

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151372-1	M	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2151372-2	M	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
5-2151372-1	M	SEAL STRIPPER CRIMPER TERMINATING UNIT	MECHANICAL
5-2151372-2	M	SEAL STRIPPER CRIMPER TERMINATING UNIT	PNEUMATIC
7-2151372-1	M	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2151372-2	M	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2151372-7	L	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA

CRIMP	SIZE	TYPE
WIRE	1.78 mm [.070]	F
INSUL	3.30 mm [.130]	O

APPLICATOR INSTRUCTIONS 408-35042

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION

TERMINAL NAME: MINI UNIVERSAL MATE-N-LOK PIN & SOCKET

WIRE STRIP LENGTH	INSULATION DIAMETER RANGE
3.20-3.70 mm [.126-.146 IN]	Ø2.00-3.20 mm [.079-.126 IN]

TERMINAL APPLICATION SPECIFICATION (A)1114-16017 (B)114-1111

TERMINALS APPLIED

TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
(A) 794407-1	(A) 794407-6	(A) 794406-3	(B) 1-794222-0
(A) 794407-2	(A) 1-794407-0	(A) 1-794406-0	(B) 794223-1
(A) 794407-3	(A) 1-794407-1	(B) 794222-1	(B) 794223-2
(A) 794407-4	(A) 794406-1	(B) 794222-2	(B) 794223-3
(A) 794407-5	(A) 794406-2	(B) 794222-3	(B) 1-794223-0

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
2 X 20 AWG	1.30+/-0.05 [.051+/-0.002]	3.8
16 AWG	1.30+/-0.05 [.051+/-0.002]	4.2
1.00mm ²	1.27+/-0.05 [.050+/-0.002]	4.5
18 AWG	1.21+/-0.05 [.048+/-0.002]	4.7
20 AWG	1.07+/-0.05 [.042+/-0.002]	6.5

- 1 RECOMMENDED SPARE PARTS
- 2 REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION & STORAGE OF APPLICATOR.
- 3 APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 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. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT 101-35000.
- 6. 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.

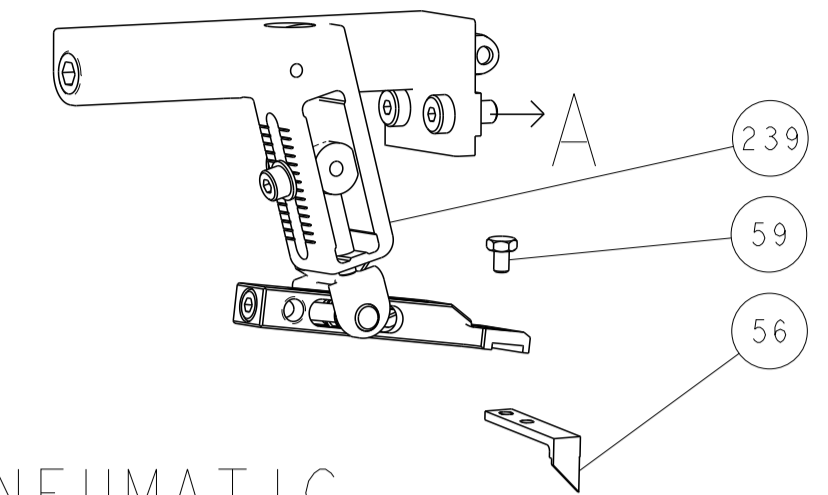
LOC	DIST	REV	DATE	BY	CHK	APPV
A	66	K	07JUL2020	JAH	TE	
		L	16NOV2020	JWC	GB	
		L	08JUN2021	FJ	RK	
		M	05DEC2023	ROY	JAH	

REV	DATE	BY	CHK	APPV	DESCRIPTION	ITEM NO	
-	-	-	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	2119082-8 CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	1	1	2079764-1 WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1	1	1	1	2119083-1 RETAINER, INSULATION DIAL	242
-	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	-	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	-	1-1752354-6 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	994970-2 COUNTER, MAGNETIC	164
-	1	1	1	1	1	1-18028-2 WASHER, FLAT, REG M4	119
-	1	1	1	1	1	2119955-1 ASSY, LUBRICATOR, SIDE FEED	113
-	1	1	1	1	1	2844908-1 SCREW, LOCKING	99
-	1	1	1	1	1	2844907-1 POST, LOCKING	98
-	1	1	1	1	1	455888-5 SPACER, CRIMPER -	82
-	1	1	1	1	1	1803607-3 DOCUMENTATION PACKAGE	71
-	1	1	1	1	1	2119791-5 DEPRESSOR, WIRE	70
-	1	1	1	1	1	2119740-1 TAG, IDENTIFICATION	67
-	2	2	2	2	2	2168078-1 SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	1	1	1	1	1	2168083-2 SCR, SKT HD CAP, RoHS, M4 X 8.0	60
-	1	1	1	1	1	5-18022-5 SCR, HEX HD CAP, M4 X 6.0	59
-	1	1	1	1	1	1338685-1 PAWL, FEED	56
-	4	4	4	4	4	2168083-3 SCR, SKT HD CAP, RoHS, M4 X 12.0	54
-	2	2	2	2	2	1-2168083-0 SCR, SKT HD CAP, RoHS, M4 X 10	53
-	1	1	1	1	1	1803382-1 HOLD DOWN, SPRING LOADED	50
-	1	2	1	2	1	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	1803583-9 APPLICATOR BASIC ASSEMBLY, SF	46
-	1	1	-	-	1	1803515-1 RAM ASSEMBLY, SF ATLANTIC	44
-	1	1	1	1	1	1803602-1 SCR, BHSC, RoHS (M8 X 25)	41
-	1	1	1	1	1	2-1752356-0 SUPPORT, TERMINAL	34
-	2	2	2	2	2	2079383-5 SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	2	2	2	2-2844962-8 SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	1	1	1	2844992-1 ASSEMBLY, STRIP GUIDE -	29
-	1	1	1	1	1	1-455888-0 SPACER, CRIMPER -	28
-	1	1	1	1	1	1320928-2 STRIP GUIDE	24
-	1	1	-	-	1	2168083-2 SCR, SKT HD CAP, RoHS, M4 X 8.0	21
-	2	2	1	1	2	1-18028-2 WASHER, FLAT, REG M4	20
-	1	1	-	-	1	2119533-1 STRIPPER, SIDE FEED	19
-	1	1	1	1	1	2119806-1 INSERT, SHEAR	13
-	1	1	1	1	1	3-22280-3 SPRING, COMPRESSION	12
-	1	1	1	1	1	1-356885-5 STOP, SHEAR	11
-	1	1	1	1	1	2119805-1 SHEAR HOLDER, FRONT -	10
-	1	1	1	1	1	1803095-3 FLOATING SHEAR, FRONT -	9
1	2	2	1	1	1	6-1333203-2 ANVIL, COMBINATION	8
-	1	1	1	1	1	3-240641-8 SPACER	7
-	-	-	-	-	-	-	6
-	1	1	1	1	1	2119757-8 DEPRESSOR, SHEAR	5
-	1	1	1	1	1	238011-2 BLOCK, CRIMPER SPACER	4
1	2	2	1	1	1	2-1803464-9 CRIMPER, INSULATION O	3
-	1	1	1	1	1	455888-3 SPACER, CRIMPER -	2
1	2	2	1	1	1	2-456404-5 CRIMPER, WIRE PREMIUM	1

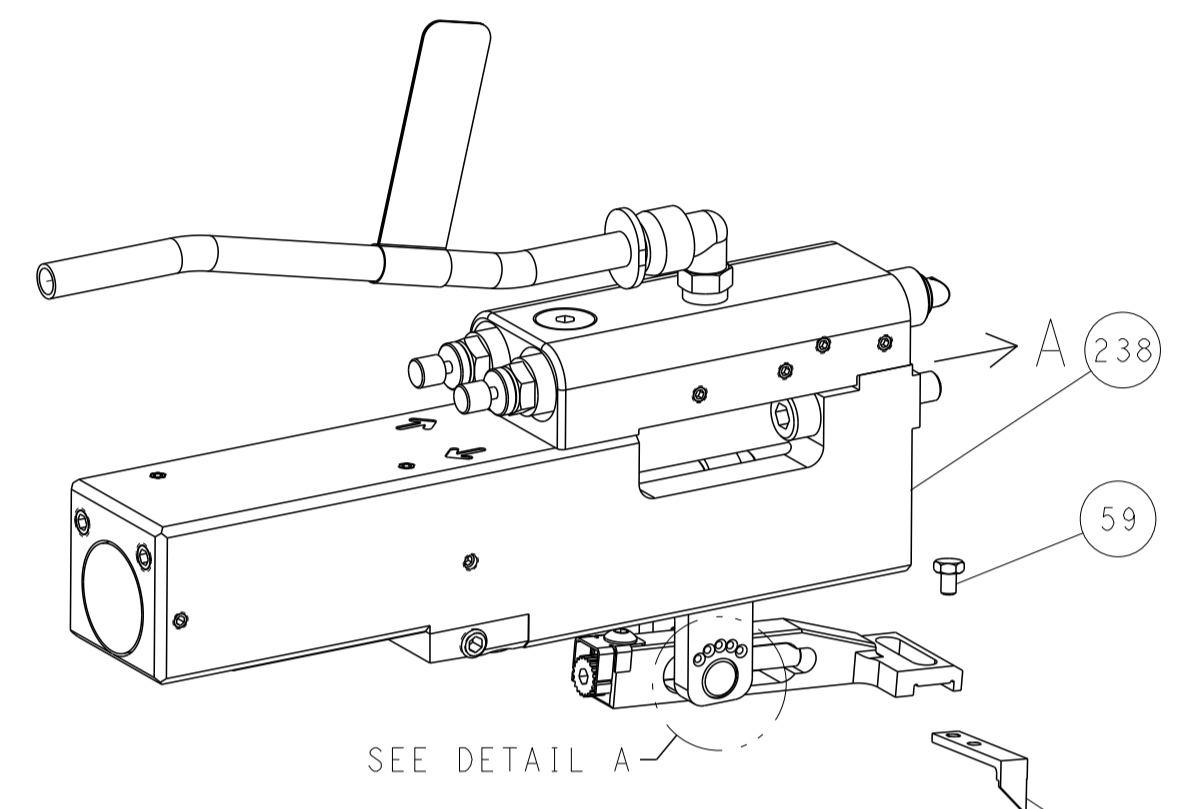
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LOC	DIST	REVISIONS					
A	66	P	LYN	DESCRIPTION	DATE	DWN	APVD
		-		SEE SHEET 1			

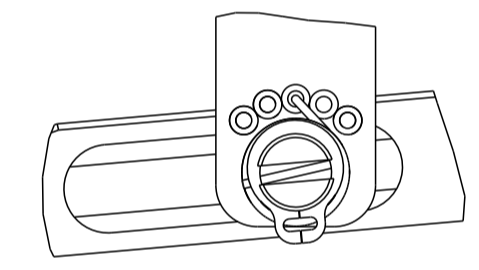
FEED TYPE MECHANICAL



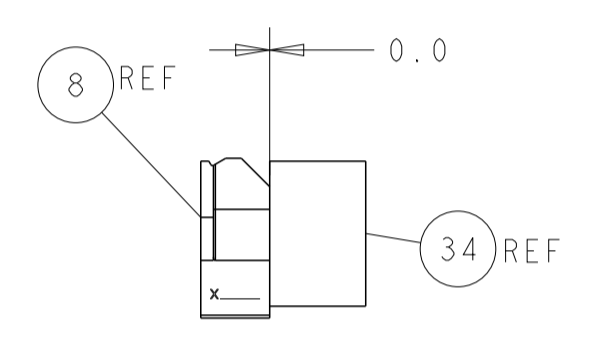
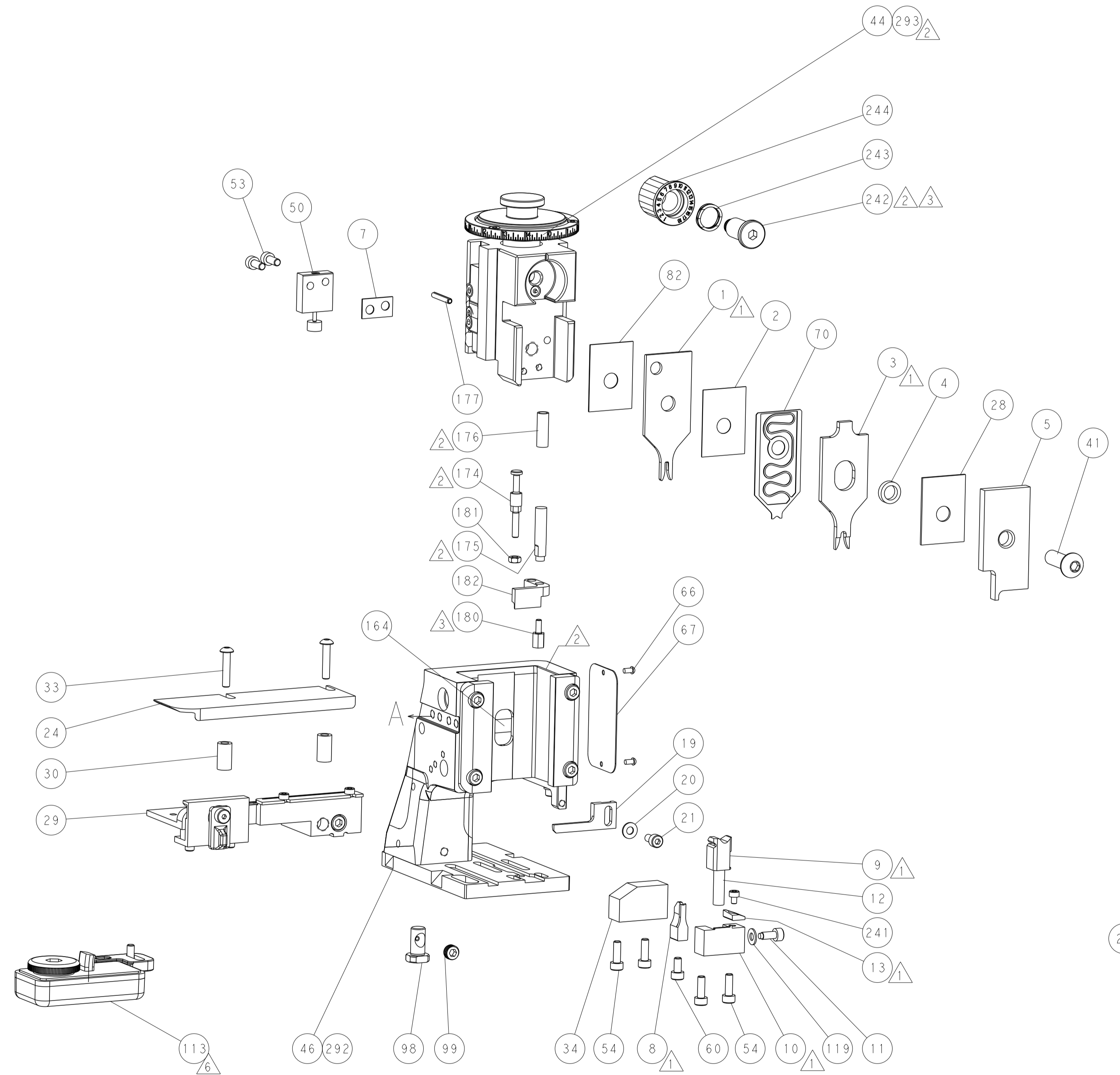
PNEUMATIC



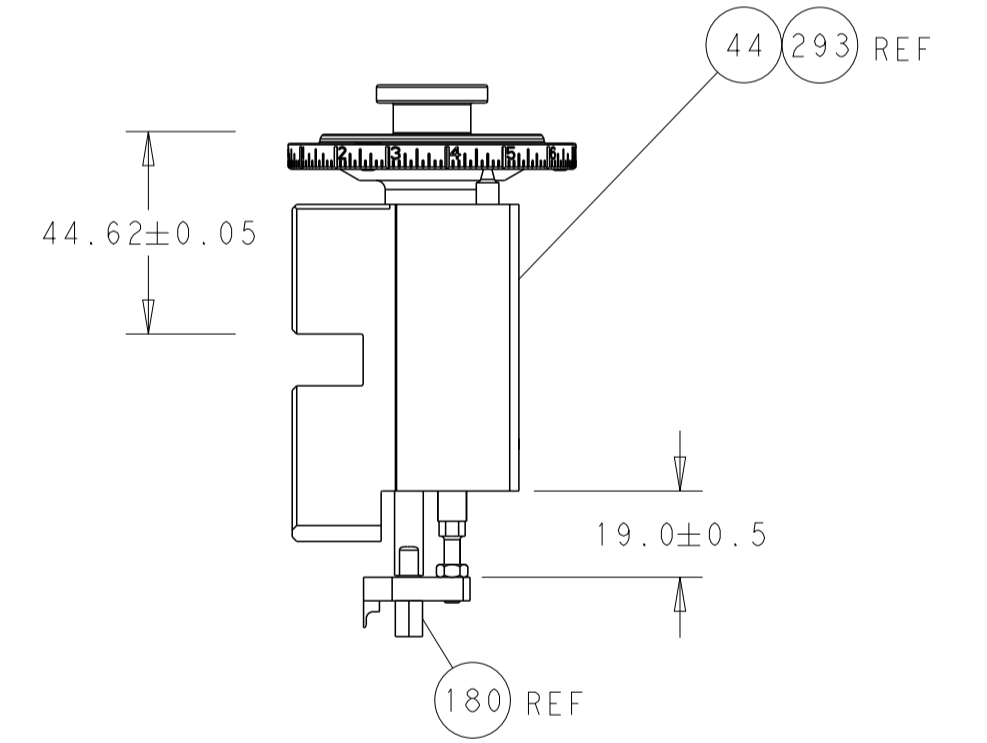
FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



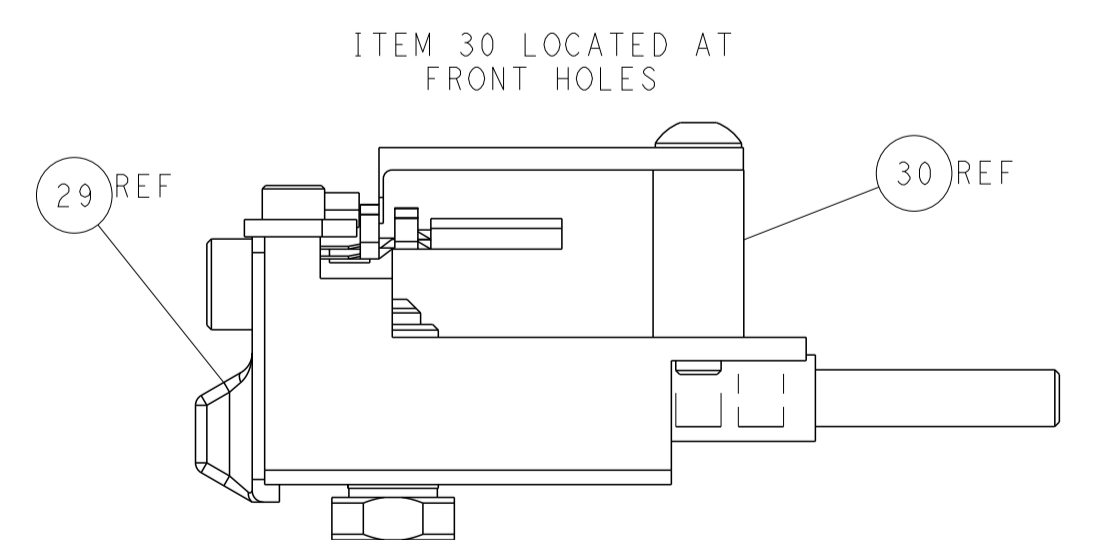
DETAIL A



TERMINAL SUPPORT LOCATION

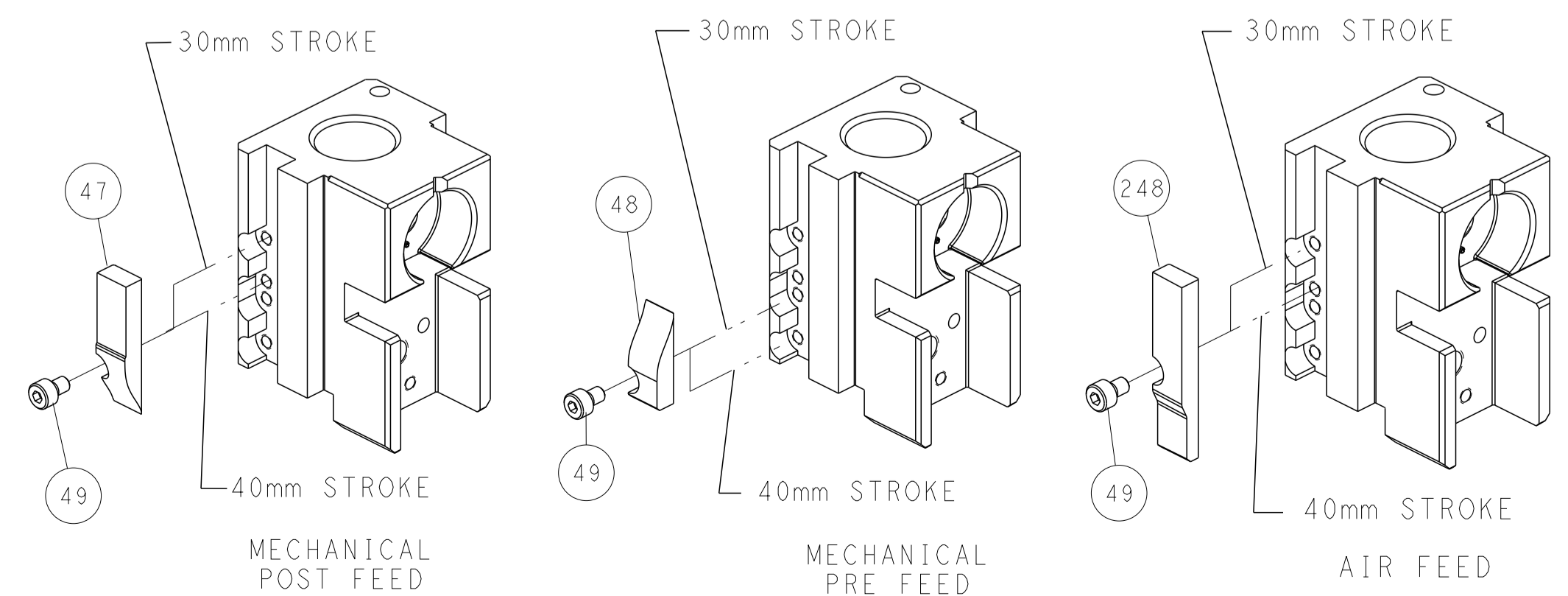


RAM AND HOLD DOWN SET-UP



FEED TRACK POSITION GUIDE BY INSULATION BARREL

CAM POSITIONS



DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ° ± FINISH		DWN X.ZHAO 16NOV2011 CHK L.ZHANG 16NOV2011 S.XI 16NOV2011 APVD S.XI 16NOV2011		NAME Ocean Side Feed Applicator SIZE CAGE CODE DRAWING NO. RESTRICTED TO A1 00779 C=2151372	
MATERIAL		WEIGHT		CUSTOMER ACCESSIBLE PRODUCTION DRAWING		SCALE 1:2 SHEET 2 OF 4 REV M	