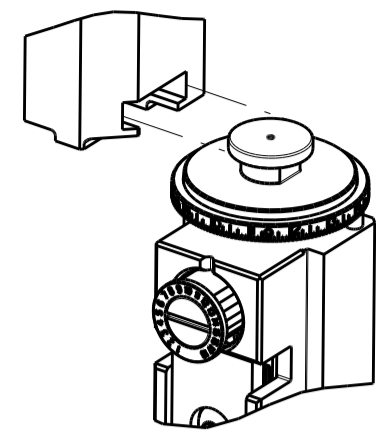


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151115-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2151115-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151115-1	B	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2151115-2	B	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2151115-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.57 mm [.062]	F
INSUL	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	
1.72-2.48 mm [.068-.098 IN]		Ø1.52-2.79 mm [.060-.110 IN]	
TERMINAL APPLICATION SPECIFICATION	114-1016		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
350566-1	350566-3	350566-4	350566-5
350566-6	350566-7	3-350566-1	

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
18 AWG OR 0.82mm2	1.07 +/- 0.05 [.042 +/- .002]	6.3
20 AWG OR 0.50mm2	1.07 +/- 0.05 [.042 +/- .002]	6.0
22 AWG OR 0.32mm2	1.07 +/- 0.05 [.042 +/- .002]	5.7

- 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.

**\*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)

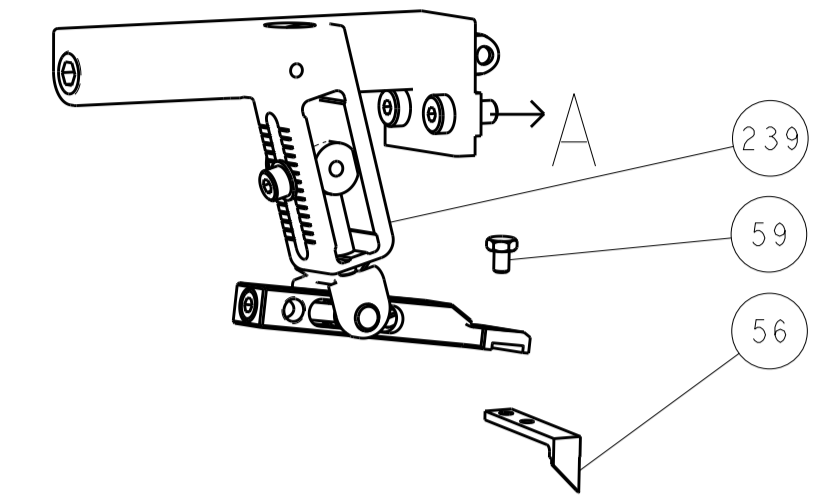
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		A2		ECR-15-016875	18NOV2015	YY	GB
		A3		ECR-17-002263	26FEB2017	RS	LZ
		B		ECR-18-007179	10MAY2018	MZ	JDG

-	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	2119082-9	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	-	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	2844908-1	SCREW, LOCKING	99
-	1	1	1	1	2844907-1	POST, LOCKING	98
-	1	1	1	1	455888-6	SPACER, CRIMPER	82
-	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	1338685-1	PAWL, FEED	56
-	4	4	4	4	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	54
-	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	3-1752356-9	SUPPORT, TERMINAL	34
-	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	2	2	2-2844962-6	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29
-	1	1	1	1	1-455888-0	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
-	2	2	2	2	1-18028-2	WASHER, FLAT, REG M4	20
-	1	1	1	1	2119533-1	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	1803095-1	FLOATING SHEAR, FRONT	9
1	2	2	1	1	1-1338691-0	ANVIL, COMBINATION .062	8
-	1	1	1	1	2119757-8	DEPRESSOR, SHEAR	5
-	1	1	1	1	2-238011-2	BLOCK, CRIMPER SPACER	4
1	2	2	1	1	2-2119582-1	CRIMPER, INSULATION F PREMIUM	3
1	2	2	1	1	1-456403-5	CRIMPER, WIRE PREMIUM	1
-77	-72	-71	-2	-1	PART NO	DESCRIPTION	ITEM NO

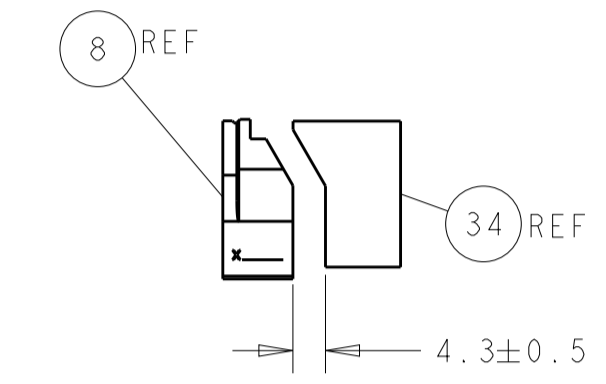
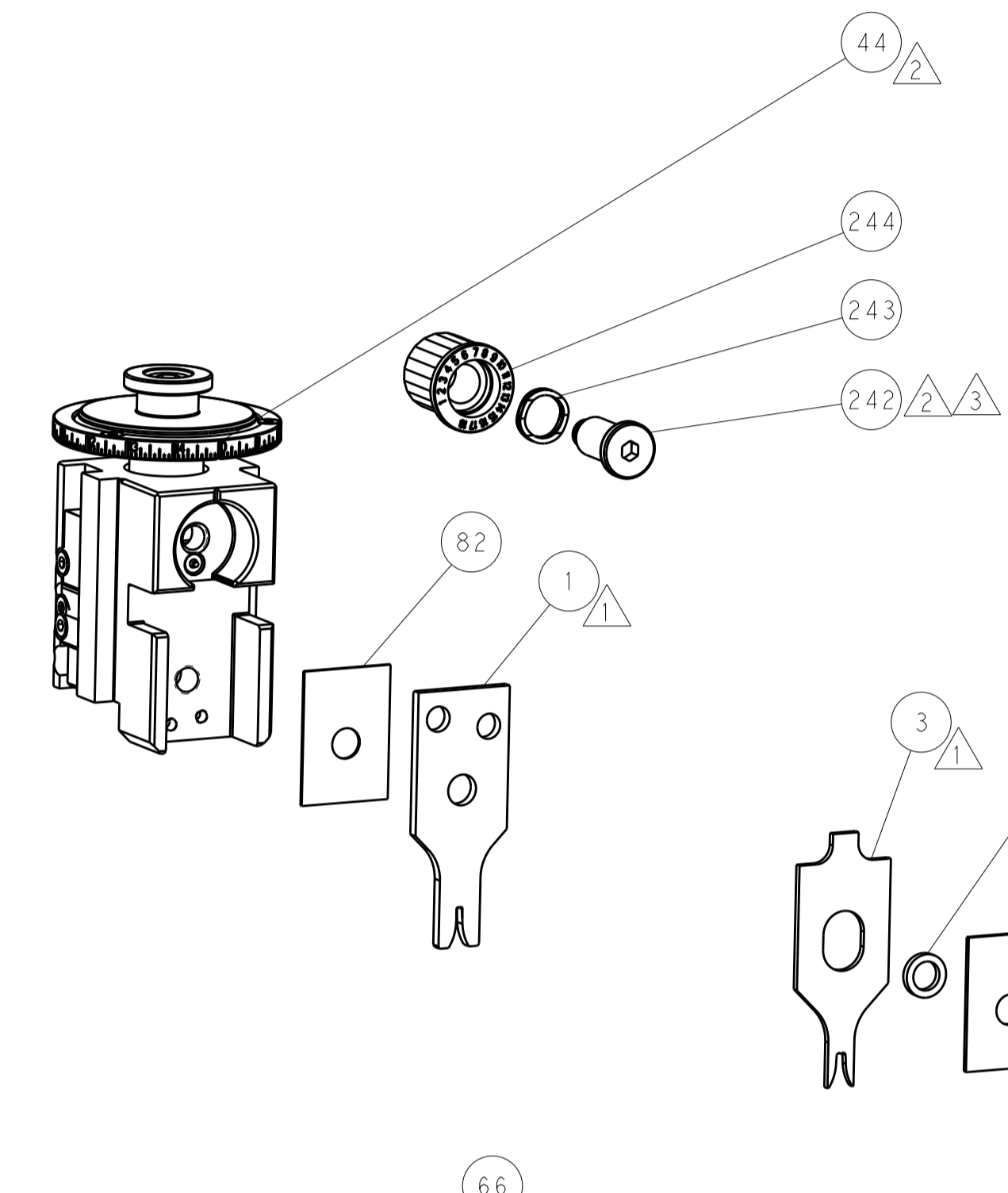
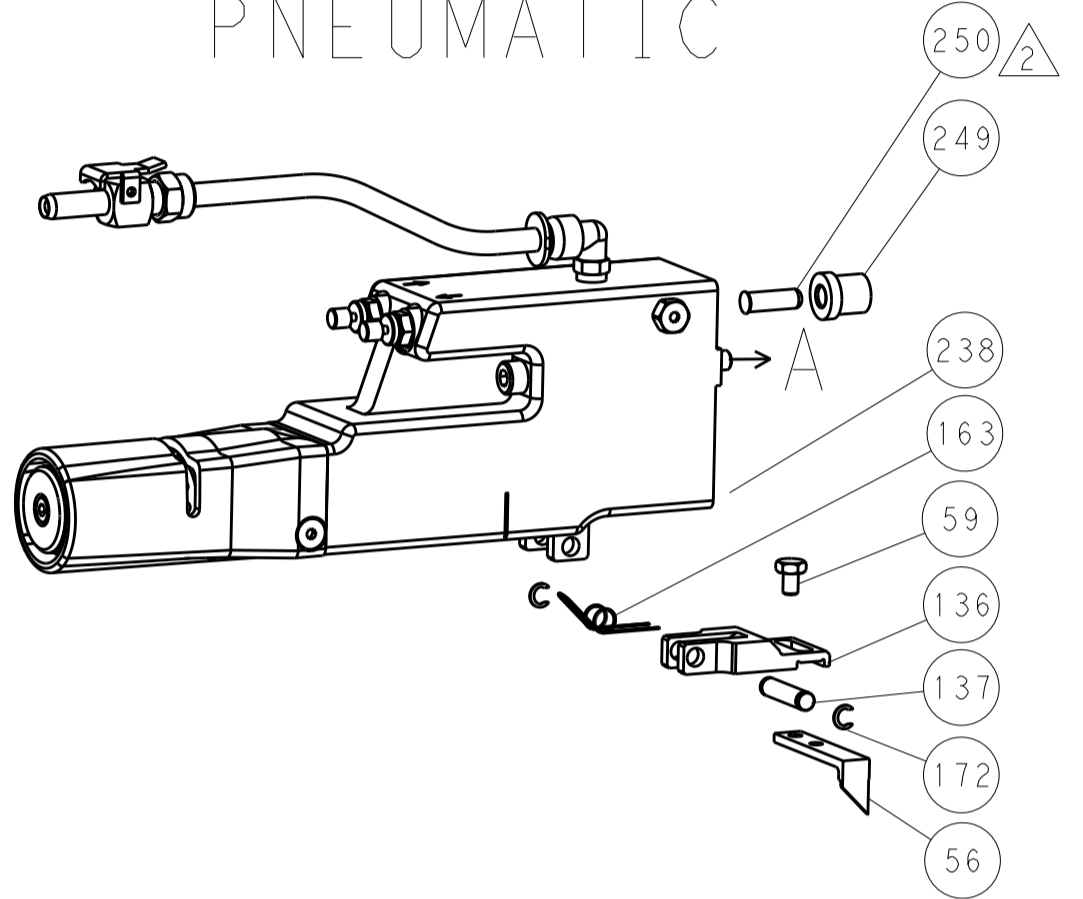
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		OWN	Y. YIN	12OCT2011	TE Connectivity Harrisburg, PA 17105-3608
mm		0 PLC ± 1 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		CHK	G. BAILEY	12OCT2011	
MATERIAL		FINISH		APVD	S. XI	12OCT2011	NAME
				PRODUCT SPEC		Ocean Side Feed Applicator	
				APPLICATION SPEC		SIZE	
				WEIGHT		A1 00779 ©=2151115	
				Customer Accessible Production Drawing		SCALE 1:2 SHEET 1 OF 4 REV B	

LOC	DIST	REV	DATE	BY	APP'D
A	66				

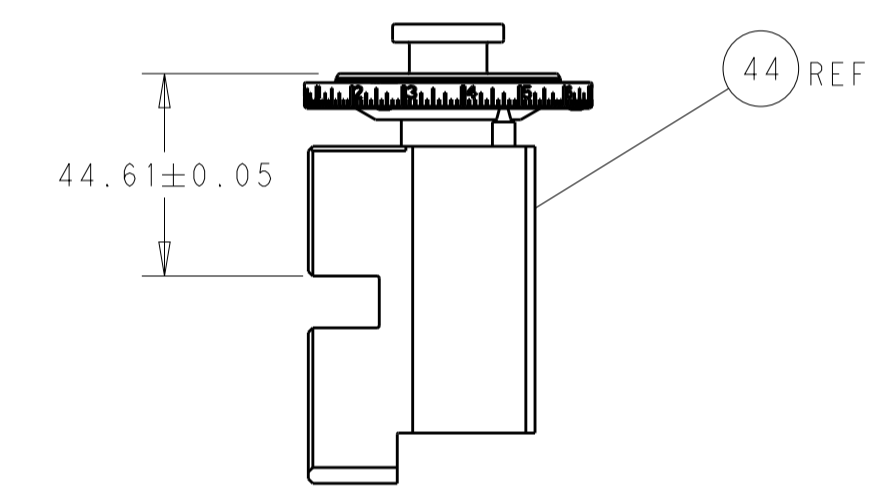
### FEED TYPE MECHANICAL



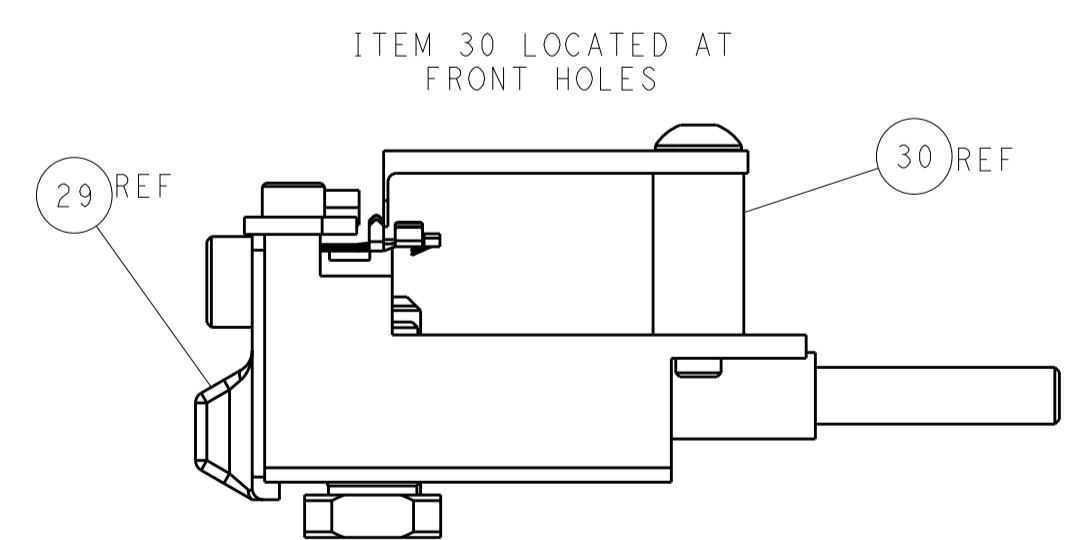
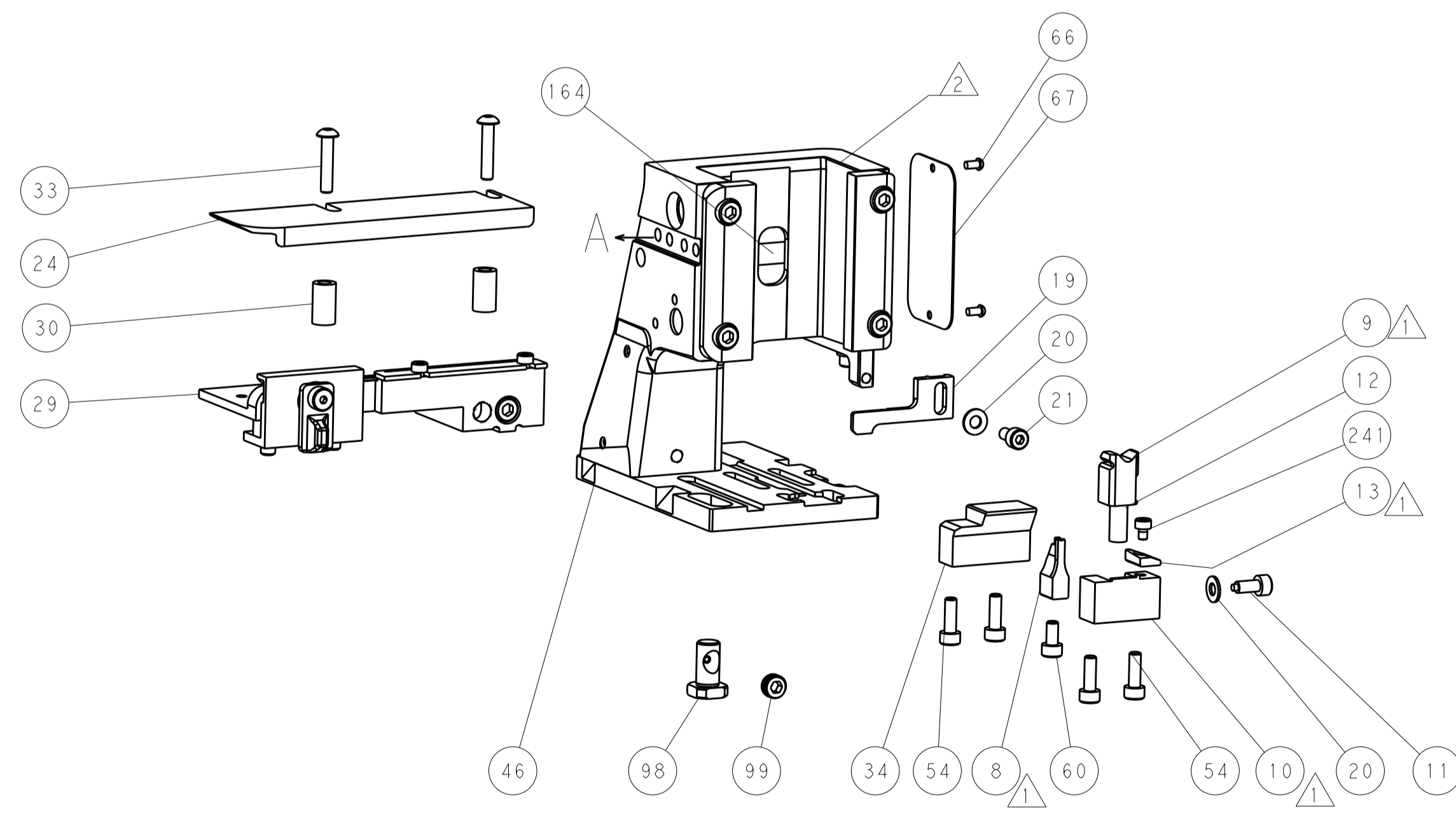
### PNEUMATIC



TERMINAL SUPPORT LOCATION

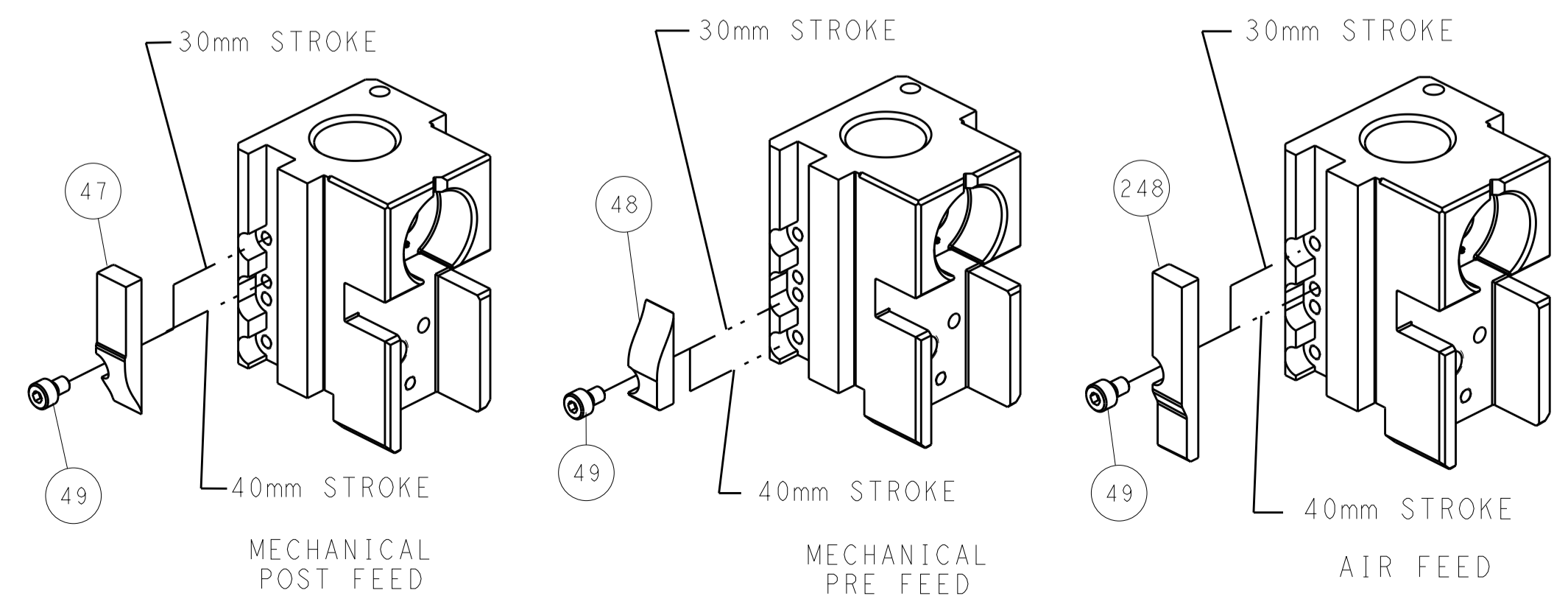


RAM SET-UP



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)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN Y. YIN 12OCT2011		TE Connectivity	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	Harrisburg, PA 17105-3608	
MATERIAL:		FINISH:		APVD S. XI 12OCT2011		NAME Ocean Side Feed Applicator	
				WEIGHT		SIZE CAGE CODE DRAWING NO. RESTRICTED TO	
				Customer Accessible Production Drawing		A1 00779 ©=2151115	
				SCALE 1:2		SHEET 2 OF 4 REV B	

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2151115-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2151115-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151115-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR  
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.57 mm [.062]	F
INSUL	2.79 mm [.110]	F

APPLICATOR INSTRUCTIONS  
408-35042

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: MINI AMP-IN			
WIRE STRIP LENGTH 1.72-2.48 mm [.068-.098 IN]		INSULATION DIAMETER RANGE Ø1.52-2.79 mm [.060-.110 IN]	
TERMINAL APPLICATION SPECIFICATION	114-1016	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
350566-1	350566-3	350566-4	350566-5
350566-6	350566-7	3-350566-1	

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
18 AWG OR 0.82mm <sup>2</sup>	1.07+/-0.05 [.042+/-0.002]	6.3
20 AWG OR 0.50mm <sup>2</sup>	1.07+/-0.05 [.042+/-0.002]	6.0
22 AWG OR 0.32mm <sup>2</sup>	1.07+/-0.05 [.042+/-0.002]	5.7

- 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.

**\*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	REV	DATE	BY	APPV
A	66	-	-	-	-

REV	REF	QTY	DESCRIPTION	DATE	BY	APPV
-	1	-	2119640-1	PUSH ROD, AIR FEED		250
-	1	-	1803259-1	BUSHING, FLANGED		249
-	1	1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT		244
-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST		243
-	1	1	2119083-1	RETAINER, INSULATION DIAL		242
-	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0		241
-	-	1	2119580-1	MECHANICAL FEED ASSEMBLY		239
-	1	-	2063440-1	AIR FEED MODULE		238
-	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	2844908-1	SCREW, LOCKING		99
-	1	1	2844907-1	POST, LOCKING		98
-	1	1	455888-6	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
-	1	1	3-1752356-9	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	1-455888-0	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	1-1338691-0	ANVIL, COMBINATION .062		8
-	1	1	2119757-8	DEPRESSOR, SHEAR		5
-	1	1	2-238011-2	BLOCK, CRIMPER SPACER		4
1	1	1	2-2119582-1	CRIMPER, INSULATION F PREMIUM		3
1	1	1	1-456403-5	CRIMPER, WIRE PREMIUM		1

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		MATERIAL:		FINISH:	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES	FINISH

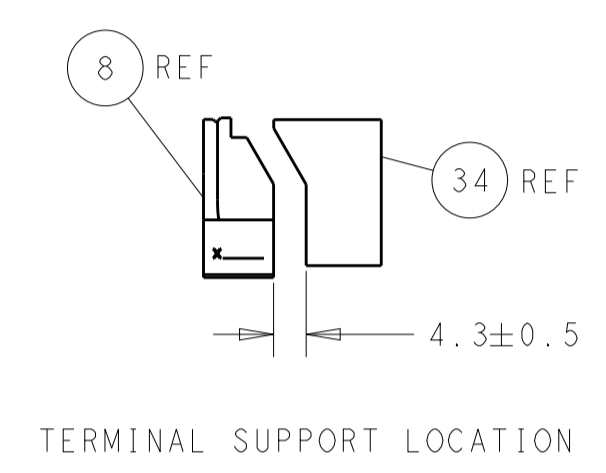
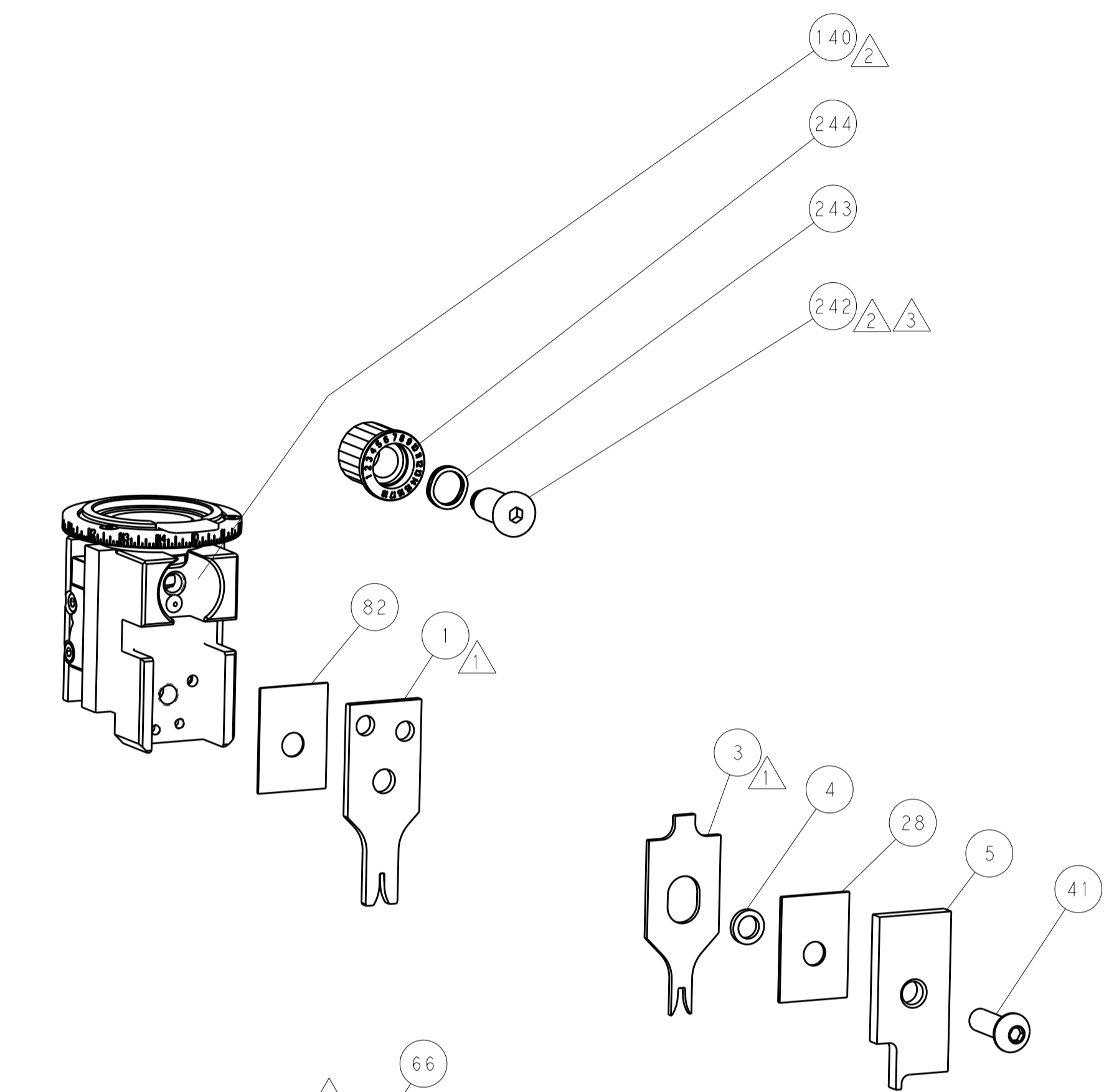
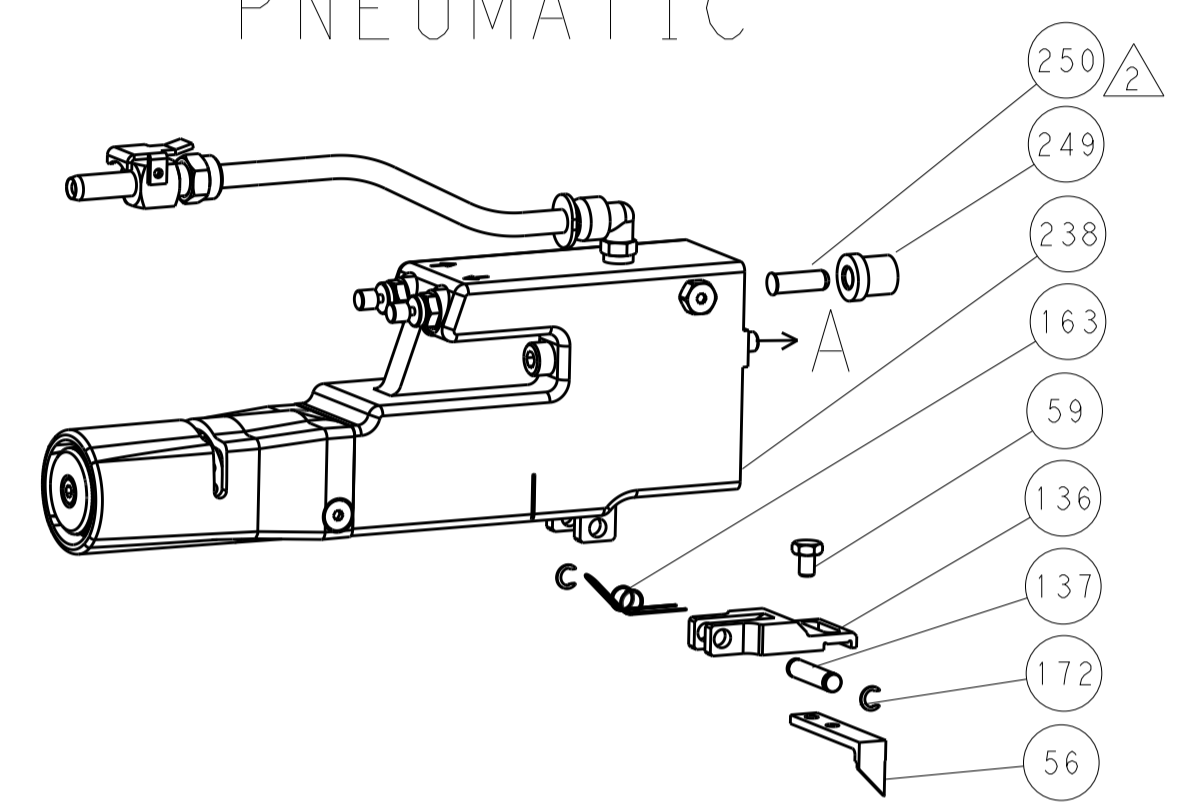
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PRODUCT SPEC	-				
APPLICATION SPEC	-				
SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO		
A1	00779	2151115	-		
Customer Accessible Production Drawing			SCALE	1:2	SHEET 3 OF 4

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

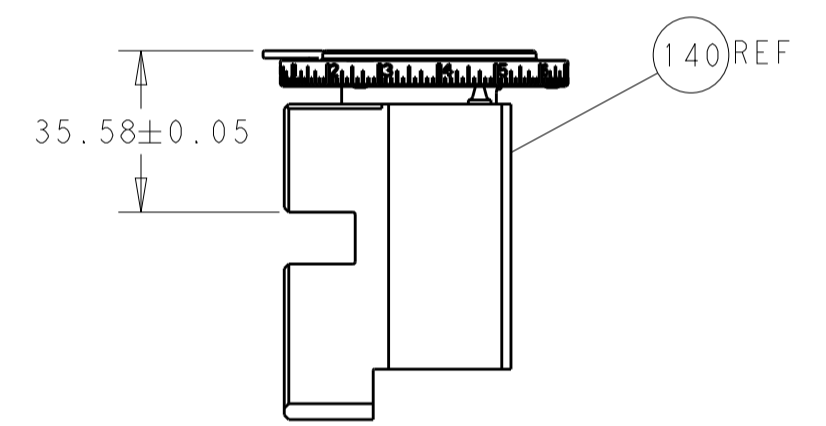
# FEED TYPE MECHANICAL



# PNEUMATIC

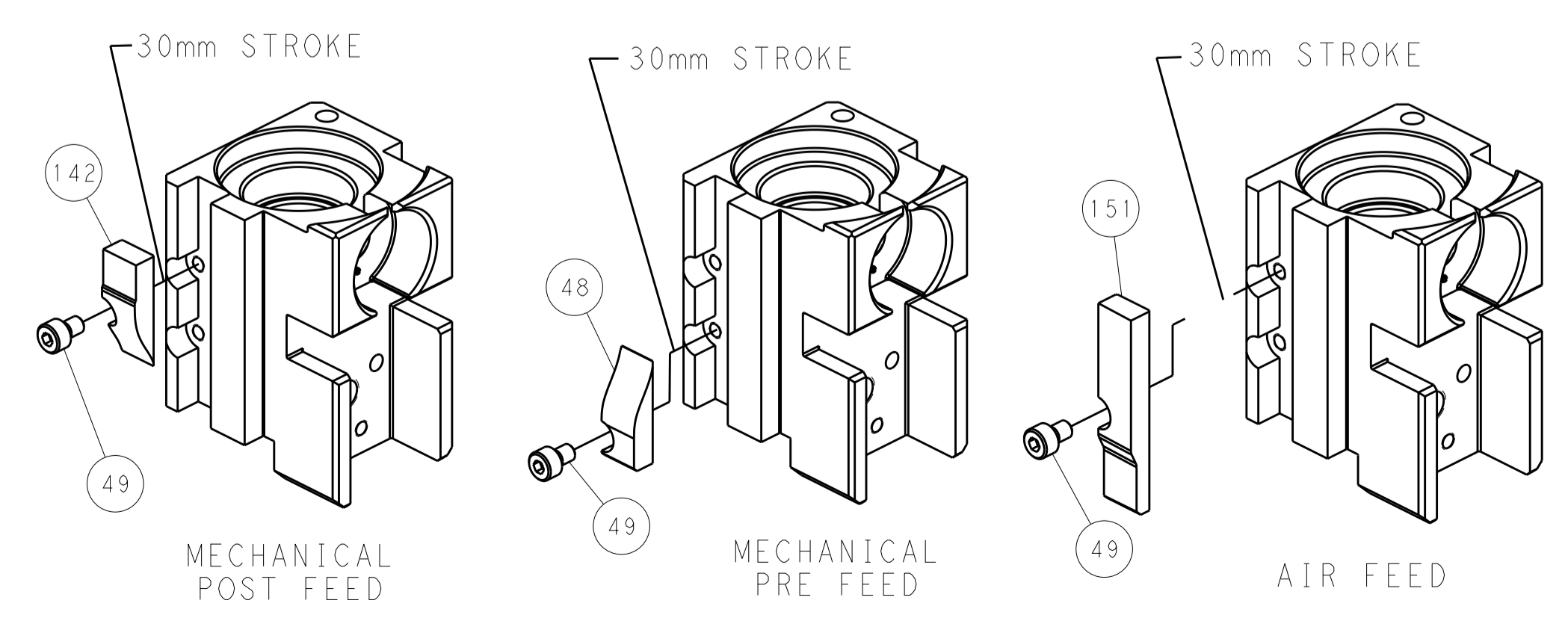


TERMINAL SUPPORT LOCATION



RAM SET-UP

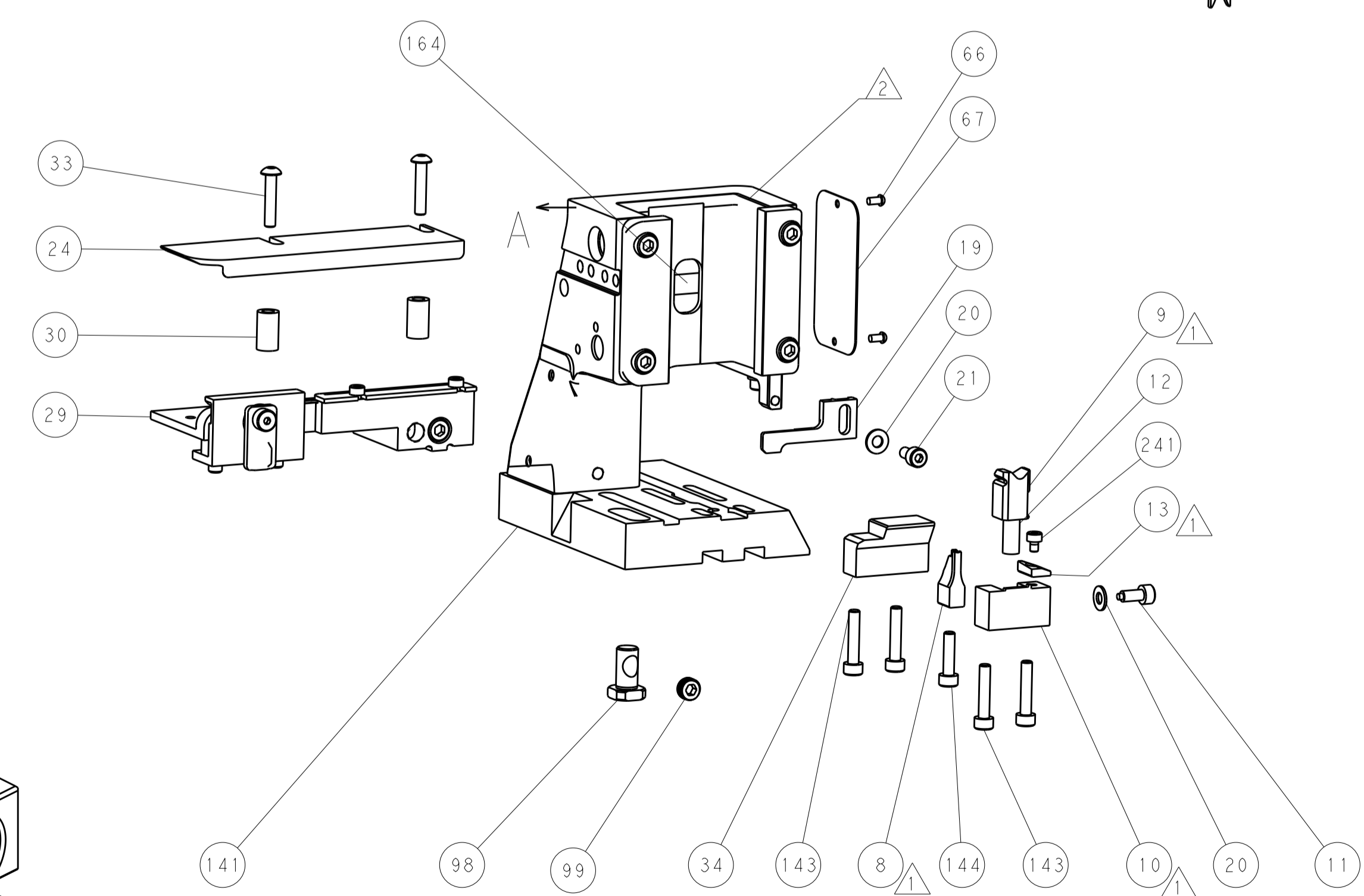
# CAM POSITIONS



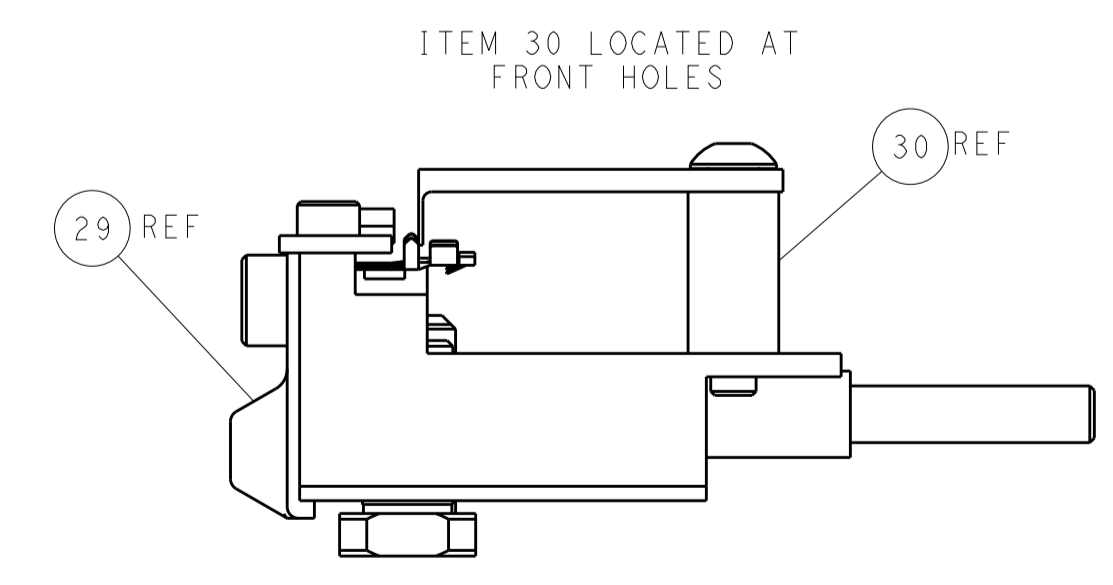
MECHANICAL POST FEED

MECHANICAL PRE FEED

AIR FEED



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



FEED TRACK POSITION GUIDE BY INSULATION BARREL

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN Y. YIN 12OCT2011		TE Connectivity	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	5 PLC ±	Harrisburg, PA 17105-3608
MATERIAL:		FINISH:		CHK G. BAILEY 12OCT2011		NAME	
				S. XI 12OCT2011		Ocean Side Feed Applicator	
				APVD		SIZE CAGE CODE DRAWING NO RESTRICTED TO	
				PRODUCT SPEC		A 00779 C=2151115	
				APPLICATION SPEC		Customer Accessible Production Drawing	
				WEIGHT		SCALE 1:2 SHEET 4 OF 4 REV B	