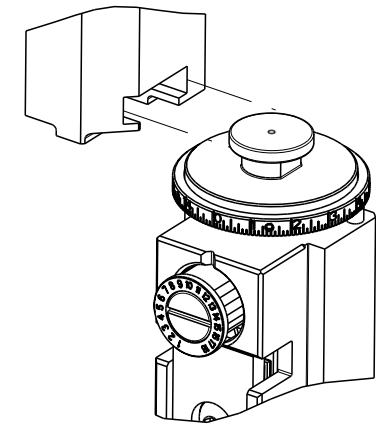


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151269-1	E	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2151269-2	E	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
3-2151269-2	E	FINE CRIMP HEIGHT ADJUST	DOUBLE ACTING PNEUMATIC WITH SENSORS
5-2151269-1	E	SEAL STRIPPER CRIMPER TERMINATING UNIT	MECHANICAL
5-2151269-2	E	SEAL STRIPPER CRIMPER TERMINATING UNIT	PNEUMATIC
7-2151269-1	E	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2151269-2	E	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2151269-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER

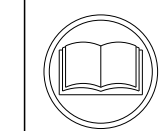


APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.57 mm [.062]	F
INSUL	2.29 mm [.090]	O

APPLICATOR INSTRUCTIONS 408-35042

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: JUNIOR-POWER-TIMER CONTACT			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
3.20-3.80 mm [.126-.150 IN]		Ø1.00-1.60 mm [.039-.063 IN]	
TERMINAL APPLICATION SPECIFICATION	114-18050		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
927774-1	927774-3	927774-6	1-927774-1
2-927774-1			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.50mm2	1.12 +/- 0.03 [.044 +/- .001]	4.6
0.35mm2	1.06 +/- 0.03 [.042 +/- .001]	5.1
0.25mm2	1.00 +/- 0.03 [.039 +/- .001]	5.8
0.20mm2	0.98 +/- 0.03 [.039 +/- .001]	6.0



- 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 THIS APPLICATOR IS EQUIPPED WITH THE DOUBLE ACTING FEED WITH SENSORS AND IS APPLICATION SPECIFIC. IT DOES NOT REQUIRE ITEMS 49 & 248.

**\*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					
A	66	#	LYR	DESCRIPTION	DATE	OWN	APVD
		C		ECR-18-006565	28APR2018	KH	JDG
		C1		ECR-19-005750	09APR2019	MEH	CT
		D		ECR-19-009013	09JUN2019	TB	TE
		E		ECR-19-015301	30SEP2019	JAH	TE

-	-	-	1	1	-	-	-	1803515-3	RAM ASSEMBLY, SF ATLANTIC	293	
-	-	-	1	1	-	-	-	2-1803583-1	APPLICATOR BASIC ASSEMBLY, SF	292	
-	-	-	-	-	1	-	-	2844950-1	AIR FEED MODULE	290	
6	-	1	-	1	-	-	1	2119641-1	FEED CAM, AIR FEED	248	
-	1	1	1	1	1	1	1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244	
-	1	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	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	
3	-	-	-	1	1	-	-	1-1752354-6	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	REF	994970-2	COUNTER, MAGNETIC	164	
-	1	1	1	1	1	1	1	2844908-1	SCREW, LOCKING	99	
-	1	1	1	1	1	1	1	2844907-1	POST, LOCKING	98	
-	1	1	1	1	1	1	1	455888-5	SPACER, CRIMPER	82	
-	1	1	1	1	1	1	1	1803607-3	DOCUMENTATION PACKAGE	71	
-	1	1	1	1	1	1	1	2119791-5	DEPRESSOR, WIRE	70	
-	1	1	1	1	1	1	1	2119740-1	TAG,IDENTIFICATION	67	
-	2	2	2	2	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66	
-	1	1	1	1	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	60	
-	1	1	1	1	1	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59	
-	1	1	1	1	1	1	1	1338685-1	PAWL, FEED	56	
-	4	4	4	4	4	4	4	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	54	
-	2	2	2	2	2	2	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	53	
-	1	1	1	1	1	1	1	1803382-2	HOLD DOWN, SPRING LOADED	50	
6	-	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	1	1803583-9	APPLICATOR BASIC ASSEMBLY, SF	46	
-	1	1	-	-	1	1	1	1803515-1	RAM ASSEMBLY, SF ATLANTIC	44	
-	1	1	1	1	1	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41	
-	1	1	1	1	1	1	1	3-1752356-3	SUPPORT, TERMINAL	34	
-	2	2	2	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33	
-	2	2	2	2	2	2	2	2-2844962-6	SPACER, CYLINDRICAL, STRIP GUIDE	30	
-	1	1	1	1	1	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29	
-	1	1	1	1	1	1	1	1-455888-0	SPACER, CRIMPER	28	
-	1	1	1	1	1	1	1	1320928-2	STRIP GUIDE	24	
-	1	1	-	-	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21	
-	2	2	1	1	2	2	2	1-18028-2	WASHER, FLAT, REG M4	20	
-	1	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	1	3-22280-3	SPRING, COMPRESSION	12	
-	1	1	1	1	1	1	1	1-356885-4	STOP, SHEAR	11	
-	1	1	1	1	1	1	1	2119805-1	SHEAR HOLDER, FRONT	10	
1	-	1	1	1	1	1	1	1803095-6	FLOATING SHEAR, FRONT	9	
1	2	2	1	1	1	1	1	2-1333202-2	ANVIL, COMBINATION	8	
-	1	1	1	1	1	1	1	3-240641-8	SPACER	7	
-	-	-	-	-	-	-	-	-	-	6	
-	1	1	1	1	1	1	1	2119757-8	DEPRESSOR, SHEAR	5	
-	1	1	1	1	1	1	1	238011-9	BLOCK, CRIMPER SPACER	4	
1	2	2	1	1	1	1	1	1-2119784-8	CRIMPER, INSULATION O PREMIUM	3	
-	-	-	-	-	-	-	-	-	-	2	
1	2	2	1	1	1	1	1	9-657555-1	CRIMPER, WIRE PREMIUM	1	
-77	-72	-71	-52	-51	-32	-2	-1	PART NO	DESCRIPTION	ITEM NO	

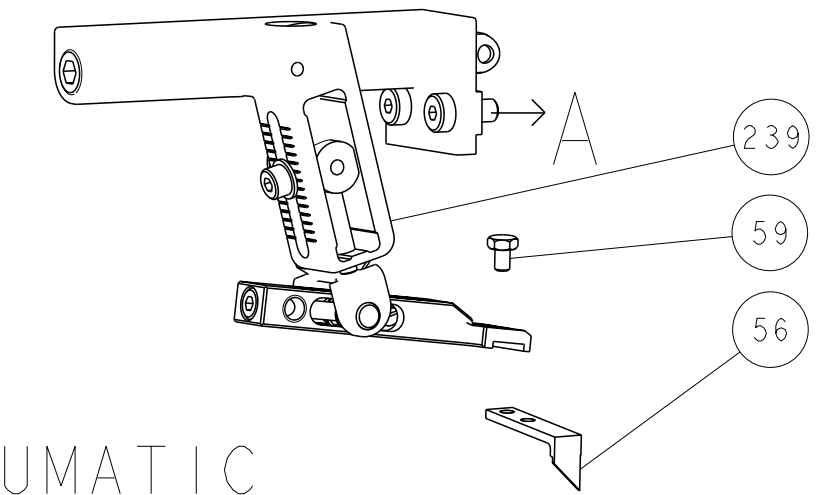
ATLANTIC VERSION  
Shown on sheets 1 of 4 & 2 of 4  
(Pacific version shown on sheets 3 of 4 & 4 of 4)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		OWN		CHK		APVD		NAME	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	Y.YIN	11OCT2012	G.BAILEY	11OCT2012	S.YI	11OCT2012
MATERIAL	FINISH	WEIGHT	SCALE	SHEET	OF	Customer Accessible Production Drawing		SCALE		SHEET 1 OF 4 REV E	

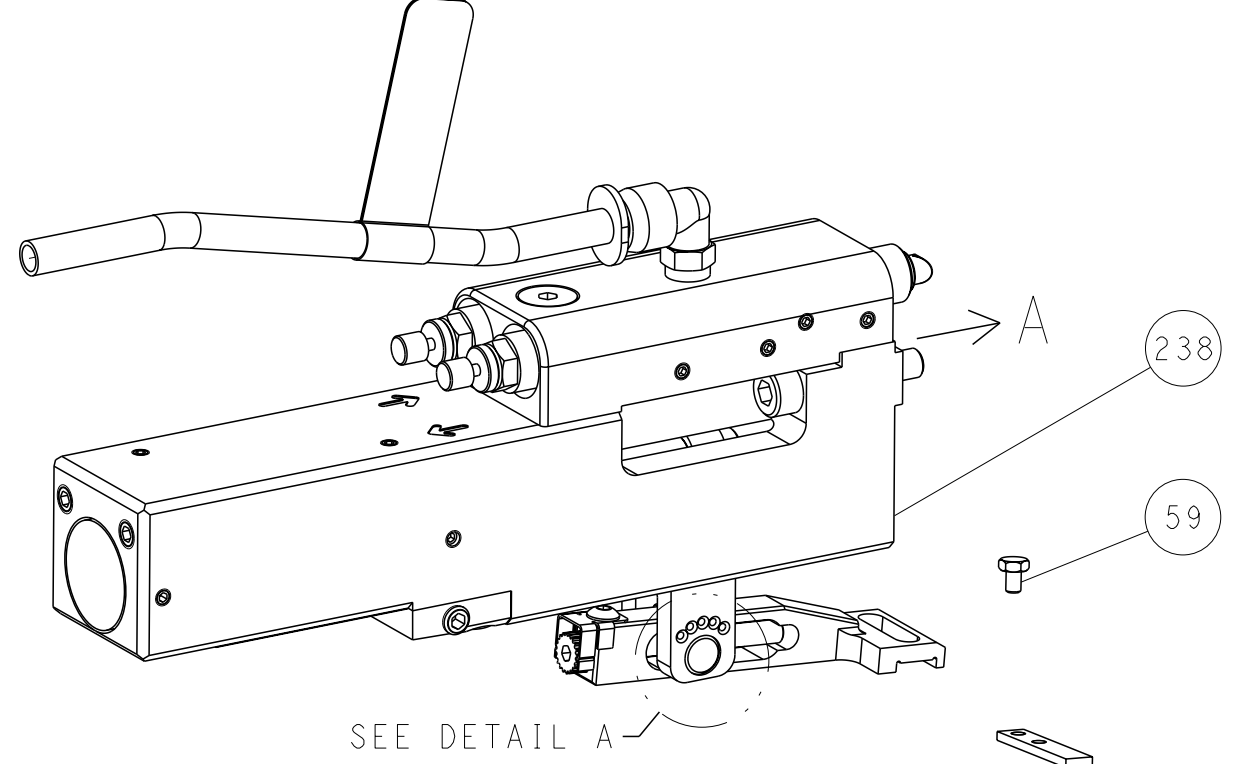
Customer Accessible Production Drawing SCALE 1:2 SHEET 1 OF 4 REV E

REVISONS		DATE	OWN	APVD
P	LYH			
- SEE SHEET 1				

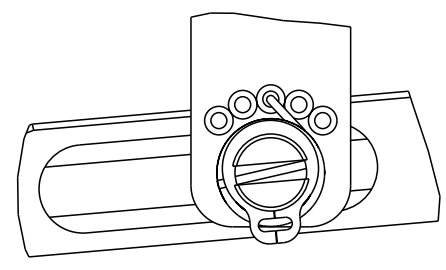
# FEED TYPE MECHANICAL



## PNEUMATIC

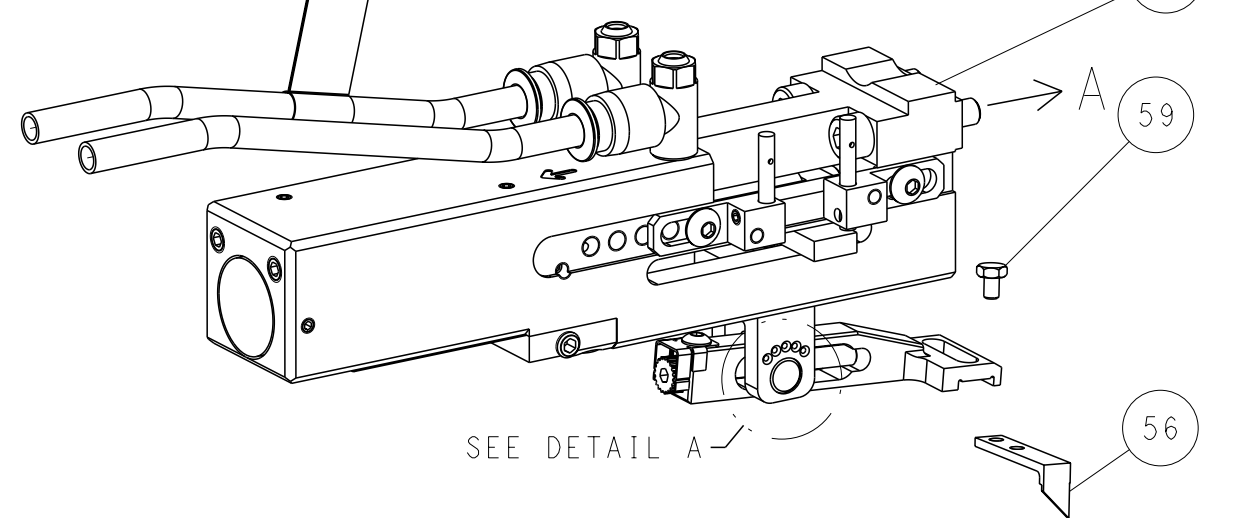


FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



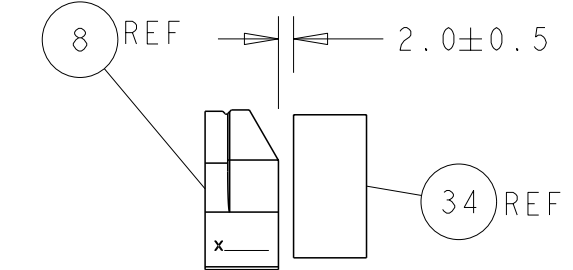
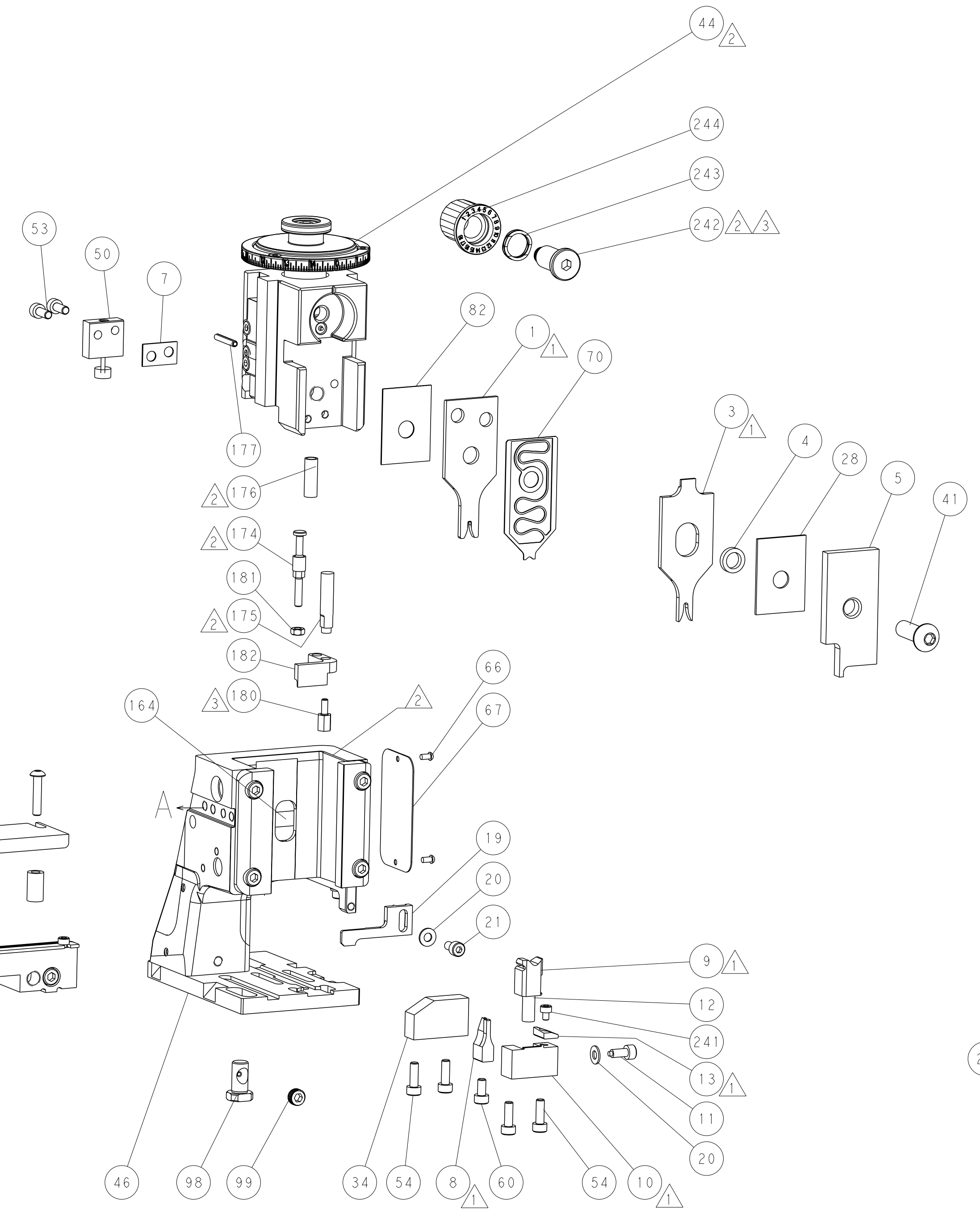
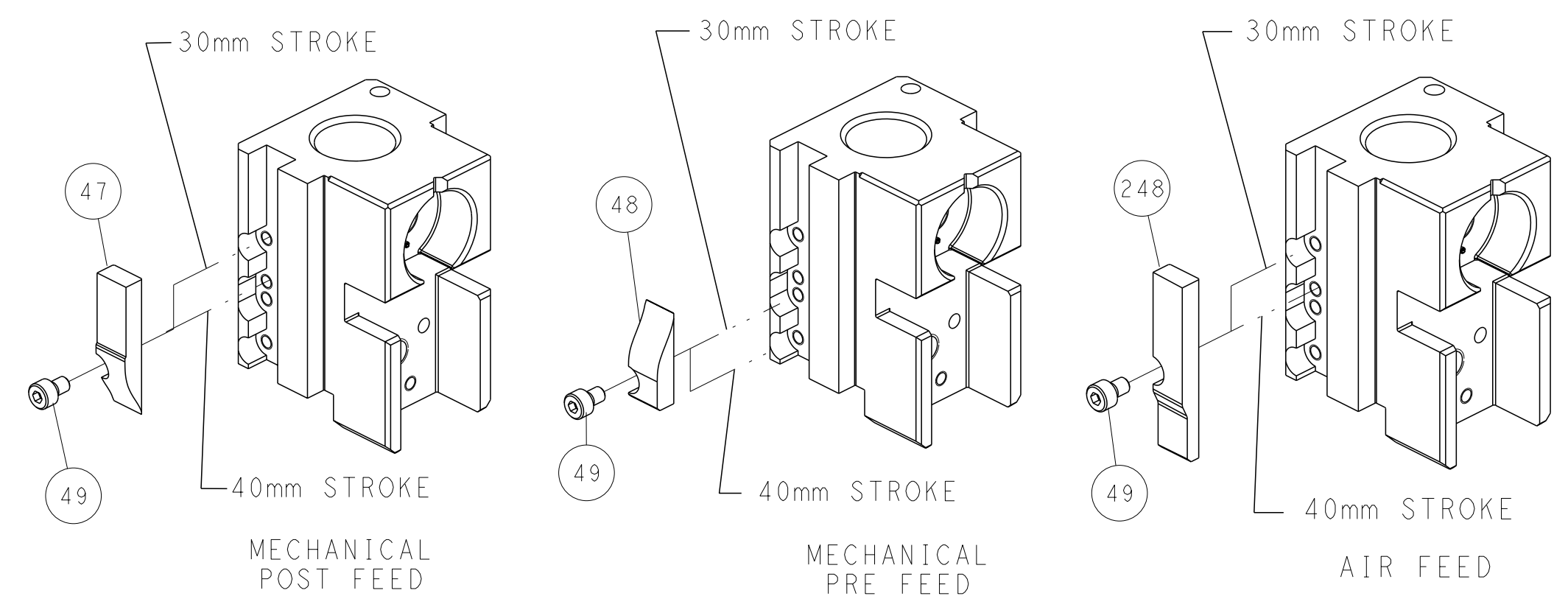
DETAIL A

## DOUBLE ACTING PNEUMATIC WITH SENSORS

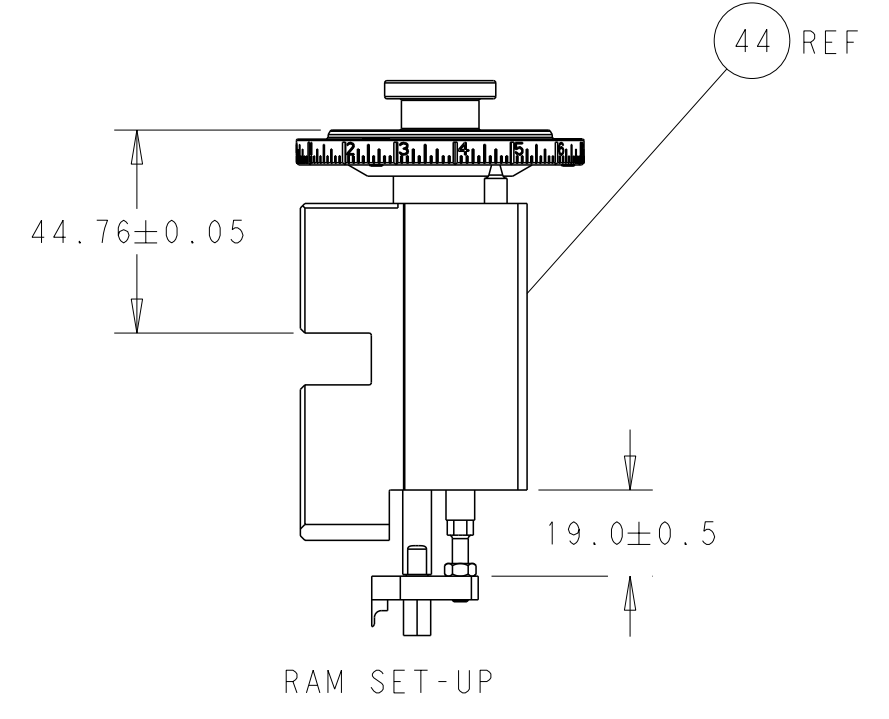


SEE DETAIL A

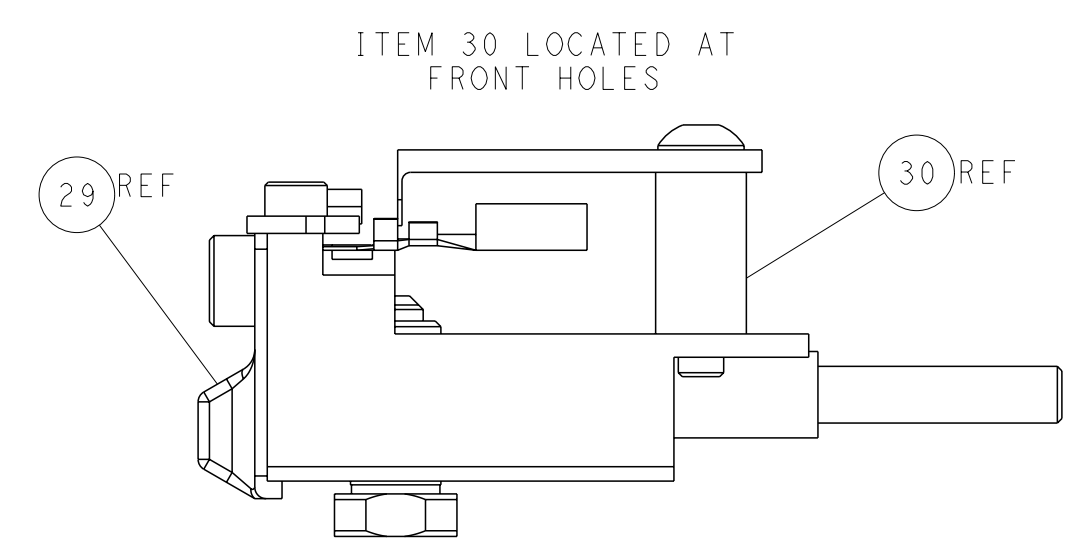
# CAM POSITIONS



TERMINAL SUPPORT LOCATION



RAM SET-UP



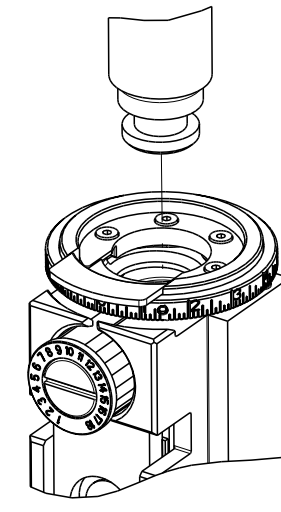
FEED TRACK POSITION GUIDE BY INSULATION BARREL

**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:		OWN: Y. YIN 11OCT2012		TE Connectivity	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	NAME: G. BAILEY 11OCT2012	Harrisburg, PA 17105-3608
	ANGLES	FINISH				PRODUCT SPEC	
MATERIAL:						APPLICATION SPEC	
						WEIGHT	
						Customer Accessible Production Drawing	
SCALE: 1:2		SHEET 2 of 4		REV E		RESTRICTED TO	

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2151269-1	E	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2151269-2	E	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
4-2151269-2	E	FINE CRIMP HEIGHT ADJUST	DOUBLE ACTING PNEUMATIC WITH SENSORS
7-2151269-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.57 mm [.062]	F
INSUL	2.29 mm [.090]	O
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: JUNIOR-POWER-TIMER CONTACT			
WIRE STRIP LENGTH 3.20-3.80 mm [.126-.150 IN]		INSULATION DIAMETER RANGE Ø1.00-1.60 mm [.039-.063 IN]	
TERMINAL APPLICATION SPECIFICATION	114-18050	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
927774-1	927774-3	927774-6	1-927774-1
2-927774-1			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.50mm2	1.12+/-0.03 [.044+/-0.001]	4.6
0.35mm2	1.06+/-0.03 [.042+/-0.001]	5.1
0.25mm2	1.00+/-0.03 [.039+/-0.001]	5.8
0.20mm2	0.98+/-0.03 [.039+/-0.001]	6.0



- 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 UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- 6 THIS APPLICATOR IS EQUIPPED WITH THE DOUBLE ACTING FEED WITH SENSORS AND IS APPLICATION SPECIFIC. IT DOES NOT REQUIRE ITEMS 49 & 151.

**\*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	P	LYR	DESCRIPTION	DATE	OWN	APVD
-	-	-	-	SEE SHEET 1	-	-	-

-	1	-	-	2844950-1	AIR FEED MODULE	290	
-	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	-	2844940-1	AIR FEED MODULE	238	
-	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164	
6	-	-	1	2119641-2	FEED CAM, AIR FEED	151	
-	1	1	1	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	144	
-	4	4	4	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	143	
-	-	-	1	2119653-2	FEED CAM, POST FEED	142	
-	1	1	1	1-1803583-0	APPLICATOR BASIC ASSEMBLY, SF	141	
-	1	1	1	1803516-1	RAM ASSEMBLY, SF PACIFIC	140	
-	1	1	1	2844908-1	SCREW, LOCKING	99	
-	1	1	1	2844907-1	POST, LOCKING	98	
-	1	1	1	455888-5	SPACER, CRIMPER	82	
-	1	1	1	1803607-3	DOCUMENTATION PACKAGE	71	
-	1	1	1	2119791-5	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	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59	
-	1	1	1	1338685-1	PAWL, FEED	56	
-	2	2	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	53	
-	1	1	1	1803382-2	HOLD DOWN, SPRING LOADED	50	
6	-	-	1	2	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	-	-	1	2119652-1	FEED CAM, PRE FEED	48	
-	1	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41	
-	1	1	1	3-1752356-3	SUPPORT, TERMINAL	34	
-	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33	
-	2	2	2	2-2844962-6	SPACER, CYLINDRICAL, STRIP GUIDE	30	
-	1	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29	
-	1	1	1	1-455888-0	SPACER, CRIMPER	28	
-	1	1	1	1320928-2	STRIP GUIDE	24	
-	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21	
-	2	2	2	1-18028-2	WASHER, FLAT, REG M4	20	
-	1	1	1	2119533-1	STRIPPER, SIDE FEED	19	
1	-	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	1	2119805-1	SHEAR HOLDER, FRONT	10
1	-	1	1	1	1803095-6	FLOATING SHEAR, FRONT	9
1	1	1	1	1	2-1333202-2	ANVIL, COMBINATION	8
-	1	1	1	3-240641-8	SPACER	7	
-	-	-	-	-	-	6	
-	1	1	1	2119757-8	DEPRESSOR, SHEAR	5	
-	1	1	1	238011-9	BLOCK, CRIMPER SPACER	4	
1	1	1	1	1-2119784-8	CRIMPER, INSULATION O PREMIUM	3	
-	-	-	-	-	-	2	
1	1	1	1	9-657555-1	CRIMPER, WIRE PREMIUM	1	
-	77	-	42	-	22	-	21

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DRAWING NO.		DATE	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	5 PLC ±	6 PLC ±
ANGLES	FINISH			WEIGHT		SCALE	
MATERIAL				APVD		SHEET	
CUSTOMER ACCESSIBLE PRODUCTION DRAWING				SCALE		SHEET	



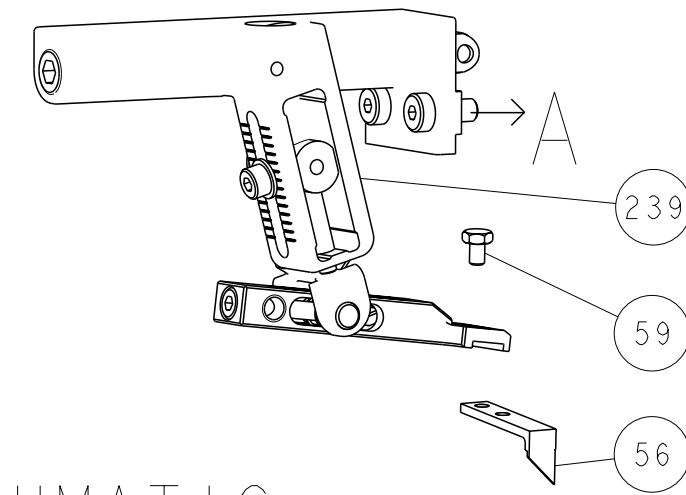
Ocean Side Feed Applicator

SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2151269

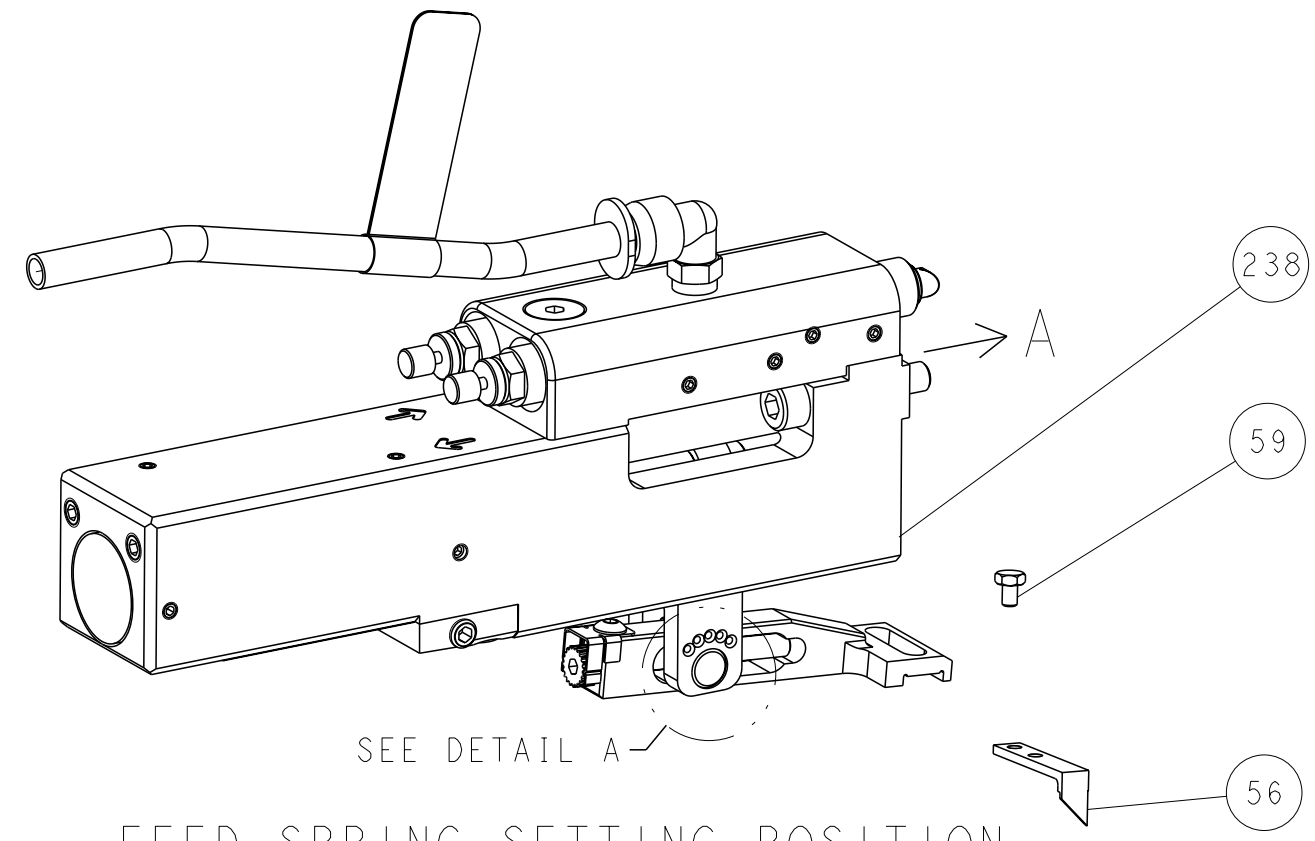
Customer Accessible Production Drawing SCALE: 1:2 SHEET 3 OF 4 REV E

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

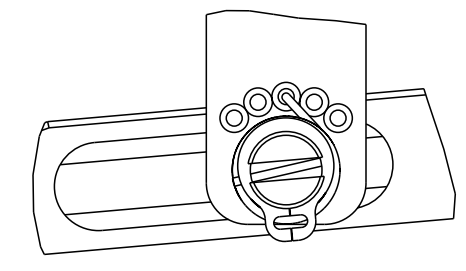
# FEED TYPE MECHANICAL



## PNEUMATIC

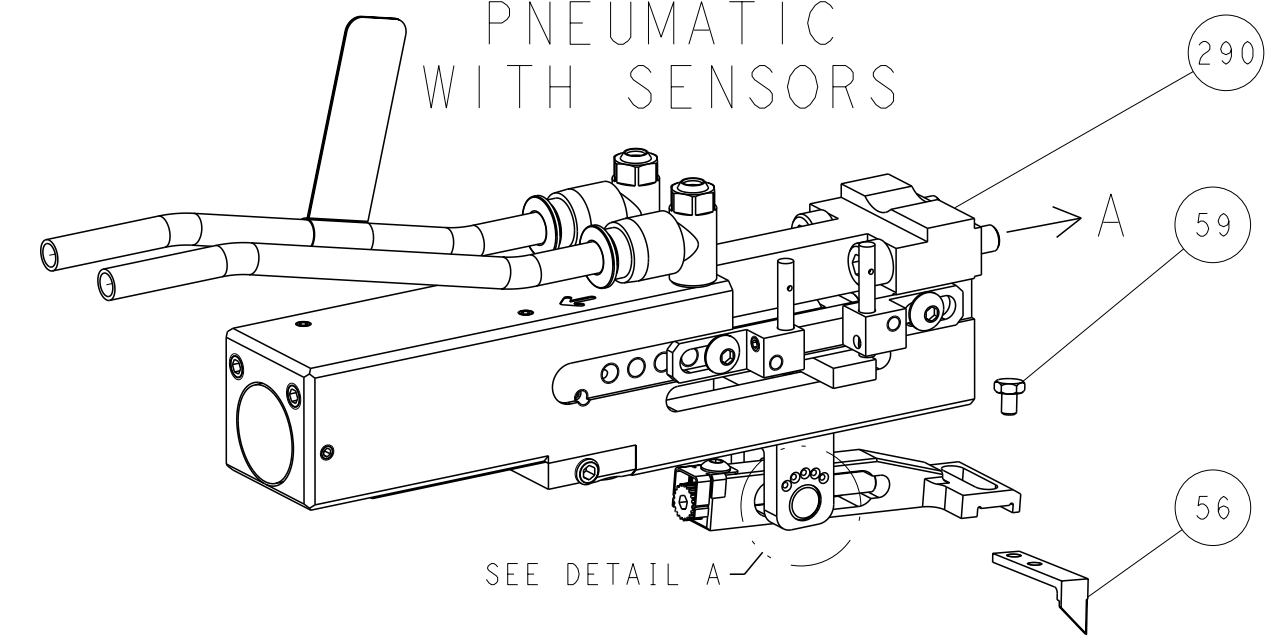


FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



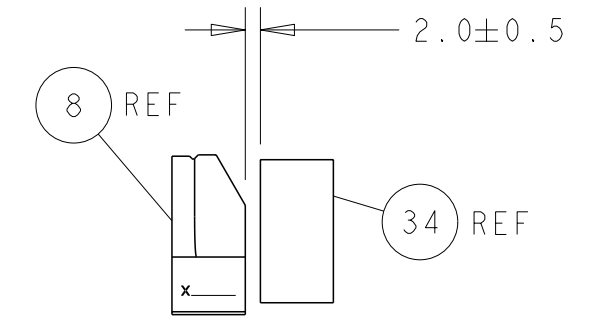
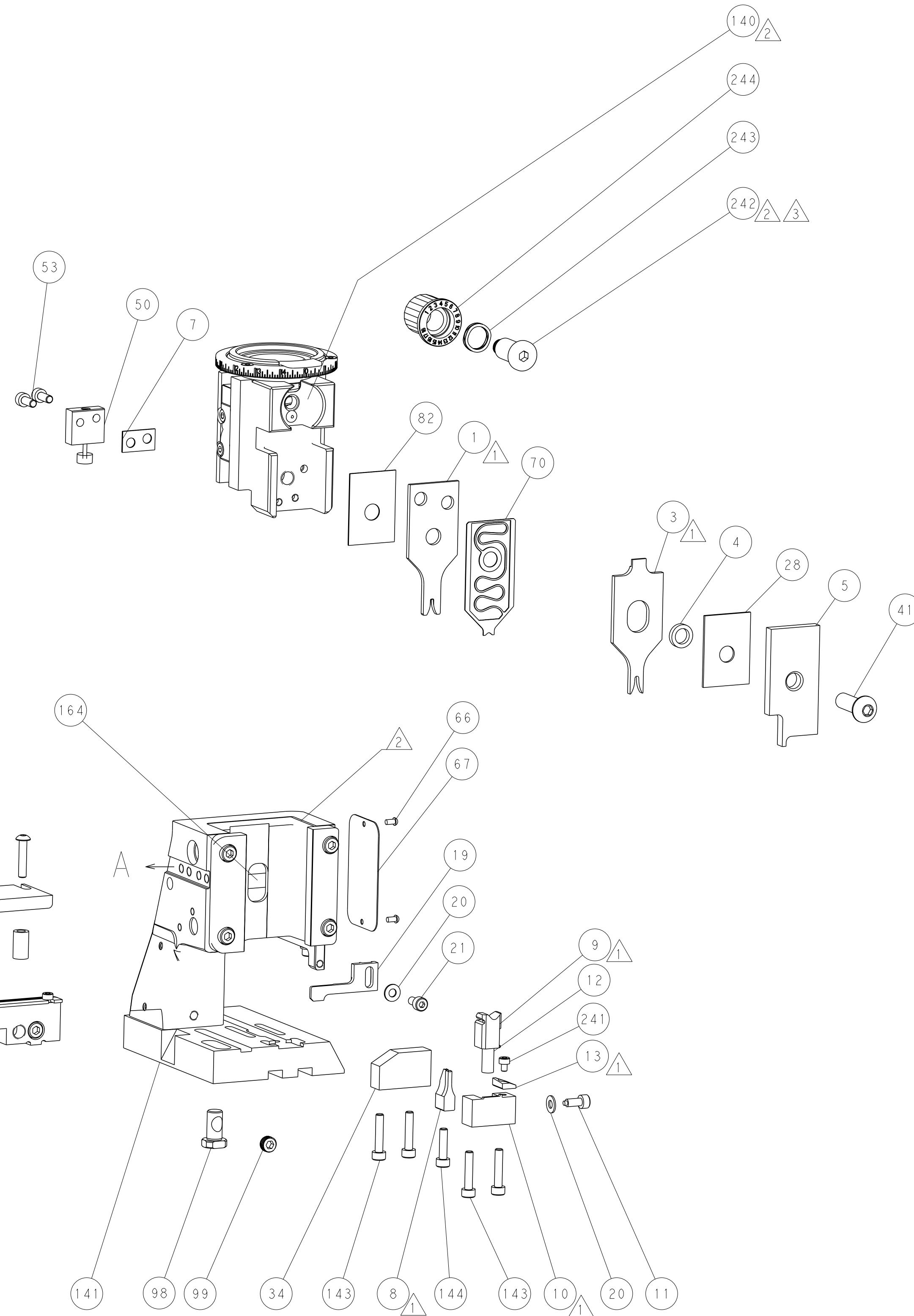
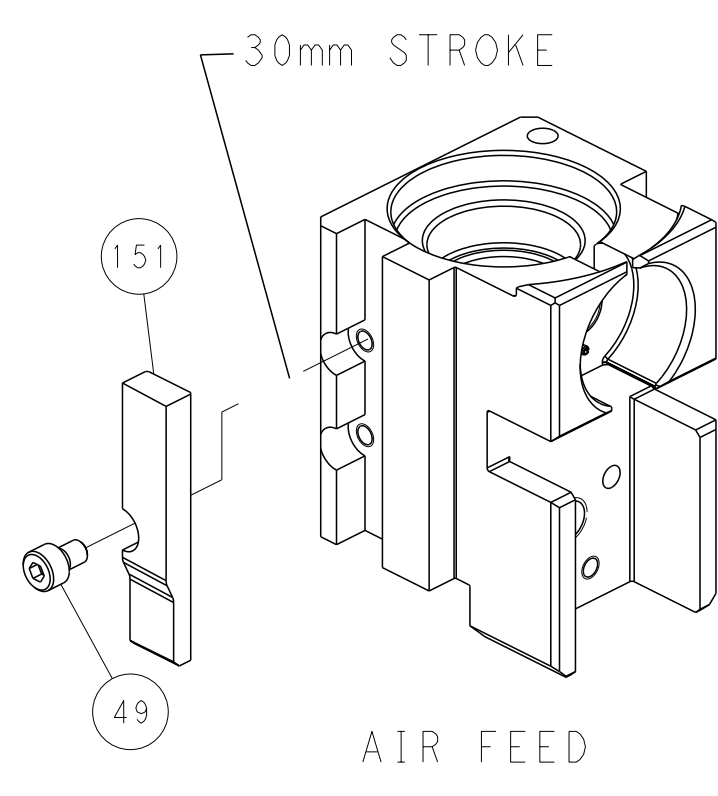
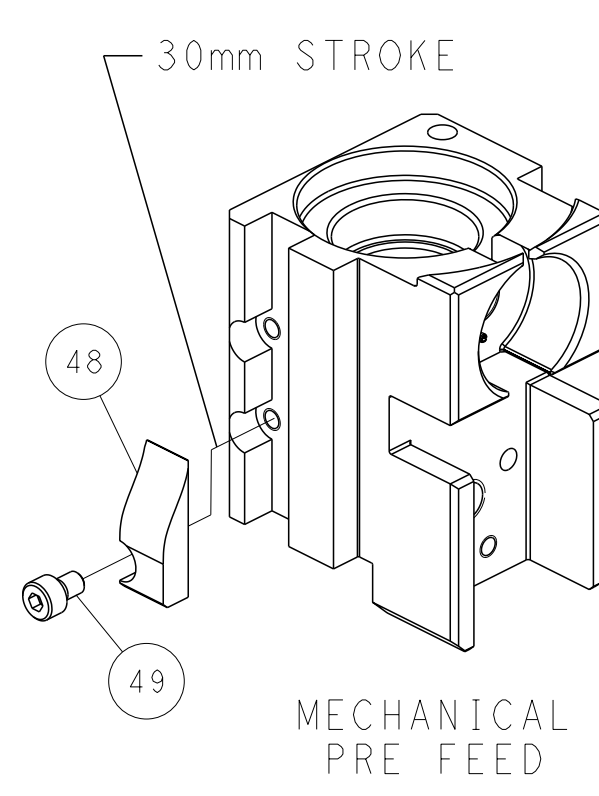
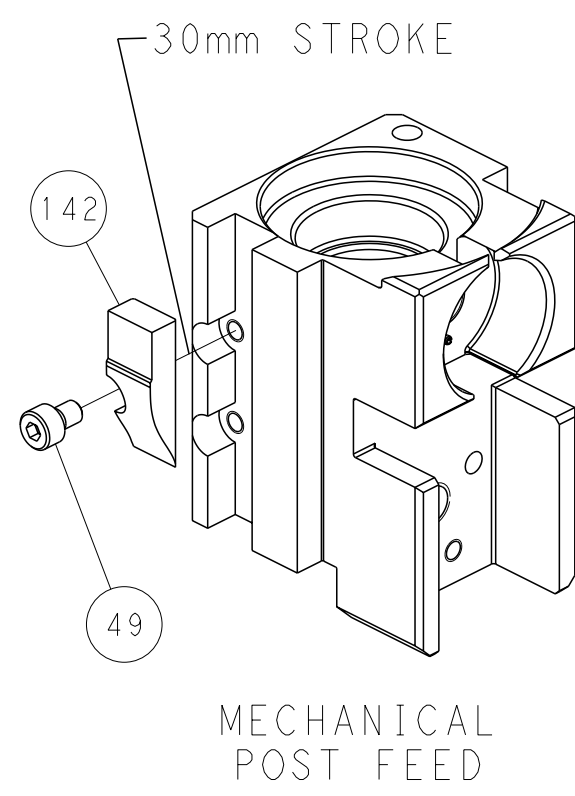
DETAIL A

## DOUBLE ACTING PNEUMATIC WITH SENSORS

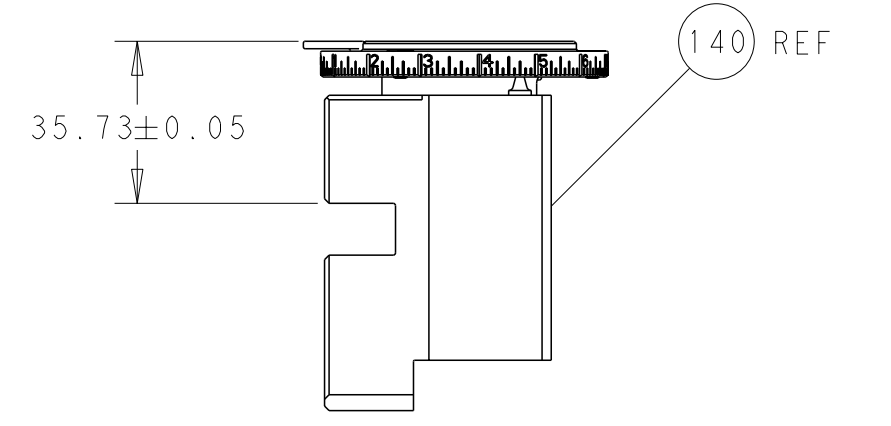


SEE DETAIL A

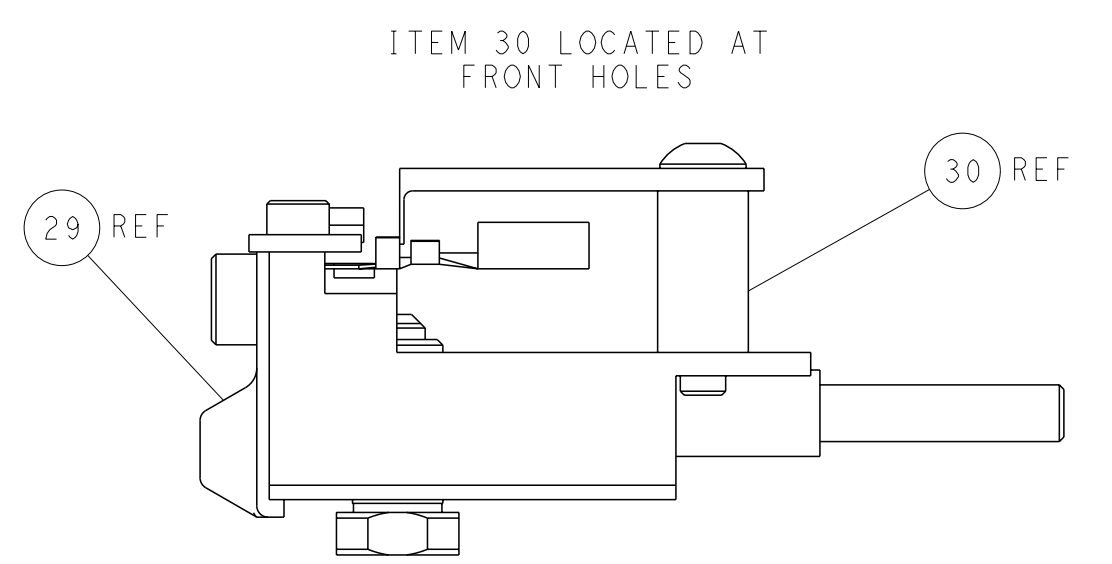
# CAM POSITIONS



TERMINAL SUPPORT LOCATION



RAM SET-UP



FEED TRACK POSITION GUIDE BY INSULATION BARREL

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

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DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH ±	PRODUCT SPEC APPLICATION SPEC WEIGHT SCALE: 1:2	SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2151269	RESTRICTED TO: E SHEET 4 OF 4

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