

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

ATLANTIC 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 +/- .001]	5.6
0.35mm2	1.08 +/- 0.03 [.043 +/- .001]	6.3

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

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

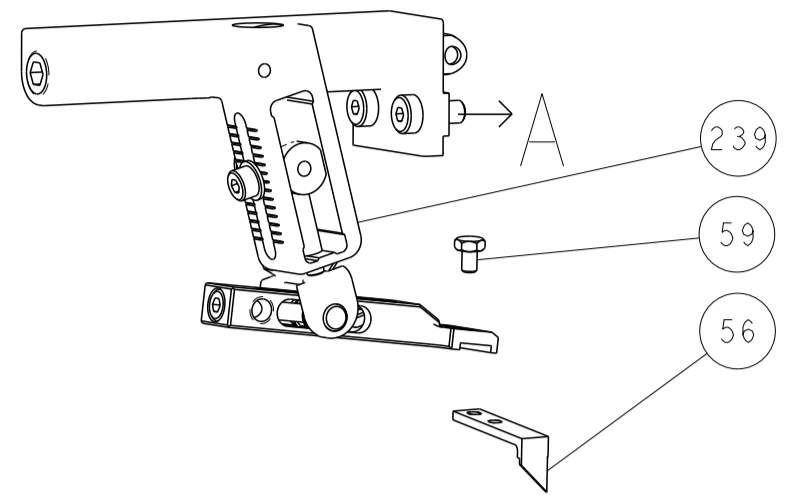
REVISIONS				
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H2		ECR-22-157596	07NOV2022	FZ JAH
H3		ECR-23-175719	17MAY2023	ROY JAH

	-	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
	-	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	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

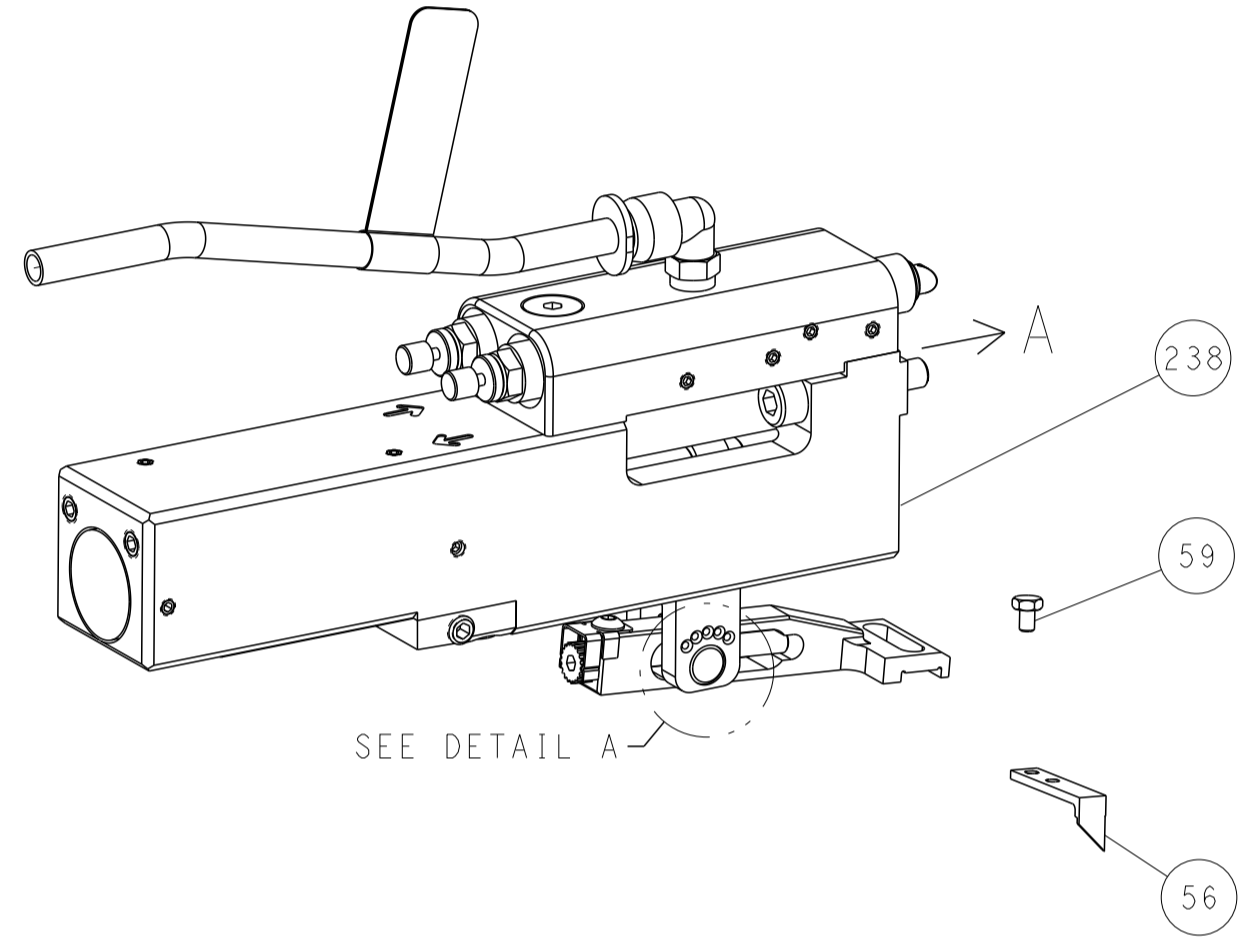
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		CHK	G. BAILEY	23SEP2011
		APVD	S. XI	23SEP2011
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		
mm	0 PLC	±		
	1 PLC	±		
	2 PLC	±		
	3 PLC	±		
	4 PLC	±		
	ANGLES	±		
	FINISH	±		
MATERIAL		WEIGHT		
CUSTOMER ACCESSIBLE PRODUCTION DRAWING		SCALE	1:2	SHEET 1 OF 4
		REV	H3	

REVISIONS				
P.	LTN.	DESCRIPTION	DATE	APVD.
-	-	SEE SHEET 1	-	-

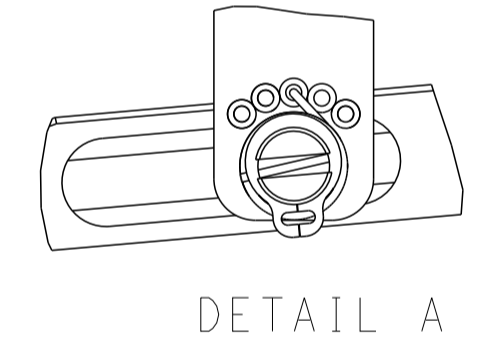
FEED TYPE MECHANICAL



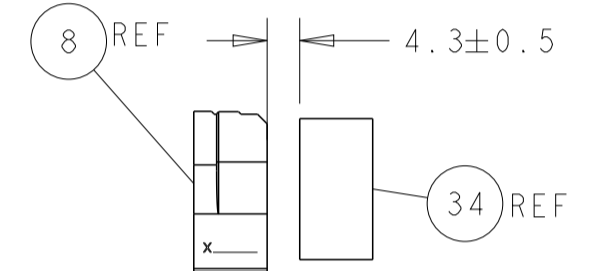
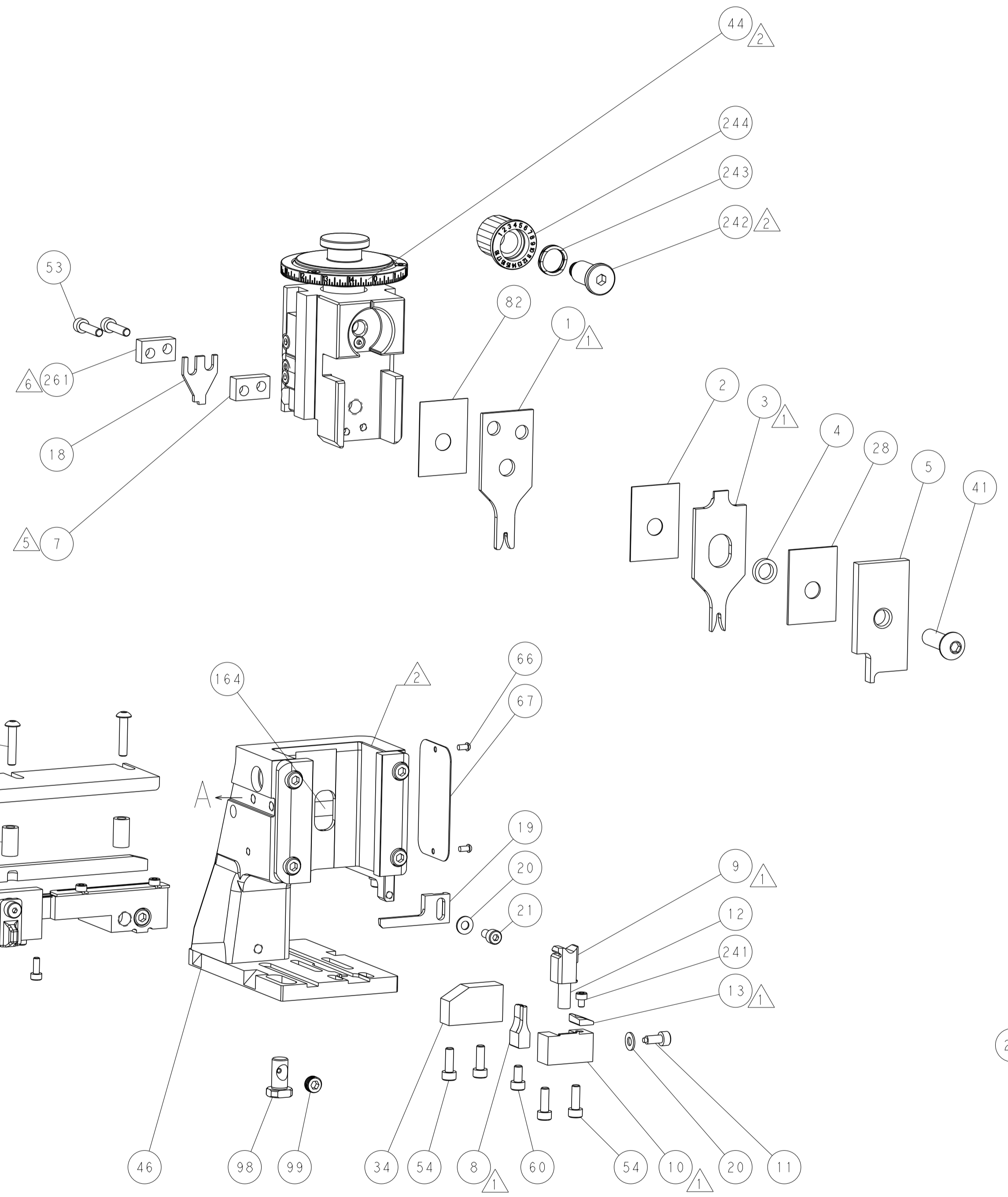
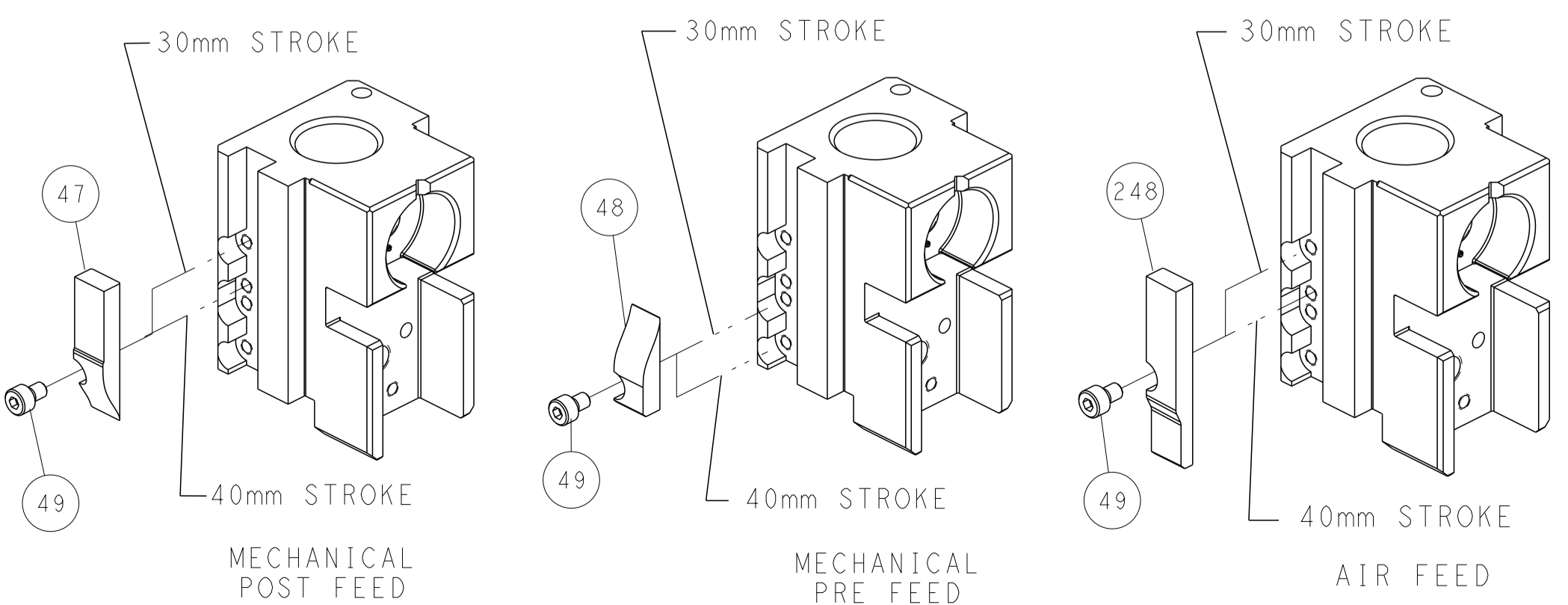
PNEUMATIC



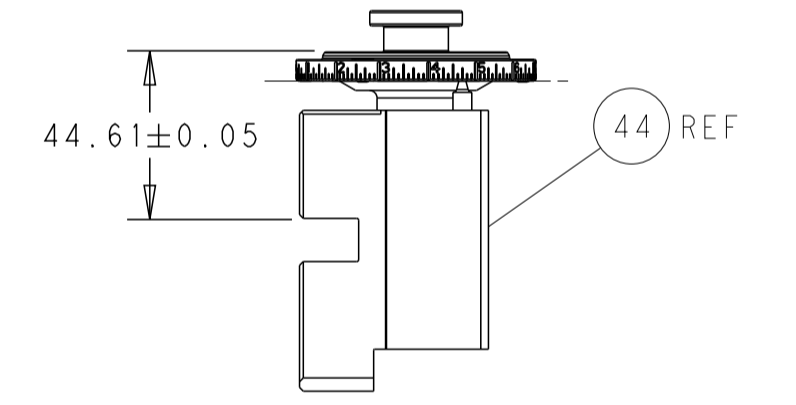
FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



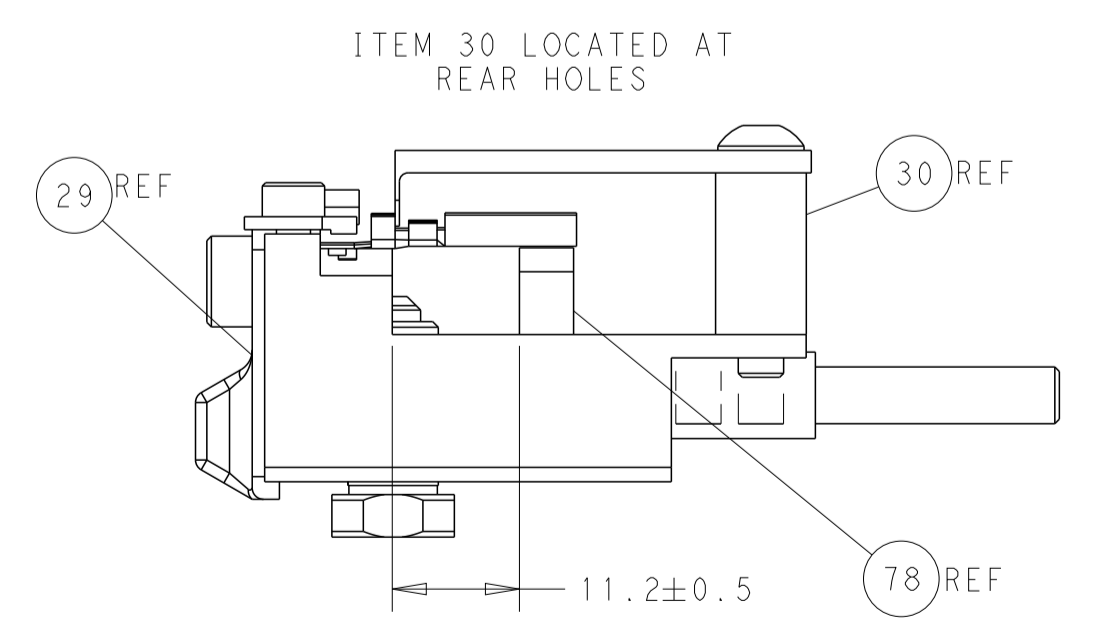
CAM POSITIONS



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.		OWN: Y. YIN 23SEP2011	TE Connectivity
DIMENSIONS: mm		CHK: G. BAILEY 23SEP2011	
TOLERANCES UNLESS OTHERWISE SPECIFIED:		APVD: S. XI 23SEP2011	
0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		NAME: Ocean Side Feed Applicator	
MATERIAL:		PRODUCT SPEC:	SIZE: A1
		APPLICATION SPEC:	CAGE CODE: -
		WEIGHT:	DRAWING NO: C=2151045
		CUSTOMER ACCESSIBLE PRODUCTION DRAWING	RESTRICTED TO: REV: H3
		SCALE: 1:2	SHEET: 2 OF 4

8	7	6	5	4	3	2	1
THIS DRAWING IS UNPUBLISHED.		RELEASED FOR PUBLICATION		2016			
COPYRIGHT 20 BY -		ALL RIGHTS RESERVED.					
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



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

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 3.20-3.80 mm [1.26-.150 IN]		INSULATION DIAMETER RANGE 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 [1.045+/-0.001]	5.6
0.35mm2	1.08+/-0.03 [1.043+/-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.

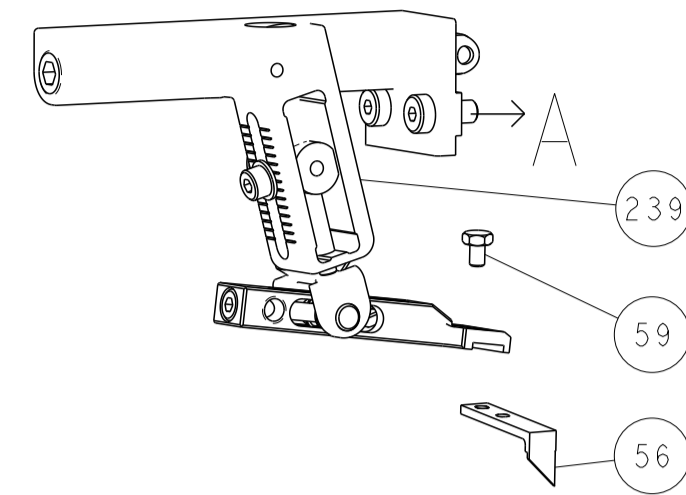
ENTRY LEVEL APPLICATOR		ITEM SUBSTITUTION LIST		
PART NUMBER	SAME AS	ITEM	ITEM DESCRIPTION	SUBSTITUTE PART NUMBER
8-2151045-1	2151045-1	1	WIRE CRIMPER	9-1803666-1
8-2151045-2	2151045-2	3	INSULATION CRIMPER	1-1803604-8
9-2151045-1	2-2151045-1	46	BASIC SUB -ASSEMBLY	1803940-9
9-2151045-2	2-2151045-2	141	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)

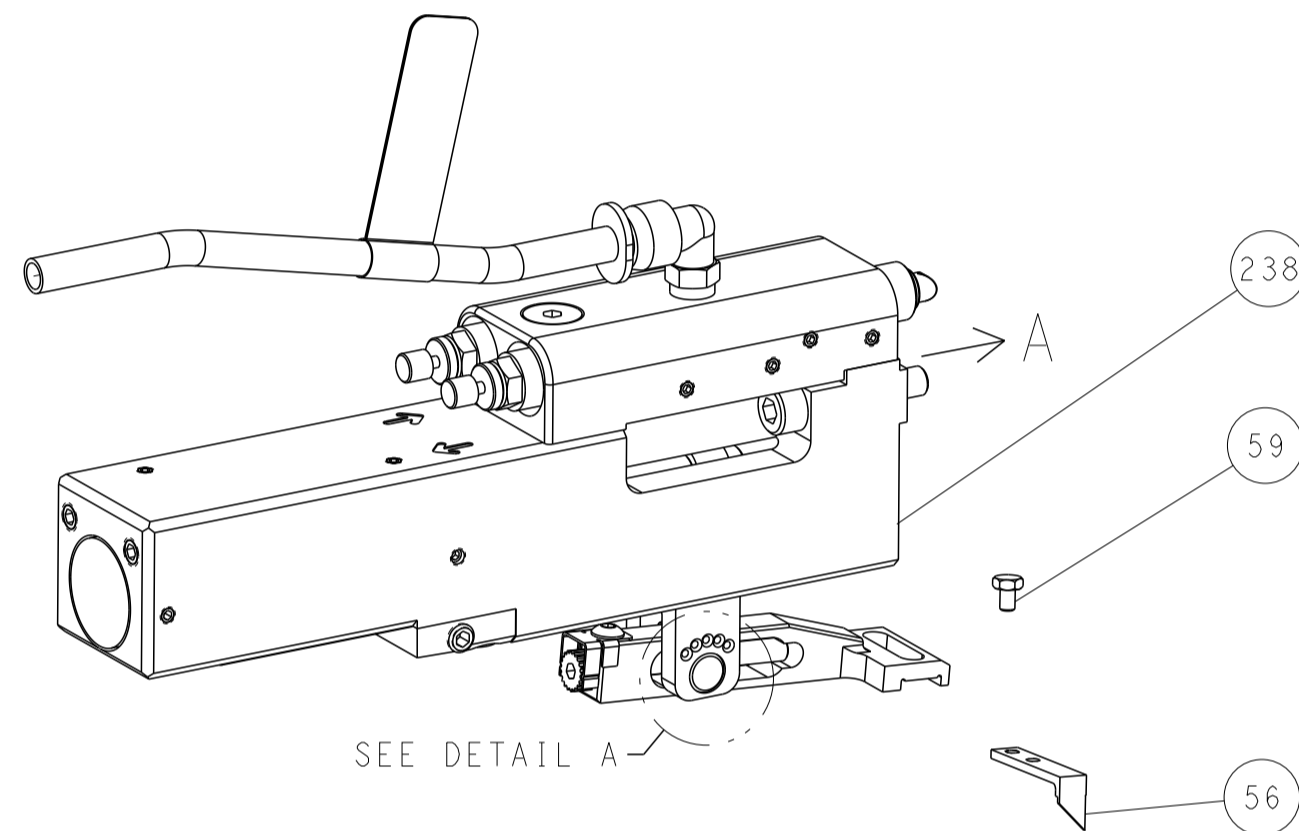
6	-	1	1	6-240641-5	SPACER	261
	-	1	1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244
	-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
3	-	1	1	2119083-1	RETAINER, INSULATION DIAL	242
	-	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
	-	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
	-	1	-	2844940-1	AIR 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
	-	1	1	2844908-1	SCREW, LOCKING	99
	-	1	1	2844907-1	POST, LOCKING	98
	-	1	1	455888-3	SPACER, CRIMPER	82
	-	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	79
	-	1	1	1633782-2	FENCE	78
	-	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	1338685-1	PAWL, FEED	56
	-	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	2119652-1	FEED CAM, PRE FEED	48
	-	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
	-	1	1	1-1752356-3	SUPPORT, TERMINAL	34
	-	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
	-	2	2	2-2844962-6	SPACER, CYLINDRICAL, STRIP GUIDE	30
	-	1	1	2844992-2	ASSEMBLY, STRIP GUIDE	29
	-	1	1	1-455888-0	SPACER, CRIMPER	28
	-	1	1	1320928-6	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	879657-2	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	1	2119805-1	SHEAR HOLDER, FRONT	10
1	-	1	1	1803095-1	FLOATING SHEAR, FRONT	9
1	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	238011-9	BLOCK, CRIMPER SPACER	4
1	1	1	1	1-2119784-8	CRIMPER, INSULATION O PREMIUM	3
	-	1	1	455888-5	SPACER, CRIMPER	2
1	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 Y. YIN	23SEP2011	TE Connectivity
		CHK G. BAILEY	23SEP2011	
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		NAME Ocean Side Feed Applicator
mm		0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		
MATERIAL		FINISH		SIZE A1
				CAGE CODE C=2151045
				RESTRICTED TO
				SCALE 1:2
				SHEET 3 OF 4
				REV H3

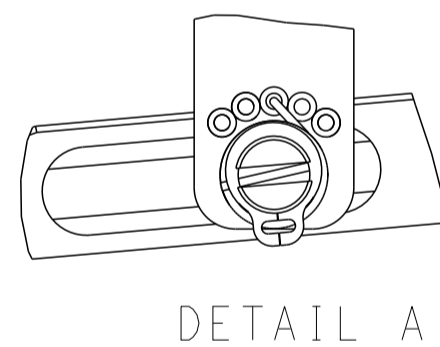
FEED TYPE MECHANICAL



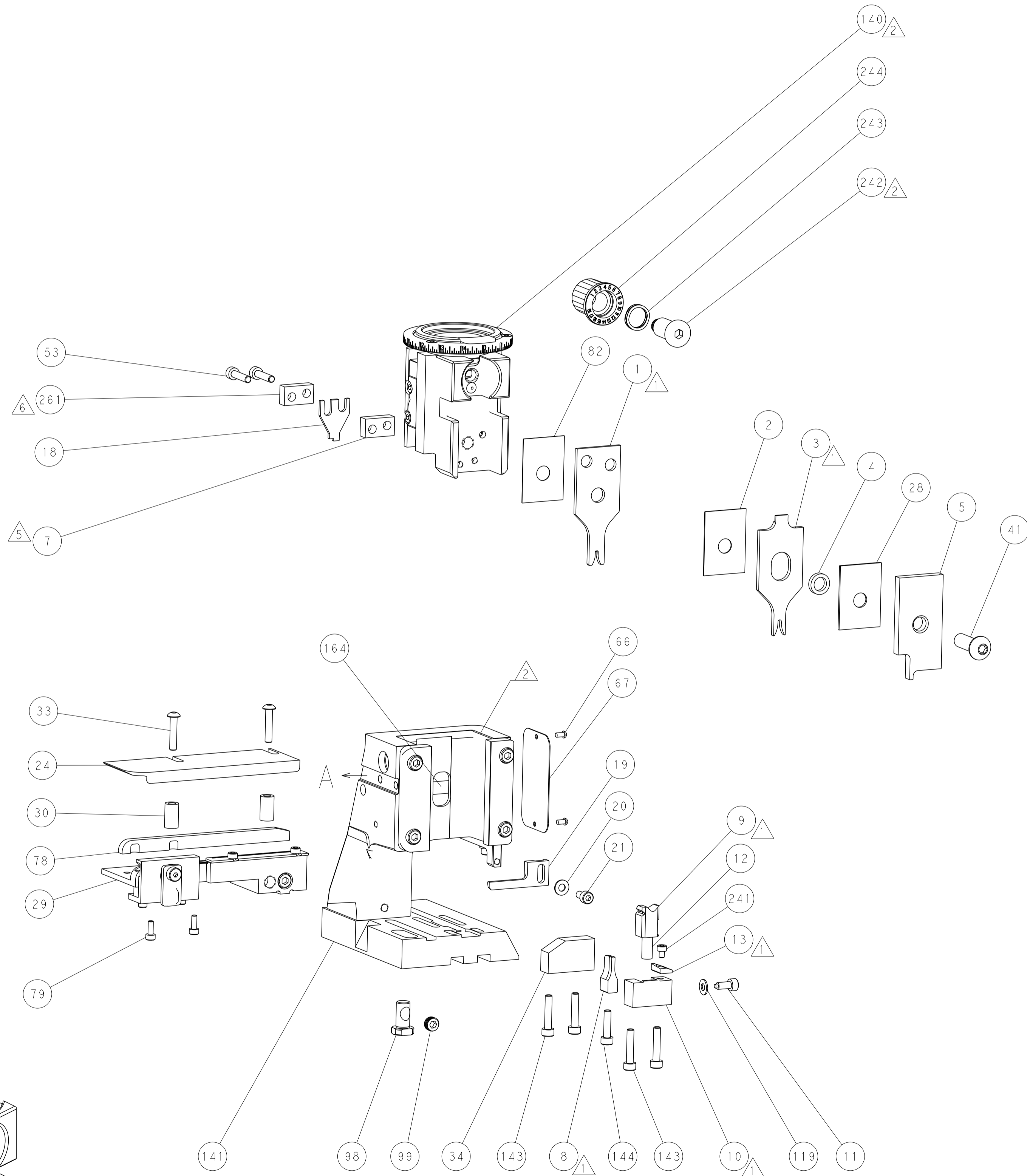
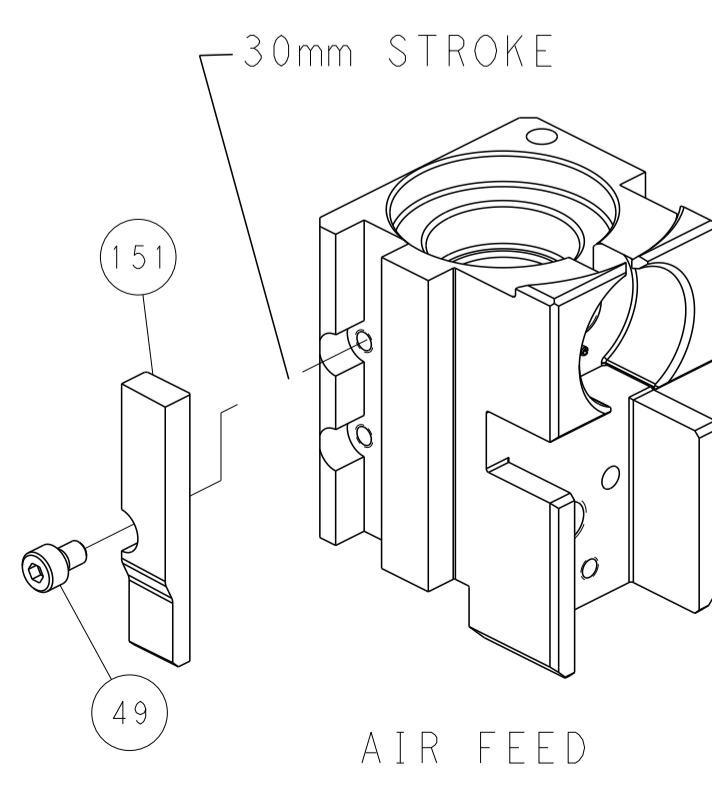
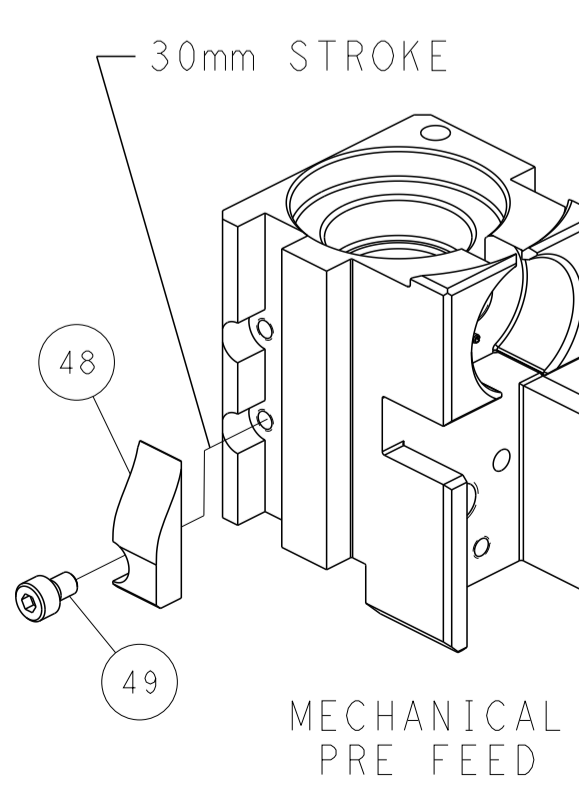
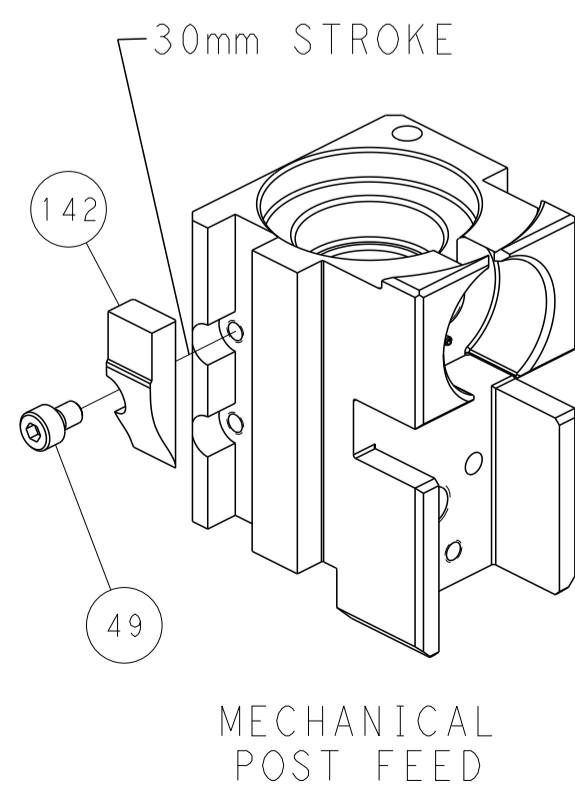
PNEUMATIC



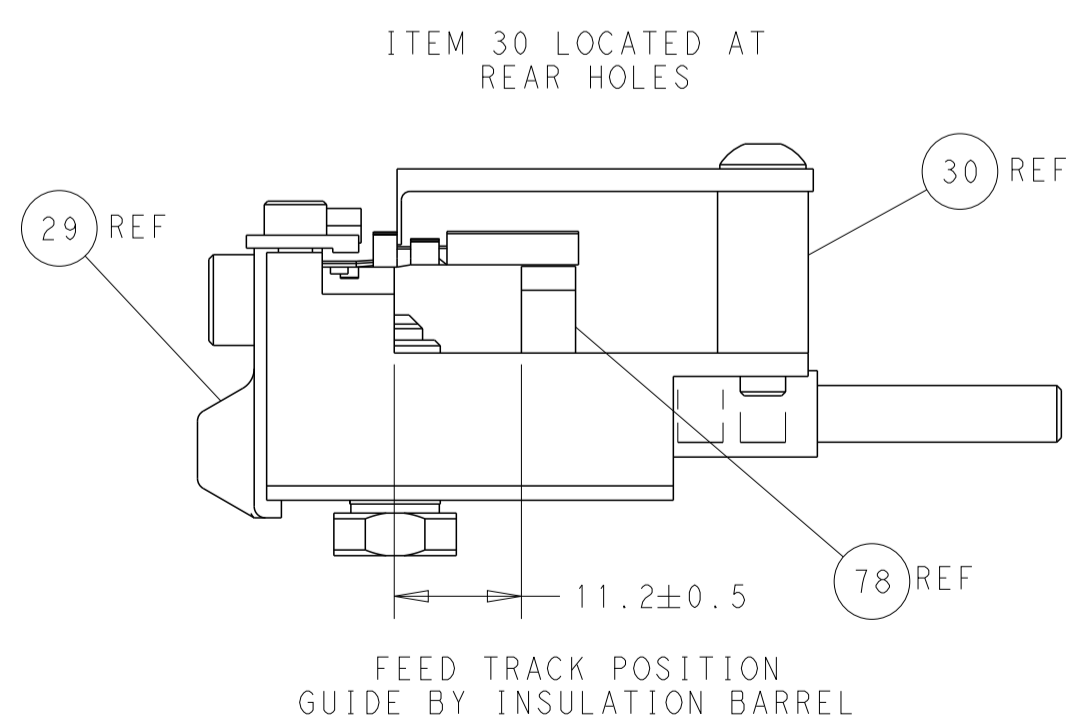
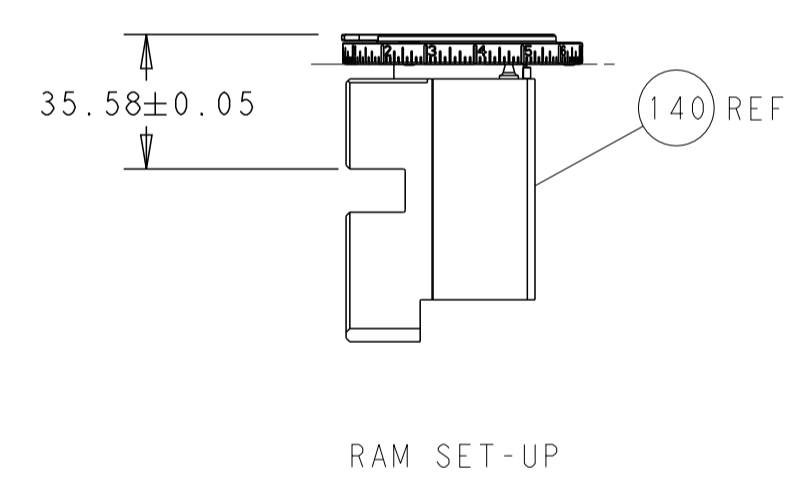
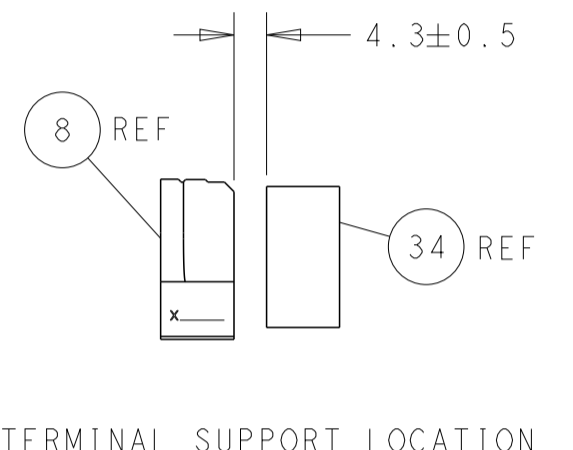
FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



CAM POSITIONS



REVISIONS				
P.	LTN.	DESCRIPTION	DATE	APVD.
-	-	SEE SHEET 1	-	-



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.		OWN: 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 ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		PRODUCT SPEC	APPLICATION SPEC
MATERIAL		WEIGHT	SIZE: A1
		CUSTOMER ACCESSIBLE PRODUCTION DRAWING	SCALE: 1:2 SHEET 4 OF 4 REV: H3

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION