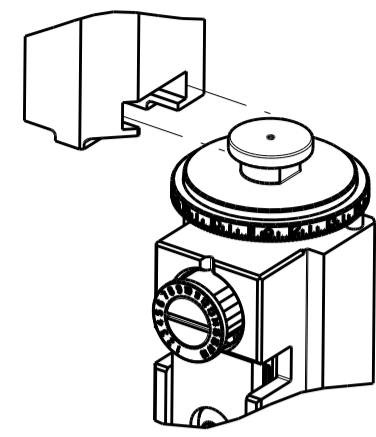


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151206-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2151206-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151206-1	B	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2151206-2	B	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2151206-7	A	CRIMP TOOLING KIT	-

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: MULTILOCK CONTACT			
WIRE STRIP LENGTH 4.00-5.00 mm [.157-.197 IN]		INSULATION DIAMETER RANGE Ø2.16-3.43 mm [.085-.135 IN]	
TERMINAL APPLICATION SPECIFICATION 114-5004			
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
170286-1	170286-2	170286-3	170286-4

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
2.00mm ²	1.78+/-0.05 [.070+/- .002]	4.2
2 X 0.5mm ²	1.50+/-0.05 [.059+/- .002]	7.1
0.85mm ² + 0.5mm ²	1.50+/-0.05 [.059+/- .002]	7.2
1.25mm ²	1.50+/-0.05 [.059+/- .002]	7.2
0.85mm ²	1.34+/-0.05 [.053+/- .002]	8.8
0.50mm ²	1.30+/-0.05 [.051+/- .002]	9.2

- 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. 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)

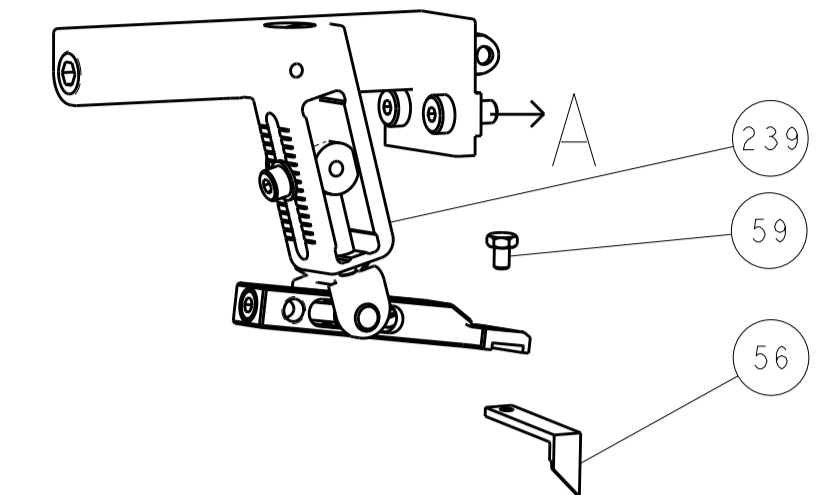
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		A	RELEASED	04DEC2015	LG GB
		A1	ECR-17-012078	18AUG2017	RS LZ
		B	ECR-19-006784	28APR2019	FZ TE

-	1	-	1	-	2119640-1	PUSH ROD, AIR FEED	250					
-	1	-	1	-	1803259-1	BUSHING, FLANGED	249					
-	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	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	-	2063440-1	AIR FEED MODULE	238					
-	2	-	2	-	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172					
-	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164					
-	1	-	1	-	240638-1	SPRING, FEED FINGER	163					
-	1	-	1	-	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854	137					
-	1	-	1	-	2119799-1	HOLDER, FEED FINGER, AF	136					
6	-	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	455888-5	SPACER, CRIMPER	82					
-	1	1	1	1	1803607-1	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	1338683-8	FEED PAWL	56					
-	4	4	4	4	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	54					
-	2	2	2	2	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	53					
-	1	1	1	1	5018030-1	NUT, HEX, REG, RoHS, M3	52					
-	1	1	1	1	811242-5	BUMPER, HOLD DOWN	51					
-	1	1	1	1	690753-2	SPACER, TONKER	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	1752356-3	SUPPORT, TERMINAL	34					
-	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33					
-	2	2	2	2	3-2844962-2	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	2119533-3	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	1803095-6	FLOATING SHEAR, FRONT	9					
1	1	2	2	1	1	2-1633921-2	ANVIL, COMBINATION	8				
-	1	1	1	1	1-240641-1	SPACER	7					
1	-	-	-	-	-	-	6					
-	1	1	1	1	2119757-8	DEPRESSOR, SHEAR	5					
-	1	1	1	1	238011-8	BLOCK, CRIMPER SPACER	4					
1	1	2	2	1	1	2-2119582-4	CRIMPER, INSULATION F PREMIUM	3				
-	1	1	1	1	455888-6	SPACER, CRIMPER	2					
1	1	2	2	1	1	2-456406-3	CRIMPER, WIRE PREMIUM	1				
-	77	-	72	-	71	-	2	-	1	PART NO	DESCRIPTION	ITEM NO

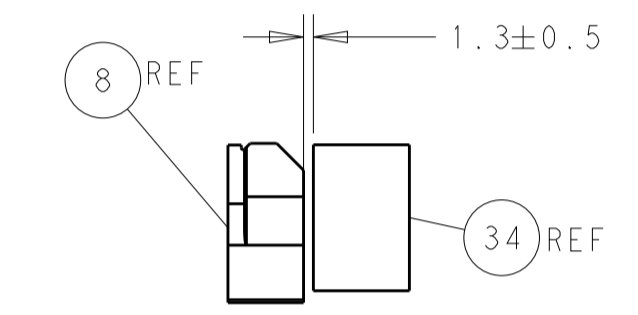
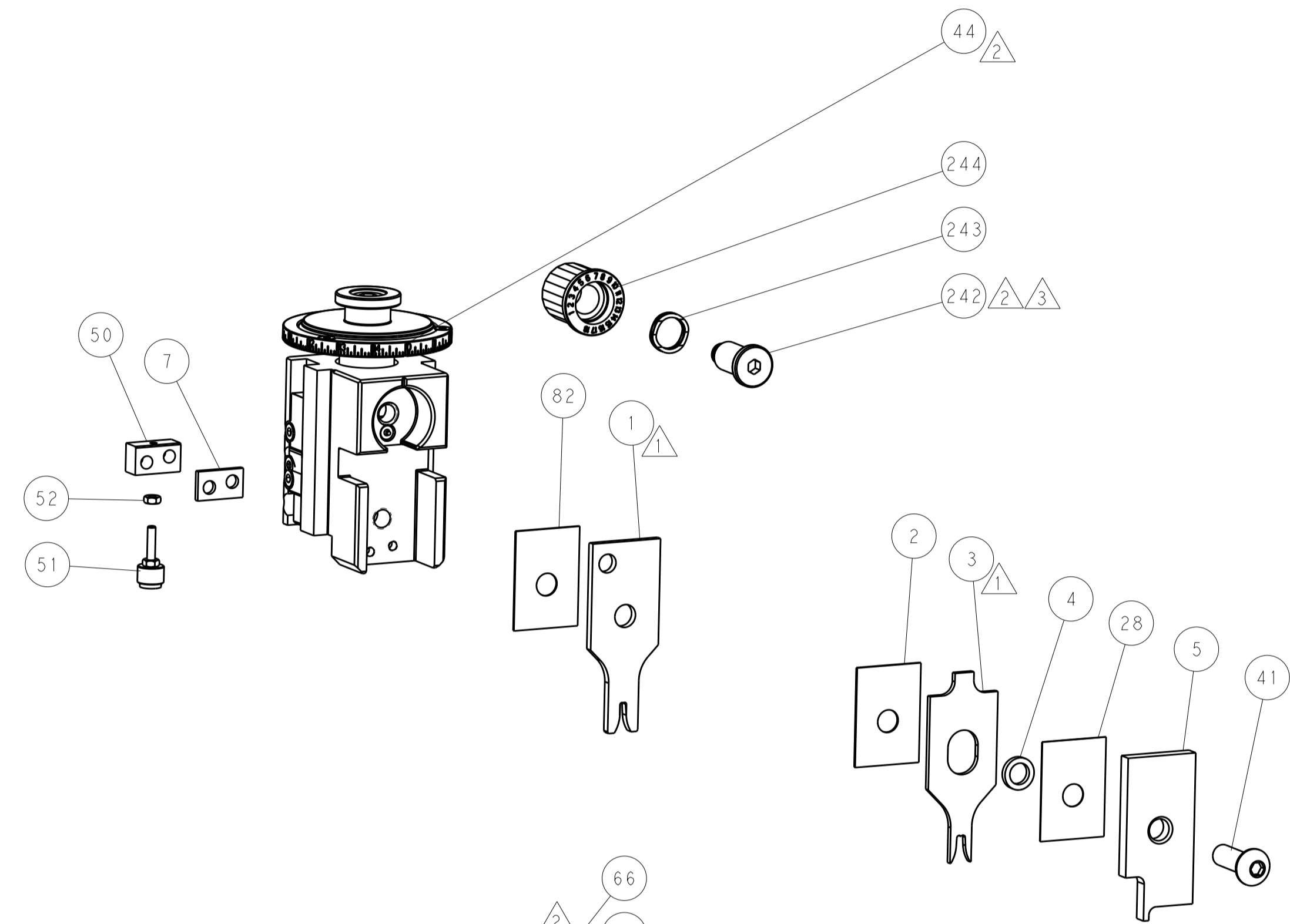
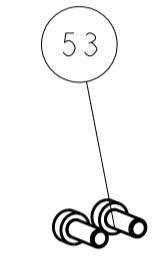
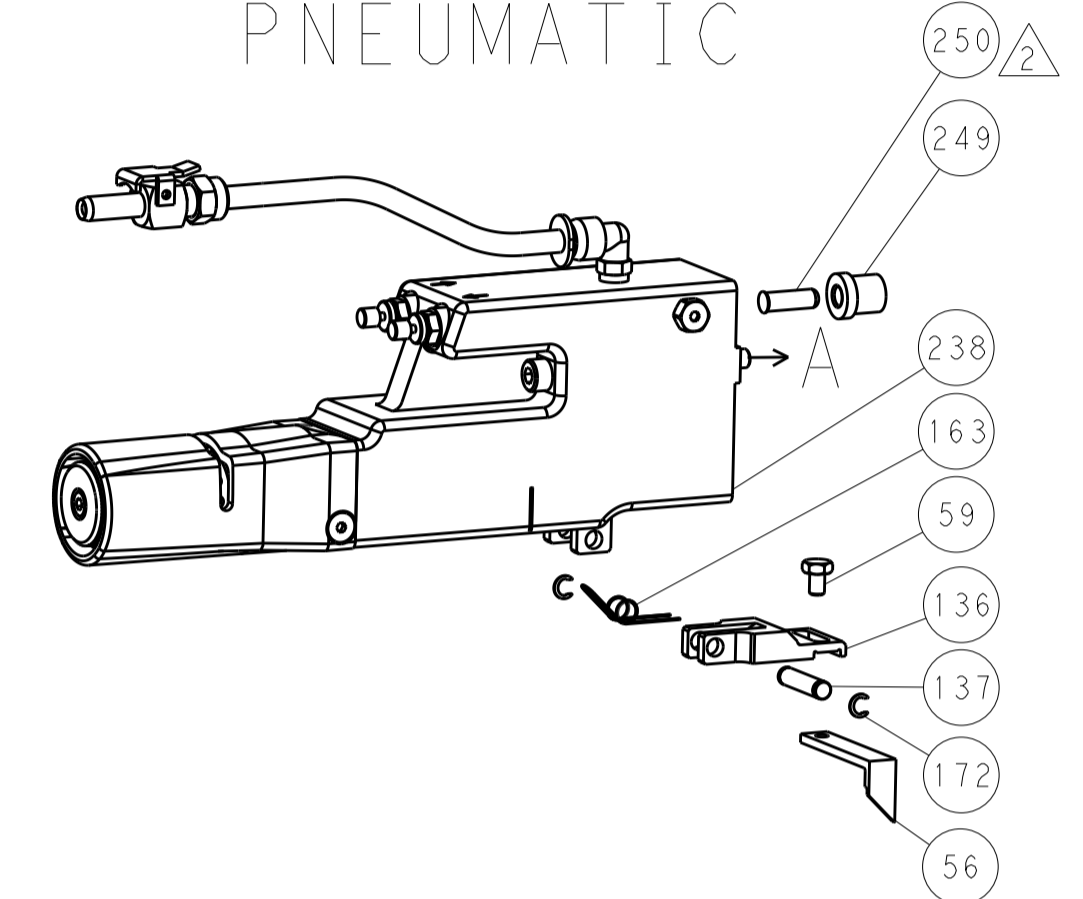
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mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES	FINISH			Customer Accessible Production Drawing	SCALE	1:2	SHEET	1	OF	4	REV	B

LOC	DIST	REV	DATE	BY	CHKD	APVD
A	66					

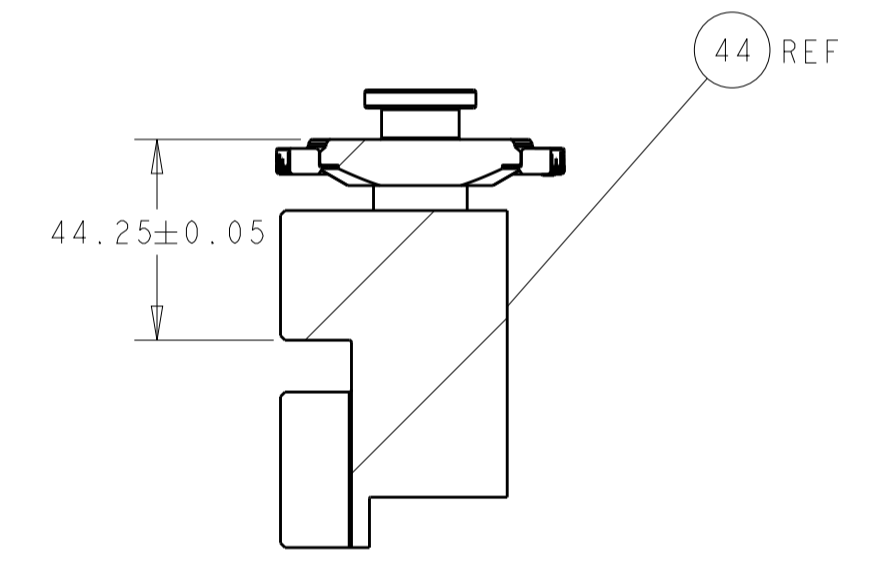
FEED TYPE MECHANICAL



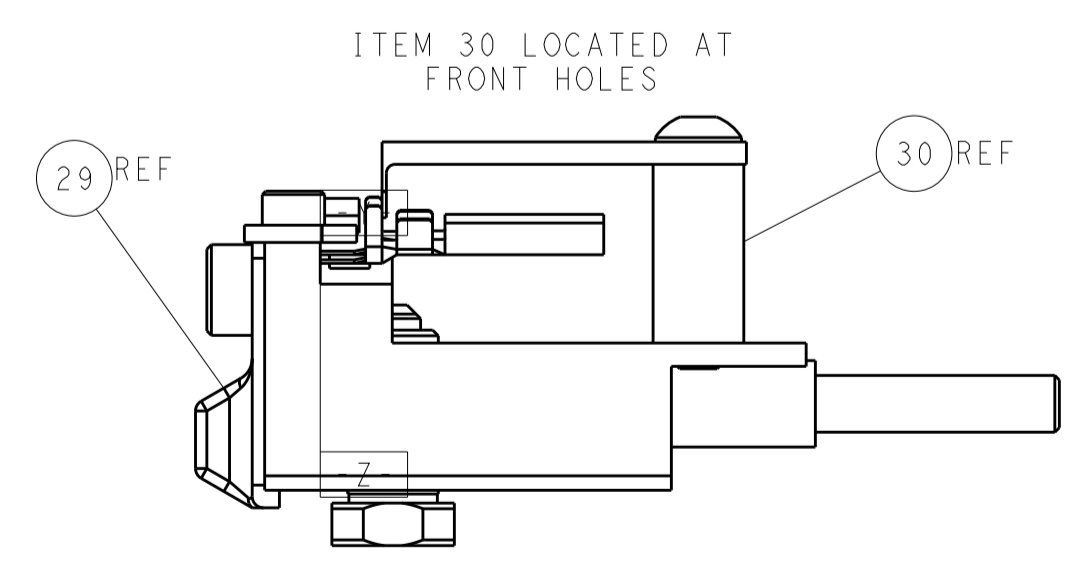
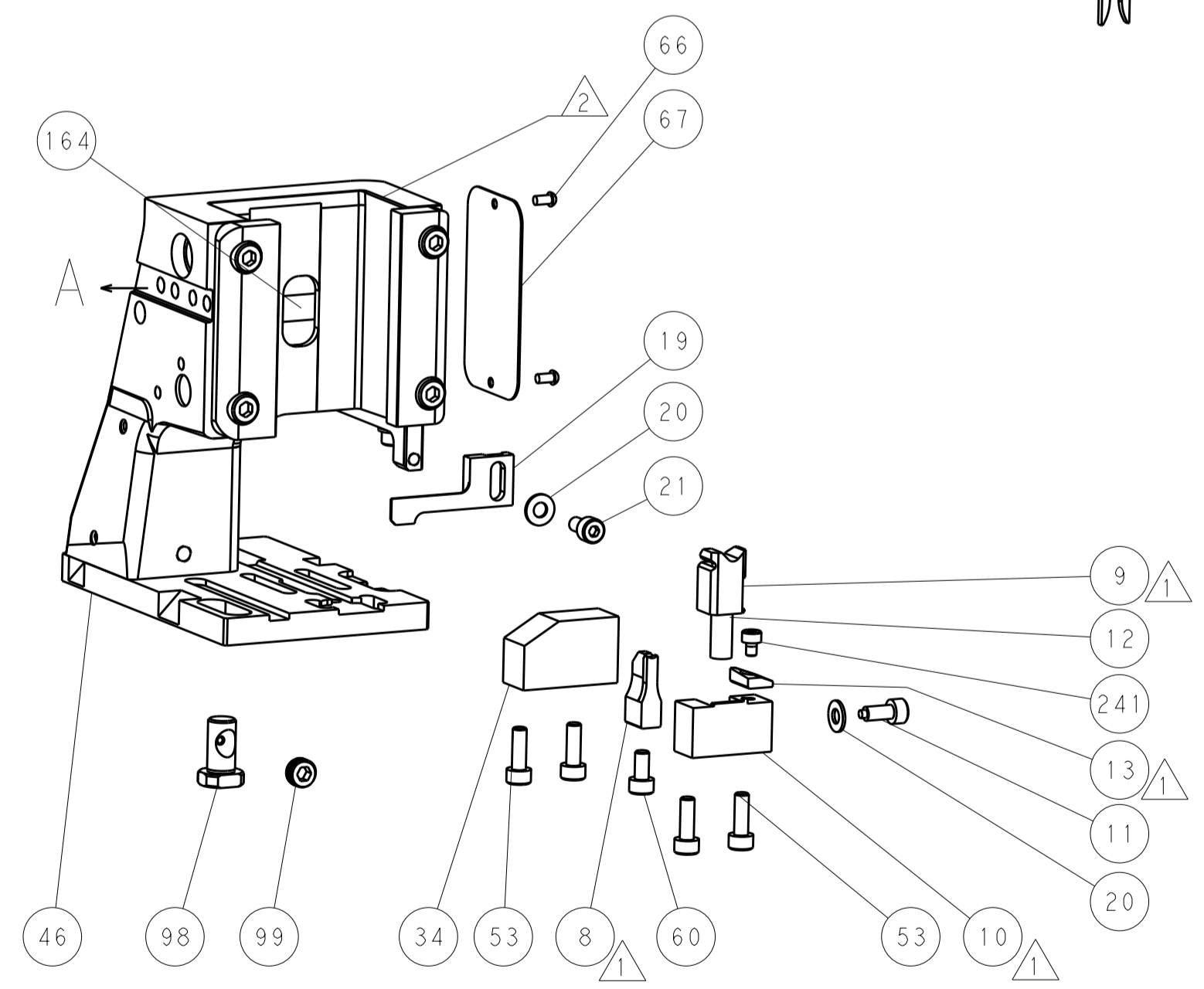
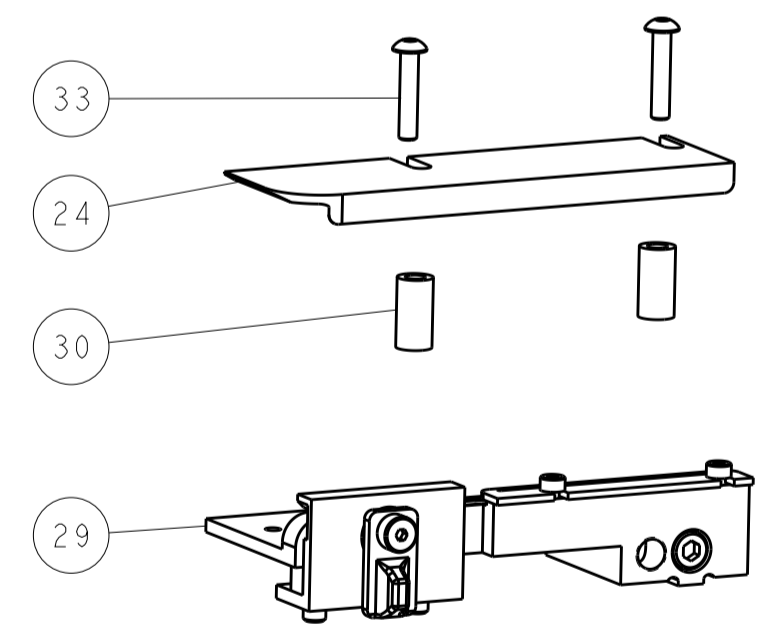
PNEUMATIC



TERMINAL SUPPORT LOCATION

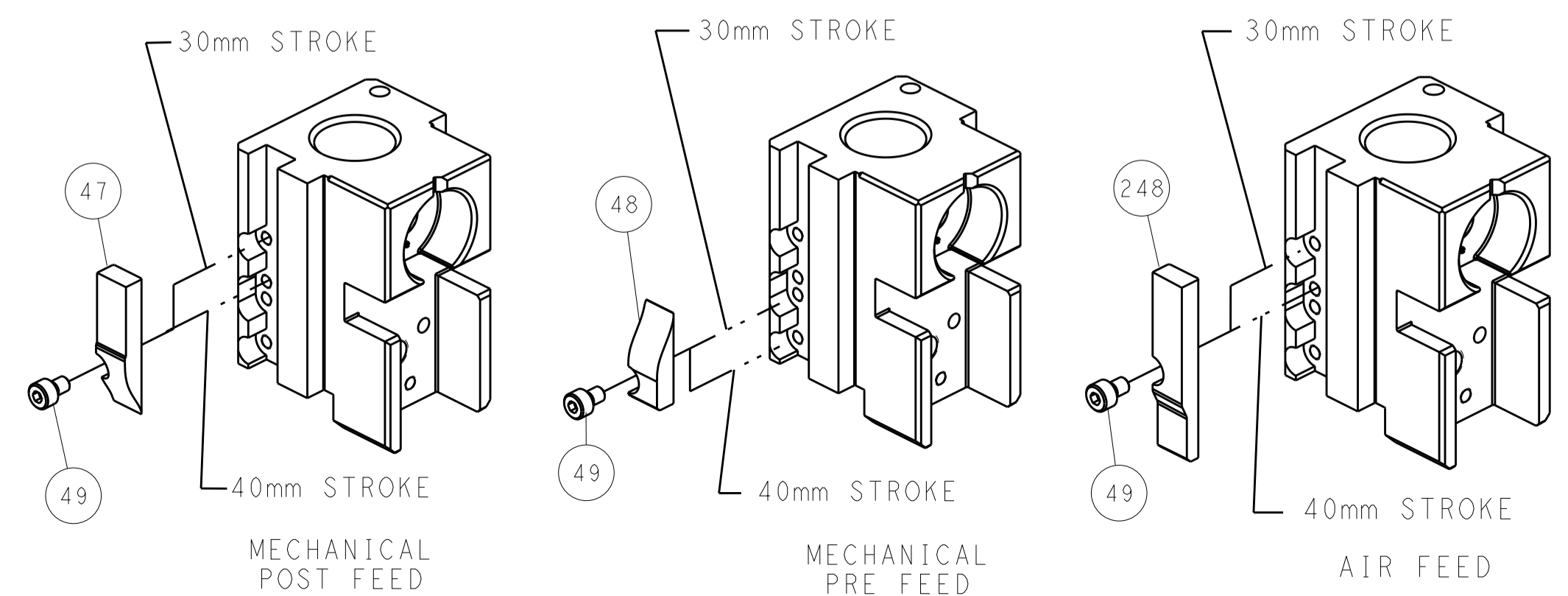


HOLDDOWN SET-UP



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:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN X ZHAO 16OCT2015		TE Connectivity	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	5 PLC ±	Harrisburg, PA 17105-3608
	ANGLES			CHK L ZHANG 16OCT2015		NAME	
				APVD JJ GUO 16OCT2015		Ocean Side Feed Applicator	
MATERIAL	FINISH			PRODUCT SPEC		RESTRICTED TO	
				APPLICATION SPEC		SIZE CAGE CODE DRAWING NO	
				WEIGHT		A1 00779 ©=2151206	
				Customer Accessible Production Drawing		SCALE 1:2 SHEET 2 OF 4 REV B	

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2151206-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2151206-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151206-7	A	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: MULTILOCK CONTACT			
WIRE STRIP LENGTH 4.00-5.00 mm [1.57-.197 IN]		INSULATION DIAMETER RANGE Ø2.16-3.43 mm [.085-.135 IN]	
TERMINAL APPLICATION SPECIFICATION	114-5004	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
170286-1	170286-2	170286-3	170286-4

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
2.00mm ²	1.78+/-0.05 [.070+/-0.002]	4.2
2 X 0.5mm ²	1.50+/-0.05 [.059+/-0.002]	7.1
0.85mm ² + 0.5mm ²	1.50+/-0.05 [.059+/-0.002]	7.2
1.25mm ²	1.50+/-0.05 [.059+/-0.002]	7.2
0.85mm ²	1.34+/-0.05 [.053+/-0.002]	8.8
0.50mm ²	1.30+/-0.05 [.051+/-0.002]	9.2

- 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 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)

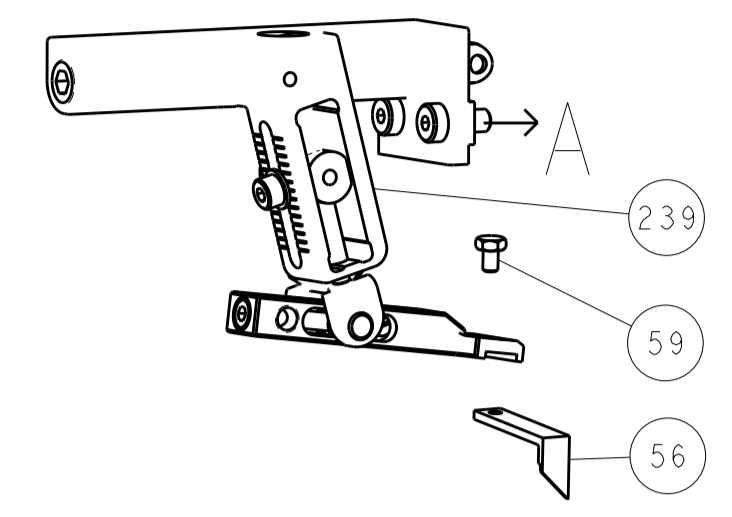
LOC	DIST	REV	DATE	BY	APPV
A	66	-	-	-	-

REV	DATE	BY	APPV	DESCRIPTION	ITEM NO	
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-	1	-	-	1803259-1	BUSHING, FLANGED	249
-	1	1	-	2119082-4	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	-	-	2063440-1	AIR FEED MODULE	238
-	2	-	-	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172
-	REF	REF	-	994970-2	COUNTER, MAGNETIC	164
-	1	-	-	240638-1	SPRING, FEED FINGER	163
-	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	-	-	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854	137
-	1	-	-	2119799-1	HOLDER, FEED FINGER, AF	136
-	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	-	455888-5	SPACER, CRIMPER	82
-	1	1	-	1803607-1	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	-	1338683-8	FEED PAWL	56
-	2	2	-	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	53
-	1	1	-	5018030-1	NUT, HEX, REG, RoHS, M3	52
-	1	1	-	811242-5	BUMPER, HOLD DOWN	51
-	1	1	-	690753-2	SPACER, TONKER	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	-	1752356-3	SUPPORT, TERMINAL	34
-	2	2	-	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	-	3-2844962-2	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	-	2119533-3	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	-	1803095-6	FLOATING SHEAR, FRONT	9
-	1	1	1	2-1633921-2	ANVIL, COMBINATION	8
-	1	1	-	1-240641-1	SPACER	7
-	-	-	-	-	-	6
-	1	1	-	2119757-8	DEPRESSOR, SHEAR	5
-	1	1	-	238011-8	BLOCK, CRIMPER SPACER	4
-	1	1	1	2-2119582-4	CRIMPER, INSULATION F PREMIUM	3
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-	1	1	1	2-456406-3	CRIMPER, WIRE PREMIUM	1

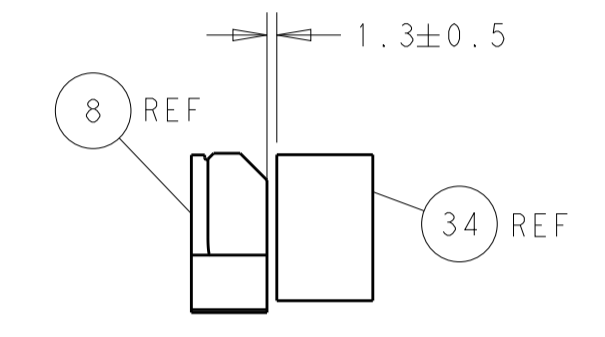
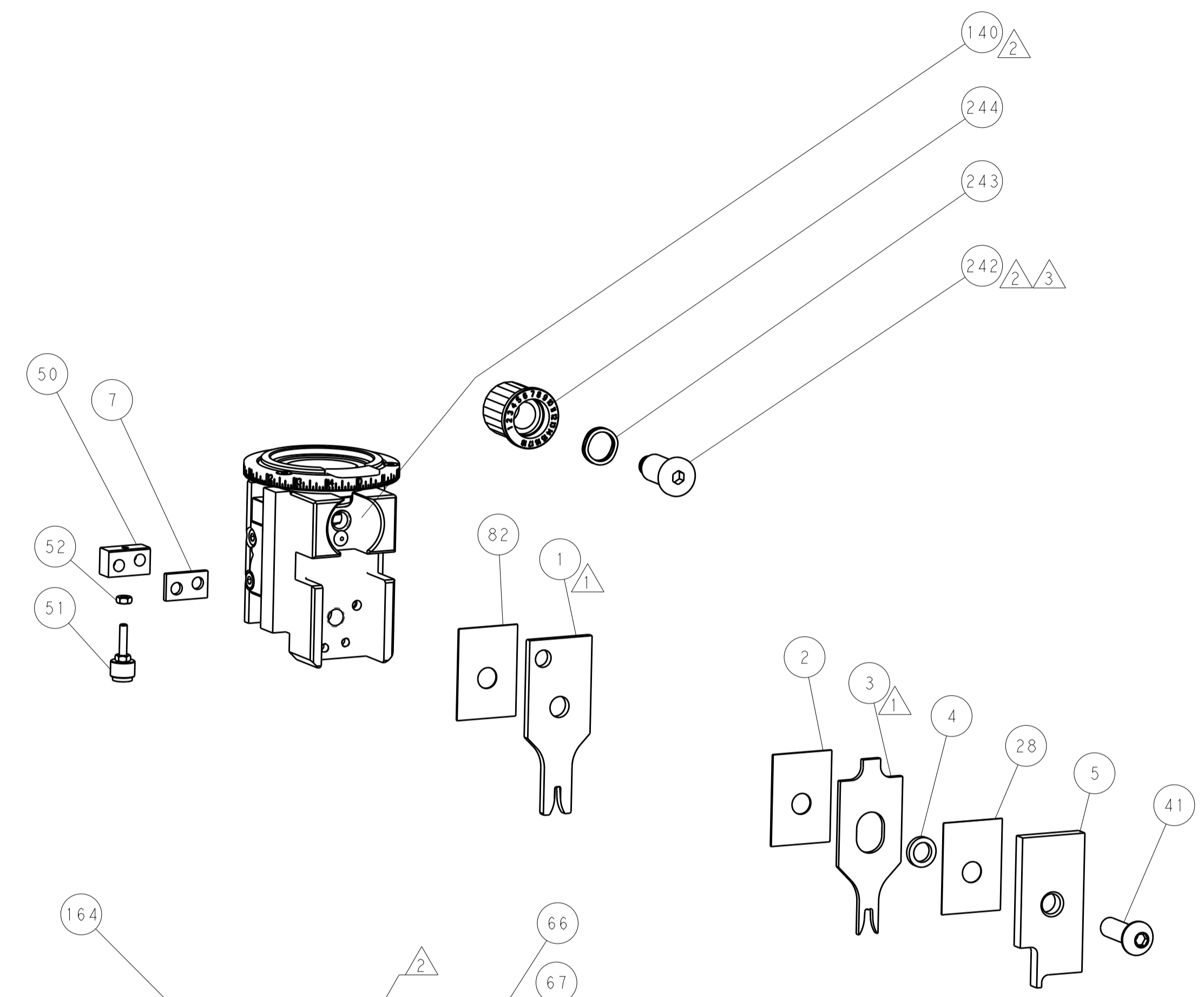
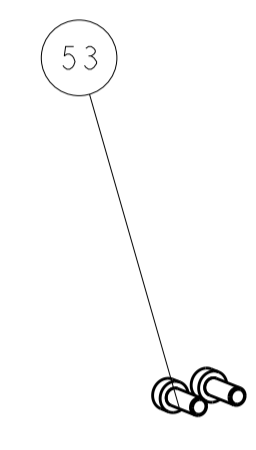
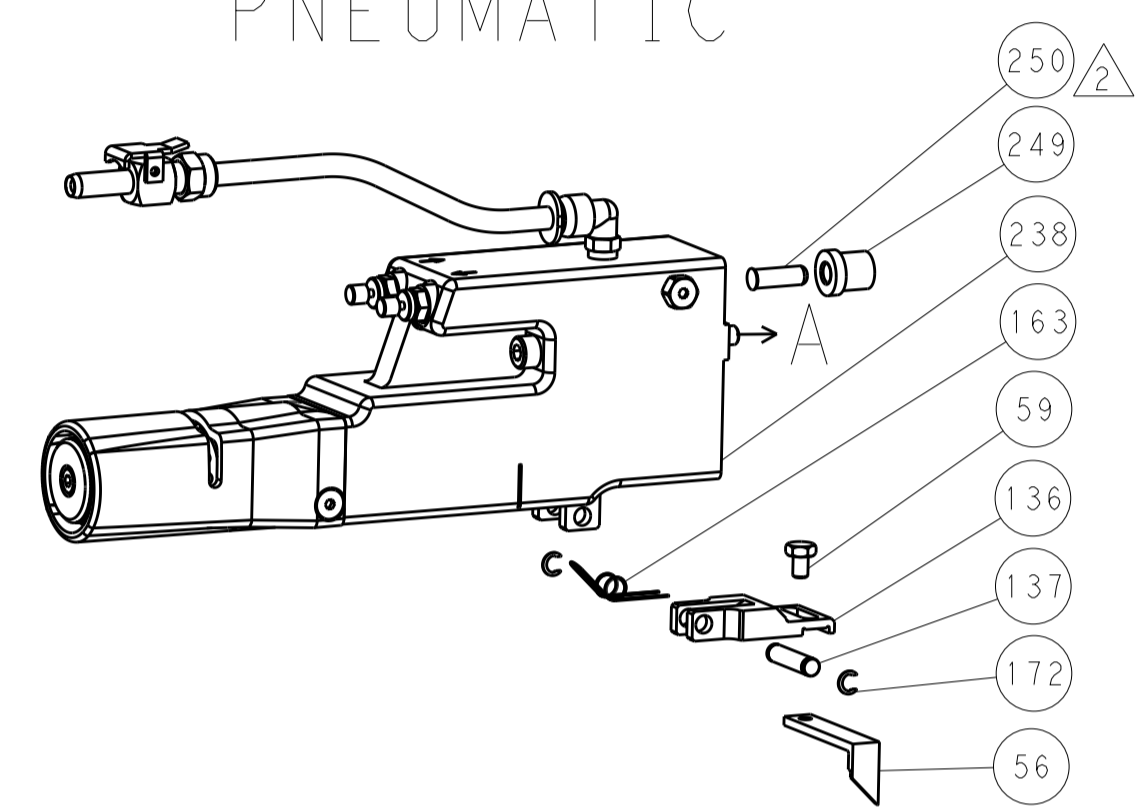
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MATERIAL:				WEIGHT:		RESTRICTED TO:	

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

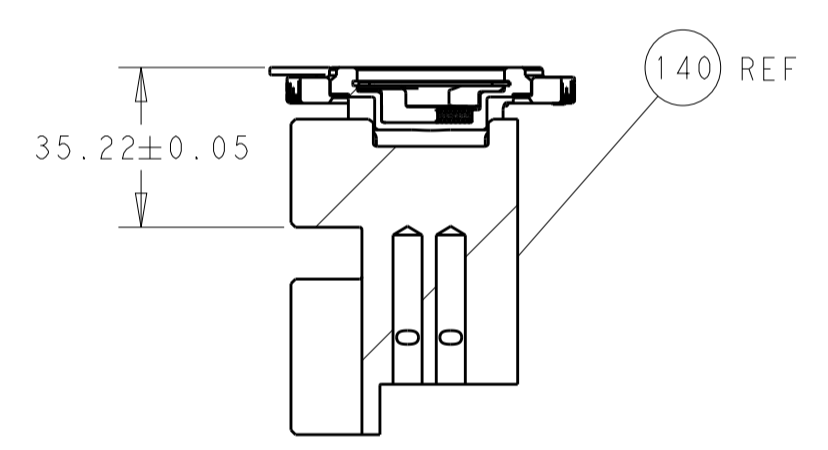
FEED TYPE MECHANICAL



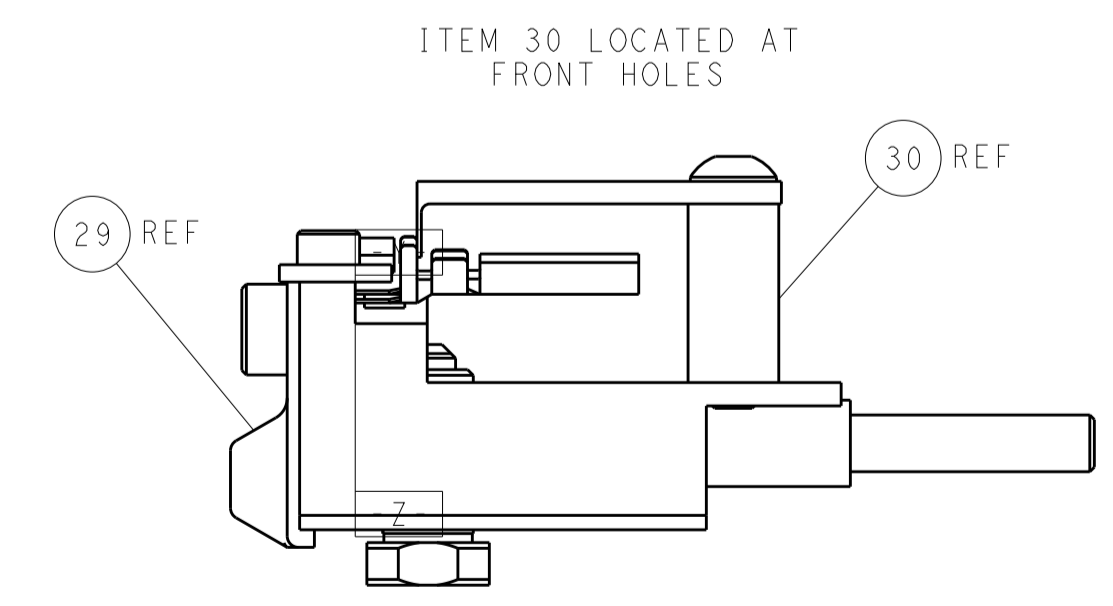
PNEUMATIC



TERMINAL SUPPORT LOCATION

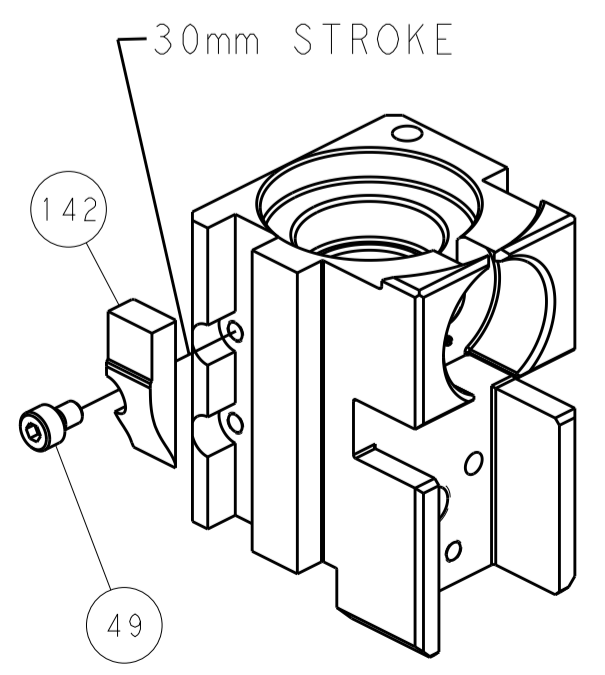


HOLDDOWN SET-UP

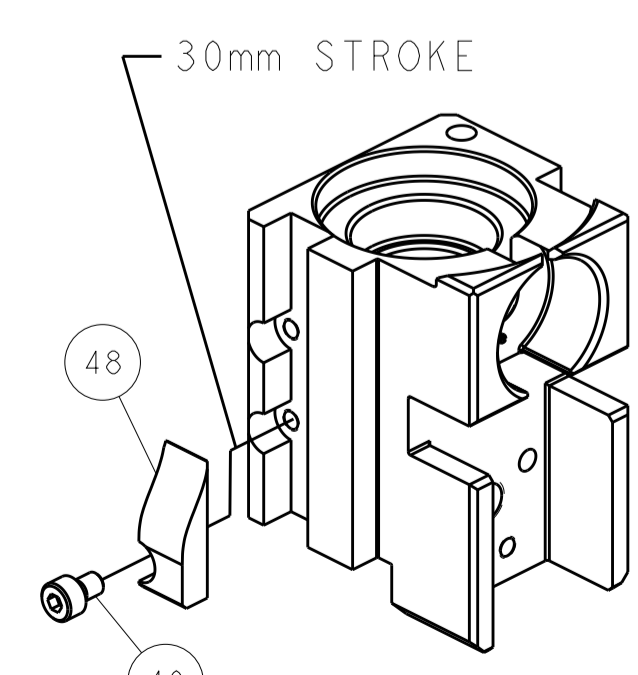


FEED TRACK POSITION
GUIDE BY INSULATION BARREL

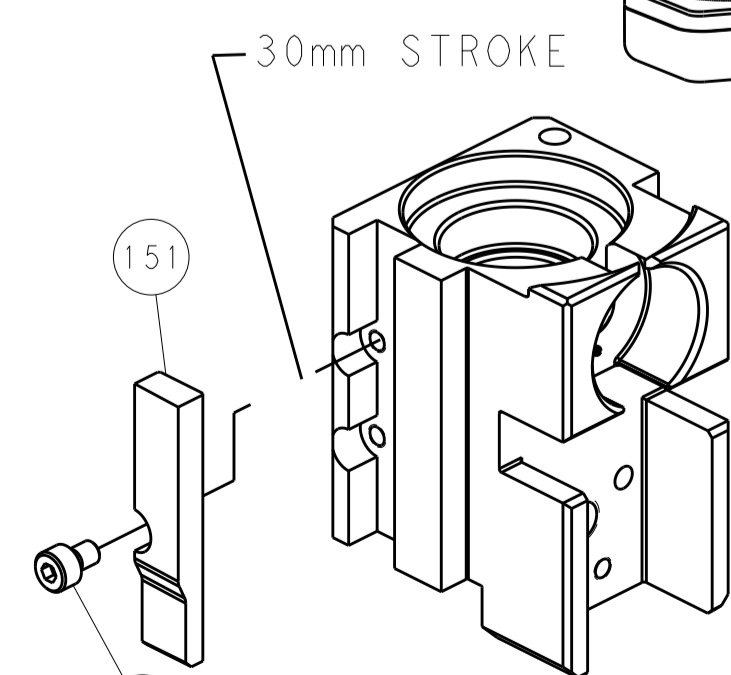
CAM POSITIONS



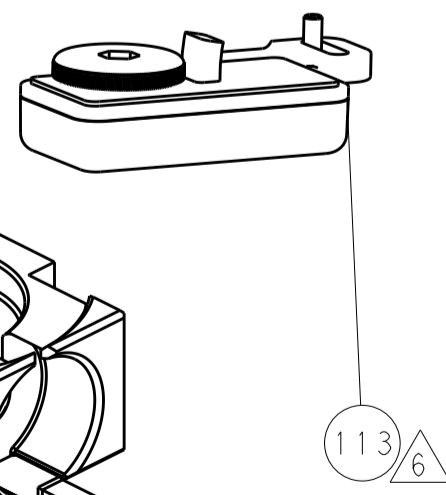
MECHANICAL
POST FEED



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)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG: X. ZHAO 16OCT2015		TE Connectivity	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	5 PLC ±	Harrisburg, PA 17105-3608
	ANGLES	FINISH		CHK: L. ZHANG 16OCT2015	NAME		
MATERIAL				APVD: H. GUO 16OCT2015	PRODUCT SPEC		
					APPLICATION SPEC		
					WEIGHT		
					SCALE		
					SHEET		
					REV		