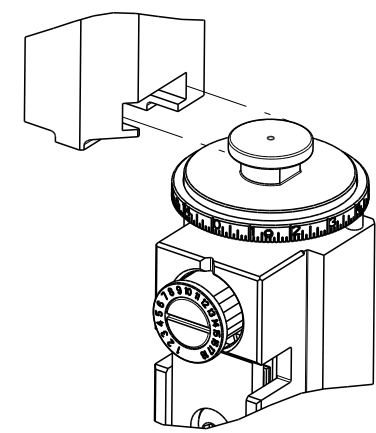


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151239-1	G	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2151239-2	H	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151239-1	G	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2151239-2	H	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2151239-7	E	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.54 mm [.100]	F
INSUL	-	-

APPLICATOR INSTRUCTIONS 408-35042

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: PIN AND SOCKET CONTACT WIRE/WIRE			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
5.0-5.2mm [.195-.205 IN]		Ø 1.96-3.94mm [.077-.155 IN]	
TERMINAL APPLICATION SPECIFICATION	114-13045		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
776491-1	776491-2	638112-1	638112-2
638112-3			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
14 AWG	1.65 +/- 0.05 [0.065 +/- .002]	5.1
1.5mm ²	1.52 +/- 0.05 [0.060 +/- .002]	6.4
16 AWG	1.52 +/- 0.05 [0.060 +/- .002]	6.4
1.0mm ²	1.39 +/- 0.05 [0.055 +/- .002]	7.8
18 AWG	1.39 +/- 0.05 [0.055 +/- .002]	7.8

- RECOMMENDED SPARE PARTS
- REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- 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.
- 4. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- TERMINAL LUBRICANT IS RECOMMENDED.

***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	OWN	APVD
		E1		ECR-18-004561	27MAR2018	FL	JD
		F		ECR-18-006398	26APR2018	FL	JD
		G		ECR-18-016618	19OCT2018	TB	CT
		H		ECR-22-131804	08MAR2022	ROY	JAH

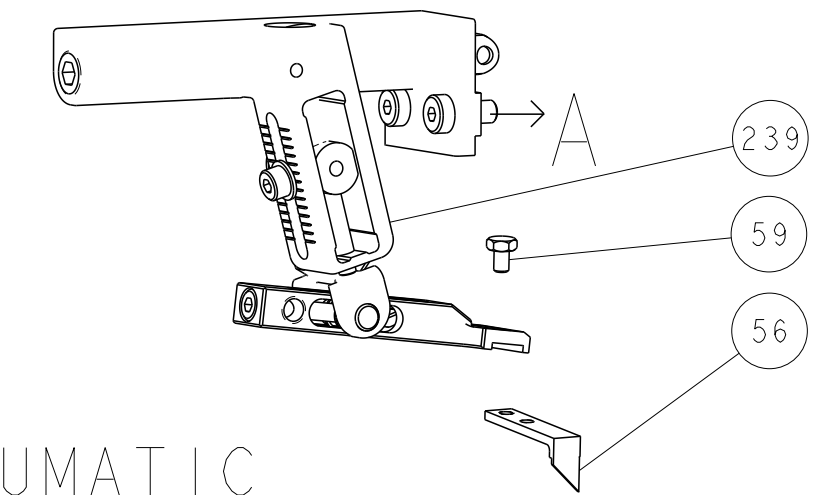
-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248
-	1	1	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
-	-	1	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	1	-	1	-	2844940-1	AIR FEED MODULE	238
-	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	1	1	1	1	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113
-	1	1	1	1	2844908-1	SCREW, LOCKING	99
-	1	1	1	1	2844907-1	POST, LOCKING	98
-	1	1	1	1	455888-4	SPACER, CRIMPER	82
-	1	1	1	1	5-547505-2	SPRING, COMPRESSION	77
-	1	1	1	1	854769-4	HOLDER, INS	74
-	1	1	1	1	1803607-3	DOCUMENTATION PACKAGE	71
-	1	1	1	1	2119791-5	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	21028-2	PIN, SLOTTED SPRING .062 X .250	58
-	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	3-1752356-3	SUPPORT, TERMINAL	34
-	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	2	2	2-2844962-8	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29
-	1	1	1	1	455888-3	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	2119806-2	INSERT, SHEAR	13
-	1	1	1	1	3-22280-3	SPRING, COMPRESSION	12
-	1	1	1	1	1-356885-5	STOP, SHEAR	11
-	1	1	1	1	2119805-4	SHEAR HOLDER, FRONT	10
-	1	1	1	1	3-454276-8	FLOATING SHEAR, FRONT	9
-	1	2	2	1	1-1803412-0	ANVIL, COMBINATION	8
-	1	1	1	1	2119780-9	DEPRESSOR, SHEAR	5
-	1	2	2	1	1803224-1	CRIMPER, WIRE	1

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

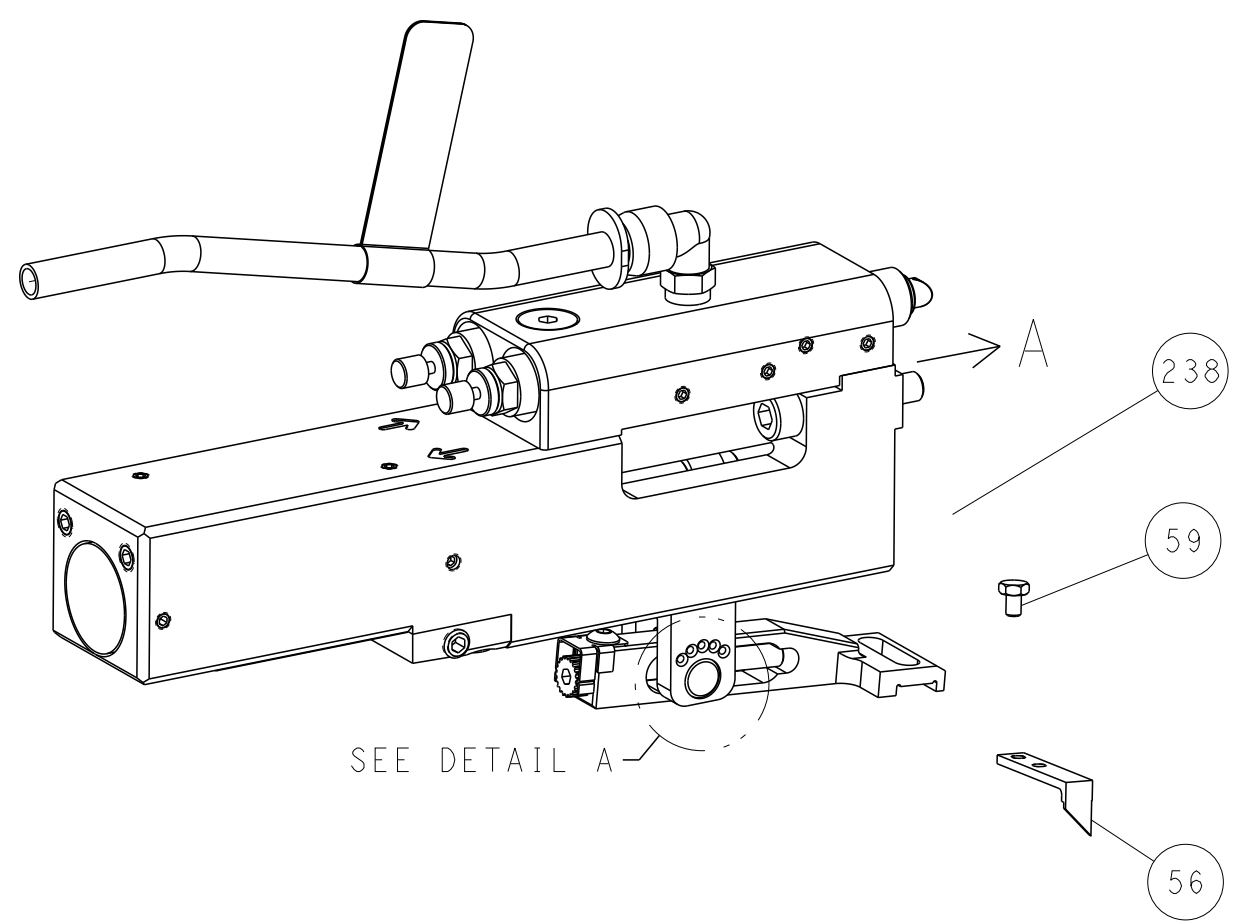
OWN	X.ZHAO	26MAY2011	
CHK	S.XI	26MAY2011	
APVD	J. CRUZ	26MAY2011	
PRODUCT SPEC			
APPLICATION SPEC			
SIZE	A1	00779	©=2151239
SCALE	1:2	SHEET	1 OF 4
REV	H		

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

FEED TYPE MECHANICAL



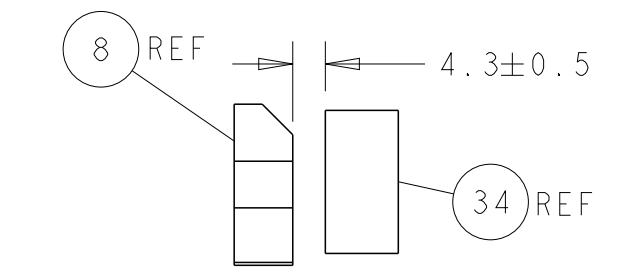
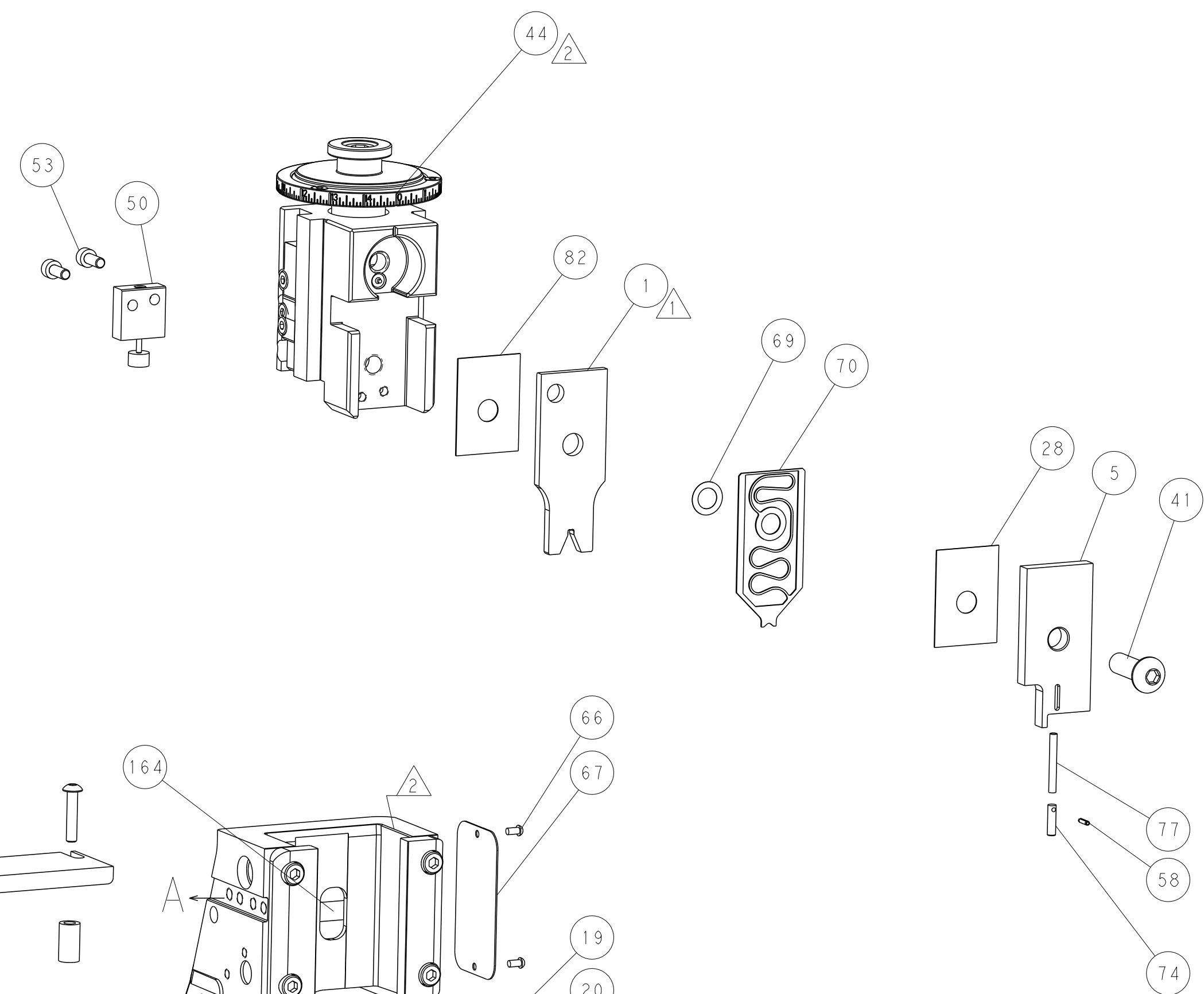
PNEUMATIC



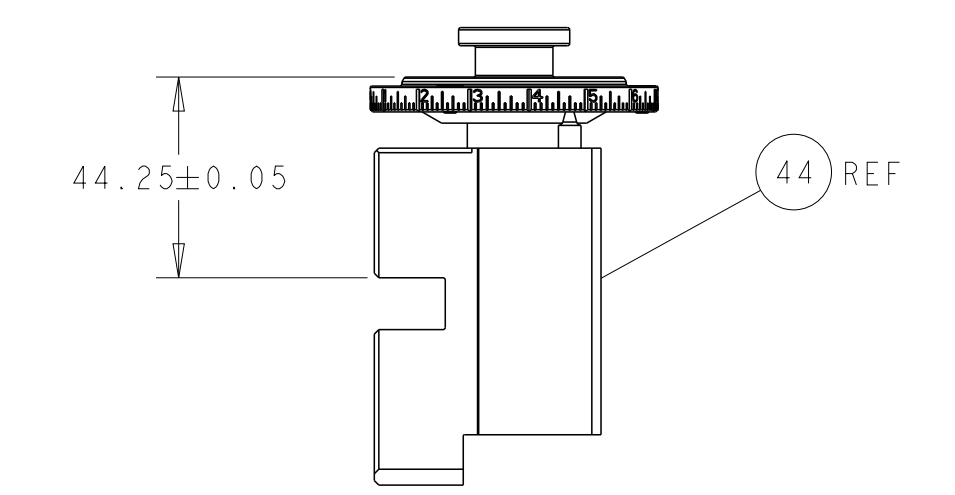
FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



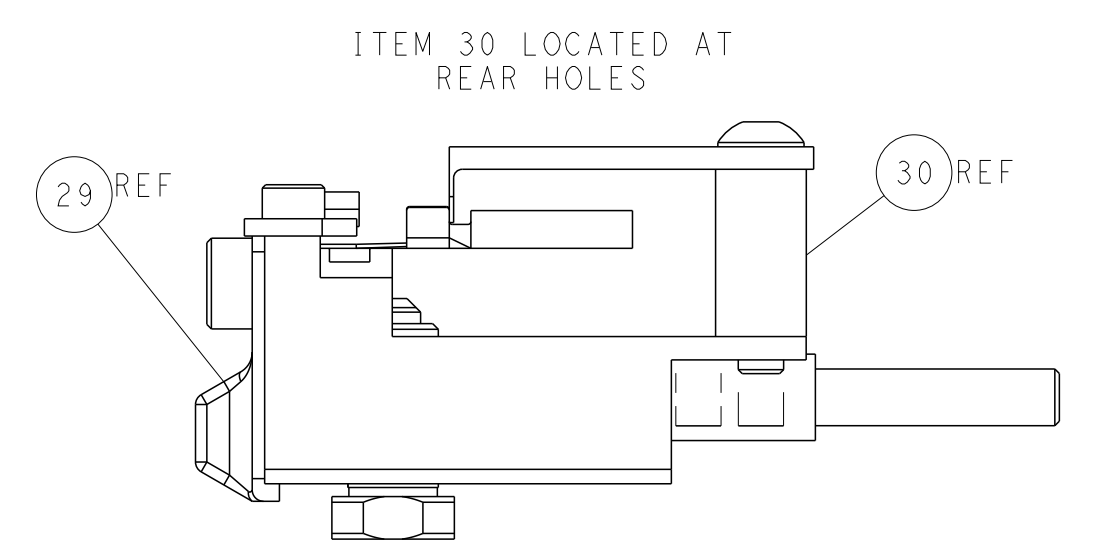
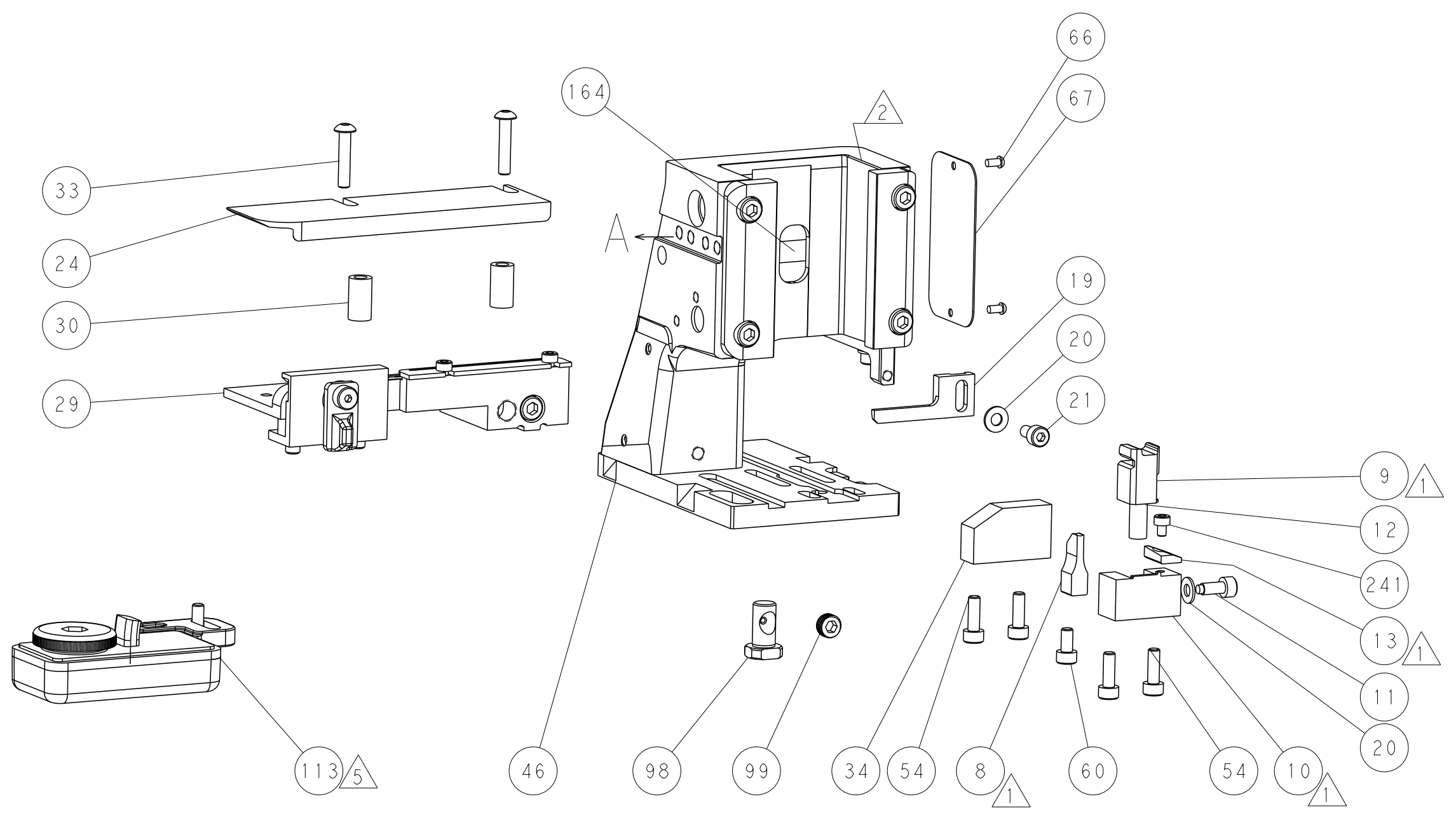
DETAIL A



TERMINAL SUPPORT LOCATION

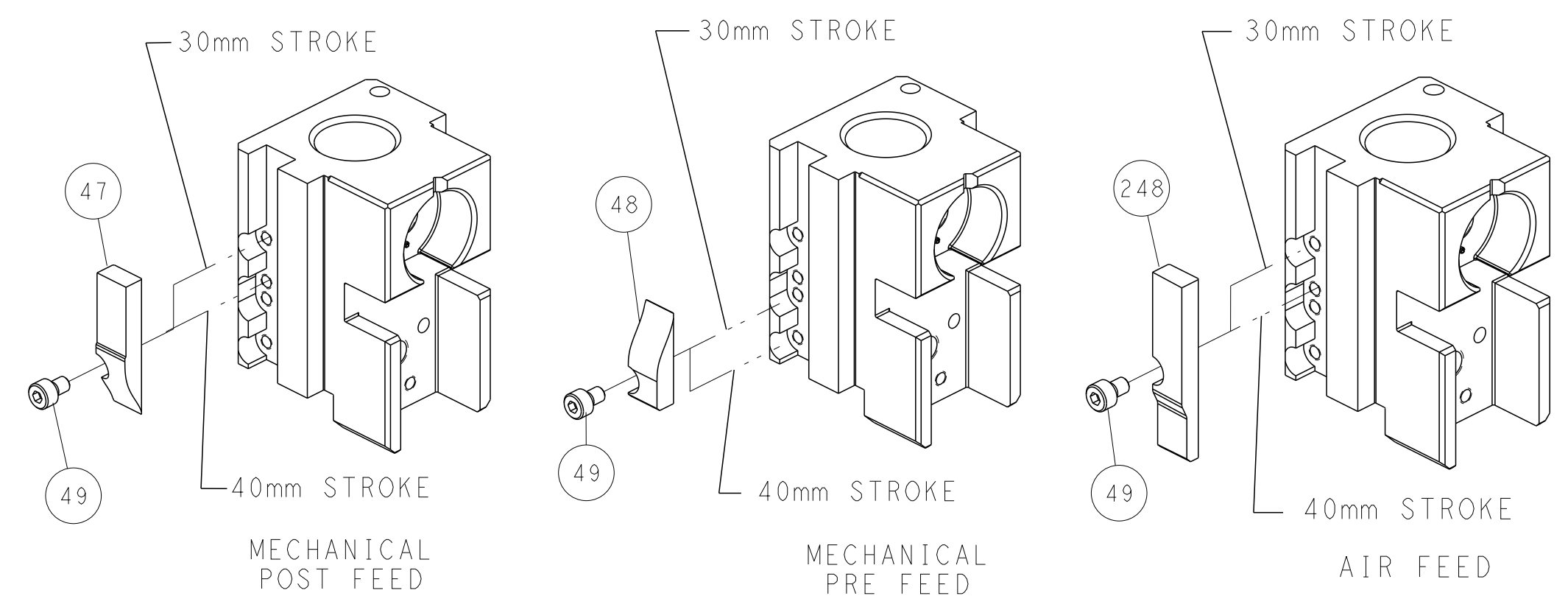


RAM SET-UP



FEED TRACK POSITION GUIDE BY WIRE 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)

<small>THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.</small>		DWN X.ZHAO 26MAY2011 CHK S.XI 26MAY2011 APVD J.CRUZ 26MAY2011	NAME Ocean Side Feed Applicator SIZE CAGE CODE DRAWING NO. A1 00779 C-2151239 RESTRICTED TO
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH ±	WEIGHT SCALE 1:2 SHEET 2 OF 4 REV H	TE Connectivity Harrisburg, PA 17105-3608	Customer Accessible Production Drawing

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COPYRIGHT 20 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.			
PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2151239-1	G	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2151239-2	H	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151239-7	E	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



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

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: PIN AND SOCKET CONTACT WIRE/WIRE			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
5.0-5.2mm [.195-.205 IN]		Ø 1.96-3.94mm [.077-.155 IN]	
TERMINAL APPLICATION SPECIFICATION	114-13045	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
776491-1	776491-2	638112-1	638112-2
638112-3			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
14 AWG	1.65 +/- 0.05 [0.065 +/- .002]	5.1
1.5mm ²	1.52 +/- 0.05 [0.060 +/- .002]	6.4
16 AWG	1.52 +/- 0.05 [0.060 +/- .002]	6.4
1.0mm ²	1.39 +/- 0.05 [0.055 +/- .002]	7.8
18 AWG	1.39 +/- 0.05 [0.055 +/- .002]	7.8

- RECOMMENDED SPARE PARTS
- REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- 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.
- 4. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- TERMINAL LUBRICANT IS RECOMMENDED.

***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)

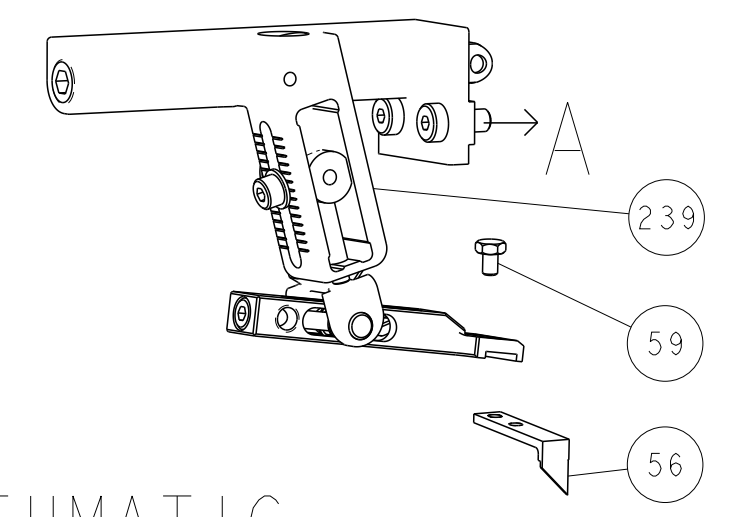
LOC	DIST	REVISIONS					
A	66	P	LTN	DESCRIPTION	DATE	DWN	APVD
		-		SEE SHEET 1	-	-	-

-	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	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113
-	1	1	2844908-1	SCREW, LOCKING	99
-	1	1	2844907-1	POST, LOCKING	98
-	1	1	455888-4	SPACER, CRIMPER	82
-	1	1	5-547505-2	SPRING, COMPRESSION	77
-	1	1	854769-4	HOLDER, INS	74
-	1	1	1803607-3	DOCUMENTATION PACKAGE	71
-	1	1	2119791-5	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	21028-2	PIN, SLOTTED SPRING .062 X .250	58
-	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	3-1752356-3	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	455888-3	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	2119806-2	INSERT, SHEAR	13
-	1	1	3-22280-3	SPRING, COMPRESSION	12
-	1	1	1-356885-5	STOP, SHEAR	11
-	1	1	2119805-4	SHEAR HOLDER, FRONT	10
-	1	1	3-454276-8	FLOATING SHEAR, FRONT	9
-	1	1	1-1803412-0	ANVIL, COMBINATION	8
-	1	1	2119780-9	DEPRESSOR, SHEAR	5
-	1	1	1803224-1	CRIMPER, WIRE	1

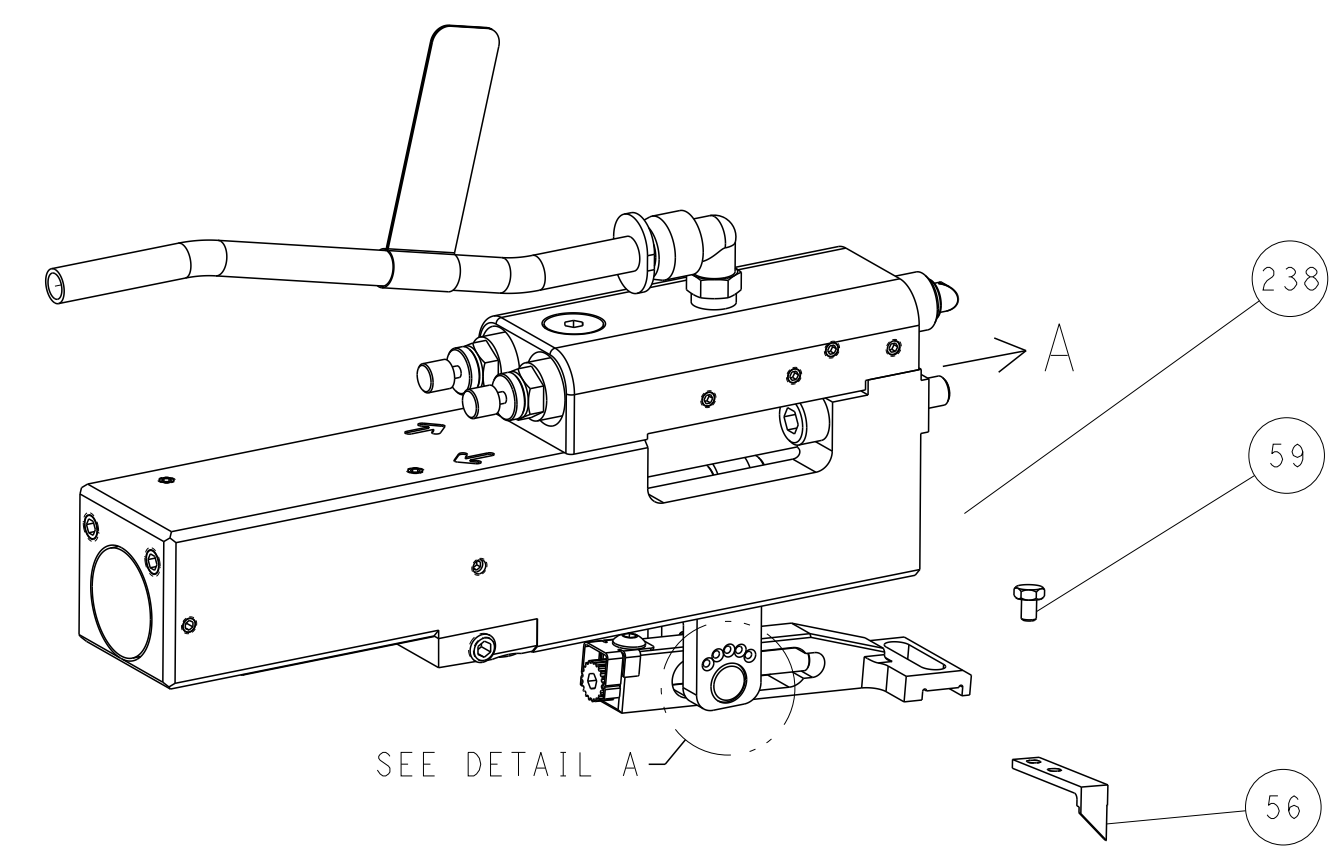
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN X.ZHAO 26MAY2011		TE Connectivity	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	5 PLC ±	Harrisburg, PA 17105-3608
	ANGLES	FINISH		CHK S.XI 26MAY2011	NAME	SIZE	CAGE CODE
MATERIAL				APVD I.CRUZ 26MAY2011	PRODUCT SPEC	A1	00779
				APPLICATION SPEC	RESTRICTED TO	SCALE	1:2
				WEIGHT	Customer Accessible Production Drawing	SHEET	3 OF 4
						REV	H

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

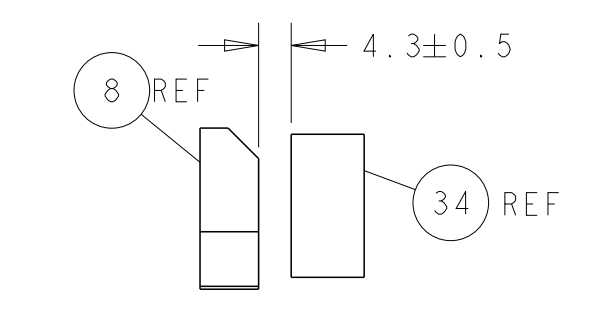
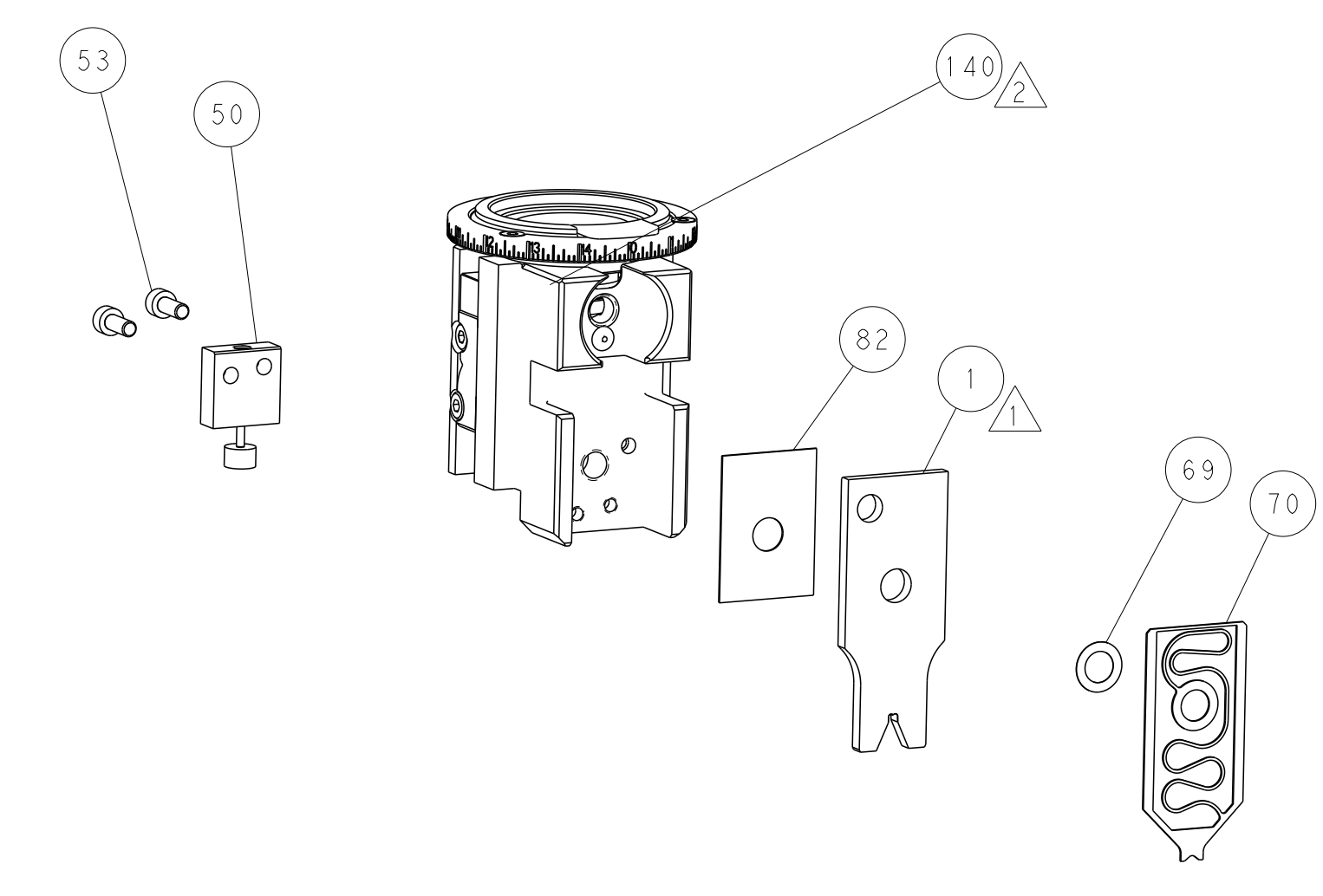
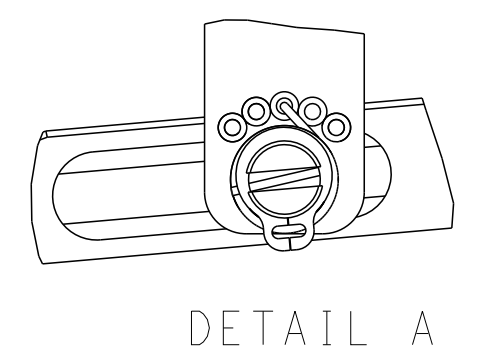
FEED TYPE MECHANICAL



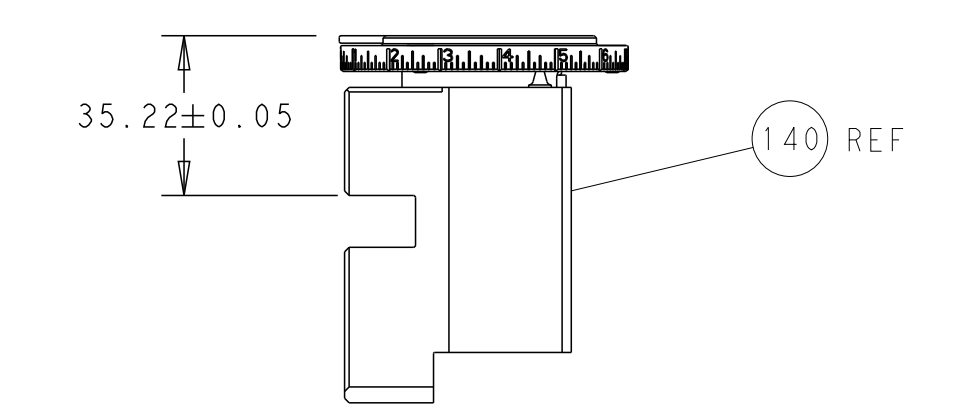
PNEUMATIC



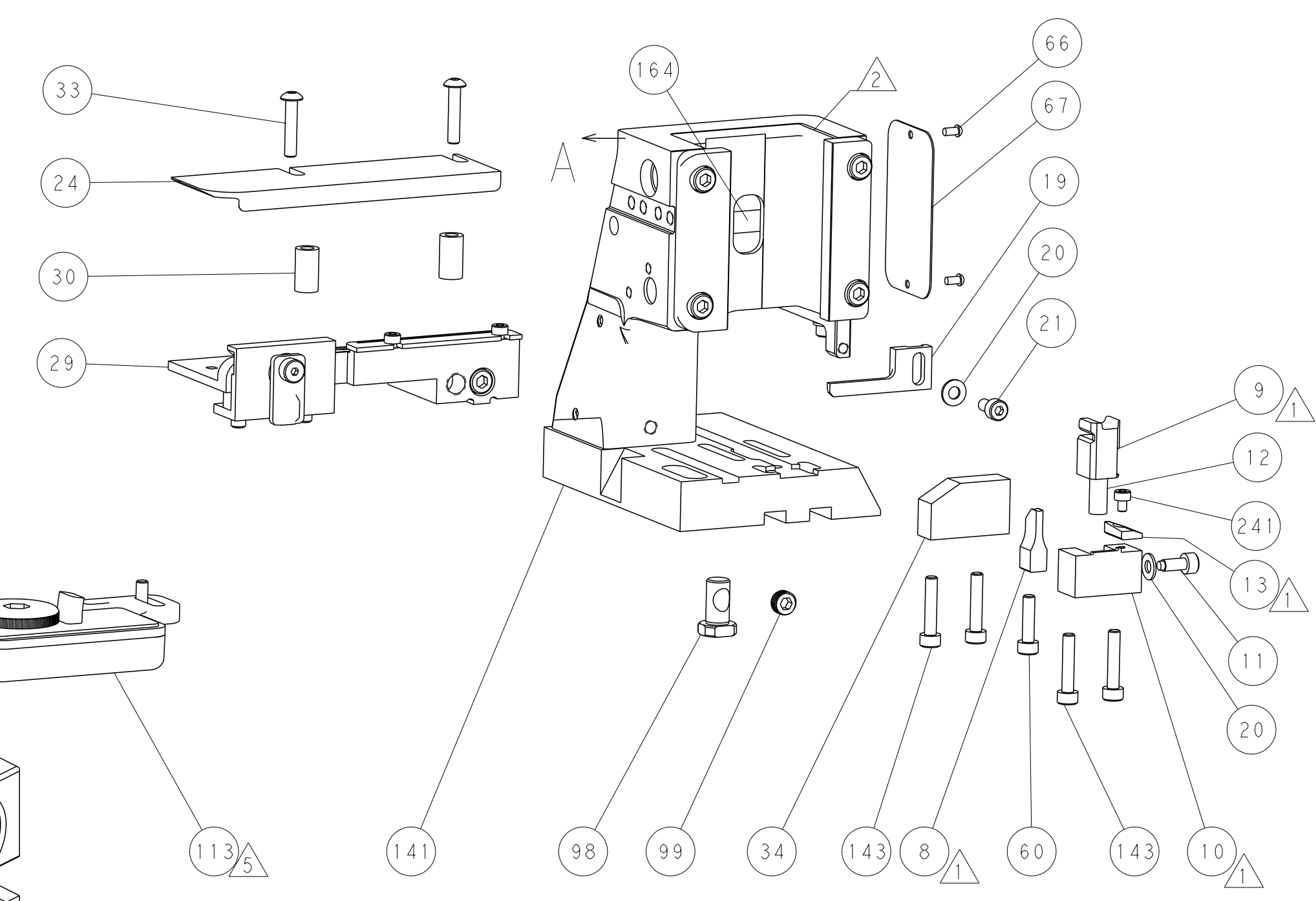
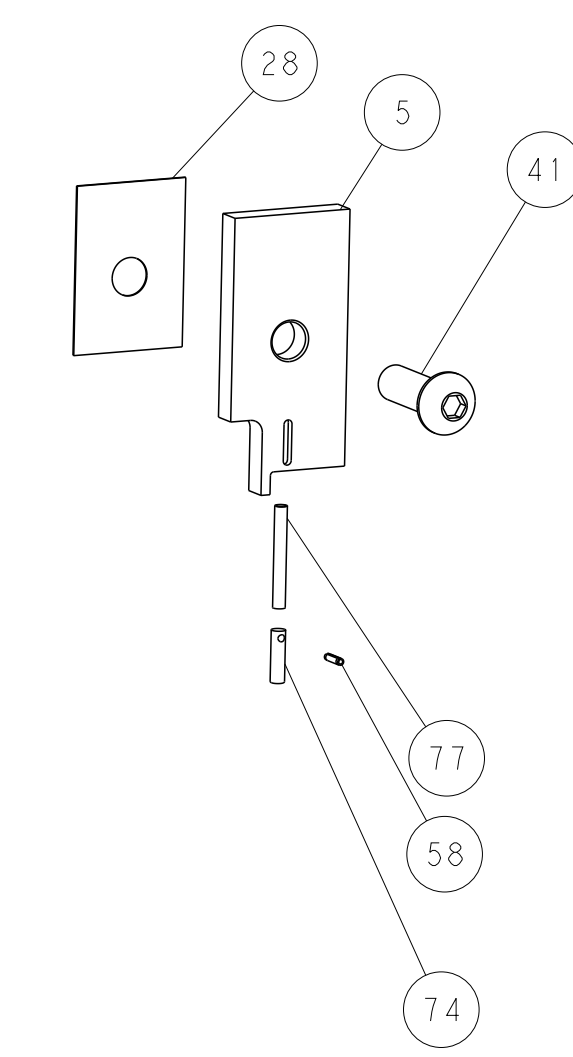
FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



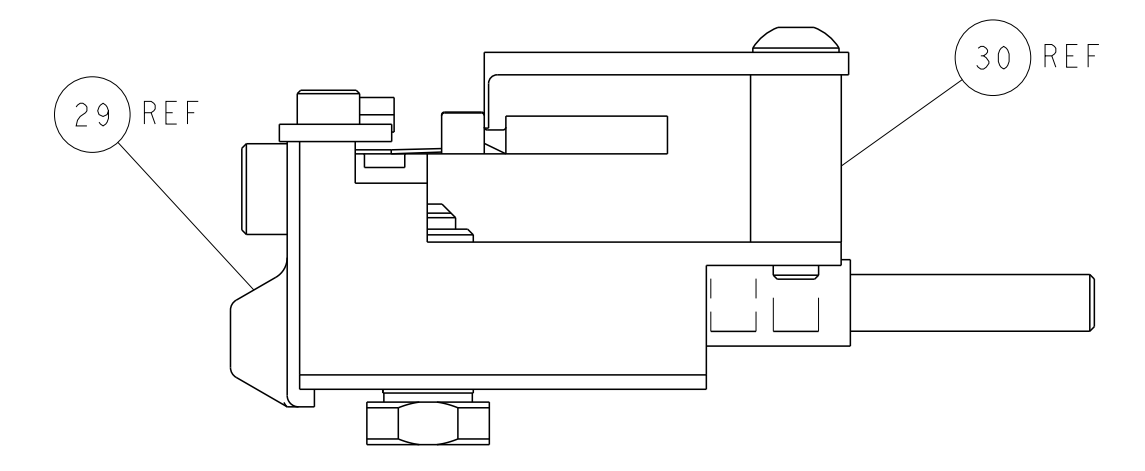
TERMINAL SUPPORT LOCATION



RAM SET-UP

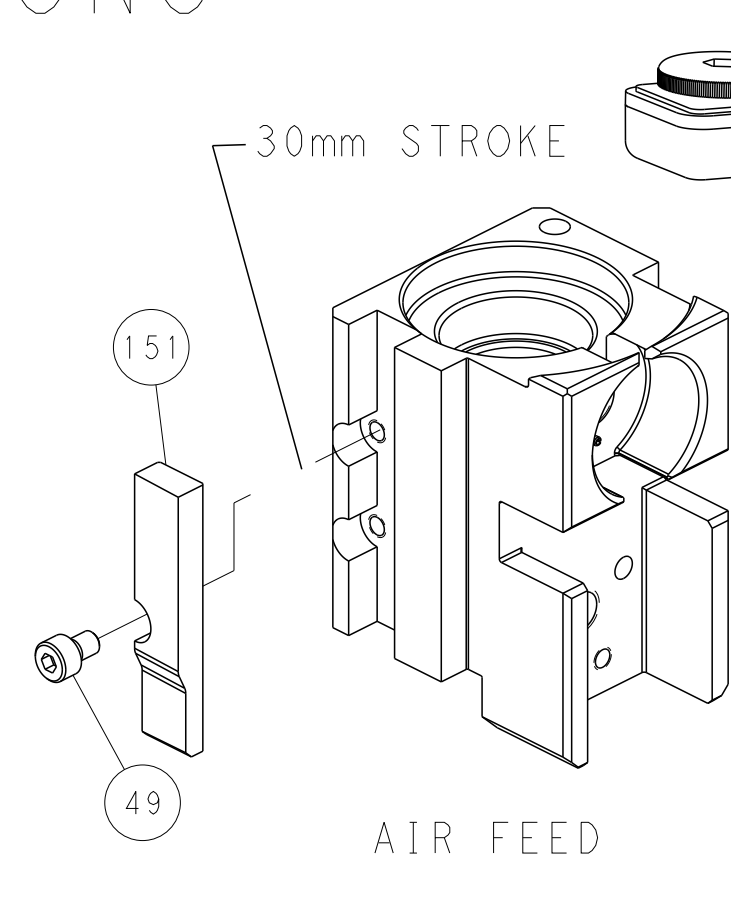
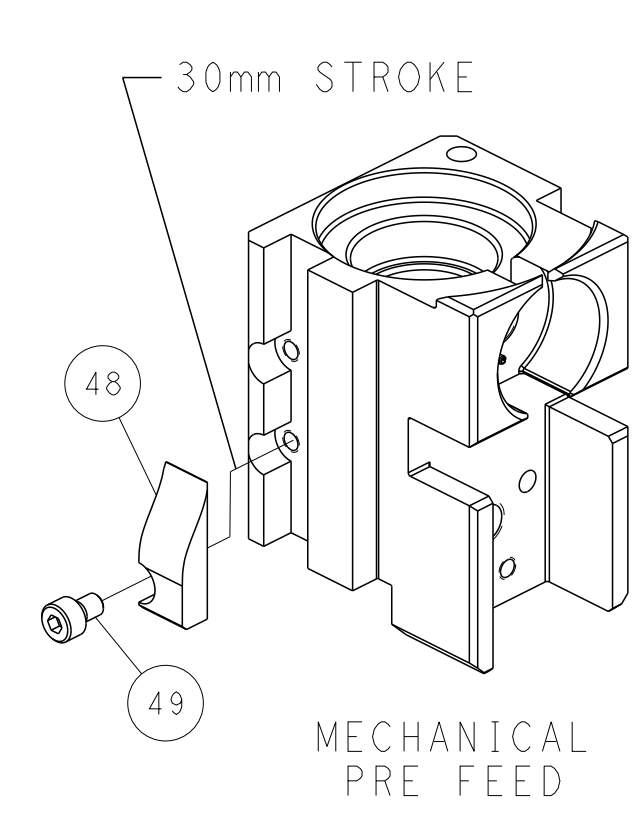
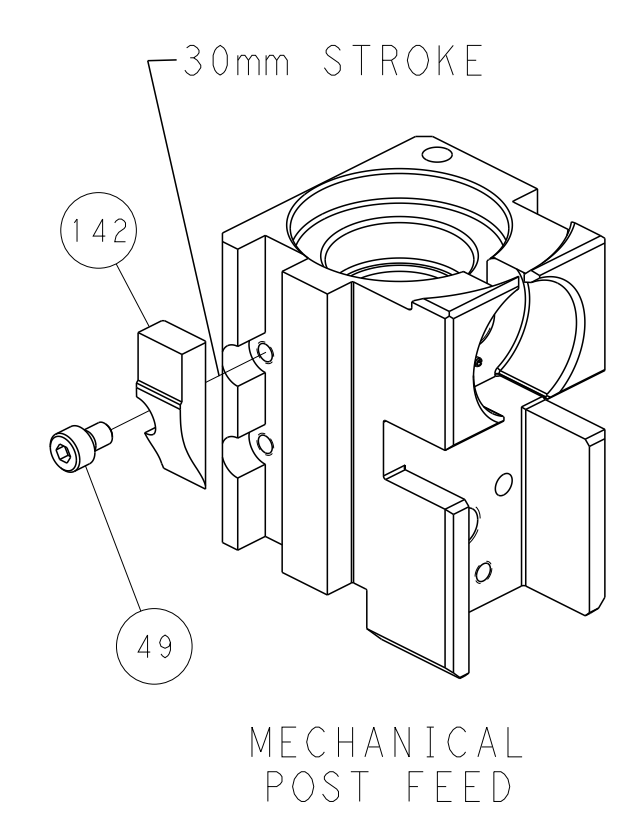


ITEM 30 LOCATED AT REAR HOLES



FEED TRACK POSITION
GUIDE BY WIRE BARREL

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. IT IS THE POLICY OF TYCO ELECTRONICS CORPORATION TO CONTINUE TO IMPROVE ITS PRODUCTS WITHOUT NOTICE. THEREFORE, THIS DRAWING IS SUBJECT TO CHANGE WITHOUT NOTICE. THE USER ASSUMES ALL RESPONSIBILITY FOR THE LATEST REVISION.</small>		DWN X.ZHAO 26MAY2011 CHK S.XI 26MAY2011 APVD J.CRUZ 26MAY2011	NAME Ocean Side Feed Applicator
DIMENSIONS: mm 	TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH	PRODUCT SPEC APPLICATION SPEC WEIGHT SCALE 1:2	SIZE CAGE CODE DRAWING NO A1 00779 C=2151239 SHEET 4 OF 4 REV H