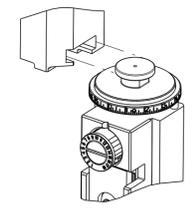


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151320-1	F	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2151320-2	F	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151320-1	F	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2151320-2	F	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2151320-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	.100 [2.54 mm]	F
INSUL	.180 [4.57 mm]	F

APPLICATOR INSTRUCTIONS 408-35042

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: .140 DIA PIN & SOCKET			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	$\varnothing .086 - .180$ IN [2.18-4.57 mm]
TERMINAL APPLICATION SPECIFICATION	114-1007		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
925714-1	925715-1	61626-1	925851-1
925714-2	925715-2	61626-2	925851-2
925714-3	925715-3	61627-1	794974-1
925714-4	925715-4	61627-2	
925714-8	925715-5		

WIRE SIZE	CRIMP HEIGHT INCH [mm]	CRIMP HEIGHT REFERENCE SETTING	STABILIZER SETTING
14 AWG	0.071+/-0.002 [1.80+/-0.05]	4.9	7
2.00mm2	0.070+/-0.002 [1.78+/-0.05]	5.1	6
1.50mm2	0.063+/-0.002 [1.60+/-0.05]	6.7	6
16 AWG	0.061+/-0.002 [1.55+/-0.05]	7.3	5
1.00mm2	0.056+/-0.002 [1.42+/-0.05]	8.9	5
18 AWG	0.054+/-0.002 [1.37+/-0.05]	9.5	3
0.75mm2	0.053+/-0.002 [1.35+/-0.05]	9.8	3
20 AWG	0.051+/-0.002 [1.30+/-0.05]	10.3	3
0.50mm2	0.051+/-0.002 [1.30+/-0.05]	10.3	3

***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.

- 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.
- UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- INSULATION DIA: .149 OR LESS
STRIP LENGTH: .188-.132
INSULATION DIA: .150-.180
STRIP LENGTH: .281-.343
- STABILIZER KNOB MUST BE ADJUSTED TO SETTINGS INDICATED (WHICH CORRESPOND TO WIRE CRIMP HEIGHT SETTINGS).

LOC	DIST	REVISIONS					
A	66	P	LTN	DESCRIPTION	DATE	OWN	APVD
		C		ECR-13-016169	16OCT2013	BH	TE
		D		ECR-14-003911	17MAR2014	XZ	TE
		E		ECR-17-003441	09MAR2017	KH	CT
		F		ECR-18-007382	14MAY2018	TB	JDG

-	1	1	1	1	2119787-1	CRIMPER, STABILIZER O PREMIUM	258
-	1	1	1	1	238011-2	BLOCK, CRIMPER SPACER	257
-	1	1	1	1	2119348-2	SNAIL CAM, STABILIZER CRIMP ADJUSTMENT	256
-	2	2	2	2	2079844-1	SPRING PLUNGER, M4	255
-	1	1	1	1	2119347-1	KNOB, STABILIZER CRIMP ADJUSTMENT	254
-	1	1	1	1	18032-1	SCR, SET, FLT PNT, M3 X 5.0	253
-	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	2119082-9	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
-	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	1-18028-2	WASHER, FLAT, REG M4	119
-	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	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	1803382-2	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	3-1752356-4	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	2119797-1	SPACER, CRIMPER, SPECIAL	28
-	1	1	1	1	1320928-1	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	454276-5	FLOATING SHEAR, FRONT	9
-	1	2	2	1	1633922-1	ANVIL, COMBINATION	8
-	1	1	1	1	240641-1	SPACER	7
-	1	1	1	1	2119349-1	SHEAR DEPRESSOR, STAB. CRIMP ADJ.	5
-	1	1	1	1	1-238011-0	BLOCK, CRIMPER SPACER	4
-	1	2	2	1	2119794-1	CRIMPER, INSUL F PREM, SPECIAL	3
-	1	1	1	1	2119797-2	SPACER, CRIMPER, SPECIAL	2
-	1	2	2	1	814590-2	CRIMPER, WIRE F PREMIUM	1

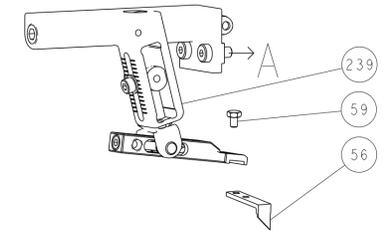
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

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

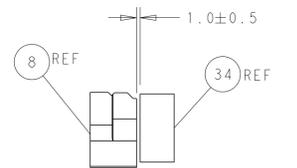
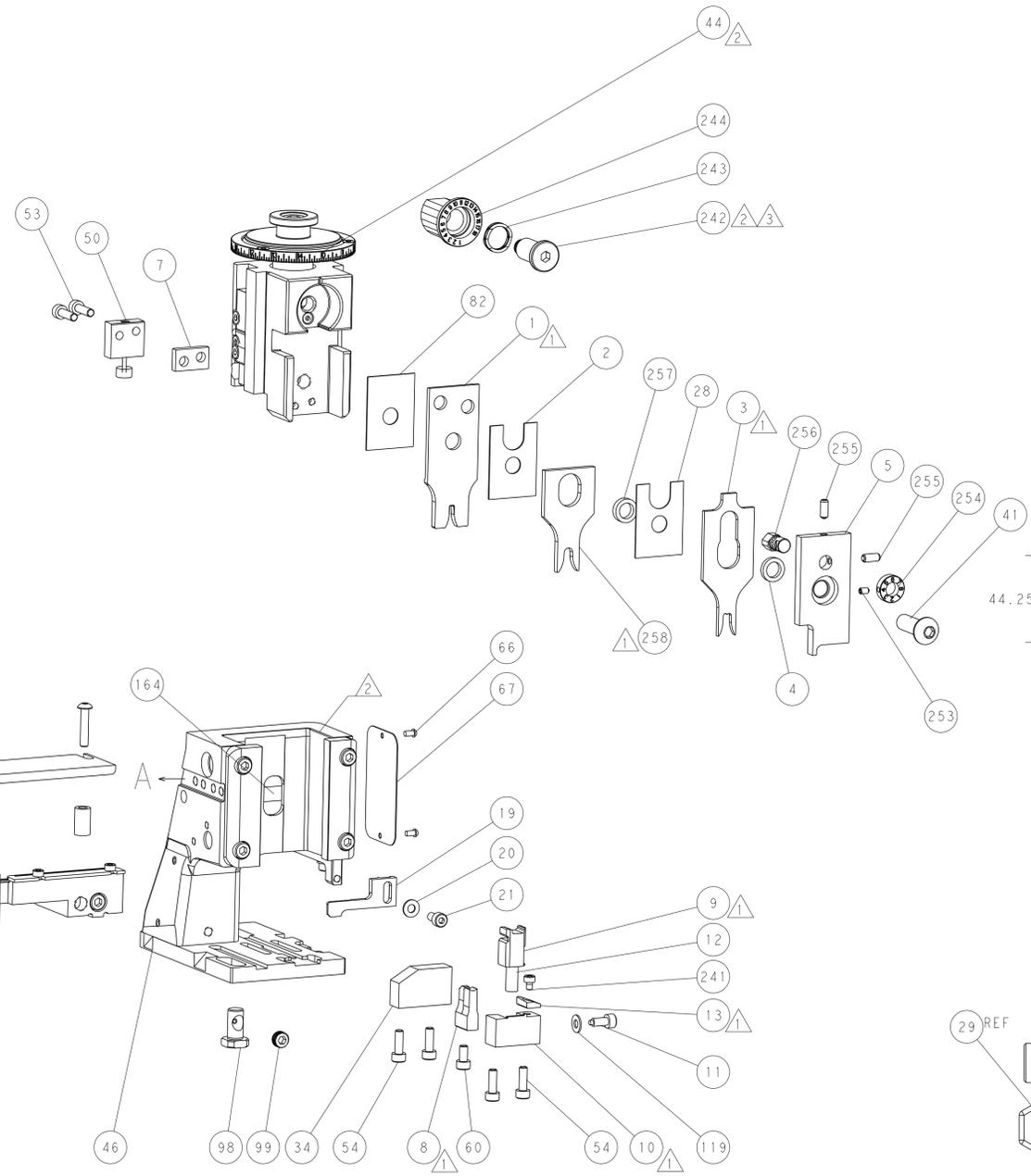
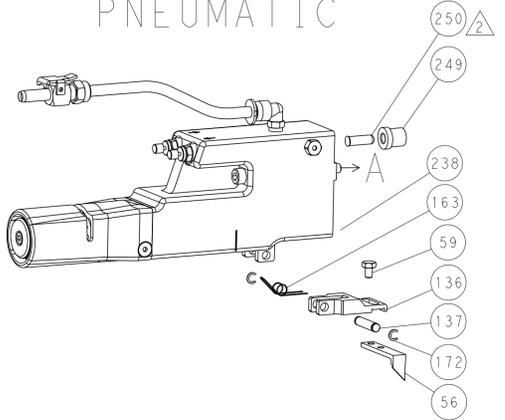
OWN	B. WEAVER	19SEP2011
CHK	G. HOFFNER	19SEP2011
APVD	T. ELBIN	19SEP2011
NAME	Ocean Side Feed Applicator	
SIZE	CAGE CODE	DRAWING NO
A1	00779	2151320
Customer Accessible Production Drawing		
SCALE	1:2	SHEET 1 OF 4
REV	F	

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

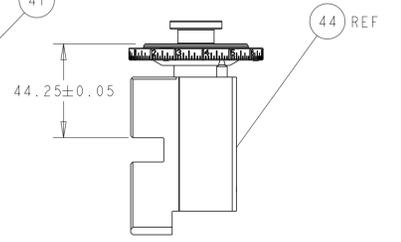
FEED TYPE MECHANICAL



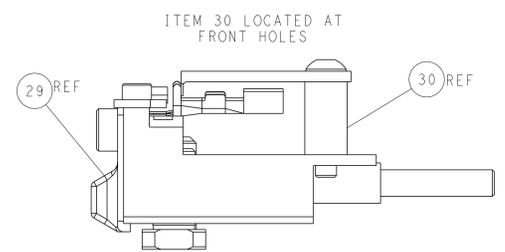
PNEUMATIC



TERMINAL SUPPORT LOCATION

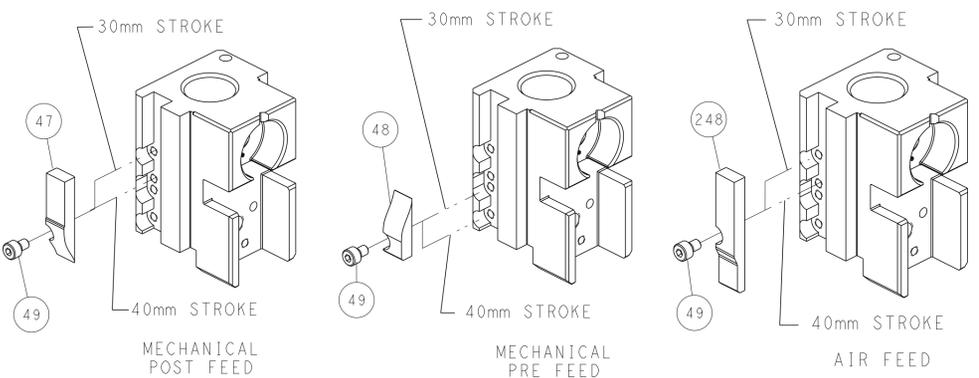


RAM SET-UP



FEED TRACK POSITION GUIDE BY INSULATION BARREL

CAM POSITIONS

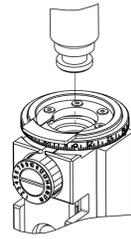


ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH		DWN B. WEAVER 19SEP2011 CHK G. HOFFNER 19SEP2011 APVD T. ELBLIN 19SEP2011 NAME PRODUCT SPEC APPLICATION SPEC WEIGHT Customer Accessible Production Drawing		TE Connectivity Harrisburg, PA 17105-3608 Ocean Side Feed Applicator SIZE CAGE CODE DRAWING NO A1 00779 ©=2151320 SCALE 1:2 SHEET 2 OF 4 REV F	
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THIS DRAWING IS UNPUBLISHED.	RELEASED FOR PUBLICATION	2011	
COPYRIGHT 2011 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.			
PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2151320-1	F	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2151320-2	F	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151320-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	.100 [2.54 mm]	F
INSUL	.180 [4.57 mm]	F
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: .140 DIA PIN & SOCKET			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
114-1007		Ø.086-.180 IN [2.18-4.57 mm]	
TERMINAL APPLICATION SPECIFICATION			
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
925714-1	925715-1	61626-1	925851-1
925714-2	925715-2	61626-2	925851-2
925714-3	925715-3	61627-1	794974-1
925714-4	925715-4	61627-2	
925714-8	925715-5		

WIRE SIZE	CRIMP HEIGHT INCH [mm]	CRIMP HEIGHT REFERENCE SETTING	STABILIZER SETTING
14 AWG	0.071+/-0.002 [1.80+/-0.05]	4.9	7
2.00mm2	0.070+/-0.002 [1.78+/-0.05]	5.1	6
1.50mm2	0.063+/-0.002 [1.60+/-0.05]	6.7	6
16 AWG	0.061+/-0.002 [1.55+/-0.05]	7.3	5
1.00mm2	0.056+/-0.002 [1.42+/-0.05]	8.9	5
18 AWG	0.054+/-0.002 [1.37+/-0.05]	9.5	3
0.75mm2	0.053+/-0.002 [1.35+/-0.05]	9.8	3
20 AWG	0.051+/-0.002 [1.30+/-0.05]	10.3	3
0.50mm2	0.051+/-0.002 [1.30+/-0.05]	10.3	3

***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.

- △ 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.
- 5. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- △ INSULATION DIA: .149 OR LESS
STRIP LENGTH: .188-.132
INSULATION DIA: .150-.180
STRIP LENGTH: .281-.343
- △ STABILIZER KNOB MUST BE ADJUSTED TO SETTINGS INDICATED (WHICH CORRESPOND TO WIRE CRIMP HEIGHT SETTINGS).

LOC	DIST	REV	DATE	BY	APPD
A	66				

REV	DATE	BY	APPD	DESCRIPTION	ITEM NO
-	-	-	-	SEE SHEET 1	-
-	1	1		2119787-1 CRIMPER, STABILIZER O PREMIUM	258
-	1	1		238011-2 BLOCK, CRIMPER SPACER	257
-	1	1		2119348-2 SNAIL CAM, STABILIZER CRIMP ADJUSTMENT	256
-	2	2		2079844-1 SPRING PLUNGER, M4	255
-	1	1		2119347-1 KNOB, STABILIZER CRIMP ADJUSTMENT	254
-	1	1		18032-1 SCR, SET, FLT PNT, M3 X 5.0	253
-	1	-		2119640-1 PUSH ROD, AIR FEED	250
-	1	-		2079988-1 BUSHING, LCH5-12, MISUMI	249
-	1	1		2119082-9 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		1-18028-2 WASHER, FLAT, REG M4	119
-	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		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		1803382-2 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		3-1752356-4 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		2119797-1 SPACER, CRIMPER, SPECIAL	28
-	1	1		1320928-1 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		454276-5 FLOATING SHEAR, FRONT	9
-	1	1		1633922-1 ANVIL, COMBINATION	8
-	1	1		240641-1 SPACER	7
-	1	1		2119349-1 SHEAR DEPRESSOR, STAB. CRIMP ADJ.	5
-	1	1		1-238011-0 BLOCK, CRIMPER SPACER	4
-	1	1		2119794-1 CRIMPER, INSUL F PREM, SPECIAL	3
-	1	1		2119797-2 SPACER, CRIMPER, SPECIAL	2
-	1	1		814590-2 CRIMPER, WIRE F PREMIUM	1

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG: B. WEAVER 19SEP2011		CHK: G. HOFFNER 19SEP2011		APVD: T. ELBIN 19SEP2011		NAME: Ocean Side Feed Applicator	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES	FINISH	WEIGHT	SCALE	SHEET	REV
									1:2	3 OF 4	F

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

