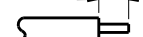
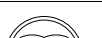


8		7	
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20		20	
COPYRIGHT 20		BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.	
PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151718-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2151718-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151718-1	C	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2151718-2	C	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2151718-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.98 mm [.078]	F
INSUL	2.50 mm [.098]	F
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: DELPHI TERMINAL		DELPHI CRIMP SPECIFICATION	
TERMINAL NAME: TERMINAL TAB			
WIRE STRIP LENGTH 4.46-4.47 mm [.175-.176 IN]		 INSULATION DIAMETER RANGE Ø1.30-1.90 mm [.051-.075 IN]	
TERMINAL APPLICATION SPECIFICATION 		DELPHI	
-		-	
-		-	
TERMINALS APPLIED			
TE TERMINAL		DELPHI TERMINAL	
1572382-1		12059894	

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.50mm2	1.15+/-0.05 [.045+/-0.002]	6.6
0.35mm2	1.10+/-0.05 [.043+/-0.002]	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.
- 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)

2		1					
LOC	DIST	REVISIONS					
A	66	P	LTR	DESCRIPTION	DATE	DWN	APVD
		A		RELEASED	09JUL2013	LG	TE
		B		ECR-19-000939	18JAN2019	TB	CT
		C		ECR-19-005012	29MAR2019	MZ	YY

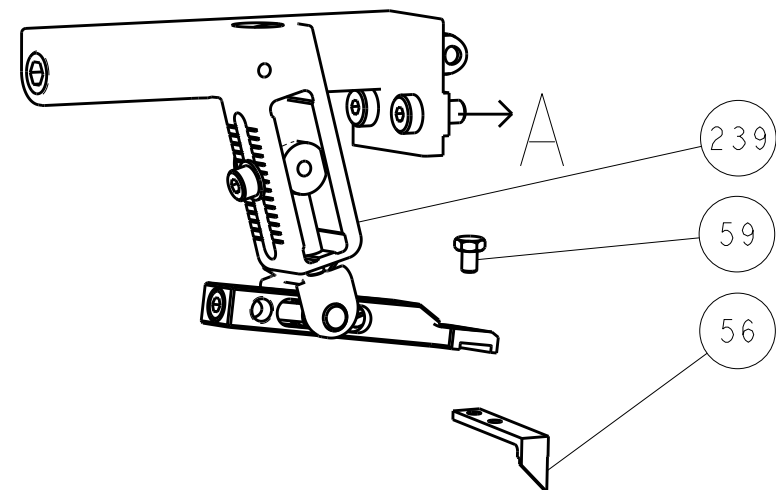
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-	1	-	1	-	1803259-1	BUSHING, FLANGED	249
-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248
-	1	1	1	1	2119082-8	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	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
-	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
-	1	-	1	-	2119799-1	HOLDER, FEED FINGER, AF	136
-	1	1	1	1	1-18028-2	WASHER, FLAT, REG M4	119
-	1	1	1	1	2844908-1	SCREW, LOCKING	99
-	1	1	1	1	2844907-1	POST, LOCKING	98
-	1	1	1	1	455888-6	SPACER, CRIMPER	82
-	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	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	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	1803583-9	APPLICATOR BASIC ASSEMBLY, SF	46
-	1	1	1	1	1803515-1	RAM ASSEMBLY, SF ATLANTIC	44
-	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	2-2844962-6	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29
-	1	1	1	1	1-455888-0	SPACER, CRIMPER	28
-	1	1	1	1	1320928-6	STRIP GUIDE	24
-	1	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
-	1	1	1	1	1-18028-2	WASHER, FLAT, REG M4	20
-	1	1	1	1	2119533-1	STRIPPER, SIDE FEED	19
-	1	1	1	1	240641-3	SPACER	16
-	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	2119805-1	SHEAR HOLDER, FRONT	10
-	1	1	1	1	318707-1	FLOATING SHEAR, FRONT	9
-	1	2	2	1	1-1803054-2	ANVIL, COMBINATION	8
-	1	1	1	1	240641-2	SPACER	7
-	-	-	-	-	-	-	6
-	1	1	1	1	2119757-9	DEPRESSOR, SHEAR	5
-	1	1	1	1	238011-4	BLOCK, CRIMPER SPACER	4
-	1	2	2	1	4-1633961-5	CRIMPER, INSULATION F PREMIUM	3
-	1	1	1	1	455888-4	SPACER, CRIMPER	2
-	1	2	2	1	8-1633305-0	CRIMPER, WIRE PREMIUM	1
-	77	72	71	-2	-1	PART NO	ITEM NO
						DESCRIPTION	

THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. ANY CHANGES TO THIS DRAWING SHOULD BE CONTACTED FOR THE LATEST EDITION.				DWN S. ALVES 17SEP2012	TE Connectivity Harrisburg, PA 17105-3608		
DIMENSIONS:				CHK P. BARLETTA 17SEP2012	NAME		
mm				APVD C. LIMA 17SEP2012	Ocean Side Feed Applicator		
TOLERANCES UNLESS OTHERWISE SPECIFIED:				PRODUCT SPEC	SIZE		
0 PLC ±				APPLICATION SPEC	CAGE CODE		
1 PLC ±					DRAWING NO		
2 PLC ±					RESTRICTED TO		
3 PLC ±					A1 00779 ©=2151718		
4 PLC ±					Customer Accessible Production Drawing		
ANGLES				FINISH	SCALE		
MATERIAL					1:2		
					SHEET 1 OF 4		
					REV C		

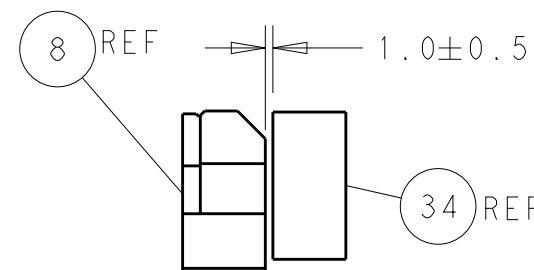
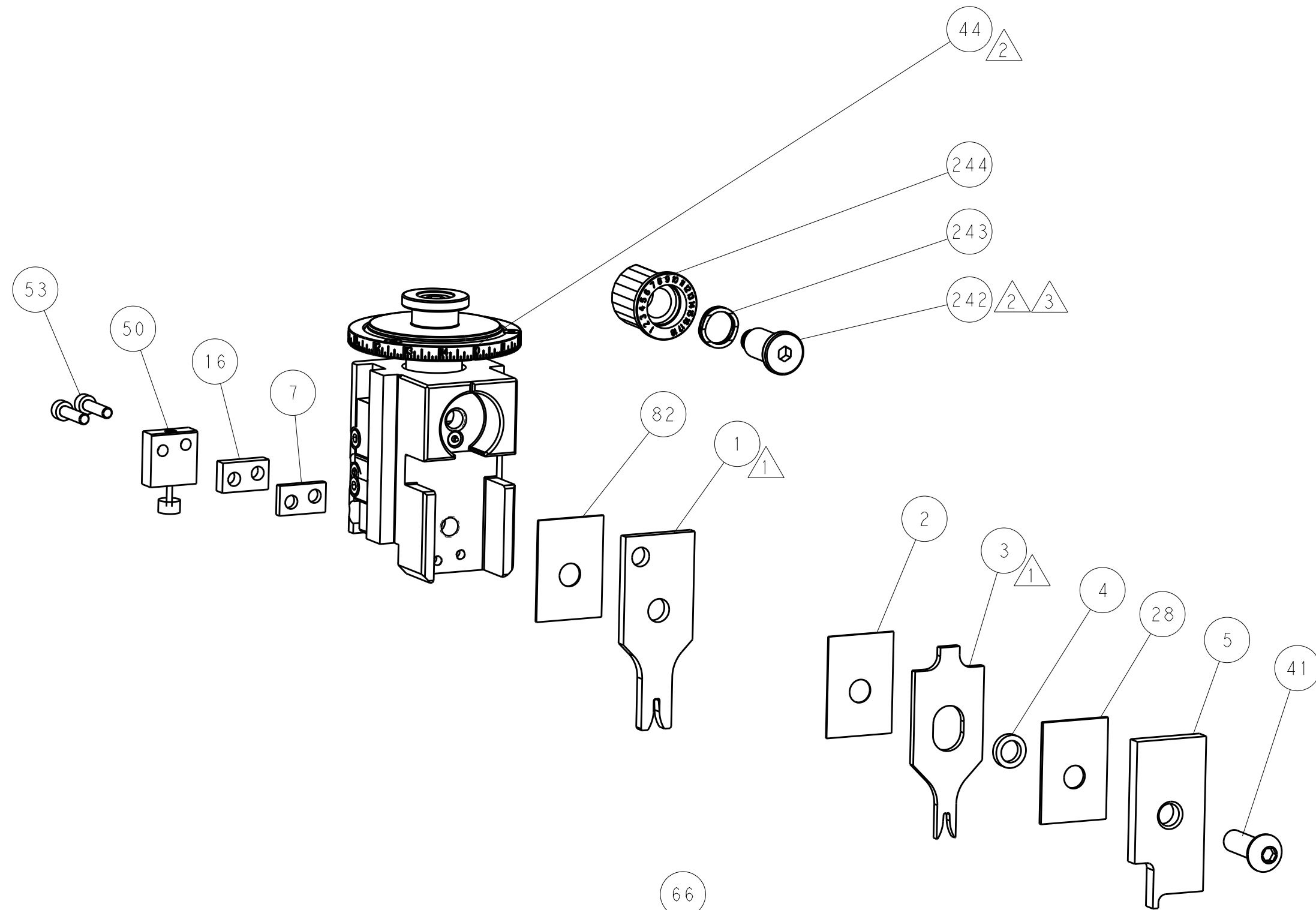
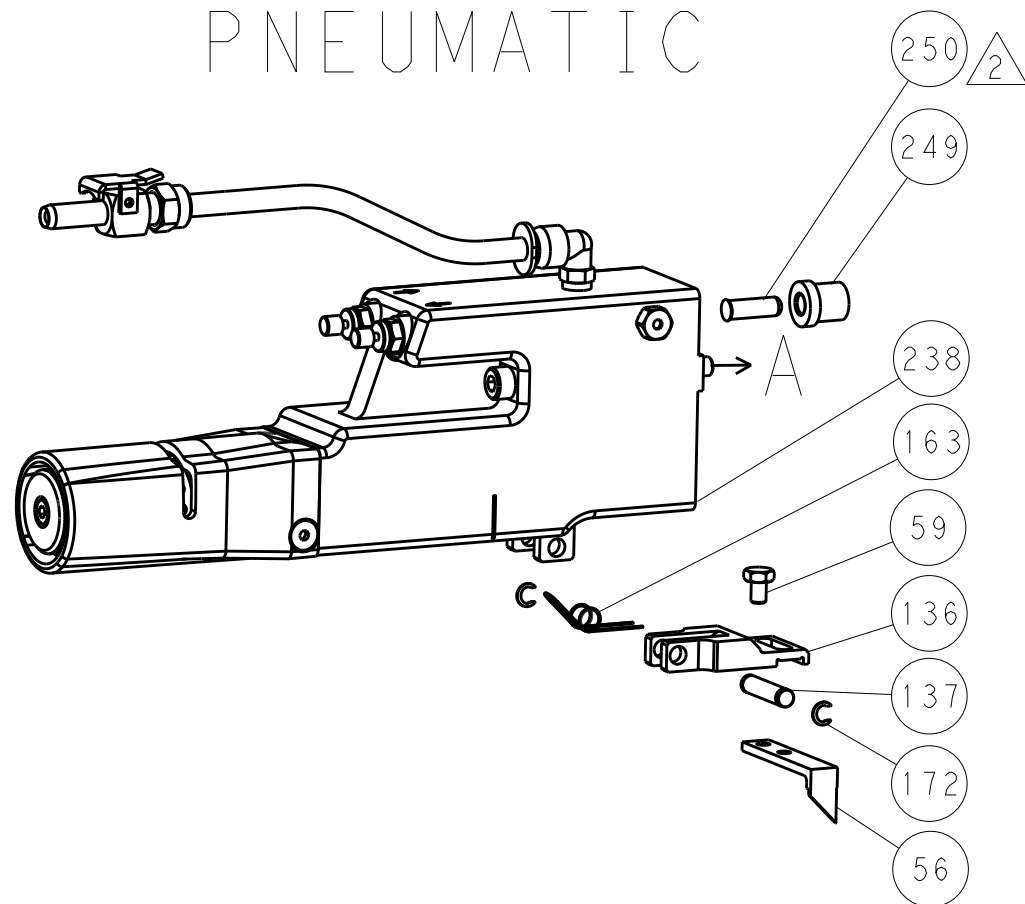
SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

LOC	DIST	REVISIONS					
		P	LTR	DESCRIPTION	DATE	DWN	APVD
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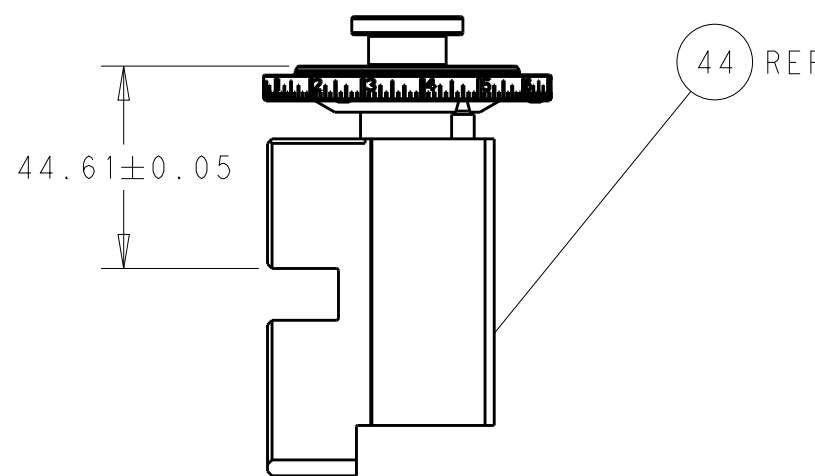
FEED TYPE
MECHANICAL



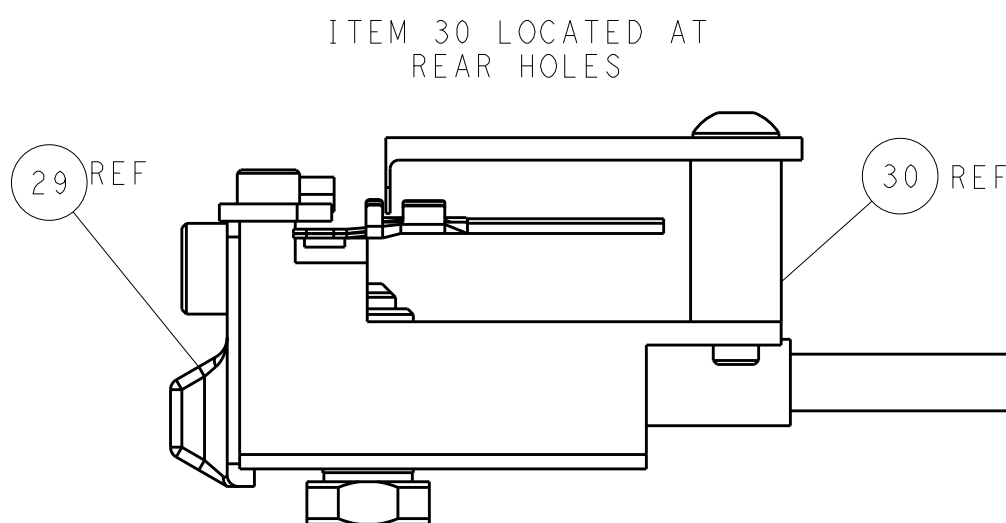
PNEUMATIC



TERMINAL SUPPORT LOCATION

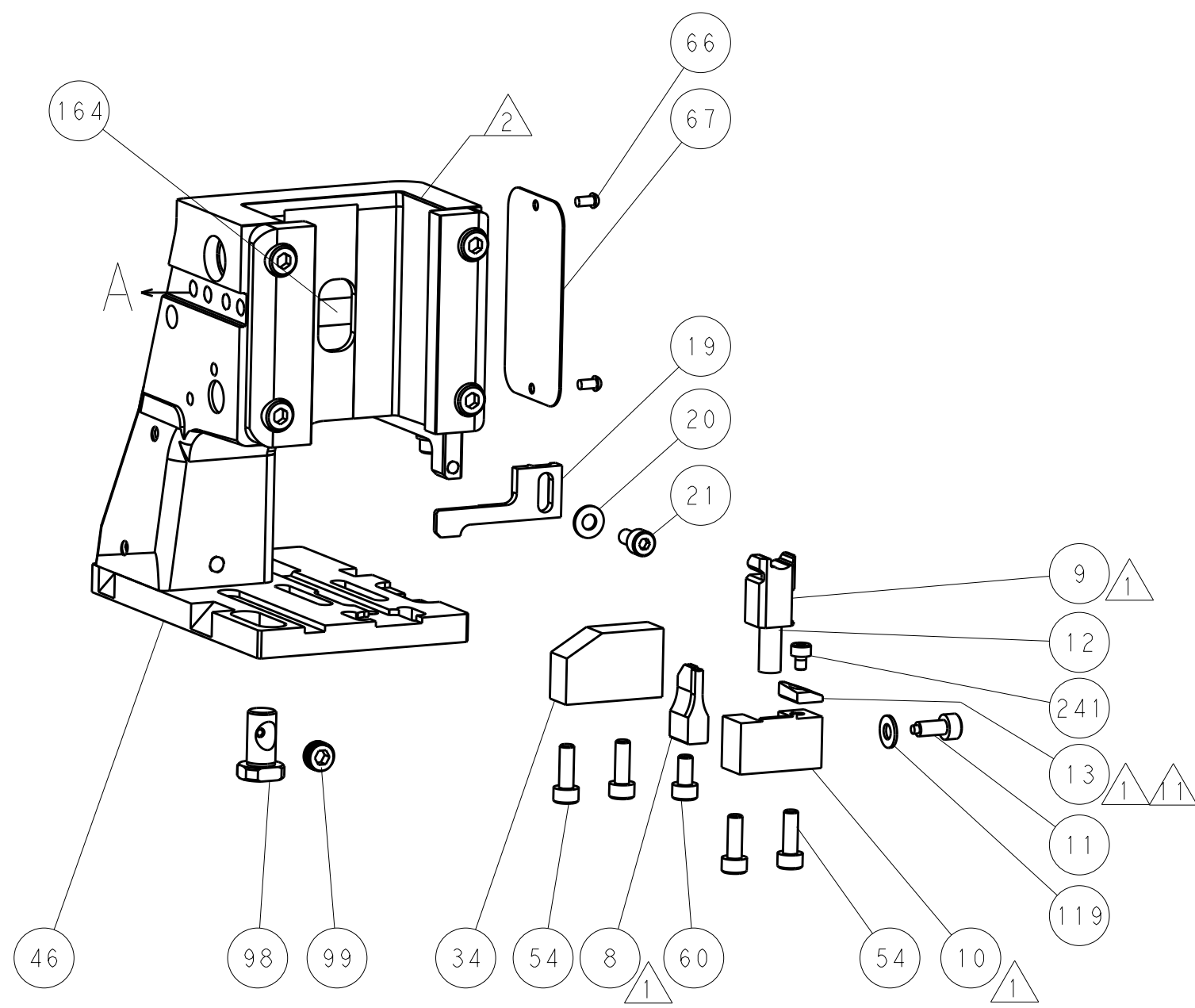
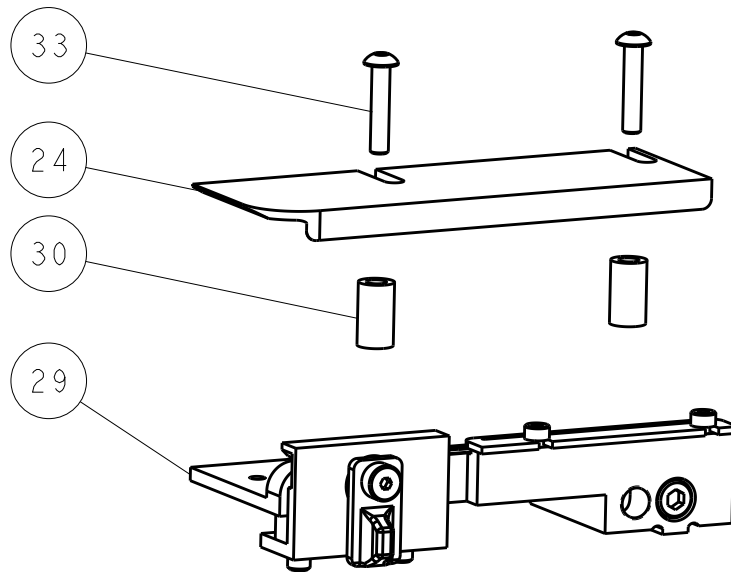
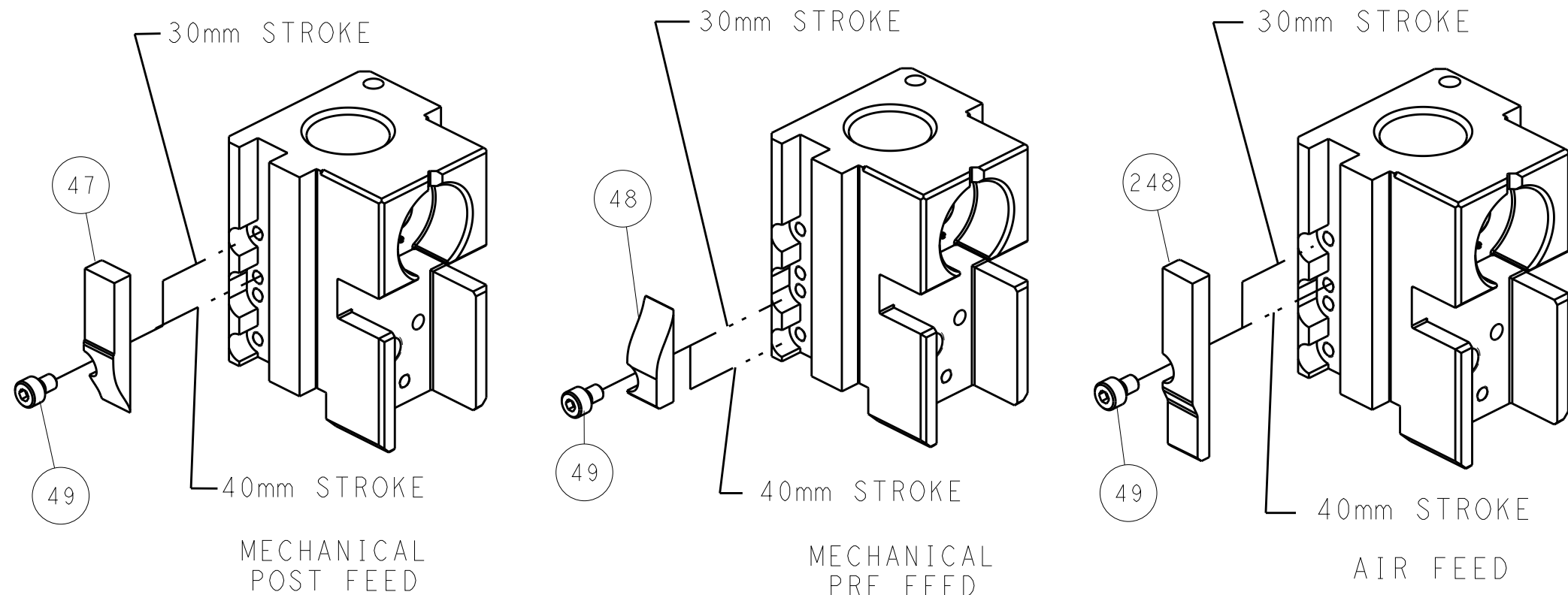


RAM SET-UP



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 S. ALVES 17SEP2012		TE Connectivity	
mm		0 PLC ±.0005		CHK P. BARLETTA 17SEP2012		Harrisburg, PA 17105-3608	
FINISH		1 PLC ±.0005		APVD C. LIMA 17SEP2012		NAME Ocean Side Feed Applicator	
MATERIAL		2 PLC ±.0005		PRODUCT SPEC		SIZE CAGE CODE DRAWING NO	
		3 PLC ±.0005		APPLICATION SPEC		A1 00779 C=2151718	
		4 PLC ±.0005		WEIGHT		RESTRICTED TO	
				Customer Accessible Production Drawing		SCALE 1:2 SHEET 2 OF 4 REV C	

8		7	
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20		20	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2151718-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2151718-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151718-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.98 mm [.078]	F
INSUL	2.50 mm [.098]	F
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: DELPHI TERMINAL		DELPHI CRIMP SPECIFICATION	
TERMINAL NAME: TERMINAL TAB			
WIRE STRIP LENGTH 4.46-4.47 mm [.175-.176 IN]		INSULATION DIAMETER RANGE Ø1.30-1.90 mm [.051-.075 IN]	
TERMINAL APPLICATION SPECIFICATION 		DELPHI Rev A	
		-	-
		-	-
TERMINALS APPLIED			
TE TERMINAL	DELPHI TERMINAL	TE TERMINAL	DELPHI TERMINAL
1572382-1	12059894		

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING
0.50mm2		1.15+/-0.05 [.045+/-0.002]		6.6
0.35mm2		1.10+/-0.05 [.043+/-0.002]		7.0



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.

*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		REVISONS				
A		66		P	LTR	DESCRIPTION	DATE	OWN
				-	-	SEE SHEET 1	-	-

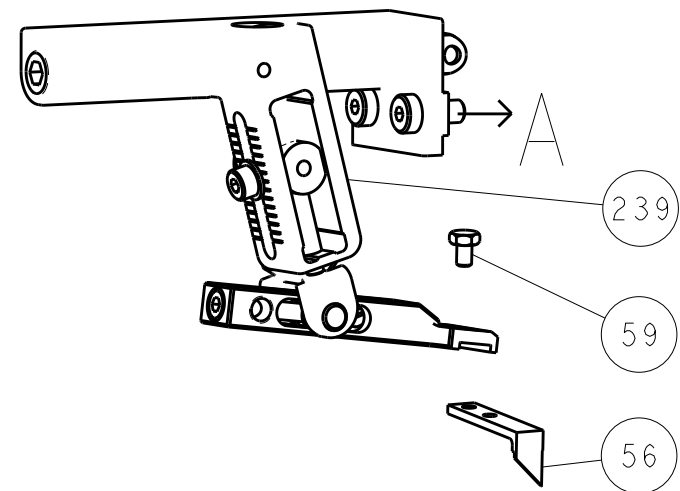
-	1	-	2119640-1	PUSH ROD, AIR FEED	250
-	1	-	1803259-1	BUSHING, FLANGED	249
-	1	1	2119082-8	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
-	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	1	-	2063440-1	AIR FEED MODULE	238
-	2	-	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172
-	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	1	-	240638-1	SPRING, FEED FINGER	163
-	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
-	1	1	1-18028-2	WASHER, FLAT, REG M4	119
-	1	1	2844908-1	SCREW, LOCKING	99
-	1	1	2844907-1	POST, LOCKING	98
-	1	1	455888-6	SPACER, CRIMPER	82
-	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
-	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	1	1	1338685-1	PAWL, FEED	56
-	2	2	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	53
-	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	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
-	1	1	1752356-1	SUPPORT, TERMINAL	34
-	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	2-2844962-6	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29
-	1	1	1-455888-0	SPACER, CRIMPER	28
-	1	1	1320928-6	STRIP GUIDE	24
-	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	240641-3	SPACER	16
-	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	318707-1	FLOATING SHEAR, FRONT	9
1	1	1	1-1803054-2	ANVIL, COMBINATION	8
-	1	1	240641-2	SPACER	7
-	-	-	-	-	6
-	1	1	2119757-9	DEPRESSOR, SHEAR	5
-	1	1	238011-4	BLOCK, CRIMPER SPACER	4
-	1	1	4-1633961-5	CRIMPER, INSULATION F PREMIUM	3
-	1	1	455888-4	SPACER, CRIMPER	2
1	1	1	8-1633305-0	CRIMPER, WIRE PREMIUM	1
-77	-22	-21	PART NO	DESCRIPTION	ITEM NO

THIS DRAWING IS A CONTROLLED DOCUMENT AND THE FOLLOWING INFORMATION IS SUBJECT TO COMPANY'S POLICY ON CONTROLLING DOCUMENTS. IT IS SUBJECT TO COMPANY'S POLICY ON CONTROLLING DOCUMENTS. IT IS SUBJECT TO COMPANY'S POLICY ON CONTROLLING DOCUMENTS. IT IS SUBJECT TO COMPANY'S POLICY ON CONTROLLING DOCUMENTS.		OWN S. ALVES	17SEP2012	TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS:		CHK P. BARLETTA	17SEP2012	NAME	
mm		APVD C. LIMA	17SEP2012	Ocean Side Feed Applicator	
TOLERANCES UNLESS OTHERWISE SPECIFIED:		PRODUCT SPEC		SIZE	
0 PLC ±.005		APPLICATION SPEC		CAGE CODE	
1 PLC ±.005		WEIGHT		DRAWING NO	
2 PLC ±.005		FINISH		00779	
3 PLC ±.005		RESTRICTED TO		©=2151718	
4 PLC ±.005		Customer Accessible Production Drawing		SCALE	
ANGLES		1:2		SHEET 3 OF 4	
FINISH		REV		C	

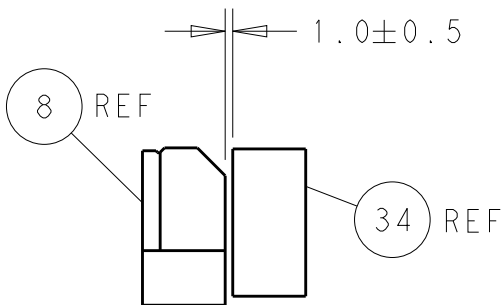
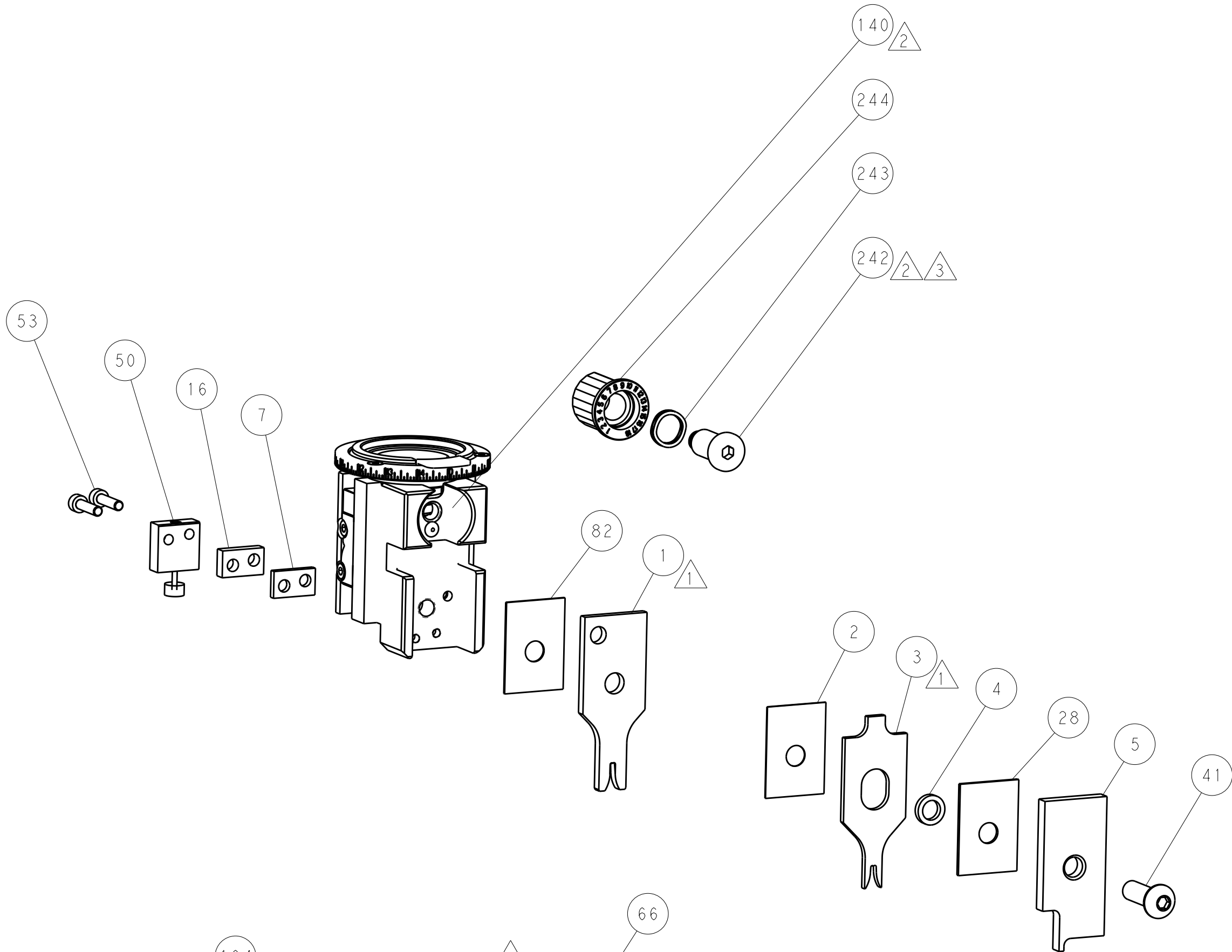
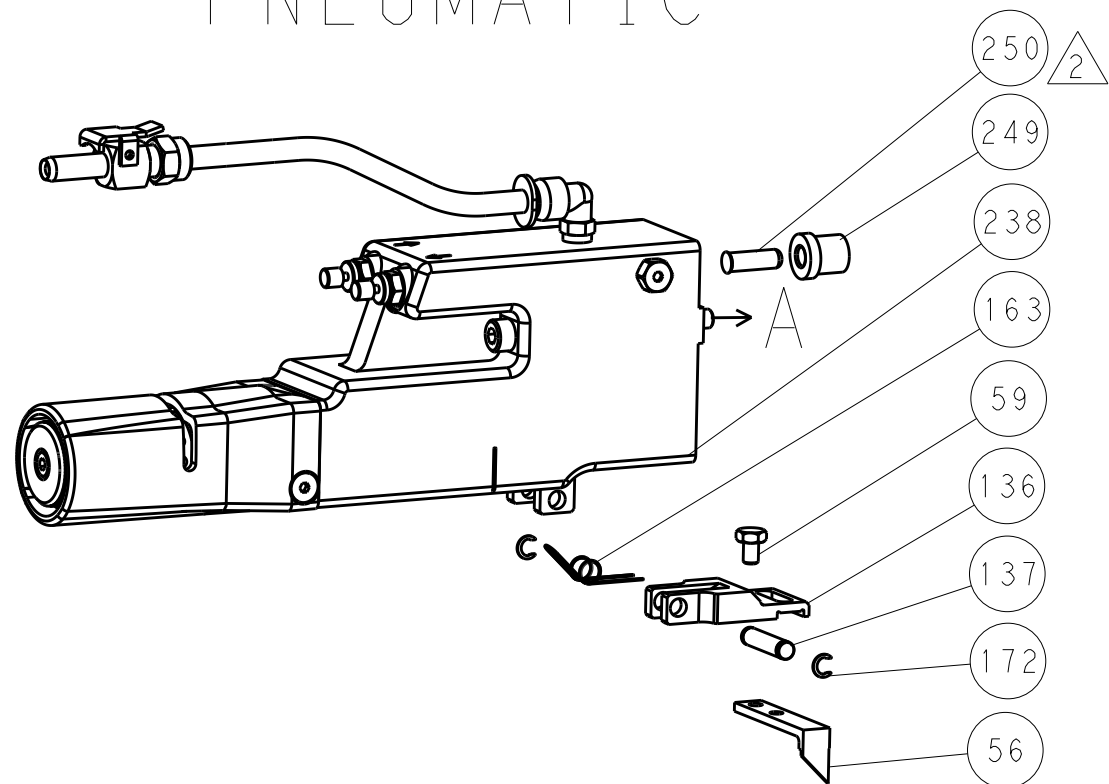
SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

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

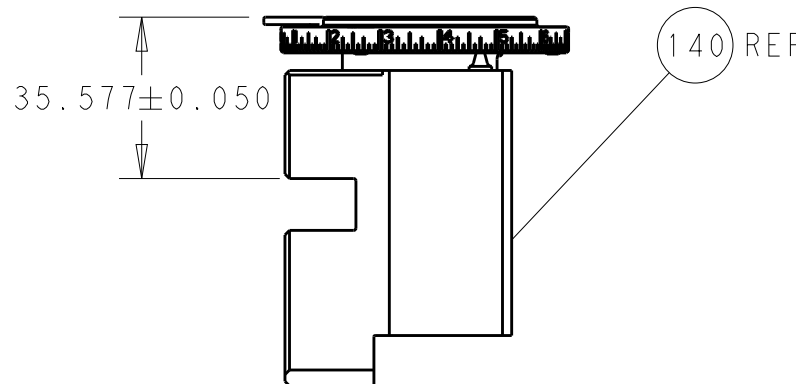
FEED TYPE
MECHANICAL



PNEUMATIC

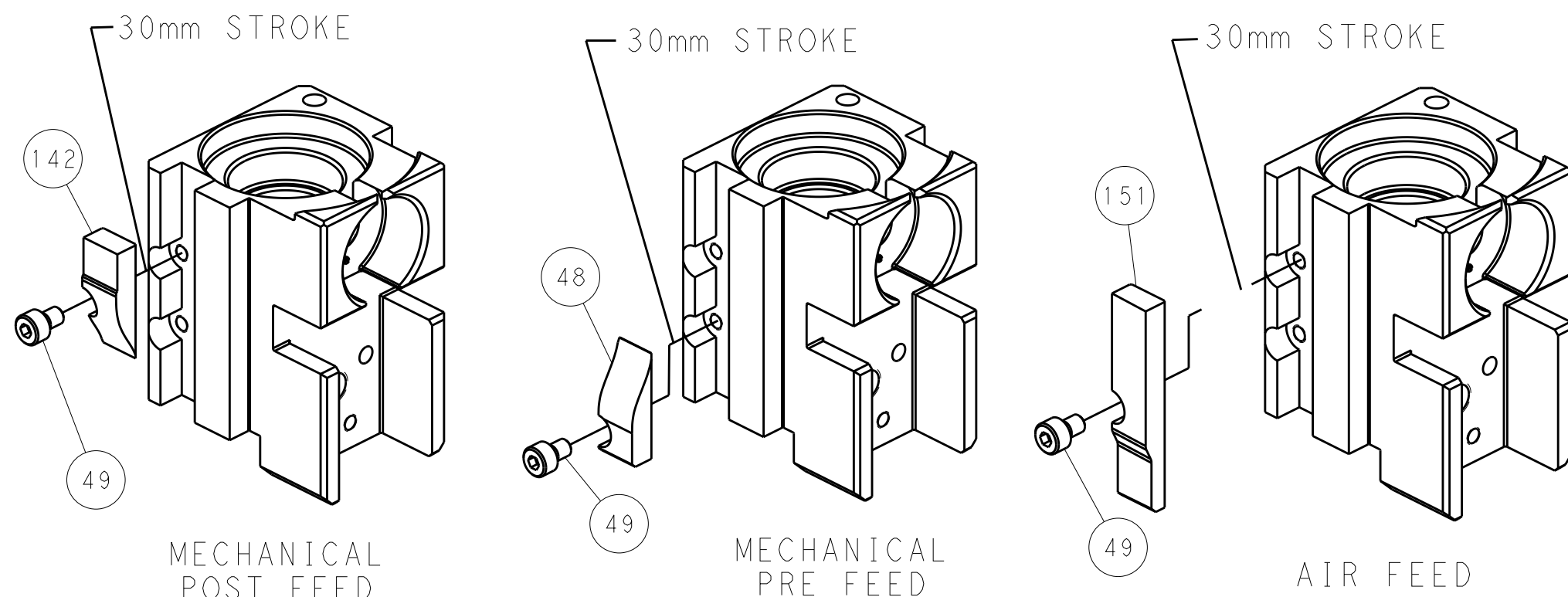


TERMINAL SUPPORT LOCATION



RAM SET-UP

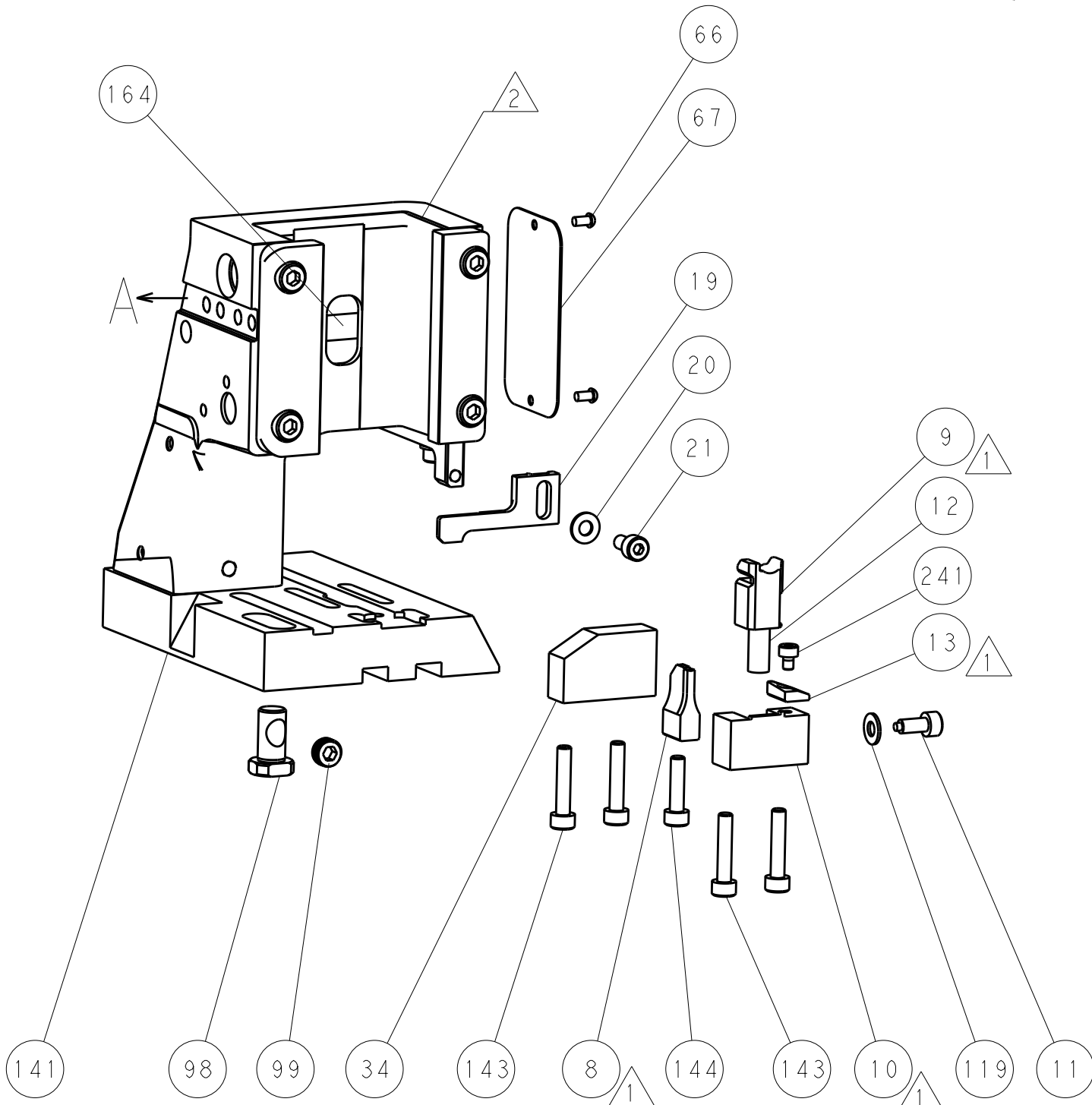
CAM POSITIONS



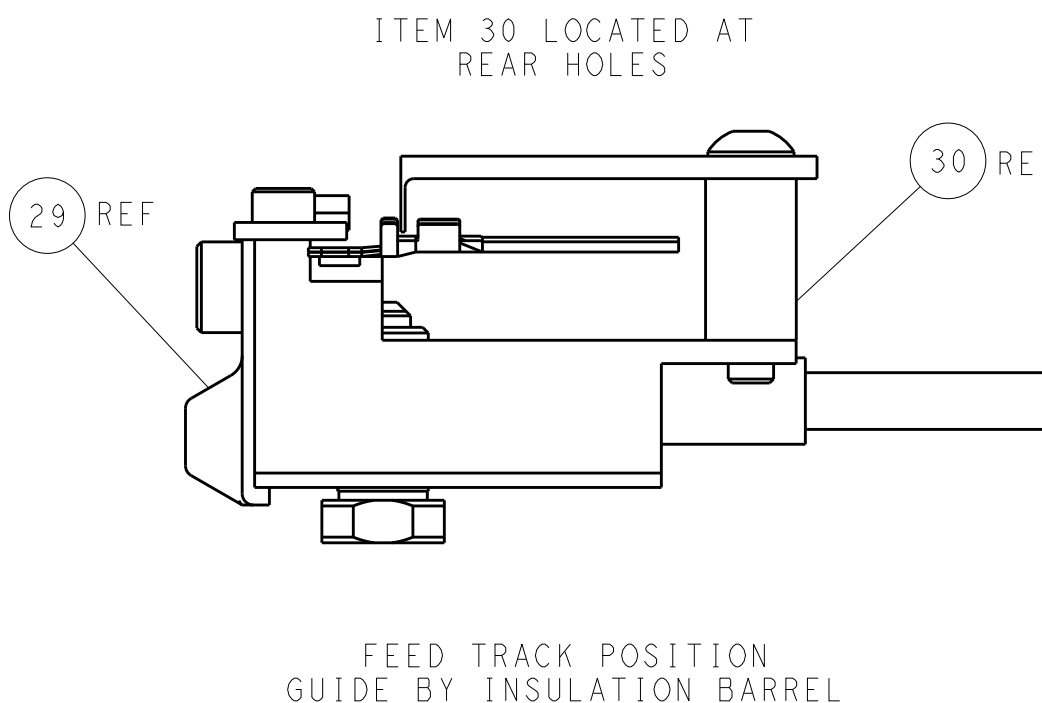
MECHANICAL
POST FEED

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)



FEED TRACK POSITION
GUIDE BY INSULATION BARREL

1ST PUBLISHED BY: COMPANY'S TOOLING FOR THE ELECTRONIC CORPORATION IT IS SUBJECT TO CHANGE WITHOUT NOTICE AND THE COMPANY'S ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST POSITION.		DWN S. ALVES 17SEP2012	TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm		CHK P. BARLETTA 17SEP2012	NAME Ocean Side Feed Applicator	
TOLERANCES UNLESS OTHERWISE SPECIFIED:		APVD C. LIMA 17SEP2012	SIZE A1	
0 PLC ±.005 1 PLC ±.005 2 PLC ±.005 3 PLC ±.005 4 PLC ±.005 ANGLES ±.005 FINISH		PRODUCT SPEC	CAGE CODE 00779	
MATERIAL -		APPLICATION SPEC	DRAWING NO C=2151718	
		WEIGHT -	RESTRICTED TO -	
		Customer Accessible Production Drawing	SCALE 1:2	
			SHEET 4	
			OF 4	
			REV C	