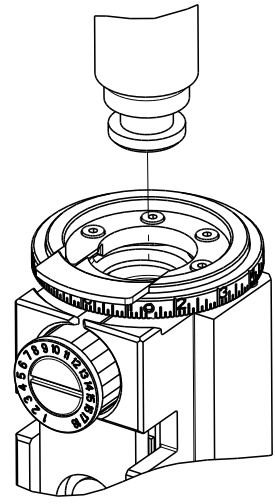
FEED TRACK POSITION
GUIDE BY INSULATION BARREL

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 UNPUBLISHED. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. IT IS THE RESPONSIBILITY OF THE USER TO CONTACT THE ORGANIZATION FOR THE LATEST VERSION.				DWN	X. ZHAO	11MAY2012	 TE Connectivity Harrisburg, PA 17105-3608				
				CHK	T. ELBIN	11MAY2012					
				APVD	S. XI	11MAY2012	NAME				
				PRODUCT SPEC				Ocean Side Feed Applicator			
				APPLICATION SPEC							
				WEIGHT				RESTRICTED TO			
				Customer Accessible Production Drawing				REV G			

8	7	
THIS DRAWING IS UNPUBLISHED.		RELEASED FOR PUBLICATION
20		
COPYRIGHT 20 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.		
PART NUMBER	REVISION	DESCRIPTION
2-2151430-1	F	FINE CRIMP HEIGHT ADJUST
2-2151430-2	G	FINE CRIMP HEIGHT ADJUST
7-2151430-7	A	CRIMP TOOLING KIT
FEED TYPE		
MECHANICAL		
PNEUMATIC		
-		

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.00 mm [.039]	F
INSUL	1.40 mm [.055]	F
APPLICATOR INSTRUCTIONS		
408-35042		

TERMINAL DATA: MOLEX TERMINAL		MOLEX CRIMP SPECIFICATION	
TERMINAL NAME: 2.00mm PITCH MILLI-GRID TERMINAL			
WIRE STRIP LENGTH 1.30-1.80 mm [.051-.071 IN]		INSULATION DIAMETER RANGE Ø0.80-1.40 mm [.031-.055 IN]	
TERMINAL APPLICATION SPECIFICATION		ATS-639005200 Rev -	
TERMINALS APPLIED			
TE TERMINAL	MOLEX TERMINAL	TE TERMINAL	MOLEX TERMINAL
994698-1	50394-8052	1642397-1	50212-8000
994698-2	50394-8051	1949068-1	50394-8053
621528-1	50394-8051	1949068-2	50394-8054
1642396-1	50394-8051		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
24 AWG OR 0.20mm ²	0.64+/-0.05 [.025+/- .002]	8.6
26 AWG OR 0.12mm ²	0.61+/-0.05 [.024+/- .002]	8.9
28 AWG OR 0.08mm ²	0.58+/-0.05 [.023+/- .002]	9.2
30 AWG OR 0.05mm ²	0.56+/-0.05 [.022+/- .002]	9.4



- RECOMMENDED SPARE PARTS.
- REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 50.
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.
- 30 AWG / 0.05mm² WIRE SIZE IS NOT RECOMMENDED BY TE.
BUT CAN BE USED AT CUSTOMERS DISCRETION.
6. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- USE TERMINAL SUPPORT LOCATION SHOWN FOR TERMINALS WITH LOCKING LANCE.

*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	P	LTR	DESCRIPTION	DATE
		-		SEE SHEET 1	-
					-
					-

-	1	1	2119082-8	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
-	2	2	1-2079383-0	SCR, BHSC, RoHS (M3 X 6)	230
-	1	1	1-1976053-0	LOCATER BLOCK,TERMINAL	179
-	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	1-455888-7	SPACER, CRIMPER	82
-	1	1	1803607-3	DOCUMENTATION PACKAGE	71
-	1	1	2-2119791-2	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
-	1	1	1338685-1	PAWL, FEED	56
-	1	1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52
-	1	1	1901681-4	HOLDDOWN, TERMINAL	51
-	1	1	1752354-7	STANDOFF,HOLD-DOWN	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	2-1752356-5	SUPPORT, TERMINAL	34
-	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	2-2844962-3	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29
-	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	2119533-3	STRIPPER, SIDE FEED	19
-	1	1	2119806-1	INSERT, SHEAR	13
-	1	1	3-22280-3	SPRING, COMPRESSION	12
-	1	1	1-356885-3	STOP, SHEAR	11
-	1	1	2119805-1	SHEAR HOLDER, FRONT	10
-	1	1	1803095-6	FLOATING SHEAR, FRONT	9
1	1	1	7-1633139-3	ANVIL, COMBINATION	8
-	-	-	-	-	7
-	-	-	-	-	6
-	1	1	2119757-5	DEPRESSOR, SHEAR	5
-	1	1	2-238011-0	BLOCK, CRIMPER SPACER	4
1	1	1	5-1803223-0	CRIMPER, INSULATION F PREMIUM	3
-	1	1	455888-3	SPACER, CRIMPER	2
1	1	1	5-1490019-0	CRIMPER, WIRE PREMIUM	1

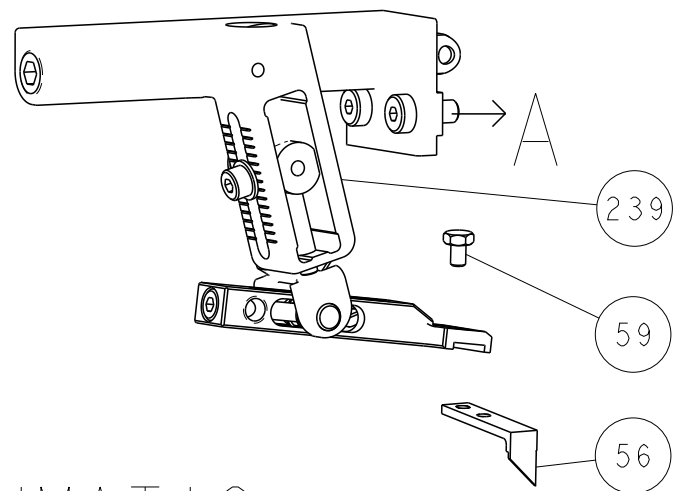
-77	-22	-21	PART NO	DESCRIPTION	ITEM NO
OWN			X,ZHAO	11MAY2012	
CHK			T,ELBIN	11MAY2012	
APVD			S,XI	11MAY2012	
DIMENSIONS:			TE Connectivity Harrisburg, PA 17105-3608		
mm			NAME		
0 PLC ±			Ocean Side Feed		
1 PLC ±			Applicator		
2 PLC ±			-		
3 PLC ±			SIZE		
4 PLC ±			CAGE CODE		
ANGLES			DRAWING NO		
FINISH			RESTRICTED TO		
MATERIAL			A1 00779 ©=2151430		
-			Customer Accessible Production Drawing		
-			SCALE		
-			1:2		
-			SHEET		
-			3		
-			OF		
-			4		
-			REV		
-			G		

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

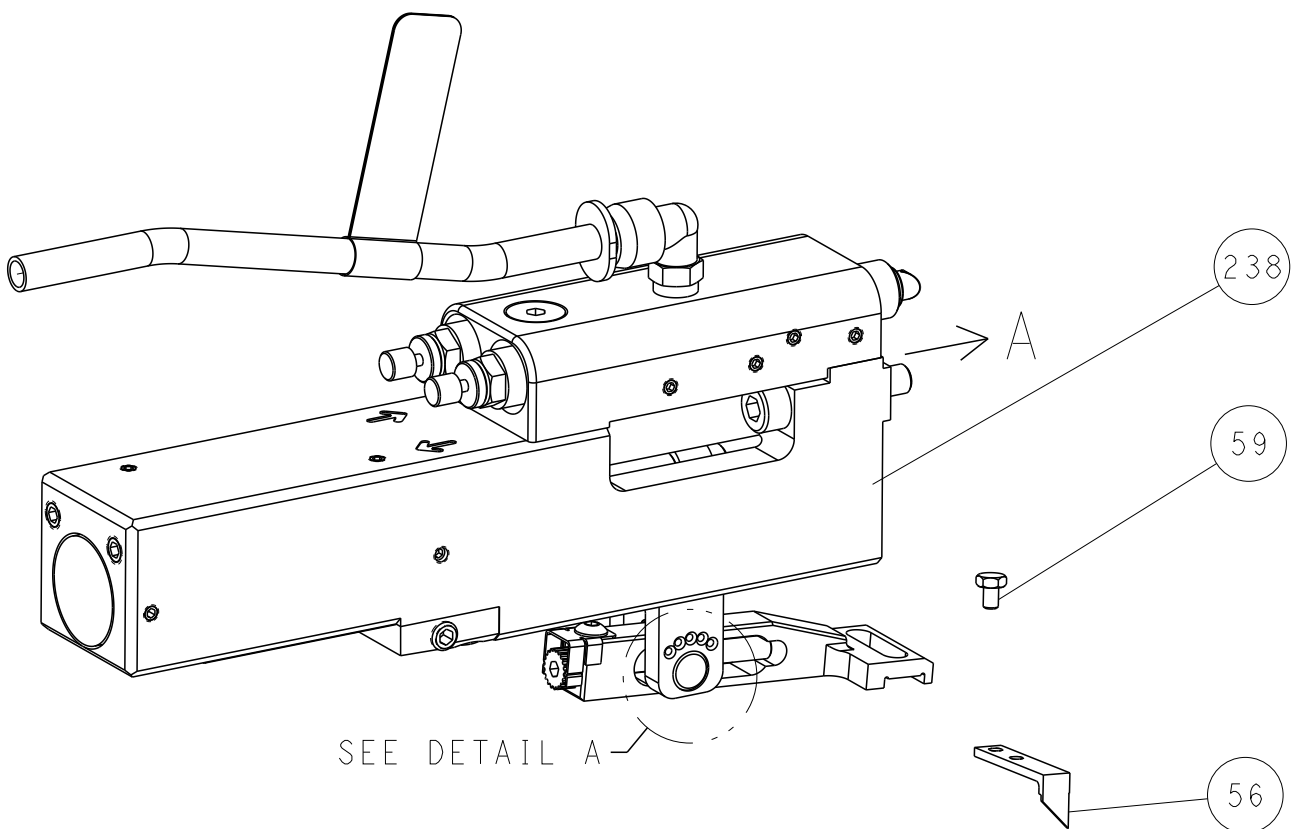
LOC	DIST	REVISIONS					
		P	LTR	DESCRIPTION	DATE	DWN	APVD
A	66	-	-	SEE SHEET 1	-	-	-

FEED TYPE

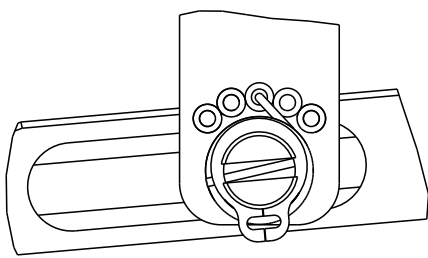
MECHANICAL



PNEUMATIC

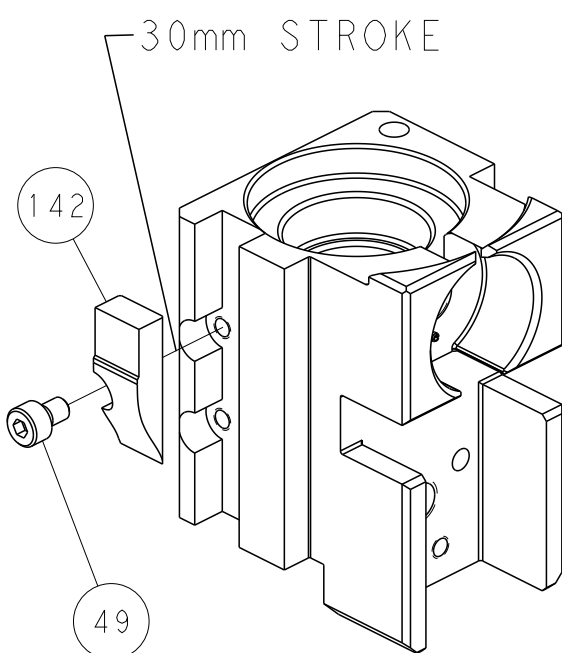


FEED SPRING SETTING POSITION
(SHOWN FROM REAR SIDE)

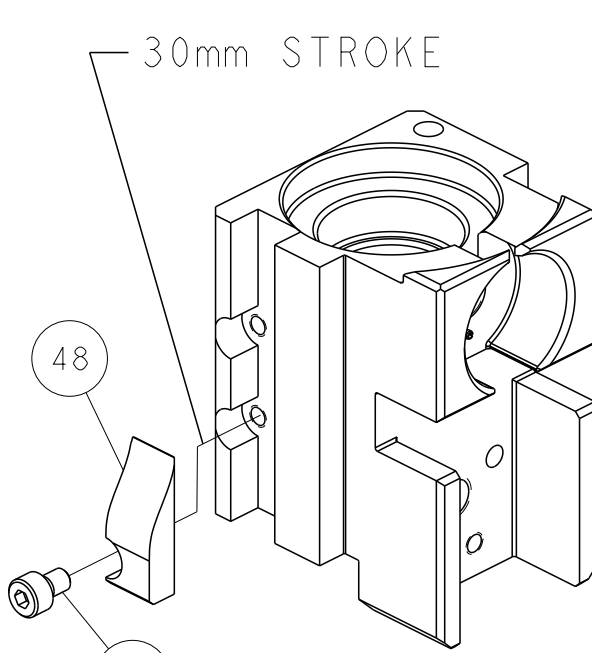


DETAIL A

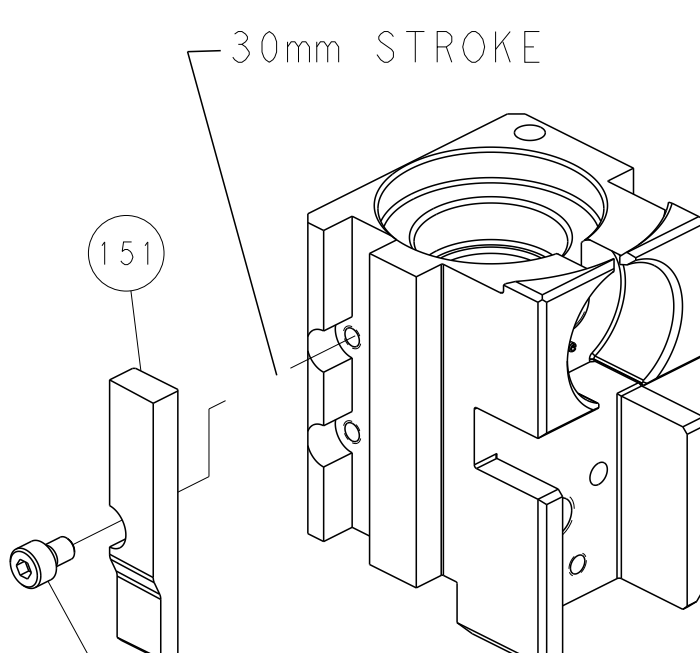
CAM POSITIONS



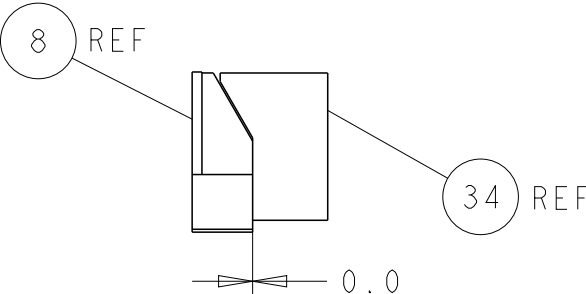
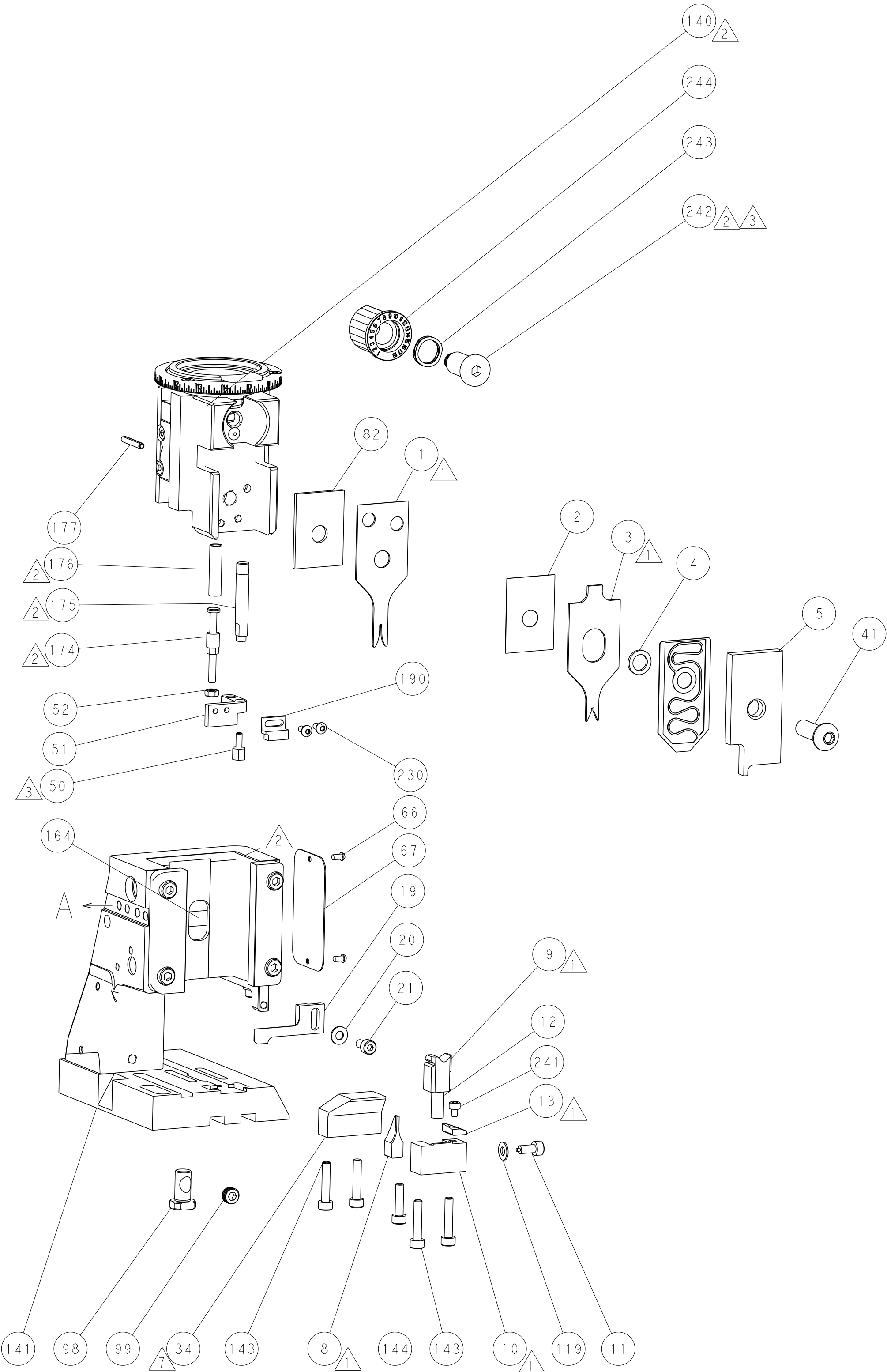
MECHANICAL
POST FEED



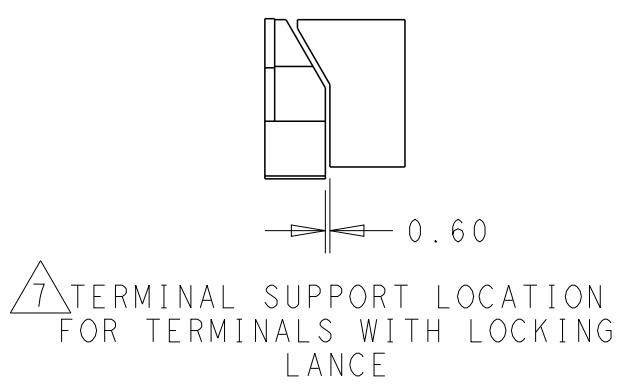
MECHANICAL
PRE FEED



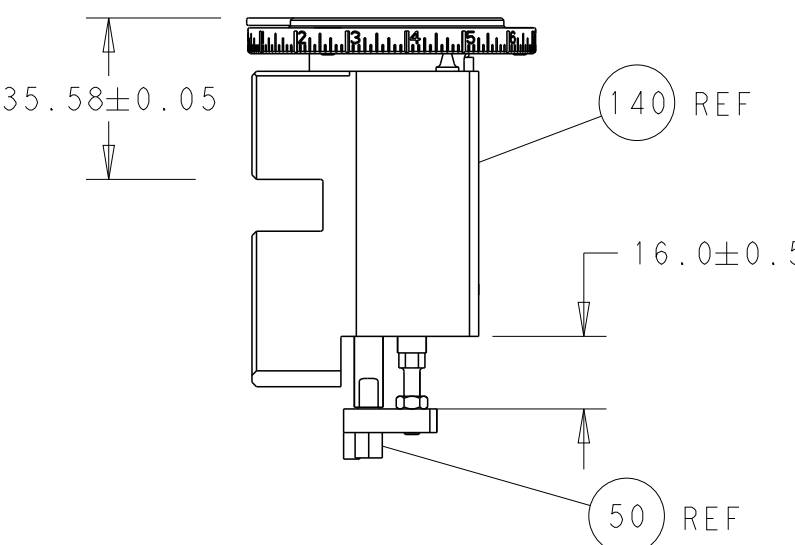
AIR FEED



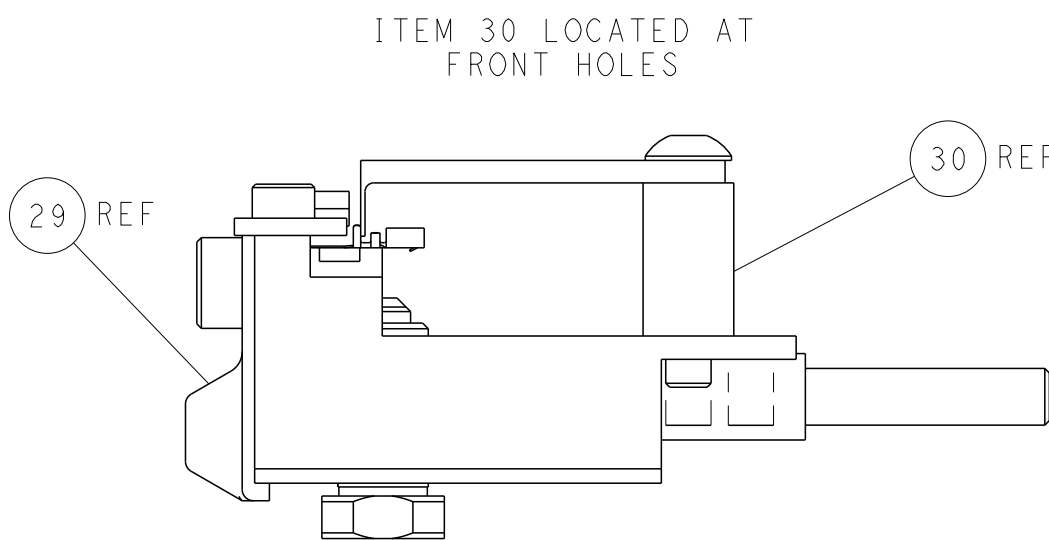
TERMINAL SUPPORT LOCATION



TERMINAL SUPPORT LOCATION
FOR TERMINALS WITH LOCKING
LANCE



HOLDDOWN AND RAM 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 UNPUBLISHED. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. ANY CHANGES TO THIS DRAWING SHOULD BE CONTACTED FOR THE LATEST VERSION.				DWN	X. ZHAO	11MAY2012	 TE Connectivity Harrisburg, PA 17105-3608				
				CHK	T. ELBIN	11MAY2012					
				APVD	S. XI	11MAY2012	NAME				
				PRODUCT SPEC				Ocean Side Feed Applicator			
				APPLICATION SPEC							
				WEIGHT				RESTRICTED TO			
				Customer Accessible Production Drawing				REV G			

Mouser Electronics

Authorized Distributor

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

[TE Connectivity:](#)

[2151430-1](#)