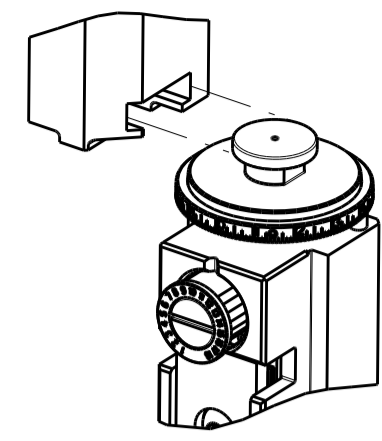


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151257-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2151257-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151257-1	C	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2151257-2	C	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2151257-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.78 mm [.070]	F
INSUL	3.84 mm [.151]	O

APPLICATOR INSTRUCTIONS
408-35042

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: JUNIOR POWER TIMER RECEPTACLE			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
4.90-5.50 mm [.193-.217 IN]		∅	
TERMINAL APPLICATION SPECIFICATION	114-15076	-	-

TERMINALS APPLIED				SEAL INSULATION DIAMETER RANGE
TE TERMINAL	TE TERMINAL	TE SEAL	TE SEAL	
185026-1	185026-4		828904-1	1.2-2.1
185026-3				

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.00mm2	1.50+/-0.05 [.059+/-0.002]	4.1
0.75mm2	1.40+/-0.05 [.055+/-0.002]	5.2
0.60mm2	1.32+/-0.05 [.052+/-0.002]	6.1
0.50mm2	1.27+/-0.05 [.050+/-0.002]	6.7
0.35mm2	1.21+/-0.05 [.048+/-0.002]	7.1

- 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 APPLY TORQ-SEAL IN ALLEN SOCKET TO FILL HOLE AFTER FLAT HD HAS BEEN ADJUSTED TO CORRECT HEIGHT AT QUALIFICATION. APPLY #1-23419-5 LOC-TITE TO THREADS.
- 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.

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

LOC	DIST	REVISIONS			
A	66	REV	DATE	BY	APP'D
		A	RELEASED	14MAY2013	GH TE
		B	ECR-19-008712	03JUN2019	TB CT
		C	ECR-19-009117	11JUN2019	MZ 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	2119082-7	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	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	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	985575-3	SCR, FLT SKT HD CAP M3 X 10.0	57	
-	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	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	53	
-	1	1	1	1	1803382-6	HOLD DOWN, SPRING LOADED	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	1-1752356-8	SUPPORT, TERMINAL	34	
-	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33	
-	2	2	2	2	3-2844962-0	SPACER, CYLINDRICAL, STRIP GUIDE	30	
-	1	1	1	1	2844992-2	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	
-	2	2	2	2	1-18028-2	WASHER, FLAT, REG M4	20	
-	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	318707-1	FLOATING SHEAR, FRONT	9	
-	1	2	2	1	1-1633919-0	ANVIL, COMBINATION	8	
-	-	-	-	-	-	-	7	
-	-	-	-	-	-	-	6	
-	1	1	1	1	2119781-5	DEPRESSOR, SHEAR	5	
-	1	1	1	1	2-238011-1	BLOCK, CRIMPER SPACER	4	
-	1	2	2	1	1-1633965-1	CRIMPER, INSULATION O PREMIUM	3	
-	1	1	1	1	455888-1	SPACER, CRIMPER	2	
-	1	2	2	1	3-456404-1	CRIMPER, WIRE PREMIUM	1	
-	77	-72	-71	-2	-1	PART NO	DESCRIPTION	ITEM NO

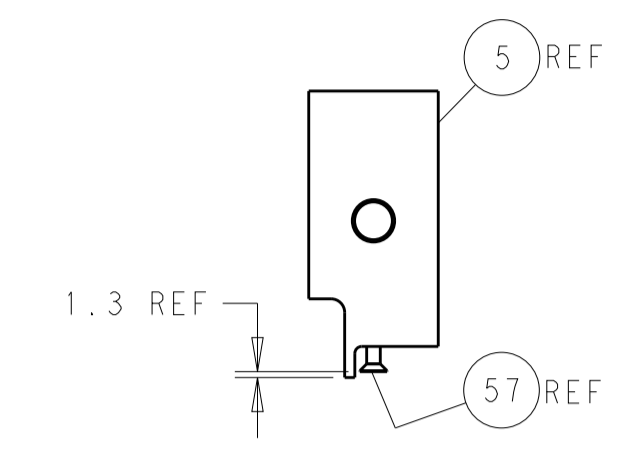
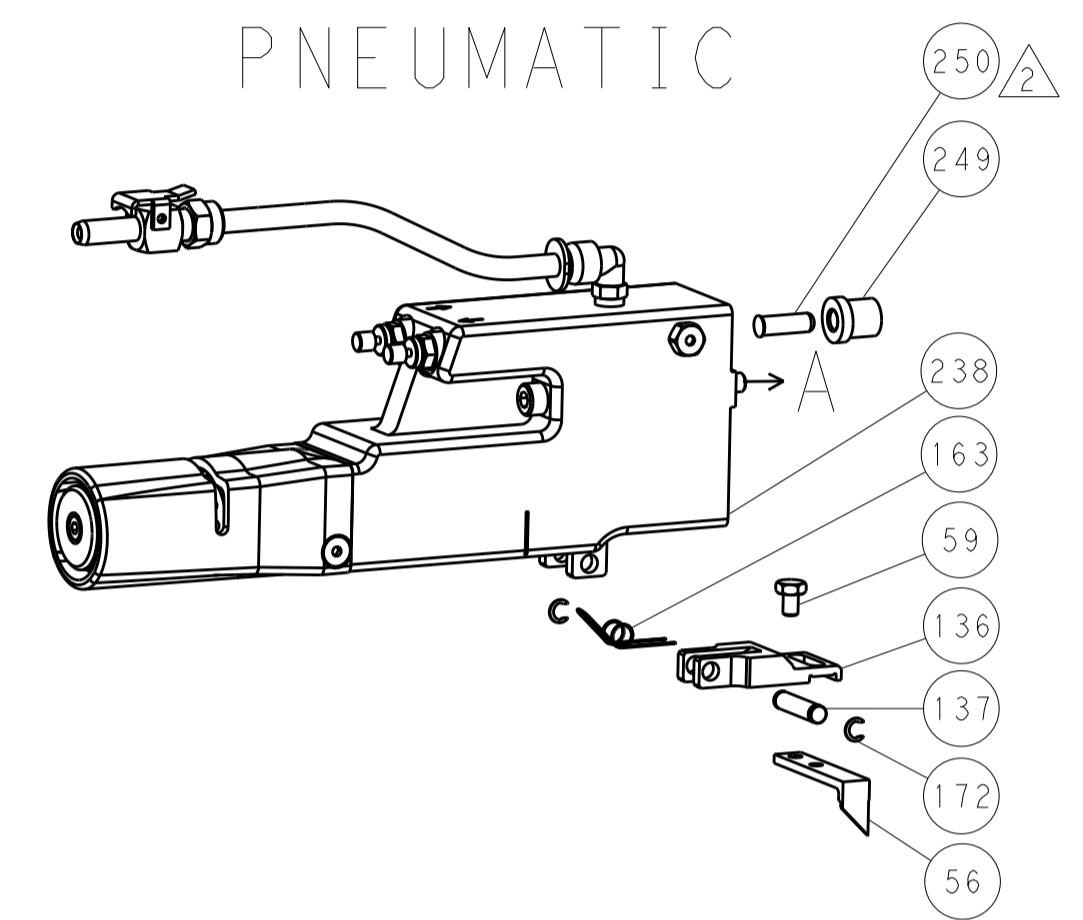
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MATERIAL:		FINISH:		WEIGHT:		SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2151257	
Customer Accessible Production Drawing				SCALE: 1:2		SHEET 1 OF 4 REV C	

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

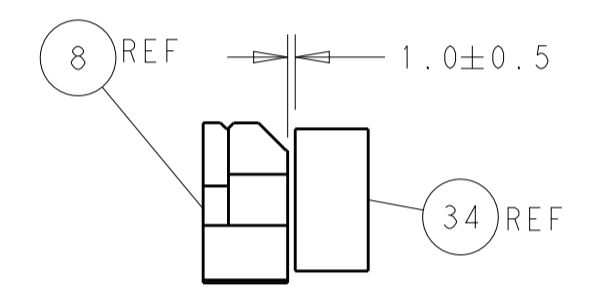
FEED TYPE MECHANICAL



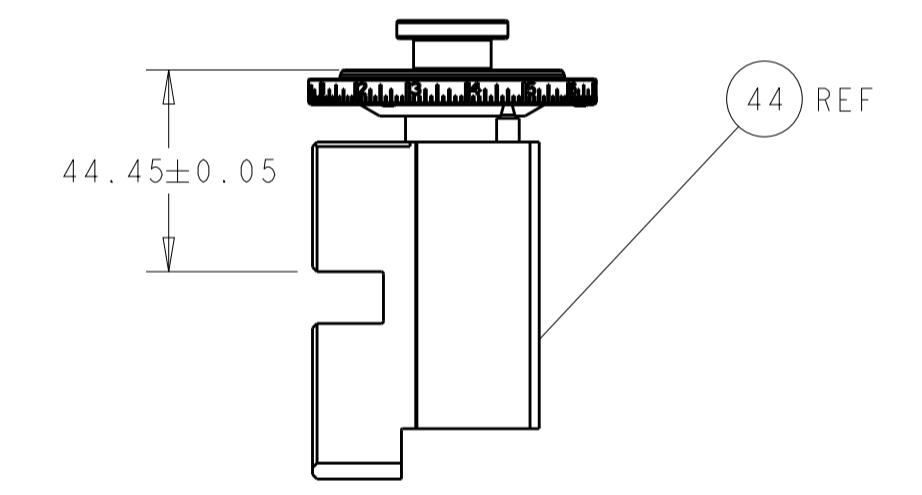
PNEUMATIC



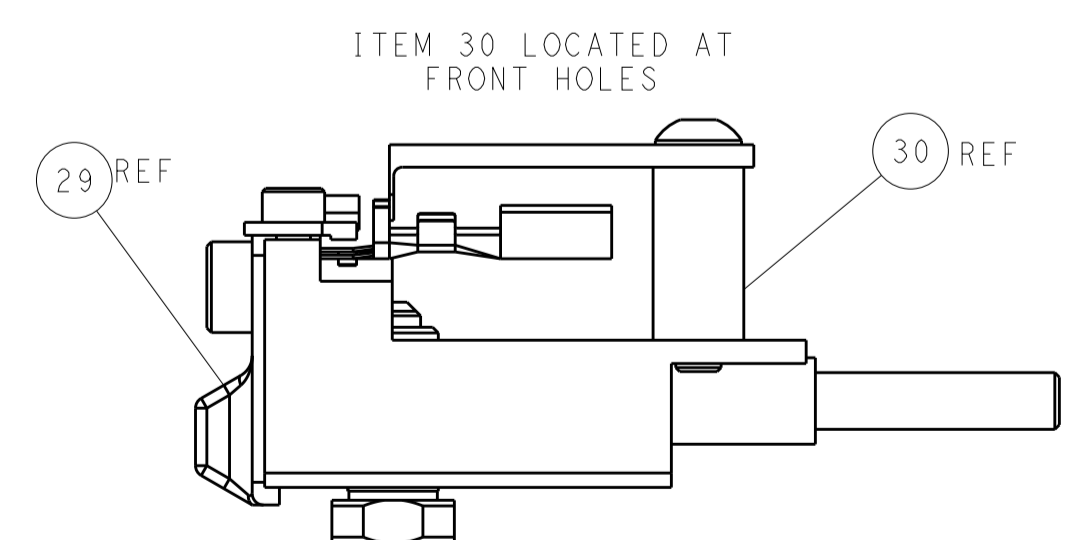
SHEAR DEPRESSOR DETAIL



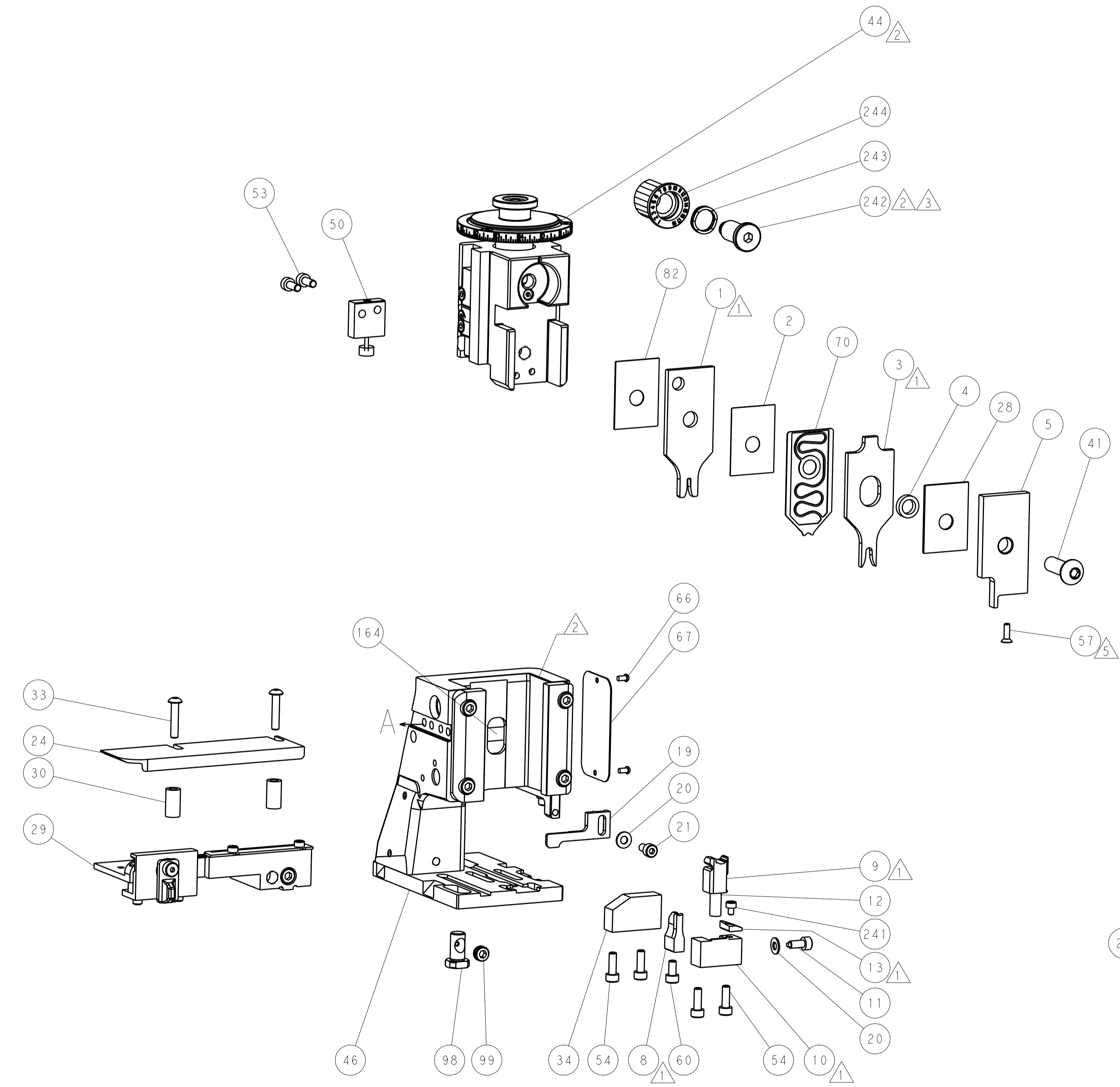
TERMINAL SUPPORT LOCATION



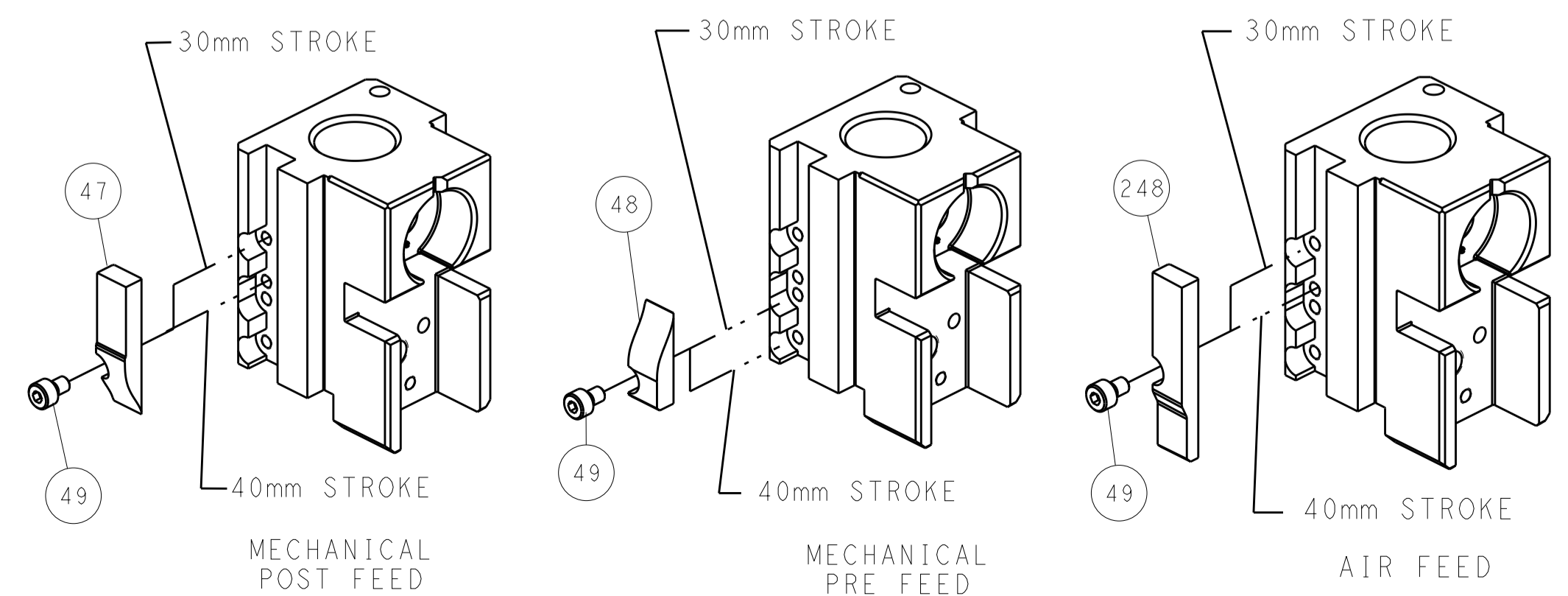
RAM SET-UP



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)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN: HOFFNER 02APR2013		TE Connectivity	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	Harrisburg, PA 17105-3608	
MATERIAL:		FINISH:		APVD: T. ELBIN 02PAR2013		NAME: Ocean Side Feed Applicator	
				PRODUCT SPEC:		SIZE: CAGE CODE: DRAWING NO: A1 00779 ©=2151257	
				APPLICATION SPEC:		RESTRICTED TO:	
				WEIGHT:		SCALE: 1:2 SHEET 2 OF 4 REV C	
				Customer Accessible Production Drawing		SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION	

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2151257-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2151257-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151257-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.78 mm [.070]	F
INSUL	3.84 mm [.151]	O

APPLICATOR INSTRUCTIONS
408-35042

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: JUNIOR POWER TIMER RECEPTACLE			
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE		
4.90-5.50 mm [.193-.217 IN]	∅		
TERMINAL APPLICATION SPECIFICATION	114-15076	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE SEAL	TE SEAL
185026-1	185026-4		828904-1
185026-3			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.00mm ²	1.50+/-0.05 [.059+/-0.002]	4.1
0.75mm ²	1.40+/-0.05 [.055+/-0.002]	5.2
0.60mm ²	1.32+/-0.05 [.052+/-0.002]	6.1
0.50mm ²	1.27+/-0.05 [.050+/-0.002]	6.7
0.35mm ²	1.21+/-0.05 [.048+/-0.002]	7.1

- 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.
- APPLY TORQ-SEAL IN ALLEN SOCKET TO FILL HOLE AFTER FLAT HD HAS BEEN ADJUSTED TO CORRECT HEIGHT AT QUALIFICATION. APPLY #1-23419-5 LOC-TITE TO THREADS.
- 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	REV	DATE	BY	APPD
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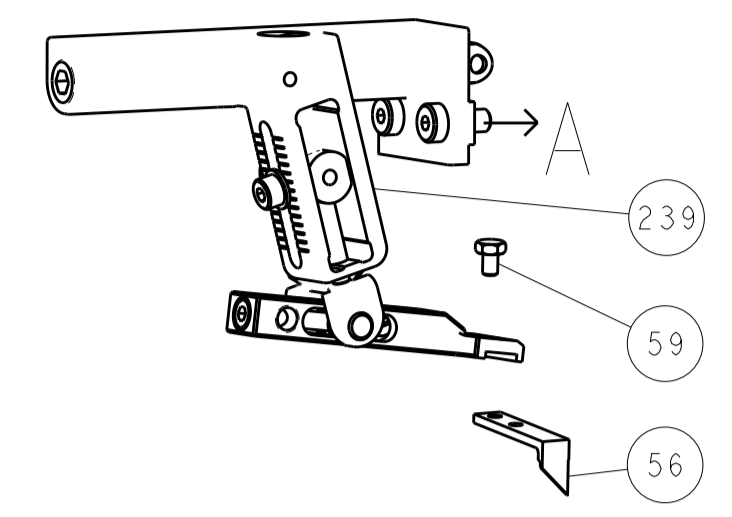
REV	DATE	BY	APPD	DESCRIPTION	ITEM NO	
-	1	-	-	2119640-1	PUSH ROD, AIR FEED	250
-	1	-	-	1803259-1	BUSHING, FLANGED	249
-	1	1	-	2119082-7	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	-	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1	-	2119083-1	RETAINER, INSULATION DIAL	242
-	1	1	-	7-18023-7	SCR, 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	-	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	-	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	-	985575-3	SCR, FLT SKT HD CAP M3 X 10.0	57
-	1	1	-	1338685-1	PAWL, FEED	56
-	2	2	-	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	53
-	1	1	-	1803382-6	HOLD DOWN, SPRING LOADED	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	-	1-1752356-8	SUPPORT, TERMINAL	34
-	2	2	-	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	-	3-2844962-0	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	-	2844992-2	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
-	2	2	-	1-18028-2	WASHER, FLAT, REG M4	20
-	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	-	318707-1	FLOATING SHEAR, FRONT	9
-	1	1	1	1-1633919-0	ANVIL, COMBINATION	8
-	-	-	-	-	-	7
-	-	-	-	-	-	6
-	1	1	-	2119781-5	DEPRESSOR, SHEAR	5
-	1	1	-	2-238011-1	BLOCK, CRIMPER SPACER	4
-	1	1	1	3-1633965-1	CRIMPER, INSULATION O PREMIUM	3
-	1	1	-	455888-1	SPACER, CRIMPER	2
-	1	1	1	3-456404-1	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)

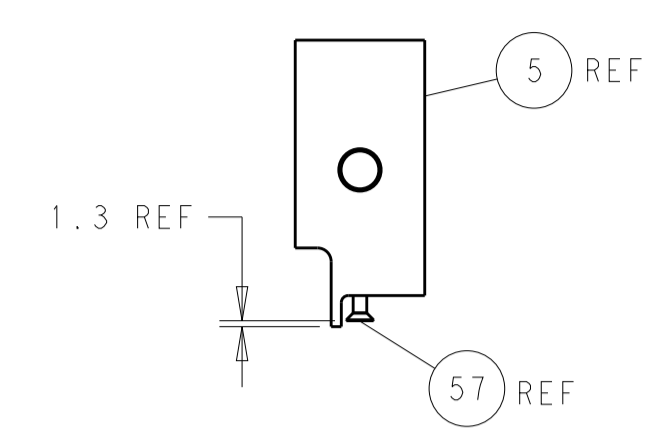
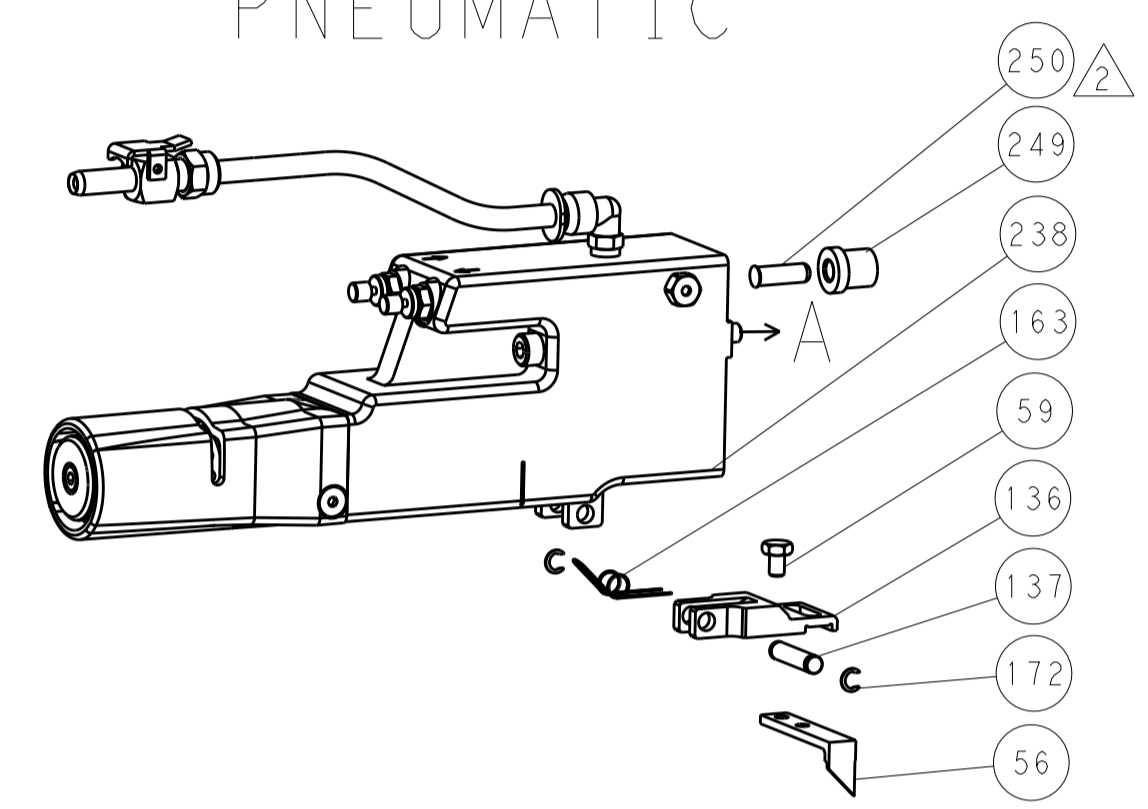
DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH		DWN: HOFFNER 02APR2013 CHK: T. ELBIN 02APR2013 APVD: T. ELBIN 02PAR2013		TE Connectivity Harrisburg, PA 17105-3608	
MATERIAL:		WEIGHT:		SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2151257		RESTRICTED TO:	
Customer Accessible Production Drawing				SCALE: 1:2		SHEET 3 OF 4	

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

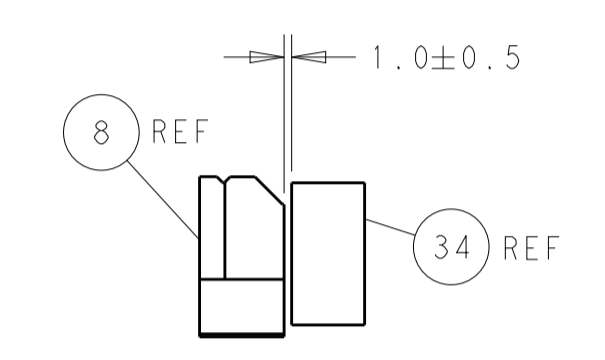
FEED TYPE MECHANICAL



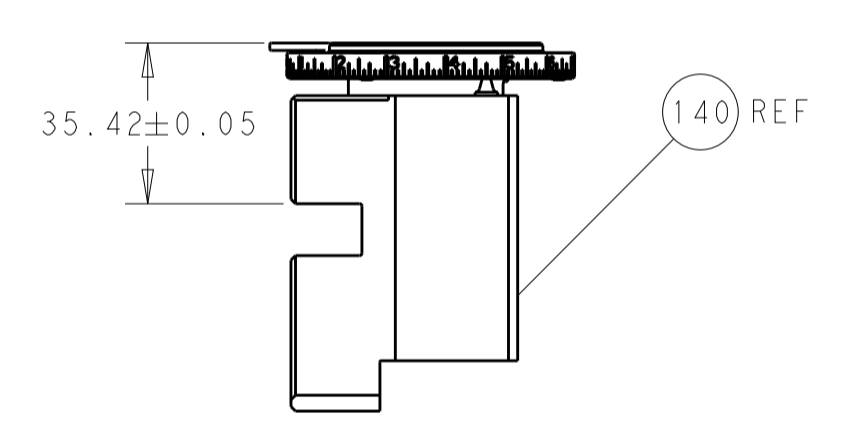
PNEUMATIC



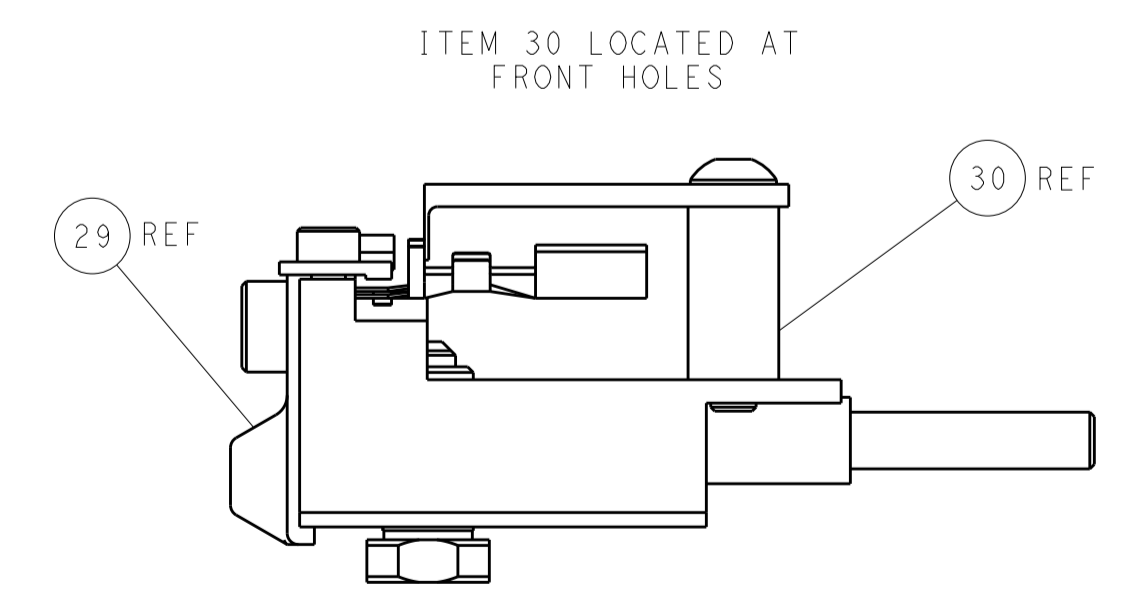
SHEAR DEPRESSOR DETAIL



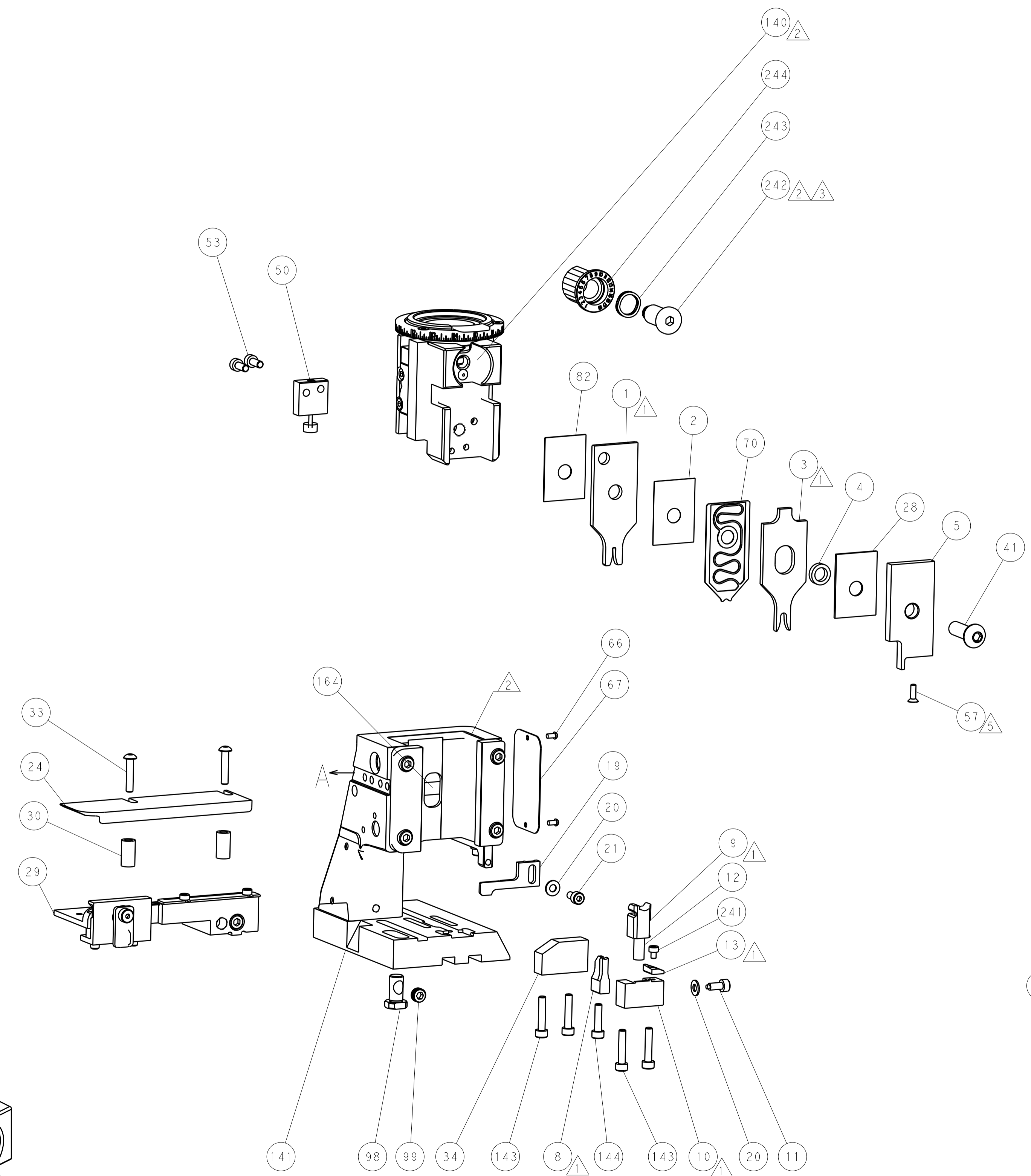
TERMINAL SUPPORT LOCATION



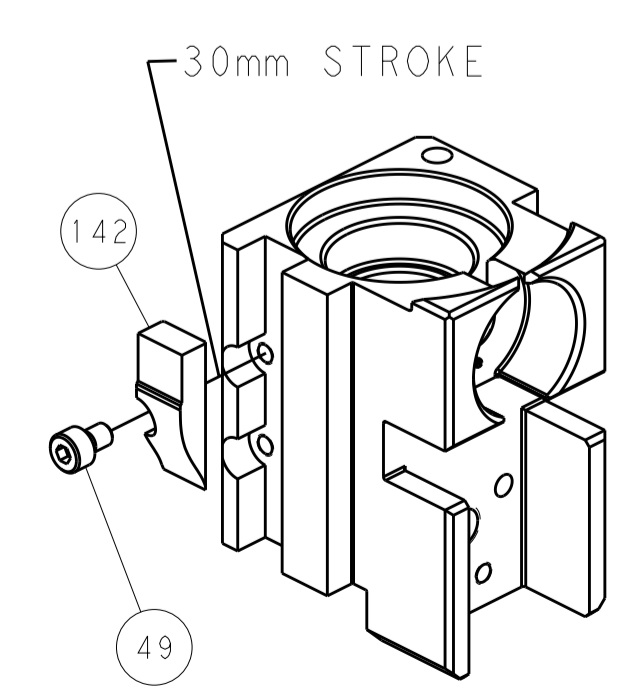
RAM SET-UP



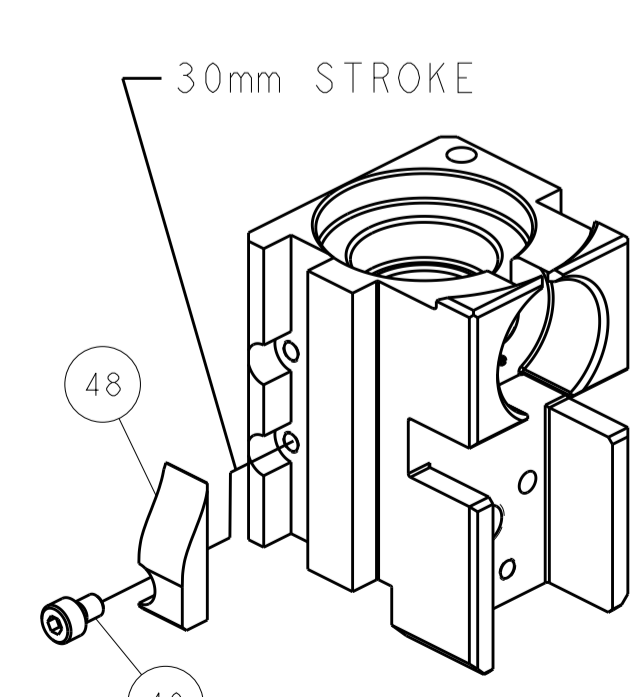
FEED TRACK POSITION GUIDE BY INSULATION BARREL



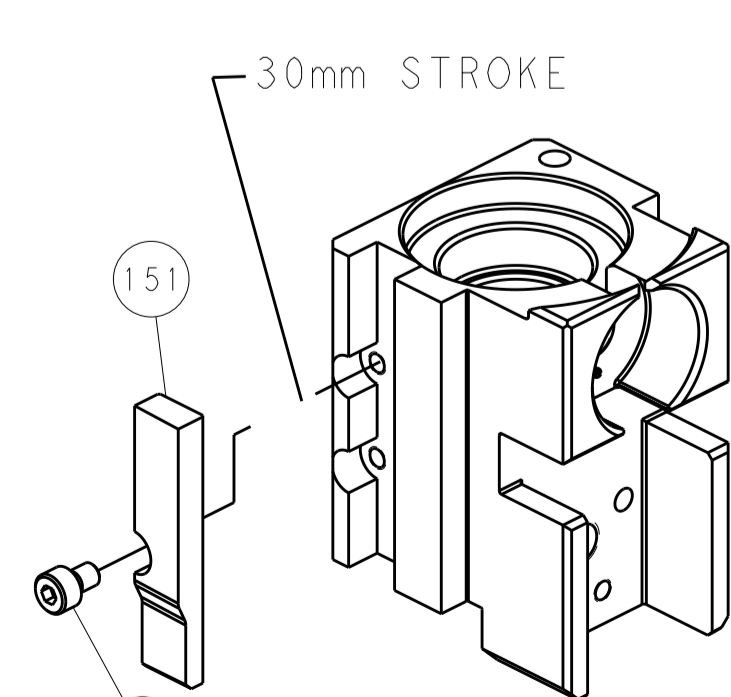
CAM POSITIONS



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)

<small>THE DRAWING IS CONTROLLED THROUGHOUT THE ENTIRE ORGANIZATION. IT IS THE DUTY OF THE USER TO CONTACT THE CONTROLLING ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST REVISION.</small>		DWN: HOFFNER 02APR2013 CHK: T. ELBIN 02APR2013 APVD: T. ELBIN 02PAR2013	TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm 	TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±	PRODUCT SPEC APPLICATION SPEC	NAME: Ocean Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2151257
MATERIAL:	FINISH:	WEIGHT:	RESTRICTED TO:
Customer Accessible Production Drawing		SCALE: 1:2	SHEET 4 OF 4 REV C