

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151085-1	E	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2151085-2	E	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151085-1	E	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2151085-2	E	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2151085-7	B	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.16 mm [.046]	F
INSUL	1.70 mm [.067]	F

APPLICATOR INSTRUCTIONS 408-35042

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: 2.5mm SIGNAL DBL LOCK REC. CONT. (M)			
WIRE STRIP LENGTH 2.20-2.80 mm [.087-.110 IN]		INSULATION DIAMETER RANGE Ø0.93-1.50 mm [.037-.059 IN]	
TERMINAL APPLICATION SPECIFICATION	114-5203	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
917765-1	917765-2	917684-1	917684-2
5-917684-1	2232575-1	2232576-1	

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
22 AWG OR 0.34mm2	0.82+/-0.05 [.032+/-0.002]	8.6
24 AWG OR 0.22mm2	0.75+/-0.05 [.030+/-0.002]	9.3
26 AWG OR 0.14mm2	0.69+/-0.05 [.027+/-0.002]	9.8

- 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. USE ITEM 34 TERMINAL SUPPORT FOR RECEPTACLE STYLE TERMINALS (917684 & 2232576). USE ITEM 286 TERMINAL SUPPORT FOR PIN STYLE TERMINALS (917765).

**\*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.

LOC	DIST	REVISIONS					
A	66	P	LTN	DESCRIPTION	DATE	OWN	APVD
		C3		ECR-18-004650	28MAR2018	MZ	SJ
		D		ECR-18-008394	31MAY2018	VLA	JDG
		D1		ECR-19-006895	09MAY2019	MZ	YY
		E		ECR-20-016746	24NOV2020	TB	RK

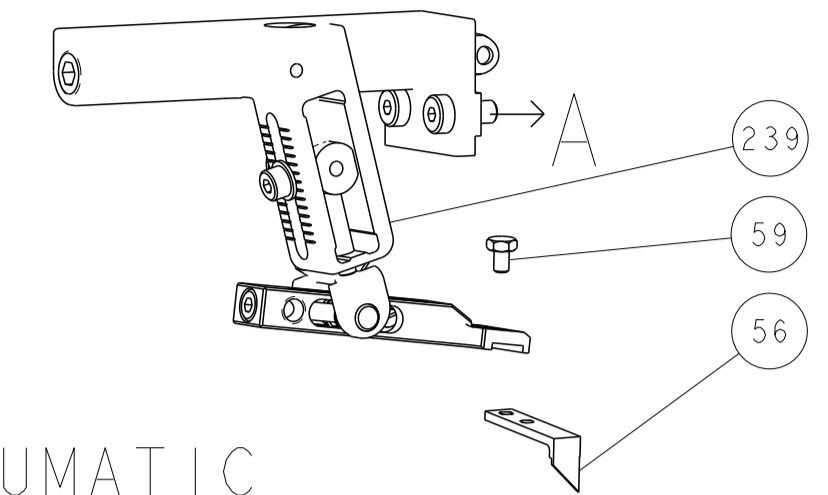
6	-	1	1	1	1	1752356-2	SUPPORT, TERMINAL	286
	-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248
	-	1	1	1	1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244
	-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
3	-	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
	-	1	1	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
	-	-	1	-	-	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	1-18028-2	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	1803607-3	DOCUMENTATION PACKAGE	71
	-	1	1	1	1	2119791-9	DEPRESSOR, WIRE	70
	-	1	1	1	1	2119943-1	WASHER, SPACER	69
	-	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	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	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	-	-	2119652-1	FEED CAM, PRE FEED	48
	-	-	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
6	-	1	1	1	1	2-1752356-7	SUPPORT, TERMINAL	34
	-	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
	-	2	2	2	2	2-2844962-4	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	1320928-2	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	2119533-3	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
1	-	1	1	1	1	1803095-1	FLOATING SHEAR, FRONT	9
1	-	2	2	1	1	1633927-2	ANVIL, COMBINATION	8
	-	1	1	1	1	2119757-8	DEPRESSOR, SHEAR	5
	-	1	1	1	1	2-238011-0	BLOCK, CRIMPER SPACER	4
1	-	1	2	2	1	1633961-6	CRIMPER, INSULATION F PREMIUM	3
	-	1	1	1	1	455888-4	SPACER, CRIMPER	2
1	-	1	2	2	1	234156-2	CRIMPER, WIRE	1

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

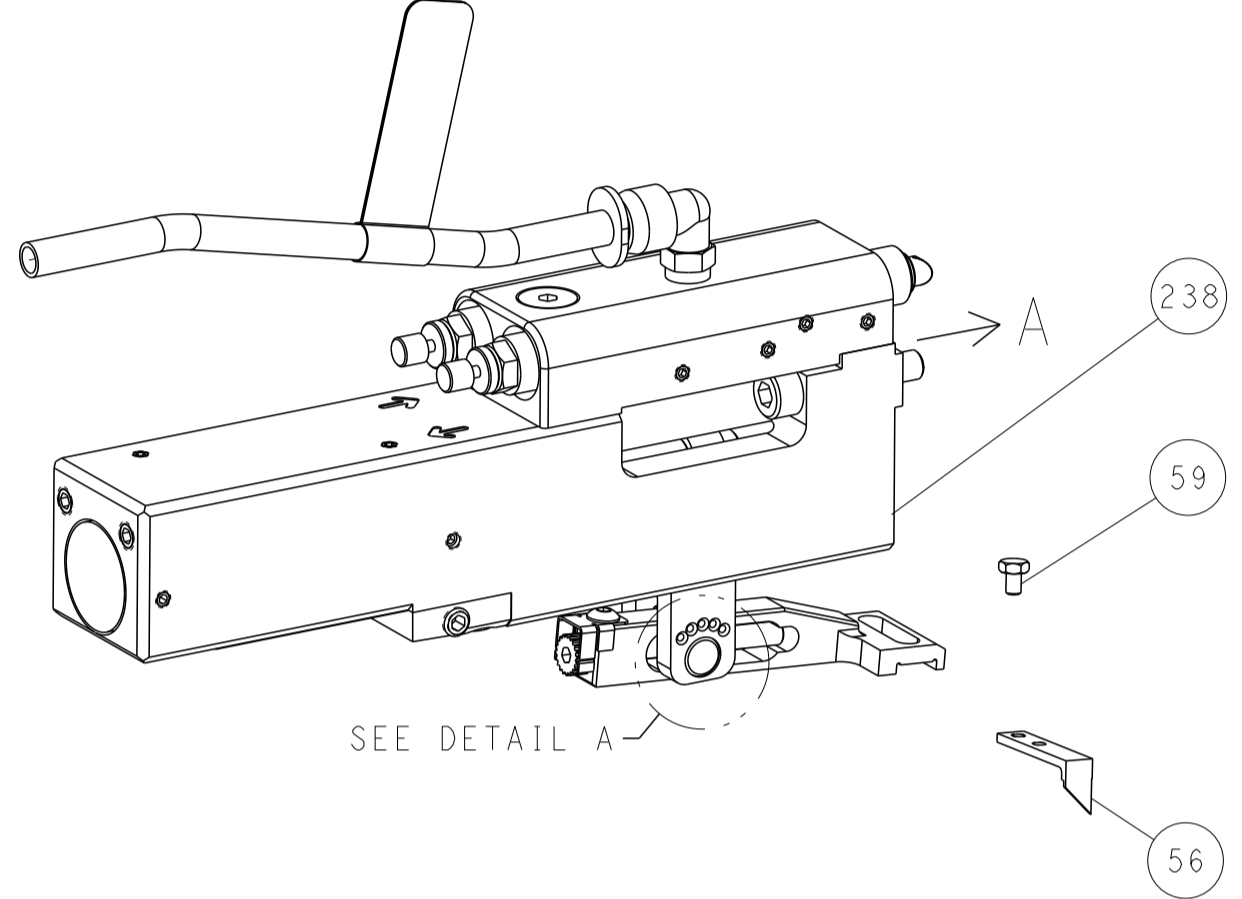
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mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	NAME Ocean Side Feed Applicator	
MATERIAL:		FINISH:		APVD S. XI 22FEB2011		SIZE CAGE CODE DRAWING NO RESTRICTED TO	
				WEIGHT		A1 00779 C=2151085	
CUSTOMER DRAWING				SCALE 1:2		SHEET 1 OF 4 REV E	

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

# FEED TYPE MECHANICAL



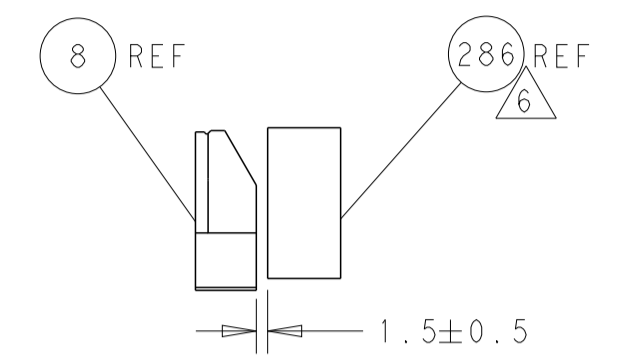
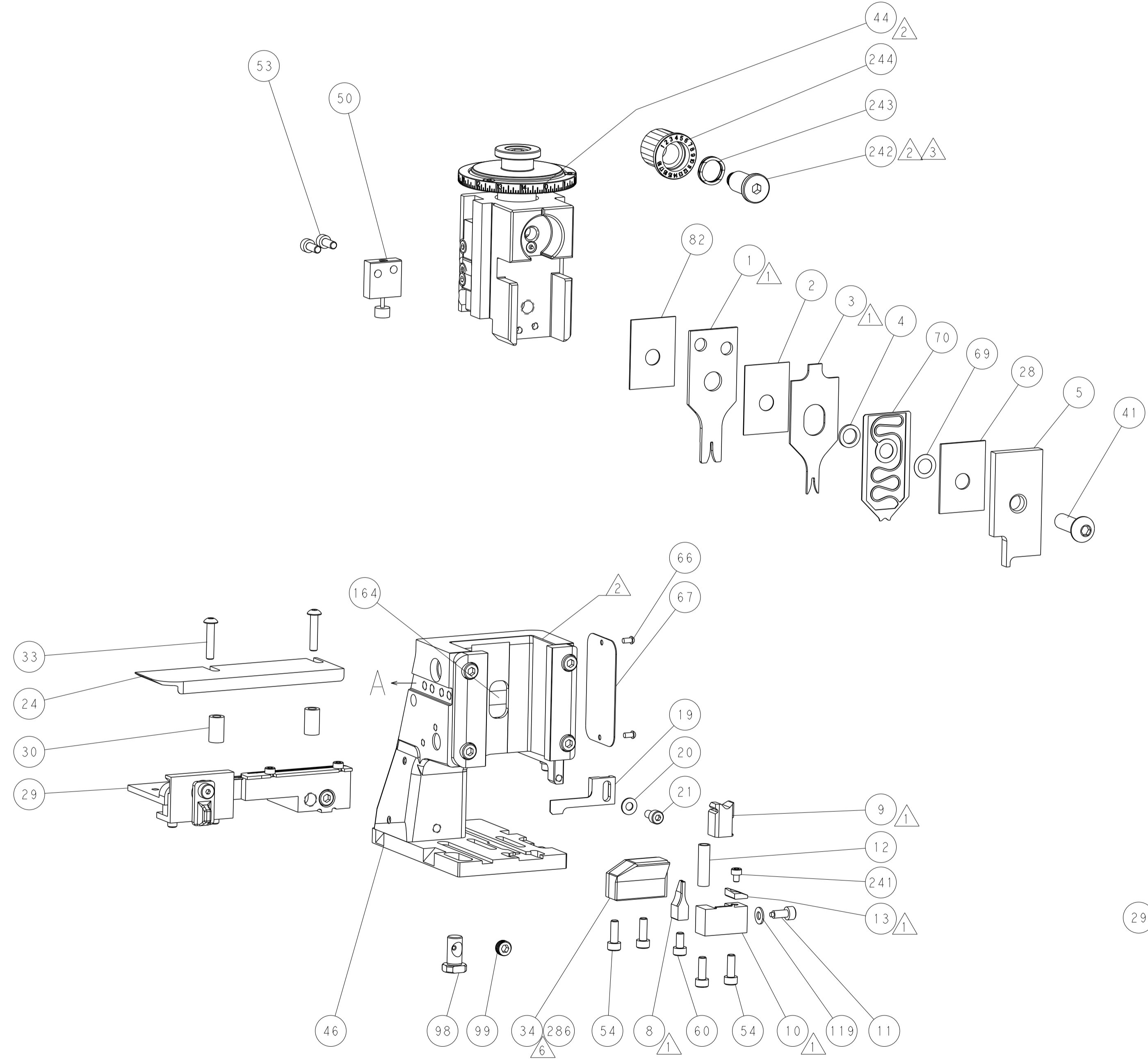
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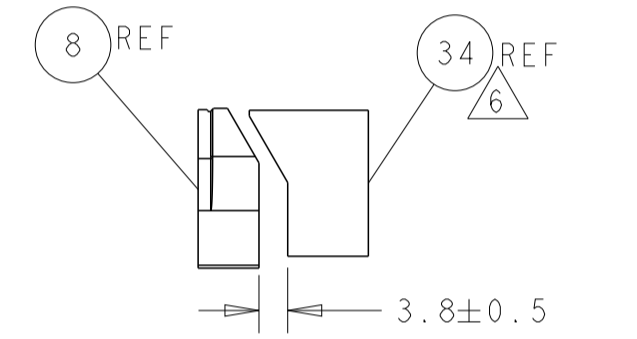
### FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



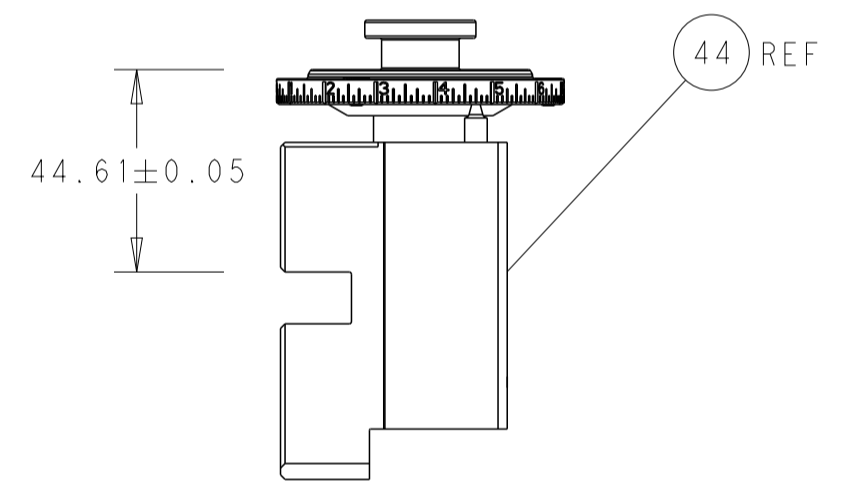
DETAIL A



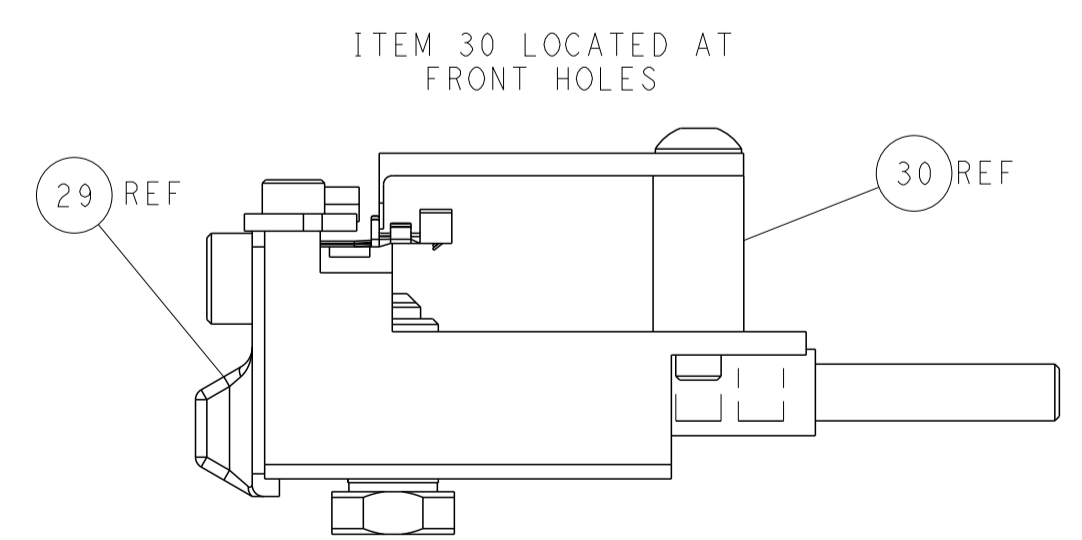
TERMINAL SUPPORT LOCATION FOR PIN STYLE TERMINALS



TERMINAL SUPPORT LOCATION FOR RECEPTACLE STYLE TERMINALS

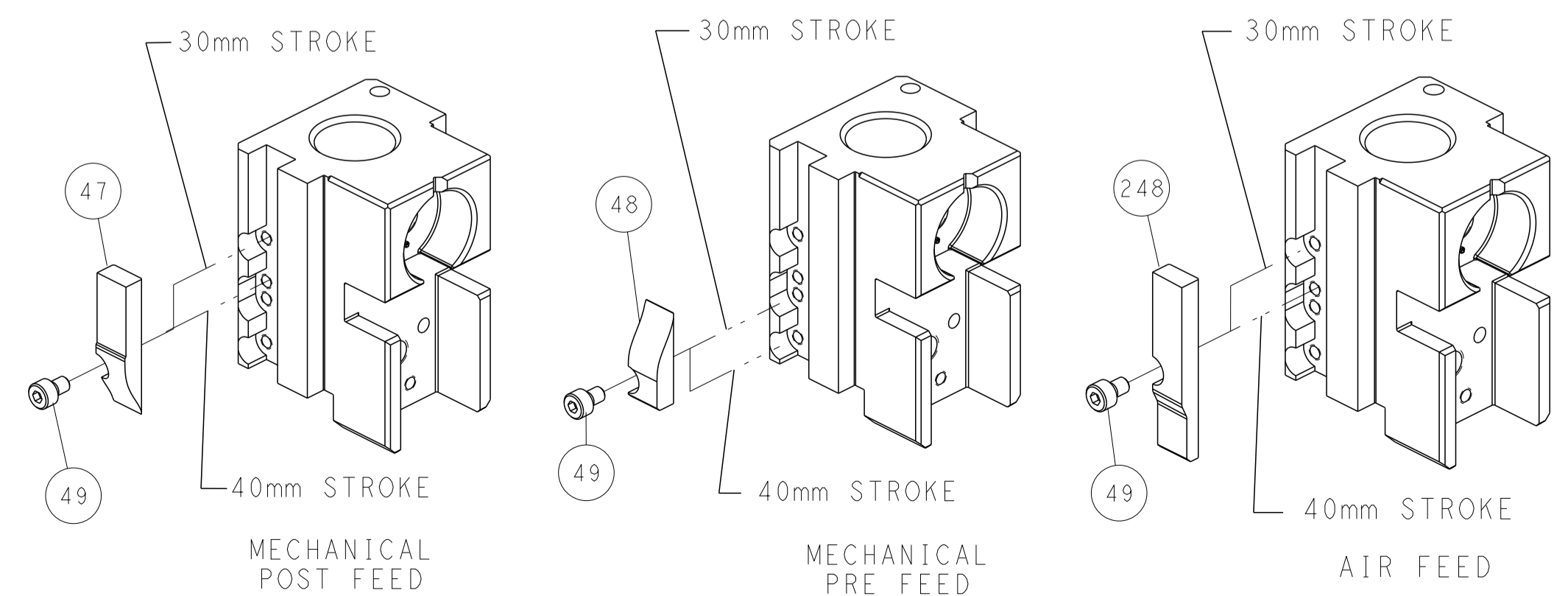


RAM SET-UP



ITEM 30 LOCATED AT FRONT HOLES

## CAM POSITIONS



**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 S_ZOU 22FEB2011 CHK T_ELBIN 22FEB2011 APVD S_XI 22FEB2011	TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ° ± FINISH		NAME Ocean Side Feed Applicator PRODUCT SPEC APPLICATION SPEC SIZE CAGE CODE DRAWING NO. A1 00779 C=2151085 WEIGHT CUSTOMER DRAWING	RESTRICTED TO SCALE 1:2 SHEET 2 OF 4 REV E

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2151085-1	E	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2151085-2	E	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151085-7	B	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR  
 INTERFACE ADAPTER

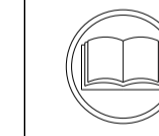


APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.16 mm [.046]	F
INSUL	1.70 mm [.067]	F

APPLICATOR INSTRUCTIONS  
 408-35042

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: 2.5mm SIGNAL DBL LOCK REC. CONT. (M)			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
2.20-2.80 mm [.087-.110 IN]		∅0.93-1.50 mm [.037-.059 IN]	
TERMINAL APPLICATION SPECIFICATION	114-5203	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
917765-1	917765-2	917684-1	917684-2
5-917684-1	2232575-1	2232576-1	

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
22 AWG OR 0.34mm2	0.82+/-0.05 [.032+/-0.002]	8.6
24 AWG OR 0.22mm2	0.75+/-0.05 [.030+/-0.002]	9.3
26 AWG OR 0.14mm2	0.69+/-0.05 [.027+/-0.002]	9.8



- 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 USE ITEM 34 TERMINAL SUPPORT FOR RECEPTACLE STYLE TERMINALS (917684 & 2232576). USE ITEM 286 TERMINAL SUPPORT FOR PIN STYLE TERMINALS (917765).

**\*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.

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

6	-	1	1	1752356-2	SUPPORT, TERMINAL	286
-	-	1	1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
3	-	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	1803516-1	RAM ASSEMBLY, SF PACIFIC	140
-	-	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	1803607-3	DOCUMENTATION PACKAGE	71
-	-	1	1	2119791-9	DEPRESSOR, WIRE	70
-	-	1	1	2119943-1	WASHER, SPACER	69
-	-	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	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	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
6	-	1	1	2-1752356-7	SUPPORT, TERMINAL	34
-	-	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	-	2	2	2-2844962-4	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	-	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29
-	-	1	1	1-455888-0	SPACER, CRIMPER	28
-	-	1	1	1320928-2	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	2119533-3	STRIPPER, SIDE FEED	19
6	-	1	1	2119806-1	INSERT, SHEAR	13
-	-	1	1	3-22280-3	SPRING, COMPRESSION	12
-	-	1	1	1-356885-4	STOP, SHEAR	11
6	-	1	1	2119805-1	SHEAR HOLDER, FRONT	10
6	-	1	1	1803095-1	FLOATING SHEAR, FRONT	9
6	1	1	1	1633927-2	ANVIL, COMBINATION	8
-	-	1	1	2119757-8	DEPRESSOR, SHEAR	5
-	-	1	1	2-238011-0	BLOCK, CRIMPER SPACER	4
6	1	1	1	1633961-6	CRIMPER, INSULATION F PREMIUM	3
-	-	1	1	455888-4	SPACER, CRIMPER	2
6	1	1	1	234156-2	CRIMPER, WIRE	1

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		MATERIAL:		FINISH:	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES ±	FINISH ±

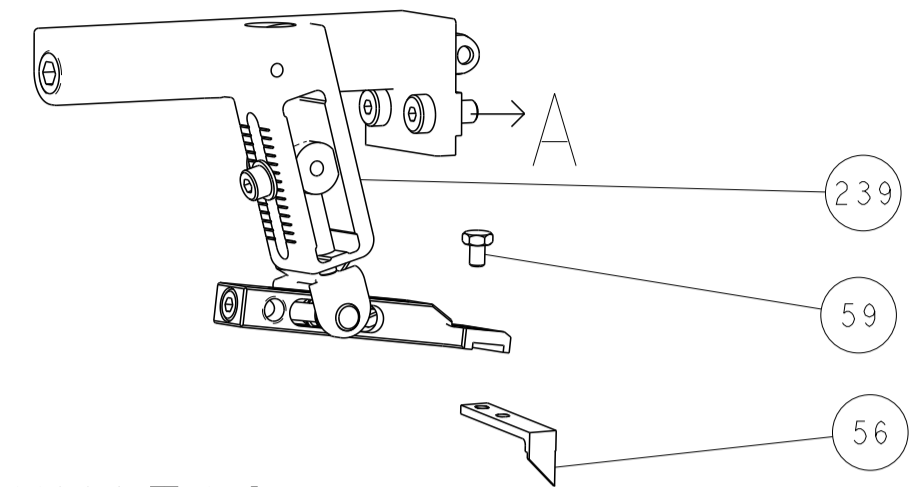
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CHK	T. ELBIN	22FEB2011
APVD	S. XI	22FEB2011
PRODUCT SPEC		
APPLICATION SPEC		
WEIGHT		
CUSTOMER DRAWING		

NAME	Ocean Side Feed Applicator		
SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
A1	00779	2151085	
SCALE	1:2	SHEET 3 OF 4	REV E

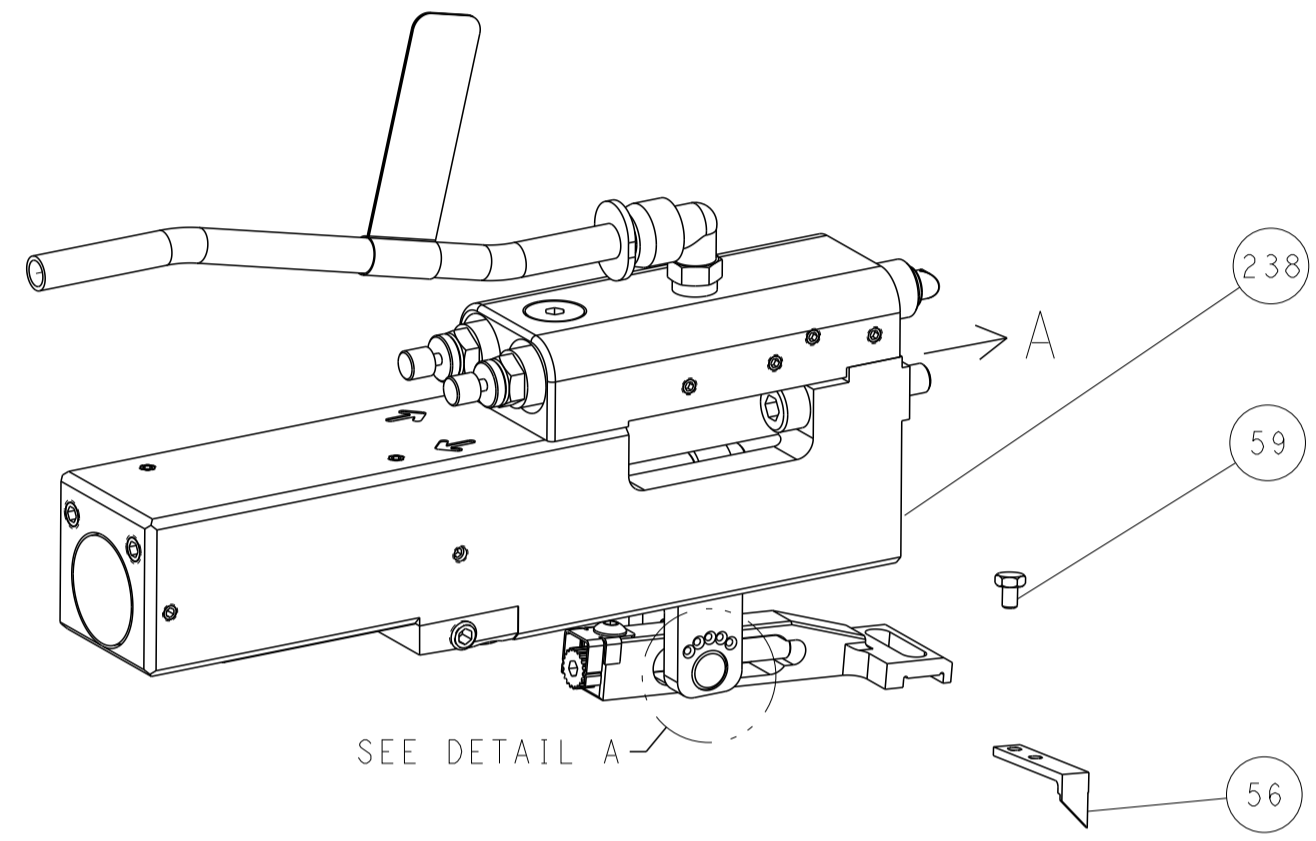
PACIFIC VERSION  
 Shown on sheets 3 of 4 & 4 of 4  
 (Atlantic version shown on sheets 1 of 4 & 2 of 4)

LOC	DIST	REVISIONS			
A	66	REV	DATE	BY	APPV
-	SEE SHEET 1	-	-	-	-

# FEED TYPE MECHANICAL



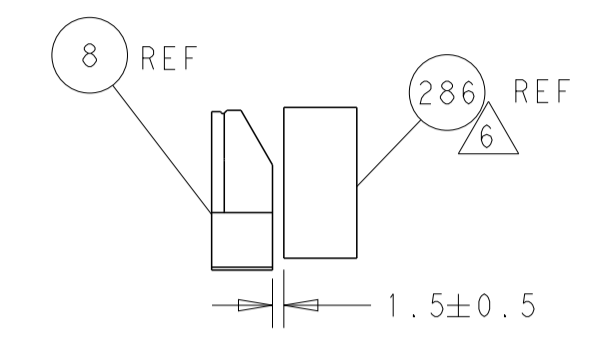
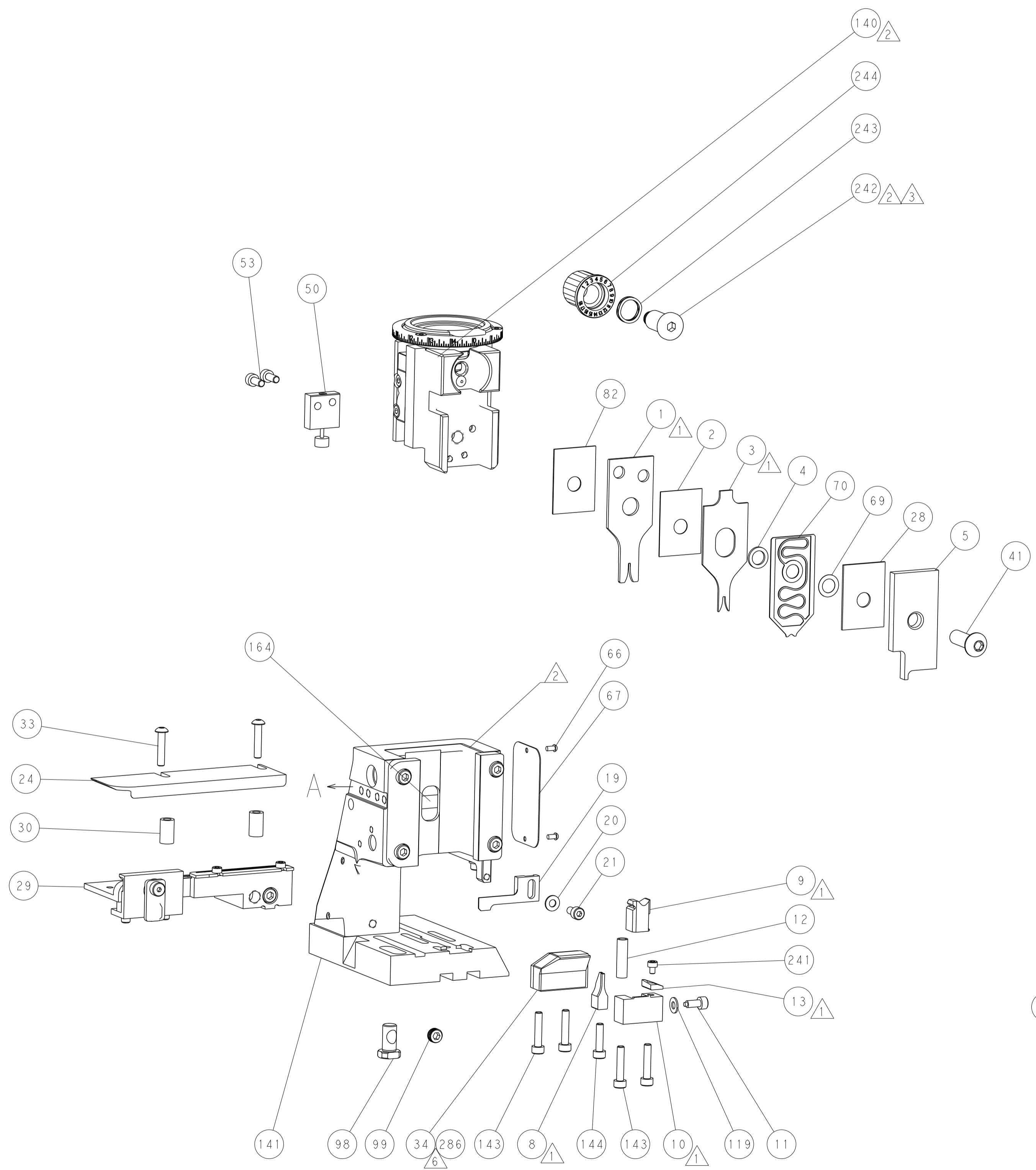
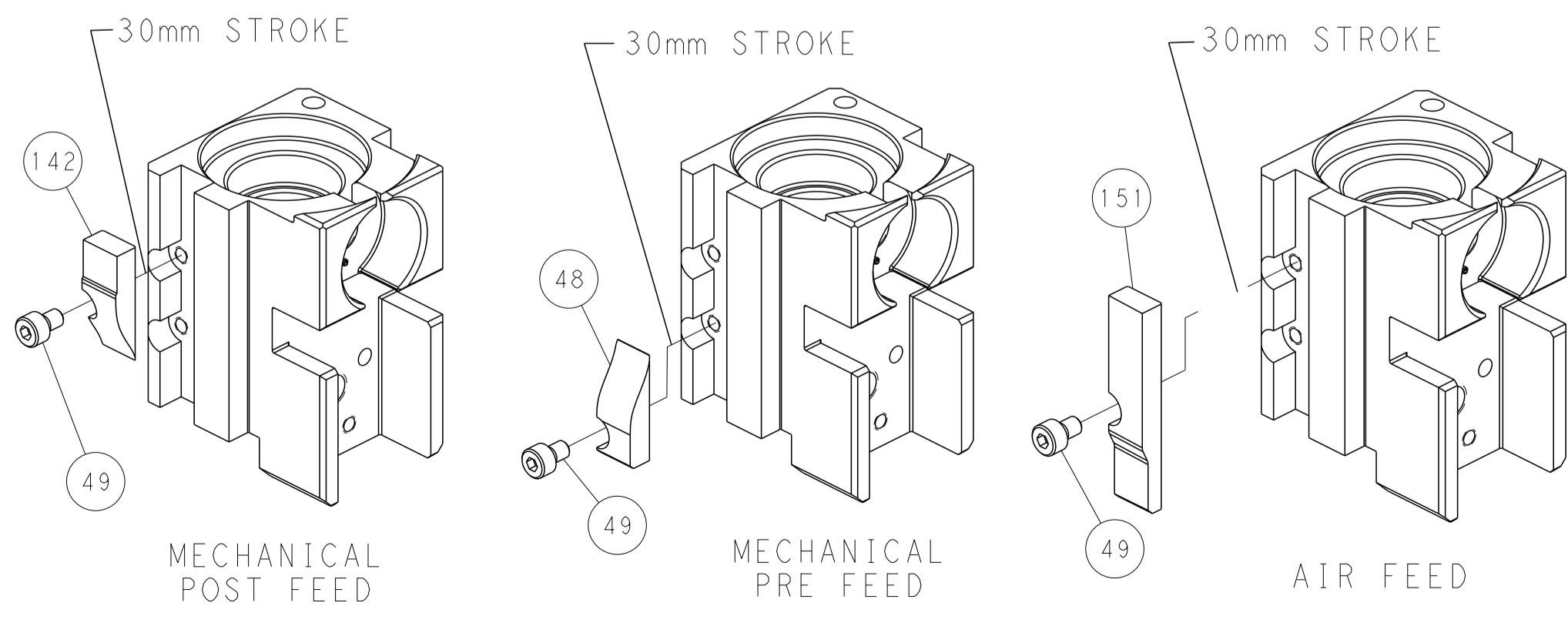
## PNEUMATIC



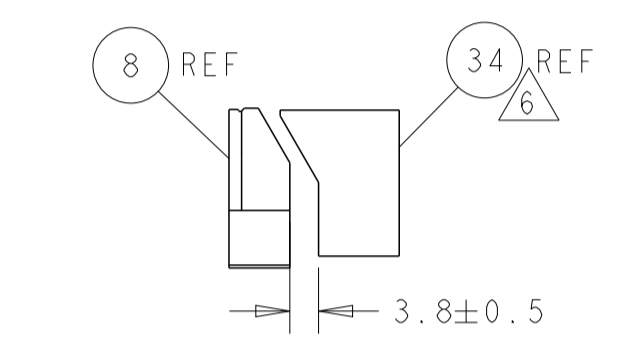
## FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



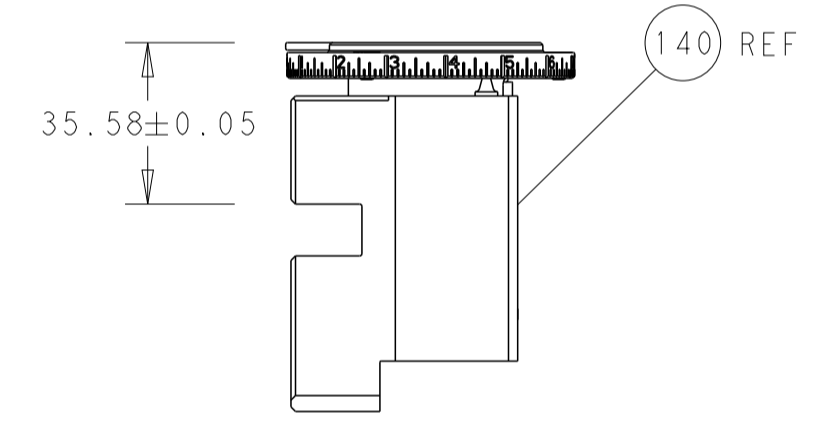
# CAM POSITIONS



TERMINAL SUPPORT LOCATION FOR PIN STYLE TERMINALS

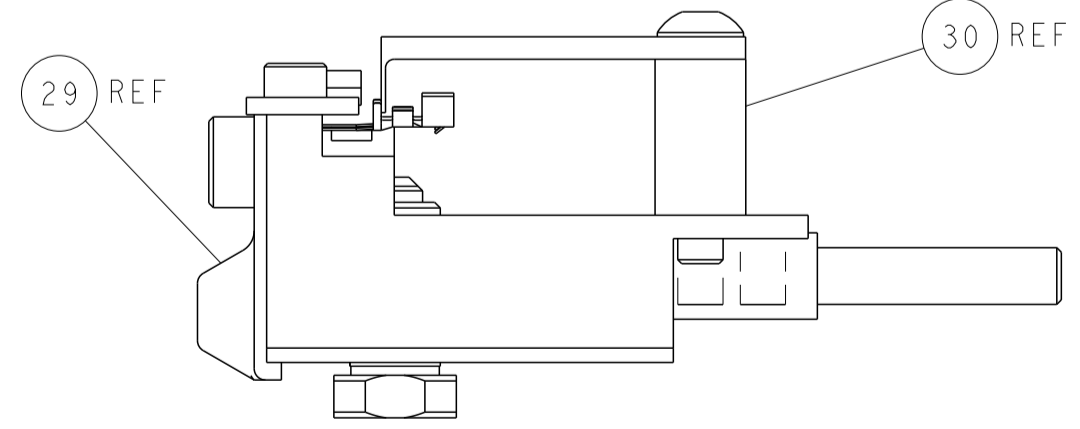


TERMINAL SUPPORT LOCATION FOR RECEPTACLE STYLE TERMINALS



RAM SET-UP

ITEM 30 LOCATED AT FRONT HOLES



FEED TRACK POSITION GUIDE BY INSULATION BARREL

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

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