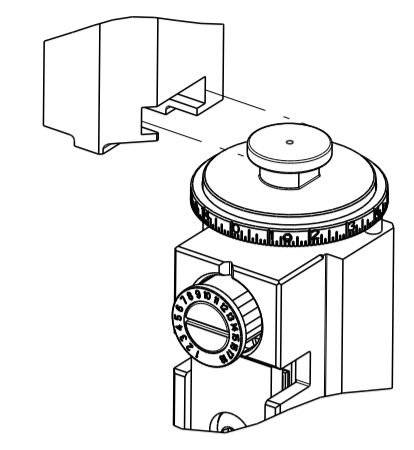


ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151639-1	H	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2151639-2	J	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
5-2151639-1	H	SEAL STRIPPER CRIMPER TERMINATING UNIT	MECHANICAL
5-2151639-2	J	SEAL STRIPPER CRIMPER TERMINATING UNIT	PNEUMATIC
7-2151639-1	H	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2151639-2	J	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2151639-7	G	CRIMP TOOLING KIT	-

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.40 mm [.055]	F
INSUL	1.78 mm [.070]	O
STAB	1.91 mm [.075]	O

APPLICATOR INSTRUCTIONS  
408-35042

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: CONTACT ASSEMBLY, LOCKING CLIP			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
.111-.126 IN [2.82-3.20 mm]		Ø.038-.062 IN [0.97-1.57 mm]	
TERMINAL APPLICATION SPECIFICATION	114-25006		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
87124-1	87124-2	87124-3	5-87124-2
2267356-1			

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: CONTACT ASSEMBLY, LOCKING CLIP			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
.111-.126 IN [2.82-3.20 mm]		Ø.038-.062 IN [0.97-1.57 mm]	
TERMINAL APPLICATION SPECIFICATION	114-25006		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
867052-1	867052-2	5-867052-1	

WIRE SIZE	CRIMP HEIGHT INCH [mm]	CRIMP HEIGHT REFERENCE SETTING	STABILIZER CRIMP HEIGHT mm [INCH]	TE HOUSING
22 AWG	0.86+/-0.05 [0.034+/-0.002]	7.1	2.44 +0.0/-0.2 [0.096 +0.0/-0.008]	926010/868781
24 AWG	0.76+/-0.05 [0.030+/-0.002]	8.1	2.44 +0.0/-0.2 [0.096 +0.0/-0.008]	926010/868781
26 AWG	0.76+/-0.05 [0.030+/-0.002]	8.1	2.44 +0.0/-0.2 [0.096 +0.0/-0.008]	926010/868781

- 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.
- 6. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- APPLICATOR WAS QUALIFIED TO STABILIZER CRIMP HEIGHT LISTED FOR TERMINAL AND HOUSING COMBINATION ONLY. THIS HEIGHT VARIES FROM 114 SPECIFICATION.

**\*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
		G		ECR-17-014213	26SEP2017	MZ	KZ
		G1		ECR-18-000788	18JAN2018	JAH	TE
		H		ECR-18-015855	07OCT2018	TB	TE
		J		ECR-21-112944	07SEP2021	JWC	GB

-	-	-	1	1	-	-	1803515-3	RAM ASSEMBLY, SF ATLANTIC	293
-	-	-	1	1	-	-	2-1803583-1	APPLICATOR BASIC ASSEMBLY, SF	292
-	1	1	1	1	1	1	455888-5	SPACER, CRIMPER	263
-	1	1	1	1	1	1	461679-3	TOOL, SIZING	261
-	1	-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248
-	1	1	1	1	1	1	2119082-5	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	1	1	1	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
-	-	1	-	1	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	1	-	1	-	1	-	2844940-1	AIR FEED MODULE	238
-	-	-	1	1	-	-	4-1722335-3	STRIPPER, SIDE FEED	182
-	-	-	1	1	-	-	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	181
-	-	-	1	1	-	-	1-1752354-8	STANDOFF,HOLD-DOWN	180
-	-	-	1	1	-	-	993111-1	PIN, SLOTTED SPRING 3.0 X 20.0	177
-	-	-	1	1	-	-	5-22280-0	SPRING, COMPRESSION	176
-	-	-	1	1	-	-	1752353-3	GUIDE PIN,HOLDDOWN	175
-	-	-	1	1	-	-	1901680-2	GUIDE PIN,HOLDDOWN	174
-	REF	REF	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	1	1	1	1	1	1	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113
-	1	1	1	1	1	1	2844908-1	SCREW, LOCKING	99
-	1	1	1	1	1	1	2844907-1	POST, LOCKING	98
-	1	1	1	1	1	1	455888-5	SPACER, CRIMPER	82
-	1	1	1	1	1	1	5-547505-2	SPRING, COMPRESSION	77
-	1	1	1	1	1	1	854769-4	HOLDER, INS	74
-	1	1	1	1	1	1	1803607-3	DOCUMENTATION PACKAGE	71
-	1	1	1	1	1	1	2119740-1	TAG,IDENTIFICATION	67
-	2	2	2	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	1	1	1	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	60
-	1	1	1	1	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	1	1	1	1	1	1	21028-2	PIN, SLOTTED SPRING .062 X .250	58
-	1	1	1	1	1	1	1338685-1	PAWL, FEED	56
-	4	4	4	4	4	4	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	54
-	2	2	2	2	2	2	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	53
-	1	1	1	1	1	1	5018030-1	NUT, HEX, REG, RoHS, M3	52
-	1	1	1	1	1	1	811242-5	BUMPER, HOLD DOWN	51
-	1	1	1	1	1	1	690753-2	SPACER, TONKER	50
-	1	2	1	2	1	2	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	-	1	-	1	-	1	2119652-1	FEED CAM, PRE FEED	48
-	-	1	-	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	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
-	1	1	1	1	1	1	1752356-1	SUPPORT, TERMINAL	34
-	2	2	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	2	2	2	2	2-2844962-6	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	1	1	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29
-	1	1	1	1	1	1	455888-4	SPACER, CRIMPER	28
-	1	1	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	1	1	2	2	1-18028-2	WASHER, FLAT, REG M4	20
-	1	1	-	-	1	1	2119533-1	STRIPPER, SIDE FEED	19
-	1	1	1	1	1	1	2119806-1	INSERT, SHEAR	13
-	1	1	1	1	1	1	3-22280-3	SPRING, COMPRESSION	12
-	1	1	1	1	1	1	1-356885-4	STOP, SHEAR	11
-	1	1	1	1	1	1	2119805-1	SHEAR HOLDER, FRONT	10
-	1	1	1	1	1	1	1803095-1	FLOATING SHEAR, FRONT	9
-	1	2	2	1	1	1	6-1633917-6	ANVIL, COMBINATION	8
-	1	1	1	1	1	1	6-240641-3	SPACER	7
-	-	-	-	-	-	-	-	-	6
-	1	1	1	1	1	1	2119780-9	DEPRESSOR, SHEAR	5
-	1	1	1	1	1	1	1-238011-0	BLOCK, CRIMPER SPACER	4
-	1	2	2	1	1	1	1-1633965-6	CRIMPER, INSULATION O PREMIUM	3
-	1	1	1	1	1	1	455888-3	SPACER, CRIMPER	2
-	1	2	2	1	1	1	456402-1	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

CHK	DATE	NAME	DESCRIPTION	ITEM NO
OWN	9 APRIL 2012	STAKEM	TE Connectivity	
CHK	9 APRIL 2012	G. BAILEY	Harrisburg, PA 17105-3608	
APVD	9 APRIL 2012	T. ELBIN	Ocean Side Feed Applicator	

SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
A1	00779	2151639	

Customer Accessible Production Drawing SCALE 1:2 SHEET 1 OF 4 REV J



PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2151639-1	H	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2151639-2	J	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151639-7	G	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR  
 INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.40 mm [.055]	F
INSUL	1.78 mm [.070]	O
STAB	1.91 mm [.075]	O

APPLICATOR INSTRUCTIONS  
 408-35042

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: CONTACT ASSEMBLY, LOCKING CLIP			
WIRE STRIP LENGTH .111-.126 IN [2.82-3.20 mm]	INSULATION DIAMETER RANGE Ø.038-.062 IN [0.97-1.57 mm]		
TERMINAL APPLICATION SPECIFICATION 114-25006			
TERMINALS APPLIED			
TE TERMINAL 87124-1	TE TERMINAL 87124-2	TE TERMINAL 87124-3	TE TERMINAL 5-87124-2
2267356-1			

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: CONTACT ASSEMBLY, LOCKING CLIP			
WIRE STRIP LENGTH .111-.126 IN [2.82-3.20 mm]	INSULATION DIAMETER RANGE Ø.038-.062 IN [0.97-1.57 mm]		
TERMINAL APPLICATION SPECIFICATION 114-25006			
TERMINALS APPLIED			
TE TERMINAL 867052-1	TE TERMINAL 867052-2	TE TERMINAL 5-867052-1	TE TERMINAL

WIRE SIZE	CRIMP HEIGHT INCH [mm]	CRIMP HEIGHT REFERENCE SETTING	STABILIZER CRIMP HEIGHT mm [INCH]	TE HOUSING
22 AWG	0.86+/-0.05 [0.034+/-0.002]	7.1	2.44 +0.0/-0.2 [0.096 +0.0/-0.008]	926010/868781
24 AWG	0.76+/-0.05 [0.030+/-0.002]	8.1	2.44 +0.0/-0.2 [0.096 +0.0/-0.008]	926010/868781
26 AWG	0.76+/-0.05 [0.030+/-0.002]	8.1	2.44 +0.0/-0.2 [0.096 +0.0/-0.008]	926010/868781

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING	STABILIZER CRIMP HEIGHT mm [INCH]	TE HOUSING
20 AWG	1.02+/-0.05 [0.040+/-0.002]	5.6	2.44 +0.0/-0.2 [0.096 +0.0/-0.008]	926010/868781

- 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.
- 6. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- APPLICATOR WAS QUALIFIED TO STABILIZER CRIMP HEIGHT LISTED FOR TERMINAL AND HOUSING COMBINATION ONLY. THIS HEIGHT VARIES FROM 114 SPECIFICATION.

**\*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)

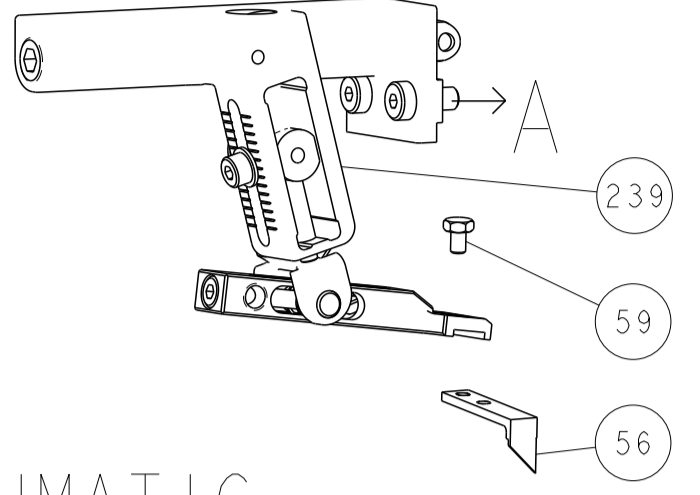
LOC	DIST	REVISIONS					
A	66	P	LTN	DESCRIPTION	DATE	OWN	APVD
-	-	-	-	SEE SHEET 1	-	-	-

-	1	1	455888-5	SPACER, CRIMPER	263	
-	1	1	461679-3	TOOL, SIZING	261	
-	1	1	2119082-5	CAM, SNAIL, INSULATION ADJUSTMENT	244	
-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243	
△	-	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	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	5-547505-2	SPRING, COMPRESSION	77	
-	1	1	854769-4	HOLDER, INS	74	
-	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	21028-2	PIN, SLOTTED SPRING .062 X .250	58	
-	1	1	1338685-1	PAWL, FEED	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	1752356-1	SUPPORT, TERMINAL	34	
-	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	455888-4	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	2119806-1	INSERT, SHEAR	13	
-	1	1	3-22280-3	SPRING, COMPRESSION	12	
-	1	1	1-356885-4	STOP, SHEAR	11	
△	-	1	2119805-1	SHEAR HOLDER, FRONT	10	
△	-	1	1803095-1	FLOATING SHEAR, FRONT	9	
△	1	1	1	6-1633917-6	ANVIL, COMBINATION	8
-	-	1	1	6-240641-3	SPACER	7
-	-	-	-	-	6	
-	1	1	2119780-9	DEPRESSOR, SHEAR	5	
-	1	1	1-238011-0	BLOCK, CRIMPER SPACER	4	
△	1	1	1	1-1633965-6	CRIMPER, INSULATION O PREMIUM	3
-	1	1	455888-3	SPACER, CRIMPER	2	
△	1	1	1	456402-1	CRIMPER, WIRE PREMIUM	1

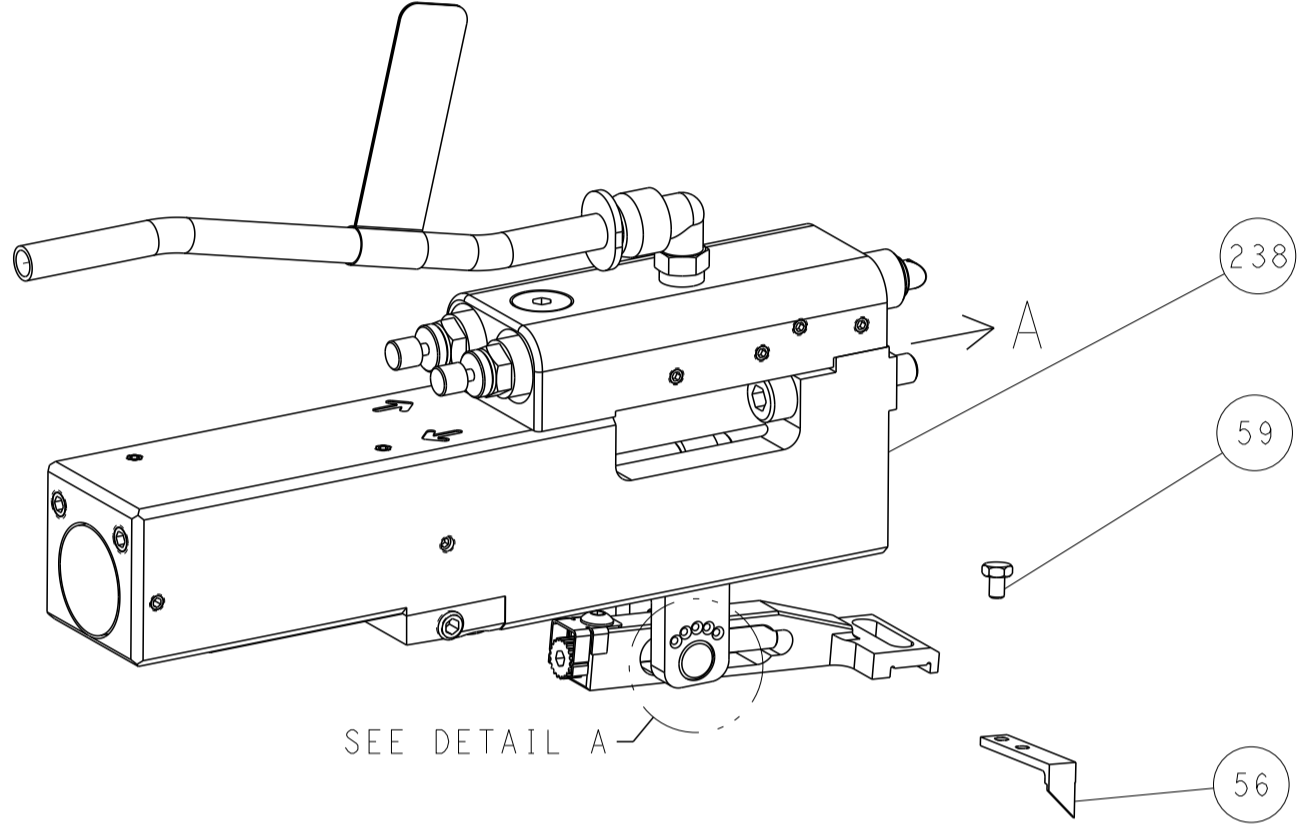
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		MATERIAL:		FINISH:		WEIGHT:		SCALE:		SHEET:		REV:	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES	FINISH			A1	00779	3	4	J	

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

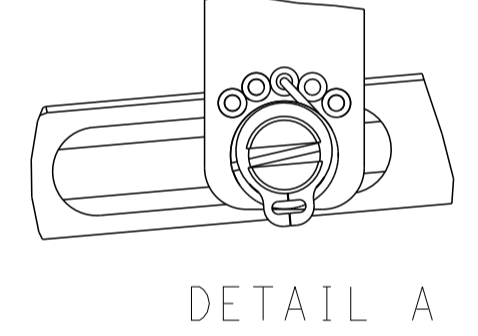
# FEED TYPE MECHANICAL



## PNEUMATIC

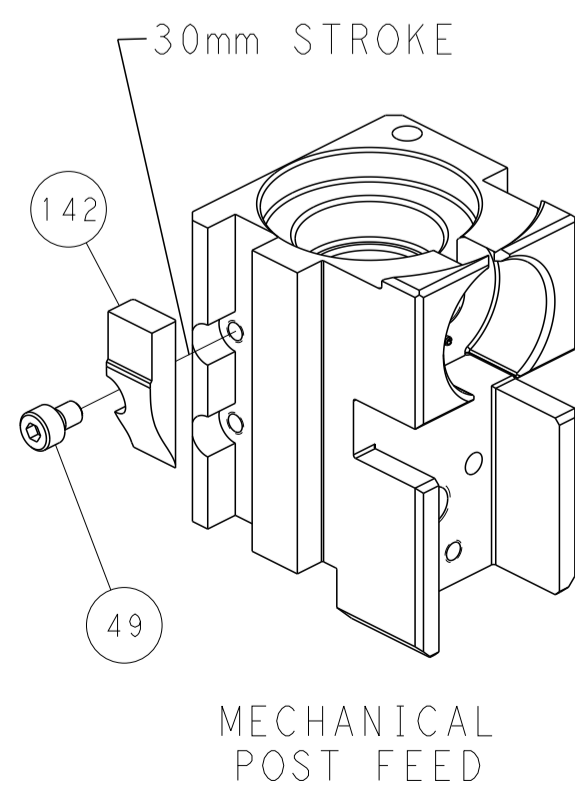


## FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)

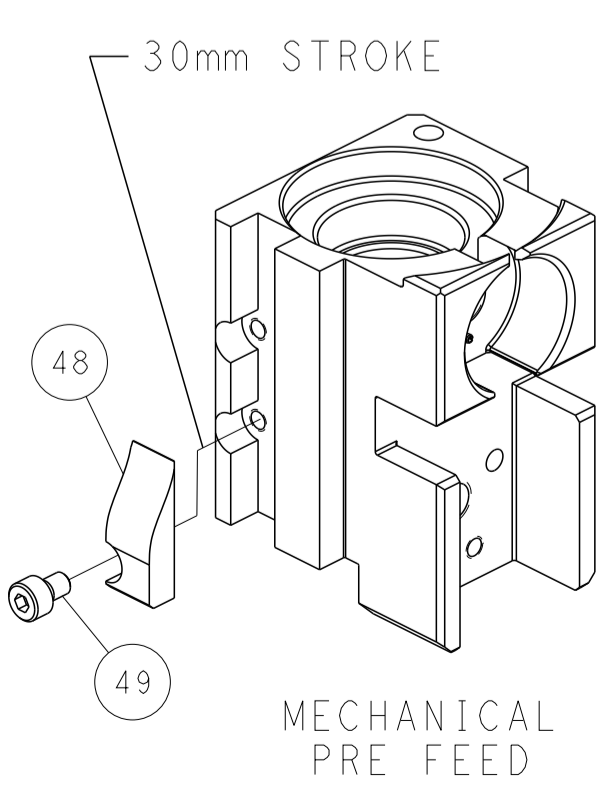


DETAIL A

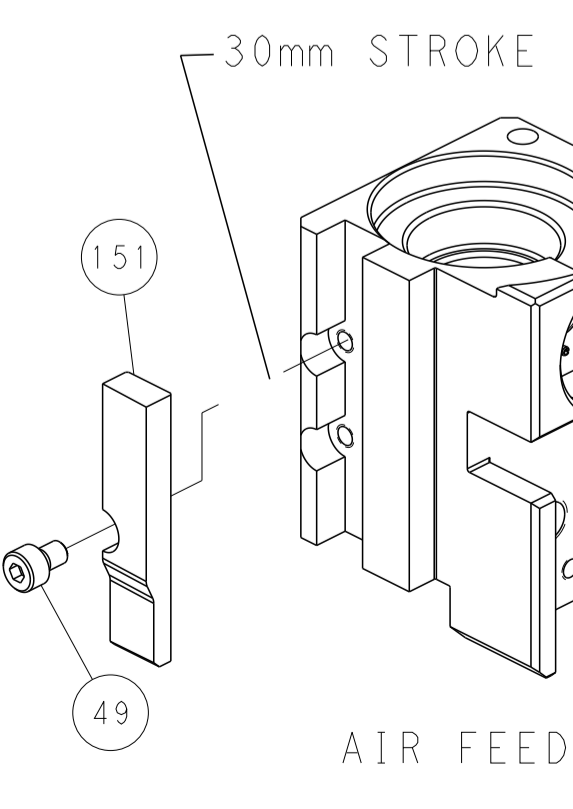
## CAM POSITIONS



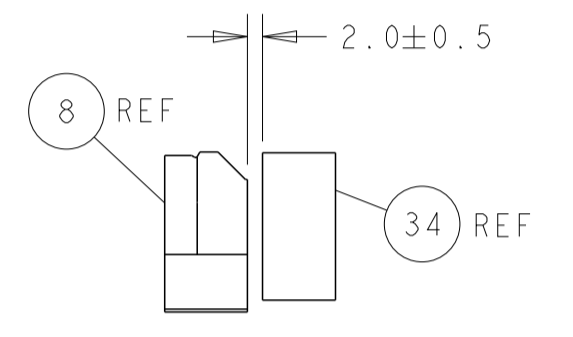
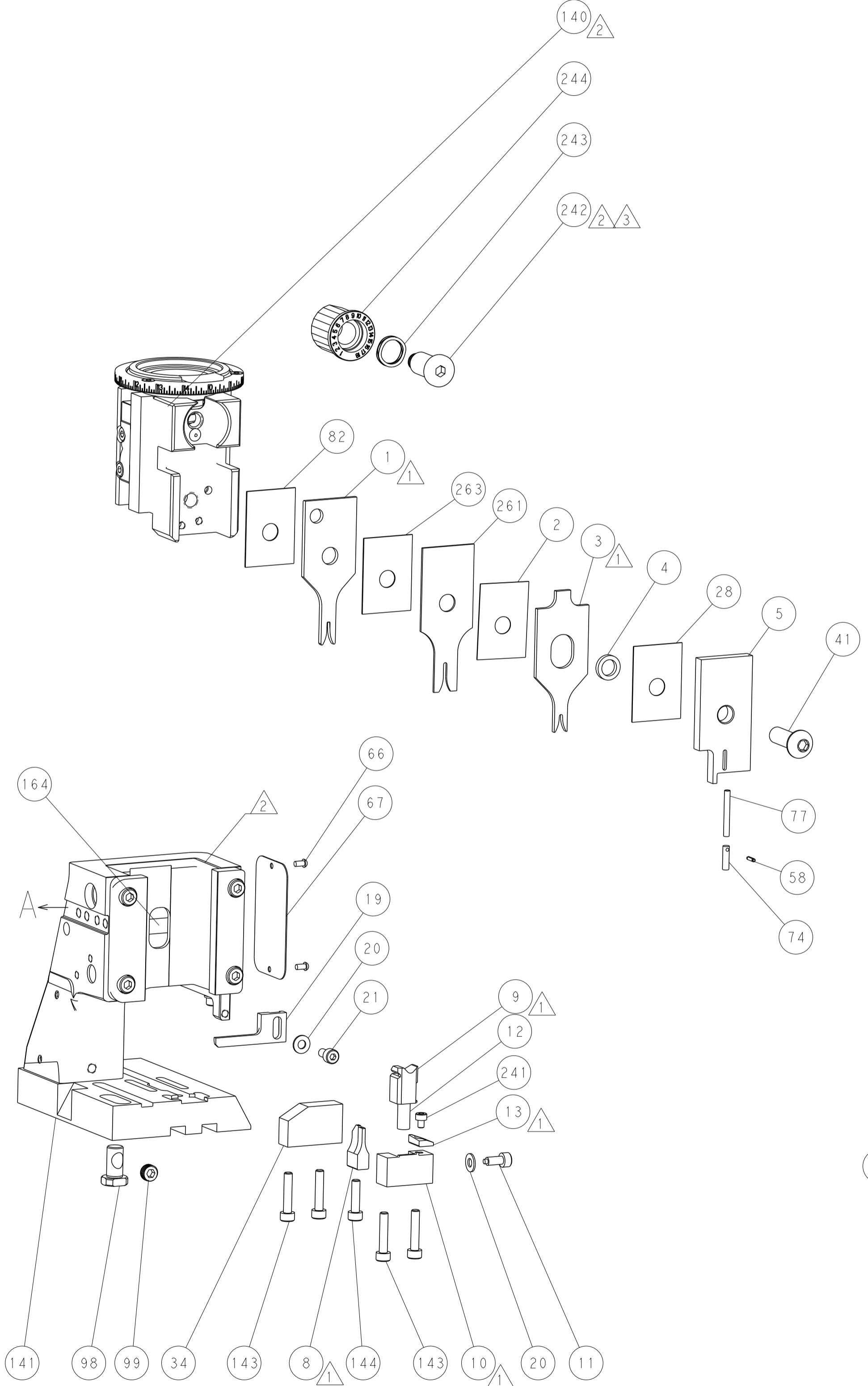
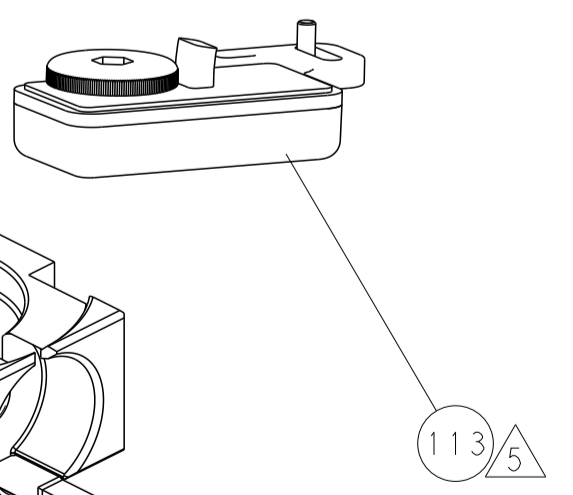
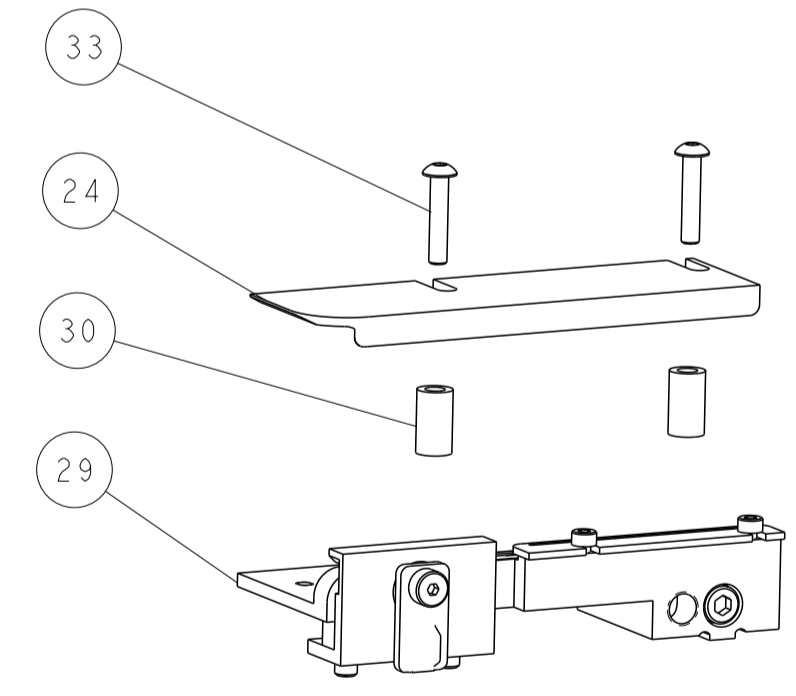
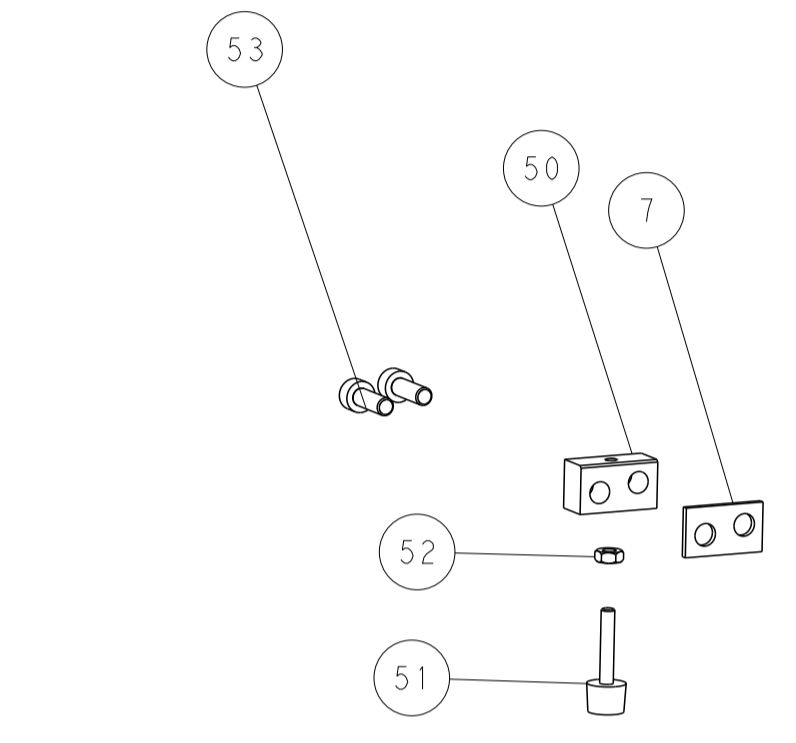
MECHANICAL POST FEED



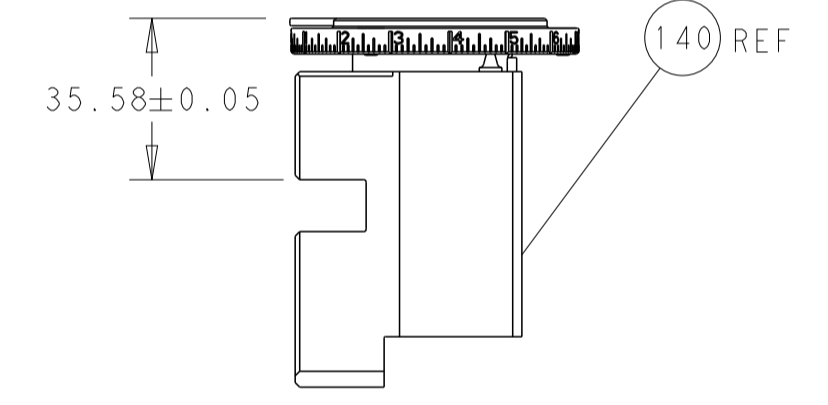
MECHANICAL PRE FEED



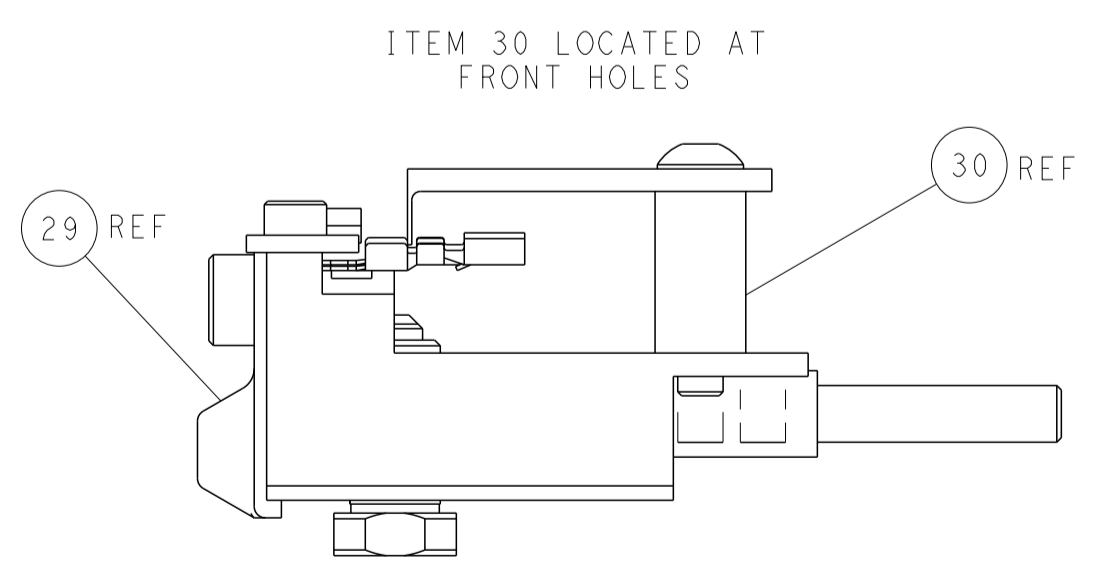
AIR FEED



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)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG. STAKEM 19APRIL2012		TE Connectivity	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	5 PLC ±	Harrisburg, PA 17105-3608
MATERIAL:		FINISH:		CHK. G. BAILEY 19APRIL2012		NAME	
				APVD. T. ELBIN 19APRIL2012		Ocean Side Feed Applicator	
				PRODUCT SPEC		SIZE CAGE CODE DRAWING NO. RESTRICTED TO	
				APPLICATION SPEC		A1 00779 C=2151639	
				WEIGHT		SCALE 1:2 SHEET 4 OF 4 REV J	
				Customer Accessible Production Drawing			