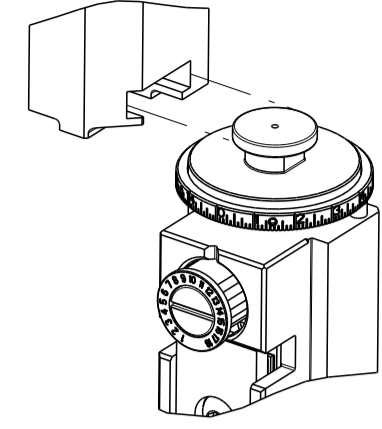


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151116-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2151116-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151116-1	C	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2151116-2	C	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2151116-7	B	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.29 mm [.090]	F
INSUL	3.56 mm [.140]	F

APPLICATOR INSTRUCTIONS 408-35042

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: TAB, POKE-IN, MAG-MATE			
WIRE STRIP LENGTH		TERMINAL INSULATION DIAMETER RANGE	
3.96-4.75 mm [.156-.187 IN]		Ø1.52-2.54 mm [.060-.100 IN]	
TERMINAL APPLICATION SPECIFICATION	114-2050		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
62896-1	62896-3	1217132-1	62898-1
63574-1	1742897-1		
63574-1			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
18 AWG	1.47 +/- 0.05 [.058 +/- .002]	3.6
20 AWG	1.37 +/- 0.05 [.054 +/- .002]	4.8
22 AWG	1.30 +/- 0.055 [.051 +/- .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 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			
P	LTN	DESCRIPTION	DATE	OWN	APVD
A	66				
	A2	ECR-17-008130	06JUN2017	FZ	KZ
	B	ECR-18-019046	07DEC2018	FJ	KZ
	C	ECR-19-015542	05OCT2019	TB	RK
	C1	ECR-22-149376	15AUG2022	FJ	YY

-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248	
-	1	1	1	1	2119082-5	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	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	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	1338685-1	PAWL, FEED	56	
-	2	2	2	2	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	
-	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33	
-	2	2	2	2	1-2844962-7	SPACER, CYLINDRICAL, STRIP GUIDE	30	
-	1	1	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29	
-	1	1	1	1	455888-5	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	2119533-4	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	5-1633921-0	ANVIL, COMBINATION	8
-	-	-	-	-	-	-	7	
-	-	-	-	-	-	-	6	
-	1	1	1	1	2119757-5	DEPRESSOR, SHEAR	5	
-	1	1	1	1	238011-8	BLOCK, CRIMPER SPACER	4	
-	1	2	2	1	1	2-2119582-4	CRIMPER, INSULATION F PREMIUM	3
-	1	1	1	1	455888-3	SPACER, CRIMPER	2	
-	1	2	2	1	1	5-456406-3	CRIMPER, WIRE PREMIUM	1
-	77	-72	-71	-2	-1	PART NO	DESCRIPTION	ITEM NO

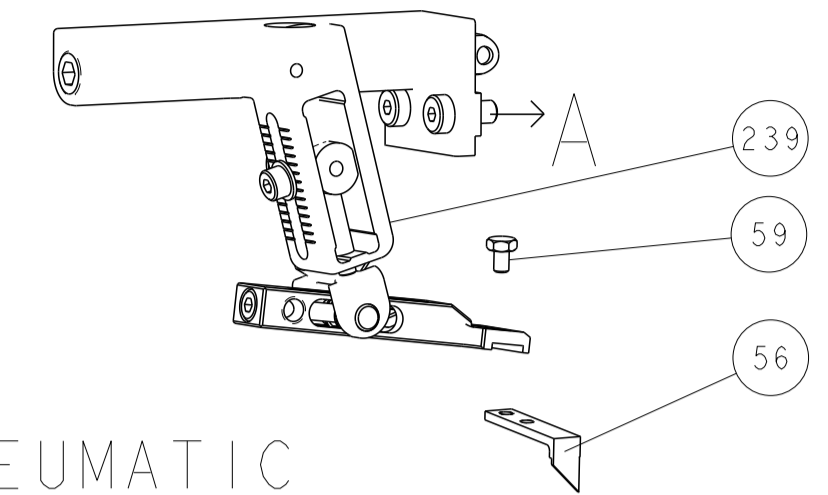
ATLANTIC VERSION  
Shown on sheets 1 of 4 & 2 of 4  
(Pacific version shown on sheets 3 of 4 & 4 of 4)

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

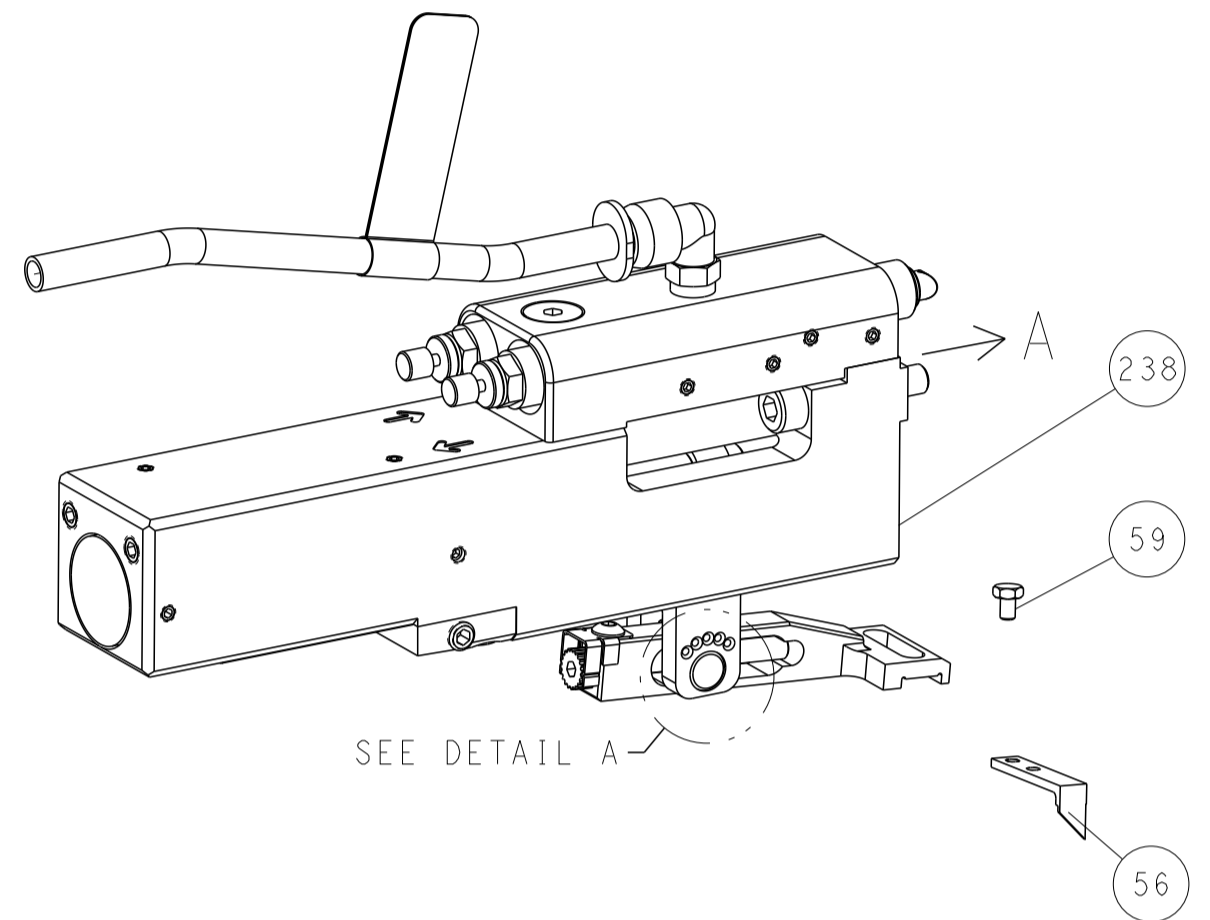
OWN	B. WEAVER	13JAN2016	
CHK	T. ELBIN	13JAN2016	
APVD	T. ELBIN	13JAN2016	
PRODUCT SPEC			
APPLICATION SPEC			
SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
A1	00779	2151116	
Customer Accessible Production Drawing			SCALE 1:2 SHEET 1 OF 4 REV C1

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

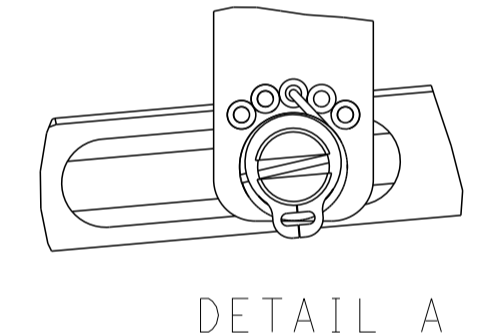
# FEED TYPE MECHANICAL



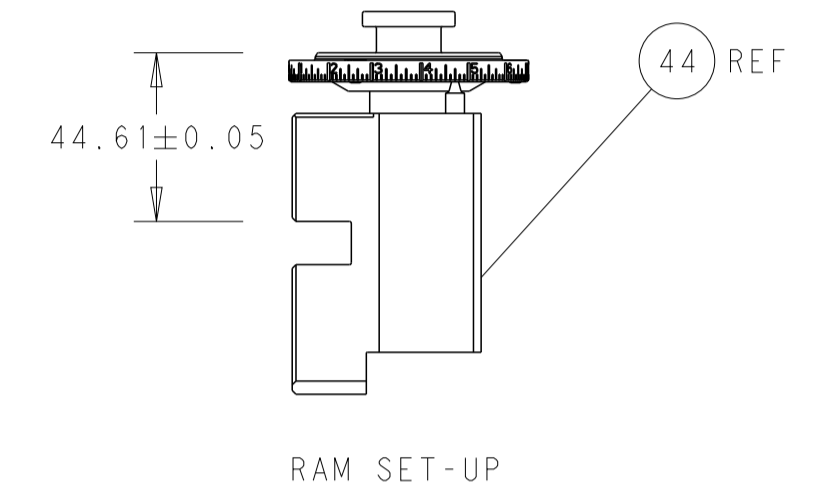
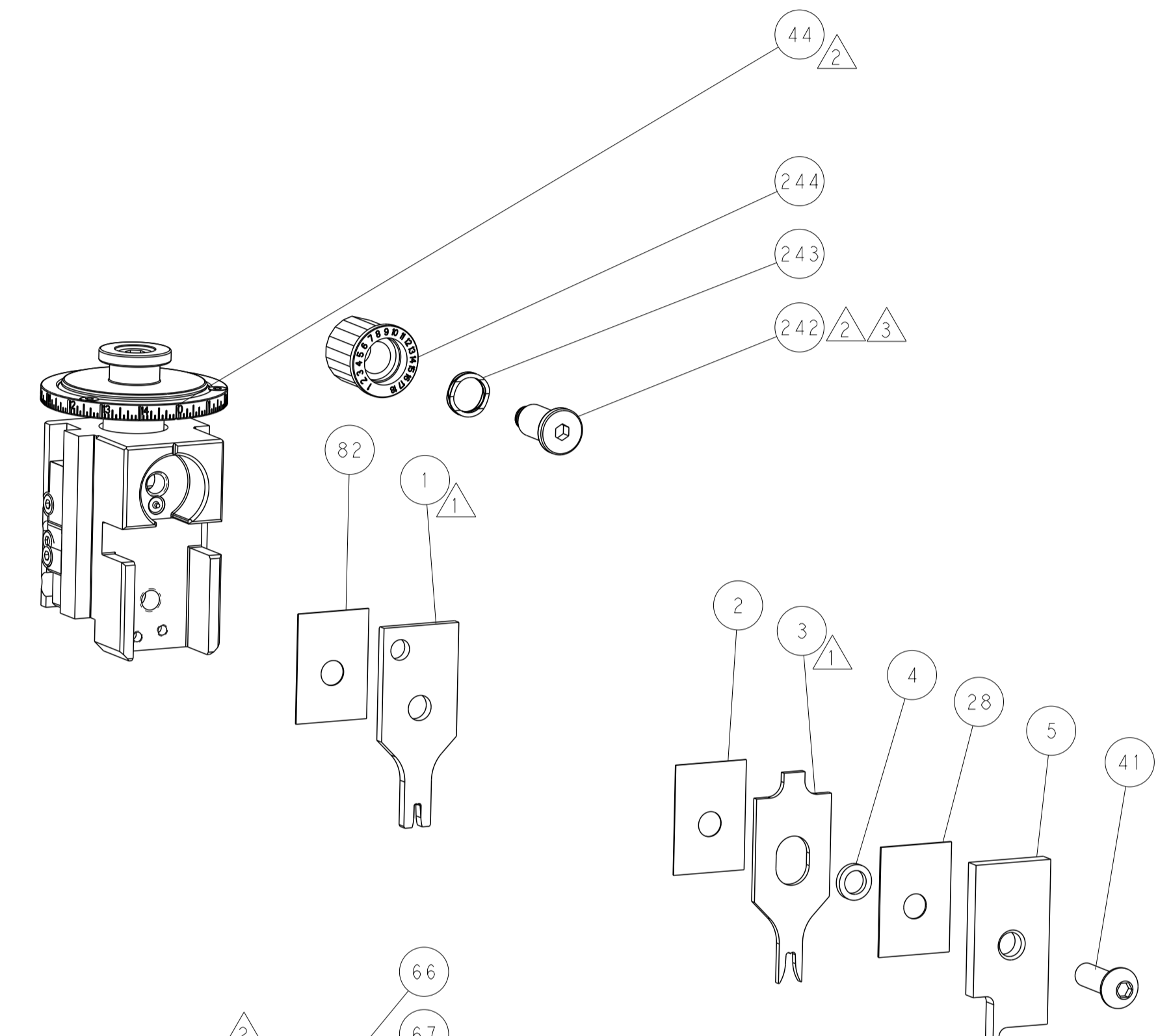
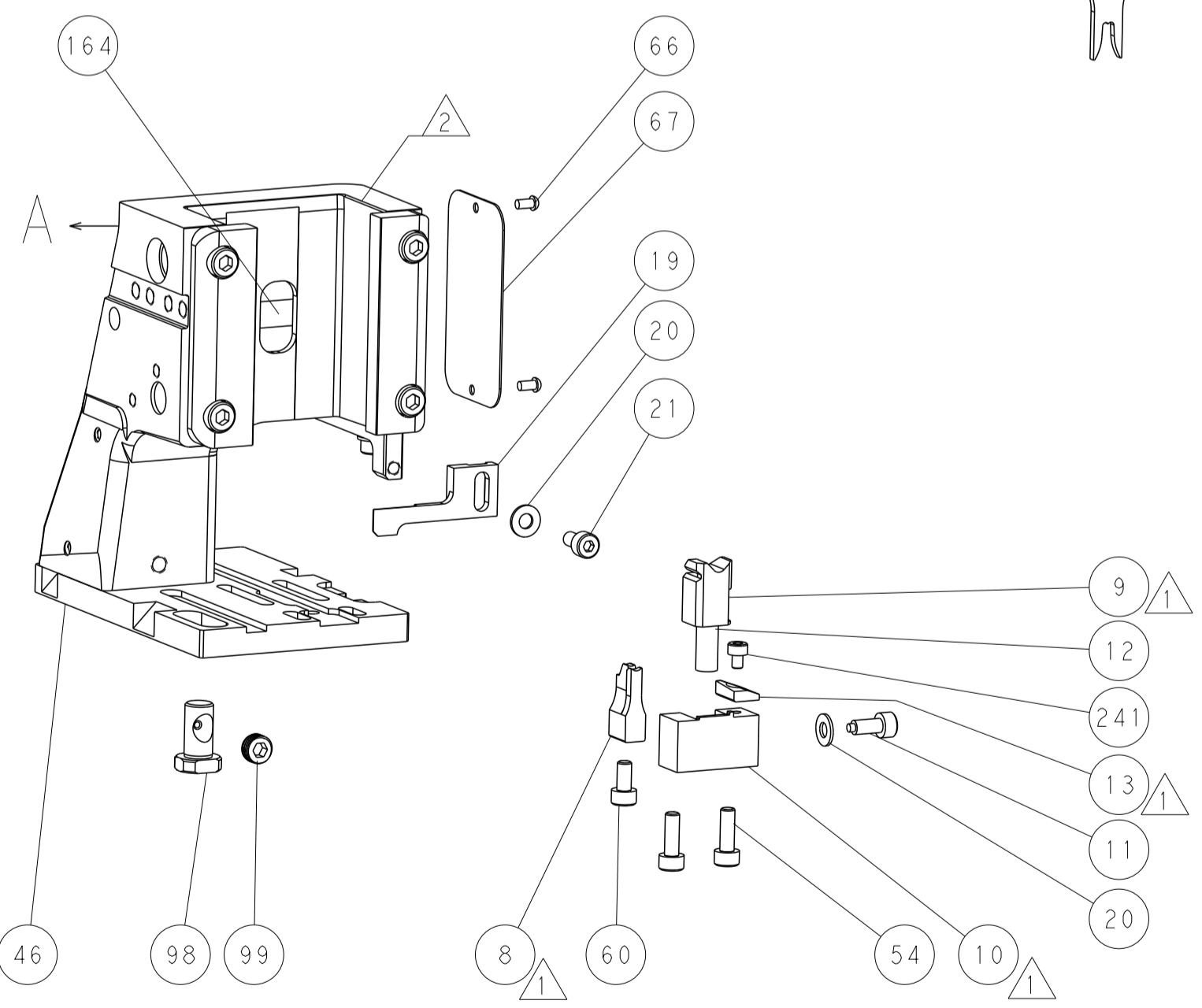
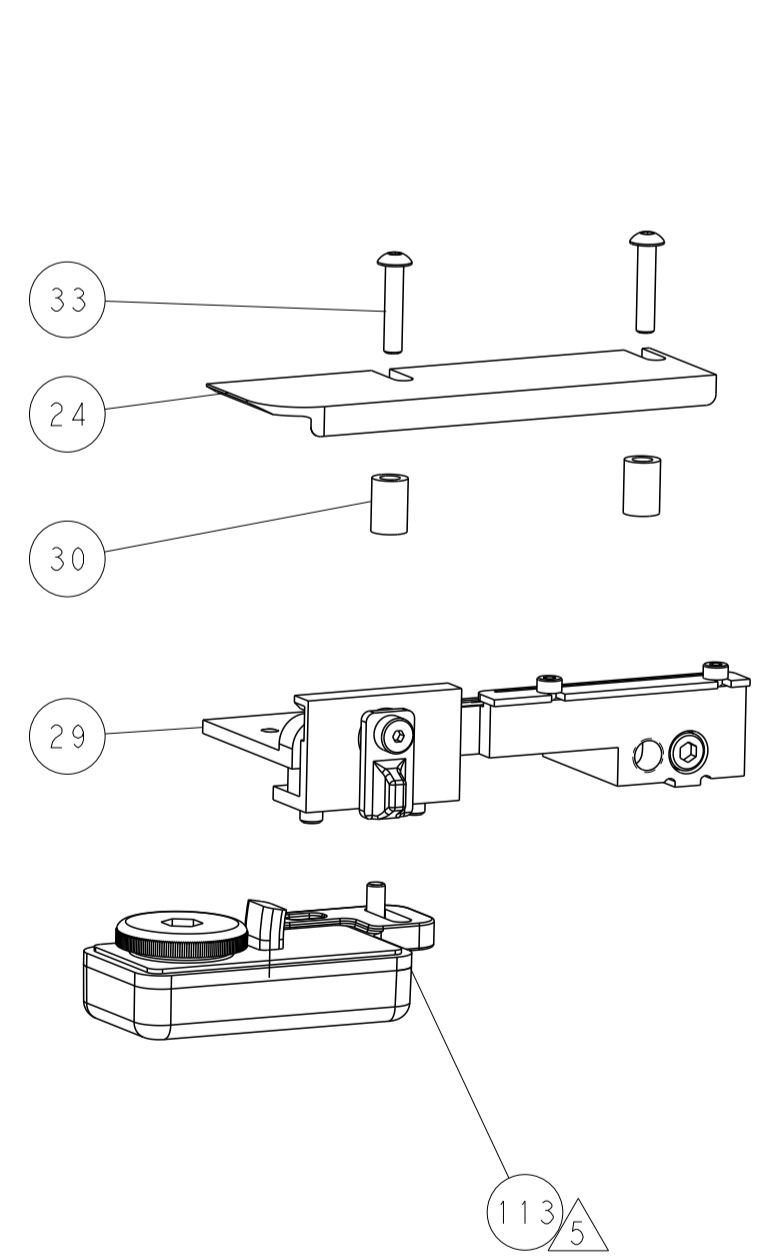
## PNEUMATIC



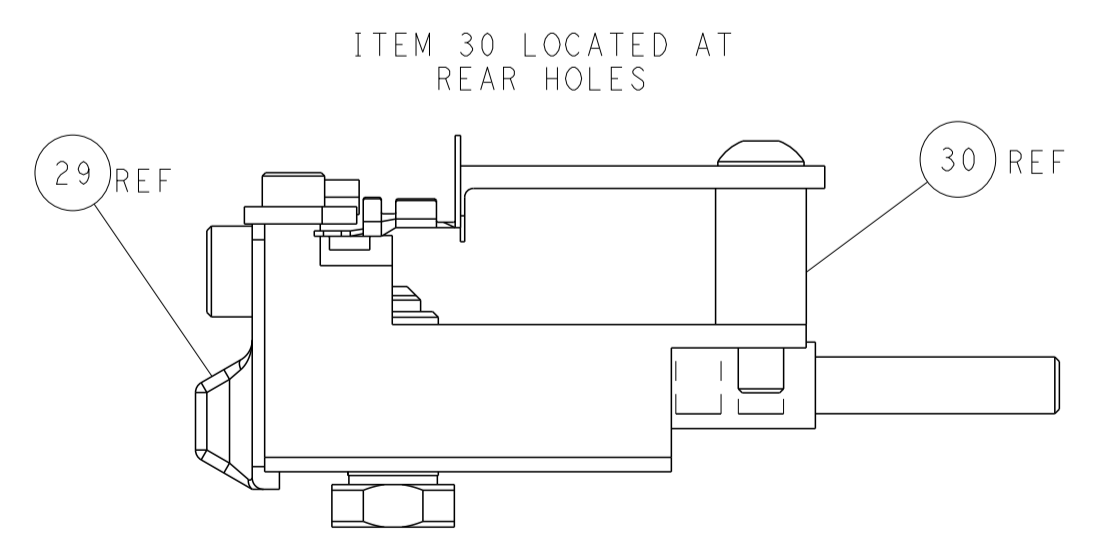
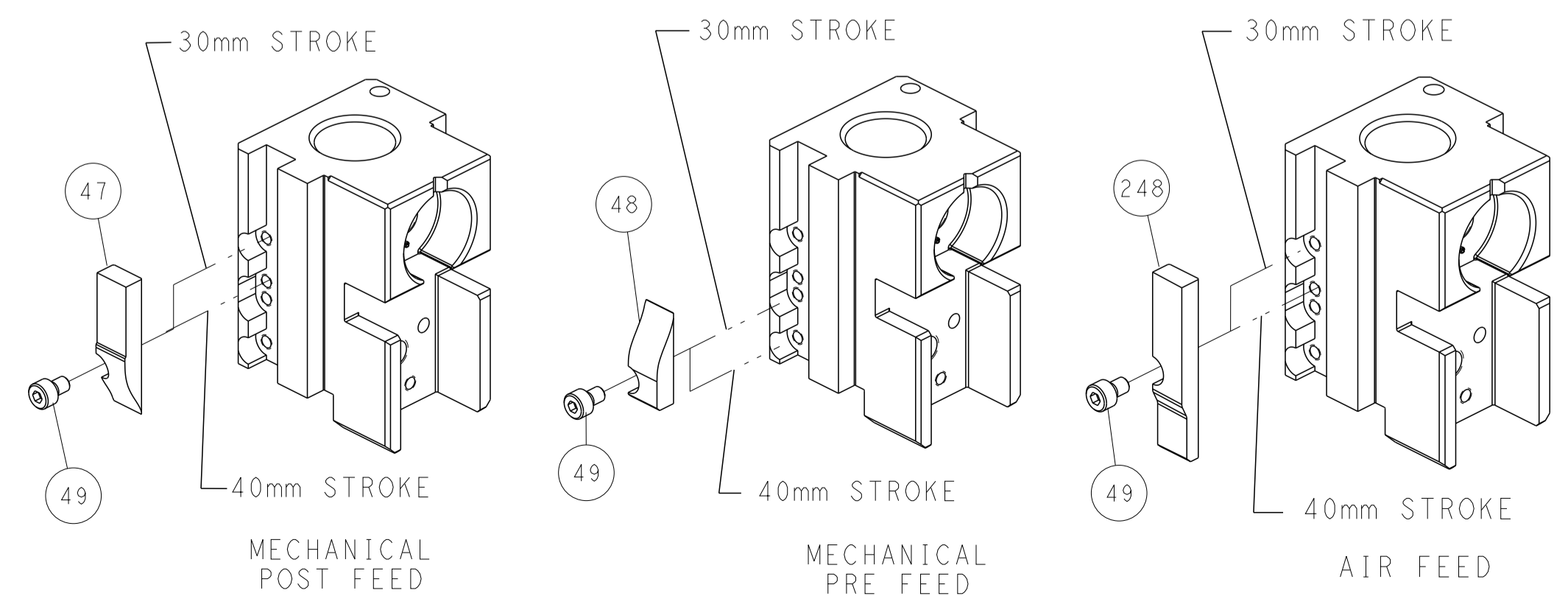
## FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



DETAIL A



# CAM POSITIONS



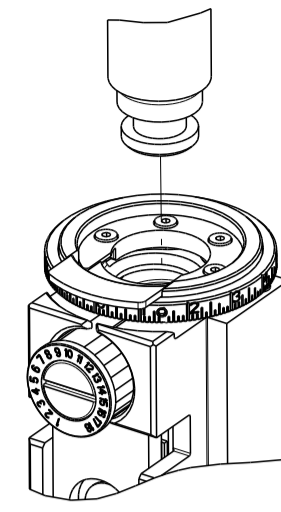
FEED TRACK POSITION GUIDE BY TERMINAL BODY

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

<small>THIS IS THE PROPERTY OF TYCO ELECTRONICS CORPORATION. IT IS TO BE USED ONLY FOR THE PURPOSES AND IN THE MANNER AND UNDER THE SUPERVISION OF THE PERSON TO WHOM IT IS LOANED. IT IS NOT TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, INCLUDING PHOTOCOPYING, RECORDING, OR BY ANY INFORMATION STORAGE AND RETRIEVAL SYSTEM, WITHOUT THE WRITTEN PERMISSION OF TYCO ELECTRONICS CORPORATION.</small>		DWN B. WEAVER 13JAN2016 CHK T. ELBIN 13JAN2016 APVD T. ELBIN 13JAN2016	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: 2151116 WEIGHT: - SCALE: 1:2	RESTRICTED TO: - SHEET 2 OF 4 REV C1
MATERIAL: - FINISH: -		Customer Accessible Production Drawing	

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2151116-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2151116-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151116-7	B	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR  
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.29 mm [.090]	F
INSUL	3.56 mm [.140]	F

APPLICATOR INSTRUCTIONS  
408-35042

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: TAB, POKE-IN, MAG-MATE			
WIRE STRIP LENGTH 3.96-4.75 mm [.156-.187 IN]		TERMINAL INSULATION DIAMETER RANGE Ø1.52-2.54 mm [.060-.100 IN]	
TERMINAL APPLICATION SPECIFICATION	114-2050	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
62896-1	62896-3	1217132-1	62898-1
63574-1	1742897-1		
63574-1			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
18 AWG	1.47+/-0.05 [.058+/-0.002]	3.6
20 AWG	1.37+/-0.05 [.054+/-0.002]	4.8
22 AWG	1.30+/-0.055 [.051+/-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.
- TERMINAL LUBRICANT IS RECOMMENDED.
- 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			
P	LTN	DESCRIPTION	DATE	OWN	APVD
A	66	SEE SHEET 1	-	-	-

-	1	1	2119082-5	CAM, SNAIL, INSULATION ADJUSTMENT	244	
-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243	
3	-	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	
-	2	2	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	
5	-	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	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	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	
-	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33	
-	2	2	1-2844962-7	SPACER, CYLINDRICAL, STRIP GUIDE	30	
-	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29	
-	1	1	455888-5	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	2119533-4	STRIPPER, SIDE FEED	19	
1	-	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	1	2119805-1	SHEAR HOLDER, FRONT	10
1	-	1	1	1803095-1	FLOATING SHEAR, FRONT	9
1	1	1	1	5-1633921-0	ANVIL, COMBINATION	8
-	-	-	-	-	7	
-	-	-	-	-	6	
-	1	1	2119757-5	DEPRESSOR, SHEAR	5	
-	1	1	238011-8	BLOCK, CRIMPER SPACER	4	
1	1	1	2-2119582-4	CRIMPER, INSULATION F PREMIUM	3	
-	1	1	455888-3	SPACER, CRIMPER	2	
1	1	1	5-456406-3	CRIMPER, WIRE PREMIUM	1	

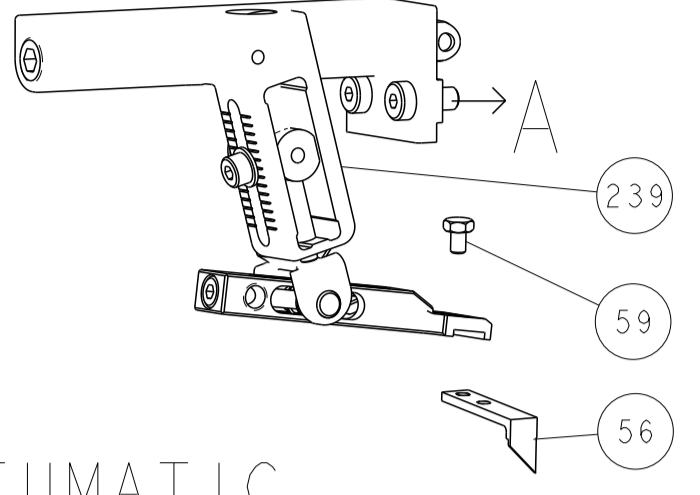
PACIFIC VERSION  
Shown on sheets 3 of 4 & 4 of 4  
(Atlantic version shown on sheets 1 of 4 & 2 of 4)

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

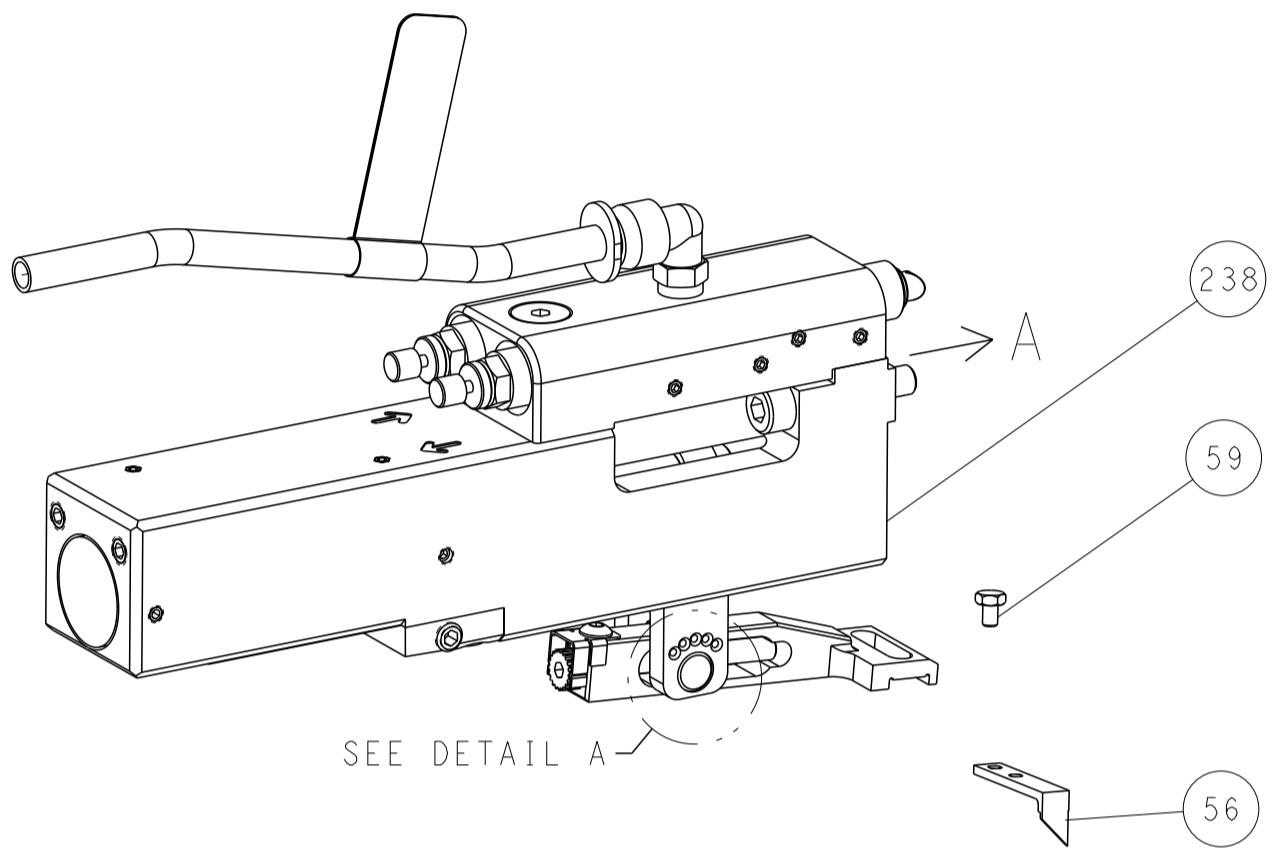
APVD	OWN	CHK	DATE	NAME	PRODUCT SPEC	APPLICATION SPEC	SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
T. ELBIN	B. WEAVER	T. ELBIN	13JAN2016	Ocean Side Feed			A1	00779	2151116	
Customer Accessible Production Drawing										

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

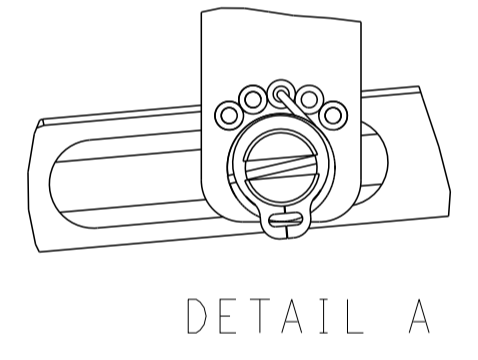
# FEED TYPE MECHANICAL



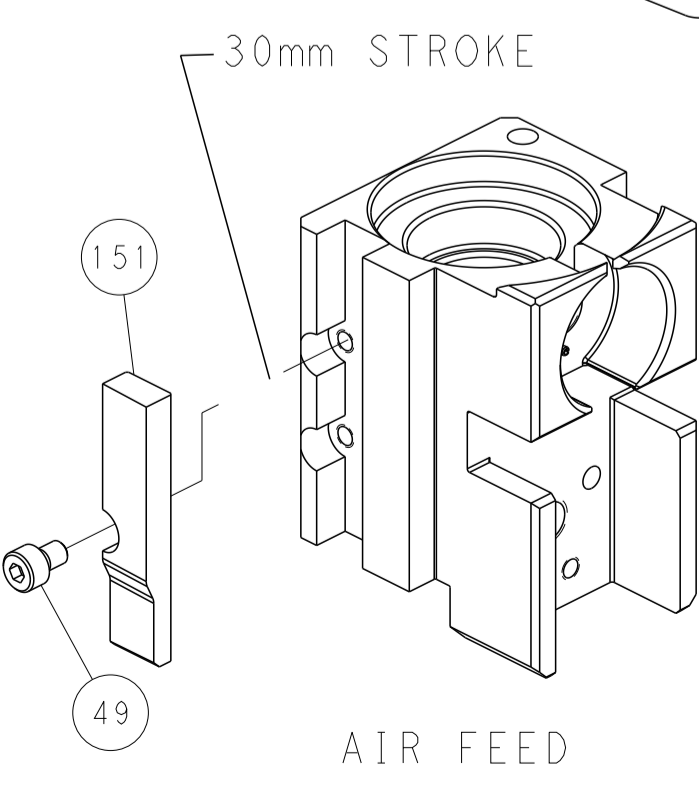
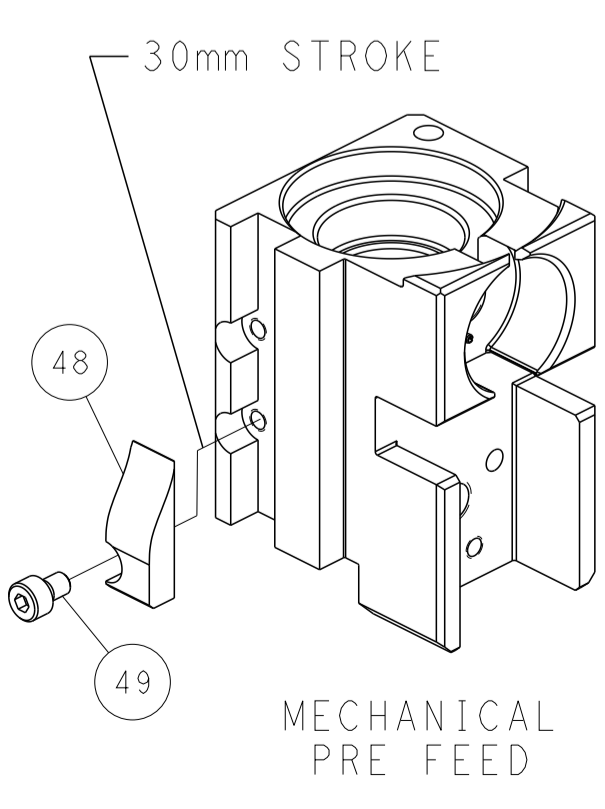
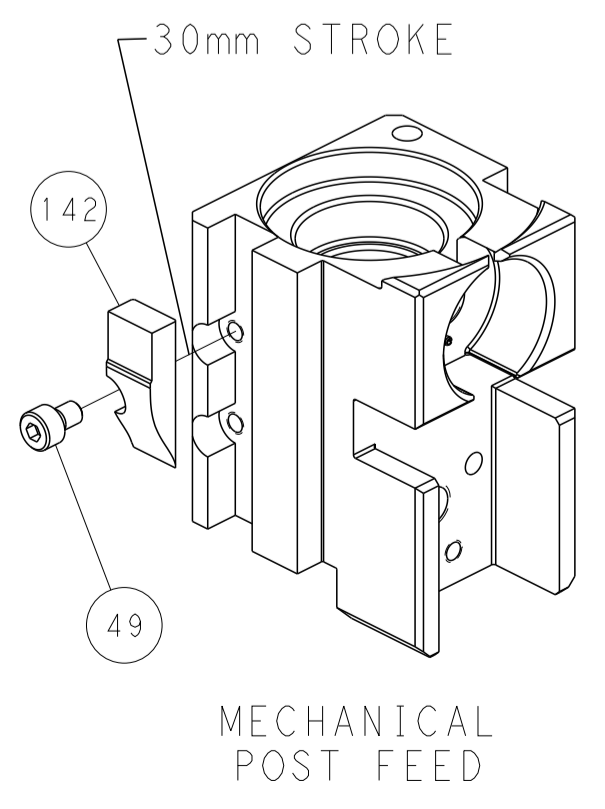
## PNEUMATIC



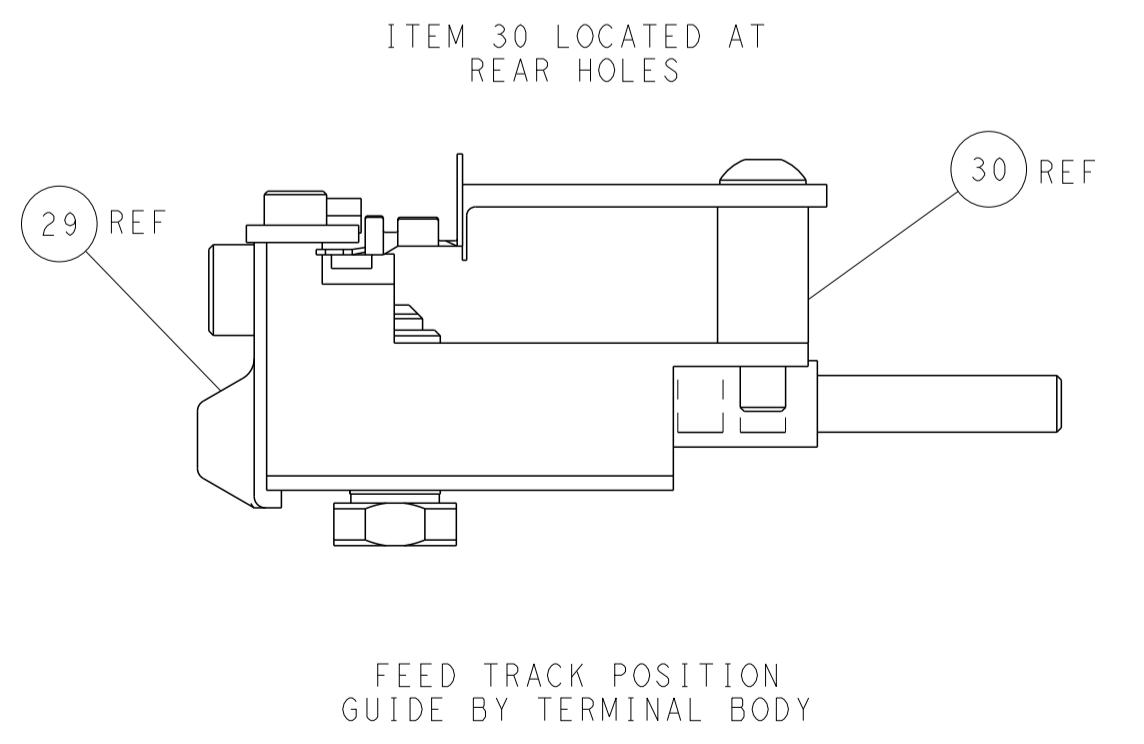
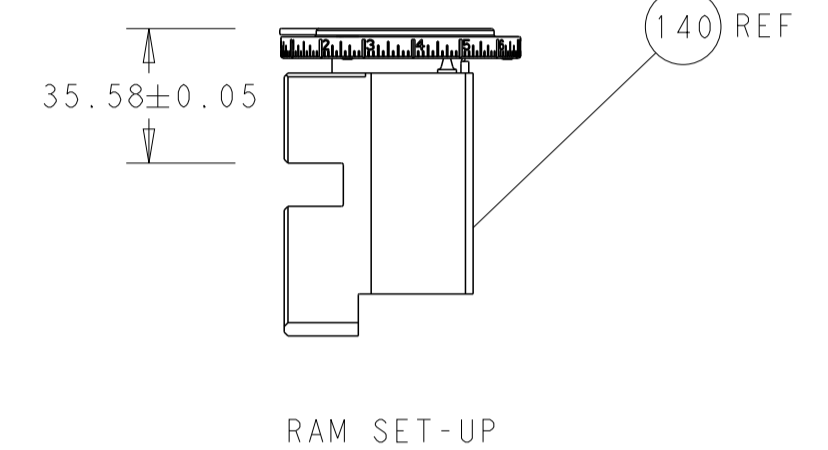
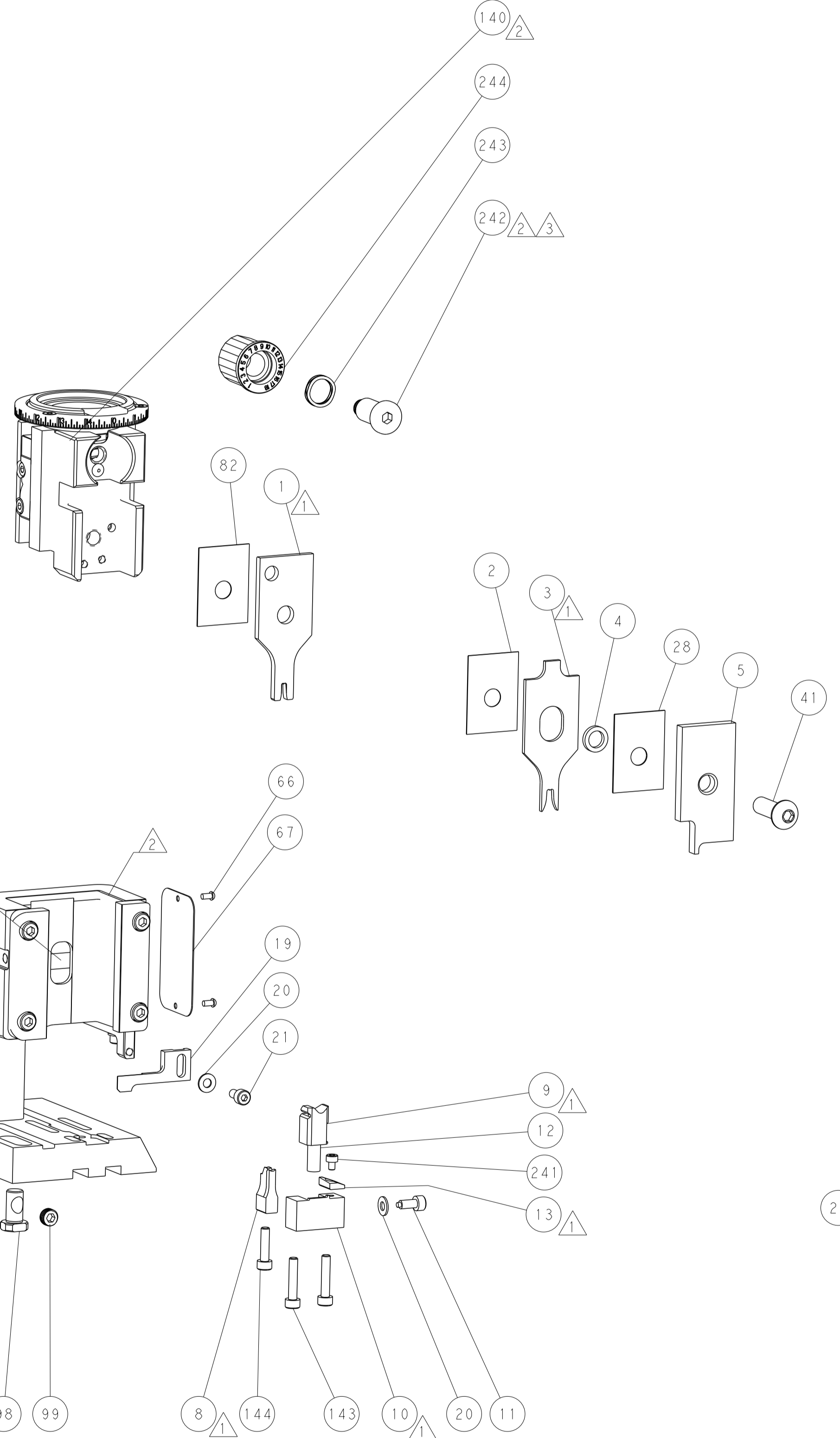
### FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



## 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 2016. COPYRIGHT 2016 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.</small>		DWN: B. WEAVER 13JAN2016 CHK: T. ELBIN 13JAN2016 APVD: T. ELBIN 13JAN2016	NAME: TE Connectivity Harrisburg, PA 17105-3608
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: A1 CAGE CODE: 00779 DRAWING NO: C=2151116 SHEET 4 OF 4	RESTRICTED TO: - REV: C1