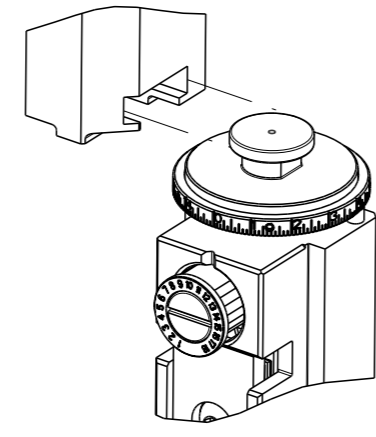


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151651-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2151651-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151651-1	C	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2151651-2	C	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2151651-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER

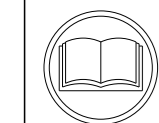


APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.40 mm [.055]	F
INSUL	2.00 mm [.079]	O

APPLICATOR INSTRUCTIONS 408-35042

TERMINAL DATA:	TE TERMINAL	TE CRIMP SPECIFICATION
TERMINAL NAME:	CONTACT, RECEPTACLE / TAB, CRIMP SNAP-IN	
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE
2.63-2.88 mm [.104-.113 IN]		∅ 1.70-2.10 mm [.067-.083 IN]
TERMINAL APPLICATION SPECIFICATION	114-13261	
TERMINALS APPLIED	5	
TE TERMINAL	TE TERMINAL	TE TERMINAL
2106123-1	2106123-3	2106124-2

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
18 AWG	1.05 +/- 0.05 [.041 +/- .002]	7.4
20 AWG	0.87 +/- 0.05 [.034 +/- .002]	9.3



- 1 RECOMMENDED SPARE PARTS
- 2 REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION & 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.

ATLANTIC VERSION  
Shown on sheets 1 of 4 & 2 of 4  
(Pacific version shown on sheets 3 of 4 & 4 of 4)

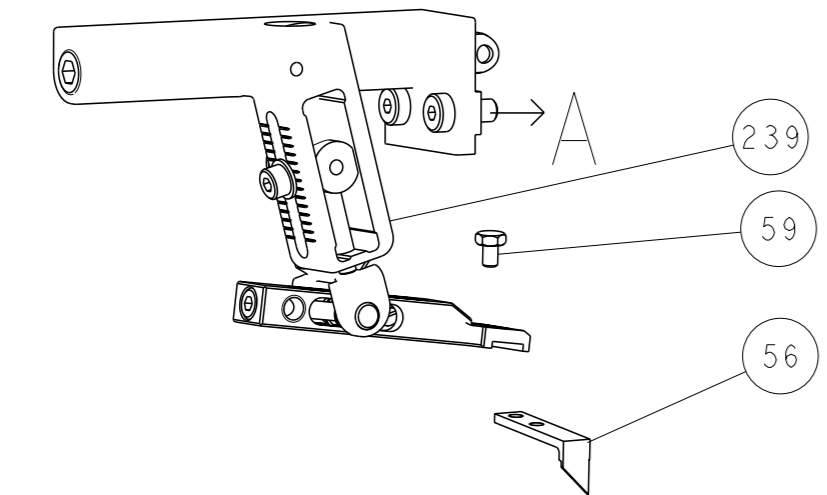
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		A		RELEASED	25SEP2015	JH	GB
		B		ECR-17-001492	03FEB2017	MR	TE
		C		ECR-18-017350	02NOV2018	JAH	CT

-	1	-	1	-	2119640-1	PUSH ROD, AIR FEED	250		
-	1	-	1	-	2079988-1	BUSHING, LCH5-12, MISUMI	249		
-	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	-	2063440-1	AIR FEED MODULE	238		
-	2	-	2	-	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172		
-	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164		
-	1	-	1	-	240638-1	SPRING, FEED FINGER	163		
-	1	-	1	-	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854	137		
-	1	-	1	-	2119799-1	HOLDER, FEED FINGER, AF	136		
-	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	455888-5	SPACER, CRIMPER	82		
-	1	1	1	1	1803607-1	DOCUMENTATION PACKAGE	71		
-	1	1	1	1	1-2119791-7	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	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	53		
-	1	1	1	1	5018030-1	NUT, HEX, REG, RoHS, M3	52		
-	1	1	1	1	811242-5	BUMPER, HOLD DOWN	51		
-	1	1	1	1	690753-2	SPACER, TONKER	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	1752356-3	SUPPORT, TERMINAL	34		
-	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33		
-	2	2	2	2	2-2844962-6	SPACER, CYLINDRICAL, STRIP GUIDE	30		
-	1	1	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29		
-	1	1	1	1	2119791-6	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		
-	2	2	2	2	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	1803095-3	FLOATING SHEAR, FRONT	9		
-	1	2	2	1	1	4-1803055-6	ANVIL, COMBINATION	8	
-	-	-	-	-	-	-	7		
-	-	-	-	-	-	-	6		
-	1	1	1	1	2119757-8	DEPRESSOR, SHEAR	5		
-	1	1	1	1	3-238011-3	BLOCK, CRIMPER SPACER	4		
-	1	2	2	1	1	5-1633966-9	CRIMPER, INSULATION O	3	
-	-	-	-	-	-	-	2		
-	1	2	2	1	1	1-456402-0	CRIMPER, WIRE PREMIUM	1	
-	77	72	71	71	-2	-1	PART NO	DESCRIPTION	ITEM NO

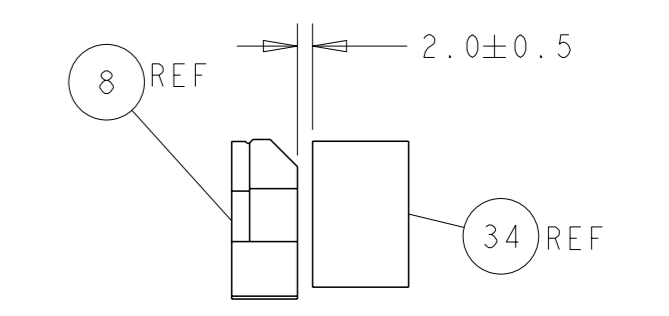
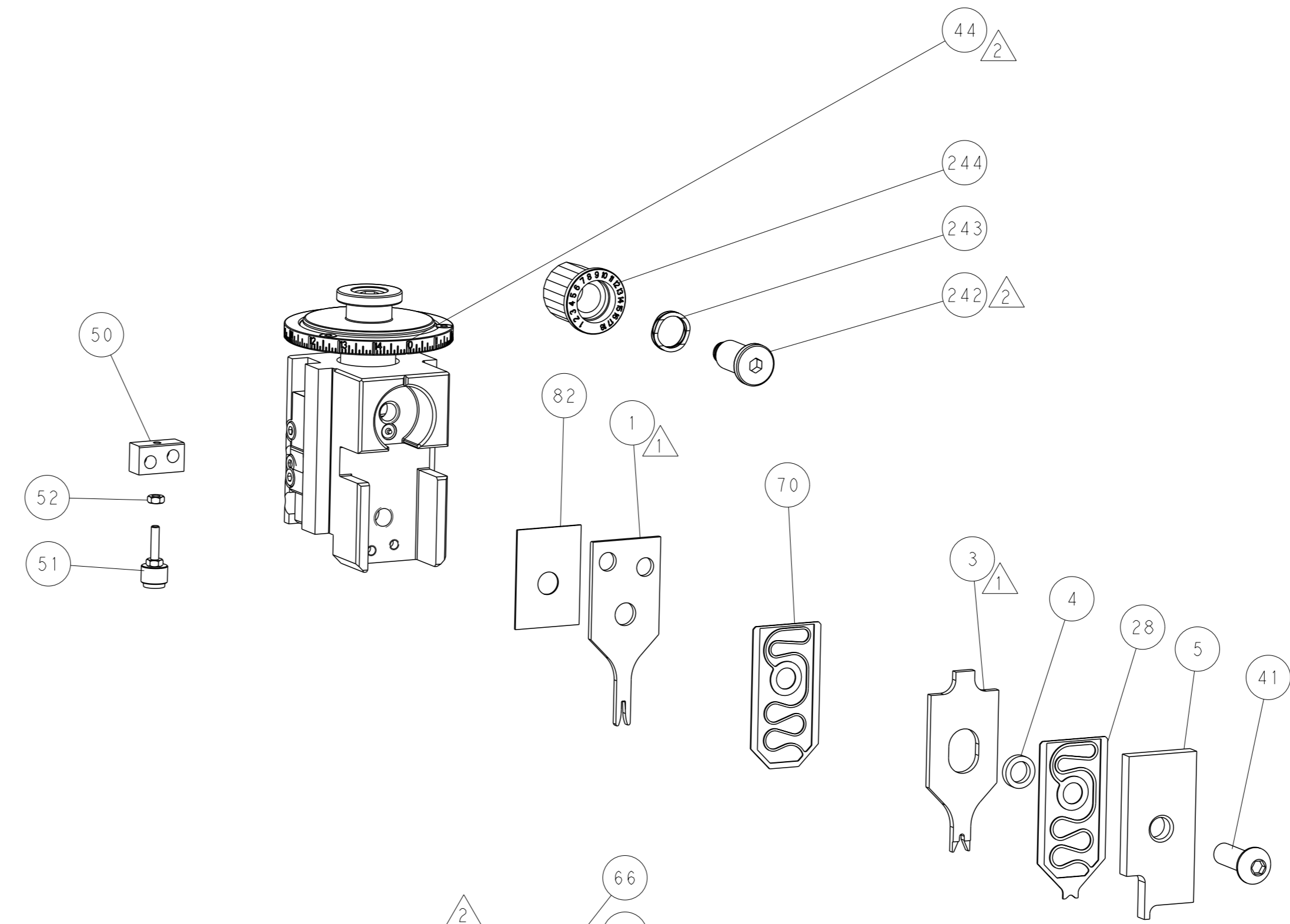
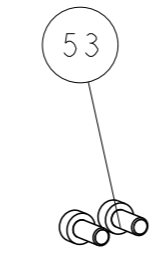
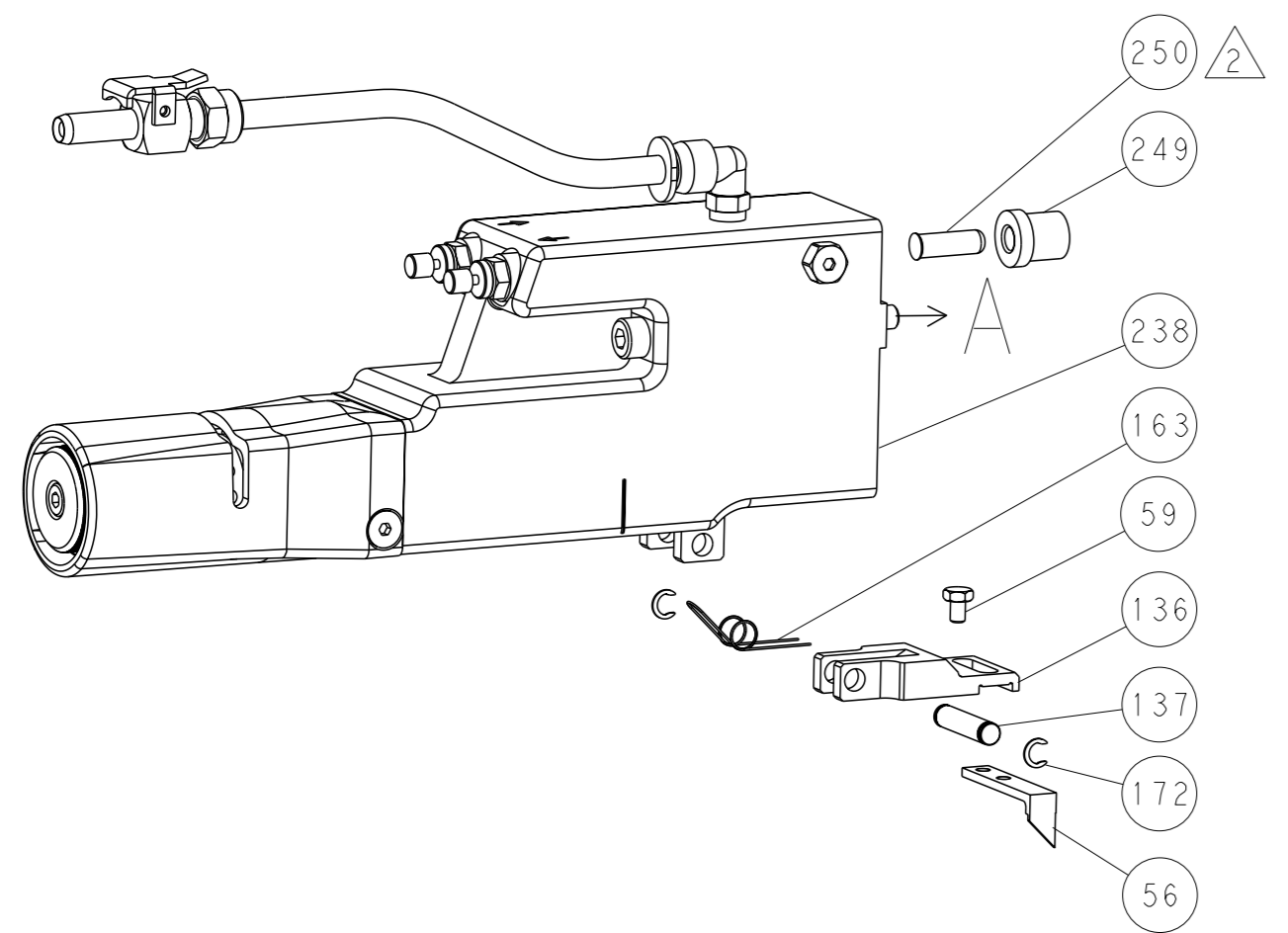
DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH ±		DWN J. HOU 1AUG2015 CHK L. ZHANG 1AUG2015 APVD U. GUO 1AUG2015 PRODUCT SPEC APPLICATION SPEC MATERIAL:		NAME: Ocean Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2151651 RESTRICTED TO:			
Customer Accessible Production Drawing				SCALE: 1:2		SHEET 1 OF 4		REV C	

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

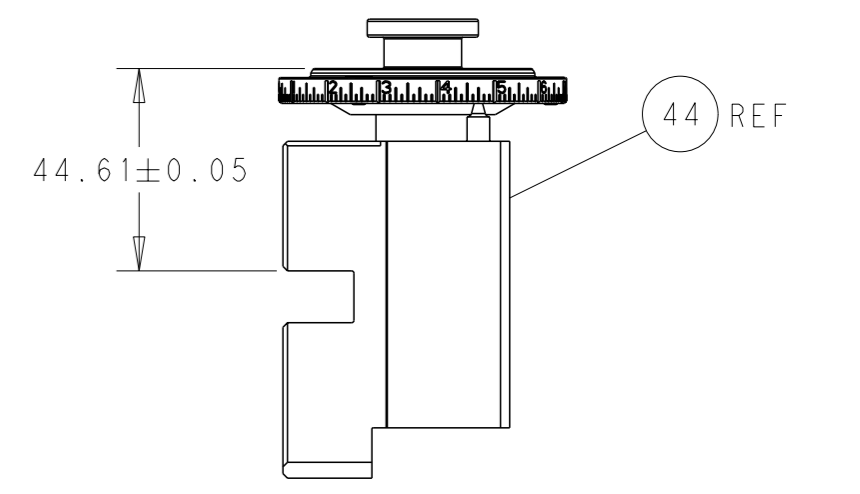
# FEED TYPE MECHANICAL



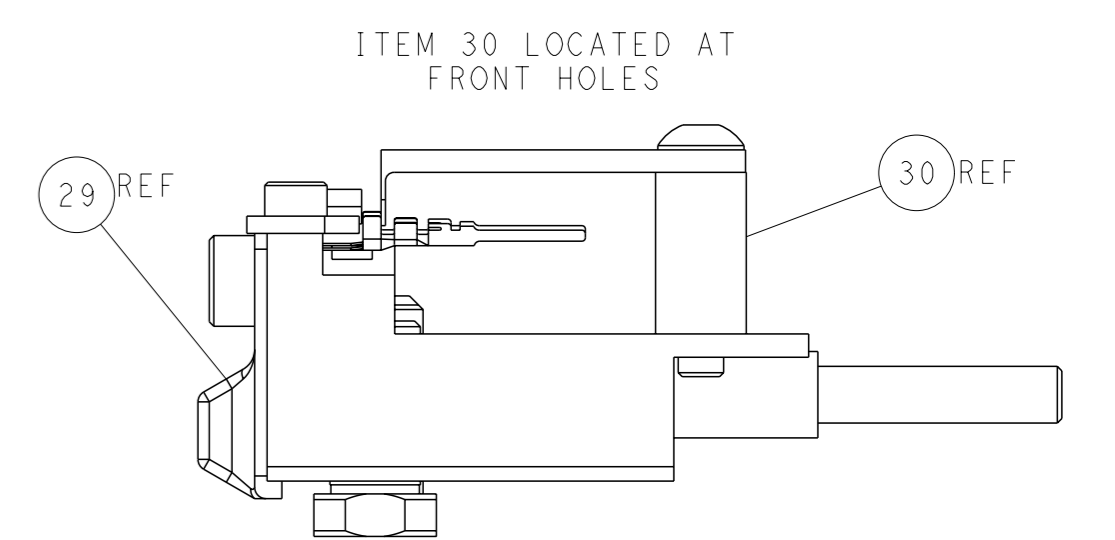
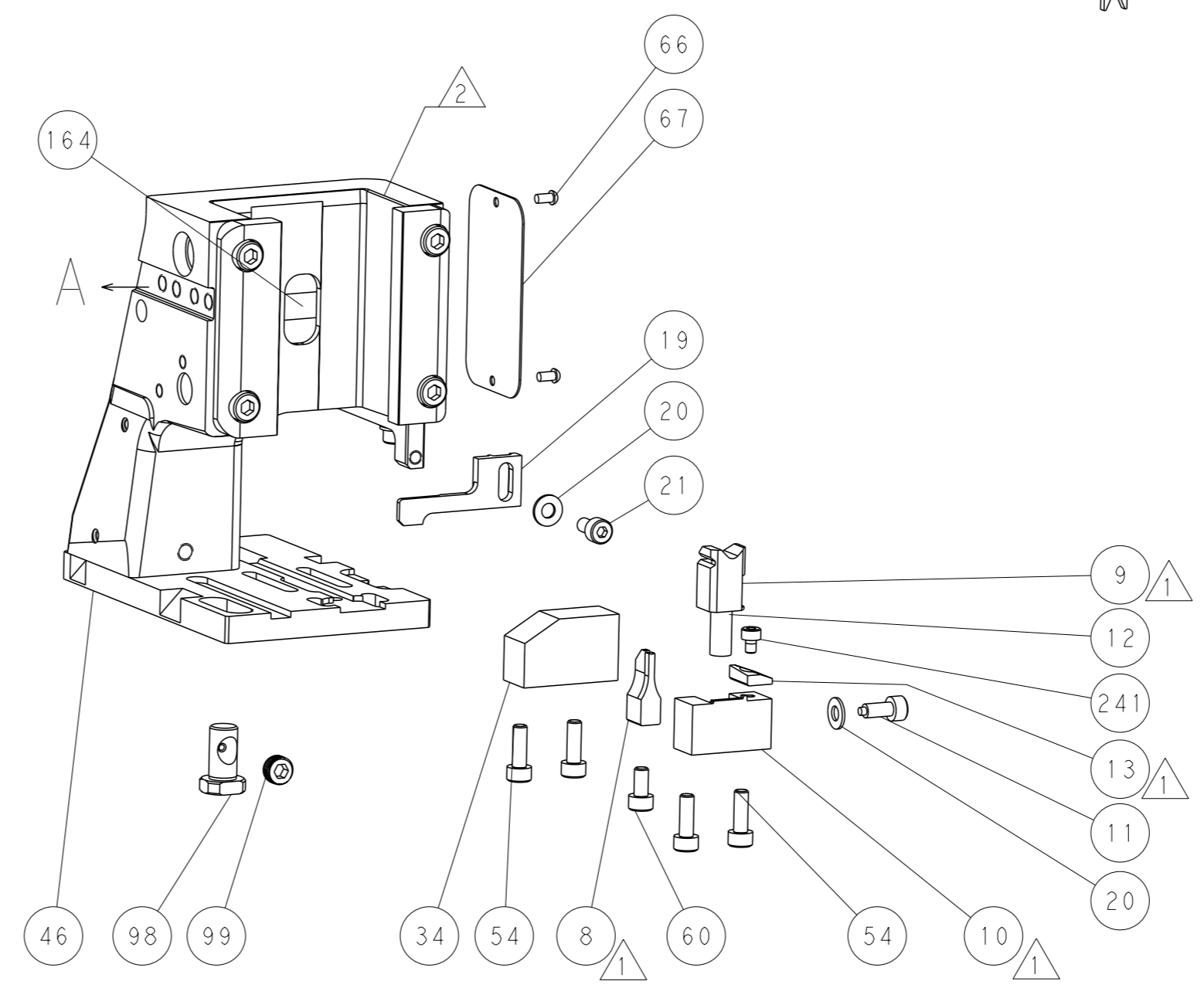
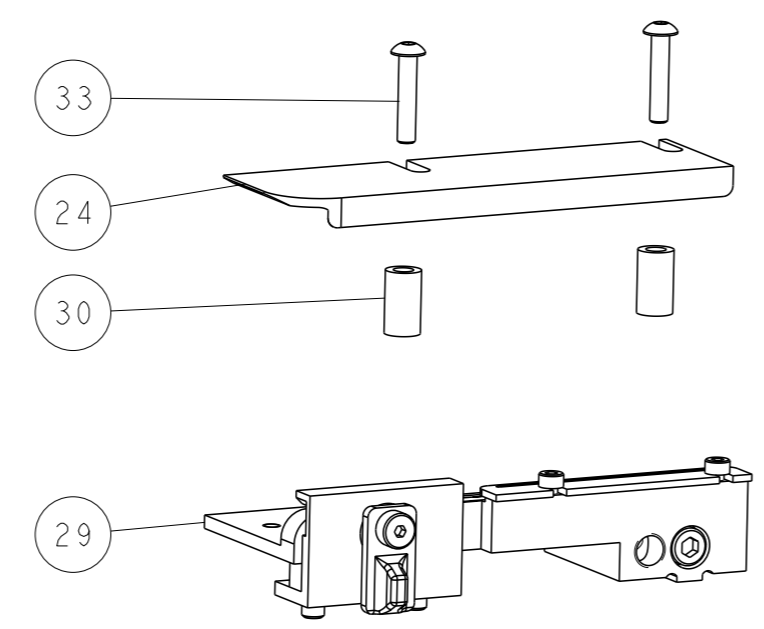
# PNEUMATIC



TERMINAL SUPPORT LOCATION

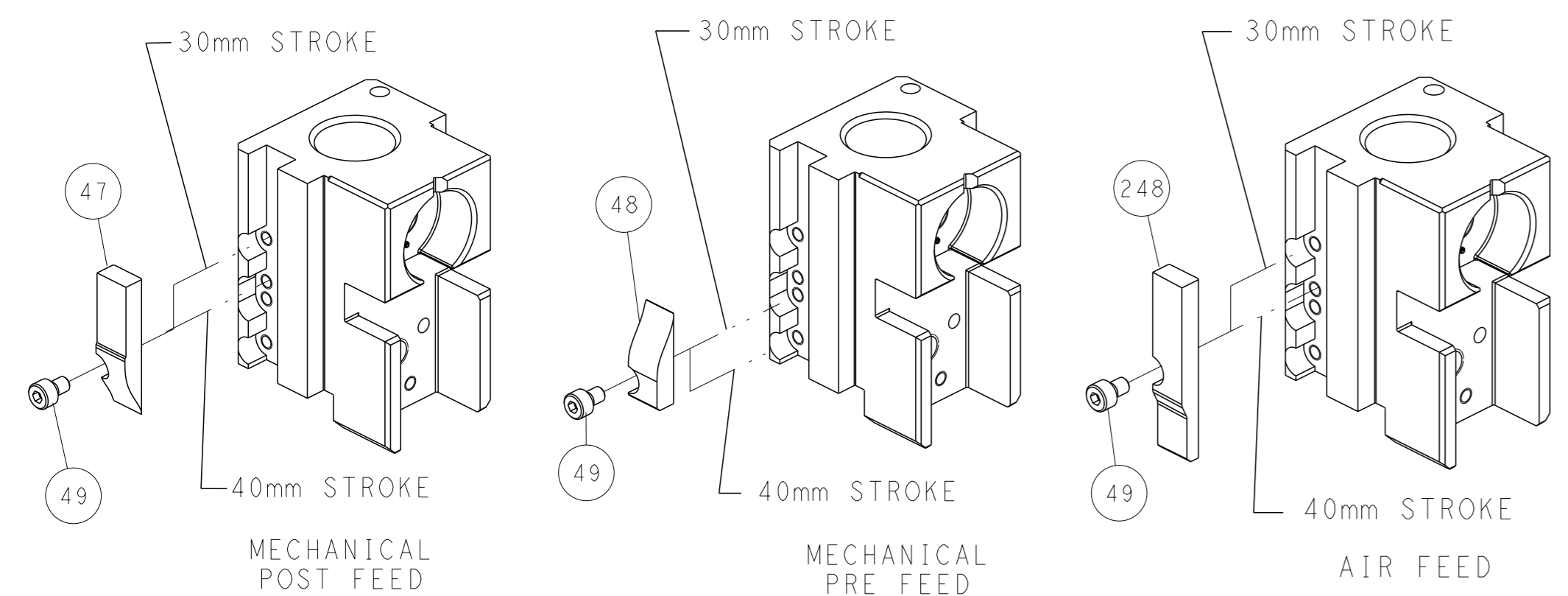


RAM SET-UP



FEED TRACK POSITION GUIDE BY INSULATION BARREL

# CAM POSITIONS

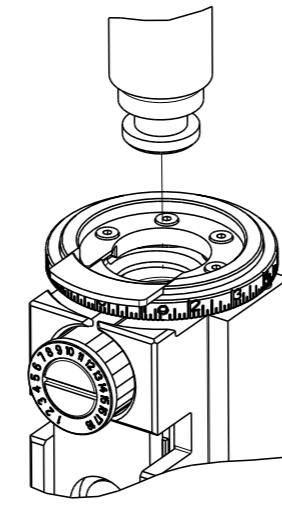


**ATLANTIC VERSION**  
 Shown on sheets 1 of 4 & 2 of 4  
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		OWN J. HOU 7AUG2015 CHK L. ZHANG 7AUG2015 APVD W. GUO 7AUG2015 PRODUCT SPEC APPLICATION SPEC WEIGHT MATERIAL		NAME Ocean Side Feed Applicator SIZE CAGE CODE DRAWING NO. A1 00779 C=2151651 RESTRICTED TO	
Customer Accessible Production Drawing				SCALE 1:2	SHEET 2 of 4	REV C	

THIS DRAWING IS UNPUBLISHED.	RELEASED FOR PUBLICATION	20	
COPYRIGHT 20 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.			
PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2151651-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2151651-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151651-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR  
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.40 mm [.055]	F
INSUL	2.00 mm [.079]	O
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: CONTACT, RECEPTACLE / TAB, CRIMP SNAP-IN			
WIRE STRIP LENGTH 2.63-2.88 mm [.104-.113 IN]		INSULATION DIAMETER RANGE Ø 1.70-2.10 mm [.067-.083 IN]	
TERMINAL APPLICATION SPECIFICATION	114-13261	-	-
TERMINALS APPLIED			
TE TERMINAL 2106123-1	TE TERMINAL 2106123-3	TE TERMINAL 2106124-2	TE TERMINAL 2106124-3

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
18 AWG	1.05+/-0.05 [.041+/-0.002]	7.4
20 AWG	0.87+/-0.05 [.034+/-0.002]	9.3



- 1 RECOMMENDED SPARE PARTS
- 2 REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION & 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)

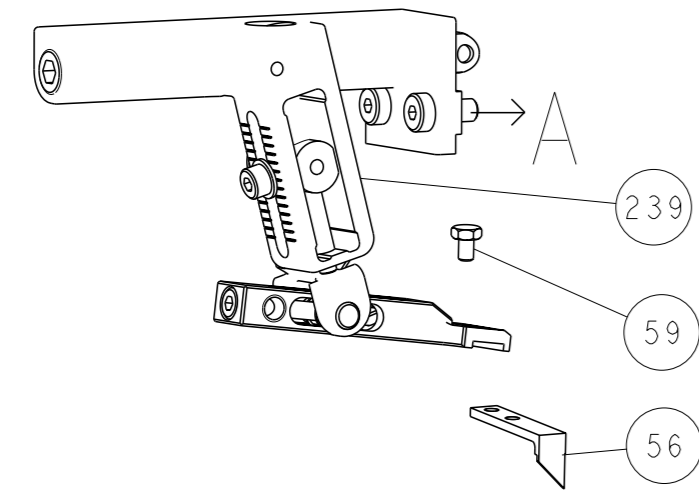
LOC	DIST	REVISIONS			
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-	1	-	2119640-1	PUSH ROD, AIR FEED	250
-	1	-	2079988-1	BUSHING, LCH5-12, MISUMI	249
-	1	1	2119082-4	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
-	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	1	-	2063440-1	AIR FEED MODULE	238
-	2	-	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172
-	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	1	-	240638-1	SPRING, FEED FINGER	163
-	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	-	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854	137
-	1	-	2119799-1	HOLDER, FEED FINGER, AF	136
-	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	1803607-1	DOCUMENTATION PACKAGE	71
-	1	1	1-2119791-7	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	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	53
-	1	1	5018030-1	NUT, HEX, REG, RoHS, M3	52
-	1	1	811242-5	BUMPER, HOLD DOWN	51
-	1	1	690753-2	SPACER, TONKER	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	1752356-3	SUPPORT, TERMINAL	34
-	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	2-2844962-6	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29
-	1	1	2119791-6	DEPRESSOR, WIRE	28
-	1	1	1320928-2	STRIP GUIDE	24
-	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
-	2	2	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	1803095-3	FLOATING SHEAR, FRONT	9
-	1	1	1-1803055-6	ANVIL, COMBINATION	8
-	-	-	-	-	7
-	-	-	-	-	6
-	1	1	2119757-8	DEPRESSOR, SHEAR	5
-	1	1	3-238011-3	BLOCK, CRIMPER SPACER	4
-	1	1	5-1633966-9	CRIMPER, INSULATION O	3
-	-	-	-	-	2
-	1	1	1-456402-0	CRIMPER, WIRE PREMIUM	1

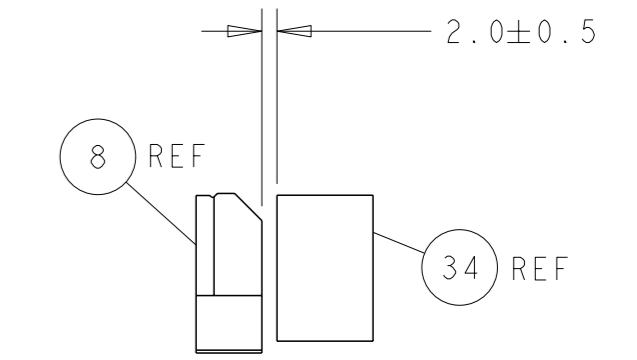
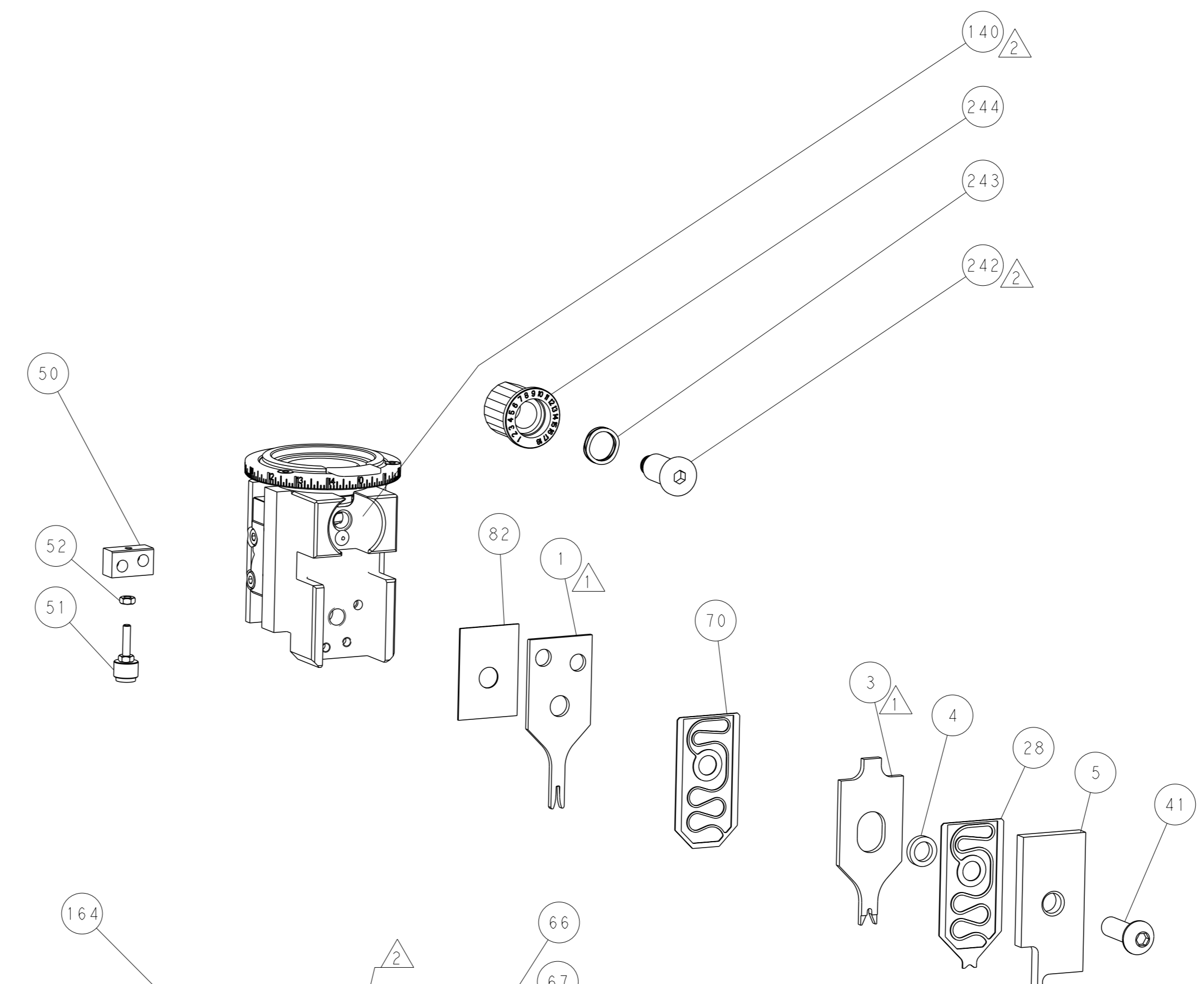
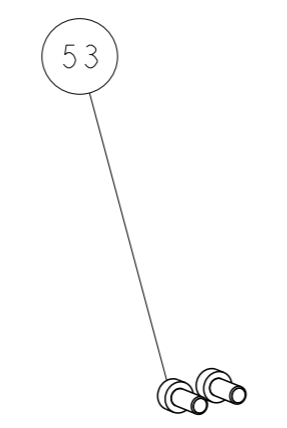
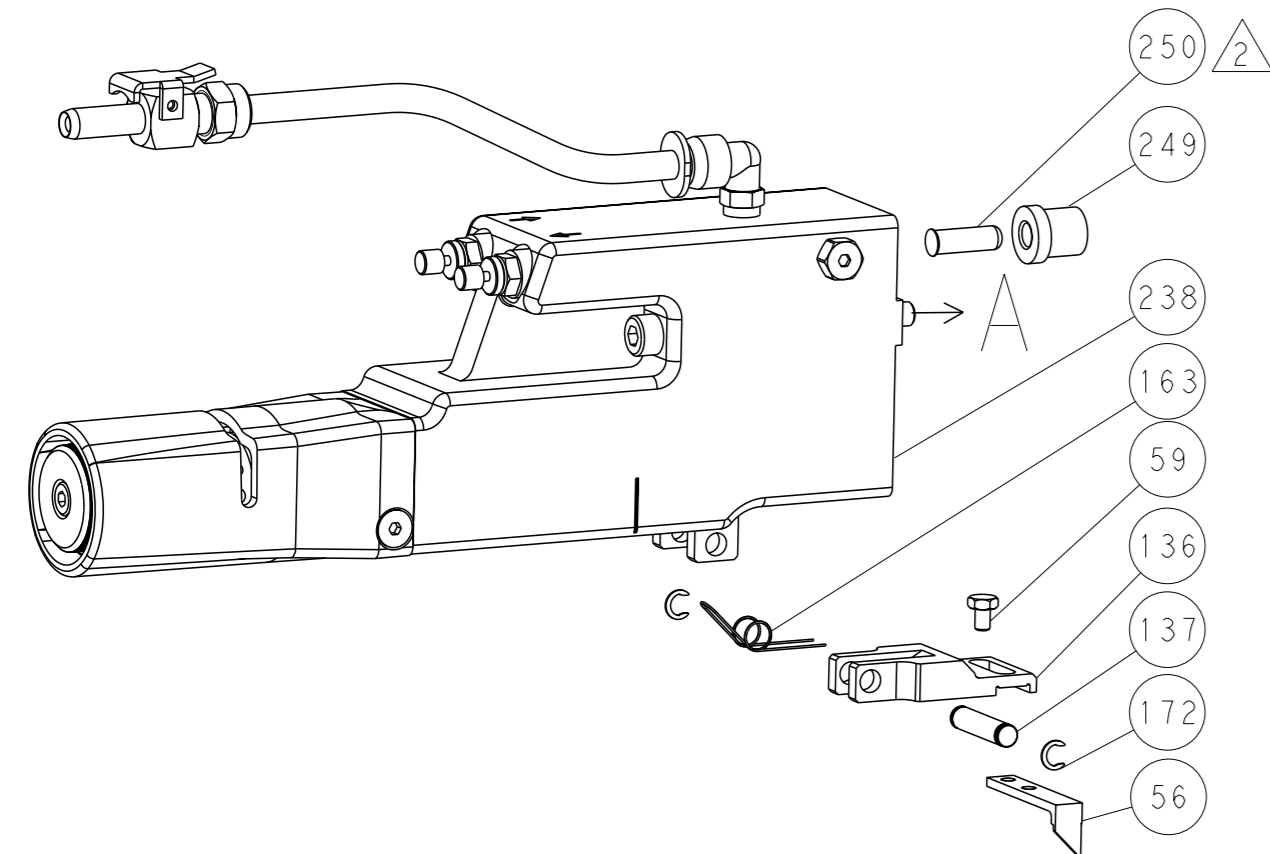
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		OWN	J. HOU	TAUG2015	STE TE Connectivity Harrisburg, PA 17105-3608
mm		0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH		CHK	L. ZHANG	TAUG2015	
MATERIAL		FINISH		APVD	J. GUO	TAUG2015	NAME
				PRODUCT SPEC		Ocean Side Feed Applicator	
				APPLICATION SPEC		SIZE	
				WEIGHT		CAGE CODE DRAWING NO	
				SCALE		RESTRICTED TO	
				CUSTOMER ACCESSIBLE PRODUCTION DRAWING		A1 00779 C=2151651	
				SCALE		SHEET 3 OF 4	
				REV		C	

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

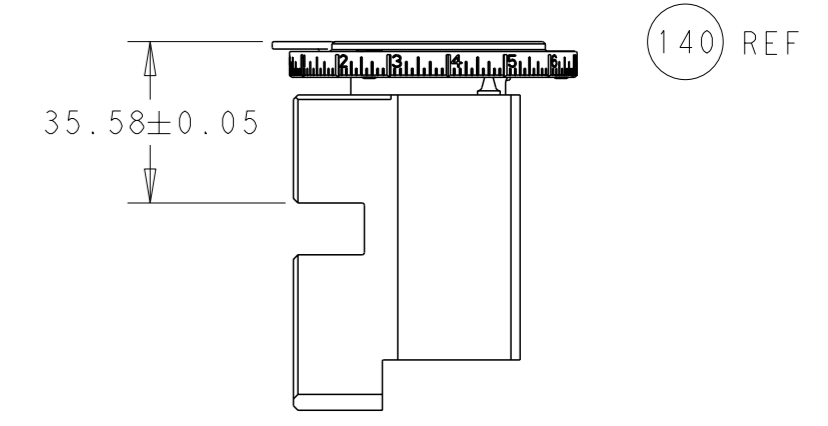
# FEED TYPE MECHANICAL



# PNEUMATIC

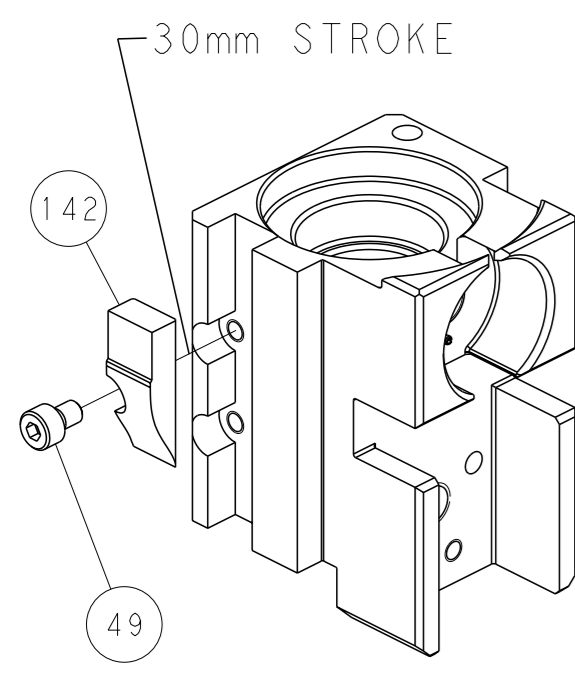


TERMINAL SUPPORT LOCATION

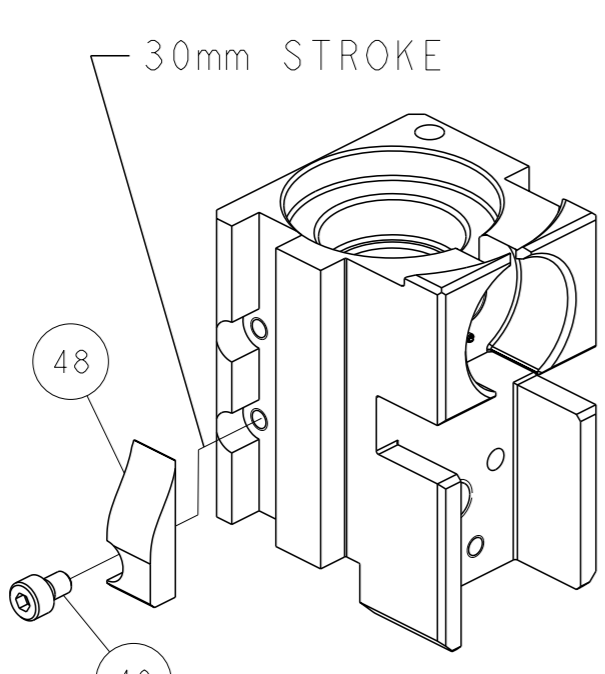


RAM SET-UP

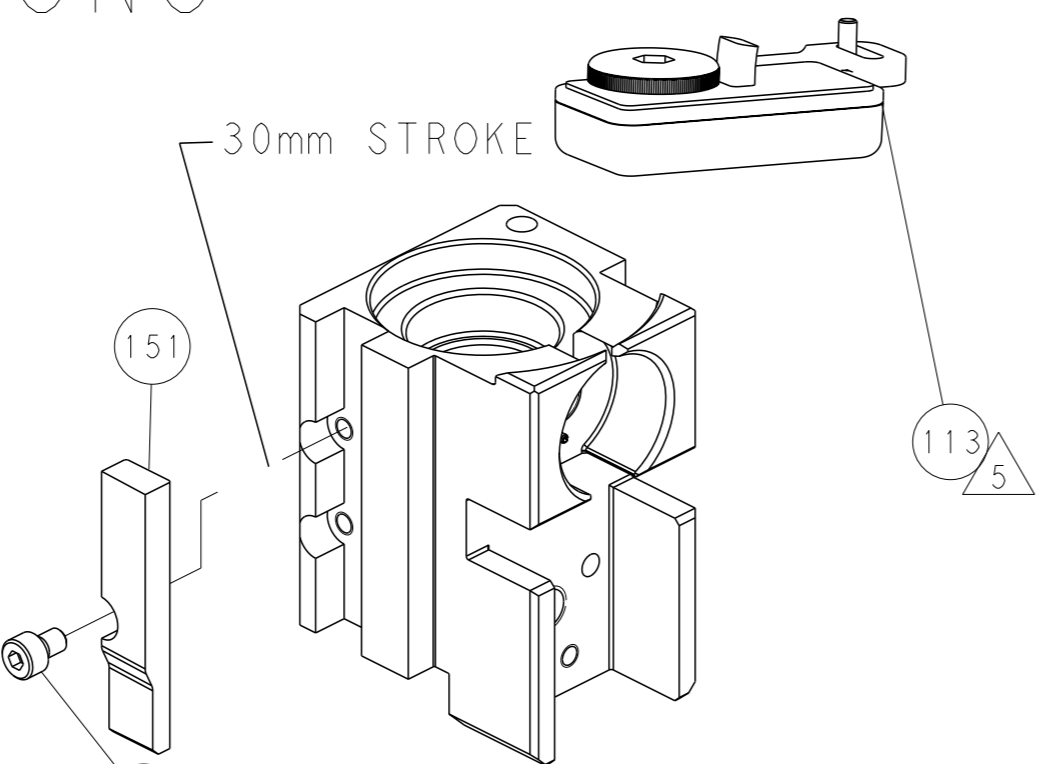
# CAM POSITIONS



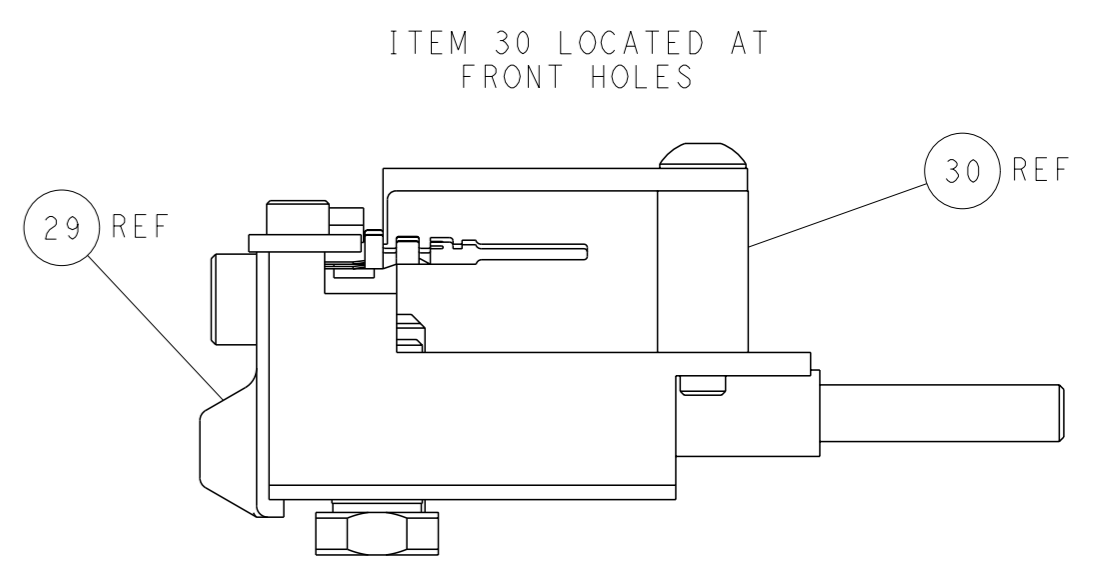
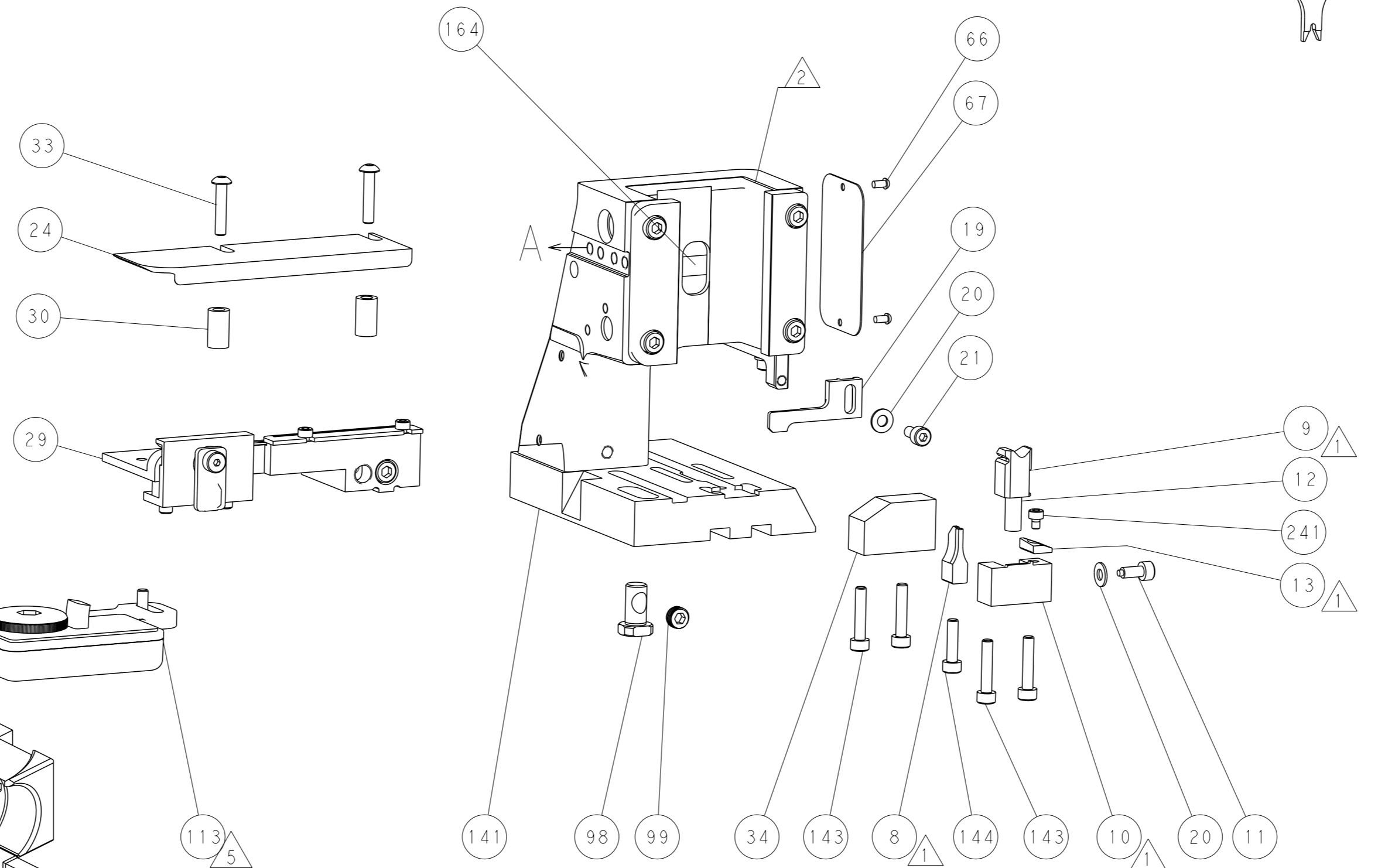
MECHANICAL  
POST FEED



MECHANICAL  
PRE FEED



AIR FEED



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)

<small>THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE AND THE CONTROLLER ENGINEERING ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST REVISION.</small>		OWN: J. HOU CHK: L. ZHANG APVD: J. GUO	DATE: 7AUG2015 DATE: 7AUG2015 DATE: 7AUG2015	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 SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2151651	RESTRICTED TO: - SCALE: 1:2 SHEET: 4 of 4 REV: C	CUSTOMER ACCESSIBLE PRODUCTION DRAWING