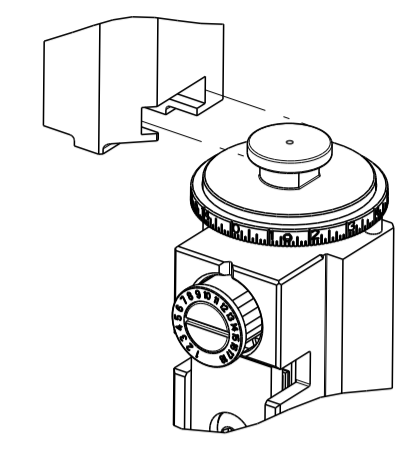


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151414-1	F	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2151414-2	F	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
5-2151414-1	F	SEAL STRIPPER CRIMPER TERMINATING UNIT	MECHANICAL
5-2151414-2	F	SEAL STRIPPER CRIMPER TERMINATING UNIT	PNEUMATIC
7-2151414-1	F	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2151414-2	F	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2151414-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



PART NUMBER	REVISION	DESCRIPTION	CONVERT FROM
7-2151414-8	A	APPLICATOR CONVERSION KIT	2837837-X

ACTION LIST	
REPLACE #8	8
REPLACE #3	3
REPLACE #1	1
-78 ACTION	ITEM NO

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.44 mm [.096]	F
INSUL	4.32 mm [.170]	O

APPLICATOR INSTRUCTIONS
408-35042

TERMINAL DATA: DELPHI TERMINAL DELPHI PACKARD CRIMP SPECIFICATION	
TERMINAL NAME: TAXI TERM F M/P 280 SEALED	
WIRE STRIP LENGTH 5.20-6.00 mm [2.05-.236 1N]	INSULATION DIAMETER RANGE Ø
TERMINAL APPLICATION SPECIFICATION (A)12077411 PAGE 37 OF 54 (B)12077411 PAGE 42 OF 54 (C)12077411 PAGE 43 OF 54 (D)12176389	

TE TERMINAL	DELPHI TERMINAL	TE SEAL	DELPHI SEAL	SEAL INSULATION DIAMETER RANGE
(B) 286650-1	(B) 12077411	(BC) 1949092-1	(BC) 15324985	1.60-2.15
(D) 286650-2	(D) 12176389	(A) 1949807-2	(A) 15324984	2.03-2.42

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
FLRY-A 1mm ²	1.40+/-0.05 [.055+/-0.002]	4.7
AVSS 0.85mm ²	1.35+/-0.05 [.053+/-0.002]	5.1
AVSS 0.5mm ²	1.25+/-0.05 [.049+/-0.002]	6.5

- ⚠ 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. APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 180.
- ⚠ 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.
- 6. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- ⚠ 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	REV	LTM	DESCRIPTION	DATE	OWN	APPD
A	66						
		C		ECR-18-009282	14JUN2018	AW	GB
		D		ECR-19-010140	27JUN2019	TB	GB
		E		ECR-20-008010	04JUN2020	TB	GB
		F		ECR-21-006590	29JUN2021	MEH	RR

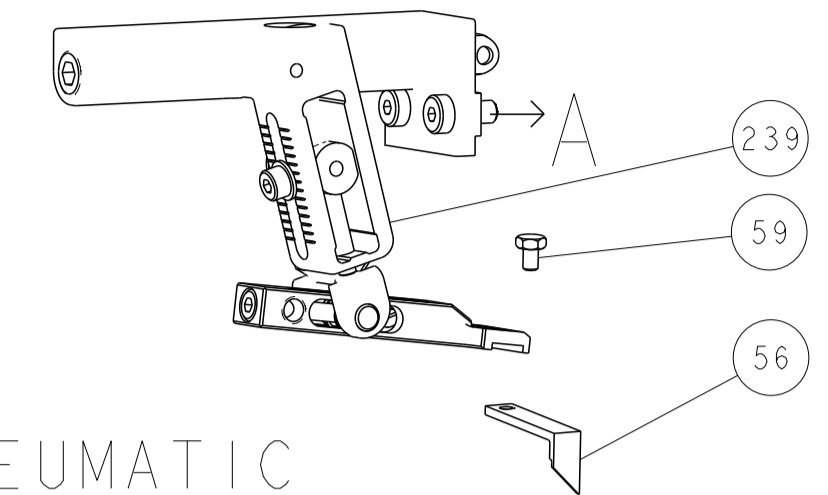
-	-	-	-	1	1	-	-	1803515-3	RAM ASSEMBLY, SF ATLANTIC		293								
-	-	-	-	1	1	-	-	2-1803583-1	APPLICATOR BASIC ASSEMBLY, SF		292								
-	-	1	-	1	-	1	-	2119641-1	FEED CAM, AIR FEED		248								
-	-	1	1	1	1	1	1	2119082-2	CAM, SNAIL, INSULATION ADJUSTMENT		244								
-	-	1	1	1	1	1	1	2079764-1	WASHER, 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	-	2119580-1	MECHANICAL FEED ASSEMBLY		239								
-	-	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	-	-	1-1752354-9	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	REF	REF	994970-2	COUNTER, MAGNETIC		164								
⚠	-	1	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								
⚠	-	1	1	1	1	1	1	985575-3	SCR, FLT SKT HD CAP M3 X 10.0		57								
-	-	1	1	1	1	1	1	1338683-8	FEED PAWL		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	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0		53								
-	-	1	1	1	1	1	1	5018030-1	NUT, HEX, REG, RoHS, M3		52								
-	-	1	1	1	1	1	1	811242-5	BUMPER, HOLD DOWN		51								
-	-	1	1	1	1	1	1	690753-2	SPACER, TONKER		50								
-	-	1	2	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	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)		41								
-	-	1	1	1	1	1	1	1752356-1	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	455888-5	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	1633711-1	ANVIL, COMBINATION		8								
-	-	1	1	1	1	1	1	3-240641-4	SPACER		7								
-	-	-	-	-	-	-	-	-	-		6								
-	-	1	1	1	1	1	1	2119781-1	DEPRESSOR, SHEAR		5								
-	-	1	1	1	1	1	1	238011-2	BLOCK, CRIMPER SPACER		4								
⚠	1	1	2	2	1	1	1	4-1633965-2	CRIMPER, INSULATION O PREMIUM		3								
-	-	1	1	1	1	1	1	455888-8	SPACER, CRIMPER		2								
⚠	1	1	2	2	1	1	1	1490019-3	CRIMPER, WIRE PREMIUM		1								

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

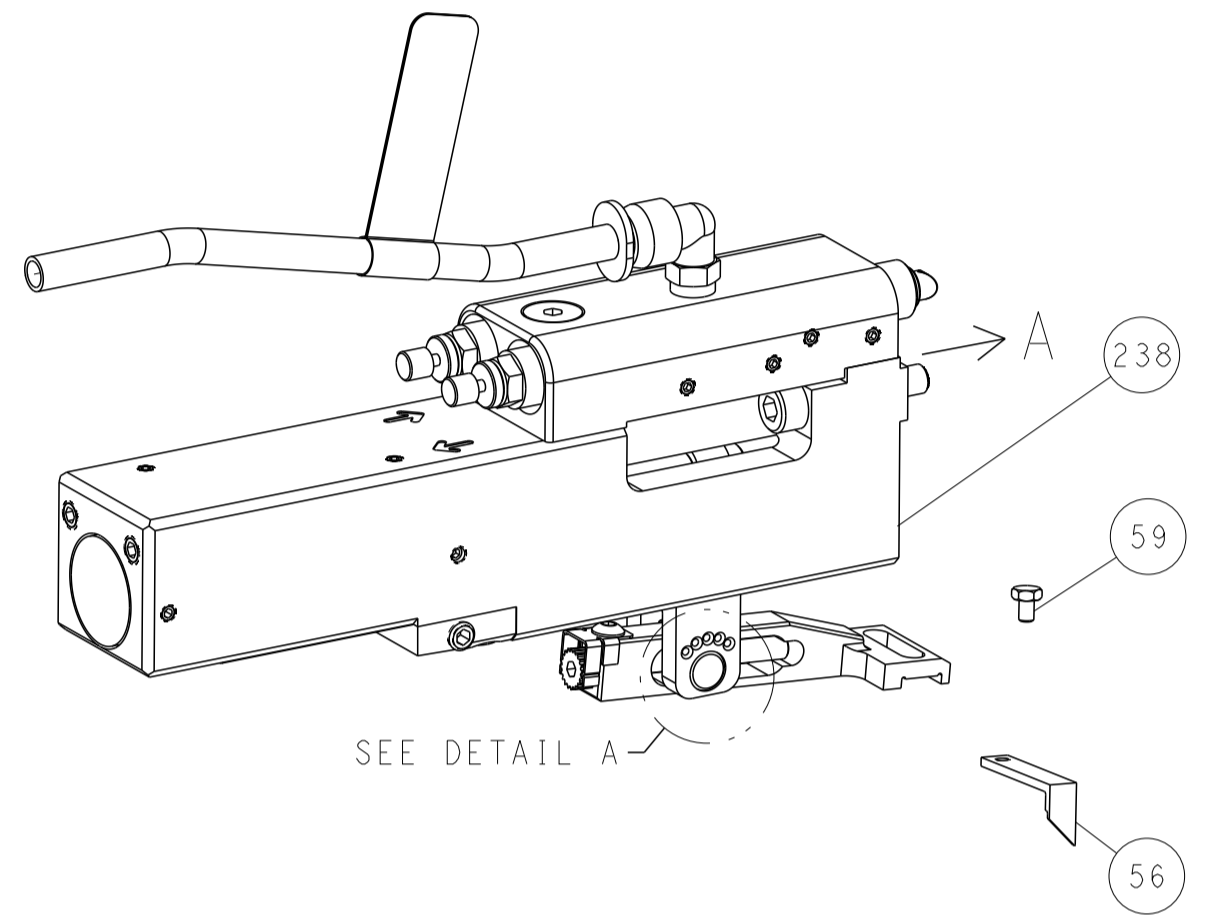
<small>THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION. COPYRIGHT © BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.</small> <small>THESE DIMENSIONS ARE UNLESS OTHERWISE SPECIFIED. DIMENSIONS ARE IN MILLIMETERS. DIMENSIONS IN PARENTHESES ARE IN INCHES.</small>		OWN: J. HUANG 31 JUL 2015 CHK: L. ZHANG 31 JUL 2015 APD: J. GUO 31 JUL 2015	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 CAGE CODE: 00779 DRAWING NO: ©=2151414 RESTRICTED TO: F	CUSTOMER ACCESSIBLE PRODUCTION DRAWING SCALE: 1:2 SHEET: 1 OF 4 REV: F

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

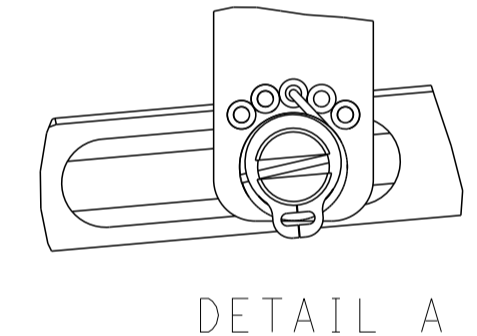
FEED TYPE MECHANICAL



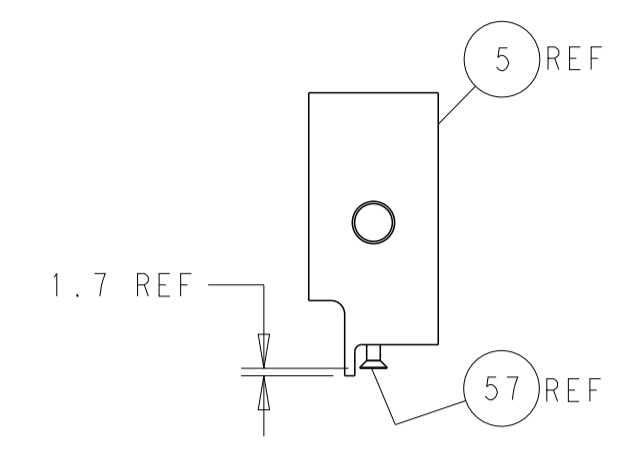
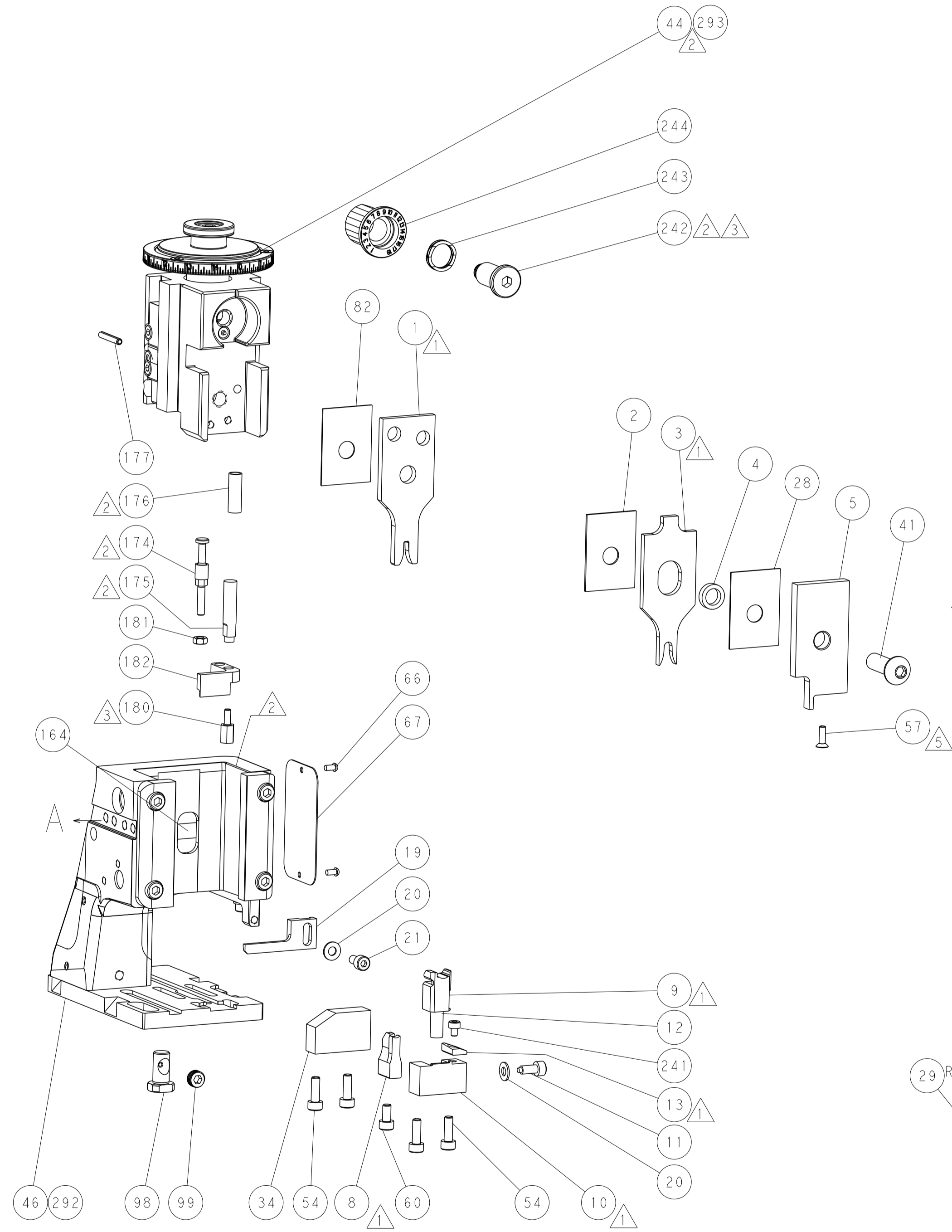
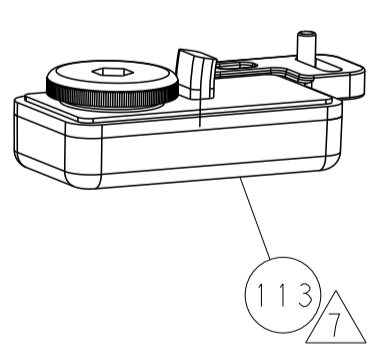
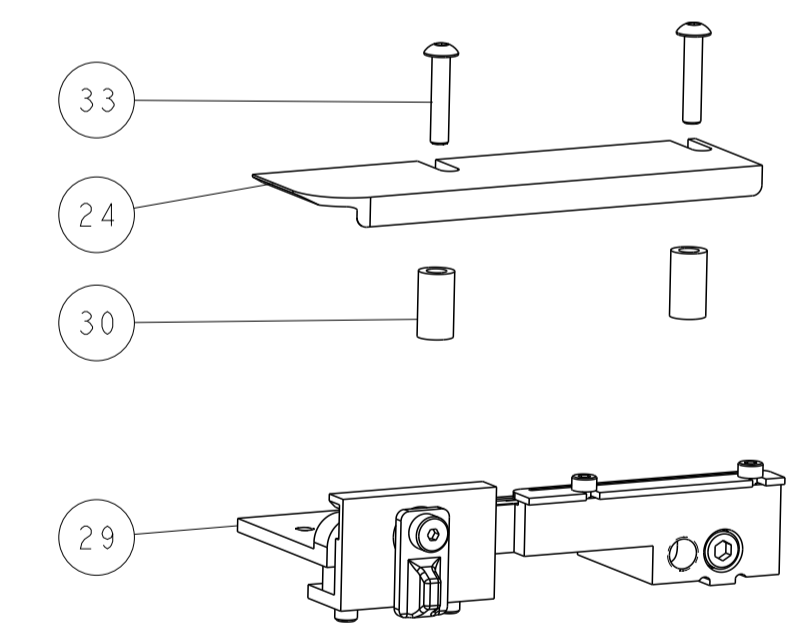
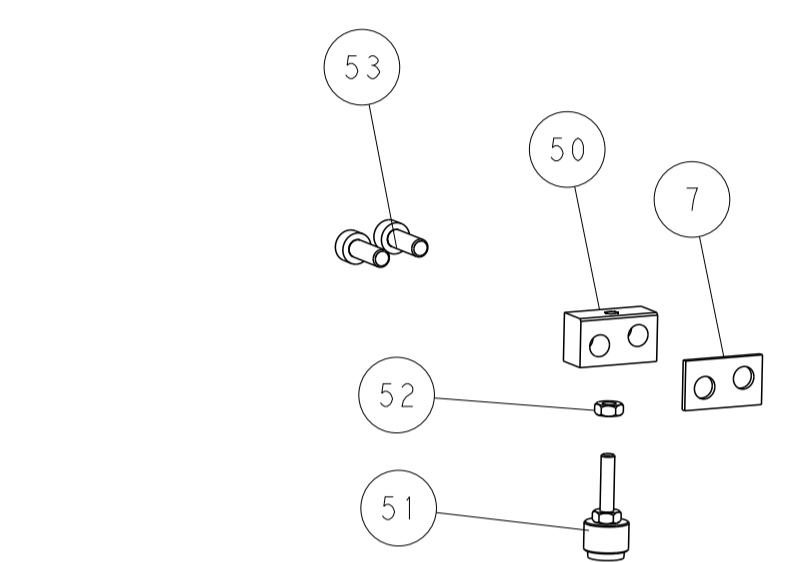
PNEUMATIC



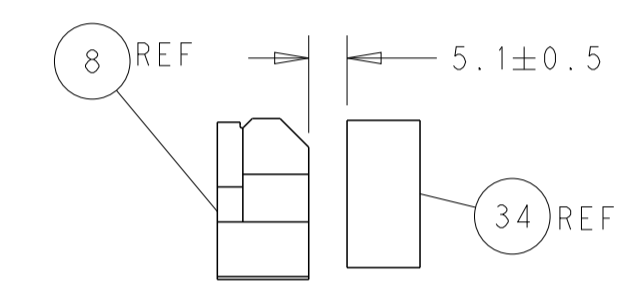
FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



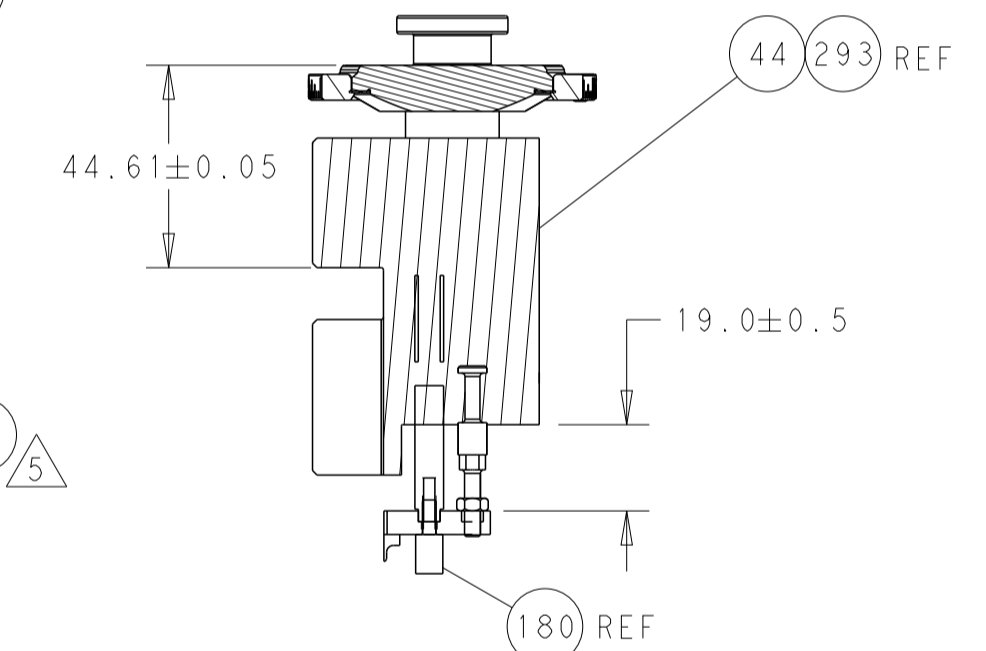
DETAIL A



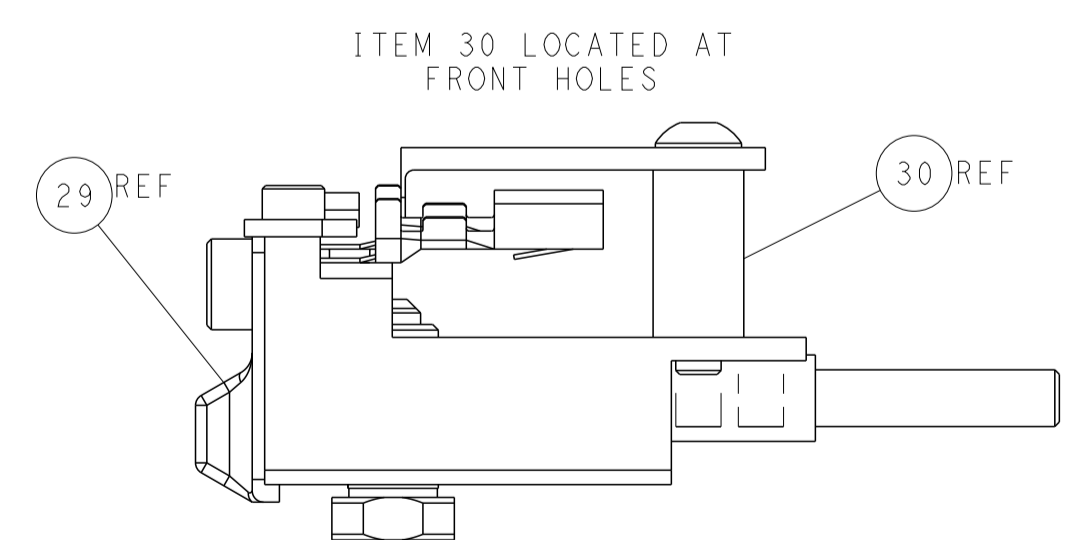
SHEAR DEPRESSOR DETAIL



TERMINAL SUPPORT LOCATION

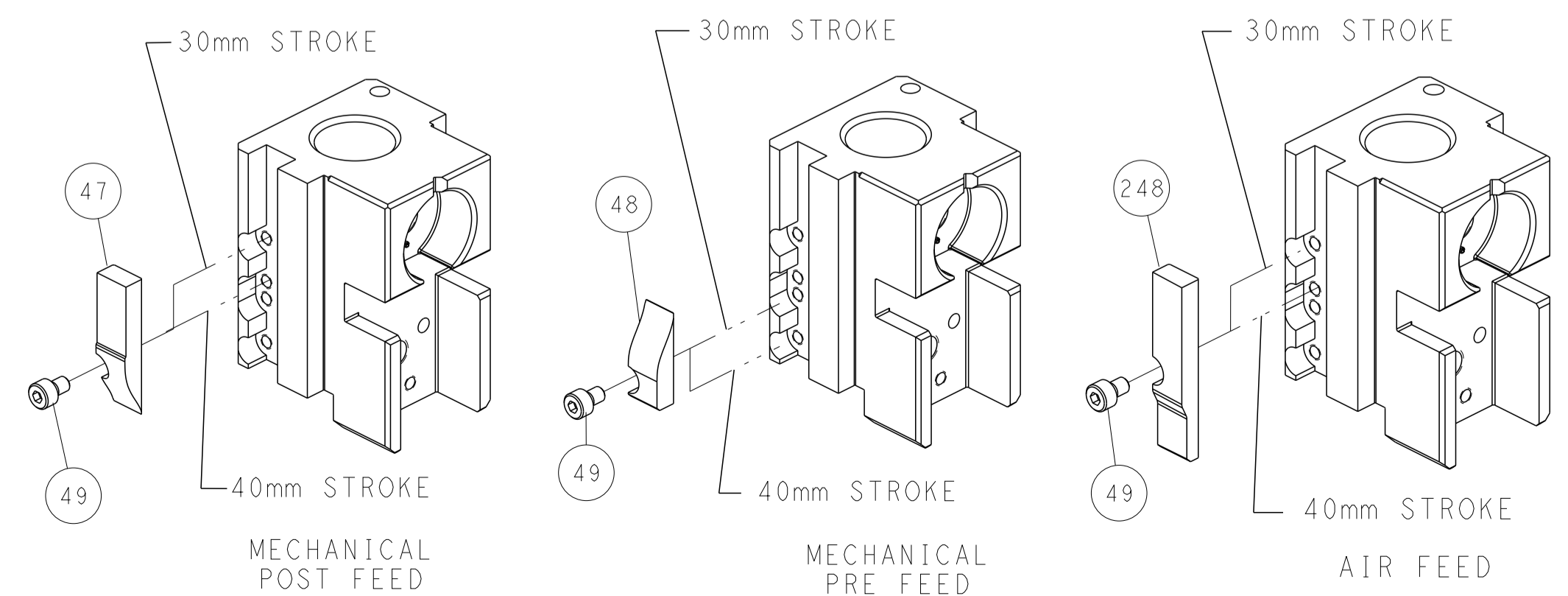


RAM AND HOLDDOWN SET-UP



FEED TRACK POSITION GUIDE BY INSULATION BARREL

CAM POSITIONS



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

<small>THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.</small>		DWN: R. HUANG 31 JUL 2015 CHK: L. ZHANG 31 JUL 2015 APVD: J. GUO 31 JUL 2015	NAME: Ocean Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2151414 SCALE: 1:2 SHEET: 2 of 4 REV: F
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH	TOLERANCES UNLESS OTHERWISE SPECIFIED: ± ± ± ± ±	TE Connectivity Harrisburg, PA 17105-3608	RESTRICTED TO:

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2151414-1	F	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2151414-2	F	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151414-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
 INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.44 mm [.096]	F
INSUL	4.32 mm [.170]	O

APPLICATOR INSTRUCTIONS
 408-35042

PART NUMBER	REVISION	DESCRIPTION	CONVERT FROM
7-2151414-8	A	APPLICATOR CONVERSION KIT	2837837-X

ACTION LIST	
REPLACE #8	8
REPLACE #3	3
REPLACE #1	1
-78 ACTION	ITEM NO

TERMINAL DATA: DELPHI TERMINAL	DELPHI PACKARD CRIMP SPECIFICATION
TERMINAL NAME: TAXI TERM F M/P 280 SEALED	
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE
5.20-6.00 mm [1.205-.236 IN]	∅
TERMINAL APPLICATION SPECIFICATION	(A)12077411 PAGE 37 OF 54 (B)12077411 PAGE 42 OF 54 (C)12077411 PAGE 43 OF 54 (D)12176389

TE TERMINAL	DELPHI TERMINAL	TE SEAL	DELPHI SEAL	SEAL INSULATION DIAMETER RANGE
(B) 286650-1	(B) 12077411	(BC) 1949092-1	(BC) 15324985	1.60-2.15
(D) 286650-2	(D) 12176389	(A) 1949807-2	(A) 15324984	2.03-2.42

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
FLRY-A 1mm ²	1.40 +/- 0.05 [0.055 +/- .002]	4.7
AVSS 0.85mm ²	1.35 +/- 0.05 [0.053 +/- .002]	5.1
AVSS 0.5mm ²	1.25 +/- 0.05 [0.049 +/- .002]	6.5



- 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. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- 7 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					
		P	LTN	DESCRIPTION	DATE	OWN	APVD
A	66	-	-	SEE SHEET 1	-	-	-

-	-	1	1	2119082-2	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	-	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
7	-	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
5	-	1	1	985575-3	SCR, FLT SKT HD CAP M3 X 10.0	57
-	-	1	1	1338683-8	FEED PAWL	56
-	-	2	2	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	53
-	-	1	1	5018030-1	NUT, HEX, REG, RoHS, M3	52
-	-	1	1	811242-5	BUMPER, HOLD DOWN	51
-	-	1	1	690753-2	SPACER, TONKER	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	1752356-1	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	455888-5	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	1	2119806-1	INSERT, SHEAR	13
-	-	1	1	3-22280-3	SPRING, COMPRESSION	12
-	-	1	1	1-356885-4	STOP, SHEAR	11
1	-	1	1	2119805-1	SHEAR HOLDER, FRONT	10
1	-	1	1	318707-1	FLOATING SHEAR, FRONT	9
1	1	1	1	1633711-1	ANVIL, COMBINATION	8
-	-	1	1	3-240641-4	SPACER	7
-	-	-	-	-	-	6
-	-	1	1	2119781-1	DEPRESSOR, SHEAR	5
-	-	1	1	238011-2	BLOCK, CRIMPER SPACER	4
1	1	1	1	4-1633965-2	CRIMPER, INSULATION O PREMIUM	3
-	-	1	1	455888-8	SPACER, CRIMPER	2
1	1	1	1	1490019-3	CRIMPER, WIRE PREMIUM	1

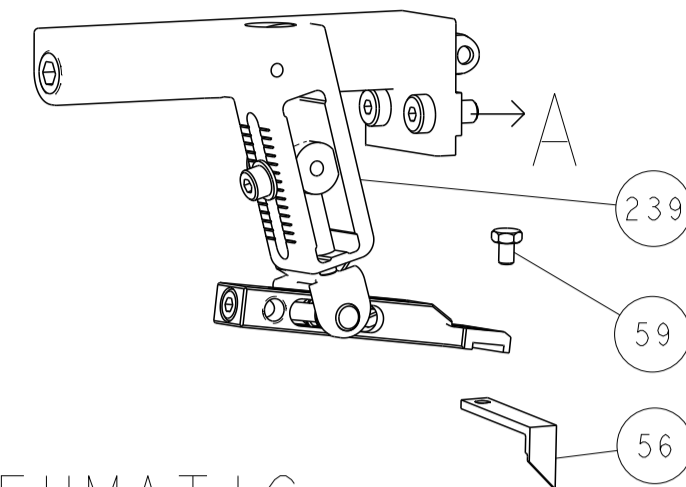
PACIFIC VERSION
 Shown on sheets 3 of 4 & 4 of 4
 (Atlantic version shown on sheets 1 of 4 & 2 of 4)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		MATERIAL:		FINISH:		WEIGHT:		SCALE:	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES	FINISH			1:2	SHEET 3 OF 4

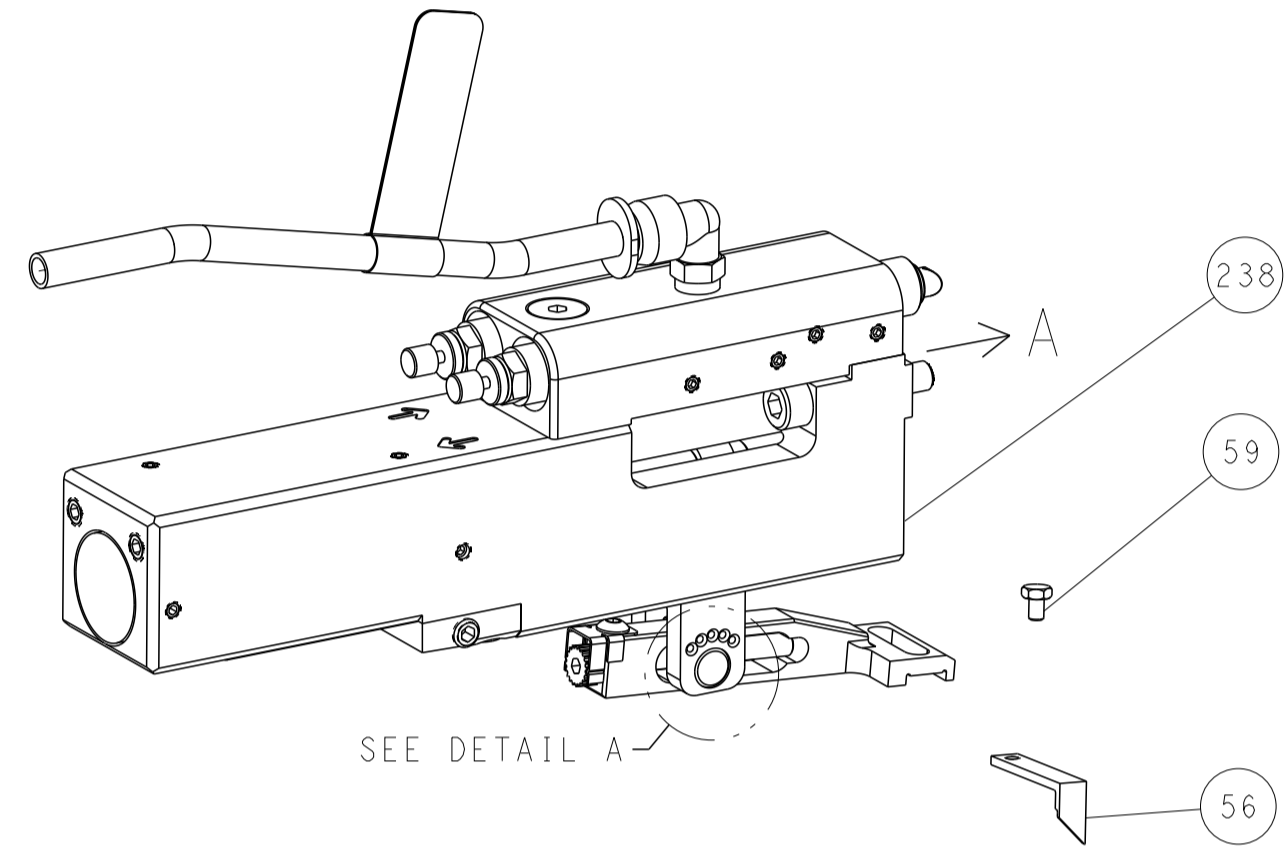
CHK	H. HUANG	31 JUL 2015
CHK	L. ZHANG	31 JUL 2015
APVD	J. GUO	31 JUL 2015
PRODUCT SPEC		
APPLICATION SPEC		
SIZE	A1	00779
CAGE CODE		
DRAWING NO		2151414
RESTRICTED TO		
Customer Accessible Production Drawing		

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

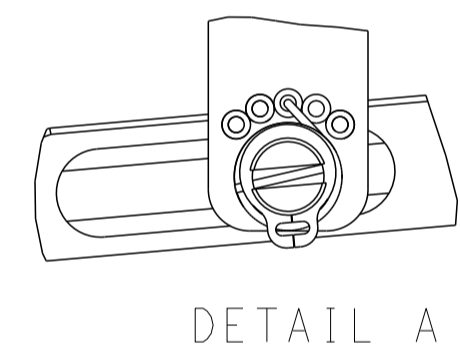
FEED TYPE MECHANICAL



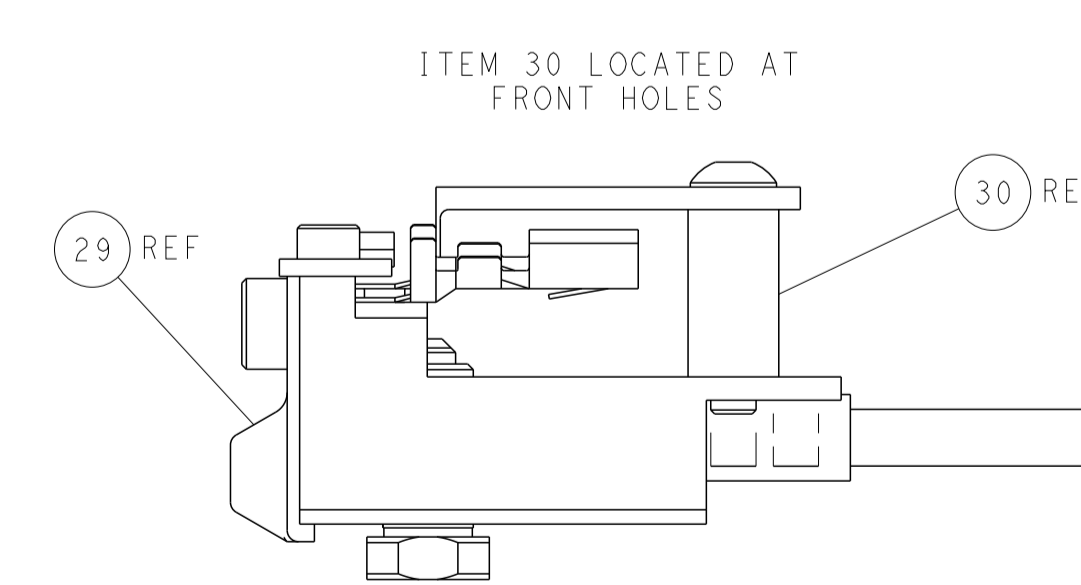
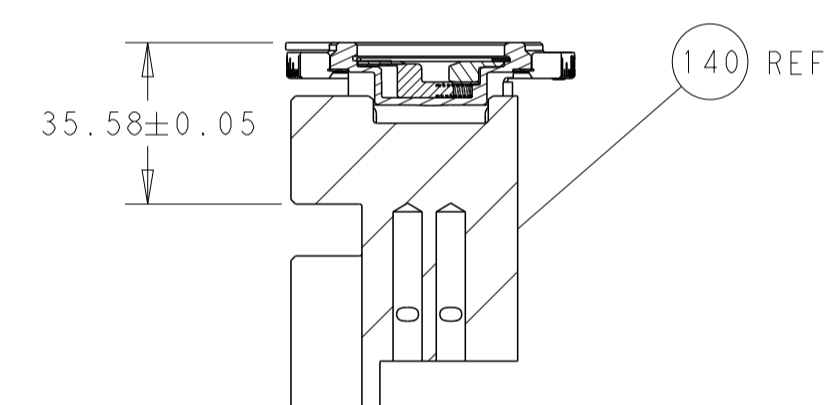
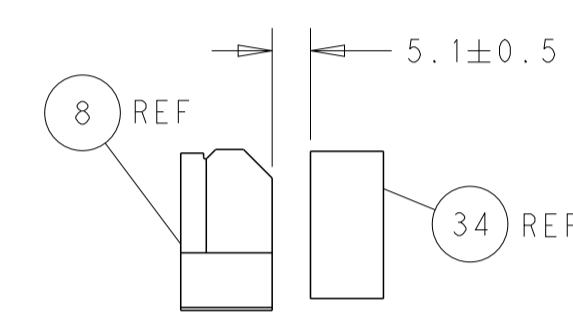
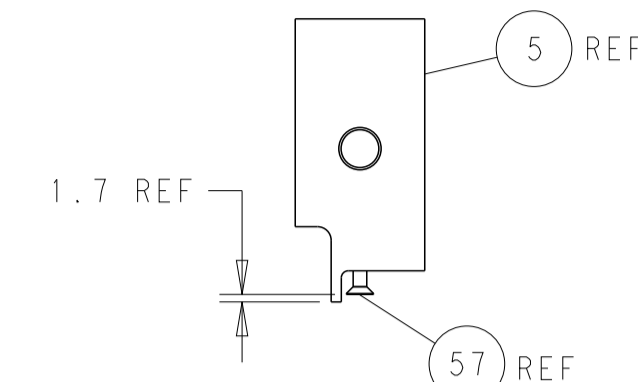
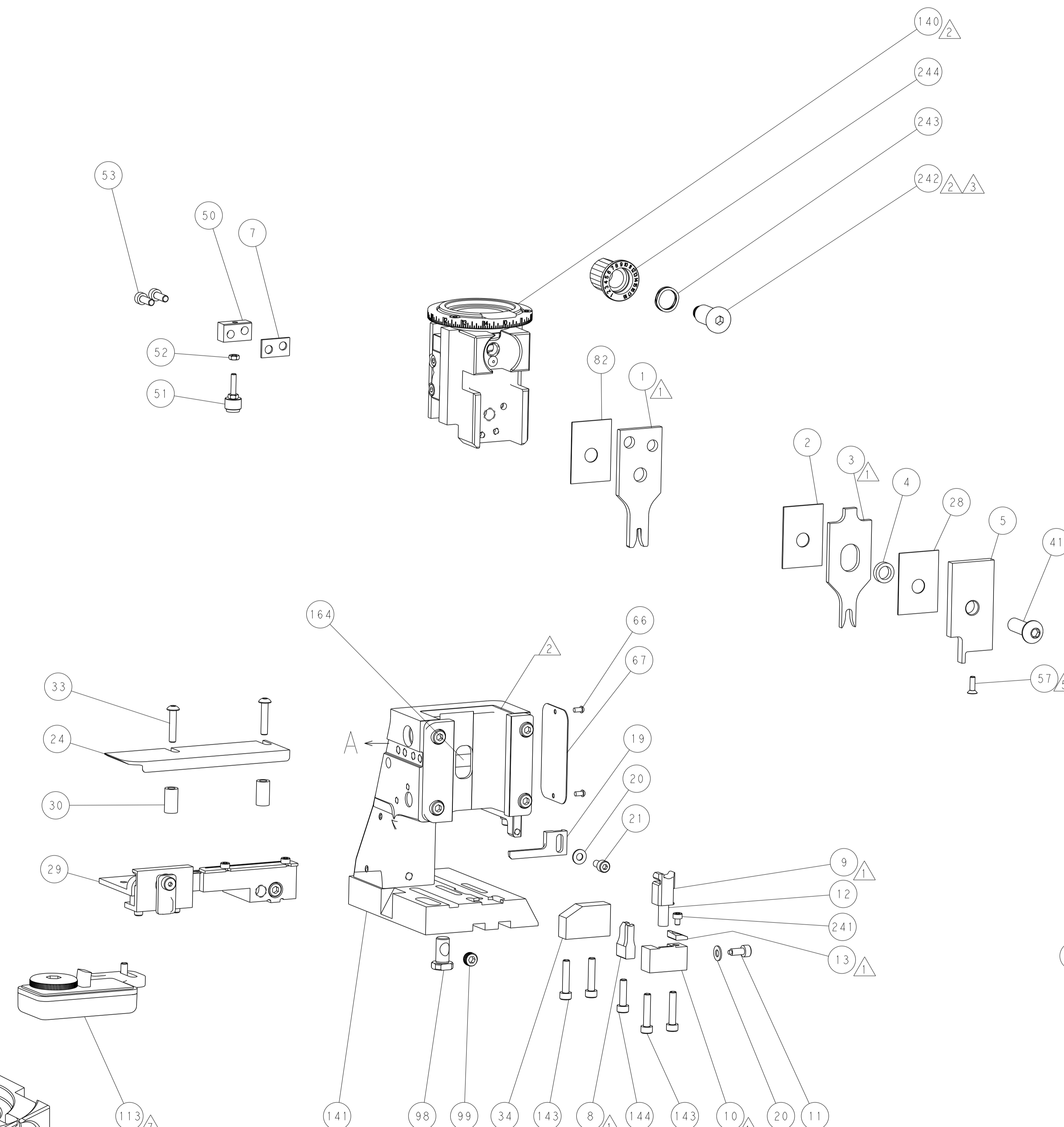
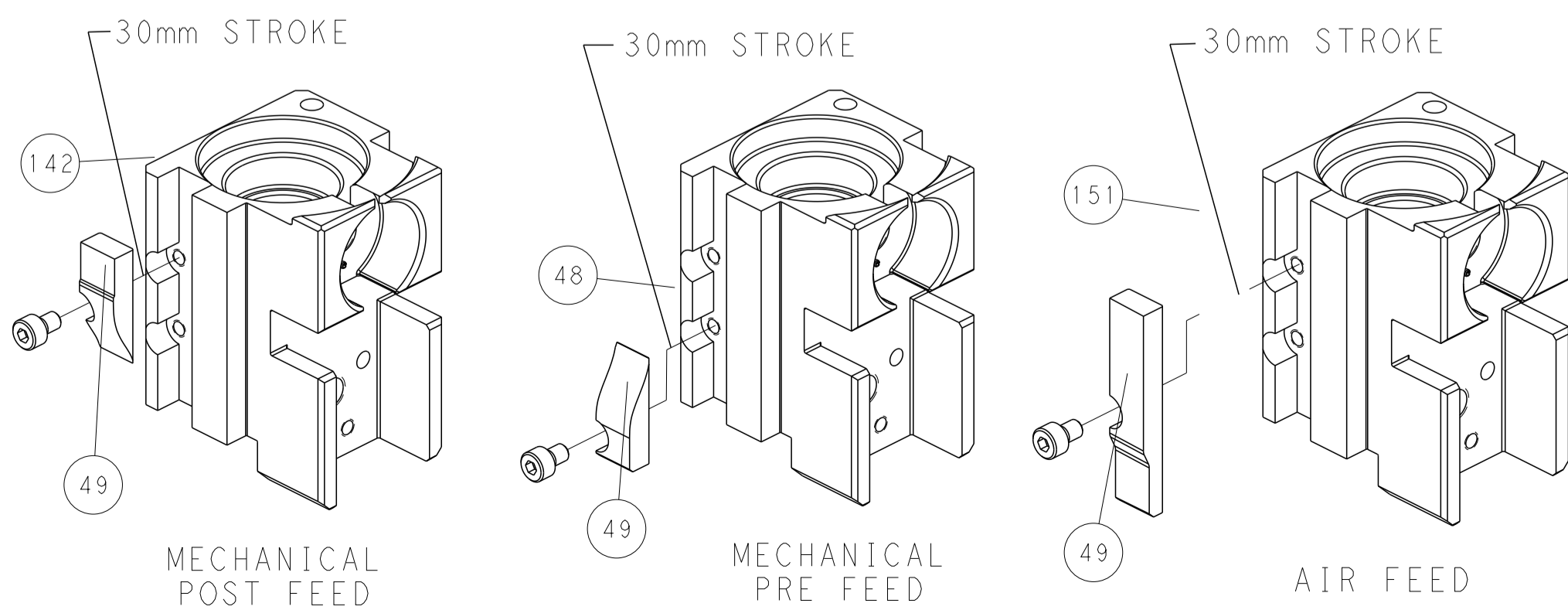
PNEUMATIC



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)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG: H. HUANG 31 JUL 2015		CHK: L. ZHANG 31 JUL 2015		APVD: J. GUO 31 JUL 2015		NAME: Ocean Side Feed Applicator	
mm	0 PLC	±		SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO				
	1 PLC	±		A1	00779	2151414					
	2 PLC	±		Customer Accessible Production Drawing		SCALE	1:2	SHEET	4	OF	4
	3 PLC	±						REV	F		
	4 PLC	±									
	ANGLES	±									
	FINISH	±									