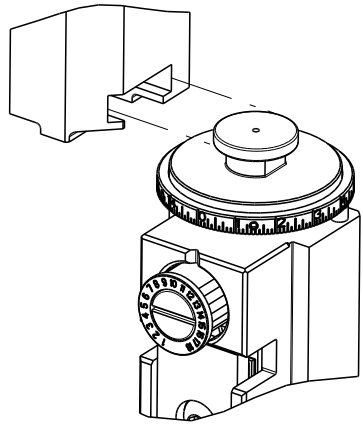


8		7	
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20		20	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151832-1	E	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2151832-2	E	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
3-2151832-2	E	FINE CRIMP HEIGHT ADJUST	DOUBLE ACTING PNEUMATIC WITH SENSORS
7-2151832-1	E	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2151832-2	E	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
4.00-4.50 mm [.157-.177 IN]			Ø0.85-1.05 mm [.033-.041 IN]
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	CRIMP HEIGHT
2x0.13 OR 2X26 AWG	mm [INCH]	REFERENCE SETTING
	0.84+/-0.02 [.033+/-0.001]	8.8



- 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.
- THIS APPLICATOR HAS BEEN DESIGNED TO APPLY WIRES WITH THIN WALL (FLR) INSULATION.
- THIS APPLICATOR EQUIPED WITH THE DOUBLE ACTING PNEUMATIC FEED WITH SENSORS, AND IS APPLICATION SPECIFIC AND DOES NOT REQUIRE ITEMS 49 & 248.

*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
			D1	ECR-16-015428			7NOV2016	RS	LZ
			D2	ECR-17-012617			29AUG2017	RS	LZ
			D3	ECR-17-015902			27OCT2017	RS	LZ
			E	ECR-19-007945			17MAY2019	TB	TE

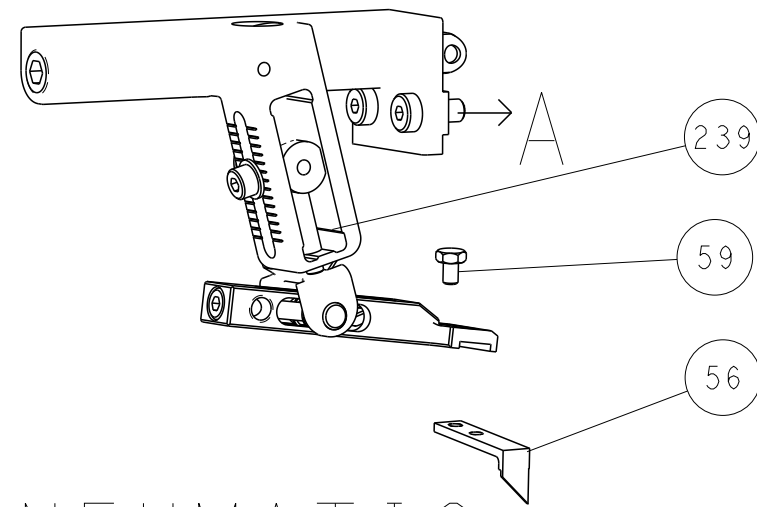
-	-	-	1	-	-	1803430-1	AIR FEED MODULE	290
-	1	-	-	1	-	2119640-1	PUSH ROD, AIR FEED	250
-	1	-	-	1	-	1803259-1	BUSHING, FLANGED	249
-	1	-	-	1	-	2119641-1	FEED CAM, AIR FEED	248
-	1	1	1	1	1	2119082-8	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	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	-	2063440-1	AIR FEED MODULE	238
-	2	-	2	2	-	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172
-	REF	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	1	-	1	1	-	240638-1	SPRING, FEED FINGER	163
-	1	-	1	1	-	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854	137
-	1	-	1	1	-	2119799-1	HOLDER,FEED FINGER, AF	136
-	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	1803607-1	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	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	2119757-8	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: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH ±		NAME Ocean Side Feed Applicator	
MATERIAL -		WEIGHT -		SIZE A1	
		Customer Accessible Production Drawing		SCALE 1:2	
		SHEET 1		OF 4	
		REV E			

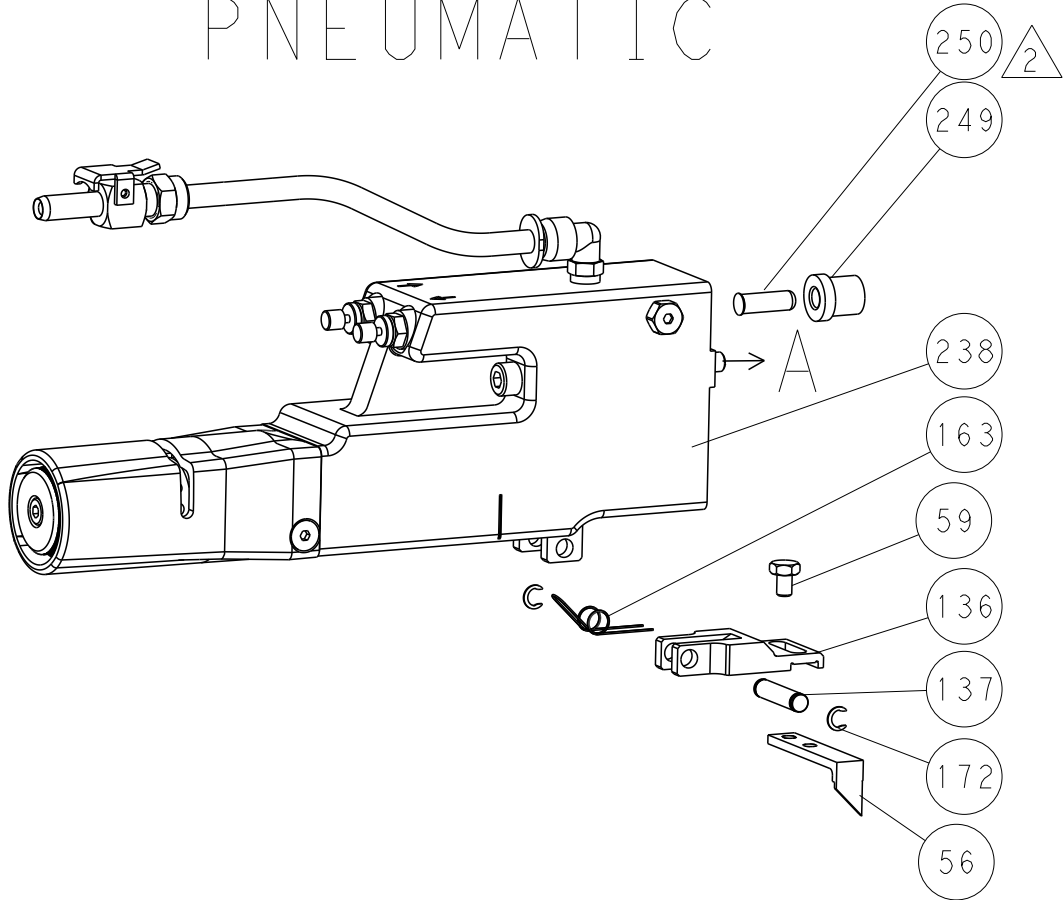
SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

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

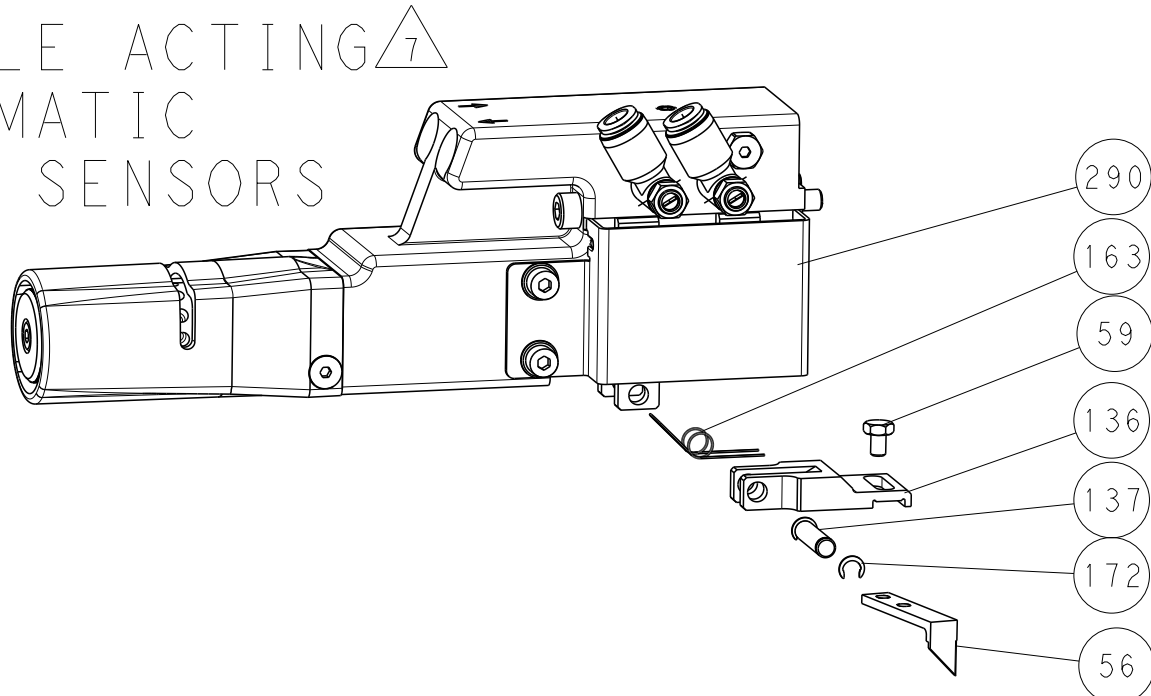
FEED TYPE
MECHANICAL



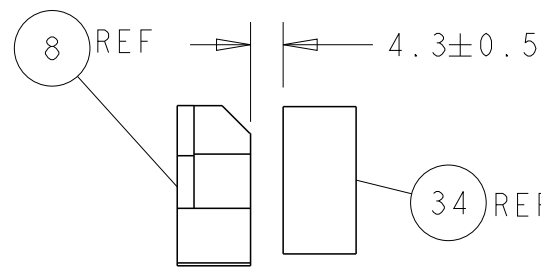
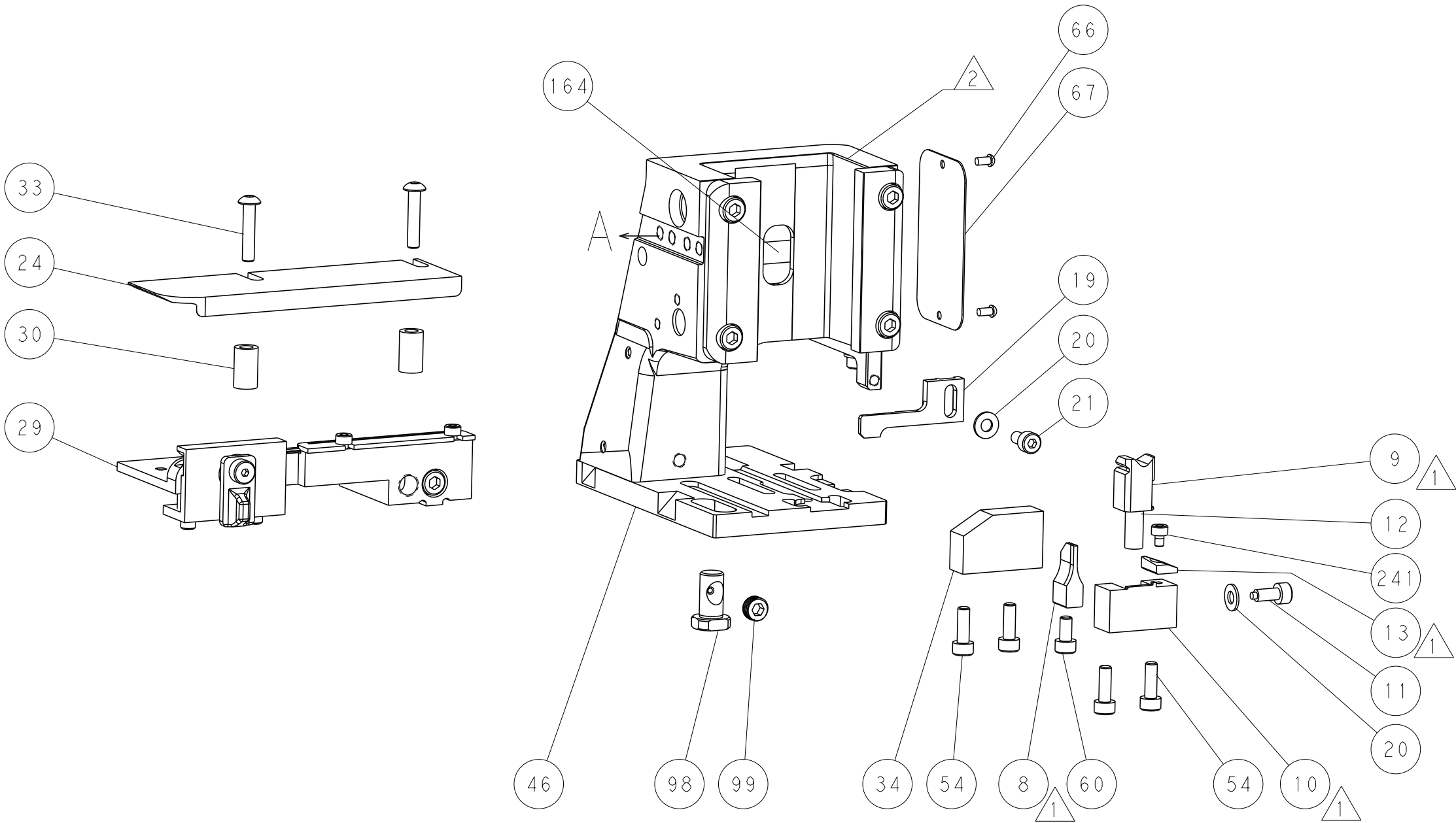
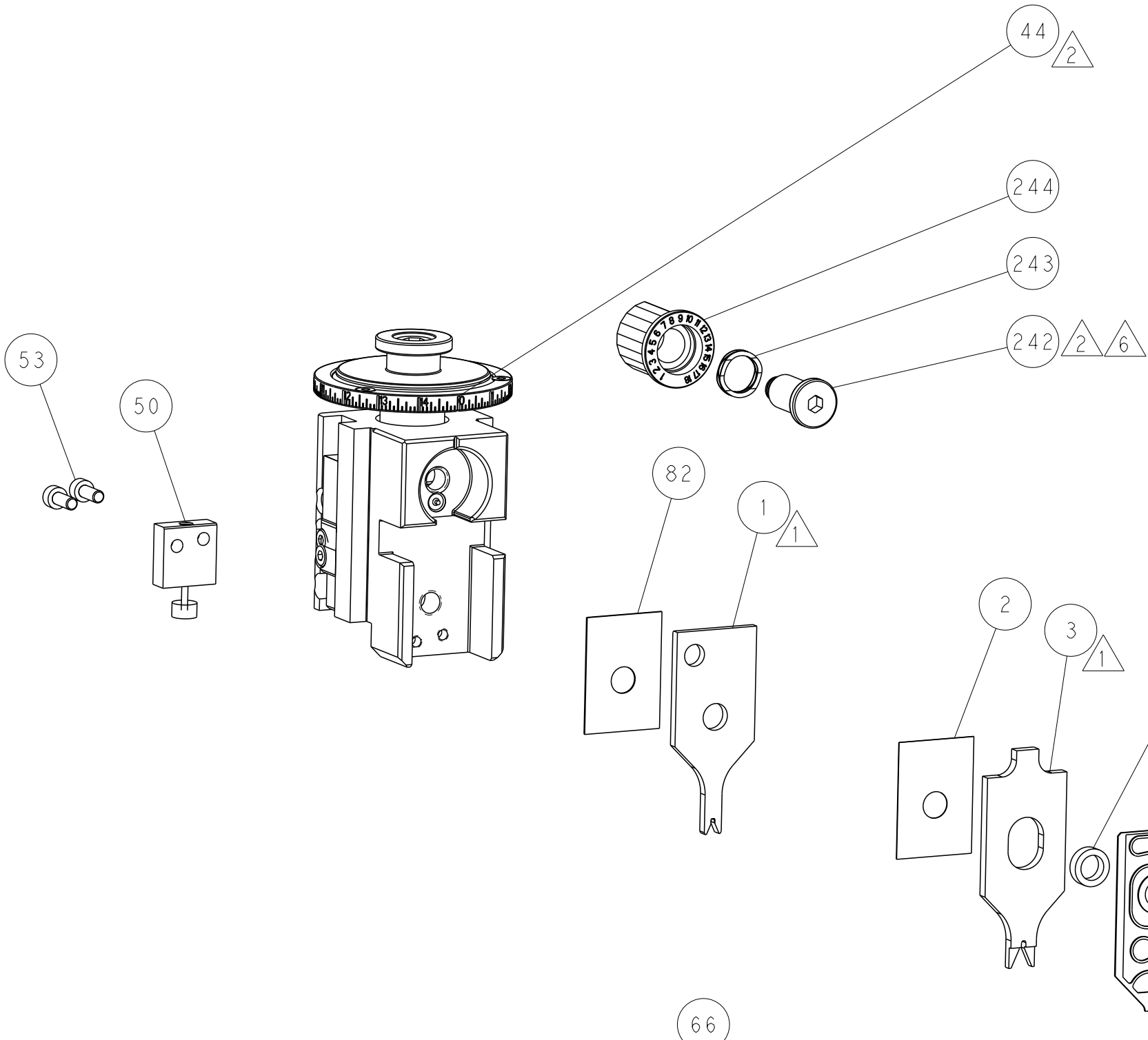
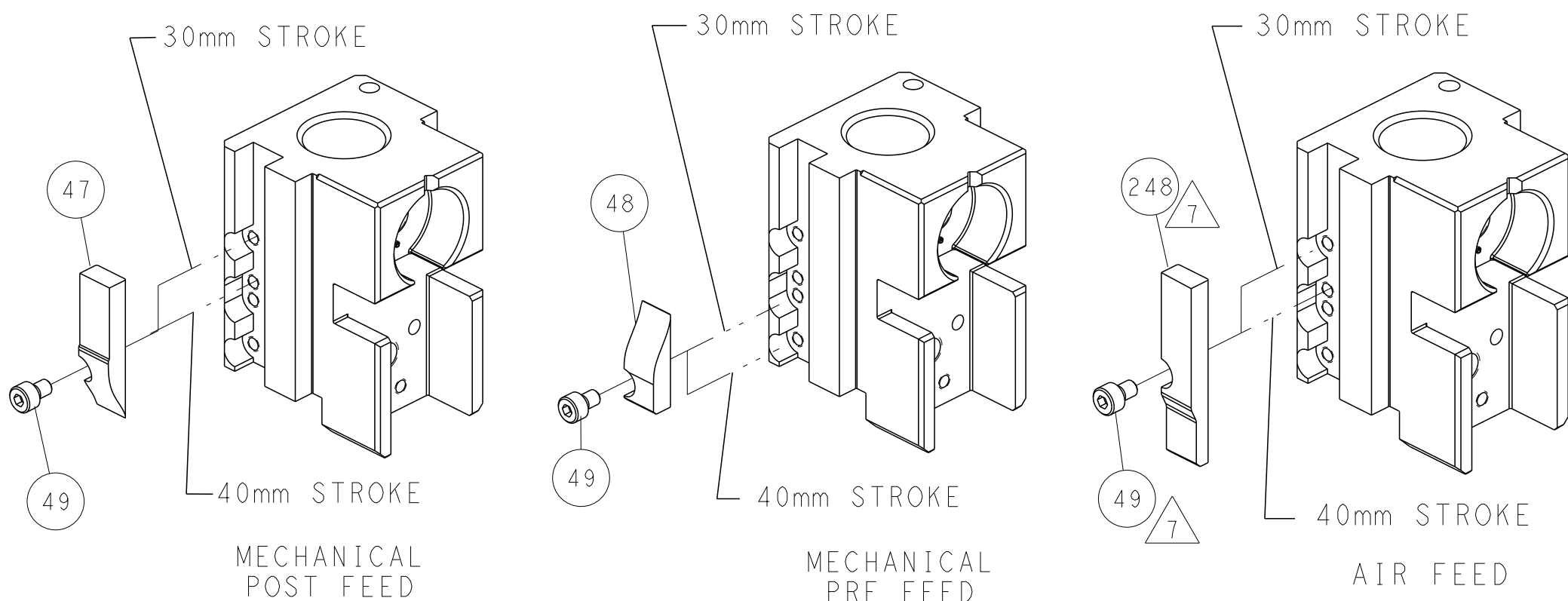
PNEUMATIC



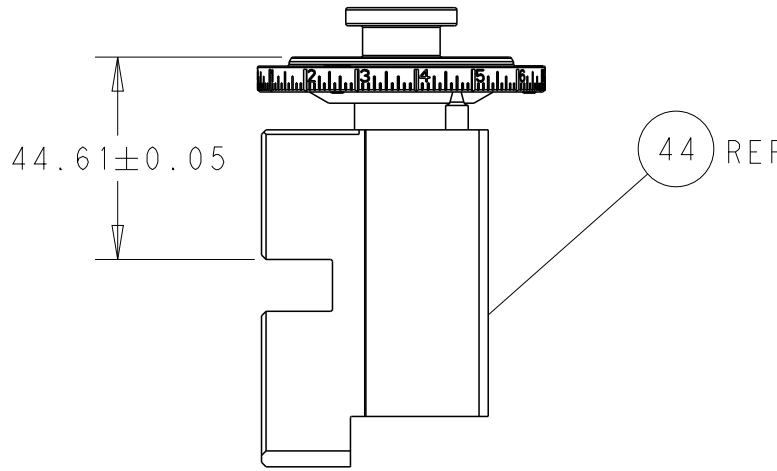
DOUBLE ACTING
PNEUMATIC
WITH SENSORS



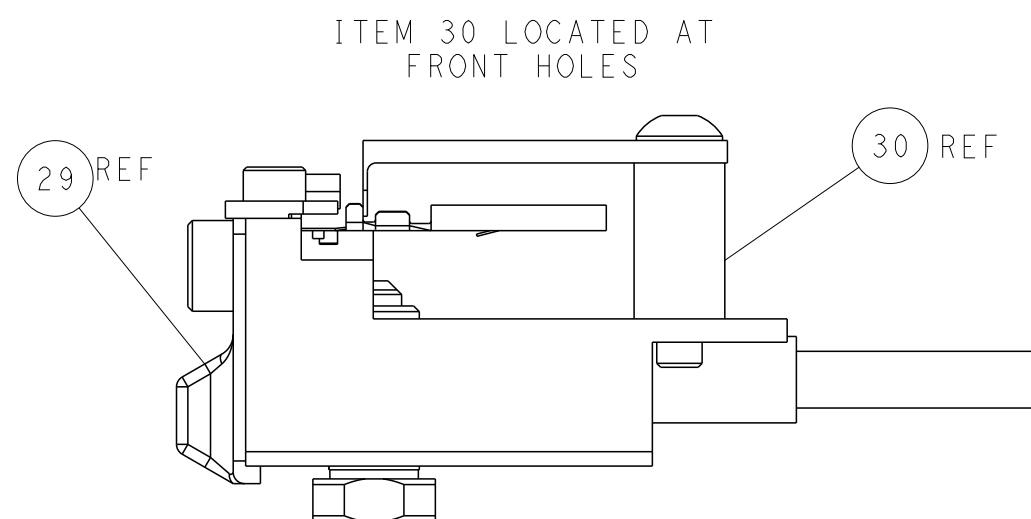
CAM POSITIONS



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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CHK L. ZHANG 26APR2010		NAME Ocean Side Feed Applicator	
APVD J. GUO 26APR2010		PRODUCT SPEC	
		APPLICATION SPEC	
		SIZE A1	CAGE CODE 00779
		DRAWING NO C=2151832	RESTRICTED TO -
		WEIGHT -	SCALE 1:2
		SHEET 2	OF 4
		REV E	

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

PACIFIC 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 4.00-4.50 mm [.157-.177 IN]			INSULATION DIAMETER RANGE Ø0.85-1.05 mm [.033-.041 IN]
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	



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 EQUIPED WITH THE DOUBLE ACTING PNEUMATIC FEED WITH SENSORS, AND IS APPLICATION SPECIFIC AND DOES NOT REQUIRE ITEMS 49 & 151.

*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.

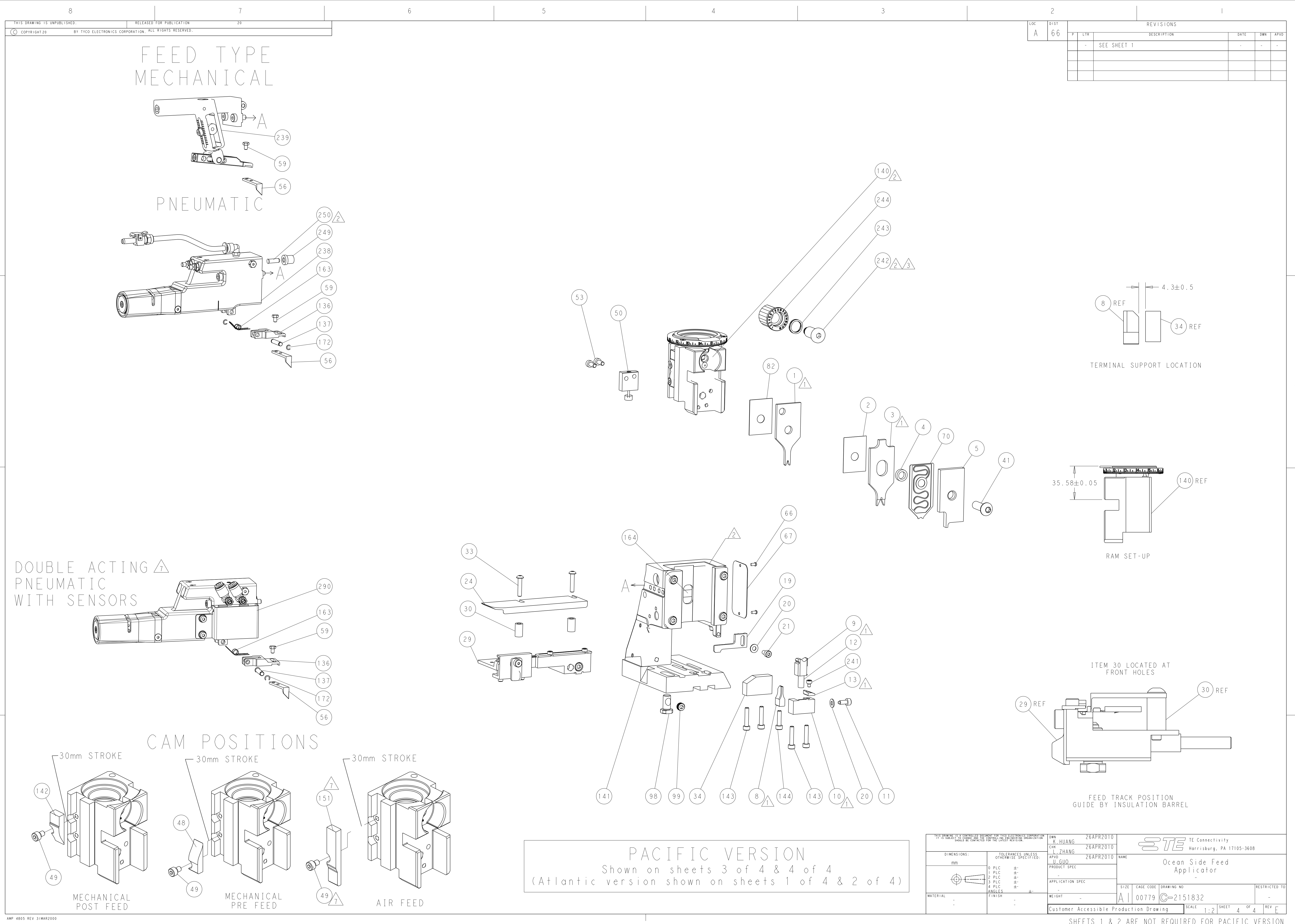
PACIFIC VERSION
Shown on sheets 3 of 4 & 4 of 4
(Atlantic version shown on sheets 1 of 4 & 2 of 4)

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

-	1	-	-	1803430-1	AIR FEED MODULE	290
-	-	1	-	2119640-1	PUSH ROD, AIR FEED	250
-	-	1	-	1803259-1	BUSHING, FLANGED	249
-	1	1	1	2119082-8	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	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	-	2063440-1	AIR FEED MODULE	238
-	2	2	-	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172
-	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	1	1	-	240638-1	SPRING, FEED FINGER	163
-	-	1	-	2119641-2	FEED CAM, AIR FEED	151
-	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	-	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854	137
-	1	1	-	2119799-1	HOLDER,FEED FINGER, AF	136
-	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	1803607-1	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	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	2119805-1	SHEAR HOLDER, FRONT	10
-	1	1	1	1803095-1	FLOATING SHEAR, FRONT -	9
-	1	1	1	1803058-6	ANVIL, COMBINATION	8
-	-	-	-	-	-	7
-	-	-	-	-	-	6
-	1	1	1	2119757-8	DEPRESSOR, SHEAR	5
-	1	1	1	3-238011-1	BLOCK, CRIMPER SPACER	4
-	1	1	1	1-1803019-1	CRIMPER, INSULATION O	3
-	1	1	1	455888-1	SPACER, CRIMPER	2
-	1	1	1	3-1633860-6	CRIMPER, WIRE	1

-77 -42 -22 -21				PART NO		DESCRIPTION				ITEM NO
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TOLERANCES UNLESS OTHERWISE SPECIFIED:				NAME		Ocean Side Feed Applicator				
0 PLC ±.001 1 PLC ±.001 2 PLC ±.001 3 PLC ±.001 4 PLC ±.001 ANGLES ±.001 FINISH -				PRODUCT SPEC APPLICATION SPEC		SIZE CAGE CODE DRAWING NO		RESTRICTED TO		
				WEIGHT -		A 1 00779 C=2151832				
Customer Accessible Production Drawing						SCALE 1:2		SHEET 3 OF 4		REV E

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION



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