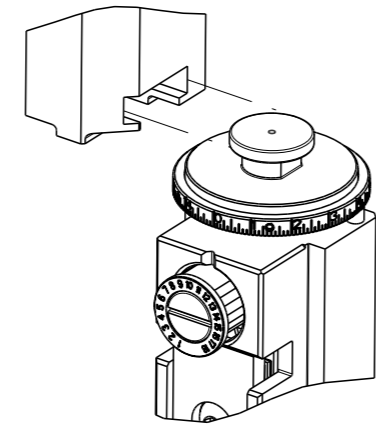


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151025-1	F	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2151025-2	F	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151025-1	F	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2151025-2	F	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2151025-7	B	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.29 mm [.090]	F
INSUL	5.08 mm [.200]	F

APPLICATOR INSTRUCTIONS 408-35042

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: PIN AND SOCKET UNIVERSAL MATE-N-LOK			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
3.99-4.75 mm [1.57-.187 IN]		Ø3.30-5.08 mm [1.130-.200 IN]	
TERMINAL APPLICATION SPECIFICATION	114-1010		

TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
350537-1	350537-7	350538-3	350700-2
350537-2	1-350537-2	350538-6	350700-3
350537-3	350538-1	350538-7	350700-7
350537-6	350538-2	350700-1	1-350700-1
			2238103-1

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
14 AWG	1.75+/-0.05 [1.069+/-0.002]	4.1
DOUBLE 2@18AWG	1.60+/-0.05 [1.063+/-0.002]	5.7
1.50mm2	1.52+/-0.05 [1.060+/-0.002]	6.5
16 AWG	1.50+/-0.05 [1.059+/-0.002]	6.7
1.00mm2	1.42+/-0.05 [1.056+/-0.002]	7.5
18 AWG	1.32+/-0.05 [1.052+/-0.002]	8.6
20 AWG	1.19+/-0.05 [1.047+/-0.002]	10.0

- 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.

**\*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	REV	DATE	BY	CHK
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		E1	22JAN2020	TB	TE
		F	23MAR2020	JWC	RK
		F1	01APR2020	JWC	RK

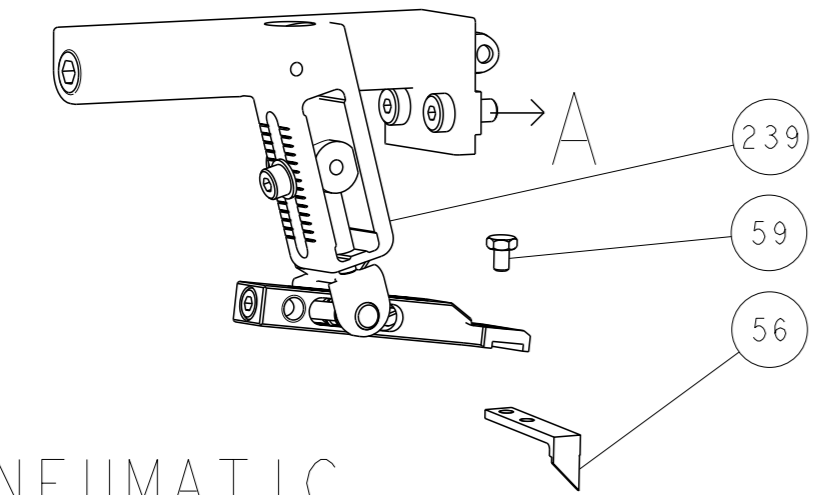
-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248
-	1	1	1	1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	1	1	1	18023-1	SCR, SKT HD CAP M3 X 5.0	241
-	-	1	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	1	-	1	-	2844940-1	AIR FEED MODULE	238
-	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	1	1	1	1	2844908-1	SCREW, LOCKING	99
-	1	1	1	1	2844907-1	POST, LOCKING	98
-	1	1	1	1	455888-6	SPACER, CRIMPER	82
-	1	1	1	1	22278-9	SPRING, COMPRESSION	77
-	1	1	1	1	854769-2	HOLDER, INS	74
-	1	1	1	1	1803607-3	DOCUMENTATION PACKAGE	71
-	1	1	1	1	2119740-1	TAG, IDENTIFICATION	67
-	2	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	1	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	60
-	1	1	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	1	1	1	1	21028-2	PIN, SLOTTED SPRING .062 X .250	58
-	1	1	1	1	1338685-1	PAWL, FEED	56
-	4	4	4	4	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	54
-	2	2	2	2	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	53
-	1	1	1	1	1803382-6	HOLD DOWN, SPRING LOADED	50
-	1	2	1	2	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	-	1	-	1	2119652-1	FEED CAM, PRE FEED	48
-	-	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	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
-	1	1	1	1	1752356-6	SUPPORT, TERMINAL	34
-	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	2	2	2-2844962-6	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29
-	1	1	1	1	1-455888-0	SPACER, CRIMPER	28
-	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	2	2	1-18028-2	WASHER, FLAT, REG M4	20
-	1	1	1	1	2119533-1	STRIPPER, SIDE FEED	19
-	1	1	1	1	2119806-1	INSERT, SHEAR	13
-	1	1	1	1	3-22280-3	SPRING, COMPRESSION	12
-	1	1	1	1	1-356885-4	STOP, SHEAR	11
-	1	1	1	1	2119805-1	SHEAR HOLDER, FRONT	10
-	1	1	1	1	462006-6	FLOATING SHEAR, FRONT	9
-	1	2	2	1	1-1333205-1	ANVIL, COMBINATION	8
-	1	1	1	1	240641-5	SPACER	7
-	1	1	1	1	1-2119780-4	DEPRESSOR, SHEAR	5
-	1	1	1	1	238011-4	BLOCK, CRIMPER SPACER	4
-	1	2	2	1	5-1803016-4	CRIMPER, INSULATION F	3
-	1	1	1	1	455888-3	SPACER, CRIMPER	2
-	1	2	2	1	8-456406-1	CRIMPER, WIRE PREMIUM	1

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

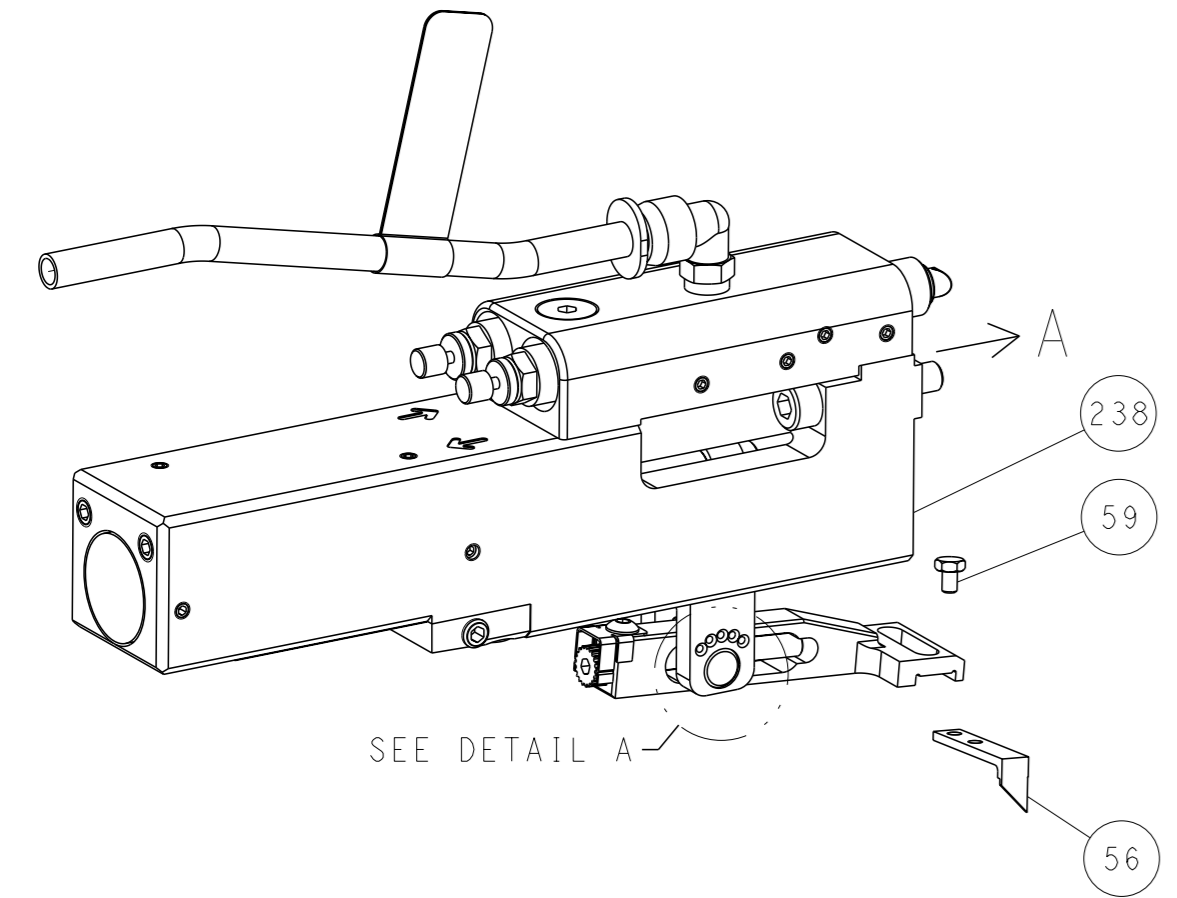
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MATERIAL: -		FINISH: -		WEIGHT: -		SCALE: 1:2 SHEET 1 OF 4 REV F1	

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

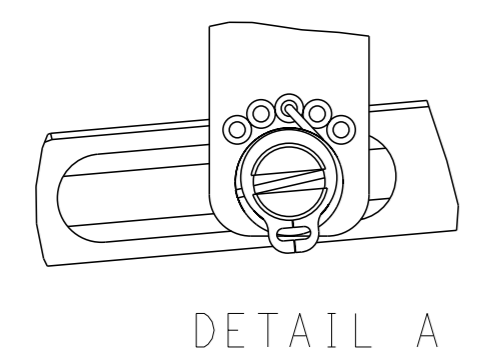
# FEED TYPE MECHANICAL



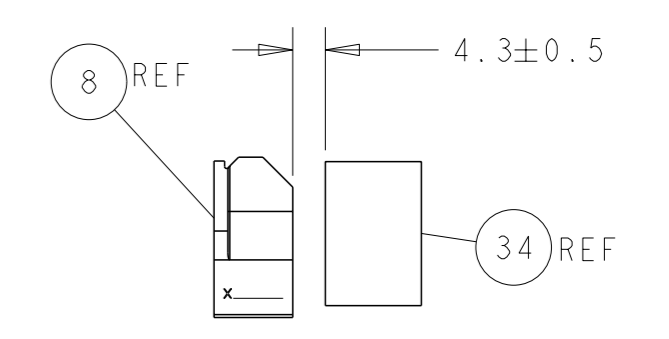
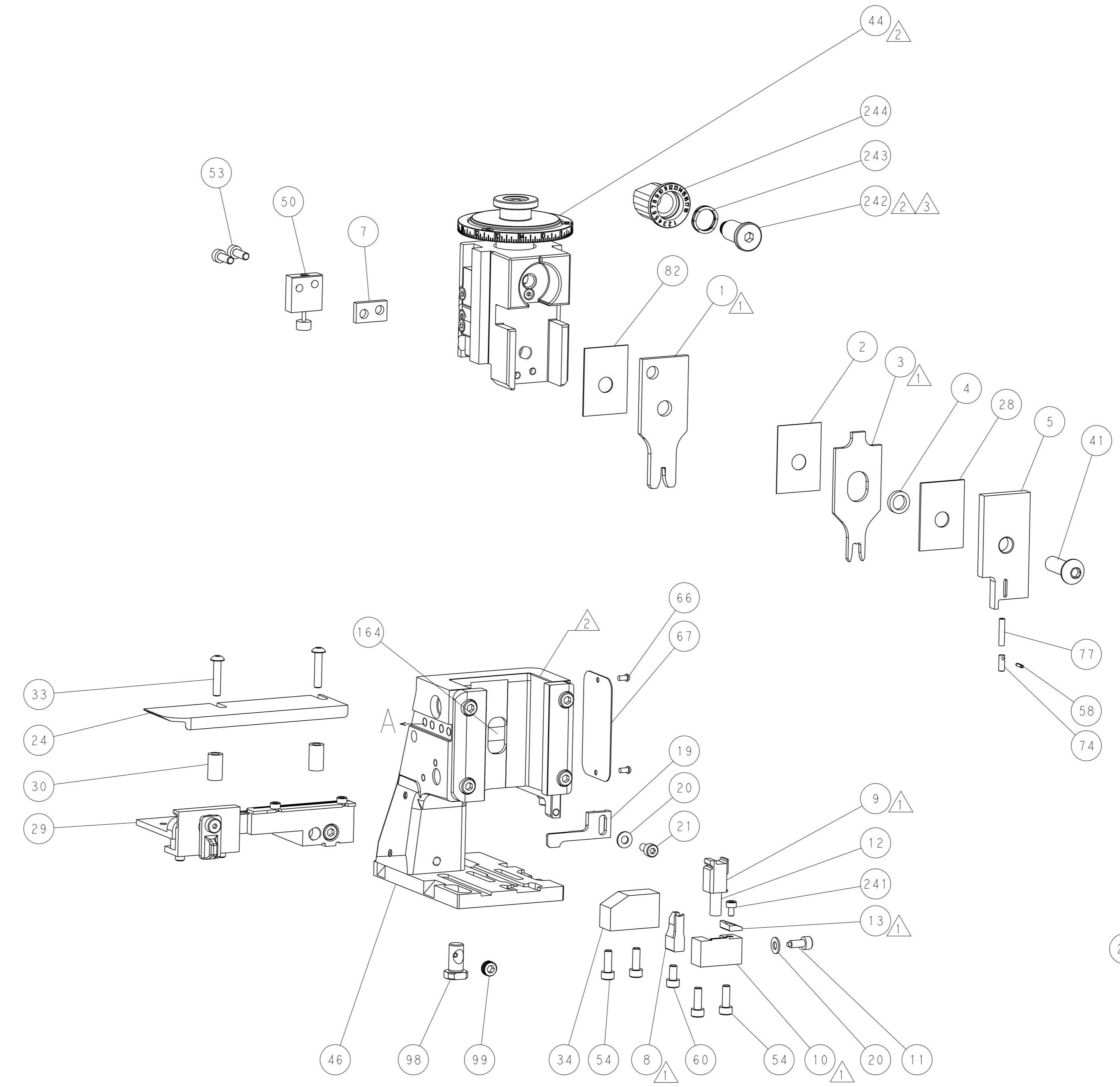
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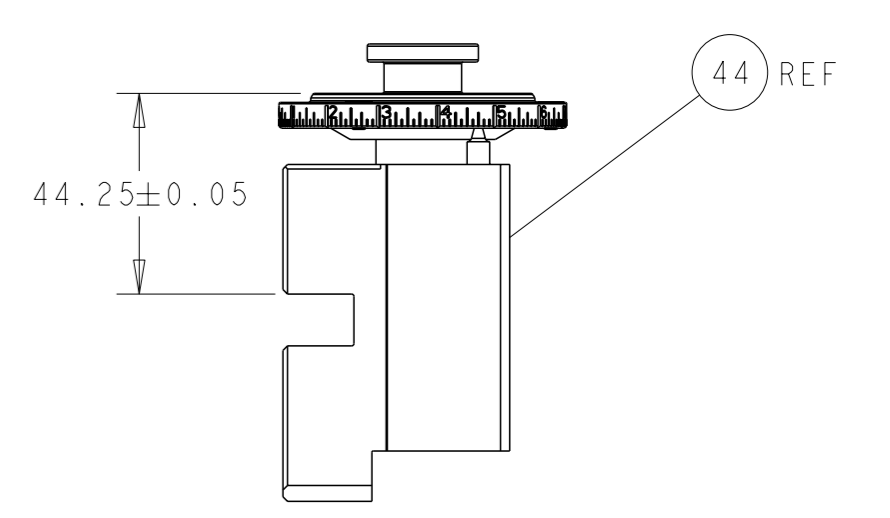
## FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



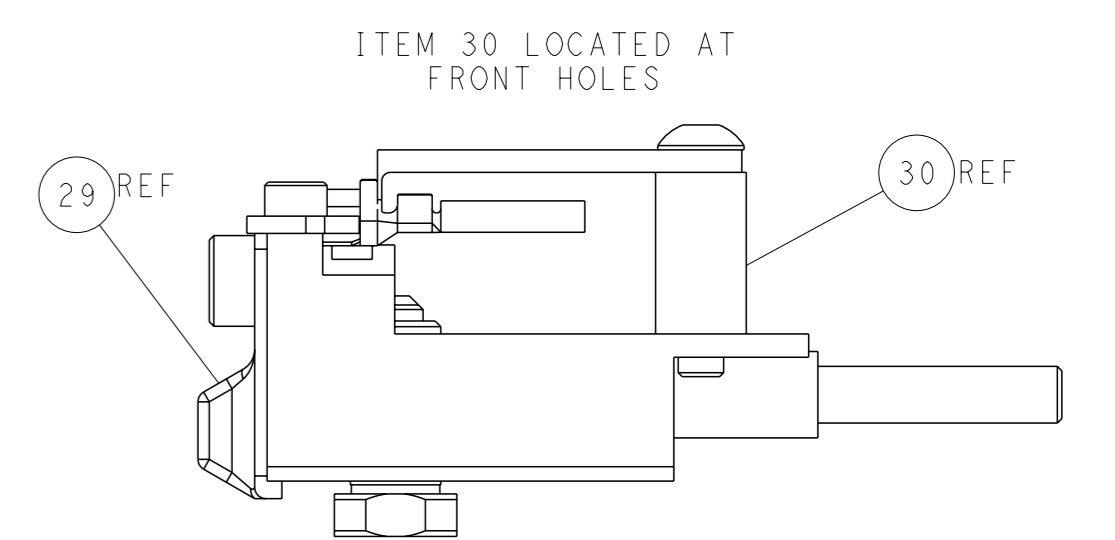
DETAIL A



TERMINAL SUPPORT LOCATION

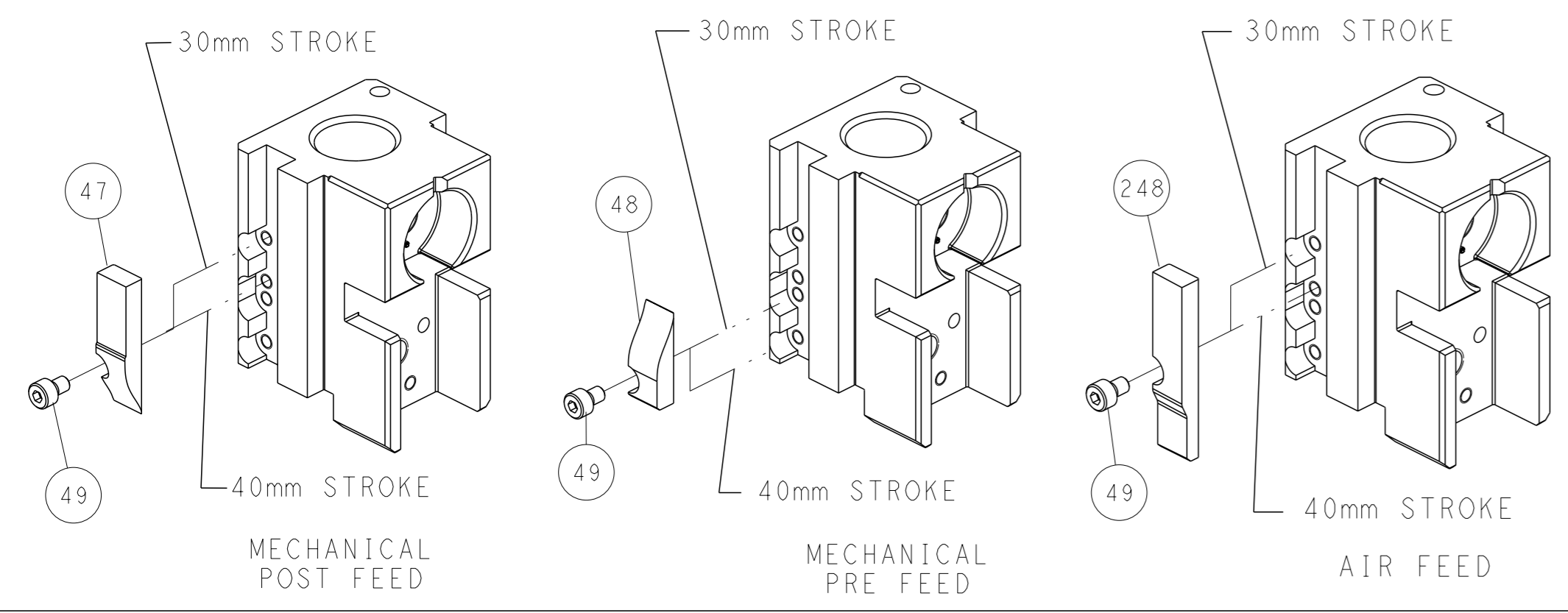


RAM SET-UP



FEED TRACK POSITION GUIDE BY INSULATION BARREL

# CAM POSITIONS

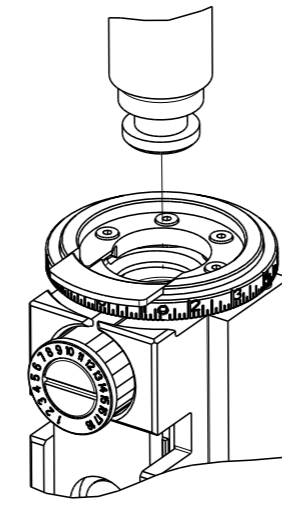


**ATLANTIC VERSION**  
 Shown on sheets 1 of 4 & 2 of 4  
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

<small>THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE AND TO CONTROLING ENGINEERING DISCRETION. SHOULD BE CONTACTED FOR THE LATEST REVISION.</small>		OWN: R. STAKEM 10OCT2011 CHK: G. BAILEY 10OCT2011 APVD: J. ELBIN 10OCT2011	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: ©=2151025	RESTRICTED TO: - SCALE: 1:2 SHEET: 2 of 4 REV: F1
MATERIAL: - FINISH: -		WEIGHT: - Customer Accessible Production Drawing	SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

8	7	6	5	4	3	2	1
THIS DRAWING IS UNPUBLISHED.		RELEASED FOR PUBLICATION		20			
COPYRIGHT © BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.							
PART NUMBER	REVISION	DESCRIPTION	FEED TYPE				
2-2151025-1	F	FINE CRIMP HEIGHT ADJUST	MECHANICAL				
2-2151025-2	F	FINE CRIMP HEIGHT ADJUST	PNEUMATIC				
7-2151025-7	B	CRIMP TOOLING KIT	-				

PACIFIC VERSION TERMINATOR  
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.29 mm [.090]	F
INSUL	5.08 mm [.200]	F
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION

TERMINAL NAME: PIN AND SOCKET UNIVERSAL MATE-N-LOK

WIRE STRIP LENGTH 3.99-4.75 mm [1.57-.187 IN]	INSULATION DIAMETER RANGE Ø3.30-5.08 mm [1.130-.200 IN]
--	--

TERMINAL APPLICATION SPECIFICATION	114-1010	-	-
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TERMINALS APPLIED

TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
350537-1	350537-7	350538-3	350700-2
350537-2	1-350537-2	350538-6	350700-3
350537-3	350538-1	350538-7	350700-7
350537-6	350538-2	350700-1	1-350700-1
			2238103-1

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
14 AWG	1.75+/-0.05 [0.069+/-0.002]	4.1
DOUBLE 2@18AWG	1.60+/-0.05 [0.063+/-0.002]	5.7
1.50mm2	1.52+/-0.05 [0.060+/-0.002]	6.5
16 AWG	1.50+/-0.05 [0.059+/-0.002]	6.7
1.00mm2	1.42+/-0.05 [0.056+/-0.002]	7.5
18 AWG	1.32+/-0.05 [0.052+/-0.002]	8.6
20 AWG	1.19+/-0.05 [0.047+/-0.002]	10.0

**\*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.

- 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.

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

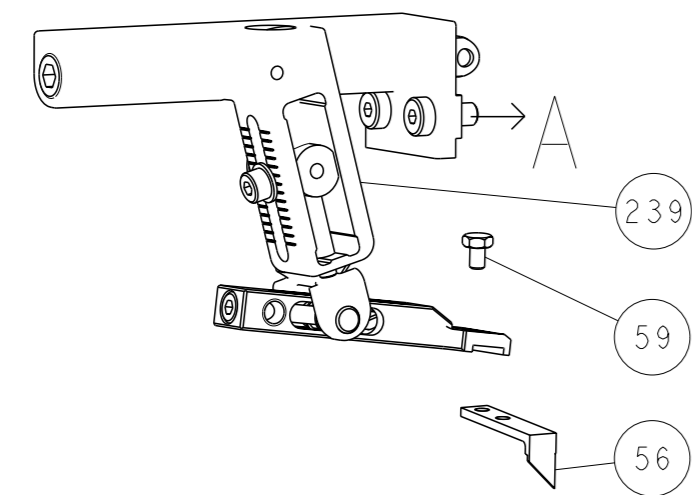
-	1	1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244	
-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243	
3	-	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	-	1	1	18023-1	SCR, SKT HD CAP M3 X 5.0	241
-	-	1	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	1	-	1	2844940-1	AIR FEED MODULE	238
-	REF	REF	1	994970-2	COUNTER, MAGNETIC	164
-	1	-	1	2119641-2	FEED CAM, AIR FEED	151
-	1	1	1	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	144
-	4	4	1	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	143
-	-	1	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	455888-6	SPACER, CRIMPER	82
-	1	1	1	22278-9	SPRING, COMPRESSION	77
-	1	1	1	854769-2	HOLDER, INS	74
-	1	1	1	1803607-3	DOCUMENTATION PACKAGE	71
-	1	1	1	2119740-1	TAG, IDENTIFICATION	67
-	2	2	1	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	21028-2	PIN, SLOTTED SPRING .062 X .250	58
-	1	1	1	1338685-1	PAWL, FEED	56
-	2	2	1	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	53
-	1	1	1	1803382-6	HOLD DOWN, SPRING LOADED	50
-	1	2	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	-	1	1	2119652-1	FEED CAM, PRE FEED	48
-	1	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
-	1	1	1	1752356-6	SUPPORT, TERMINAL	34
-	2	2	1	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	1	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	1	1-18028-2	WASHER, FLAT, REG M4	20
-	1	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	462006-6	FLOATING SHEAR, FRONT	9
1	1	1	1	1-1333205-1	ANVIL, COMBINATION	8
-	1	1	1	240641-5	SPACER	7
-	1	1	1	1-2119780-4	DEPRESSOR, SHEAR	5
-	1	1	1	238011-4	BLOCK, CRIMPER SPACER	4
1	1	1	1	5-1803016-4	CRIMPER, INSULATION F	3
-	1	1	1	455888-3	SPACER, CRIMPER	2
1	1	1	1	8-456406-1	CRIMPER, WIRE PREMIUM	1
-77	-22	-21		PART NO	DESCRIPTION	ITEM NO

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

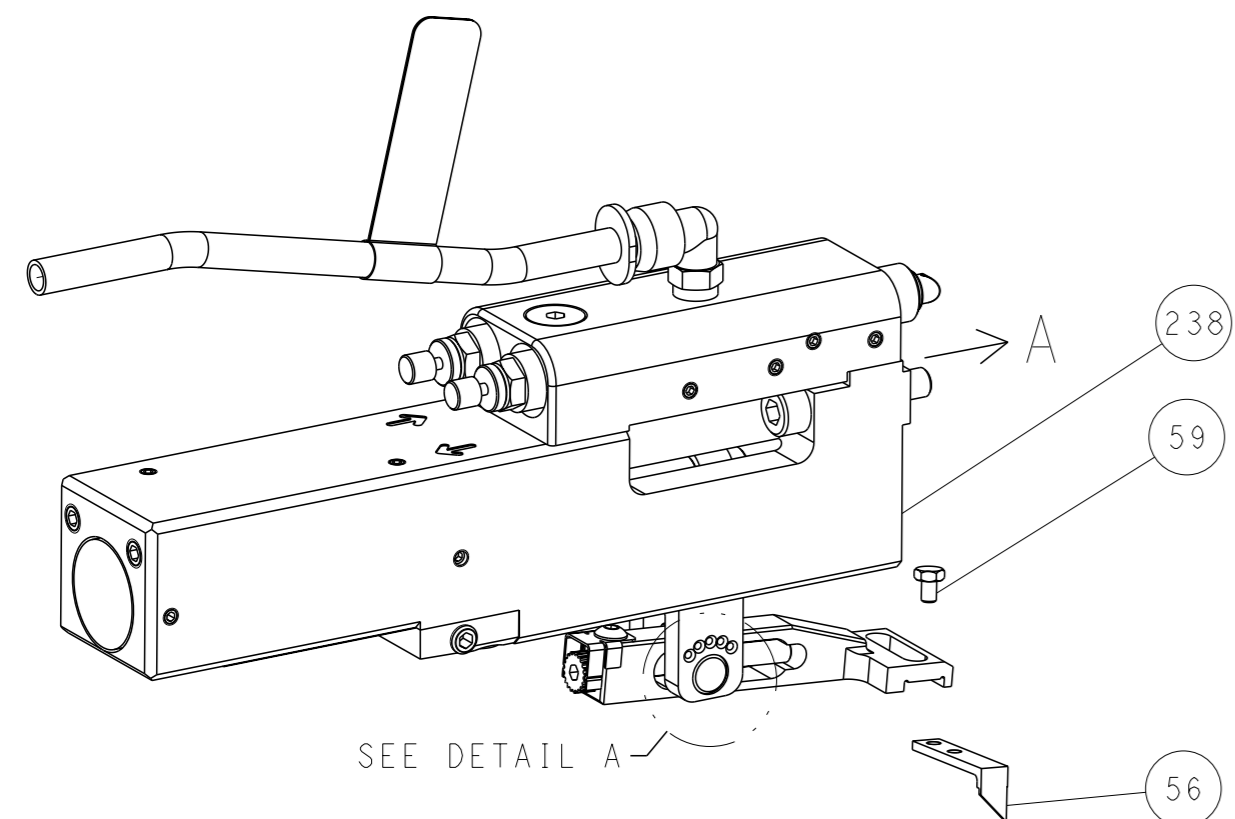
<small>THE DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE AND THE CUSTOMER IS RESPONSIBLE FOR VERIFYING THE DIMENSIONS AND TOLERANCES OF THE PARTS TO BE ORDERED. CONTACT THE SUPPLIER FOR THE LATEST REVISION.</small>		OWN: H. STAKEM 10OCT2011 CHK: G. BAILEY 10OCT2011 APVD: J. ELBIN 10OCT2011	NAME: TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH ±	TOLERANCES UNLESS OTHERWISE SPECIFIED: ±	PRODUCT SPEC APPLICATION SPEC WEIGHT: - SCALE: 1:2	SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2151025 RESTRICTED TO: - SCALE: 1:2 SHEET 3 OF 4 REV F1
MATERIAL: -		Customer Accessible Production Drawing	

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

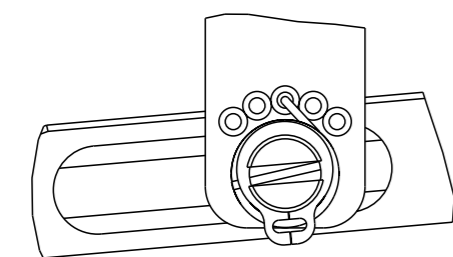
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# PNEUMATIC

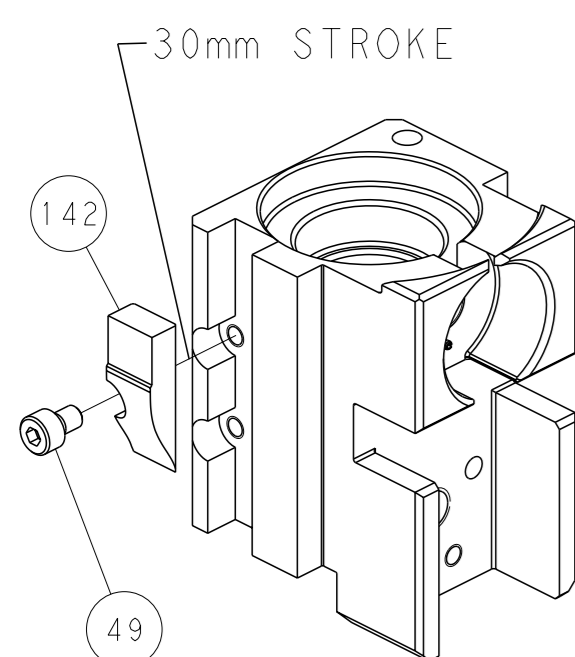


FEED SPRING SETTING POSITION  
(SHOWN FROM REAR SIDE)

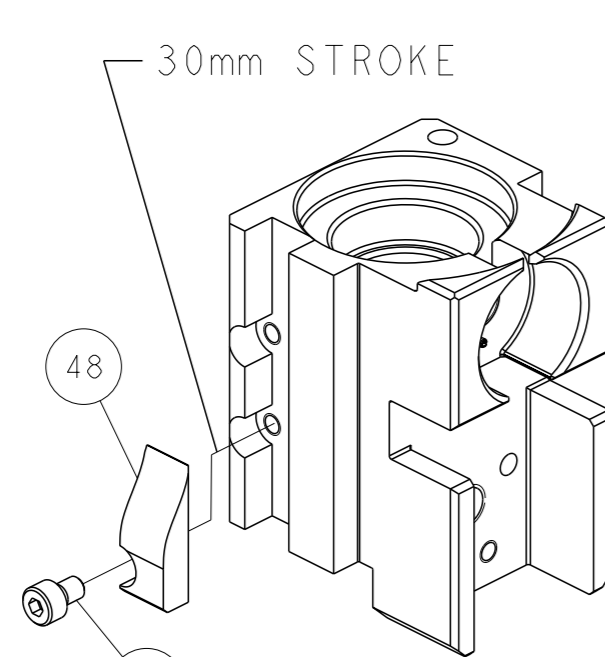


DETAIL A

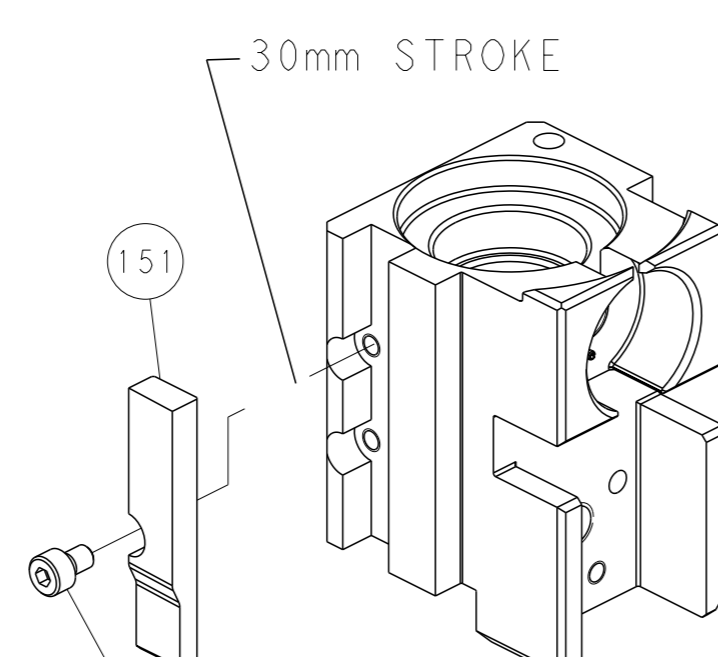
# CAM POSITIONS



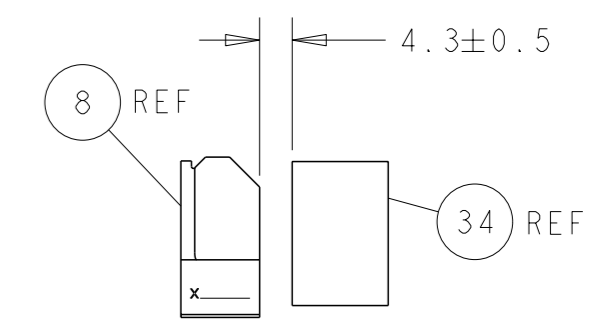
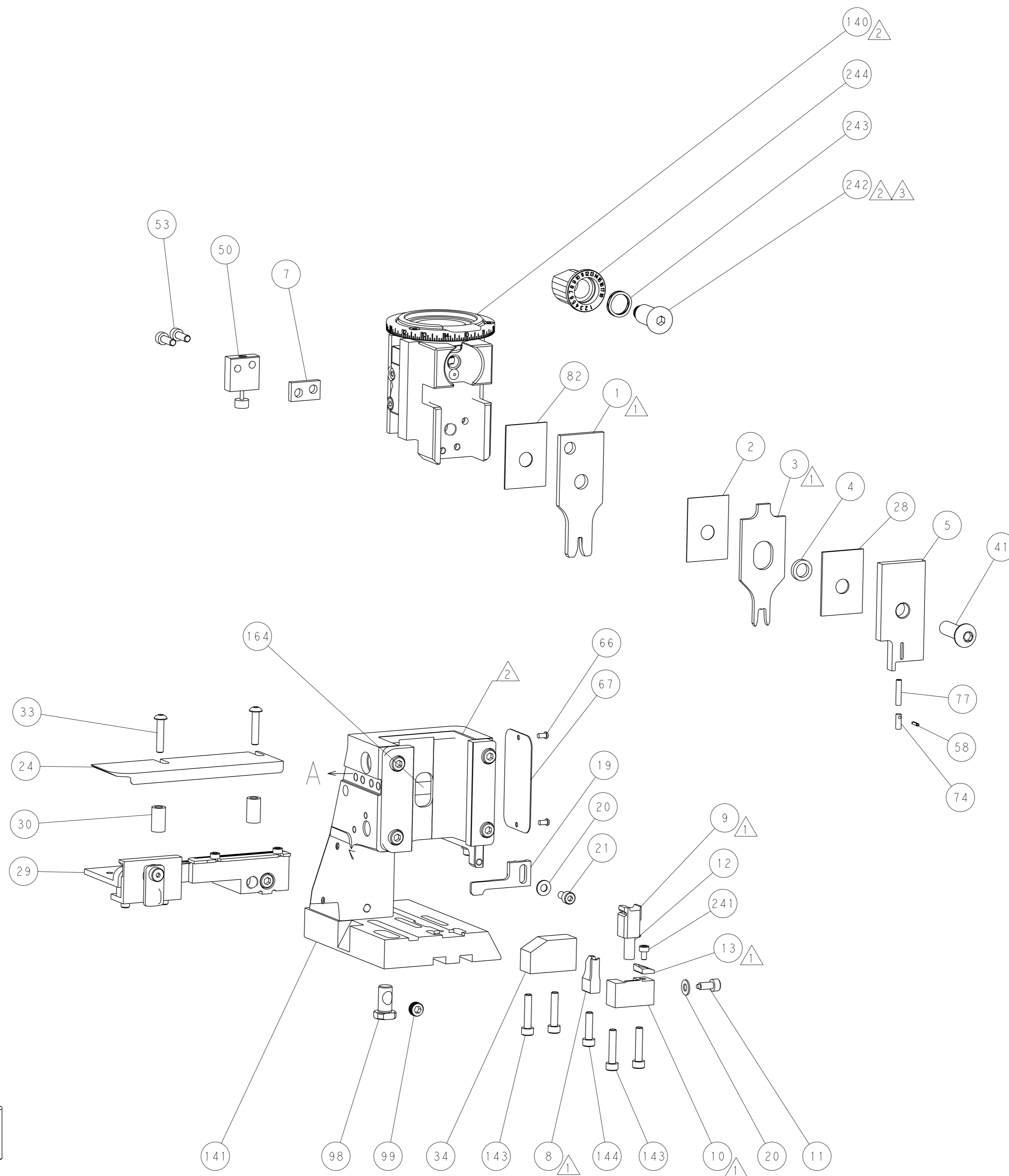
MECHANICAL  
POST FEED



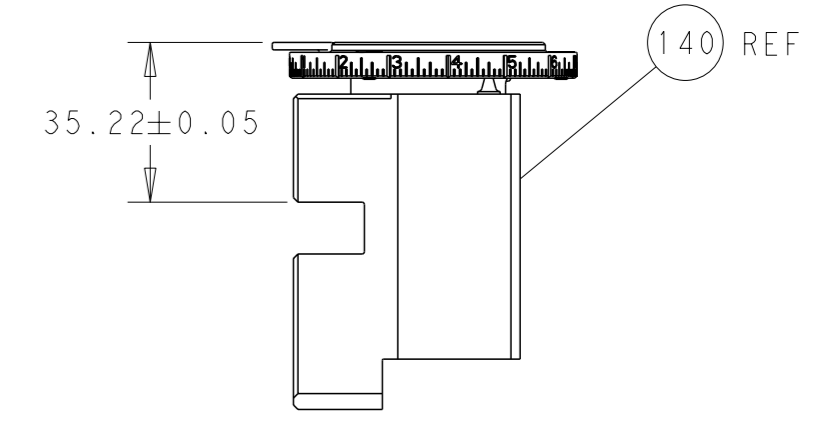
MECHANICAL  
PRE FEED



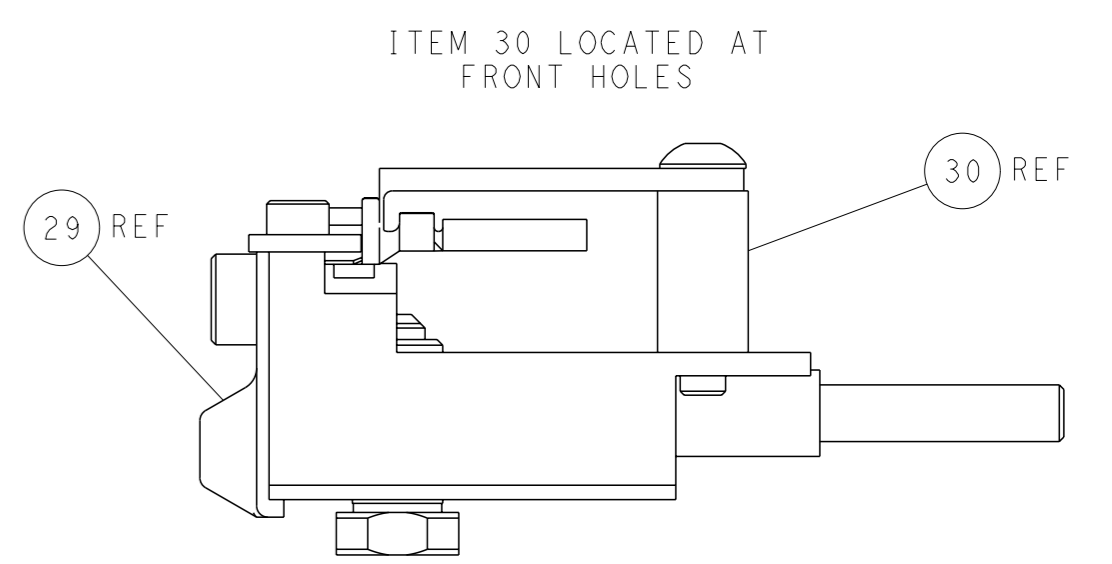
AIR FEED



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)

<small>THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE AND THE USER'S RESPONSIBILITY TO OBTAIN THE LATEST REVISION. SHOULD BE CONTACTED FOR THE LATEST REVISION.</small>		OWN: H. STAKEM CHK: G. BAILEY APVD: J. ELBIN PRODUCT SPEC: - APPLICATION SPEC: - MATERIAL: - FINISH: -	100CT2011 100CT2011 100CT2011 NAME: Ocean Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2151025 SCALE: 1:2 SHEET: 4 of 4 REV: F1	TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH ±		WEIGHT: - Customer Accessible Production Drawing	RESTRICTED TO: -	SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

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