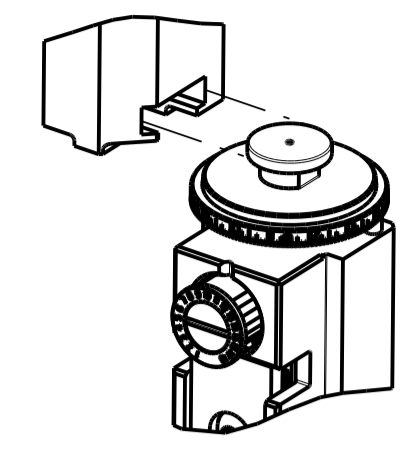


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151539-1	V	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2151539-2	V	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151539-1	V	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2151539-2	V	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2151539-7	L	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.78 mm [.070]	F
INSUL	1.73 mm [.068]	SP

APPLICATOR INSTRUCTIONS 408-35042

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: GET 0.64mm PIN AND SOCKET CONTACTS			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
4.40 mm [.173 IN]		Ø1.40-2.06 mm [.055-.081 IN]	
TERMINAL APPLICATION SPECIFICATION	114-13060		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
1393366-1	1393365-1	1438299-3	1438299-4
1393366-2	1393365-2	1438299-6	1-1438299-1
2-1393366-2			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
18 AWG	1.12 +/- 0.04 [.044 +/- .0016]	7.0
0.75mm2	1.10 +/- 0.04 [.043 +/- .0016]	7.1
0.50mm2	1.02 +/- 0.04 [.040 +/- .0016]	8.1
20 AWG	1.02 +/- 0.04 [.040 +/- .0016]	8.1

- 1 RECOMMENDED SPARE PARTS
  - 2 REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND 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 REAR STRIP GUIDE MUST BE ADJUSTED WHEN SWITCHING TERMINALS.
  - 6 USE ITEM 34, WHEN CRIMPING MALE TERMINALS.
  - 7 USE ITEM 261, WHEN CRIMPING FEMALE TERMINALS.
  - 8 TERMINAL LUBRICANT IS RECOMMENDED.
9. 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)

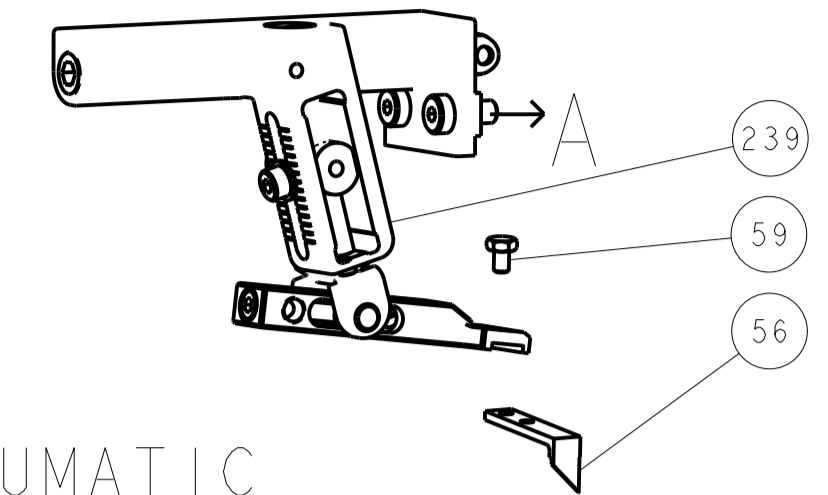
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		T1	ECR-20-000962	20JAN2020	MZ YY
		U	ECR-20-010690	28JUL2020	TB RK
		V	ECR-21-005185	08MAY2021	MZ YY
		V1	ECR-21-006079	07JUN2021	LJ YY

1	-	1	1	1	1	1-1752356-8	SUPPORT, TERMINAL	261
1	-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248
1	-	1	1	1	1	2119082-7	CAM, SNAIL, INSULATION ADJUSTMENT	244
1	-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
3	-	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
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	REF	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
1	-	1	1	1	1	1-22281-8	SPRING, COMPRESSION	121
8	-	1	1	1	1	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113
1	-	1	1	1	1	2844908-1	SCREW, LOCKING	99
1	-	1	1	1	1	2844907-1	POST, LOCKING	98
1	-	1	1	1	1	2-690438-2	FRONT STRIP GUIDE	96
2	-	2	2	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	95
1	-	1	1	1	1	2168083-6	SCR, SKT HD CAP, RoHS, M5 X 65	93
1	-	1	1	1	1	455888-8	SPACER, CRIMPER	82
1	-	1	1	1	1	1803607-3	DOCUMENTATION PACKAGE	71
1	-	1	1	1	1	2119791-5	DEPRESSOR, WIRE	70
1	-	1	1	1	1	2119740-1	TAG IDENTIFICATION	67
2	-	2	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
2	-	2	2	2	2	2-18032-5	SCR, SET, FLT PNT, M5 X 20.0	61
1	-	1	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	60
1	-	1	1	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
1	-	1	1	1	1	1338685-1	PAWL, FEED	56
4	-	4	4	4	4	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	54
2	-	2	2	2	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	53
1	-	1	1	1	1	1803382-6	HOLD DOWN, SPRING LOADED	50
1	-	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	1	1803583-9	APPLICATOR BASIC ASSEMBLY, SF	46
1	-	1	1	1	1	1803515-1	RAM ASSEMBLY, SF ATLANTIC	44
1	-	1	1	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
1	-	1	1	1	1	1752356-6	SUPPORT, TERMINAL	34
2	-	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
2	-	2	2	2	2	2-2844962-4	SPACER, CYLINDRICAL, STRIP GUIDE	30
1	-	1	1	1	1	2844938-5	PLATE, STRIP GUIDE	29
2	-	2	2	2	2	22281-8	SPRING, COMPRESSION	27
1	-	1	1	1	1	356835-1	LEVER, DRAG RELEASE	26
1	-	1	1	1	1	217233-1	DRAG, STOCK	25
1	-	1	1	1	1	1320928-6	STRIP GUIDE	24
1	-	1	1	1	1	980371-4	SCR, SKT HD SHLDR 5.0 DIA X 6.0	23
1	-	1	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
2	-	2	2	2	2	1-18028-2	WASHER, FLAT, REG M4	20
1	-	1	1	1	1	2119533-1	STRIPPER, SIDE FEED	19
1	-	1	1	1	1	2119806-1	INSERT, SHEAR	13
1	-	1	1	1	1	3-22280-3	SPRING, COMPRESSION	12
1	-	1	1	1	1	1-356885-4	STOP, SHEAR	11
1	-	1	1	1	1	2119805-1	SHEAR HOLDER, FRONT	10
1	-	1	1	1	1	318707-1	FLOATING SHEAR, FRONT	9
1	1	2	2	1	1	1333231-1	ANVIL, COMBINATION, SPECIAL	8
-	-	-	-	-	-	-	-	7
-	-	-	-	-	-	-	-	6
1	-	1	1	1	1	2119757-8	DEPRESSOR, SHEAR	5
1	-	1	1	1	1	3-238011-5	BLOCK, CRIMPER SPACER	4
1	1	2	2	1	1	2-1633989-1	CRIMPER, INSULATION, SPECIAL	3
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1	1	2	2	1	1	5-562108-2	CRIMPER, WIRE, F	1

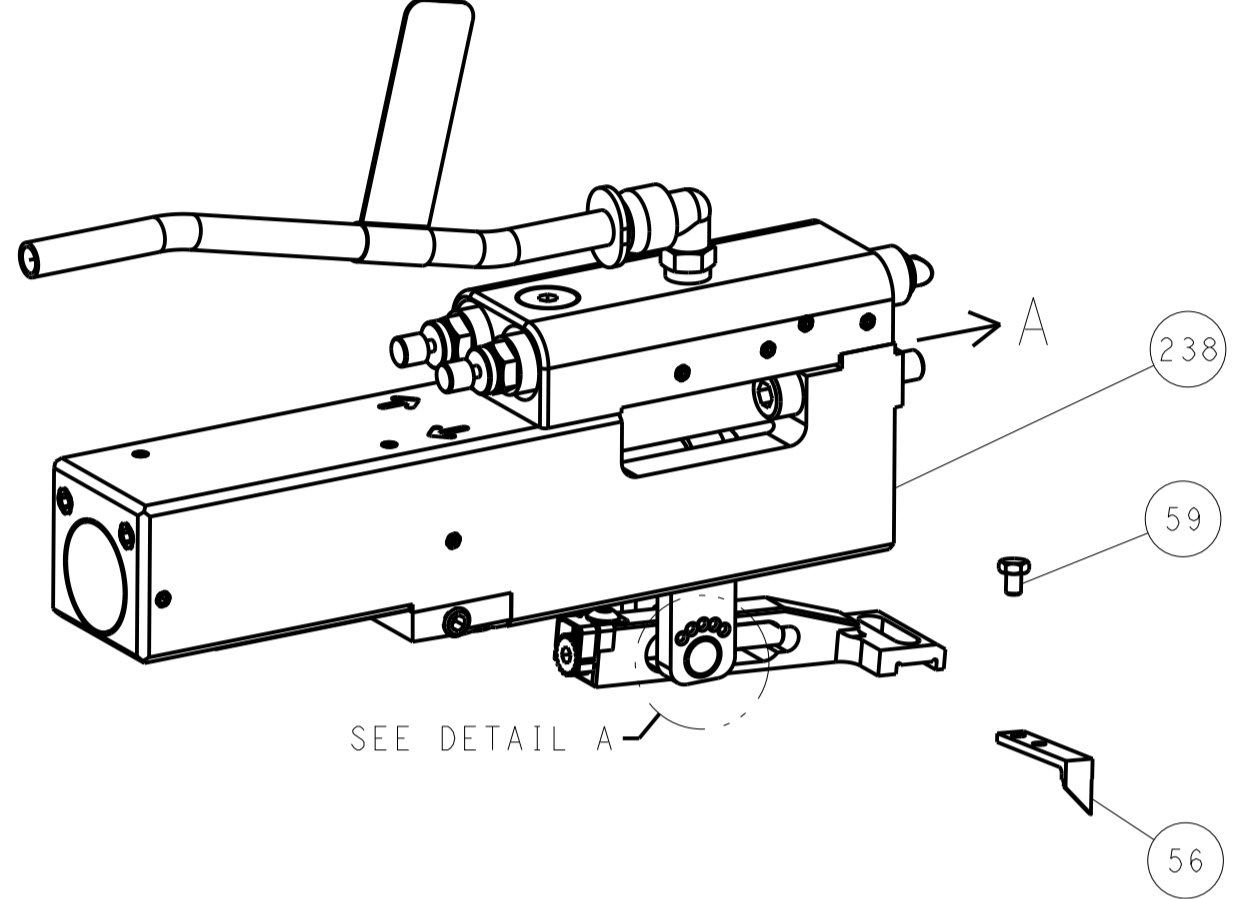
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		MATERIAL:		FINISH:		WEIGHT:		SCALE:	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES	FINISH	Customer Accessible Production Drawing	SCALE	1:2	SHEET 1 OF 4

LOC	DIST	REVISIONS			
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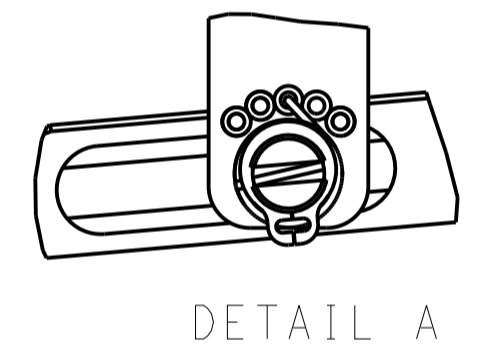
# FEED TYPE MECHANICAL



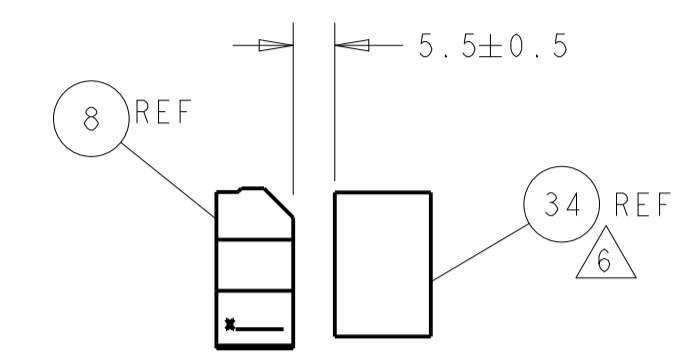
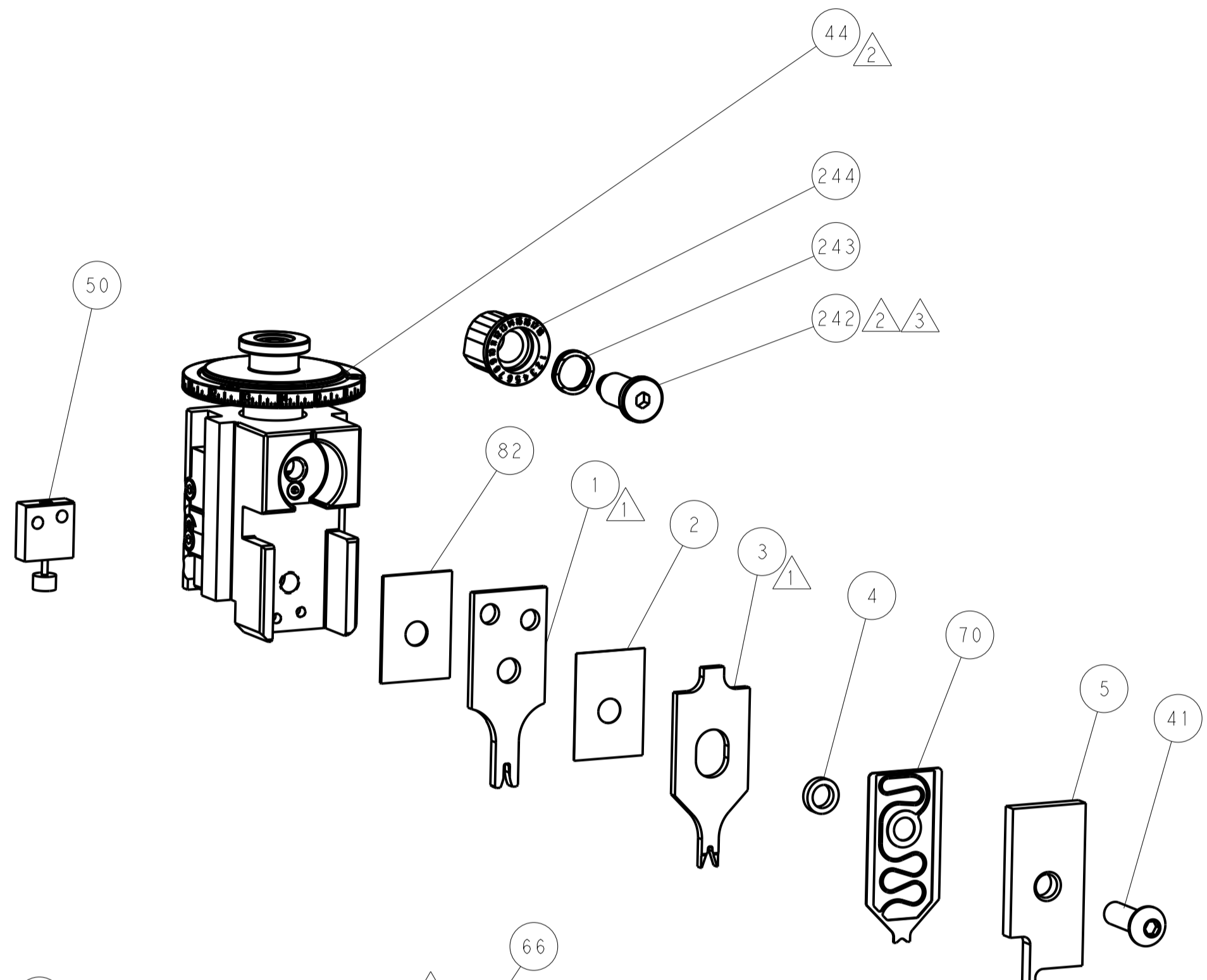
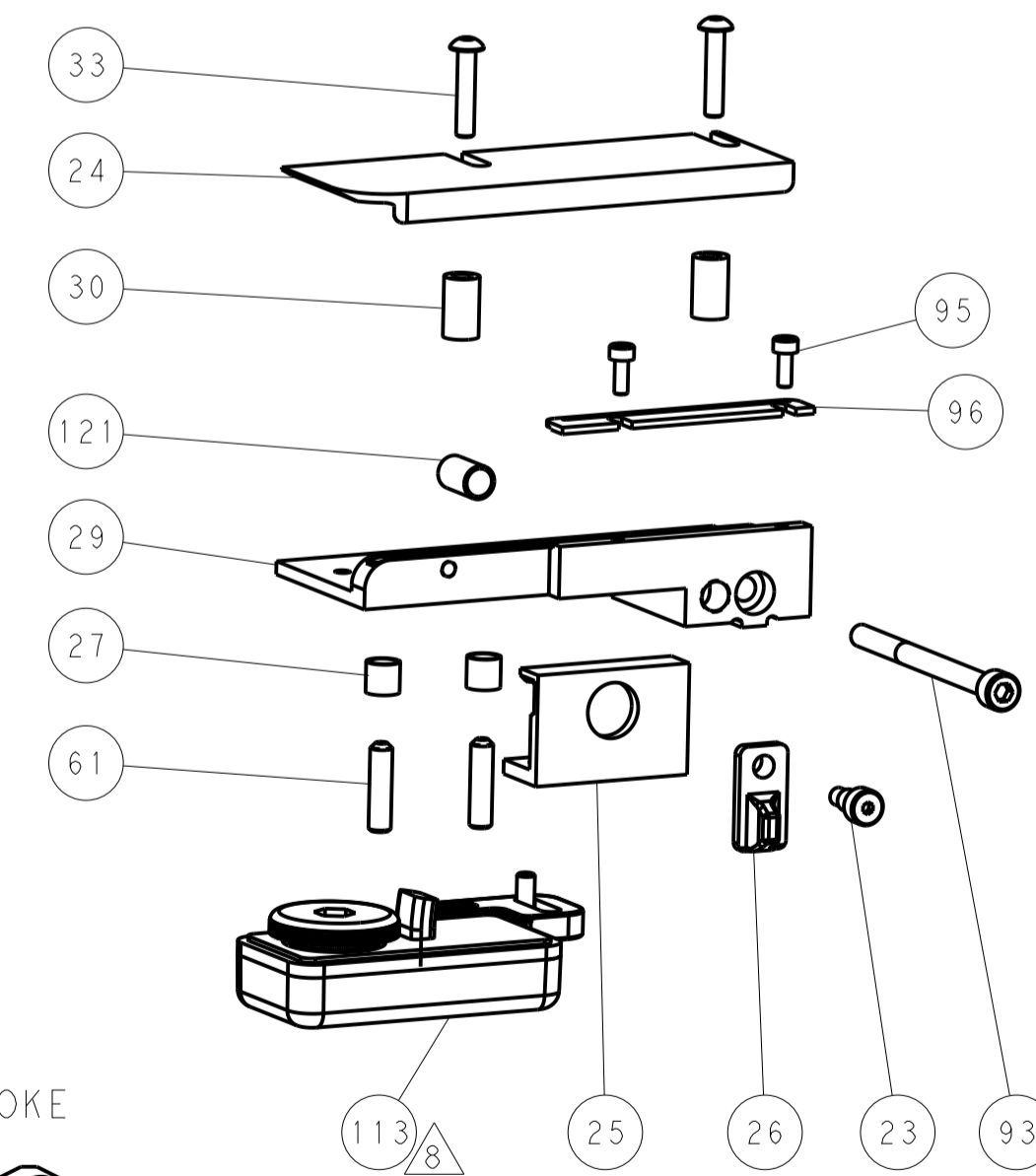
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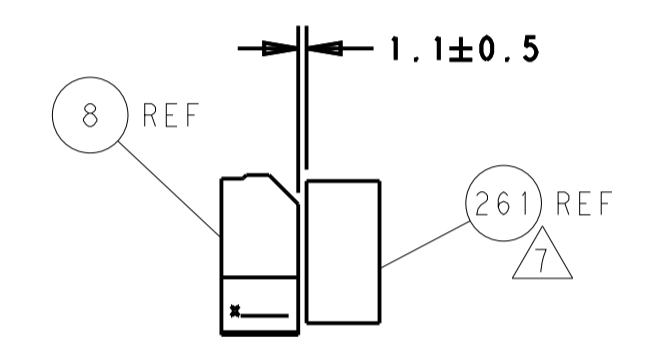
### FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



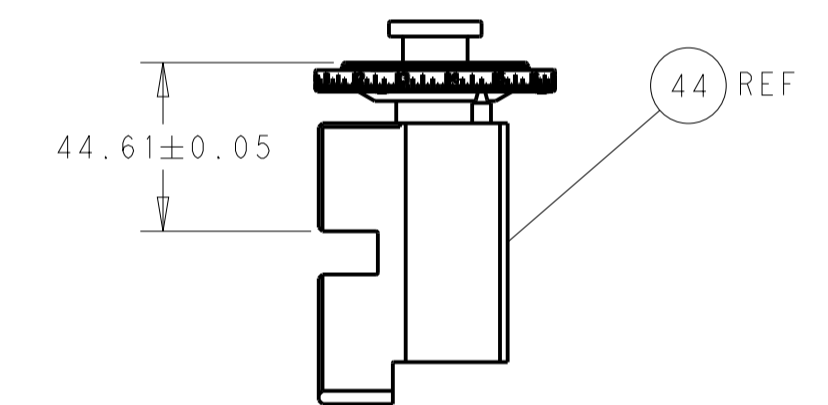
DETAIL A



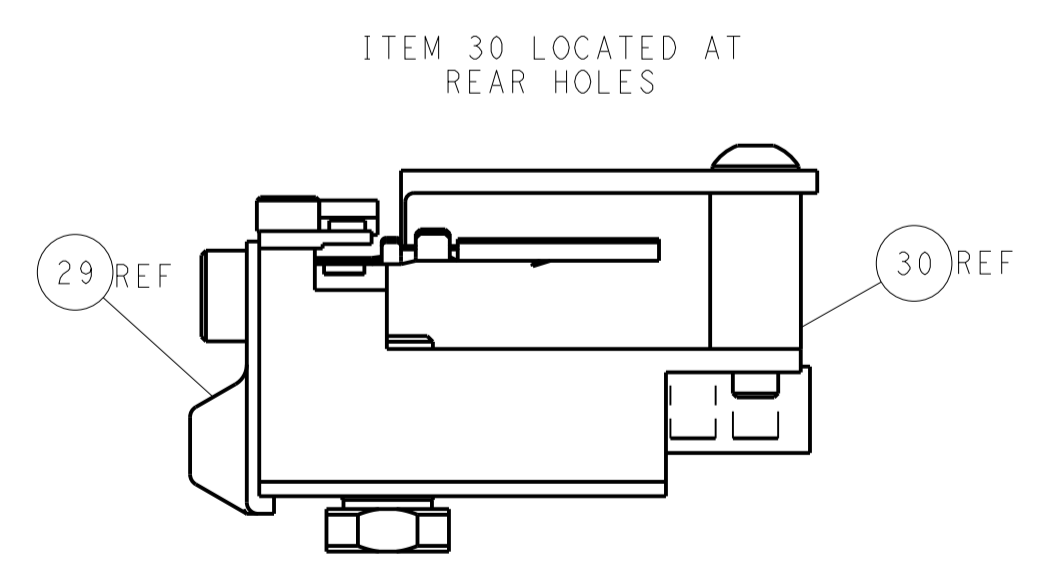
TERMINAL SUPPORT LOCATION FOR MALE TERMINAL



TERMINAL SUPPORT LOCATION FOR FEMALE TERMINAL

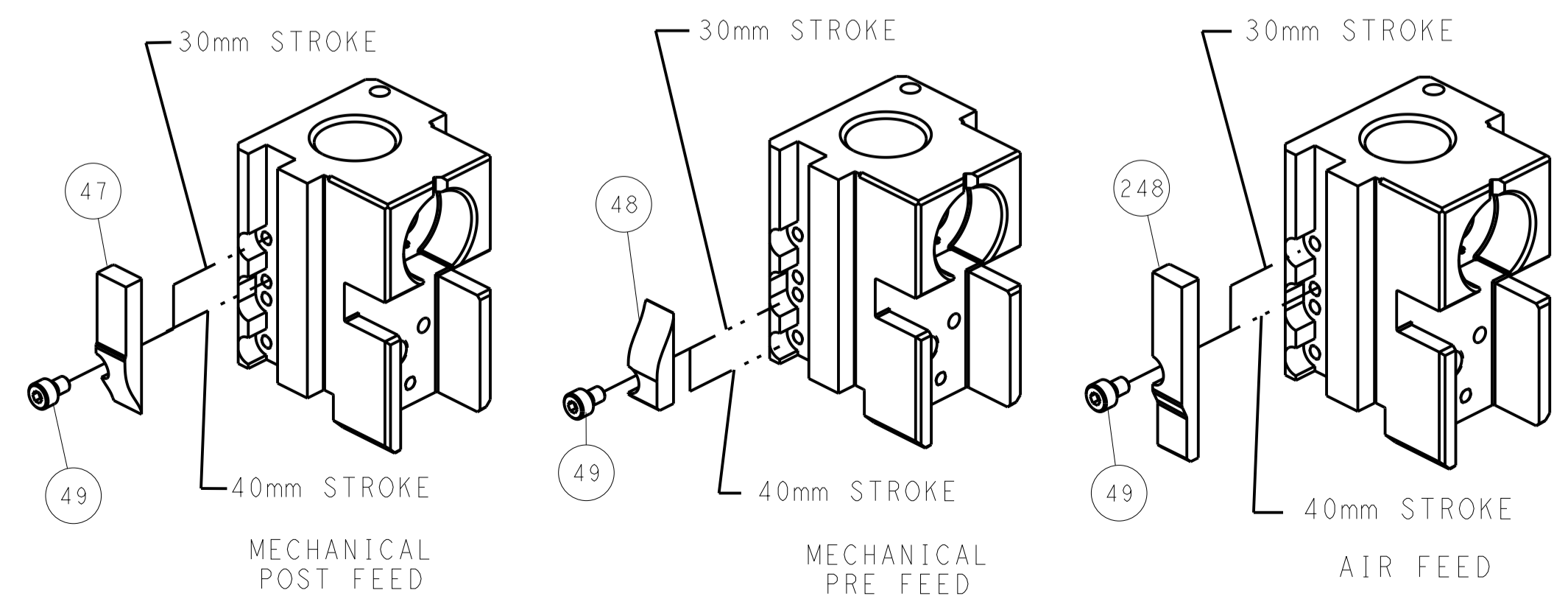


RAM SET-UP



ITEM 30 LOCATED AT REAR HOLES

# CAM POSITIONS

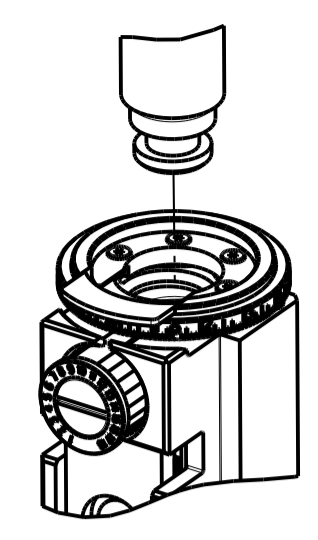


**ATLANTIC VERSION**  
 Shown on sheets 1 of 4 & 2 of 4  
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		DWN C. MOYER Z0DEC2012 CHK T. ELBIN Z0DEC2012 APVD T. ELBIN Z0DEC2012 NAME Ocean Side Feed Applicator SIZE CAGE CODE DRAWING NO. RESTRICTED TO A11 00779 ©=2151539 Customer Accessible Production Drawing SCALE 1:2 SHEET 2 OF 4 REV 1	
MATERIAL:		FINISH:		WEIGHT:	

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2151539-1	V	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2151539-2	V	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151539-7	L	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR  
 INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.78 mm [.070]	F
INSUL	1.73 mm [.068]	SP
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: GET 0.64mm PIN AND SOCKET CONTACTS			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
4.40 mm [.173 IN]		Ø1.40-2.06 mm [.055-.081 IN]	
TERMINAL APPLICATION SPECIFICATION	114-13060		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
1393366-1	1393365-1	1438299-3	1438299-4
1393366-2	1393365-2	1438299-6	1-1438299-1
2-1393366-2			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
18 AWG	1.12 +/- 0.04 [.044 +/- .0016]	7.0
0.75mm <sup>2</sup>	1.10 +/- 0.04 [.043 +/- .0016]	7.1
0.50mm <sup>2</sup>	1.02 +/- 0.04 [.040 +/- .0016]	8.1
20 AWG	1.02 +/- 0.04 [.040 +/- .0016]	8.1

- 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.
  - REAR STRIP GUIDE MUST BE ADJUSTED WHEN SWITCHING TERMINALS.
  - USE ITEM 34, WHEN CRIMPING MALE TERMINALS.
  - USE ITEM 261, WHEN CRIMPING FEMALE TERMINALS.
  - TERMINAL LUBRICANT IS RECOMMENDED.
9. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.

ENTRY LEVEL APPLICATOR		ITEM SUBSTITUTION LIST		
PART NUMBER	SAME AS	ITEM	ITEM DESCRIPTION	SUBSTITUTE PART NUMBER
8-2151539-1	2151539-1	1	WIRE CRIMPER	5-1803529-2
8-2151539-2	2151539-2	3	INSULATION CRIMPER	2-1803623-1
9-2151539-1	2-2151539-1	46	BASIC SUB -ASSEMBLY	1803940-9
9-2151539-2	2-2151539-2	141	BASIC SUB -ASSEMBLY	1-1803940-0
			LUBRICATOR	DELETE

**\*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)

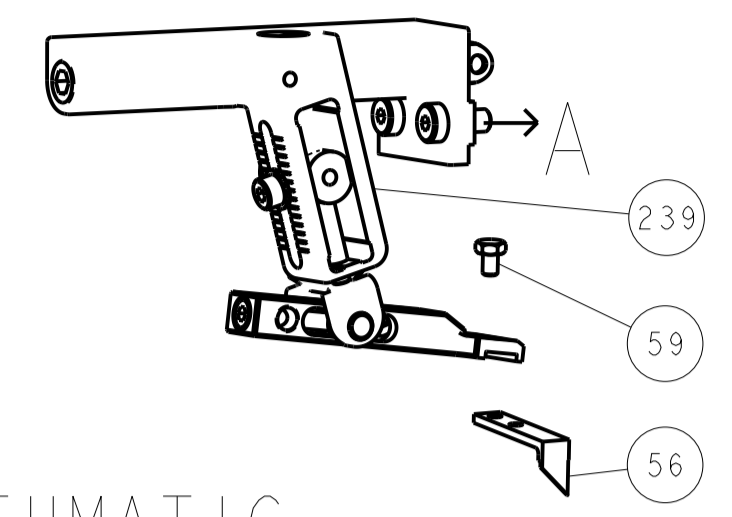
LOC	DIST	REV	DATE	BY	APPV
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REVISIONS						
REV	DATE	BY	APPV	DESCRIPTION	ITEM NO	
-	-	-	-	SEE SHEET 1	-	
△	-	1	1	1-1752356-8	SUPPORT, TERMINAL	261
-	-	1	1	2119082-7	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	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	1-22281-8	SPRING, COMPRESSION	121
△	-	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	2-690438-2	FRONT STRIP GUIDE	96
-	-	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	95
-	-	1	1	2168083-6	SCR, SKT HD CAP, RoHS, M5 X 65	93
-	-	1	1	455888-8	SPACER, CRIMPER	82
-	-	1	1	1803607-3	DOCUMENTATION PACKAGE	71
-	-	1	1	2119791-5	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	1803382-6	HOLD DOWN, SPRING LOADED	50
-	-	1	2	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	-	-	-	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	2-2844962-4	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	-	1	1	2844938-5	PLATE, STRIP GUIDE	29
-	-	2	2	22281-8	SPRING, COMPRESSION	27
-	-	1	1	356835-1	LEVER, DRAG RELEASE	26
-	-	1	1	217233-1	DRAG, STOCK	25
-	-	1	1	1320928-6	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
-	-	2	2	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	318707-1	FLOATING SHEAR, FRONT	9
△	1	1	1	1333231-1	ANVIL, COMBINATION, SPECIAL	8
-	-	-	-	-	-	7
-	-	-	-	-	-	6
-	-	1	1	2119757-8	DEPRESSOR, SHEAR	5
-	-	1	1	3-238011-5	BLOCK, CRIMPER SPACER	4
△	1	1	1	2-1633989-1	CRIMPER, INSULATION, SPECIAL	3
-	-	1	1	455888-1	SPACER, CRIMPER	2
△	1	1	1	5-562108-2	CRIMPER, WIRE, F	1

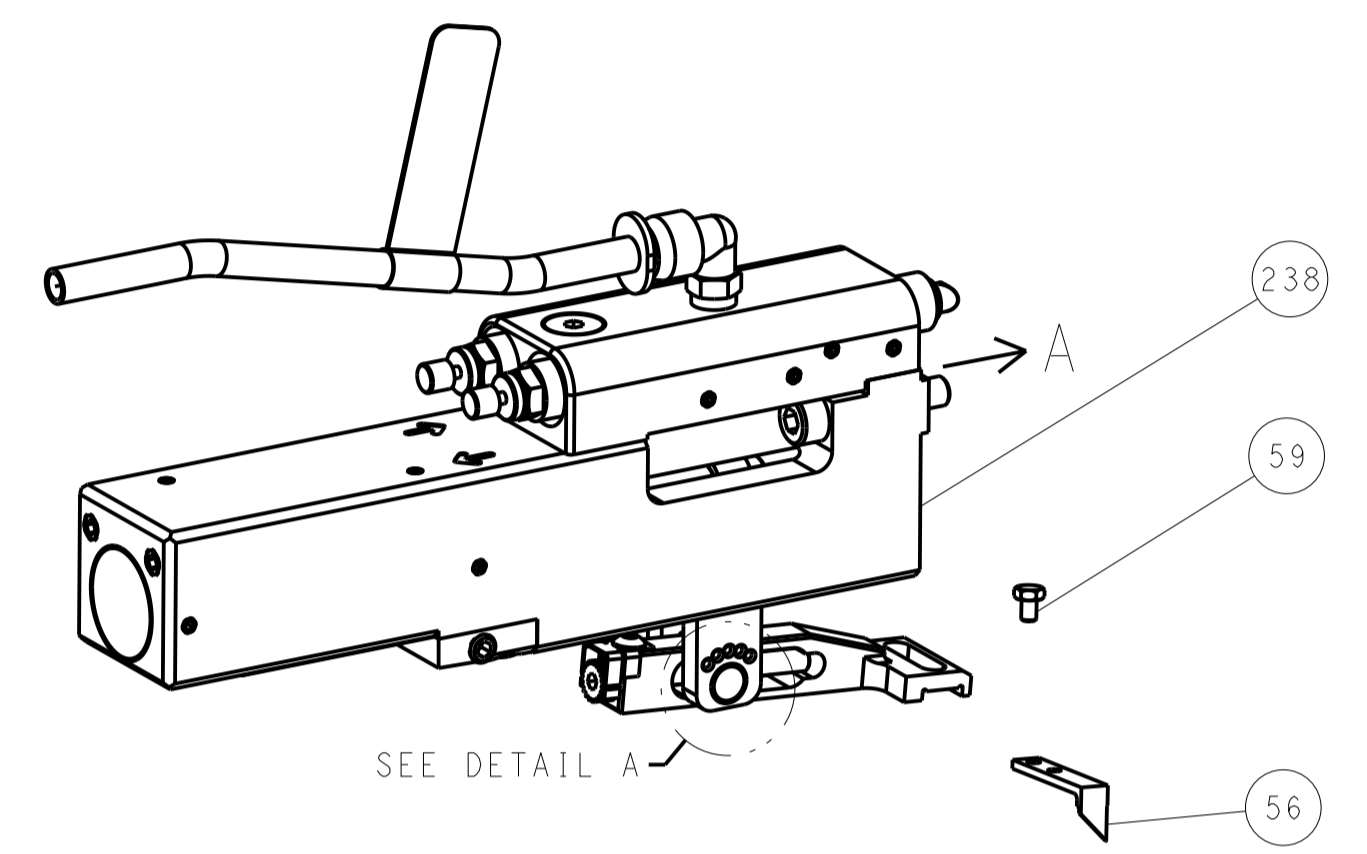
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG: MOYER ZODEC2012		CHK: T. ELBIN ZODEC2012		APVD: T. ELBIN ZODEC2012		NAME: Ocean Side Feed Applicator	
0 PLC ±		1 PLC ±		2 PLC ±		3 PLC ±		4 PLC ±		SIZE: A1	
ANGLES		FINISH		WEIGHT		SCALE: 1:2		SHEET: 3 OF 4		REV: 1	
MATERIAL		FINISH		WEIGHT		SCALE: 1:2		SHEET: 3 OF 4		REV: 1	

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

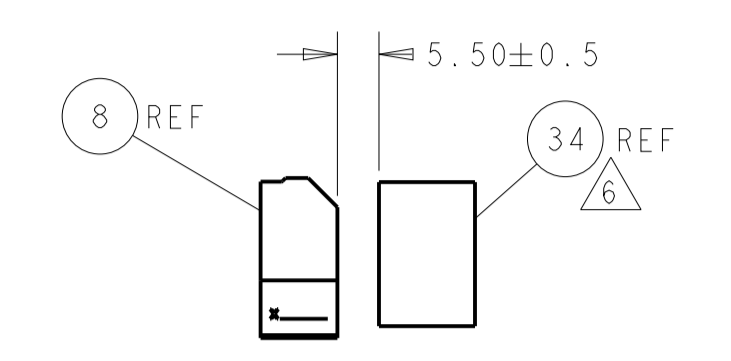
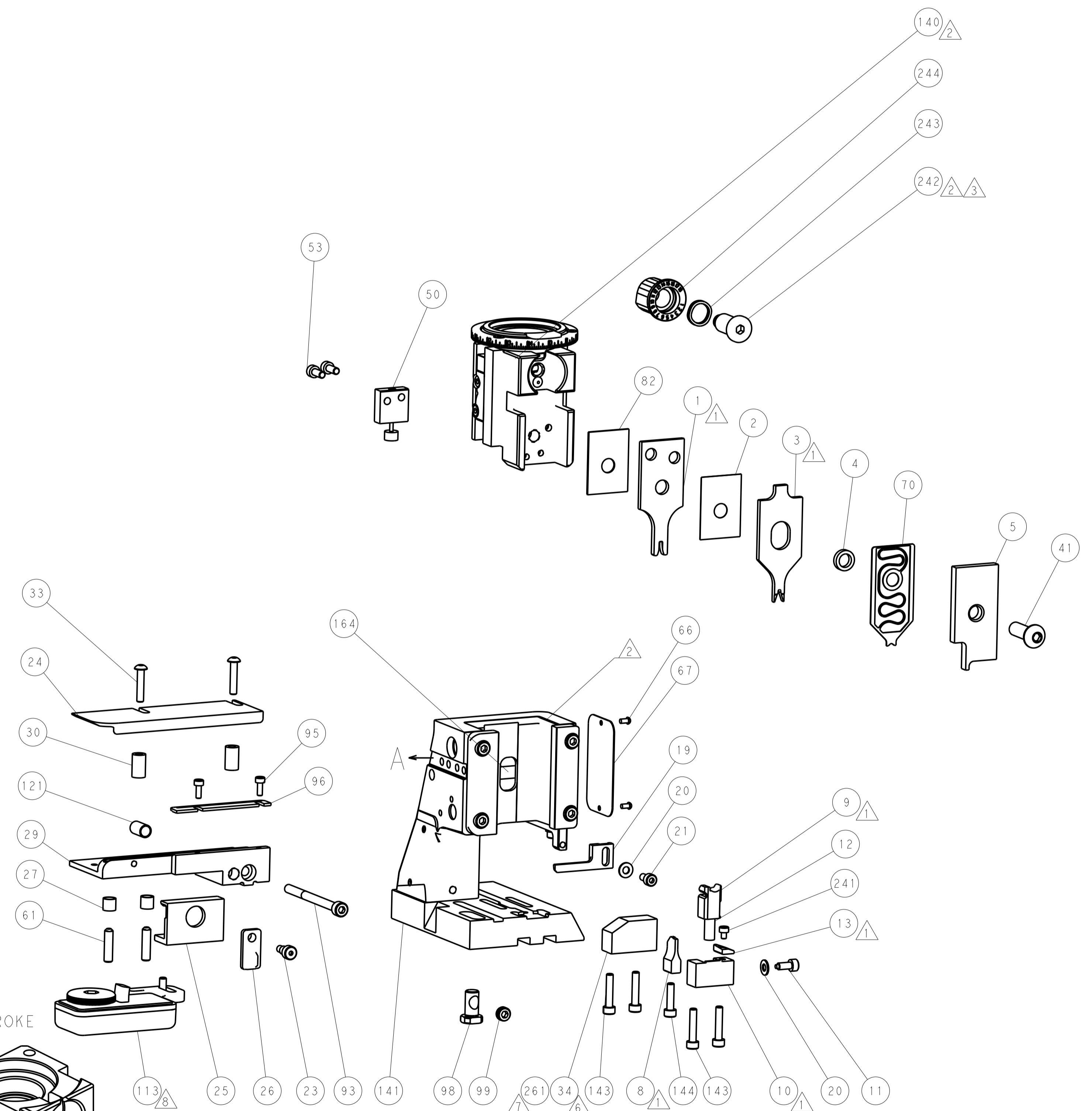
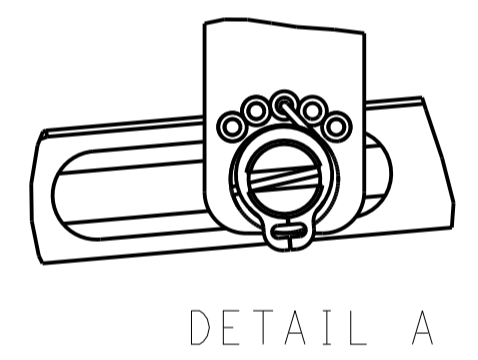
# FEED TYPE MECHANICAL



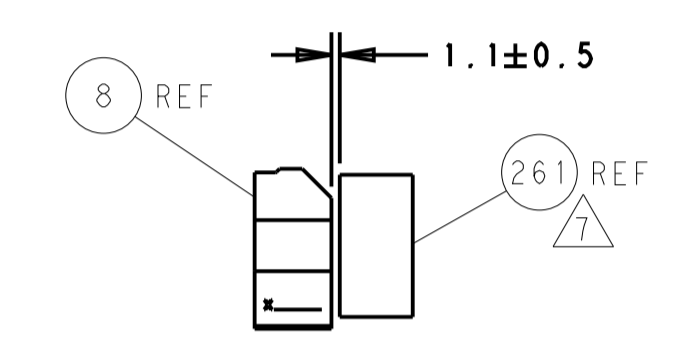
## PNEUMATIC



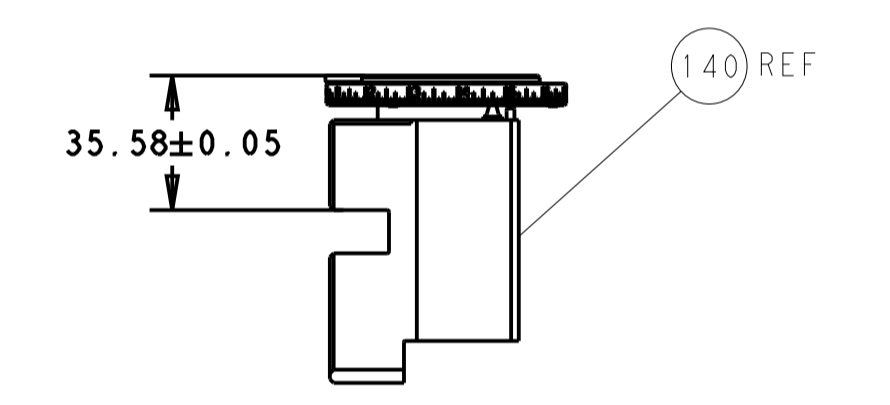
### FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



TERMINAL SUPPORT LOCATION FOR MALE TERMINAL

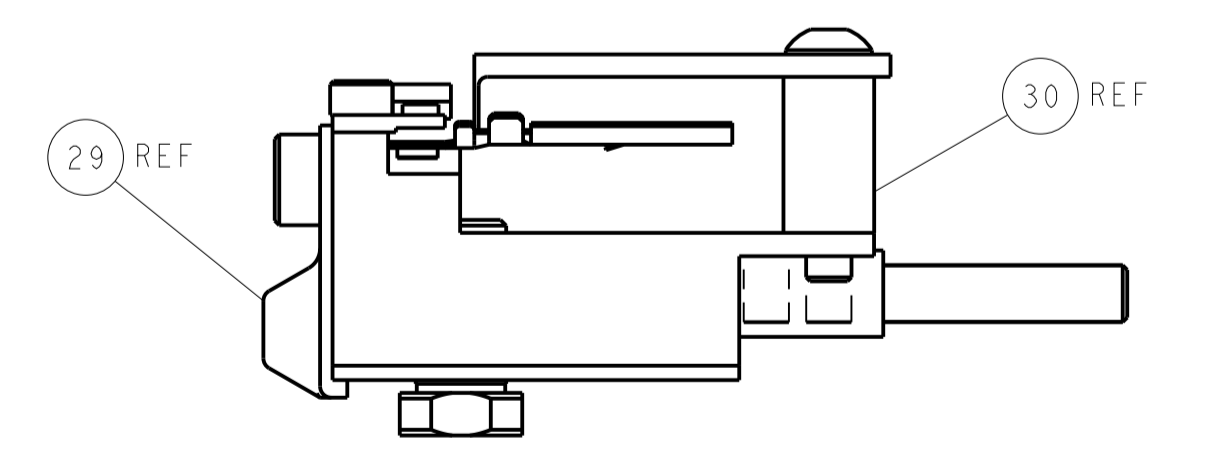


TERMINAL SUPPORT LOCATION FOR FEMALE TERMINAL

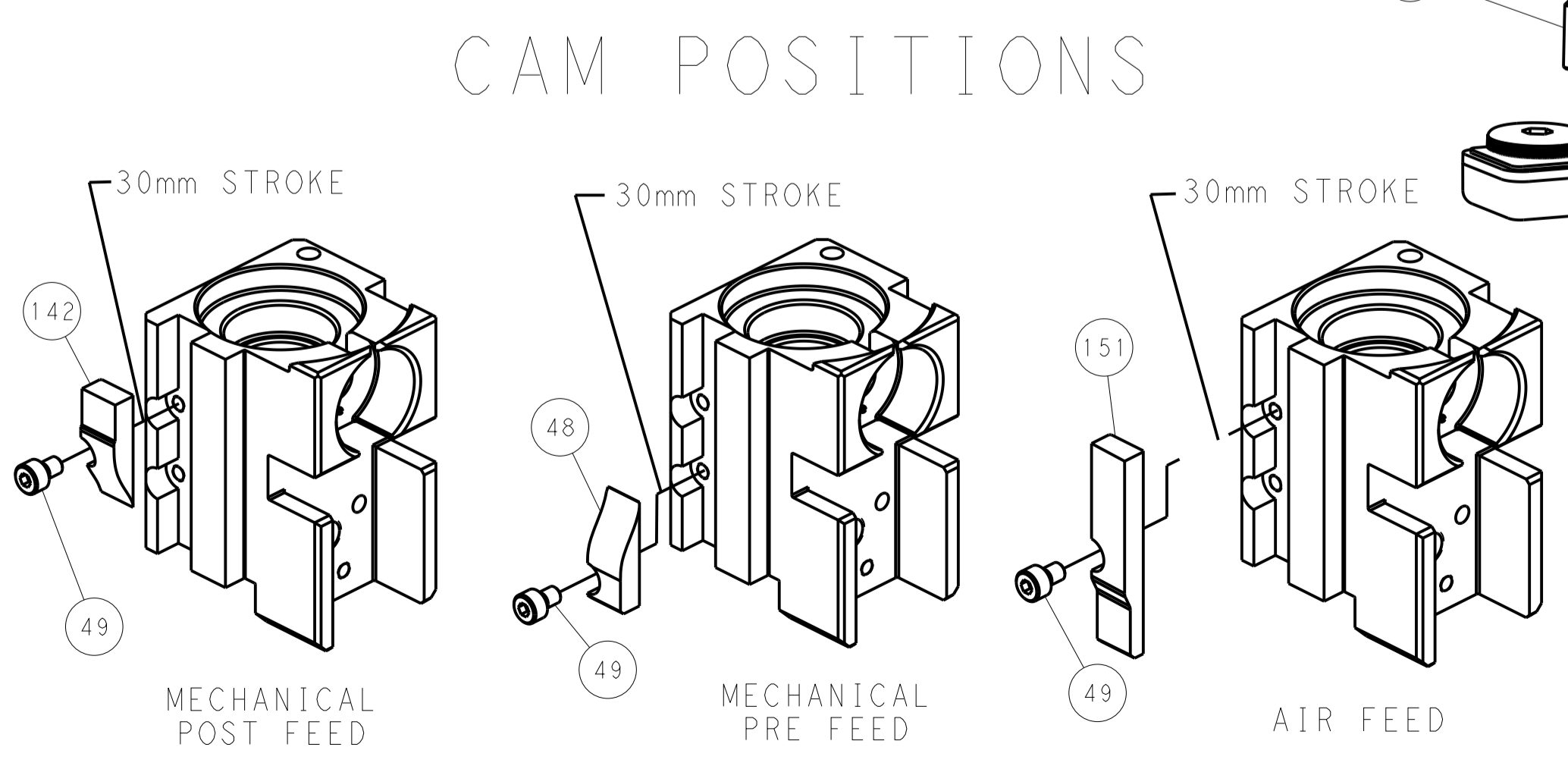


RAM SET-UP

ITEM 30 LOCATED AT REAR HOLES



FEED TRACK POSITION GUIDE BY INSULATION BARREL



## CAM POSITIONS

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

DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		DWN C. MOYER Z0DEC2012 CHK T. ELBIN Z0DEC2012 APVD T. ELBIN Z0DEC2012 PRODUCT SPEC APPLICATION SPEC WEIGHT Customer Accessible Production Drawing		NAME Ocean Side Feed Applicator SIZE CAGE CODE DRAWING NO A1 00779 ©=2151539 SCALE 1:2 SHEET 4 OF 4 REV 1		TE Connectivity Harrisburg, PA 17105-3608 RESTRICTED TO	
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