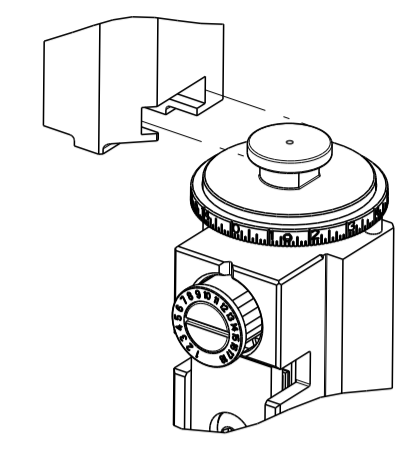


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151096-1	M	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2151096-2	M	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
5-2151096-1	M	SEAL STRIPPER CRIMPER TERMINATING UNIT	MECHANICAL
5-2151096-2	M	SEAL STRIPPER CRIMPER TERMINATING UNIT	PNEUMATIC
7-2151096-1	M	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2151096-2	M	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2151096-7	H	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.57 mm [.062]	F
INSUL	3.18 mm [.125]	F

APPLICATOR INSTRUCTIONS 408-35042

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: VAL-U-LOK PIN CONTACT			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
3.00-3.50 mm [.118-.138 IN]		Ø 1.50-3.30 mm [.059-.130 IN]	
TERMINAL APPLICATION SPECIFICATION	114-13172		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
794955-1	794955-2	794955-3	794955-4
794956-1	794956-2	794956-3	794956-4
794956-5			

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: VAL-U-LOK PIN CONTACT			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
3.00-3.50 mm [.118-.138 IN]		Ø 1.50-3.30 mm [.059-.130 IN]	
TERMINAL APPLICATION SPECIFICATION	114-13172		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
2238016-1	2238017-1	2825210-1	2825211-1

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
22 AWG + 20 AWG	1.22+/-0.05 [.048+/- .002]	4.1
17.45 AWG OR 0.936mm2	1.17+/-0.05 [.046+/- .002]	5.6
18 AWG OR 0.87mm2	1.09+/-0.05 [.043+/- .002]	5.8
2 X 22 AWG	1.09+/-0.05 [.043+/- .002]	5.8
20 AWG OR 0.50mm2	0.99+/-0.05 [.039+/- .002]	6.8
22 AWG OR 0.35mm2	0.80+/-0.05 [.031+/- .002]	7.7

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
22 AWG + 20 AWG	1.22+/-0.05 [.048+/- .002]	4.1
18 AWG OR 0.87mm2	1.09+/-0.05 [.043+/- .002]	5.8
2 X 22 AWG	1.09+/-0.05 [.043+/- .002]	5.8
20 AWG OR 0.50mm2	0.99+/-0.05 [.039+/- .002]	6.8
22 AWG OR 0.35mm2	0.80+/-0.05 [.031+/- .002]	7.7

- RECOMMENDED SPARE PARTS
- REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 180. 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.
- INSTALL ITEM 3 AS SHOWN FOR TERMINALS 2238016 AND 2238017.
- INSTALL ITEM 3 WITH RELIEF INWARDS AGAINST ITEM 1 FOR TERMINALS 794955 AND 794956.
- TERMINAL LUBRICANT IS RECOMMENDED.
- 8. 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
		K		ECR-18-009001	11JUN2018	JAH	JDG
		L		ECR-18-019939	20DEC2018	TB	TE
		L1		ECR-19-006483	23APR2019	FL	CT
		M		ECR-19-018162	20NOV2019	TB	TE

-	-	-	1	1	-	-	1803515-3	RAM ASSEMBLY, SF ATLANTIC	293
-	-	-	1	1	-	-	2-1803583-1	APPLICATOR BASIC ASSEMBLY, SF	292
-	1	-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248
-	1	1	1	1	1	1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	1	1	1	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
-	-	1	-	1	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	1	-	1	-	1	-	2844940-1	AIR FEED MODULE	238
-	-	-	1	1	-	-	4-1722335-3	STRIPPER, SIDE FEED	182
-	-	-	1	1	-	-	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	181
-	-	-	1	1	-	-	1-1752354-9	STANDOFF,HOLD-DOWN	180
-	-	-	1	1	-	-	993111-1	PIN, SLOTTED SPRING 3.0 X 20.0	177
-	-	-	1	1	-	-	5-22280-0	SPRING, COMPRESSION	176
-	-	-	1	1	-	-	1752353-3	GUIDE PIN,HOLDDOWN	175
-	-	-	1	1	-	-	1901680-2	GUIDE PIN,HOLDDOWN	174
-	REF	REF	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	1	1	1	1	1	1	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113
-	1	1	1	1	1	1	2844908-1	SCREW, LOCKING	99
-	1	1	1	1	1	1	2844907-1	POST, LOCKING	98
-	1	1	1	1	1	1	1-455888-1	SPACER, CRIMPER	82
-	1	1	1	1	1	1	1803607-3	DOCUMENTATION PACKAGE	71
-	1	1	1	1	1	1	2119791-5	DEPRESSOR, WIRE	70
-	1	1	1	1	1	1	2119740-1	TAG IDENTIFICATION	67
-	2	2	2	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	1	1	1	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	60
-	1	1	1	1	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	1	1	1	1	1	1	1338685-1	PAWL, FEED	56
-	4	4	4	4	4	4	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	54
-	2	2	2	2	2	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	53
-	1	1	1	1	1	1	1803382-6	HOLD DOWN, SPRING LOADED	50
-	1	2	1	2	1	2	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	-	1	-	1	-	1	2119652-1	FEED CAM, PRE FEED	48
-	-	1	-	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	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
-	1	1	1	1	1	1	1752356-1	SUPPORT, TERMINAL	34
-	2	2	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	2	2	2	2	2-2844962-4	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	1	1	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29
-	1	1	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	1	1	2	2	1-18028-2	WASHER, FLAT, REG M4	20
-	1	1	-	-	1	1	2119533-1	STRIPPER, SIDE FEED	19
-	1	1	1	1	1	1	2119806-1	INSERT, SHEAR	13
-	1	1	1	1	1	1	3-22280-3	SPRING, COMPRESSION	12
-	1	1	1	1	1	1	1-356885-4	STOP, SHEAR	11
-	1	1	1	1	1	1	2119805-1	SHEAR HOLDER, FRONT	10
-	1	1	1	1	1	1	1803095-6	FLOATING SHEAR, FRONT	9
1	2	2	1	1	1	1	8-1333202-5	ANVIL, COMBINATION	8
-	1	1	1	1	1	1	3-240641-8	SPACER	7
-	-	-	-	-	-	-	-	-	6
-	1	1	1	1	1	1	2119757-1	DEPRESSOR, SHEAR	5
-	1	1	1	1	1	1	1-238011-7	BLOCK, CRIMPER SPACER	4
1	2	2	1	1	1	1	9-2119582-0	CRIMPER, INSULATION F PREMIUM	3
-	-	-	-	-	-	-	-	-	2
1	2	2	1	1	1	1	4-456403-2	CRIMPER, WIRE PREMIUM	1

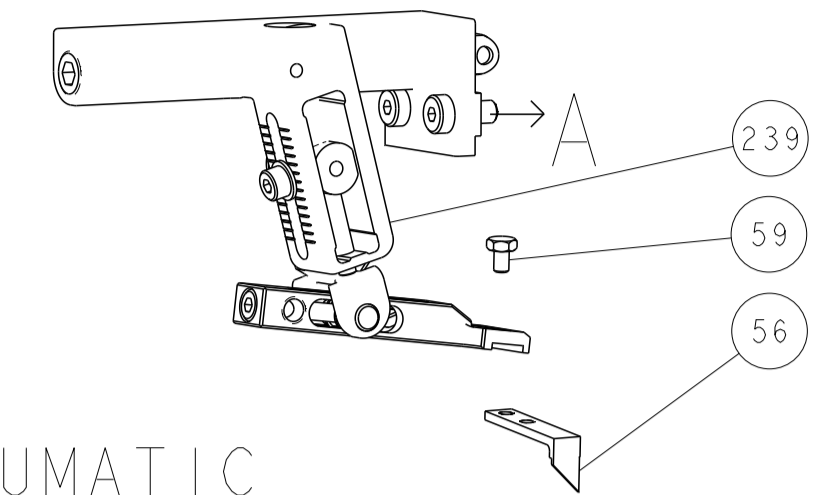
ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

ITEM NO	PART NO	DESCRIPTION
-77	-72	-71
-52	-51	-2
-1		

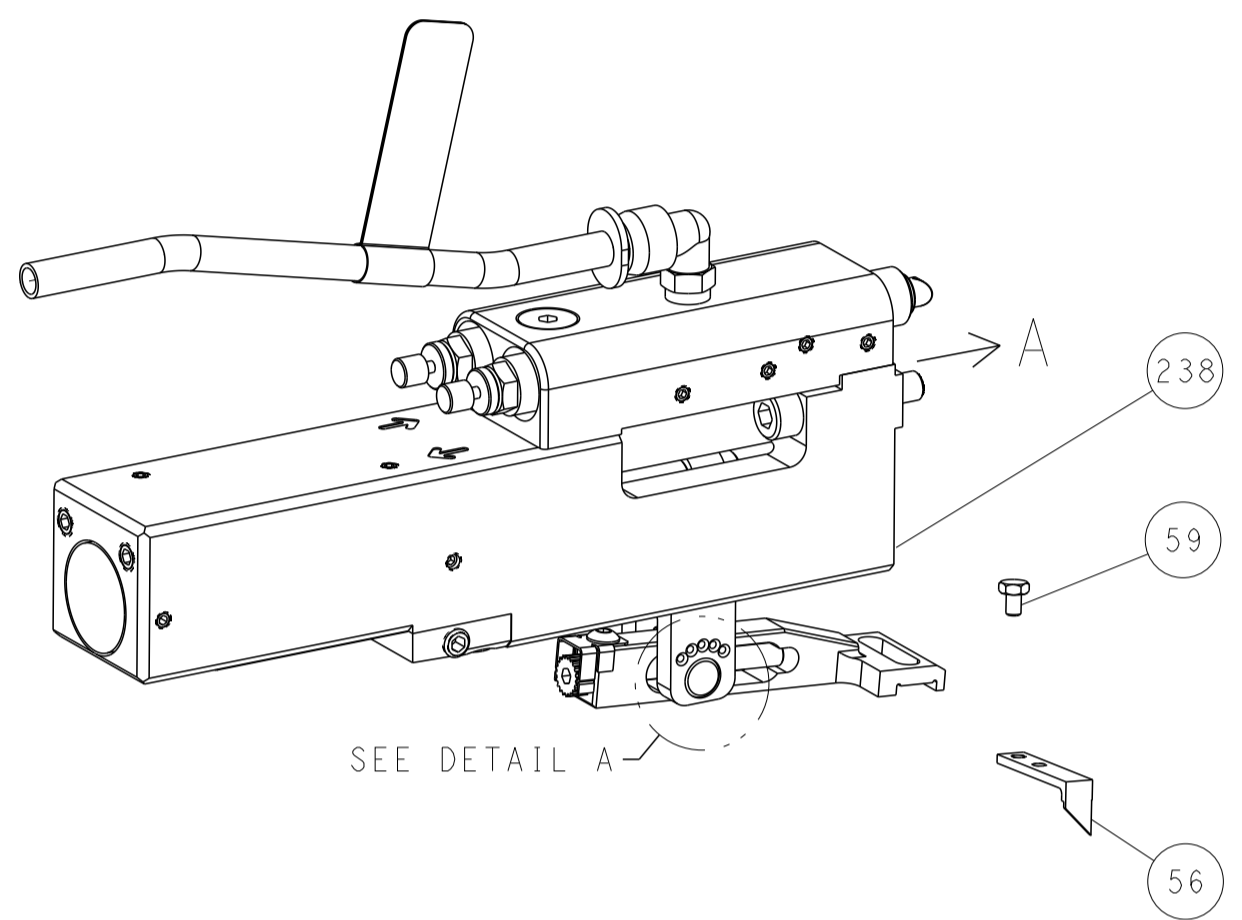
THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION 20 COPYRIGHT 20 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.	OWN: L. ZHANG 10NOV2011 CHK: L. ZHANG 10NOV2011	TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm	TOLERANCES UNLESS OTHERWISE SPECIFIED:	
0 PLC ±	1 PLC ±	NAME: Ocean Side Feed Product: Applicator
2 PLC ±	3 PLC ±	
4 PLC ±	ANGLES ±	
MATERIAL:	FINISH:	
Customer Accessible Production Drawing	SCALE: 1:2	SHEET 1 of 4 REV M

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

FEED TYPE MECHANICAL



PNEUMATIC

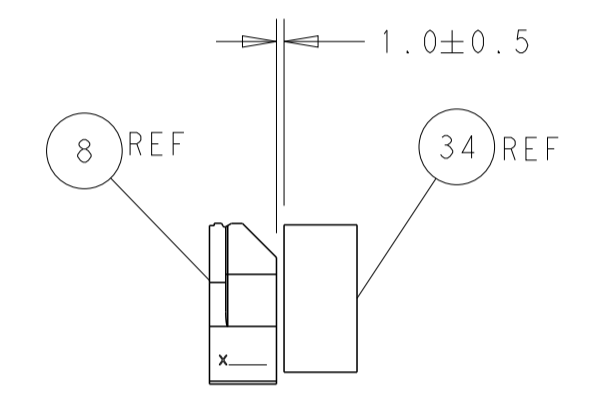
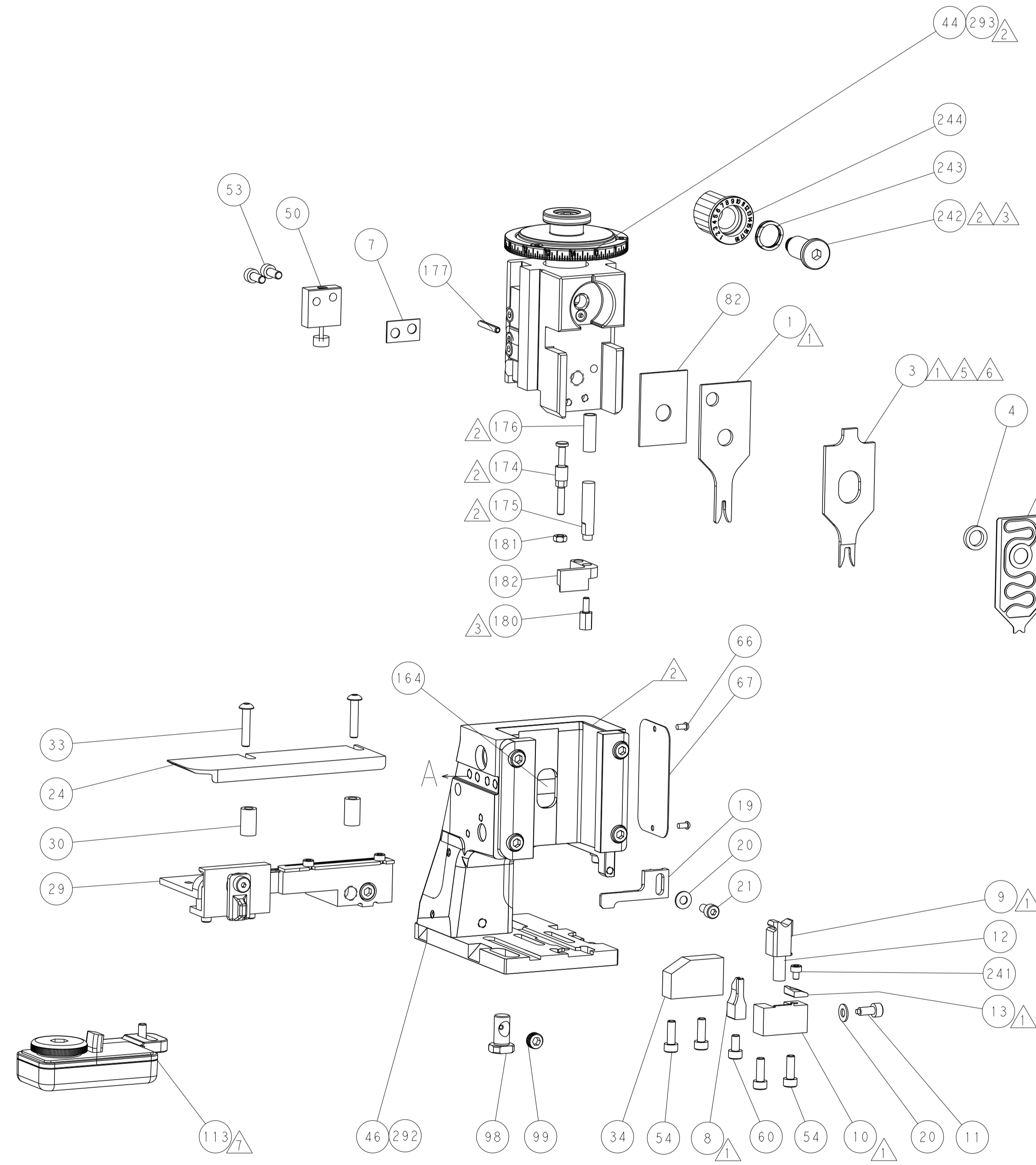
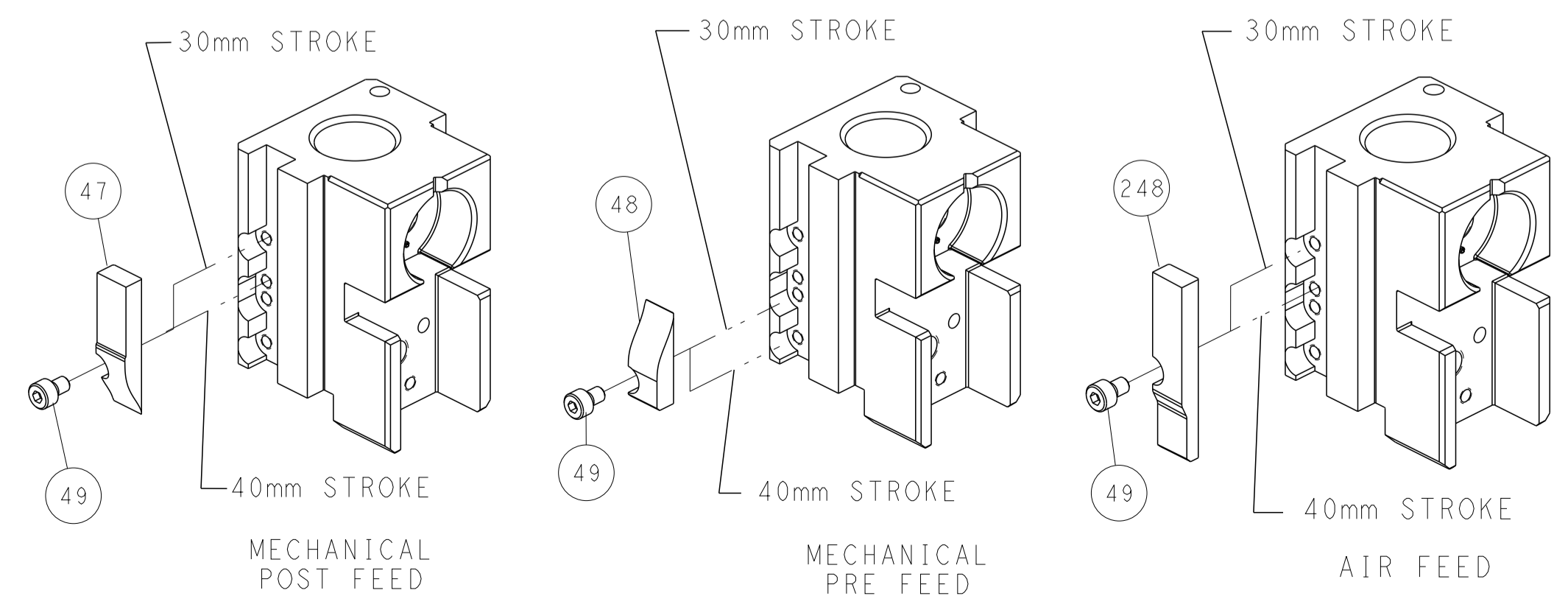


FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)

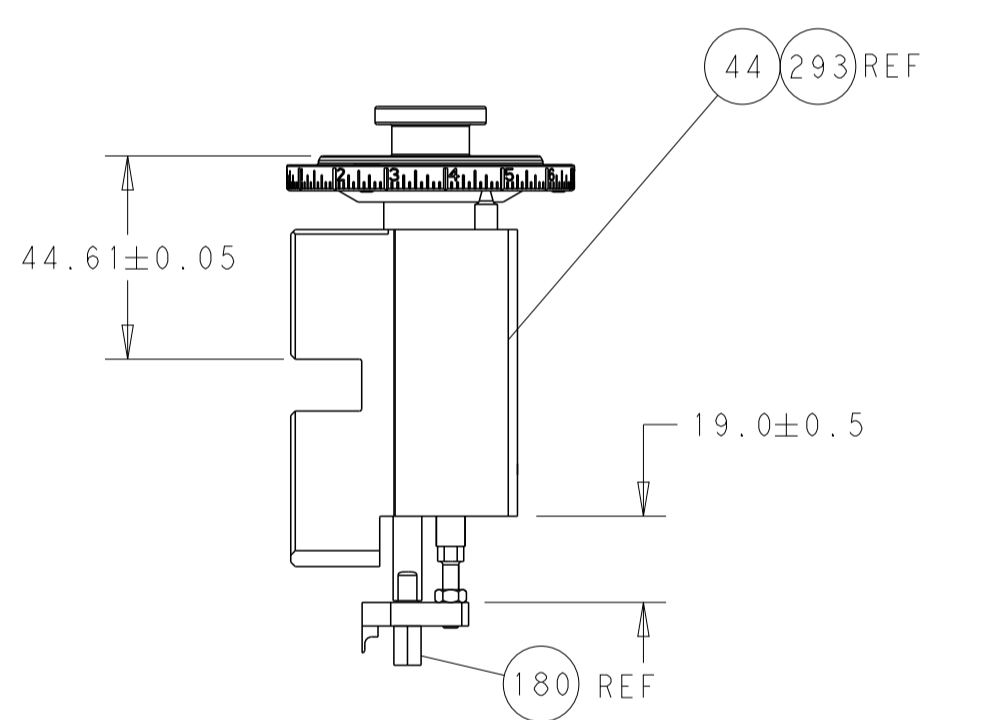


DETAIL A

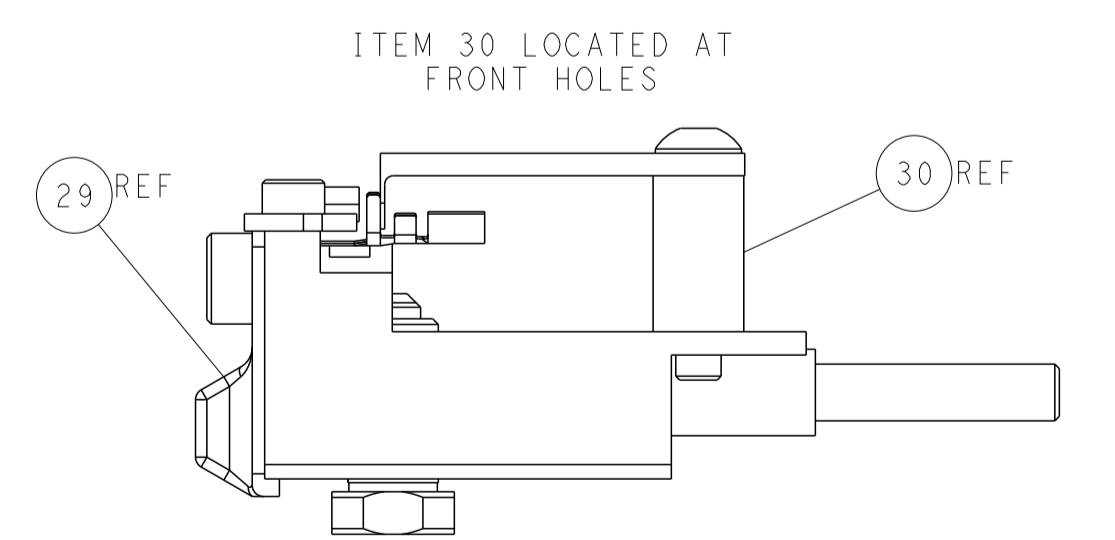
CAM POSITIONS



TERMINAL SUPPORT LOCATION



RAM AND HOLDDOWN 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)

DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH		DWN L. ZHANG 10NOV2011 CHK L. ZHANG 10NOV2011 S. XI 10NOV2011 APVD S. XI PRODUCT SPEC APPLICATION SPEC WEIGHT Customer Accessible Production Drawing		NAME Ocean Side Feed Applicator SIZE CAGE CODE DRAWING NO. RESTRICTED TO A1 00779 C=2151096 SCALE 1:2 SHEET 2 OF 4 REV M	
MATERIAL:				TE Connectivity Harrisburg, PA 17105-3608			

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2151096-1	M	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2151096-2	M	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151096-7	H	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.57 mm [.062]	F
INSUL	3.18 mm [.125]	F

APPLICATOR INSTRUCTIONS
408-35042

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: VAL-U-LOK PIN CONTACT			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
3.00-3.50 mm [.118-.138 IN]		∅ 1.50 - 3.30 mm [.059 -.130 IN]	
TERMINAL APPLICATION SPECIFICATION	114-13172	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
794955-1	794955-2	794955-3	794955-4
794956-1	794956-2	794956-3	794956-4
794956-5			

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: VAL-U-LOK PIN CONTACT			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
3.00-3.50 mm [.118-.138 IN]		∅ 1.50 - 3.30 mm [.059 -.130 IN]	
TERMINAL APPLICATION SPECIFICATION	114-13172	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
2238016-1	2238017-1	2825210-1	2825211-1

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
22 AWG + 20 AWG	1.22+/-0.05 [.048+/- .002]	4.1
17.45AWG OR 0.936mm2	1.17+/-0.05 [.046+/- .002]	5.6
18 AWG OR 0.87mm2	1.09+/-0.05 [.043+/- .002]	5.8
2 X 22 AWG	1.09+/-0.05 [.043+/- .002]	5.8
20 AWG OR 0.50mm2	0.99+/-0.05 [.039+/- .002]	6.8
22 AWG OR 0.35mm2	0.80+/-0.05 [.031+/- .002]	7.7

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
22 AWG + 20 AWG	1.22+/-0.05 [.048+/- .002]	4.1
18 AWG OR 0.87mm2	1.09+/-0.05 [.043+/- .002]	5.8
2 X 22 AWG	1.09+/-0.05 [.043+/- .002]	5.8
20 AWG OR 0.50mm2	0.99+/-0.05 [.039+/- .002]	6.8
22 AWG OR 0.35mm2	0.80+/-0.05 [.031+/- .002]	7.7

- 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.
- INSTALL ITEM 3 AS SHOWN FOR TERMINALS 2238016 AND 2238017.
- INSTALL ITEM 3 WITH RELIEF INWARDS AGAINST ITEM 1 FOR TERMINALS 794955 AND 794956.
- TERMINAL LUBRICANT IS RECOMMENDED.
- 8. 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	-	-	-

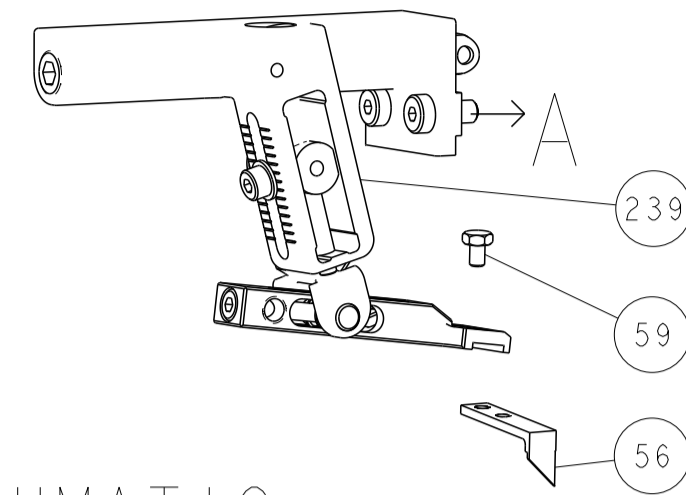
-	1	1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
-	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	1	-	2844940-1	AIR FEED MODULE	238
-	REF	REF	994970-2	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	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113
-	1	1	2844908-1	SCREW, LOCKING	99
-	1	1	2844907-1	POST, LOCKING	98
-	1	1	1-455888-1	SPACER, CRIMPER	82
-	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	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	1752356-1	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	1-356885-4	STOP, SHEAR	11
-	1	1	2119805-1	SHEAR HOLDER, FRONT	10
-	1	1	1803095-6	FLOATING SHEAR, FRONT	9
-	1	1	8-1333202-5	ANVIL, COMBINATION	8
-	1	1	3-240641-8	SPACER	7
-	-	-	-	-	6
-	1	1	2119757-1	DEPRESSOR, SHEAR	5
-	1	1	1-238011-7	BLOCK, CRIMPER SPACER	4
-	1	1	9-2119582-0	CRIMPER, INSULATION F PREMIUM	3
-	-	-	-	-	2
-	1	1	4-456403-2	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)

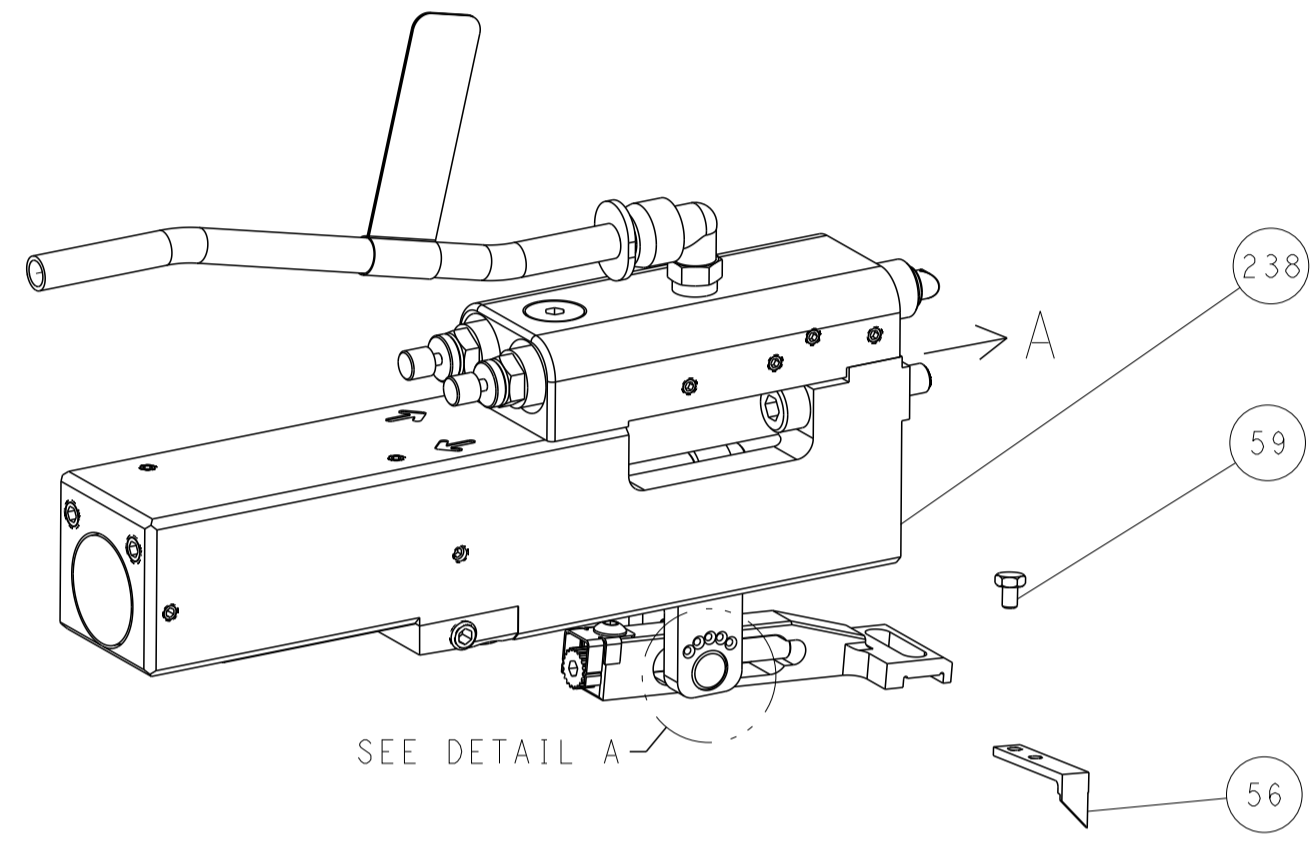
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		MATERIAL:		FINISH:		WEIGHT:		SCALE:		SHEET:		REV:	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES	FINISH			Customer Accessible Production Drawing	1:2	3	4	M	

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

FEED TYPE MECHANICAL



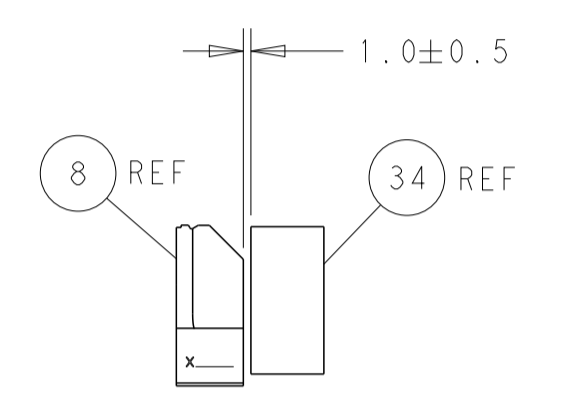
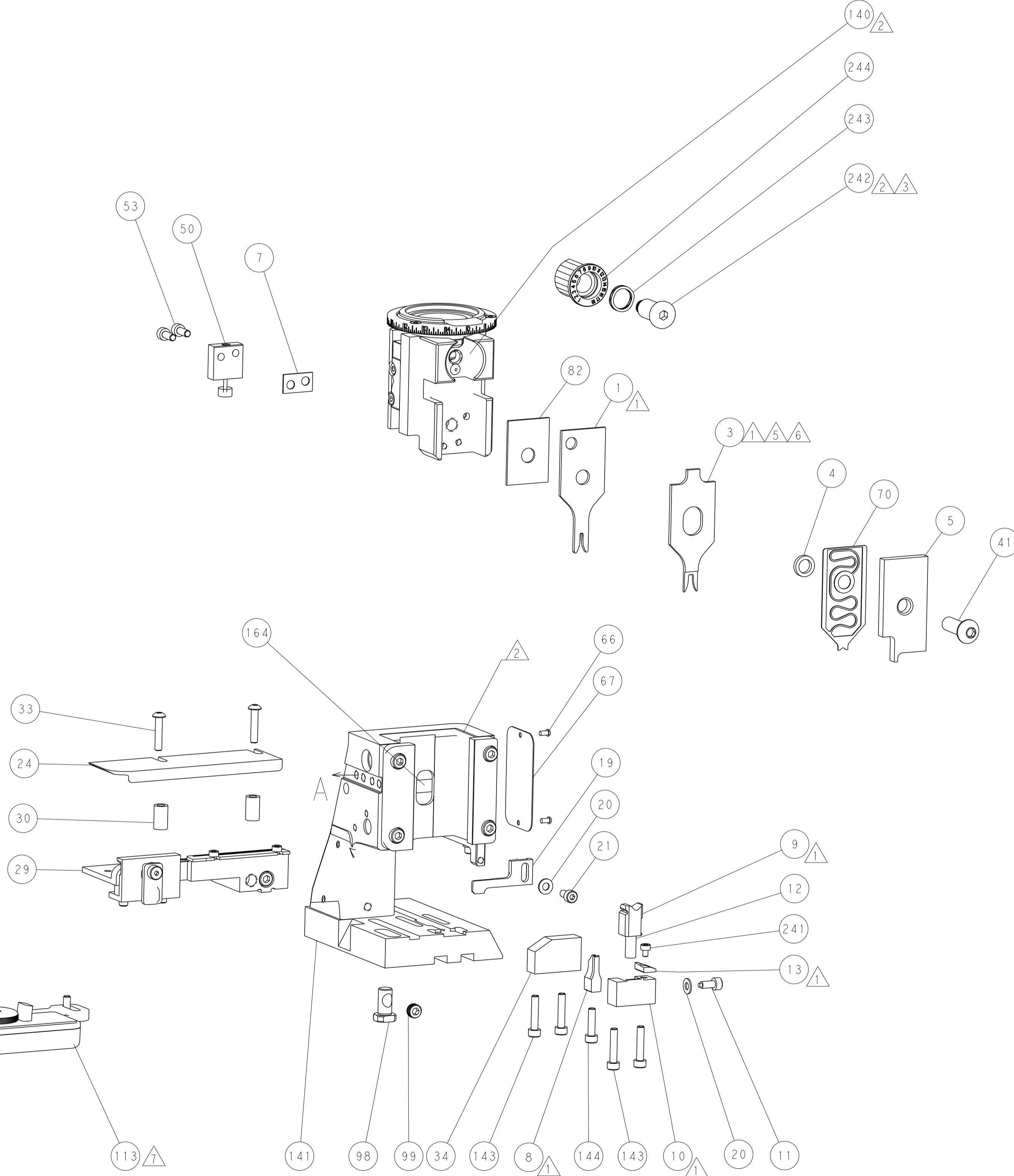
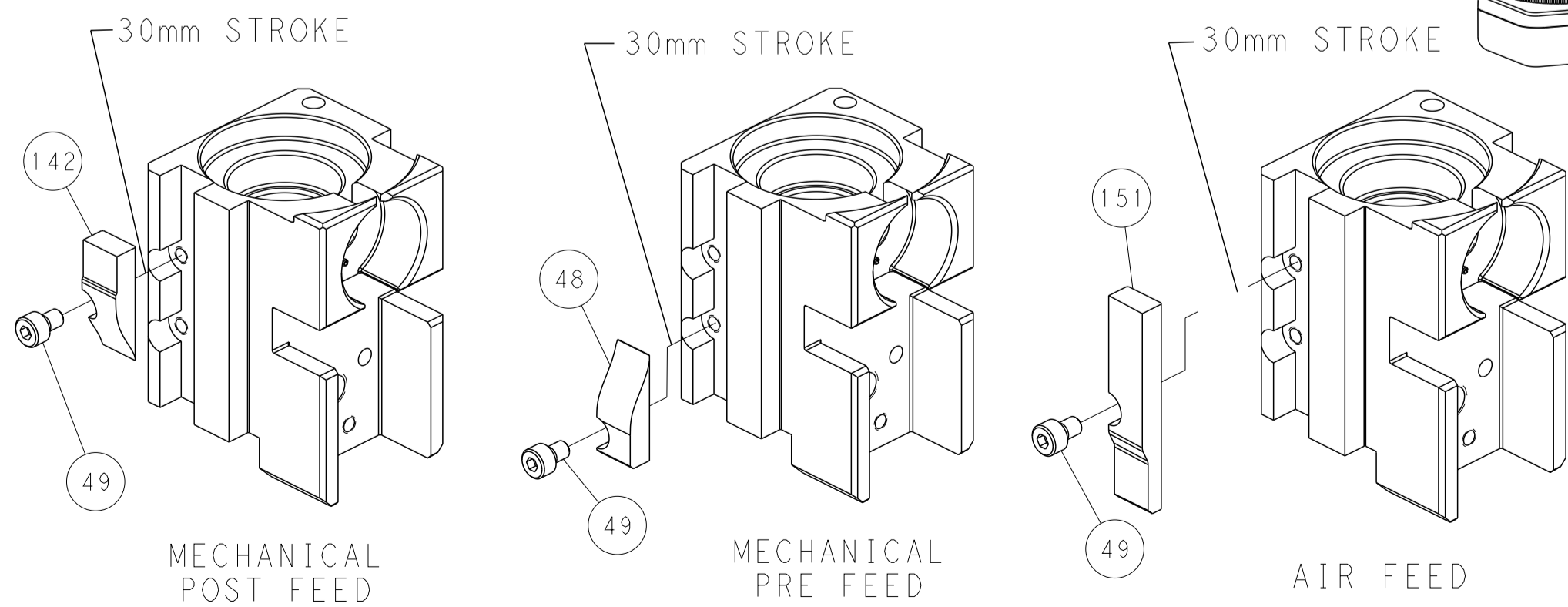
PNEUMATIC



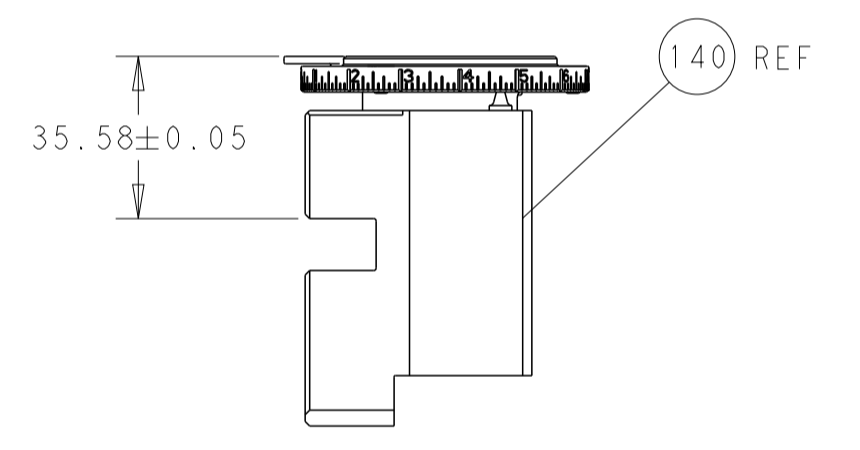
FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



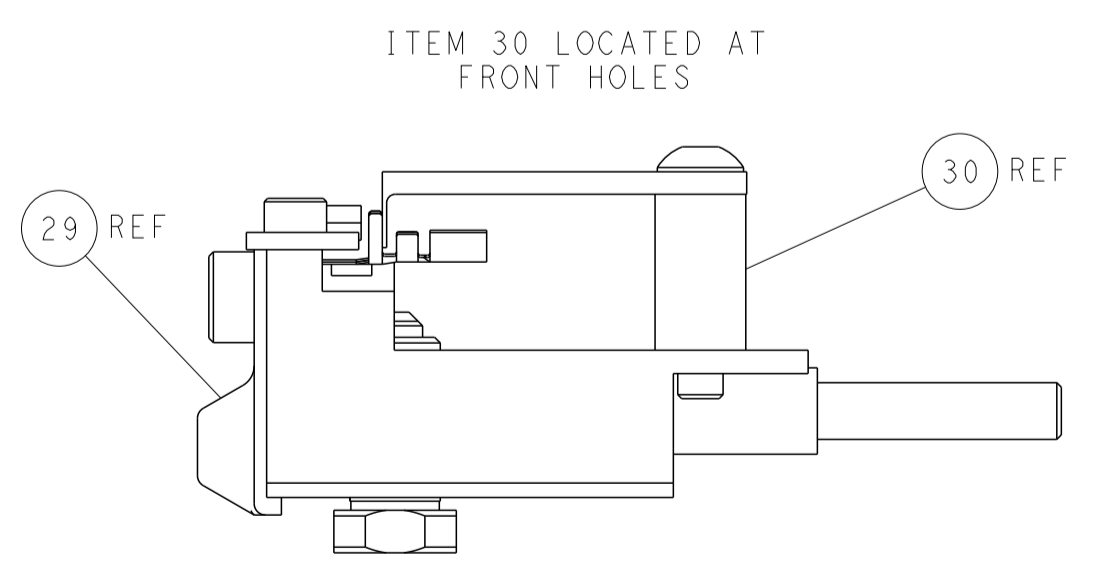
CAM POSITIONS



TERMINAL SUPPORT LOCATION



RAM SET-UP



FEED TRACK POSITION GUIDE BY INSULATION BARREL

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 ±		NAME Ocean Side Feed Applicator PRODUCT SPEC APPLICATION SPEC SIZE CAGE CODE DRAWING NO WEIGHT 00779 C=2151096	RESTRICTED TO SCALE 1:2 SHEET 4 OF 4 REV M
MATERIAL:		Customer Accessible Production Drawing	