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20		20	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151030-1	G	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2151030-2	H	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
5-2151030-1	G	SEAL STRIPPER CRIMPER TERMINATING UNIT	MECHANICAL
5-2151030-2	H	SEAL STRIPPER CRIMPER TERMINATING UNIT	PNEUMATIC
7-2151030-1	G	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2151030-2	H	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2151030-7	C	CRIMP TOOLING KIT	-

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.57 mm [.062]	F
INSUL	2.79 mm [.110]	F
APPLICATOR INSTRUCTIONS 408-35042		

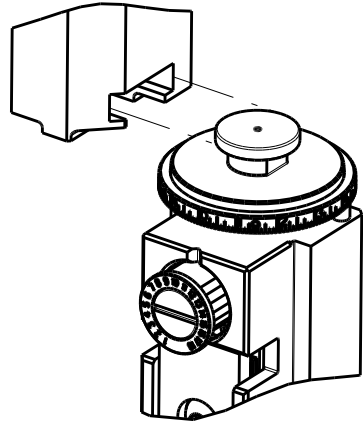
TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION			
TERMINAL NAME: MINI UNIVERSAL MATE-N-LOK			
WIRE STRIP LENGTH 3.20-3.70 mm [.126-.146 IN]		INSULATION DIAMETER RANGE -	
TERMINAL APPLICATION SPECIFICATION		(A)114-16017	(A)114-13089
		(B)114-5050	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
(A) 770903-1	(A) 770904-1	(A) 794137-1	(B) 170360-6
(A) 770903-2	(A) 770904-2	(A) 794137-2	(B) 170362-1
(A) 770903-3	(A) 770904-3	(A) 794137-3	(B) 170362-2
(A) 770903-4	(A) 770904-4	(A) 1-794137-0	(B) 170362-3
(A) 770903-5	(A) 770904-5	(B) 170360-1	(B) 170362-4
(A) 770903-6	(A) 770904-6	(B) 170360-2	(B) 170362-6
(A) 1-770903-0	(A) 1-770904-0	(B) 170360-3	(B) 1-170362-3
(A) 1-770903-1	(A) 1-770904-1	(B) 170360-4	

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
18 AWG	1.07+/-0.05 [.042+/- .002]	6.7
0.75mm2	1.04+/-0.05 [.041+/- .002]	7.0
20 AWG OR 0.50mm2	0.91+/-0.05 [.036+/- .002]	8.5
2 X 22 AWG	0.91+/-0.05 [.036+/- .002]	8.5
22 AWG OR 0.35mm2	0.81+/-0.05 [.032+/- .002]	9.5



- 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 TERMINAL LUBRICANT IS RECOMMENDED.
- 6 114-13089 TERMINAL SPECIFICATION IS FOR SEAL APPLICATION ONLY. "F" TYPE INSULATION CRIMP SNAIL CAM SETTING FOR SEAL APPLICATIONS WILL DIFFER TO THAT OF UNSEALED APPLICATIONS
7. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.

ATLANTIC VERSION TERMINATOR
INTERFACE ADAPTER



*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.

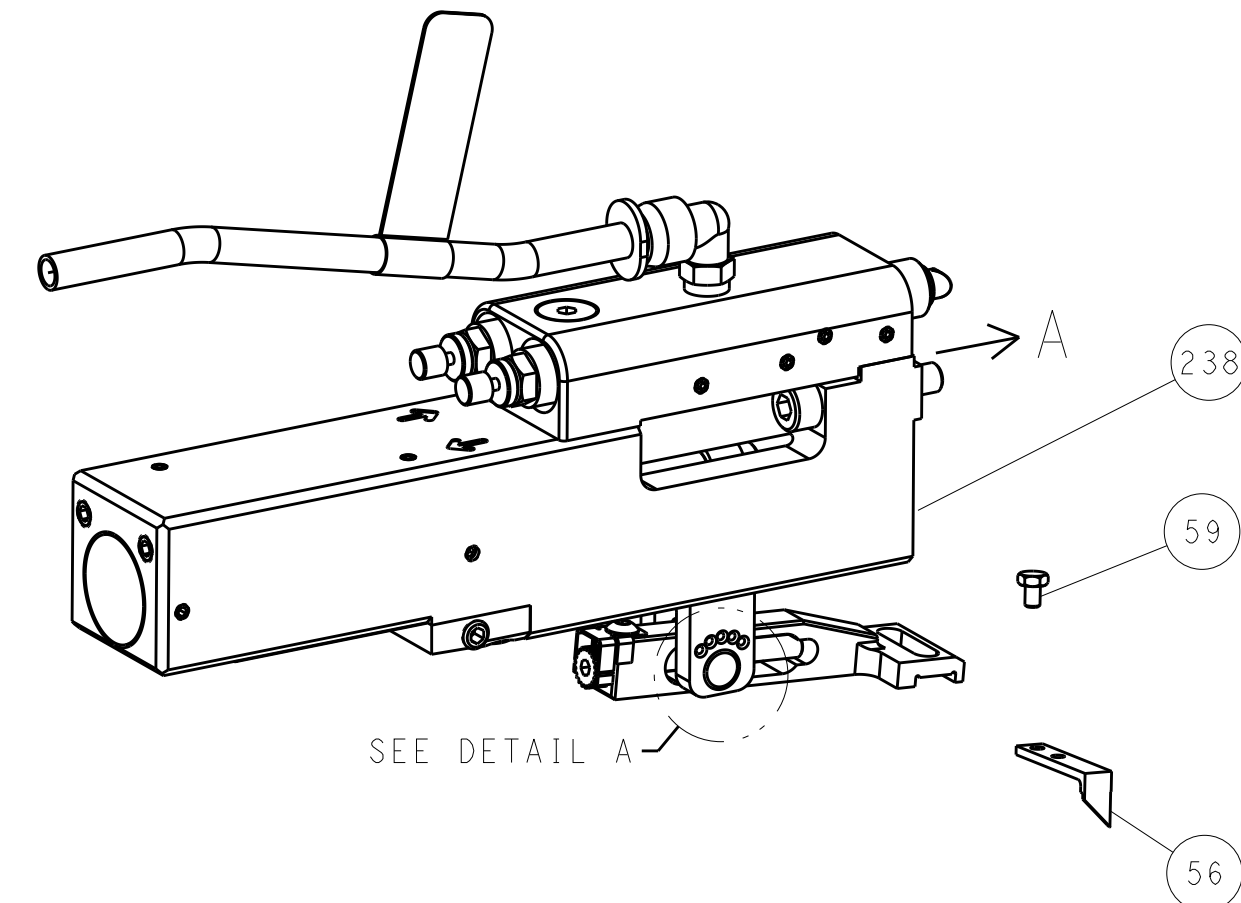
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

LOC		DIST		REVISONS			
A		66		P	LTR	DESCRIPTION	DATE
							DWN
							APVD
				E		ECR-17-008457	19JUN2017
				F		ECR-18-005797	17APR2018
				G		ECR-18-012682	09AUG2018
				H		ECR-19-005937	12APR2019

-	-	-	1	1	-	-	1803515-3	RAM ASSEMBLY, SF ATLANTIC	293
-	-	-	1	1	-	-	2-1803583-1	APPLICATOR BASIC ASSEMBLY, SF	292
-	1	-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248
-	1	1	1	1	1	1	2119082-3	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	1	1	1	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
-	-	1	-	1	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	1	-	1	-	1	-	2844940-1	AIR FEED MODULE	238
-	-	-	1	1	-	-	4-1722335-3	STRIPPER, SIDE FEED	182
-	-	-	1	1	-	-	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	181
-	-	-	1	1	-	-	1-1752354-9	STANDOFF,HOLD-DOWN	180
-	-	-	1	1	-	-	993111-1	PIN, SLOTTED SPRING 3.0 X 20.0	177
-	-	-	1	1	-	-	5-22280-0	SPRING, COMPRESSION	176
-	-	-	1	1	-	-	1752353-3	GUIDE PIN,HOLDDOWN	175
-	-	-	1	1	-	-	1901680-2	GUIDE PIN,HOLDDOWN	174
-	REF	REF	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	1	1	1	1	1	1	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113
-	1	1	1	1	1	1	2844908-1	SCREW, LOCKING	99
-	1	1	1	1	1	1	2844907-1	POST, LOCKING	98
-	1	1	1	1	1	1	455888-5	SPACER, CRIMPER	82
-	1	1	1	1	1	1	1803607-3	DOCUMENTATION PACKAGE	71
-	1	1	1	1	1	1	2119740-1	TAG,IDENTIFICATION	67
-	2	2	2	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	1	1	1	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	60
-	1	1	1	1	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	1	1	1	1	1	1	1338685-1	PAWL, FEED	56
-	4	4	4	4	4	4	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	54
-	2	2	2	2	2	2	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	53
-	1	1	1	1	1	1	1803382-6	HOLD DOWN, SPRING LOADED	50
-	1	2	1	2	1	2	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	-	1	-	1	-	1	2119652-1	FEED CAM, PRE FEED	48
-	-	1	-	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	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
-	1	1	1	1	1	1	1752356-5	SUPPORT, TERMINAL	34
-	2	2	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	2	2	2	2	2-2844962-4	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	1	1	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29
-	1	1	1	1	1	1	455888-3	SPACER, CRIMPER	28
-	1	1	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	1	1	2	2	1-18028-2	WASHER, FLAT, REG M4	20
-	1	1	-	-	1	1	2119533-1	STRIPPER, SIDE FEED	19
-	1	1	1	1	1	1	2119806-1	INSERT, SHEAR	13
-	1	1	1	1	1	1	3-22280-3	SPRING, COMPRESSION	12
-	1	1	1	1	1	1	2-519000-1	SCR, SKT HD CAP M4 X 10.0	11
-	1	1	1	1	1	1	2119805-1	SHEAR HOLDER, FRONT	10
-	1	1	1	1	1	1	1803095-1	FLOATING SHEAR, FRONT	9
1	2	2	1	1	1	1	1338691-1	ANVIL, COMBINATION .062	8
-	1	1	1	1	1	1	3-240641-3	SPACER	7
-	1	1	1	1	1	1	2119757-4	DEPRESSOR, SHEAR	5
-	1	1	1	1	1	1	2-238011-2	BLOCK, CRIMPER SPACER	4
1	2	2	1	1	1	1	2-2119582-1	CRIMPER, INSULATION F PREMIUM	3
-	1	1	1	1	1	1	455888-1	SPACER, CRIMPER	2
1	2	2	1	1	1	1	1633860-3	CRIMPER, WIRE	1

-77	-72	-71	-52	-51	-2	-1	PART NO	DESCRIPTION	ITEM NO
THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE WITHOUT NOTICE AND THE MANUFACTURING ORGANIZATION SHALL BE CONTACTED FOR THE LATEST REVISION.							DWN G. MOYER 03NOV2011	TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm							CHK G. BAILEY 03NOV2011	NAME Ocean Side Feed Applicator	
TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±							APVD G. BAILEY 03NOV2011	PRODUCT SPEC	
MATERIAL							FINISH	APPLICATION SPEC	
								WEIGHT	
								Customer Accessible Production Drawing	
								SCALE 1:2	
								SHEET 1 OF 4	
								REV H	

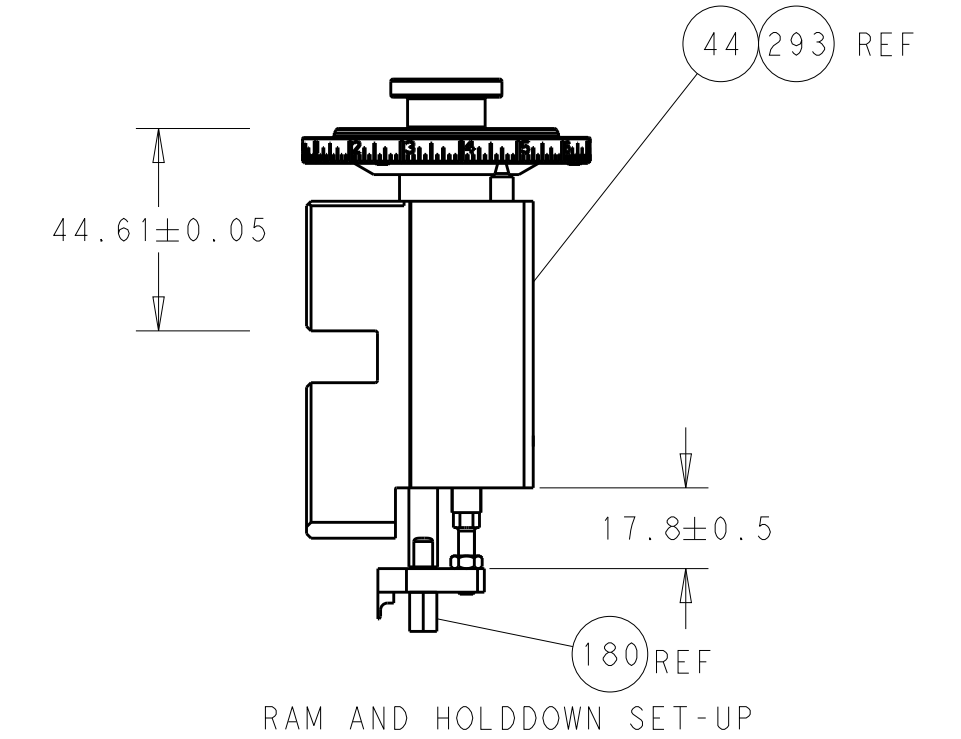
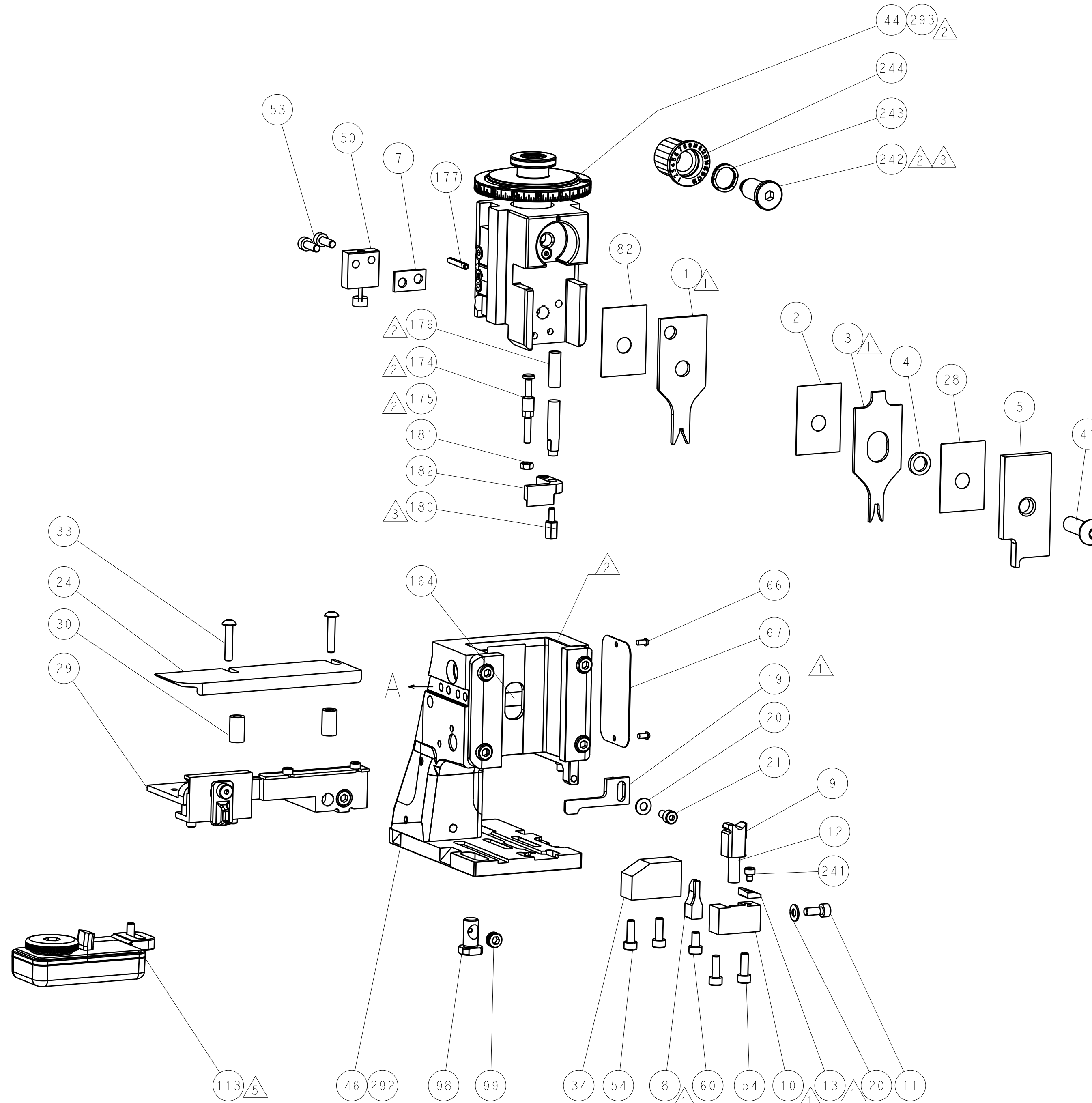
PNEUMATIC



DETAIL A

0mm STROKE
AIR FEED

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



FEED TRACK POSITION
GUIDE BY INSULATION BARREL

THIS DRAWING IS A CONFIDENTIAL DOCUMENT FOR TFCO INDUSTRIES CORPORATION IT IS SUBJECT TO CHANGE AND THE CONTROLLING ENGINEERING ORGANIZATION SHOULD BE NOTIFIED FOR THE LATEST REVISION		DWN 03NOV2011 CKK MOYER G. BAILEY 03NOV2011 APWU G. BAILEY 03NOV2011		 TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		NAME Ocean Side Feed Applicator	
MATERIAL -		FINISH -		SIZE A 1	
WEIGHT -		PRODUCT SPEC - APPLICATION SPEC -		CAGE CODE 00779	
				DRAWING NO C=2151030	
				RESTRICTED TO -	
		Customer Accessible Production Drawing		SCALE 1:2 SHEET 2 OF 4 REV H	

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PART NUMBER		REVISION		DESCRIPTION	
2-2151030-1		G		FINE CRIMP HEIGHT ADJUST	
2-2151030-2		H		FINE CRIMP HEIGHT ADJUST	
7-2151030-7		C		CRIMP TOOLING KIT	
				FEED TYPE	
				MECHANICAL	
				PNEUMATIC	
				-	

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.57 mm [.062]	F
INSUL	2.79 mm [.110]	F
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: TE TERMINAL				TE CRIMP SPECIFICATION	
TERMINAL NAME: MINI UNIVERSAL MATE-N-LOK					
WIRE STRIP LENGTH				INSULATION DIAMETER RANGE	
3.20-3.70 mm [.126-.146 IN]				-	
TERMINAL APPLICATION SPECIFICATION	(A)114-16017	(A)114-13089		-	-
	(B)114-5050	-	-	-	-
TERMINALS APPLIED					
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL	TERM PART NO	INSULATION RANGE
(A) 770903-1	(A) 770904-1	(A) 794137-1	(B) 170360-6	770903	1.5-2.4 mm
(A) 770903-2	(A) 770904-2	(A) 794137-2	(B) 170362-1	770904	
(A) 770903-3	(A) 770904-3	(A) 794137-3	(B) 170362-2	170362	
(A) 770903-4	(A) 770904-4	(A) 1-794137-0	(B) 170362-3	170360	
(A) 770903-5	(A) 770904-5	(B) 170360-1	(B) 170362-4	794137	1.5-2.8 mm
(A) 770903-6	(A) 770904-6	(B) 170360-2	(B) 170362-6		
(A) 1-770903-0	(A) 1-770904-0	(B) 170360-3	(B) 1-170362-3		
(A) 1-770903-1	(A) 1-770904-1	(B) 170360-4			

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING
18 AWG		1.07+/-0.05 [.042+/- .002]		6.7
0.75mm2		1.04+/-0.05 [.041+/- .002]		7.0
20 AWG OR 0.50mm2		0.91+/-0.05 [.036+/- .002]		8.5
2 X 22 AWG		0.91+/-0.05 [.036+/- .002]		8.5
22 AWG OR 0.35mm2		0.81+/-0.05 [.032+/- .002]		9.5

*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.



- 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 LUBRICANT IS RECOMMENDED.
- 114-13089 TERMINAL SPECIFICATION IS FOR SEAL APPLICATION ONLY. "F" TYPE INSULATION CRIMP SNAIL CAM SETTING FOR SEAL APPLICATIONS WILL DIFFER TO THAT OF UNSEALED APPLICATIONS
- UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.

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	P	LTR	DESCRIPTION	DATE	DWN	APVD
		-		SEE SHEET 1	-	-	-

-	1	1	2119082-3	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	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113
-	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	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	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	1752356-5	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	2844992-1	ASSEMBLY, STRIP GUIDE	29
-	1	1	455888-3	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	2-519000-1	SCR, SKT HD CAP M4 X 10.0	11
-	1	1	2119805-1	SHEAR HOLDER, FRONT	10
-	1	1	1803095-1	FLOATING SHEAR, FRONT	9
-	1	1	1338691-1	ANVIL, COMBINATION .062	8
-	1	1	3-240641-3	SPACER	7
-	1	1	2119757-4	DEPRESSOR, SHEAR	5
-	1	1	2-238011-2	BLOCK, CRIMPER SPACER	4
-	1	1	2-2119582-1	CRIMPER, INSULATION F PREMIUM	3
-	1	1	455888-1	SPACER, CRIMPER	2
-	1	1	1633860-3	CRIMPER, WIRE	1
-77	-22	-21	PART NO	DESCRIPTION	ITEM NO

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TOLERANCES UNLESS OTHERWISE SPECIFIED:				CHK G. BAILEY 03NOV2011	NAME	
DIMENSIONS:				APVD G. BAILEY 03NOV2011	Ocean Side Feed Applicator	
mm				PRODUCT SPEC	SIZE	
				APPLICATION SPEC	CAGE CODE	
0 PLC ±				WEIGHT	DRAWING NO	
1 PLC ±					RESTRICTED TO	
2 PLC ±					00779	
3 PLC ±					©=2151030	
4 PLC ±					Customer Accessible Production Drawing	
ANGLES					SCALE	
FINISH					1:2	
MATERIAL					SHEET	
					3 OF 4	
					REV	
					H	

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

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

D

C

B

A

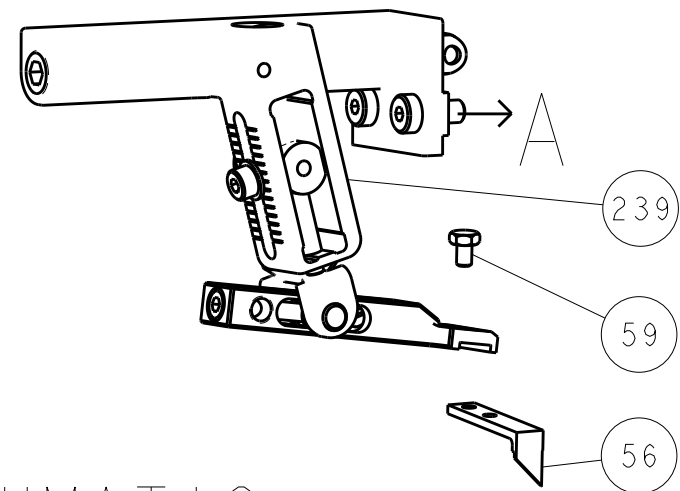
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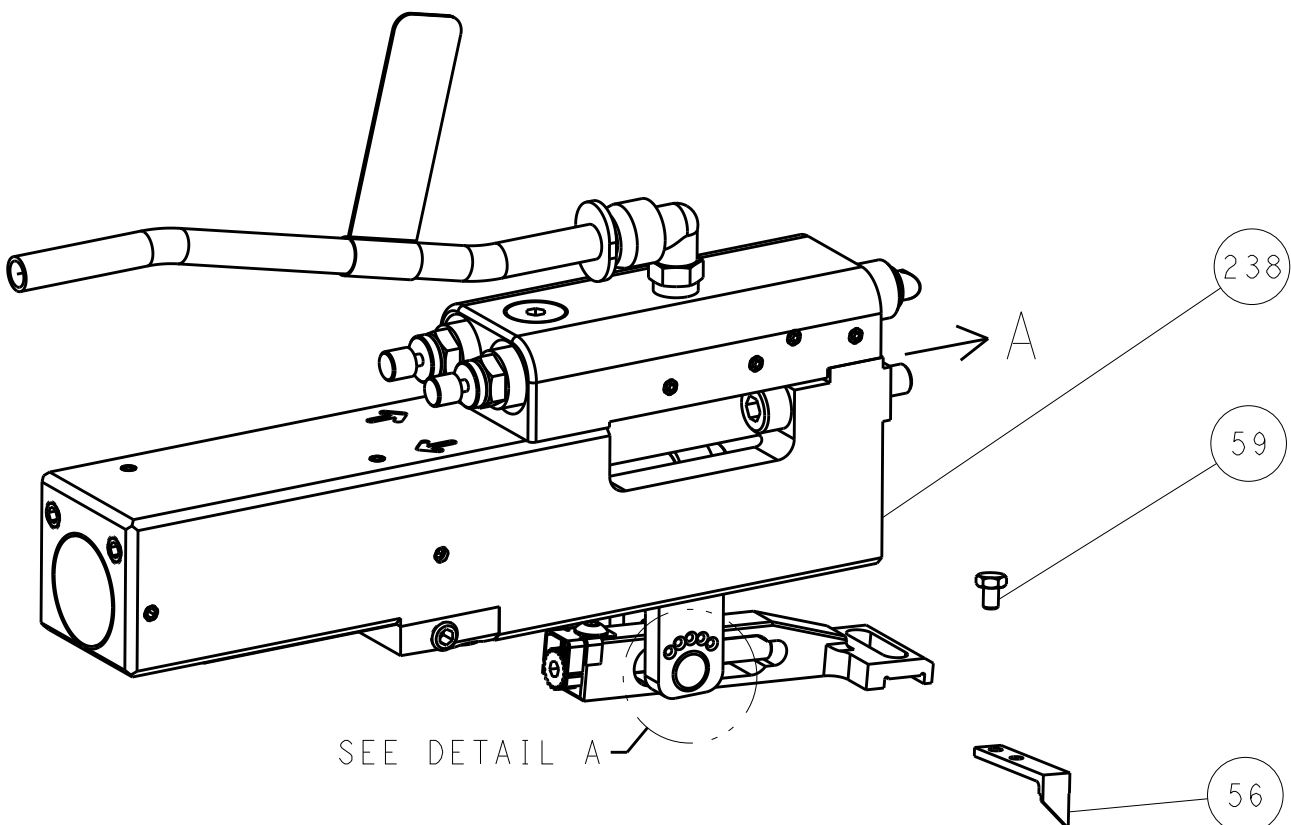
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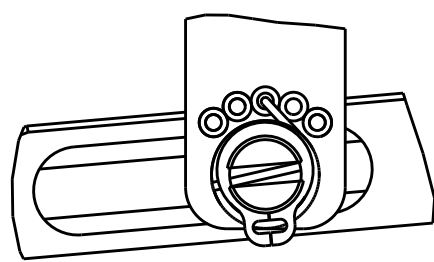
FEED TYPE MECHANICAL



PNEUMATIC

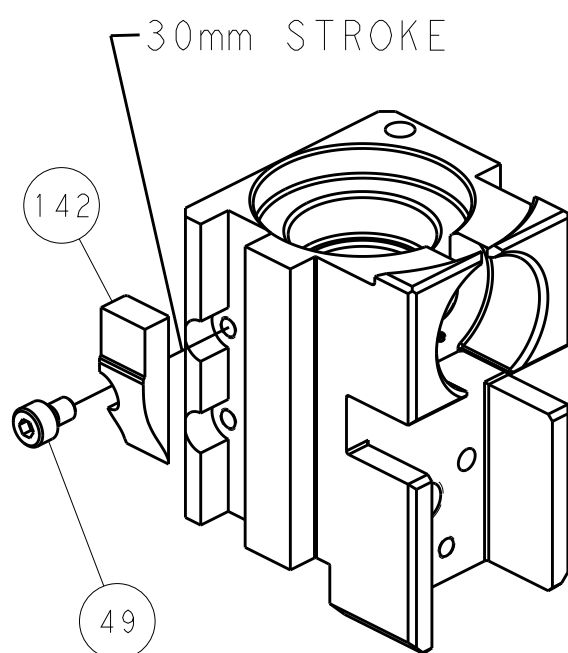


FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)

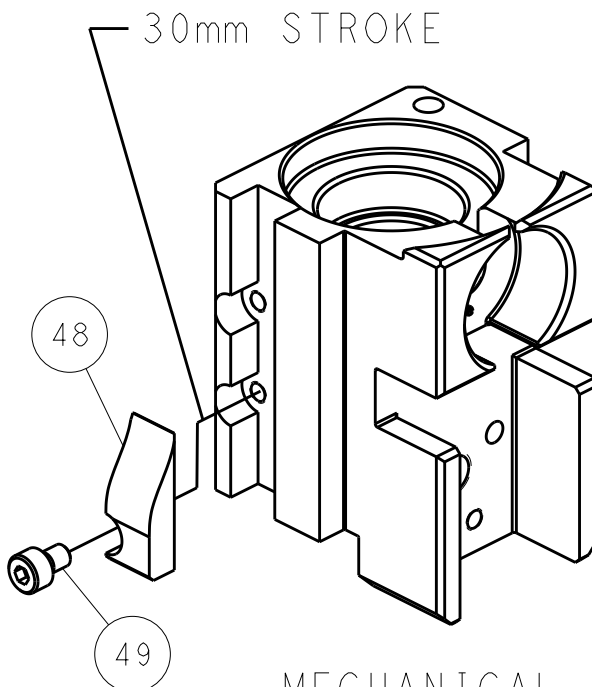


DETAIL A

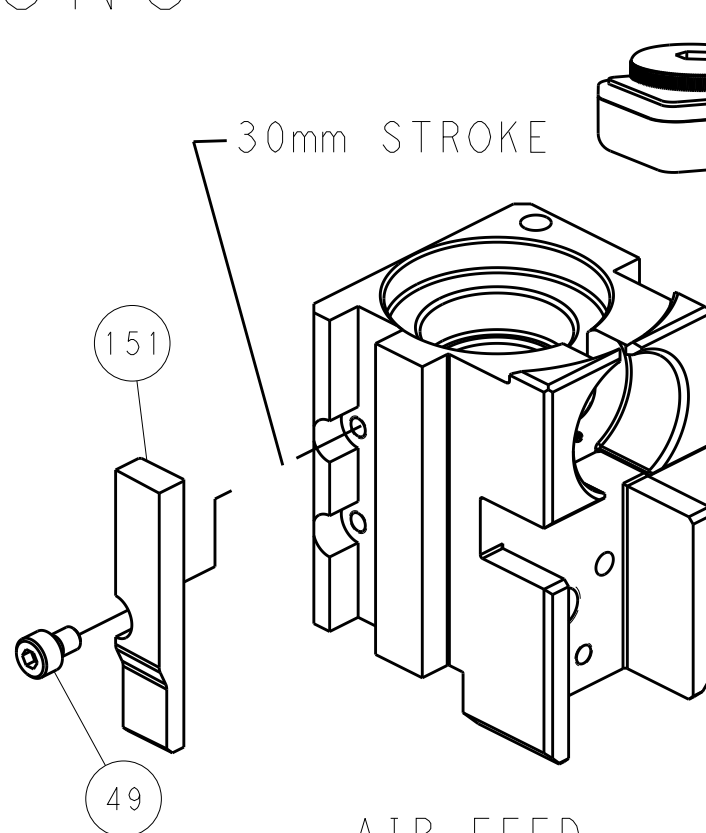
CAM POSITIONS



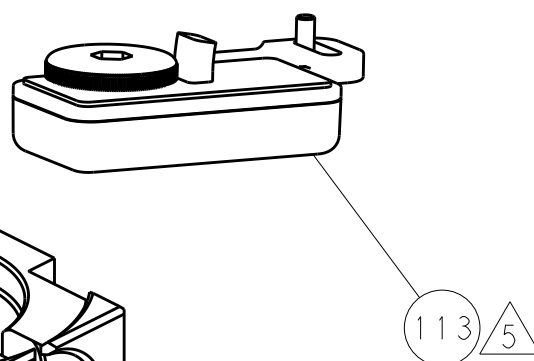
MECHANICAL
POST FEED



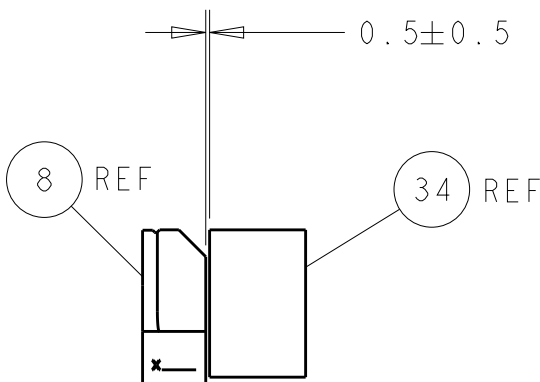
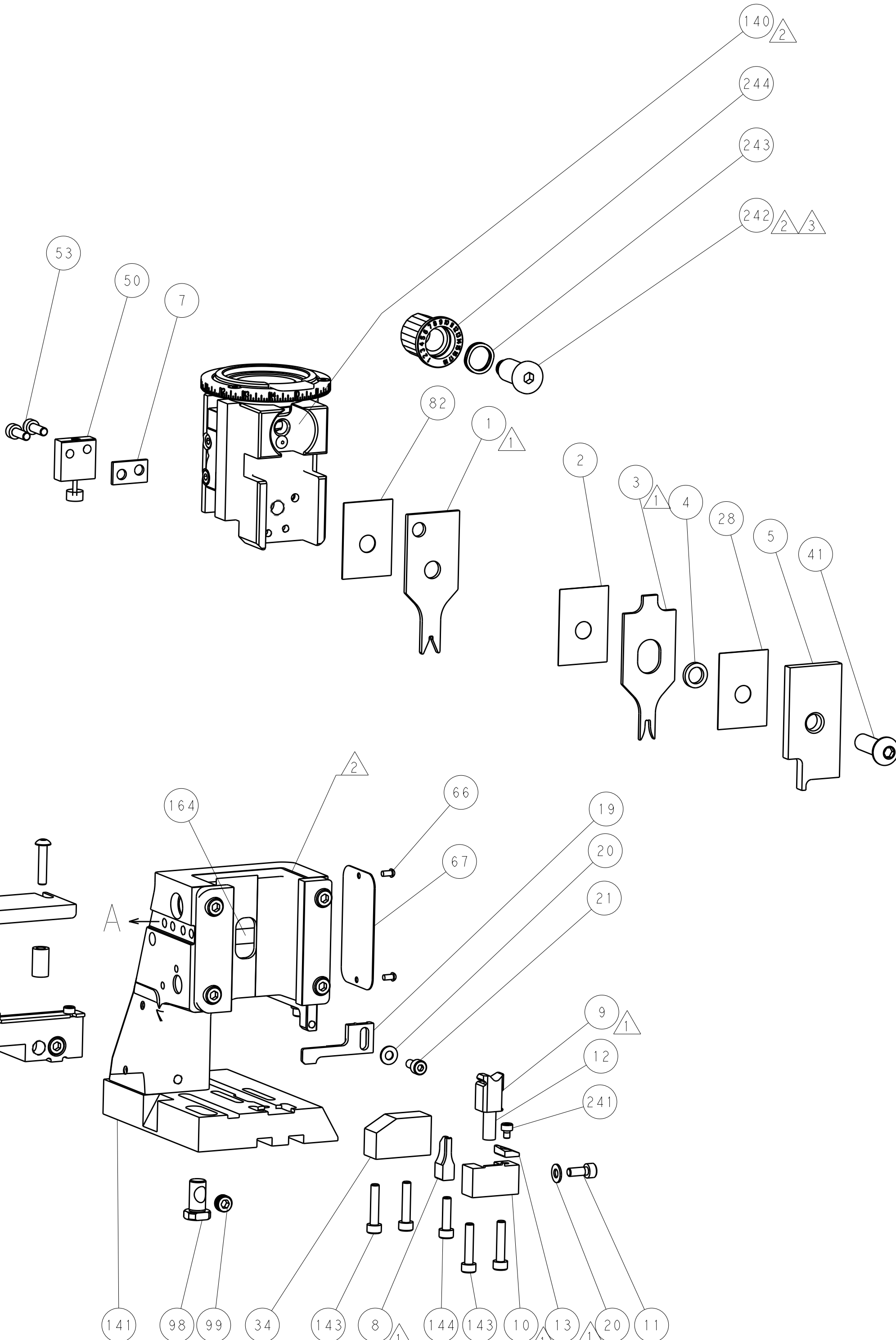
MECHANICAL
PRE FEED



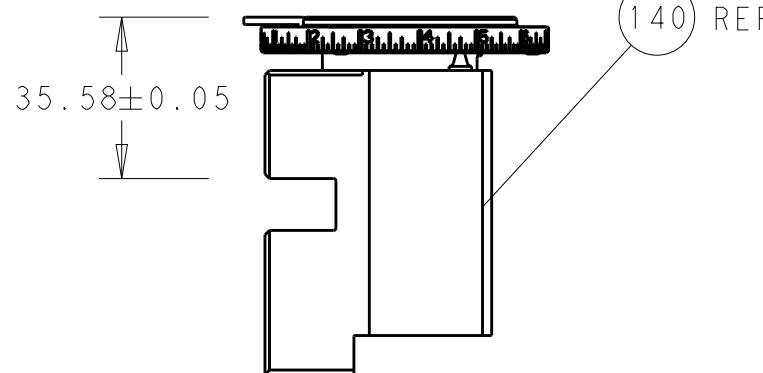
AIR FEED



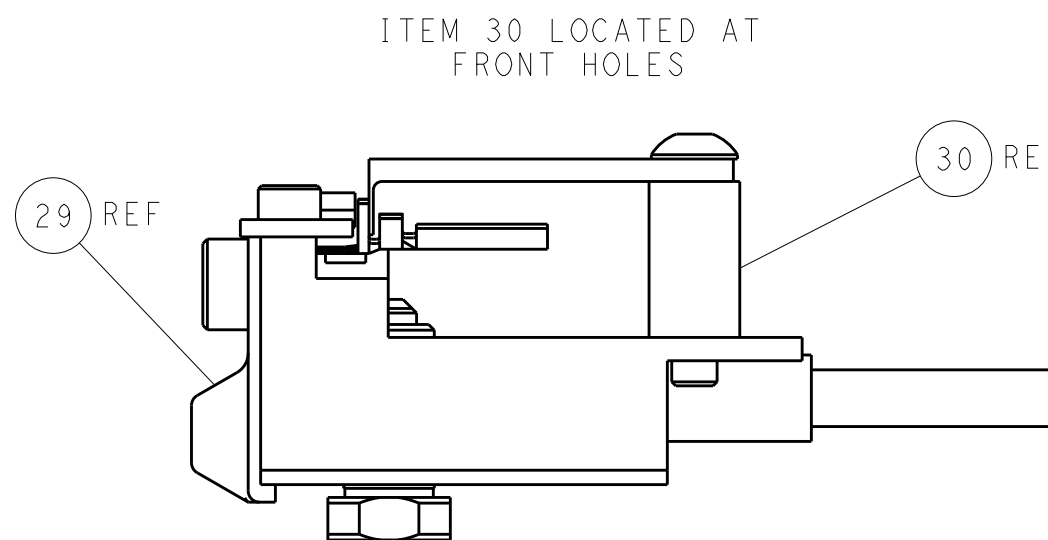
PACIFIC VERSION
Shown on sheets 3 of 4 & 4 of 4
(Atlantic version shown on sheets 1 of 4 & 2 of 4)



TERMINAL SUPPORT LOCATION



RAM SET-UP



FEED TRACK POSITION
GUIDE BY INSULATION BARREL

THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. ANY CHANGES TO THIS DRAWING SHOULD BE CONTACTED FOR THE LATEST REVISION.				DWN C. MOYER 03NOV2011				STE TE Connectivity Harrisburg, PA 17105-3608			
CHK G. BAILEY 03NOV2011				NAME				Ocean Side Feed Applicator			
APVD G. BAILEY 03NOV2011				PRODUCT SPEC				SIZE			
				APPLICATION SPEC				CAGE CODE			
				WEIGHT				DRAWING NO			
				Customer Accessible Production Drawing				RESTRICTED TO			
				SCALE				SHEET			
				1:2				4			
								REV			
								H			

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION