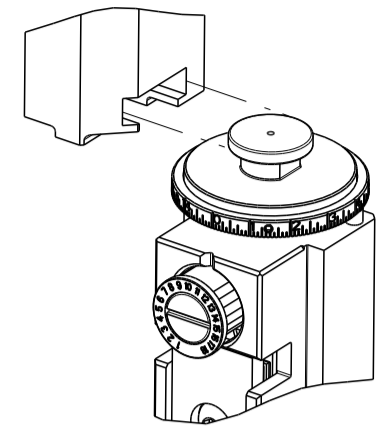


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151481-1	F	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2151481-2	F	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151481-1	F	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2151481-2	F	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2151481-7	F	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.03 mm [.080]	F
INSUL	2.54 mm [.100]	OV

APPLICATOR INSTRUCTIONS 408-35042

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: TAB 1.6 X 0.6 MM			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
4.00-4.60 mm [.157-.181 IN]		Ø1.40-2.10 mm [.055-.083 IN]	
TERMINAL APPLICATION SPECIFICATION	(A)114-18081		
	(B)114-18082		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
(A) 964348-2	(B) 969079-2	(B) 969079-3	-

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: TAB 1.6 X 0.6 MM			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
4.00-4.60mm [.157-.181 IN]		Ø1.40-2.10 mm [.055-.083 IN]	
TERMINAL APPLICATION SPECIFICATION	(A)114-18081		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL		
(A) 964150-1	(A) 964150-2	-	-

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.00mm2	1.20+/-0.05 [.047+/- .002]	4.9
0.75mm2	1.18+/-0.05 [.046+/- .002]	5.1
0.50mm2	1.15+/-0.05 [.045+/- .002]	5.4

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.00mm2	1.36+/-0.05 [.054+/- .002]	3.5
0.75mm2	1.27+/-0.05 [.050+/- .002]	4.3
0.50mm2	1.18+/-0.05 [.046+/- .002]	5.1

- 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.

**\*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	LTN	DESCRIPTION	DATE	DWN	APVD
		C		ECR-17-011864	15AUG2017	TB	TE
		D		ECR-18-008727	06JUN2018	VLA	JDG
		E		ECR-19-009593	19JUN2019	FJ	TE
		F		ECR-23-169999	21MAR2023	ROY	JAH

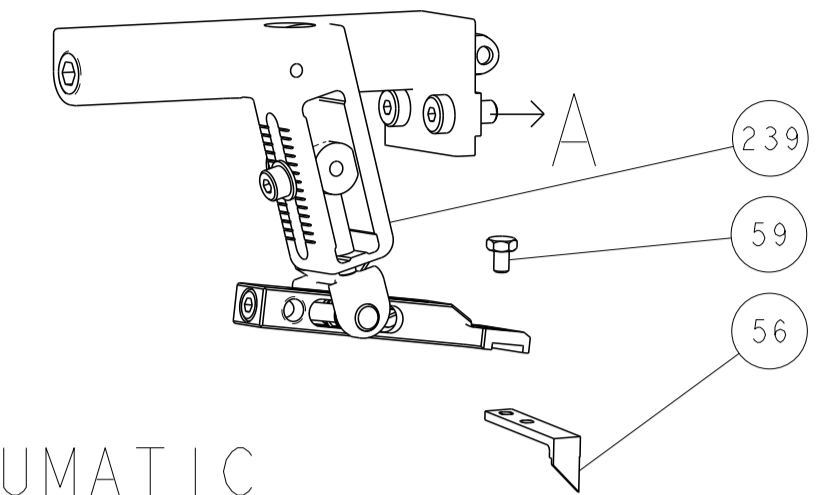
-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248
-	1	1	1	1	2119082-7	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
	-	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	1	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
-	-	1	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	1	-	1	-	2844940-1	AIR FEED MODULE	238
-	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
	-	1	1	1	1-18028-2	WASHER, FLAT, REG M4	119
-	1	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	455888-5	SPACER, CRIMPER	82
-	1	1	1	1	1803607-3	DOCUMENTATION PACKAGE	71
-	1	1	1	1	2119791-9	DEPRESSOR, WIRE	70
-	1	1	1	1	2119943-1	WASHER, SPACER	69
-	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
-	2	2	2	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	53
-	1	1	1	1	1803382-6	HOLD DOWN, SPRING LOADED	50
-	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	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	2844992-2	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
-	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	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	2119805-1	SHEAR HOLDER, FRONT	10
	-	1	1	1	454276-5	FLOATING SHEAR, FRONT	9
	1	2	2	1	1-1633131-7	ANVIL, COMBINATION .080	8
-	-	-	-	-	-	-	7
-	-	-	-	-	-	-	6
-	1	1	1	1	2119757-4	DEPRESSOR, SHEAR	5
-	1	1	1	1	238011-4	BLOCK, CRIMPER SPACER	4
	1	2	2	1	1-1633964-8	CRIMPER, INSULATION OVERLAP PREMIUM	3
-	1	1	1	1	455888-3	SPACER, CRIMPER	2
	1	2	2	1	1-456405-6	CRIMPER, WIRE PREMIUM	1

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

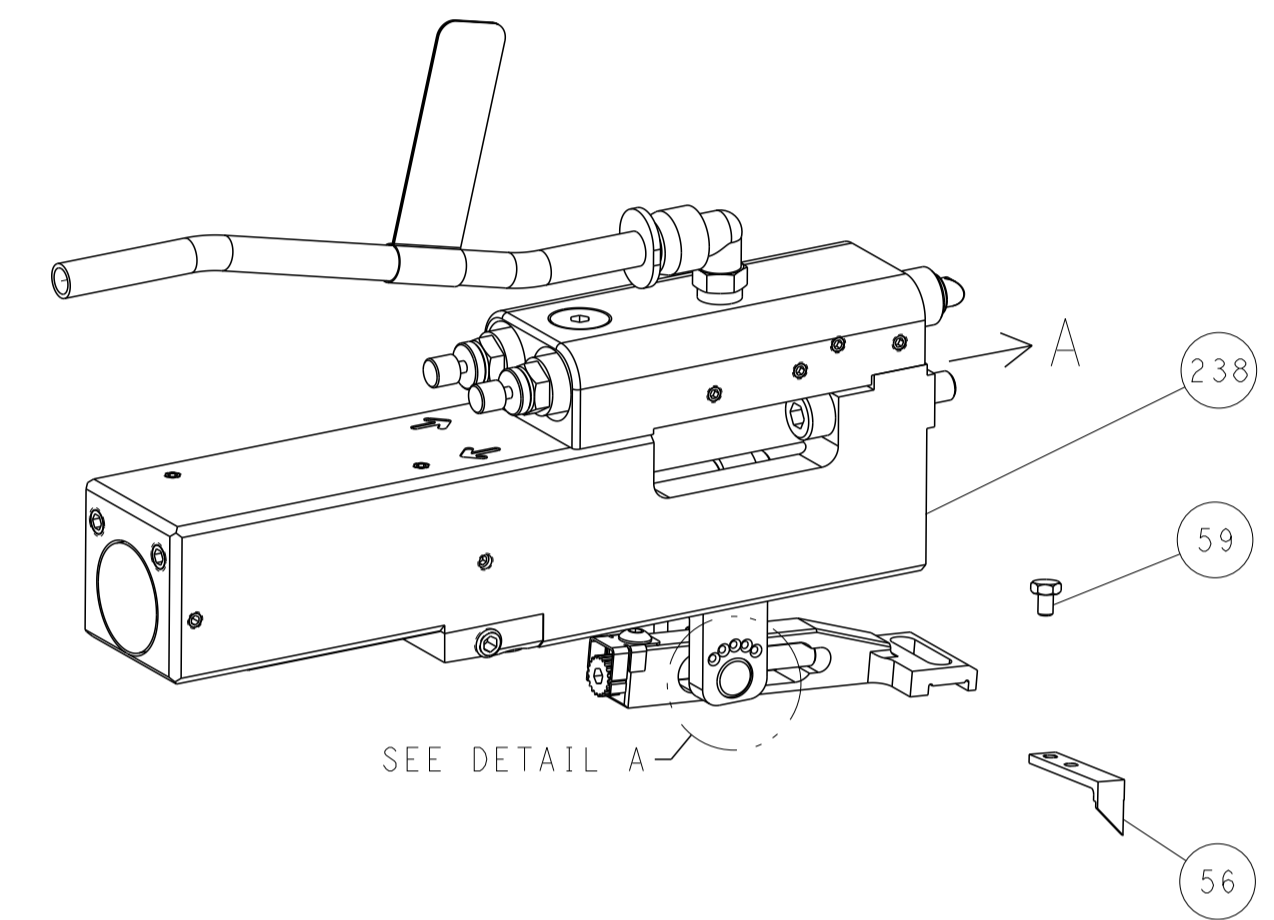
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CHK	S. XI	27AUG2012
APVD	J. CRUZ	27AUG2012
PRODUCT SPEC		
APPLICATION SPEC		
SIZE	A1	00779
CAGE CODE		
DRAWING NO		2151481
RESTRICTED TO		
WEIGHT		
CUSTOMER ACCESSIBLE PRODUCTION DRAWING		
SCALE	1:2	
SHEET	1	OF 4
REV	F	

LOC	DIST	REV	DATE	BY	APPD
A	66				

# FEED TYPE MECHANICAL



## PNEUMATIC

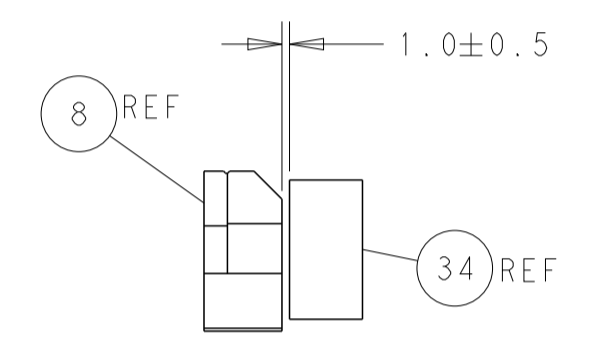
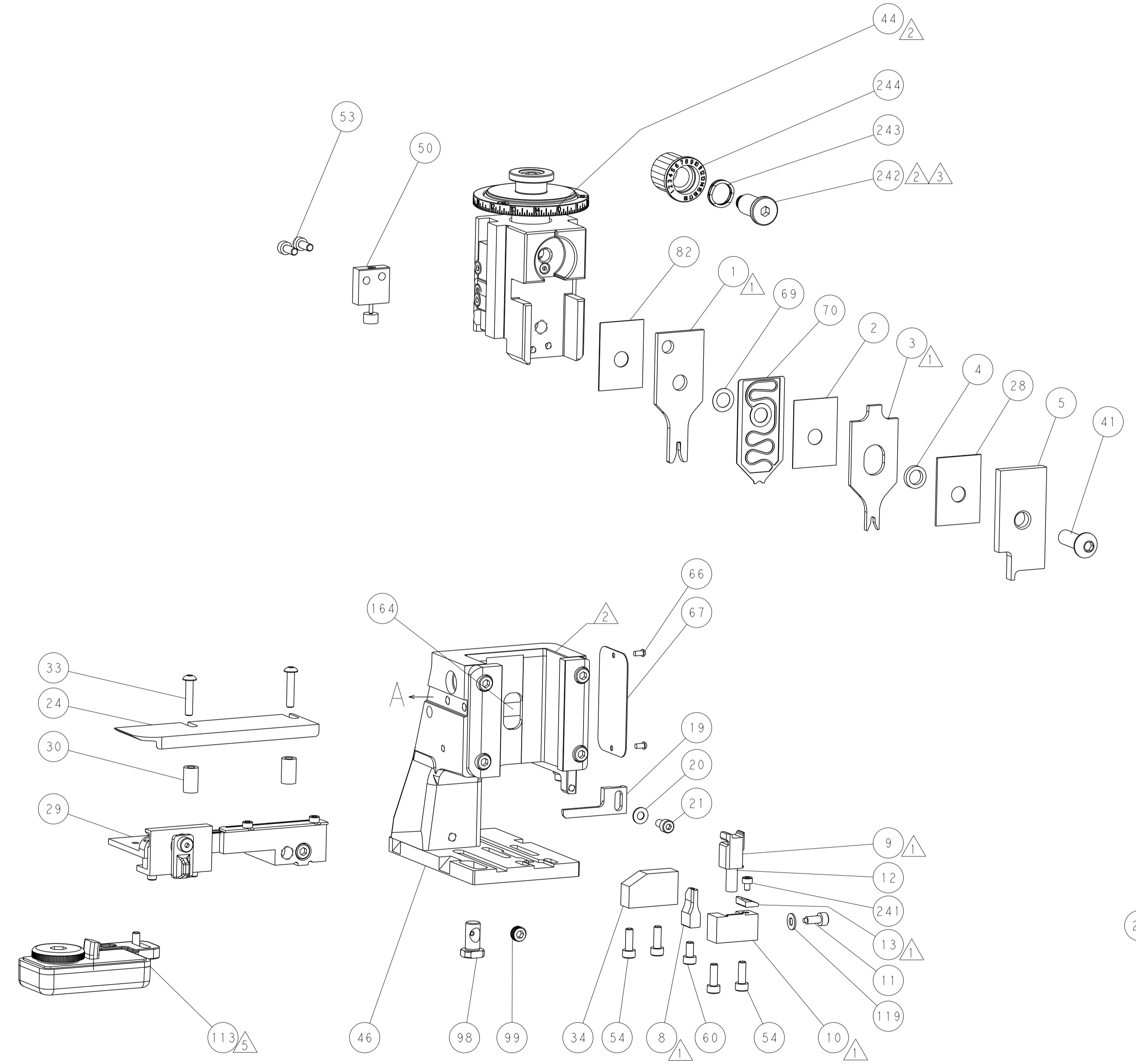
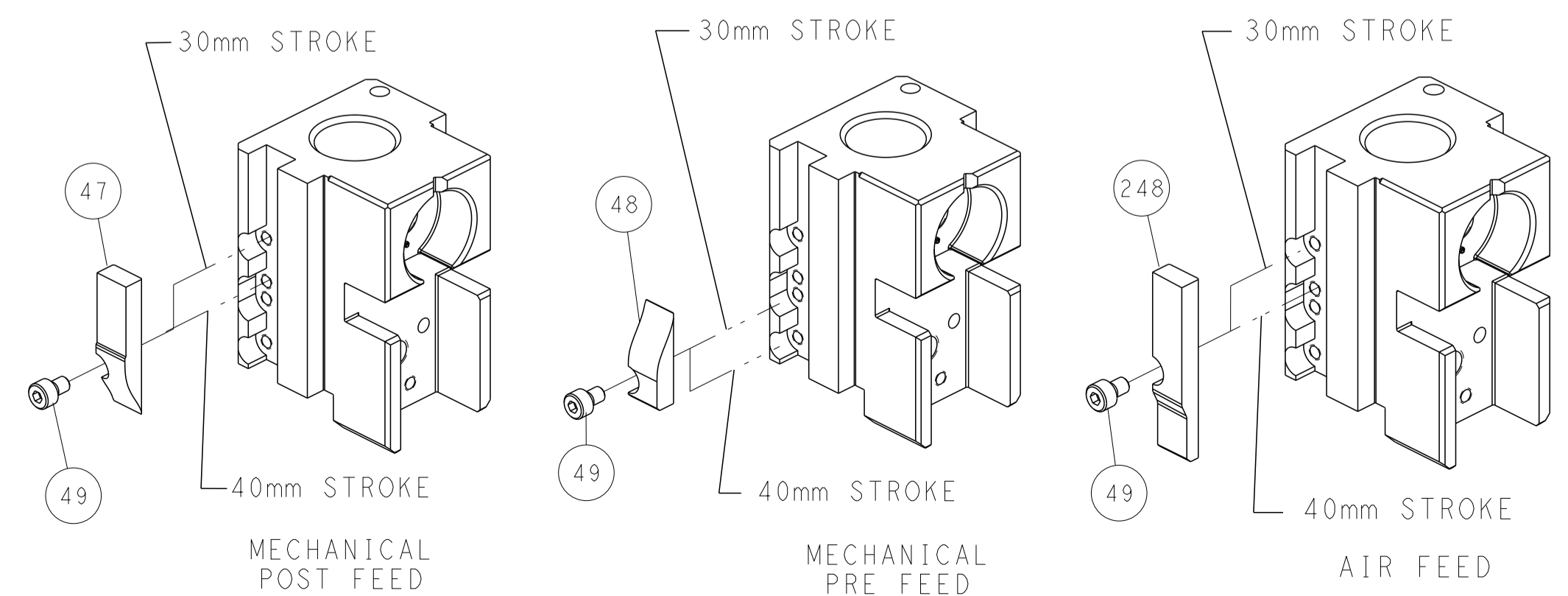


## FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)

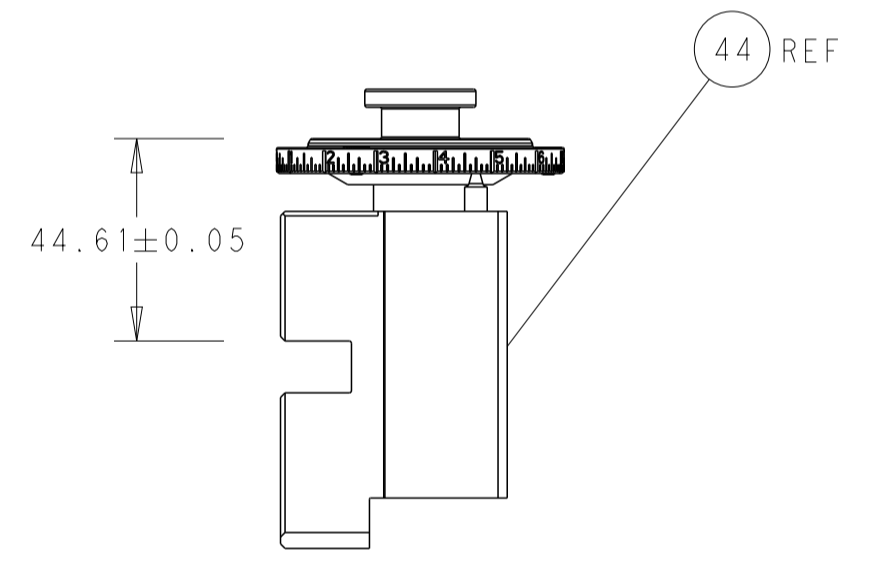


DETAIL A

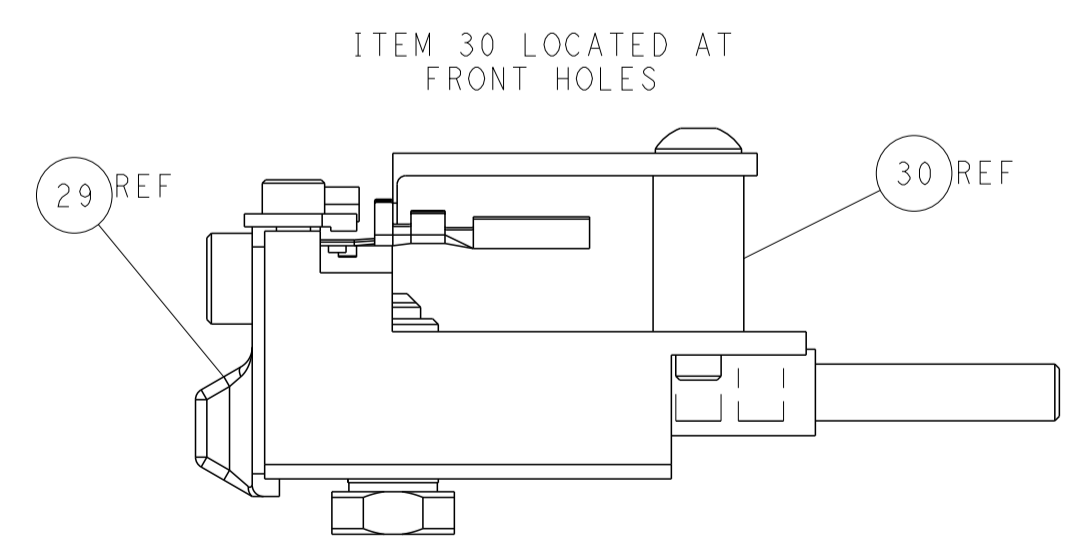
# CAM POSITIONS



TERMINAL SUPPORT LOCATION



RAM SET-UP



FEED TRACK POSITION GUIDE BY INSULATION BARREL

**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:		DRAWING NO.		NAME	
mm	0 PLC	±		27AUG2012	TE Connectivity		
	1 PLC	±		27AUG2012	Harrisburg, PA 17105-3608		
	2 PLC	±					
	3 PLC	±					
	4 PLC	±					
	ANGLES	±					
	FINISH	±					
MATERIAL				WEIGHT	SIZE	CAGE CODE	DRAWING NO.
					A1	00779	2151481
Customer Accessible Production Drawing				SCALE	1:2	SHEET	2 of 4
				REV	F		

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2151481-1	F	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2151481-2	F	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151481-7	F	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR  
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.03 mm [.080]	F
INSUL	2.54 mm [.100]	OV
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: TAB 1.6 X 0.6 MM			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
4.00-4.60 mm [.157-.181 IN]		Ø1.40-2.10 mm [.055-.083 IN]	
TERMINAL APPLICATION SPECIFICATION	(A)114-18081	-	-
	(B)114-18082	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
(A) 964348-2	(B) 969079-2	(B) 969079-3	-

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: TAB 1.6 X 0.6 MM			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
4.00-4.60 mm [.157-.181 IN]		Ø1.40-2.10 mm [.055-.083 IN]	
TERMINAL APPLICATION SPECIFICATION	(A) 114-18081	-	-
	-	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	-	-
(A) 964150-1	(A) 964150-2	-	-

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.00mm2	1.20 +/- 0.05 [.047 +/- .002]	4.9
0.75mm2	1.18 +/- 0.05 [.046 +/- .002]	5.1
0.50mm2	1.15 +/- 0.05 [.045 +/- .002]	5.4

WIRE SIZE	CRIMP HEIGHT WIRE CRIMP UNIT	CRIMP HEIGHT REFERENCE SETTING
1.00mm2	1.36 +/- 0.05 [.054 +/- .002]	3.5
0.75mm2	1.27 +/- 0.05 [.050 +/- .002]	4.3
0.50mm2	1.18 +/- 0.05 [.046 +/- .002]	5.1



- 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.

**\*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.

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

-	1	1	2119082-7	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	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	455888-5	SPACER, CRIMPER	82
-	1	1	1803607-3	DOCUMENTATION PACKAGE	71
-	1	1	2119791-9	DEPRESSOR, WIRE	70
-	1	1	2119943-1	WASHER, SPACER	69
-	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
-	2	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	53
-	1	1	1803382-6	HOLD DOWN, SPRING LOADED	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	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	2844992-2	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
-	1	1	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	454276-5	FLOATING SHEAR, FRONT	9
-	1	1	9-1633131-7	ANVIL, COMBINATION .080	8
-	-	-	-	-	7
-	-	-	-	-	6
-	1	1	2119757-4	DEPRESSOR, SHEAR	5
-	1	1	238011-4	BLOCK, CRIMPER SPACER	4
-	1	1	7-1633964-8	CRIMPER, INSULATION OVERLAP PREMIUM	3
-	1	1	455888-3	SPACER, CRIMPER	2
-	1	1	1-456405-6	CRIMPER, WIRE PREMIUM	1

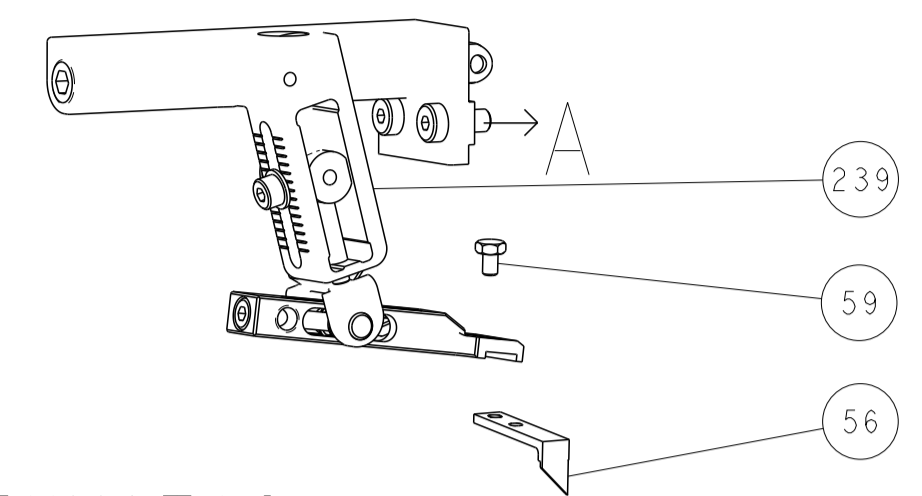
PACIFIC VERSION  
Shown on sheets 3 of 4 & 4 of 4  
(Atlantic version shown on sheets 1 of 4 & 2 of 4)

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

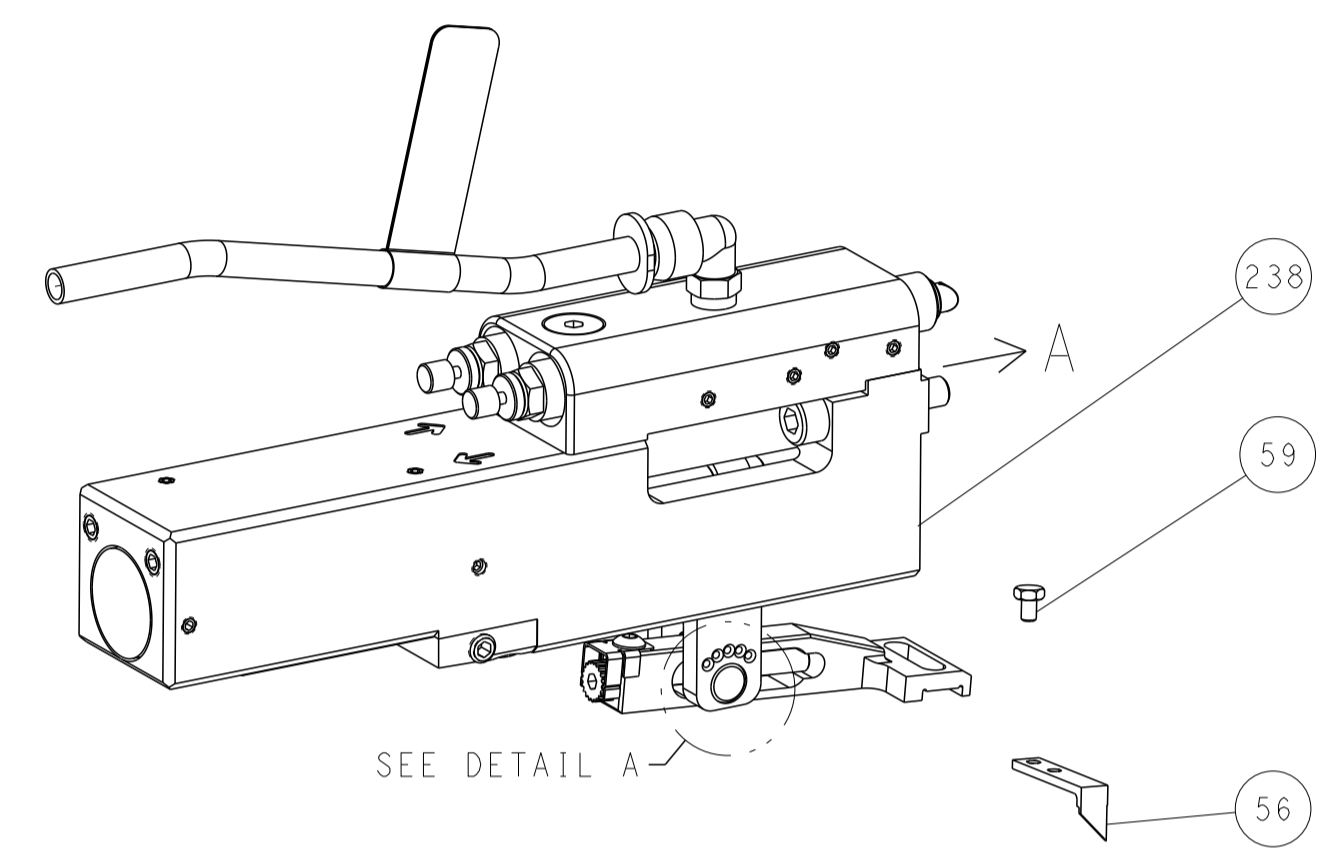
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CHK	S. XI	27AUG2012
APVD	J. CRUZ	27AUG2012
PRODUCT SPEC		
APPLICATION SPEC		
SIZE	A1	00779
CAGE CODE		
DRAWING NO		2151481
RESTRICTED TO		
WEIGHT		
SCALE	1:2	
SHEET	3	OF 4
REV		F

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

# FEED TYPE MECHANICAL



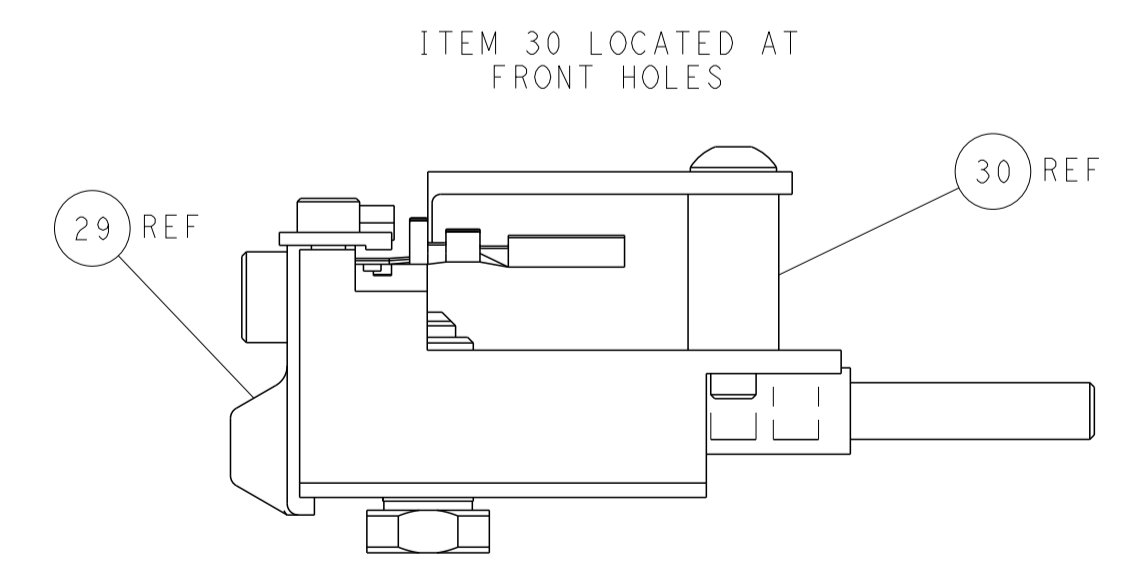
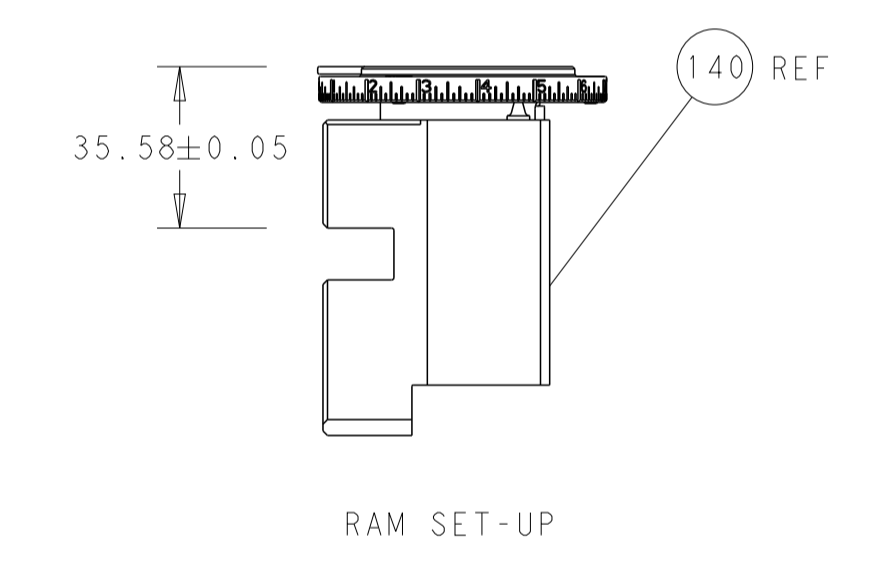
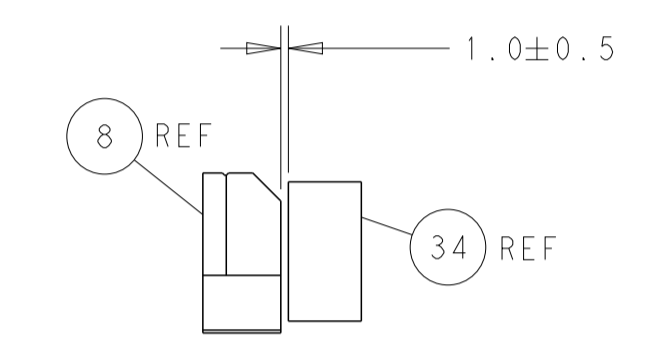
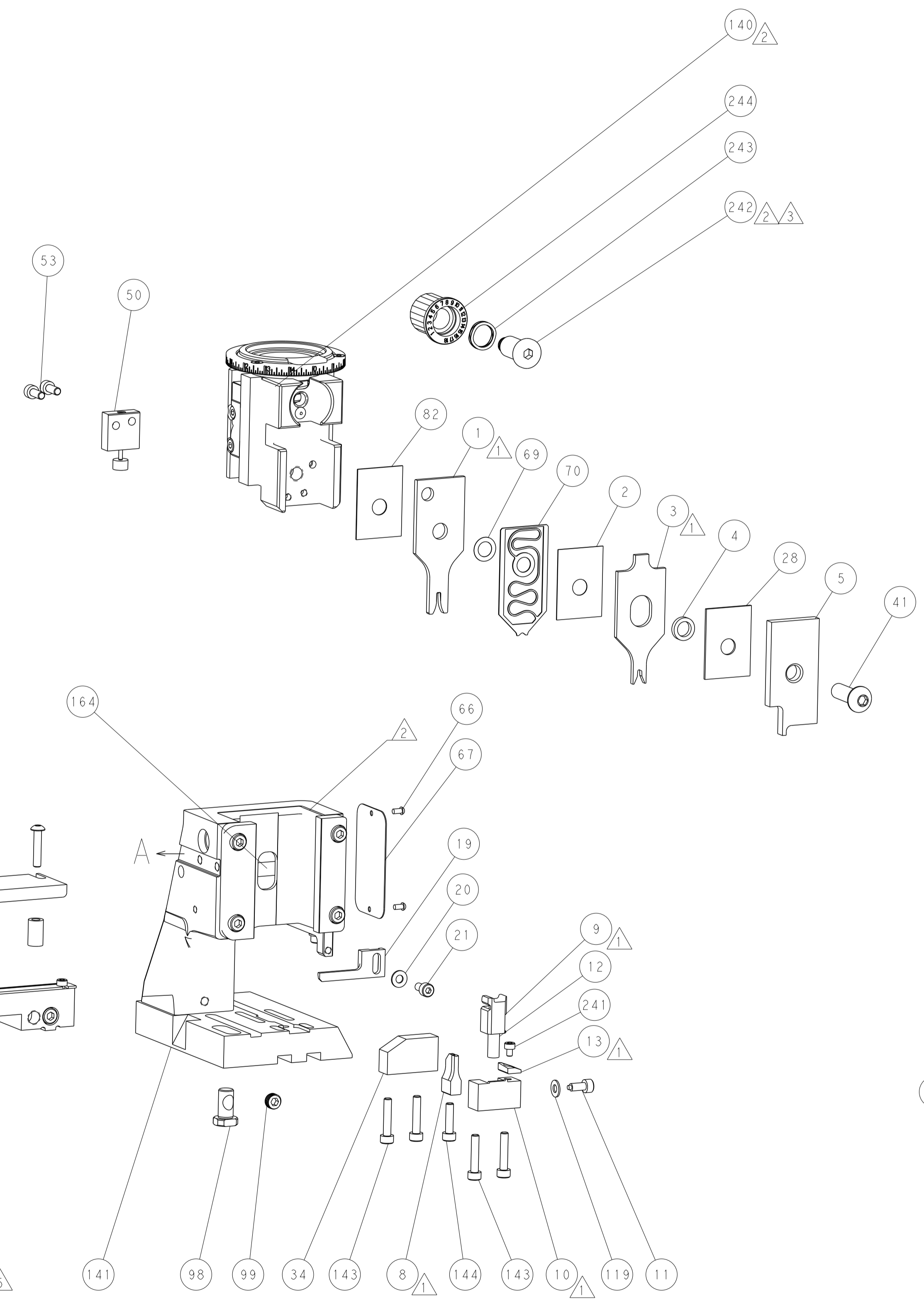
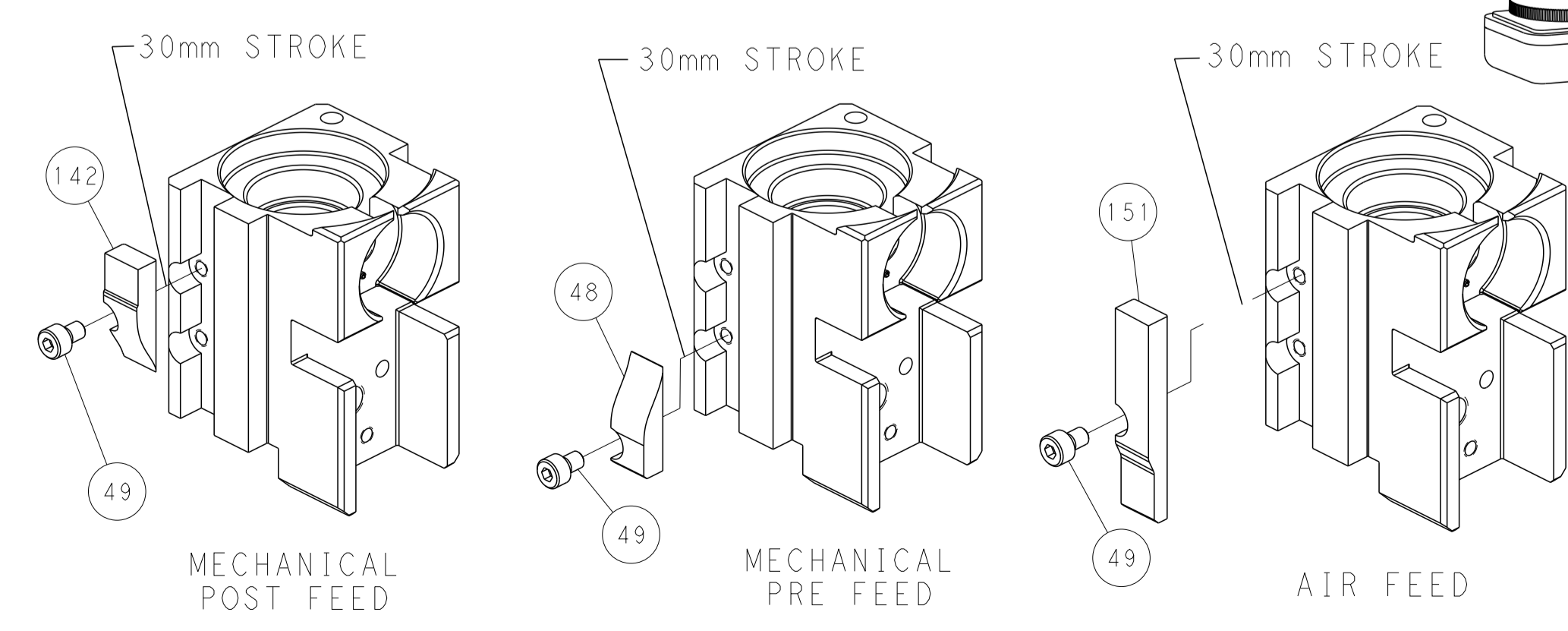
## PNEUMATIC



### FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



## CAM POSITIONS



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

<small>THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION. ALL RIGHTS RESERVED. THIS DRAWING IS CONTROLLED DOCUMENT. THE INFORMATION CONTAINED HEREIN IS UNCLASSIFIED EXCEPT WHERE SHOWN OTHERWISE. THIS INFORMATION IS UNCLASSIFIED EXCEPT WHERE SHOWN OTHERWISE.</small>		DWN: C. CHEN 27AUG2012 CHK: S. XI 27AUG2012 APVD: J. CRUZ 27AUG2012	NAME: TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± MATERIAL: - FINISH: -	PRODUCT SPEC: APPLICATION SPEC: WEIGHT: - SCALE: 1:2	SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2151481 CUSTOMER ACCESSIBLE PRODUCTION DRAWING	RESTRICTED TO: - SHEET 4 OF 4 REV F