

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151042-1	M	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2151042-2	N	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
5-2151042-1	N	SEAL STRIPPER CRIMPER TERMINATING UNIT	MECHANICAL
5-2151042-2	N	SEAL STRIPPER CRIMPER TERMINATING UNIT	PNEUMATIC
7-2151042-7	H	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.27 mm [.050]	F
INSUL	1.78 mm [.070]	O

APPLICATOR INSTRUCTIONS  
408-35042

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: 1.2MM CONTACT ASSEMBLY			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
3.00-3.60 mm [.118-.142 IN]		Ø1.10-1.75 mm [.043-.069 IN]	
TERMINAL APPLICATION SPECIFICATION	114-18464		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
1452653-1	1452653-2	1452653-3	7-1452653-1
7-1452653-2	7-1452653-3	1718348-1	1718348-2
1718348-3	7-1718348-1	7-1718348-2	7-1718348-3

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
22 AWG	0.83+/-0.03 [.033+/- .001]	8.7
0.35mm2	0.78+/-0.03 [.031+/- .001]	9.2
24 AWG	0.75+/-0.03 [.030+/- .001]	9.5

- 1 RECOMMENDED SPARE PARTS
- 2 REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICANTION & STORAGE OF APPLICATOR.
- 3 APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242. APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 180.
- 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 TERMINAL LUBRICANT IS RECOMMENDED.

\*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.

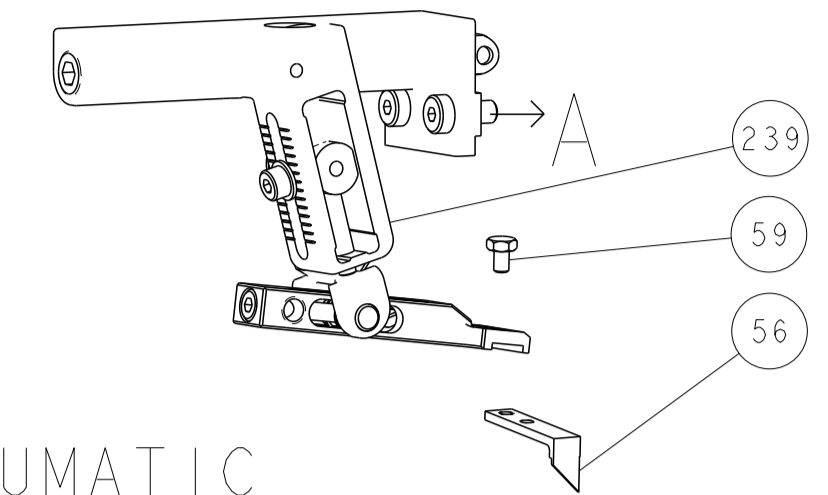
LOC	DIST	REVISIONS					
A	66	P	LTN	DESCRIPTION	DATE	OWN	APVD
		N1		ECR-19-015825	11OCT2019	TB	TE
		N2		ECR-19-016321	18OCT2019	TB	TE
		N3		ECR-21-003615	25MAR2021	FZ	YY
		N4		ECR-24-215526	22JUL2024	TB	TE

-	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	2119082-3	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
3	-	1	1	-	1-1752354-9	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
6	-	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	455888-5	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	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	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	2-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 14	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	2-1752356-0	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	2844992-2	ASSEMBLY, STRIP GUIDE -	29
-	1	1	1	1	1-455888-0	SPACER, CRIMPER -	28
-	1	1	1	1	1320928-6	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
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	1803095-1	FLOATING SHEAR, FRONT -	9
1	1	1	1	1	2-1333225-0	ANVIL, COMBINATION	8
-	1	1	1	1	2-240641-0	SPACER	7
-	1	1	1	1	1-2119757-0	DEPRESSOR, SHEAR	5
-	1	1	1	1	4-238011-2	BLOCK, CRIMPER SPACER	4
1	1	1	1	1	1-1633989-8	CRIMPER, INSULATION, SPECIAL	3
1	1	1	1	1	2-1490019-3	CRIMPER, WIRE PREMIUM	1

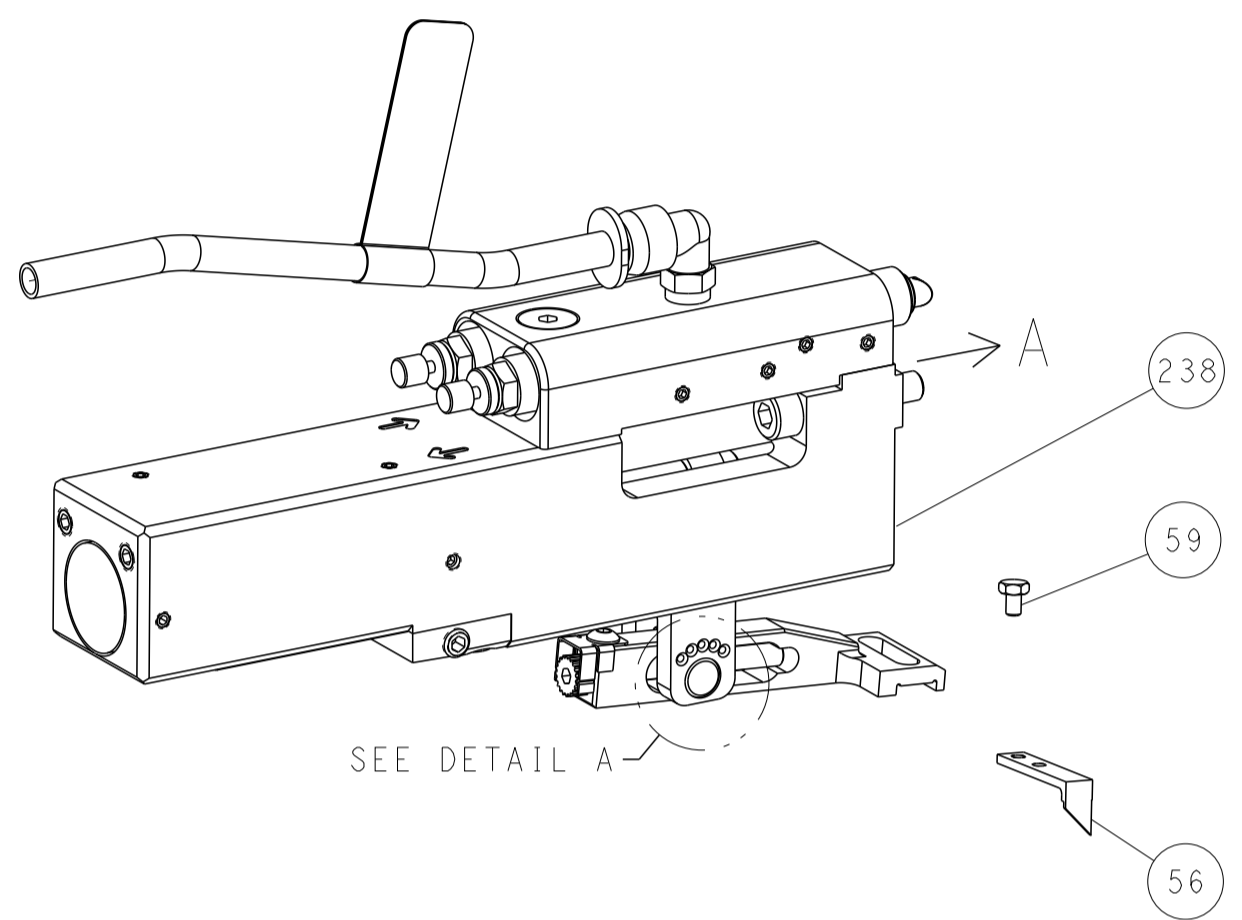
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DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH	NAME Ocean Side Feed Applicator SIZE CAGE CODE DRAWING NO RESTRICTED TO A1 00779 C=2151042 Customer Accessible Production Drawing SCALE 1:2 SHEET 1 OF 4 REV N4

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

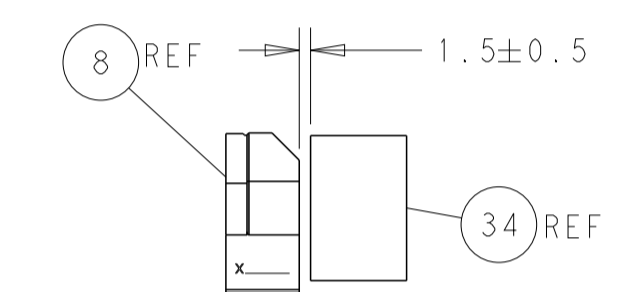
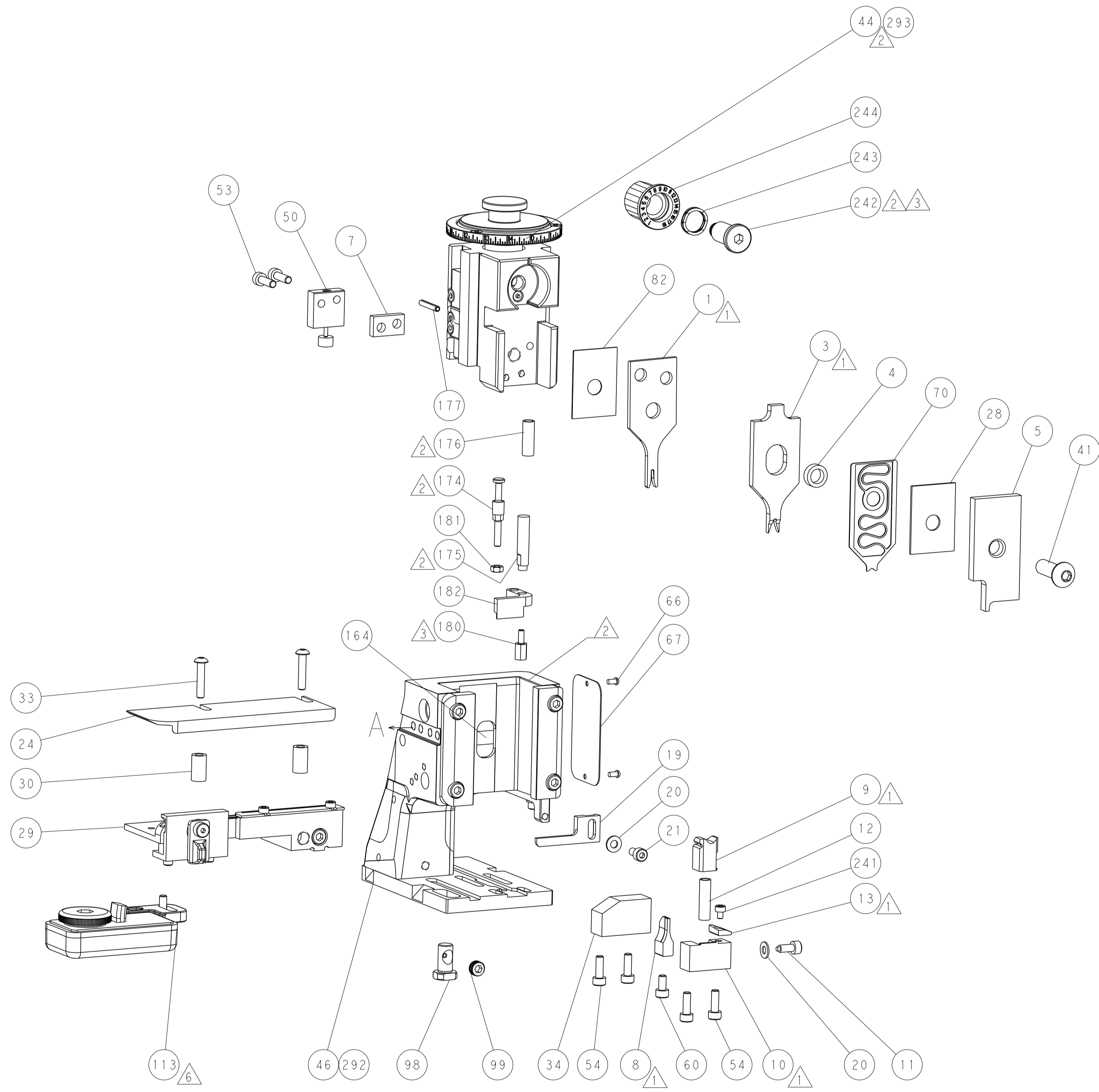
# FEED TYPE MECHANICAL



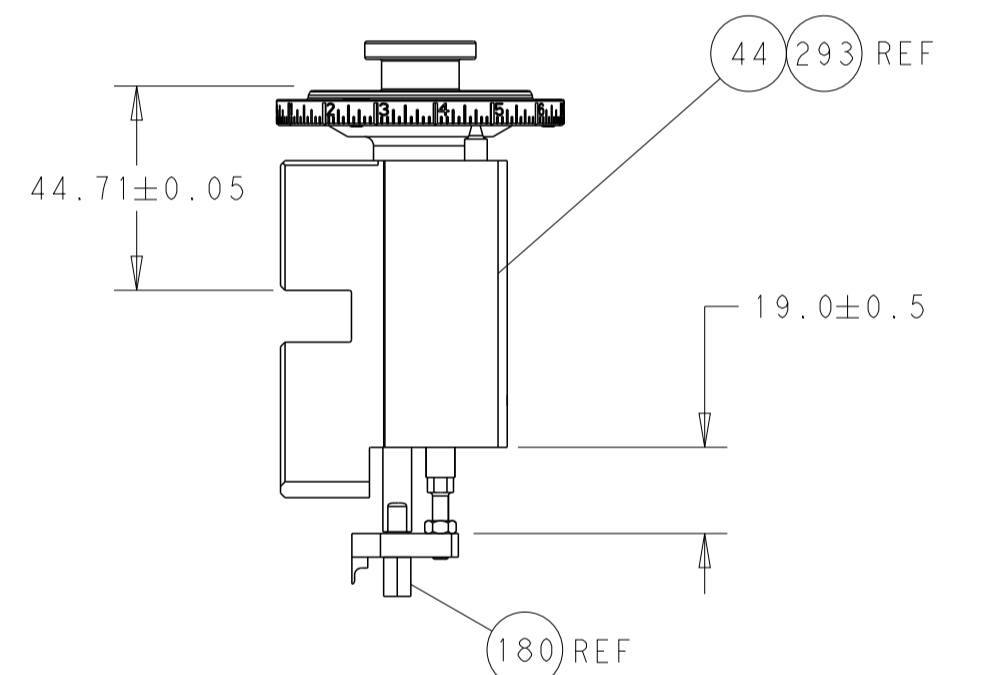
## PNEUMATIC



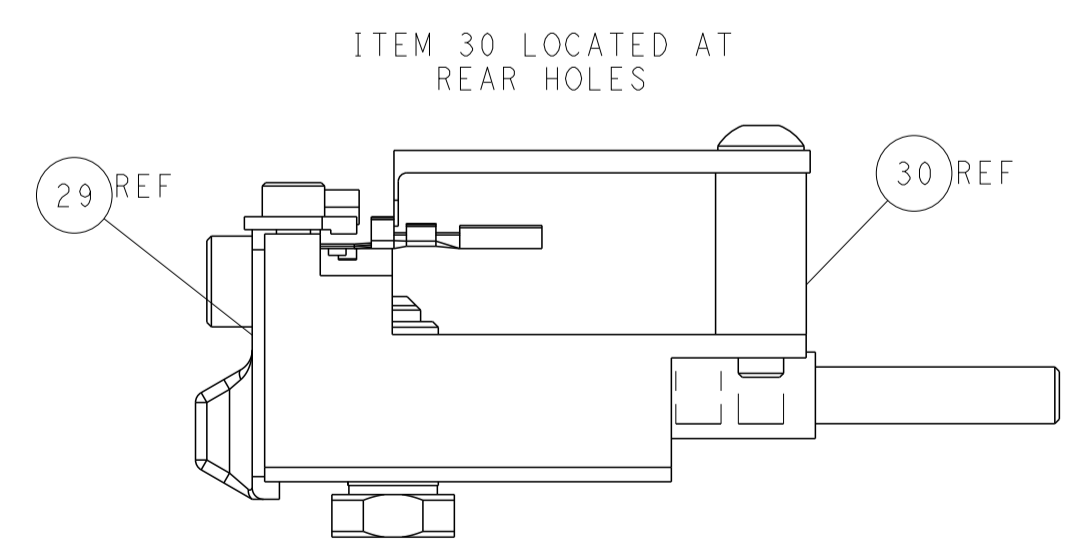
## FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



TERMINAL SUPPORT LOCATION

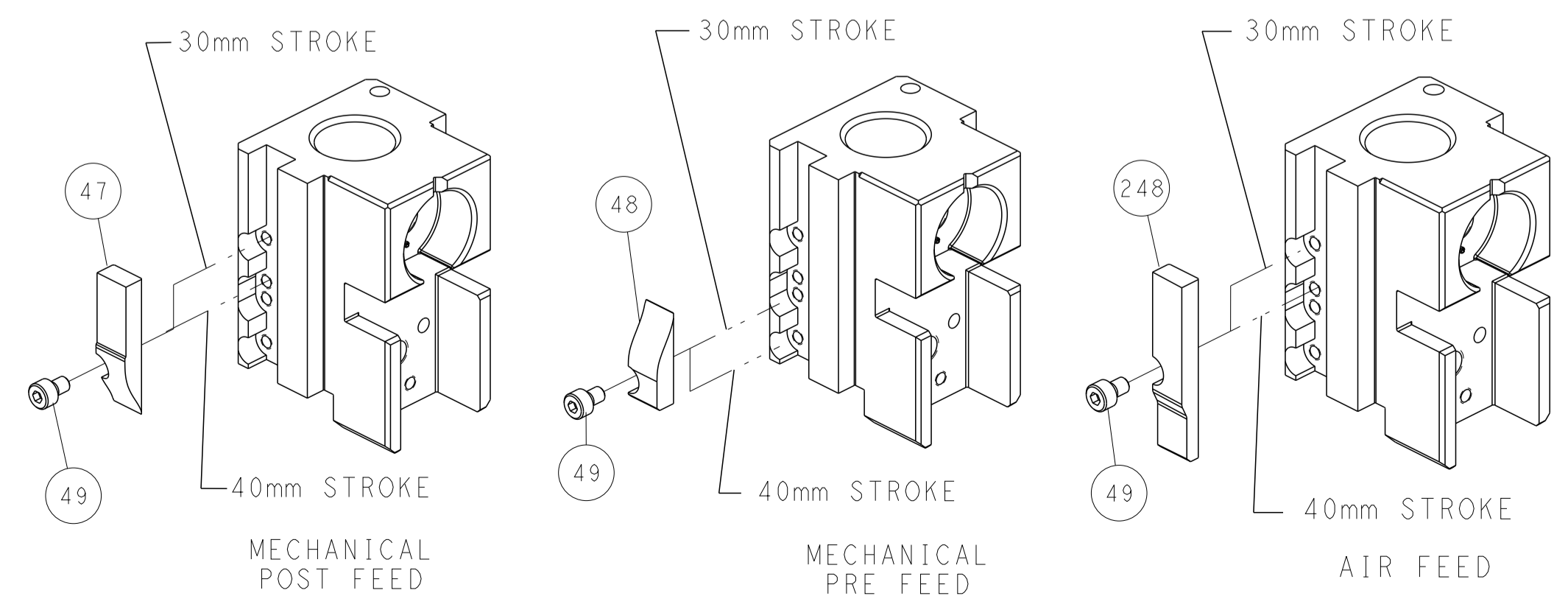


RAM & HOLDDOWN SET-UP



FEED TRACK POSITION GUIDE BY INSULATION BARREL

## CAM POSITIONS



DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		DWN Y. YIN 22SEP2011 CHK G. BAILEY 22SEP2011 APVD S. XI 22SEP2011 NAME Ocean Side Feed Applicator SIZE CAGE CODE DRAWING NO RESTRICTED TO A1 00779 C=2151042 Customer Accessible Production Drawing SCALE 1:2 SHEET 2 OF 4 REV N4	
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