

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151166-1	M	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2151166-2	M	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
3-2151166-2	M	FINE CRIMP HEIGHT ADJUST	DOUBLE ACTING PNEUMATIC WITH SENSORS
5-2151166-1	M	SEAL STRIPPER CRIMPER TERMINATING UNIT	MECHANICAL
5-2151166-2	M	SEAL STRIPPER CRIMPER TERMINATING UNIT	PNEUMATIC
7-2151166-7	D	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA

CRIMP	SIZE	TYPE
WIRE	2.54 mm [.100]	F
INSUL	3.56 mm [.140]	OV

APPLICATOR INSTRUCTIONS 408-35042

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION

TERMINAL NAME: TE MCP 2.8 FLAT TYPE RECEPTACLE

WIRE STRIP LENGTH	INSULATION DIAMETER RANGE
4.50-5.10 [.177-.201 IN]	∅ 2.20-3.00 [.087-.118 IN]

TERMINAL APPLICATION SPECIFICATION 114-18148

TERMINALS APPLIED

TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
1-968851-1	1-968851-2	1-968851-3	1-1355877-1

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION

TERMINAL NAME: TE MCP 2.8 FLAT TYPE RECEPTACLE

WIRE STRIP LENGTH	INSULATION DIAMETER RANGE
4.50-5.10 [.177-.201 IN]	∅ 2.20-3.00 [.087-.118 IN]

TERMINAL APPLICATION SPECIFICATION 114-18668

TERMINALS APPLIED

TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
1718188-1	1241582-1		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
2.50mm2	1.76+/-0.05 [.069+/-0.002]	8.2
2.00mm2 AVS	1.70+/-0.05 [.067+/-0.002]	7.8
2.00mm2 AESSX-F	1.66+/-0.05 [.065+/-0.002]	8.3
14 AWG	1.61+/-0.05 [.063+/-0.002]	9.7
1.50mm2	1.47+/-0.05 [.058+/-0.002]	11.0
1.25mm2	1.46+/-0.05 [.057+/-0.002]	11.1
16 AWG	1.36+/-0.05 [.054+/-0.002]	11.9

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
2.50mm2	1.88+/-0.05 [.074+/-0.002]	6.8
2.00mm2	1.73+/-0.05 [.068+/-0.002]	8.3
1.50mm2	1.58+/-0.05 [.062+/-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.
- 6 WHEN APPLYING TERMINALS 1-968851-1, 1-968851-2, 1-968851-3, 1-1355877-1 AND 1241582-1 USE ITEM 34 PN 1-1752356-3 TERMINAL SUPPORT.
- 7 WHEN APPLYING TERMINAL 1718188-1 USE ITEM 272 PN 1752356-6 TERMINAL SUPPORT.
- 8 TERMINAL LUBRICANT IS RECOMMENDED.
- 9 THIS APPLICATOR IS EQUIPPED WITH THE DOUBLE ACTING FEED WITH SENSORS AND IS APPLICATION SPECIFIC. IT DOES NOT REQUIRE ITEMS 49 & 248

LOC	DIST	REV	DATE	BY	APPV
A	66	K	13FEB2023	MEH	GB
		L	15NOV2023	TB	JAH
		L1	31JUL2024	TB	RK
		M	24SEP2024	MEH	GB

-	1	1	1	1	1	1803945-4	TONKER -	300
-	1	1	1	1	1	22278-9	SPRING, COMPRESSION	299
-	2	2	2	2	2	4-18032-3	SCR, SET, FLT PNT, M3 X 6.0	298
-	1	1	1	1	1	1803944-1	SPACER, TONKER	297
-	1	1	-	-	-	2-1803583-1	APPLICATOR BASIC ASSEMBLY, SF	292
-	-	-	1	-	-	2844950-1	AIR FEED MODULE	290
7	-	1	1	1	1	1752356-6	SUPPORT, TERMINAL	272
9	-	1	-	-	-	2119641-1	FEED CAM, AIR FEED	248
-	1	1	1	1	1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
3	-	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	1	1	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
-	-	1	-	-	-	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	1	-	-	1	-	2844940-1	AIR FEED MODULE	238
-	REF	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
8	-	1	1	1	1	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113
-	1	1	1	1	1	2844908-1	SCREW, LOCKING	99
-	1	1	1	1	1	2844907-1	POST, LOCKING	98
-	1	1	1	1	1	455888-6	SPACER, CRIMPER -	82
-	1	1	1	1	1	1803607-3	DOCUMENTATION PACKAGE	71
-	1	1	1	1	1	2119740-1	TAG, IDENTIFICATION	67
-	2	2	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	1	1	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	60
-	1	1	1	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	1	1	1	1	1	1338685-1	PAWL, FEED	56
-	4	4	4	4	4	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	54
-	2	2	2	2	2	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	53
-	1	2	-	1	2	18023-9	SCR, SKT HD CAP M4 X 6.0	49
9	-	1	-	-	-	2119652-1	FEED CAM, PRE FEED	48
-	-	1	-	-	-	2119653-1	FEED CAM, POST FEED	47
-	-	-	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	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
6	-	1	1	1	1	1-1752356-6	SUPPORT, TERMINAL	34
-	2	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	2	2	2	3-2844962-0	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	1	1	1	2844992-2	ASSEMBLY, STRIP GUIDE -	29
-	1	1	1	1	1	1-455888-6	SPACER, CRIMPER -	28
-	1	1	1	1	1	1320928-2	STRIP GUIDE -	24
-	-	-	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
-	1	1	2	2	2	1-18028-2	WASHER, FLAT, REG M4	20
-	-	-	1	1	1	2119533-1	STRIPPER, SIDE FEED	19
1	-	1	1	1	1	2119806-1	INSERT, SHEAR	13
-	1	1	1	1	1	3-22280-3	SPRING, COMPRESSION	12
-	1	1	1	1	1	1-356885-4	STOP, SHEAR	11
1	-	1	1	1	1	2119805-1	SHEAR HOLDER, FRONT -	10
1	-	1	1	1	1	454276-5	FLOATING SHEAR, FRONT	9
1	1	1	1	1	1	1333206-8	ANVIL, COMBINATION .100	8
-	1	1	1	1	1	1-240641-7	SPACER	7
-	-	-	-	-	-	-	-	6
-	1	1	1	1	1	2119757-4	DEPRESSOR, SHEAR	5
-	1	1	1	1	1	1-238011-0	BLOCK, CRIMPER SPACER	4
1	1	1	1	1	1	2119785-6	CRIMPER, INSULATION OVERLAP PREMIUM	3
-	1	1	1	1	1	455888-7	SPACER, CRIMPER -	2
1	1	1	1	1	1	2-1722335-2	CRIMPER, WIRE	1

ITEM NO	PART NO	DESCRIPTION						
-77	-52	-51	-32	-2	-1	PART NO	DESCRIPTION	ITEM NO

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OWN: X ZHAO 26 JUL 2011
CHK: T ELBIN 26 JUL 2011
APPV: S XI 26 JUL 2011

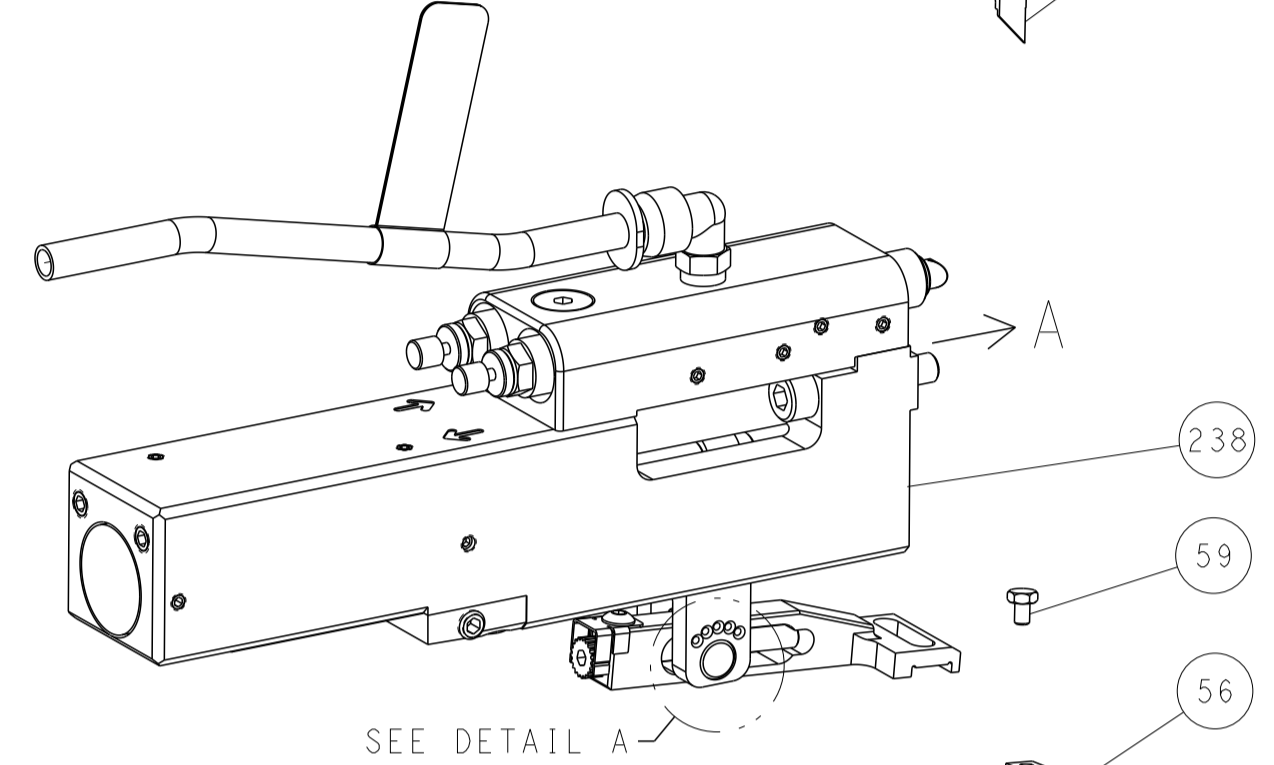
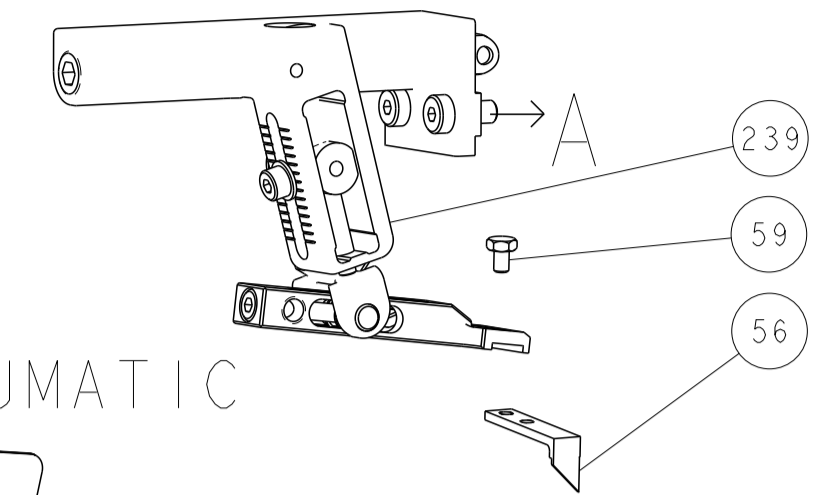
TE Connectivity
Harrisburg, PA 17105-3608

Ocean Side Feed
Applicator

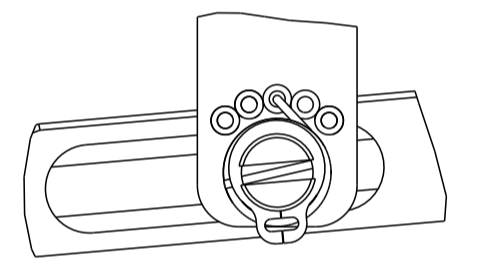
Customer Accessible Production Drawing SCALE 1:2 SHEET 1 OF 4 REV M

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

FEED TYPE MECHANICAL

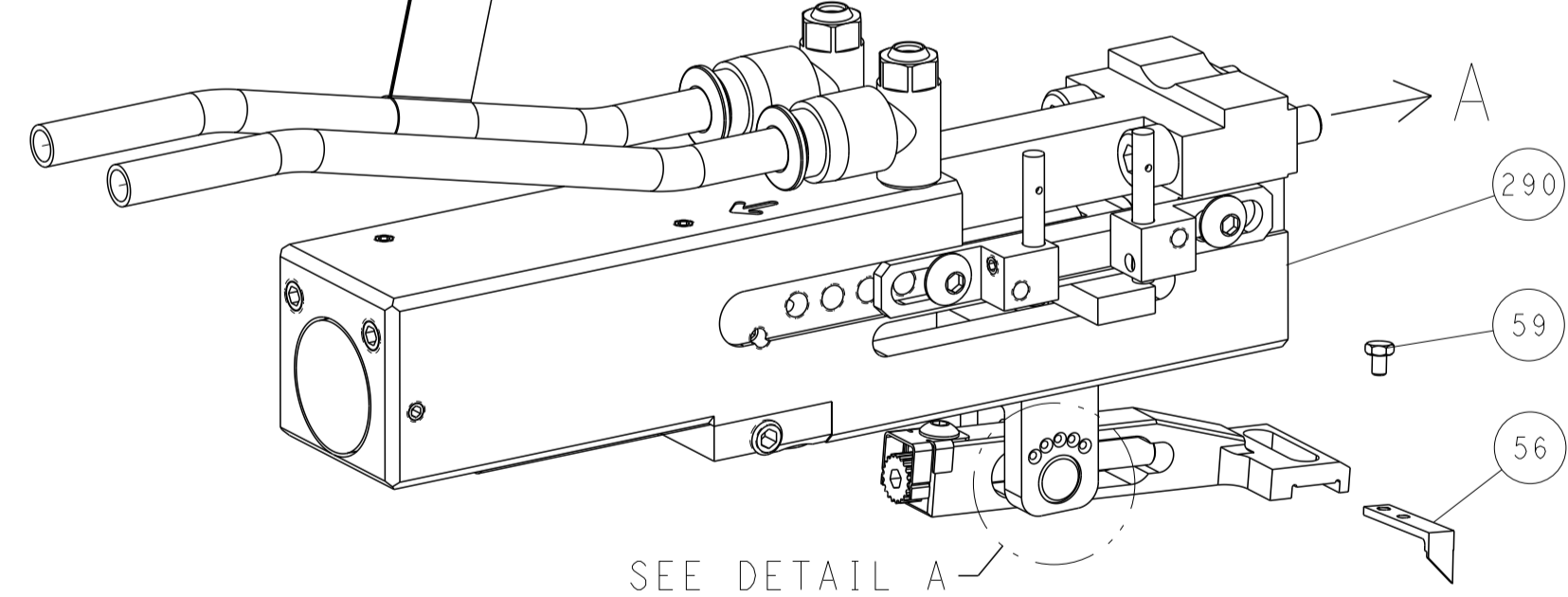


FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)

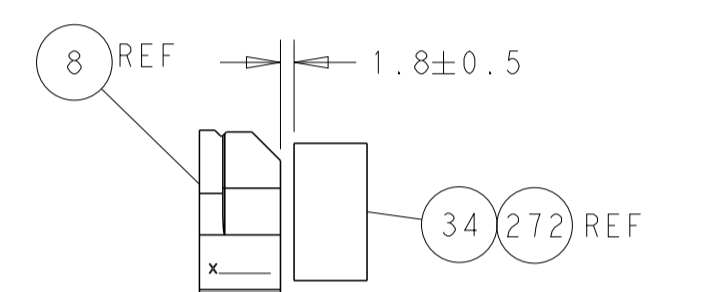
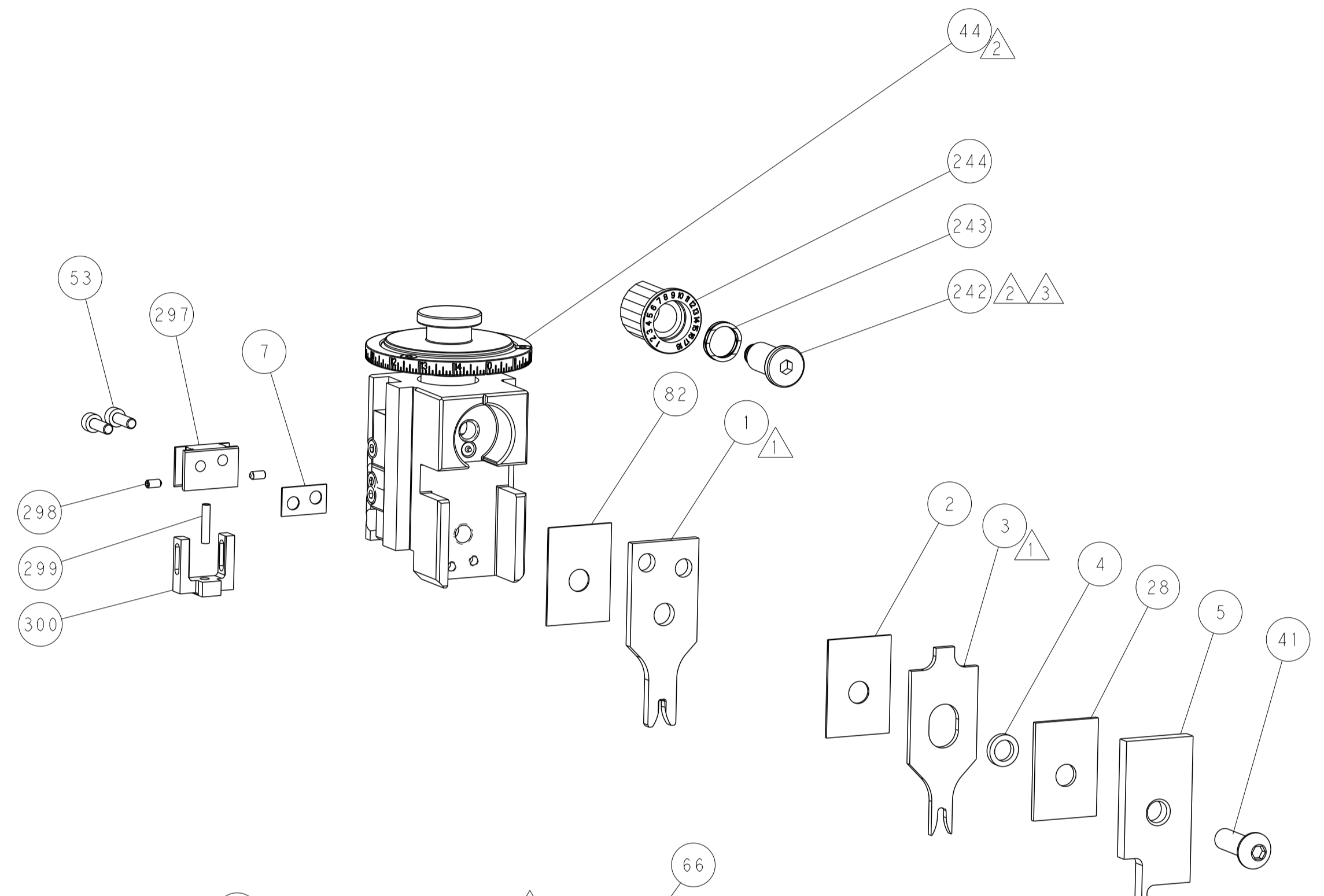
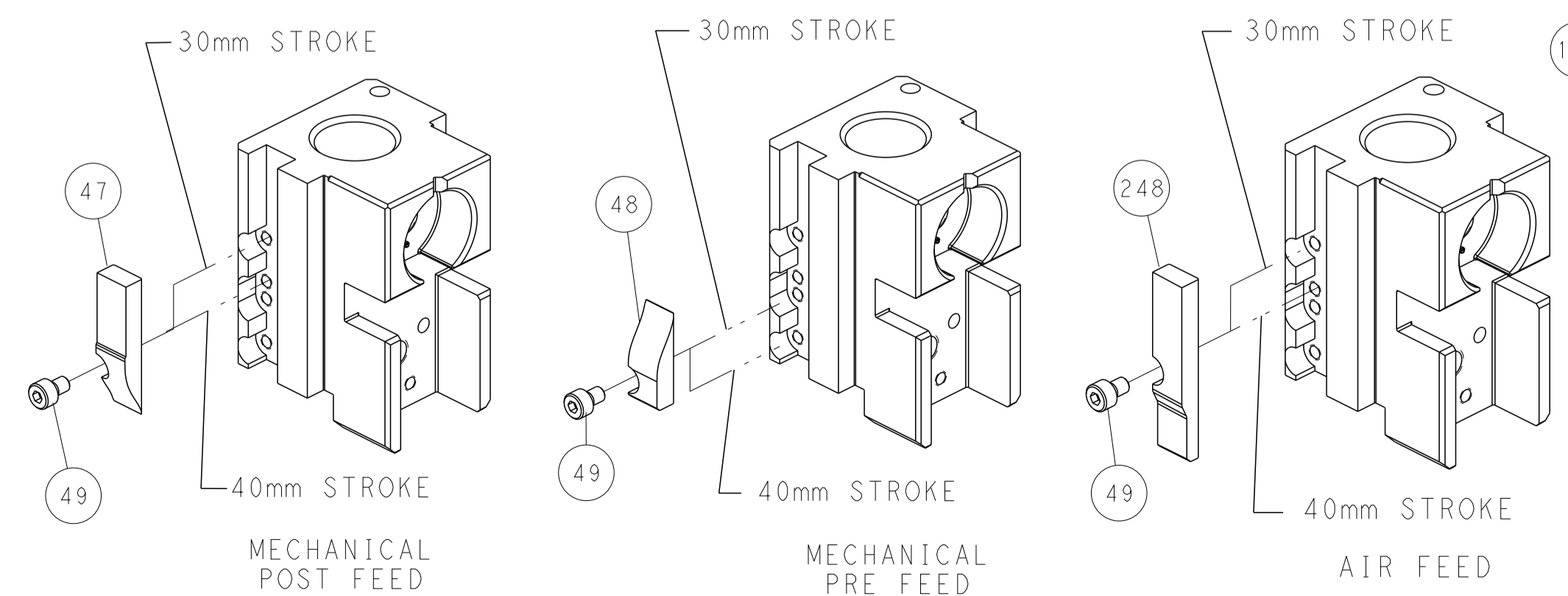


DETAIL A

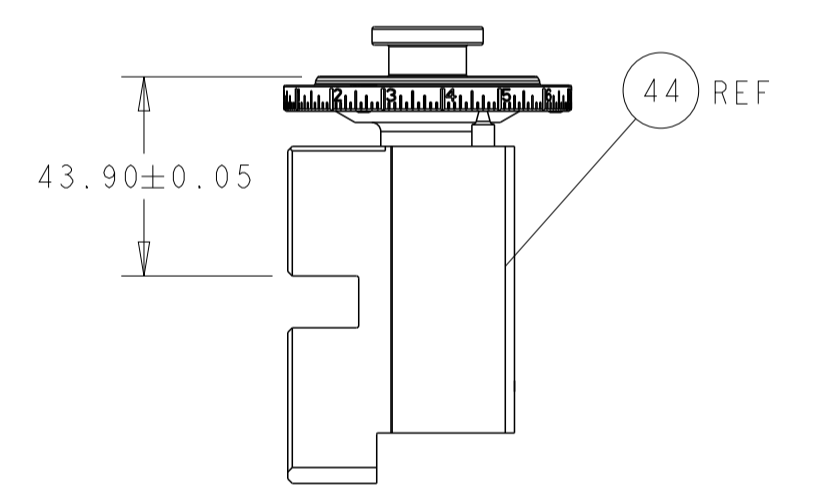
DOUBLE ACTING PNEUMATIC WITH SENSORS



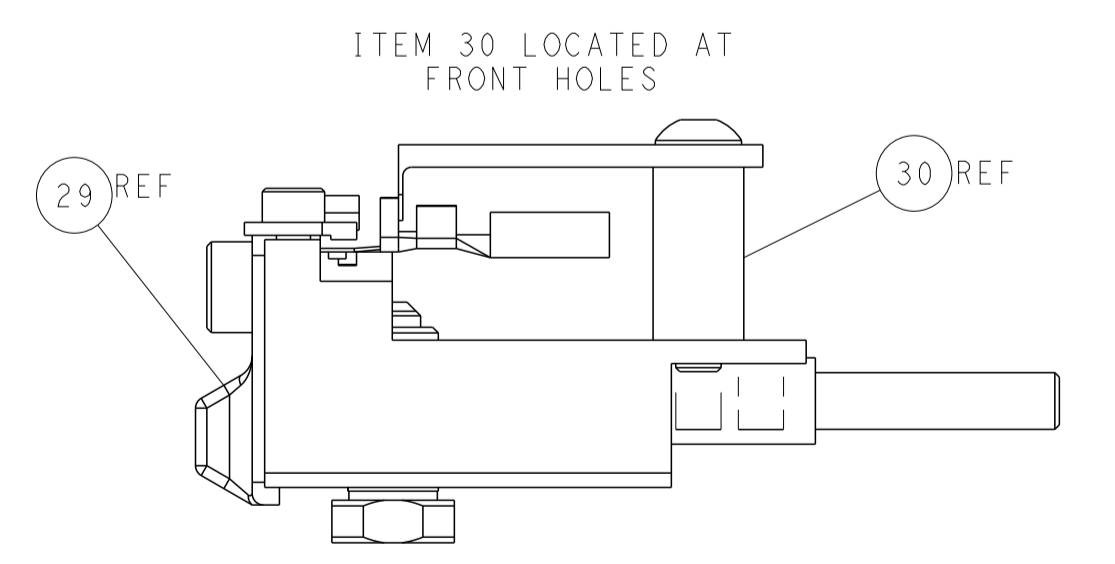
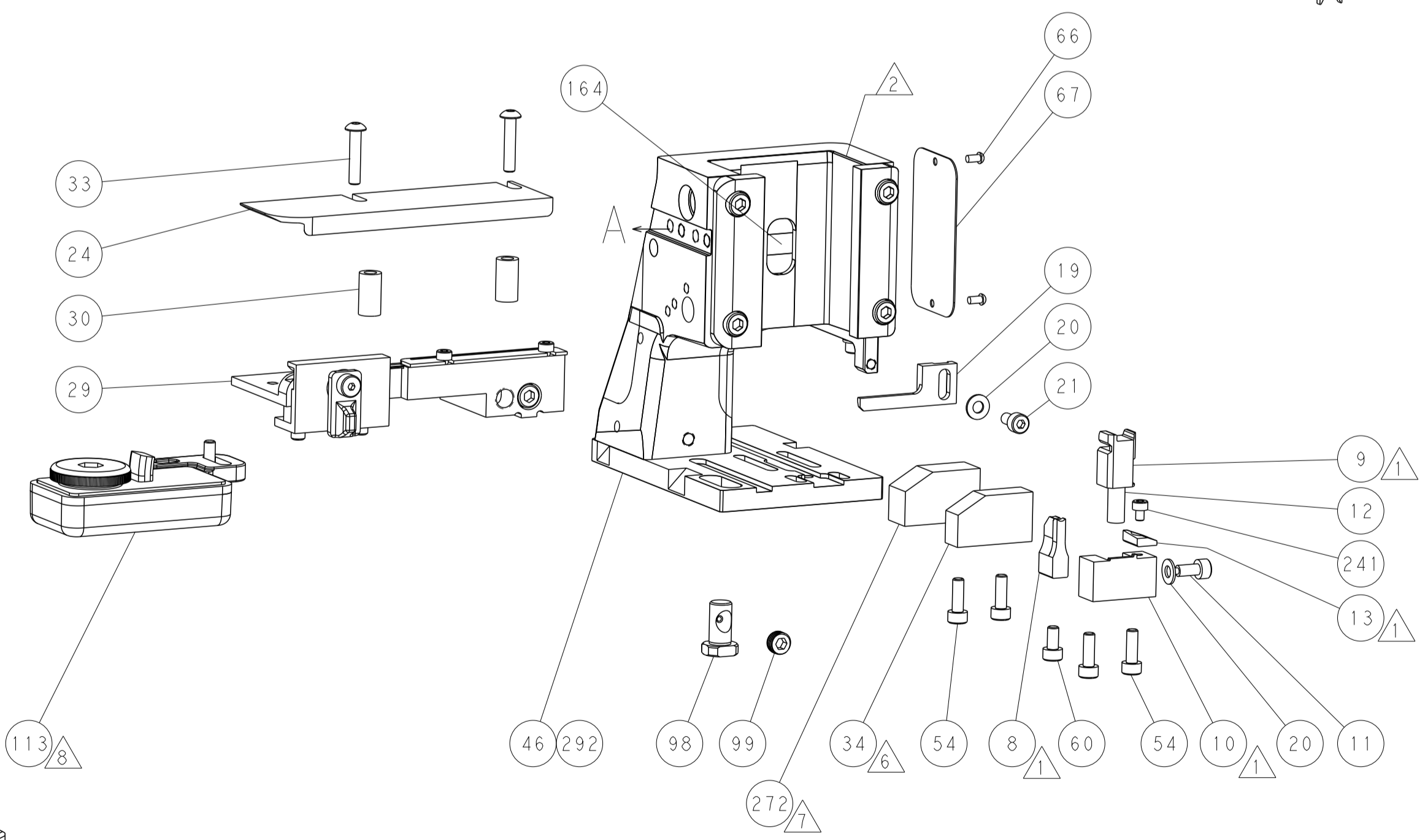
CAM POSITIONS



TERMINAL SUPPORT LOCATION



RAM SET-UP



FEED TRACK POSITION GUIDE BY INSULATION BARREL

DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH		DWN X ZHAO 26 JUL 2011 CHK T. ELBIN 26 JUL 2011 APVD S. XI 26 JUL 2011 PRODUCT SPEC APPLICATION SPEC WEIGHT SCALE 1:2		NAME Ocean Side Feed Applicator SIZE CAGE CODE DRAWING NO. RESTRICTED TO A1 00779 C=2151166 SHEET 2 OF 4 REV M	
MATERIAL:				Customer Accessible Production Drawing			