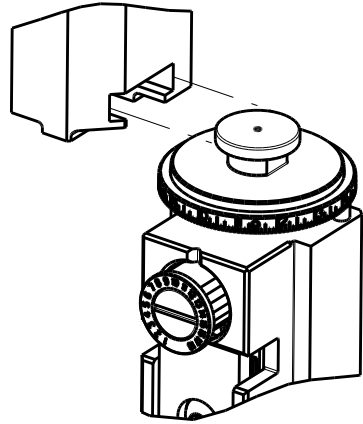


8		7	
THIS DRAWING IS UNPUBLISHED.		RELEASED FOR PUBLICATION	
20		20	
COPYRIGHT 20		BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.	
PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151111-1	E	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2151111-2	E	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151111-1	E	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2151111-2	E	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2151111-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.16 mm [.046]	F
INSUL	1.78 mm [.070]	F
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: DYNAMIC D-1000 SERIES REC CONTACT L TYPE			
WIRE STRIP LENGTH			INSULATION DIAMETER RANGE
1.70-2.30 mm [.067-.091 IN]			Ø1.08-1.90 mm [.043-.075 IN]
TERMINAL APPLICATION SPECIFICATION		(A)114-5377	-
		-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
(A) 1827571-2	(A) 1871304-1	(A) 1903113-2	(A) 1903121-1

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: HD1 CONTACT L SIZE			
WIRE STRIP LENGTH 1.70-2.30 mm [.067-.091 IN]		INSULATION DIAMETER RANGE Ø1.08-1.90 mm [.043-.075 IN]	
TERMINAL APPLICATION SPECIFICATION 		-	-
(B)114-78021		-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
(B) 2316663-3	(B) 2316670-3		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.34-0.37mm2 (22AWG)	0.80+/-0.03 [.031+/- .001]	7.1
0.21-0.23mm2 (24AWG)	0.73+/-0.03 [.029+/- .001]	7.9
0.12-0.15mm2 (26AWG)	0.67+/-0.03 [.026+/- .001]	8.5
0.08-0.10mm2 (28AWG)	0.64+/-0.03 [.025+/- .001]	8.8



1. RECOMMENDED SPARE PARTS
2. REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
3. APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 180. 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.

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
					C	ECR-15-018772	31DEC2015
					D	ECR-18-006952	09MAY2018
					D1	ECR-18-008851	08JUN2018
					E	ECR-18-017879	14NOV2018

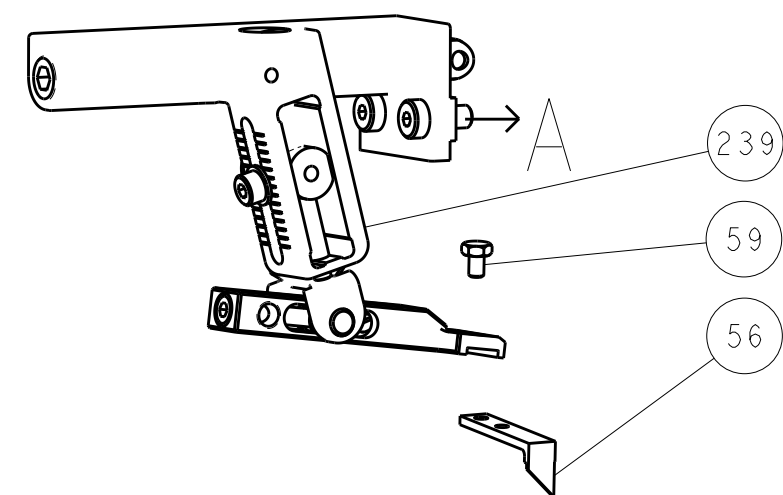
-	1	-	1	-	2119640-1	PUSH ROD, AIR FEED	250
-	1	-	1	-	1803259-1	BUSHING, FLANGED	249
-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248
-	1	1	1	1	2119082-8	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	1	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
-	-	1	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	1	-	1	-	2063440-1	AIR FEED MODULE	238
-	2	2	2	2	1-2079383-0	SCR, BHSC, RoHS (M3 X 6)	230
-	1	1	1	1	1-1752354-5	STANDOFF, HOLD-DOWN	180
-	1	1	1	1	2-1633764-0	HOLD DOWN, TERMINAL	179
-	1	1	1	1	9931111-1	PIN, SLOTTED SPRING 3.0 X 20.0	177
-	1	1	1	1	8-22280-7	SPRING, COMPRESSION	176
-	1	1	1	1	1752353-2	GUIDE PIN, HOLDDOWN	175
-	1	1	1	1	1901680-2	GUIDE PIN, HOLDDOWN	174
-	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	2844908-1	SCREW, LOCKING	99
-	1	1	1	1	2844907-1	POST, LOCKING	98
-	1	1	1	1	1-455888-6	SPACER, CRIMPER	82
-	1	1	1	1	1962431-2	SPRING, COMPRESSION	77
-	1	1	1	1	854769-4	HOLDER, INS	74
-	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	21028-2	PIN, SLOTTED SPRING .062 X .250	58
-	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
-	1	1	1	1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52
-	1	1	1	1	1901681-8	HOLDDOWN, TERMINAL	51
-	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	1803515-3	RAM ASSEMBLY, SF ATLANTIC	44
-	1	1	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
-	1	1	1	1	1-1752356-7	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	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
-	1	1	1	1	1-18028-2	WASHER, FLAT, REG M4	20
-	1	1	1	1	2119533-4	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	1633861-1	SHEAR, FLOATING	9
-	1	2	2	1	2-1729372-8	ANVIL	8
-	1	1	1	1	2119780-4	DEPRESSOR, SHEAR	5
-	1	1	1	1	4-238011-3	BLOCK, CRIMPER SPACER	4
-	1	2	2	1	5-1633962-5	CRIMPER, INSULATION F PREMIUM	3
-	1	1	1	1	455888-2	SPACER, CRIMPER	2
-	1	2	2	1	3-1633730-7	CRIMPER, WIRE	1

THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. THE USER SHALL BE RESPONSIBLE FOR OBTAINING THE LATEST EDITION. TOLERANCES UNLESS OTHERWISE SPECIFIED:				DWN A. HUANG CHK L. ZHANG APVD J. GUO	05MAY2014 05MAY2014 05MAY2014	TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		NAME		Ocean Side Feed Applicator	
mm		0 PLC ±.01 1 PLC ±.01 2 PLC ±.01 3 PLC ±.01 4 PLC ±.01 ANGLES ±.01		PRODUCT SPEC		SIZE	
MATERIAL		FINISH		APPLICATION SPEC		CAGE CODE	
				WEIGHT		DRAWING NO	
				Customer Accessible Production Drawing		RESTRICTED TO	
				SCALE		REV	
				1:2		E	

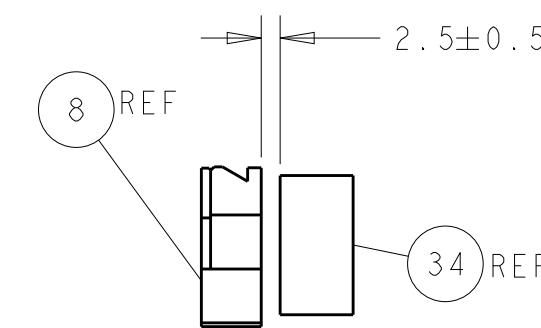
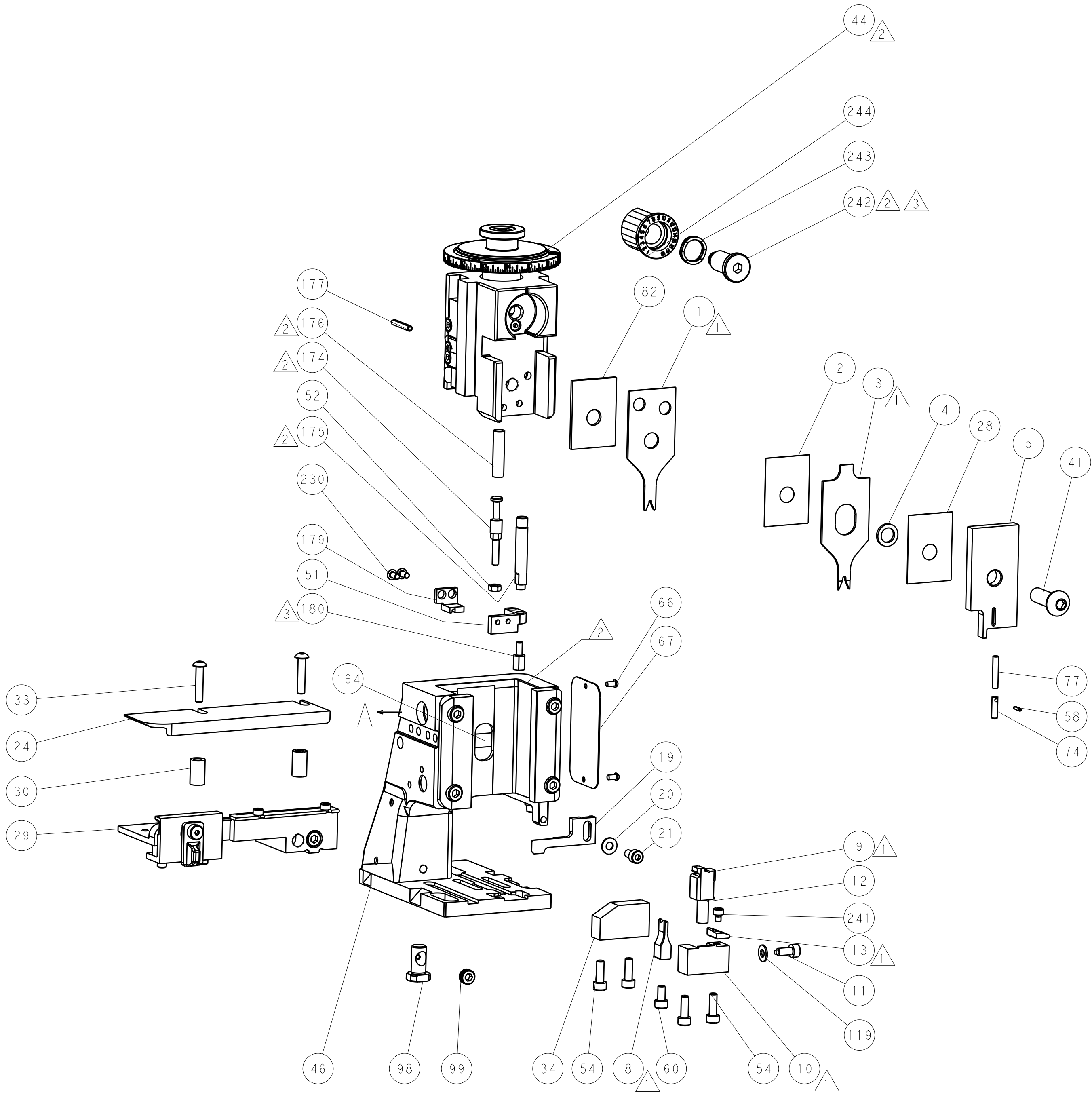
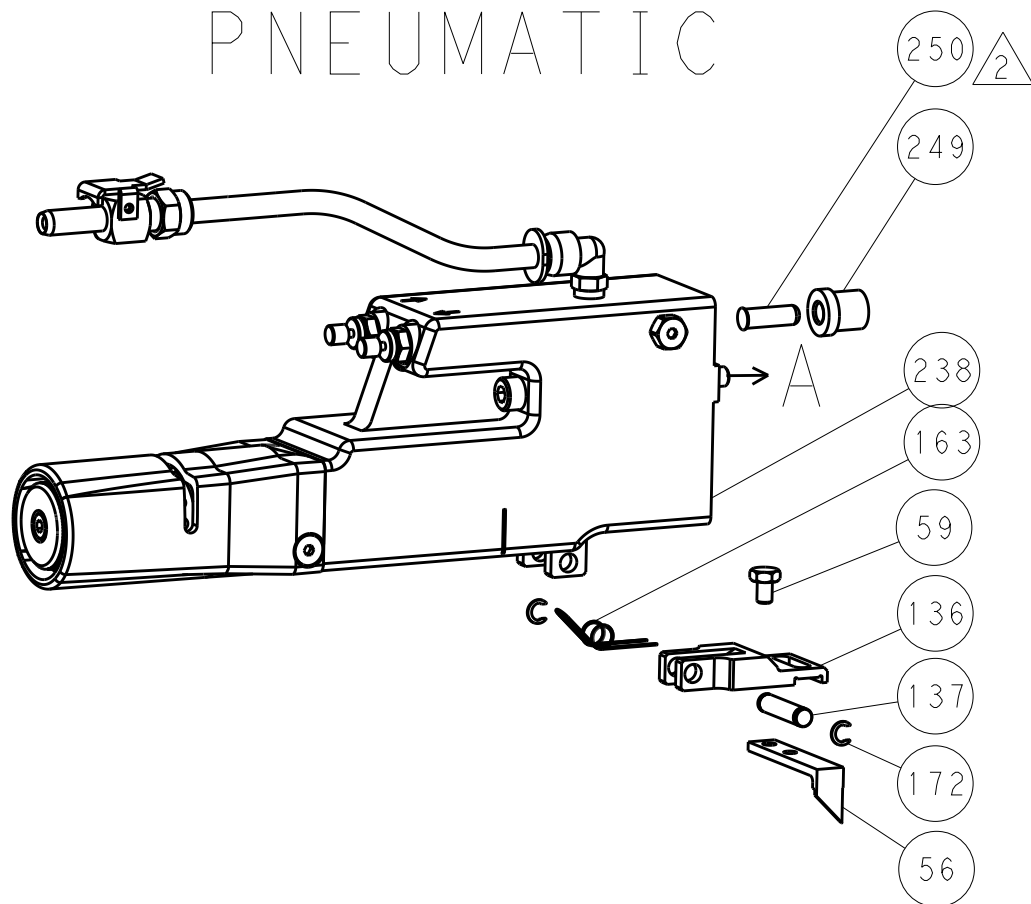
SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

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

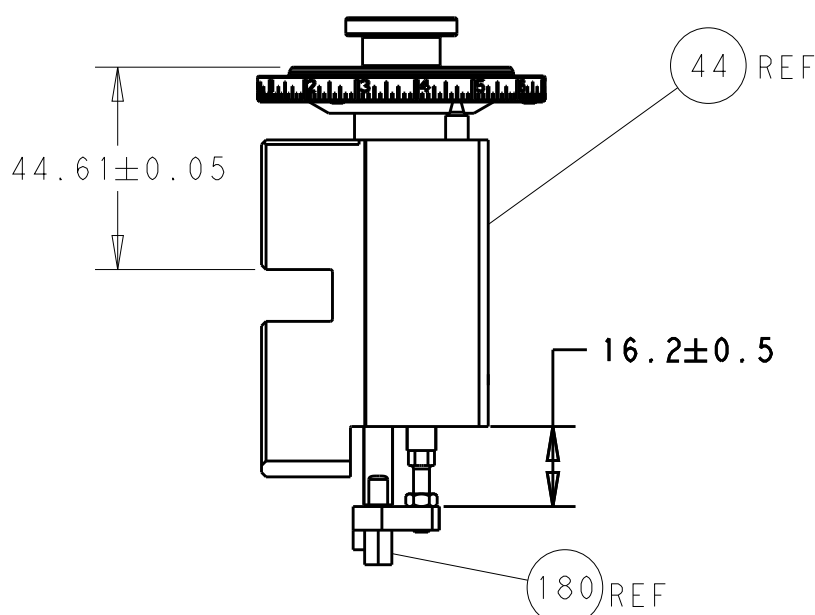
FEED TYPE
MECHANICAL



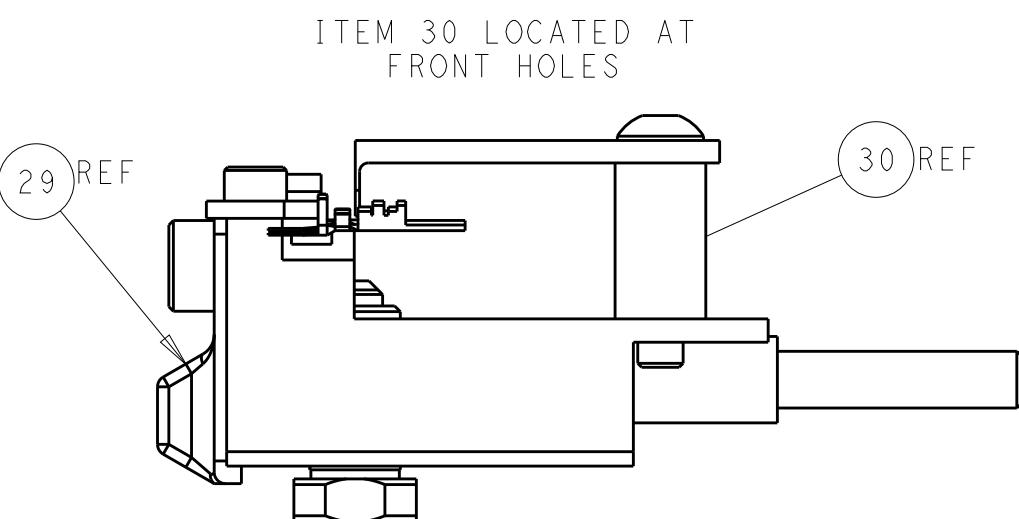
PNEUMATIC



TERMINAL SUPPORT LOCATION

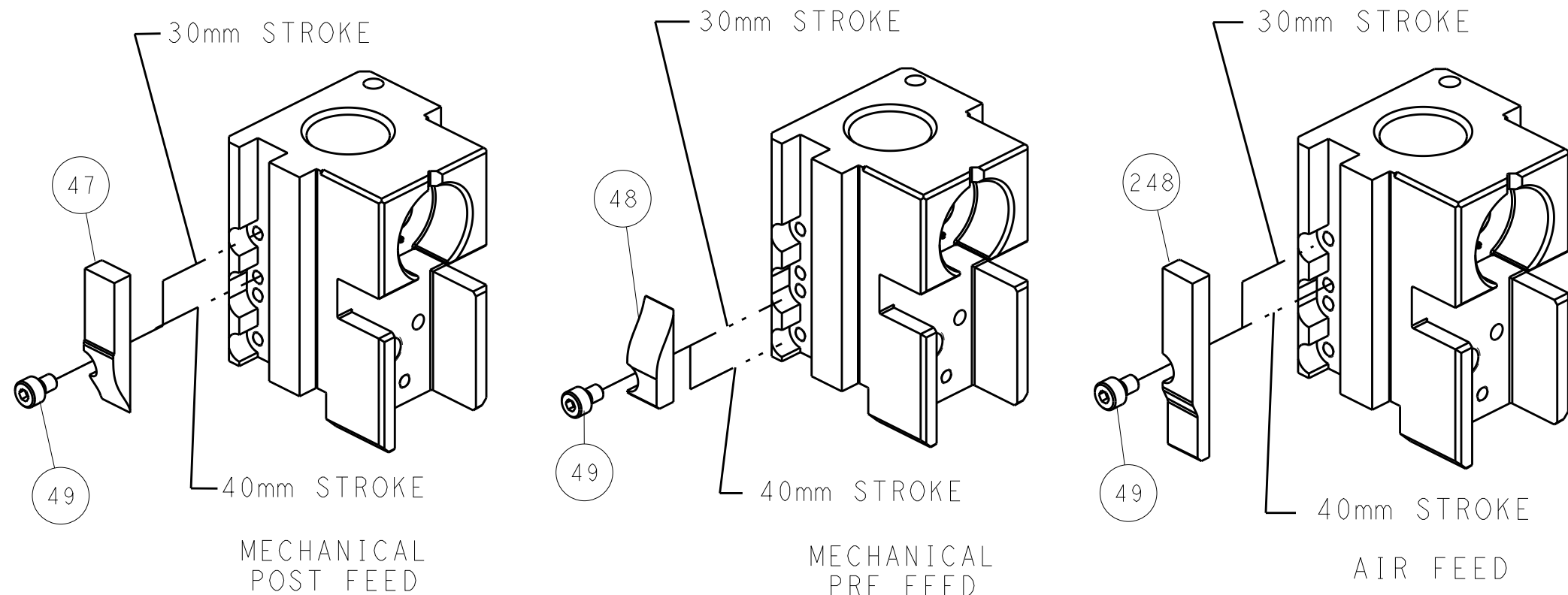


RAM AND HOLDDOWN SET-UP



FEED TRACK POSITION
GUIDE BY INSULATION BARREL

CAM POSITIONS

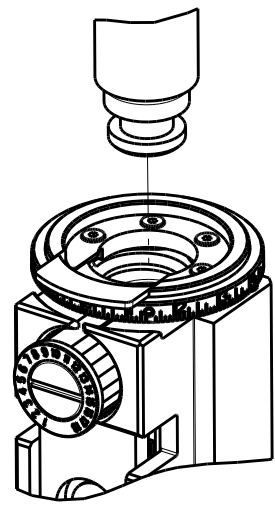


ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN		CHK		APVD		NAME		SIZE		CAGE CODE		DRAWING NO		RESTRICTED TO	
mm		0 PLC ±0.5		K. HUANG		L. ZHANG		J. GUO		Ocean Side Feed Applicator		A1		00779		C=2151111		-	
MATERIAL		FINISH		WEIGHT		Customer Accessible Production Drawing		SCALE		1:2		SHEET		2		OF		4	

THIS DRAWING IS UNPUBLISHED.	RELEASED FOR PUBLICATION	20
© COPYRIGHT 20 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.		

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2151111-1	E	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2151111-2	E	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151111-7	A	CRIMP TOOLING KIT	-

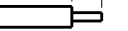


APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.16 mm [.046]	F
INSUL	1.78 mm [.070]	F

APPLICATOR INSTRUCTIONS
408-35042



TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: DYNAMIC D-1000 SERIES REC CONTACT L TYPE			
WIRE STRIP LENGTH 1.70-2.30 mm [.067-.091 IN]		INSULATION DIAMETER RANGE Ø1.08-1.90 mm [.043-.075 IN]	
TERMINAL APPLICATION 		(A) 114-5377	
SPECIFICATION		-	
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
(A) 1827571-2	(A) 1871304-1	(A) 1903113-2	(A) 1903121-1

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: HD1 CONTACT		L SIZE	
WIRE STRIP LENGTH 1.70-2.30 mm [.067-.091 IN]		INSULATION DIAMETER RANGE Ø1.08-1.90 mm [.043-.075 IN]	
TERMINAL APPLICATION SPECIFICATION	 (B)114-78021	-	-
TERMINALS APPLIED			
TE TERMINAL (B) 2316663-3	TE TERMINAL (B) 2316670-3	TE TERMINAL	TE TERMINAL

WIRE SIZE			CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING
0.34 - 0.37mm2 (22AWG)			0.80+/- 0.03 [0.031+/- .001]		7.1
0.21 - 0.23mm2 (24AWG)			0.73+/- 0.03 [0.029+/- .001]		7.9
0.12 - 0.15mm2 (26AWG)			0.67+/- 0.03 [0.026+/- .001]		8.5
0.08 - 0.10mm2 (28AWG)			0.64+/- 0.03 [0.025+/- .001]		8.8

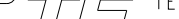


1. RECOMMENDED SPARE PARTS
2. REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
3. APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 180.
APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242.
4. CRIMP HEIGHT REFERENCE SETTING WAS THE SETTING USED WHEN 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.

[illegible]

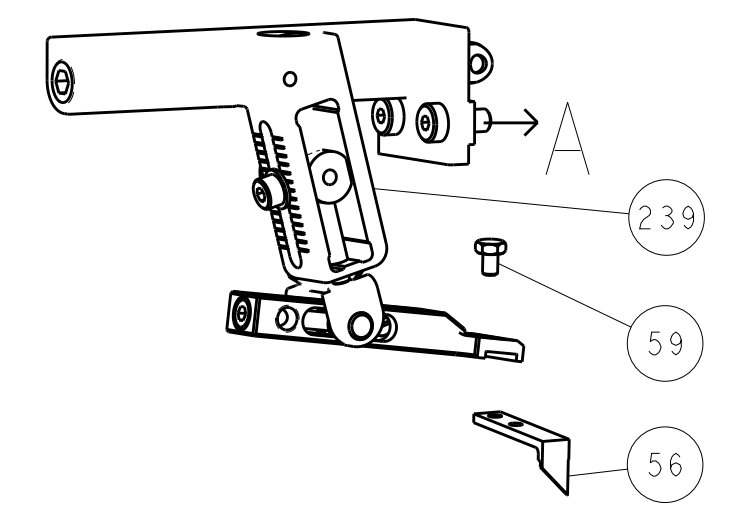
	-	1	-	2119640-1	PUSH ROD, AIR FEED	250
	-	1	-	1803259-1	BUSHING, FLANGED	249
	-	1	1	2119082-8	CAM, SNAIL, INSULATION ADJUSTMENT	244
	-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
3	-	1	1	2119083-1	RETAINER, INSULATION DIAL	242
	-	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
	-	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
	-	1	-	2063440-1	AIR FEED MODULE	238
	-	2	2	1-2079383-0	SCR, BHSC, RoHS (M3 X 6)	230
3	-	1	1	1-1752354-5	STANDOFF, HOLD-DOWN	180
	-	1	1	2-1633764-0	HOLD DOWN, TERMINAL	179
	-	1	1	9931111-1	PIN, SLOTTED SPRING 3.0 X 20.0	177
	-	1	1	8-22280-7	SPRING, COMPRESSION	176
	-	1	1	1752353-2	GUIDE PIN,HOLDDOWN	175
	-	1	1	1901680-2	GUIDE PIN,HOLDDOWN	174
	-	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	2844908-1	SCREW, LOCKING	99
	-	1	1	2844907-1	POST, LOCKING	98
	-	1	1	1-455888-6	SPACER, CRIMPER	82
	-	1	1	1962431-2	SPRING, COMPRESSION	77
	-	1	1	854769-4	HOLDER, INS	74
	-	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	21028-2	PIN, SLOTTED SPRING .062 X .250	58
	-	1	1	1338685-1	PAWL, FEED	56
	-	1	1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52
	-	1	1	1901681-8	HOLDDOWN, TERMINAL	51
	-	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	1-1752356-7	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	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
	-	1	1	1-18028-2	WASHER, FLAT, REG M4	20
	-	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	1633861-1	SHEAR, FLOATING	9
1	1	1	1	2-1729372-8	ANVIL	8
	-	1	1	2119780-4	DEPRESSOR, SHEAR	5
	-	1	1	4-238011-3	BLOCK, CRIMPER SPACER	4
1	1	1	1	5-1633962-5	CRIMPER, INSULATION F PREMIUM	3
	-	1	1	455888-2	SPACER, CRIMPER	2
1	1	1	1	3-1633730-7	CRIMPER, WIRE	1

THIS DRAWING IS THE PROPERTY OF THE COMPANY AND IS NOT TO BE REPRODUCED OR COPIED IN ANY MANNER WITHOUT THE WRITTEN PERMISSION OF THE COMPANY. IT IS TO BE USED ONLY FOR THE PROJECT AND PURPOSE SPECIFIED BY THE COMPANY. IT IS TO BE RETURNED TO THE COMPANY WHEN NO LONGER REQUIRED.		OWN C. HUANG 05MAY2014		 TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		NAME	
mm		0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± ANGLES ±		Ocean Side Feed Applicator	
		PRODUCT SPEC		SIZE	
MATERIAL		APPLICATION SPEC		CAGE CODE	
FINISH		WEIGHT		DRAWING NO	
-		-		A 00779 C=2151111	
-		Customer Accessible Production Drawing		SCALE 1:2 SHEET 3 OF 4 REV E	

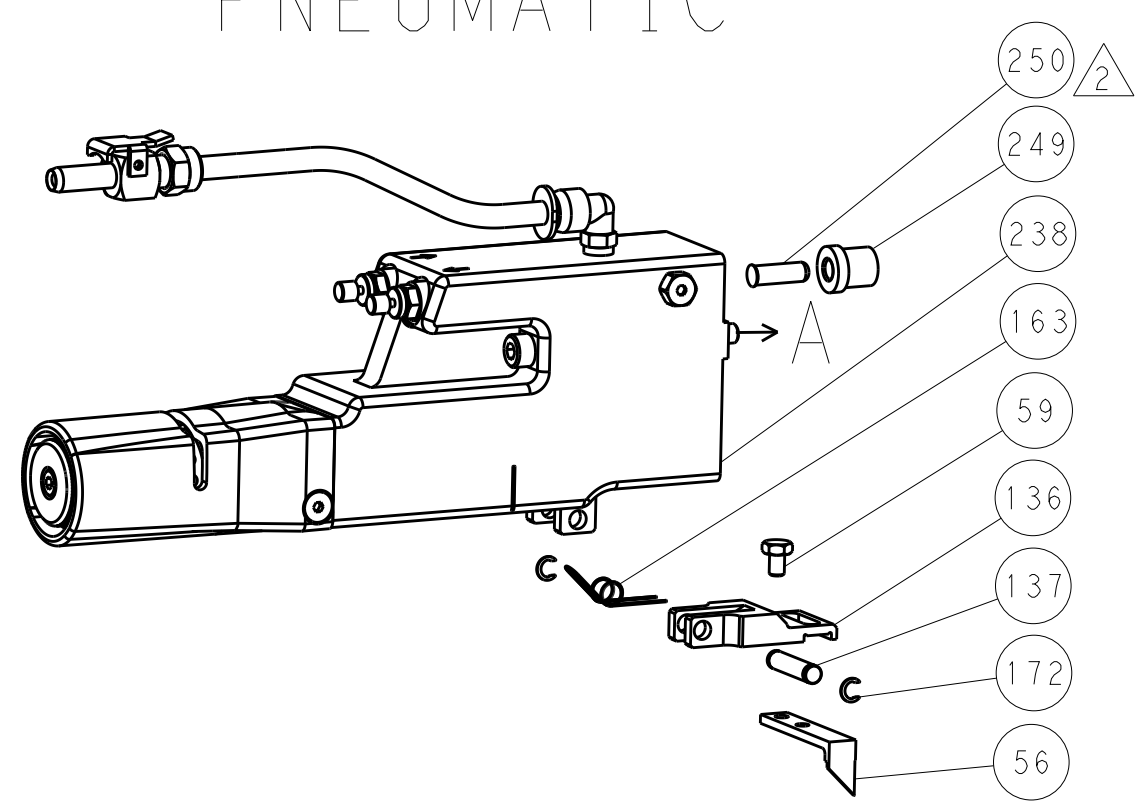
SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

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

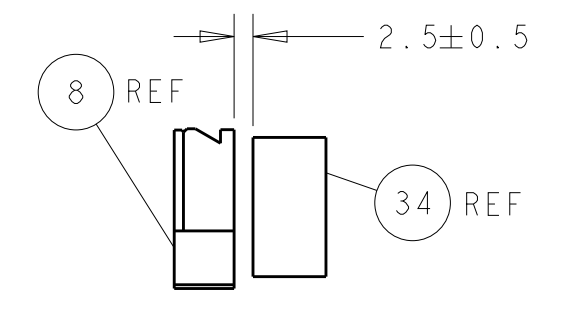
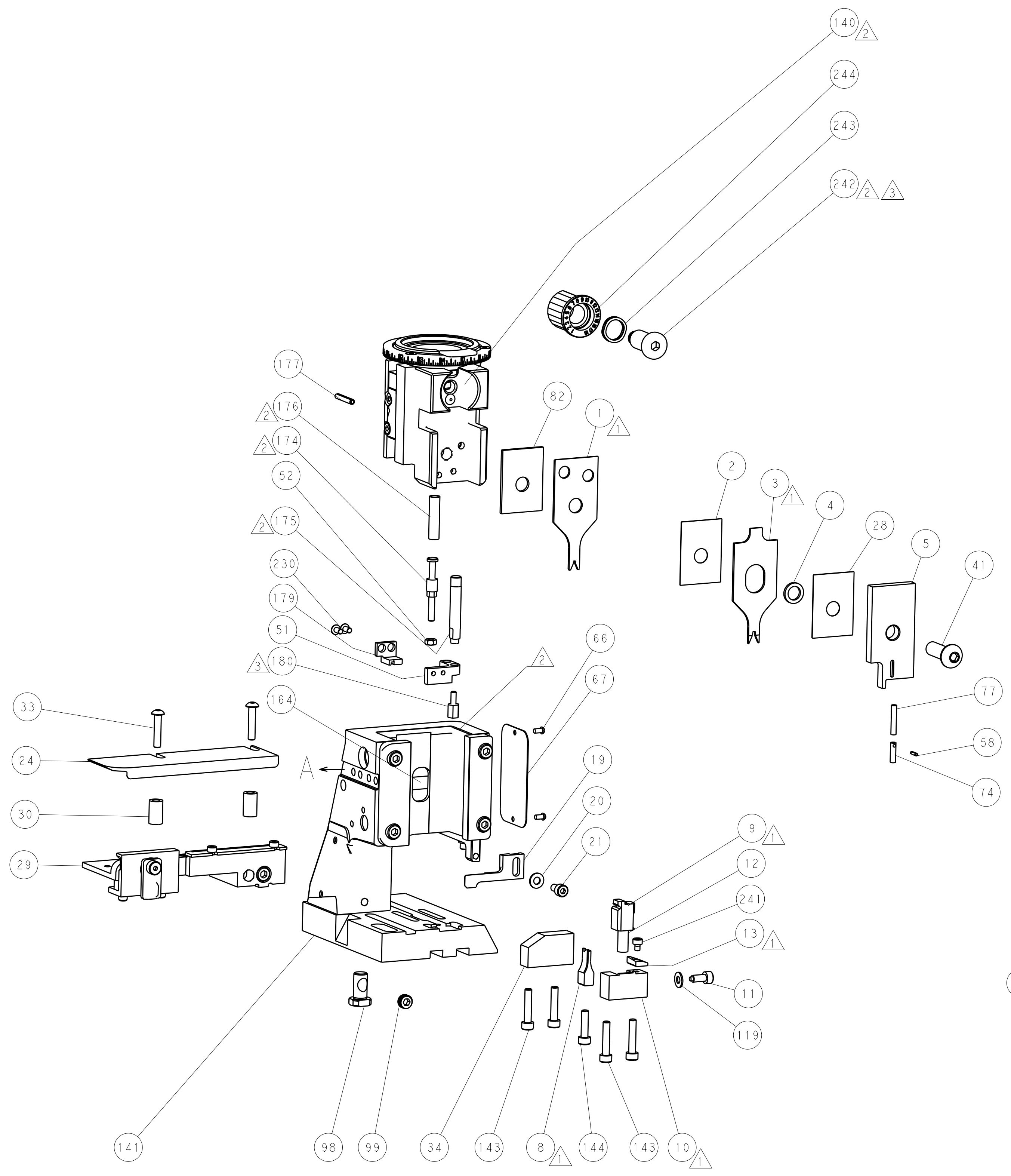
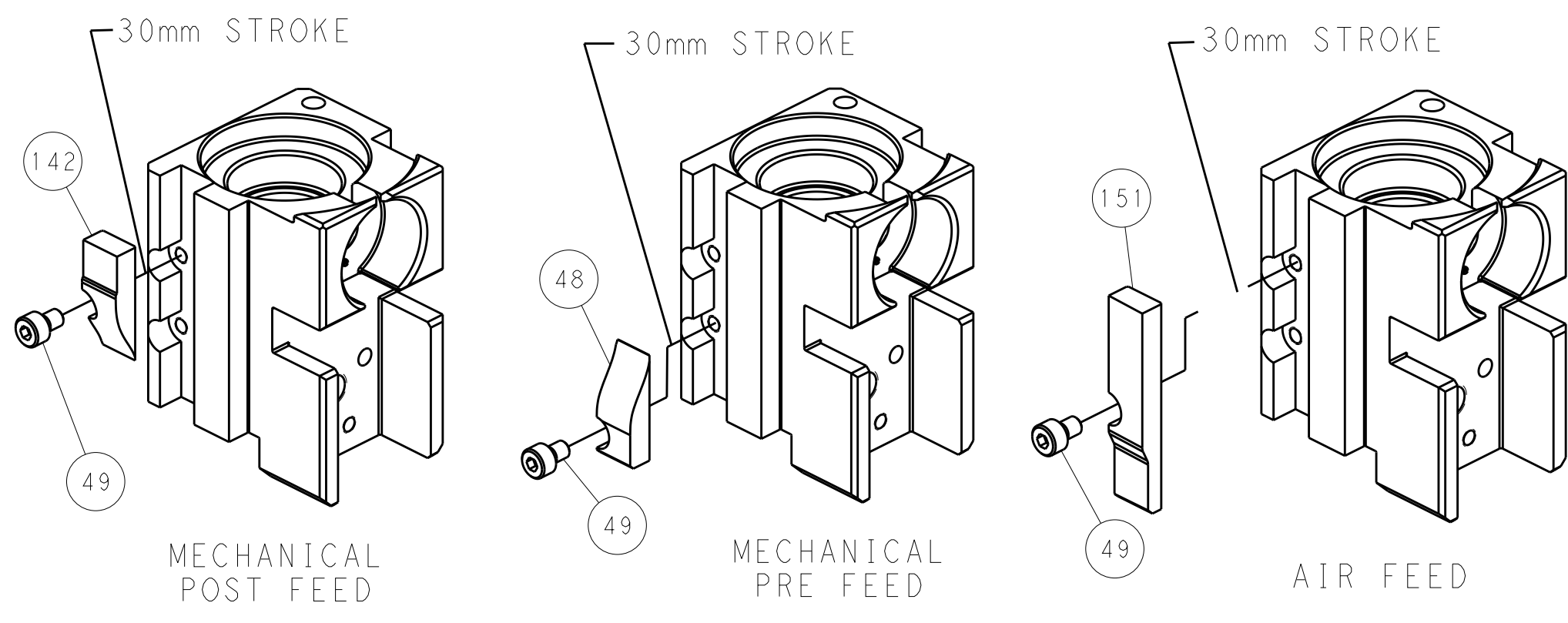
FEED TYPE
MECHANICAL



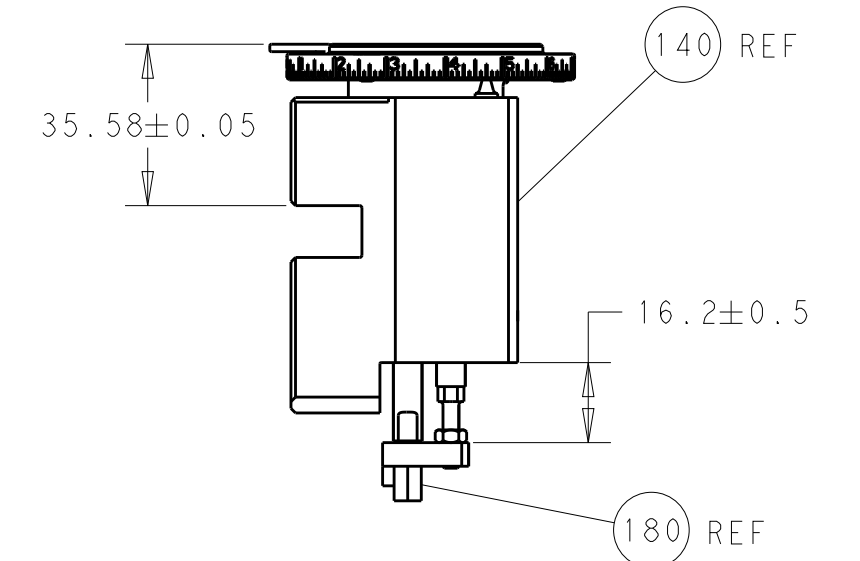
PNEUMATIC



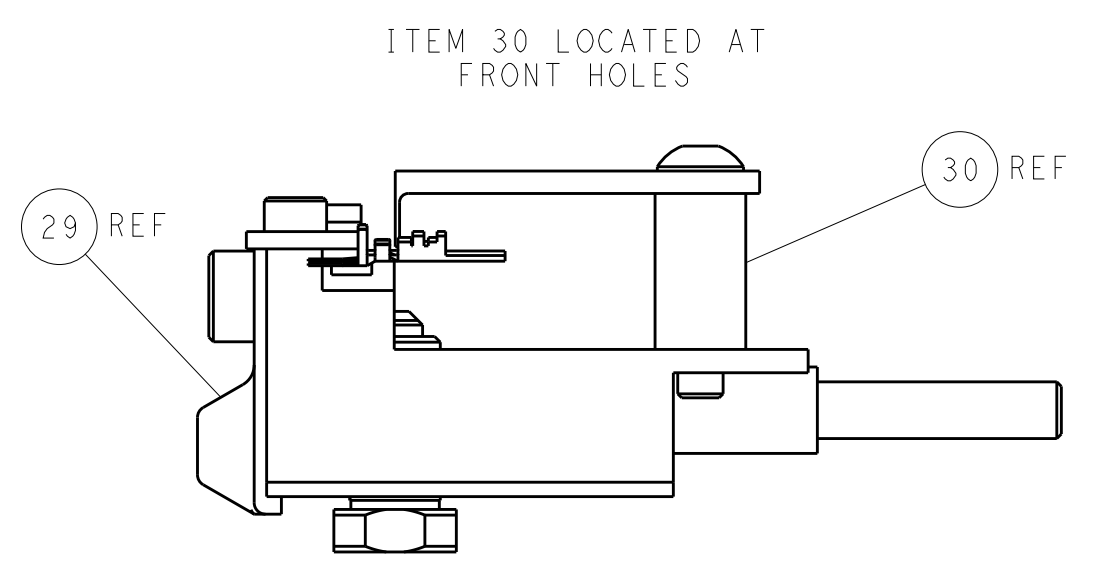
CAM POSITIONS



TERMINAL SUPPORT LOCATION



RAM AND HOLDDOWN SET-UP



FEED TRACK POSITION GUIDE BY INSULATION BARREL

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 K. HUANG 05MAY2014		CHK L. ZHANG 05MAY2014		APVD J. GUO 05MAY2014		NAME	
mm		0 PLC ±.01		PRODUCT SPEC		APPLICATION SPEC		SIZE		CAGE CODE	
MATERIAL		FINISH		WEIGHT		Customer Accessible Production Drawing		SCALE		SHEET	
								1:2		4 OF 4	
										REV	
										E	

Mouser Electronics

Authorized Distributor

Click to View Pricing, Inventory, Delivery & Lifecycle Information:

[TE Connectivity:](#)

[2-2151111-1](#)