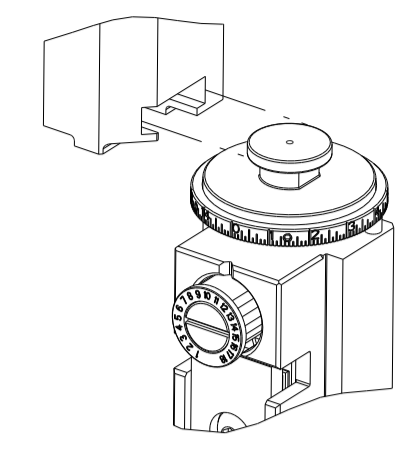


| PART NUMBER | REVISION | DESCRIPTION                            | FEED TYPE  |
|-------------|----------|--|------------|
| 2151346-1   | L        | FINE CRIMP HEIGHT ADJUST               | MECHANICAL |
| 2151346-2   | L        | FINE CRIMP HEIGHT ADJUST               | PNEUMATIC  |
| 5-2151346-1 | L        | SEAL STRIPPER CRIMPER TERMINATING UNIT | MECHANICAL |
| 5-2151346-2 | L        | SEAL STRIPPER CRIMPER TERMINATING UNIT | PNEUMATIC  |
| 7-2151346-1 | L        | MECHANICAL AND CRIMP TOOLING KIT       | MECHANICAL |
| 7-2151346-2 | L        | PNEUMATIC AND CRIMP TOOLING KIT        | PNEUMATIC  |
| 7-2151346-7 | J        | CRIMP TOOLING KIT                      | -          |

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



| APPLICATOR DATA |                |      |
|-----------------|----------------|------|
| CRIMP           | SIZE           | TYPE |
| WIRE            | 2.54 mm [.100] | F    |
| INSUL           | 4.19 mm [.165] | O    |

APPLICATOR INSTRUCTIONS 408-35042

| TERMINAL DATA: TE TERMINAL                |                | TE CRIMP SPECIFICATION    |         |
|---|----------------|---------------------------|---------|
| TERMINAL NAME: 2.8MM FLAT TYPE RECEPTACLE |                |                           |         |
| WIRE STRIP LENGTH                         |                | INSULATION DIAMETER RANGE |         |
| 4.70-5.30 mm [.185-.209 IN]               |                | 3.40 [.134 IN MAX]        | 5       |
| TERMINAL APPLICATION SPECIFICATION        | (A)114-18144-0 | -                         | -       |
|   | (B)114-18144-1 | -                         | -       |
| TERMINALS APPLIED 7                       |                |                           |         |
| TE TERMINAL                               | TE TERMINAL    | TE SEAL                   | TE SEAL |
| (A) 967543-1                              | (B) 968088-1   | 828905-1                  |         |
| (A) 967543-2                              | (B) 968088-2   |                           |         |
| (A) 967543-3                              | (B) 1703035-1  |                           |         |
|   | (B) 1703035-2  |                           |         |

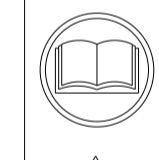
| TERMINAL DATA: TE TERMINAL                |                 | TE CRIMP SPECIFICATION    |              |
|---|-----------------|---------------------------|--------------|
| TERMINAL NAME: 2.8MM FLAT TYPE RECEPTACLE |                 |                           |              |
| WIRE STRIP LENGTH                         |                 | INSULATION DIAMETER RANGE |              |
| 4.70-5.30 mm [.185-.209 IN]               |                 | 3.40 [.134 IN MAX]        | 5            |
| TERMINAL APPLICATION SPECIFICATION        | (C)114-18148    | -                         | -            |
| TERMINALS APPLIED 7                       |                 |                           |              |
| TE TERMINAL                               | TE TERMINAL     | TE SEAL                   | TE SEAL      |
| (C) 1-968857-1                            | (C)11-968857-3  | 828905-1                  | 2236402-1 10 |
| (C) 1-2282364-1                           | (C) 1-2282364-3 |                           |              |
| (C)1-968857-2                             |                 |                           |              |

| TERMINAL DATA: TE TERMINAL                |              | TE CRIMP SPECIFICATION    |         |
|---|--------------|---------------------------|---------|
| TERMINAL NAME: 2.8MM FLAT TYPE RECEPTACLE |              |                           |         |
| WIRE STRIP LENGTH                         |              | INSULATION DIAMETER RANGE |         |
| 4.70-5.30 mm [.185-.209 IN]               |              | 3.40 [.134 IN MAX]        | 5       |
| TERMINAL APPLICATION SPECIFICATION        | (D)114-13295 | -                         | -       |
| TERMINALS APPLIED 7                       |              |                           |         |
| TE TERMINAL                               | TE TERMINAL  | TE SEAL                   | TE SEAL |
| (D)1-968857-3                             |              | 368941-1                  |         |

| WIRE SIZE           | CRIMP HEIGHT mm [INCH]     | CRIMP HEIGHT REFERENCE SETTING |
|---------------------|----------------------------|--------------------------------|
| 2.50mm <sup>2</sup> | 1.88+/-0.05 [.074+/- .002] | 6.1                            |
| 1.50mm <sup>2</sup> | 1.58+/-0.05 [.062+/- .002] | 9.2                            |

| WIRE SIZE                   | CRIMP HEIGHT mm [INCH]     | CRIMP HEIGHT REFERENCE SETTING |
|-----------------------------|----------------------------|--------------------------------|
| 2.50mm <sup>2</sup>         | 1.76+/-0.05 [.069+/- .002] | 8.3                            |
| 2.00mm <sup>2</sup> AVS     | 1.70+/-0.05 [.067+/- .002] | 8.8                            |
| 2.00mm <sup>2</sup>         | 1.70+/-0.05 [.067+/- .002] | 9.2                            |
| 2.00mm <sup>2</sup> AESSX-F | 1.66+/-0.05 [.065+/- .002] | 9.3                            |
| 14 AWG                      | 1.61+/-0.05 [.063+/- .002] | 9.8                            |
| 1.50mm <sup>2</sup>         | 1.47+/-0.05 [.058+/- .002] | 11.4                           |
| 1.25mm <sup>2</sup>         | 1.46+/-0.05 [.057+/- .002] | 11.7                           |
| 16 AWG                      | 1.36+/-0.05 [.054+/- .002] | 12.5                           |

| WIRE SIZE           | CRIMP HEIGHT mm [INCH]     | CRIMP HEIGHT REFERENCE SETTING |
|---------------------|----------------------------|--------------------------------|
| 2.50mm <sup>2</sup> | 1.88+/-0.05 [.074+/- .002] | 7.1                            |



- 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 THIS APPLICATOR APPLIES TERMINAL WITH A SEAL.
 

| SEAL P/N | INSUL. Ø  |
|----------|-----------|
| 828905-1 | 2.2-3.0mm |
| 368941-1 | 2.7-3.0mm |
- 6 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.
- 7 TERMINAL LUBRICANT IS RECOMMENDED.
- 8. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- 9 WIRE TYPES AEX-F, AESSX-F, AVS, AEX, CAVS.

**\*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.

10 THIS CRIMP PARAMETER IS PROVIDED TO MEET A CUSTOM AND UNIQUE CUSTOMER REQUIREMENT. IT HAS BEEN EVALUATED AND IS CONDITIONALLY SPECIFIED BY TE CONNECTIVITY. THIS CUSTOMIZED CRIMP PARAMETER IS NOT LISTED AS AN APPROVED APPLICATION WITHIN A TE CONNECTIVITY APPLICATION SPECIFICATION; HOWEVER, IT HAS BEEN VALIDATED ACCORDING TO TE CONNECTIVITY SPECIFICATIONS 109-18079 (TEST GROUP 1) AND 114-18022. **TE CONNECTIVITY EXPRESSLY DISCLAIMS ANY AND ALL WARRANTIES THAT THE PRODUCT WILL PERFORM SIMILARLY TO VALIDATED AND APPROVED APPLICATIONS, AS STATED WITHIN TE CONNECTIVITY APPLICATION SPECIFICATIONS, INCLUDING BUT NOT LIMITED TO IMPLIED WARRANTIES OF MERCHANTABILITY OR FITNESS FOR PARTICULAR PURPOSE.** AS SUCH, IT IS HIGHLY RECOMMENDED THAT THE CUSTOMER PERFORM FURTHER DETAILED EVALUATION TO ASSESS PRODUCT PERFORMANCE IN THE SPECIFIC APPLICATION.

**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   | P         | LTN | DESCRIPTION   | DATE      | OWN | APVD |
|     |      | K5        |     | ECR-22-158191 | 14NOV2022 | FZ  | GB   |
|     |      | K6        |     | ECR-23-167495 | 27FEB2023 | FZ  | JAH  |
|     |      | K7        |     | ECR-23-167594 | 27FEB2023 | JWC | TE   |
|     |      | L         |     | ECR-23-183768 | 09AUG2023 | TB  | GB   |

|   |     |     |     |     |     |     |             |                                     |     |
|---|-----|-----|-----|-----|-----|-----|-------------|-------------------------------------|-----|
| - | -   | -   | 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   | 2119082-7   | 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 |
| - | -   | -   | 1   | 1   | -   | -   | 2-1752354-6 | 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   | 455888-3    | SPACER, CRIMPER                     | 82  |
| - | 1   | 1   | 1   | 1   | 1   | 1   | 1803607-3   | DOCUMENTATION PACKAGE               | 71  |
| - | 1   | 1   | 1   | 1   | 1   | 1   | 2119791-5   | DEPRESSOR, WIRE                     | 70  |
| - | 1   | 1   | 1   | 1   | 1   | 1   | 2119943-1   | WASHER, SPACER                      | 69  |
| - | 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   | 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   | 2168083-3   | SCR, SKT HD CAP, RoHS, M4 X 12.0    | 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   | 2   | 2   | 1   | 1   | 1   | 1333206-1   | ANVIL, COMBINATION .100             | 8   |
| - | 1   | 1   | 1   | 1   | 1   | 1   | 240641-9    | SPACER                              | 7   |
| - | -   | -   | -   | -   | -   | -   | -           | -                                   | 6   |
| - | 1   | 1   | 1   | 1   | 1   | 1   | 2119781-1   | DEPRESSOR, SHEAR                    | 5   |
| - | 1   | 1   | 1   | 1   | 1   | 1   | 238011-4    | BLOCK, CRIMPER SPACER               | 4   |
| - | 1   | 2   | 2   | 1   | 1   | 1   | 6-1633996-1 | CRIMPER, INSULATION SPECIAL         | 3   |
| - | 1   | 1   | 1   | 1   | 1   | 1   | 455888-8    | SPACER, CRIMPER                     | 2   |
| - | 1   | 2   | 2   | 1   | 1   | 1   | 456407-5    | CRIMPER, WIRE PREMIUM               | 1   |

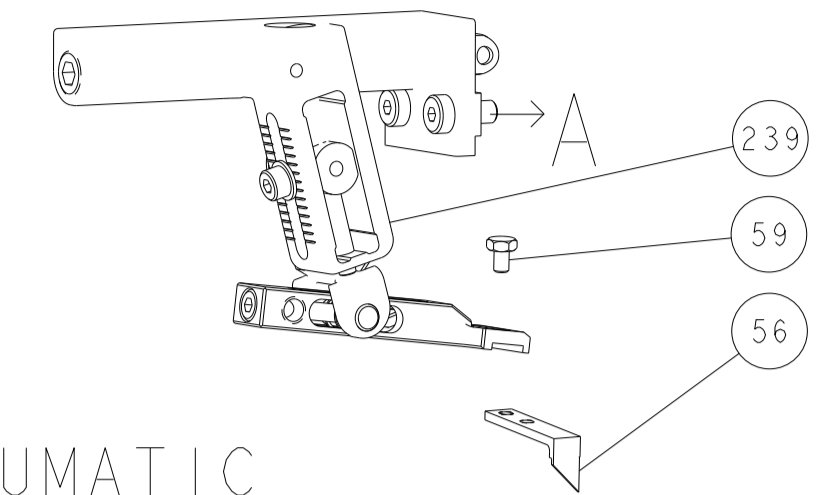
| ITEM NO | PART NO | DESCRIPTION | ITEM NO |
|---------|---------|-------------|---------|
| -77     | -72     | -71         | -52     |
| -51     | -2      | -1          |         |

|             |        |  |  |
|-------------|--------|--|--|
| DIMENSIONS: |        | TOLERANCES UNLESS OTHERWISE SPECIFIED: |  |
| mm          | 0 PLC  | ±                                      |  |
|             | 1 PLC  | ±                                      |  |
|             | 2 PLC  | ±                                      |  |
|             | 3 PLC  | ±                                      |  |
|             | 4 PLC  | ±                                      |  |
|             | ANGLES | ±                                      |  |
|             | FINISH | ±                                      |  |

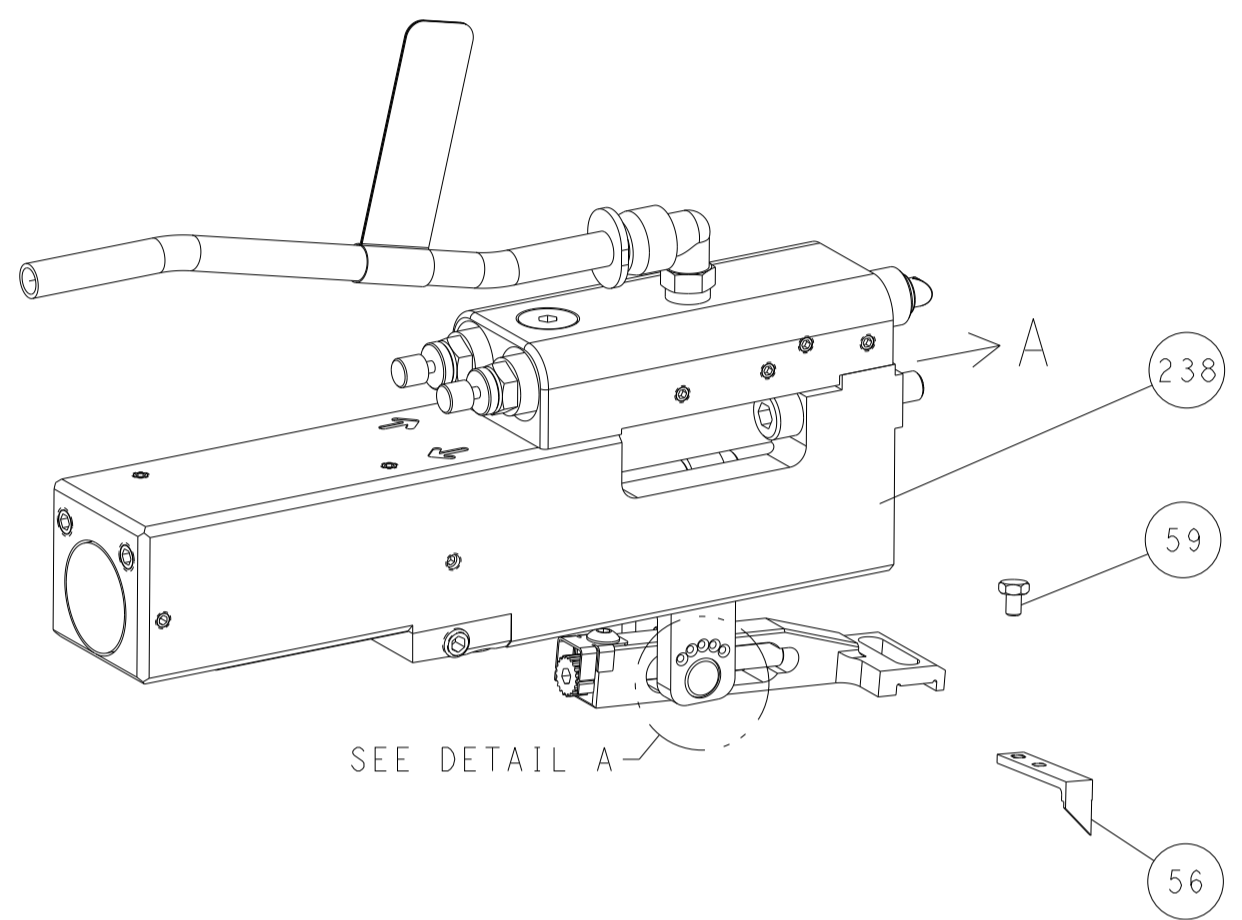
|  |                            |            |               |
|--|----------------------------|------------|---------------|
| OWN                                    | H. HUANG                   | 14NOV2011  |               |
| CHK                                    | S. XI                      | 14NOV2011  |               |
| APVD                                   | J. CRUZ                    | 14NOV2011  |               |
| NAME                                   | Ocean Side Feed Applicator |            |               |
| SIZE                                   | CAGE CODE                  | DRAWING NO | RESTRICTED TO |
| A1                                     | 00779                      | 2151346    |               |
| Customer Accessible Production Drawing |                            | SCALE      | SHEET 1 OF 4  |
|  |                            | 1:2        | REV           |

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

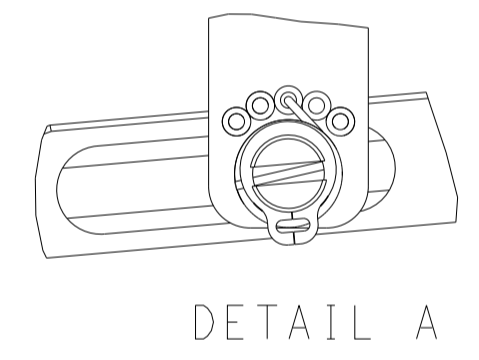
# FEED TYPE MECHANICAL



## PNEUMATIC

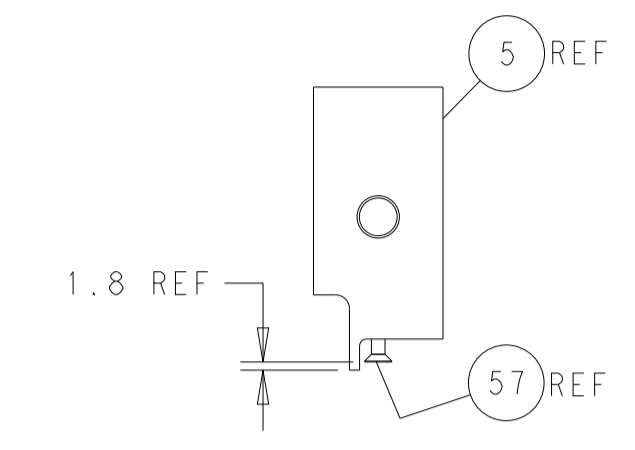
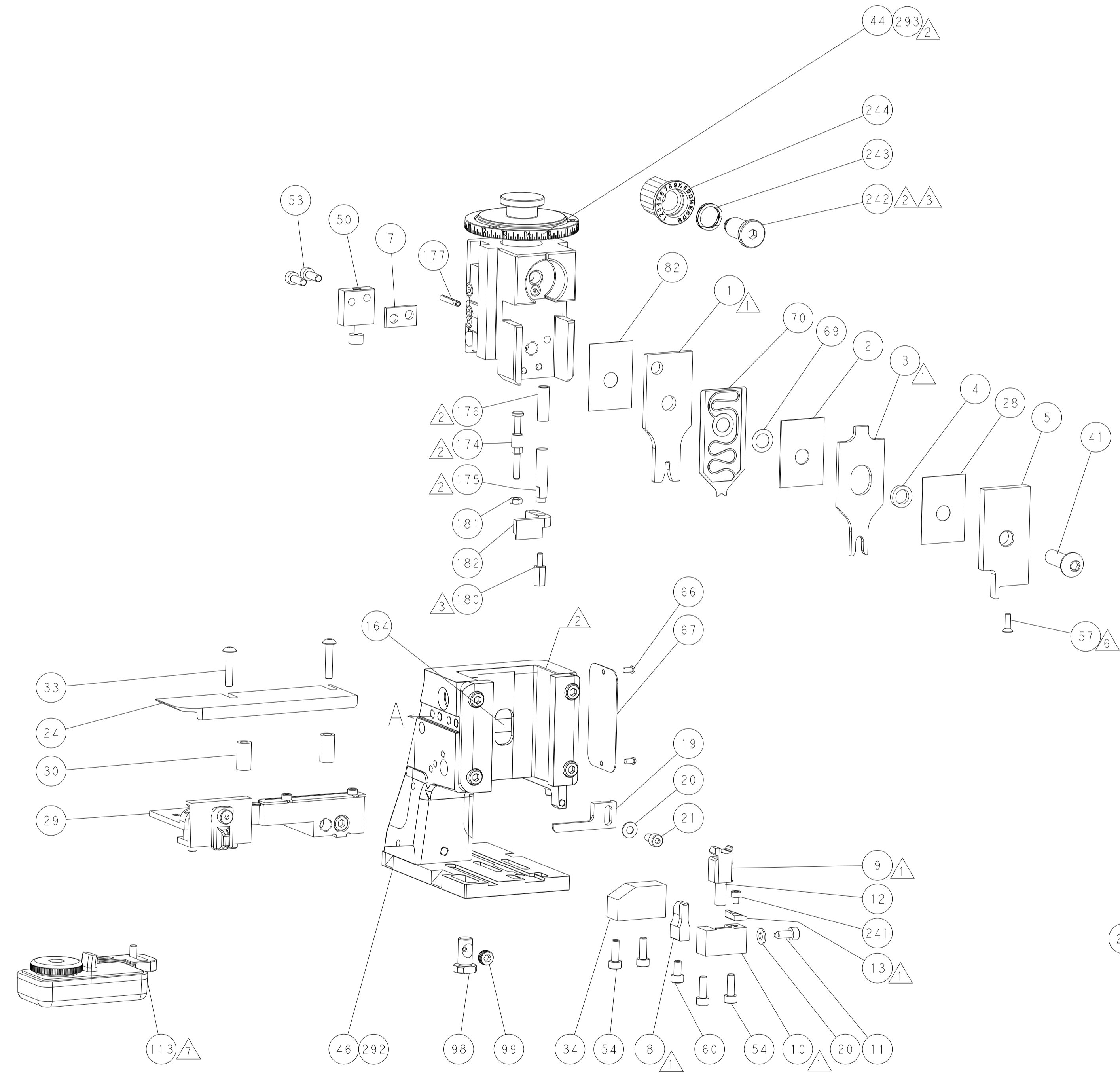
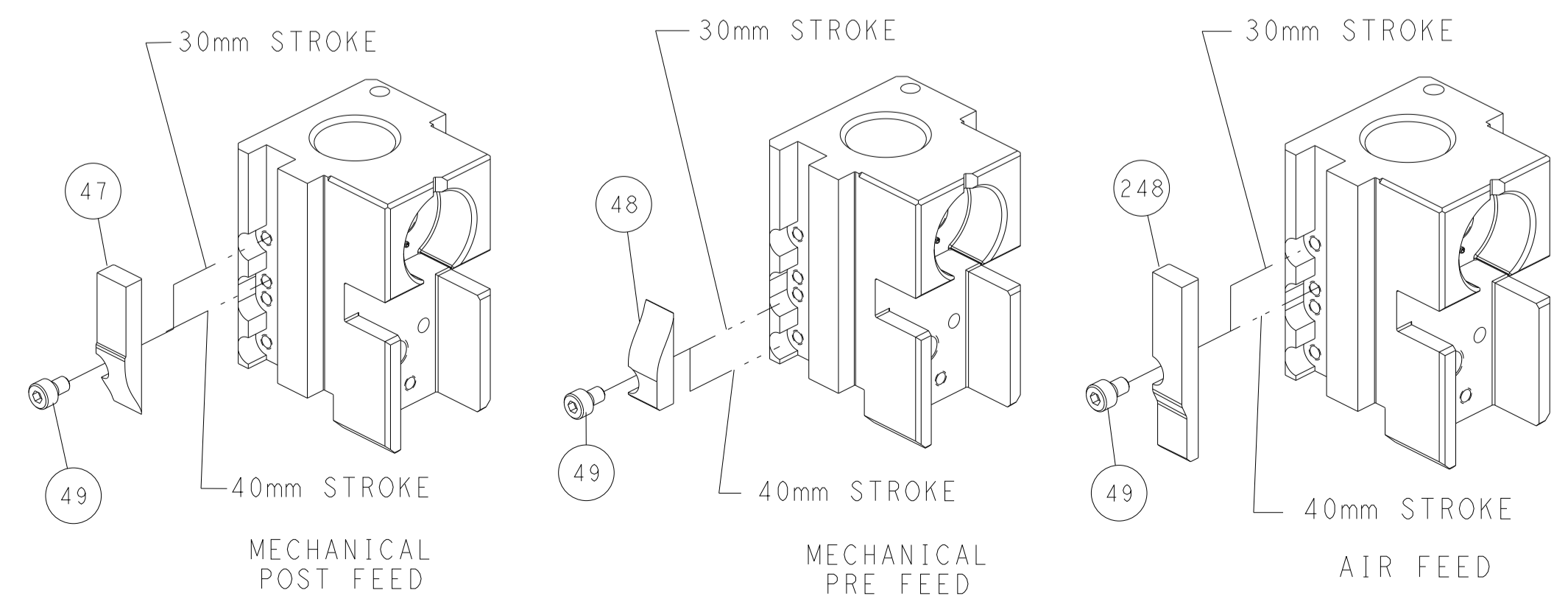


## FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)

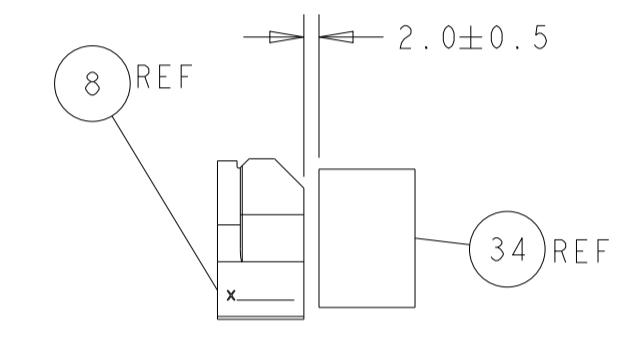


DETAIL A

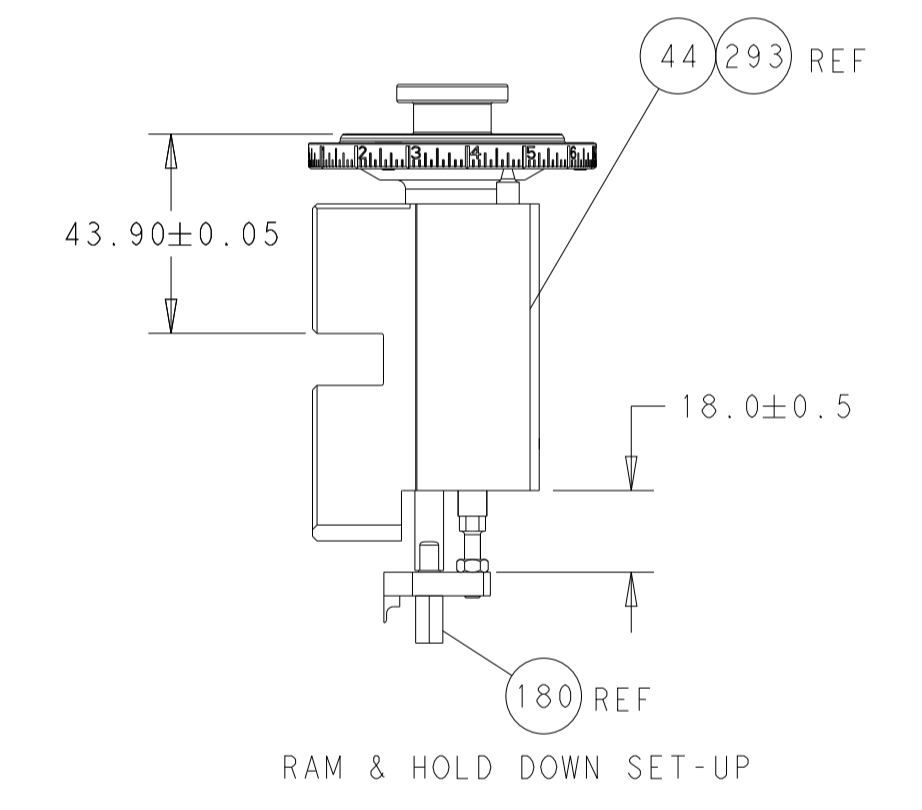
# CAM POSITIONS



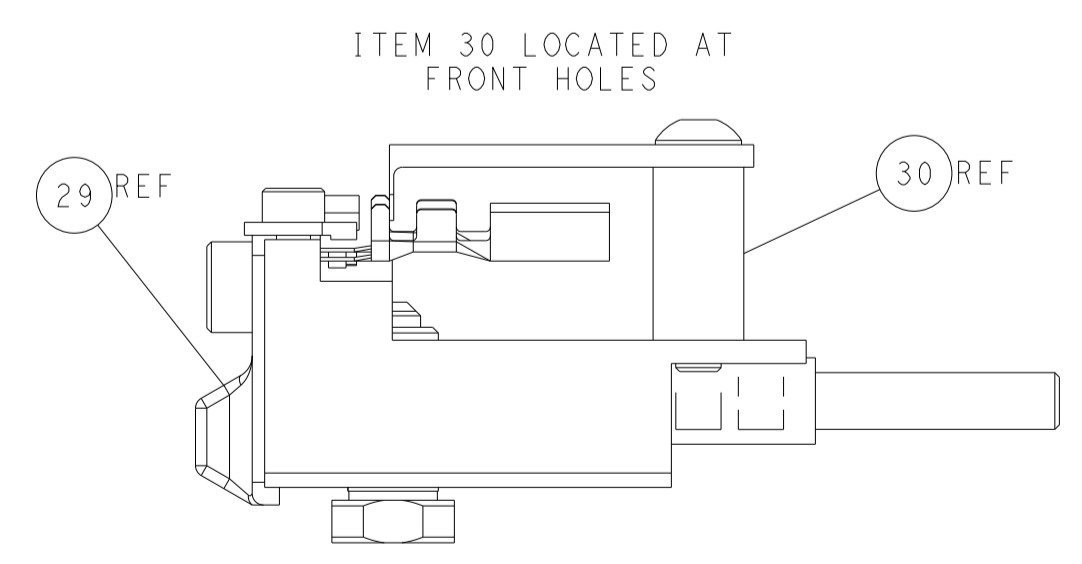
SHEAR DEPRESSOR DETAIL



TERMINAL SUPPORT LOCATION



RAM & HOLD DOWN SET-UP



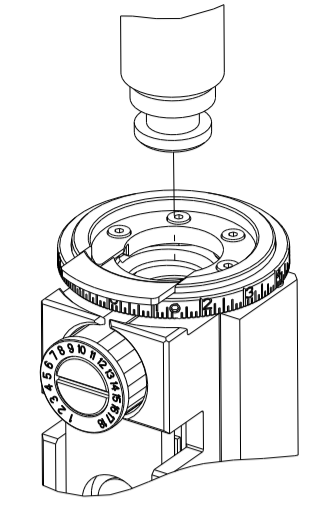
FEED TRACK POSITION GUIDE BY INSULATION BARREL

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

|  |  |  |  |
|--|--|--|--|
| <small>THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.</small>         |  | DWN: R. HUANG 14NOV2011<br>CHK: S. XI 14NOV2011<br>APVD: J. CRUZ 14NOV2011 | NAME: Ocean Side Feed Applicator<br>SIZE: A1<br>CAGE CODE: 00779<br>DRAWING NO: 2151346<br>SCALE: 1:2<br>SHEET: 2 of 4<br>REV: L |
| DIMENSIONS: mm<br>TOLERANCES UNLESS OTHERWISE SPECIFIED:<br>0 PLC ±<br>1 PLC ±<br>2 PLC ±<br>3 PLC ±<br>4 PLC ±<br>ANGLES FINISH ± | TOLERANCES UNLESS OTHERWISE SPECIFIED:<br>0 PLC ±<br>1 PLC ±<br>2 PLC ±<br>3 PLC ±<br>4 PLC ±<br>ANGLES FINISH ± | WEIGHT: -<br>MATERIAL: -   | RESTRICTED TO: -<br>Customer Accessible Production Drawing   |

| PART NUMBER | REVISION | DESCRIPTION              | FEED TYPE  |
|-------------|----------|--------------------------|------------|
| 2-2151346-1 | L        | FINE CRIMP HEIGHT ADJUST | MECHANICAL |
| 2-2151346-2 | L        | FINE CRIMP HEIGHT ADJUST | PNEUMATIC  |
| 7-2151346-7 | J        | CRIMP TOOLING KIT        | -          |

PACIFIC VERSION TERMINATOR INTERFACE ADAPTER



| APPLICATOR DATA                      |                |      |
|--------------------------------------|----------------|------|
| CRIMP                                | SIZE           | TYPE |
| WIRE                                 | 2.54 mm [.100] | F    |
| INSUL                                | 4.19 mm [.165] | O    |
| APPLICATOR INSTRUCTIONS<br>408-35042 |                |      |

| TERMINAL DATA: TE TERMINAL                |                | TE CRIMP SPECIFICATION    |         |
|---|----------------|---------------------------|---------|
| TERMINAL NAME: 2.8MM FLAT TYPE RECEPTACLE |                |                           |         |
| WIRE STRIP LENGTH                         |                | INSULATION DIAMETER RANGE |         |
| 4.70-5.30 mm [.185-.209 IN]               |                | ∅ 3.40 [.134 IN MAX]      | 5       |
| TERMINAL APPLICATION SPECIFICATION        | (A)114-18144-0 | -                         | -       |
|   | (B)114-18144-1 | -                         | -       |
| TERMINALS APPLIED 7                       |                |                           |         |
| TE TERMINAL                               | TE TERMINAL    | TE SEAL                   | TE SEAL |
| (A) 967543-1                              | (B) 968088-1   | 828905-1                  |         |
| (A) 967543-2                              | (B) 968088-2   |                           |         |
| (A) 967543-3                              | (B) 1703035-1  |                           |         |
|   | (B) 1703035-2  |                           |         |

| TERMINAL DATA: TE TERMINAL                |                 | TE CRIMP SPECIFICATION    |              |
|---|-----------------|---------------------------|--------------|
| TERMINAL NAME: 2.8MM FLAT TYPE RECEPTACLE |                 |                           |              |
| WIRE STRIP LENGTH                         |                 | INSULATION DIAMETER RANGE |              |
| 4.70-5.30 [.185-.209 IN]                  |                 | ∅ 3.40 [.134 IN MAX]      | 5            |
| TERMINAL APPLICATION SPECIFICATION        | (C) 114-18148   | -                         | -            |
|   | -               | -                         | -            |
| TERMINALS APPLIED 7                       |                 |                           |              |
| TE TERMINAL                               | TE TERMINAL     | TE SEAL                   | TE SEAL      |
| (C) 1-968857-1                            | (C) 1-968857-3  | 828905-1                  | 2236402-1 10 |
| (C) 1-2282364-1                           | (C) 1-2282364-3 |                           |              |
| (C)1-968857-2                             |                 |                           |              |

| TERMINAL DATA: TE TERMINAL                |              | TE CRIMP SPECIFICATION    |         |
|---|--------------|---------------------------|---------|
| TERMINAL NAME: 2.8MM FLAT TYPE RECEPTACLE |              |                           |         |
| WIRE STRIP LENGTH                         |              | INSULATION DIAMETER RANGE |         |
| 4.70-5.30 mm [.185-.209 IN]               |              | ∅ 3.40 [.134 IN MAX]      | 5       |
| TERMINAL APPLICATION SPECIFICATION        | (D)114-13295 | -                         | -       |
|   | -            | -                         | -       |
| TERMINALS APPLIED 7                       |              |                           |         |
| TE TERMINAL                               | TE TERMINAL  | TE SEAL                   | TE SEAL |
| (D)1-968857-3                             |              | 368941-1                  |         |

| WIRE SIZE | CRIMP HEIGHT mm [INCH]        | CRIMP HEIGHT REFERENCE SETTING |
|-----------|-------------------------------|--------------------------------|
| 2.50mm2   | 1.88 +/- 0.05 [.074 +/- .002] | 6.1                            |
| 1.50mm2   | 1.58 +/- 0.05 [.062 +/- .002] | 9.2                            |

| WIRE SIZE       | CRIMP HEIGHT mm [INCH]        | CRIMP HEIGHT REFERENCE SETTING |
|-----------------|-------------------------------|--------------------------------|
| 2.50mm2         | 1.76 +/- 0.05 [.069 +/- .002] | 8.3                            |
| 2.00mm2 AVS     | 1.70 +/- 0.05 [.067 +/- .002] | 8.8                            |
| 2.00mm2         | 1.70 +/- 0.05 [.067 +/- .002] | 9.2                            |
| 2.00mm2 AESSX-F | 1.66 +/- 0.05 [.065 +/- .002] | 9.3                            |
| 14 AWG          | 1.61 +/- 0.05 [.063 +/- .002] | 9.8                            |
| 1.50mm2         | 1.47 +/- 0.05 [.058 +/- .002] | 11.4                           |
| 1.25mm2         | 1.46 +/- 0.05 [.057 +/- .002] | 11.7                           |
| 16 AWG          | 1.36 +/- 0.05 [.054 +/- .002] | 12.5                           |

| WIRE SIZE | CRIMP HEIGHT mm [INCH]        | CRIMP HEIGHT REFERENCE SETTING |
|-----------|-------------------------------|--------------------------------|
| 2.50mm2   | 1.88 +/- 0.05 [.074 +/- .002] | 7.1                            |

- 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.

| SEAL P/N | INSUL. ∅  |
|----------|-----------|
| 828905-1 | 2.2-3.0mm |
| 368941-1 | 2.7-3.0mm |
- 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.
- 9 WIRE TYPES AEX-F, AESSX-F, AVS, AEX, CAVS.
- 10 THIS CRIMP PARAMETER IS PROVIDED TO MEET A CUSTOM AND UNIQUE CUSTOMER REQUIREMENT. IT HAS BEEN EVALUATED AND IS CONDITIONALLY SPECIFIED BY TE CONNECTIVITY. THIS CUSTOMIZED CRIMP PARAMETER IS NOT LISTED AS AN APPROVED APPLICATION WITHIN A TE CONNECTIVITY APPLICATION SPECIFICATION; HOWEVER, IT HAS BEEN VALIDATED ACCORDING TO TE CONNECTIVITY SPECIFICATIONS 109-18079 (TEST GROUP 1) AND 114-18022. **TE CONNECTIVITY EXPRESSLY DISCLAIMS ANY AND ALL WARRANTIES THAT THE PRODUCT WILL PERFORM SIMILARLY TO VALIDATED AND APPROVED APPLICATIONS, AS STATED WITHIN TE CONNECTIVITY APPLICATION SPECIFICATIONS, INCLUDING BUT NOT LIMITED TO IMPLIED WARRANTIES OF MERCHANTABILITY OR FITNESS FOR PARTICULAR PURPOSE.** AS SUCH, IT IS HIGHLY RECOMMENDED THAT THE CUSTOMER PERFORM FURTHER DETAILED EVALUATION TO ASSESS PRODUCT PERFORMANCE IN THE SPECIFIC APPLICATION.

**\*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 |
| 8-2151061-1            | 2151061-1   | 1                      | WIRE CRIMPER        | 1803552-5              |
| 8-2151061-2            | 2151061-2   | 3                      | INSULATION CRIMPER  | 6-1803674-1            |
| 9-2151061-1            | 2-2151061-1 | 46                     | BASIC SUB -ASSEMBLY | 1803940-9              |
| 9-2151061-2            | 2-2151061-2 | 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)

| LOC | DIST | REVISIONS |             |      |     |      |
|-----|------|-----------|-------------|------|-----|------|
| A   | 66   | P LTM     | DESCRIPTION | DATE | OWN | APVD |
|     |      | -         | 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   | 2119955-1   | ASSY, LUBRICATOR, SIDE FEED         | 113 |
| - | 1   | 1   | 2844908-1   | SCREW, LOCKING                      | 99  |
| - | 1   | 1   | 2844907-1   | POST, LOCKING                       | 98  |
| - | 1   | 1   | 455888-3    | SPACER, CRIMPER                     | 82  |
| - | 1   | 1   | 1803607-3   | DOCUMENTATION PACKAGE               | 71  |
| - | 1   | 1   | 2119791-5   | 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   | 2168083-3   | SCR, SKT HD CAP, RoHS, M4 X 12.0    | 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   | 1333206-1   | ANVIL, COMBINATION .100             | 8   |
| - | 1   | 1   | 240641-9    | SPACER                              | 7   |
| - | -   | -   | -           | -                                   | 6   |
| - | 1   | 1   | 2119781-1   | DEPRESSOR, SHEAR                    | 5   |
| - | 1   | 1   | 238011-4    | BLOCK, CRIMPER SPACER               | 4   |
| - | 1   | 1   | 6-1633996-1 | CRIMPER, INSULATION SPECIAL         | 3   |
| - | 1   | 1   | 455888-8    | SPACER, CRIMPER                     | 2   |
| - | 1   | 1   | 456407-5    | CRIMPER, WIRE PREMIUM               | 1   |

| DIMENSIONS: |         | TOLERANCES UNLESS OTHERWISE SPECIFIED: |         | DRAWING NO    |         |
|-------------|---------|--|---------|---------------|---------|
| mm          | 0 PLC ± | 1 PLC ±                                | 2 PLC ± | 3 PLC ±       | 4 PLC ± |
|             | ANGLES  | FINISH                                 |         |               |         |
| MATERIAL    |         | WEIGHT                                 |         | RESTRICTED TO |         |
|             |         |  |         |               |         |

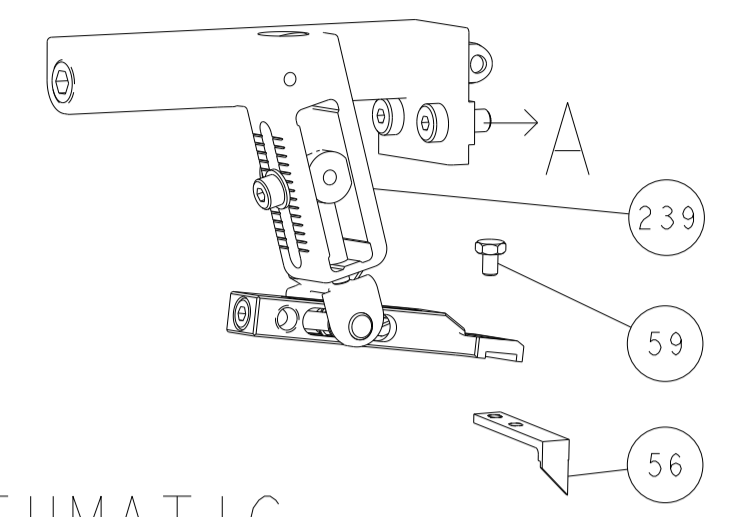
| OWN      | CHK     | DATE      | NAME |
|----------|---------|-----------|------|
| R. HUANG | S. XI   | 14NOV2011 |      |
|          | I. CRUZ | 14NOV2011 |      |

| DESCRIPTION                            | ITEM NO |
|--|---------|
| Ocean Side Feed Applicator             |         |
| Customer Accessible Production Drawing |         |

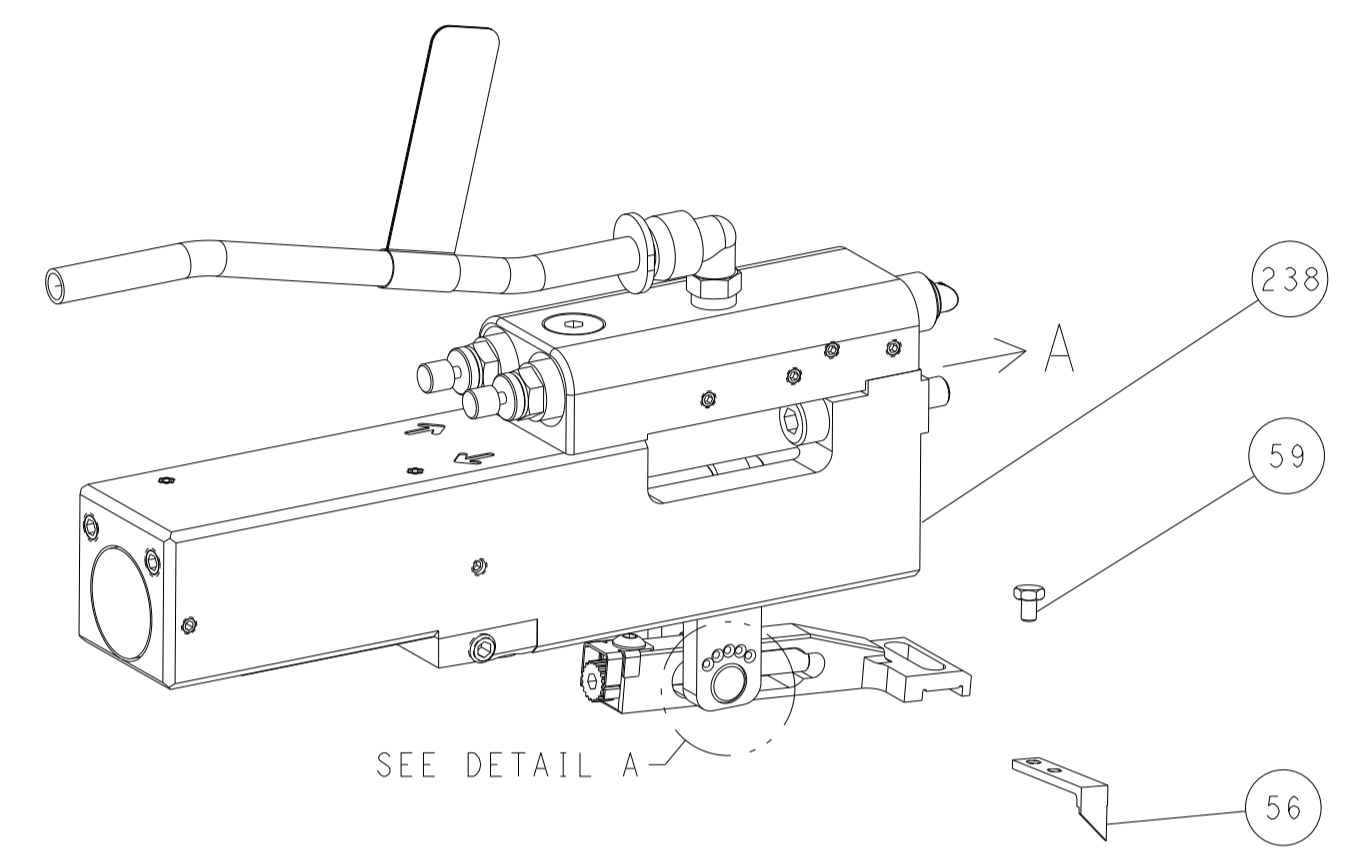
SCALE 1:2 SHEET 3 OF 4 REV L

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

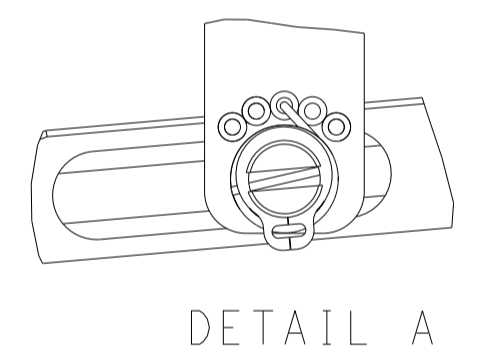
# FEED TYPE MECHANICAL



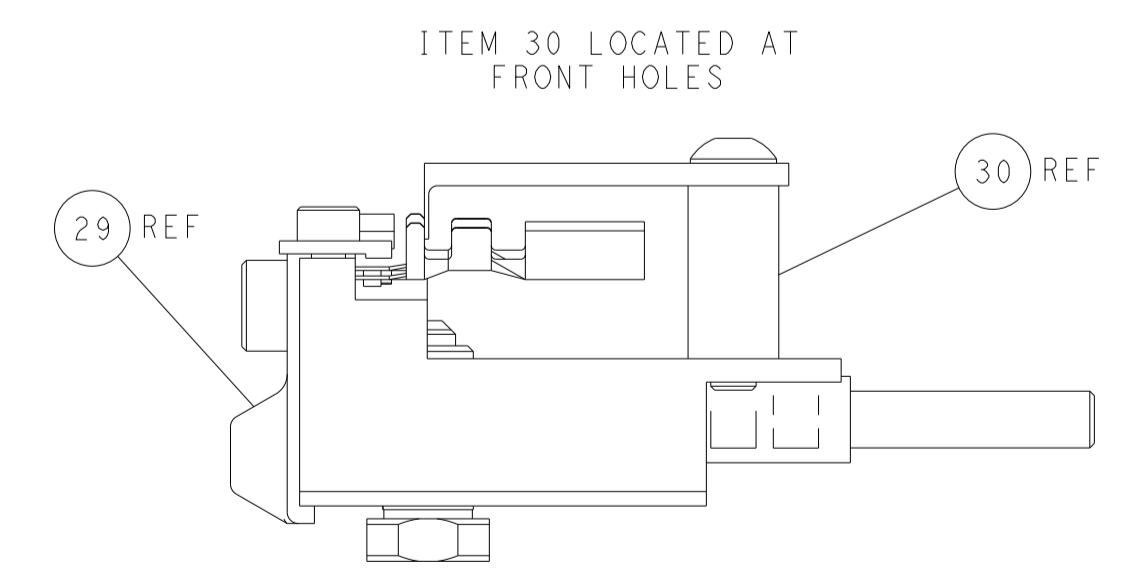
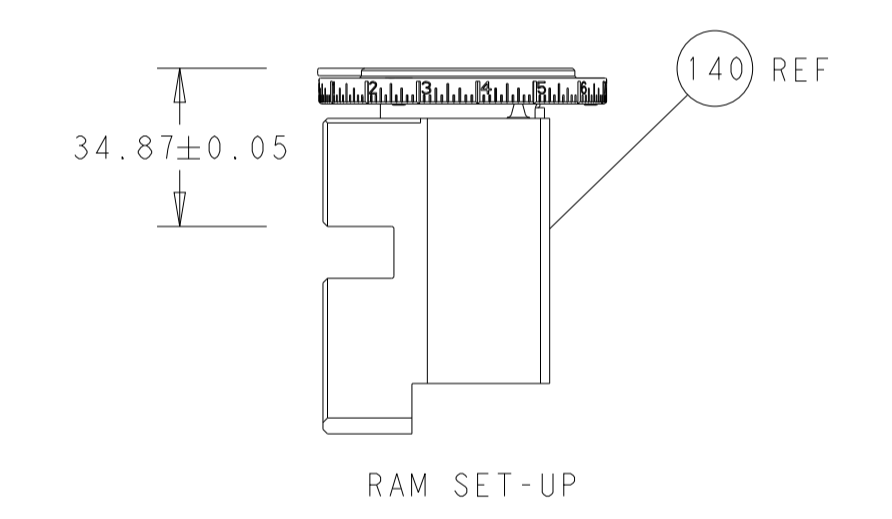
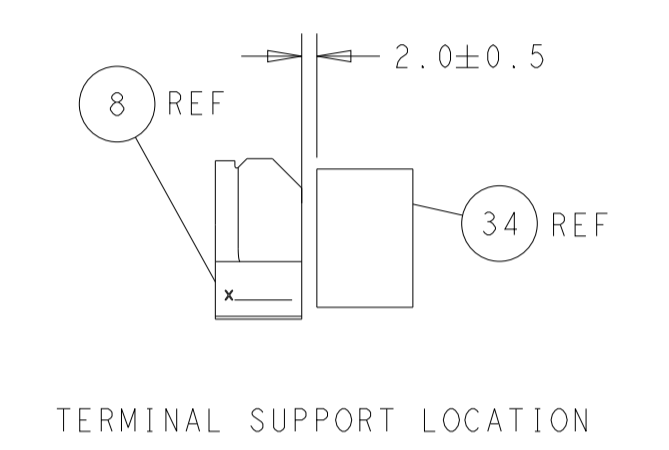
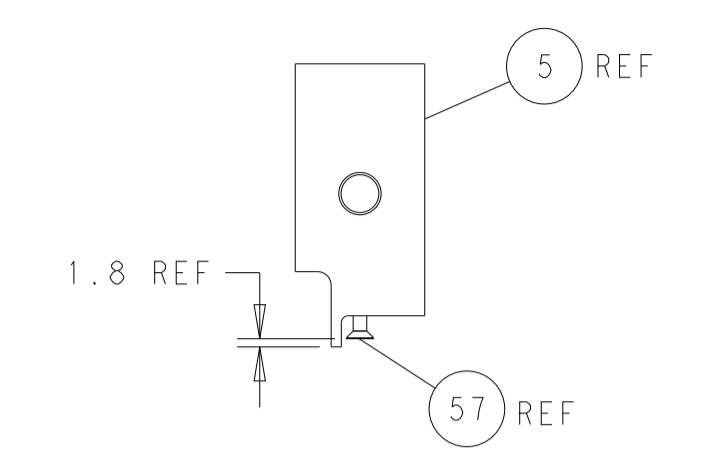
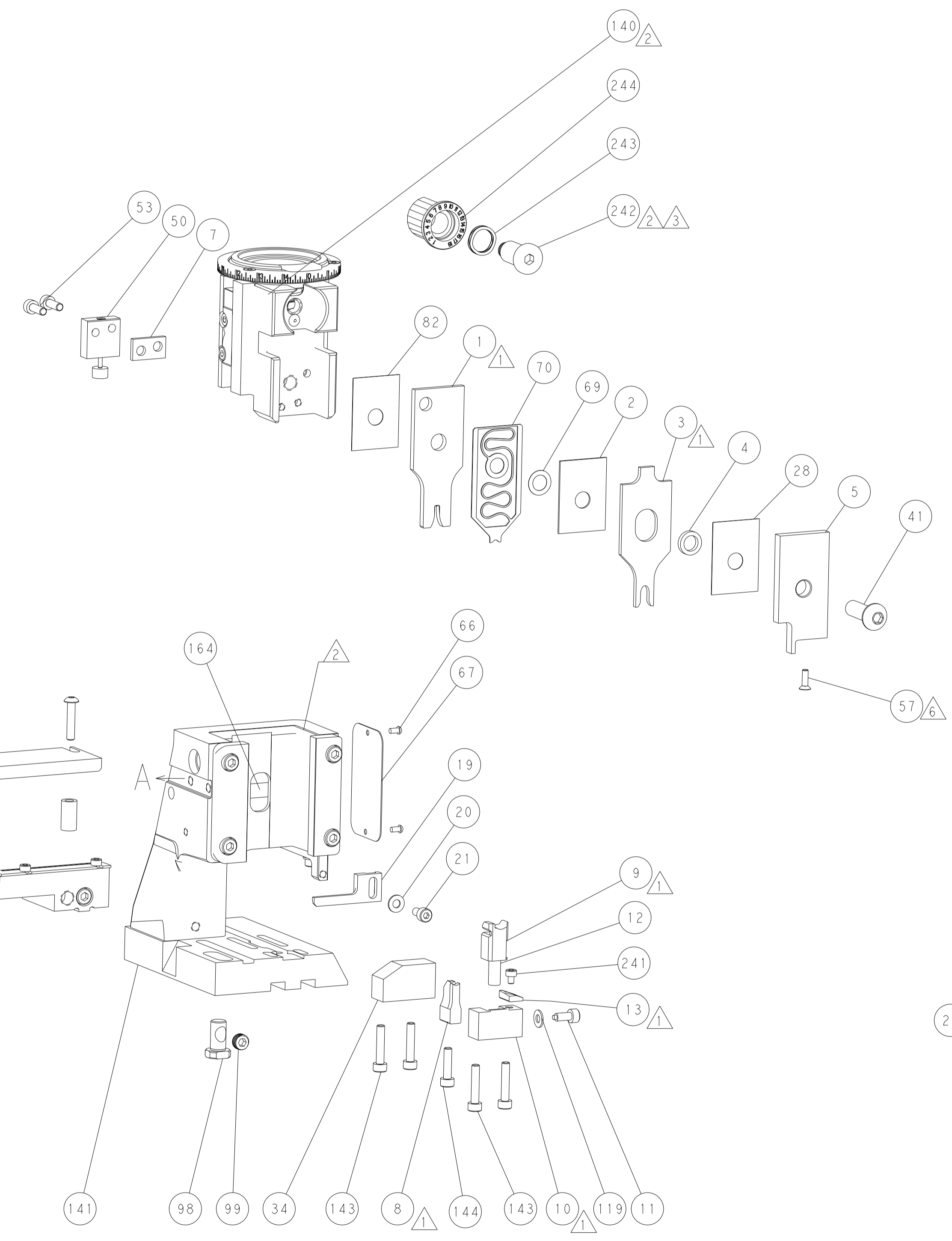
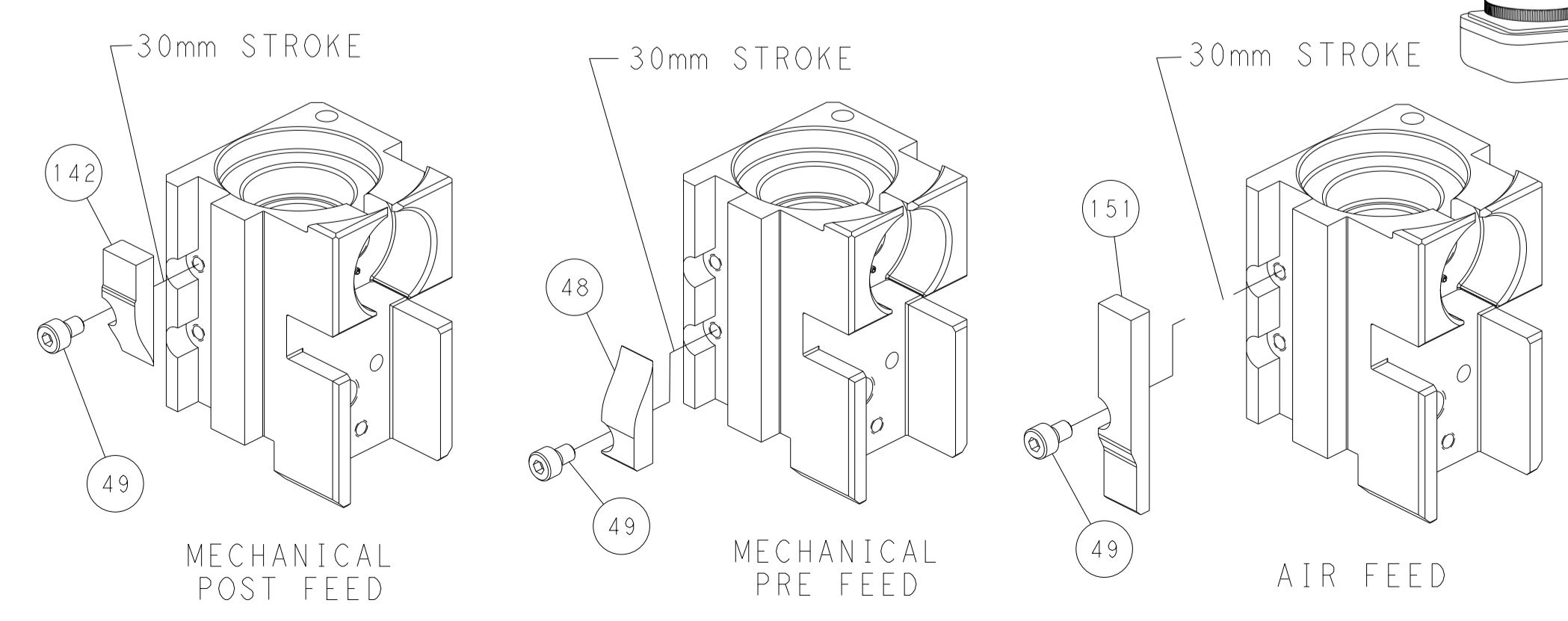
## PNEUMATIC



### FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



## CAM POSITIONS



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

|   |   |  |  |
|---|---|--|--|
| <small>THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION. IT IS THE PROPERTY OF COMPANY AND CONTROL AND INSPECTION ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST REVISION.</small> |   | DWN: R. HUANG 14NOV2011<br>CHK: S. XI 14NOV2011<br>APVD: J. CRUZ 14NOV2011 | NAME: TE Connectivity<br>Harrisburg, PA 17105-3608 |
| DIMENSIONS: mm<br>TOLERANCES UNLESS OTHERWISE SPECIFIED:<br>0 PLC ±<br>1 PLC ±<br>2 PLC ±<br>3 PLC ±<br>4 PLC ±<br>ANGLES FINISH ±  | APPLICATION SPEC<br>PRODUCT SPEC<br>RESTRICTED TO | SIZE: A1<br>CAGE CODE: 00779<br>DRAWING NO: ©=2151346                      | SCALE: 1:2<br>SHEET: 4 OF 4<br>REV: L              |
| MATERIAL:   |   | WEIGHT:  | Customer Accessible Production Drawing             |