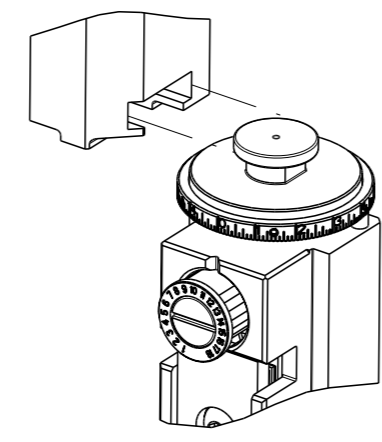


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151556-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2151556-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151556-1	C	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2151556-2	C	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2151556-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER

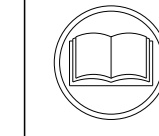


APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.03 mm [.080]	F
INSUL	4.06 mm [.160]	O

APPLICATOR INSTRUCTIONS
408-35042

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: MICRO POWER QUADLOK TAB CONTACT SWS			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
4.00-4.60 mm [.157-.181 IN]		∅ 3.40 mm MAX [.134 IN MAX]	
TERMINAL APPLICATION SPECIFICATION	114-18141-1		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE SEAL	TE SEAL
968119-2	968138-5	967610-1	
968119-4	1-968138-5		
968138-2	2-968138-5		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.00mm2	1.36 +/- 0.05 [.054 +/- .002]	3.9
0.75mm2	1.27 +/- 0.04 [.050 +/- .002]	4.9



- 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.
- THIS APPLICATOR APPLIES TERMINAL WITH A SEAL. FOR TERMINAL 968119 THE SEAL INSULATION RANGE IS ∅1.70-1.90 [∅.067-.075 IN] FOR TERMINAL 968138 THE SEAL INSULATION RANGE IS ∅1.90-2.10 [∅.075-.083 IN]
- 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.
- 8. 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.

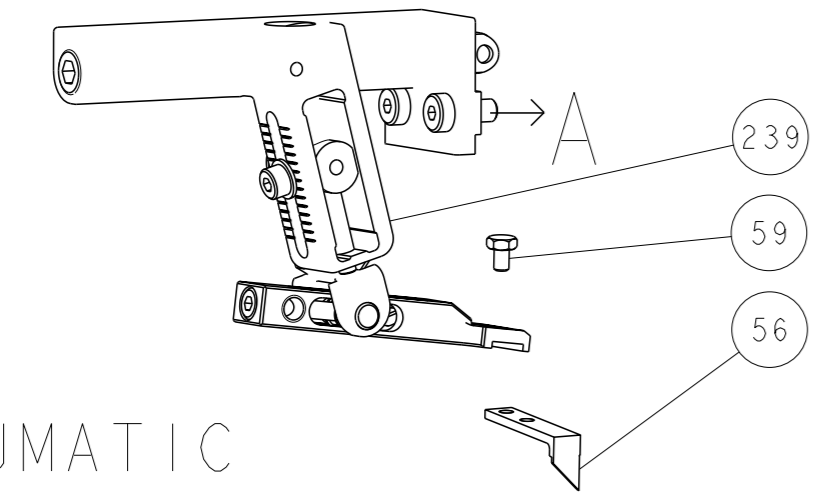
REVISIONS					
#	LY#	DESCRIPTION	DATE	OWN	APVD
1		DEVELOPMENT	17OCT2012	YY	SX
A		RELEASED	14DEC2012	YY	SX
B		ECR-17-003068	07MAR2017	TB	TE
C		ECR-22-140800	30MAY2022	FJ	TE

-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248
-	1	1	1	1	2119082-7	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	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	1-18028-2	WASHER, FLAT, REG M4	119
-	1	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	2119791-9	DEPRESSOR, WIRE	70
-	1	1	1	1	2119943-1	WASHER, SPACER	69
-	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	985575-3	SCR, FLT SKT HD CAP M3 X 10.0	57
-	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	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	53
-	1	1	1	1	5018030-1	NUT, HEX, REG, RoHS, M3	52
-	1	1	1	1	811242-5	BUMPER, HOLD DOWN	51
-	1	1	1	1	690753-2	SPACER, TONKER	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	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	1752356-6	SUPPORT, TERMINAL	34
-	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	2	2	3-2844962-0	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	1	1	2844992-2	ASSEMBLY, STRIP GUIDE	29
-	1	1	1	1	455888-4	SPACER, CRIMPER	28
-	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
-	1	1	1	1	1-18028-2	WASHER, FLAT, REG M4	20
-	1	1	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	318707-1	FLOATING SHEAR, FRONT	9
1	2	2	1	1	6-1333204-9	ANVIL, COMBINATION	8
-	1	1	1	1	240641-3	SPACER	7
-	-	-	-	-	-	-	6
-	1	1	1	1	2119781-1	DEPRESSOR, SHEAR	5
-	1	1	1	1	4-238011-5	BLOCK, CRIMPER SPACER	4
1	2	2	1	1	1-1633996-9	CRIMPER, INSULATION SPECIAL	3
-	1	1	1	1	455888-6	SPACER, CRIMPER	2
1	2	2	1	1	1-456405-6	CRIMPER, WIRE PREMIUM	1
-	77	-72	-71	-2	-1	PART NO	ITEM NO

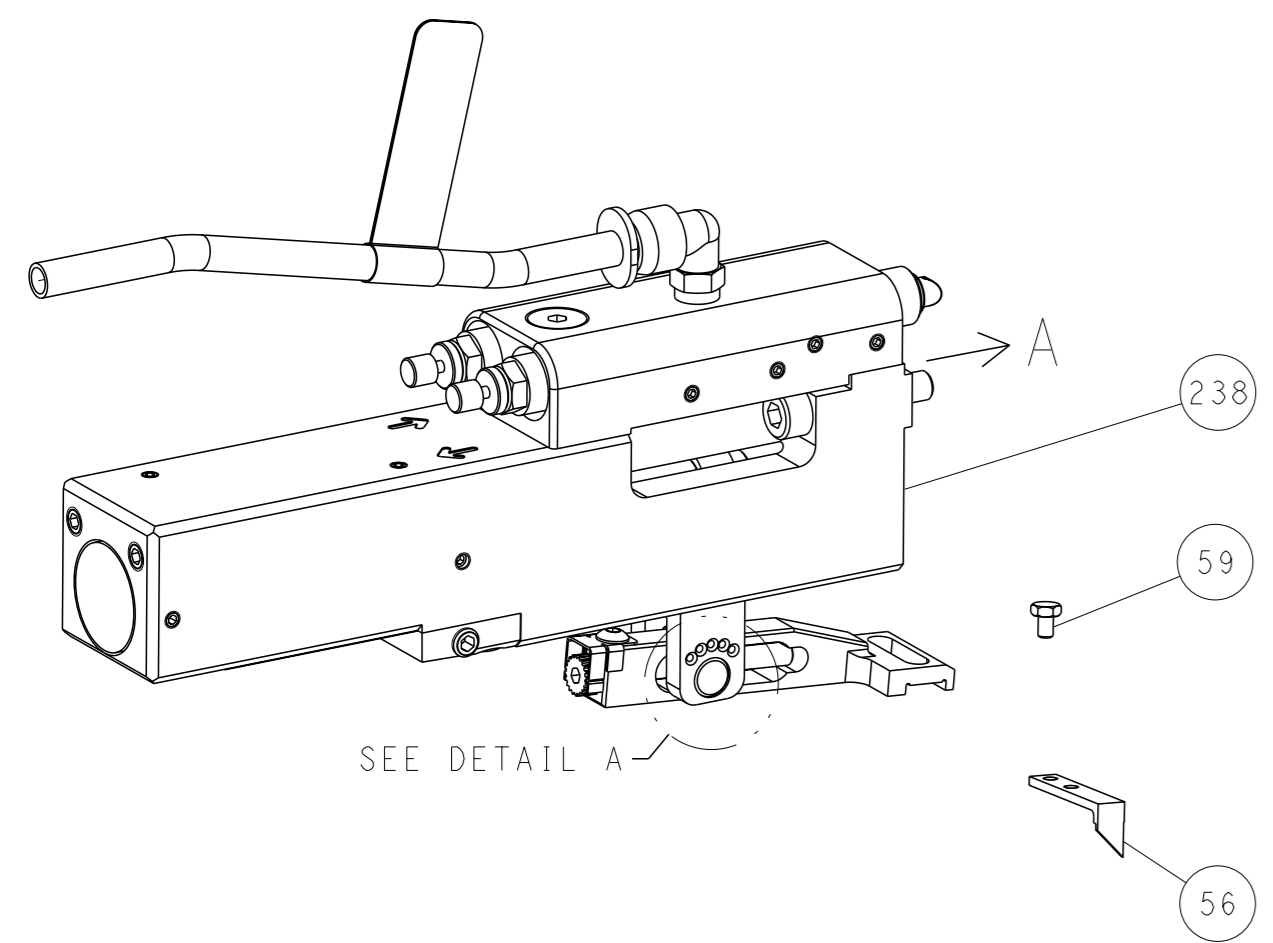
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

THIS DRAWING IS A CONTROLLED DOCUMENT.		OWN Y. YIN	17OCT2012	TE Connectivity NAME Ocean Side Feed Product Spec Applicator
DIMENSIONS:		CHK G. BAILEY	17OCT2012	
TOLERANCES UNLESS OTHERWISE SPECIFIED:		APVD S. XI	17OCT2012	SIZE A1
mm		PRODUCT SPEC		CAGE CODE C=2151556
0 PLC ±		APPLICATION SPEC		RESTRICTED TO
1 PLC ±				
2 PLC ±				
3 PLC ±				
4 PLC ±				
ANGLES FINISH		WEIGHT		
MATERIAL				
		CUSTOMER ACCESSIBLE PRODUCTION DRAWING	SCALE 1:2	SHEET 1 OF 4

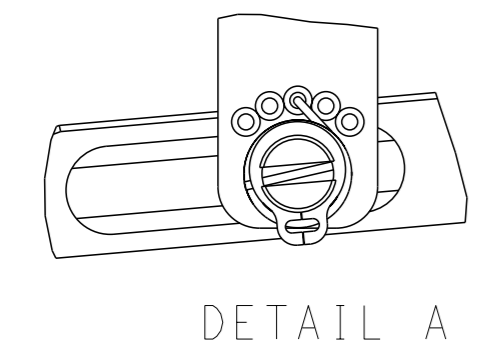
FEED TYPE MECHANICAL



PNEUMATIC

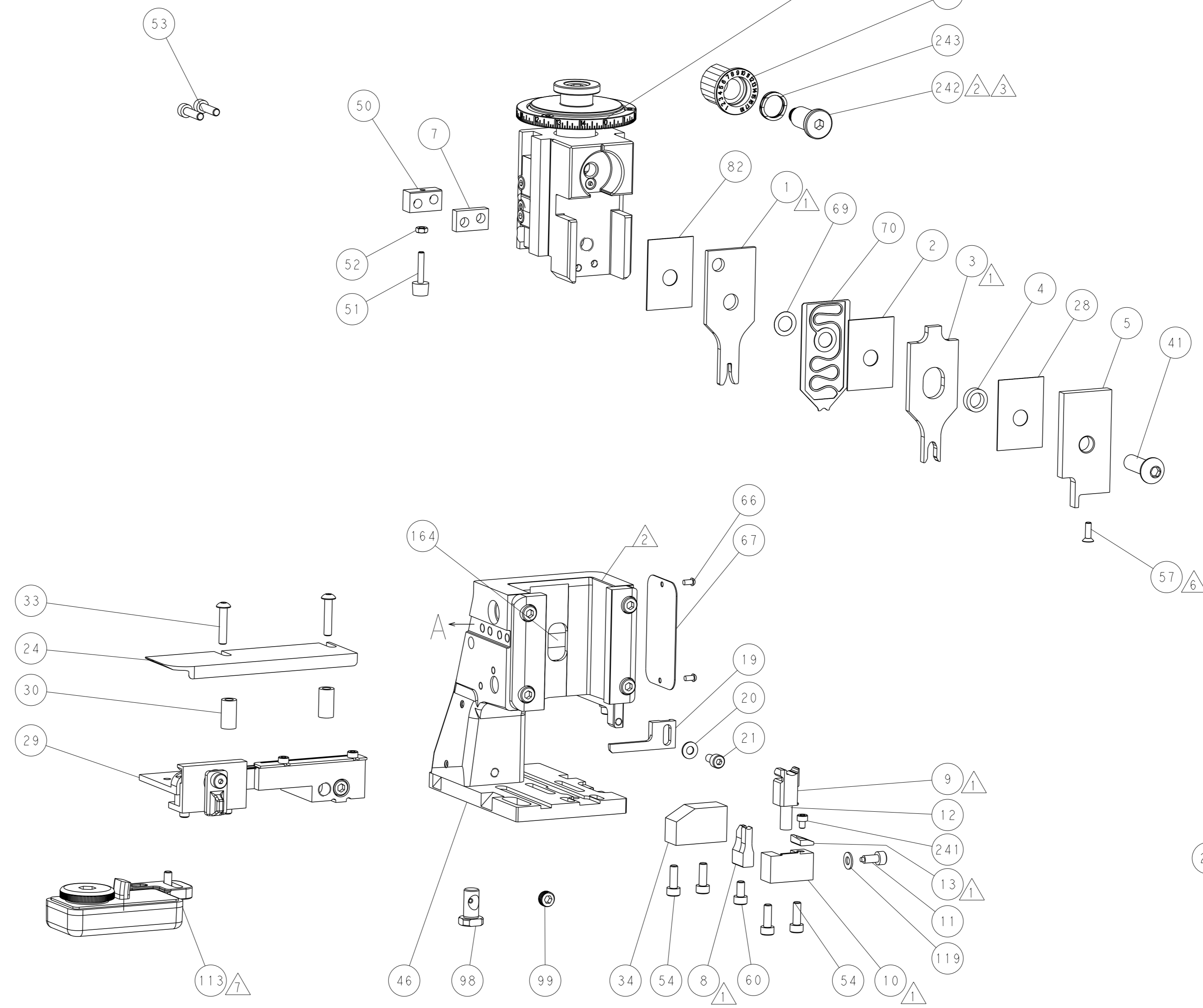
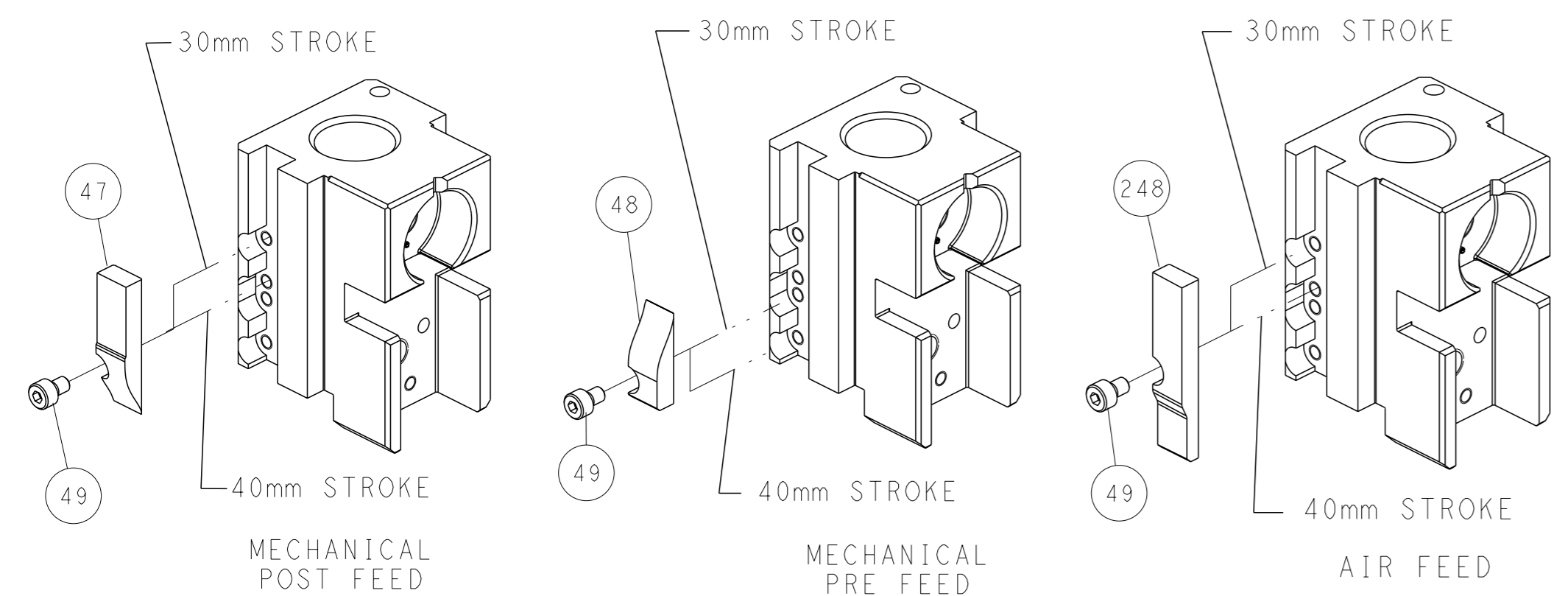


FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)

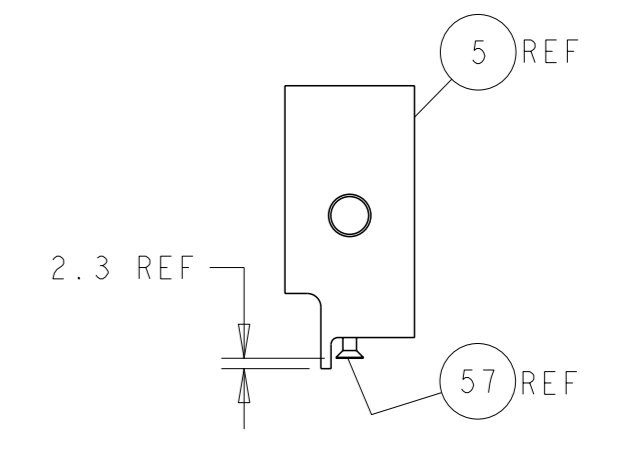


DETAIL A

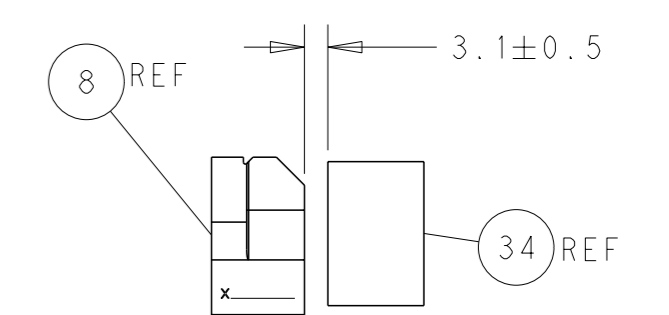
CAM POSITIONS



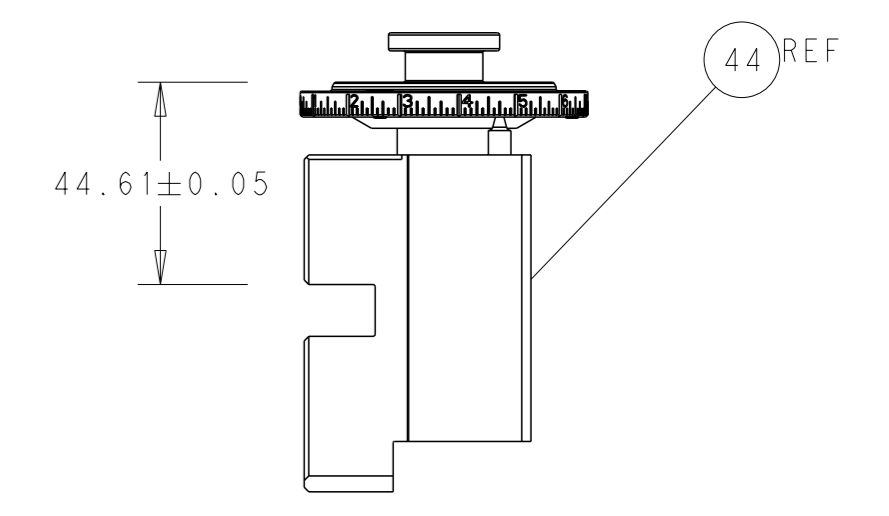
REVISIONS				
P	LYR	DESCRIPTION	DATE	APVD
-	-	SEE SHEET 1	-	-



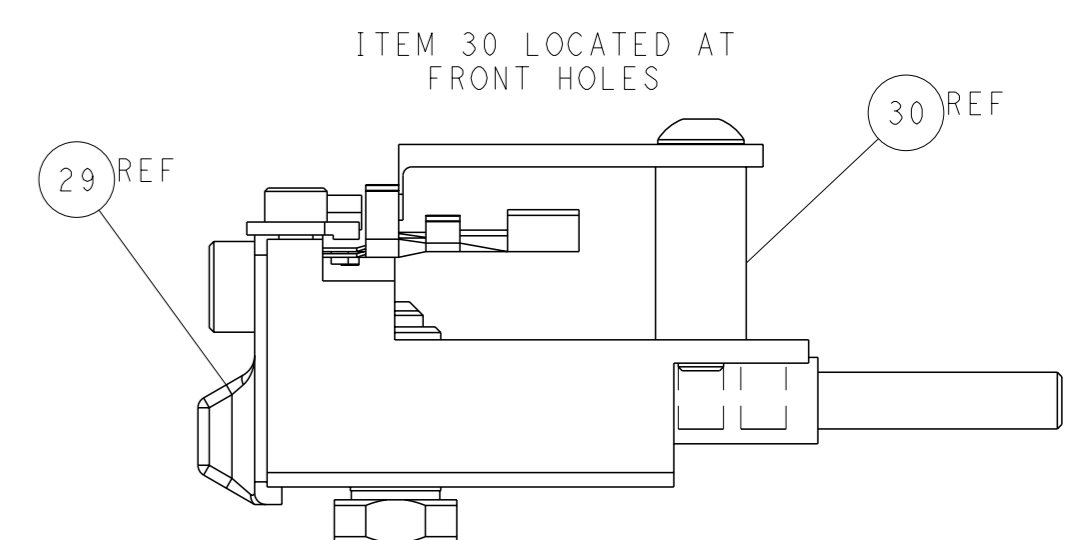
SHEAR DEPRESSOR DETAIL



TERMINAL SUPPORT LOCATION



FEED TRACK POSITION GUIDE BY INSULATION BARREL



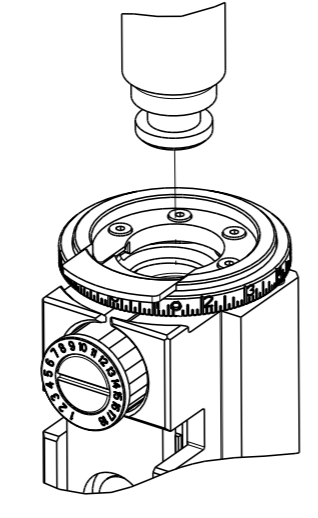
ITEM 30 LOCATED AT FRONT HOLES

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.		OWN Y.YIN 17OCT2012	TE Connectivity
DIMENSIONS: mm		CHK G.BIALEY 17OCT2012	
TOLERANCES UNLESS OTHERWISE SPECIFIED:		APVD S.XI 17OCT2012	
0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH *		NAME Ocean Side Feed Applicator	
MATERIAL		PRODUCT SPEC	SIZE A1
		APPLICATION SPEC	CAGE CODE DRAWING NO. C=2151556
		WEIGHT	RESTRICTED TO
		CUSTOMER ACCESSIBLE PRODUCTION DRAWING	SCALE 1:2 SHEET 2 OF 4 REV C

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2151556-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2151556-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151556-7	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: MICRO POWER QUADLOK TAB CONTACT SWS			
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE		
4.00-4.60 mm [.157-.181 IN]	Ø 3.40 mm MAX [.134 IN MAX]		
TERMINAL APPLICATION SPECIFICATION	114-18141-1		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE SEAL	TE SEAL
968119-2	968138-5	967610-1	
968119-4	1-968138-5		
968138-2	2-968138-5		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.00mm2	1.36+/-0.05 [.054+/-0.002]	3.9
0.75mm2	1.27+/-0.04 [.050+/-0.002]	4.9

- 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. THIS APPLICATOR APPLIES TERMINAL WITH A SEAL. FOR TERMINAL 968119 THE SEAL INSULATION RANGE IS Ø1.70-1.90 [Ø.067-.075 IN] FOR TERMINAL 968138 THE SEAL INSULATION RANGE IS Ø1.90-2.10 [Ø.075-.083 IN]
- 6. 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.
- 7. TERMINAL LUBRICANT IS RECOMMENDED.
- 8. 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.

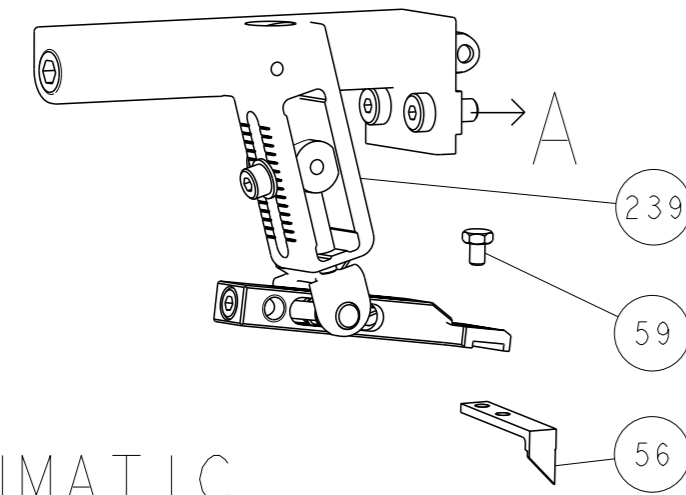
PACIFIC VERSION
Shown on sheets 3 of 4 & 4 of 4
(Atlantic version shown on sheets 1 of 4 & 2 of 4)

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

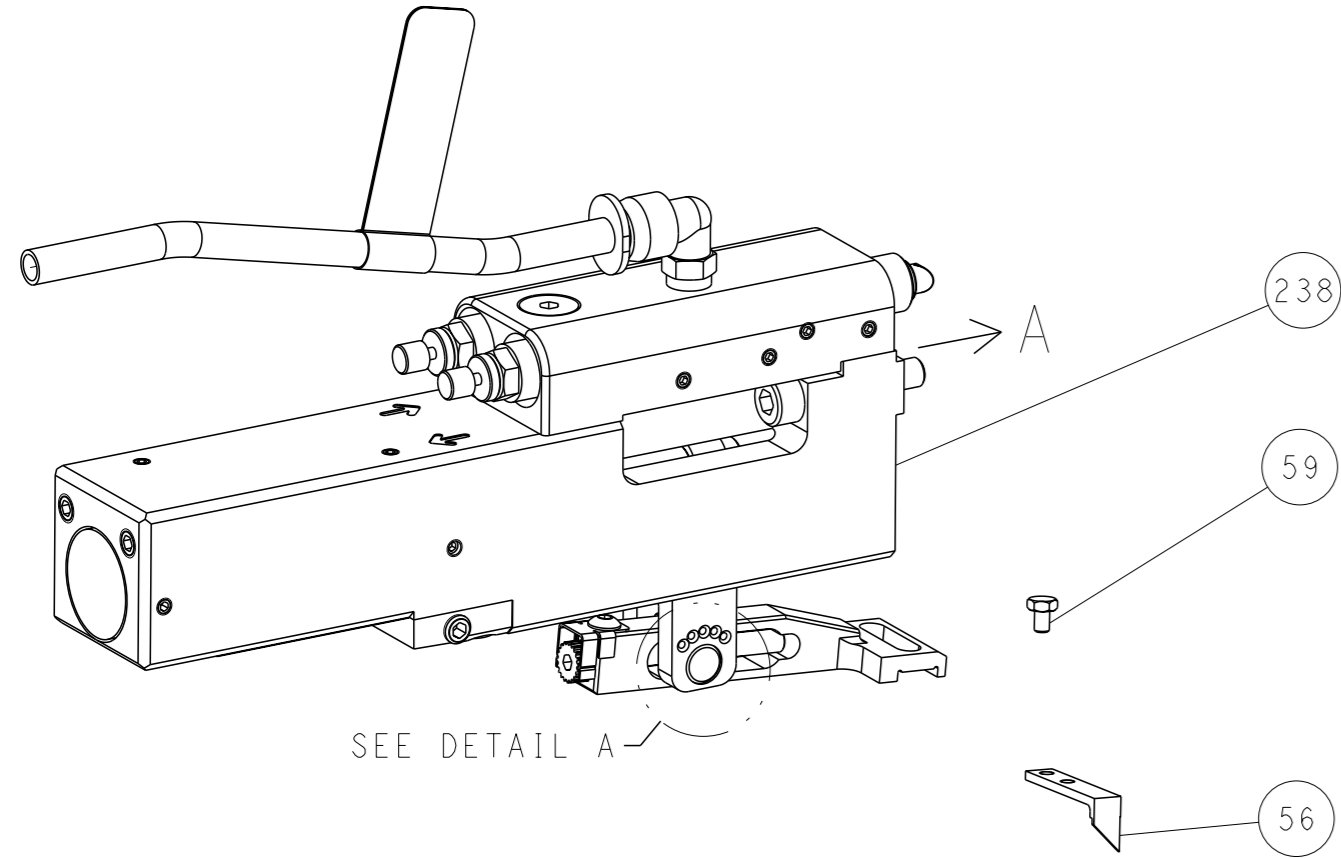
-	1	1	2119082-7	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
-	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	1	-	2844940-1	AIR FEED MODULE	238
-	REF	REF	994970-2	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	1-18028-2	WASHER, FLAT, REG M4	119
-	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	2119791-9	DEPRESSOR, WIRE	70
-	1	1	2119943-1	WASHER, SPACER	69
-	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	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	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	1752356-6	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	455888-4	SPACER, CRIMPER	28
-	1	1	1320928-2	STRIP GUIDE	24
-	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
-	1	1	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	1	6-1333204-9	ANVIL, COMBINATION	8
-	1	1	240641-3	SPACER	7
-	-	-	-	-	6
-	1	1	2119781-1	DEPRESSOR, SHEAR	5
-	1	1	4-238011-5	BLOCK, CRIMPER SPACER	4
1	1	1	1-1633996-9	CRIMPER, INSULATION SPECIAL	3
-	1	1	455888-6	SPACER, CRIMPER	2
1	1	1	1-456405-6	CRIMPER, WIRE PREMIUM	1
-77	-22	-21	PART NO	DESCRIPTION	ITEM NO

THIS DRAWING IS A CONTROLLED DOCUMENT.		OWN Y. YIN 17OCT2012	STE TE Connectivity	
DIMENSIONS: mm		CHK G. BAILEY 17OCT2012		
TOLERANCES UNLESS OTHERWISE SPECIFIED:		APVD S. XI 17OCT2012	NAME Ocean Side Feed Applicator	
0 PLC ±		PRODUCT SPEC	SIZE CAGE CODE DRAWING NO	
1 PLC ±		APPLICATION SPEC	A1 ©=2151556	
2 PLC ±		RESTRICTED TO	CUSTOMER ACCESSIBLE PRODUCTION DRAWING	
3 PLC ±		SCALE 1:2	SHEET 3 of 4	
4 PLC ±		REV C		
ANGLES FINISH				

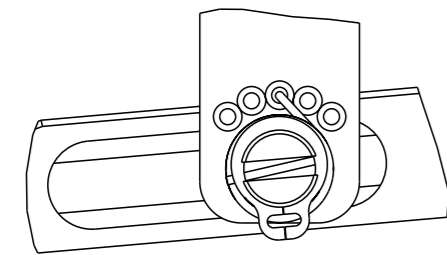
FEED TYPE MECHANICAL



PNEUMATIC

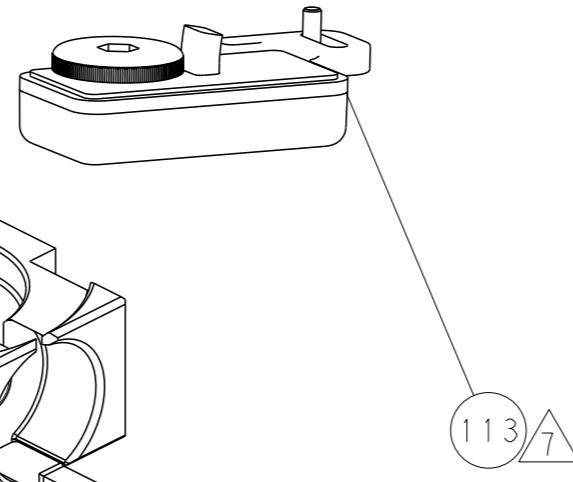
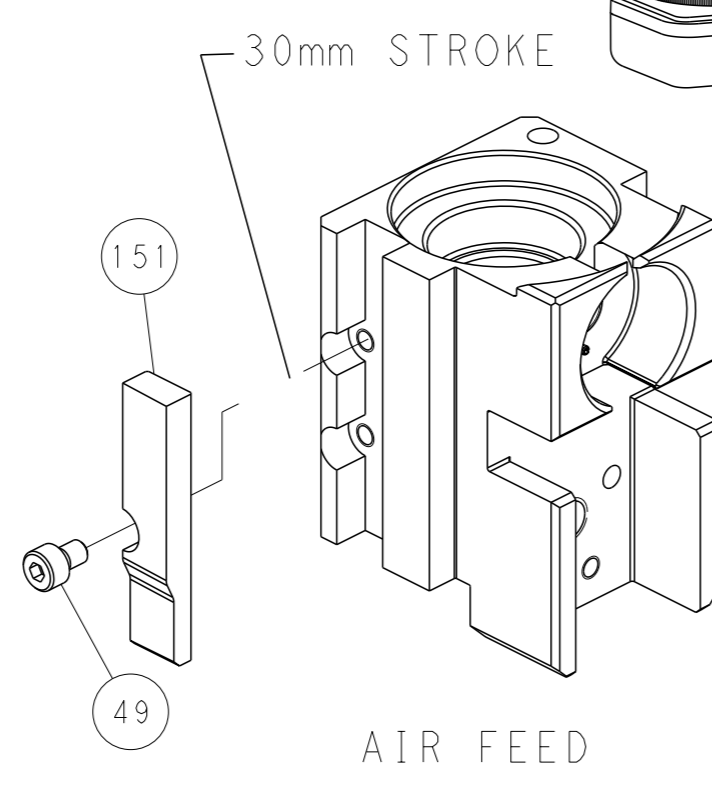
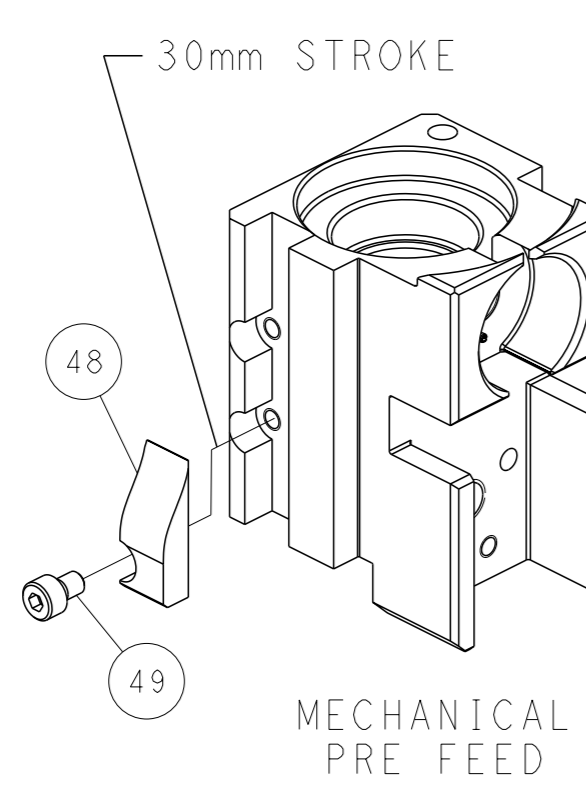
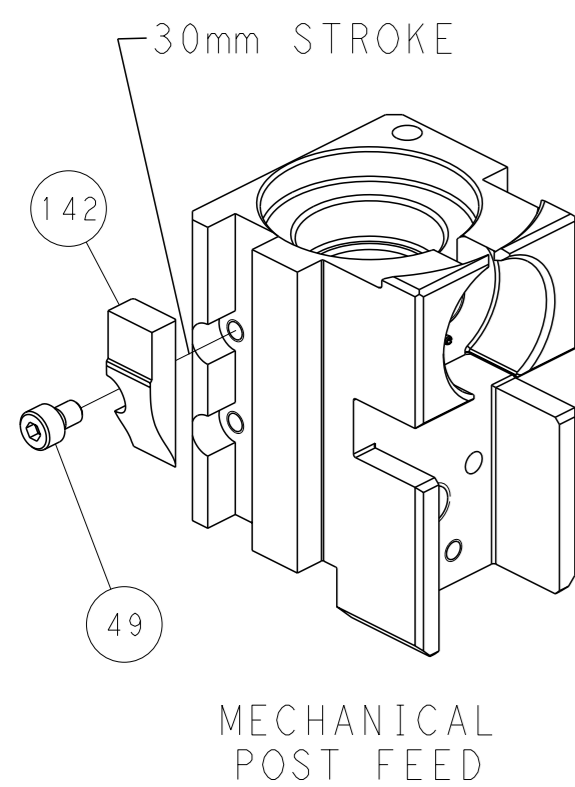


FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



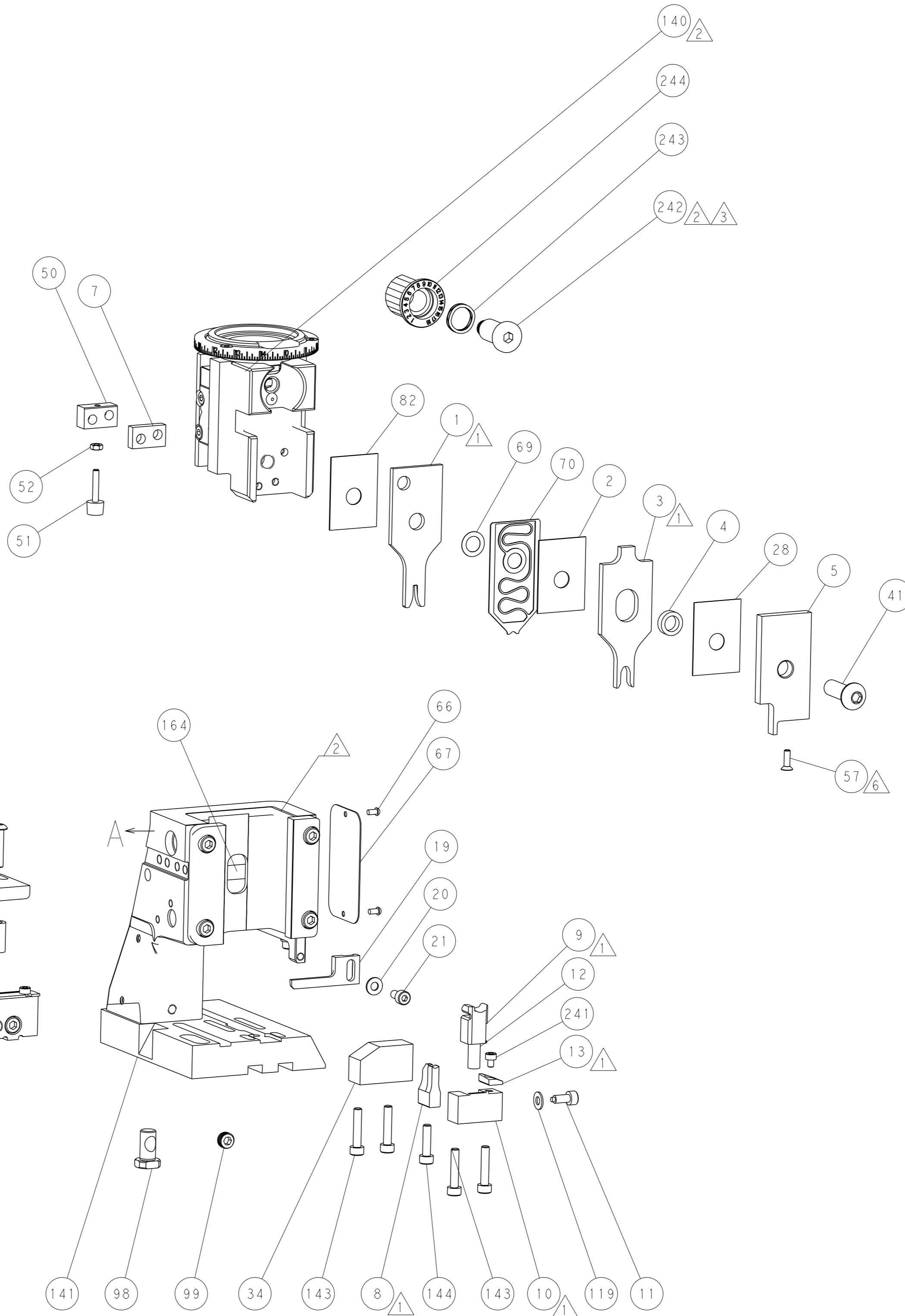
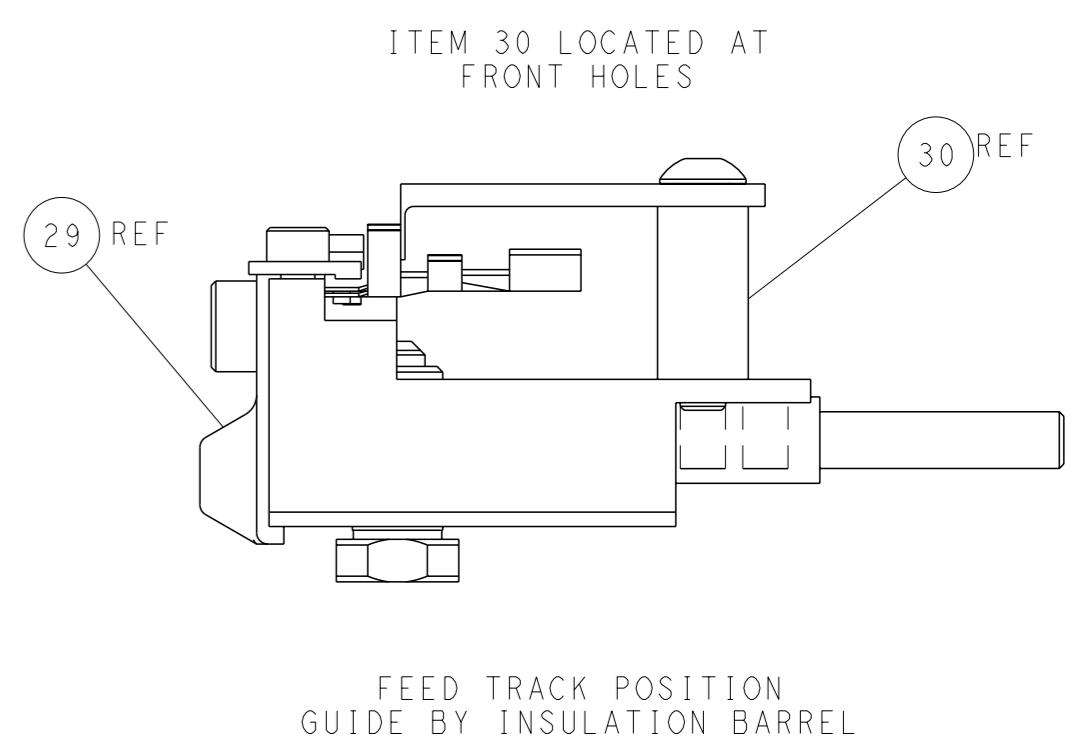
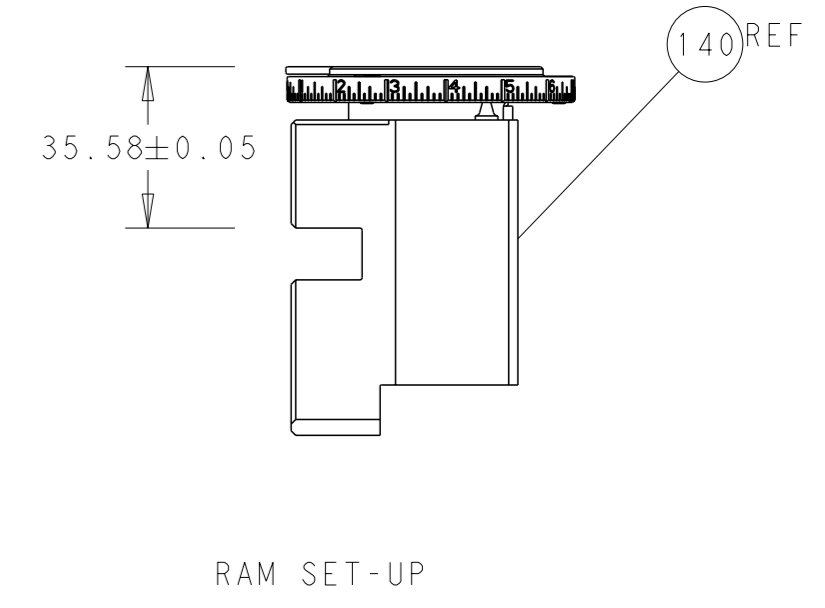
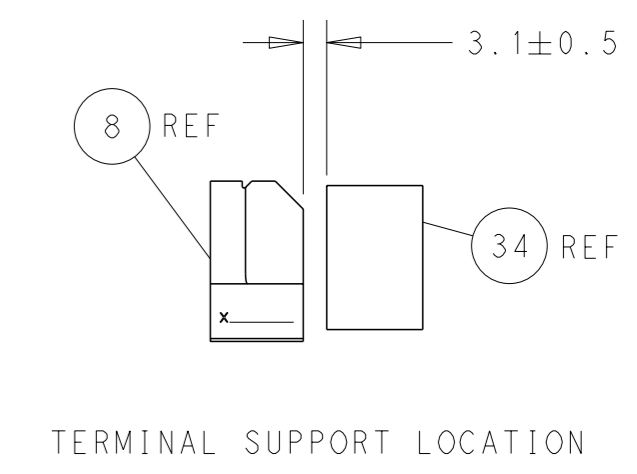
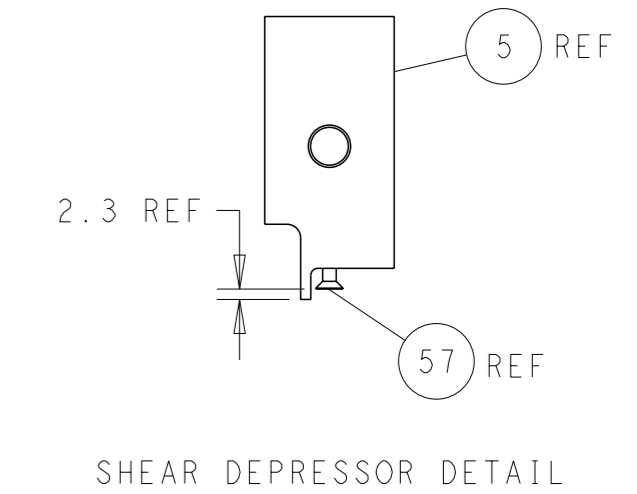
DETAIL A

CAM POSITIONS



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

REVISIONS				
P.	LY#	DESCRIPTION	DATE	APVD
-	-	SEE SHEET 1	-	-



THIS DRAWING IS A CONTROLLED DOCUMENT.		OWN: Y. YIN 17OCT2012	TE Connectivity
DIMENSIONS: mm		CHK: G. BAILEY 17OCT2012	
TOLERANCES UNLESS OTHERWISE SPECIFIED:		APVD: S. XI 17OCT2012	NAME: Ocean Side Feed Applicator
0 PLC	±	PRODUCT SPEC	SIZE: A1
1 PLC	±	APPLICATION SPEC	CAGE CODE: -
2 PLC	±	SCALE: 1:2	DRAWING NO: C=2151556
3 PLC	±	SHEET: 4 of 4	REV: C
4 PLC	±	CUSTOMER ACCESSIBLE PRODUCTION DRAWING	RESTRICTED TO: -
ANGLES	±	WEIGHT: -	SCALE: 1:2
FINISH	-	SCALE: 1:2	SHEET: 4 of 4