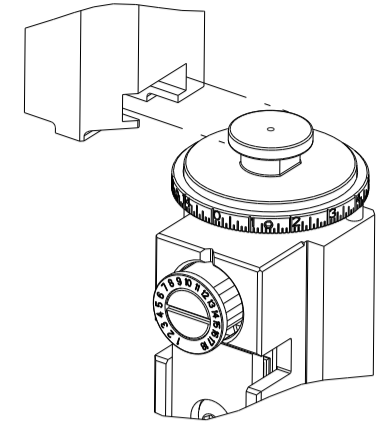


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151105-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2151105-2	D	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
5-2151105-1	C	SEAL STRIPPER CRIMPER TERMINATING UNIT	MECHANICAL
5-2151105-2	D	SEAL STRIPPER CRIMPER TERMINATING UNIT	PNEUMATIC
7-2151105-1	C	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2151105-2	D	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2151105-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



*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.

APPLICATOR DATA

CRIMP	SIZE	TYPE
WIRE	1.57 mm [.062]	F
INSUL	3.40 mm [.134]	Ø

APPLICATOR INSTRUCTIONS
408-35042

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION

TERMINAL NAME: RECEPTACLE CONTACT 070 TYPE

WIRE STRIP LENGTH 4.00-4.50 mm [1.57-.177 IN]	INSULATION DIAMETER RANGE Ø
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TERMINAL APPLICATION SPECIFICATION

114-5082

TERMINALS APPLIED

TE TERMINAL	TE TERMINAL	TE SEAL	TE SEAL	SEAL INSULATION DIAMETER RANGE
(A) 171630-1	171630-2	172746-1	9-172746-1	1.4-2.4
(A) 171630-5	-	178210-1	1-178210-3	1.4-2.1
			347681-1	1.1-1.4
			347874-1	1.6-2.4
			2822352-1	1.4-2.4

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.50mm2	1.09+/-0.05 [.043+/- .002]	6.4
0.30mm2	1.06+/-0.05 [.042+/- .002]	6.8
0.20mm2	1.00+/-0.05 [.039+/- .002]	7.4

- 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. APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 180.
- 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.
- APPLY TORO-SEAL IN ALLEN SOCKET TO FILL HOLE AFTER FLAT HD HAS BEEN ADJUSTED TO CORRECT HEIGHT AT QUALIFICATION. APPLY #1-23419-5 LOC-TITE TO THREADS.

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION

TERMINAL NAME: PECEPTACLE CONTACT 070 TYPE

WIRE STRIP LENGTH 4.00-4.50mm [1.57-.177 IN]	INSULATION DIAMETER RANGE Ø
---	--------------------------------

TERMINAL APPLICATION SPECIFICATION

114-3040

TERMINALS APPLIED

TE TERMINAL	TE TERMINAL	TE SEAL	TE SEAL	SEAL INSULATION DIAMETER RANGE
345808-1	347661-1	172746-1	9-172746-1	1.4-2.4
			178210-1	1.4-2.1
			347681-1	1.1-1.4
			347874-1	1.6-2.4
			2822352-1	1.4-2.4

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.50mm2	1.14+/-0.05 [.045+/- .002]	5.7
0.35mm2	1.07+/-0.05 [.042+/- .002]	6.8

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION

TERMINAL NAME: PECEPTACLE CONTACT 070 TYPE

WIRE STRIP LENGTH 4.00-4.50mm [1.57-.177 IN]	INSULATION DIAMETER RANGE Ø
---	--------------------------------

TERMINAL APPLICATION SPECIFICATION

114-3142

TERMINALS APPLIED

TE TERMINAL	TE TERMINAL	TE SEAL	TE SEAL	SEAL INSULATION DIAMETER RANGE
345808-1	-	172746-1	9-172746-1	1.4-2.4
			178210-1	1.4-2.1
			347681-1	1.1-1.4
			347874-1	1.6-2.4
			2822352-1	1.4-2.4

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.22mm2	1.00+/-0.05 [.039+/- .002]	7.4

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

LOC	DIST	REV	DATE	BY	CHKD	APVD
A	66	B	30JUN2017	TB	TE	
		C	12AUG2018	TB	TE	
		D	02NOV2020	JWC	TE	
		D1	25JUL2022	FZ	YY	

REV	DATE	DESCRIPTION	BY	CHKD	APVD	ITEM NO
-	-	1803515-3				293
-	-	2-1803583-1				292
-	-	2119641-1				248
-	-	2119082-7				244
-	-	2079764-1				243
-	-	2119083-1				242
-	-	7-18023-7				241
-	-	2119580-1				239
-	-	2844940-1				238
-	-	4-1722335-3				182
-	-	1-5018030-0				181
-	-	2-1752354-0				180
-	-	993111-1				177
-	-	5-22280-0				176
-	-	1752353-3				175
-	-	1901680-2				174
-	-	994970-2				164
-	-	1-18028-2				119
-	-	2119955-1				113
-	-	2844908-1				99
-	-	2844907-1				98
-	-	455888-5				82
-	-	1803607-3				71
-	-	2119740-1				67
-	-	2168078-1				66
-	-	2168083-2				60
-	-	5-18022-5				59
-	-	985575-3				57
-	-	1338685-1				56
-	-	2168083-3				54
-	-	2168083-3				53
-	-	5018030-1				52
-	-	811242-5				51
-	-	690753-2				50
-	-	18023-9				49
-	-	2119652-1				48
-	-	2119653-1				47
-	-	1803583-9				46
-	-	1803515-1				44
-	-	1803602-1				41
-	-	1752356-3				34
-	-	2079383-5				33
-	-	2-2844962-8				30
-	-	2844992-1				29
-	-	455888-3				28
-	-	1320928-2				24
-	-	2168083-2				21
-	-	1-18028-2				20
-	-	2119533-1				19
-	-	2119806-1				13
-	-	3-22280-3				12
-	-	1-356885-4				11
-	-	2119805-1				10
-	-	318707-1				9
-	-	1333202-6				8
-	-	3-240641-4				7
-	-	2119781-1				5
-	-	5-238011-5				4
-	-	1803018-3				3
-	-	1-455888-0				2
-	-	1-456403-2				1

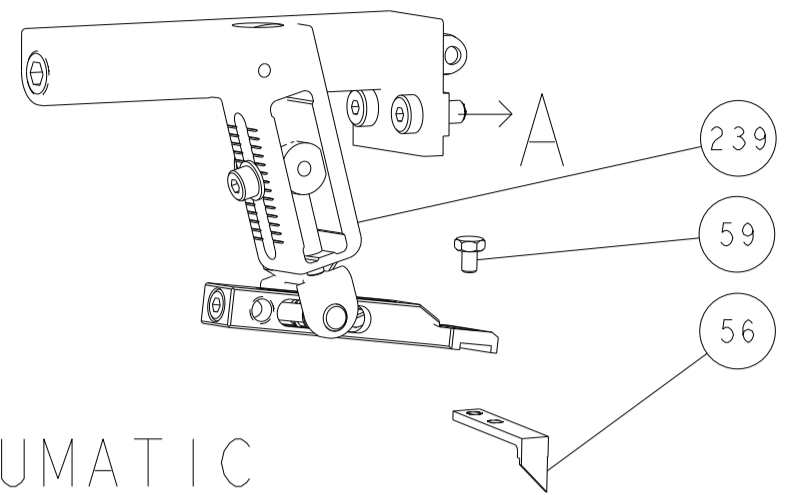
PART NO		DESCRIPTION	ITEM NO
77	72-71-52-51-2	-1	

DIMENSIONS:	TOLERANCES UNLESS OTHERWISE SPECIFIED:	OWN	30MAY2011
mm	0 PLC ±	CHK	C. CHEN
	1 PLC ±		30MAY2011
	2 PLC ±		S. XI
	3 PLC ±	NAME	J. CRUZ
	4 PLC ±		30MAY2011
	ANGLES ±	PRODUCT SPEC	
	FINISH ±	APPLICATION SPEC	
MATERIAL		WEIGHT	

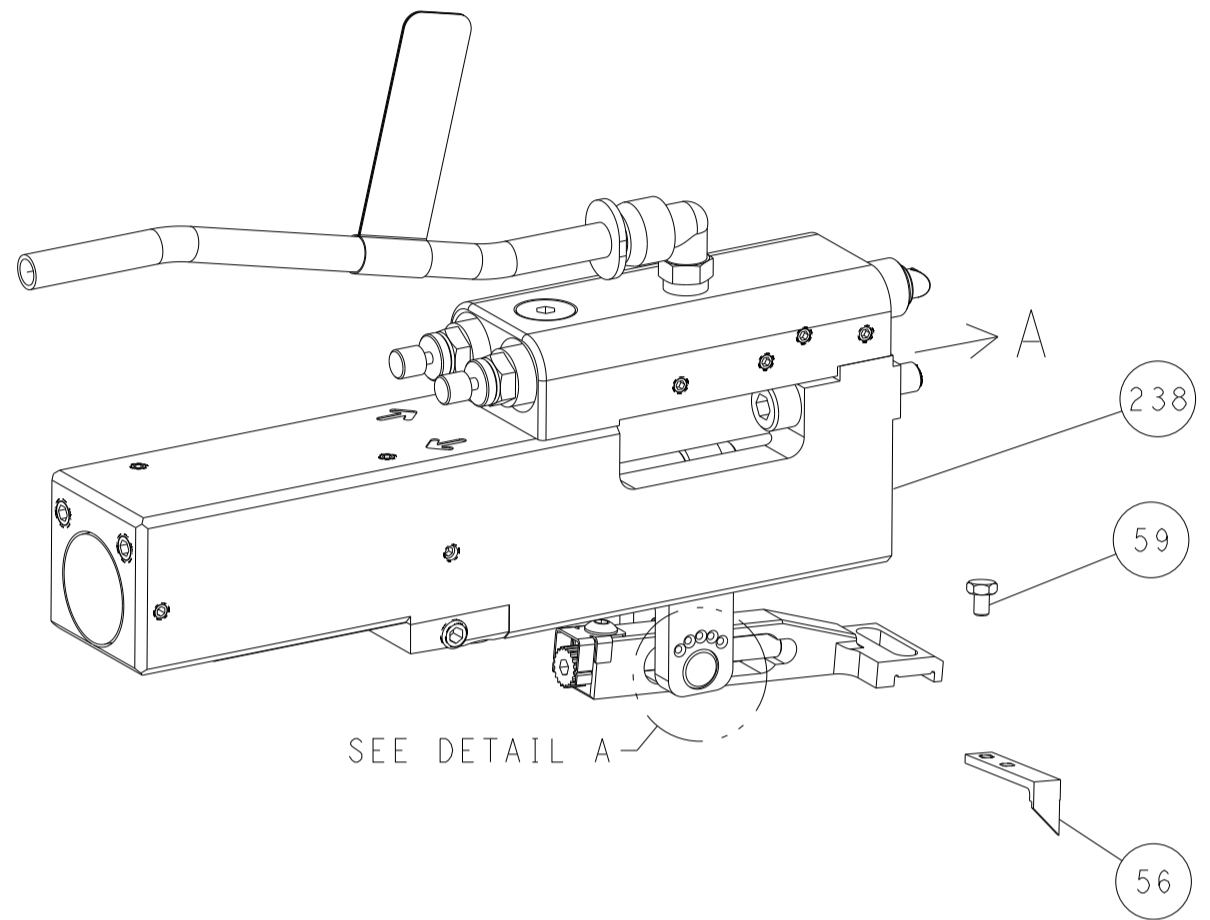
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A1	00779	C=2151105	
Customer Accessible Production Drawing			SCALE 1:2 SHEET 1 of 4 REV D1

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

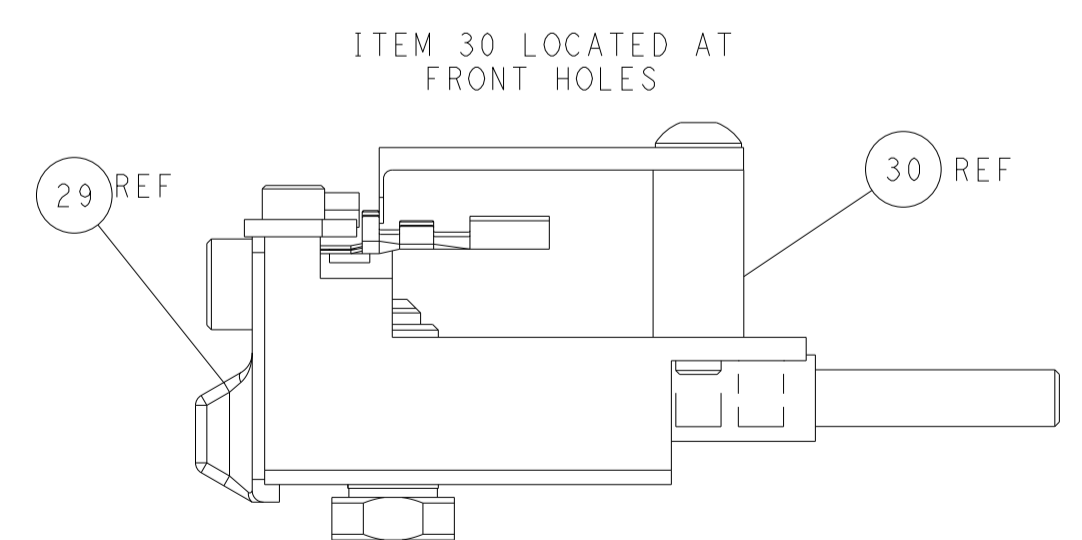
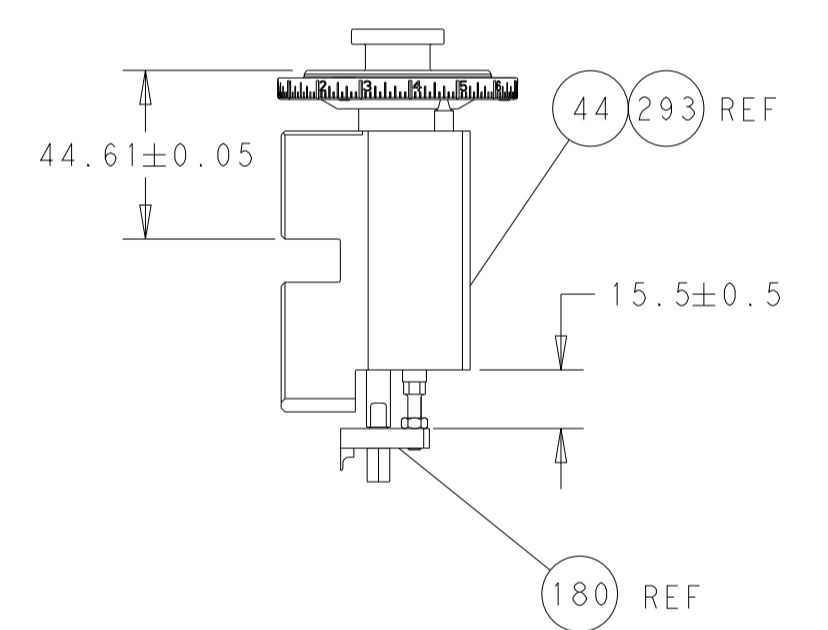
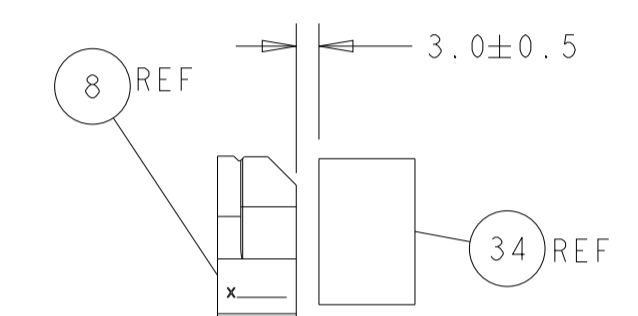
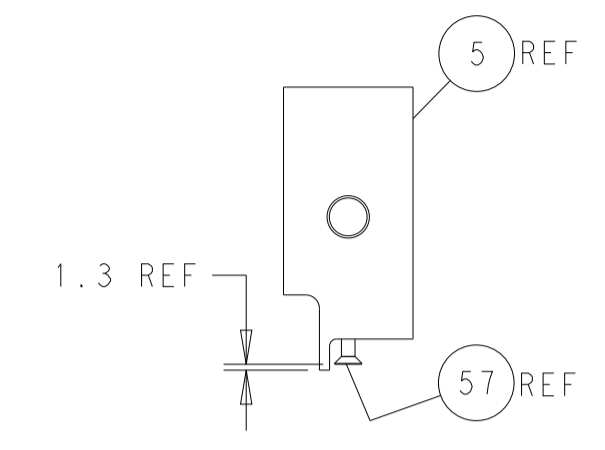
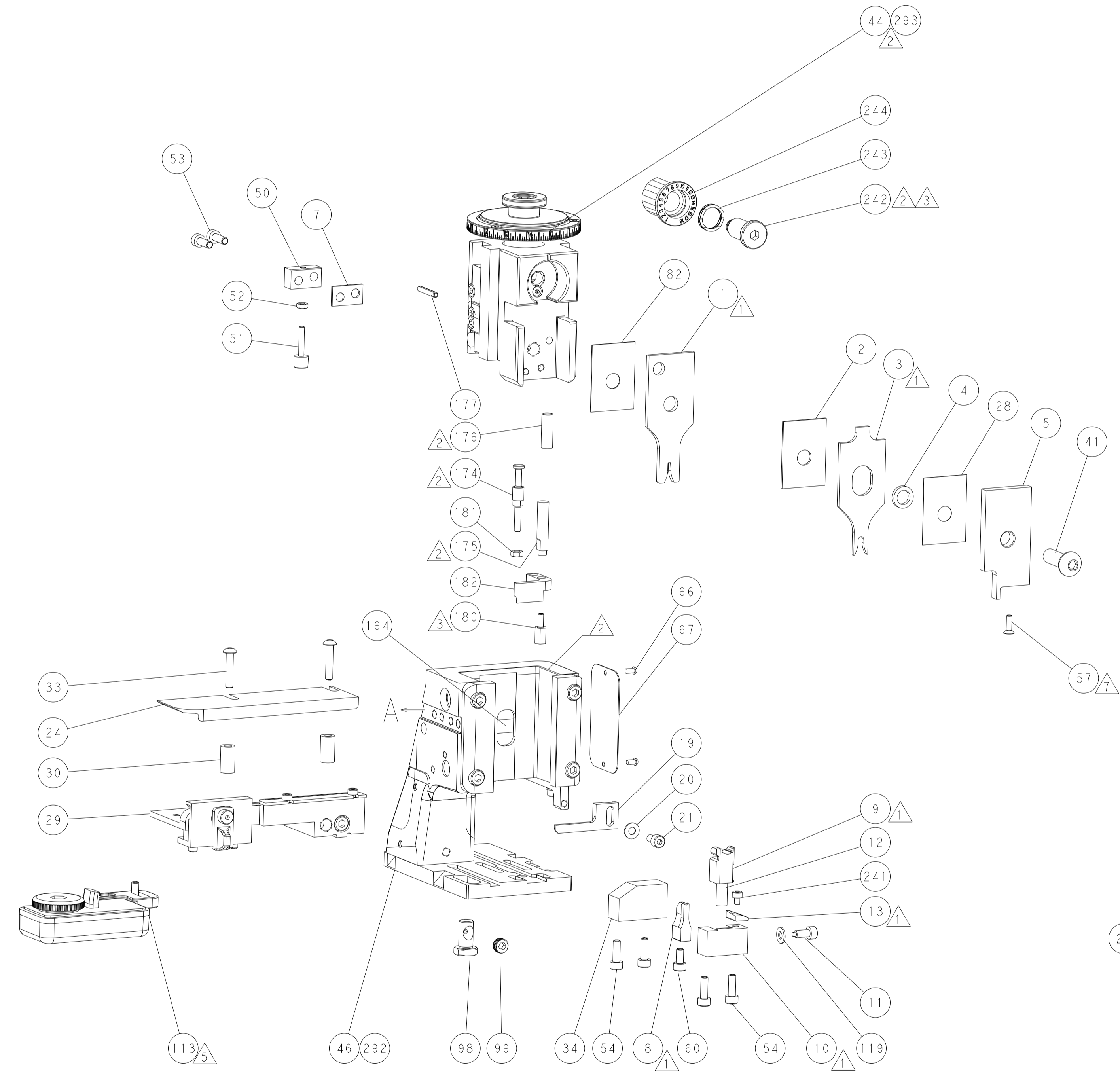
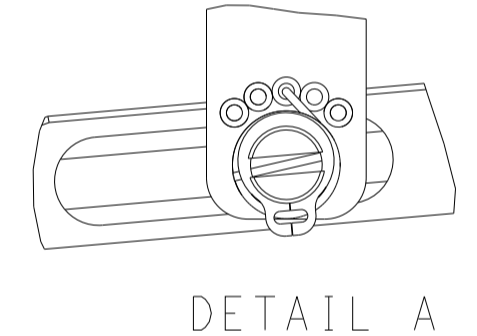
FEED TYPE MECHANICAL



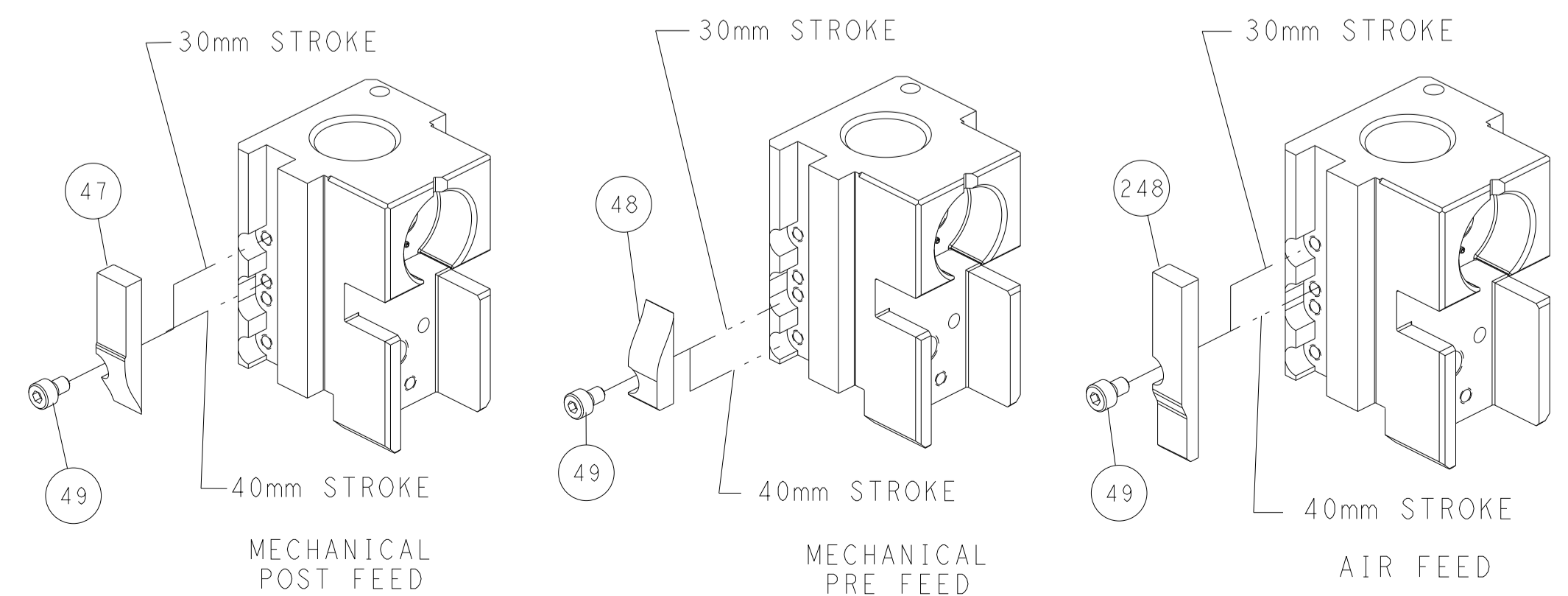
PNEUMATIC



FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



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 UNPUBLISHED. RELEASED FOR PUBLICATION. ALL RIGHTS RESERVED. © 2011 TYCO ELECTRONICS CORPORATION. THIS DRAWING IS CONTROLLED DOCUMENT. FOR THE ELECTRONICS CORPORATION. IT IS THE PROPERTY OF TYCO ELECTRONICS CORPORATION AND IS NOT TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, INCLUDING PHOTOCOPYING, RECORDING, OR BY ANY INFORMATION STORAGE AND RETRIEVAL SYSTEM, WITHOUT THE WRITTEN PERMISSION OF TYCO ELECTRONICS CORPORATION.</small>		DWN: C. CHEN CHK: S. XI APVD: J. CRUZ DATE: 30MAY2011 PRODUCT SPEC: 30MAY2011	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: 2151105 WEIGHT: - SCALE: 1:2	SHEET 2 OF 4 REV D1

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2151105-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2151105-2	D	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151105-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



***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.

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.57 mm [.062]	F
INSUL	3.40 mm [.134]	O

APPLICATOR INSTRUCTIONS 408-35042

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: RECEPTACLE CONTACT 070 TYPE			
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE		
4.00-4.50 mm [.157-.177 IN]	∅		
TERMINAL APPLICATION SPECIFICATION	114-5082	-	-

TERMINALS APPLIED				
TE TERMINAL	TE TERMINAL	TE SEAL	TE SEAL	SEAL INSULATION DIAMETER RANGE
(A) 171630-1	171630-2	172746-1	9-172746-1	1.4-2.4
(A) 171630-5	-	178210-1	1-178210-3	1.4-2.1
			347681-1	1.1-1.4
			347874-1	1.6-2.4
			2822352-1	1.4-2.4

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.50mm2	1.09+/-0.05 [.043+/- .002]	6.4
0.30mm2	1.06+/-0.05 [.042+/- .002]	6.8
0.20mm2	1.00+/-0.05 [.039+/- .002]	7.4

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: RECEPTACLE CONTACT 070 TYPE			
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE		
4.00-4.50mm [.157-.177 IN]	∅		
TERMINAL APPLICATION SPECIFICATION	114-3040	-	-

TERMINALS APPLIED				
TE TERMINAL	TE TERMINAL	TE SEAL	TE SEAL	SEAL INSULATION DIAMETER RANGE
345808-1	347661-1	172746-1	9-172746-1	1.4-2.4
		178210-1	1-178210-3	1.4-2.1
			347681-1	1.1-1.4
			347874-1	1.6-2.4
			2822352-1	1.4-2.4

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.50mm2	1.14+/-0.05 [.045+/- .002]	5.7
0.35mm2	1.07+/-0.05 [.042+/- .002]	6.8

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: RECEPTACLE CONTACT 070 TYPE			
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE		
4.00-4.50mm [.157-.177 IN]	∅		
TERMINAL APPLICATION SPECIFICATION	114-3142	-	-

TERMINALS APPLIED				
TE TERMINAL	TE TERMINAL	TE SEAL	TE SEAL	SEAL INSULATION DIAMETER RANGE
345808-1	-	172746-1	9-172746-1	1.4-2.4
		178210-1	1-178210-3	1.4-2.1
			347681-1	1.1-1.4
			347874-1	1.6-2.4
			2822352-1	1.4-2.4

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.22mm2	1.00+/-0.05 [.039+/- .002]	7.4

- 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.
- UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- APPLY TORQ-SEAL IN ALLEN SOCKET TO FILL HOLE AFTER FLAT HD HAS BEEN ADJUSTED TO CORRECT HEIGHT AT QUALIFICATION. APPLY #1-23419-5 LOC-TITE TO THREADS.

ENTRY LEVEL APPLICATOR		ITEM SUBSTITUTION LIST		
PART NUMBER	SAME AS	ITEM	ITEM DESCRIPTION	SUBSTITUTE PART NUMBER
8-2151105-1	2151105-1	1	WIRE CRIMPER	1-1803547-2
8-2151105-2	2151105-2	3	INSULATION CRIMPER	1803597-3
9-2151105-1	2-2151105-1	46	BASIC SUB -ASSEMBLY	1803940-9
9-2151105-2	2-2151105-2	141	BASIC SUB -ASSEMBLY LUBRICATOR	1-1803940-0 DELETE

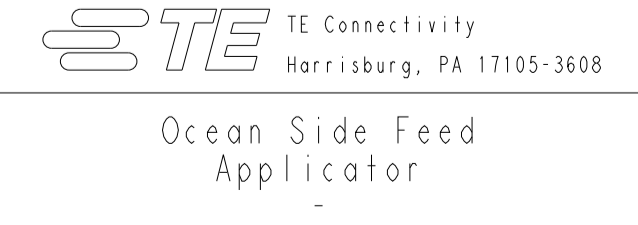
PACIFIC VERSION
Shown on sheets 3 of 4 & 4 of 4
(Atlantic version shown on sheets 1 of 4 & 2 of 4)

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

-	1	1	2119082-7	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	1-18028-2	WASHER, FLAT, REG M4	119
-	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	985575-3	SCR, FLT SKT HD CAP M3 X 10.0	57
-	1	1	1338685-1	PAWL, FEED	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	2-2844962-8	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
-	1	1	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	318707-1	FLOATING SHEAR, FRONT	9
-	1	1	1333202-6	ANVIL, COMBINATION	8
-	1	1	3-240641-4	SPACER	7
-	1	1	2119781-1	DEPRESSOR, SHEAR	5
-	1	1	5-238011-5	BLOCK, CRIMPER SPACER	4
-	1	1	1803018-3	CRIMPER, INSULATION O	3
-	1	1	1-455888-0	SPACER, CRIMPER	2
-	1	1	1-456403-2	CRIMPER, WIRE PREMIUM	1

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

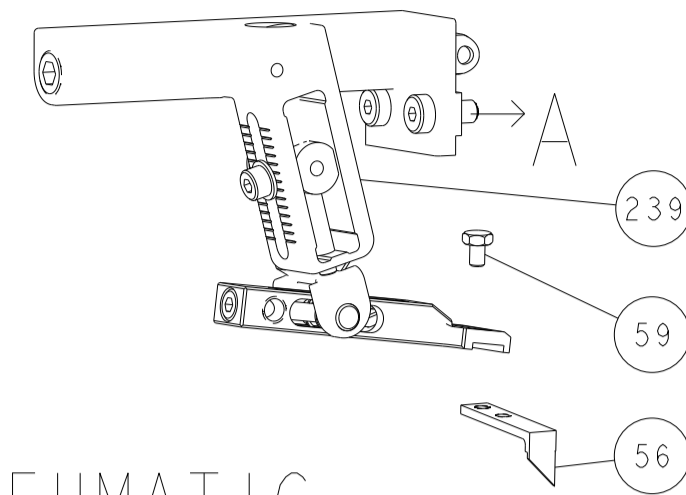
Customer Accessible Production Drawing



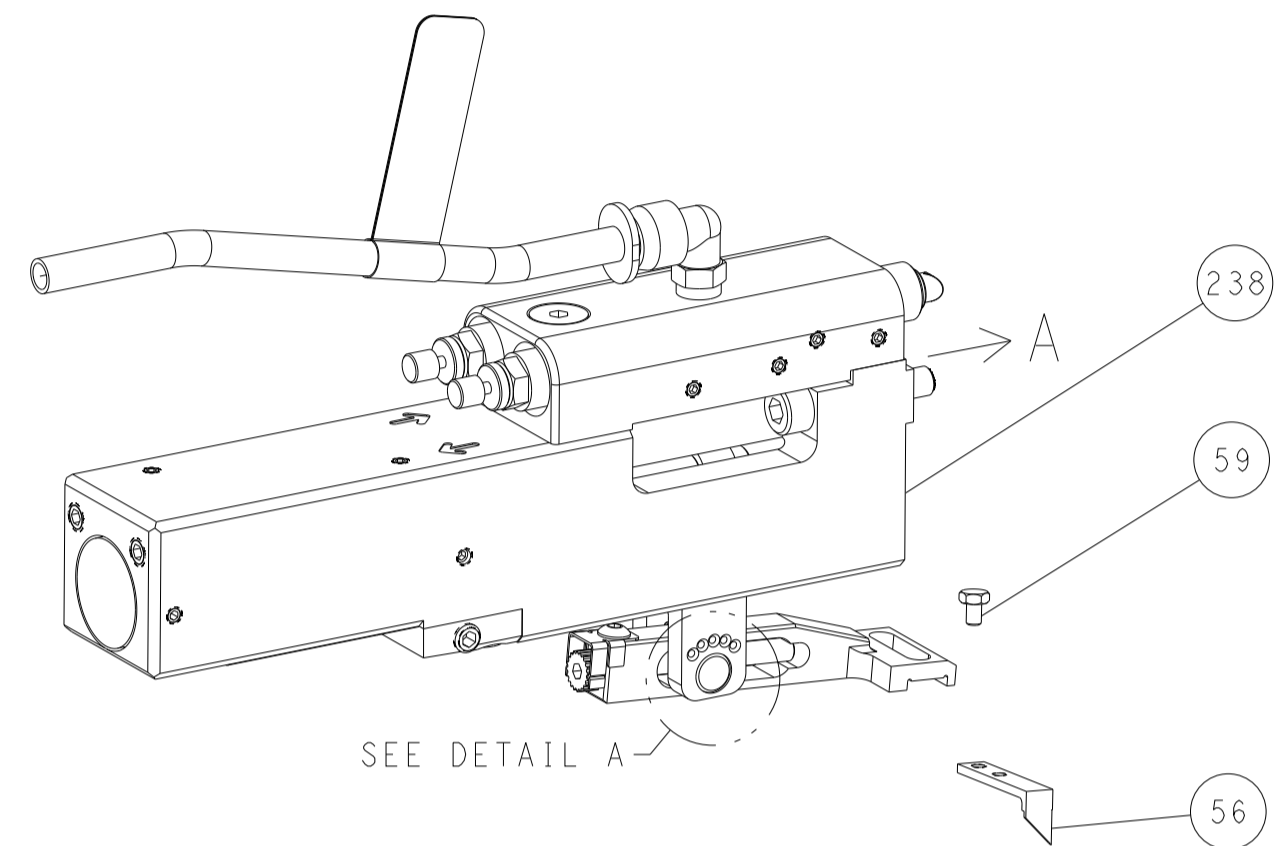
Ocean Side Feed
Applicator

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

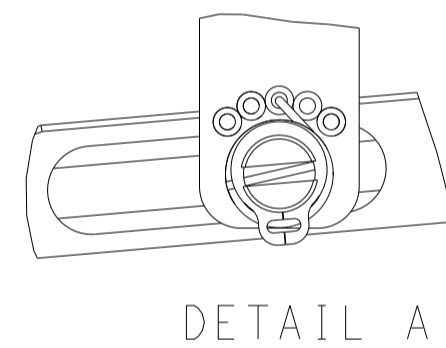
FEED TYPE MECHANICAL



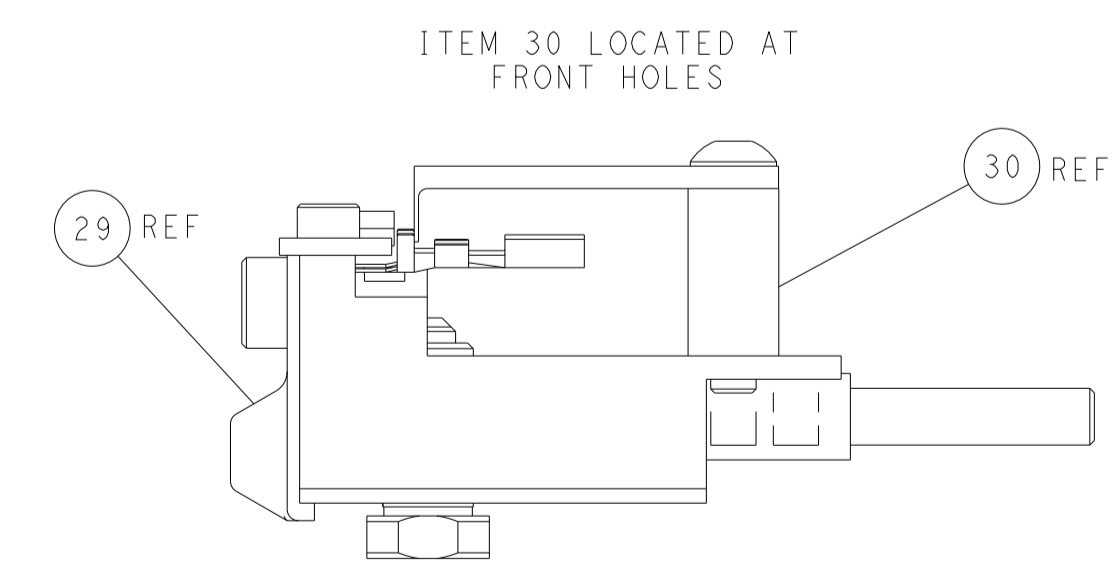
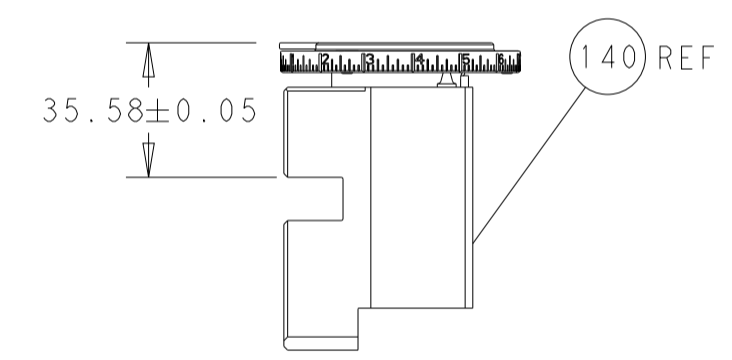
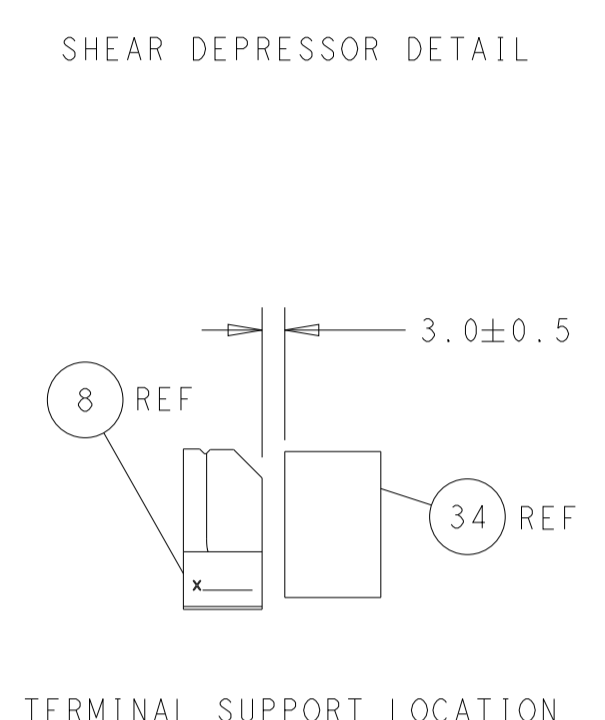
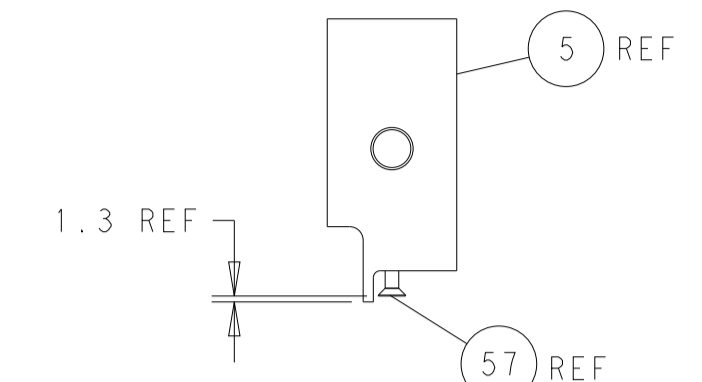
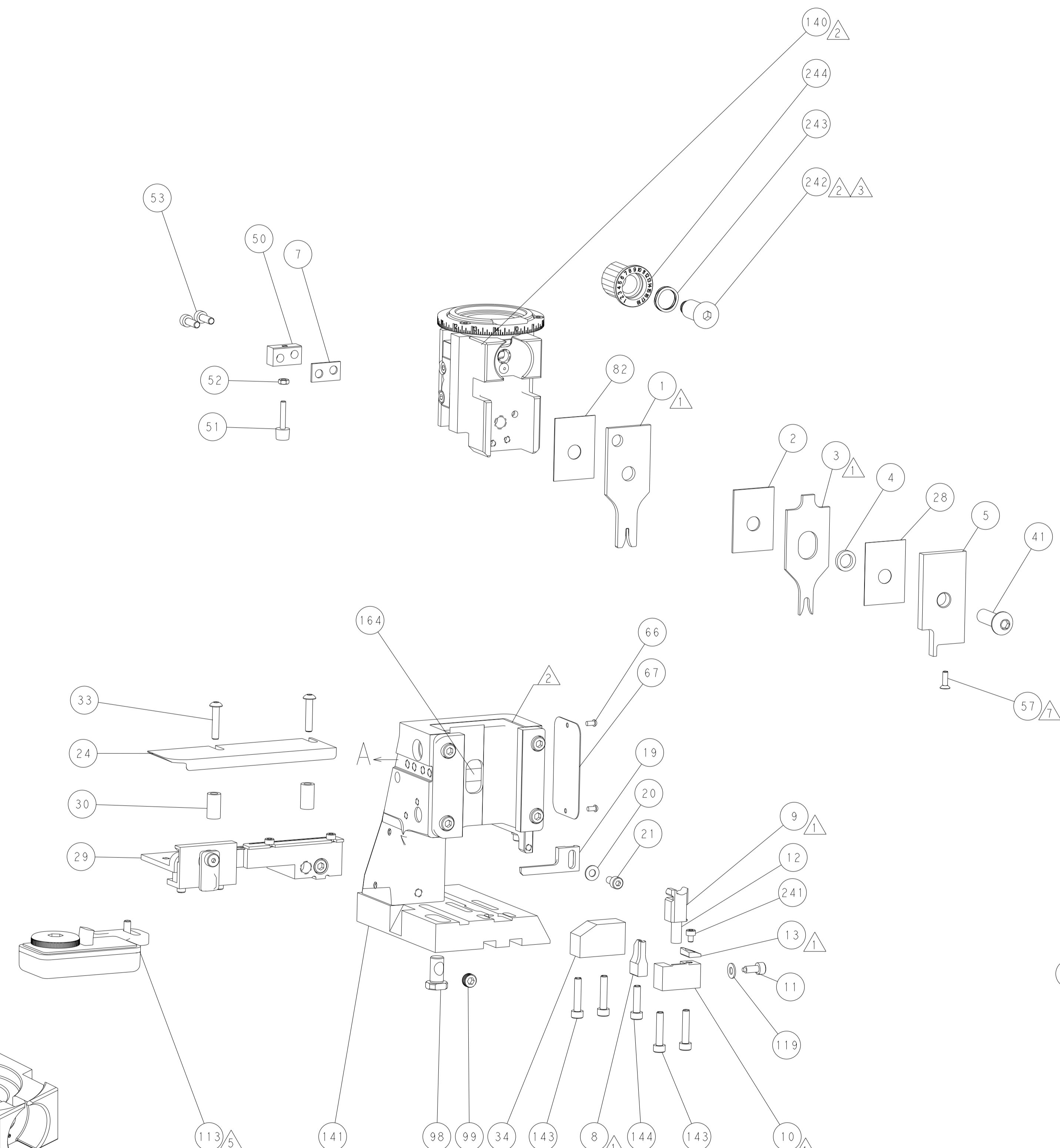
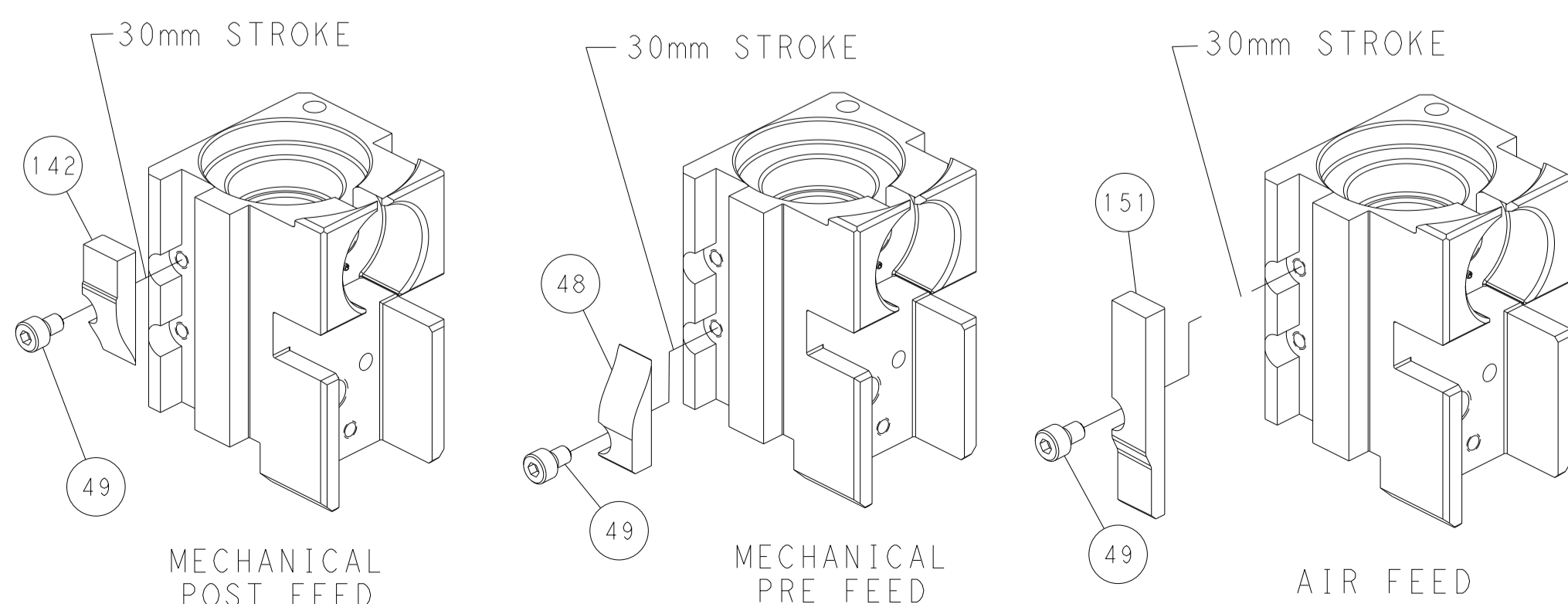
PNEUMATIC



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		NAME: Ocean Side Feed Applicator APPLICATION SPEC: - SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2151105 SCALE: 1:2 SHEET: 4 OF 4 REV: 1	RESTRICTED TO: - Customer Accessible Production Drawing