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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	
2151679-1	D	FINE CRIMP HEIGHT ADJUST	MECHANICAL	
2151679-2	D	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	
7-2151679-1	D	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL	
7-2151679-2	D	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC	
7-2151679-7	A	CRIMP TOOLING KIT	-	

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.00 mm [.039]	F
INSUL	1.07 mm [.042]	O
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: CONTACT, FEMALE, UNSEALED, 0.50 SERIES			
WIRE STRIP LENGTH 3.00-3.50 mm [.118-.138 IN]		INSULATION DIAMETER RANGE Ø0.85-1.05 mm [.033-.041 IN]	
TERMINAL APPLICATION SPECIFICATION		(B)114-5379	
TERMINALS APPLIED		△ ₆ △ ₇	
TE TERMINAL (B) 1827855-4	TE TERMINAL	TE TERMINAL	TE TERMINAL

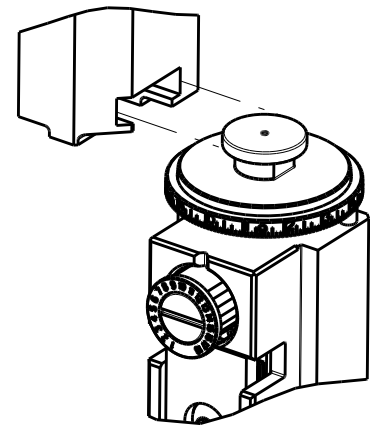
WIRE SIZE			CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING 
0.22mm2			0.64+/-0.02 [0.025+/-0.001]		7.1
0.13mm2			0.57+/-0.05 [0.022+/-0.002]		7.8



- △ RECOMMENDED SPARE PARTS
- △ REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- △ APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 180.
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.
- △ FEED ADJUSTMENT REQUIRED WHEN CHANGING TERMINAL APPLIED.
- △ TERMINAL LUBRICANT IS RECOMMENDED.

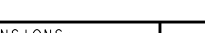
*WARNING
ON INSTALLATION, SET WIRE DISC TO CRIMP HEIGHT REFERENCE SETTING
FOR LARGEST WIRE SIZE. CRIMP HEIGHT REFERENCE SETTINGS GREATER
THAN THE VALUE SHOWN MAY CAUSE DAMAGE TO THE CRIMP TOOLING.
REFER TO THE INSTRUCTION SHEET FOR PROPER SETUP AND ADJUSTMENTS.

ATLANTIC VERSION TERMINATOR
INTERFACE ADAPTER



LOC	DIST	REVISIONS						
A	66	P	LTR	DESCRIPTION	DATE	DNW	APPV	
			B	ECR-16-009491	30JUN2016	MR	TE	
			B1	ECR-16-016595	23NOV2016	RS	LZ	
			C	ECR-18-018247	21NOV2018	FL	CT	
			D	ECR-18-019285	11DEC2018	MZ	CT	

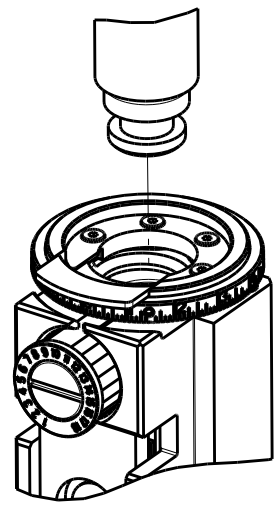
	-	1	-	1	-	2119640-1	PUSH ROD, AIR FEED	250
	-	1	-	1	-	1803259-1	BUSHING, FLANGED	249
	-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248
	-	1	1	1	1	2119082-8	CAM, SNAIL, INSULATION ADJUSTMENT	244
	-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
3	-	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
	-	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	-	2063440-1	AIR FEED MODULE	238
3	-	2	2	2	2	1-2079383-0	SCR, BHSC, RoHS (M3 X 6)	230
	-	1	1	1	1	1-1752354-8	STANDOFF,HOLD-DOWN	180
	-	1	1	1	1	1976053-9	LOCATOR BLOCK, TERMINAL	177
	-	1	1	1	1	9931111-1	PIN, SLOTTED SPRING 3.0 X 20.0	177
	-	1	1	1	1	8-22280-7	SPRING, COMPRESSION	176
	-	1	1	1	1	1752353-2	GUIDE PIN,HOLDDOWN	175
	-	1	1	1	1	1901680-2	GUIDE PIN,HOLDDOWN	174
	-	2	-	2	-	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172
	-	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
	-	1	-	1	-	240638-1	SPRING, FEED FINGER	163
	-	1	-	1	-	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854	137
7	-	1	-	1	-	2119799-1	HOLDER,FEED FINGER, AF	136
	-	1	1	1	1	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113
	-	1	1	1	1	2844908-1	SCREW, LOCKING	99
	-	1	1	1	1	2844907-1	POST, LOCKING	98
	-	1	1	1	1	455888-8	SPACER, CRIMPER	82
	-	1	1	1	1	5-547505-2	SPRING, COMPRESSION	77
	-	1	1	1	1	854769-4	HOLDER, INS	74
	-	1	1	1	1	1803607-1	DOCUMENTATION PACKAGE	71
	-	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	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
	-	1	1	1	1	21028-2	PIN, SLOTTED SPRING .062 X .250	58
	-	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
	-	1	1	1	1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52
	-	1	1	1	1	1901681-4	HOLDDOWN, TERMINAL	51
	-	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	1803515-3	RAM ASSEMBLY, SF ATLANTIC	44
	-	1	1	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
	-	1	1	1	1	1-1752356-6	SUPPORT, TERMINAL	34
	-	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
	-	2	2	2	2	2-2844962-3	SPACER, CYLINDRICAL, STRIP GUIDE	30
	-	1	1	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29
	-	1	1	1	1	455888-3	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	2119533-1	STRIPPER, SIDE FEED	19
1	-	1	1	1	1	2119806-1	INSERT, SHEAR	13
	-	1	1	1	1	3-22280-3	SPRING, COMPRESSION	12
	-	1	1	1	1	1-356885-4	STOP, SHEAR	11
1	-	1	1	1	1	2119805-1	SHEAR HOLDER, FRONT	10

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										CHK Z.ZHANG		17JUN2013																	
										APP'D W.GUO		17JUN2013																	
DIMENSIONS: mm			TOLERANCES UNLESS OTHERWISE SPECIFIED:							PRODUCT SPEC		NAME Ocean Side Feed Applicator -																	
			Ø PLC ± 1 PLC ± 2 PLC ± 3 PLC ± ANGLES ±							APPLICATION SPEC																			
MATERIAL -			FINISH -							WEIGHT -																			
										SIZE		CAGE CODE		DRAWING NO		RESTRICTED TO													
										A		00779		C=2151679		-													
Customer Accessible Production Drawing														SCALE		1:2		SHEET		1		OF		4		REV		D	

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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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2151679-1	D	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2151679-2	D	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151679-7	A	CRIMP TOOLING KIT	-



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.00 mm [.039]	F
INSUL	1.07 mm [.042]	O
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: CONTACT, FEMALE, UNSEALED, 0.50 SERIES			
WIRE STRIP LENGTH 3.00-3.50 mm [.118-.138 IN]		INSULATION DIAMETER RANGE Ø0.85-1.05 mm [.033-.041 IN]	
TERMINAL APPLICATION 		(B)114-5379	
SPECIFICATION		-	
TERMINALS APPLIED 		-	
TE TERMINAL (B) 1827855-4	TE TERMINAL	TE TERMINAL	TE TERMINAL

WIRE SIZE			CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING 
0.22mm2			0.64+/-0.02 [0.025+/-0.001]		7.1
0.13mm2			0.57+/-0.05 [0.022+/-0.002]		7.8



- ① RECOMMENDED SPARE PARTS
- ② REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- ③ APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 180.
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.
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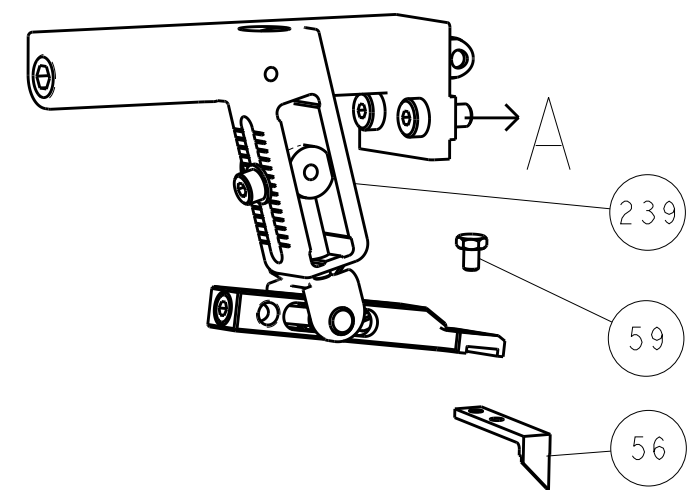
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	-	1	-	2119640-1	PUSH ROD, AIR FEED	250
	-	1	-	1803259-1	BUSHING, FLANGED	249
	-	1	1	2119082-8	CAM, SNAIL, INSULATION ADJUSTMENT	244
	-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
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	-	1	-	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	-	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854	137
	-	1	-	2119799-1	HOLDER, FEED FINGER, AF	136
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	-	1	1	5-547505-2	SPRING, COMPRESSION	77
	-	1	1	854769-4	HOLDER, INS	74
	-	1	1	1803607-1	DOCUMENTATION PACKAGE	71
	-	1	1	2119740-1	TAG, IDENTIFICATION	67
	-	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
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	-	1	1	1320928-2	STRIP GUIDE	24
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	-	2	2	1-18028-2	WASHER, FLAT, REG M4	20
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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	1633861-1	SHEAR, FLOATING	9
1	1	1	1	3-1633711-1	ANVIL, COMBINATION	8
	-	-	-	-	-	7
	-	-	-	-	-	6
	-	1	1	2119780-9	DEPRESSOR, SHEAR	5
	-	1	1	3-238011-8	BLOCK, CRIMPER SPACER	4
1	1	1	1	1633966-3	CRIMPER, INSULATION O	3
	-	-	-	-	-	2
1	1	1	1	2-937157-8	CRIMPER, WIRE SPECIAL	1
-77	-22	-21		PART NO	DESCRIPTION	ITEM NO

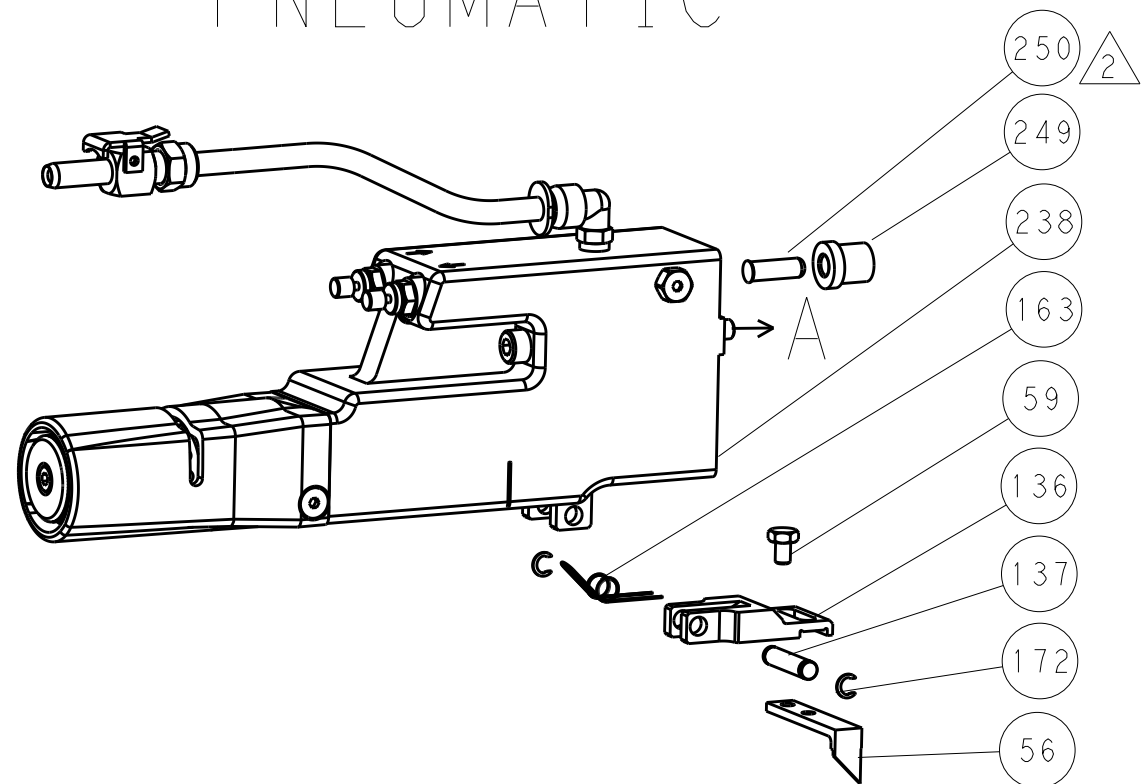
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										CHK L.ZHANG		17JUN2013					
										APP'D W.GUO		17JUN2013					
DIMENSIONS: mm			TOLERANCES UNLESS OTHERWISE SPECIFIED:							PRODUCT SPEC		NAME Ocean Side Feed Applicator -					
			Ø PLC ±. 1 PLC ±. 2 PLC ±. 3 PLC ±. ANGLES ±.							APPLICATION SPEC							
MATERIAL -			FINISH -							WEIGHT -							
										SIZE CAGE CODE DRAWING NO		RESTRICTED TO					
										A 00779 C=2151679		-					
Customer Accessible Production Drawing														SCALE 1:2 SHEET 3 OF 4 REV D			

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

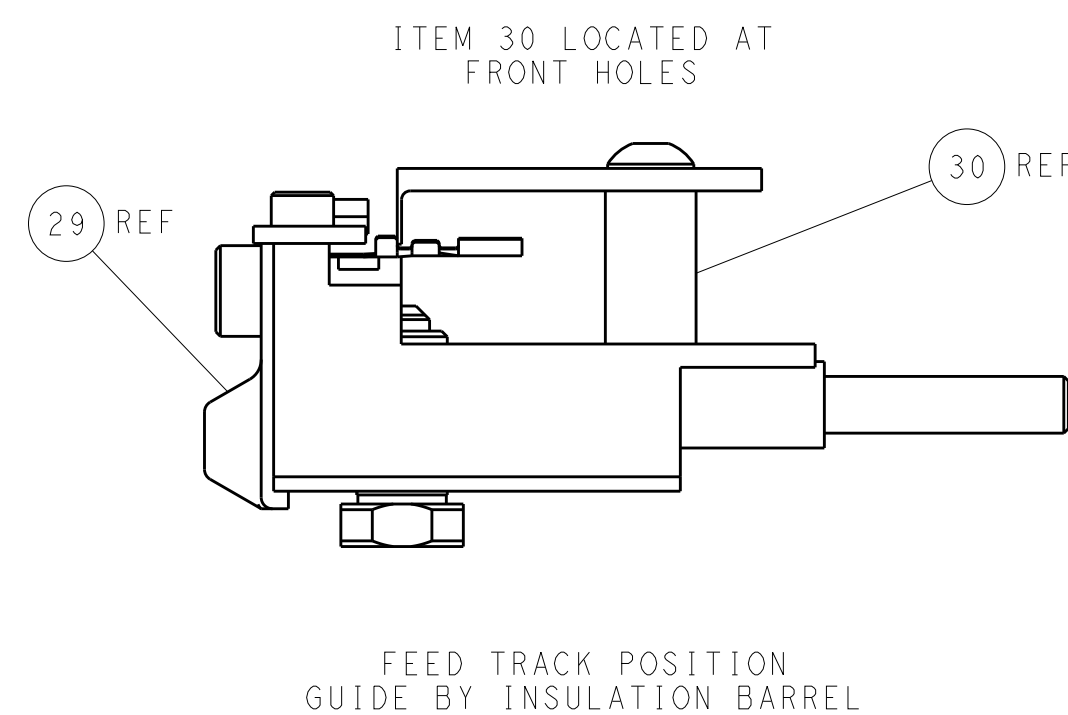
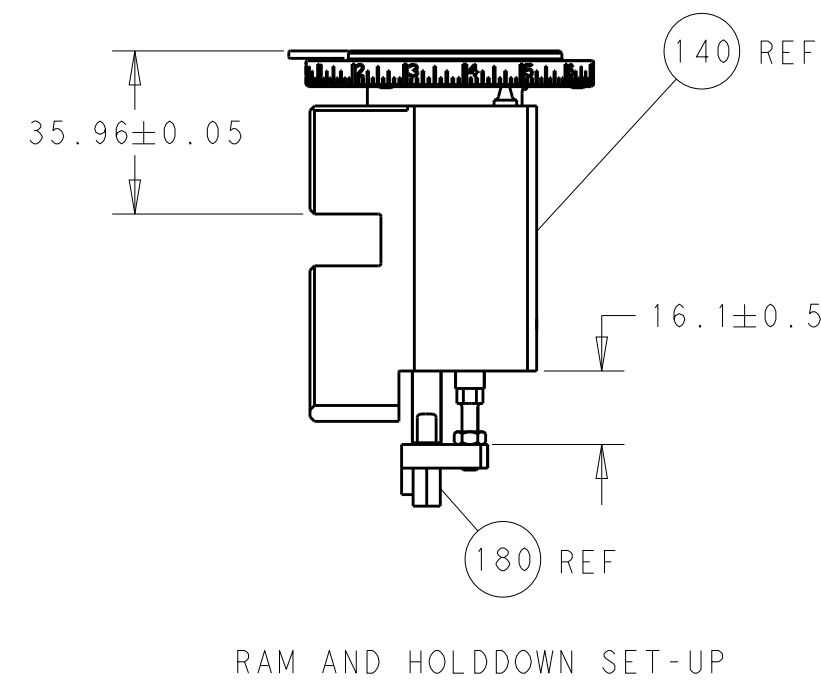
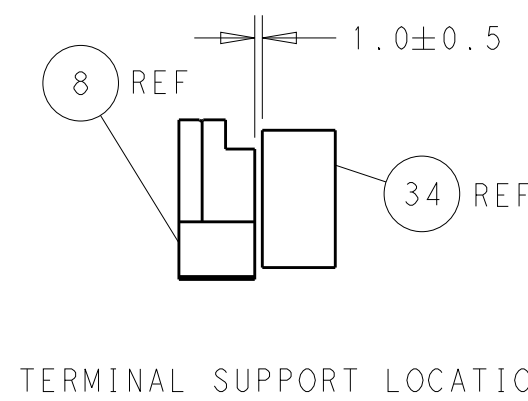
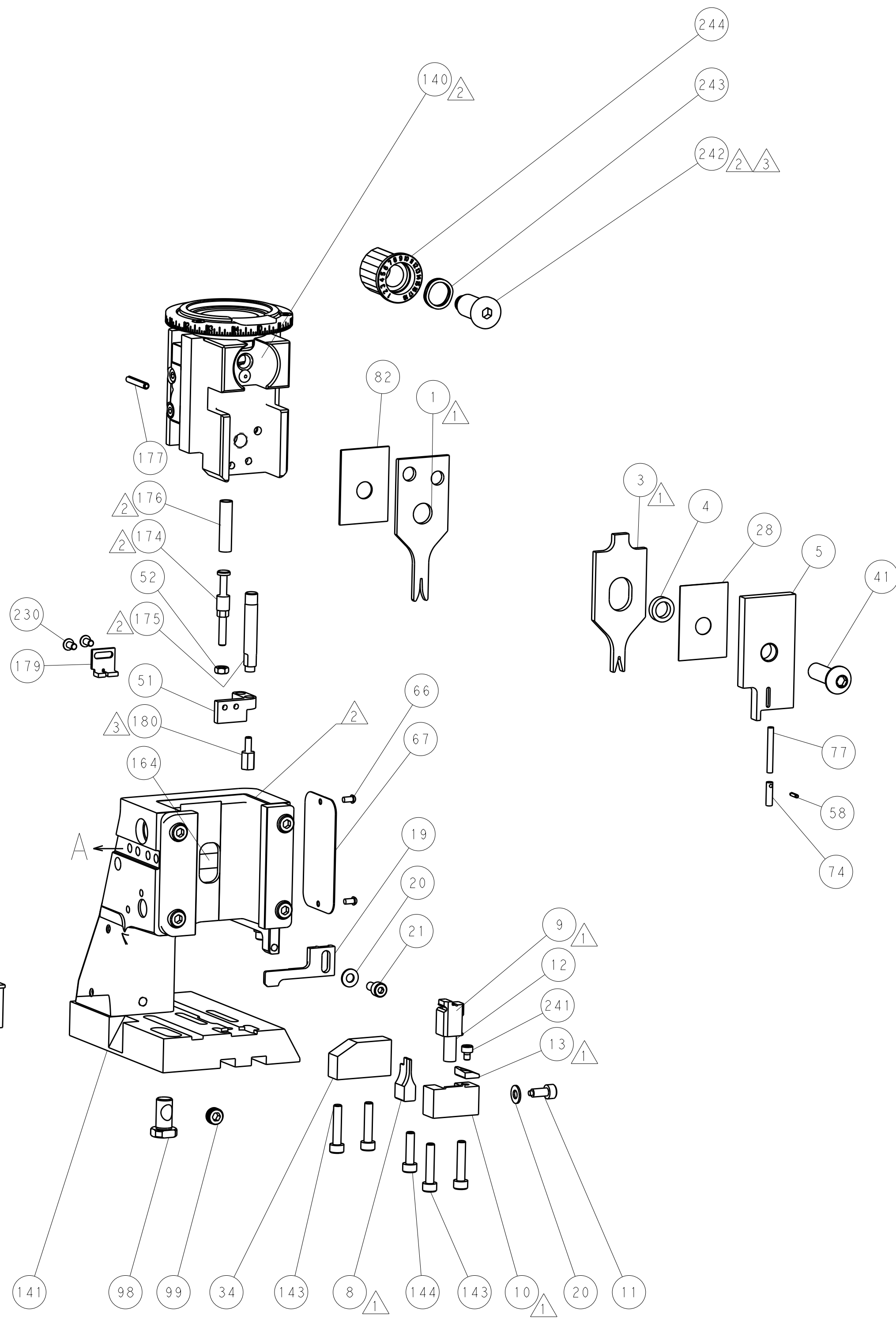
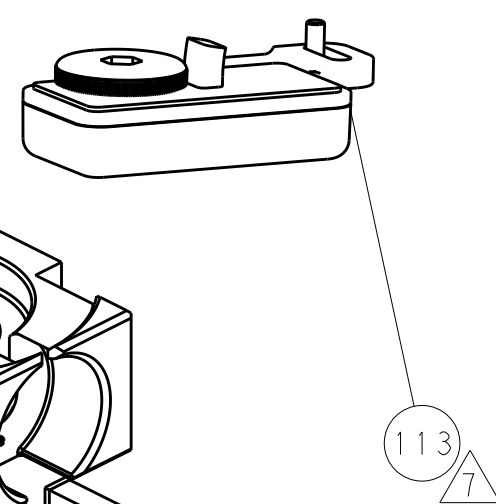
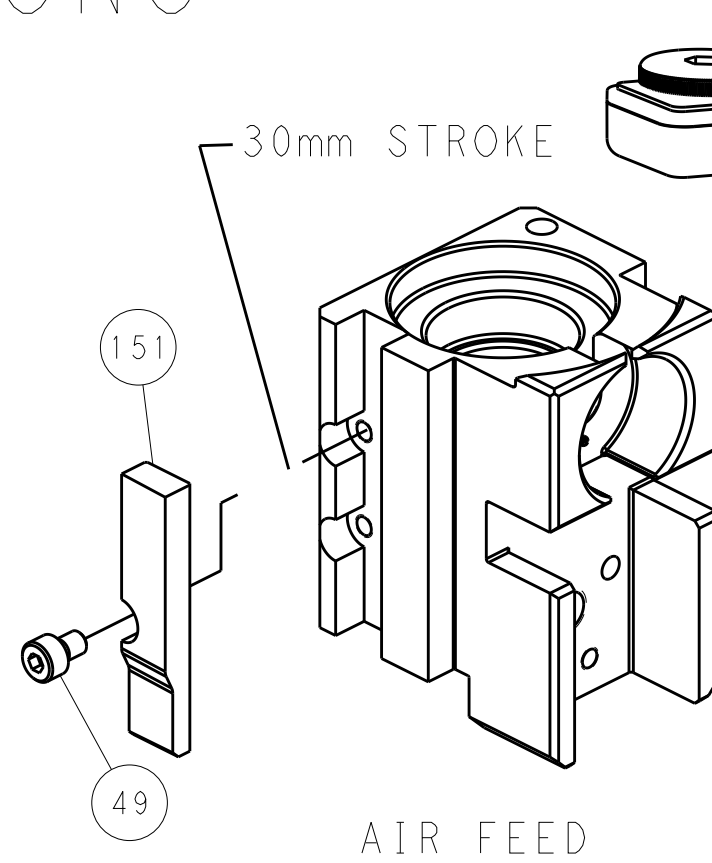
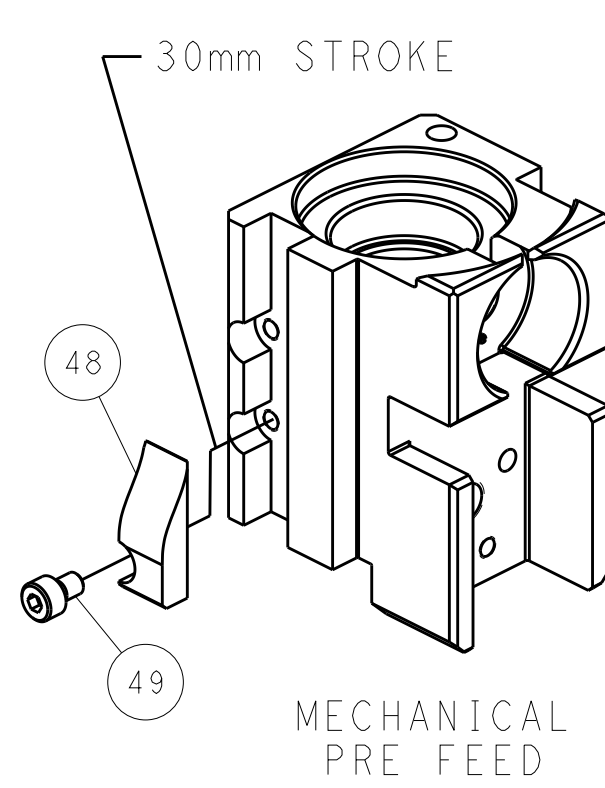
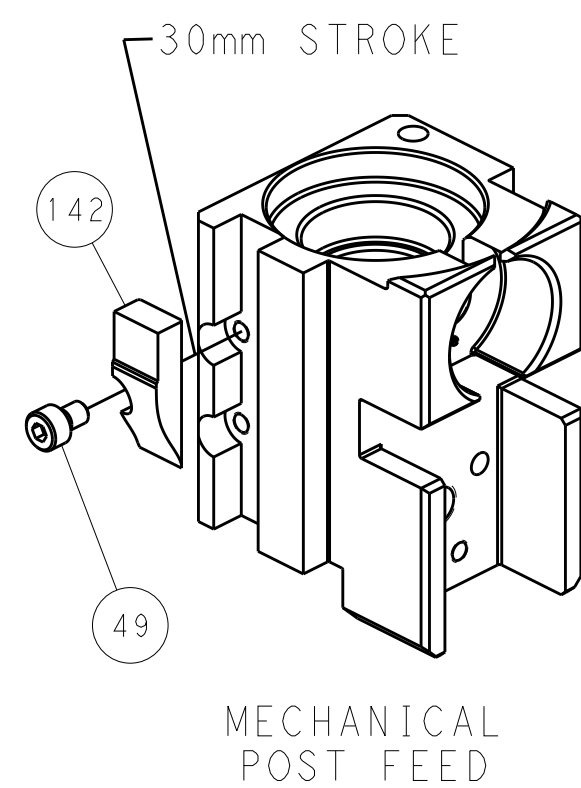
FEED TYPE
MECHANICAL



PNEUMATIC



CAM POSITIONS



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

1. THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. THE USER SHALL BE RESPONSIBLE FOR VERIFYING THE LATEST VERSION OF THE DRAWING. 2. THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. THE USER SHALL BE RESPONSIBLE FOR VERIFYING THE LATEST VERSION OF THE DRAWING.		OWN K. HUANG CHK L. ZHANG APVD J. GUO	17JUN2013 17JUN2013 17JUN2013	NAME	TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.1 1 PLC ±.1 2 PLC ±.1 3 PLC ±.1 4 PLC ±.1 ANGLES ±.1 FINISH		PRODUCT SPEC	Ocean Side Feed Applicator
MATERIAL		WEIGHT		APPLICATION SPEC	
-		-		SIZE CAGE CODE DRAWING NO	RESTRICTED TO
-		-		A1 00779 ©=2151679	-
Customer Accessible Production Drawing		SCALE 1:2		SHEET 4 OF 4	REV D