

8	7
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RELEASED FOR PUBLICATION 2016	
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PART NUMBER	REVISION
2151045-1	G
2151045-2	H
7-2151045-1	G
7-2151045-2	H
7-2151045-7	A
DESCRIPTION	
FEED TYPE	
FINE CRIMP HEIGHT ADJUST	
MECHANICAL	
FINE CRIMP HEIGHT ADJUST	
PNEUMATIC	
MECHANICAL AND CRIMP TOOLING KIT	
MECHANICAL	
PNEUMATIC AND CRIMP TOOLING KIT	
PNEUMATIC	
CRIMP TOOLING KIT	
-	

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.57 mm [.062]	F
INSUL	2.29 mm [.090]	O
APPLICATOR INSTRUCTIONS 408-35042		

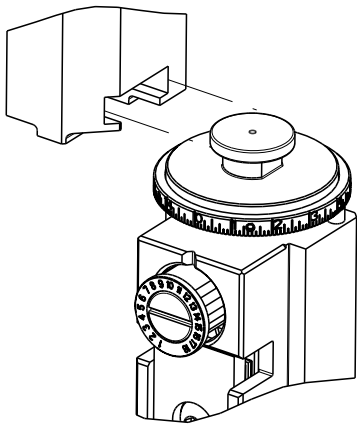
TERMINAL DATA: TE TERMINAL			
TE CRIMP SPECIFICATION			
TERMINAL NAME: MICRO POWER QUADLOK SOCKET CONTACT			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
3.20-3.80 mm [.126-.150 IN]		Ø1.20-1.60 mm [.047-.063 IN]	
TERMINAL APPLICATION SPECIFICATION		114-18141	
TERMINALS APPLIED		56	
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
968678-2	968679-5	1-968679-5	
968679-2	968679-6	2-968679-5	

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.50mm2	1.15+/-0.03 [.045+/- .001]	5.6
0.35mm2	1.08+/-0.03 [.043+/- .001]	6.3



- 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 WHEN RUNNING TERMINAL 968678 MOVE ITEM 7 BETWEEN ITEM 44 OR ITEM 18.
- 6 WHEN RUNNING TERMINAL 968679 MOVE ITEM 261 BETWEEN ITEM 44 OR ITEM 18.
7. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.

ATLANTIC VERSION TERMINATOR
INTERFACE ADAPTER



*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)

REVISIONS				
P	LYR	DESCRIPTION	DATE	DWN
E		ECR-16-012668	6SEP2016	TB
F		ECR-18-006541	27APR2018	MEH
G		ECR-18-010968	11JUL2018	AW
H		ECR-19-005517	05APR2019	LG

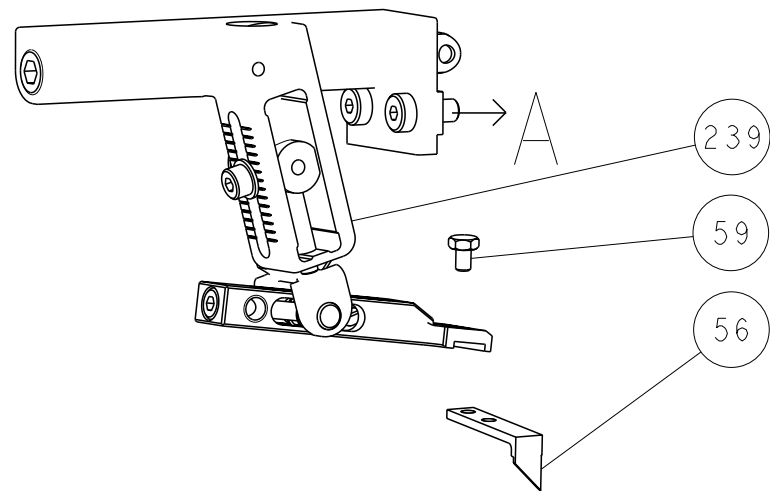
6	-	1	1	1	1	6-240641-5	SPACER	261
	-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248
	-	1	1	1	1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244
	-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
3	-	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
	-	1	1	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
	-	-	1	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
	-	1	-	1	-	2844940-1	AIR FEED MODULE	238
	-	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	455888-3	SPACER, CRIMPER	82
	-	2	2	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	79
	-	1	1	1	1	1633782-2	FENCE	78
	-	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	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	2-2168083-6	SCR, SKT HD CAP, RoHS, M4 X 18	53
	-	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	1-1752356-3	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	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	879657-2	HOLD DOWN	18
1	-	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	2	2	1	1	5-1333202-3	ANVIL, COMBINATION	8
	-	1	1	1	1	2-240641-5	SPACER	7
	-	1	1	1	1	2119757-1	DEPRESSOR, SHEAR	5
	-	1	1	1	1	238011-9	BLOCK, CRIMPER SPACER	4
	1	2	2	1	1	1-2119784-8	CRIMPER, INSULATION O PREMIUM	3
	-	1	1	1	1	455888-5	SPACER, CRIMPER	2
	1	2	2	1	1	9-657555-1	CRIMPER, WIRE PREMIUM	1
	-77	-72	-71	-2	-1	PART NO	DESCRIPTION	ITEM NO

THIS DRAWING IS A CONTROLLED DOCUMENT.		DWN T.Y. YIN	23SEP2011	TE Connectivity	
		CHK G.BAILEY	23SEP2011	NAME Ocean Side Feed Applicator	
DIMENSIONS: mm		APVD S.XI	23SEP2011	PRODUCT SPEC	
				APPLICATION SPEC	
				SIZE	
				A1	
MATERIAL				SCALE	
				1:2	
				SHEET	
				1 OF 4	
				REV	
				H	
				CUSTOMER ACCESSIBLE PRODUCTION DRAWING	

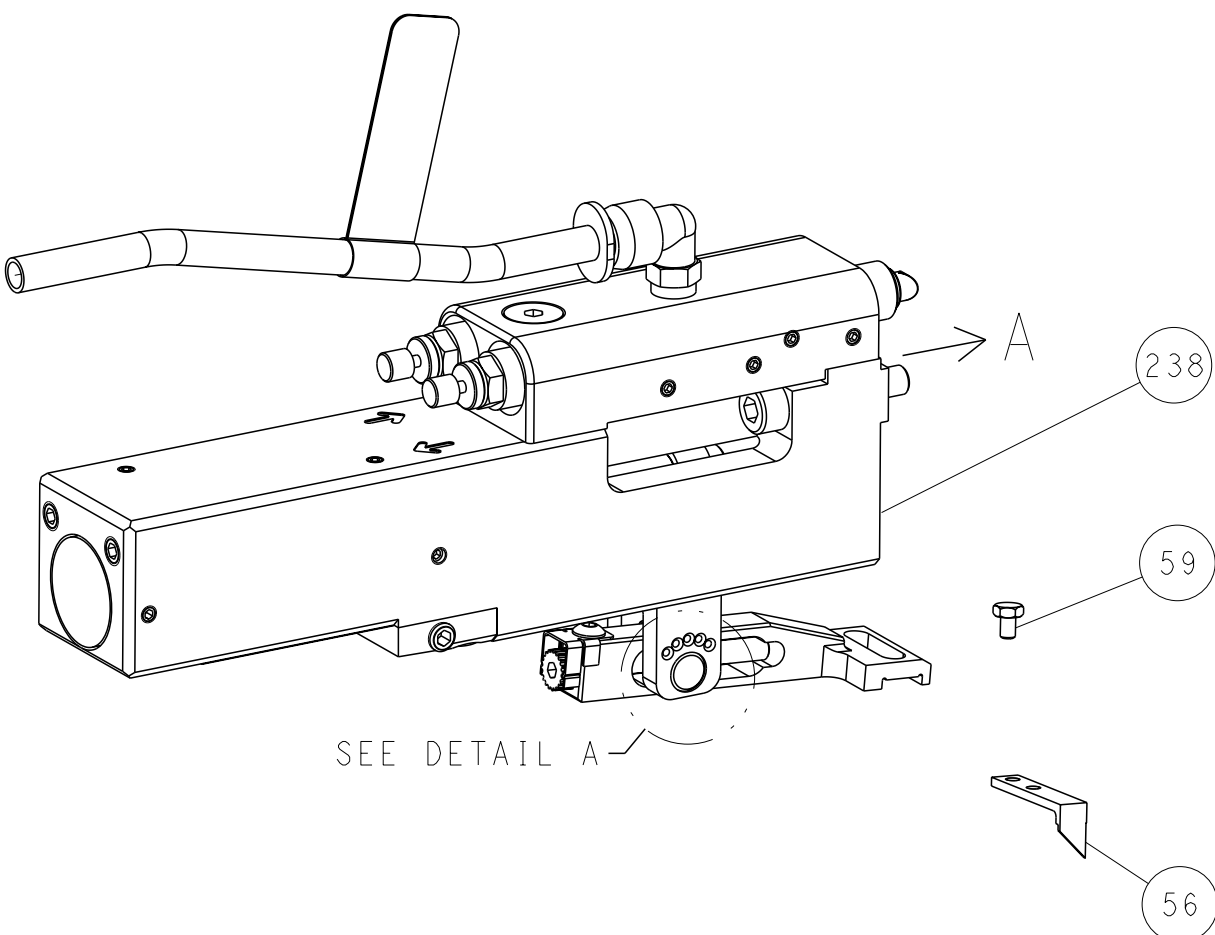
SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

REVISIONS					
P	LYR	DESCRIPTION	DATE	DWN	APVD
-	-	SEE SHEET 1	-	-	-

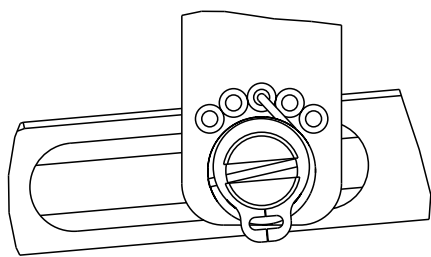
FEED TYPE MECHANICAL



PNEUMATIC

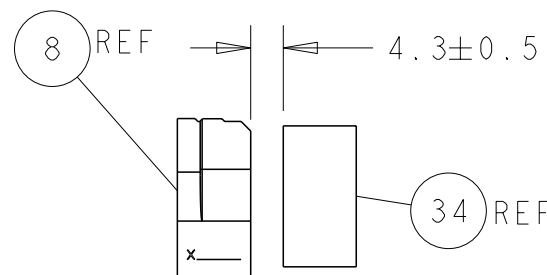
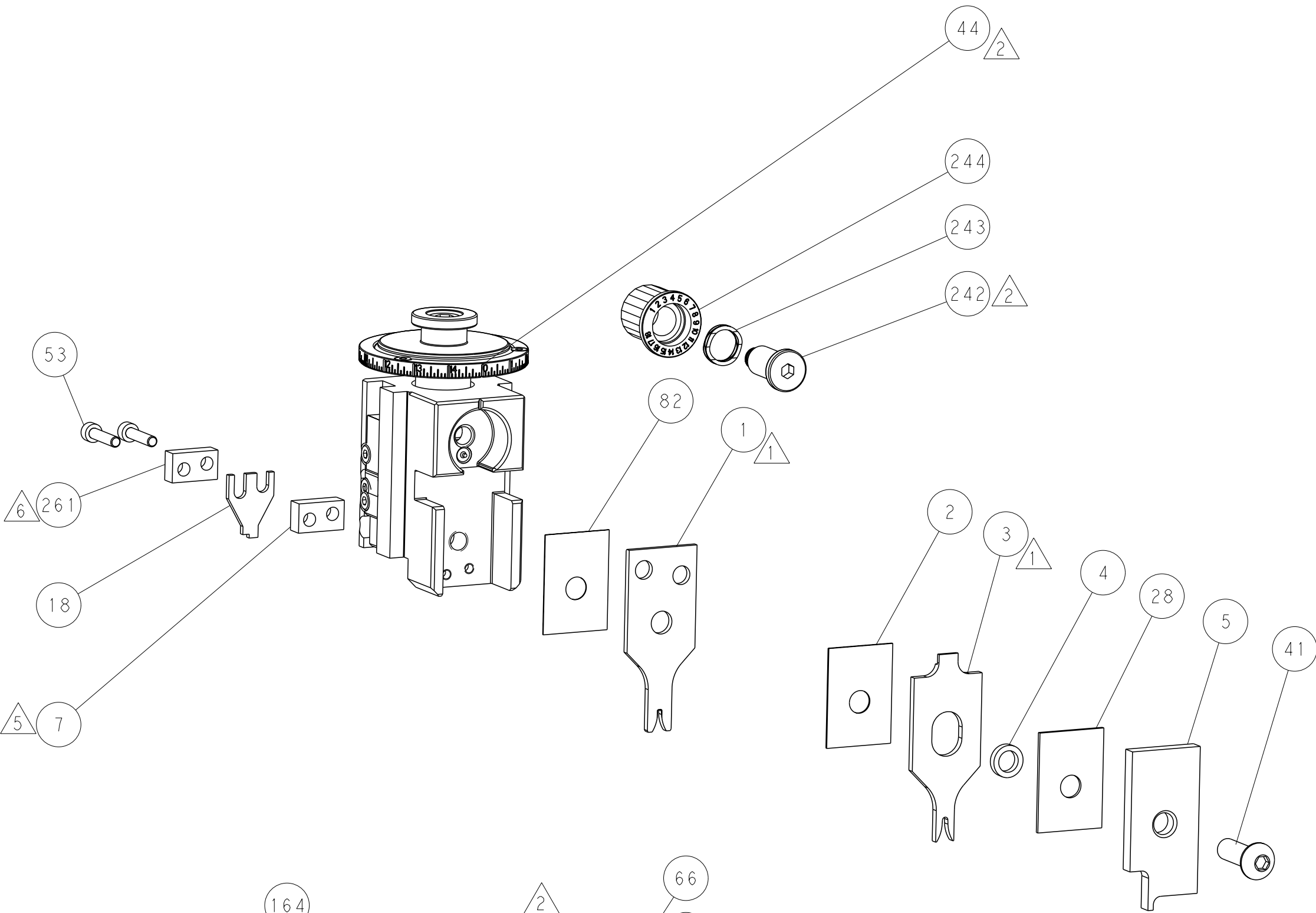
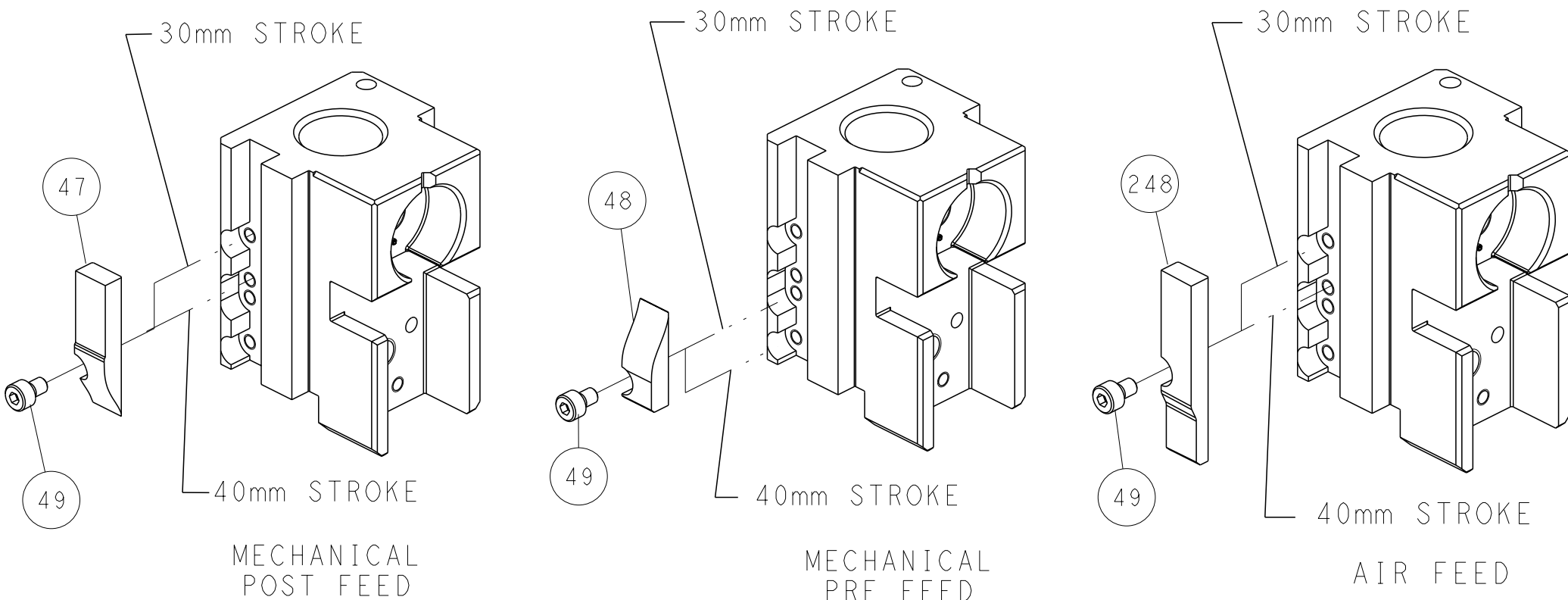


FEED SPRING SETTING POSITION
(SHOWN FROM REAR SIDE)

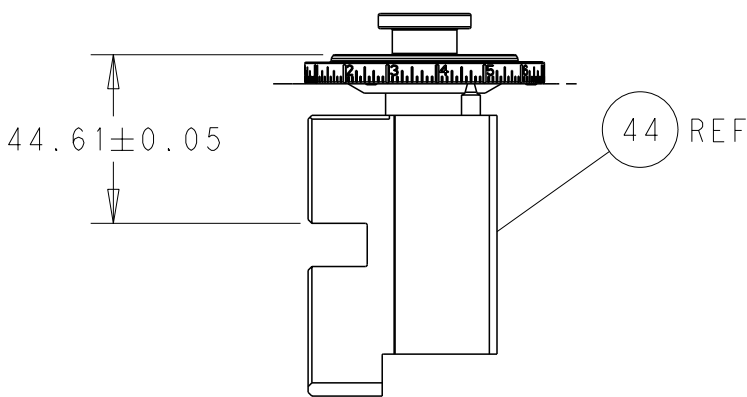


DETAIL A

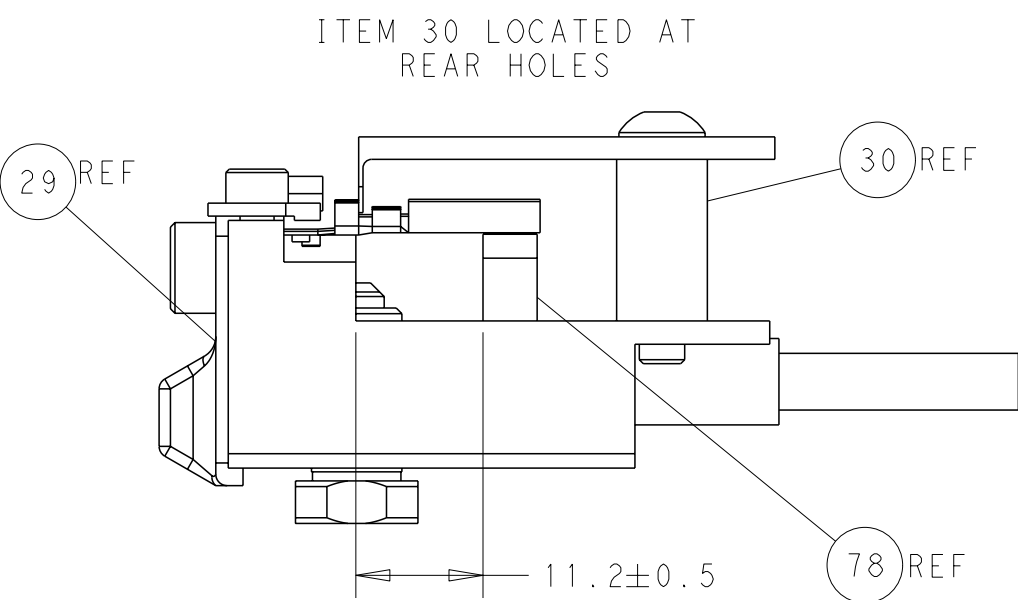
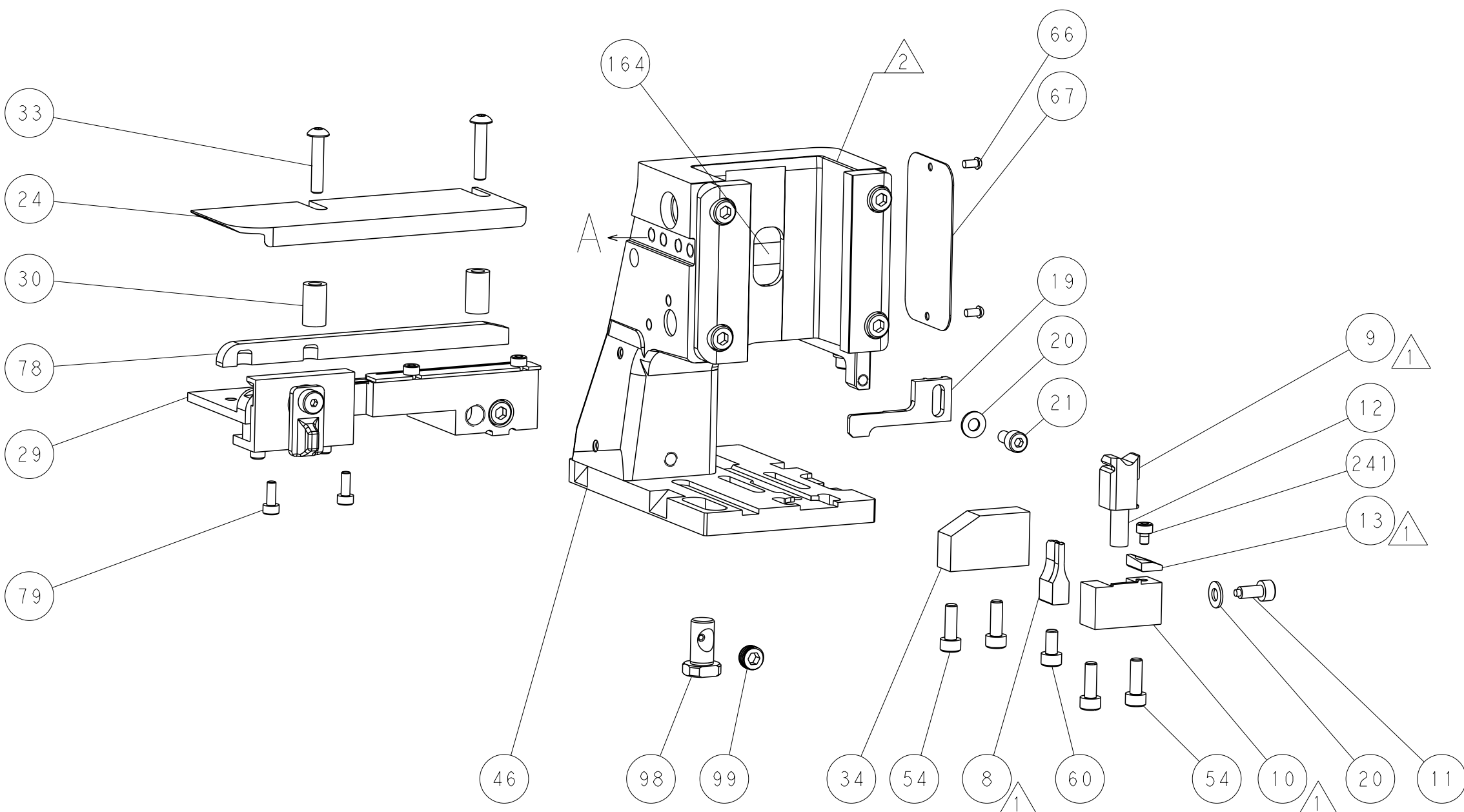
CAM POSITIONS



TERMINAL SUPPORT LOCATION



RAM SET-UP



FEED TRACK POSITION
GUIDE BY INSULATION BARREL

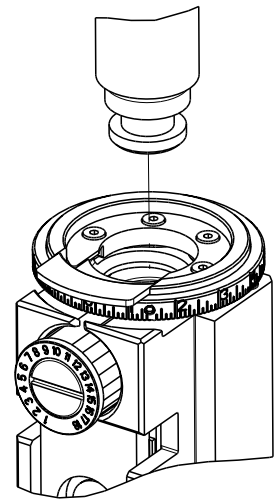
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

THIS DRAWING IS A CONTROLLED DOCUMENT.		DWN Y.YIN 23SEP2011	TE Connectivity	
DIMENSIONS: mm		CHK G.BAILEY 23SEP2011		
TOLERANCES UNLESS OTHERWISE SPECIFIED:		APVD S.XI 23SEP2011	NAME Ocean Side Feed Applicator	
0 PLC ±		PRODUCT SPEC	SIZE A1	
1 PLC ±		APPLICATION SPEC	CAGE CODE DRAWING NO	
2 PLC ±		WEIGHT	C=2151045	
3 PLC ±		CUSTOMER ACCESSIBLE PRODUCTION DRAWING	SCALE 1:2	
4 PLC ±		RESTRICTED TO	SHEET 2 of 4	
ANGLES FINISH		REV H		

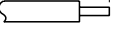
SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

8		7	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2151045-1	G	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2151045-2	H	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151045-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.57 mm [.062]	F
INSUL	2.29 mm [.090]	O
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: MICRO POWER QUADLOK SOCKET CONTACT			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
3.20-3.80 mm [.126-.150 IN]		Ø1.20-1.60 mm [.047-.063 IN]	
TERMINAL APPLICATION SPECIFICATION	114-18141	-	-
		-	-
TERMINALS APPLIED		 	
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
968678-2	968679-5	1-968679-5	
968679-2	968679-6	2-968679-5	

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING
0.50mm2		1.15+/-0.03 [.045+/-0.001]		5.6
0.35mm2		1.08+/-0.03 [.043+/-0.001]		6.3



- 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 WHEN RUNNING TERMINAL 968678 MOVE ITEM 7 BETWEEN ITEM 44 OR ITEM 18.
- 6 WHEN RUNNING TERMINAL 968679 MOVE ITEM 261 BETWEEN ITEM 44 OR ITEM 18.
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.

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

REVISIONS				
#	LYR	DESCRIPTION	DATE	OWN
-	-	SEE SHEET 1	-	-

6	-	1	1	6-240641-5	SPACER	261
	-	1	1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244
3	-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
	-	1	1	2119083-1	RETAINER, INSULATION DIAL	242
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	994970-2	COUNTER, MAGNETIC	164
1	-	1	-	2119641-2	FEED CAM, AIR FEED	151
	-	1	1	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	144
1	-	4	4	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	143
	-	-	1	2119653-2	FEED CAM, POST FEED	142
1	-	1	1	1-1803583-0	APPLICATOR BASIC ASSEMBLY, SF	141
	-	1	1	1803516-1	RAM ASSEMBLY, SF PACIFIC	140
1	-	1	1	2844908-1	SCREW, LOCKING	99
	-	1	1	2844907-1	POST, LOCKING	98
1	-	1	1	455888-3	SPACER, CRIMPER	82
	-	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	79
1	-	1	1	1633782-2	FENCE	78
	-	1	1	1803607-3	DOCUMENTATION PACKAGE	71
1	-	1	1	2119740-1	TAG,IDENTIFICATION	67
	-	2	2	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	1338685-1	PAWL, FEED	56
1	-	2	2	2-2168083-6	SCR, SKT HD CAP, RoHS, M4 X 18	53
	-	1	2	18023-9	SCR, SKT HD CAP M4 X 6.0	49
1	-	-	1	2119652-1	FEED CAM, PRE FEED	48
	-	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
1	-	1	1	1-1752356-3	SUPPORT, TERMINAL	34
	-	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
1	-	2	2	2-2844962-6	SPACER, CYLINDRICAL, STRIP GUIDE	30
	-	1	1	2844992-2	ASSEMBLY, STRIP GUIDE	29
1	-	1	1	1-455888-0	SPACER, CRIMPER	28
	-	1	1	1320928-6	STRIP GUIDE	24
1	-	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
	-	2	2	1-18028-2	WASHER, FLAT, REG M4	20
1	-	1	1	2119533-1	STRIPPER, SIDE FEED	19
	-	1	1	879657-2	HOLD DOWN	18
1	-	1	1	2119806-1	INSERT, SHEAR	13
	-	1	1	3-22280-3	SPRING, COMPRESSION	12
1	-	1	1	1-356885-4	STOP, SHEAR	11
	-	1	1	2119805-1	SHEAR HOLDER, FRONT	10
1	-	1	1	1803095-1	FLOATING SHEAR, FRONT	9
	1	1	1	5-1333202-3	ANVIL, COMBINATION	8
5	-	1	1	2-240641-5	SPACER	7
	-	1	1	2119757-1	DEPRESSOR, SHEAR	5
1	-	1	1	238011-9	BLOCK, CRIMPER SPACER	4
	1	1	1	1-2119784-8	CRIMPER, INSULATION O PREMIUM	3
1	-	1	1	455888-5	SPACER, CRIMPER	2
	1	1	1	9-657555-1	CRIMPER, WIRE PREMIUM	1
-77		-22	-21	PART NO	DESCRIPTION	ITEM NO

THIS DRAWING IS A CONTROLLED DOCUMENT.		OWN T.Y.YIN	23SEP2011	TE Connectivity		
DIMENSIONS:		CHK G.BAILEY	23SEP2011			
mm		APVD S.XI	23SEP2011	NAME Ocean Side Feed Applicator		
		TOLERANCES UNLESS OTHERWISE SPECIFIED:		PRODUCT SPEC		
		0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ±		APPLICATION SPEC		
MATERIAL		FINISH		SIZE CASE CODE DRAWING NO		
-		-		A1 - ©=2151045		
-		-		CUSTOMER ACCESSIBLE PRODUCTION DRAWING		
				SCALE 1:2 SHEET 3 OF 4 REV H		

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

REVISIONS					
P	LYR	DESCRIPTION	DATE	DWN	APVD
-	-	SEE SHEET 1	-	-	-

D

C

B

A

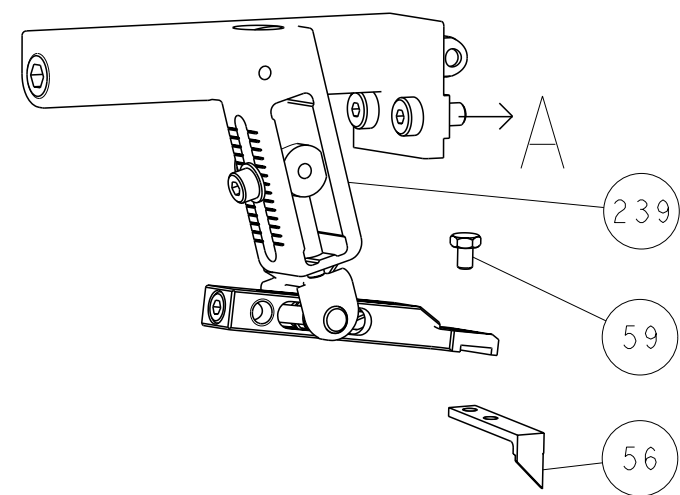
D

C

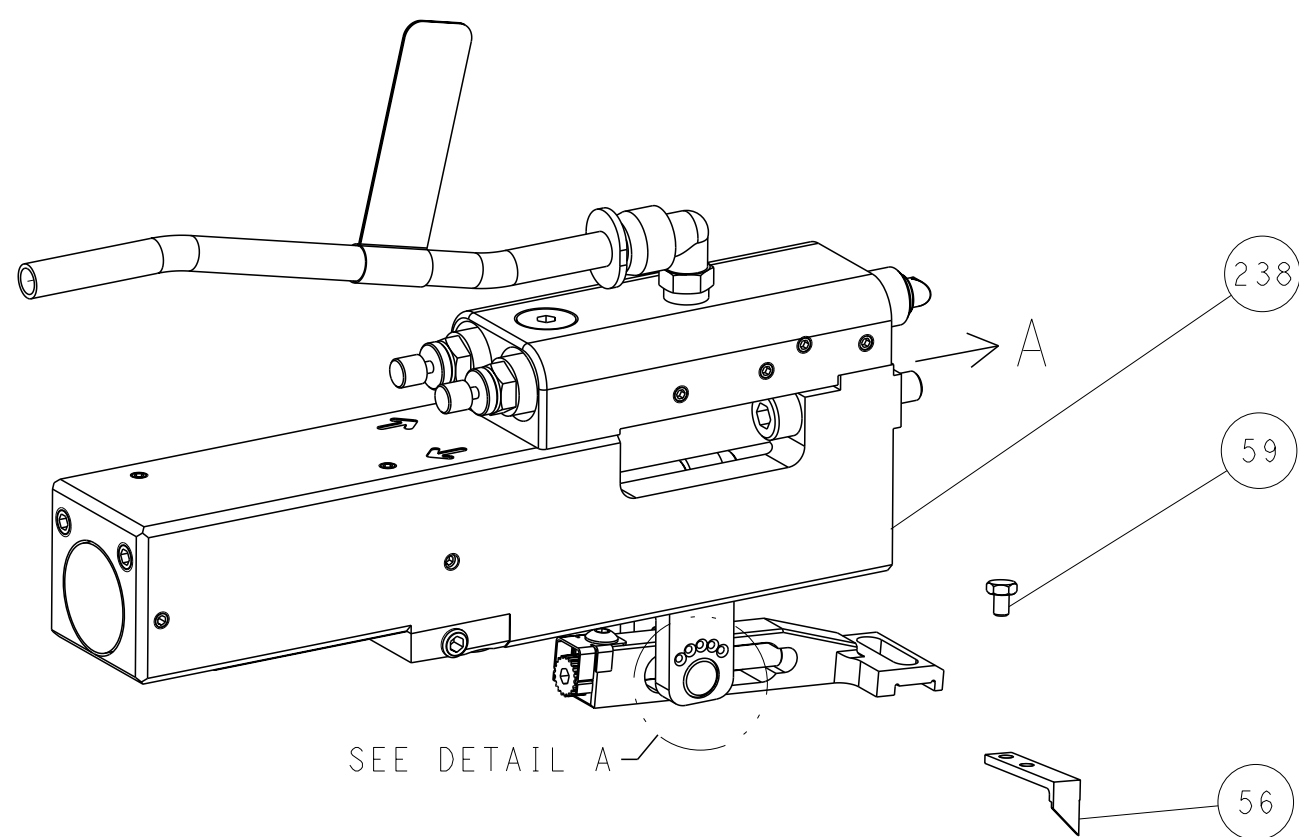
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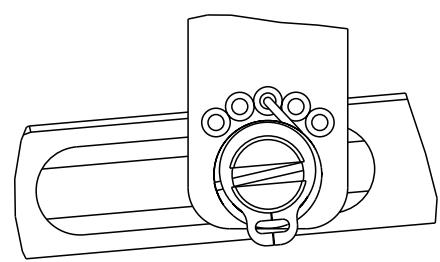
FEED TYPE MECHANICAL



PNEUMATIC

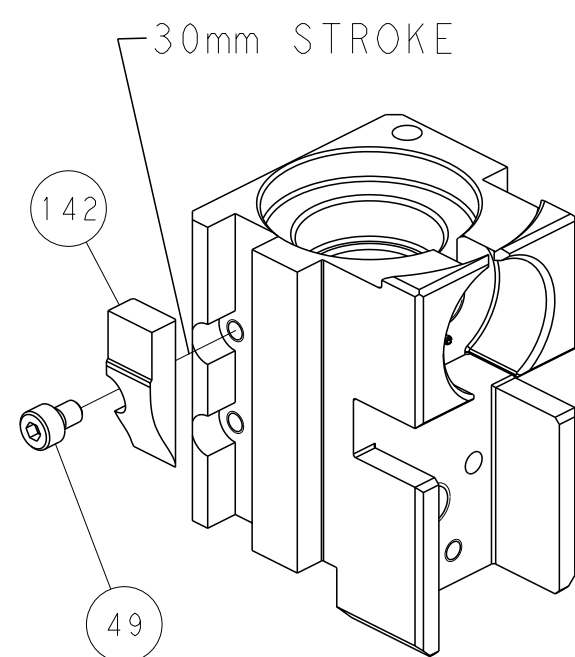


FEED SPRING SETTING POSITION
(SHOWN FROM REAR SIDE)

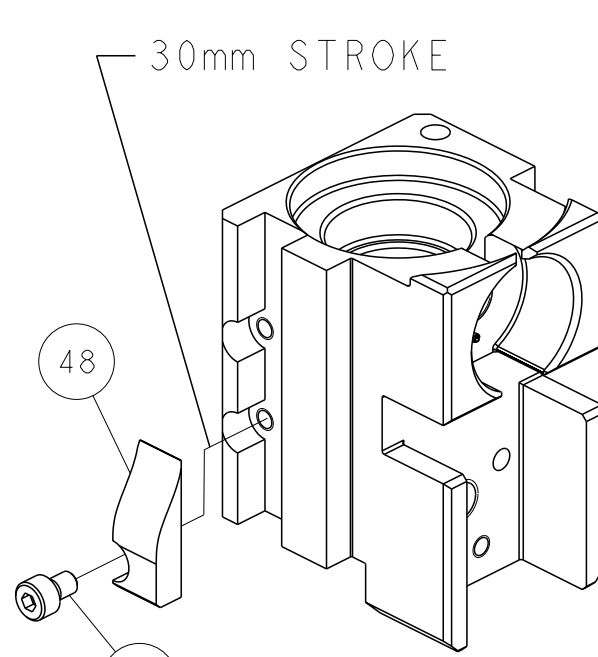


DETAIL A

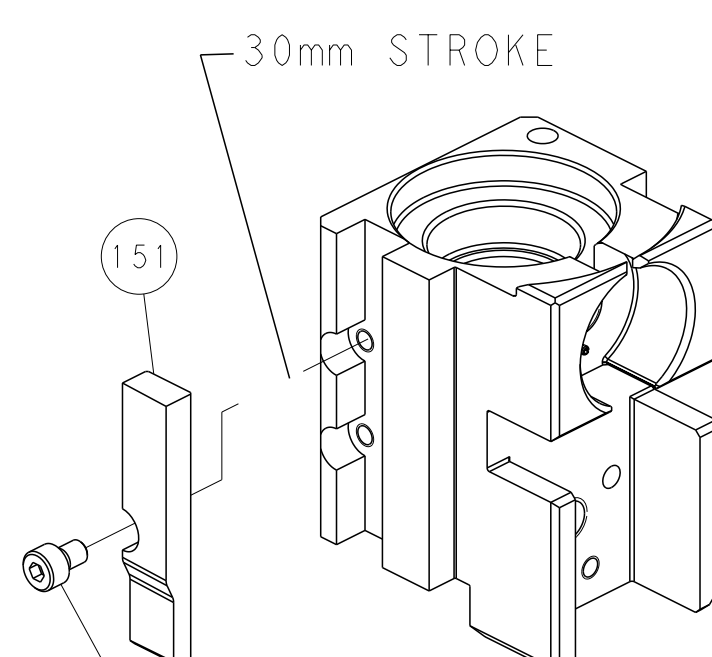
CAM POSITIONS



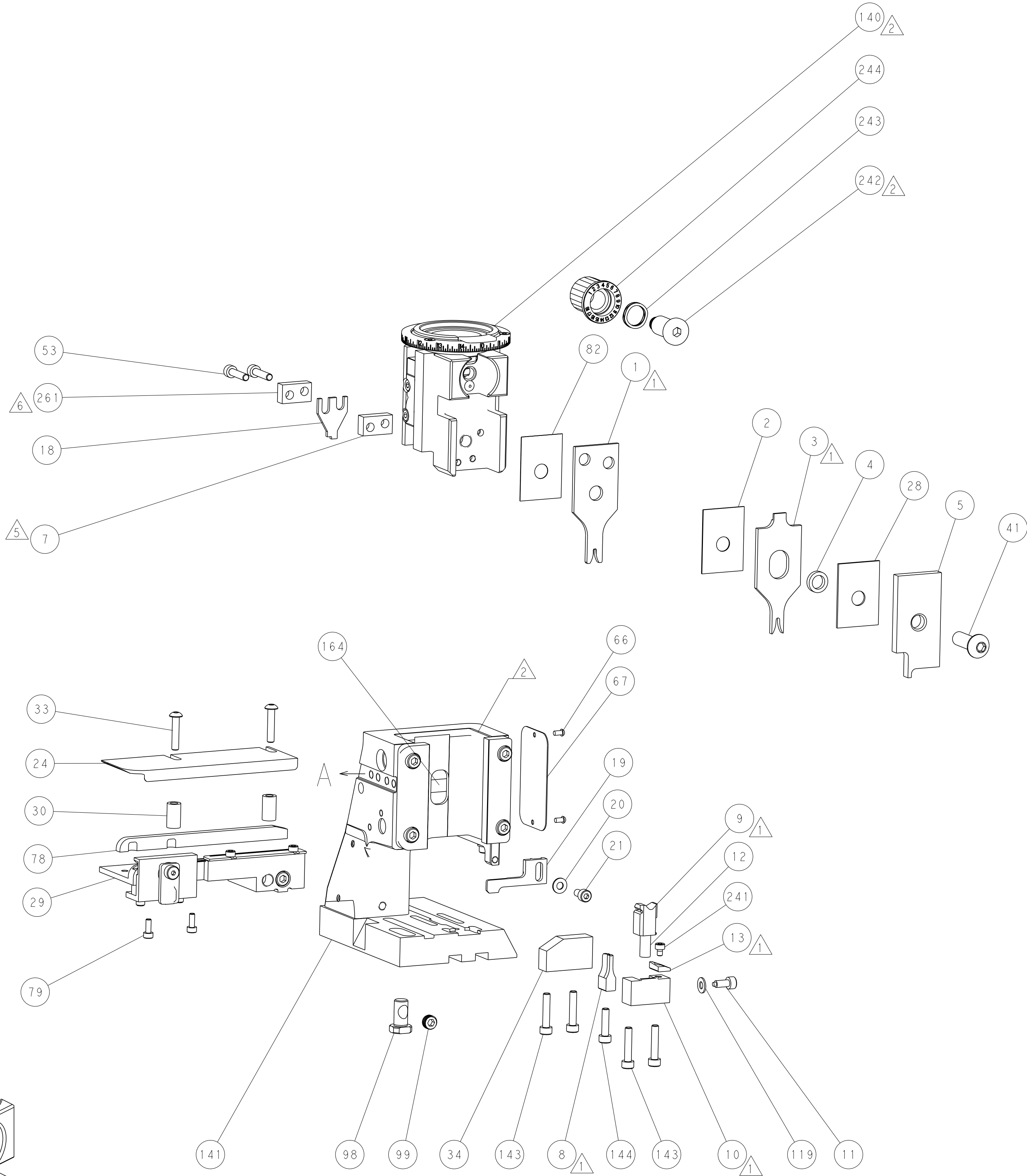
MECHANICAL
POST FEED



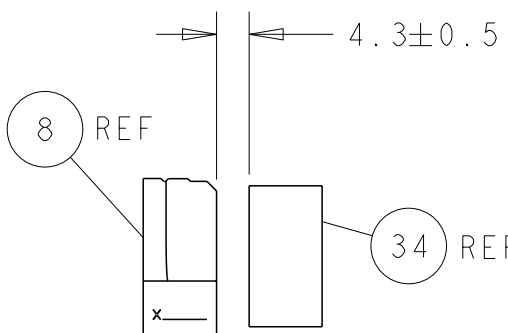
MECHANICAL
PRE FEED



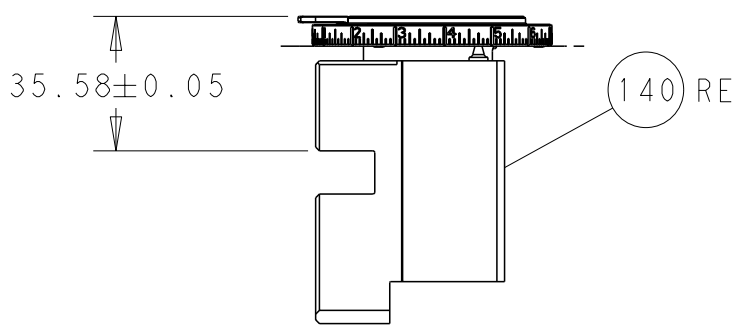
AIR FEED



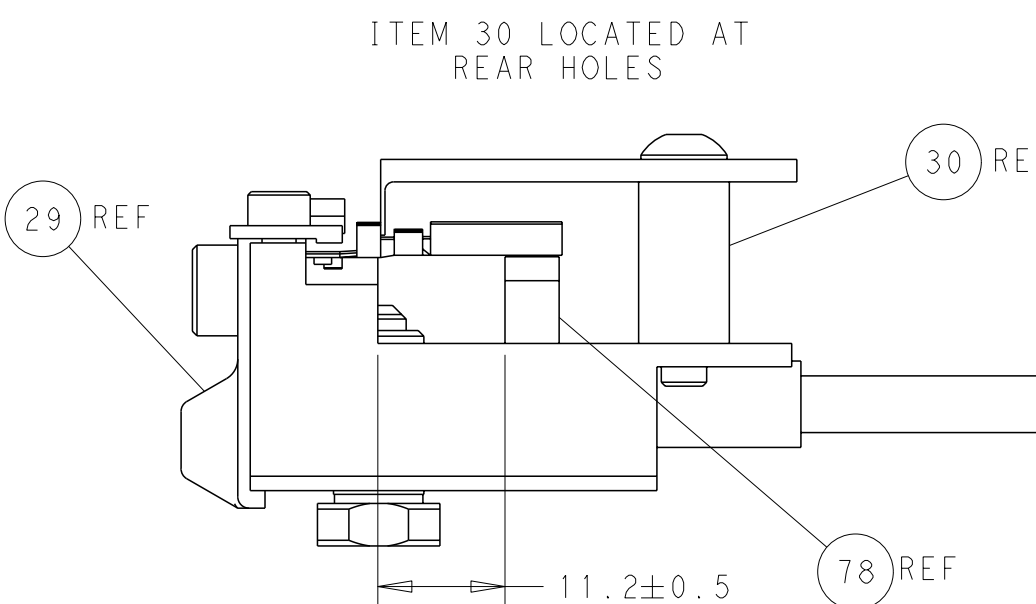
PACIFIC VERSION
Shown on sheets 3 of 4 & 4 of 4
(Atlantic version shown on sheets 1 of 4 & 2 of 4)



TERMINAL SUPPORT LOCATION



RAM SET-UP



FEED TRACK POSITION
GUIDE BY INSULATION BARREL

THIS DRAWING IS A CONTROLLED DOCUMENT.		DWN Y. YIN	23SEP2011	TE Connectivity	
DIMENSIONS:		CHK G. BAILEY	-		
TOLERANCES UNLESS OTHERWISE SPECIFIED:		APVD	-	NAME Ocean Side Feed Applicator	
mm		PRODUCT SPEC		SIZE	
0 PLC ±		APPLICATION SPEC		CAGE CODE	
1 PLC ±		WEIGHT		DRAWING NO	
2 PLC ±		CUSTOMER ACCESSIBLE PRODUCTION DRAWING		RESTRICTED TO	
3 PLC ±		SCALE		SHEET	
4 PLC ±		1:2		4	
ANGLES		REV		H	
FINISH		2151045		REV	

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION