

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151022-1	L	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2151022-2	M	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151022-1	L	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2151022-2	M	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2151022-7	D	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.40 mm [.055]	F
INSUL	1.78 mm [.070]	F

APPLICATOR INSTRUCTIONS
408-35042

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION			
TERMINAL NAME: CONTACT, RECEPTACLE, CRIMP SNAP-IN, MICRO MATE-N-LOCK			
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE		
2.90-3.50 mm [.114-.138 IN]	Ø.89-1.52 mm [.035-.060 IN]		
TERMINAL APPLICATION SPECIFICATION	114-13000	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
794606-1	794606-2	794606-3	2825493-1
1-794606-1	1-794606-2	1-794606-3	

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
20 AWG	0.89+/-0.05 [.035+/- .002]	7.8
0.5mm ²	0.83+/-0.03 [.033+/- .001]	8.4
22 AWG	0.79+/-0.05 [.031+/- .002]	8.9
0.35mm ²	0.79+/-0.03 [.031+/- .001]	9.0
24 AWG	0.69+/-0.05 [.027+/- .002]	9.9

- 1. RECOMMENDED SPARE PARTS
- 2. REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION, AND STORAGE OF THE APPLICATOR
- 3. APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEMS 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. TERMINAL LUBRICANT IS RECOMMENDED.
- 6. 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)

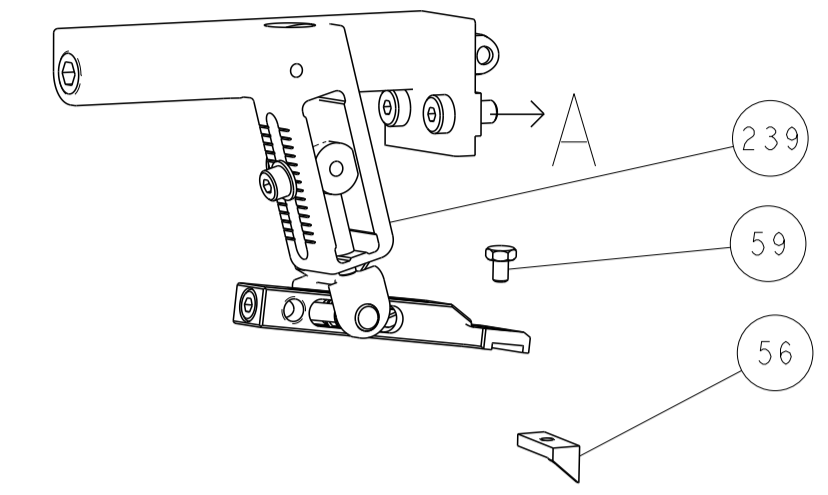
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		L		ECR-19-005880	11APR2019	FL	CT
		M		ECR-19-009012	08JUN2019	TB	TE

-	1	1	1	1	2280441-1	INSERT, SHEAR	282
-	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
3	-	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	2	2	2	2	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
-	-	1	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	1	-	1	-	2844940-1	AIR FEED MODULE	238
-	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	1	1	1	1	2168083-6	SCR, SKT HD CAP, RoHS, M5 X 65	124
-	2	2	2	2	1-18028-2	WASHER, FLAT, REG M4	119
5	-	1	1	1	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113
-	1	1	1	1	2844908-1	SCREW, LOCKING	99
-	1	1	1	1	2844907-1	POST, LOCKING	98
-	1	1	1	1	1-22281-8	SPRING, COMPRESSION	96
-	1	1	1	1	980371-4	SCR, SKT HD SHLDR 5.0 DIA X 6.0	83
-	1	1	1	1	455888-6	SPACER, CRIMPER	82
-	1	1	1	1	240641-5	SPACER	81
-	1	1	1	1	1803607-3	DOCUMENTATION PACKAGE	71
-	4	4	4	4	18026-1	WASHER, SPRG LOCK, REG M3	68
-	1	1	1	1	2119740-1	TAG, IDENTIFICATION	67
-	2	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	4	4	4	4	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	65
-	2	2	2	2	2-18032-5	SCR, SET, FLT PNT, M5 X 20.0	61
-	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	1338683-1	FEED PAWL	56
-	4	4	4	4	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	54
-	2	2	2	2	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	53
-	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	1803515-1	RAM ASSEMBLY, SF ATLANTIC	44
-	1	1	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
-	1	1	1	1	2305692-1	PLATE, REAR STRIP GUIDE	29
-	1	1	1	1	1-455888-0	SPACER, CRIMPER	28
-	2	2	2	2	1-22284-0	SPRING, COMPRESSION	27
-	1	1	1	1	356835-1	LEVER, DRAG RELEASE	26
-	1	1	1	1	240792-1	DRAG, TERMINAL	25
-	1	1	1	1	189124-7	GUIDE, FRONT STRIP	24
-	1	1	1	1	690438-1	FRONT STRIP GUIDE	23
-	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	2119533-1	STRIPPER, SIDE FEED	19
-	1	1	1	1	690518-1	HOLD DOWN, TERMINAL	18
-	1	1	1	1	2-690463-3	FLOATING SHEAR, REAR	17
-	2	2	2	2	1-2168083-1	SCR, SKT HD CAP, RoHS, M3 X 6	16
-	1	1	1	1	1-690691-1	PLATE, REAR SHEAR	15
-	1	1	1	1	2119862-1	SHEAR HOLDER, REAR	14
-	1	1	1	1	2119806-1	INSERT, SHEAR	13
-	2	2	2	2	3-22280-3	SPRING, COMPRESSION	12
-	2	2	2	2	1-356885-4	STOP, SHEAR	11
1	-	1	1	1	2119805-1	SHEAR HOLDER, FRONT	10
1	-	1	1	1	1803095-1	FLOATING SHEAR, FRONT	9
1	2	2	1	1	4-1333201-0	ANVIL, COMBINATION	8
-	1	1	1	1	3-240641-7	SPACER	7
-	1	1	1	1	690468-7	DEPRESSOR SHEAR, REAR	6
-	1	1	1	1	2119757-1	DEPRESSOR, SHEAR	5
-	1	1	1	1	2-238011-0	BLOCK, CRIMPER SPACER	4
1	2	2	1	1	1-2119582-2	CRIMPER, INSULATION F PREMIUM	3
-	1	1	1	1	455888-6	SPACER, CRIMPER	2
1	2	2	1	1	5-456402-4	CRIMPER, WIRE PREMIUM	1
-77	-72	-71	-2	-1	PART NO	DESCRIPTION	ITEM NO

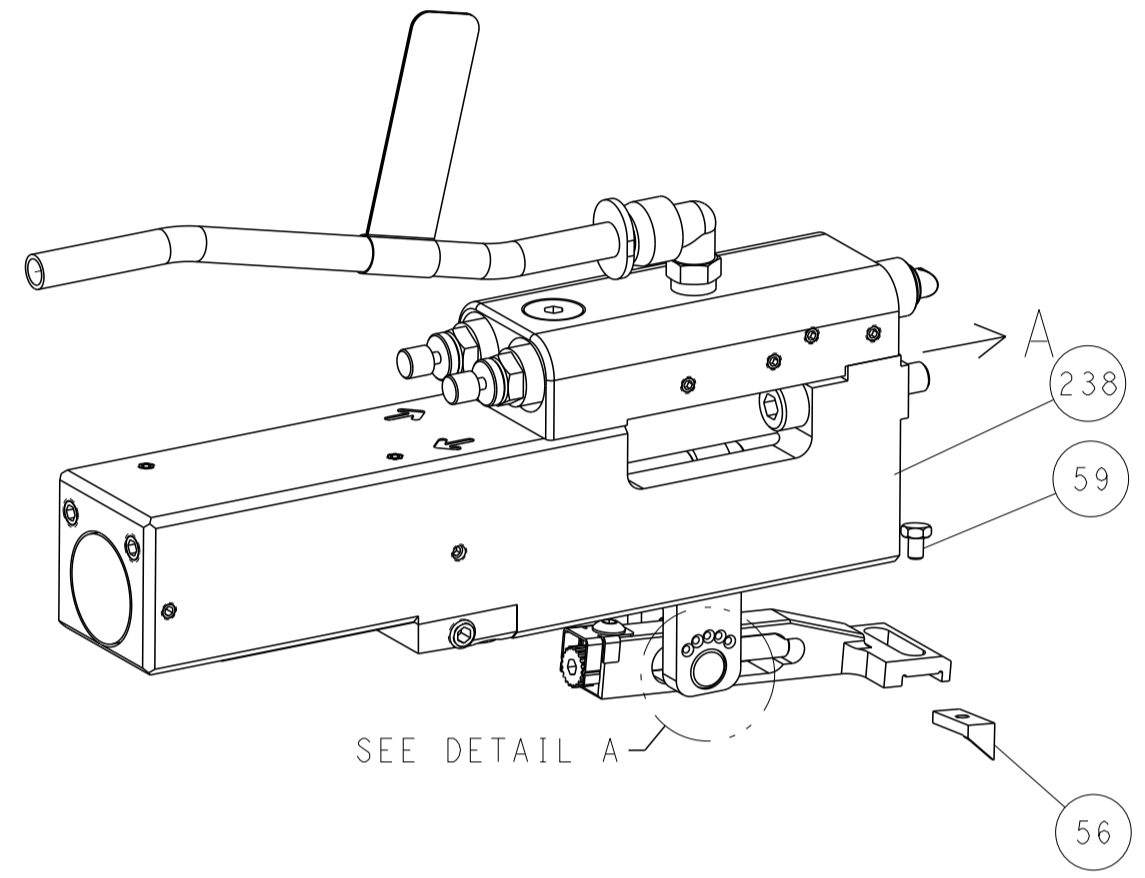
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MATERIAL:		WEIGHT:		SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2151022		RESTRICTED TO:	
Customer Accessible Production Drawing				SCALE: 1:2		SHEET 1 OF 4 REV M	

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

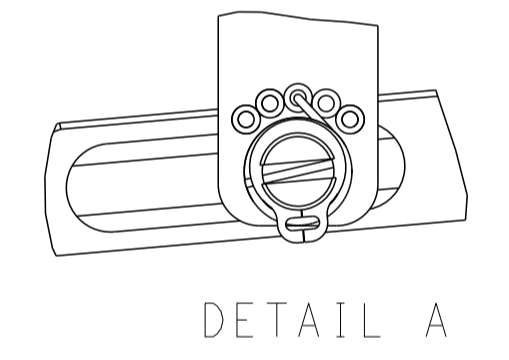
FEED TYPE MECHANICAL



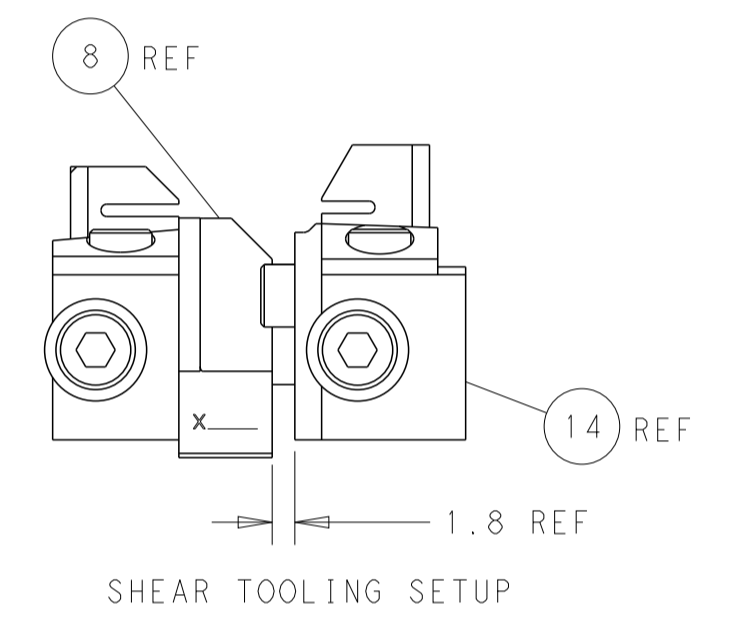
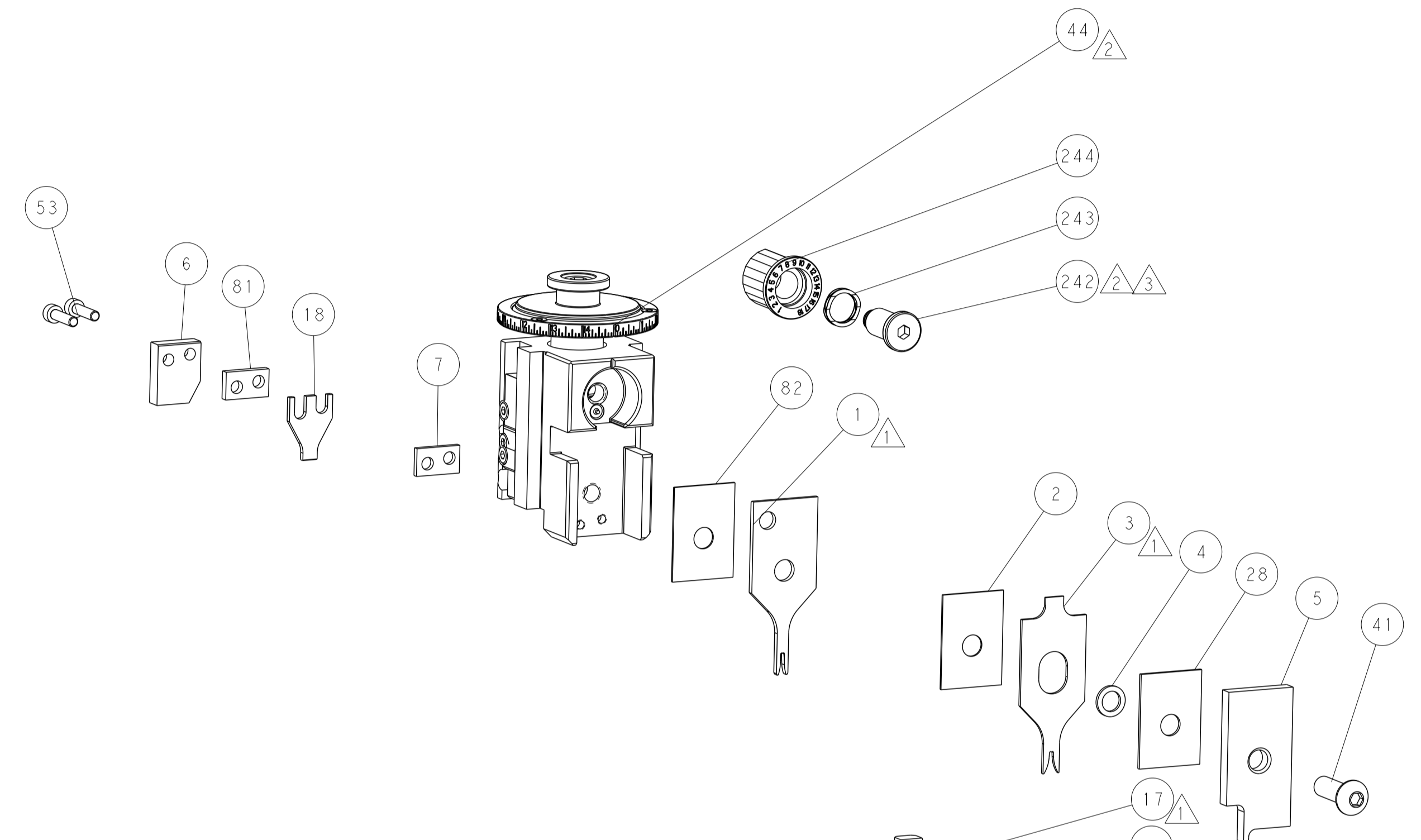
PNEUMATIC



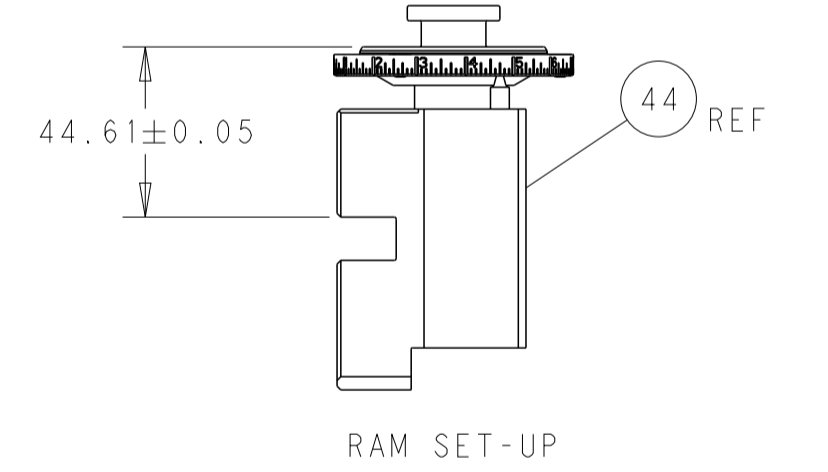
FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



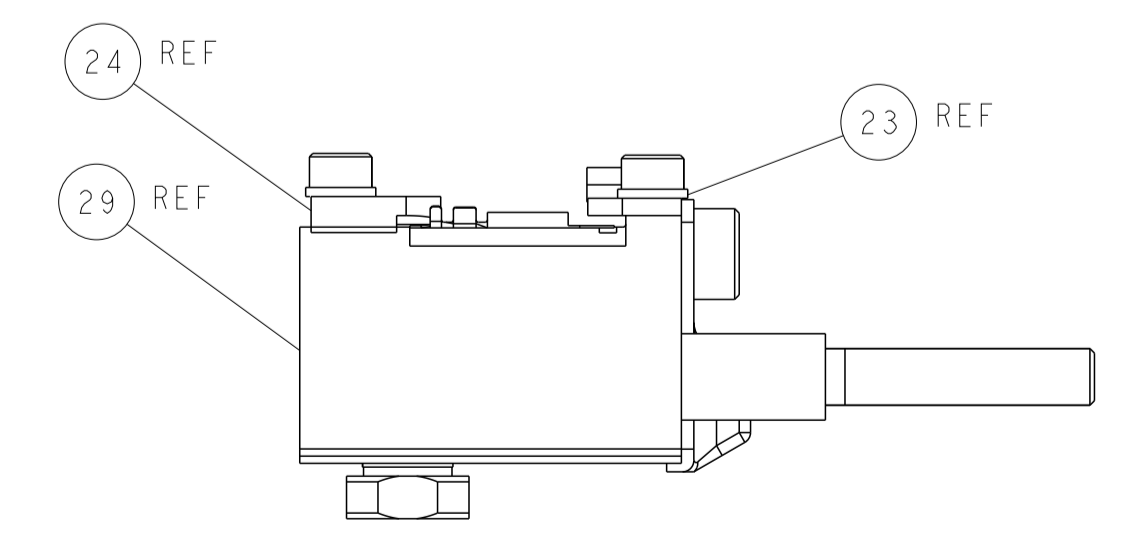
DETAIL A



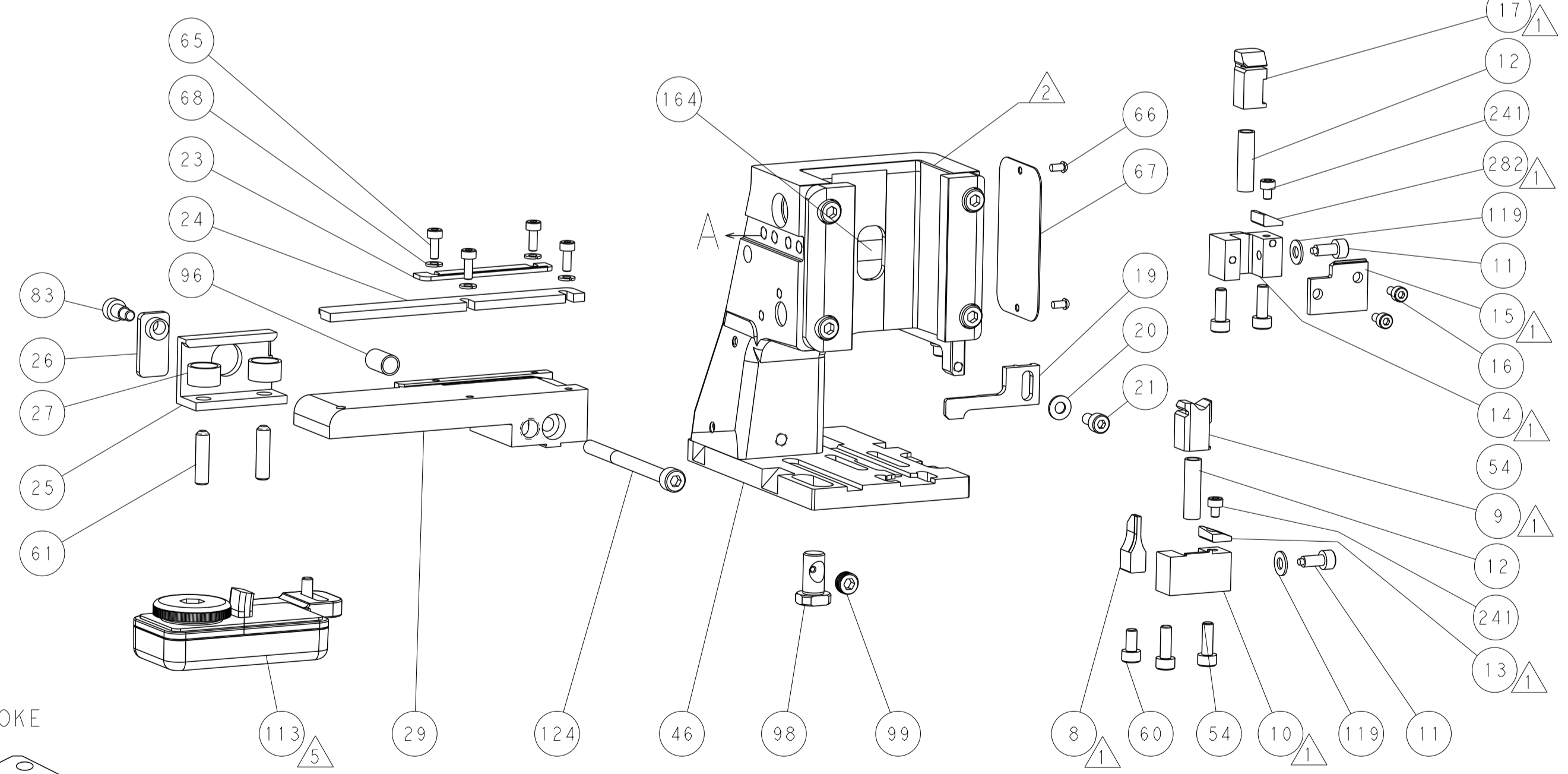
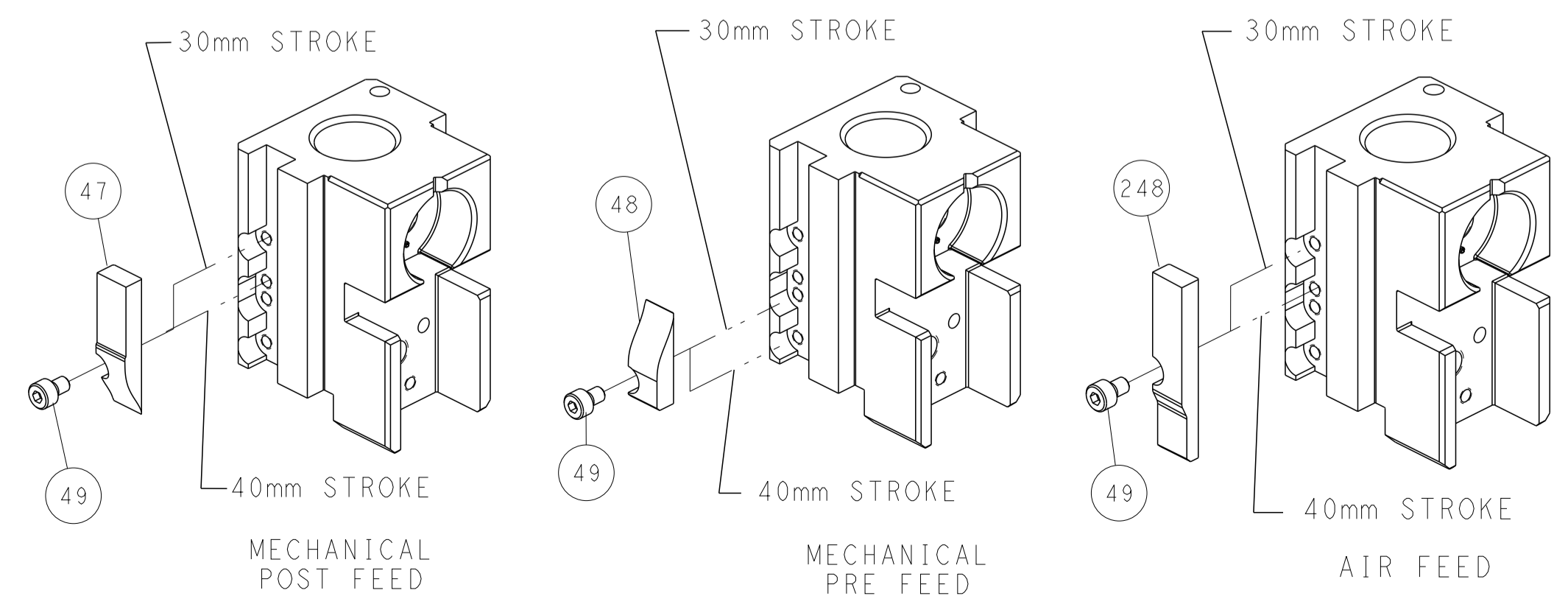
SHEAR TOOLING SETUP



RAM SET-UP



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:		DWG L. ZHANG 16NOV2011		TE Connectivity Harrisburg, PA 17105-3608	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	NAME Ocean Side Feed Applicator	
MATERIAL:		FINISH:		APVD S. XI 16NOV2011		RESTRICTED TO	
				PRODUCT SPEC		SIZE CAGE CODE DRAWING NO	
				APPLICATION SPEC		A1 00779 ©=2151022	
				WEIGHT		SCALE 1:2 SHEET 2 OF 4 REV M	
				Customer Accessible Production Drawing		SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION	

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2151022-1	L	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2151022-2	M	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151022-7	D	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.40 mm [.055]	F
INSUL	1.78 mm [.070]	F

APPLICATOR INSTRUCTIONS 408-35042

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: CONTACT, RECEPTACLE, CRIMP SNAP-IN, MICRO MATE-N-LOCK			
WIRE STRIP LENGTH 2.90-3.50 mm [.114-.138 IN]		INSULATION DIAMETER RANGE Ø.89-1.52 mm [.035-.060 IN]	
TERMINAL APPLICATION SPECIFICATION	114-13000	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
794606-1	794606-2	794606-3	2825493-1
1-794606-1	1-794606-2	1-794606-3	

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
20 AWG	0.89+/-0.05 [.035+/- .002]	7.8
0.5mm ²	0.83+/-0.03 [.033+/- .001]	8.4
22 AWG	0.79+/-0.05 [.031+/- .002]	8.9
0.35mm ²	0.79+/-0.03 [.031+/- .001]	9.0
24 AWG	0.69+/-0.05 [.027+/- .002]	9.9

- RECOMMENDED SPARE PARTS
- GREASE BEARING SURFACES LIGHTLY
- APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEMS 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.

***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	LTN	DESCRIPTION	DATE	OWN	APVD
-	-	-	-	SEE SHEET 1	-	-	-

-	1	1	2280441-1	INSERT, SHEAR	282
-	1	1	2119082-8	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	2	2	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	2168083-6	SCR, SKT HD CAP, RoHS, M5 X 65	124
-	2	2	1-18028-2	WASHER, FLAT, REG M4	119
-	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	1-22281-8	SPRING, COMPRESSION	96
-	1	1	980371-4	SCR, SKT HD SHLDR 5.0 DIA X 6.0	83
-	1	1	455888-6	SPACER, CRIMPER	82
-	1	1	240641-5	SPACER	81
-	1	1	1803607-3	DOCUMENTATION PACKAGE	71
-	4	4	18026-1	WASHER, SPRG LOCK, REG M3	68
-	1	1	2119740-1	TAG, IDENTIFICATION	67
-	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	4	4	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	65
-	2	2	2-18032-5	SCR, SET, FLT PNT, M5 X 20.0	61
-	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	1	1	1338683-1	FEED PAWL	56
-	2	2	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	53
-	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	2305692-1	PLATE, REAR STRIP GUIDE	29
-	1	1	1-455888-0	SPACER, CRIMPER	28
-	2	2	1-22284-0	SPRING, COMPRESSION	27
-	1	1	356835-1	LEVER, DRAG RELEASE	26
-	1	1	240792-1	DRAG, TERMINAL	25
-	1	1	189124-7	GUIDE, FRONT STRIP	24
-	1	1	690438-1	FRONT STRIP GUIDE	23
-	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	2119533-1	STRIPPER, SIDE FEED	19
-	1	1	690518-1	HOLD DOWN, TERMINAL	18
-	1	1	2-690463-3	FLOATING SHEAR, REAR	17
-	2	2	1-2168083-1	SCR, SKT HD CAP, RoHS, M3 X 6	16
-	1	1	1-690691-1	PLATE, REAR SHEAR	15
-	1	1	2119862-1	SHEAR HOLDER, REAR	14
-	1	1	2119806-1	INSERT, SHEAR	13
-	2	2	3-22280-3	SPRING, COMPRESSION	12
-	2	2	1-356885-4	STOP, SHEAR	11
-	1	1	2119805-1	SHEAR HOLDER, FRONT	10
-	1	1	1803095-1	FLOATING SHEAR, FRONT	9
-	1	1	4-1333201-0	ANVIL, COMBINATION	8
-	1	1	3-240641-7	SPACER	7
-	1	1	690468-7	DEPRESSOR SHEAR, REAR	6
-	1	1	2119757-1	DEPRESSOR, SHEAR	5
-	1	1	2-238011-0	BLOCK, CRIMPER SPACER	4
-	1	1	1-2119582-2	CRIMPER, INSULATION F PREMIUM	3
-	1	1	455888-6	SPACER, CRIMPER	2
-	1	1	5-456402-4	CRIMPER, WIRE PREMIUM	1

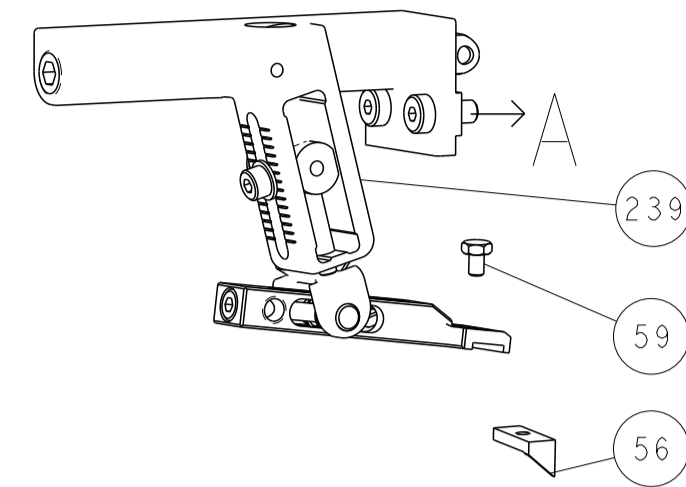
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mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES ±	FINISH ±

DATE	16NOV2011	CHK	L. ZHANG	DATE	16NOV2011	CHK	L. ZHANG
DATE	16NOV2011	CHK	L. ZHANG	DATE	16NOV2011	CHK	L. ZHANG
DATE	16NOV2011	CHK	L. ZHANG	DATE	16NOV2011	CHK	L. ZHANG

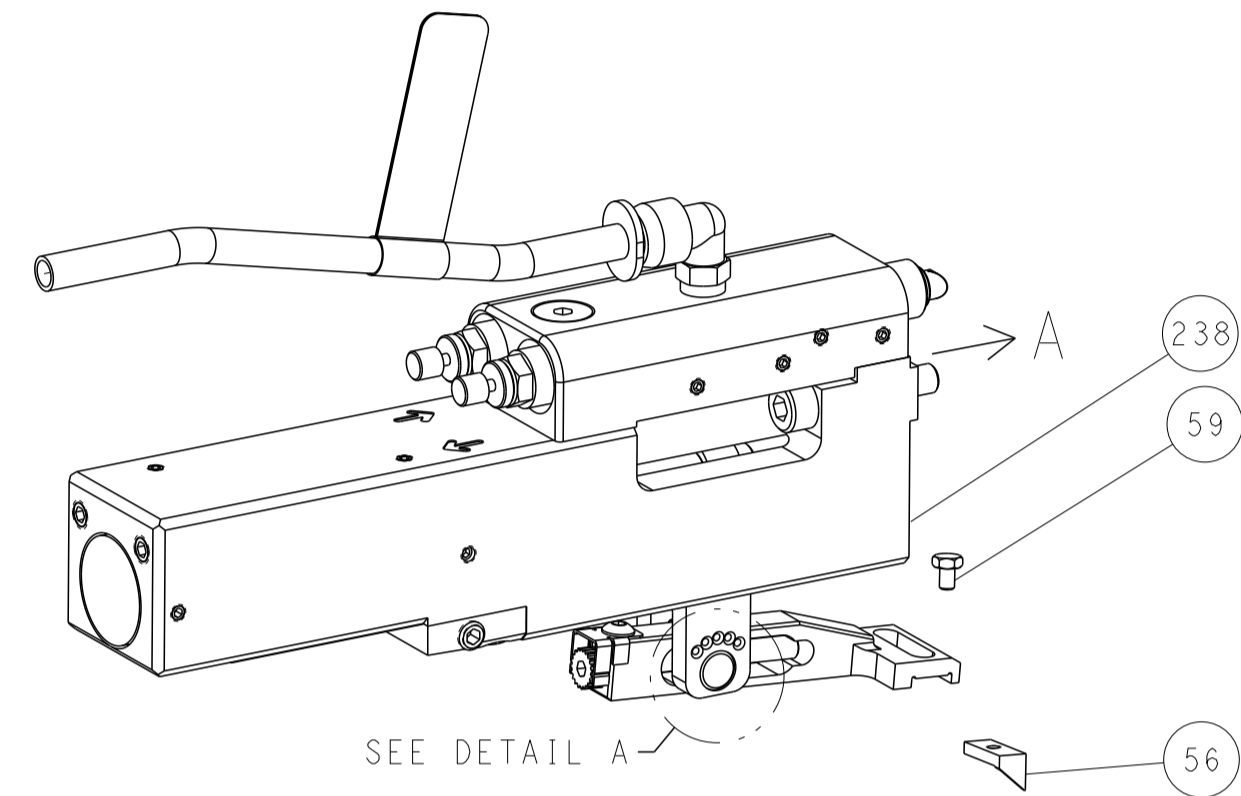
NAME	Ocean Side Feed Applicator		
SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
A1	00779	2151022	-
Customer Accessible Production Drawing		SCALE	1:2 SHEET 3 OF 4 REV M

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

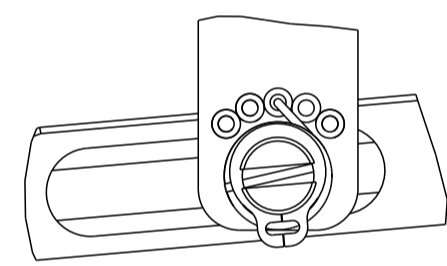
FEED TYPE MECHANICAL



PNEUMATIC

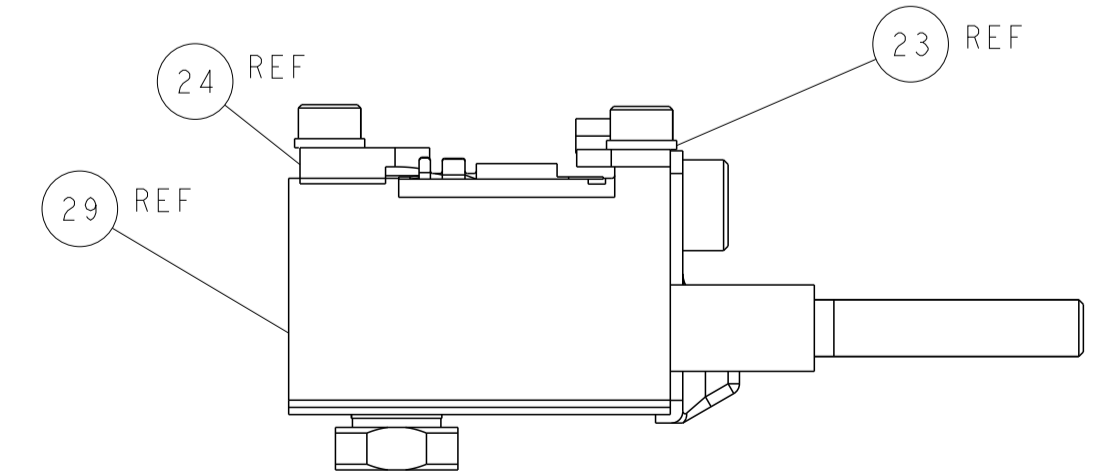
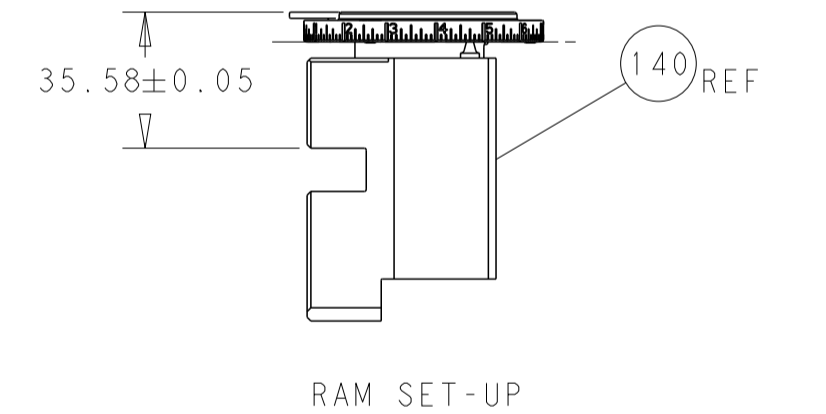
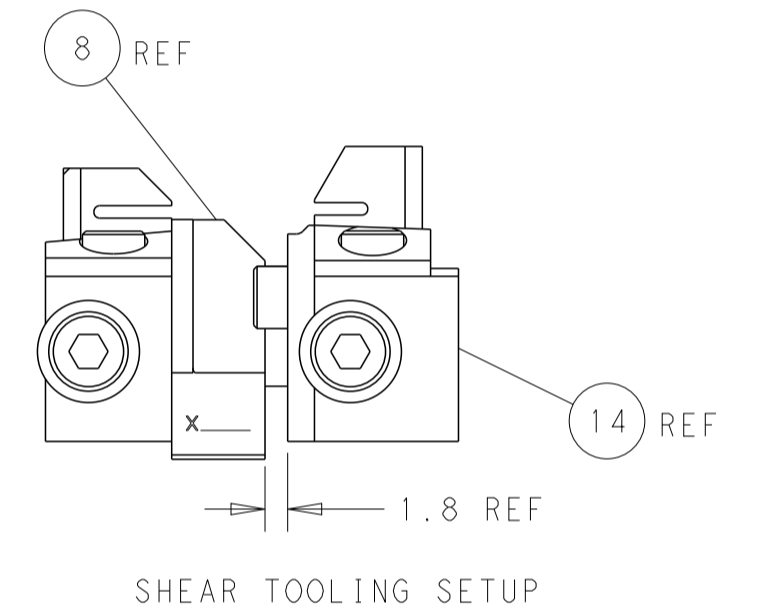
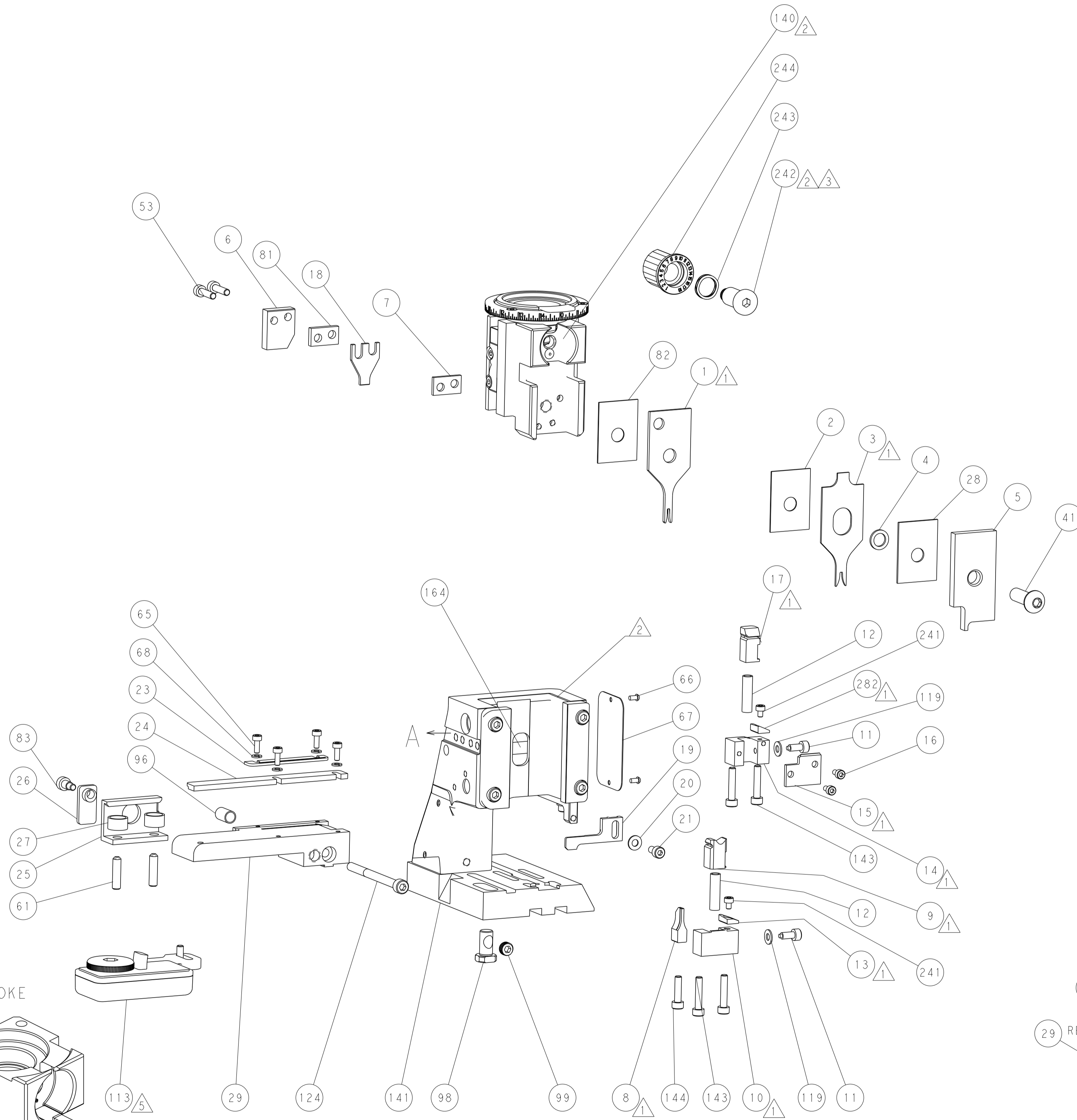
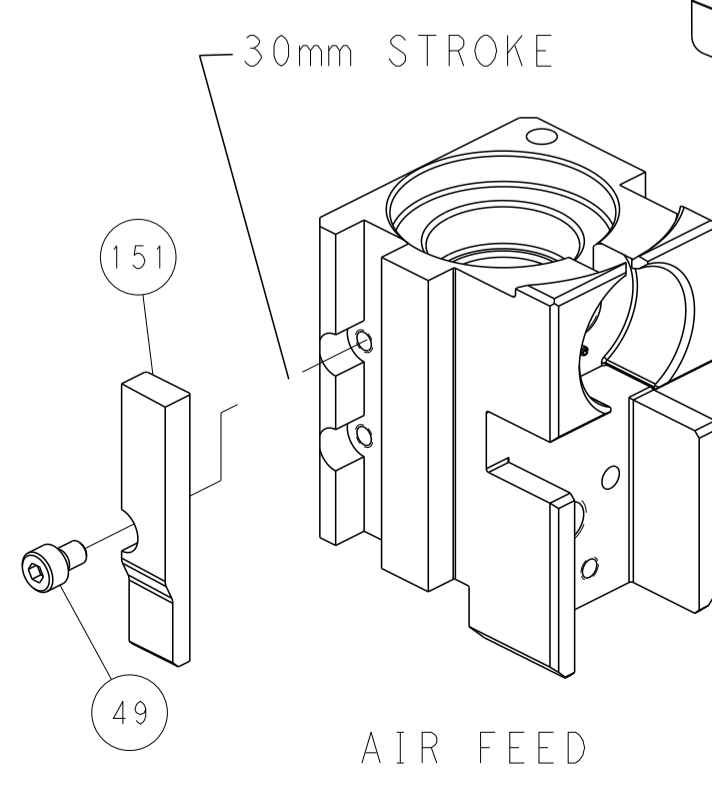
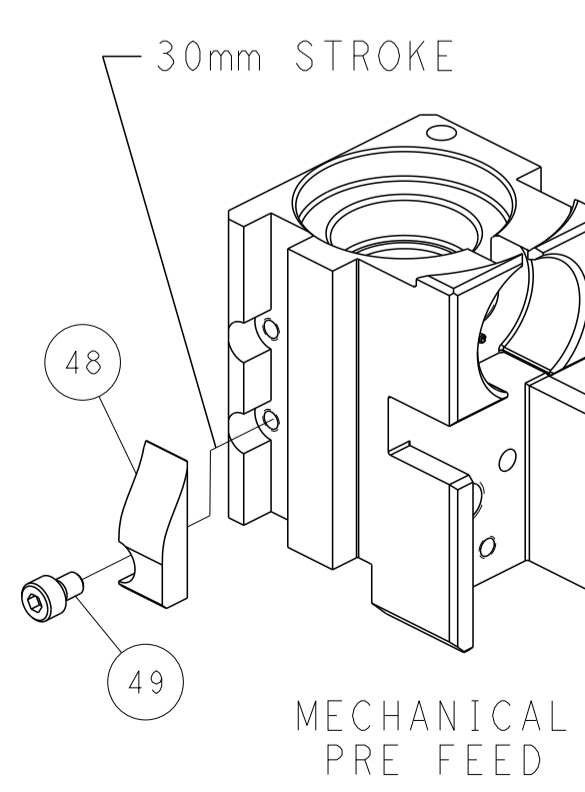
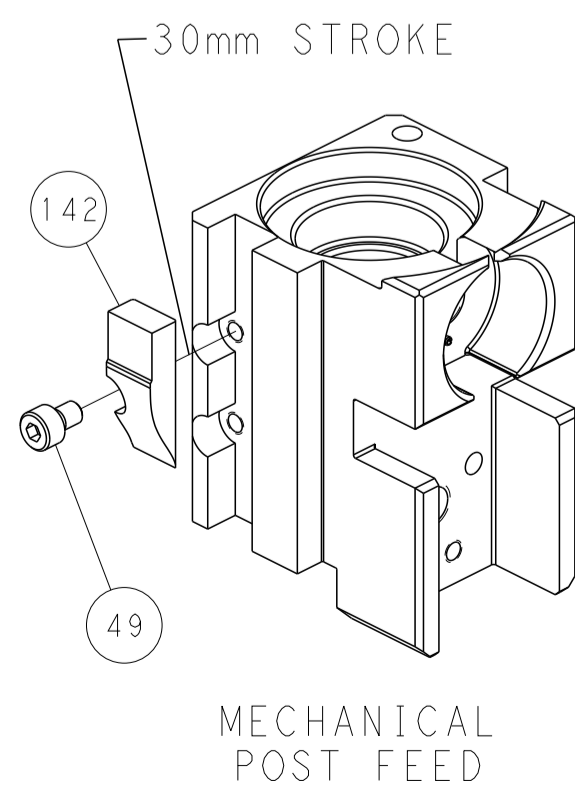


FEED SPRING SETTING POSITION
(SHOWN FROM REAR SIDE)



DETAIL A

CAM POSITIONS



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 L. ZHANG 16NOV2011		TE Connectivity	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	5 PLC ±	Harrisburg, PA 17105-3608
	ANGLES FINISH			CHK L. ZHANG 16NOV2011	NAME		
MATERIAL				APVD S. XI 16NOV2011	PRODUCT SPEC		
				APPLICATION SPEC		SIZE CAGE CODE DRAWING NO RESTRICTED TO	
				WEIGHT		A1 00779 C=2151022	
				Customer Accessible Production Drawing		SCALE 1:2 SHEET 4 OF 4 REV M	