

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

ATLANTIC VERSION TERMINATOR
INTERFACE ADAPTER



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		INSULATION DIAMETER RANGE		WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
3.00-3.50 mm [.118-.138 IN]		Ø0.85-1.05 mm [.033-.041 IN]		3.00-3.50 mm [.118-.138 IN]		Ø0.85-0.95 mm [.033-.037 IN]	
TERMINAL APPLICATION SPECIFICATION		114-5379		TERMINAL APPLICATION SPECIFICATION		114-78061-1	
TERMINALS APPLIED				TERMINALS APPLIED			
TE TERMINAL		TE TERMINAL		TE TERMINAL		TE TERMINAL	
1827855-4							

TERMINAL DATA: TE TERMINAL				TE CRIMP SPECIFICATION			
TERMINAL NAME: CONTACT, FEMALE, UNSEALED, 0.50 SERIES							
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE		WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
3.00-3.50 mm [.118-.138 IN]		Ø0.85-1.05 mm [.033-.041 IN]		3.00-3.50 mm [.118-.138 IN]		Ø0.85-0.95 mm [.033-.037 IN]	
TERMINAL APPLICATION SPECIFICATION		114-5379		TERMINAL APPLICATION SPECIFICATION		114-78061-1	
TERMINALS APPLIED				TERMINALS APPLIED			
TE TERMINAL		TE TERMINAL		TE TERMINAL		TE TERMINAL	
2356389-1							

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.22mm2	0.64 +/- 0.02 [.025 +/- .001]	7.1
0.13mm2	0.57 +/- 0.05 [.022 +/- .002]	7.8

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.13mm2	0.57 +/- 0.03 [.022 +/- .001]	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.
- 5. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- 6 FEED ADJUSTMENT REQUIRED WHEN CHANGING TERMINAL APPLIED.
- 7 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
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

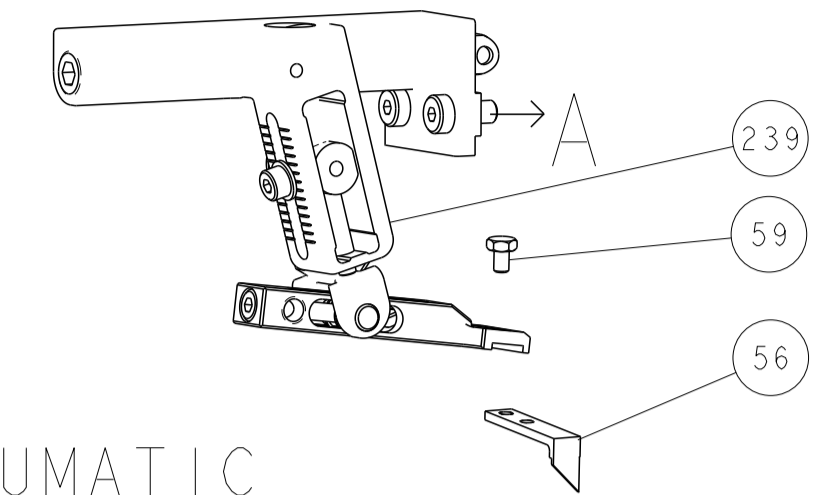
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		C		ECR-18-018247	21NOV2018	FL	CT
		D		ECR-18-019285	11DEC2018	MZ	CT
		E		ECR-22-155582	14OCT2022	FZ	TE

-	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	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	
-	2	2	2	2	1-2079383-0	SCR, BHSC, RoHS (M3 X 6)	230	
3	-	1	1	1	1-1752354-8	STANDOFF, HOLD-DOWN	180	
-	1	1	1	1	1976053-9	LOCATER BLOCK, TERMINAL	179	
-	1	1	1	1	993111-1	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	
-	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164	
7	-	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	1803607-3	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	
-	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	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	1633861-1	SHEAR, FLOATING	9	
1	1	2	2	1	1	3-1633711-1	ANVIL, COMBINATION	8
-	-	-	-	-	-	-	7	
-	-	-	-	-	-	-	6	
-	1	1	1	1	2119780-9	DEPRESSOR, SHEAR	5	
-	1	1	1	1	3-238011-8	BLOCK, CRIMPER SPACER	4	
1	1	2	2	1	1	1633966-3	CRIMPER, INSULATION O	3
-	-	-	-	-	-	-	2	
1	1	2	2	1	1	2-937157-8	CRIMPER, WIRE SPECIAL	1

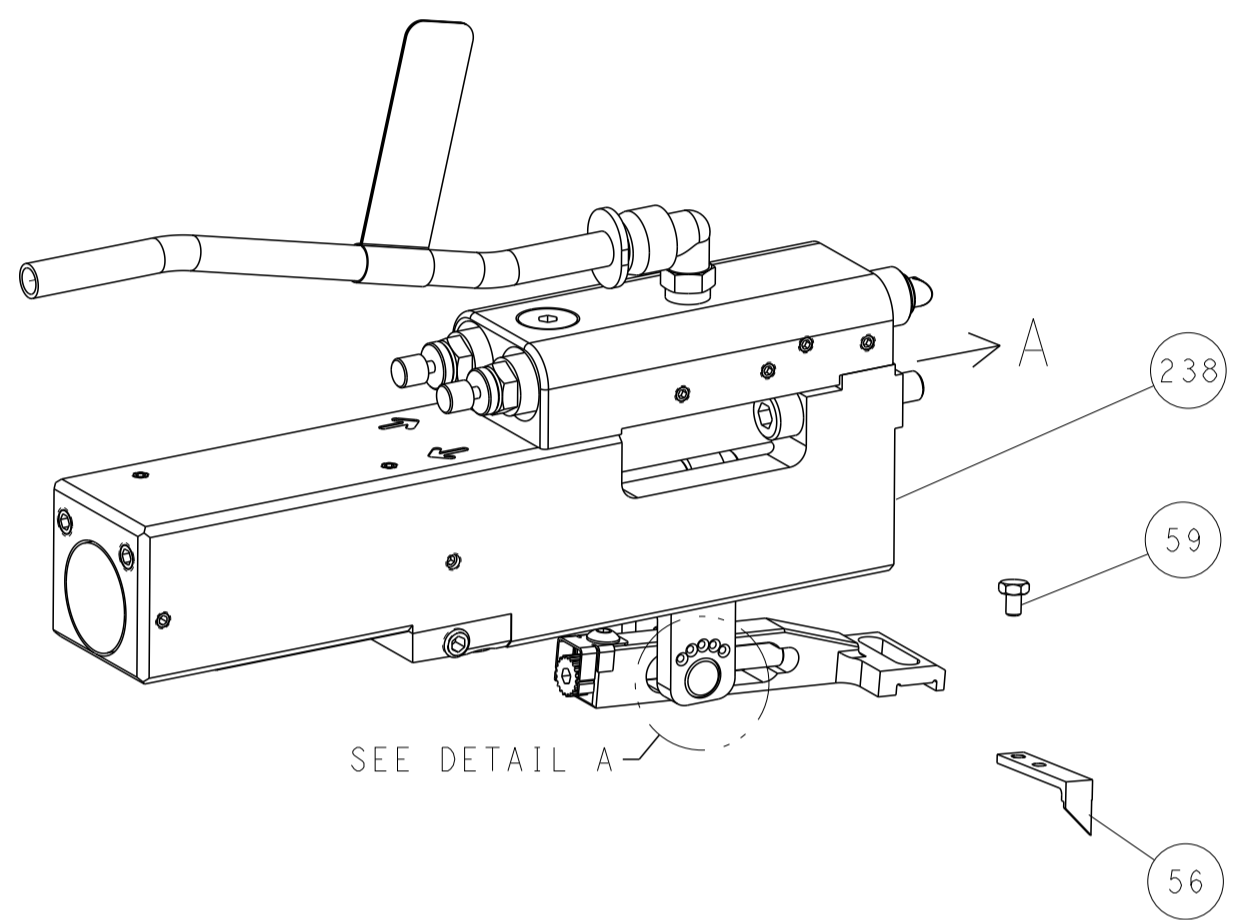
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mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES	FINISH			A1	00779	C=2151679	1	4	E

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

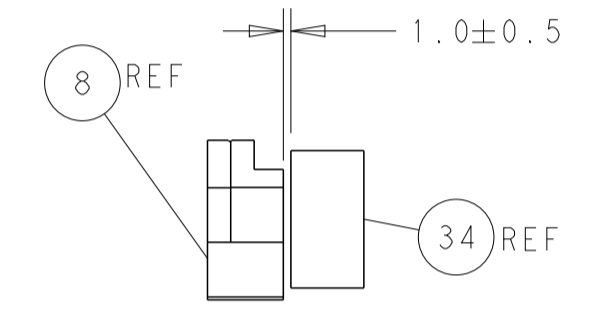
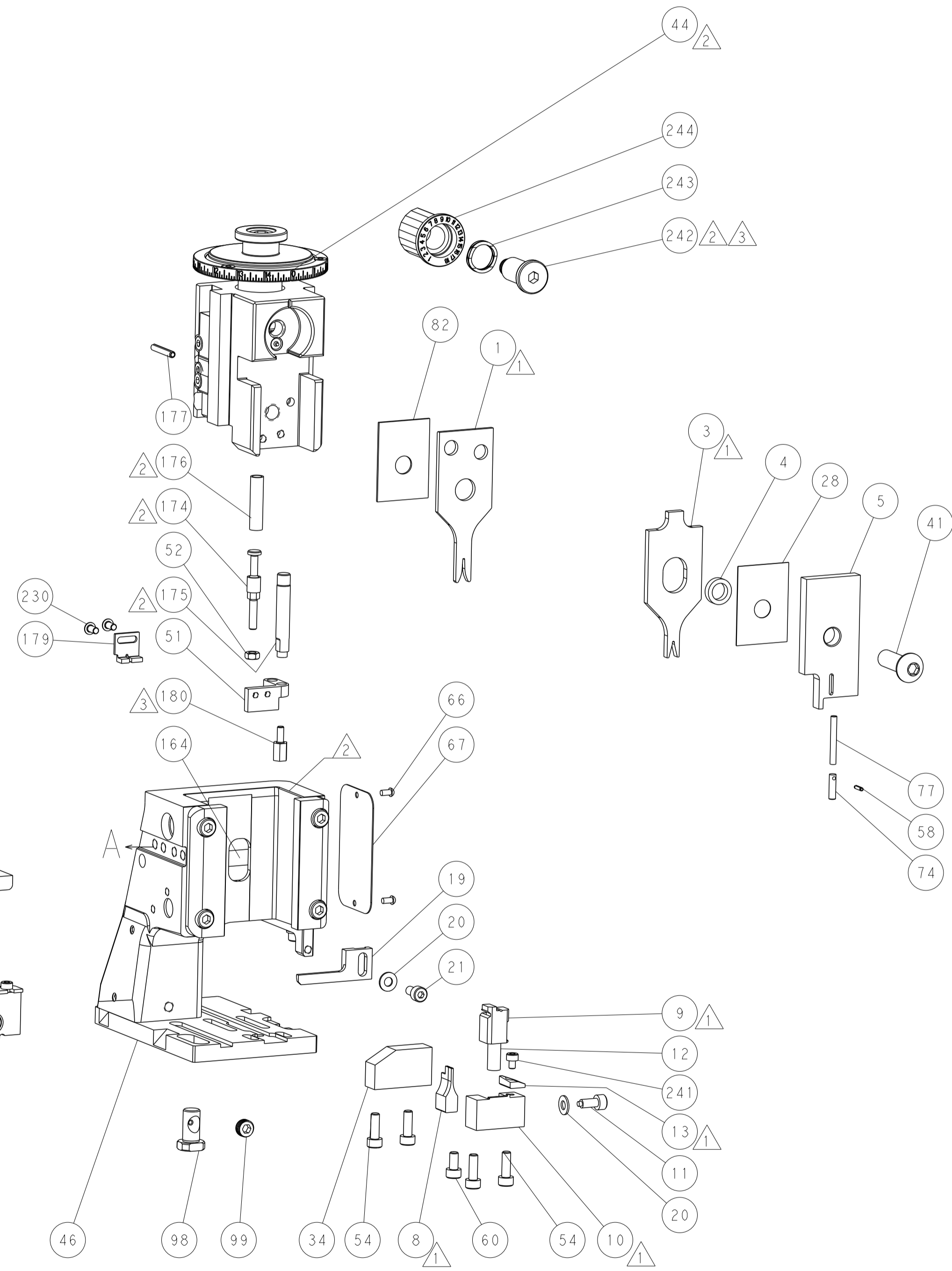
FEED TYPE MECHANICAL



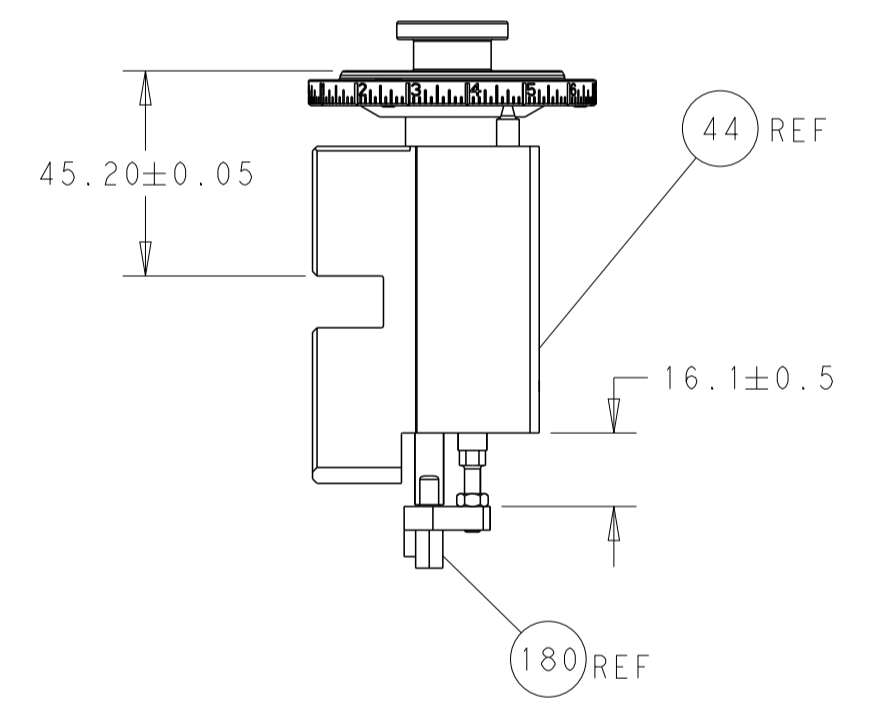
PNEUMATIC



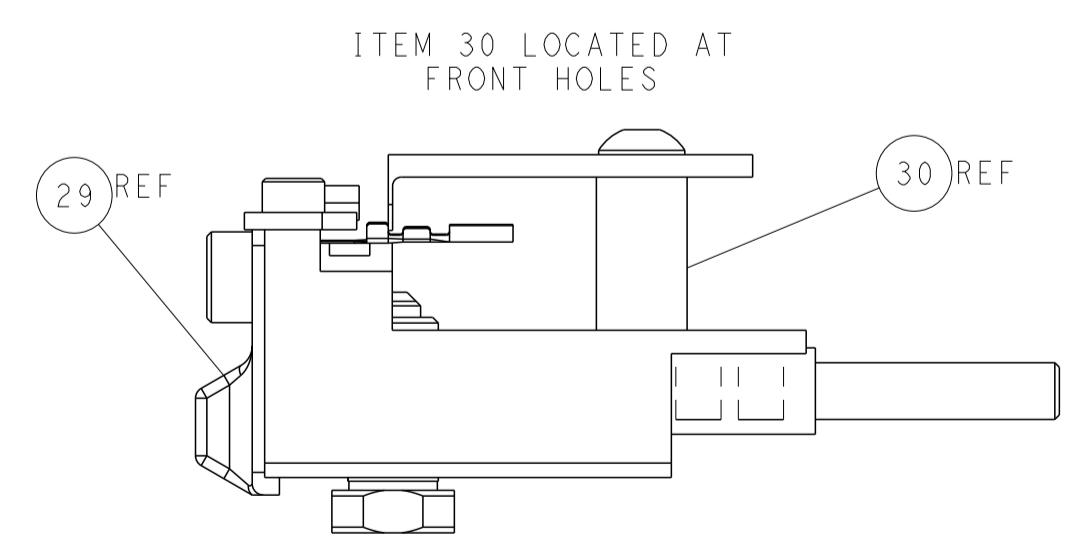
FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



TERMINAL SUPPORT LOCATION

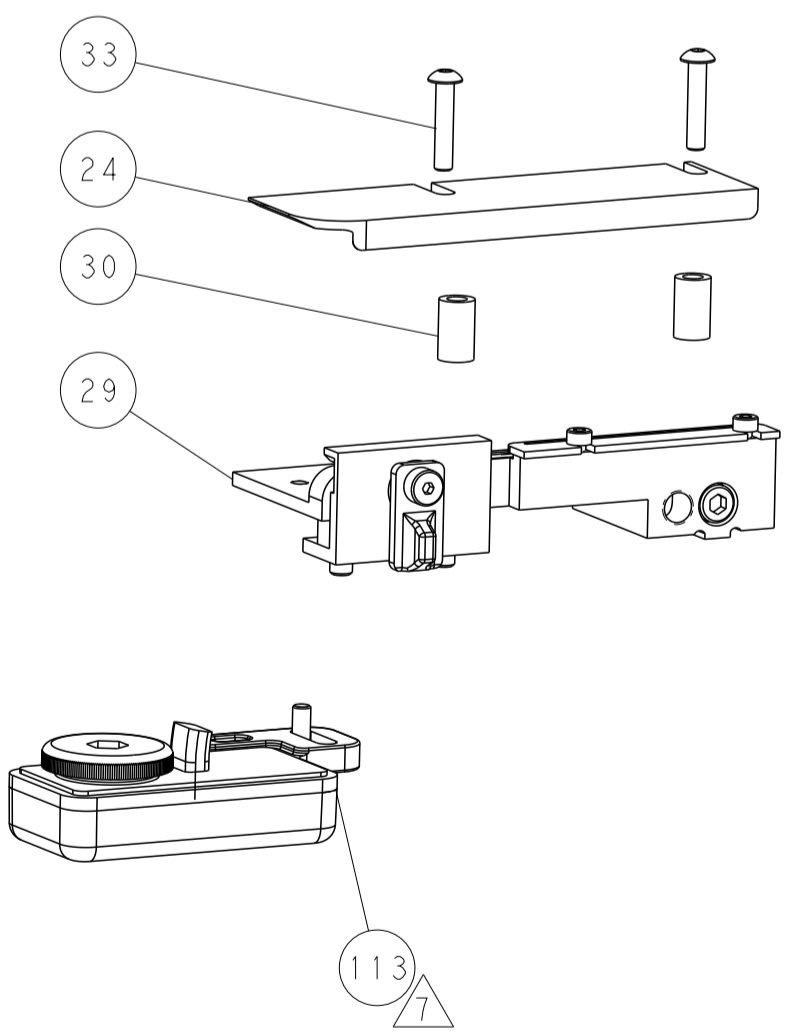
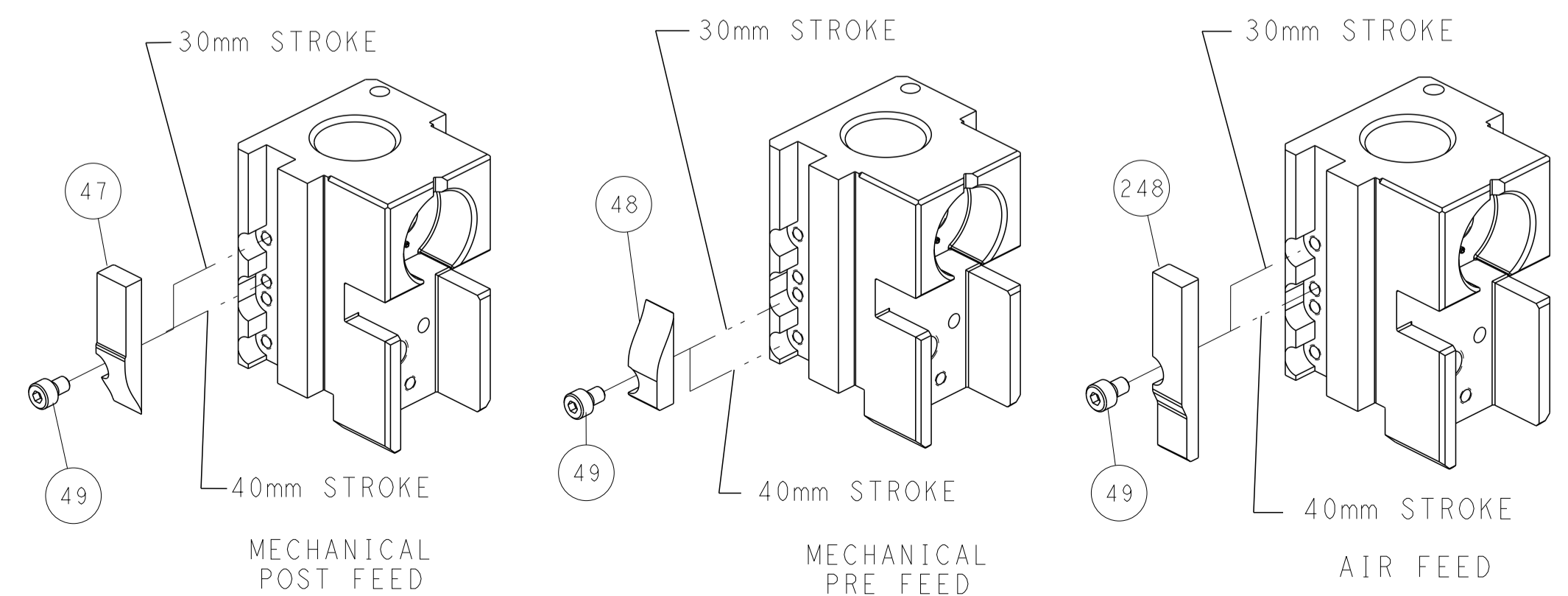


RAM AND HOLDDOWN SET-UP



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: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		OWN: R. HUANG 17JUN2013	TE Connectivity
0 PLC ±		1 PLC ±		CHK: L. ZHANG 17JUN2013	Harrisburg, PA 17105-3608
2 PLC ±		3 PLC ±		APVD: J. GUO 17JUN2013	NAME: Ocean Side Feed Applicator
4 PLC ±		ANGLES ±		PRODUCT SPEC	SIZE: CAGE CODE: DRAWING NO: RESTRICTED TO
MATERIAL: -		FINISH: -		APPLICATION SPEC	A1 00779 ©=2151679
WEIGHT: -		SCALE: 1:2		CUSTOMER ACCESSIBLE PRODUCTION DRAWING	SHEET 2 OF 4 REV E

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

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



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		INSULATION DIAMETER RANGE	
3.00-3.50 mm [1.18-.138 IN]		Ø0.85-1.05 mm [.033-.041 IN]	
TERMINAL APPLICATION SPECIFICATION	114-5379	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
1827855-4			

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: CONTACT, FEMALE, UNSEALED, 0.50 SERIES			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
3.00-3.50 mm [1.18-.138 IN]		Ø0.85-0.95 mm [.033-.037 IN]	
TERMINAL APPLICATION SPECIFICATION	114-78061-1	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
2356389-1			

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING
0.22mm ²		0.64+/-0.02 [.025+/- .001]		7.1
0.13mm ²		0.57+/-0.05 [.022+/- .002]		7.8

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING
0.13mm ²		0.57+/-0.03 [.022+/- .001]		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.

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

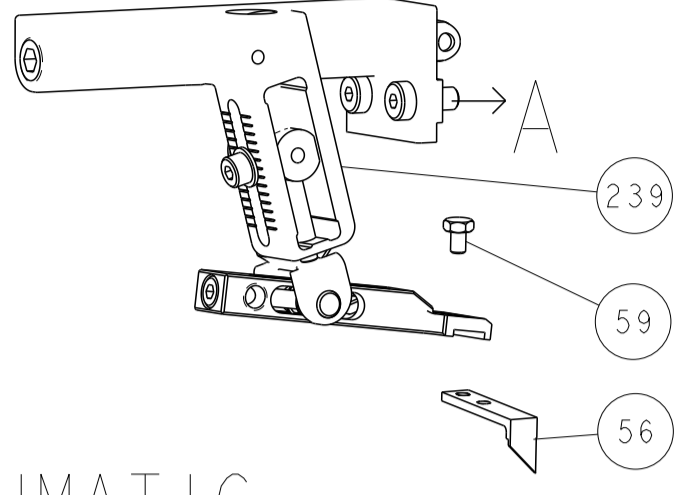
-	1	1	2119082-8	CAM, SNAIL, INSULATION ADJUSTMENT	244	
-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243	
-	1	1	2119083-1	RETAINER, INSULATION DIAL	242	
-	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241	
-	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239	
-	1	-	2844940-1	AIR FEED MODULE	238	
-	2	2	1-2079383-0	SCR, BHSC, RoHS (M3 X 6)	230	
-	1	1	1-1752354-8	STANDOFF, HOLD-DOWN	180	
-	1	1	1976053-9	LOCATER BLOCK, TERMINAL	179	
-	1	1	993111-1	PIN, SLOTTED SPRING 3.0 X 20.0	177	
-	1	1	8-22280-7	SPRING, COMPRESSION	176	
-	1	1	1752353-2	GUIDE PIN, HOLDDOWN	175	
-	1	1	1901680-2	GUIDE PIN, HOLDDOWN	174	
-	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	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113	
-	1	1	2844908-1	SCREW, LOCKING	99	
-	1	1	2844907-1	POST, LOCKING	98	
-	1	1	455888-8	SPACER, CRIMPER	82	
-	1	1	5-547505-2	SPRING, COMPRESSION	77	
-	1	1	854769-4	HOLDER, INS	74	
-	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	21028-2	PIN, SLOTTED SPRING .062 X .250	58	
-	1	1	1338685-1	PAWL, FEED	56	
-	1	1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52	
-	1	1	1901681-4	HOLDDOWN, TERMINAL	51	
-	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	1-1752356-6	SUPPORT, TERMINAL	34	
-	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33	
-	2	2	2-2844962-3	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	1633861-1	SHEAR, FLOATING	9	
-	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	1633966-3	CRIMPER, INSULATION O	3	
-	-	-	-	-	2	
-	1	1	2-937157-8	CRIMPER, WIRE SPECIAL	1	
-	77	-	21	PART NO	DESCRIPTION	ITEM NO

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

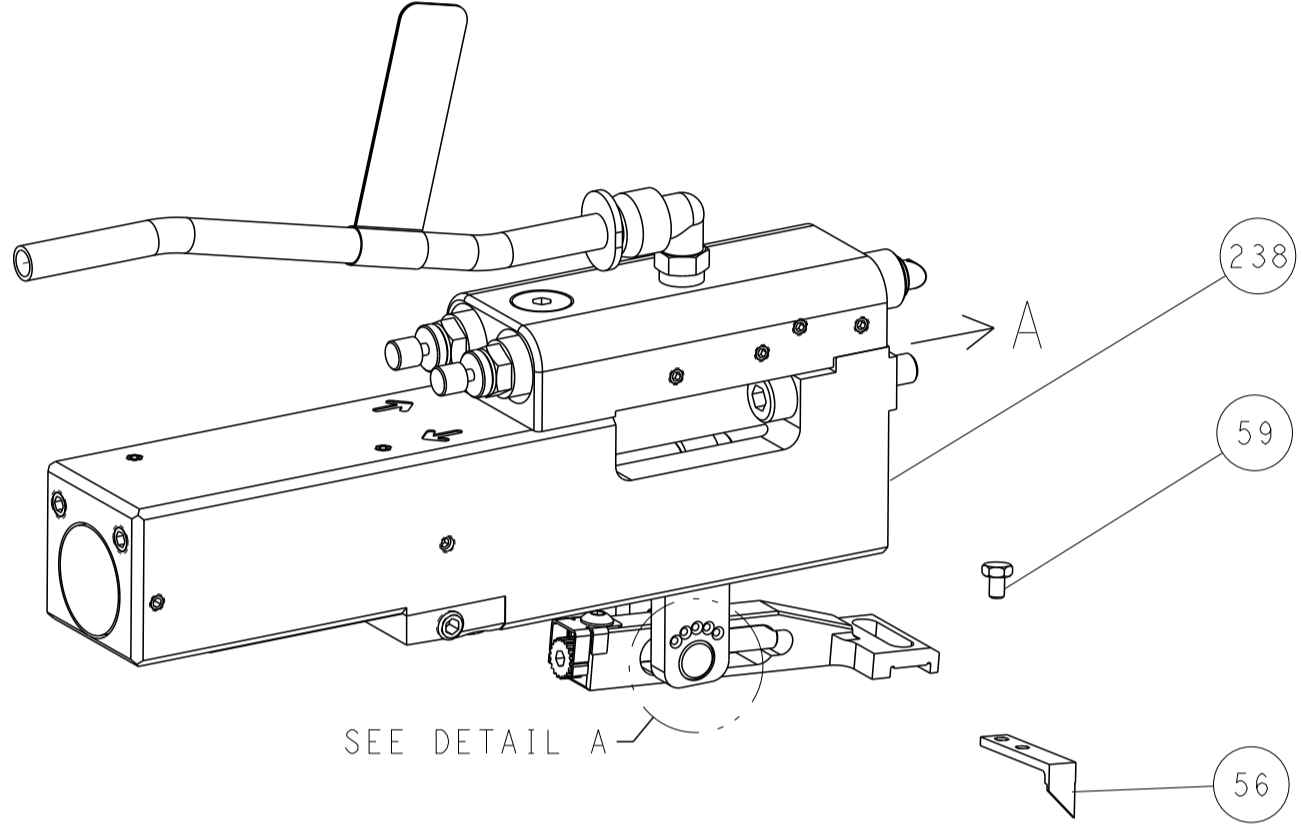
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG		CHK		APVD		NAME	
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MATERIAL											Ocean Side Feed Applicator
Customer Accessible Production Drawing		SCALE	1:2	SHEET	3	OF	4	REV	E		

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

FEED TYPE MECHANICAL



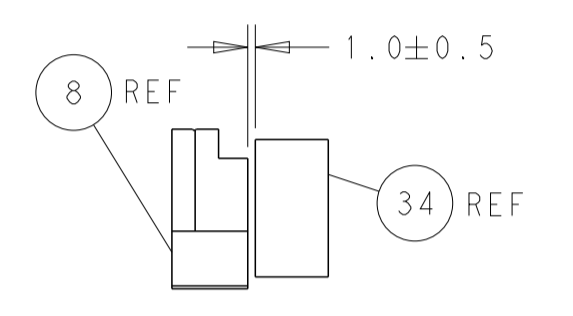
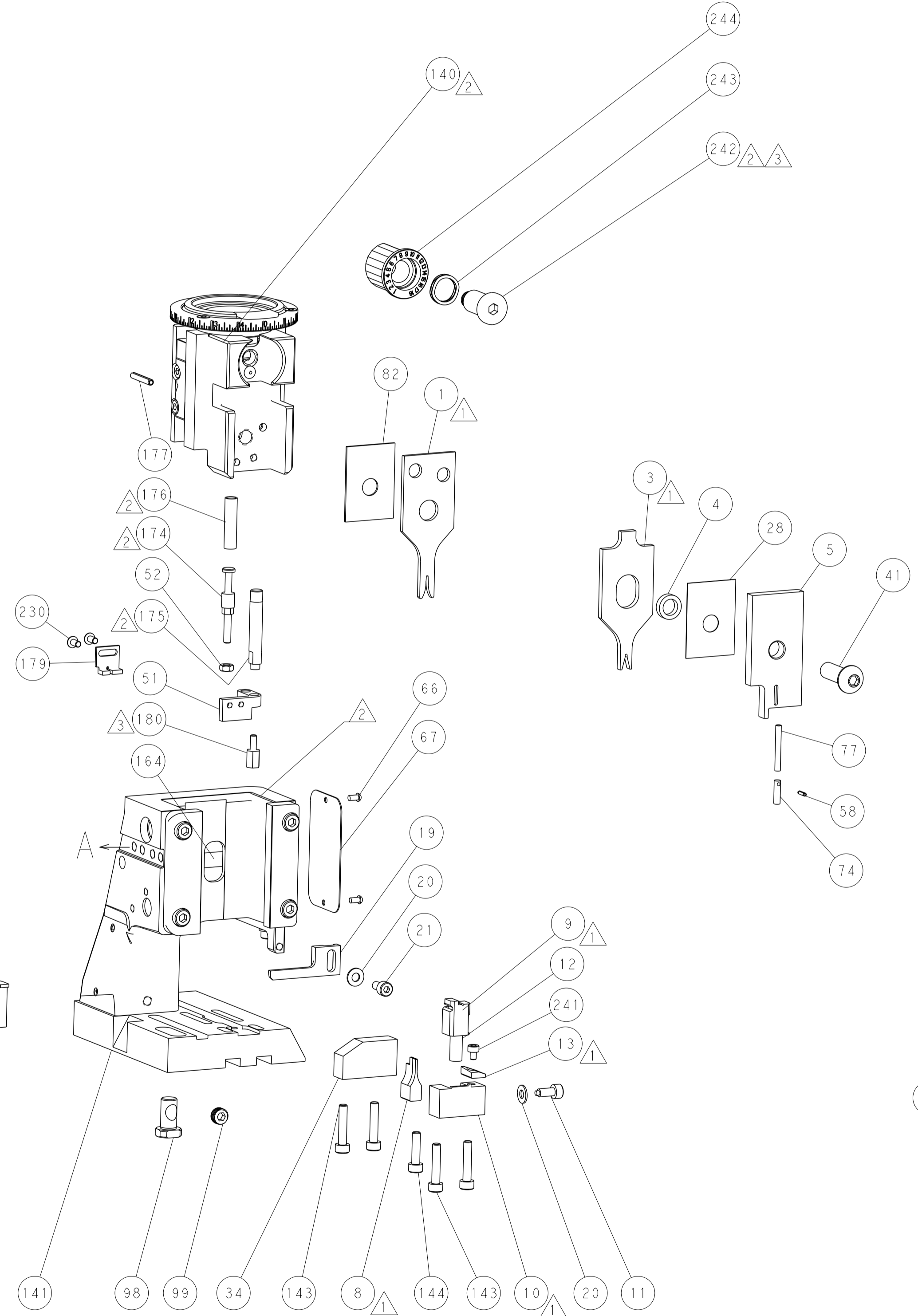
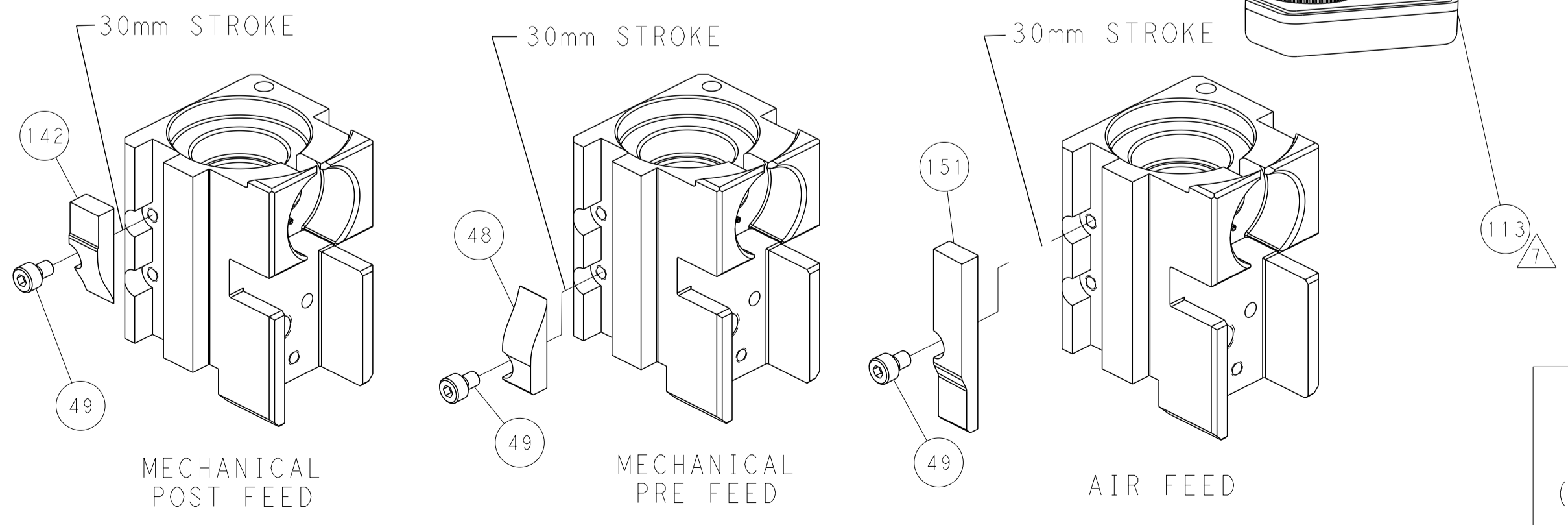
PNEUMATIC



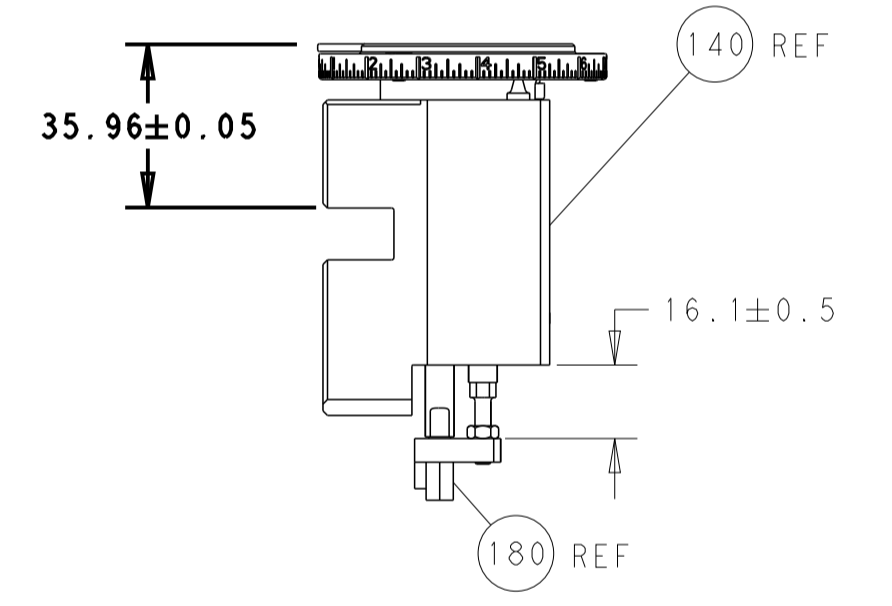
FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



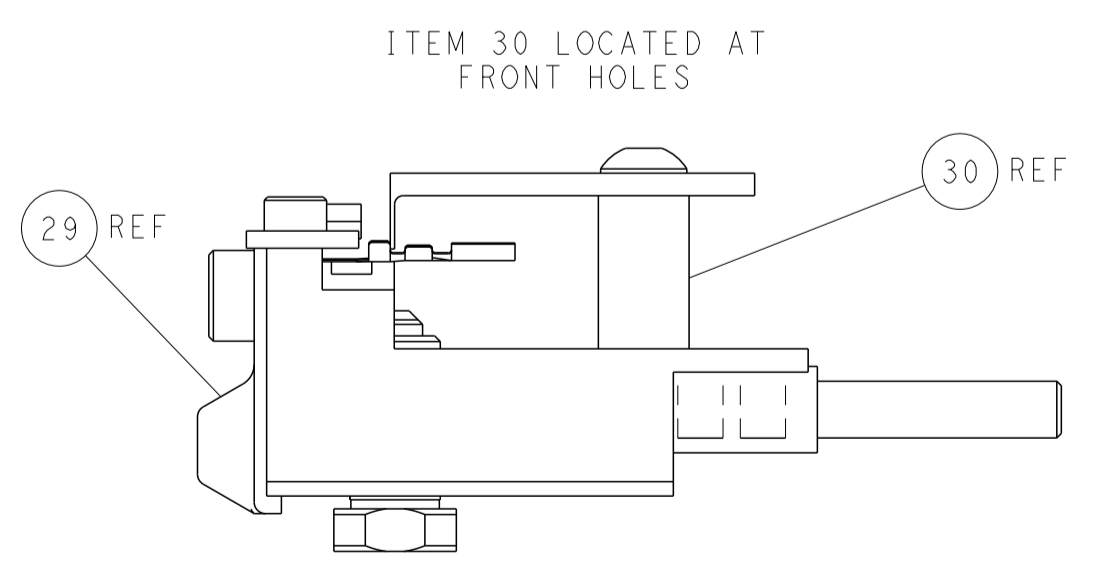
CAM POSITIONS



TERMINAL SUPPORT LOCATION



RAM AND HOLDDOWN SET-UP



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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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: A1 CAGE CODE: 00779 DRAWING NO: C-2151679	RESTRICTED TO: SCALE: 1:2 SHEET: 4 OF 4 REV: E
MATERIAL:		WEIGHT: Customer Accessible Production Drawing	