

| 8                                                                    |          | 7                                         |            |
|----------------------------------------------------------------------|----------|-------------------------------------------|------------|
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| PART<br>NUMBER                                                       | REVISION | DESCRIPTION                               | FEED TYPE  |
| 2151639-1                                                            | H        | FINE CRIMP HEIGHT ADJUST                  | MECHANICAL |
| 2151639-2                                                            | J        | FINE CRIMP HEIGHT ADJUST                  | PNEUMATIC  |
| 5-2151639-1                                                          | H        | SEAL STRIPPER CRIMPER<br>TERMINATING UNIT | MECHANICAL |
| 5-2151639-2                                                          | J        | SEAL STRIPPER CRIMPER<br>TERMINATING UNIT | PNEUMATIC  |
| 7-2151639-1                                                          | H        | MECHANICAL AND CRIMP<br>TOOLING KIT       | MECHANICAL |
| 7-2151639-2                                                          | J        | PNEUMATIC AND CRIMP<br>TOOLING KIT        | PNEUMATIC  |
| 7-2151639-7                                                          | G        | CRIMP TOOLING KIT                         | -          |

| APPLICATOR DATA                      |                 |      |
|--------------------------------------|-----------------|------|
| CRIMP                                | SIZE            | TYPE |
| WIRE                                 | 1.40 mm [ .055] | F    |
| INSUL                                | 1.78 mm [ .070] | O    |
| STAB                                 | 1.91 mm [ .075] | O    |
| APPLICATOR INSTRUCTIONS<br>408-35042 |                 |      |

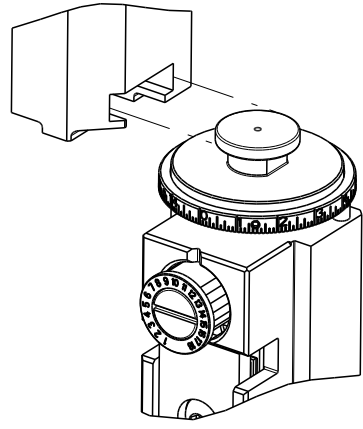
|                                                  |             |                                                           |             |
|--------------------------------------------------|-------------|-----------------------------------------------------------|-------------|
| TERMINAL DATA: TE TERMINAL                       |             | TE CRIMP SPECIFICATION                                    |             |
| TERMINAL NAME: CONTACT ASSEMBLY, LOCKING CLIP    |             |                                                           |             |
| WIRE STRIP LENGTH<br>.111-.126 IN [2.82-3.20 mm] |             | INSULATION DIAMETER RANGE<br>Ø.038-.062 IN [0.97-1.57 mm] |             |
| TERMINAL APPLICATION SPECIFICATION<br>114-25006  |             | -                                                         |             |
| TERMINAL APPLICATION SPECIFICATION<br>-          |             | -                                                         |             |
| TERMINALS APPLIED                                |             |                                                           |             |
| TE TERMINAL                                      | TE TERMINAL | TE TERMINAL                                               | TE TERMINAL |
| 87124-1                                          | 87124-2     | 87124-3                                                   | 5-87124-2   |
| 2267356-1                                        |             |                                                           |             |

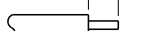
| WIRE SIZE | CRIMP HEIGHT INCH [mm]      | CRIMP HEIGHT REFERENCE SETTING | STABILIZER CRIMP HEIGHT mm [INCH]  | TE HOUSING    |
|-----------|-----------------------------|--------------------------------|------------------------------------|---------------|
| 22 AWG    | 0.86+/-0.05 [0.034+/-0.002] | 7.1                            | 2.44 +0.0/-0.2 [ .096 +0.0/-0.008] | 926010/868781 |
| 24 AWG    | 0.76+/-0.05 [0.030+/-0.002] | 8.1                            | 2.44 +0.0/-0.2 [ .096 +0.0/-0.008] | 926010/868781 |
| 26 AWG    | 0.76+/-0.05 [0.030+/-0.002] | 8.1                            | 2.44 +0.0/-0.2 [ .096 +0.0/-0.008] | 926010/868781 |



- 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.
- TERMINAL LUBRICANT IS RECOMMENDED.
6. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- APPLICATOR WAS QUALIFIED TO STABILIZER CRIMP HEIGHT LISTED FOR TERMINAL AND HOUSING COMBINATION ONLY. THIS HEIGHT VARIES FROM 114 SPEIFICATION.

ATLANTIC VERSION TERMINATOR  
INTERFACE ADAPTER



|                                                                                                                                                                                           |             |                                                                                     |                                                           |
|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-------------|-------------------------------------------------------------------------------------|-----------------------------------------------------------|
| TERMINAL DATA: TE TERMINAL                                                                                                                                                                |             | TE CRIMP SPECIFICATION                                                              |                                                           |
| TERMINAL NAME: CONTACT ASSEMBLY, LOCKING CLIP                                                                                                                                             |             |                                                                                     |                                                           |
| WIRE STRIP LENGTH<br>.111-.126 IN [2.82-3.20 mm]                                                                                                                                          |             |  | INSULATION DIAMETER RANGE<br>Ø.038-.062 IN [0.97-1.57 mm] |
| TERMINAL APPLICATION SPECIFICATION                                                                                                                                                        | 114-25006   |  | -                                                         |
|                                                                                                                                                                                           | -           | -                                                                                   | -                                                         |
| TERMINALS APPLIED   |             |                                                                                     |                                                           |
| TE TERMINAL                                                                                                                                                                               | TE TERMINAL | TE TERMINAL                                                                         | TE TERMINAL                                               |
| 867052-1                                                                                                                                                                                  | 867052-2    | 5-867052-1                                                                          |                                                           |

| WIRE SIZE | CRIMP HEIGHT mm [INCH]      | CRIMP HEIGHT REFERENCE SETTING | STABILIZER CRIMP HEIGHT mm [INCH]  | TE HOUSING    |
|-----------|-----------------------------|--------------------------------|------------------------------------|---------------|
| 20 AWG    | 1.02+/-0.05 [0.040+/-0.002] | 5.6                            | 2.44 +0.0/-0.2 [ .096 +0.0/-0.008] | 926010/868781 |

\*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.

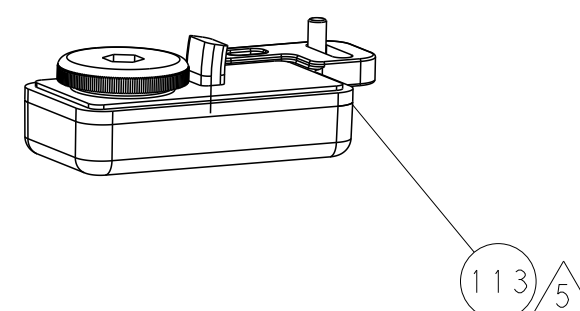
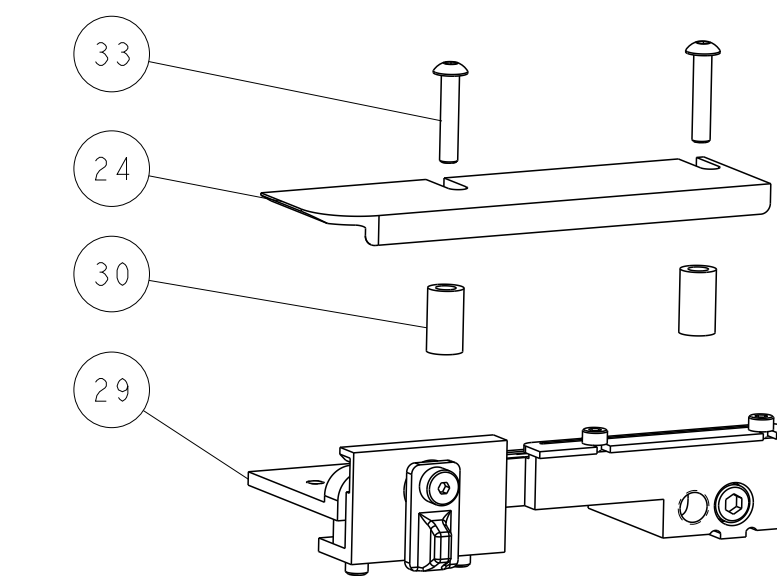
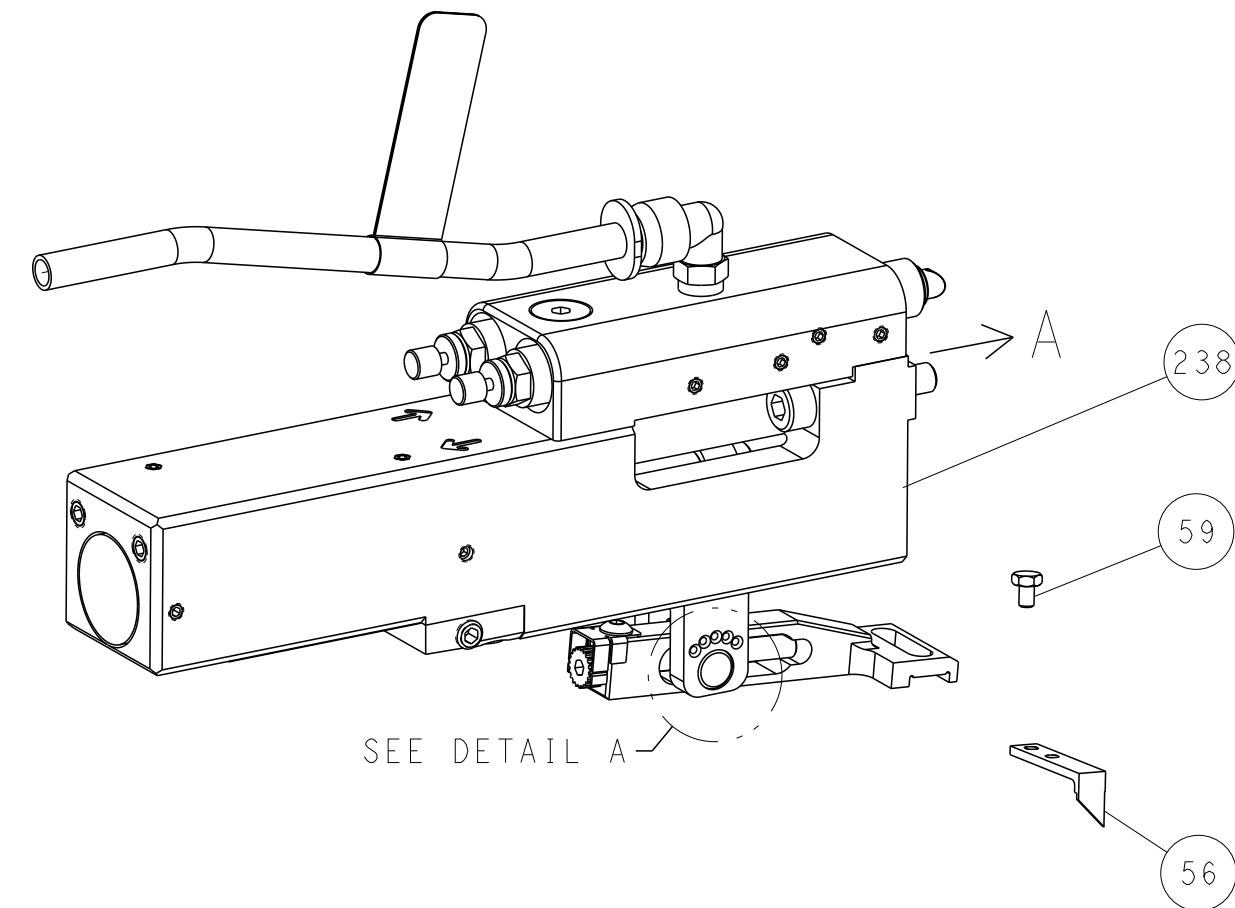
ATLANTIC VERSION  
Shown on sheets 1 of 4 & 2 of 4  
(Pacific version shown on sheets 3 of 4 & 4 of 4)

|     |      |           |     |               |  |           |     |      |
|-----|------|-----------|-----|---------------|--|-----------|-----|------|
| 2   |      | 1         |     |               |  |           |     |      |
| LOC | DIST | REVISIONS |     |               |  |           |     |      |
| A   | 66   | P         | LTR | DESCRIPTION   |  | DATE      | DWN | APVD |
|     |      | G         |     | ECR-17-014213 |  | 26SEP2017 | MZ  | KZ   |
|     |      | G1        |     | ECR-18-000788 |  | 18JAN2018 | JAH | TE   |
|     |      | H         |     | ECR-18-015855 |  | 07OCT2018 | TB  | TE   |
|     |      | J         |     | ECR-21-112944 |  | 07SEP2021 | JWC | GB   |

|   |     |     |     |     |     |     |             |                                     |     |
|---|-----|-----|-----|-----|-----|-----|-------------|-------------------------------------|-----|
| - | -   | -   | 1   | 1   | -   | -   | 1803515-3   | RAM ASSEMBLY, SF ATLANTIC           | 293 |
| - | -   | -   | 1   | 1   | -   | -   | 2-1803583-1 | APPLICATOR BASIC ASSEMBLY, SF       | 292 |
| - | 1   | 1   | 1   | 1   | 1   | 1   | 455888-5    | SPACER, CRIMPER                     | 263 |
| - | 1   | 1   | 1   | 1   | 1   | 1   | 461679-3    | TOOL, SIZING                        | 261 |
| - | 1   | -   | 1   | -   | 1   | -   | 2119641-1   | FEED CAM, AIR FEED                  | 248 |
| - | 1   | 1   | 1   | 1   | 1   | 1   | 2119082-5   | 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   | -   | -   | 1-1752354-8 | 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   | 5-547505-2  | SPRING, COMPRESSION                 | 77  |
| - | 1   | 1   | 1   | 1   | 1   | 1   | 854769-4    | HOLDER, INS                         | 74  |
| - | 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   | 21028-2     | PIN, SLOTTED SPRING .062 X .250     | 58  |
| - | 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   | 2168083-3   | SCR, SKT HD CAP, RoHS, M4 X 12.0    | 53  |
| - | 1   | 1   | 1   | 1   | 1   | 1   | 5018030-1   | NUT, HEX, REG, RoHS, M3             | 52  |
| - | 1   | 1   | 1   | 1   | 1   | 1   | 811242-5    | BUMPER, HOLD DOWN                   | 51  |
| - | 1   | 1   | 1   | 1   | 1   | 1   | 690753-2    | SPACER, TONKER                      | 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   | 455888-4    | 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   | 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   | 6-1633917-6 | ANVIL, COMBINATION                  | 8   |
| - | 1   | 1   | 1   | 1   | 1   | 1   | 6-240641-3  | SPACER                              | 7   |
| - | -   | -   | -   | -   | -   | -   | -           | -                                   | 6   |
| - | 1   | 1   | 1   | 1   | 1   | 1   | 2119780-9   | DEPRESSOR, SHEAR                    | 5   |
| - | 1   | 1   | 1   | 1   | 1   | 1   | 1-238011-0  | BLOCK, CRIMPER SPACER               | 4   |
| 1 | 2   | 2   | 1   | 1   | 1   | 1   | 1-1633965-6 | CRIMPER, INSULATION O PREMIUM       | 3   |
| - | 1   | 1   | 1   | 1   | 1   | 1   | 455888-3    | SPACER, CRIMPER                     | 2   |
| 1 | 2   | 2   | 1   | 1   | 1   | 1   | 456402-1    | CRIMPER, WIRE PREMIUM               | 1   |

|                                                                                                                          |         |                                        |              |
|--------------------------------------------------------------------------------------------------------------------------|---------|----------------------------------------|--------------|
| -77-72-71-52-51-2-1                                                                                                      | PART NO | DESCRIPTION                            | ITEM NO      |
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| DWN<br>CHK<br>G. BAILEY                                                                                                  |         | 9APRIL2012                             |              |
| APVD<br>T. ELBIN                                                                                                         |         | 9APRIL2012                             |              |
| DIMENSIONS:<br>mm                                                                                                        |         | TOLERANCES UNLESS OTHERWISE SPECIFIED: |              |
| 0 PLC ±                                                                                                                  |         | 1 PLC ±                                |              |
| 2 PLC ±                                                                                                                  |         | 3 PLC ±                                |              |
| 4 PLC ±                                                                                                                  |         | ANGLES ±                               |              |
| FINISH                                                                                                                   |         | FINISH                                 |              |
| MATERIAL                                                                                                                 |         | WEIGHT                                 |              |
| -                                                                                                                        |         | -                                      |              |
| Customer Accessible Production Drawing                                                                                   |         | SCALE 1:2                              | SHEET 1 OF 4 |
| REV J                                                                                                                    |         | REV J                                  |              |

## PNEUMATIC



30mm STROKE

47

49

40mm STROKE

MECHANICAL POST FEED

30mm STROKE

48

49

40mm STROKE

MECHANICAL PRE FEED

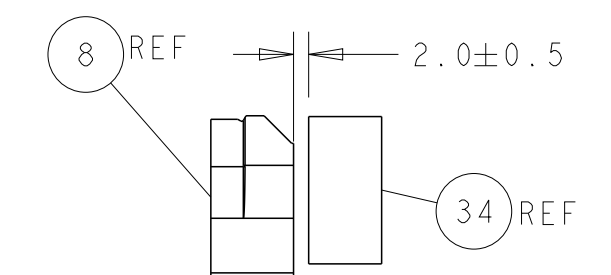
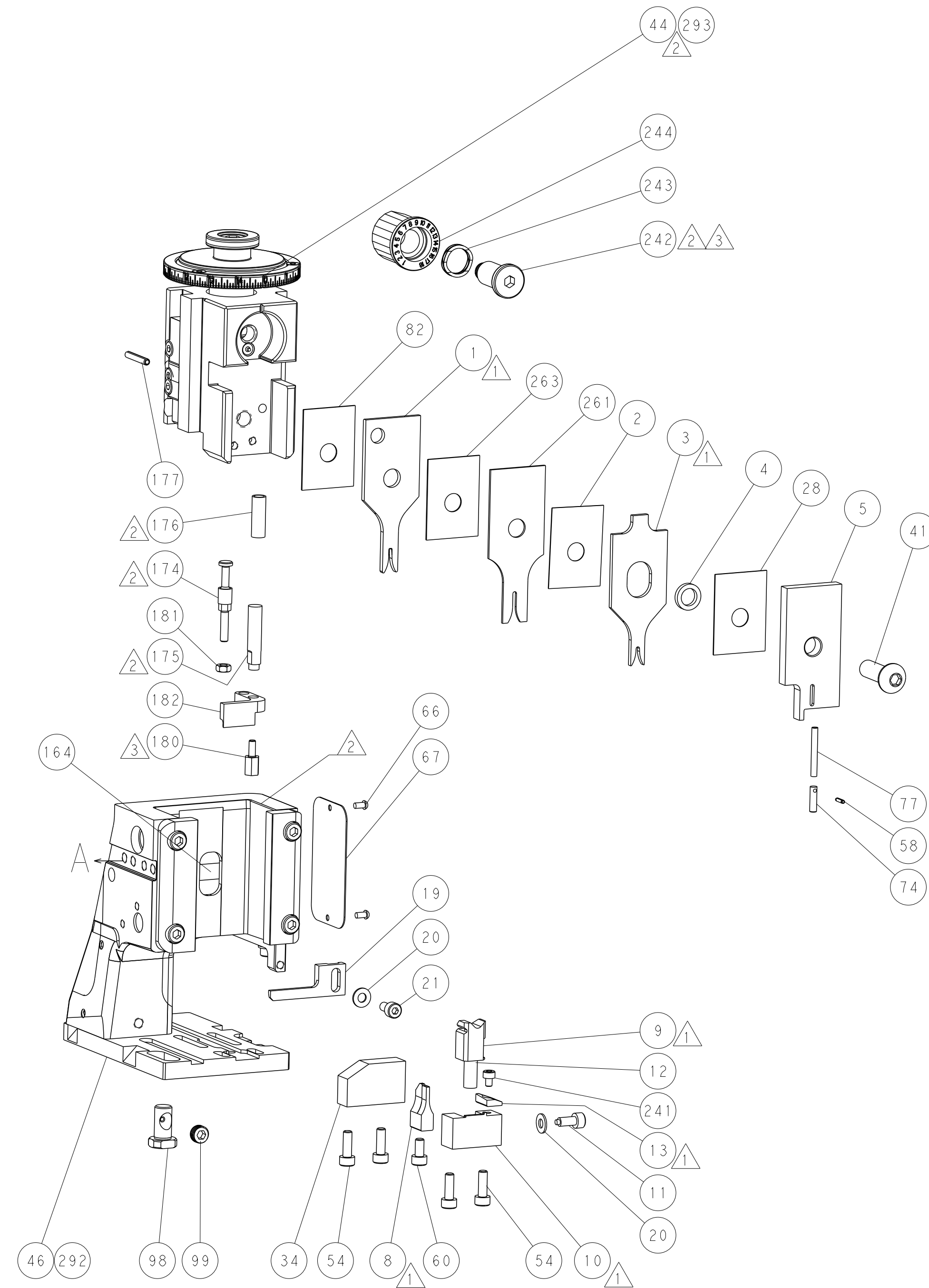
30mm STROKE

248

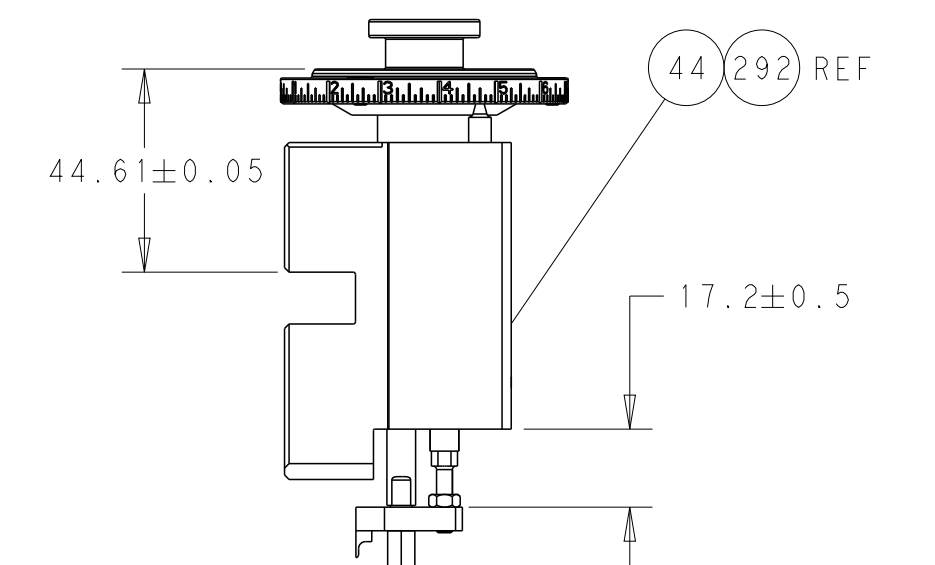
49

40mm STROKE

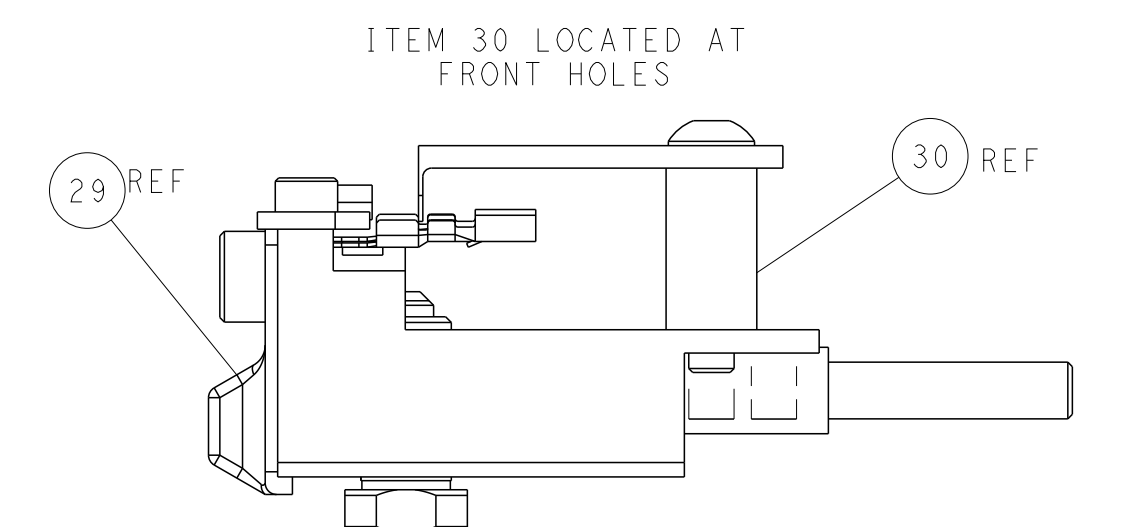
AIR FEED



TERMINAL SUPPORT LOCATION



## RAM SET-UP



FEED TRACK POSITION  
GUIDE BY INSULATION BARREL

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

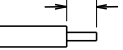
|                                                                                                                                             |  |                                                                 |  |  |  |                                    |  |                            |  |                                              |  |
|---------------------------------------------------------------------------------------------------------------------------------------------|--|-----------------------------------------------------------------|--|--|--|------------------------------------|--|----------------------------|--|----------------------------------------------|--|
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| DIMENSIONS:                                                                                                                                 |  | TOLERANCES UNLESS OTHERWISE SPECIFIED:                          |  |  |  | NAME                               |  | Ocean Side Feed Applicator |  |                                              |  |
| mm                                                                                                                                          |  |                                                                 |  |  |  | APVD<br>T. ELBIN                   |  |                            |  |                                              |  |
|                                                        |  | 0 PLC ±<br>1 PLC ±<br>2 PLC ±<br>3 PLC ±<br>4 PLC ±<br>ANGLES ± |  |  |  | PRODUCT SPEC<br>-                  |  |                            |  |                                              |  |
| APPLICATION SPEC                                                                                                                            |  |                                                                 |  |  |  | SIZE                               |  | CAGE CODE                  |  | DRAWING NO                                   |  |
| MATERIAL                                                                                                                                    |  | FINISH                                                          |  |  |  | WEIGHT                             |  | A   00779                  |  | C=251639                                     |  |
| -                                                                                                                                           |  | -                                                               |  |  |  | -                                  |  | -                          |  | -                                            |  |
| Customer Accessible Production Drawing                                                                                                      |  |                                                                 |  |  |  | SCALE                              |  | 1:2                        |  | SHEET 2 OF 4 REV 1                           |  |

|                              |          |                                                       |            |
|------------------------------|----------|-------------------------------------------------------|------------|
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| PART NUMBER                  | REVISION | DESCRIPTION                                           | FEED TYPE  |
| 2-2151639-1                  | H        | FINE CRIMP HEIGHT ADJUST                              | MECHANICAL |
| 2-2151639-2                  | J        | FINE CRIMP HEIGHT ADJUST                              | PNEUMATIC  |
| 7-2151639-7                  | G        | CRIMP TOOLING KIT                                     | -          |

PACIFIC VERSION TERMINATOR  
INTERFACE ADAPTER



| APPLICATOR DATA                      |                |      |
|--------------------------------------|----------------|------|
| CRIMP                                | SIZE           | TYPE |
| WIRE                                 | 1.40 mm [.055] | F    |
| INSUL                                | 1.78 mm [.070] | O    |
| STAB                                 | 1.91 mm [.075] | O    |
| APPLICATOR INSTRUCTIONS<br>408-35042 |                |      |

|                                                                                                                                                                                       |             |                                                                                   |                                                           |
|---------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-------------|-----------------------------------------------------------------------------------|-----------------------------------------------------------|
| TERMINAL DATA: TE TERMINAL                                                                                                                                                            |             | TE CRIMP SPECIFICATION                                                            |                                                           |
| TERMINAL NAME: CONTACT ASSEMBLY, LOCKING CLIP                                                                                                                                         |             |                                                                                   |                                                           |
| WIRE STRIP LENGTH<br>.111-.126 IN [2.82-3.20 mm]                                                                                                                                      |             |  | INSULATION DIAMETER RANGE<br>Ø.038-.062 IN [0.97-1.57 mm] |
| TERMINAL APPLICATION SPECIFICATION                                                                                                                                                    | 114-25006   |  | -                                                         |
|                                                                                                                                                                                       | -           | -                                                                                 | -                                                         |
| TERMINALS APPLIED   |             |                                                                                   |                                                           |
| TE TERMINAL                                                                                                                                                                           | TE TERMINAL | TE TERMINAL                                                                       | TE TERMINAL                                               |
| 87124-1                                                                                                                                                                               | 87124-2     | 87124-3                                                                           | 5-87124-2                                                 |
| 2267356-1                                                                                                                                                                             |             |                                                                                   |                                                           |

|                                                                                                                                                                         |                                                                                     |                                                                                     |                                                           |
|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-------------------------------------------------------------------------------------|-------------------------------------------------------------------------------------|-----------------------------------------------------------|
| TERMINAL DATA: TE TERMINAL                                                                                                                                              |                                                                                     | TE CRIMP SPECIFICATION                                                              |                                                           |
| TERMINAL NAME: CONTACT ASSEMBLY, LOCKING CLIP                                                                                                                           |                                                                                     |                                                                                     |                                                           |
| WIRE STRIP LENGTH<br>.111-.126 IN [2.82-3.20 mm]                                                                                                                        |                                                                                     |  | INSULATION DIAMETER RANGE<br>Ø.038-.062 IN [0.97-1.57 mm] |
| 114-25006                                                                                                                                                               |                                                                                     |  | -                                                         |
| TERMINAL APPLICATION SPECIFICATION                                                                                                                                      |  | -                                                                                   | -                                                         |
| TERMINALS APPLIED                                                                                                                                                       |                                                                                     |                                                                                     |                                                           |
|   |                                                                                     |                                                                                     |                                                           |
| TE TERMINAL                                                                                                                                                             | TE TERMINAL                                                                         | TE TERMINAL                                                                         | TE TERMINAL                                               |
| 867052-1                                                                                                                                                                | 867052-2                                                                            | 5-867052-1                                                                          |                                                           |

| WIRE SIZE | CRIMP HEIGHT INCH [mm]      | CRIMP HEIGHT REFERENCE SETTING | STABILIZER CRIMP HEIGHT mm [INCH] | TE HOUSING    |
|-----------|-----------------------------|--------------------------------|-----------------------------------|---------------|
| 22 AWG    | 0.86+/-0.05 [0.034+/-0.002] | 7.1                            | 2.44 +0.0/-0.2 [.096 +0.0/-0.008] | 926010/868781 |
| 24 AWG    | 0.76+/-0.05 [0.030+/-0.002] | 8.1                            | 2.44 +0.0/-0.2 [.096 +0.0/-0.008] | 926010/868781 |
| 26 AWG    | 0.76+/-0.05 [0.030+/-0.002] | 8.1                            | 2.44 +0.0/-0.2 [.096 +0.0/-0.008] | 926010/868781 |

| WIRE SIZE | CRIMP HEIGHT mm [INCH]     | CRIMP HEIGHT REFERENCE SETTING | STABILIZER CRIMP HEIGHT mm [INCH] | TE HOUSING    |
|-----------|----------------------------|--------------------------------|-----------------------------------|---------------|
| 20 AWG    | 1.02+/-0.05 [.040+/-0.002] | 5.6                            | 2.44 +0.0/-0.2 [.096 +0.0/-0.008] | 926010/868781 |



- 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.
- TERMINAL LUBRICANT IS RECOMMENDED.
- 6. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- APPLICATOR WAS QUALIFIED TO STABILIZER CRIMP HEIGHT LISTED FOR TERMINAL AND HOUSING COMBINATION ONLY. THIS HEIGHT VARIES FROM 114 SPEIFICATION.

\*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 | OWN |
|     |  |      |  | -         | -   | SEE SHEET 1 | -    | -   |
|     |  |      |  |           |     |             |      |     |
|     |  |      |  |           |     |             |      |     |

|     |     |     |             |                                     |         |
|-----|-----|-----|-------------|-------------------------------------|---------|
| -   | 1   | 1   | 455888-5    | SPACER, CRIMPER                     | 263     |
| -   | 1   | 1   | 461679-3    | TOOL, SIZING                        | 261     |
| -   | 1   | 1   | 2119082-5   | 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   | 5-547505-2  | SPRING, COMPRESSION                 | 77      |
| -   | 1   | 1   | 854769-4    | HOLDER, INS                         | 74      |
| -   | 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   | 21028-2     | PIN, SLOTTED SPRING .062 X .250     | 58      |
| -   | 1   | 1   | 1338685-1   | PAWL, FEED                          | 56      |
| -   | 2   | 2   | 2168083-3   | SCR, SKT HD CAP, RoHS, M4 X 12.0    | 53      |
| -   | 1   | 1   | 5018030-1   | NUT, HEX, REG, RoHS, M3             | 52      |
| -   | 1   | 1   | 811242-5    | BUMPER, HOLD DOWN                   | 51      |
| -   | 1   | 1   | 690753-2    | SPACER, TONKER                      | 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   | 455888-4    | 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   | 1803095-1   | FLOATING SHEAR, FRONT               | 9       |
| 1   | 1   | 1   | 6-1633917-6 | ANVIL, COMBINATION                  | 8       |
| -   | 1   | 1   | 6-240641-3  | SPACER                              | 7       |
| -   | -   | -   | -           | -                                   | 6       |
| -   | 1   | 1   | 2119780-9   | DEPRESSOR, SHEAR                    | 5       |
| -   | 1   | 1   | 1-238011-0  | BLOCK, CRIMPER SPACER               | 4       |
| 1   | 1   | 1   | 1-1633965-6 | CRIMPER, INSULATION O PREMIUM       | 3       |
| -   | 1   | 1   | 455888-3    | SPACER, CRIMPER                     | 2       |
| 1   | 1   | 1   | 456402-1    | CRIMPER, WIRE PREMIUM               | 1       |
| -77 | -22 | -21 | PART NO     | DESCRIPTION                         | ITEM NO |

|                                                                                                                            |  |                                                                           |                                        |                                              |  |
|----------------------------------------------------------------------------------------------------------------------------|--|---------------------------------------------------------------------------|----------------------------------------|----------------------------------------------|--|
| THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. THE USER SHALL BE RESPONSIBLE FOR THE LATEST EDITION. |  | OWN<br>A. STAKEM<br>CHK<br>G. BAILEY<br>APVD<br>T. ELBIN                  | 9APRIL2012<br>9APRIL2012<br>9APRIL2012 | TE Connectivity<br>Harrisburg, PA 17105-3608 |  |
| DIMENSIONS:<br>mm                                                                                                          |  | TOLERANCES UNLESS OTHERWISE SPECIFIED:                                    |                                        | NAME<br>Ocean Side Feed<br>Applicator        |  |
|                                                                                                                            |  | 0 PLC ±<br>1 PLC ±<br>2 PLC ±<br>3 PLC ±<br>4 PLC ±<br>ANGLES ±<br>FINISH |                                        | PRODUCT SPEC<br>APPLICATION SPEC             |  |
| MATERIAL                                                                                                                   |  | WEIGHT                                                                    |                                        | SIZE<br>A1                                   |  |
| -                                                                                                                          |  | -                                                                         |                                        | CAGE CODE<br>00779                           |  |
| Customer Accessible Production Drawing                                                                                     |  | SCALE<br>1:2                                                              |                                        | DRAWING NO<br>C=2151639                      |  |
|                                                                                                                            |  |                                                                           |                                        | RESTRICTED TO<br>-                           |  |
|                                                                                                                            |  |                                                                           |                                        | SHEET<br>3                                   |  |
|                                                                                                                            |  |                                                                           |                                        | OF<br>4                                      |  |
|                                                                                                                            |  |                                                                           |                                        | REV<br>J                                     |  |

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

DETAIL A

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

|                                                                                                                                |  |                                                                 |  |                            |  |                                                                                                                                    |  |
|--------------------------------------------------------------------------------------------------------------------------------|--|-----------------------------------------------------------------|--|----------------------------|--|------------------------------------------------------------------------------------------------------------------------------------|--|
| (THIS DRAWING IS A COMPUTER GENERATED FILE FROM THE AUTOCAD TO PLOT COMMAND AND SHOULD BE CONTACTED FOR THE LATEST REVISIONS.) |  |                                                                 |  | DWN: K. STAKM 19APRIL2012  |  |  TE Connectivity<br>Harrisburg, PA 17105-3608 |  |
|                                                                                                                                |  |                                                                 |  | CHK: G. BAILEY 19APRIL2012 |  |                                                                                                                                    |  |
|                                                                                                                                |  |                                                                 |  | APPV: T. ELBIN 19APRIL2012 |  | NAME                                                                                                                               |  |
| DIMENSIONS:                                                                                                                    |  | TOLERANCES UNLESS OTHERWISE SPECIFIED:                          |  | PRODUCT SPEC               |  | Ocean Side Feed Applicator                                                                                                         |  |
| mm                                                                                                                             |  |                                                                 |  | APPLICATION SPEC           |  |                                                                                                                                    |  |
|                                           |  | Ø PLC ±<br>1 PLC ±<br>2 PLC ±<br>3 PLC ±<br>Ø PLC ±<br>ANGLES ± |  |                            |  | SIZE   CODE   DRAWING NO                                                                                                           |  |
| MATERIAL                                                                                                                       |  | FINISH                                                          |  | WEIGHT                     |  | RESTRICTED TO                                                                                                                      |  |
|                                                                                                                                |  |                                                                 |  | -                          |  | A   00779   C=2151639                                                                                                              |  |
| Customer Accessible Production Drawing                                                                                         |  |                                                                 |  |                            |  | SCALE 1:2 SHEET 4 OF 4 REV J                                                                                                       |  |

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

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