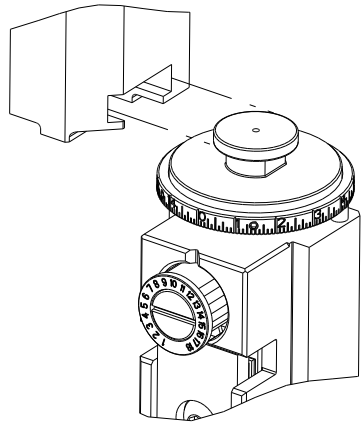
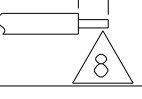


8		7	
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20		20	
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(C) COPYRIGHT 20			
PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151832-1	G	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2151832-2	G	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
3-2151832-2	G	FINE CRIMP HEIGHT ADJUST	DOUBLE ACTING PNEUMATIC WITH SENSORS
7-2151832-1	G	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2151832-2	G	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2151832-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.12 mm [.044]	F
INSUL	1.57 mm [.062]	O
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: CONTACT, MALE, GENERATION Y, 0.64			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
TERMINAL APPLICATION SPECIFICATION 	114-13183	-	-
	-	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
1924968-8	1-2035334-8	1-1456968-4	1-2138699-4
1-1924727-4	2035170-4	1-1456968-8	1-2138699-8
1924955-8	1-2035170-4	1-1456574-8	
1-1924955-8	1924275-8	2098762-4	
2035334-8	1456968-8	1-1456841-8	

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
2x0.13 OR 2X26 AWG	0.84+/-0.02 [.033+/- .001]	8.8
0.35mm2 OR 22 AWG	0.91+/-0.03 [.036+/- .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. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- 6 THIS APPLICATOR HAS BEEN DESIGNED TO APPLY WIRES WITH THIN WALL (FLR) INSULATION.
- 7 THIS APPLICATOR EQUIPPED WITH THE DOUBLE ACTING PNEUMATIC FEED WITH SENSORS, AND IS APPLICATION SPECIFIC AND DOES NOT REQUIRE ITEMS 49 & 248.
- 8 WIRE STRIP LENGTH
2X0.13 mm² 2x0.13 mm² or 2x 26AWG; 4.3-4.5mm [.169-.177 IN]
0.35mm² or 22AWG; 4.0-4.5 mm [.157-.177 IN]
- 9 INSULATION DIAMETER RANGE
2X0.13mm² or 2X26AWG; 0.85-1.05mm [.033-.041 IN]
0.35mm² or 22AWG; 1.10-1.40mm [.043-.055 IN]

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	DESCRIPTION				DATE	DWN	APVD
		P	LTR					
			E	ECR-19-007945			17MAY2019	TB TE
			E1	ECR-20-016024			11NOV2020	JWC TE
			F	ECR-21-113739			14SEP2021	TB RK
			G	ECR-21-114929			23SEP2021	LG RK

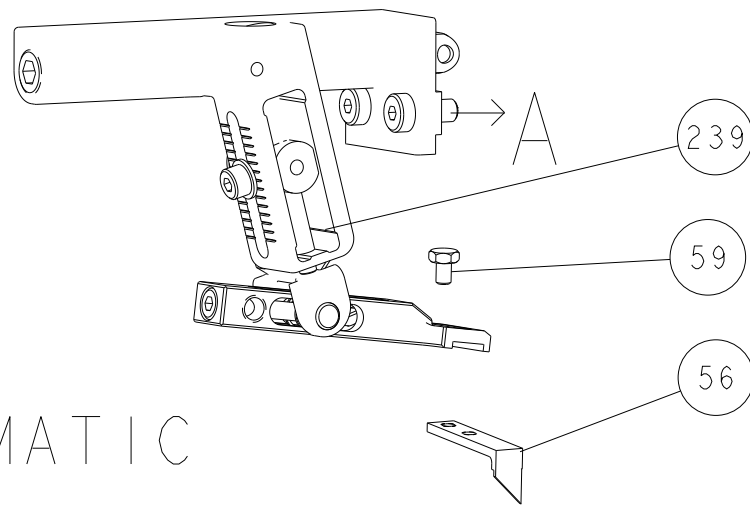
-	-	-	1	-	-	2844950-1	AIR FEED MODULE	290
-	1	-	-	1	-	2119641-1	FEED CAM, AIR FEED	248
-	1	1	1	1	1	2119082-8	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	1	1	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
-	-	1	-	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	1	-	-	1	-	2844940-1	AIR FEED MODULE	238
-	REF	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	1	1	1	1	1	2844908-1	SCREW, LOCKING	99
-	1	1	1	1	1	2844907-1	POST, LOCKING	98
-	1	1	1	1	1	455888-4	SPACER, CRIMPER	82
-	1	1	1	1	1	1803607-3	DOCUMENTATION PACKAGE	71
-	1	1	1	1	1	2119791-9	DEPRESSOR, WIRE	70
-	1	1	1	1	1	2119740-1	TAG, IDENTIFICATION	67
-	2	2	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	1	1	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	60
-	1	1	1	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	1	1	1	1	1	1338685-1	PAWL, FEED	56
-	4	4	4	4	4	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	54
-	2	2	2	2	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	53
-	1	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	-	-	1	2119652-1	FEED CAM, PRE FEED	48
-	-	1	-	-	1	2119653-1	FEED CAM, POST FEED	47
-	1	1	1	1	1	1803583-9	APPLICATOR BASIC ASSEMBLY, SF	46
-	1	1	1	1	1	1803515-1	RAM ASSEMBLY, SF ATLANTIC	44
-	1	1	1	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
-	1	1	1	1	1	1752356-1	SUPPORT, TERMINAL	34
-	2	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	2	2	2	2-2844962-4	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	1	1	1	2844992-7	ASSEMBLY, STRIP GUIDE	29
-	1	1	1	1	1	1320928-2	STRIP GUIDE	24
-	1	1	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
-	2	2	2	2	2	1-18028-2	WASHER, FLAT, REG M4	20
-	1	1	1	1	1	2119533-1	STRIPPER, SIDE FEED	19
-	1	1	1	1	1	2119806-1	INSERT, SHEAR	13
-	1	1	1	1	1	3-22280-3	SPRING, COMPRESSION	12
-	1	1	1	1	1	1-356885-4	STOP, SHEAR	11
-	1	1	1	1	1	2119805-1	SHEAR HOLDER, FRONT	10
-	1	1	1	1	1	1803095-1	FLOATING SHEAR, FRONT	9
-	1	2	2	1	1	1803058-6	ANVIL, COMBINATION	8
-	-	-	-	-	-	-	-	7
-	-	-	-	-	-	-	-	6
-	1	1	1	1	1	2119757-1	DEPRESSOR, SHEAR	5
-	1	1	1	1	1	3-238011-1	BLOCK, CRIMPER SPACER	4
-	1	2	2	1	1	1-1803019-1	CRIMPER, INSULATION O	3
-	1	1	1	1	1	455888-1	SPACER, CRIMPER	2
-	1	2	2	1	1	3-1633860-6	CRIMPER, WIRE	1

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DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		NAME Ocean Side Feed Applicator	
0 PLC 1 PLC 2 PLC 3 PLC 4 PLC		± ± ± ± ±		SIZE CAGE CODE DRAWING NO	
MATERIAL		WEIGHT		RESTRICTED TO	
-		-		-	
Customer Accessible Production Drawing		SCALE 1:2		SHEET 1 OF 4	
				REV G	

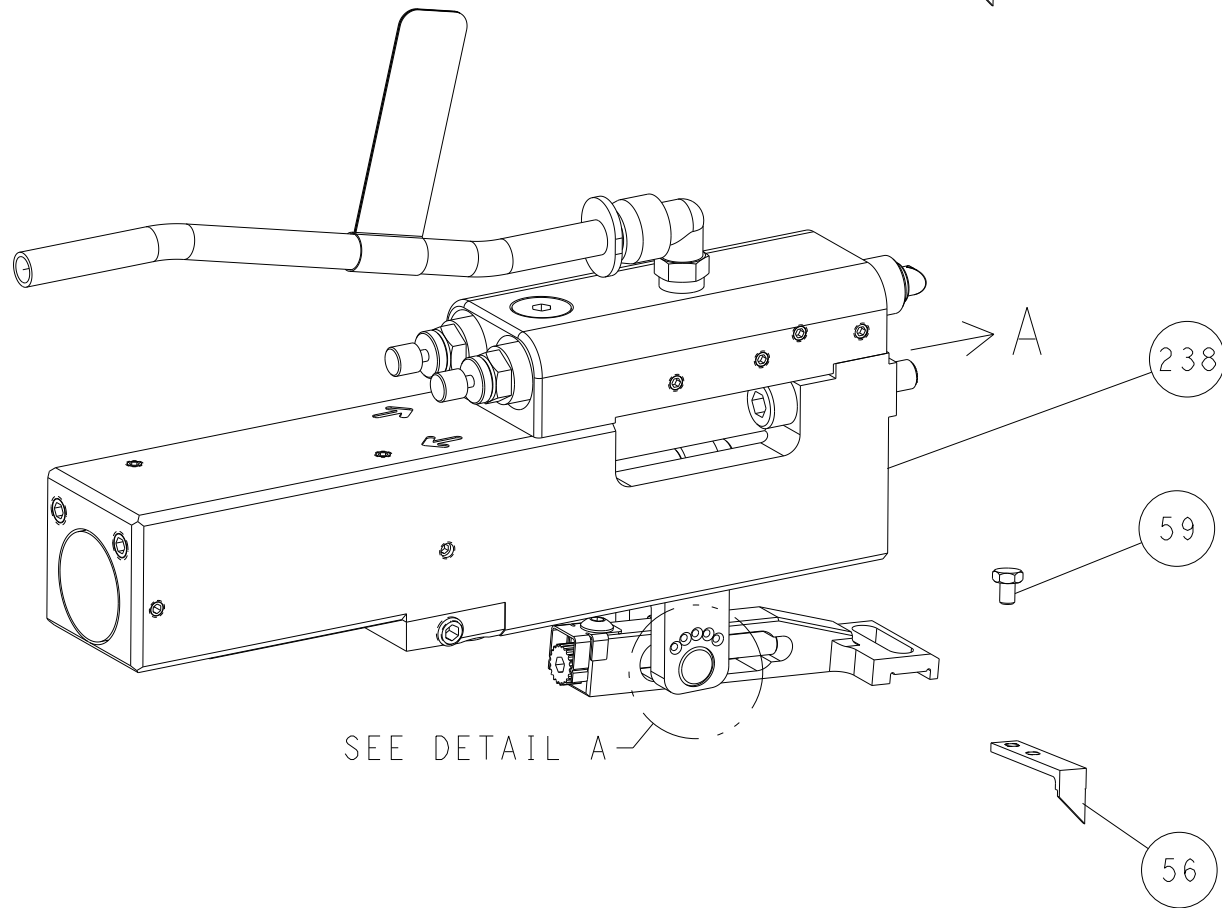
SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

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

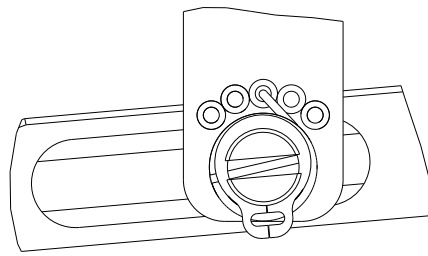
FEED TYPE MECHANICAL



PNEUMATIC

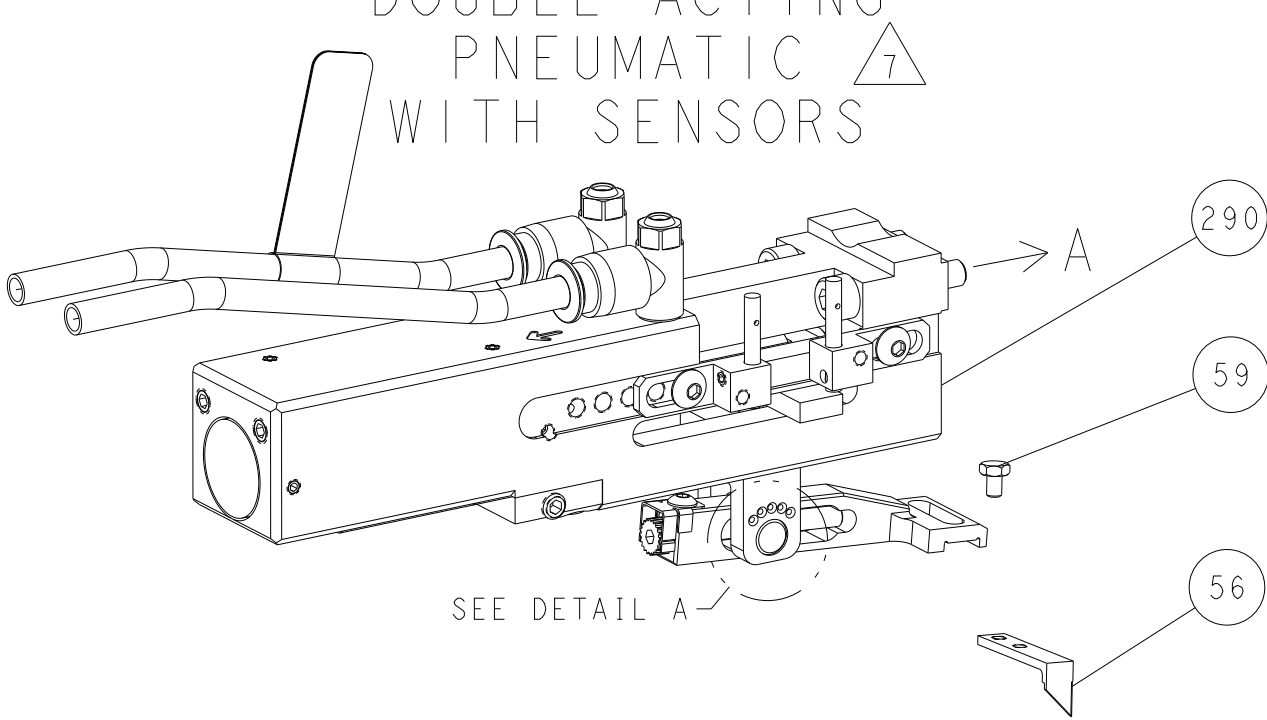


FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)

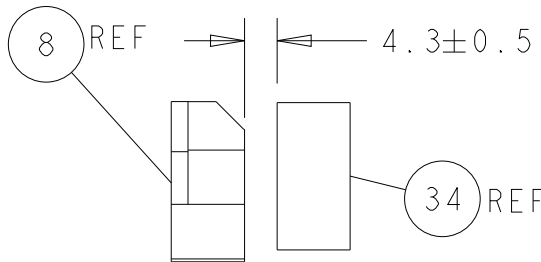
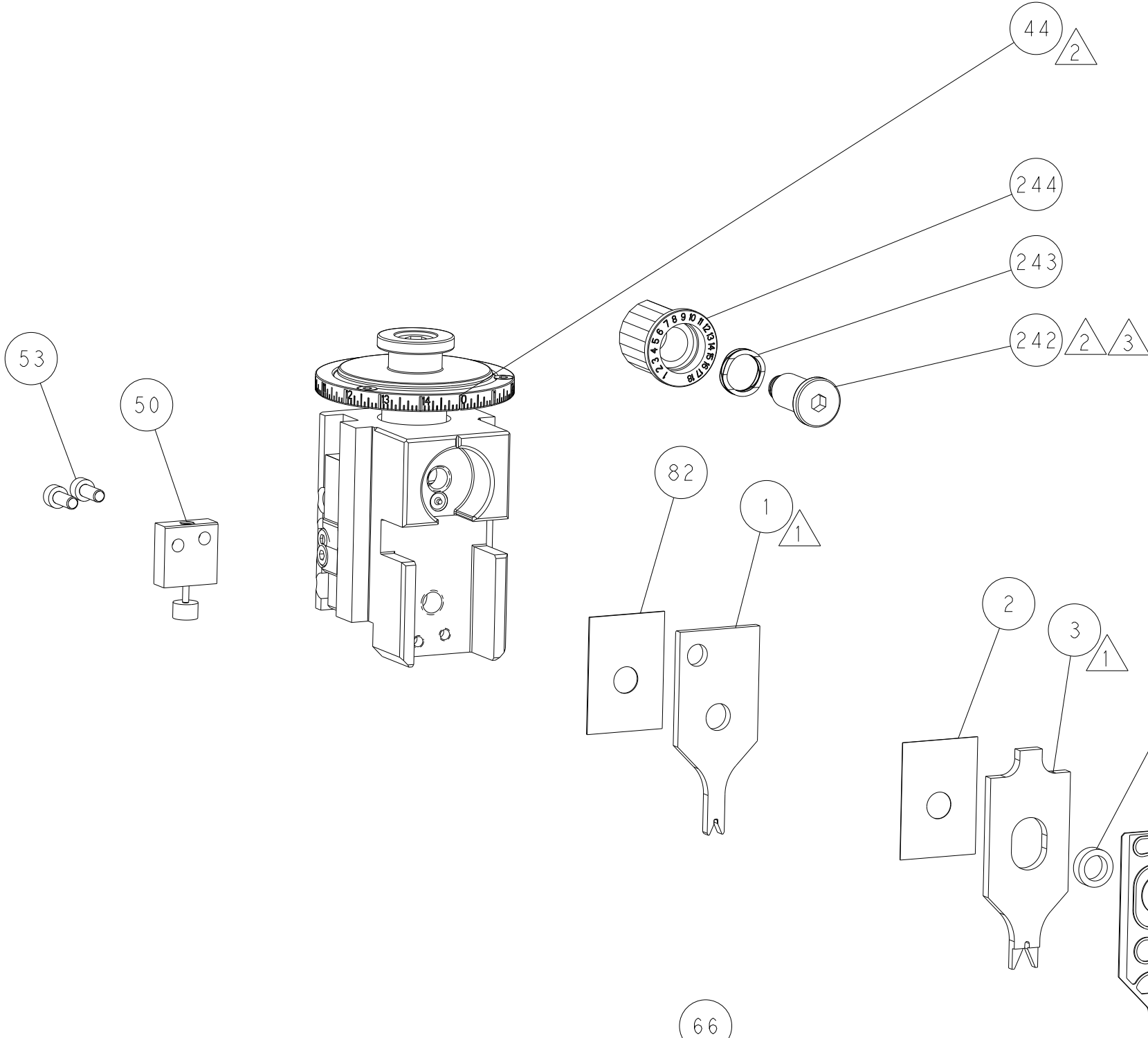
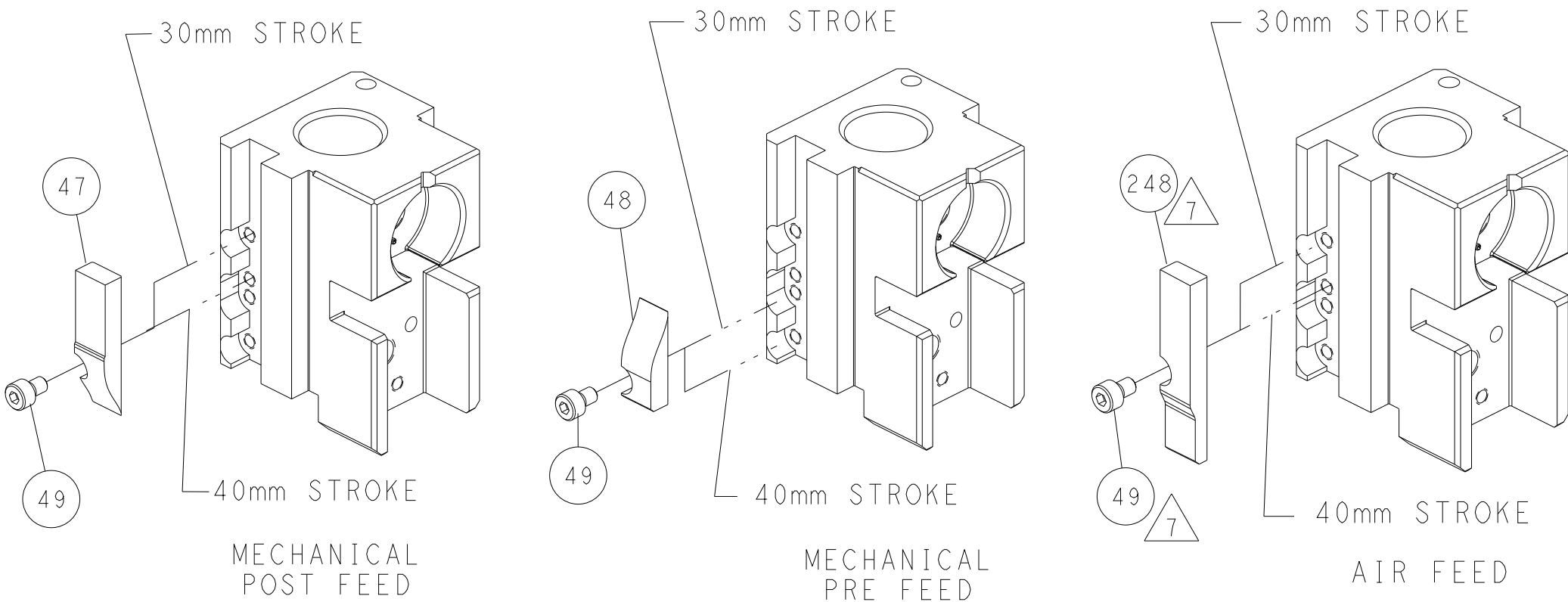


DETAIL A

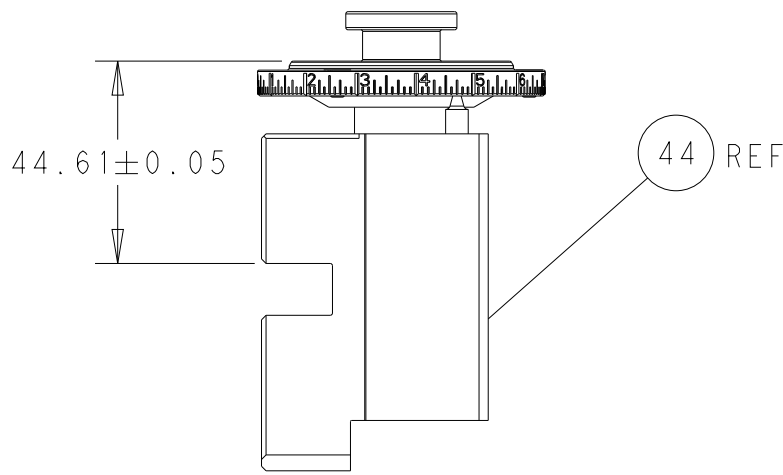
DOUBLE ACTING PNEUMATIC WITH SENSORS



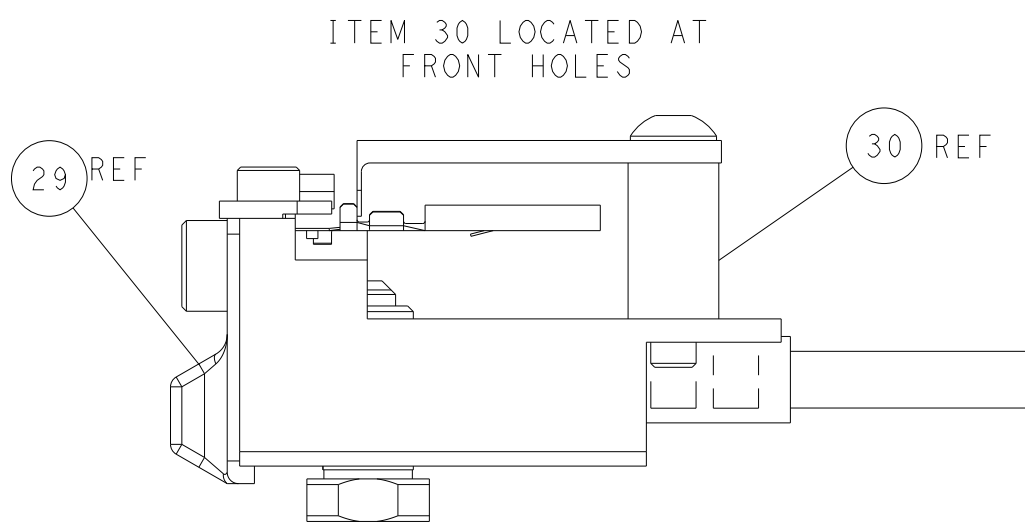
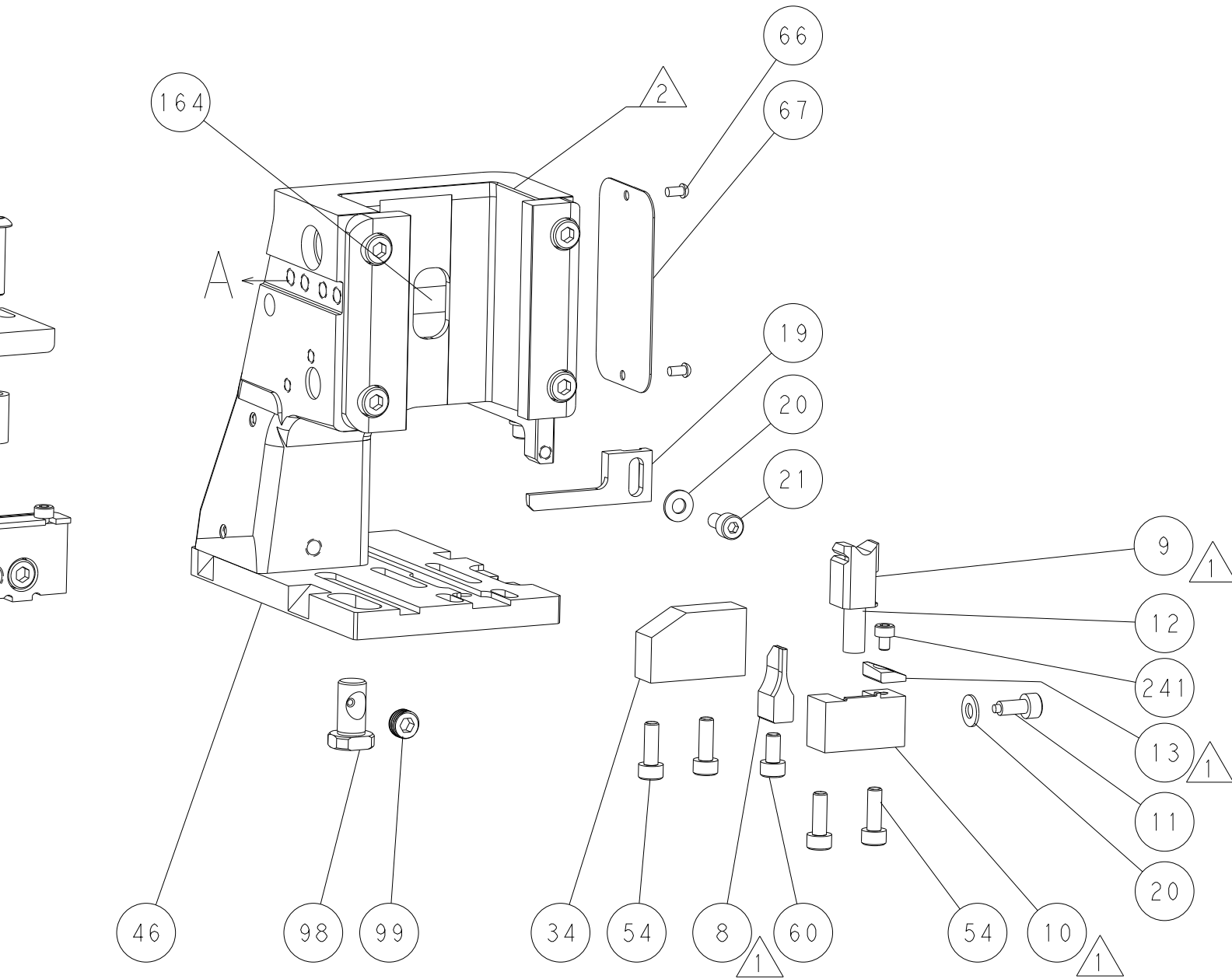
CAM POSITIONS



TERMINAL SUPPORT LOCATION

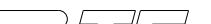


RAM SET-UP

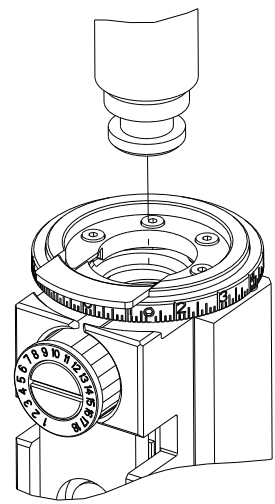


FEED TRACK POSITION
GUIDE BY INSULATION BARREL

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

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DIMENSIONS:				CHK L. ZHANG 26APR2010		NAME Ocean Side Feed Applicator					
mm				APVD J. GUO 26APR2010		SIZE A1					
TOLERANCES UNLESS OTHERWISE SPECIFIED:				PRODUCT SPEC		CAGE CODE		DRAWING NO		RESTRICTED TO	
0 PLC ±.01				APPLICATION SPEC		00779		C=2151832		-	
1 PLC ±.01				WEIGHT		A1		SCALE		1:2	
2 PLC ±.01								SHEET		2 of 4	
3 PLC ±.01								Customer Accessible Production Drawing		REV G	
4 PLC ±.01											
ANGLES FINISH											
MATERIAL											
-											

8		7	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2151832-1	G	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2151832-2	G	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
4-2151832-2	G	FINE CRIMP HEIGHT ADJUST	DOUBLE ACTING PNEUMATIC WITH SENSORS
7-2151832-7	A	CRIMP TOOLING KIT	-

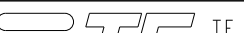
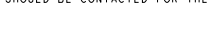


APPLICATOR DATA			
CRIMP	SIZE	TYPE	
WIRE	1.12 mm [.044]	F	
INSUL	1.57 mm [.062]	O	
APPLICATOR INSTRUCTIONS 408-35042			
TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: CONTACT, MALE, GENERATION Y, 0.64			
WIRE STRIP LENGTH			INSULATION DIAMETER RANGE
TERMINAL APPLICATION SPECIFICATION	114-13183	-	-
	-	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
1924968-8	1-2035334-8	1-1456968-4	1-2138699-4
1-1924727-4	2035170-4	1-1456968-8	1-2138699-8
1924955-8	1-2035170-4	1-1456574-8	
1-1924955-8	1924275-8	2098762-4	
2035334-8	1456968-8	1-1456841-8	
WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT	REFERENCE SETTING
2x0.13 OR 2X26 AWG	0.84+/-0.02 [.033+/- .001]		8.8
0.35mm2 OR 22 AWG	0.91+/-0.03 [.036+/- .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. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
6. THIS APPLICATOR HAS BEEN DESIGNED TO APPLY WIRES WITH THIN WALL (FLR) INSULATION.
7. THIS APPLICATOR EQUIPPED WITH THE DOUBLE ACTING PNEUMATIC FEED WITH SENSORS, AND IS APPLICATION SPECIFIC AND DOES NOT REQUIRE ITEMS 49 & 151.
8. WIRE STRIP LENGTH
2X0.13 mm² 2x0.13 mm² or 2x 26AWG; 4.3-4.5mm [.169-.177 IN]
0.35mm² or 22AWG; 4.0-4.5 mm [.157-.177 IN]
9. INSULATION DIAMETER RANGE
2X0.13mm² or 2X26AWG; 0.85-1.05mm [.033-.041 IN]
0.35mm² or 22AWG; 1.10-1.40mm [.043-.055 IN]

*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.

	-	1	-	-	2844950-1	AIR FEED MODULE	290
	-	1	1	1	2119082-8	CAM, SNAIL, INSULATION ADJUSTMENT	244
	-	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
3	-	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
	-	1	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	REF	994970-2	COUNTER, MAGNETIC	164
	-	-	1	-	2119641-2	FEED CAM, AIR FEED	155
	-	1	1	1	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	144
	-	4	4	4	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	143
	-	-	-	1	2119653-2	FEED CAM, POST FEED	142
	-	1	1	1	1-1803583-0	APPLICATOR BASIC ASSEMBLY, SF	141
	-	1	1	1	1803516-1	RAM ASSEMBLY, SF PACIFIC	140
	-	1	1	1	2844908-1	SCREW, LOCKING	99
	-	1	1	1	2844907-1	POST, LOCKING	98
	-	1	1	1	455888-4	SPACER, CRIMPER	82
	-	1	1	1	1803607-3	DOCUMENTATION PACKAGE	71
	-	1	1	1	2119791-9	DEPRESSOR, WIRE	70
	-	1	1	1	2119740-1	TAG, IDENTIFICATION	67
	-	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
	-	1	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
	-	1	1	1	1338685-1	PAWL, FEED	56
	-	2	2	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	53
	-	1	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	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
	-	1	1	1	1752356-1	SUPPORT, TERMINAL	34
	-	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
	-	2	2	2	2-2844962-4	SPACER, CYLINDRICAL, STRIP GUIDE	30
	-	1	1	1	2844992-7	ASSEMBLY, STRIP GUIDE	29
	-	1	1	1	1320928-2	STRIP GUIDE	24
	-	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
	-	2	2	2	1-18028-2	WASHER, FLAT, REG M4	20
	-	1	1	1	2119533-1	STRIPPER, SIDE FEED	19
1	-	1	1	1	2119806-1	INSERT, SHEAR	13
	-	1	1	1	3-22280-3	SPRING, COMPRESSION	12
	-	1	1	1	1-356885-4	STOP, SHEAR	11
1	-	1	1	1	2119805-1	SHEAR HOLDER, FRONT	10
	-	1	1	1	1803095-1	FLOATING SHEAR, FRONT	9
1	1	1	1	1	1803058-6	ANVIL, COMBINATION	8
	-	-	-	-	-	-	7
	-	-	-	-	-	-	6
	-	1	1	1	2119757-1	DEPRESSOR, SHEAR	5
1	-	1	1	1	3-238011-1	BLOCK, CRIMPER SPACER	4
1	1	1	1	1	1-1803019-1	CRIMPER, INSULATION O	3
	-	1	1	1	455888-1	SPACER, CRIMPER	2
1	1	1	1	1	3-1633860-6	CRIMPER, WIRE	1

THIS DRAWING IS A CONTROLLED DOCUMENT AND ANY ELECTRIFICATION OR MODIFICATION SHALL BE CONTROLLED BY THE LATEST VERSION.		DWN 26APR2010 CHG 26APR2010 APP 26APR2010 U GUO		 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	
		PRODUCT SPEC - APPLICATION SPEC -		SIZE CAGE CODE DRAWING NO A 00779 C=2151832	
MATERIAL -		WEIGHT -		RESTRICTED TO -	
Customer Accessible Production Drawing				SCALE 1:2 SHEET 3 of 4 REV G	

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

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	DWN	APVD
A	66	-		SEE SHEET 1	-	-	-

D

C

B

A

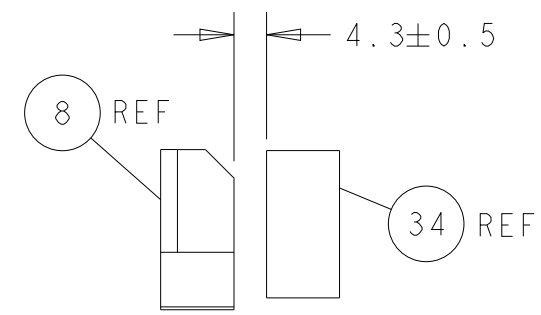
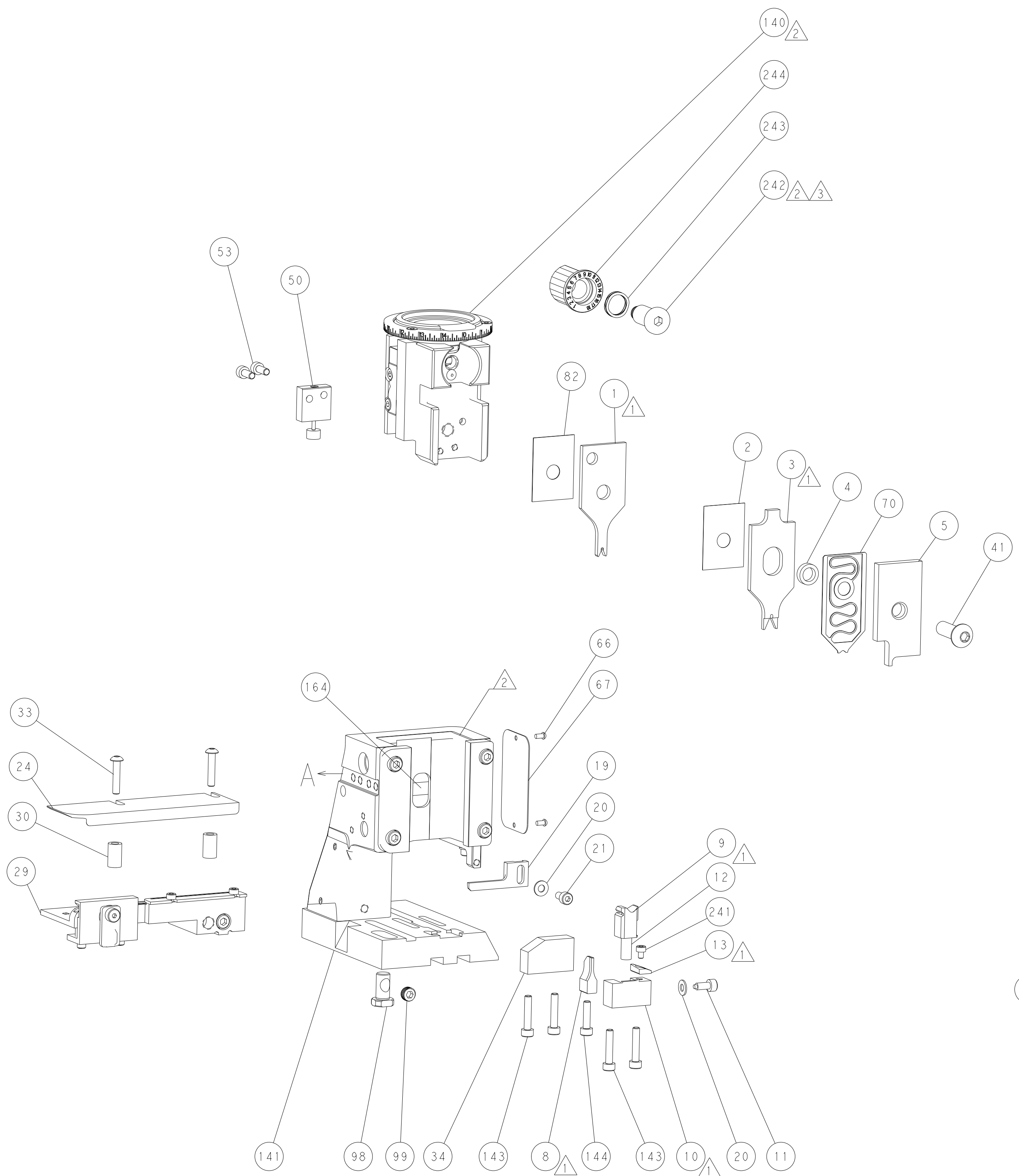
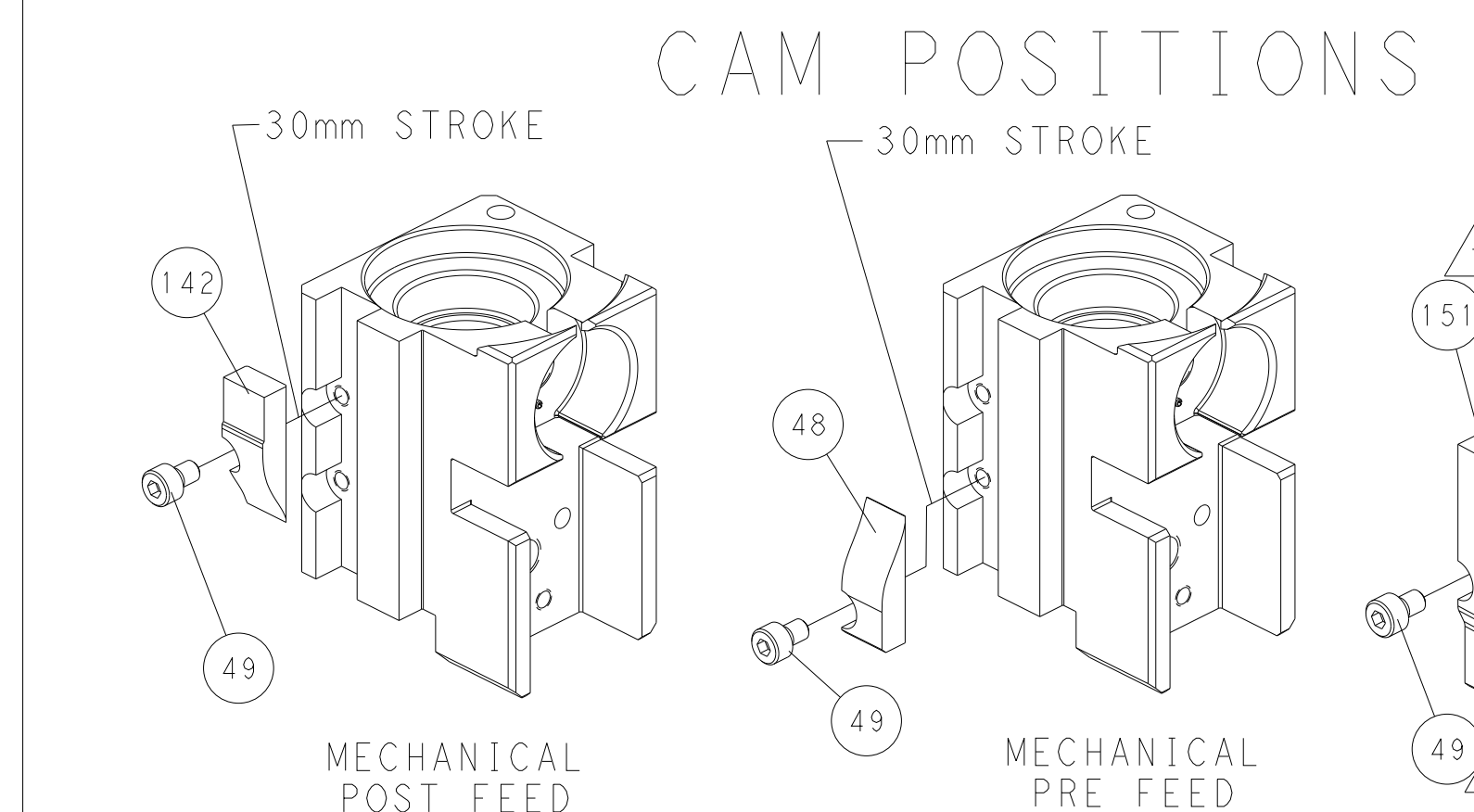
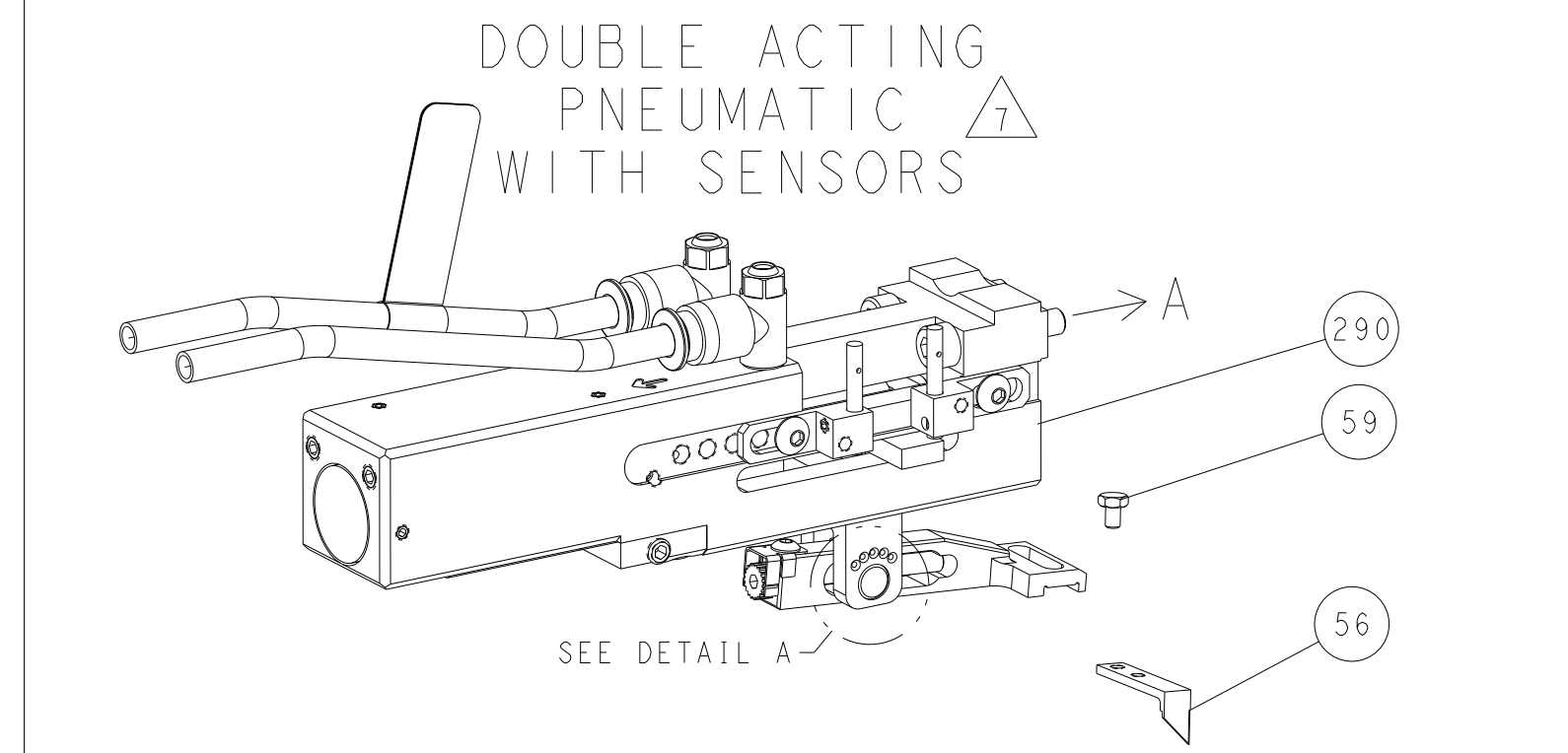
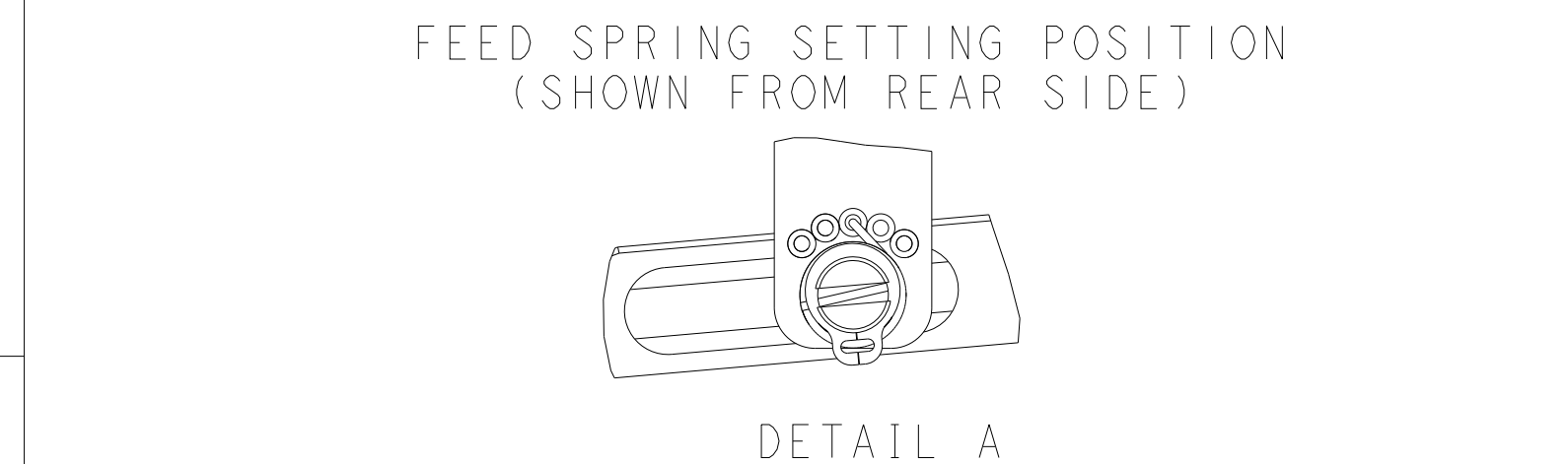
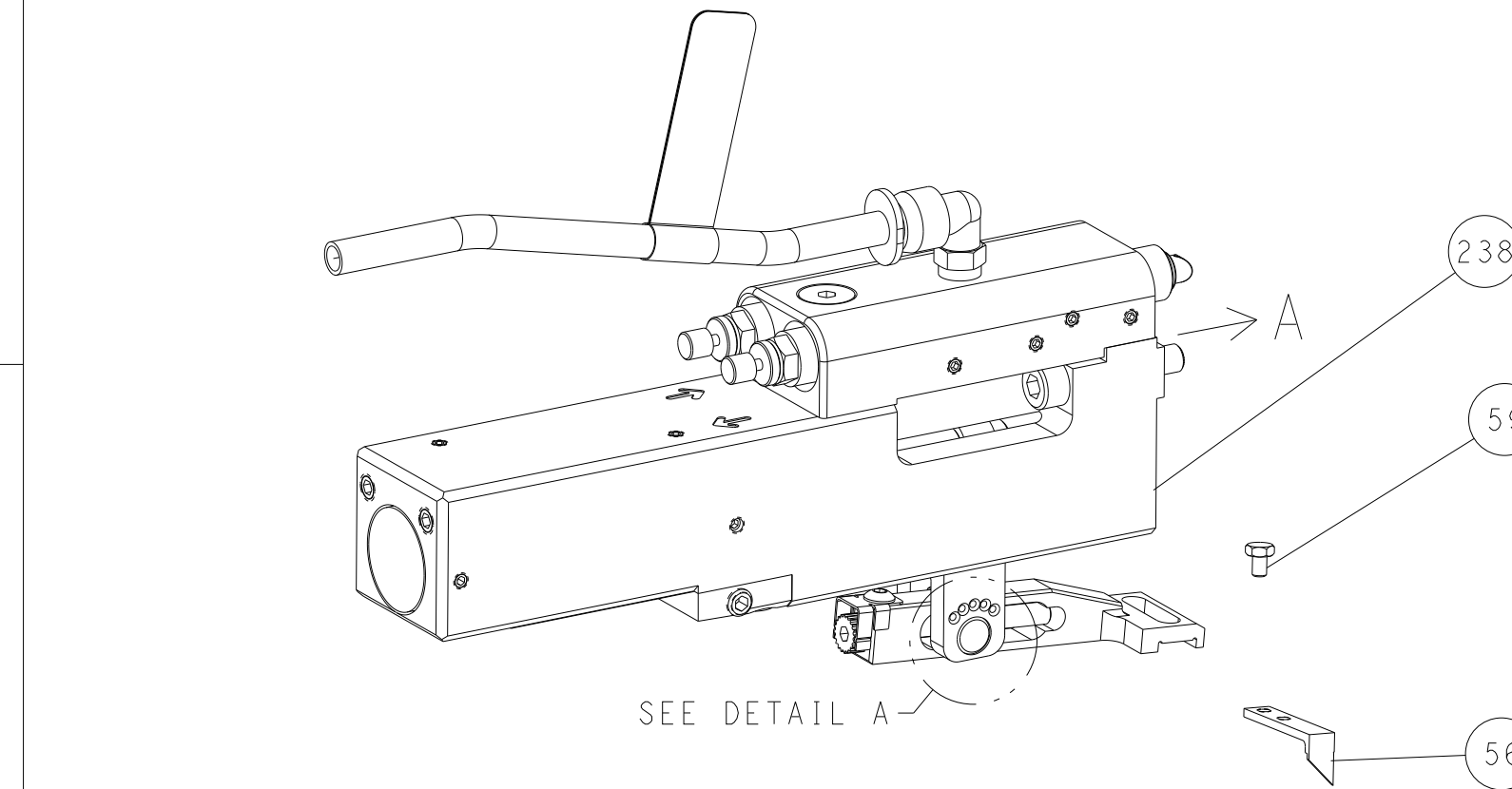
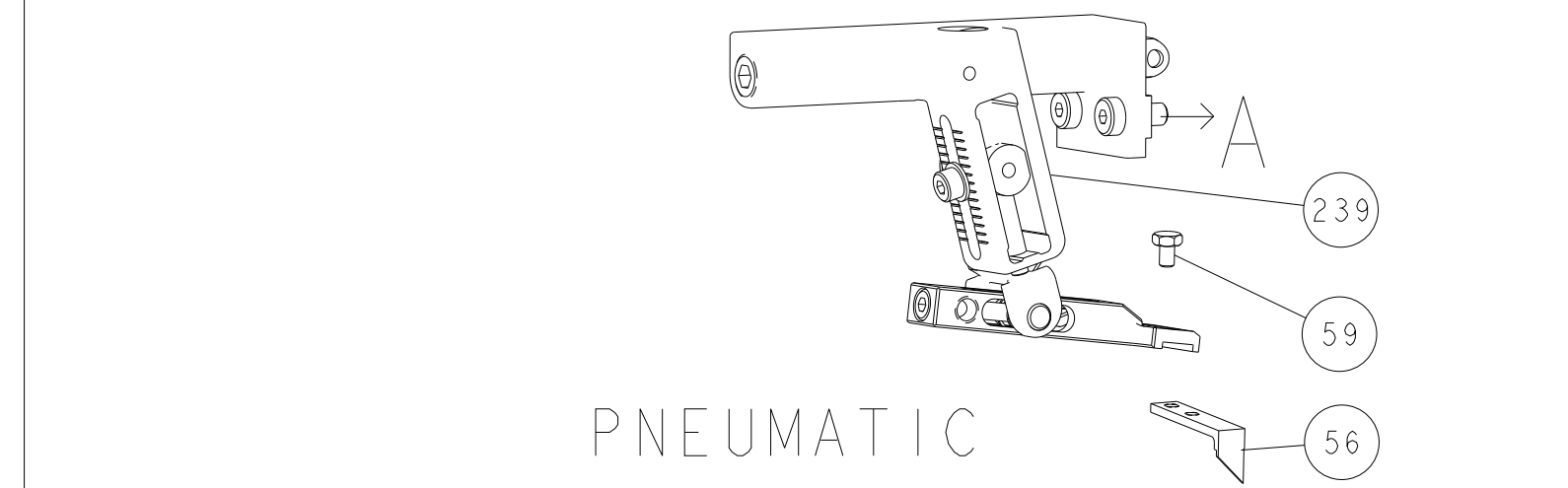
D

C

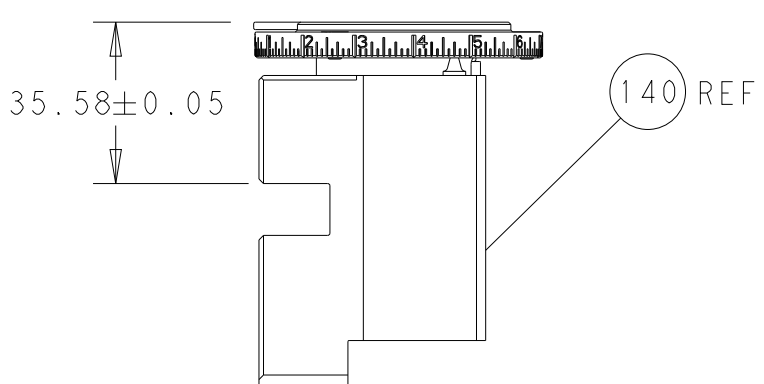
B

A

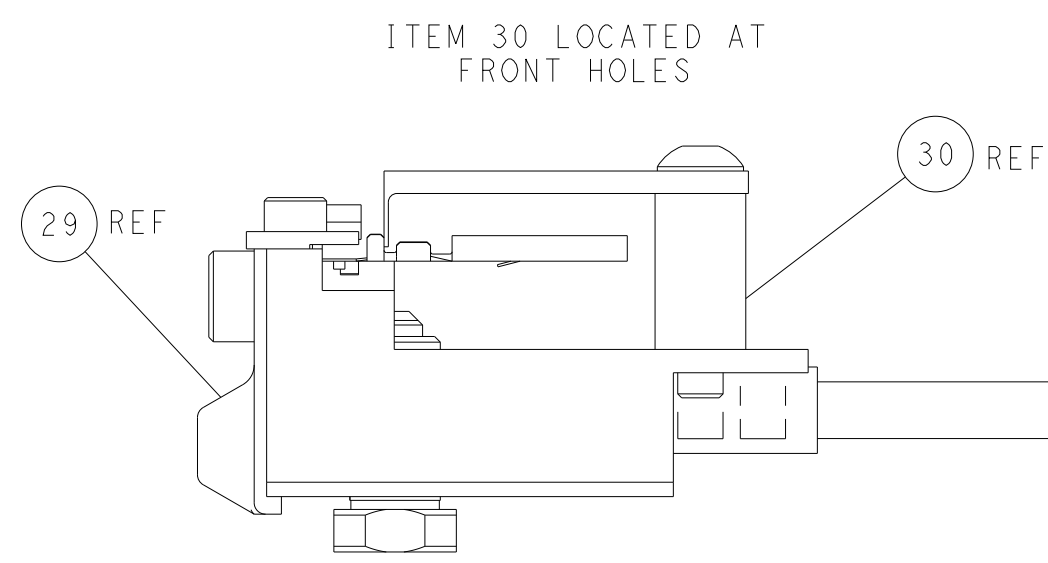
FEED TYPE MECHANICAL



TERMINAL SUPPORT LOCATION



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)

THE 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 26APR2010		 TE Connectivity Harrisburg, PA 17105-3608					
DIMENSIONS: mm										CHK L. ZHANG 26APR2010							
TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH										APVD V. GUO 26APR2010		NAME Ocean Side Feed Applicator					
MATERIAL -										PRODUCT SPEC -		APPLICATION SPEC -					
										SIZE A		CAGE CODE 00779		DRAWING NO C-2151832		RESTRICTED TO -	
										WEIGHT -		Customer Accessible Production Drawing					
										SCALE 1:2		SHEET 4		OF 4		REV G	

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

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