

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151399-1	A	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2151399-2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151399-1	A	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2151399-2	A	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2151399-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.78 mm [.070]	F
INSUL	2.29 mm [.090]	F

APPLICATOR INSTRUCTIONS
408-35042

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: MULTILOCK 070 SRS CTC FOR NEW GEN CONN.			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
3.20-3.80 mm [.126-.150 IN]		Ø1.40-1.70 mm [.055-.067 IN]	
TERMINAL APPLICATION SPECIFICATION	114-20098		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
284087-1	284087-2		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.50mm2	1.09+/-0.03 [.043+/- .001]	6.9
0.35mm2	1.02+/-0.03 [.040+/- .001]	7.5

- 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.

***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
				1		DEVELOPMENT	11JAN2013	KH	SX
				2		REVISED	06NOV2019	FJ	YY
				A		RELEASED	19DEC2019	TB	TE

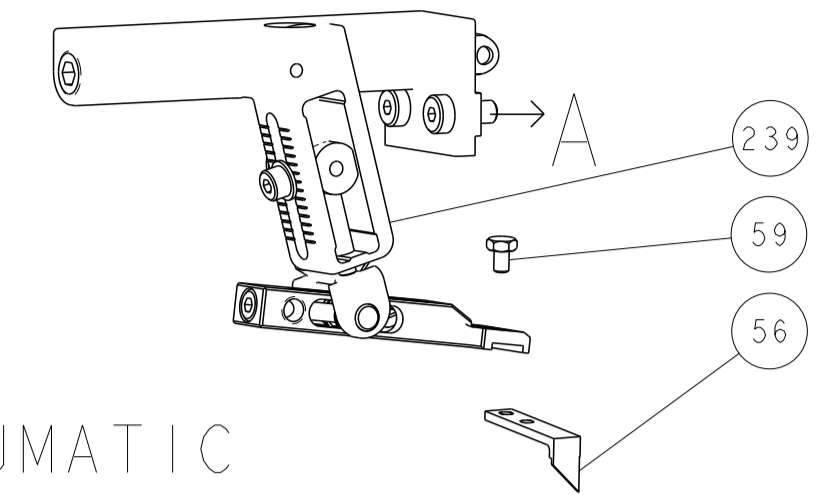
-	1	1	1	1	455888-5	SPACER, CRIMPER			285
-	1	-	1	-	2119641-1	FEED CAM, AIR FEED			248
-	1	1	1	1	2119082-8	CAM, SNAIL, INSULATION ADJUSTMENT			244
-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST			243
-	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL			242
-	1	1	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0			241
-	-	1	-	1	2119580-1	MECHANICAL FEED ASSEMBLY			239
-	1	-	1	-	2844940-1	AIR FEED MODULE			238
-	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC			164
-	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	1803607-3	DOCUMENTATION PACKAGE			71
-	1	1	1	1	2119791-5	DEPRESSOR, WIRE			70
-	1	1	1	1	2119943-1	WASHER, SPACER			69
-	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	1803382-6	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	1752356-3	SUPPORT, TERMINAL			34
-	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)			33
-	2	2	2	2	2-2844962-5	SPACER, CYLINDRICAL, STRIP GUIDE			30
-	1	1	1	1	2844992-1	ASSEMBLY, STRIP GUIDE			29
-	1	1	1	1	455888-3	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
-	2	2	2	2	1-18028-2	WASHER, FLAT, REG M4			20
-	1	1	1	1	2119533-3	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	1803095-6	FLOATING SHEAR, FRONT			9
1	2	2	1	1	1338692-4	ANVIL, COMBINATION .070			8
-	-	-	-	-	-	-			7
-	-	-	-	-	-	-			6
-	1	1	1	1	2119757-8	DEPRESSOR, SHEAR			5
-	1	1	1	1	238011-4	BLOCK, CRIMPER SPACER			4
1	2	2	1	1	1803016-9	CRIMPER, INSULATION F			3
-	1	1	1	1	455888-6	SPACER, CRIMPER			2
1	2	2	1	1	3-456404-2	CRIMPER, WIRE PREMIUM			1
-	77	-72	-71	-2	-1	PART NO			ITEM NO

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		MATERIAL:		FINISH:		WEIGHT:		CUSTOMER DRAWING:	
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	1 PLC	±									
	2 PLC	±									
	3 PLC	±									
	4 PLC	±									
	ANGLES	±									

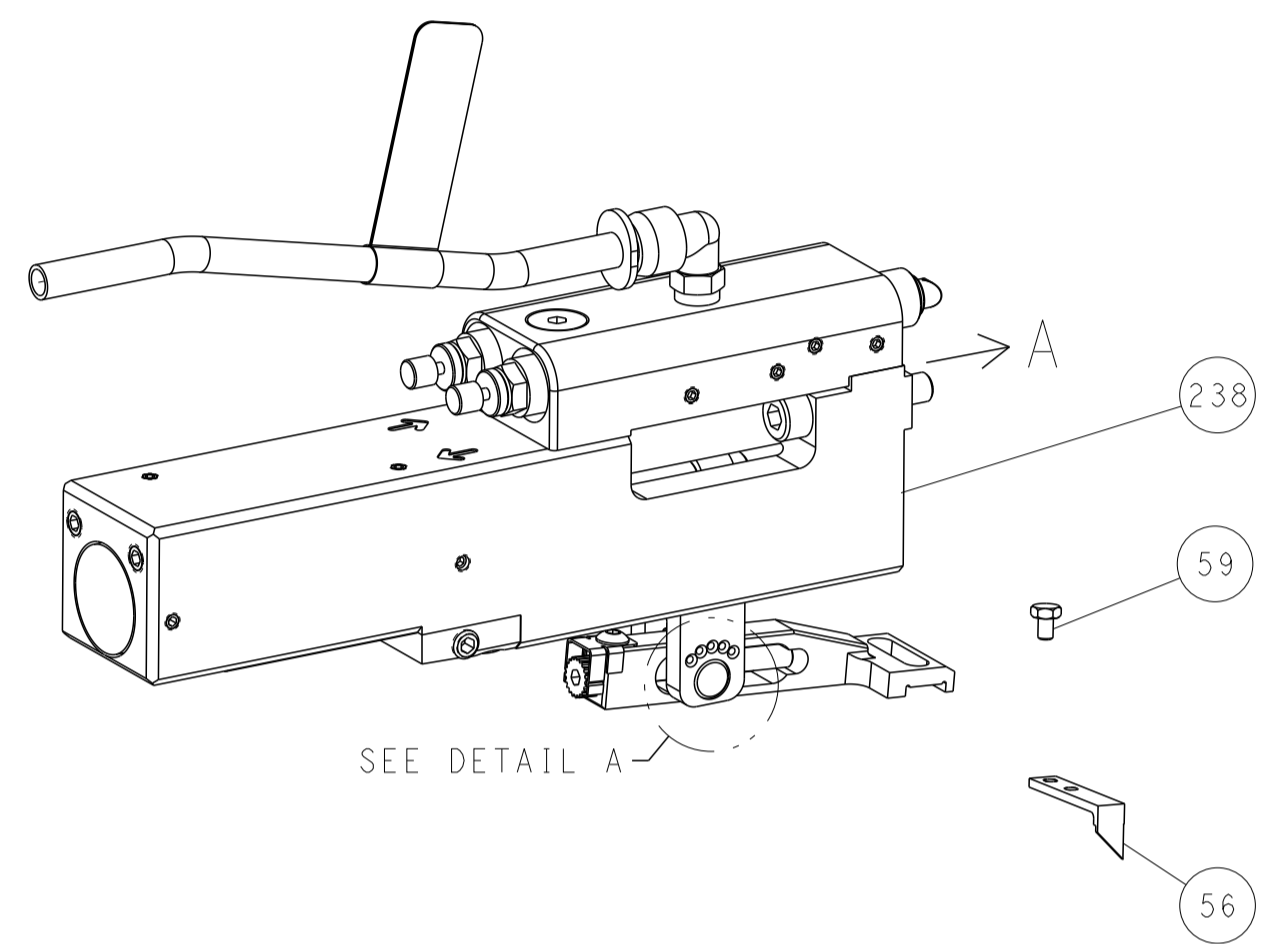
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CHK	S. XI	11JAN2013	
APVD	S. XI	11JAN2013	
NAME	Ocean Side Feed Applicator		
SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
A1	00779	2151399	
SCALE		SHEET	REV
1:2		1 OF 4	A

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

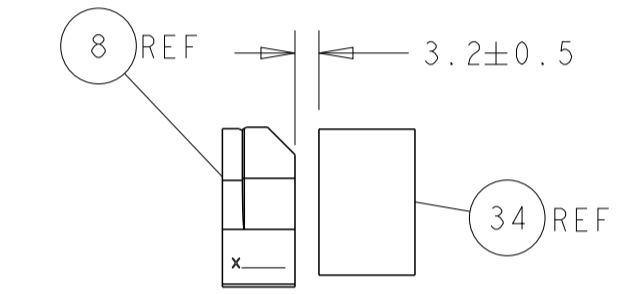
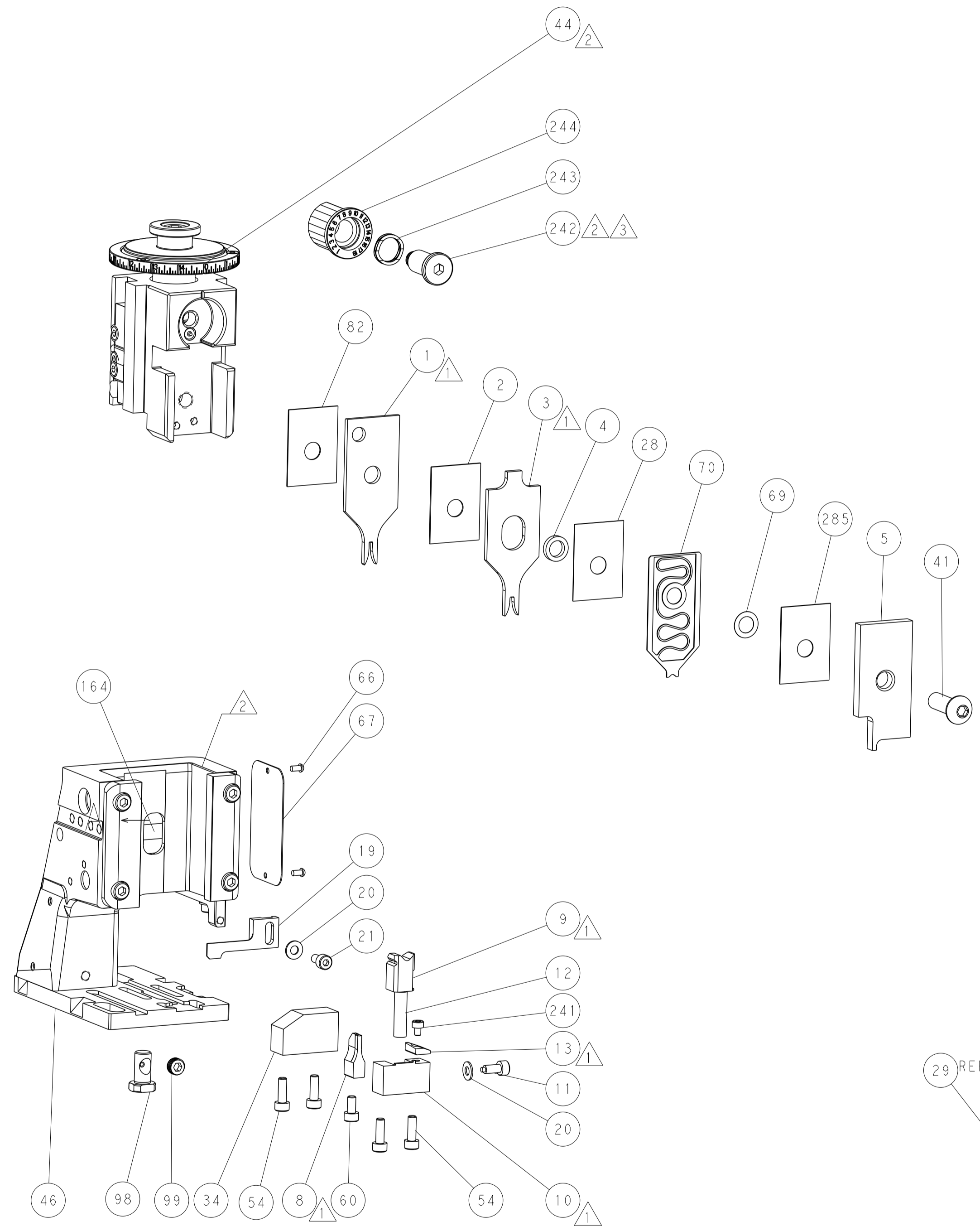
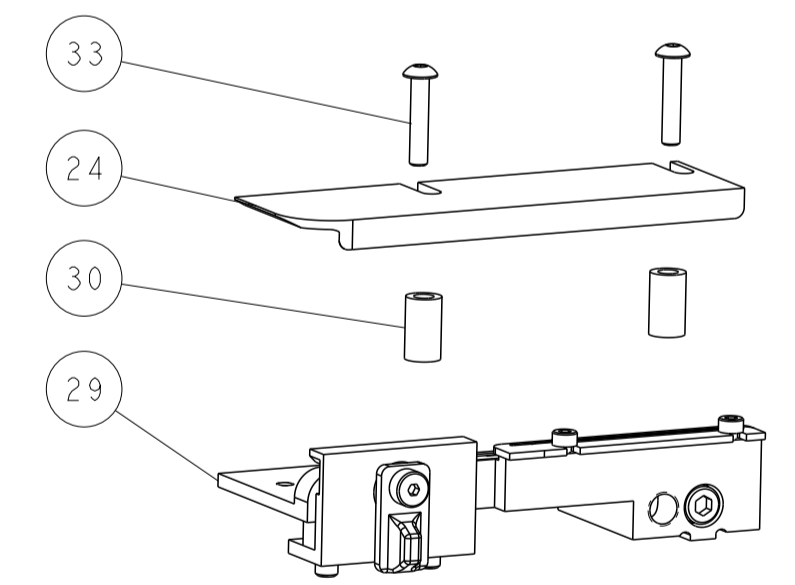
FEED TYPE MECHANICAL



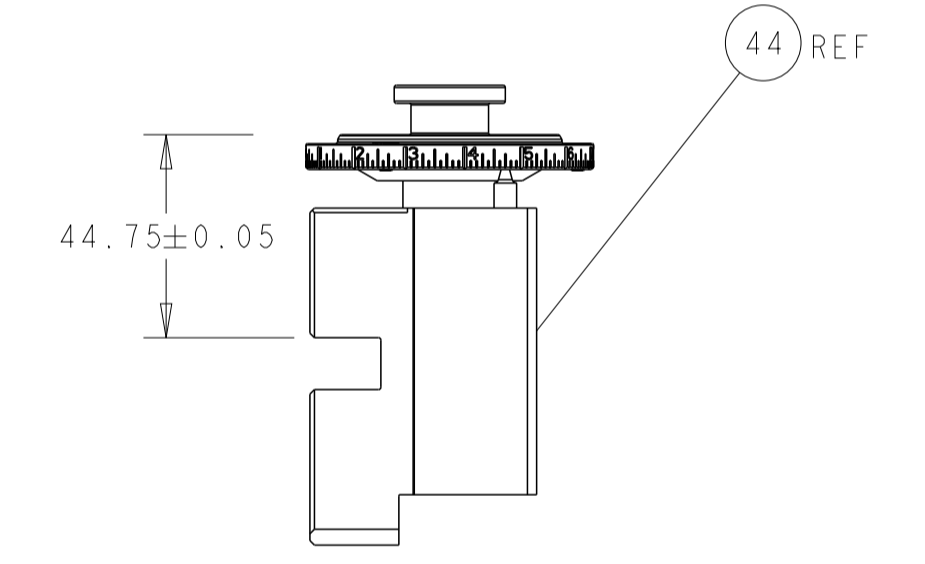
PNEUMATIC



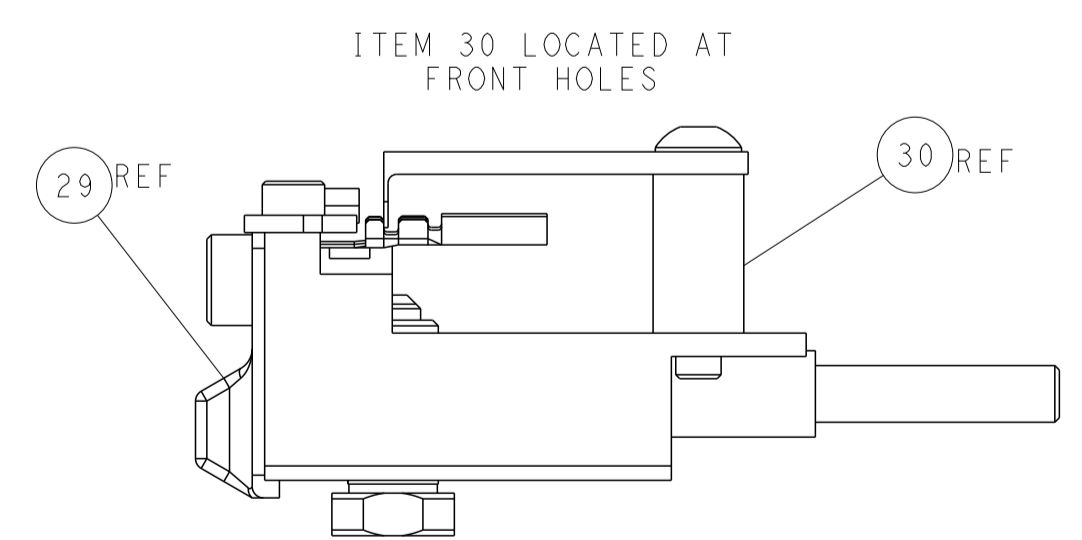
FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



TERMINAL SUPPORT LOCATION

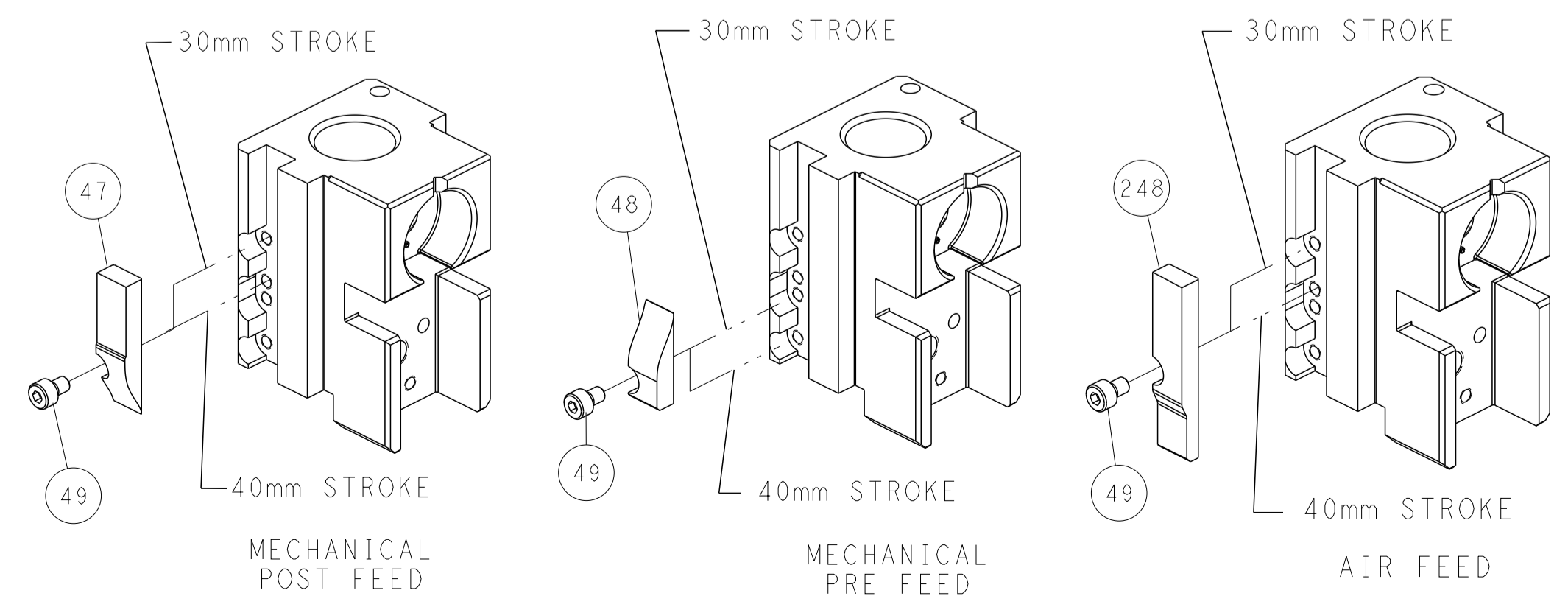


RAM SET-UP



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)

<small>THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.</small>		DWN: H. HUANG 11JAN2013 CHK: S. XI 11JAN2013 APVD: S. XI 11JAN2013	NAME: TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH	PRODUCT SPEC APPLICATION SPEC WEIGHT CUSTOMER DRAWING	SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2151399	RESTRICTED TO: - SCALE: 1:2 SHEET: 2 of 4 REV: A

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2151399-1	A	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2151399-2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151399-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
 INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.78 mm [.070]	F
INSUL	2.29 mm [.090]	F

APPLICATOR INSTRUCTIONS
 408-35042

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: MULTILOCK 070 SRS CTC FOR NEW GEN CONN.			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
3.20-3.80 mm [1.26-.150 IN]		∅1.40-1.70 mm [0.055-.067 IN]	
TERMINAL APPLICATION SPECIFICATION	114-20098	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
284087-1	284087-2		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.50mm2	1.09 +/- 0.03 [0.043 +/- .001]	6.9
0.35mm2	1.02 +/- 0.03 [0.040 +/- .001]	7.5



- 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. 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					
A	66	P	LTN	DESCRIPTION	DATE	OWN	APVD
-	-	-	-	SEE SHEET 1	-	-	-

-	1	1	455888-5	SPACER, CRIMPER	285
-	1	1	2119082-8	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
-	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	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	1	2844908-1	SCREW, LOCKING	99
-	1	1	2844907-1	POST, LOCKING	98
-	1	1	455888-5	SPACER, CRIMPER	82
-	1	1	1803607-3	DOCUMENTATION PACKAGE	71
-	1	1	2119791-5	DEPRESSOR, WIRE	70
-	1	1	2119943-1	WASHER, SPACER	69
-	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	1803382-6	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	1752356-3	SUPPORT, TERMINAL	34
-	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	2-2844962-5	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29
-	1	1	455888-3	SPACER, CRIMPER	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	2119533-3	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	1803095-6	FLOATING SHEAR, FRONT	9
-	1	1	1338692-4	ANVIL, COMBINATION .070	8
-	-	-	-	-	7
-	-	-	-	-	6
-	1	1	2119757-8	DEPRESSOR, SHEAR	5
-	1	1	238011-4	BLOCK, CRIMPER SPACER	4
-	1	1	1803016-9	CRIMPER, INSULATION F	3
-	1	1	455888-6	SPACER, CRIMPER	2
-	1	1	3-456404-2	CRIMPER, WIRE PREMIUM	1

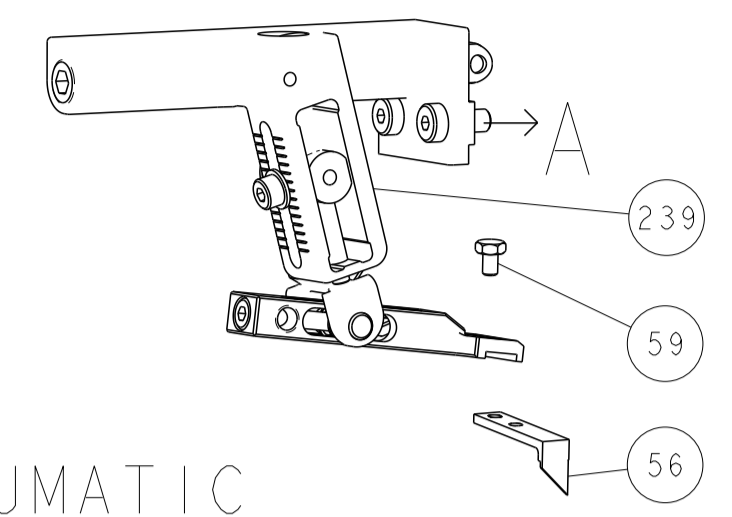
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mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES	FINISH

ITEM NO	DESCRIPTION	DATE	BY	CHK
-77	-22	-21	PART NO	DESCRIPTION

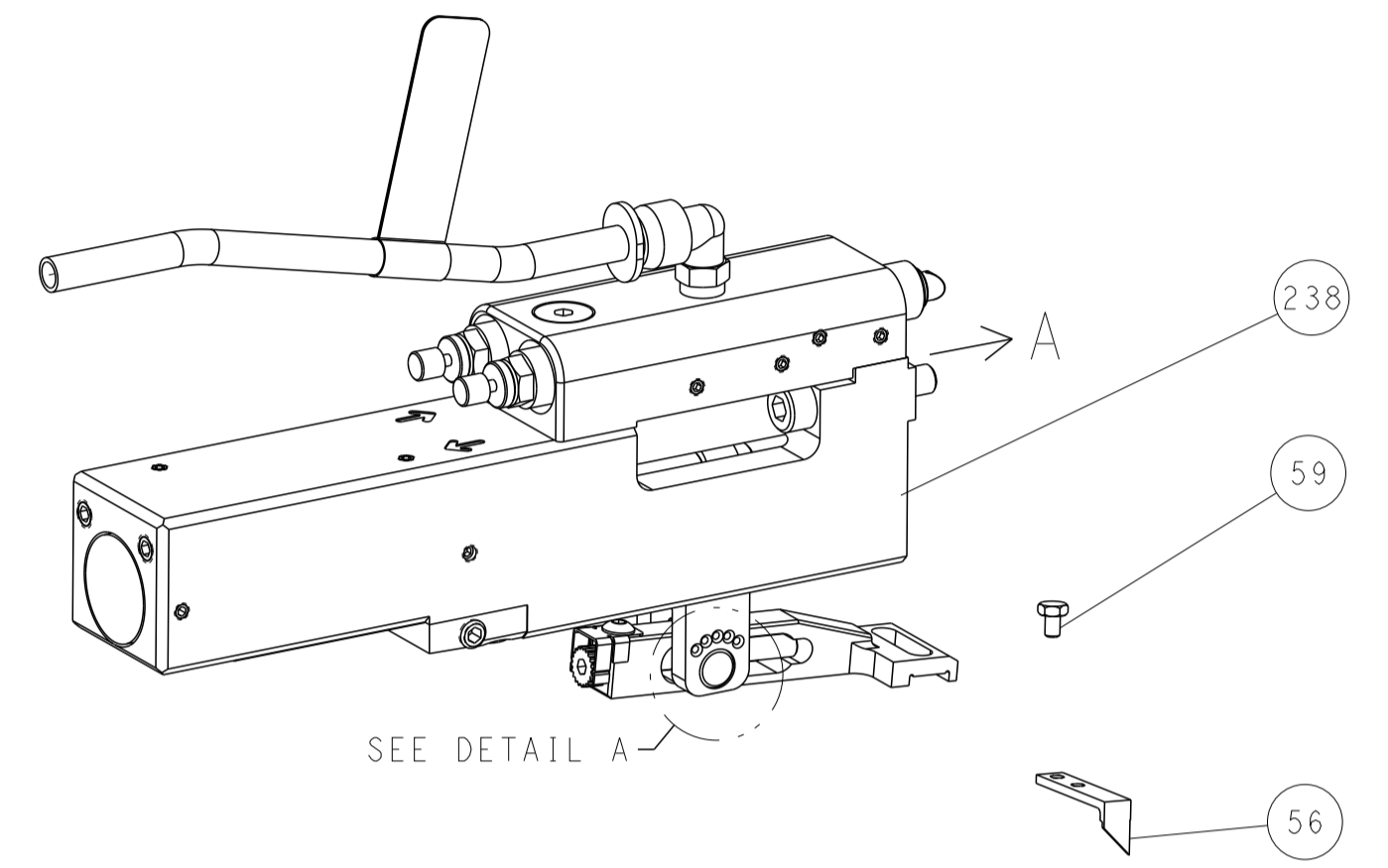
APVD	S. XI	11JAN2013	NAME	Ocean Side Feed Applicator	
CHK	H. HUANG	11JAN2013	SIZE	A1	
OWN	S. XI	11JAN2013	CAGE CODE	00779	
TE Connectivity	Harrisburg, PA 17105-3608	DRAWING NO	©=2151399	SCALE	1:2
CUSTOMER DRAWING		SHEET 3 OF 4		REV	A

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

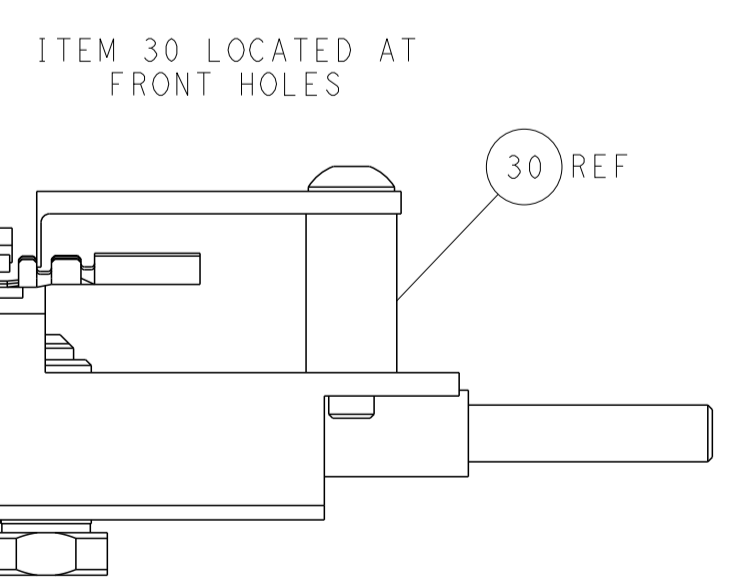
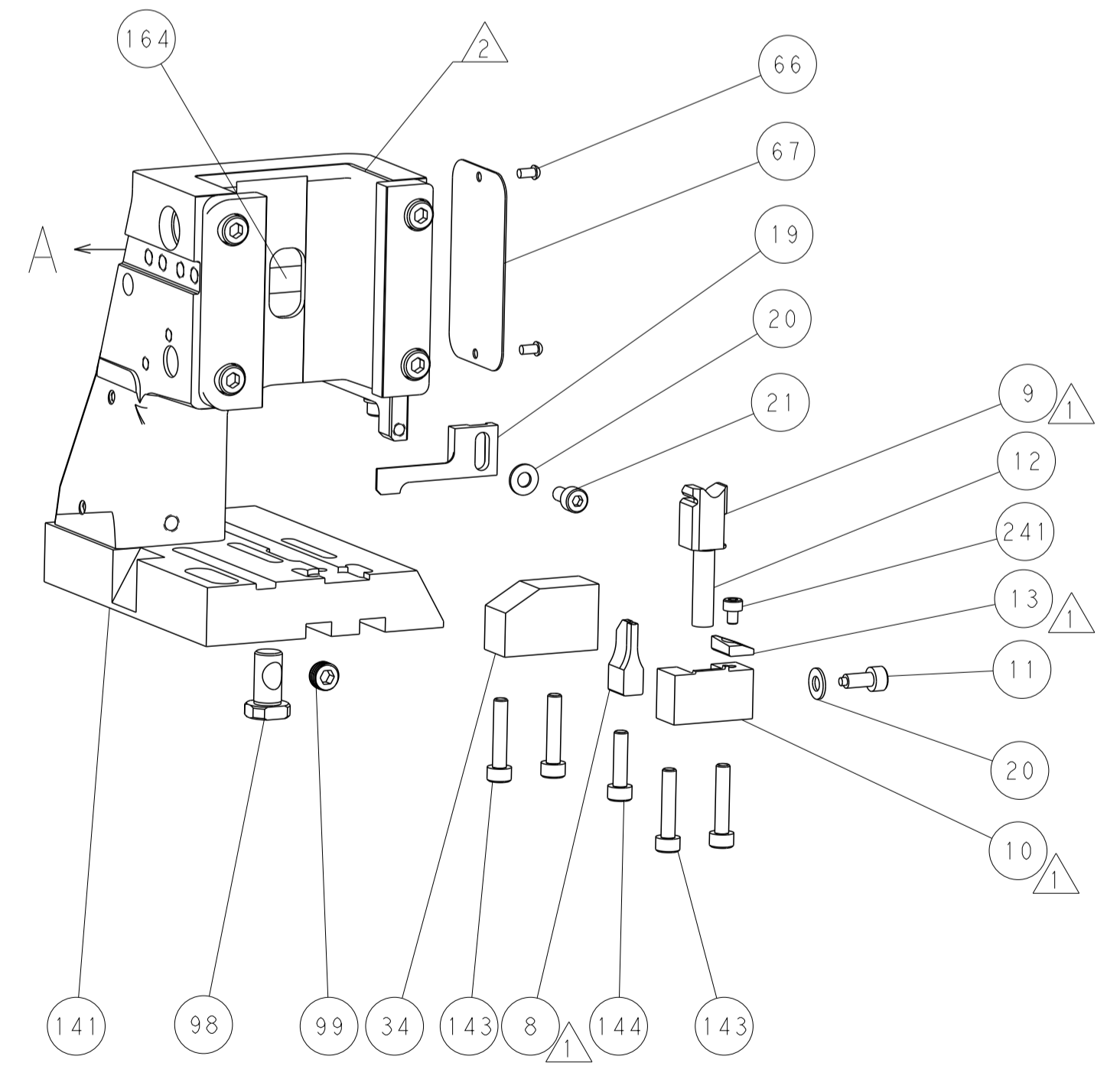
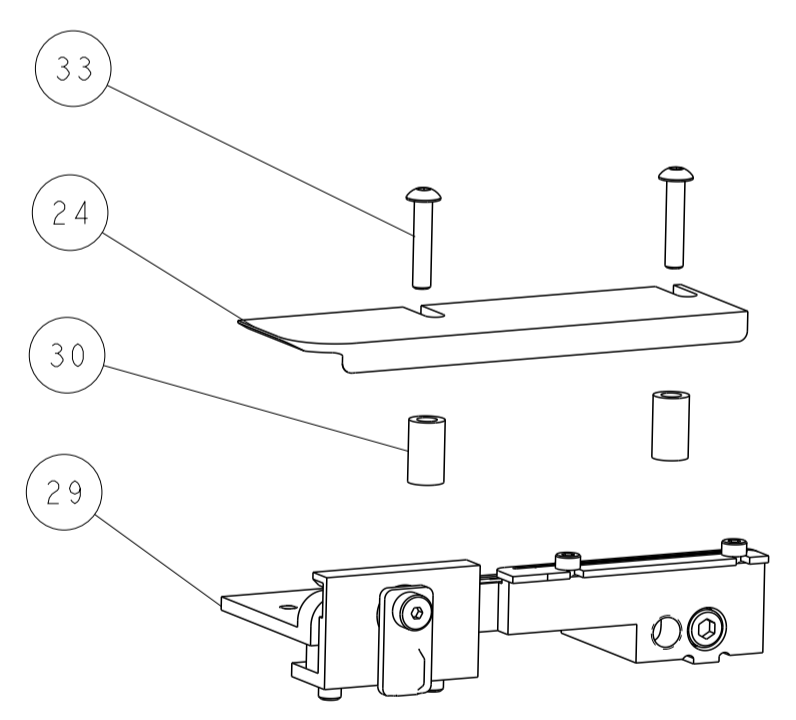
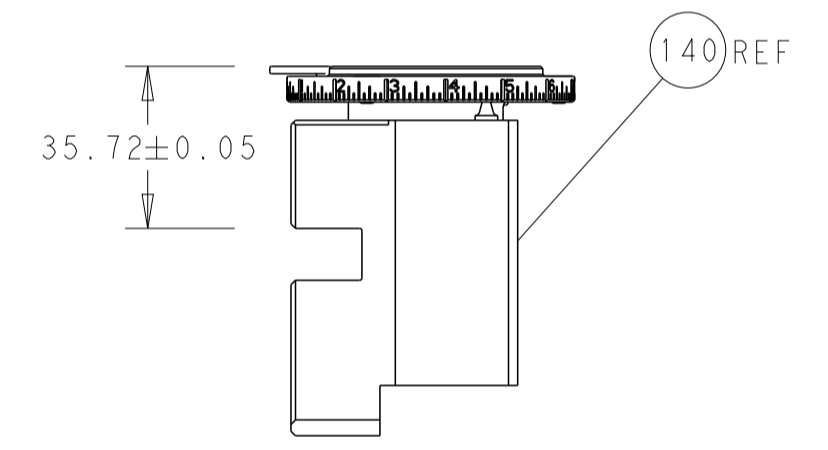
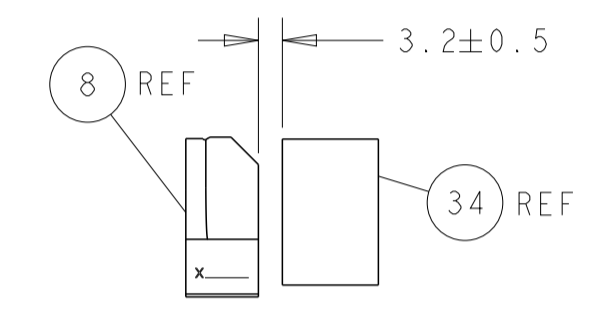
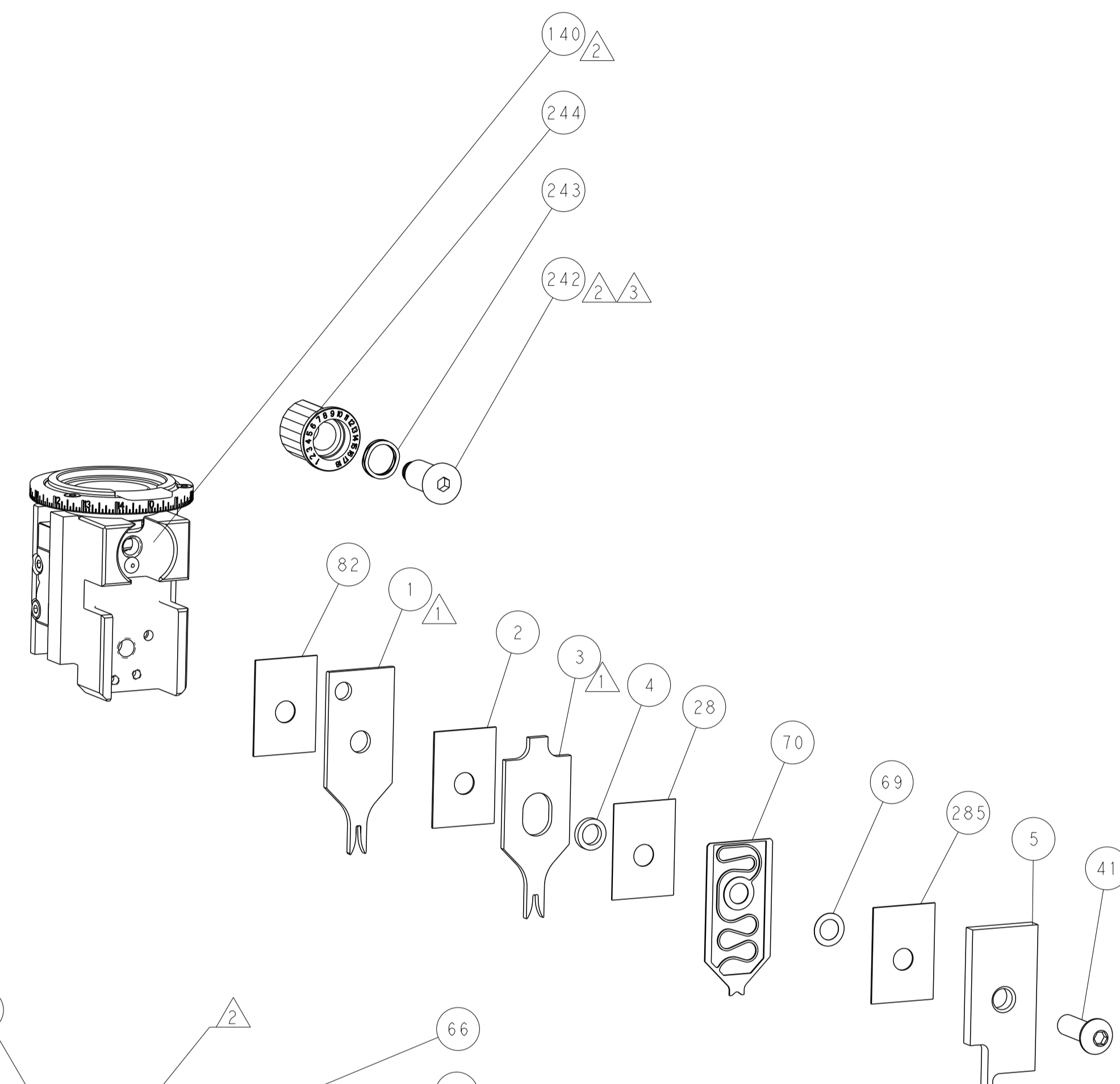
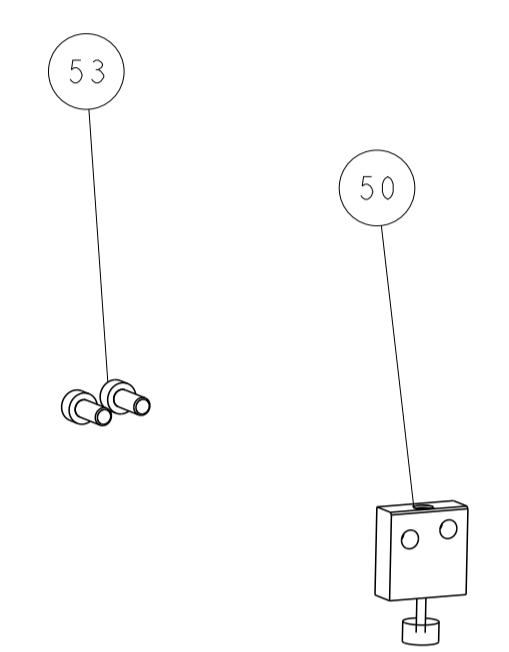
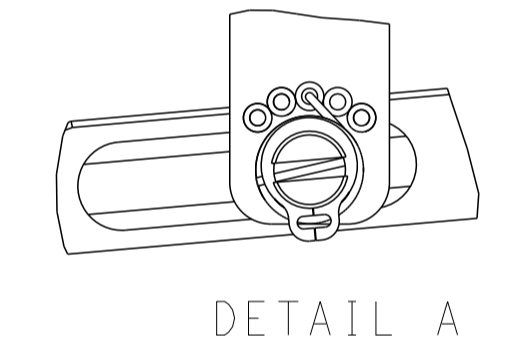
FEED TYPE MECHANICAL



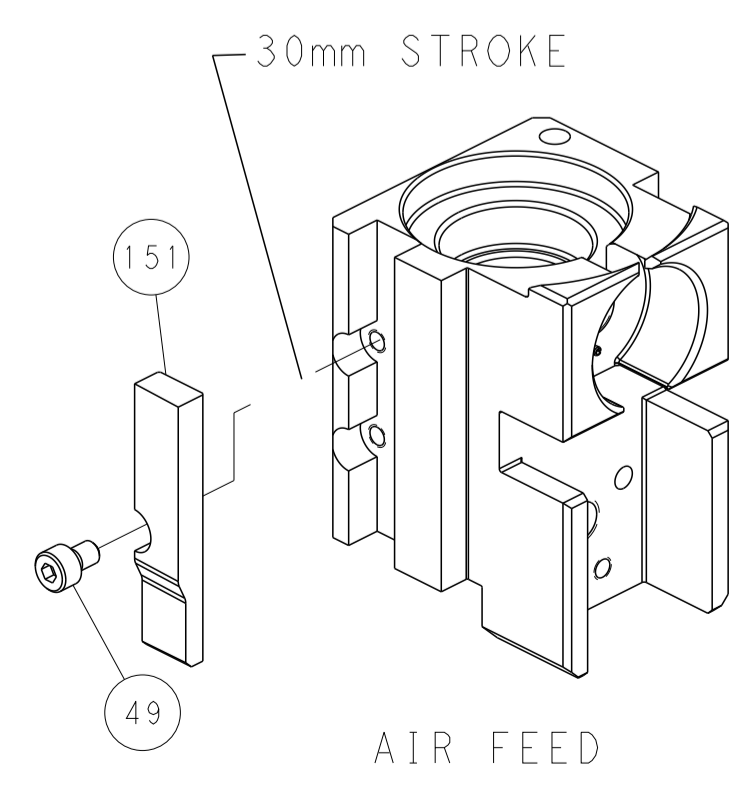
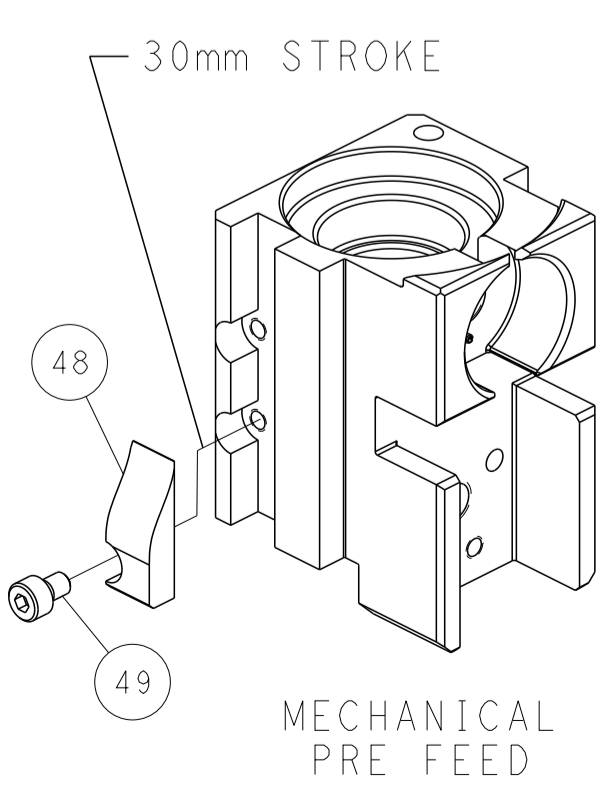
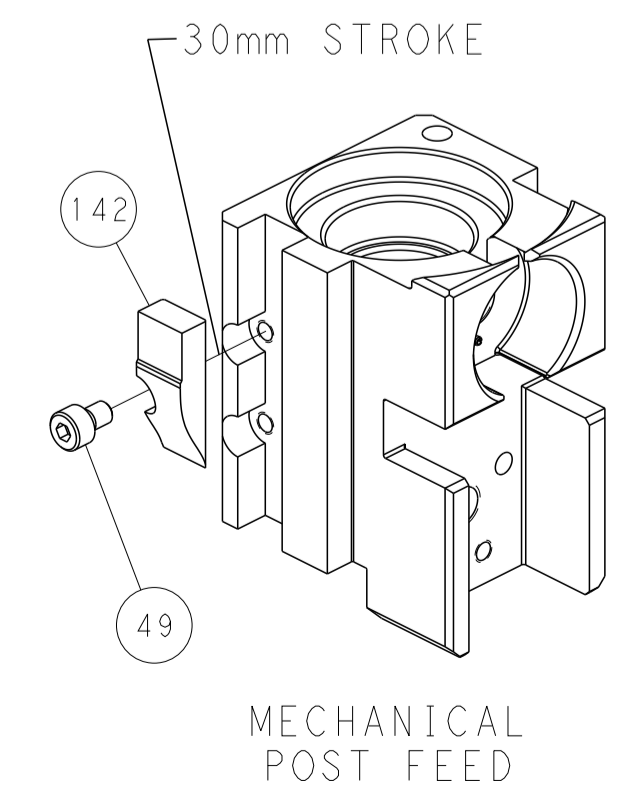
PNEUMATIC



FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



CAM POSITIONS



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 ±		NAME: Ocean Side Feed Applicator PRODUCT SPEC: - APPLICATION SPEC: - WEIGHT: - CUSTOMER DRAWING: -	SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2151399 RESTRICTED TO: -
MATERIAL: - FINISH: -		SCALE: 1:2 SHEET: 4 OF 4 REV: A	SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION