

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151307-1	L	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2151307-2	L	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151307-1	L	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2151307-2	L	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2151307-7	L	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.06 mm [.042]	F
INSUL	1.57 mm [.062]	O

APPLICATOR INSTRUCTIONS 408-35042

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: CONTACT, MOD IV, RECEPTACLE, CRIMP SNAP-IN			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
2.77-4.37 mm [.109-.172 IN]		∅ 1.55 mm [.061 IN] MAX	
TERMINAL APPLICATION SPECIFICATION	114-25003		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
87666-1	87756-2	6-87756-2	102548-5
87666-2	87756-4	6-87756-7	103171-1
87666-3	87756-6	87809-1	103171-4
87666-4	1-87756-1	87809-2	5-103171-1
87666-5	1-87756-2	87809-6	5-103171-4
1-87666-9	1-87756-7	102548-1	

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
22 AWG	0.89 +/- 0.05 [.035 +/- .002]	10.0
24 AWG	0.79 +/- 0.05 [.031 +/- .002]	11.2
26 AWG	0.76 +/- 0.05 [.030 +/- .002]	11.4

- 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.
- 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.

**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
		H		ECR-18-001329	26JAN2018	TB	CT
		J		ECR-18-006102	20APR2018	MEH	JDG
		K		ECR-18-019108	07DEC2018	KH	LZ
		L		ECR-21-111520	25AUG2021	JWC	RK

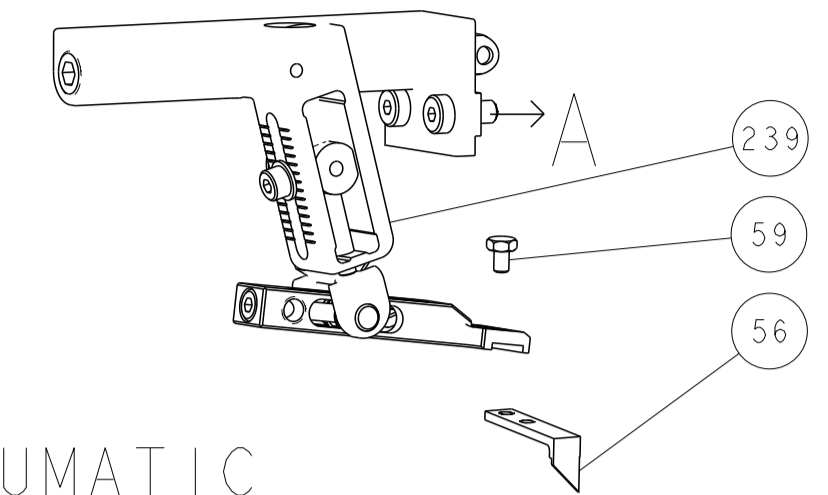
	-	1	1	1	1	2280441-1	INSERT, SHEAR	282
	-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248
	-	1	1	1	1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244
	-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
	-	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
	-	2	2	2	2	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
	-	-	1	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
	-	1	-	1	-	2844940-1	AIR FEED MODULE	238
	-	2	2	2	2	18023-1	SCR, SKT HD CAP M3 X 5.0	237
	-	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	455888-7	SPACER, CRIMPER	82
	-	1	1	1	1	240641-7	SPACER	81
	-	2	2	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	79
	-	1	1	1	1	1901085-4	FENCE	78
	-	1	1	1	1	1803607-3	DOCUMENTATION PACKAGE	71
	-	1	1	1	1	2119791-9	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	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	2-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 14	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	2-2844962-3	SPACER, CYLINDRICAL, STRIP GUIDE	30
	-	1	1	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29
	-	1	1	1	1	2119791-5	DEPRESSOR, WIRE	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	690518-2	HOLD DOWN, TERMINAL	18
	-	1	1	1	1	690463-1	FLOATING SHEAR, REAR	17
	-	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	4-1803250-0	ANVIL, COMBINATION	8
	-	-	-	-	-	-	-	7
	-	1	1	1	1	690468-1	DEPRESSOR SHEAR, REAR	6
	-	1	1	1	1	2119757-6	DEPRESSOR, SHEAR	5
	-	1	1	1	1	2-238011-2	BLOCK, CRIMPER SPACER	4
	1	2	2	1	1	6-1803453-2	CRIMPER, INSULATION O	3
	-	-	-	-	-	-	-	2
	1	2	2	1	1	2-1633730-7	CRIMPER, WIRE	1
	-	-	-	-	-	-	-	0

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

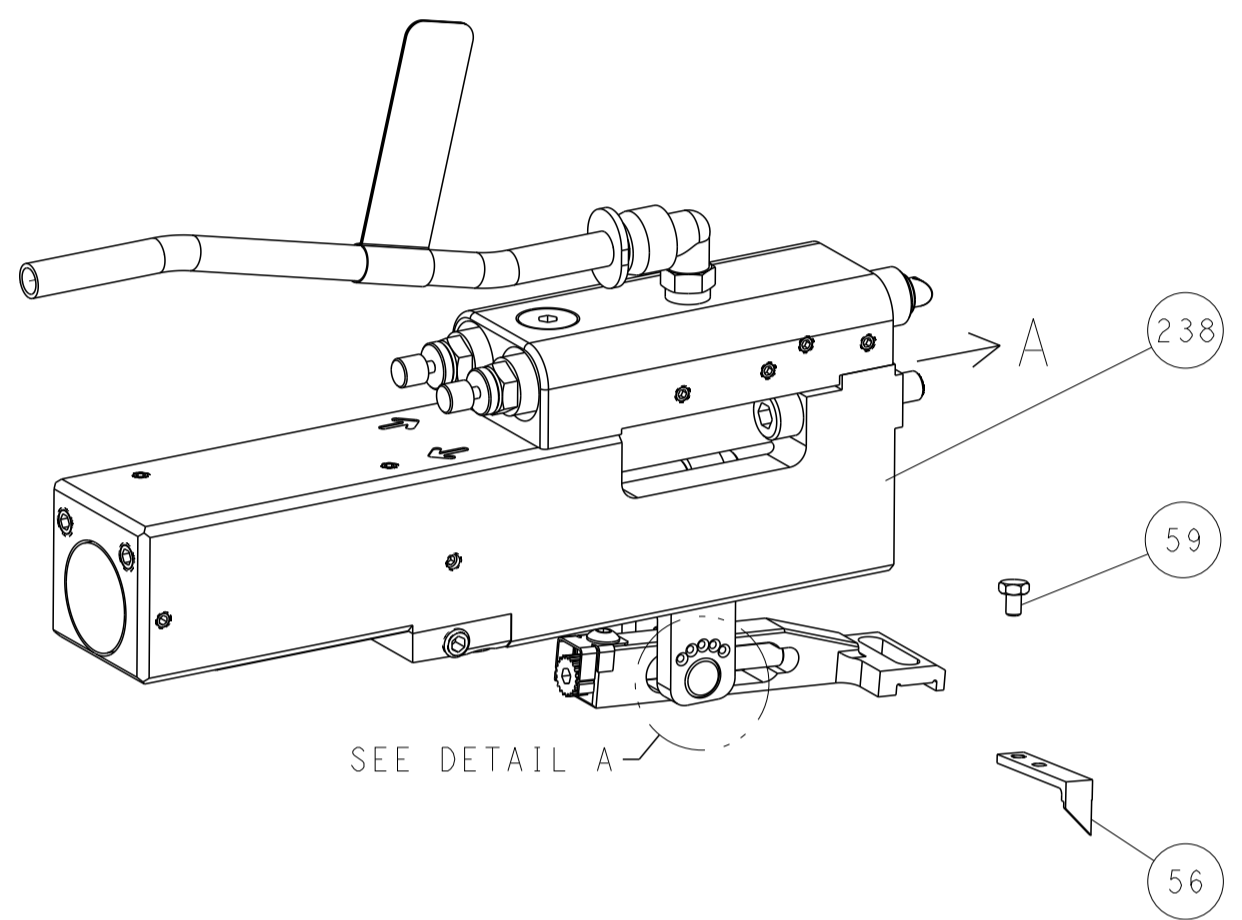
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CHK	T. ELBIN	23NOV2011
APVD	T. ELBIN	23NOV2011
PRODUCT SPEC		
APPLICATION SPEC		
SIZE	CAGE CODE	DRAWING NO
A1	00779	2151307
Customer Accessible Production Drawing		
SCALE	1:2	SHEET 1 OF 4
REV	L	

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

# FEED TYPE MECHANICAL



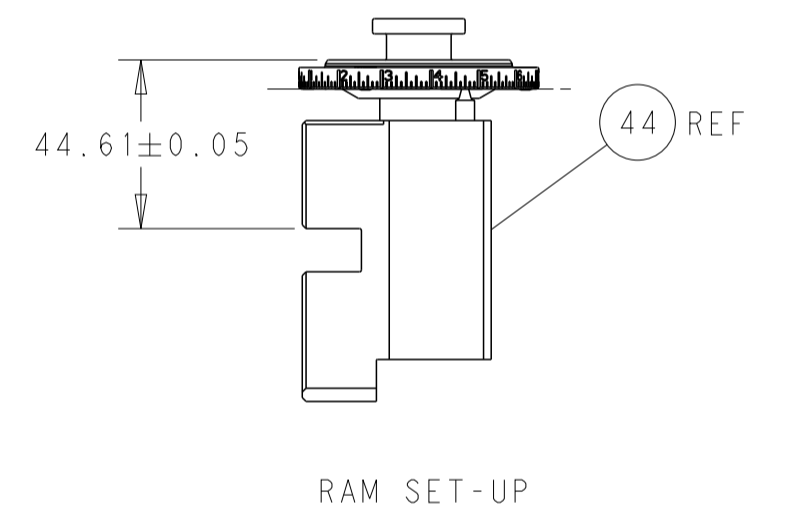
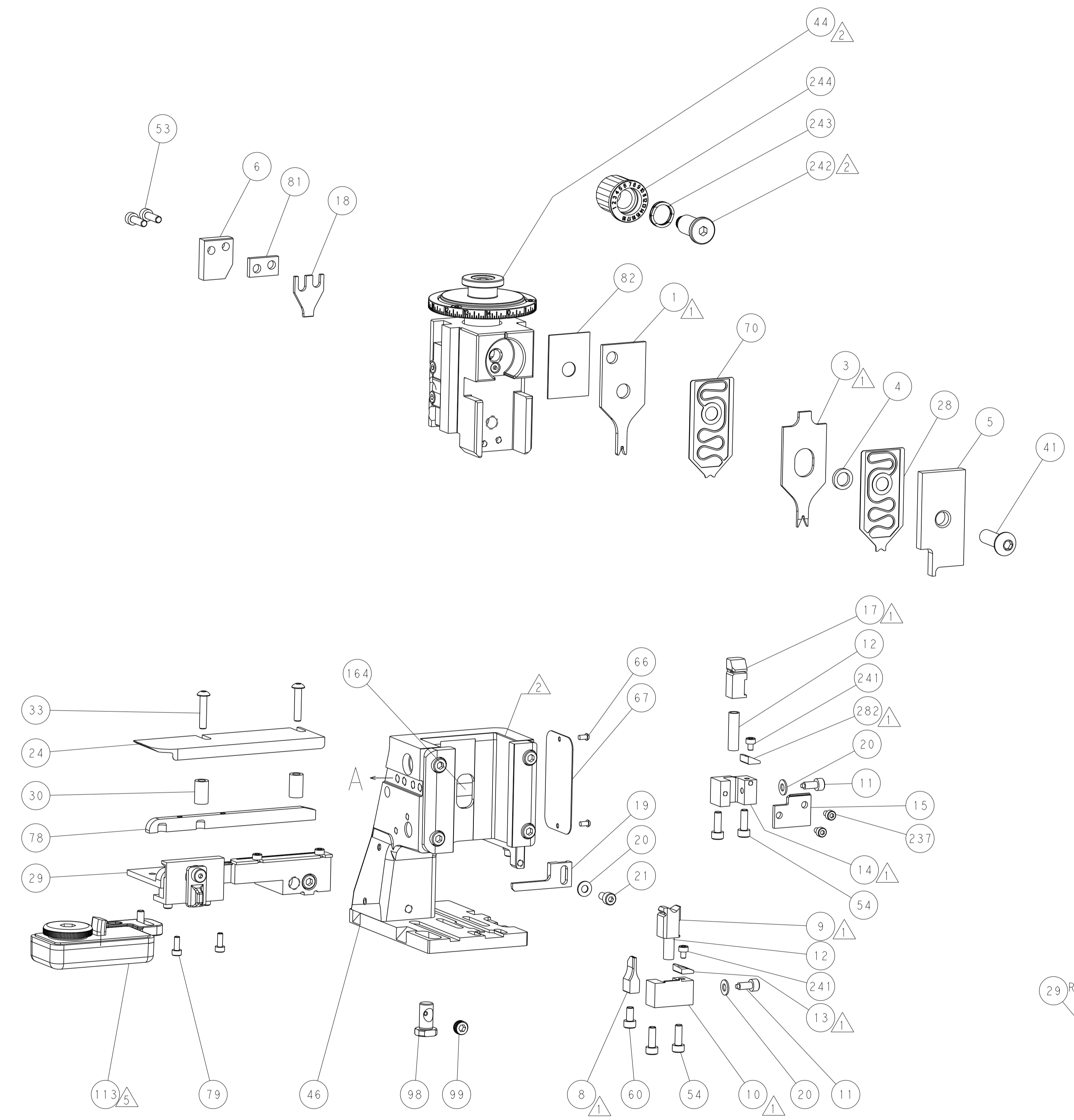
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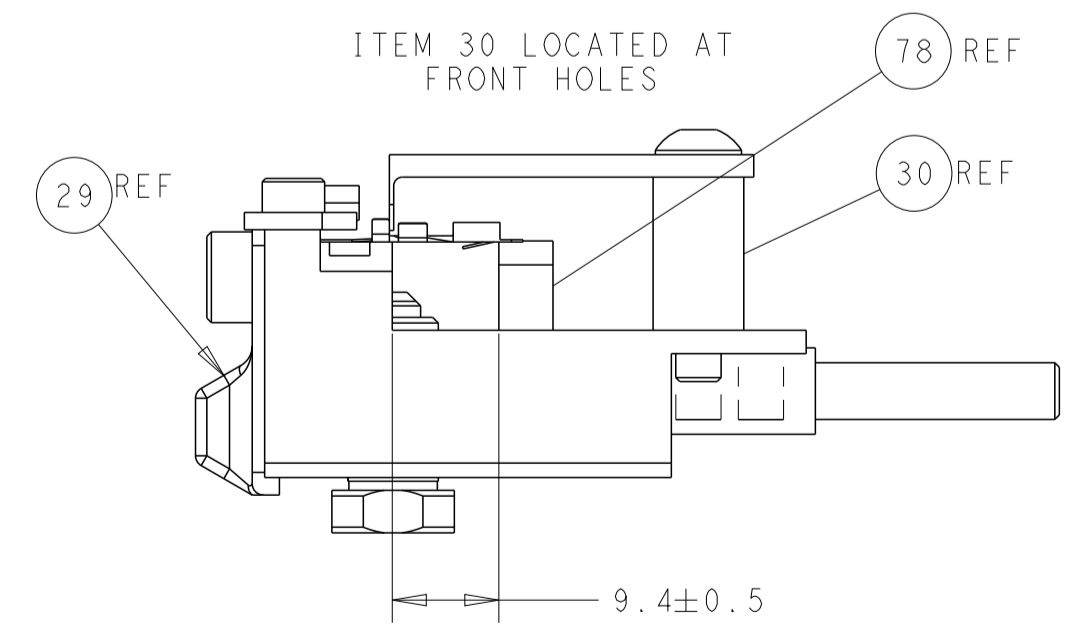
### FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



DETAIL A

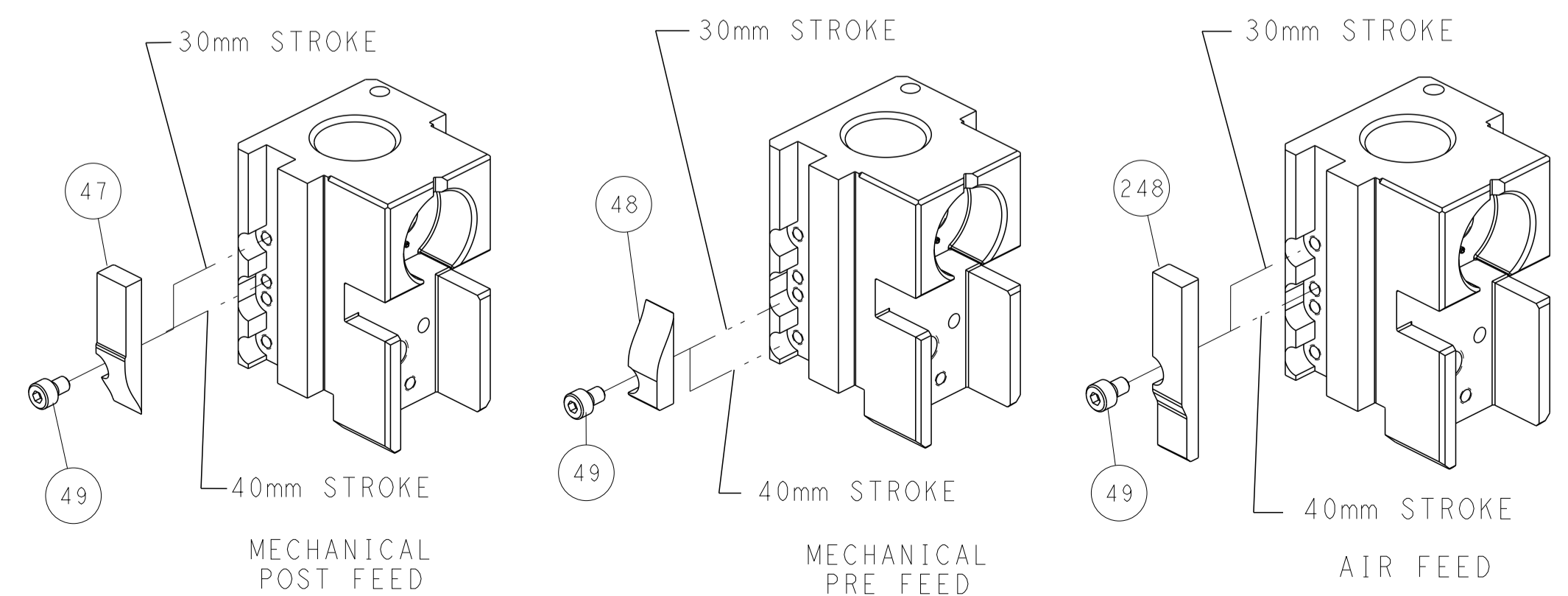


RAM SET-UP



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 UNPUBLISHED. RELEASED FOR PUBLICATION BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.</small>		DWN: C. MOYER 23NOV2011 CHK: T. ELBIN 23NOV2011 APVD: T. ELBIN 23NOV2011	NAME: Ocean Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2151307	TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH	WEIGHT: - SCALE: 1:2 SHEET: 2 of 4 REV: L	RESTRICTED TO: - Customer Accessible Production Drawing	SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION	

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2151307-1	L	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2151307-2	L	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151307-7	L	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR  
 INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.06 mm [.042]	F
INSUL	1.57 mm [.062]	O

APPLICATOR INSTRUCTIONS  
 408-35042

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION  
 TERMINAL NAME: CONTACT, MOD IV, RECEPTACLE, CRIMP SNAP-IN

WIRE STRIP LENGTH 2.77-4.37 mm [1.09-.172 IN]	INSULATION DIAMETER RANGE Ø 1.55 mm [.061 IN] MAX
TERMINAL APPLICATION SPECIFICATION 114-25003	

TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
87666-1	87756-2	6-87756-2	102548-5
87666-2	87756-4	6-87756-7	103171-1
87666-3	87756-6	87809-1	103171-4
87666-4	1-87756-1	87809-2	5-103171-1
87666-5	1-87756-2	87809-6	5-103171-4
1-87666-9	1-87756-7	102548-1	

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
22 AWG	0.89+/-0.05 [.035+/- .002]	10.0
24 AWG	0.79+/-0.05 [.031+/- .002]	11.2
26 AWG	0.76+/-0.05 [.030+/- .002]	11.4



- 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.

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

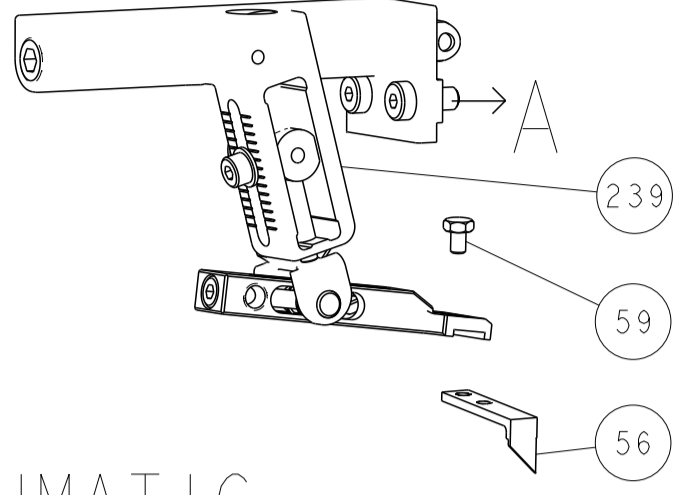
LOC	DIST	REVISIONS					
A	66	P	LTN	DESCRIPTION	DATE	OWN	APVD
-	-	-	-	SEE SHEET 1	-	-	-

1	1	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	2119083-1	RETAINER, INSULATION DIAL	242
2	2	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
1	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
1	-	2844940-1	AIR FEED MODULE	238
2	2	18023-1	SCR, SKT HD CAP M3 X 5.0	237
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	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113
1	1	2844908-1	SCREW, LOCKING	99
1	1	2844907-1	POST, LOCKING	98
1	1	455888-7	SPACER, CRIMPER	82
1	1	240641-7	SPACER	81
2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	79
1	1	1901085-4	FENCE	78
1	1	1803607-3	DOCUMENTATION PACKAGE	71
1	1	2119791-9	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	2-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 14	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	2-2844962-3	SPACER, CYLINDRICAL, STRIP GUIDE	30
1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29
1	1	2119791-5	DEPRESSOR, WIRE	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	690518-2	HOLD DOWN, TERMINAL	18
1	1	690463-1	FLOATING SHEAR, REAR	17
1	1	1-690691-1	PLATE, REAR SHEAR	15
1	1	2119862-1	SHEAR HOLDER, REAR	14
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	1803095-3	FLOATING SHEAR, FRONT	9
1	1	4-1803250-0	ANVIL, COMBINATION	8
-	-	-	-	7
1	1	690468-1	DEPRESSOR SHEAR, REAR	6
1	1	2119757-6	DEPRESSOR, SHEAR	5
1	1	2-238011-2	BLOCK, CRIMPER SPACER	4
1	1	6-1803453-2	CRIMPER, INSULATION O	3
-	-	-	-	2
1	1	2-1633730-7	CRIMPER, WIRE	1

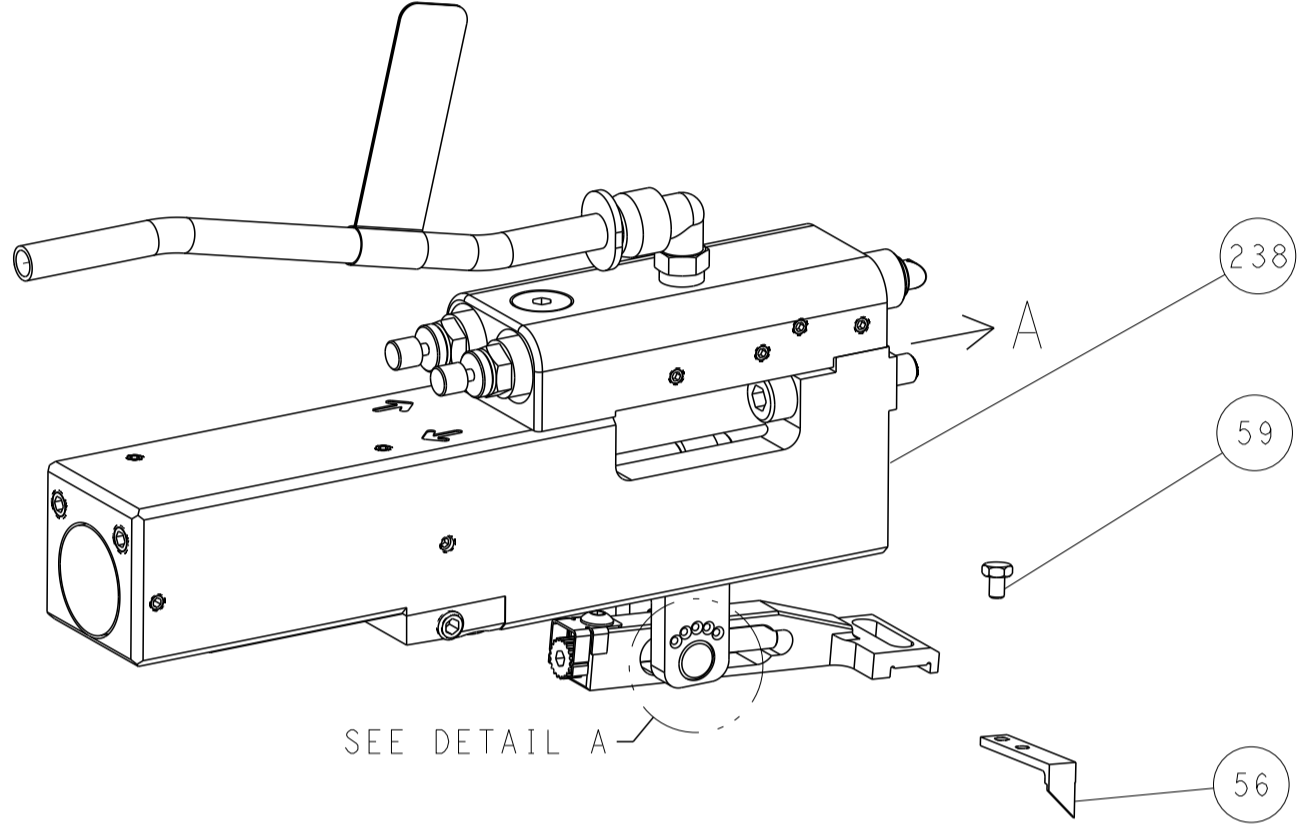
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mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES	FINISH			1:2	3	4	L		

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

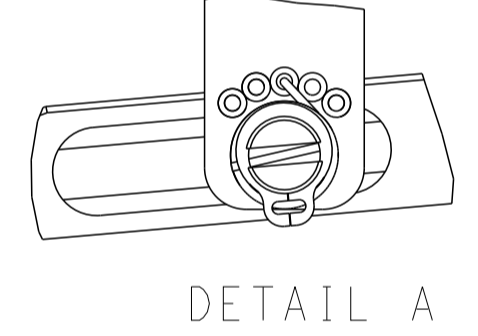
# FEED TYPE MECHANICAL



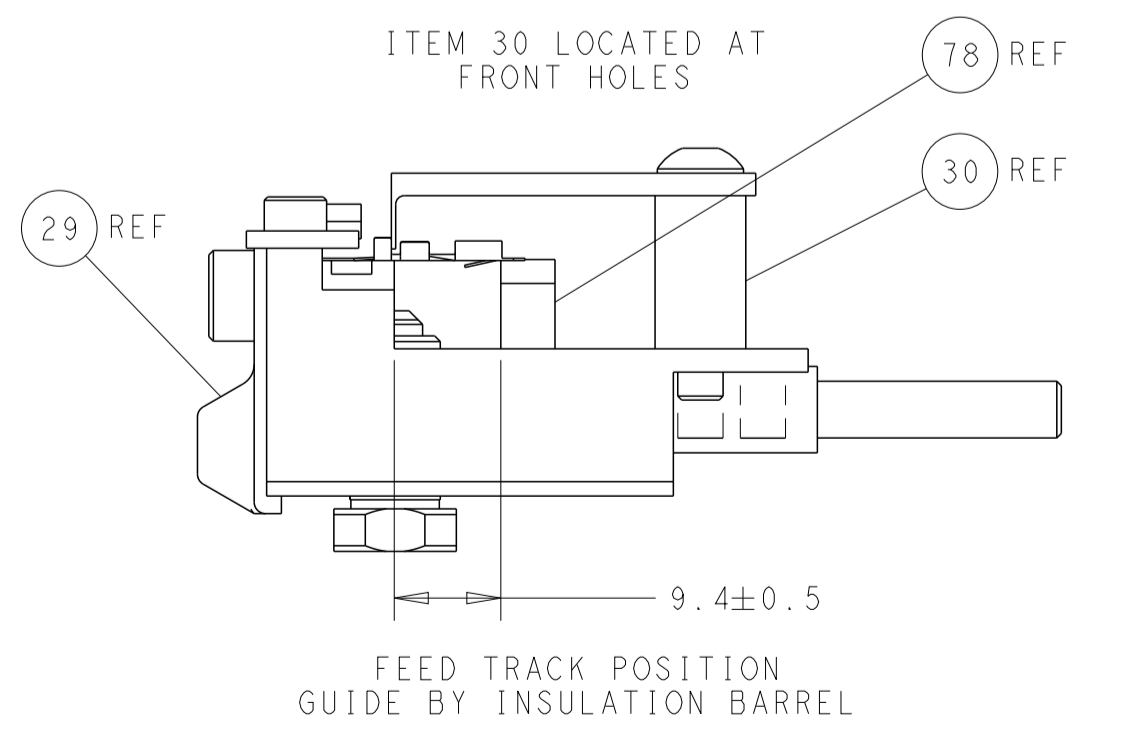
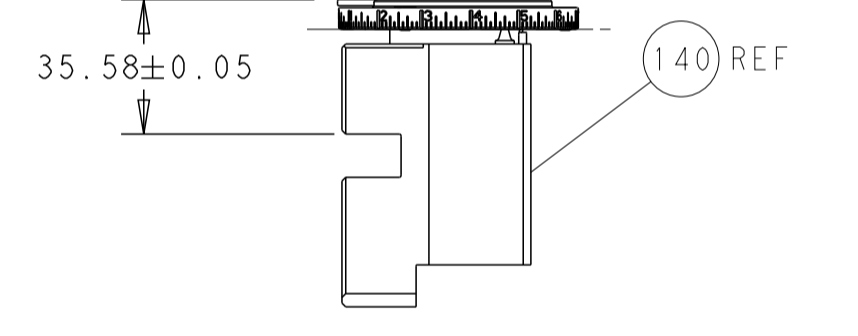
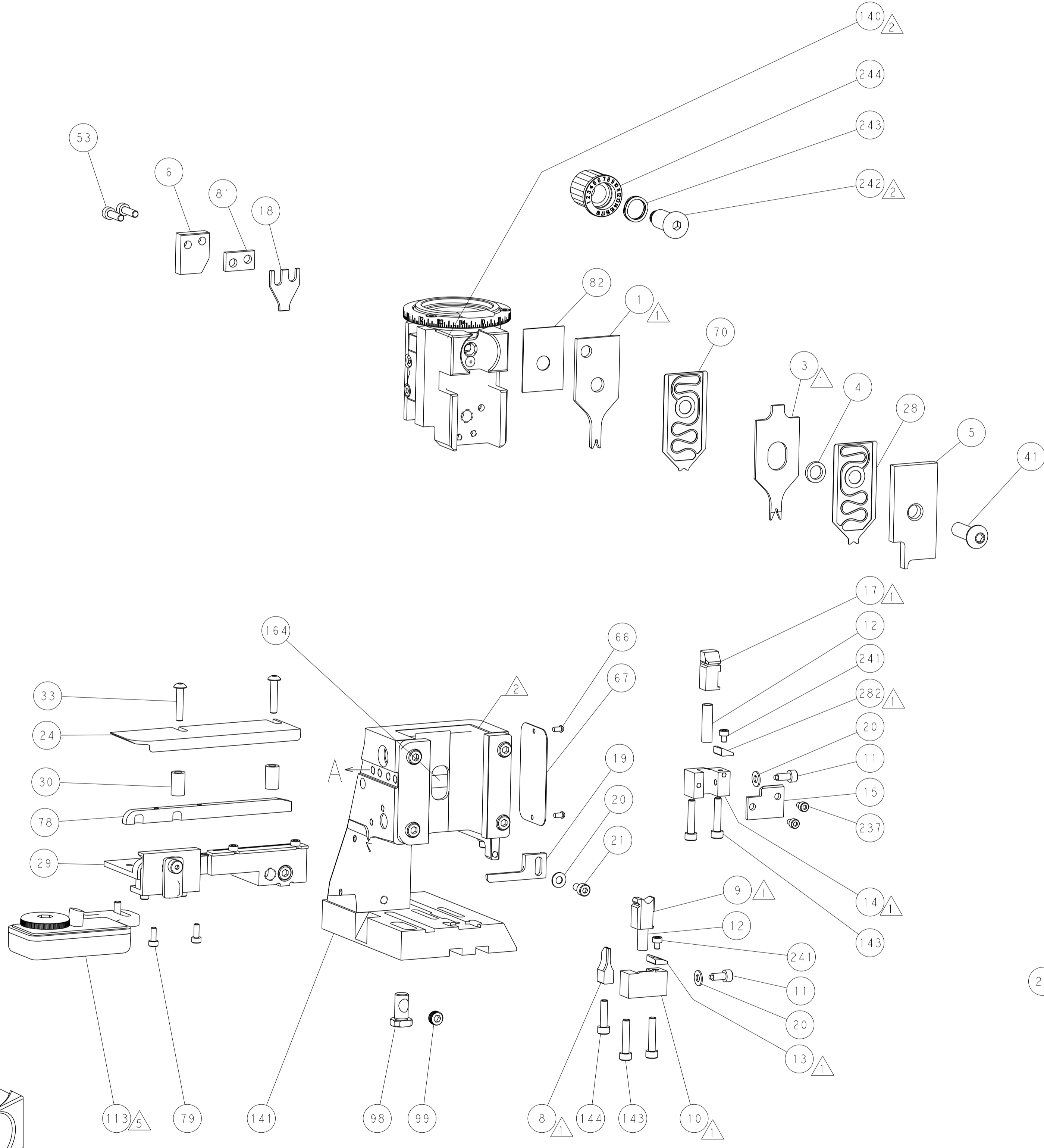
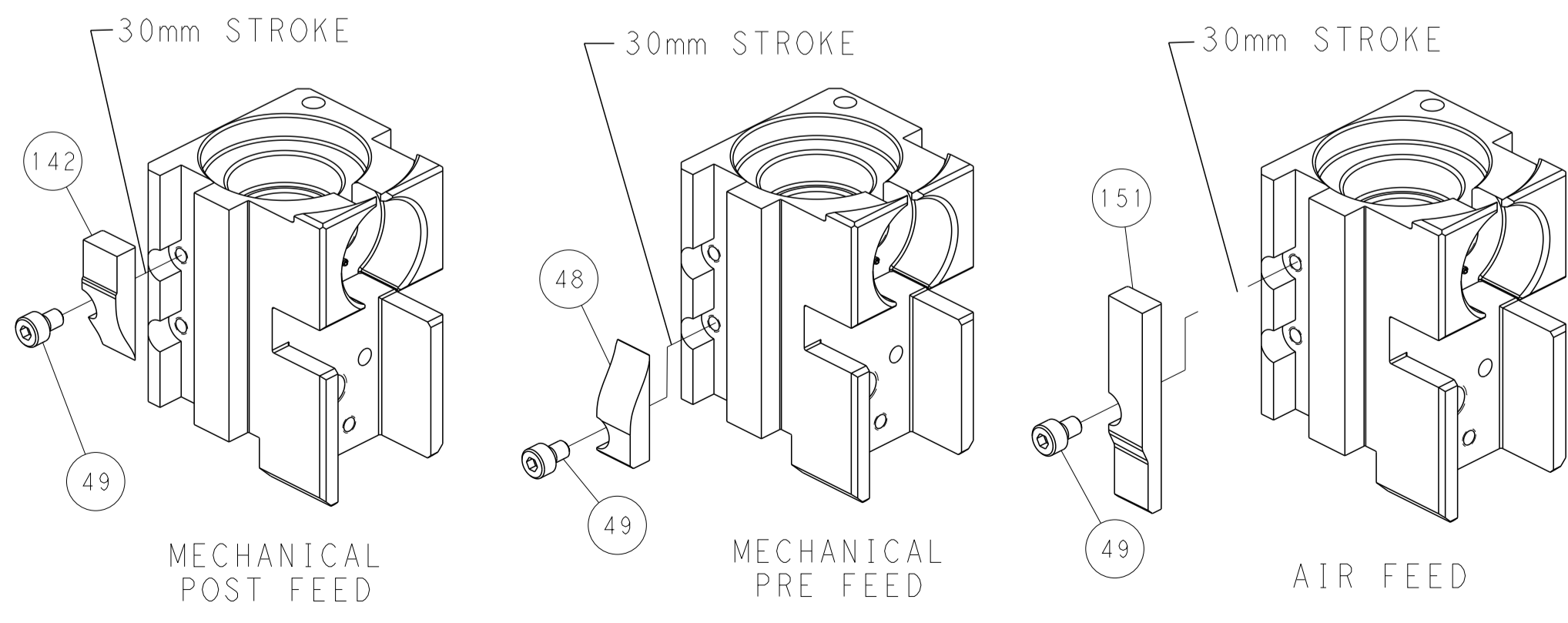
## PNEUMATIC



### 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)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN C. MOYER 23NOV2011		TE Connectivity	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	5 PLC ±	Harrisburg, PA 17105-3608
	ANGLES	FINISH		APVD T. ELBIN 23NOV2011	NAME Ocean Side Feed Applicator		
MATERIAL				PRODUCT SPEC	SIZE	CAGE CODE	DRAWING NO
				APPLICATION SPEC	A1	00779	©=2151307
				RESTRICTED TO	WEIGHT	SCALE	SHEET 4 OF 4 REV L
				Customer Accessible Production Drawing	1:2		