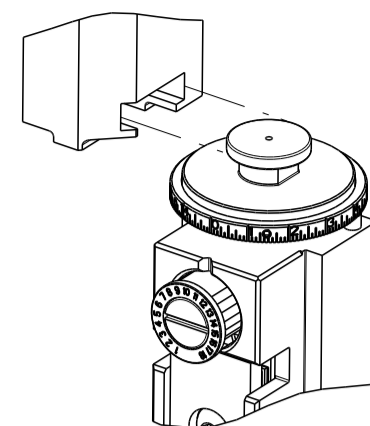


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151920-1	J	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2151920-2	J	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151920-1	J	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2151920-2	J	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2151920-7	D	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.40 mm [.055]	F
INSUL	1.52 mm [.060]	F

APPLICATOR INSTRUCTIONS 408-35042

TERMINAL DATA: MOLEX TERMINAL		MOLEX CRIMP SPECIFICATION	
TERMINAL NAME: MINI FIT JR OVERALL TIN FEMALE CRIMP TERMINAL			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
2.80-3.30 mm [.110-.130 IN]		Ø1.10-1.30 mm [.043-.051 IN]	
TERMINAL APPLICATION SPECIFICATION	ATS-639020200		

TERMINALS APPLIED			
TE TERMINAL	MOLEX TERMINAL	TE TERMINAL	MOLEX TERMINAL
1572221-1	39000046	1572222-9	39000145
1572221-2	39000065	1572222-5	39000221
1-1572221-1	39000091	1572222-6	39000432
1-1572221-2	39000139	1-1572222-0	40010854
1572221-7	39000183	1-1572222-1	98000175
1572221-8	39000209	1572222-1	39000048
1572221-9	39000215	1572222-2	39000067
1-1572221-8	39000434	1572222-4	39000128
1-1572221-9	46018-2541		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.35mm2 OR 22AWG	0.795+/-0.035 [.0315+/-0.0015]	5.9
0.20mm2 OR 24AWG	0.735+/-0.035 [.029+/-0.001]	6.3
0.12mm2 OR 26AWG	0.69+/-0.03 [.027+/-0.001]	7.0
0.08mm2 OR 28AWG	0.66+/-0.03 [.026+/-0.001]	7.4

- 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)

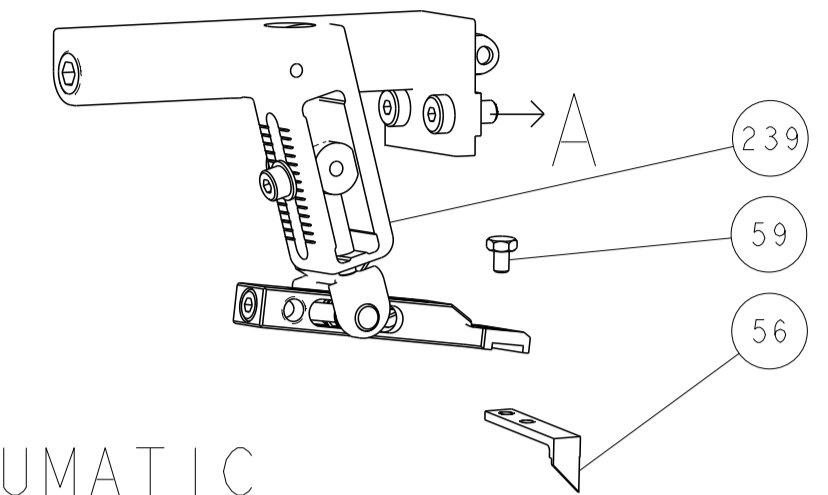
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		G		ECR-17-006302	03MAY2017	KH	TE
		H		ECR-19-005146	30MAR2019	TB	CT
		J		ECR-22-133466	22MAR2022	JWC	JH

-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248	
-	1	1	1	1	2119082-5	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	-	2844940-1	AIR FEED MODULE	238	
-	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164	
-	1	1	1	1	2844908-1	SCREW, LOCKING	99	
-	1	1	1	1	2844907-1	POST, LOCKING	98	
-	1	1	1	1	455888-6	SPACER, CRIMPER	82	
-	1	1	1	1	1803607-3	DOCUMENTATION PACKAGE	71	
-	1	1	1	1	2119791-9	DEPRESSOR, WIRE	70	
-	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	2-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 14	53	
-	1	1	1	1	1803382-6	HOLD DOWN, SPRING LOADED	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	1-1752356-9	SUPPORT, TERMINAL	34	
-	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33	
-	2	2	2	2	2-2844962-4	SPACER, CYLINDRICAL, STRIP GUIDE	30	
-	1	1	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29	
-	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	2	2	1-18028-2	WASHER, FLAT, REG M4	20	
-	1	1	1	1	2119533-1	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	1-356885-3	STOP, SHEAR	11	
-	1	1	1	1	2119805-1	SHEAR HOLDER, FRONT	10	
-	1	1	1	1	1803095-3	FLOATING SHEAR, FRONT	9	
-	1	2	2	1	1-1633917-4	ANVIL, COMBINATION	8	
-	1	1	1	1	240641-1	SPACER	7	
-	-	-	-	-	-	-	6	
-	1	1	1	1	2119757-1	DEPRESSOR, SHEAR	5	
-	1	1	1	1	238011-7	BLOCK, CRIMPER SPACER	4	
-	1	2	2	1	6-1633961-8	CRIMPER, INSULATION F PREMIUM	3	
-	1	1	1	1	455888-5	SPACER, CRIMPER	2	
-	1	2	2	1	6-456402-4	CRIMPER, WIRE PREMIUM	1	
-	77	-72	-71	-2	-1	PART NO	DESCRIPTION	ITEM NO

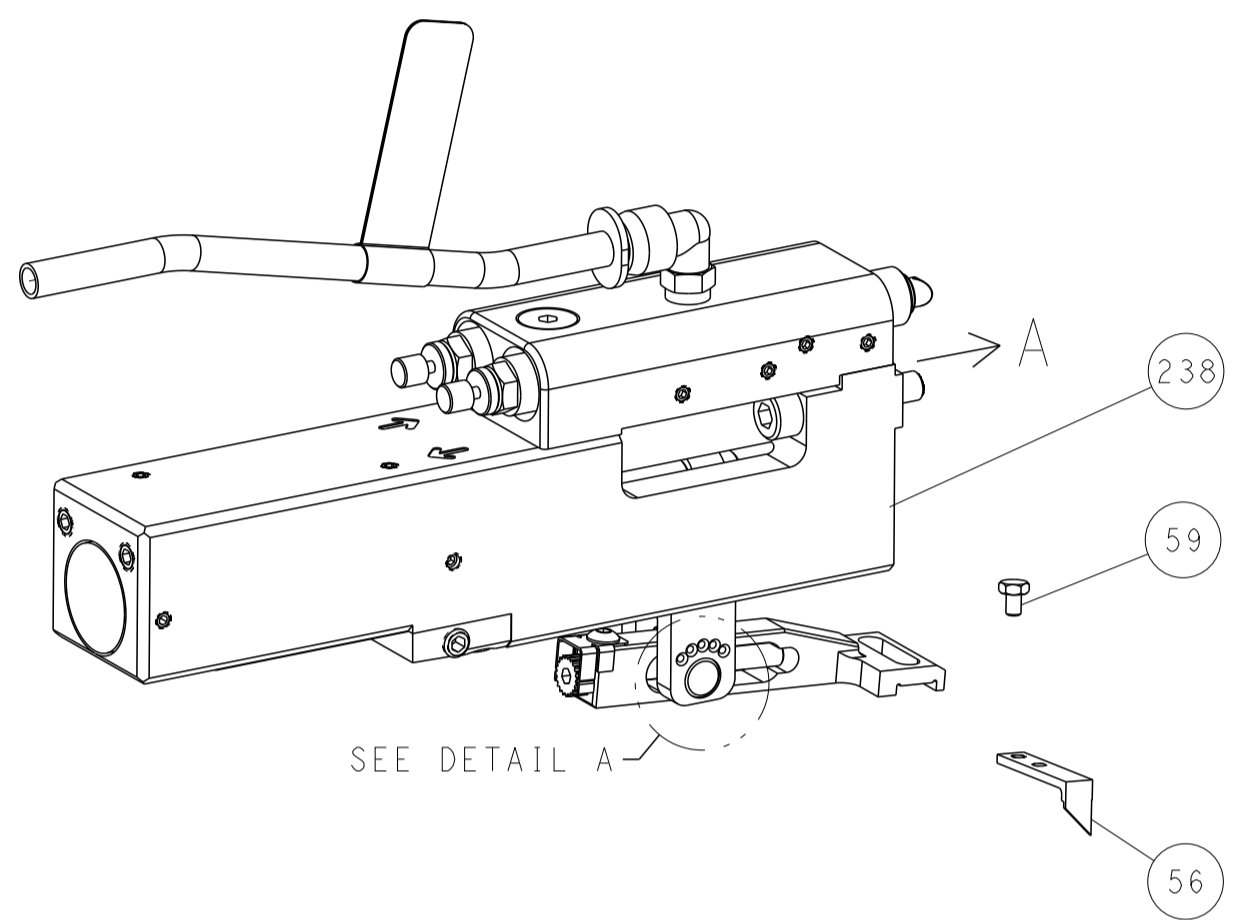
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mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES	FINISH			Customer Accessible Production Drawing	SCALE 1:2
OWN Y. YIN 29MAR2013		CHK G. BAILEY 29MAR2013		APVD U. GUO 29MAR2013		NAME		SIZE CAGE CODE DRAWING NO		RESTRICTED TO	
G. BAILEY		U. GUO		PRODUCT SPEC		APPLICATION SPEC		A1 00779 C=2151920		SHEET 1 OF 4	
TE Connectivity		Harrisburg, PA 17105-3608		Ocean Side Feed		Applicator		REV J		Customer Accessible Production Drawing	

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

# FEED TYPE MECHANICAL



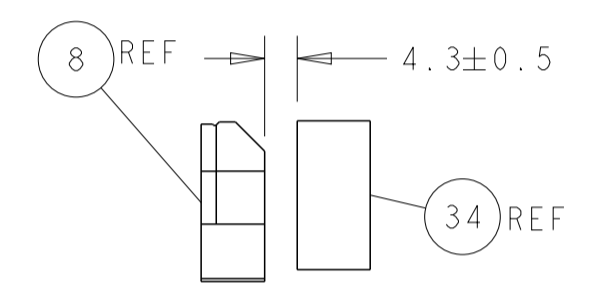
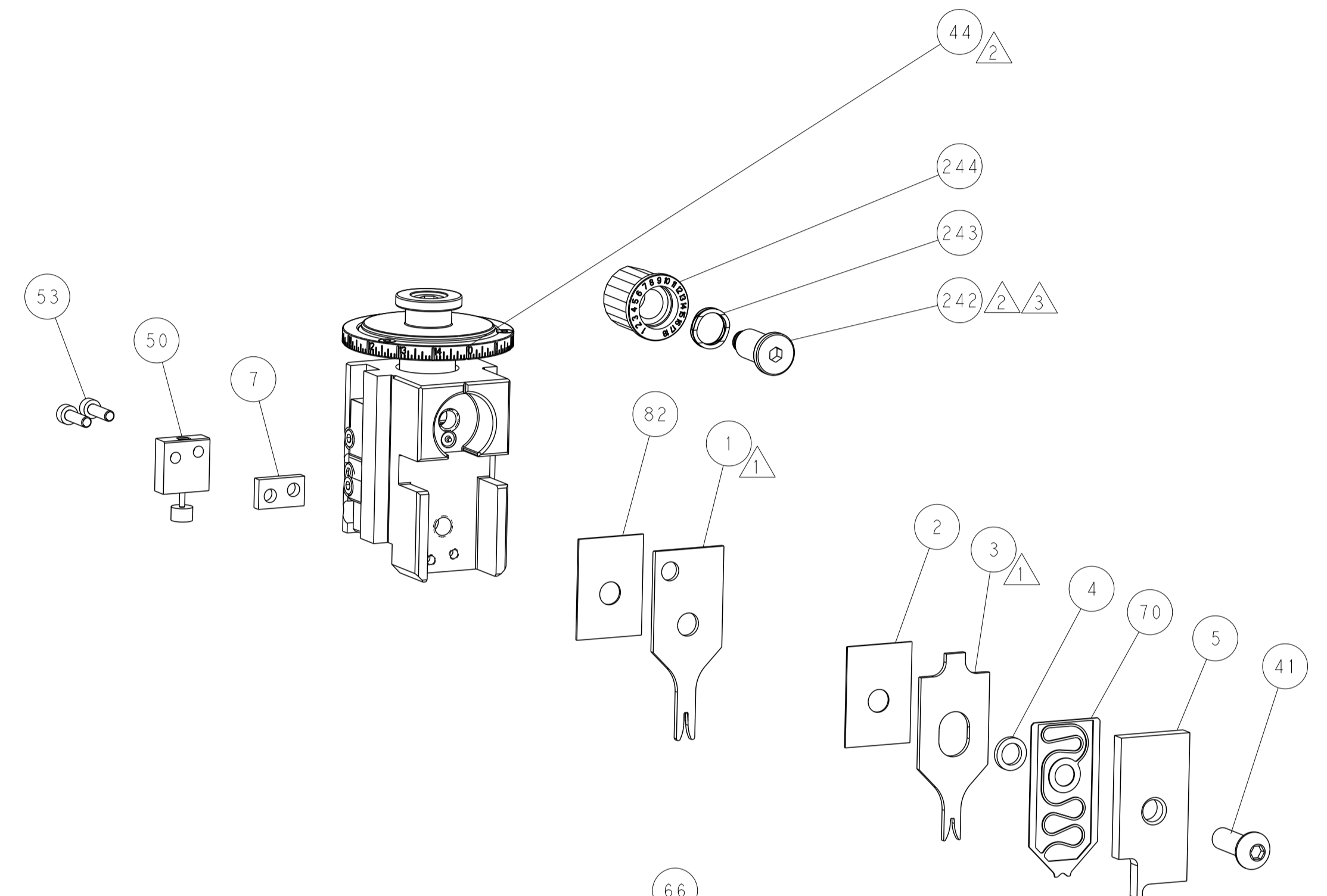
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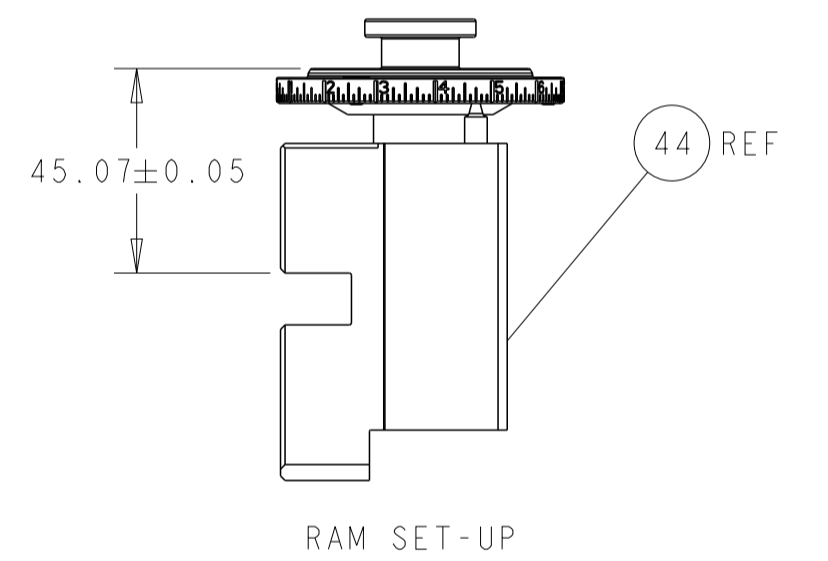
## FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



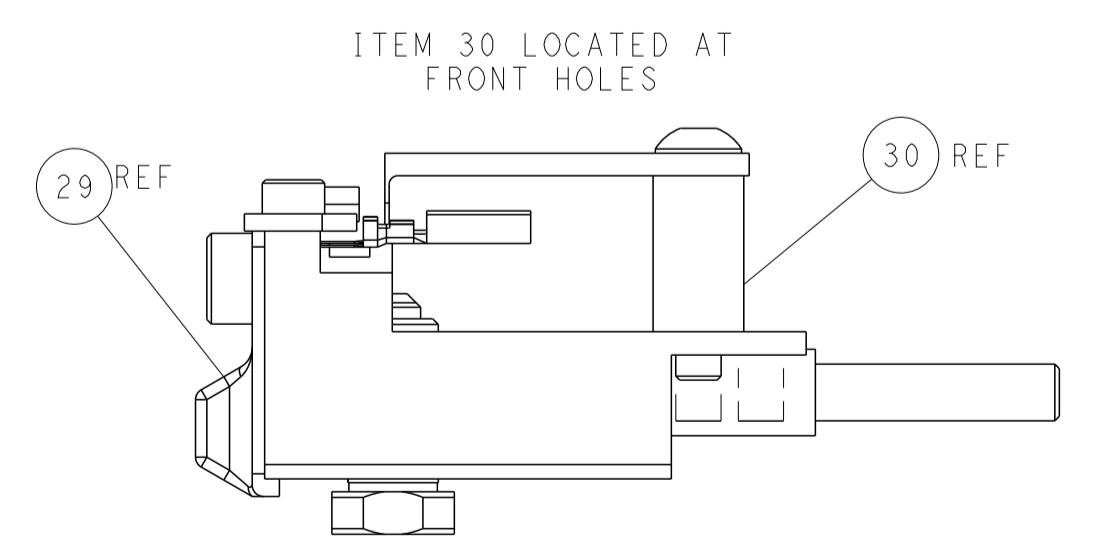
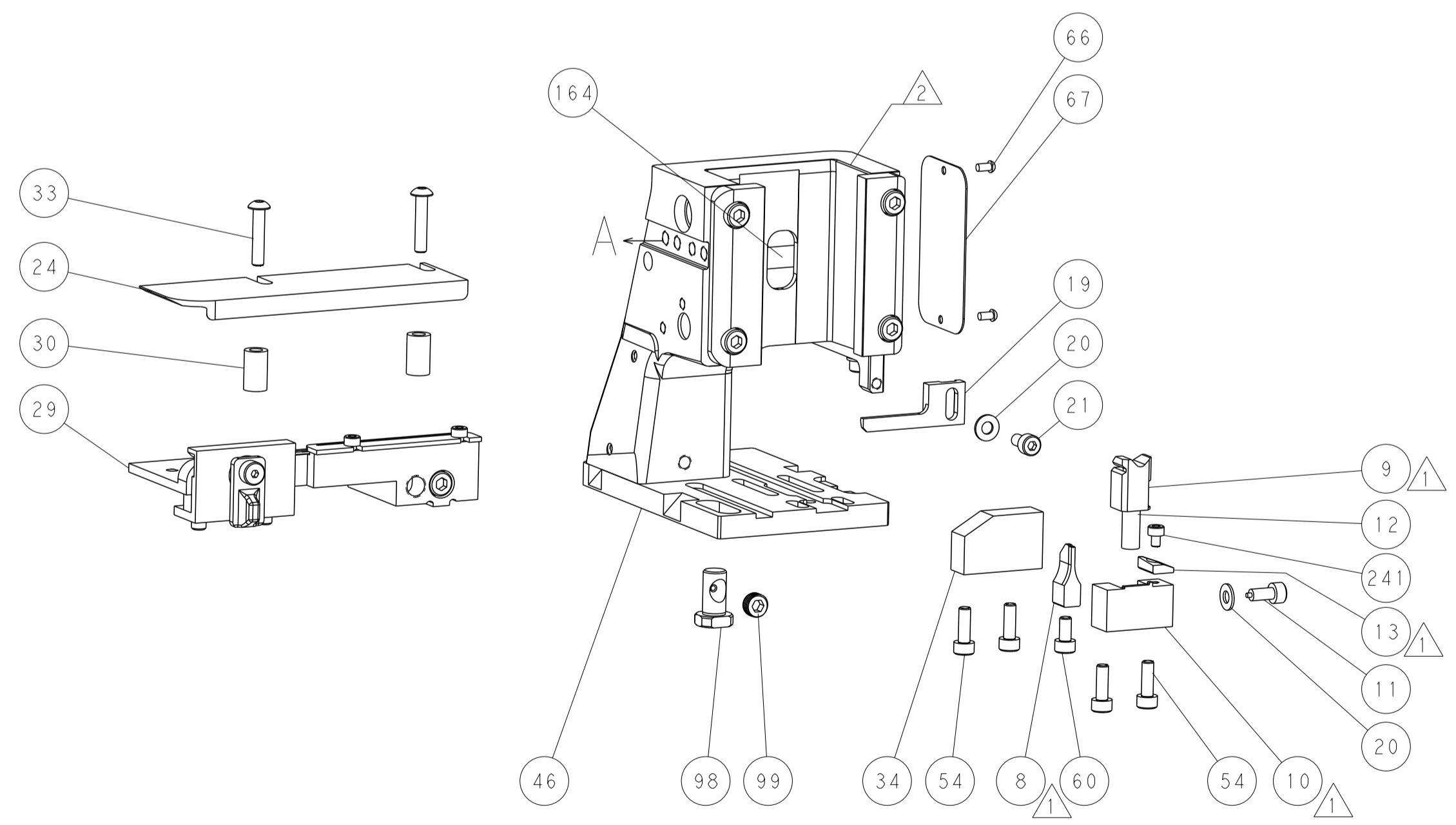
DETAIL A



TERMINAL SUPPORT LOCATION

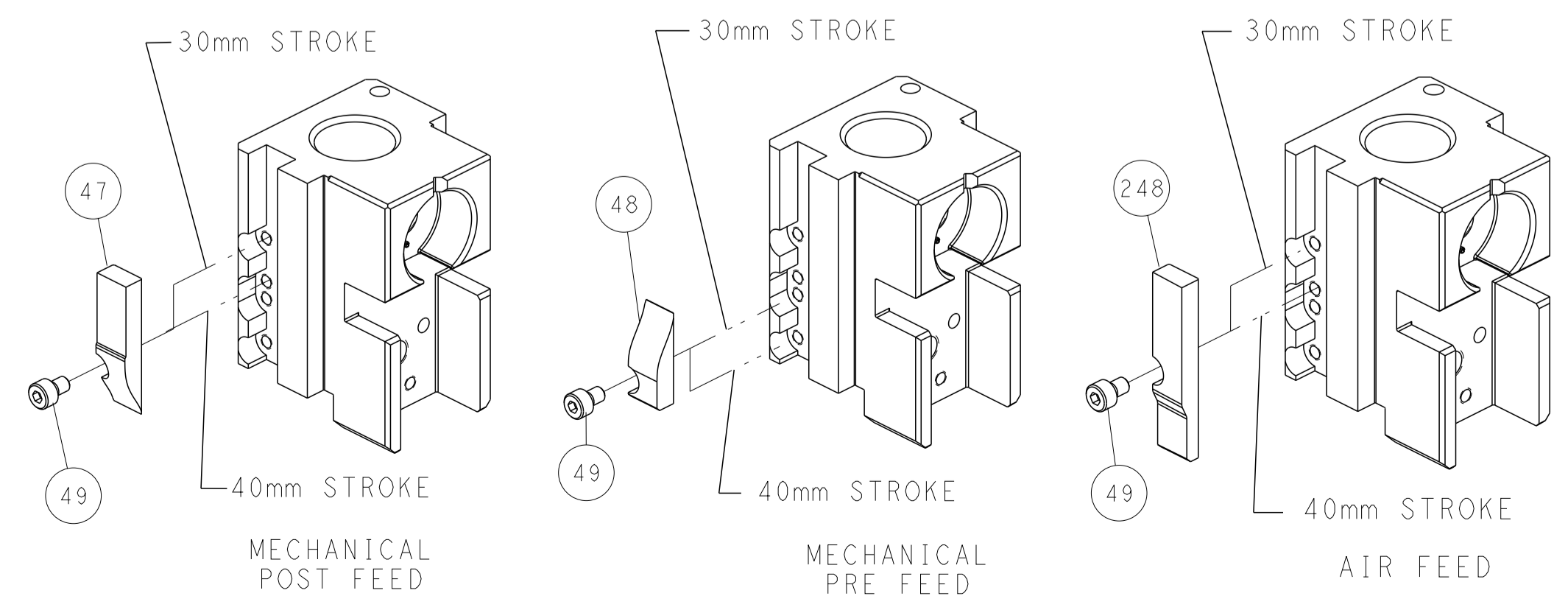


RAM SET-UP



FEED TRACK POSITION GUIDE BY INS. 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)

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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: 2151920	RESTRICTED TO: J
MATERIAL:		WEIGHT:	SCALE: 1:2 SHEET: 2 of 4 REV: J

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2151920-1	J	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2151920-2	J	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151920-7	D	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR  
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.40 mm [.055]	F
INSUL	1.52 mm [.060]	F

APPLICATOR INSTRUCTIONS  
408-35042

TERMINAL DATA: MOLEX TERMINAL MOLEX CRIMP SPECIFICATION  
TERMINAL NAME: MINI FIT JR OVERALL TIN FEMALE CRIMP TERMINAL

WIRE STRIP LENGTH	INSULATION DIAMETER RANGE
2.80-3.30 mm [.110-.130 IN]	Ø1.10-1.30 mm [.043-.051 IN]

TERMINAL APPLICATION SPECIFICATION  
ATS-639020200

TE TERMINAL	MOLEX TERMINAL	TE TERMINAL	MOLEX TERMINAL
1572221-1	39000046	1572222-9	39000145
1572221-2	39000065	1572222-5	39000221
1-1572221-1	39000091	1572222-6	39000432
1-1572221-2	39000139	1-1572222-0	40010854
1572221-7	39000183	1-1572222-1	98000175
1572221-8	39000209	1572222-1	39000048
1572221-9	39000215	1572222-2	39000067
1-1572221-8	39000434	1572222-4	39000128
1-1572221-9	46018-2541		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.35mm2 OR 22AWG	0.795+/-0.035 [.0315+/- .0014]	5.9
0.20mm2 OR 24AWG	0.735+/-0.035 [.029+/- .001]	6.3
0.12mm2 OR 26AWG	0.69+/-0.03 [.027+/- .001]	7.0
0.08mm2 OR 28AWG	0.66+/-0.03 [.026+/- .001]	7.4

- 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.

LOC	DIST	REV	DATE	BY	APPV
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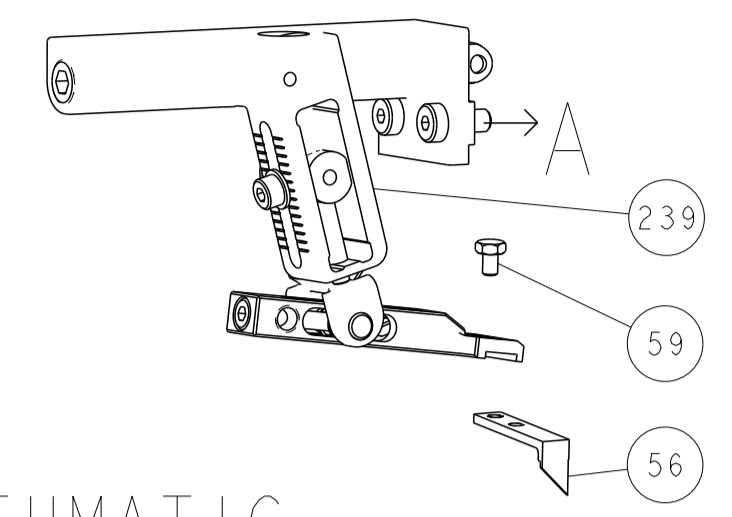
REV	DATE	BY	APPV	DESCRIPTION	ITEM NO
-	1	1	2119082-5	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
-	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	1	-	2844940-1	AIR 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	2844908-1	SCREW, LOCKING	99
-	1	1	2844907-1	POST, LOCKING	98
-	1	1	455888-6	SPACER, CRIMPER	82
-	1	1	1803607-3	DOCUMENTATION PACKAGE	71
-	1	1	2119791-9	DEPRESSOR, WIRE	70
-	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	2-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 14	53
-	1	1	1803382-6	HOLD DOWN, SPRING LOADED	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	1-1752356-9	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	2844992-1	ASSEMBLY, STRIP GUIDE	29
-	1	1	1320928-2	STRIP GUIDE	24
-	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	1-356885-3	STOP, SHEAR	11
-	1	1	2119805-1	SHEAR HOLDER, FRONT	10
-	1	1	1803095-3	FLOATING SHEAR, FRONT	9
-	1	1	1-1633917-4	ANVIL, COMBINATION	8
-	1	1	240641-1	SPACER	7
-	-	-	-	-	6
-	1	1	2119757-1	DEPRESSOR, SHEAR	5
-	1	1	238011-7	BLOCK, CRIMPER SPACER	4
-	1	1	6-1633961-8	CRIMPER, INSULATION F PREMIUM	3
-	1	1	455888-5	SPACER, CRIMPER	2
-	1	1	6-456402-4	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)

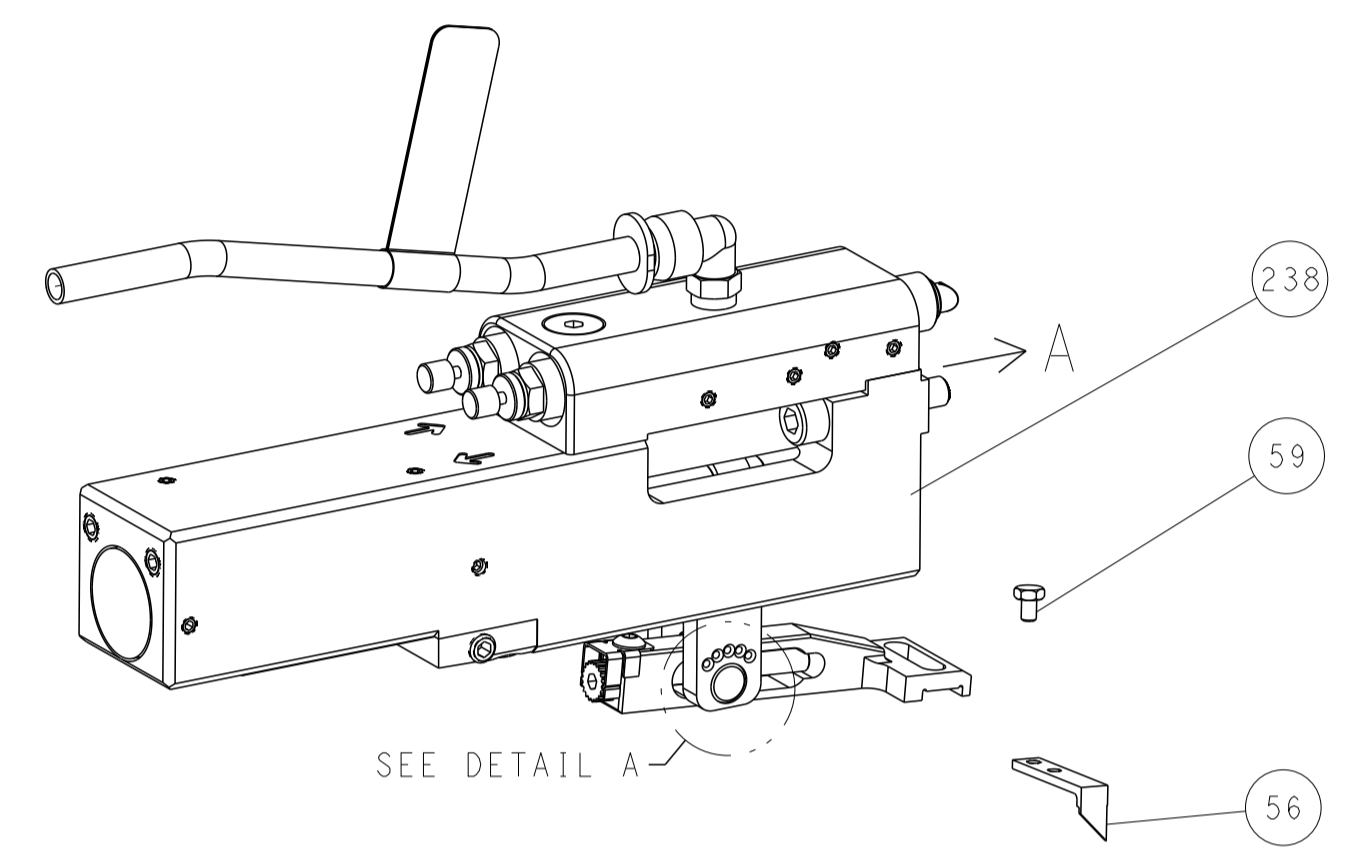
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DIMENSIONS: mm 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH	TOLERANCES UNLESS OTHERWISE SPECIFIED: ± ± ± ± ± ±	PRODUCT SPEC: APPLICATION SPEC: WEIGHT:	CUSTOMER ACCESSIBLE PRODUCTION DRAWING SCALE: 1:2 SHEET: 3 OF 4 REV: J

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

# FEED TYPE MECHANICAL



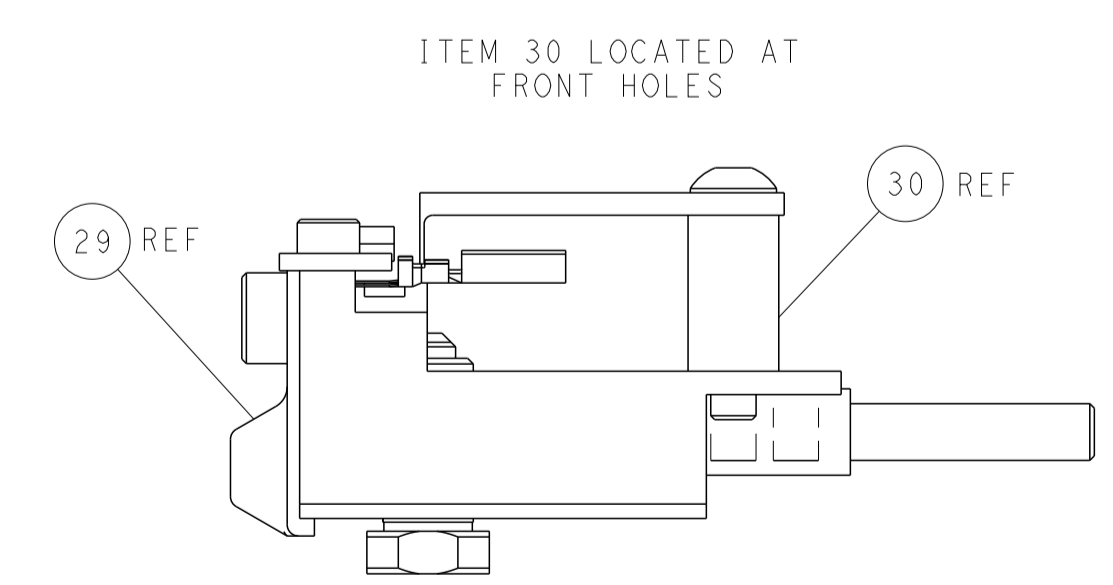
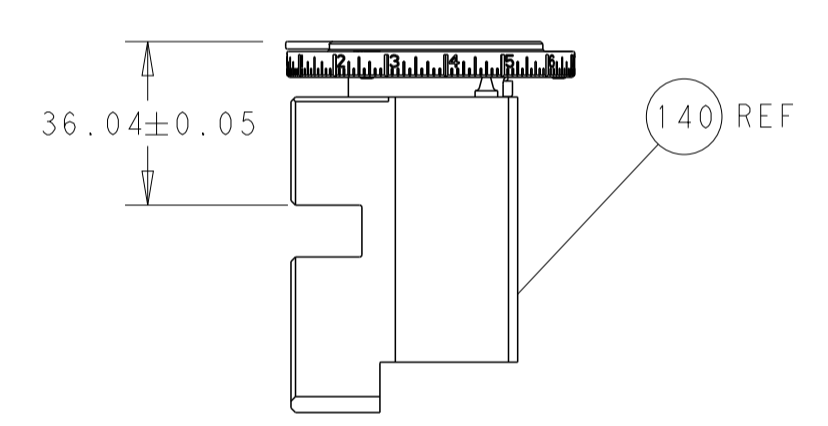
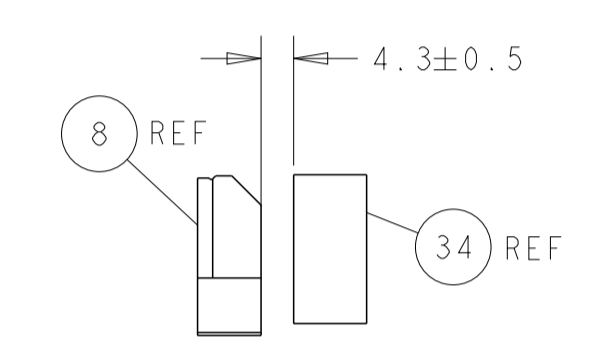
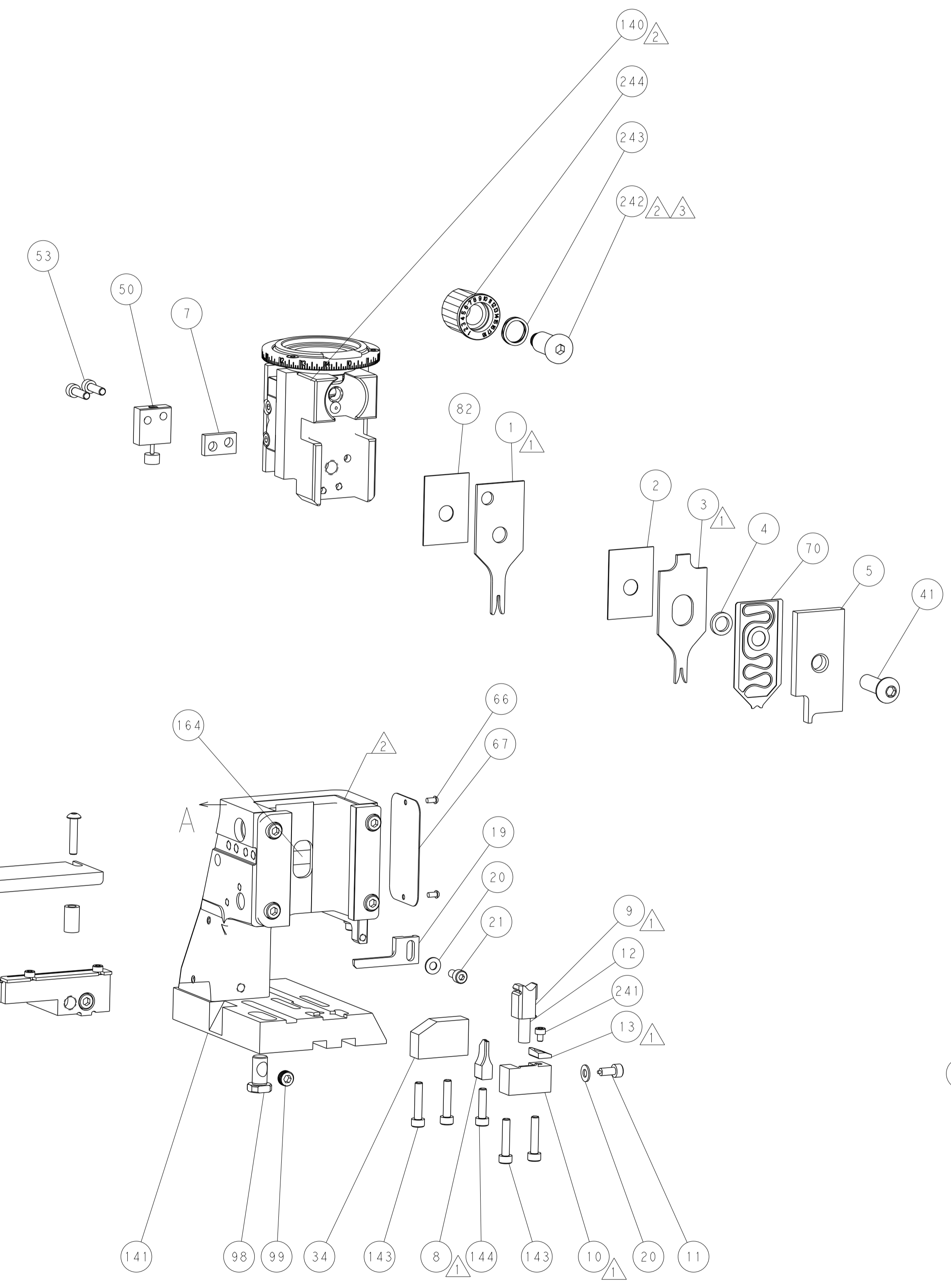
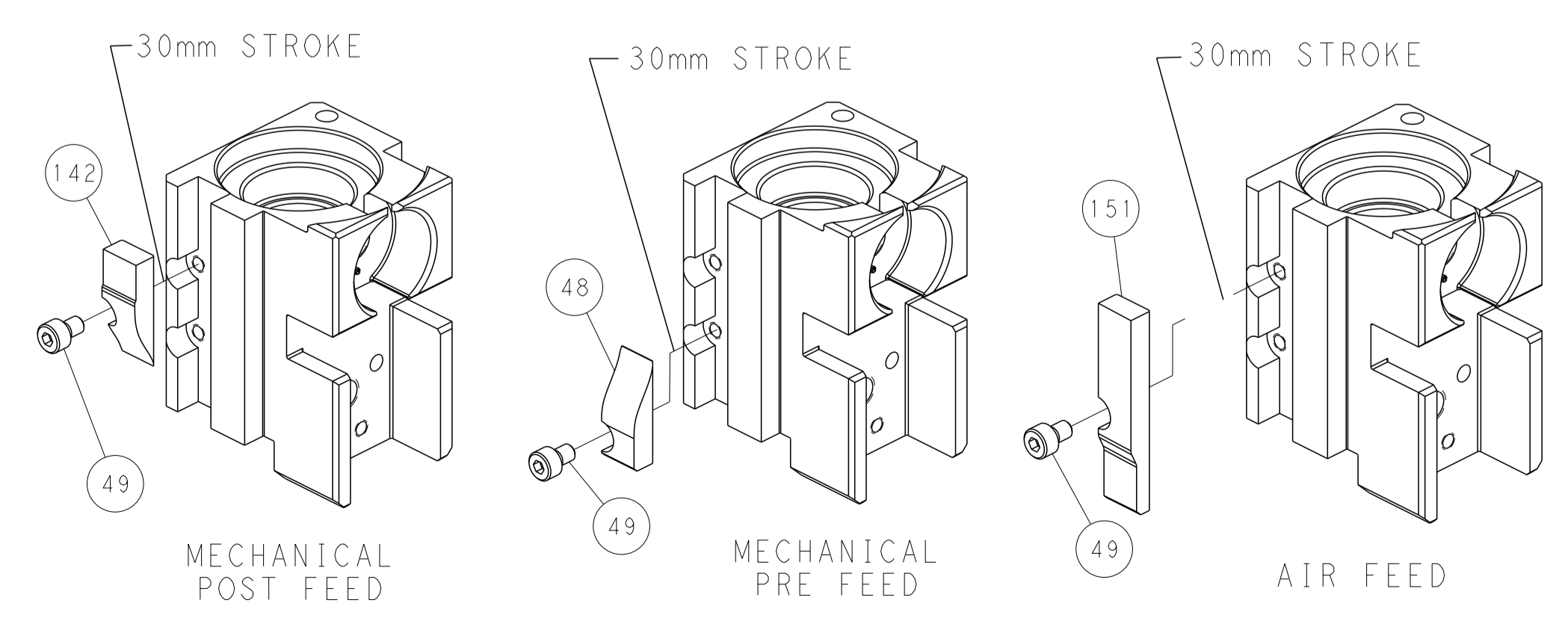
## PNEUMATIC



## 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)

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DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH	WEIGHT SCALE 1:2 SHEET 4 OF 4 REV J	SIZE CAGE CODE DRAWING NO A1 00779 C=2151920	RESTRICTED TO Customer Accessible Production Drawing