

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	RR

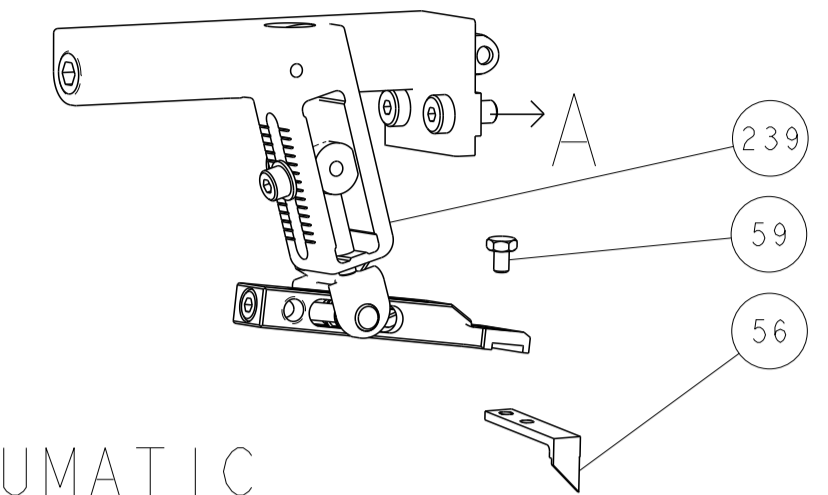
	-	1	1	1	1	2280441-1	INSERT, SHEAR	282
	-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248
	-	1	1	1	1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244
	-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
	-	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
	-	2	2	2	2	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
	-	-	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

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

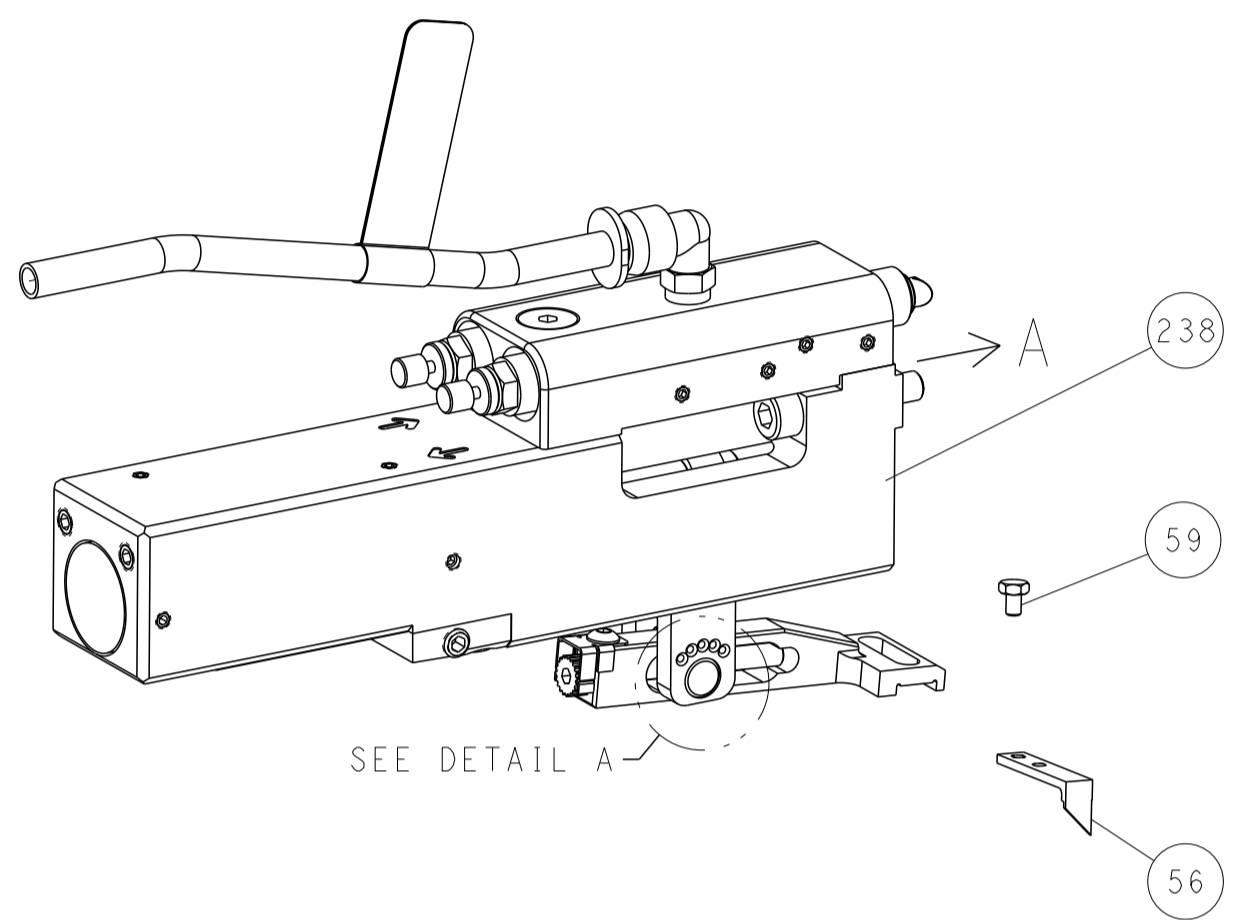
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CHK	T. ELBIN	23NOV2011
APVD	T. ELBIN	23NOV2011
PRODUCT SPEC		
APPLICATION SPEC		
WEIGHT		
SCALE	1:2	SHEET 1 OF 4
REV	L	

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

FEED TYPE MECHANICAL



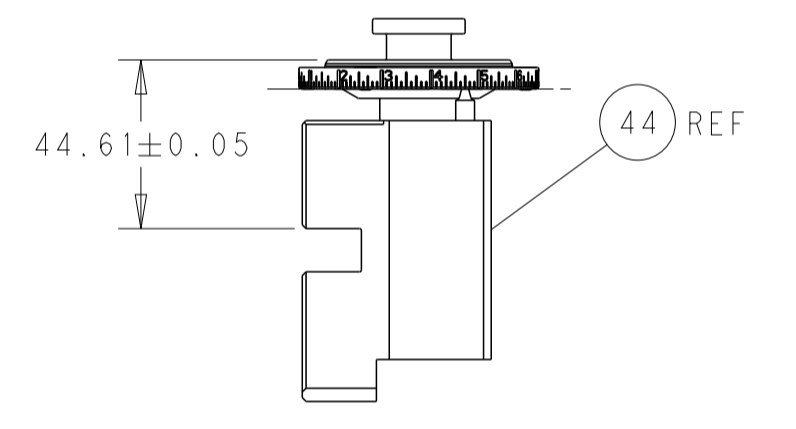
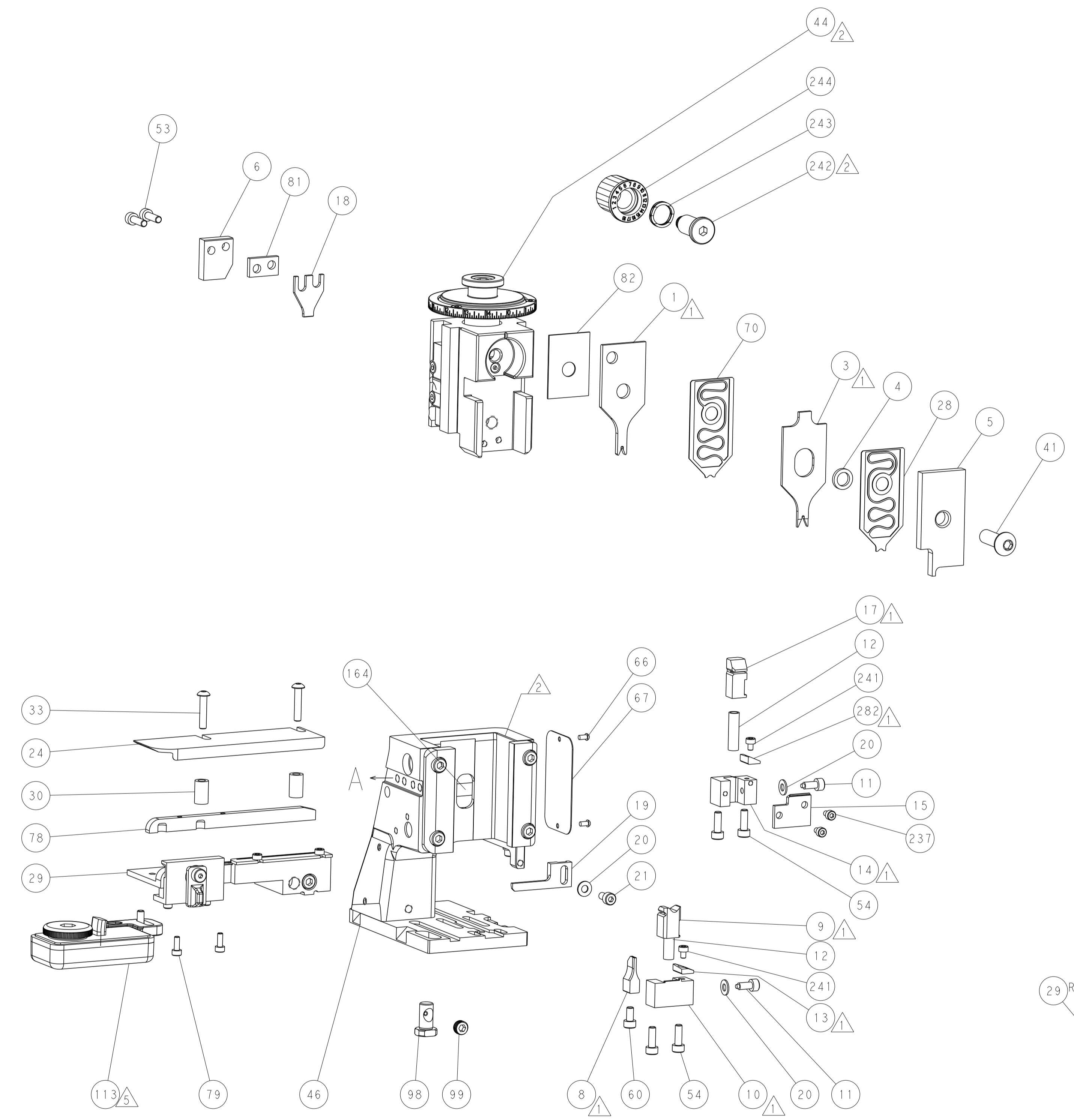
PNEUMATIC



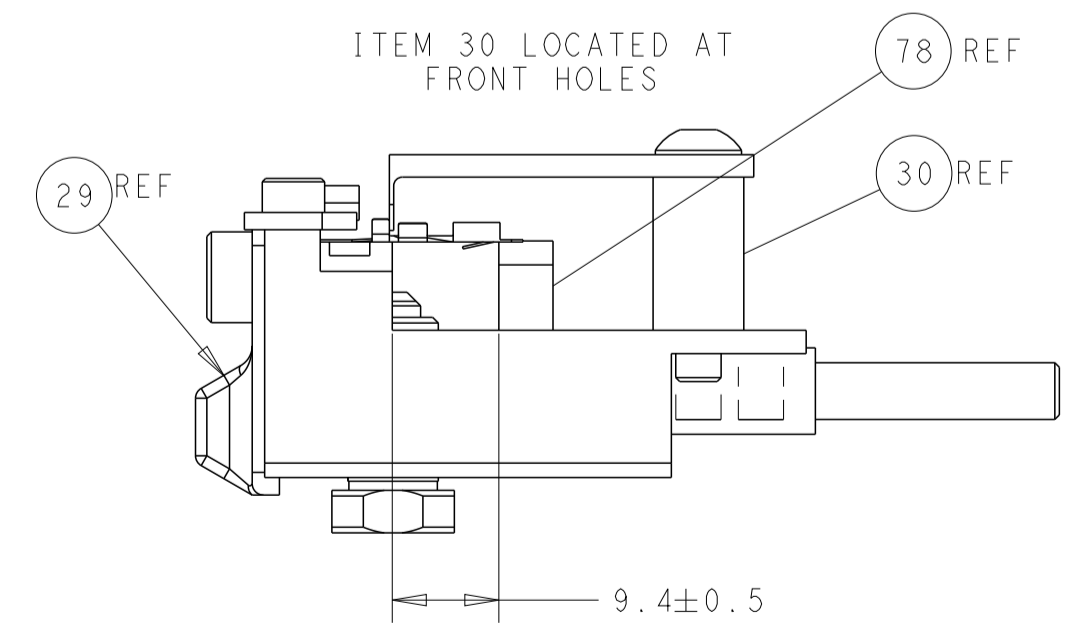
FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



DETAIL A

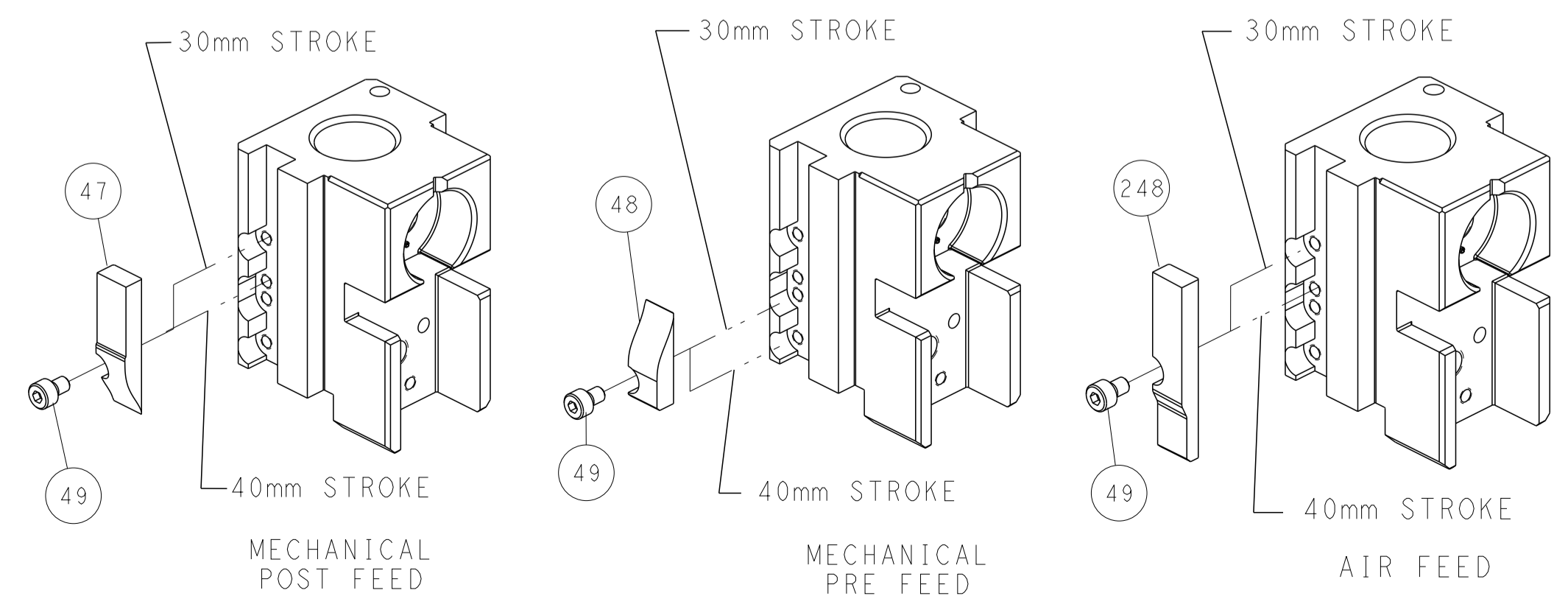


RAM SET-UP



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)

DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ° ± FINISH		DWN C. MOYER 23NOV2011 CHK T. ELBIN 23NOV2011 APVD T. ELBIN 23NOV2011 PRODUCT SPEC APPLICATION SPEC WEIGHT Customer Accessible Production Drawing		NAME Ocean Side Feed Applicator SIZE CAGE CODE DRAWING NO. RESTRICTED TO A1 00779 C=2151307 SCALE 1:2 SHEET 2 OF 4 REV L	
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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	INSULATION DIAMETER RANGE
2.77-4.37 mm [1.09-.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+/-0.002]	10.0
24 AWG	0.79+/-0.05 [.031+/-0.002]	11.2
26 AWG	0.76+/-0.05 [.030+/-0.002]	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)

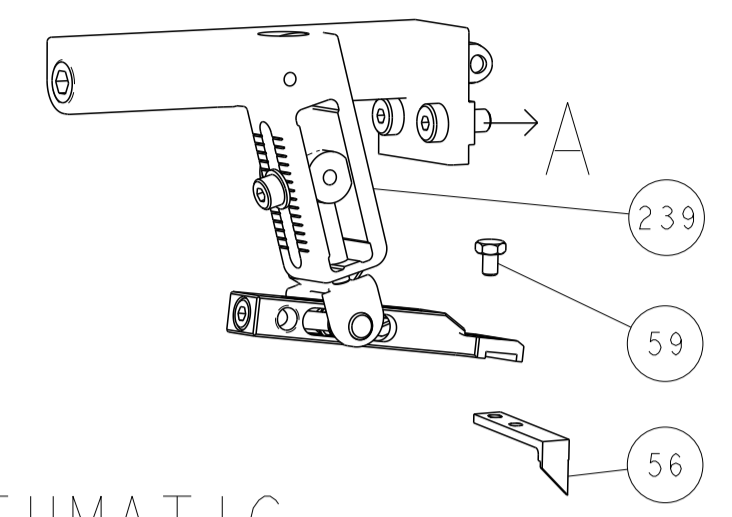
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A	66					

REVISIONS						
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△	- 1 1	2280441-1				282
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-	- 1 1	2079764-1				243
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-	- 2 2	7-18023-7				241
-	- 1 1	2119580-1				239
-	- 1 -	2844940-1				238
-	- 2 2	18023-1				237
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-	- 1 1	455888-7				82
-	- 1 1	240641-7				81
-	- 2 2	2168083-1				79
-	- 1 1	1901085-4				78
-	- 1 1	1803607-3				71
-	- 1 1	2119791-9				70
-	- 1 1	2119740-1				67
-	- 2 2	2168078-1				66
-	- 1 1	5-18022-5				59
-	- 1 1	1338685-1				56
-	- 2 2	2-2168083-5				53
-	- 1 2	18023-9				49
-	- 1 1	2119652-1				48
-	- 1 1	1803602-1				41
-	- 2 2	2079383-5				33
-	- 2 2	2-2844962-3				30
-	- 1 1	2844992-1				29
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-	- 1 1	1320928-2				24
-	- 1 1	2168083-2				21
-	- 3 3	1-18028-2				20
-	- 1 1	2119533-1				19
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-	- 1 1	2119757-6				5
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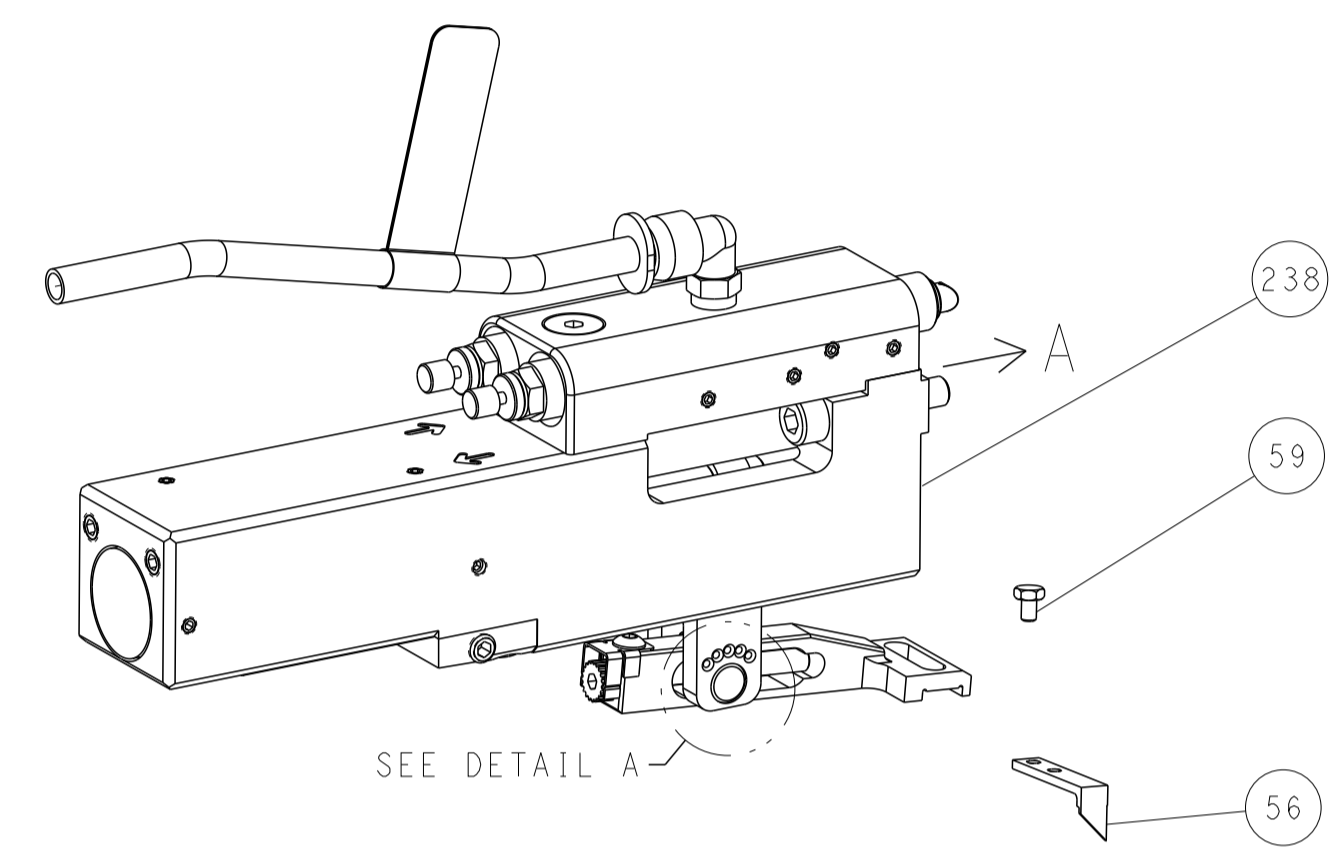
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0 PLC	±	1 PLC	±	SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO				
2 PLC	±	3 PLC	±	APPLICATOR SPEC							
4 PLC	±	5 PLC	±	WEIGHT							
ANGLES	±										
FINISH											
MATERIAL				SCALE		SHEET		OF		REV	
				1:2		3		4		L	

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

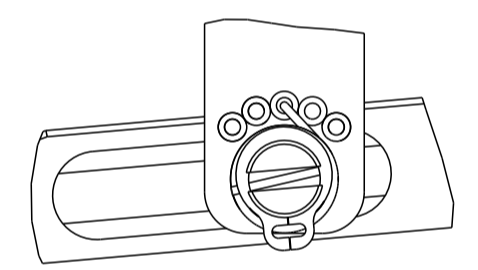
FEED TYPE MECHANICAL



PNEUMATIC

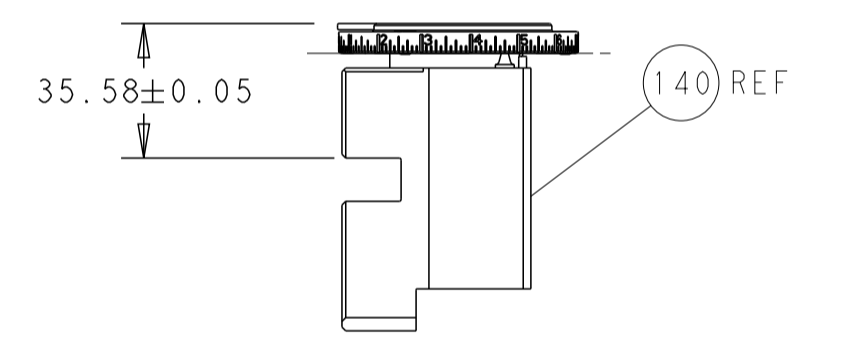
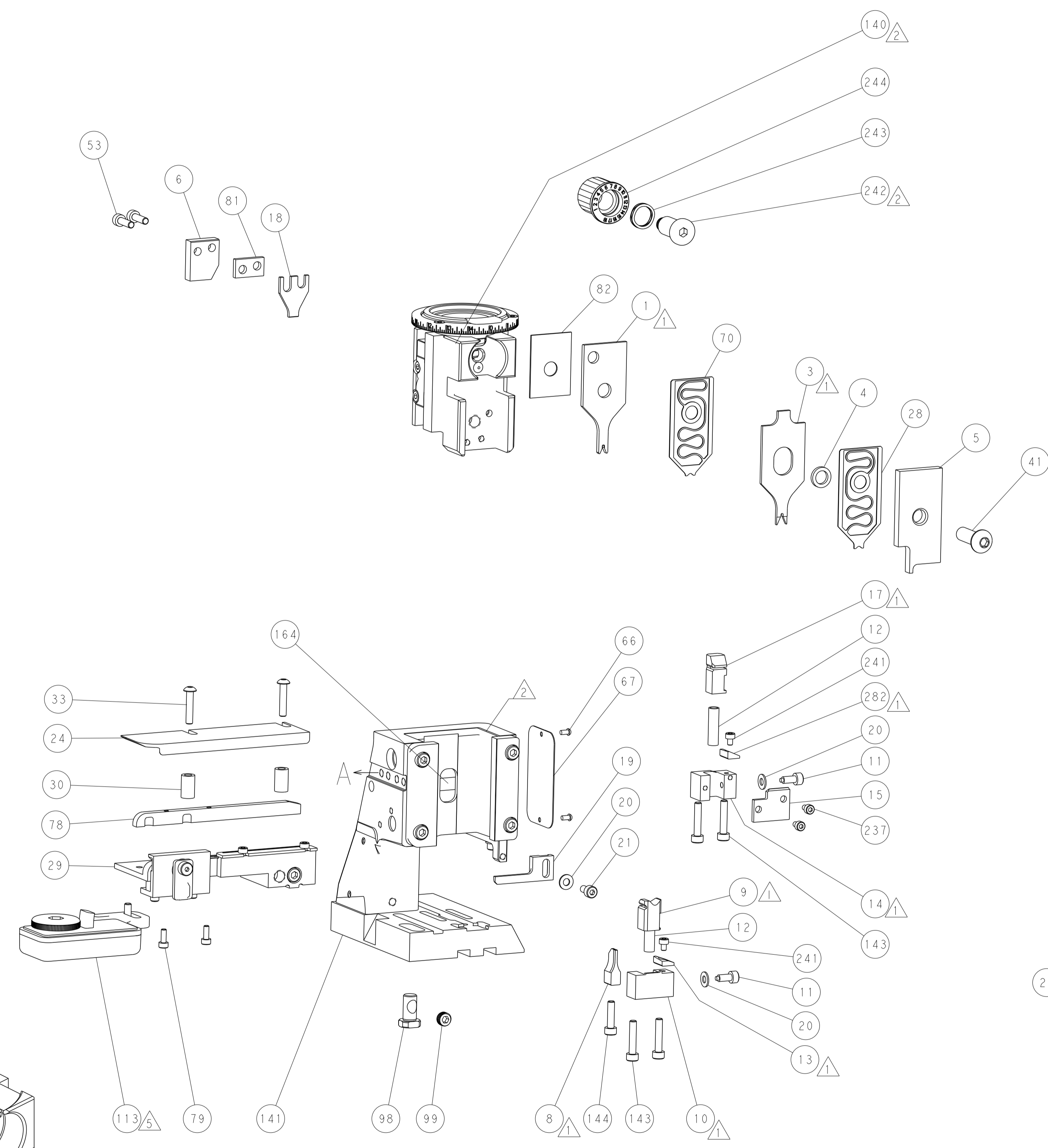
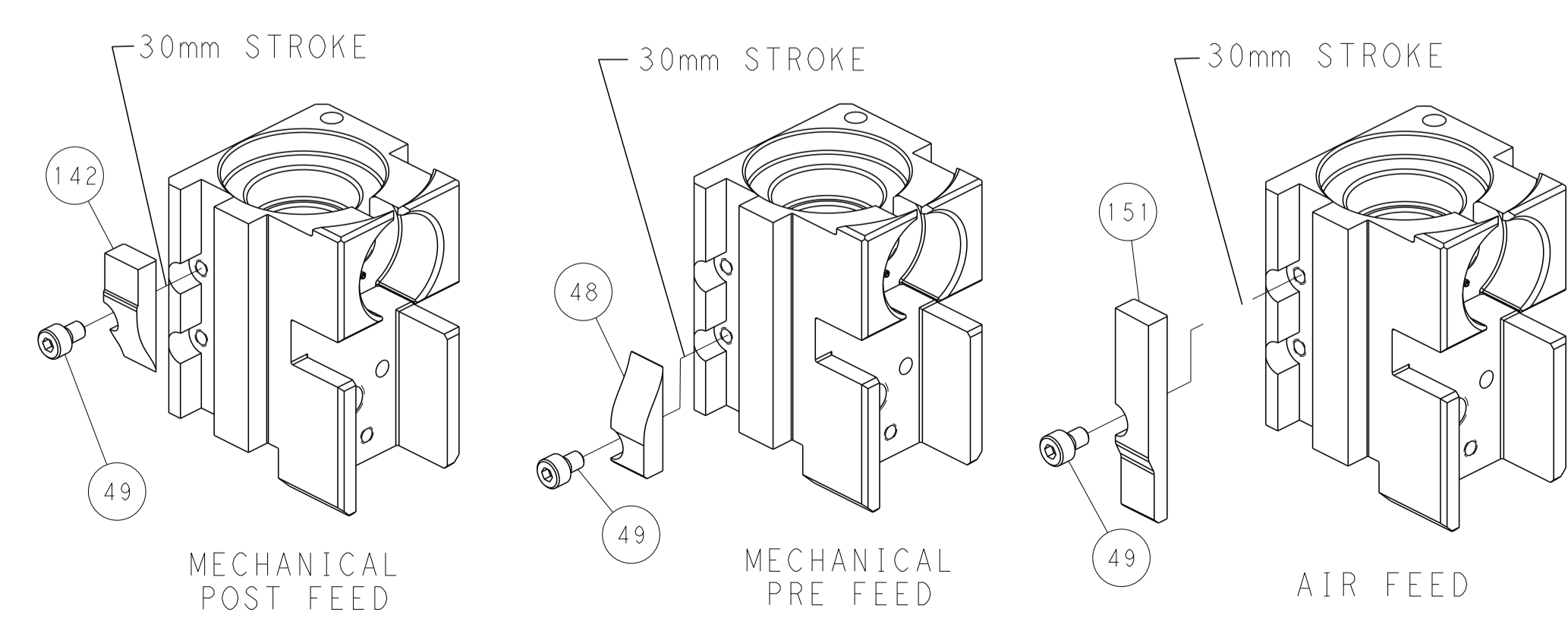


FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)

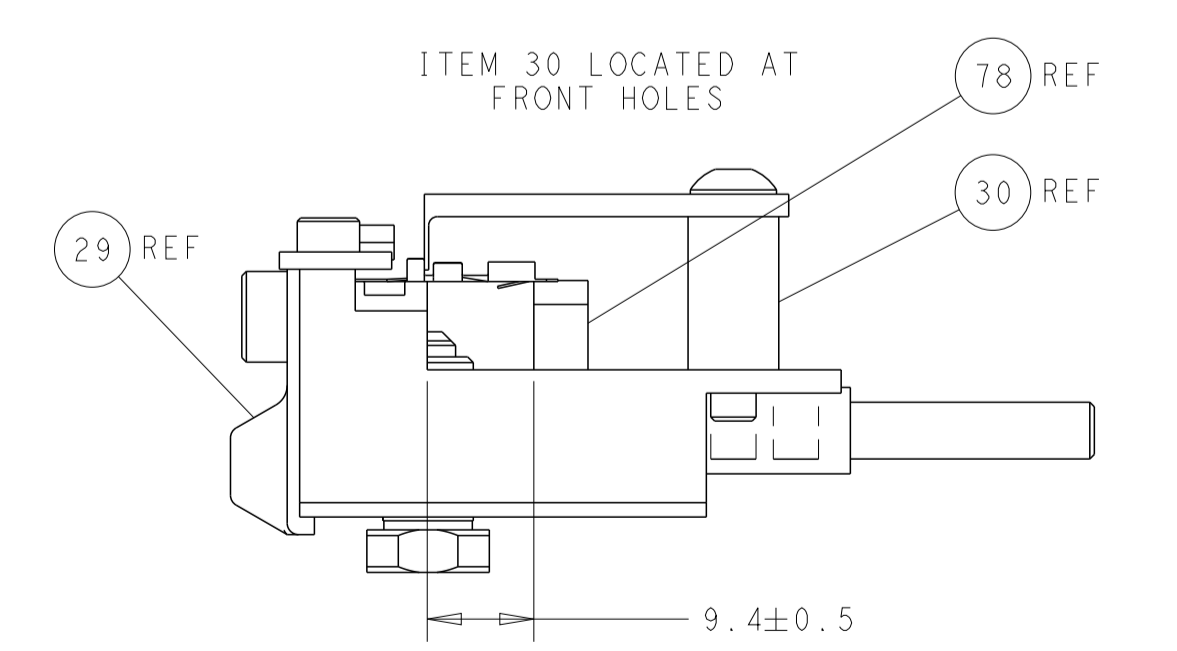


DETAIL A

CAM POSITIONS



RAM SET-UP



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)

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DIMENSIONS: mm 	TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH	PRODUCT SPEC APPLICATION SPEC WEIGHT SCALE 1:2	SIZE CAGE CODE DRAWING NO A1 00779 C=2151307 RESTRICTED TO SHEET 4 OF 4 REV L