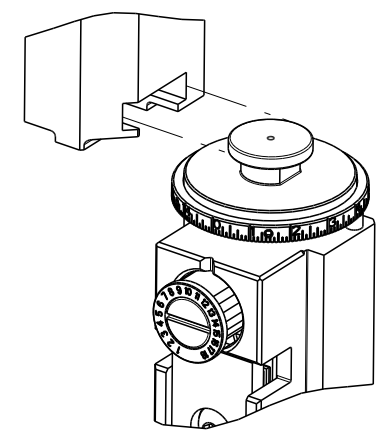


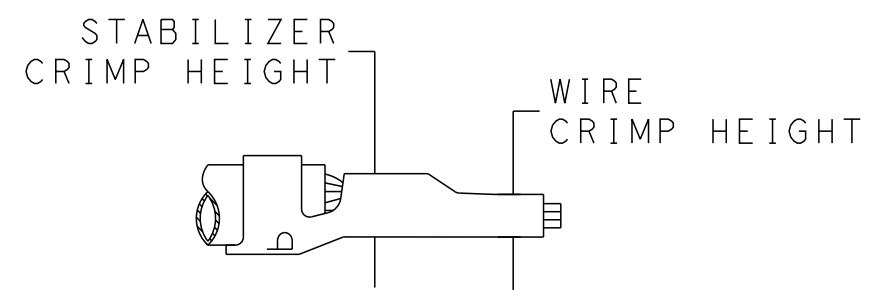
PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151209-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2151209-2	D	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151209-1	C	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2151209-2	D	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2151209-*	B	SEE CRIMP TOOLING KIT BELOW	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.57 mm [.062]	F
STABILIZER	1.57 mm [.062]	F
INSULATION	2.79 mm [1.10]	F

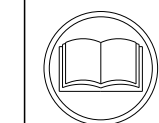
APPLICATOR INSTRUCTIONS  
408-35042



TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: MINI AMP-IN			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
4.45-4.98 mm [1.75-.196 IN]		1.52-2.79 mm [0.60-.110 IN]	
TERMINAL APPLICATION SPECIFICATION	114-1016		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
3-640311-1			

PART NO	REV	WIRE SIZE	WIRE CRIMPER	STABILIZER CRIMPER	INSULATION CRIMPER	ANVIL
7-2151209-7	B	18 AWG	7-1803188-7	1-456403-3	2-2119582-1	1-1633916-4
7-2151209-8	B	22-20 AWG	7-1803188-8	1-456403-3	2-2119582-1	1-1633916-4

WIRE SIZE	CRIMP HEIGHT mm [INCH]	WIRE CRIMPER PART NUMBER	STABILIZER CRIMPER HEIGHT mm [INCH]	STABILIZER CRIMPER PART NUMBER	CRIMP HEIGHT REFERENCE SETTING
18 AWG	0.94+/-0.05 [.037+/-0.002]	7-1803188-7	1.40+/-0.05 [.055+/-0.002]	1-456403-3	5.0
22-20	0.76+/-0.05 [.030+/-0.002]	7-1803188-8			5.0



- 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.
- 5. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- ITEM 1 TO BE USED WITH 18 AWG ONLY. ITEM TO BE SHIPPED WITH APPLICATOR.
- ITEM 253 TO BE USED WITH 22-20 AWG ONLY. ITEM TO BE SHIPPED WITH APPLICATOR.
- ITEM 19 MUST BE POSITIONED BETWEEN ITEMS 1 OR 253 AND ITEM 178.
- WHEN RUNNING APPLICATOR IN BENCH MACHINE WIRE MUST BE PLACED IN WIRE BARREL IN ORDER TO ACHIEVE PROPER BRUSH LENGTH.

**\*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	LTN	DESCRIPTION	DATE	OWN	APVD
		A		RELEASED	08JUN2016	RK	GB
		B		ECR-16-011873	18AUG2016	MZ	JDG
		C		ECR-18-016121	11OCT2018	FL	TE
		D		ECR-21-117796	19OCT2021	LG	TE

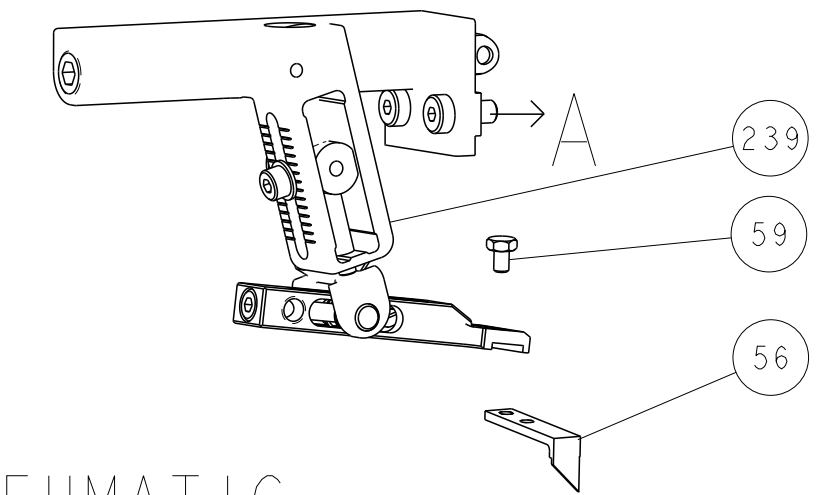
	1	-	1	1	1	1	7-1803188-8	CRIMPER, WIRE	253
	-	-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248
	-	-	1	1	1	1	2119082-4	CAM, SNAIL, INSULATION ADJUSTMENT	244
	-	-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
	3	-	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
	-	-	1	1	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
	-	-	-	1	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
	-	-	1	-	1	-	2844940-1	AIR FEED MODULE	238
	1	1	2	2	1	1	1-456403-3	CRIMPER, WIRE PREMIUM	178
	-	-	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
	-	-	1	1	1	1	455888-8	SPACER, CRIMPER	128
	-	-	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	2-2844962-6	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
	8	-	1	1	1	1	2119533-4	STRIPPER, SIDE FEED	19
	1	-	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	1	2119805-1	SHEAR HOLDER, FRONT	10
	1	-	1	1	1	1	1803095-1	FLOATING SHEAR, FRONT	9
	1	1	2	2	1	1	1-1633916-4	ANVIL, COMBINATION	8
	-	-	-	-	-	-	-	-	7
	-	-	-	-	-	-	-	-	6
	-	-	1	1	1	1	2119757-8	DEPRESSOR, SHEAR	5
	-	-	1	1	1	1	2-238011-2	BLOCK, CRIMPER SPACER	4
	1	1	2	2	1	1	2-2119582-1	CRIMPER, INSULATION F PREMIUM	3
	-	-	-	-	-	-	-	-	2
	6	1	2	2	1	1	7-1803188-7	CRIMPER, WIRE	1

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

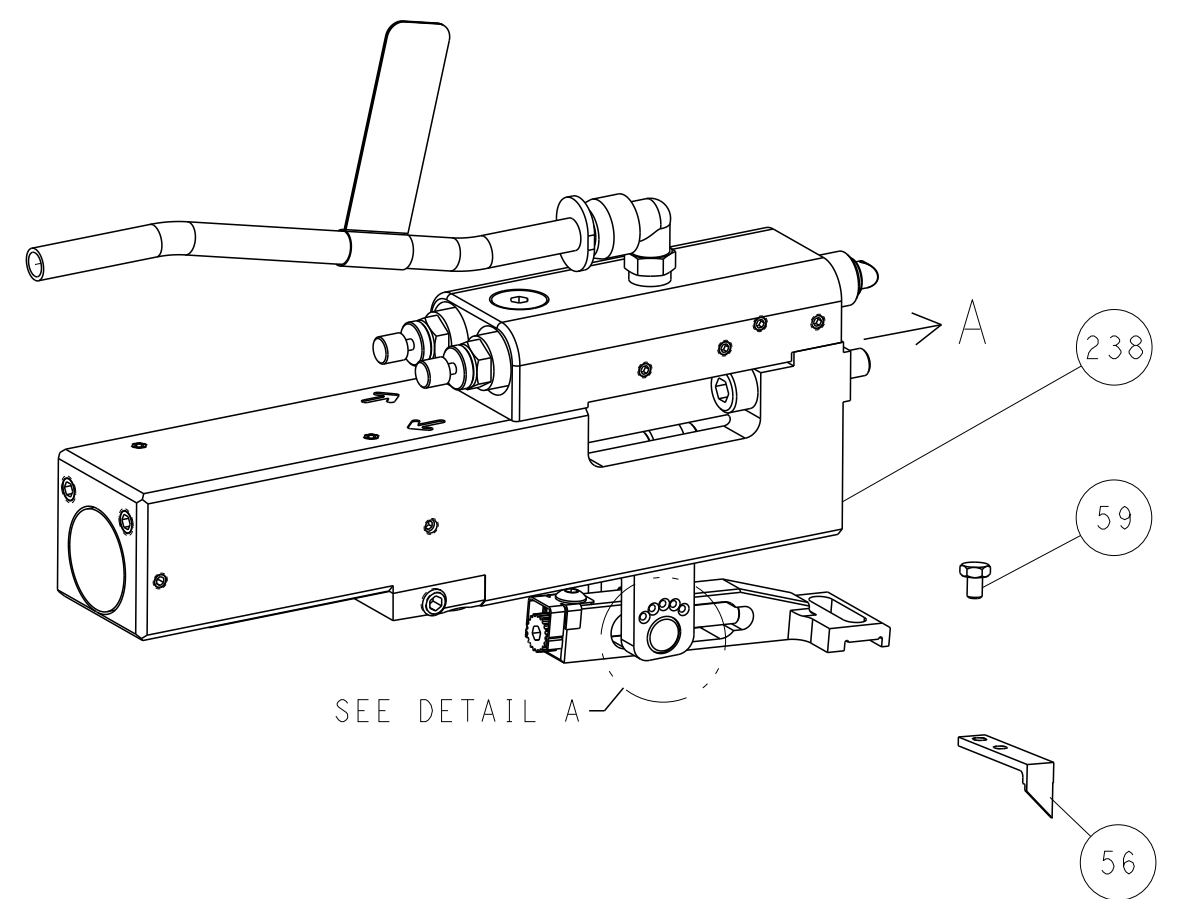
<small>THIS IS THE ONLY DRAWING TO BE USED FOR THE FABRICATION OF THIS PRODUCT. ANY CHANGES TO THE DESIGN OR DIMENSIONS MUST BE APPROVED BY THE DESIGN ENGINEER AND THE MANUFACTURING ENGINEER. ANY CHANGES TO THE DESIGN OR DIMENSIONS MUST BE APPROVED BY THE DESIGN ENGINEER AND THE MANUFACTURING ENGINEER. ANY CHANGES TO THE DESIGN OR DIMENSIONS MUST BE APPROVED BY THE DESIGN ENGINEER AND THE MANUFACTURING ENGINEER.</small>		DWG: M. RILEY 09-JUN-16 CHK: R. KNEPPER 09-JUN-16 APVD: G. BAILEY 09-JUN-16	TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±	NAME: Ocean Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2151209 RESTRICTED TO: - WEIGHT: - SCALE: 1:2 SHEET: 1 OF 4 REV: D
MATERIAL: - FINISH: -		APPLICATION SPEC: - WEIGHT: - SCALE: 1:2 SHEET: 1 OF 4 REV: D	Customer Accessible Production Drawing

LOC	DIST	REV	DATE	BY	APPV
A	66	-	-	-	-
REVISIONS			DESCRIPTION	DATE	BY
-			SEE SHEET 1	-	-

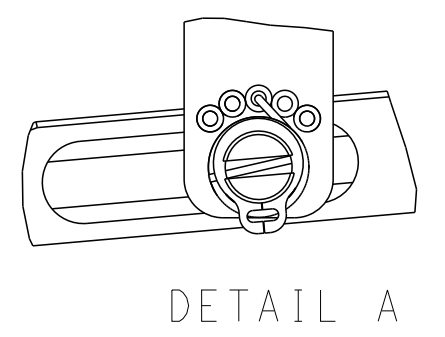
# FEED TYPE MECHANICAL



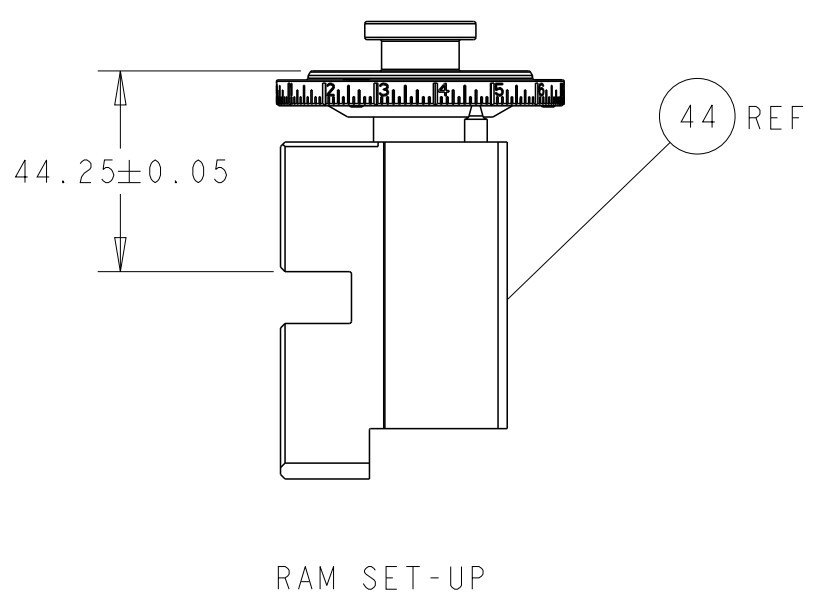
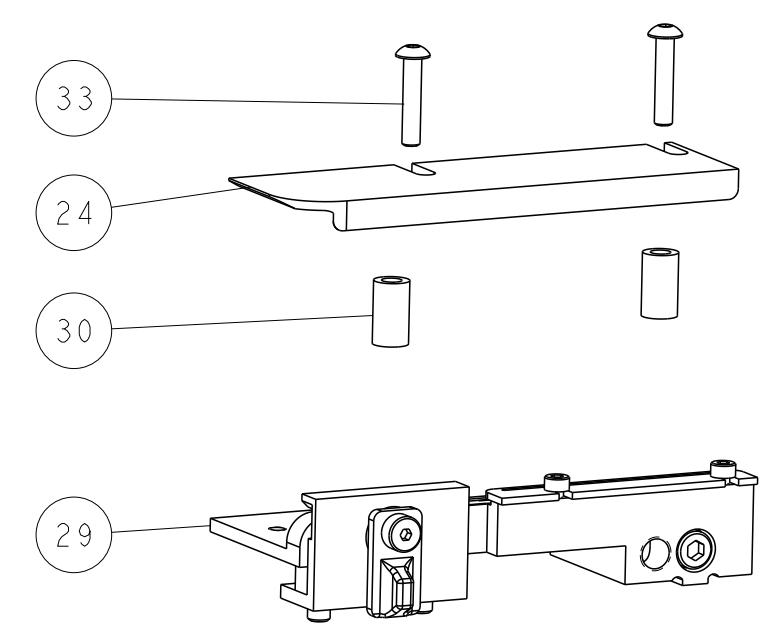
## PNEUMATIC



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

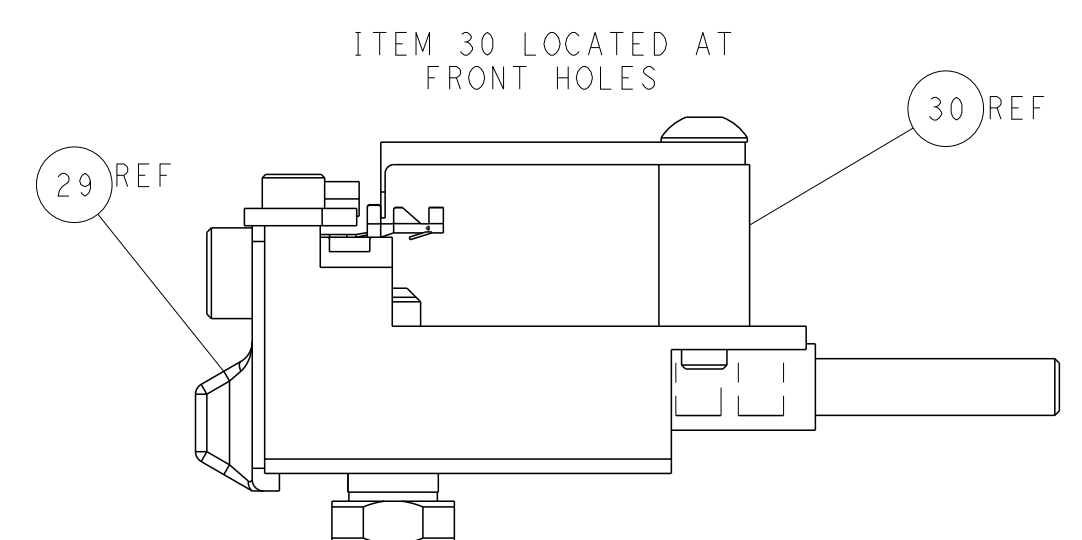
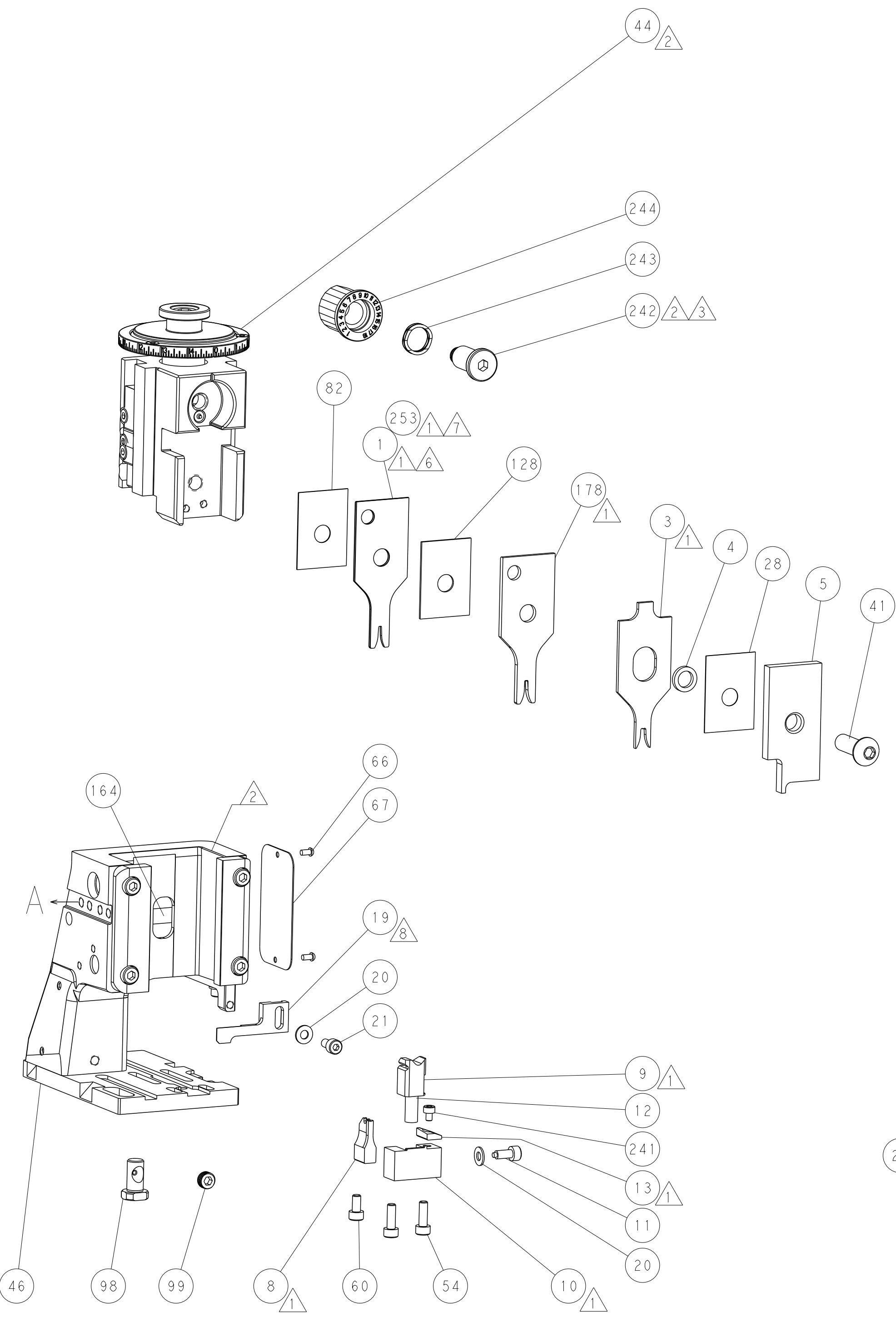
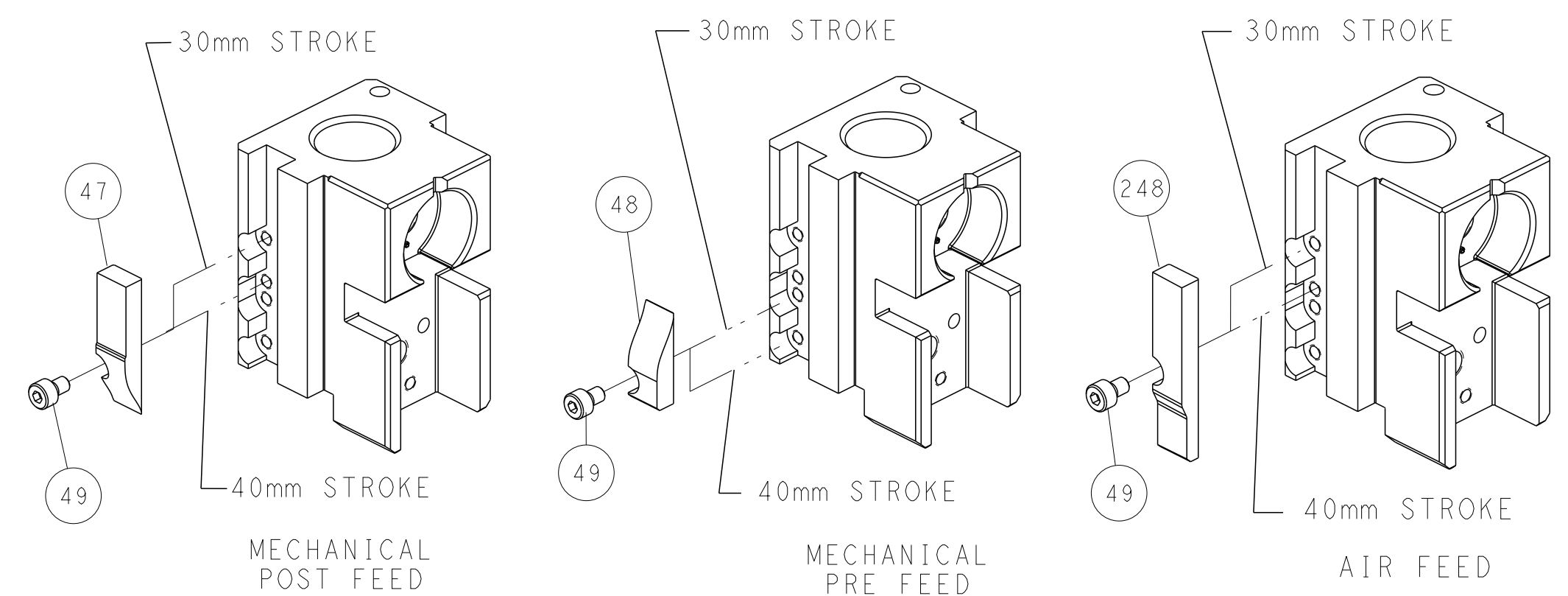


DETAIL A



RAM SET-UP

# CAM POSITIONS



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)

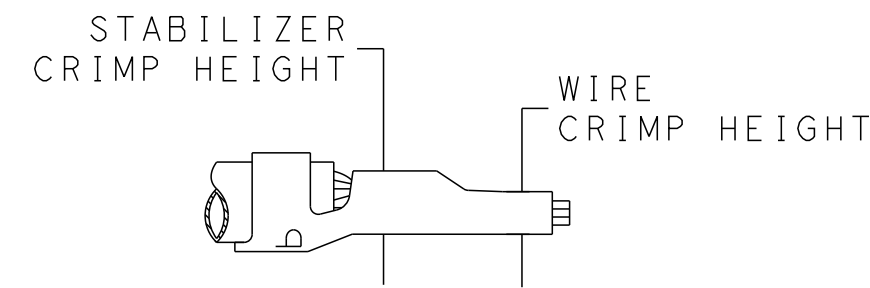
DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH ±		DWN M. RILEY 09-JUN-16 CHK R. KNEPPER 09-JUN-16 APVD G. BAILEY 09-JUN-16 NAME Ocean Side Feed Applicator SIZE CAGE CODE DRAWING NO RESTRICTED TO A1 00779 C=2151209 Customer Accessible Production Drawing SCALE 1:2 SHEET 2 OF 4 REV D	
THIS DRAWING IS CONTROLLED DOCUMENT FOR THE ELECTRONICS CORPORATION IT IS THE USER'S RESPONSIBILITY TO CONTACT THE ELECTRONICS CORPORATION TO OBTAIN THE LATEST REVISIONS AND TO CONTACT THE ELECTRONICS CORPORATION TO OBTAIN THE LATEST REVISIONS.				TE Connectivity Harrisburg, PA 17105-3608	

THIS DRAWING IS UNPUBLISHED.	RELEASED FOR PUBLICATION		
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2151209-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2151209-2	D	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151209-*	B	SEE CRIMP TOOLING KIT BELOW	-

PACIFIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.57 mm [.062]	F
STABILIZER	1.57 mm [.062]	F
INSULATION	2.79 mm [.110]	F
APPLICATOR INSTRUCTIONS 408-35042		



TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: MINI AMP-IN			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
4.45-4.98 mm [1.175-.196 IN]		1.52-2.79 mm [.060-.110 IN]	
TERMINAL APPLICATION SPECIFICATION		TERMINAL APPLICATION SPECIFICATION	
114-1016		-	
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
3-640311-1			

PART NO	REV	WIRE SIZE	WIRE CRIMPER	STABILIZER CRIMPER	INSULATION CRIMPER	ANVIL
7-2151209-7	B	18 AWG	7-1803188-7	1-456403-3	2-2119582-1	1-1633916-4
7-2151209-8	B	22-20 AWG	7-1803188-8	1-456403-3	2-2119582-1	1-1633916-4

WIRE SIZE	CRIMP HEIGHT mm [INCH]	WIRE CRIMPER PART NUMBER	STABILIZER CRIMPER PART NUMBER	STABILIZER CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
18 AWG	0.94+/-0.05 [.037+/-0.002]	7-1803188-7	7-1803188-8	1.40+/-0.05 [.055+/-0.002]	5.0
22-20	0.76+/-0.05 [.030+/-0.002]	7-1803188-8			5.0

- 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.
- 6 ITEM 1 TO BE USED WITH 18 AWG ONLY. ITEM TO BE SHIPPED WITH APPLICATOR.
- 7 ITEM 253 TO BE USED WITH 22-20 AWG ONLY. ITEM TO BE SHIPPED WITH APPLICATOR.
- 8 ITEM 19 MUST BE POSITIONED BETWEEN ITEMS 1 OR 253 AND ITEM 178.
- 9 WHEN RUNNING APPLICATOR IN BENCH MACHINE WIRE MUST BE PLACED IN WIRE BARREL IN ORDER TO ACHIEVE PROPER BRUSH LENGTH.

**\*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			
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		-	SEE SHEET 1	-	-

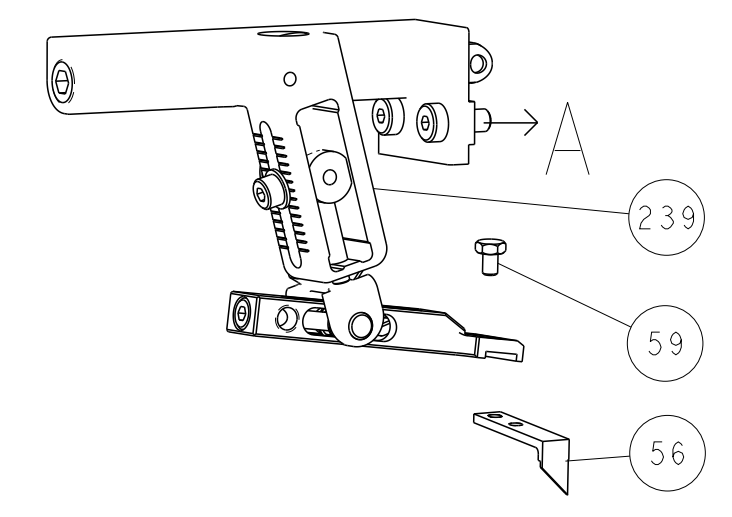
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1	-	1	1	7-1803188-8	CRIMPER, WIRE	253
-	-	1	1	2119082-4	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
3	-	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	-	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
-	-	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	-	1	-	2844940-1	AIR FEED MODULE	238
1	1	1	1	1-456403-3	CRIMPER, WIRE PREMIUM	178
-	-	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
-	-	1	1	455888-8	SPACER, CRIMPER	128
-	-	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	2-2844962-6	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
8	-	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	1803095-1	FLOATING SHEAR, FRONT	9
1	1	1	1	1-1633916-4	ANVIL, COMBINATION	8
-	-	-	-	-	-	7
-	-	-	-	-	-	6
-	-	1	1	2119757-8	DEPRESSOR, SHEAR	5
-	-	1	1	2-238011-2	BLOCK, CRIMPER SPACER	4
1	1	1	1	2-2119582-1	CRIMPER, INSULATION F PREMIUM	3
-	-	-	-	-	-	2
6	1	1	1	7-1803188-7	CRIMPER, WIRE	1

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

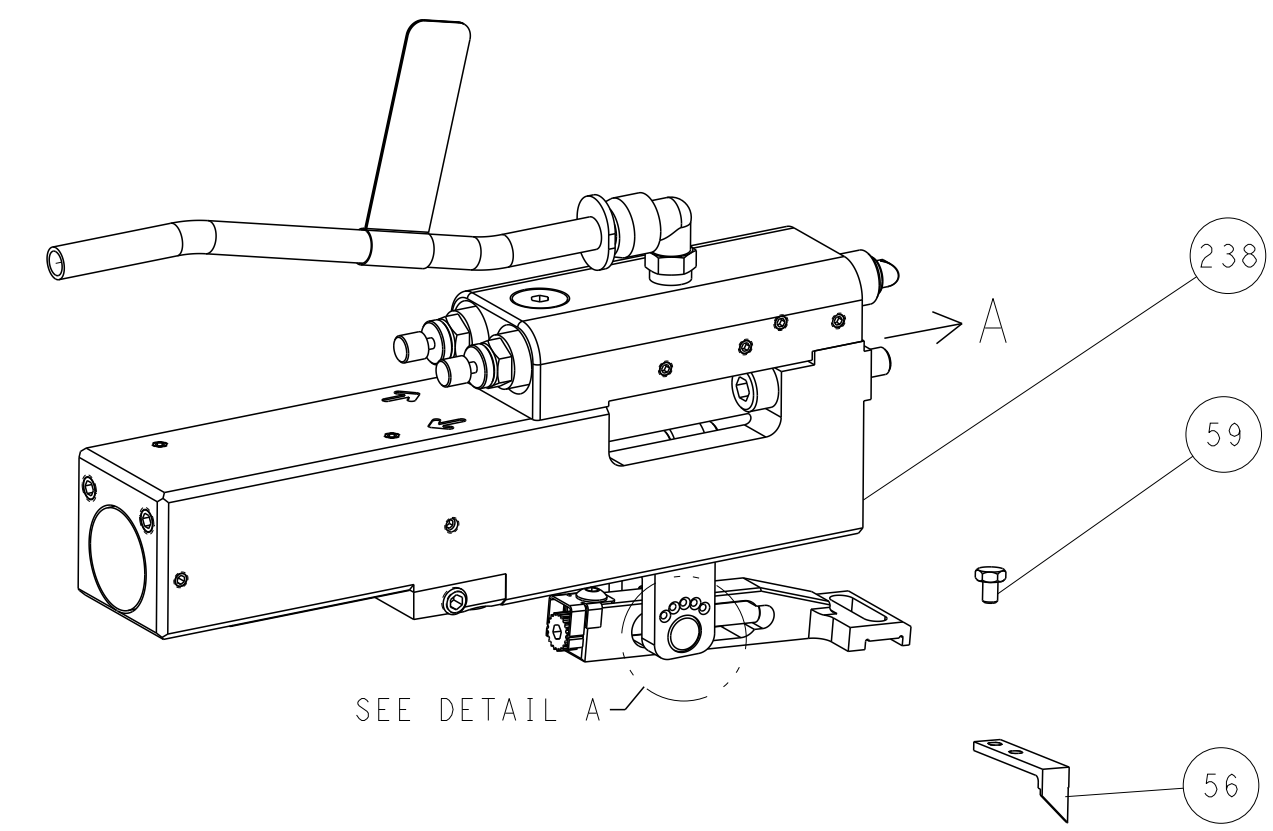
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0 PLC ±		1 PLC ±		2 PLC ±		3 PLC ±		4 PLC ±		SIZE: A1	
ANGLES		FINISH		WEIGHT		SCALE: 1:2		SHEET: 3 of 4		REV: D	
MATERIAL		FINISH		WEIGHT		SCALE: 1:2		SHEET: 3 of 4		REV: D	

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

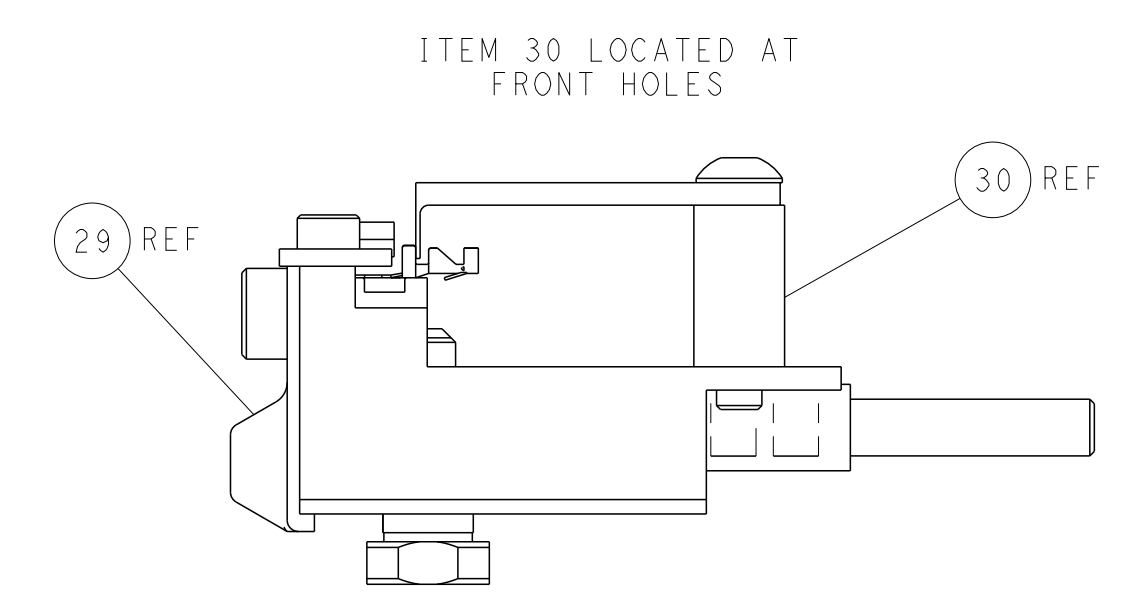
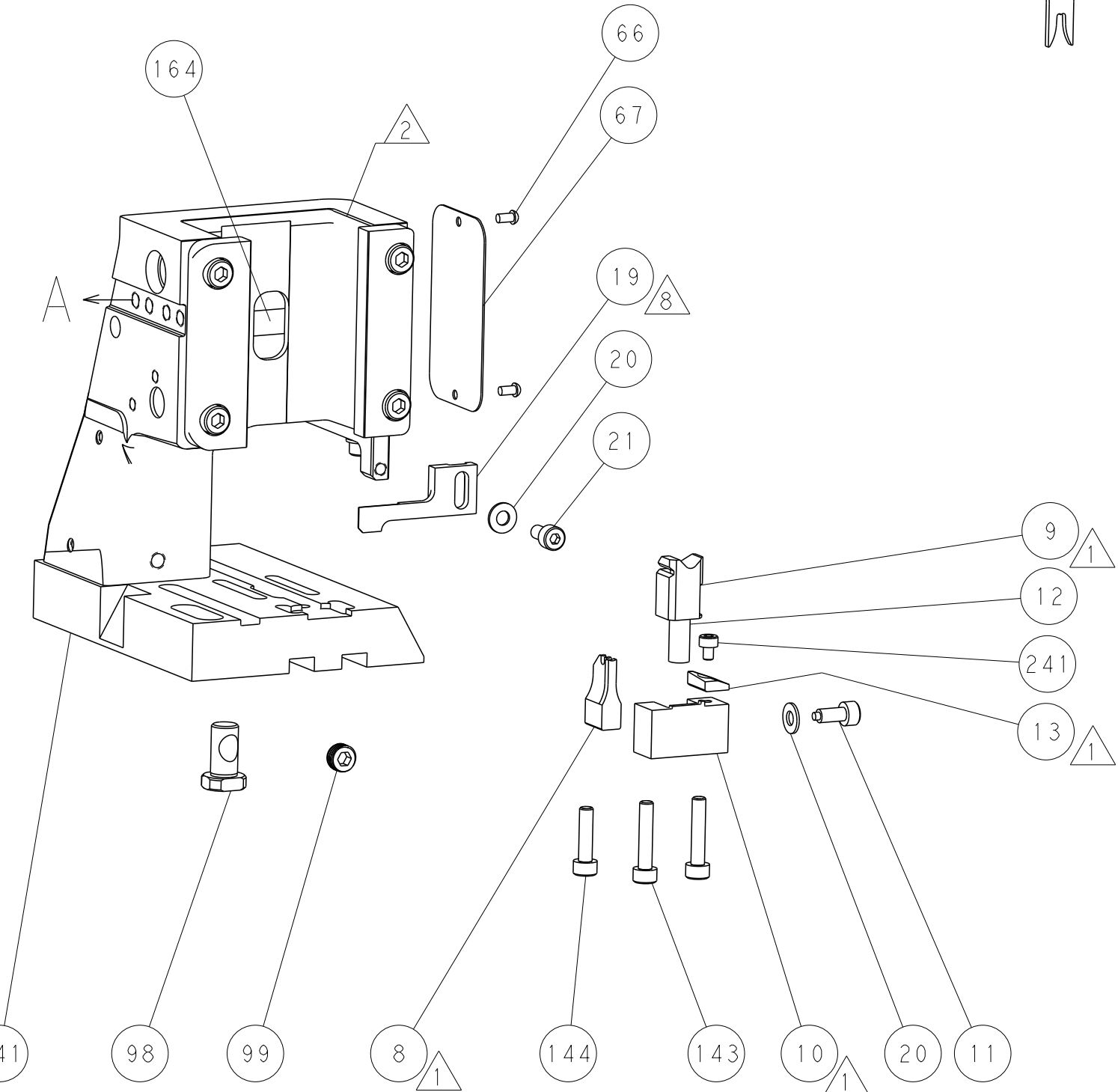
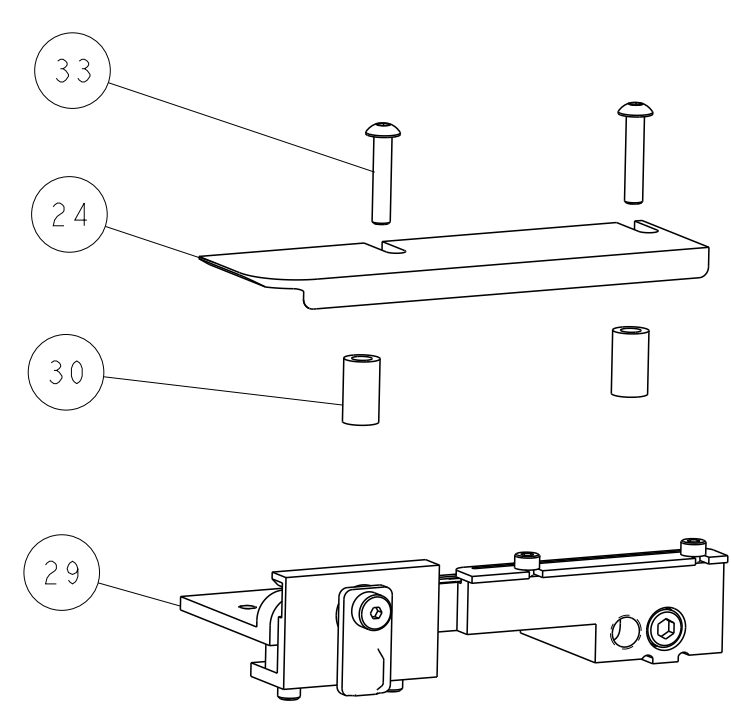
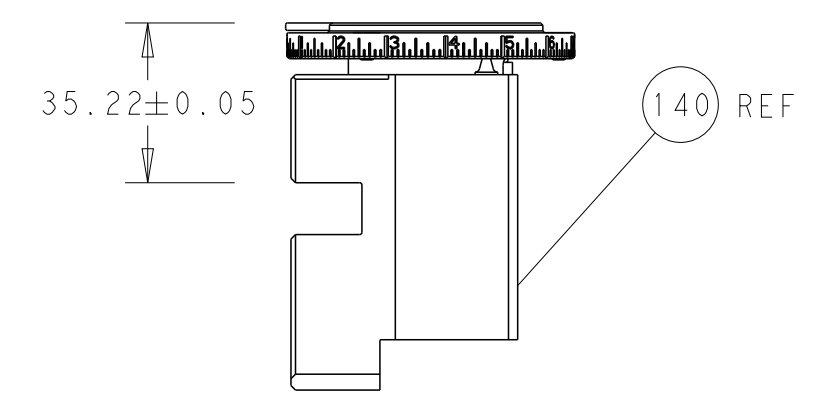
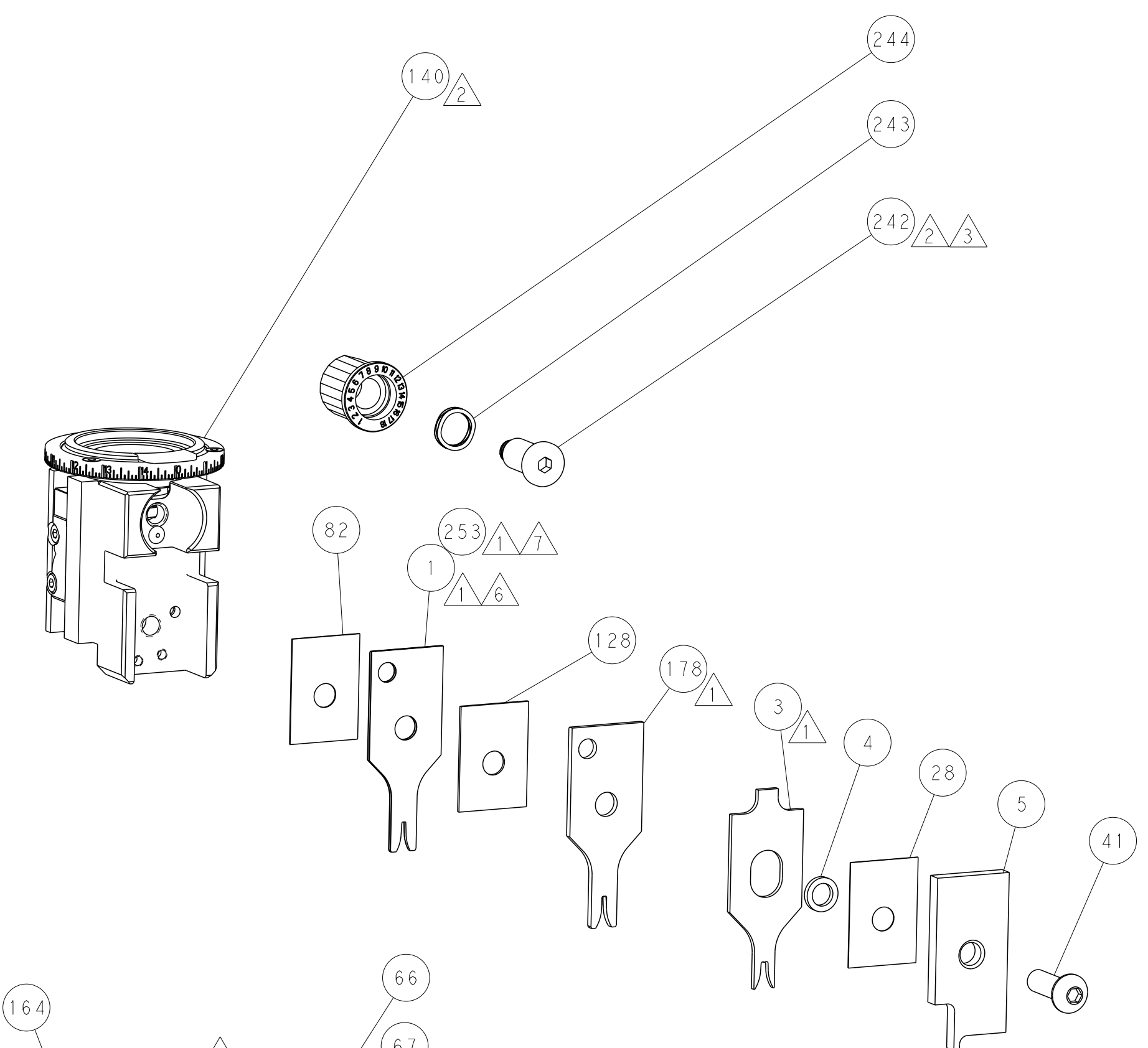
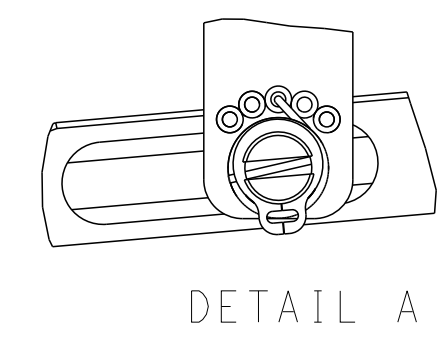
# FEED TYPE MECHANICAL



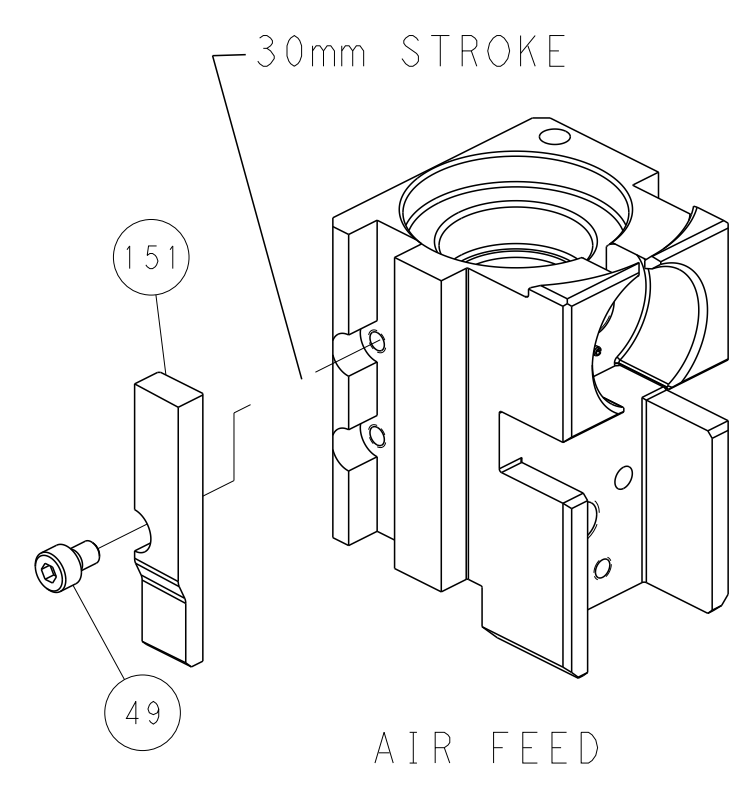
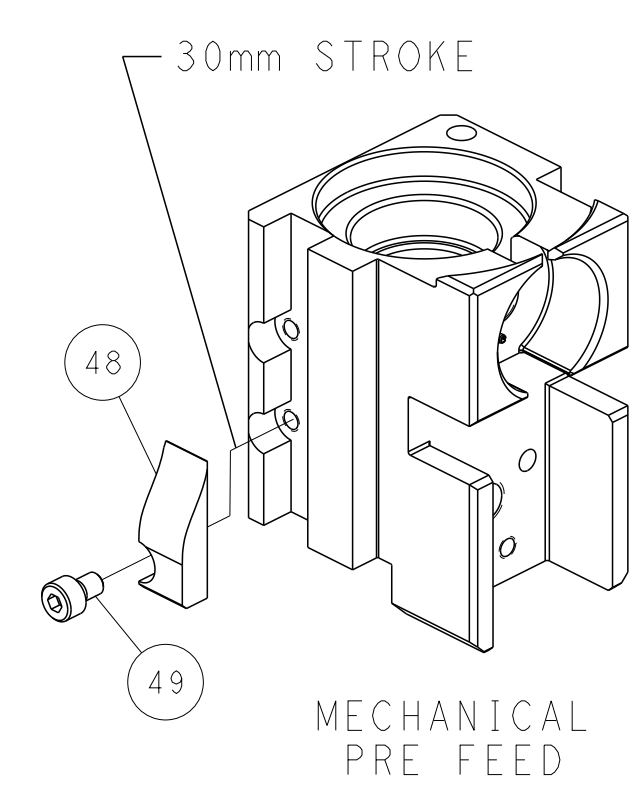
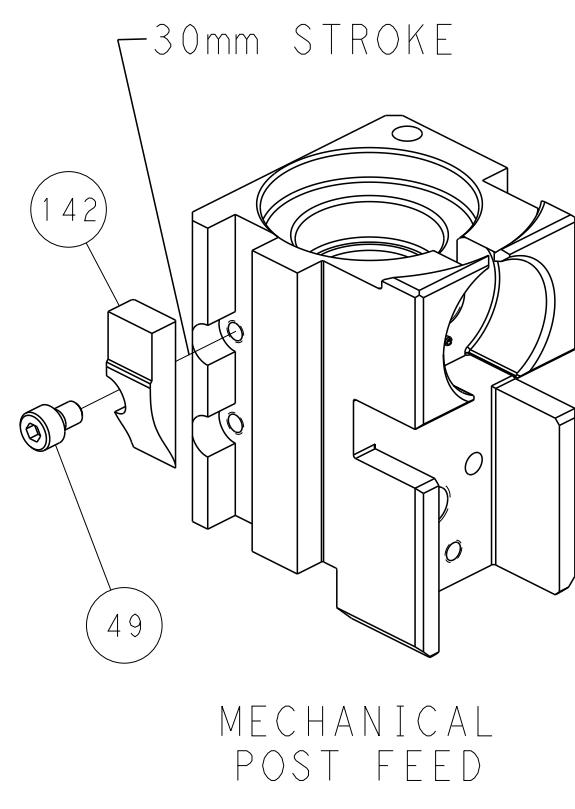
# PNEUMATIC



# 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. ALL RIGHTS RESERVED.</small> <small>THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION. ALL RIGHTS RESERVED.</small>		DMN M. RILEY 09-JUN-16 CHK R. KNEPPER 09-JUN-16 APVD G. BAILEY 09-JUN-16	TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH	TOLERANCES UNLESS OTHERWISE SPECIFIED: ± ± ± ± ±	NAME Ocean Side Feed Applicator	RESTRICTED TO
MATERIAL	WEIGHT	SIZE CAGE CODE DRAWING NO A1 00779 C=2151209	SCALE 1:2 SHEET 4 OF 4 REV D