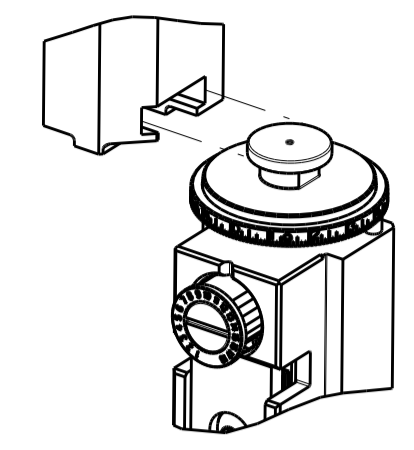


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151206-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2151206-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151206-1	B	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2151206-2	B	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2151206-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.29 mm [.090]	F
INSUL	3.56 mm [.140]	F

APPLICATOR INSTRUCTIONS
408-35042

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: MULTILOCK CONTACT			
WIRE STRIP LENGTH 4.00-5.00 mm [.157-.197 IN]		INSULATION DIAMETER RANGE Ø2.16-3.43 mm [.085-.135 IN]	
TERMINAL APPLICATION SPECIFICATION 114-5004			
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
170286-1	170286-2	170286-3	170286-4

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
2.00mm ²	1.78+/-0.05 [.070+/- .002]	4.2
2 X 0.5mm ²	1.50+/-0.05 [.059+/- .002]	7.1
0.85mm ² + 0.5mm ²	1.50+/-0.05 [.059+/- .002]	7.2
1.25mm ²	1.50+/-0.05 [.059+/- .002]	7.2
0.85mm ²	1.34+/-0.05 [.053+/- .002]	8.8
0.50mm ²	1.30+/-0.05 [.051+/- .002]	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. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- 6 TERMINAL LUBRICANT IS RECOMMENDED.

***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	P	LTN	DESCRIPTION	DATE	OWN	APVD
		A		RELEASED	04DEC2015	LG	GB
		A1		ECR-17-012078	18AUG2017	RS	LZ
		B		ECR-19-006784	28APR2019	FZ	TE

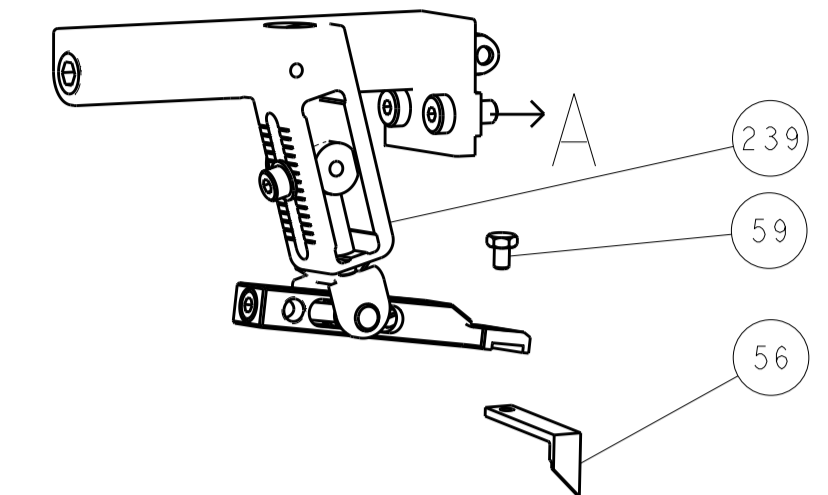
-	1	-	1	-	2119640-1	PUSH ROD, AIR FEED	250					
-	1	-	1	-	1803259-1	BUSHING, FLANGED	249					
-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248					
-	1	1	1	1	2119082-4	CAM, SNAIL, INSULATION ADJUSTMENT	244					
-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243					
3	-	1	1	1	2119083-1	RETAINER, INSULATION 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					
6	-	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	1803607-1	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	1338683-8	FEED PAWL	56					
-	4	4	4	4	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	54					
-	2	2	2	2	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	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	1752356-3	SUPPORT, TERMINAL	34					
-	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33					
-	2	2	2	2	3-2844962-2	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					
-	2	2	2	2	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	1803095-6	FLOATING SHEAR, FRONT	9					
1	1	2	2	1	1	2-1633921-2	ANVIL, COMBINATION	8				
-	1	1	1	1	1-240641-1	SPACER	7					
1	-	-	-	-	-	-	6					
-	1	1	1	1	2119757-8	DEPRESSOR, SHEAR	5					
-	1	1	1	1	238011-8	BLOCK, CRIMPER SPACER	4					
1	1	2	2	1	1	2-2119582-4	CRIMPER, INSULATION F PREMIUM	3				
-	1	1	1	1	455888-6	SPACER, CRIMPER	2					
1	1	2	2	1	1	2-456406-3	CRIMPER, WIRE PREMIUM	1				
-	77	-	72	-	71	-	2	-	1	PART NO	DESCRIPTION	ITEM NO

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

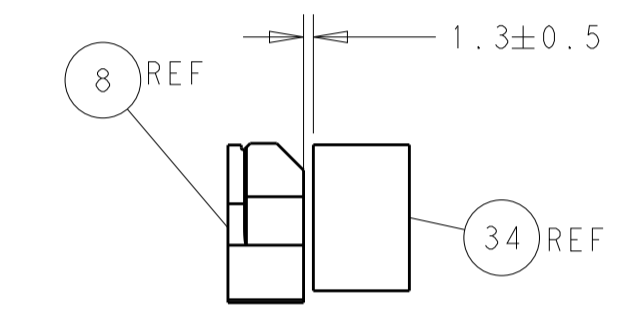
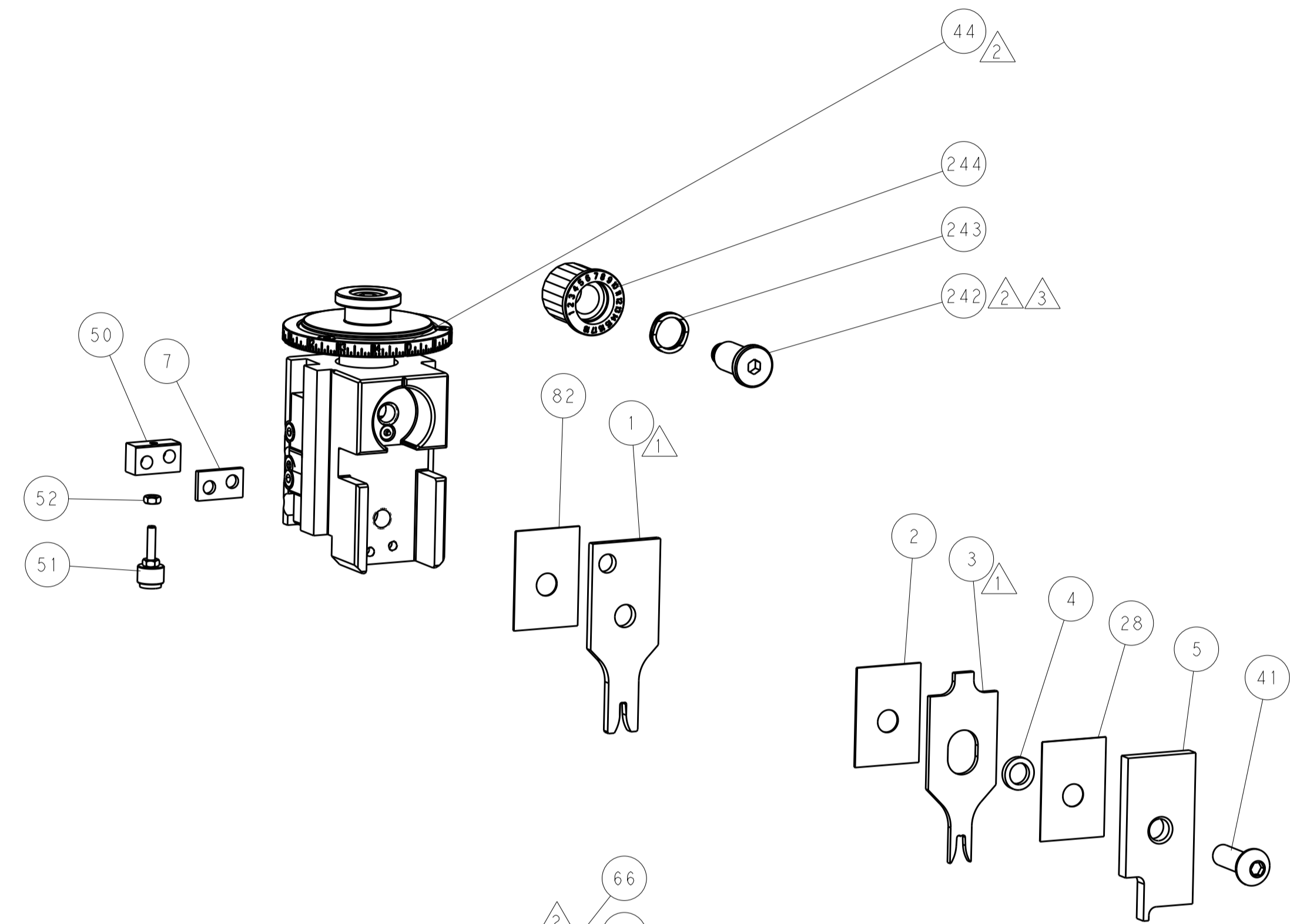
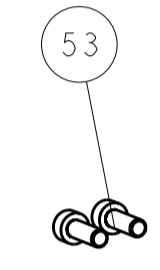
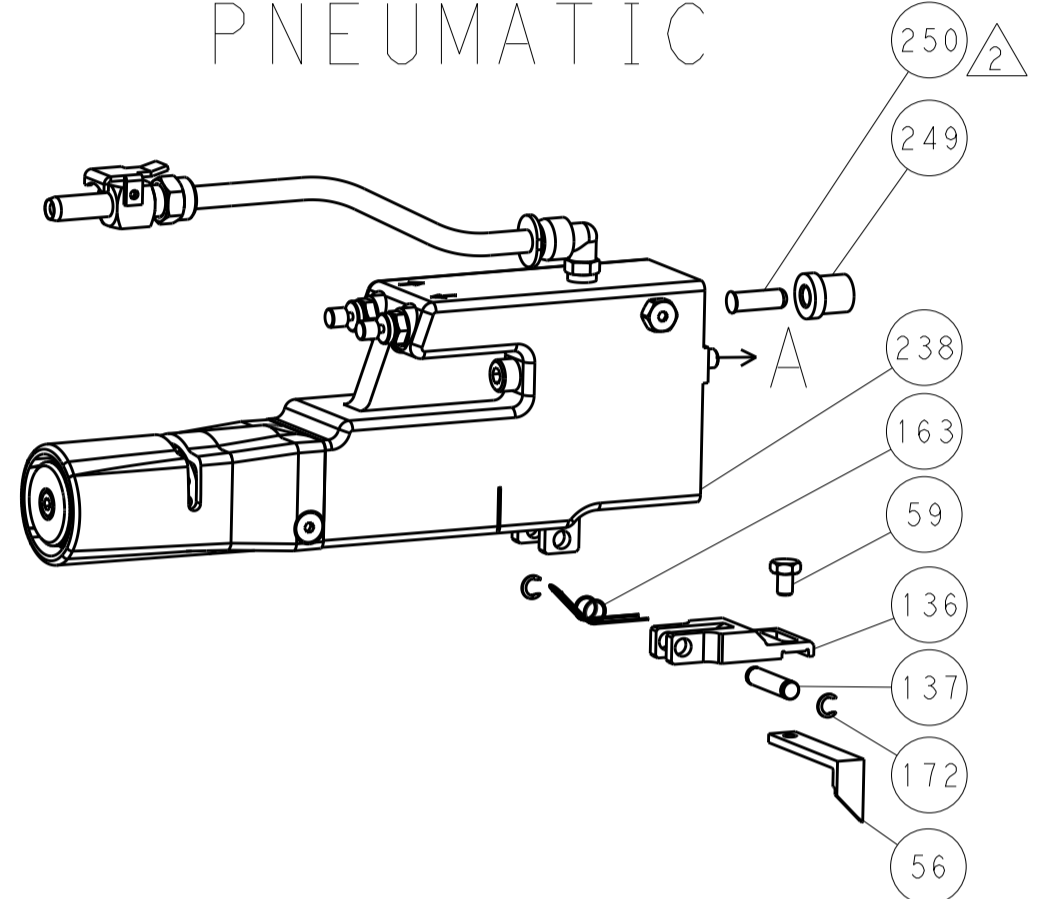
OWN	X. ZHAO	16OCT2015
CHK	L. ZHANG	16OCT2015
APVD	H. GUO	16OCT2015
PRODUCT SPEC		
APPLICATION SPEC		
SIZE	A1	00779
CAGE CODE	C=2151206	
DRAWING NO	Customer Accessible Production Drawing	
SCALE	1:2	SHEET 1 OF 4
REV	B	

LOC	DIST	REV	DATE	BY	APP'D
A	66				

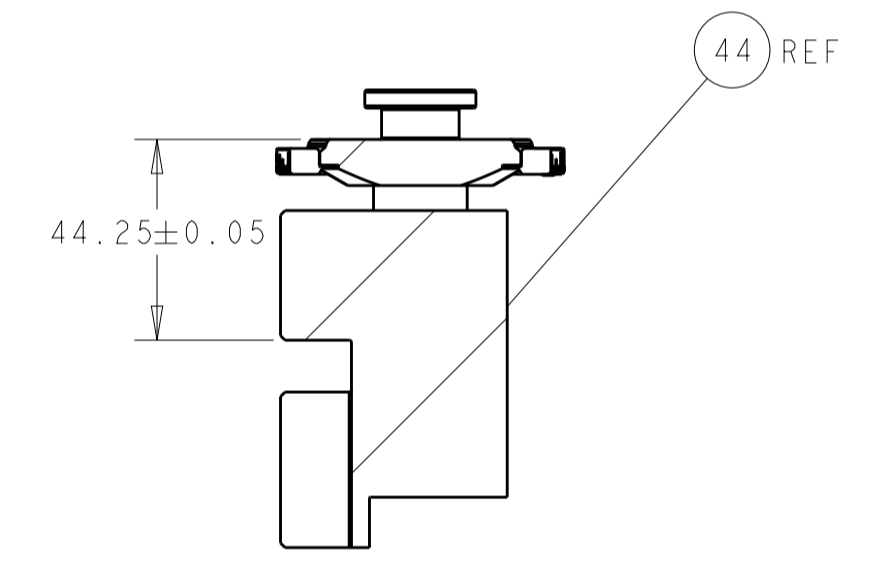
FEED TYPE MECHANICAL



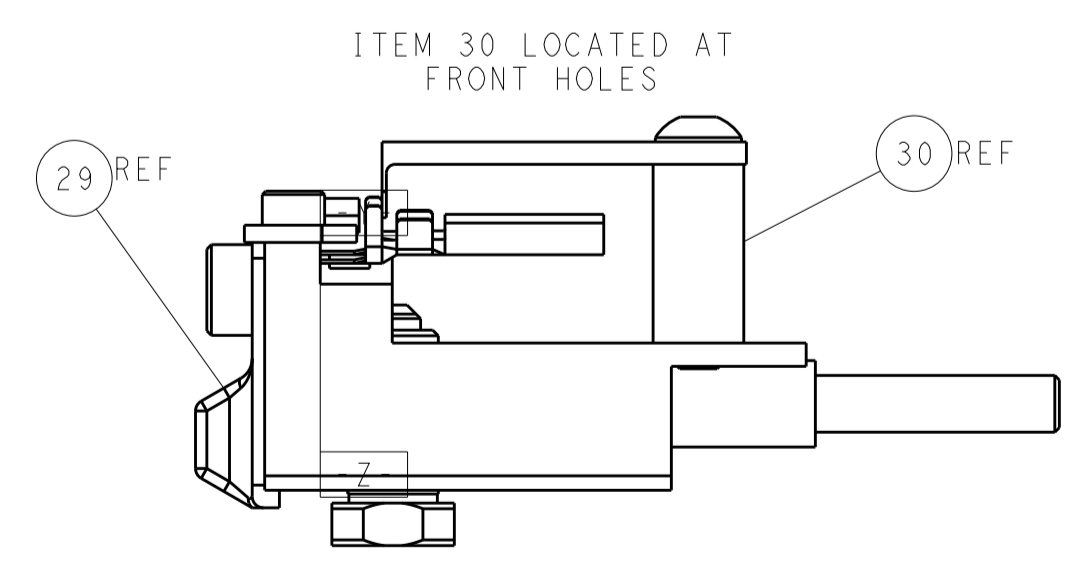
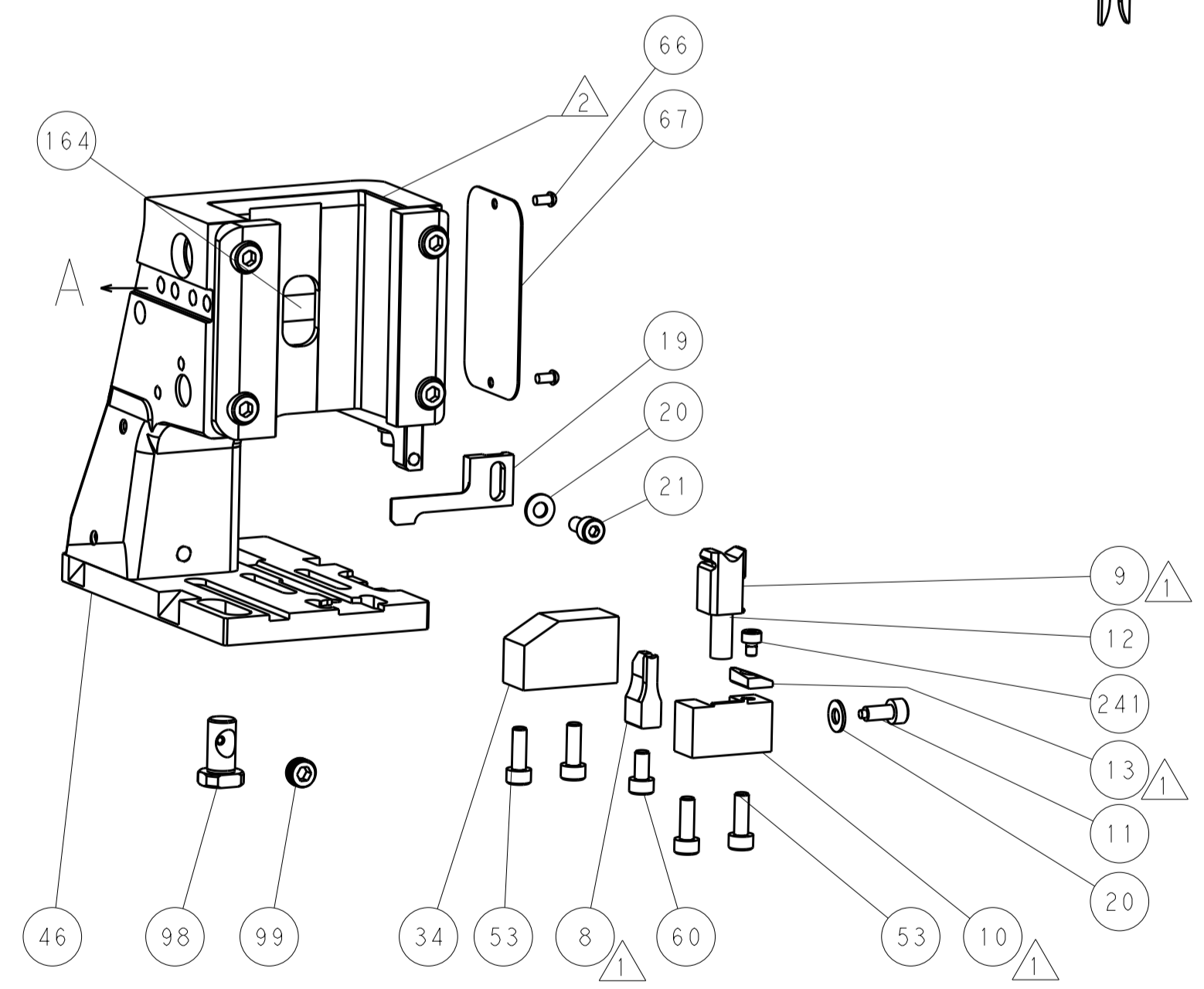
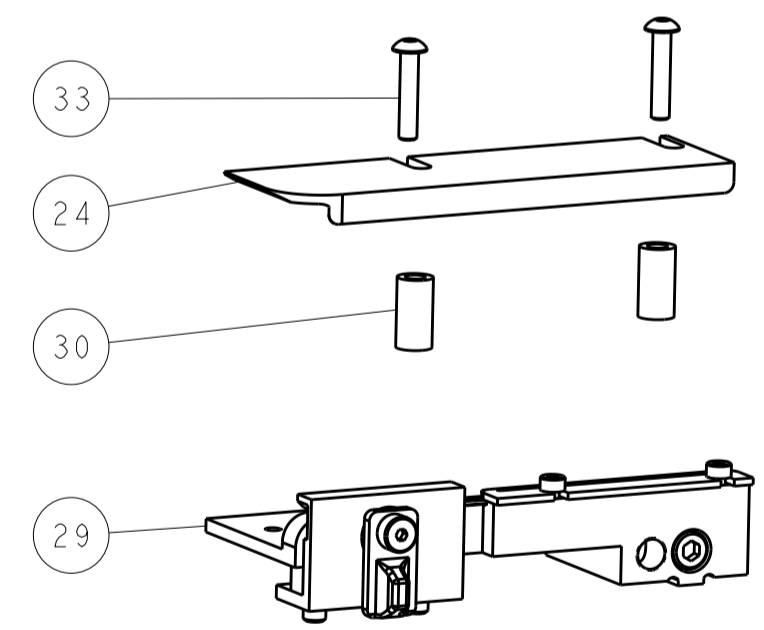
PNEUMATIC



TERMINAL SUPPORT LOCATION

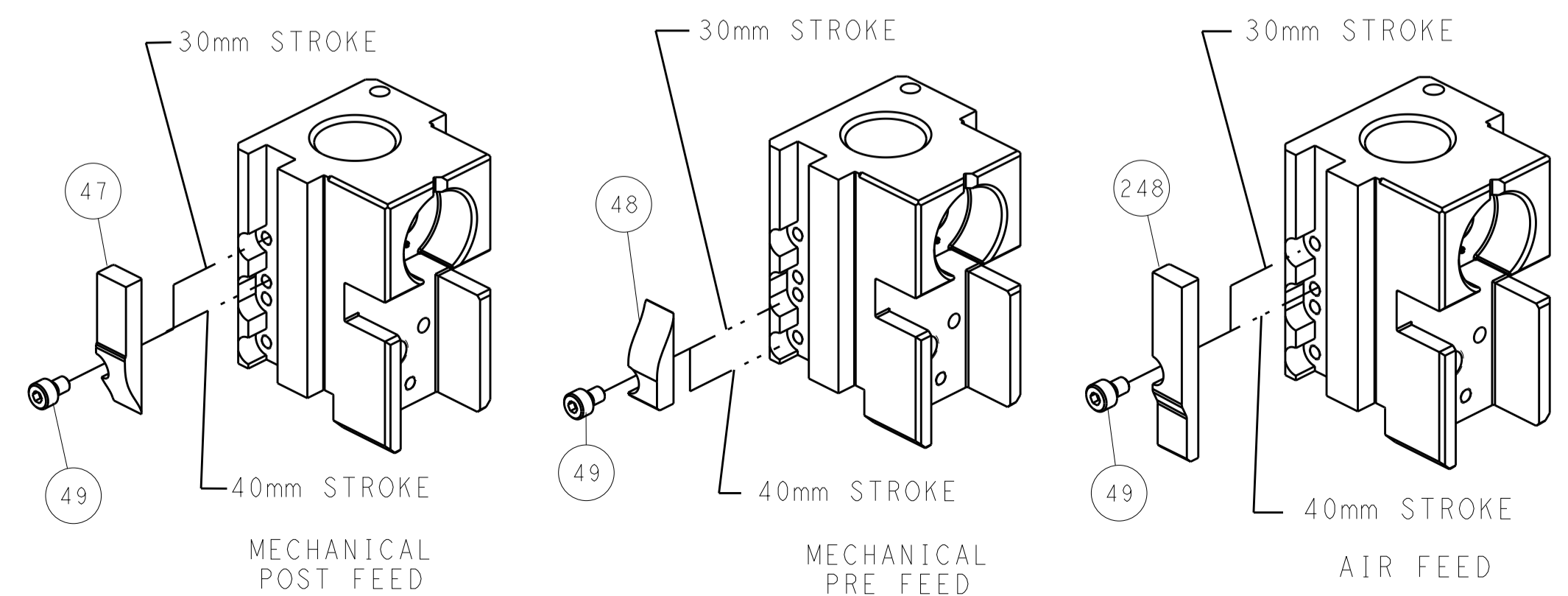


HOLDDOWN SET-UP



FEED TRACK POSITION GUIDE BY INSULATION BARREL

CAM POSITIONS

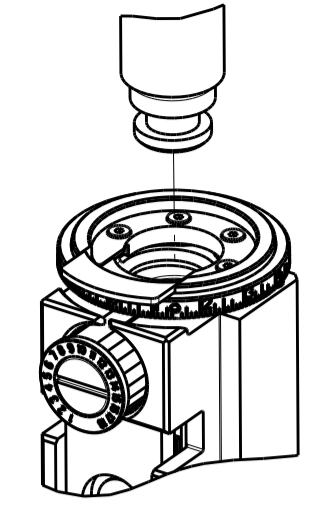


ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		DWN X.ZHAO 16OCT2015 CHK L.ZHANG 16OCT2015 APVD H.GUO 16OCT2015 NAME Ocean Side Feed Applicator SIZE CAGE CODE DRAWING NO. RESTRICTED TO A1 00779 ©=2151206 Customer Accessible Production Drawing SCALE 1:2 SHEET 2 OF 4 REV B	
MATERIAL:		FINISH:		WEIGHT:	

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2151206-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2151206-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151206-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
 INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.29 mm [.090]	F
INSUL	3.56 mm [.140]	F

APPLICATOR INSTRUCTIONS
 408-35042

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: MULTILOCK CONTACT			
WIRE STRIP LENGTH 4.00-5.00 mm [1.57-.197 IN]		INSULATION DIAMETER RANGE Ø2.16-3.43 mm [.085-.135 IN]	
TERMINAL APPLICATION SPECIFICATION	114-5004	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
170286-1	170286-2	170286-3	170286-4

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
2.00mm ²	1.78+/-0.05 [.070+/-0.002]	4.2
2 X 0.5mm ²	1.50+/-0.05 [.059+/-0.002]	7.1
0.85mm ² + 0.5mm ²	1.50+/-0.05 [.059+/-0.002]	7.2
1.25mm ²	1.50+/-0.05 [.059+/-0.002]	7.2
0.85mm ²	1.34+/-0.05 [.053+/-0.002]	8.8
0.50mm ²	1.30+/-0.05 [.051+/-0.002]	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. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- 6 TERMINAL LUBRICANT IS RECOMMENDED.

***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)

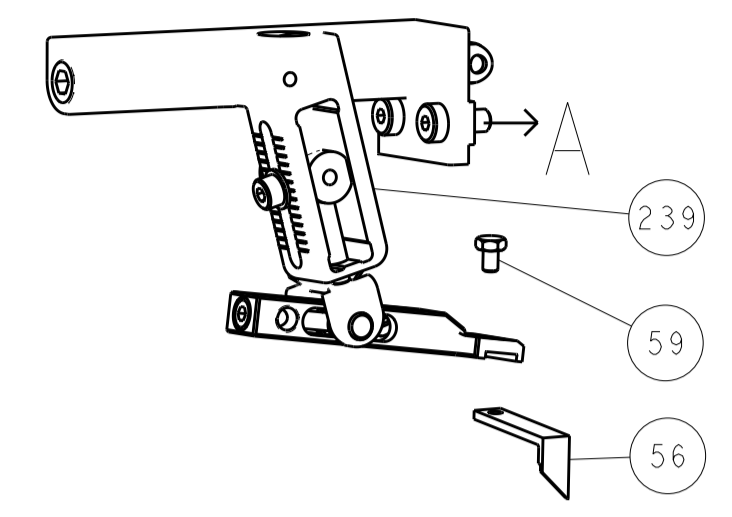
LOC	DIST	REV	DATE	BY	APPV
A	66				

REV	DATE	BY	APPV	DESCRIPTION	ITEM NO	
-	1	-		2119640-1 PUSH ROD, AIR FEED	250	
-	1	-		1803259-1 BUSHING, FLANGED	249	
-	1	1		2119082-4 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	-		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		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		1803607-1 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		1338683-8 FEED PAWL	56	
-	2	2		2168083-3 SCR, SKT HD CAP, RoHS, M4 X 12.0	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		1752356-3 SUPPORT, TERMINAL	34	
-	2	2		2079383-5 SCR, BHSC, RoHS (M4 X 20)	33	
-	2	2		3-2844962-2 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	
-	2	2		1-18028-2 WASHER, FLAT, REG M4	20	
-	1	1		2119533-3 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		1803095-6 FLOATING SHEAR, FRONT	9	
-	1	1		2-1633921-2 ANVIL, COMBINATION	8	
-	1	1		1-240641-1 SPACER	7	
-	-	-		-	6	
-	1	1		2119757-8 DEPRESSOR, SHEAR	5	
-	1	1		238011-8 BLOCK, CRIMPER SPACER	4	
-	1	1		2-2119582-4 CRIMPER, INSULATION F PREMIUM	3	
-	1	1		455888-6 SPACER, CRIMPER	2	
-	1	1		2-456406-3 CRIMPER, WIRE PREMIUM	1	
-	77	-22	-21	PART NO	DESCRIPTION	ITEM NO

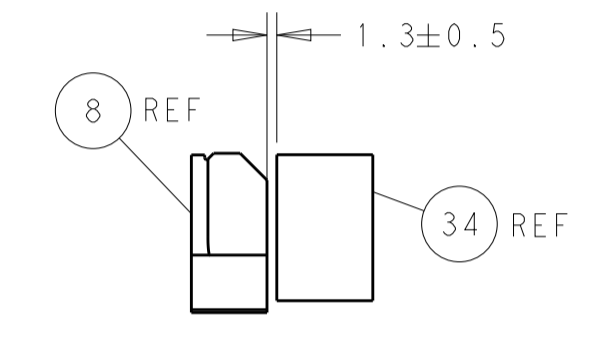
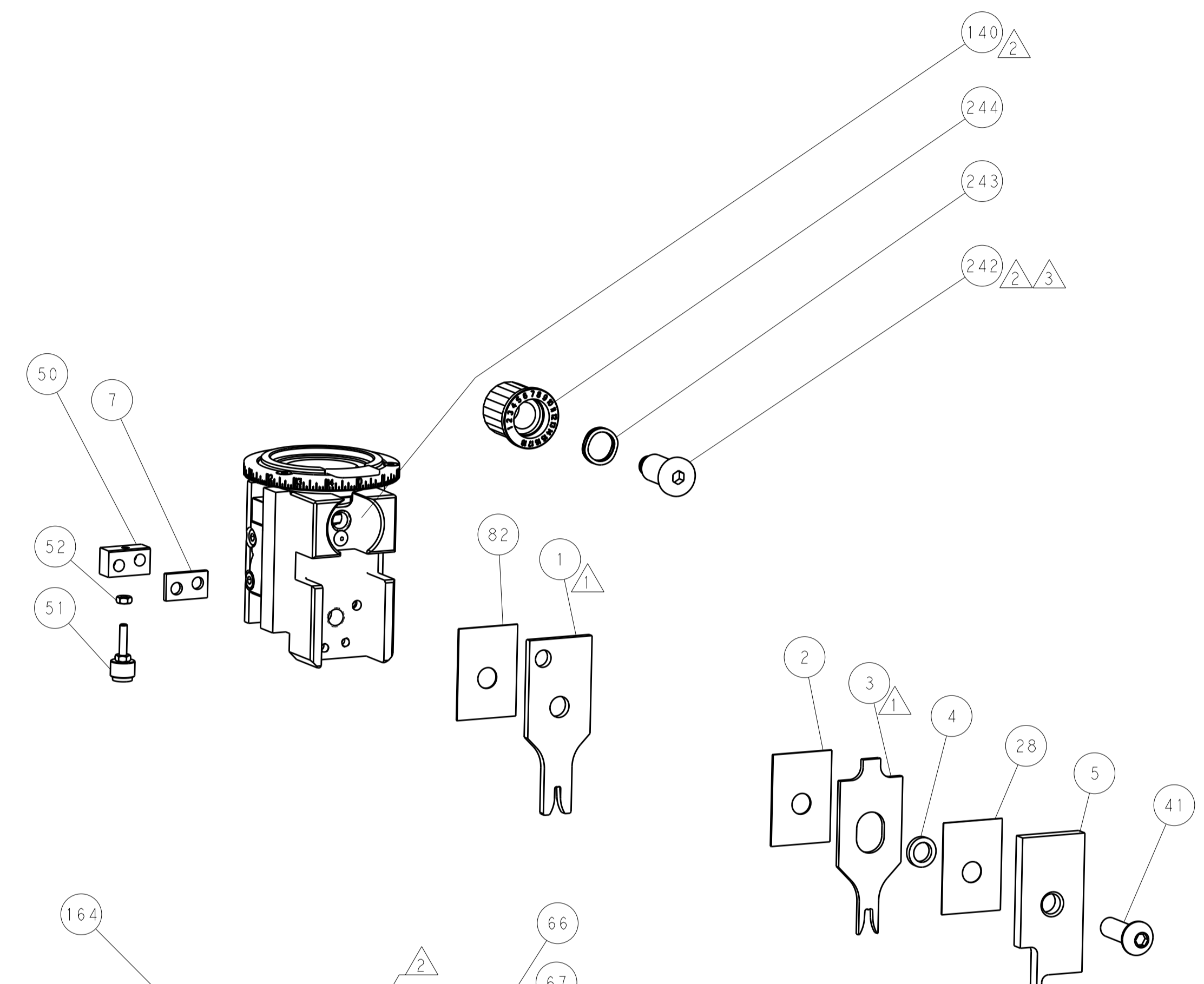
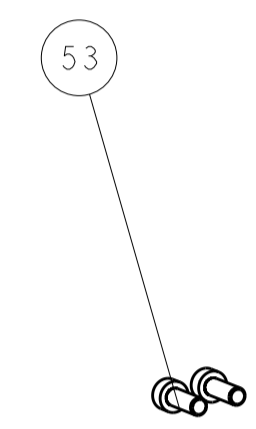
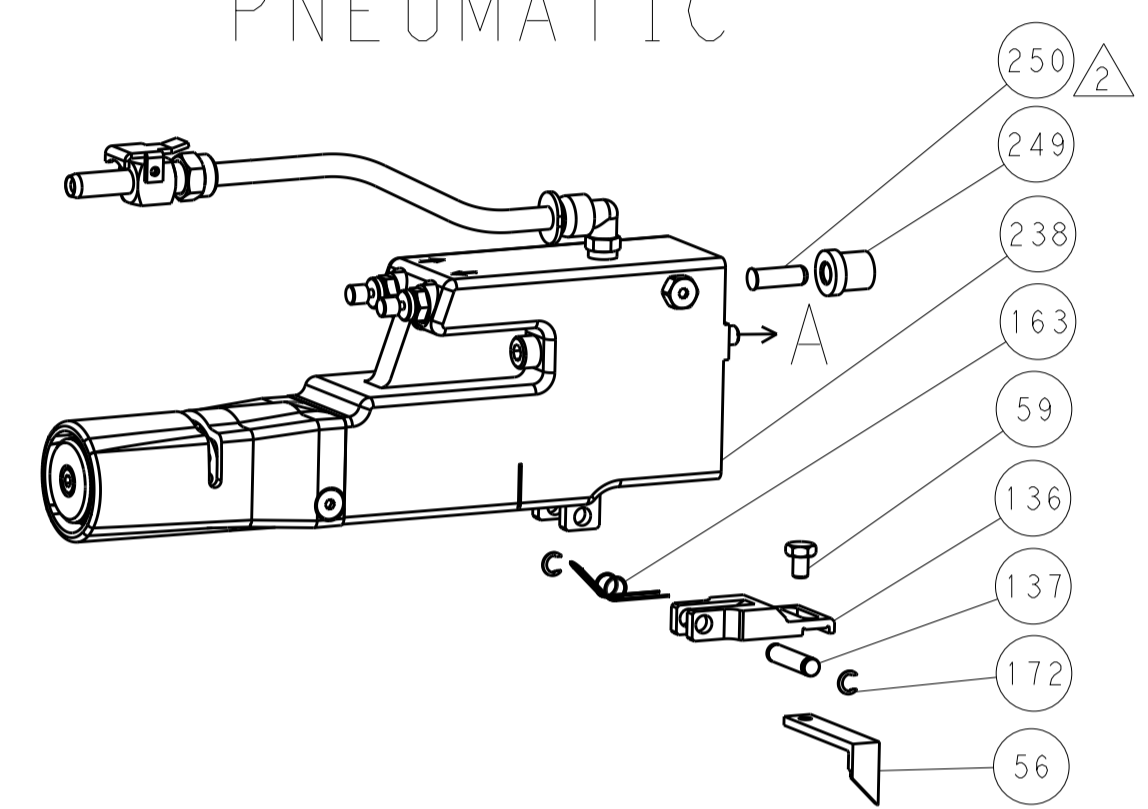
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MATERIAL: -		FINISH: -		WEIGHT: -		SCALE: 1:2 SHEET 3 OF 4 REV B	

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

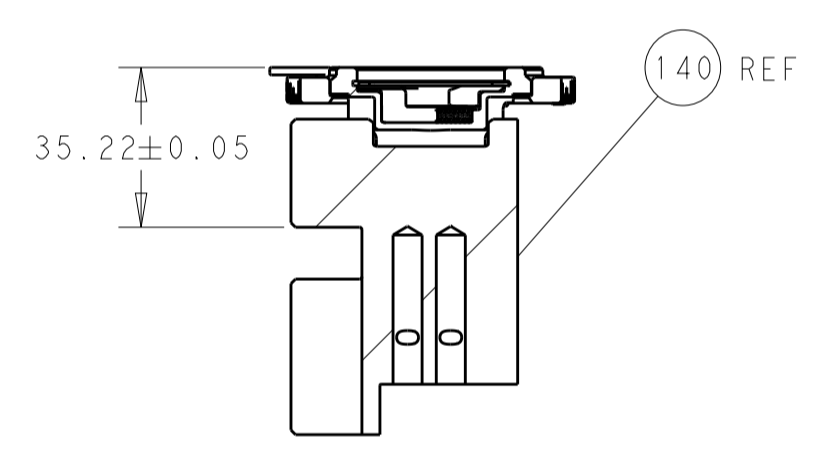
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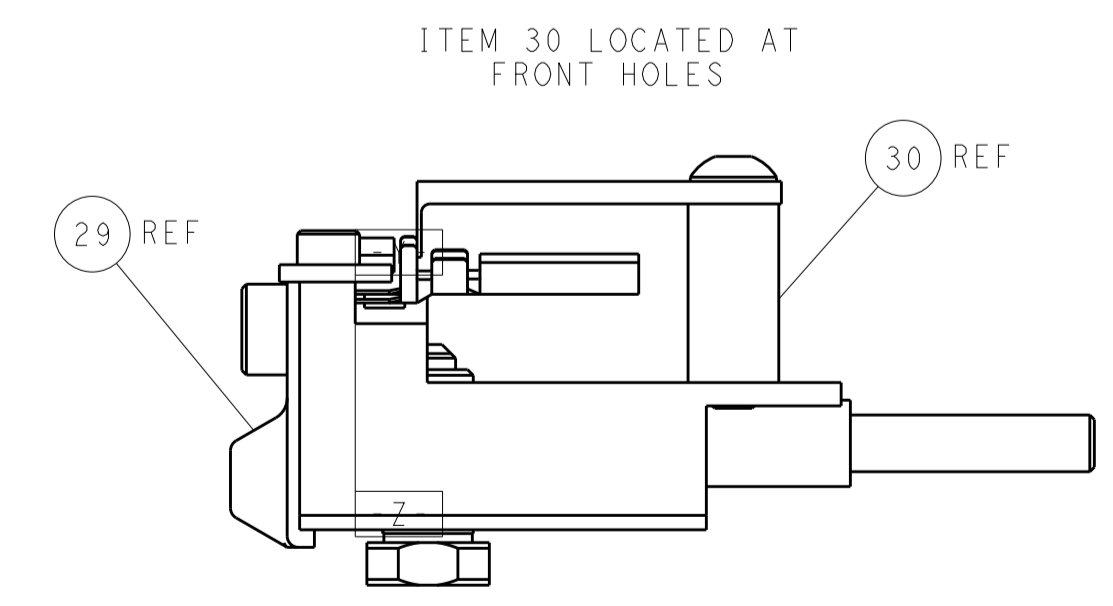
PNEUMATIC



TERMINAL SUPPORT LOCATION

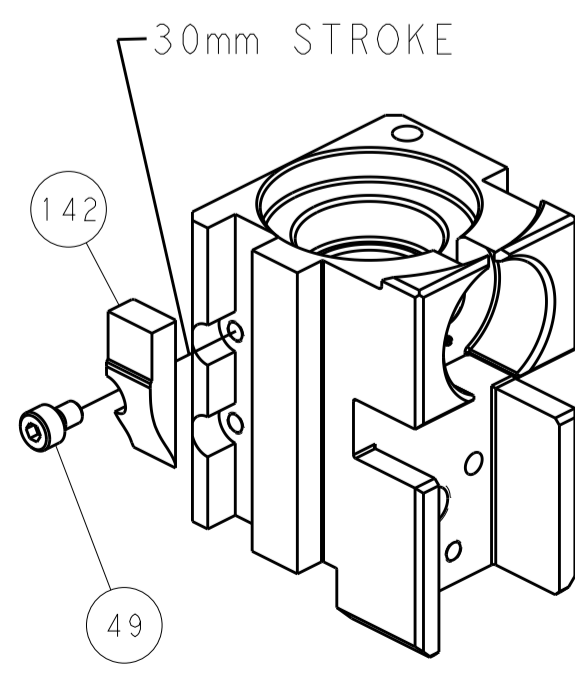


HOLDDOWN SET-UP

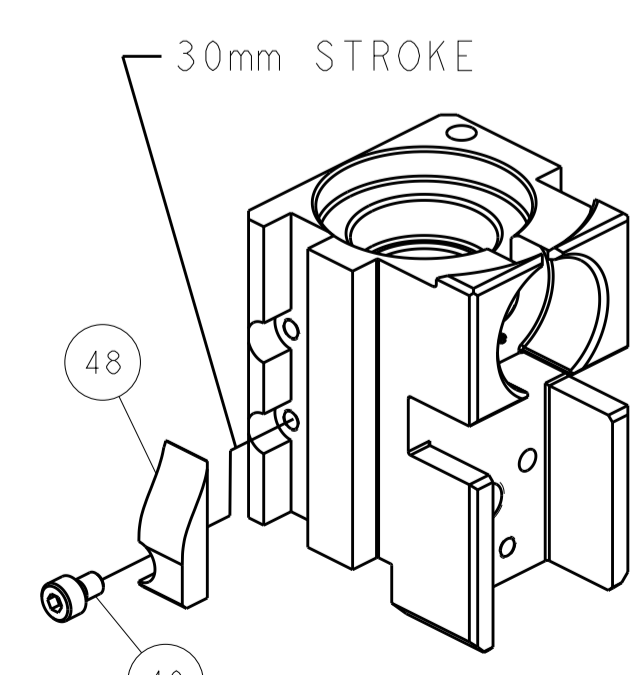


FEED TRACK POSITION
GUIDE BY INSULATION BARREL

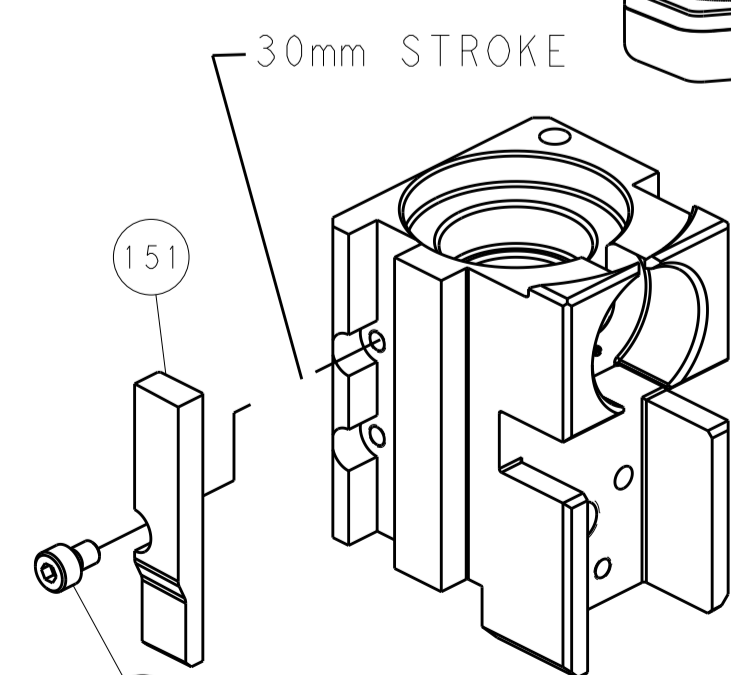
CAM POSITIONS



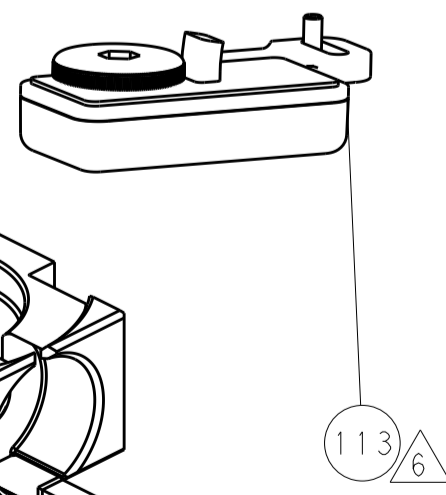
MECHANICAL
POST FEED



MECHANICAL
PRE FEED



AIR FEED



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: X. ZHAO 16OCT2015		TE Connectivity	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	5 PLC ±	Harrisburg, PA 17105-3608
	ANGLES	FINISH		CHK: L. ZHANG 16OCT2015		NAME	
MATERIAL				APVD: H. GUO 16OCT2015		Ocean Side Feed Applicator	
				PRODUCT SPEC		SIZE: CAGE CODE: DRAWING NO:	
				APPLICATION SPEC		RESTRICTED TO	
				WEIGHT		A 00779 ©=2151206	
				Customer Accessible Production Drawing		SCALE: 1:2 SHEET 4 OF 4 REV B	