

Table with 4 columns: PART NUMBER, REVISION, DESCRIPTION, FEED TYPE. Contains various crimping tool specifications.

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA table with columns for CRIMP, SIZE, TYPE, WIRE, and INSUL.

Terminal data tables for TE TERMINAL, including terminal names, wire strip lengths, insulation diameters, and crimp specifications.

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WIRE SIZE and CRIMP HEIGHT tables with diagrams showing crimping parameters and settings.

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- Notes and warnings: 1. RECOMMENDED SPARE PARTS, 2. REFER TO SUPPLIED INSTRUCTION SHEET... 3. APPLY PART NUMBER... 4. CRIMP HEIGHT REFERENCE SETTING... 5. THIS APPLICATOR APPLIES TERMINAL WITH A SEAL... 6. APPLY TORO-SEAL... 7. THIS CRIMP PARAMETER IS PROVIDED... 8. THIS APPLICATOR IS EQUIPPED WITH THE DOUBLE ACTING PNEUMATIC FEED... 9. TERMINAL LUBRICANT IS RECOMMENDED. 10. 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.

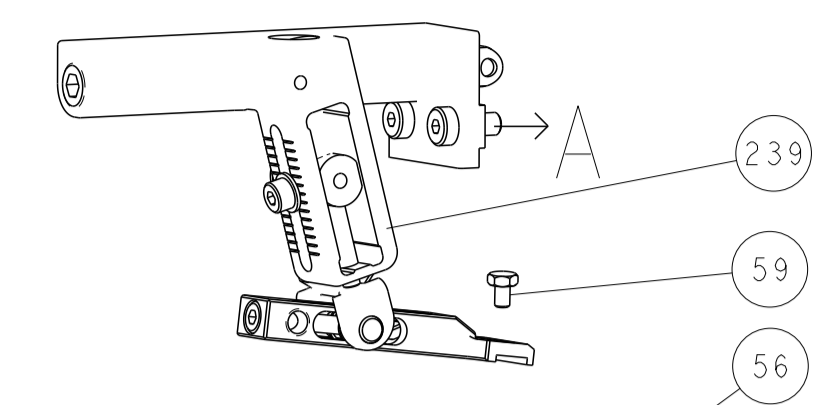
ATLANTIC VERSION Shown on sheets 1 of 4 & 2 of 4 (Pacific version shown on sheets 3 of 4 & 4 of 4)

Large assembly table with columns for part number, description, date, and quantity. Lists various components like RAM ASSEMBLY, AIR FEED MODULE, CRIMPER SPACER, etc.

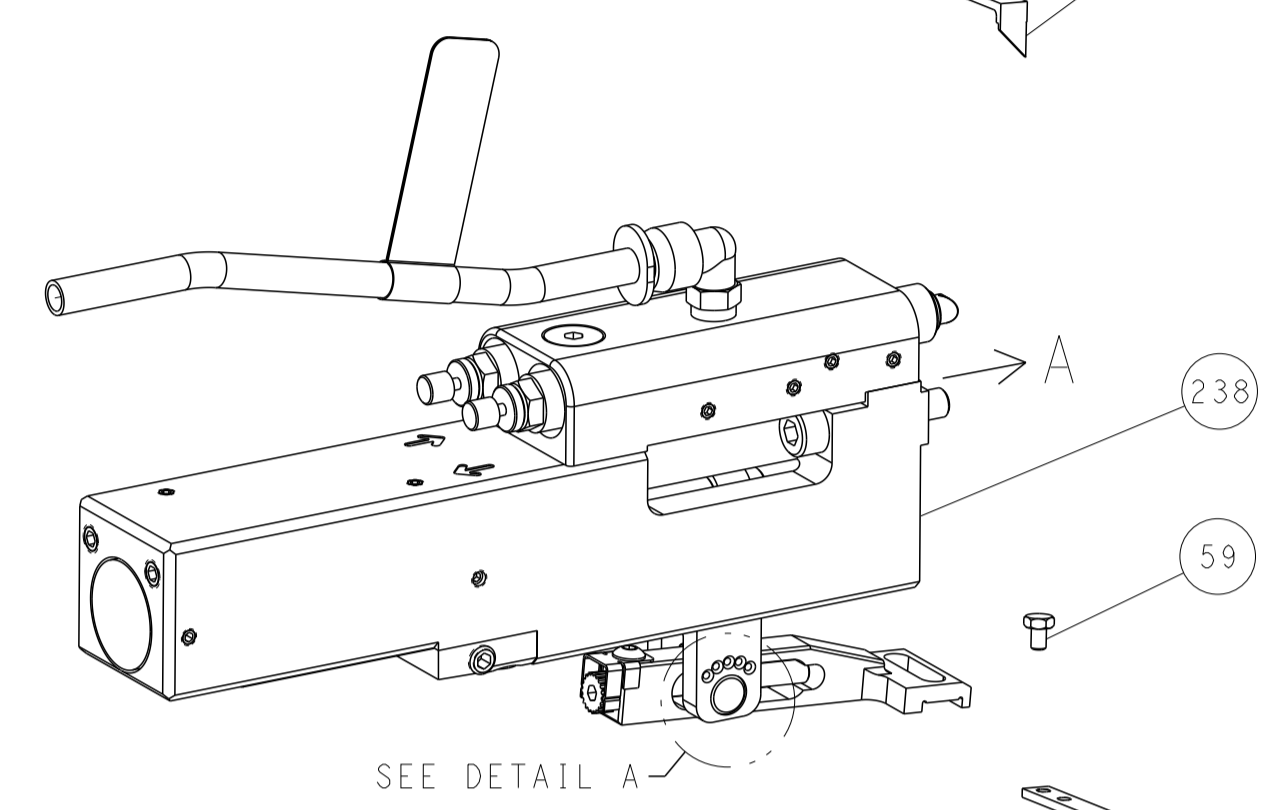
Technical drawing information block including dimensions, tolerances, materials, finishes, weights, and drawing metadata like part number (00779) and drawing number (2151477).

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

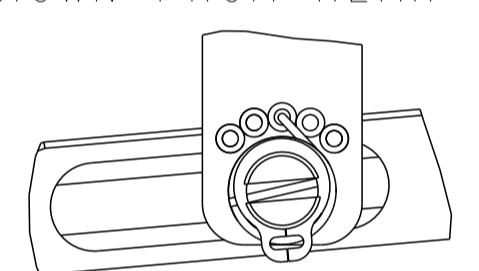
# FEED TYPE MECHANICAL



## PNEUMATIC

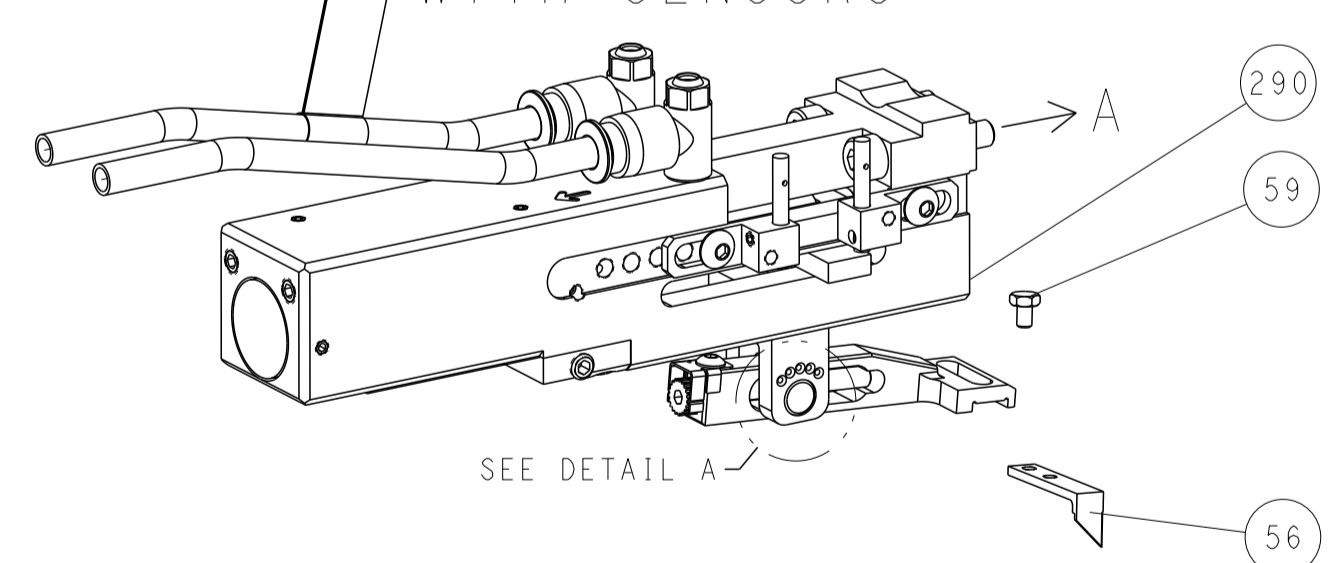


## FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)

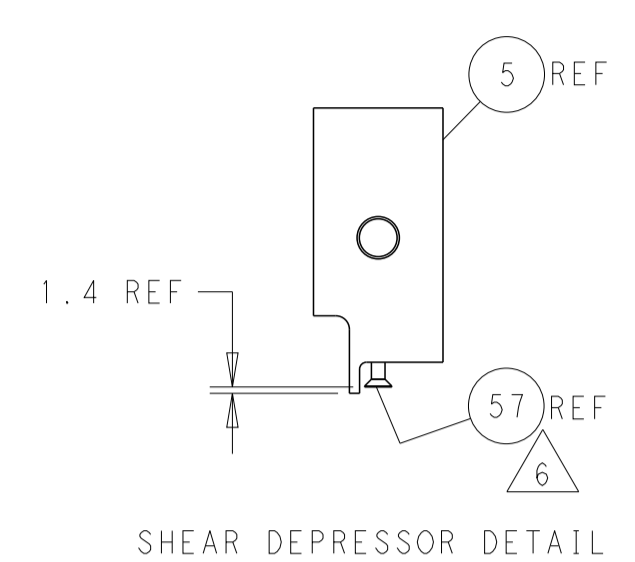
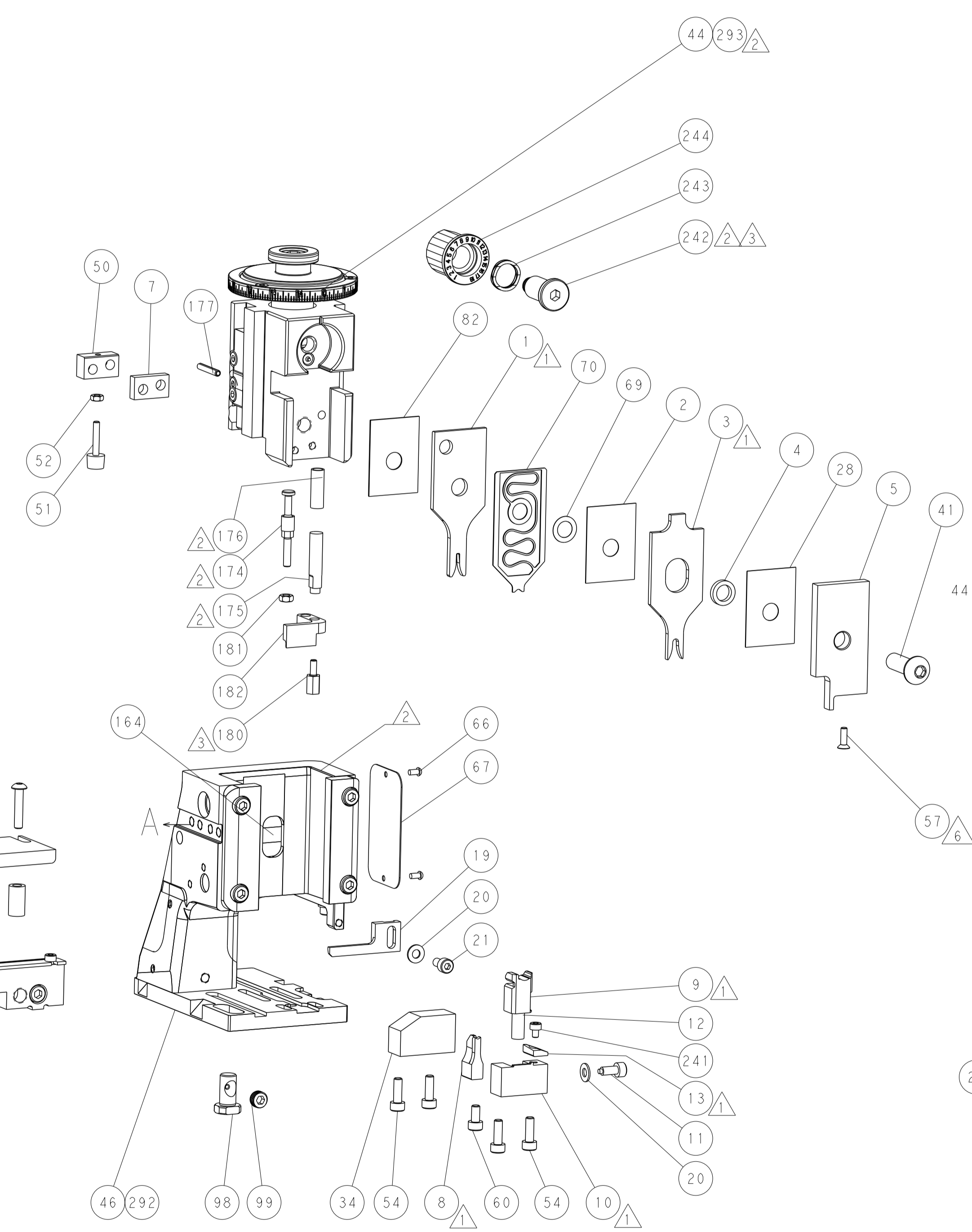
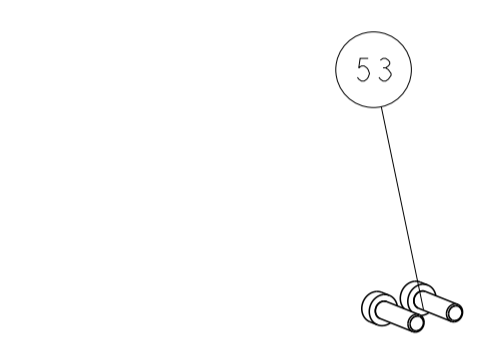
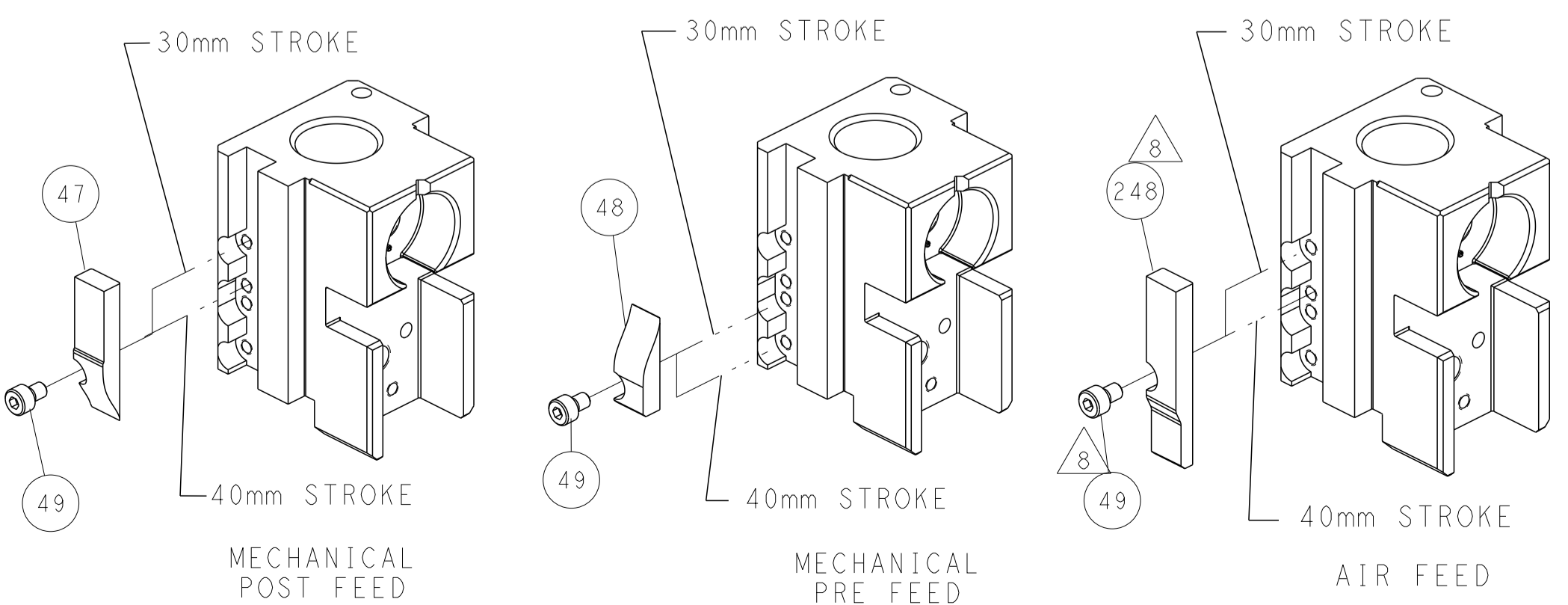


DETAIL A

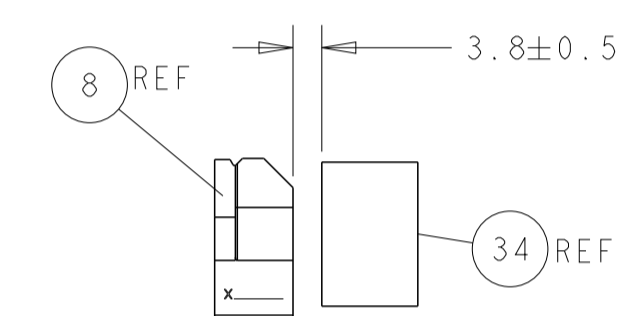
## DOUBLE ACTING PNEUMATIC WITH SENSORS



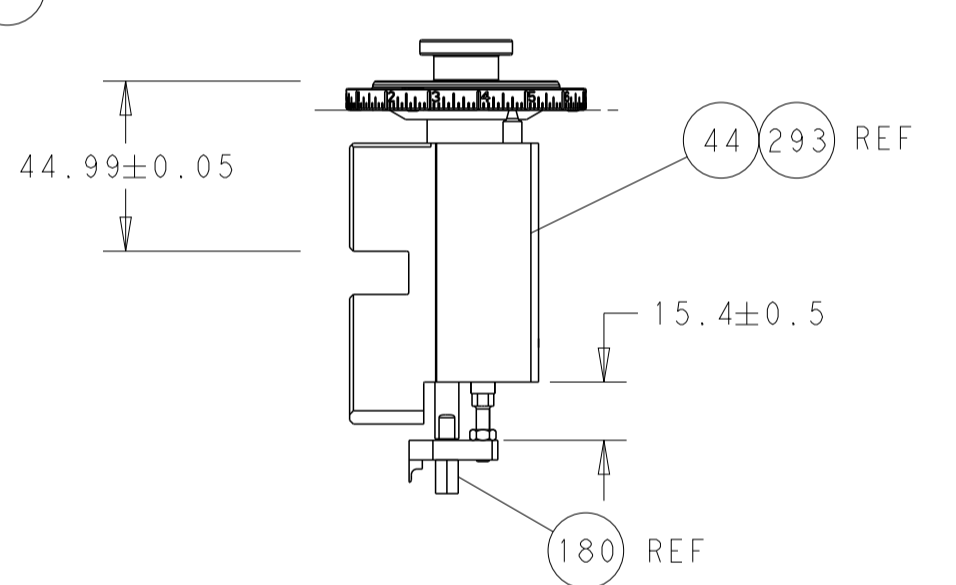
# CAM POSITIONS



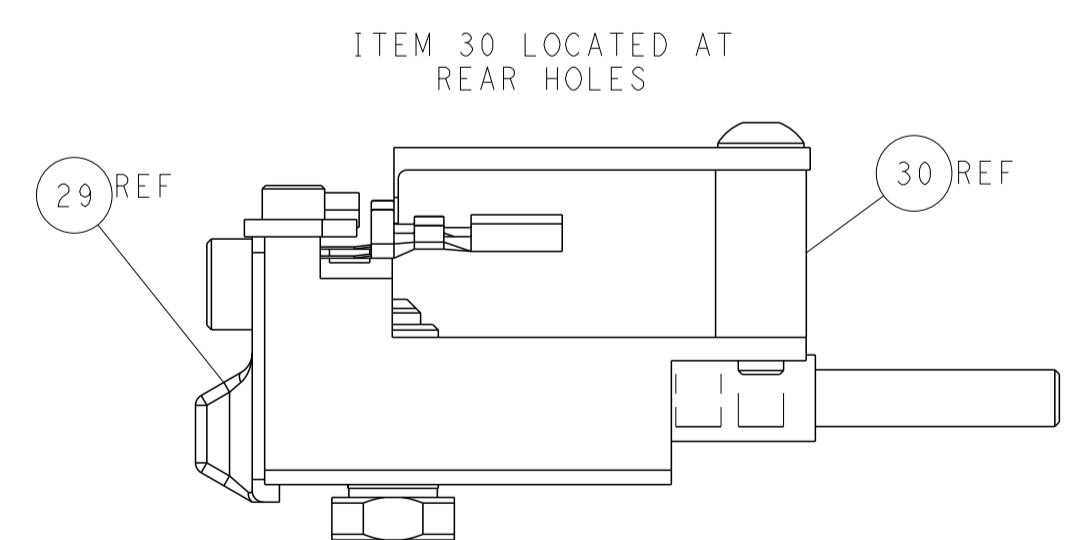
SHEAR DEPRESSOR DETAIL



TERMINAL SUPPORT LOCATION



RAM AND HOLD-DOWN SET-UP



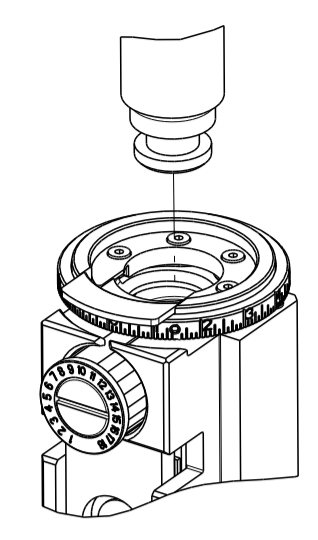
FEED TRACK POSITION GUIDE BY INSULATION BARREL

**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:		DWG: BOB_HIGMAN_02APR2012		TE Connectivity	
0 PLC ±		1 PLC ±		CHK: T_ELBIN_02APR2012		Harrisburg, PA 17105-3608	
2 PLC ±		3 PLC ±		APVD: M_CLIFFORD_02APR2012		NAME: Ocean Side Feed Applicator	
4 PLC ±		ANGLES ±		PRODUCT SPEC		SIZE: CAGE CODE: DRAWING NO: RESTRICTED TO	
MATERIAL: .		FINISH: .		APPLICATION SPEC		A1 00779 ©=2151477	
WEIGHT: .		SCALE: 1:2		Customer Accessible Production Drawing		SHEET 2 OF 4 REV L	

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2151477-1	L	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2151477-2	L	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
4-2151477-2	L	FINE CRIMP HEIGHT ADJUST	DOUBLE ACTING PNEUMATIC WITH SENSORS
7-2151477-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA

CRIMP	SIZE	TYPE
WIRE	1.40 mm [.055]	F
INSUL	3.18 mm [1.25]	O

APPLICATOR INSTRUCTIONS  
408-35042

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION

TERMINAL NAME: TAB CONTACT 1.2MM

WIRE STRIP LENGTH	INSULATION DIAMETER RANGE
3.30-3.90 mm [.130-.154 IN]	Ø 5

TERMINAL APPLICATION SPECIFICATION 114-18464

TERMINALS APPLIED 9

TE TERMINAL	TE TERMINAL	TE SEAL	TE SEAL
1718760-1	1718760-2	967067-1	963142-2
1718760-3			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.75mm2	1.05+/-0.03 [.041+/-0.001]	5.9
20 AWG OR 0.50mm2	0.93+/-0.03 [.037+/-0.001]	7.2

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION

TERMINAL NAME: TAB CONTACT 1.2MM

WIRE STRIP LENGTH	INSULATION DIAMETER RANGE
3.30-3.90 mm [.130-.154 IN]	Ø 5

TERMINAL APPLICATION SPECIFICATION 114-18464

TERMINALS APPLIED 9

TE TERMINAL	TE TERMINAL	TE SEAL	TE SEAL
2141116-1	2208328-3	967067-1	963142-2
2141116-3			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.75mm2	0.98+/-0.03 [.039+/-0.001]	6.8
20 AWG OR 0.50mm2	0.93+/-0.03 [.037+/-0.001]	7.2

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION

TERMINAL NAME: TAB CONTACT 1.2MM

WIRE STRIP LENGTH	INSULATION DIAMETER RANGE
3.30-3.90 mm [.130-.154 IN]	Ø 5

TERMINAL APPLICATION SPECIFICATION

TERMINALS APPLIED 9

TE TERMINAL	TE TERMINAL	TE SEAL	TE SEAL
1718760-1	1718760-2	1718760-3	967067-1

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
20 AWG (19 / 0.203 mm)	0.99+/-0.03 [.039+/-0.001]	6.7
0.61mm2	0.99+/-0.03 [.039+/-0.001]	6.7

- 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.
- THIS APPLICATOR APPLIES TERMINAL WITH A SEAL.
- | SEAL P/N  | INS. Ø    |
|-----------|-----------|
| 967067-1  | 1.4-2.1mm |
| 963142-2  | 0.9-1.3mm |
| 1718760-3 | 1.4-1.9mm |
- 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.
- THIS CRIMP PARAMETER IS PROVIDED TO MEET A CUSTOM AND UNIQUE CUSTOMER REQUIREMENT. IT HAS BEEN EVALUATED AND IS CONDITIONALLY SPECIFIED BY TE CONNECTIVITY. THIS CUSTOMIZED CRIMP PARAMETER IS NOT LISTED AS AN APPROVED APPLICATION WITHIN A TE CONNECTIVITY APPLICATION SPECIFICATION; HOWEVER, IT HAS BEEN VALIDATED ACCORDING TO TE CONNECTIVITY SPECIFICATIONS 109-18079 (TEST GROUP 1) AND 114-18022. **TE CONNECTIVITY EXPRESSLY DISCLAIMS ANY AND ALL WARRANTIES THAT THE PRODUCT WILL PERFORM SIMILARLY TO VALIDATED AND APPROVED APPLICATIONS, AS STATED WITHIN TE CONNECTIVITY APPLICATION SPECIFICATIONS, INCLUDING BUT NOT LIMITED TO IMPLIED WARRANTIES OF MERCHANTABILITY OR FITNESS FOR PARTICULAR PURPOSE.** AS SUCH, IT IS HIGHLY RECOMMENDED THAT THE CUSTOMER PERFORM FURTHER DETAILED EVALUATION TO ASSESS PRODUCT PERFORMANCE IN THE SPECIFIC APPLICATION.
- THIS APPLICATOR IS EQUIPPED WITH THE DOUBLE ACTING PNEUMATIC FEED WITH SENSORS, AND IS APPLICATION SPECIFIC AND DOES NOT REQUIRE ITEMS 49 & 151.
- TERMINAL LUBRICANT IS RECOMMENDED.
10. 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.

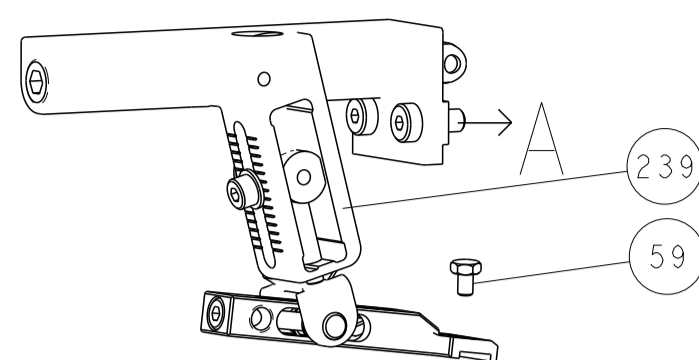
PACIFIC VERSION  
 Shown on sheets 3 of 4 & 4 of 4  
 (Atlantic version shown on sheets 1 of 4 & 2 of 4)

LOC	DIST	REV	DATE	BY	APPV
A	66				

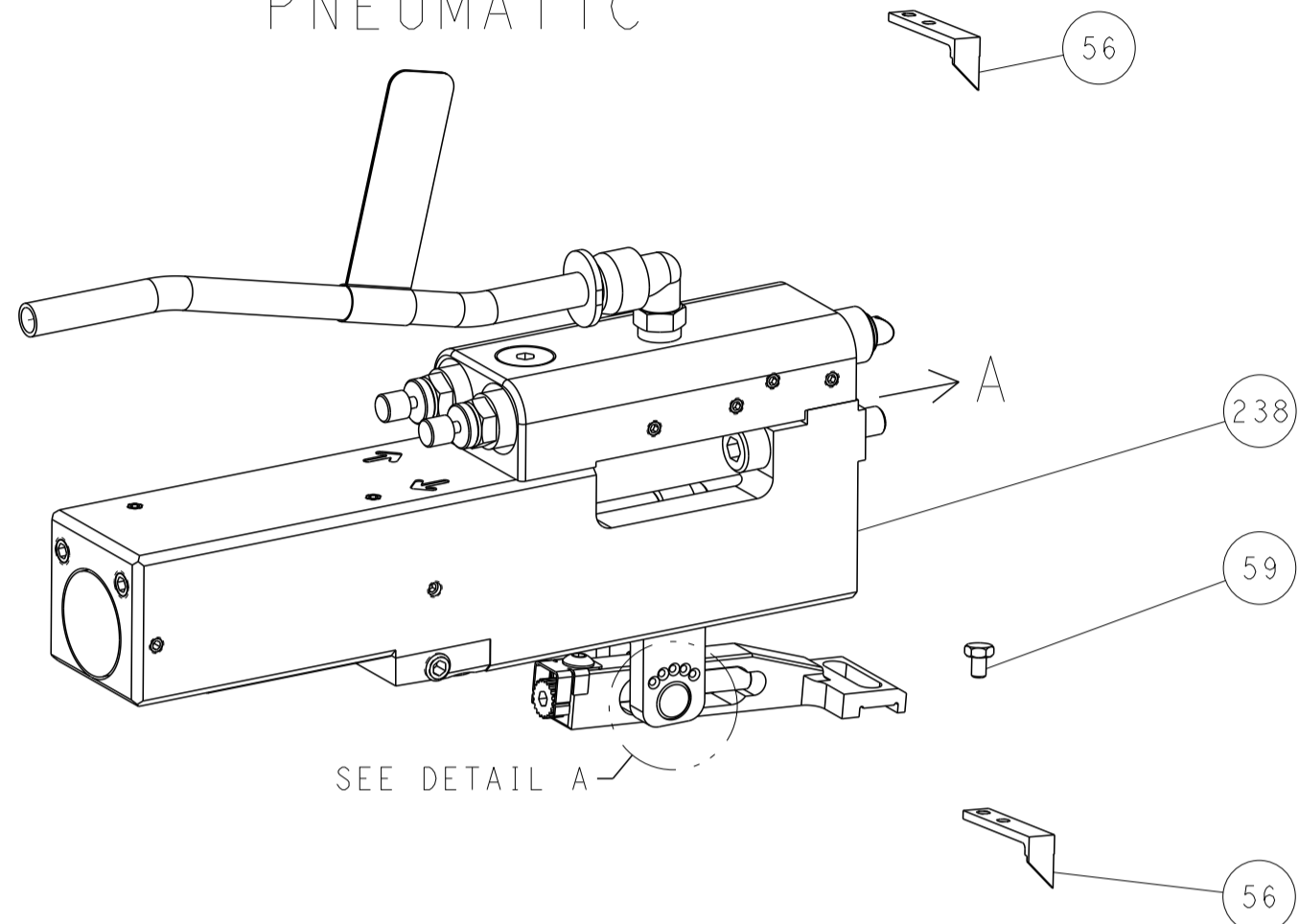
REV	DATE	DESCRIPTION	ITEM NO		
-	1	-	2844950-1 AIR FEED MODULE	290	
-	1	1	2119082-4 CAM, SNAIL, INSULATION ADJUSTMENT	244	
-	1	1	2079764-1 WASHER, WAVE SPRING, CREST-TO-CREST	243	
-	1	1	2119083-1 RETAINER, INSULATION DIAL	242	
-	1	1	7-18023-7 SCR, SKT HD CAP M3 X 4.0	241	
-	-	-	2119580-1 MECHANICAL FEED 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	2119791-5 DEPRESSOR, WIRE	70	
-	1	1	2119943-1 WASHER, SPACER	69	
-	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	2168083-8 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
-	-	-	1	2119652-1 FEED CAM, PRE FEED	48
-	1	1	1803602-1 SCR, BHSC, RoHS (M8 X 25)	41	
-	1	1	1752356-6 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	455888-3 SPACER, CRIMPER	28	
-	1	1	1320928-6 STRIP GUIDE	24	
-	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	318707-1 FLOATING SHEAR, FRONT	9
-	1	1	1	7-1333201-4 ANVIL, COMBINATION	8
-	1	1	1	5-240641-0 SPACER	7
-	-	-	-	-	6
-	1	1	1	2-2119781-4 DEPRESSOR, SHEAR	5
-	1	1	1	238011-4 BLOCK, CRIMPER SPACER	4
-	1	1	1	1633965-1 CRIMPER, INSULATION O PREMIUM	3
-	1	1	1	455888-3 SPACER, CRIMPER	2
-	1	1	1	1-456402-7 CRIMPER, WIRE PREMIUM	1

DIMENSIONS:	TOLERANCES UNLESS OTHERWISE SPECIFIED:	APV	NAME
mm	0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±	BOB HIGMAN 02APR2012 T. ELBIN 02APR2012 M. CLIFFORD 02APR2012	TE Connectivity Harrisburg, PA 17105-3608
MATERIAL:	FINISH:	APV	Customer Accessible Production Drawing
		SCALE	1:2
		SHEET	3 of 4
		REV	L

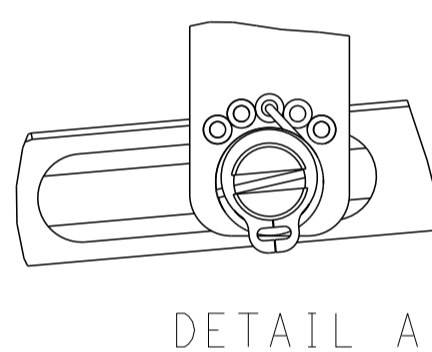
# FEED TYPE MECHANICAL



## PNEUMATIC

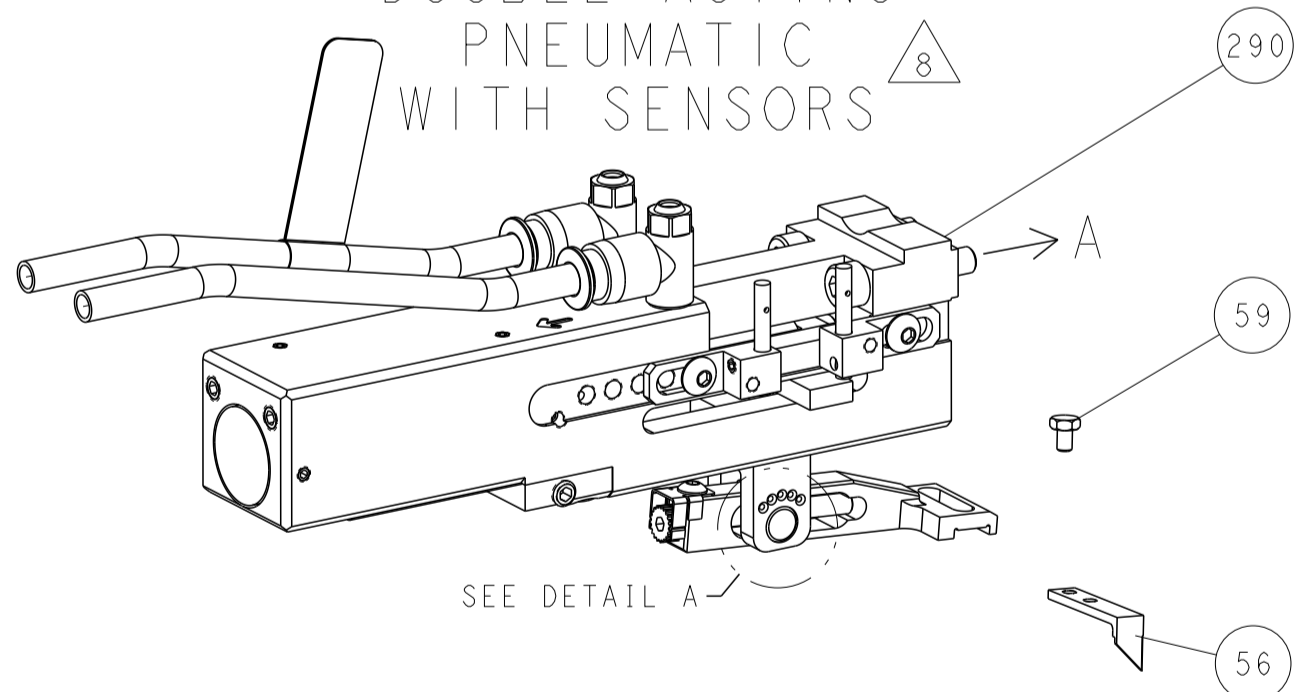


## FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



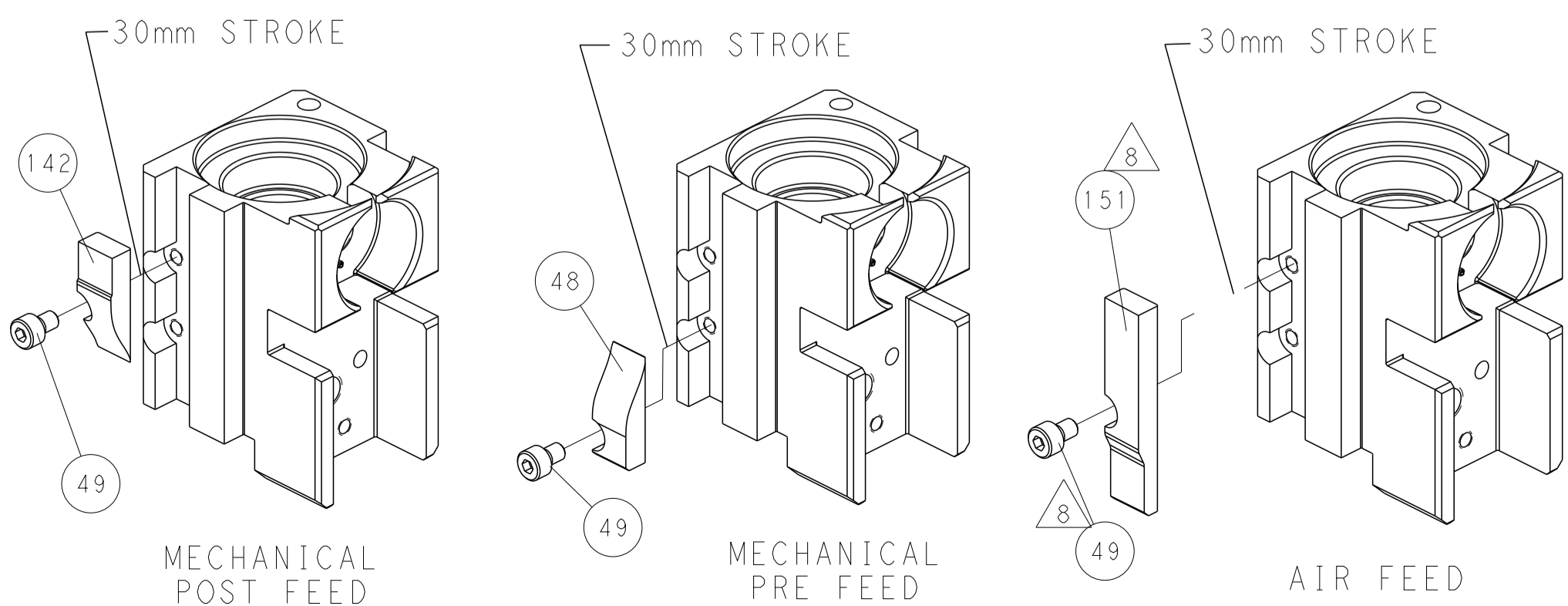
DETAIL A

## DOUBLE ACTING PNEUMATIC WITH SENSORS



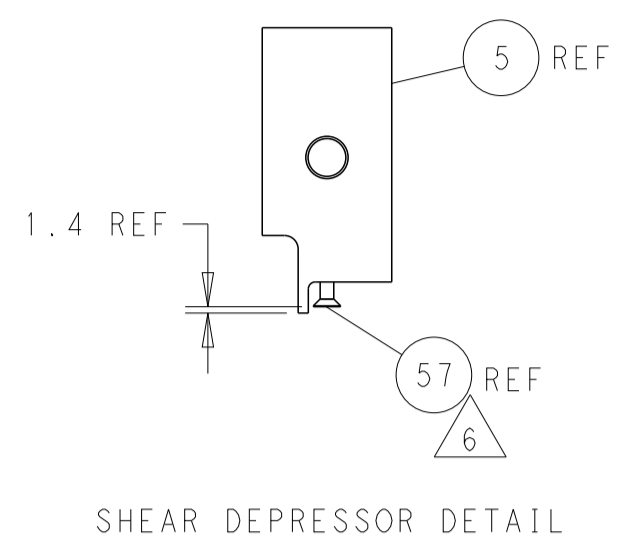
SEE DETAIL A

## CAM POSITIONS

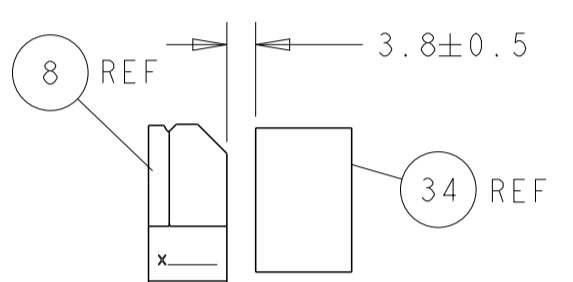


**PACIFIC VERSION**  
 Shown on sheets 3 of 4 & 4 of 4  
 (Atlantic version shown on sheets 1 of 4 & 2 of 4)

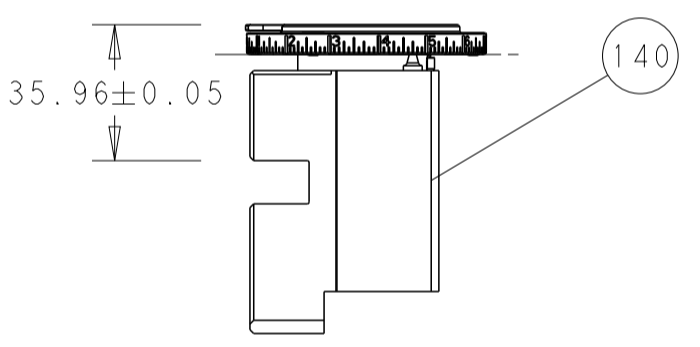
LOC	DIST	REVISIONS					
		P	LTN	DESCRIPTION	DATE	DWN	APVD
A	66	-	-	SEE SHEET 1	-	-	-



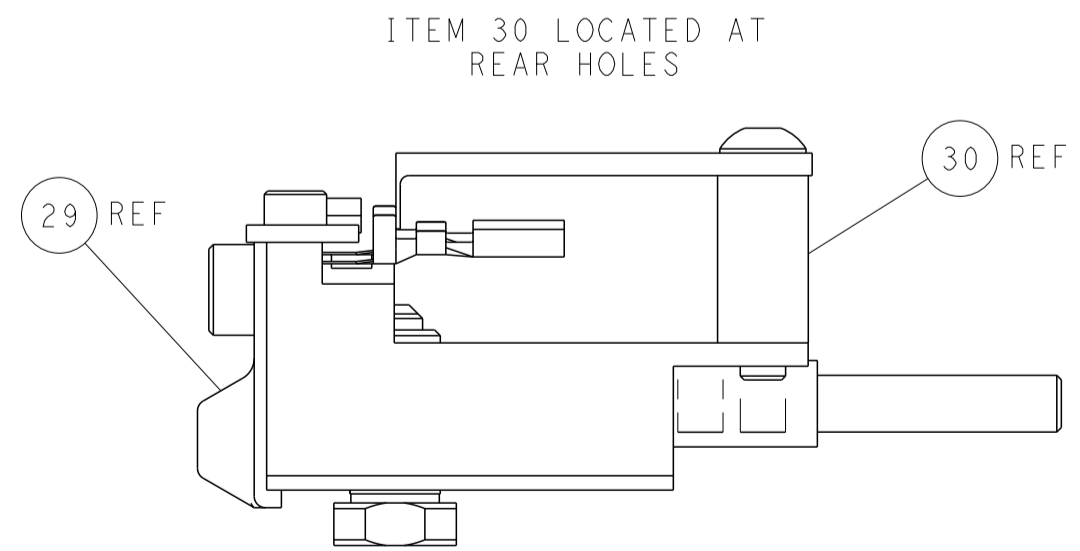
SHEAR DEPRESSOR DETAIL



TERMINAL SUPPORT LOCATION



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 ± FINISH		DWN BOB HIGMAN 02APR2012 CHK T. ELBIN 02APR2012 APVD M. CLIFFORD 02APR2012 PRODUCT SPEC APPLICATION SPEC WEIGHT SCALE 1:2		NAME Ocean Side Feed Applicator SIZE CAGE CODE DRAWING NO. A1 00779 C=2151477 RESTRICTED TO SHEET 4 OF 4 REV L	