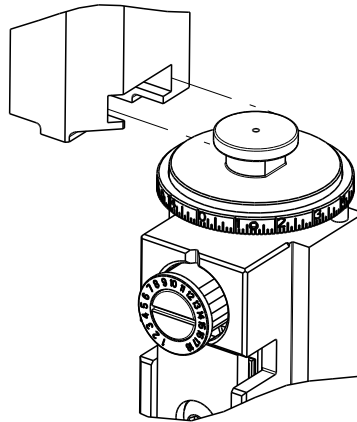
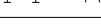


8		7	
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20		20	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151822-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2151822-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151822-1	C	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2151822-2	C	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2151822-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.40 mm [.055]	F
INSUL	1.57 mm [.062]	F
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: AMPMODU II RECEPTACLE CONTACT, HIGH PRESSURE			
WIRE STRIP LENGTH 3.56-4.32 mm [.140-.170 IN]			INSULATION DIAMETER RANGE Ø 0.00-1.60 mm [.000-.063 IN]
TERMINAL APPLICATION SPECIFICATION 		114-20004	-
		-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
281999-1	281556-2		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
20 AWG	0.89+/-0.03 [.035+/-0.001]	7.8
22 AWG	0.84+/-0.03 [.033+/-0.001]	8.4
24 AWG	0.74+/-0.03 [.029+/-0.001]	9.7



- 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 USEDER DOCUMENT, 101-35000.
- 6 GRIND TO LENGTH AT ASSEMBLY.

*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								
A	66	P	LTR	DESCRIPTION				DATE	DWN	APVD
			A	RELEASED				04FEB2013	LG	TE
			A1	ECR-14-015170				13OCT2014	KH	UG
			B	ECR-22-151466				05SEP2022	FZ	GB
			C	ECR-22-159590				26NOV2022	TB	TE

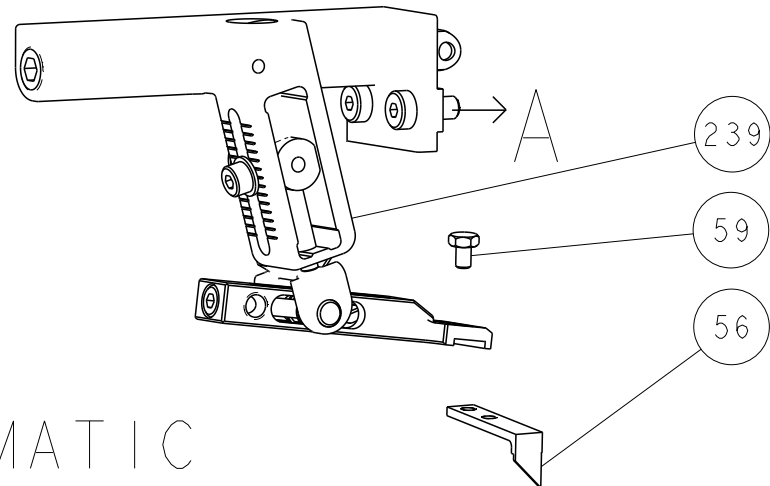
	-	1	1	1	1	2119791-6	DEPRESSOR, WIRE	286
	-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248
	-	1	1	1	1	2119082-8	CAM, SNAIL, INSULATION ADJUSTMENT	244
3	-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
	-	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
	-	2	2	2	2	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
	-	-	1	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
	-	1	-	1	-	2844940-1	AIR FEED MODULE	238
	-	1	1	1	1	356885-4	STOP, SHEAR	237
	-	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	3-240641-1	SPACER	81
	-	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	1338685-1	PAWL, FEED	56
	-	4	4	4	4	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	54
	-	2	2	2	2	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	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
	-	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	2844992-2	ASSEMBLY, STRIP GUIDE	29
	-	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	690518-1	HOLD DOWN, TERMINAL	18
	-	1	1	1	1	690463-1	FLOATING SHEAR, REAR	17
	-	2	2	2	2	1-2168083-1	SCR, SKT HD CAP, RoHS, M3 X 6	16
6	-	1	1	1	1	1-690691-3	PLATE,REAR SHEAR	15
	-	1	1	1	1	2119862-1	SHEAR HOLDER, REAR	14
	-	2	2	2	2	2119806-1	INSERT, SHEAR	13
1	-	2	2	2	2	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	1	1633861-1	SHEAR, FLOATING	9
	1	2	2	1	1	1-1633932-8	ANVIL, COMBINATION	8
	-	-	-	-	-	-	-	7
1	-	1	1	1	1	690468-1	DEPRESSOR SHEAR, REAR	6
	-	1	1	1	1	2119757-4	DEPRESSOR, SHEAR	5
	-	1	1	1	1	2-238011-2	BLOCK, CRIMPER SPACER	4
1	1	2	2	1	1	1-1803017-0	CRIMPER, INSULATION F	3
	-	-	-	-	-	-	-	2
	1	2	2	1	1	7-456402-3	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 OF THIS DRAWING SHOULD BE CONTACTED FOR THE LATEST EDITION.		DWN BOB HIGMAN 20NOV2012	TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm		CHK T.ELBIN 20NOV2012	NAME Ocean Side Feed Applicator	
TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH ±		APVD M.CLIFFORD 20NOV2012	PRODUCT SPEC	
MATERIAL		APPLY SPEC	SIZE A1	
-		WEIGHT	00779 ©=2151822	
-		Customer Accessible Production Drawing		SCALE 1:2
		SHEET 1 OF 4		REV C

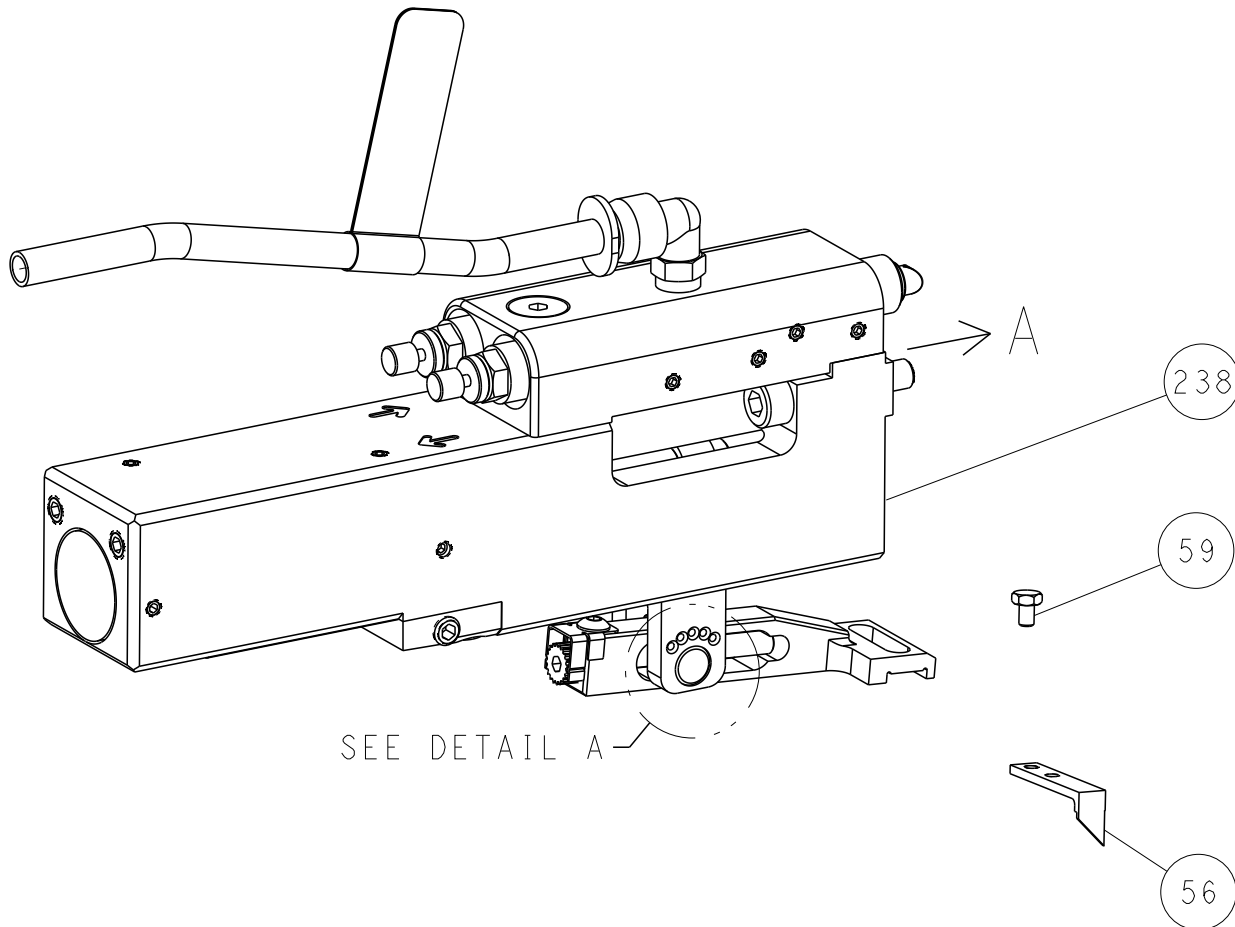
SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

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

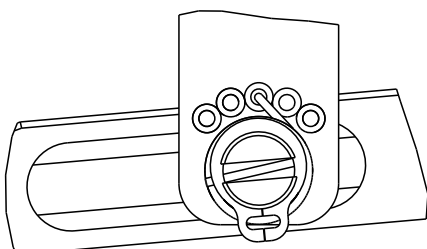
FEED TYPE MECHANICAL



PNEUMATIC

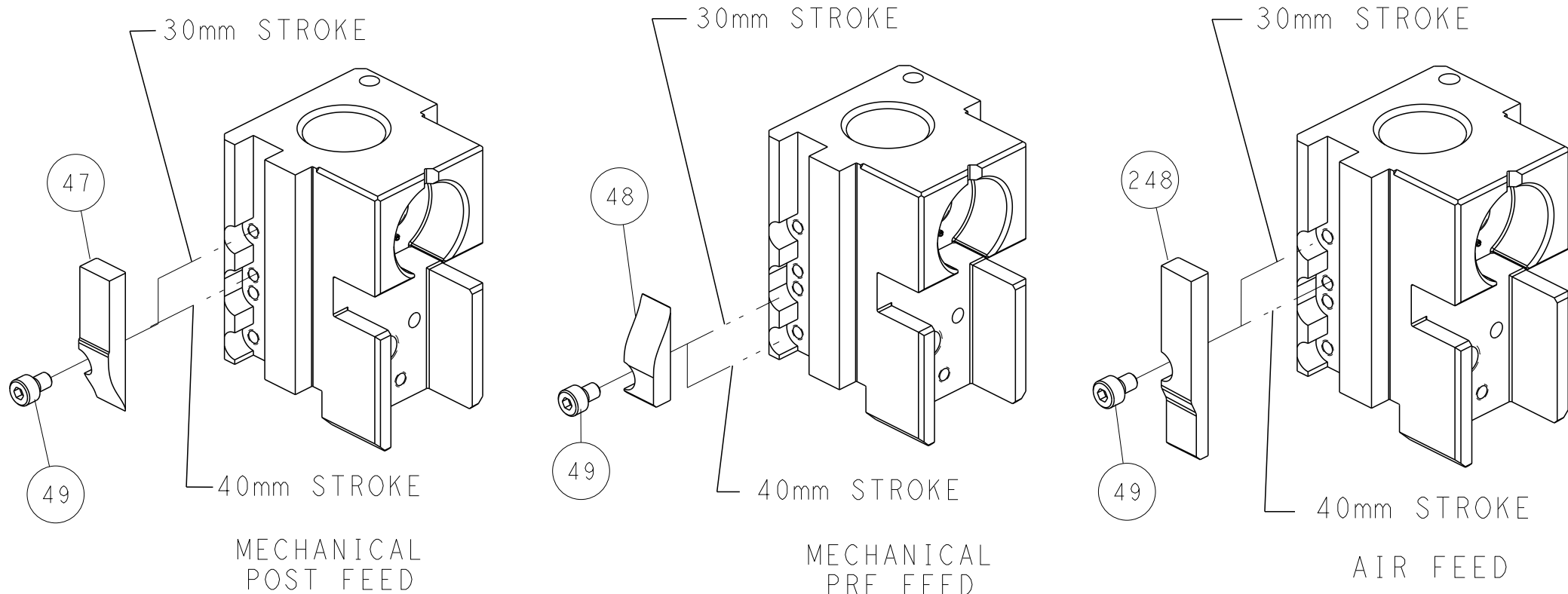


FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)

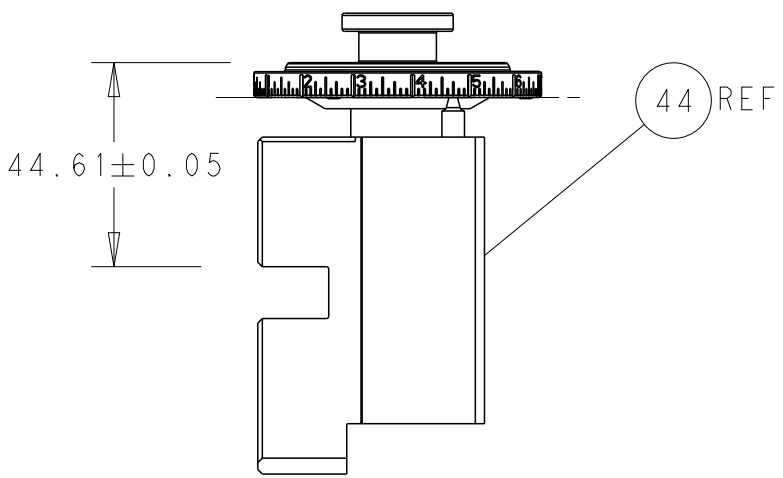
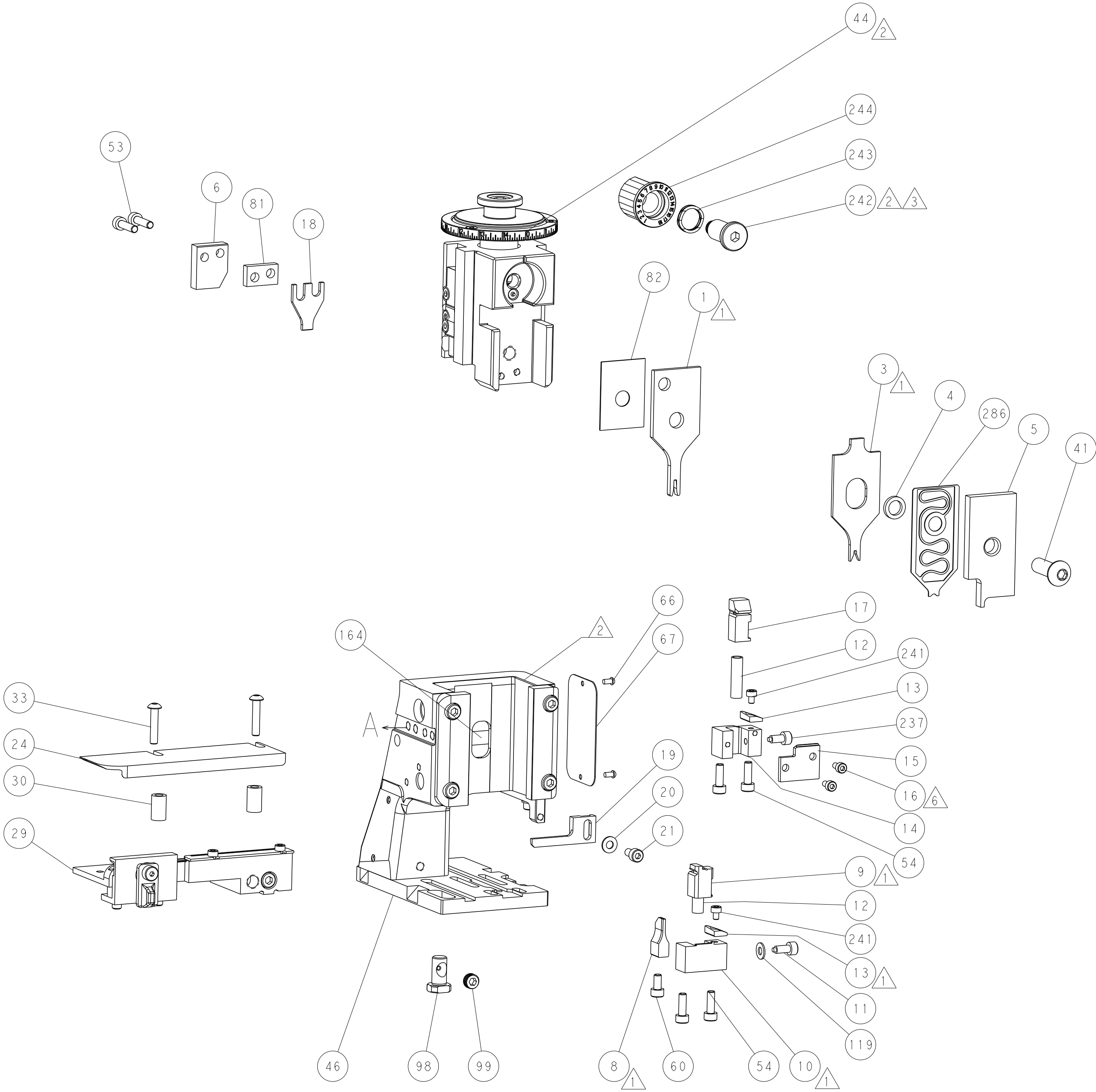


DETAIL A

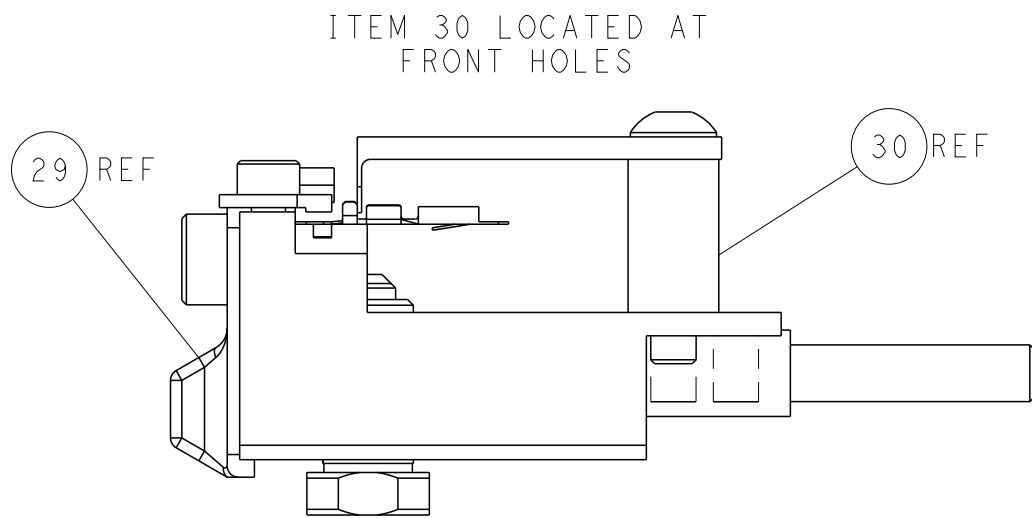
CAM POSITIONS



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



RAM SET-UP

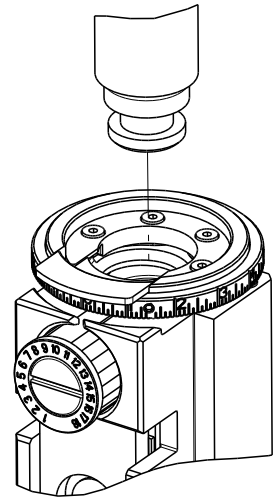


FEED TRACK POSITION
GUIDE BY INSULATION BARREL

THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. IT IS THE RESPONSIBILITY OF THE USER TO VERIFY THE DIMENSIONS AND TOLERANCES OF THE PARTS AND ASSEMBLY BEFORE USE.				DWN: BOB HIGMAN 20NOV2012 CHK: T. ELBIN 20NOV2012 APVD: M. CLIFFORD 20NOV2012				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				SIZE: A1			
MATERIAL: -				FINISH: -				CAGE CODE: 00779			
								DRAWING NO: C-2151822			
								RESTRICTED TO: -			
								SCALE: 1:2			
								SHEET: 2 OF 4			
								REV: C			

8		7	
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20		20	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2151822-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2151822-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151822-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.40 mm [.055]	F
INSUL	1.57 mm [.062]	F
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA:		TE TERMINAL	TE CRIMP SPECIFICATION	
TERMINAL NAME:		AMPMODU II	RECEPTACLE CONTACT, HIGH PRESSURE	
WIRE STRIP LENGTH			INSULATION DIAMETER RANGE	
3.56-4.32 mm [.140-.170 IN]			0.00-1.60 mm [0.00-.063 IN]	
TERMINAL APPLICATION SPECIFICATION			-	
TERMINALS APPLIED		-	-	
TE TERMINAL		TE TERMINAL	TE TERMINAL	
281999-1		281556-2		

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING
20 AWG		0.89+/-0.03 [.035+/-0.001]		7.8
22 AWG		0.84+/-0.03 [.033+/-0.001]		8.4
24 AWG		0.74+/-0.03 [.029+/-0.001]		9.7



- 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 USEDER DOCUMENT, 101-35000.
- 6 GRIND TO LENGTH AT ASSEMBLY.

*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)

2		1					
LOC	DIST	REVISIONS					
A	66	P	LTR	DESCRIPTION	DATE	DWN	APVD
		-		SEE SHEET 1	-	-	-

-	1	1	2119791-6	DEPRESSOR, WIRE	286
-	1	1	2119082-8	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
3	-	1	2119083-1	RETAINER, INSULATION DIAL	242
-	2	2	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
-	1	1	356885-4	STOP, SHEAR	237
-	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	3-240641-1	SPACER	81
-	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	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	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	2-2844962-3	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	2844992-2	ASSEMBLY, STRIP GUIDE	29
-	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	690518-1	HOLD DOWN, TERMINAL	18
-	1	1	690463-1	FLOATING SHEAR, REAR	17
6	-	2	1-2168083-1	SCR, SKT HD CAP, RoHS, M3 X 6	16
-	1	1	1-690691-3	PLATE,REAR SHEAR	15
-	1	1	2119862-1	SHEAR HOLDER, REAR	14
1	-	2	2119806-1	INSERT, SHEAR	13
-	2	2	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	1	1-1633932-8	ANVIL, COMBINATION	8
-	-	-	-	-	7
-	1	1	690468-1	DEPRESSOR SHEAR, REAR	6
-	1	1	2119757-4	DEPRESSOR, SHEAR	5
-	1	1	2-238011-2	BLOCK, CRIMPER SPACER	4
1	1	1	1-1803017-0	CRIMPER, INSULATION F	3
-	-	-	-	-	2
1	1	1	7-456402-3	CRIMPER, WIRE PREMIUM	1

-77	-22	-21	PART NO	DESCRIPTION		ITEM NO
OWN			BOB HIGMAN	ZONOV2012		
CHK			T.ELBIN	ZONOV2012		
APVD			M. CLIFFORD	ZONOV2012		
DIMENSIONS:			PRODUCT SPEC		NAME	
mm			APPLICATION SPEC		Ocean Side Feed Applicator	
MATERIAL			WEIGHT		RESTRICTED TO	
-			-		-	
Customer Accessible Production Drawing			SCALE		SHEET 3 OF 4	
			REV		C	

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

PNEUMATIC



30mm STROKE

142

49

MECHANICAL POST FEED

30mm STROKE

48

49

MECHANICAL PRE FEED

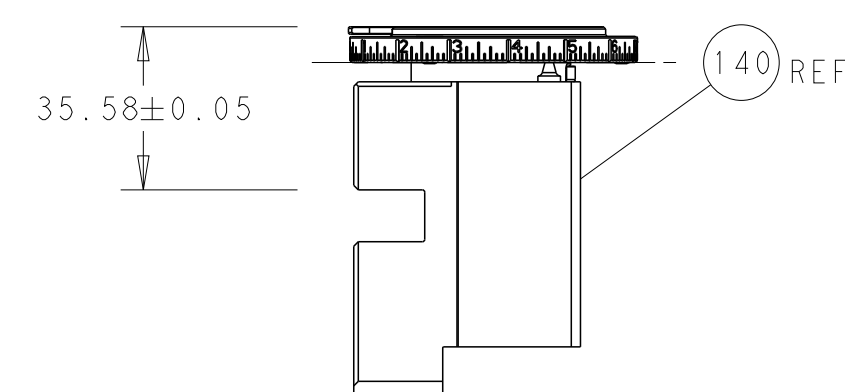
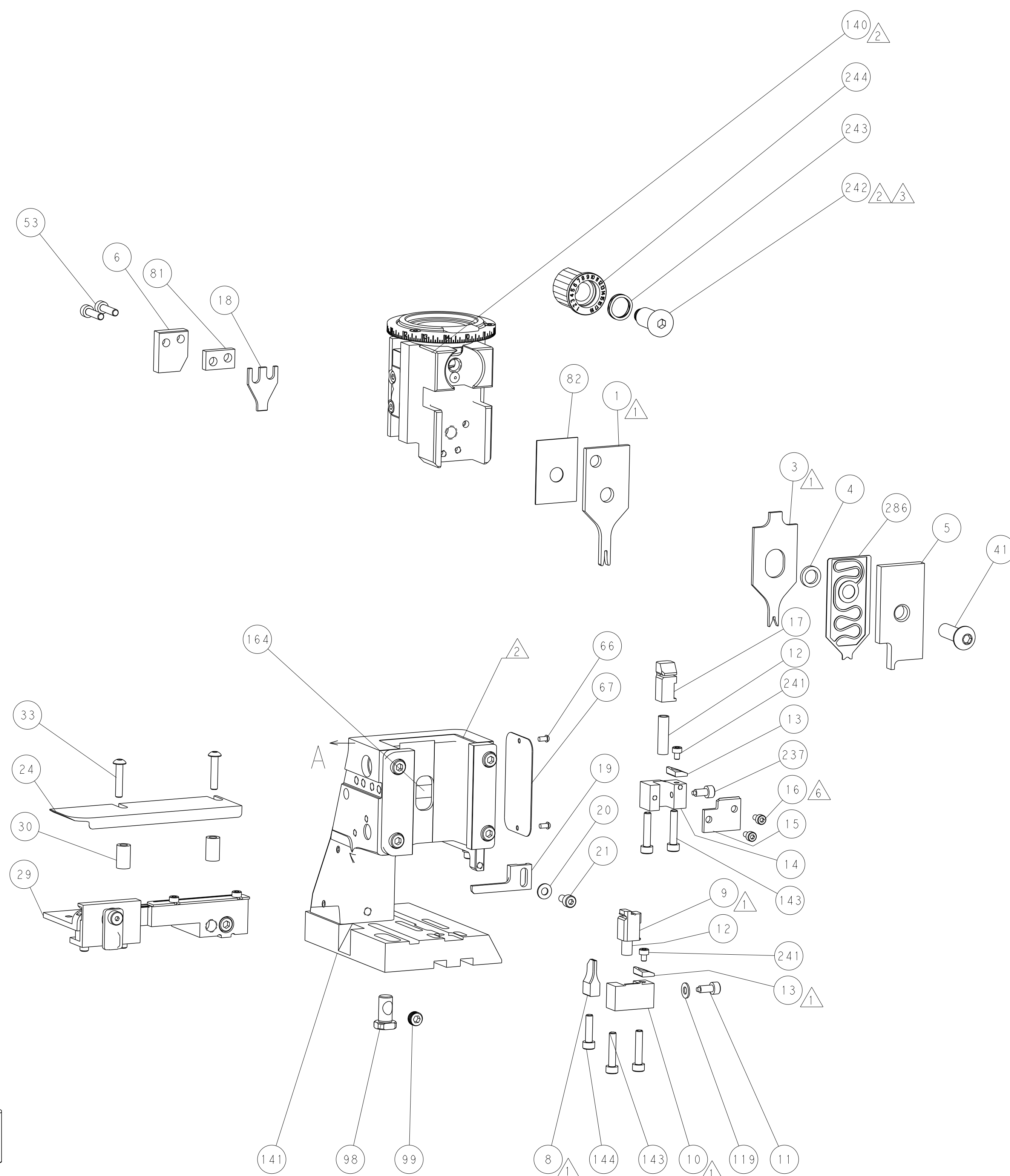
30mm STROKE

151

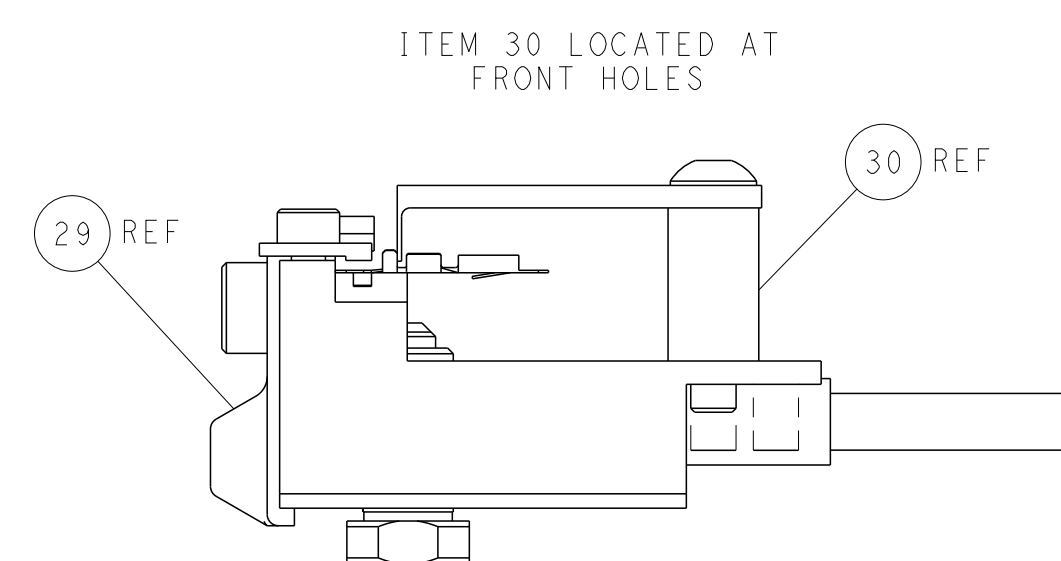
49

AIR FEED

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



RAM SET-UP



FEED TRACK POSITION
GUIDE BY INSULATION BARREL

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DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±. 1 PLC ±. 2 PLC ±. 3 PLC ±. 4 PLC ±. ANGLES ±.		NAME Ocean Side Feed Applicator -	
		PRODUCT SPEC - APPLICATION SPEC -		SIZE A1	
MATERIAL -		FINISH -		CAGE CODE 00779	
		WEIGHT -		DRAWING NO C=2151822	
Customer Accessible Production Drawing				SCALE 1:1 SHEET 4 OF 4 REV C	