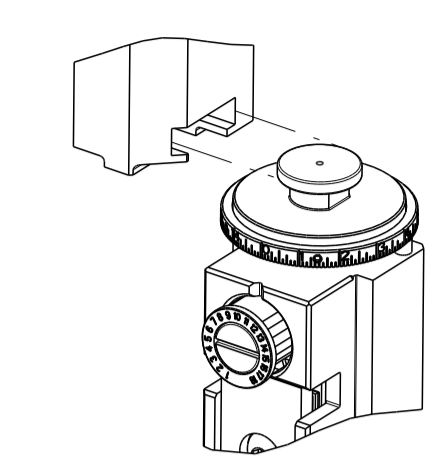


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151314-1	F	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2151314-2	F	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151314-1	F	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2151314-2	F	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2151314-*	-	SEE CRIMP TOOLING KITS BELOW	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER

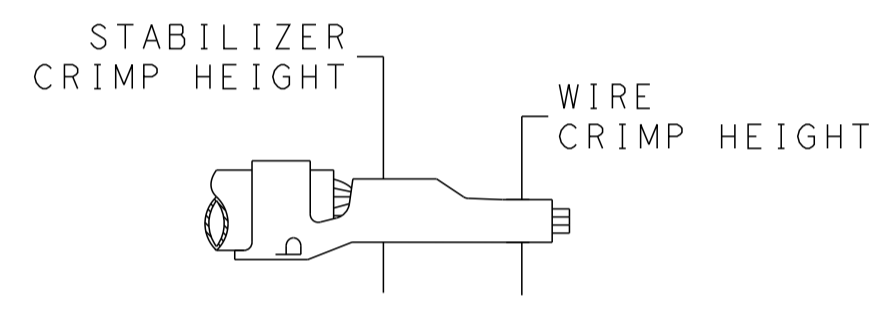


APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.79 mm [.110]	F
STABILIZER	2.79 mm [.110]	Ø
INSULATION	3.94 mm [.155]	F

APPLICATOR INSTRUCTIONS
408-35042

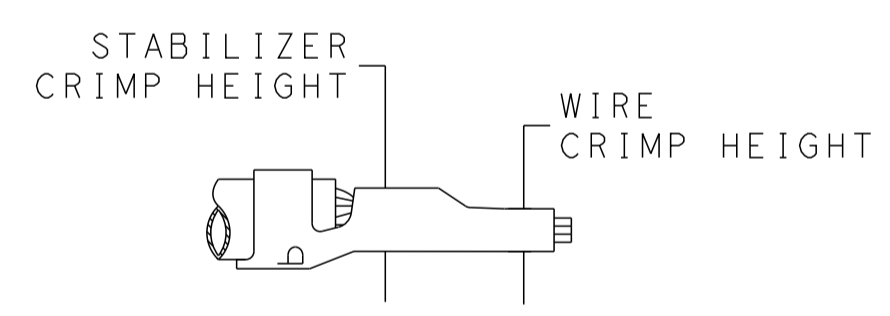
PART NO	REV	WIRE SIZE	WIRE CRIMPER	STABILIZER CRIMPER	INSULATION CRIMPER	ANVIL
7-2151314-7	C	12 AWG	7-456408-6	815664-2	6-2119582-7	1633923-5
7-2151314-8	C	14 AWG	2-456408-5	815664-6	6-2119582-7	1633923-5
7-2151314-9	F	18-16 AWG	2-456408-6	815664-6	6-2119582-7	1633923-5

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: AMP-IN			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
4.83-5.59 mm [.190-.220 IN]		Ø2.29-3.81 mm [.090-.150 IN]	
TERMINAL APPLICATION SPECIFICATION	114-1016		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
3-794013-1			

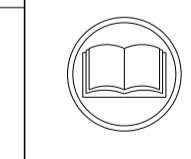


WIRE SIZE	WIRE CRIMP HEIGHT mm [INCH]	WIRE CRIMPER PART NUMBER	STABILIZER CRIMP HEIGHT mm [INCH]	STABILIZER CRIMPER PART NUMBER	CRIMP HEIGHT REFERENCE SETTING
12 AWG	2.16+/-0.05 [.085+/- .002]	7-456408-6	2.79+/-0.05 [.110+/- .002]	815664-2	9.1

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: AMP-IN			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
4.83-5.59 mm [.190-.220 IN]		Ø2.29-3.81 mm [.090-.150 IN]	
TERMINAL APPLICATION SPECIFICATION	114-1016		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
3-770060-1			



WIRE SIZE	WIRE CRIMP HEIGHT mm [INCH]	WIRE CRIMPER PART NUMBER	STABILIZER CRIMP HEIGHT mm [INCH]	STABILIZER CRIMPER PART NUMBER	CRIMP HEIGHT REFERENCE SETTING
14 AWG	1.40+/-0.05 [.055+/- .002]	2-456408-5	2.75+/-0.10 [.108+/- .004]	815664-6	7.6
18-16 AWG	1.09+/-0.05 [.043+/- .002]	7-456408-6	2.75+/-0.10 [.108+/- .004]	815664-6	7.6



- 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 ITEMS 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 ITEMS 1 & 178 TO BE USED WITH 12 AWG ONLY. ITEMS TO BE SHIPPED WITH APPLICATOR.
- 6 ITEMS 253 & 254 TO BE USED WITH 14 AWG ONLY. ITEMS TO BE SHIPPED WITH APPLICATOR.

***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)

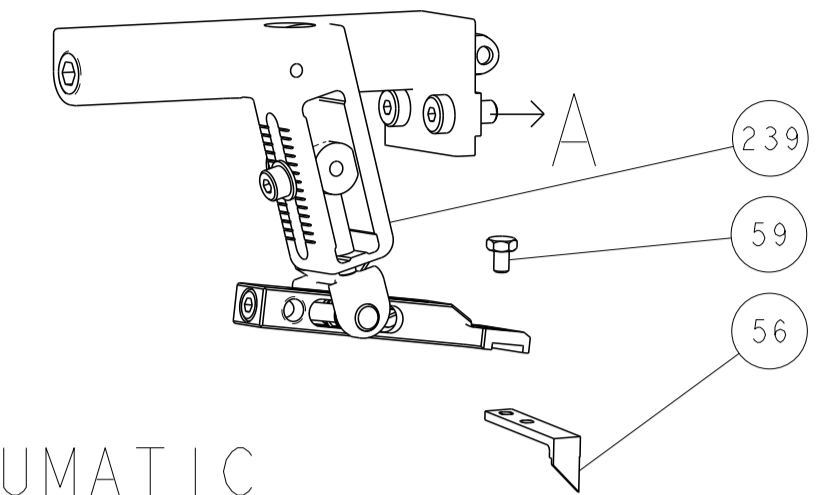
LOC	DIST	REVISIONS			
A	66	REV	DATE	BY	CHKD
		D	19APR2018	FZ	KZ
		D1	21MAR2019	TB	GB
		E	21JUL2021	TB	RK
		F	03OCT2022	ROY	JAH

ITEM NO	QTY	DESCRIPTION	ITEM NO
256	1	CRIMPER, WIRE PREMIUM	256
254	1	CRIMPER, WIRE PREMIUM	254
253	1	CRIMPER, WIRE-O	253
248	1	FEED CAM, AIR FEED	248
244	1	CAM, SNAIL, INSULATION ADJUSTMENT	244
243	1	WASHER, WAVE SPRING, CREST-TO-CREST	243
242	1	RETAINER, INSULATION DIAL	242
241	1	SCR, SKT HD CAP M3 X 4.0	241
239	1	MECHANICAL FEED ASSEMBLY	239
238	1	AIR FEED MODULE	238
178	1	CRIMPER, WIRE PREMIUM	178
164	1	COUNTER, MAGNETIC	164
119	1	WASHER, FLAT, REG M4	119
99	1	SCREW, LOCKING	99
98	1	POST, LOCKING	98
82	1	SPACER, CRIMPER	82
71	1	DOCUMENTATION PACKAGE	71
67	1	TAG, IDENTIFICATION	67
66	2	SCREW, DRIVE, RH, RoHS, 2 x .188	66
60	1	SCR, SKT HD CAP, RoHS, M4 X 8.0	60
59	1	SCR, HEX HD CAP, M4 X 6.0	59
56	1	PAWL, FEED	56
54	4	SCR, SKT HD CAP, RoHS, M4 X 12.0	54
49	1	SCR, SKT HD CAP M4 X 6.0	49
48	1	FEED CAM, PRE FEED	48
47	1	FEED CAM, POST FEED	47
46	1	APPLICATOR BASIC ASSEMBLY, SF	46
44	1	RAM ASSEMBLY, SF ATLANTIC	44
41	1	SCR, BHSC, RoHS (M8 X 25)	41
34	1	STOP, WIRE	34
33	2	SCR, BHSC, RoHS (M4 X 20)	33
30	2	SPACER, CYLINDRICAL, STRIP GUIDE	30
29	1	ASSEMBLY, STRIP GUIDE	29
28	1	SPACER, CRIMPER	28
24	1	STRIP GUIDE	24
21	1	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
20	1	WASHER, FLAT, REG M4	20
19	1	STRIPPER, SIDE FEED	19
13	1	INSERT, SHEAR	13
12	1	SPRING, COMPRESSION	12
11	1	STOP, SHEAR	11
10	1	SHEAR HOLDER, FRONT	10
9	1	FLOATING SHEAR, FRONT	9
8	1	ANVIL, COMBINATION	8
7	-	-	7
6	-	-	6
5	1	DEPRESSOR, SHEAR	5
4	1	BLOCK, CRIMPER SPACER	4
3	1	CRIMPER, INSULATION F PREMIUM	3
2	1	SPACER, CRIMPER	2
1	1	CRIMPER, WIRE-O	1

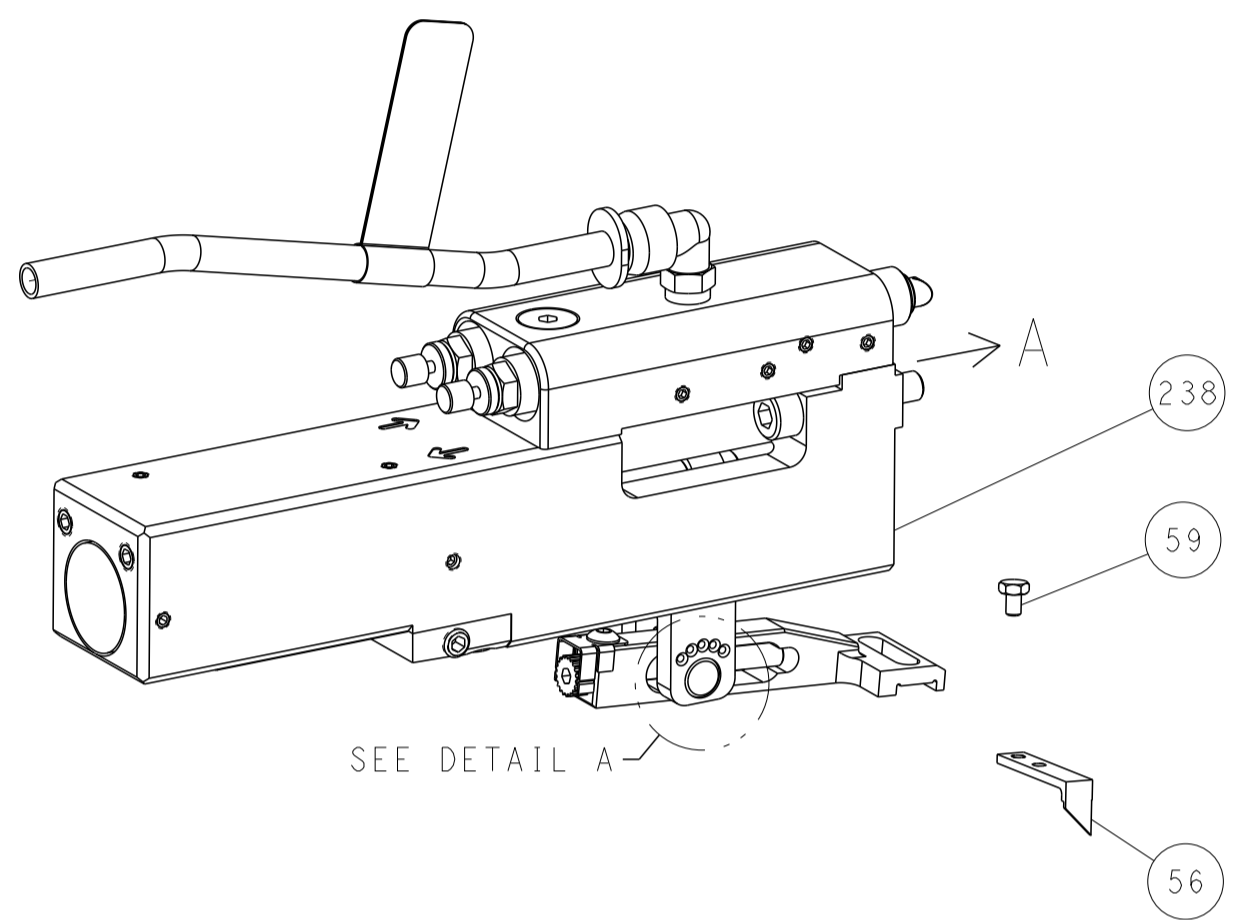
ITEM NO	QTY	DESCRIPTION	ITEM NO
-79	-78	-77	-72
-71	-2	-1	PART NO
DESCRIPTION		ITEM NO	

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

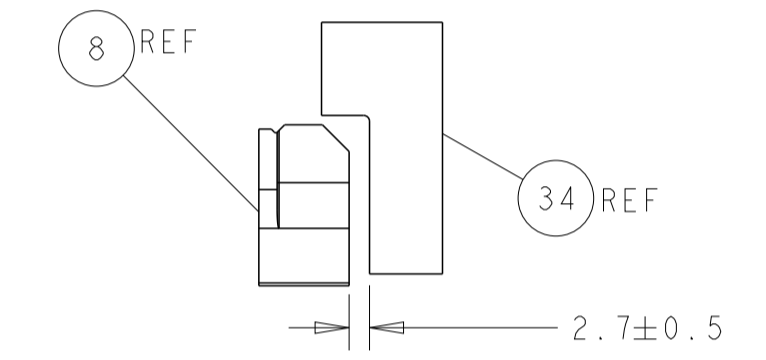
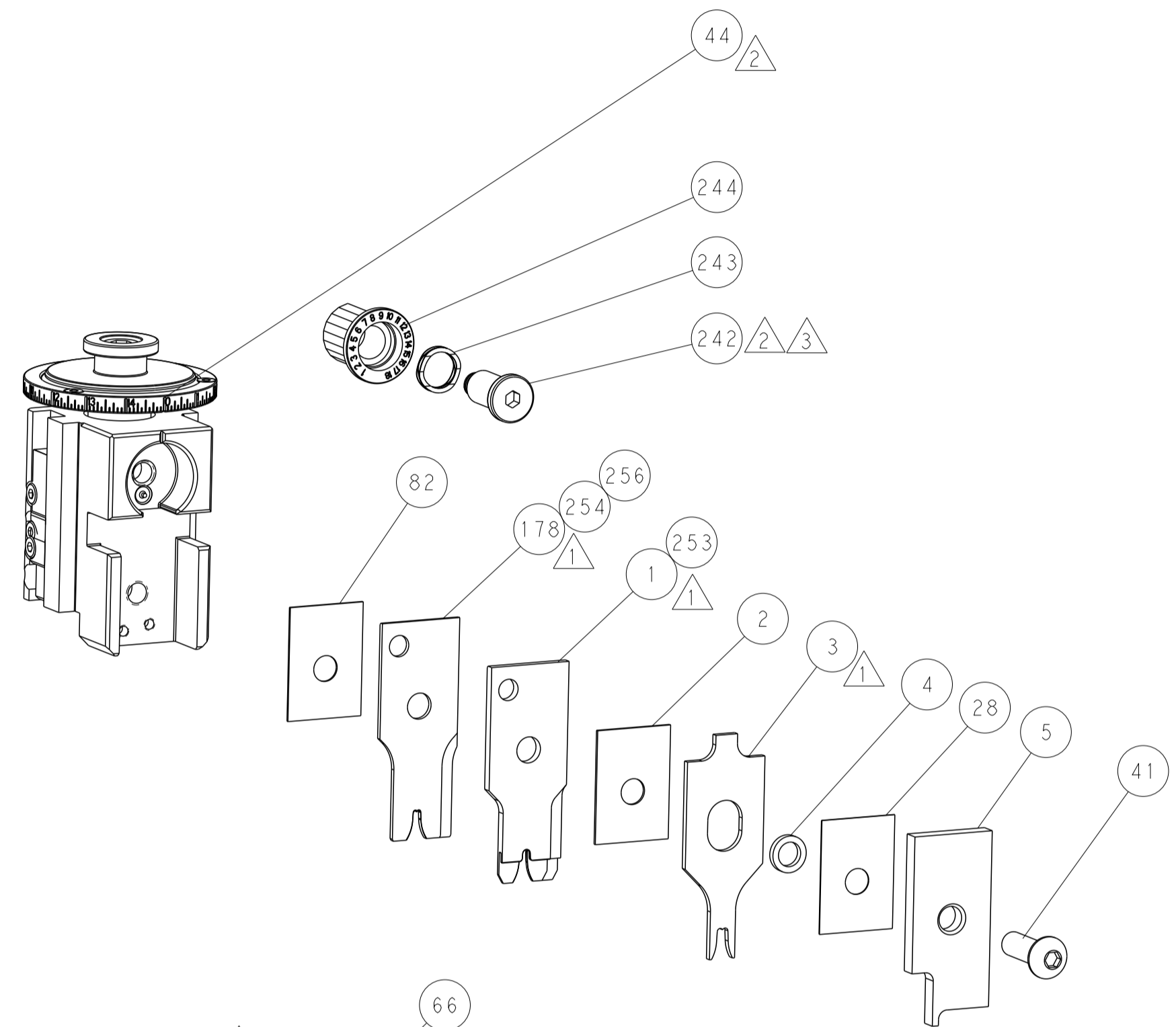
FEED TYPE MECHANICAL



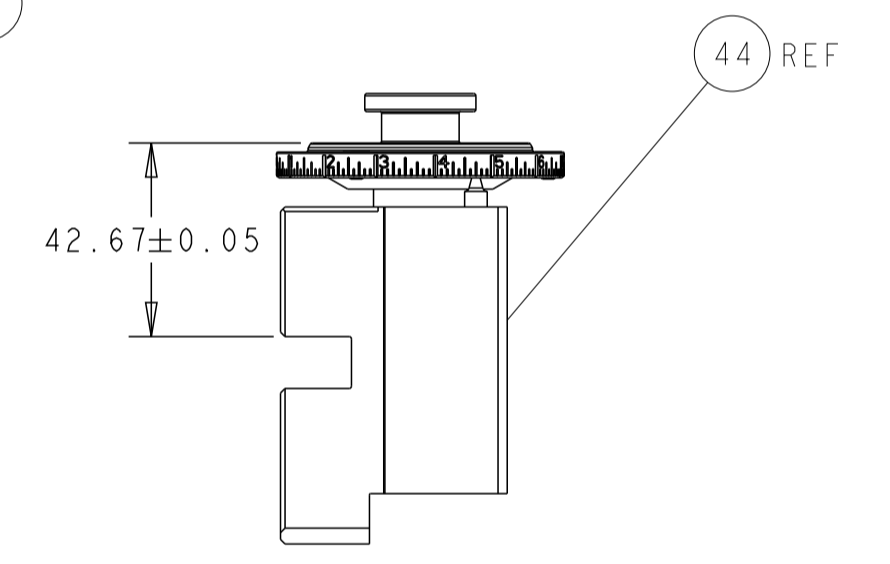
PNEUMATIC



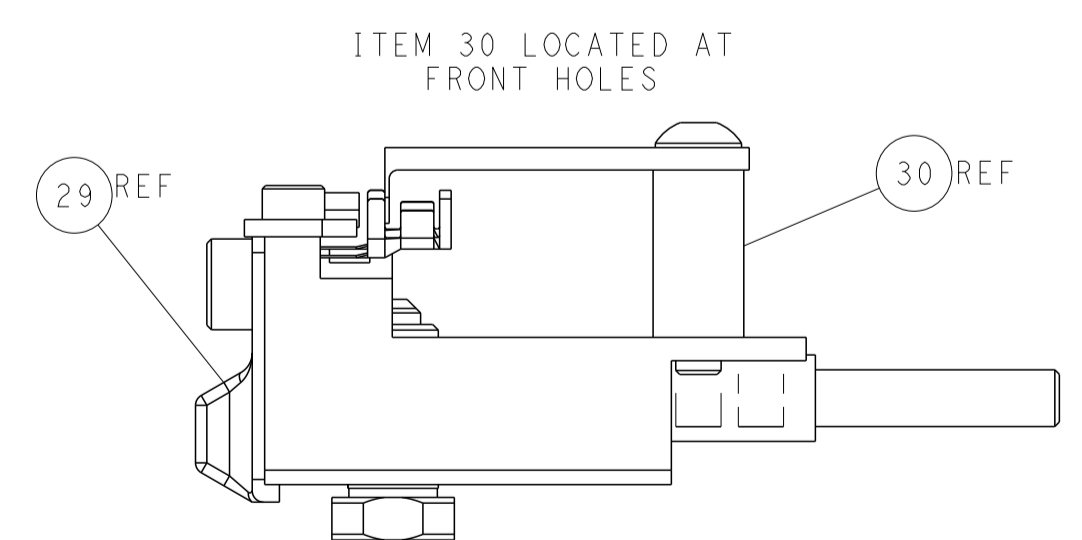
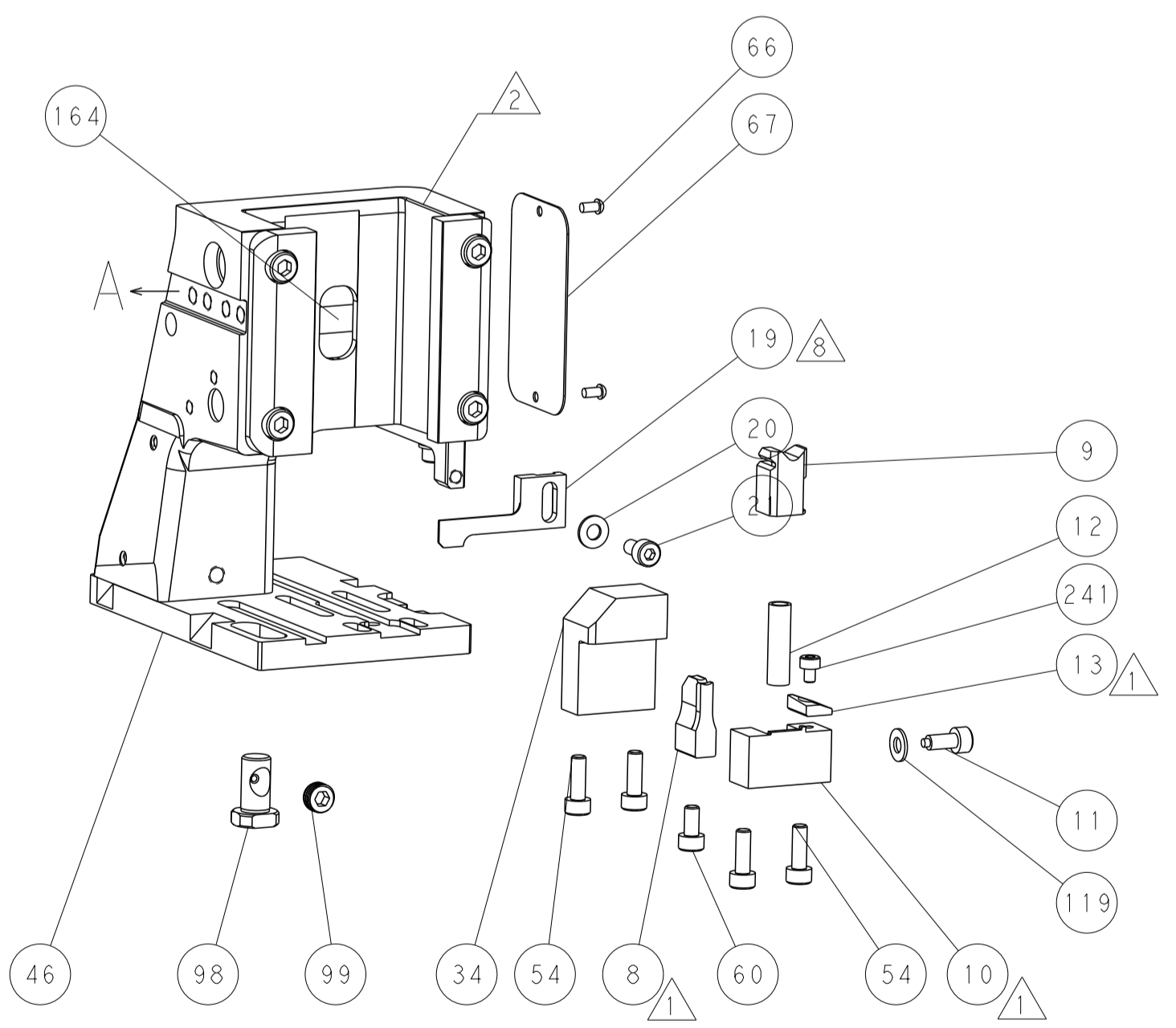
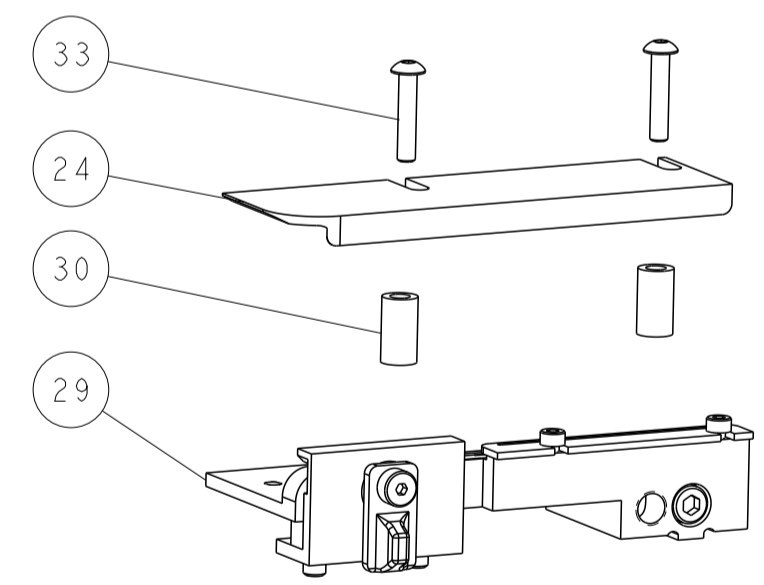
FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



WIRE STOP LOCATION

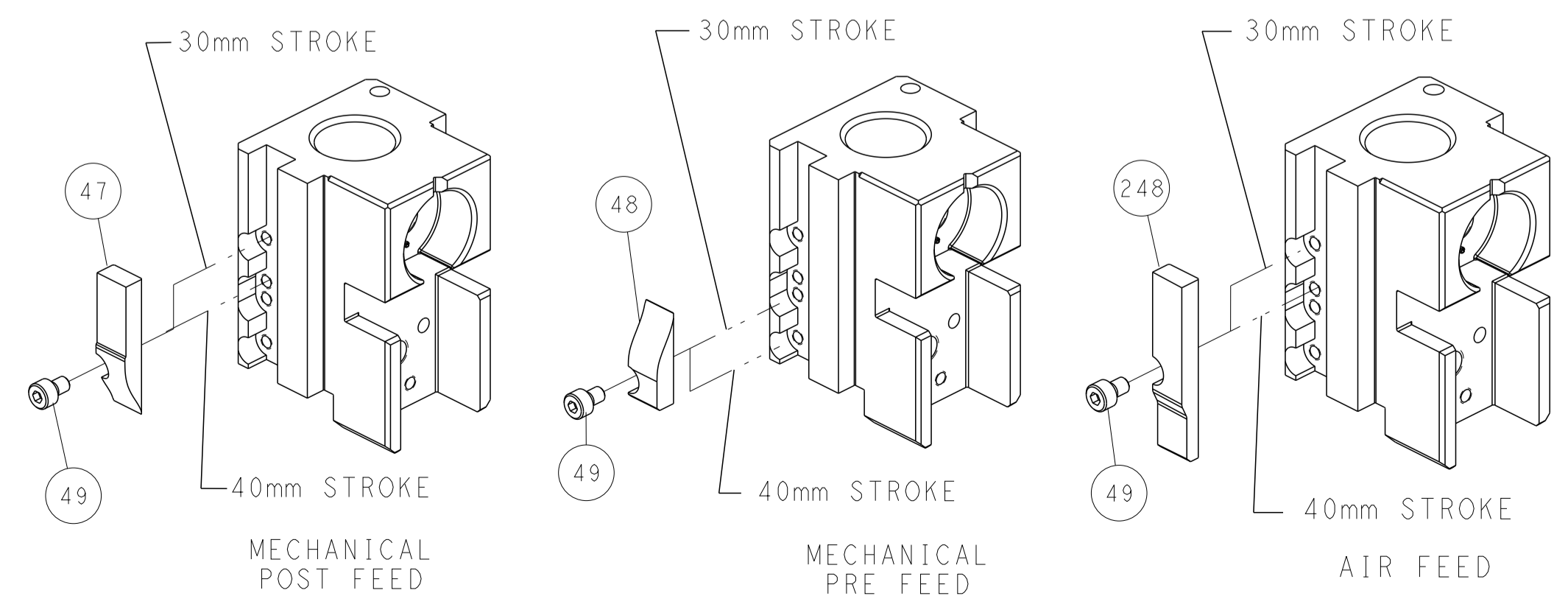


RAM SET-UP



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)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN L. GROSS 31JAN2013		TE Connectivity	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	Harrisburg, PA 17105-3608	
MATERIAL:		FINISH:		APVD M. CLIFFORD 31JAN2013		NAME Ocean Side Feed Applicator	
				PRODUCT SPEC		SIZE CAGE CODE DRAWING NO RESTRICTED TO	
				APPLICATION SPEC		A1 00779 C=2151314	
				WEIGHT		SCALE 1:2 SHEET 2 OF 4 REV F	
				Customer Accessible Production Drawing		SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION	

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2151314-1	F	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2151314-2	F	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151314-*	-	SEE CRIMP TOOLING KITS BELOW	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER

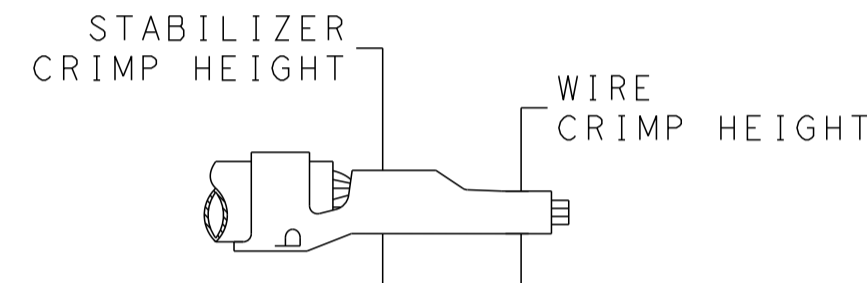


APPLICATOR DATA		
CRIMP WIRE	SIZE	TYPE
WIRE	2.79 mm [.110]	F
STABILIZER	2.79 mm [.110]	O
INSULATION	3.94 mm [.155]	F

APPLICATOR INSTRUCTIONS
408-35042

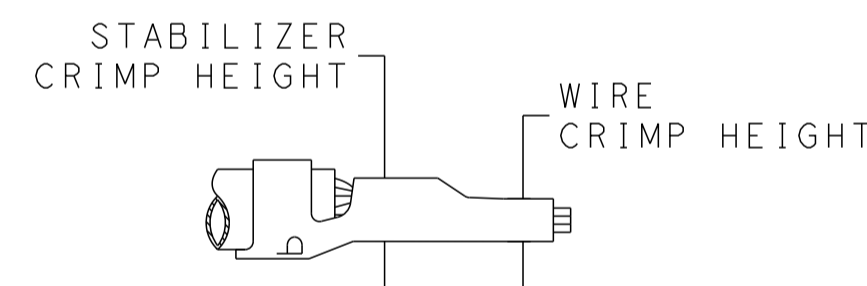
PART NO	REV	WIRE SIZE	WIRE CRIMPER	STABILIZER CRIMPER	INSULATION CRIMPER	ANVIL
7-2151314-7	C	12 AWG	7-456408-6	815664-2	6-2119582-7	1633923-5
7-2151314-8	C	14 AWG	2-456408-5	815664-6	6-2119582-7	1633923-5
7-2151314-9	F	18-16 AWG	2-456408-6	815664-6	6-2119582-7	1633923-5

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: AMP-IN			
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE		
4.83-5.59 mm [.190-.220 IN]	Ø2.29-3.81 mm [.090-.150 IN]		
TERMINAL APPLICATION SPECIFICATION	114-1016		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
3-794013-1			



WIRE SIZE	CRIMP HEIGHT mm [INCH]	WIRE CRIMPER PART NUMBER	STABILIZER CRIMP HEIGHT mm [INCH]	STABILIZER CRIMPER PART NUMBER	CRIMP HEIGHT REFERENCE SETTING
12 AWG	2.16+/-0.05 [.085+/- .002]	7-456408-6	2.79+/-0.05 [.110+/- .002]	815664-2	9.1

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: AMP-IN			
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE		
4.83-5.59 mm [.190-.220 IN]	Ø2.29-3.81 mm [.090-.150 IN]		
TERMINAL APPLICATION SPECIFICATION	114-1016		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
3-770060-1			



WIRE SIZE	CRIMP HEIGHT mm [INCH]	WIRE CRIMPER PART NUMBER	STABILIZER CRIMP HEIGHT mm [INCH]	STABILIZER CRIMPER PART NUMBER	CRIMP HEIGHT REFERENCE SETTING
14 AWG	1.40+/-0.05 [.055+/- .002]	2-456408-5	2.75+/-0.10 [.108+/- .004]	815664-6	7.6
18-16 AWG	1.09+/-0.05 [.043+/- .002]	2-456408-6	2.75+/-0.10 [.108+/- .004]	815664-6	7.6

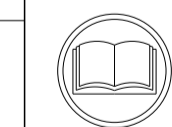
⚠ ITEMS 253 & 256 TO BE USED WITH 18-16 AWG ONLY. APPLICATOR TO BE SET UP WITH THESE ITEMS.

⚠ POSITION ITEM 19 BETWEEN ITEMS 1 AND 3.

9. 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.



- 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 ITEMS 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 ITEMS 1 & 178 TO BE USED WITH 12 AWG ONLY. ITEMS TO BE SHIPPED WITH APPLICATOR.
- 6 ITEMS 253 & 254 TO BE USED WITH 14 AWG ONLY. ITEMS TO BE SHIPPED WITH APPLICATOR.

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	1	2-456408-6	CRIMPER, WIRE PREMIUM	256
1	-	1	-	1	2-456408-5	CRIMPER, WIRE PREMIUM	254
1	1	-	1	1	815664-6	CRIMPER, WIRE-O	253
-	-	-	1	1	2119082-6	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
-	-	1	1	1	7-456408-6	CRIMPER, WIRE PREMIUM	178
-	-	-	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	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
-	-	-	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	469465-4	STOP, WIRE	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	2119533-3	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	1803095-1	FLOATING SHEAR, FRONT	9
1	1	1	1	1	1633923-5	ANVIL, COMBINATION	8
-	-	-	-	-	-	-	7
-	-	-	-	-	-	-	6
-	-	-	1	1	1-2119757-2	DEPRESSOR, SHEAR	5
-	-	-	1	1	238011-8	BLOCK, CRIMPER SPACER	4
1	1	1	1	1	6-2119582-7	CRIMPER, INSULATION F PREMIUM	3
-	-	-	1	1	455888-7	SPACER, CRIMPER	2
5	1	-	1	1	815664-2	CRIMPER, WIRE-O	1

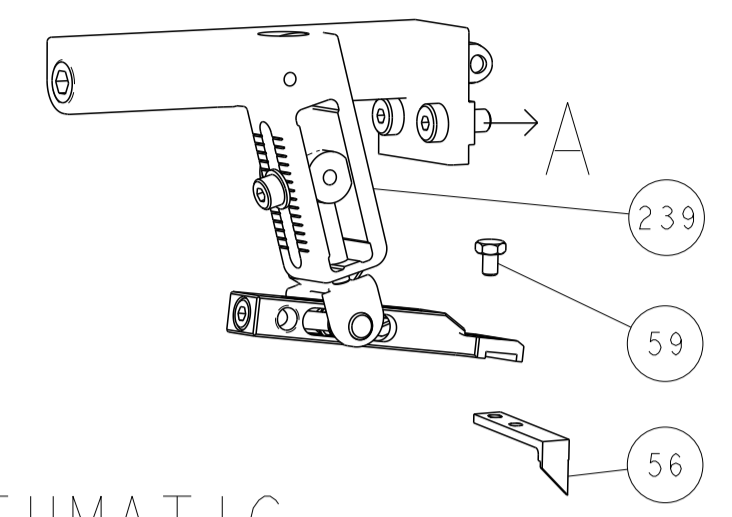
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		MATERIAL:		FINISH:	
mm	0 PLC	±					
	1 PLC	±					
	2 PLC	±					
	3 PLC	±					
	4 PLC	±					
	ANGLES	±					
	FINISH						

ITEM NO	PART NO	DESCRIPTION					
-79	-78	-77	-22	-21	PART NO	DESCRIPTION	ITEM NO

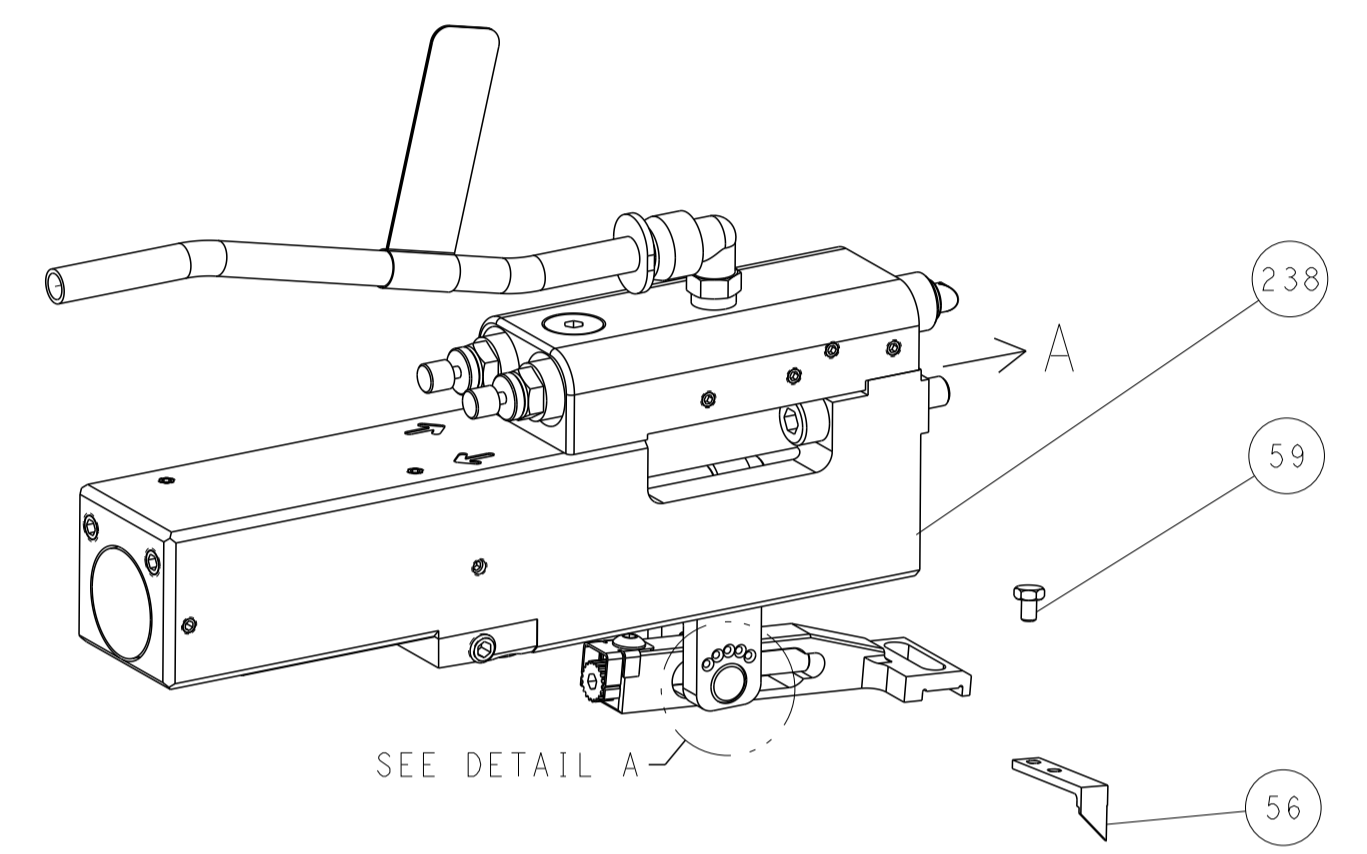
OWN	EL GROSS	31JAN2013	TE Connectivity Harrisburg, PA 17105-3608				
CHK	T. ELBIN	31JAN2013					
APVD	M. CLIFFORD	31JAN2013	NAME Ocean Side Feed Applicator				
PRODUCT SPEC							
APPLICATION SPEC			SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO	
			A1	00779	2151314		
WEIGHT			Customer Accessible Production Drawing	SCALE	1:2	SHEET 3 OF 4	REV F

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

FEED TYPE MECHANICAL



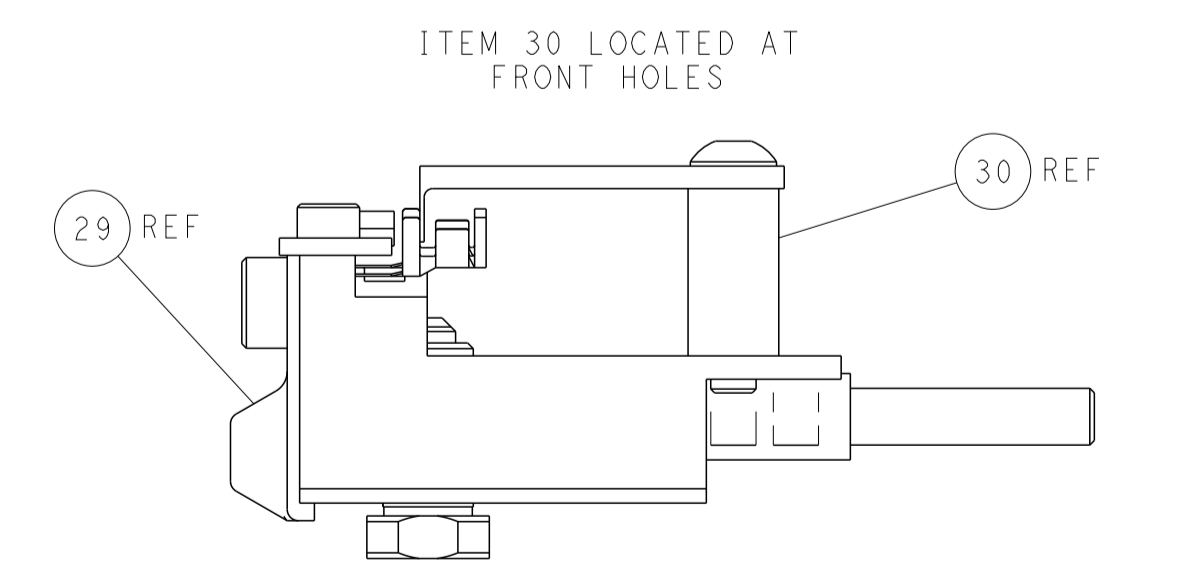
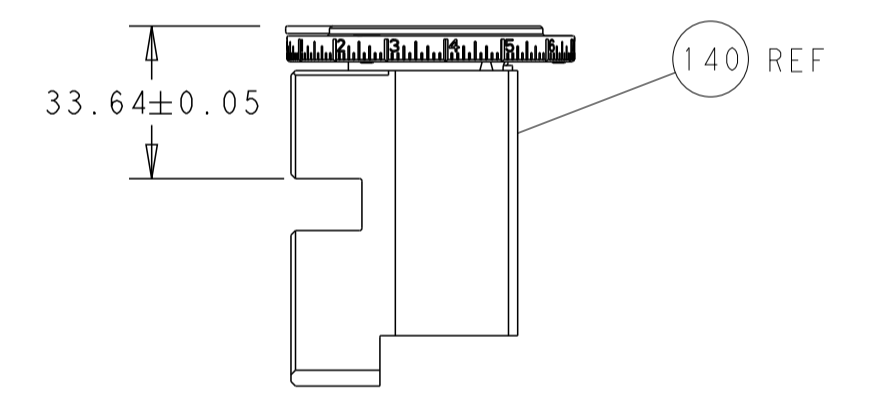
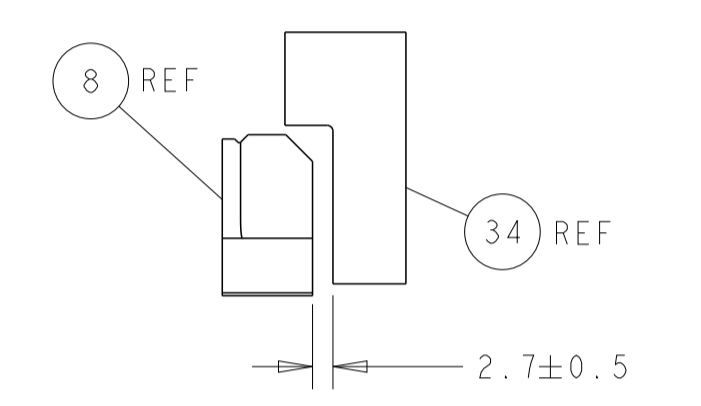
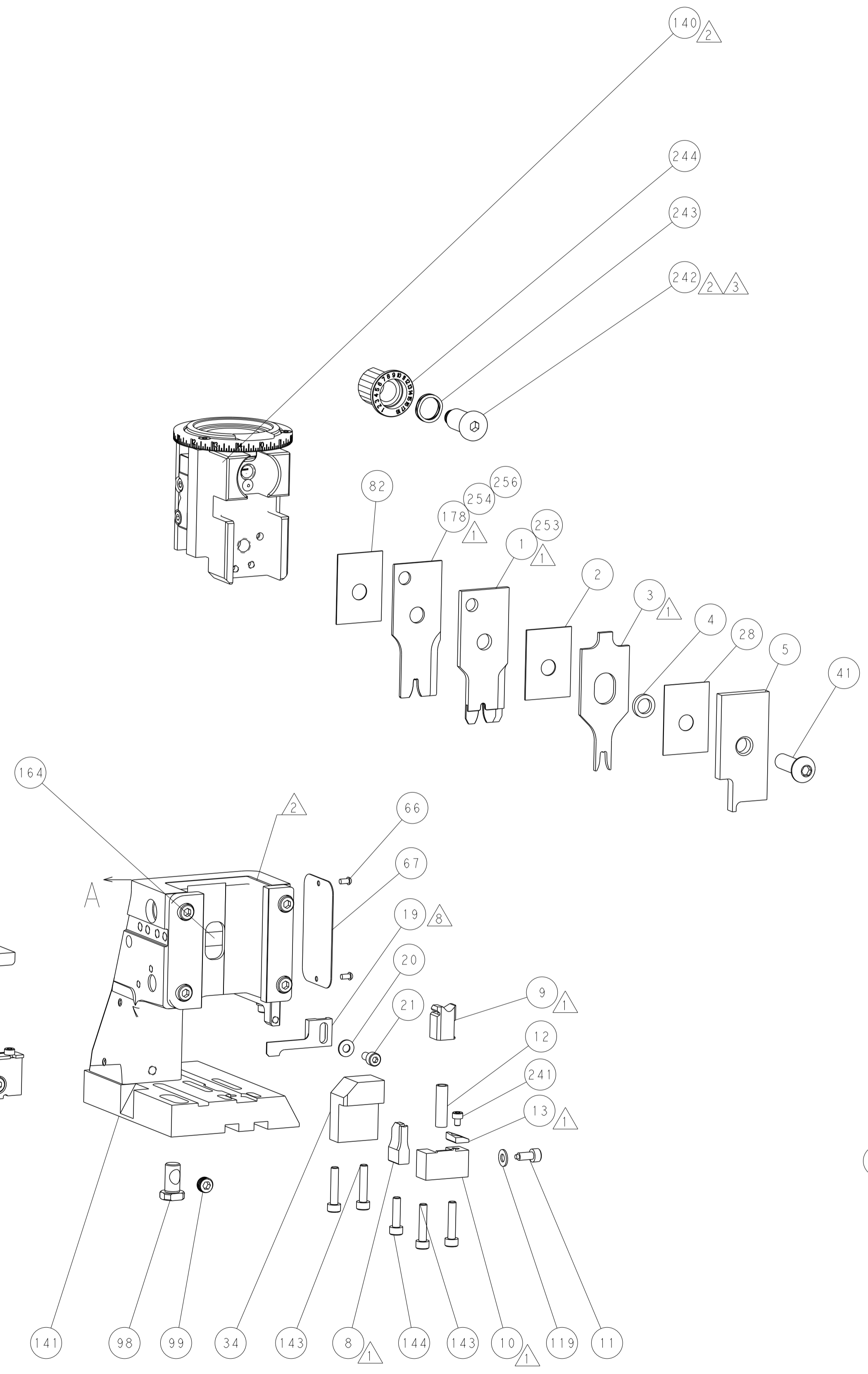
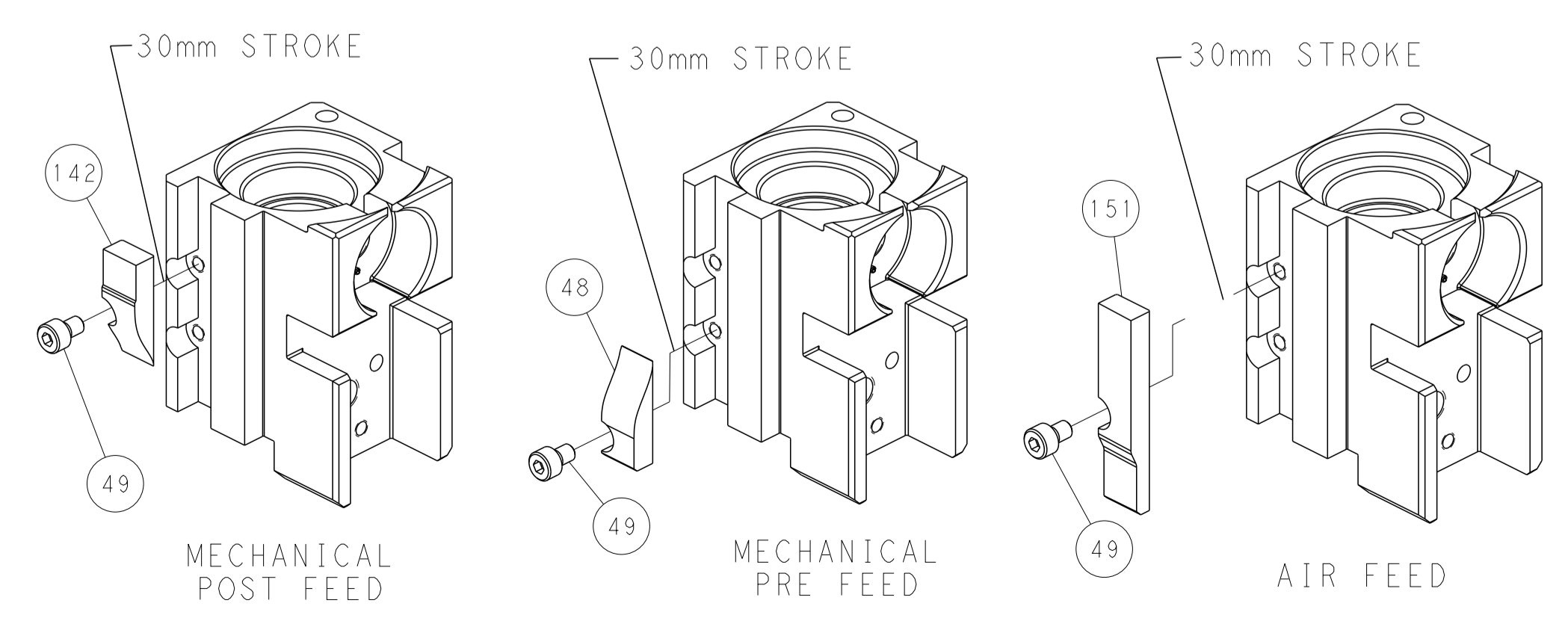
PNEUMATIC



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)

<small>THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION. IT IS THE PROPERTY OF TYCO ELECTRONICS CORPORATION. IT IS TO BE USED ONLY FOR THE PURPOSES AND IN THE QUANTITIES SPECIFIED IN THE ORDER. IT 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 L. GROSS 31 JAN 2013	NAME Ocean Side Feed Applicator
DIMENSIONS: mm		CHK T. ELBIN 31 JAN 2013	SIZE A1
TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH		APVD M. CLIFFORD PRODUCT SPEC APPLICATION SPEC	CAGE CODE 00779
MATERIAL		WEIGHT	SCALE 1:2
		RESTRICTED TO CUSTOMER ACCESSIBLE PRODUCTION DRAWING	SHEET 4 OF 4 REV F