

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151123-1	E	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2151123-2	E	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
5-2151123-1	E	SEAL STRIPPER CRIMPER TERMINATING UNIT	MECHANICAL
5-2151123-2	E	SEAL STRIPPER CRIMPER TERMINATING UNIT	PNEUMATIC
7-2151123-1	E	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2151123-2	E	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2151123-7	B	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.57 mm [.062]	F
INSUL	3.30 mm [.130]	O

APPLICATOR INSTRUCTIONS 408-35042

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: MINI AMP-IN 2000			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
4.70-5.46 mm [.185-.215 IN]		1.27-2.79 mm [.050-.110 IN]	
TERMINAL APPLICATION SPECIFICATION	114-1016		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
794121-1	3-794121-1		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
18 AWG	0.91 +/- 0.05 [.036 +/- .002]	7.4
20 AWG	0.86 +/- 0.05 [.034 +/- .002]	7.9
22 AWG	0.76 +/- 0.05 [.030 +/- .002]	8.9

- 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 180.
- 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.
- TERMINAL SUPPORT ONLY REQUIRED FOR BT VERSIONS, 5-2151123-1 OR 5-2151123-2
- 6. 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.

LOC	DIST	REVISIONS					
A	66	P	LTN	DESCRIPTION	DATE	OWN	APVD
		B		ECR-15-003642	05MAR2015	MR	TE
		C		ECR-18-015856	07OCT2018	TB	TE
		D		ECR-21-116249	06OCT2021	LG	TE
		E		ECR-179853	29JUN2023	JWC	GB

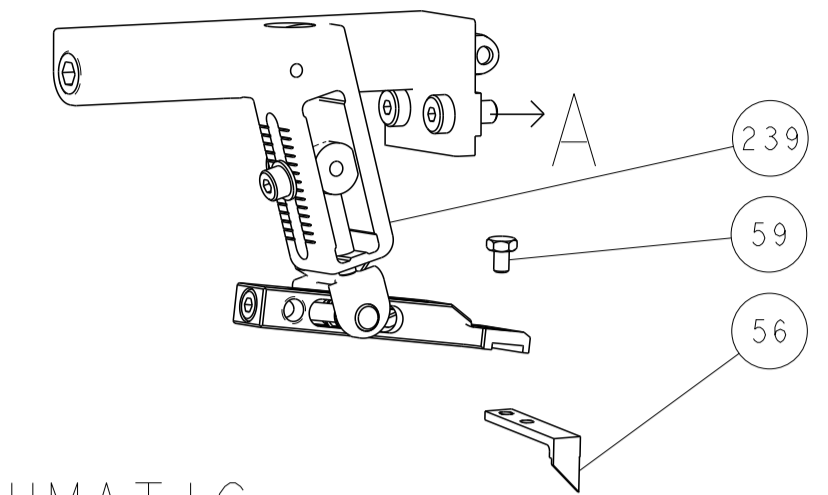
-	-	-	1	1	-	-	1803515-3	RAM ASSEMBLY, SF ATLANTIC	293
-	-	-	1	1	-	-	2-1803583-1	APPLICATOR BASIC ASSEMBLY, SF	292
-	1	-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248
-	1	1	1	1	1	1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
	-	1	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	1	1	1	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
-	-	1	-	1	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	1	-	1	-	1	-	2844940-1	AIR FEED MODULE	238
-	-	-	1	1	-	-	4-1722335-3	STRIPPER, SIDE FEED	182
	-	-	-	1	1	-	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	181
-	-	-	-	1	1	-	1-1752354-9	STANDOFF, HOLD-DOWN	180
-	-	-	-	1	1	-	993111-1	PIN, SLOTTED SPRING 3.0 X 20.0	177
-	-	-	-	1	1	-	5-22280-0	SPRING, COMPRESSION	176
-	-	-	-	1	1	-	1752353-3	GUIDE PIN, HOLDDOWN	175
-	-	-	-	1	1	-	1901680-2	GUIDE PIN, HOLDDOWN	174
-	REF	REF	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
	-	1	1	1	1	1	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113
-	1	1	1	1	1	1	2844908-1	SCREW, LOCKING	99
-	1	1	1	1	1	1	2844907-1	POST, LOCKING	98
-	1	1	1	1	1	1	455888-6	SPACER, CRIMPER	82
-	1	1	1	1	1	1	1803607-3	DOCUMENTATION PACKAGE	71
-	1	1	1	1	1	1	2119740-1	TAG, IDENTIFICATION	67
-	2	2	2	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	1	1	1	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	60
-	1	1	1	1	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	1	1	1	1	1	1	1338685-1	PAWL, FEED	56
-	2	2	4	4	2	2	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	54
-	1	2	1	2	1	2	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	-	1	-	1	-	1	2119652-1	FEED CAM, PRE FEED	48
-	-	1	-	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	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
	-	-	-	1	1	-	1752356-1	SUPPORT, TERMINAL	34
-	2	2	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	2	2	2	2	2-2844962-4	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	1	1	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29
-	1	1	1	1	1	1	455888-4	SPACER, CRIMPER	28
-	1	1	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	1	1	2	2	1-18028-2	WASHER, FLAT, REG M4	20
-	1	1	-	-	1	1	2119533-1	STRIPPER, SIDE FEED	19
	-	1	1	1	1	1	2119806-1	INSERT, SHEAR	13
-	1	1	1	1	1	1	3-22280-3	SPRING, COMPRESSION	12
-	1	1	1	1	1	1	1-356885-4	STOP, SHEAR	11
	-	1	1	1	1	1	2119805-1	SHEAR HOLDER, FRONT	10
	-	1	1	1	1	1	454276-5	FLOATING SHEAR, FRONT	9
	1	2	2	1	1	1	1333230-2	ANVIL, COMBINATION	8
-	1	1	1	1	1	1	2119757-4	DEPRESSOR, SHEAR	5
-	1	1	1	1	1	1	238011-8	BLOCK, CRIMPER SPACER	4
	1	2	2	1	1	1	1-1633965-0	CRIMPER, INSULATION O PREMIUM	3
-	1	1	1	1	1	1	1-455888-1	SPACER, CRIMPER	2
	1	2	2	1	1	1	3-456403-3	CRIMPER, WIRE PREMIUM	1

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

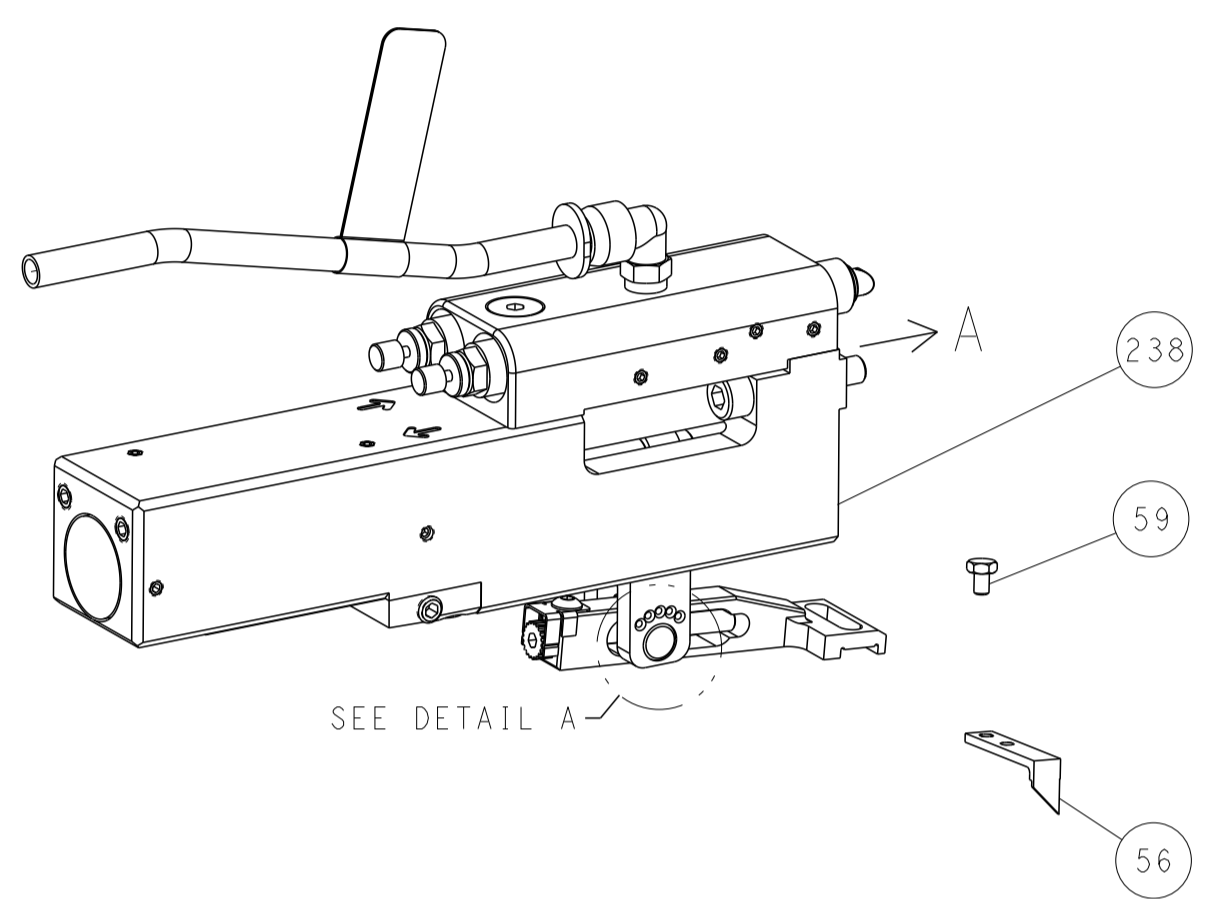
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0 PLC ±		1 PLC ±		APVD: J. CRUZ 16JUN2011		PRODUCT SPEC		SIZE: A1	
2 PLC ±		3 PLC ±		APPLICATION SPEC		CAGE CODE		DRAWING NO: 00779	
4 PLC ±		ANGLES ±		WEIGHT		SCALE: 1:2		SHEET 1 OF 4	
FINISH		MATERIAL		RESTRICTED TO		CUSTOMER ACCESSIBLE PRODUCTION DRAWING		REV: E	

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

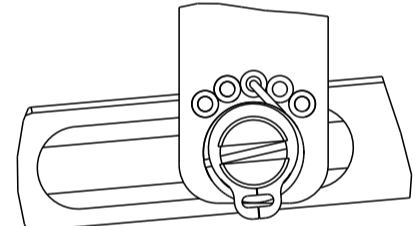
# FEED TYPE MECHANICAL



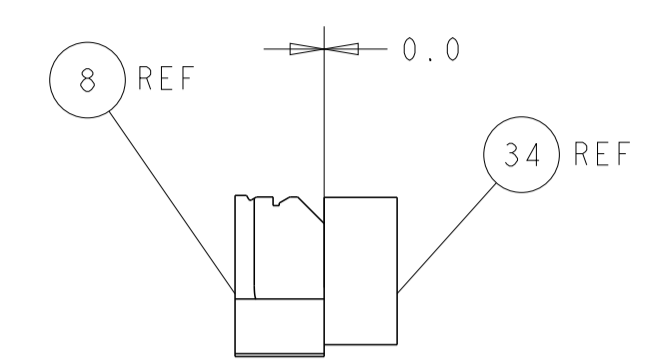
## PNEUMATIC



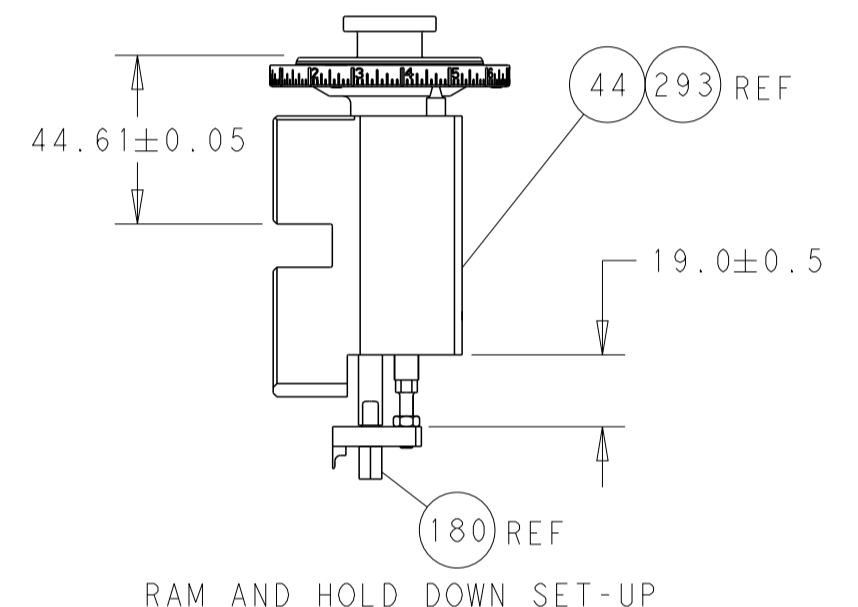
### FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



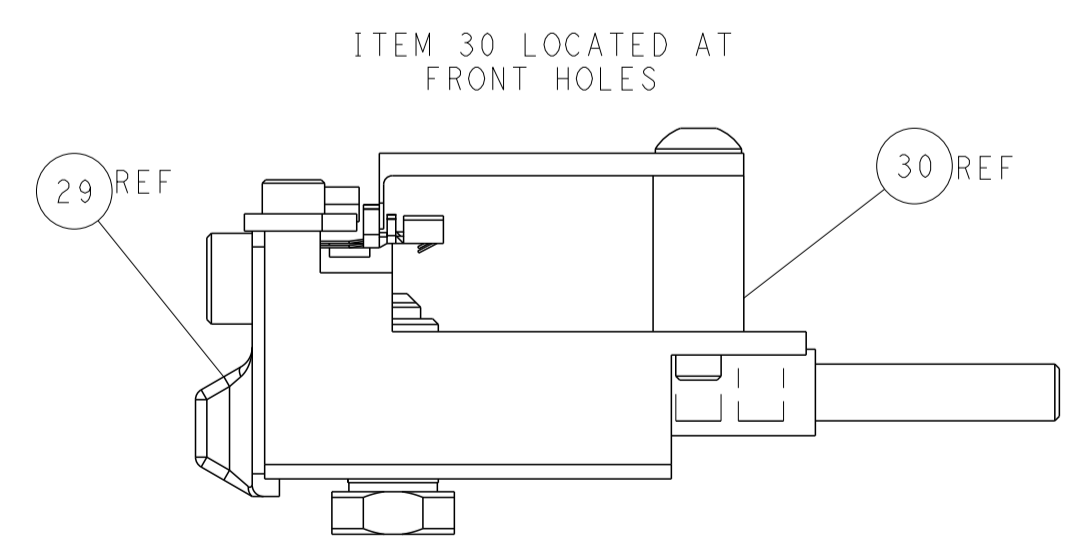
DETAIL A



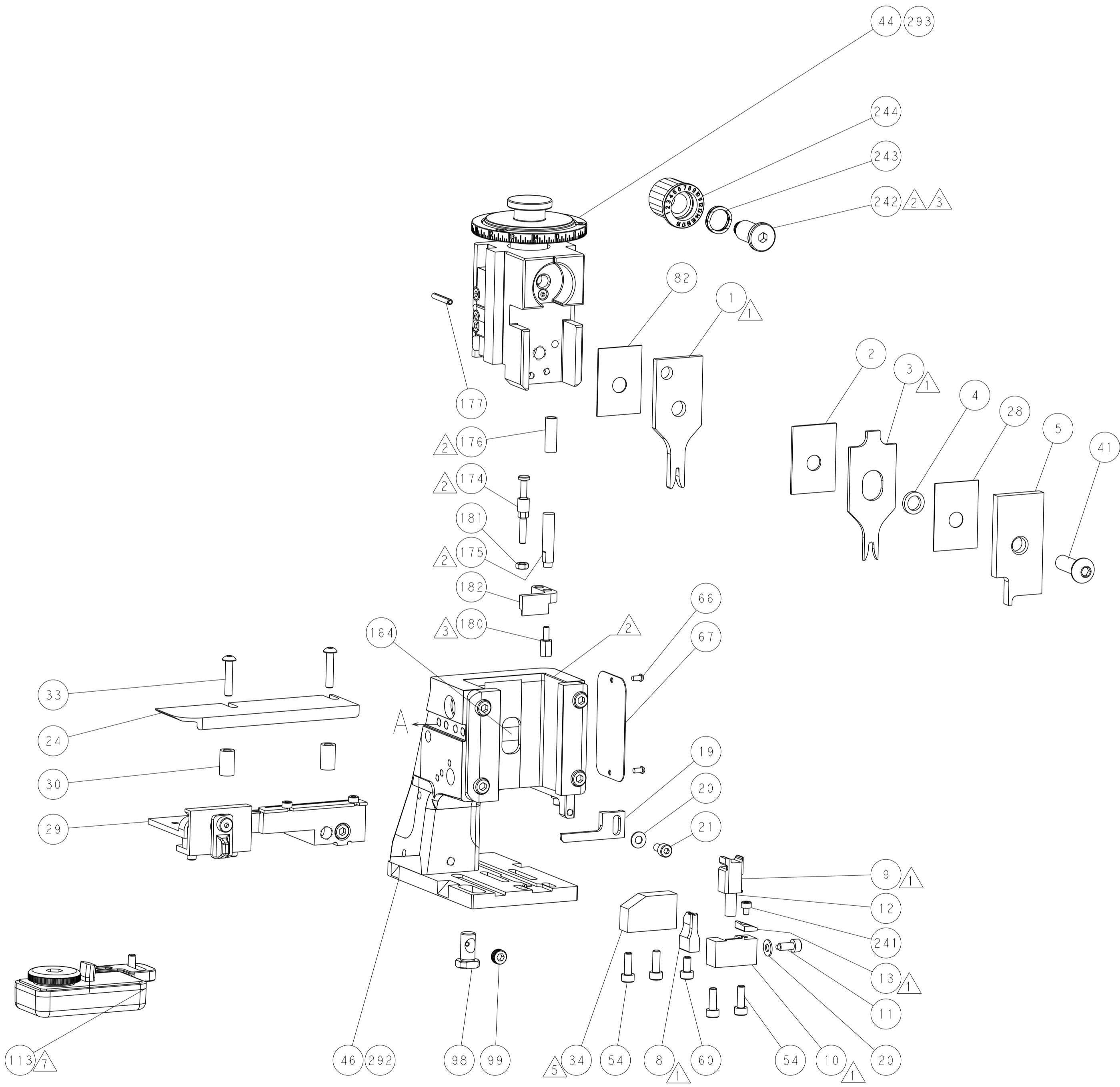
△ TERMINAL SUPPORT SET-UP  
 TERMINAL SUPPORT ONLY REQUIRED FOR BT VERSIONS, 5-2151123-1 OR 5-2151123-2



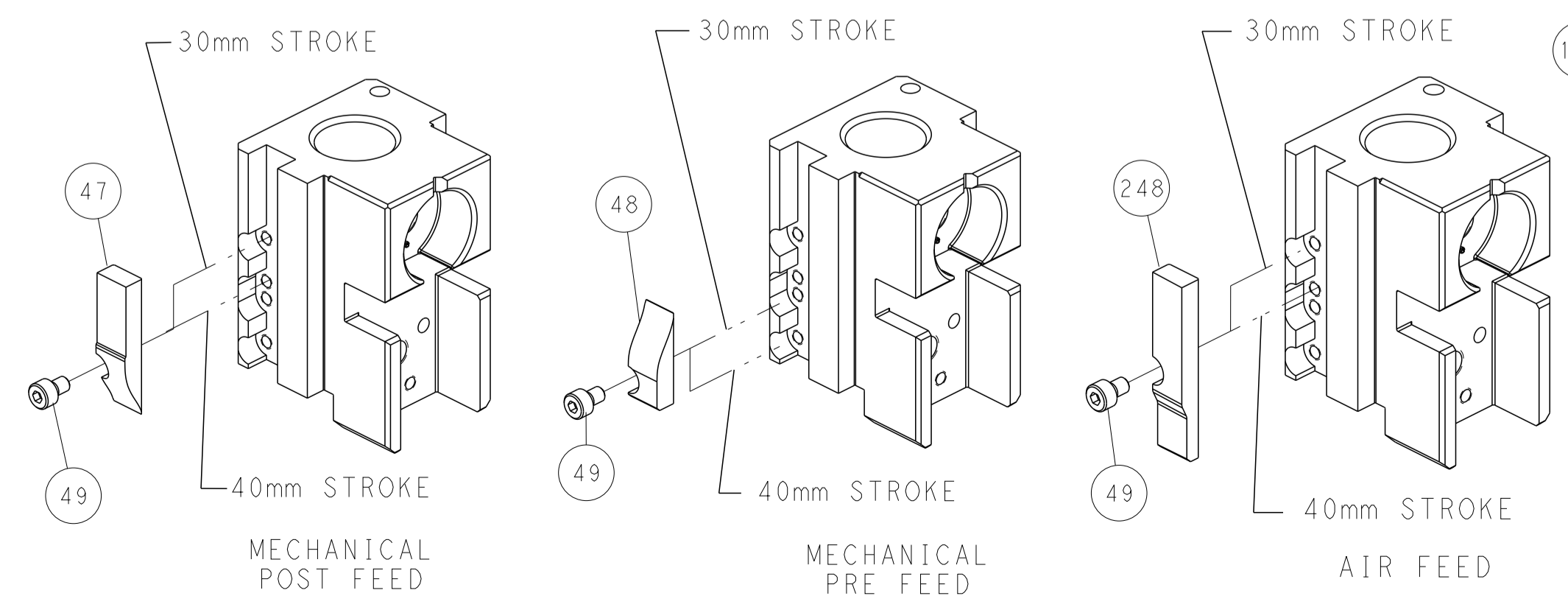
RAM AND HOLD DOWN SET-UP



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:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DMN X.ZHAO 16JUN2011	TE Connectivity Harrisburg, PA 17105-3608
mm	0 PLC ±	1 PLC ±	2 PLC ±	CHK S.XI 16JUN2011	
MATERIAL:		FINISH:		APVD J. CRUZ 16JUN2011	NAME Ocean Side Feed Applicator
-		-		PRODUCT SPEC	SIZE CAGE CODE DRAWING NO
-		-		APPLICATION SPEC	A1 00779 C=2151123
-		-		RESTRICTED TO	Customer Accessible Production Drawing
-		-		SCALE 1:2	SHEET 2 OF 4 REV E

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2151123-1	E	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2151123-2	E	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151123-7	B	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR  
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.57 mm [.062]	F
INSUL	3.30 mm [.130]	O

APPLICATOR INSTRUCTIONS  
408-35042

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION
TERMINAL NAME: MINI AMP-IN 2000		
WIRE STRIP LENGTH 4.70-5.46 mm [1.85-.215 IN]		INSULATION DIAMETER RANGE Ø1.27-2.79 mm [0.050-.110 IN]
TERMINAL APPLICATION SPECIFICATION 114-1016	-	-
TERMINALS APPLIED		
TE TERMINAL	TE TERMINAL	TE TERMINAL
794121-1	3-794121-1	

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
18 AWG	0.91+/-0.05 [0.036+/-0.002]	7.4
20 AWG	0.86+/-0.05 [0.034+/-0.002]	7.9
22 AWG	0.76+/-0.05 [0.030+/-0.002]	8.9

- 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 180.
- 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.
- TERMINAL SUPPORT ONLY REQUIRED FOR BT VERSIONS, 5-2151123-1 OR 5-2151123-2
- 6. 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.

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

-	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	-	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
-	2	2	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	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113
-	1	1	2844908-1	SCREW, LOCKING	99
-	1	1	2844907-1	POST, LOCKING	98
-	1	1	455888-6	SPACER, CRIMPER	82
-	1	1	1803607-3	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
-	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
-	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	455888-4	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	2119533-1	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	1333230-2	ANVIL, COMBINATION	8
-	1	1	2119757-4	DEPRESSOR, SHEAR	5
-	1	1	238011-8	BLOCK, CRIMPER SPACER	4
-	1	1	1-1633965-0	CRIMPER, INSULATION O PREMIUM	3
-	1	1	1-455888-1	SPACER, CRIMPER	2
-	1	1	3-456403-3	CRIMPER, WIRE PREMIUM	1

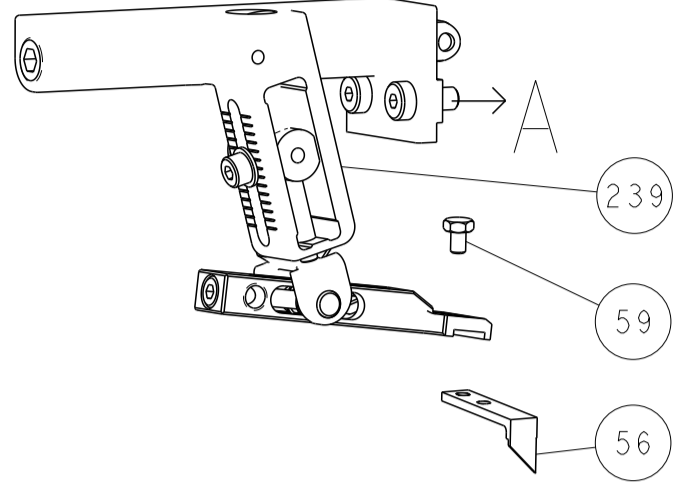
PACIFIC VERSION  
Shown on sheets 3 of 4 & 4 of 4  
(Atlantic version shown on sheets 1 of 4 & 2 of 4)

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

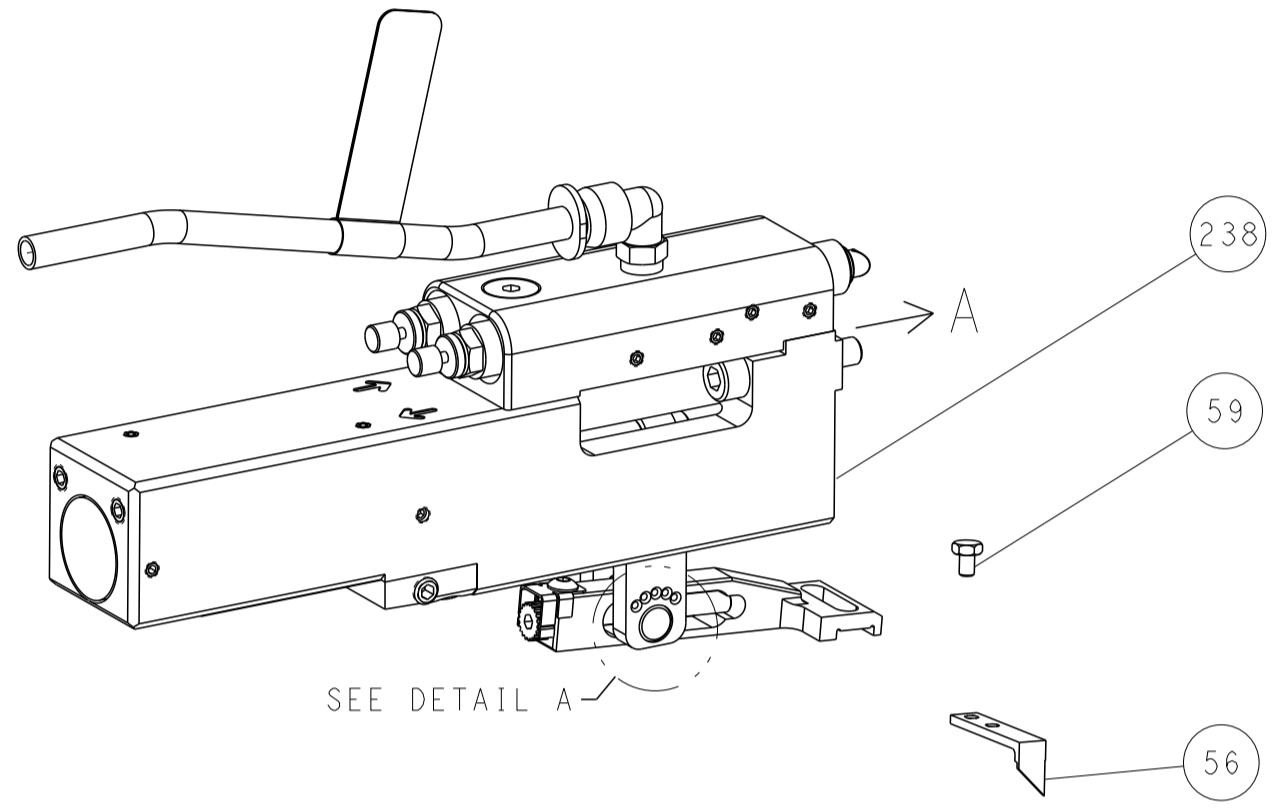
OWN	X. ZHAO	16 JUN 2011	CHK	S. XI	16 JUN 2011	APVD	J. CRUZ	16 JUN 2011
NAME		Ocean Side Feed Applicator		SIZE		CAGE CODE		DRAWING NO
-		-		A1		00779		©=2151123
RESTRICTED TO		Customer Accessible Production Drawing		SCALE		1:2		SHEET 3 OF 4
REV		E		REV		-		REV

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

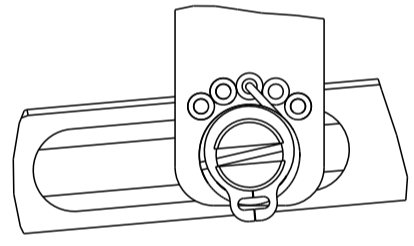
# FEED TYPE MECHANICAL



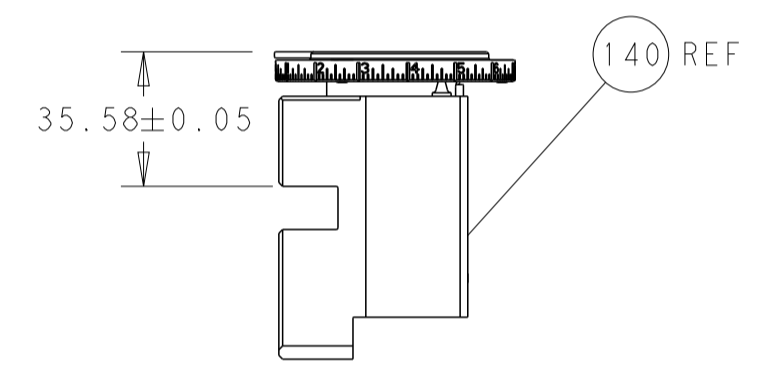
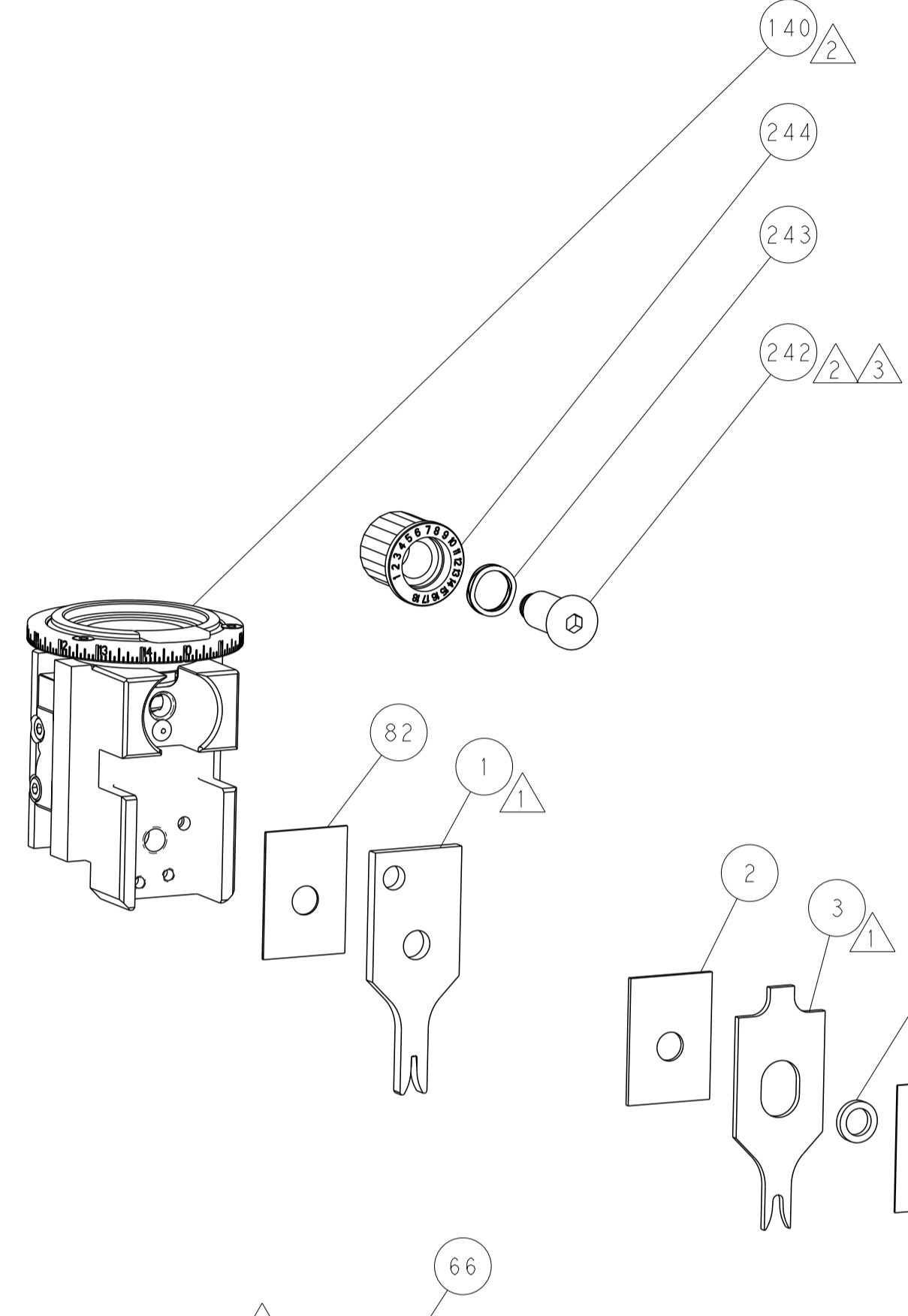
## PNEUMATIC



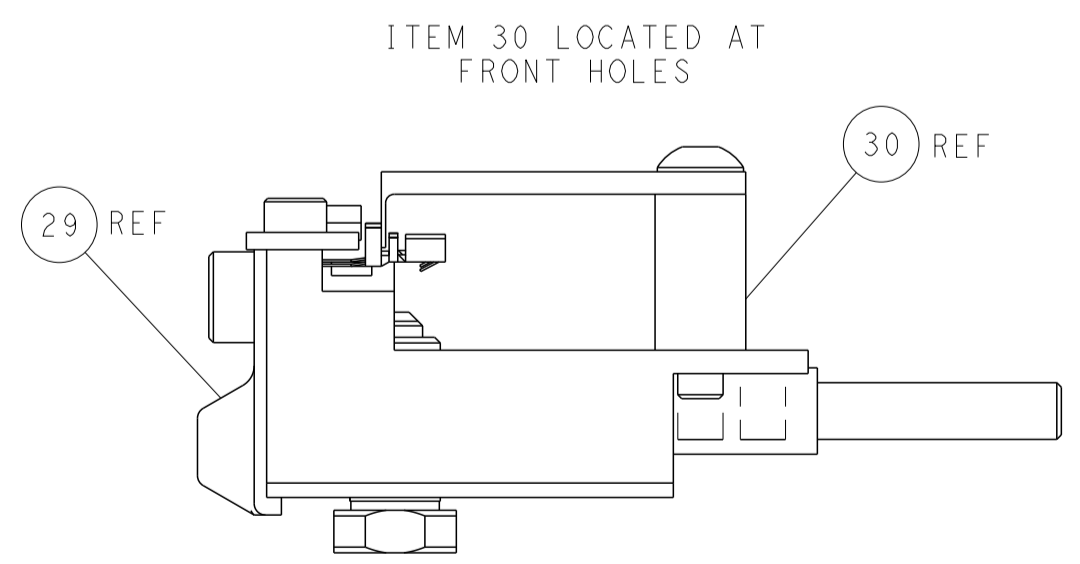
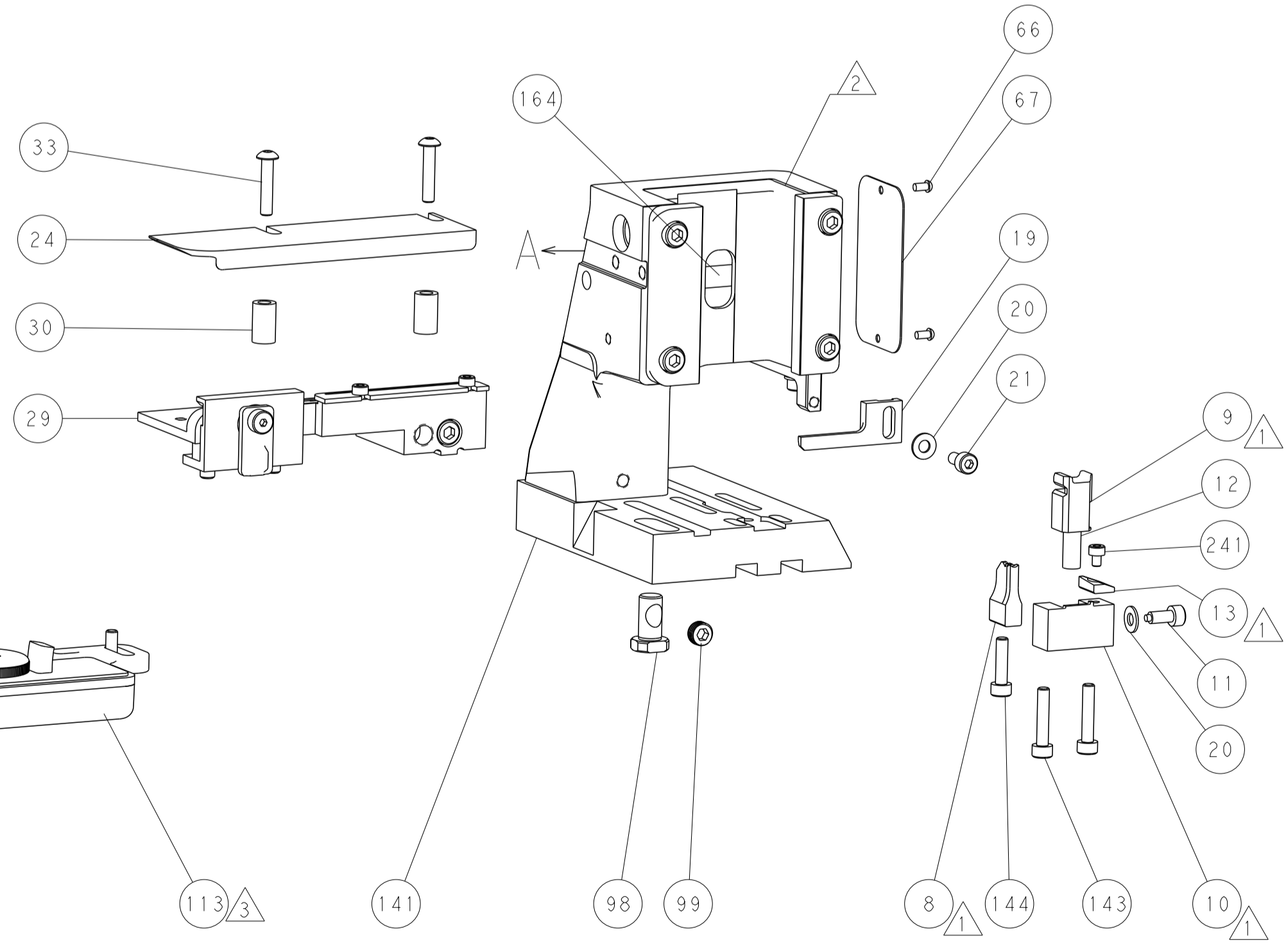
FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



DETAIL A

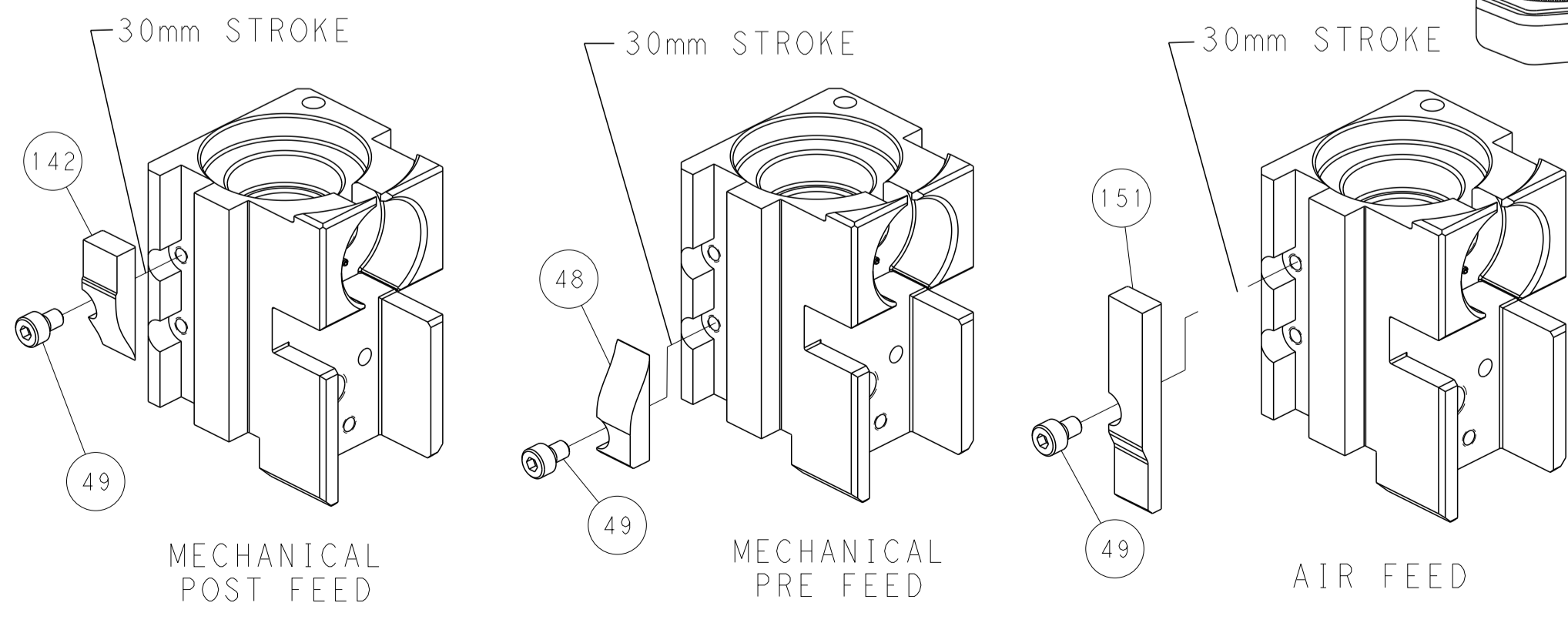


RAM SET-UP



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)

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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 SIZE CAGE CODE DRAWING NO A1 00779 C=2151123	RESTRICTED TO SCALE 1:2 SHEET 4 OF 4 REV E
MATERIAL:		WEIGHT:	Customer Accessible Production Drawing