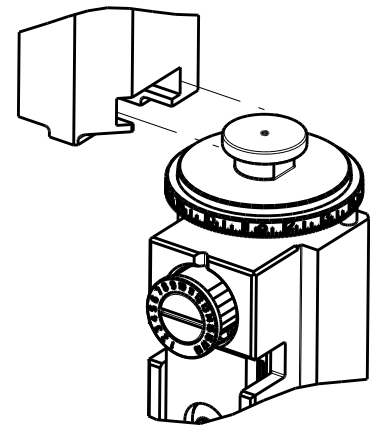


THIS DRAWING IS UNPUBLISHED.		RELEASED FOR PUBLICATION	20
(C) COPYRIGHT 20 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.			
PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151020-1	H	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2151020-2	J	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151020-1	H	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2151020-2	J	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2151020-7	A	CRIMP TOOLING KIT	-



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.40 mm [.055]	F
INSUL	1.57 mm [.062]	O
APPLICATOR INSTRUCTIONS 408-35042		

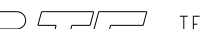
TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: CONTACT, MOD IV CRIMP SNAP-IN			
WIRE STRIP LENGTH 		INSULATION DIAMETER RANGE	
3.58-4.78 mm [1.41-1.88 IN]		Ø0.00-1.75 mm [0.00-.069 IN]	
TERMINAL APPLICATION SPECIFICATION 	114-25003 Rev L	-	-
TERMINALS APPLIED 			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
85969-6	141760-1	141600-1	87309-8
85969-2	1-141097-1	141600-5	87309-9
85969-7	166309-1	171275-1	1-87309-2
85969-8	166309-2	171275-2	87523-2
85969-9	166309-3	171275-4	87523-4
102680-1	166309-4	171275-5	87523-5
102680-2	166309-5	1-87195-7	1-87523-5
86492-2	167301-4	1-87195-9	1-87523-8
86492-4	1-167301-6	2-87195-0	2-87523-3
86492-6	2-167301-2	2-87195-3	6-87523-8
86492-9	2-167301-4	2-87195-4	
1-86492-0			

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING
20 AWG		0.83+/-0.11 [.033+/- .004]		7.5
22 AWG		0.78+/-0.06 [.031+/- .002]		8.4
24 AWG		0.74+/-0.095 [.029+/- .004]		9.2

```
*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.
```

2		1					
LOC	DIST	REVISIONS					
A	66	P	LYR	DESCRIPTION	DATE	DWN	APVD
		F	ECR-17-009860		06 JULY 2017	TB	CT
		G	ECR-18-005223		16 APR 2018	TB	JDG
		H	ECR-18-015251		28 SEP 2018	KH	TE
		J	ECR-19-010779		10 JUL 2019	FZ	TE

	-	1	1	1	1	2280441-1	INSERT, SHEAR	282
	-	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
3	-	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
	-	2	2	2	2	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
5	-	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
	-	1	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	455888-7	SPACER, CRIMPER	82
	-	1	1	1	1	4-240641-1	SPACER	81
	-	1	1	1	1	5-547505-2	SPRING, COMPRESSION	77
	-	1	1	1	1	854769-4	HOLDER, INS	74
	-	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	21028-2	PIN, SLOTTED SPRING .062 X .250	58
	-	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	1-18023-3	SCR, SKT HD CAP M4 X 16.0	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
	-	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	1-455888-0	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
	-	3	3	3	3	1-18028-2	WASHER, FLAT, REG M4	20
	-	1	1	1	1	2119533-1	STRIPPER, SIDE FEED	19
	-	1	1	1	1	690518-1	HOLD DOWN, TERMINAL	18
	-	1	1	1	1	690463-1	FLOATING SHEAR, REAR	17
	-	2	2	2	2	1-2168083-1	SCR, SKT HD CAP, RoHS, M3 X 6	16
1	-	1	1	1	1	1-690691-1	PLATE, REAR SHEAR	15
1	-	1	1	1	1	2119862-1	SHEAR HOLDER, REAR	14
1	-	1	1	1	1	2119806-1	INSERT, SHEAR	13
	-	2	2	2	2	3-22280-3	SPRING, COMPRESSION	12
	-	2	2	2	2	1-356885-4	STOP, SHEAR	11
	-	1	1	1	1	2119805-1	SHEAR HOLDER, FRONT	10
1	-	1	1	1	1	1803095-3	FLOATING SHEAR, FRONT -	9
1	1	2	2	1	1	1338701-1	ANVIL, COMBINATION	8
	-	1	1	1	1	690468-1	DEPRESSOR SHEAR, REAR	6
	-	1	1	1	1	2119780-1	DEPRESSOR, SHEAR	5
	-	1	1	1	1	2-238011-2	BLOCK, CRIMPER SPACER	4
1	1	2	2	1	1	1633966-6	CRIMPER, INSULATION O	3
	-	1	1	1	1	455888-1	SPACER, CRIMPER	2
1	1	2	2	1	1	3-456402-1	CRIMPER, WIRE PREMIUM	1
	-77	-72	-71	-2	-1	PART NO	DESCRIPTION	ITEM NO

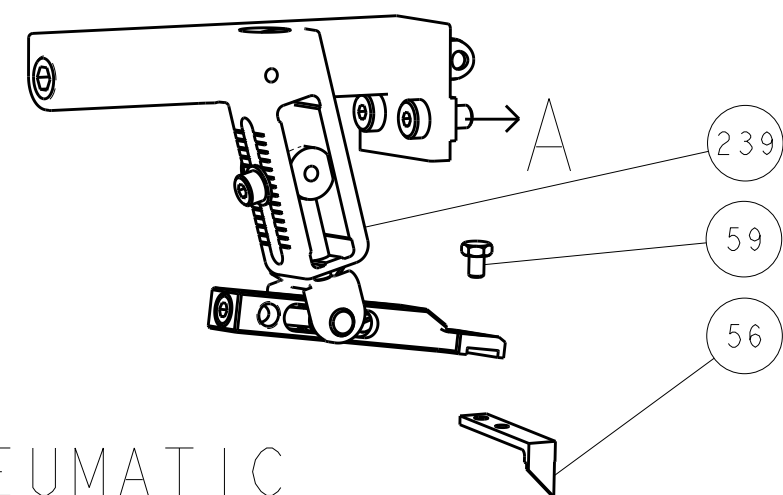
101. DIMENSIONS: THIS COMPANY'S DIMENSIONS ARE BASED ON THE DIMENSIONS SPECIFIED IN THE DRAWING. THE CUSTOMER SHALL BE RESPONSIBLE FOR THE DIMENSIONS SPECIFIED IN THE DRAWING. THE CUSTOMER SHALL BE RESPONSIBLE FOR THE DIMENSIONS SPECIFIED IN THE DRAWING.		OWN 070CT2011 STAKEM CHK G. BAILEY 070CT2011 APP'D FLB/N 070CT2011		 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	
		PRODUCT SPEC APPLICATION SPEC		SIZE CAGE CODE DRAWING NO A 1 00779 C=2151020	
MATERIAL -		FINISH -		RESTRICTED TO -	
Customer Accessible Production Drawing					
		SCALE 1:2		SHEET 1 OF 4 REV J	

SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

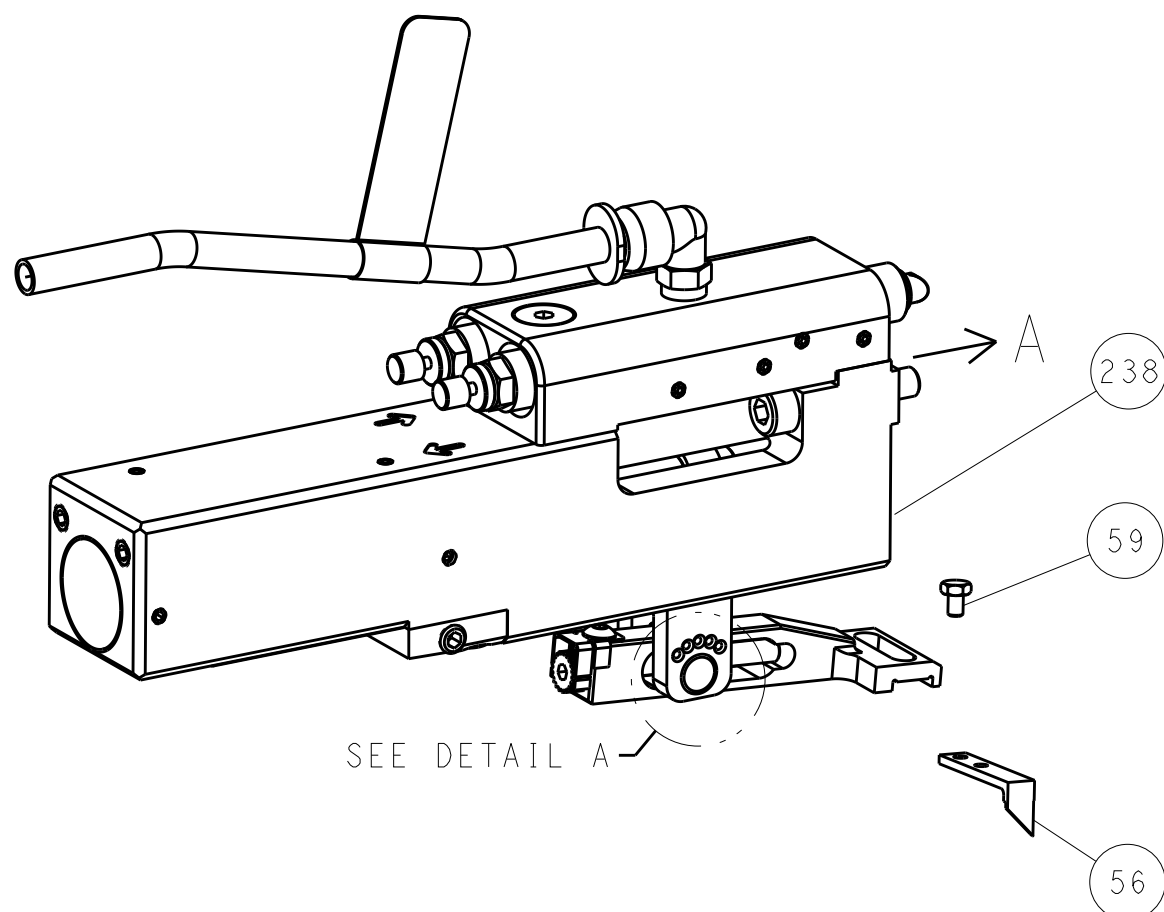
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

LOC		DIST		REVISONS			
A	66	P	LTR	DESCRIPTION	DATE	DWN	APVD
		-		SEE SHEET 1	-	-	-

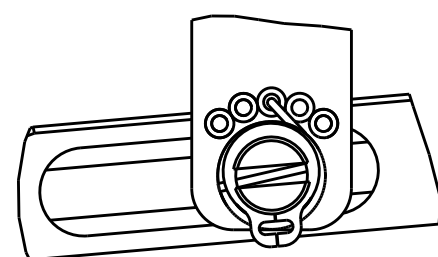
FEED TYPE
MECHANICAL



PNEUMATIC

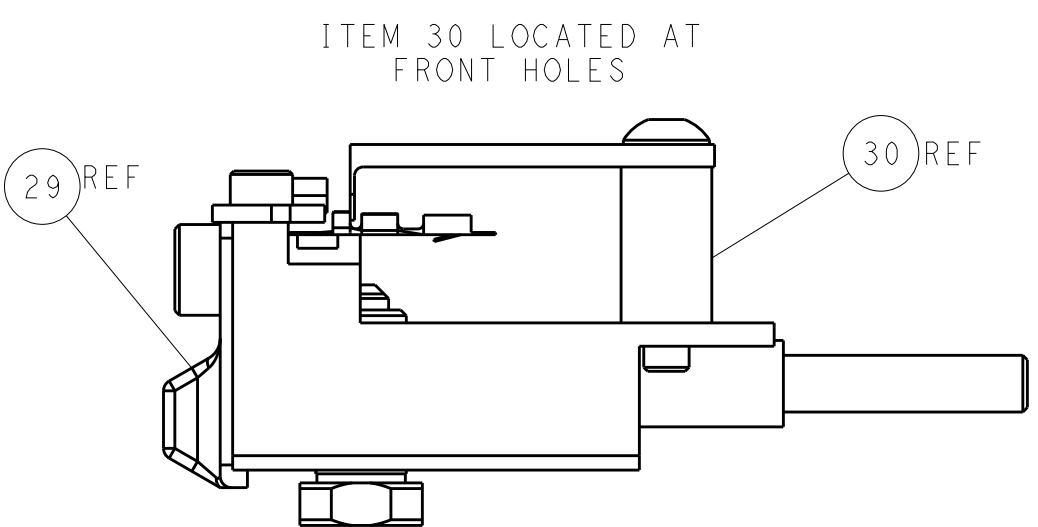
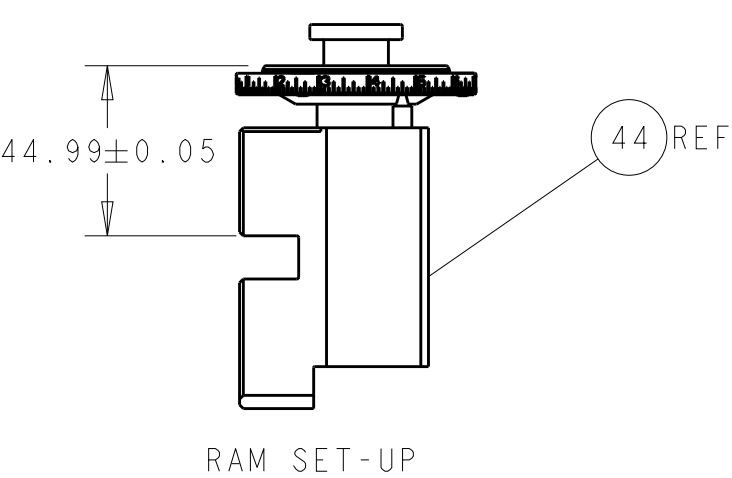
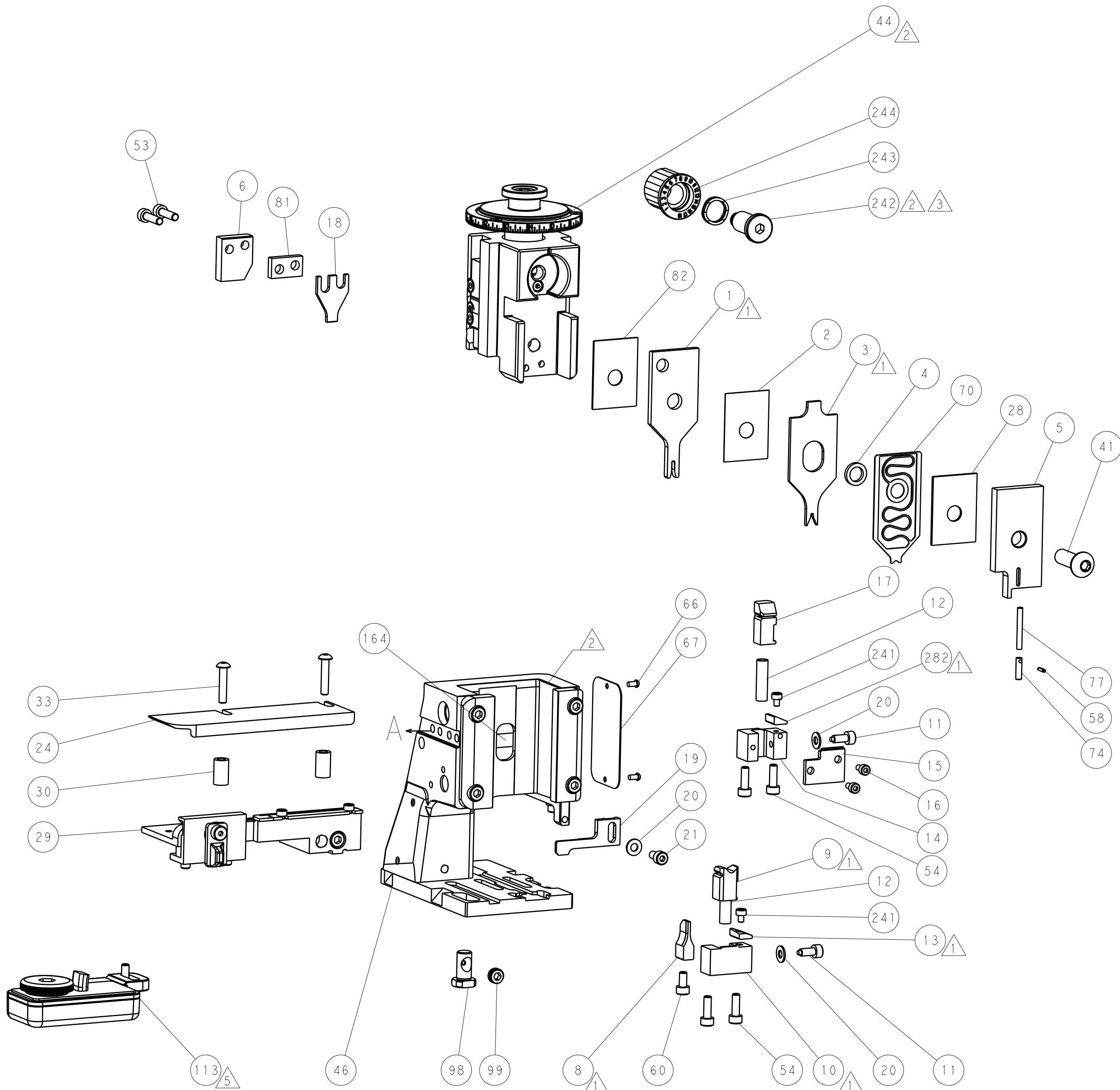
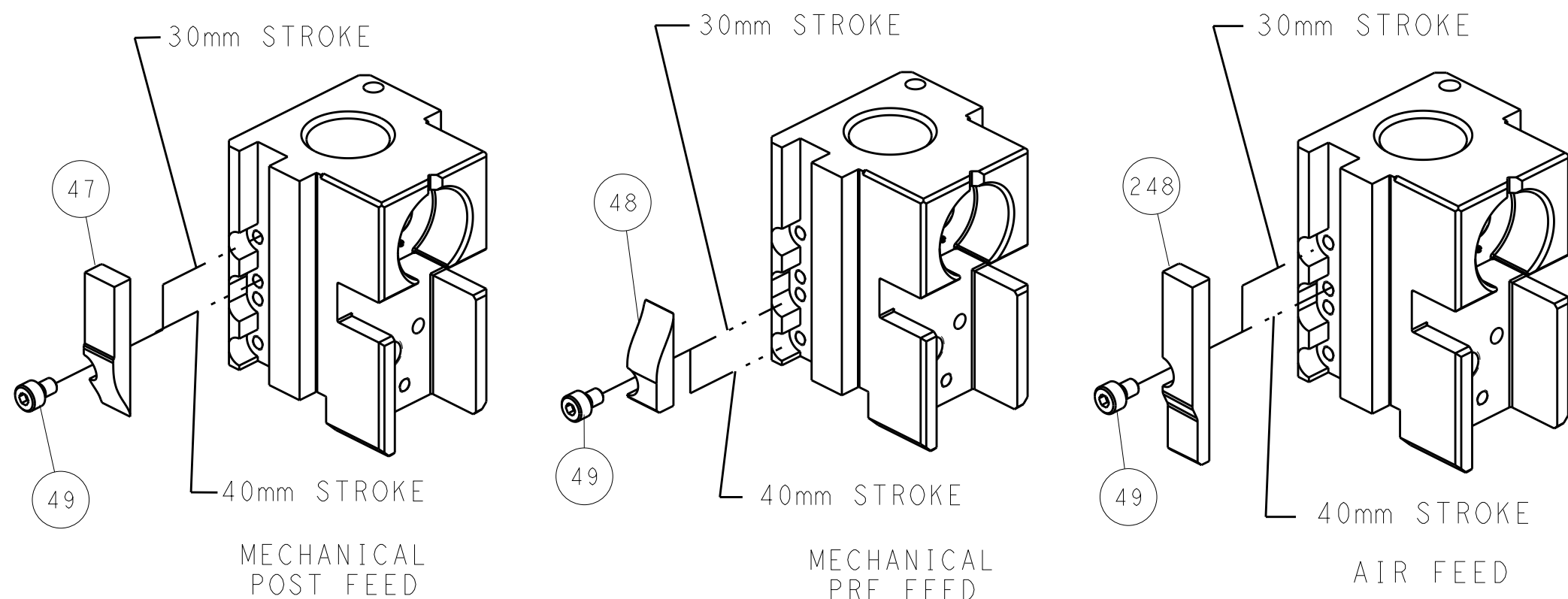


FEED SPRING SETTING POSITION
(SHOWN FROM REAR SIDE)



DETAIL A

CAM POSITIONS

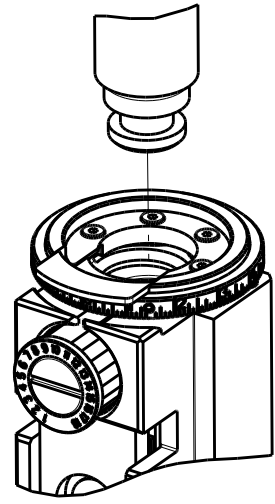


ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

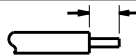
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN: R. STANEM 07OCT2011		CHK: G. BAILEY 07OCT2011		APVD: T. ELBIN 07OCT2011		NAME: Ocean Side Feed Applicator	
mm		0 PLC ±		PRODUCT SPEC		APPLICATION SPEC		SIZE: A1		CAGE CODE: 00779	
MATERIAL: -		FINISH: -		WEIGHT: -		Customer Accessible Production Drawing		SCALE: 1:2		SHEET: 2 of 4	
										REV: J	

8		7	
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20		20	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2151020-1	H	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2151020-2	J	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151020-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.40 mm [.055]	F
INSUL	1.57 mm [.062]	O
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: CONTACT,MOD IV CRIMP SNAP-IN			
WIRE STRIP LENGTH			INSULATION DIAMETER RANGE
3.58-4.78 mm [.141-.188 IN]			Ø0.00-1.75 mm [.000-.069 IN]
TERMINAL APPLICATION SPECIFICATION		114-25003 Rev L	- - -
TERMINALS APPLIED 			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
85969-6	141760-1	141600-1	87309-8
85969-2	1-141097-1	141600-5	87309-9
85969-7	166309-1	171275-1	1-87309-2
85969-8	166309-2	171275-2	87523-2
85969-9	166309-3	171275-4	87523-4
102680-1	166309-4	171275-5	87523-5
102680-2	166309-5	1-87195-7	1-87523-5
86492-2	167301-4	1-87195-9	1-87523-8
86492-4	1-167301-6	2-87195-0	2-87523-3
86492-6	2-167301-2	2-87195-3	6-87523-8
86492-9	2-167301-4	2-87195-4	
1-86492-0			

WIRE SIZE		CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
20 AWG		0.83+/-0.11 [.033+/--.004]	7.5
22 AWG		0.78+/-0.06 [.031+/--.002]	8.4
24 AWG		0.74+/-0.095 [.029+/--.004]	9.2

*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	LTR	DESCRIPTION	DATE	DWN
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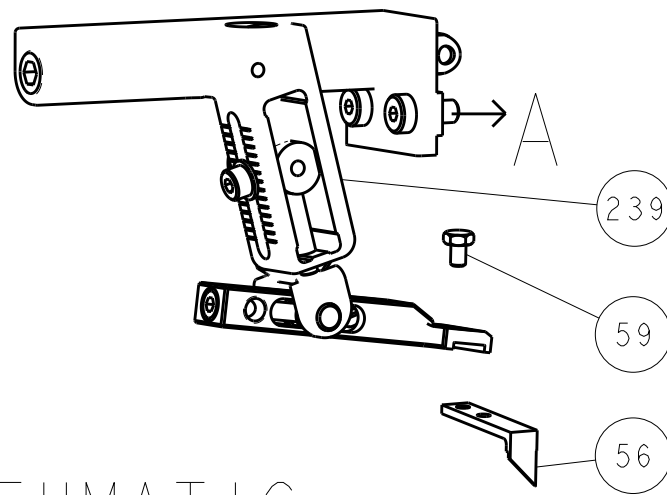
-	1	1	2280441-1	INSERT, SHEAR	282
-	1	1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
3	-	1	2119083-1	RETAINER, INSULATION DIAL	242
-	2	2	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
-	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	1	-	2844940-1	AIR FEED 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
5	-	1	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113
-	1	1	2844908-1	SCREW, LOCKING	99
-	1	1	2844907-1	POST, LOCKING	98
-	1	1	455888-7	SPACER, CRIMPER	82
-	1	1	4-240641-1	SPACER	81
-	1	1	5-547505-2	SPRING, COMPRESSION	77
-	1	1	854769-4	HOLDER, INS	74
-	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	21028-2	PIN, SLOTTED SPRING .062 X .250	58
-	1	1	1338685-1	PAWL, FEED	56
-	2	2	1-18023-3	SCR, SKT HD CAP M4 X 16.0	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
-	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	1-455888-0	SPACER, CRIMPER	28
-	1	1	1320928-2	STRIP GUIDE	24
-	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
-	3	3	1-18028-2	WASHER, FLAT, REG M4	20
-	1	1	2119533-1	STRIPPER, SIDE FEED	19
-	1	1	690518-1	HOLD DOWN, TERMINAL	18
-	1	1	690463-1	FLOATING SHEAR, REAR	17
-	2	2	1-2168083-1	SCR, SKT HD CAP, RoHS, M3 X 6	16
1	-	1	1-690691-1	PLATE,REAR SHEAR	15
1	-	1	2119862-1	SHEAR HOLDER, REAR	14
1	-	1	2119806-1	INSERT, SHEAR	13
-	2	2	3-22280-3	SPRING, COMPRESSION	12
-	2	2	1-356885-4	STOP, SHEAR	11
-	1	1	2119805-1	SHEAR HOLDER, FRONT	10
1	-	1	1803095-3	FLOATING SHEAR, FRONT	9
1	1	1	1338701-1	ANVIL, COMBINATION	8
-	1	1	690468-1	DEPRESSOR SHEAR, REAR	6
-	1	1	2119780-1	DEPRESSOR, SHEAR	5
-	1	1	2-238011-2	BLOCK, CRIMPER SPACER	4
1	1	1	1633966-6	CRIMPER, INSULATION O	3
-	1	1	455888-1	SPACER, CRIMPER	2
1	1	1	3-456402-1	CRIMPER, WIRE PREMIUM	1

THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. ANY ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST EDITION.		DWN R. STAKEM 07OCT2011	TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm		CHK G. BAILEY 07OCT2011	NAME Ocean Side Feed Applicator	
TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.0 1 PLC ±.0 2 PLC ±.0 3 PLC ±.0 4 PLC ±.0 ANGLES ±.0 FINISH		APVD T. ELBIN 07OCT2011	PRODUCT SPEC	
MATERIAL			APPLICATION SPEC	
			WEIGHT	
			Customer Accessible Production Drawing	
			SCALE 1:2	
			SHEET 3 OF 4	
			REV J	

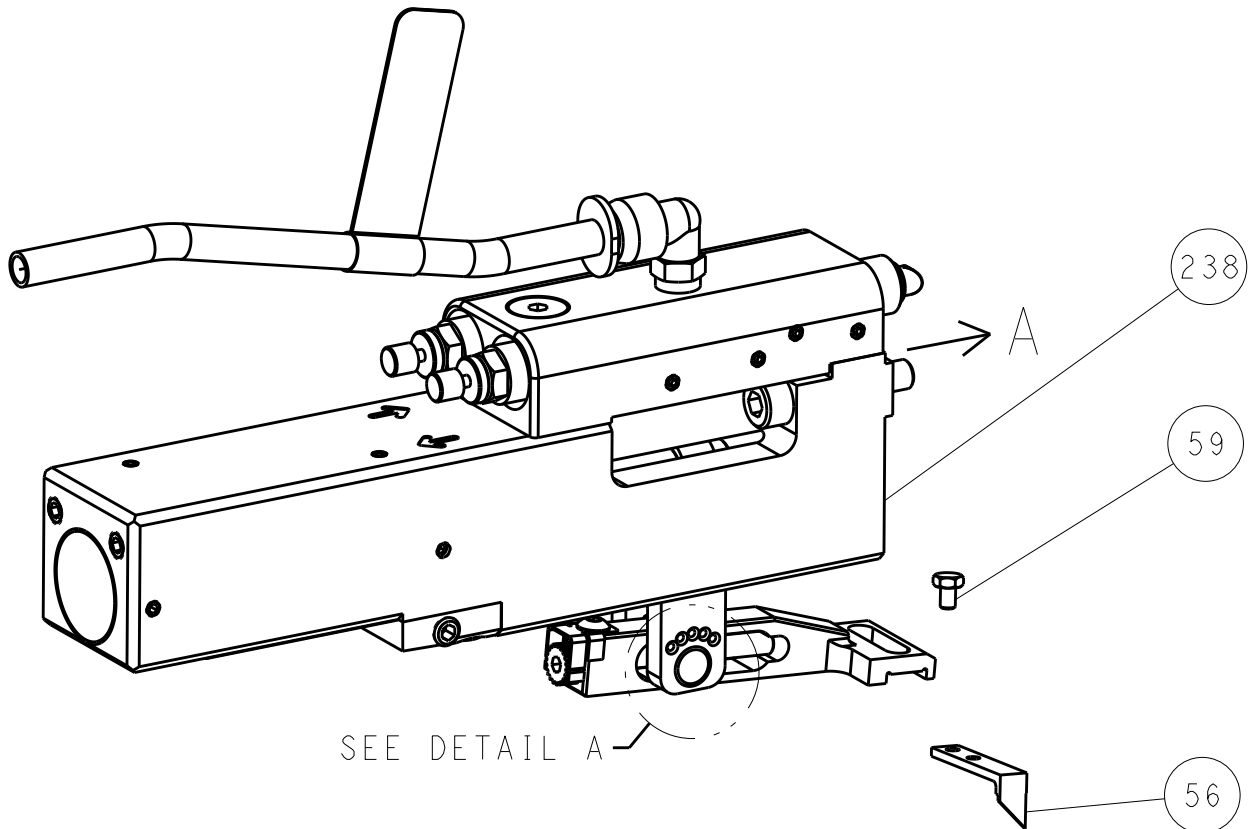
SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

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

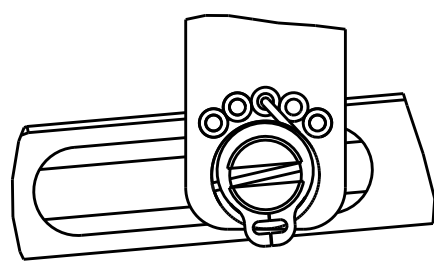
FEED TYPE MECHANICAL



PNEUMATIC

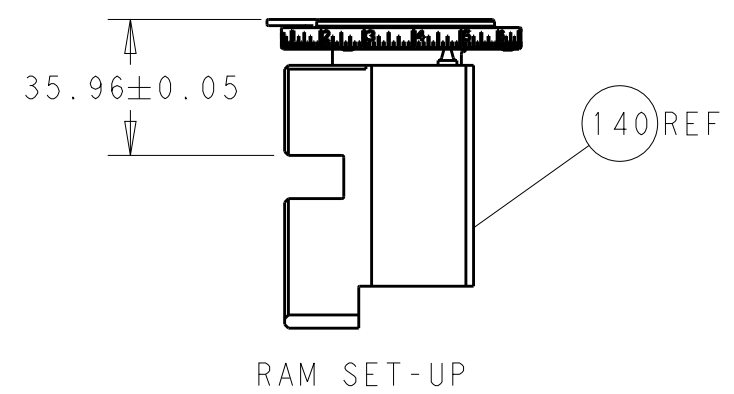
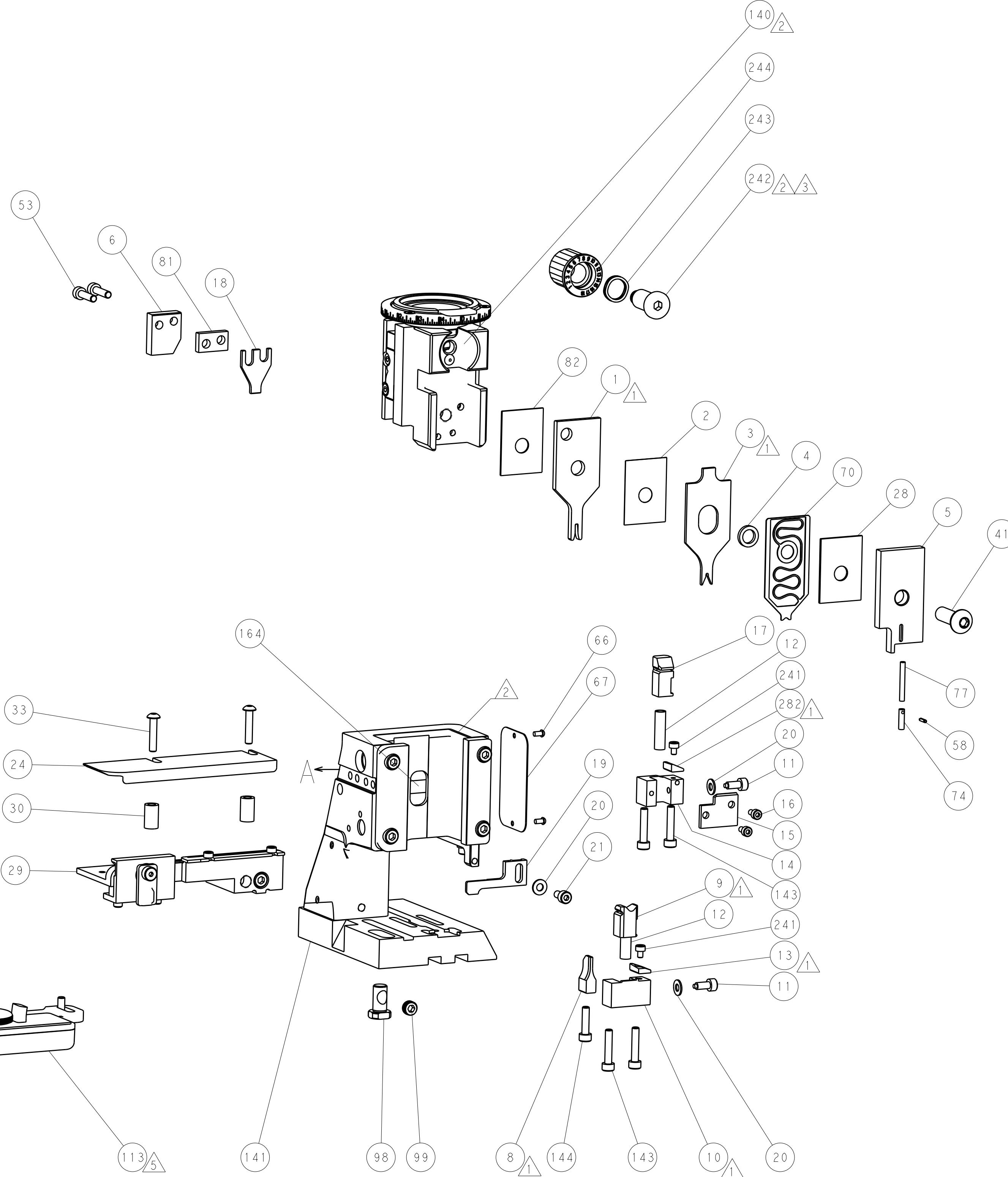
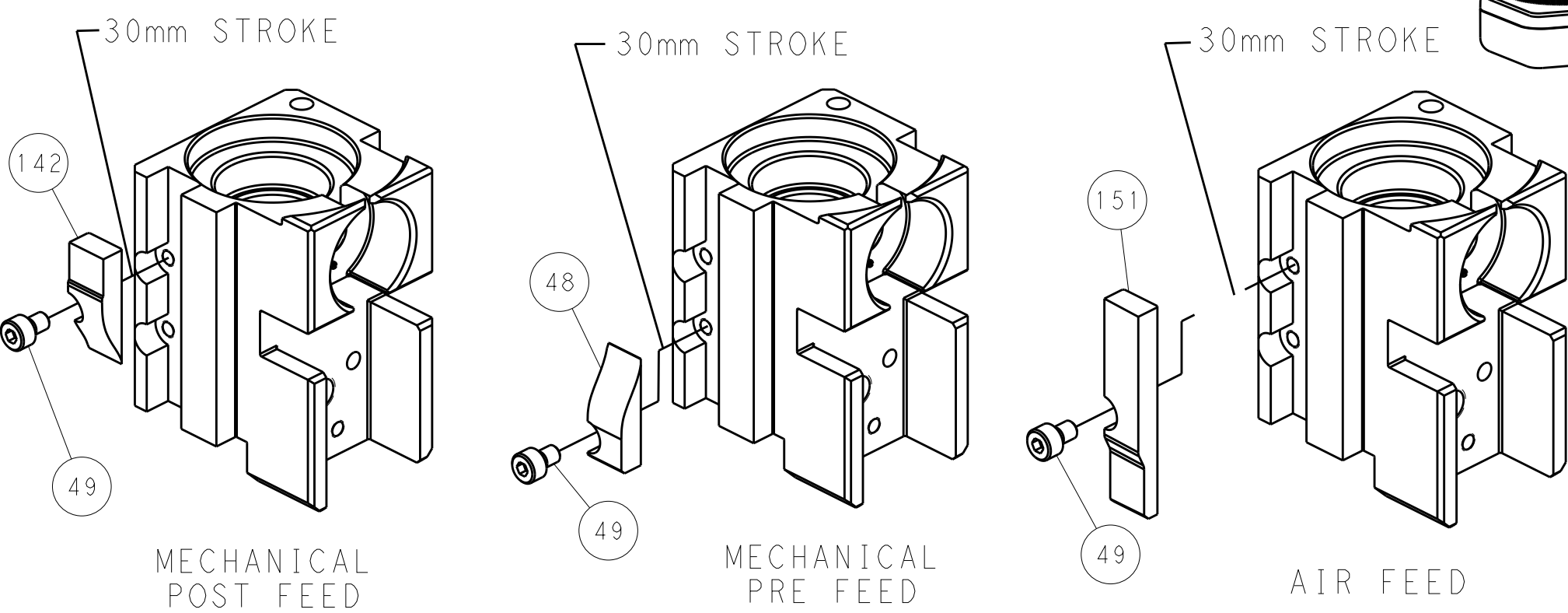


FEED SPRING SETTING POSITION
(SHOWN FROM REAR SIDE)

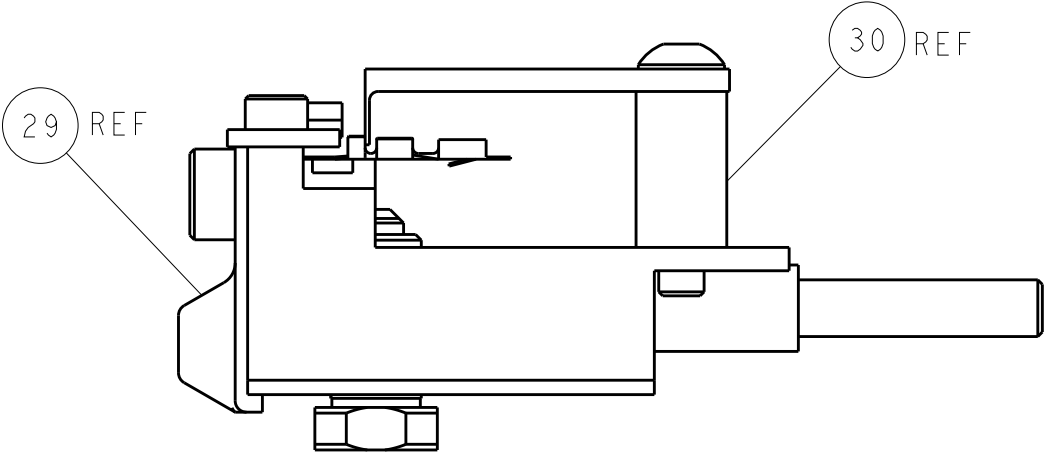


DETAIL A

CAM POSITIONS



ITEM 30 LOCATED AT
FRONT HOLES



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

THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. ANY CHANGES TO THIS DRAWING MUST BE APPROVED BY THE DESIGNING ORGANIZATION. NO PARTS OR MATERIALS SHOULD BE ORDERED FOR THIS DRAWING.				DWN R. STANEM 07OCT2011	 TE Connectivity Harrisburg, PA 17105-3608		
				CHK G. BAILEY 07OCT2011			
				APVD T. ELBIN 07OCT2011	NAME Ocean Side Feed Applicator		
DIMENSIONS: mm				PRODUCT SPEC	SIZE A1		
TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH				APPLICATION SPEC	CAGE CODE 00779		
MATERIAL				WEIGHT	DRAWING NO C-2151020		
				Customer Accessible Production Drawing	RESTRICTED TO		
				SCALE 1:2	SHEET 4 OF 4		
					REV J		