

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151346-1	L	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2151346-2	L	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
5-2151346-1	L	SEAL STRIPPER CRIMPER TERMINATING UNIT	MECHANICAL
5-2151346-2	L	SEAL STRIPPER CRIMPER TERMINATING UNIT	PNEUMATIC
7-2151346-7	J	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.54 mm [.100]	F
INSUL	4.19 mm [.165]	O

APPLICATOR INSTRUCTIONS
408-35042

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: 2.8MM FLAT TYPE RECEPTACLE			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
4.70-5.30 mm [.185-.209 IN]		3.40 [.134 IN MAX]	5
TERMINAL APPLICATION SPECIFICATION	(A)114-18144-0 (B)114-18144-1		
TERMINALS APPLIED 7			
TE TERMINAL	TE TERMINAL	TE SEAL	TE SEAL
(A) 967543-1	(B) 968088-1	828905-1	
(A) 967543-2	(B) 968088-2	828904-1	
(A) 967543-3	(B) 1703035-1		
	(B) 1703035-2		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: 2.8MM FLAT TYPE RECEPTACLE			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
4.70-5.30 mm [.185-.209 IN]		3.40 [.134 IN MAX]	5
TERMINAL APPLICATION SPECIFICATION	(C)114-18148		
TERMINALS APPLIED 7			
TE TERMINAL	TE TERMINAL	TE SEAL	TE SEAL
(C) 1-968857-1	(C)11-968857-3	828905-1	2236402-1 10
(C) 1-2282364-1	(C) 1-2282364-3		
(C)1-968857-2			

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: 2.8MM FLAT TYPE RECEPTACLE			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
4.70-5.30 mm [.185-.209 IN]		3.40 [.134 IN MAX]	5
TERMINAL APPLICATION SPECIFICATION	(D)114-13295		
TERMINALS APPLIED 7			
TE TERMINAL	TE TERMINAL	TE SEAL	TE SEAL
(D)1-968857-3		368941-1	

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
2.50mm2	1.76+/-0.05 [.069+/- .002]	6.1
1.50mm2	1.47+/-0.05 [.058+/- .002]	9.2

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
2.50mm2	1.76+/-0.05 [.069+/- .002]	8.3
2.00mm2 AVS	1.70+/-0.05 [.067+/- .002]	8.8
2.00mm2 AESSX-F	1.66+/-0.05 [.065+/- .002]	9.3
14 AWG	1.61+/-0.05 [.063+/- .002]	9.8
1.50mm2	1.47+/-0.05 [.058+/- .002]	11.4
1.25mm2	1.46+/-0.05 [.057+/- .002]	11.7
16 AWG	1.36+/-0.05 [.054+/- .002]	12.5

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
2.50mm2	1.88+/-0.05 [.074+/- .002]	7.1

- 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 THIS APPLICATOR APPLIES TERMINAL WITH A SEAL.

SEAL P/N	INSUL. Ø
828905-1	2.2-3.0mm
368941-1	2.7-3.0mm
828904-1	1.2-2.1mm
- 6 APPLY TORQ-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.
- 7 TERMINAL LUBRICANT IS RECOMMENDED.
- 8. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- 9 WIRE TYPES AEX-F, AESSX-F, AVS, AEX, CAVS.

***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.

10 THIS CRIMP PARAMETER IS PROVIDED TO MEET A CUSTOM AND UNIQUE CUSTOMER REQUIREMENT. IT HAS BEEN EVALUATED AND IS CONDITIONALLY SPECIFIED BY TE CONNECTIVITY. THIS CUSTOMIZED CRIMP PARAMETER IS NOT LISTED AS AN APPROVED APPLICATION WITHIN A TE CONNECTIVITY APPLICATION SPECIFICATION; HOWEVER, IT HAS BEEN VALIDATED ACCORDING TO TE CONNECTIVITY SPECIFICATIONS 109-18079 (TEST GROUP 1) AND 114-18022. **TE CONNECTIVITY EXPRESSLY DISCLAIMS ANY AND ALL WARRANTIES THAT THE PRODUCT WILL PERFORM SIMILARLY TO VALIDATED AND APPROVED APPLICATIONS, AS STATED WITHIN TE CONNECTIVITY APPLICATION SPECIFICATIONS, INCLUDING BUT NOT LIMITED TO IMPLIED WARRANTIES OF MERCHANTABILITY OR FITNESS FOR PARTICULAR PURPOSE.** AS SUCH, IT IS HIGHLY RECOMMENDED THAT THE CUSTOMER PERFORM FURTHER DETAILED EVALUATION TO ASSESS PRODUCT PERFORMANCE IN THE SPECIFIC APPLICATION.

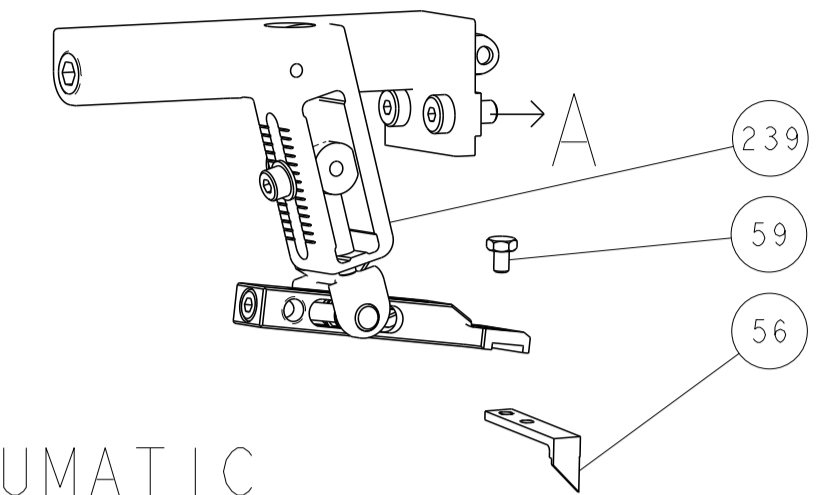
LOC	DIST	REVISIONS					
A	66	P	LTN	DESCRIPTION	DATE	OWN	APVD
		K6		ECR-23-167495	27FEB2023	FZ	JAH
		K7		ECR-23-167594	27FEB2023	JWC	TE
		L		ECR-23-183768	09AUG2023	TB	GB
		L1		ECR-24-220361	11SEP2024	ZZ	TE

-	1	1	-	-	1803515-3	RAM ASSEMBLY, SF ATLANTIC	293
-	1	1	-	-	2-1803583-1	APPLICATOR BASIC ASSEMBLY, SF	292
-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248
-	1	1	1	1	2119082-7	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
3	-	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	1	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
-	-	1	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	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
-	1	1	-	-	2-1752354-6	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	994970-2	COUNTER, MAGNETIC	164
-	1	1	1	1	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113
-	1	1	1	1	2844908-1	SCREW, LOCKING	99
-	1	1	1	1	2844907-1	POST, LOCKING	98
-	1	1	1	1	455888-3	SPACER, CRIMPER -	82
-	1	1	1	1	1803607-3	DOCUMENTATION PACKAGE	71
-	1	1	1	1	2119791-5	DEPRESSOR, WIRE	70
-	1	1	1	1	2119943-1	WASHER, SPACER	69
-	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
6	-	1	1	1	985575-3	SCR, FLT SKT HD CAP M3 X 10.0	57
-	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	1803583-9	APPLICATOR BASIC ASSEMBLY, SF	46
-	-	-	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	1752356-4	SUPPORT, TERMINAL	34
-	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	2	2	3-2844962-0	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	1	1	2844992-2	ASSEMBLY, STRIP GUIDE -	29
-	1	1	1	1	455888-3	SPACER, CRIMPER -	28
-	1	1	1	1	1320928-2	STRIP GUIDE -	24
-	-	-	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
-	1	1	2	2	1-18028-2	WASHER, FLAT, REG M4	20
-	-	-	1	1	2119533-1	STRIPPER, SIDE FEED	19
7	-	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
8	-	1	1	1	2119805-1	SHEAR HOLDER, FRONT -	10
8	-	1	1	1	318707-1	FLOATING SHEAR, FRONT	9
8	1	1	1	1	1333206-1	ANVIL, COMBINATION .100	8
-	1	1	1	1	240641-9	SPACER	7
-	-	-	-	-	-	-	6
-	1	1	1	1	2119781-1	DEPRESSOR, SHEAR	5
-	1	1	1	1	238011-4	BLOCK, CRIMPER SPACER	4
9	1	1	1	1	6-1633996-1	CRIMPER, INSULATION SPECIAL	3
-	1	1	1	1	455888-8	SPACER, CRIMPER -	2
9	1	1	1	1	456407-5	CRIMPER, WIRE PREMIUM	1

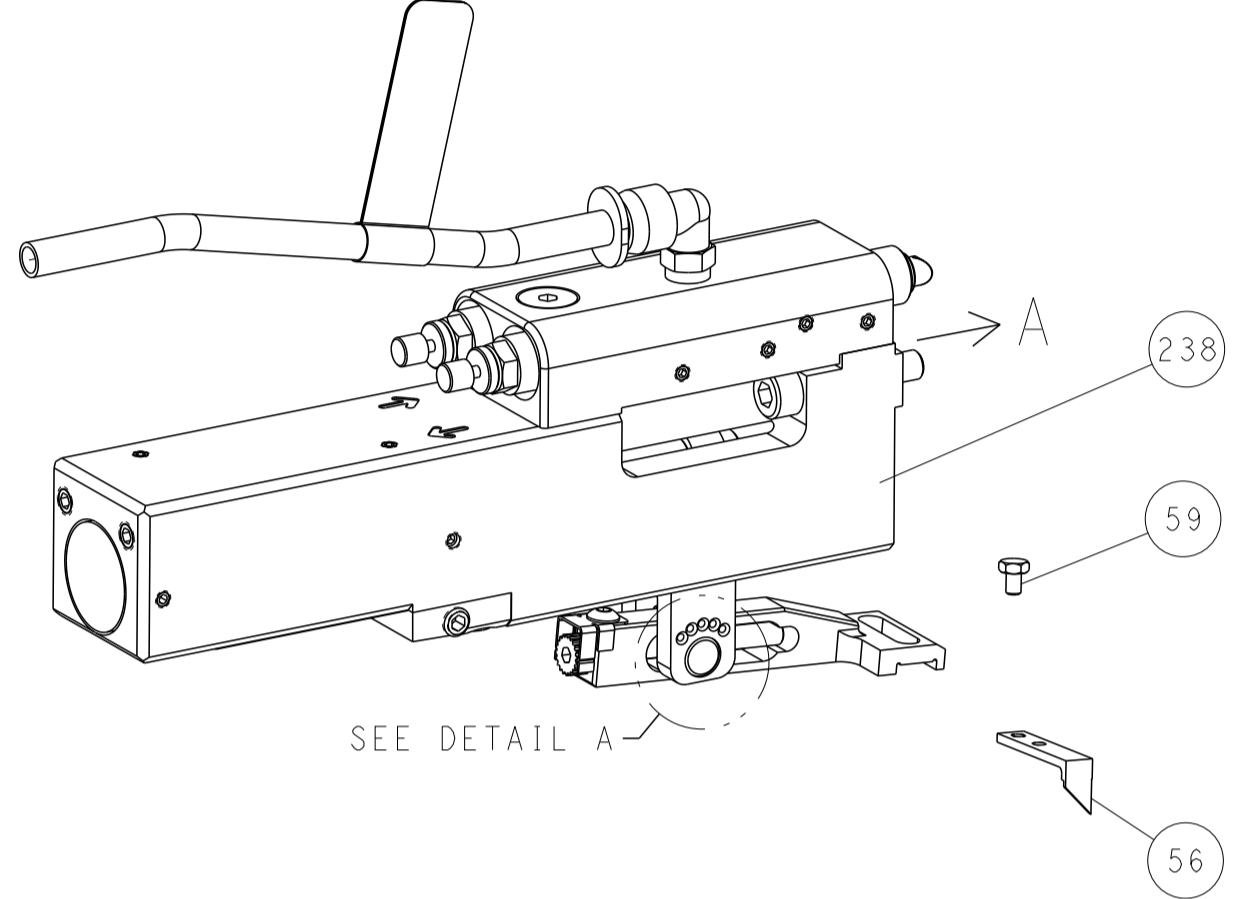
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		OWN	CHK	APVD	DATE	NAME		RESTRICTED TO
mm	0 PLC ±	1 PLC ±	2 PLC ±	H. HUANG	S. XI	I. CRUZ	14NOV2011	Ocean Side Feed Applicator		
	3 PLC ±	4 PLC ±	ANGLES ±					Customer Accessible Production Drawing		
MATERIAL	FINISH	WEIGHT	SCALE	SHEET		REV				
			1:2	1 of 4		L1				

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

FEED TYPE MECHANICAL



PNEUMATIC

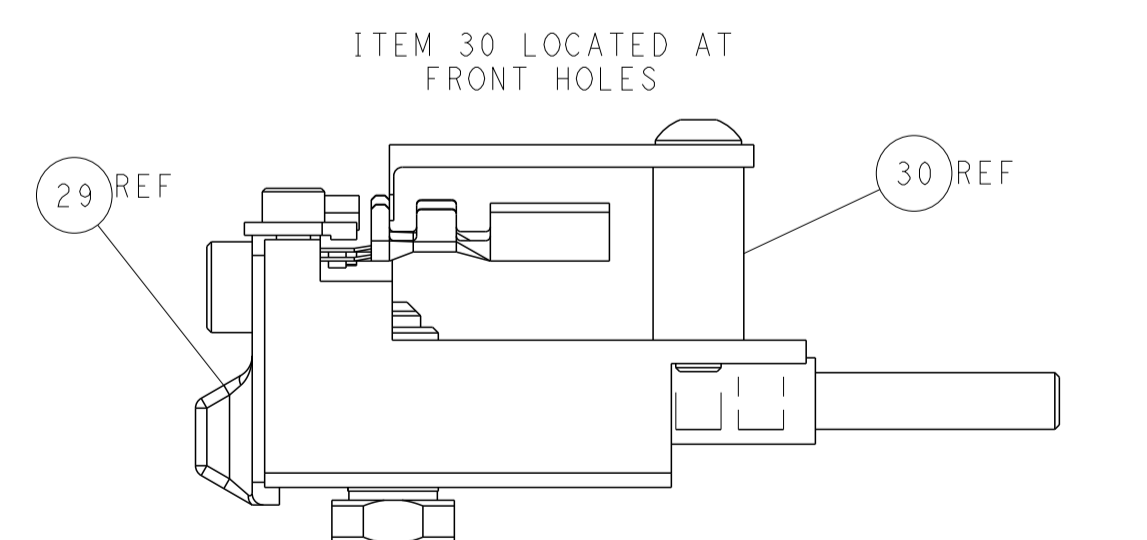
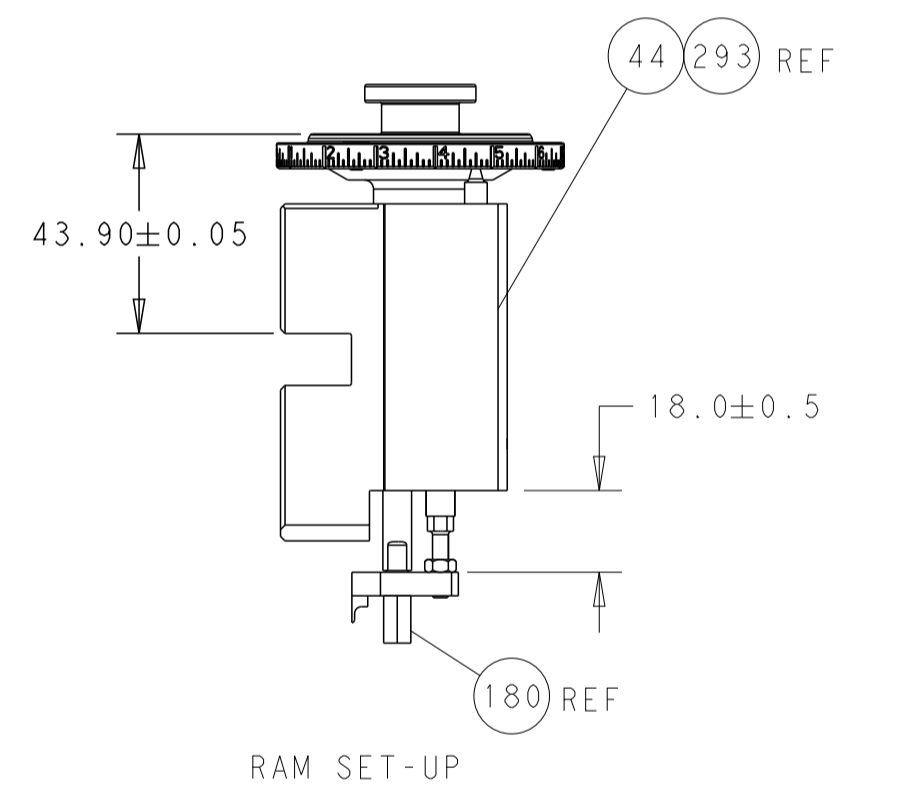
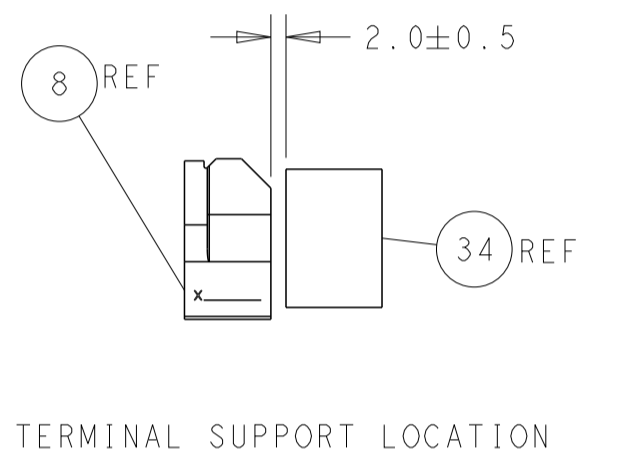
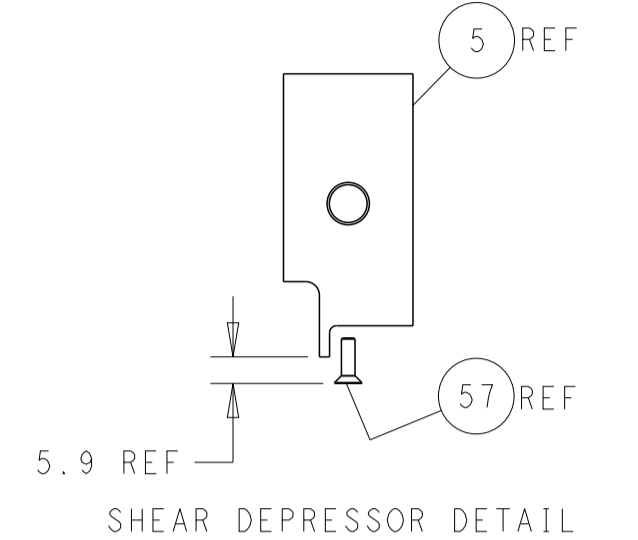
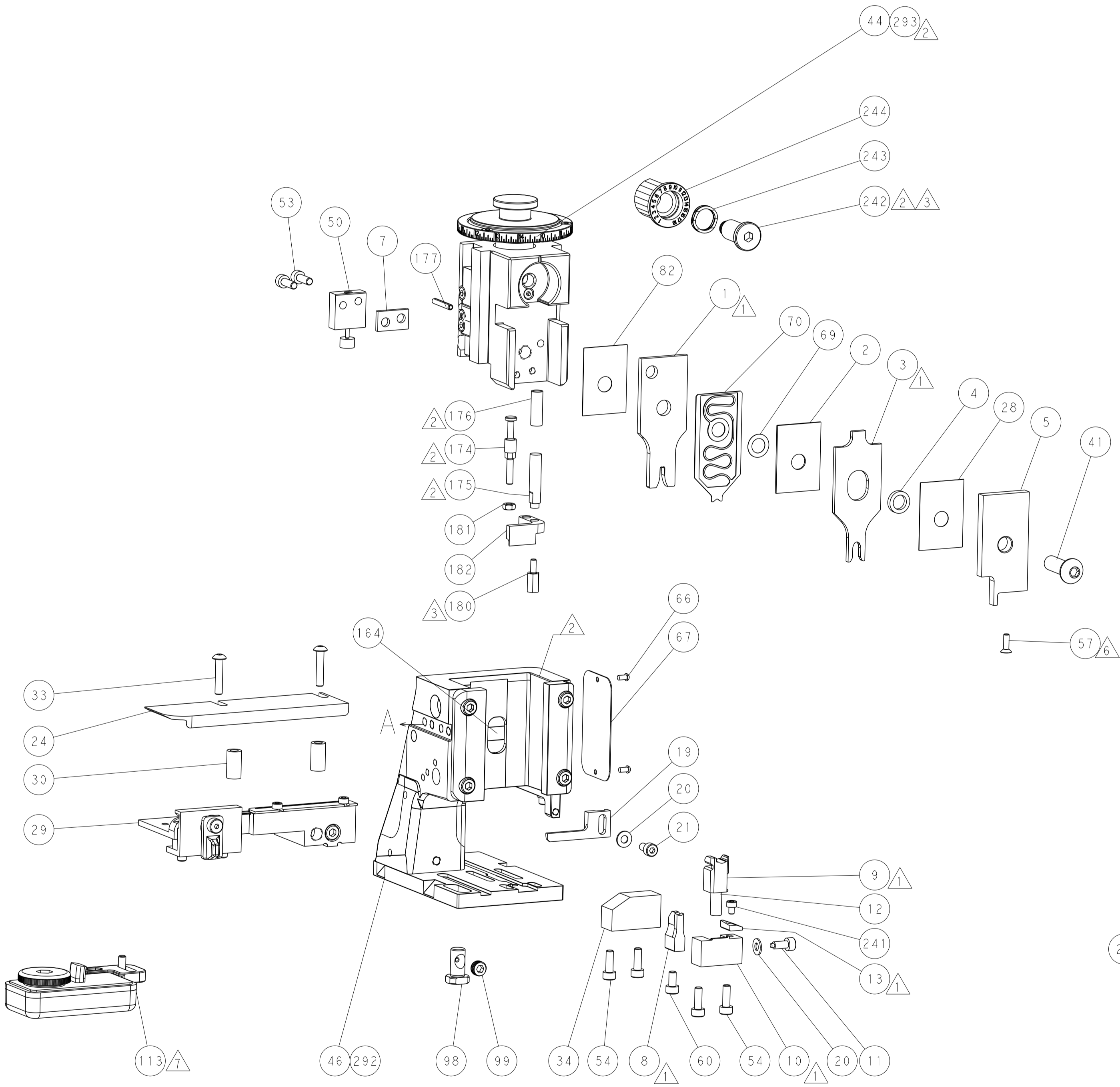
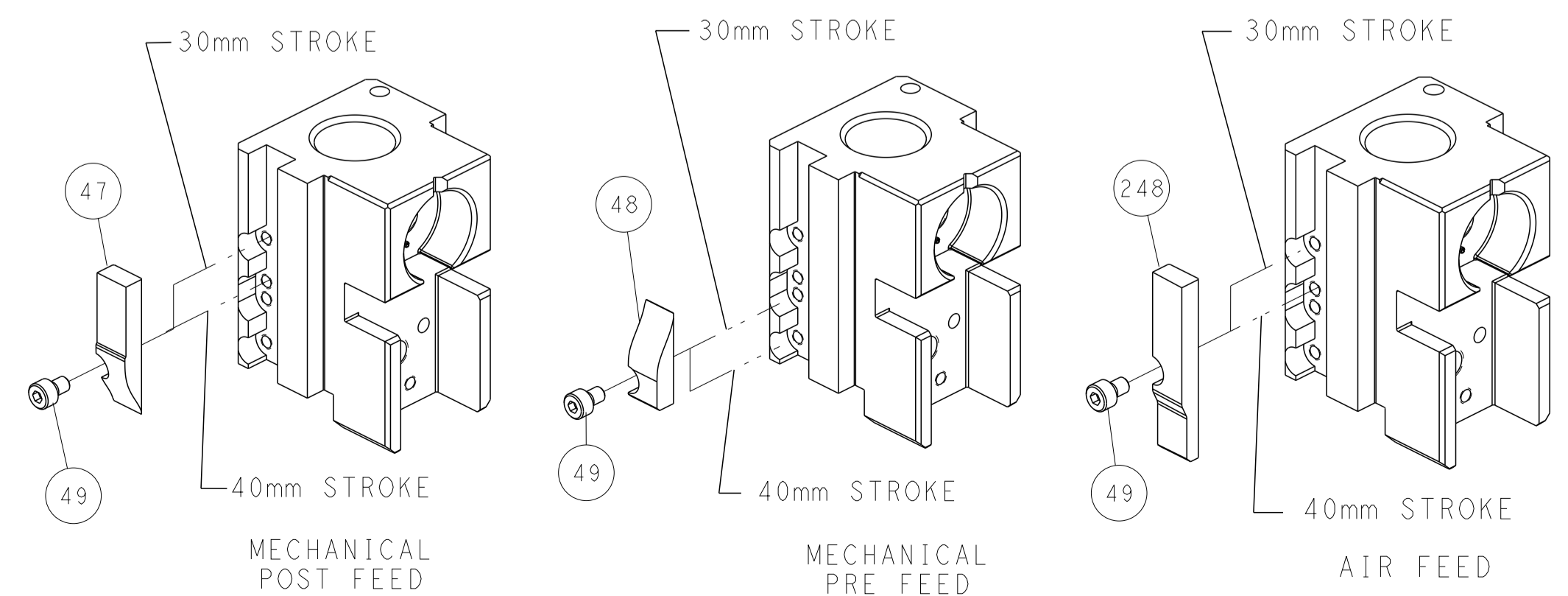


FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



DETAIL A

CAM POSITIONS



DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH ±		DWN: R. HUANG 14NOV2011 CHK: S. XI 14NOV2011 APVD: J. CRUZ 14NOV2011 PRODUCT SPEC APPLICATION SPEC WEIGHT SCALE: 1:2	NAME: Ocean Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2151346 SHEET 2 OF 4 REV L1	TE Connectivity Harrisburg, PA 17105-3608
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