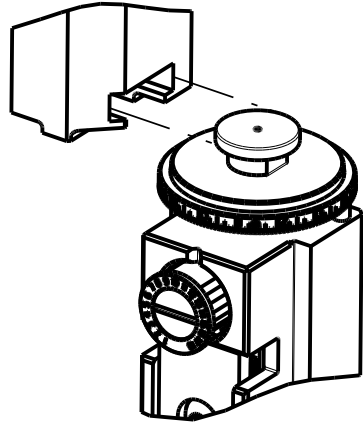


8		7	
THIS DRAWING IS UNPUBLISHED.		RELEASED FOR PUBLICATION	
20		20	
(C) COPYRIGHT 20 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.			
PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151104-1	L	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2151104-2	L	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
5-2151104-1	L	SEAL STRIPPER CRIMPER TERMINATING UNIT	MECHANICAL
5-2151104-2	L	SEAL STRIPPER CRIMPER TERMINATING UNIT	PNEUMATIC
7-2151104-1	L	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2151104-2	L	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2151104-7	J	CRIMP TOOLING KIT	-

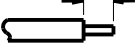
ATLANTIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.40 mm [.055]	F
INSUL	2.90 mm [1.114]	O

APPLICATOR INSTRUCTIONS
408-35042



TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: MICRO QUADLOCK SYSTEM W/SEAL			
WIRE STRIP LENGTH 3.05-3.35 mm [1.20-.132 IN]			TERMINAL INSULATION DIAMETER RANGE Ø0.90-1.90 mm [1.035-.075 IN]
TERMINAL APPLICATION SPECIFICATION	 114-18025	-	-
TERMINALS APPLIED		-	-
TE TERMINAL	TE TERMINAL	TE SEAL	TE SEAL
962885-1	962886-1		967067-1
962885-5	962886-2		967067-2
962885-6	1-962886-1		967067-3
2-962885-5	2-962886-2		
5-962885-1	5-962886-1		
5-962885-5	5-962886-2		
5-962885-6	5-962886-3		
7-962885-5	7-962886-2		

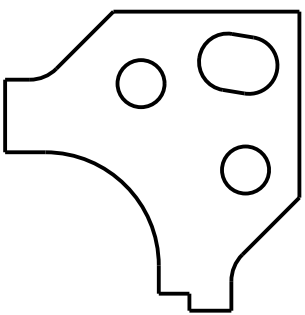
SEAL INSULATION DIAMETER RANGE
1.4-2.1 mm
0.9-1.4 mm
0.9-1.3 mm

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.50mm2	0.86+/-0.03 [1.034+/-0.001]	7.7
0.35mm2	0.76+/-0.03 [1.030+/-0.001]	8.7
0.25mm2	0.72+/-0.03 [1.028+/-0.001]	9.1
0.20mm2	0.69+/-0.03 [1.027+/-0.001]	9.4



- RECOMMENDED SPARE PARTS
- REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 180. 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.
- APPLY TORO-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.
- POSITION THE HOLD DOWN, ITEM 18, IN ORIENTATION 1. FOR ALL TERMINALS LISTED IN THE 'TERMINAL APPLIED' TABLE.

*NOTE ORIENTATION 2 OF ITEM 18 IS NOT TO BE USE FOR THIS APPLICATION.



7. 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.

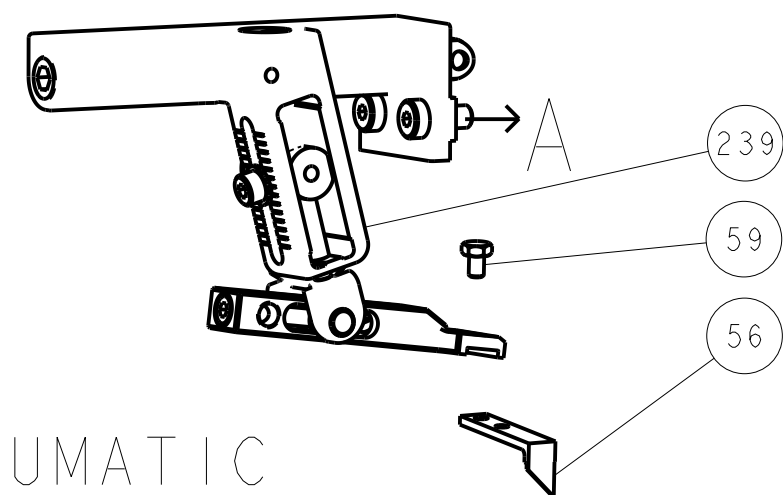
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

LOC	DIST	REVISIONS				
		P	LTR	DESCRIPTION	DATE	DWN
A	66	J		ECR-19-008876	05JUN2019	TB
		K		ECR-19-009764	22JUN2019	TB
		L		ECR-19-013112	21AUG2019	FZ
		L1		ECR-21-003710	26MAR2021	FJ

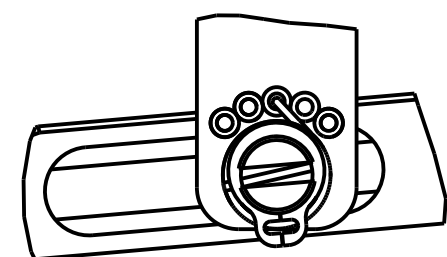
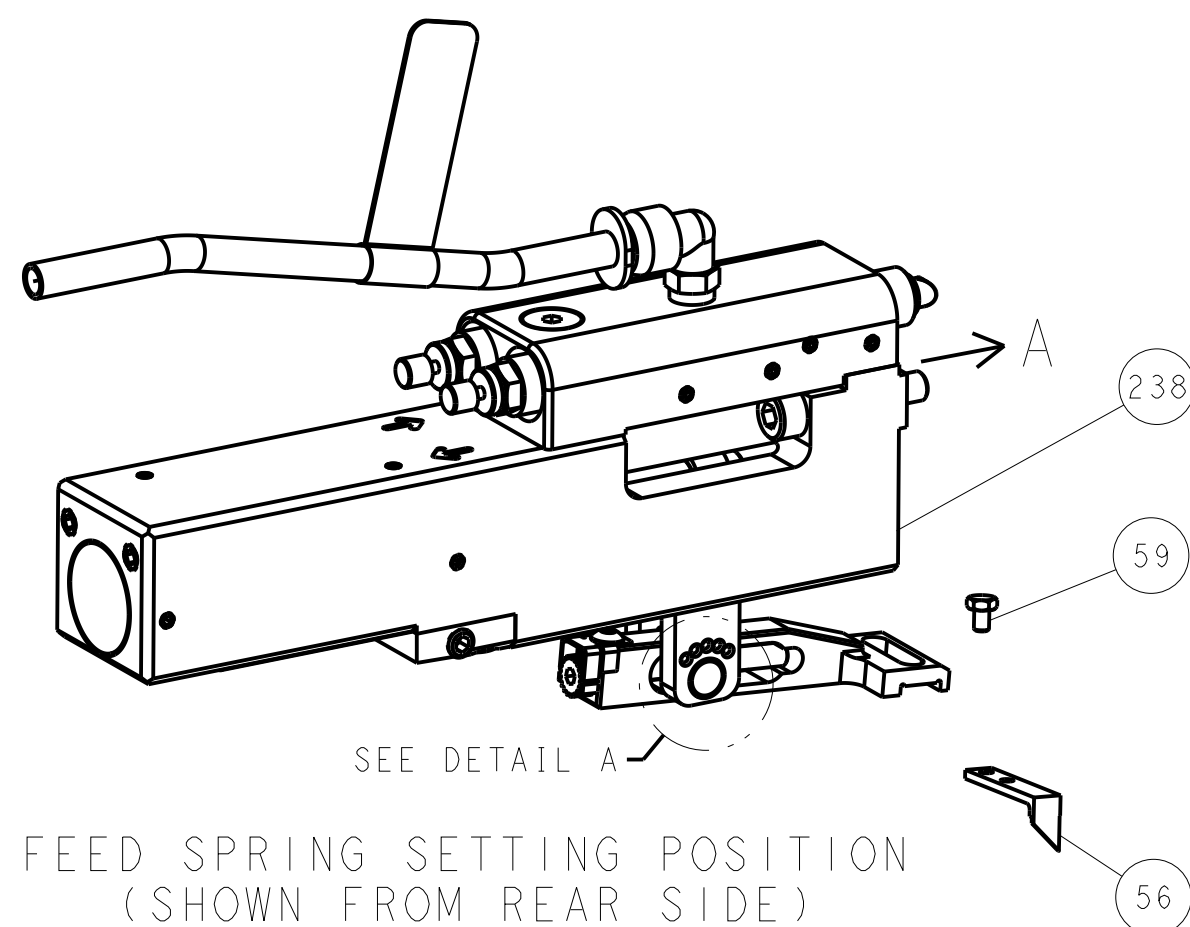
-	-	-	1	1	-	-	1803515-3	RAM ASSEMBLY, SF ATLANTIC	293
-	-	-	1	1	-	-	2-1803583-1	APPLICATOR BASIC ASSEMBLY, SF	292
-	1	-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248
-	1	1	1	1	1	1	2119082-8	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	1	1	1	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
-	-	1	-	1	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	1	-	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	-	-	1-1752354-6	STANDOFF,HOLD-DOWN	180
-	-	-	1	1	-	-	9931111-1	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	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	1	1	1	1	1	1	2844908-1	SCREW, LOCKING	99
-	1	1	1	1	1	1	2844907-1	POST, LOCKING	98
-	1	1	1	1	1	1	455888-6	SPACER, CRIMPER	82
-	1	1	1	1	1	1	1803607-3	DOCUMENTATION PACKAGE	71
-	1	1	1	1	1	1	2119740-1	TAG,IDENTIFICATION	67
-	2	2	2	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	1	1	1	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	60
-	1	1	1	1	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	1	1	1	1	1	1	985575-3	SCR, FLT SKT HD CAP M3 X 10.0	57
-	1	1	1	1	1	1	1338685-1	PAWL, FEED	56
-	4	4	4	4	4	4	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	54
-	2	2	2	2	2	2	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	53
-	1	2	1	2	1	2	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	-	1	-	1	-	1	2119652-1	FEED CAM, PRE FEED	48
-	-	1	-	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	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
-	1	1	1	1	1	1	1752356-6	SUPPORT, TERMINAL	34
-	2	2	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	2	2	2	2	2-2844962-8	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	1	1	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29
-	1	1	1	1	1	1	455888-3	SPACER, CRIMPER	28
-	1	1	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
-	4	4	3	3	4	4	1-18028-2	WASHER, FLAT, REG M4	20
-	1	1	-	-	1	1	2119533-1	STRIPPER, SIDE FEED	19
-	1	1	1	1	1	1	2217529-1	TERMINAL HOLD DOWN	18
-	1	1	1	1	1	1	2119806-1	INSERT, SHEAR	13
-	1	1	1	1	1	1	3-22280-3	SPRING, COMPRESSION	12
-	1	1	1	1	1	1	1-356885-4	STOP, SHEAR	11
-	1	1	1	1	1	1	2119805-1	SHEAR HOLDER, FRONT	10
-	1	1	1	1	1	1	318707-1	FLOATING SHEAR, FRONT	9
1	2	2	1	1	1	1	8-1333201-8	ANVIL, COMBINATION	8
-	1	1	1	1	1	1	4-240641-2	SPACER	7
-	1	1	1	1	1	1	2119781-1	DEPRESSOR, SHEAR	5
-	1	1	1	1	1	1	1-238011-7	BLOCK, CRIMPER SPACER	4
1	2	2	1	1	1	1	8-2119784-2	CRIMPER, INSULATION O PREMIUM	3
-	1	1	1	1	1	1	455888-7	SPACER, CRIMPER	2
1	2	2	1	1	1	1	1-562108-5	CRIMPER, WIRE, F	1

-77	-72	-71	-52	-51	-2	-1	PART NO	DESCRIPTION	ITEM NO
THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE AND TO BE CONTROLLED BY THE ORGANIZATION THAT IT WAS ISSUED FROM. ANY REVISIONS TO THIS DRAWING SHOULD BE CONTACTED FOR THE LATEST EDITION.							DWN G. STAKEM 06OCT2011	TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm							CHK G. BAILEY 06OCT2011	NAME Ocean Side Feed Applicator	
TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±							APVD T. FLRIN 06OCT2011	PRODUCT SPEC	
MATERIAL							FINISH	APPLICATION SPEC	
-							-	WEIGHT	
-							-	CUSTOMER ACCESSIBLE PRODUCTION DRAWING	
-							-	SCALE 1:2	
-							-	SHEET 1 OF 4	
-							-	REV 1	

FEED TYPE
MECHANICAL

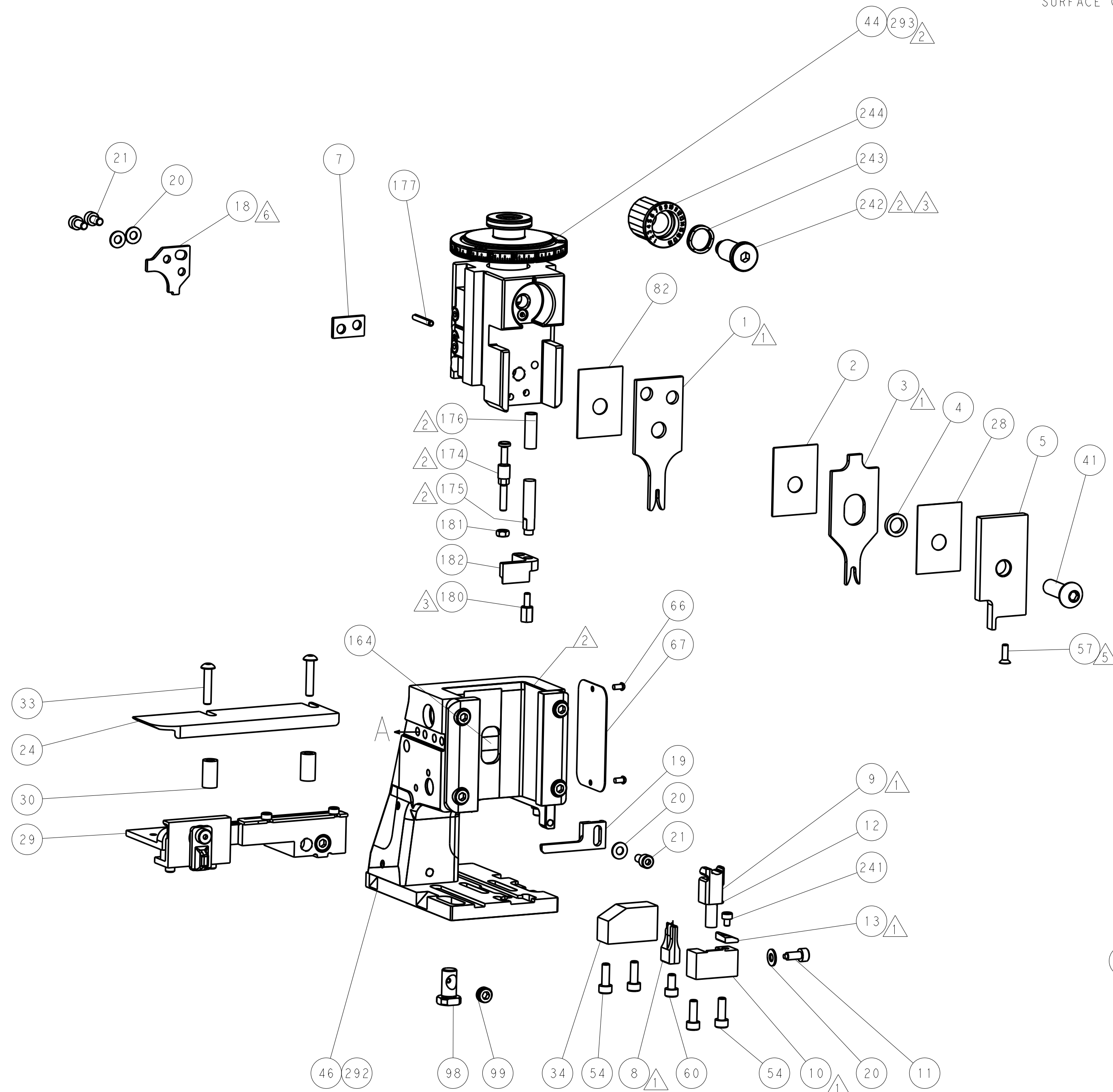
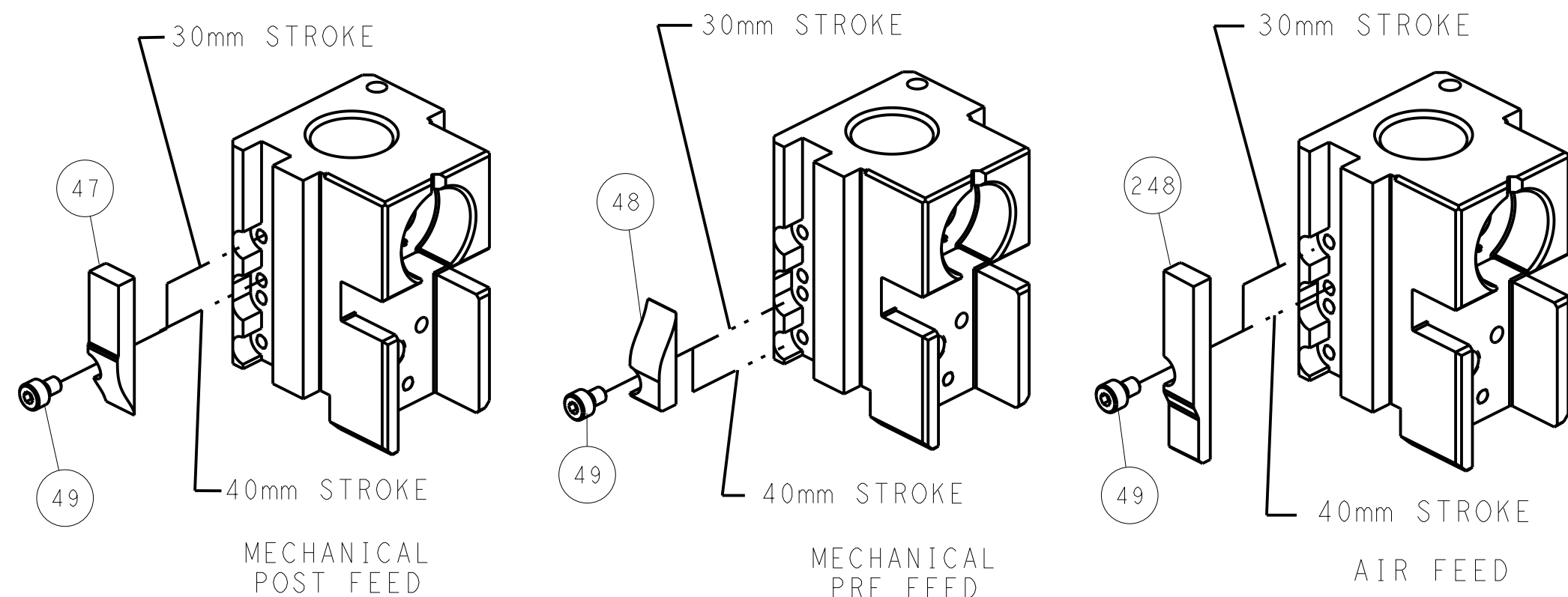


PNEUMATIC

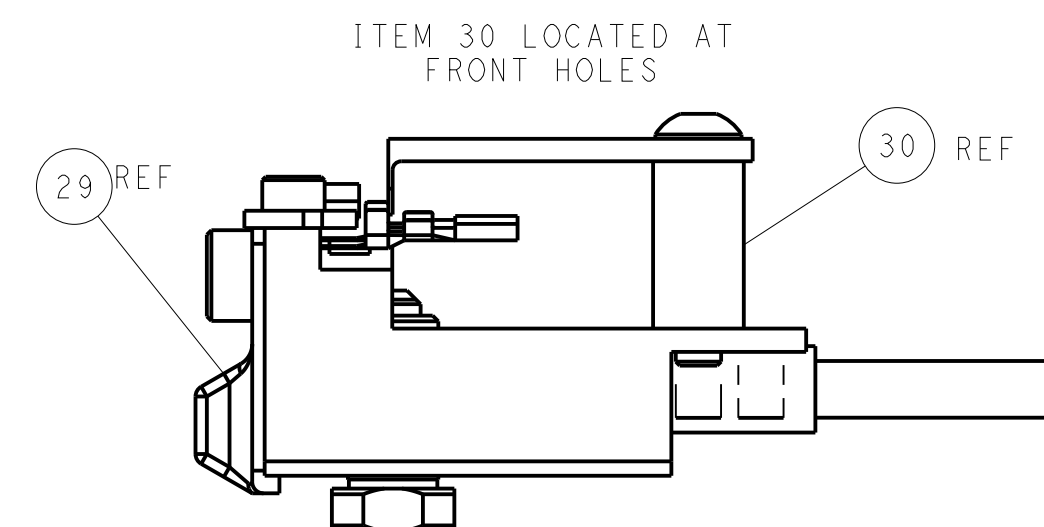
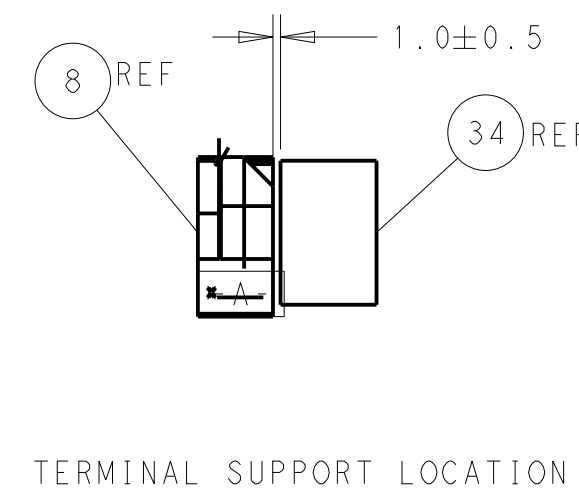
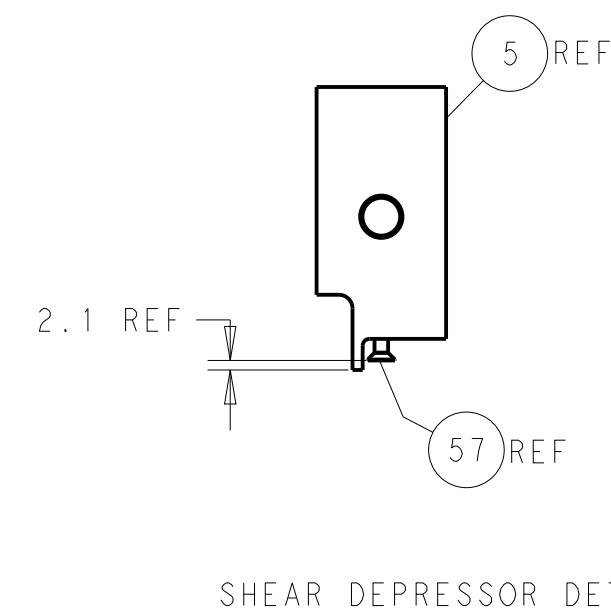
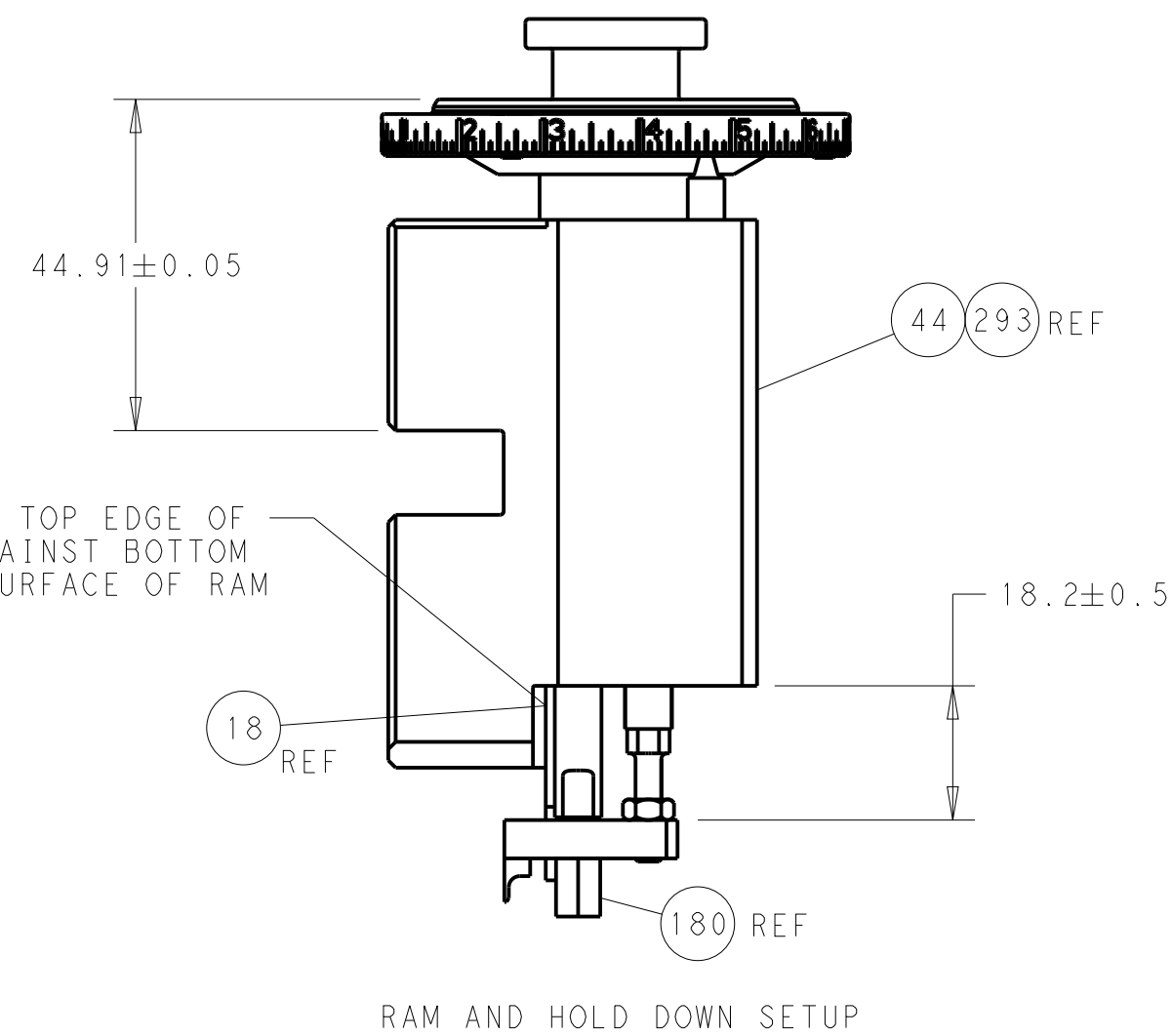


DETAIL A

CAM POSITIONS



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

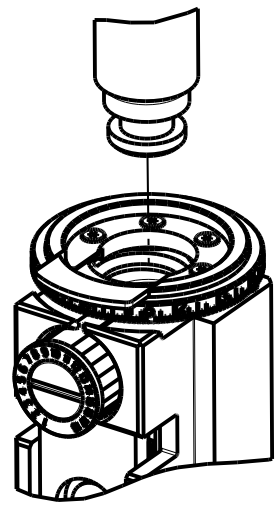


ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. ANY CHANGES TO THIS DRAWING MUST BE APPROVED BY THE DESIGNING ORGANIZATION. ANY CHANGES TO THIS DRAWING MUST BE APPROVED BY THE DESIGNING ORGANIZATION.				OWN: STANEM 06OCT2011	TE Connectivity Harrisburg, PA 17105-3608		
CHK: G. BAILEY 06OCT2011				NAME: T. ELBIN 06OCT2011	Ocean Side Feed Applicator		
APVD: T. ELBIN 06OCT2011				PRODUCT SPEC: -	SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2151104		
APPLICATION SPEC: -				WEIGHT: -	RESTRICTED TO: -		
MATERIAL: -				CUSTOMER ACCESSIBLE PRODUCTION DRAWING	SCALE: 1:2	SHEET: 2 OF 4	REV: 1

SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2151104-1	L	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2151104-2	L	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151104-7	J	CRIMP TOOLING KIT	-



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.40 mm [.055]	F
INSUL	2.90 mm [.114]	O
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: MICRO QUADLOCK SYSTEM W/SEAL			
WIRE STRIP LENGTH		TERMINAL INSULATION DIAMETER RANGE	
3.05-3.35 mm [.120-.132 IN]		Ø0.90-1.90 mm [.035-.075 IN]	
TERMINAL APPLICATION SPECIFICATION	 114-18025	-	-
	-	-	-

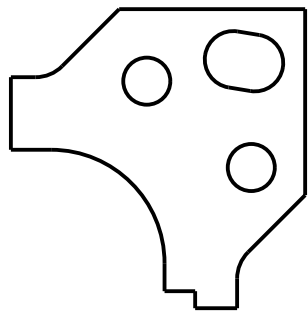
TERMINALS APPLIED				SEAL INSULATION DIAMETER RANGE
TE TERMINAL	TE TERMINAL	TE SEAL	TE SEAL	
962885-1	962886-1		967067-1	1.4-2.1 mm
962885-5	962886-2		967067-2	0.9-1.4 mm
962885-6	1-962886-1		967067-3	0.9-1.3 mm
2-962885-5	2-962886-2			
5-962885-1	5-962886-1			
5-962885-5	5-962886-2			
5-962885-6	5-962886-3			
7-962885-5	7-962886-2			

WIRE SIZE			CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING 
0.50mm2			0.86 +/- 0.03 [0.034 +/- .001]		7.7
0.35mm2			0.76 +/- 0.03 [0.030 +/- .001]		8.7
0.25mm2			0.72 +/- 0.03 [0.028 +/- .001]		9.1
0.20mm2			0.69 +/- 0.03 [0.027 +/- .001]		9.4



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. 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.
6. POSITION THE HOLD DOWN, ITEM 18, IN ORIENTATION 1. FOR ALL TERMINALS LISTED IN THE 'TERMINAL APPLIED' TABLE.

*NOTE ORIENTATION 2 OF ITEM 18 IS NOT TO BE USE FOR THIS APPLICATION.



7. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.

ENTRY LEVEL APPLICATOR		ITEM SUBSTITUTION LIST		
PART NUMBER	SAME AS	ITEM	ITEM DESCRIPTION	SUBSTITUTE PART NUMBER
8-2151104-1	2151104-1	1	WIRE CRIMPER	1-1803529-5
8-2151104-2	2151104-2	3	INSULATION CRIMPER	8-1803604-2
9-2151104-1	2-2151104-1	46	BASIC SUB -ASSEMBLY	1803940-9
9-2151104-2	2-2151104-2	141	BASIC SUB -ASSEMBLY	1-1803940-0
			LUBRICATOR	DELETE

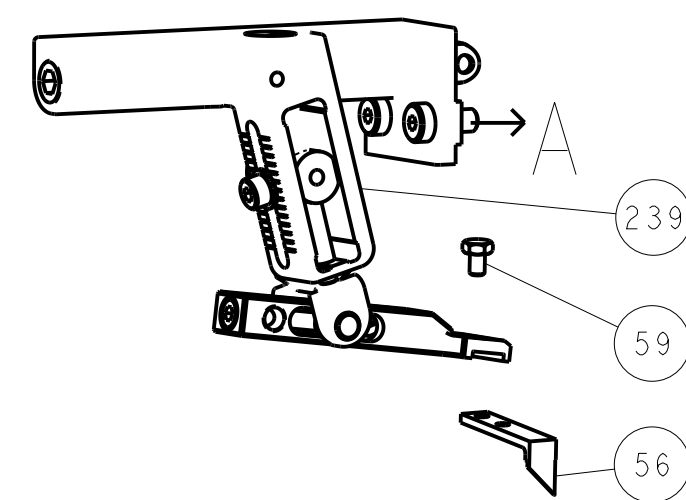
PACIFIC VERSION
Shown on sheets 3 of 4 & 4 of 4
(Atlantic version shown on sheets 1 of 4 & 2 of 4)

[illegible]

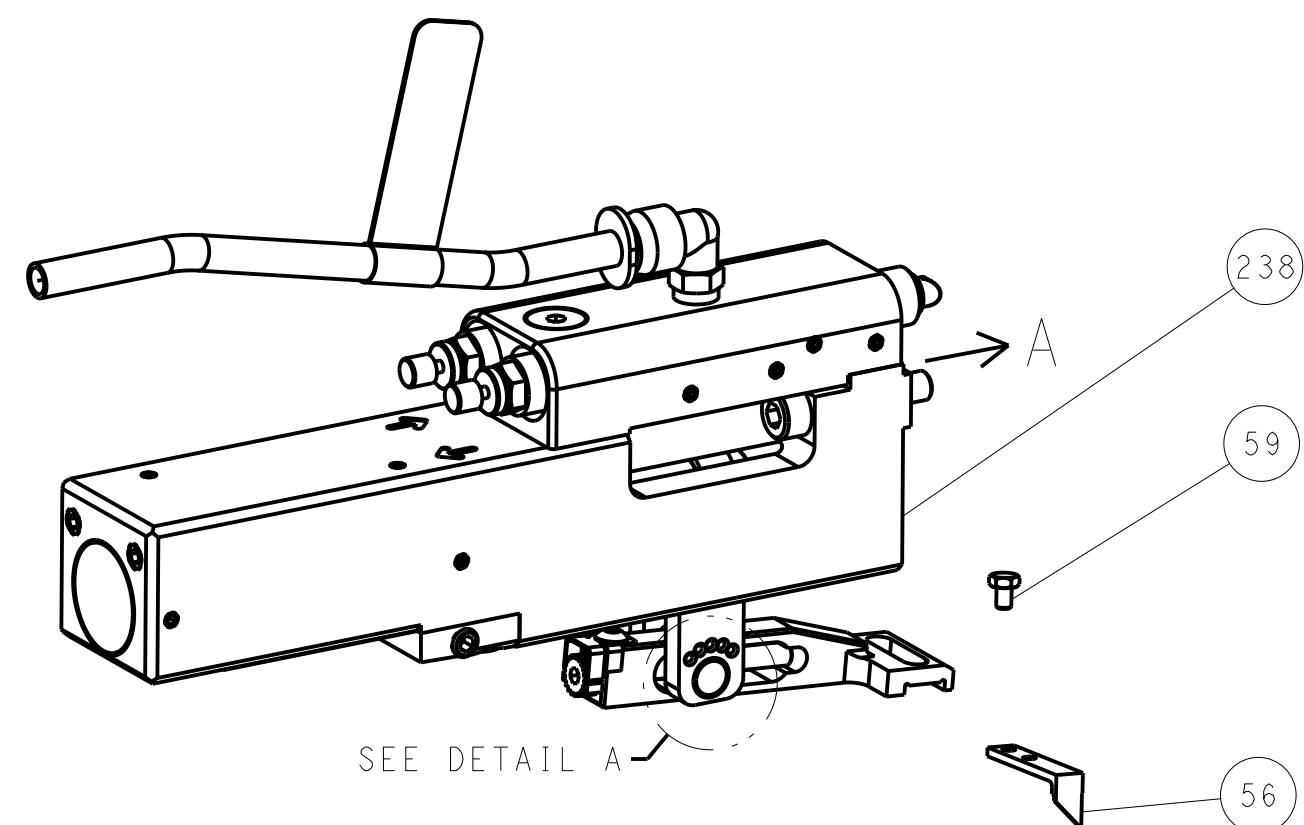
	-	1	1	2119082-8	CAM, SNAIL, INSULATION ADJUSTMENT	242
	-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
3	-	1	1	2119083-1	RETAINER, INSULATION DIAL	242
	-	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
	-	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
	-	1	-	2844940-1	AIR FEED MODULE	238
	-	REF	REF	994970-2	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	2844908-1	SCREW, LOCKING	99
	-	1	1	2844907-1	POST, LOCKING	98
	-	1	1	455888-6	SPACER, CRIMPER	82
	-	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
5	-	1	1	985575-3	SCR, FLT SKT HD CAP M3 X 10.0	57
	-	1	1	1338685-1	PAWL, FEED	56
	-	2	2	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	53
	-	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	1752356-6	SUPPORT, TERMINAL	34
	-	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
	-	2	2	2-2844962-8	SPACER, CYLINDRICAL, STRIP GUIDE	30
	-	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29
	-	1	1	455888-3	SPACER, CRIMPER	28
	-	1	1	1320928-2	STRIP GUIDE	24
	-	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
	-	4	4	1-18028-2	WASHER, FLAT, REG M4	20
	-	1	1	2119533-1	STRIPPER, SIDE FEED	19
6	-	1	1	2217529-1	TERMINAL HOLD DOWN	18
1	-	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	1	318707-1	FLOATING SHEAR, FRONT	9
1	1	1	1	8-1333201-8	ANVIL, COMBINATION	8
	-	1	1	4-240641-2	SPACER	7
	-	1	1	2119781-1	DEPRESSOR, SHEAR	5
	-	1	1	1-238011-7	BLOCK, CRIMPER SPACER	4
1	1	1	1	8-2119784-2	CRIMPER, INSULATION O PREMIUM	3
	-	1	1	455888-7	SPACER, CRIMPER	2
1	1	1	1	1-562108-5	CRIMPER, WIRE, F	1
	-77	-22	-21	PART NO	DESCRIPTION	ITEM NO

[illegible]

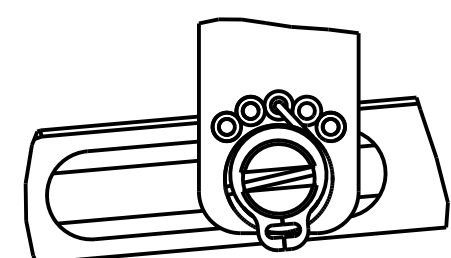
FEED TYPE
MECHANICAL



PNEUMATIC

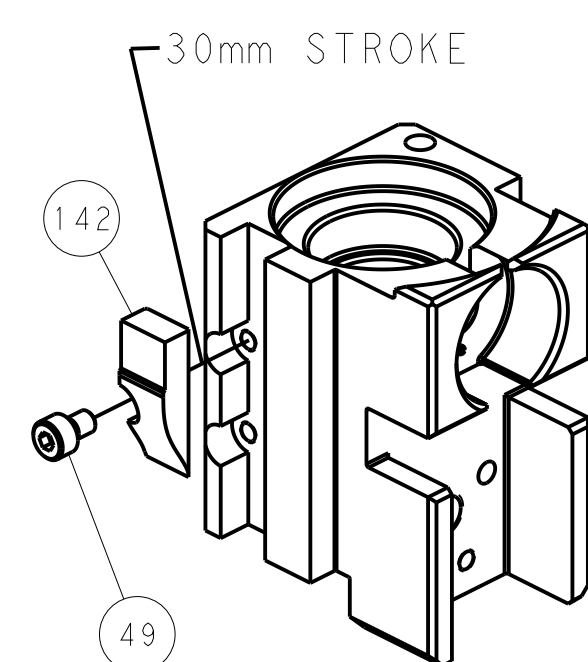


FEED SPRING SETTING POSITION
(SHOWN FROM REAR SIDE)

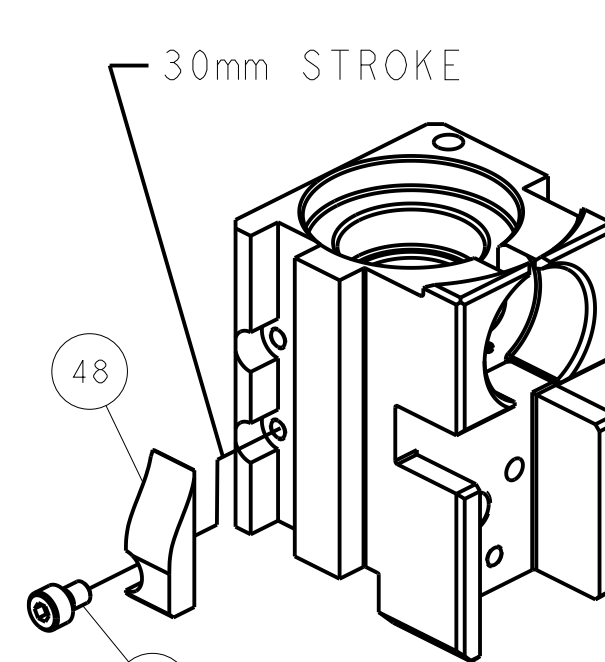


DETAIL A

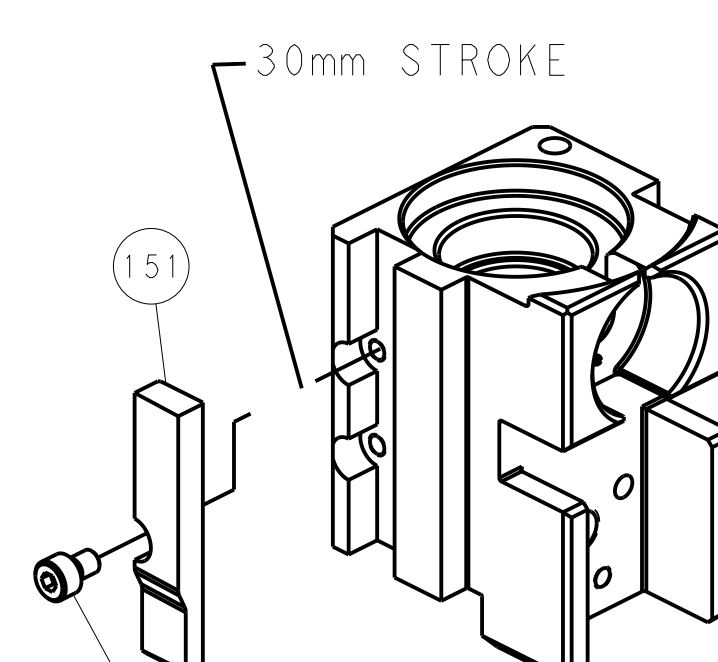
CAM POSITIONS



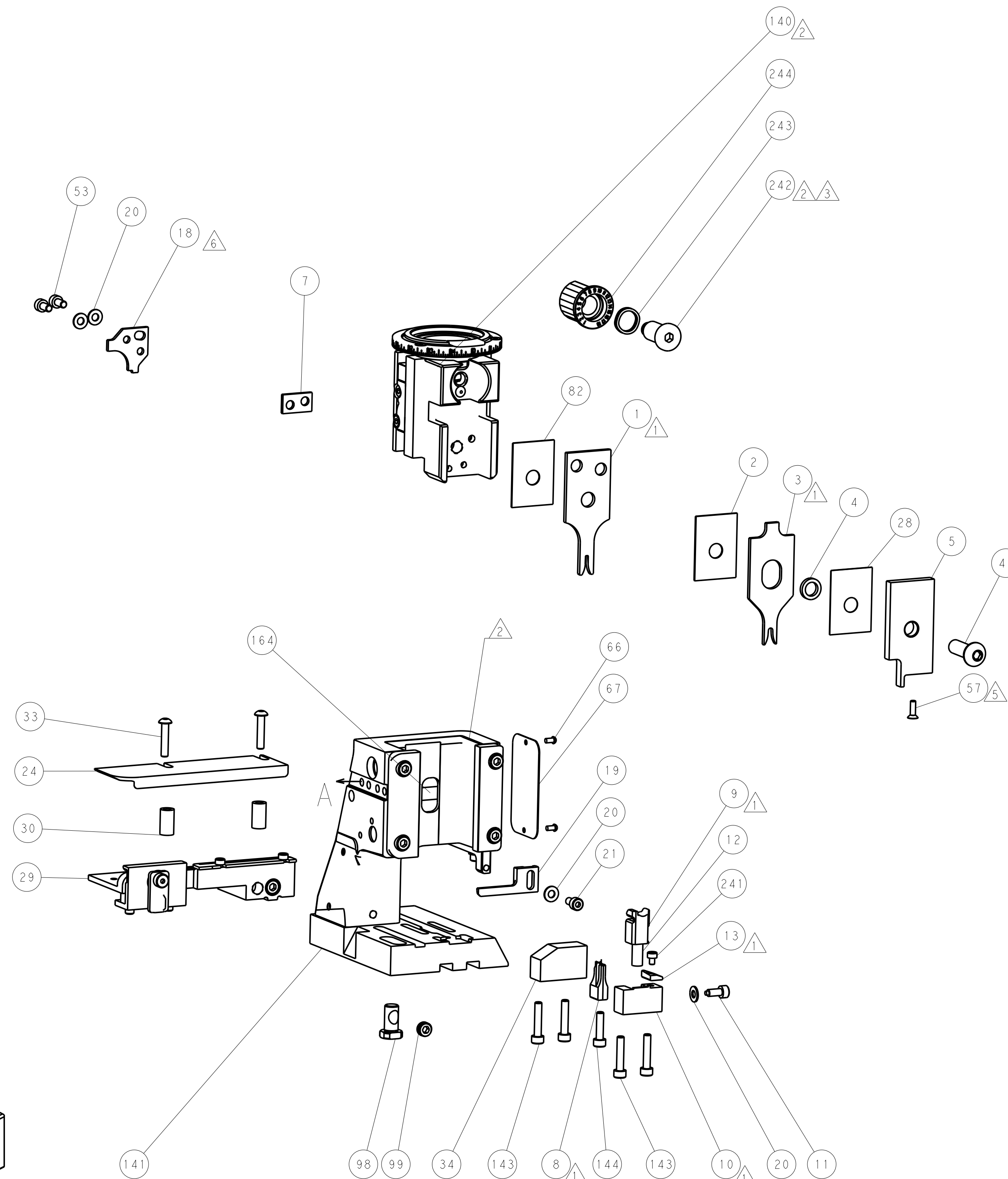
MECHANICAL
POST FEED



MECHANICAL
PRE FEED



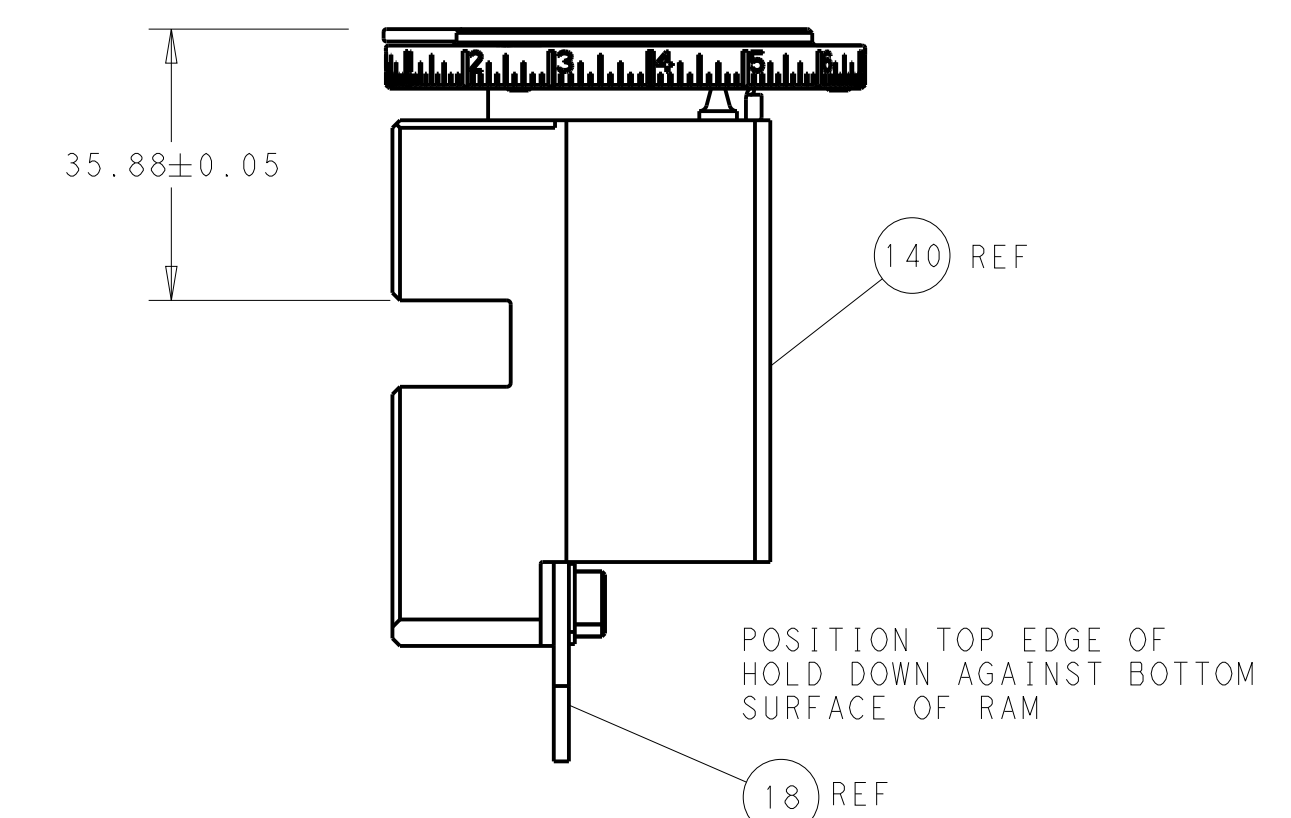
AIR FEED



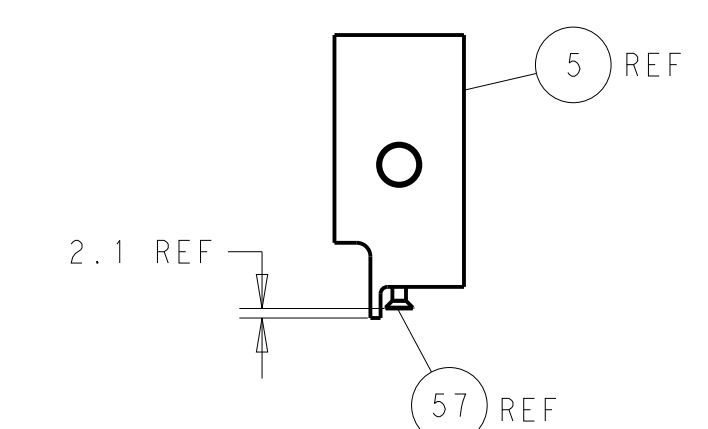
PACIFIC VERSION

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

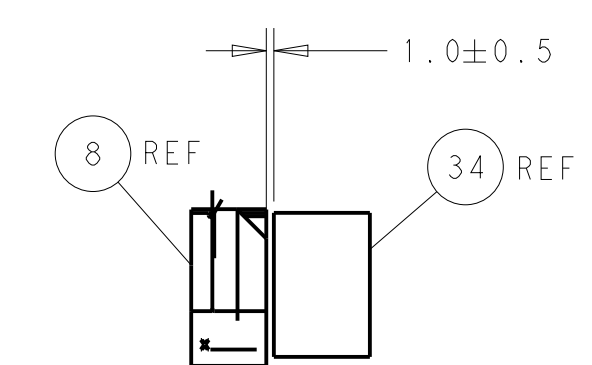
LOC		DIST		REVISONS					
A		66		R	LTR	DESCRIPTION	DATE	DWN	APVD
					-	SEE SHEET 1	-	-	-



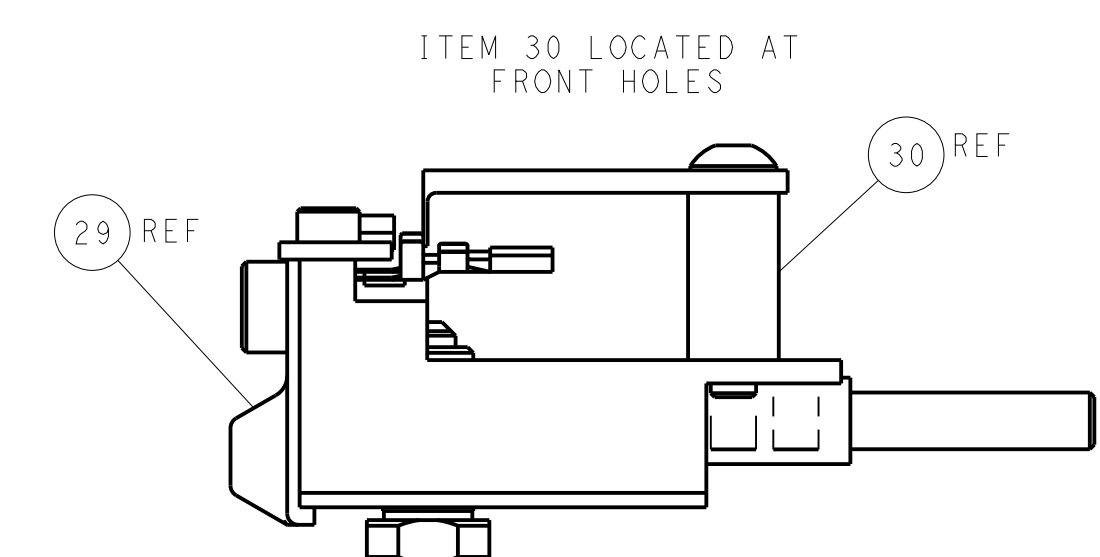
RAM AND HOLD DOWN SETUP



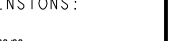
SHEAR DEPRESSOR DETAIL



TERMINAL SUPPORT LOCATION



FEED TRACK POSITION
GUIDE BY INSULATION BARREL

THIS DRAWING IS A CONTROLLED DOCUMENT FOR TECHNICAL SERVICES CORPORATION IT IS SUBJECT TO CHANGE AND THE CONTROLLING ENGINEERING ORGANIZATION SHALL BE NOTIFIED FOR THE LATEST REVISION		DWN 060C21011 STAKEM CHK 060C21011 G. BAILEY APVD 060C21011 TELBIB		 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 CAGE CODE DRAW NO A 00779 C=2151104	
MATERIAL -		WEIGHT -		RESTRICTED TO CUSTOMER ACCESSIBLE PRODUCTION DRAWING SCALE 1:2 SHEET A OF A REV	

Mouser Electronics

Authorized Distributor

Click to View Pricing, Inventory, Delivery & Lifecycle Information:

[TE Connectivity:](#)

[2-2151104-1](#)