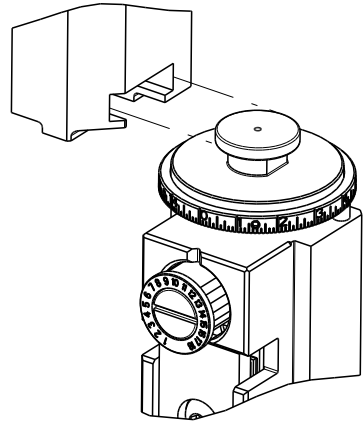


8		7	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151078-1	H	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2151078-2	H	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151078-1	H	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2151078-2	H	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2151078-7	G	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.16 mm [.046]	F
INSUL	1.78 mm [.070]	F
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: 2.5MM PITCH SIGNAL MATE CONN			
WIRE STRIP LENGTH 1.60-2.10 mm [.063-.083 IN]		INSULATION DIAMETER RANGE Ø1.20-1.90 mm [.047-.075 IN]	
TERMINAL APPLICATION SPECIFICATION		(A)114-5286	
		(B)114-5451	
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
(A) 1376476-1	(B) 2069337-1	(A) 2318468-1	(A) 2318468-2

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
22 AWG	0.82+/-0.05 [.032+/- .002]	8.3
24 AWG	0.75+/-0.05 [.030+/- .002]	8.9
26 AWG	0.69+/-0.05 [.027+/- .002]	9.6



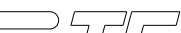
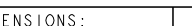
- 1 RECOMMENDED SPARE PARTS
- 2 REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- 3 APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242. APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 50.
- 4 CRIMP HEIGHT REFERENCE SETTING WAS THE SETTING USED WHEN THE APPLICATOR WAS QUALIFIED AT THE FACTORY. ADJUSTMENT MAY BE NECESSARY WHEN RUNNING APPLICATOR IN THE FIELD.
5. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- 6 TERMINAL LUBRICANT IS RECOMMENDED.

*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)

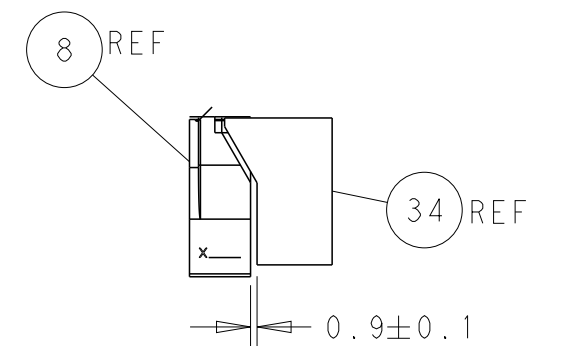
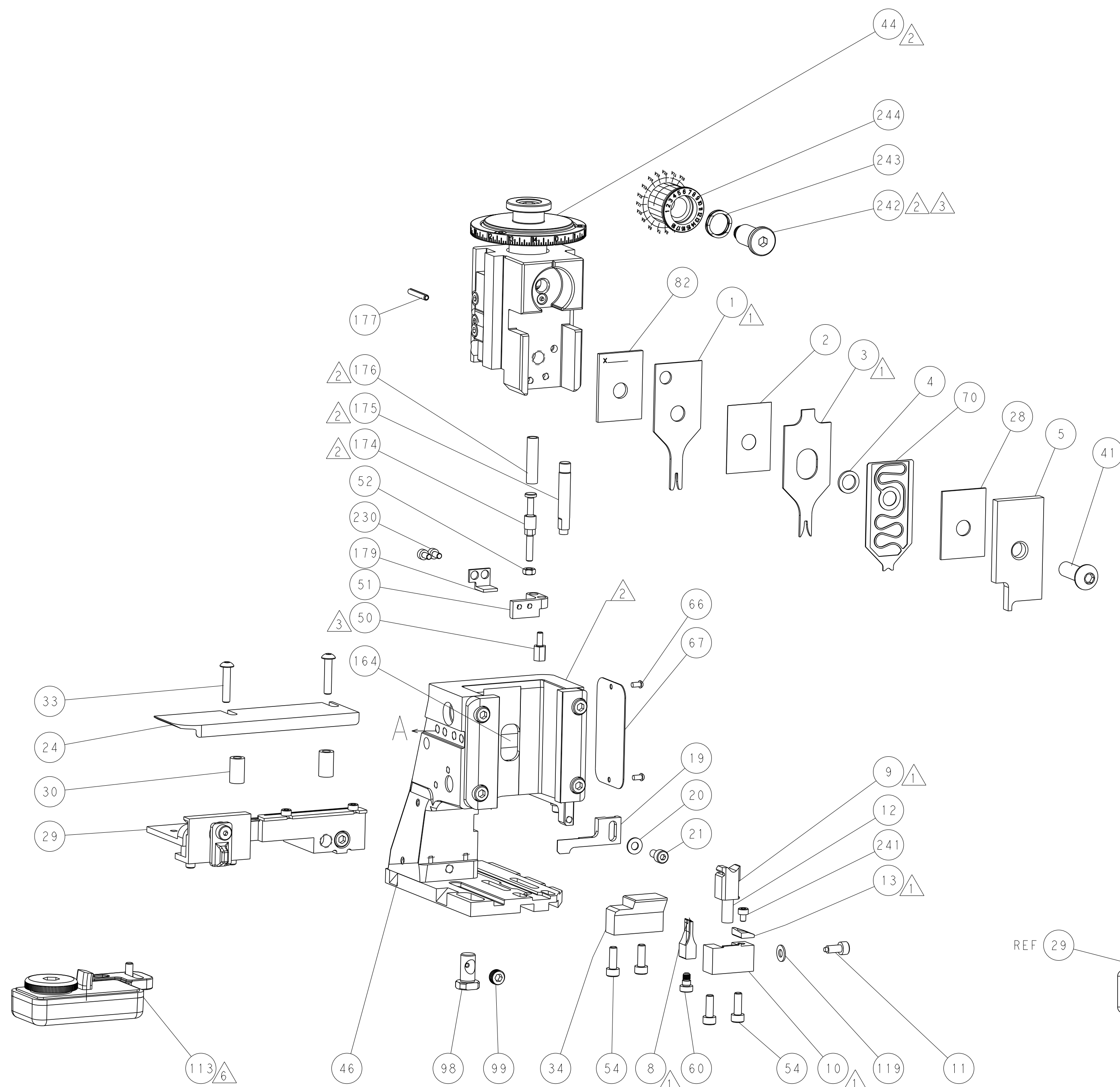
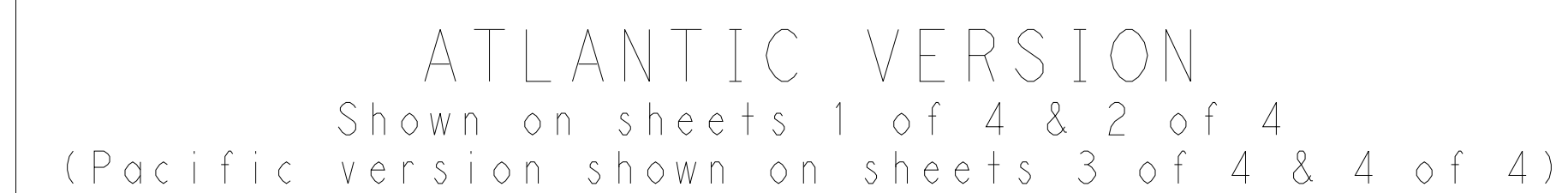
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		P	LTR	DESCRIPTION	DATE	DWN
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		F		ECR-20-016349	18NOV2020	JWC
		G		ECR-21-115008	27SEP2021	FZ
		H		ECR-22-137858	04MAY2022	JWC

-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248
-	1	1	1	1	2119082-4	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
-	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
-	2	2	2	2	1-2168083-1	SCR, SKT HD CAP, RoHS, M3 X 6	230
-	1	1	1	1	3-1633764-0	HOLD DOWN, TERMINAL	179
-	1	1	1	1	9931111-1	PIN, SLOTTED SPRING 3.0 X 20.0	177
-	1	1	1	1	8-22280-7	SPRING, COMPRESSION	176
-	1	1	1	1	1752353-2	GUIDE PIN,HOLDDOWN	175
-	1	1	1	1	1901680-2	GUIDE PIN,HOLDDOWN	174
-	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	1	1	1	1	1-18028-2	WASHER, FLAT, REG M4	119
-	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	1-455888-8	SPACER, CRIMPER	82
-	1	1	1	1	1803607-3	DOCUMENTATION PACKAGE	71
-	1	1	1	1	2119791-5	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	2161425-4	SCREW, SHOULDER	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
-	1	1	1	1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52
-	1	1	1	1	3-1901681-6	HOLDDOWN, TERMINAL	51
-	1	1	1	1	1-1752354-6	STANDOFF,HOLD-DOWN	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	2-1803583-5	APPLICATOR BASIC ASSEMBLY, SF	46
-	1	1	1	1	1803515-3	RAM ASSEMBLY, SF ATLANTIC	44
-	1	1	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
-	1	1	1	1	2-1752356-6	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	1-455888-0	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	2119533-4	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	1803095-3	FLOATING SHEAR, FRONT	9
-	1	2	2	1	9-1333225-7	ANVIL, COMBINATION	8
-	1	1	1	1	2119757-4	DEPRESSOR, SHEAR	5
-	1	1	1	1	2-238011-0	BLOCK, CRIMPER SPACER	4
-	1	2	2	1	1-2119582-2	CRIMPER, INSULATION F PREMIUM	3
-	1	1	1	1	455888-1	SPACER, CRIMPER	2
-	1	2	2	1	9-1803556-0	CRIMPER, WIRE F	1
-77-72-71	-2	-1			PART NO	DESCRIPTION	ITEM NO

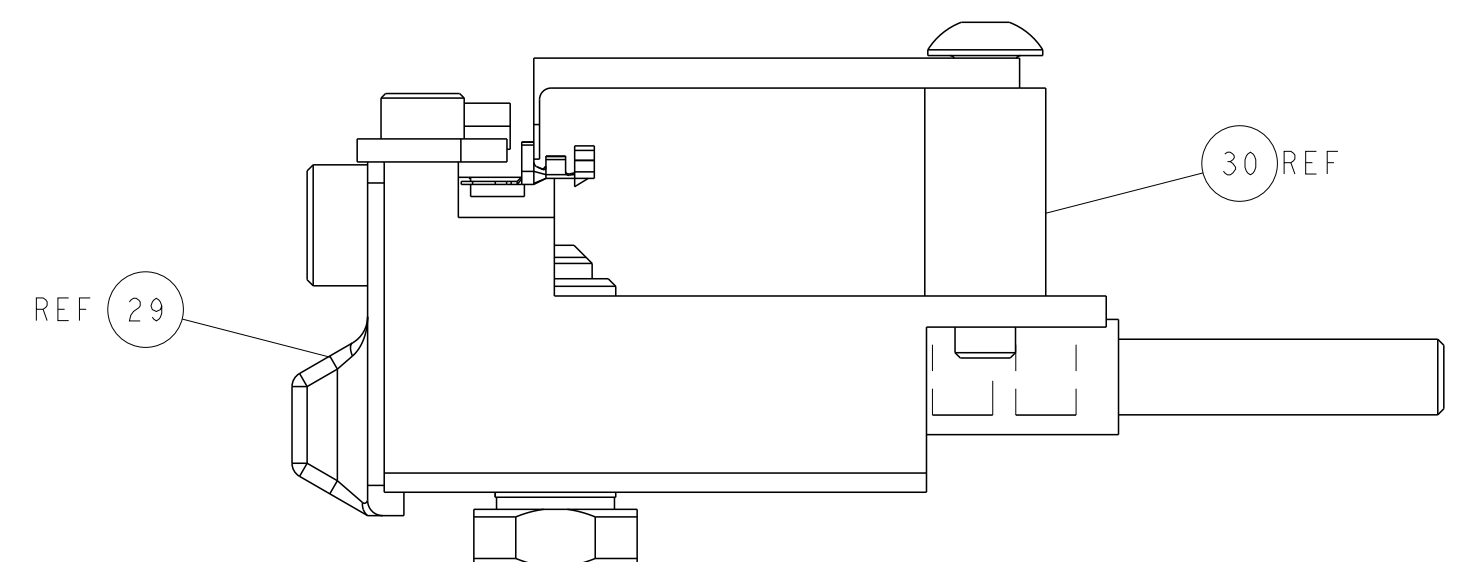
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CHK G. BAILEY		29AUG2011	NAME					
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		OCEAN SIDE FEED APPLICATOR				
		0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		- - - - - -				
MATERIAL		FINISH		SIZE CAGE CODE DRAWING NO RESTRICTED TO				
-		-		A1 00779 ©=2151078 -				
Customer Accessible Production Drawing				SCALE 1:2		SHEET 1 OF 4		REV H

SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

CAM POSITIONS



ITEM 30 LOCATED AT
FRONT HOLES

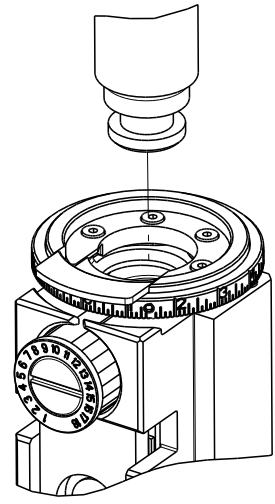


FEED TRACK POSITION
GUIDE BY INSULATION BARREL

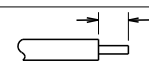
THIS DRAWING IS A CONTROLLED DOCUMENT FOR THE UNITED STATES GOVERNMENT IT IS SUBJECT TO THE PROVISIONS OF EXECUTIVE ORDER 12812 WHICH ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST REVISION		DWN 29AUG2011 Y.YIN CRK 29AUG2011 G.BAILEY APVD 29AUG2011 S.XI		 TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.1 1 PLC ±.1 2 PLC ±.1 3 PLC ±.1 4 ANGLES ±.1		NAME OCEAN SIDE FEED APPLICATOR	
		PRODUCT SPEC - APPLICATION SPEC -		SIZE A1	
MATERIAL -		FINISH -		CAGE CODE 00779	
WEIGHT -		DRAWING NO C=2151078		RESTRICTED TO -	
Customer Accessible Production Drawing				SCALE 1:2 SHEET 2 of 4 REV H	

8		7	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2151078-1	H	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2151078-2	H	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151078-7	G	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.16 mm [.046]	F
INSUL	1.78 mm [.070]	F
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: 2.5MM PITCH SIGNAL MATE CONN			
WIRE STRIP LENGTH 1.60-2.10 mm [.063-.083 IN]			INSULATION DIAMETER RANGE Ø1.20-1.90 mm [.047-.075 IN]
TERMINAL APPLICATION SPECIFICATION	(A)114-5286	-	-
	(B)114-5451	-	-
TERMINALS APPLIED 			
TE TERMINAL (A) 1376476-1	TE TERMINAL (B) 2069337-1	TE TERMINAL (A) 2318468-1	TE TERMINAL (A) 2318468-2

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING 
22 AWG		0.82+/-0.05 [.032+/-0.002]		8.3
24 AWG		0.75+/-0.05 [.030+/-0.002]		8.9
26 AWG		0.69+/-0.05 [.027+/-0.002]		9.6



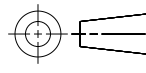
-  RECOMMENDED SPARE PARTS
-  REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
-  APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242.
APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 50.
-  CRIMP HEIGHT REFERENCE SETTING WAS THE SETTING USED WHEN THE APPLICATOR WAS QUALIFIED AT THE FACTORY. ADJUSTMENT MAY BE NECESSARY WHEN RUNNING APPLICATOR IN THE FIELD.
5. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
-  TERMINAL LUBRICANT IS RECOMMENDED.

*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)

2		1					
LOC	DIST	REVISIONS					
A	66	P	LTR	DESCRIPTION	DATE	OWN	APVD
		-		SEE SHEET 1	-	-	-

-	1	1	2119082-4	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
-	2	2	1-2168083-1	SCR, SKT HD CAP, RoHS, M3 X 6	230
-	1	1	3-1633764-0	HOLD DOWN, TERMINAL	179
-	1	1	993111-1	PIN, SLOTTED SPRING 3.0 X 20.0	177
-	1	1	8-22280-7	SPRING, COMPRESSION	176
-	1	1	1752353-2	GUIDE PIN,HOLDDOWN	175
-	1	1	1901680-2	GUIDE PIN,HOLDDOWN	174
-	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	1	-	2119641-2	FEED CAM, AIR FEED	151
-	1	1	2161425-4	SCREW, SHOULDER	144
-	2	2	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	143
-	-	1	2119653-2	FEED CAM, POST FEED	142
-	1	1	3-1803583-0	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	1-455888-8	SPACER, CRIMPER	82
-	1	1	1803607-3	DOCUMENTATION PACKAGE	71
-	1	1	2119791-5	DEPRESSOR, WIRE	70
-	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	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	54
-	1	1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52
-	1	1	3-1901681-6	HOLDDOWN, TERMINAL	51
-	1	1	1-1752354-6	STANDOFF,HOLD-DOWN	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	2-1752356-6	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	1-455888-0	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	2119533-4	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	1803095-3	FLOATING SHEAR, FRONT	9
-	1	1	9-1333225-7	ANVIL, COMBINATION	8
-	1	1	2119757-4	DEPRESSOR, SHEAR	5
-	1	1	2-238011-0	BLOCK, CRIMPER SPACER	4
-	1	1	1-2119582-2	CRIMPER, INSULATION F PREMIUM	3
-	1	1	455888-1	SPACER, CRIMPER	2
-	1	1	9-1803556-0	CRIMPER, WIRE F	1

-77	-22	-21	PART NO	DESCRIPTION	ITEM NO
OWN Y. YIN CHK G. BAILEY APVD S. XI			29AUG2011 29AUG2011 29AUG2011	TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm			PRODUCT SPEC	NAME OCEAN SIDE FEED APPLICATOR	
			APPLICATION SPEC	SIZE 00779	
MATERIAL -			WEIGHT -	DRAWING NO C=2151078	
TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH -			Customer Accessible Production Drawing	SCALE 1:2	SHEET 3 OF 4

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

D

C

B

A

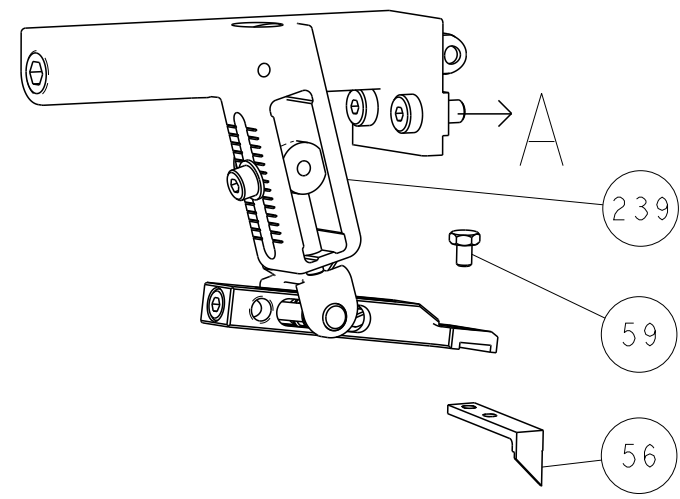
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C

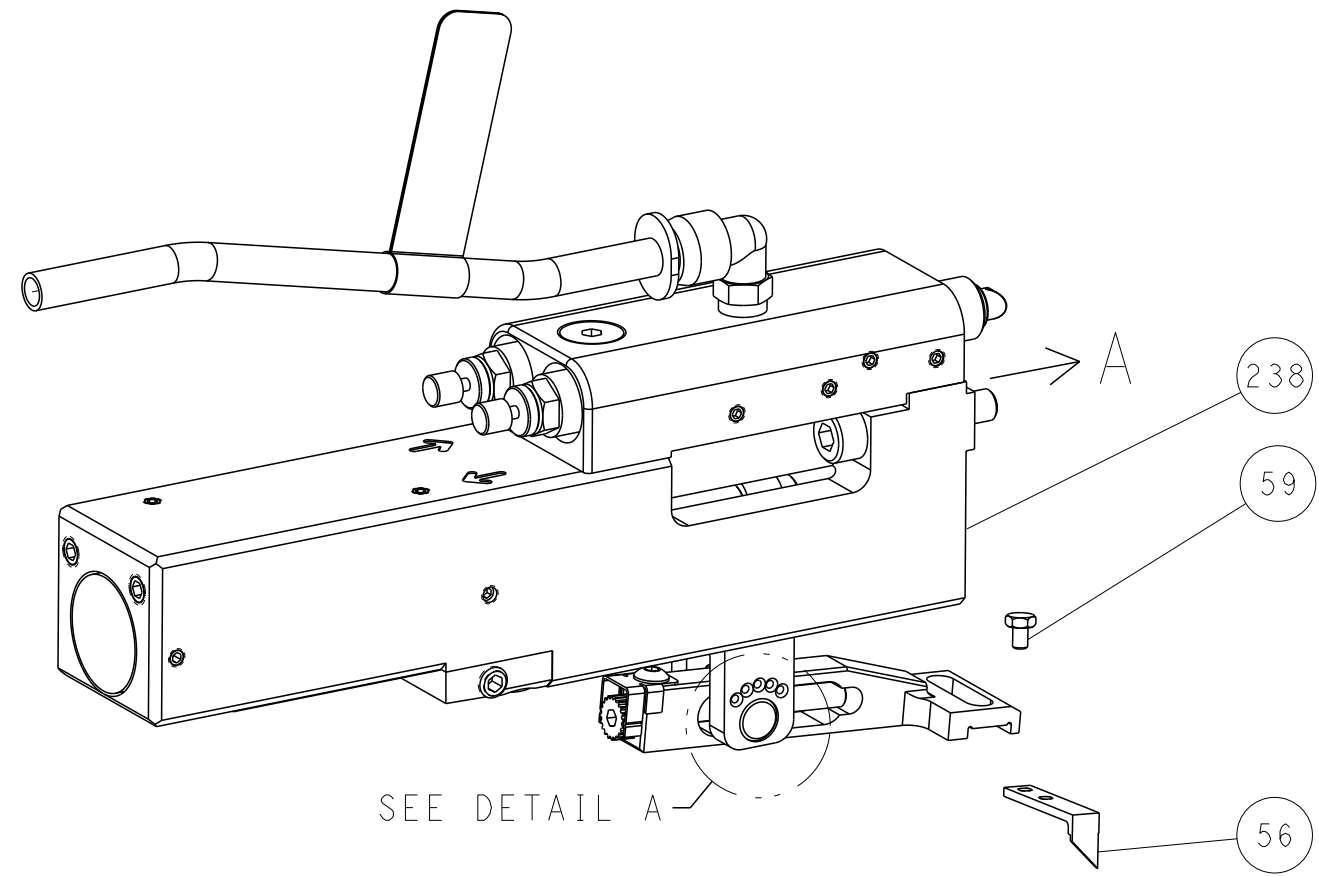
B

A

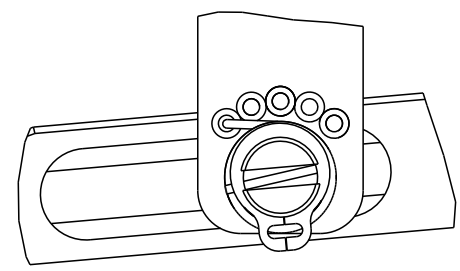
FEED TYPE MECHANICAL



PNEUMATIC

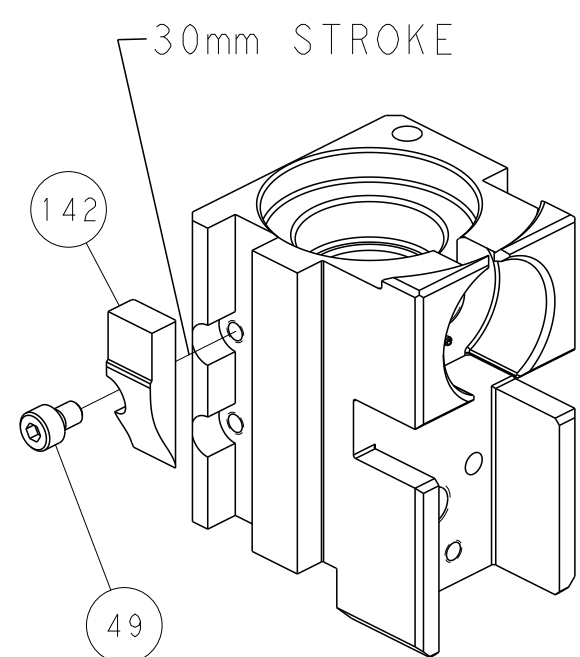


FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)

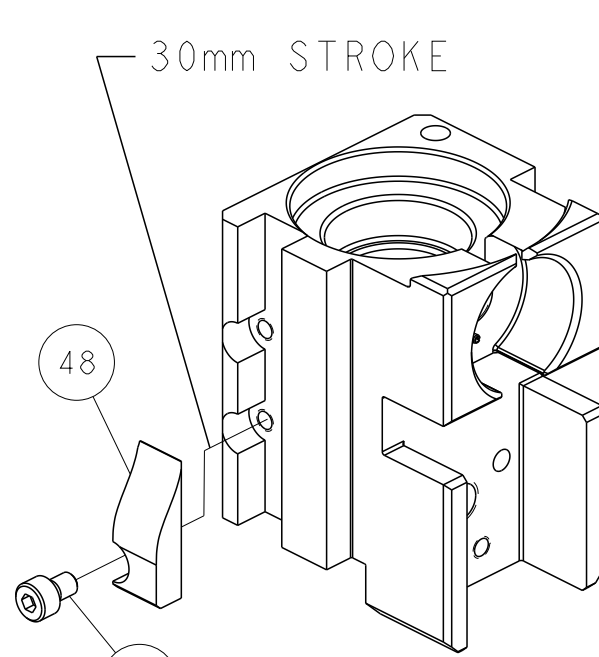


DETAIL A

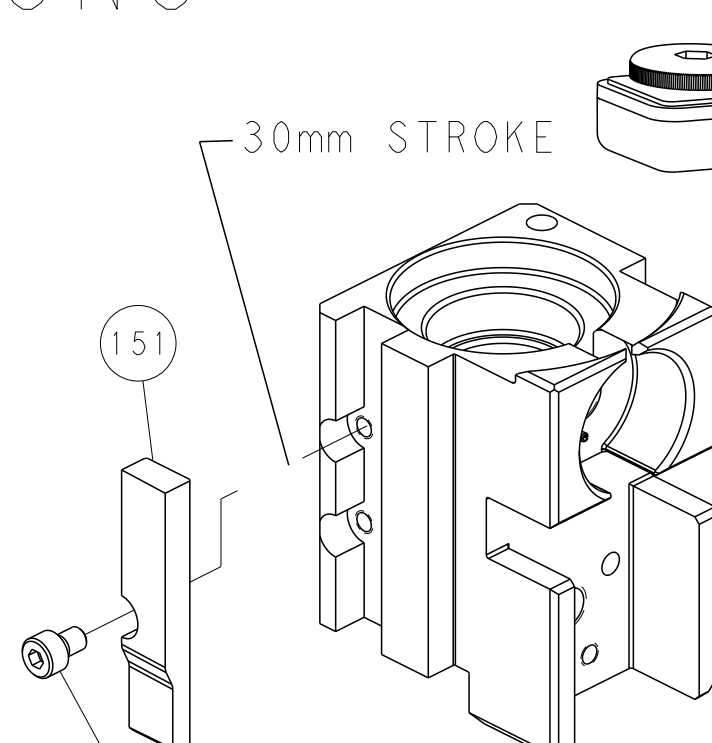
CAM POSITIONS



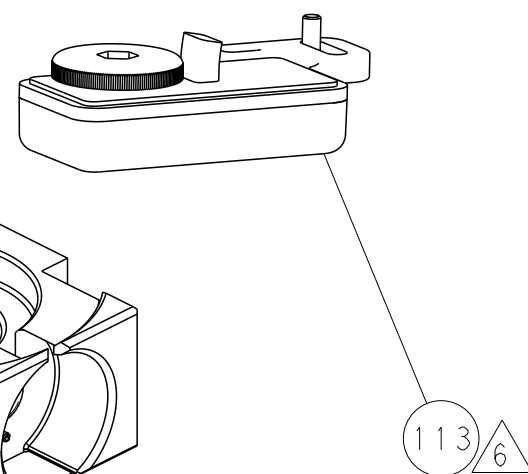
MECHANICAL
POST FEED



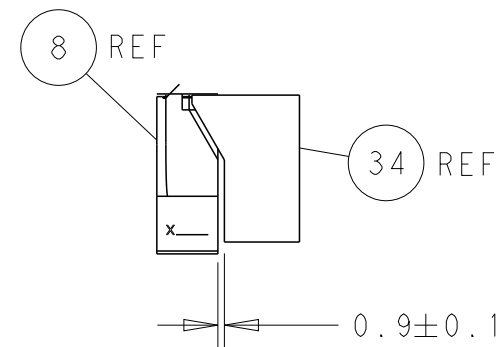
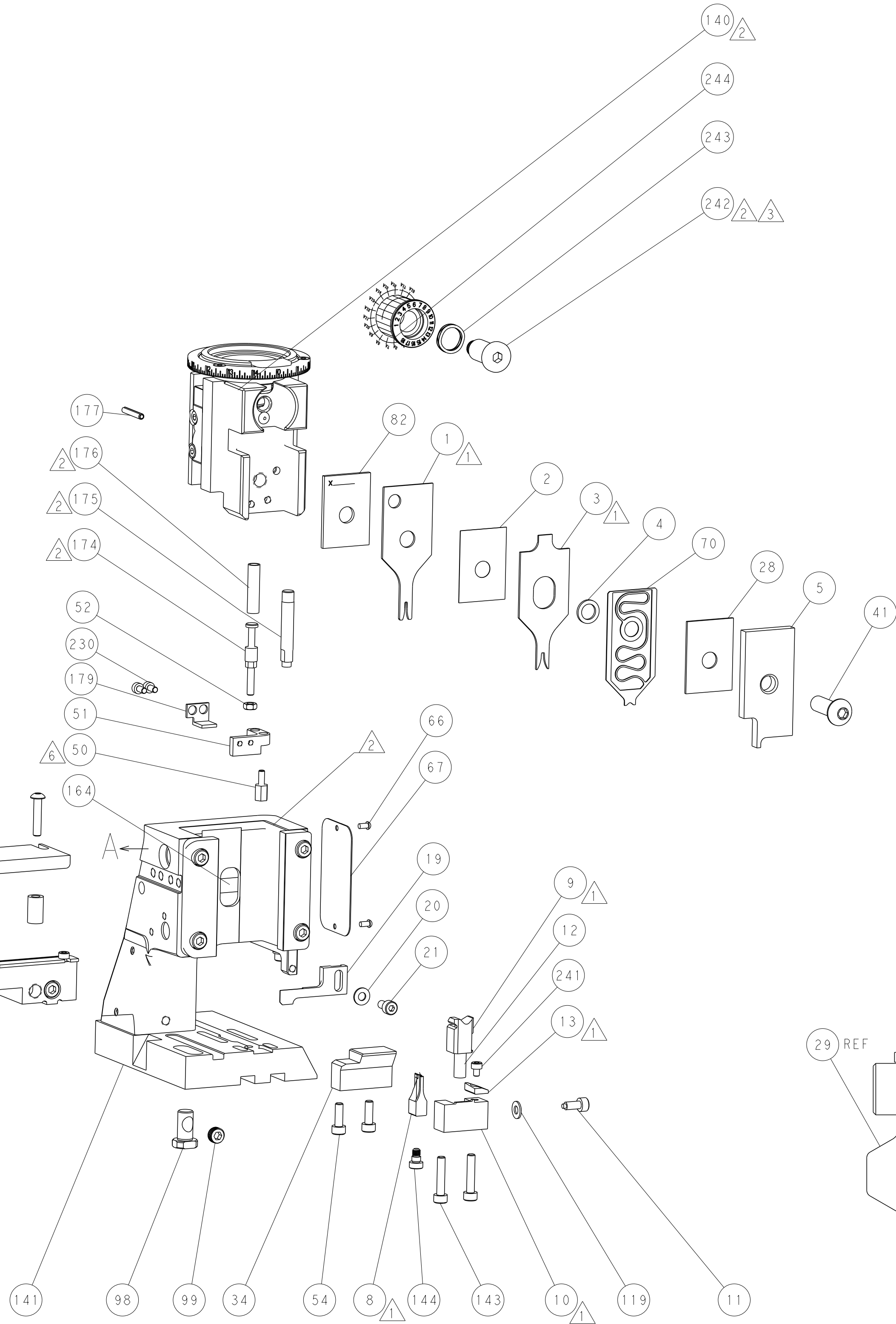
MECHANICAL
PRE FEED



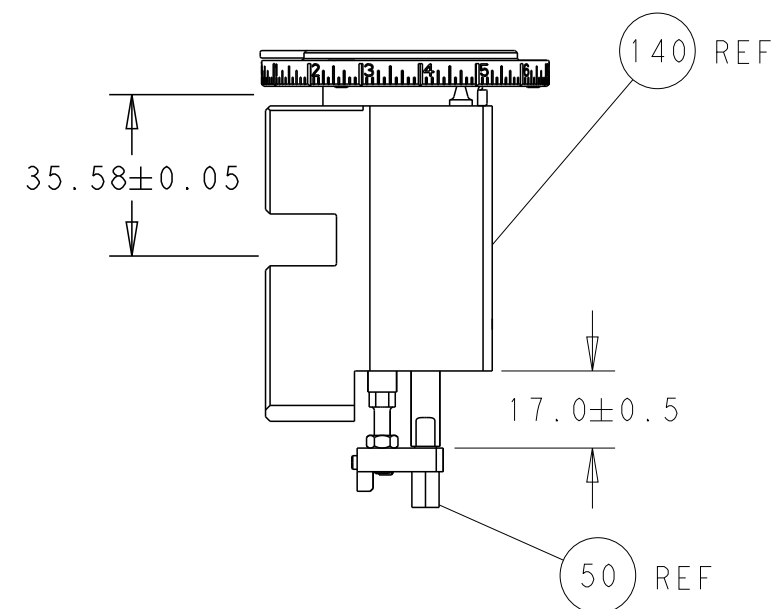
AIR FEED



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

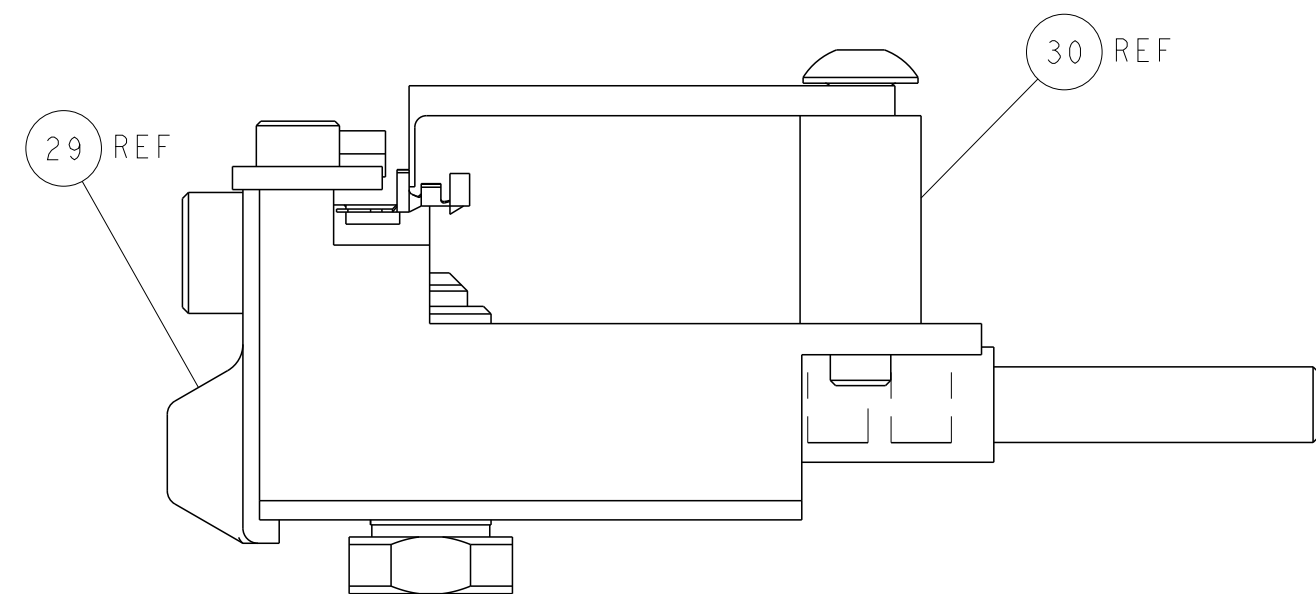


TERMINAL SUPPORT LOCATION



RAM AND HOLDOWN SET-UP

ITEM 30 LOCATED AT
FRONT HOLES



FEED TRACK POSITION
GUIDE BY INSULATION BARREL

THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. THE USER SHALL BE RESPONSIBLE FOR VERIFYING THE LATEST VERSION OF THE DRAWING.				DWN Y. YIN 29AUG2011		TE Connectivity Harrisburg, PA 17105-3608	
CHK G. BAILEY 29AUG2011				APVD S. XI 29AUG2011		NAME OCEAN SIDE FEED APPLICATOR	
DIMENSIONS: mm				TOLERANCES UNLESS OTHERWISE SPECIFIED:		SIZE A1	
0 PLC 1 PLC 2 PLC 3 PLC 4 PLC				± ± ± ± ±		CAGE CODE 00779	
MATERIAL -				FINISH -		DRAWING NO 2151078	
				WEIGHT -		SCALE 1:2	
						SHEET 4 OF 4	
						REV H	

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION