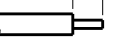


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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151087-1	H	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2151087-2	H	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
5-2151087-1	H	SEAL STRIPPER CRIMPER TERMINATING UNIT	MECHANICAL
5-2151087-2	H	SEAL STRIPPER CRIMPER TERMINATING UNIT	PNEUMATIC
7-2151087-1	H	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2151087-2	H	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2151087-7	E	CRIMP TOOLING KIT	-

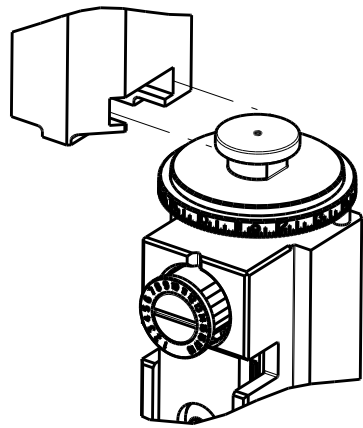
APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.78 mm [.070]	F
INSUL	3.30 mm [.130]	F
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: AMP UNIVERSAL POWER CONNECTOR TAB CONTACT			
WIRE STRIP LENGTH 2.70-3.70 mm [1.06-.146 IN] 		INSULATION DIAMETER RANGE Ø1.70-3.30 mm [0.067-.130 IN]	
TERMINAL APPLICATION SPECIFICATION 	(A)114-5142	-	-
TERMINALS APPLIED 			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
(A)175150-1	(A)175150-2	(A)175152-1	(A)175152-2
(A)175152-4			

WIRE SIZE			CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING 
16 AWG OR 1.27mm2			1.25+/- 0.05 [.049+/- .002]		4.4
0.50mm2+0.75mm2			1.25+/- 0.05 [.049+/- .002]		4.4
18 AWG OR 0.89mm2			1.25+/- 0.05 [.049+/- .002]		4.4
20 AWG OR 0.50mm2			1.06+/- 0.05 [.042+/- .002]		6.2

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: AMP UNIVERSAL POWER CONNECTOR TAB CONTACT			
WIRE STRIP LENGTH 2.70-3.70 mm [.106-.146 IN]			INSULATION DIAMETER RANGE Ø2.00-3.30 mm [.079-.130 IN]
TERMINAL APPLICATION 	(A)114-5142	-	-
SPECIFICATION	(B)114-5147	-	-
TERMINALS APPLIED 			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
(B) 176758-1			

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING
16 AWG OR 1.27mm2		1.25+/-0.05 [0.049+/-0.002]		4.4
18 AWG OR 0.89mm2		1.25+/-0.05 [0.049+/-0.002]		4.4
20 AWG OR 0.50mm2		1.06+/-0.05 [0.042+/-0.002]		6.2



LOC	DIST	REVISIONS						
A	66	P	LTR	DESCRIPTION	DATE	DRN	APVD	
			F	ECR-16-012048	22AUG2016	MR	JDG	
			G	ECR-16-017368	08DEC2016	YY	JDG	
			H	ECR-18-008649	01JUN2018	JAH	TE	
			HI	ECR-19-005384	03APR2019	MZ	YY	

	-	-	-	1	-	-	-	1803515-3	RAM ASSEMBLY, SF ATLANTIC	293
	-	-	-	1	1	-	-	2-1803583-1	APPLICATOR BASIC ASSEMBLY, SF	292
	-	1	-	1	-	1	-	2119640-1	PUSH ROD, AIR FEED	250
	-	1	-	1	-	1	-	1803259-1	BUSHING, FLANGED	249
	-	1	-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248
	-	1	1	1	1	1	1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244
	-	1	1	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
3	-	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	-	2063440-1	AIR FEED MODULE	238
	-	-	-	1	1	-	-	4-1722335-3	STRIPPER, SIDE FEED	182
3	-	-	-	1	1	-	-	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	181
	-	-	-	1	1	-	-	1-1752354-7	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
	-	2	-	2	-	2	-	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172
	-	REF	REF	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
	-	1	-	1	-	1	-	240638-1	SPRING, FEED FINGER	163
	-	1	-	1	-	1	-	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854	137
6	-	1	-	1	-	1	-	2119799-1	HOLDER,FEED FINGER, AF	136
	-	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	1803607-1	DOCUMENTATION PACKAGE	71
	-	1	1	1	1	1	1	2119791-6	DEPRESSOR, WIRE	70
	-	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	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	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	1752356-6	SUPPORT, TERMINAL	34
	-	2	2	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
	-	2	2	2	2	2	2	3-2844962-0	SPACER, CYLINDRICAL, STRIP GUIDE	30
	-	1	1	1	1	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29
	-	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	1	2119806-1	INSERT, SHEAR	13
	-	1	1	1	1	1	1	3-22280-3	SPRING, COMPRESSION	12
	-	1	1	1	1	1	1	1-356885-4	STOP, SHEAR	11
	-	1	1	1	1	1	1	2119805-1	SHEAR HOLDER, FRONT	10
	-	1	1	1	1	1	1	1803095-3	FLOATING SHEAR, FRONT -	9
1	1	2	2	1	1	1	1	4-1333203-7	ANVIL, COMBINATION	8
	-	1	1	1	1	1	1	1-2119757-2	DEPRESSOR, SHEAR	5
	-	1	1	1	1	1	1	238011-7	BLOCK, CRIMPER SPACER	4
1	1	2	2	1	1	1	1	1803260-1	CRIMPER, INSULATION F PREMIUM	3
	-	1	1	1	1	1	1	455888-8	SPACER, CRIMPER	2
1	1	2	2	1	1	1	1	3-456404-6	CRIMPER, WIRE PREMIUM	1

-77 -72 -71 -52 -51 -2 -1				PART NO		DESCRIPTION				ITEM NO	
THIS DRAWING IS A CONTROL DOCUMENT FOR TWO ELECTRONICS CORPORATION IT IS SUBJECT TO THE DESIGN AND MANUFACTURING ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST REVISION.						OWN C HUANG		01SEP2011		 TE Connectivity Harrisburg, PA 17105-3608	
						CHK -					
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:				APVD S X1		01SEP2011		NAME	
mm						PRODUCT SPEC				Ocean Side Feed	
		1 PLC ±				-				Applicator	
		1 PLC ±				-					
		3 PLC ±				-					
		4 PLC ±				-					
		ANGLES ±				APPLICATION SPEC					
MATERIAL		FINISH				WEIGHT		-		SIZE	
-		-				-		A		00779	
								C=2151087		DRAWING NO	
Customer Accessible						Production Drawing					
						SCALE		1:2		SHEET 1 of 4	
										REV H	

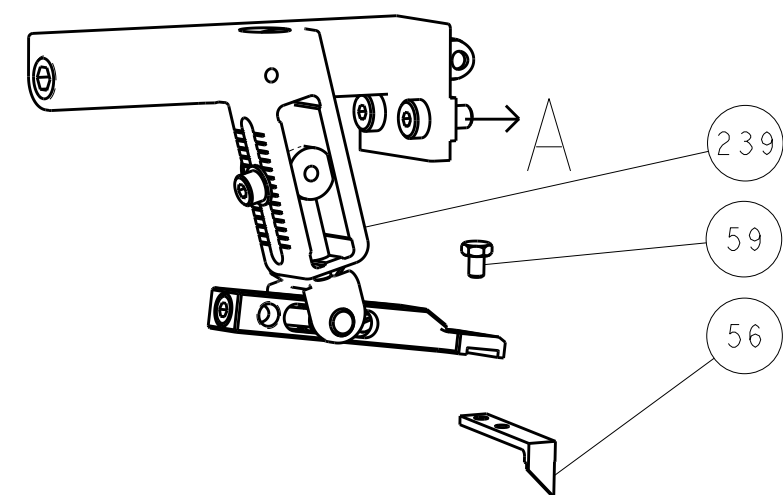
13 THIS APPLICATOR APPLIES TERMINAL WITH A SEAL.

14 APPLY TORO-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.

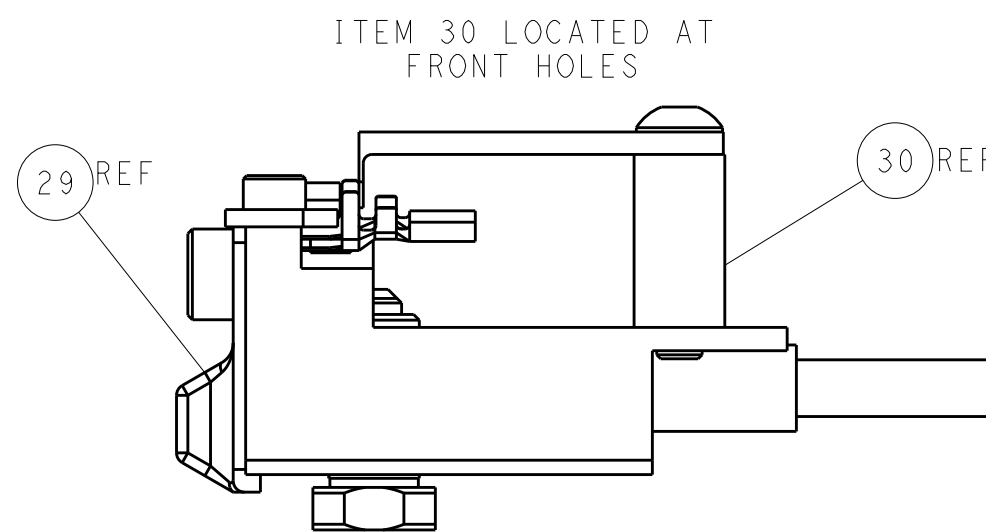
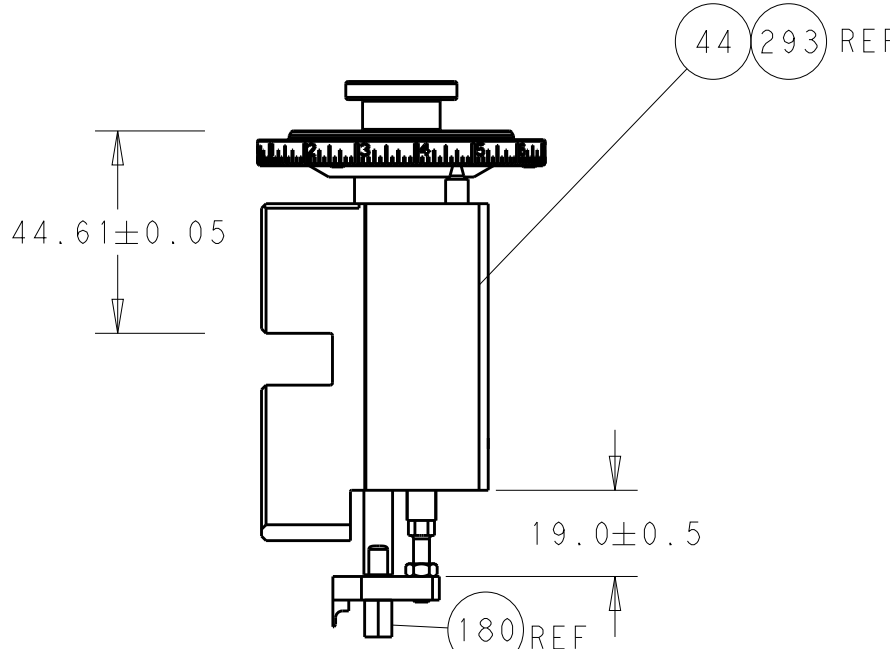
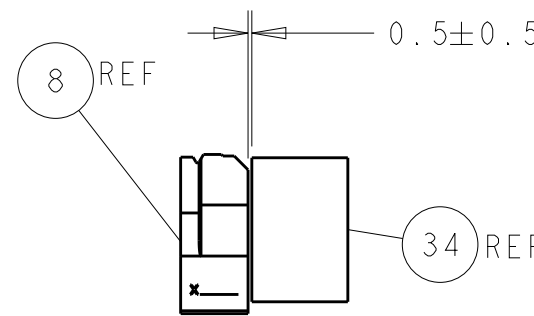
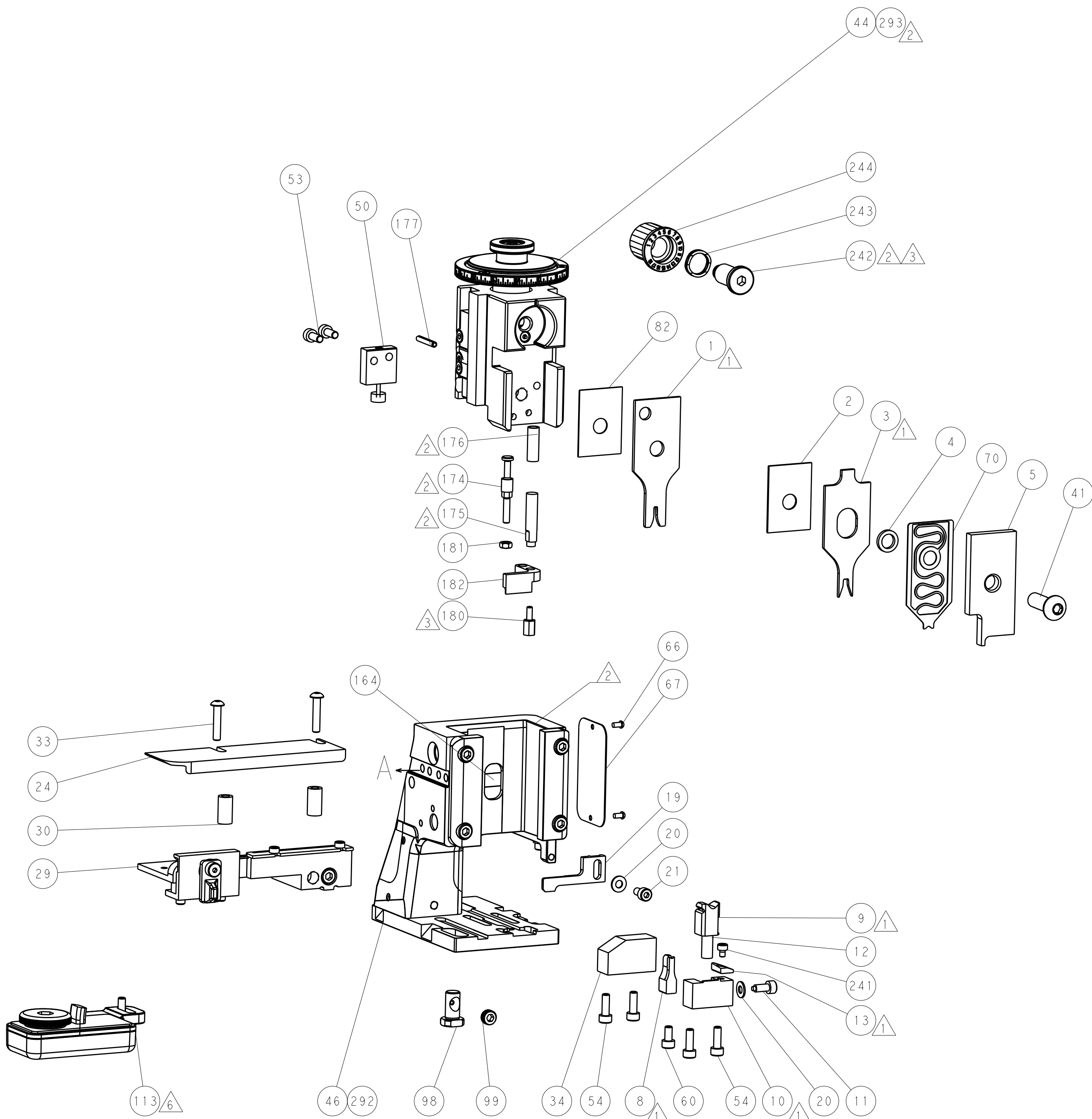
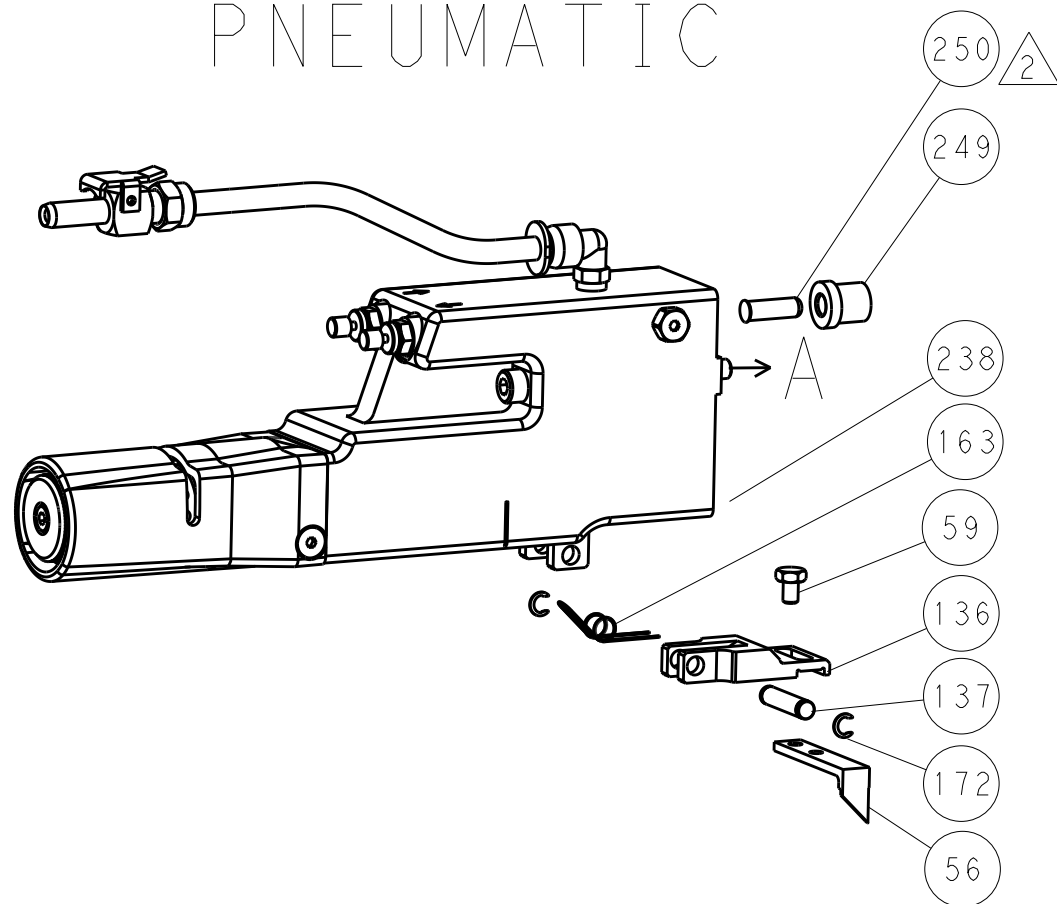
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

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

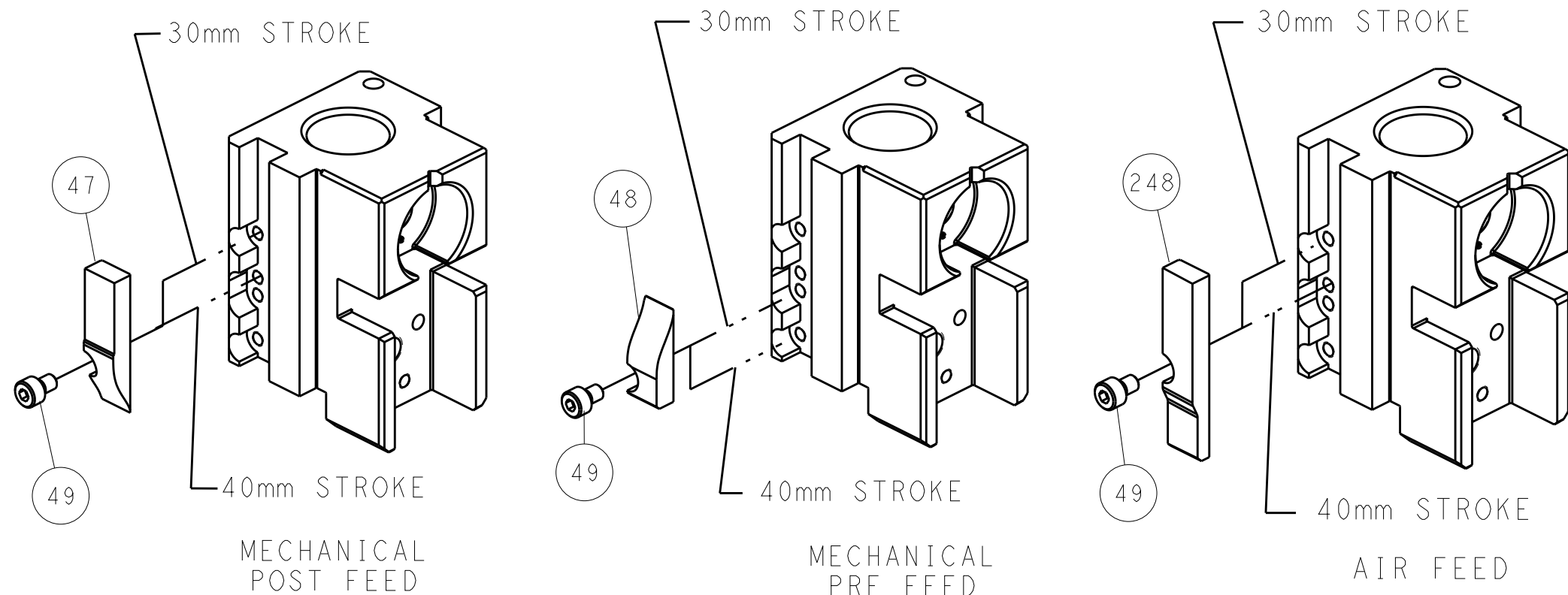
FEED TYPE
MECHANICAL



PNEUMATIC



CAM POSITIONS

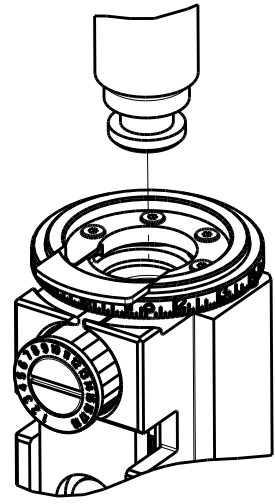


ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

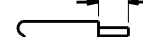
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN		01SEP2011		TE Connectivity	
mm		0 PLC ±		CHK		K. HUANG		Harrisburg, PA 17105-3608	
		1 PLC ±		APVD		S. XI		NAME	
		2 PLC ±		PRODUCT SPEC		01SEP2011		Ocean Side Feed	
		3 PLC ±		APPLICATION SPEC				Applicator	
		4 PLC ±		WEIGHT		-		-	
MATERIAL		FINISH		Customer Accessible Production Drawing		SCALE		1:2	
						SHEET		2 of 4	
						REV		H1	

8		7	
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20		20	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2151087-1	H	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2151087-2	H	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151087-7	E	CRIMP TOOLING KIT	-

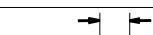
PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.78 mm [.070]	F
INSUL	3.30 mm [.130]	F
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: AMP UNIVERSAL POWER CONNECTOR TAB CONTACT			
WIRE STRIP LENGTH			INSULATION DIAMETER RANGE
2.70-3.70 mm [.106-.146 IN]			Ø1.70-3.30 mm [.067-.130 IN]
TERMINAL APPLICATION SPECIFICATION		(A)114-5142	-
		-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
(A)175150-1	(A)175150-2	(A)175152-1	(A)175152-2
(A)175152-4			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
16 AWG OR 1.27mm2	1.25+/-0.05 [.049+/- .002]	4.4
0.50mm2+0.75mm2	1.25+/-0.05 [.049+/- .002]	4.4
18 AWG OR 0.89mm2	1.25+/-0.05 [.049+/- .002]	4.4
20 AWG OR 0.50mm2	1.06+/-0.05 [.042+/- .002]	6.2

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: AMP UNIVERSAL POWER CONNECTOR TAB CONTACT			
WIRE STRIP LENGTH			INSULATION DIAMETER RANGE
2.70-3.70 mm [.106-.146 IN]			Ø2.00-3.30 mm [.079-.130 IN]
TERMINAL APPLICATION SPECIFICATION	(A)114-5142	-	-
	(B)114-5147	-	-
TERMINALS APPLIED 			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
(B) 176758-1			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
16 AWG OR 1.27mm2	1.25+/-0.05 [.049+/- .002]	4.4
18 AWG OR 0.89mm2	1.25+/-0.05 [.049+/- .002]	4.4
20 AWG OR 0.50mm2	1.06+/-0.05 [.042+/- .002]	6.2



- 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.
- 3 COMBINED INSULATION DIAMETER 3.30mm MAX.
- 6 TERMINAL LUBRICANT IS RECOMMENDED.

7. 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	LTR	DESCRIPTION	DATE	DWN	APVD
A	66	-		SEE SHEET 1	-	-	-

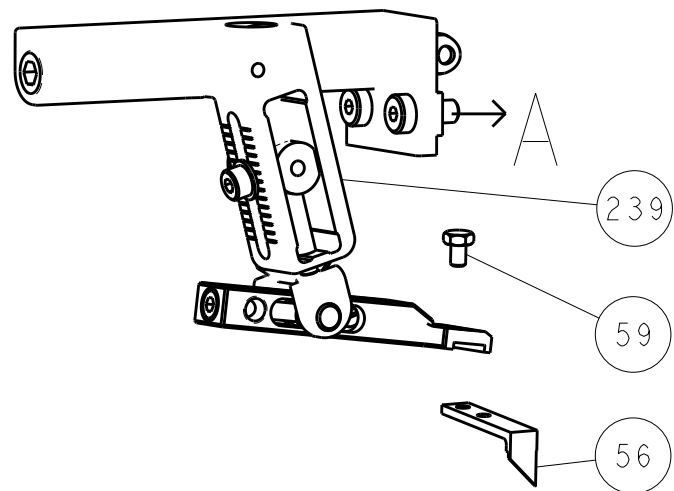
3	-	1	-	2119640-1	PUSH ROD, AIR FEED	250
	-	1	-	1803259-1	BUSHING, FLANGED	249
	-	1	1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244
	-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
	-	1	1	2119083-1	RETAINER, INSULATION DIAL	242
	-	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
	-	-	1	2119580-1	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
6	-	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	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	1803607-1	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	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	1752356-6	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	2844992-1	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	
-	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	1	3-22280-3	SPRING, COMPRESSION	12
-	1	1	1	1-356885-4	STOP, SHEAR	11
1	-	1	1	2119805-1	SHEAR HOLDER, FRONT	10
1	-	1	1	1803095-3	FLOATING SHEAR, FRONT	9
1	1	1	1	4-1333203-7	ANVIL, COMBINATION	8
-	1	1	1	1-2119757-2	DEPRESSOR, SHEAR	5
-	1	1	1	238011-7	BLOCK, CRIMPER SPACER	4
1	1	1	1	1803260-1	CRIMPER, INSULATION F PREMIUM	3
-	1	1	1	455888-8	SPACER, CRIMPER	2
1	1	1	1	3-456404-6	CRIMPER, WIRE PREMIUM	1

-77	-22	-21	PART NO	DESCRIPTION	ITEM NO
			DWN R. HUANG	01SEP2011	
			CHK -		
			APVD S. XI	01SEP2011	
			PRODUCT SPEC		
			APPLICATION SPEC		
			WEIGHT		
			Customer Accessible Production Drawing	SCALE 1:2	SHEET 3 OF 4

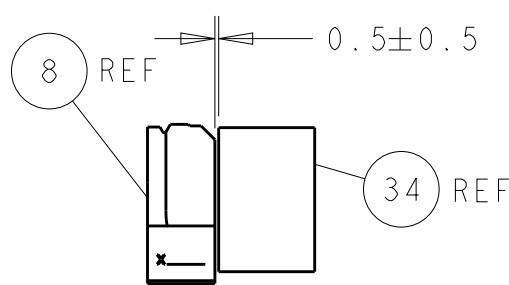
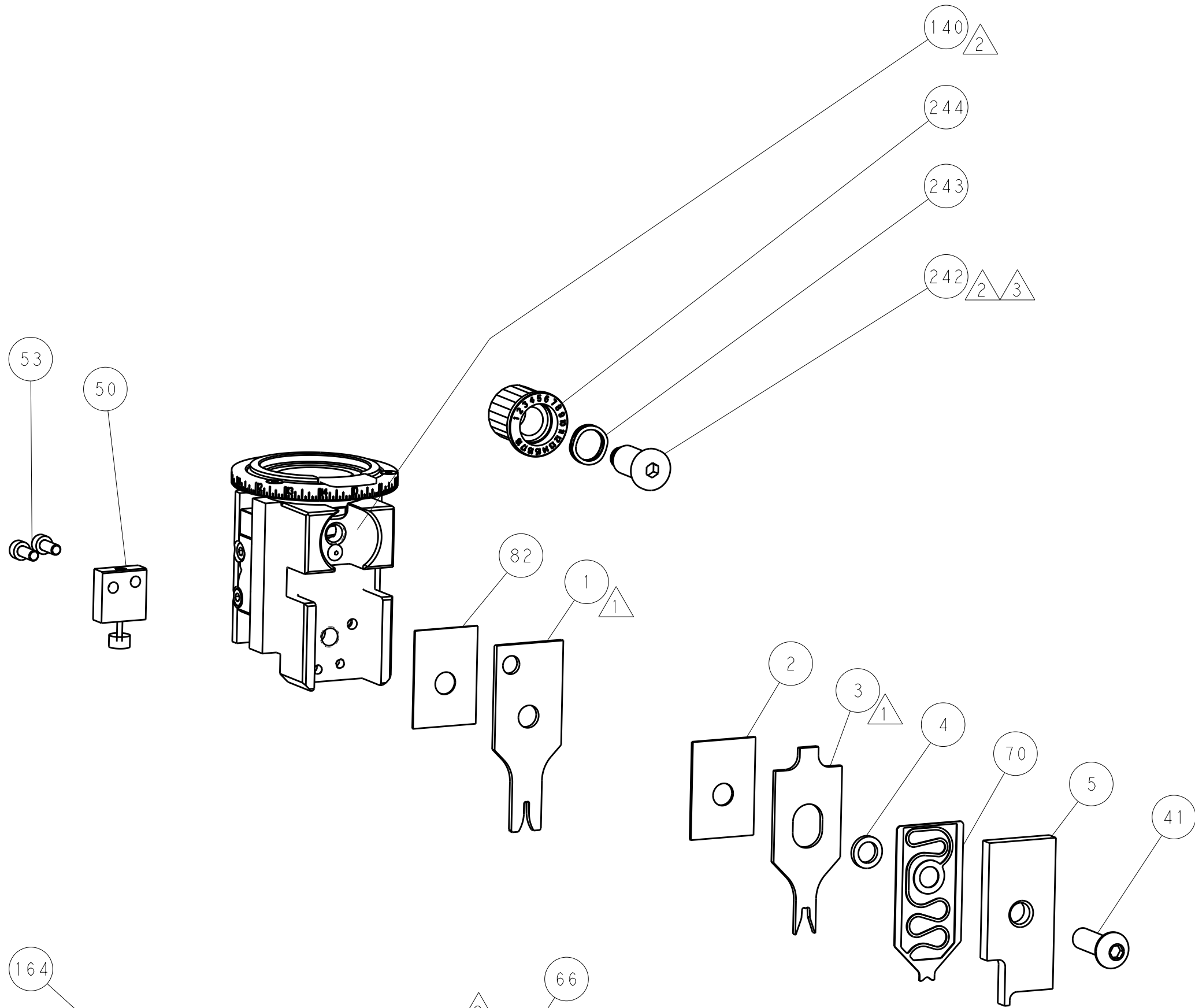
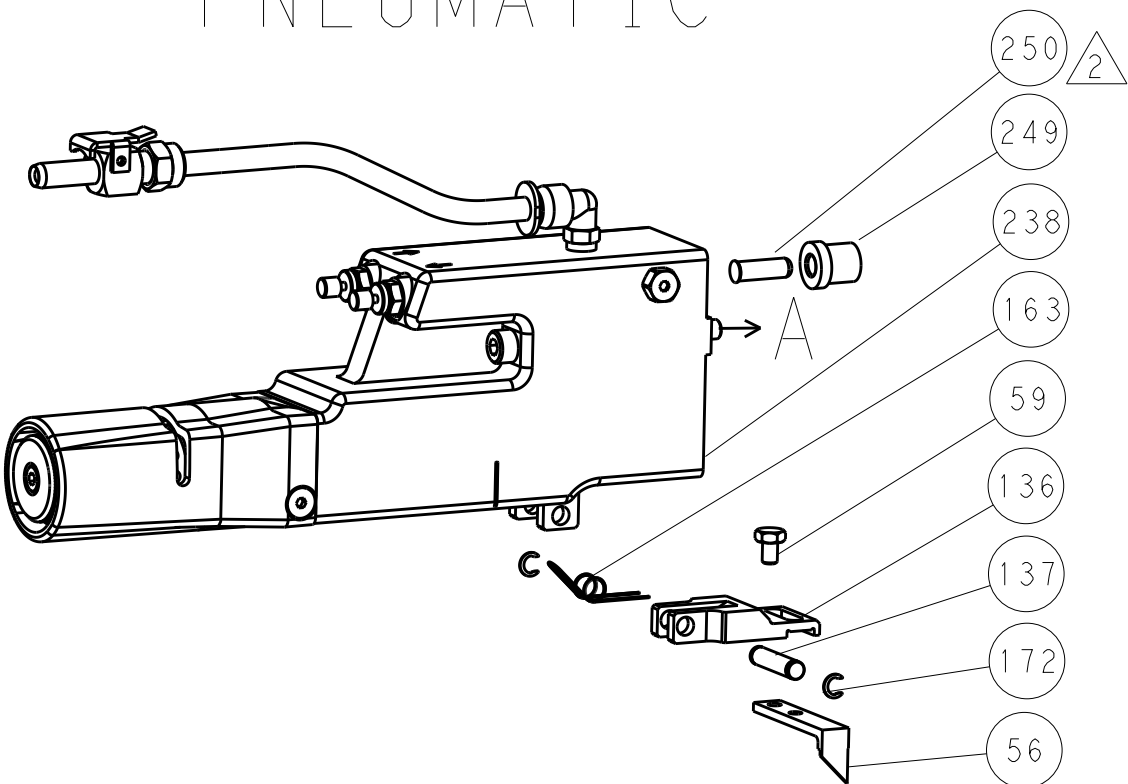
SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

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

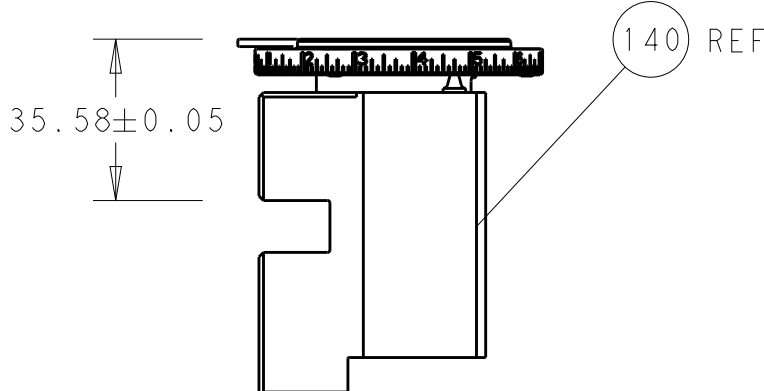
FEED TYPE
MECHANICAL



PNEUMATIC

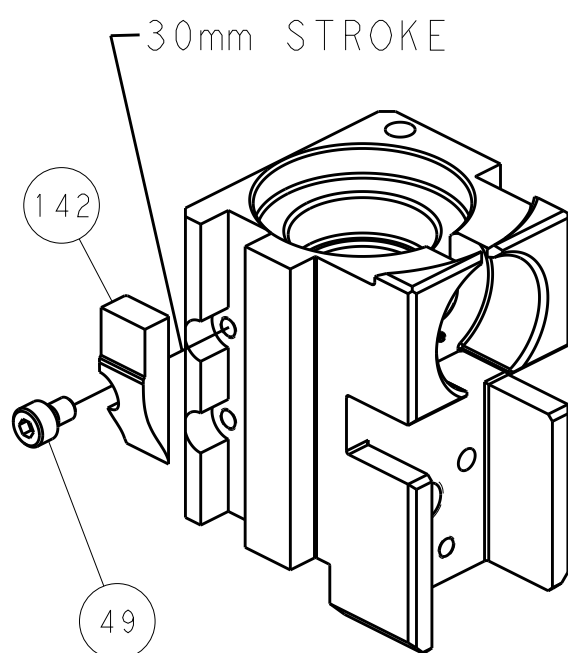


TERMINAL SUPPORT LOCATION

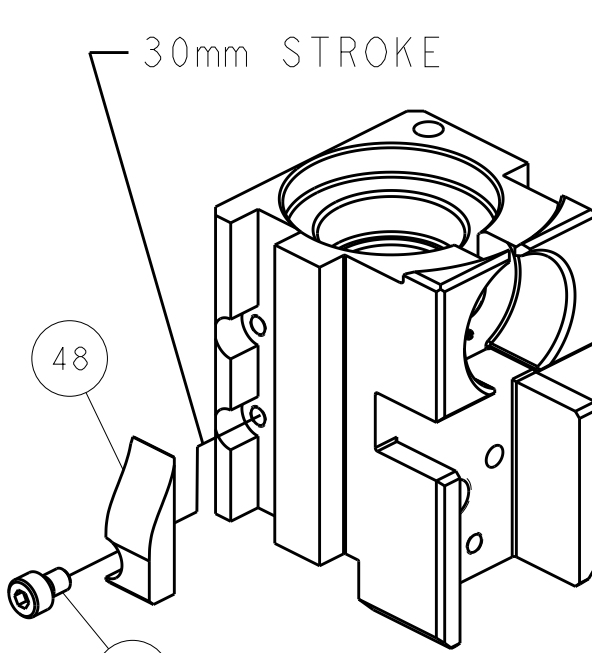


RAM SET-UP

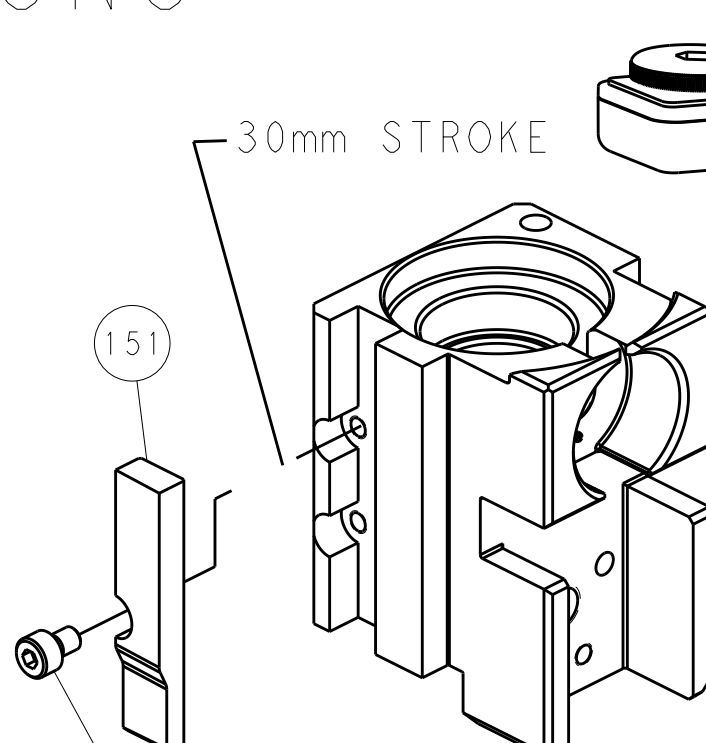
CAM POSITIONS



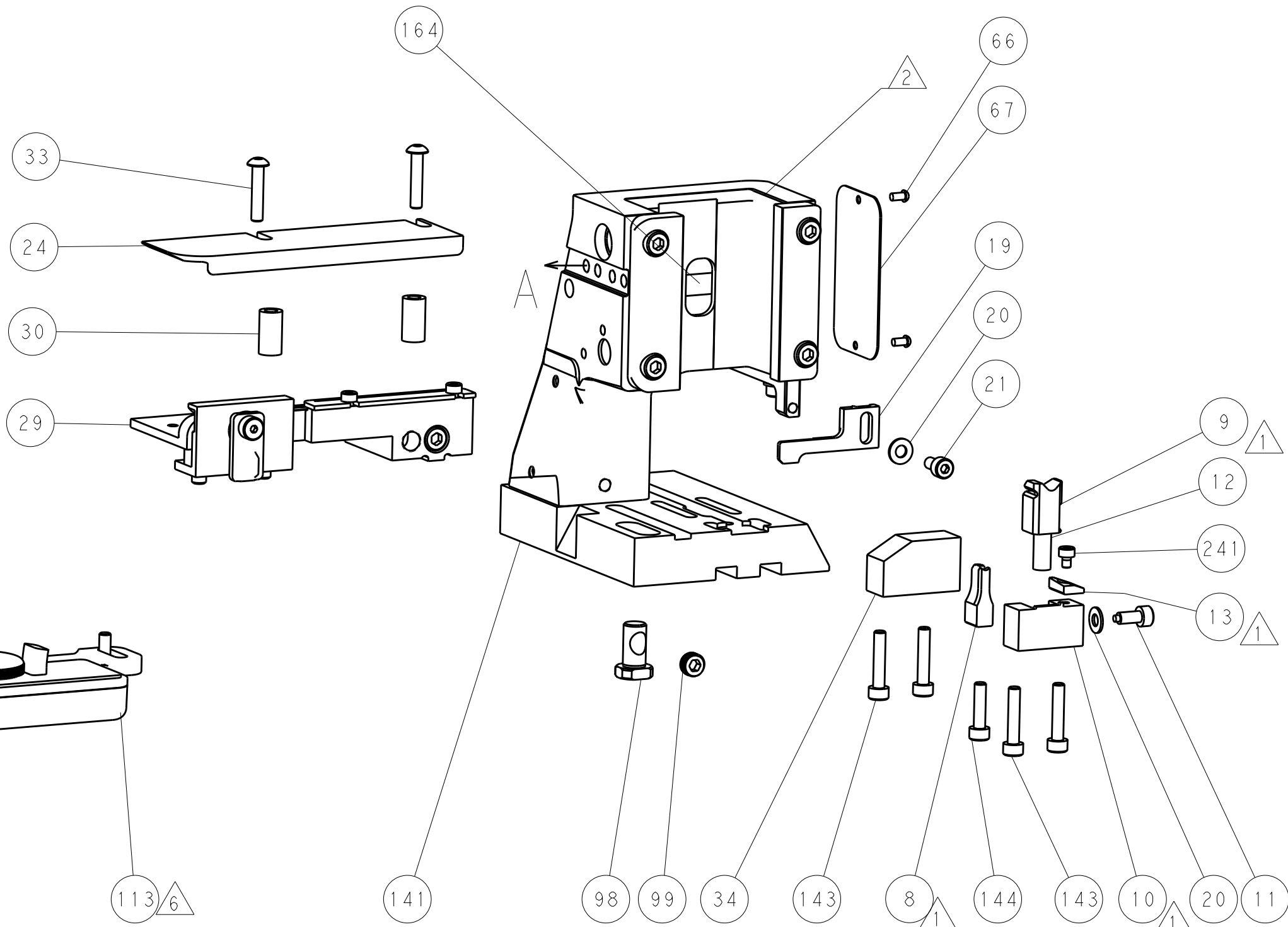
MECHANICAL
POST FEED



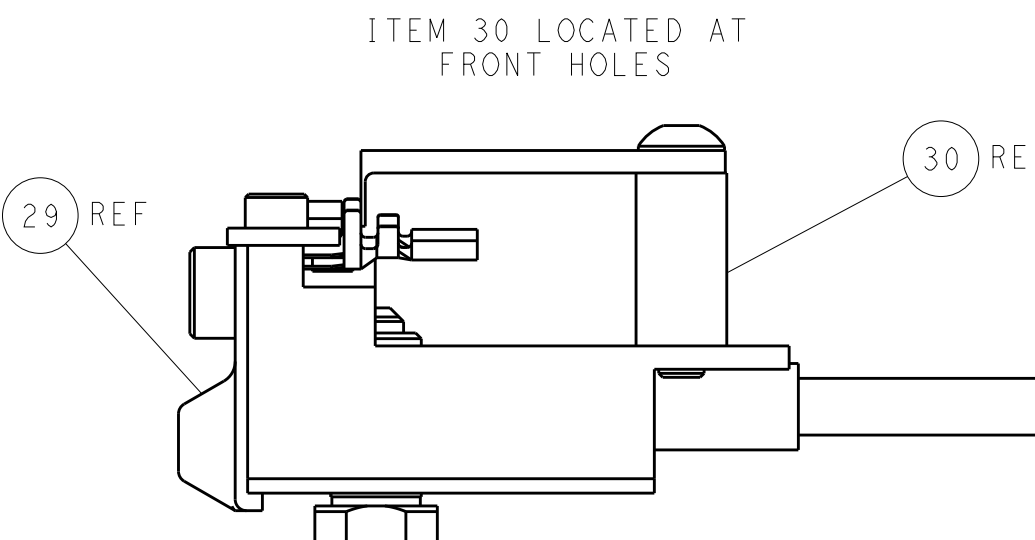
MECHANICAL
PRE FEED



AIR FEED



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



FEED TRACK POSITION
GUIDE BY INSULATION BARREL

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DIMENSIONS:				CHK: S. XI 01SEP2011				NAME: Ocean Side Feed Applicator			
mm				APVD: S. XI 01SEP2011				SIZE: CAGE CODE: DRAWING NO: 00779 C=2151087			
TOLERANCES UNLESS OTHERWISE SPECIFIED:				PRODUCT SPEC				RESTRICTED TO			
0 PLC ±				APPLICATION SPEC				Customer Accessible Production Drawing			
1 PLC ±				WEIGHT				SCALE: 1:2			
2 PLC ±				FINISH				SHEET 4 OF 4			
3 PLC ±				ANGLES				REV: H1			
4 PLC ±				MATERIAL							