

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151089-1	D	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2151089-2	E	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151089-1	D	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2151089-2	E	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2151089-7	C	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	3.05 mm [.120]	F
INSUL	4.57 mm [.180]	OV

APPLICATOR INSTRUCTIONS
408-35042

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: FASTIN-FASTON CONNECTOR .312 FLAG REC. CONTACT.			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
6.40-7.20 mm [.252-.283 IN]		Ø2.50-3.80 mm [.098-.150 IN]	
TERMINAL APPLICATION SPECIFICATION	114-3118		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
180453-1	180453-2	180453-4	180453-6
1-180453-2			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
2.50mm2	1.90 +/- 0.05 [0.075 +/- .002]	6.8
2.00mm2	1.75 +/- 0.05 [0.069 +/- .002]	8.6
1.50mm2	1.62 +/- 0.05 [0.064 +/- .002]	9.6
1.00mm2	1.47 +/- 0.05 [0.058 +/- .002]	11.3

- 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 GRIND TO LENGTH AT ASSEMBLY.
- 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					
A	66	P	LTN	DESCRIPTION	DATE	DWN	APVD
		C		ECR-16-005378	13APR2016	XZ	JDG
		D		ECR-19-006751	26APR2019	LG	CT
		D1		ECR-19-009798	24JUN2019	FZ	TE
		E		ECR-21-119976	05NOV2021	TB	RK

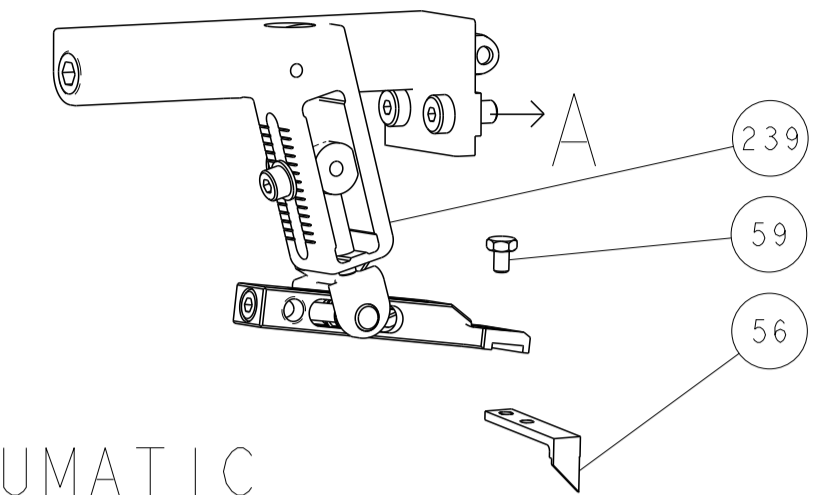
-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248
-	1	1	1	1	2119082-6	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	-	1	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	1	-	1	-	2844940-1	AIR FEED MODULE	238
-	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	1	1	1	1	2217068-1	BRACKET, AIR BLAST	130
-	1	1	1	1	2030758-3	TUBING, POLYURETHANE	129
-	1	1	1	1	5018030-2	NUT, HEX, REG, RoHS, M4	128
-	1	1	1	1	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	127
-	1	1	1	1	986220-3	CLAMP, CABLE, BLACK	126
-	1	1	1	1	1-22281-8	SPRING, COMPRESSION	121
-	1	1	1	1	3-690487-8	GUIDE, FRONT STRIP	115
-	1	1	1	1	23238-1	INSERT, COUPLING	101
-	1	1	1	1	980371-4	SCR, SKT HD SHLDR 5.0 DIA X 6.0	100
-	1	1	1	1	2844908-1	SCREW, LOCKING	99
-	2	2	2	2	2168400-1	SHCS, LOW HEAD, RoHS, M4 X 12	98
-	1	1	1	1	2844907-1	POST, LOCKING	97
-	1	1	1	1	2168083-6	SCR, SKT HD CAP, RoHS, M5 X 65	93
-	2	2	2	2	2-18032-5	SCR, SET, FLT PNT, M5 X 20.0	91
-	2	2	2	2	1-2168083-3	SCR, SKT HD CAP, RoHS, M3 X 16	85
-	1	1	1	1	455888-5	SPACER, CRIMPER	82
-	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	1338685-2	PAWL, FEED	56
-	2	2	2	2	1-18023-4	SCR, SKT HD CAP M4 X 20.0	53
-	1	1	1	1	1803011-4	HOLDER, SLUG BLADE	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	1803583-1	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
-	2	2	2	2	2079383-8	SCR, BHSC, RoHS (M4 X 16)	33
-	2	2	2	2	5-2844962-7	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	1	1	1-2844938-9	PLATE, STRIP GUIDE	29
-	2	2	2	2	22282-1	SPRING, COMPRESSION	27
-	1	1	1	1	356835-1	LEVER, DRAG RELEASE	26
-	1	1	1	1	6-690754-4	DRAG, SPECIAL	25
-	1	1	1	1	7-690440-5	GUIDE, REAR STRIP	23
-	2	2	2	2	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	21
-	4	4	4	4	1-18028-2	WASHER, FLAT, REG M4	20
-	1	1	1	1	2161830-1	COMBINATION STRIPPER	19
-	1	1	1	1	2-1583859-0	BLADE, SLUG	10
-	1	1	1	1	2-1803012-3	PLATE, REAR SHEAR	9
1	2	2	1	1	1803010-1	ANVIL, SPCEIAL, COMBINATION	8
-	1	1	1	1	238009-3	BLOCK, FL CRIMPER SPACER	4
1	2	2	1	1	7-2119785-0	CRIMPER, INSULATION OVERLAP PREMIUM	3
-	1	1	1	1	3-455888-7	SPACER, CRIMPER	2
1	2	2	1	1	2-456409-9	CRIMPER, WIRE .120 "F" PREMIUM	1
-	77	-72	-71	-2	-1	PART NO	ITEM NO

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

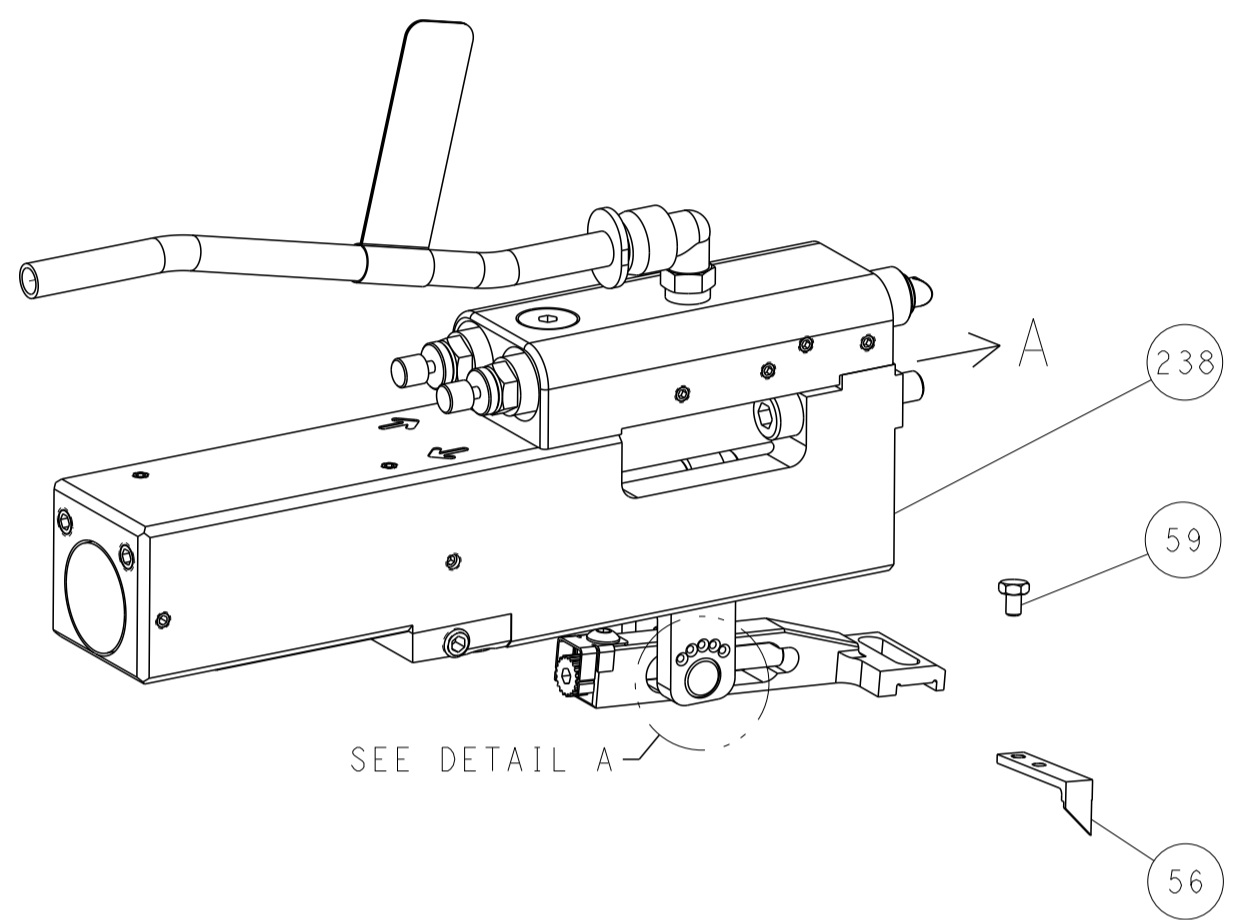
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CHK	T. ELBIN	26MAY2011	
APVD	S. XI	26MAY2011	
NAME	Ocean Side Feed Applicator		
SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
A1	00779	2151089	
Customer Accessible Production Drawing		SCALE	1:2
		SHEET	1 of 4
		REV	E

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

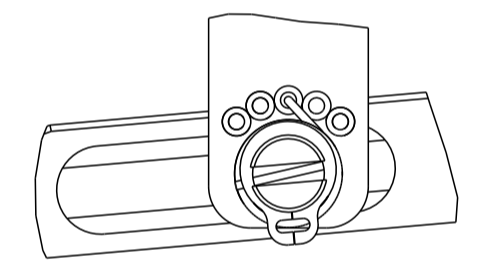
FEED TYPE MECHANICAL



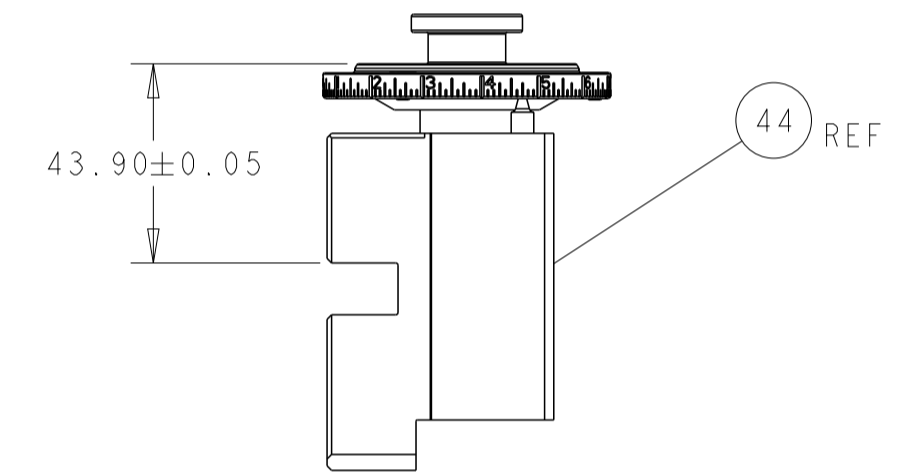
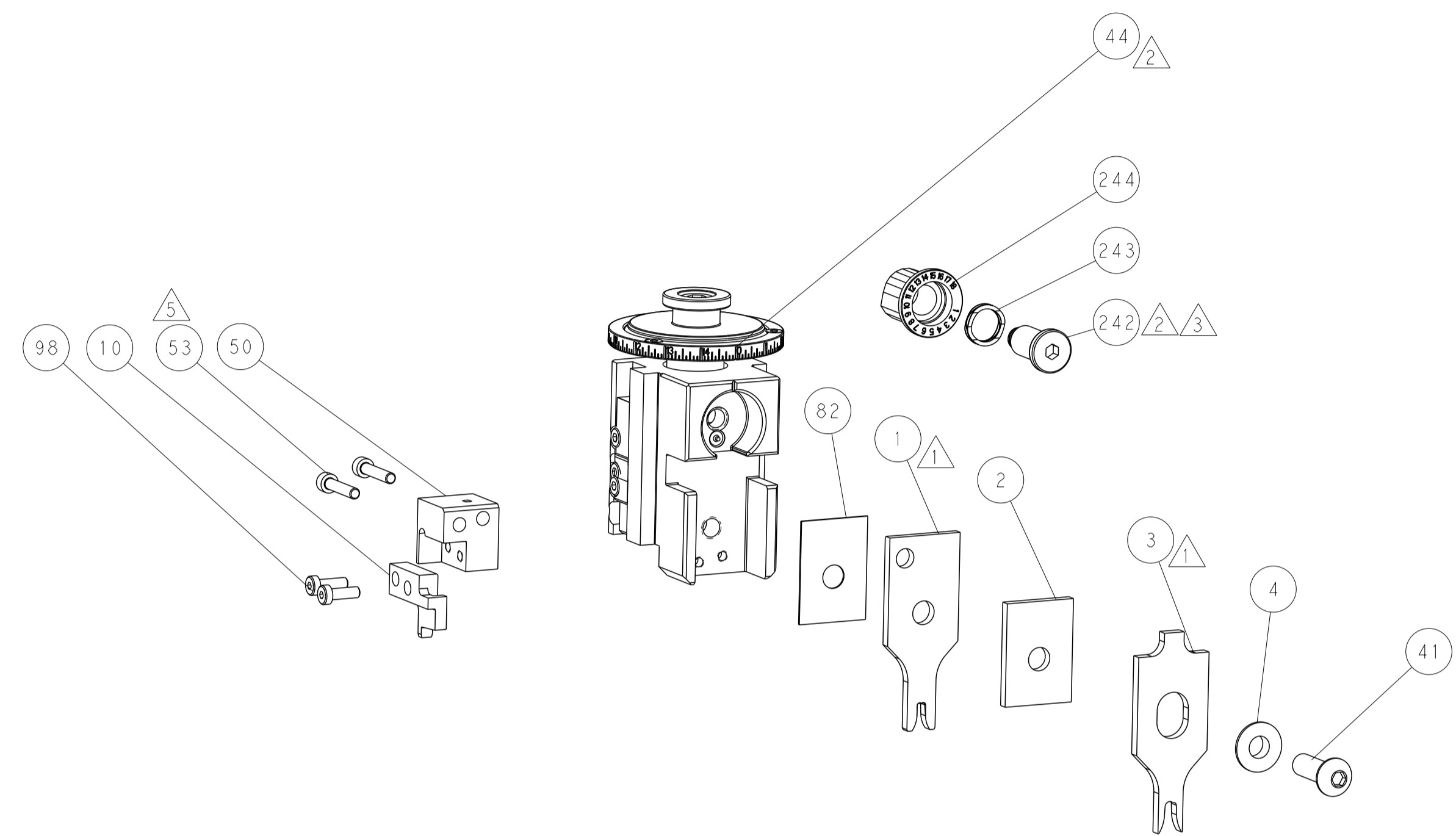
PNEUMATIC



FEED SPRING SETTING POSITION
(SHOWN FROM REAR SIDE)

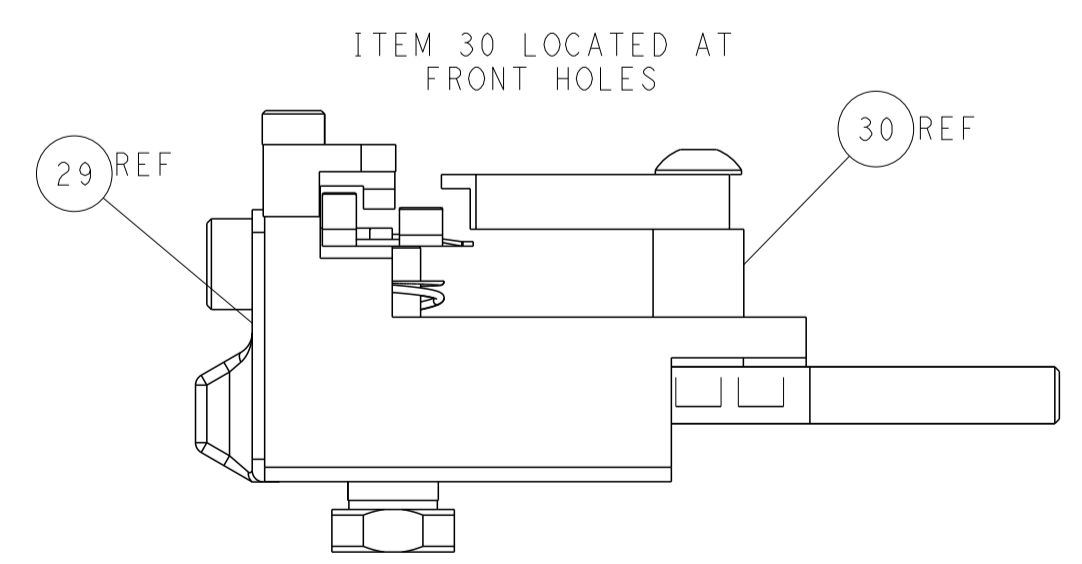
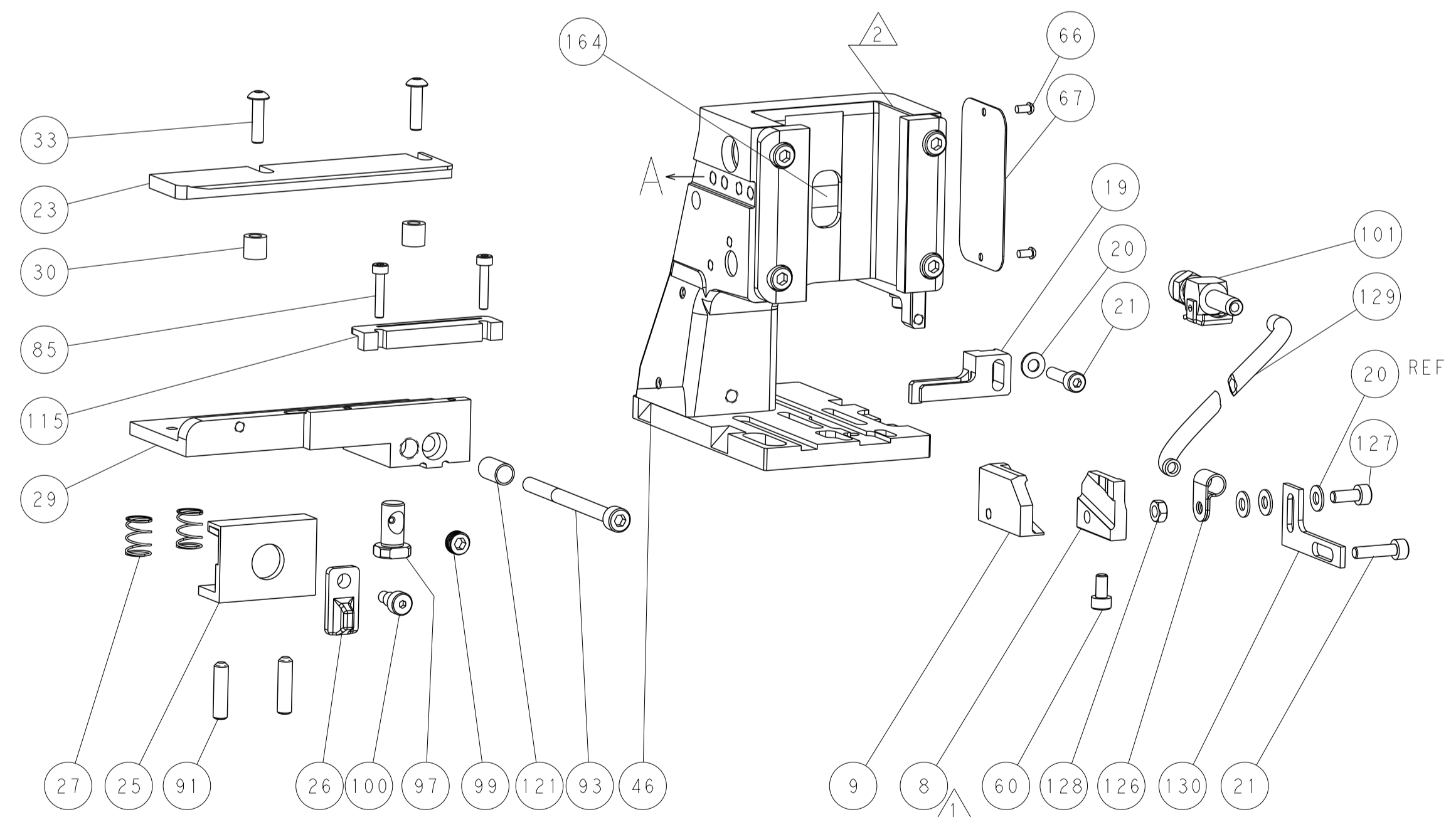
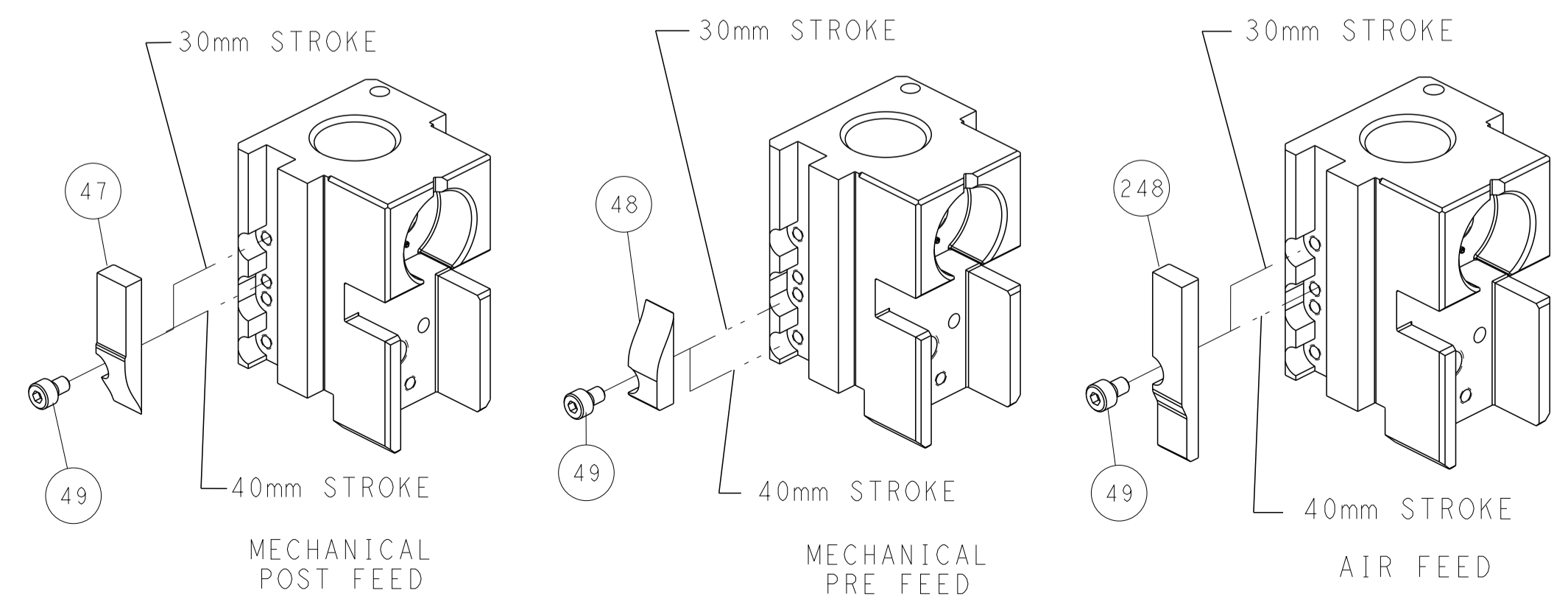


DETAIL A



RAM SET-UP

CAM POSITIONS



FEED TRACK POSITION
GUIDE BY INSULATION AND BODY

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 26MAY2011 CHK: T_ELFIN 26MAY2011 APVD: S_XI 26MAY2011	NAME: Ocean Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2151089	TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± MATERIAL: - FINISH: -	WEIGHT: - SCALE: 1:2 SHEET: 2 of 4 REV: E	RESTRICTED TO: -	CUSTOMER ACCESSIBLE PRODUCTION DRAWING	SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

THIS DRAWING IS UNPUBLISHED.	RELEASED FOR PUBLICATION		
COPYRIGHT 20 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.			
PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2151089-1	D	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2151089-2	E	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151089-7	C	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	3.05 mm [.120]	F
INSUL	4.57 mm [.180]	OV
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: FASTIN-FASTON CONNECTOR .312 FLAG REC. CONTACT.			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
6.40-7.20 mm [.252-.283 IN]		∅2.50-3.80 mm [.098-.150 IN]	
TERMINAL APPLICATION SPECIFICATION	114-3118		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
180453-1	180453-2	180453-4	180453-6
1-180453-2			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
2.50mm2	1.90 +/- 0.05 [.075 +/- .002]	6.8
2.00mm2	1.75 +/- 0.05 [.069 +/- .002]	8.6
1.50mm2	1.62 +/- 0.05 [.064 +/- .002]	9.6
1.00mm2	1.47 +/- 0.05 [.058 +/- .002]	11.3

- 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 GRIND TO LENGTH AT ASSEMBLY.
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.

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

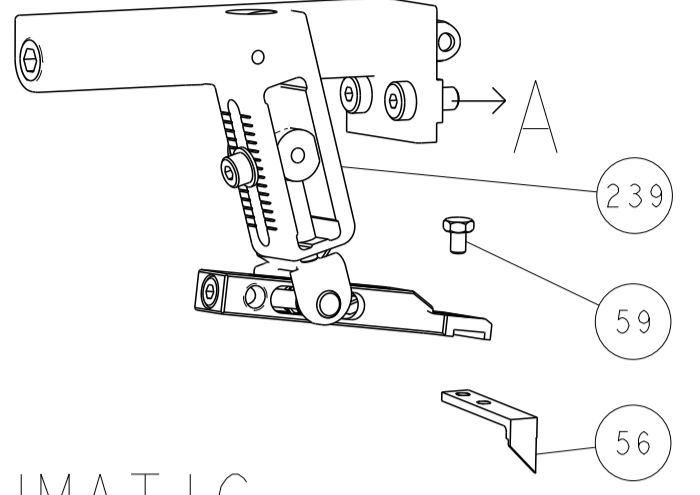
LOC	DIST	REVISIONS					
A	66	P	LTN	DESCRIPTION	DATE	OWN	APVD
		-		SEE SHEET 1			

-	1	1	2119082-6	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	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
-	-	1	2119653-2	FEED CAM, POST FEED	142
-	1	1	1803583-2	APPLICATOR BASIC ASSEMBLY, SF	141
-	1	1	1803516-1	RAM ASSEMBLY, SF PACIFIC	140
-	1	1	2217068-1	BRACKET, AIR BLAST	130
-	1	1	2030758-3	TUBING, POLYURETHANE	129
-	1	1	5018030-2	NUT, HEX, REG, RoHS, M4	128
-	1	1	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	127
-	1	1	986220-3	CLAMP, CABLE, BLACK	126
-	1	1	1-22281-8	SPRING, COMPRESSION	121
-	1	1	3-690487-8	GUIDE, FRONT STRIP	115
-	1	1	23238-1	INSERT, COUPLING	101
-	1	1	980371-4	SCR, SKT HD SHLDR 5.0 DIA X 6.0	100
-	1	1	2844908-1	SCREW, LOCKING	99
-	2	2	2168400-1	SHCS, LOW HEAD, RoHS, M4 X 12	98
-	1	1	2844907-1	POST, LOCKING	97
-	1	1	2168083-6	SCR, SKT HD CAP, RoHS, M5 X 65	93
-	2	2	2-18032-5	SCR, SET, FLT PNT, M5 X 20.0	91
-	2	2	1-2168083-3	SCR, SKT HD CAP, RoHS, M3 X 16	85
-	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	1338685-2	PAWL, FEED	56
-	2	2	1-18023-4	SCR, SKT HD CAP M4 X 20.0	53
-	1	1	1803011-4	HOLDER, SLUG BLADE	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
-	2	2	2079383-8	SCR, BHSC, RoHS (M4 X 16)	33
-	2	2	5-2844962-7	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	1-2844938-9	PLATE, STRIP GUIDE	29
-	2	2	22282-1	SPRING, COMPRESSION	27
-	1	1	356835-1	LEVER, DRAG RELEASE	26
-	1	1	6-690754-4	DRAG, SPECIAL	25
-	1	1	7-690440-5	GUIDE, REAR STRIP	23
-	2	2	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	21
-	4	4	1-18028-2	WASHER, FLAT, REG M4	20
-	1	1	2161830-1	COMBINATION STRIPPER	19
-	1	1	2-1583859-0	BLADE, SLUG	10
-	1	1	2-1803012-3	PLATE, REAR SHEAR	9
-	1	1	1803010-1	ANVIL, SPECIAL, COMBINATION	8
-	1	1	238009-3	BLOCK, FL CRIMPER SPACER	4
-	1	1	7-2119785-0	CRIMPER, INSULATION OVERLAP PREMIUM	3
-	1	1	3-455888-7	SPACER, CRIMPER	2
-	1	1	2-456409-9	CRIMPER, WIRE .120 "F" PREMIUM	1

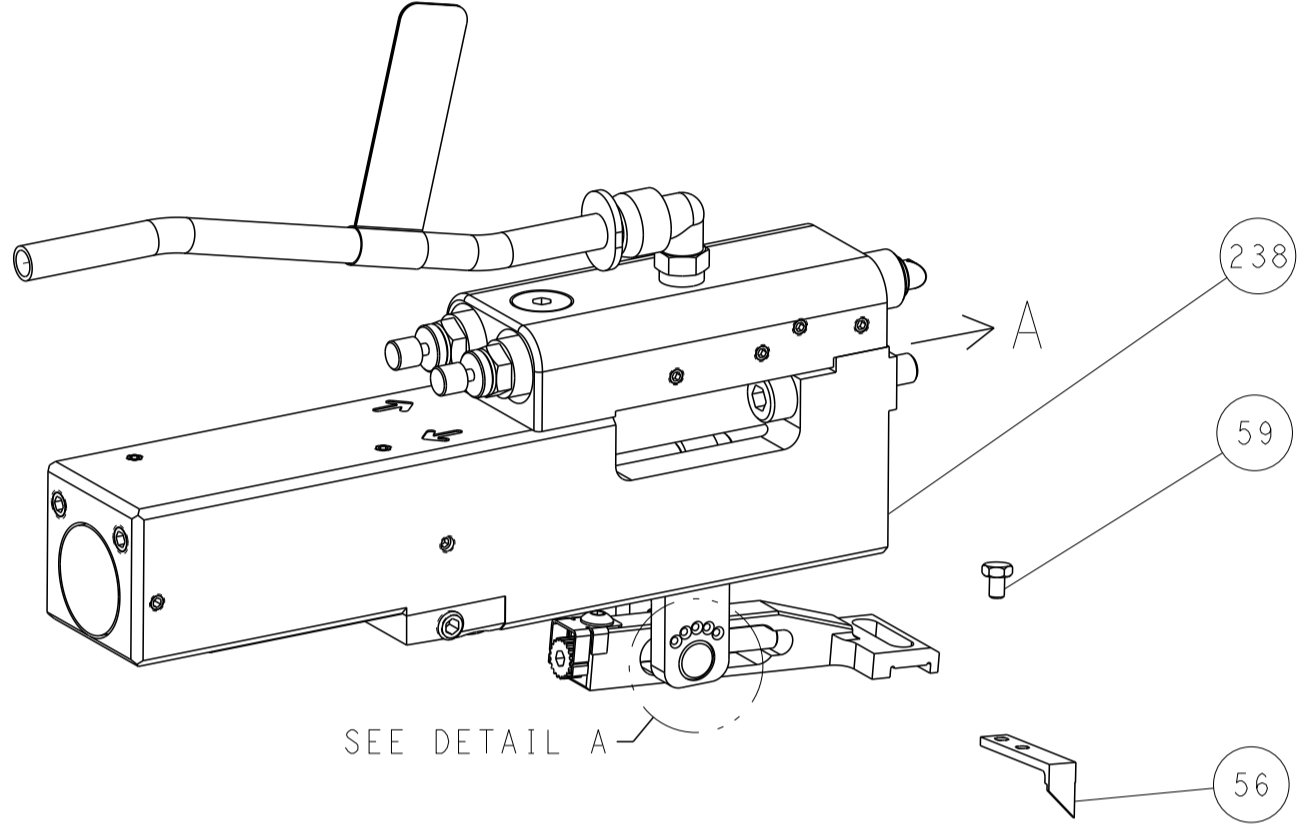
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN S.ZOU 26MAY2011		TE Connectivity	
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		1 PLC ±		APVD S.XI 26MAY2011		NAME	
		2 PLC ±		PRODUCT SPEC		Ocean Side Feed	
		3 PLC ±		APPLICATION SPEC		Applicator	
		4 PLC ±		SIZE		CAGE CODE DRAWING NO	
		ANGLES		A1 00779		©=2151089	
		FINISH		WEIGHT		RESTRICTED TO	
				Customer Accessible Production Drawing		SCALE 1:2 SHEET 3 OF 4 REV E	

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

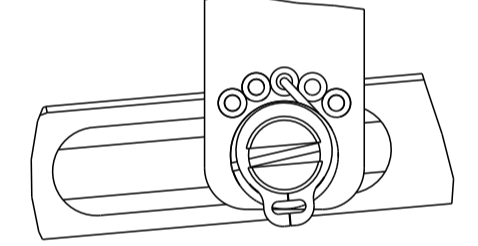
FEED TYPE MECHANICAL



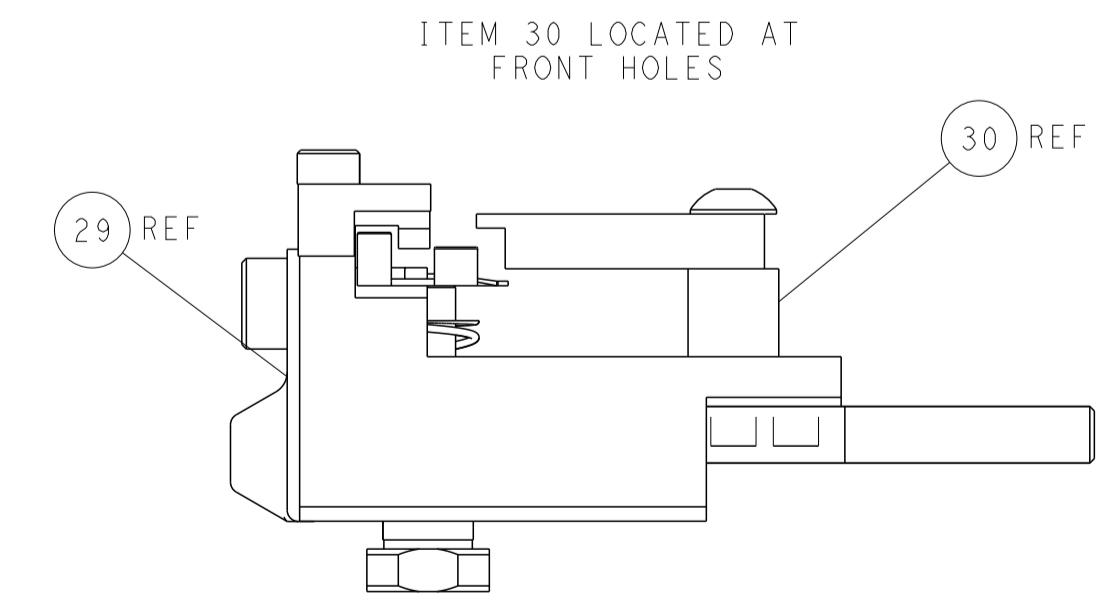
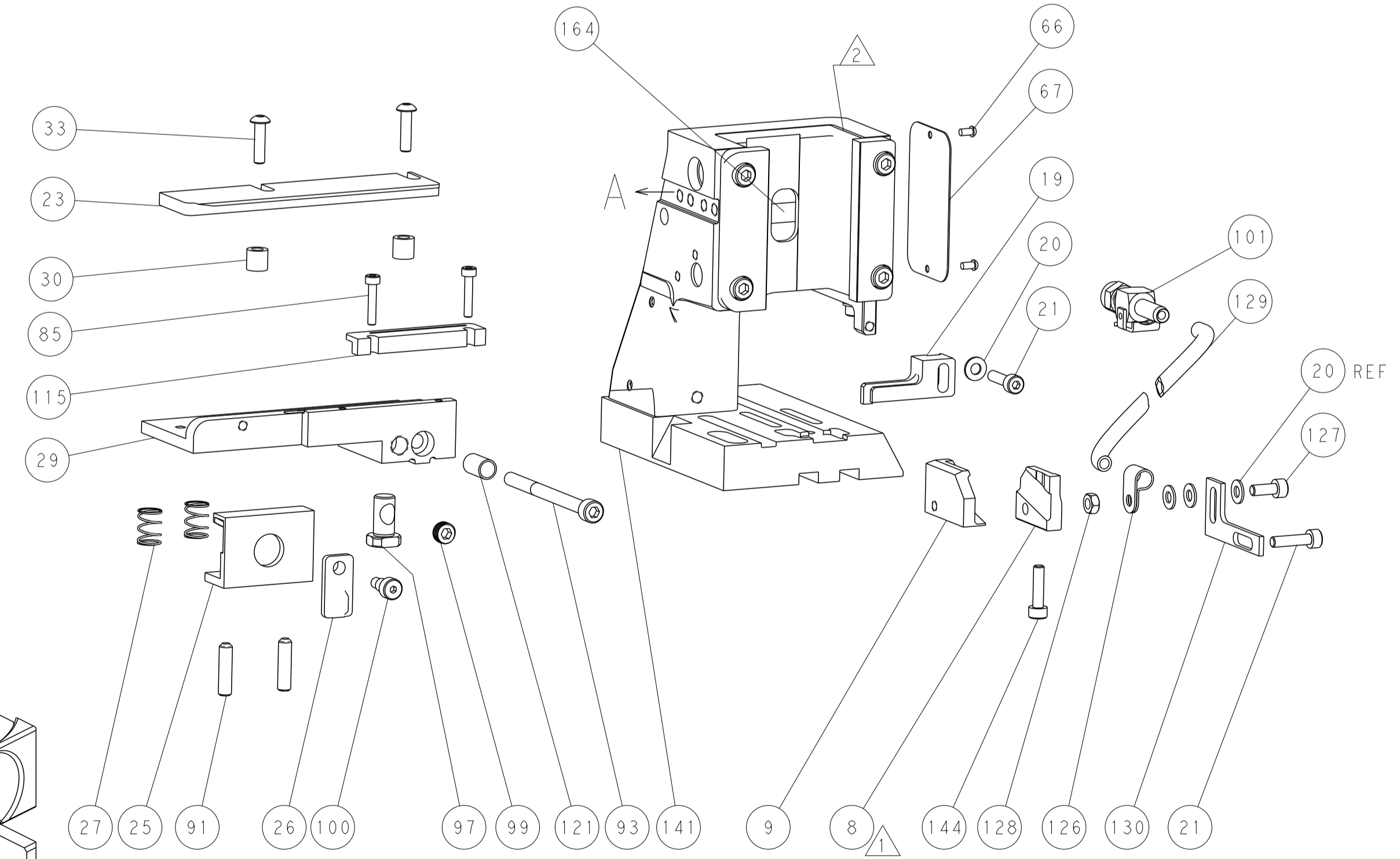
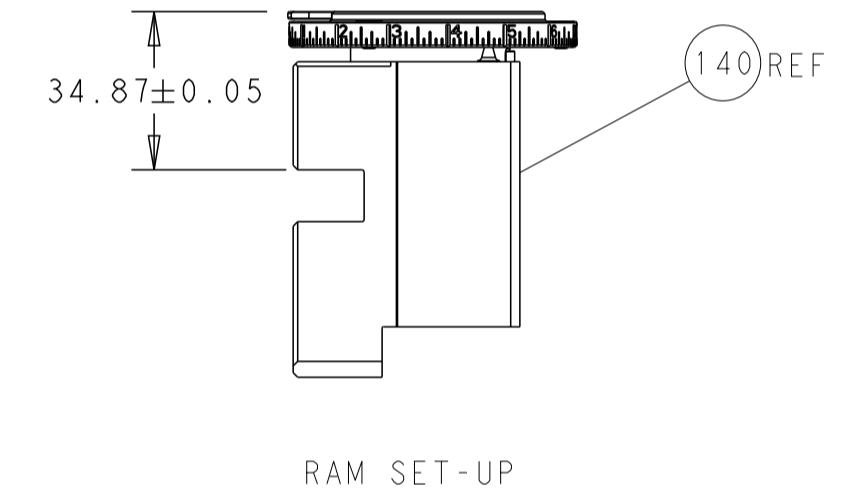
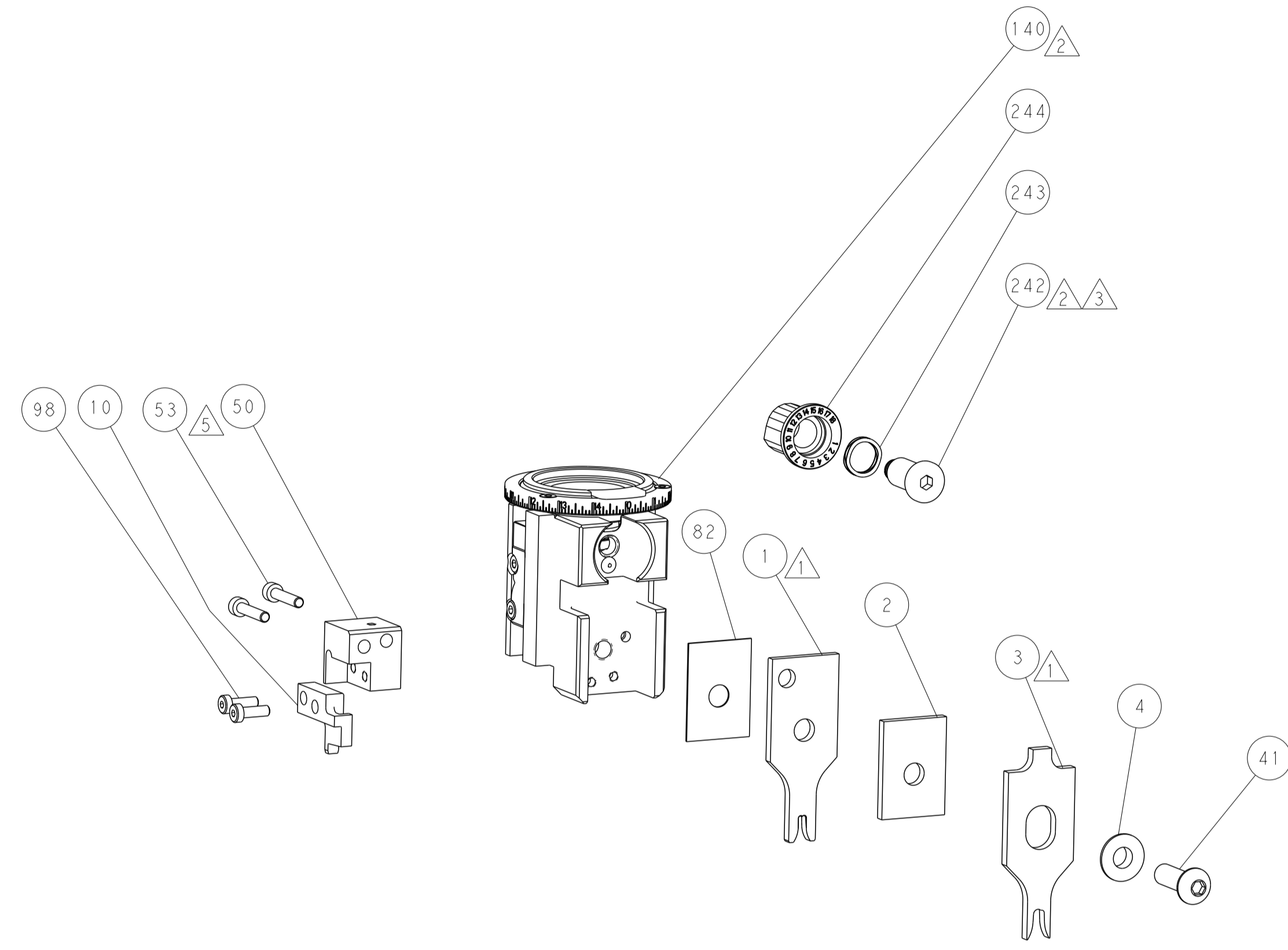
PNEUMATIC



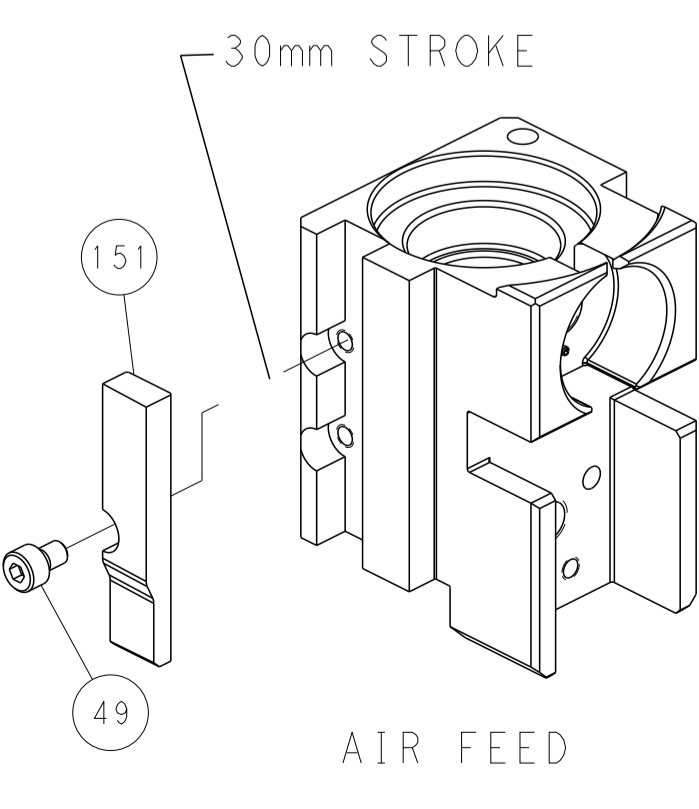
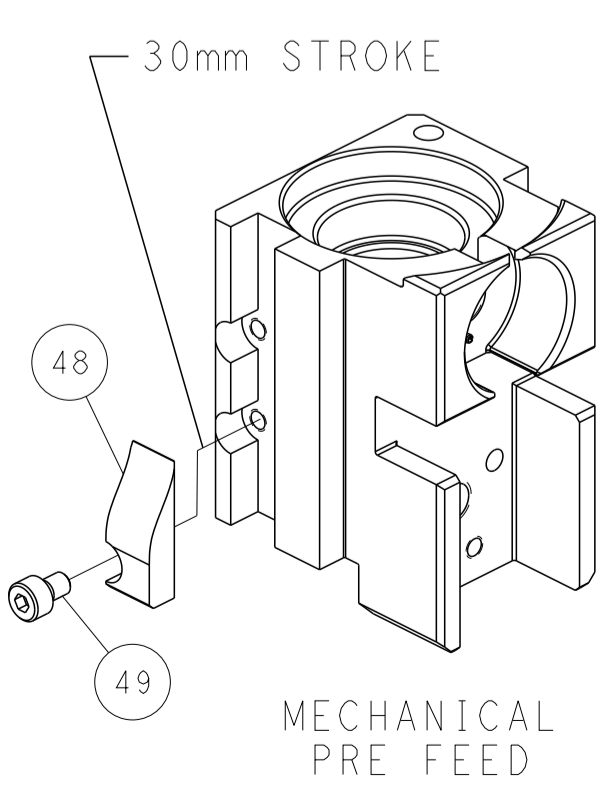
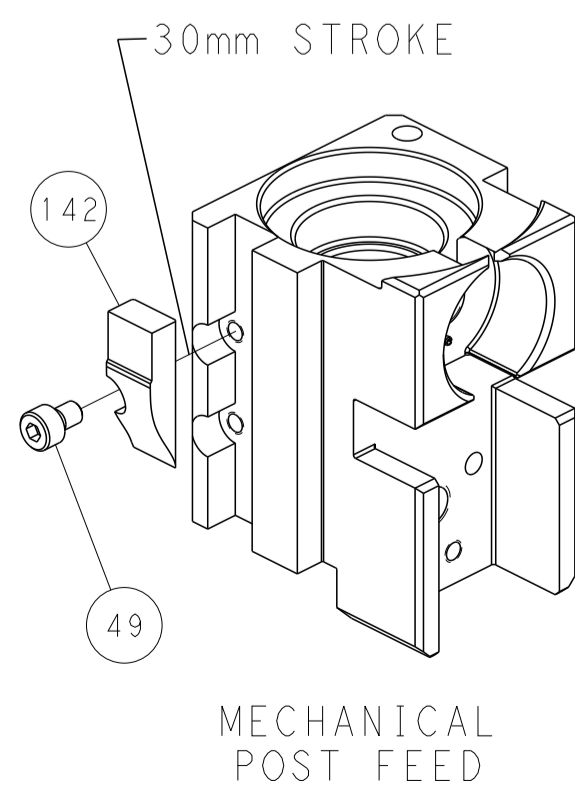
FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



DETAIL A



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:		OWN: S. ZOU 26MAY2011		TE Connectivity	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	Harrisburg, PA 17105-3608	
MATERIAL:		FINISH:		APVD: S. XI 26MAY2011		NAME: Ocean Side Feed Applicator	
				PRODUCT SPEC:		SIZE: CAGE CODE: DRAWING NO: RESTRICTED TO	
				APPLICATION SPEC:		A1 00779 ©=2151089	
				WEIGHT:		SCALE: 1:2 SHEET 4 OF 4 REV E	
				Customer Accessible Production Drawing		SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION	