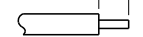


8		7	
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20		20	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151579-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2151579-2	D	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151579-1	C	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2151579-2	D	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2151579-7	A	CRIMP TOOLING KIT	-

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	3.05 mm [.120]	F
INSUL	3.98 mm [.157]	O
APPLICATOR INSTRUCTIONS 408-35042		

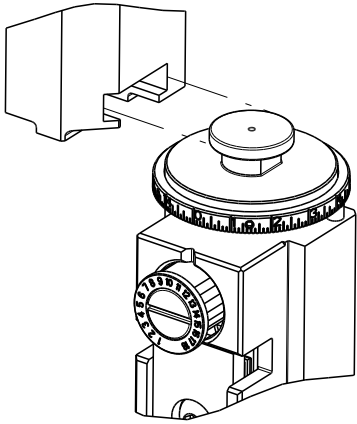
TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: POWER QUADLOK CONTACT			
WIRE STRIP LENGTH			INSULATION DIAMETER RANGE
5.20-5.80 mm [.205-.228 IN]			Ø3.40-3.70 mm [.134-.146 IN]
TERMINAL APPLICATION SPECIFICATION		114-18141-1	
		-	-
		-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
968073-2	968132-2	1241602-2	1241615-2

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
4.00mm2	2.34+/-0.05 [.092+/- .002]	8.8



- 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 ITEM 34 TO BE USED FOR TERMINAL PN 968073-2 AND 968132-2.
- 6 ITEM 261 TO BE USED FOR TERMINAL PN 1241602-2 AND 1241615-2.
- 7 CUT TO LENGTH AT ASSEMBLY.
8. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.

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
		B		ECR-13-004646			14MAR2013	JY	UG
		B1		ECR-16-001135			26JAN2016	JH	GB
		C		ECR-18-007489			15MAY2018	MEH	JDG
		D		ECR-19-009768			23JUN2019	TB	TE

6	-	1	1	1	1	1752356-6	SUPPORT, TERMINAL	261
	-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248
	-	1	1	1	1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244
3	-	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	455888-5	SPACER, CRIMPER	82
	-	1	1	1	1	1803607-3	DOCUMENTATION PACKAGE	71
	-	1	1	1	1	2119791-5	DEPRESSOR, WIRE	70
	-	1	1	1	1	2119943-1	WASHER, SPACER	69
	-	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	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	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	53
	-	1	1	1	1	5018030-1	NUT, HEX, REG, RoHS, M3	52
	-	1	1	1	1	811242-5	BUMPER, HOLD DOWN	51
	-	1	1	1	1	690753-2	SPACER, TONKER	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
5	-	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	3-2844962-2	SPACER, CYLINDRICAL, STRIP GUIDE	30
	-	1	1	1	1	2844992-2	ASSEMBLY, STRIP GUIDE	29
	-	1	1	1	1	455888-4	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	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	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	1	1	1333208-8	ANVIL, COMBINATION .120	8
	-	1	1	1	1	2-240641-4	SPACER	7
	-	-	-	-	-	-	-	6
	-	1	1	1	1	1-2119757-0	DEPRESSOR, SHEAR	5
	-	1	1	1	1	238011-1	BLOCK, CRIMPER SPACER	4
	1	2	2	1	1	2-2119784-6	CRIMPER, INSULATION O PREMIUM	3
1	-	1	1	1	1	455888-4	SPACER, CRIMPER	2
	1	2	2	1	1	2-456409-8	CRIMPER, WIRE .120 "F" PREMIUM	1
	-	-	-	-	-	-	-	-

THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. THE USER SHALL BE RESPONSIBLE FOR OBTAINING THE LATEST EDITION.				DWN	L. ZHANG	12JUN2012	 TE Connectivity Harrisburg, PA 17105-3608				
DIMENSIONS:				CHK	L. ZHANG	12JUN2012	NAME				
mm				APVD	S. XI	12JUN2012	Ocean Side Feed Applicator -				
TOLERANCES UNLESS OTHERWISE SPECIFIED:				PRODUCT SPEC		SIZE					
0 PLC ±				APPLICATION SPEC		CAGE CODE					
1 PLC ±				WEIGHT		DRAWING NO					
2 PLC ±				MATERIAL		00779					
3 PLC ±				FINISH		2151579					
4 PLC ±				Customer Accessible Production Drawing		SCALE					
ANGLES				1:1		SHEET 1 OF 4					
FINISH				REV		D					

SEE DETAIL A

FEED SPRING SETTING POSITION
(SHOWN FROM REAR SIDE)

238

59

56



30mm STROKE

47

49

40mm STROKE

MECHANICAL POST FEED

30mm STROKE

48

49

40mm STROKE

MECHANICAL PRE FEED

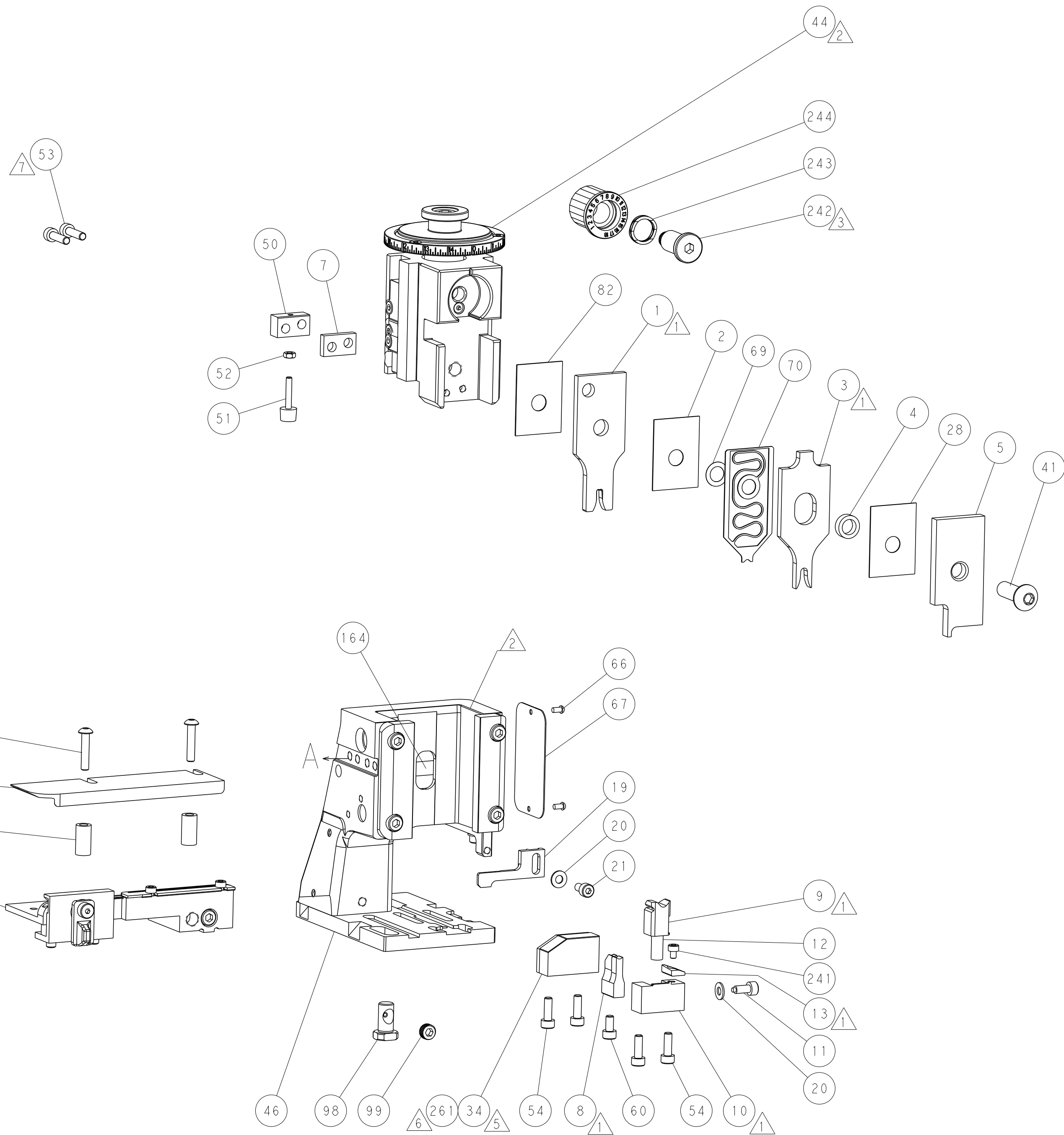
30mm STROKE

248

49

40mm STROKE

AIR FEED

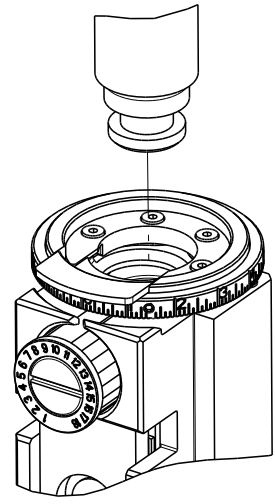


Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

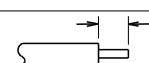
THIS DRAWING IS A CONTROLLED DOCUMENT FOR ISO-9001:2015 CERTIFICATION 1710 IS REQUIRED. ANY CHANGES TO THIS DOCUMENT MUST BE APPROVED BY THE ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST VERSION		DWN 12JUN2012 CRK L ZHANG 12JUN2012		 TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		NAME APVD S.X.I 12JUN2012 PRODUCT SPEC - APPLICATION SPEC -	
		WEIGHT -		SIZE A1 CASE CODE 00779 DRAWING NO. C=2151579	
MATERIAL -		FINISH -		RESTRICTED TO - Customer Accessible Production Drawing	
				SCALE 1:2 SHEET 2 of 4 REV D	

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
2-2151579-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2151579-2	D	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151579-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	3.05 mm [.120]	F
INSUL	3.98 mm [.157]	O
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: POWER QUADLOK CONTACT			
WIRE STRIP LENGTH 5.20-5.80 mm [.205-.228 IN]			INSULATION DIAMETER RANGE Ø3.40-3.70 mm [.134-.146 IN]
TERMINAL APPLICATION SPECIFICATION		114-18141-1	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
968073-2	968132-2	1241602-2	1241615-2

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING
4.00mm2		2.34+/-0.05 [.092+/- .002]		8.8



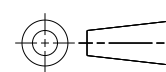
- 1 RECOMMENDED SPARE PARTS
- 2 REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- 3 APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242.
- 4 CRIMP HEIGHT REFERENCE SETTING WAS THE SETTING USED WHEN THE APPLICATOR WAS QUALIFIED AT THE FACTORY. ADJUSTMENT MAY BE NECESSARY WHEN RUNNING APPLICATOR IN THE FIELD.
- 5 ITEM 34 TO BE USED FOR TERMINAL PN 968073-2 AND 968132-2.
- 6 ITEM 261 TO BE USED FOR TERMINAL PN 1241602-2 AND 1241615-2.
- 7 CUT TO LENGTH AT ASSEMBLY.
8. 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)

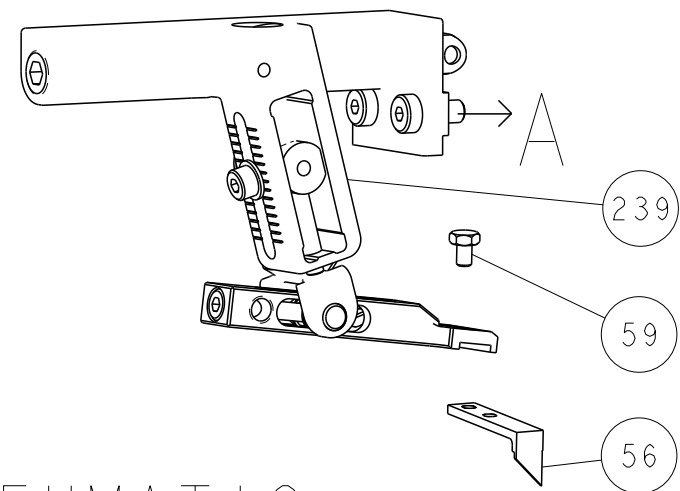
LOC	DIST	REVISIONS				
		P	LTR	DESCRIPTION	DATE	OWN
A	66	-	-	SEE SHEET 1	-	-

6	-	1	1	1752356-6	SUPPORT, TERMINAL	261
	-	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
	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	455888-5	SPACER, CRIMPER	82
	-	1	1	1803607-3	DOCUMENTATION PACKAGE	71
	-	1	1	2119791-5	DEPRESSOR, WIRE	70
	-	1	1	2119943-1	WASHER, SPACER	69
	-	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
7	-	2	2	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	53
	-	1	1	5018030-1	NUT, HEX, REG, RoHS, M3	52
	-	1	1	811242-5	BUMPER, HOLD DOWN	51
	-	1	1	690753-2	SPACER, TONKER	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
5	-	1	1	1752356-1	SUPPORT, TERMINAL	34
	-	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
	-	2	2	3-2844962-2	SPACER, CYLINDRICAL, STRIP GUIDE	30
	-	1	1	2844992-2	ASSEMBLY, STRIP GUIDE	29
	-	1	1	455888-4	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	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	1	1333208-8	ANVIL, COMBINATION .120	8
	-	1	1	2-240641-4	SPACER	7
	-	-	-	-	-	6
	-	1	1	1-2119757-0	DEPRESSOR, SHEAR	5
	-	1	1	238011-1	BLOCK, CRIMPER SPACER	4
	1	1	1	2-2119784-6	CRIMPER, INSULATION O PREMIUM	3
	-	1	1	455888-4	SPACER, CRIMPER	2
	1	1	1	2-456409-8	CRIMPER, WIRE .120 "F" PREMIUM	1

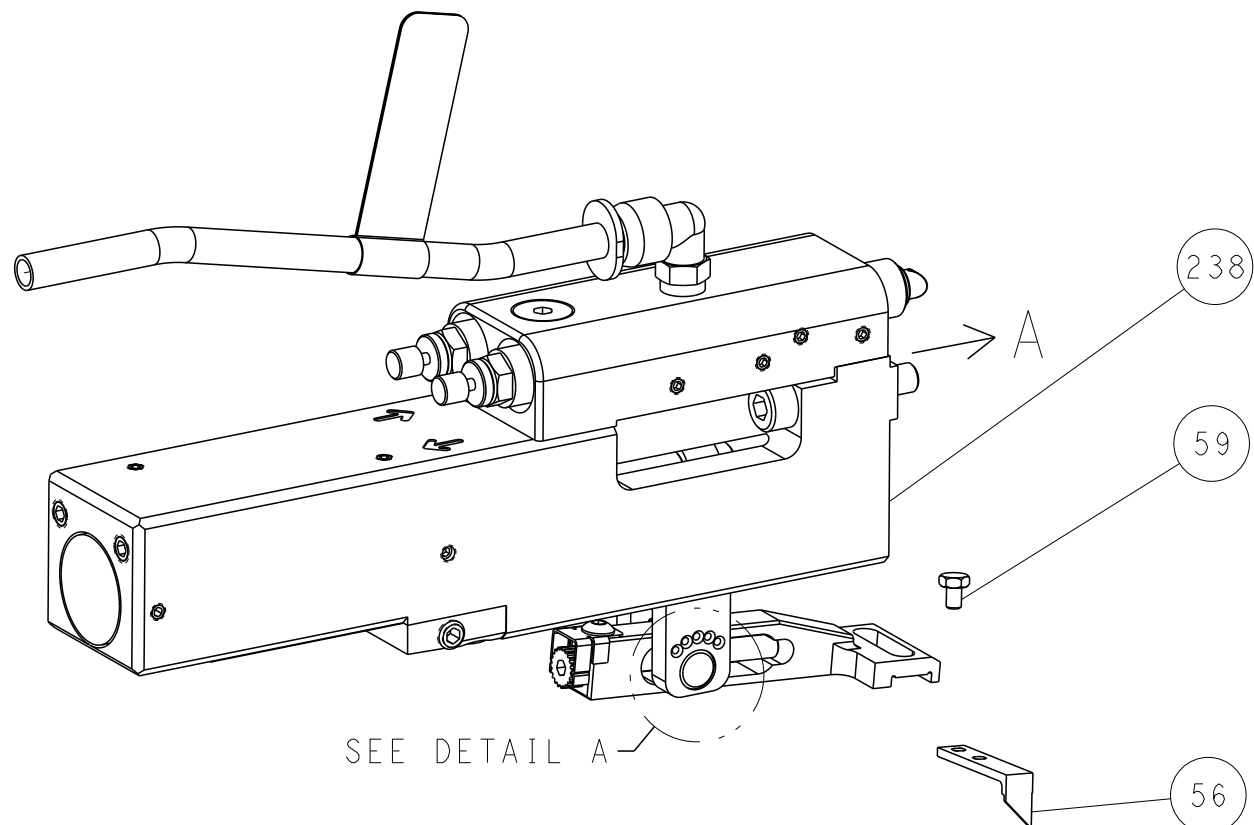
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				CHK L. ZHANG 12JUN2012			
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		APVD S. XI 12JUN2012		NAME	
mm				PRODUCT SPEC		Ocean Side Feed Applicator	
		0 PLC ±		-			
		1 PLC ±		-			
		2 PLC ±		-		APPLICATION SPEC	
		3 PLC ±		-			
		4 PLC ±		-		SIZE CAGE CODE DRAWING NO RESTRICTED TO	
		ANGLES ±		-			
MATERIAL		FINISH		WEIGHT		A 00779 C=2151579 -	
						Customer Accessible Production Drawing SCALE 1:2 SHEET 3 OF 4 REV D	

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

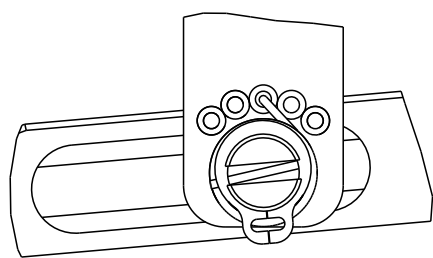
FEED TYPE MECHANICAL



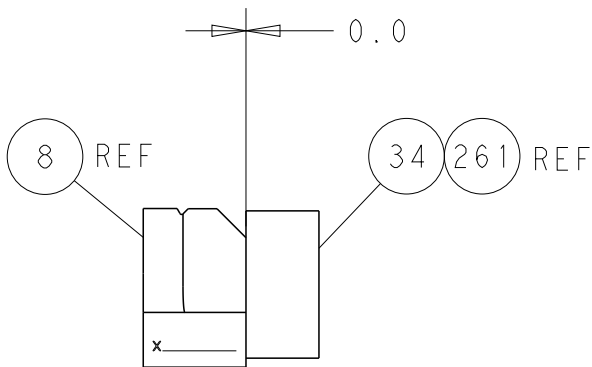
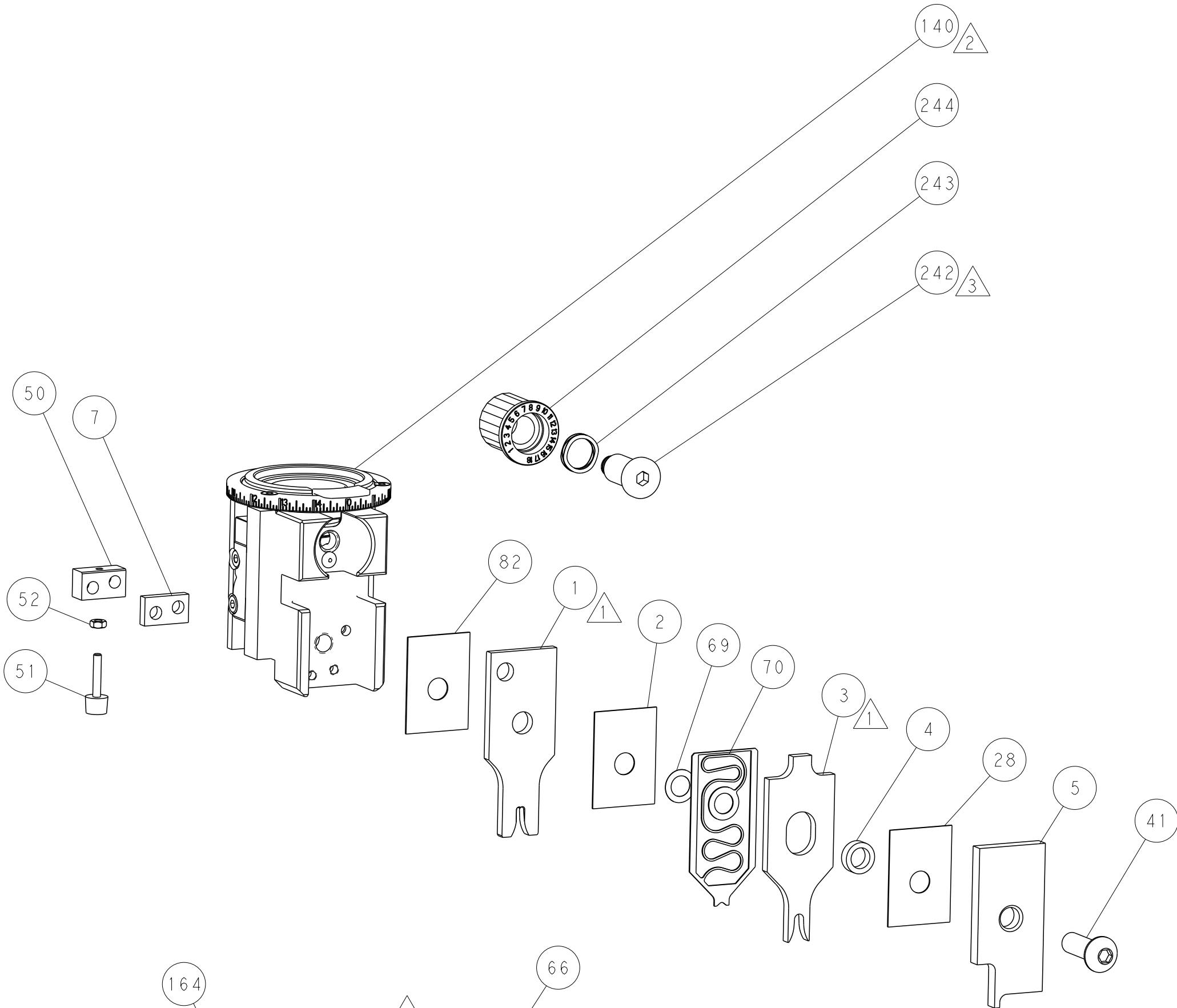
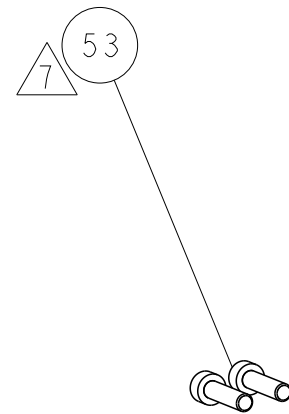
PNEUMATIC



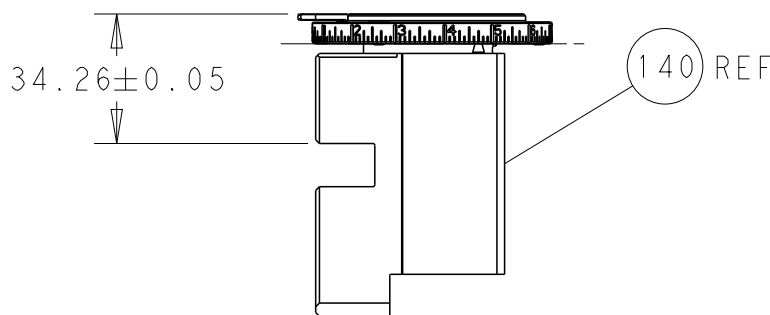
FEED SPRING SETTING POSITION
(SHOWN FROM REAR SIDE)



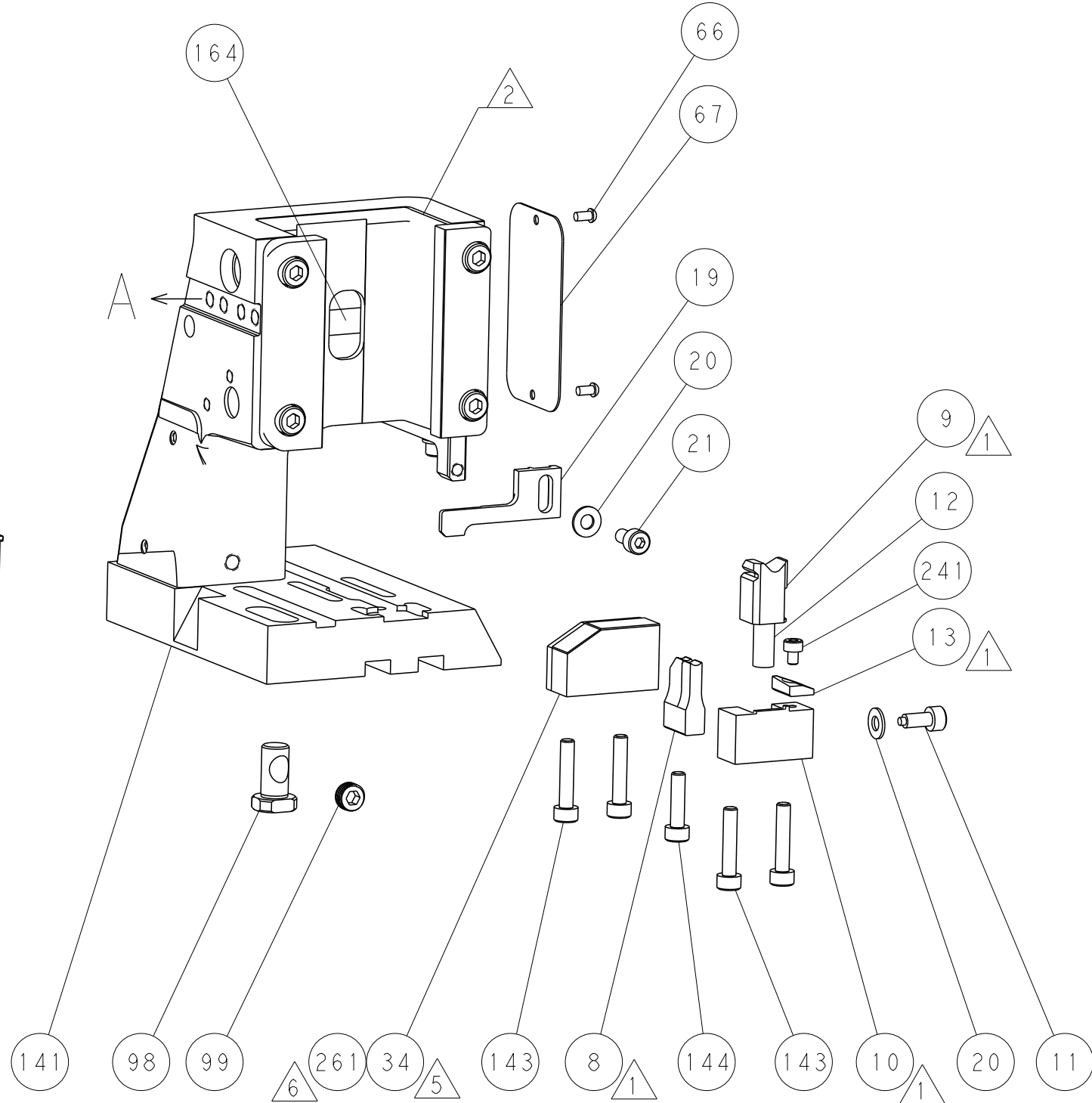
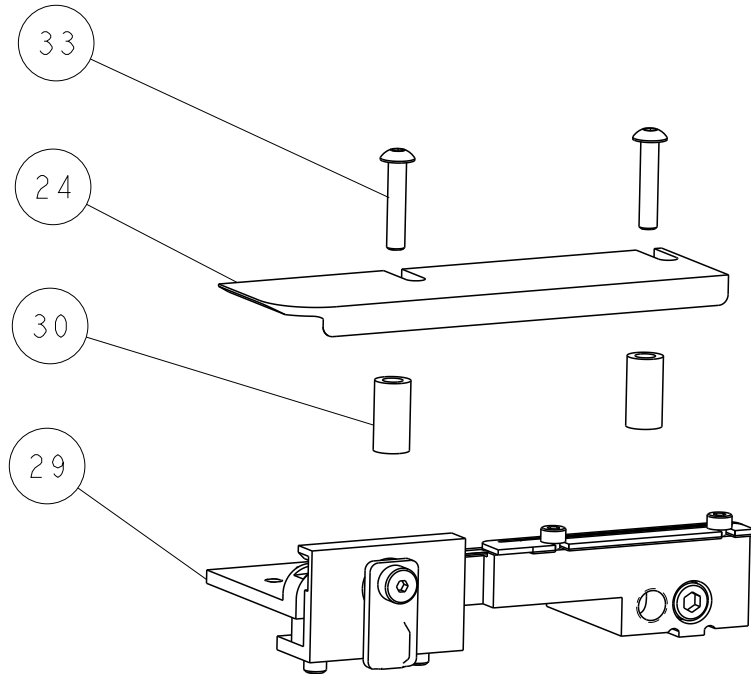
DETAIL A



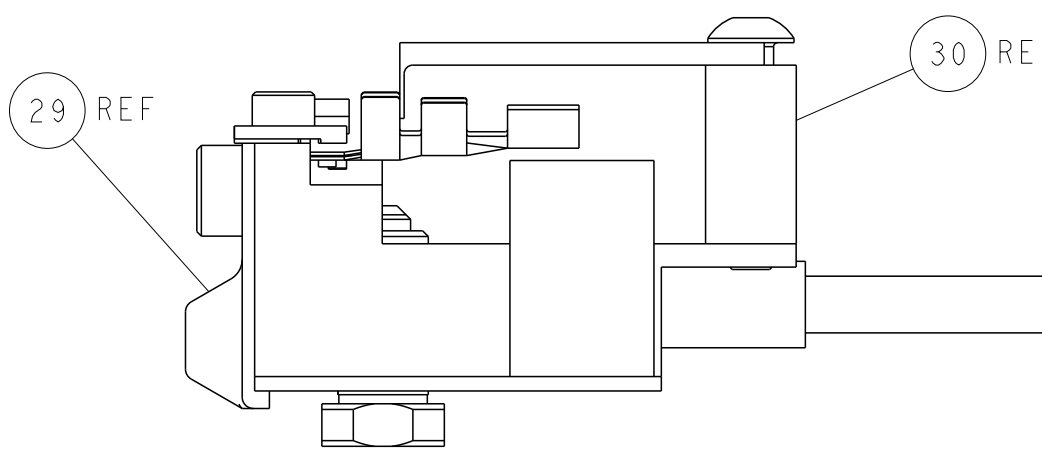
TERMINAL SUPPORT LOCATION



RAM SET-UP

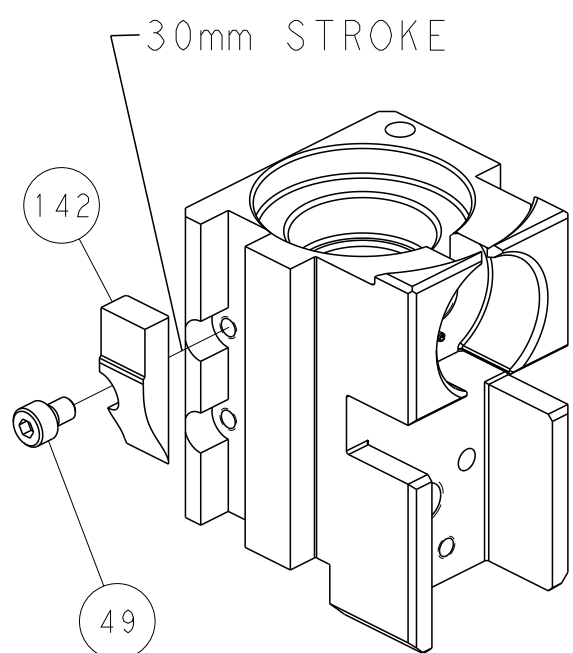


ITEM 30 LOCATED AT
REAR HOLES

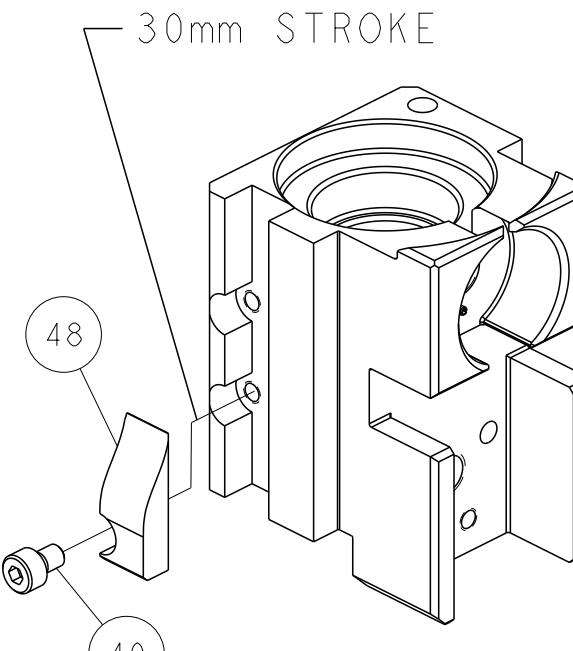


FEED TRACK POSITION
GUIDE BY INSULATION BARREL

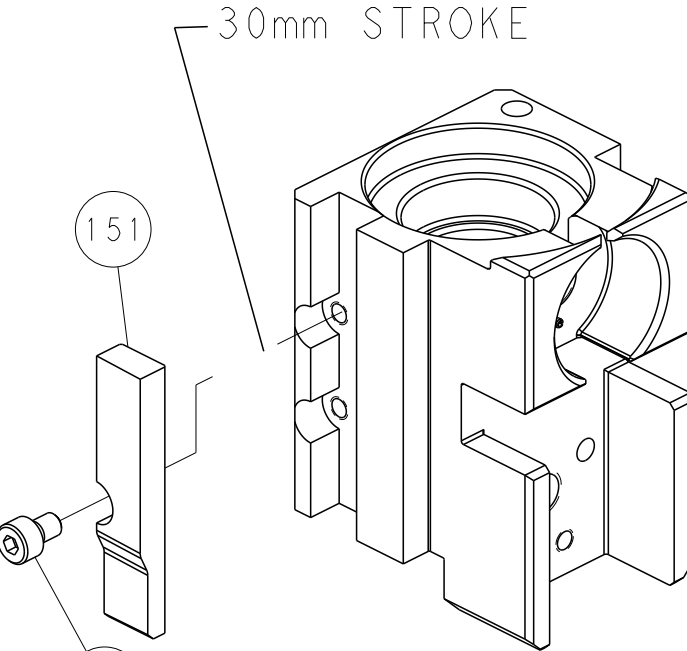
CAM POSITIONS



MECHANICAL
POST FEED



MECHANICAL
PRE FEED



AIR FEED

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 L. ZHANG 12JUN2012	TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm		CHK L. ZHANG 12JUN2012	NAME Ocean Side Feed Applicator	
TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH		APVD S. XI 12JUN2012	PRODUCT SPEC APPLICATION SPEC	
MATERIAL -		WEIGHT -	SIZE A1	
			CAGE CODE 00779	
			DRAWING NO C=2151579	
			RESTRICTED TO -	
			Customer Accessible Production Drawing	
			SCALE 1:2	
			SHEET 4	
			OF 4	
			REV D	

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION