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RELEASED FOR PUBLICATION

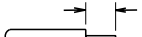
20

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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151017-1	H	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2151017-2	H	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
5-2151017-1	H	SEAL STRIPPER CRIMPER TERMINATING UNIT	MECHANICAL
5-2151017-2	H	SEAL STRIPPER CRIMPER TERMINATING UNIT	PNEUMATIC
7-2151017-1	H	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2151017-2	H	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2151017-7	A	CRIMP TOOLING KIT	-

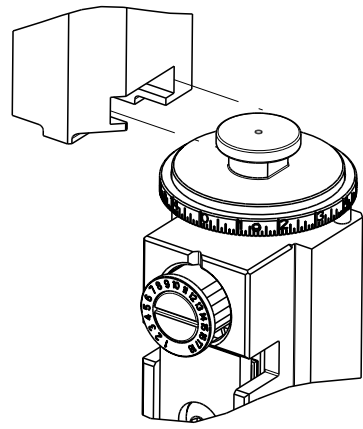
APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.22 mm [.048]	F
INSUL	2.03 mm [.080]	F
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: MINI UNIV MATE-N-LOK PIN CONTACT			
WIRE STRIP LENGTH			INSULATION DIAMETER RANGE
3.20-4.00 mm [.126-.157 IN]			Ø1.20-1.75 mm [.047-.069 IN]
TERMINAL APPLICATION SPECIFICATION 		(A)114-5050	(C)114-1111 -
		(B)114-16017	-
TERMINALS APPLIED 			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
(A) 170359-1	(A) 170359-2	(A) 170359-3	(A) 170359-4
(A) 170361-3	(A) 170361-4	(A) 170361-1	(A) 170361-2

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
22 AWG OR 0.34mm2	0.78+/-0.05 [.031+/- .002]	8.2
24 AWG OR 0.22mm2	0.69+/-0.05 [.027+/- .002]	9.1
26 AWG OR 0.14mm2	0.63+/-0.05 [.025+/- .002]	9.8

- 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. APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 180.
- 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.
- 6 TERMINAL LUBRICANT IS RECOMMENDED.

ATLANTIC VERSION TERMINATOR
INTERFACE ADAPTER



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

LOC	DIST	REVISONS				
		P	LYR	DESCRIPTION	DATE	DWN
						APVD
		E		ECR-19-001524	29JAN2019	TB
		F		ECR-19-006414	23APR2019	MZ
A	66	G		ECR-20-018179	29DEC2020	JWC
		H		ECR-21-001283	01FEB2021	JWC

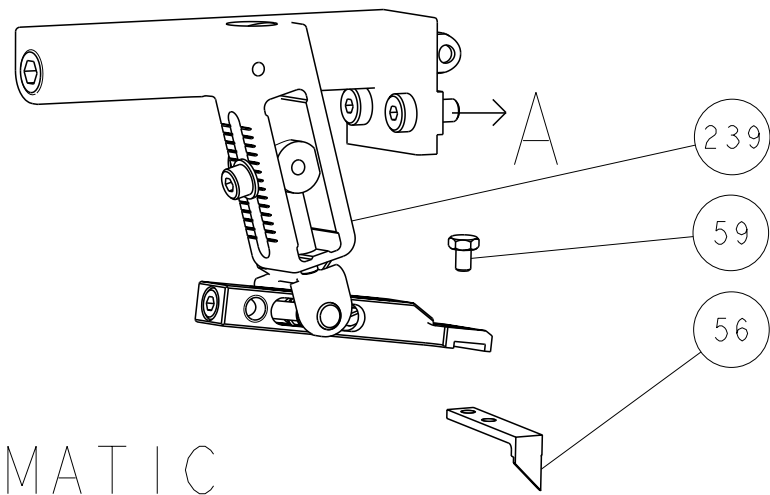
-	-	-	1	1	-	-	1803515-3	RAM ASSEMBLY, SF ATLANTIC	293
-	-	-	1	1	-	-	2-1803583-1	APPLICATOR BASIC ASSEMBLY, SF	292
-	1	-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248
-	1	1	1	1	1	1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1	1	1	1	1	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	-	-	1-1752354-7	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	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	455888-5	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
-	4	4	4	4	4	4	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	54
-	2	2	2	2	2	2	2-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 14	53
-	1	1	1	1	1	1	1803382-6	HOLD DOWN, SPRING LOADED	50
-	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	1	1	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	2-2844962-6	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	1	1	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29
-	1	1	1	1	1	1	455888-3	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	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	1	2119805-1	SHEAR HOLDER, FRONT	10
-	1	1	1	1	1	1	1803095-1	FLOATING SHEAR, FRONT	9
1	2	2	1	1	1	1	1333225-9	ANVIL, COMBINATION	8
-	1	1	1	1	1	1	1-240641-0	SPACER	7
-	-	-	-	-	-	-	-	-	6
-	1	1	1	1	1	1	2119757-8	DEPRESSOR, SHEAR	5
-	1	1	1	1	1	1	1-238011-3	BLOCK, CRIMPER SPACER	4
1	2	2	1	1	1	1	1-2119582-9	CRIMPER, INSULATION F PREMIUM	3
-	1	1	1	1	1	1	455888-7	SPACER, CRIMPER	2
1	2	2	1	1	1	1	568176-6	CRIMPER, WIRE	1

-77 -72 -71 -52 -51 -2 -1						PART NO		DESCRIPTION				ITEM NO
THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE AND TO BE CONTROLLED BY THE ENGINEERING ORGANIZATION. ANY CHANGES SHOULD BE CONTACTED FOR THE LATEST REVISION.						DWN	09NOV2011		TE Connectivity Harrisburg, PA 17105-3608			
						CHK	09NOV2011					
						S XI	09NOV2011					
						APVD	09NOV2011					
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:				PRODUCT SPEC	NAME	Ocean Side Feed Applicator				
mm						APPLICATION SPEC						
		0 PLC ±				-	SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO		
		1 PLC ±				-	A1	00779	C=2151017	-		
		2 PLC ±				-						
		3 PLC ±				-						
		4 PLC ±				-						
		ANGLES ±										
MATERIAL		FINISH				WEIGHT						
Customer Accessible Production Drawing						SCALE	1:2	SHEET	1	OF	4	
										REV	H	

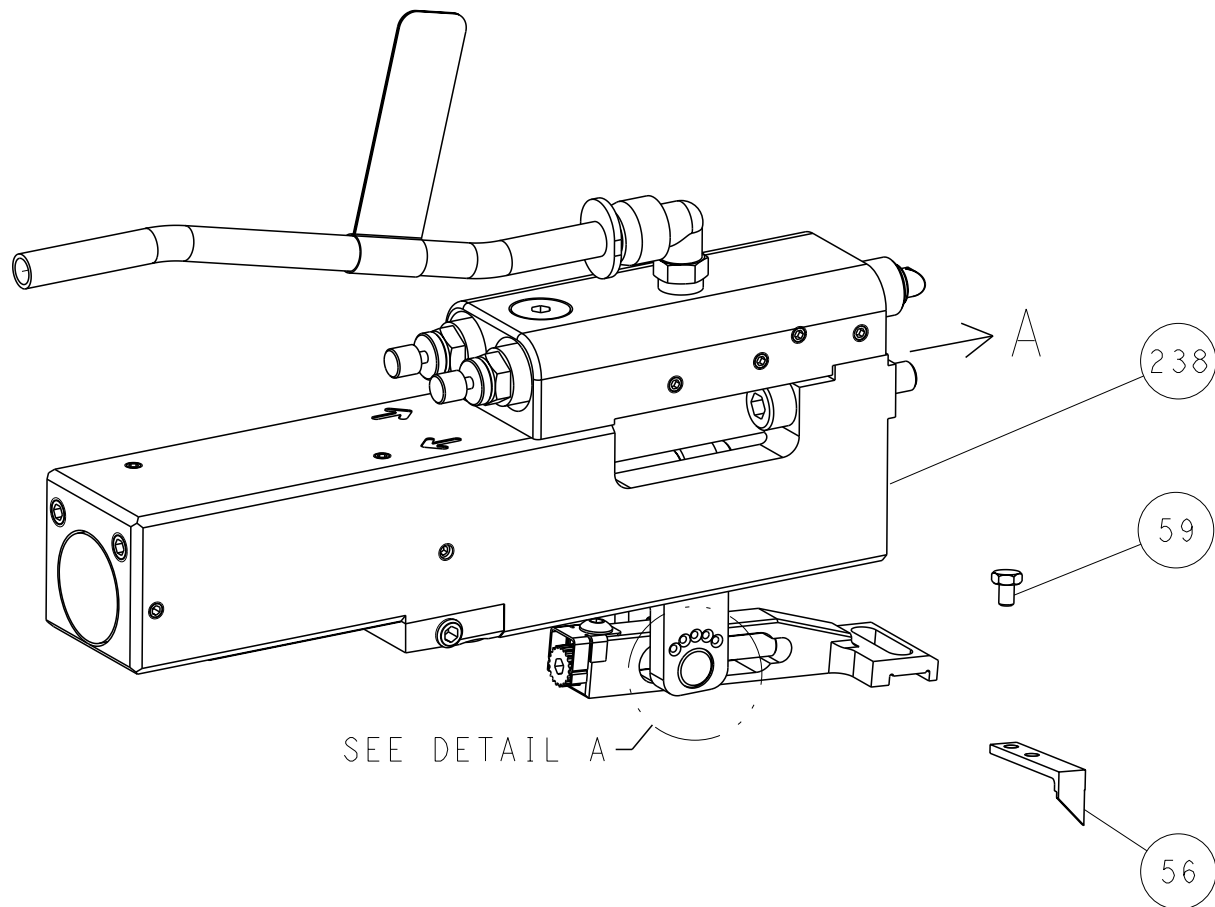
SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

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

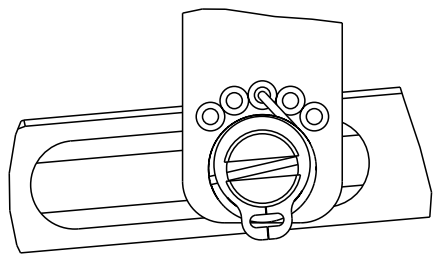
FEED TYPE MECHANICAL



PNEUMATIC

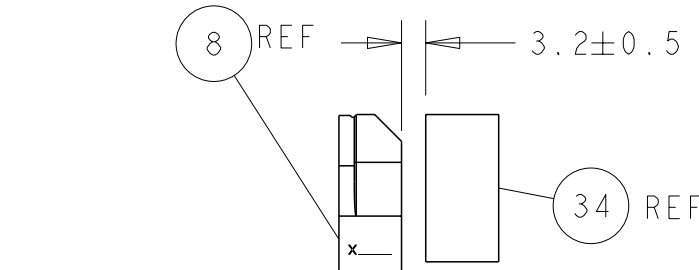
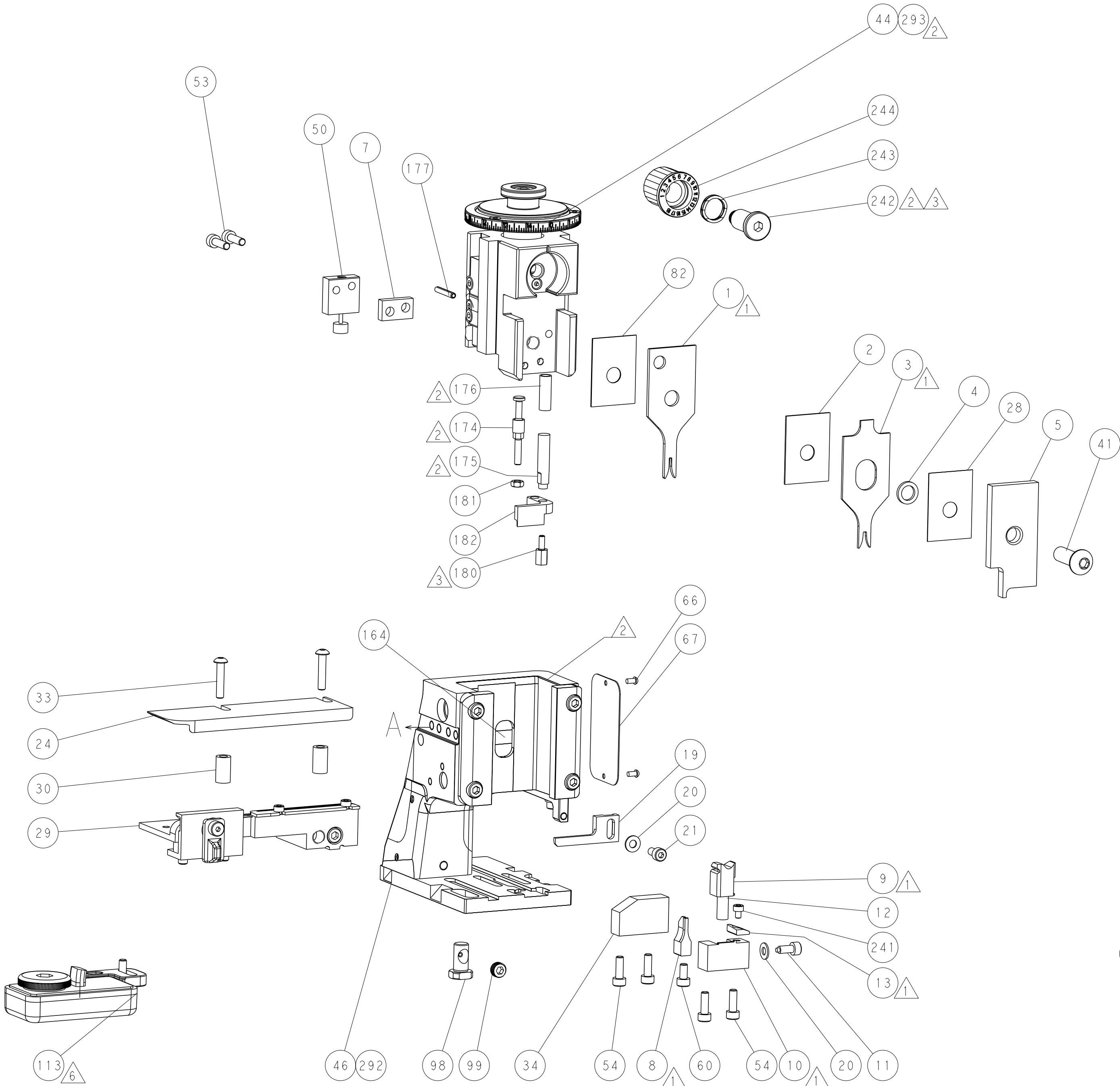
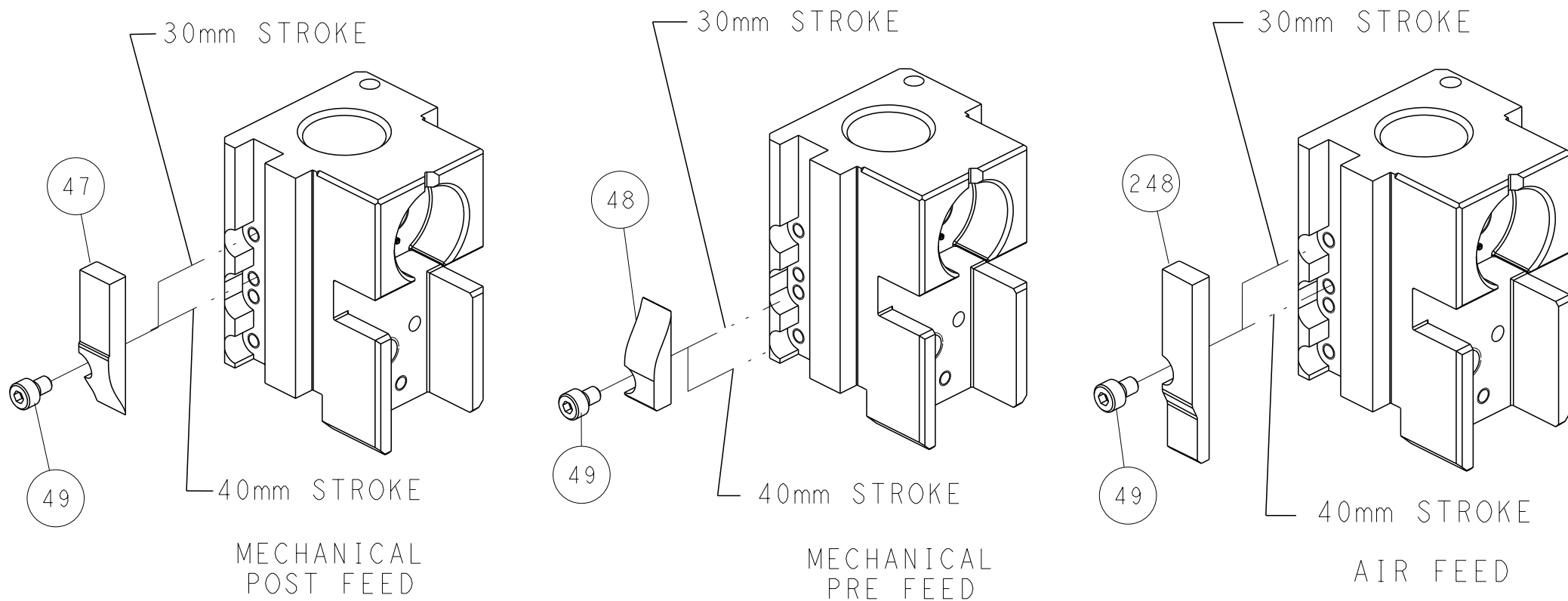


FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)

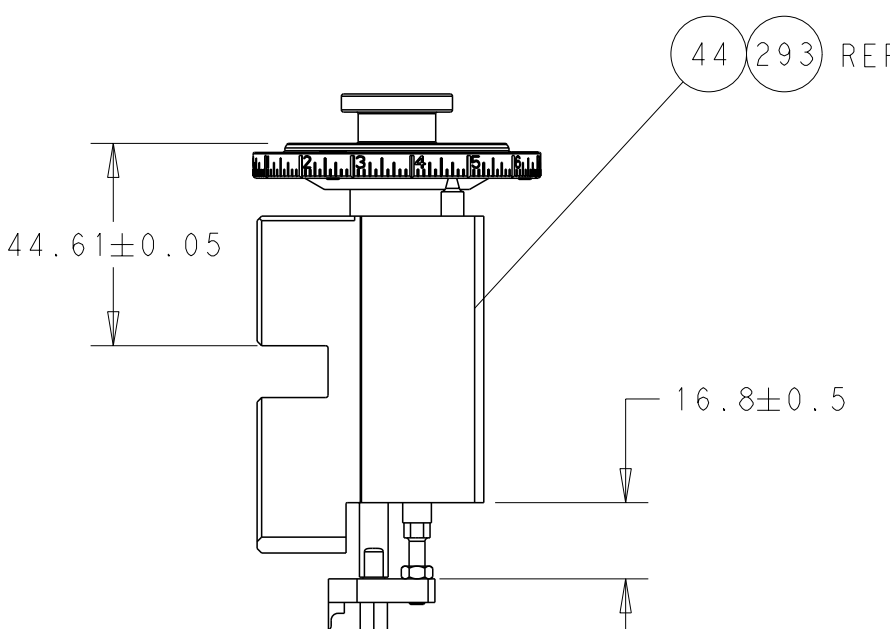


DETAIL A

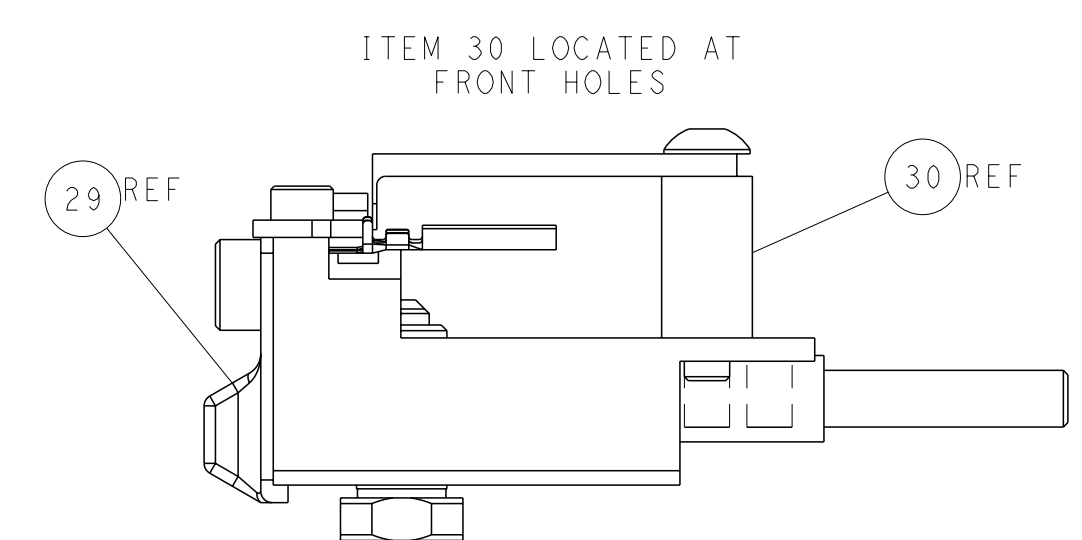
CAM POSITIONS



TERMINAL SUPPORT LOCATION



RAM AND HOLD-DOWN SET-UP



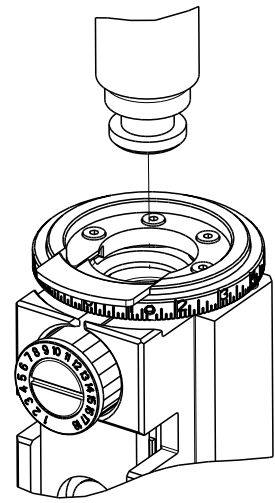
FEED TRACK POSITION
GUIDE BY INSULATION BARREL

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

111 IS SUBJECT TO CHANGE AND TO BE CONTROLLED BY THE ENGINEERING DEPARTMENT. ANY CHANGE TO THIS DRAWING MUST BE CONTROLLED BY THE ENGINEERING DEPARTMENT.		DWN K. HUANG 09NOV2011	TE Connectivity Harrisburg, PA 17105-3608		
CHK S. XI 09NOV2011		APVD J. CRUZ 09NOV2011	NAME Ocean Side Feed Applicator		
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH ±			
MATERIAL -		WEIGHT -			
Customer Accessible Production Drawing		SCALE 1:2	SHEET 2 of 4	REV H	

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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2151017-1	H	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2151017-2	H	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151017-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.22 mm [.048]	F
INSUL	2.03 mm [.080]	F
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: MINI UNIV MATE-N-LOK PIN CONTACT			
WIRE STRIP LENGTH 3.20-4.00 mm [.126-.157 IN]		INSULATION DIAMETER RANGE Ø1.20-1.75 mm [.047-.069 IN]	
TERMINAL APPLICATION SPECIFICATION	(A)114-5050	(C)114-1111	-
	(B)114-16017	-	-
TERMINALS APPLIED 			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
(A) 170359-1	(A) 170359-2	(A) 170359-3	(A) 170359-4
(A) 170361-3	(A) 170361-4	(A) 170361-1	(A) 170361-2

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
22 AWG OR 0.34mm2	0.78+/-0.05 [.031+/- .002]	8.2
24 AWG OR 0.22mm2	0.69+/-0.05 [.027+/- .002]	9.1
26 AWG OR 0.14mm2	0.63+/-0.05 [.025+/- .002]	9.8



- 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.
- 6 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.

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

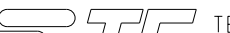
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LOC	DIST	REVISIONS						
A	66	P	LTR	DESCRIPTION	DATE	DWN	APVD	
		-		SEE SHEET 1	-	-	-	

-	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
-	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	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	1803607-3	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
-	2	2	2-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 14	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	1752356-1	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	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	2119533-1	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	1803095-1	FLOATING SHEAR, FRONT	9
-	1	1	1333225-9	ANVIL, COMBINATION	8
-	1	1	1-240641-0	SPACER	7
-	-	-	-	-	6
-	1	1	2119757-8	DEPRESSOR, SHEAR	5
-	1	1	1-238011-3	BLOCK, CRIMPER SPACER	4
-	1	1	1-2119582-9	CRIMPER, INSULATION F PREMIUM	3
-	1	1	455888-7	SPACER, CRIMPER	2
-	1	1	568176-6	CRIMPER, WIRE	1

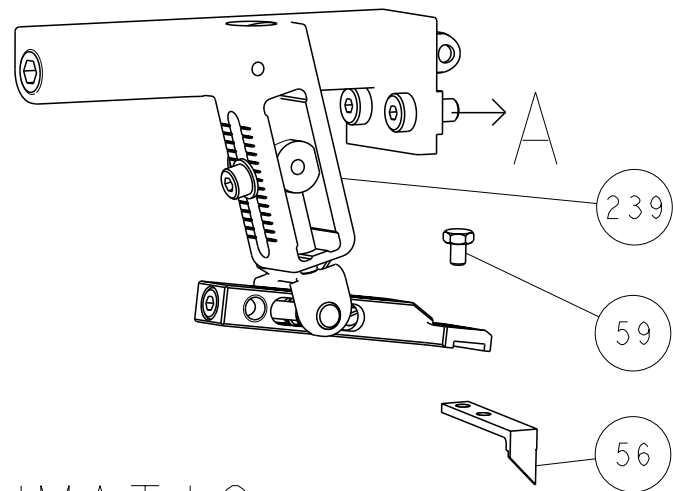
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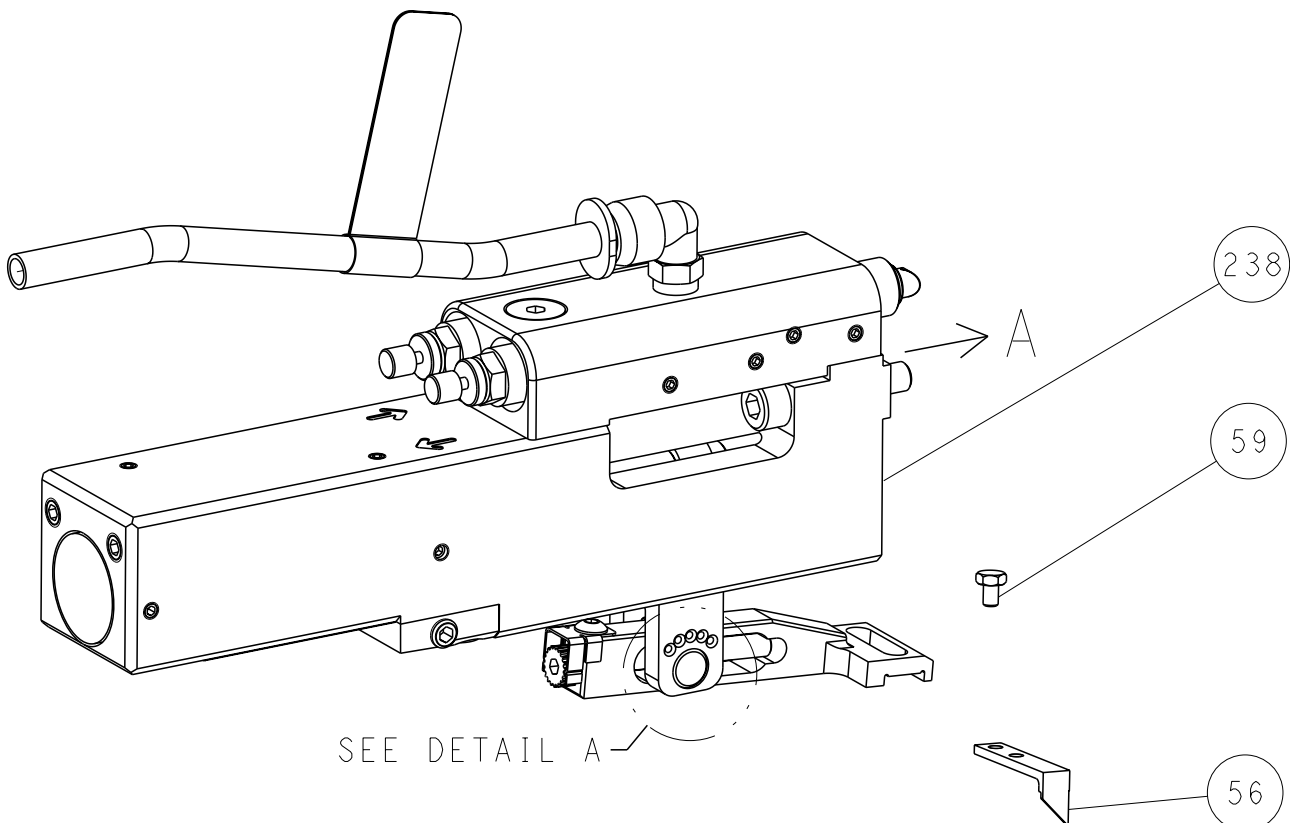
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THIS DRAWING IS A CONTROLLED DOCUMENT FOR THE ELECTRONIC CORPORATION IT IS SUBJECT TO CHANGE AND TO BE SUBJECT TO THE ENGINEERING ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST REVISION			DWN H. HUANG 09NOV2011		 TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm			CHK S. XI 09NOV2011			
			TOLERANCES UNLESS OTHERWISE SPECIFIED:		NAME Ocean Side Feed Applicator	
			APVD J. CRUZ 09NOV2011		PRODUCT SPEC	
			APPLICATION SPEC		SIZE	
			RESTRICTED TO			
MATERIAL			FINISH		CAGE CODE	
-			-		DRAWING NO	
-			WEIGHT		A 00779 C=2151017	
-			-		-	
Customer Accessible Production Drawing					SCALE 1:2	
					SHEET 3 OF 4	
					REV H	

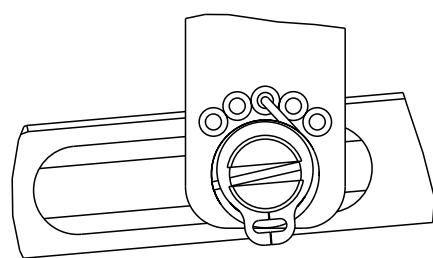
FEED TYPE MECHANICAL



PNEUMATIC

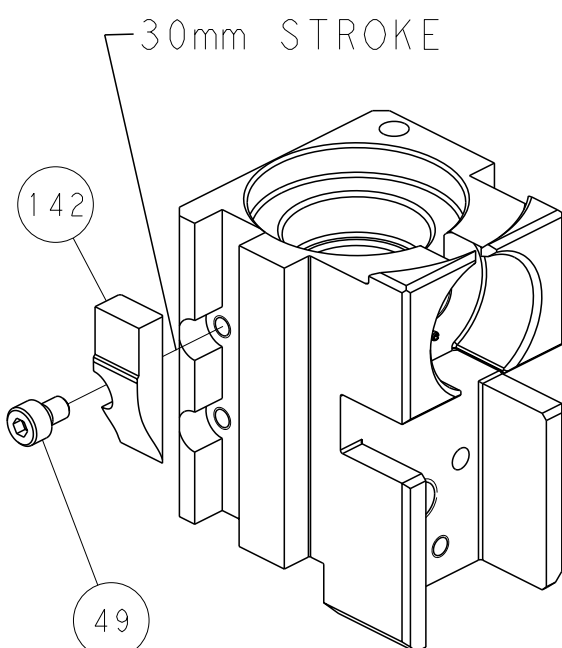


FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)

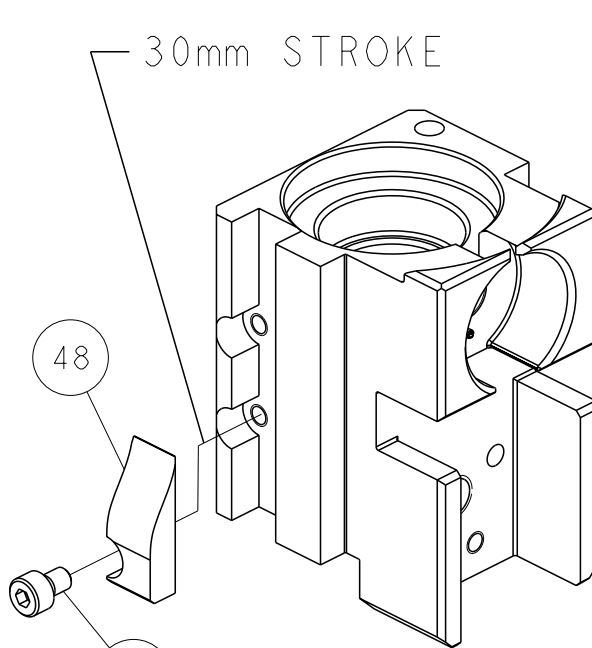


DETAIL A

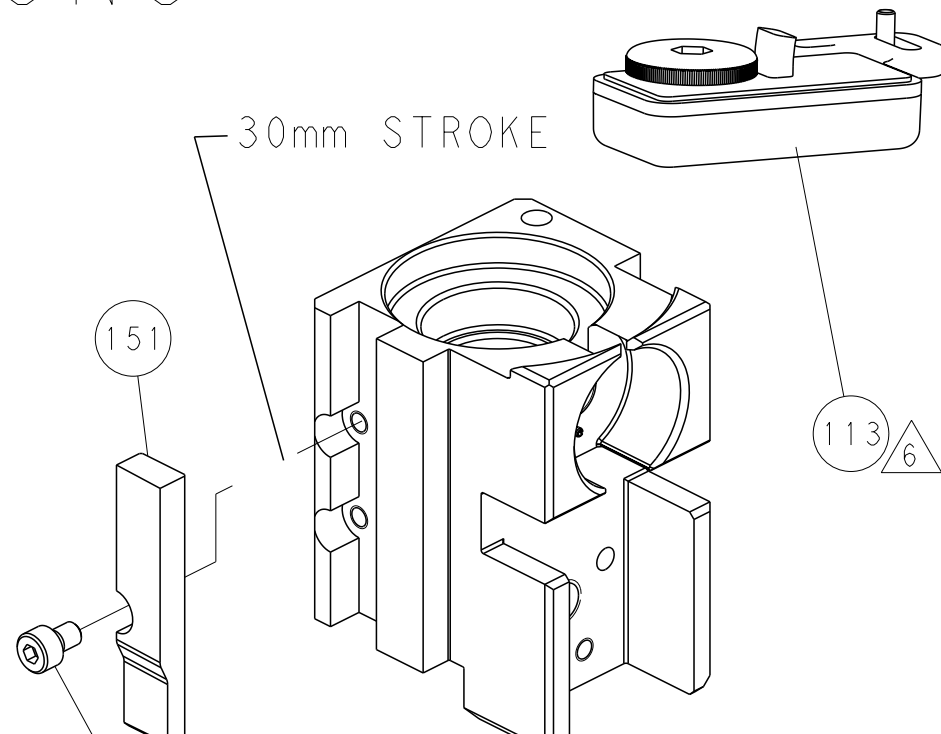
CAM POSITIONS



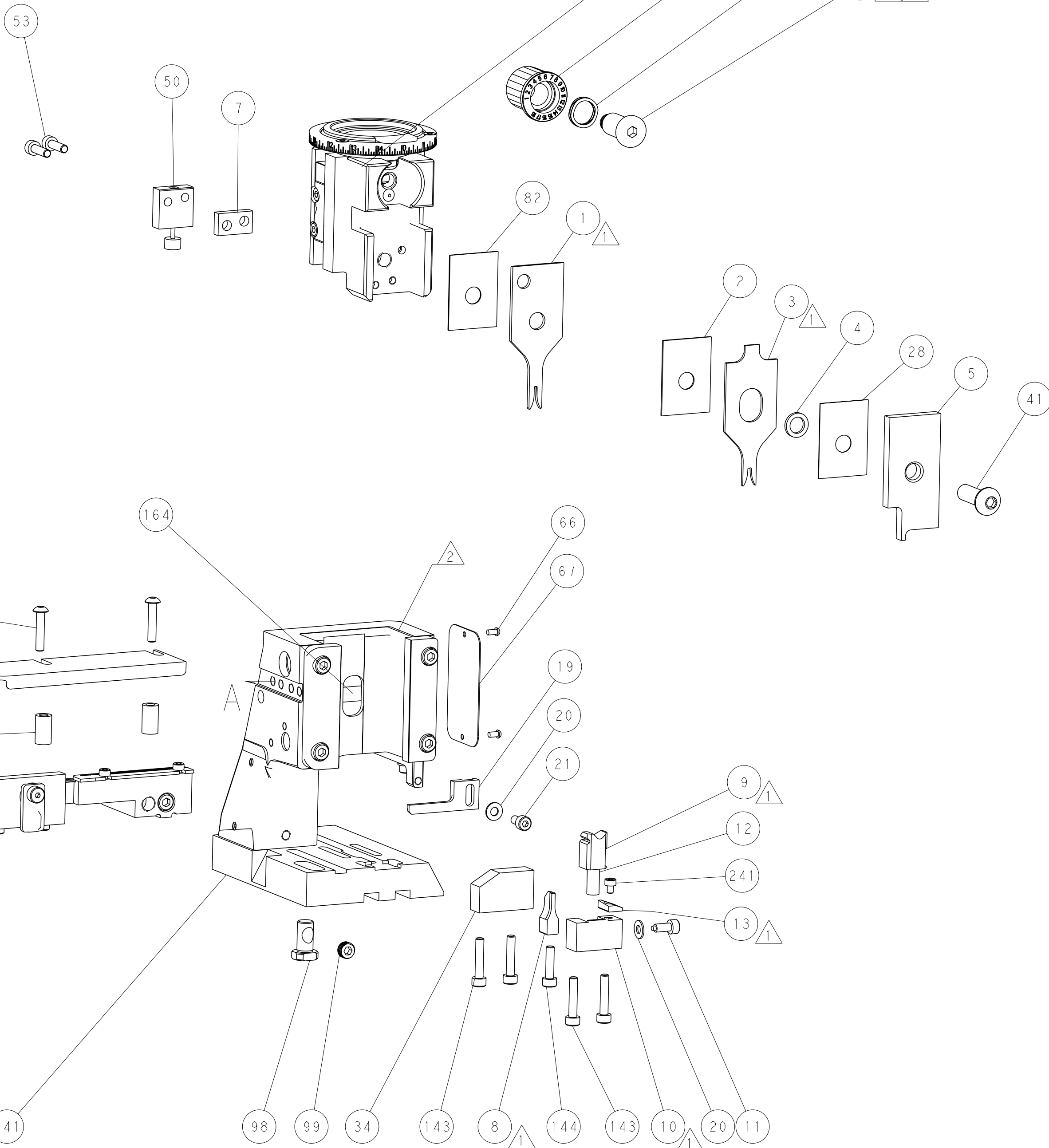
MECHANICAL
POST FEED



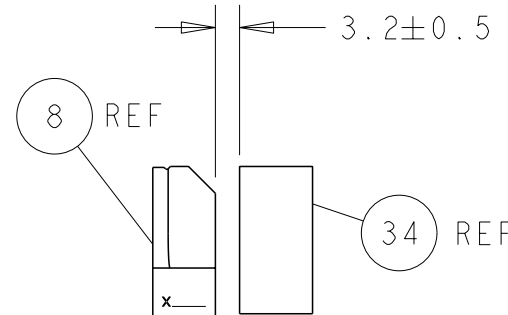
MECHANICAL
PRE FEED



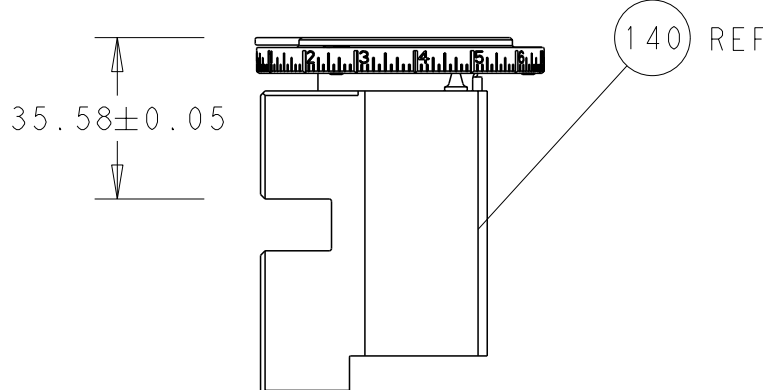
AIR FEED



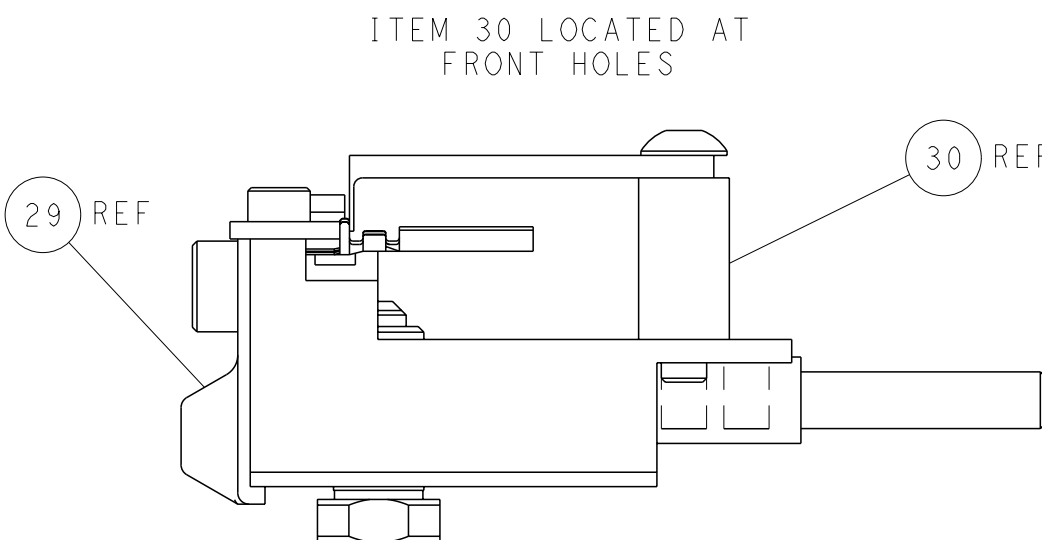
PACIFIC VERSION
Shown on sheets 3 of 4 & 4 of 4
(Atlantic version shown on sheets 1 of 4 & 2 of 4)



TERMINAL SUPPORT LOCATION



RAM SET-UP



FEED TRACK POSITION
GUIDE BY INSULATION BARREL

THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE AND TO THE CONTROL AND ENGINEERING DEPARTMENT. SHOULD BE CONTACTED FOR THE LATEST REVISION.		OWN K. HUANG CHK S. XI APVD J. CRUZ	09NOV2011 09NOV2011 09NOV2011	NAME Ocean Side Feed Applicator	
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		SIZE A1	
0 PLC 1 PLC 2 PLC 3 PLC 4 PLC		± ± ± ± ±		CAGE CODE 00779	
ANGLES FINISH		± ±		DRAWING NO 2151017	
MATERIAL -		WEIGHT -		RESTRICTED TO -	
Customer Accessible Production Drawing		SCALE 1:2		SHEET 4 of 4	
				REV H	

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