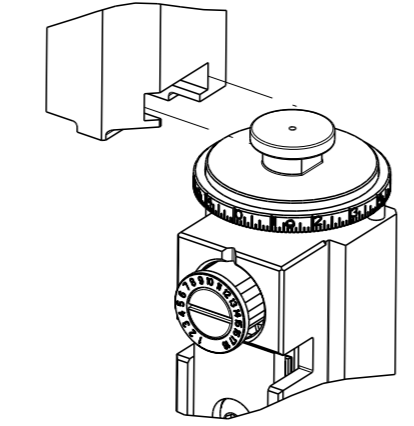


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151242-1	F	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2151242-2	F	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
5-2151242-1	F	SEAL STRIPPER CRIMPER TERMINATING UNIT	MECHANICAL
5-2151242-2	F	SEAL STRIPPER CRIMPER TERMINATING UNIT	PNEUMATIC
7-2151242-1	F	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2151242-2	F	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2151242-7	B	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA

CRIMP	SIZE	TYPE
WIRE	2.29 mm [.090]	F
INSUL	3.05 mm [.120]	O

APPLICATOR INSTRUCTIONS
408-35042

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION

TERMINAL NAME: .250 SERIES FASTON PIGGYBACK RECEPTACLE

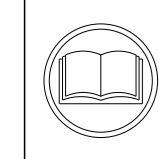
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE
4.70-5.46 mm [1.85-.215 IN]	Ø1.52-2.54 mm [0.060-.100 IN]

TERMINAL APPLICATION SPECIFICATION

TERMINALS APPLIED

TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
61988-1	61988-2	61988-3	61988-4

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
18 AWG	1.32+/-0.05 [0.052+/-0.002]	7.0
20 AWG	1.19+/-0.05 [0.047+/-0.002]	8.2
22 AWG	1.14+/-0.05 [0.045+/-0.002]	8.8



- 1 RECOMMENDED SPARE PARTS
- 2 REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- 3 APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 180. 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. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- 6 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.

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

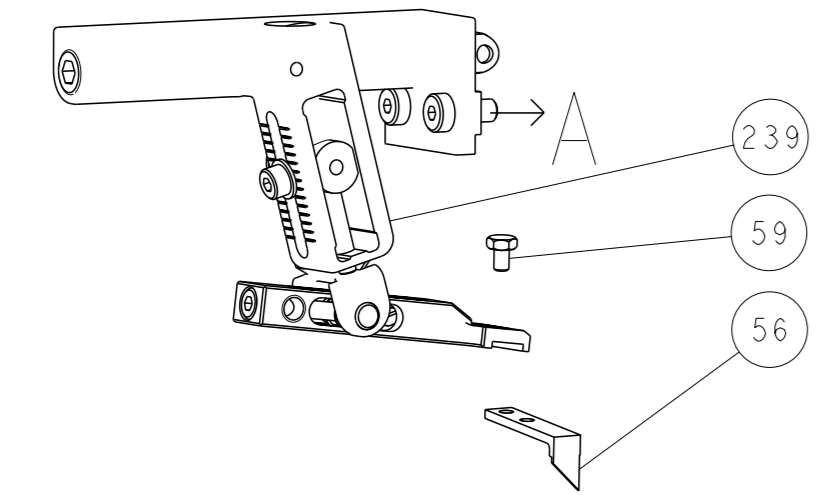
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A	66	C	05NOV2013	XZ	TE
		D	21MAR2017	TB	TE
		E	30MAY2018	FL	JD
		F	17DEC2018	JAH	TE

REV	DATE	BY	CHKD	DESCRIPTION	ITEM NO	
-	-	-	-	1803515-3	RAM ASSEMBLY, SF ATLANTIC	293
-	-	-	-	2-1803583-1	APPLICATOR BASIC ASSEMBLY, SF	292
-	1	1	1	2119791-7	DEPRESSOR, WIRE	286
-	1	-	-	2119640-1	PUSH ROD, AIR FEED	250
-	1	-	-	1803259-1	BUSHING, FLANGED	249
-	1	-	-	2119641-1	FEED CAM, AIR FEED	248
-	1	1	1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
3	-	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	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
-	-	-	-	4-1722335-3	STRIPPER, SIDE FEED	182
-	-	-	-	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	181
3	-	-	-	2-1752354-8	STANDOFF, HOLD-DOWN	180
-	-	-	-	993111-1	PIN, SLOTTED SPRING 3.0 X 20.0	177
-	-	-	-	5-22280-0	SPRING, COMPRESSION	176
-	-	-	-	1752353-3	GUIDE PIN, HOLDDOWN	175
-	-	-	-	1901680-2	GUIDE PIN, HOLDDOWN	174
-	2	-	-	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172
-	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	1	-	-	240638-1	SPRING, FEED FINGER	163
-	1	-	-	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854	137
-	1	-	-	2119799-1	HOLDER, FEED FINGER, AF	136
-	1	1	1	1-18028-2	WASHER, FLAT, REG M4	119
6	-	1	1	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113
-	1	1	1	2844908-1	SCREW, LOCKING	99
-	1	1	1	2844907-1	POST, LOCKING	98
-	1	1	1	455888-4	SPACER, CRIMPER	82
-	1	1	1	1803607-1	DOCUMENTATION PACKAGE	71
-	1	1	1	2119791-9	DEPRESSOR, WIRE	70
-	1	1	1	2119740-1	TAG, IDENTIFICATION	67
-	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	60
-	1	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	1	1	1	1338685-1	PAWL, FEED	56
-	4	4	4	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	54
-	2	2	2	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	53
-	1	1	1	5018030-1	NUT, HEX, REG, RoHS, M3	52
-	1	1	1	811242-5	BUMPER, HOLD DOWN	51
-	1	1	1	690753-2	SPACER, TONKER	50
-	1	2	1	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	-	1803583-9	APPLICATOR BASIC ASSEMBLY, SF	46
-	1	1	-	1803515-1	RAM ASSEMBLY, SF ATLANTIC	44
-	1	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
-	1	1	1	1752356-7	SUPPORT, TERMINAL	34
-	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	2	2-2844962-8	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29
-	1	1	1	1320928-2	STRIP GUIDE	24
-	1	1	-	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
-	2	2	1	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	1	3-22280-3	SPRING, COMPRESSION	12
-	1	1	1	1-356885-3	STOP, SHEAR	11
1	-	1	1	2119805-1	SHEAR HOLDER, FRONT	10
1	-	1	1	1803095-6	FLOATING SHEAR, FRONT	9
1	1	2	1	5-1333205-6	ANVIL, COMBINATION	8
-	1	1	1	6-240641-7	SPACER	7
-	-	-	-	-	-	6
-	1	1	1	2119757-4	DEPRESSOR, SHEAR	5
-	1	1	1	238011-4	BLOCK, CRIMPER SPACER	4
1	1	2	1	1633965-2	CRIMPER, INSULATION O PREMIUM	3
-	1	1	1	1-455888-4	SPACER, CRIMPER	2
1	1	2	1	4-456406-4	CRIMPER, WIRE PREMIUM	1

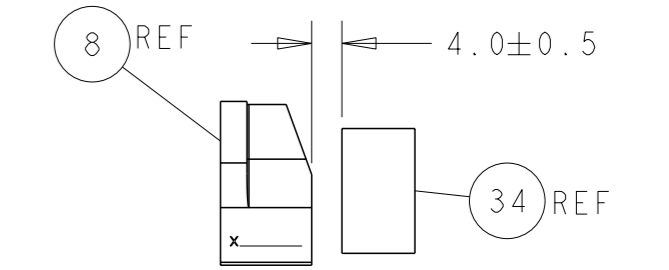
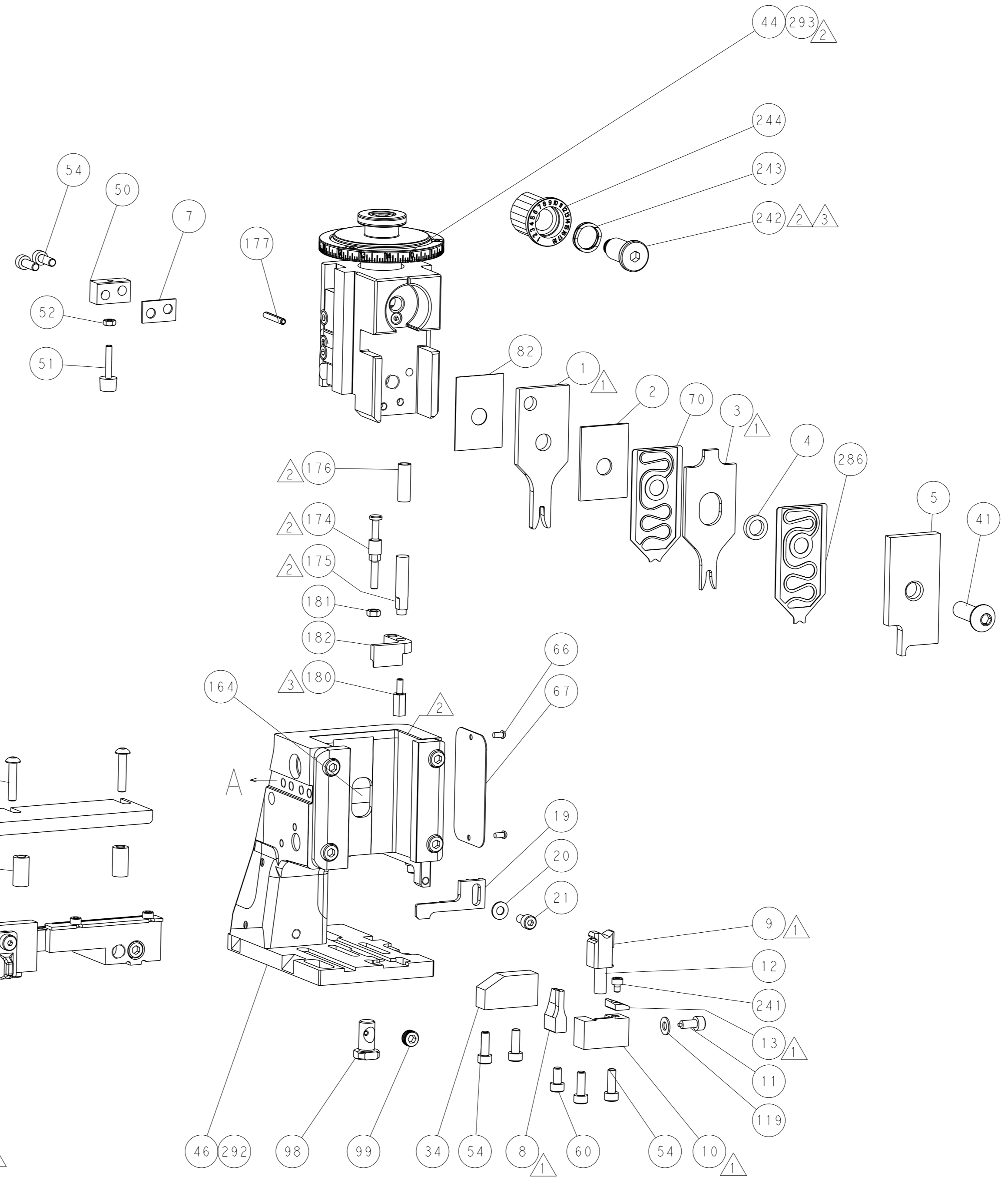
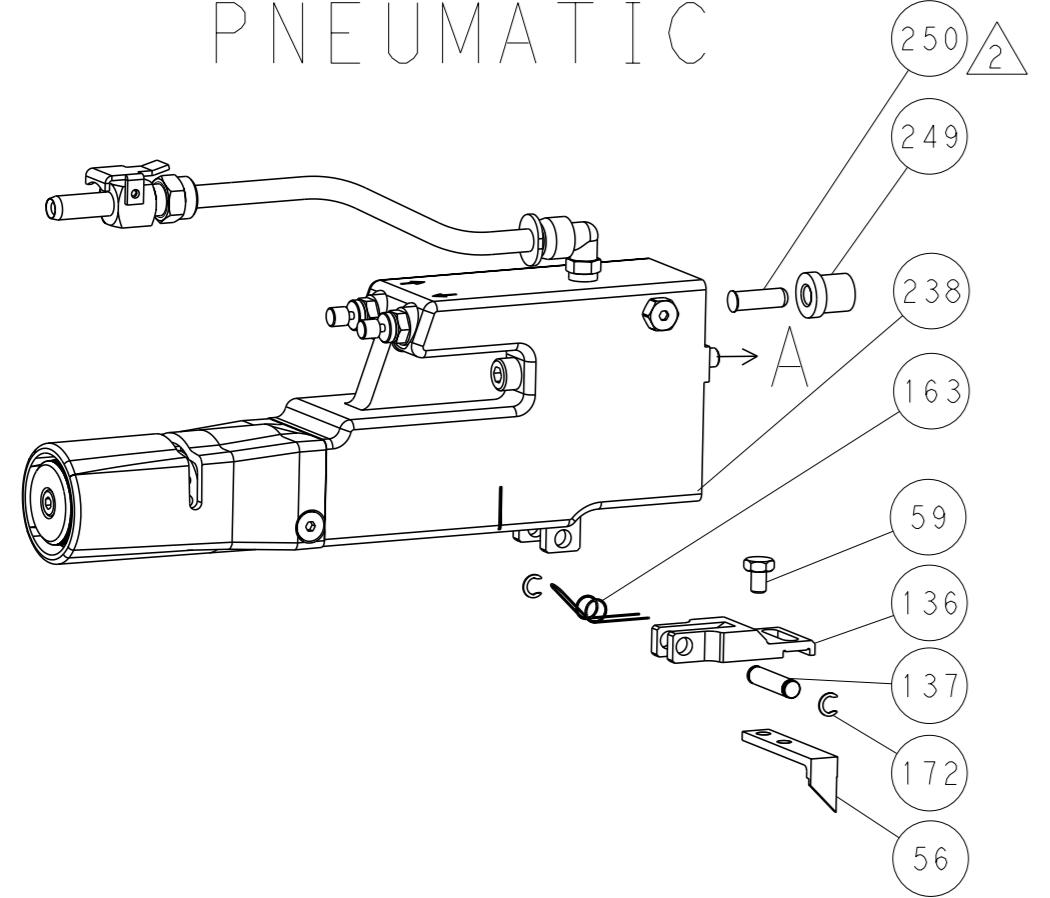
DIMENSIONS:	TOLERANCES UNLESS OTHERWISE SPECIFIED:	OWN	DATE	NAME
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		T. ELBIN	04MAY2012	
		T. ELBIN	04MAY2012	
MATERIAL:	FINISH:	APVD	PRODUCT SPEC	APPLICATION SPEC
		WEIGHT	SCALE	SHEET
			1:2	1 of 4

LOC	DIST	REVISIONS			
A	66	REV	DATE	OWN	APVD
		-	SEE SHEET 1	-	-

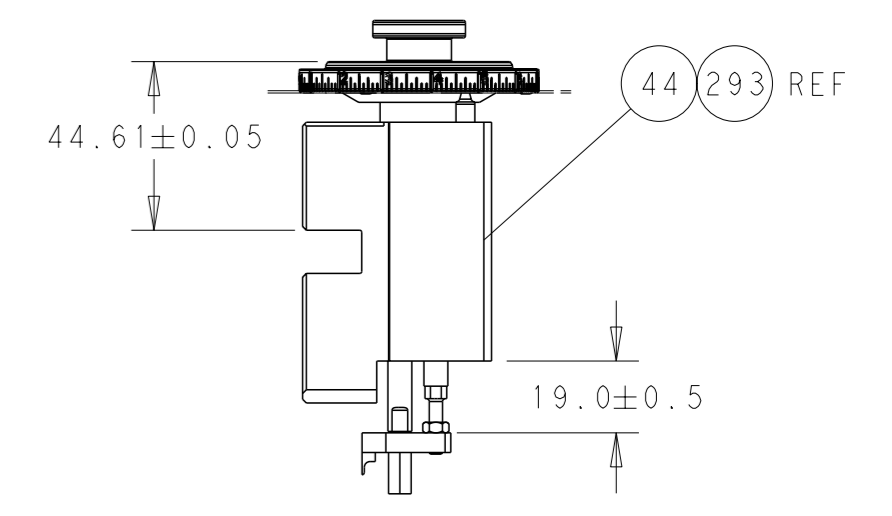
FEED TYPE MECHANICAL



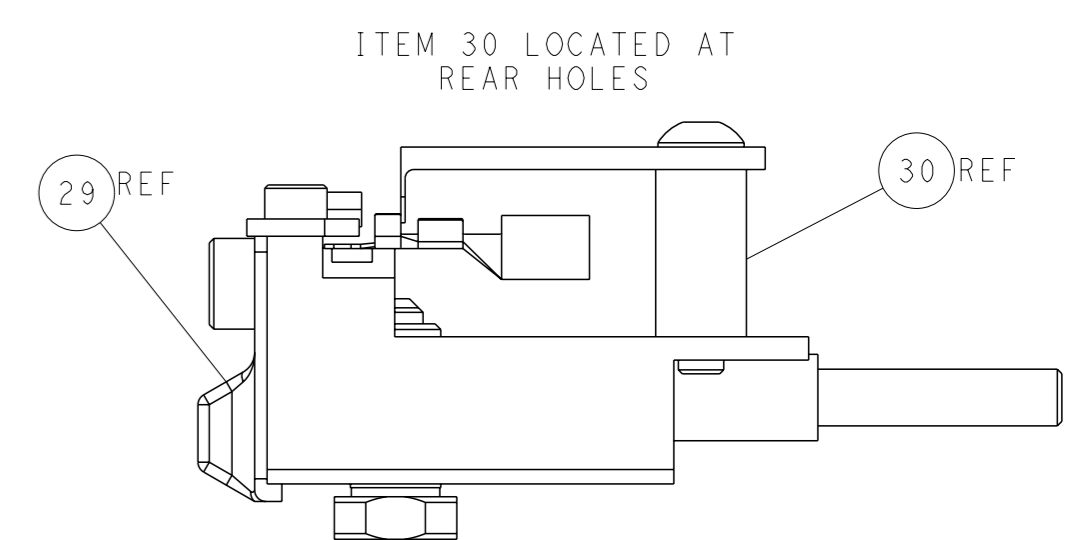
PNEUMATIC



TERMINAL SUPPORT LOCATION

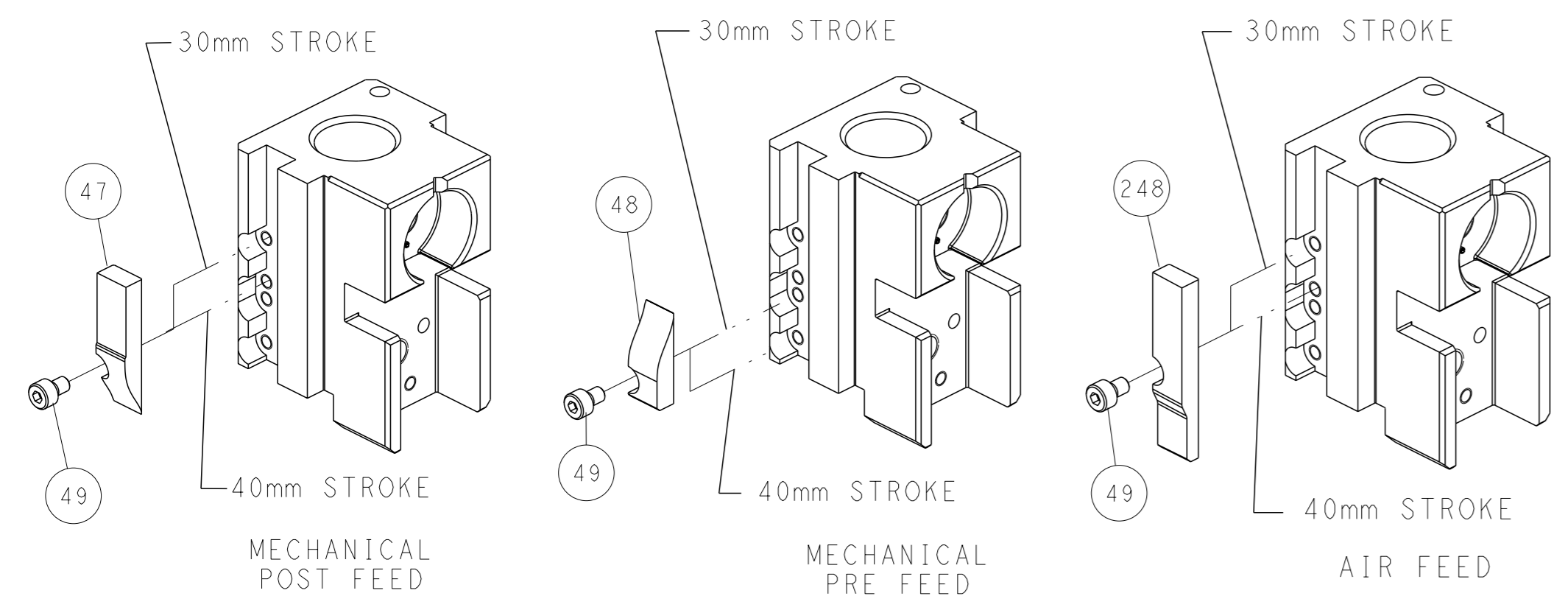


RAM AND HOLD-DOWN SET-UP



FEED TRACK POSITION GUIDE BY INSULATION BARREL

CAM POSITIONS

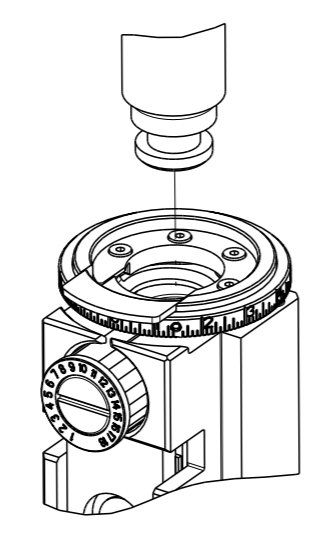


ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

<small>THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE AND THE CONTROL AND REVISIONS DISPOSITION SHOULD BE CONTACTED FOR THE LATEST REVISION.</small>		OWN: C. MOYER 04MAY2012 CHK: T. ELBIN 04MAY2012 APVD: T. ELBIN 04MAY2012	TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH ±		NAME: Ocean Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2151242	RESTRICTED TO: - SCALE: 1:2 SHEET: 2 of 4 REV: F
MATERIAL: - FINISH: -		WEIGHT: - Customer Accessible Production Drawing	SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2151242-1	F	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2151242-2	F	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151242-7	B	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
 INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.29 mm (.090)	F
INSUL	3.05 mm (.120)	O
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: .250 SERIES FASTON PIGGYBACK RECEPTACLE			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
4.70-5.46 mm (.185-.215 IN)		Ø1.52-2.54 mm (.060-.100 IN)	
TERMINAL APPLICATION SPECIFICATION	114-2082		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
61988-1	61988-2	61988-3	61988-4

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
18 AWG	1.32+/-0.05 [0.052+/-0.002]	7.0
20 AWG	1.19+/-0.05 [0.047+/-0.002]	8.2
22 AWG	1.14+/-0.05 [0.045+/-0.002]	8.8

- 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.

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

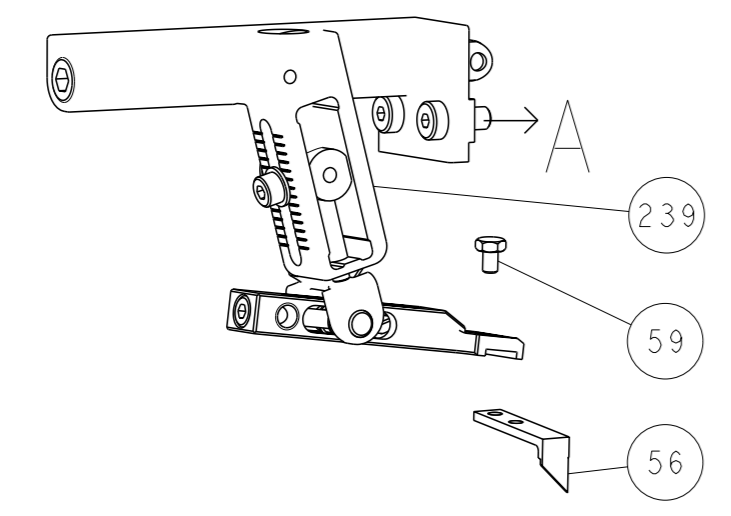
LOC	DIST	REVISIONS			
A	66	REV	DATE	BY	APPV
-	-	SEE SHEET 1	-	-	-

-	1	1	2119791-7	DEPRESSOR, WIRE	286
-	1	-	2119640-1	PUSH ROD, AIR FEED	250
-	1	-	1803259-1	BUSHING, FLANGED	249
-	1	1	2119082-9	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	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	455888-4	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	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	1752356-7	SUPPORT, TERMINAL	34
-	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	2-2844962-8	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29
-	1	1	1320928-2	STRIP GUIDE	24
-	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	2119533-1	STRIPPER, SIDE FEED	19
-	1	1	2119806-1	INSERT, SHEAR	13
-	1	1	3-22280-3	SPRING, COMPRESSION	12
-	1	1	1-356885-3	STOP, SHEAR	11
-	1	1	2119805-1	SHEAR HOLDER, FRONT	10
-	1	1	1803095-6	FLOATING SHEAR, FRONT	9
-	1	1	5-1333205-6	ANVIL, COMBINATION	8
-	1	1	6-240641-7	SPACER	7
-	-	-	-	-	6
-	1	1	2119757-4	DEPRESSOR, SHEAR	5
-	1	1	238011-4	BLOCK, CRIMPER SPACER	4
-	1	1	1633965-2	CRIMPER, INSULATION O PREMIUM	3
-	1	1	1-455888-4	SPACER, CRIMPER	2
-	1	1	4-456406-4	CRIMPER, WIRE PREMIUM	1

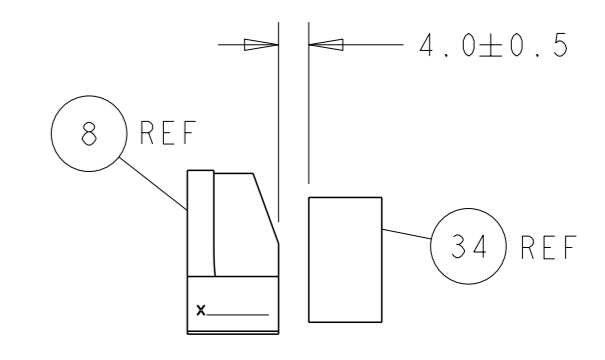
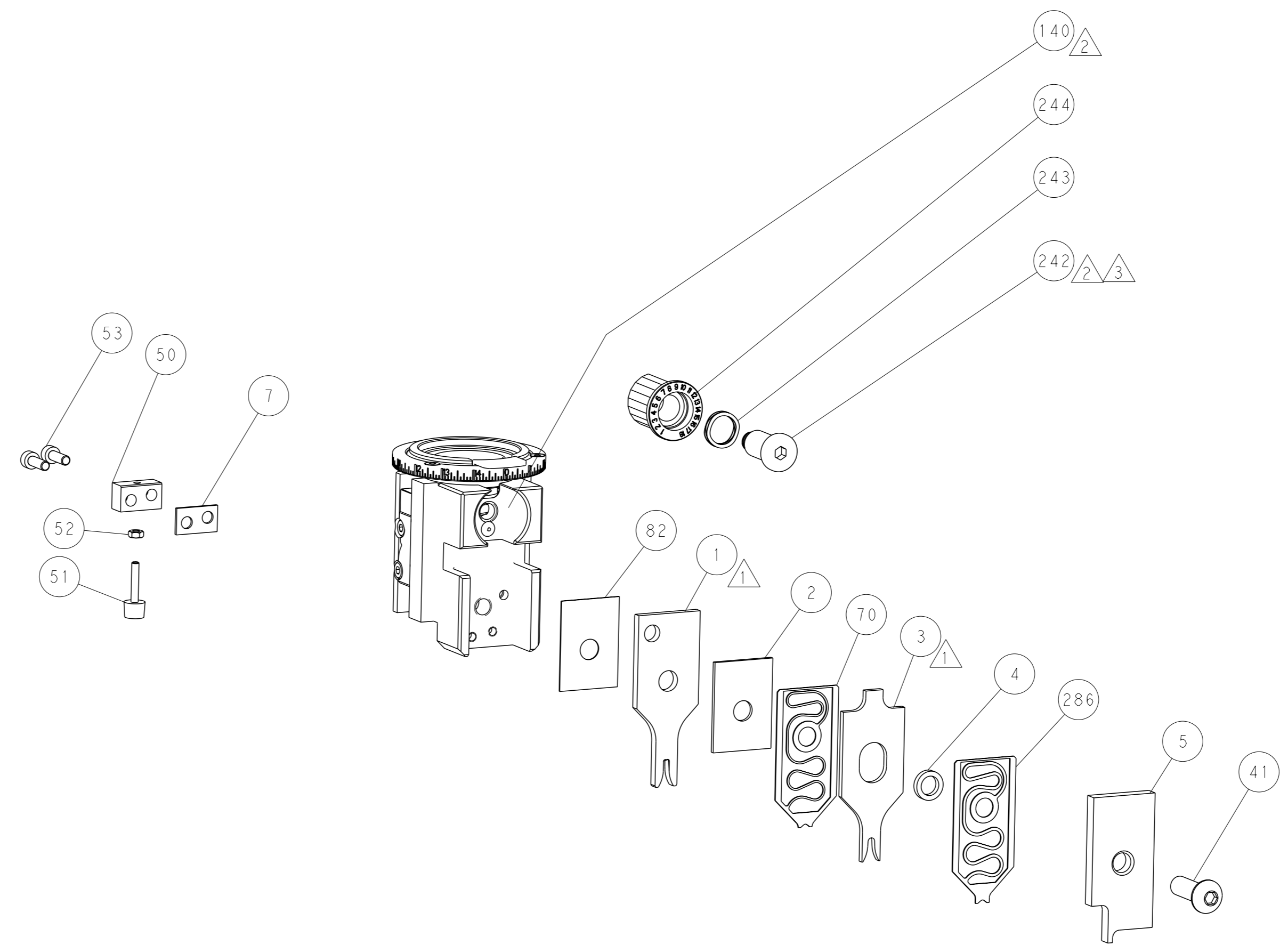
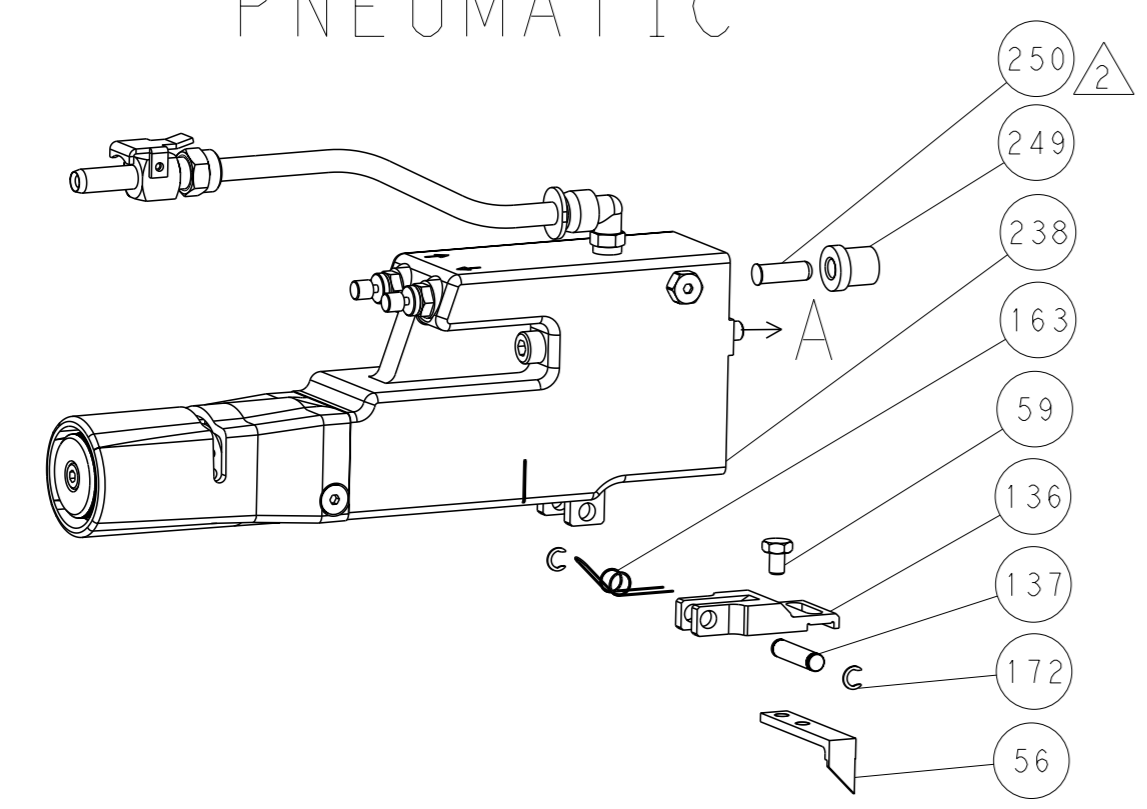
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		OWN	DATE	REV	DESCRIPTION	ITEM NO
mm	0 PLC ±	1 PLC ±	2 PLC ±	C. MOYER	04MAY2012		TE Connectivity	
	3 PLC ±	4 PLC ±	ANGLES ±	T. ELBIN	04MAY2012		Harrisburg, PA 17105-3608	
	FINISH			I. ELBIN	04MAY2012			
MATERIAL							Ocean Side Feed Applicator	
							SIZE CAGE CODE DRAWING NO	RESTRICTED TO
							A1 00779 C=2151242	
							Customer Accessible Production Drawing	SCALE 1:2 SHEET 3 OF 4 REV F

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

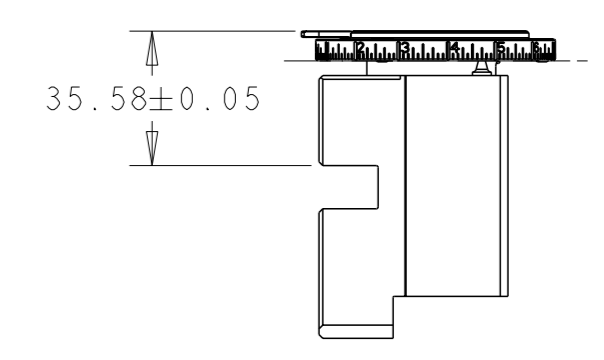
FEED TYPE MECHANICAL



PNEUMATIC

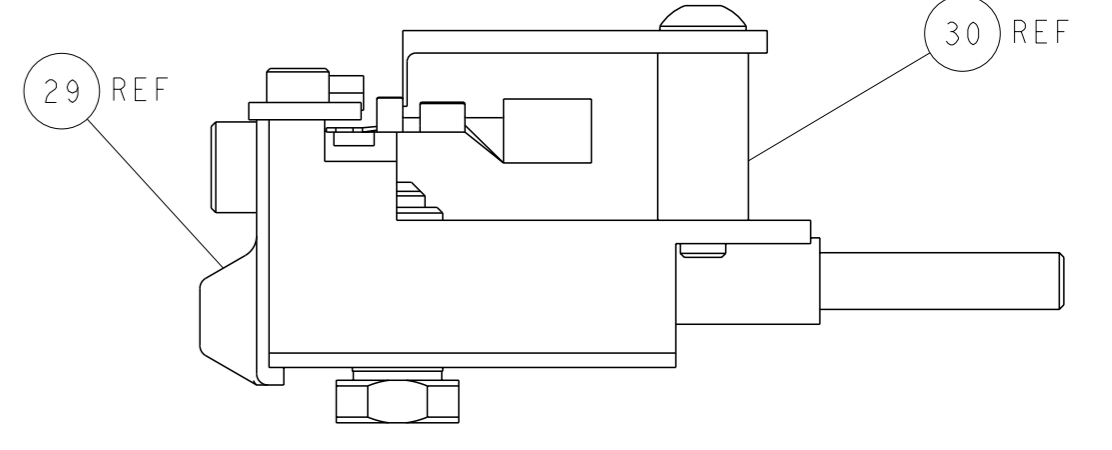


TERMINAL SUPPORT LOCATION



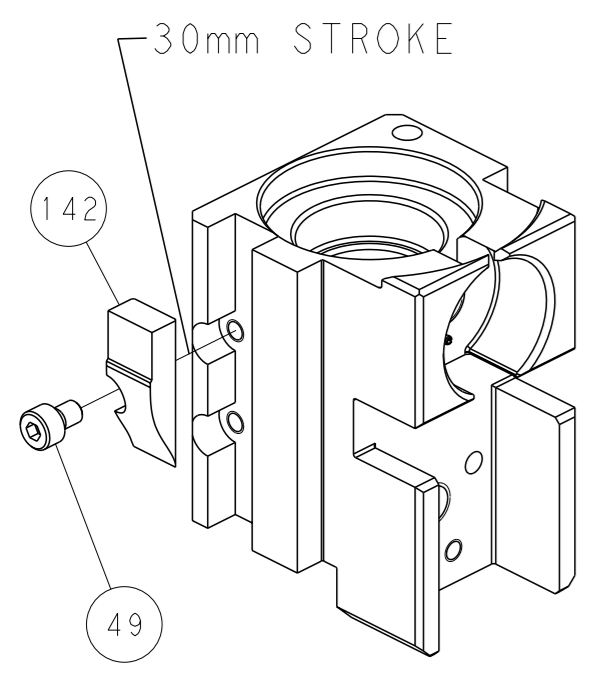
RAM SET-UP

ITEM 30 LOCATED AT REAR HOLES

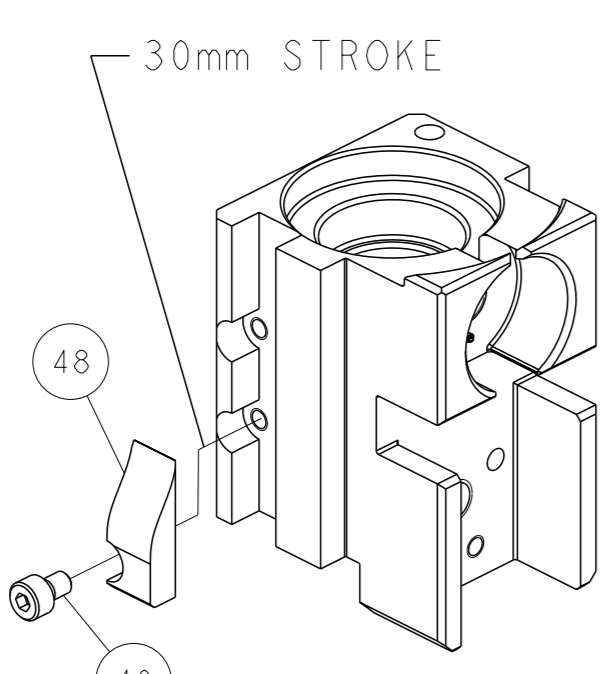


FEED TRACK POSITION GUIDE BY INSULATION BARREL

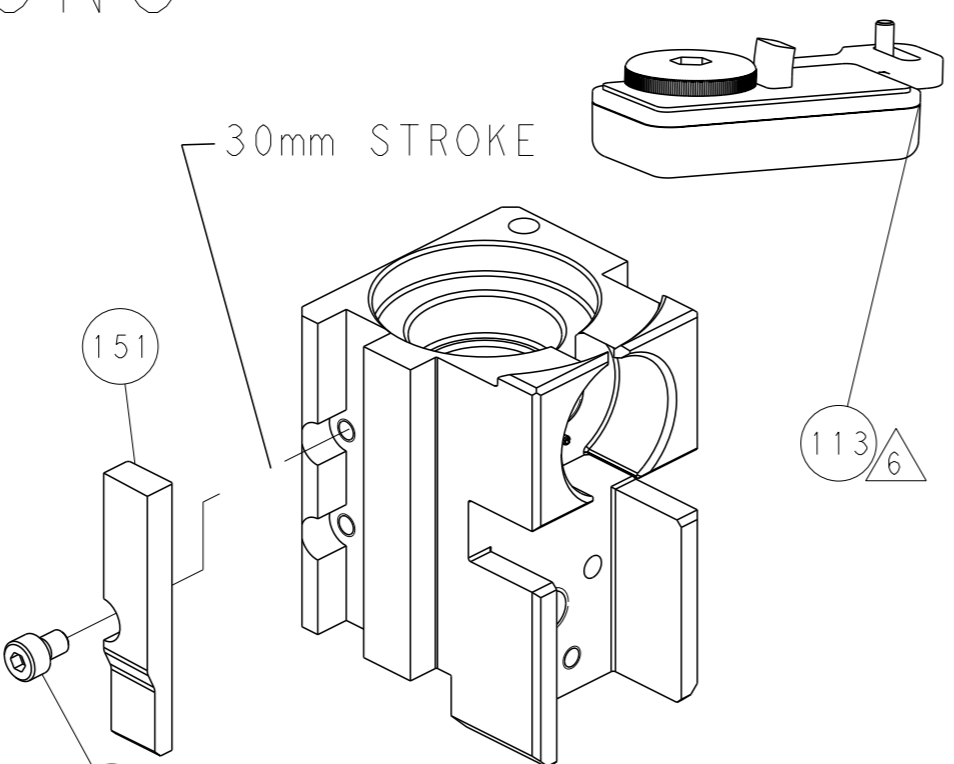
CAM POSITIONS



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)

<small>THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE AND THE CONTROLLER'S ENGINEERING DEPARTMENT SHOULD BE CONTACTED FOR THE LATEST REVISION.</small>		OWN: C. MOYER 04MAY2012 CHK: T. ELBIN 04MAY2012 APVD: T. ELBIN 04MAY2012	TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH ±		NAME: Ocean Side Feed Applicator APPLICATION SPEC: - WEIGHT: - SCALE: 1:2	SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2151242 SHEET 4 OF 4 REV F
MATERIAL: - FINISH: -		Customer Accessible Production Drawing	