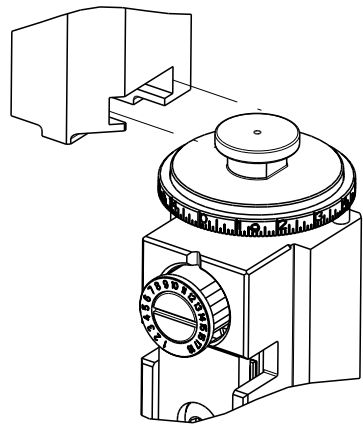


8		7	
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20		20	
(C) COPYRIGHT 20 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.			
PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151182-2	F	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151182-2	F	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2151182-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR
INTERFACE ADAPTER

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.29 mm [.090]	F
INSUL	3.30 mm [.130]	F
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: POSITIVE LOCK RECEPTACLE			
WIRE STRIP LENGTH 5.46-6.22 mm [.215-.245 IN]		INSULATION DIAMETER RANGE Ø2.30-3.30 mm [.091-.130 IN]	
TERMINAL APPLICATION SPECIFICATION 		114-2153 - -	
TERMINALS APPLIED  			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
160759-1	160759-4	1-160759-9	3-160759-1
160759-2	1-160759-1	2-160759-9	3-160759-4
160759-3	1-160759-2	3-160759-0	2-160759-1

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING
1.50mm2		1.65+/-0.05 [.065+/- .002]		4.9
0.70mm2		1.60+/-0.05 [.063+/- .002]		5.2
0.60mm2		1.50+/-0.05 [.059+/- .002]		6.3
0.50mm2		1.45+/-0.05 [.057+/- .002]		7.0



 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 PITCH NOT COMPATIBLE WITH MECHANICAL FEED.

6 TERMINAL LUBRICANT IS RECOMMENDED.

7. 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)

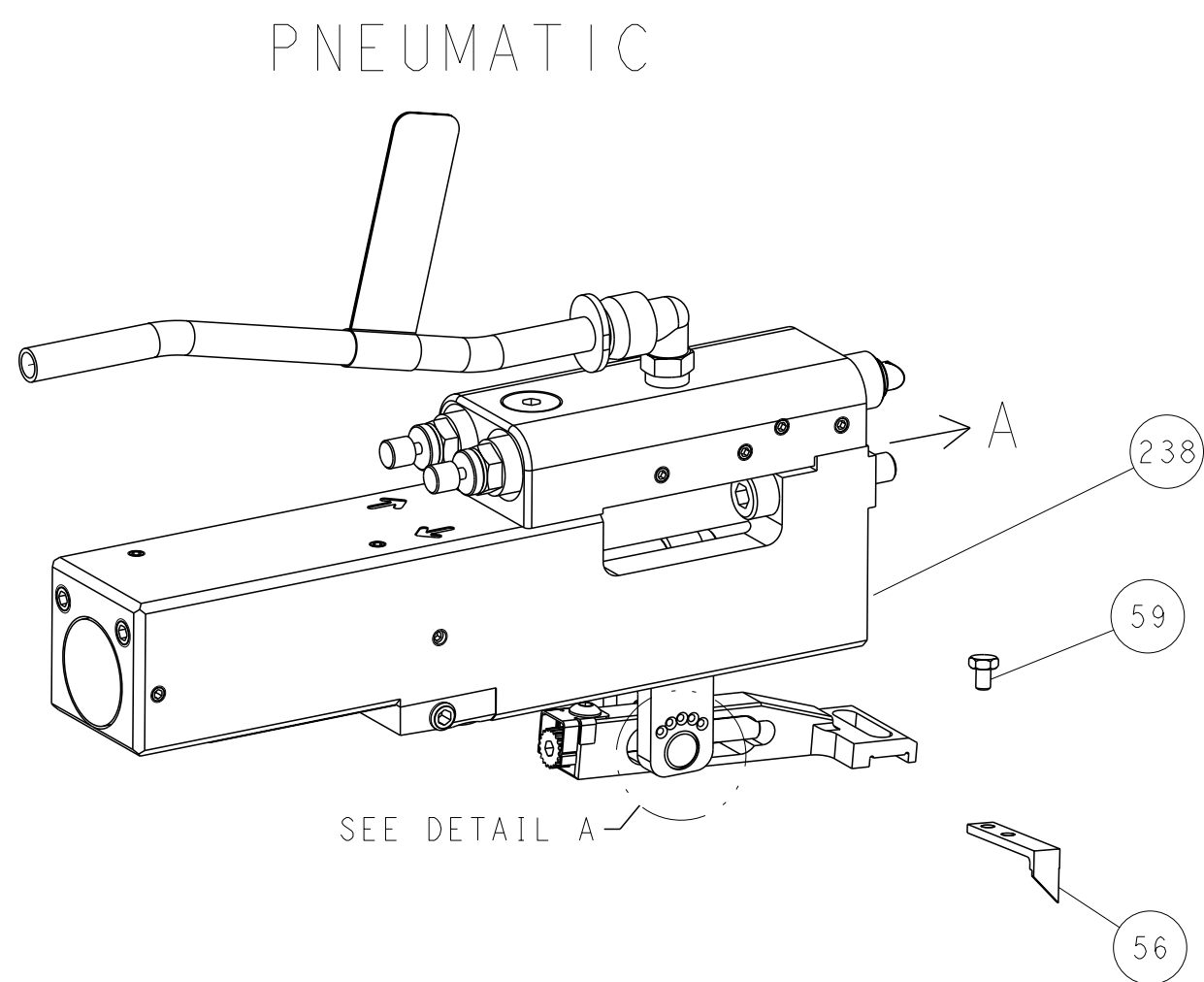
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			E	ECR-18-012726	10AUG2018	MZ	CT	
			F	ECR-19-005669	09APR2019	JAH	CT	
			F1	ECR-19-014169	10SEP2019	FJ	TE	

	-	1	1	2119641-1	FEED CAM, AIR FEED	248
	-	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	1	2844940-2	AIR FEED MODULE	238
6	-	REF	REF	994970-2	COUNTER, MAGNETIC	164
	-	1	1	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113
	-	1	1	2844908-1	SCREW, LOCKING	99
	-	1	1	2844907-1	POST, LOCKING	98
	-	1	1	455888-4	SPACER, CRIMPER	82
	-	1	1	22278-7	SPRING, COMPRESSION	77
	-	1	1	854769-4	HOLDER, INS	74
	-	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	73
	-	1	1	693855-8	FRONT STRIP GUIDE	72
	-	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	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	60
	-	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
	-	1	1	21028-2	PIN, SLOTTED SPRING .062 X .250	58
	-	1	1	1338685-1	PAWL, FEED	56
	-	4	4	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	54
	-	2	2	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	53
	-	1	1	1803382-6	HOLD DOWN, SPRING LOADED	50
	-	1	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49
	-	1	1	1803583-9	APPLICATOR BASIC ASSEMBLY, SF	46
	-	1	1	1803515-1	RAM ASSEMBLY, SF ATLANTIC	44
	-	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
	-	1	1	1-1752356-7	SUPPORT, TERMINAL	34
	-	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
	-	2	2	2-18032-5	SCR, SET, FLT PNT, M5 X 20.0	31
	-	2	2	3-2844962-0	SPACER, CYLINDRICAL, STRIP GUIDE	30
	-	1	1	2844992-3	ASSEMBLY, STRIP GUIDE	29
	-	1	1	455888-3	SPACER, CRIMPER	28
	-	2	2	22283-1	SPRING, COMPRESSION	27
	-	1	1	356835-1	LEVER, DRAG RELEASE	26
	-	1	1	240792-1	DRAG, TERMINAL	25
	-	1	1	1320928-2	STRIP GUIDE	24
	-	1	1	980371-4	SCR, SKT HD SHLDR 5.0 DIA X 6.0	23
	-	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	318563-1	GUARD, FRONT CHIP	14
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	1	2119805-1	SHEAR HOLDER, FRONT	10
1	-	1	1	1803095-1	FLOATING SHEAR, FRONT -	9
1	1	2	1	1333205-2	ANVIL, COMBINATION	8
	-	1	1	240641-2	SPACER	7
	-	1	1	2119780-9	DEPRESSOR, SHEAR	5
	-	1	1	1-238011-7	BLOCK, CRIMPER SPACER	4
1	1	2	1	1-1633961-5	CRIMPER, INSULATION F PREMIUM	3
	-	1	1	455888-8	SPACER, CRIMPER	2
1	1	2	1	1-456406-1	CRIMPER, WIRE PREMIUM	1
-77 -72 -2 PART NO					DESCRIPTION	ITEM NO

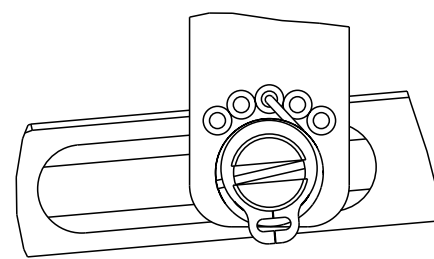
THIS DRAWING IS A CONTROLLED DOCUMENT FOR THE ELECTRICAL CONNECTIONS DEPARTMENT. IT IS THE PROPERTY OF TE CONNECTIVITY. IT IS TO BE KEPT IN THE ORIGINAL FILE AND SHOULD BE CONTROLLED FOR THE LIFETIME OF THE PART.		DWG 17AUG2011 TYN		 TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		NAME	
mm		G. BAILEY 17AUG2011		Ocean Side Feed Applicator	

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

FEED TYPE

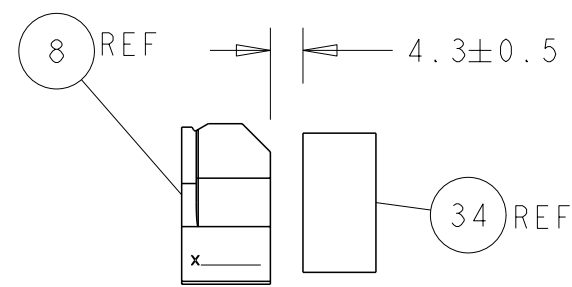
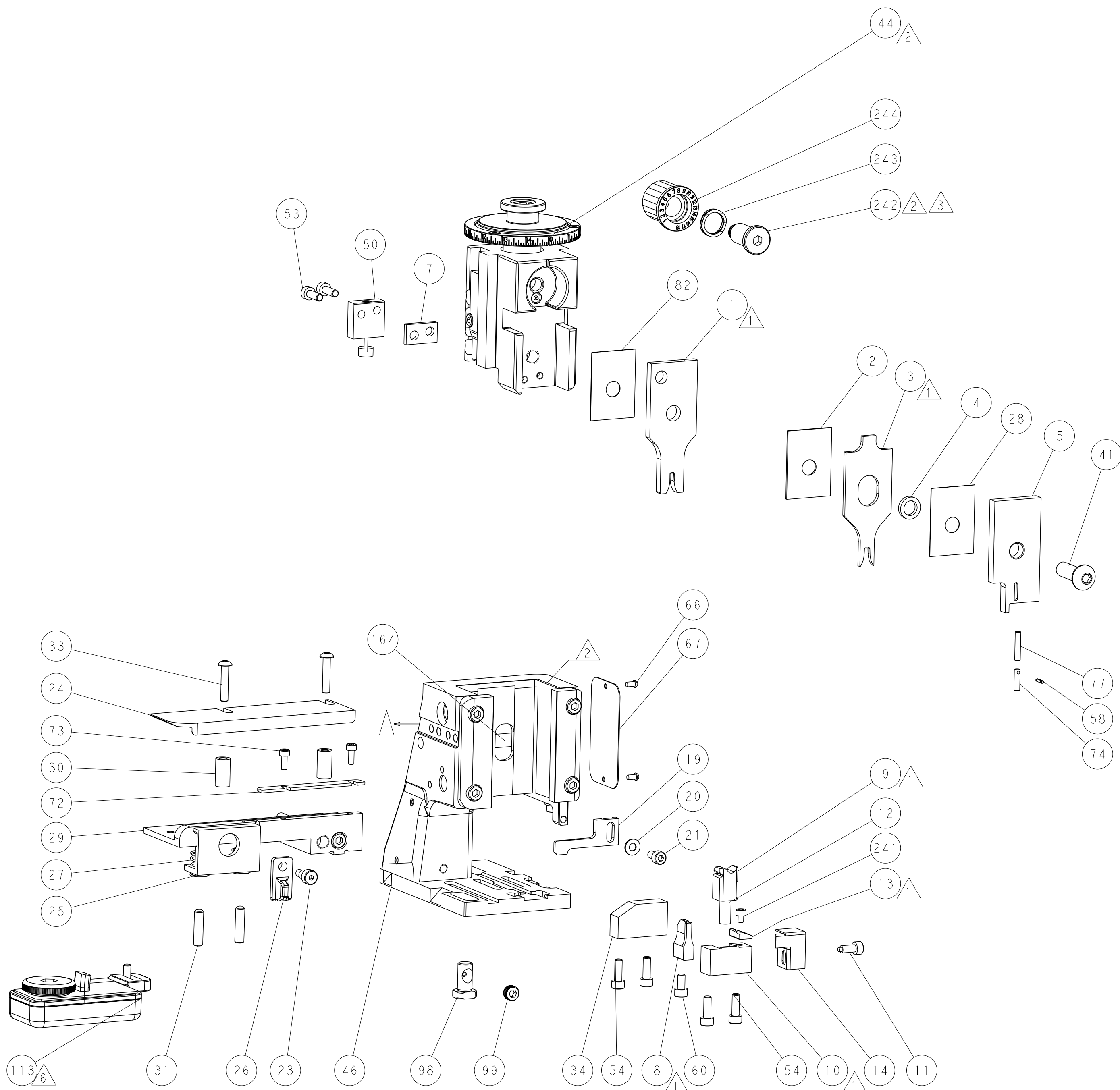
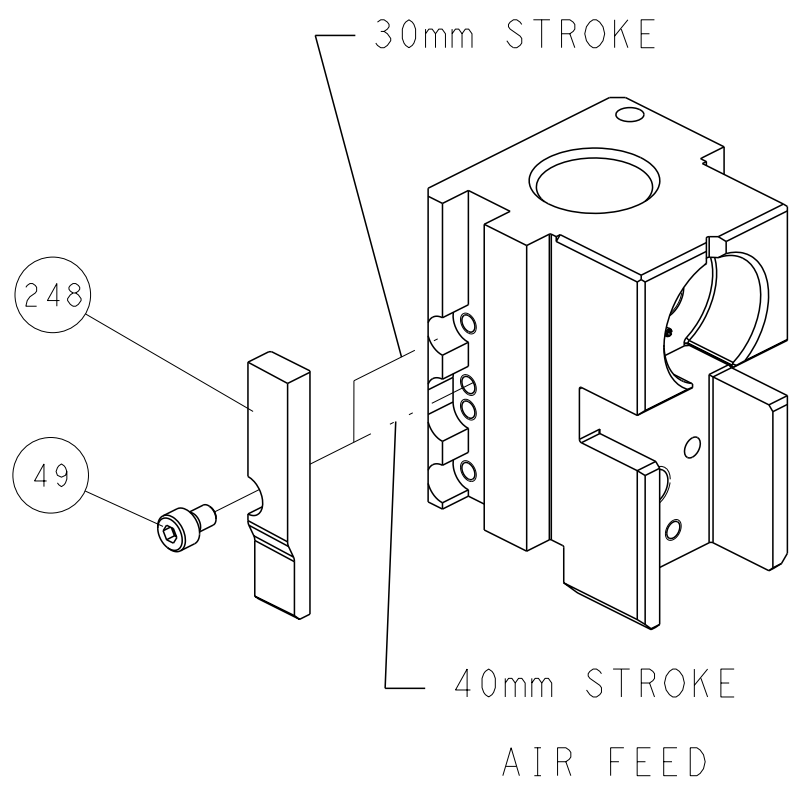


FEED SPRING SETTING POSITION
(SHOWN FROM REAR SIDE)

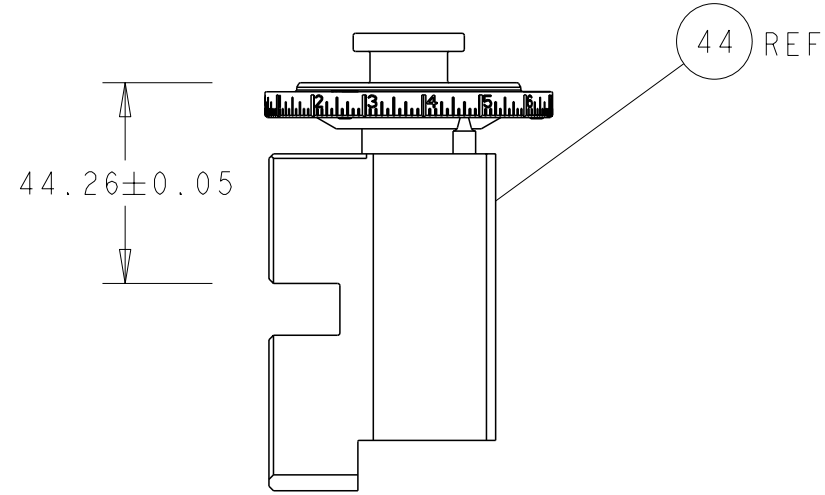


DETAIL A

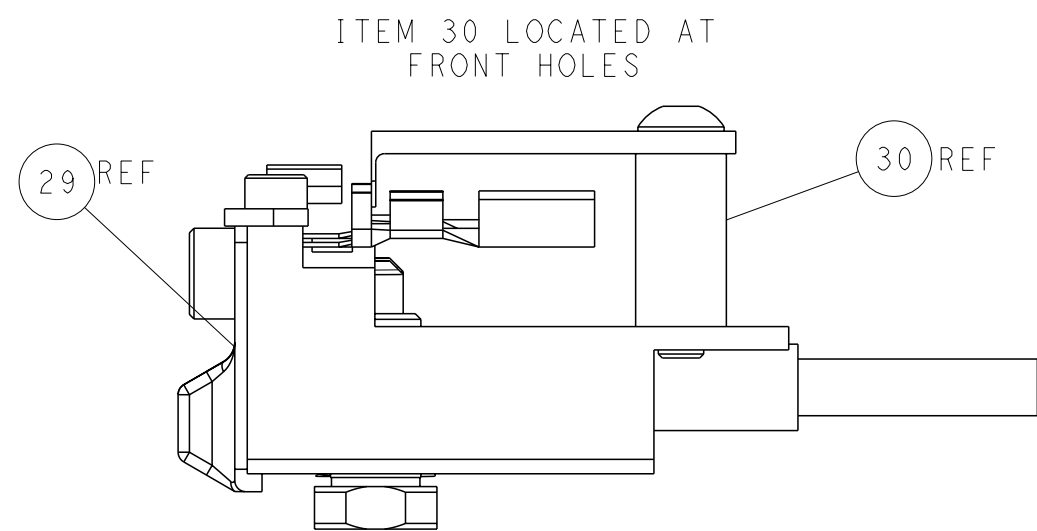
CAM POSITION



TERMINAL SUPPORT LOCATION



RAM SET-UP



FEED TRACK POSITION
GUIDE BY INSULATION BARREL

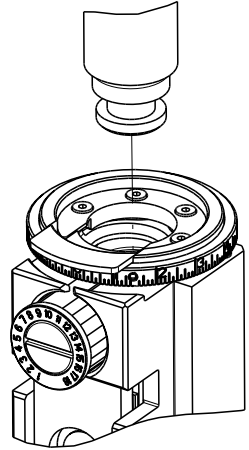
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION IT IS SUBJECT TO CHANGE AND TO CONTROL THE ENGINEERING ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST REVISION				DWN Y. YIN	17AUG2011	TE Connectivity Harrisburg, PA 17105-3608	
				CHK G. BAILEY	17AUG2011		
				APVD S. XI	17AUG2011	NAME Ocean Side Feed Applicator	
DIMENSIONS: mm				PRODUCT SPEC		SIZE A1	
				APPLICATION SPEC		CAGE CODE 00779	
TOLERANCES UNLESS OTHERWISE SPECIFIED:				WEIGHT		DRAWING NO C=2151182	
0 PLC ±				CUSTOMER ACCESSIBLE PRODUCTION DRAWING		SCALE 1:2	
1 PLC ±						SHEET 2	
2 PLC ±						OF 4	
3 PLC ±						REV F1	
4 PLC ±							
ANGLES ±							
FINISH -							

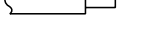
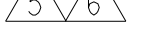
SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2151182-2	F	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151182-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.29 mm [.090]	F
INSUL	3.30 mm [.130]	F
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: POSITIVE LOCK RECEPTACLE			
WIRE STRIP LENGTH 5.46-6.22 mm [.215-.245 IN]		 INSULATION DIAMETER RANGE Ø2.30-3.30 mm [.091-.130 IN]	
TERMINAL APPLICATION SPECIFICATION	 114-2153	-	-
TERMINALS APPLIED			
			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
160759-1	160759-4	1-160759-9	3-160759-1
160759-2	1-160759-1	2-160759-9	3-160759-4
160759-3	1-160759-2	3-160759-0	2-160759-1

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING
1.50mm2		1.65+/-0.05 [.065+/- .002]		4.9
0.70mm2		1.60+/-0.05 [.063+/- .002]		5.2
0.60mm2		1.50+/-0.05 [.059+/- .002]		6.3
0.50mm2		1.45+/-0.05 [.057+/- .002]		7.0



- 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.
- TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- TERMINAL LUBRICANT IS RECOMMENDED.

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	DWN	APVD
A	66		-	SEE SHEET 1	-	-	-
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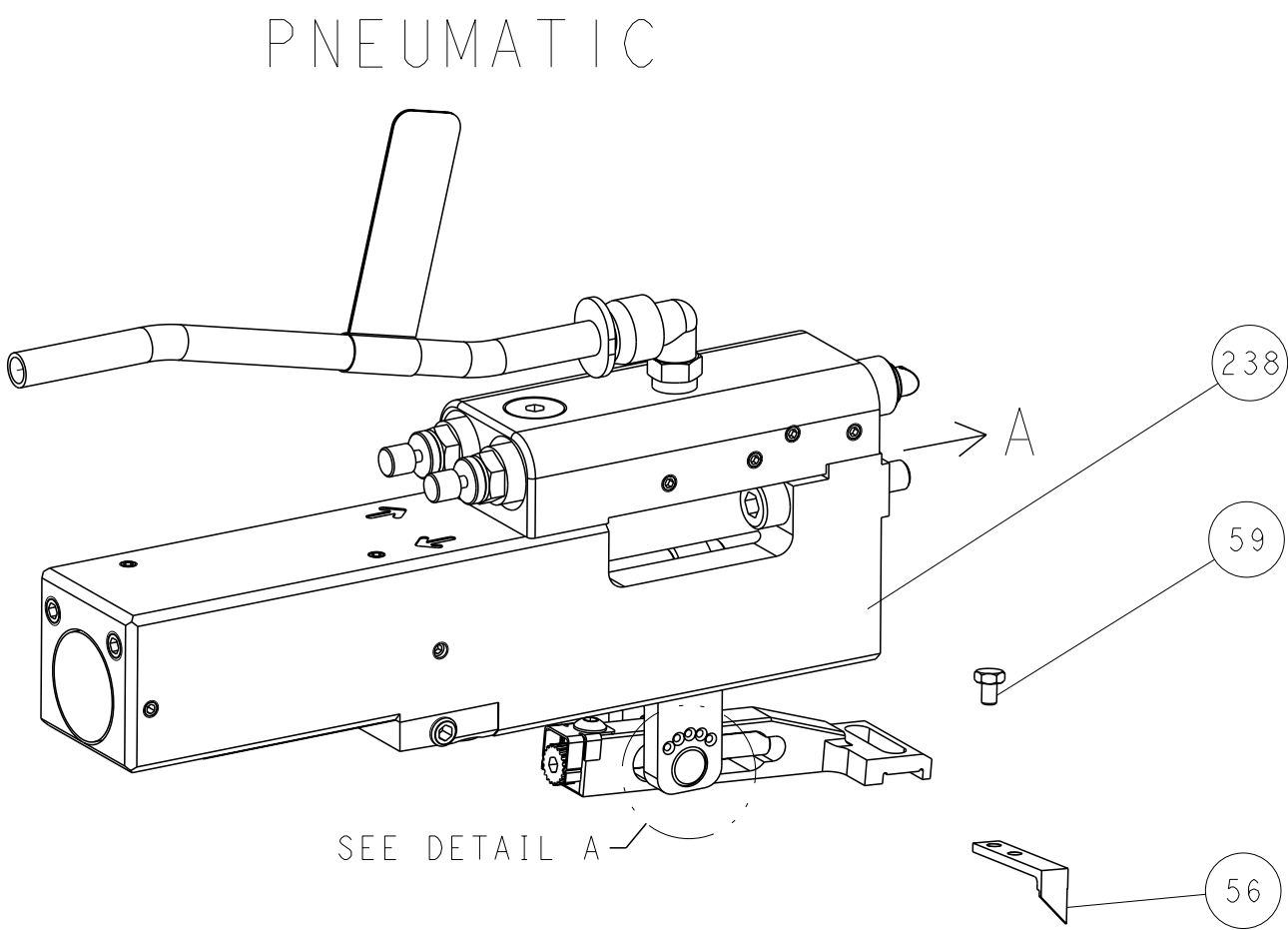
	-	1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244
	-	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
3	-	1	2119083-1	RETAINER, INSULATION DIAL	242
	-	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
	-	1	2844940-2	AIR FEED MODULE	238
	-	REF	994970-2	COUNTER, MAGNETIC	164
	-	1	2119641-2	FEED CAM, AIR FEED	151
	-	1	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	144
	-	4	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	143
	-	1	1-1803583-0	APPLICATOR BASIC ASSEMBLY, SF	141
	-	1	1803516-1	RAM ASSEMBLY, SF PACIFIC	140
6	-	1	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113
	-	1	2844908-1	SCREW, LOCKING	99
	-	1	2844907-1	POST, LOCKING	98
	-	1	455888-4	SPACER, CRIMPER	82
	-	1	22278-7	SPRING, COMPRESSION	77
	-	1	854769-4	HOLDER, INS	74
	-	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	73
	-	1	693855-8	FRONT STRIP GUIDE	72
	-	1	1803607-3	DOCUMENTATION PACKAGE	71
	-	1	2119740-1	TAG, IDENTIFICATION	67
	-	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
	-	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
	-	1	21028-2	PIN, SLOTTED SPRING .062 X .250	58
	-	1	1338685-1	PAWL, FEED	56
	-	2	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	53
	-	1	1803382-6	HOLD DOWN, SPRING LOADED	50
	-	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49
	-	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
	-	1	1-1752356-7	SUPPORT, TERMINAL	34
	-	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
	-	2	2-18032-5	SCR, SET, FLT PNT, M5 X 20.0	31
	-	2	3-2844962-0	SPACER, CYLINDRICAL, STRIP GUIDE	30
	-	1	2844992-3	ASSEMBLY, STRIP GUIDE	29
	-	1	455888-3	SPACER, CRIMPER	28
	-	2	22283-1	SPRING, COMPRESSION	27
	-	1	356835-1	LEVER, DRAG RELEASE	26
	-	1	240792-1	DRAG, TERMINAL	25
	-	1	1320928-2	STRIP GUIDE	24
	-	1	980371-4	SCR, SKT HD SHLDR 5.0 DIA X 6.0	23
	-	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
	-	1	1-18028-2	WASHER, FLAT, REG M4	20
	-	1	2119533-1	STRIPPER, SIDE FEED	19
	-	1	318563-1	GUARD, FRONT CHIP	14
1	-	1	2119806-1	INSERT, SHEAR	13
	-	1	3-22280-3	SPRING, COMPRESSION	12
	-	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	1333205-2	ANVIL, COMBINATION	8
	-	1	240641-2	SPACER	7
	-	1	2119780-9	DEPRESSOR, SHEAR	5
	-	1	1-238011-7	BLOCK, CRIMPER SPACER	4
1	1	1	1-1633961-5	CRIMPER, INSULATION F PREMIUM	3
	-	1	455888-8	SPACER, CRIMPER	2
1	1	1	1-456406-1	CRIMPER, WIRE PREMIUM	1
-77	-22		PART NO	DESCRIPTION	ITEM NO

DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±° FINISH -		OWN Y. YIN 17AUG2011 CHK G. BAILEY 17AUG2011 APVD S. XI 17AUG2011 PRODUCT SPEC - APPLICATION SPEC - WEIGHT -		TE Connectivity Harrisburg, PA 17105-3608 Ocean Side Feed Applicator - SIZE CAGE CODE DRAWING NO RESTRICTED TO	
MATERIAL -		-		A		00779 ©=2151182	
CUSTOMER ACCESSIBLE PRODUCTION DRAWING				SCALE 1:2		SHEET 3 of 4	
						REV F1	

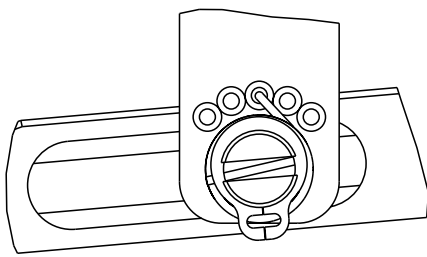
SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

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

FEED TYPE

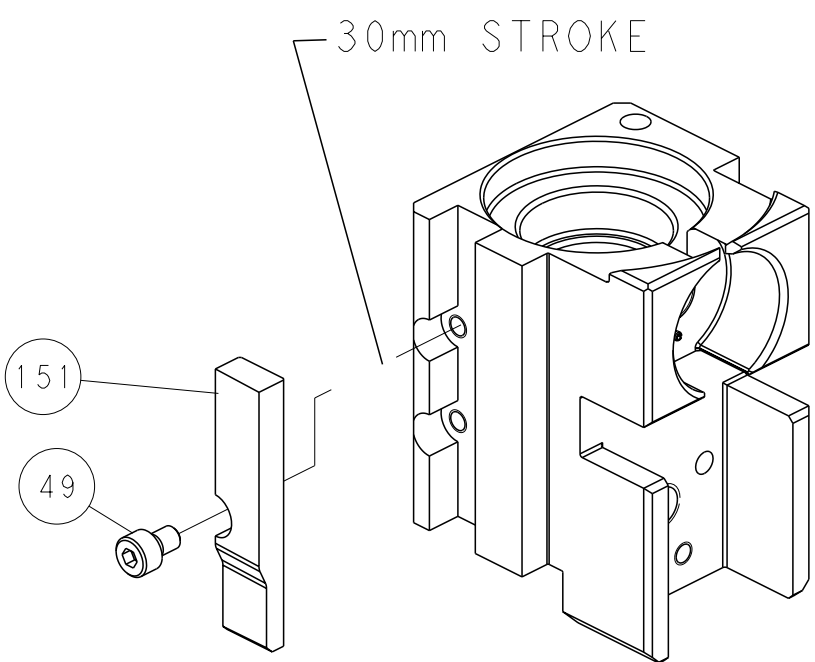


FEED SPRING SETTING POSITION
(SHOWN FROM REAR SIDE)

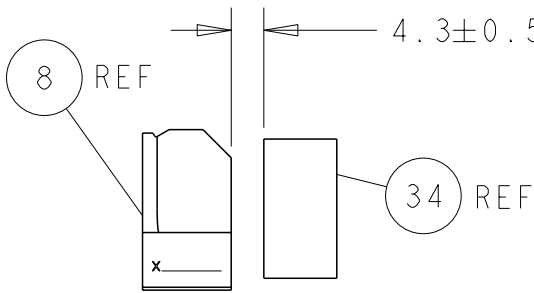
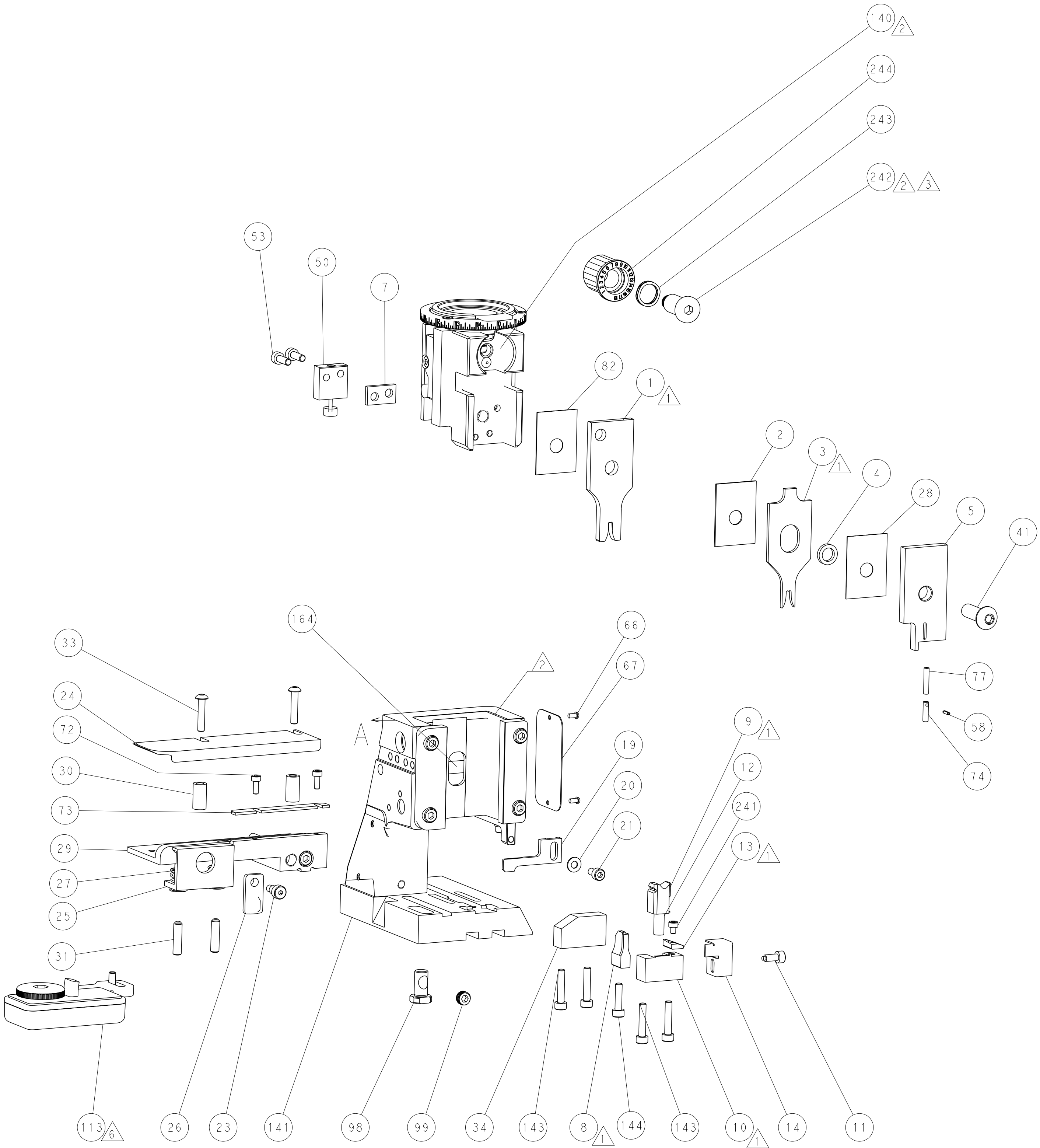


DETAIL A

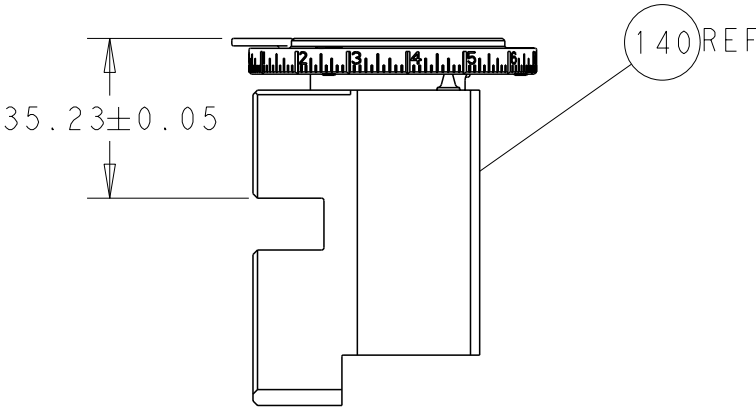
CAM POSITION



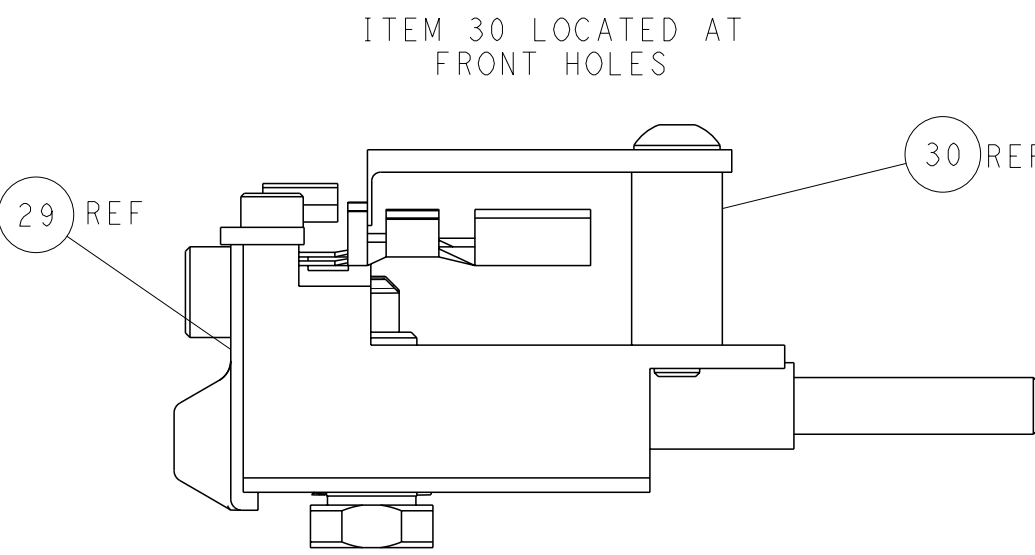
AIR FEED



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)

THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION IT IS SUBJECT TO CHANGE AND TO CONTROL AND ENGINEERING ORGANIZATION SHALL BE CONTACTED FOR THE LATEST REVISION		DWN Y. YIN	18AUG2011	TE Connectivity Harrisburg, PA 17105-3608	
		CHK G. BAILEY	18AUG2011		
		APVD S. XI	18AUG2011	NAME Ocean Side Feed Applicator	
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		PRODUCT SPEC	
		0 PLC ±		APPLICATION SPEC	
		1 PLC ±		CAGE CODE DRAWING NO	
		2 PLC ±		RESTRICTED TO	
		3 PLC ±		SIZE	
		4 PLC ±		CAGE CODE DRAWING NO	
		ANGLES		WEIGHT	
		FINISH		A1 00779 C=2151182	
MATERIAL				CUSTOMER ACCESSIBLE PRODUCTION DRAWING	
				SCALE 1:2 SHEET 4 OF 4 REV F1	