

Table with 4 columns: PART NUMBER, REVISION, DESCRIPTION, FEED TYPE. Rows include parts 2151639-1 through 7-2151639-7.

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA table with columns: CRIMP, SIZE, TYPE. Rows include WIRE, INSUL, STAB specifications.

Terminal data table for TE TERMINAL. Includes columns for terminal name, wire strip length, insulation diameter range, and terminal application specifications.

Terminal data table for TE CRIMP SPECIFICATION. Includes columns for terminal name, wire strip length, insulation diameter range, and terminal application specifications.

Dimensions table with columns: WIRE SIZE, CRIMP HEIGHT INCH [mm], CRIMP HEIGHT REFERENCE SETTING, STABILIZER CRIMP HEIGHT mm [INCH], TE HOUSING.

Dimensions table with columns: WIRE SIZE, CRIMP HEIGHT mm [INCH], CRIMP HEIGHT REFERENCE SETTING, STABILIZER CRIMP HEIGHT mm [INCH], TE HOUSING.

- 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.
UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
APPLICATOR WAS QUALIFIED TO STABILIZER CRIMP HEIGHT LISTED FOR TERMINAL AND HOUSING COMBINATION ONLY. THIS HEIGHT VARIES FROM 114 SPECIFICATION.

*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)

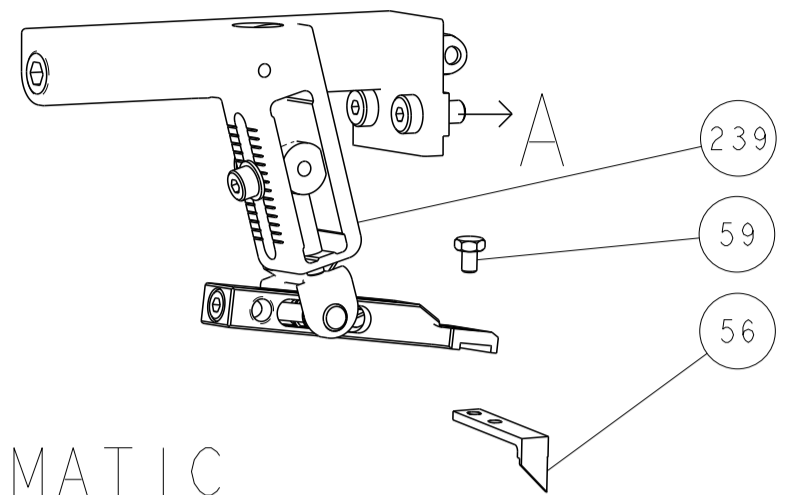
REVISIONS table with columns: P, LTR, DESCRIPTION, DATE, DWN, APVD. Rows include revisions G1, H, J.

Main BOM table with columns: QTY, PART NO, DESCRIPTION, ITEM NO. Rows include various components like RAM ASSEMBLY, SPACER, CRIMPER, TOOL, SIZING, FEED CAM, AIR FEED, etc.

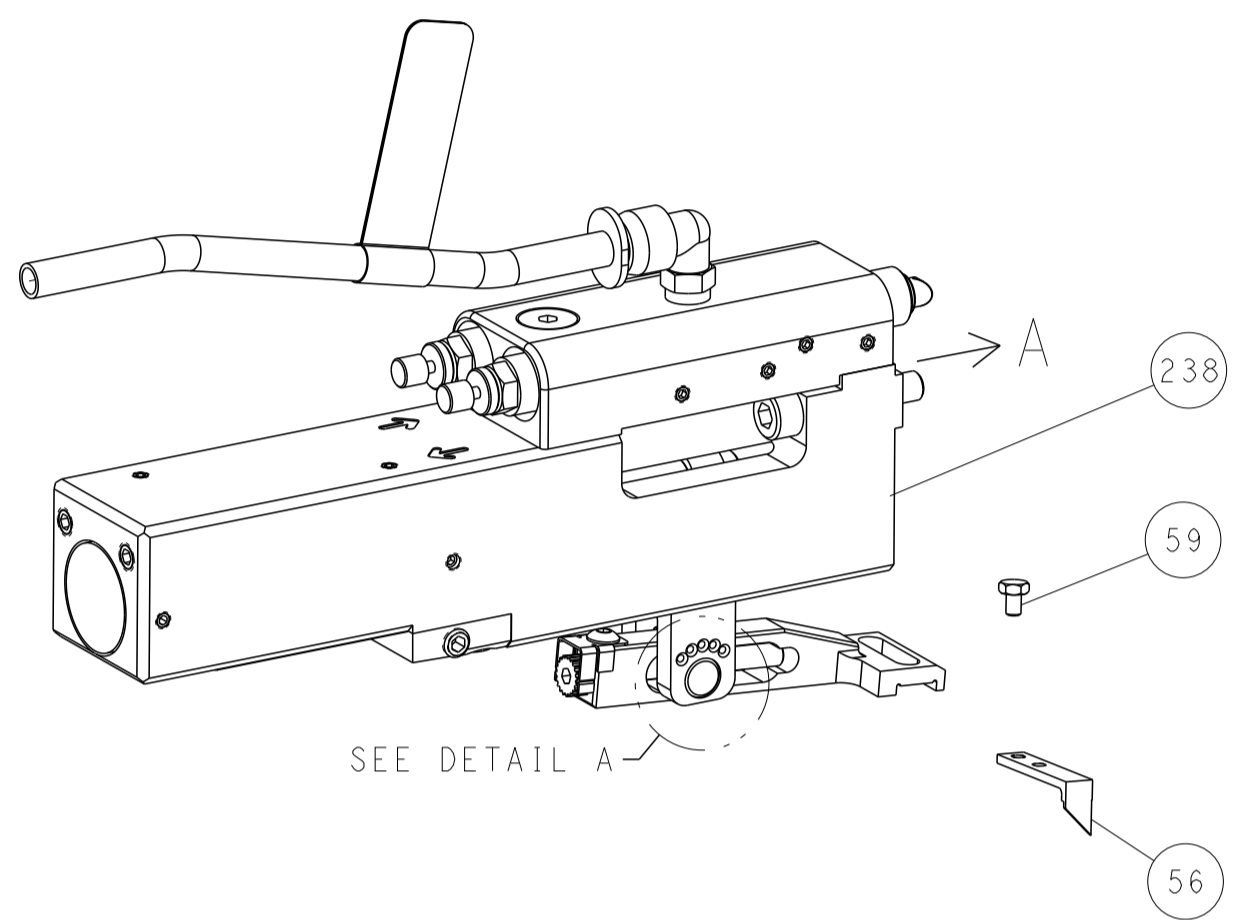
Customer Accessible Production Drawing section including dimensions, tolerances, material, weight, and drawing information.

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

FEED TYPE MECHANICAL



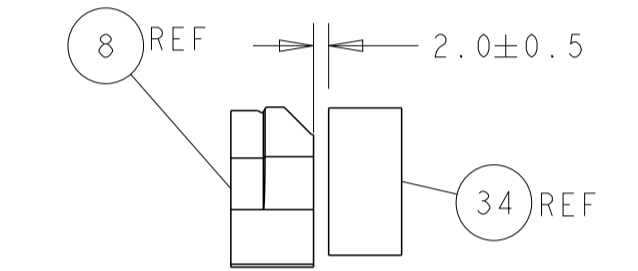
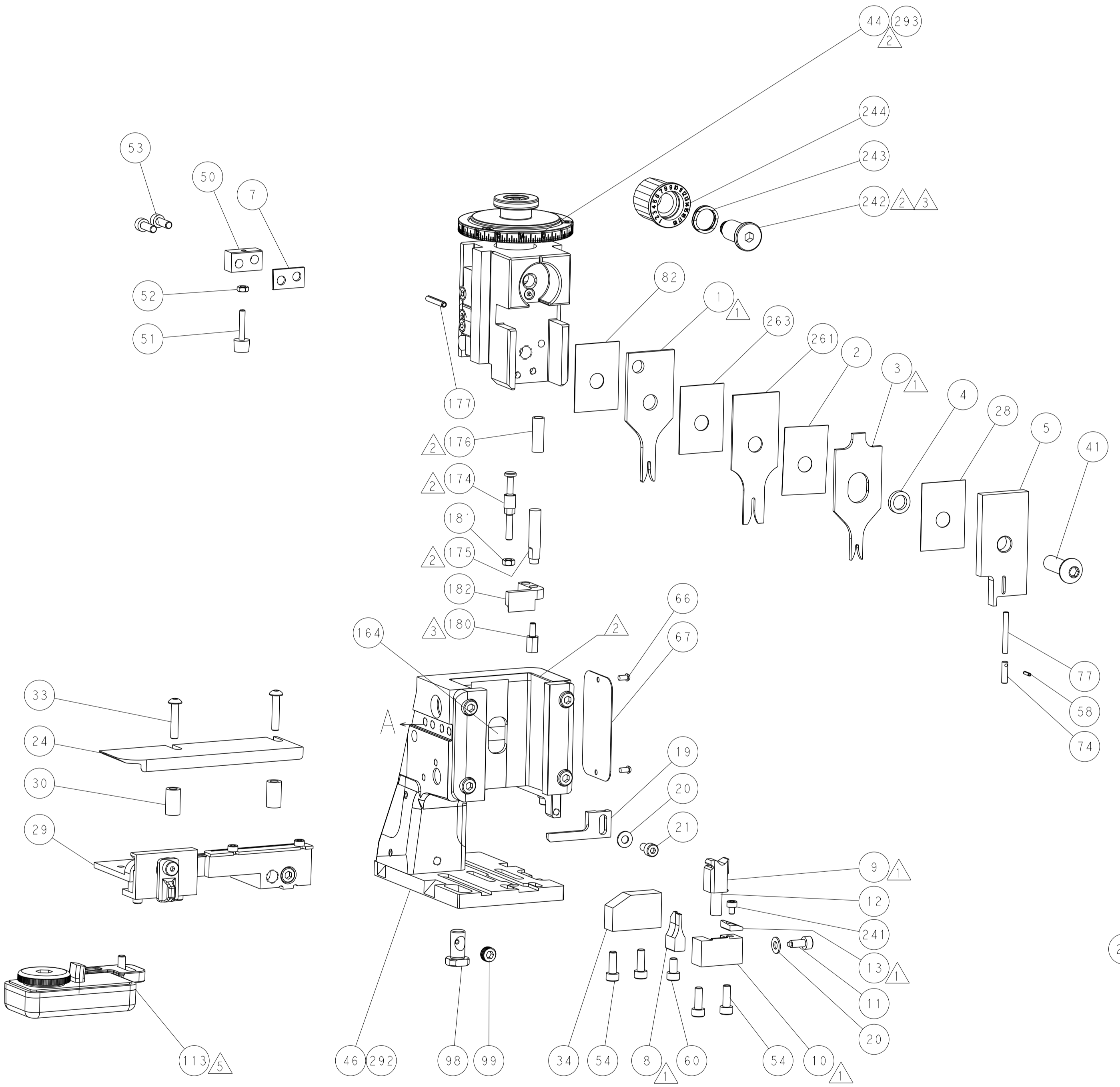
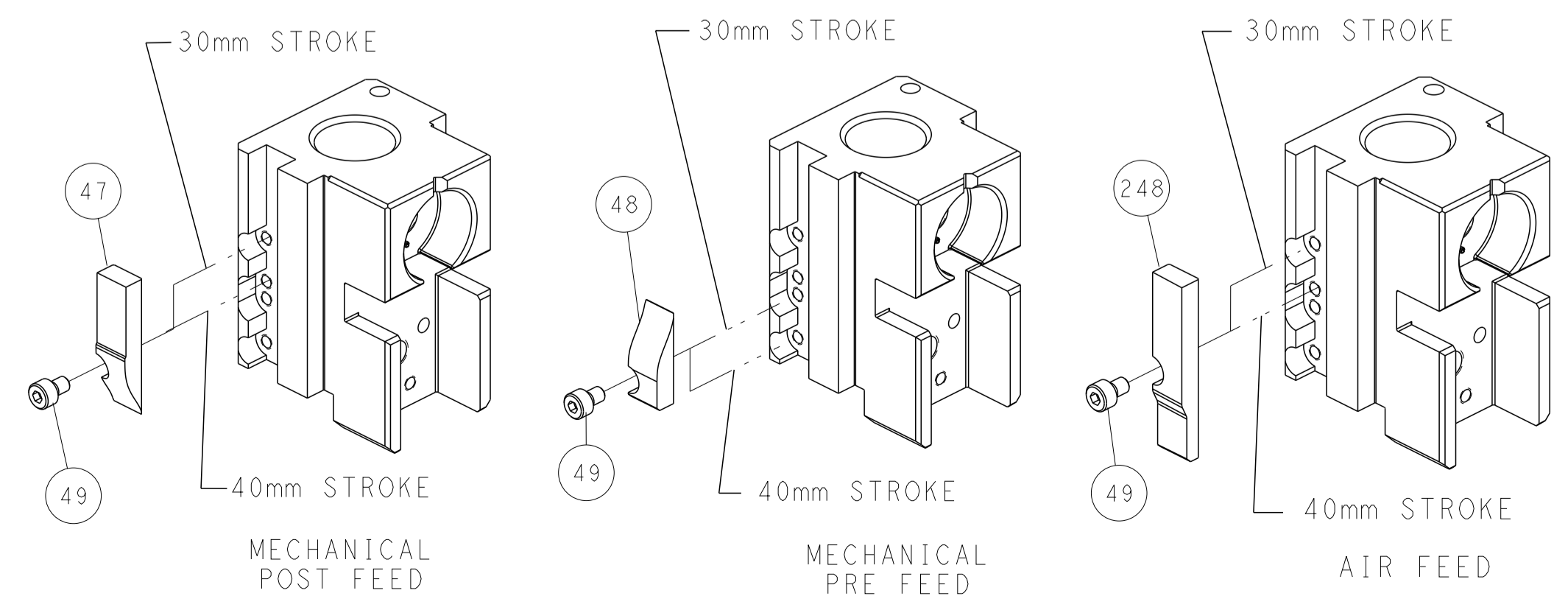
PNEUMATIC



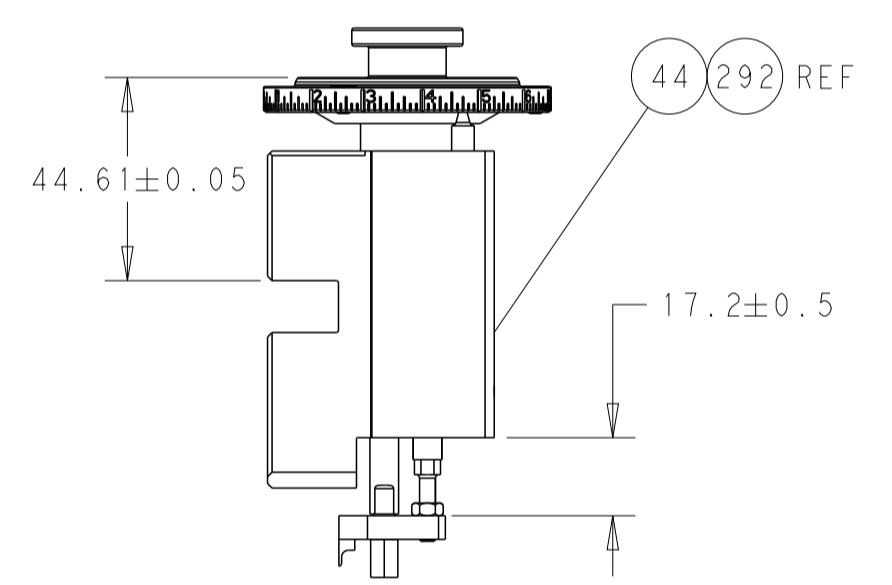
FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



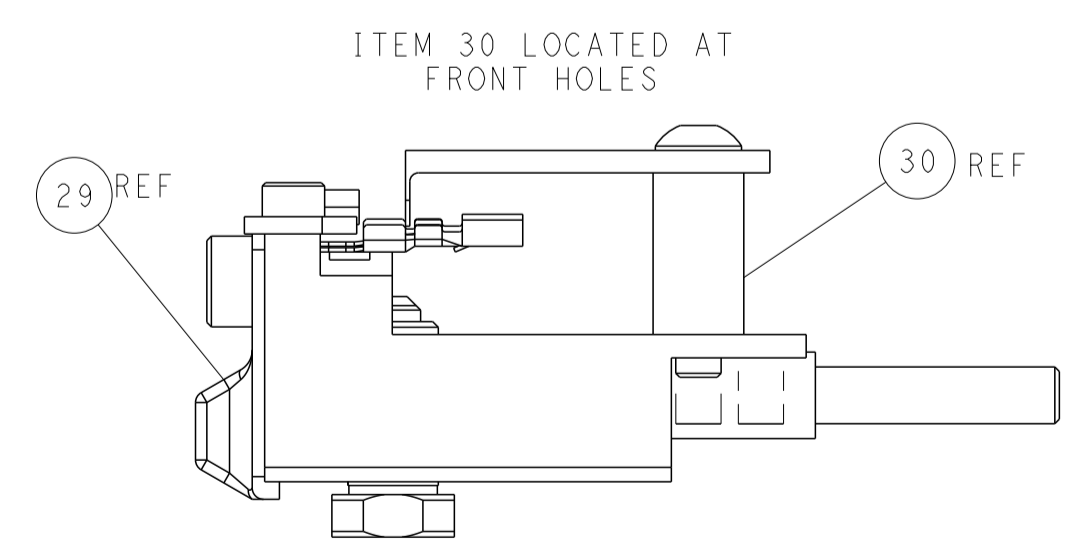
CAM POSITIONS



TERMINAL SUPPORT LOCATION



RAM SET-UP



ITEM 30 LOCATED AT FRONT HOLES

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)

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DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		NAME: Ocean Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: C-2151639	RESTRICTED TO: - SCALE: 1:2 SHEET: 2 of 4 REV: J
MATERIAL: - FINISH: -		WEIGHT: - Customer Accessible Production Drawing	SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2151639-1	H	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2151639-2	J	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151639-7	G	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
 INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.40 mm [.055]	F
INSUL	1.78 mm [.070]	O
STAB	1.91 mm [.075]	O

APPLICATOR INSTRUCTIONS
 408-35042

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: CONTACT ASSEMBLY, LOCKING CLIP			
WIRE STRIP LENGTH .111-.126 IN [2.82-3.20 mm]		INSULATION DIAMETER RANGE Ø.038-.062 IN [0.97-1.57 mm]	
TERMINAL APPLICATION SPECIFICATION 114-25006		-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
87124-1	87124-2	87124-3	5-87124-2
2267356-1			

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: CONTACT ASSEMBLY, LOCKING CLIP			
WIRE STRIP LENGTH .111-.126 IN [2.82-3.20 mm]		INSULATION DIAMETER RANGE Ø.038-.062 IN [0.97-1.57 mm]	
TERMINAL APPLICATION SPECIFICATION 114-25006		-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
867052-1	867052-2	5-867052-1	

WIRE SIZE	CRIMP HEIGHT INCH [mm]	CRIMP HEIGHT REFERENCE SETTING	STABILIZER CRIMP HEIGHT mm [INCH]	TE HOUSING
22 AWG	0.86+/-0.05 [0.034+/-0.002]	7.1	2.44 +0.0/-0.2 [0.096 +0.0/-0.008]	926010/868781
24 AWG	0.76+/-0.05 [0.030+/-0.002]	8.1	2.44 +0.0/-0.2 [0.096 +0.0/-0.008]	926010/868781
26 AWG	0.76+/-0.05 [0.030+/-0.002]	8.1	2.44 +0.0/-0.2 [0.096 +0.0/-0.008]	926010/868781

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING	STABILIZER CRIMP HEIGHT mm [INCH]	TE HOUSING
20 AWG	1.02+/-0.05 [0.040+/-0.002]	5.6	2.44 +0.0/-0.2 [0.096 +0.0/-0.008]	926010/868781

- 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.
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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	LTN	DESCRIPTION	DATE	OWN	APVD
-	-	-	-	SEE SHEET 1	-	-	-

-	1	1	455888-5	SPACER, CRIMPER	263
-	1	1	461679-3	TOOL, SIZING	261
-	1	1	2119082-5	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	5-547505-2	SPRING, COMPRESSION	77
-	1	1	854769-4	HOLDER, INS	74
-	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	21028-2	PIN, SLOTTED SPRING .062 X .250	58
-	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	1752356-1	SUPPORT, TERMINAL	34
-	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	2-2844962-6	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29
-	1	1	455888-4	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	1-356885-4	STOP, SHEAR	11
△	1	1	2119805-1	SHEAR HOLDER, FRONT	10
△	1	1	1803095-1	FLOATING SHEAR, FRONT	9
△	1	1	1-1633917-6	ANVIL, COMBINATION	8
-	1	1	6-240641-3	SPACER	7
-	-	-	-	-	6
-	1	1	2119780-9	DEPRESSOR, SHEAR	5
-	1	1	1-238011-0	BLOCK, CRIMPER SPACER	4
△	1	1	1-1633965-6	CRIMPER, INSULATION O PREMIUM	3
-	1	1	455888-3	SPACER, CRIMPER	2
△	1	1	456402-1	CRIMPER, WIRE PREMIUM	1

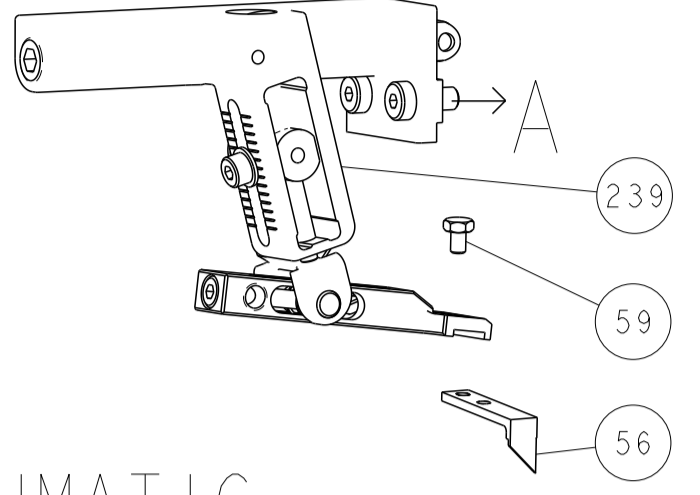
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		MATERIAL:		FINISH:	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES ±	FINISH ±

DATE	BY	CHK	APPD	NAME	SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
9 APRIL 2012	STAKEM	9 APRIL 2012	G. BAILEY	TE Connectivity	A1	00779	2151639	-

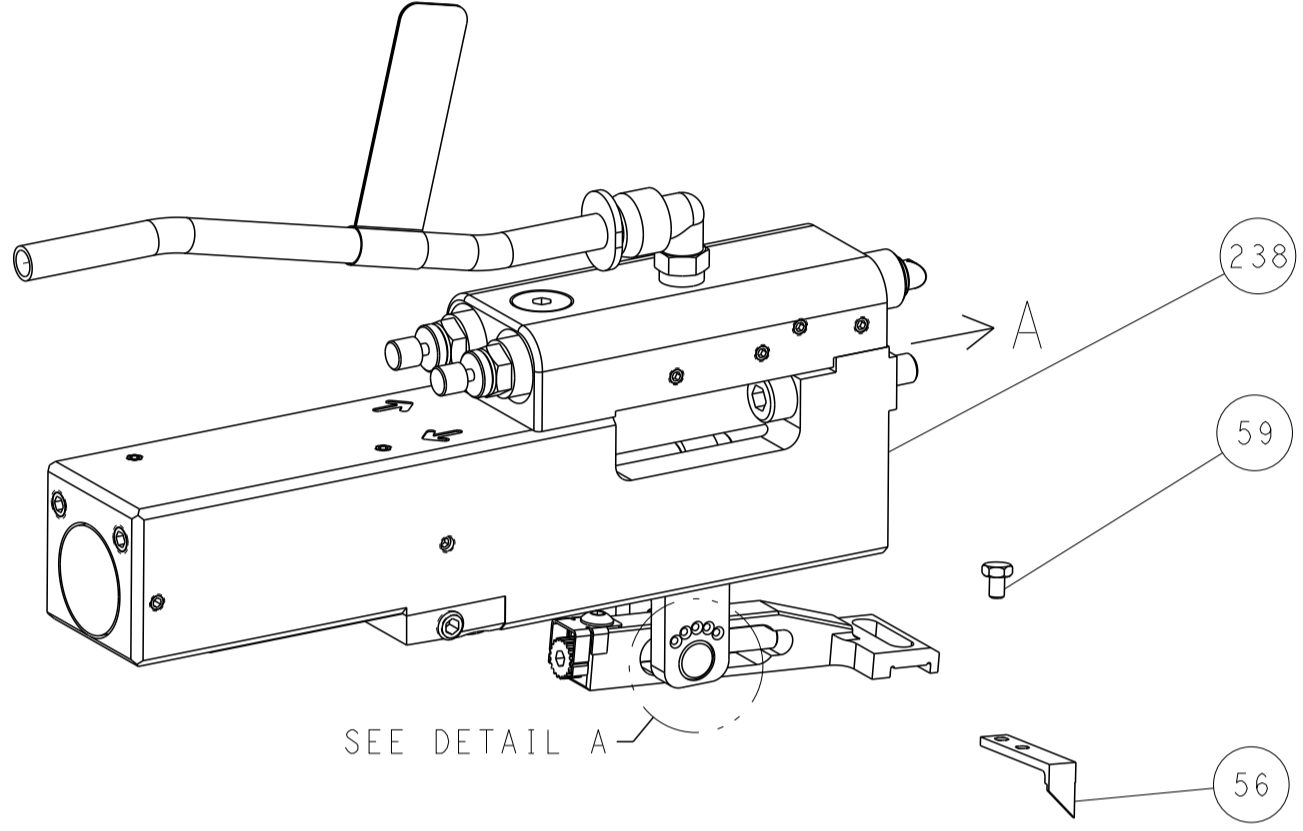
Customer Accessible Production Drawing SCALE 1:2 SHEET 3 OF 4 REV J

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

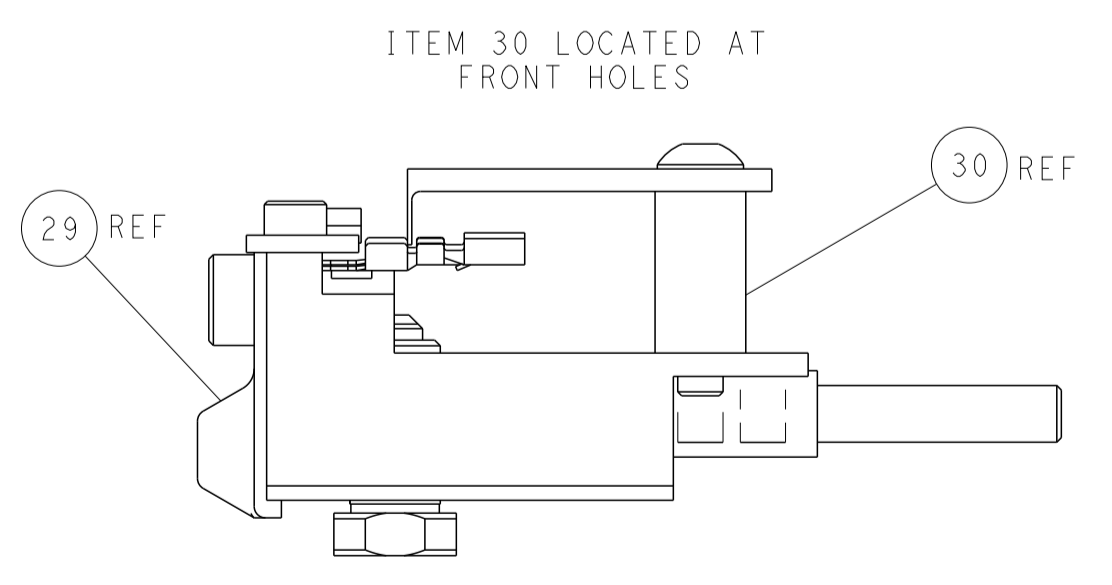
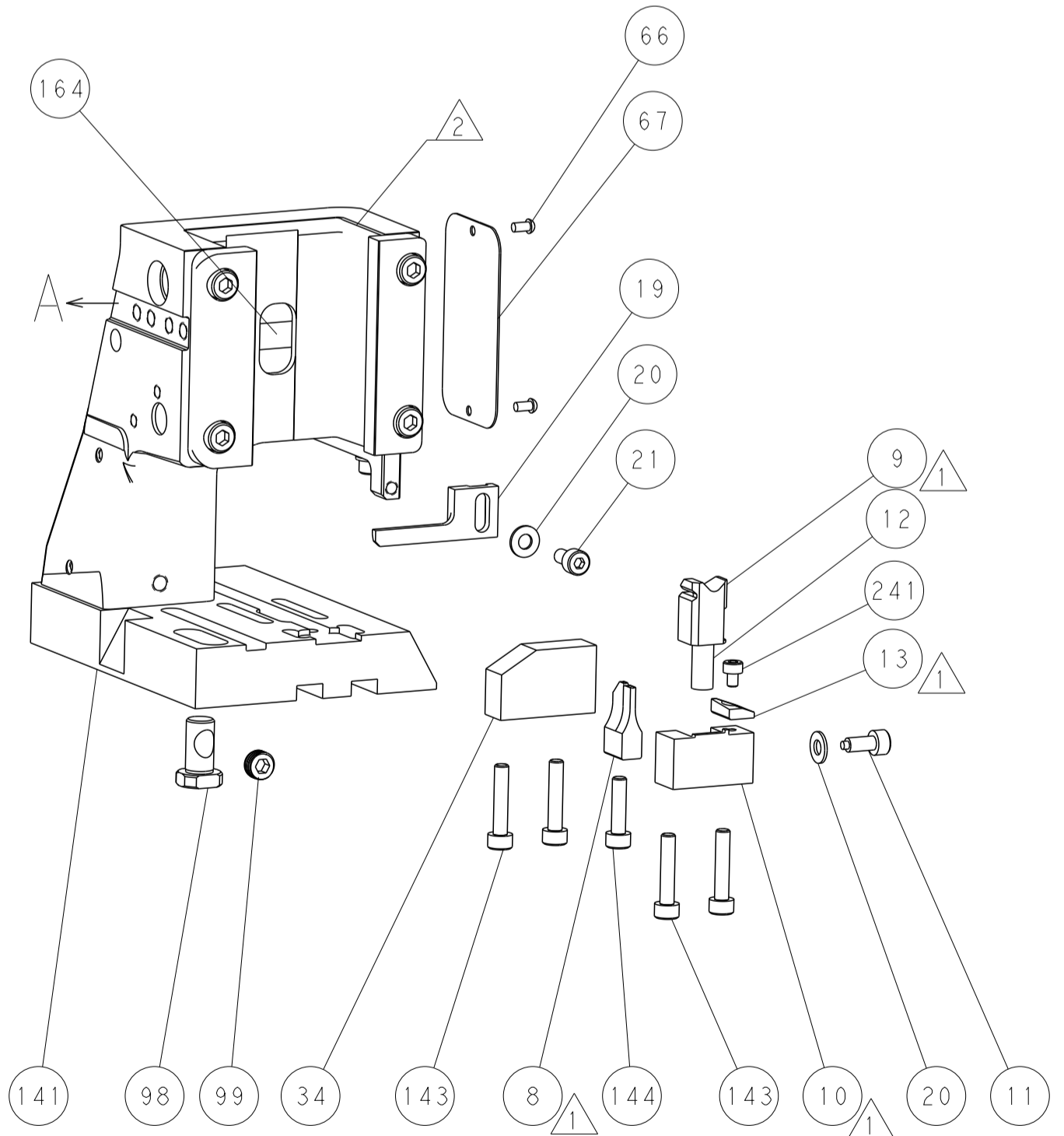
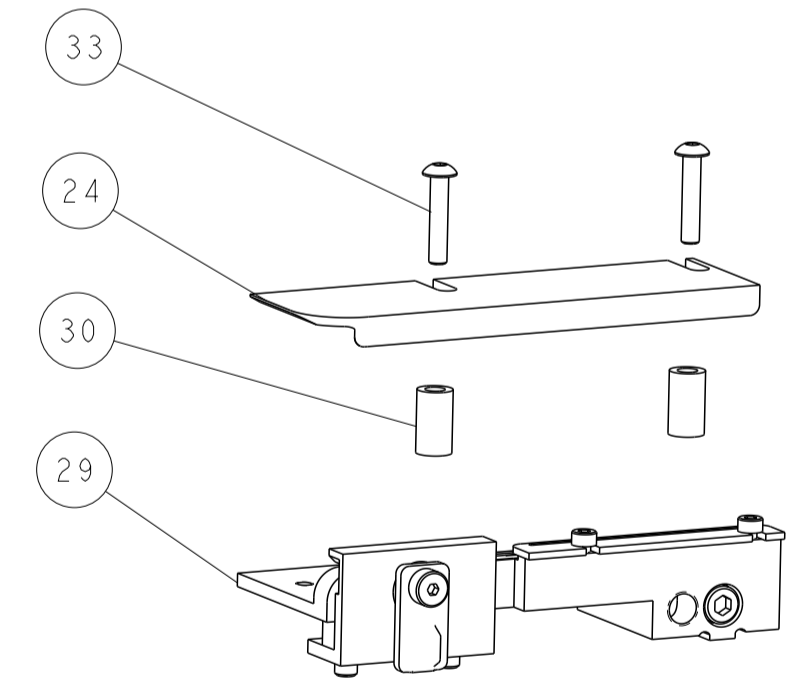
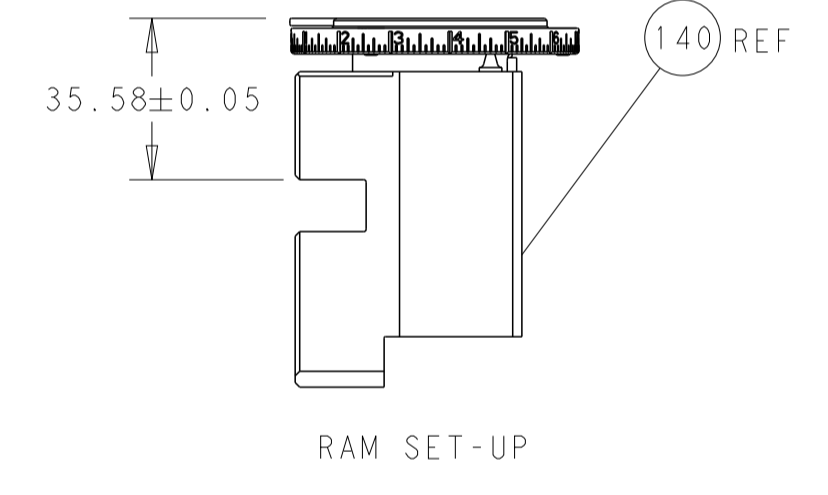
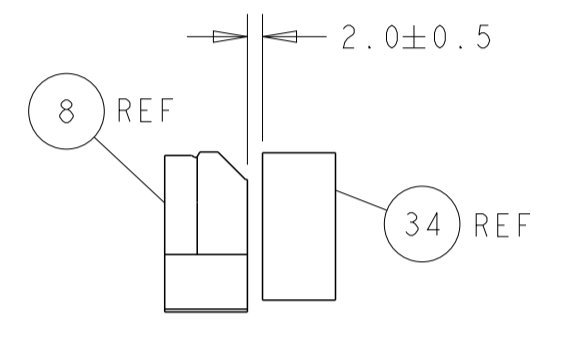
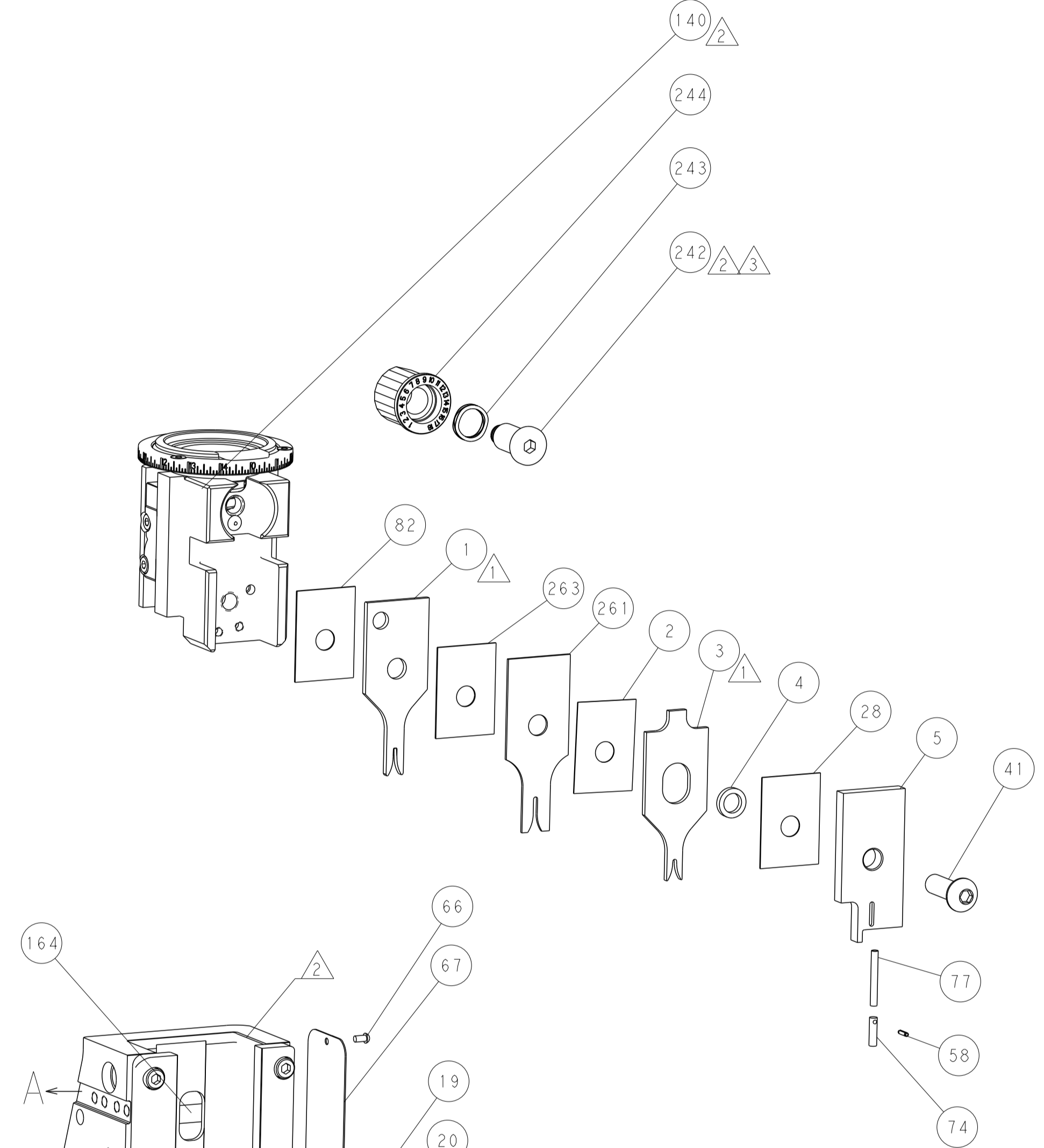
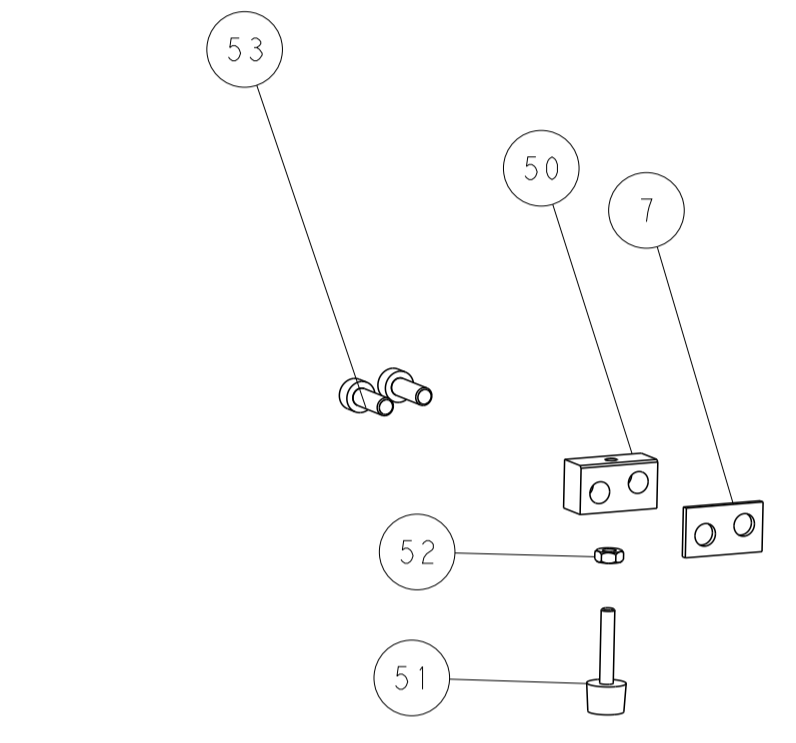
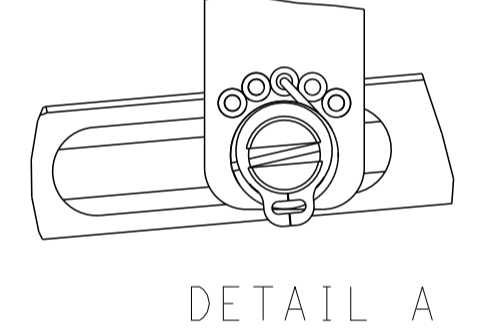
FEED TYPE MECHANICAL



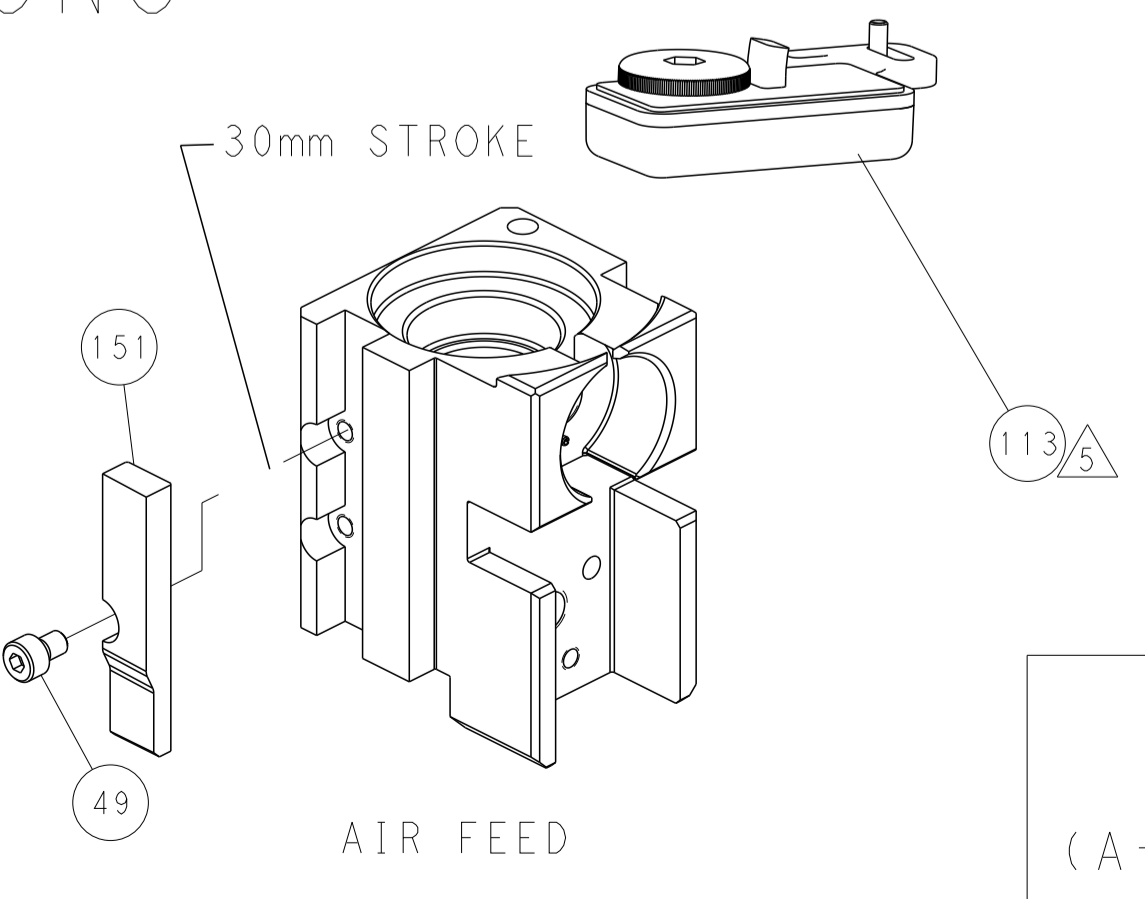
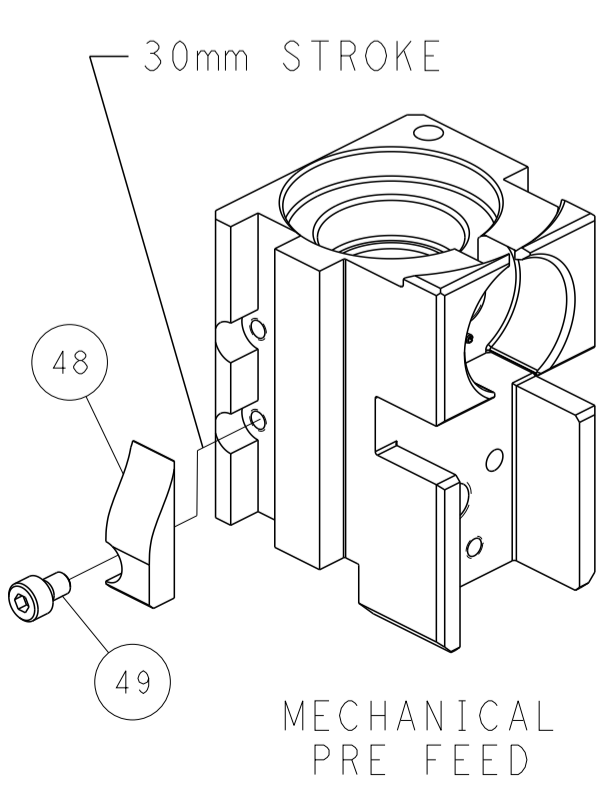
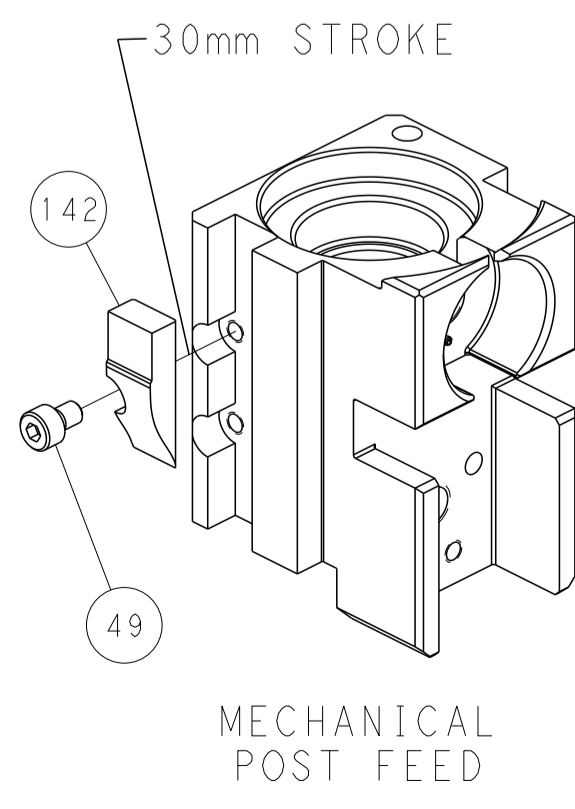
PNEUMATIC



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:		DWG: STAKEM 19APRIL2012		TE Connectivity	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	5 PLC ±	Harrisburg, PA 17105-3608
MATERIAL:		FINISH:		CHK: G. BAILEY 19APRIL2012		NAME: Ocean Side Feed Applicator	
				APVD: T. ELBIN 19APRIL2012		SIZE: CAGE CODE: DRAWING NO: RESTRICTED TO	
				PRODUCT SPEC:		A1 00779 ©=2151639	
				APPLICATION SPEC:		Customer Accessible Production Drawing	
				WEIGHT:		SCALE: 1:2 SHEET 4 OF 4 REV J	

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[TE Connectivity:](#)

[2-2151639-1](#)