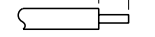


8	7	6	5	4	3	2	1
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE				
2151930-1	J	FINE CRIMP HEIGHT ADJUST	MECHANICAL				
2151930-2	J	FINE CRIMP HEIGHT ADJUST	PNEUMATIC				
5-2151930-1	J	SEAL STRIPPER CRIMPER TERMINATING UNIT	MECHANICAL				
5-2151930-2	J	SEAL STRIPPER CRIMPER TERMINATING UNIT	PNEUMATIC				
7-2151930-1	J	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL				
7-2151930-2	J	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC				
7-2151930-7	A	CRIMP TOOLING KIT	-				

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.35 mm [.053]	F
INSUL	1.40 mm [.055]	F
APPLICATOR INSTRUCTIONS 408-35042		

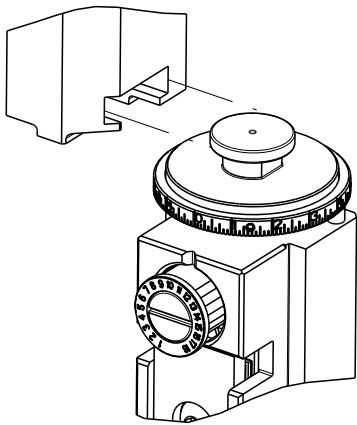
TERMINAL DATA: JST TERMINAL		JST CRIMP SPECIFICATION	
TERMINAL NAME: TERMINAL, TAB AND RECEPTACLE			
WIRE STRIP LENGTH 3.10-3.90 mm [.122-.154 IN]			INSULATION DIAMETER RANGE Ø1.40-1.70 mm [.055-.067 IN]
TERMINAL APPLICATION SPECIFICATION		H4009/017-00 Rev -	-
TERMINALS APPLIED 			
TE TERMINAL	JST TERMINAL	TE TERMINAL	JST TERMINAL
1949498-1	SWPT-001T-P025	1949499-1	SWPR-001T-P025
1949498-2	SWPT-001T-025	1949499-2	SWPR-001T-025

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
22 AWG	0.92+/-0.05 [.036+/- .002]	8.2
24 AWG	0.85+/-0.05 [.033+/- .002]	8.9
26 AWG	0.80+/-0.05 [.031+/- .002]	9.7



- 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. APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 180.
- 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 LUBRICANT IS RECOMMENDED.
6. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- 7 USE ITEM 34 FOR TERMINAL PN 1949498-1, USE ITEM 272 FOR TERMINAL PN 1949499-1.

ATLANTIC VERSION TERMINATOR
INTERFACE ADAPTER



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

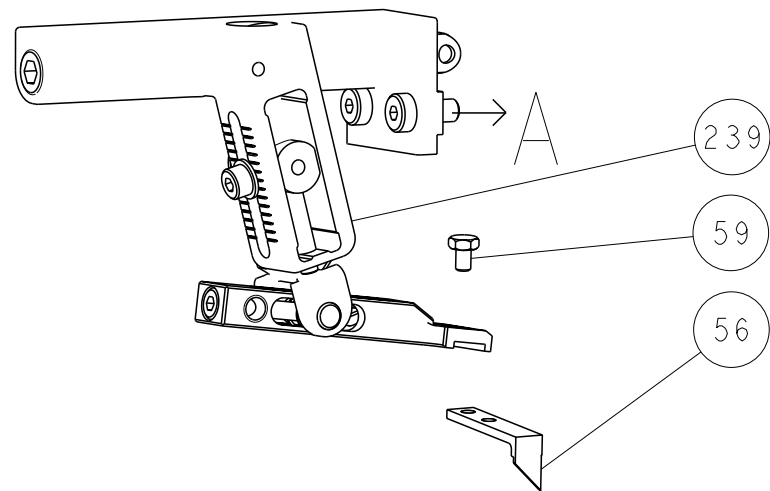
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						APVD
		G		ECR-18-003082	28FEB2018	JAH
		H		ECR-18-012706	09AUG2018	TB
		J		ECR-18-013557	25AUG2018	TB
		J1		ECR-19-016776	29OCT2019	FJ

-	-	-	1	1	-	-	1803515-3	RAM ASSEMBLY, SF ATLANTIC	293
-	-	-	1	1	-	-	2-1803583-1	APPLICATOR BASIC ASSEMBLY, SF	292
-	1	1	1	1	1	1	1752356-1	SUPPORT, TERMINAL	272
-	1	-	1	-	1	-	2119640-1	PUSH ROD, AIR FEED	250
-	1	-	1	-	1	-	1803259-1	BUSHING, FLANGED	249
-	1	-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248
-	1	1	1	1	1	1	2119082-8	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	1	1	1	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
-	-	1	-	1	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	1	-	1	-	1	-	2063440-1	AIR FEED MODULE	238
-	-	-	1	1	-	-	4-1722335-3	STRIPPER, SIDE FEED	182
-	-	-	1	1	-	-	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	181
-	-	-	1	1	-	-	1-1752354-7	STANDOFF, HOLD-DOWN	180
-	-	-	1	1	-	-	9931111-1	PIN, SLOTTED SPRING 3.0 X 20.0	177
-	-	-	1	1	-	-	5-22280-0	SPRING, COMPRESSION	176
-	-	-	1	1	-	-	1752353-3	GUIDE PIN,HOLDDOWN	175
-	-	-	1	1	-	-	1901680-2	GUIDE PIN,HOLDDOWN	174
-	2	-	2	-	2	-	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172
-	REF	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	1	1-18028-2	WASHER, FLAT, REG M4	119
-	1	1	1	1	1	1	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113
-	1	1	1	1	1	1	2844908-1	SCREW, LOCKING	99
-	1	1	1	1	1	1	2844907-1	POST, LOCKING	98
-	1	1	1	1	1	1	455888-5	SPACER, CRIMPER	82
-	1	1	1	1	1	1	1803607-1	DOCUMENTATION PACKAGE	71
-	1	1	1	1	1	1	2119791-5	DEPRESSOR, WIRE	70
-	1	1	1	1	1	1	2119740-1	TAG,IDENTIFICATION	67
-	2	2	2	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	1	1	1	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	60
-	1	1	1	1	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	1	1	1	1	1	1	1338685-1	PAWL, FEED	56
-	4	4	4	4	4	4	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	54
-	2	2	2	2	2	2	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	53
-	1	1	1	1	1	1	1803382-1	HOLD DOWN, SPRING LOADED	50
-	1	2	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	-	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	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
-	1	1	1	1	1	1	1752356-2	SUPPORT, TERMINAL	34
-	2	2	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	2	2	2	2	2-2844962-6	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	1	1	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29
-	1	1	1	1	1	1	1-455888-3	SPACER, CRIMPER	28
-	1	1	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	1	1	2	2	1-18028-2	WASHER, FLAT, REG M4	20
-	1	1	-	-	1	1	2119533-1	STRIPPER, SIDE FEED	19
-	1	1	1	1	1	1	2119806-1	INSERT, SHEAR	13
-	1	1	1	1	1	1	3-22280-3	SPRING, COMPRESSION	12
-	1	1	1	1	1	1	1-356885-3	STOP, SHEAR	11
-	1	1	1	1	1	1	2119805-1	SHEAR HOLDER, FRONT	10
-	1	1	1	1	1	1	1633861-4	SHEAR, FLOATING	9
1	2	2	1	1	1	1	2-1633932-6	ANVIL, COMBINATION	8
-	1	1	1	1	1	1	6-240641-3	SPACER	7
-	-	-	-	-	-	-	-	-	6
-	1	1	1	1	1	1	2119757-4	DEPRESSOR, SHEAR	5
-	1	1	1	1	1	1	238011-4	BLOCK, CRIMPER SPACER	4
1	2	2	1	1	1	1	1-1803017-7	CRIMPER, INSULATION F	3
-	1	1	1	1	1	1	455888-4	SPACER, CRIMPER	2
1	2	2	1	1	1	1	3-1633713-6	CRIMPER, WIRE PREMIUM	1

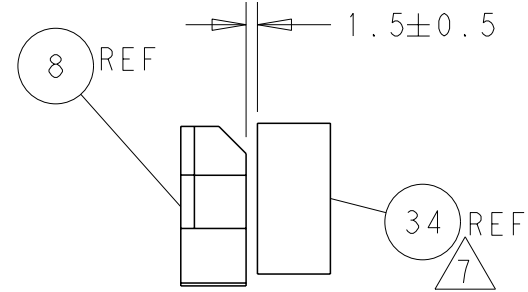
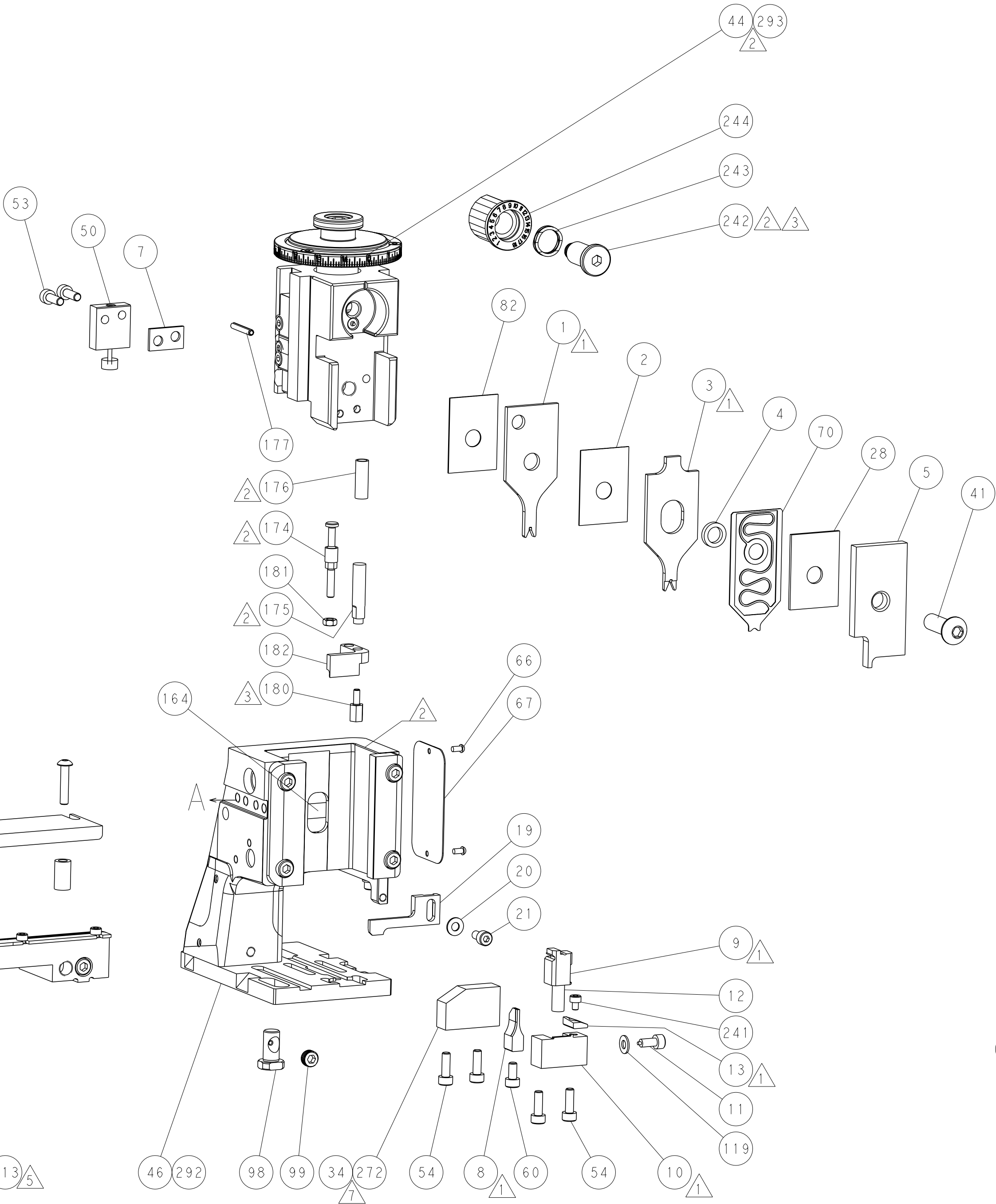
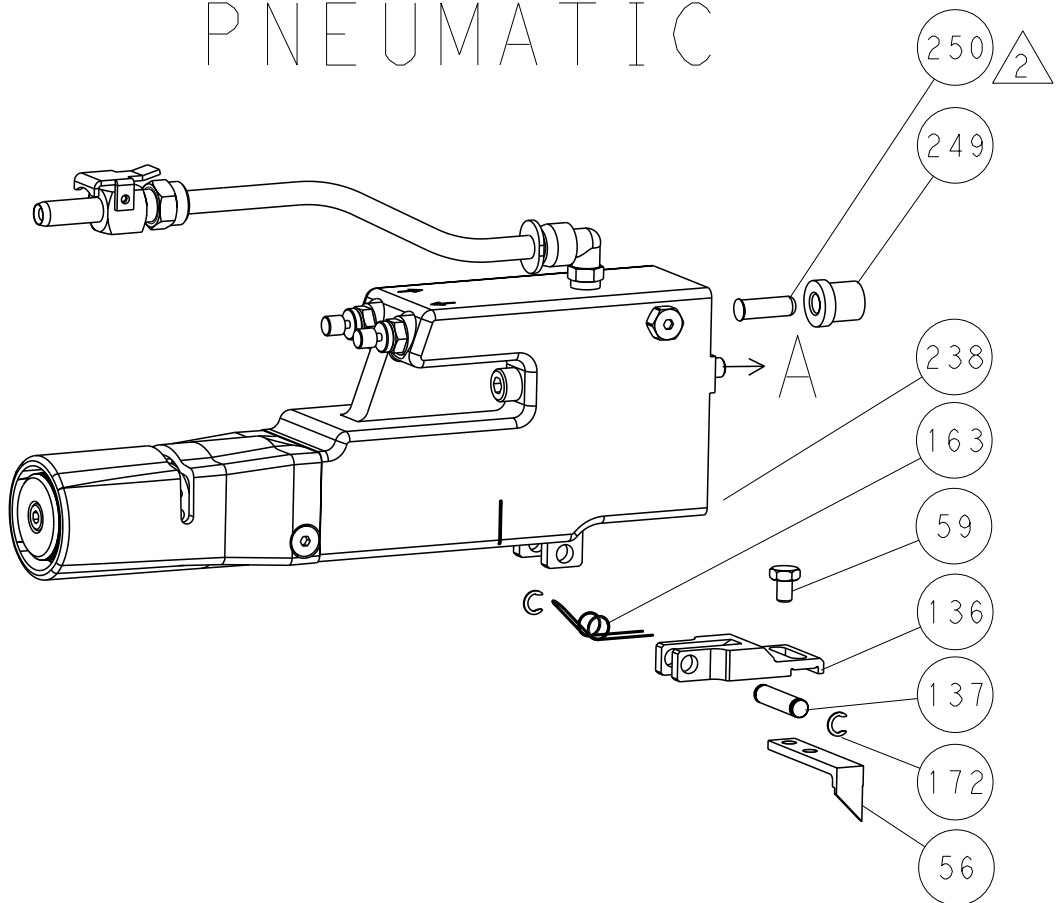
-77-72-71-52-51-2-1			PART NO		DESCRIPTION			ITEM NO				
101 IS DRAWING IS A CONTROLLED DOCUMENT FOR THE QUALITY CONTROL ORGANIZATION. ANY CHANGES TO THE DRAWING SHOULD BE CONTACTED FOR THE LATEST REVISION.												
DIMENSIONS: mm 			DWN R. O. WILSON 15APR2013		 TE Connectivity Harrisburg, PA 17105-3608							
			CHK K. J. STAKEM 19APR2013									
			APVD T. L. ELBIN 19APR2013									
			NAME									
			PRODUCT SPEC									
			APPLICATION SPEC		Ocean Side Feed Applicator -							
MATERIAL			FINISH		SIZE		CAGE CODE		DRAWING NO		RESTRICTED TO	
					A1		00779		C=2151930			

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

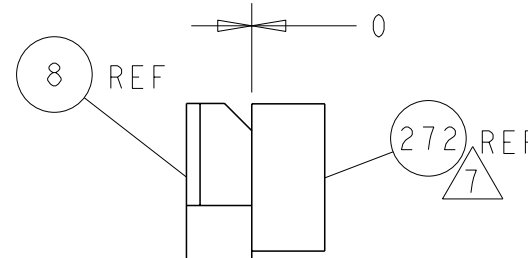
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MECHANICAL



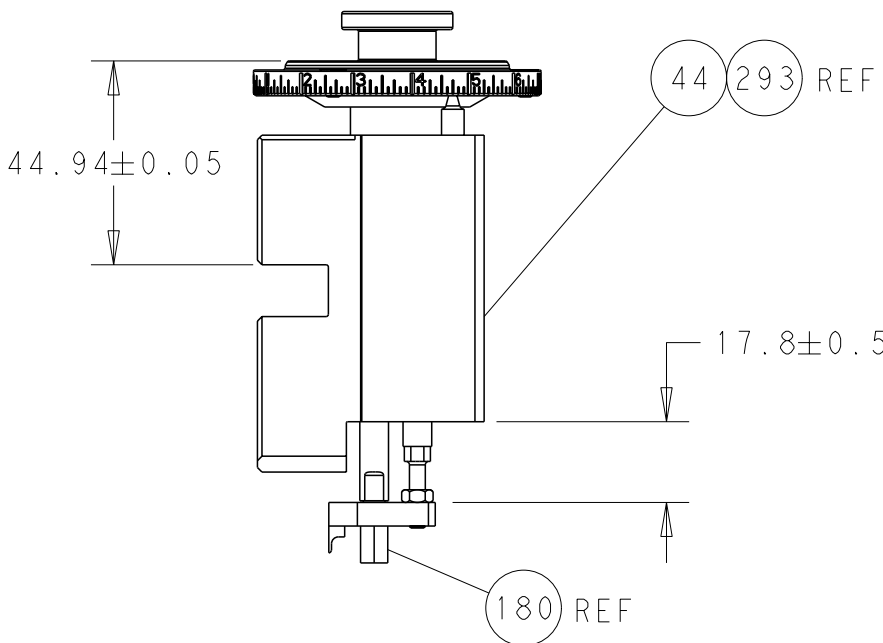
PNEUMATIC



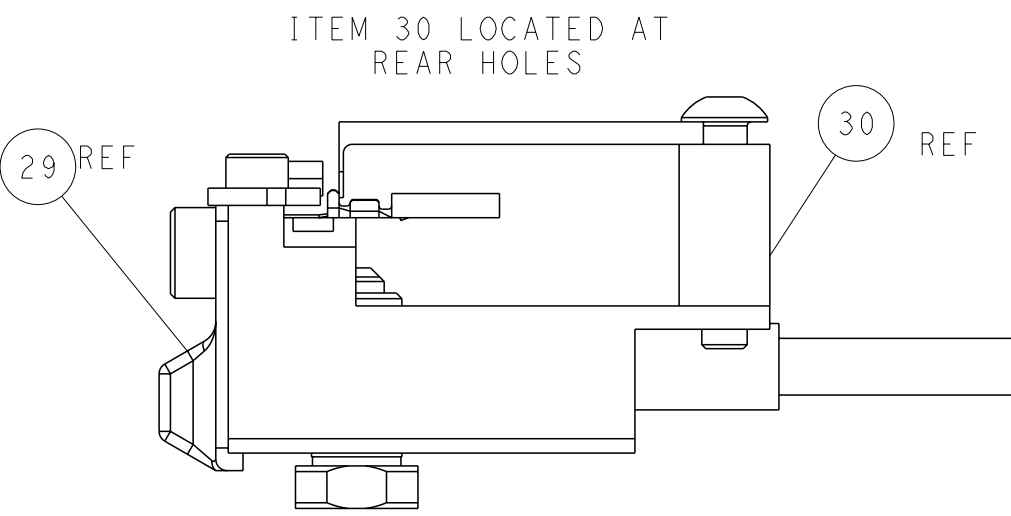
TERMINAL SUPPORT LOCATION
FOR TERMINAL PN 1949498-1



TERMINAL SUPPORT LOCATION
FOR TERMINAL PN 1949499-1

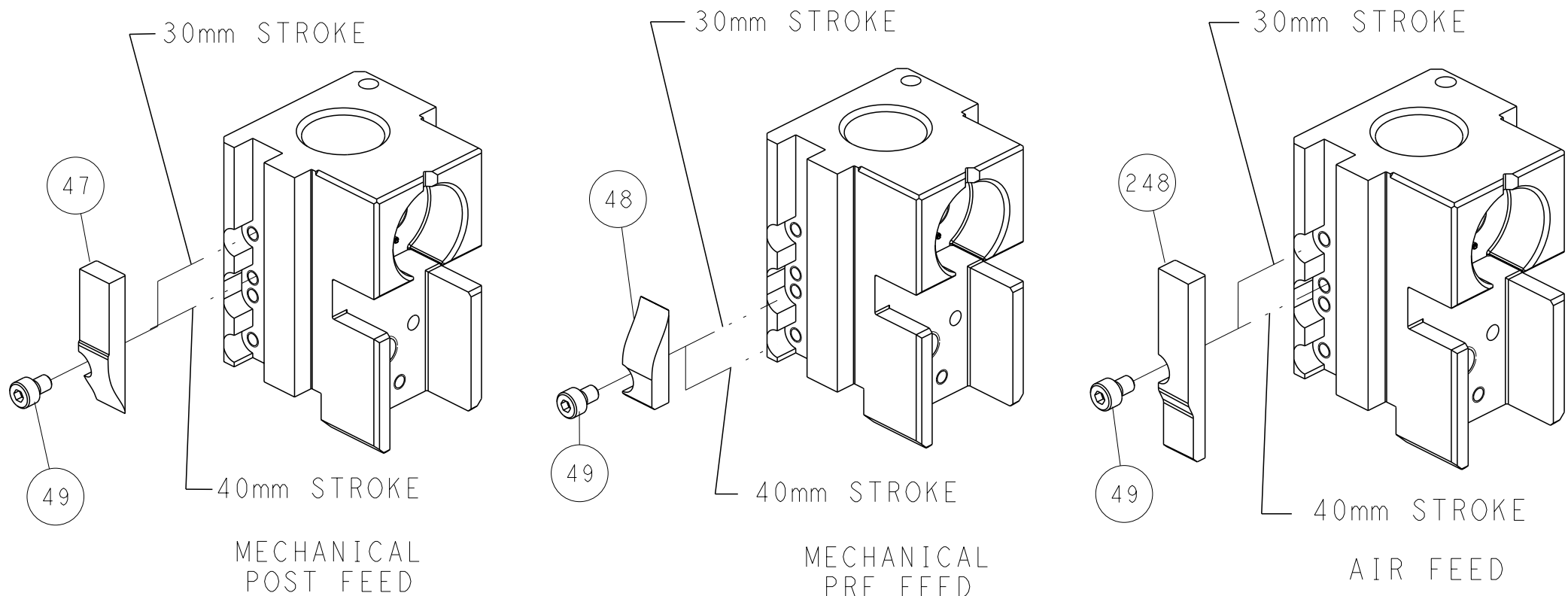


RAM SET-UP



FEED TRACK POSITION
GUIDE BY INSULATION BARREL

CAM POSITIONS

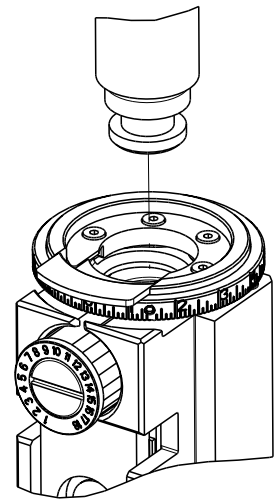


ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN		15APR2013		R. O. WILSON	
mm		0 PLC ±		CHK		19APR2013		K. J. STAKEM	
		1 PLC ±		APVD		19APR2013		T. L. ELBIN	
		2 PLC ±		PRODUCT SPEC					
		3 PLC ±		APPLICATION SPEC					
		4 PLC ±		WEIGHT					
		ANGLES		SCALE		1:2			
		FINISH		SHEET		2			
				OF		4			
				REV		J1			

8		7	
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20		20	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2151930-1	J	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2151930-2	J	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151930-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.35 mm [.053]	F
INSUL	1.40 mm [.055]	F
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: JST TERMINAL		JST CRIMP SPECIFICATION	
TERMINAL NAME: TERMINAL, TAB AND RECEPTACLE			
WIRE STRIP LENGTH 3.10-3.90 mm [.122-.154 IN]		INSULATION DIAMETER RANGE Ø1.40-1.70 mm [.055-.067 IN]	
TERMINAL APPLICATION SPECIFICATION		H4009/017-00 Rev -	
TERMINALS APPLIED 5			
TE TERMINAL	JST TERMINAL	TE TERMINAL	JST TERMINAL
1949498-1	SWPT-001T-P025	1949499-1	SWPR-001T-P025
1949498-2	SWPT-001T-025	1949499-2	SWPR-001T-025

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING 4
22 AWG		0.92+/-0.05 [.036+/-0.002]		8.2
24 AWG		0.85+/-0.05 [.033+/-0.002]		8.9
26 AWG		0.80+/-0.05 [.031+/-0.002]		9.7

-
- 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.
- 3

TERMINAL LUBRICANT IS RECOMMENDED.
6. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- 1

USE ITEM 34 FOR TERMINAL PN 1949498-1, USE ITEM 272 FOR TERMINAL PN 1949499-1.

*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)

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

7	-	1	1	1752356-1	SUPPORT, TERMINAL	272
	-	1	-	2119640-1	PUSH ROD, AIR FEED	250
3	-	1	-	1803259-1	BUSHING, FLANGED	249
	-	1	1	2119082-8	CAM, SNAIL, INSULATION ADJUSTMENT	244
3	-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
	-	1	1	2119083-1	RETAINER, INSULATION DIAL	242
3	-	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
	-	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
3	-	1	-	2063440-1	AIR FEED MODULE	238
	-	2	-	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172
3	-	REF	REF	994970-2	COUNTER, MAGNETIC	164
	-	1	-	240638-1	SPRING, FEED FINGER	163
3	-	1	-	2119641-2	FEED CAM, AIR FEED	151
	-	1	1	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	144
3	-	4	4	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	143
	-	-	1	2119653-2	FEED CAM, POST FEED	142
3	-	1	1	1-1803583-0	APPLICATOR BASIC ASSEMBLY, SF	141
	-	1	1	1803516-1	RAM ASSEMBLY, SF PACIFIC	140
3	-	1	-	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854	137
	-	1	-	2119799-1	HOLDER,FEED FINGER, AF	136
3	-	1	1	1-18028-2	WASHER, FLAT, REG M4	119
	-	1	1	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113
3	-	1	1	2844908-1	SCREW, LOCKING	99
	-	1	1	2844907-1	POST, LOCKING	98
3	-	1	1	455888-5	SPACER, CRIMPER	82
	-	1	1	1803607-1	DOCUMENTATION PACKAGE	71
3	-	1	1	2119791-5	DEPRESSOR, WIRE	70
	-	1	1	2119740-1	TAG,IDENTIFICATION	67
3	-	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
3	-	1	1	1338685-1	PAWL, FEED	56
	-	2	2	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	53
3	-	1	1	1803382-1	HOLD DOWN, SPRING LOADED	50
	-	1	2	18023-9	SCR, SKT HD CAP M4 X 6.0	49
3	-	-	1	2119652-1	FEED CAM, PRE FEED	48
	-	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
7	-	1	1	1752356-2	SUPPORT, TERMINAL	34
	-	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
7	-	2	2	2-2844962-6	SPACER, CYLINDRICAL, STRIP GUIDE	30
	-	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29
7	-	1	1	1-455888-3	SPACER, CRIMPER	28
	-	1	1	1320928-2	STRIP GUIDE	24
7	-	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
	-	1	1	1-18028-2	WASHER, FLAT, REG M4	20
7	-	1	1	2119533-1	STRIPPER, SIDE FEED	19
	-	1	1	2119806-1	INSERT, SHEAR	13
7	-	1	1	3-22280-3	SPRING, COMPRESSION	12
	-	1	1	1-356885-3	STOP, SHEAR	11
7	-	1	1	2119805-1	SHEAR HOLDER, FRONT	10
	-	1	1	1633861-4	SHEAR, FLOATING	9
7	1	1	1	2-1633932-6	ANVIL, COMBINATION	8
	-	1	1	6-240641-3	SPACER	7
7	-	-	-	-	-	6
	-	1	1	2119757-4	DEPRESSOR, SHEAR	5
7	-	1	1	238011-4	BLOCK, CRIMPER SPACER	4
	1	1	1	1-1803017-7	CRIMPER, INSULATION F	3
7	-	1	1	455888-4	SPACER, CRIMPER	2
	1	1	1	3-1633713-6	CRIMPER, WIRE PREMIUM	1
-77 -22 -21		PART NO		DESCRIPTION		ITEM NO

THIS DRAWING IS CONTROLLED DOCUMENT FOR THE ELECTRONIC CORPORATION IT IS SUBJECT TO CHANGE AND TO BE CONTROLLED BY THE ENGINEERING ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST REVISION				DWN R. O. WILSON CHK K. J. STAKEM APVD T. L. ELBIN	15APR2013 19APR2013 19APR2013		
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		NAME			
		0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		PRODUCT SPEC			
MATERIAL		FINISH		APPLICATION SPEC			
-		-		-			
-		-		WEIGHT			
-		-		A1 00779 ©=2151930			
Customer Accessible Production Drawing				SCALE	1:2		
				SHEET	3		
				OF	4		
				REV	J1		

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

D

C

B

A

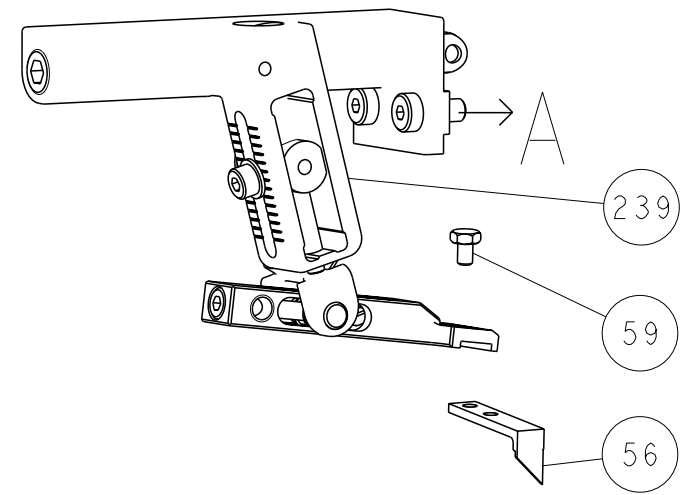
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C

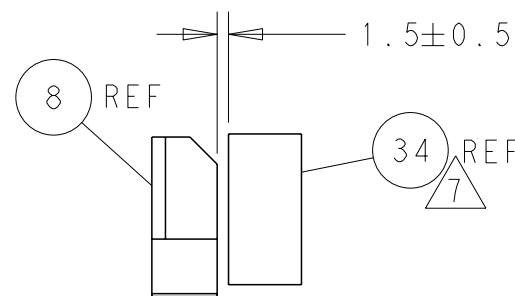
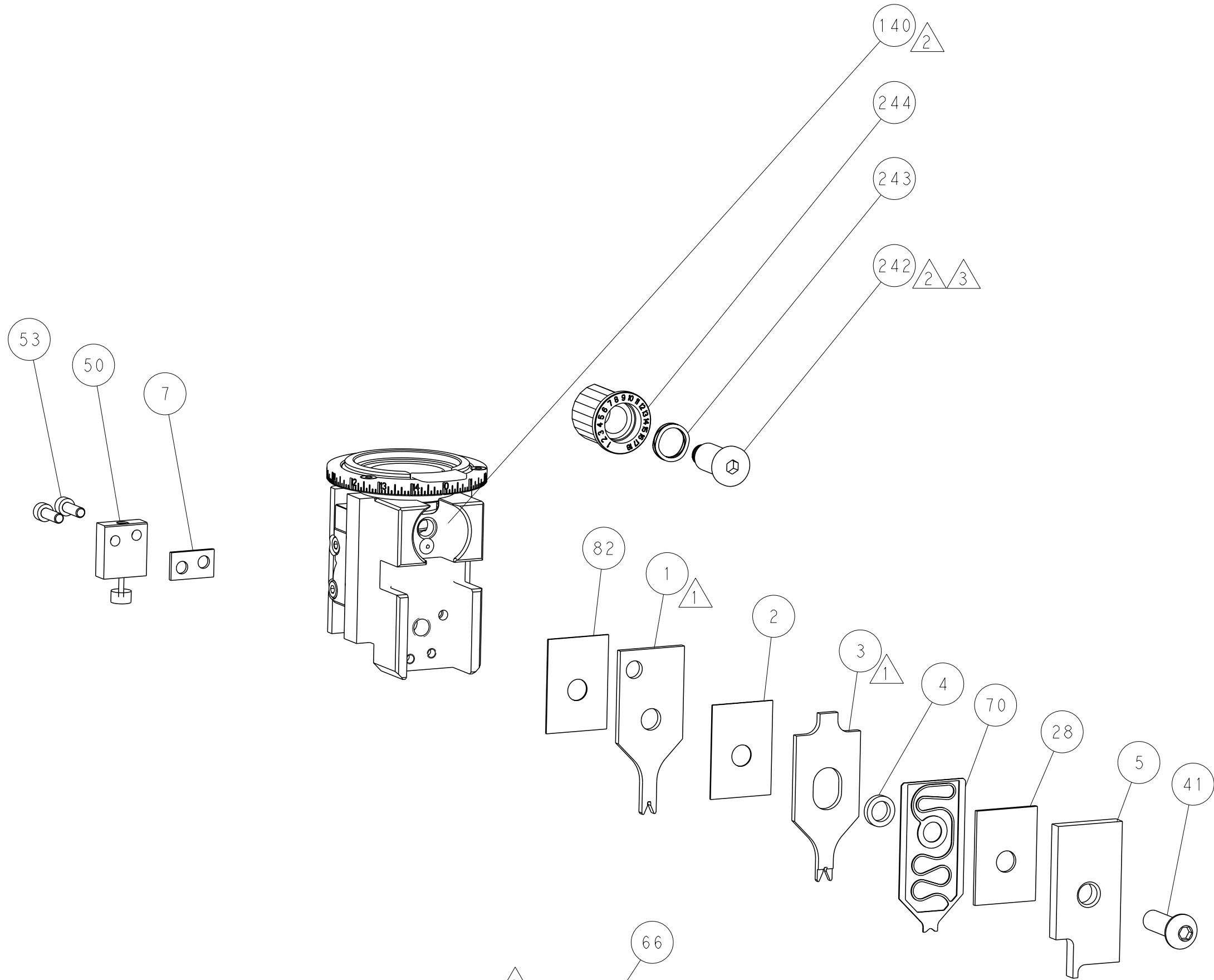
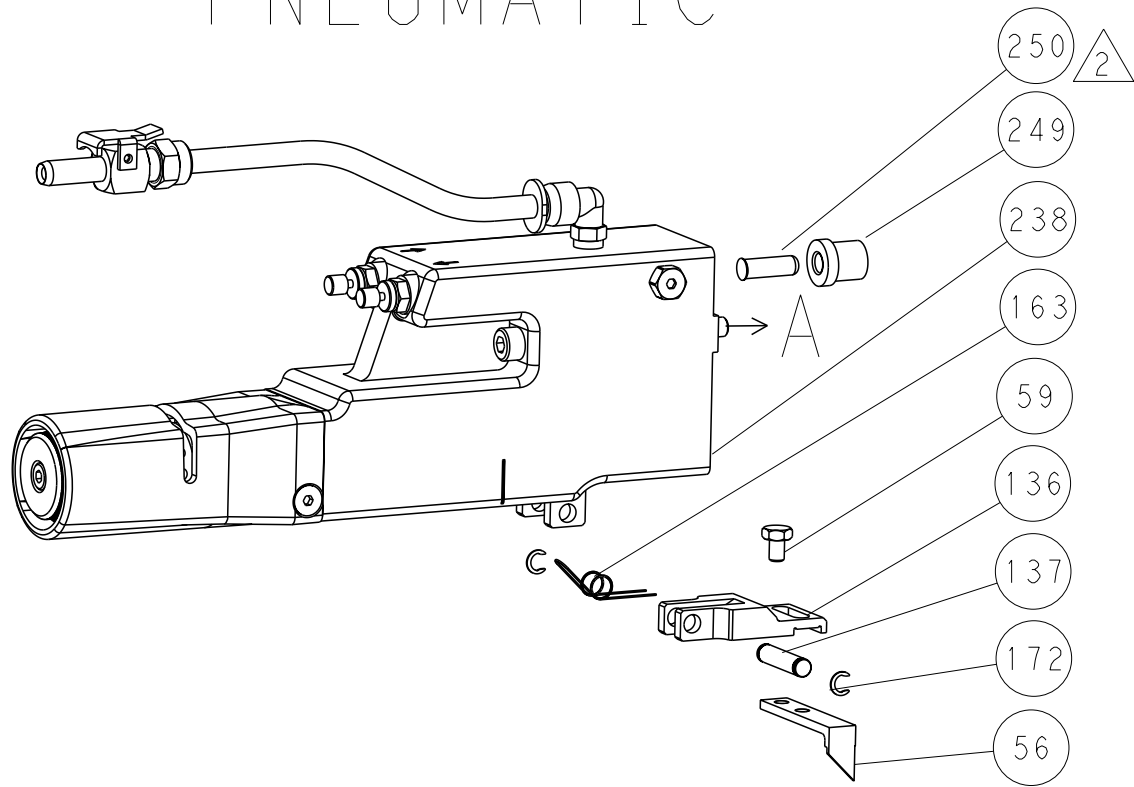
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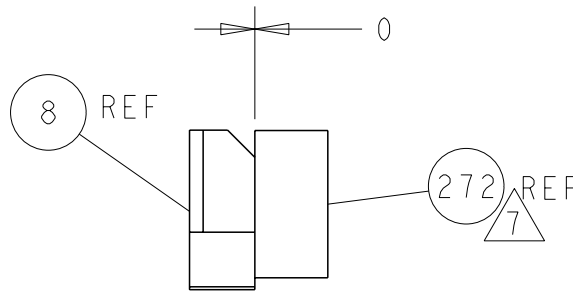
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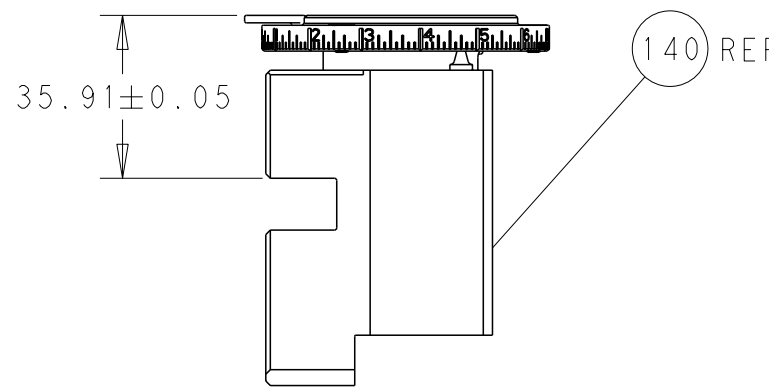
PNEUMATIC



TERMINAL SUPPORT LOCATION
FOR TERMINAL PN 1949498-1

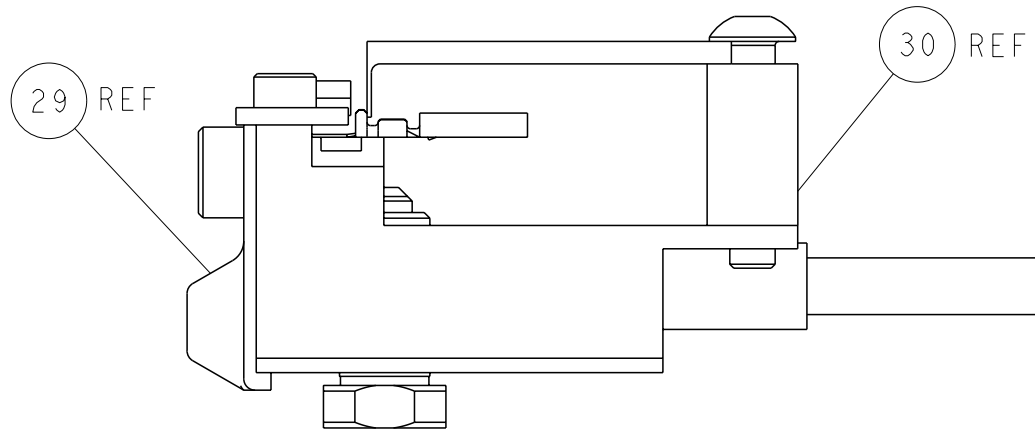


TERMINAL SUPPORT LOCATION
FOR TERMINAL PN 1949499-1



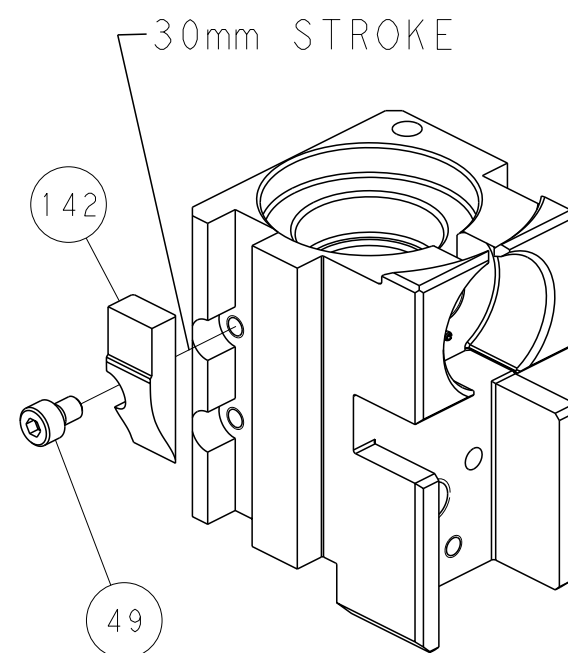
RAM SET-UP

ITEM 30 LOCATED AT
REAR HOLES

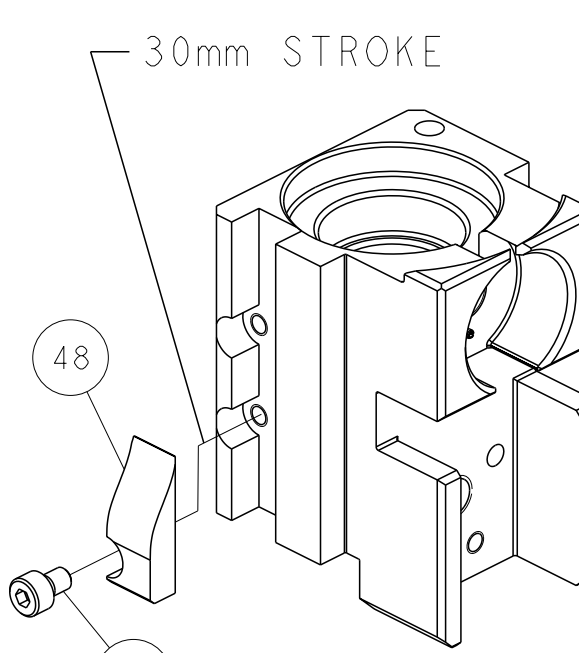


FEED TRACK POSITION
GUIDE BY INSULATION BARREL

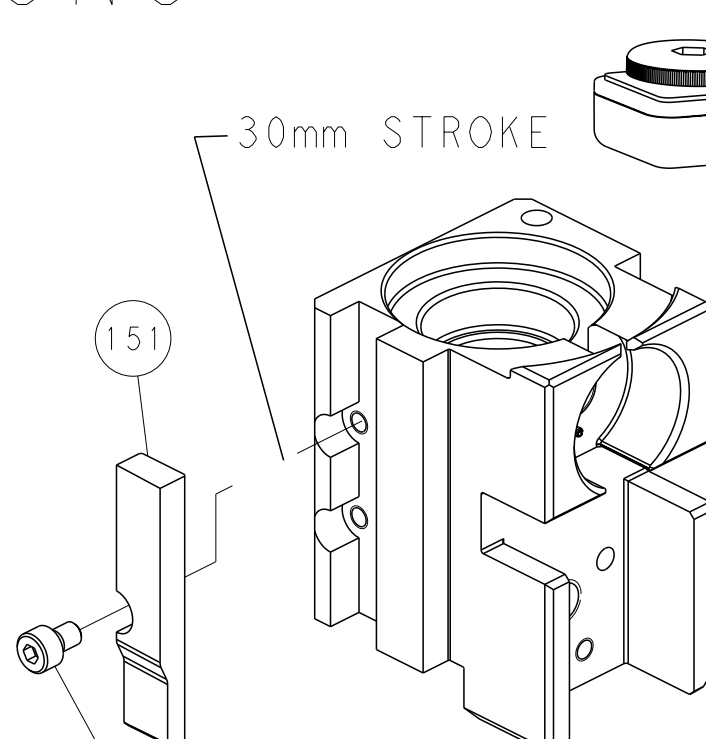
CAM POSITIONS



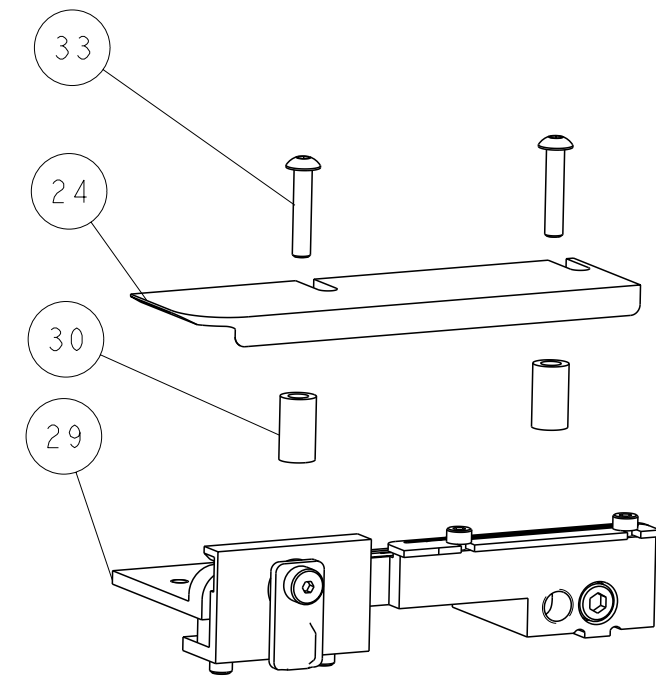
MECHANICAL
POST FEED



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 AND TO CONTROL AND ENGINEERING DISCREPANCY SHOULD BE CONTACTED FOR THE LATEST REVISION.		DWN R. O. WILSON CHK K. J. STAKEM APVD T. L. ELBIN	15APR2013 19APR2013 19APR2013	NAME Ocean Side Feed Applicator
DIMENSIONS: mm	TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±	PRODUCT SPEC	SIZE A1	CAGE CODE 00779
MATERIAL -	FINISH -	APPLICATION SPEC	DRAWING NO C=2151930	RESTRICTED TO -
Customer Accessible Production Drawing		SCALE 1:2	SHEET 4	OF 4 REV J1

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION