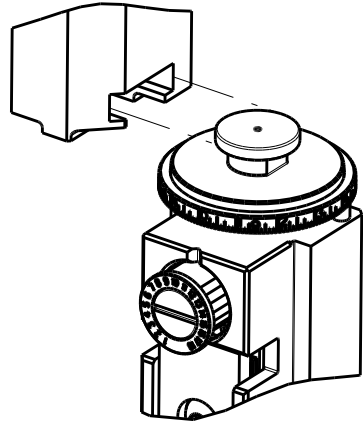
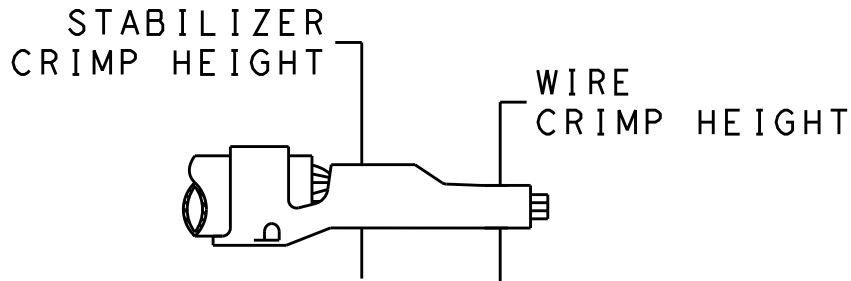


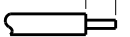
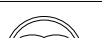
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THIS DRAWING IS UNPUBLISHED.		RELEASED FOR PUBLICATION	
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© COPYRIGHT 20 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.			
PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151209-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2151209-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151209-1	C	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2151209-2	C	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2151209-*	B	SEE CRIMP TOOLING KIT BELOW	-

ATLANTIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.57 mm [.062]	F
STABILIZER	1.57 mm [.062]	F
INSULATION	2.79 mm [.110]	F
APPLICATOR INSTRUCTIONS 408-35042		



TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: MINI AMP-IN			
WIRE STRIP LENGTH 4.45-4.98 mm [.175-.196 IN]			INSULATION DIAMETER RANGE 1.52-2.79 mm [.060-.110 IN]
TERMINAL APPLICATION SPECIFICATION		114-1016	
		-	-
		-	-
TERMINALS APPLIED 			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
3-640311-1			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	WIRE CRIMPER PART NUMBER	STABLIZER CRIMPER HEIGHT mm [INCH]	STABILIZER CRIMPER PART NUMBER	CRIMP HEIGHT REFERENCE SETTING
18 AWG	0.94+/-0.05 [.037+/- .002]	7-1803188-7	1.40+/-0.05 [.055+/- .002]	1-456403-3	5.0
22-20	0.76+/-0.05 [.030+/- .002]	7-1803188-8			5.0



- 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.
- ITEM 1 TO BE USED WITH 18 AWG ONLY. ITEM TO BE SHIPPED WITH APPLICATOR.
- ITEM 253 TO BE USED WITH 22-20 AWG ONLY. ITEM TO BE SHIPPED WITH APPLICATOR.
- ITEM 19 MUST BE POSITIONED BETWEEN ITEMS 1 OR 253 AND ITEM 178.
- WHEN RUNNING APPLICATOR IN BENCH MACHINE WIRE MUST BE PLACED IN WIRE BARREL IN ORDER TO ACHIEVE PROPER BRUSH LENGTH.

***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	LTR	DESCRIPTION	DATE	DWN	APVD
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		C		ECR-18-016121	11OCT2018	FL	TE

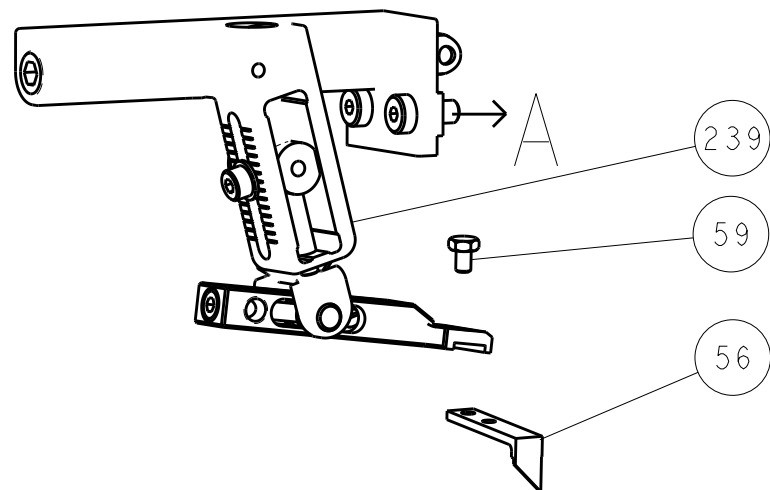
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			-	1	-	1	2119640-1	PUSH ROD, AIR FEED	250
			-	1	-	1	1803259-1	BUSHING, FLANGED	249
			-	1	-	1	2119641-1	FEED CAM, AIR FEED	248
			-	1	1	1	2119082-4	CAM, SNAIL, INSULATION ADJUSTMENT	244
			-	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
3			-	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
			-	1	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
			-	-	1	-	2119580-1	MECHANICAL FEED ASSEMBLY	239
			-	1	-	1	2063440-1	AIR FEED MODULE	238
1			1	1	2	2	1-456403-3	CRIMPER, WIRE PREMIUM	178
			-	2	-	2	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172
			-	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	455888-8	SPACER, CRIMPER	128
			-	1	1	1	2844908-1	SCREW, LOCKING	99
			-	1	1	1	2844907-1	POST, LOCKING	98
			-	1	1	1	455888-4	SPACER, CRIMPER	82
			-	1	1	1	1803607-1	DOCUMENTATION PACKAGE	71
			-	1	1	1	2119740-1	TAG, IDENTIFICATION	67
			-	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
			-	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	60
			-	1	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
			-	1	1	1	1338685-1	PAWL, FEED	56
			-	2	2	2	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	54
			-	1	2	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49
			-	-	1	-	2119652-1	FEED CAM, PRE FEED	48
			-	-	1	-	2119653-1	FEED CAM, POST FEED	47
			-	1	1	1	1803583-9	APPLICATOR BASIC ASSEMBLY, SF	46
			-	1	1	1	1803515-1	RAM ASSEMBLY, SF ATLANTIC	44
			-	1	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
			-	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
			-	2	2	2	2-2844962-6	SPACER, CYLINDRICAL, STRIP GUIDE	30
			-	1	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29
			-	1	1	1	455888-3	SPACER, CRIMPER	28
			-	1	1	1	1320928-2	STRIP GUIDE	24
			-	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
			-	2	2	2	1-18028-2	WASHER, FLAT, REG M4	20
8			-	1	1	1	2119533-4	STRIPPER, SIDE FEED	19
1			-	1	1	1	2119806-1	INSERT, SHEAR	13
			-	1	1	1	3-22280-3	SPRING, COMPRESSION	12
			-	1	1	1	1-356885-4	STOP, SHEAR	11
			-	1	1	1	2119805-1	SHEAR HOLDER, FRONT	10
1			-	1	1	1	1803095-1	FLOATING SHEAR, FRONT -	9
1			1	1	2	2	1-1633916-4	ANVIL, COMBINATION	8
			-	-	-	-	-	-	7
			-	-	-	-	-	-	6
			-	1	1	1	2119757-8	DEPRESSOR, SHEAR	5
			-	1	1	1	2-238011-2	BLOCK, CRIMPER SPACER	4
1			1	1	2	2	2-2119582-1	CRIMPER, INSULATION F PREMIUM	3
			-	-	-	-	-	-	2
6	1		-	1	2	2	7-1803188-7	CRIMPER, WIRE	1

THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. ANY CHANGES TO THIS DRAWING SHOULD BE CONTACTED FOR THE LATEST EDITION.		DWN M. RILEY 09-JUN-16	TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm		CHK R. KNEPPER 09-JUN-16	NAME Ocean Side Feed Applicator	
TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH ±		APVD G. BAILEY 09-JUN-16	PRODUCT SPEC APPLICATION SPEC	
MATERIAL		WEIGHT	SIZE A1	CAGE CODE 00779
			DRAWING NO C-2151209	RESTRICTED TO -
		Customer Accessible Production Drawing	SCALE 1:2	SHEET 1 OF 4
			REV C	

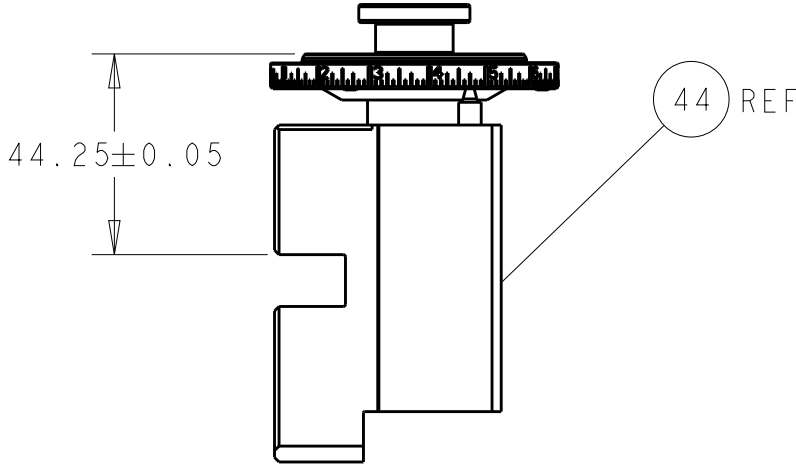
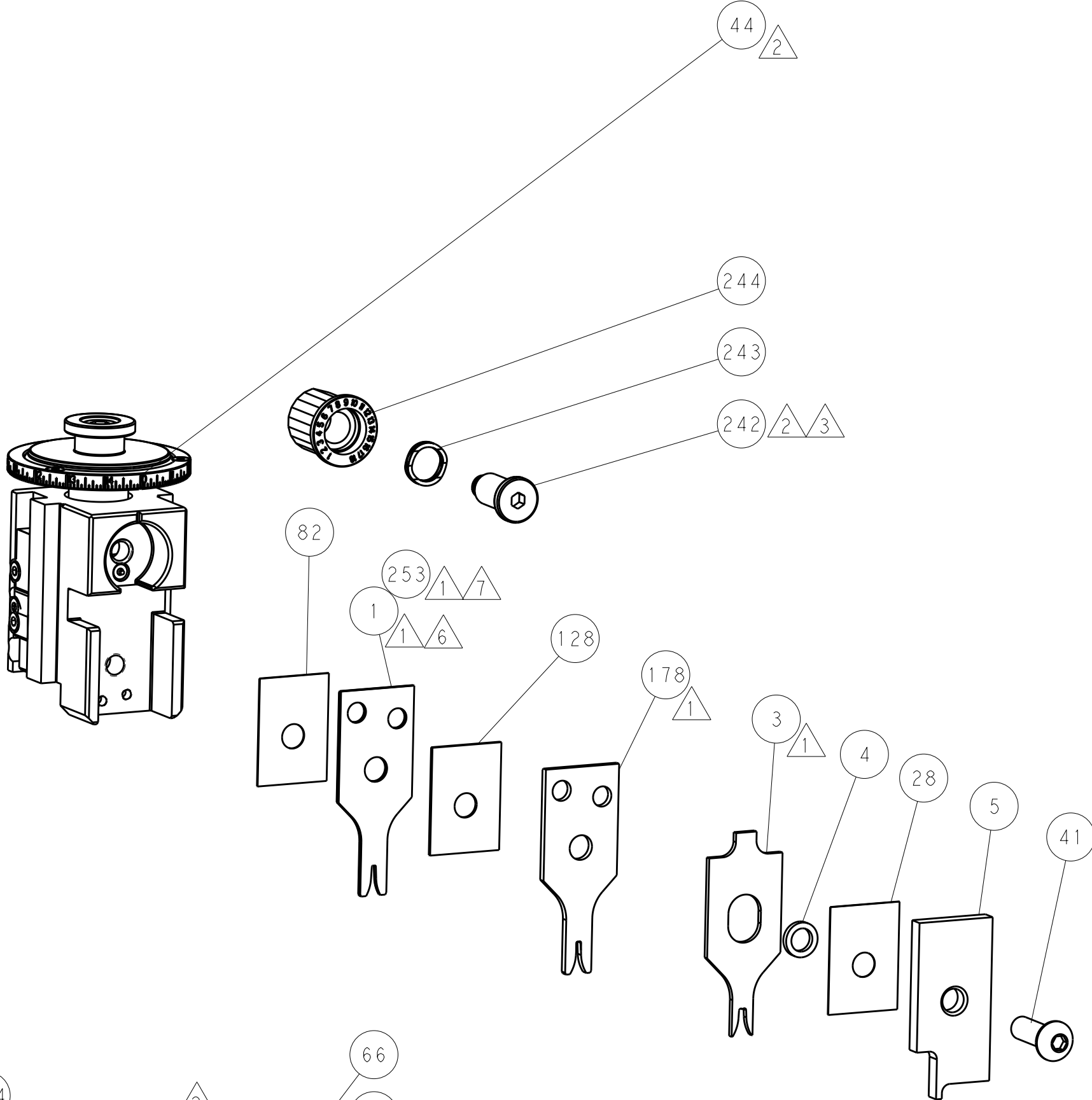
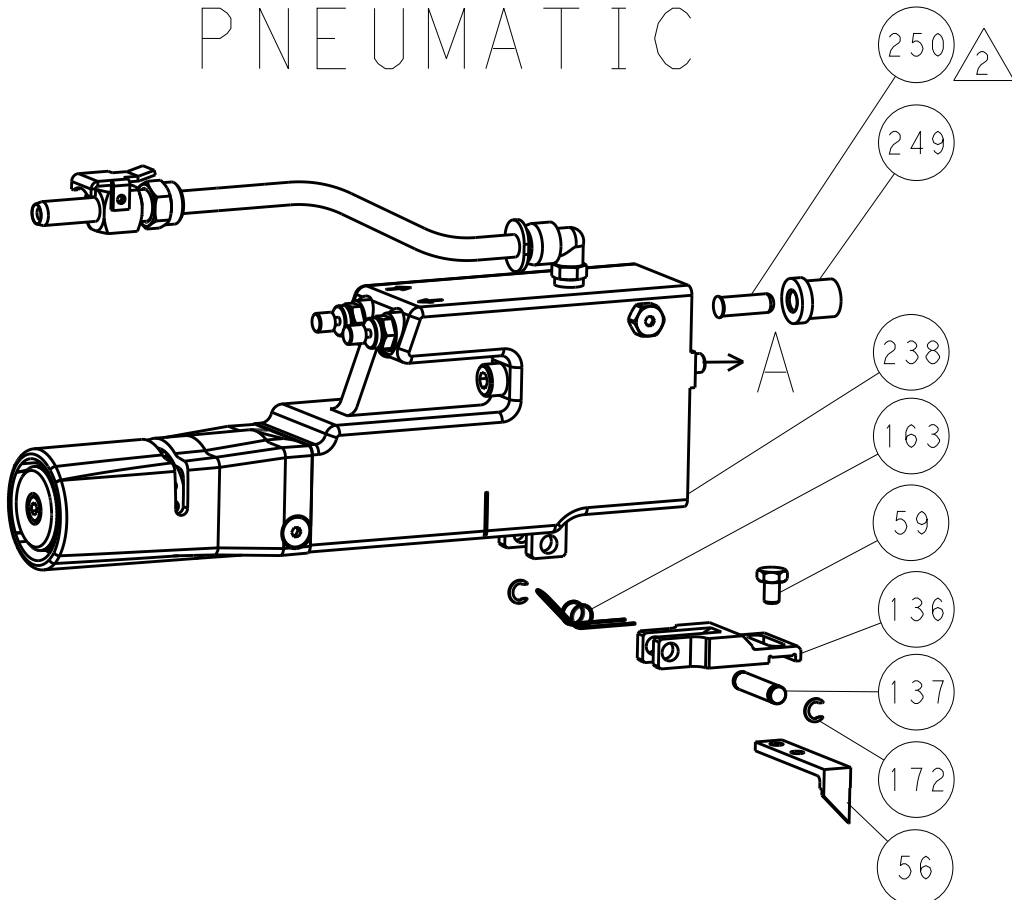
SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

LOC	DIST	REVISIONS					
		P	LTR	DESCRIPTION	DATE	DWN	APVD
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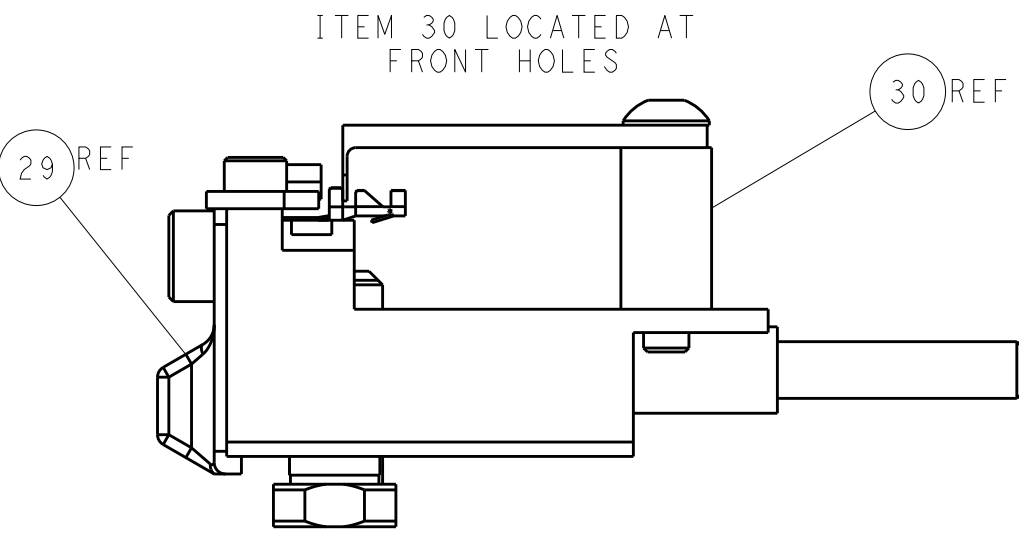
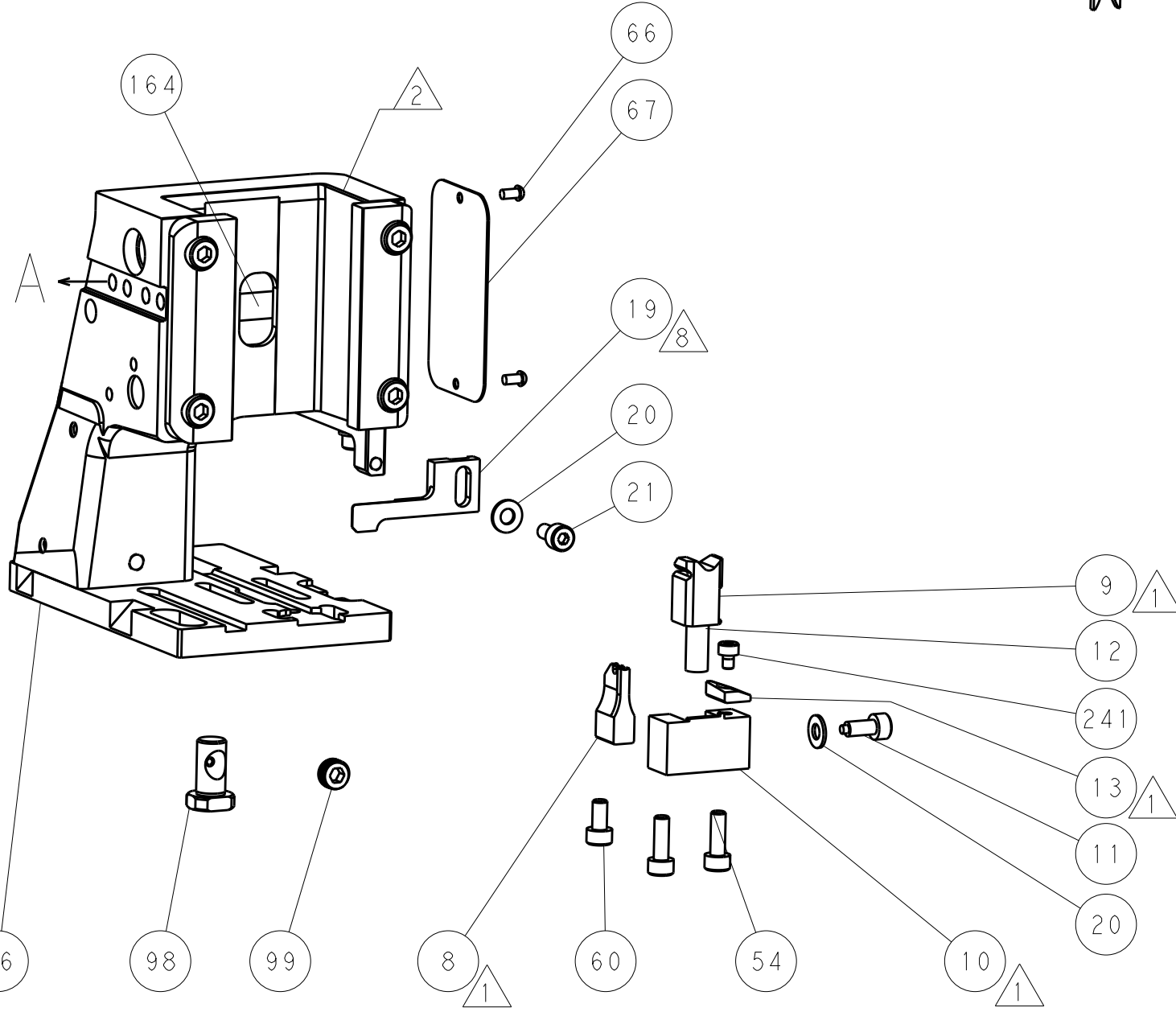
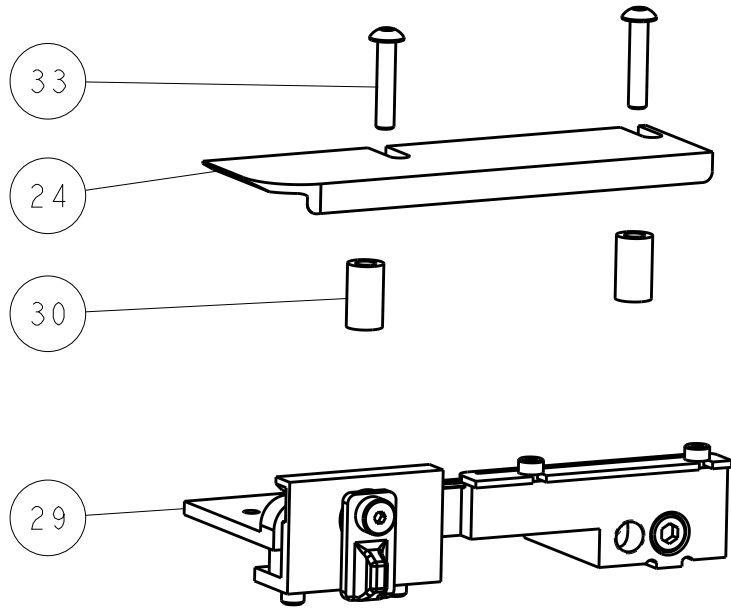
FEED TYPE
MECHANICAL



PNEUMATIC

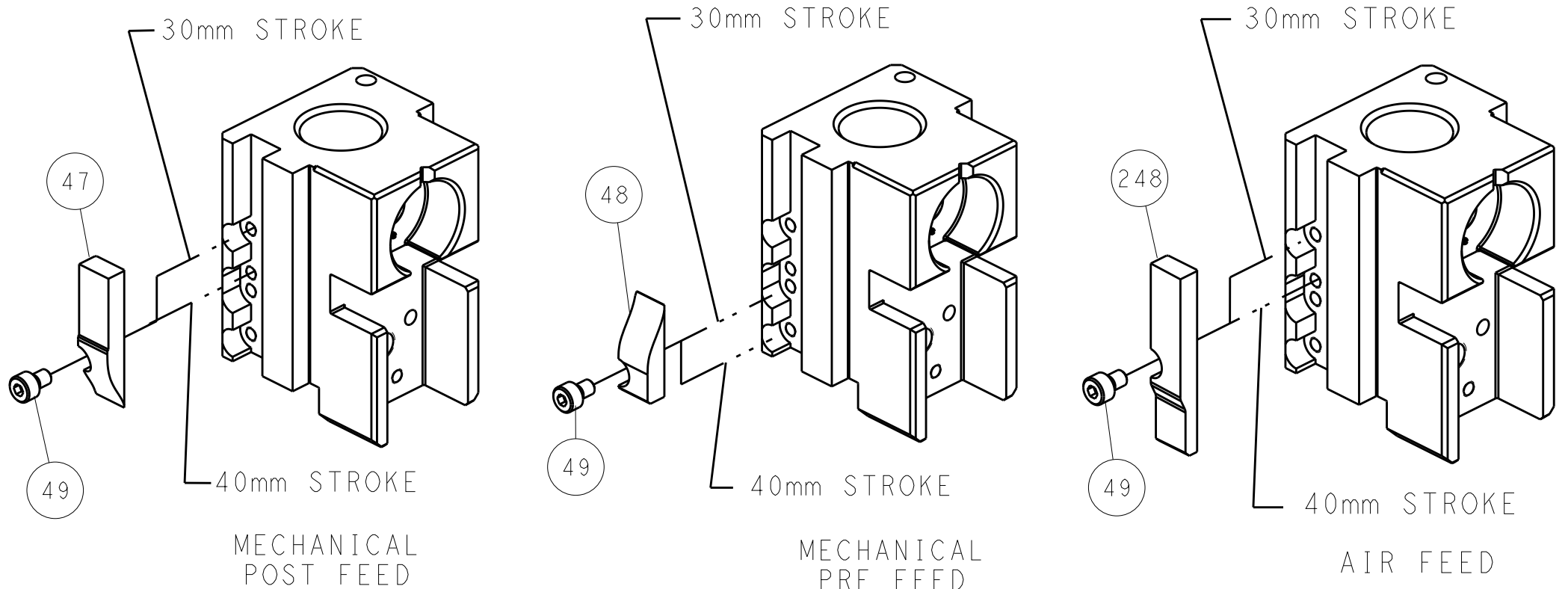


RAM SET-UP



FEED TRACK POSITION
GUIDE BY INSULATION BARREL

CAM POSITIONS

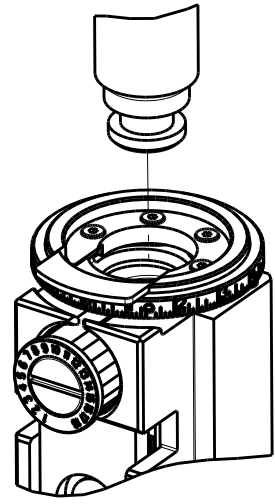


ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

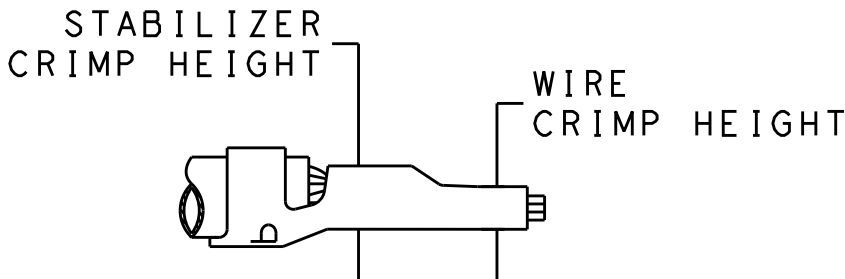
THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. ANY CHANGES TO THIS DRAWING SHOULD BE CONTACTED FOR THE LATEST REVISION.				DWN M. RILEY 09-JUN-16 CHK R. KNEPPER 09-JUN-16 APVD G. BAILEY 09-JUN-16				TE Connectivity Harrisburg, PA 17105-3608			
DIMENSIONS:				TOLERANCES UNLESS OTHERWISE SPECIFIED:				NAME Ocean Side Feed Applicator			
mm				0 PLC ±.005 1 PLC ±.005 2 PLC ±.005 3 PLC ±.005 4 PLC ±.005				SIZE A1			
MATERIAL				FINISH				CAGE CODE 00779			
Customer Accessible Production Drawing				SCALE 1:2				SHEET 2 OF 4			
								REV C			

8		7	
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20		20	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2151209-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2151209-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151209-*	B	SEE CRIMP TOOLING KIT BELOW	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.57 mm [.062]	F
STABILIZER	1.57 mm [.062]	F
INSULATION	2.79 mm [.110]	F
APPLICATOR INSTRUCTIONS 408-35042		



TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: MINI AMP-IN			
WIRE STRIP LENGTH			INSULATION DIAMETER RANGE
4.45-4.98 mm [.175-.196 IN]			1.52-2.79 mm [.060-.110 IN]
TERMINAL APPLICATION SPECIFICATION		114-1016	
		-	-
		-	-
TERMINALS APPLIED 			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
3-640311-1			

PART NO	REV	WIRE SIZE	WIRE CRIMPER	STABILIZER CRIMPER	INSULATION CRIMPER	ANVIL
7-2151209-7	B	18 AWG	7-1803188-7	1-456403-3	2-2119582-1	1-1633916-4
7-2151209-8	B	22-20 AWG	7-1803188-8	1-456403-3	2-2119582-1	1-1633916-4

WIRE SIZE	CRIMP HEIGHT mm [INCH]	WIRE CRIMPER PART NUMBER	STABLIZER CRIMPER HEIGHT mm [INCH]	STABILIZER CRIMPER PART NUMBER	CRIMP HEIGHT REFERENCE SETTING
18 AWG	0.94+/-0.05 [.037+/- .002]	7-1803188-7	1.40+/-0.05 [.055+/- .002]	1-456403-3	5.0
22-20	0.76+/-0.05 [.030+/- .002]	7-1803188-8			5.0



- 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 ITEM 1 TO BE USED WITH 18 AWG ONLY. ITEM TO BE SHIPPED WITH APPLICATOR.
- 7 ITEM 253 TO BE USED WITH 22-20 AWG ONLY. ITEM TO BE SHIPPED WITH APPLICATOR.
- 8 ITEM 19 MUST BE POSITIONED BETWEEN ITEMS 1 OR 253 AND ITEM 178.
- 9 WHEN RUNNING APPLICATOR IN BENCH MACHINE WIRE MUST BE PLACED IN WIRE BARREL IN ORDER TO ACHIEVE PROPER BRUSH LENGTH.

*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)

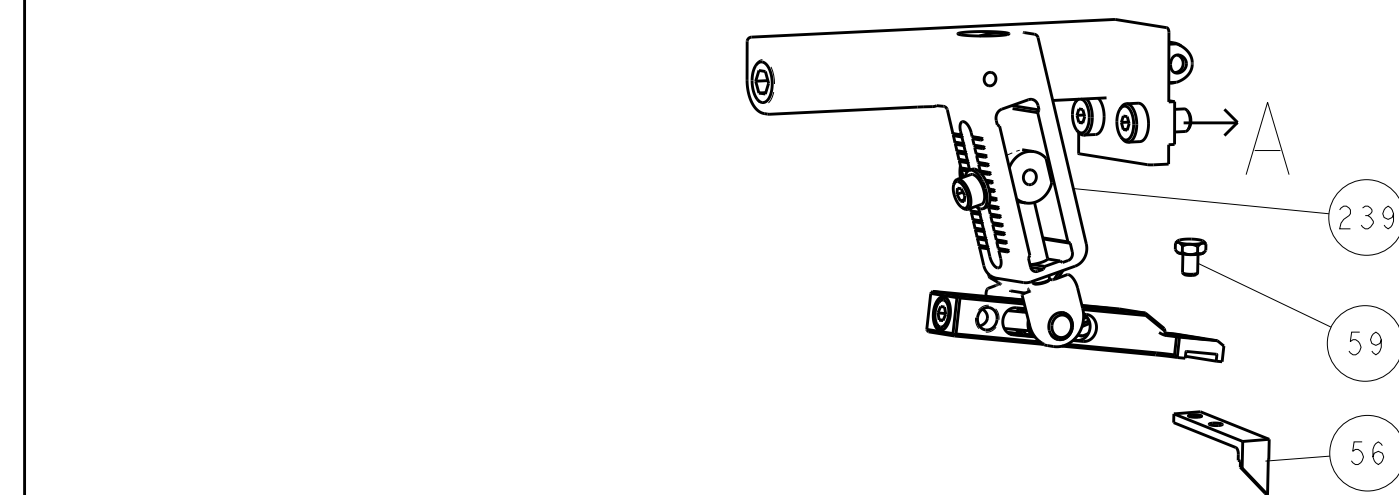
LOC	DIST	REVISIONS					
A	66	P	LTR	DESCRIPTION	DATE	DWN	APVD
			-	SEE SHEET 1	-	-	-

1	-	1	1	7-1803188-8	CRIMPER, WIRE	253
-	-	1	-	2119640-1	PUSH ROD, AIR FEED	250
-	-	1	-	1803259-1	BUSHING, FLANGED	249
-	-	1	1	2119082-4	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
3	-	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
1	1	1	1	1-456403-3	CRIMPER, WIRE PREMIUM	178
-	-	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
-	-	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	-	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854	137
-	-	1	-	2119799-1	HOLDER, FEED FINGER, AF	136
-	-	1	1	455888-8	SPACER, CRIMPER	128
-	-	1	1	2844908-1	SCREW, LOCKING	99
-	-	1	1	2844907-1	POST, LOCKING	98
-	-	1	1	455888-4	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
-	-	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	2-2844962-6	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
8	-	1	1	2119533-4	STRIPPER, SIDE FEED	19
1	-	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	1	2119805-1	SHEAR HOLDER, FRONT	10
1	-	1	1	1803095-1	FLOATING SHEAR, FRONT -	9
1	1	1	1	1-1633916-4	ANVIL, COMBINATION	8
-	-	-	-	-	-	7
-	-	-	-	-	-	6
-	-	1	1	2119757-8	DEPRESSOR, SHEAR	5
-	-	1	1	2-238011-2	BLOCK, CRIMPER SPACER	4
1	1	1	1	2-2119582-1	CRIMPER, INSULATION F PREMIUM	3
-	-	-	-	-	-	2
6	1	1	1	7-1803188-7	CRIMPER, WIRE	1
-78	-77	-22	-21	PART NO	DESCRIPTION	ITEM NO

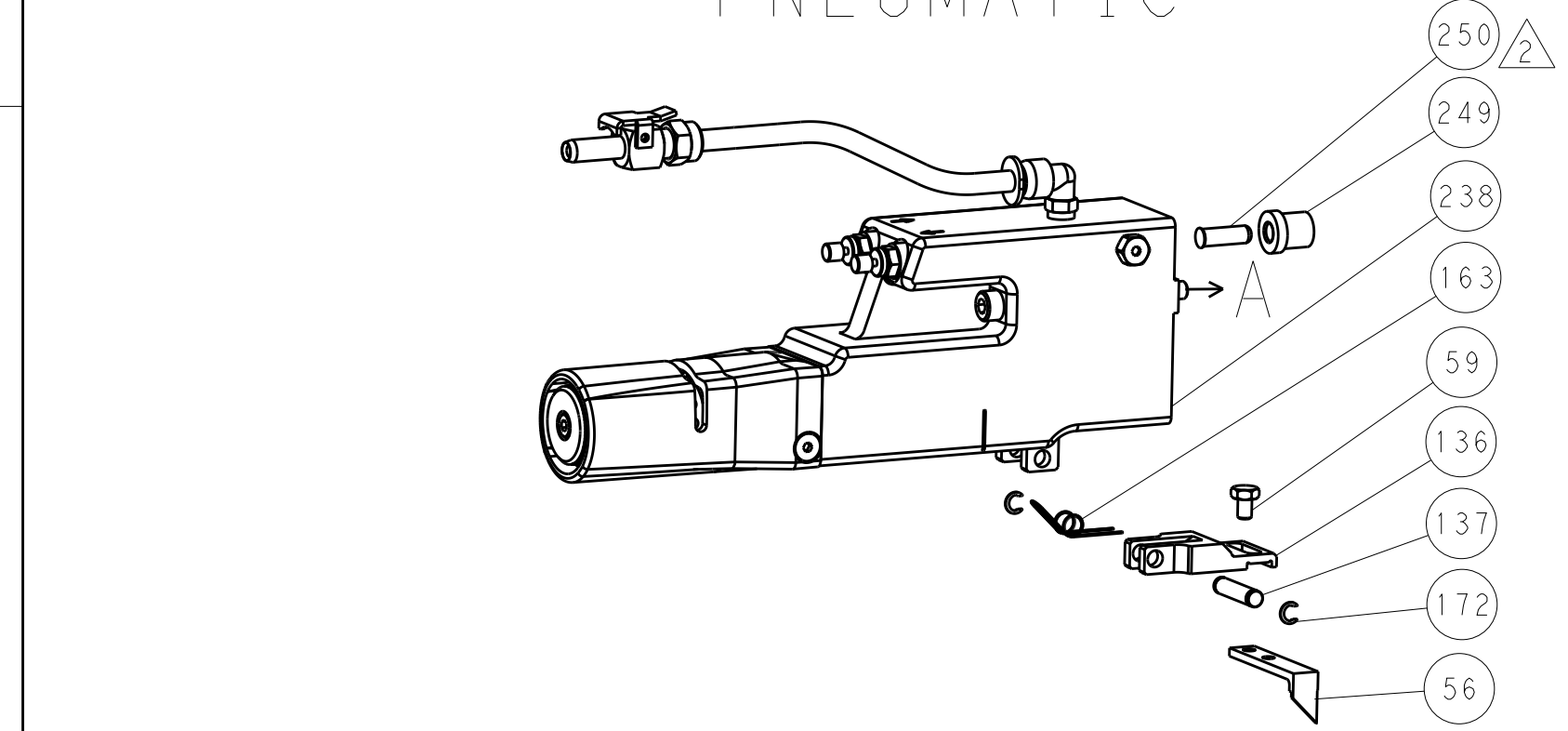
THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE WITHOUT NOTICE AND WITHOUT LIABILITY. THE USER SHALL BE RESPONSIBLE FOR VERIFYING THE LATEST REVISIONS. SHOULD BE CONTACTED FOR THE LATEST REVISIONS.				DWN M. RILEY 09-JUN-16	STE TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS:				CHK R. KNEPPER 09-JUN-16	NAME	
mm				APVD G. BAILEY 09-JUN-16	Ocean Side Feed Applicator	
TOLERANCES UNLESS OTHERWISE SPECIFIED:				PRODUCT SPEC	SIZE	
0 PLC ±.1				APPLICATION SPEC	CAGE CODE	
1 PLC ±.1				WEIGHT	DRAWING NO	
2 PLC ±.1				FINISH	RESTRICTED TO	
3 PLC ±.1					A1 00779	
4 PLC ±.1					©=2151209	
ANGLES					Customer Accessible Production Drawing	
MATERIAL					SCALE	1:2
					SHEET	3 OF 4
					REV	C

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

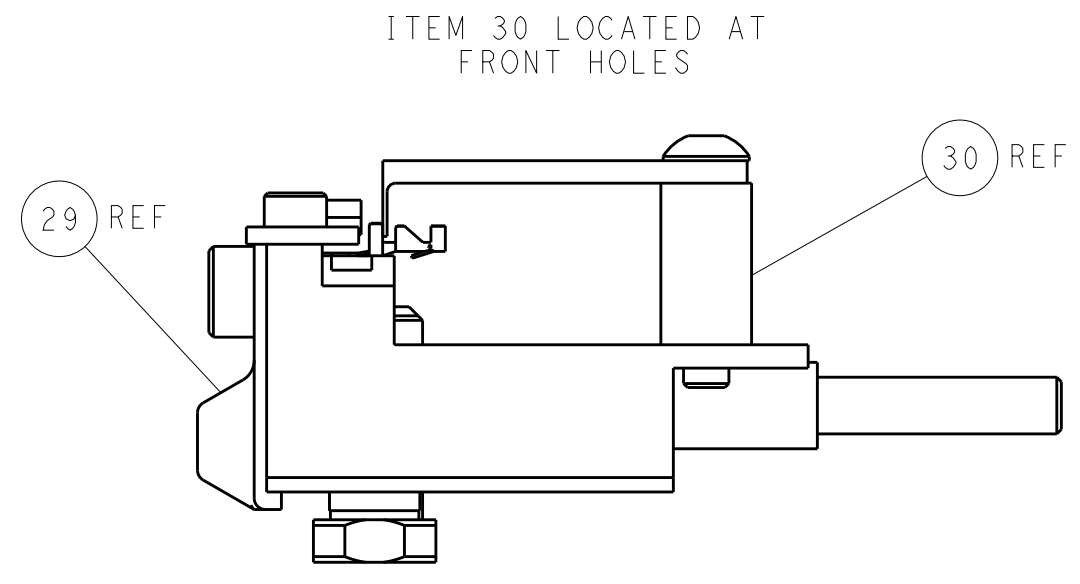
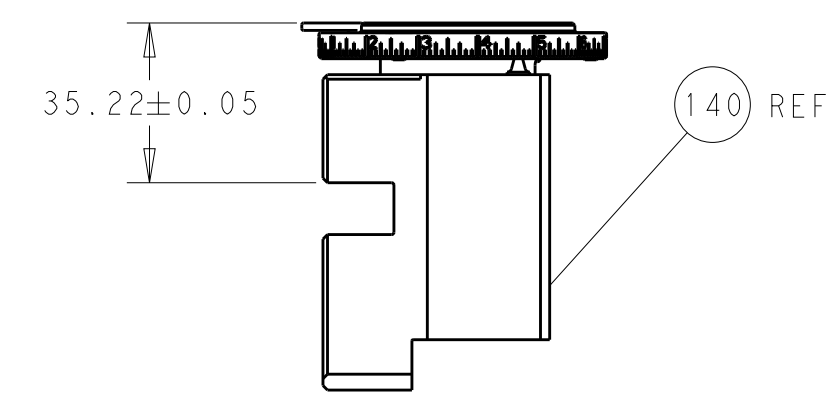
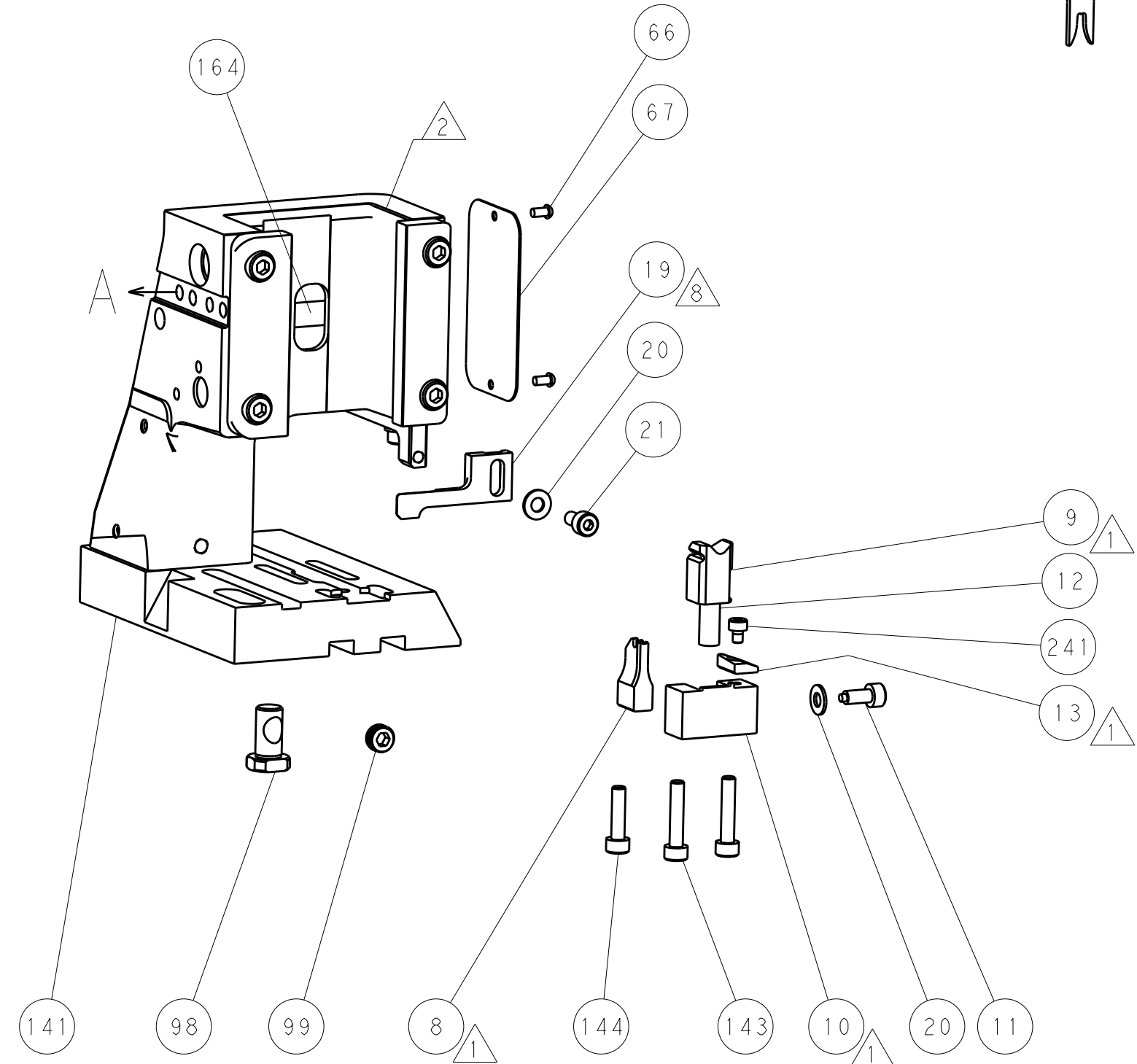
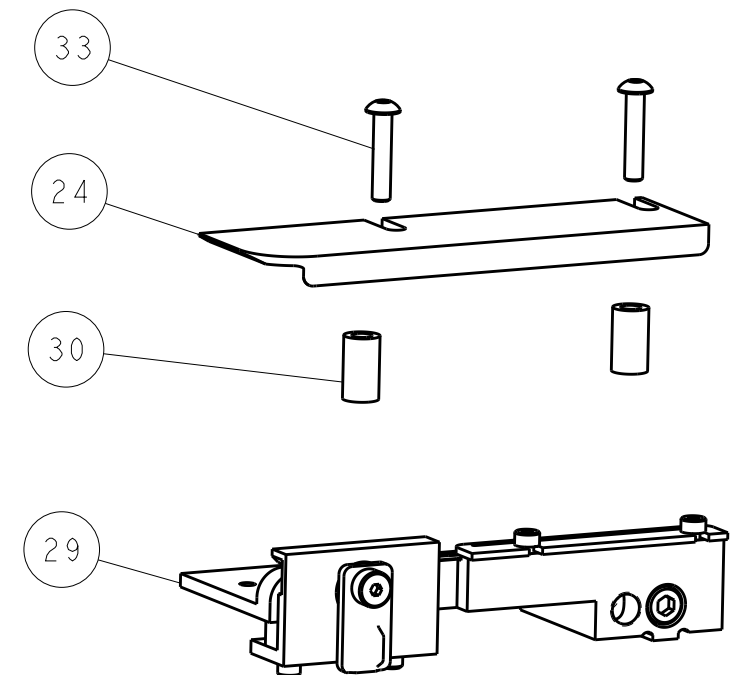
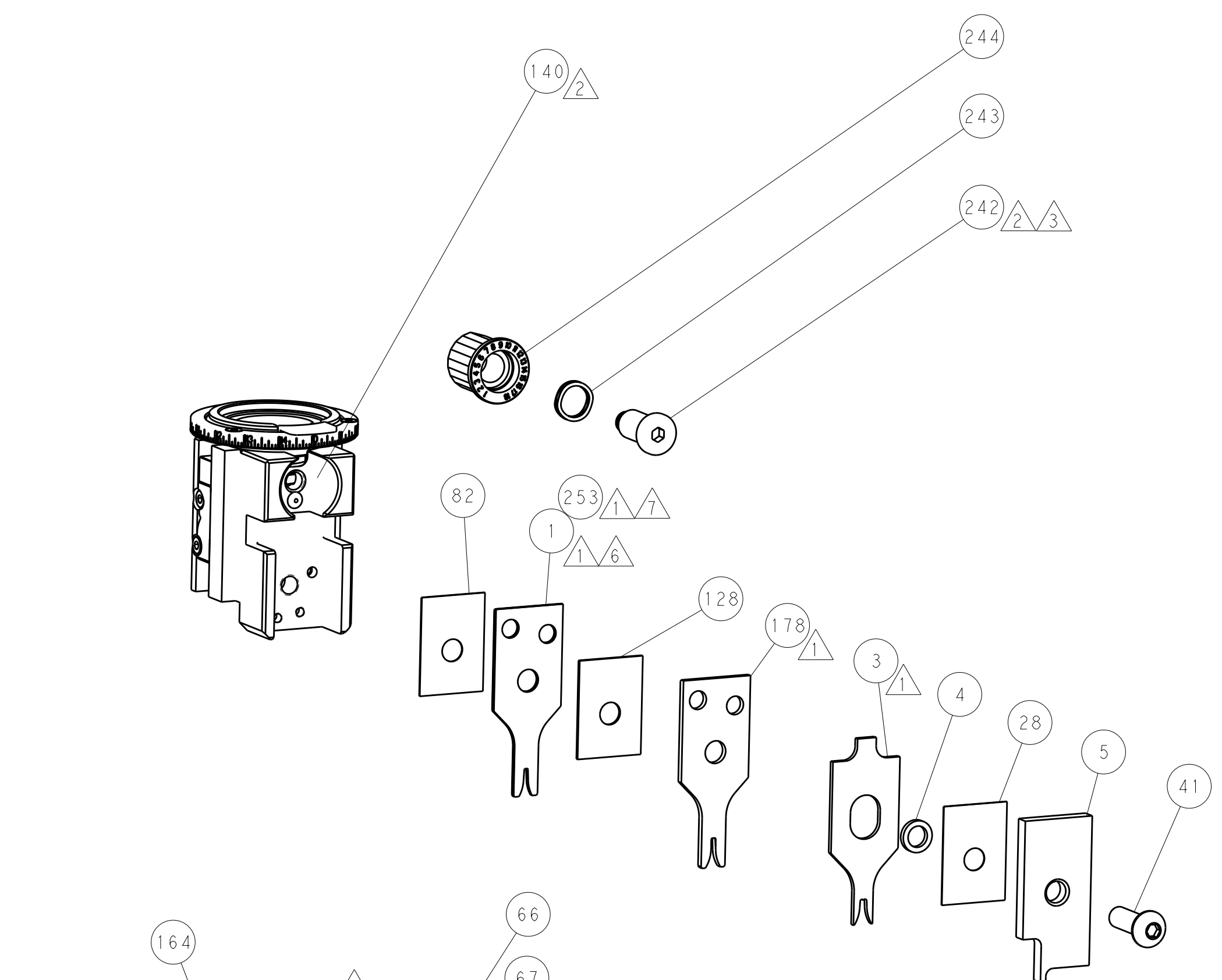
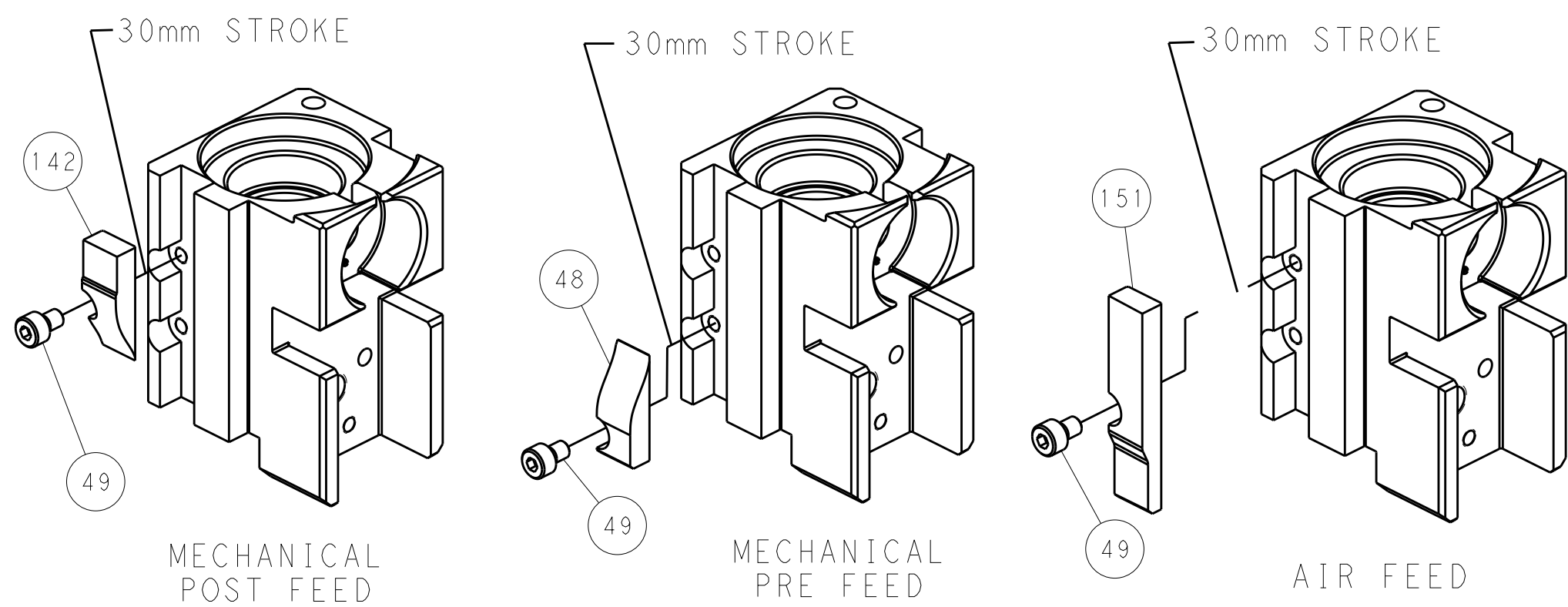
FEED TYPE
MECHANICAL



PNEUMATIC



CAM POSITIONS



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

THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. ANY CHANGES TO THIS DRAWING SHOULD BE CONTACTED FOR THE LATEST VERSION.		OWN: M. RILEY 09-JUN-16	TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm		CHK: R. KNEPPER 09-JUN-16	NAME: Ocean Side Feed Applicator	
		APVD: G. BAILEY 09-JUN-16	SIZE: A1	
		PRODUCT SPEC	CAGE CODE: 00779	
		APPLICATION SPEC	DRAWING NO: 2151209	
		WEIGHT: -	Customer Accessible Production Drawing	
MATERIAL: -		SCALE: 1:2	SHEET: 4 OF 4	REV: C

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