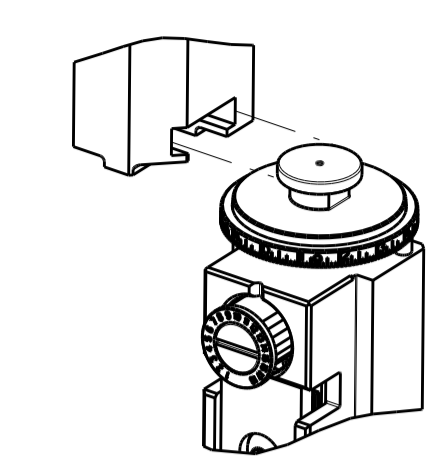


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151742-1	F	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2151742-2	F	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151742-1	F	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2151742-2	F	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2151742-7	D	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.29 mm [.090]	F
INSUL	4.06 mm [.160]	F

APPLICATOR INSTRUCTIONS
408-35042

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: RECEPTACLE CONTACT NEXT GENERATION SOFET SHELL			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
4.20-4.80 mm [.165-.189 IN]		Ø3.40-3.70 mm [.134-.146 IN]	
TERMINAL APPLICATION SPECIFICATION	114-106118		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
1971781-1	1971781-2	1971782-1	1971782-2

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
14 AWG OR 2.10mm2	1.63 +/- 0.05 [.064 +/- .002]	9.0

- 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 1971781 REVISION 11. TERMINAL 1971782 REVISION 10.
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	CHK
		C	ECR-16-002768	26FEB2016	XZ TE
		D	ECR-16-015666	04NOV2016	TB TE
		E	ECR-18-007138	14MAY2018	MEH JDG
		F	ECR-18-007741	18MAY2018	AW CT

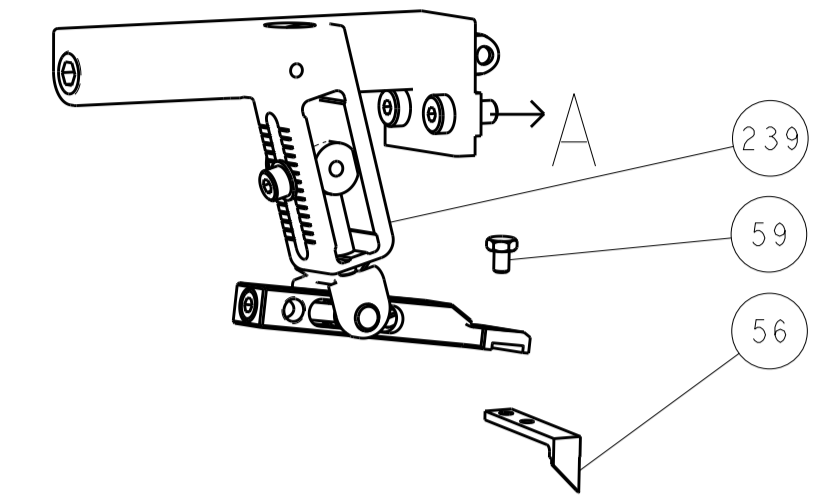
-	1	-	1	-	2119640-1	PUSH ROD, AIR FEED	250
-	1	-	1	-	1803259-1	BUSHING, FLANGED	249
-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248
-	1	1	1	1	2119082-8	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	1	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	455888-8	SPACER, CRIMPER	82
-	1	1	1	1	22278-8	SPRING, COMPRESSION	77
-	1	1	1	1	854769-4	HOLDER, INS	74
-	1	1	1	1	1803607-1	DOCUMENTATION PACKAGE	71
-	1	1	1	1	2119791-6	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	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	53
-	1	1	1	1	5018030-1	NUT, HEX, REG, RoHS, M3	52
-	1	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	-	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	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	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	1803095-1	FLOATING SHEAR, FRONT	9
-	1	2	2	1	1-1803079-2	ANVIL, WITH STABILIZER	8
-	1	1	1	1	4-240641-2	SPACER	7
-	-	-	-	-	-	-	6
-	1	1	1	1	1-2119780-1	DEPRESSOR, SHEAR	5
-	1	1	1	1	238011-2	BLOCK, CRIMPER SPACER	4
-	1	2	2	1	1-1803187-3	CRIMPER, INSULATION F	3
-	1	1	1	1	455888-6	SPACER, CRIMPER	2
-	1	2	2	1	3-456406-3	CRIMPER, WIRE PREMIUM	1

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

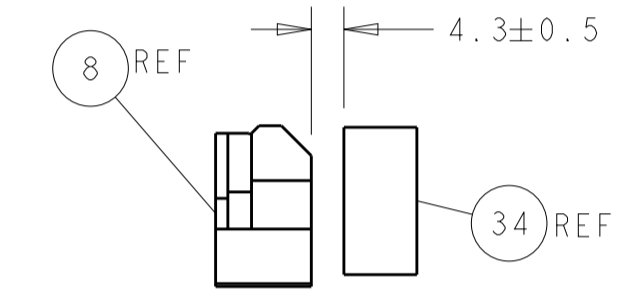
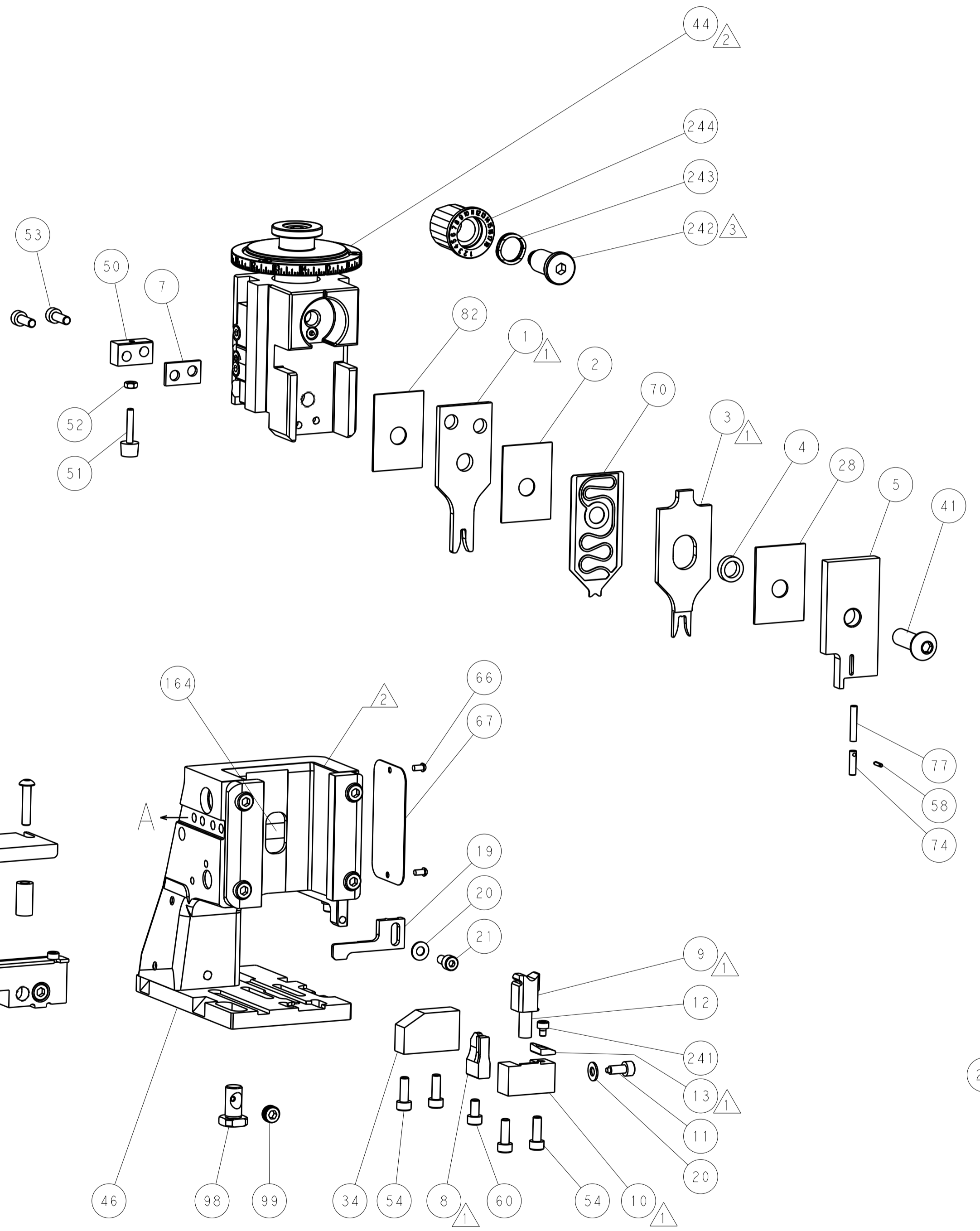
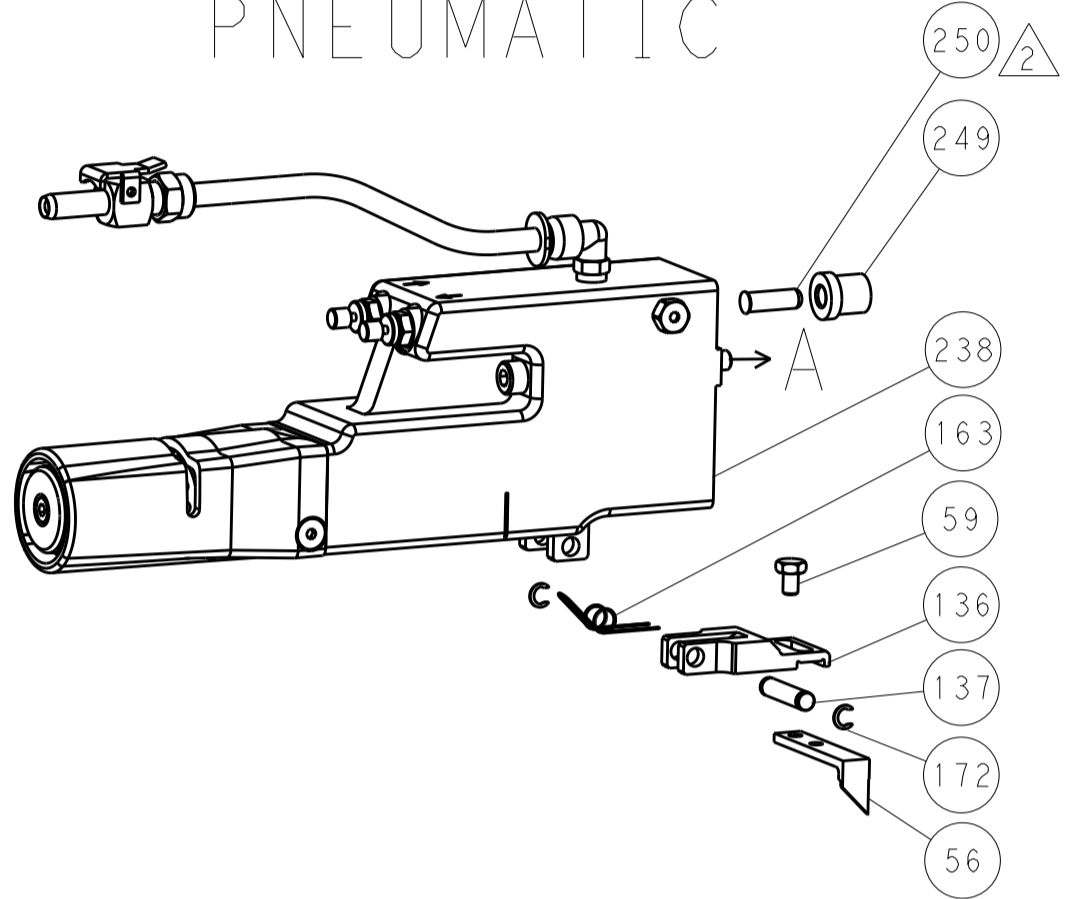
OWN	Y. YIN	03SEP2012	TE Connectivity Harrisburg, PA 17105-3608
CHK	G. BAILEY	03SEP2012	
APP'D	S. XI	03SEP2012	
NAME			Ocean Side Feed Applicator
PRODUCT SPEC			
APPLICATION SPEC			
SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
A1	00779	2151742	
Customer Accessible Production Drawing			SCALE 1:2 SHEET 1 OF 4 REV F

LOC		DIST		REVISIONS			
REV	DATE	BY	CHK	DESCRIPTION	DATE	OWN	APVD
A	66			SEE SHEET 1			

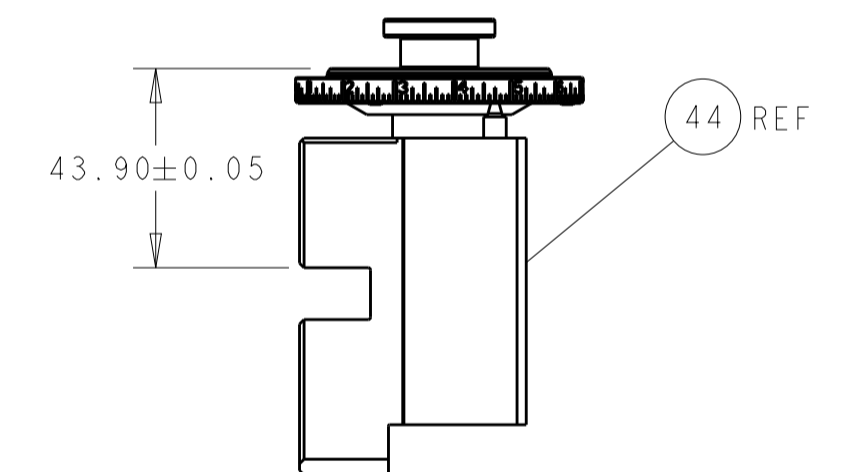
FEED TYPE MECHANICAL



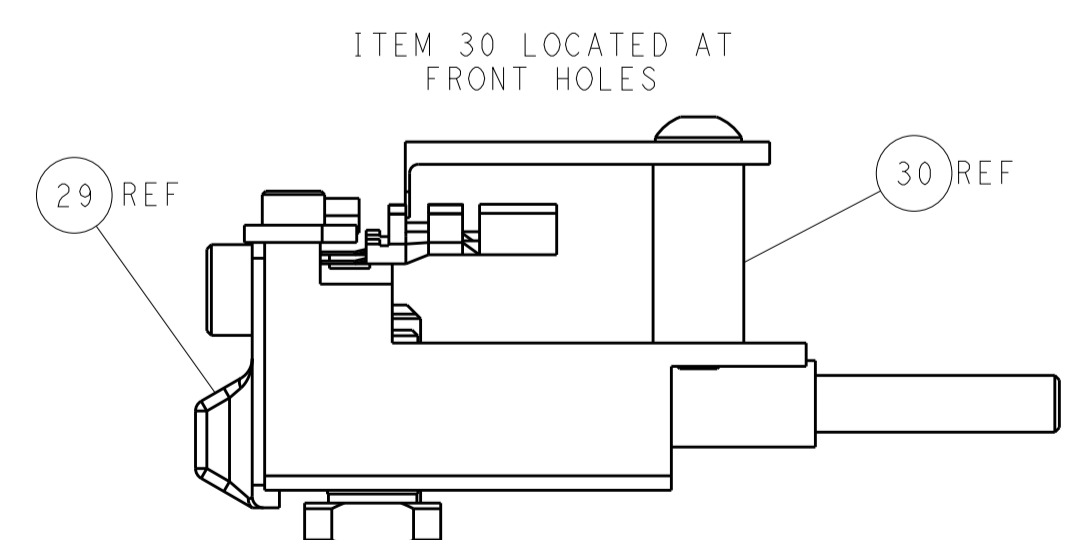
PNEUMATIC



TERMINAL SUPPORT LOCATION

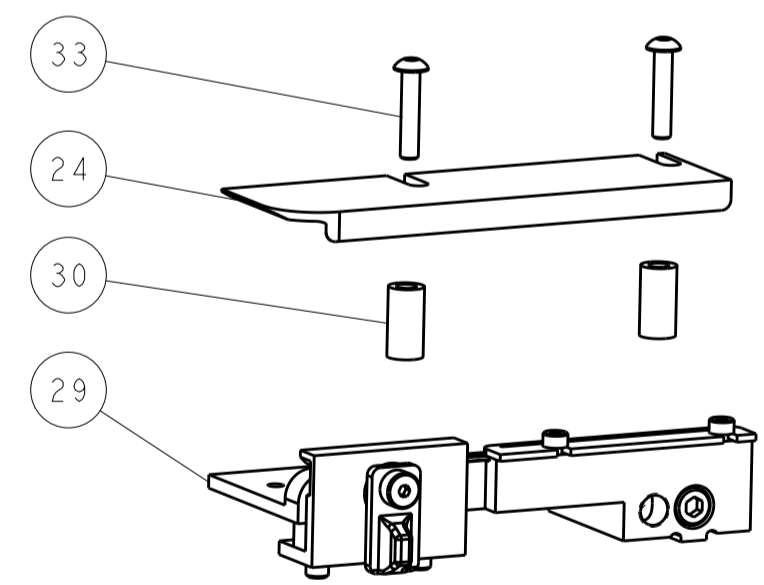
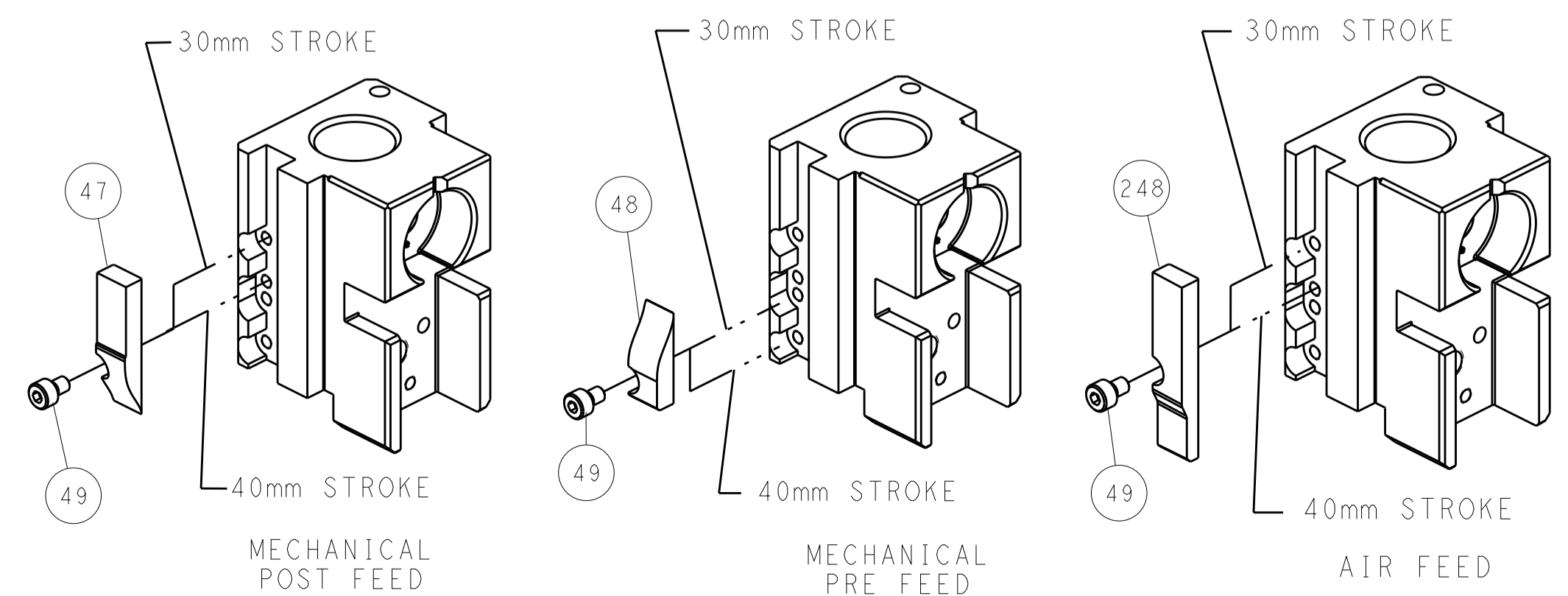


RAM SET-UP



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)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG: Y. YIN 03SEP2012		TE Connectivity	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	Harrisburg, PA 17105-3608	
MATERIAL:		FINISH:		CHK: G. BAILEY 03SEP2012		NAME: Ocean Side Feed Applicator	
				S. XI 03SEP2012		SIZE: CAGE CODE: DRAWING NO: A1 00779 ©=2151742	
				APVD: S. XI 03SEP2012		RESTRICTED TO: -	
				PRODUCT SPEC: -		SCALE: 1:2 SHEET 2 OF 4 REV F	
				APPLICATION SPEC: -		Customer Accessible Production Drawing	
				WEIGHT: -		SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION	

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2151742-1	F	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2151742-2	F	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151742-7	D	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.29 mm [.090]	F
INSUL	4.06 mm [1.60]	F
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: RECEPTACLE CONTACT NEXT GENERATION SOFET SHELL			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
4.20-4.80 mm [1.65-.189 IN]		∅3.40-3.70 mm [1.34-.146 IN]	
TERMINAL APPLICATION SPECIFICATION	114-106118		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
1971781-1	1971781-2	1971782-1	1971782-2

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
14 AWG OR 2.10mm2	1.63+/-0.05 [1.064+/-0.02]	9.0

- 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 TERMINAL 1971781 REVISION 11. TERMINAL 1971782 REVISION 10.
- 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.

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	LTN	DESCRIPTION	DATE	OWN	APVD
A	66	-	-	SEE SHEET 1	-	-	-

-	1	-	2119640-1	PUSH ROD, AIR FEED			250
-	1	-	1803259-1	BUSHING, FLANGED			249
-	1	1	2119082-8	CAM, SNAIL, INSULATION ADJUSTMENT			244
-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST			243
3	-	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	455888-8	SPACER, CRIMPER			82
-	1	1	22278-8	SPRING, COMPRESSION			77
-	1	1	854769-4	HOLDER, INS			74
-	1	1	1803607-1	DOCUMENTATION PACKAGE			71
-	1	1	2119791-6	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	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	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	1	2119806-1	INSERT, SHEAR			13
-	1	1	3-22280-3	SPRING, COMPRESSION			12
-	1	1	1-356885-4	STOP, SHEAR			11
1	1	1	2119805-1	SHEAR HOLDER, FRONT			10
1	1	1	1803095-1	FLOATING SHEAR, FRONT			9
1	1	1	1-1803079-2	ANVIL, WITH STABILIZER			8
-	1	1	4-240641-2	SPACER			7
-	-	-	-	-			6
-	1	1	1-2119780-1	DEPRESSOR, SHEAR			5
-	1	1	238011-2	BLOCK, CRIMPER SPACER			4
1	1	1	9-1803187-3	CRIMPER, INSULATION F			3
-	1	1	455888-6	SPACER, CRIMPER			2
1	1	1	3-456406-3	CRIMPER, WIRE PREMIUM			1
-77	-22	-21	PART NO	DESCRIPTION			ITEM NO

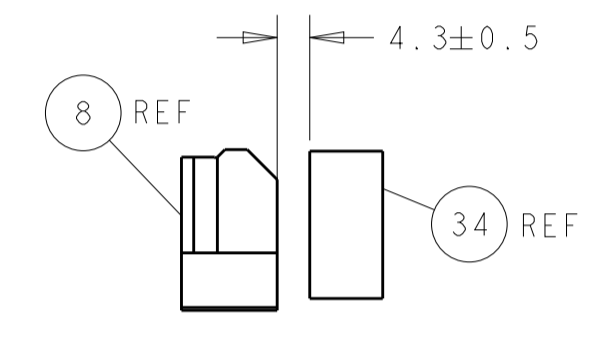
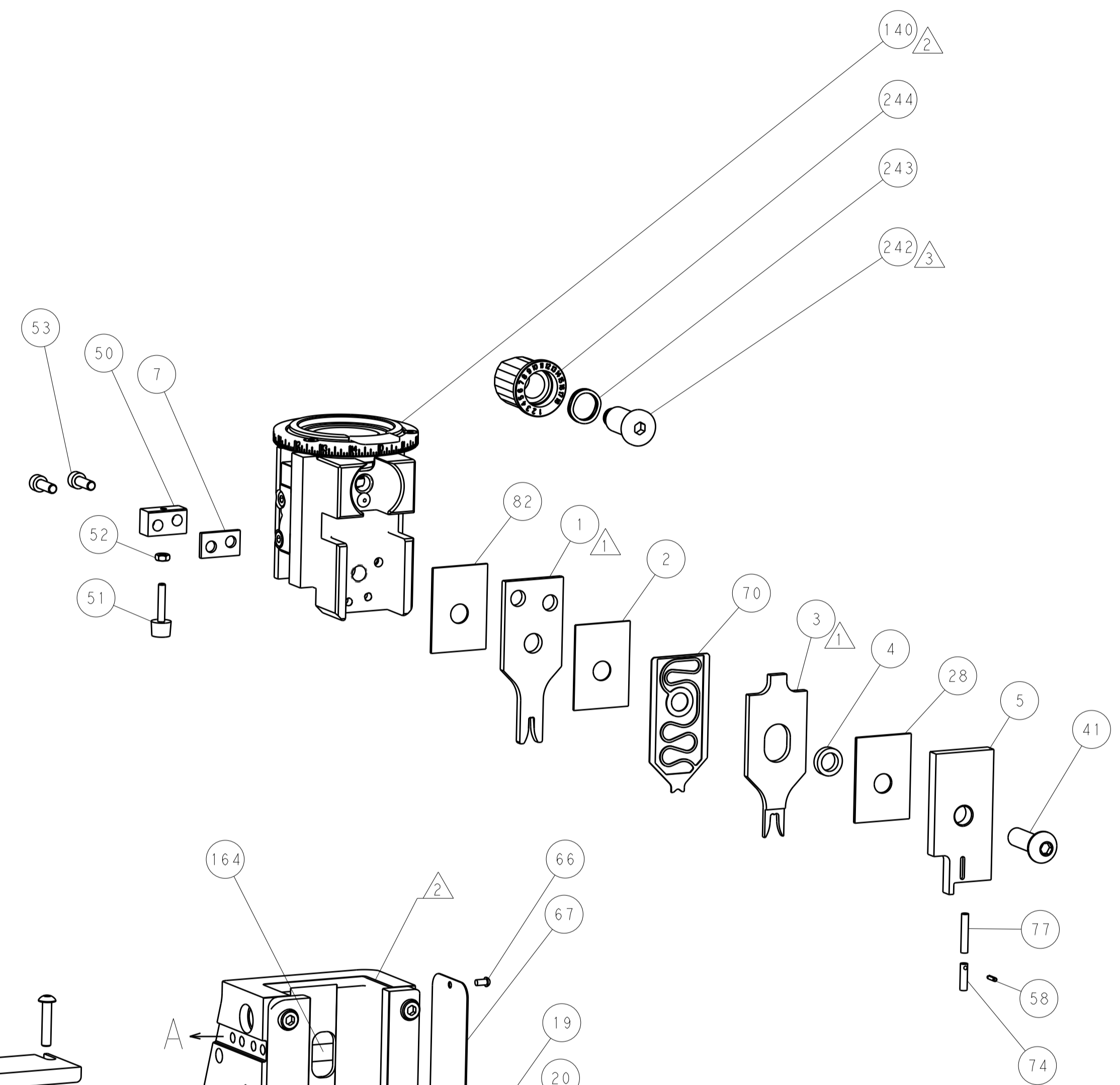
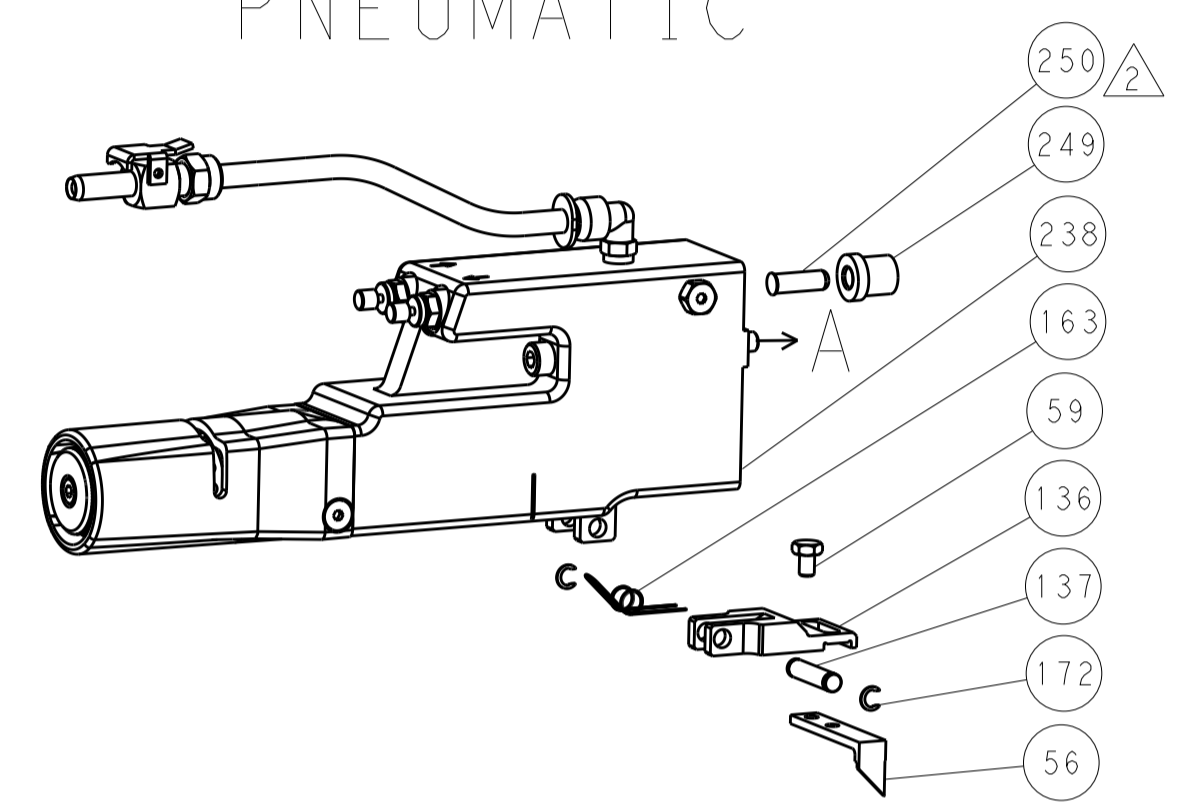
<small>THIS DRAWING IS UNPUBLISHED. IT IS THE PROPERTY OF STC CONNECTIVITY CORPORATION. IT IS TO BE USED ONLY FOR THE PROJECT AND FOR THE CUSTOMER'S USE. IT IS NOT TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, WITHOUT PERMISSION IN WRITING FROM STC CONNECTIVITY CORPORATION.</small>		DWN Y. YIN 03SEP2012	TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm 		CHK G. BAILEY 03SEP2012	
TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		APVD S. XI 03SEP2012	NAME Ocean Side Feed Applicator
MATERIAL FINISH		WEIGHT SCALE 1:2	SIZE A1 00779 C=2151742
CUSTOMER ACCESSIBLE PRODUCTION DRAWING		SHEET 3 OF 4	REV F

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

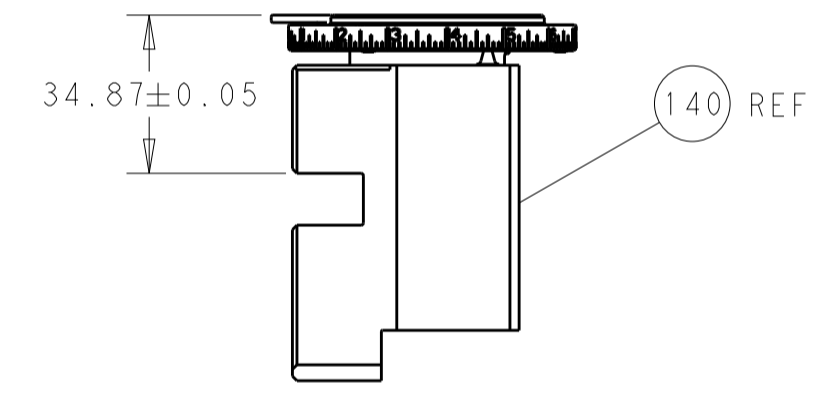
FEED TYPE MECHANICAL



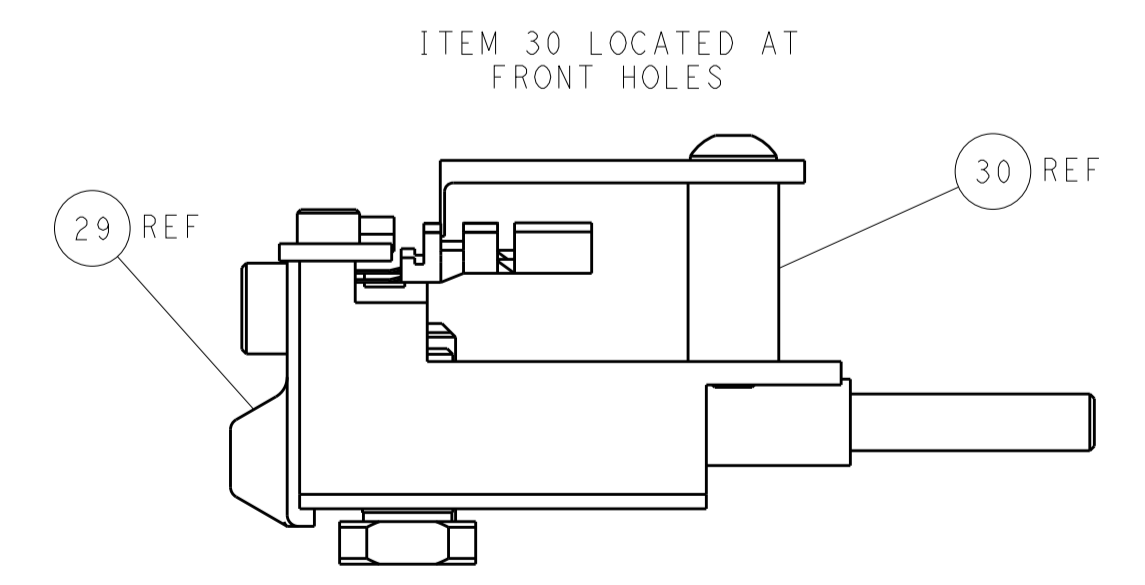
PNEUMATIC



TERMINAL SUPPORT LOCATION

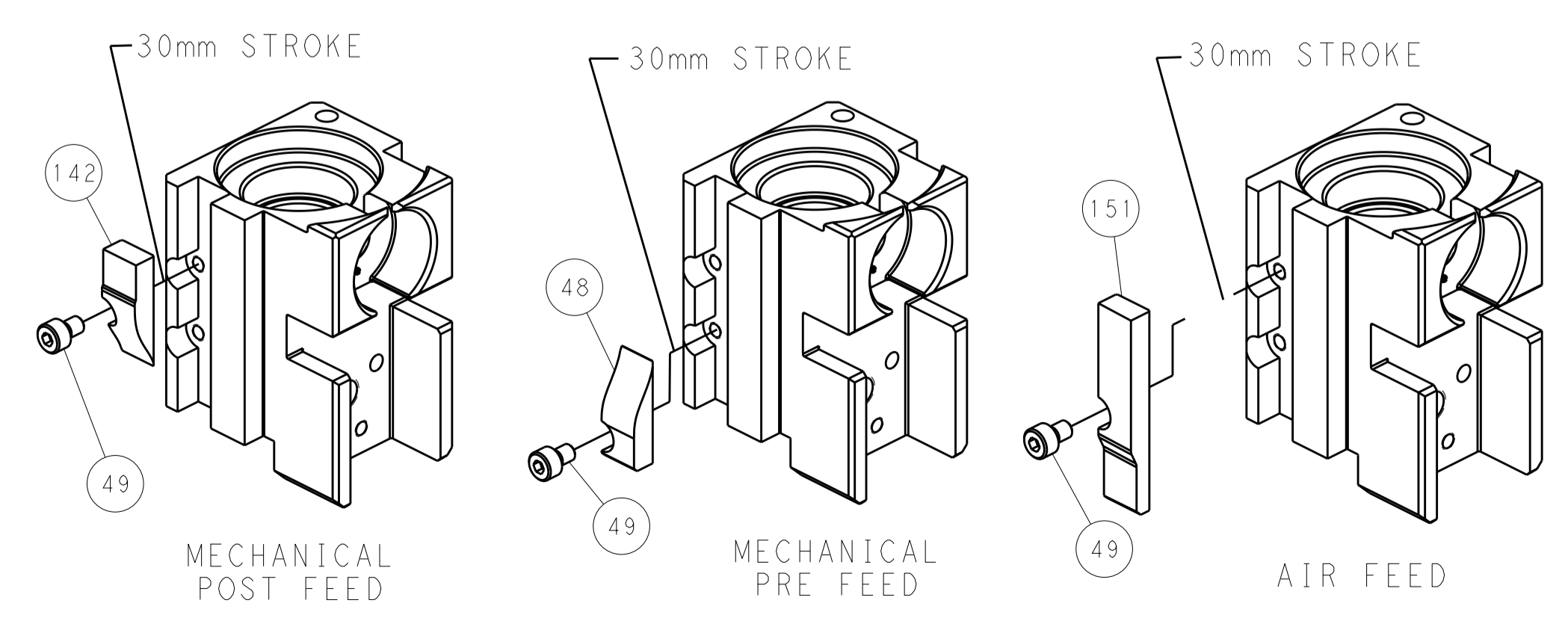


RAM SET-UP



FEED TRACK POSITION GUIDE BY INSULATION BARREL

CAM POSITIONS



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 03SEP2012		STE TE Connectivity Harrisburg, PA 17105-3608	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	NAME Ocean Side Feed Applicator	
MATERIAL		FINISH		APVD S. XI 03SEP2012		RESTRICTED TO	
				PRODUCT SPEC		SIZE CAGE CODE DRAWING NO	
				APPLICATION SPEC		A1 00779 ©=2151742	
				WEIGHT		SCALE 1:2 SHEET 4 OF 4 REV F	
				Customer Accessible Production Drawing		SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION	