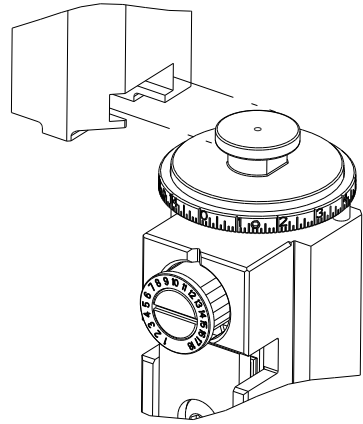


8		7	
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20		20	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151607-1	D	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2151607-2	E	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151607-1	D	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2151607-2	E	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2151607-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.96 mm [.077]	F
INSUL	2.67 mm [.105]	F
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: JST TERMINAL JST CRIMP SPECIFICATION			
TERMINAL NAME: VH CONNECTOR			
WIRE STRIP LENGTH 2.80-3.20 mm [.110-.126 IN]		TERMINAL INSULATION DIAMETER RANGE Ø1.70-3.00 mm [.067-.118 IN]	
TERMINAL APPLICATION SPECIFICATION	H4009/017-00	-	-
TERMINALS APPLIED			
TE TERMINAL	JST TERMINAL	TE TERMINAL	JST TERMINAL
1572729-1	SVH-41T-P1.1		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
16 AWG OR 1.25mm2	1.20+/-0.05 [.047+/- .002]	5.5
18 AWG OR 0.85mm2	1.10+/-0.05 [.043+/- .002]	6.4
20 AWG OR 0.50mm2	1.05+/-0.05 [.041+/- .002]	6.8



- 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.

*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	OWN
A	66		C	ECR-18-015181	24SEP2018	JAH
			D	ECR-18-017101	30OCT2018	FL
			E	ECR-21-006555	30JUN2021	FZ

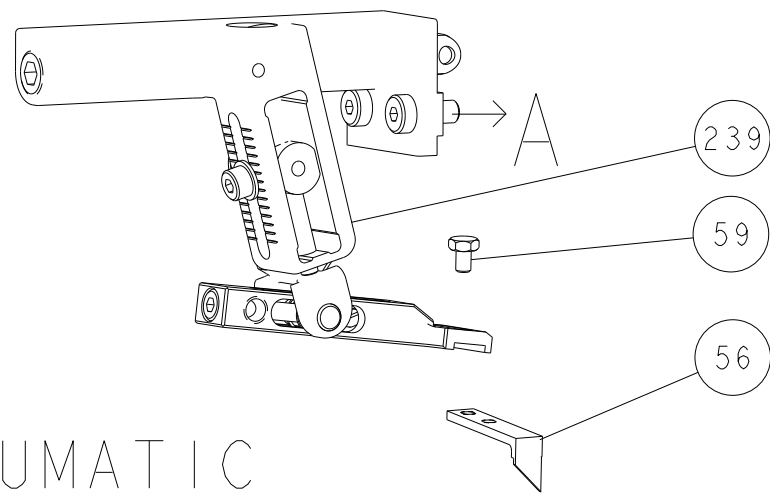
-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248
-	1	1	1	1	2119082-3	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	1	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
-	-	1	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	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	455888-6	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	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	1752356-1	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	1803095-1	FLOATING SHEAR, FRONT	9
-	1	2	2	1	1633927-5	ANVIL, COMBINATION	8
-	-	-	-	-	-	-	7
-	-	-	-	-	-	-	6
-	1	1	1	1	2119757-4	DEPRESSOR, SHEAR	5
-	1	1	1	1	2-238011-2	BLOCK, CRIMPER SPACER	4
-	1	2	2	1	1803016-2	CRIMPER, INSULATION F	3
-	-	-	-	-	-	-	2
-	1	2	2	1	1633738-1	CRIMPER, WIRE	1
-	77	72	71	-2	-1	PART NO	ITEM NO
-	-	-	-	-	-	DESCRIPTION	

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DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		NAME		Ocean Side Feed Applicator							
		0 PLC ±.005 1 PLC ±.005 2 PLC ±.005 3 PLC ±.005 4 PLC ±.005 ANGLES ±.005 FINISH		PRODUCT SPEC		SIZE		CAGE CODE		DRAWING NO		RESTRICTED TO	
MATERIAL		WEIGHT		APPLICATION SPEC		A 00779		C 2151607				-	
Customer Accessible Production Drawing						SCALE		1:2		SHEET		1 OF 4	
												REV E	

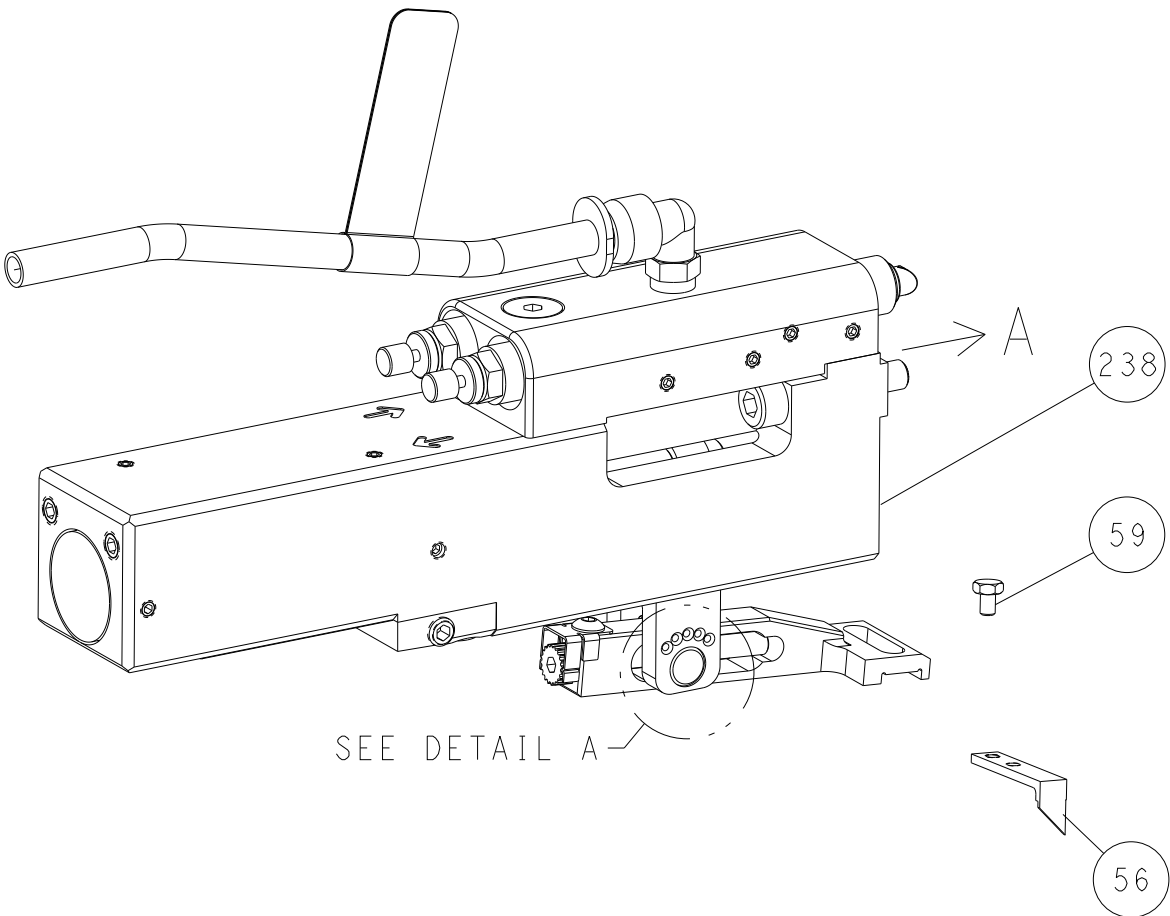
SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

LOC	DIST	REVISIONS					
		P	LTR	DESCRIPTION	DATE	DWN	APVD
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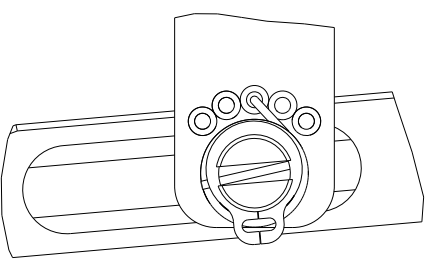
FEED TYPE MECHANICAL



PNEUMATIC

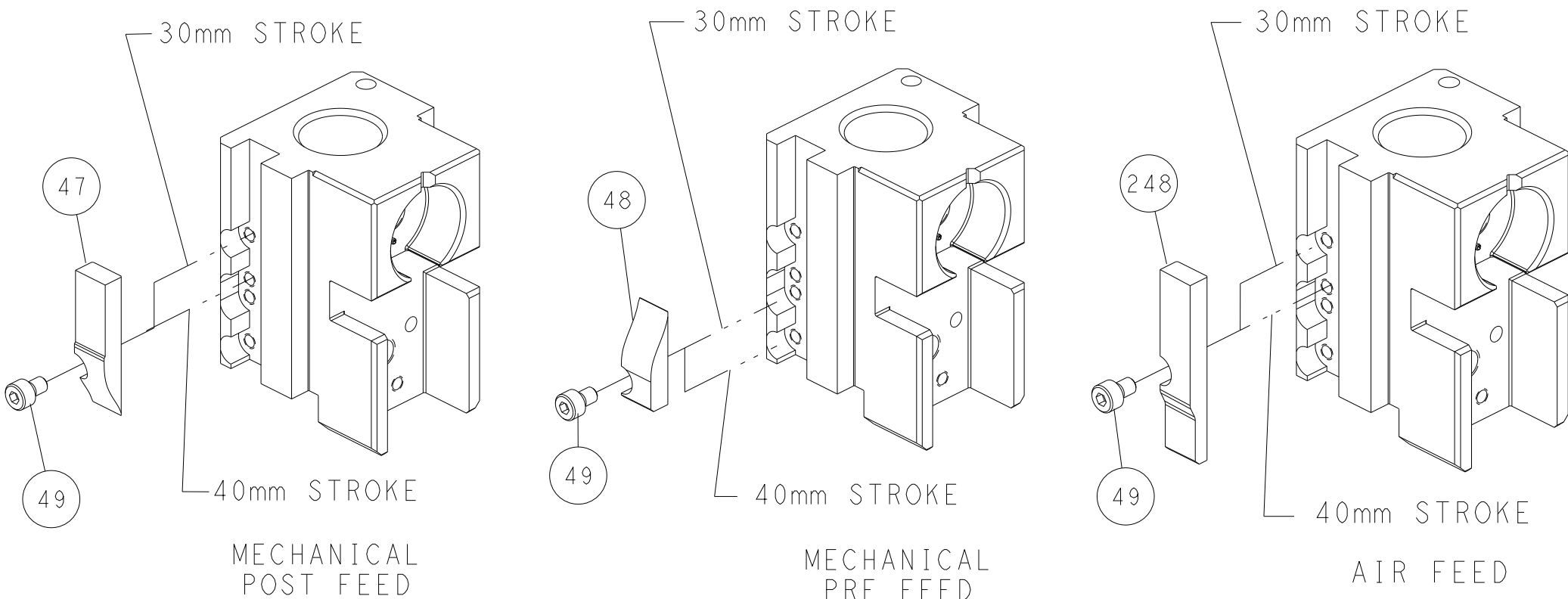


FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



DETAIL A

CAM POSITIONS



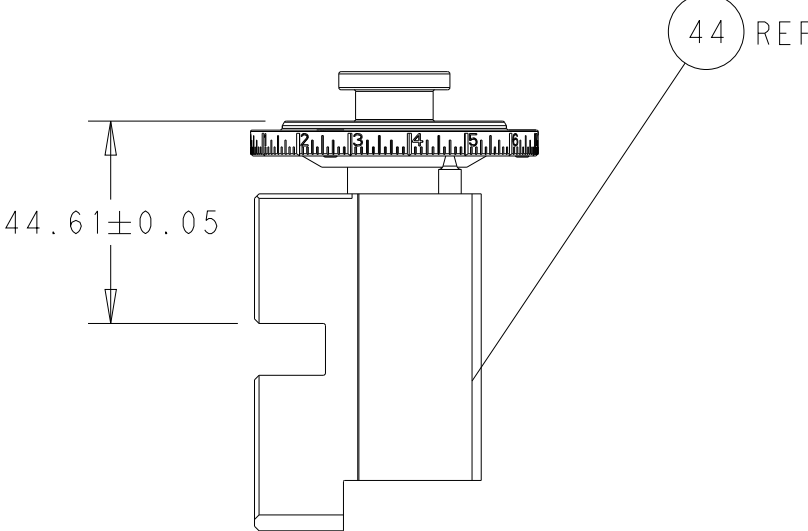
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)



8 REF 1.0±0.5

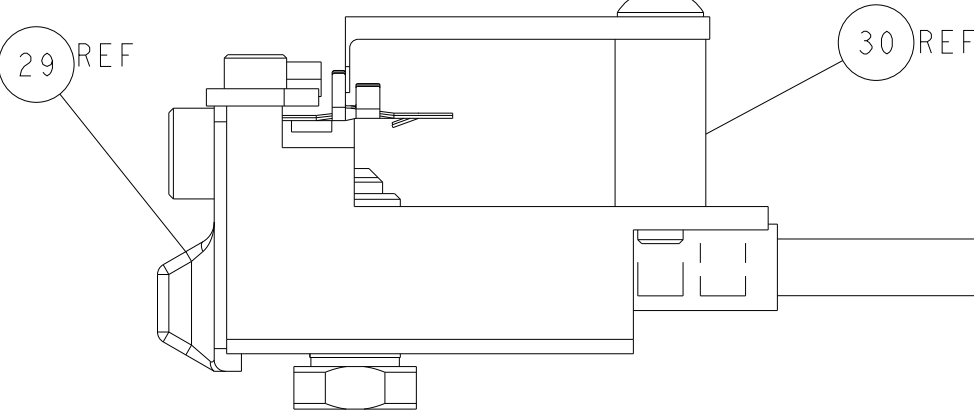
34 REF

TERMINAL SUPPORT LOCATION

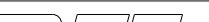


RAM SET-UP

ITEM 30 LOCATED AT
FRONT HOLES



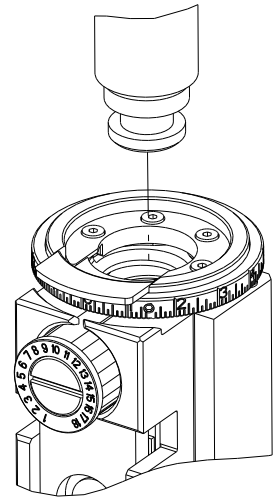
FEED TRACK POSITION
GUIDE BY INSULATION BARREL

THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CONTROLLED DOCUMENT AND INSPECTION ORGANIZATION. SHOULD BE CONTACTED FOR THE LATEST POSITION.				DWN	BOB HIGMAN	15FEB2012			TE Connectivity				
				CHK	T. ELBIN	15FEB2012			Harrisburg, PA 17105-3608				
DIMENSIONS:				TOLERANCES, UNLESS OTHERWISE SPECIFIED:			NAME		Ocean Side Feed Applicator				
mm							APVD						
							PRODUCT SPEC						
							APPLICATION SPEC						
							SIZE						
MATERIAL				FINISH			WEIGHT		CASE CODE	DRAWING NO	RESTRICTED TO		
-				-			-		A1	00779	©=2151607	-	
Customer Accessible Production Drawing								SCALE	1:2	SHEET	2 of 4	REV	E

SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2151607-1	D	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2151607-2	E	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151607-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.96 mm [.077]	F
INSUL	2.67 mm [.105]	F
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: JST TERMINAL		JST CRIMP SPECIFICATION	
TERMINAL NAME: VH CONNECTOR			
WIRE STRIP LENGTH 2.80-3.20 mm [.110-.126 IN]			TERMINAL INSULATION DIAMETER RANGE Ø1.70-3.00 mm [.067-.118 IN]
TERMINAL APPLICATION SPECIFICATION 	H4009/017-00	-	-
TERMINALS APPLIED			
TE TERMINAL	JST TERMINAL	TE TERMINAL	JST TERMINAL
1572729-1	SVH-41T-PI.1		

WIRE SIZE 	CRIMP HEIGHT mm [INCH] 	CRIMP HEIGHT REFERENCE SETTING
16 AWG OR 1.25mm2	1.20+/-0.05 [.047+/- .002]	5.5
18 AWG OR 0.85mm2	1.10+/-0.05 [.043+/- .002]	6.4
20 AWG OR 0.50mm2	1.05+/-0.05 [.041+/- .002]	6.8



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

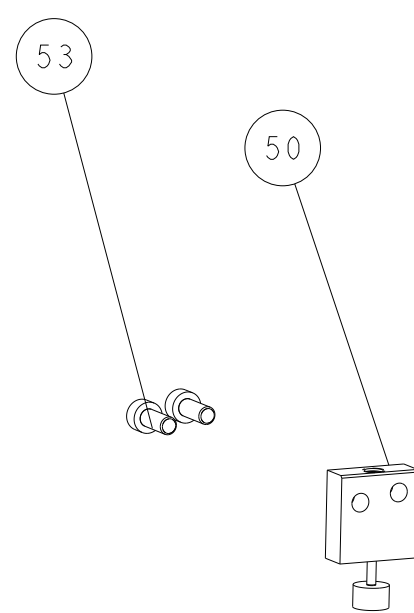
*WARNING
ON INSTALLATION, SET WIRE DISC TO CRIMP HEIGHT REFERENCE SETTING FOR LARGEST WIRE SIZE. CRIMP HEIGHT REFERENCE SETTINGS GREATER THAN THE VALUE SHOWN MAY CAUSE DAMAGE TO THE CRIMP TOOLING, REFER TO THE INSTRUCTION SHEET FOR PROPER SETUP AND ADJUSTMENTS.

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

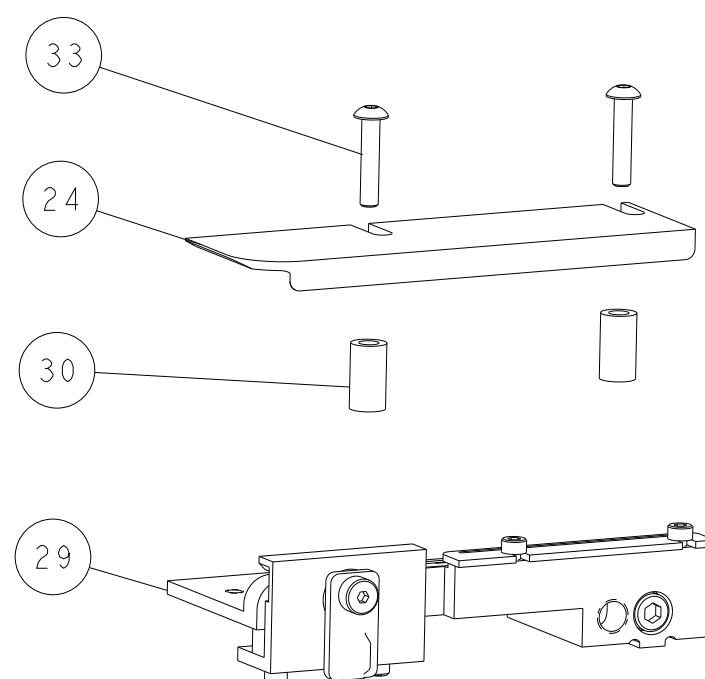
LOC	DIST	REVISIONS				
		P	LTR	DESCRIPTION	DATE	OWN
A	66	-	-	SEE SHEET 1	-	-

-	1	1	2119082-3	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	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	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
-	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	1752356-1	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	1803095-1	FLOATING SHEAR, FRONT	9
1	1	1	1633927-5	ANVIL, COMBINATION	8
-	-	-	-	-	7
-	-	-	-	-	6
-	1	1	2119757-4	DEPRESSOR, SHEAR	5
-	1	1	2-238011-2	BLOCK, CRIMPER SPACER	4
1	1	1	1803016-2	CRIMPER, INSULATION F	3
-	-	-	-	-	2
1	1	1	1633738-1	CRIMPER, WIRE	1

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DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.005 1 PLC ±.005 2 PLC ±.005 3 PLC ±.005 4 PLC ±.005 ANGLES ±.005		NAME Ocean Side Feed Applicator	
		APPLICATION SPEC		SIZE A	
MATERIAL -		WEIGHT -		CAGE CODE 00779	
				DRAWING NO C=2151607	
				RESTRICTED TO -	
				Customer Accessible Production Drawing	
				SCALE 1:2	
				SHEET 3	
				OF 4	
				REV E	



DETAIL A



30mm STROKE

142

49

MECHANICAL POST FEED

30mm STROKE

48

49

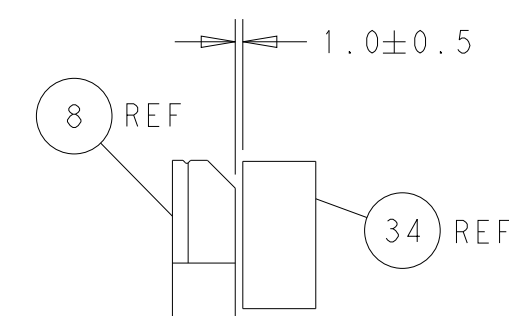
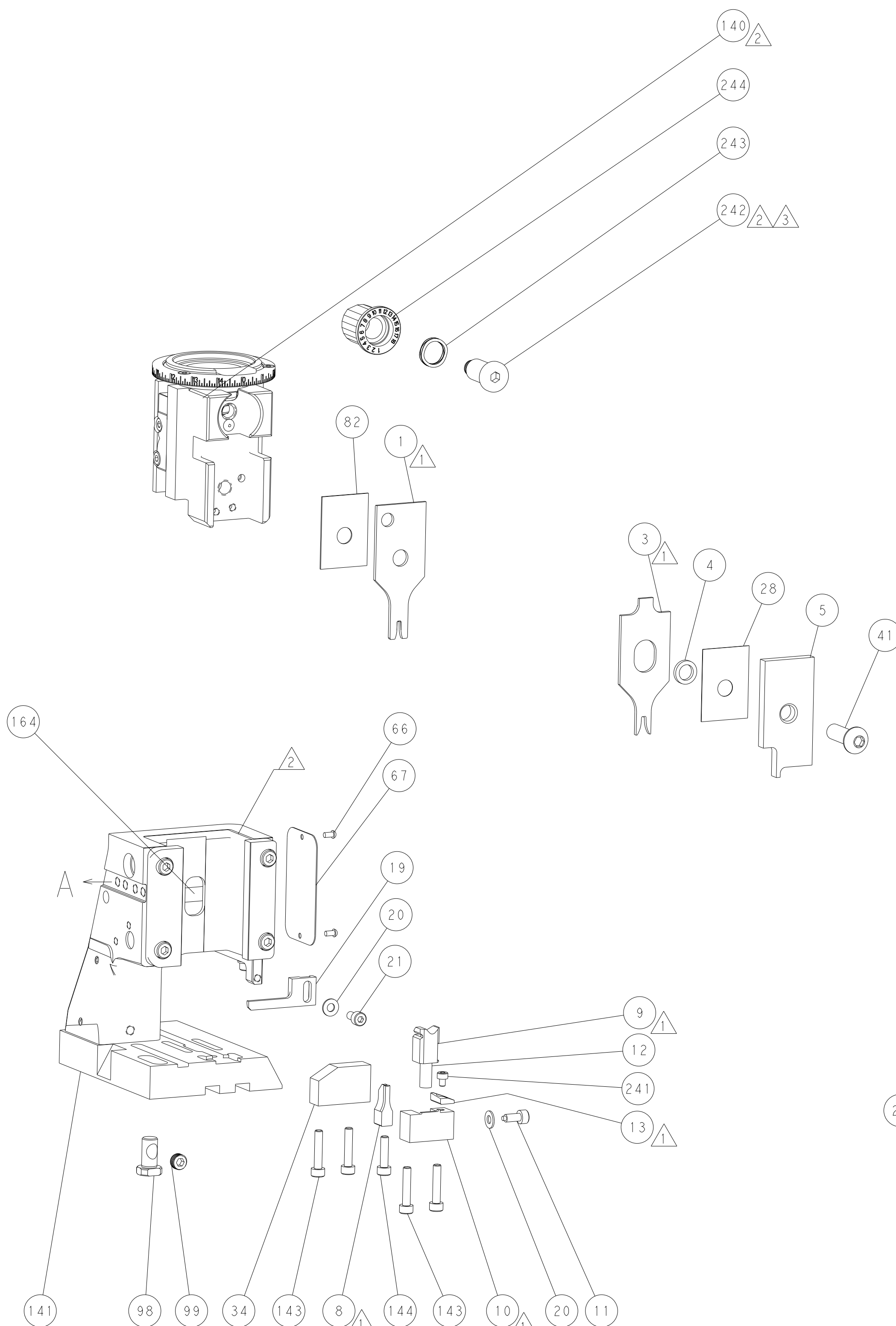
MECHANICAL PRE FEED

30mm STROKE

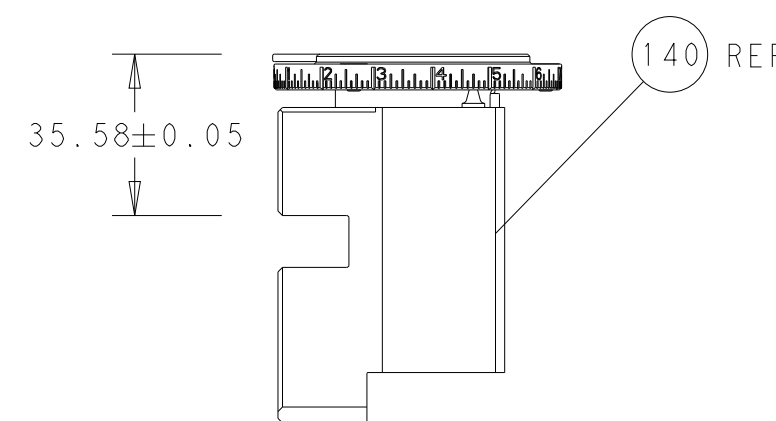
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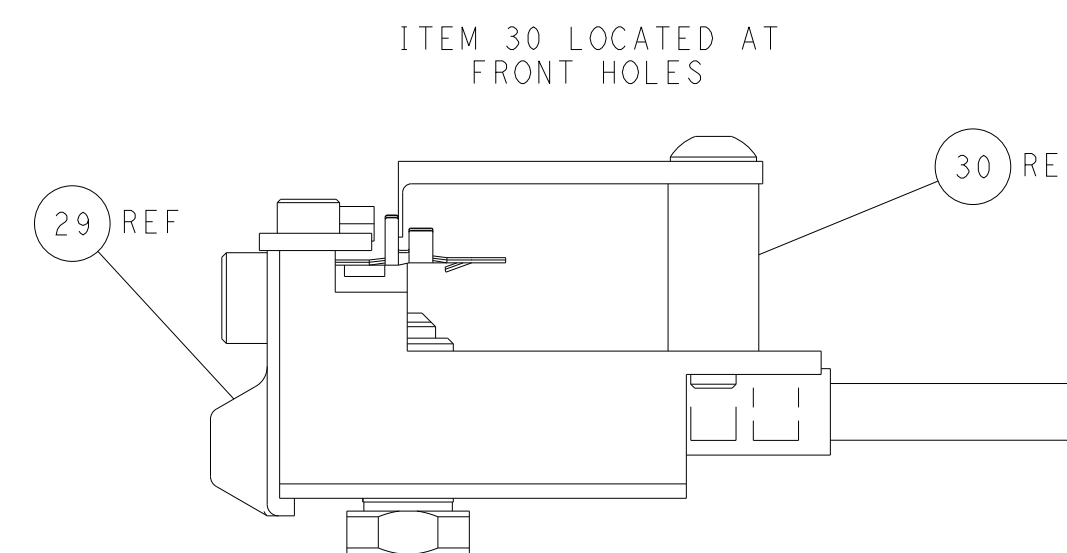
AIR FEED



TERMINAL SUPPORT LOCATION

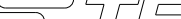


RAM SET-UP



FEED TRACK POSITION GUIDE BY INSULATION BARREL

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 PROTECTIVE INFORMATION AND IS TO BE USED TO CONSTRUCT AND TO VERIFY THE CONSTRUCTION OF THE PROJECT. IT SHOULD BE CONTACTED FOR THE LATEST REVISION.		DWG: BOB HIGMAN 15FEB2012 T. ELBRIN 15FEB2012 W. CLIFFORD 15FEB2012		 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 SIZE: A CAD CODE: 00779 DRAWING NO: C-2151607 RESTRICTED TO:	
		PRODUCT SPEC APPLICATION SPEC		WEIGHT: - SCALE: 1:2 SHEET: 4 OF 4 REV: F	
MATERIAL:		WEIGHT: -		Customer Accessible Production Drawing	

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[7-2151607-7](#)