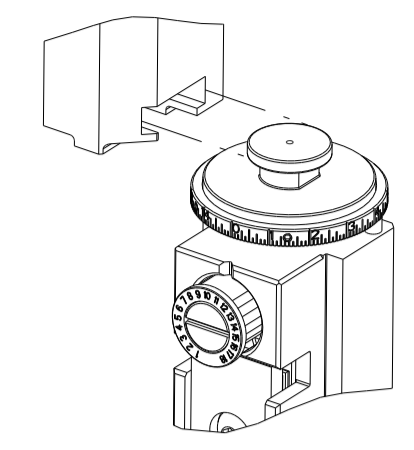


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151205-1	K	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2151205-2	K	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
5-2151205-1	K	SEAL STRIPPER CRIMPER TERMINATING UNIT	MECHANICAL
5-2151205-2	K	SEAL STRIPPER CRIMPER TERMINATING UNIT	PNEUMATIC
7-2151205-1	K	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2151205-2	K	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2151205-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.28 mm [.090]	F
INSUL	3.68 mm [.145]	O

APPLICATOR INSTRUCTIONS 408-35042

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: MINI MIC RECEPT CONTACT			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
3.00-3.50 mm [1.18-.138 IN]		Ø1.70-3.30 mm [0.067-.130 IN]	
TERMINAL APPLICATION SPECIFICATION	(A)114-20045		
	(B)114-20062		

TERMINALS APPLIED				SEAL INSULATION DIAMETER RANGE
TE TERMINAL	TE TERMINAL	TE SEAL	TE SEAL	
(A) 282110-1			(A) 281934-2	Ø1.7-2.4mm
			(A) 281934-3	Ø2.5-3.3mm
			(B) 828904-1	Ø1.9-2.1mm
			(B) 828905-1	Ø2.2-2.4mm

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.50mm2	1.40+/-0.05 [0.055+/-0.002]	4.6
16 AWG	1.33+/-0.05 [0.052+/-0.002]	5.4
1.00mm2	1.22+/-0.05 [0.048+/-0.002]	6.6
0.75mm2	1.14+/-0.05 [0.045+/-0.002]	7.7

- 1. RECOMMENDED SPARE PARTS
- 2. GREASE BEARING SURFACES LIGHTLY
- 3. APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 180. 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. 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.
- 6. TERMINAL LUBRICANT IS RECOMMENDED.
- 7. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT 101-35000.
- 8. CUT TO LENGTH AT ASSEMBLY.

***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-19-006015	15APR2019	FJ	CT
		H1		ECR-22-131140	02MAR2022	TB	GB
		J		ECR-22-156730	27OCT2022	FZ	JAH
		K		ECR-23-165080	01FEB2023	FZ	TE

-	1	1	1	1	1	1	1803945-4	TONKER	300
-	1	1	1	1	1	1	1-22278-9	SPRING, COMPRESSION	299
-	2	2	2	2	2	2	4-18032-3	SCR, SET, FLT PNT, M3 X 6.0	298
-	1	1	1	1	1	1	1803944-1	SPACER, TONKER	297
-	1	1	1	1	1	1	3-1463053-5	HOLDER, TERMINAL	294
-	-	-	-	-	-	-	2-1803583-1	APPLICATOR BASIC ASSEMBLY, SF	292
-	1	-	-	-	-	-	2119641-1	FEED CAM, AIR FEED	248
-	1	1	1	1	1	1	2119082-2	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
3	-	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
-	-	-	-	-	-	-	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	1	-	-	-	-	-	2844940-1	AIR FEED MODULE	238
-	REF	REF	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	1	1	1	1	1	1	1-18028-2	WASHER, FLAT, REG M4	119
6	-	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	455888-5	SPACER, CRIMPER	82
-	1	1	1	1	1	1	1803607-3	DOCUMENTATION PACKAGE	71
-	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
5	-	1	1	1	1	1	985575-3	SCR, FLT SKT HD CAP M3 X 10.0	57
-	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
8	-	2	2	2	2	2	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	53
-	1	2	1	2	1	2	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	-	-	-	-	-	-	2119652-1	FEED CAM, PRE FEED	48
-	-	-	-	-	-	-	2119653-1	FEED CAM, POST FEED	47
-	1	1	-	-	-	-	1803583-9	APPLICATOR BASIC ASSEMBLY, SF	46
-	1	1	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	2-2844962-8	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	1	1	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29
-	1	1	1	1	1	1	455888-3	SPACER, CRIMPER	28
-	1	1	1	1	1	1	1320928-2	STRIP GUIDE	24
-	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	-	-	-	-	2119533-3	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	318707-1	FLOATING SHEAR, FRONT	9
1	2	2	1	1	1	1	1333205-6	ANVIL, COMBINATION	8
-	1	1	1	1	1	1	1-240641-3	SPACER	7
-	-	-	-	-	-	-	-	-	6
-	1	1	1	1	1	1	2119781-2	DEPRESSOR, SHEAR	5
-	1	1	1	1	1	1	2-238011-2	BLOCK, CRIMPER SPACER	4
1	2	2	1	1	1	1	3-2119784-8	CRIMPER, INSULATION O PREMIUM	3
-	1	1	1	1	1	1	1-455888-0	SPACER, CRIMPER	2
1	2	2	1	1	1	1	4-456406-1	CRIMPER, WIRE PREMIUM	1

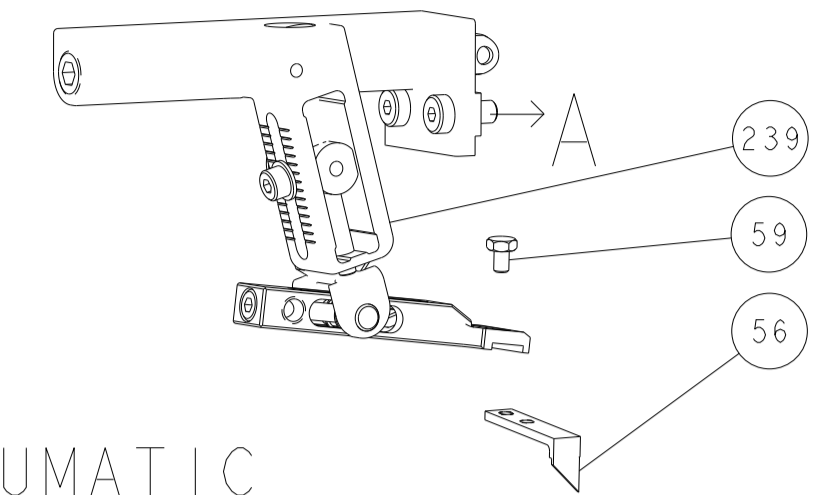
ITEM NO	PART NO	DESCRIPTION
-77	-72	-71
-52	-51	-2
-1		

OWN	Y. YIN	15NOV2011
CHK	G. BAILEY	15NOV2011
APVD	S. XI	15NOV2011

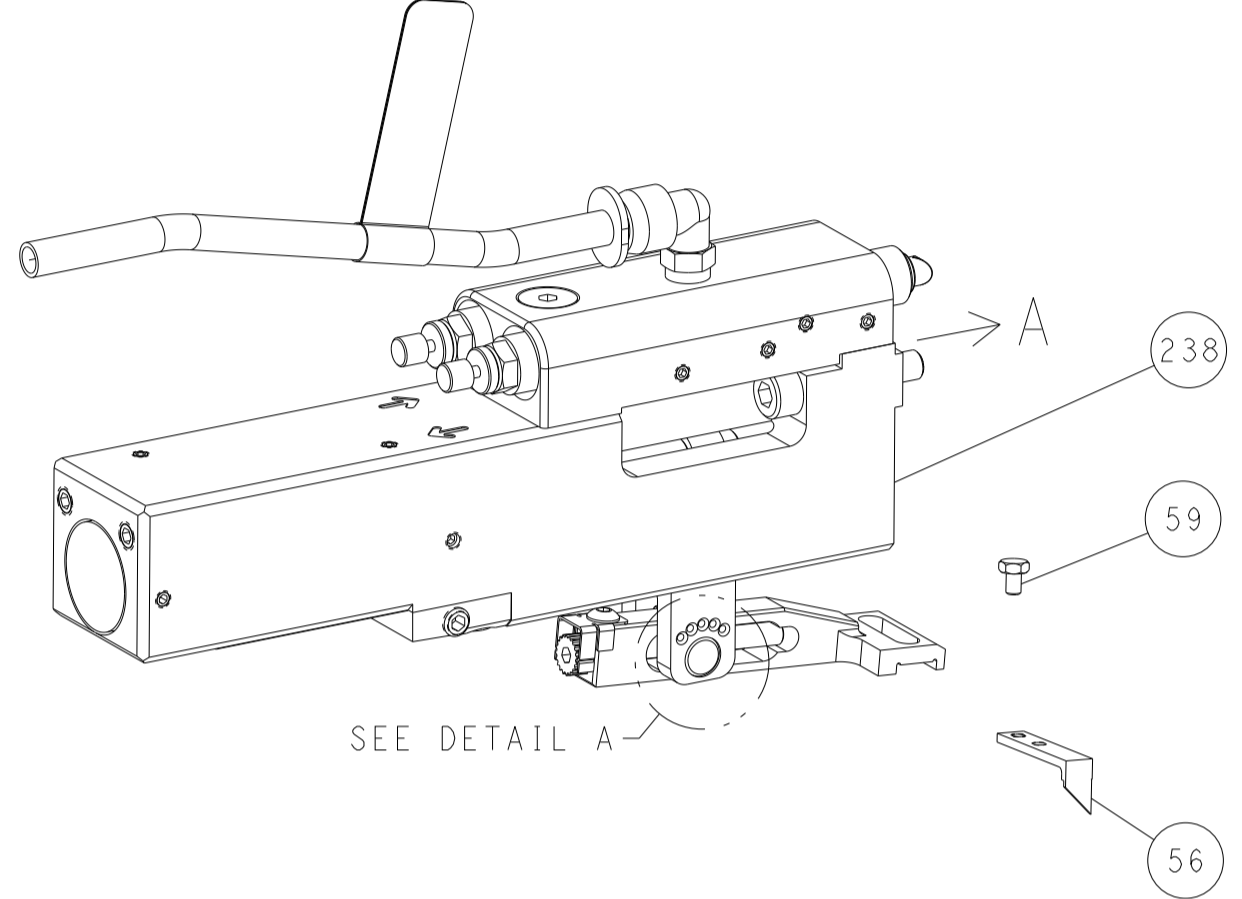
TE Connectivity	Harrisburg, PA 17105-3608		
Ocean Side Feed Applicator			
SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
A1	00779	2151205	-
Customer Accessible Production Drawing		SCALE	SHEET 1 OF 4
		REV	K

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

FEED TYPE MECHANICAL



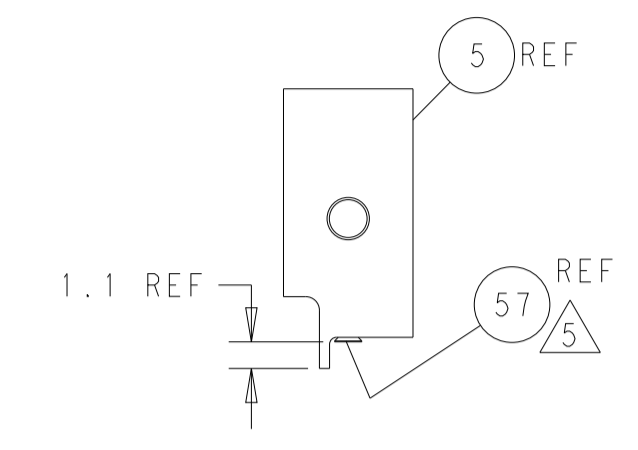
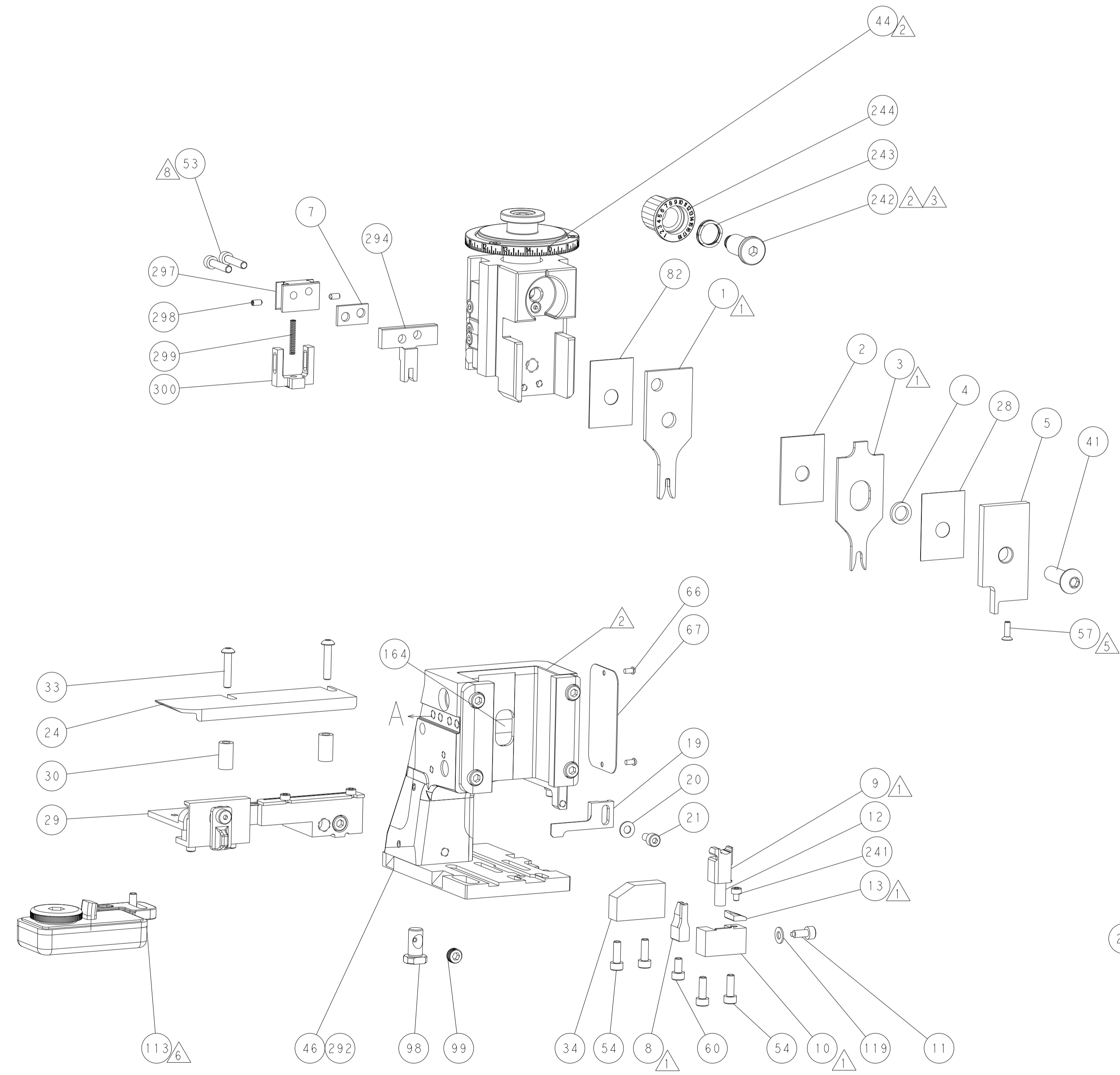
PNEUMATIC



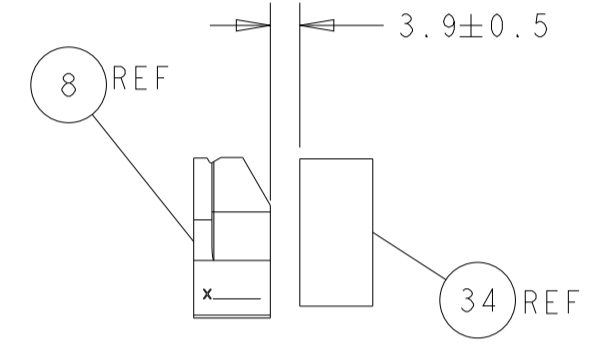
FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



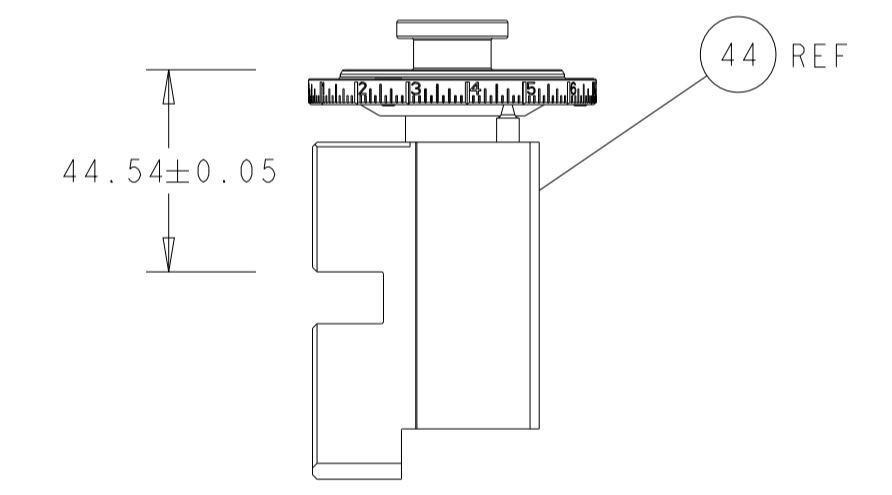
DETAIL A



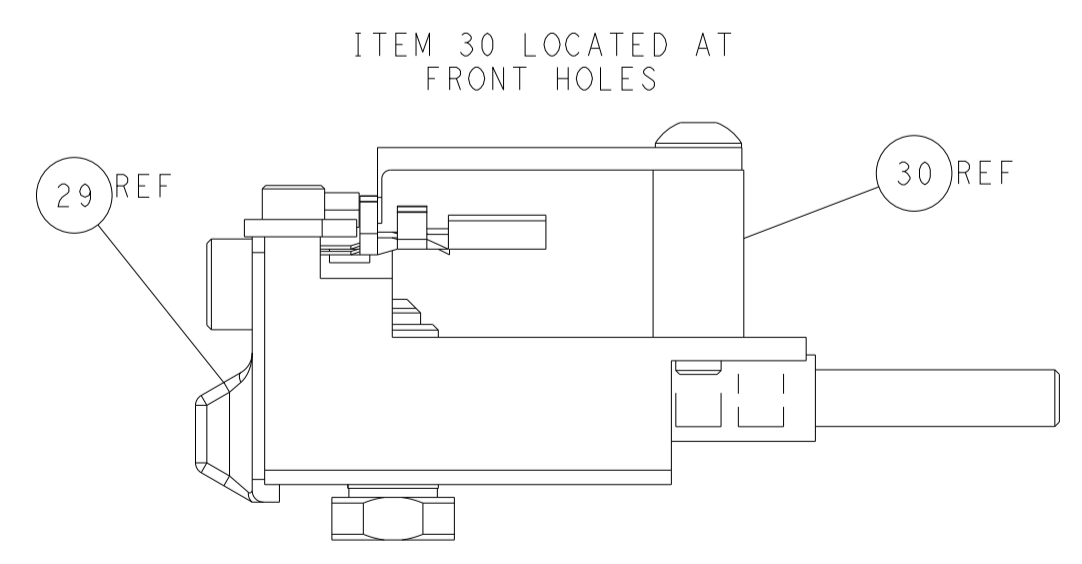
SHEAR DEPRESSOR DETAIL



TERMINAL SUPPORT LOCATION

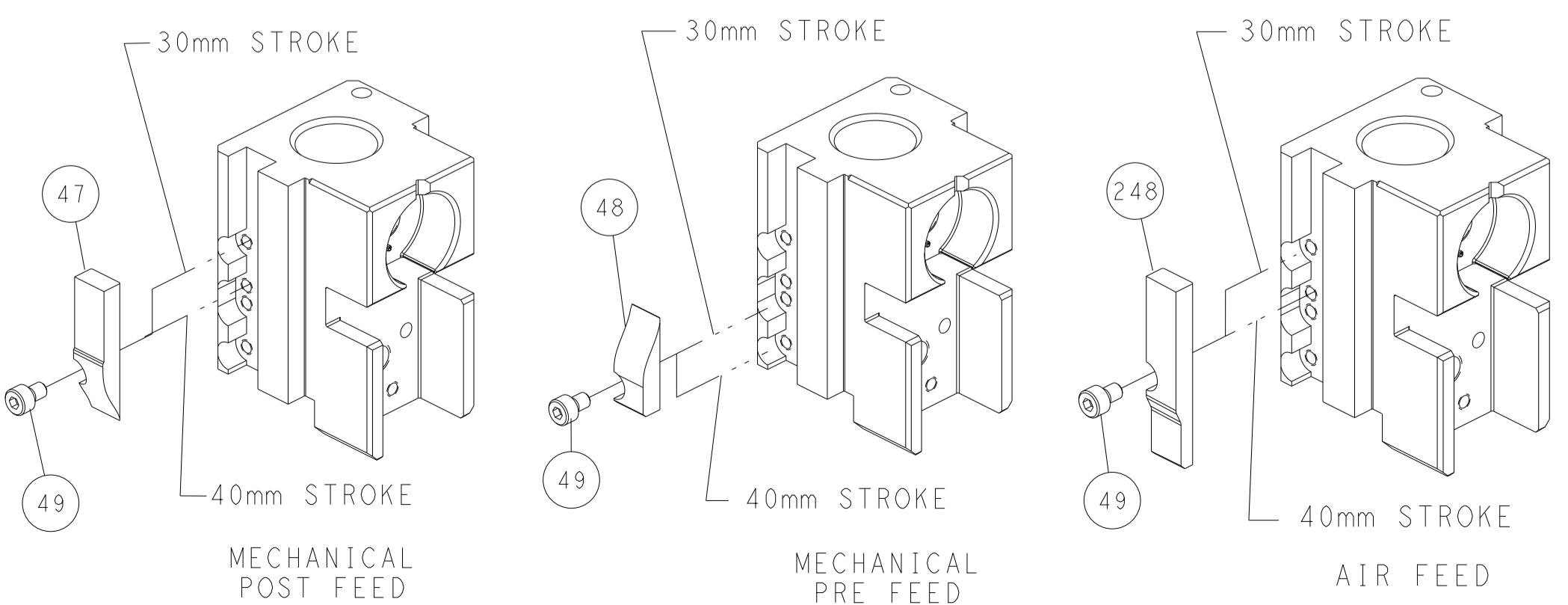


RAM SET-UP



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 UNPUBLISHED. RELEASED FOR PUBLICATION BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.</small>		DWN Y. YIN 15NOV2011 CHK G. BAILEY 15NOV2011 APVD S. XI 15NOV2011	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 PRODUCT SPEC APPLICATION SPEC SIZE CAGE CODE DRAWING NO. RESTRICTED TO A1 00779 ©=2151205	WEIGHT SCALE 1:2 SHEET 2 of 4 REV K

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2151205-1	K	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2151205-2	K	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151205-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
 INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.28 mm [.090]	F
INSUL	3.68 mm [.145]	O

APPLICATOR INSTRUCTIONS
 408-35042

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: MINI MIC RECEPT CONTACT			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
3.00-3.50 mm [1.18-.138 IN]		Ø1.70-3.30 mm [0.067-.130 IN]	
TERMINAL APPLICATION SPECIFICATION	(A)114-20045	-	-
	(B)114-20062	-	-

TERMINALS APPLIED				SEAL INSULATION DIAMETER RANGE
TE TERMINAL	TE TERMINAL	TE SEAL	TE SEAL	
(A) 282110-1			(A) 281934-2	Ø1.7-2.4mm
			(A) 281934-3	Ø2.5-3.3mm
			(B) 828904-1	Ø1.9-2.1mm
			(B) 828905-1	Ø2.2-2.4mm

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.50mm2	1.40+/-0.05 [0.055+/-0.002]	4.6
16 AWG	1.33+/-0.05 [0.052+/-0.002]	5.4
1.00mm2	1.22+/-0.05 [0.048+/-0.002]	6.6
0.75mm2	1.14+/-0.05 [0.045+/-0.002]	7.7

- 1 RECOMMENDED SPARE PARTS
- 2 GREASE BEARING SURFACES LIGHTLY
- 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 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.
- 6 TERMINAL LUBRICANT IS RECOMMENDED.
- 7. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT 101-35000.
- 8 CUT TO LENGTH AT ASSEMBLY.

***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	1803945-4	TONKER			300
-	1	1	1-22278-9	SPRING, COMPRESSION			299
-	2	2	4-18032-3	SCR, SET, FLT PNT, M3 X 6.0			298
-	1	1	1803944-1	SPACER, TONKER			297
-	1	1	3-1463053-5	HOLDER, TERMINAL			294
-	1	1	2119082-2	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	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20			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
-	1	1	1752356-1	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	2119533-3	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	318707-1	FLOATING SHEAR, FRONT			9
-	1	1	1333205-6	ANVIL, COMBINATION			8
-	1	1	1-240641-3	SPACER			7
-	-	-	-	-			6
-	1	1	2119781-2	DEPRESSOR, SHEAR			5
-	1	1	2-238011-2	BLOCK, CRIMPER SPACER			4
-	1	1	3-2119784-8	CRIMPER, INSULATION O PREMIUM			3
-	1	1	1-455888-0	SPACER, CRIMPER			2
-	1	1	4-456406-1	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				

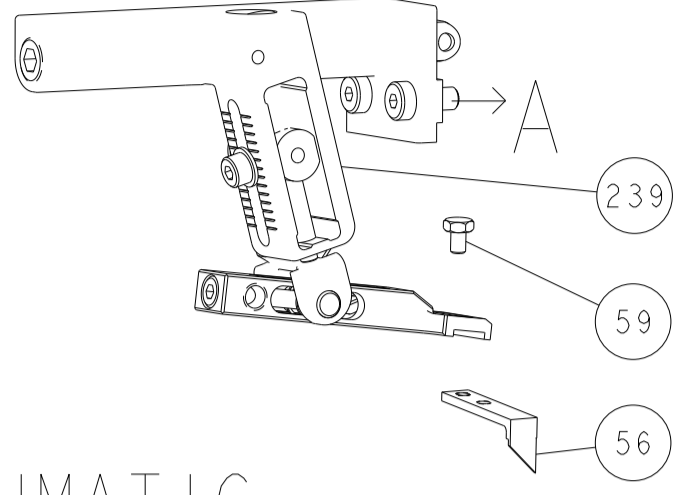
ITEM NO	DESCRIPTION	DATE	BY	CHKD	APVD
-77-22-21	PART NO	15NOV2011	T. YIN	G. BAILEY	S. XI

NAME	SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
Ocean Side Feed Applicator	A1	00779	2151205	

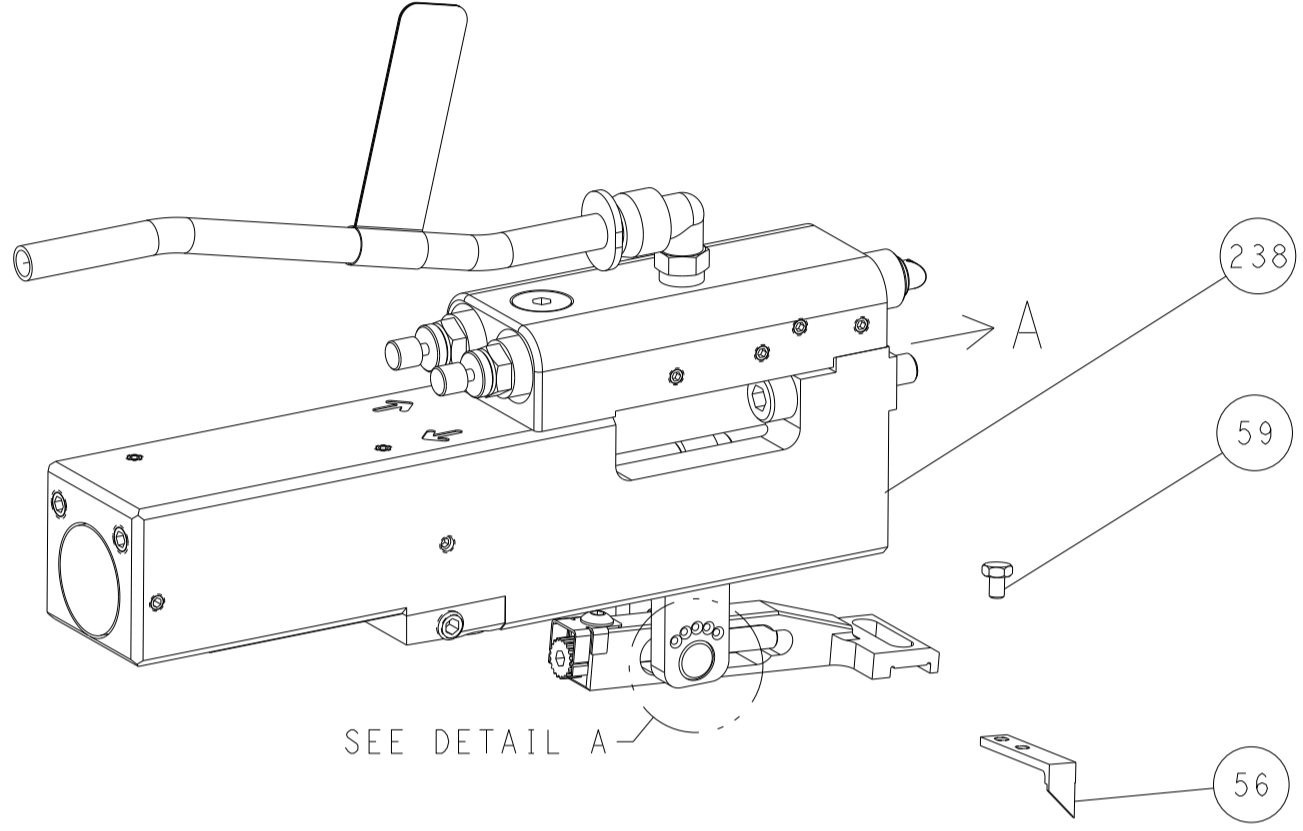
Customer Accessible Production Drawing

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

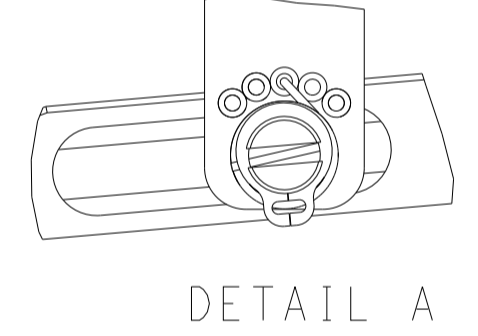
FEED TYPE MECHANICAL



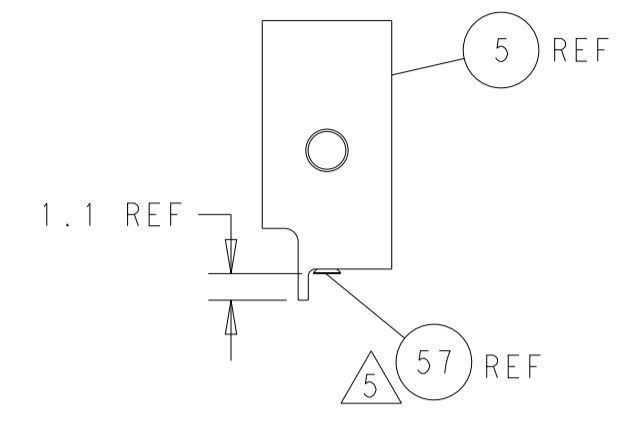
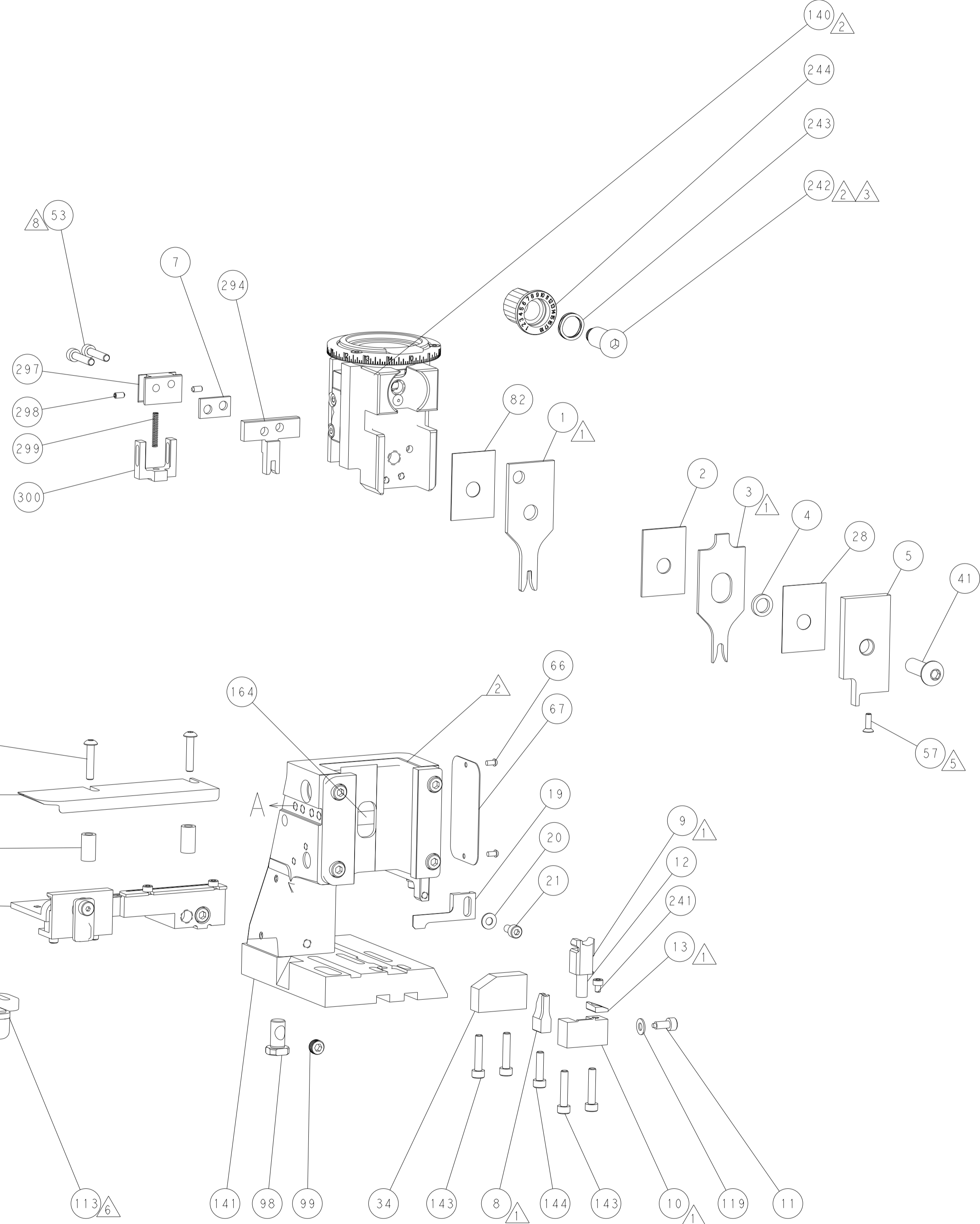
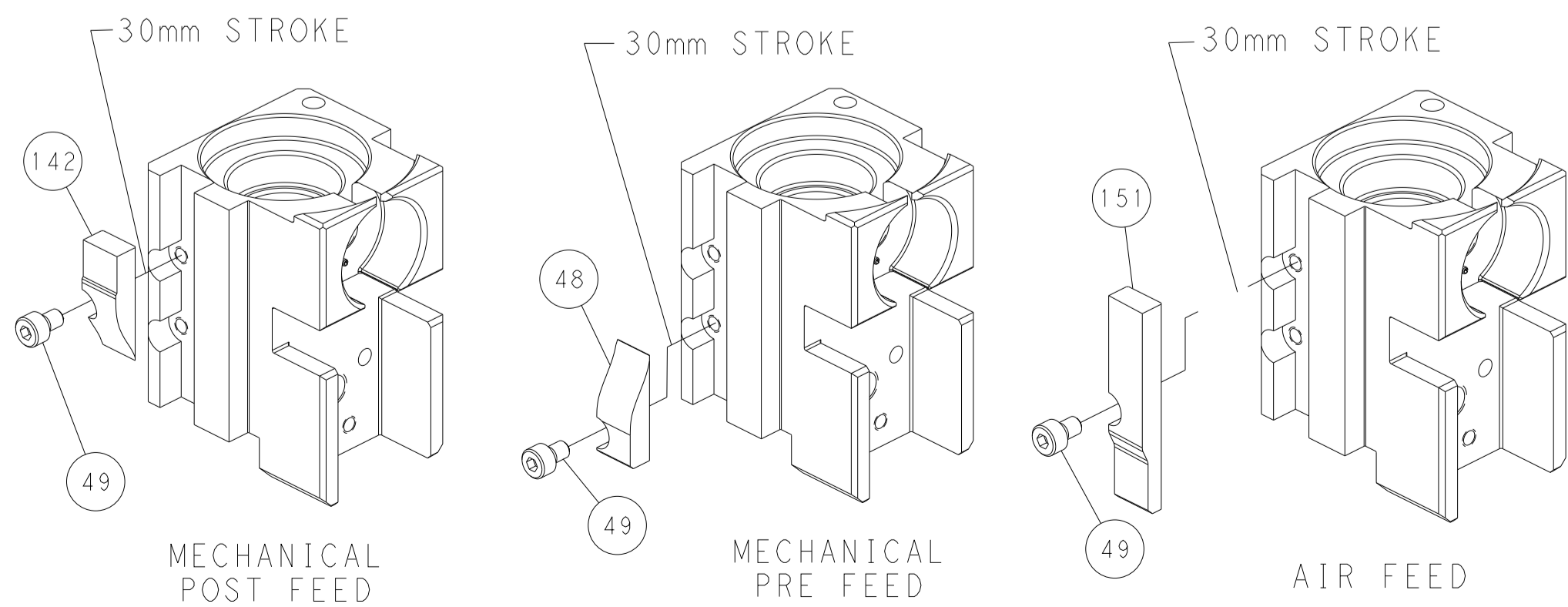
PNEUMATIC



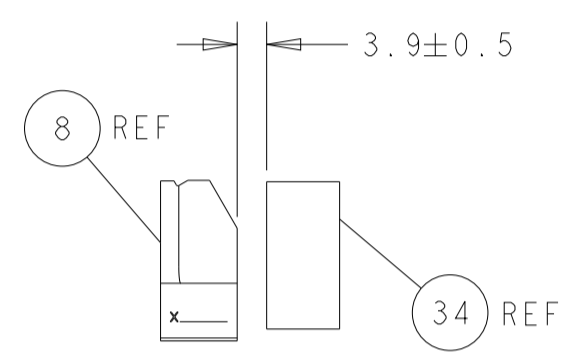
FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



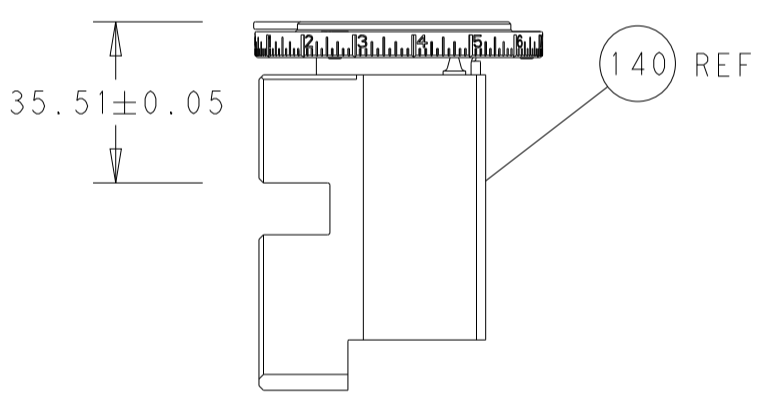
CAM POSITIONS



SHEAR DEPRESSOR DETAIL

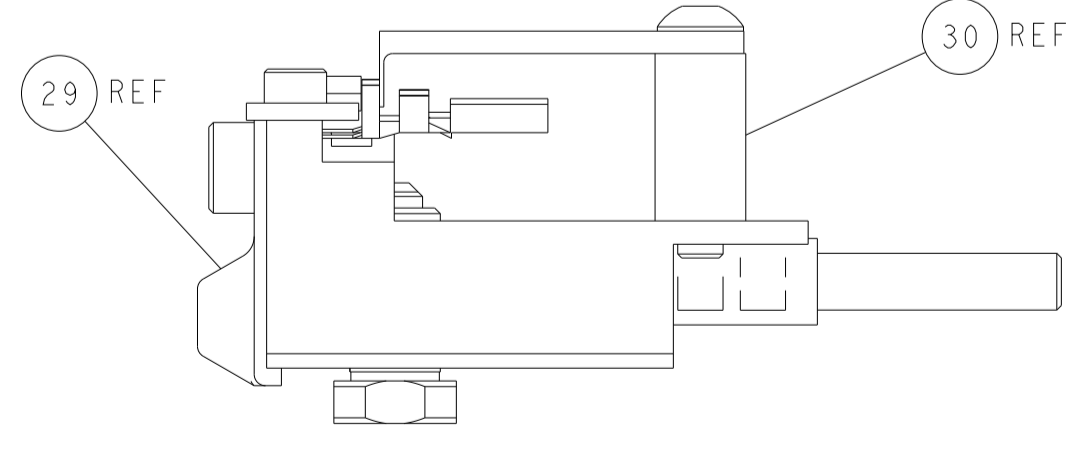


TERMINAL SUPPORT LOCATION



RAM SET-UP

ITEM 30 LOCATED AT FRONT HOLES



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)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN Y. YIN 15NOV2011		TE Connectivity Harrisburg, PA 17105-3608	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±		
MATERIAL:		FINISH:		NAME Ocean Side Feed Applicator		RESTRICTED TO	
				SIZE CAGE CODE DRAWING NO		A 00779 C-2151205	
				WEIGHT		SCALE 1:2 SHEET 4 OF 4 REV K	