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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151184-1	G	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2151184-2	H	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
5-2151184-1	G	SEAL STRIPPER CRIMPER TERMINATING UNIT	MECHANICAL
5-2151184-2	H	SEAL STRIPPER CRIMPER TERMINATING UNIT	PNEUMATIC
7-2151184-1	G	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2151184-2	H	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2151184-7	G	CRIMP TOOLING KIT	-

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.57 mm [.062]	F
INSUL	1.78 mm [.070]	BX
APPLICATOR INSTRUCTIONS 408-35042		

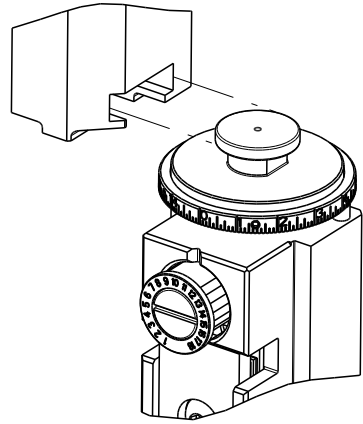
TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: .040 SERIES REC / TAB CONTACT			
WIRE STRIP LENGTH 4.00-4.50 mm [.157-.177 IN]		INSULATION DIAMETER RANGE Ø1.80-2.00 mm [.071-.079 IN]	
TERMINAL APPLICATION SPECIFICATION (A)114-5094		(B)114-5108	
(C)114-5111		(D)114-13170	
TERMINALS APPLIED			
TE TERMINAL (A) 173681-1	TE TERMINAL (A) 173681-2	TE TERMINAL (A) 173681-3	TE TERMINAL (A) 173681-4
(A) 173681-6	(B) 173682-1	(B) 2098032-1	(C) 2098032-3
(C) 173716-1	(C) 173716-2	(D) 776768-2	(D) 776768-3

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.50mm2	1.02+/-0.05 [.040+/- .002]	4.8
0.30mm2	0.92+/-0.05 [.036+/- .002]	5.8
20 AWG OR 0.50mm2	0.97+/-0.05 [.038+/- .002]	5.3
22 AWG OR 0.30mm2	0.88+/-0.05 [.035+/- .002]	6.2



- 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. APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 180.
- 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.
- UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- TERMINALS 173716, 173681, 173682, AND 2098032 CRIMP WIRE SIZES OF 0.30mm² (7/0.26) AND 0.50mm² (7/0.32); TYPICALLY AVS. REFER TO APPLICABLE TERMINAL APPLICATION SPECIFICATION FOR CALCULATED CROSS-SECTIONAL AREA.
- ADJUSTMENTS ARE REQUIRED WHEN CHANGING TERMINALS.

ATLANTIC VERSION TERMINATOR
INTERFACE ADAPTER



TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: .040 SERIES TSAB CONTACT MULTI-LOC			
WIRE STRIP LENGTH 4.00-4.50 mm [.157-.177 IN]		INSULATION DIAMETER RANGE Ø1.40-2.00 mm [.055-.079 IN]	
TERMINAL APPLICATION SPECIFICATION (A)114-5094		-	
TERMINALS APPLIED		-	
TERMINALS APPLIED			
TE TERMINAL (A) 776181-1	TE TERMINAL	TE TERMINAL	TE TERMINAL

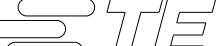
WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
18 AWG	1.17+/-0.05 [.046+/- .002]	3.3

*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 CRIMPTOOLING. 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
		E		ECR-17-004154	22MAR2017	TB	TE
		F		ECR-18-011592	20JUL2018	TB	TE
		G		ECR-19-009598	19JUN2019	MZ	YY
		H		ECR-19-009777	06JUL2019	TB	TE

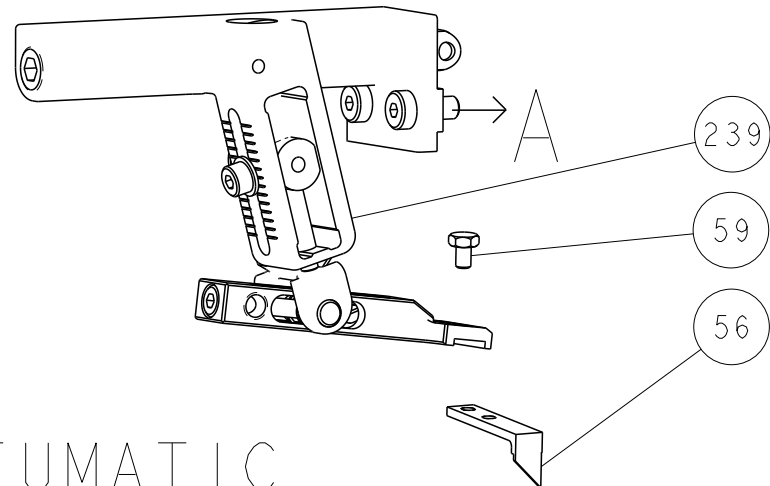
-	-	-	1	1	-	-	1803515-3	RAM ASSEMBLY, SF ATLANTIC	293
-	-	-	1	1	-	-	2-1803583-1	APPLICATOR BASIC ASSEMBLY, SF	292
-	1	-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248
-	1	1	1	1	1	1	2119082-6	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	1	1	1	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
-	-	1	-	1	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	1	-	1	-	1	-	2844940-1	AIR FEED MODULE	238
-	-	-	1	1	-	-	4-1722335-3	STRIPPER, SIDE FEED	182
-	-	-	1	1	-	-	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	181
-	-	-	1	1	-	-	1-1752354-9	STANDOFF,HOLD-DOWN	180
-	-	-	1	1	-	-	9931111-1	PIN, SLOTTED SPRING 3.0 X 20.0	177
-	-	-	1	1	-	-	5-22280-0	SPRING, COMPRESSION	176
-	-	-	1	1	-	-	1752353-3	GUIDE PIN,HOLDDOWN	175
-	-	-	1	1	-	-	1901680-2	GUIDE PIN,HOLDDOWN	174
-	REF	REF	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	1	1	1	1	1	1	2844908-1	SCREW, LOCKING	99
-	1	1	1	1	1	1	2844907-1	POST, LOCKING	98
-	1	1	1	1	1	1	455888-5	SPACER, CRIMPER	82
-	1	1	1	1	1	1	2119791-8	DEPRESSOR, WIRE	73
-	1	1	1	1	1	1	1803607-3	DOCUMENTATION PACKAGE	71
-	1	1	1	1	1	1	2119791-5	DEPRESSOR, WIRE	70
-	1	1	1	1	1	1	2119740-1	TAG,IDENTIFICATION	67
-	2	2	2	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	1	1	1	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	60
-	1	1	1	1	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	1	1	1	1	1	1	1338685-1	PAWL, FEED	56
-	4	4	4	4	4	4	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	54
-	2	2	2	2	2	2	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	53
-	1	1	1	1	1	1	5018030-1	NUT, HEX, REG, RoHS, M3	52
-	1	1	1	1	1	1	811242-5	BUMPER, HOLD DOWN	51
-	1	1	1	1	1	1	690753-2	SPACER, TONKER	50
-	1	2	1	2	1	2	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	-	1	-	1	-	1	2119652-1	FEED CAM, PRE FEED	48
-	-	1	-	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	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
-	1	1	1	1	1	1	2-1752356-3	SUPPORT, TERMINAL	34
-	2	2	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	2	2	2	2	3-2844962-0	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	1	1	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29
-	1	1	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
-	2	2	1	1	2	2	1-18028-2	WASHER, FLAT, REG M4	20
-	1	1	-	-	1	1	2119533-1	STRIPPER, SIDE FEED	19
-	1	1	1	1	1	1	2119806-1	INSERT, SHEAR	13
-	1	1	1	1	1	1	3-22280-3	SPRING, COMPRESSION	12
-	1	1	1	1	1	1	1-356885-4	STOP, SHEAR	11
-	1	1	1	1	1	1	2119805-1	SHEAR HOLDER, FRONT	10
-	1	1	1	1	1	1	1803095-1	FLOATING SHEAR, FRONT -	9
1	2	2	1	1	1	1	4-1333202-6	ANVIL, COMBINATION	8
-	1	1	1	1	1	1	3-240641-3	SPACER	7
-	-	-	-	-	-	-	-	-	6
-	1	1	1	1	1	1	2119757-8	DEPRESSOR, SHEAR	5
-	1	1	1	1	1	1	2-238011-1	BLOCK, CRIMPER SPACER	4
1	2	2	1	1	1	1	1633988-5	CRIMPER, INSULATION BOX PREMIUM	3
-	1	1	1	1	1	1	455888-1	SPACER, CRIMPER	2
1	2	2	1	1	1	1	3-456403-4	CRIMPER, WIRE PREMIUM	1

-77 -72 -71 -52 -51 -2 -1						PART NO		DESCRIPTION			ITEM NO						
THIS DRAWING IS A CONTROLLED DOCUMENT FOR TWO ELECTRONICS CORPORATION IT IS SUBJECT TO CHANGE WITHOUT NOTICE AND WITHOUT LIABILITY THE ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST EDITION.						DWN X.ZHAO	10AUG2011		TE Connectivity		Harrisburg, PA 17105-3608						
DIMENSIONS: mm 						CHK S.XI	10AUG2011		NAME								
												APVD J.CRUZ	01JUN2011	PRODUCT SPEC			
												APPLICATION SPEC		Ocean Side Feed Applicator -			
MATERIAL - -						FINISH		-		WEIGHT	-	SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO		
												A1	00779	©=2151184	-		
Customer Accessible Production Drawing										SCALE	1:2	SHEET	1	OF	4	REV	H

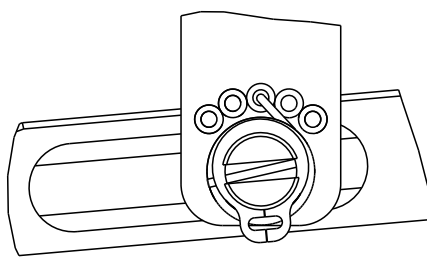
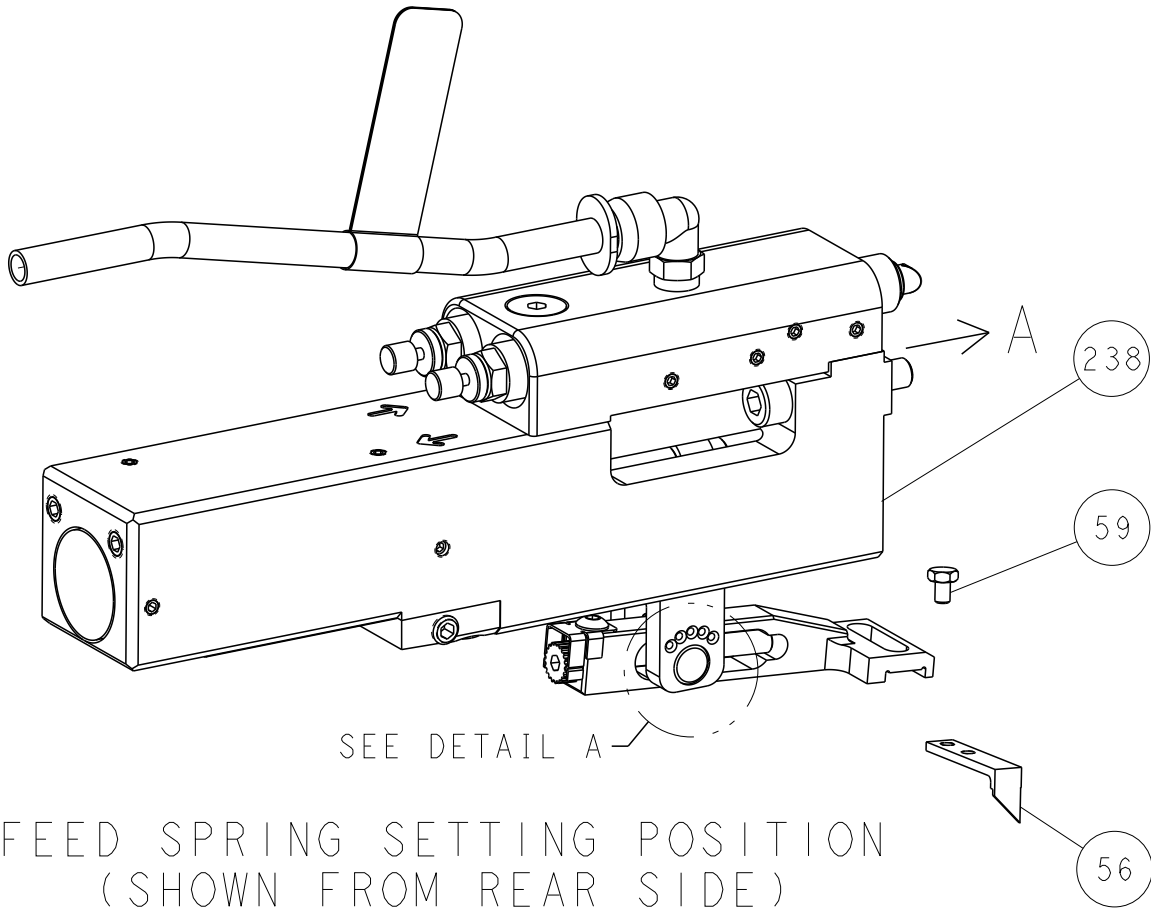
SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

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

FEED TYPE MECHANICAL

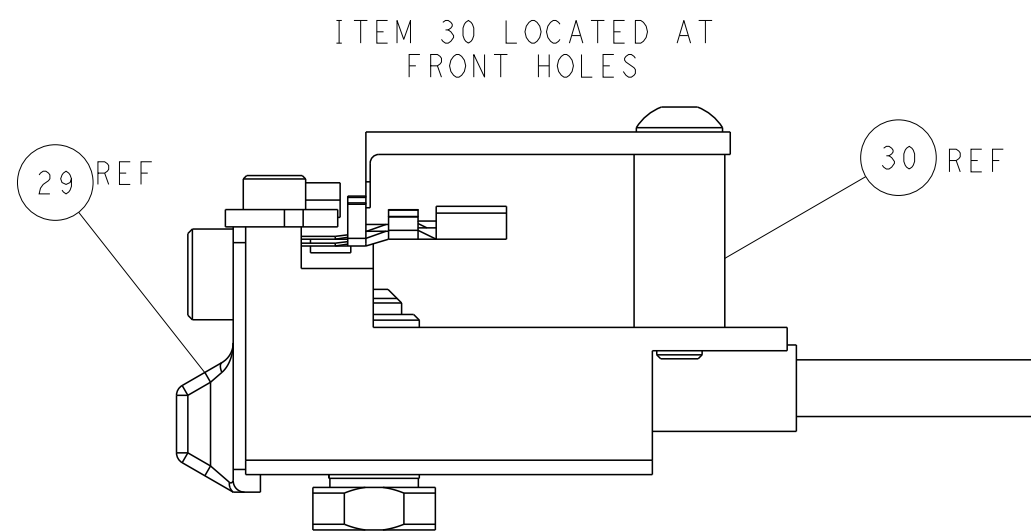
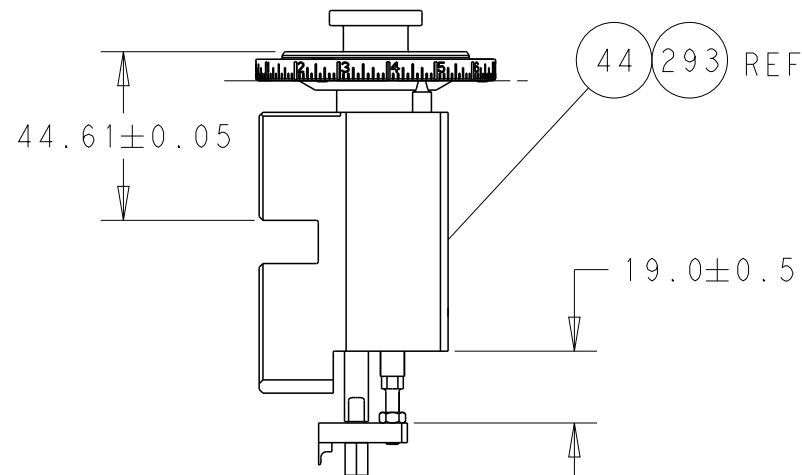
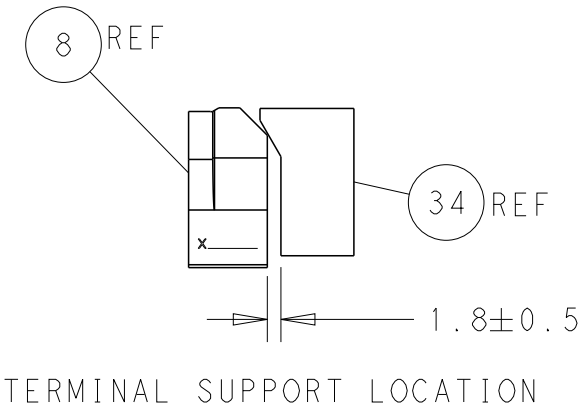
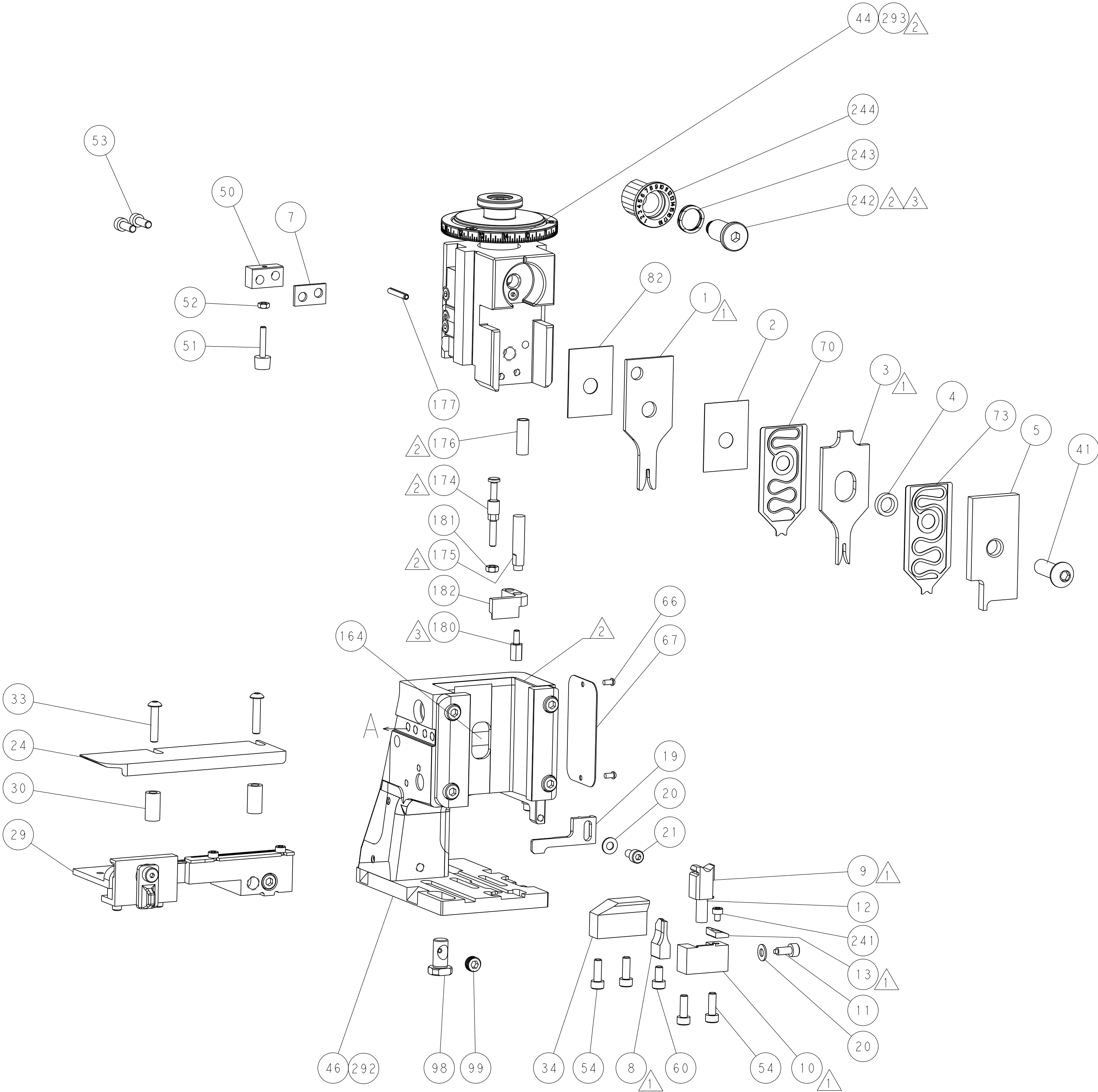
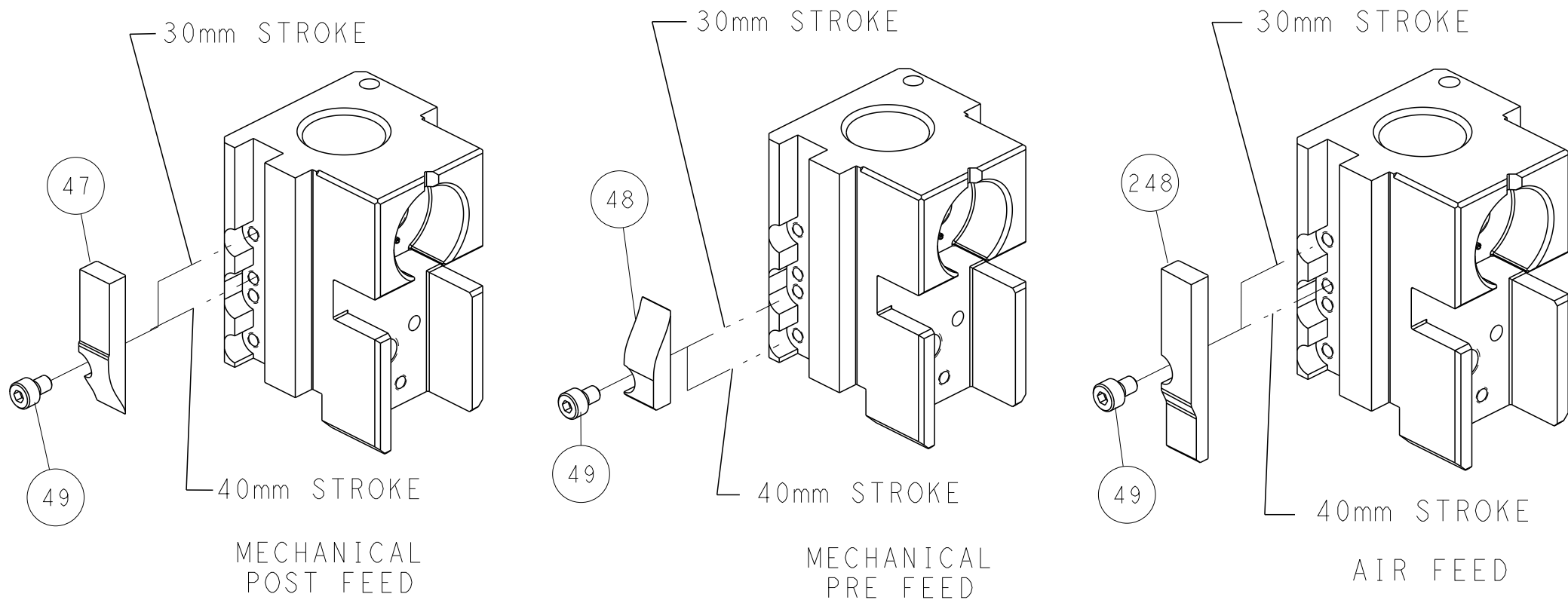


PNEUMATIC



DETAIL A

CAM POSITIONS

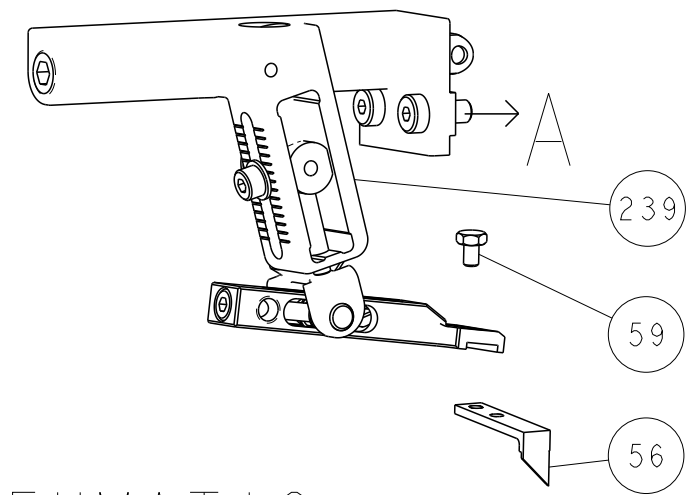


ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

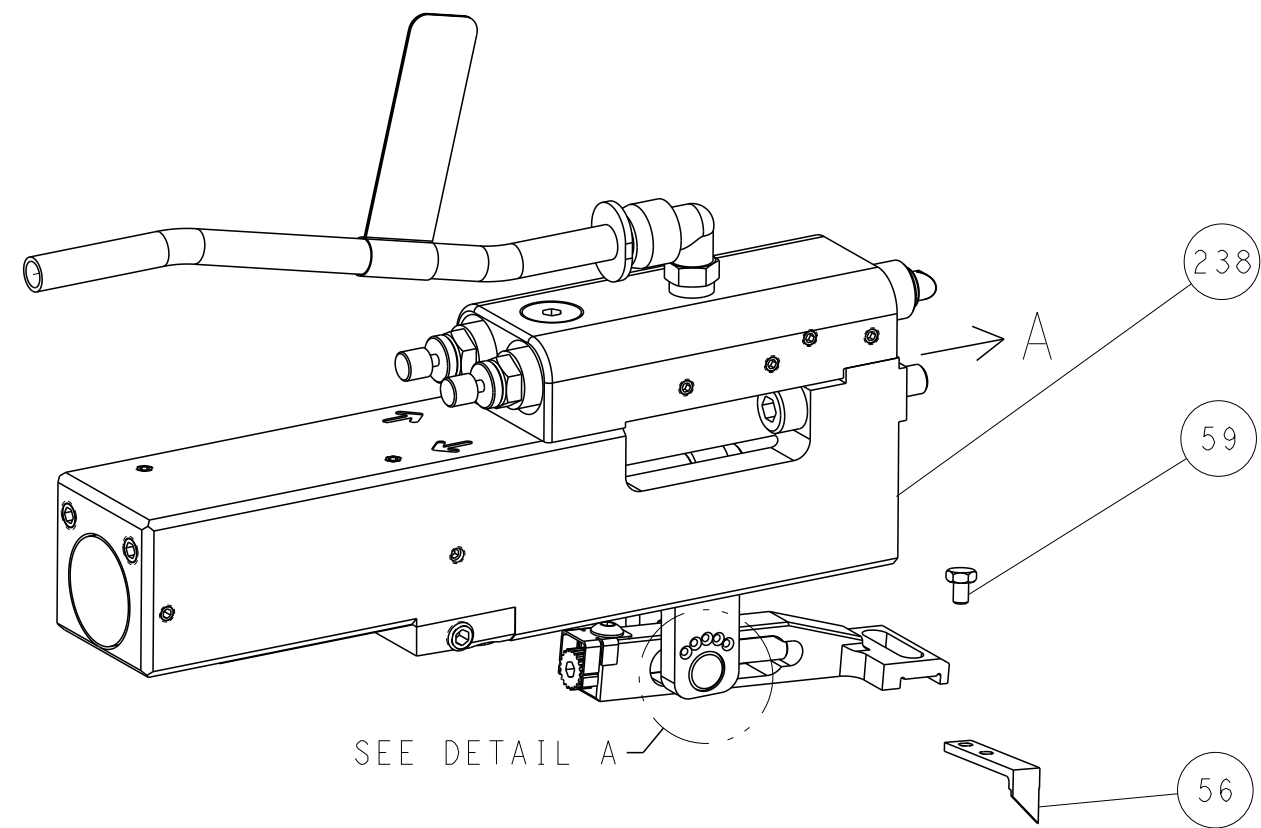
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CHK				CHK	S. XI	10AUG2011	NAME	
APVD				APVD	I. CRUZ	01JUN2011	Ocean Side Feed Applicator	
PRODUCT SPEC				APPLICATION SPEC		SIZE		RESTRICTED TO
MATERIAL				WEIGHT		A1 00779 C=2151184		-
Customer Accessible Production Drawing				SCALE		1:2		REV H

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

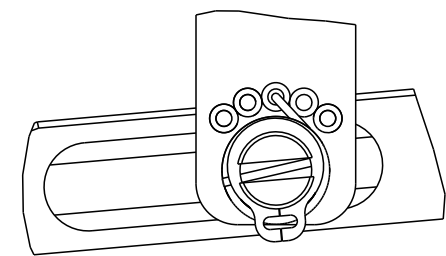
FEED TYPE MECHANICAL



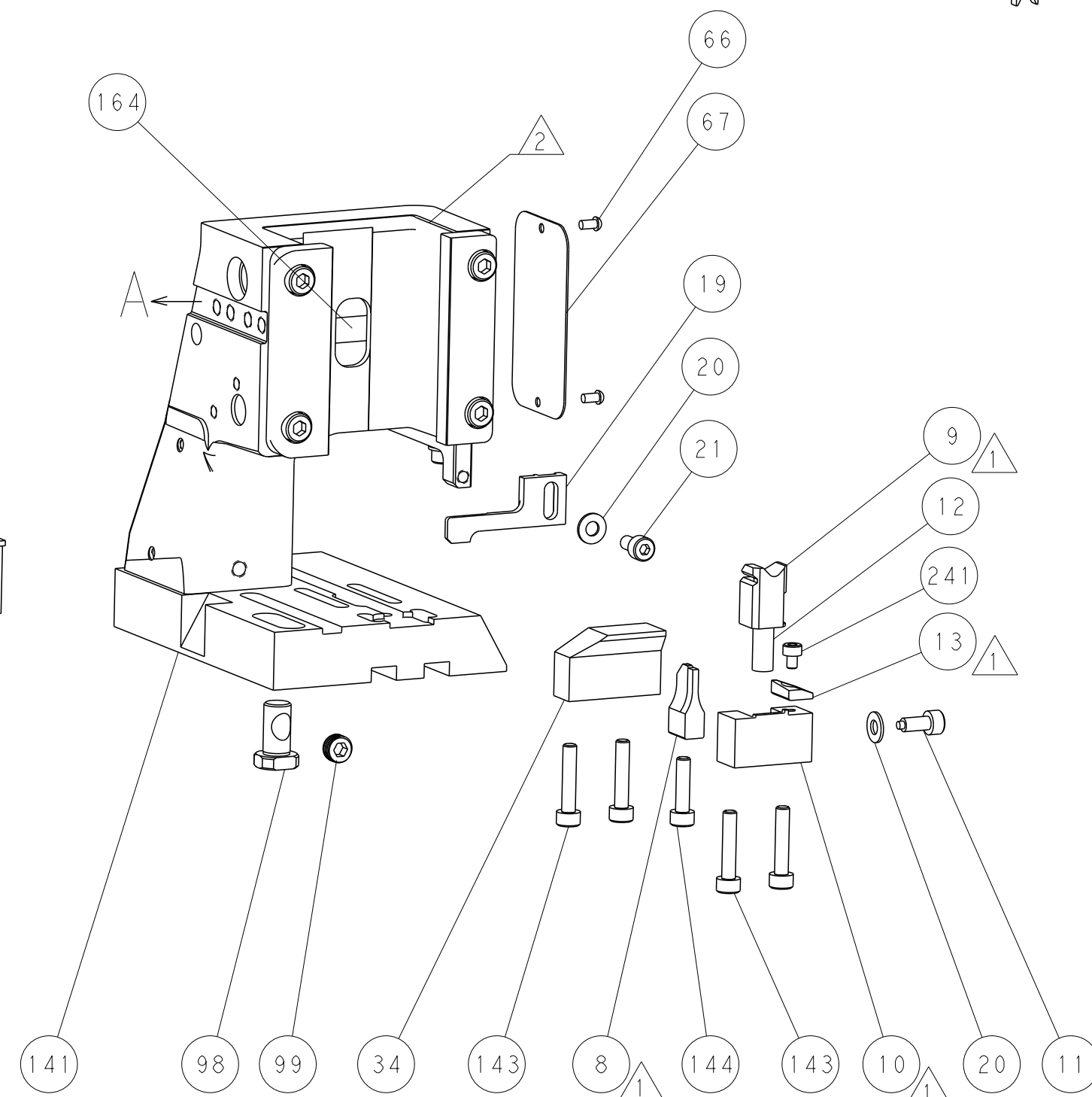
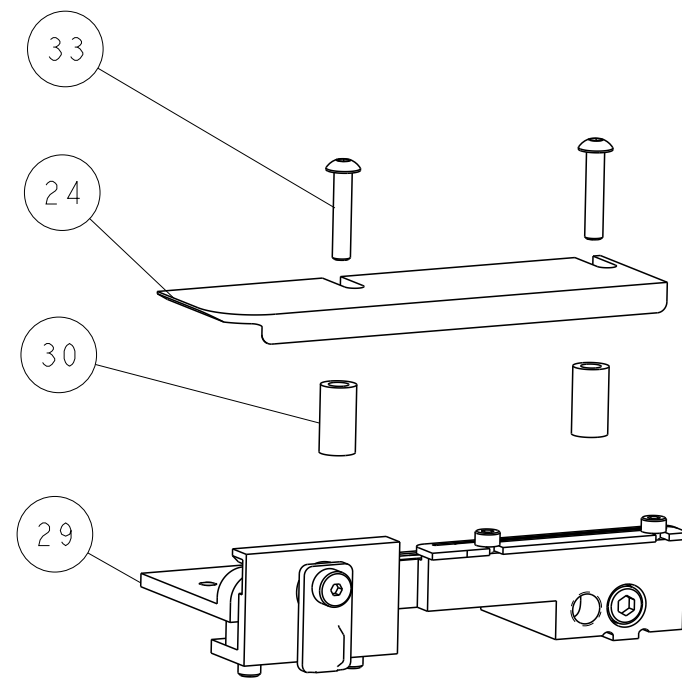
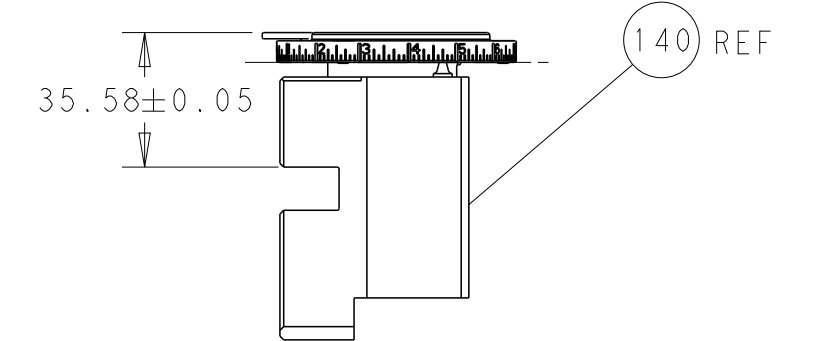
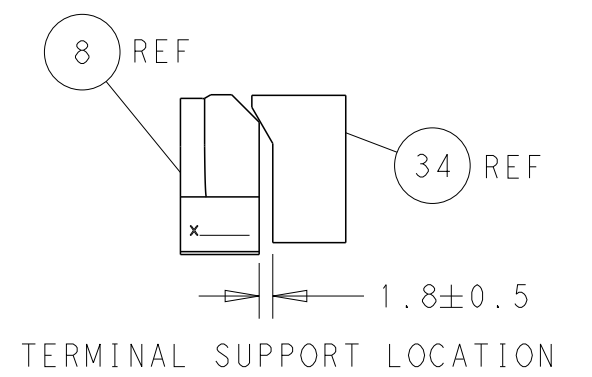
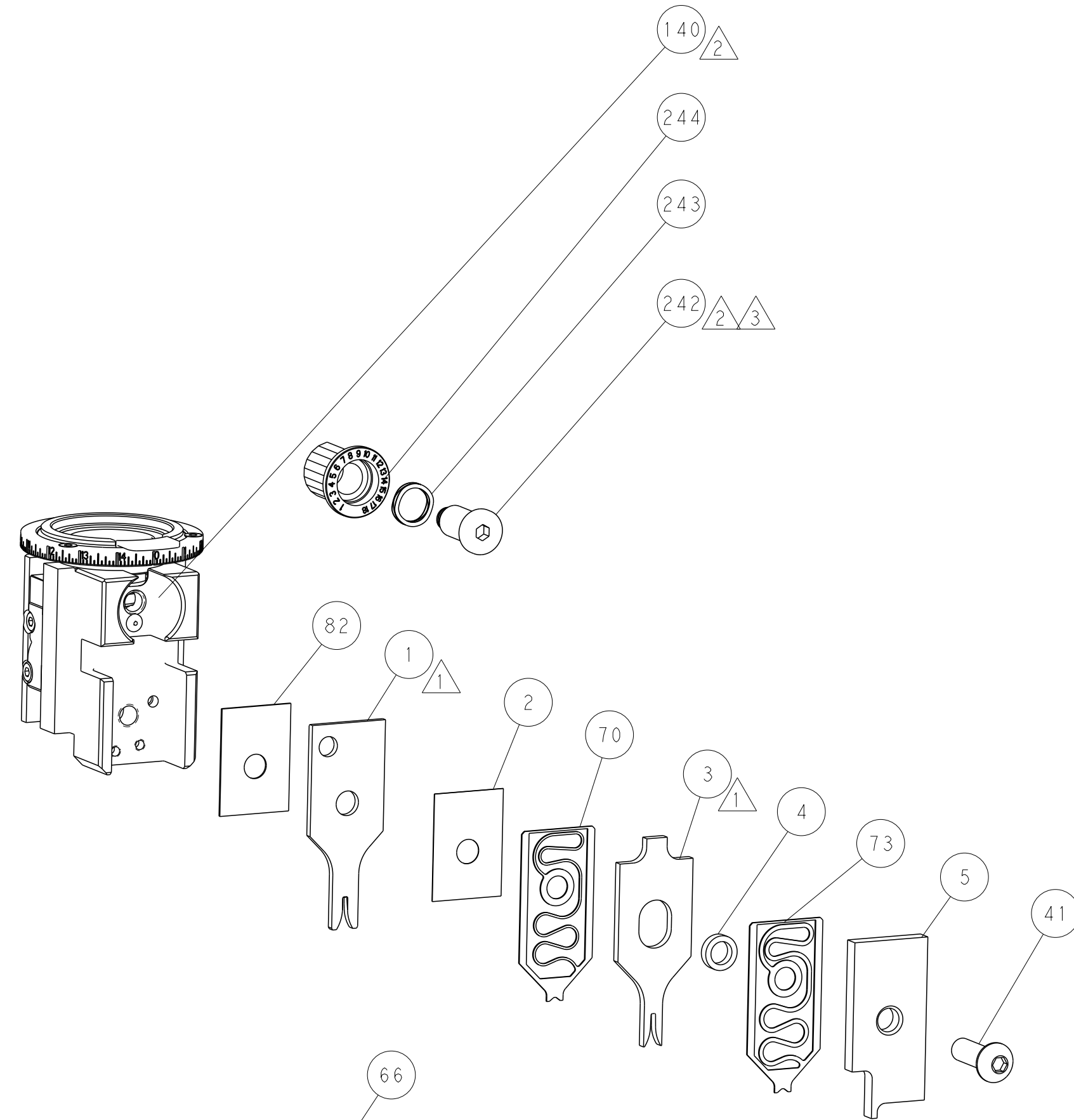
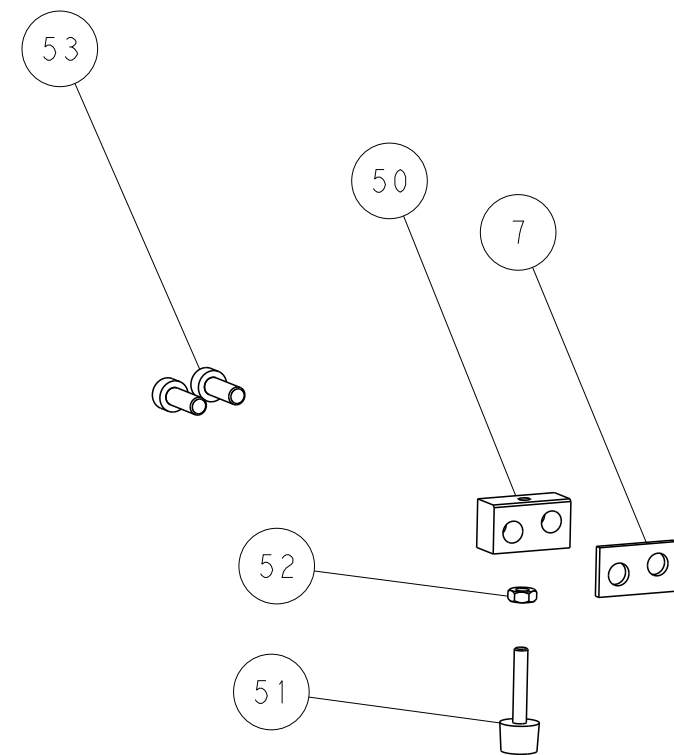
PNEUMATIC



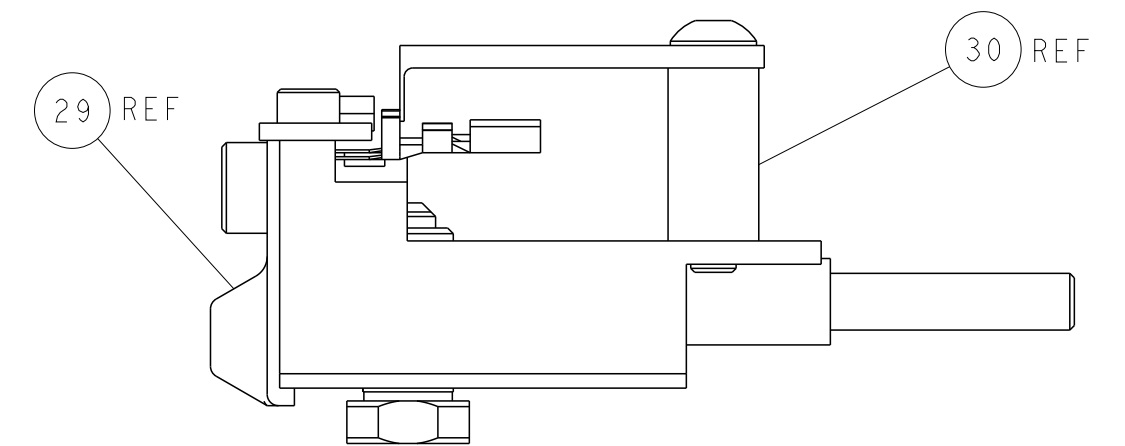
FEED SPRING SETTING POSITION
(SHOWN FROM REAR SIDE)



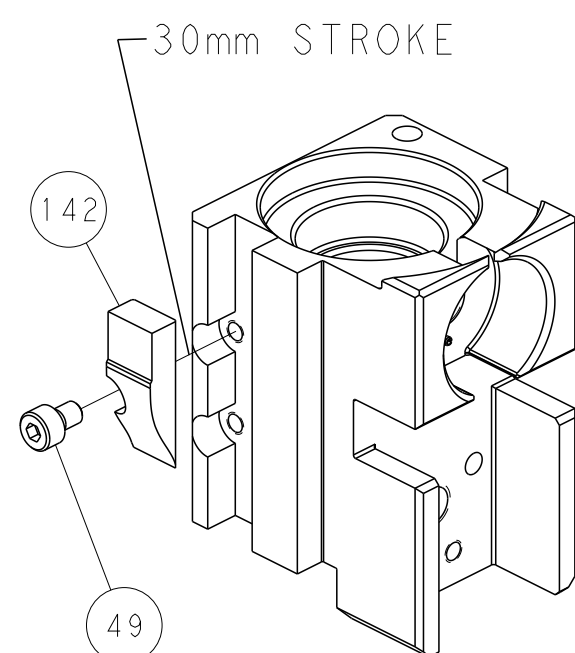
DETAIL A



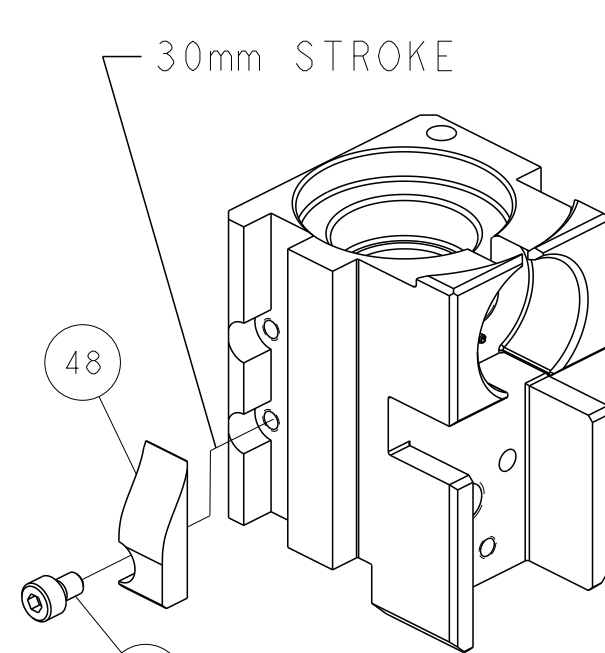
ITEM 30 LOCATED AT
FRONT HOLES



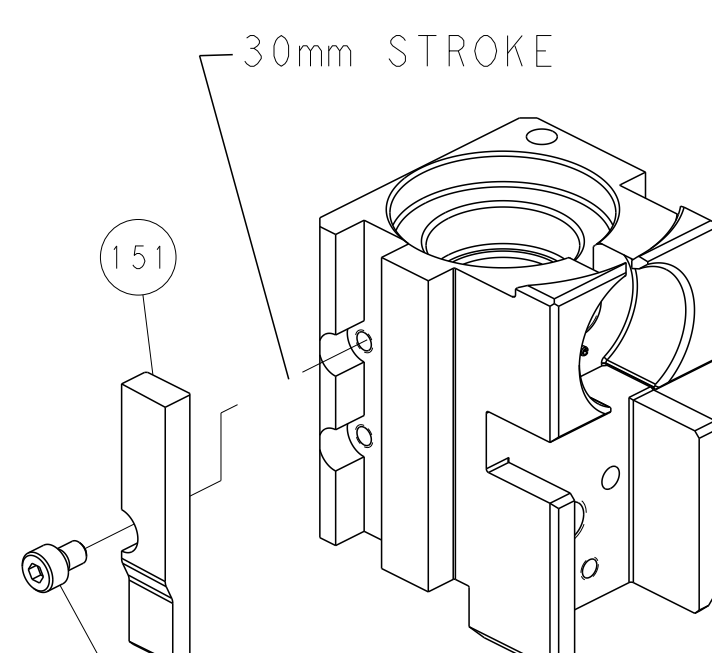
CAM POSITIONS



MECHANICAL
POST FEED

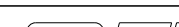


MECHANICAL
PRE FEED



AIR FEED

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

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				CHK	S. XI	10AUG2011	NAME														
DIMENSIONS:				APVD	I. CRUZ	01JUN2011	Ocean Side Feed Applicator														
mm				PRODUCT SPEC		SIZE					CAGE CODE		DRAWING NO		RESTRICTED TO						
				TOLERANCES UNLESS OTHERWISE SPECIFIED:		APPLICATION SPEC					SCALE		SHEET		4 OF 4		REV				
				0 PLC		±					-		A		00779		C-2151184		H		
				1 PLC		±															
				2 PLC		±															
				3 PLC		±															
4 PLC		±																			
ANGLES		±																			
FINISH		-																			
MATERIAL		-																			
				WEIGHT		-															
				Customer Accessible Production Drawing																	

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION