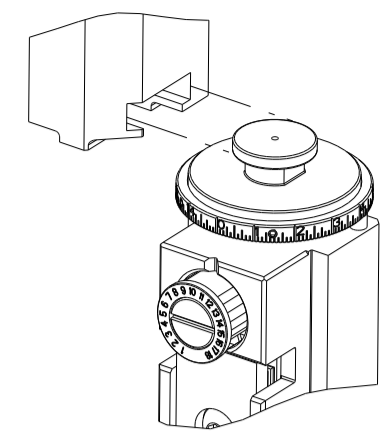


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151966-1	E	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2151966-2	E	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151966-1	E	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2151966-2	E	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2151966-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.17 mm [.046]	F
INSUL	1.57 mm [.062]	F

APPLICATOR INSTRUCTIONS
408-35042

TERMINAL DATA: TE TERMINAL				TE CRIMP SPECIFICATION			
TERMINAL NAME: 025 TH CONTACT							
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE		WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
3.00-3.50 mm [.118-.138 IN]		Ø0.90-1.20 mm [.035-.047 IN]		3.00-3.50 mm [.118-.138 IN]		Ø0.95-1.05 mm [.037-.041 IN]	
TERMINAL APPLICATION SPECIFICATION		(A)114-61030		TERMINAL APPLICATION SPECIFICATION		114-15120-1	
		(B)114-61031					
TERMINALS APPLIED							
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
(A) 2005097-1	(B) 2005098-1						

TERMINAL DATA: TE TERMINAL				TE CRIMP SPECIFICATION			
TERMINAL NAME: 025 TH CONTACT							
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE		WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
3.00-3.50 mm [.118-.138 IN]		Ø0.90-1.20 mm [.035-.047 IN]		3.00-3.50 mm [.118-.138 IN]		Ø0.95-1.05 mm [.037-.041 IN]	
TERMINAL APPLICATION SPECIFICATION		(A)114-61030		TERMINAL APPLICATION SPECIFICATION		114-15120-1	
		(B)114-61031					
TERMINALS APPLIED							
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
2005097-1	2005098-1						

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.22mm2	0.82+/-0.03 [.032+/- .001]	8.8
0.13mm2	0.764+/-0.02 [.030+/- .0008]	9.4

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.13mmR	0.764+/-0.020 [.0300+/- .0008]	9.4

- 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.
- 7 APPLICATION SPECIFICATION 114-15120-1 IS RESTRICTED TO PEUGEOT CITROËN AND ITS HARNESS MAKERS.

***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)

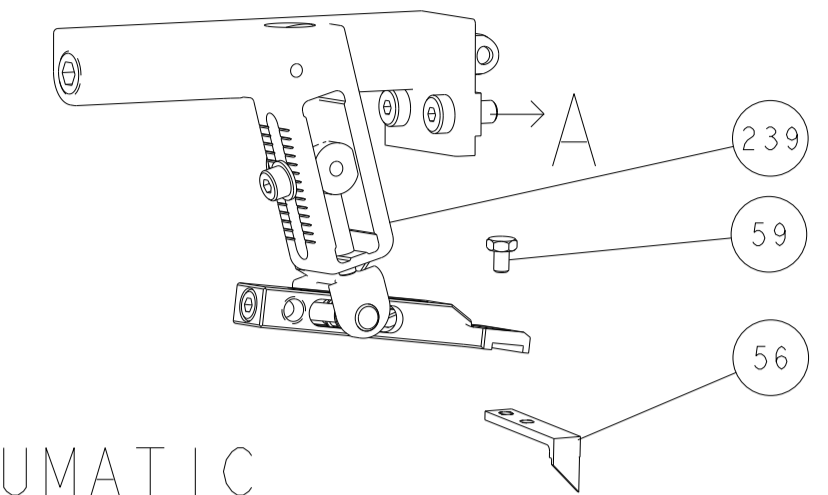
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A	66	P	LTN	DESCRIPTION	DATE	OWN	APVD
		C		ECR-14-019111	22DEC2014	LG	GB
		D		ECR-18-011724	23JUL2018	AW	CT
		E		ECR-19-019938	24DEC2019	FZ	TE
		E1		ECR-22-160550	05JAN2022	FZ	JAH

-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248	
-	1	1	1	1	2119082-5	CAM, SNAIL, INSULATION ADJUSTMENT	244	
-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243	
3	-	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242	
-	1	1	1	1	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	
-	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164	
-	1	1	1	1	1-18028-2	WASHER, FLAT, REG M4	119	
5	-	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	455888-5	SPACER, CRIMPER	82	
-	1	1	1	1	1803607-3	DOCUMENTATION PACKAGE	71	
-	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	1	1	1	1803382-6	HOLD DOWN, SPRING LOADED	50	
-	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	
-	1	1	1	1	1752356-6	SUPPORT, TERMINAL	34	
-	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33	
-	2	2	2	2	2-2844962-4	SPACER, CYLINDRICAL, STRIP GUIDE	30	
-	1	1	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29	
-	1	1	1	1	455888-3	SPACER, CRIMPER	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	
-	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	2119806-1	INSERT, SHEAR	13	
-	1	1	1	1	3-22280-3	SPRING, COMPRESSION	12	
-	1	1	1	1	1-356885-4	STOP, SHEAR	11	
1	-	1	1	1	2119805-1	SHEAR HOLDER, FRONT	10	
1	-	1	1	1	1803095-6	FLOATING SHEAR, FRONT	9	
1	1	2	2	1	1	2-1633928-4	ANVIL, COMBINATION	8
-	1	1	1	1	6-240641-9	SPACER	7	
-	-	-	-	-	-	-	6	
-	1	1	1	1	2119757-4	DEPRESSOR, SHEAR	5	
-	1	1	1	1	2-238011-2	BLOCK, CRIMPER SPACER	4	
1	1	2	2	1	1	6-2119582-4	CRIMPER, INSULATION F PREMIUM	3
-	1	1	1	1	455888-3	SPACER, CRIMPER	2	
1	1	2	2	1	1	5-568176-2	CRIMPER, WIRE	1
-	77	-72	-71	-2	-1	PART NO	DESCRIPTION	ITEM NO

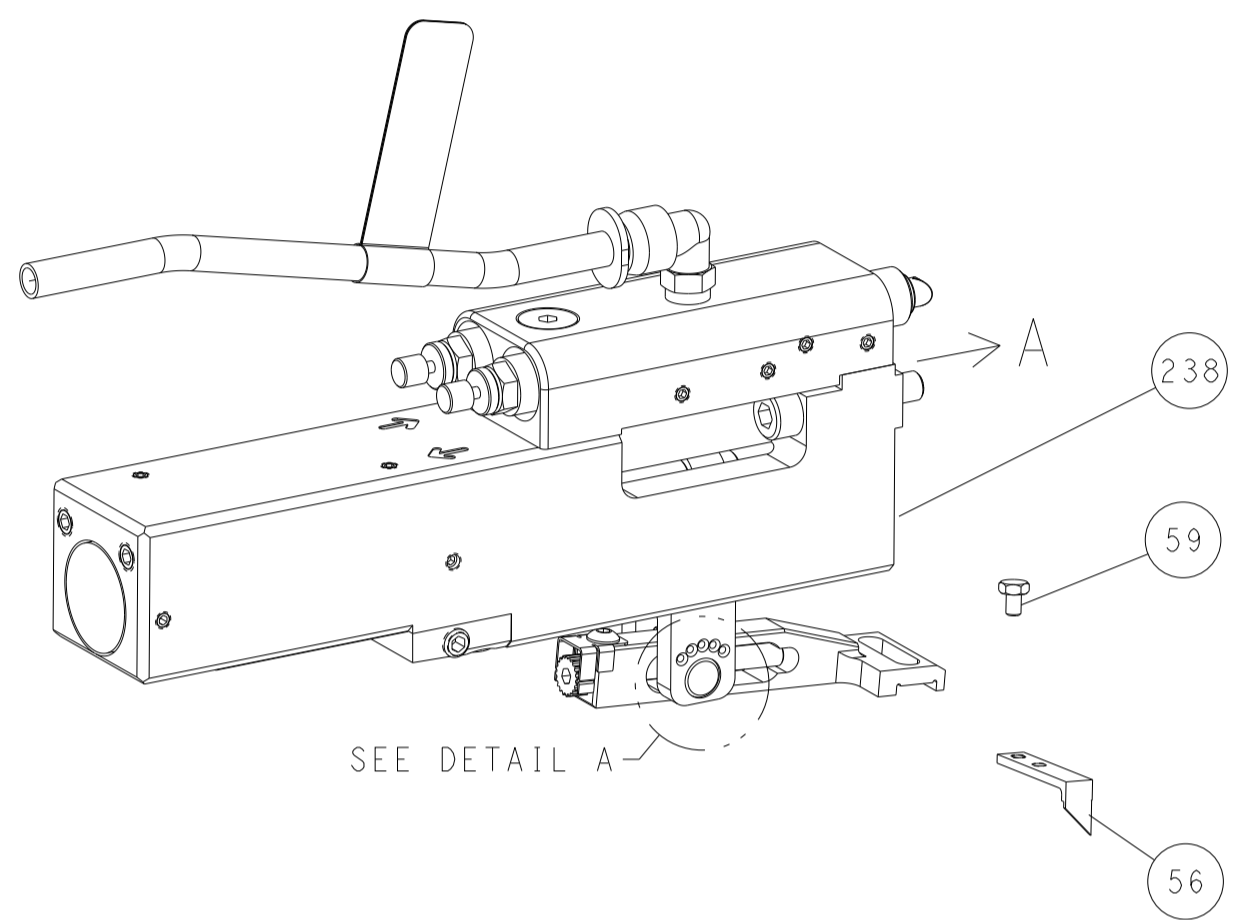
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mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES	FINISH	-	-	A1	00779
SCALE		1:2		SHEET		1 OF 4		REV		E1	

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

FEED TYPE MECHANICAL



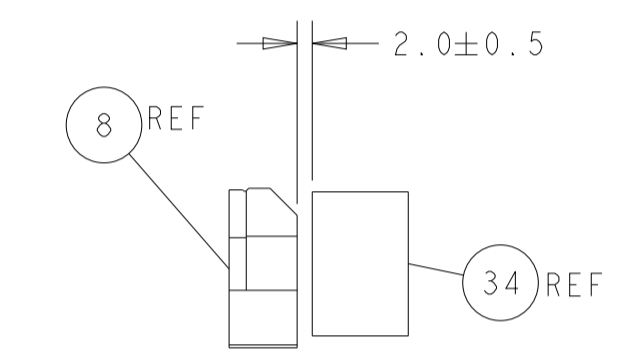
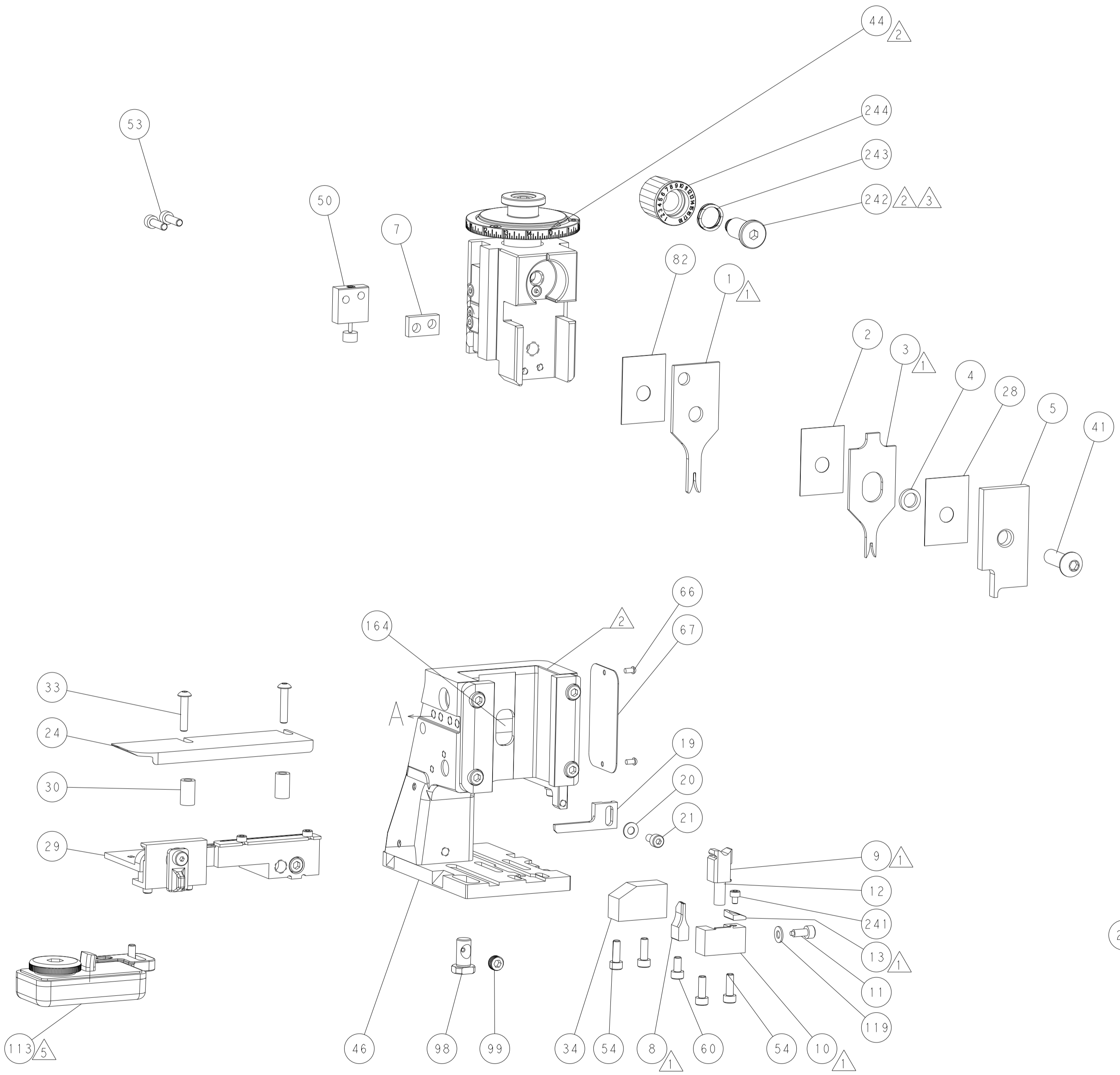
PNEUMATIC



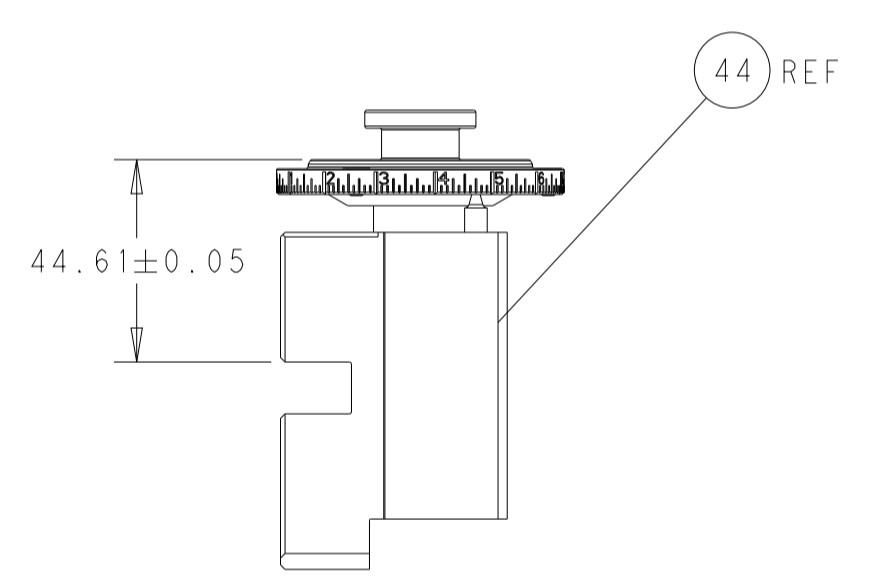
FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



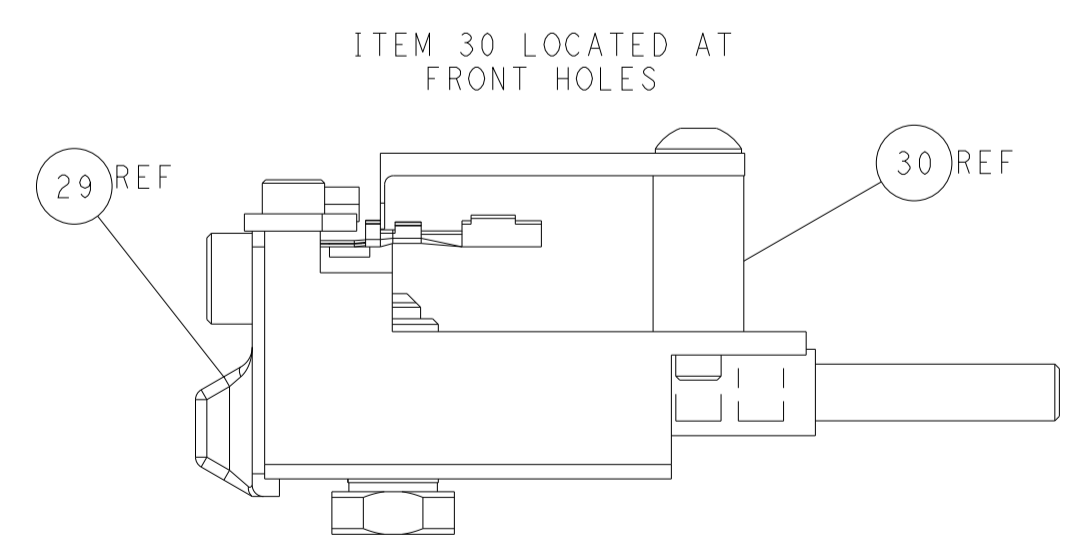
DETAIL A



TERMINAL SUPPORT LOCATION

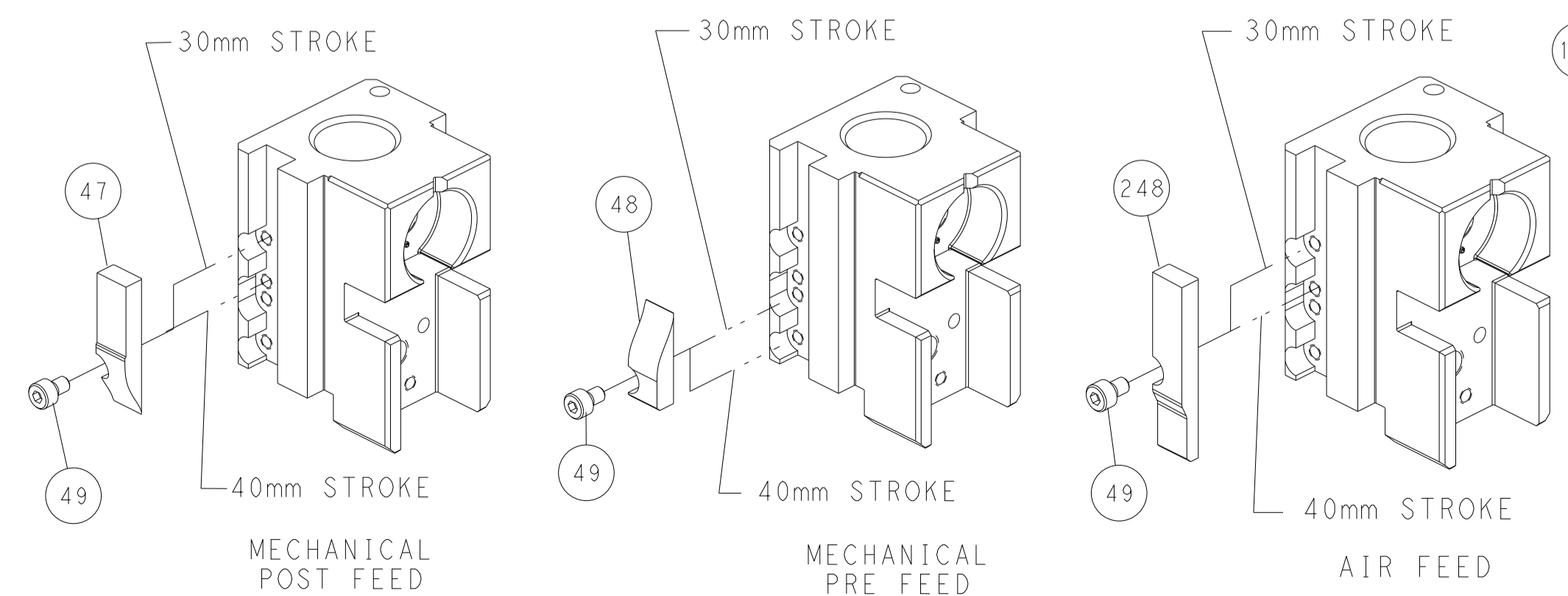


RAM SET-UP



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. ALL RIGHTS RESERVED. © 2013 BY TYCO ELECTRONICS CORPORATION. THIS DRAWING IS CONTROLLED DOCUMENT. THE INFORMATION CONTAINED HEREIN IS UNCLASSIFIED EXCEPT WHERE SHOWN OTHERWISE. THIS INFORMATION IS CONTROLLED DOCUMENT. THE INFORMATION CONTAINED HEREIN IS UNCLASSIFIED EXCEPT WHERE SHOWN OTHERWISE. THIS INFORMATION IS CONTROLLED DOCUMENT. THE INFORMATION CONTAINED HEREIN IS UNCLASSIFIED EXCEPT WHERE SHOWN OTHERWISE.</small>		DWN: Y. YIN CHK: G. BAILEY APVD: J. GUO	DATE: 29MAY2013 DATE: 29MAY2013 DATE: 29MAY2013	NAME: TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH ±	MATERIAL:	PRODUCT SPEC: APPLICATION SPEC: WEIGHT:	SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2151966	RESTRICTED TO:
CUSTOMER ACCESSIBLE PRODUCTION DRAWING		SCALE: 1:2	SHEET: 2 of 4	REV: E1

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2151966-1	E	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2151966-2	E	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151966-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
 INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.17 mm [.046]	F
INSUL	1.57 mm [.062]	F
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: 025 TH CONTACT			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
3.00-3.50 mm [.118-.138 IN]		Ø0.90-1.20 mm [.035-.047 IN]	
TERMINAL APPLICATION SPECIFICATION	(A)114-61030 (B)114-61031	-	-
TERMINALS APPLIED ⁴			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
(A) 2005097-1	(B) 2005098-1		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: 025 TH CONTACT			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
3.00-3.50 mm [.118-.138 IN]		Ø0.95-1.05 mm [.037-.041 IN]	
TERMINAL APPLICATION SPECIFICATION	114-15120-1 ⁴	-	-
TERMINALS APPLIED ⁵			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
2005097-1	2005098-1		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.22mm ²	0.82+/-0.03 [.032+/-0.001]	8.8
0.13mm ²	0.764+/-0.02 [.030+/-0.0008]	9.4

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.13mm ²	0.764+/-0.020 [.0300+/-0.0008]	9.4

- 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.
- APPLICATION SPECIFICATION 114-15120-1 IS RESTRICTED TO PEUGEOT CITROËN AND ITS HARNESS MAKERS.

***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			
P	LTN	DESCRIPTION	DATE	OWN	APVD
A	66	SEE SHEET 1	-	-	-

-	1	1	2119082-5	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	1338685-1	PAWL, FEED	56
-	2	2	2-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 14	53
-	1	1	1803382-6	HOLD DOWN, SPRING LOADED	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	1752356-6	SUPPORT, TERMINAL	34
-	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	2-2844962-4	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	1803095-6	FLOATING SHEAR, FRONT	9
-	1	1	2-1633928-4	ANVIL, COMBINATION	8
-	1	1	6-240641-9	SPACER	7
-	-	-	-	-	6
-	1	1	2119757-4	DEPRESSOR, SHEAR	5
-	1	1	2-238011-2	BLOCK, CRIMPER SPACER	4
-	1	1	6-2119582-4	CRIMPER, INSULATION F PREMIUM	3
-	1	1	455888-3	SPACER, CRIMPER	2
-	1	1	5-568176-2	CRIMPER, WIRE	1

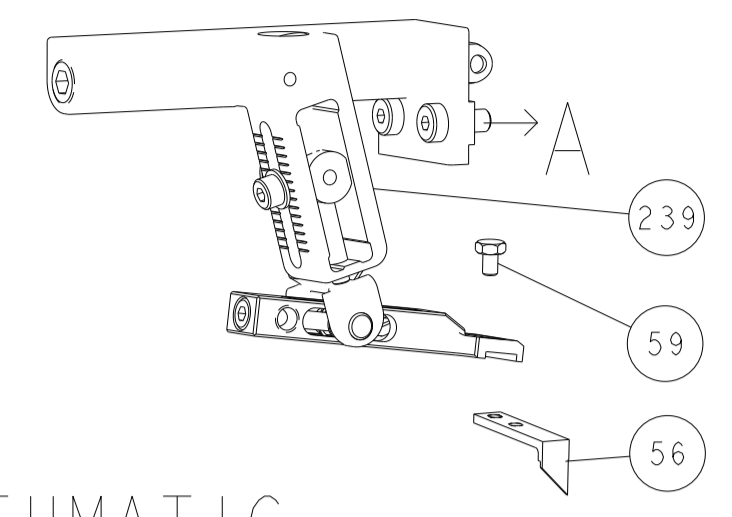
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		MATERIAL:	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±
	ANGLES ±	FINISH			

OWN	CHK	APVD	DATE	NAME	SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
Y. YIN	G. BAILEY	U. GUO	29MAY2013	G. BAILEY	A1	00779	2151966	

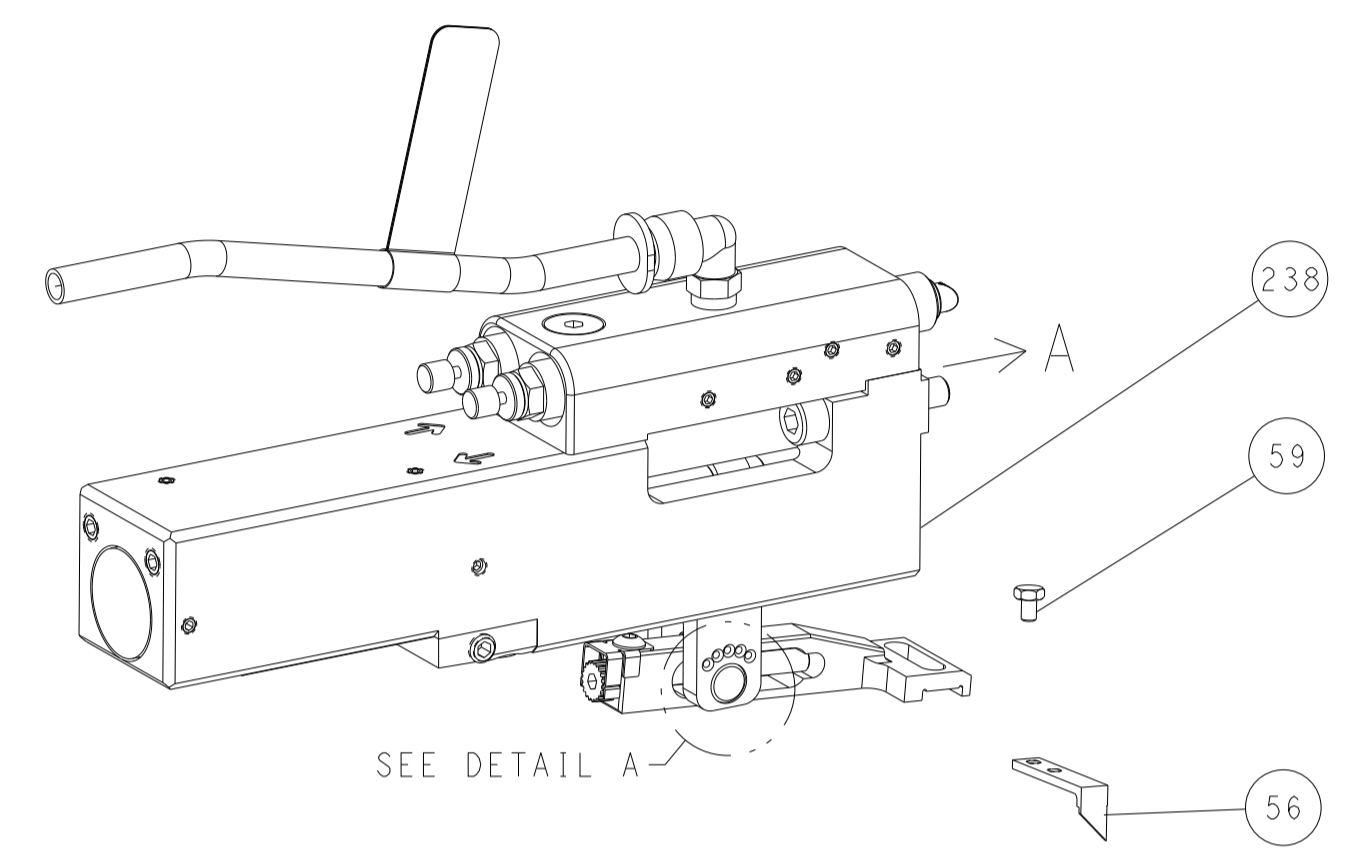
CUSTOMER ACCESSIBLE PRODUCTION DRAWING SCALE 1:2 SHEET 3 OF 4 REV E1

LOC	DIST	REVISIONS			
		REV	DATE	BY	APPV
A	66	1	SEE SHEET 1		

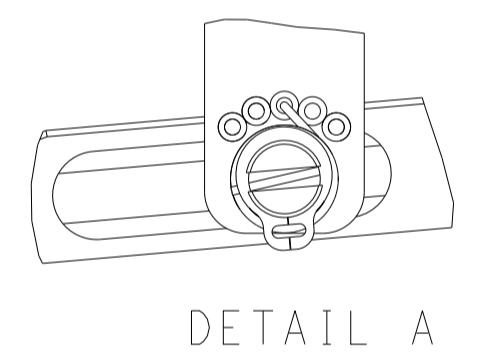
FEED TYPE MECHANICAL



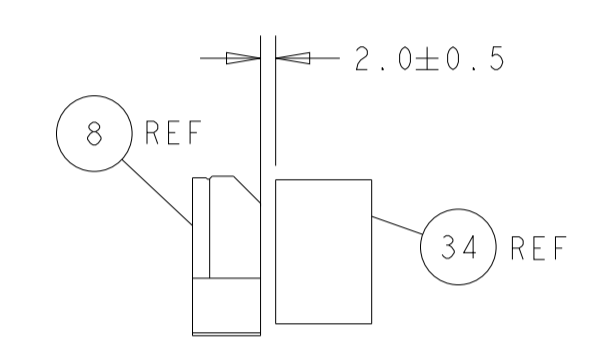
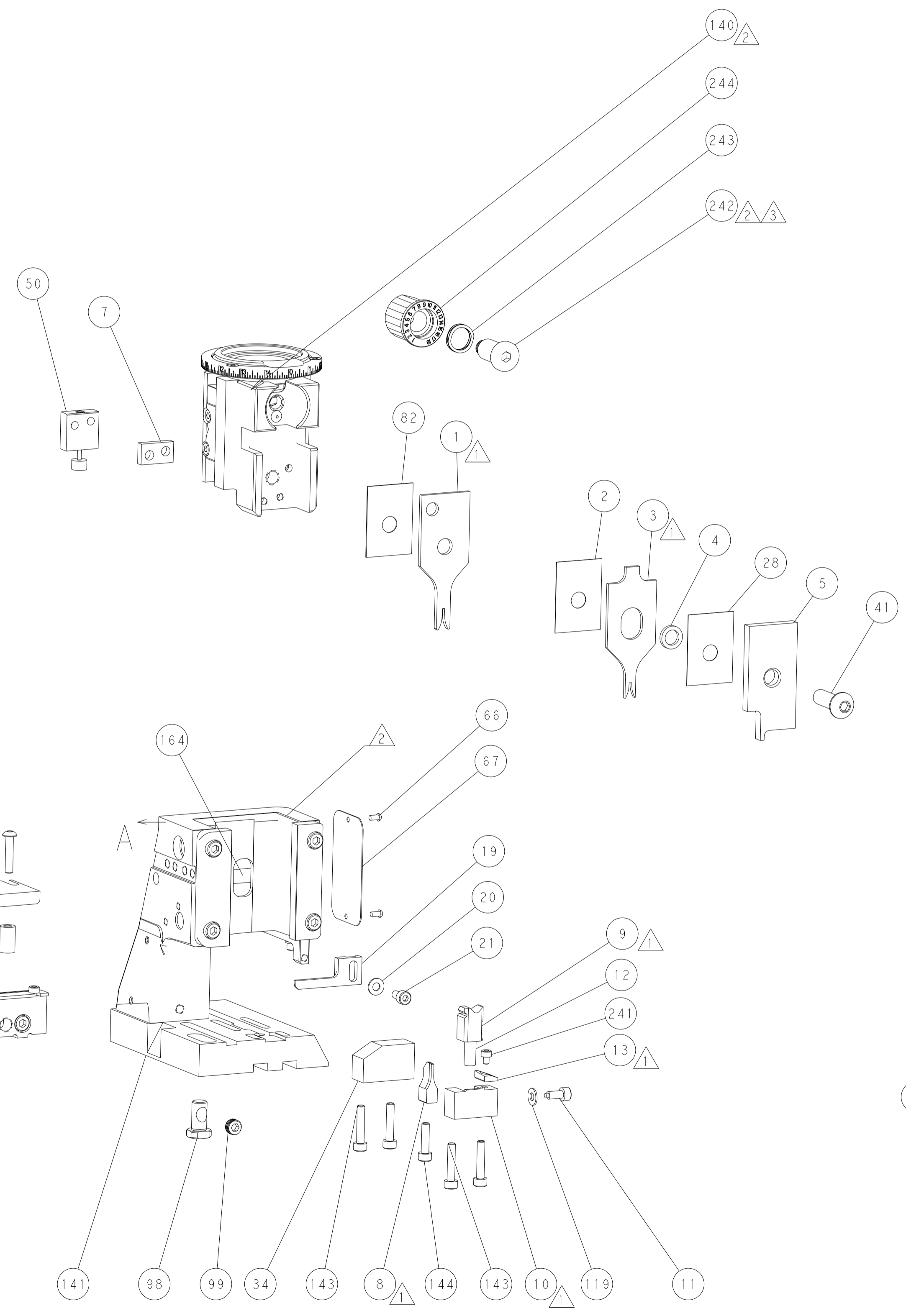
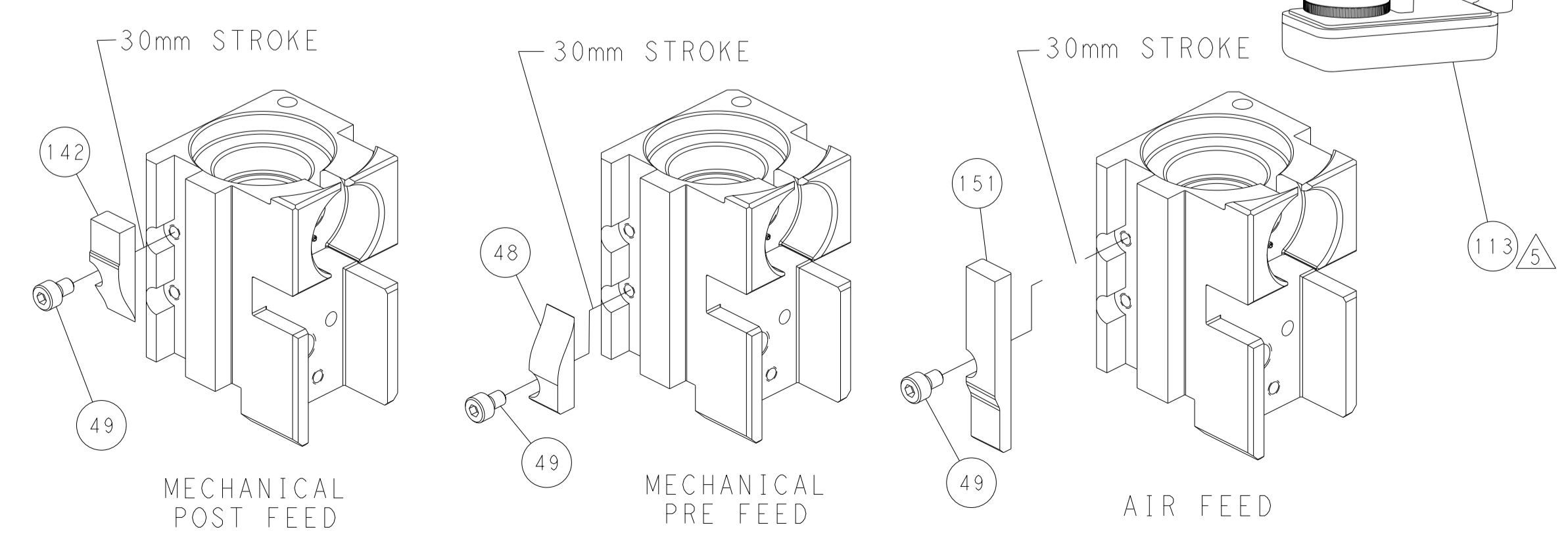
PNEUMATIC



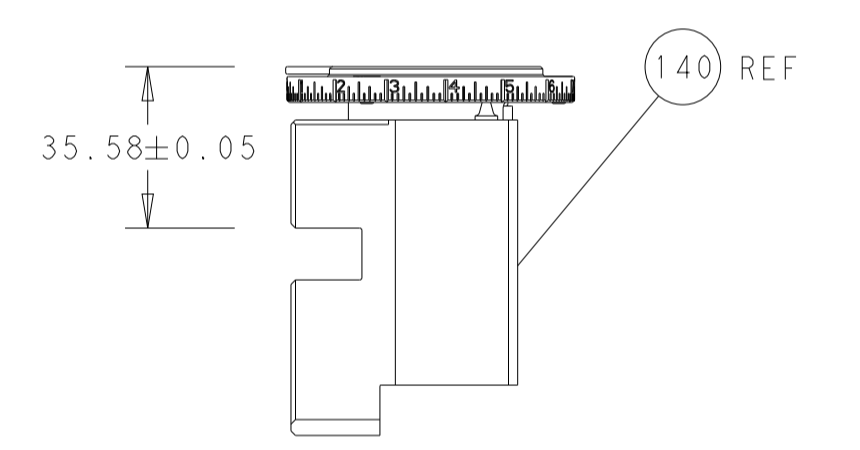
FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



CAM POSITIONS

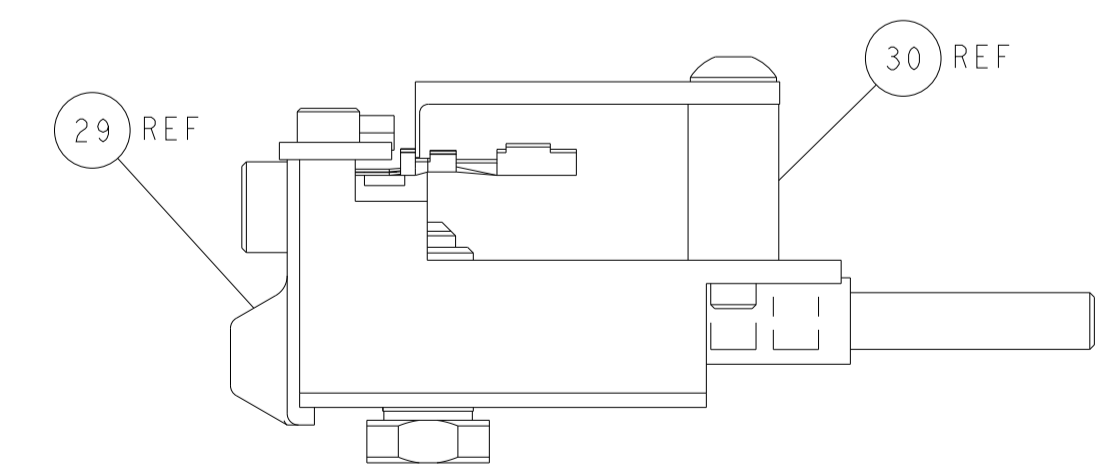


TERMINAL SUPPORT LOCATION



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: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH ±		DWG Y. YIN 29MAY2013 CHK G. BAILEY 29MAY2013 APVD U. GUO 29MAY2013 NAME Ocean Side Feed Applicator SIZE CAGE CODE DRAWING NO. RESTRICTED TO A1 00779 C-2151966 CUSTOMER ACCESSIBLE PRODUCTION DRAWING SCALE 1:2 SHEET 4 OF 4 REV E1	
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