

8	7	6	5	4	3	2	1
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE				
2151227-1	E	FINE CRIMP HEIGHT ADJUST	MECHANICAL				
2151227-2	F	FINE CRIMP HEIGHT ADJUST	PNEUMATIC				
5-2151227-1	E	SEAL STRIPPER CRIMPER TERMINATING UNIT	MECHANICAL				
5-2151227-2	F	SEAL STRIPPER CRIMPER TERMINATING UNIT	PNEUMATIC				
7-2151227-1	E	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL				
7-2151227-2	F	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC				
7-2151227-7	A	CRIMP TOOLING KIT	-				

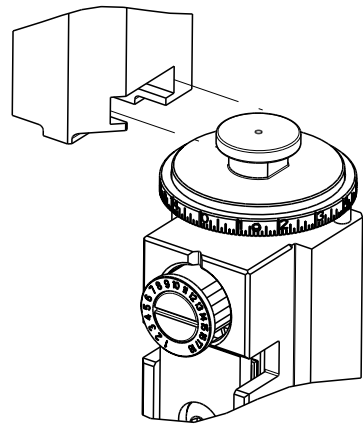
APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.03 mm [.080]	F
INSUL	4.06 mm [.160]	O
APPLICATOR INSTRUCTIONS 408-35042		

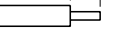
TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: 2.8MM SENSOR - FLAT TYPE RECEPTACLE			
WIRE STRIP LENGTH			INSULATION DIAMETER RANGE
4.20-4.80 mm [.165-.189 IN]			Ø1.40-2.10 mm [.055-.083 IN]
TERMINAL APPLICATION 		(B)114-18144-1	-
SPECIFICATION		-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE SEAL	TE SEAL
(B) 968087-1	(B) 968087-2	1572276-1	828904-1
(B) 1703034-1	(B) 1703034-2		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.00mm2	1.36+/-0.05 [.054+/- .002]	4.6
0.75mm2	1.27+/-0.05 [.050+/- .002]	5.5
0.50mm2	1.18+/-0.05 [.046+/- .002]	6.5

- 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
- 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.
- 6
- TERMINAL LUBRICANT IS RECOMMENDED.
7.
- UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.

ATLANTIC VERSION TERMINATOR
INTERFACE ADAPTER



TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: 2.8MM SENSOR - FLAT TYPE RECEPTACLE			
WIRE STRIP LENGTH 4.20-4.80 mm [.165-.189 IN]			INSULATION DIAMETER RANGE Ø1.30-2.10 mm [.051-.083 IN]
TERMINAL APPLICATION SPECIFICATION 	(A)114-18144-0	-	-
	(C)114-18148	-	-
TERMINALS APPLIED 			
TE TERMINAL	TE TERMINAL	TE SEAL	TE SEAL
(A) 967542-1	(C) 1-968855-2	1572276-1	828904-1
(A) 967542-2	(C) 1-968855-3		
(C) 1-968855-1	(C) 1-968855-4		

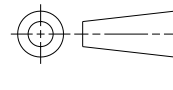
WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.00mm2	1.20+/-0.05 [.047+/- .002]	6.3
0.75mm2	1.18+/-0.05 [.046+/- .002]	6.5
0.50mm2	1.15+/-0.05 [.045+/- .002]	6.8

*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.

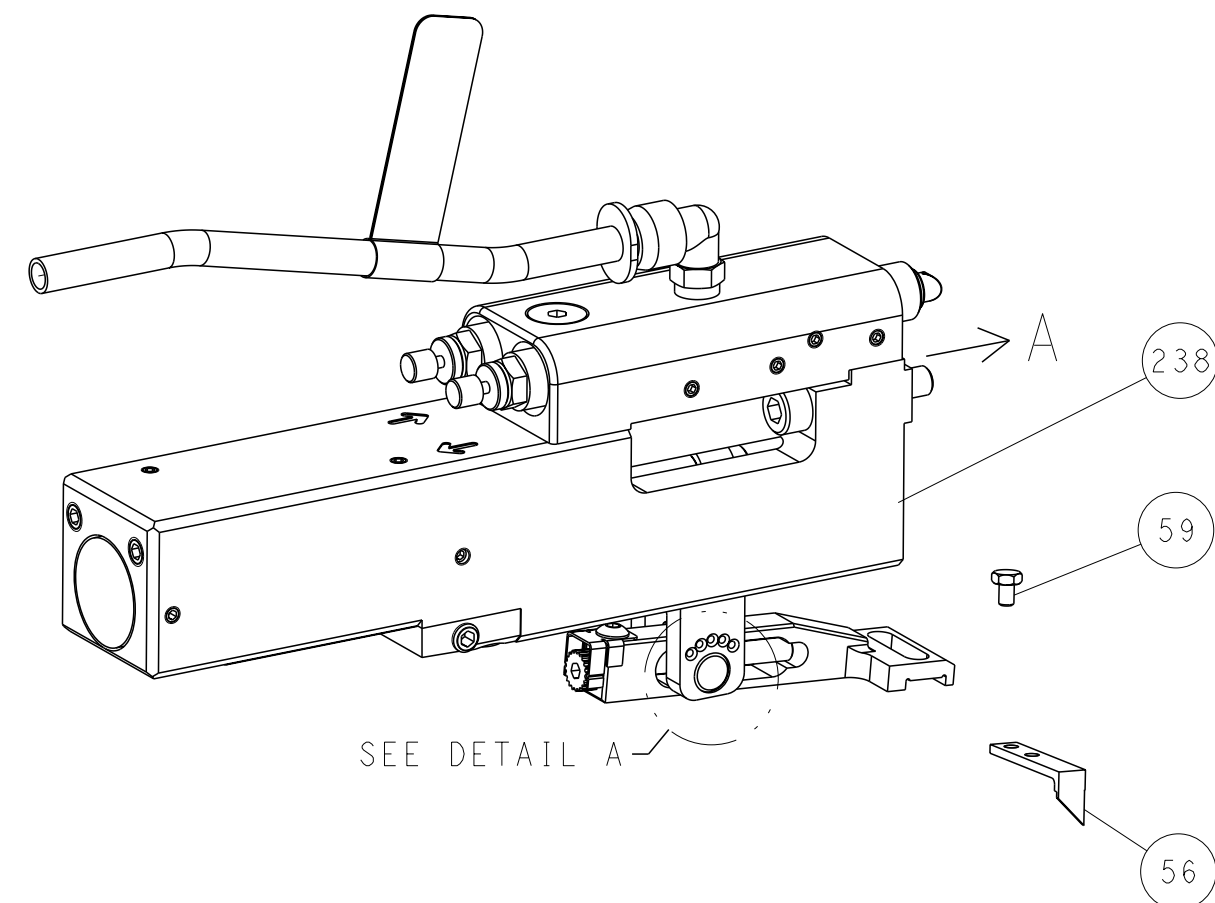
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

LOC	DIST	REVISIONS					
A	66	#	LYR	DESCRIPTION	DATE	DWN	APVD
			D2	ECR-17-013806	19SEP2017	RS	LZ
			E	ECR-18-006994	07MAY2018	JAH	JDG
			F	ECR-19-005557	05APR2019	JAH	CT

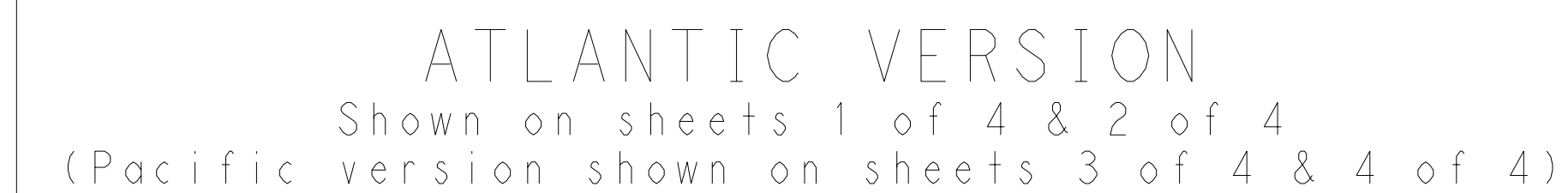
-	-	-	1	1	-	-	1803515-3	RAM ASSEMBLY, SF ATLANTIC	293
-	-	-	1	1	-	-	2-1803583-1	APPLICATOR BASIC ASSEMBLY, SF	292
-	1	-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248
-	1	1	1	1	1	1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
3	-	1	1	1	1	1	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
3	-	-	-	1	1	-	1-1752354-7	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	REF	REF	994970-2	COUNTER, MAGNETIC	164
6	-	1	1	1	1	1	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113
-	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	455888-5	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
5	-	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	2-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 14	53
-	1	1	1	1	1	1	1803382-6	HOLD DOWN, SPRING LOADED	50
-	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	1752356-4	SUPPORT, TERMINAL	34
-	2	2	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	2	2	2	2	3-2844962-0	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	1	1	1	1	2844992-2	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
-	2	2	1	1	2	2	1-18028-2	WASHER, FLAT, REG M4	20
-	1	1	-	-	1	1	2119533-1	STRIPPER, SIDE FEED	19
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	1	2	2	1	1	1	1333204-1	ANVIL, COMBINATION	8
-	1	1	1	1	1	1	2-240641-9	SPACER	7
-	-	-	-	-	-	-	-	-	6
-	1	1	1	1	1	1	2119781-1	DEPRESSOR, SHEAR	5
-	1	1	1	1	1	1	238011-9	BLOCK, CRIMPER SPACER	4
1	1	2	2	1	1	1	3-2119784-1	CRIMPER, INSULATION O PREMIUM	3
-	1	1	1	1	1	1	1-455888-0	SPACER, CRIMPER	2
1	1	2	2	1	1	1	1-456405-6	CRIMPER, WIRE PREMIUM	1

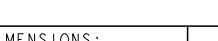
-77	-72	-71	-52	-51	-2	-1	PART NO	DESCRIPTION	ITEM NO
THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE AND TO CANCELLATION WITHOUT NOTICE. THE USER OF THIS DRAWING SHOULD BE CONTACTED FOR THE LATEST REVISION.							DWN Y. YIN 30NOV2011	 TE Connectivity Harrisburg, PA 17105-3608	
							CHK G. BAILEY 30NOV2011		
							APVD S. XI 30NOV2011		
							NAME		
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		PRODUCT SPEC		APPLICATION SPEC		SIZE CASE CODE DRAWING NO	
mm		0 PLC ±		-		-		A1 00779 ©=2151227	
		1 PLC ±		-		-		RESTRICTED TO	
		2 PLC ±		-		-		-	
		3 PLC ±		-		-		-	
		4 PLC ±		-		-		-	
MATERIAL		FINISH		WEIGHT		Customer Accessible Production Drawing		SCALE 1:2 SHEET 1 OF 4 REV F	

PNEUMATIC



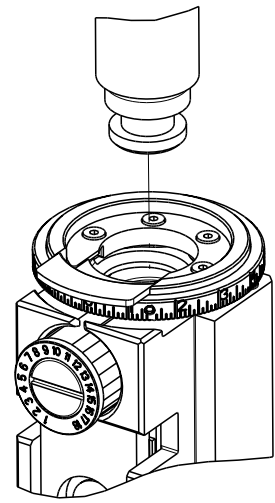
CAM POSITIONS



THIS DRAWING IS A CONTROLLED DOCUMENT FOR TSC ELECTRONICS CORPORATION IT IS SUBJECT TO THE DESIGN AND/OR MANUFACTURING ORGANIZATION POLICY AND SHALL BE CONTROLLED BY THE LATEST REVISION		DWN Y_YIN 30NOV2011 CHK G_BAILEY 30NOV2011 APVD S_XI 30NOV2011		 TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		NAME Ocean Side Feed Applicator -	
		PRODUCT SPEC - APPLICATION SPEC -		SIZE A1	
MATERIAL -		FINISH -		CAGE CODE 00779	
WEIGHT -		DRAWING NO C-151227		RESTRICTED TO -	
Customer Accessible Production Drawing					
SCALE 1:2		SHEET 2 of 4		REV F	

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20		20	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2151227-1	E	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2151227-2	F	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151227-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.03 mm [.080]	F
INSUL	4.06 mm [.160]	O
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: 2.8MM SENSOR - FLAT TYPE RECEPTACLE			
WIRE STRIP LENGTH			INSULATION DIAMETER RANGE
4.20-4.80 mm [.165-.189 IN]			Ø1.40-2.10 mm [.055-.083 IN]
TERMINAL APPLICATION SPECIFICATION	(B)114-18144-1	-	-
		-	-
TERMINALS APPLIED			
			
TE TERMINAL	TE TERMINAL	TE SEAL	TE SEAL
(B) 968087-1	(B) 968087-2	1572276-1	828904-1
(B) 1703034-1	(B) 1703034-2		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.00mm2	1.36+/-0.05 [.054+/- .002]	4.6
0.75mm2	1.27+/-0.05 [.050+/- .002]	5.5
0.50mm2	1.18+/-0.05 [.046+/- .002]	6.5

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: 2.8MM SENSOR - FLAT TYPE RECEPTACLE			
WIRE STRIP LENGTH 4.20-4.80 mm [.165-.189 IN]		INSULATION DIAMETER RANGE Ø1.30-2.10 mm [.051-.083 IN]	
TERMINAL APPLICATION SPECIFICATION	(A)114-18144-0	-	-
	(C)114-18148	-	-
TERMINALS APPLIED			
		6	
TE TERMINAL	TE TERMINAL	TE SEAL	TE SEAL
(A) 967542-1	(C) 1-968855-2	1572276-1	828904-1
(A) 967542-2	(C) 1-968855-3		
(C) 1-968855-1	(C) 1-968855-4		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.00mm2	1.20+/-0.05 [.047+/- .002]	6.3
0.75mm2	1.18+/-0.05 [.046+/- .002]	6.5
0.50mm2	1.15+/-0.05 [.045+/- .002]	6.8



- RECOMMENDED SPARE PARTS
- REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- 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 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.
- TERMINAL LUBRICANT IS RECOMMENDED.
- 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)

2		1						
LOC	DIST	REVISIONS						
A	66	P	LTR	DESCRIPTION	DATE	DWN	APVD	
		-		SEE SHEET 1	-	-	-	

-	1	1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	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	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113
-	1	1	2844908-1	SCREW, LOCKING	99
-	1	1	2844907-1	POST, LOCKING	98
-	1	1	455888-5	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
-	1	1	985575-3	SCR, FLT SKT HD CAP M3 X 10.0	57
-	1	1	1338685-1	PAWL, FEED	56
-	2	2	2-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 14	53
-	1	1	1803382-6	HOLD DOWN, SPRING LOADED	50
-	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	1752356-4	SUPPORT, TERMINAL	34
-	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	3-2844962-0	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	2844992-2	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
-	2	2	1-18028-2	WASHER, FLAT, REG M4	20
-	1	1	2119533-1	STRIPPER, SIDE FEED	19
-	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	318707-1	FLOATING SHEAR, FRONT	9
-	1	1	1333204-1	ANVIL, COMBINATION	8
-	1	1	2-240641-9	SPACER	7
-	-	-	-	-	6
-	1	1	2119781-1	DEPRESSOR, SHEAR	5
-	1	1	238011-9	BLOCK, CRIMPER SPACER	4
-	1	1	3-2119784-1	CRIMPER, INSULATION O PREMIUM	3
-	1	1	1-455888-0	SPACER, CRIMPER	2
-	1	1	1-456405-6	CRIMPER, WIRE PREMIUM	1

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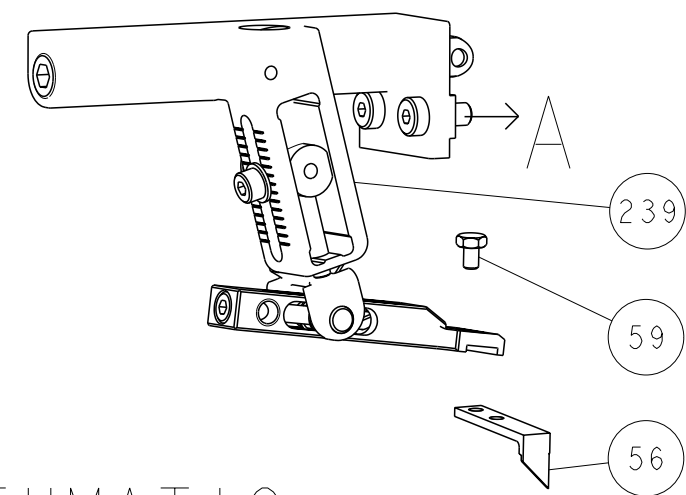
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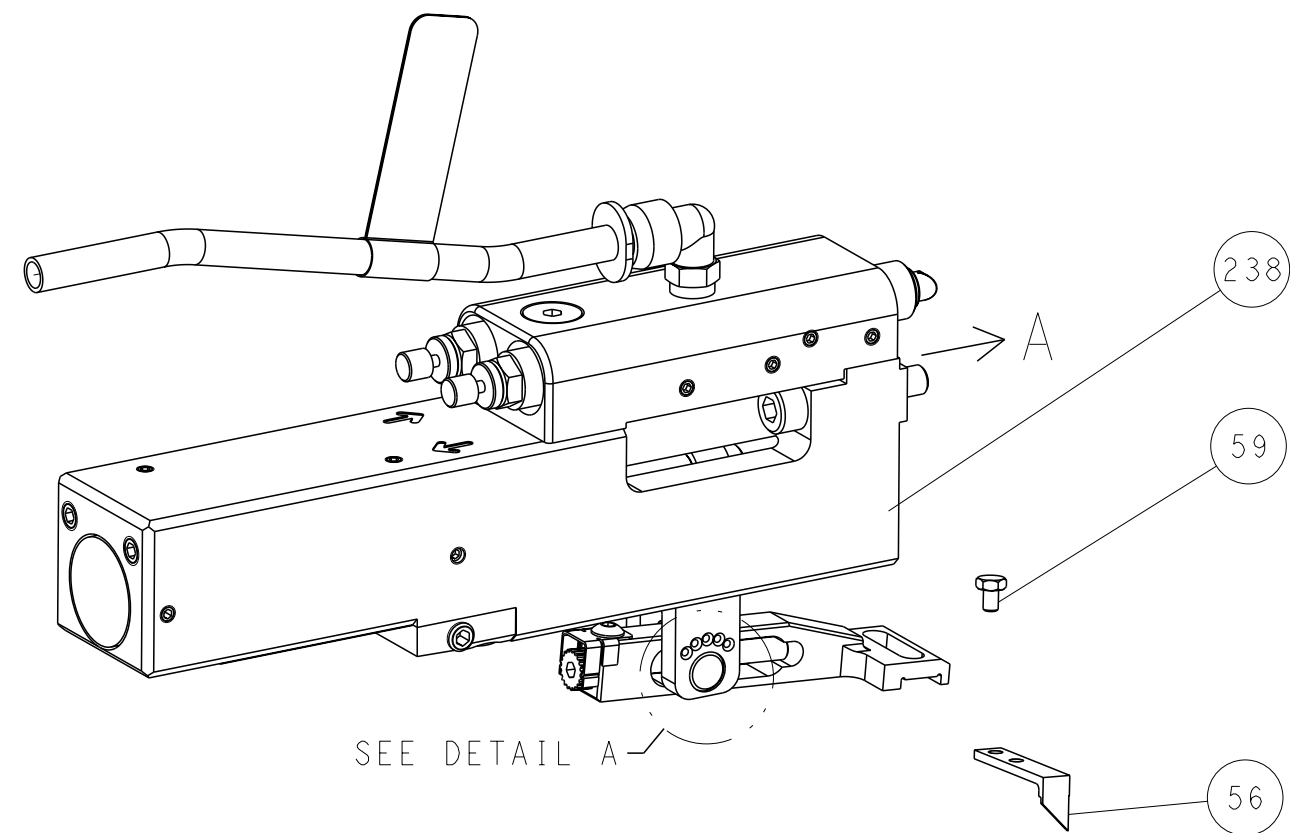
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DIMENSIONS:		CHK	G. BAILEY	30NOV2011	NAME		
mm		APVD	S. XI	30NOV2011	Ocean Side Feed Applicator		
TOLERANCES UNLESS OTHERWISE SPECIFIED:		PRODUCT SPEC		SIZE			
0 PLC ±		APPLICATION SPEC		CASE CODE			
1 PLC ±		WEIGHT		DRAWING NO			
2 PLC ±		RESTRICTED TO		00779			
3 PLC ±		Customer Accessible Production Drawing		SCALE			
4 PLC ±		1:2		SHEET 3 OF 4			
ANGLES FINISH		REV		F			

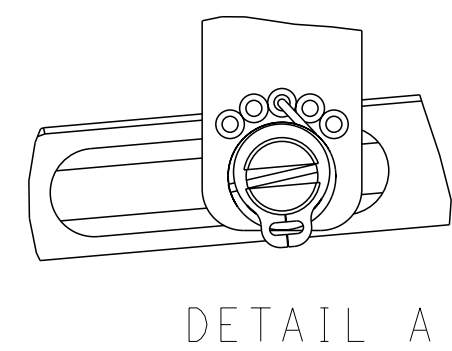
FEED TYPE MECHANICAL



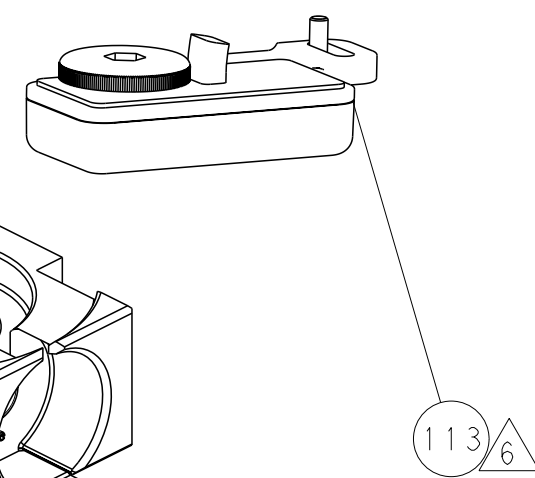
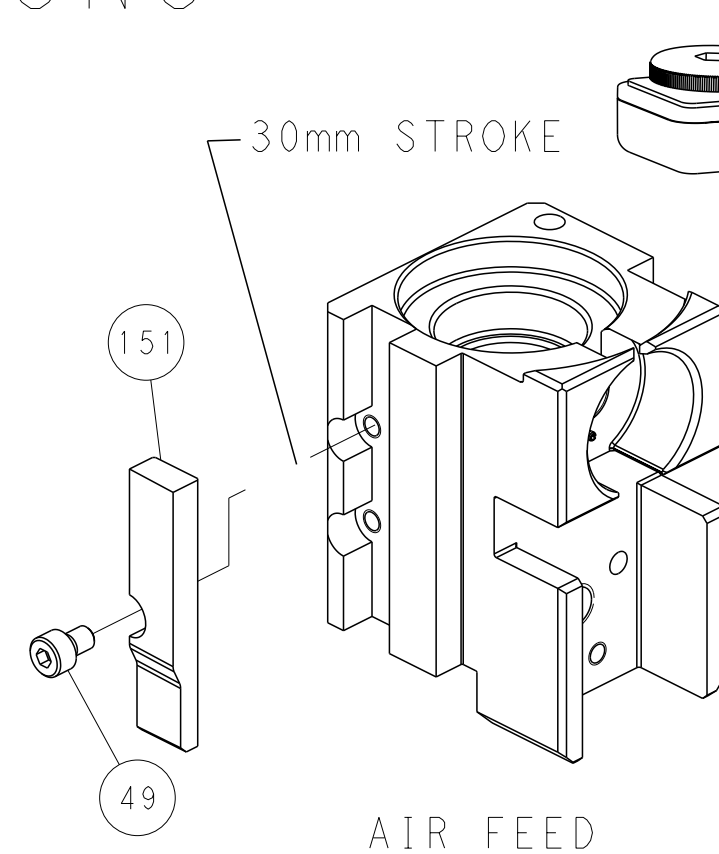
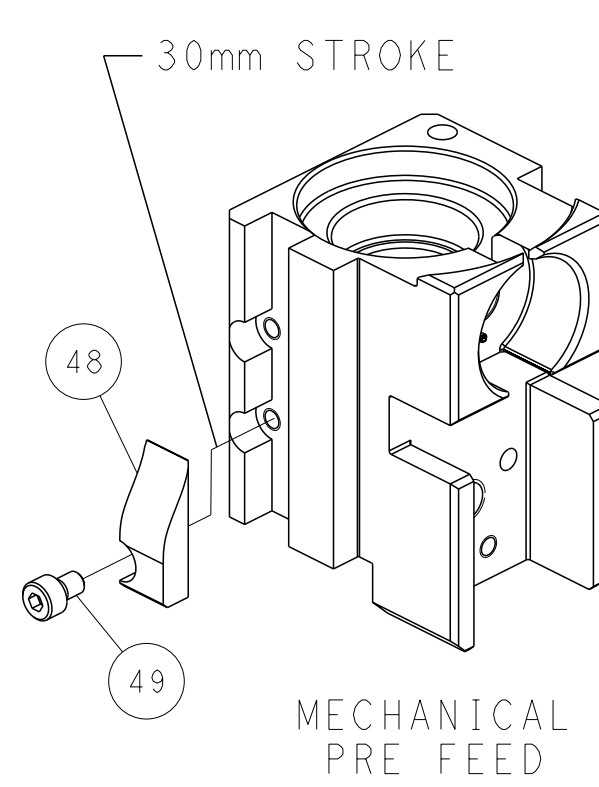
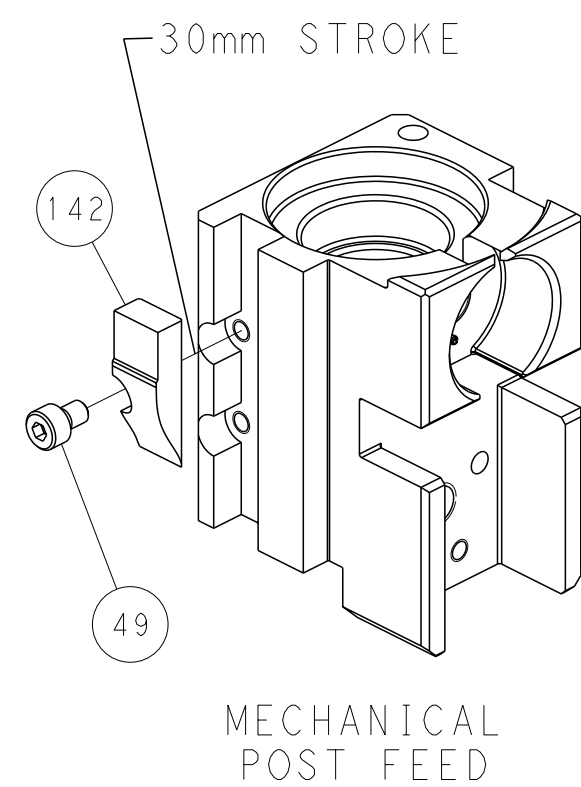
PNEUMATIC



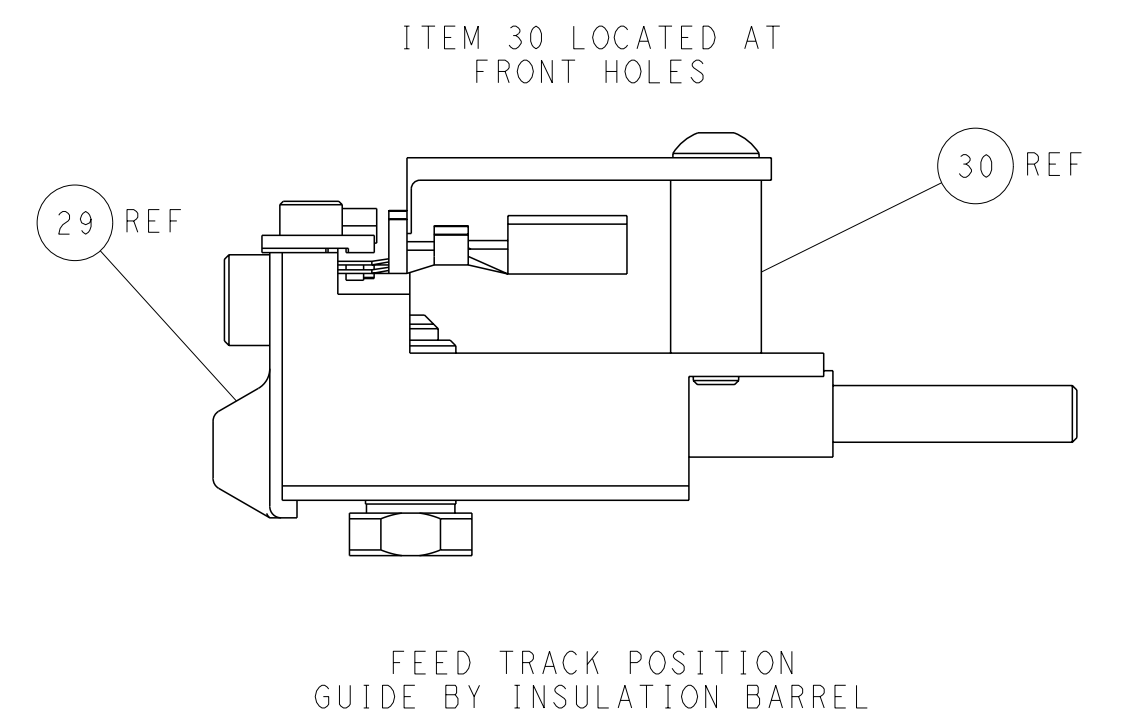
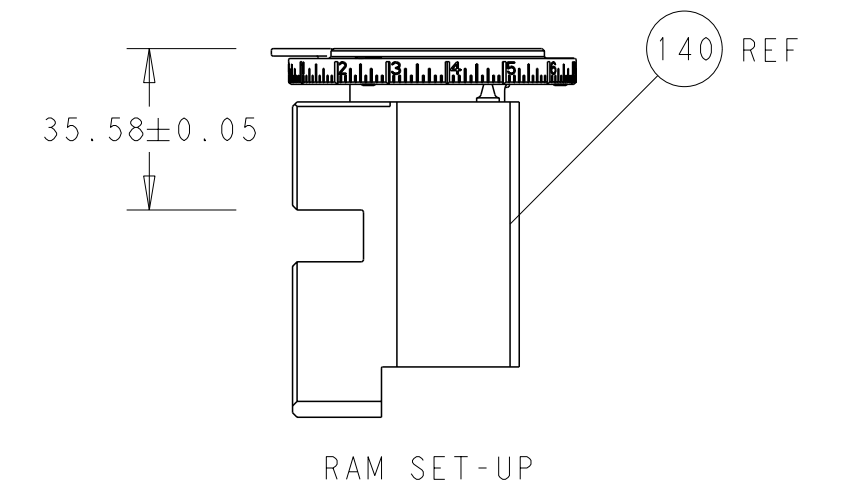
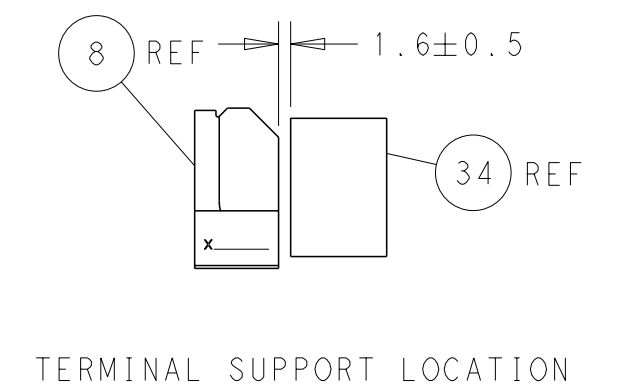
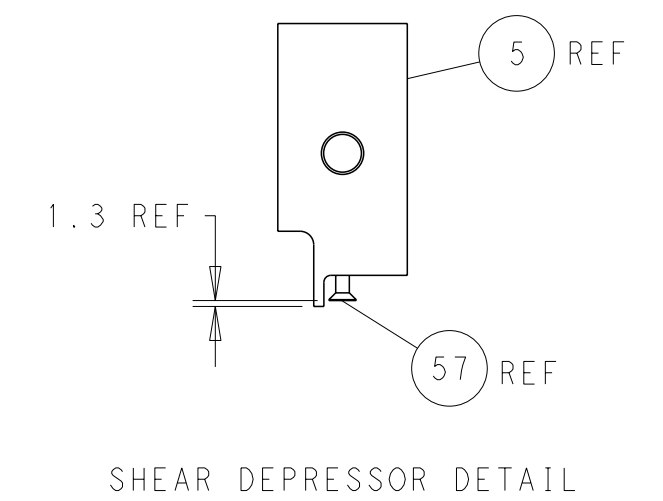
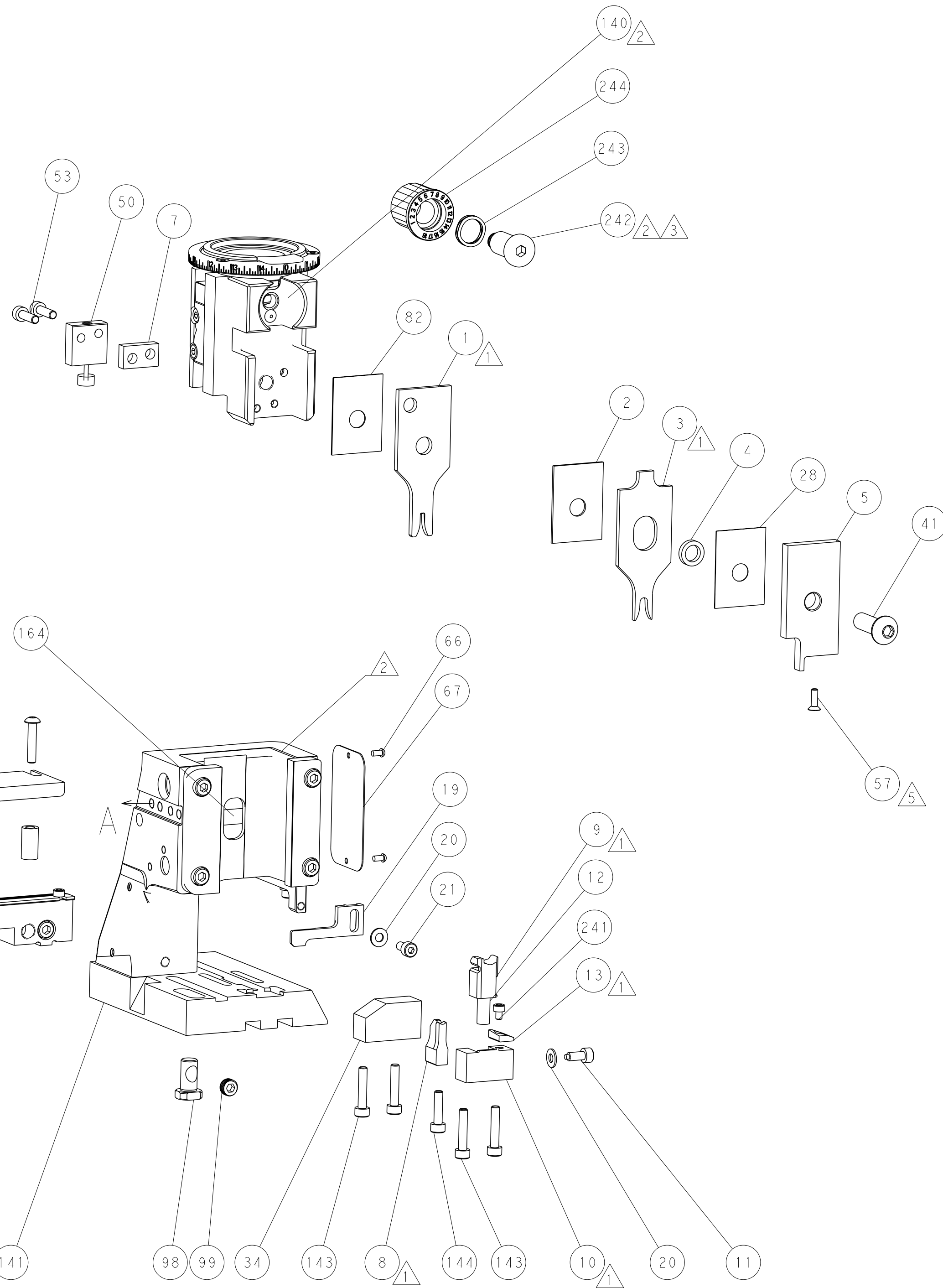
FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



CAM POSITIONS



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



THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION IT IS SUBJECT TO CHANGE AND TO THE CONTROL AND ENGINEERING ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST REVISION		DWN Y. YIN	30NOV2011	 TE Connectivity Harrisburg, PA 17105-3608	
		CHK G. BAILEY	30NOV2011		
		APVD S. YI	30NOV2011	NAME Ocean Side Feed Applicator	
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		PRODUCT SPEC	
		0 PLC ±		APPLICATION SPEC	
		1 PLC ±			
		2 PLC ±			
		3 PLC ±			
		4 PLC ±			
		ANGLES ±			
MATERIAL		FINISH		WEIGHT	
				Customer Accessible Production Drawing	
				SCALE 1:2	
				SHEET 4 OF 4	
				REV F	

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION