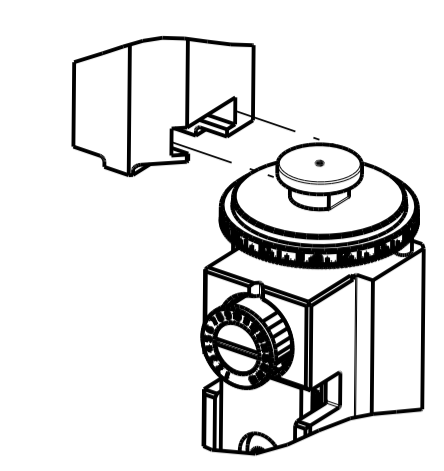


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151566-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2151566-2	D	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151566-1	C	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2151566-2	D	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2151566-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.78 mm [.070]	F
INSUL	2.29 mm [.090]	O

APPLICATOR INSTRUCTIONS
408-35042

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: MCON 2.8 RECEPTACLE			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
3.70-4.30 mm [.146-.169 IN]		Ø1.40-1.60 mm [.055-.063 IN]	
TERMINAL APPLICATION SPECIFICATION	114-18718		
TERMINALS APPLIED ⁵			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
1563719-1	1563719-3		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.50mm2	1.08 +/- 0.03 [.043 +/- .001]	6.5

- 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 TERMINAL LUBRICANT IS RECOMMENDED.
- 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.

LOC	DIST	REVISIONS			
A	66	REV	DATE	BY	APP'D
		A	RELEASED	26SEP2013	BH TE
		B	ECR-17-006198	01MAY2017	AW CT
		C	ECR-18-008490	05JUN2018	MZ KZ
		D	ECR-21-005912	31MAY2021	FJ TE

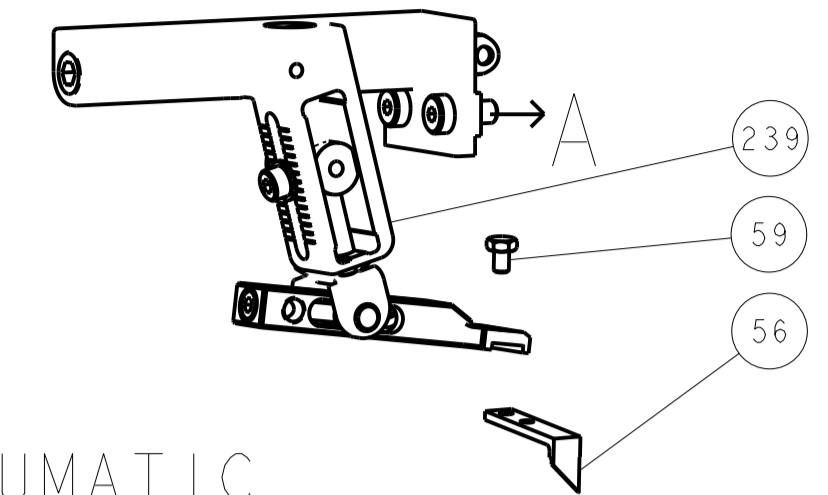
REV	DATE	BY	APP'D	DESCRIPTION	ITEM NO		
-	1	-	1	2119641-1	FEED CAM, AIR FEED	248	
-	1	1	1	2119082-4	CAM, SNAIL, INSULATION ADJUSTMENT	244	
-	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243	
-	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242	
-	1	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241	
-	-	1	-	2119580-1	MECHANICAL FEED ASSEMBLY	239	
-	1	-	1	2844940-1	AIR FEED MODULE	238	
-	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164	
-	1	1	1	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113	
-	1	1	1	2844908-1	SCREW, LOCKING	99	
-	1	1	1	2844907-1	POST, LOCKING	98	
-	1	1	1	455888-5	SPACER, CRIMPER	82	
-	1	1	1	1803607-3	DOCUMENTATION PACKAGE	71	
-	1	1	1	2119740-1	TAG, IDENTIFICATION	67	
-	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66	
-	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	60	
-	1	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59	
-	1	1	1	1338685-1	PAWL, FEED	56	
-	4	4	4	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	54	
-	2	2	2	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	53	
-	1	1	1	5018030-1	NUT, HEX, REG, RoHS, M3	52	
-	1	1	1	811242-5	BUMPER, HOLD DOWN	51	
-	1	1	1	690753-2	SPACER, TONKER	50	
-	1	2	1	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	1803583-9	APPLICATOR BASIC ASSEMBLY, SF	46	
-	1	1	1	1803515-1	RAM ASSEMBLY, SF ATLANTIC	44	
-	1	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41	
-	1	1	1	2-1752356-0	SUPPORT, TERMINAL	34	
-	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33	
-	2	2	2	2-2844962-6	SPACER, CYLINDRICAL, STRIP GUIDE	30	
-	1	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29	
-	1	1	1	455888-3	SPACER, CRIMPER	28	
-	1	1	1	1320928-2	STRIP GUIDE	24	
-	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21	
-	2	2	2	1-18028-2	WASHER, FLAT, REG M4	20	
-	1	1	1	2119533-1	STRIPPER, SIDE FEED	19	
-	1	1	1	2119806-1	INSERT, SHEAR	13	
-	1	1	1	3-22280-3	SPRING, COMPRESSION	12	
-	1	1	1	1-356885-4	STOP, SHEAR	11	
-	1	1	1	2119805-1	SHEAR HOLDER, FRONT	10	
-	1	1	1	1803095-1	FLOATING SHEAR, FRONT	9	
-	1	2	2	1-1633919-3	ANVIL, COMBINATION	8	
-	1	1	1	6-240641-5	SPACER	7	
-	-	-	-	-	-	6	
-	1	1	1	2119757-8	DEPRESSOR, SHEAR	5	
-	1	1	1	238011-4	BLOCK, CRIMPER SPACER	4	
-	1	2	2	1633965-4	CRIMPER, INSULATION O PREMIUM	3	
-	1	1	1	455888-2	SPACER, CRIMPER	2	
-	1	2	2	3-456404-1	CRIMPER, WIRE PREMIUM	1	
-77	-72	-71	-2	-1	PART NO	DESCRIPTION	ITEM NO

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

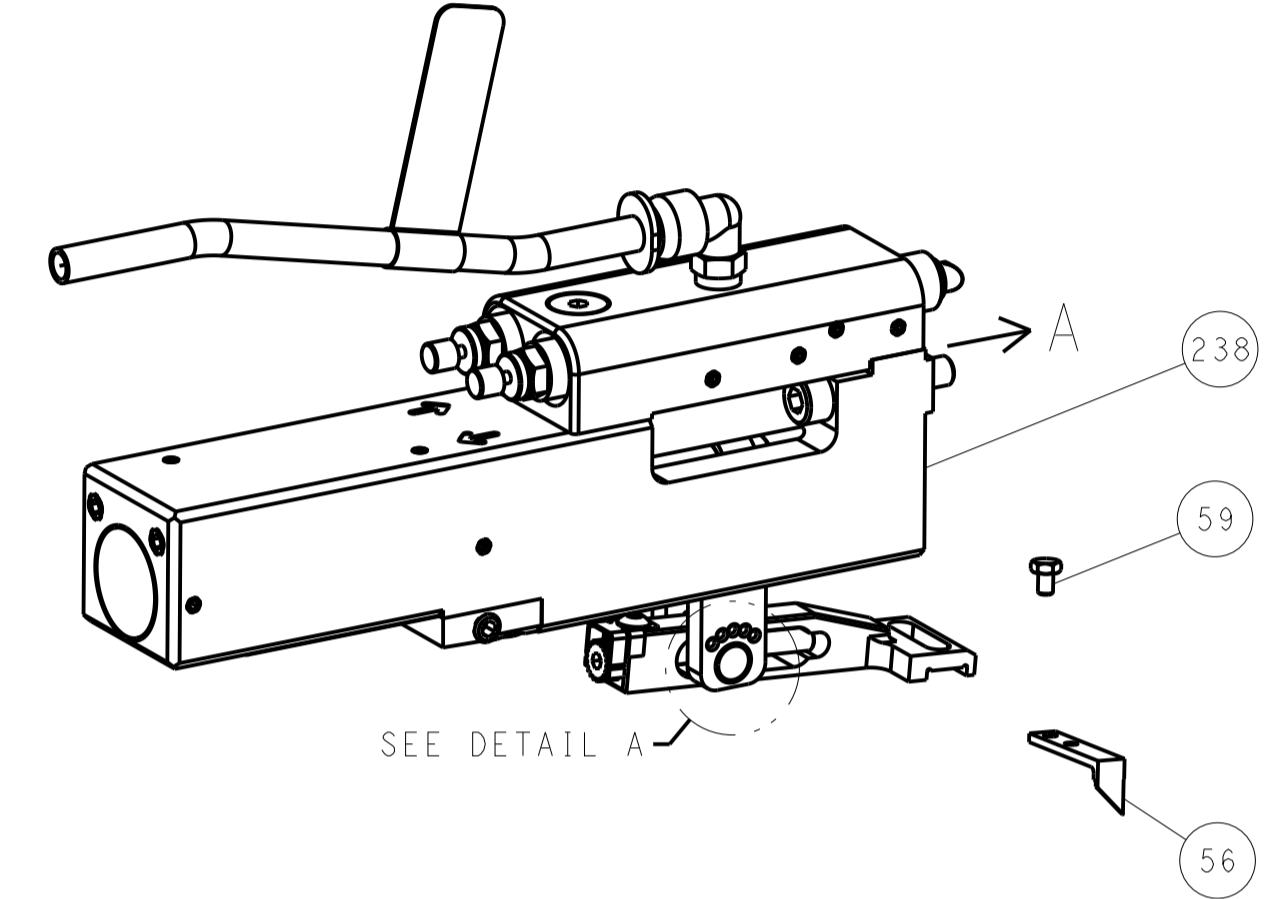
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mm	0 PLC ±	1 PLC ±	2 PLC ±	CH	19FEB2013	Harrisburg, PA 17105-3608	
	3 PLC ±	4 PLC ±	ANGLES ±	FINISH			
MATERIAL				APVD	19FEB2013	NAME	
						Ocean Side Feed Applicator	
				SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
				A1	00779	2151566	
Customer Accessible Production Drawing				SCALE	1:2	SHEET	1 OF 4

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

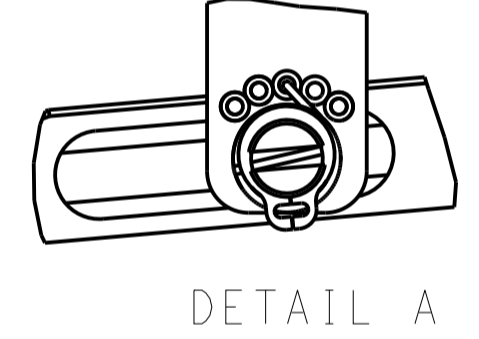
FEED TYPE MECHANICAL



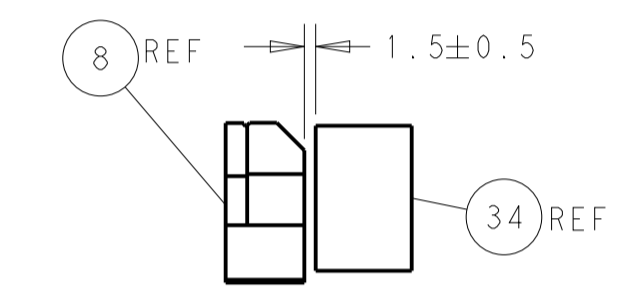
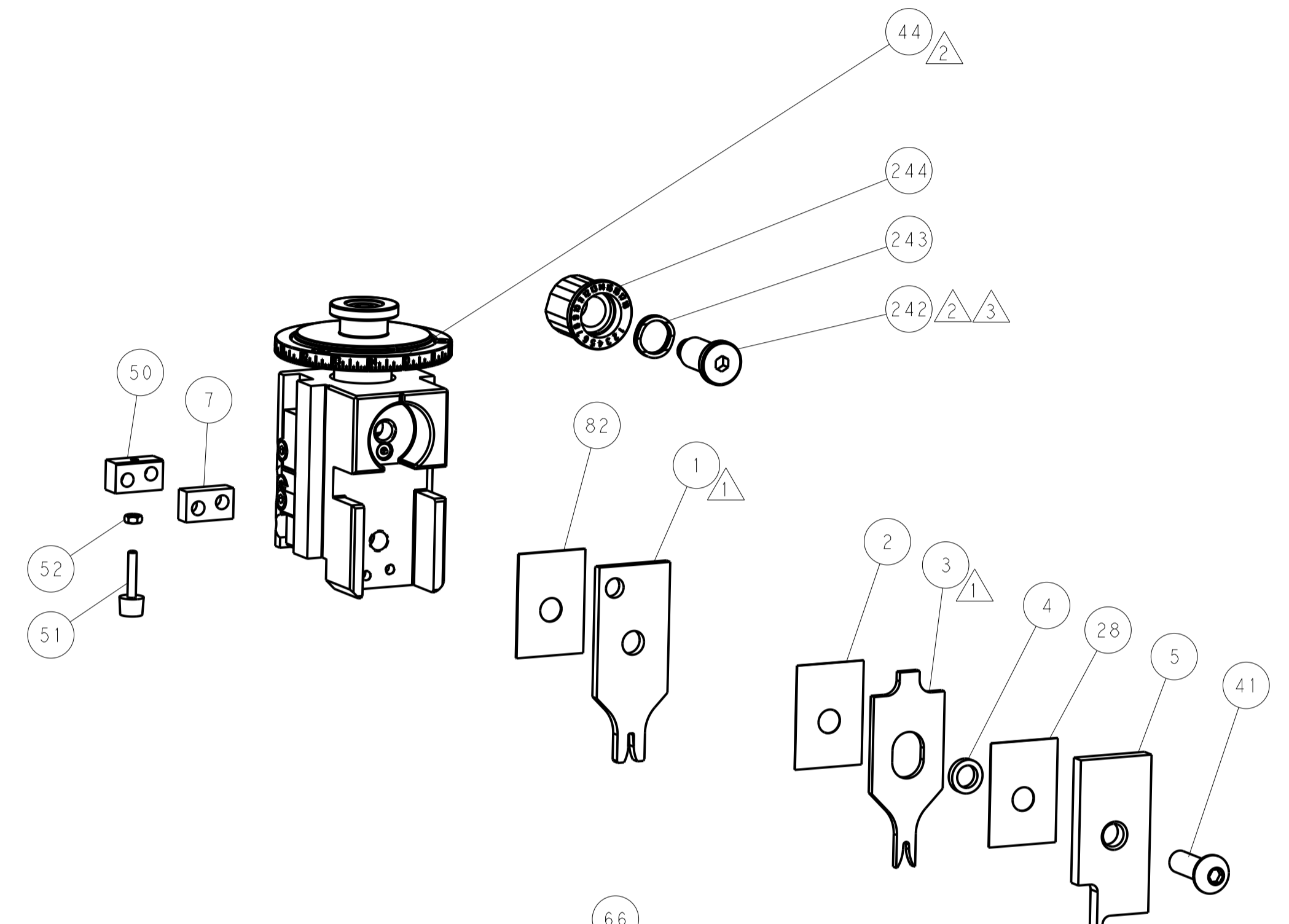
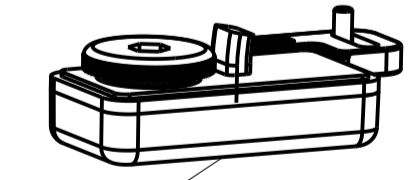
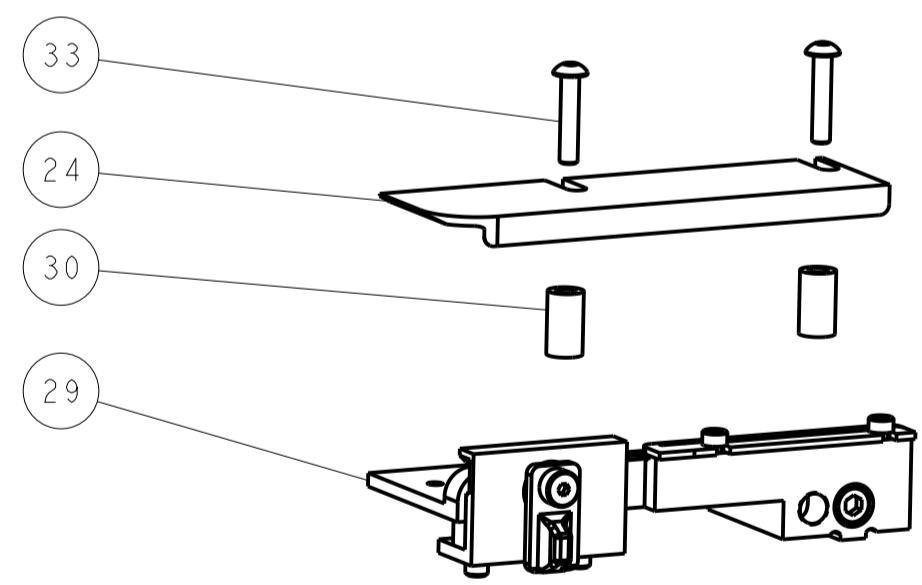
PNEUMATIC



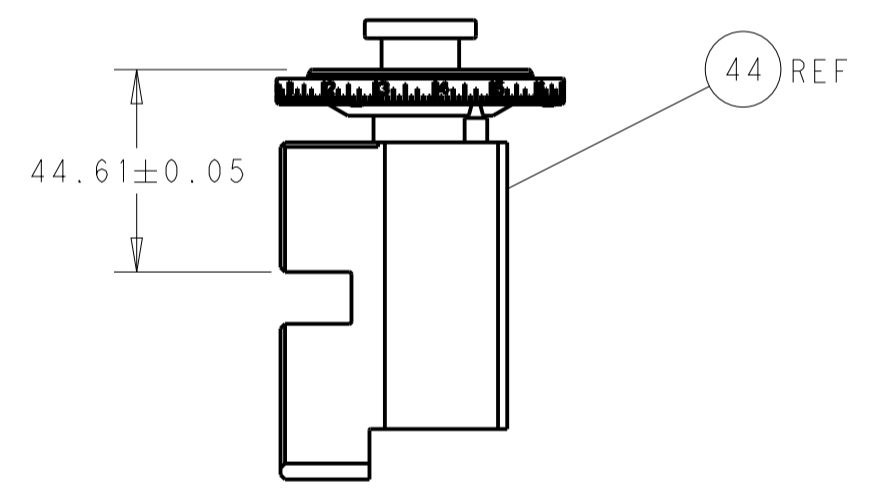
FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



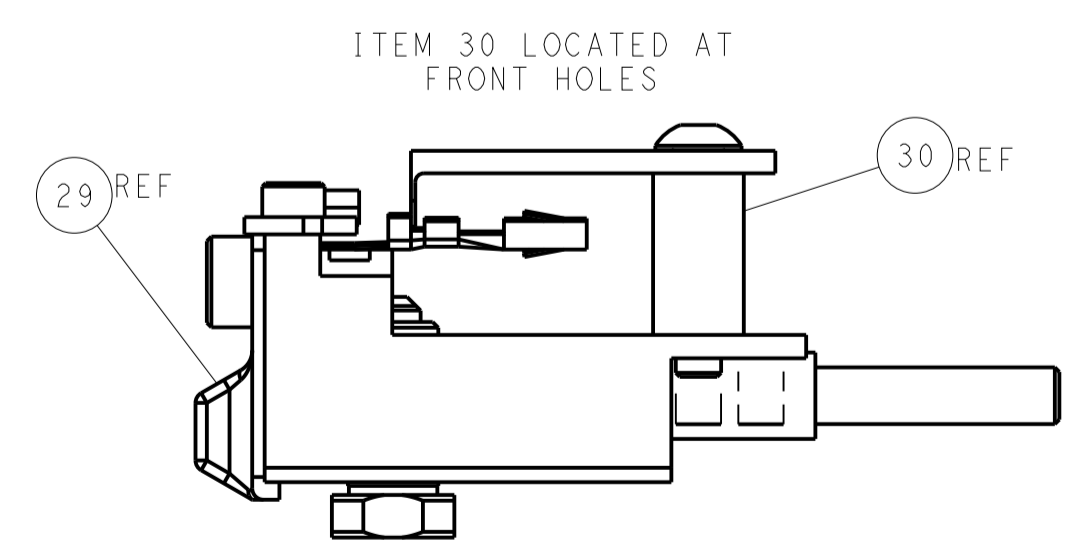
DETAIL A



TERMINAL SUPPORT LOCATION

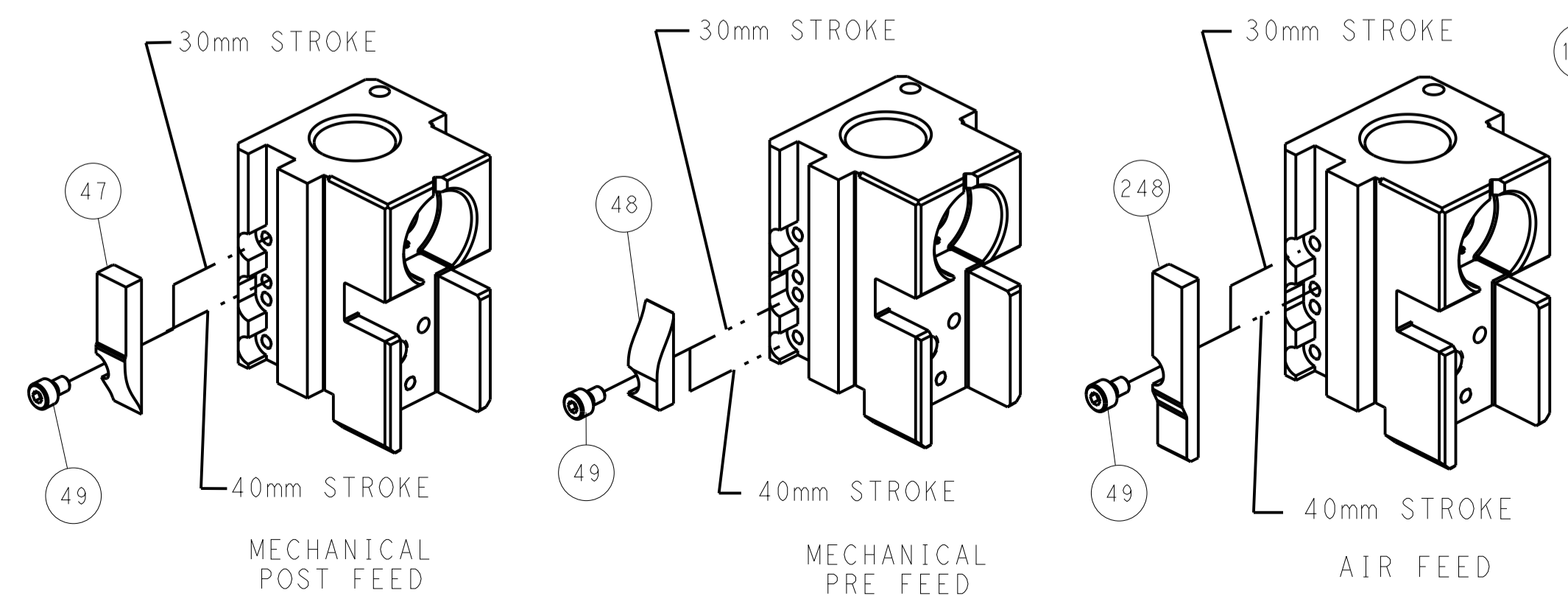


RAM SET-UP



FEED TRACK POSITION GUIDE BY INSULATION BARREL

CAM POSITIONS

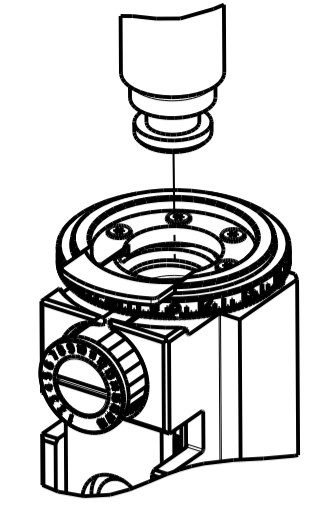


ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN X ZHAO 19FEB2013		TE Connectivity	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	Harrisburg, PA 17105-3608	
MATERIAL:		FINISH:		APVD S. XI 19FEB2013		NAME	
				PRODUCT SPEC		Ocean Side Feed	
				APPLICATION SPEC		Applicator	
				WEIGHT		SIZE CAGE CODE DRAWING NO	
				Customer Accessible Production Drawing		A1 00779 ©=2151566	
				SCALE		RESTRICTED TO	
				1:2		SHEET 2 OF 4 REV D	

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2151566-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2151566-2	D	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151566-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
 INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.78 mm [.070]	F
INSUL	2.29 mm [.090]	O

APPLICATOR INSTRUCTIONS
 408-35042

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION
TERMINAL NAME: MCON 2.8 RECEPTACLE		
WIRE STRIP LENGTH 3.70-4.30 mm [1.46-.169 IN]		INSULATION DIAMETER RANGE Ø1.40-1.60 mm [.055-.063 IN]
TERMINAL APPLICATION SPECIFICATION 114-18718		
TERMINALS APPLIED		
TE TERMINAL 1563719-1	TE TERMINAL 1563719-3	

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.50mm ²	1.08+/-0.03 [.043+/-0.001]	6.5

- 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.
 - TERMINAL LUBRICANT IS RECOMMENDED.
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.

LOC	DIST	REV	DATE	BY	APPV
A	66				

REVISIONS					
REV	DATE	DESCRIPTION	DATE	BY	APPV
-	-	SEE SHEET 1	-	-	-
-	1	1	2119082-4	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
-	-	-	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
-	-	-	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	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113
-	1	1	2844908-1	SCREW, LOCKING	99
-	1	1	2844907-1	POST, LOCKING	98
-	1	1	455888-5	SPACER, CRIMPER	82
-	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
-	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	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
-	-	-	2119652-1	FEED CAM, PRE FEED	48
-	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
-	1	1	2-1752356-0	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	455888-3	SPACER, CRIMPER	28
-	1	1	1320928-2	STRIP GUIDE	24
-	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
-	2	2	1-18028-2	WASHER, FLAT, REG M4	20
-	1	1	2119533-1	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	1803095-1	FLOATING SHEAR, FRONT	9
-	1	1	1-1633919-3	ANVIL, COMBINATION	8
-	1	1	6-240641-5	SPACER	7
-	-	-	-	-	6
-	1	1	2119757-8	DEPRESSOR, SHEAR	5
-	1	1	238011-4	BLOCK, CRIMPER SPACER	4
-	1	1	1633965-4	CRIMPER, INSULATION O PREMIUM	3
-	1	1	455888-2	SPACER, CRIMPER	2
-	1	1	3-456404-1	CRIMPER, WIRE PREMIUM	1

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

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

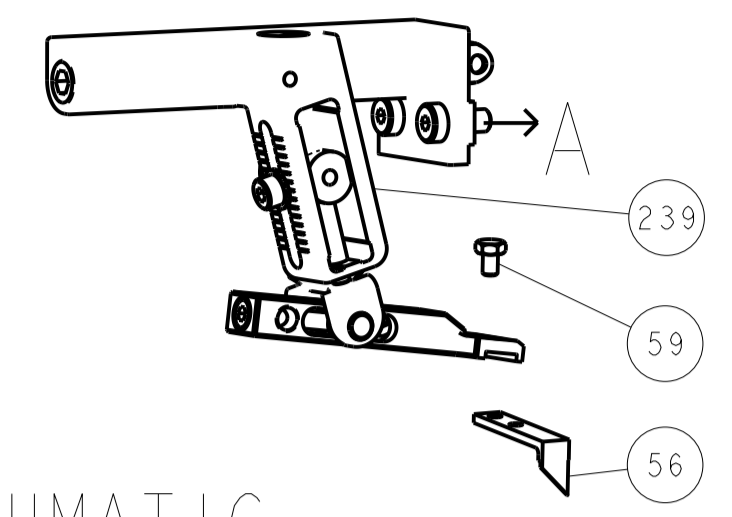
DATE	19FEB2013	DESIGNER	X. ZHAO
DATE	19FEB2013	CHECKED	T. ELBIN
DATE	19FEB2013	APPROVED	S. XI

NAME	Ocean Side Feed Applicator		
SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
A1	00779	2151566	

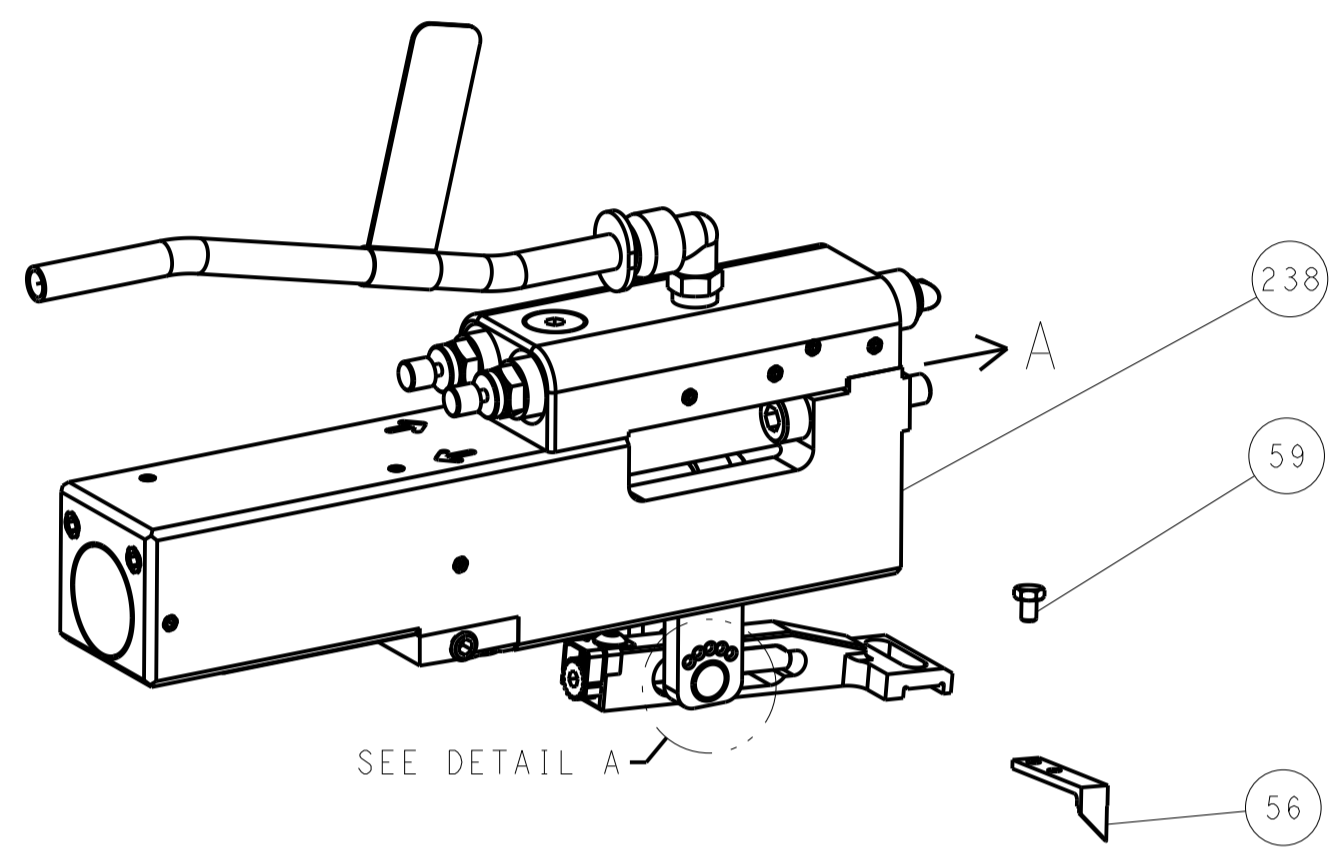
Customer Accessible Production Drawing SCALE 1:2 SHEET 3 OF 4 REV D

LOC		DIST		REVISIONS			
A		66		REV	DATE	BY	APP'D
-				1	SEE SHEET 1	-	-

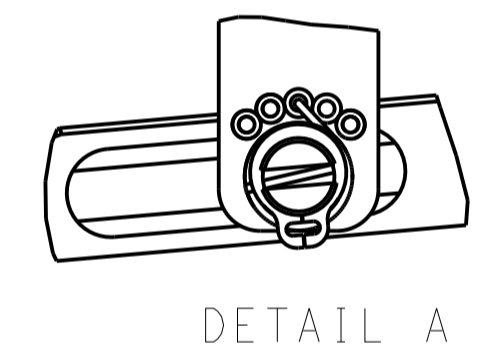
FEED TYPE MECHANICAL



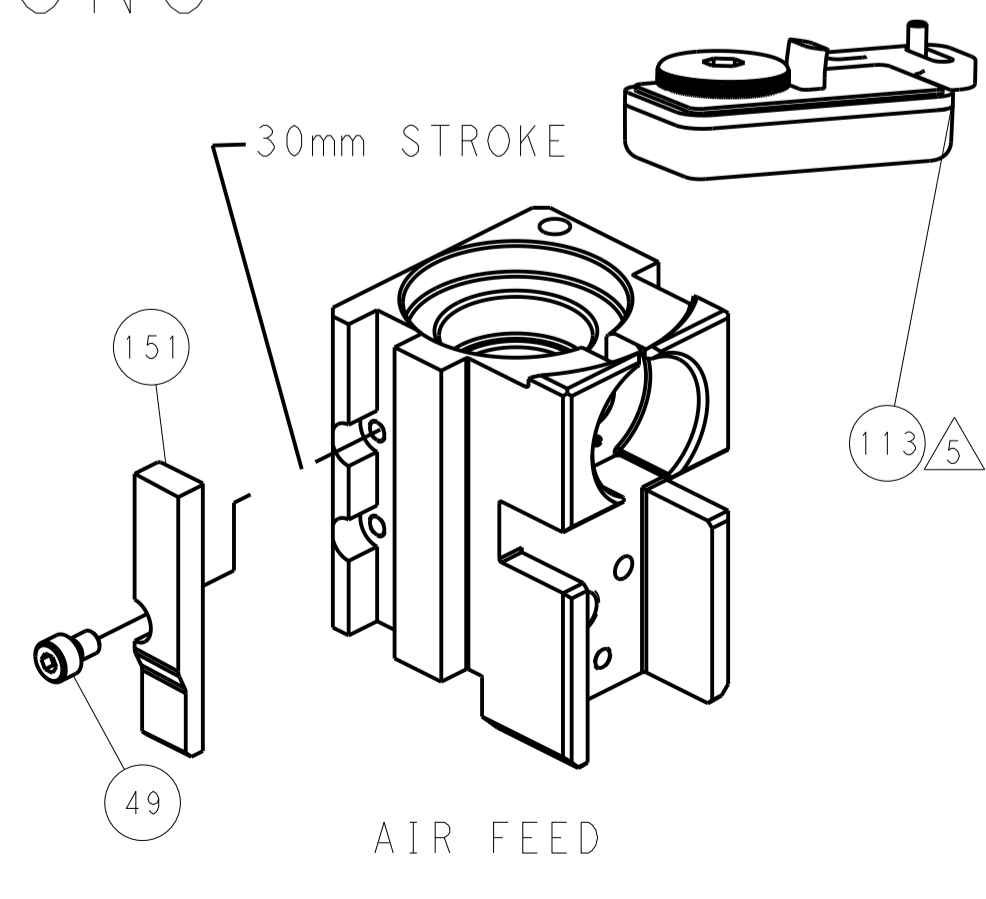
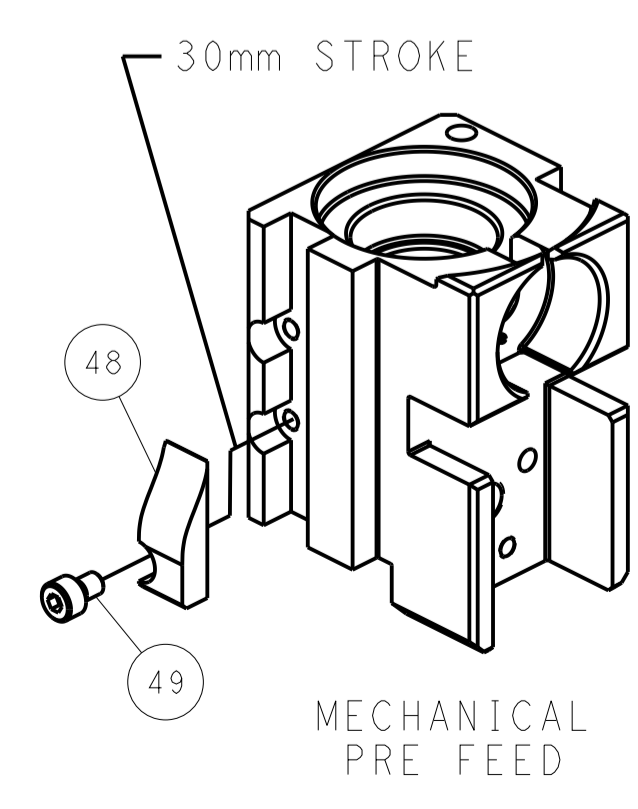
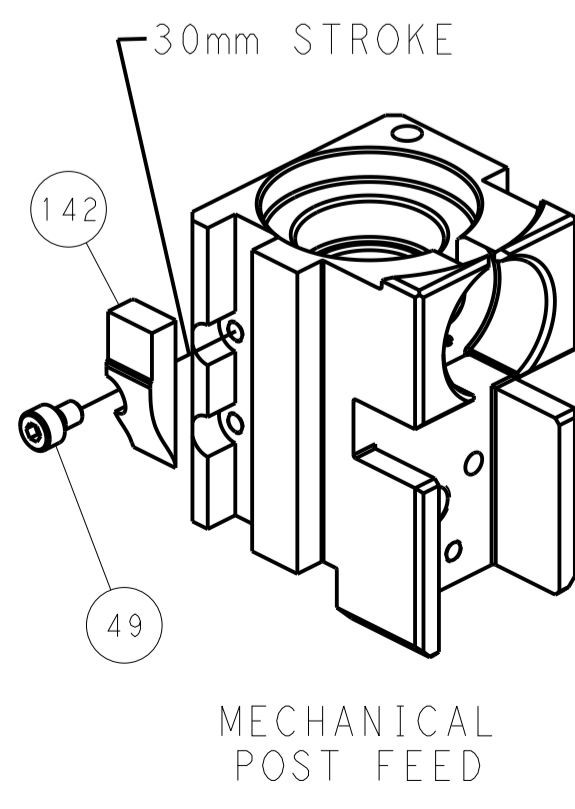
PNEUMATIC



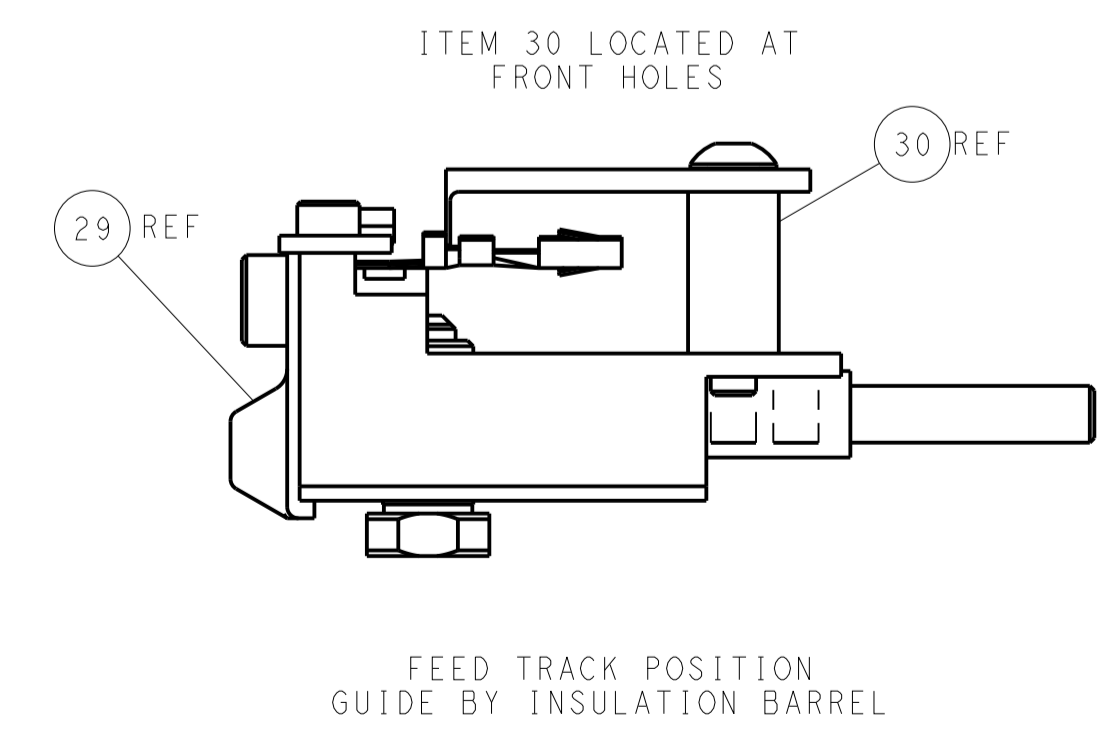
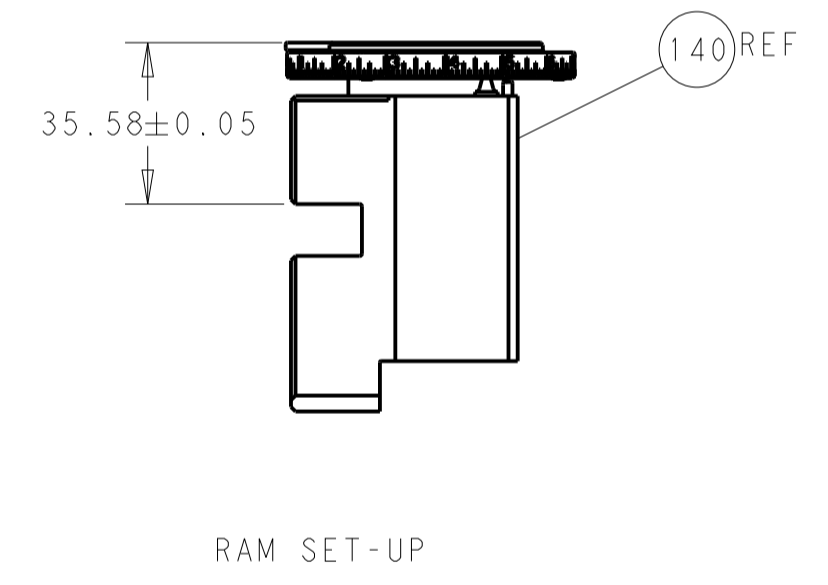
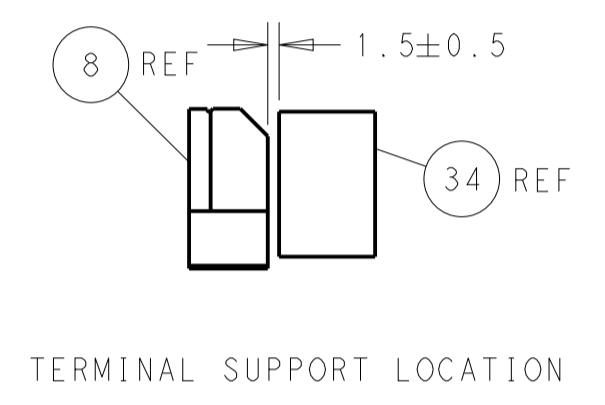
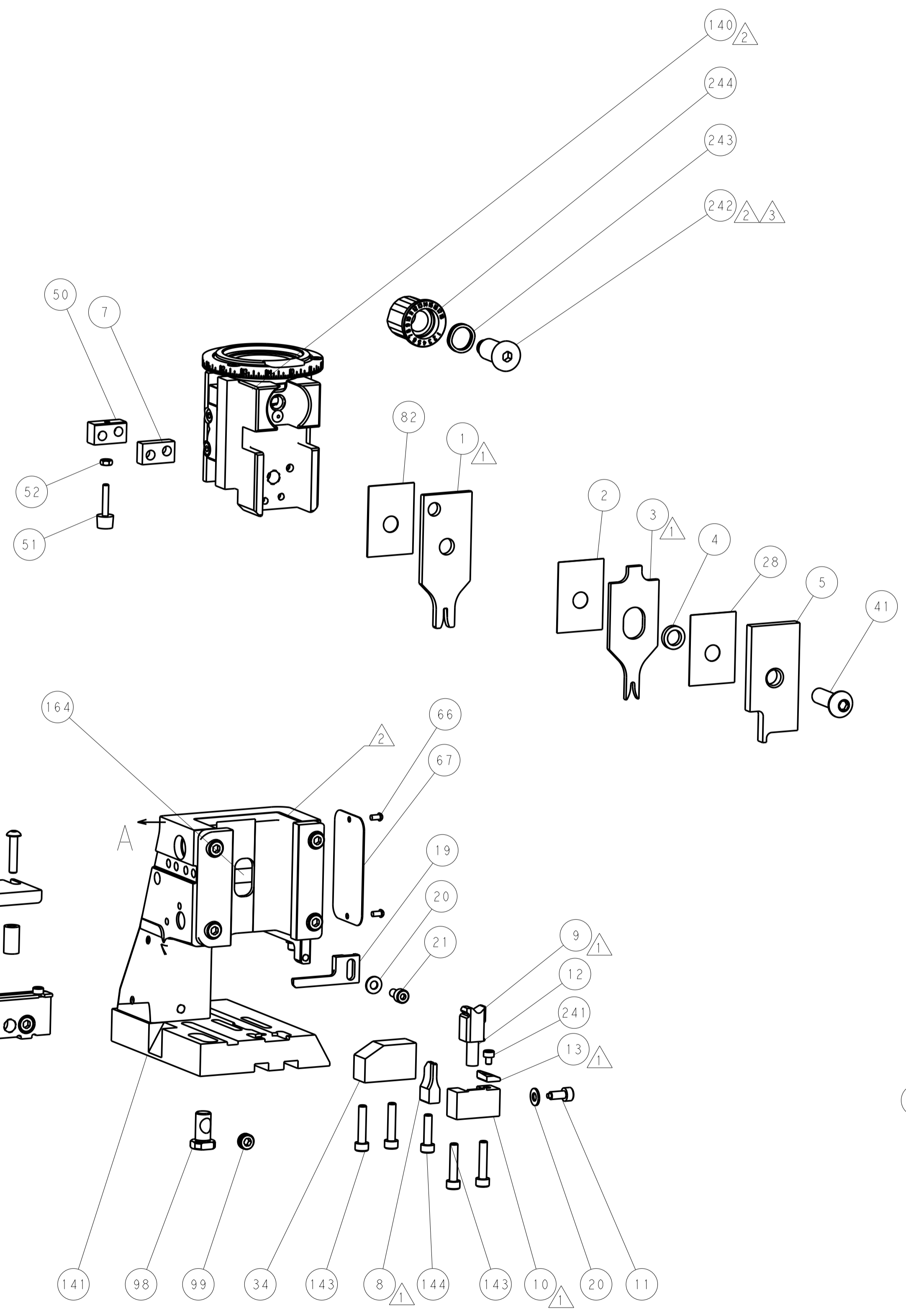
FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



CAM POSITIONS



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



DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG: X_ZHAO 19FEB2013		TE Connectivity	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	5 PLC ±	Harrisburg, PA 17105-3608
MATERIAL:		FINISH:		CHK: T_ELFIN 19FEB2013		NAME: Ocean Side Feed Applicator	
				S_XI 19FEB2013		RESTRICTED TO:	
				APVD: S_XI 19FEB2013		SIZE: CAGE CODE: DRAWING NO: 00779 ©=2151566	
				PRODUCT SPEC:		SCALE: 1:2 SHEET 4 OF 4 REV D	
				APPLICATION SPEC:		Customer Accessible Production Drawing	
				WEIGHT:			
				ANGLES:			