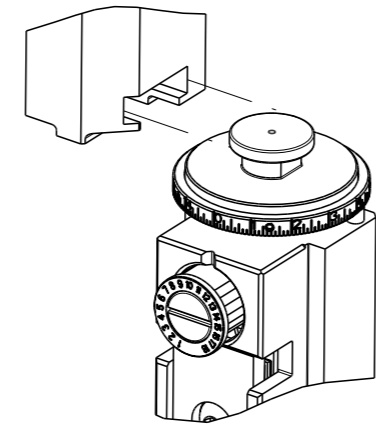


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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151372-1	L	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2151372-2	L	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
5-2151372-1	L	SEAL STRIPPER CRIMPER TERMINATING UNIT	MECHANICAL
5-2151372-2	L	SEAL STRIPPER CRIMPER TERMINATING UNIT	PNEUMATIC
7-2151372-1	L	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2151372-2	L	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2151372-7	L	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.78 mm [.070]	F
INSUL	3.30 mm [.130]	O

APPLICATOR INSTRUCTIONS 408-35042

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: MINI UNIVERSAL MATE-N-LOK PIN & SOCKET			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
3.20-3.70 mm [.126-.146 IN]	(A)1114-16017	Ø2.00-3.20 mm [.079-.126 IN]	-
TERMINAL APPLICATION SPECIFICATION	(B)114-1111	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
(A) 794407-1	(A) 794407-6	(A) 794406-3	(B) 1-794222-0
(A) 794407-2	(A) 1-794407-0	(A) 1-794406-0	(B) 794223-1
(A) 794407-3	(A) 1-794407-1	(B) 794222-1	(B) 794223-2
(A) 794407-4	(A) 794406-1	(B) 794222-2	(B) 794223-3
(A) 794407-5	(A) 794406-2	(B) 794222-3	(B) 1-794223-0

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
2 X 20 AWG	1.30+/-0.05 [.051+/-0.002]	3.8
16 AWG	1.30+/-0.05 [.051+/-0.002]	4.2
1.00mm <sup>2</sup>	1.27+/-0.05 [.050+/-0.002]	4.5
18 AWG	1.21+/-0.05 [.048+/-0.002]	4.7
20 AWG	1.07+/-0.05 [.042+/-0.002]	6.5

- 
- 1. RECOMMENDED SPARE PARTS
  - 2. REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION & STORAGE OF APPLICATOR.
  - 3. APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 180. 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			
		REV	DATE	BY	CHKD
A	66	J	14JUN2019	TB	TE
		K	07JUL2020	JAH	TE
		K1	16NOV2020	JWC	GB
		L	08JUN2021	FJ	RR

-	-	-	1	1	-	-	1803515-3	RAM ASSEMBLY, SF ATLANTIC	293
-	-	-	1	1	-	-	2-1803583-1	APPLICATOR BASIC ASSEMBLY, SF	292
-	1	-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248
-	1	1	1	1	1	1	2119082-8	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	-	-	1-1752354-6	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	1-18028-2	WASHER, FLAT, REG M4	119
-	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	1803607-3	DOCUMENTATION PACKAGE	71
-	1	1	1	1	1	1	2119791-5	DEPRESSOR, WIRE	70
-	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	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	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	53
-	1	1	1	1	1	1	1803382-1	HOLD DOWN, SPRING LOADED	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	2-1752356-0	SUPPORT, TERMINAL	34
-	2	2	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	2	2	2	2	2-2844962-8	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	1	1	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29
-	1	1	1	1	1	1	1-455888-0	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	1-356885-5	STOP, SHEAR	11
-	1	1	1	1	1	1	2119805-1	SHEAR HOLDER, FRONT	10
-	1	1	1	1	1	1	1803095-3	FLOATING SHEAR, FRONT	9
1	2	2	1	1	1	1	6-1333203-2	ANVIL, COMBINATION	8
-	1	1	1	1	1	1	3-240641-8	SPACER	7
-	-	-	-	-	-	-	-	-	6
-	1	1	1	1	1	1	2119757-8	DEPRESSOR, SHEAR	5
-	1	1	1	1	1	1	238011-2	BLOCK, CRIMPER SPACER	4
1	2	2	1	1	1	1	2-1803464-9	CRIMPER, INSULATION O	3
-	1	1	1	1	1	1	455888-3	SPACER, CRIMPER	2
1	2	2	1	1	1	1	2-456404-5	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)

ITEM NO	PART NO	DESCRIPTION
-77	-72	-52
-51	-2	-1

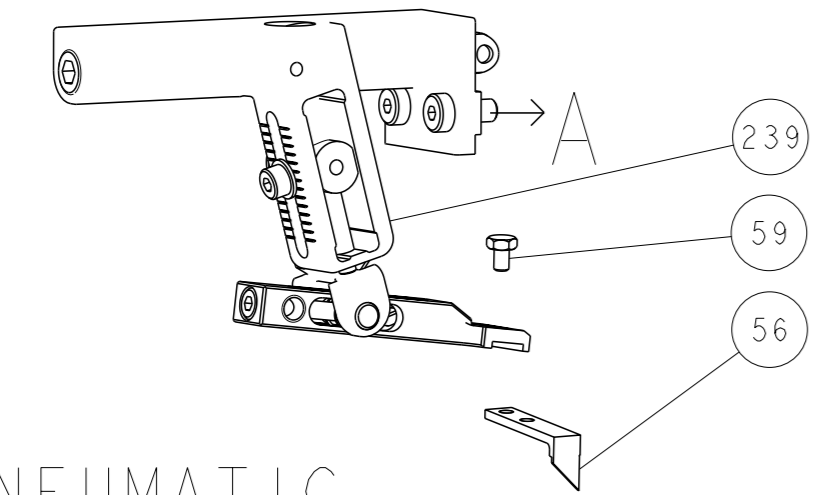
OWN	X. ZHAO	16NOV2011
CHK	L. ZHANG	16NOV2011
APP'D	S. XI	16NOV2011

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

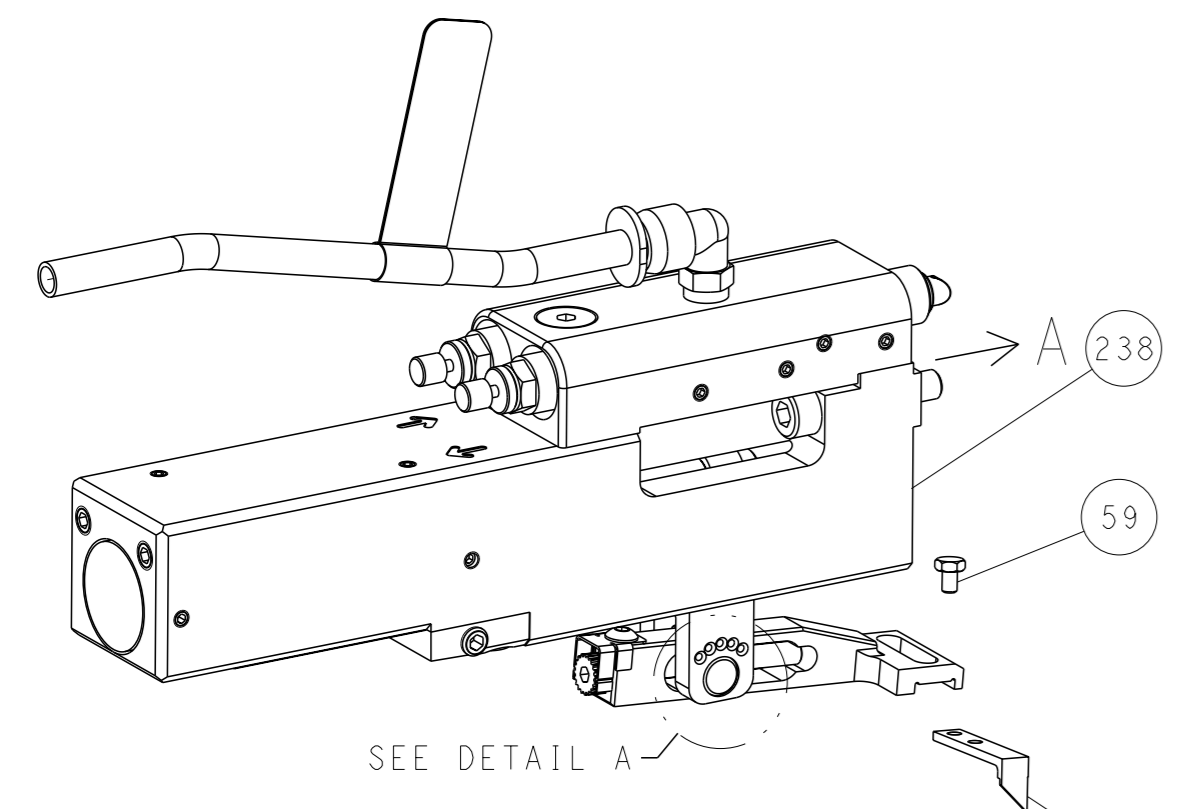
NAME	Ocean Side Feed Applicator
SIZE	A1
CAGE CODE	00779
DRAWING NO	2151372
RESTRICTED TO	NO
CUSTOMER ACCESSIBLE PRODUCTION DRAWING	SCALE 1:2
SHEET	1 of 4
REV	L

LOC	DIST	REVISIONS			
A	66	REV	DATE	OWN	APVD
-	-	SEE SHEET 1	-	-	-

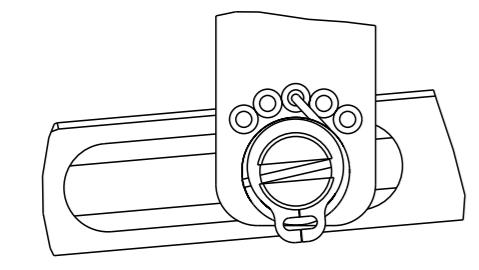
# FEED TYPE MECHANICAL



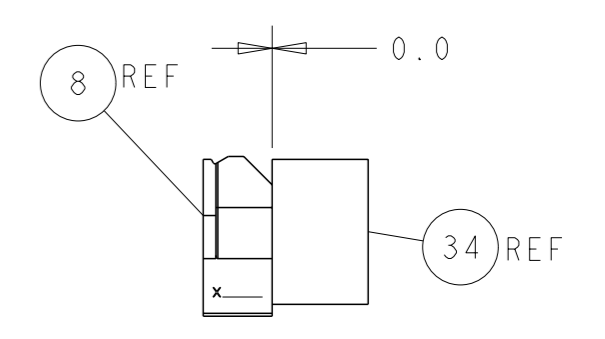
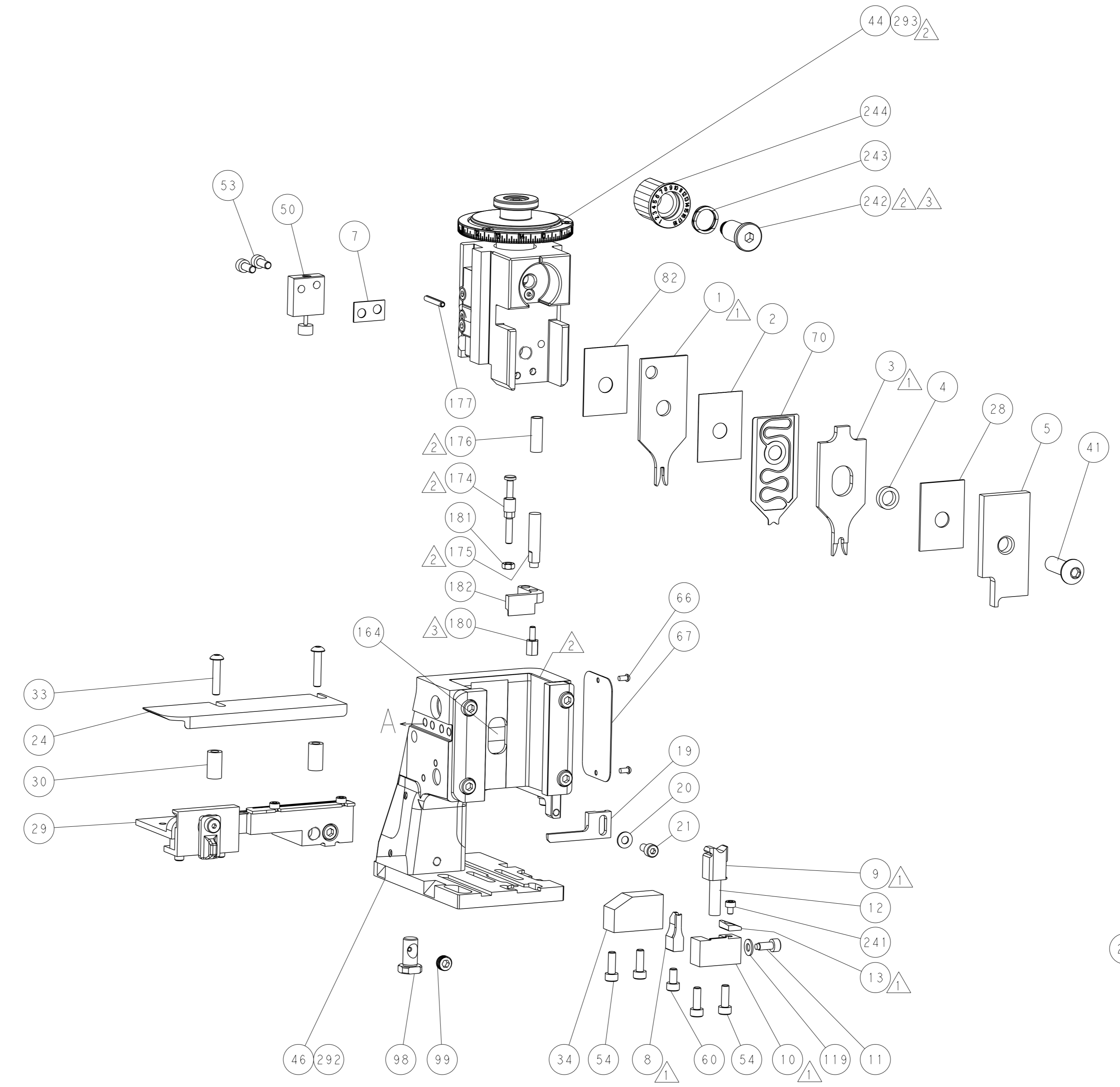
## PNEUMATIC



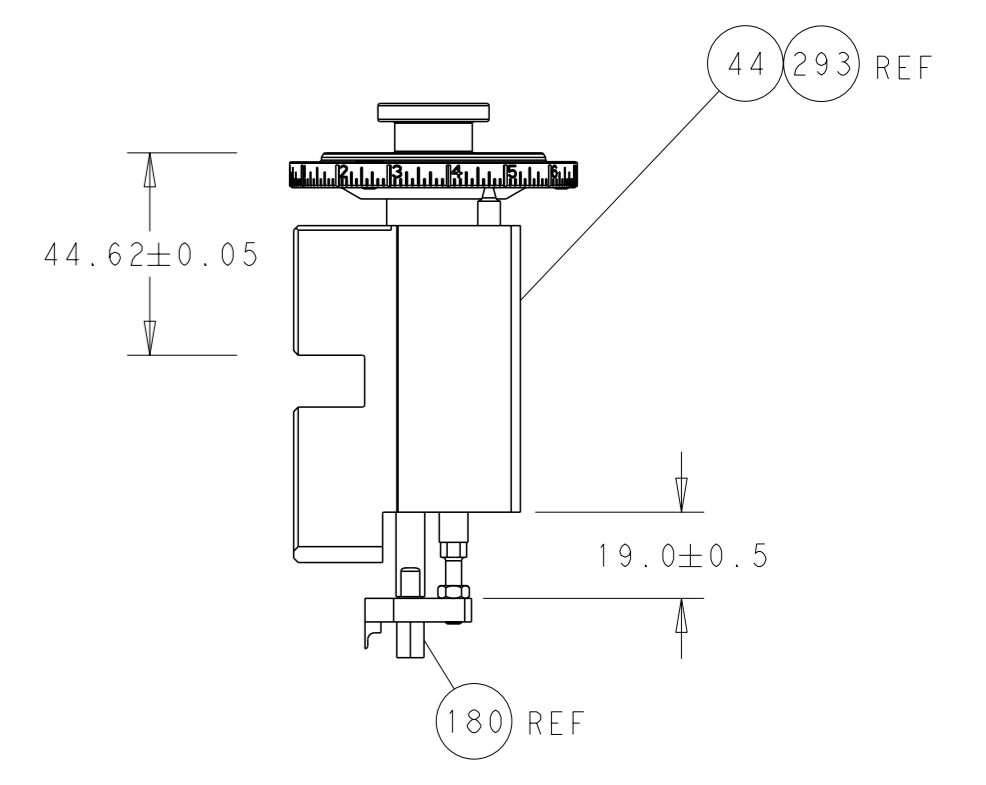
FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



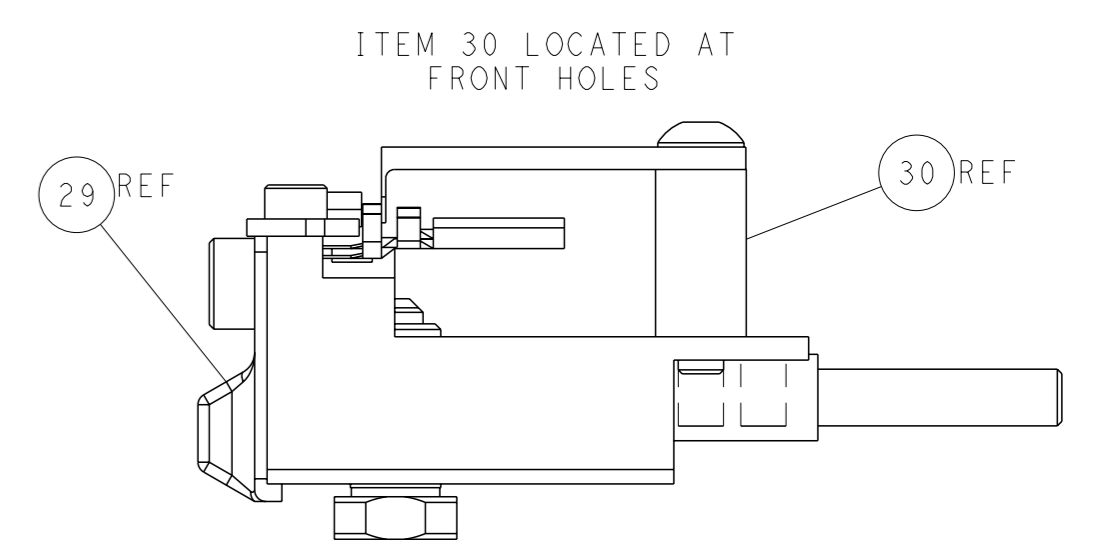
DETAIL A



TERMINAL SUPPORT LOCATION

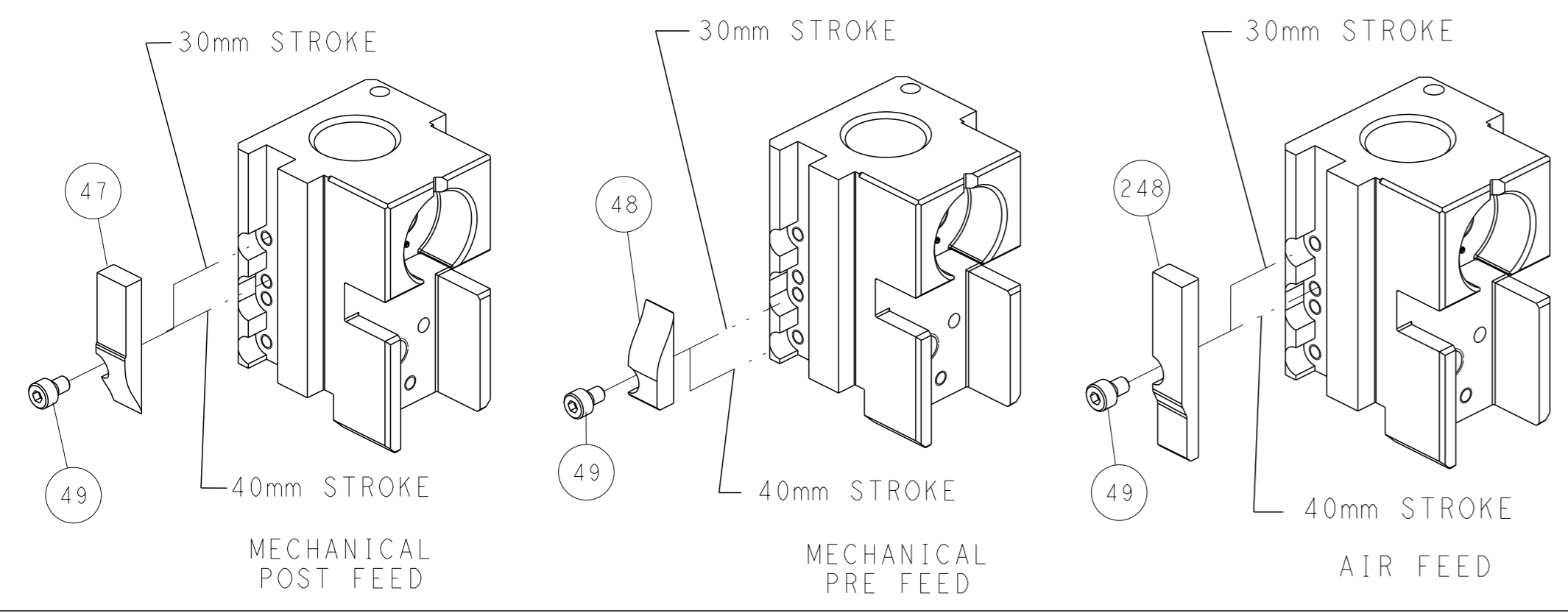


RAM SET-UP



FEED TRACK POSITION GUIDE BY INSULATION BARREL

# CAM POSITIONS

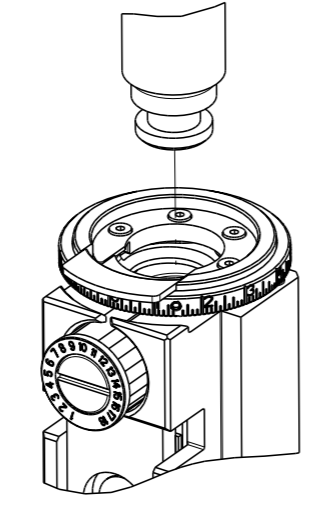


**ATLANTIC VERSION**  
 Shown on sheets 1 of 4 & 2 of 4  
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH ±		OWN: X_ZHAO 16NOV2011 CHK: L_ZHANG 16NOV2011 APVD: S_XI 16NOV2011 PRODUCT SPEC APPLICATION SPEC WEIGHT: - MATERIAL: -	NAME: Ocean Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2151372 SCALE: 1:2 SHEET: 2 of 4 REV: L	TE Connectivity Harrisburg, PA 17105-3608
--	--	---	--	--

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2151372-1	L	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2151372-2	L	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151372-7	L	CRIMP TOOLING KIT	-

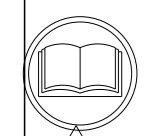
PACIFIC VERSION TERMINATOR  
 INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.78 mm [.070]	F
INSUL	3.30 mm [.130]	O
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: MINI UNIVERSAL MATE-N-LOK PIN & SOCKET			
WIRE STRIP LENGTH 3.20-3.70 mm [.126-.146 IN]		INSULATION DIAMETER RANGE Ø2.00-3.20 mm [.079-.126 IN]	
TERMINAL APPLICATION SPECIFICATION (A)114-16017 (B)114-1111	-	-	-
TERMINALS APPLIED			
TE TERMINAL (A) 794407-1 (A) 794407-2 (A) 794407-3 (A) 794407-4 (A) 794407-5	TE TERMINAL (A) 794407-6 (A) 1-794407-0 (A) 1-794407-1 (A) 794406-1 (A) 794406-2	TE TERMINAL (A) 794406-3 (A) 1-794406-0 (B) 794222-1 (B) 794222-2 (B) 794222-3	TE TERMINAL (B) 1-794222-0 (B) 794223-1 (B) 794223-2 (B) 794223-3 (B) 1-794223-0

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
2 X 20 AWG	1.30 +/- 0.05 [.051 +/- .002]	3.8
16 AWG	1.30 +/- 0.05 [.051 +/- .002]	4.2
1.00mm <sup>2</sup>	1.27 +/- 0.05 [.050 +/- .002]	4.5
18 AWG	1.21 +/- 0.05 [.048 +/- .002]	4.7
20 AWG	1.07 +/- 0.05 [.042 +/- .002]	6.5



- RECOMMENDED SPARE PARTS**
- REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION & 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.

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

-	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
-	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	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	2119791-5	DEPRESSOR, WIRE	70
-	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	1803382-1	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	2-1752356-0	SUPPORT, TERMINAL	34
-	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	2-2844962-8	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
-	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	1-356885-5	STOP, SHEAR	11
-	1	1	2119805-1	SHEAR HOLDER, FRONT	10
-	1	1	1803095-3	FLOATING SHEAR, FRONT	9
-	1	1	6-1333203-2	ANVIL, COMBINATION	8
-	1	1	3-240641-8	SPACER	7
-	-	-	-	-	6
-	1	1	2119757-8	DEPRESSOR, SHEAR	5
-	1	1	238011-2	BLOCK, CRIMPER SPACER	4
-	1	1	2-1803464-9	CRIMPER, INSULATION O	3
-	1	1	455888-3	SPACER, CRIMPER	2
-	1	1	2-456404-5	CRIMPER, WIRE PREMIUM	1
-	77	-22	-21	PART NO	ITEM NO

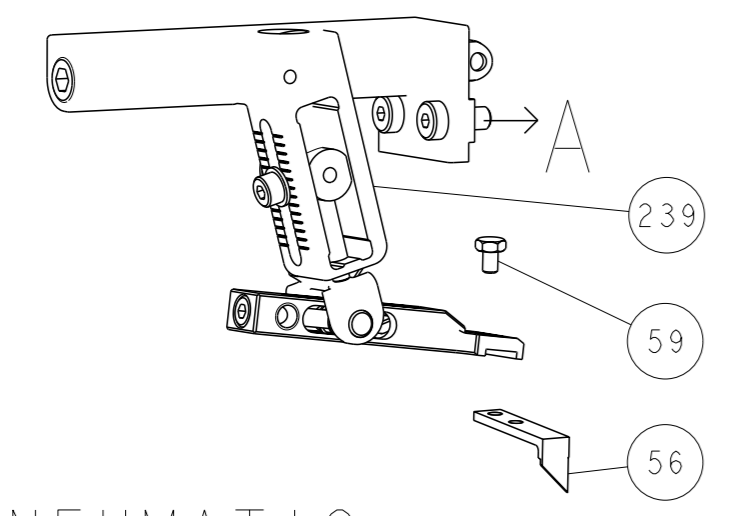
PACIFIC VERSION  
 Shown on sheets 3 of 4 & 4 of 4  
 (Atlantic version shown on sheets 1 of 4 & 2 of 4)

DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG X.ZHAO 16NOV2011		CHK L.ZHANG 16NOV2011		APVD S.XI 16NOV2011		NAME	
0 PLC	±	1 PLC	±	Ocean Side Feed							
2 PLC	±	3 PLC	±	Applicator							
4 PLC	±	FINISH		SIZE		CAGE CODE		DRAWING NO		RESTRICTED TO	
MATERIAL		FINISH		WEIGHT		SCALE		SHEET		REV	
						1:2		3 OF 4		L	

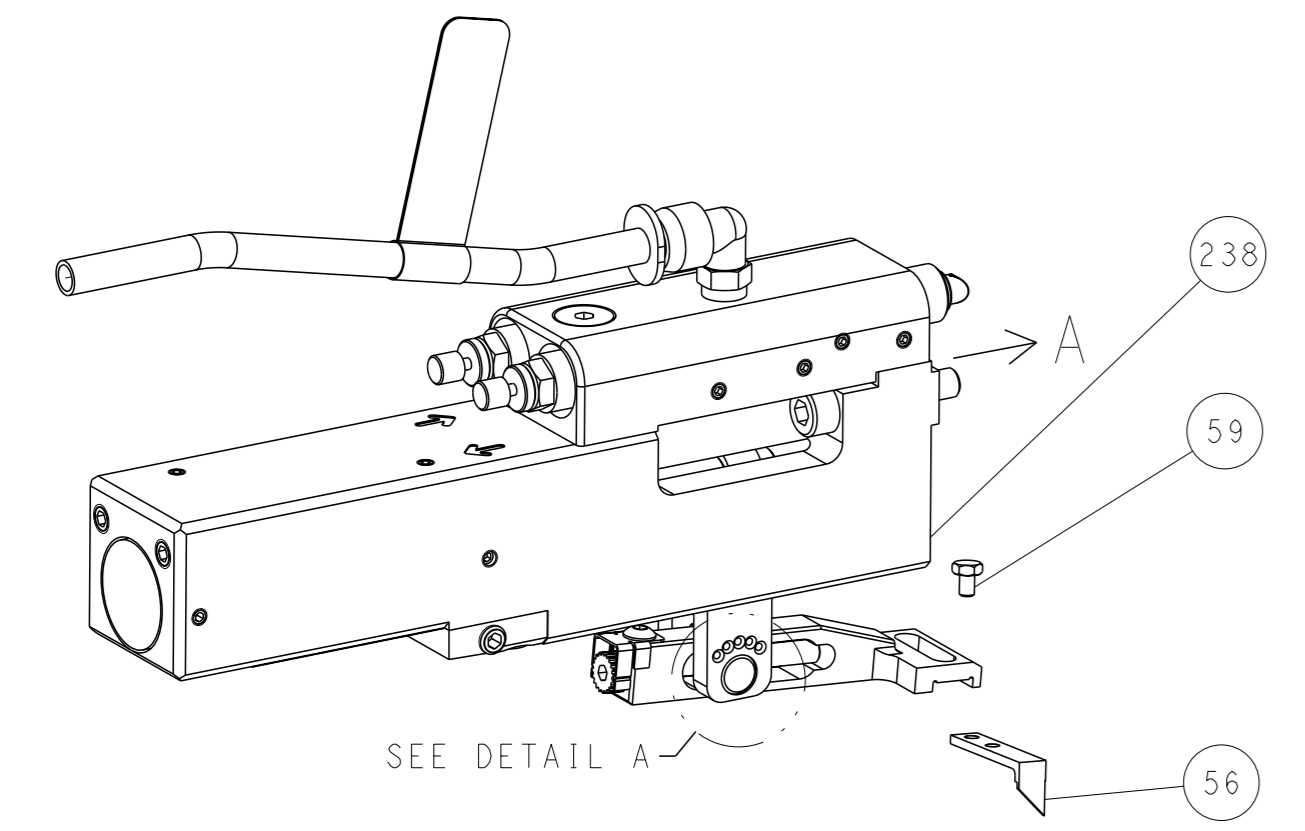
CUSTOMER ACCESSIBLE PRODUCTION DRAWING

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

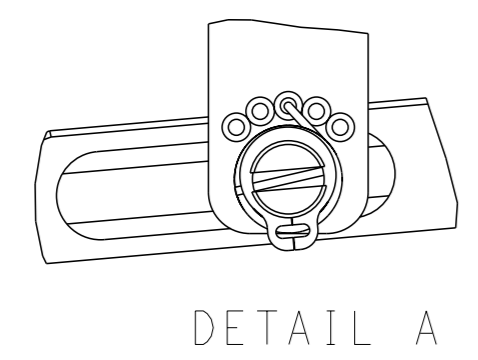
# FEED TYPE MECHANICAL



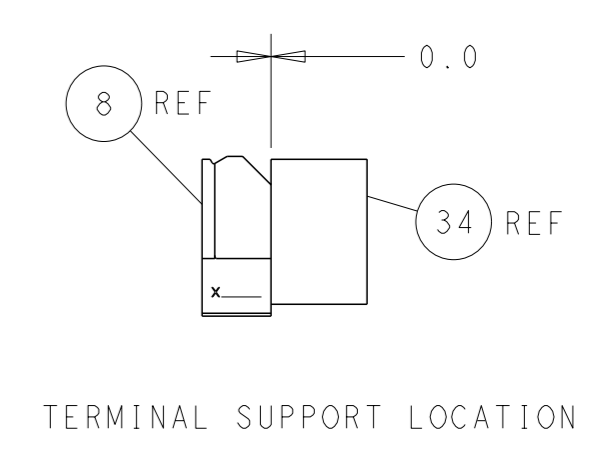
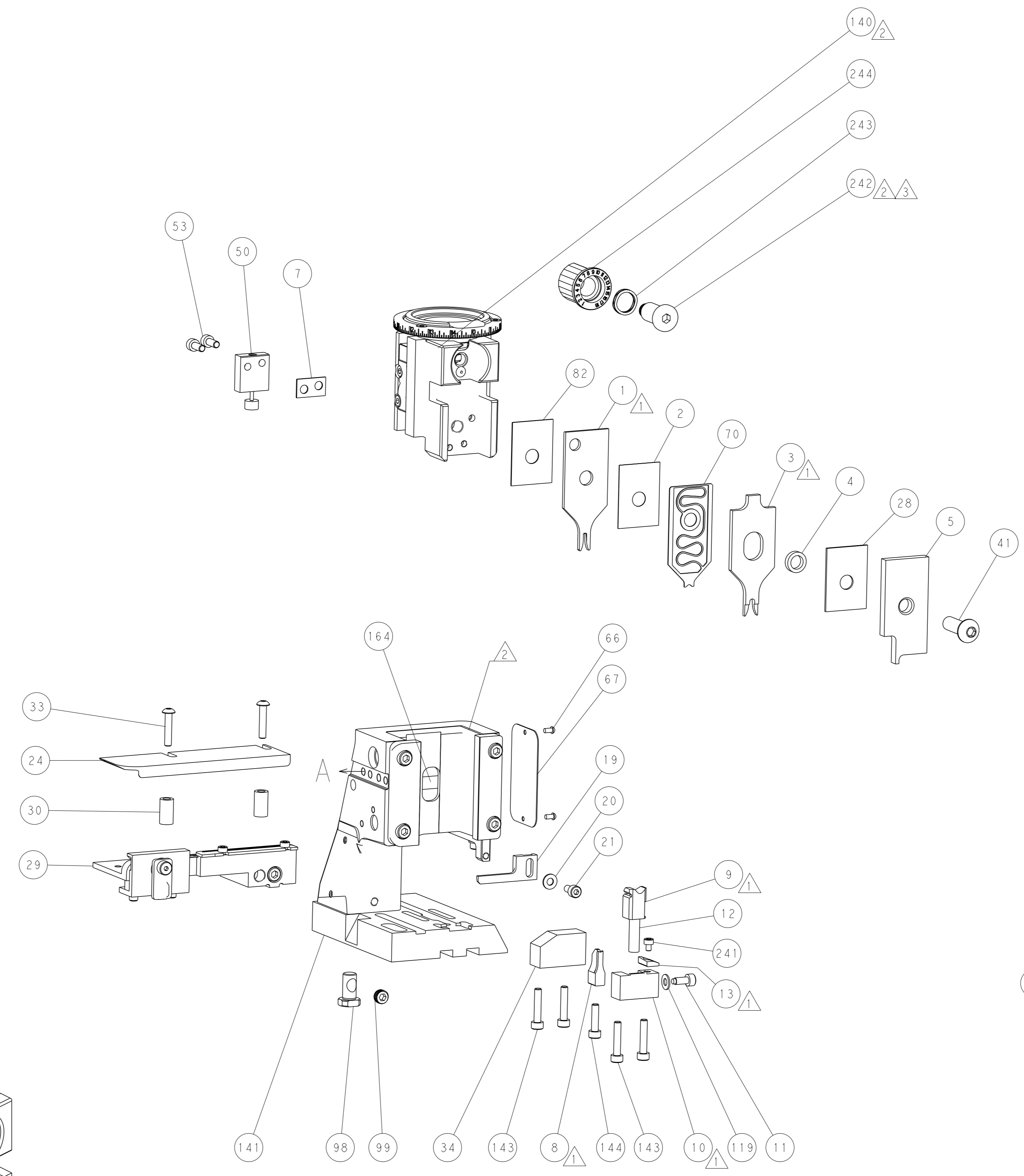
# PNEUMATIC



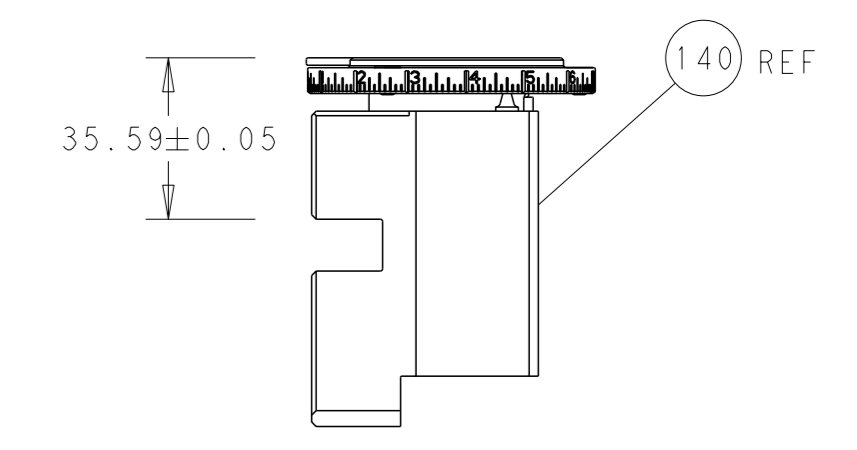
FEED SPRING SETTING POSITION  
(SHOWN FROM REAR SIDE)



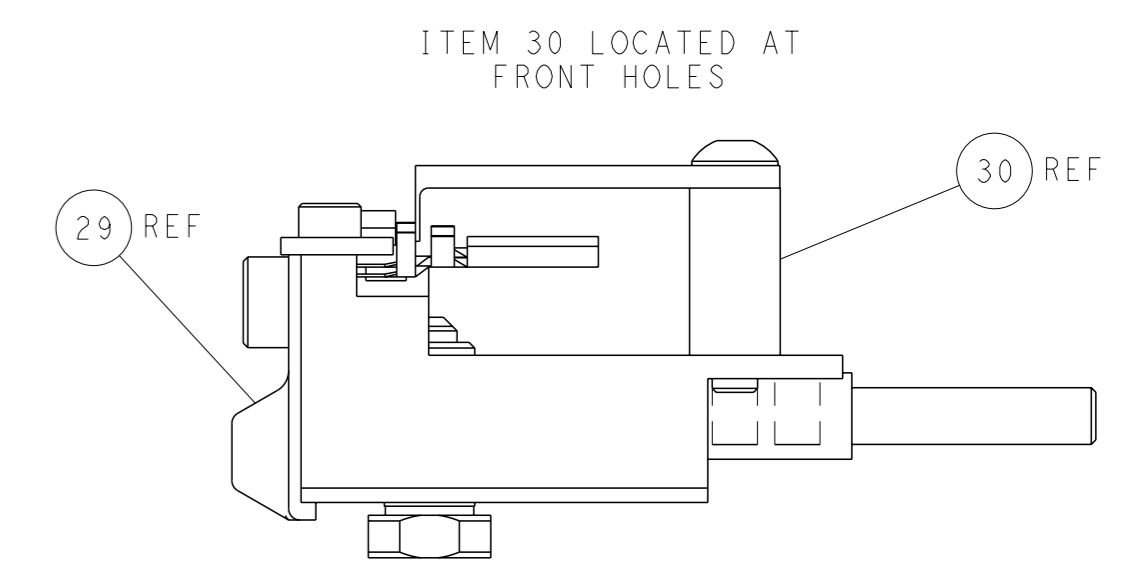
DETAIL A



TERMINAL SUPPORT LOCATION

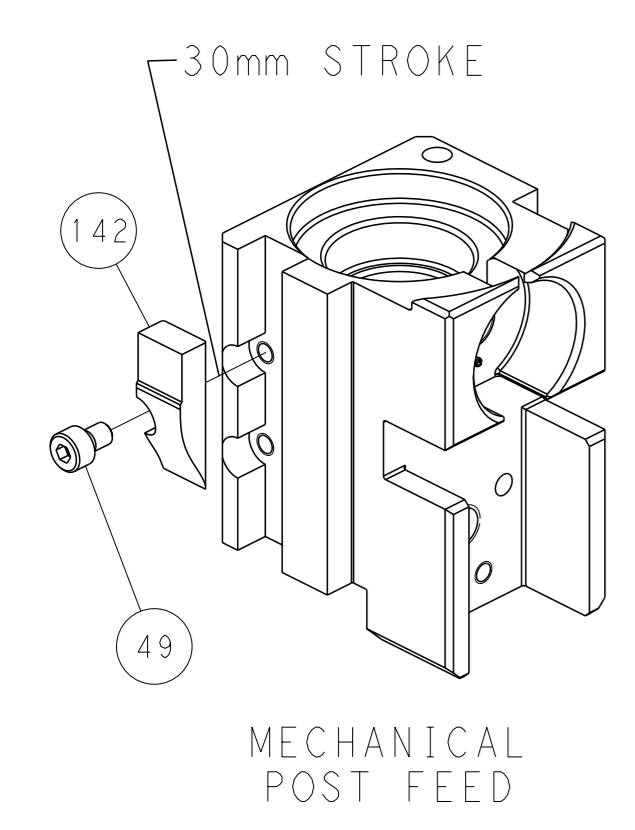


RAM SET-UP

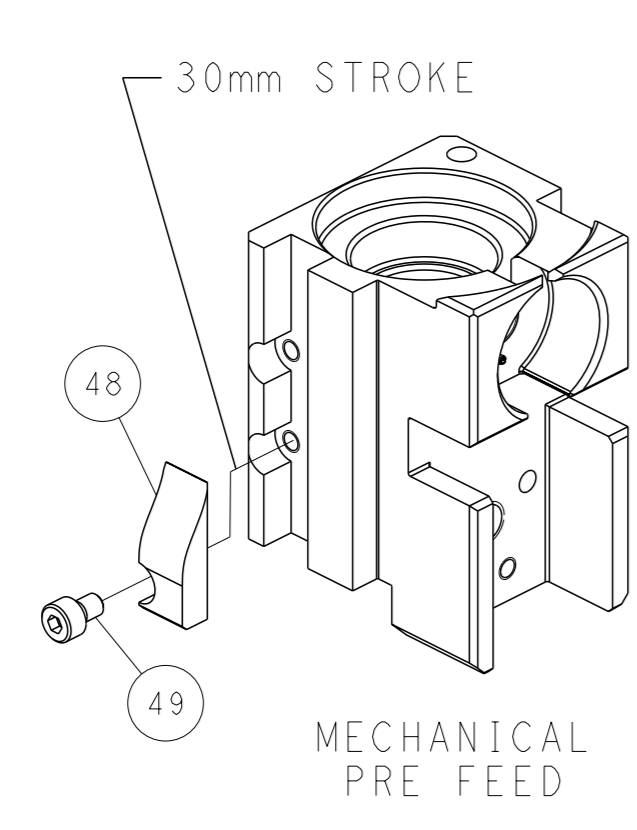


FEED TRACK POSITION  
GUIDE BY INSULATION BARREL

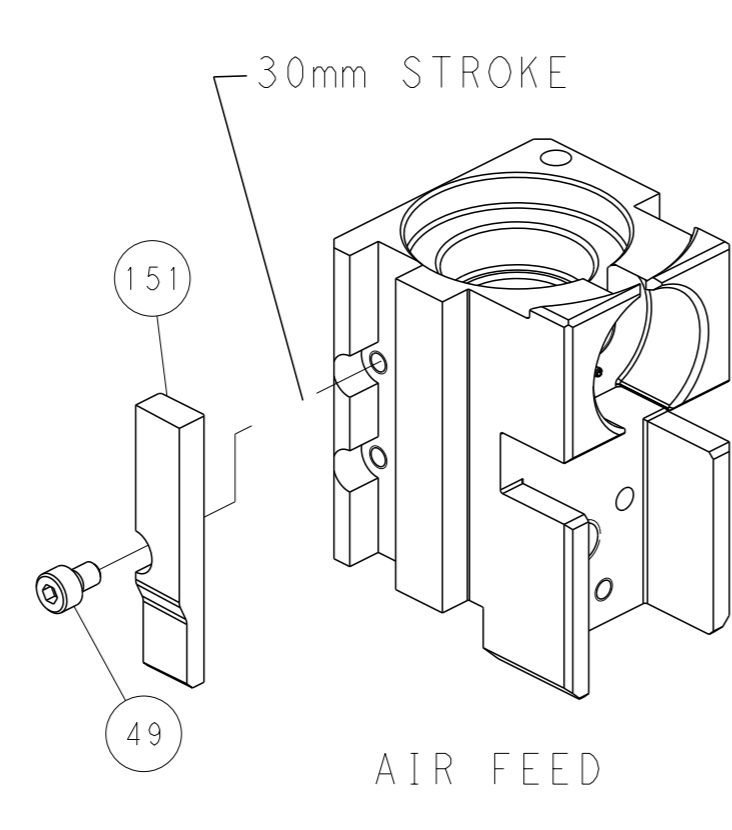
# CAM POSITIONS



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)

<small>THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE AND THE USER MUST CONTACT THE ENGINEERING ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST REVISION.</small>		OWN: X. ZHAO 16NOV2011 CHK: L. ZHANG 16NOV2011 APVD: S. XI 16NOV2011	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: 2151372	RESTRICTED TO: - SCALE: 1:2 SHEET: 4 of 4 REV: L
MATERIAL: - FINISH: -		WEIGHT: - CUSTOMER ACCESSIBLE PRODUCTION DRAWING	SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION