

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151731-1	H	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2151731-2	H	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
5-2151731-1	H	SEAL STRIPPER CRIMPER TERMINATING UNIT	MECHANICAL
5-2151731-2	H	SEAL STRIPPER CRIMPER TERMINATING UNIT	PNEUMATIC
7-2151731-1	H	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2151731-2	H	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2151731-7	H	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.54 mm [.100]	F
INSUL	3.30 mm [.130]	O

APPLICATOR INSTRUCTIONS 408-35042

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION			
TERMINAL NAME: SOCKET/PIN CONTACT			
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE		
.185-.217 IN [4.70-5.51 mm]	Ø.089-.131 IN [2.26-3.33 mm]		
TERMINAL APPLICATION SPECIFICATION	114-13045		
TERMINALS APPLIED 6			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
776492-1	776492-2	638078-1	638078-3

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION			
TERMINAL NAME: SOCKET/PIN CONTACT			
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE		
.185-.217 IN [4.70-5.51 mm]	Ø.089-.131 IN [2.26-3.33 mm]		
TERMINAL APPLICATION SPECIFICATION	114-13045		
TERMINALS APPLIED 6			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
776493-1	776493-2	776349-1	776349-3

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION			
TERMINAL NAME: SOCKET/PIN CONTACT			
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE		
.185-.217 IN [4.70-5.51 mm]	Ø.089-.131 IN [2.26-3.33 mm]		
TERMINAL APPLICATION SPECIFICATION	114-18022		
TERMINALS APPLIED 6			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
776492-1	776492-2	-	-

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
14 AWG	1.63+/-0.05 [1.064+/-0.002]	5.5
16 AWG	1.50+/-0.05 [1.059+/-0.002]	6.9
18 AWG	1.37+/-0.05 [1.054+/-0.002]	8.4

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
18 AWG	1.32+/-0.05 [1.052+/-0.002]	9.0
20 AWG	1.22+/-0.05 [1.048+/-0.002]	10.0

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.50mm2	1.55+/-0.05 [1.061+/-0.002]	6.9

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION			
TERMINAL NAME: SOCKET/PIN CONTACT			
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE		
.185-.217 IN [4.70-5.51 mm]	Ø.089-.131 IN [2.26-3.33 mm]		
TERMINAL APPLICATION SPECIFICATION	114-18022		
TERMINALS APPLIED 6			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
776493-1	-	-	-

WIRE SIZE	CRIMP HEIGHT W2_CRIMP_UNITS	CRIMP HEIGHT REFERENCE SETTING
0.75mm2	1.27+/-0.05 [1.050+/-0.002]	9.5

- 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 180.
- 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 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. **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.
- 6 TERMINAL LUBRICANT IS RECOMMENDED.
- 7. 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.

LOC	DIST	REVISIONS					
A	66	P	LTN	DESCRIPTION	DATE	OWN	APVD
		F		ECR-22-147627	27JUL2022	TB	GB
		G		ECR-22-149202	11AUG2022	TB	TE
		H		ECR-23-189429	11OCT2023	ROY	TLE
		H1		ECR-24-201375	28FEB2024	TB	GB

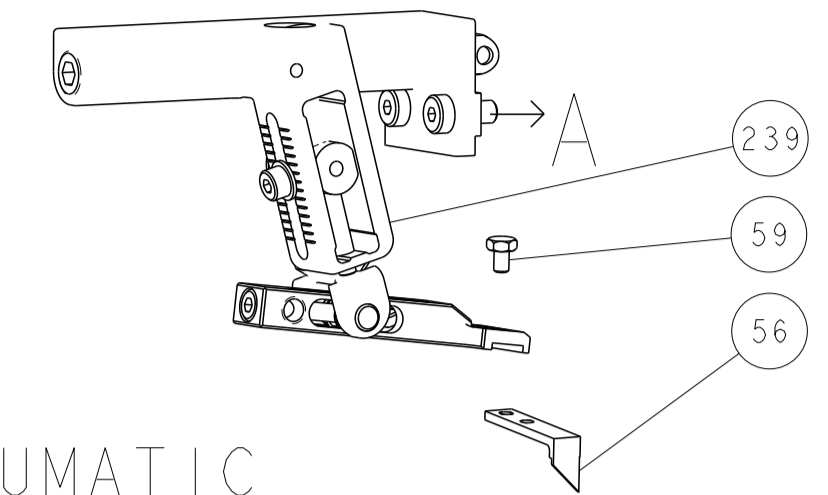
-	1	1	1	1	1	1	1803945-4	TONKER	300
-	1	1	1	1	1	1	22278-9	SPRING, COMPRESSION	299
-	2	2	2	2	2	2	4-18032-3	SCR, SET, FLT PNT, M3 X 6.0	298
-	1	1	1	1	1	1	1803944-1	SPACER, TONKER	297
-	-	-	1	1	-	-	2-1803583-1	APPLICATOR BASIC ASSEMBLY, SF	292
-	1	-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248
-	1	1	1	1	1	1	2119082-9	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
-	REF	REF	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	1	1	1	1	1	1	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113
-	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	455888-6	SPACER, CRIMPER -	82
-	1	1	1	1	1	1	22278-8	SPRING, COMPRESSION	77
-	1	1	1	1	1	1	854769-4	HOLDER, INS	74
-	1	1	1	1	1	1	1803607-3	DOCUMENTATION PACKAGE	71
-	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	21028-2	PIN, SLOTTED SPRING .062 X .250	58
-	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	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	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	1752356-6	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	455888-4	SPACER, CRIMPER -	28
-	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	1633133-8	ANVIL, COMBINATION .100	8
-	1	1	1	1	1	1	1-240641-1	SPACER	7
-	-	-	-	-	-	-	-	-	6
-	1	1	1	1	1	1	1-2119780-1	DEPRESSOR, SHEAR	5
-	1	1	1	1	1	1	4-238011-1	BLOCK, CRIMPER SPACER	4
1	2	2	1	1	1	1	1-1803019-9	CRIMPER, INSULATION O	3
-	1	1	1	1	1	1	455888-1	SPACER, CRIMPER -	2
1	2	2	1	1	1	1	456407-6	CRIMPER, WIRE PREMIUM	1

ITEM NO	PART NO	DESCRIPTION	ITEM NO
-77	-72	-71	-52
-51	-2	-1	

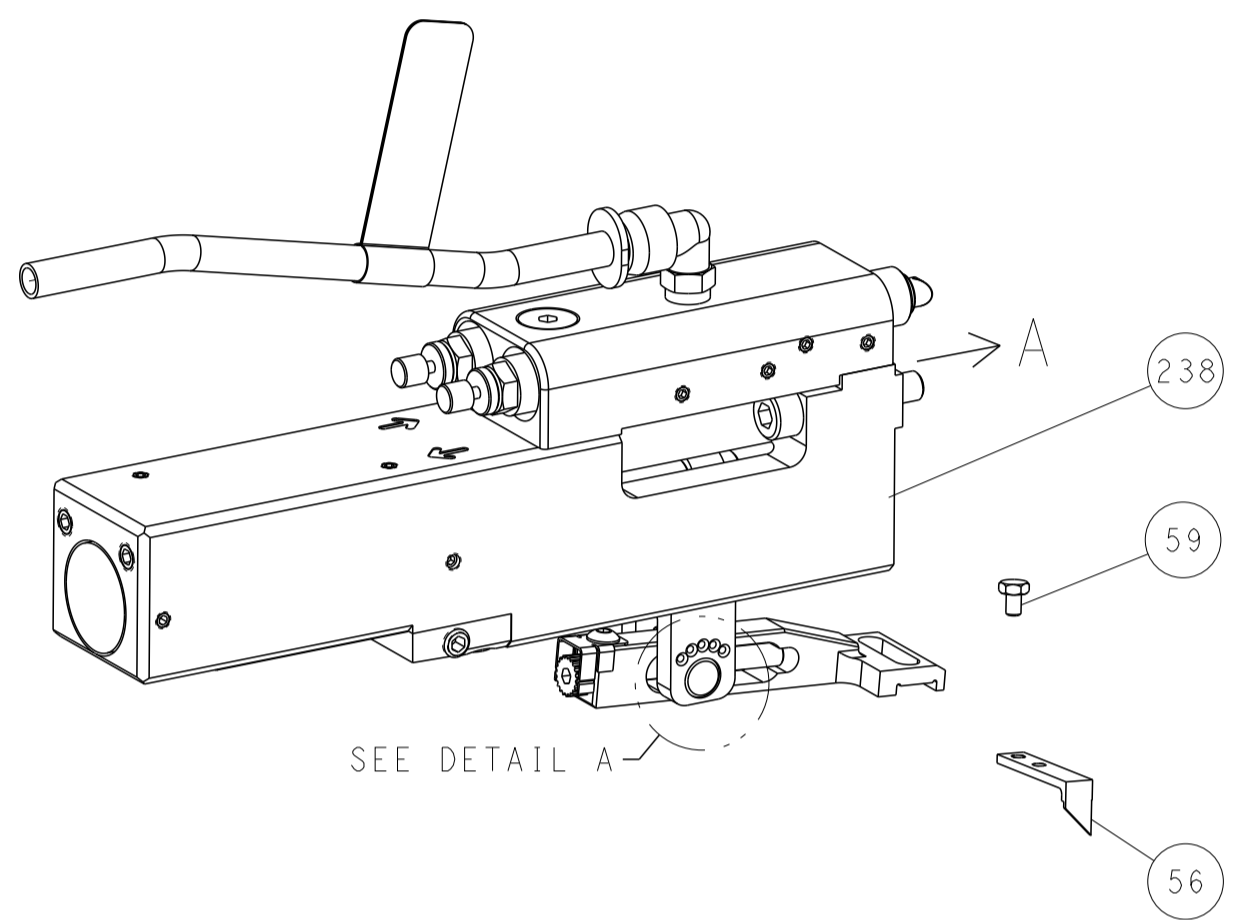
THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION	DATE: 23NOV2012	CHK: L. ZHANG	DATE: 23NOV2012
COPYRIGHT 20 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.	DATE: 23NOV2012	CHK: L. ZHANG	DATE: 23NOV2012
DIMENSIONS:	TOLERANCES UNLESS OTHERWISE SPECIFIED:	NAME	APVD: S. XI
mm	0 PLC ±	PRODUCT SPEC	APVD: S. XI
	1 PLC ±	APPLICATION SPEC	
	2 PLC ±		
	3 PLC ±		
	4 PLC ±		
	ANGLES ±		
MATERIAL:	FINISH:	WEIGHT:	
CUSTOMER ACCESSIBLE PRODUCTION DRAWING		SCALE: 1:2	SHEET 1 OF 4

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

FEED TYPE MECHANICAL



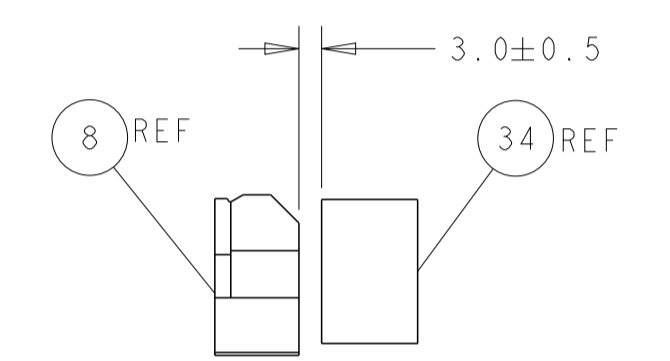
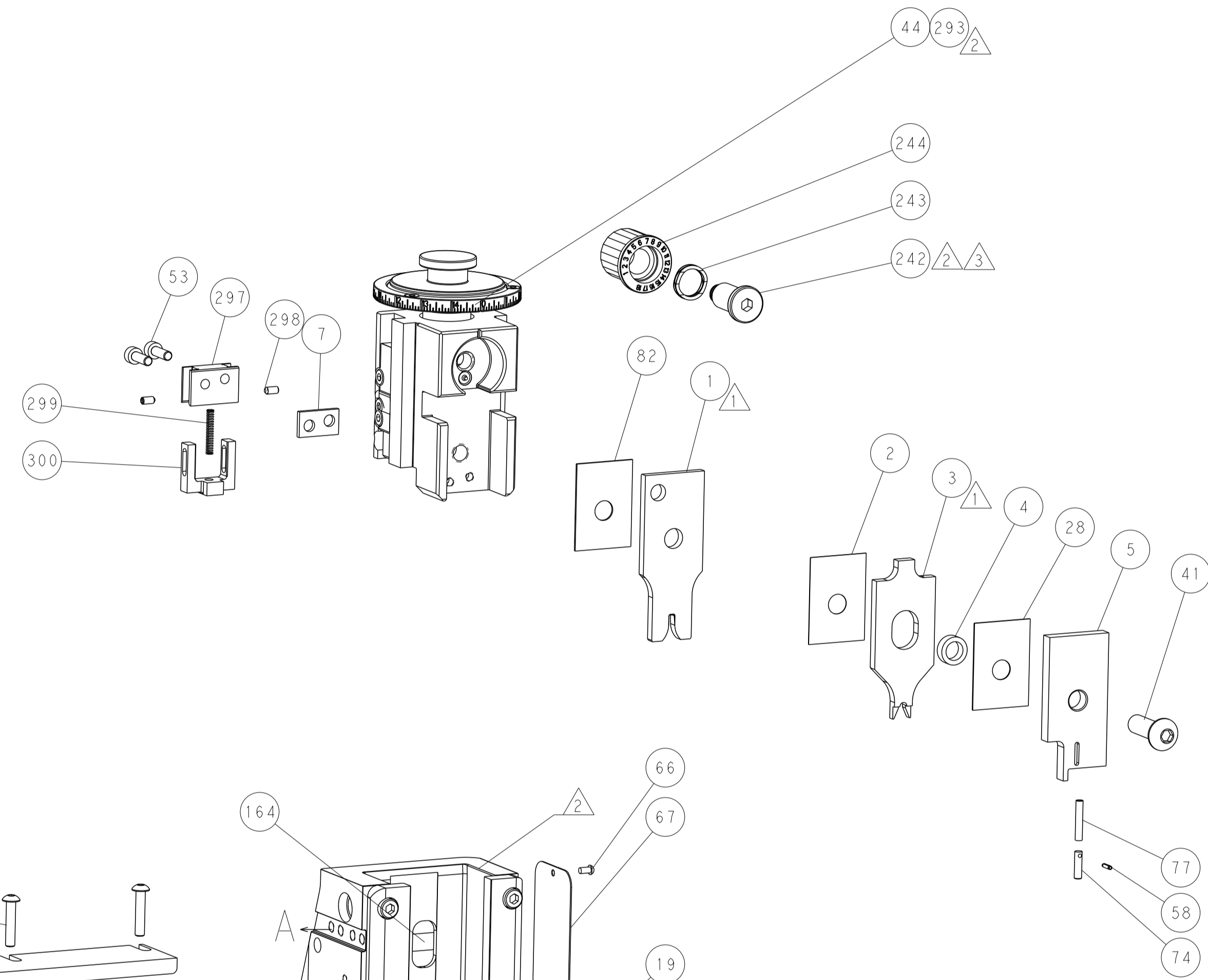
PNEUMATIC



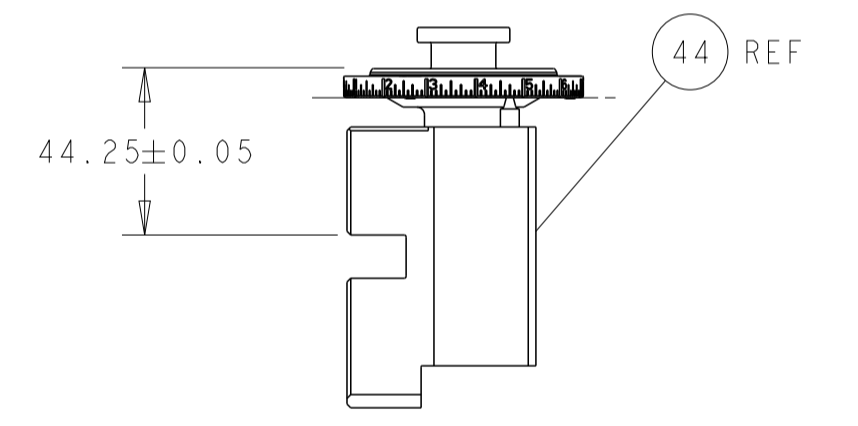
FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



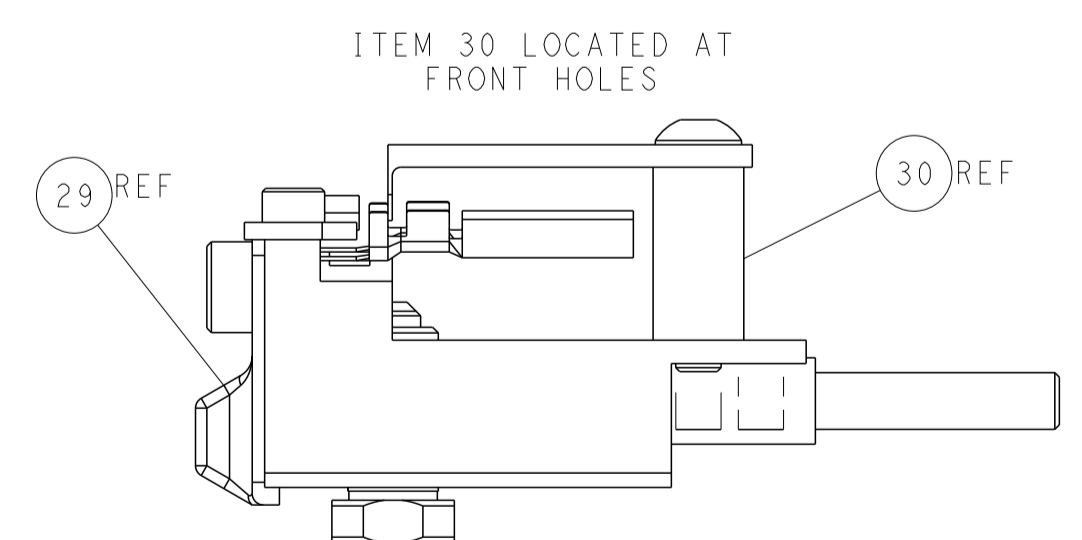
DETAIL A



TERMINAL SUPPORT LOCATION

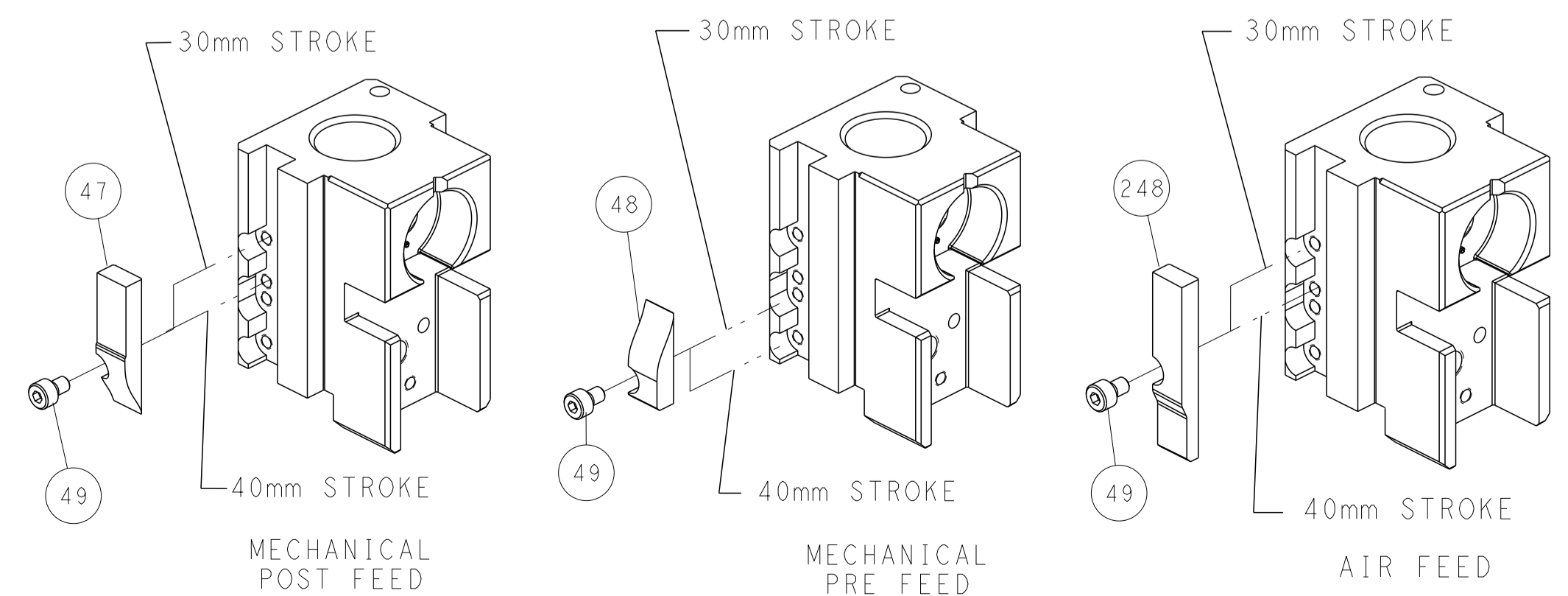


RAM SET-UP



FEED TRACK POSITION GUIDE BY INSULATION BARREL

CAM POSITIONS



DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH		DWN L. ZHANG 23NOV2012 CHK L. ZHANG 23NOV2012 APVD S. XI 23NOV2012 NAME Ocean Side Feed Applicator SIZE CAGE CODE DRAWING NO. RESTRICTED TO A1 00779 C=2151731 CUSTOMER ACCESSIBLE PRODUCTION DRAWING SCALE 1:2 SHEET 2 OF 4 REV H1	
MATERIAL: - FINISH: -		WEIGHT: -		TE Connectivity Harrisburg, PA 17105-3608	