

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151730-1	F	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2151730-2	F	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151730-1	F	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2151730-2	F	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2151730-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.03 mm [.080]	F
INSUL	4.25 mm [.167]	O

APPLICATOR INSTRUCTIONS  
408-35042

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: 2.8mm BLADE, SEALED			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
5.50-5.51 mm [.217-.217 IN]		Ø1.20-2.70 mm [.047-.106 IN]	
TERMINAL APPLICATION SPECIFICATION	114-13013		

TERMINALS APPLIED				SEAL	INSULATION DIAMETER RANGE
TE TERMINAL	TE TERMINAL	TE SEAL	YAZAKI SEAL		
1326031-8	1326032-9	1949064-1	7158-3113-40		1.2-2.7 mm
		1949064-2	7158-3112-70		1.2-2.7 mm

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
18 AWG	1.37+/-0.05 [.054+/- .002]	4.1
1.00mm2	1.30+/-0.05 [.051+/- .002]	4.9
0.75mm2	1.22+/-0.05 [.048+/- .002]	6.0

- 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 APPLY TORO-SEAL IN ALLEN SOCKET TO FILL HOLE AFTER FLAT HD HAS BEEN ADJUSTED TO CORRECT HEIGHT AT QUALIFICATION. APPLY #1-23419-5 LOC-TITE TO THREADS.
- 6 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)

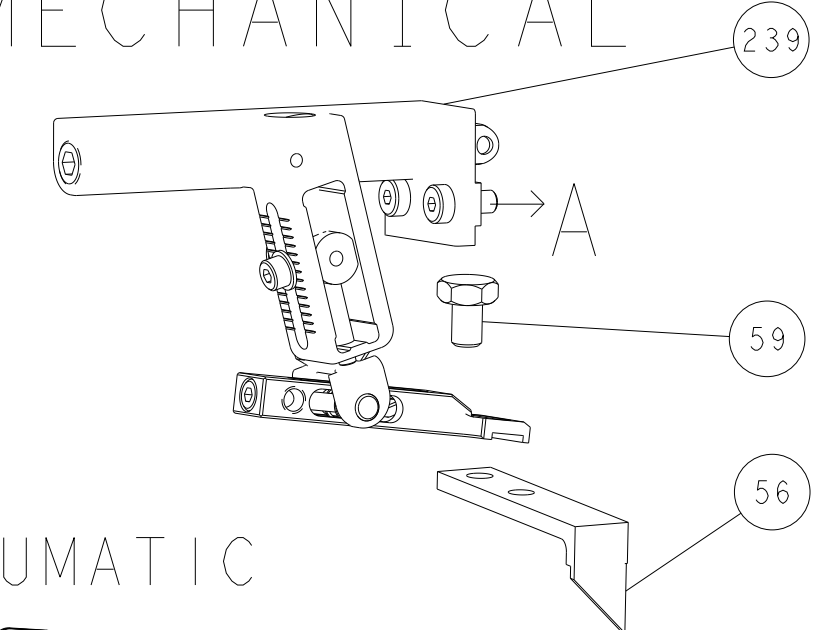
LOC	DIST	REVISIONS					
		P	LTN	DESCRIPTION	DATE	OWN	APVD
A	66	E		ECR-19-014658	20SEP2019	FZ	TE
		E1		ECR-20-002411	19FEB2020	MZ	YY
		E2		ECR-21-006796	09JUL2021	FJ	YY
		F		ECR-22-130118	21FEB2022	FZ	GB

-	1	1	1	1	2-455888-9	SPACER, CRIMPER	259
-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248
-	1	1	1	1	2119082-7	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	-	2844940-1	AIR FEED MODULE	238
-	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	1	1	1	1	1-22281-8	SPRING, COMPRESSION	121
-	1	1	1	1	318563-1	GUARD, FRONT CHIP	119
-	1	1	1	1	2844908-1	SCREW, LOCKING	99
-	1	1	1	1	2844907-1	POST, LOCKING	98
-	1	1	1	1	1-690438-0	FRONT STRIP GUIDE	96
-	2	2	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	95
-	1	1	1	1	2168083-6	SCR, SKT HD CAP, RoHS, M5 X 65	93
-	1	1	1	1	1-455888-7	SPACER, CRIMPER	82
-	1	1	1	1	985575-1	SCR, FLT SKT HD CAP M3 X 6.0	81
-	1	1	1	1	224405-2	DEPRESSOR, WIRE	80
-	2	2	2	2	18024-6	SCR, BTN SKT HD CAP (M4 X 8.0)	79
-	1	1	1	1	1803096-1	EXTENSION PLATE	78
-	1	1	1	1	1803607-3	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
-	2	2	2	2	2-18032-5	SCR, SET, FLT PNT, M5 X 20.0	61
-	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	985575-3	SCR, FLT SKT HD CAP M3 X 10.0	57
-	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	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	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	1803515-2	RAM ASSEMBLY, SF ATLANTIC	44
-	1	1	1	1	1803602-2	SCR, BHSC, RoHS (M8 X 40)	41
-	1	1	1	1	2-1752356-0	SUPPORT, TERMINAL	34
-	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	2	2	1-2844962-8	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	1	1	2844938-5	PLATE, STRIP GUIDE	29
-	1	1	1	1	455888-3	SPACER, CRIMPER	28
-	2	2	2	2	22283-1	SPRING, COMPRESSION	27
-	1	1	1	1	356835-1	LEVER, DRAG RELEASE	26
-	1	1	1	1	240792-2	DRAG, TERMINAL	25
-	1	1	1	1	1320928-6	STRIP GUIDE	24
-	1	1	1	1	980371-4	SCR, SKT HD SHLDR 5.0 DIA X 6.0	23
-	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	2119533-2	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	1-356885-4	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	1-1633927-6	ANVIL, COMBINATION	8
-	-	-	-	-	-	-	7
-	-	-	-	-	-	-	6
-	1	1	1	1	2119781-1	DEPRESSOR, SHEAR	5
-	1	1	1	1	2-238011-1	BLOCK, CRIMPER SPACER	4
-	1	2	2	1	6-2119784-2	CRIMPER, INSULATION O PREMIUM	3
-	1	1	1	1	1-455888-9	SPACER, CRIMPER	2
-	1	2	2	1	1-856313-7	CRIMPER, WIRE	1
-	77	72	71	2	-1	PART NO	ITEM NO

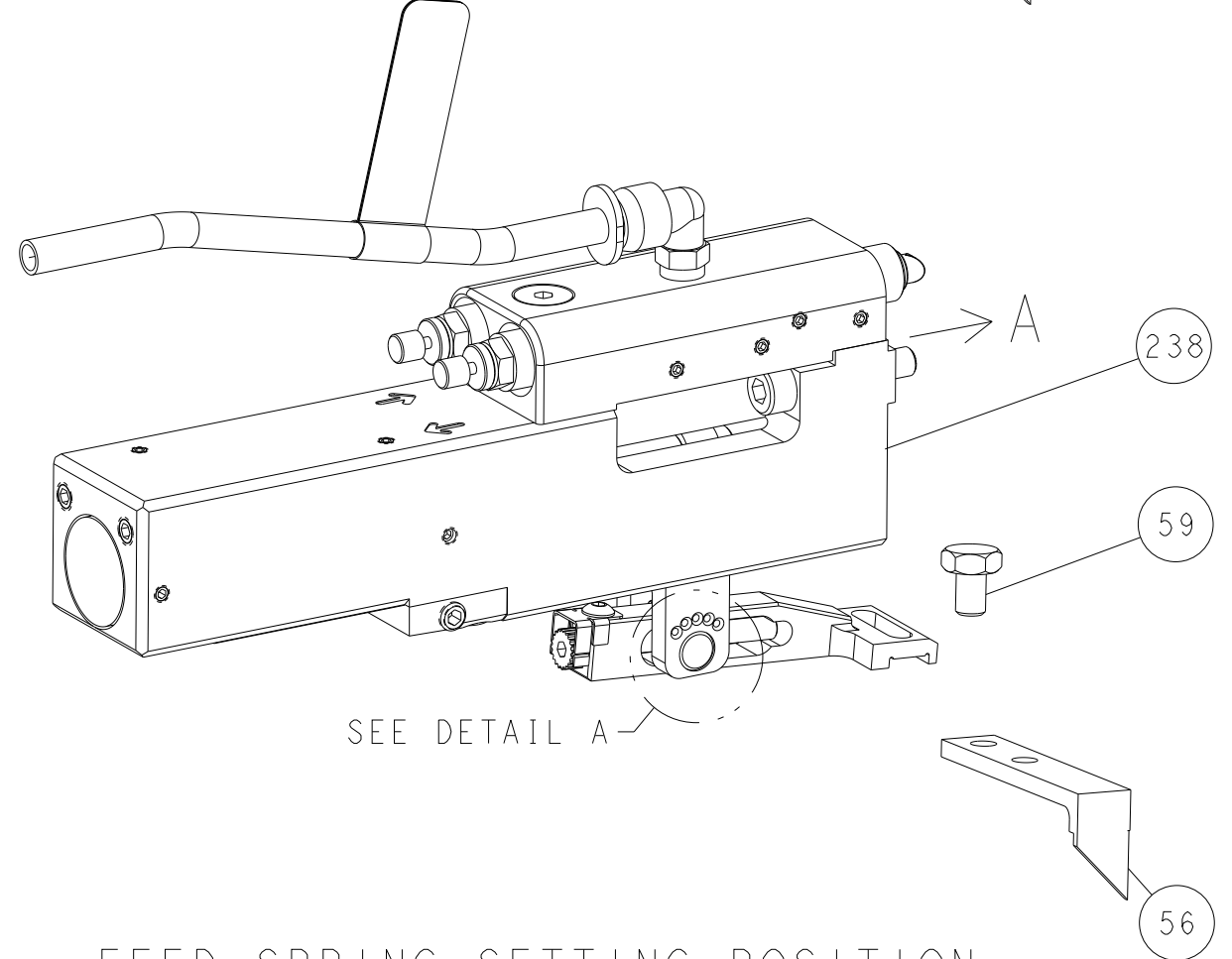
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		OWN		DATE	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES ±	FINISH
MATERIAL				WEIGHT	SCALE	SHEET	REV
Customer Accessible Production Drawing				SCALE	1:2	SHEET	1 OF 4

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

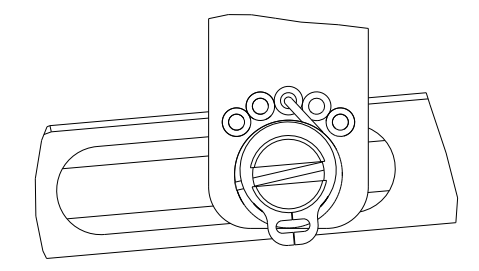
### FEED TYPE MECHANICAL



### PNEUMATIC

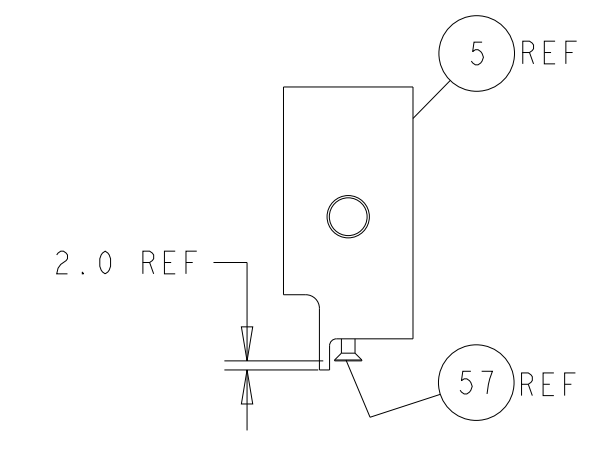
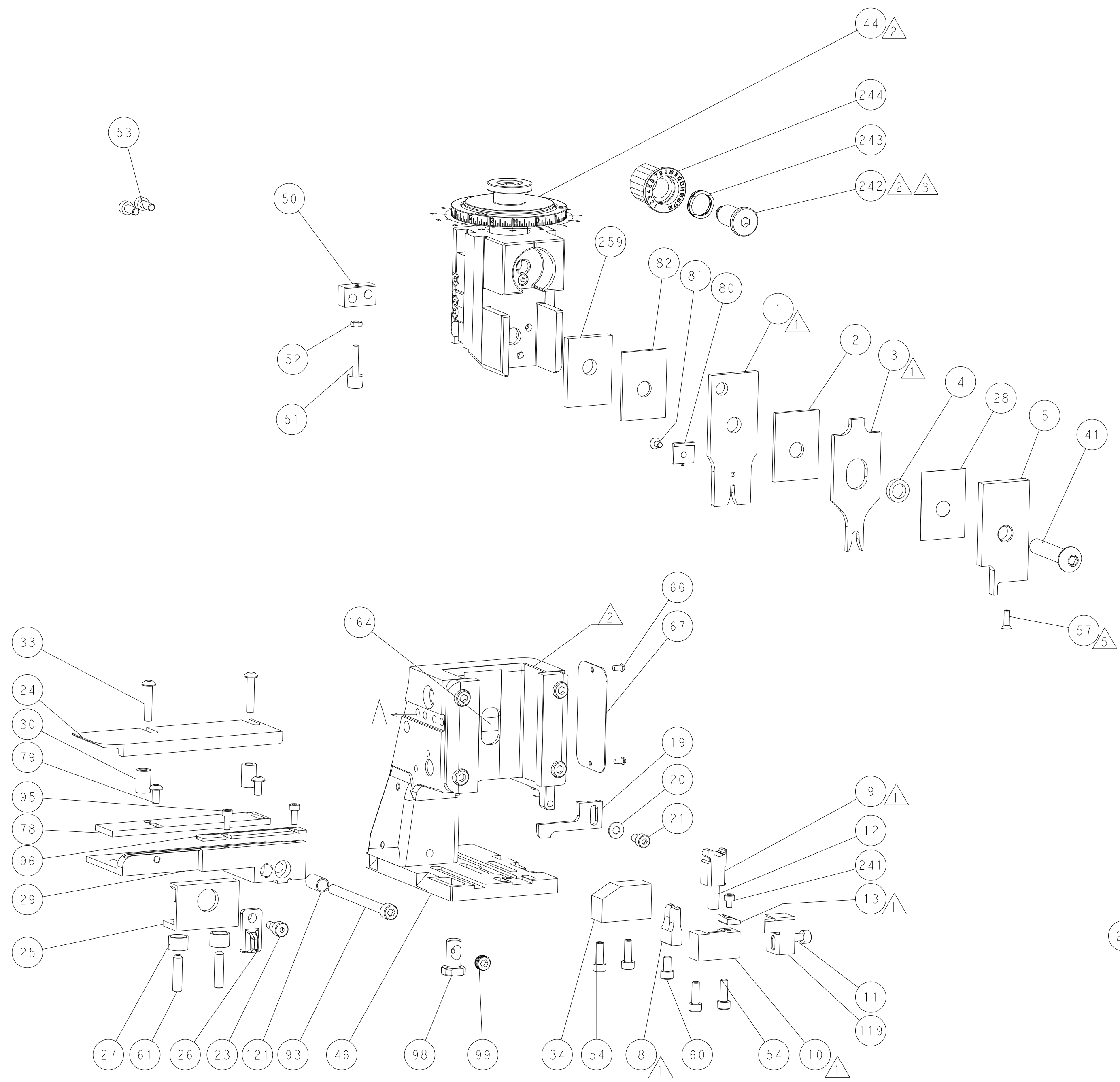
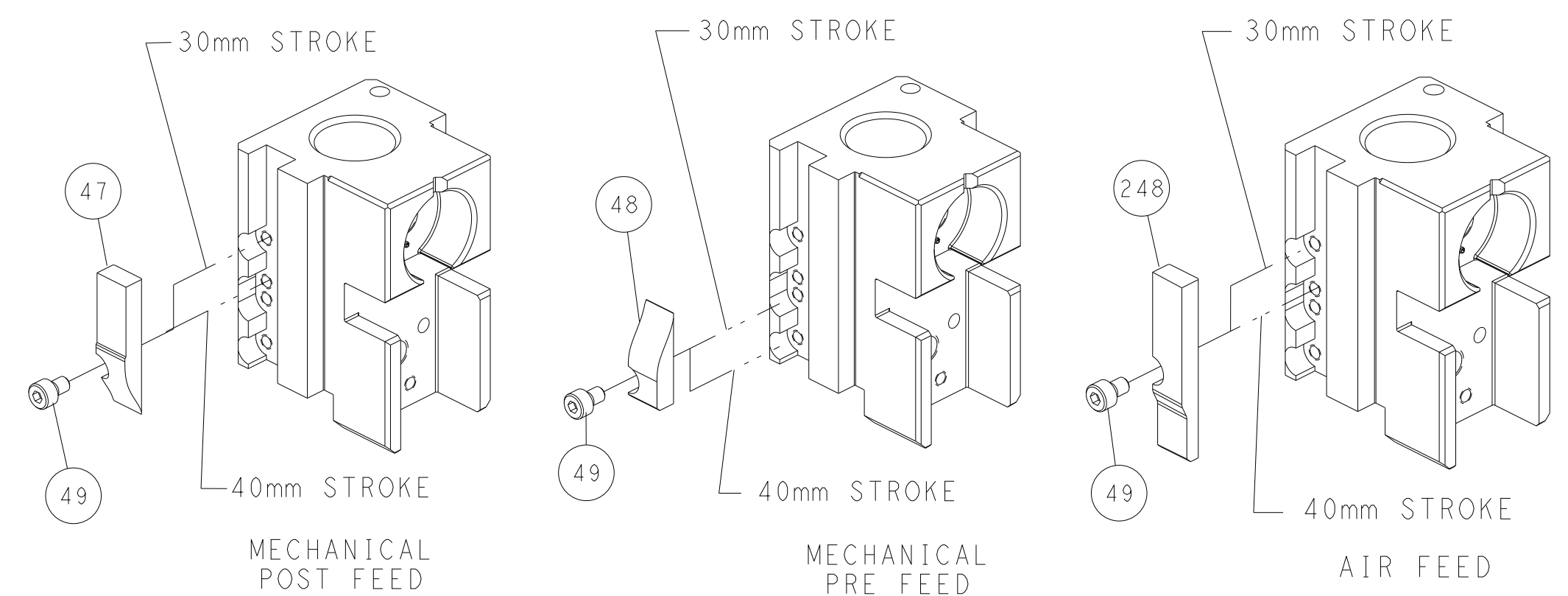


### FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)

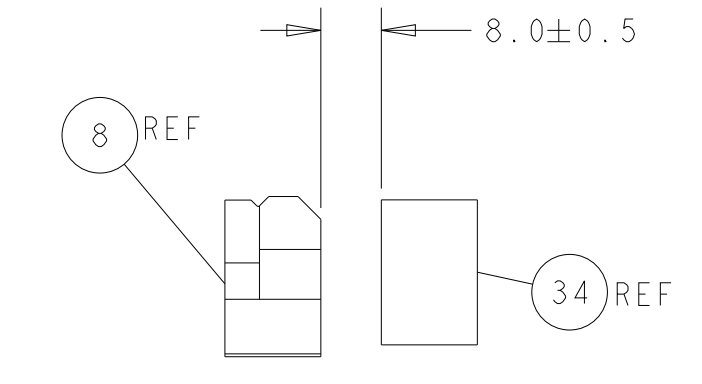


DETAIL A

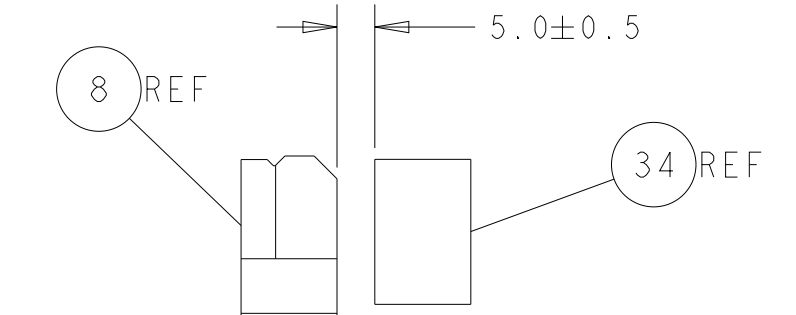
### CAM POSITIONS



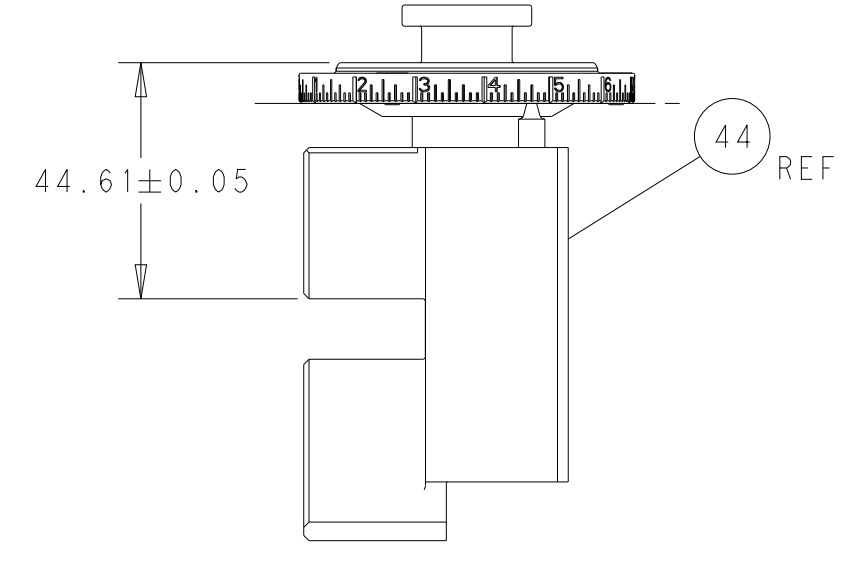
SHEAR DEPRESSOR DETAIL



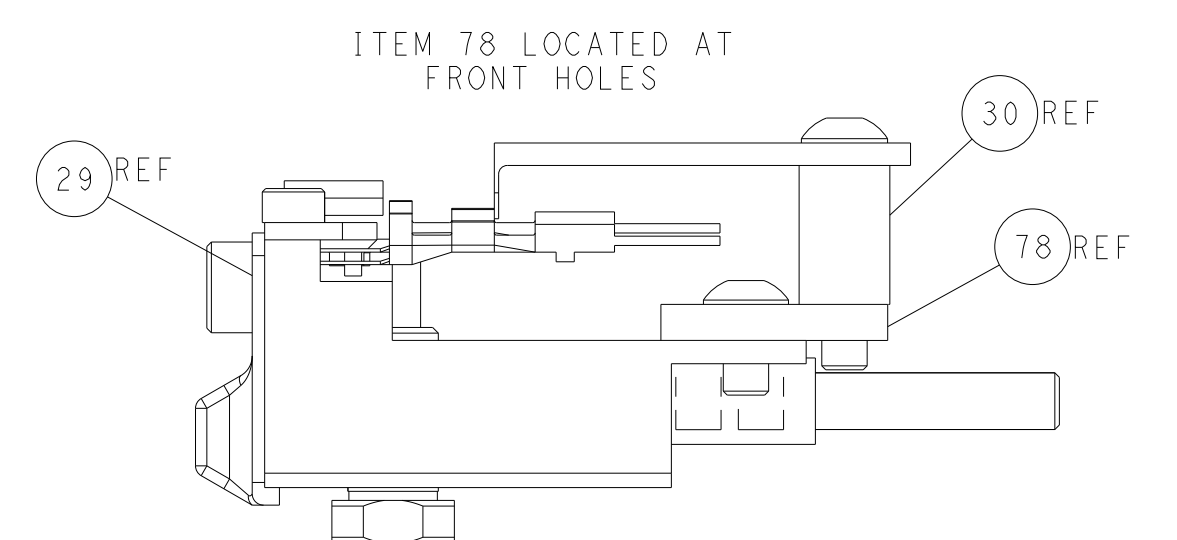
TERMINAL SUPPORT LOCATION FOR BLADE TERMINAL P/N 1326031-8



TERMINAL SUPPORT LOCATION FOR RECEPTACLE TERMINAL P/N 1326032-9



RAM SET-UP



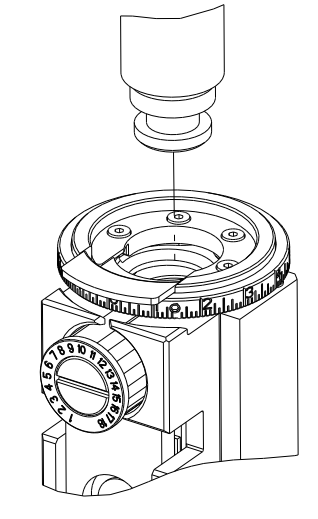
FEED TRACK POSITION GUIDE BY WIRE BARREL

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

<small>THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.</small>		DWN Y. YIN 25JUL2012 CHK G. BAILEY 25JUL2012 APVD S. XI 25JUL2012	NAME Ocean Side Feed Applicator
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH	TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH	SIZE CAGE CODE DRAWING NO A1 00779 ©=2151730	RESTRICTED TO Customer Accessible Production Drawing SCALE 1:1 SHEET 2 OF 4 REV F

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2151730-1	F	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2151730-2	F	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151730-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.03 mm [.080]	F
INSUL	4.25 mm [1.67]	O

APPLICATOR INSTRUCTIONS 408-35042

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: 2.8mm BLADE, SEALED			
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE		
5.50-5.51 mm [1.217-.217 IN]	Ø1.20-2.70 mm [1.047-.106 IN]		
TERMINAL APPLICATION SPECIFICATION	114-13013		

TERMINALS APPLIED				SEAL INSULATION DIAMETER RANGE
TE TERMINAL	TE TERMINAL	TE SEAL PN	YAZAKI PN	
1326031-8	1326032-9	1949064-1	7158-3113-40	1.2-2.7 mm
		1949064-2	7158-3112-70	1.2-2.7 mm

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
18 AWG	1.37+/-0.05 [1.054+/-0.002]	4.1
1.00mm2	1.30+/-0.05 [1.051+/-0.002]	4.9
0.75mm2	1.22+/-0.05 [1.048+/-0.002]	6.0

- 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 APPLY TORQ-SEAL IN ALLEN SOCKET TO FILL HOLE AFTER FLAT HD HAS BEEN ADJUSTED TO CORRECT HEIGHT AT QUALIFICATION. APPLY #1-23419-5 LOC-TITE TO THREADS.
6. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.

ENTRY LEVEL APPLICATOR		ITEM SUBSTITUTION LIST		
PART NUMBER	SAME AS	ITEM	ITEM DESCRIPTION	SUBSTITUTE PART NUMBER
8-2151730-1	2151730-1	1	WIRE CRIMPER	1-2370389-7
8-2151730-2	2151730-2	3	INSULATION CRIMPER	6-1803604-2
9-2151730-1	2-2151730-1	46	BASIC SUB -ASSEMBLY	1803940-9
9-2151730-2	2-2151730-2	141	BASIC SUB -ASSEMBLY	1-1803940-0
			LUBRICATOR	DELETE

**\*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)

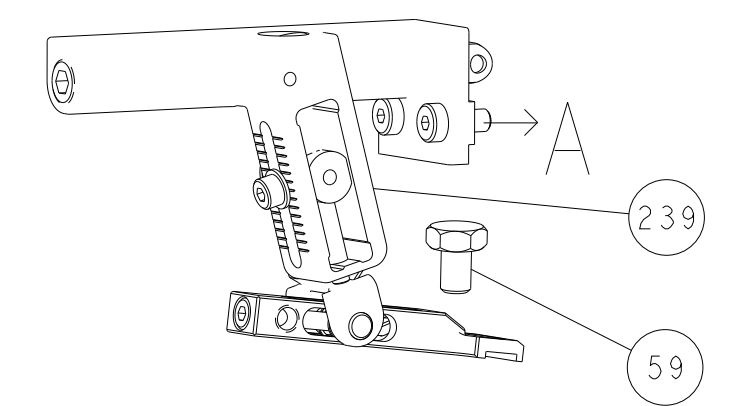
LOC	DIST	REVISIONS					
A	66	P	LTN	DESCRIPTION	DATE	OWN	APVD
-	-	-	-	SEE SHEET 1	-	-	-

-	1	1	2-455888-9	SPACER, CRIMPER	259
-	1	1	2119082-7	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	-	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	1803516-2	RAM ASSEMBLY, SF PACIFIC	140
-	1	1	1-22281-8	SPRING, COMPRESSION	121
-	1	1	318563-1	GUARD, FRONT CHIP	119
-	1	1	2844908-1	SCREW, LOCKING	99
-	1	1	2844907-1	POST, LOCKING	98
-	1	1	1-690438-0	FRONT STRIP GUIDE	96
-	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	95
-	1	1	2168083-6	SCR, SKT HD CAP, RoHS, M5 X 6.5	93
-	1	1	1-455888-7	SPACER, CRIMPER	82
-	1	1	985575-1	SCR, FLT SKT HD CAP M3 X 6.0	81
-	1	1	224405-2	DEPRESSOR, WIRE	80
-	2	2	18024-6	SCR, BTN SKT HD CAP (M4 X 8.0)	79
-	1	1	1803096-1	EXTENSION PLATE	78
-	1	1	1803607-3	DOCUMENTATION PACKAGE	71
-	1	1	2119740-1	TAG, IDENTIFICATION	67
-	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	2	2	2-18032-5	SCR, SET, FLT PNT, M5 X 20.0	61
-	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	1	1	985575-3	SCR, FLT SKT HD CAP M3 X 10.0	57
-	1	1	1338685-1	PAWL, FEED	56
-	2	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	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	1803602-2	SCR, BHSC, RoHS (M8 X 40)	41
-	1	1	2-1752356-0	SUPPORT, TERMINAL	34
-	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	1-2844962-8	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	2844938-5	PLATE, STRIP GUIDE	29
-	1	1	455888-3	SPACER, CRIMPER	28
-	2	2	22283-1	SPRING, COMPRESSION	27
-	1	1	356835-1	LEVER, DRAG RELEASE	26
-	1	1	240792-2	DRAG, TERMINAL	25
-	1	1	1320928-6	STRIP GUIDE	24
-	1	1	980371-4	SCR, SKT HD SHLDR 5.0 DIA X 6.0	23
-	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	2119533-2	STRIPPER, SIDE FEED	19
-	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	1-1633927-6	ANVIL, COMBINATION	8
-	-	-	-	-	7
-	-	-	-	-	6
-	1	1	2119781-1	DEPRESSOR, SHEAR	5
-	1	1	2-238011-1	BLOCK, CRIMPER SPACER	4
-	1	1	6-2119784-2	CRIMPER, INSULATION O PREMIUM	3
-	1	1	1-455888-9	SPACER, CRIMPER	2
-	1	1	1-856313-7	CRIMPER, WIRE	1

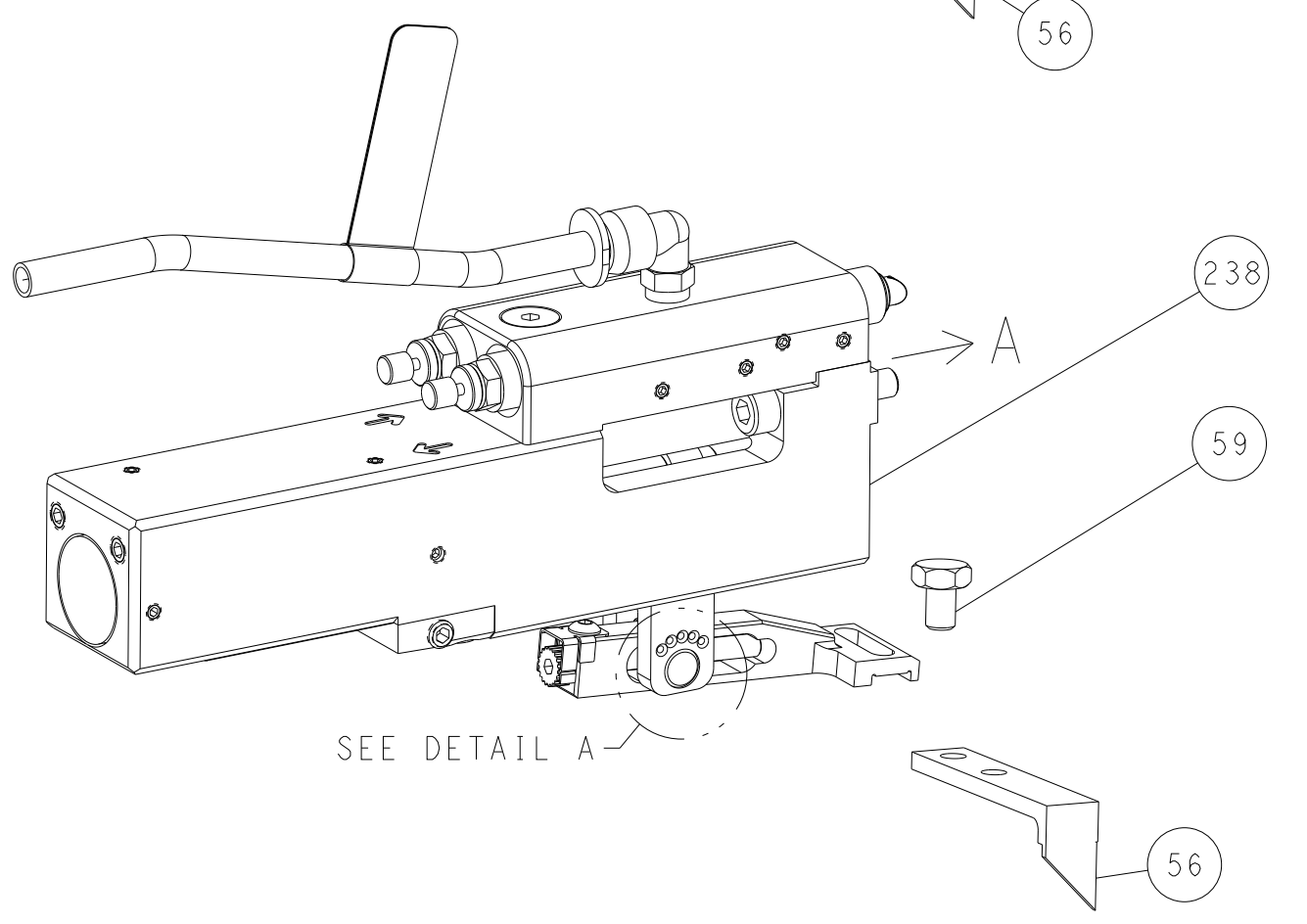
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG: Y. YIN 25JUL2012		CHK: G. BAILEY 25JUL2012		NAME: Ocean Side Feed Applicator	
0 PLC ±		1 PLC ±		APVD: S. XI 25JUL2012		PRODUCT SPEC: -		SIZE: A1	
2 PLC ±		3 PLC ±		APPLICATION SPEC: -		CAGE CODE: 00779		DRAWING NO: 2151730	
4 PLC ±		ANGLES: -		WEIGHT: -		SCALE: 1:2		SHEET 3 OF 4	
MATERIAL: -		FINISH: -		RESTRICTED TO: -		Customer Accessible Production Drawing		REV: F	

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

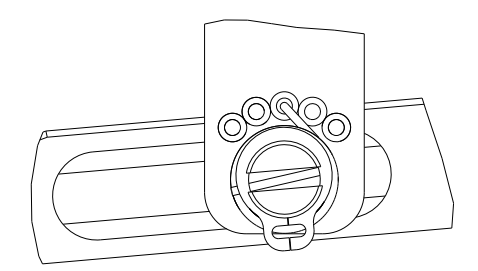
# FEED TYPE MECHANICAL



## PNEUMATIC

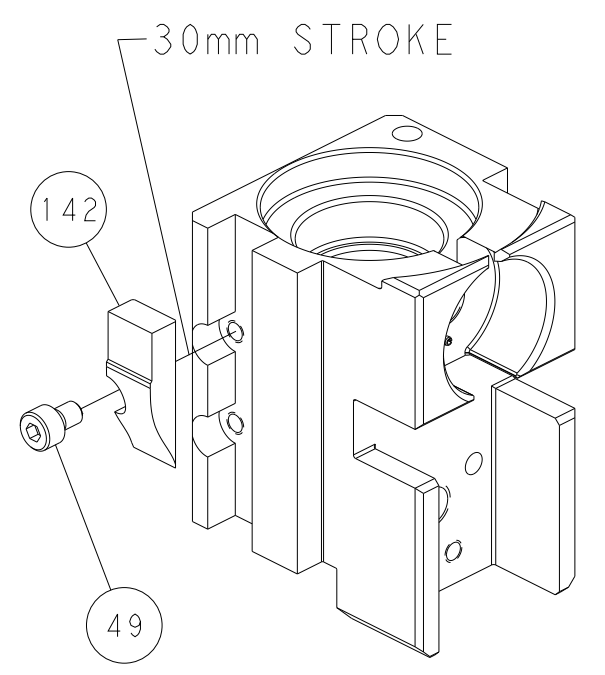


FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)

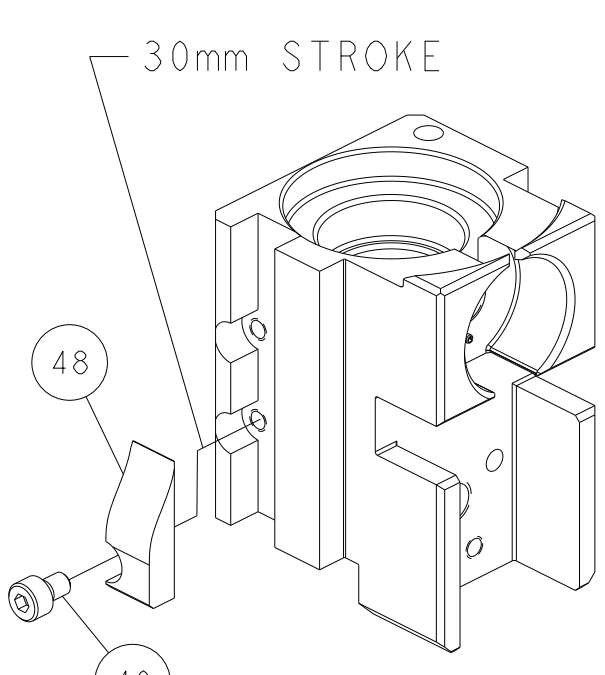


DETAIL A

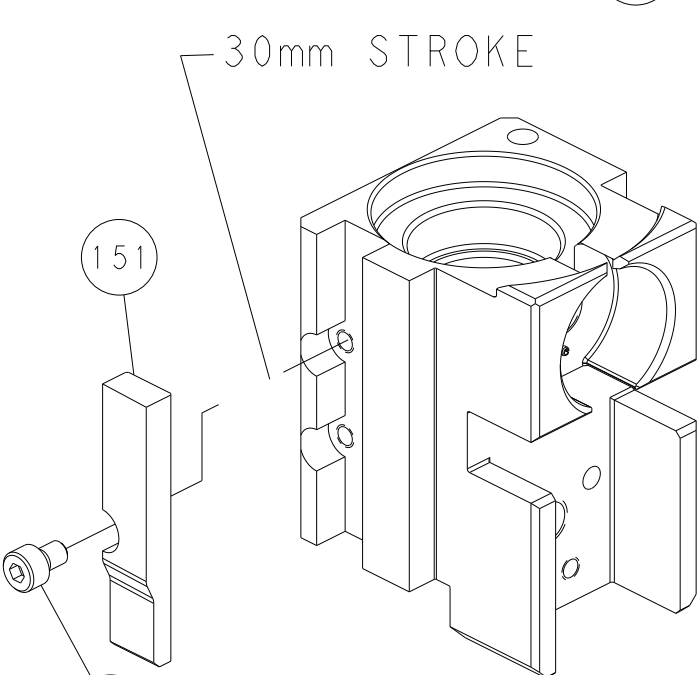
## CAM POSITIONS



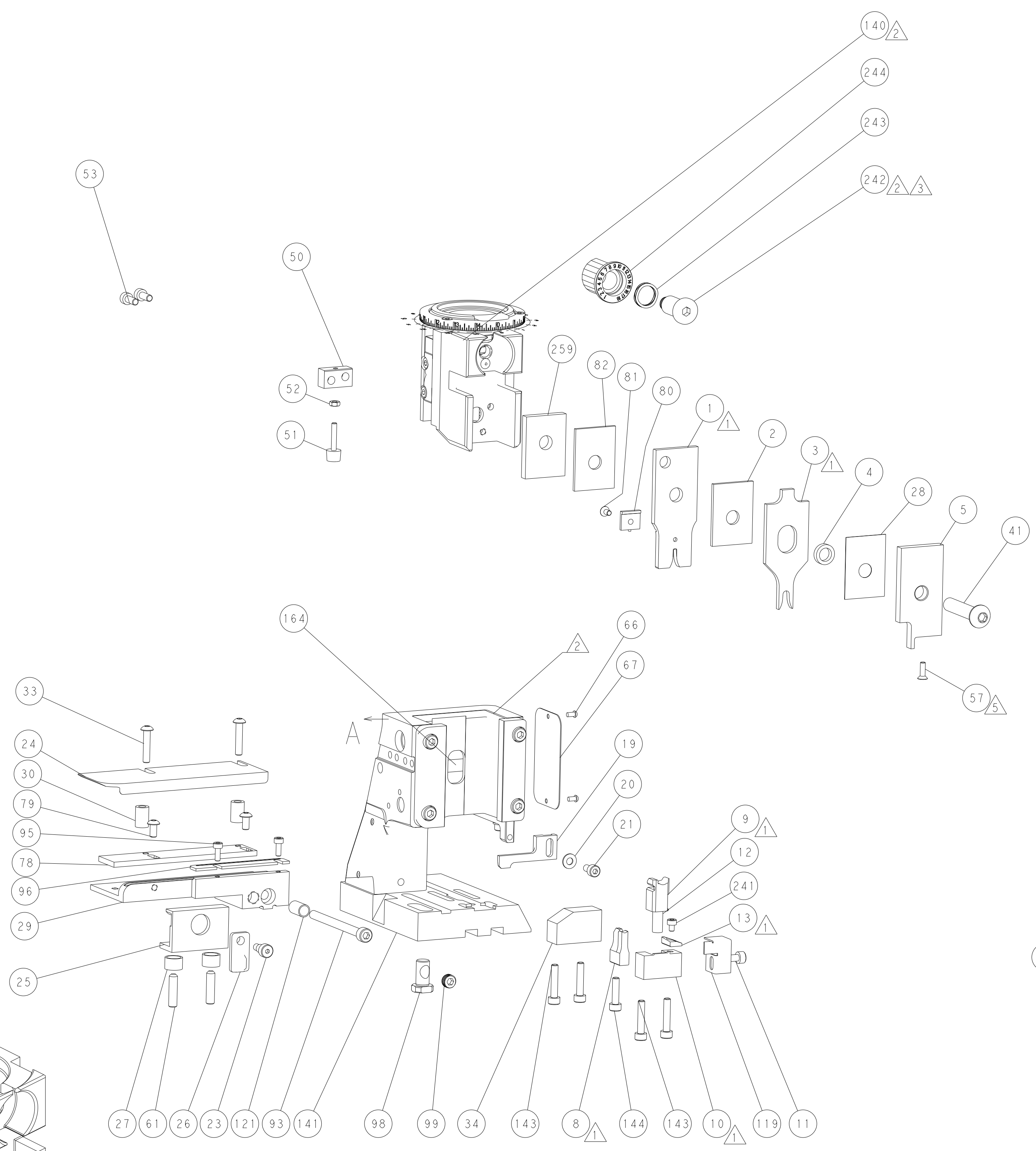
MECHANICAL POST FEED



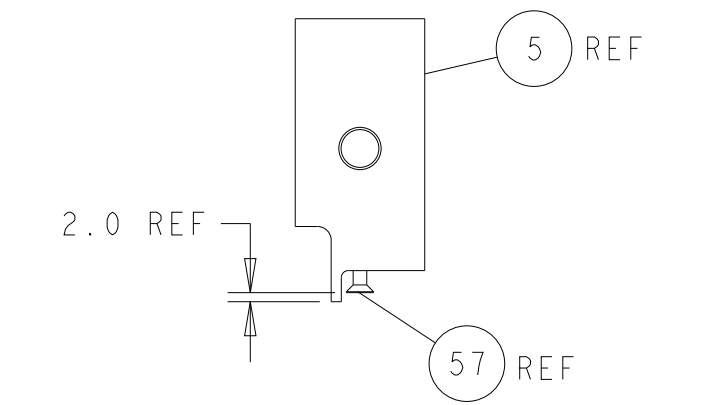
MECHANICAL PRE FEED



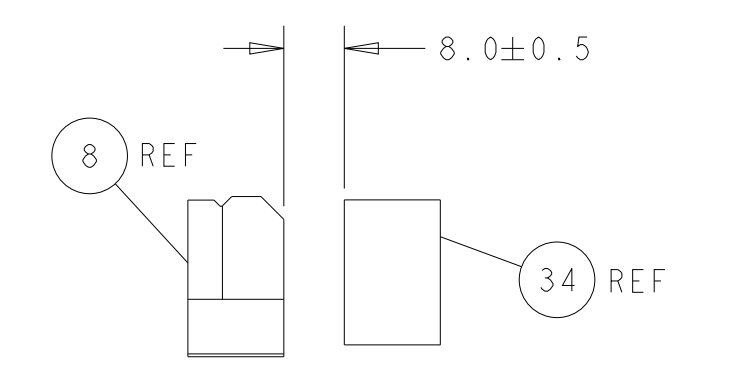
AIR FEED



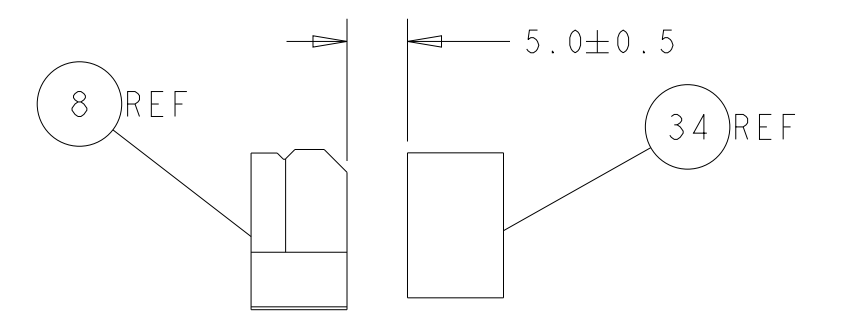
**PACIFIC VERSION**  
 Shown on sheets 3 of 4 & 4 of 4  
 (Atlantic version shown on sheets 1 of 4 & 2 of 4)



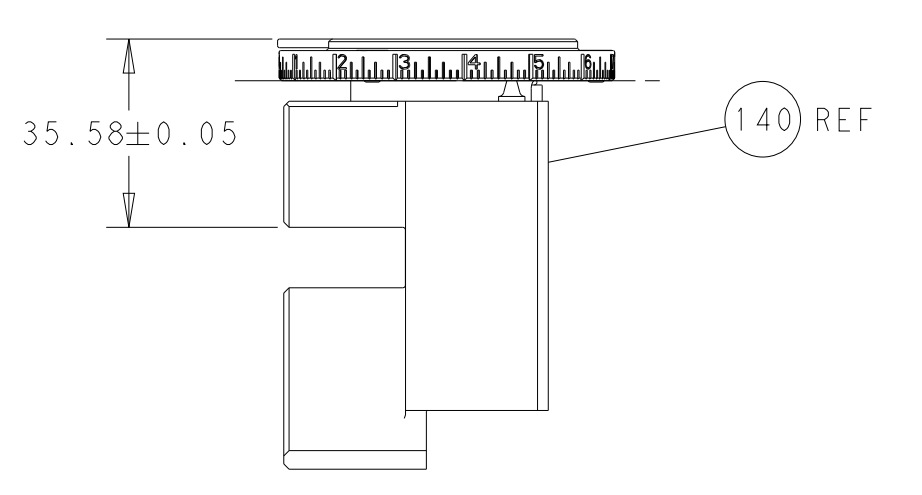
SHEAR DEPRESSOR DETAIL



TERMINAL SUPPORT LOCATION FOR BLADE TERMINAL P/N 1326031-8

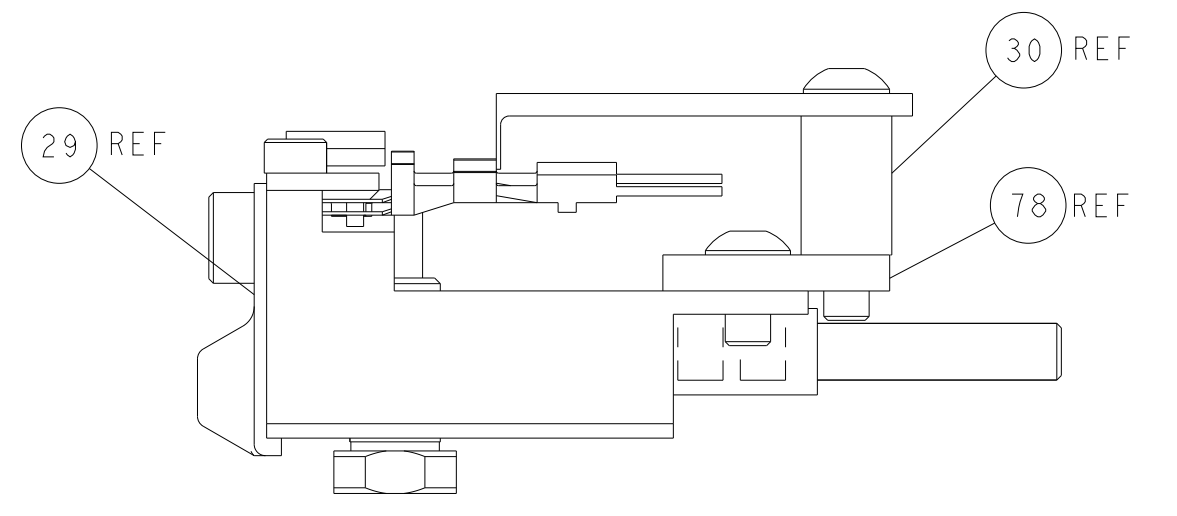


TERMINAL SUPPORT LOCATION FOR RECEPTACLE TERMINAL P/N 1326032-9



RAM SET-UP

ITEM 78 LOCATED AT FRONT HOLES



FEED TRACK POSITION GUIDE BY WIRE BARREL

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG Y. YIN 25JUL2012		TE Connectivity	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	5 PLC ±	Harrisburg, PA 17105-3608
	ANGLES	FINISH		CHK G. BAILEY 25JUL2012	NAME	SIZE	CAGE CODE
				APVD S. XI 25JUL2012	Ocean Side Feed	A1	00779
MATERIAL				PRODUCT SPEC	APPLICATOR	SCALE	1:1
				APPLICATOR SPEC	Customer Accessible Production Drawing	SHEET	4 of 4
				WEIGHT	©=2151730	REV	F