

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

- 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).
- 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.

LOC	DIST	REV	DATE	BY	CHK	APPV
A	66	D	17MAR2014	XZ	TE	
		E	09MAR2017	KH	CT	
		F	14MAY2018	TB	JDG	
		G	16MAY2019	FJ	TE	

QTY	LOC	DIST	REV	DATE	BY	CHK	APPV	DESCRIPTION	ITEM NO
-	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	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	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)

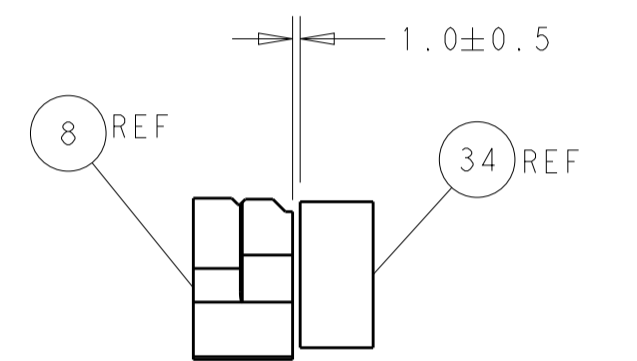
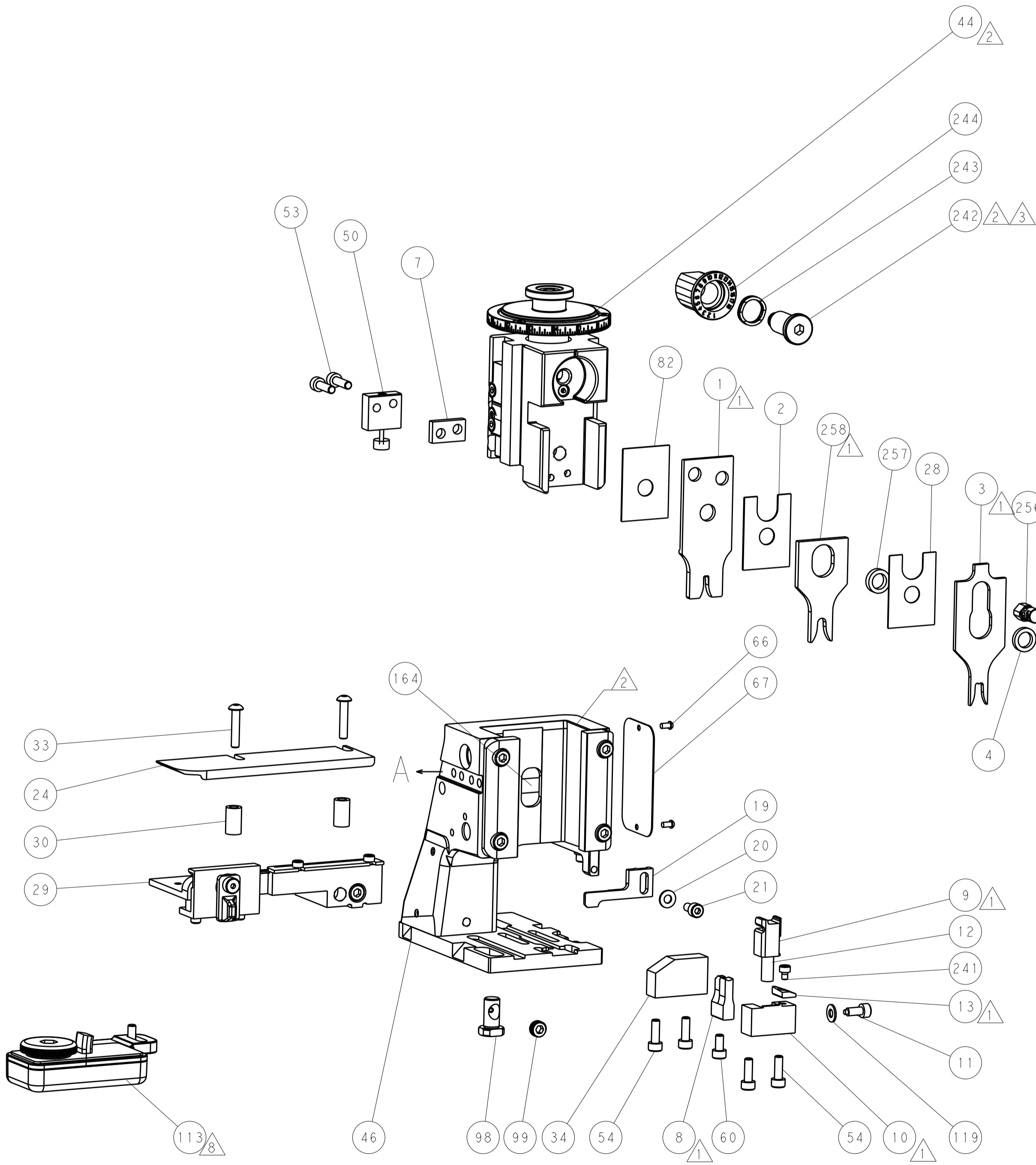
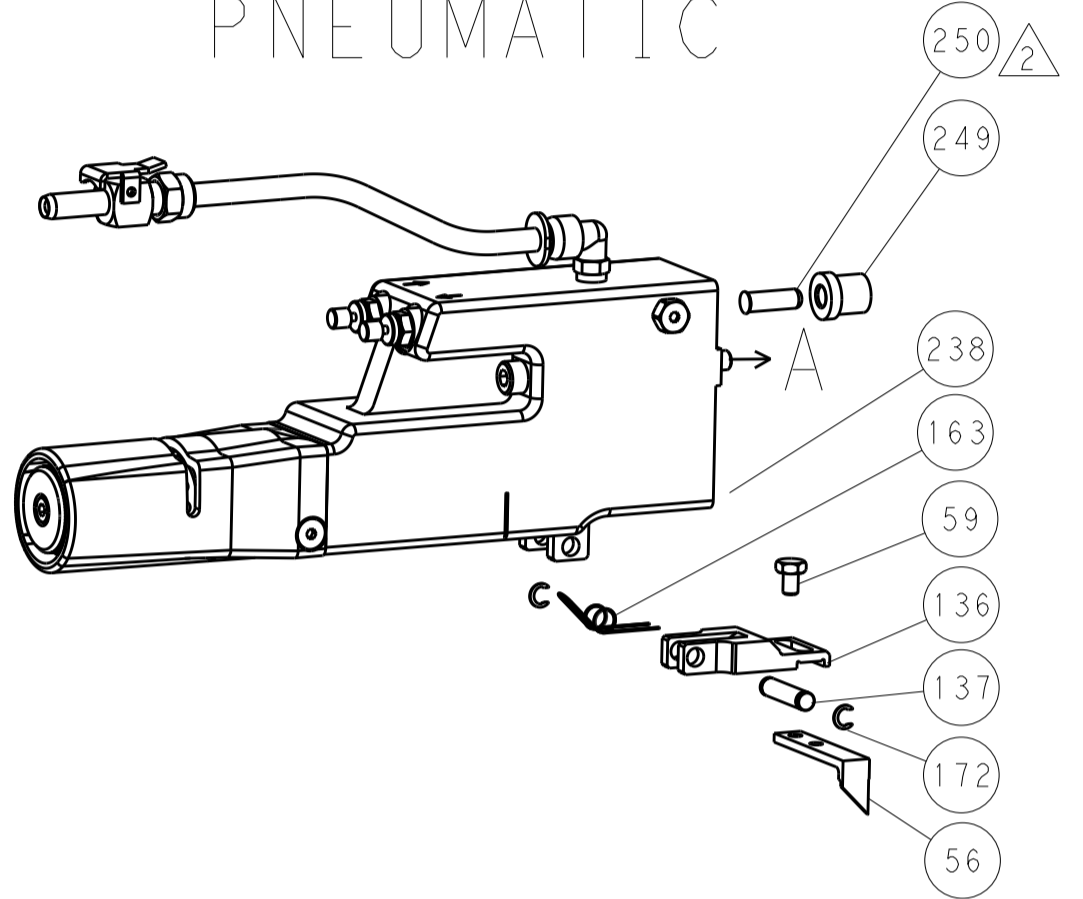
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG: B. WEAVER 19SEP2011		CHK: G. HOFENER 19SEP2011		APVD: T. ELBIN 19SEP2011		NAME: Ocean Side Feed Applicator	
MATERIAL: -		FINISH: -		WEIGHT: -		SCALE: 1:2		SHEET: 1 of 4		REV: G	

LOC	DIST	REV	DATE	BY	APPV
A	66				

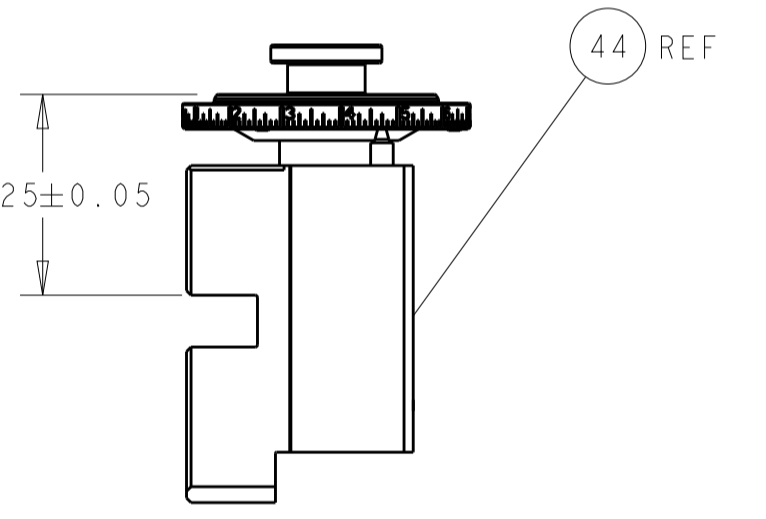
FEED TYPE MECHANICAL



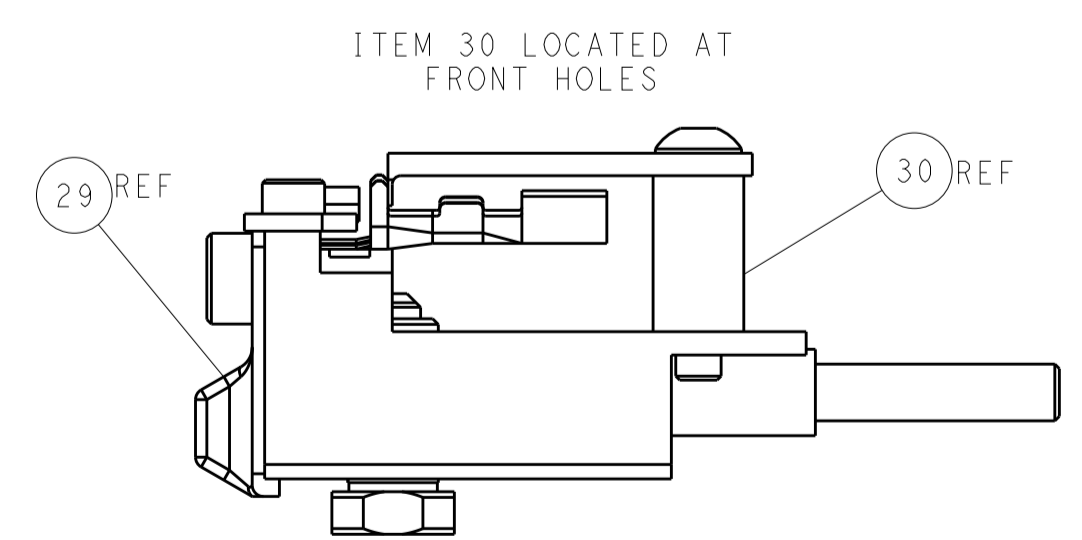
PNEUMATIC



TERMINAL SUPPORT LOCATION

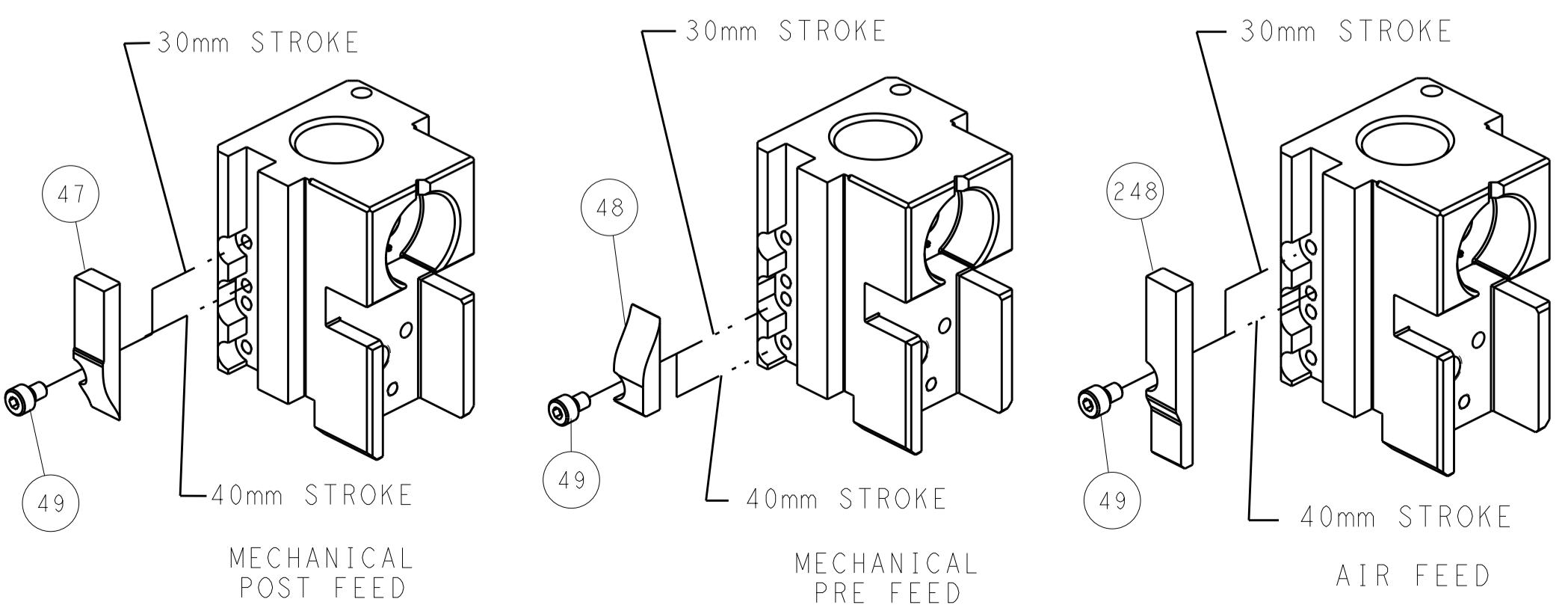


RAM SET-UP



ITEM 30 LOCATED AT FRONT HOLES

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 ±		DWN B. WEAVER 19SEP2011 CHK G. HOFFNER 19SEP2011 APVD T. ERLIN 19SEP2011 NAME Ocean Side Feed Applicator SIZE CAGE CODE DRAWING NO. RESTRICTED TO A1 00779 ©=2151320 Customer Accessible Production Drawing SCALE 1:2 SHEET 2 OF 4 REV G	
MATERIAL:		FINISH:		WEIGHT:	

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2151320-1	G	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2151320-2	G	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.
- 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).
- TERMINAL LUBRICANT IS RECOMMENDED.

LOC	DIST	REV	DATE	BY	CHK	APPV
A	66					

REV	DATE	BY	CHK	APPV	DESCRIPTION	ITEM NO
-	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			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			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	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	1			2119794-1 CRIMPER, INSUL F PREM, SPECIAL	3
-	1	1			2119797-2 SPACER, CRIMPER, SPECIAL	2
1	1	1			814590-2 CRIMPER, WIRE F PREMIUM	1

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

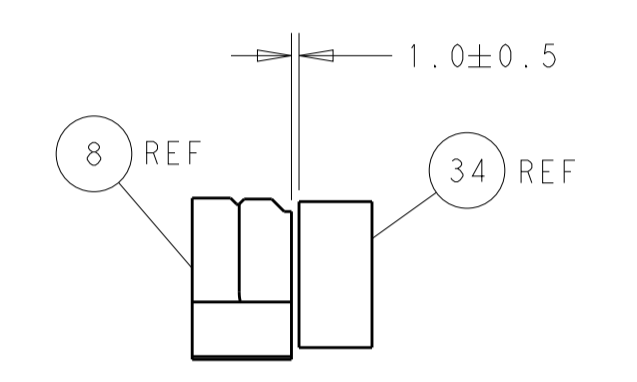
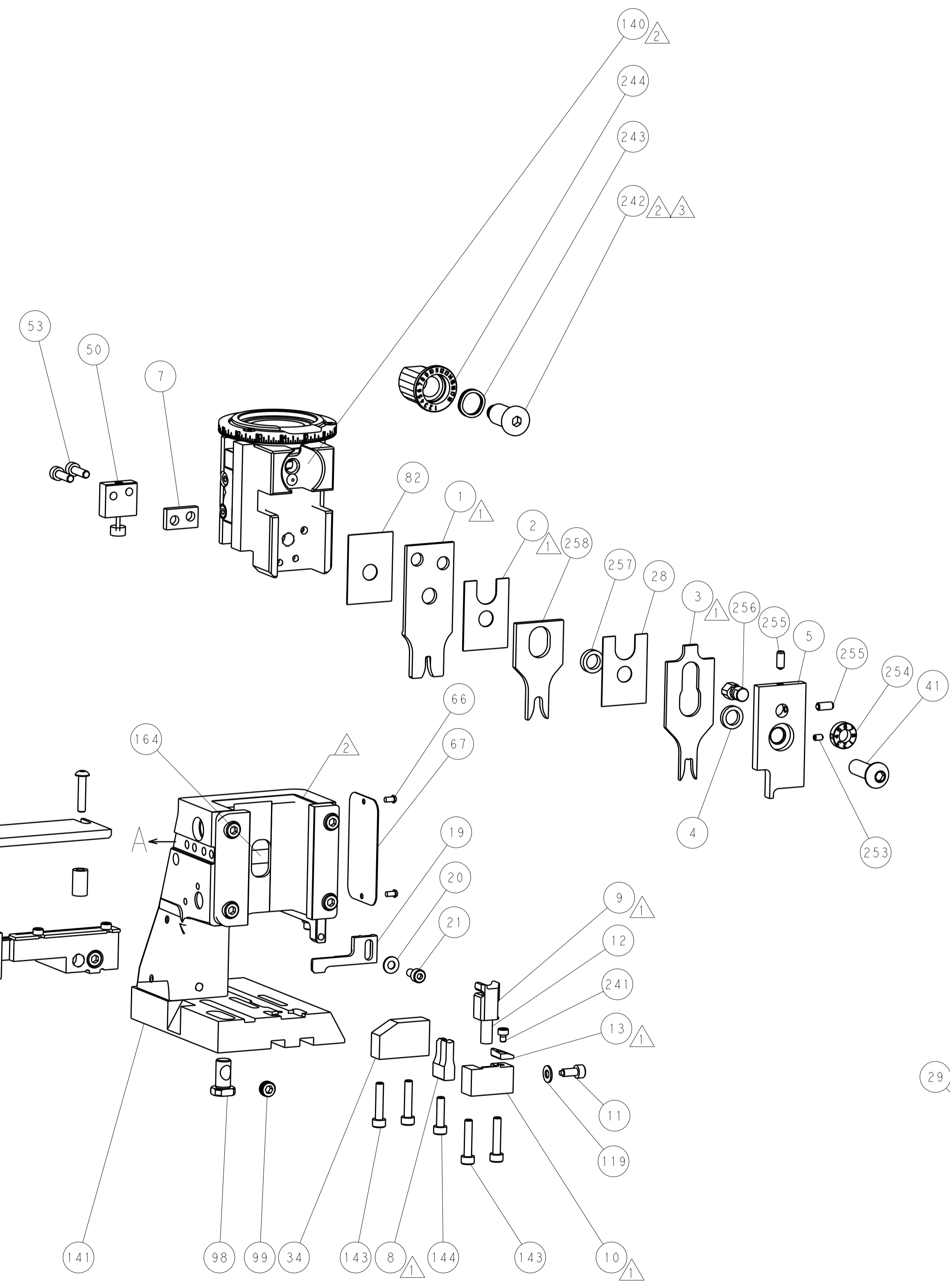
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DRAWING NO: 00779		SCALE: 1:2	
0 PLC	±	1 PLC	±	SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
2 PLC	±	3 PLC	±	APV	00779	©=2151320	REV G
4 PLC	±	ANGLES	±	WEIGHT	Customer Accessible Production Drawing		SHEET 3 OF 4
MATERIAL	FINISH						

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

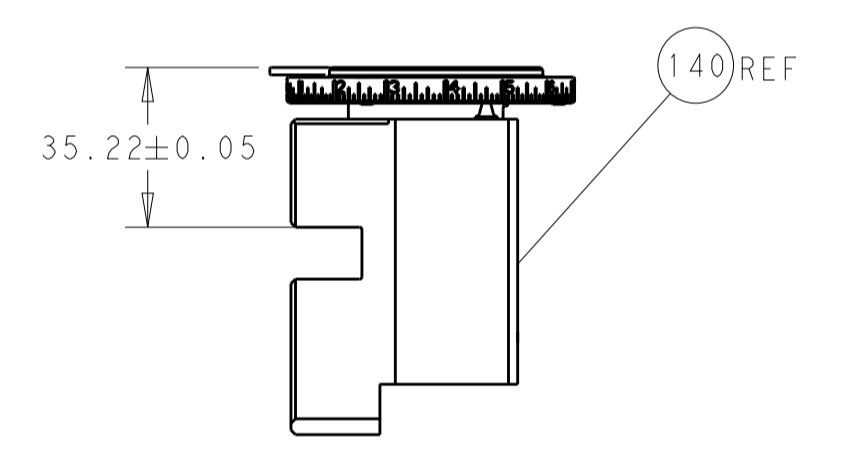
FEED TYPE MECHANICAL



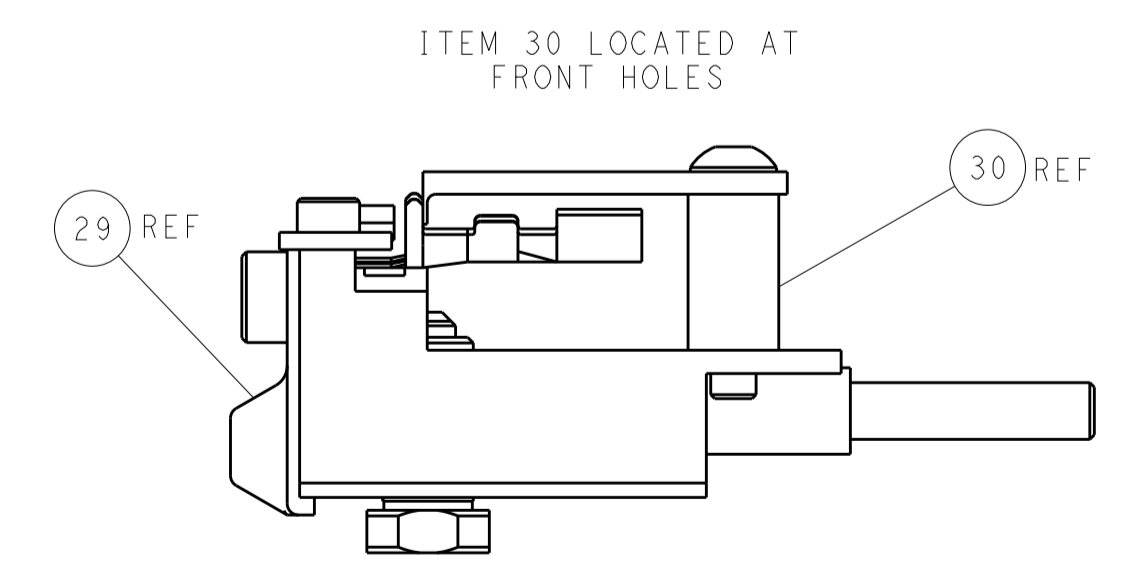
PNEUMATIC



TERMINAL SUPPORT LOCATION

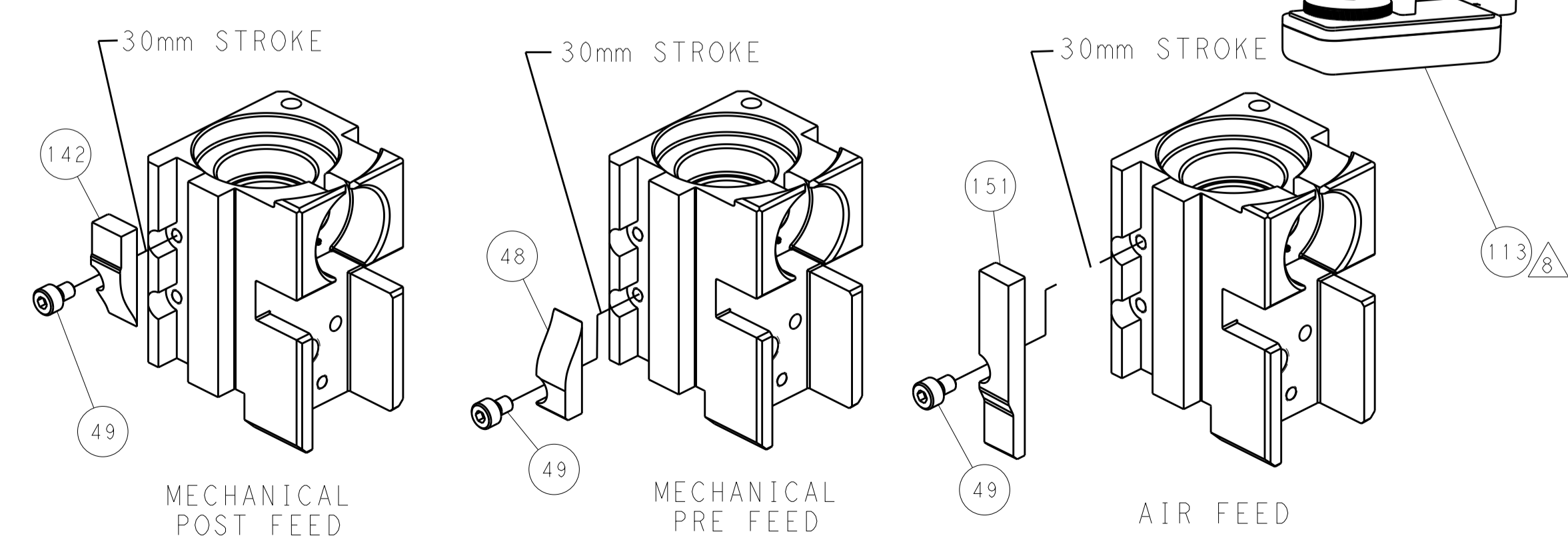


RAM SET-UP



FEED TRACK POSITION GUIDE BY INSULATION BARREL

CAM POSITIONS



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

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN B. WEAVER 19SEP2011		TE Connectivity	
mm	0 PLC	±		CHK G. HOFFNER 19SEP2011	NAME		Harrisburg, PA 17105-3608
	1 PLC	±		APVD T. ELBIN 19SEP2011	PRODUCT SPEC		
	2 PLC	±			APPLICATION SPEC		
	3 PLC	±			SIZE		CAGE CODE DRAWING NO
	4 PLC	±			WEIGHT		RESTRICTED TO
	ANGLES	±			MATERIAL		
	FINISH	±			Customer Accessible Production Drawing		
				SCALE 1:2		SHEET 4 OF 4 REV G	