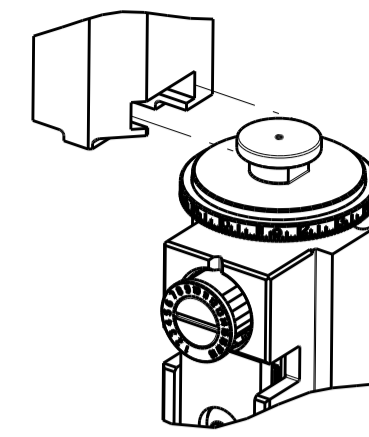


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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151246-1	E	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2151246-2	F	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151246-1	E	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2151246-2	F	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2151246-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA

CRIMP	SIZE	TYPE
WIRE	1.22 mm [.048]	F
INSUL	1.57 mm [.062]	F

APPLICATOR INSTRUCTIONS
408-35042

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION

TERMINAL NAME: LOW PROFILE MINI AMP IN TERMINAL	
WIRE STRIP LENGTH 2.80-3.20 mm [.110-.126 IN]	INSULATION DIAMETER RANGE ∅1.40-1.50 mm [.055-.059 IN]
TERMINAL APPLICATION SPECIFICATION 114-5062-1	-
TERMINALS APPLIED	-
TE TERMINAL	TE TERMINAL
172782-5	172782-7
TE TERMINAL	TE TERMINAL
172782-9	1-172782-2

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
22 AWG OR 0.30mm ²	0.85+/-0.05 [.033+/- .002]	7.9
24 AWG OR 0.20mm ²	0.77+/-0.05 [.030+/- .002]	8.9
26 AWG OR 0.13mm ²	0.72+/-0.05 [.028+/- .002]	9.3



- 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.
- UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- TERMINAL LUBRICANT IS RECOMMENDED.

***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					
				F	LTN	DESCRIPTION	DATE	DWN	APVD
A		66							
				C		ECR-17-015599	23OCT2017	FL	TE
				D		ECR-18-009963	27JUN2018	FL	TE
				E		ECR-18-019319	11DEC2018	TB	CT
				F		ECR-21-000578	18JAN2021	FZ	TE

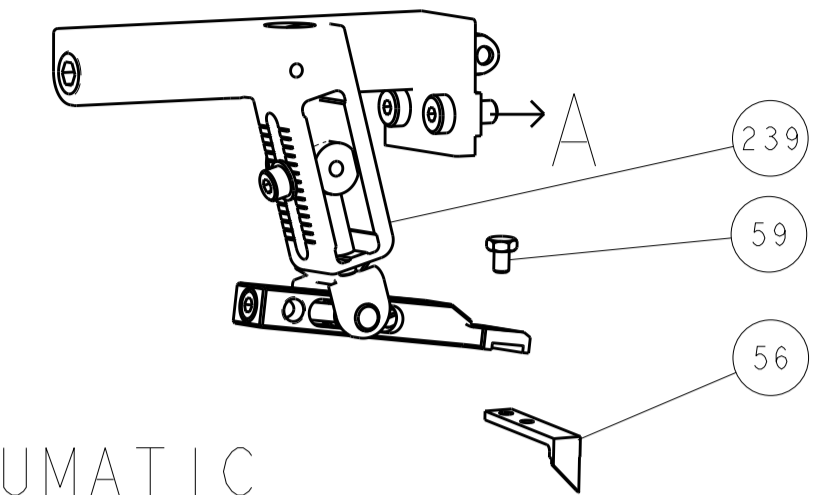
-	1	-	1	-	2119641-1	FEED CAM, AIR FEED			248
-	1	1	1	1	2119082-8	CAM, SNAIL, INSULATION ADJUSTMENT			244
-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST			243
	-	1	1	1	2119083-1	RETAINER, INSULATION DIAL			242
-	1	1	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0			241
-	-	1	-	1	2119580-1	MECHANICAL FEED ASSEMBLY			239
-	1	-	1	-	2844940-1	AIR FEED MODULE			238
-	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC			164
-	1	1	1	1	1-18028-2	WASHER, FLAT, REG M4			119
	-	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	1-690438-0	FRONT STRIP GUIDE			96
-	2	2	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0			95
-	1	1	1	1	455888-6	SPACER, CRIMPER			82
-	1	1	1	1	1803607-3	DOCUMENTATION PACKAGE			71
-	1	1	1	1	2119740-1	TAG IDENTIFICATION			67
-	2	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188			66
-	2	2	2	2	2-18032-5	SCR, SET, FLT PNT, M5 X 20.0			61
-	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	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	7-1752356-1	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	2844992-3	ASSEMBLY, STRIP GUIDE			29
-	1	1	1	1	1-455888-0	SPACER, CRIMPER			28
-	2	2	2	2	22283-1	SPRING, COMPRESSION			27
-	1	1	1	1	356835-1	LEVER, DRAG RELEASE			26
-	1	1	1	1	240792-5	DRAG, TERMINAL			25
-	1	1	1	1	1320928-2	STRIP GUIDE			24
-	1	1	1	1	980371-4	SCR, SKT HD SHLDR 5.0 DIA X 6.0			23
-	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	2119533-3	STRIPPER, SIDE FEED			19
	-	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	2119805-1	SHEAR HOLDER, FRONT			10
	-	1	1	1	1803095-6	FLOATING SHEAR, FRONT			9
	1	2	2	1	1	4-1333225-3	ANVIL, COMBINATION		8
-	-	-	-	-	-	-			7
-	-	-	-	-	-	-			6
-	1	1	1	1	2119757-5	DEPRESSOR, SHEAR			5
-	1	1	1	1	1-238011-3	BLOCK, CRIMPER SPACER			4
	1	2	2	1	1	4-1633961-0	CRIMPER, INSULATION F PREMIUM		3
-	-	-	-	-	-	-			2
	1	2	2	1	1	568176-5	CRIMPER, WIRE		1
-	-	-	-	-	-	-			-
-77	-72	-71	-2	-1	PART NO	DESCRIPTION			ITEM NO

THE DRAWING IS UNPUBLISHED. IT IS THE PROPERTY OF TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE WITHOUT NOTICE AND THE ISSUING ORGANIZATION SHALL BE CONTACTED FOR THE LATEST REVISION.			DWN: X. ZHAO 06SEP2013 CHK: T. ELBIN 06SEP2013 APVD: J. ZHANG 06SEP2013	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 FINISH	NAME Ocean Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2151246 RESTRICTED TO: -	
MATERIAL:			WEIGHT: - SCALE: 1:2 SHEET: 1 OF 4 REV: F	

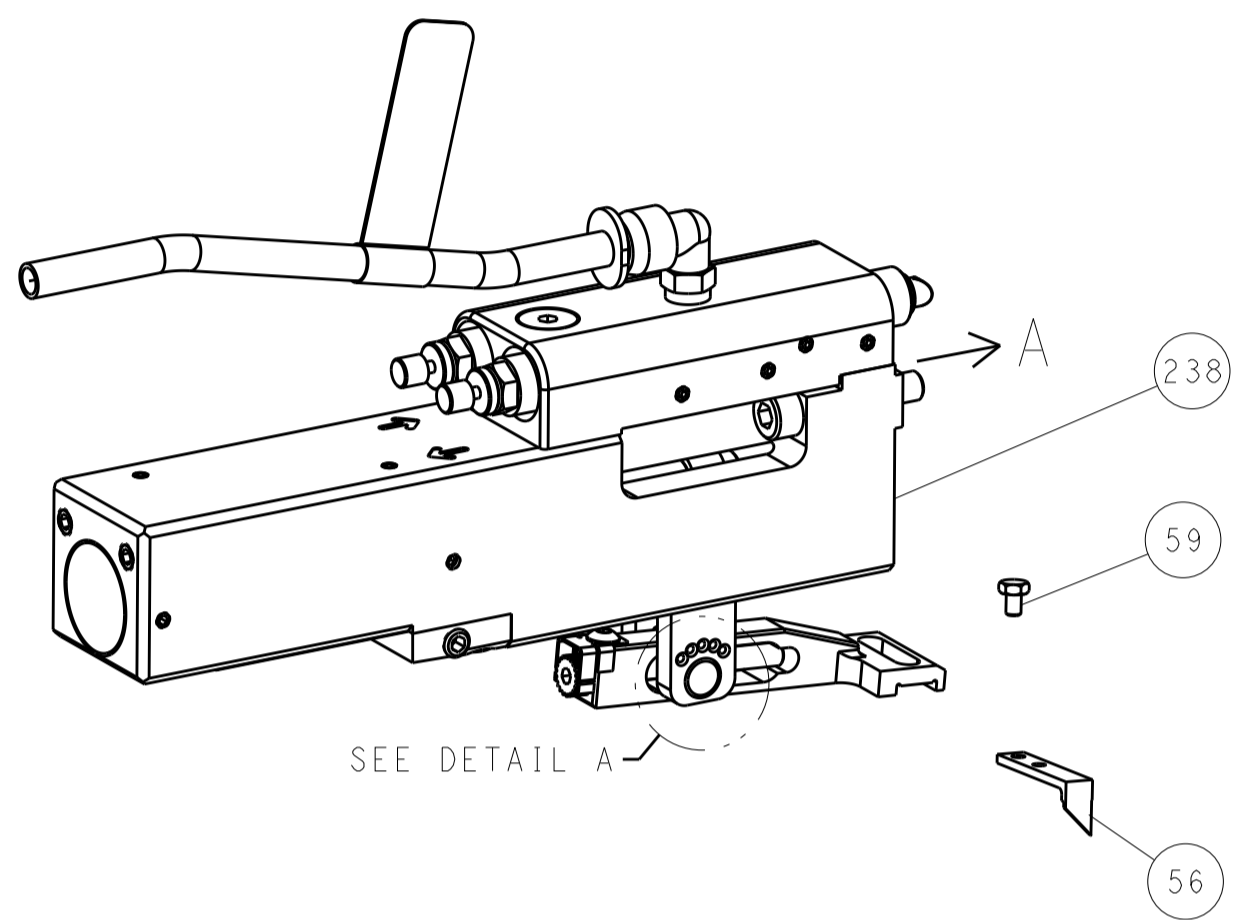
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

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

FEED TYPE MECHANICAL



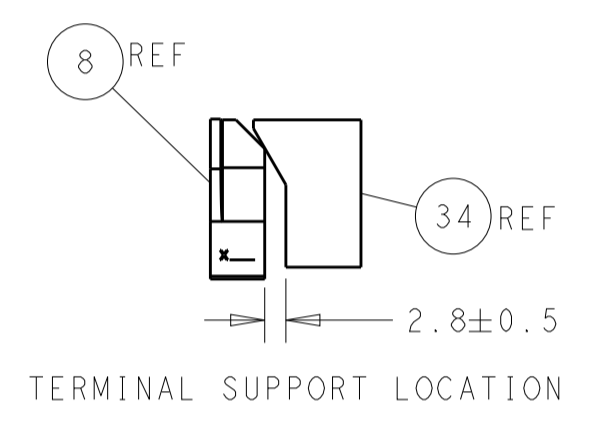
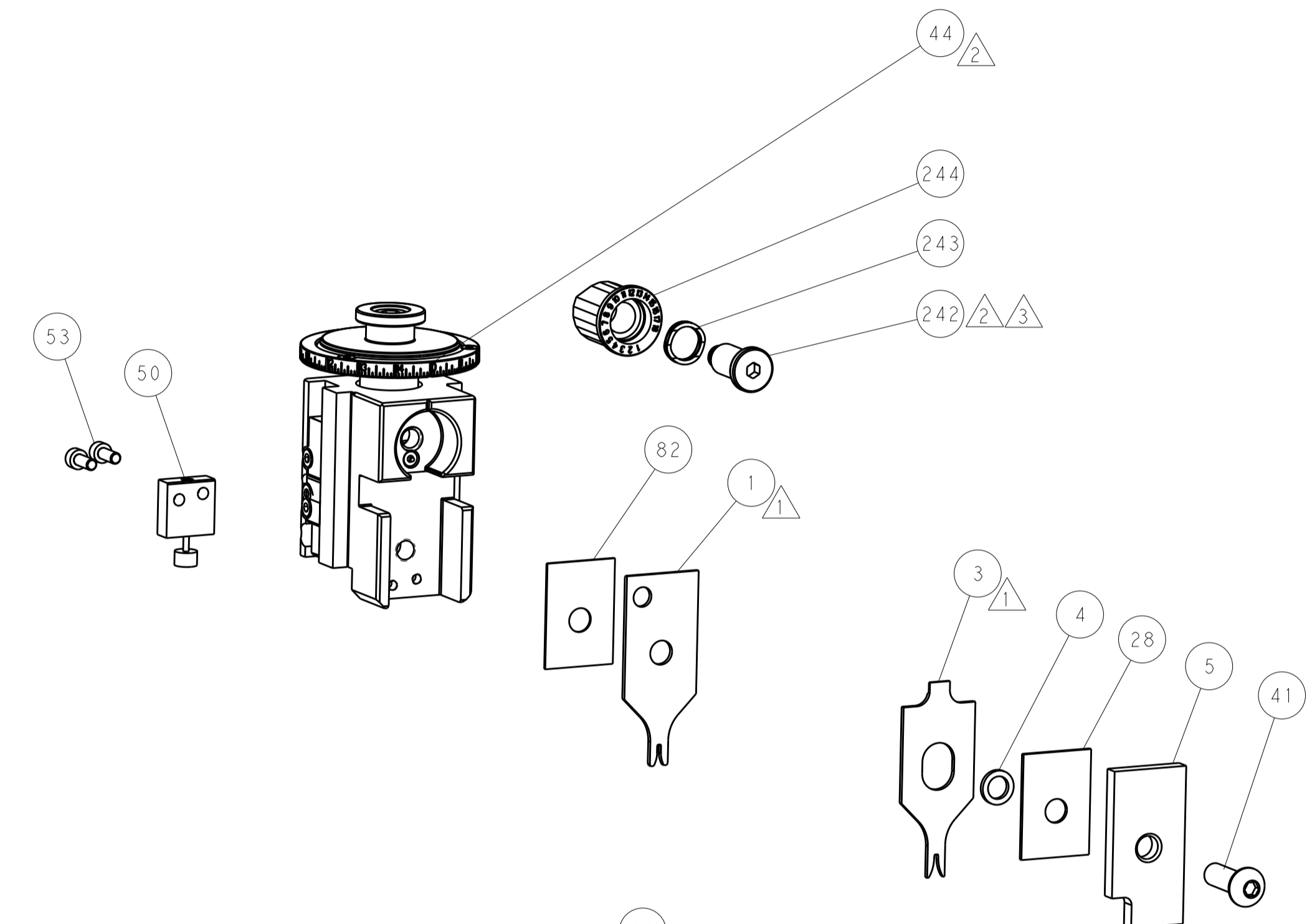
PNEUMATIC



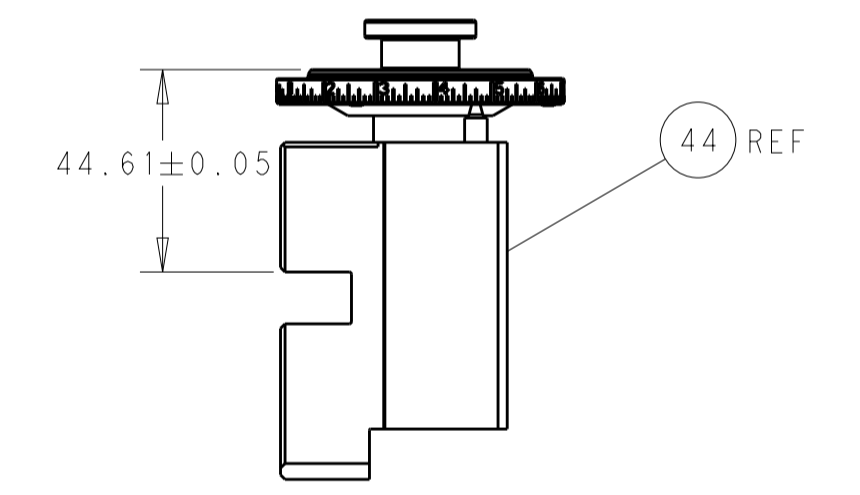
FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



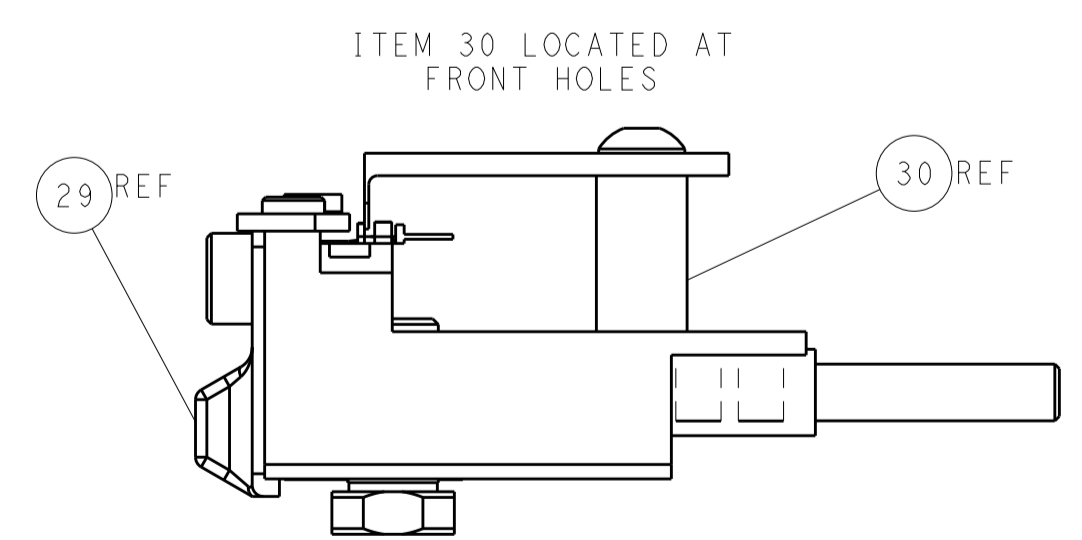
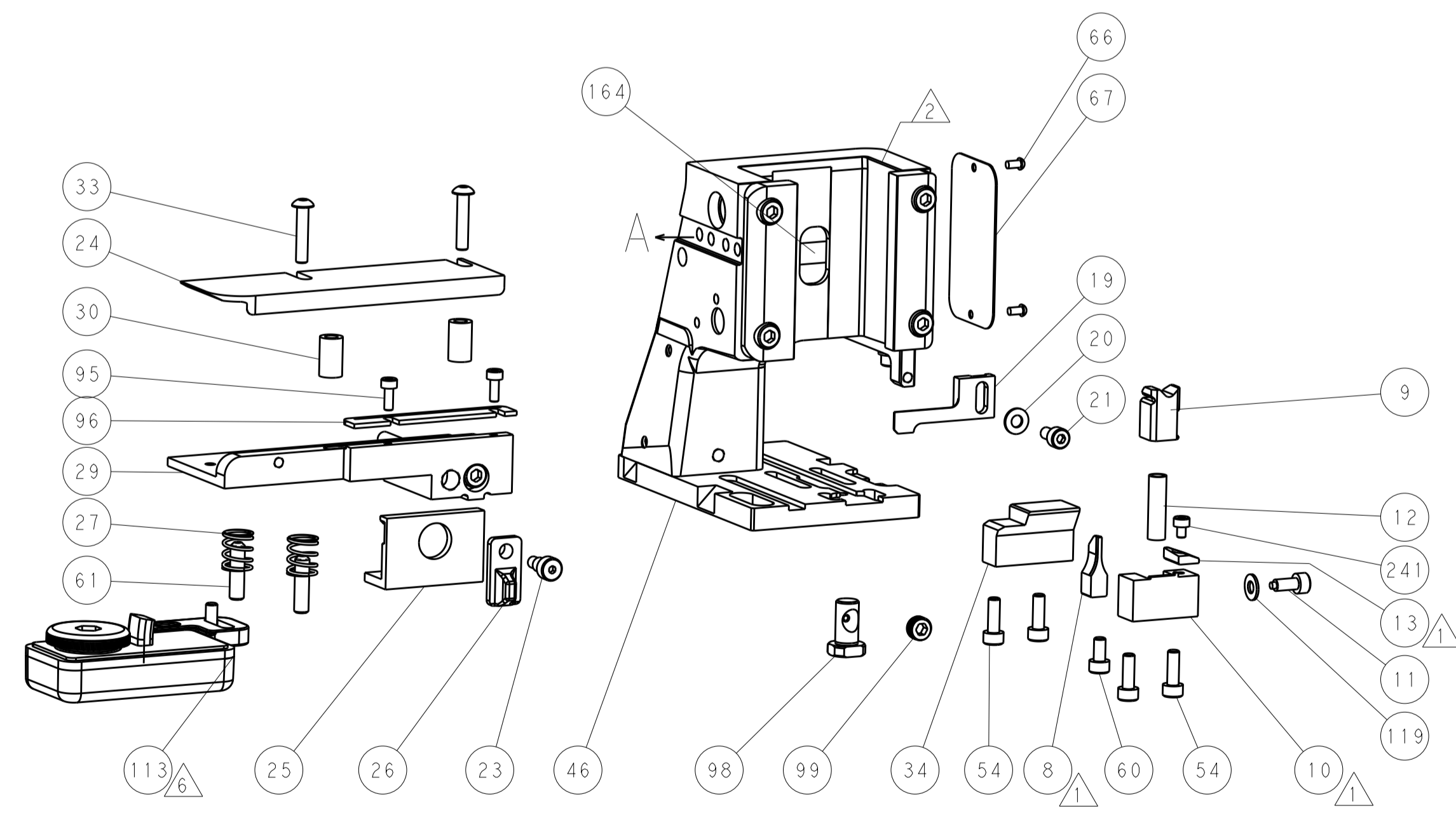
DETAIL A



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 X ZHAO 06SEP2013		TE Connectivity	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	Harrisburg, PA 17105-3608	
MATERIAL:		FINISH:		APVD T. ELBIN 06SEP2013		NAME	
				PRODUCT SPEC		Ocean Side Feed	
				APPLICATION SPEC		Applicator	
				WEIGHT		SIZE CAGE CODE DRAWING NO	
				Customer Accessible Production Drawing		A1 00779 ©=2151246	
				SCALE		RESTRICTED TO	
				1:2		SHEET 2 OF 4 REV F	

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2151246-1	E	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2151246-2	F	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151246-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.22 mm [.048]	F
INSUL	1.57 mm [.062]	F
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: LOW PROFILE MINI AMP IN TERMINAL			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
2.80-3.20 mm [.110-.126 IN]		∅1.40-1.50 mm [.055-.059 IN]	
TERMINAL APPLICATION SPECIFICATION	114-5062-1	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
172782-5	172782-7	172782-9	1-172782-2

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
22 AWG OR 0.30mm ²	0.85 +/- 0.05 [.033 +/- .002]	7.9
24 AWG OR 0.20mm ²	0.77 +/- 0.05 [.030 +/- .002]	8.9
26 AWG OR 0.13mm ²	0.72 +/- 0.05 [.028 +/- .002]	9.3



- 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.
- TERMINAL LUBRICANT IS RECOMMENDED.

***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)

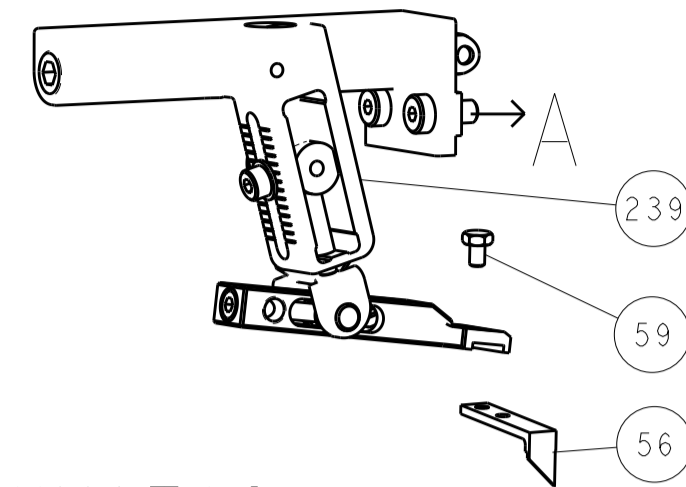
LOC	DIST	REVISIONS			
A	66	REV	DATE	BY	APPV
-	-	SEE SHEET 1	-	-	-

-	1	1	2119082-8	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
-	1	1	1-18028-2	WASHER, FLAT, REG M4	119
-	1	1	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113
-	1	1	2844908-1	SCREW, LOCKING	99
-	1	1	2844907-1	POST, LOCKING	98
-	1	1	1-690438-0	FRONT STRIP GUIDE	96
-	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	95
-	1	1	455888-6	SPACER, CRIMPER	82
-	1	1	1803607-3	DOCUMENTATION PACKAGE	71
-	1	1	2119740-1	TAG, IDENTIFICATION	67
-	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	2	2	2-18032-5	SCR, SET, FLT PNT, M5 X 20.0	61
-	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	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	7-1752356-1	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	2844992-3	ASSEMBLY, STRIP GUIDE	29
-	1	1	1-455888-0	SPACER, CRIMPER	28
-	2	2	22283-1	SPRING, COMPRESSION	27
-	1	1	356835-1	LEVER, DRAG RELEASE	26
-	1	1	240792-5	DRAG, TERMINAL	25
-	1	1	1320928-2	STRIP GUIDE	24
-	1	1	980371-4	SCR, SKT HD SHLDR 5.0 DIA X 6.0	23
-	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	2119533-3	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	1803095-6	FLOATING SHEAR, FRONT	9
-	1	1	4-1333225-3	ANVIL, COMBINATION	8
-	-	-	-	-	7
-	-	-	-	-	6
-	1	1	2119757-5	DEPRESSOR, SHEAR	5
-	1	1	1-238011-3	BLOCK, CRIMPER SPACER	4
-	1	1	4-1633961-0	CRIMPER, INSULATION F PREMIUM	3
-	-	-	-	-	2
-	1	1	568176-5	CRIMPER, WIRE	1

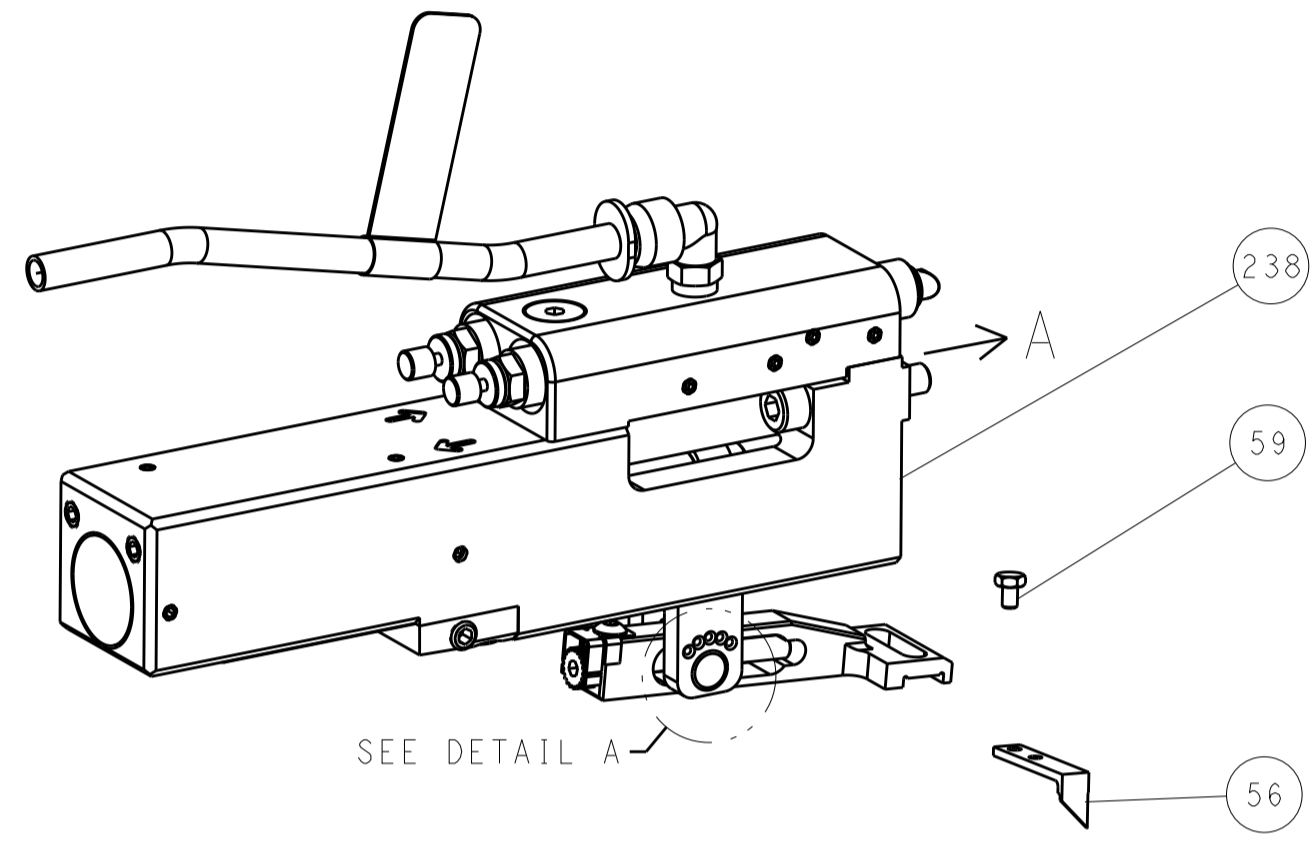
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mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES ±	FINISH ±
DWG: X.ZHAO 06SEP2013 CHK: T.ELBIN 06SEP2013 APVD: L.ZHANG 06SEP2013		NAME: Ocean Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2151246		RESTRICTED TO: F SCALE: 1:2 SHEET: 3 OF 4		CUSTOMER ACCESSIBLE PRODUCTION DRAWING	

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

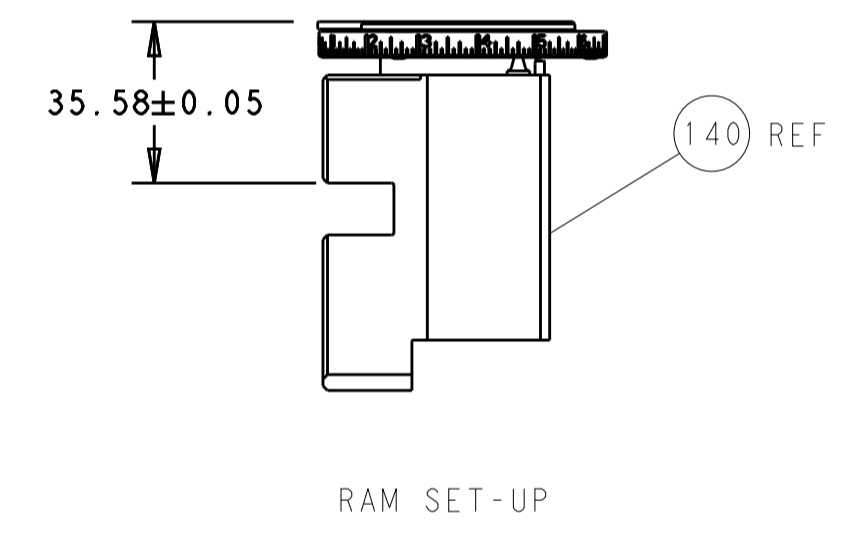
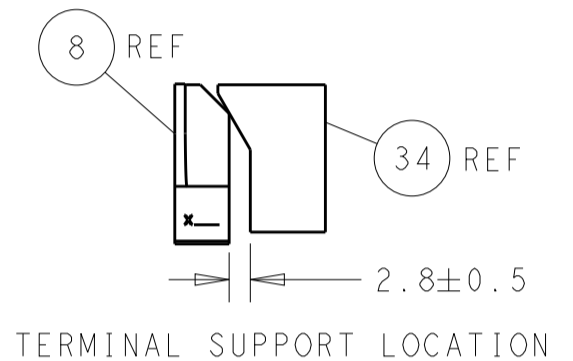
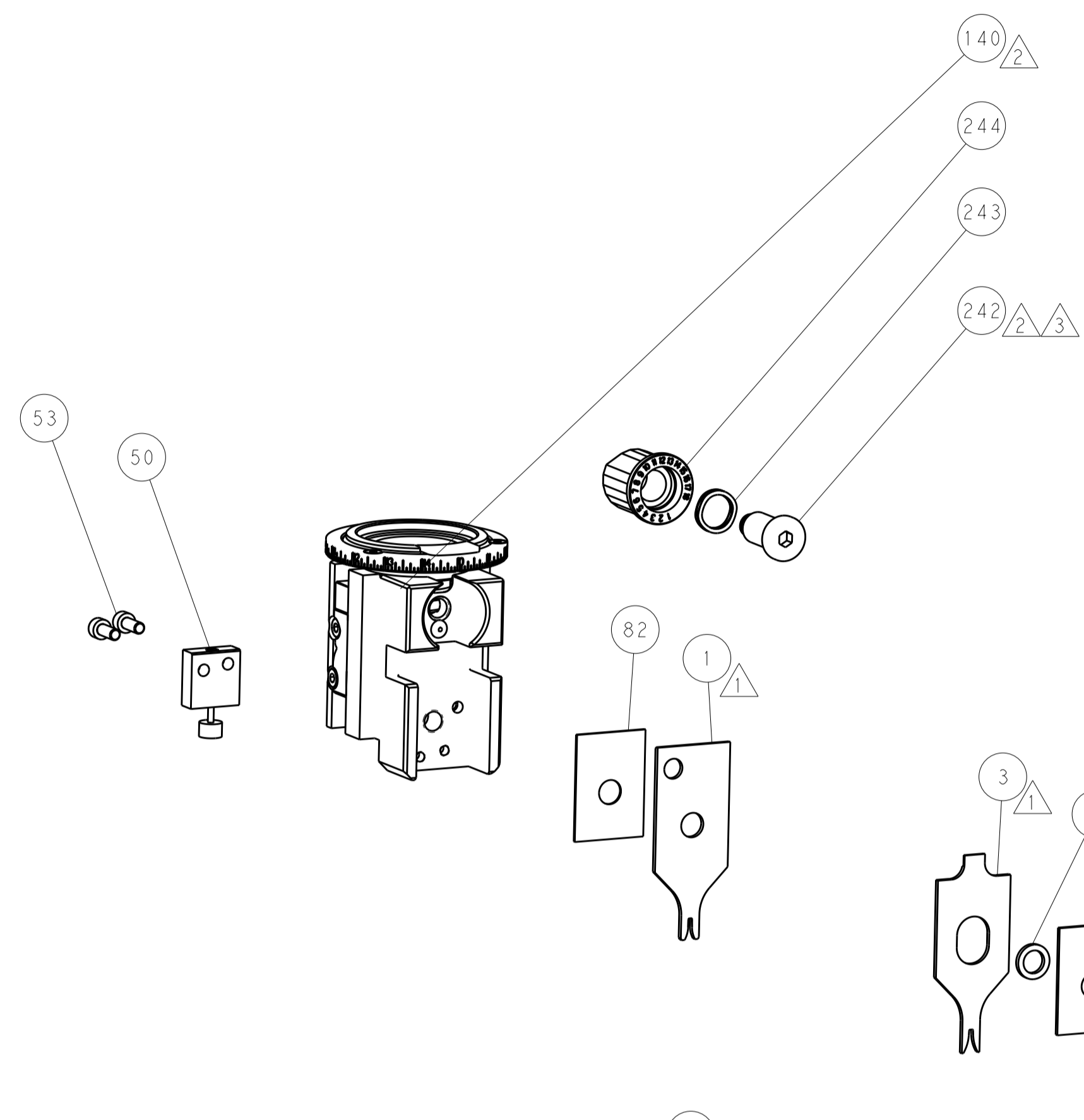
FEED TYPE MECHANICAL



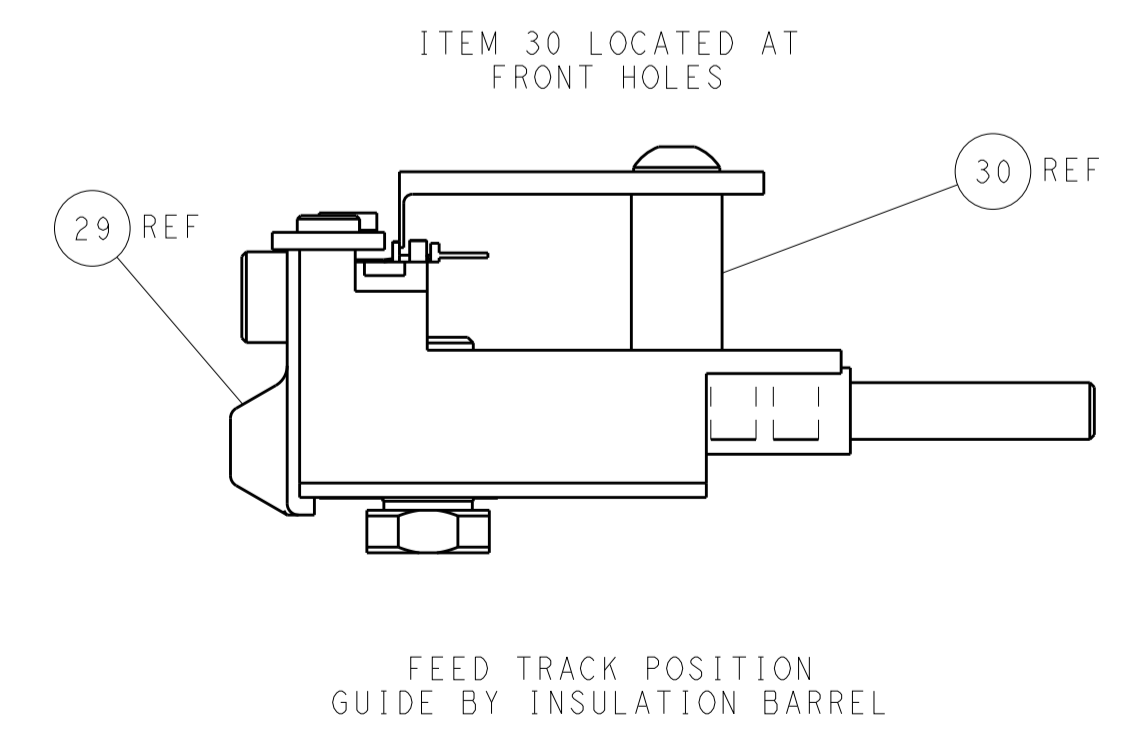
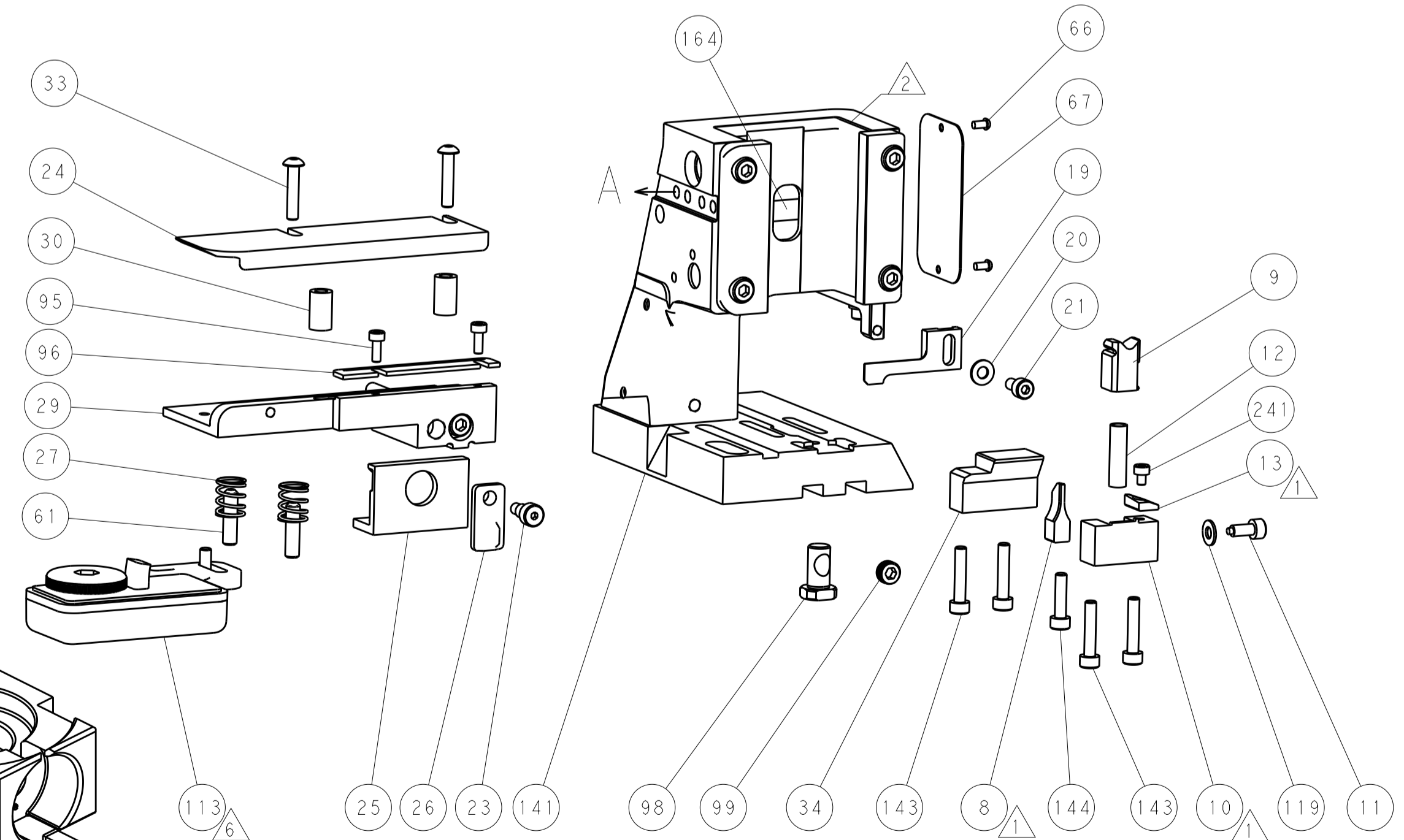
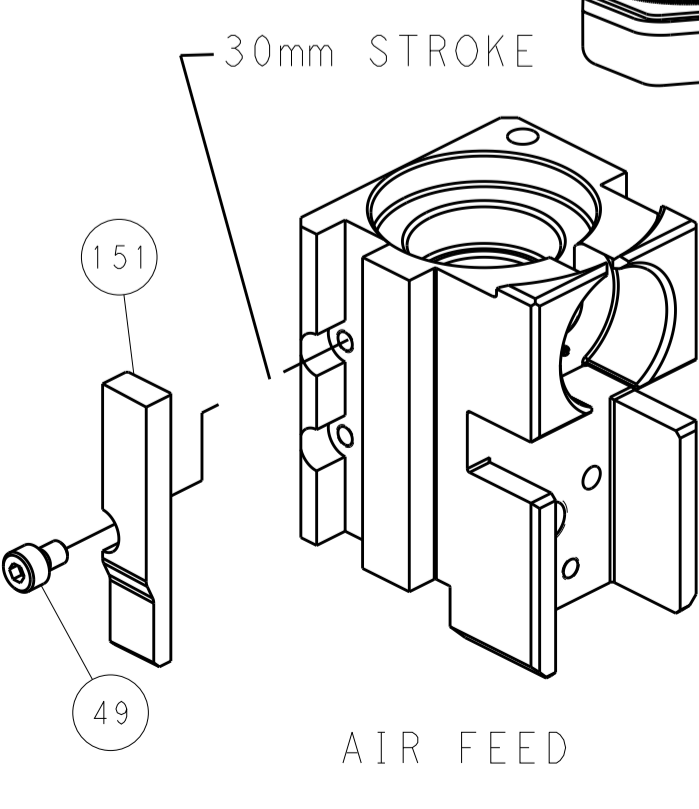
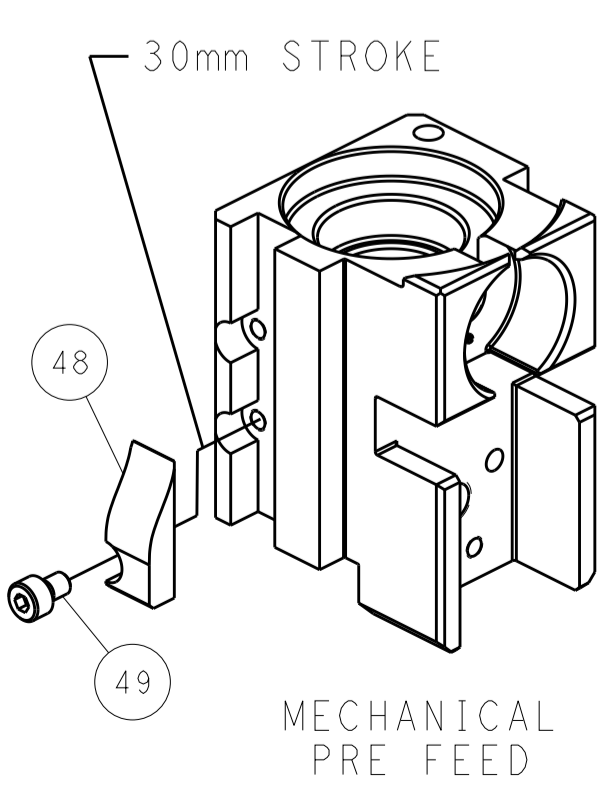
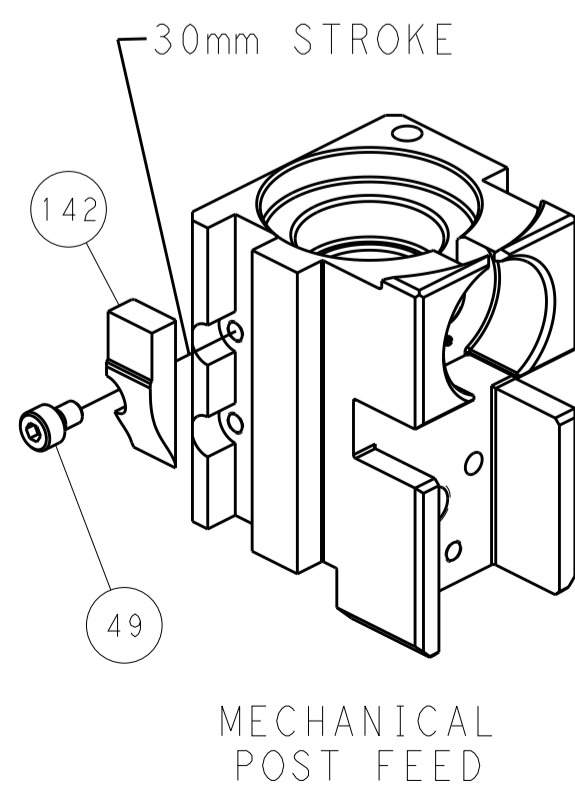
PNEUMATIC



FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



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 X ZHAO 06SEP2013		STE TE Connectivity	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	5 PLC ±	Harrisburg, PA 17105-3608
MATERIAL:		FINISH:		CHK T. ELBIN 06SEP2013		NAME	
				APVD L. ZHANG 06SEP2013		Ocean Side Feed Applicator	
				PRODUCT SPEC		SIZE CAGE CODE DRAWING NO	
				APPLICATION SPEC		A1 00779 C=2151246	
				WEIGHT		RESTRICTED TO	
				Customer Accessible Production Drawing		SCALE 1:2 SHEET 4 OF 4 REV F	