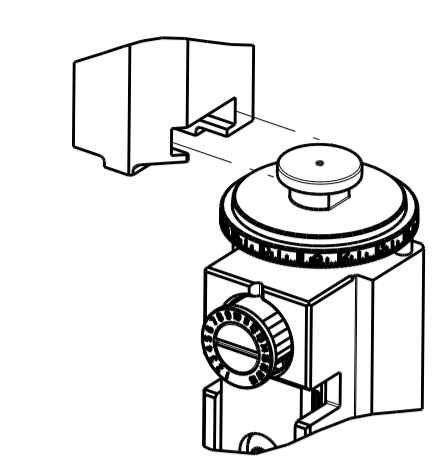


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151024-1	D	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2151024-2	E	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151024-1	D	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2151024-2	E	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2151024-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.29 mm [.090]	F
INSUL	3.30 mm [.130]	F

APPLICATOR INSTRUCTIONS
408-35042

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: UNIVERSAL MATE-N-LOK II			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
4.00-4.75 mm [.157-.187 IN]		∅1.52-3.30 mm [.060-.130 IN]	
TERMINAL APPLICATION SPECIFICATION	114-1043		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
770193-1	770193-2	770193-9	1-770193-0

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: UNIVERSAL MATE-N-LOK II			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
4.00-4.75 mm [.157-.187 IN]		∅1.52-3.30 mm [.060-.130 IN]	
TERMINAL APPLICATION SPECIFICATION	114-1043		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
770007-1	770007-2	770007-9	1-770007-0
770008-3	770008-4	1-770008-0	

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
14 AWG	1.75+/-0.05 [.069+/- .002]	4.3
16 AWG	1.50+/-0.05 [.059+/- .002]	6.8
18 AWG	1.32+/-0.05 [.052+/- .002]	8.8
20 AWG	1.19+/-0.05 [.047+/- .002]	10.2

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
14 AWG	1.75+/-0.05 [.069+/- .002]	4.3
16 AWG	1.50+/-0.05 [.059+/- .002]	6.8
18 AWG	1.32+/-0.05 [.052+/- .002]	8.8
20 AWG	1.19+/-0.05 [.047+/- .002]	10.2

- 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.
- FEED ADJUSTMENT MAY BE REQUIRED WHEN SWITCHING TERMINALS.
- 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	REV	DATE	BY	CHKD
		B	ECR-13-005283	25MAR2013	LG TE
		C	ECR-16-013655	26SEP2016	JH LZ
		D	ECR-18-006609	30APR2018	MEH JDG
		E	ECR-20-014469	13OCT2020	FZ TE

-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248	
-	1	1	1	1	2119082-9	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	-	-	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	455888-5	SPACER, CRIMPER	82	
-	1	1	1	1	1803607-3	DOCUMENTATION PACKAGE	71	
-	1	1	1	1	2119791-5	DEPRESSOR, WIRE	70	
-	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	1-1752356-8	SUPPORT, TERMINAL	34	
-	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33	
-	2	2	2	2	3-2844962-0	SPACER, CYLINDRICAL, STRIP GUIDE	30	
-	1	1	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29	
-	1	1	1	1	1-455888-0	SPACER, CRIMPER	28	
-	1	1	1	1	1320928-6	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	2119806-1	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	1	2-1333205-6	ANVIL, COMBINATION	8
-	1	1	1	1	2119757-8	DEPRESSOR, SHEAR	5	
-	1	1	1	1	238011-7	BLOCK, CRIMPER SPACER	4	
-	1	2	2	1	1	2119582-1	CRIMPER, INSULATION F PREMIUM	3
-	1	1	1	1	455888-2	SPACER, CRIMPER	2	
-	1	2	2	1	1	3-456406-3	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)

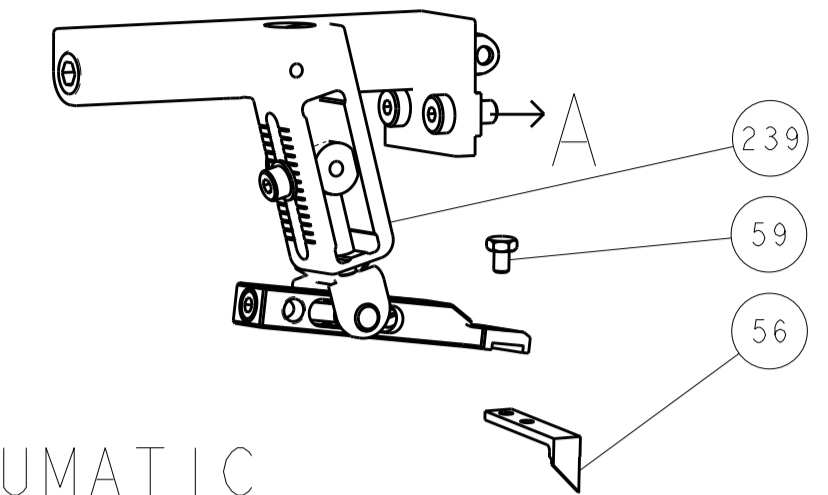
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		MATERIAL:		FINISH:	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES ±	FINISH ±

REV	DATE	BY	CHKD
03NOV2010	03NOV2010	T. ELBIN	
03NOV2010	03NOV2010	I. CRUZ	

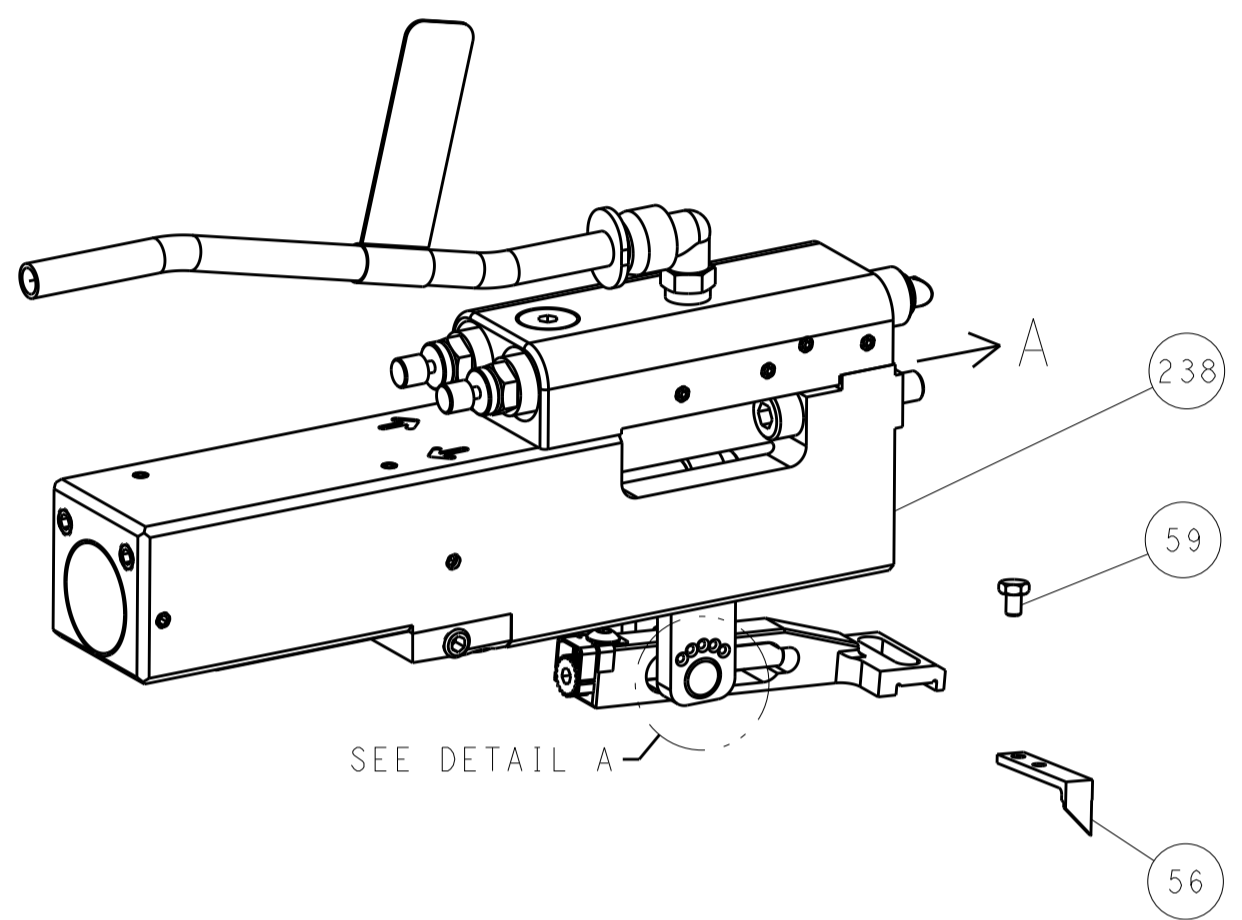
NAME	TE Connectivity
ADDRESS	Harrisburg, PA 17105-3608
PRODUCT SPEC	Ocean Side Feed Applicator
APPLICATION SPEC	
SIZE	A1
CAGE CODE	00779
DRAWING NO	2151024
RESTRICTED TO	
WEIGHT	
SCALE	1:2
SHEET	1 OF 4
REV	E

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

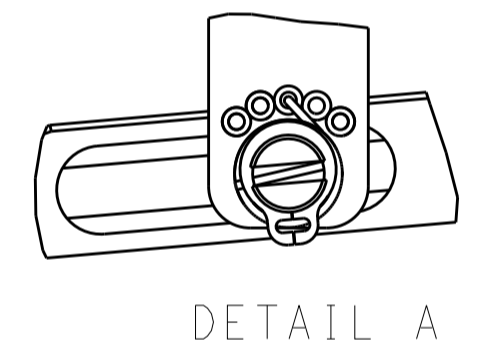
FEED TYPE MECHANICAL



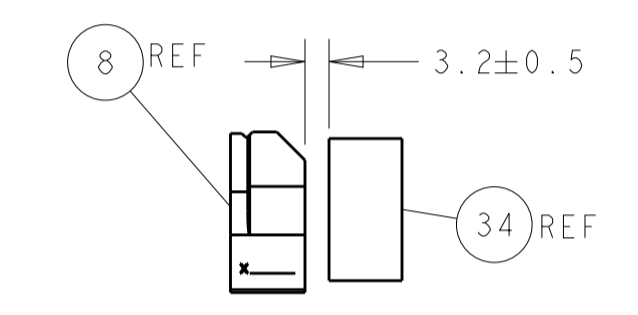
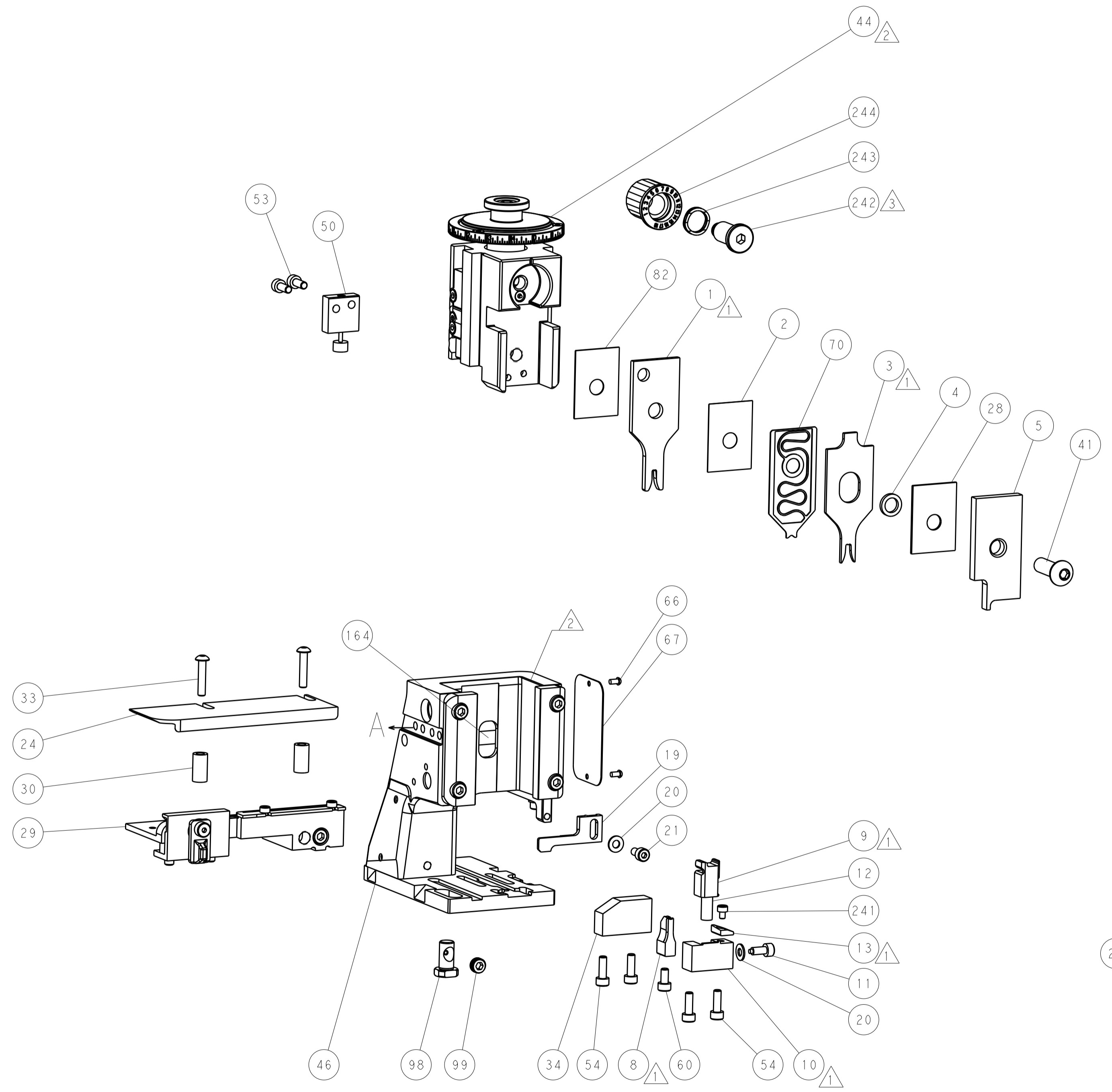
PNEUMATIC



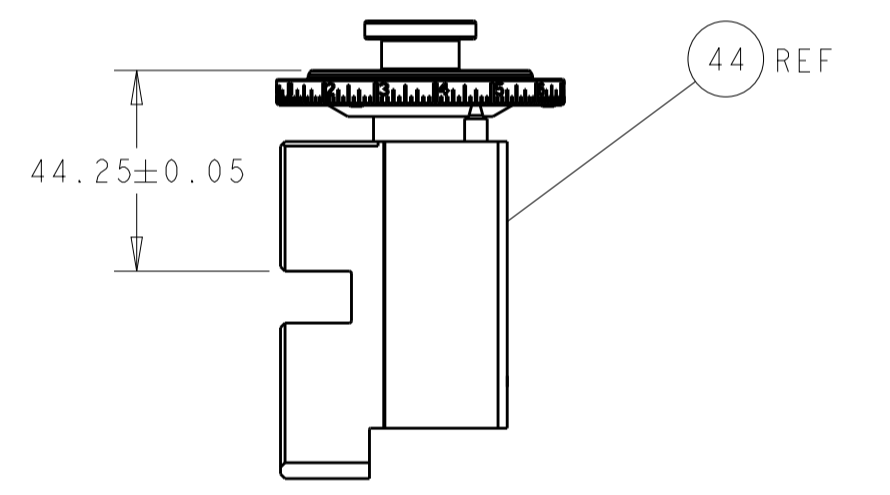
FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



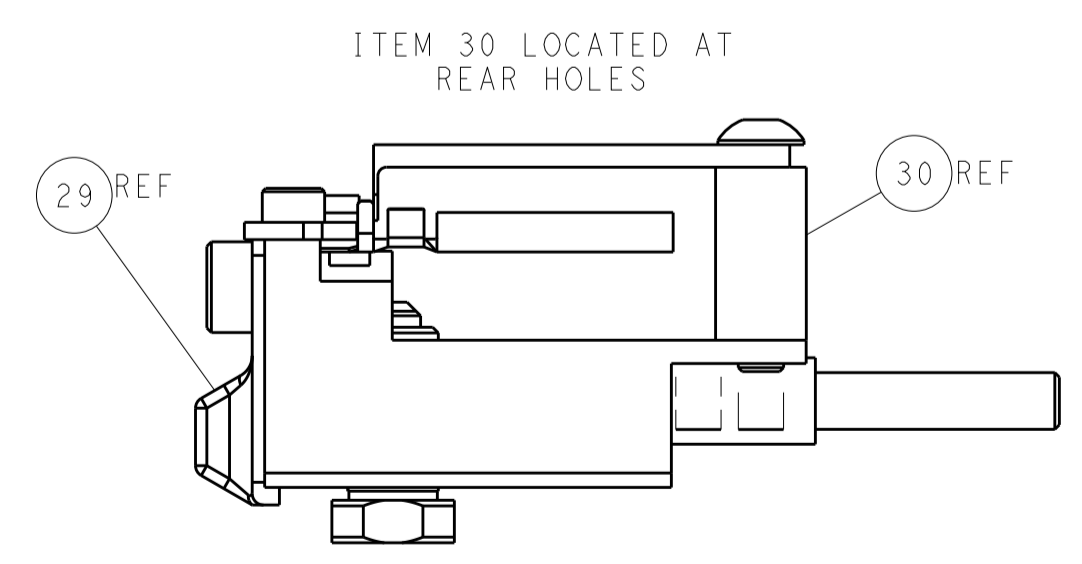
DETAIL A



TERMINAL SUPPORT LOCATION

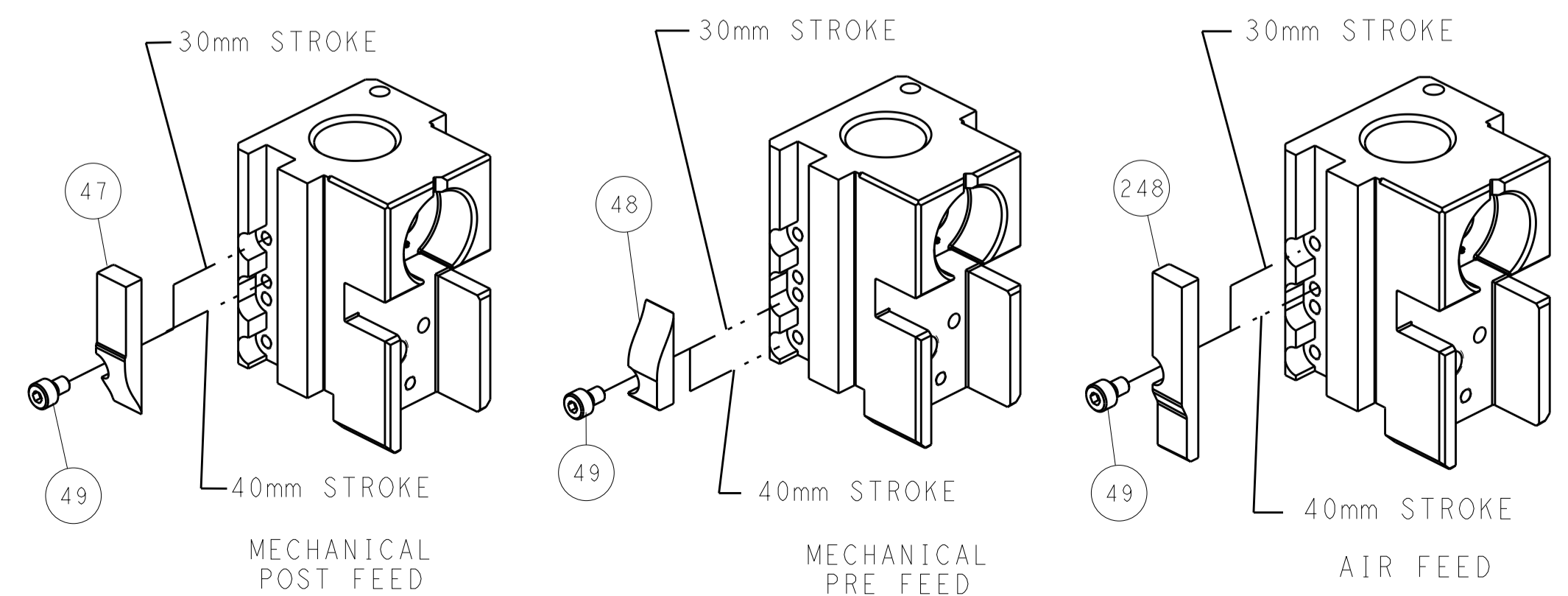


RAM SET-UP



ITEM 30 LOCATED AT REAR HOLES

CAM POSITIONS

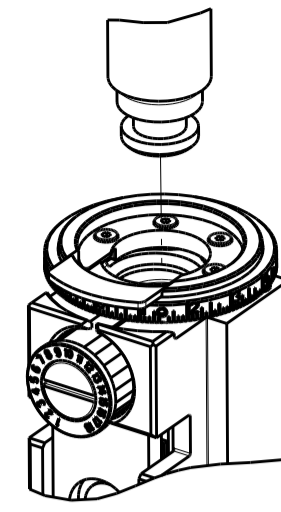


ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN 03NOV2010		TE Connectivity	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	Harrisburg, PA 17105-3608	
MATERIAL:		FINISH:		APVD 03NOV2010		NAME	
				PRODUCT SPEC		Ocean Side Feed	
				APPLICATION SPEC		Applicator	
				WEIGHT		SIZE CAGE CODE DRAWING NO	
				Customer Accessible Production Drawing		A1 00779 ©=2151024	
				SCALE 1:2		SHEET 2 OF 4 REV E	

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2151024-1	D	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2151024-2	E	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151024-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.29 mm [.090]	F
INSUL	3.30 mm [.130]	F

APPLICATOR INSTRUCTIONS
408-35042

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: UNIVERSAL MATE-N-LOK II			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
4.00-4.75 mm [.157-.187 IN]		Ø1.52-3.30 mm [.060-.130 IN]	
TERMINAL APPLICATION SPECIFICATION	114-1043	-	-
TERMINALS APPLIED ⁵			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
770193-1	770193-2	770193-9	1-770193-0

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: UNIVERSAL MATE-N-LOK II			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
4.00-4.75 mm [.157-.187 IN]		Ø1.52-3.30 mm [.060-.130 IN]	
TERMINAL APPLICATION SPECIFICATION	114-1043	-	-
TERMINALS APPLIED ⁵			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
770007-1	770007-2	770007-9	1-770007-0
770008-3	770008-4	1-770008-0	

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
14 AWG	1.75+/-0.05 [.069+/- .002]	4.3
16 AWG	1.50+/-0.05 [.059+/- .002]	6.8
18 AWG	1.32+/-0.05 [.052+/- .002]	8.8
20 AWG	1.19+/-0.05 [.047+/- .002]	10.2

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
14 AWG	1.75+/-0.05 [.069+/- .002]	4.3
16 AWG	1.50+/-0.05 [.059+/- .002]	6.8
18 AWG	1.32+/-0.05 [.052+/- .002]	8.8
20 AWG	1.19+/-0.05 [.047+/- .002]	10.2

- 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.
 - FEED ADJUSTMENT MAY BE REQUIRED WHEN SWITCHING TERMINALS.
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.

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

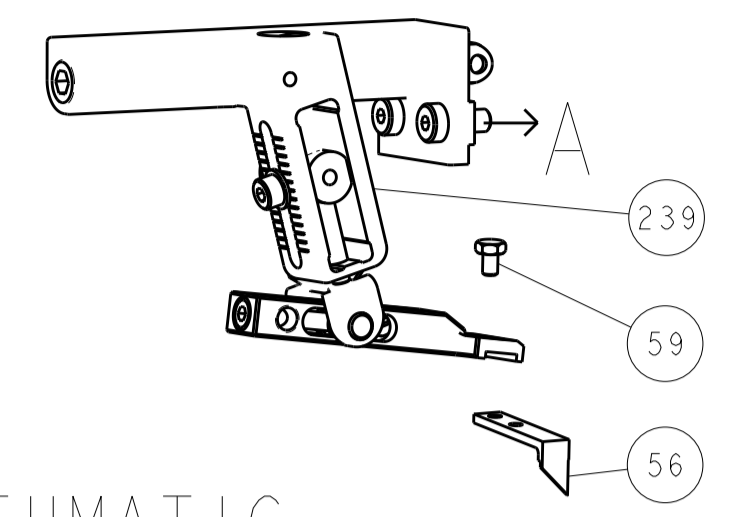
-	1	1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
-	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	1	-	2844940-1	AIR FEED MODULE	238
-	REF	REF	994970-2	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	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	1803382-6	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	1-1752356-8	SUPPORT, TERMINAL	34
-	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	3-2844962-0	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29
-	1	1	1-455888-0	SPACER, CRIMPER	28
-	1	1	1320928-6	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	2119806-1	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	2-1333205-6	ANVIL, COMBINATION	8
-	1	1	2119757-8	DEPRESSOR, SHEAR	5
-	1	1	238011-7	BLOCK, CRIMPER SPACER	4
-	1	1	2119582-1	CRIMPER, INSULATION F PREMIUM	3
-	1	1	455888-2	SPACER, CRIMPER	2
-	1	1	3-456406-3	CRIMPER, WIRE PREMIUM	1

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

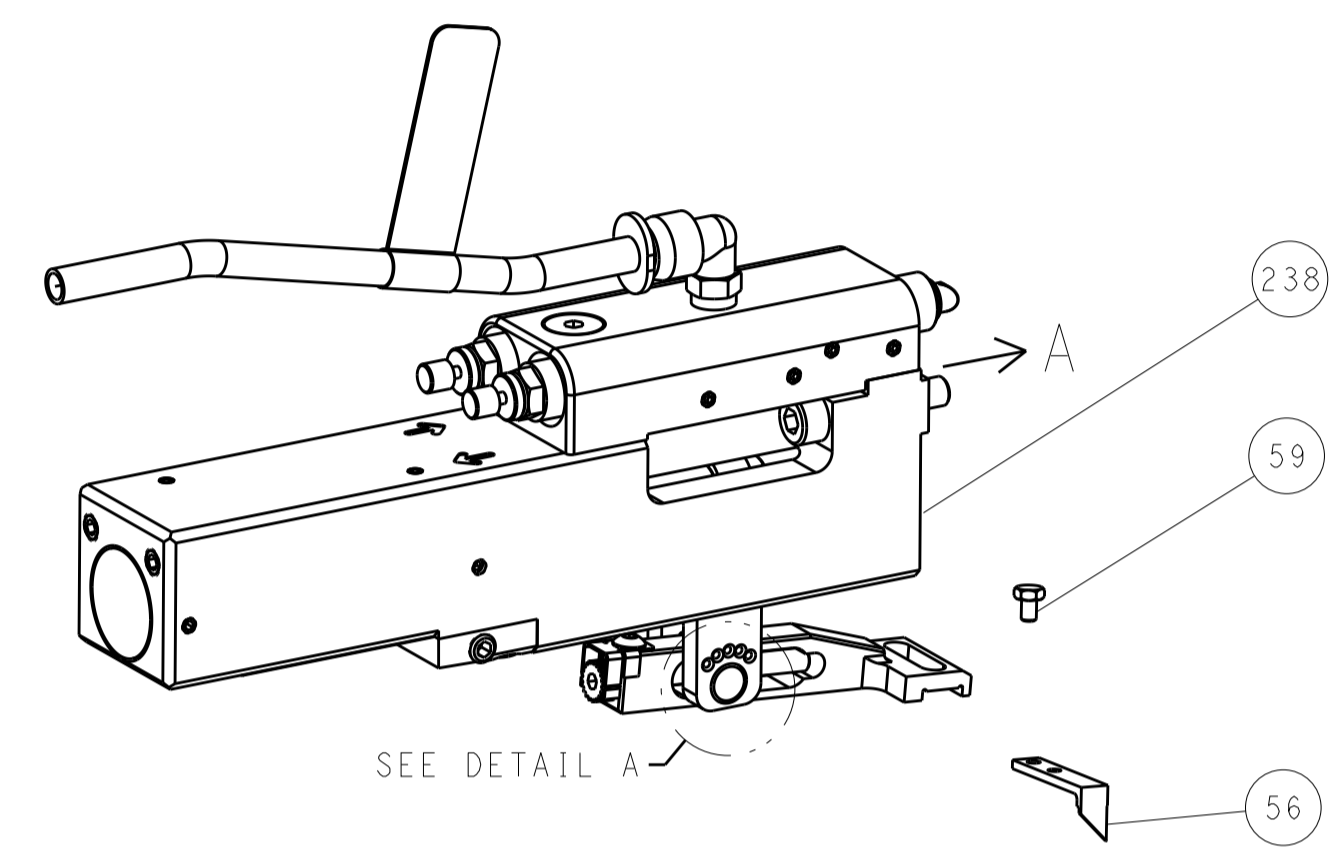
ITEM NO	77-22-21	PART NO		DESCRIPTION		ITEM NO	
OWN	EL GROSS	03NOV2010		TE Connectivity			
CHK	T. ELBIN	03NOV2010		Harrisburg, PA 17105-3608			
APVD	J. CRUZ	03NOV2010		NAME	Ocean Side Feed Applicator		
PRODUCT SPEC				SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
APPLICATION SPEC				A1	00779	2151024	
WEIGHT				Customer Accessible Production Drawing	SCALE	1:2	SHEET 3 OF 4
							REV E

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

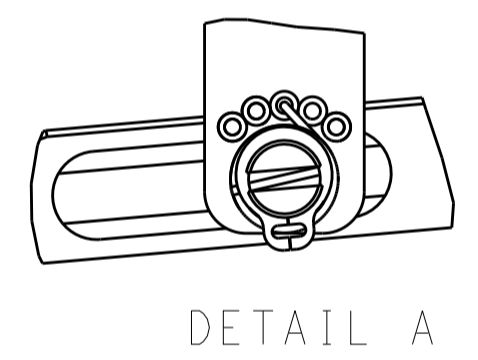
FEED TYPE MECHANICAL



PNEUMATIC

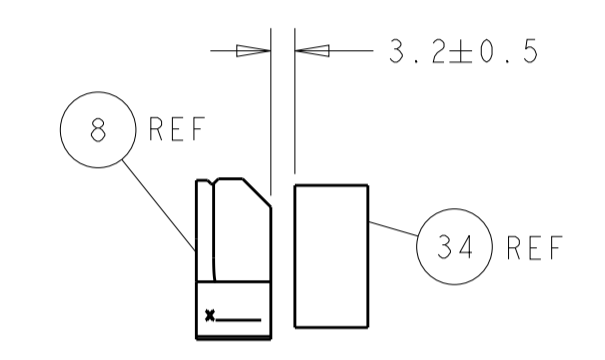
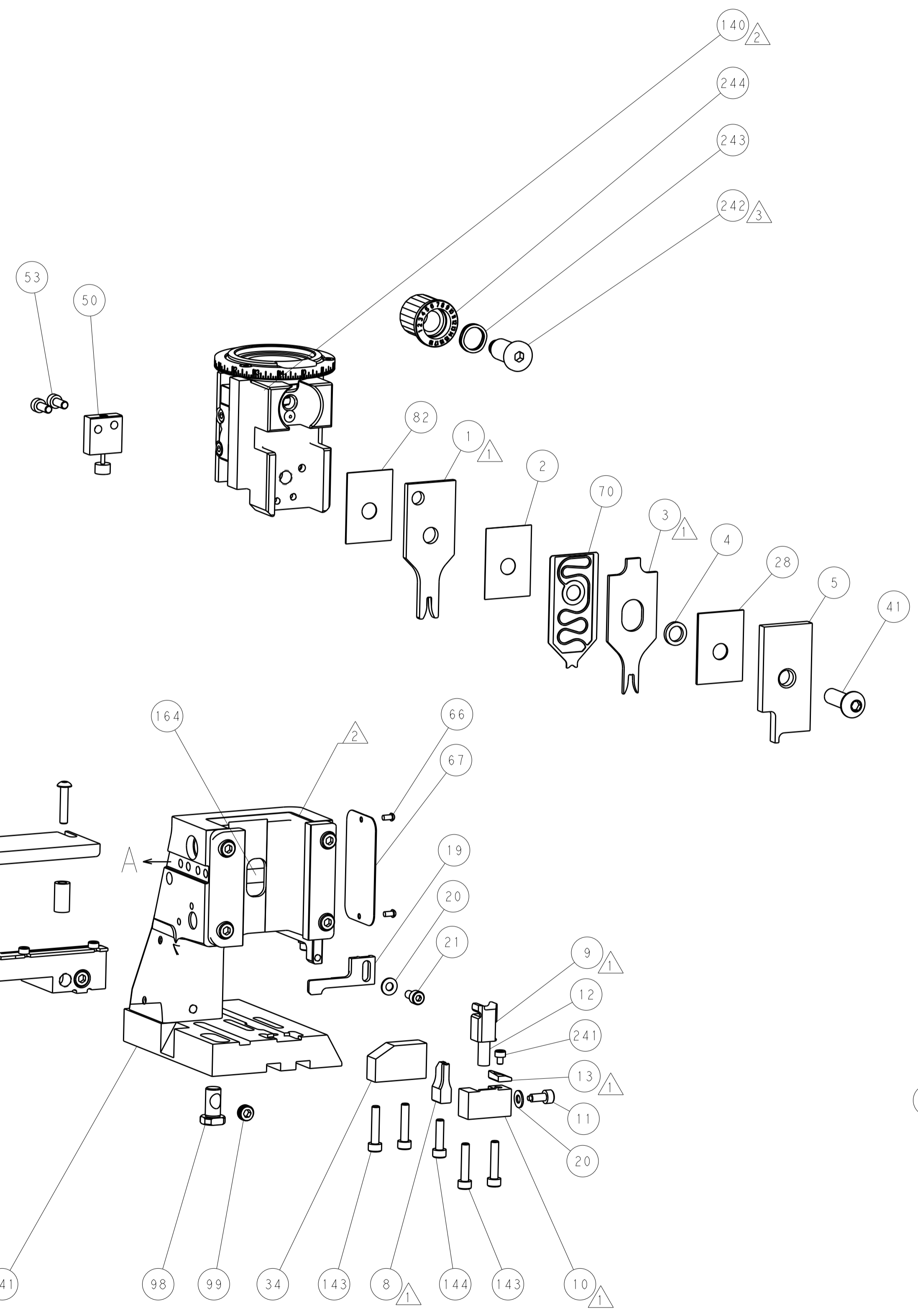
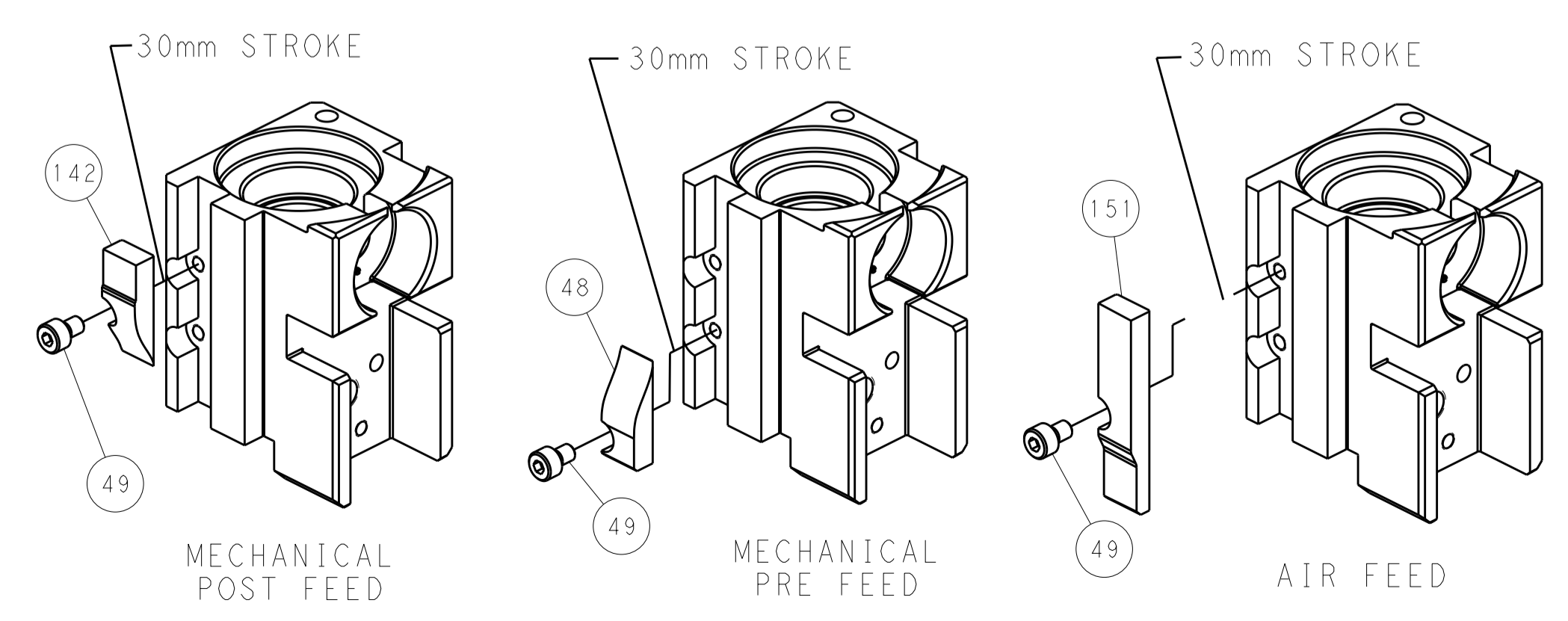


FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)

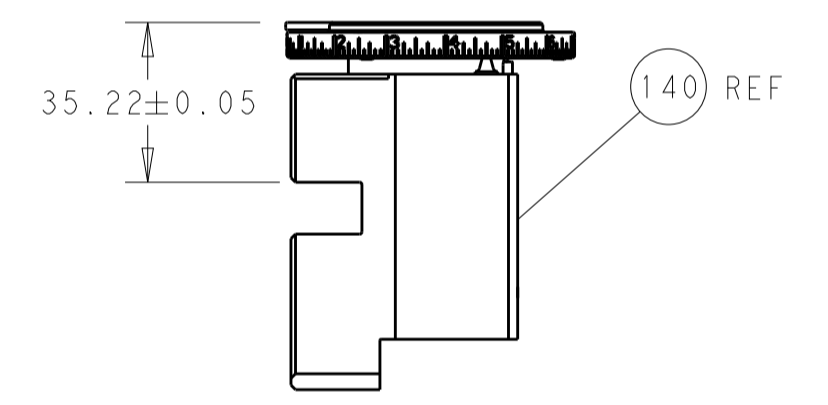


DETAIL A

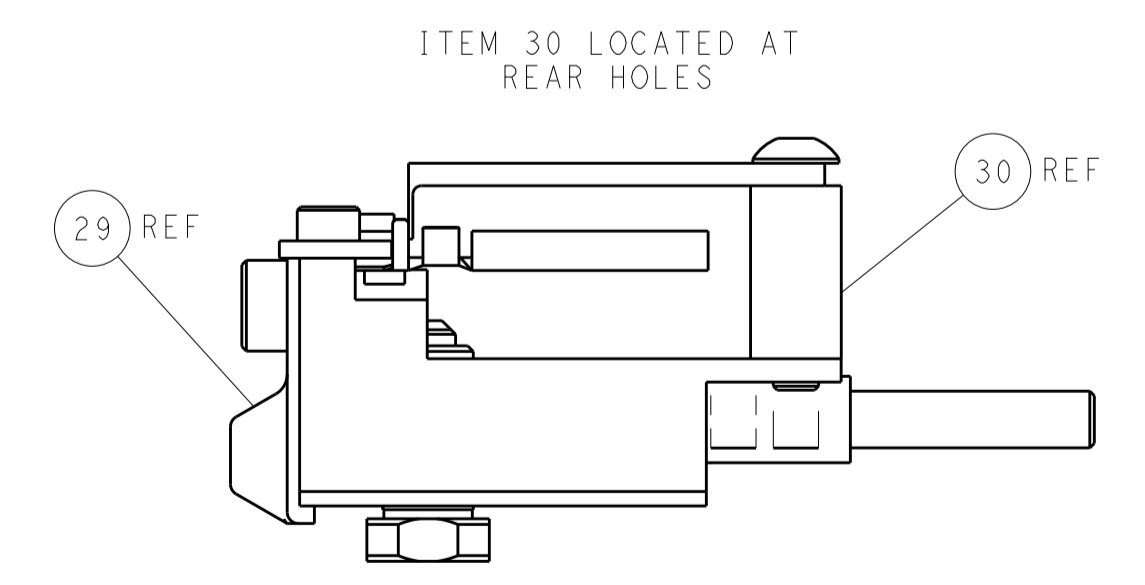
CAM POSITIONS



TERMINAL SUPPORT LOCATION



RAM SET-UP



FEED TRACK POSITION GUIDE BY INSULATION BARREL

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 PROPERTY OF TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE AND WITHOUT WARRANTY OF MERCHANTABILITY. SHOULD BE CONTACTED FOR THE LATEST REVISION.</small>		DWN: 03NOV2010 EL_GROSS: 03NOV2010 CHS: T.ELBIN APVD: J. CRUZ PRODUCT SPEC: 03NOV2010 APPLICATION SPEC:	NAME: Ocean Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2151024 SCALE: 1:2 SHEET: 4 OF 4 REV: E
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± MATERIAL: - FINISH: -		WEIGHT: - RESTRICTED TO: -	CUSTOMER ACCESSIBLE PRODUCTION DRAWING