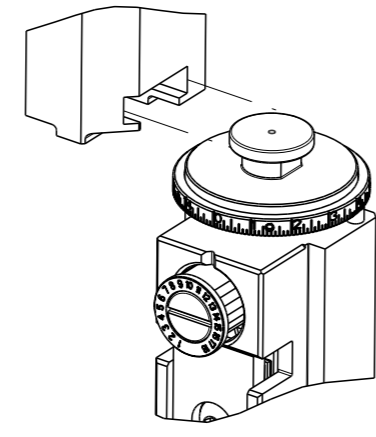


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151617-1	D	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2151617-2	D	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151617-1	D	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2151617-2	D	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2151617-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.29 mm [.090]	F
INSUL	3.30 mm [.130]	O

APPLICATOR INSTRUCTIONS
408-35042

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: PIN CONTACT, SIZE 16, W/W			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
4.78-5.38 mm [.188-.212 IN]		Ø1.65-3.00 mm [.065-.118 IN]	
TERMINAL APPLICATION SPECIFICATION	114-13045		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
2098250-1	2098250-2	2098250-3	2098251-1
2098251-2			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.50mm2	1.50 +/- 0.05 [0.059 +/- .002]	4.1
16 AWG	1.45 +/- 0.05 [0.057 +/- .002]	4.7
18 AWG	1.32 +/- 0.05 [0.052 +/- .002]	5.9
1.00mm2	1.29 +/- 0.05 [0.051 +/- .002]	6.2

- 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.

***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	REV	DATE	BY	APPV
		B	ECR-17-004468	28MAR2017	MR GB
		C	ECR-18-009460	19JUN2018	MZ TE
		D	ECR-20-010851	30JUL2020	MEH TE

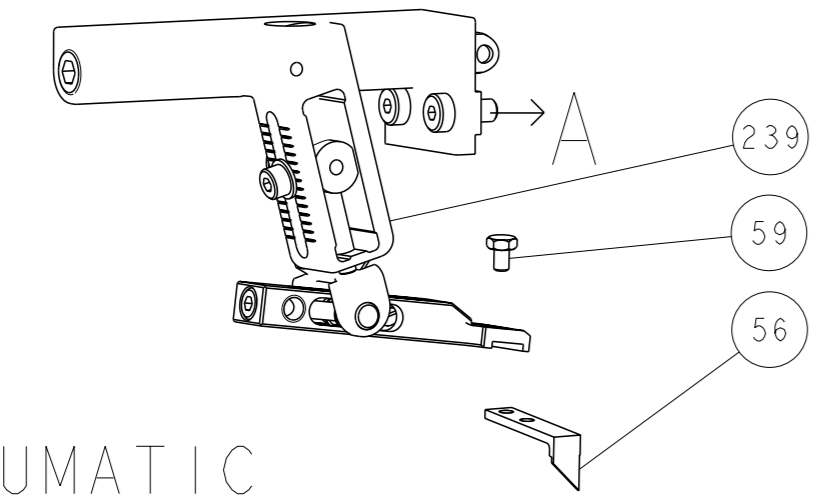
-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248					
-	1	1	1	1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244					
-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243					
-	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242					
-	1	1	1	1	18023-1	SCR, SKT HD CAP M3 X 5.0	241					
-	-	1	-	1	2119580-1	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	455888-5	SPACER, CRIMPER	82					
-	1	1	1	1	1803607-3	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	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	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	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	2-1752356-0	SUPPORT, TERMINAL	34					
-	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33					
-	2	2	2	2	2-2844962-0	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	1320928-1	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	1-356885-4	STOP, SHEAR	11					
-	1	1	1	1	2119805-1	SHEAR HOLDER, FRONT	10					
-	1	1	1	1	1803095-1	FLOATING SHEAR, FRONT	9					
-	1	2	2	1	1	4-1633132-4	ANVIL, COMBINATION .090	8				
-	-	-	-	-	-	-	7					
-	-	-	-	-	-	-	6					
-	1	1	1	1	2119757-4	DEPRESSOR, SHEAR	5					
-	1	1	1	1	238011-4	BLOCK, CRIMPER SPACER	4					
-	1	2	2	1	1	2119784-4	CRIMPER, INSULATION O PREMIUM	3				
-	1	1	1	1	455888-6	SPACER, CRIMPER	2					
-	1	2	2	1	1	1-456406-5	CRIMPER, WIRE PREMIUM	1				
-	77	-	72	-	71	-	2	-	1	PART NO	DESCRIPTION	ITEM NO

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

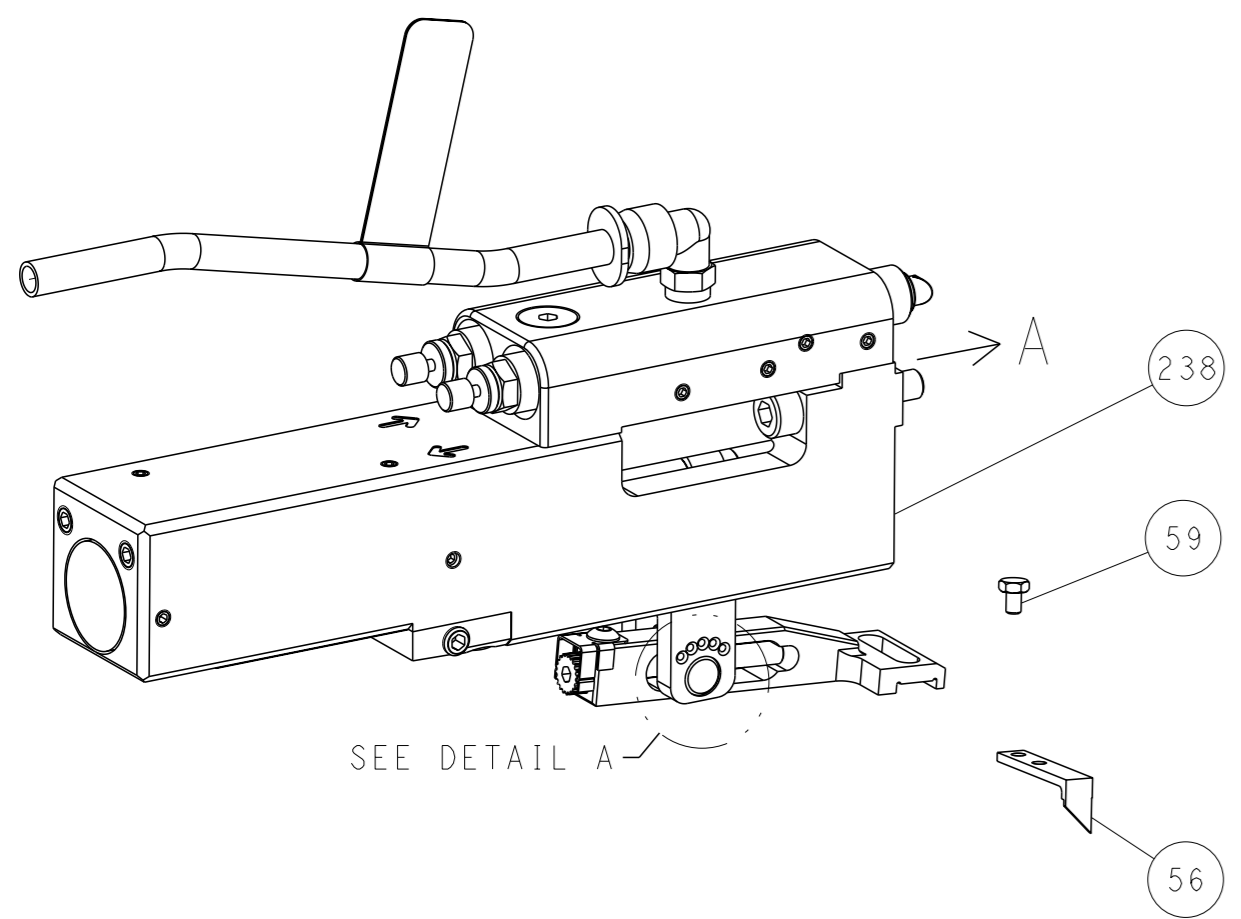
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	3 PLC ±	4 PLC ±	ANGLES FINISH	APVD S. XI 01MAR2012	NAME Ocean Side Feed Applicator
	MATERIAL	WEIGHT	SCALE 1:2	RESTRICTED TO	SIZE CAGE CODE DRAWING NO 00779 C=2151617
CUSTOMER ACCESSIBLE PRODUCTION DRAWING				SHEET 1 OF 4	REV D

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

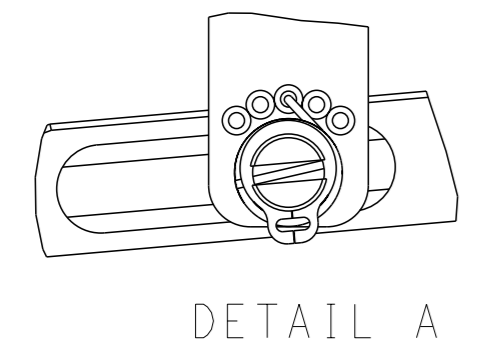
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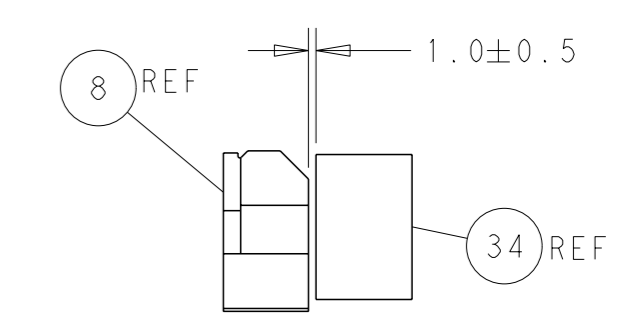
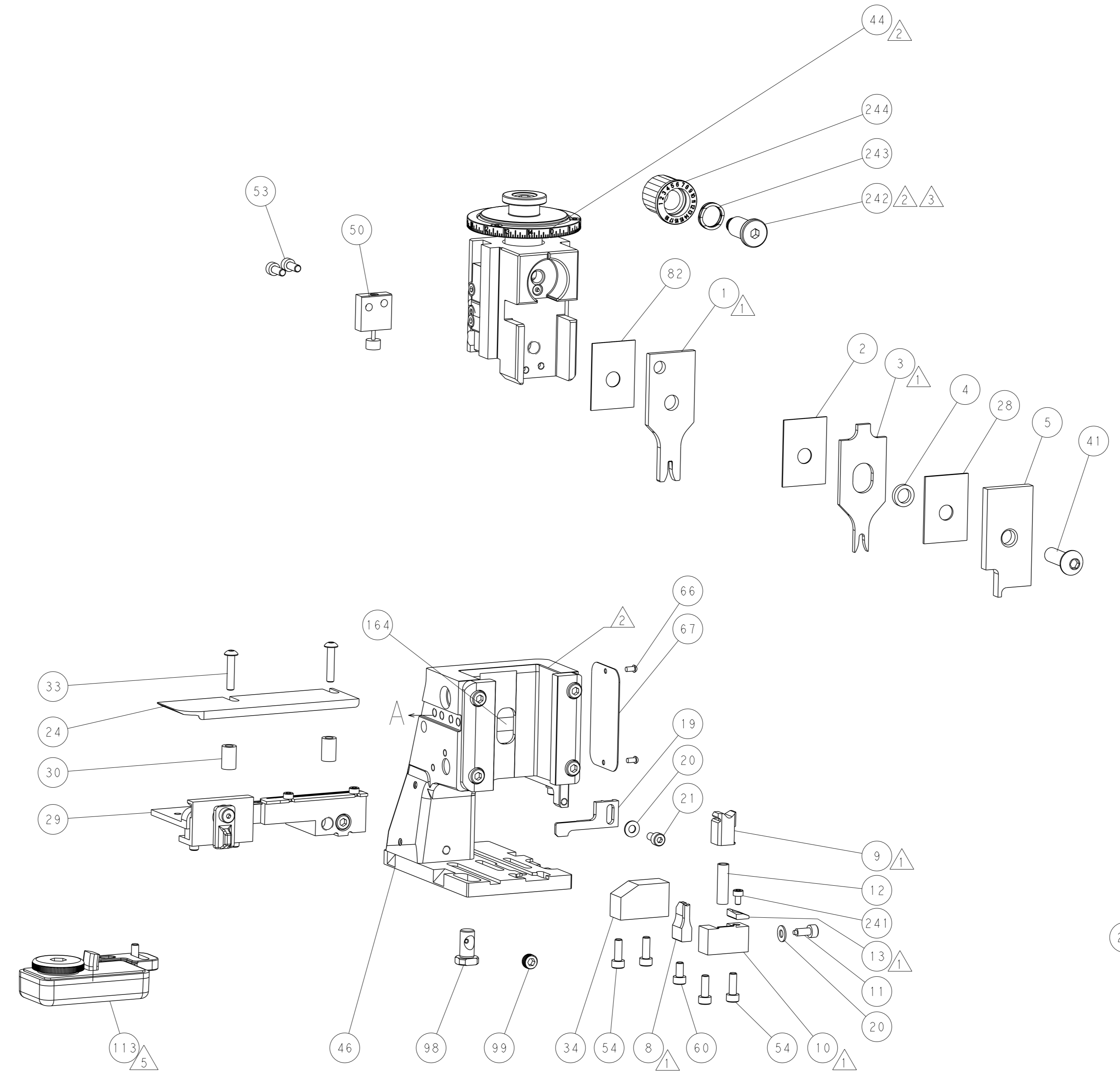
PNEUMATIC



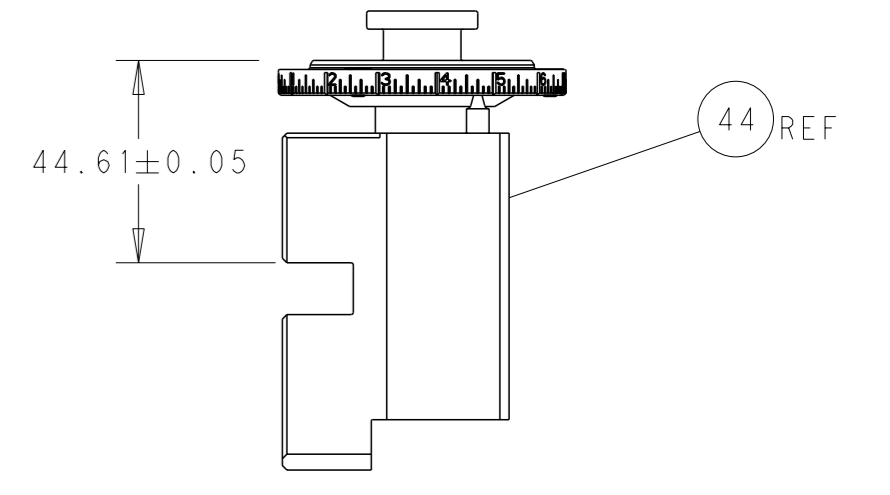
FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



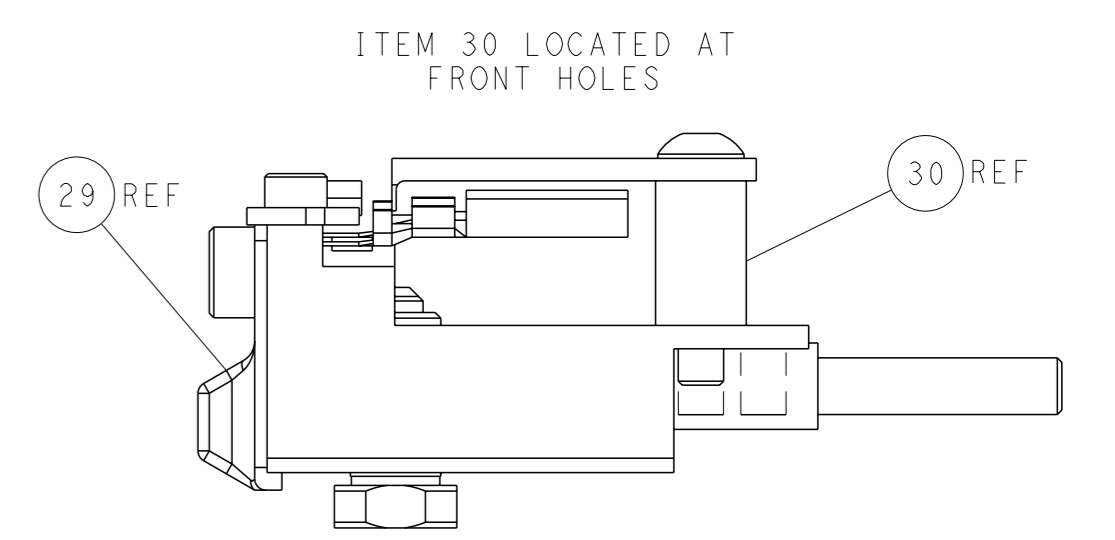
DETAIL A



TERMINAL SUPPORT LOCATION

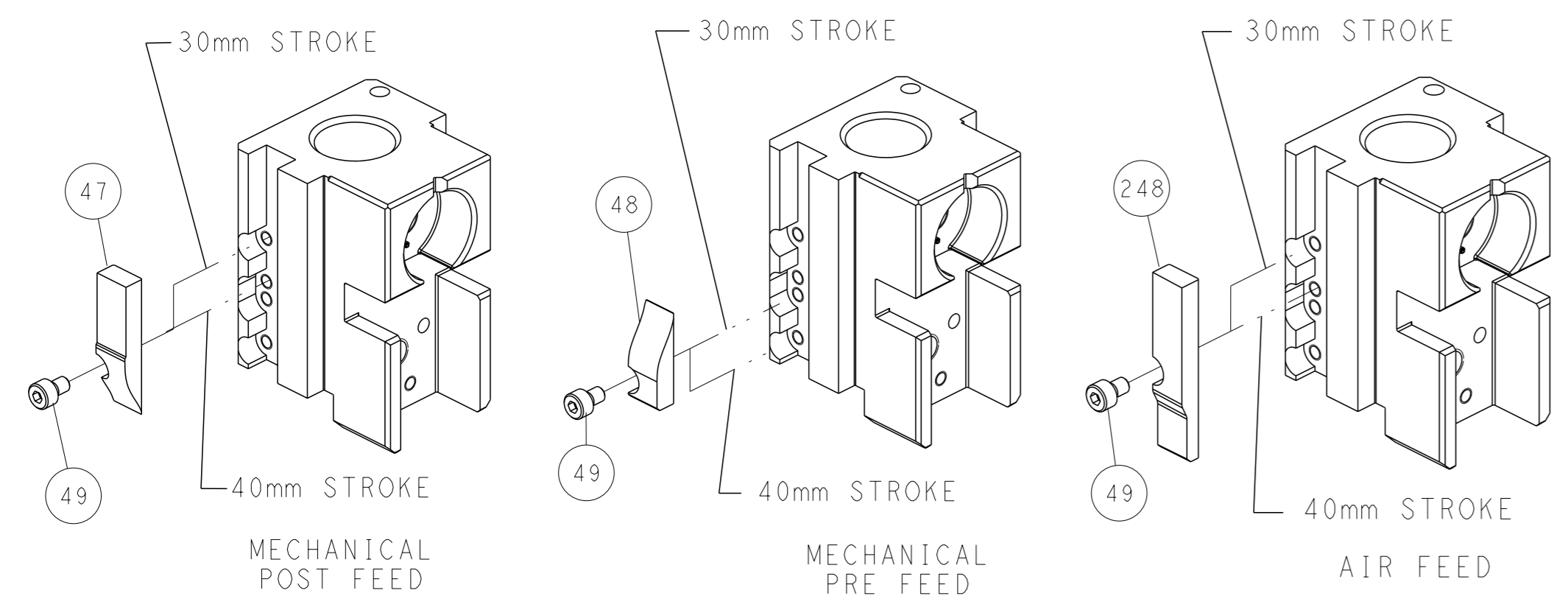


RAM SET-UP



FEED TRACK POSITION GUIDE BY INSULATION BARREL

CAM POSITIONS

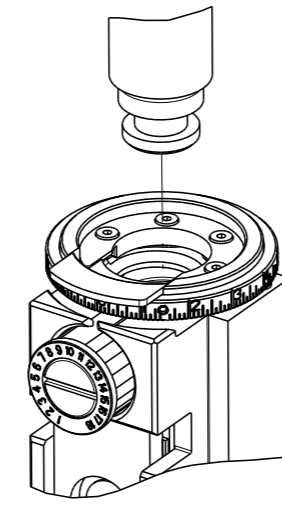


ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

<small>THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE AND TO CONTROLING ENGINEERING DISCRETION. SHOULD BE CONTACTED FOR THE LATEST REVISION.</small>		OWN: Y. YIN CHK: G. BAILEY APVD: S. XI	01MAR2012 01MAR2012 01MAR2012	TE Connectivity Harrisburg, PA 17105-3608
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: C=2151617	RESTRICTED TO: D SCALE: 1:2 SHEET: 2 of 4 REV: D	
MATERIAL:		CUSTOMER ACCESSIBLE PRODUCTION DRAWING		

THIS DRAWING IS UNPUBLISHED.	RELEASED FOR PUBLICATION		
© COPYRIGHT 20 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.	20		
PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2151617-1	D	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2151617-2	D	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151617-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.29 mm [.090]	F
INSUL	3.30 mm [.130]	O
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: PIN CONTACT, SIZE 16, W/W			
WIRE STRIP LENGTH 4.78-5.38 mm [.188-.212 IN]		INSULATION DIAMETER RANGE Ø1.65-3.00 mm [.065-.118 IN]	
TERMINAL APPLICATION SPECIFICATION	114-13045	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
2098250-1	2098250-2	2098250-3	2098251-1
2098251-2			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.50mm2	1.50+/-0.05 [.059+/-0.002]	4.1
16 AWG	1.45+/-0.05 [.057+/-0.002]	4.7
18 AWG	1.32+/-0.05 [.052+/-0.002]	5.9
1.00mm2	1.29+/-0.05 [.051+/-0.002]	6.2

- 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.

***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)

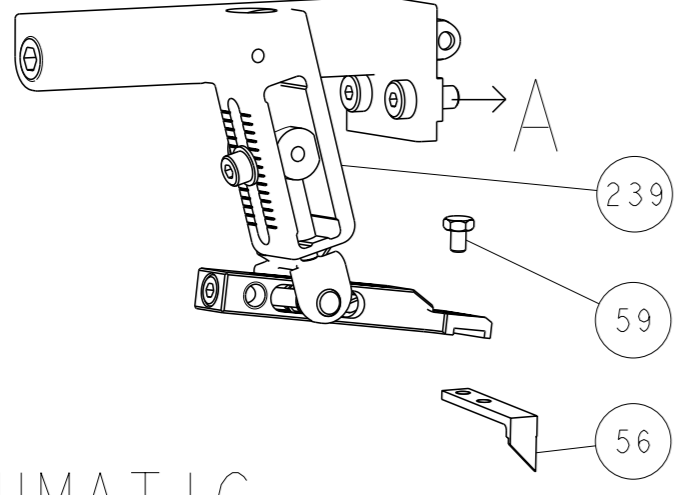
LOC	DIST	REVISIONS					
A	66	P	LY#	DESCRIPTION	DATE	OWN	APVD
		-		SEE SHEET 1	-	-	-

-	1	1	2119082-9	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	18023-1	SCR, SKT HD CAP M3 X 5.0	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	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	1803607-3	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	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
-	-	1	2119652-1	FEED CAM, PRE FEED	48
-	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
-	1	1	2-1752356-0	SUPPORT, TERMINAL	34
-	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	2-2844962-0	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29
-	1	1	1-455888-0	SPACER, CRIMPER	28
-	1	1	1320928-1	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	1-356885-4	STOP, SHEAR	11
-	1	1	2119805-1	SHEAR HOLDER, FRONT	10
-	1	1	1803095-1	FLOATING SHEAR, FRONT	9
1	1	1	4-1633132-4	ANVIL, COMBINATION .090	8
-	-	-	-	-	7
-	-	-	-	-	6
-	1	1	2119757-4	DEPRESSOR, SHEAR	5
-	1	1	238011-4	BLOCK, CRIMPER SPACER	4
1	1	1	2119784-4	CRIMPER, INSULATION O PREMIUM	3
-	1	1	455888-6	SPACER, CRIMPER	2
1	1	1	1-456406-5	CRIMPER, WIRE PREMIUM	1
-77	-22	-21	PART NO	DESCRIPTION	ITEM NO

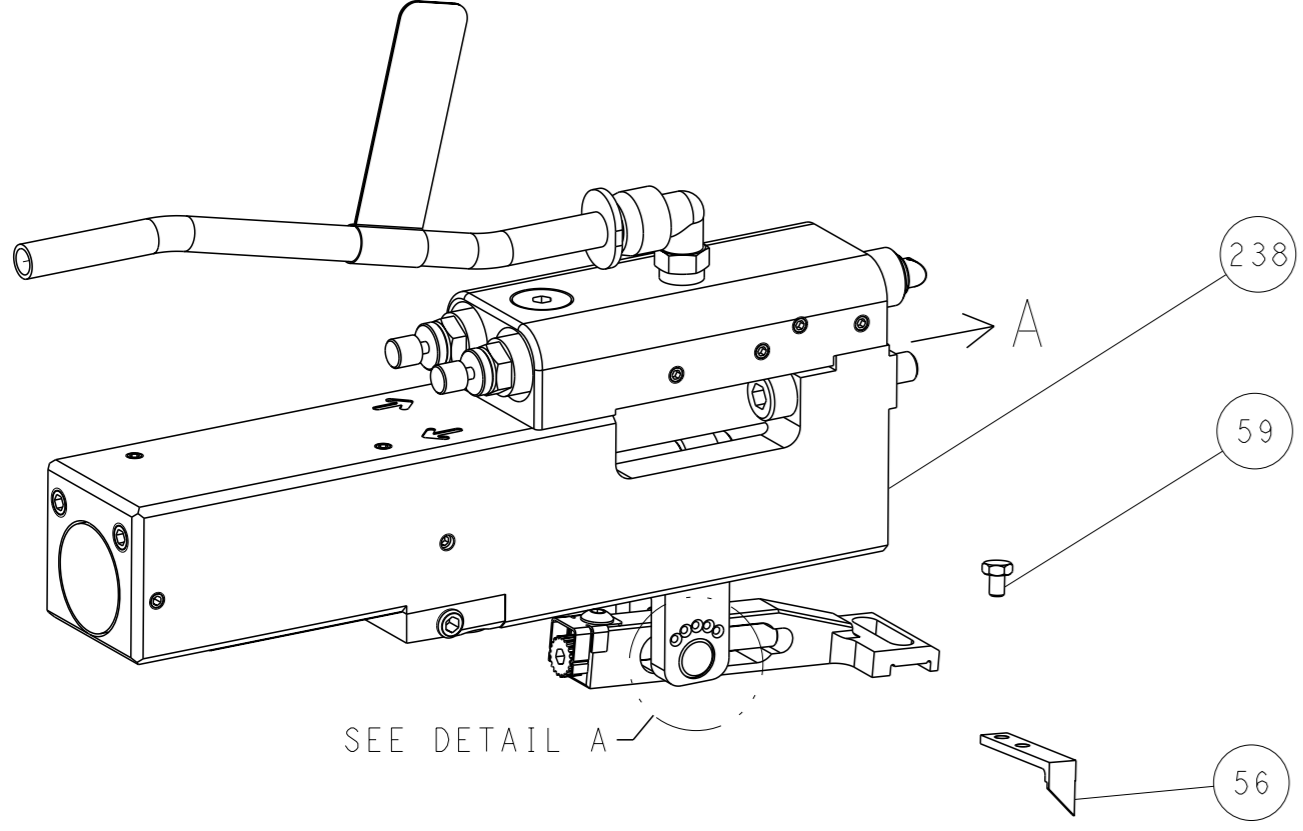
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		OWN Y. YIN 01MAR2012	TE Connectivity Harrisburg, PA 17105-3608
mm	0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ±	±	±	CHK G. BAILEY 01MAR2012	
MATERIAL:		FINISH:		APVD S. YI 01MAR2012	NAME Ocean Side Feed Applicator
-		-		PRODUCT SPEC	
-		-		APPLICATION SPEC	SIZE CAGE CODE DRAWING NO
-		-		WEIGHT	A1 00779 C=2151617
-		-		CUSTOMER ACCESSIBLE PRODUCTION DRAWING	
-		-		SCALE 1:2	SHEET 3 OF 4
-		-		REV D	

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

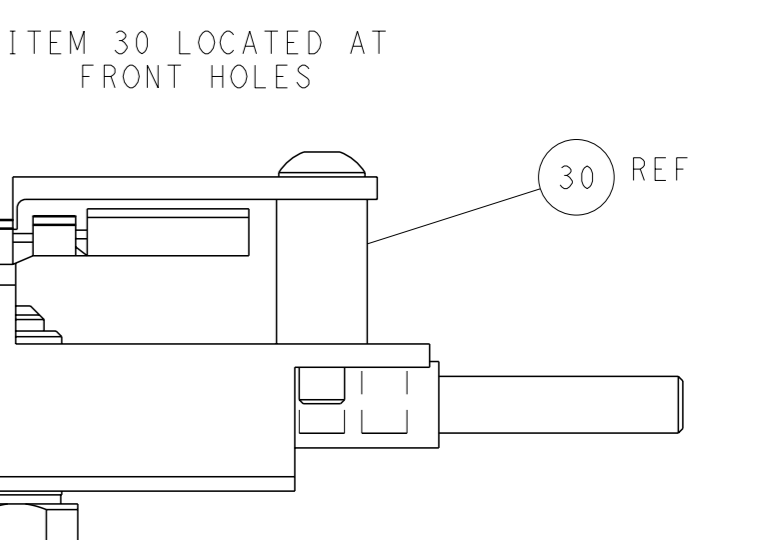
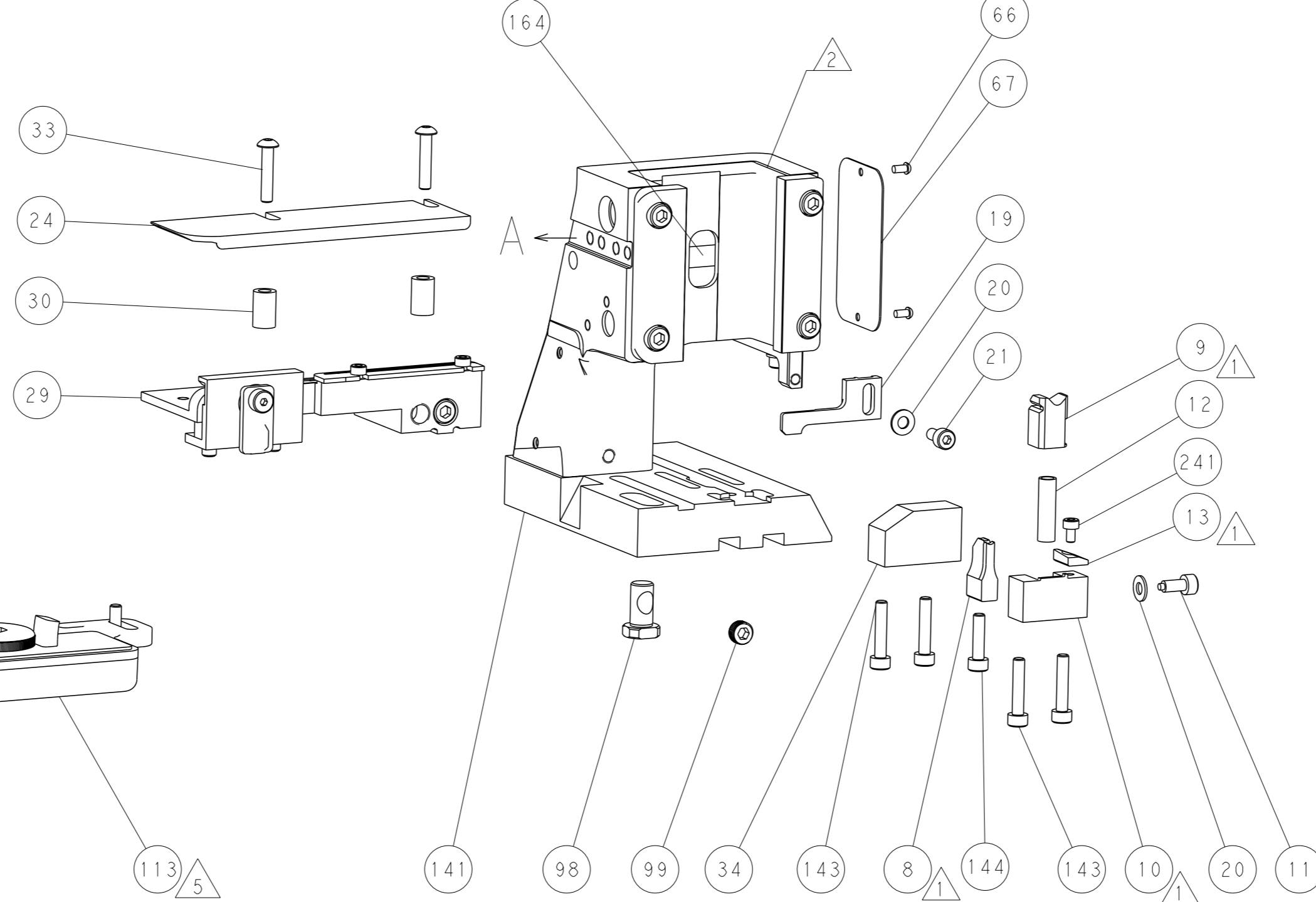
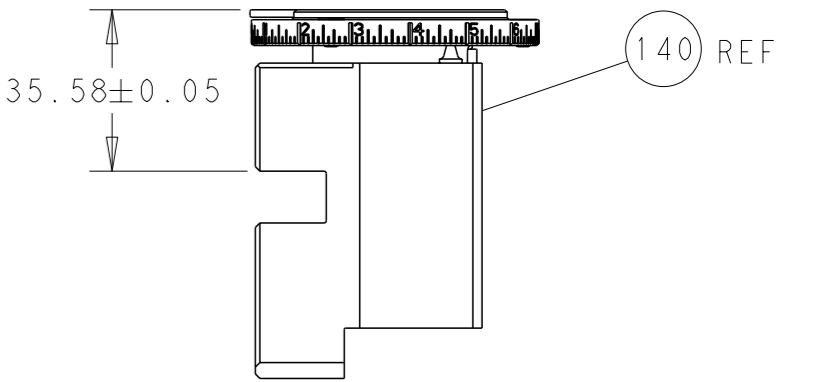
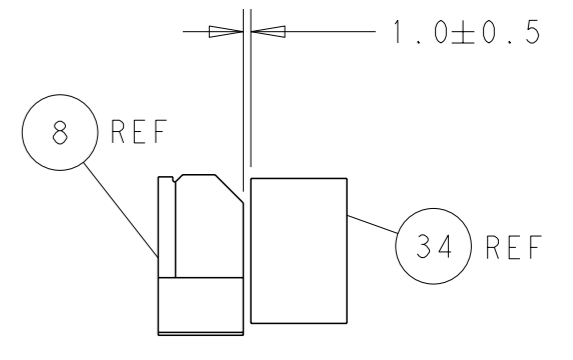
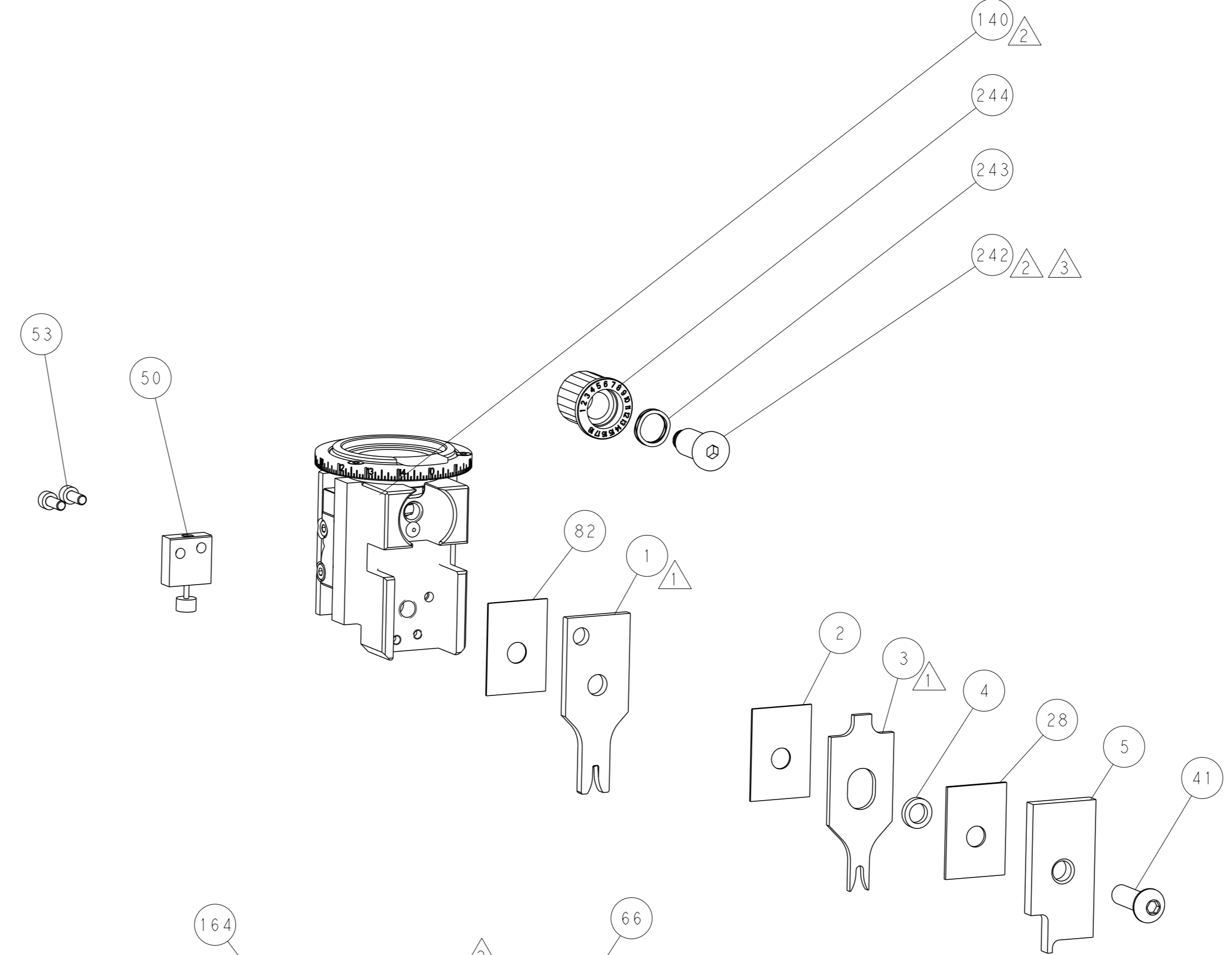
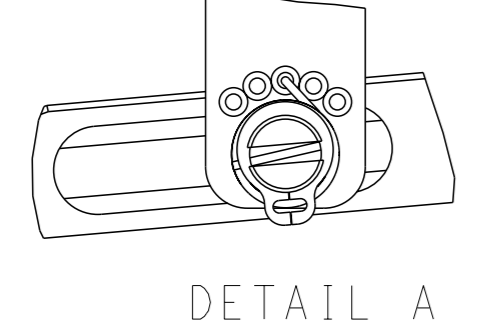
FEED TYPE MECHANICAL



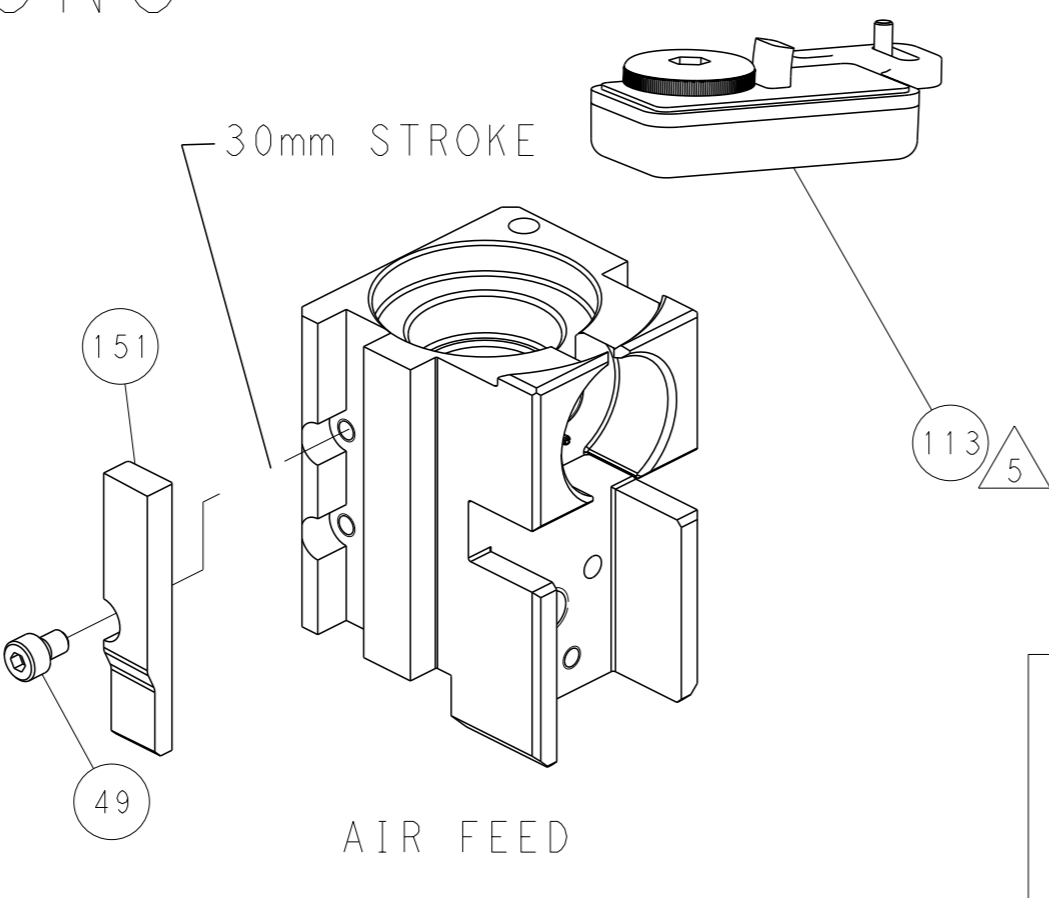
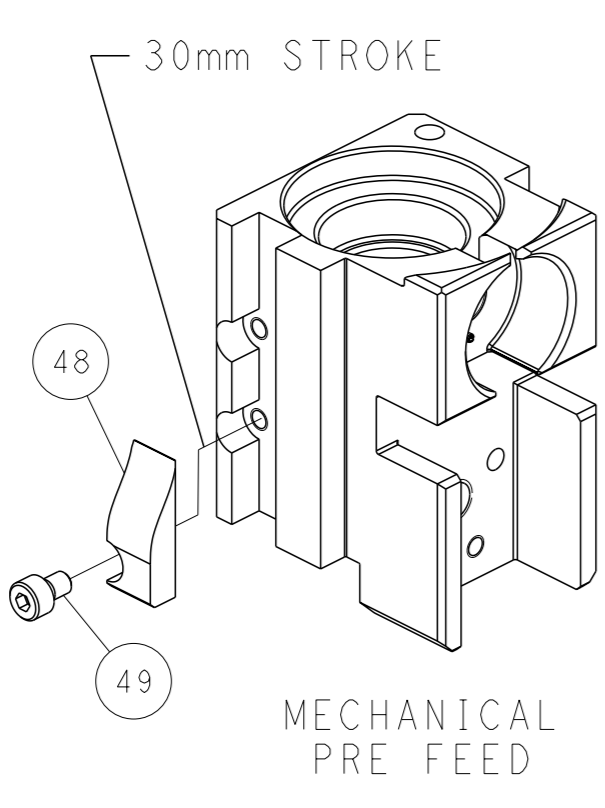
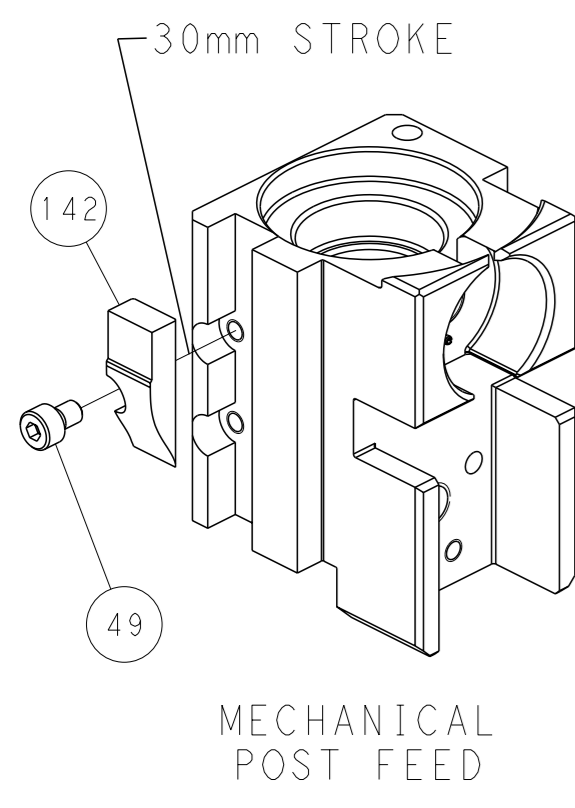
PNEUMATIC



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)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		OWN Y. YIN 01MAR2012	TE Connectivity Harrisburg, PA 17105-3608
mm	0 PLC ±	1 PLC ±	2 PLC ±	CHK G. BAILEY 01MAR2012	
	3 PLC ±	4 PLC ±	ANGLES FINISH *	APVD S. XI 01MAR2012	NAME Ocean Side Feed Applicator
	MATERIAL	WEIGHT	FINISH	SIZE CAGE CODE DRAWING NO. A1 00779 C=2151617	RESTRICTED TO
CUSTOMER ACCESSIBLE PRODUCTION DRAWING				SCALE 1:2	SHEET 4 OF 4 REV D