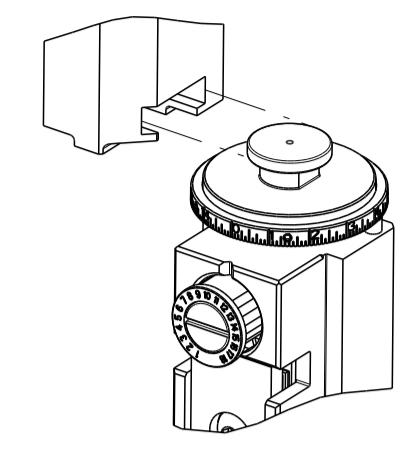


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151414-1	F	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2151414-2	F	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
5-2151414-1	F	SEAL STRIPPER CRIMPER TERMINATING UNIT	MECHANICAL
5-2151414-2	F	SEAL STRIPPER CRIMPER TERMINATING UNIT	PNEUMATIC
7-2151414-1	F	MECHANICAL AND CRIMP TOOLING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

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



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 [.205-.236 1N]	Ø		
TERMINAL APPLICATION SPECIFICATION	(A)12077411 PAGE 37 OF 54	(B)12077411 PAGE 42 OF 54	
	(C)12077411 PAGE 43 OF 54	(D)12176389	
TERMINALS APPLIED			
TE TERMINAL	DELPHI TERMINAL	TE SEAL	DELPHI SEAL
(B) 286650-1	(B) 12077411	(BC) 1949092-1	(BC) 15324985
(D) 286650-2	(D) 12176389	(A) 1949807-2	(A) 15324984
			SEAL INSULATION DIAMETER RANGE
			1.60-2.15
			2.03-2.42

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
FLRY-A 1mm ²	1.40 +/- 0.05 [.055 +/- .002]	4.7
AVSS 0.85mm ²	1.35 +/- 0.05 [.053 +/- .002]	5.1
AVSS 0.5mm ²	1.25 +/- 0.05 [.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. APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 180.
- 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	REV	LTN	DESCRIPTION	DATE	OWN	APVD
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	RK

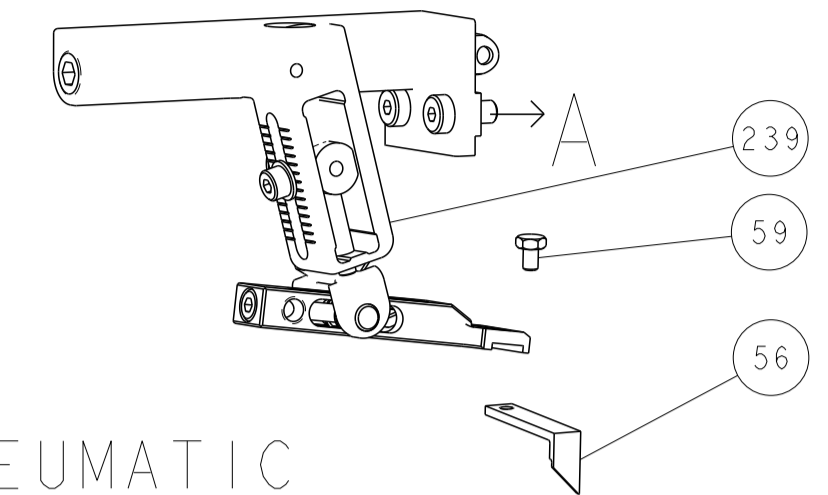
-	-	-	-	1	1	-	-	1803515-3	RAM ASSEMBLY, SF ATLANTIC	293
-	-	-	-	1	1	-	-	2-1803583-1	APPLICATOR BASIC ASSEMBLY, SF	292
-	-	1	-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248
-	-	1	1	1	1	1	1	2119082-2	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	-	1	1	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
3	-	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	-	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
3	-	-	-	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	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
5	-	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	-	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	1752356-1	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	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	1	318707-1	FLOATING SHEAR, FRONT	9
1	1	2	2	1	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	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	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)

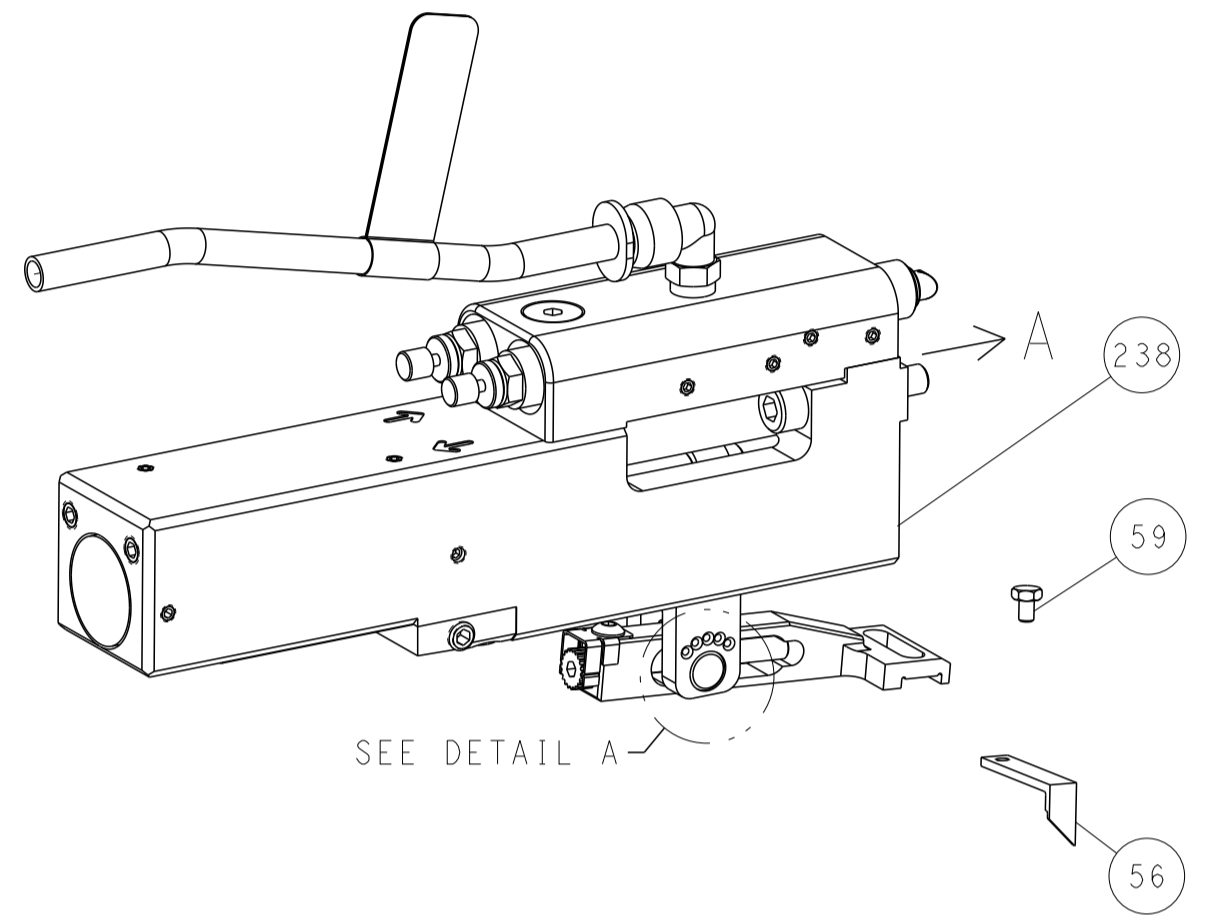
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mm		0 PLC ±		CHK: L. ZHANG 31JUL2015		NAME: Ocean Side Feed Applicator	
1 PLC ±		2 PLC ±		APVD: J. GUO 31JUL2015		SIZE: A1	
3 PLC ±		4 PLC ±		PRODUCT SPEC		CAGE CODE: 00779	
5 PLC ±		6 PLC ±		APPLICATION SPEC		DRAWING NO: 2151414	
ANGLES		FINISH		WEIGHT		RESTRICTED TO: -	
MATERIAL		FINISH		SCALE: 1:2		SHEET 1 OF 4	
-		-		CUSTOMER ACCESSIBLE PRODUCTION DRAWING		REV F	

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

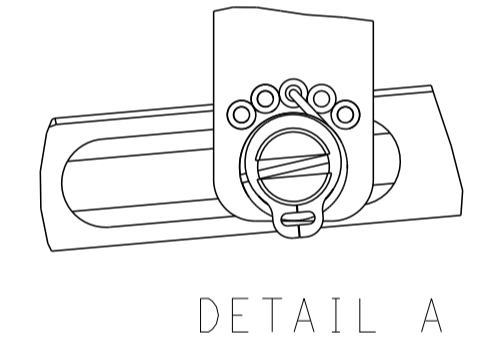
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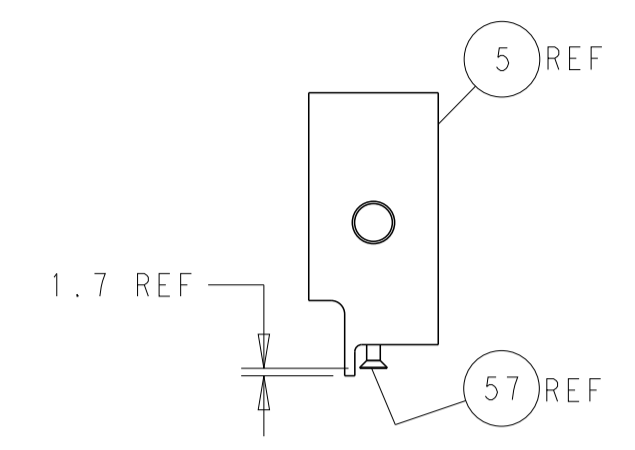
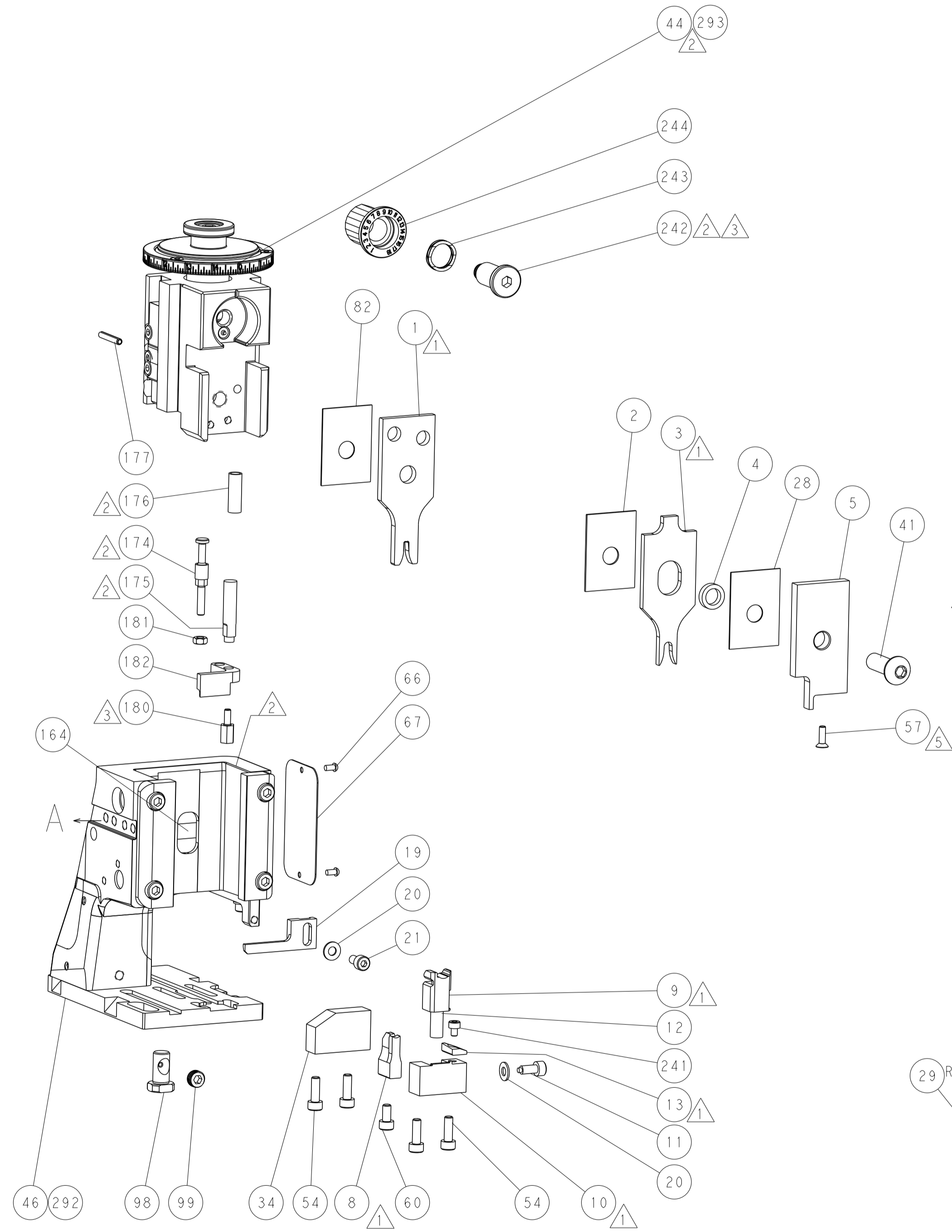
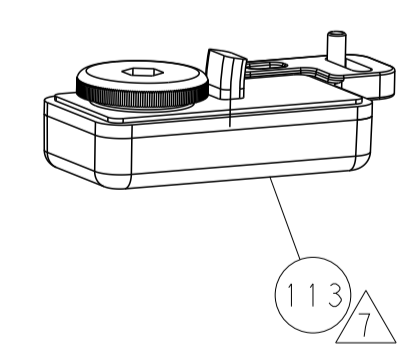
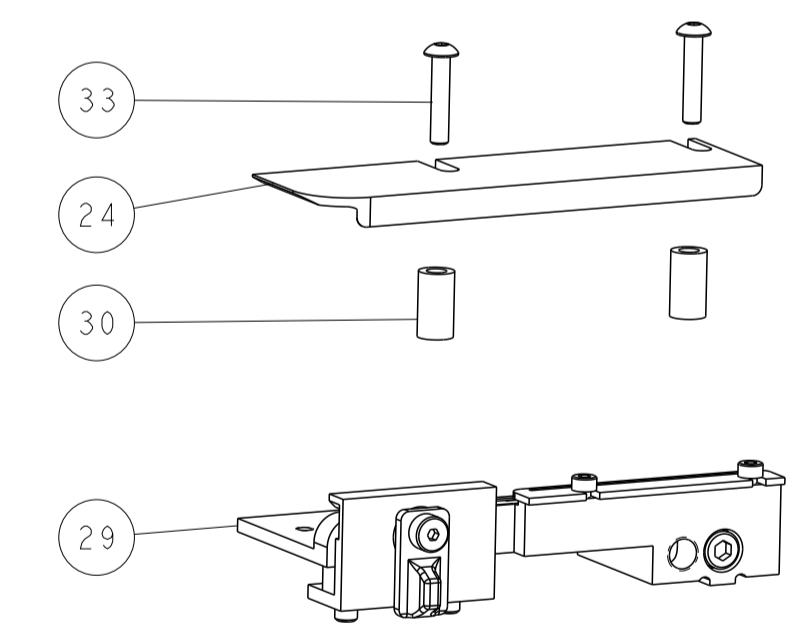
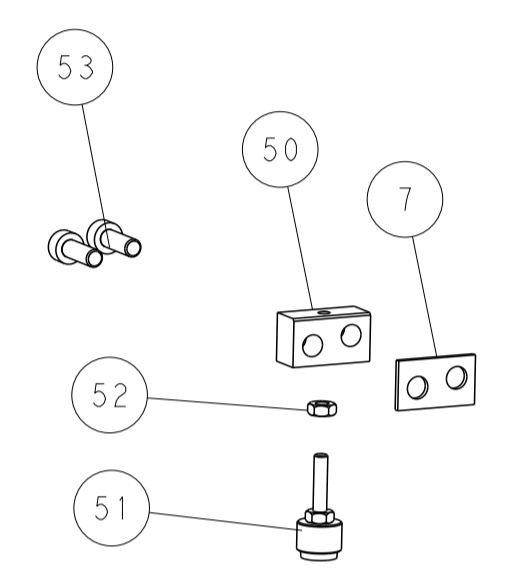
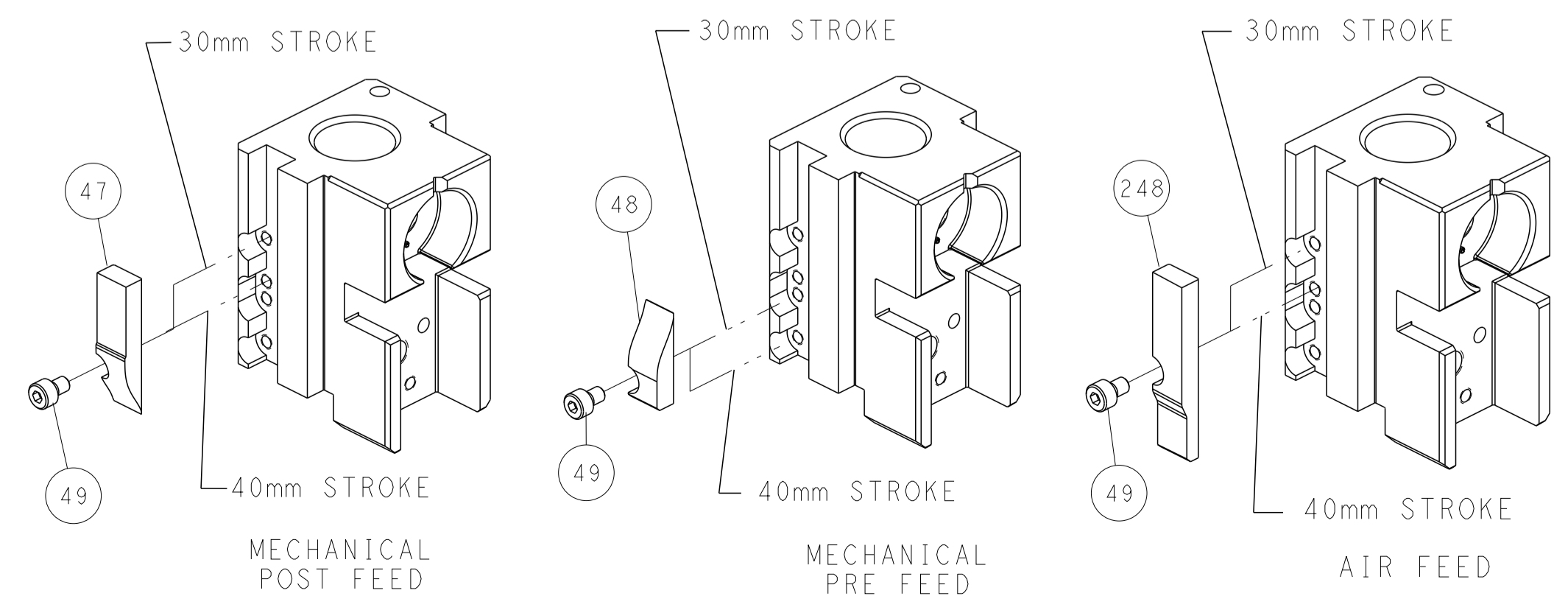
PNEUMATIC



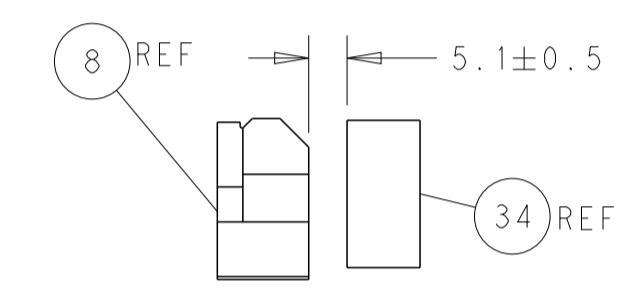
FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



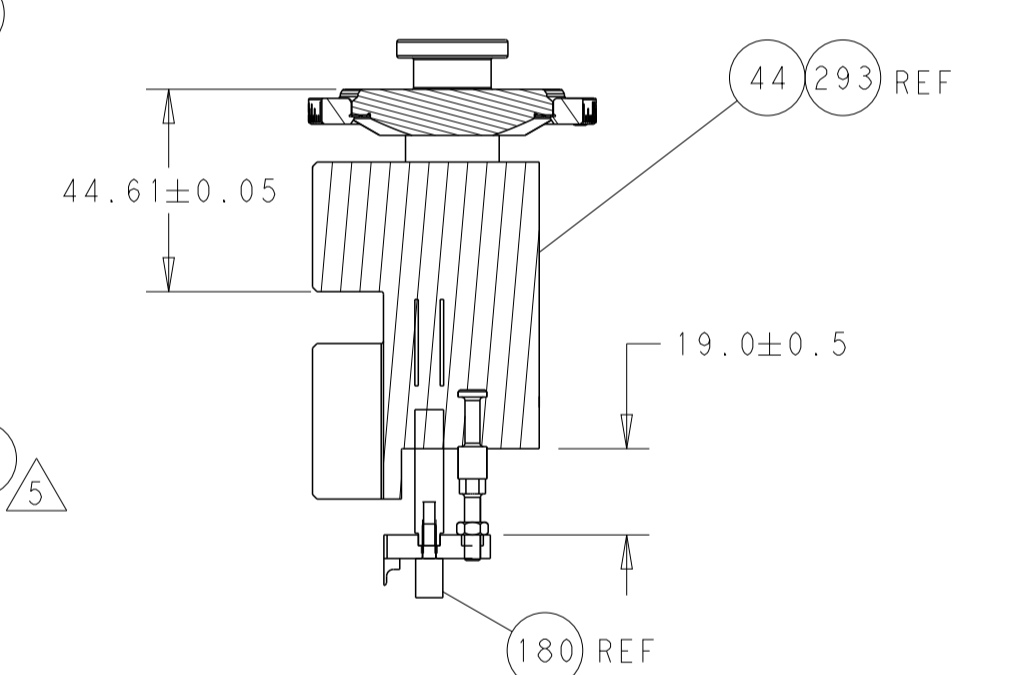
CAM POSITIONS



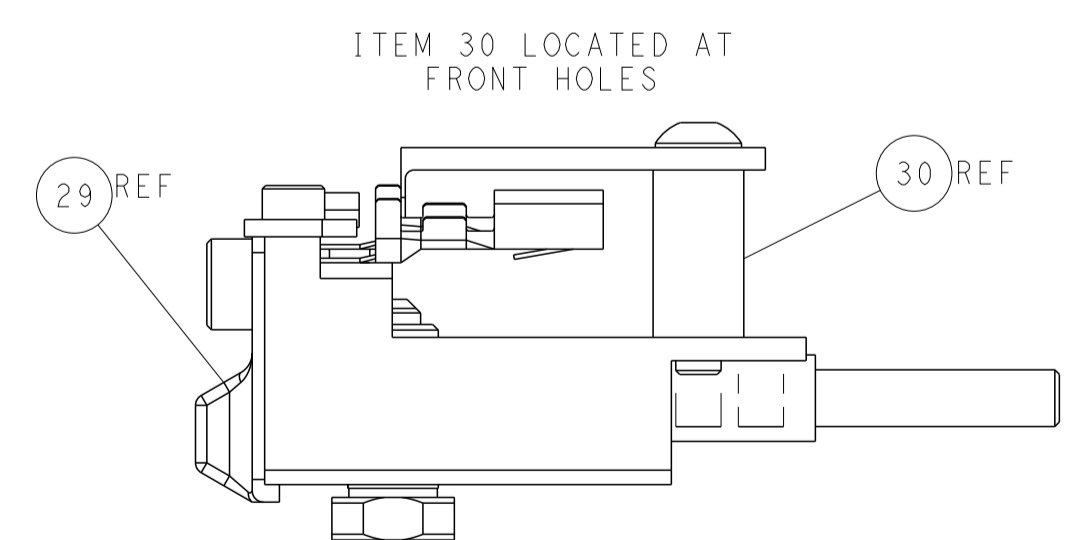
SHEAR DEPRESSOR DETAIL



TERMINAL SUPPORT LOCATION



RAM AND HOLDDOWN 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)

DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH ±		DWN R. HUANG 31 JUL 2015 CHK L. ZHANG 31 JUL 2015 APVD J. GUO 31 JUL 2015 PRODUCT SPEC APPLICATION SPEC WEIGHT Customer Accessible Production Drawing		NAME Ocean Side Feed Applicator SIZE CAGE CODE DRAWING NO. RESTRICTED TO A1 00779 ©=2151414 SCALE 1:2 SHEET 2 OF 4 REV F	
MATERIAL:				TE Connectivity Harrisburg, PA 17105-3608			

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 5.20-6.00 mm [1.205-.236 IN]	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 [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	-	-	-

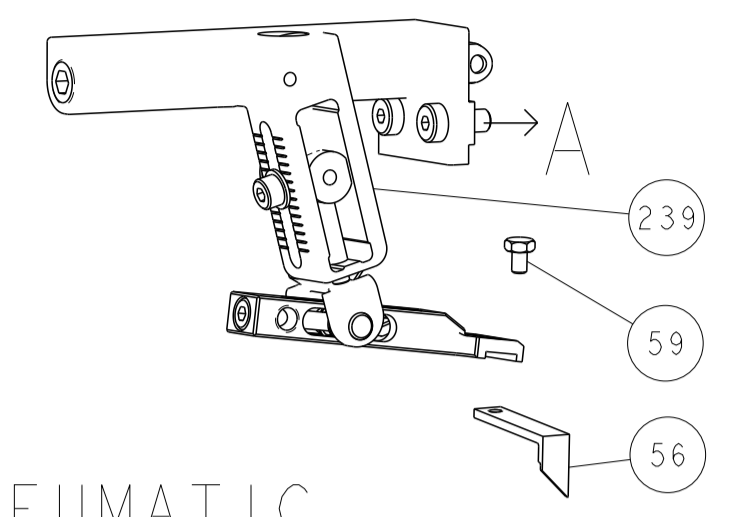
-	-	1	1	2119082-2	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
3	-	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	-	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
-	-	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	-	1	-	2844940-1	AIR FEED MODULE	238
-	-	REF	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)

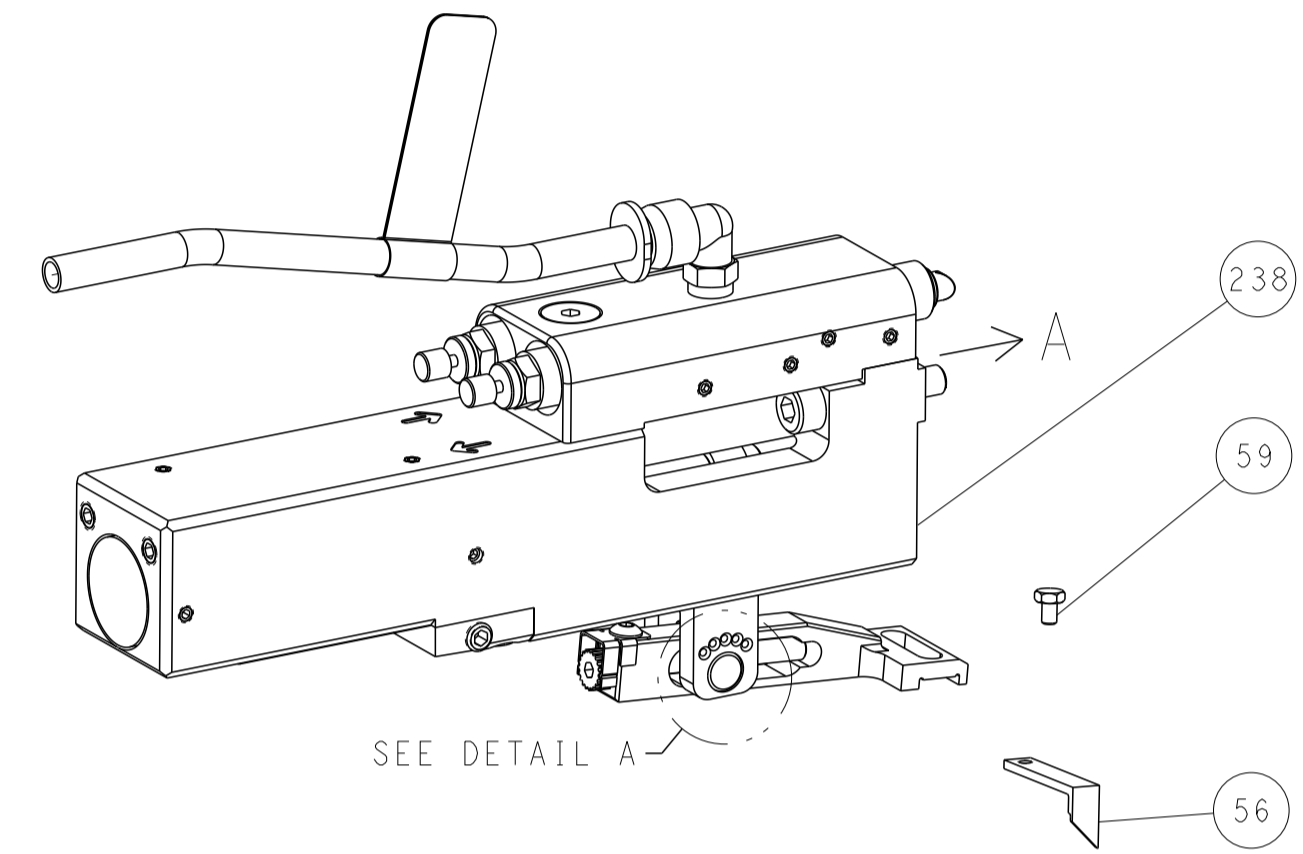
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0 PLC ±		1 PLC ±		2 PLC ±		3 PLC ±		4 PLC ±		ANGLES ±		FINISH		WEIGHT		A1 00779		C=2151414		-	
Customer Accessible Production Drawing												SCALE 1:2		SHEET 3 OF 4		REV F					

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

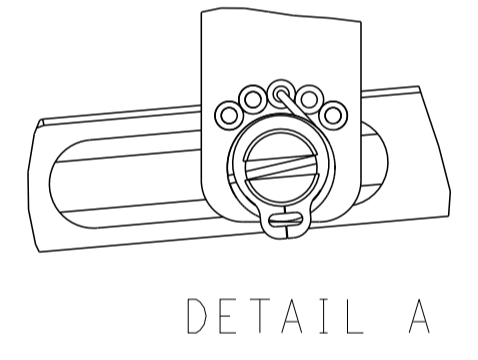
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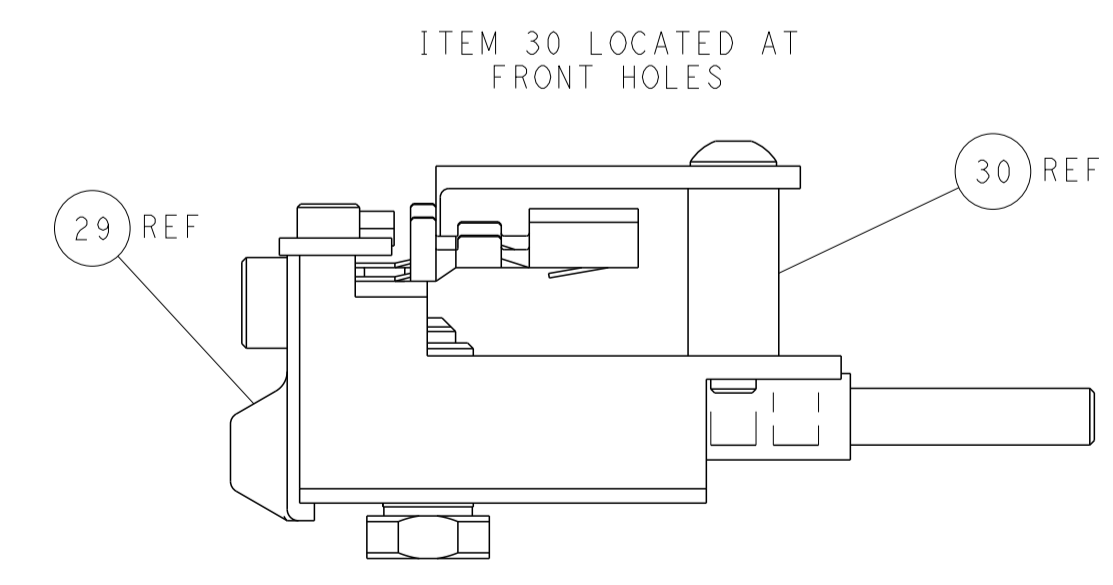
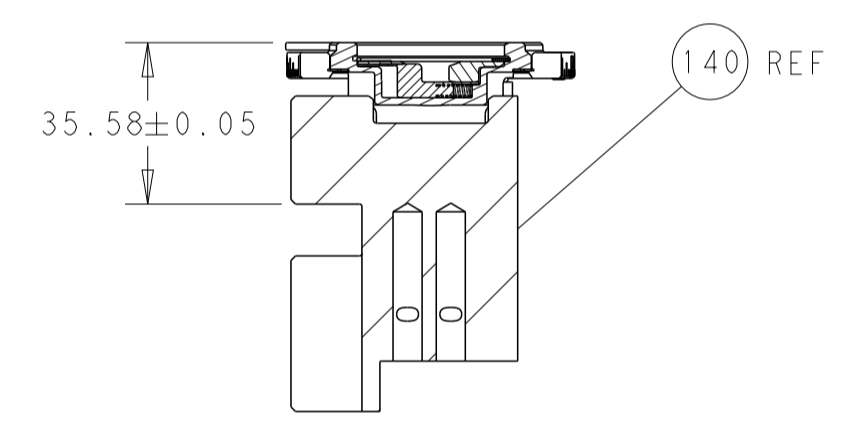
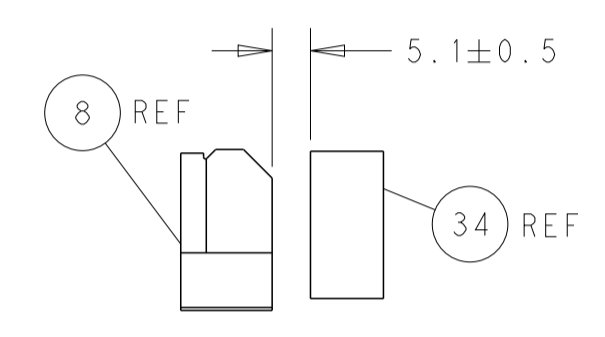
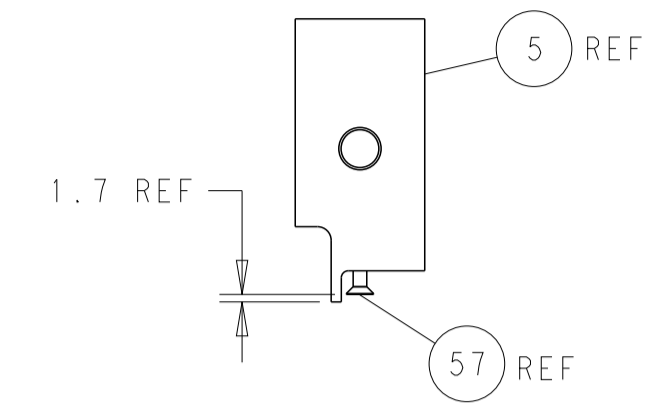
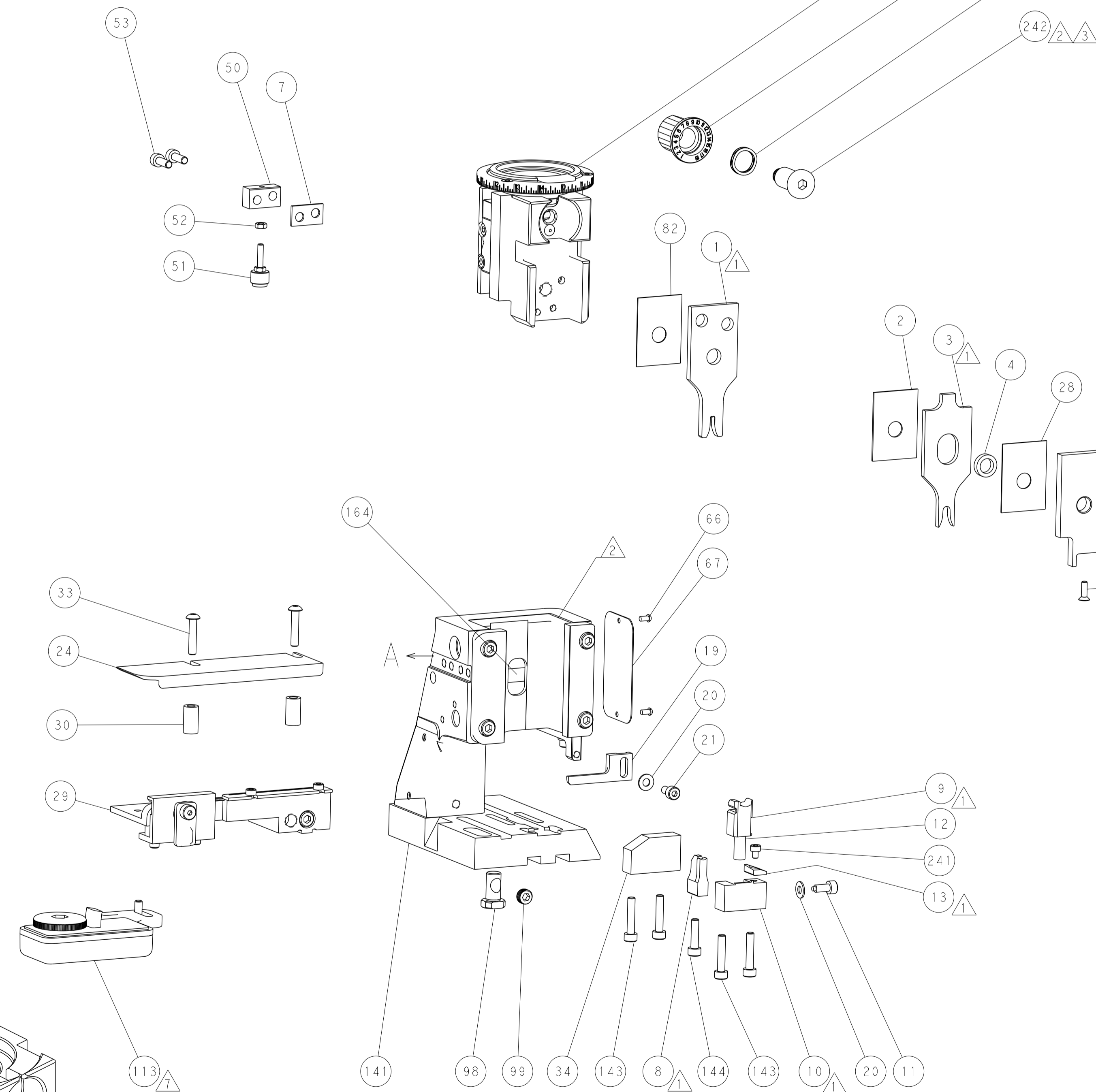
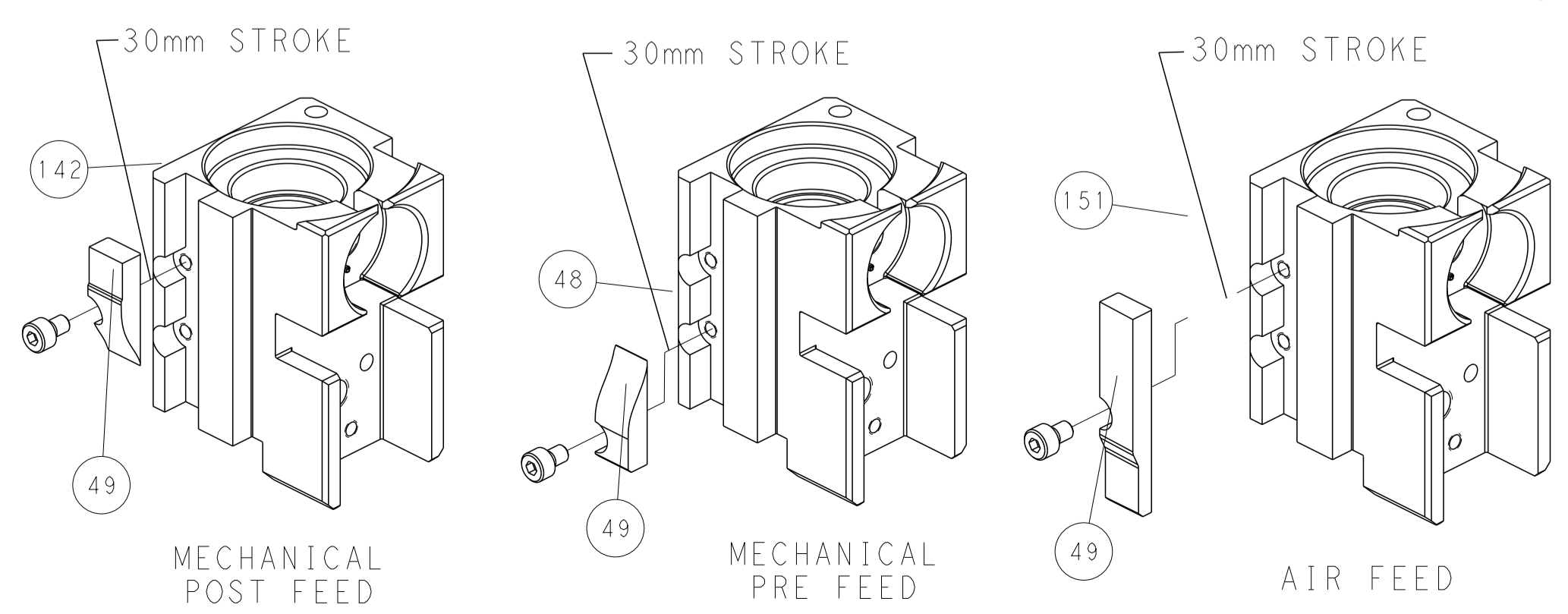
PNEUMATIC



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	±		SCALE	1:2	00779	Customer Accessible Production Drawing				
	2 PLC	±		SHEET	4	2151414	4	REV			
	3 PLC	±		OF	4			F			
	4 PLC	±									
	ANGLES	±									
	FINISH	±									