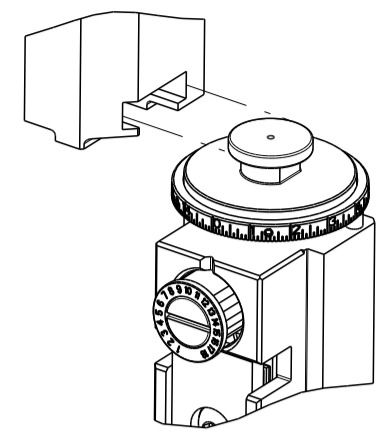


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151022-1	N	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2151022-2	N	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151022-1	N	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2151022-2	N	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2151022-7	N	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.40 mm [.055]	F
INSUL	1.78 mm [.070]	F

APPLICATOR INSTRUCTIONS
408-35042

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: CONTACT, RECEPTACLE, CRIMP SNAP-IN, MICRO MATE-N-LOCK			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
2.90-3.50 mm [.114-.138 IN]		Ø.89-1.52 mm [.035-.060 IN]	
TERMINAL APPLICATION SPECIFICATION	114-13000		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
794606-1	794606-2	794606-3	2825493-1
1-794606-1	1-794606-2	1-794606-3	

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
20 AWG	0.89+/-0.05 [.035+/- .002]	7.8
0.5mm ²	0.83+/-0.03 [.033+/- .001]	8.4
22 AWG	0.79+/-0.05 [.031+/- .002]	8.9
0.35mm ²	0.79+/-0.03 [.031+/- .001]	9.0
24 AWG	0.69+/-0.05 [.027+/- .002]	9.9

- RECOMMENDED SPARE PARTS
- REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION, AND STORAGE OF THE APPLICATOR
- APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEMS 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					
		P	LTN	DESCRIPTION	DATE	OWN	APVD
A	66	K1		ECR-19-001747	02FEB2019	FJ	YY
		L		ECR-19-005880	11APR2019	FL	CT
		M		ECR-19-009012	08JUN2019	TB	TE
		N		ECR-21-006467	24JUN2021	JWC	GB

-	1	1	1	1	2280441-1	INSERT, SHEAR	282	
-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248	
-	1	1	1	1	2119082-8	CAM, SNAIL, INSULATION ADJUSTMENT	244	
-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243	
	-	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	-	-	2119580-1	MECHANICAL FEED ASSEMBLY	239	
-	1	-	1	-	2844940-1	AIR FEED MODULE	238	
-	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164	
-	1	1	1	1	2168083-6	SCR, SKT HD CAP, RoHS, M5 X 65	124	
-	2	2	2	2	1-18028-2	WASHER, FLAT, REG M4	119	
	-	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	1-22281-8	SPRING, COMPRESSION	96	
-	1	1	1	1	980371-4	SCR, SKT HD SHLDR 5.0 DIA X 6.0	83	
-	1	1	1	1	455888-6	SPACER, CRIMPER	82	
-	1	1	1	1	240641-5	SPACER	81	
-	1	1	1	1	1803607-3	DOCUMENTATION PACKAGE	71	
-	4	4	4	4	18026-1	WASHER, SPRG LOCK, REG M3	68	
-	1	1	1	1	2119740-1	TAG, IDENTIFICATION	67	
-	2	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66	
-	4	4	4	4	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	65	
-	2	2	2	2	2-18032-5	SCR, SET, FLT PNT, M5 X 20.0	61	
-	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	1338683-1	FEED PAWL	56	
-	4	4	4	4	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	54	
-	2	2	2	2	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	53	
-	1	2	1	2	18023-9	SCR, SKT HD CAP M4 X 6.0	49	
-	-	1	-	-	2119652-1	FEED CAM, PRE FEED	48	
-	-	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	
-	1	1	1	1	2305692-1	PLATE, REAR STRIP GUIDE	29	
-	1	1	1	1	1-455888-0	SPACER, CRIMPER	28	
-	2	2	2	2	1-22284-0	SPRING, COMPRESSION	27	
-	1	1	1	1	356835-1	LEVER, DRAG RELEASE	26	
-	1	1	1	1	240792-1	DRAG, TERMINAL	25	
-	1	1	1	1	189124-7	GUIDE, FRONT STRIP	24	
-	1	1	1	1	690438-1	FRONT STRIP GUIDE	23	
-	1	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21	
-	1	1	1	1	1-18028-2	WASHER, FLAT, REG M4	20	
-	1	1	1	1	2119533-1	STRIPPER, SIDE FEED	19	
-	1	1	1	1	690518-1	HOLD DOWN, TERMINAL	18	
-	1	1	1	1	2-690463-3	FLOATING SHEAR, REAR	17	
-	2	2	2	2	1-2168083-1	SCR, SKT HD CAP, RoHS, M3 X 6	16	
-	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	2119805-1	SHEAR HOLDER, FRONT	10	
	-	1	1	1	1803095-1	FLOATING SHEAR, FRONT	9	
	1	2	2	1	1	4-1333201-0	ANVIL, COMBINATION	8
-	1	1	1	1	3-240641-7	SPACER	7	
-	1	1	1	1	690468-7	DEPRESSOR SHEAR, REAR	6	
-	1	1	1	1	1-2119757-9	DEPRESSOR, SHEAR	5	
-	1	1	1	1	2-238011-0	BLOCK, CRIMPER SPACER	4	
	1	2	2	1	1	1-2119582-2	CRIMPER, INSULATION F PREMIUM	3
-	1	1	1	1	455888-6	SPACER, CRIMPER	2	
	1	2	2	1	1	3-1803125-5	CRIMPER, WIRE	1

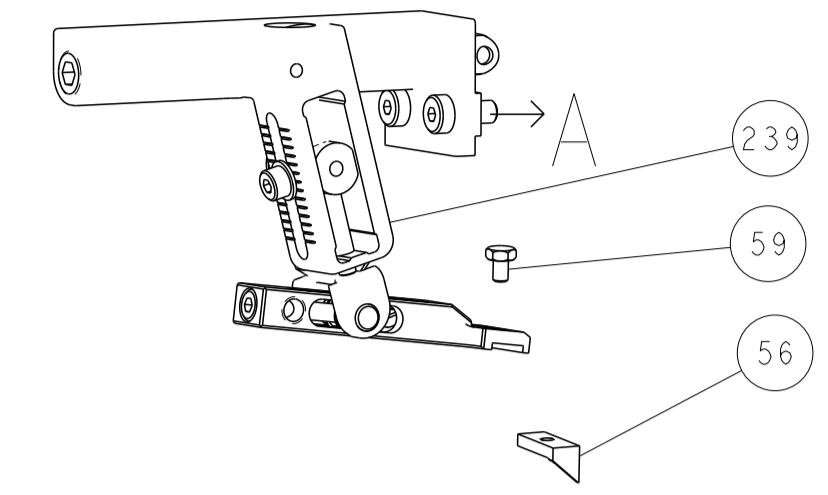
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		MATERIAL:	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±
	ANGLES	FINISH			

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

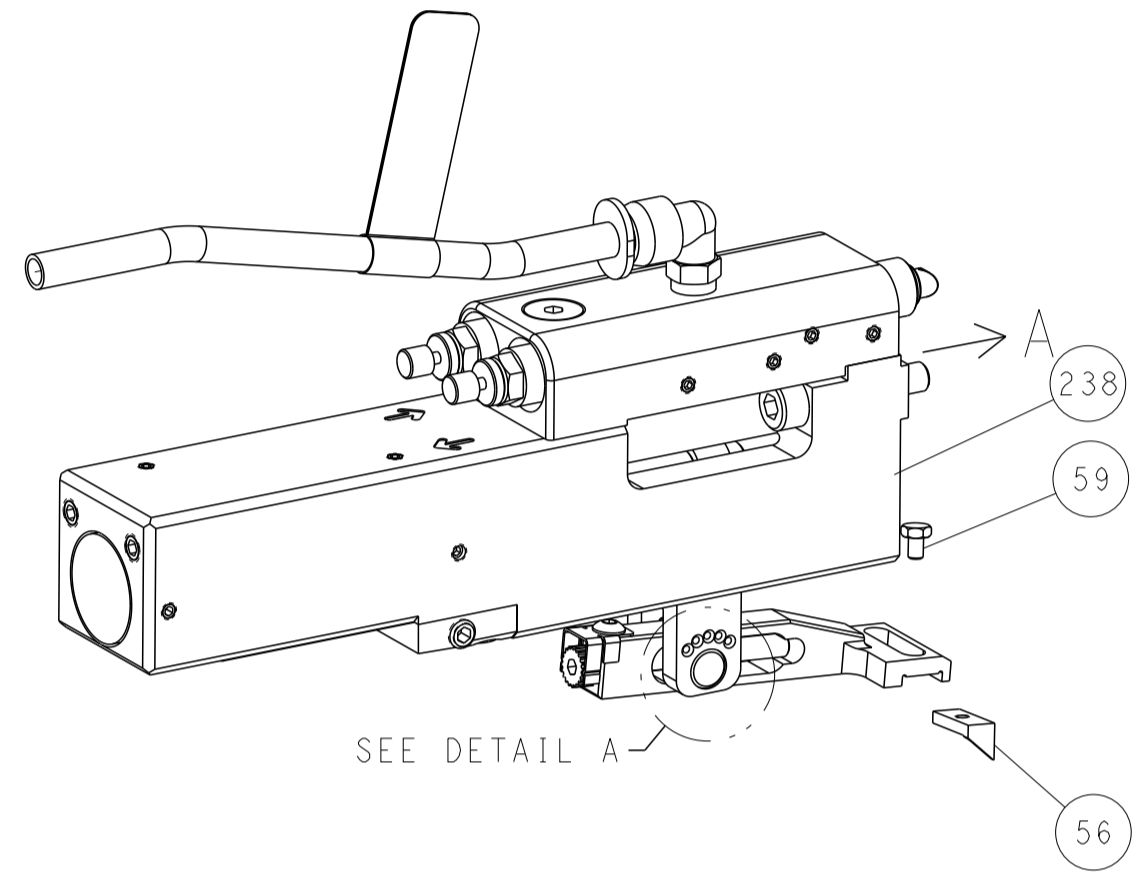
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CHK	L. ZHANG	16NOV2011	SIZE	A1
CHK	L. ZHANG	16NOV2011	CAGE CODE	00779
CHK	L. ZHANG	16NOV2011	DRAWING NO	2151022
APVD	S. XI	16NOV2011	SCALE	1:2
APVD	S. XI	16NOV2011	SHEET	1 of 4
APVD	S. XI	16NOV2011	REV	N

LOC		DIST		REVISIONS				
P	LTN	DATE	DMN	APVD	DESCRIPTION	DATE	DMN	APVD
-	-	SEE SHEET 1	-	-	-	-	-	-

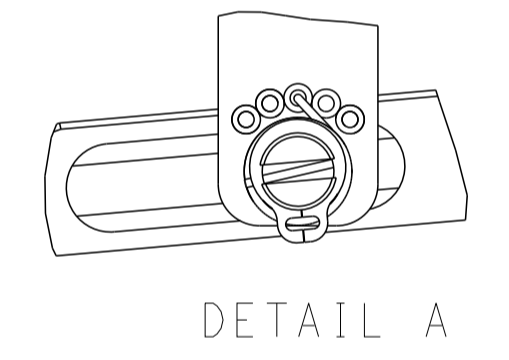
FEED TYPE MECHANICAL



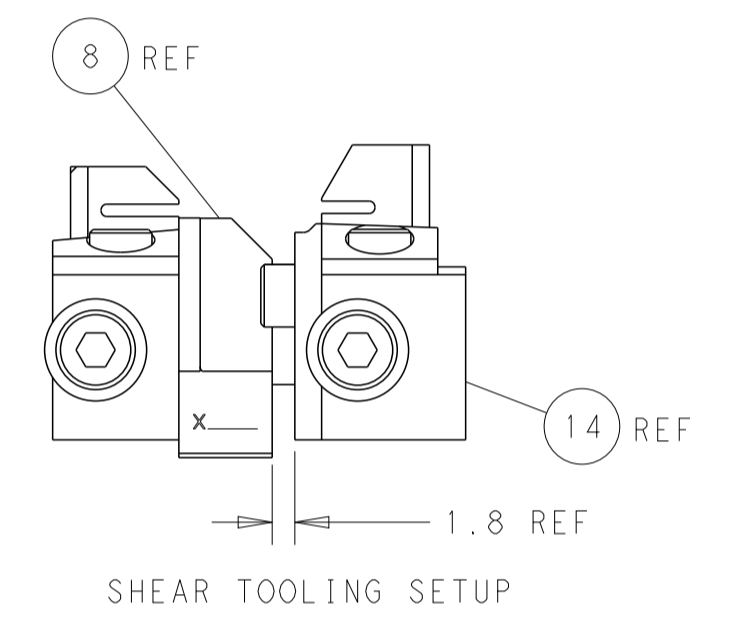
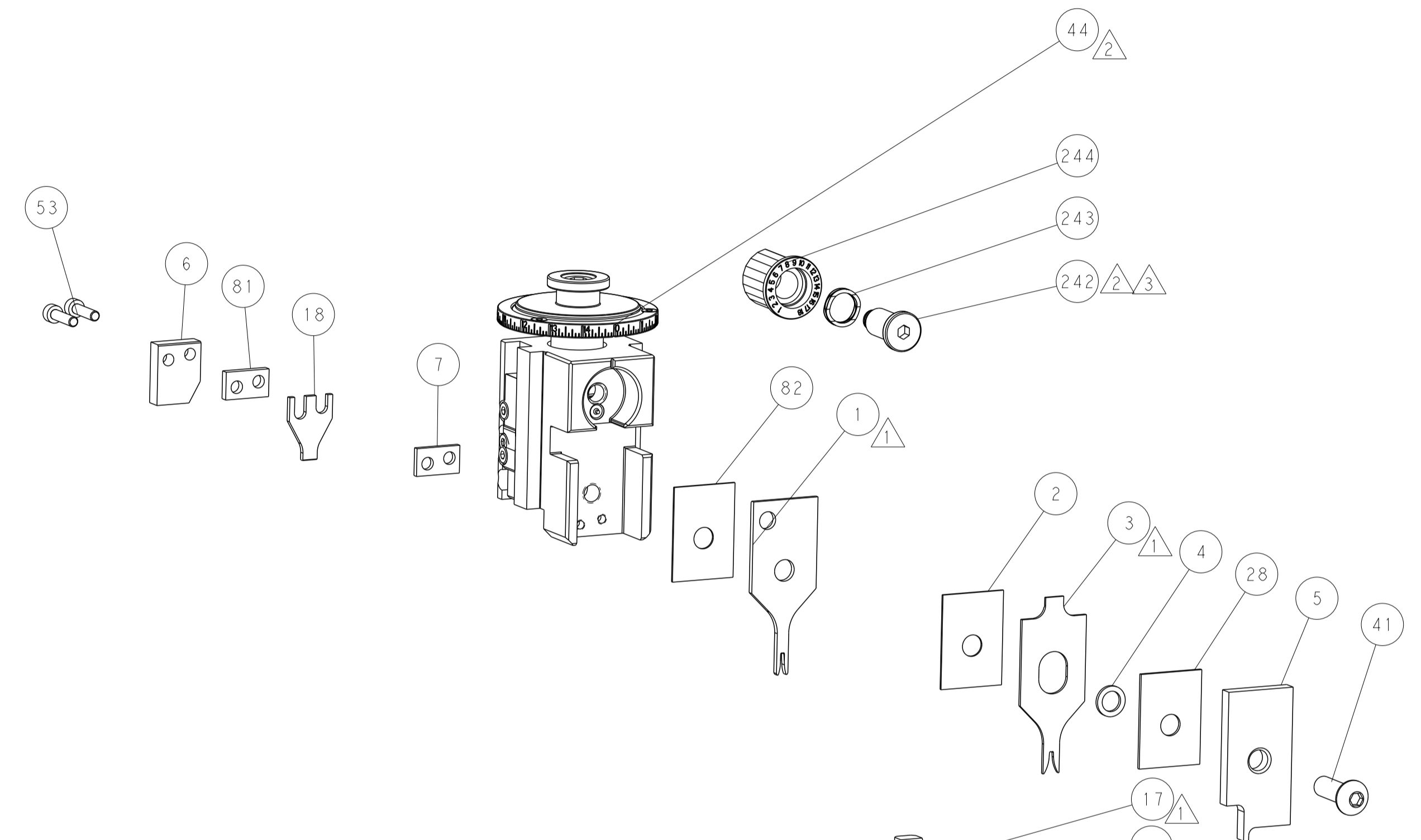
PNEUMATIC



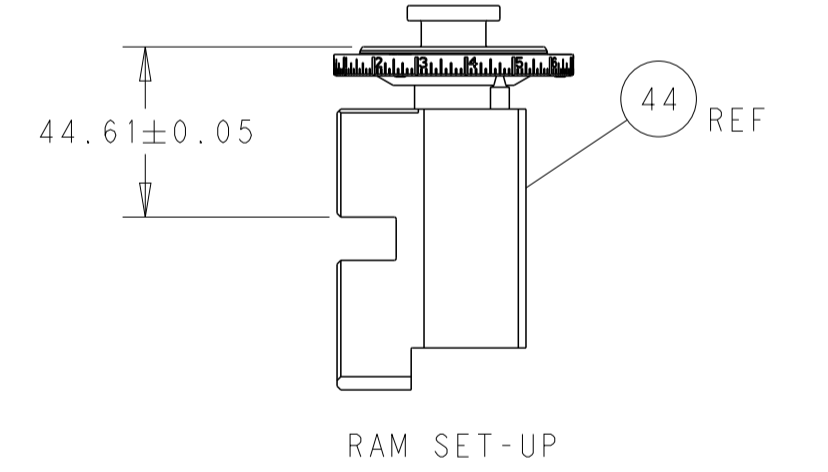
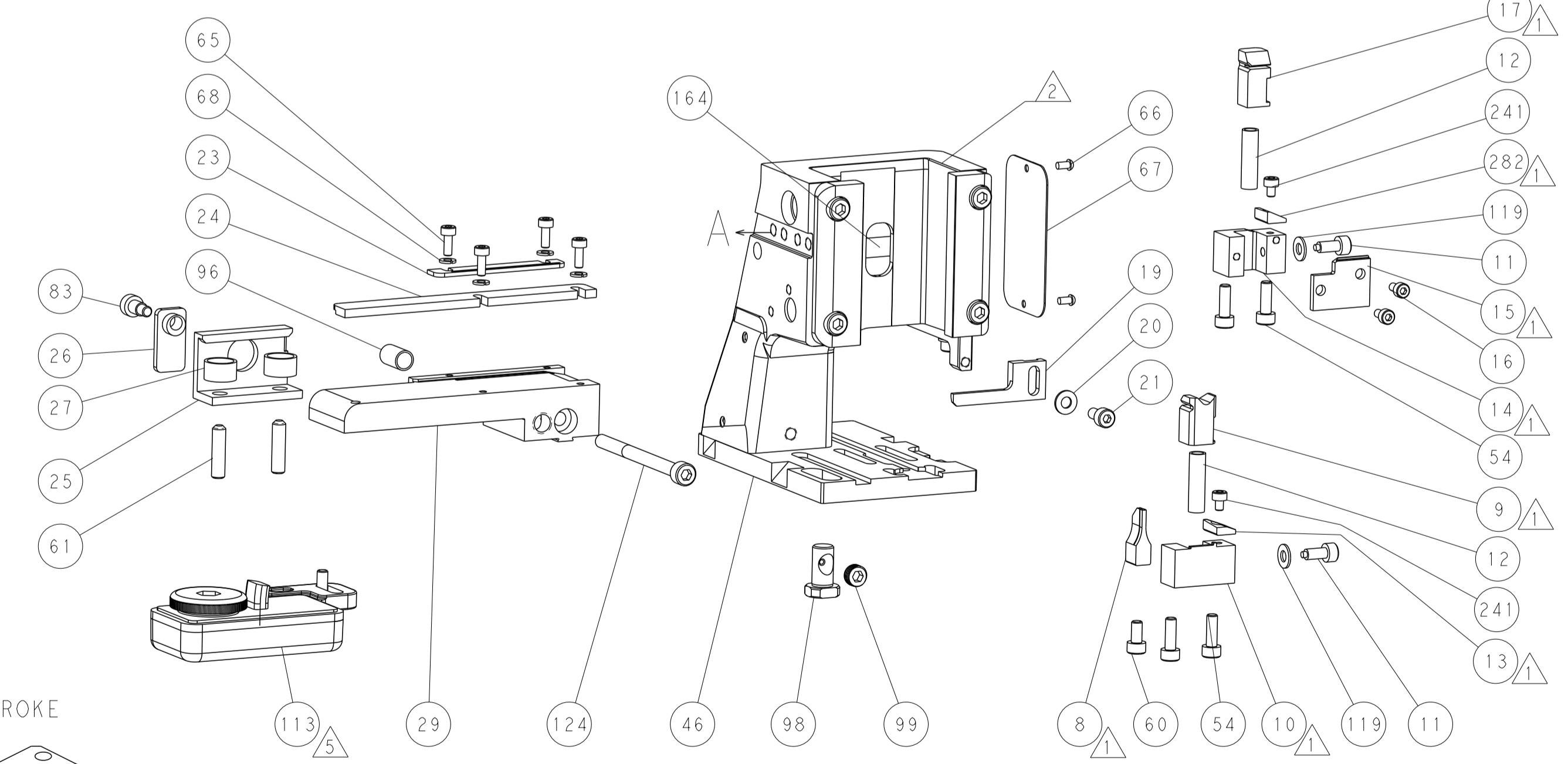
FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



DETAIL A

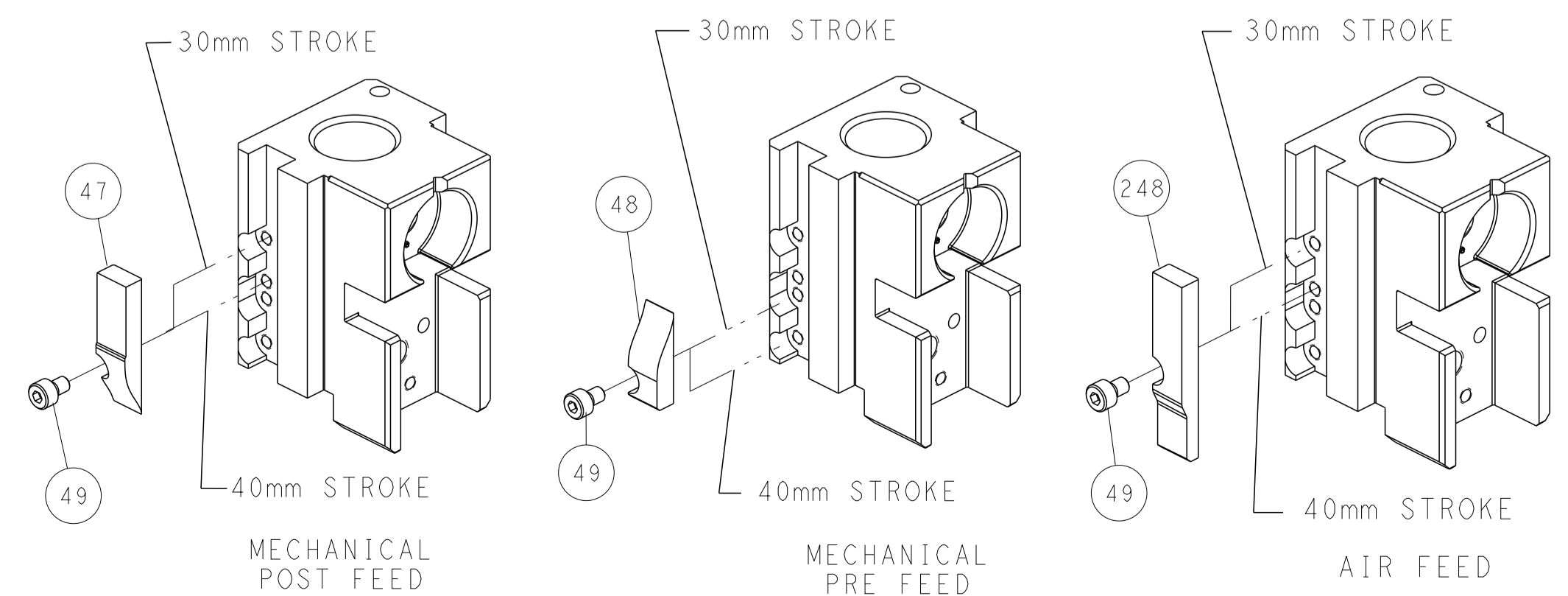


SHEAR TOOLING SETUP

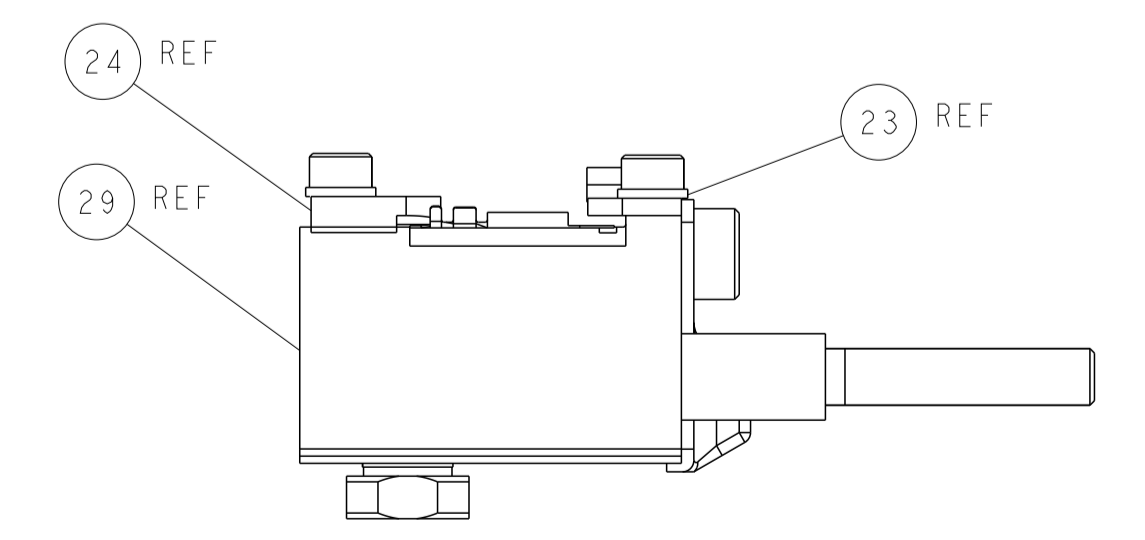


RAM SET-UP

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:		DWG L. ZHANG 16NOV2011		TE Connectivity Harrisburg, PA 17105-3608	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	NAME	Ocean Side Feed Applicator
MATERIAL:	FINISH:	WEIGHT:	SCALE:	1:2	SHEET 2 OF 4	REV N	RESTRICTED TO
Customer Accessible Production Drawing				A1 00779 ©=2151022			

8	7	6	5	4	3	2	1
THIS DRAWING IS UNPUBLISHED.		RELEASED FOR PUBLICATION		20			
COPYRIGHT © BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.							
PART NUMBER	REVISION	DESCRIPTION	FEED TYPE				
2-2151022-1	N	FINE CRIMP HEIGHT ADJUST	MECHANICAL				
2-2151022-2	N	FINE CRIMP HEIGHT ADJUST	PNEUMATIC				
7-2151022-7	N	CRIMP TOOLING KIT	-				

PACIFIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.40 mm [.055]	F
INSUL	1.78 mm [.070]	F
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: CONTACT, RECEPTACLE, CRIMP SNAP-IN, MICRO MATE-N-LOCK			
WIRE STRIP LENGTH 2.90-3.50 mm [.114-.138 IN]		INSULATION DIAMETER RANGE Ø.89-1.52 mm [.035-.060 IN]	
TERMINAL APPLICATION SPECIFICATION	114-13000	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
794606-1	794606-2	794606-3	2825493-1
1-794606-1	1-794606-2	1-794606-3	

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
20 AWG	0.89+/-0.05 [.035+/- .002]	7.8
0.5mm ²	0.83+/-0.03 [.033+/- .001]	8.4
22 AWG	0.79+/-0.05 [.031+/- .002]	8.9
0.35mm ²	0.79+/-0.03 [.031+/- .001]	9.0
24 AWG	0.69+/-0.05 [.027+/- .002]	9.9

- RECOMMENDED SPARE PARTS
- GREASE BEARING SURFACES LIGHTLY
- APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEMS 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.

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

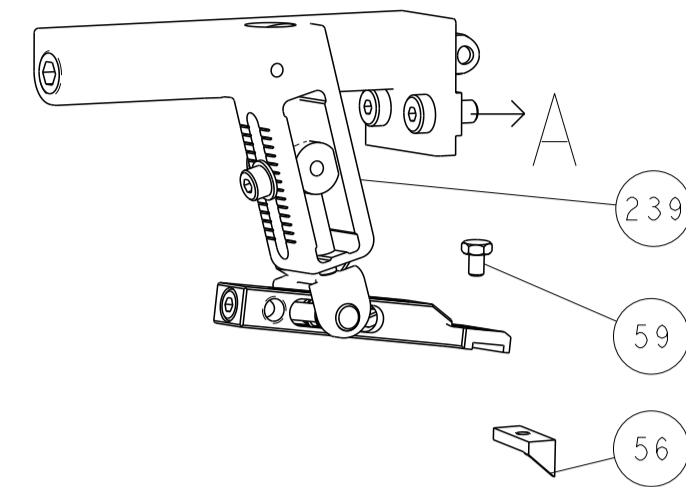
LOC	DIST	REVISIONS					
A	66	P	LTN	DESCRIPTION	DATE	OWN	APVD
		-		SEE SHEET 1	-	-	-

-	1	1	2280441-1	INSERT, SHEAR	282
-	1	1	2119082-8	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	2	2	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	2168083-6	SCR, SKT HD CAP, RoHS, M5 X 65	124
-	2	2	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	1-22281-8	SPRING, COMPRESSION	96
-	1	1	980371-4	SCR, SKT HD SHLDR 5.0 DIA X 6.0	83
-	1	1	455888-6	SPACER, CRIMPER	82
-	1	1	240641-5	SPACER	81
-	1	1	1803607-3	DOCUMENTATION PACKAGE	71
-	4	4	18026-1	WASHER, SPRG LOCK, REG M3	68
-	1	1	2119740-1	TAG, IDENTIFICATION	67
-	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	4	4	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	65
-	2	2	2-18032-5	SCR, SET, FLT PNT, M5 X 20.0	61
-	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	1	1	1338683-1	FEED PAWL	56
-	2	2	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	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	2305692-1	PLATE, REAR STRIP GUIDE	29
-	1	1	1-455888-0	SPACER, CRIMPER	28
-	2	2	1-22284-0	SPRING, COMPRESSION	27
-	1	1	356835-1	LEVER, DRAG RELEASE	26
-	1	1	240792-1	DRAG, TERMINAL	25
-	1	1	189124-7	GUIDE, FRONT STRIP	24
-	1	1	690438-1	FRONT STRIP GUIDE	23
-	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	690518-1	HOLD DOWN, TERMINAL	18
-	1	1	2-690463-3	FLOATING SHEAR, REAR	17
-	2	2	1-2168083-1	SCR, SKT HD CAP, RoHS, M3 X 6	16
-	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	1803095-1	FLOATING SHEAR, FRONT	9
1	1	1	4-1333201-0	ANVIL, COMBINATION	8
-	1	1	3-240641-7	SPACER	7
-	1	1	690468-7	DEPRESSOR SHEAR, REAR	6
-	1	1	1-2119757-9	DEPRESSOR, SHEAR	5
-	1	1	2-238011-0	BLOCK, CRIMPER SPACER	4
1	1	1	1-2119582-2	CRIMPER, INSULATION F PREMIUM	3
-	1	1	455888-6	SPACER, CRIMPER	2
1	1	1	3-1803125-5	CRIMPER, WIRE	1

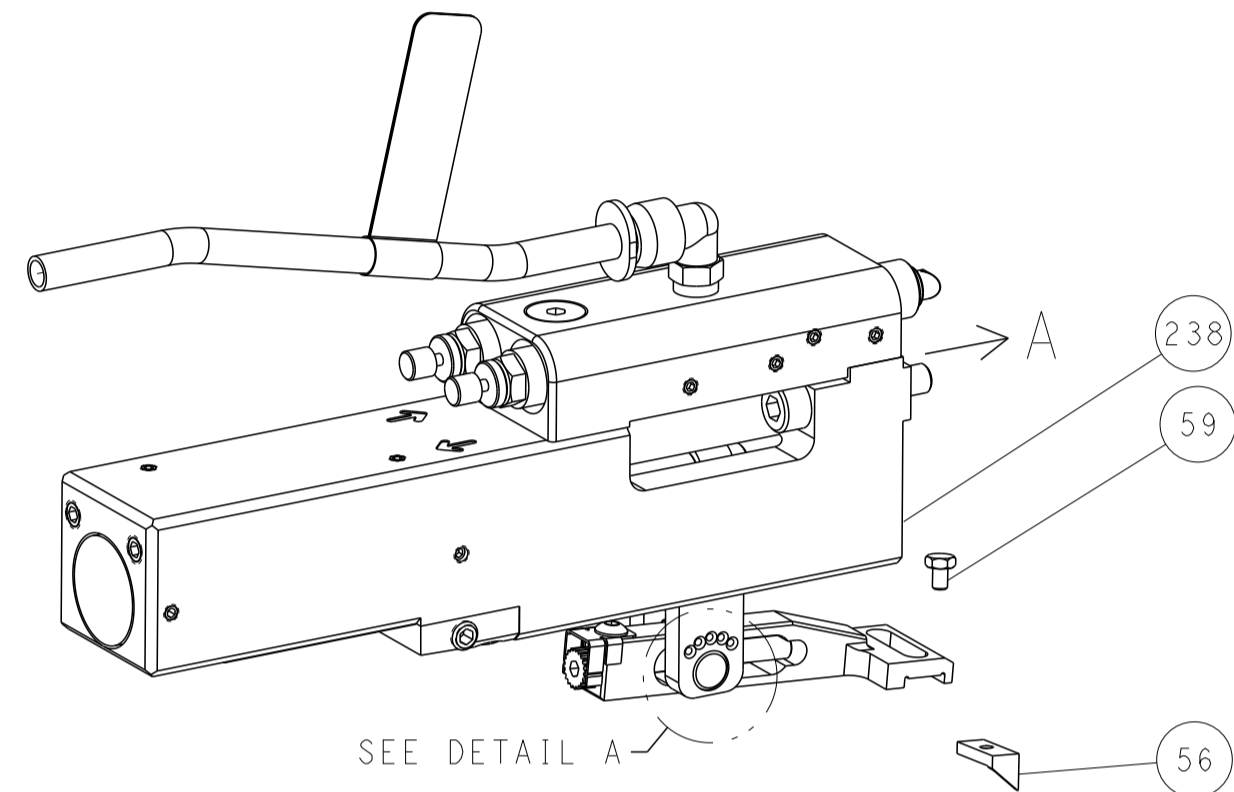
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG		16NOV2011		TE Connectivity	
mm		0 PLC ±		CHK		L. ZHANG		Harrisburg, PA 17105-3608	
Ø		1 PLC ±		CHK		L. ZHANG		NAME	
H		3 PLC ±		APVD		S. XI		Ocean Side Feed	
A		4 PLC ±		APVD		16NOV2011		Applicator	
ANGLES		FINISH		PRODUCT SPEC		APPLICATION SPEC		SIZE	
MATERIAL		FINISH		WEIGHT		A1		CAGE CODE	
						00779		DRAWING NO	
						C=2151022		RESTRICTED TO	
						Customer Accessible Production Drawing		SCALE	
						1:2		SHEET 3 OF 4	
								REV N	

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

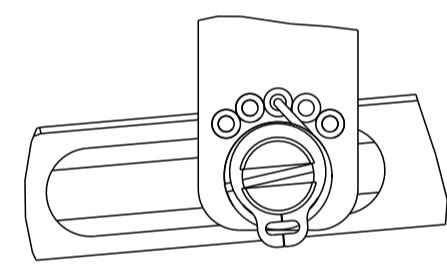
FEED TYPE MECHANICAL



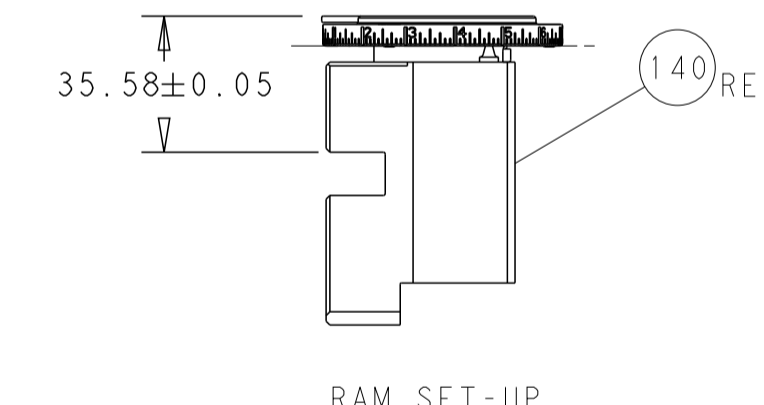
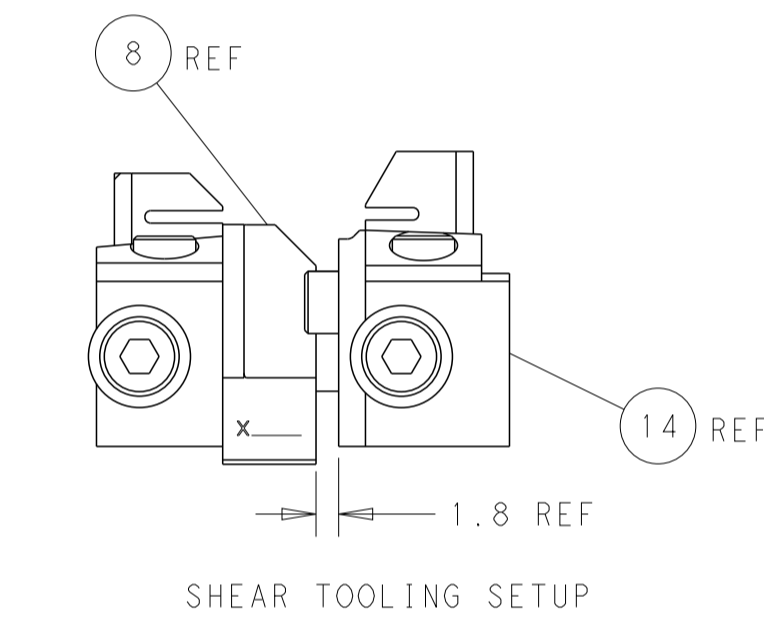
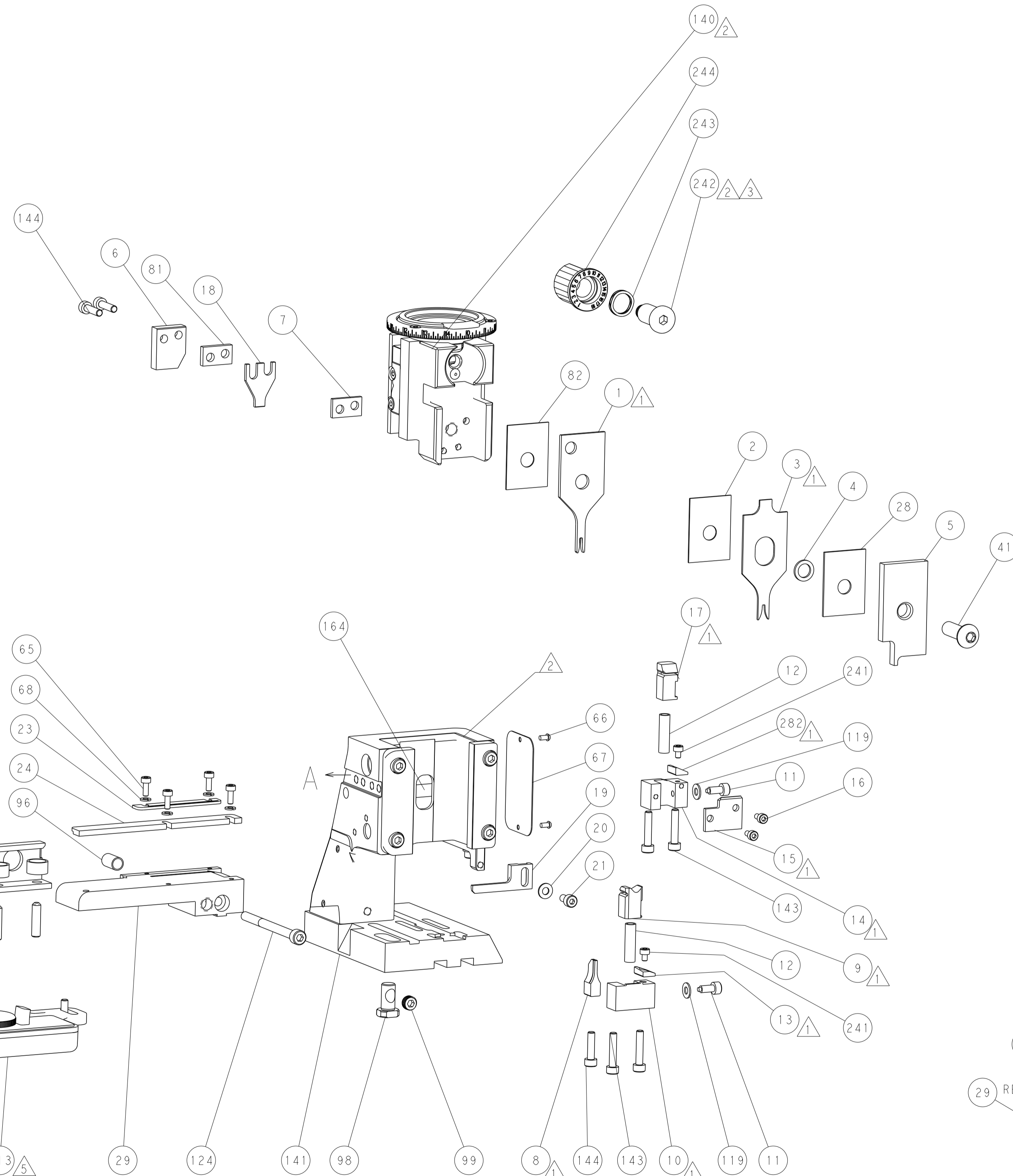
PNEUMATIC



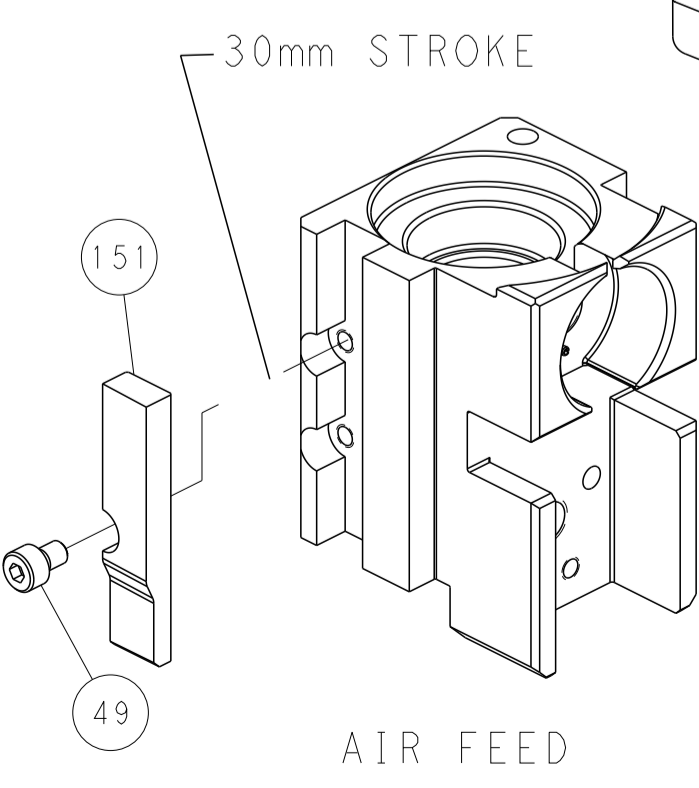
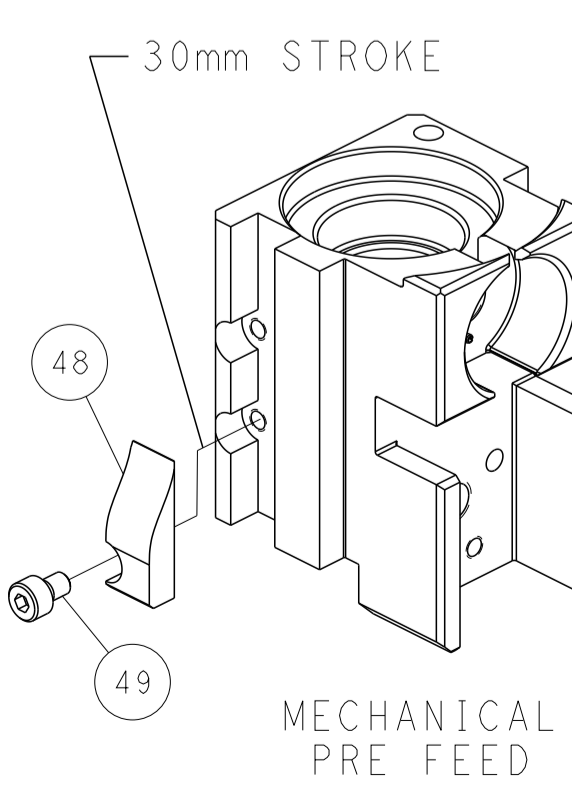
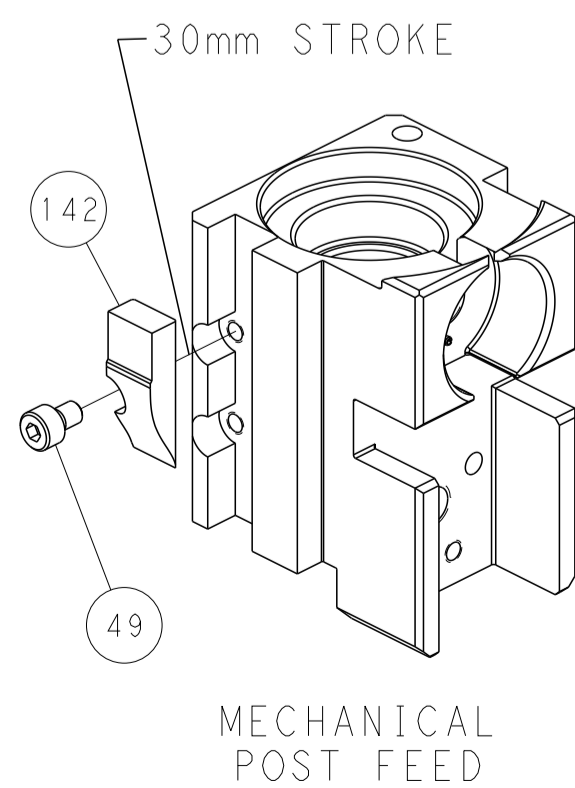
FEED SPRING SETTING POSITION
(SHOWN FROM REAR SIDE)



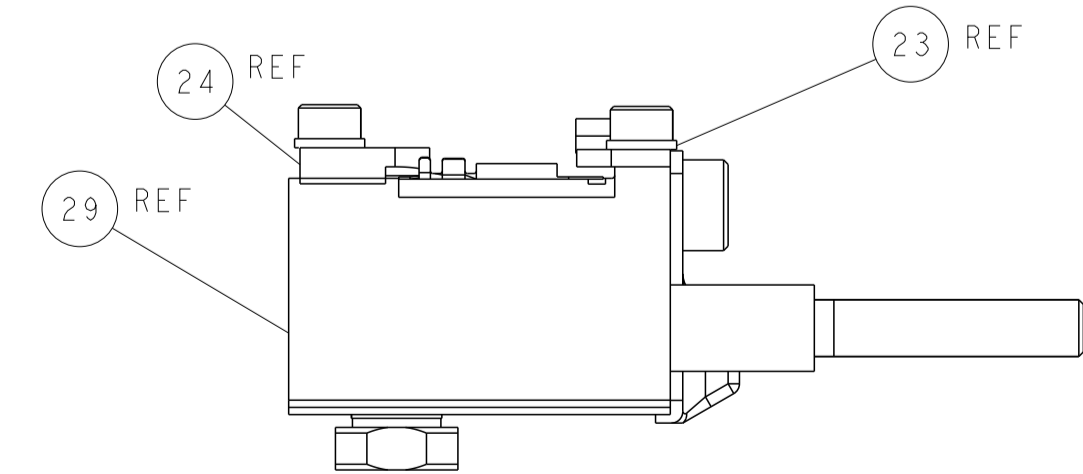
DETAIL A



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 PRODUCT SPEC APPLICATION SPEC SIZE CAGE CODE DRAWING NO. A1 00779 C=2151022 WEIGHT Customer Accessible Production Drawing	RESTRICTED TO SCALE 1:2 SHEET 4 OF 4 REV N