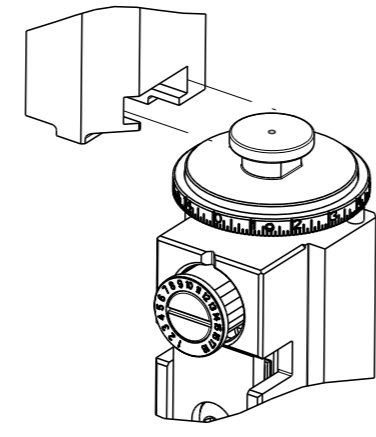


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151321-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2151321-2	D	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151321-1	C	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2151321-2	D	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2151321-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	3.56 mm [.140]	F
INSUL	4.57 mm [.180]	F

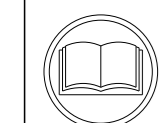
APPLICATOR INSTRUCTIONS 408-35042

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: PIN, .140 PIN & SOCKET CONN.			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
4.78-7.92 mm [.188-.312 IN]		Ø2.54-3.78 mm [.100-.149 IN]	
TERMINAL APPLICATION SPECIFICATION		114-1007	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
925712-1	925712-5	925713-4	350200-2
925712-2	925713-1	925713-7	350201-1
925712-4	925713-2	350200-1	350201-2

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: PIN, .140 PIN & SOCKET CONN.			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
7.14-8.71 mm [.281-.343 IN]		Ø3.81-4.57 mm [.150-.180 IN]	
TERMINAL APPLICATION SPECIFICATION		114-1007	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
925712-1	925712-5	925713-4	350200-2
925712-2	925713-1	925713-7	350201-1
925712-4	925713-2	350200-1	350201-2

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING	STABILIZER SETTINGS
10 AWG	2.54+/-0.05 [.100+/- .002]	2.0	7
12 AWG	2.08+/-0.05 [.082+/- .002]	6.8	4
14 AWG	1.78+/-0.05 [.070+/- .002]	10.1	1

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING	STABILIZER SETTINGS
10 AWG	2.54+/-0.05 [.100+/- .002]	2.0	7
12 AWG	2.08+/-0.05 [.082+/- .002]	6.8	4
14 AWG	1.78+/-0.05 [.070+/- .002]	10.1	1



- 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.

LOC	DIST	REVISIONS					
A	66	P	LY#	DESCRIPTION	DATE	OWN	APVD
		A		RELEASED	14JAN2015	KS	TE
		B		ECR-16-004345	23MAR2016	XZ	TE
		C		ECR-18-015402	28SEP2018	FL	TE
		D		ECR-20-017678	15DEC2020	JAH	RR

-	1	1	1	1	1803078-3	SPACER, PRECISION	259
-	1	1	1	1	2119787-3	CRIMPER, STABILIZER O PREMIUM	258
-	1	1	1	1	2119348-2	SNAIL CAM, STABILIZER CRIMP ADJUSTMENT	256
-	2	2	2	2	2079844-1	SPRING PLUNGER, M4	255
-	1	1	1	1	2119347-1	KNOB, STABILIZER CRIMP ADJUSTMENT	254
-	1	1	1	1	18032-1	SCR, SET, FLT PNT, M3 X 5.0	253
-	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	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	2844908-1	SCREW, LOCKING	99
-	1	1	1	1	2844907-1	POST, LOCKING	98
-	1	1	1	1	455888-3	SPACER, CRIMPER	82
-	1	1	1	1	1803607-3	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	1338683-8	FEED PAWL	56
-	4	4	4	4	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	54
-	2	2	2	2	2168083-5	SCR, SKT HD CAP, RoHS, M4 X 6.0	53
-	1	1	1	1	1-457754-0	TOOL, SIZING	52
-	1	1	1	1	2-240641-1	SPACER	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	1803515-2	RAM ASSEMBLY, SF ATLANTIC	44
-	1	1	1	1	1803602-2	SCR, BHSC, RoHS (M8 X 40)	41
-	1	1	1	1	2280562-1	TERMINAL SUPPORT	34
-	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	2	2	3-2844962-2	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29
-	1	1	1	1	2119797-1	SPACER, CRIMPER, SPECIAL	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	2119533-3	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	454276-5	FLOATING SHEAR, FRONT	9
-	1	2	2	1	1633926-7	ANVIL, COMBINATION	8
-	-	-	-	-	-	-	7
-	-	-	-	-	-	-	6
-	1	1	1	1	2119349-2	SHEAR DEPRESSOR, STAB. CRIMP ADJ.	5
-	1	1	1	1	2-238011-9	BLOCK, CRIMPER SPACER	4
-	1	2	2	1	2119794-1	CRIMPER, INSUL F PREM, SPECIAL	3
-	1	1	1	1	2119797-2	SPACER, CRIMPER, SPECIAL	2
-	1	2	2	1	456411-7	CRIMPER, WIRE PREMIUM	1

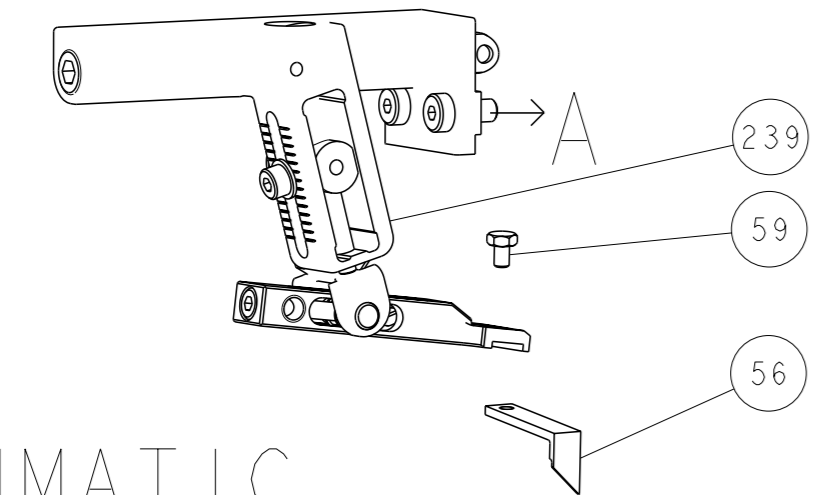
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

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

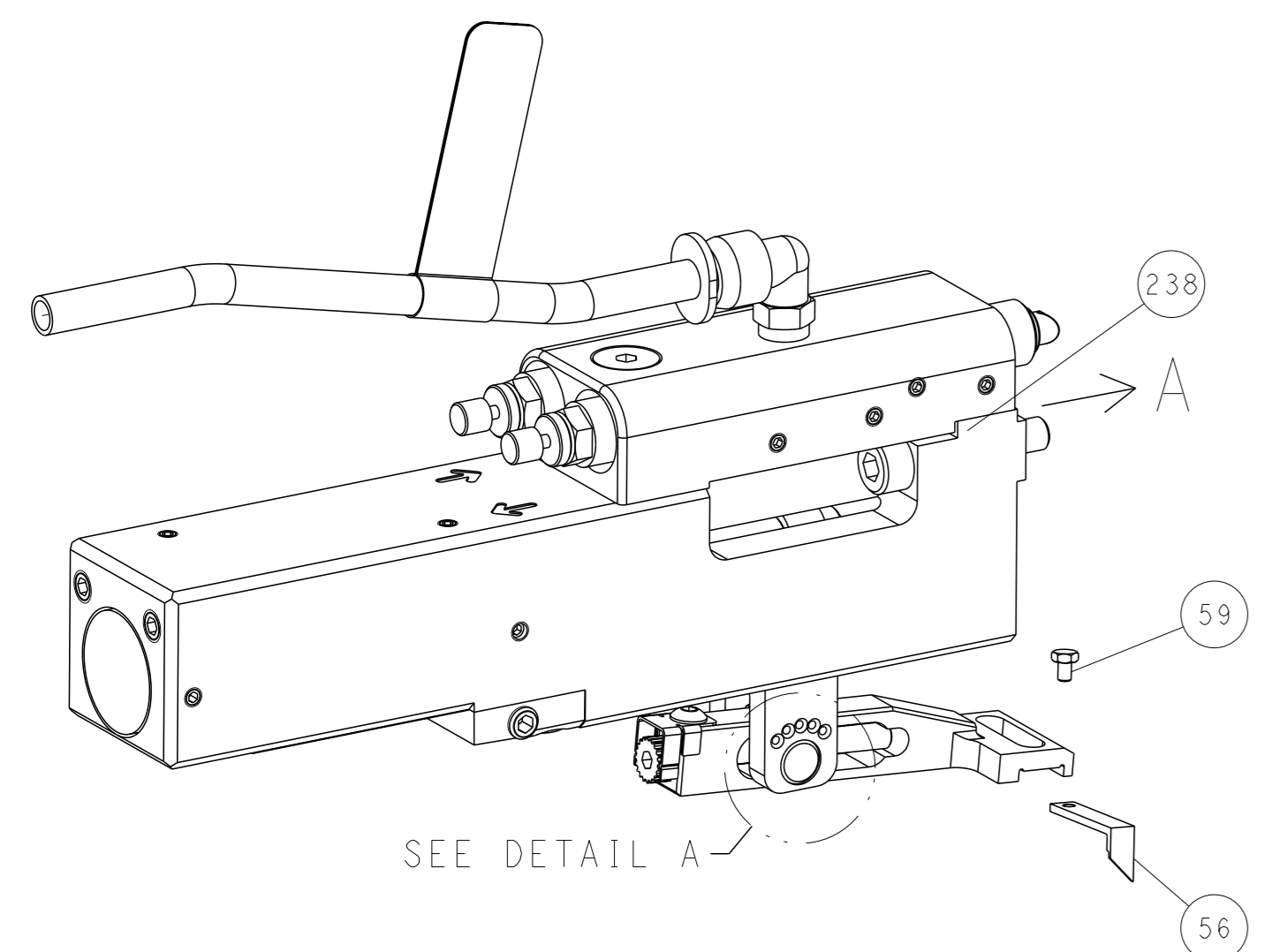
OWN	R. STAKEM	23SEPT2014
CHK	G. BAILEY	23SEPT2014
APVD	T. ELBIN	23SEPT2014
NAME: Ocean Side Feed Applicator		
SIZE	CAGE CODE	DRAWING NO
A1	00779	2151321
Customer Accessible Production Drawing		
SCALE	1:2	SHEET 1 of 4
REV	D	

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

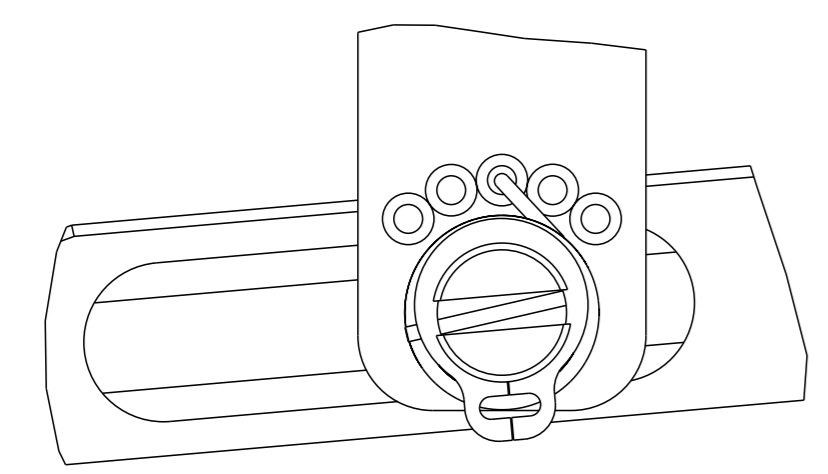
FEED TYPE MECHANICAL



PNEUMATIC

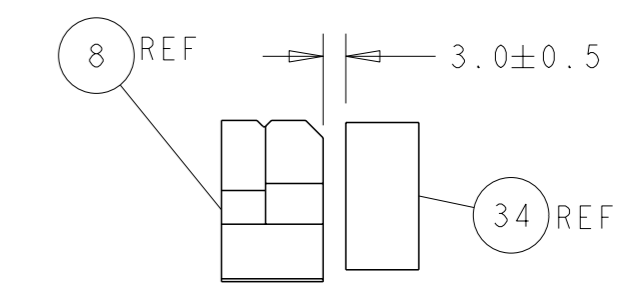
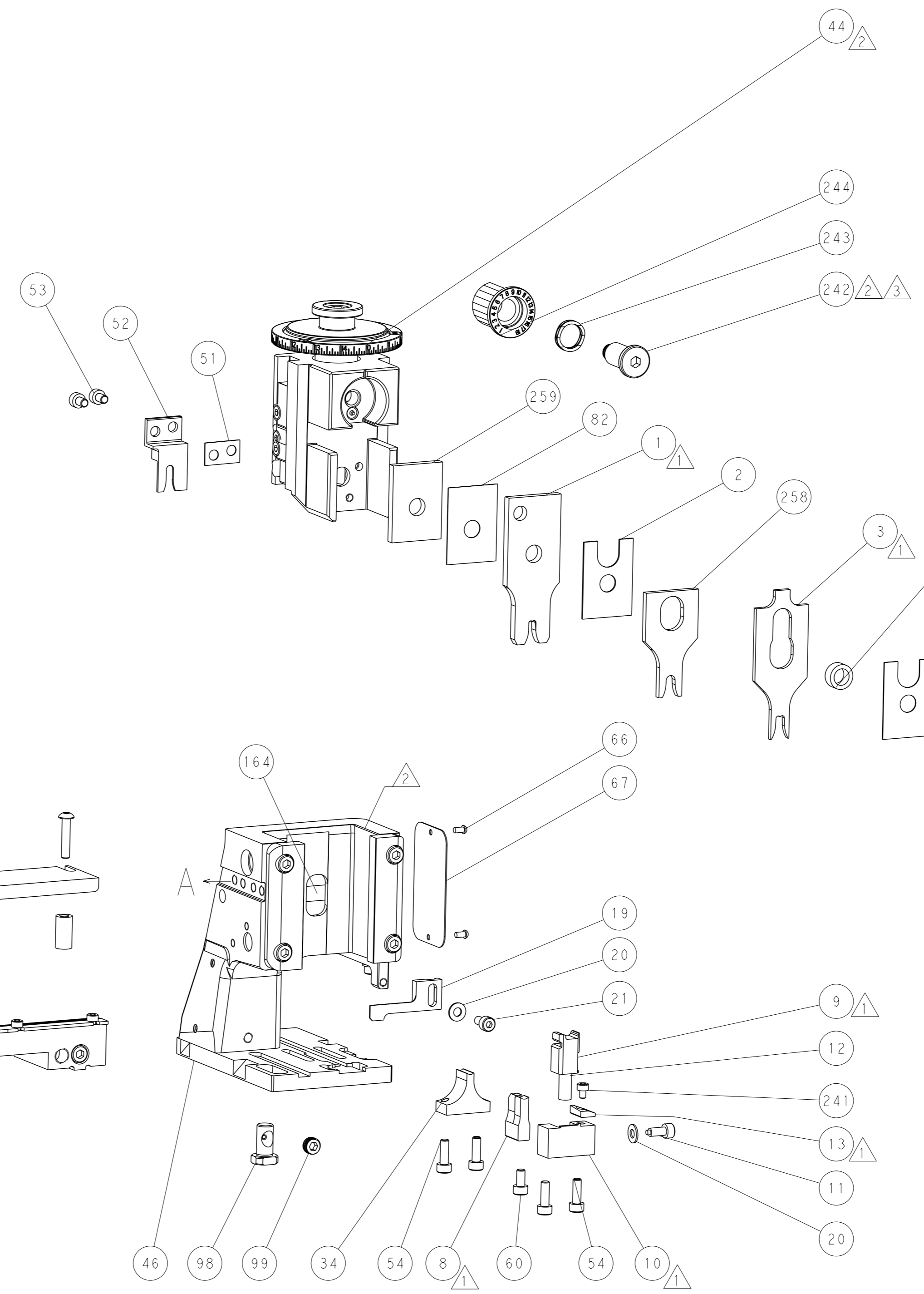
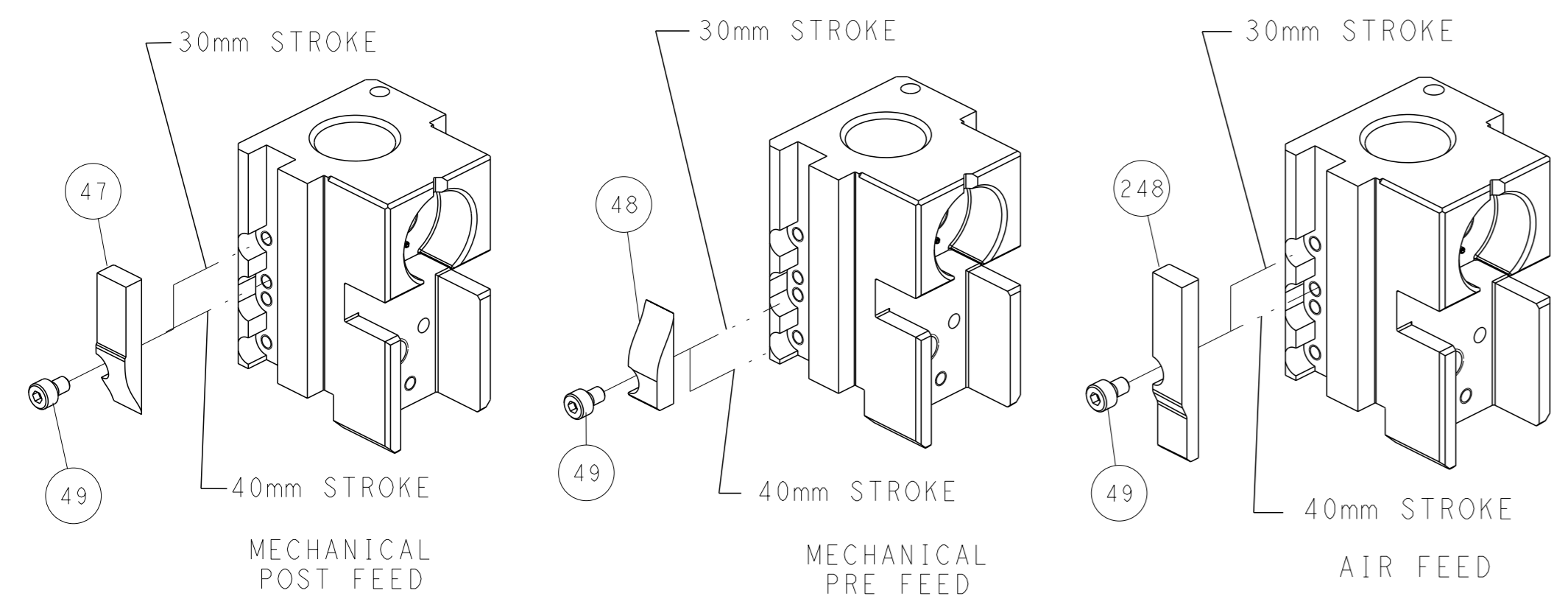


FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)

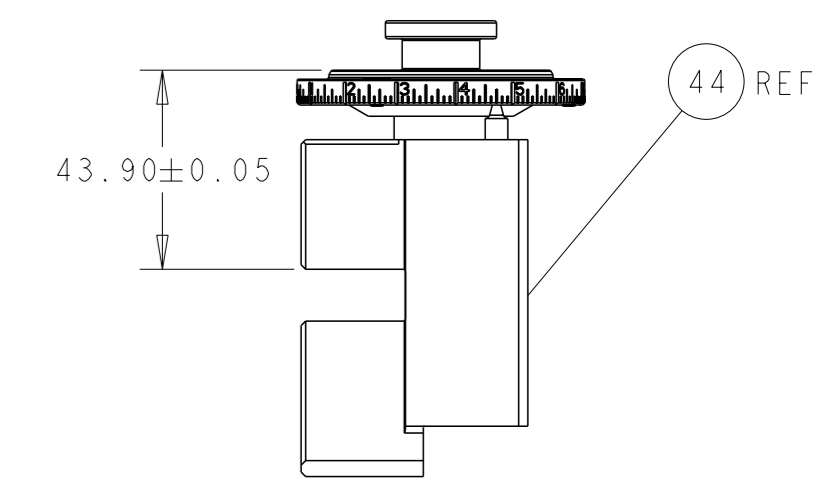


DETAIL A

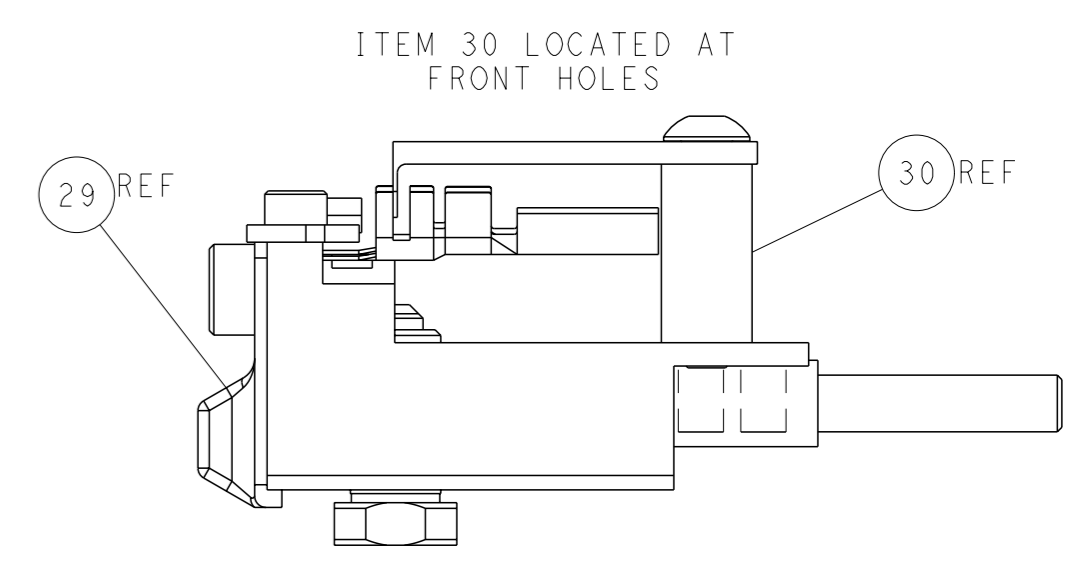
CAM POSITIONS



TERMINAL SUPPORT LOCATION



RAM SET-UP



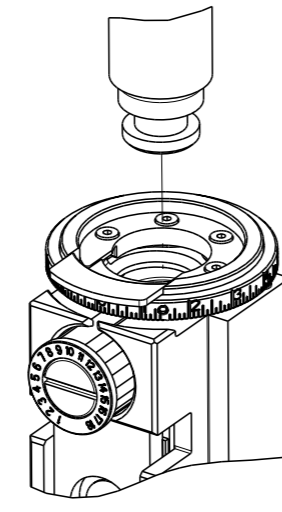
FEED TRACK POSITION GUIDE BY INSULATION BARREL

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

<small>THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE AND TO CONTROLING ENGINEERING DISCRETION. SHOULD BE CONTACTED FOR THE LATEST REVISION.</small>		OWN: R. STAKEM CHK: G. BAILEY APVD: T. ELBIN	23SEPT2014 23SEPT2014 23SEPT2014	TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH ±		NAME: Ocean Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2151321	RESTRICTED TO: - SCALE: 1:2 SHEET: 2 of 4 REV: D	
MATERIAL: - FINISH: -		WEIGHT: - Customer Accessible Production Drawing	SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION	

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BY TFCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.	20		
COPYRIGHT 20			
PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2151321-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2151321-2	D	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151321-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	3.56 mm [.140]	F
INSUL	4.57 mm [.180]	F
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: PIN, .140 PIN & SOCKET CONN.			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
4.78-7.92 mm [.188-.312 IN]		Ø2.54-3.78 mm [.100-.149 IN]	
TERMINAL APPLICATION SPECIFICATION	114-1007	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
925712-1	925712-5	925713-4	350200-2
925712-2	925713-1	925713-7	350201-1
925712-4	925713-2	350200-1	350201-2

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: PIN, .140 PIN & SOCKET CONN.			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
7.14-8.71 mm [.281-.343 IN]		Ø3.81-4.57 mm [.150-.180 IN]	
TERMINAL APPLICATION SPECIFICATION	114-1007	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
925712-1	925712-5	925713-4	350200-2
925712-2	925713-1	925713-7	350201-1
925712-4	925713-2	350200-1	350201-2

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING	STABILIZER SETTING
10 AWG	2.54+/-0.05 [.100+/-0.002]	2.0	7
12 AWG	2.08+/-0.05 [.082+/-0.002]	6.8	4
14 AWG	1.78+/-0.05 [.070+/-0.002]	10.1	1

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING	STABILIZER SETTINGS
10 AWG	2.54+/-0.05 [.100+/-0.002]	2.0	7
12 AWG	2.08+/-0.05 [.082+/-0.002]	6.8	4
14 AWG	1.78+/-0.05 [.070+/-0.002]	10.1	1

- 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.

LOC	DIST	REV	DATE	BY	APPV
A	66				

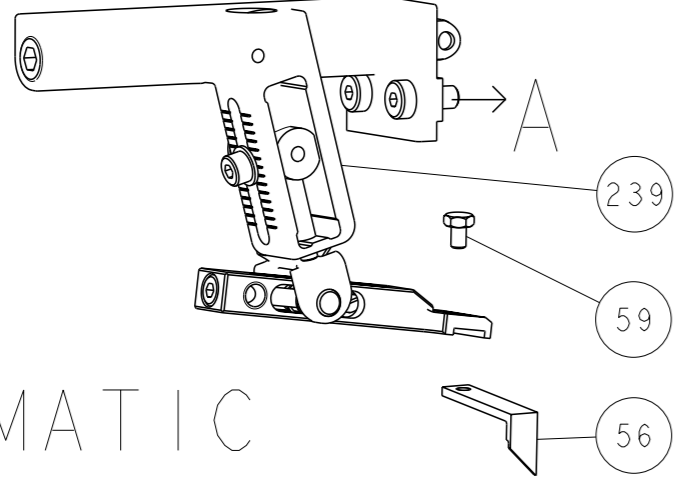
REV	DATE	BY	APPV	DESCRIPTION	ITEM NO
-	-	-	-	SEE SHEET 1	-
-	1	1		1803078-3 SPACER, PRECISION	259
-	1	1		2119787-3 CRIMPER, STABILIZER O PREMIUM	258
-	1	1		2119348-2 SNAIL CAM, STABILIZER CRIMP ADJUSTMENT	256
-	2	2		2079844-1 SPRING PLUNGER, M4	255
-	1	1		2119347-1 KNOB, STABILIZER CRIMP ADJUSTMENT	254
-	1	1		18032-1 SCR, SET, FLT PNT, M3 X 5.0	253
-	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		1803516-2 RAM ASSEMBLY, SF PACIFIC	140
-	1	1		2844908-1 SCREW, LOCKING	99
-	1	1		2844907-1 POST, LOCKING	98
-	1	1		455888-3 SPACER, CRIMPER	82
-	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		1338683-8 FEED PAWL	56
-	2	2		2168083-5 SCR, SKT HD CAP, RoHS, M4 X 6.0	53
-	1	1		1-457754-0 TOOL, SIZING	52
-	1	1		2-240641-1 SPACER	51
-	1	2		18023-9 SCR, SKT HD CAP M4 X 6.0	49
-	-	1		2119652-1 FEED CAM, PRE FEED	48
-	1	1		1803602-2 SCR, BHSC, RoHS (M8 X 40)	41
-	1	1		2280562-1 TERMINAL SUPPORT	34
-	2	2		2079383-5 SCR, BHSC, RoHS (M4 X 20)	33
-	2	2		3-2844962-2 SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1		2844992-1 ASSEMBLY, STRIP GUIDE	29
-	1	1		2119797-1 SPACER, CRIMPER, SPECIAL	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		2119533-3 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		1633926-7 ANVIL, COMBINATION	8
-	-	-		-	7
-	-	-		-	6
-	1	1		2119349-2 SHEAR DEPRESSOR, STAB. CRIMP ADJ.	5
-	1	1		2-238011-9 BLOCK, CRIMPER SPACER	4
-	1	1		2119794-1 CRIMPER, INSUL F PREM, SPECIAL	3
-	1	1		2119797-2 SPACER, CRIMPER, SPECIAL	2
-	1	1		456411-7 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)

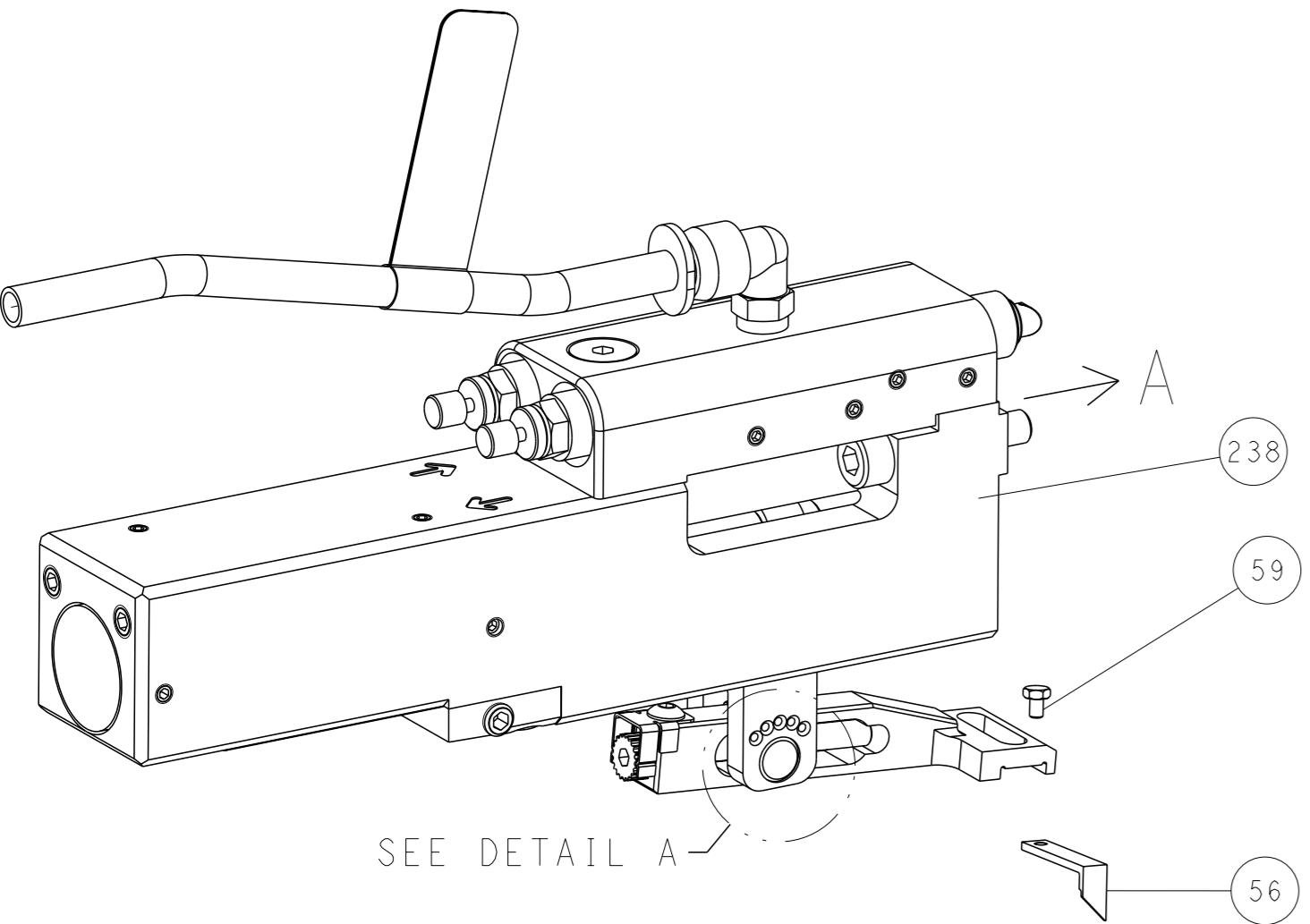
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DRAWING NO	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±
	ANGLES	FINISH			
MATERIAL		WEIGHT		SCALE	
				1:2	
Customer Accessible Production Drawing		SHEET 3 of 4		REV D	

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

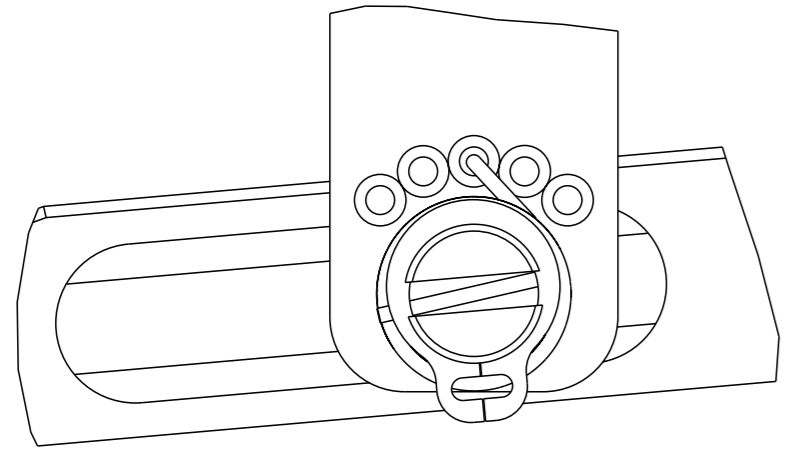
FEED TYPE MECHANICAL



PNEUMATIC

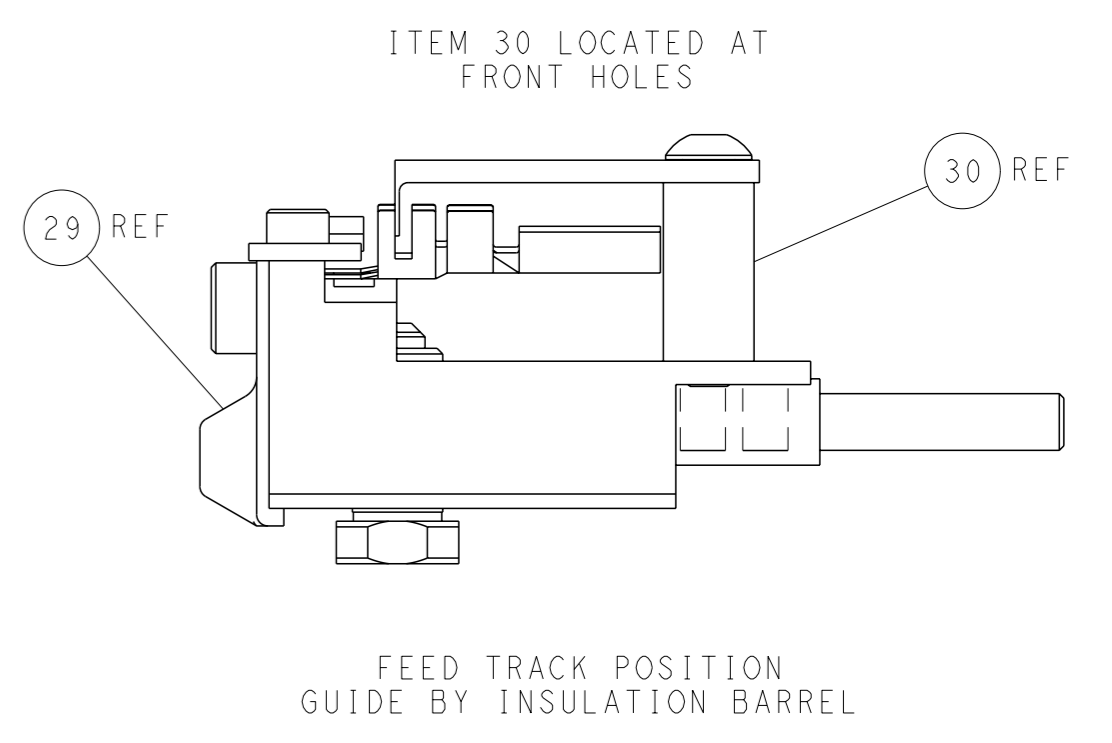
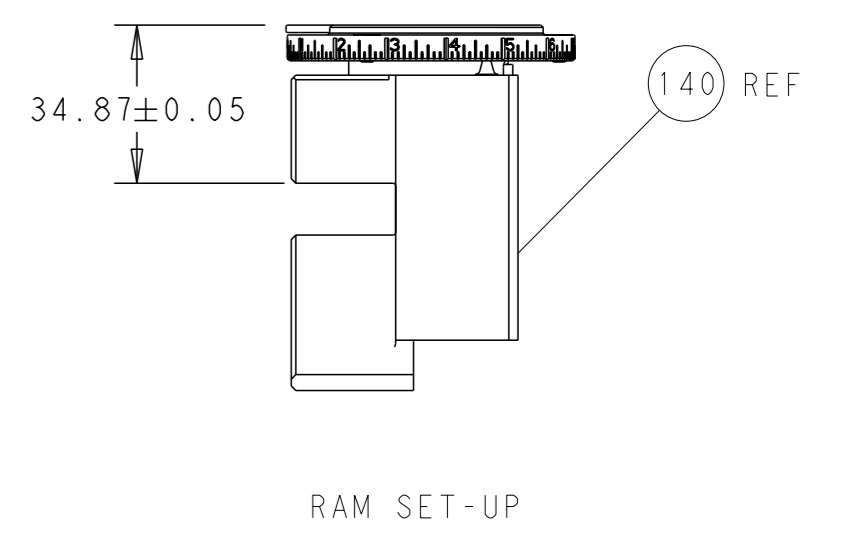
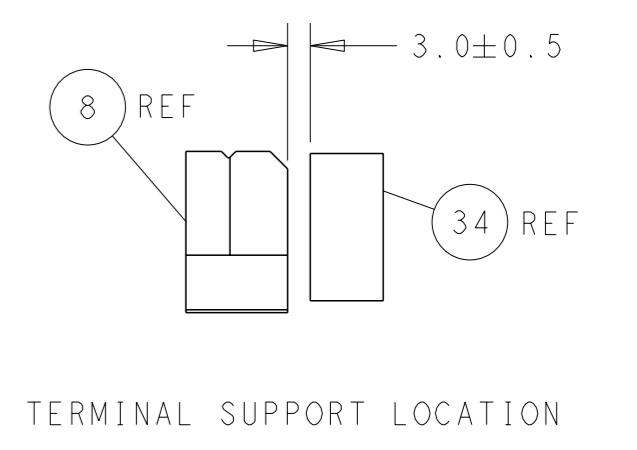
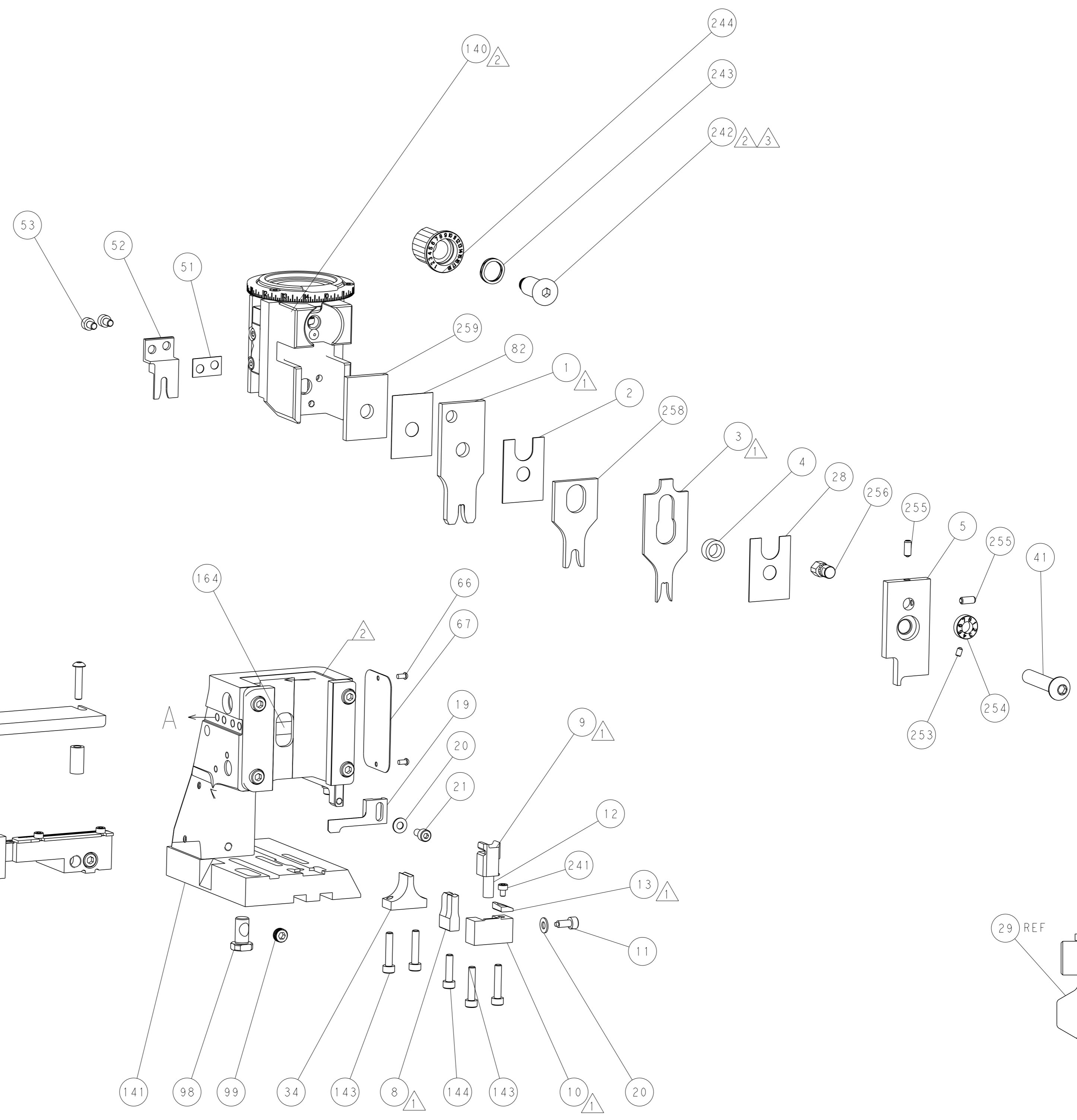
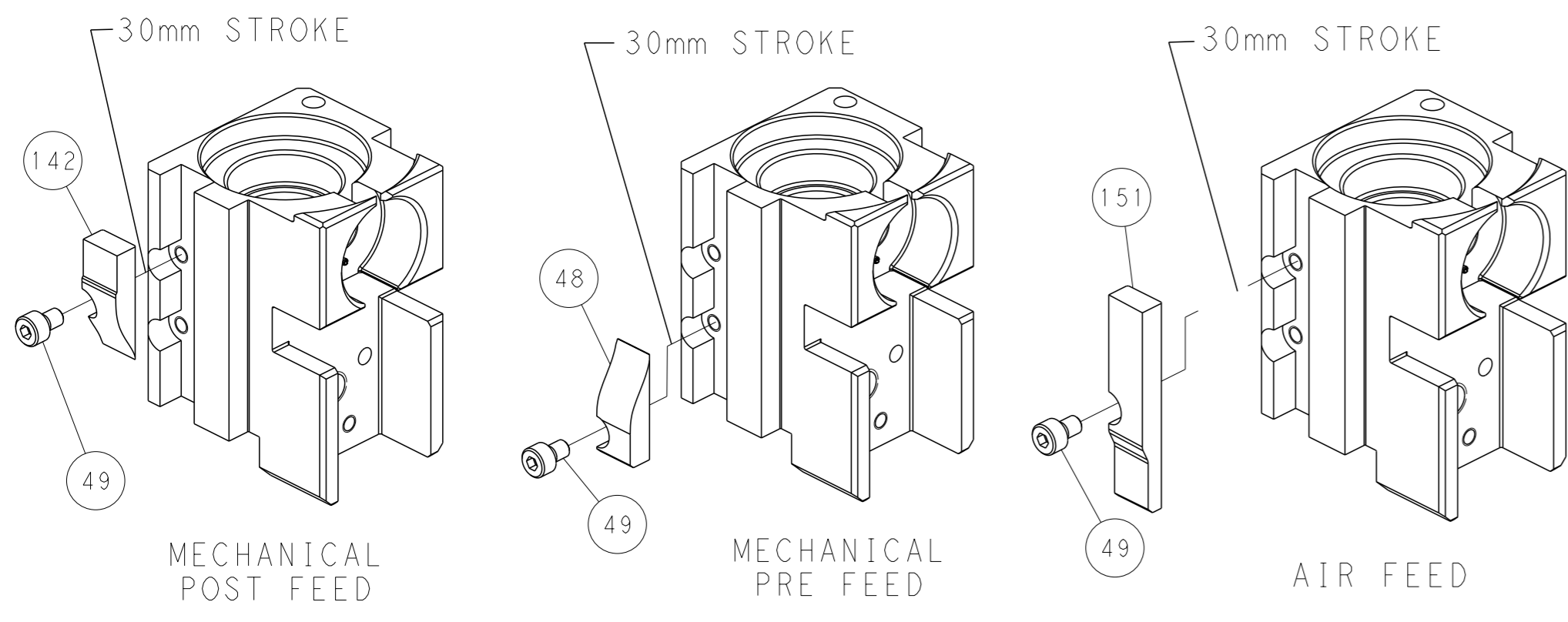


FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



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)

<small>THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION 20. IT IS SUBJECT TO CHANGE AND THE USER'S RESPONSIBILITY TO OBTAIN THE LATEST REVISION SHOULD BE CONTACTED FOR THE LATEST REVISION.</small>		OWN: K. STAKEM CHK: G. BAILEY APVD: J. ELBIN PRODUCT SPEC:	23SEPT2014 23SEPT2014 23SEPT2014	TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH ±		NAME: Ocean Side Feed Applicator APPLICATION SPEC:	SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2151321	RESTRICTED TO:
MATERIAL:		WEIGHT:	SCALE: 1:2 SHEET: 4 of 4 REV: D	Customer Accessible Production Drawing