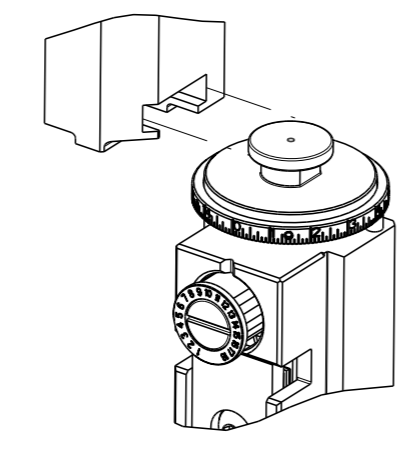


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151019-1	J	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2151019-2	J	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
5-2151019-1	J	STRIPPER SEAL TERMINATING UNIT	MECHANICAL
5-2151019-2	J	STRIPPER SEAL TERMINATING UNIT	PNEUMATIC
7-2151019-1	J	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2151019-2	J	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2151019-7	E	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.78 mm [.070]	F
INSUL	2.54 mm [.100]	F

APPLICATOR INSTRUCTIONS 408-35042

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: PIN/SOCKET, MATE-N-LOK			
WIRE STRIP LENGTH 3.96-4.75 mm [.156-.187 IN]		INSULATION DIAMETER RANGE Ø1.02-2.54 mm [.040-.100 IN]	
TERMINAL APPLICATION SPECIFICATION (C)114-1012 (A)114-1010		(B)114-1011	

TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
(C) 61115-1	(C) 61314-1	(B) 350560-1	(A) 350570-7
(C) 61116-1	(C) 61314-2	(B) 350561-1	(A) 350699-1
(C) 61116-2	(C) 61314-3	(B) 350561-2	(A) 350699-2
(C) 61116-3	(C) 61314-4	(B) 350561-3	(A) 350699-3
(C) 61116-4	(C) 61314-5	(B) 350561-5	(A) 350699-5
(C) 61116-5	(C) 61314-6	(B) 350561-7	(A) 350699-7
(C) 61116-6	(C) 61314-7	(B) 350561-8	(A) 350699-8
(C) 61116-7	(C) 61314-8	(A) 350570-1	(A) 350851-1
(C) 61116-8	(C) 61527-2	(A) 350570-2	(A) 350851-2
(C) 61116-9	(C) 170147-1	(A) 350570-3	(A) 350851-7
(C) 1-61116-3	(C) 170147-2	(A) 350570-6	

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
18 AWG	1.22+/-0.05 [.048+/-0.002]	6.1
20 AWG	1.09+/-0.05 [.043+/-0.002]	7.7
22 AWG	1.02+/-0.05 [.040+/-0.002]	8.4
24 AWG	0.96+/-0.05 [.038+/-0.002]	8.8

- 1 RECOMMENDED SPARE PARTS
- 2 REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION & 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.

***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			
		REV	DATE	BY	CHKD
A	66	G	15JAN2016	MR	JT
		G1	11OCT2016	YY	JDG
		H	27APR2017	TB	GB
		J	13MAR2018	LG	JD

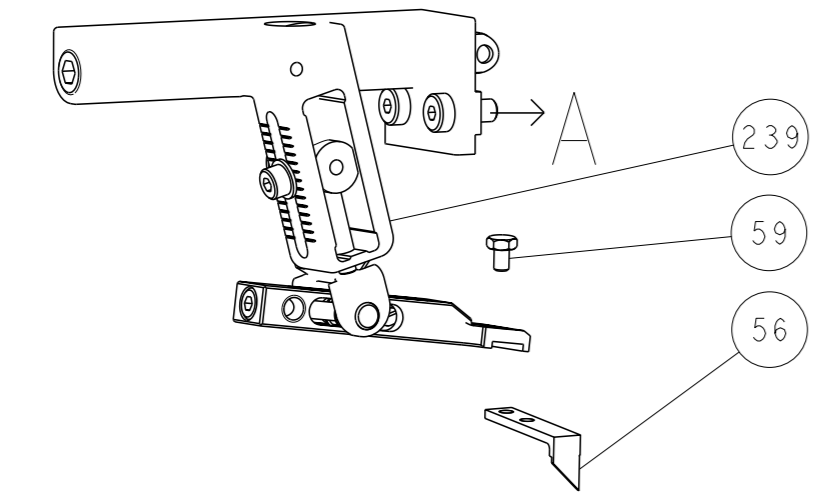
REV	DATE	BY	CHKD	DESCRIPTION	ITEM NO	
-	-	-	-	1803515-3	RAM ASSEMBLY, SF ATLANTIC	293
-	-	-	-	2-1803583-1	APPLICATOR BASIC ASSEMBLY, SF	292
-	2	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	271
-	1	1	1	1-690438-0	FRONT STRIP GUIDE	270
-	1	-	-	2119640-1	PUSH ROD, AIR FEED	250
-	1	-	-	1803259-1	BUSHING, FLANGED	249
-	1	-	-	2119641-1	FEED CAM, AIR FEED	248
-	1	1	1	2119082-4	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
-	-	-	-	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	1	-	-	2063440-1	AIR FEED MODULE	238
-	-	-	-	4-1722335-3	STRIPPER, SIDE FEED	182
-	-	-	-	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	181
-	-	-	-	1-1752354-9	STANDOFF,HOLD-DOWN	180
-	-	-	-	993111-1	PIN, SLOTTED SPRING 3.0 X 20.0	177
-	-	-	-	5-22280-0	SPRING, COMPRESSION	176
-	-	-	-	1752353-3	GUIDE PIN,HOLDDOWN	175
-	-	-	-	1901680-2	GUIDE PIN,HOLDDOWN	174
-	2	-	-	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172
-	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	1	-	-	240638-1	SPRING, FEED FINGER	163
-	1	-	-	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854	137
-	1	-	-	2119799-1	HOLDER,FEED FINGER, AF	136
-	1	1	1	1-18028-2	WASHER, FLAT, REG M4	119
-	1	1	1	2844908-1	SCREW, LOCKING	99
-	1	1	1	2844907-1	POST, LOCKING	98
-	1	1	1	455888-4	SPACER, CRIMPER	82
-	1	1	1	1803607-1	DOCUMENTATION PACKAGE	71
-	1	1	1	2119791-6	DEPRESSOR, WIRE	70
-	1	1	1	2119740-1	TAG,IDENTIFICATION	67
-	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	2	2	2	2-18032-5	SCR, SET, FLT PNT, M5 X 20.0	61
-	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	60
-	1	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	1	1	1	1338685-1	PAWL, FEED	56
-	4	4	4	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	54
-	2	2	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	53
-	1	1	1	5018030-1	NUT, HEX, REG, RoHS, M3	52
-	1	1	1	811242-5	BUMPER, HOLD DOWN	51
-	1	1	1	690753-2	SPACER, TONKER	50
-	1	2	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	-	-	-	2119652-1	FEED CAM, PRE FEED	48
-	-	-	-	2119653-1	FEED CAM, POST FEED	47
-	1	1	-	1803583-9	APPLICATOR BASIC ASSEMBLY, SF	46
-	1	1	-	1803515-1	RAM ASSEMBLY, SF ATLANTIC	44
-	1	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
-	1	1	1	1752356-3	SUPPORT, TERMINAL	34
-	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	2	2-2844962-8	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	1	2844992-3	ASSEMBLY, STRIP GUIDE	29
-	2	2	2	22283-1	SPRING, COMPRESSION	27
-	1	1	1	356835-1	LEVER, DRAG RELEASE	26
-	1	1	1	240792-5	DRAG, TERMINAL	25
-	1	1	1	1320928-2	STRIP GUIDE	24
-	1	1	1	980371-4	SCR, SKT HD SHLDR 5.0 DIA X 6.0	23
-	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	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	1803095-3	FLOATING SHEAR, FRONT	9
1	2	2	1	1338692-1	ANVIL, COMBINATION .070	8
-	1	1	1	2119757-8	DEPRESSOR, SHEAR	5
-	1	1	1	2-238011-2	BLOCK, CRIMPER SPACER	4
1	2	2	1	1-2119582-0	CRIMPER, INSULATION F PREMIUM	3
-	1	1	1	455888-6	SPACER, CRIMPER	2
1	2	2	1	1-456404-8	CRIMPER, WIRE PREMIUM	1

REV	DATE	BY	CHKD	DESCRIPTION	ITEM NO				
-77	-72	-71	-52	-51	-2	-1	PART NO	DESCRIPTION	ITEM NO

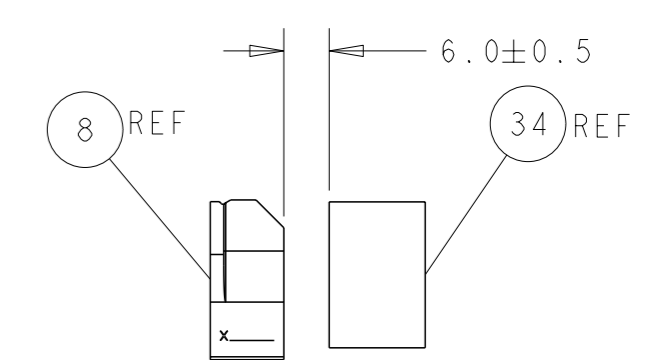
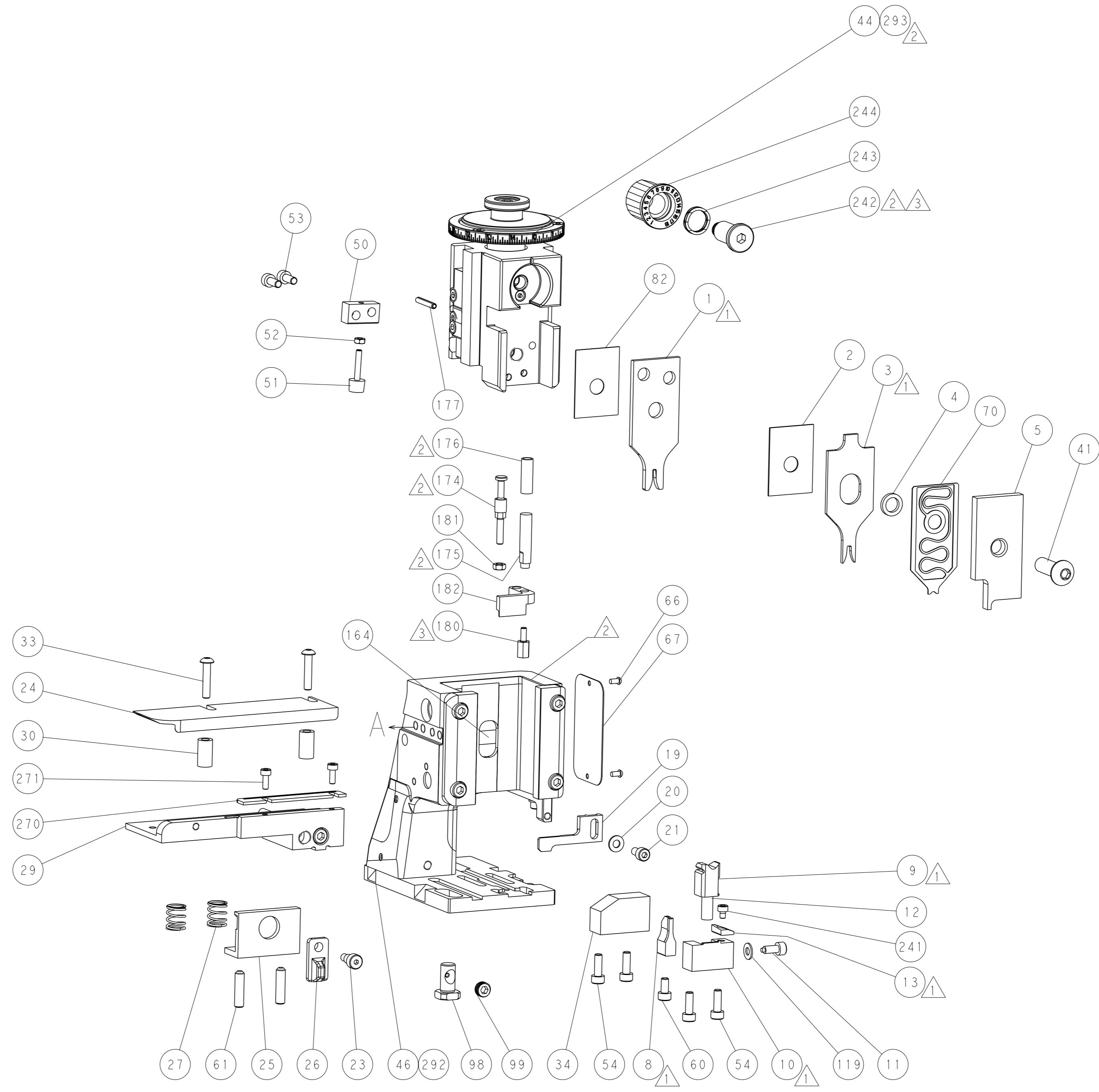
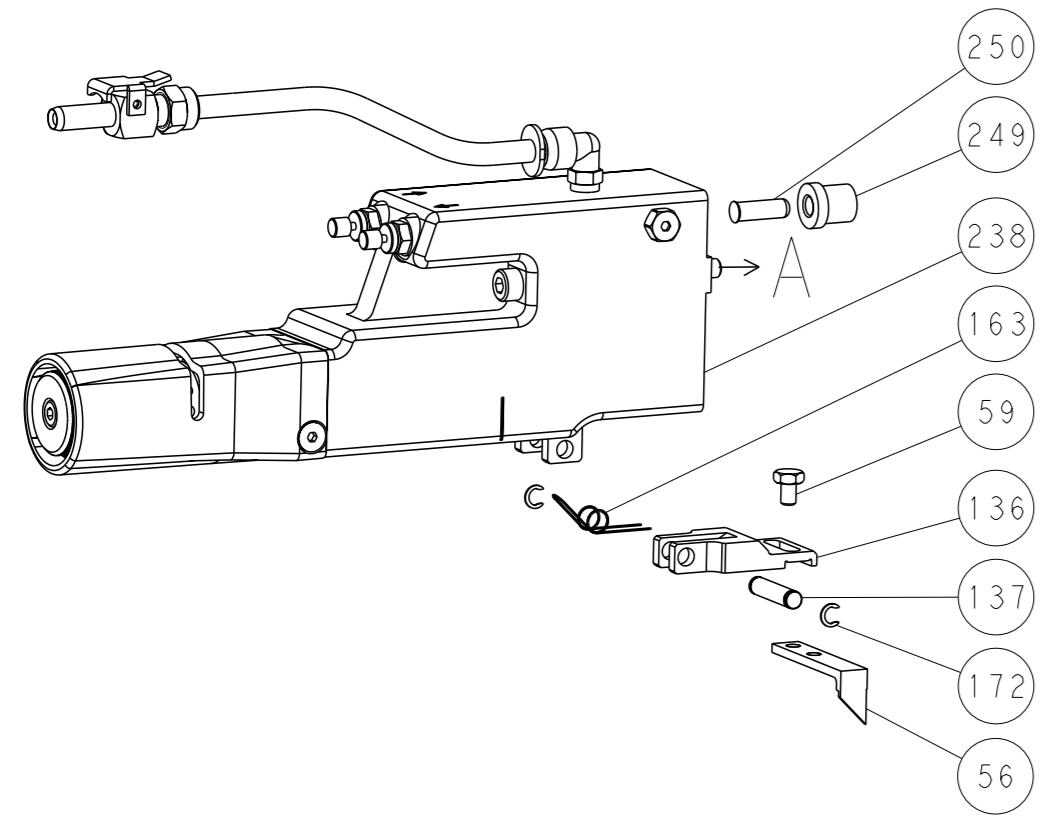
OWN	L. ZHANG	24AUG2011	CHK	L. ZHANG	24AUG2011	APVD	S. XI	24AUG2011	NAME	Ocean Side Feed Applicator	
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		MATERIAL		FINISH		WEIGHT		SCALE	
mm	0 PLC	±	1 PLC	±	2 PLC	±	3 PLC	±	4 PLC	±	RESTRICTED TO
MATERIAL		FINISH		WEIGHT		SCALE		SHEET		REV	
-		-		-		-		A1		00779 ©=2151019	
Customer Accessible Production Drawing										SCALE 1:2 SHEET 1 of 4 REV J	

LOC	DIST	REVISIONS			
A	66	REV	DATE	OWN	APVD
-	-	SEE SHEET 1	-	-	-

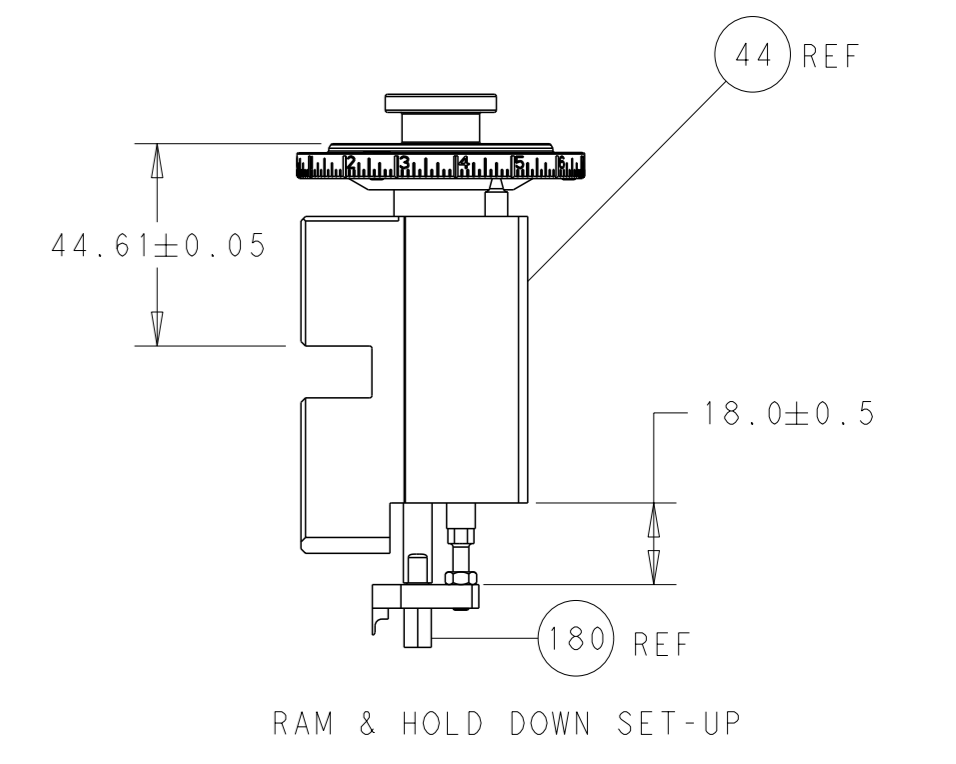
FEED TYPE MECHANICAL



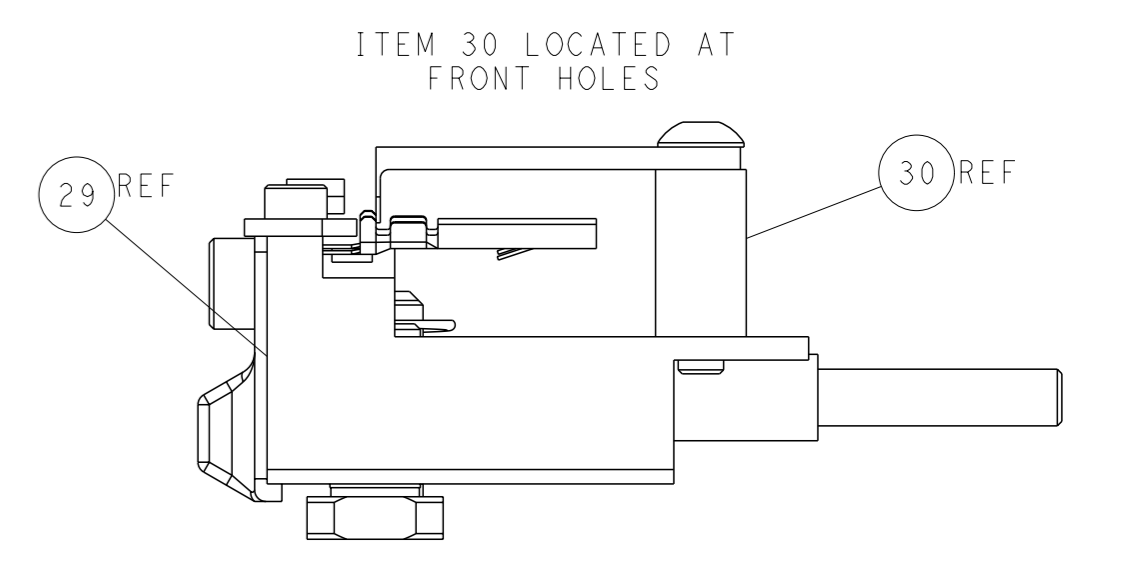
PNEUMATIC



TERMINAL SUPPORT LOCATION

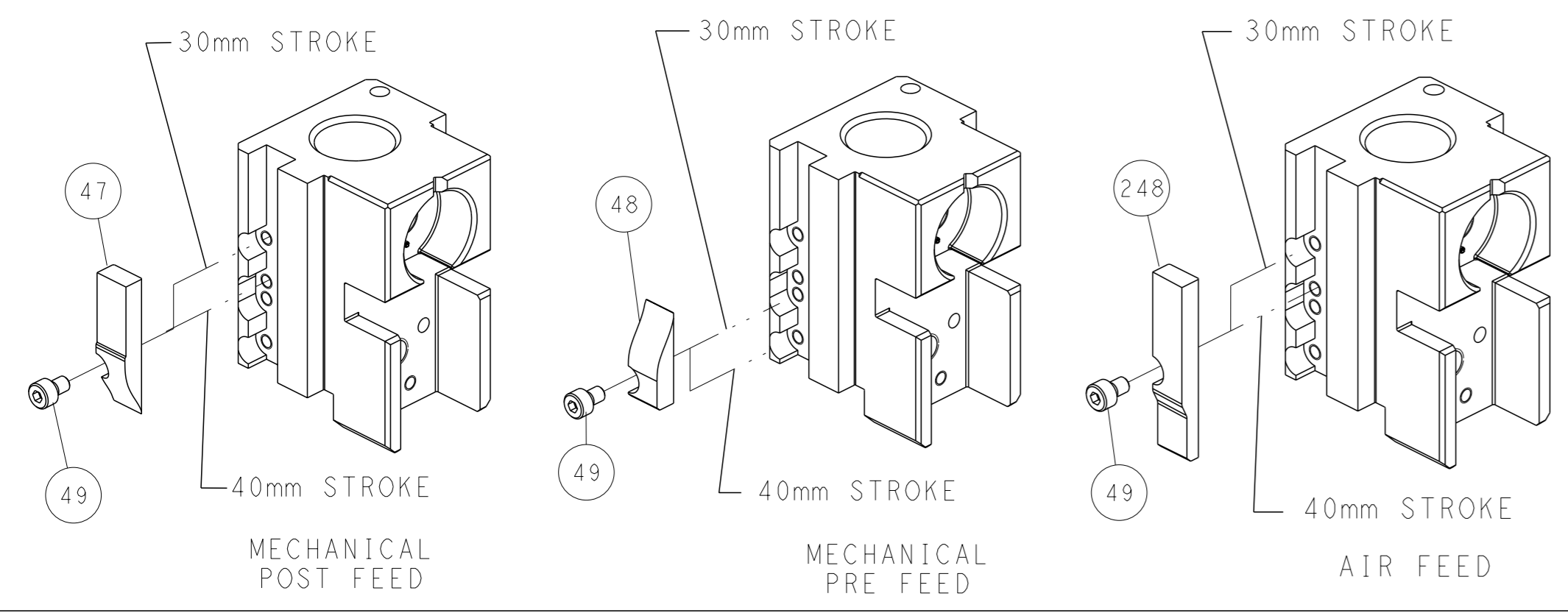


RAM & HOLD DOWN SET-UP



FEED TRACK POSITION GUIDE BY INSULATION BARREL

CAM POSITIONS

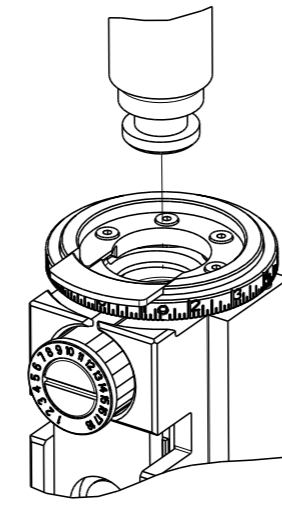


ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

<small>THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE AND THE CONTROLLER'S ENGINEERING DEPARTMENT SHOULD BE CONTACTED FOR THE LATEST REVISION.</small>		DWN L. ZHANG 24AUG2011 CHK L. ZHANG 24AUG2011 APVD S. XI 24AUG2011	TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH ±		NAME Ocean Side Feed Applicator SIZE CAGE CODE DRAWING NO. A1 00779 ©=2151019 WEIGHT - SCALE 1:2 SHEET 2 of 4 REV J	RESTRICTED TO
MATERIAL:		Customer Accessible Production Drawing	

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2151019-1	J	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2151019-2	J	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151019-7	E	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.78 mm [.070]	F
INSUL	2.54 mm [.100]	F
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION

TERMINAL NAME: PIN/SOCKET, MATE-N-LOK	
WIRE STRIP LENGTH 3.96-4.75 mm [.156-.187 IN]	INSULATION DIAMETER RANGE Ø1.02-2.54 mm [.040-.100 IN]
TERMINAL APPLICATION SPECIFICATION (A)114-1010	(B)114-1011

TERMINALS APPLIED

TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
(C) 61115-1	(C) 61314-1	(B) 350560-1	(A) 350570-7
(C) 61116-1	(C) 61314-2	(B) 350561-1	(A) 350699-1
(C) 61116-2	(C) 61314-3	(B) 350561-2	(A) 350699-2
(C) 61116-3	(C) 61314-4	(B) 350561-3	(A) 350699-3
(C) 61116-4	(C) 61314-5	(B) 350561-5	(A) 350699-5
(C) 61116-5	(C) 61314-6	(B) 350561-7	(A) 350699-7
(C) 61116-6	(C) 61314-7	(B) 350561-8	(A) 350699-8
(C) 61116-7	(C) 61314-8	(A) 350570-1	(A) 350851-1
(C) 61116-8	(C) 61527-2	(A) 350570-2	(A) 350851-2
(C) 61116-9	(C) 170147-1	(A) 350570-3	(A) 350851-7
(C) 1-61116-3	(C) 170147-2	(A) 350570-6	

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
18 AWG	1.22 +/- 0.05 [.048 +/- .002]	6.1
20 AWG	1.09 +/- 0.05 [.043 +/- .002]	7.7
22 AWG	1.02 +/- 0.05 [.040 +/- .002]	8.4
24 AWG	0.96 +/- 0.05 [.038 +/- .002]	8.8

- 1 RECOMMENDED SPARE PARTS
 - 2 REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION & 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. LESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 100-35000.

***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)

SET UP GAUGE	LOC	DIST	REVISIONS					
2119599-1	A	66	#	LYR	DESCRIPTION	DATE	OWN	APVD
			-		SEE SHEET 1			

-	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	271
-	1	1	1-690438-0	FRONT STRIP GUIDE	270
-	1	-	2119640-1	PUSH ROD, AIR FEED	250
-	1	-	1803259-1	BUSHING, FLANGED	249
-	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
-	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	1	-	2063440-1	AIR FEED MODULE	238
-	2	-	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172
-	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	1	-	240638-1	SPRING, FEED FINGER	163
-	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	-	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854	137
-	1	-	2119799-1	HOLDER, FEED FINGER, AF	136
-	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	455888-4	SPACER, CRIMPER	82
-	1	1	1803607-1	DOCUMENTATION PACKAGE	71
-	1	1	2119791-6	DEPRESSOR, WIRE	70
-	1	1	2119740-1	TAG, IDENTIFICATION	67
-	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	2	2	2-18032-5	SCR, SET, FLT PNT, M5 X 20.0	61
-	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	1	1	1338685-1	PAWL, FEED	56
-	2	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	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	1752356-3	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	2844992-3	ASSEMBLY, STRIP GUIDE	29
-	2	2	22283-1	SPRING, COMPRESSION	27
-	1	1	356835-1	LEVER, DRAG RELEASE	26
-	1	1	240792-5	DRAG, TERMINAL	25
-	1	1	1320928-2	STRIP GUIDE	24
-	1	1	980371-4	SCR, SKT HD SHLDR 5.0 DIA X 6.0	23
-	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	1803095-3	FLOATING SHEAR, FRONT	9
1	1	1	1338692-1	ANVIL, COMBINATION .070	8
-	1	1	2119757-8	DEPRESSOR, SHEAR	5
-	1	1	2-238011-2	BLOCK, CRIMPER SPACER	4
1	1	1	1-2119582-0	CRIMPER, INSULATION F PREMIUM	3
-	1	1	455888-6	SPACER, CRIMPER	2
1	1	1	1-456404-8	CRIMPER, WIRE PREMIUM	1

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DRAWING NO		RESTRICTED TO	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES FINISH	WEIGHT
MATERIAL		FINISH		SCALE		SHEET 3 OF 4 REV J	

STE TE Connectivity
Harrisburg, PA 17105-3608

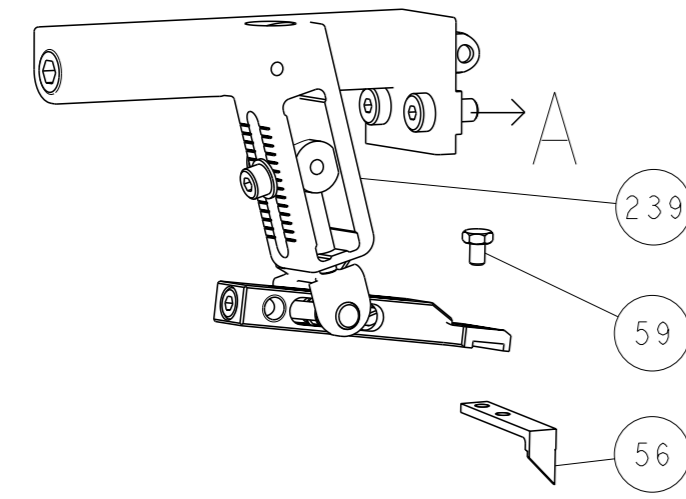
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SIZE: A1 CASE CODE: 00779 C=2151019

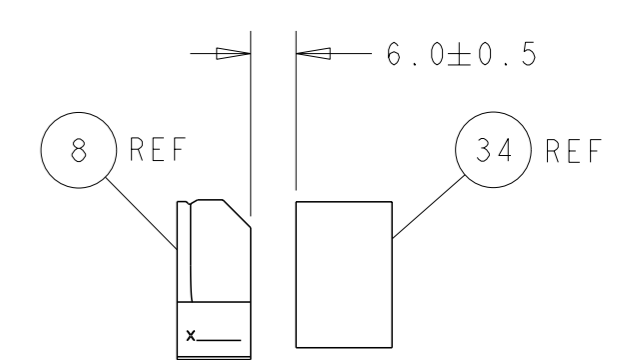
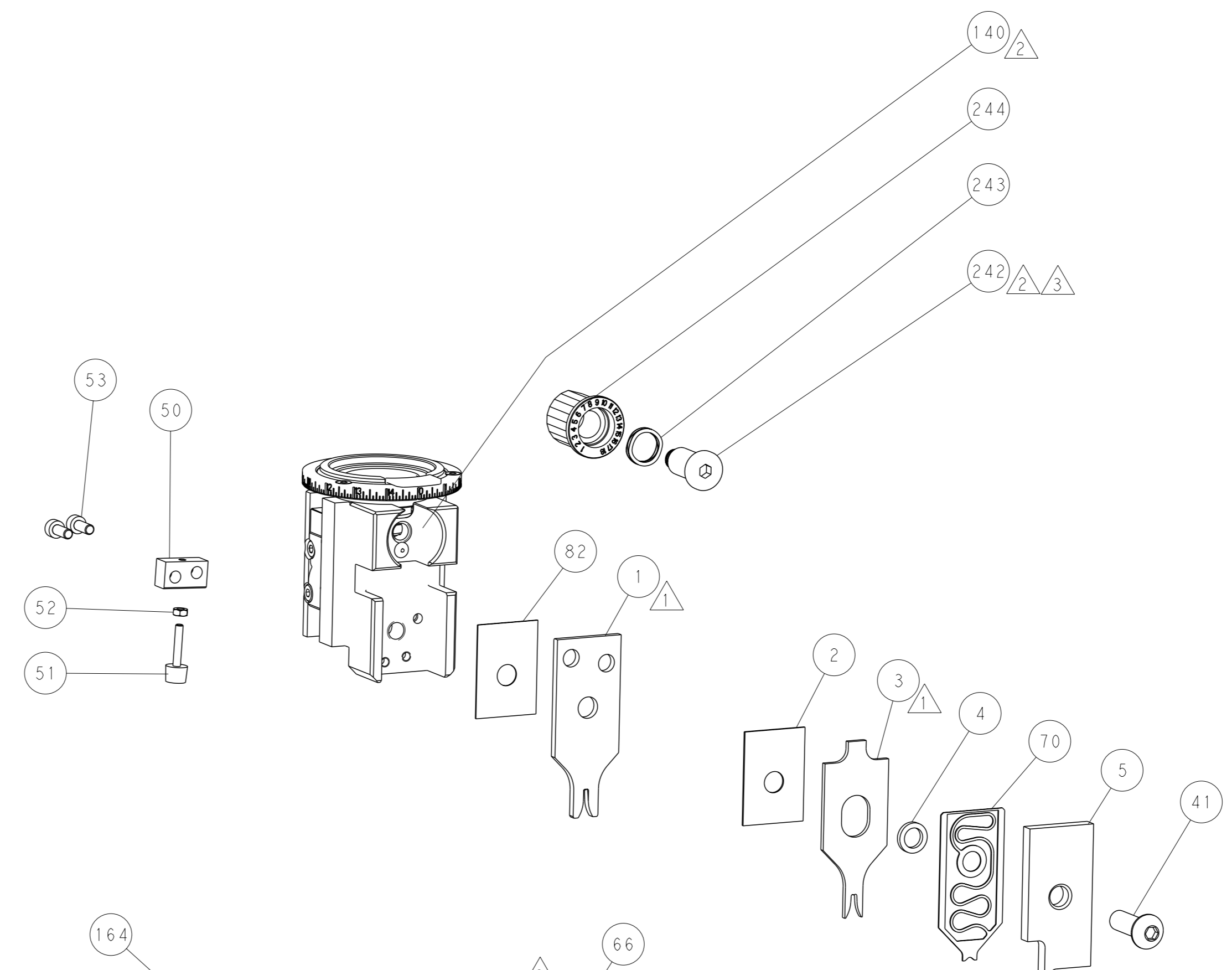
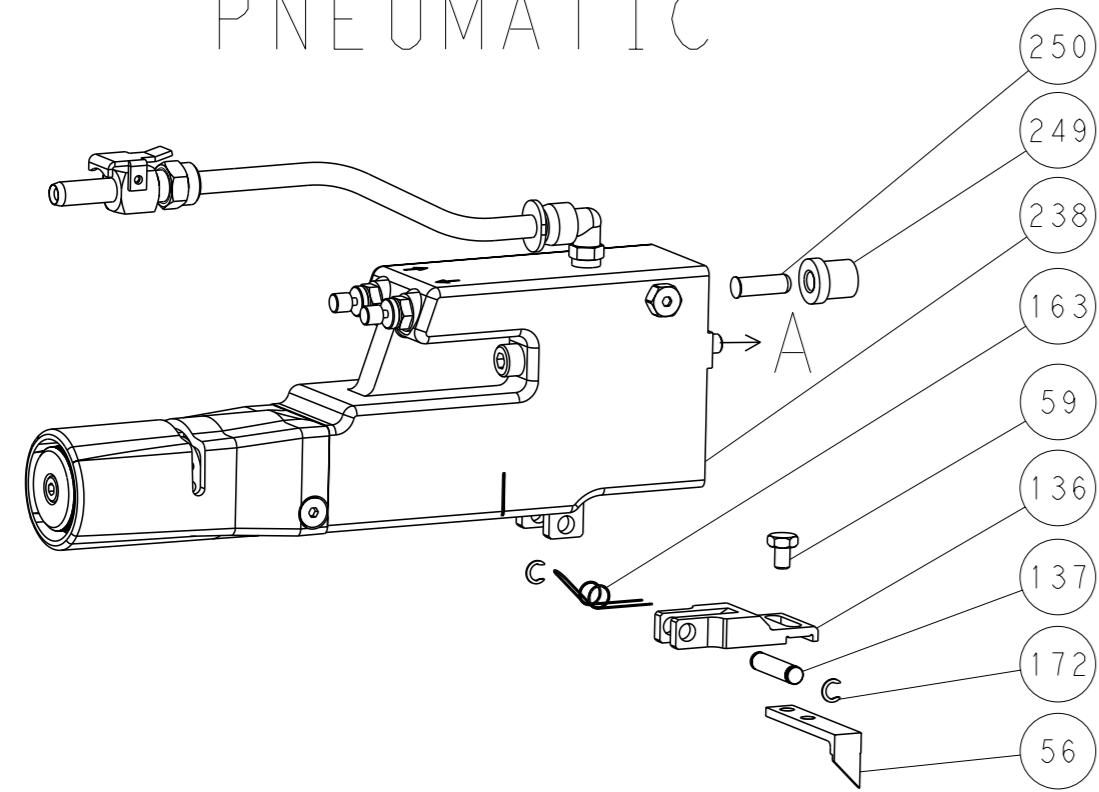
Customer Accessible Production Drawing

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

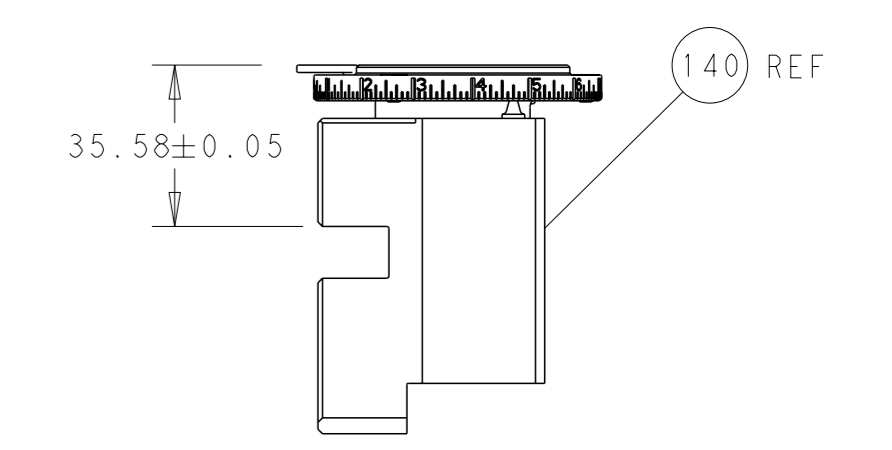
FEED TYPE MECHANICAL



PNEUMATIC

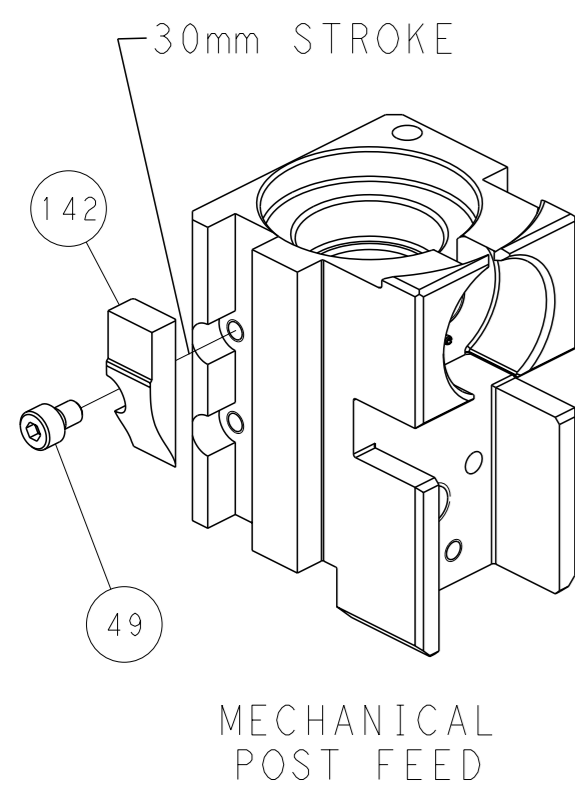


TERMINAL SUPPORT LOCATION

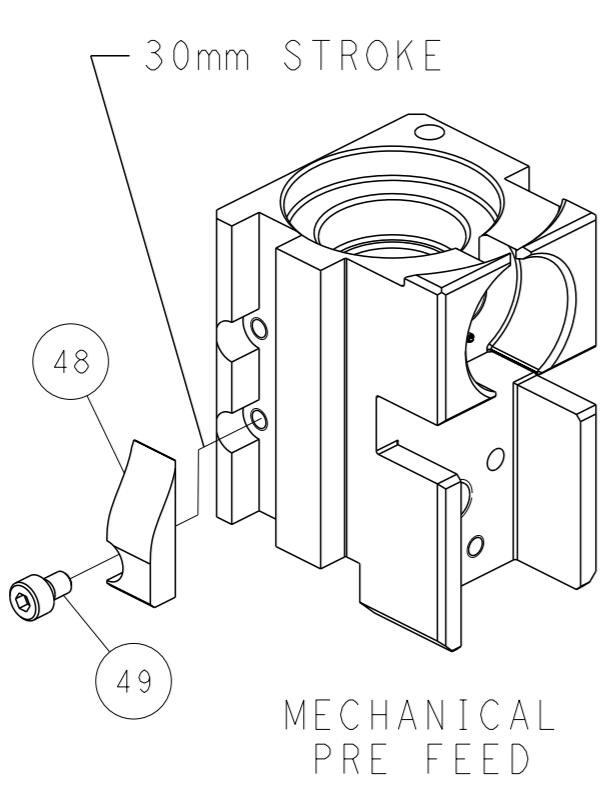


RAM SET-UP

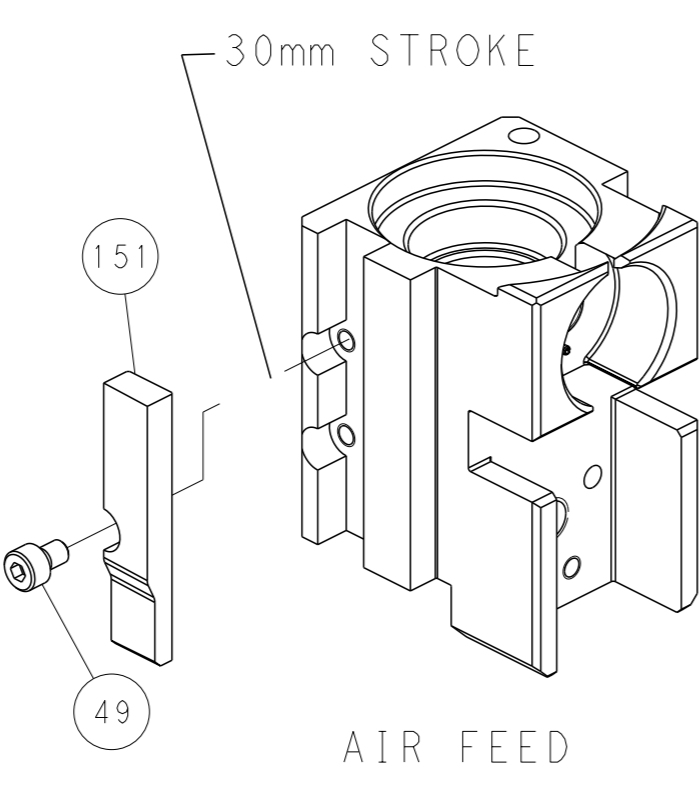
CAM POSITIONS



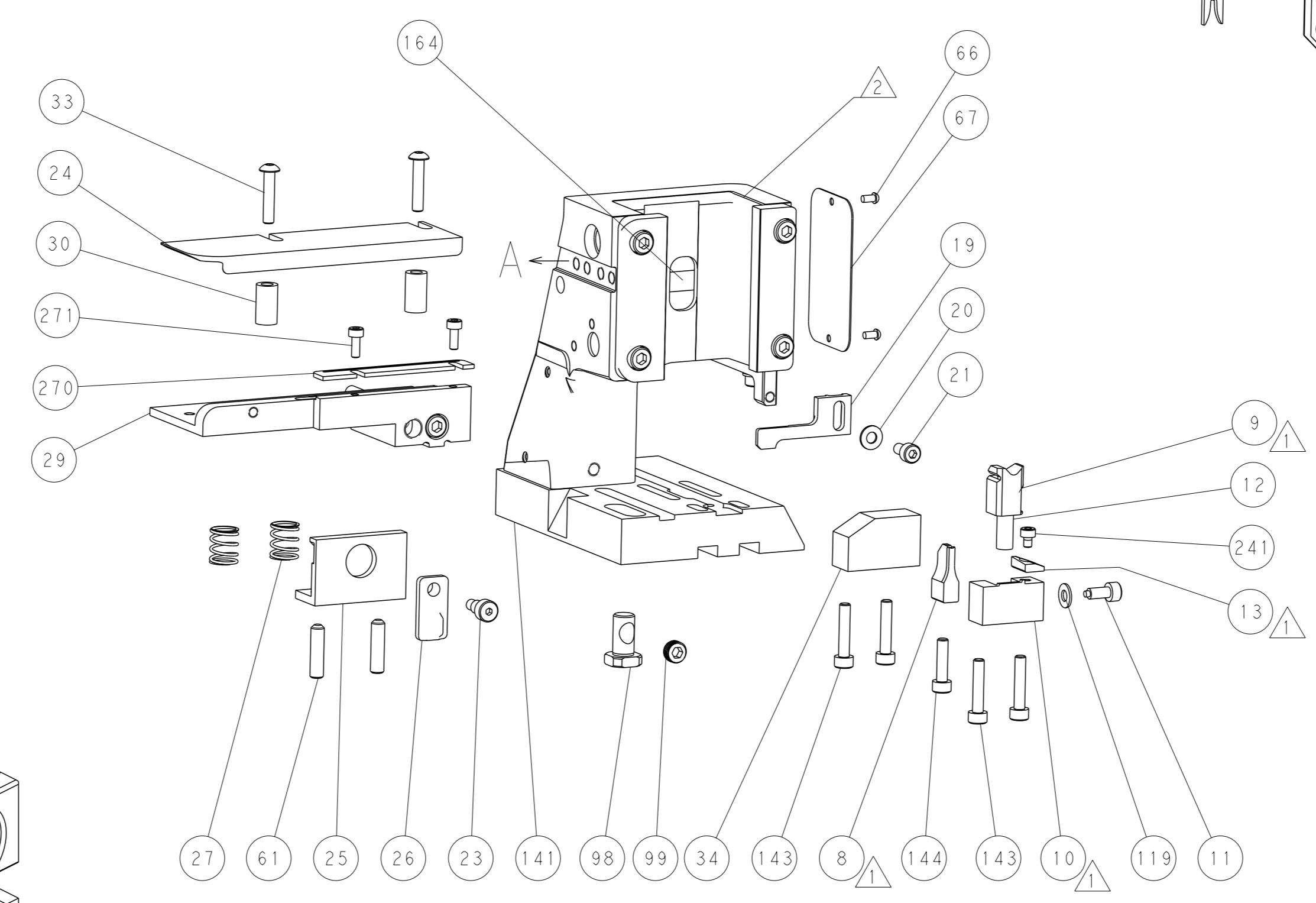
MECHANICAL POST FEED



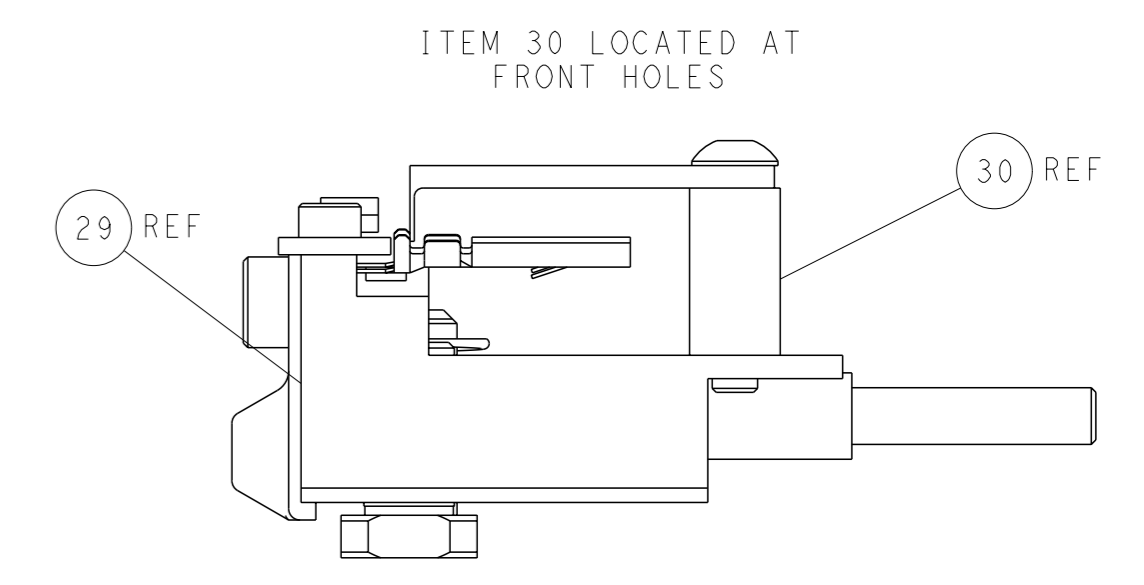
MECHANICAL PRE FEED



AIR FEED



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



FEED TRACK POSITION GUIDE BY INSULATION BARREL

<small>THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE AND THE CONTROLLER'S ENGINEERING DEPARTMENT SHOULD BE CONTACTED FOR THE LATEST REVISION.</small>		OWN: L. ZHANG 24AUG2011 CHK: L. ZHANG 24AUG2011 APVD: S. XI 24AUG2011	NAME: Ocean Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2151019	RESTRICTED TO: - SCALE: 1:2 SHEET: 4 of 4 REV: J
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH ±*	WEIGHT: - MATERIAL: -	PRODUCT SPEC: - APPLICATION SPEC: -	CUSTOMER ACCESSIBLE PRODUCTION DRAWING	SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

单击下面可查看定价，库存，交付和生命周期等信息

[>>TE Connectivity\(泰科\)](#)