

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151931-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2151931-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151931-1	C	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2151931-2	C	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2151931-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.40 mm [.055]	F
INSUL	1.90 mm [.075]	OV

APPLICATOR INSTRUCTIONS 408-35042

TERMINAL DATA: JST TERMINAL		JST CRIMP SPECIFICATION	
TERMINAL NAME: SXA 2.5mm JST			
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE		
1.73-2.11 mm [.068-.083 IN]	Ø1.50-1.90 mm [.059-.075 IN]		
TERMINAL APPLICATION SPECIFICATION XA-XAD (W-W) CHM-1-170 Rev R3			
TERMINALS APPLIED			
TE TERMINAL	JST TERMINAL	TE TERMINAL	JST TERMINAL
1572601-1	SXA-01T-P0.6	1572601-3	SXA-01GW-P0.6
1572601-2	SXAM-01T-P0.6	2113096-1	SXM-01T-P0.6

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
20 AWG OR 0.50mm ²	0.90 +/- 0.05 [.035 +/- .002]	7.1
22 AWG OR 0.35mm ²	0.80 +/- 0.05 [.031 +/- .002]	8.2
24 AWG OR 0.20mm ²	0.75 +/- 0.05 [.030 +/- .002]	8.6

- 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. 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			
A	66	REV	DATE	BY	APPV
		A1	ECR-16-012205	25AUG2016	RS LZ
		B	ECR-17-009002	21JUNE2017	TB TE
		B1	ECR-17-017723	5DEC2017	RS LZ
		C	ECR-18-006876	07MAY2018	FZ KZ

-	1	-	1	-	2119640-1	PUSH ROD, AIR FEED	250	
-	1	-	1	-	1803259-1	BUSHING, FLANGED	249	
-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248	
-	1	1	1	1	2119082-8	CAM, SNAIL, INSULATION ADJUSTMENT	244	
-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243	
-	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242	
-	1	1	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241	
-	-	1	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239	
-	1	-	1	-	2063440-1	AIR FEED MODULE	238	
-	2	-	2	-	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172	
-	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164	
-	1	-	1	-	240638-1	SPRING, FEED FINGER	163	
-	1	-	1	-	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854	137	
-	1	-	1	-	2119799-1	HOLDER, FEED FINGER, AF	136	
-	1	1	1	1	1-18028-2	WASHER, FLAT, REG M4	119	
-	1	1	1	1	2844908-1	SCREW, LOCKING	99	
-	1	1	1	1	2844907-1	POST, LOCKING	98	
-	1	1	1	1	1-455888-7	SPACER, CRIMPER	82	
-	1	1	1	1	5-547505-2	SPRING, COMPRESSION	77	
-	1	1	1	1	854769-4	HOLDER, INS	74	
-	1	1	1	1	1803607-1	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	21028-2	PIN, SLOTTED SPRING .062 X .250	58	
-	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	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	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	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	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41	
-	1	1	1	1	2-1752356-3	SUPPORT, TERMINAL	34	
-	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33	
-	2	2	2	2	2-2844962-6	SPACER, CYLINDRICAL, STRIP GUIDE	30	
-	1	1	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29	
-	1	1	1	1	455888-3	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	2119533-3	STRIPPER, SIDE FEED	19	
-	1	1	1	1	2119806-1	INSERT, SHEAR	13	
-	1	1	1	1	3-22280-3	SPRING, COMPRESSION	12	
-	1	1	1	1	1-356885-4	STOP, SHEAR	11	
-	1	1	1	1	2119805-1	SHEAR HOLDER, FRONT	10	
-	1	1	1	1	1633861-1	SHEAR, FLOATING	9	
-	1	2	2	1	1-1633917-5	ANVIL, COMBINATION	8	
-	1	1	1	1	1-240641-6	SPACER	7	
-	-	-	-	-	-	-	6	
-	1	1	1	1	1-2119780-1	DEPRESSOR, SHEAR	5	
-	1	1	1	1	2-238011-0	BLOCK, CRIMPER SPACER	4	
-	1	2	2	1	1-1633964-2	CRIMPER, INSULATION OVERLAP PREMIUM	3	
-	1	1	1	1	455888-3	SPACER, CRIMPER	2	
-	1	2	2	1	3-456402-4	CRIMPER, WIRE PREMIUM	1	
-	77	-72	-71	-2	-1	PART NO	DESCRIPTION	ITEM NO

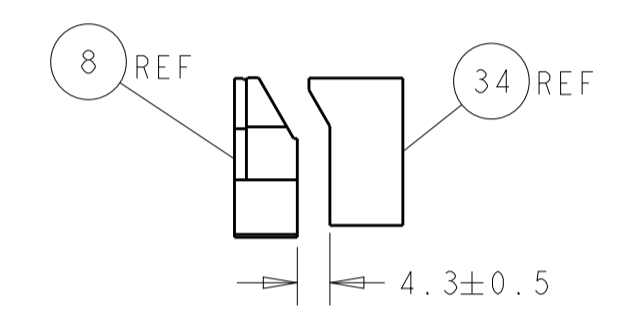
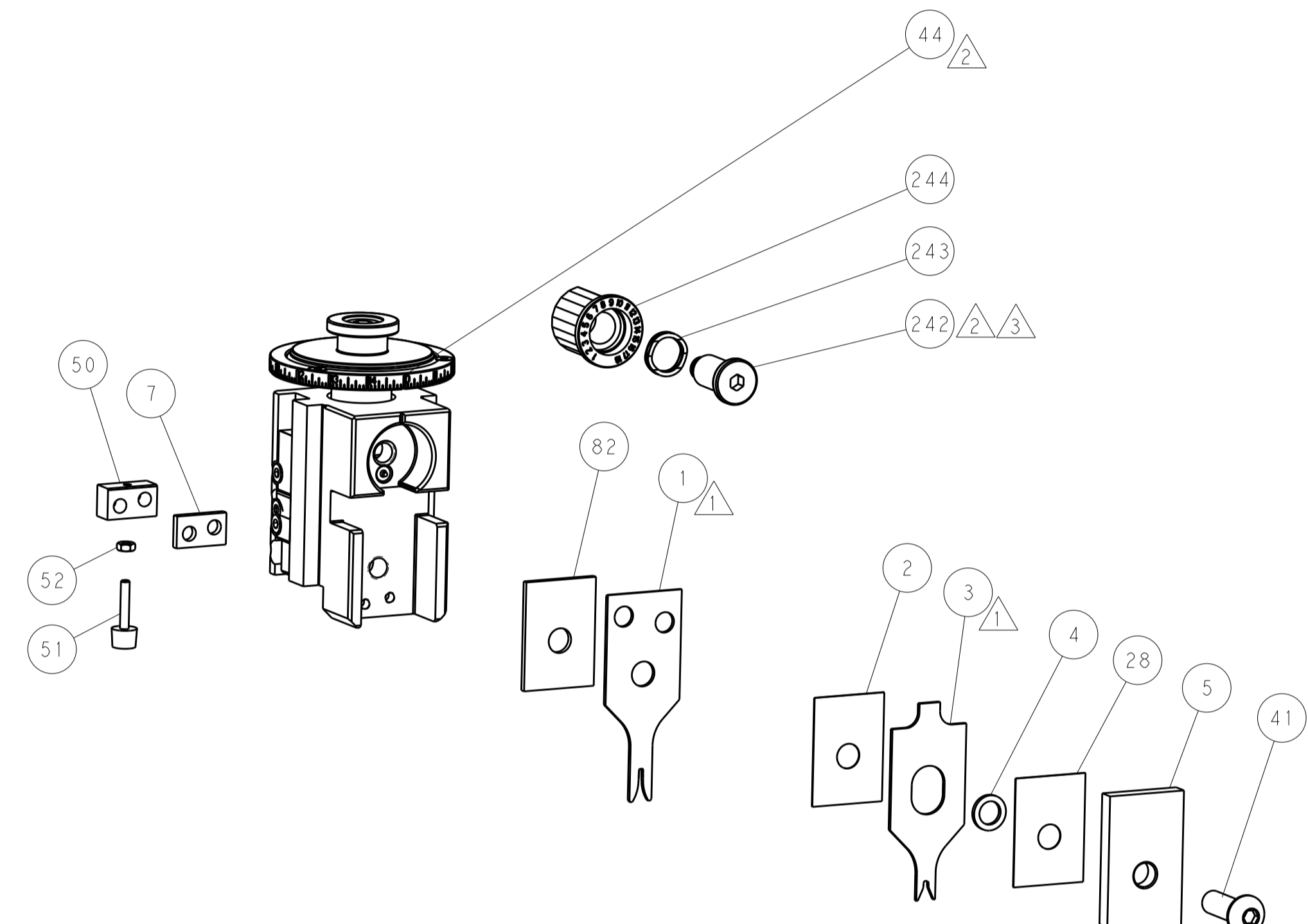
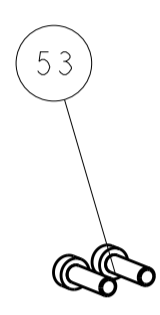
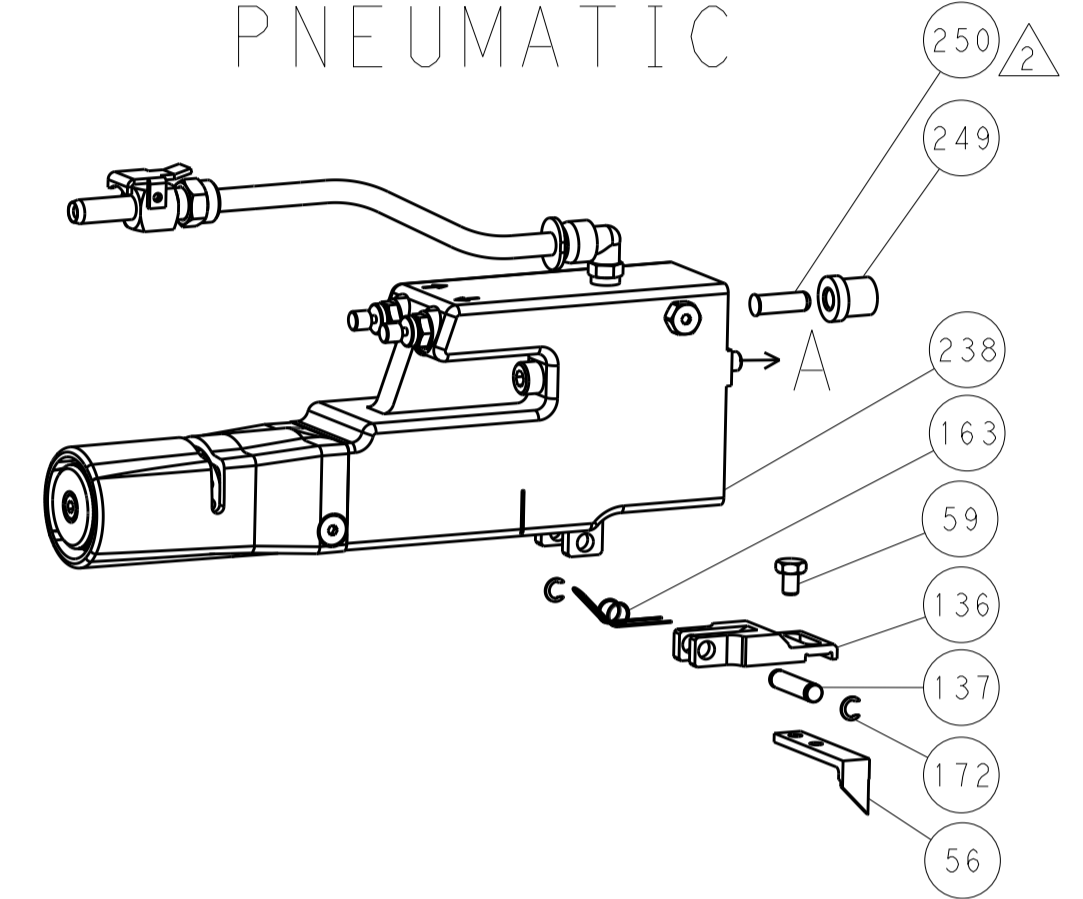
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1 PLC ±		2 PLC ±		APPV C. LIMA 05APR2013		NAME	
3 PLC ±		4 PLC ±		PRODUCT SPEC		Ocean Side Feed	
5 PLC ±		ANGLES ±		APPLICATION SPEC		Applicator	
MATERIAL		FINISH		WEIGHT		SIZE CAGE CODE DRAWING NO RESTRICTED TO	
				A1 00779		C=2151931	
				Customer Accessible Production Drawing		SCALE 1:2 SHEET 1 OF 4 REV C	

LOC		DIST		REVISIONS			
NO.	REV.	DATE	BY	DESCRIPTION	DATE	BY	APPROV.
A	66	-	-	SEE SHEET 1	-	-	-

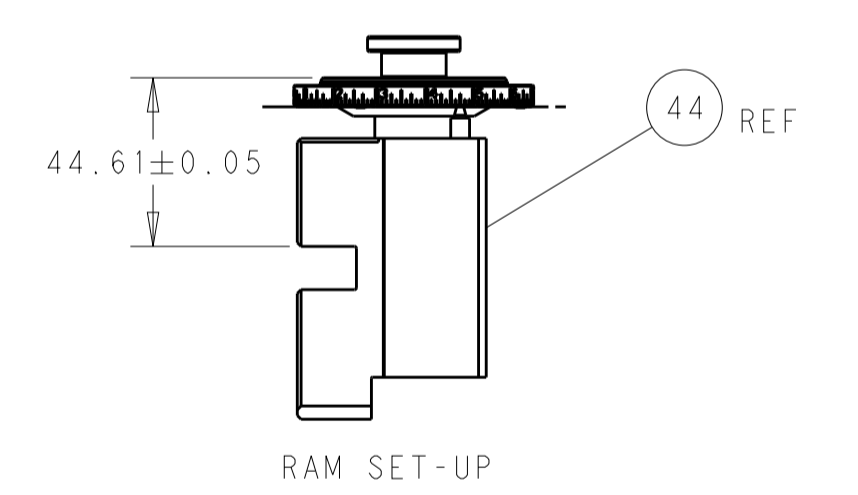
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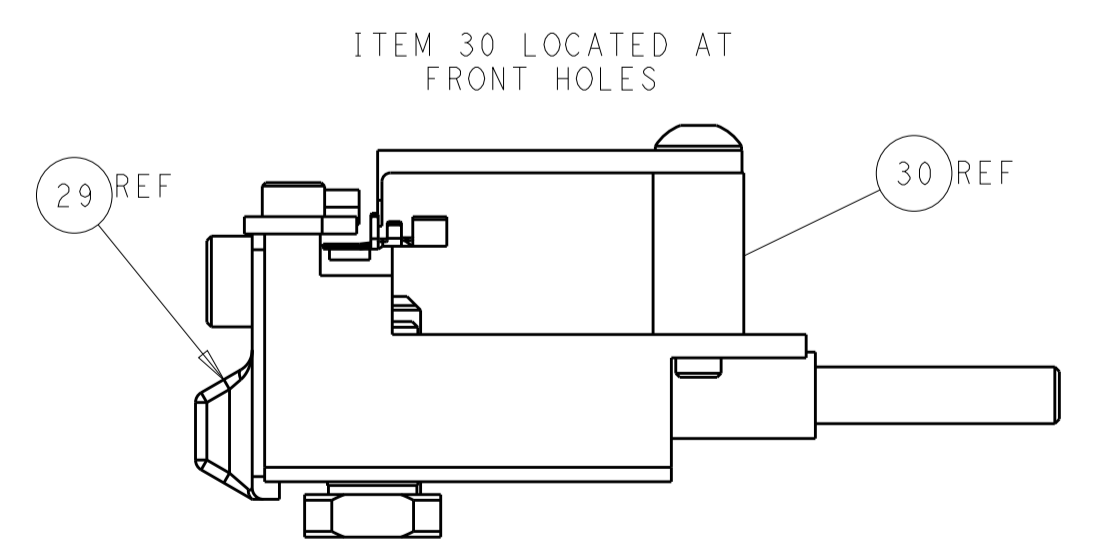
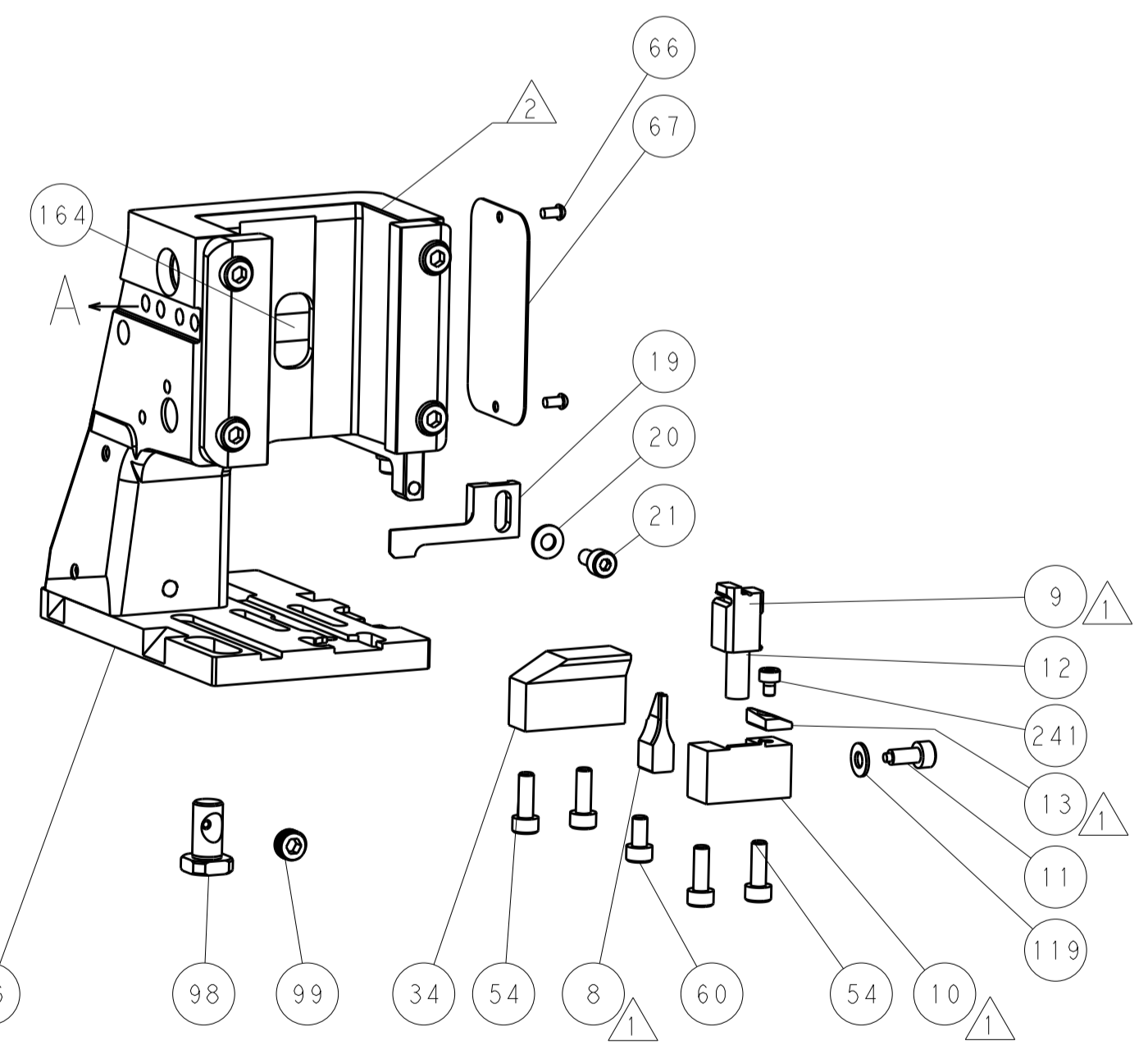
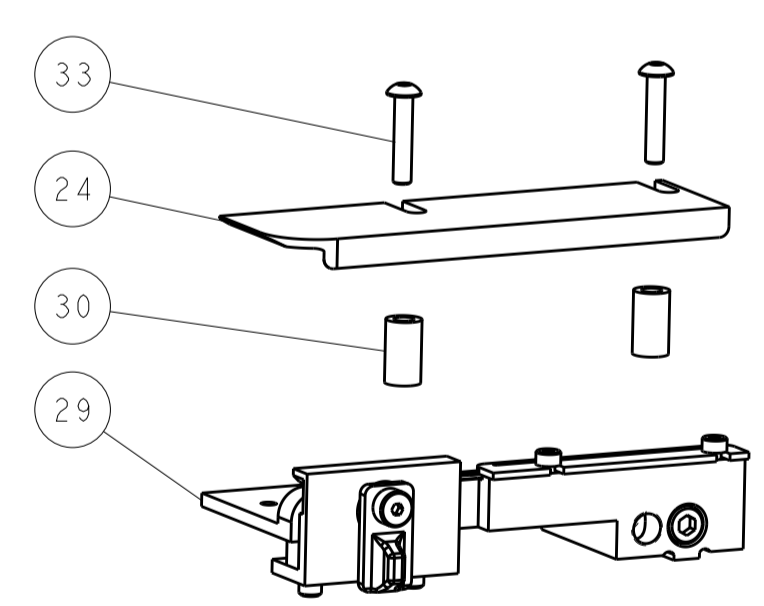
PNEUMATIC



TERMINAL SUPPORT LOCATION

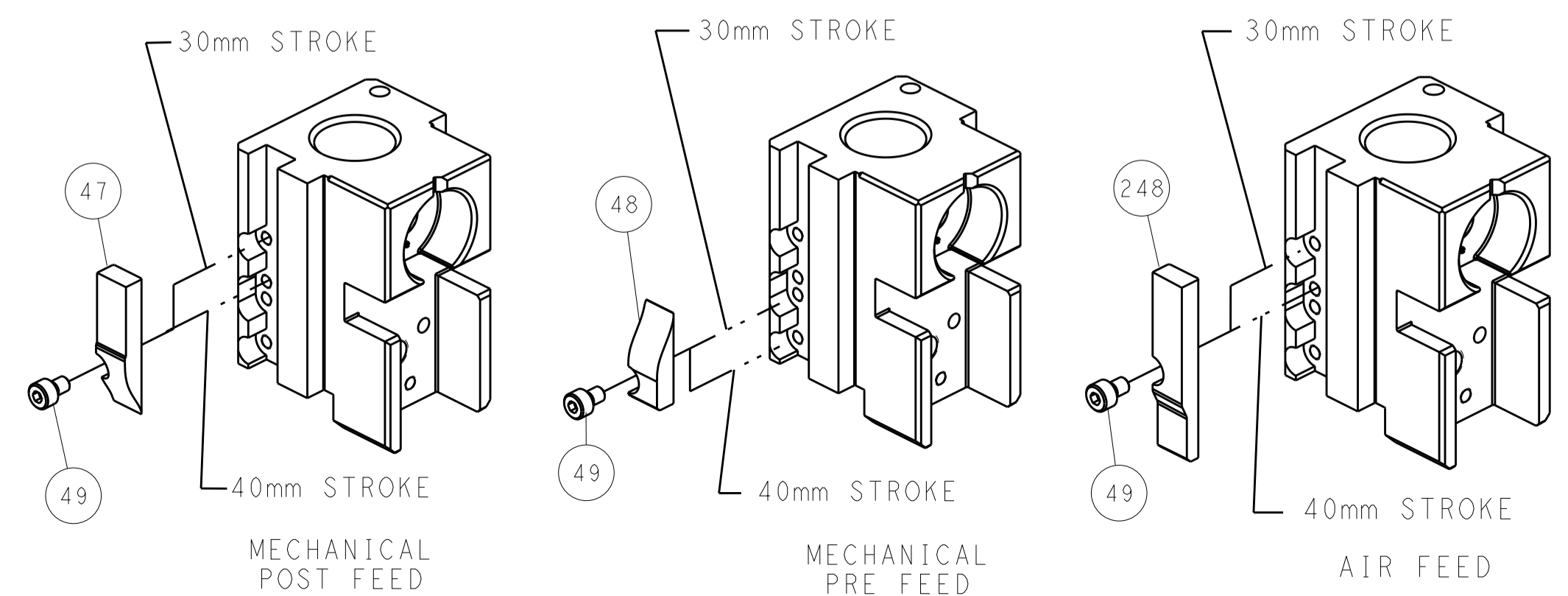


RAM SET-UP



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)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG		TE Connectivity	
mm	0 PLC	±		S. ALVES	05APR2013	Harrisburg, PA 17105-3608	
	1 PLC	±		CHK P. BARLETTA	05APR2013		
	2 PLC	±		APPV C. LIMA	05APR2013		
	3 PLC	±		NAME Ocean Side Feed Applicator			
	4 PLC	±		SIZE CAGE CODE DRAWING NO RESTRICTED TO			
	ANGLES	±		A1 00779 ©=2151931			
MATERIAL	FINISH			WEIGHT		SCALE 1:2 SHEET 2 OF 4 REV C	
				Customer Accessible Production Drawing			

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2151931-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2151931-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151931-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
 INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.40 mm [.055]	F
INSUL	1.90 mm [.075]	OV
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: JST TERMINAL JST CRIMP SPECIFICATION			
TERMINAL NAME: SXA 2.5mm JST			
WIRE STRIP LENGTH 1.73-2.11 mm [.068-.083 IN]		INSULATION DIAMETER RANGE 1.50-1.90 mm [.059-.075 IN]	
TERMINAL APPLICATION SPECIFICATION XA-XAD (W-W) CHM-1-170 Rev R3			
TERMINALS APPLIED			
TE TERMINAL	JST TERMINAL	TE TERMINAL	JST TERMINAL
1572601-1	SXA-01T-P0.6	1572601-3	SXA-01GW-P0.6
1572601-2	SXAM-01T-P0.6	2113096-1	SXM-01T-P0.6

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
20 AWG OR 0.50mm ²	0.90 +/- 0.05 [.035 +/- .002]	7.1
22 AWG OR 0.35mm ²	0.80 +/- 0.05 [.031 +/- .002]	8.2
24 AWG OR 0.20mm ²	0.75 +/- 0.05 [.030 +/- .002]	8.6



- 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. 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.

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

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

-	1	-	2119640-1	PUSH ROD, AIR FEED			250
-	1	-	1803259-1	BUSHING, FLANGED			249
-	1	1	2119082-8	CAM, SNAIL, INSULATION ADJUSTMENT			244
-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST			243
3	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	1-455888-7	SPACER, CRIMPER			82
-	1	1	5-547505-2	SPRING, COMPRESSION			77
-	1	1	854769-4	HOLDER, INS			74
-	1	1	1803607-1	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	21028-2	PIN, SLOTTED SPRING .062 X .250			58
-	1	1	1338685-1	PAWL, FEED			56
-	2	2	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16			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	2-1752356-3	SUPPORT, TERMINAL			34
-	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)			33
-	2	2	2-2844962-6	SPACER, CYLINDRICAL, STRIP GUIDE			30
-	1	1	2844992-1	ASSEMBLY, STRIP GUIDE			29
-	1	1	455888-3	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	2119533-3	STRIPPER, SIDE FEED			19
1	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	1	2119805-1	SHEAR HOLDER, FRONT			10
1	1	1	1633861-1	SHEAR, FLOATING			9
1	1	1	1-1633917-5	ANVIL, COMBINATION			8
-	1	1	1-240641-6	SPACER			7
-	-	-	-	-			6
-	1	1	1-2119780-1	DEPRESSOR, SHEAR			5
-	1	1	2-238011-0	BLOCK, CRIMPER SPACER			4
1	1	1	1-1633964-2	CRIMPER, INSULATION OVERLAP PREMIUM			3
-	1	1	455888-3	SPACER, CRIMPER			2
1	1	1	3-456402-4	CRIMPER, WIRE PREMIUM			1

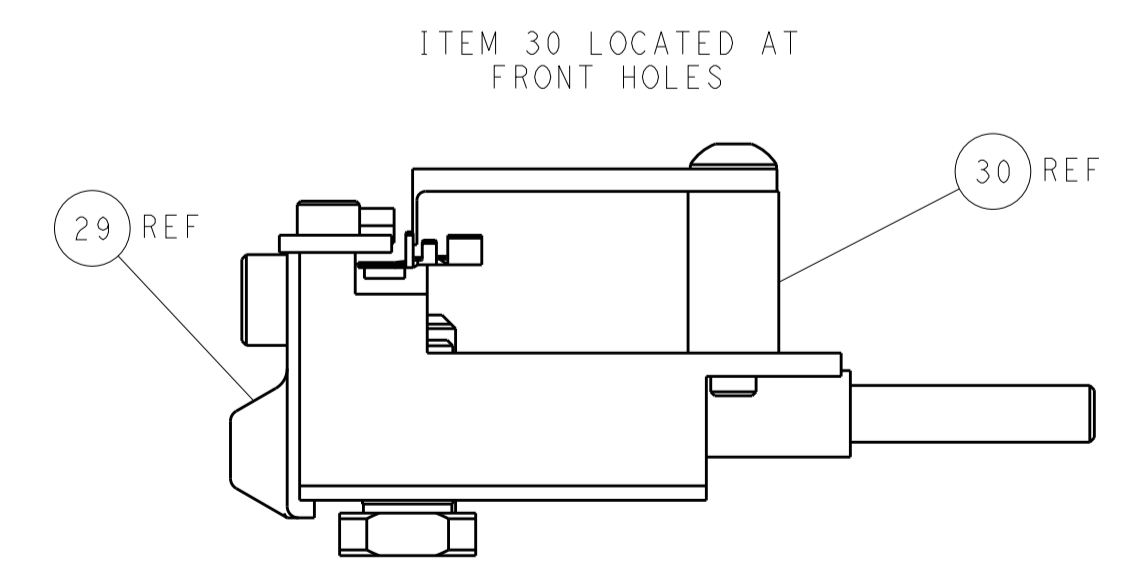
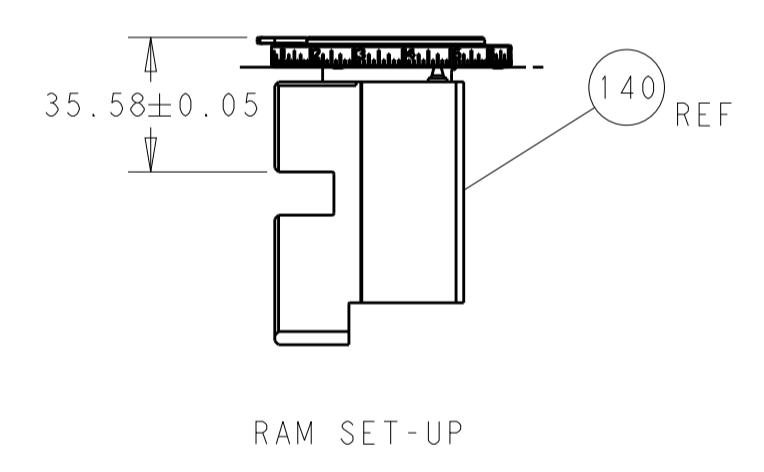
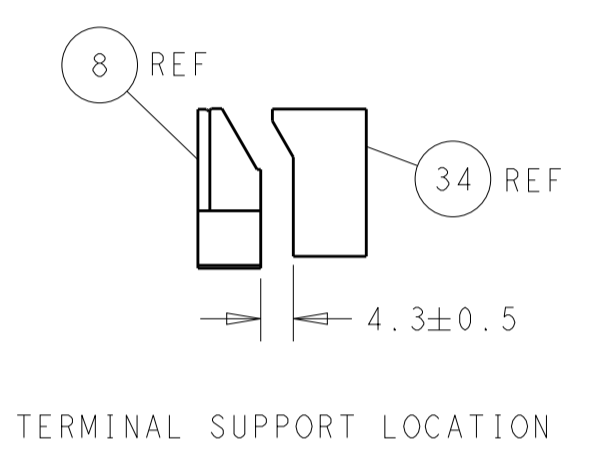
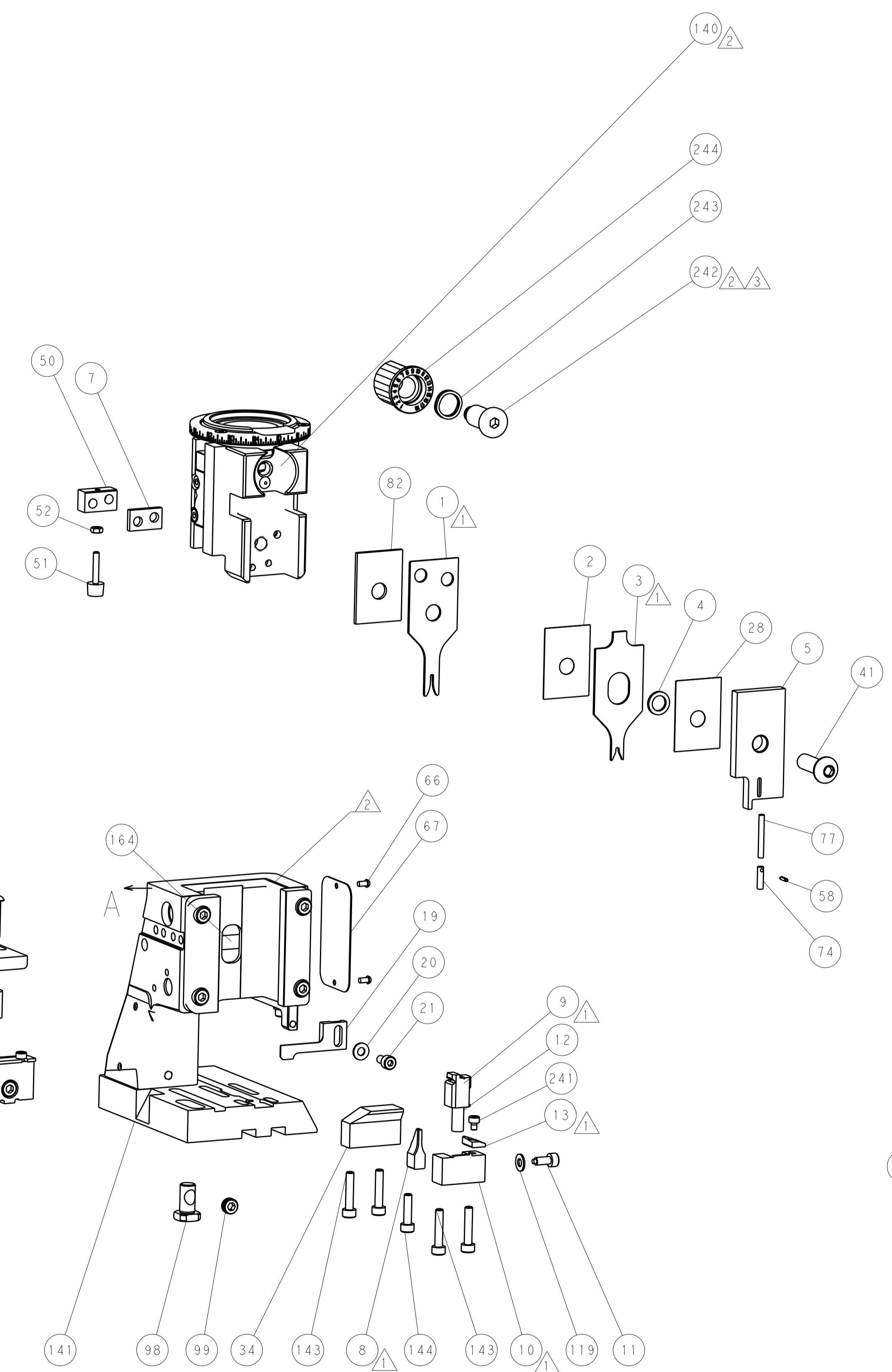
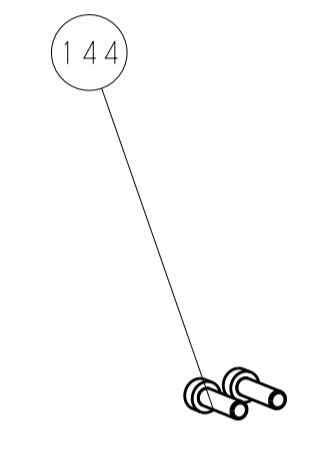
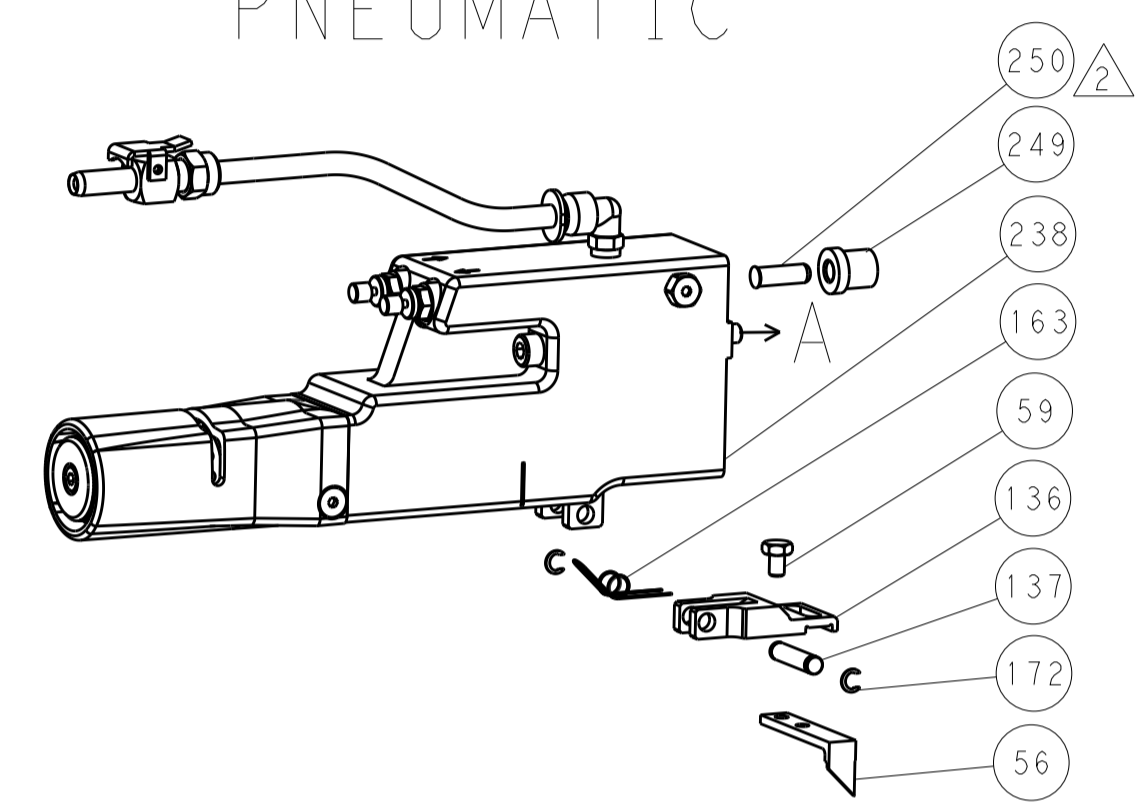
DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH		DWG: S. ALVES 05APR2013 CHK: P. BARLETTA 05APR2013 APVD: C. LIMA 05APR2013		NAME: Ocean Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2151931 SCALE: 1:2 SHEET: 3 OF 4 REV: C	
MATERIAL:				WEIGHT:		RESTRICTED TO:	

LOC		DIST		REVISIONS				
P	LTN	DATE	DMN	APVD	DESCRIPTION	DATE	DMN	APVD
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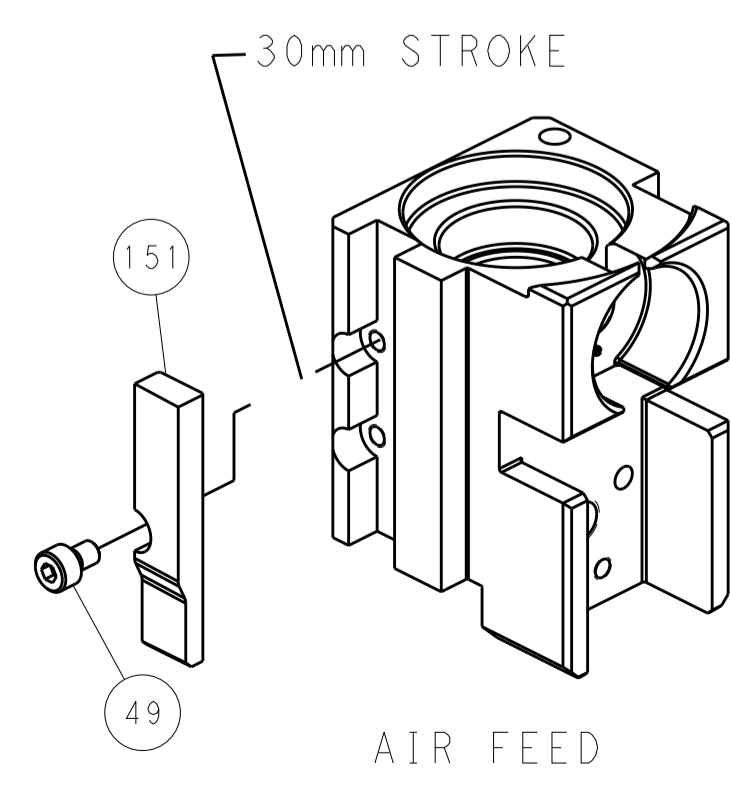
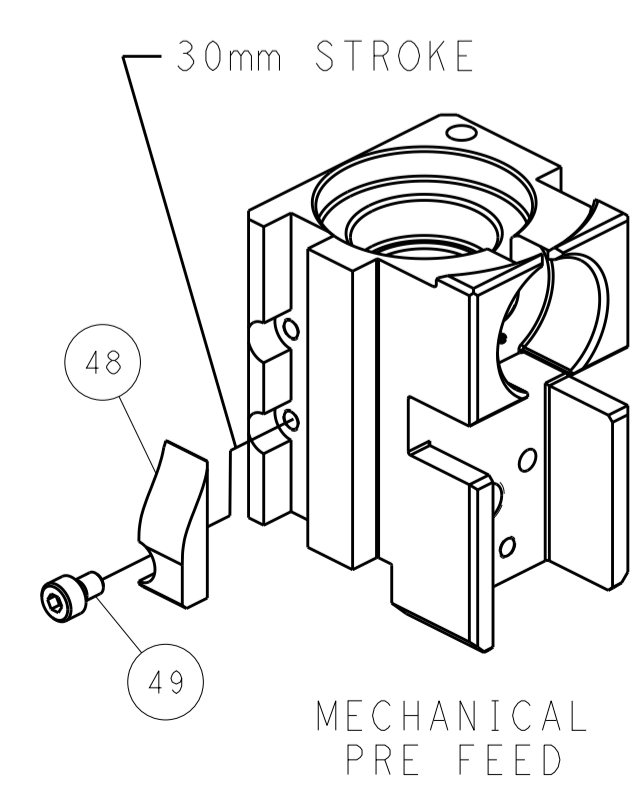
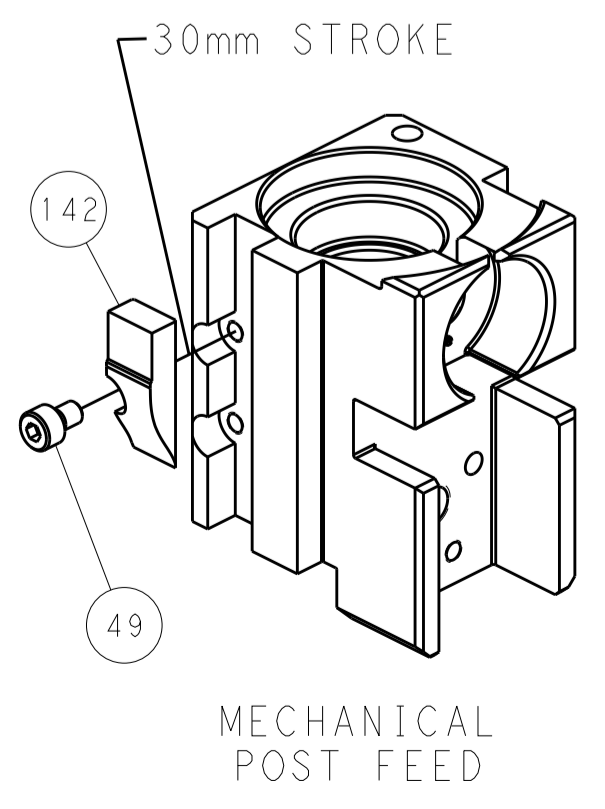
FEED TYPE MECHANICAL



PNEUMATIC



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:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG: S. ALVES 05APR2013		CHK: P. BARLETTA 05APR2013		APVD: C. LIMA 05APR2013		NAME: Ocean Side Feed Applicator	
mm	0 PLC	±		mm	0 PLC	±		mm	0 PLC	±	
	1 PLC	±			1 PLC	±			1 PLC	±	
	2 PLC	±			2 PLC	±			2 PLC	±	
	3 PLC	±			3 PLC	±			3 PLC	±	
	4 PLC	±			4 PLC	±			4 PLC	±	
	ANGLES	±			ANGLES	±			ANGLES	±	
MATERIAL:	FINISH:	WEIGHT:	SCALE:	SIZE:	CAGE CODE:	DRAWING NO:	RESTRICTED TO:	Customer Accessible Production Drawing			
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