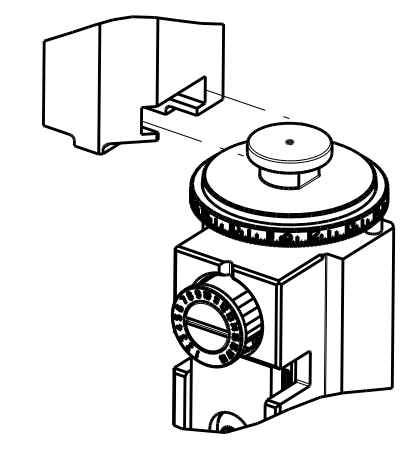


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151020-1	K	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2151020-2	K	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151020-1	K	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2151020-2	K	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2151020-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.40 mm [.055]	F
INSUL	1.57 mm [.062]	O

APPLICATOR INSTRUCTIONS
408-35042

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: CONTACT, MOD IV CRIMP SNAP-IN			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
3.58-4.78 mm [.141-.188 IN]		Ø0.00-1.75 mm [.000-.069 IN]	
TERMINAL APPLICATION SPECIFICATION	114-25003 Rev L		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
85969-6	141760-1	141600-1	87309-8
85969-2	1-141097-1	141600-5	87309-9
85969-7	166309-1	171275-1	1-87309-2
85969-8	166309-2	171275-2	87523-2
85969-9	166309-3	171275-4	87523-4
102680-1	166309-4	171275-5	87523-5
102680-2	166309-5	1-87195-7	1-87523-5
86492-2	167301-4	1-87195-9	1-87523-8
86492-4	1-167301-6	2-87195-0	2-87523-3
86492-6	2-167301-2	2-87195-3	6-87523-8
86492-9	2-167301-4	2-87195-4	
1-86492-0			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
20 AWG	0.83+/-0.11 [.033+/- .004]	7.5
22 AWG	0.78+/-0.06 [.031+/- .002]	8.4
24 AWG	0.74+/-0.095 [.029+/- .004]	9.2

***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.
- 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.
- TERMINAL LUBRICANT IS RECOMMENDED.
- 6. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.

LOC	DIST	REVISIONS			
A	66	REV	DATE	BY	CHKD
		G	16APR2018	TB	JDG
		H	28SEP2018	KH	TE
		J	10JUL2019	FZ	TE
		K	17JUL2020	FJ	RR

-	1	1	1	1	2280441-1	INSERT, SHEAR	282
-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248
-	1	1	1	1	2119082-9	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
-	2	2	2	2	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	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	455888-4	SPACER, CRIMPER	82
-	1	1	1	1	4-240641-1	SPACER	81
-	1	1	1	1	5-547505-2	SPRING, COMPRESSION	77
-	1	1	1	1	854769-4	HOLDER, INS	74
-	1	1	1	1	1803607-3	DOCUMENTATION PACKAGE	71
-	1	1	1	1	2119791-5	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	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	1-18023-3	SCR, SKT HD CAP M4 X 16.0	53
-	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
-	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	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
-	3	3	3	3	1-18028-2	WASHER, FLAT, REG M4	20
-	1	1	1	1	2119533-1	STRIPPER, SIDE FEED	19
-	1	1	1	1	690518-1	HOLD DOWN, TERMINAL	18
-	1	1	1	1	690463-1	FLOATING SHEAR, REAR	17
-	2	2	2	2	1-2168083-1	SCR, SKT HD CAP, RoHS, M3 X 6	16
-	1	1	1	1	1-690691-1	PLATE, REAR SHEAR	15
-	1	1	1	1	2119862-1	SHEAR HOLDER, REAR	14
-	1	1	1	1	2119806-1	INSERT, SHEAR	13
-	2	2	2	2	3-22280-3	SPRING, COMPRESSION	12
-	2	2	2	2	1-356885-4	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	1338701-1	ANVIL, COMBINATION	8
-	1	1	1	1	690468-1	DEPRESSOR SHEAR, REAR	6
-	1	1	1	1	2119780-1	DEPRESSOR, SHEAR	5
-	1	1	1	1	2-238011-2	BLOCK, CRIMPER SPACER	4
1	2	2	1	1	1633966-6	CRIMPER, INSULATION O	3
-	1	1	1	1	455888-3	SPACER, CRIMPER	2
1	2	2	1	1	3-456402-1	CRIMPER, WIRE PREMIUM	1

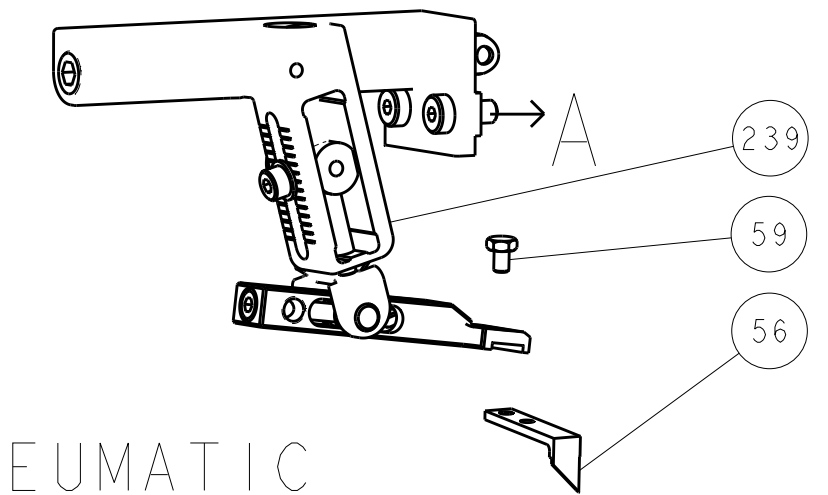
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		MATERIAL:		FINISH:	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES ±	

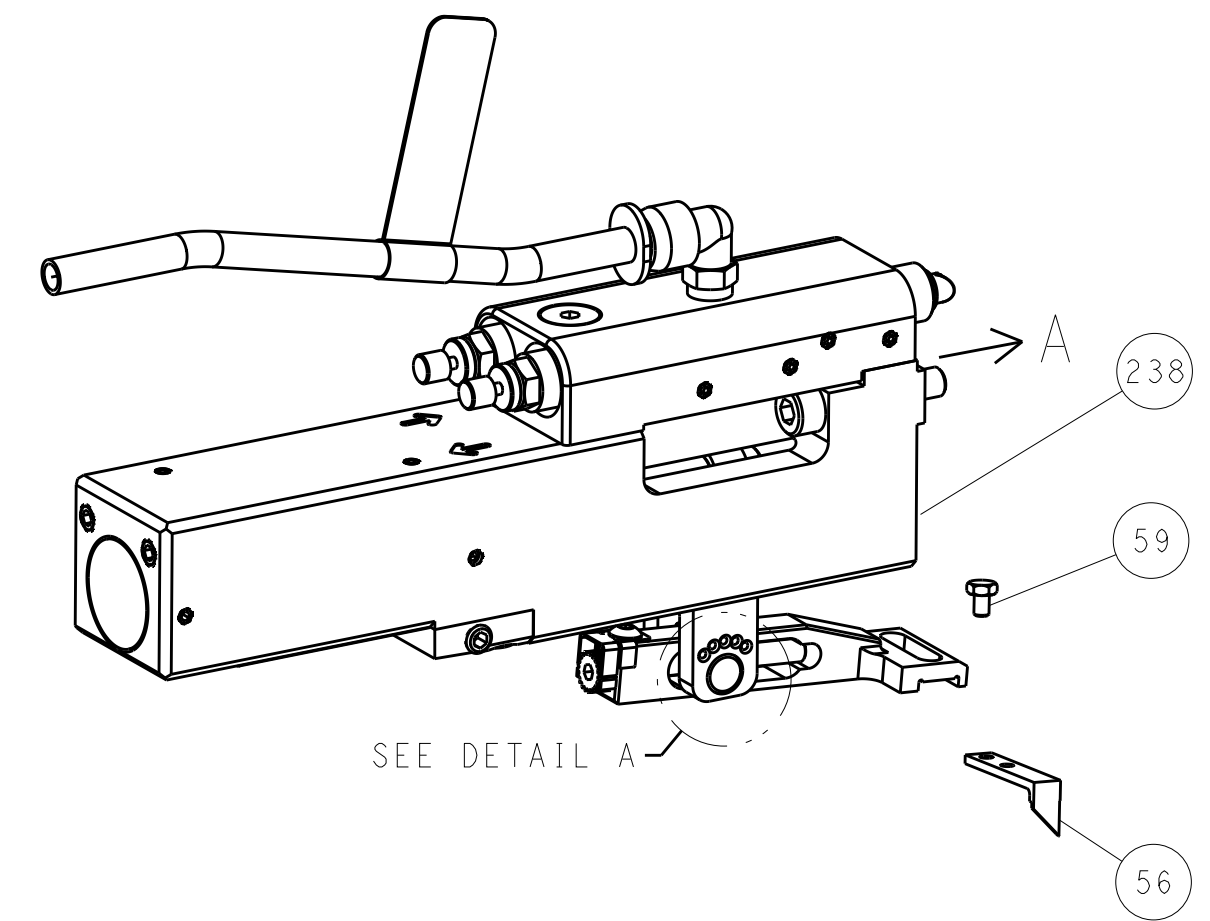
DATE	01OCT2011	CHKD	STAKEM
DATE	07OCT2011	CHKD	G. BAILEY
DATE	07OCT2011	APVD	T. ERLIN
NAME	Ocean Side Feed Applicator		
SIZE	A1	CAGE CODE	00779
DRAWING NO	C=2151020		RESTRICTED TO
SCALE	1:2	SHEET	1 OF 4
REV	K		

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

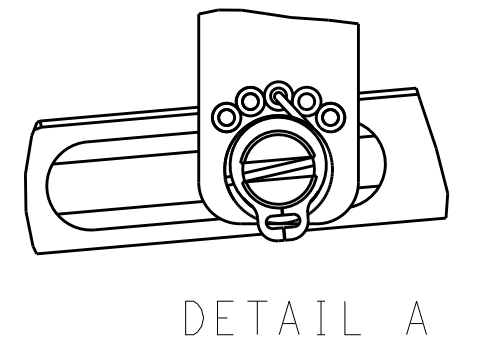
FEED TYPE MECHANICAL



PNEUMATIC

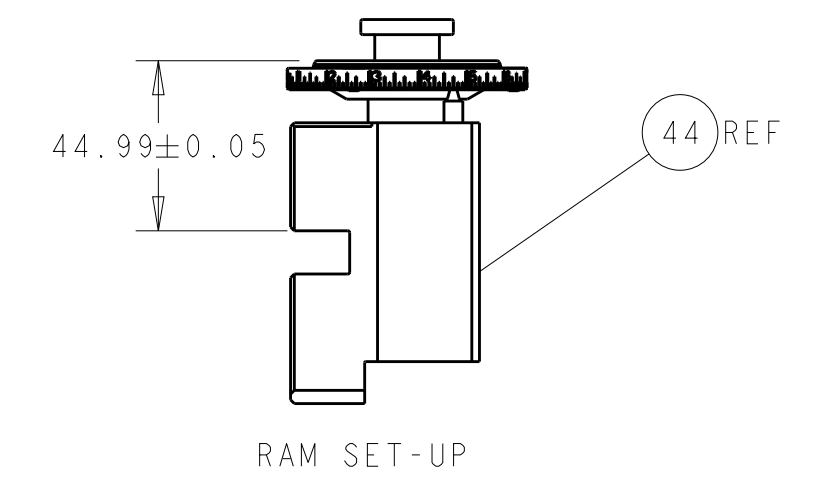
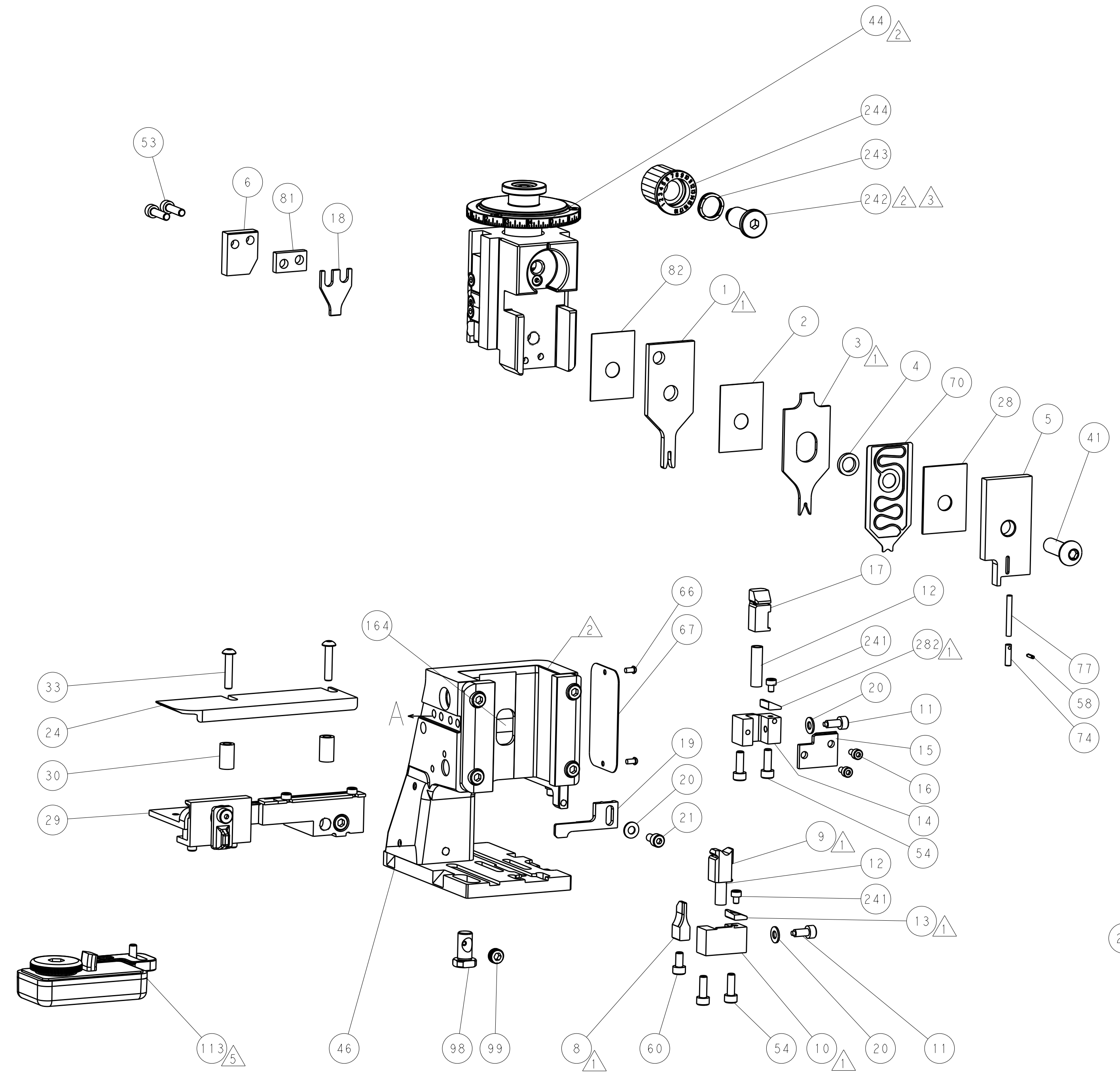
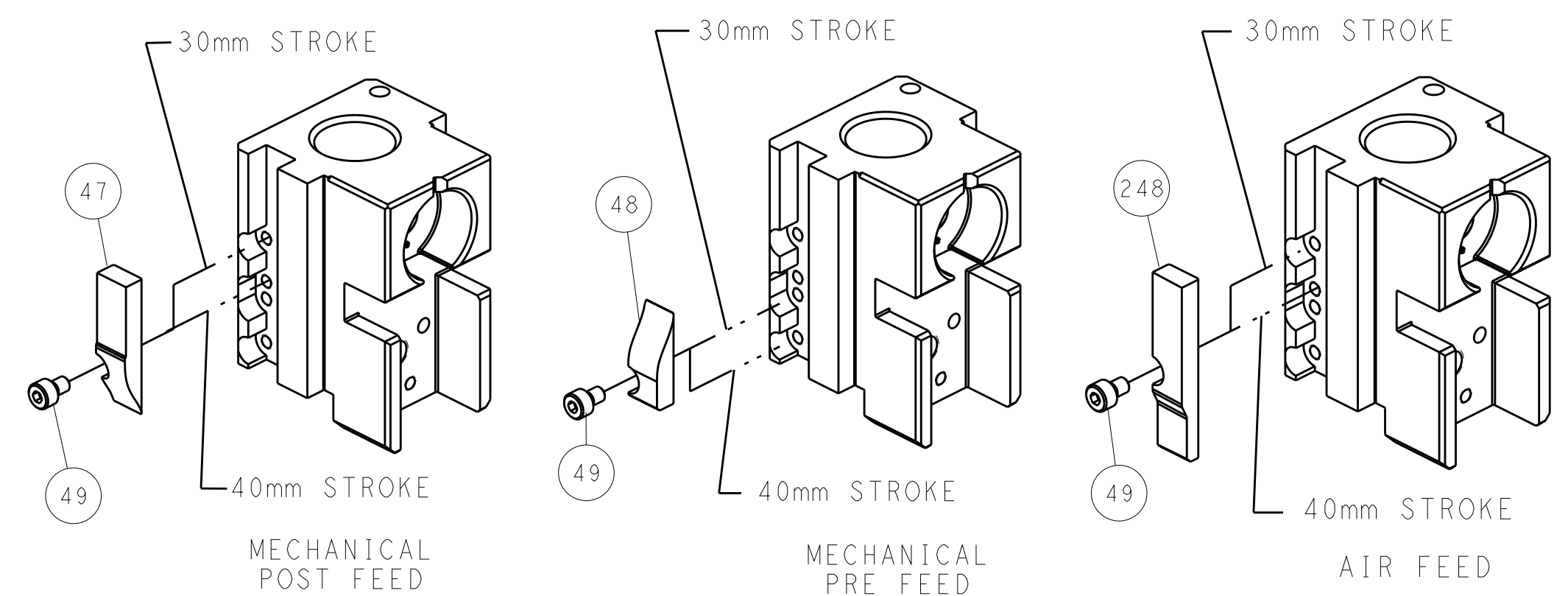


FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)

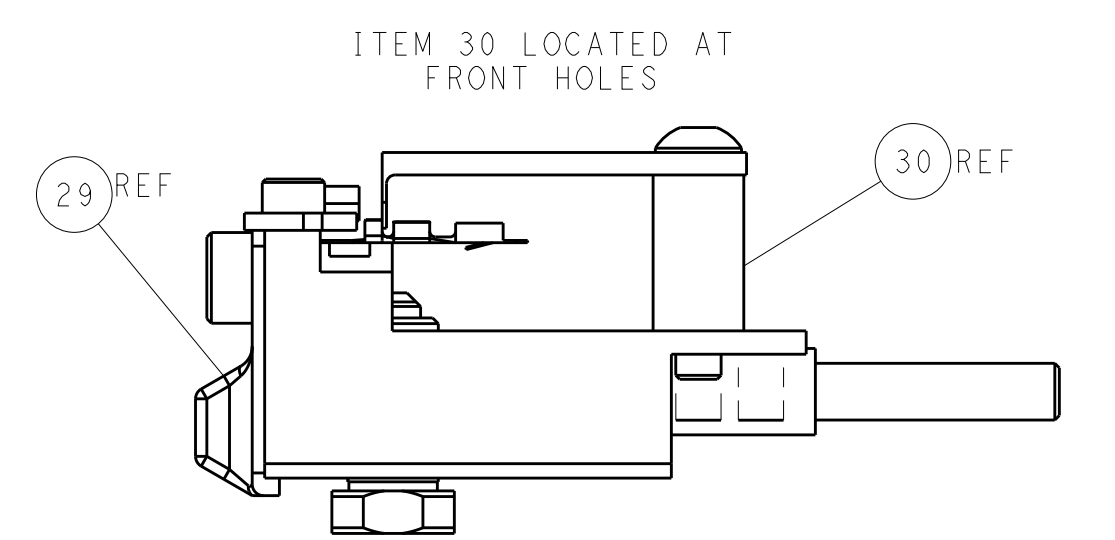


DETAIL A

CAM POSITIONS



RAM SET-UP



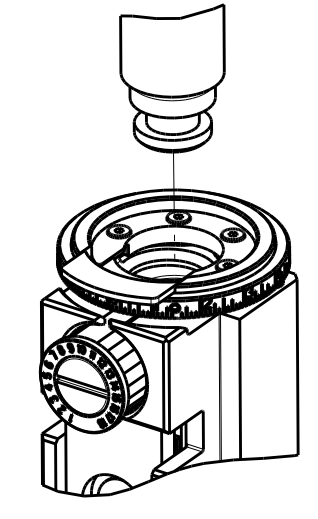
FEED TRACK POSITION GUIDE BY INSULATION BARREL

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

<small>THE INFORMATION CONTAINED HEREIN IS UNCLASSIFIED EXCEPT WHERE SHOWN OTHERWISE. IT IS THE PROPERTY OF TYCO ELECTRONICS CORPORATION AND IS LOANED TO YOUR ORGANIZATION FOR YOUR INFORMATION ONLY. IT IS TO BE RETURNED TO TYCO ELECTRONICS CORPORATION UPON THE COMPLETION OF YOUR PROJECT OR AS OTHERWISE SPECIFIED.</small>		DWN: STAKEM 07OCT2011 CHK: G. BAILEY 07OCT2011 APVD: T. ERLIN 07OCT2011	TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		NAME: Ocean Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2151020	RESTRICTED TO: - SCALE: 1:2 SHEET: 2 of 4 REV: K
MATERIAL: - FINISH: -		WEIGHT: - Customer Accessible Production Drawing	

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2151020-1	K	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2151020-2	K	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151020-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
 INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.40 mm [.055]	F
INSUL	1.57 mm [.062]	O

APPLICATOR INSTRUCTIONS
 408-35042

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: CONTACT, MOD IV CRIMP SNAP-IN			
WIRE STRIP LENGTH 3.58-4.78 mm [.141-.188 IN]		INSULATION DIAMETER RANGE Ø0.00-1.75 mm [.000-.069 IN]	
TERMINAL APPLICATION SPECIFICATION 114-25003 Rev L			
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
85969-6	141760-1	141600-1	87309-8
85969-2	1-141097-1	141600-5	87309-9
85969-7	166309-1	171275-1	1-87309-2
85969-8	166309-2	171275-2	87523-2
85969-9	166309-3	171275-4	87523-4
102680-1	166309-4	171275-5	87523-5
102680-2	166309-5	1-87195-7	1-87523-5
86492-2	167301-4	1-87195-9	1-87523-8
86492-4	1-167301-6	2-87195-0	2-87523-3
86492-6	2-167301-2	2-87195-3	6-87523-8
86492-9	2-167301-4	2-87195-4	
1-86492-0			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
20 AWG	0.83 +/- 0.11 [.033 +/- .004]	7.5
22 AWG	0.78 +/- 0.06 [.031 +/- .002]	8.4
24 AWG	0.74 +/- 0.095 [.029 +/- .004]	9.2

- 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 TERMINAL LUBRICANT IS RECOMMENDED.
6. 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
-	-	-	-	SEE SHEET 1	-	-	-

-	1	1	2280441-1	INSERT, SHEAR	282	
-	1	1	2119082-9	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
-	2	2	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	
5	-	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	455888-4	SPACER, CRIMPER	82	
-	1	1	4-240641-1	SPACER	81	
-	1	1	5-547505-2	SPRING, COMPRESSION	77	
-	1	1	854769-4	HOLDER, INS	74	
-	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	
-	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	1-18023-3	SCR, SKT HD CAP M4 X 16.0	53	
-	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	
-	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	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	
-	3	3	1-18028-2	WASHER, FLAT, REG M4	20	
-	1	1	2119533-1	STRIPPER, SIDE FEED	19	
-	1	1	690518-1	HOLD DOWN, TERMINAL	18	
-	1	1	690463-1	FLOATING SHEAR, REAR	17	
-	2	2	1-2168083-1	SCR, SKT HD CAP, RoHS, M3 X 6	16	
1	-	1	1	1-690691-1	PLATE, REAR SHEAR	15
1	-	1	1	2119862-1	SHEAR HOLDER, REAR	14
1	-	1	1	2119806-1	INSERT, SHEAR	13
-	2	2	3-22280-3	SPRING, COMPRESSION	12	
-	2	2	1-356885-4	STOP, SHEAR	11	
-	1	1	2119805-1	SHEAR HOLDER, FRONT	10	
1	-	1	1	1803095-3	FLOATING SHEAR, FRONT	9
1	1	1	1	1338701-1	ANVIL, COMBINATION	8
-	1	1	1	690468-1	DEPRESSOR SHEAR, REAR	6
-	1	1	1	2119780-1	DEPRESSOR, SHEAR	5
-	1	1	1	2-238011-2	BLOCK, CRIMPER SPACER	4
1	1	1	1	1633966-6	CRIMPER, INSULATION O	3
-	1	1	1	455888-3	SPACER, CRIMPER	2
1	1	1	1	3-456402-1	CRIMPER, WIRE PREMIUM	1

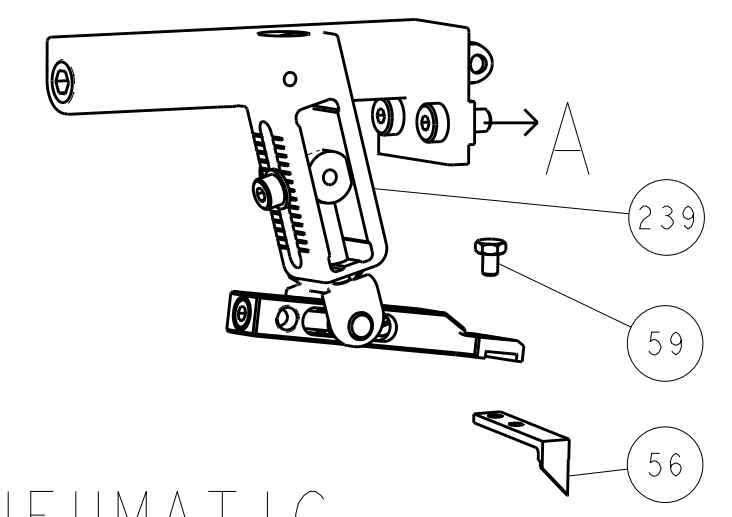
PACIFIC VERSION
 Shown on sheets 3 of 4 & 4 of 4
 (Atlantic version shown on sheets 1 of 4 & 2 of 4)

DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DRAWN: STAKEM 07OCT2011		CHK: G. BAILEY 07OCT2011		APVD: T. ELBIN 07OCT2011		NAME: Ocean Side Feed Applicator	
0 PLC ±		1 PLC ±		2 PLC ±		3 PLC ±		4 PLC ±		RESTRICTED TO	
MATERIAL:		FINISH:		WEIGHT:		SCALE: 1:2		SHEET 3 OF 4		REV K	

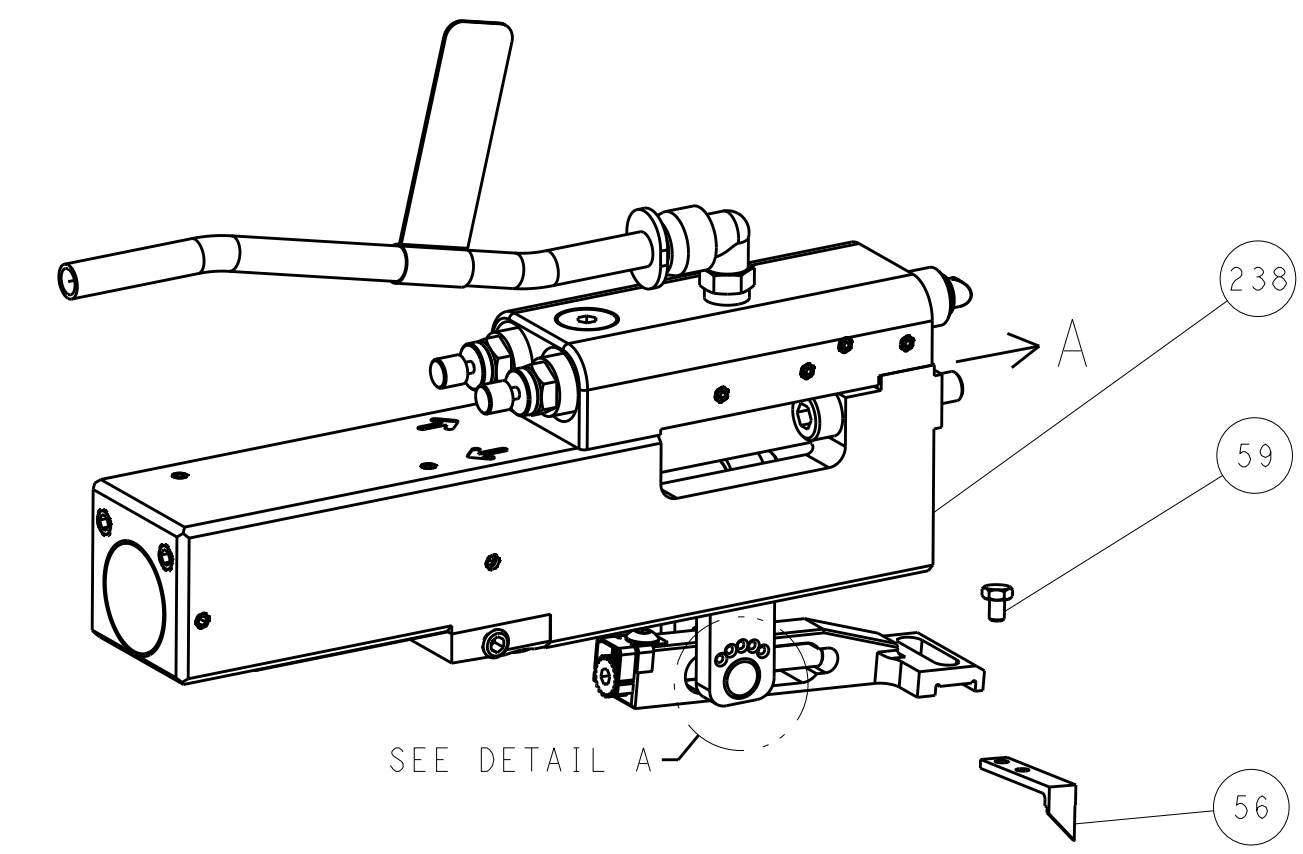
Customer Accessible Production Drawing

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

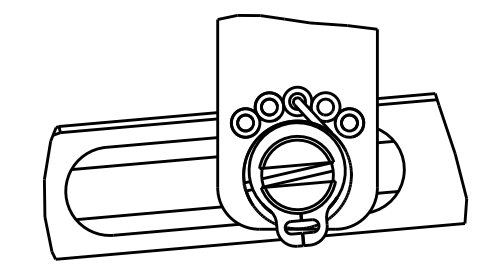
FEED TYPE MECHANICAL



PNEUMATIC

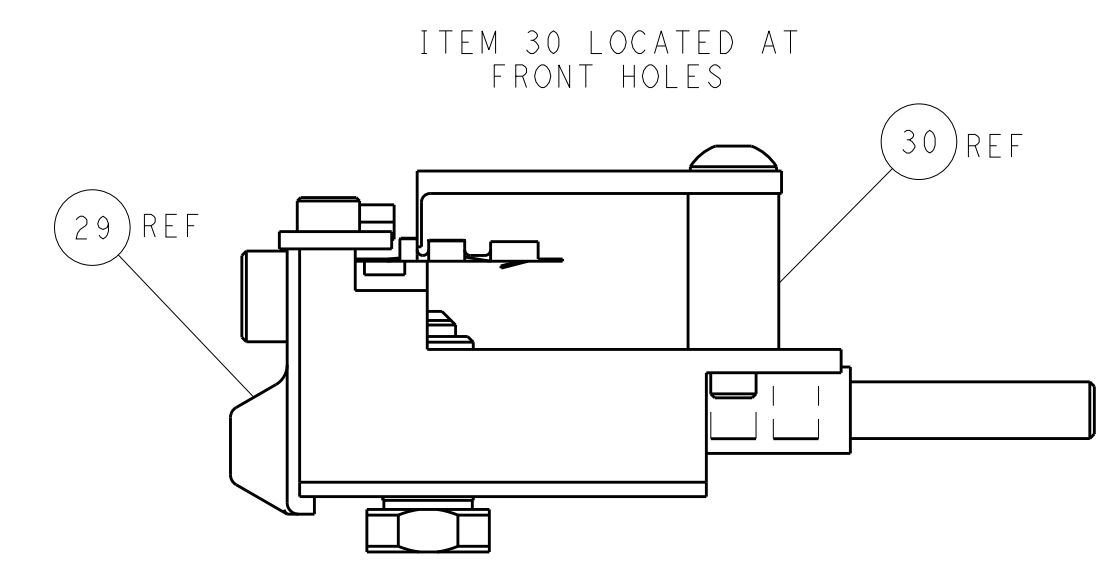
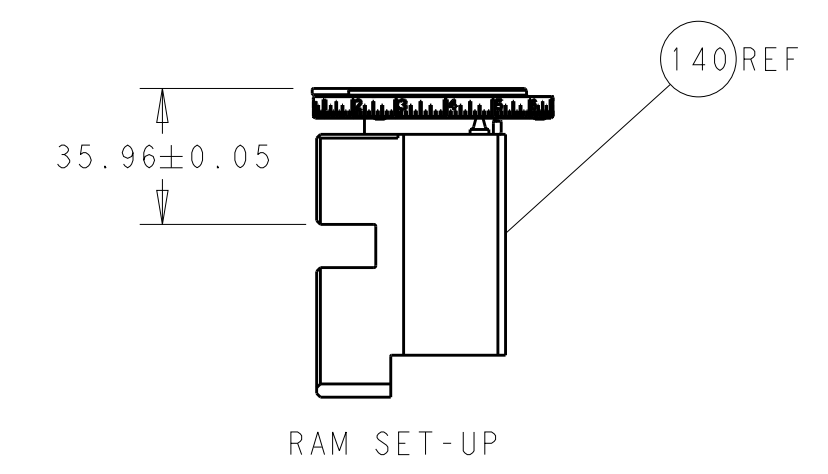
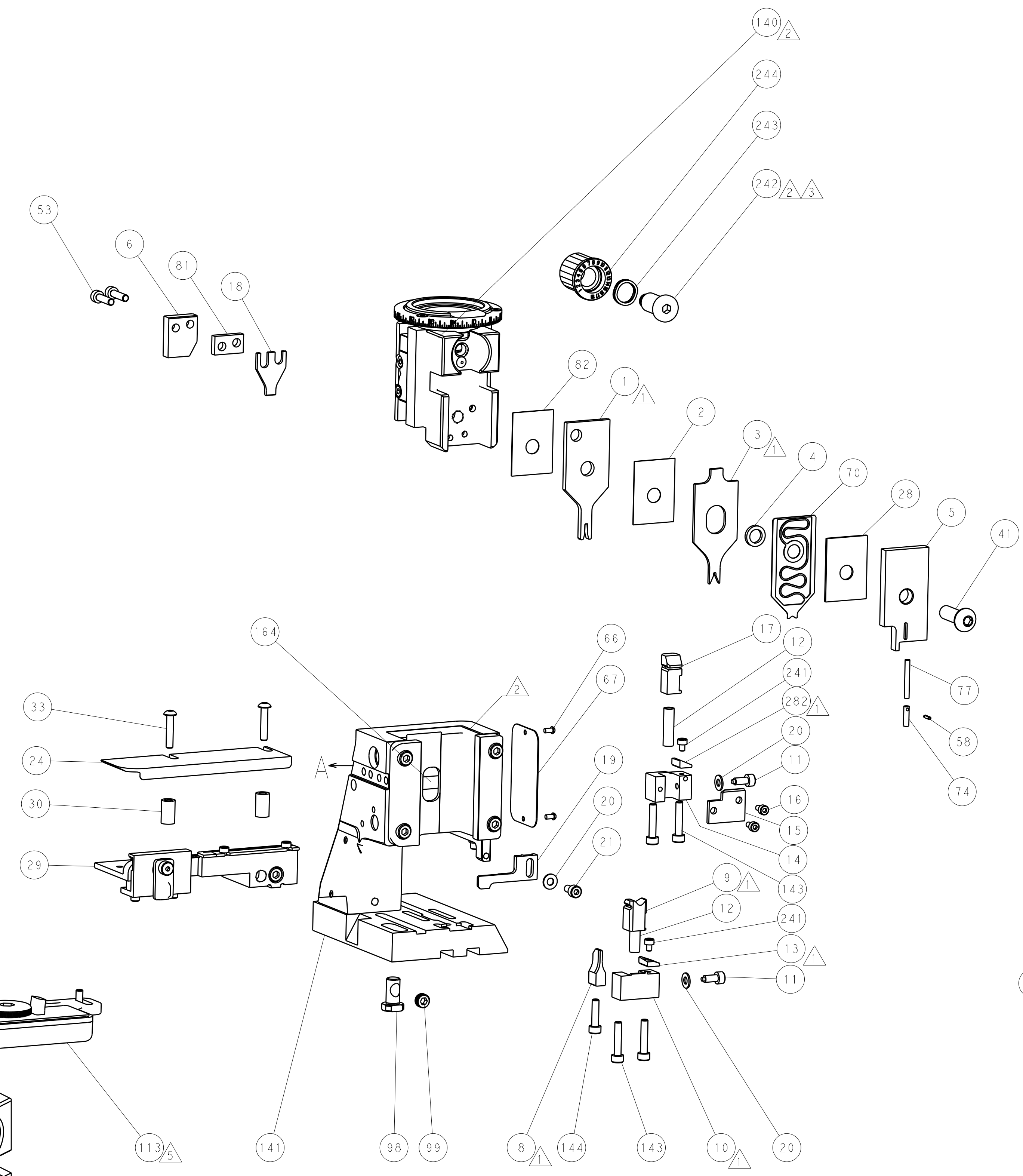
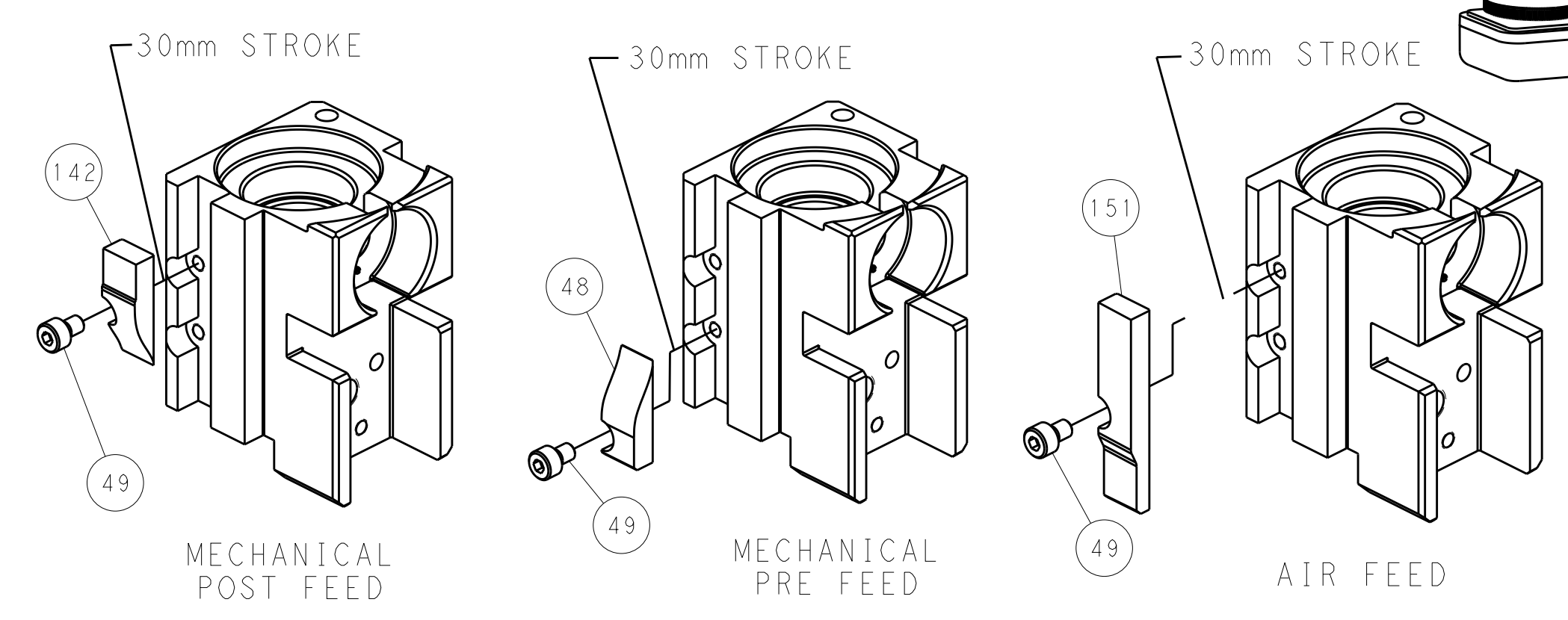


FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



DETAIL A

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 ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH		DWN: R. STAKEM 07OCT2011 CHK: G. BAILEY 07OCT2011 APVD: T. ERLIN 07OCT2011 PRODUCT SPEC APPLICATION SPEC WEIGHT Customer Accessible Production Drawing		NAME: Ocean Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: C-2151020 SCALE: 1:2 SHEET: 4 OF 4 REV: K	
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