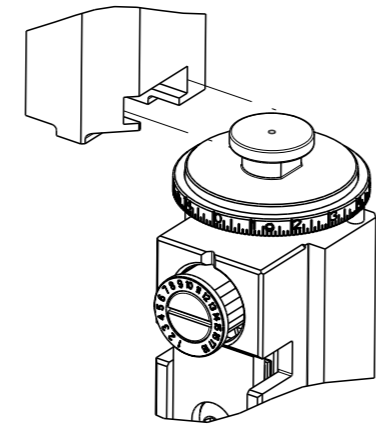


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151839-1	G	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2151839-2	H	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151839-1	G	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2151839-2	H	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2151839-7	F	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.07 mm [.042]	F
INSUL	-	-

APPLICATOR INSTRUCTIONS
408-35042

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: SOCKET CONTACT, PLUG			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
TERMINAL APPLICATION SPECIFICATION	114-13157	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
1438890-8	1438896-4	2203232-4	2365471-4
2365466-8	-	-	-

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.5 DS-OFB	0.86 +/- 0.05 [0.034 +/- .002]	8.5
RG-174 LL	0.79 +/- 0.05 [0.031 +/- .002]	9.5
RG-174 OR RG-316	0.74 +/- 0.05 [0.029 +/- .002]	9.9
DACAR 462	0.74 +/- 0.05 [0.029 +/- .002]	9.9

***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.

- RECOMMENDED SPARE PARTS**
- REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- 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 IS A CUT CARRIER ONLY.
- SEE TERMINAL APPLICATOR SPEC 114-13157 FOR WIRE STRIP LENGTHS.
- THIS TERMINAL CANNOT BE RUN ON AUTOMATED EQUIPMENT.
- TERMINAL LUBRICANT IS RECOMMENDED
- UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.

LOC	DIST	REVISIONS					
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		G		ECR-18-015366	26SEP2018	MS	CT
		H		ECR-19-010887	11JUL2019	MZ	YY
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		H2		ECR-20-012680	08SEP2020	JWC	GB

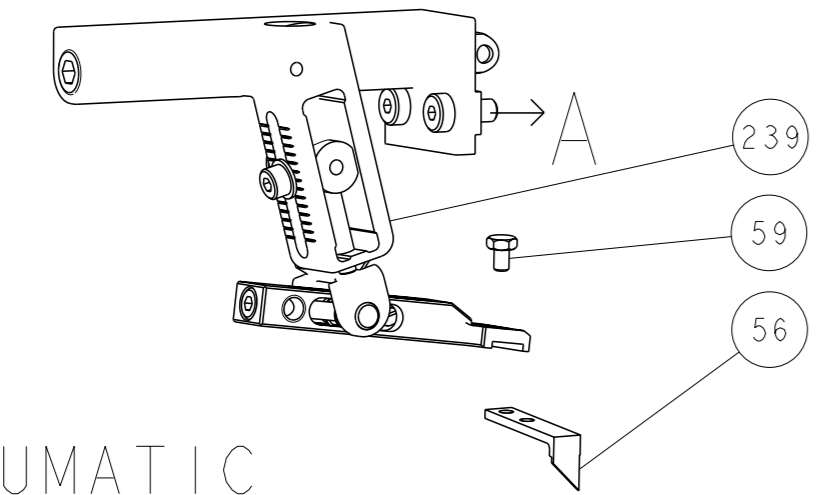
-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248
-	-	1	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	1	-	1	-	2844940-1	AIR FEED MODULE	238
-	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	1	1	1	1	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113
-	1	1	1	1	2844908-1	SCREW, LOCKING	99
-	1	1	1	1	2844907-1	POST, LOCKING	98
-	1	1	1	1	455888-5	SPACER, CRIMPER	82
-	1	1	1	1	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	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	53
-	1	1	1	1	5018030-1	NUT, HEX, REG, RoHS, M3	52
-	1	1	1	1	811242-5	BUMPER, HOLD DOWN	51
-	1	1	1	1	690753-2	SPACER, TONKER	50
-	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	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
-	1	1	1	1	1752356-1	SUPPORT, TERMINAL	34
-	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	2844992-1	ASSEMBLY, STRIP GUIDE	29
-	1	1	1	1	1-455888-0	SPACER, CRIMPER	28
-	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	3-22280-3	SPRING, COMPRESSION	12
-	1	1	1	1	356885-5	STOP, SHEAR	11
-	1	1	1	1	1803216-1	HOLDER, SHEAR	10
-	1	1	1	1	1338293-4	SHEAR, FLOATING	9
1	2	2	1	1	2-1633733-5	ANVIL, WIRE	8
-	-	-	-	-	-	-	7
-	-	-	-	-	-	-	6
-	1	1	1	1	1-2119757-6	DEPRESSOR, SHEAR	5
-	-	-	-	-	-	-	4
-	-	-	-	-	-	-	3
-	-	-	-	-	-	-	2
1	2	2	1	1	3-1633713-8	CRIMPER, WIRE PREMIUM	1

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

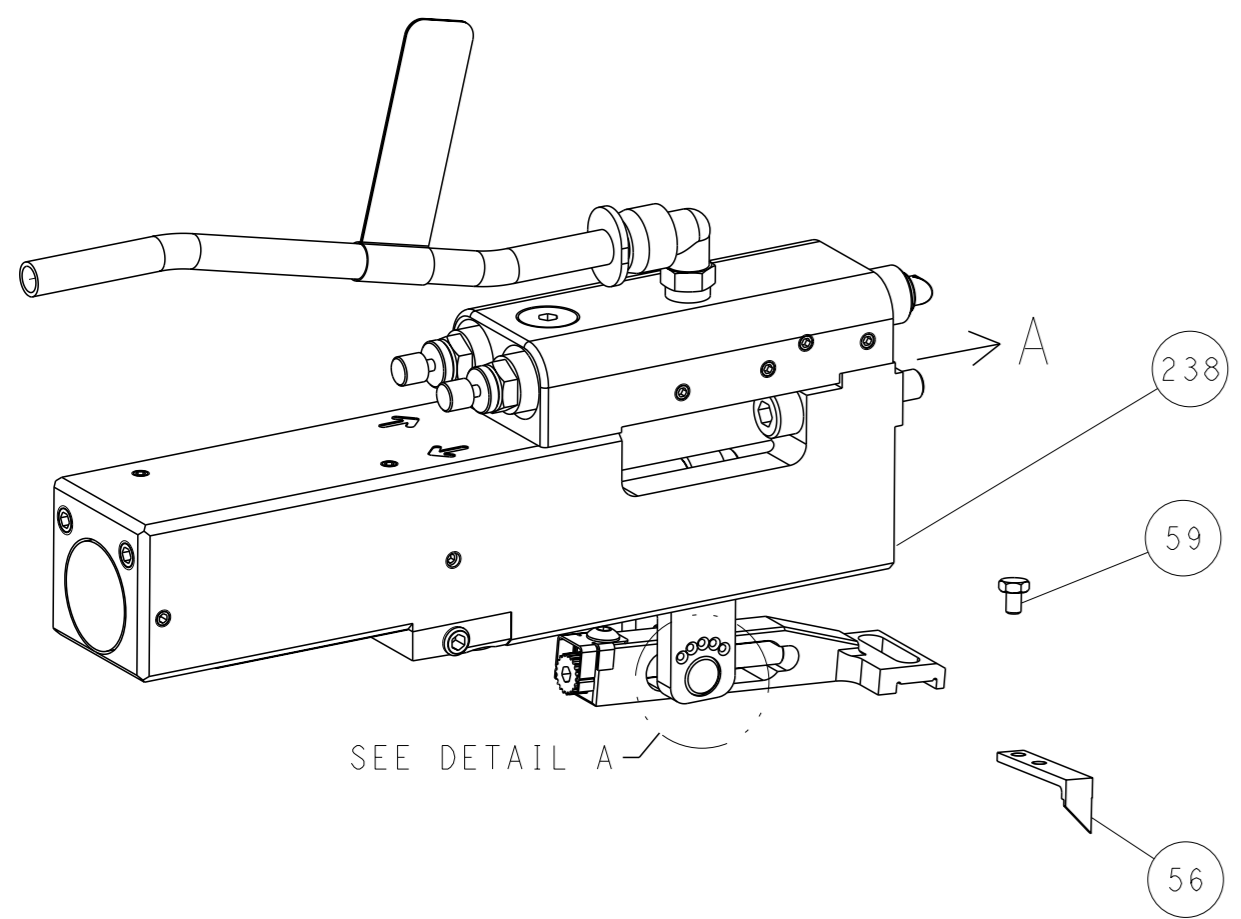
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mm	0 PLC	±		H. STAKEM	G. BAILEY	T. ELBIN	10DEC2012	Ocean Side Feed Applicator	A1	00779	2151839	-			
	1 PLC	±													
	2 PLC	±													
	3 PLC	±													
	4 PLC	±													
	ANGLES	±	*												
MATERIAL	FINISH														
Customer Accessible Production Drawing								SCALE	1:2	SHEET	1	OF	4	REV	H2

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

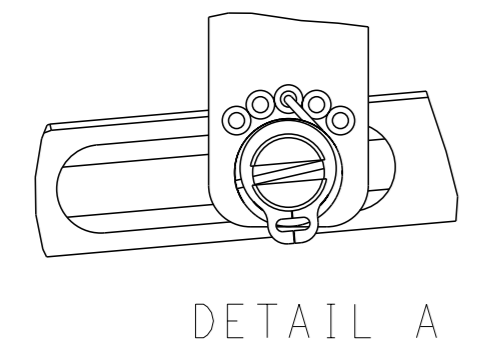
FEED TYPE MECHANICAL



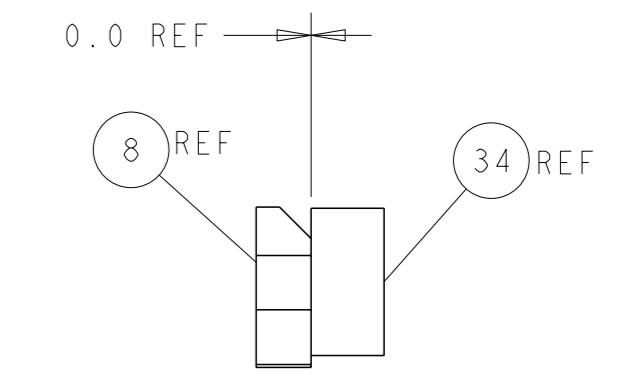
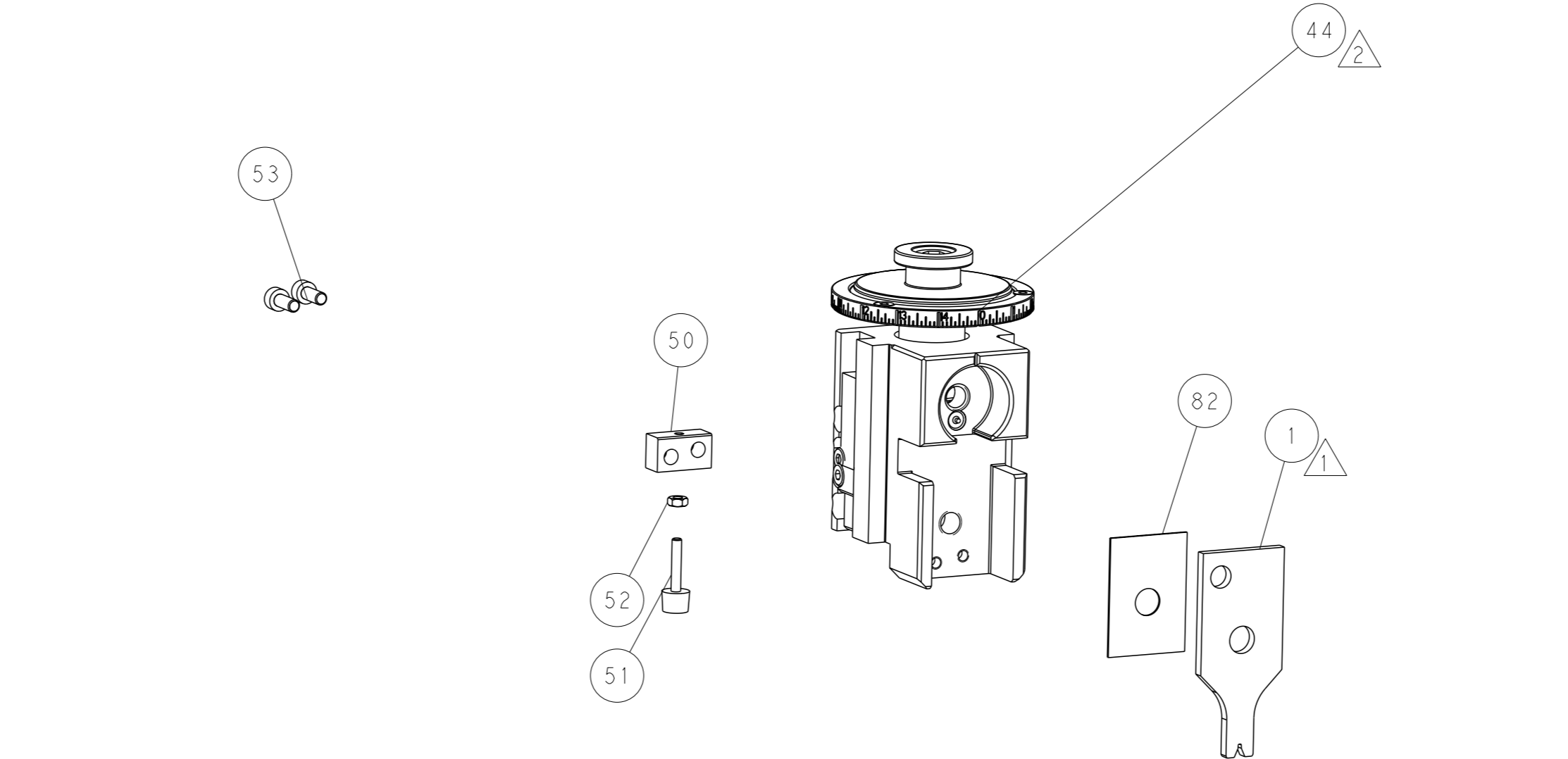
PNEUMATIC



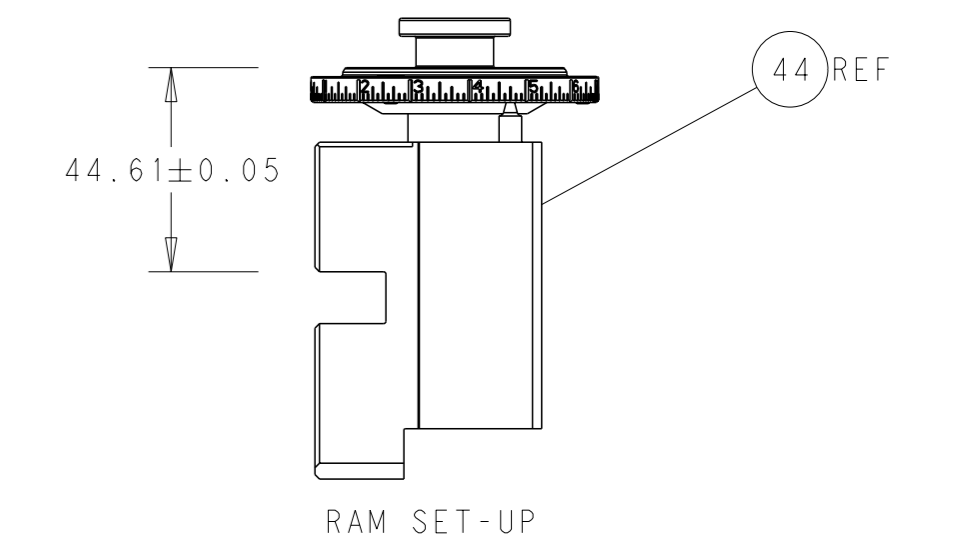
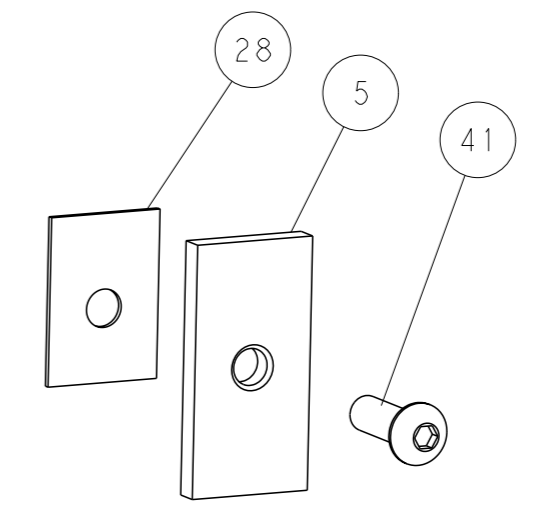
FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



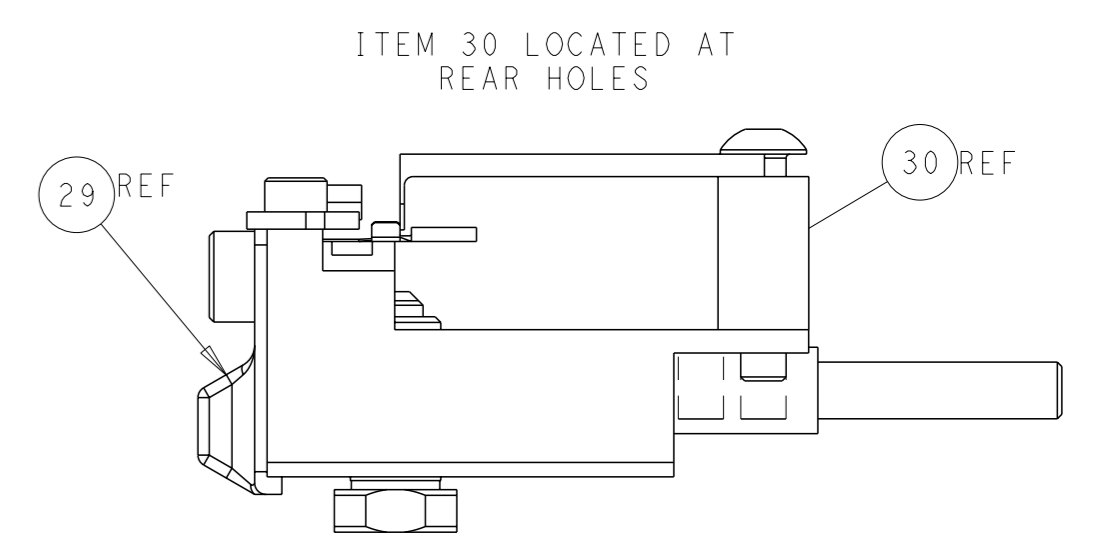
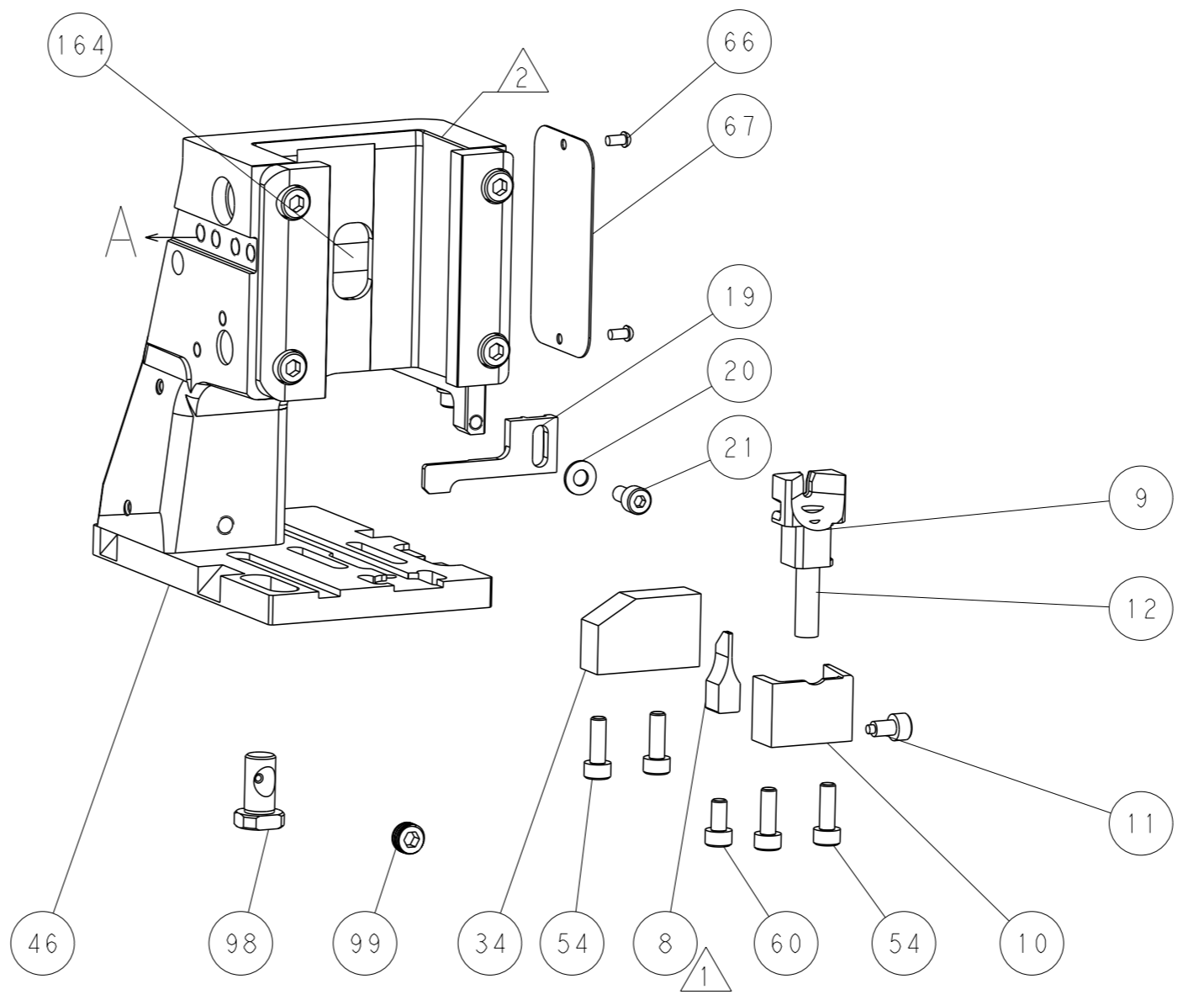
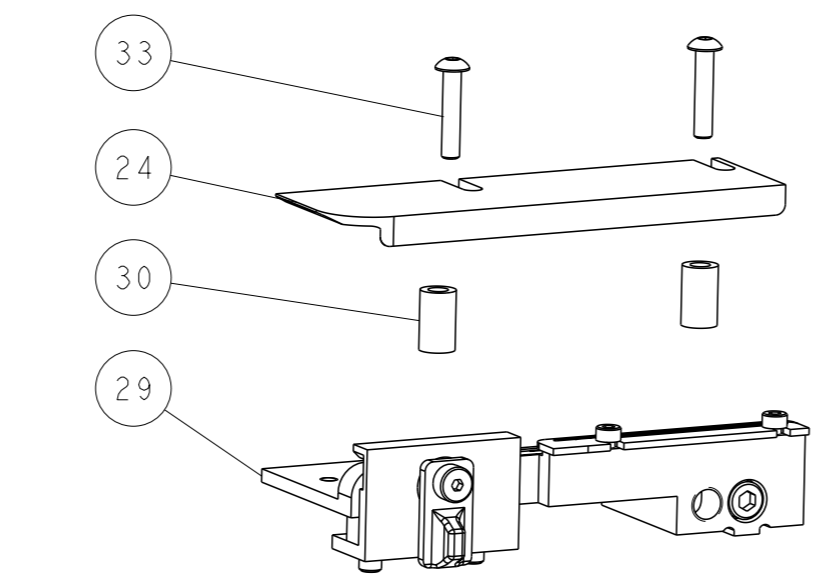
DETAIL A



TERMINAL SUPPORT LOCATION

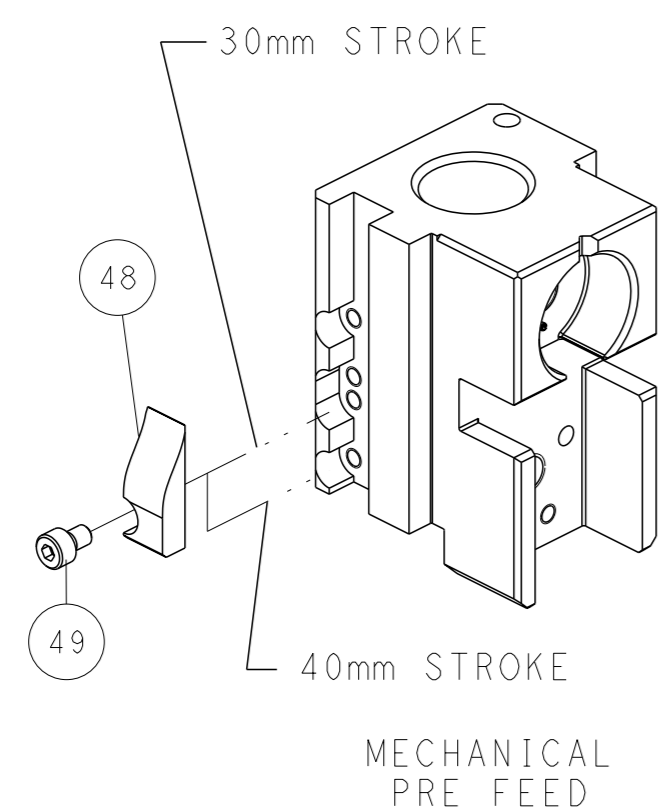


RAM SET-UP

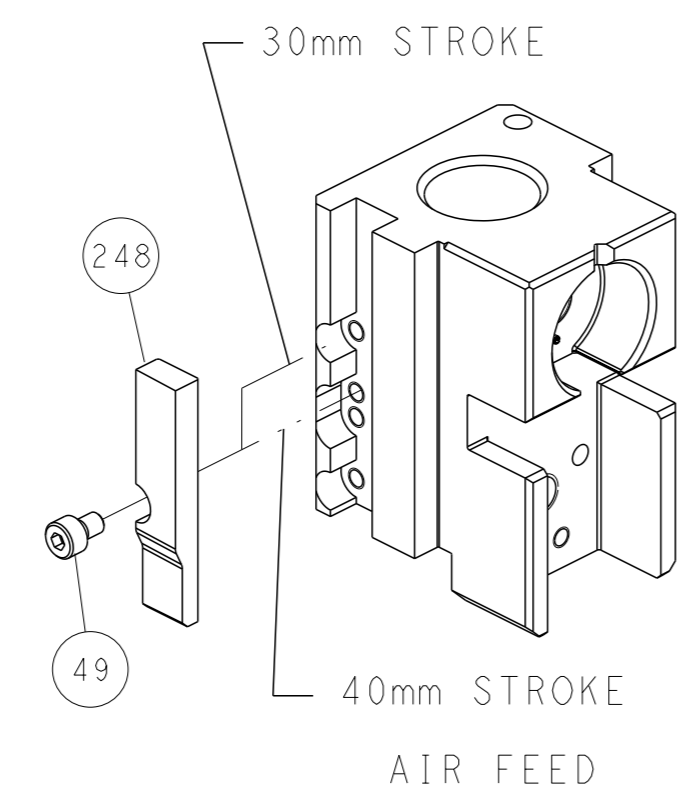


FEED TRACK POSITION GUIDE BY WIRE BARREL

CAM POSITIONS



MECHANICAL PRE FEED



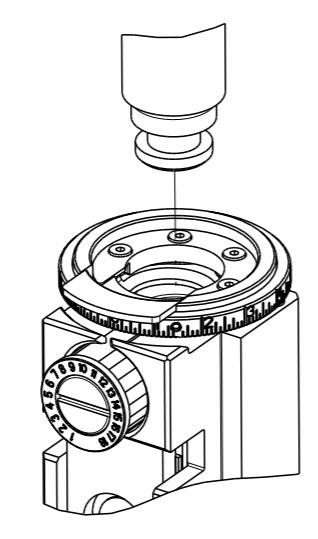
AIR FEED

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 CONTROL AND REVISIONS ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST REVISION.</small>		DWN: H. STAKEM 10DEC2012 CHK: G. BAILEY 10DEC2012 APVD: J. ELBIN 10DEC2012	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: A1 CAGE CODE: 00779 DRAWING NO: 2151839	RESTRICTED TO: - SCALE: 1:2 SHEET: 2 of 4 REV: H2
MATERIAL: - FINISH: -		WEIGHT: - Customer Accessible Production Drawing	SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2151839-1	G	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2151839-2	H	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151839-7	F	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.07 mm [.042]	F
INSUL	-	-

APPLICATOR INSTRUCTIONS
408-35042

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION			
TERMINAL NAME: SOCKET CONTACT, PLUG			
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE		
114-13157	-		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
1438890-8	1438896-4	2203232-4	2365471-4
2365466-8	-	-	-

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.5 DS-QFB	0.86+/-0.05 [.034+/-0.002]	8.5
RG-174 LL	0.79+/-0.05 [.031+/-0.002]	9.5
RG-174 OR RG-316	0.74+/-0.05 [.029+/-0.002]	9.9
DACAR 462	0.74+/-0.05 [.029+/-0.002]	9.9

- 1 RECOMMENDED SPARE PARTS
- 2 REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- 3 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.
- 4 THIS APPLICATOR IS A CUT CARRIER ONLY.
- 5 SEE TERMINAL APPLICATOR SPEC 114-13157 FOR WIRE STRIP LENGTHS.
- 6 THIS APPLICATOR CANNOT BE RUN ON AUTOMATED EQUIPMENT.
- 7 TERMINAL LUBRICANT IS RECOMMENDED
- 8. 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	REV	DATE	OWN	APVD
A	66	-	-	-	-

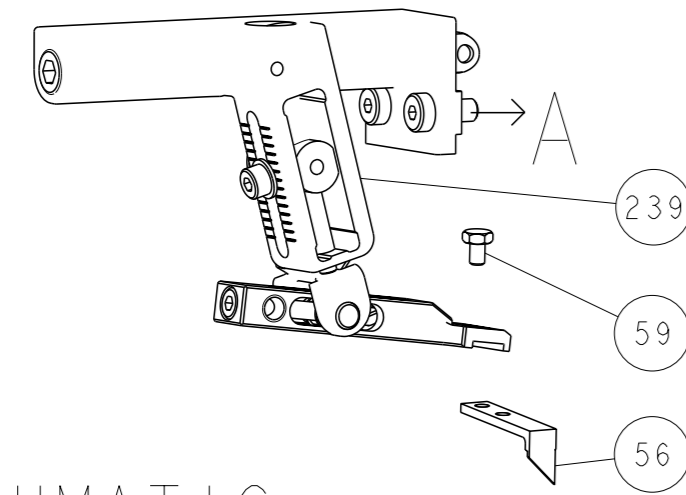
REV	DATE	DESCRIPTION	ITEM NO
-	-	1 2119580-1 MECHANICAL FEED ASSEMBLY	239
-	1	- 2844940-1 AIR FEED MODULE	238
-	REF	REF 994970-2 COUNTER, MAGNETIC	164
-	1	- 2119641-2 FEED CAM, AIR FEED	151
-	1	1 2168083-8 SCR, SKT HD CAP, RoHS, M4 X 16	144
-	4	4 2168083-9 SCR, SKT HD CAP, RoHS, M4 X 20	143
-	-	1 2119653-2 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 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 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 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 1752356-1 SUPPORT, TERMINAL	34
-	2	2 2079383-5 SCR, BHSC, RoHS (M4 X 20)	33
-	2	2 2-2844962-3 SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1 2844992-1 ASSEMBLY, STRIP GUIDE	29
-	1	1 1-455888-0 SPACER, CRIMPER	28
-	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 3-22280-3 SPRING, COMPRESSION	12
-	1	1 356885-5 STOP, SHEAR	11
-	1	1 1803216-1 HOLDER, SHEAR	10
-	1	1 1338293-4 SHEAR, FLOATING	9
-	1	1 1 2-1633733-5 ANVIL, WIRE	8
-	-	- - -	7
-	-	- - -	6
-	1	1 1-2119757-6 DEPRESSOR, SHEAR	5
-	-	- - -	4
-	-	- - -	3
-	-	- - -	2
-	1	1 1 3-1633713-8 CRIMPER, WIRE PREMIUM	1

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

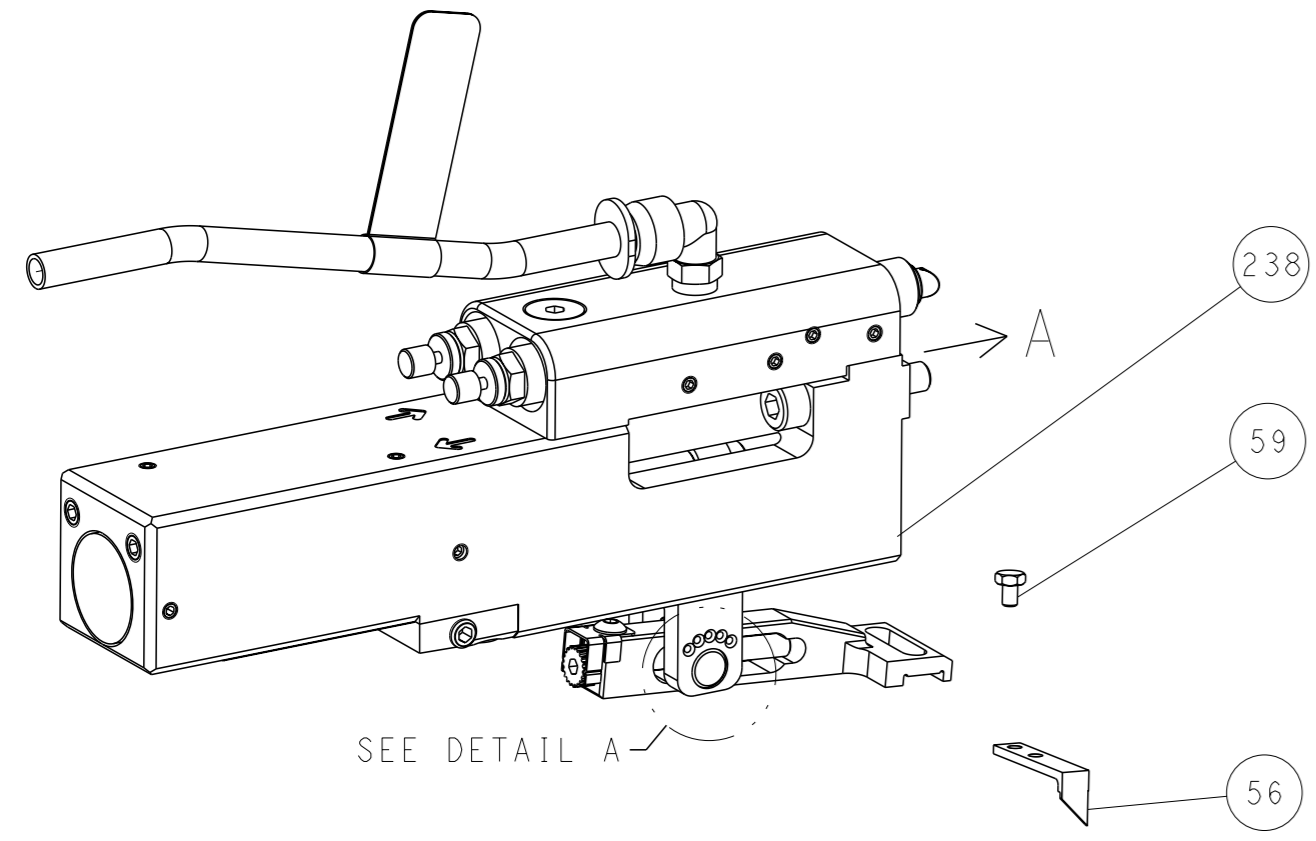
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MATERIAL: -		WEIGHT: -		SIZE: A1		CAGE CODE: 00779		DRAWING NO: ©=2151839	
Customer Accessible Production Drawing		SCALE: 1:2		SHEET: 3		OF: 4		REV: H2	

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

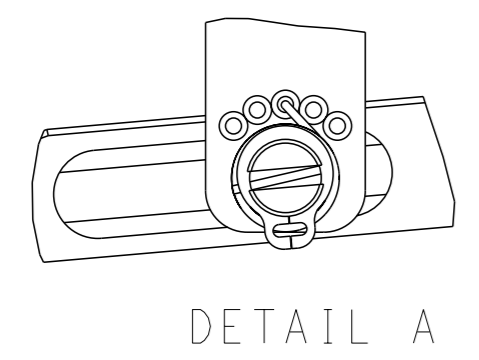
FEED TYPE MECHANICAL



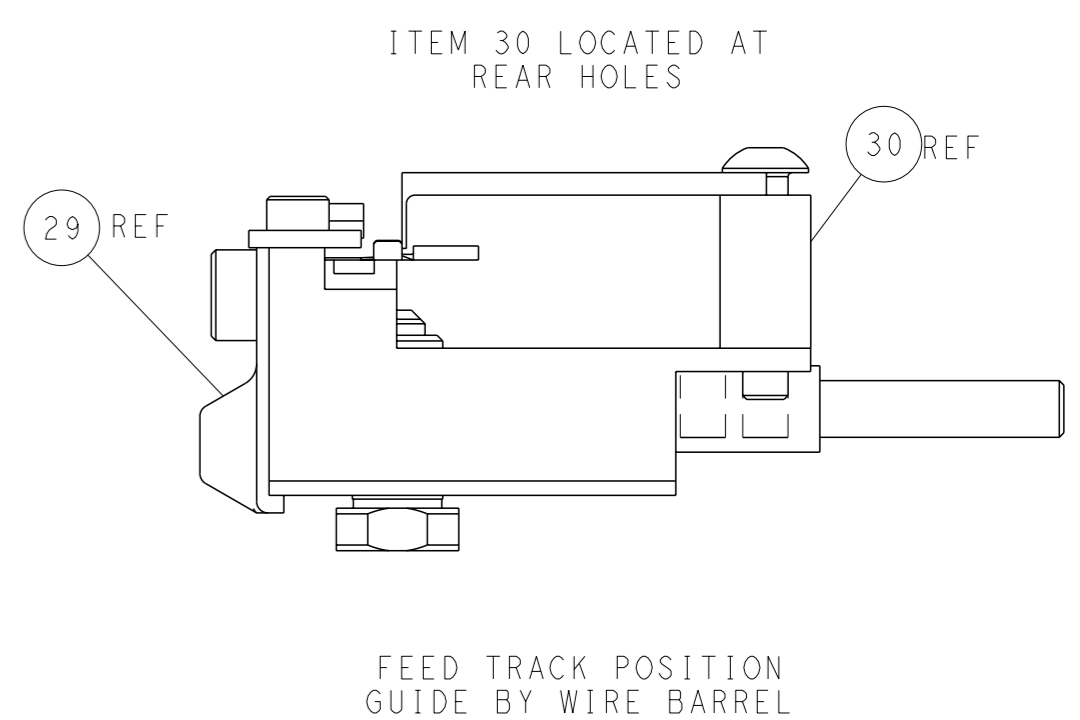
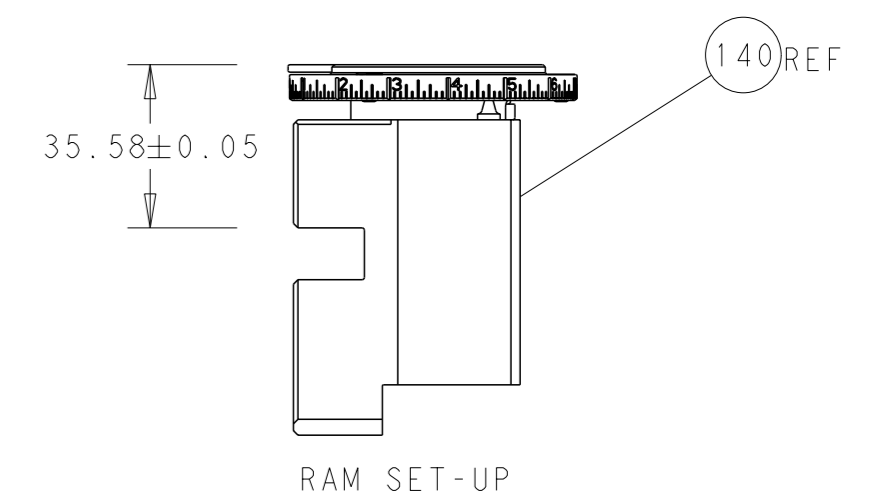
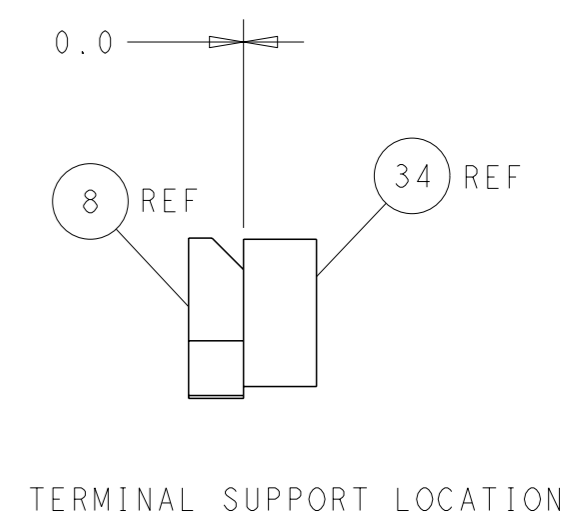
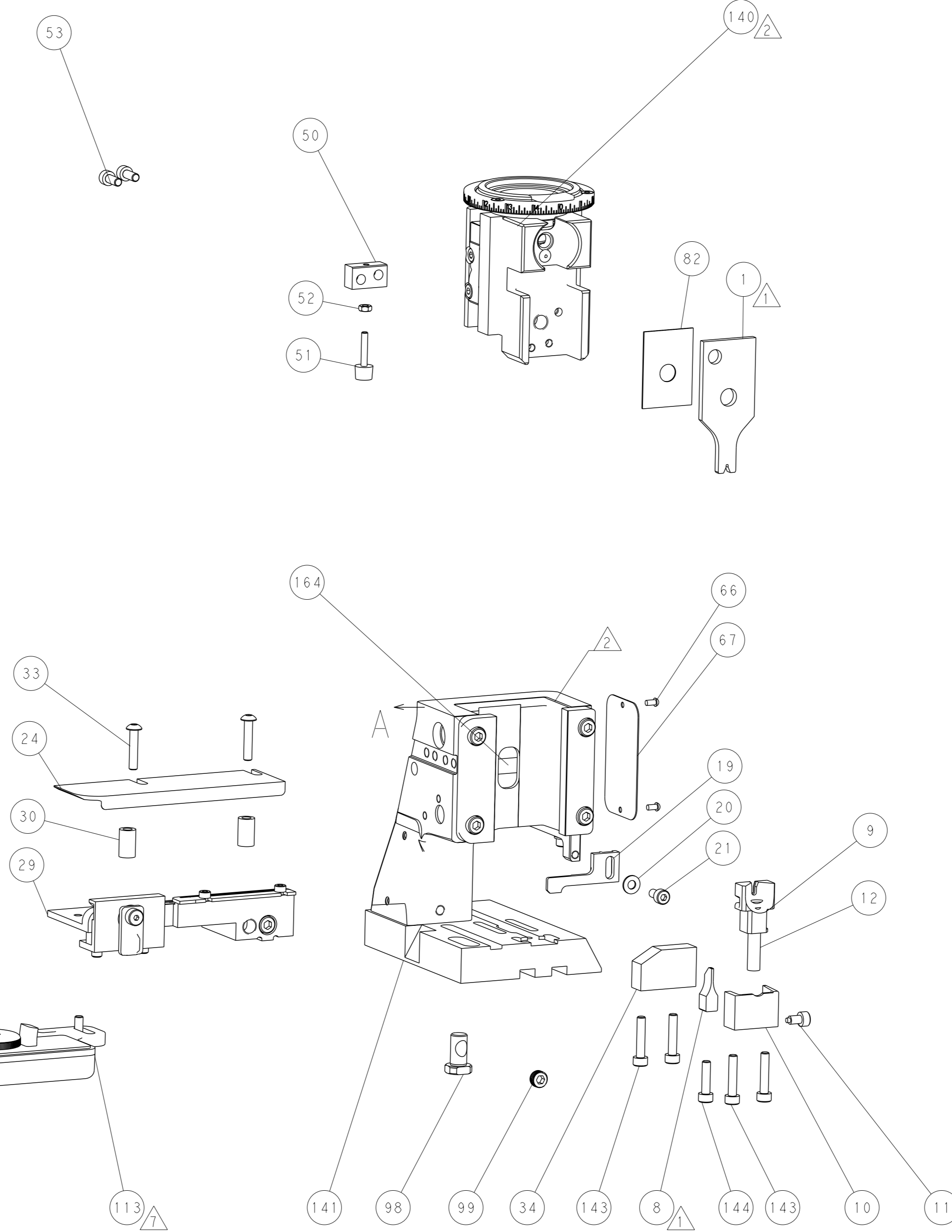
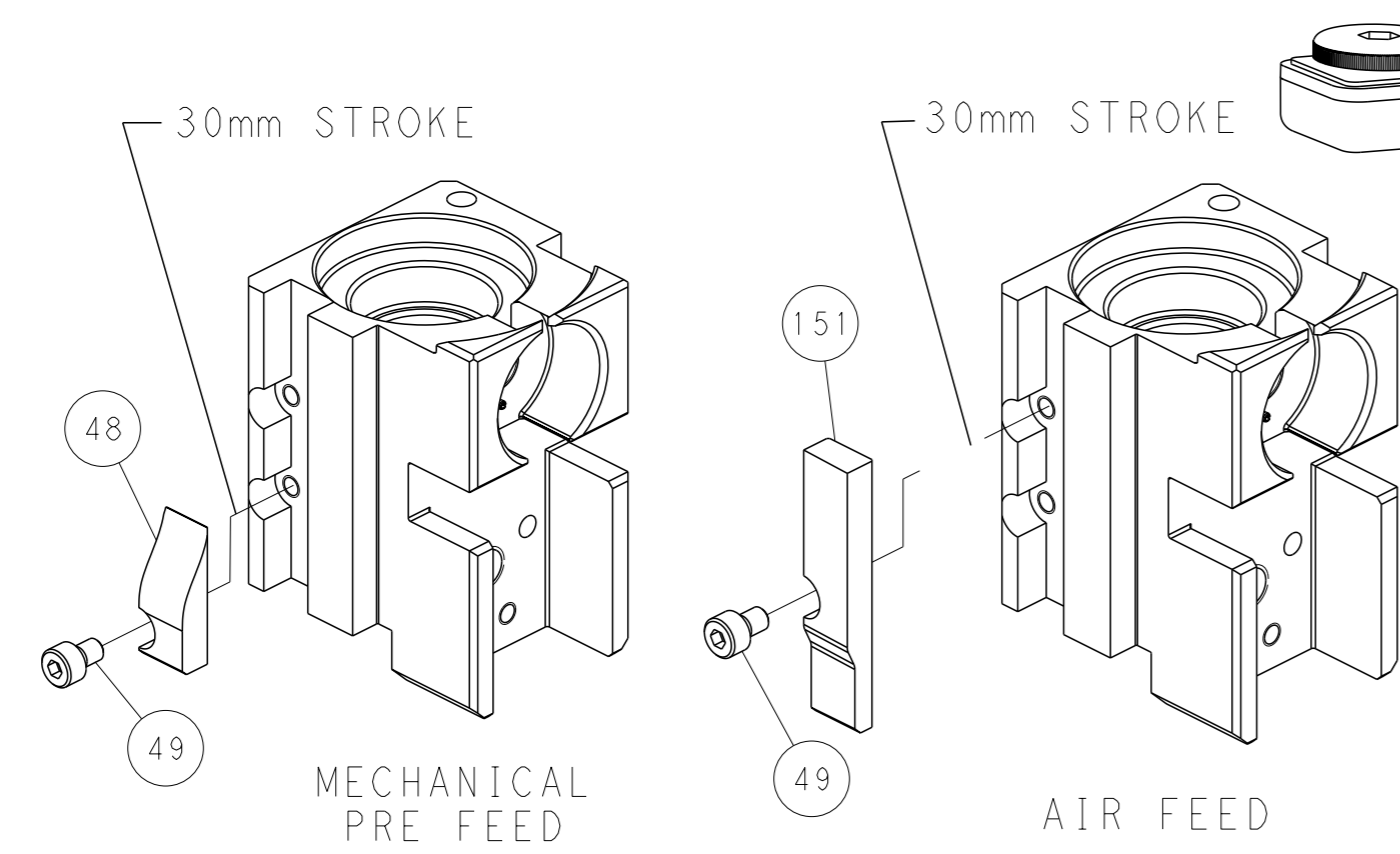
PNEUMATIC



FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



CAM POSITIONS



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

<small>THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE AND THE CONTROLLING ENGINEERING ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST REVISION.</small>		OWN: H. STAKEM CHK: G. BAILEY APVD: T. ELBIN	10DEC2012 10DEC2012 10DEC2012	NAME: Ocean Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2151839	RESTRICTED TO: - SCALE: 1:2 SHEET: 4 of 4 REV: H2
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH ±	WEIGHT: - MATERIAL: -	APPLICATION SPEC: - PRODUCT SPEC: -	CUSTOMER ACCESSIBLE PRODUCTION DRAWING	TE Connectivity Harrisburg, PA 17105-3608	SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

Mouser Electronics

Authorized Distributor

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[2151839-2](#)