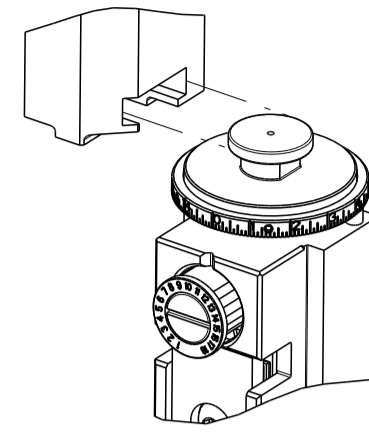


| PART NUMBER | REVISION | DESCRIPTION | FEED TYPE |
|-------------|----------|----------------------------------|------------|
| 2151746-1 | C | FINE CRIMP HEIGHT ADJUST | MECHANICAL |
| 2151746-2 | D | FINE CRIMP HEIGHT ADJUST | PNEUMATIC |
| 7-2151746-1 | C | MECHANICAL AND CRIMP TOOLING KIT | MECHANICAL |
| 7-2151746-2 | D | PNEUMATIC AND CRIMP TOOLING KIT | PNEUMATIC |
| 7-2151746-7 | B | CRIMP TOOLING KIT | - |

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER

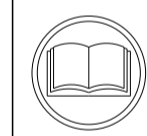


| APPLICATOR DATA | | |
|-----------------|----------------|------|
| CRIMP | SIZE | TYPE |
| WIRE | 2.03 mm [.080] | F |
| INSUL | 3.05 mm [.120] | F |

APPLICATOR INSTRUCTIONS 408-35042

| TERMINAL DATA: TE TERMINAL | | TE CRIMP SPECIFICATION | |
|---|-------------|---|-------------|
| TERMINAL NAME: NEXT GENERATION SOFT SHELL | | | |
| WIRE STRIP LENGTH | | INSULATION DIAMETER RANGE | |
| 4.20-4.80 mm [.165-.189 IN] | | \varnothing 2.40-2.70 mm [.094-.106 IN] | |
| TERMINAL APPLICATION SPECIFICATION | 114-106118 | | |
| TERMINALS APPLIED | | | |
| TE TERMINAL | TE TERMINAL | TE TERMINAL | TE TERMINAL |
| 1971237-1 | 1971237-2 | 1971238-1 | 1971238-2 |

| WIRE SIZE | CRIMP HEIGHT mm [INCH] | CRIMP HEIGHT REFERENCE SETTING |
|-----------|----------------------------|--------------------------------|
| (2)20 AWG | 1.28+/-0.04 [.050+/- .002] | 3.7 |



- 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 ADJUST ITEM 51 WHEN SWITCHING TERMINALS.
- 6 UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.

***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.

| REVISONS | | DATE | OWN | APVD |
|----------|---------------|-----------|-----|------|
| A | RELEASED | 22OCT2012 | YY | SX |
| B | ECR-16-003459 | 07MAR2016 | JH | TE |
| C | ECR-18-008507 | 05JUN2018 | YY | TE |
| D | ECR-22-135201 | 06APR2022 | TB | RK |

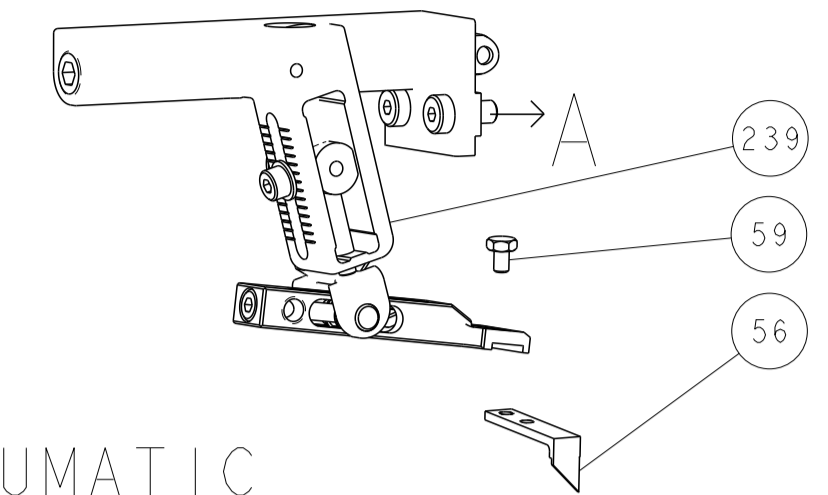
| | | | | | | | |
|---|-----|-----|-----|-----|-------------|-------------------------------------|-----|
| - | 1 | - | 1 | - | 2119641-1 | FEED CAM, AIR FEED | 248 |
| - | 1 | 1 | 1 | 1 | 2119082-6 | CAM, SNAIL, INSULATION ADJUSTMENT | 244 |
| - | 1 | 1 | 1 | 1 | 2079764-1 | WASHER, WAVE SPRING, CREST-TO-CREST | 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 | - | - | 2119580-1 | MECHANICAL FEED ASSEMBLY | 239 |
| - | 1 | - | 1 | - | 2844940-1 | AIR FEED MODULE | 238 |
| - | REF | REF | REF | REF | 994970-2 | COUNTER, MAGNETIC | 164 |
| - | 2 | 2 | 2 | 2 | 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 | 455888-5 | SPACER, CRIMPER | 82 |
| - | 1 | 1 | 1 | 1 | 1803607-3 | DOCUMENTATION PACKAGE | 71 |
| - | 1 | 1 | 1 | 1 | 2119791-9 | DEPRESSOR, WIRE | 70 |
| - | 1 | 1 | 1 | 1 | 2119943-1 | WASHER, SPACER | 69 |
| - | 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 | 2168083-3 | SCR, SKT HD CAP, RoHS, M4 X 12.0 | 53 |
| - | 1 | 1 | 1 | 1 | 5018030-1 | NUT, HEX, REG, RoHS, M3 | 52 |
| 5 | - | 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 | - | - | 2119652-1 | FEED CAM, PRE FEED | 48 |
| - | - | 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 | 1752356-1 | 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 | 2-455888-2 | 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 |
| - | 1 | 1 | 1 | 1 | 2119533-1 | 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 | 1803095-1 | FLOATING SHEAR, FRONT | 9 |
| 1 | 1 | 2 | 2 | 1 | 1-1803079-4 | ANVIL, WITH STABILIZER | 8 |
| - | 1 | 1 | 1 | 1 | 4-240641-2 | SPACER | 7 |
| - | - | - | - | - | - | - | 6 |
| - | 1 | 1 | 1 | 1 | 1-2119757-3 | DEPRESSOR, SHEAR | 5 |
| - | 1 | 1 | 1 | 1 | 238011-2 | BLOCK, CRIMPER SPACER | 4 |
| 1 | 1 | 2 | 2 | 1 | 1-1803016-5 | CRIMPER, INSULATION F | 3 |
| - | - | - | - | - | - | - | 2 |
| 1 | 1 | 2 | 2 | 1 | 5-456405-6 | 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)

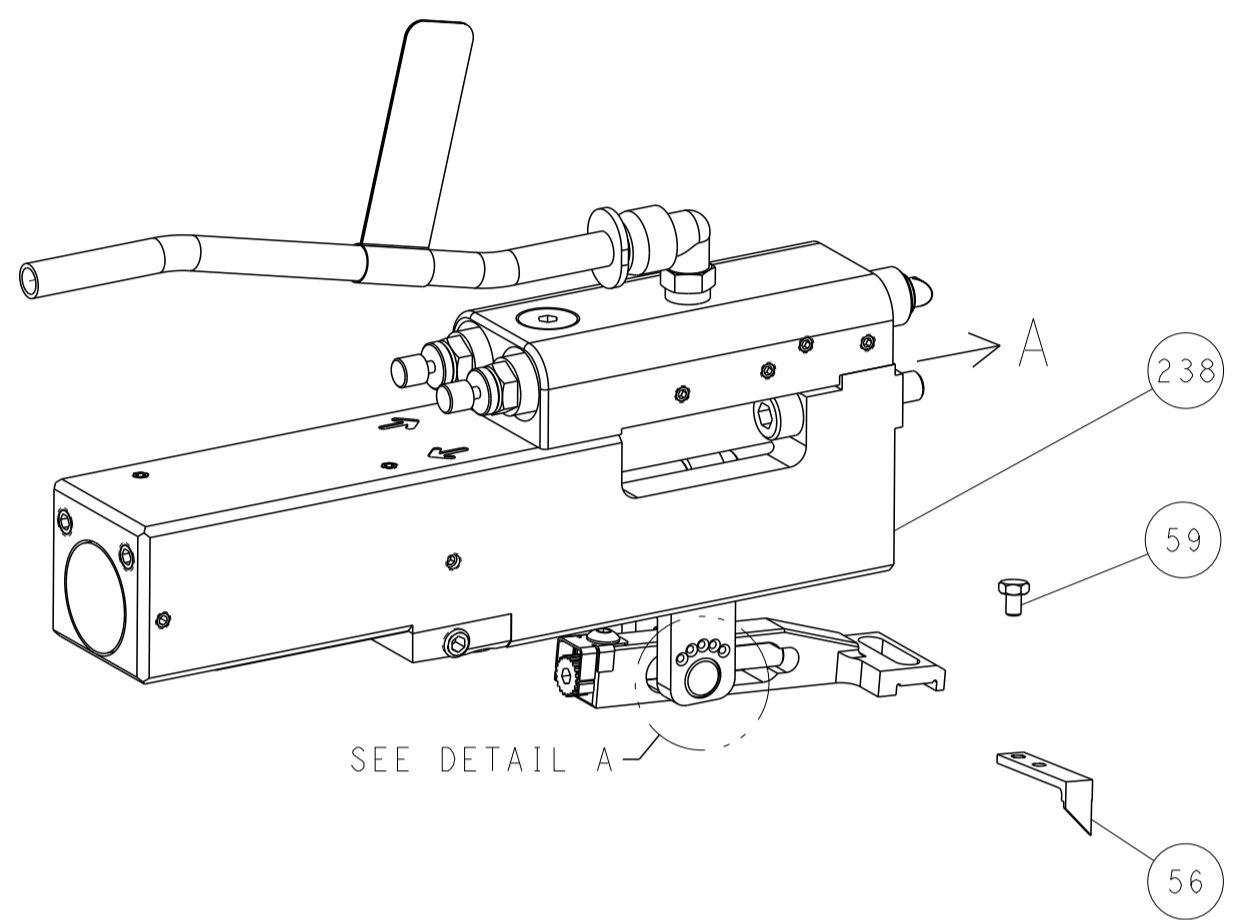
| DIMENSIONS: | TOLERANCES UNLESS OTHERWISE SPECIFIED: | OWN | DATE | REV | DESCRIPTION | ITEM NO |
|-------------|---|-----------|-----------|-----|--|-----------|
| mm | 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± | Y. YIN | 05SEP2012 | 1 | TE Connectivity Harrisburg, PA 17105-3608 | |
| | | G. BAILEY | 05SEP2012 | 1 | | |
| | | S. XI | 05SEP2012 | 1 | | |
| | | | | | Ocean Side Feed Applicator | |
| | | | | | SIZE | CAGE CODE |
| | | | | | A1 | 00779 |
| | | | | | DRAWING NO | C=2151746 |
| | | | | | SCALE | 1:2 |
| | | | | | SHEET | 1 OF 4 |
| | | | | | REV | D |

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

FEED TYPE MECHANICAL



PNEUMATIC

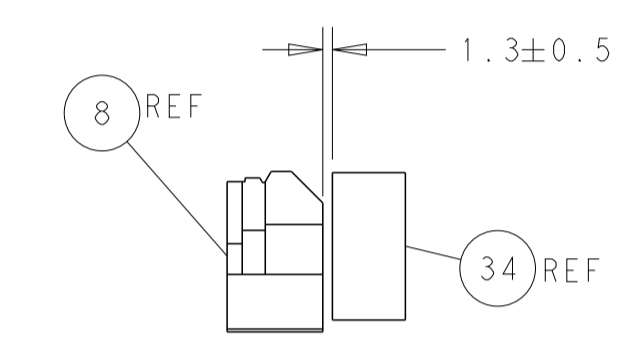
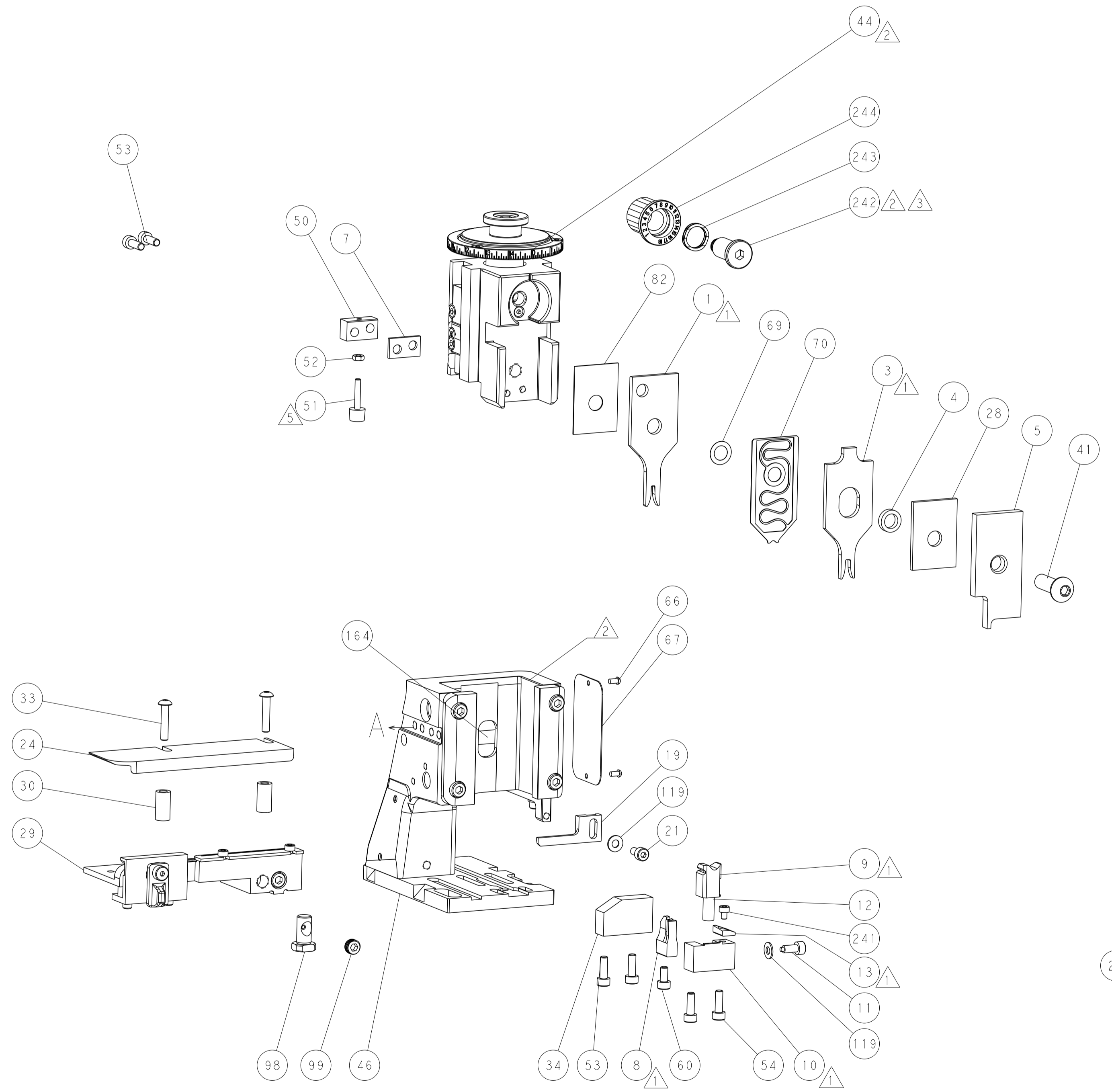
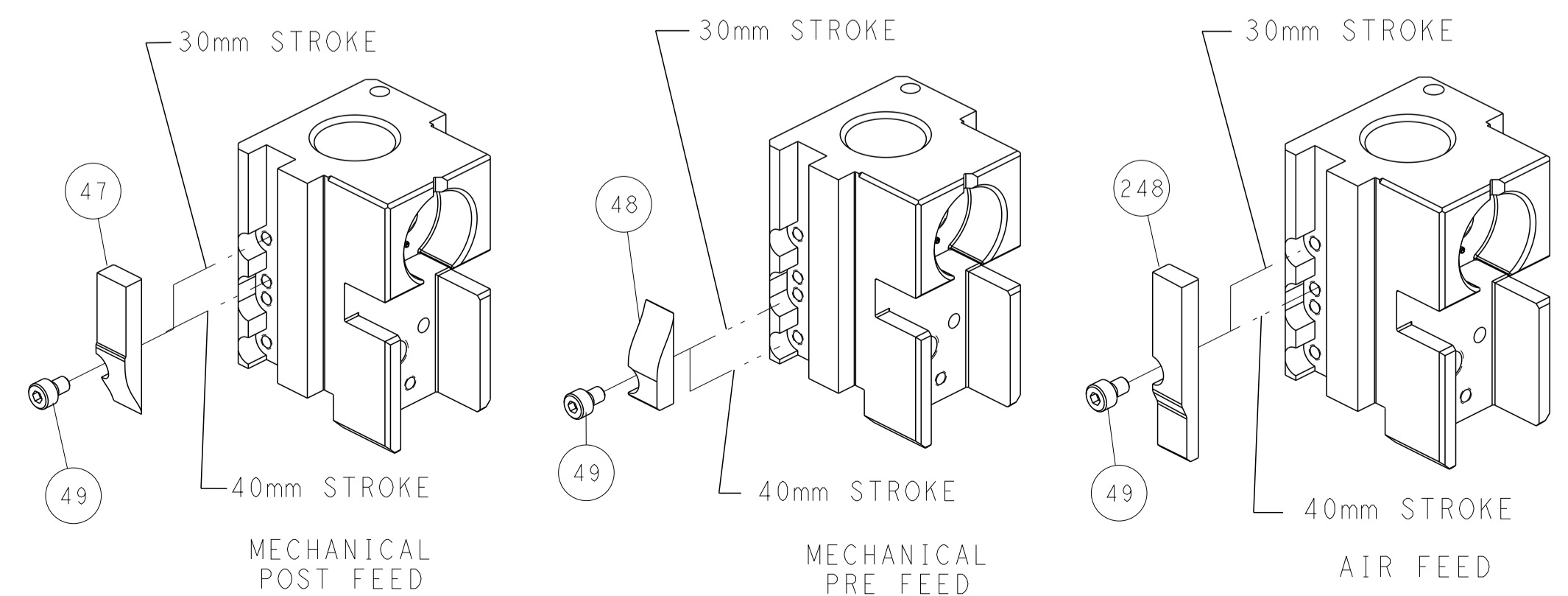


FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)

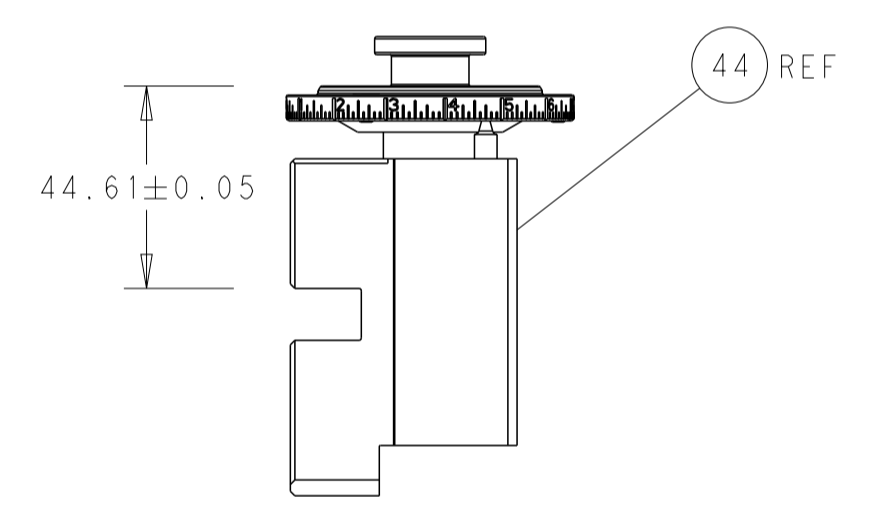


DETAIL A

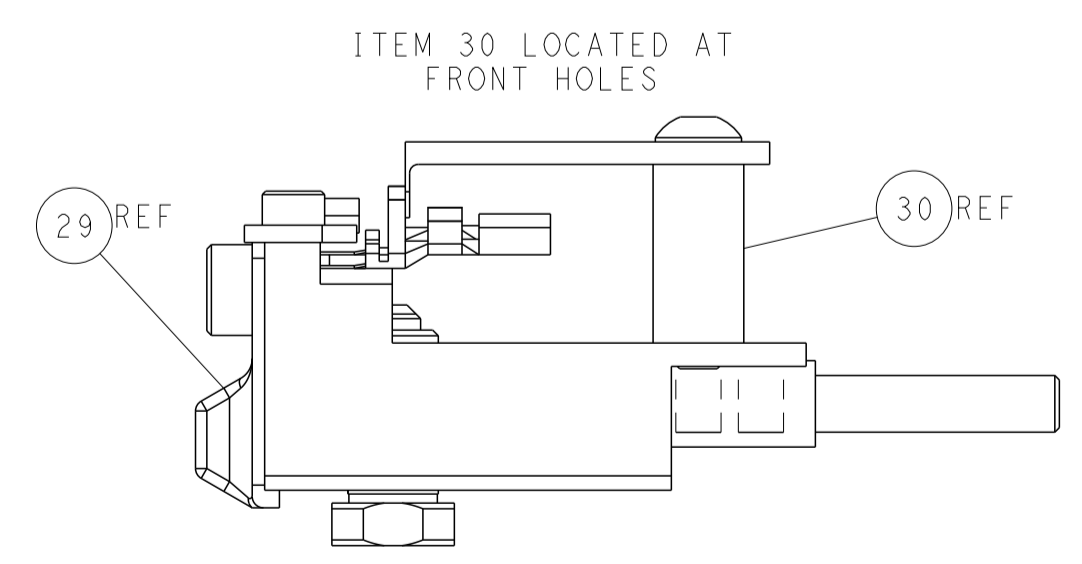
CAM POSITIONS



TERMINAL SUPPORT LOCATION



RAM SET-UP



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: | | TOLERANCES UNLESS OTHERWISE SPECIFIED: | | DWN Y. YIN 05SEP2012 | | TE Connectivity | |
| mm | 0 PLC ± | 1 PLC ± | 2 PLC ± | 3 PLC ± | 4 PLC ± | Harrisburg, PA 17105-3608 | |
| MATERIAL: | | FINISH: | | CHK G. BAILEY 05SEP2012 | | NAME | |
| | | | | S. XI 05SEP2012 | | Ocean Side Feed | |
| | | | | APVD | | Applicator | |
| | | | | PRODUCT SPEC | | SIZE CAGE CODE DRAWING NO | |
| | | | | APPLICATION SPEC | | A1 00779 C=2151746 | |
| | | | | WEIGHT | | RESTRICTED TO | |
| | | | | CUSTOMER DRAWING | | SCALE 1:2 SHEET 2 OF 4 REV D | |

| PART NUMBER | REVISION | DESCRIPTION | FEED TYPE |
|-------------|----------|--------------------------|------------|
| 2-2151746-1 | C | FINE CRIMP HEIGHT ADJUST | MECHANICAL |
| 2-2151746-2 | D | FINE CRIMP HEIGHT ADJUST | PNEUMATIC |
| 7-2151746-7 | B | CRIMP TOOLING KIT | - |

PACIFIC VERSION TERMINATOR
 INTERFACE ADAPTER



| APPLICATOR DATA | | |
|-----------------|----------------|------|
| CRIMP | SIZE | TYPE |
| WIRE | 2.03 mm [.080] | F |
| INSUL | 3.05 mm [.120] | F |

APPLICATOR INSTRUCTIONS
 408-35042

| | | | |
|---|-------------|-------------------------------|-------------|
| TERMINAL DATA: TE TERMINAL | | TE CRIMP SPECIFICATION | |
| TERMINAL NAME: NEXT GENERATION SOFT SHELL | | | |
| WIRE STRIP LENGTH | | INSULATION DIAMETER RANGE | |
| 4.20-4.80 mm [1.65-.189 IN] | | Ø2.40-2.70 mm [1.094-.106 IN] | |
| TERMINAL APPLICATION SPECIFICATION | 114-106118 | - | - |
| TERMINALS APPLIED | | | |
| TE TERMINAL | TE TERMINAL | TE TERMINAL | TE TERMINAL |
| 1971237-1 | 1971237-2 | 1971238-1 | 1971238-2 |

| WIRE SIZE | CRIMP HEIGHT mm [INCH] | CRIMP HEIGHT REFERENCE SETTING |
|------------|----------------------------|--------------------------------|
| (2120 AWG) | 1.28+/-0.04 [1.050+/-0.02] | 3.7 |



- 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 ADJUST ITEM 51 WHEN SWITCHING TERMINALS.
- 6. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.

***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 | DWN | APVD |
| - | - | - | - | SEE SHEET 1 | - | - | - |

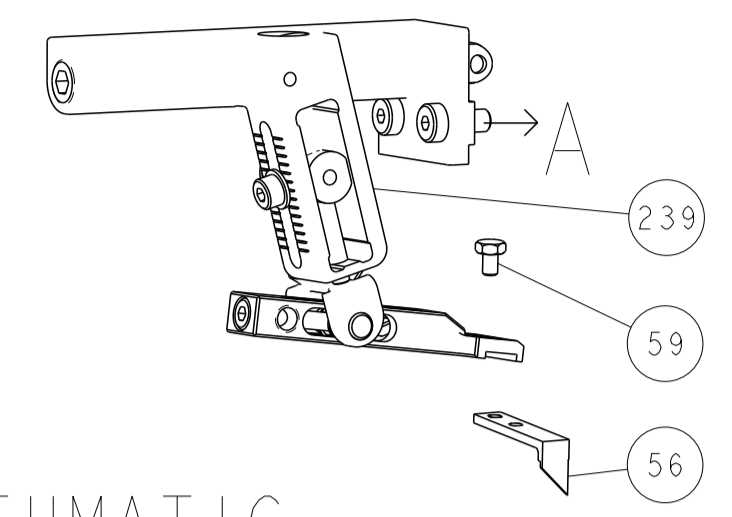
| | | | | | |
|-----|-----|-----|-------------|-------------------------------------|---------|
| - | 1 | 1 | 2119082-6 | CAM, SNAIL, INSULATION ADJUSTMENT | 244 |
| - | 1 | 1 | 2079764-1 | WASHER, WAVE SPRING, CREST-TO-CREST | 243 |
| - | 1 | 1 | 2119083-1 | RETAINER, INSULATION DIAL | 242 |
| - | 1 | 1 | 7-18023-7 | SCR, SKT HD CAP M3 X 4.0 | 241 |
| - | - | 1 | 2119580-1 | MECHANICAL FEED ASSEMBLY | 239 |
| - | 1 | - | 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 |
| - | 2 | 2 | 1-18028-2 | WASHER, FLAT, REG M4 | 119 |
| - | 1 | 1 | 2844908-1 | SCREW, LOCKING | 99 |
| - | 1 | 1 | 2844907-1 | POST, LOCKING | 98 |
| - | 1 | 1 | 455888-5 | SPACER, CRIMPER | 82 |
| - | 1 | 1 | 1803607-3 | DOCUMENTATION PACKAGE | 71 |
| - | 1 | 1 | 2119791-9 | DEPRESSOR, WIRE | 70 |
| - | 1 | 1 | 2119943-1 | WASHER, SPACER | 69 |
| - | 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 | 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 | 3-2844962-2 | SPACER, CYLINDRICAL, STRIP GUIDE | 30 |
| - | 1 | 1 | 2844992-1 | ASSEMBLY, STRIP GUIDE | 29 |
| - | 1 | 1 | 2-455888-2 | SPACER, CRIMPER | 28 |
| - | 1 | 1 | 1320928-2 | STRIP GUIDE | 24 |
| - | 1 | 1 | 2168083-2 | SCR, SKT HD CAP, RoHS, M4 X 8.0 | 21 |
| - | 1 | 1 | 2119533-1 | 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 | 1803095-1 | FLOATING SHEAR, FRONT | 9 |
| - | 1 | 1 | 1-1803079-4 | ANVIL, WITH STABILIZER | 8 |
| - | 1 | 1 | 4-240641-2 | SPACER | 7 |
| - | - | - | - | - | 6 |
| - | 1 | 1 | 1-2119757-3 | DEPRESSOR, SHEAR | 5 |
| - | 1 | 1 | 238011-2 | BLOCK, CRIMPER SPACER | 4 |
| - | 1 | 1 | 1-1803016-5 | CRIMPER, INSULATION F | 3 |
| - | - | - | - | - | 2 |
| - | 1 | 1 | 5-456405-6 | CRIMPER, WIRE PREMIUM | 1 |
| -77 | -22 | -21 | PART NO | DESCRIPTION | ITEM NO |

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

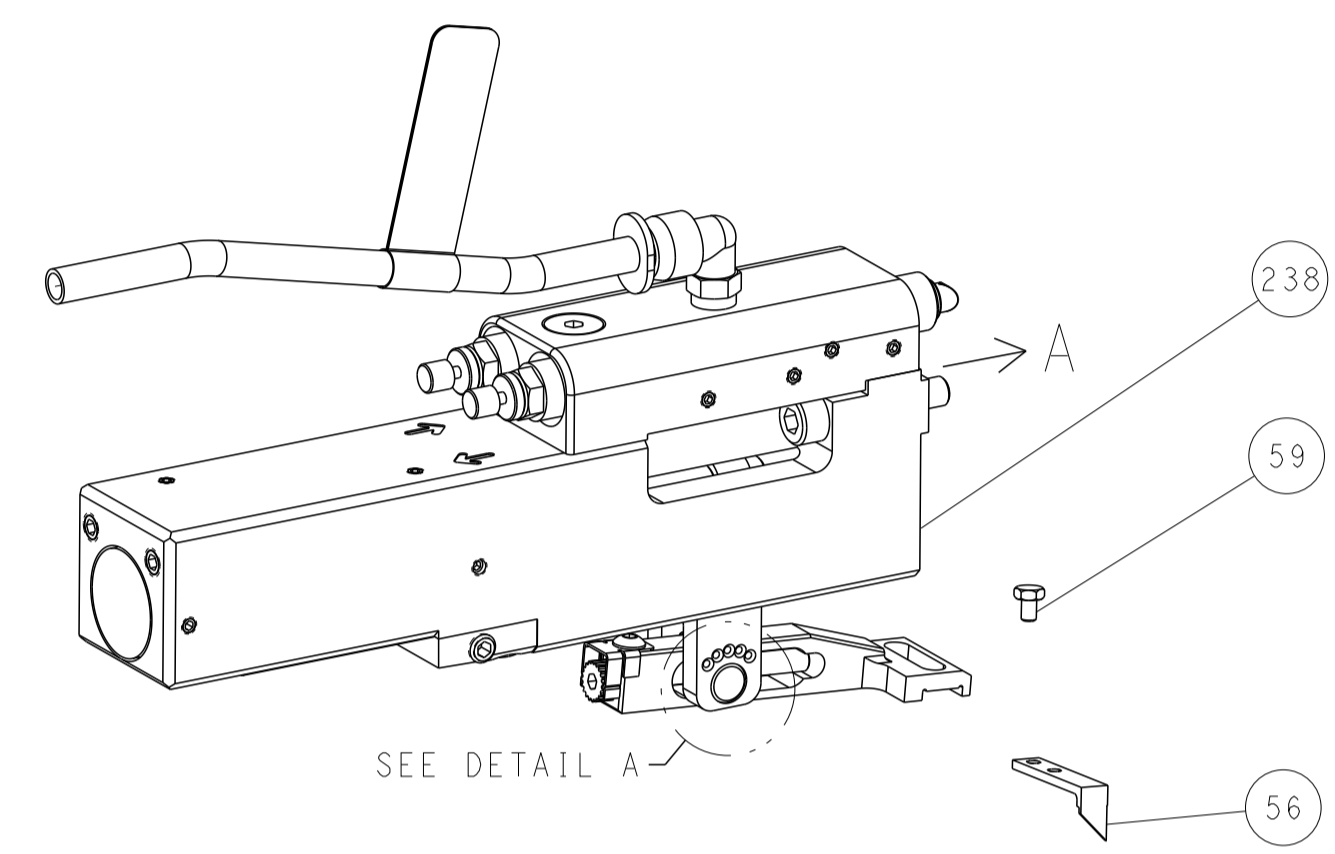
| | | | | | | | | | | | |
|-------------|---------|--|---------|-----------------------|---------|--------------------------|--------|-----------------------|------------------|----------------------------------|------------------|
| DIMENSIONS: | | TOLERANCES UNLESS OTHERWISE SPECIFIED: | | DWG: Y. YIN 05SEP2012 | | CHK: G. BAILEY 05SEP2012 | | APVD: S. XI 05SEP2012 | | NAME: Ocean Side Feed Applicator | |
| mm | 0 PLC ± | 1 PLC ± | 2 PLC ± | 3 PLC ± | 4 PLC ± | ANGLES ± | FINISH | SIZE: A1 | CAGE CODE: 00779 | DRAWING NO: C=2151746 | RESTRICTED TO: - |
| MATERIAL: - | | | | | | | | WEIGHT: - | CUSTOMER DRAWING | | SCALE: 1:2 |
| | | | | | | | | SHEET: 3 | OF: 4 | REV: D | |

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

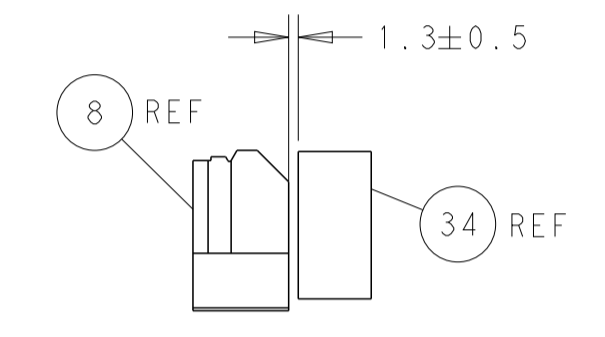
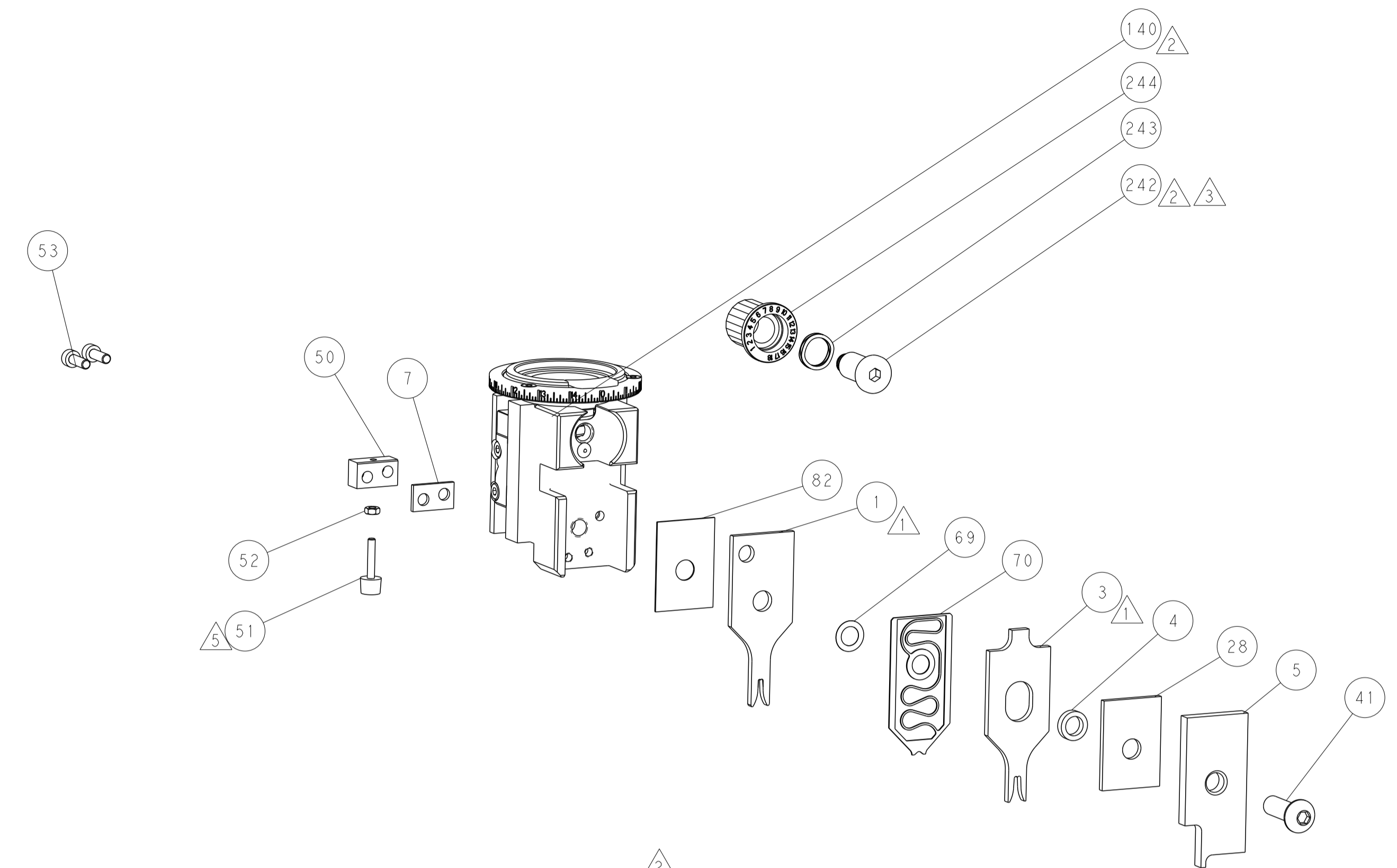
FEED TYPE MECHANICAL



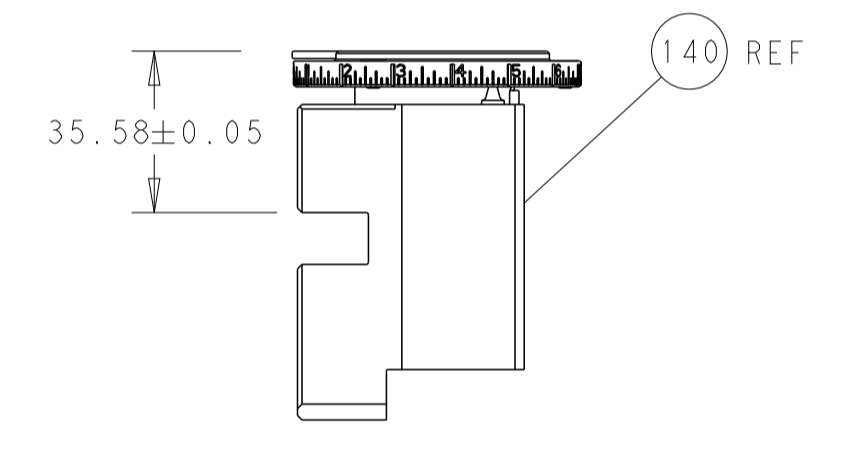
PNEUMATIC



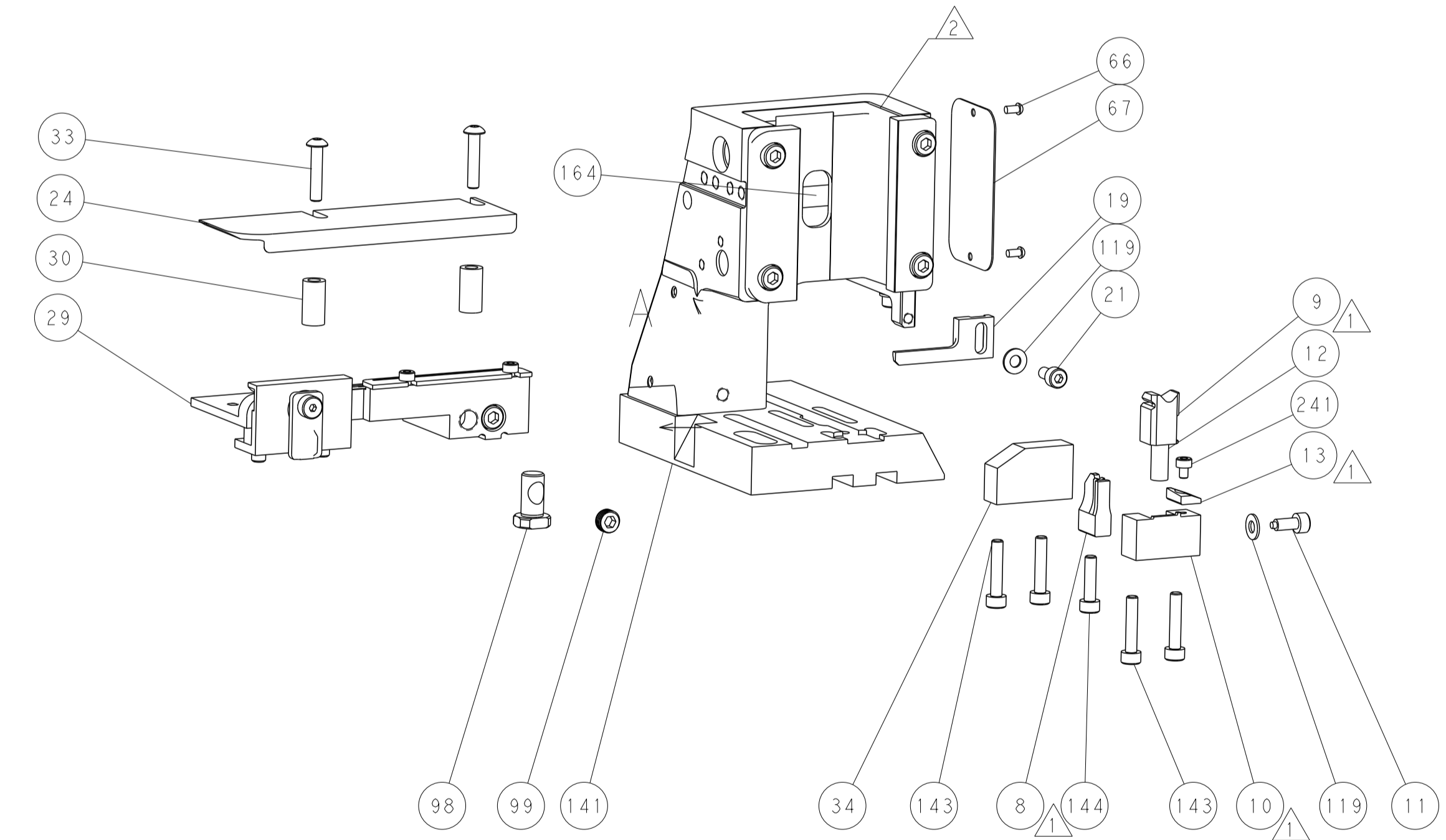
FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



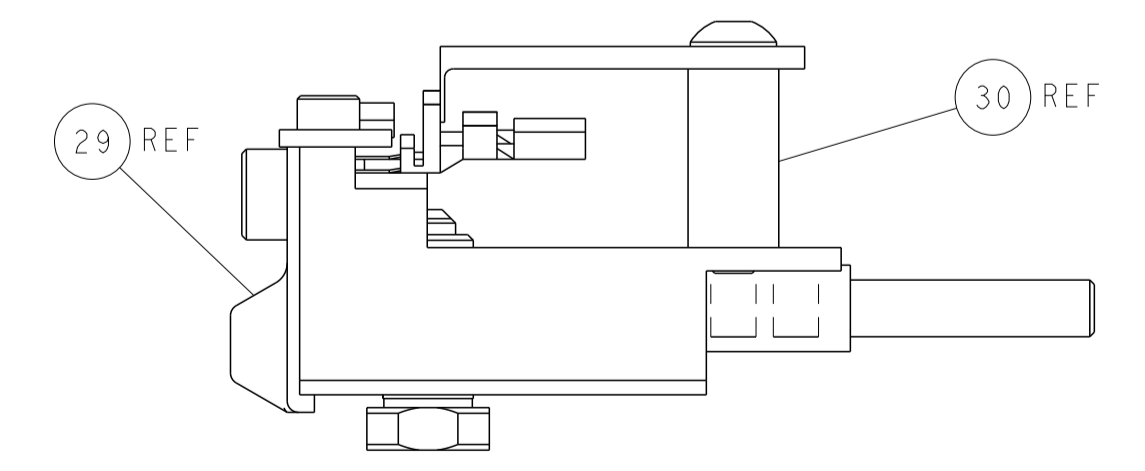
TERMINAL SUPPORT LOCATION



RAM SET-UP

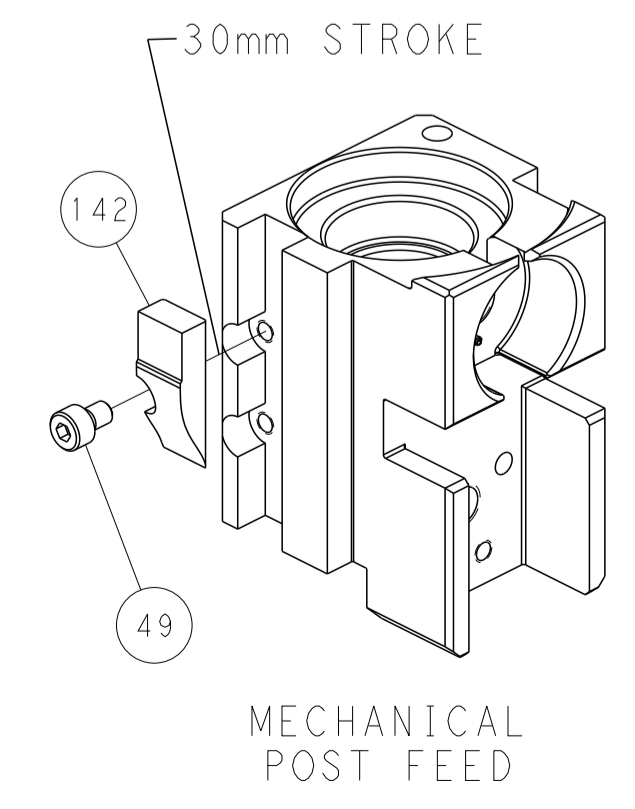


ITEM 30 LOCATED AT FRONT HOLES

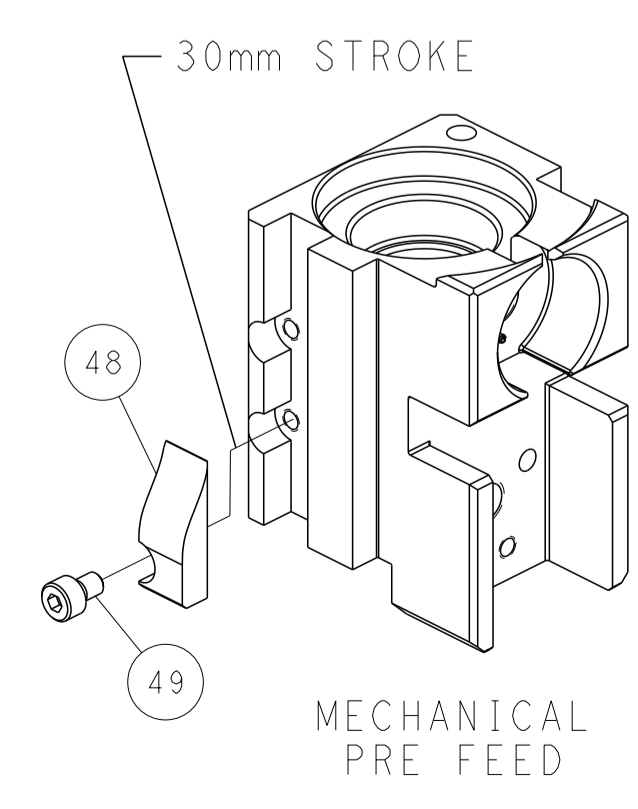


FEED TRACK POSITION GUIDE BY INSULATION BARREL

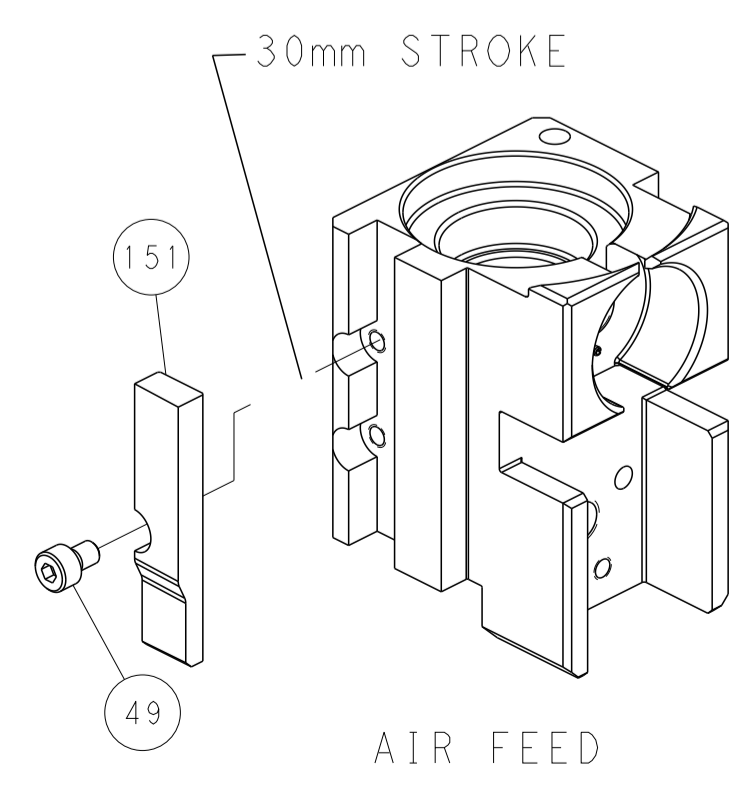
CAM POSITIONS



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: | | DWN Y. YIN 05SEP2012 | | TE Connectivity | |
| mm | 0 PLC ± | 1 PLC ± | 2 PLC ± | 3 PLC ± | 4 PLC ± | 5 PLC ± | Harrisburg, PA 17105-3608 |
| MATERIAL: | | FINISH: | | CHK G. BAILEY 05SEP2012 | | NAME | |
| | | | | S. XI 05SEP2012 | | Ocean Side Feed | |
| | | | | APVD | | Applicator | |
| | | | | PRODUCT SPEC | | SIZE CAGE CODE DRAWING NO | |
| | | | | APPLICATION SPEC | | A1 00779 C=2151746 | |
| | | | | WEIGHT | | RESTRICTED TO | |
| | | | | CUSTOMER DRAWING | | SCALE 1:2 SHEET 4 OF 4 REV D | |