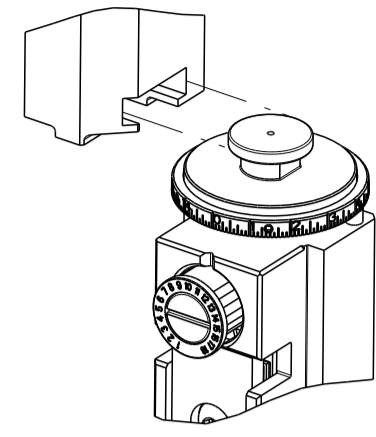


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151127-1	E	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2151127-2	E	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151127-1	E	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2151127-2	E	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2151127-7	D	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.16 mm [.046]	F
INSUL	1.78 mm [.070]	F

APPLICATOR INSTRUCTIONS
408-35042

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: GRACE INERTIA CONNECTOR 2.5 REC CONTACT			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
1.70-2.30 mm [.067-.091 IN]		Ø1.08-1.90 mm [.043-.075 IN]	
TERMINAL APPLICATION SPECIFICATION	(A)114-5359		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
(A) 1747063-1	(A) 1871859-1	(A) 1871859-2	

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: GRACE INERTIA CONNECTOR 2.5 REC CONTACT			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
1.70-2.30 mm [.067-.091 IN]		Ø0.88-1.50 mm [.035-.059 IN]	
TERMINAL APPLICATION SPECIFICATION	(B)114-5527		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
(B) 2293351-1			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.31-0.38mm2 (22AWG)	0.80+/-0.03 [.031+/- .001]	8.3
0.21-0.23mm2 (24AWG)	0.73+/-0.03 [.029+/- .001]	9.0
0.12-0.15mm2 (26AWG)	0.67+/-0.03 [.026+/- .001]	9.7
0.079mm2 (28AWG)	0.64+/-0.03 [.025+/- .001]	10.0

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.12-0.15mm2 (26AWG)	0.67+/-0.03 [.026+/- .001]	9.7
0.079mm2 (28AWG)	0.64+/-0.03 [.025+/- .001]	10.0

***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.

- 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.

LOC	DIST	REVISIONS					
A	66	P	LTN	DESCRIPTION	DATE	OWN	APVD
		B		ECR-16-001180	26JAN2016	MR	JDG
		C		ECR-17-013754	18SEP2017	JAH	TE
		D		ECR-18-004305	22MAR2018	KH	CT
		E		ECR-18-013573	26AUG2018	TB	TE

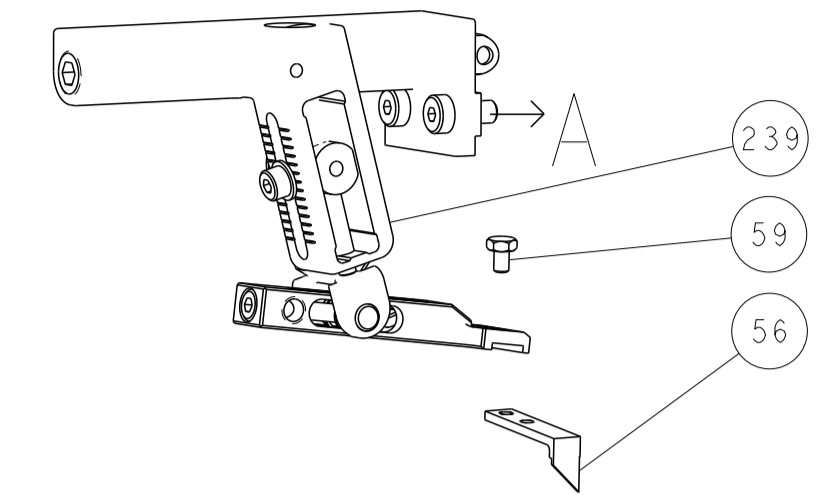
-	1	-	1	-	2119640-1	PUSH ROD, AIR FEED	250	
-	1	-	1	-	1803259-1	BUSHING, FLANGED	249	
-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248	
-	1	1	1	1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244	
-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243	
-	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242	
-	1	1	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241	
-	-	1	-	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	
-	1	1	1	1	1-18028-2	WASHER, FLAT, REG M4	119	
-	1	1	1	1	2844908-1	SCREW, LOCKING	99	
-	1	1	1	1	2844907-1	POST, LOCKING	98	
-	1	1	1	1	1-455888-6	SPACER, CRIMPER	82	
-	1	1	1	1	1803607-1	DOCUMENTATION PACKAGE	71	
-	1	1	1	1	2119791-9	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	18023-8	SCR, SKT HD CAP M4 X 5.0	53	
-	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	2-1752356-5	SUPPORT, TERMINAL	34	
-	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33	
-	2	2	2	2	2-2844962-4	SPACER, CYLINDRICAL, STRIP GUIDE	30	
-	1	1	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29	
-	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	
-	1	1	1	1	1-18028-2	WASHER, FLAT, REG M4	20	
-	1	1	1	1	2119533-1	STRIPPER, SIDE FEED	19	
-	1	1	1	1	1-690518-9	HOLD DOWN, TERMINAL	18	
-	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	2	2	1	1	6-1633703-9	ANVIL, COMBINATION	8
-	-	-	-	-	-	-	7	
-	-	-	-	-	-	-	6	
-	1	1	1	1	2119757-8	DEPRESSOR, SHEAR	5	
-	1	1	1	1	238011-6	BLOCK, CRIMPER SPACER	4	
-	1	2	2	1	1	2-1803384-6	CRIMPER, INSULATION F	3
-	1	1	1	1	455888-1	SPACER, CRIMPER	2	
-	1	2	2	1	1	6-1633305-7	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)

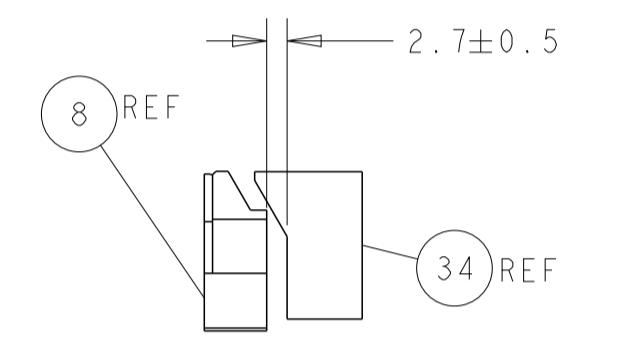
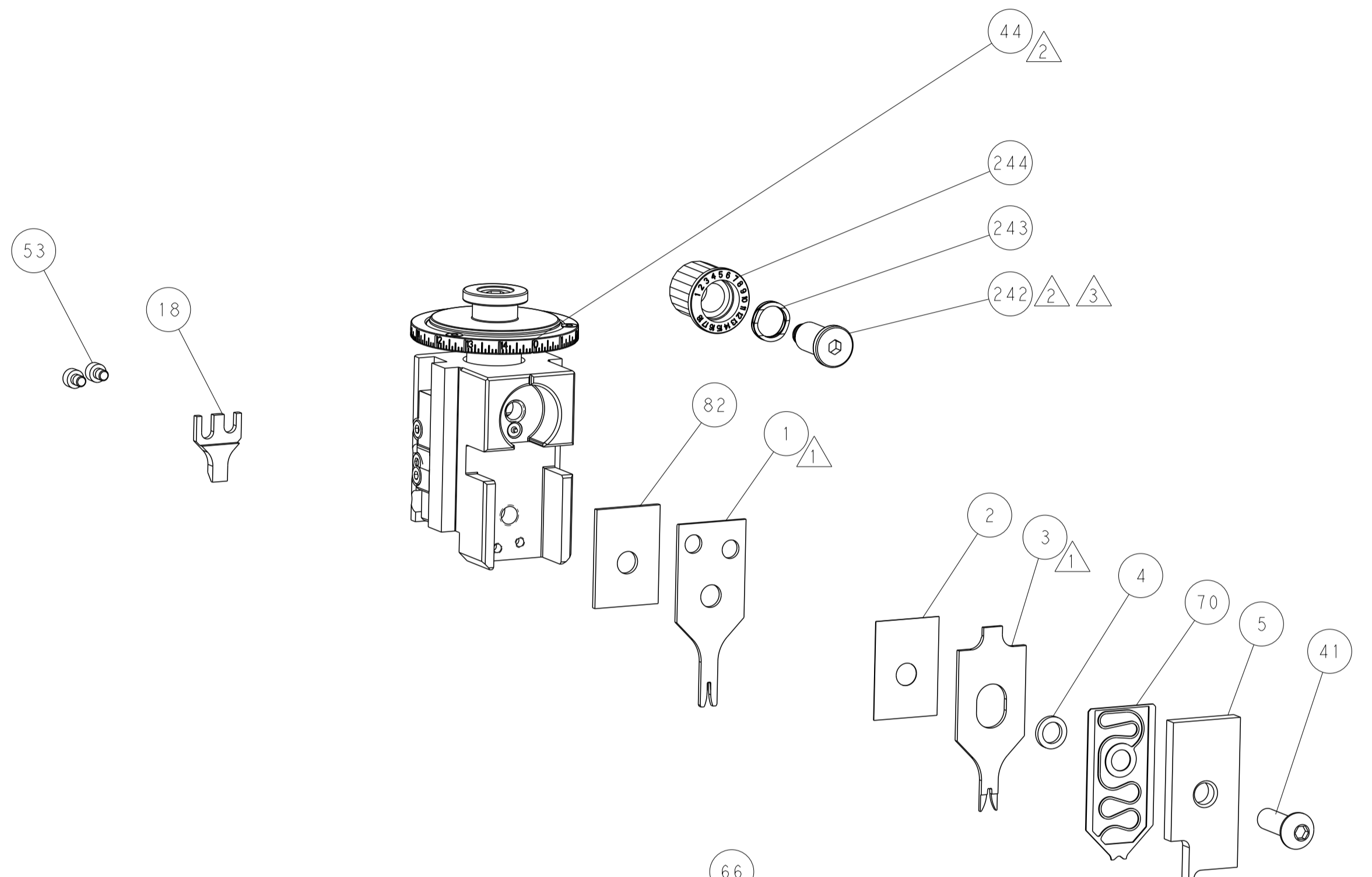
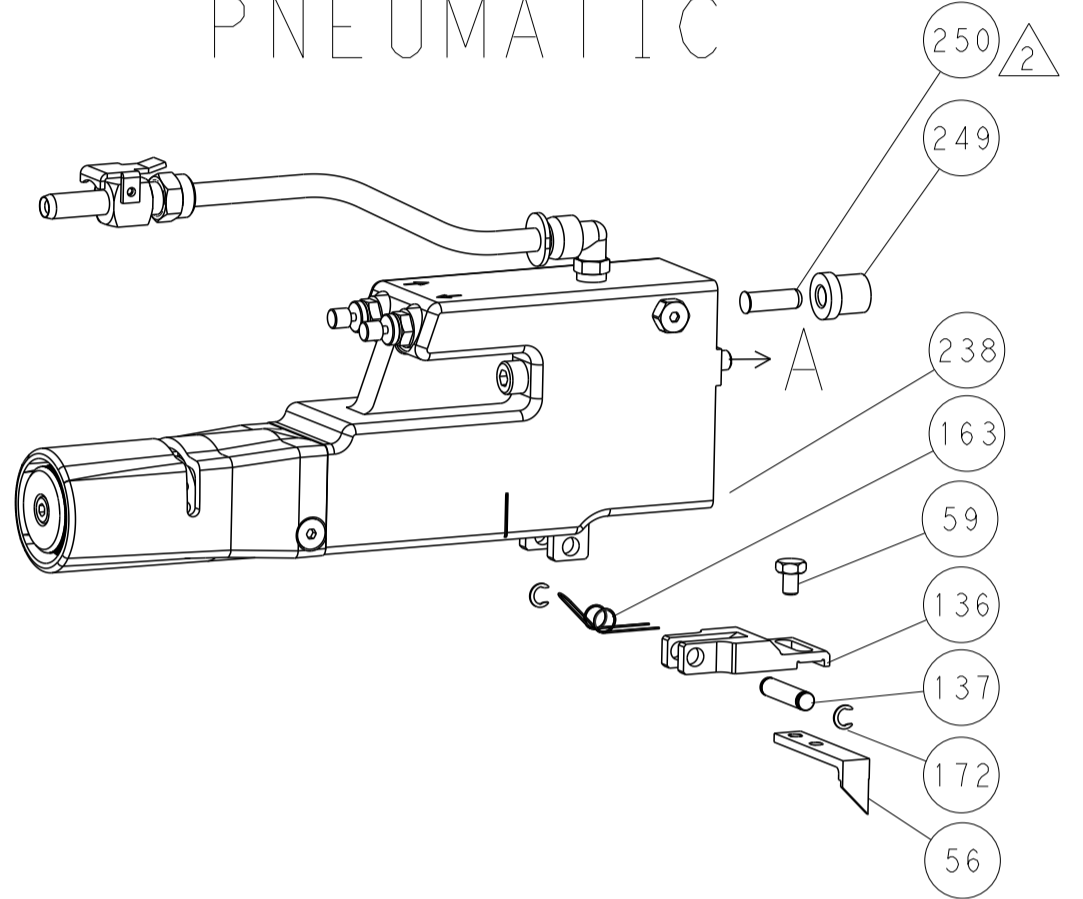
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		OWN: C. CHEN 22JUN2011		TE Connectivity Harrisburg, PA 17105-3608	
mm		0 PLC ±		CHK: S. XI 22JUN2011		NAME: Ocean Side Feed Applicator	
		1 PLC ±		APVD: J. CRUZ 22JUN2011		SIZE: A1 00779 C=2151127	
		2 PLC ±		PRODUCT SPEC		CAGE CODE: 00779	
		3 PLC ±		APPLICATION SPEC		DRAWING NO: 2151127	
		4 PLC ±		WEIGHT		SHEET 1 OF 4	
		ANGLES ±		FINISH		REV E	
MATERIAL				Customer Accessible Production Drawing		SCALE: 1:2	

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

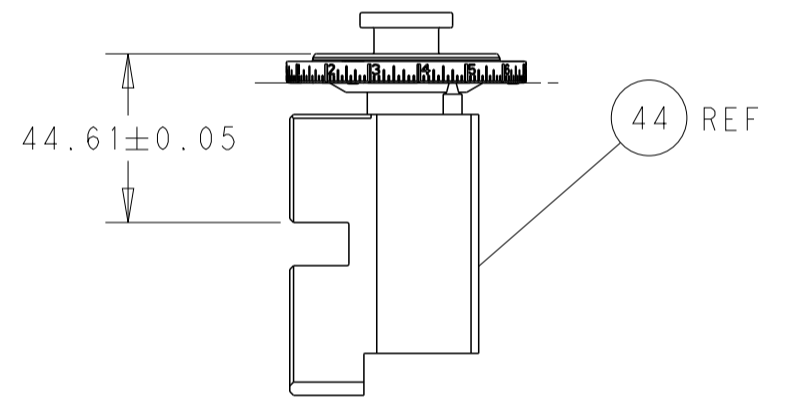
FEED TYPE MECHANICAL



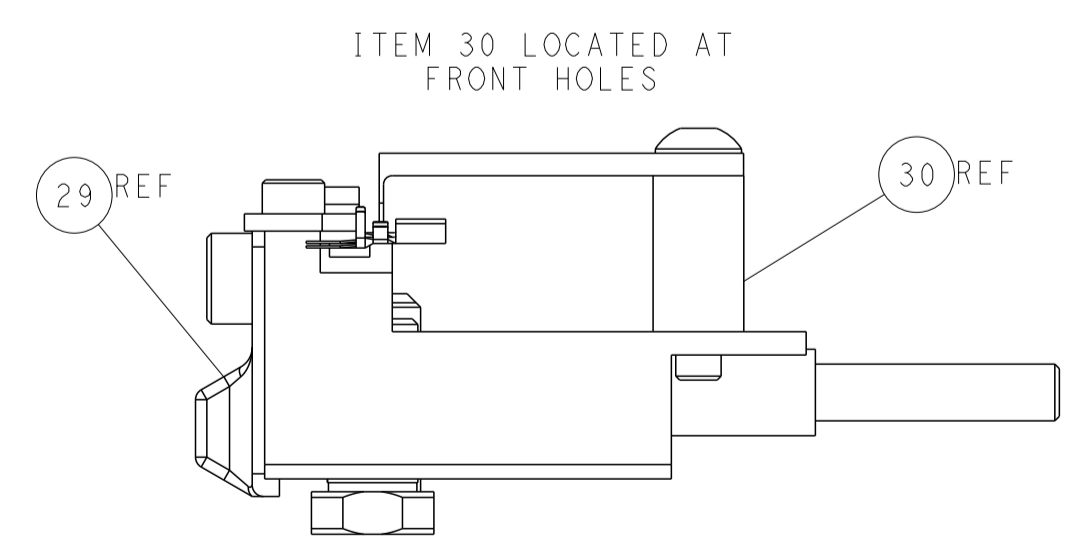
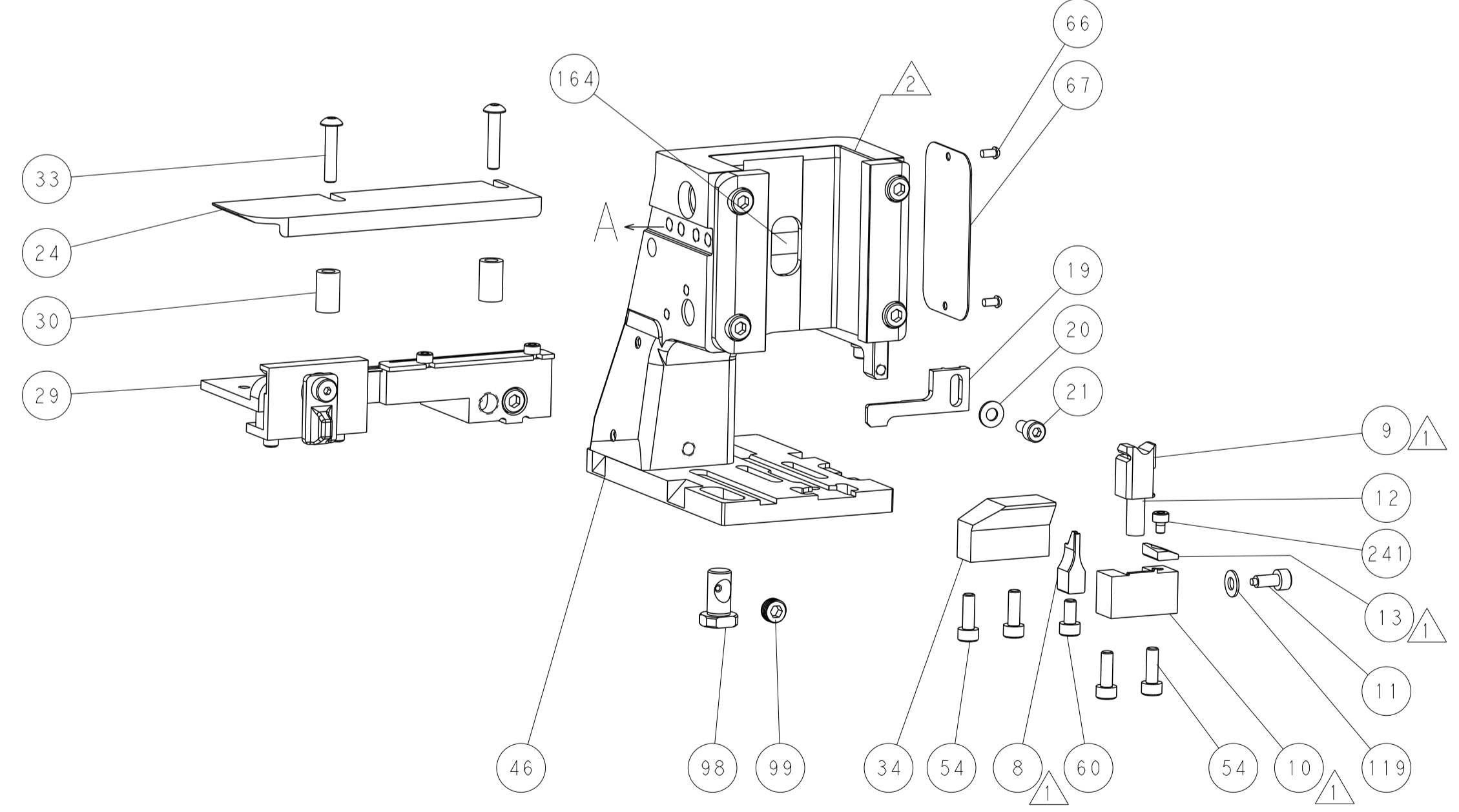
PNEUMATIC



TERMINAL SUPPORT LOCATION

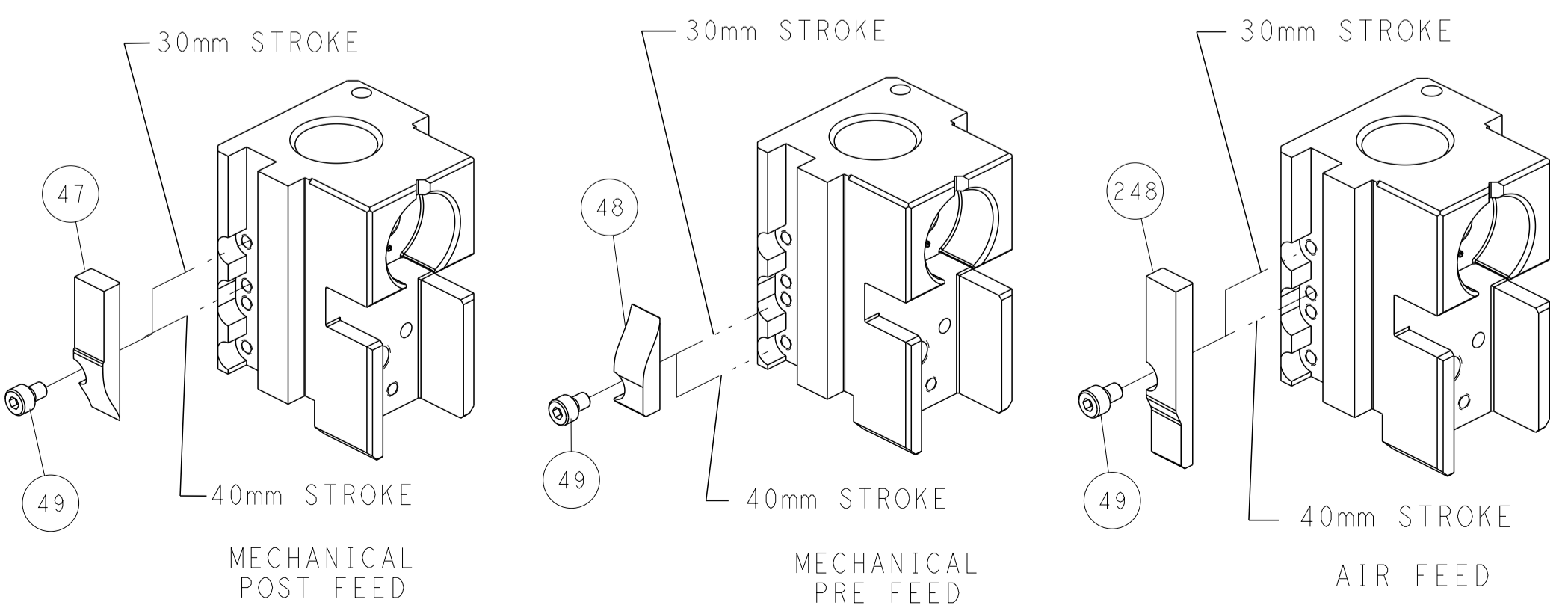


RAM SET-UP



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)

<small>THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.</small>		DWN: C. CHEN 22JUN2011 CHK: S. XI 22JUN2011 APVD: J. CRUZ 22JUN2011	NAME: Ocean Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2151127 SCALE: 1:2	RESTRICTED TO: - SHEET: 2 OF 4 REV: E
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH	TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH	WEIGHT: - MATERIAL: -	CUSTOMER ACCESSIBLE PRODUCTION DRAWING	SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2151127-1	E	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2151127-2	E	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151127-7	D	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.16 mm [.046]	F
INSUL	1.78 mm [.070]	F

APPLICATOR INSTRUCTIONS
408-35042

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: GRACE INERTIA CONNECTOR 2.5 REC CONTACT			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
1.70-2.30 mm [.067-.091 IN]		Ø1.08-1.90 mm [.043-.075 IN]	
TERMINAL APPLICATION SPECIFICATION	(A)114-5359		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
(A) 1747063-1	(A) 1871859-1	(A) 1871859-2	

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: GRACE INERTIA CONNECTOR 2.5 REC CONTACT			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
1.70-2.30 mm [.067-.091 IN]		Ø0.88-1.50 mm [.035-.059 IN]	
TERMINAL APPLICATION SPECIFICATION	(B)114-5527		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
(B) 2293351-1			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.31-0.38mm2 (22AWG)	0.80 +/- 0.03 [.031 +/- .001]	8.3
0.21-0.23mm2 (24AWG)	0.73 +/- 0.03 [.029 +/- .001]	9.0
0.12-0.15mm2 (26AWG)	0.67 +/- 0.03 [.026 +/- .001]	9.7
0.079mm2 (28AWG)	0.64 +/- 0.03 [.025 +/- .001]	10.0

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.12-0.15mm2 (26AWG)	0.67 +/- 0.03 [.026 +/- .001]	9.7
0.079mm2 (28AWG)	0.64 +/- 0.03 [.025 +/- .001]	10.0

***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.

- 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.

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

-	1	-	2119640-1	PUSH ROD, AIR FEED	250	
-	1	-	1803259-1	BUSHING, FLANGED	249	
-	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	-	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	1-18028-2	WASHER, FLAT, REG M4	119	
-	1	1	2844908-1	SCREW, LOCKING	99	
-	1	1	2844907-1	POST, LOCKING	98	
-	1	1	1-455888-6	SPACER, CRIMPER	82	
-	1	1	1803607-1	DOCUMENTATION PACKAGE	71	
-	1	1	2119791-9	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	18023-8	SCR, SKT HD CAP M4 X 5.0	53	
-	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	2-1752356-5	SUPPORT, TERMINAL	34	
-	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33	
-	2	2	2-2844962-4	SPACER, CYLINDRICAL, STRIP GUIDE	30	
-	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29	
-	1	1	1320928-2	STRIP GUIDE	24	
-	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21	
-	1	1	1-18028-2	WASHER, FLAT, REG M4	20	
-	1	1	2119533-1	STRIPPER, SIDE FEED	19	
-	1	1	1-690518-9	HOLD DOWN, TERMINAL	18	
-	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	6-1633703-9	ANVIL, COMBINATION	8
-	-	-	-	-	7	
-	-	-	-	-	6	
-	1	1	2119757-8	DEPRESSOR, SHEAR	5	
-	1	1	238011-6	BLOCK, CRIMPER SPACER	4	
-	1	1	2-1803384-6	CRIMPER, INSULATION F	3	
-	1	1	455888-1	SPACER, CRIMPER	2	
-	1	1	1	6-1633305-7	CRIMPER, WIRE PREMIUM	1

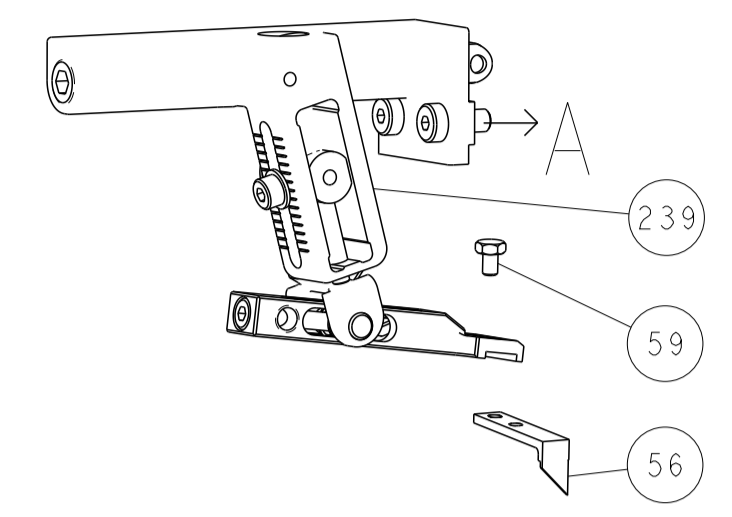
PACIFIC VERSION
Shown on sheets 3 of 4 & 4 of 4
(Atlantic version shown on sheets 1 of 4 & 2 of 4)

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

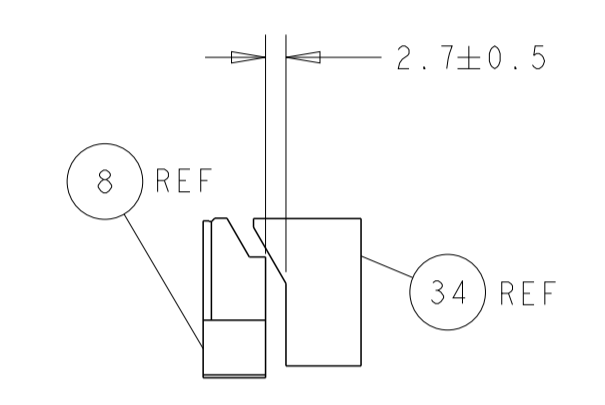
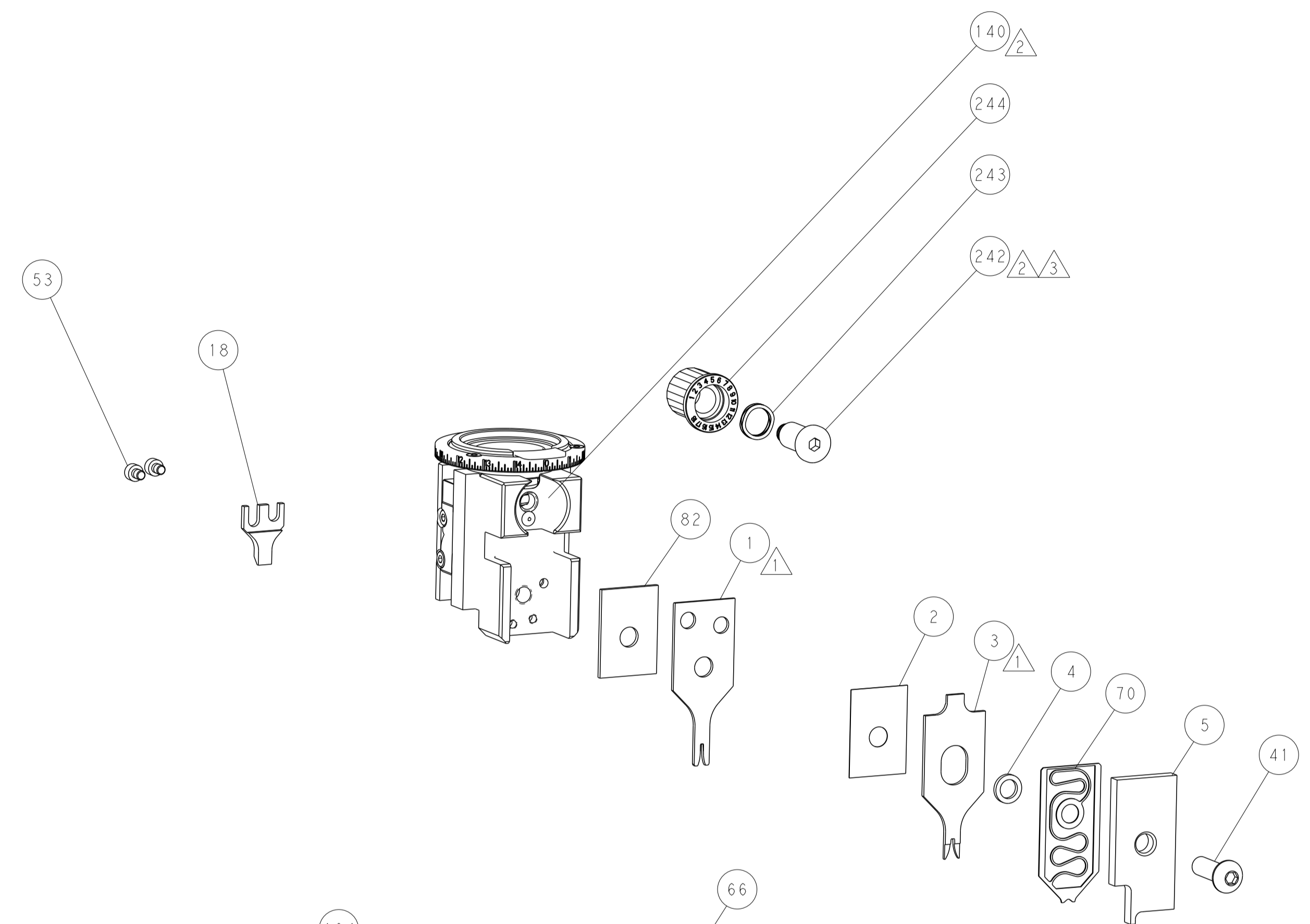
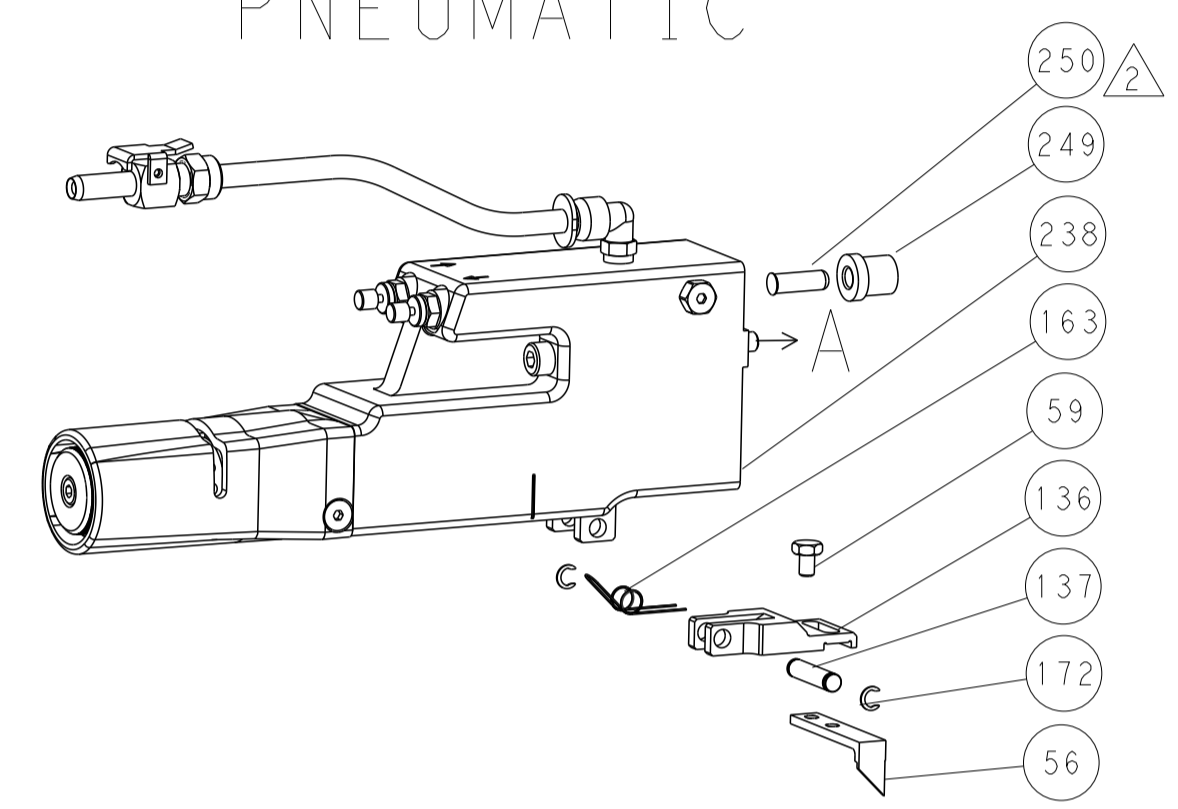
DATE	22JUN2011	CHK	C. CHEN	DATE	22JUN2011	CHK	S. XI
APVD	J. CRUZ	DATE	22JUN2011	NAME	Ocean Side Feed Applicator		
PRODUCT SPEC	-						
APPLICATION SPEC	-						
SIZE	A1	CAGE CODE	00779	DRAWING NO	C=2151127		RESTRICTED TO
WEIGHT	-						
Customer Accessible Production Drawing							
SCALE	1:2	SHEET	3	OF	4	REV	E

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

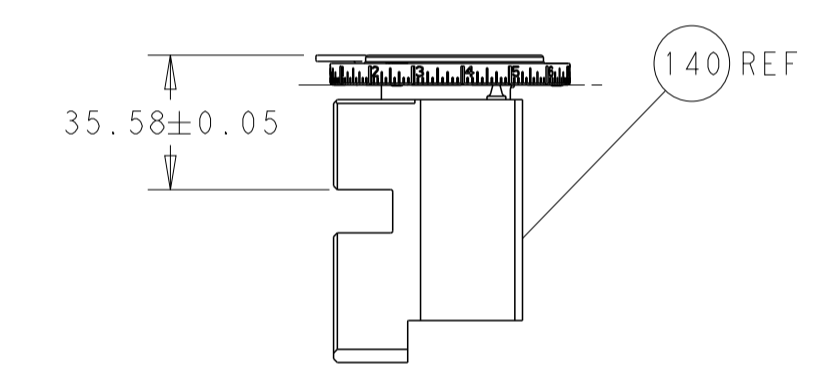
FEED TYPE MECHANICAL



PNEUMATIC

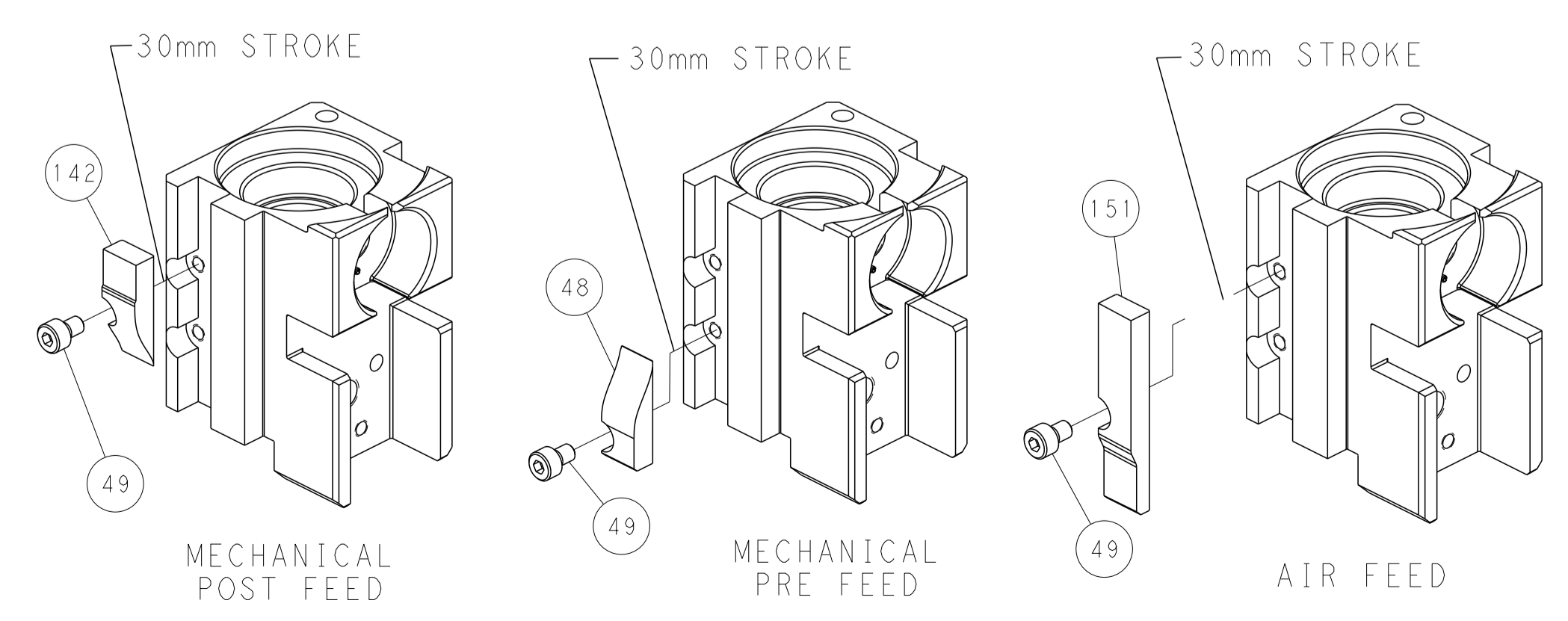


TERMINAL SUPPORT LOCATION



RAM SET-UP

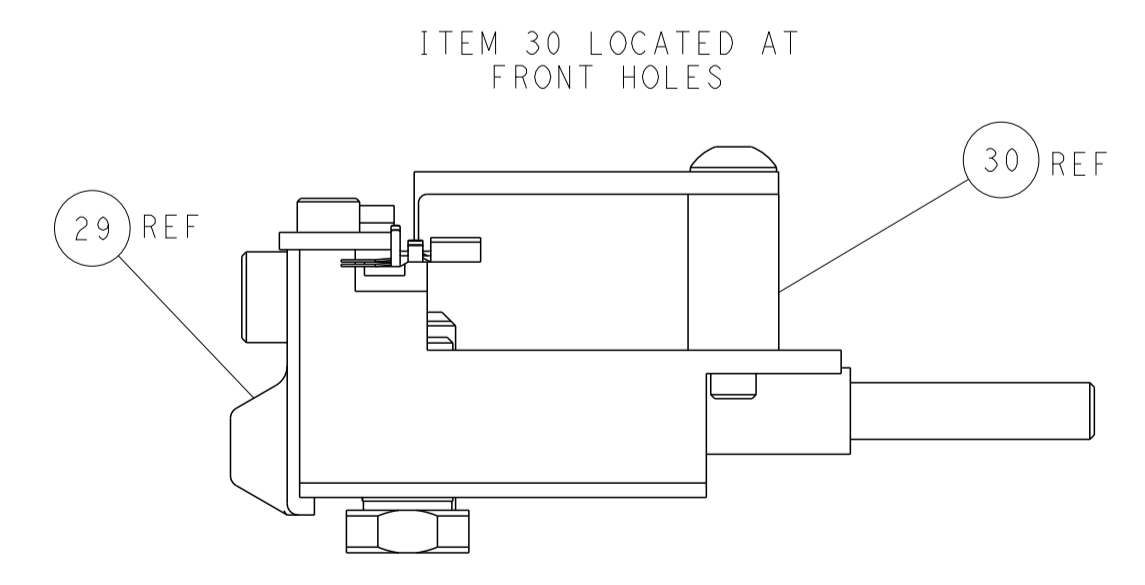
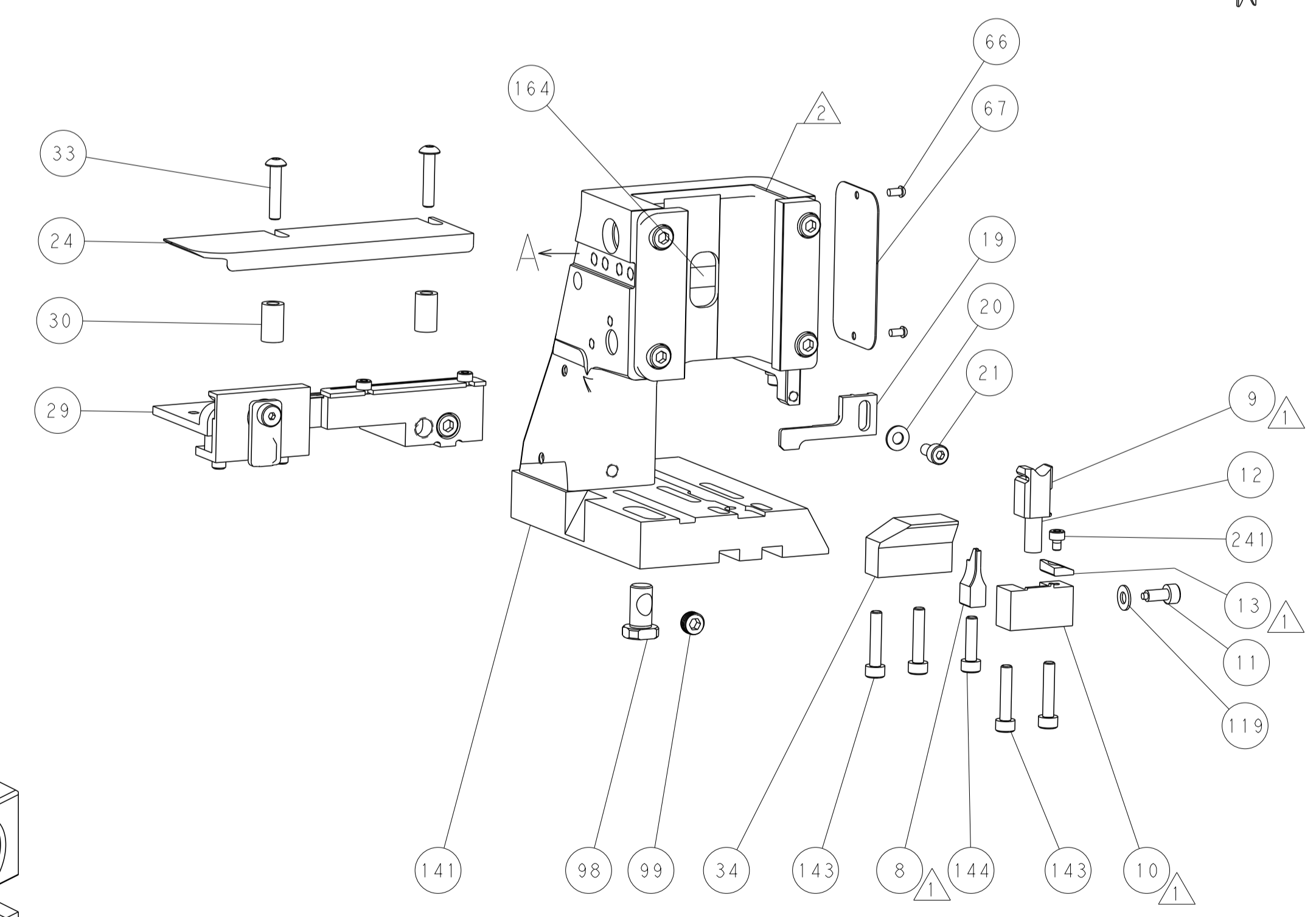
CAM POSITIONS



MECHANICAL POST FEED

MECHANICAL PRE FEED

AIR FEED



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:		DWN C. CHEN 22JUN2011		TE Connectivity	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	5 PLC ±	Harrisburg, PA 17105-3608
ANGLES	FINISH	MATERIAL		CHK S. XI 22JUN2011	NAME	Ocean Side Feed Applicator	
Customer Accessible Production Drawing				APVD J. CRUZ 22JUN2011	PRODUCT SPEC	RESTRICTED TO	
SCALE 1:2				WEIGHT	SIZE CAGE CODE DRAWING NO	A 00779 C=2151127	
SHEET 4 OF 4				Customer Accessible Production Drawing		REV E	