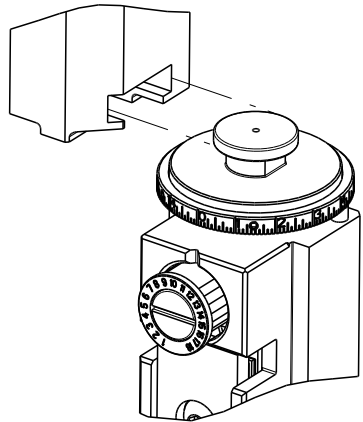


8		7	
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20		20	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151618-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2151618-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151618-1	C	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2151618-2	C	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2151618-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.03 mm [.080]	F
INSUL	3.30 mm [1.130]	O
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: BOSCH TERMINAL		BOSCH CRIMP SPECIFICATION	
TERMINAL NAME: TAB 1.2X0.6 CONTACT			
WIRE STRIP LENGTH 3.99-4.60 mm [1.57-.181 IN]		INSULATION DIAMETER RANGE Ø 	
TERMINAL APPLICATION SPECIFICATION 	-	-	-
TERMINALS APPLIED			

TE TERMINAL	BOSCH TERMINAL	TE SEAL	BOSCH SEAL	CABLE Ø
2177467-1	1928492467	2177468-1	1928300934	Ø 1.2-1.6
		964972-1	964972-1	Ø 1.9-2.4
		964971-1	964971-1	Ø 1.2-1.6

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.00mm2	1.36+/-0.05 [1.054+/-0.002]	8.0
0.75mm2	1.27+/-0.05 [1.050+/-0.002]	9.1
0.61mm2	1.20+/-0.05 [1.047+/-0.002]	9.7
0.50mm2	1.18+/-0.05 [1.046+/-0.002]	10.1



- 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 THIS APPLICATOR APPLIES TERMINAL WITH A SEAL.
- 7 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.

*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.

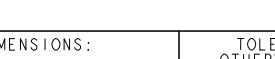
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

2		1					
LOC	DIST	REVISIONS					
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		B		ECR-15-002514	16FEB2015	MR	GB
		C		ECR-23-187394	18SEP2023	JWC	TE

-	1	1	1	1	1803945-4	TONKER	300
-	1	1	1	1	22278-9	SPRING, COMPRESSION	299
-	2	2	2	2	4-18032-3	SCR, SET, FLT PNT, M3 X 6.0	298
-	1	1	1	1	1803944-1	SPACER, TONKER	297
-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248
-	1	1	1	1	2119082-4	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	18023-1	SCR, SKT HD CAP M3 X 5.0	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	1-18028-2	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	455888-5	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	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	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	53
-	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	1803515-1	RAM ASSEMBLY, SF ATLANTIC	44
-	1	1	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
-	1	1	1	1	3-1752356-3	SUPPORT, TERMINAL	34
-	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	2	2	2-2844962-8	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29
-	1	1	1	1	455888-7	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	2119533-1	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	318707-1	FLOATING SHEAR, FRONT	9
1	2	2	1	1	1333204-5	ANVIL, COMBINATION	8
-	1	1	1	1	240641-5	SPACER	7
-	-	-	-	-	-	-	6
-	1	1	1	1	2119781-1	DEPRESSOR, SHEAR	5
-	1	1	1	1	238011-4	BLOCK, CRIMPER SPACER	4
1	2	2	1	1	2119784-4	CRIMPER, INSULATION O PREMIUM	3
-	1	1	1	1	1-455888-2	SPACER, CRIMPER	2
1	2	2	1	1	1-456405-5	CRIMPER, WIRE PREMIUM	1
-77-72-71	-2	-1	PART NO		DESCRIPTION		ITEM NO

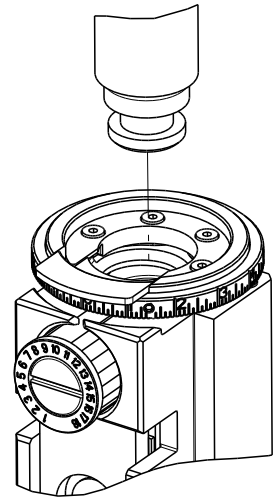
THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. THE USER SHALL BE RESPONSIBLE FOR OBTAINING THE LATEST EDITION.				DWN C. CHEN CHK S. XI APVD J. CRUZ	15MAR2012 15MAR2012 15MAR2012	TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		NAME		Ocean Side Feed Applicator	
mm		0 PLC ±.01 1 PLC ±.01 2 PLC ±.01 3 PLC ±.01 4 PLC ±.01 ANGLES ±.01 FINISH		PRODUCT SPEC		-	
MATERIAL		-		APPLICATION SPEC		-	
-		-		WEIGHT		-	
-		-		SIZE		CAGE CODE	
-		-		DRAWING NO		RESTRICTED TO	
-		-		00779		C=2151618	
-		-		Customer Accessible Production Drawing		SCALE	
-		-		1:2		SHEET 1 OF 4	
-		-		REV		C	

SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

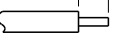
THIS DRAWING IS A CONFIDENTIAL DOCUMENT FOR TFCO. ANY SERVICES CORPORATION IT IS SUBJECT TO CHANGE AND THE CONTROLLING ENGINEERING ORGANIZATION SHALL BE NOTIFIED FOR ANY CHANGES TO THE DRAWING OR DESIGN.		DWN S. CHEN 15MAR2012		 TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm		CHK S. XI 15MAR2012			
		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.1 1 PLC ±.1 2 PLC ±.1 3 PLC ±.1 4 PLC ±.1 ANGLES ±.1		NAME OCEAN SIDE FEED APPLICATOR	
MATERIAL -		FINISH -		SIZE A	
WEIGHT -		PRODUCT SPEC -		CAGE CODE 00779	
DRAWING NO C-2151618		APPLICATION SPEC -		DRAWING NO C-2151618	
RESTRICTED TO -		SCALE 1:2		SHEET 2 OF 4	
REV C		CUSTOMER ACCESSIBLE PRODUCTION DRAWING		REV C	

8		7	
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20		20	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2151618-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2151618-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151618-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.03 mm [.080]	F
INSUL	3.30 mm [.130]	O
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: BOSCH TERMINAL		BOSCH CRIMP SPECIFICATION	
TERMINAL NAME: TAB 1.2X0.6 CONTACT			
WIRE STRIP LENGTH 3.99-4.60 mm [.157-.181 IN]			INSULATION DIAMETER RANGE  
TERMINAL APPLICATION SPECIFICATION	-	-	-
TERMINALS APPLIED			
TE TERMINAL	BOSCH TERMINAL	TE SEAL	BOSCH SEAL
2177467-1	1928492467	2177468-1	1928300934
		964972-1	964972-1
		964971-1	964971-1

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING
1.00mm2		1.36+/-0.05 [.054+/- .002]		8.0
0.75mm2		1.27+/-0.05 [.050+/- .002]		9.1
0.61mm2		1.20+/-0.05 [.047+/- .002]		9.7
0.50mm2		1.18+/-0.05 [.046+/- .002]		10.1



- 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.
5. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- THIS APPLICATOR APPLIES TERMINAL WITH A SEAL.
- 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.

*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				
		P	LTR	DESCRIPTION	DATE	DWN
A	66	-	-	SEE SHEET 1	-	-

-	1	1	1803945-4	TONKER	300
-	1	1	22278-9	SPRING, COMPRESSION	299
-	2	2	4-18032-3	SCR, SET, FLT PNT, M3 X 6.0	298
-	1	1	1803944-1	SPACER, TONKER	297
-	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	18023-1	SCR, SKT HD CAP M3 X 5.0	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	455888-5	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	985575-3	SCR, FLT SKT HD CAP M3 X 10.0	57
-	1	1	1338685-1	PAWL, FEED	56
-	2	2	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	53
-	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	3-1752356-3	SUPPORT, TERMINAL	34
-	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	2-2844962-8	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29
-	1	1	455888-7	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	2119533-1	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	318707-1	FLOATING SHEAR, FRONT	9
1	1	1	1333204-5	ANVIL, COMBINATION	8
-	1	1	240641-5	SPACER	7
-	-	-	-	-	6
-	1	1	2119781-1	DEPRESSOR, SHEAR	5
-	1	1	238011-4	BLOCK, CRIMPER SPACER	4
1	1	1	2119784-4	CRIMPER, INSULATION O PREMIUM	3
-	1	1	1-455888-2	SPACER, CRIMPER	2
1	1	1	1-456405-5	CRIMPER, WIRE PREMIUM	1

-77	-22	-21	PART NO	DESCRIPTION	ITEM NO
DWN			15MAR2012	TE Connectivity Harrisburg, PA 17105-3608	
CHK			15MAR2012		
S.XI				NAME Ocean Side Feed Applicator	
APVD			15MAR2012		
PRODUCT SPEC				SIZE CAGE CODE DRAWING NO	
APPLICATION SPEC					
WEIGHT			-	RESTRICTED TO	
MATERIAL			-	A1 00779 ©=2151618	
FINISH			-	Customer Accessible Production Drawing	
SCALE			1:2	SHEET 3 OF 4	
REV			C		

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

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

D

C

B

A

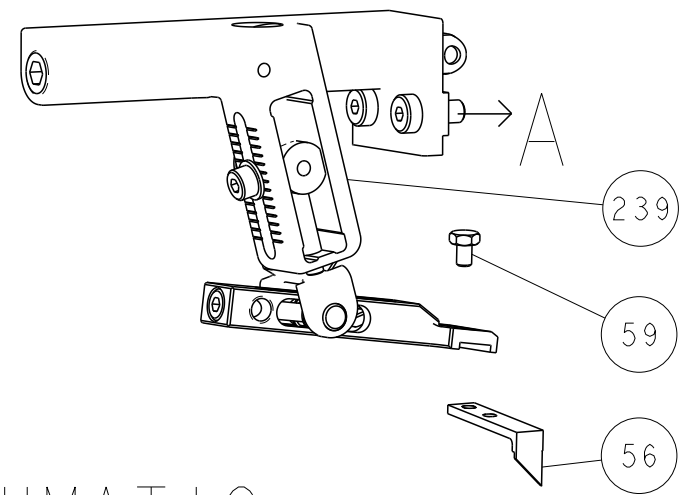
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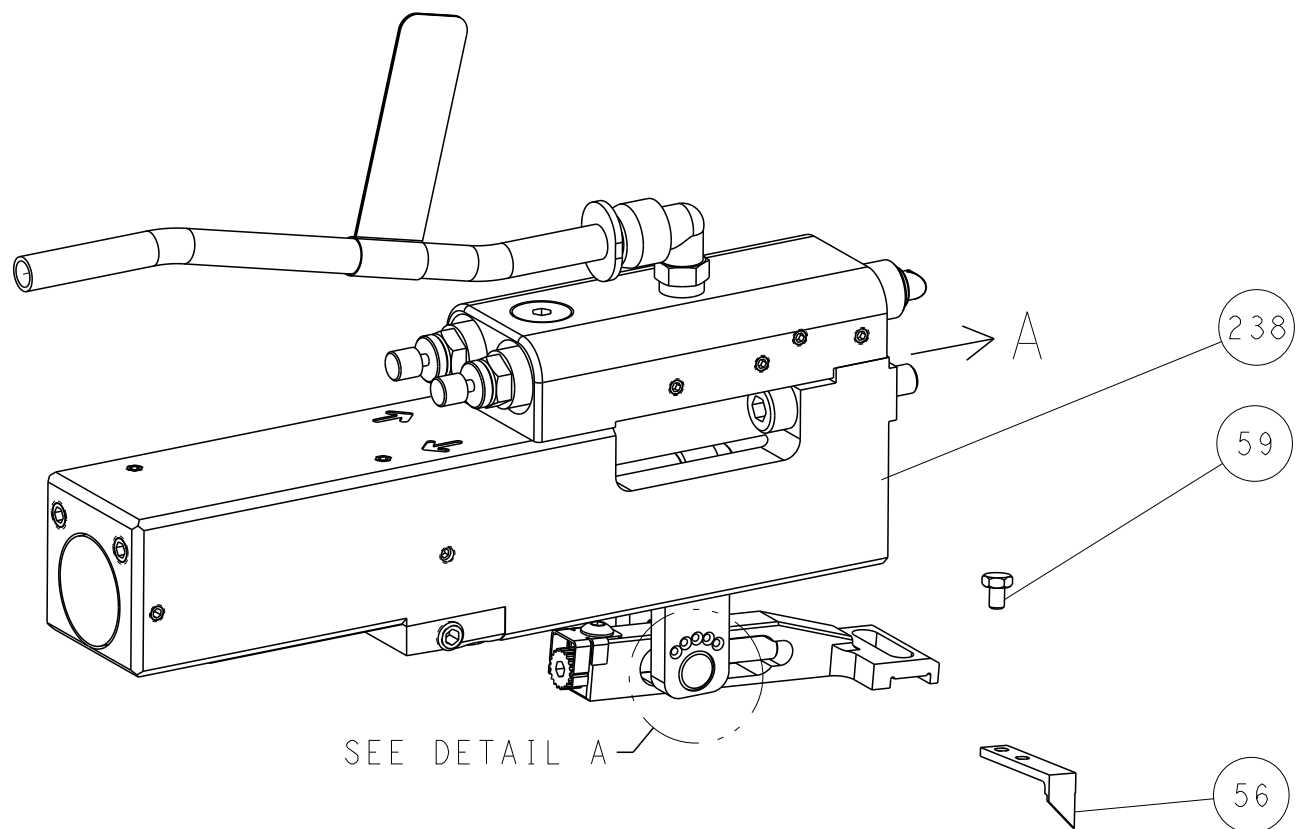
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A

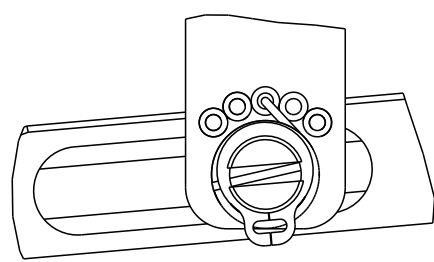
FEED TYPE MECHANICAL



PNEUMATIC

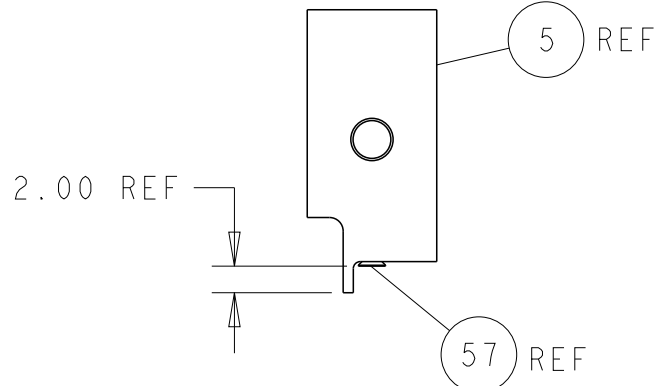
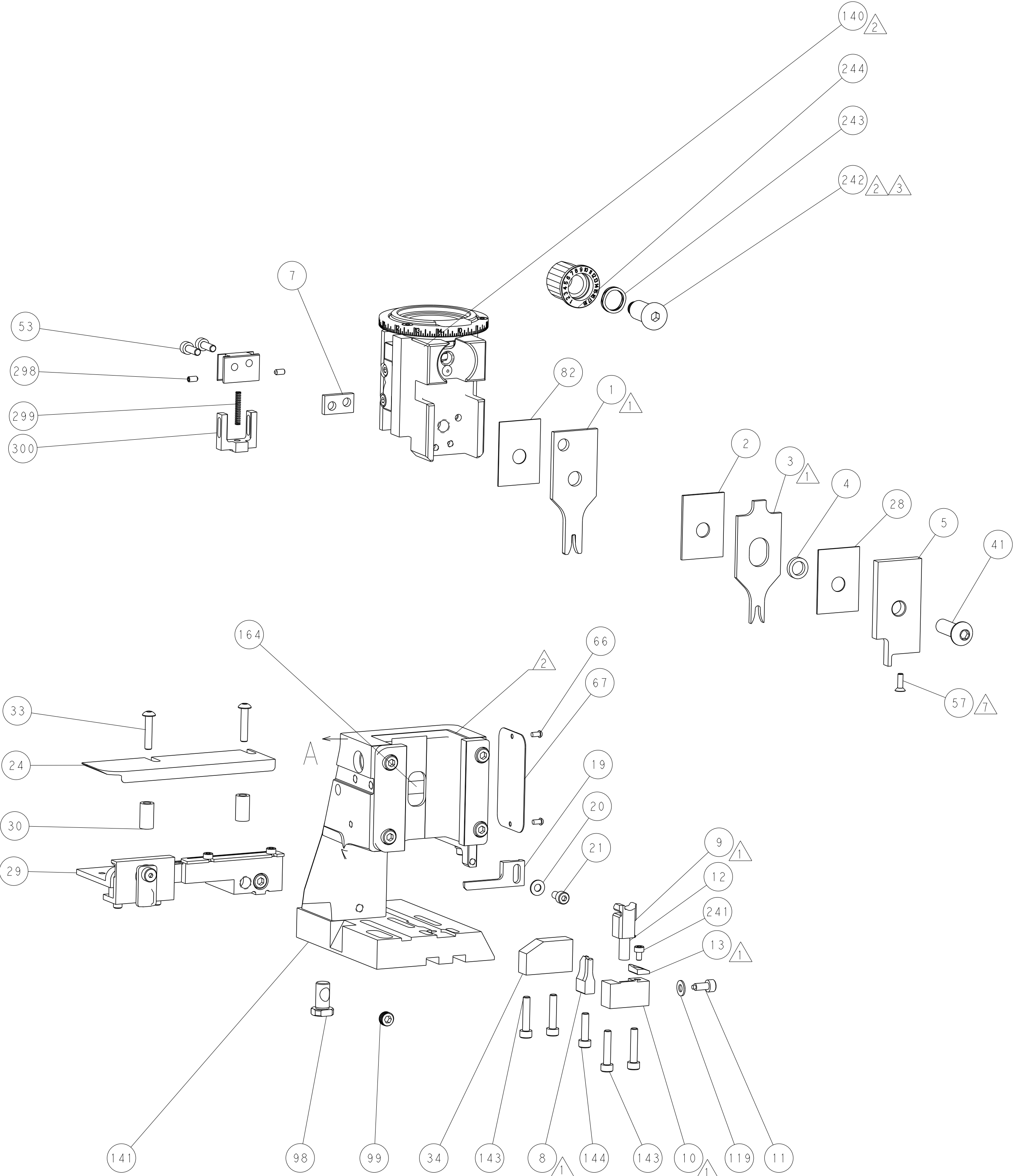
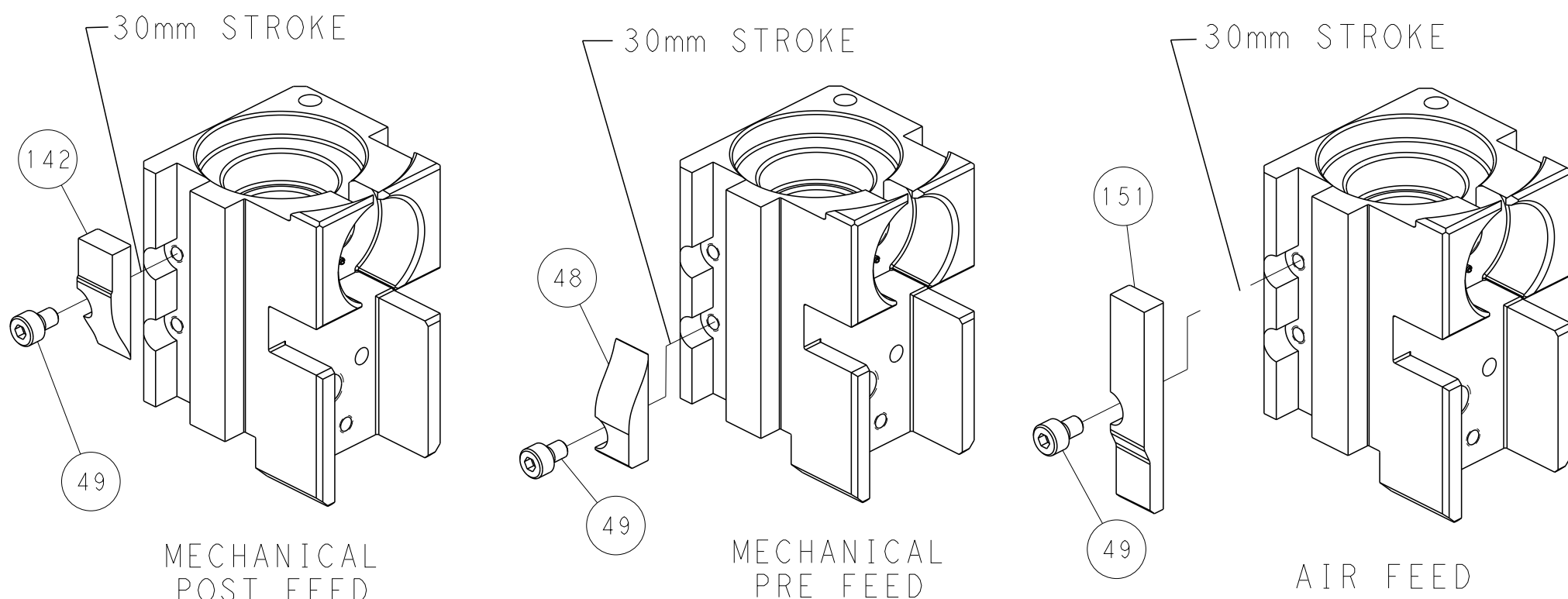


FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)

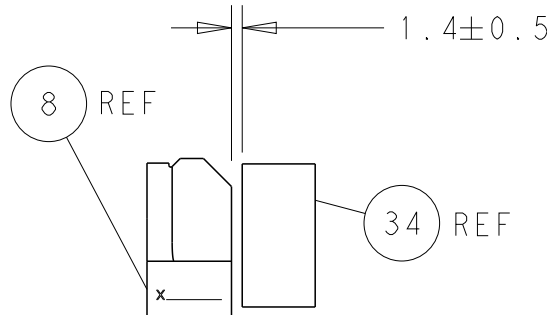


DETAIL A

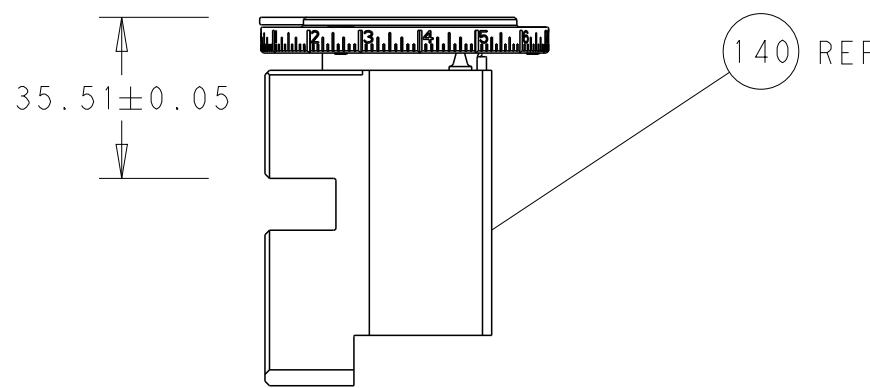
CAM POSITIONS



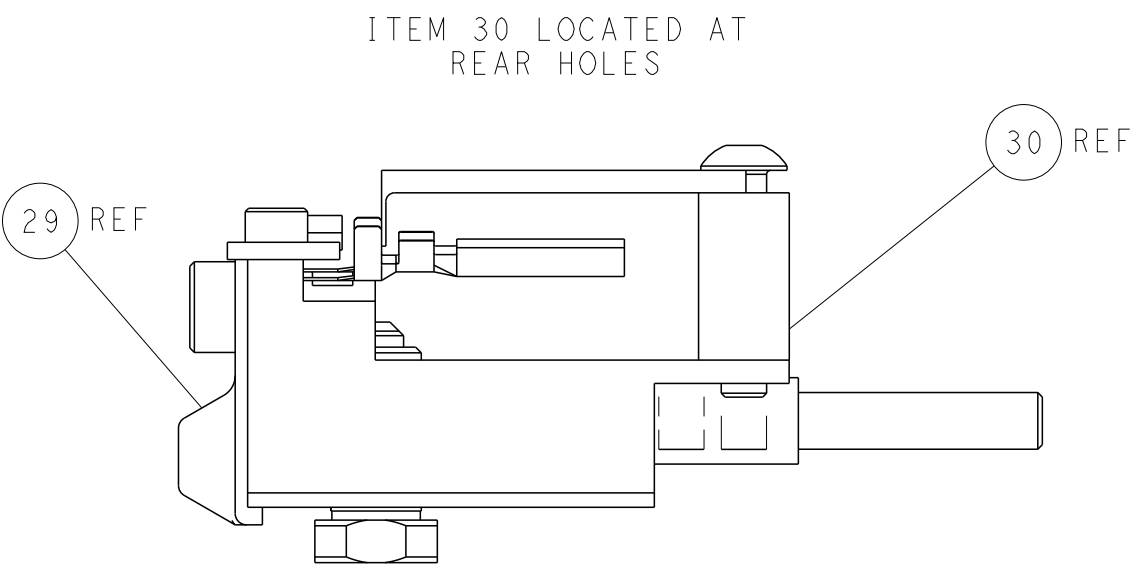
SHEAR DEPRESSOR DETAIL



TERMINAL SUPPORT LOCATION

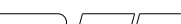


RAM SET-UP



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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										CHK		S. XI	15MAR2012	Harrisburg, PA 17105-3608															
										APVD		J. CRUZ	15MAR2012	NAME		Ocean Side Feed Applicator													
										PRODUCT SPEC																			
										APPLICATION SPEC				SIZE		CAGE CODE		DRAWING NO		RESTRICTED TO									
														A1		00779		C=2151618											
										WEIGHT				Customer Accessible Production Drawing				SCALE		1:2		SHEET		4 OF 4		REV		C	