

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151921-1	E	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2151921-2	E	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
3-2151921-2	E	SEAL STRIPPER CRIMPER TERMINATING UNIT	DOUBLE ACTING PNEUMATIC WITH SENSORS $\Delta$
5-2151921-1	E	SEAL STRIPPER CRIMPER TERMINATING UNIT	MECHANICAL
5-2151921-2	E	SEAL STRIPPER CRIMPER TERMINATING UNIT	PNEUMATIC
7-2151921-7	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: TAB 2.8 x 0.8

WIRE STRIP LENGTH	INSULATION DIAMETER RANGE
3.20-3.80 mm [.126-.150 IN]	$\varnothing$ 1.10-1.60 mm [.043-.063 IN]

TERMINAL APPLICATION SPECIFICATION 114-18051

TERMINALS APPLIED  $\Delta$

TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
1-963860-1	1-963860-2	1-963860-3	2-963860-1
2-963860-2	2-963860-3		

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION

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3.20-3.80 mm [.126-.150 IN]	$\varnothing$ 1.20-1.60 mm [.047-.063 IN]

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TERMINALS APPLIED  $\Delta$

TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
5-963860-1	5-963860-2	5-963860-3	

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.50mm2	1.12 +/- 0.03 [.044 +/- .001]	6.7
0.35mm2	1.05 +/- 0.03 [.041 +/- .001]	7.4
0.25mm2	1.00 +/- 0.03 [.039 +/- .001]	7.9
0.20mm2	0.98 +/- 0.03 [.039 +/- .001]	8.2

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.50mm2	1.07 +/- 0.03 [.042 +/- .001]	7.2
0.35mm2	1.00 +/- 0.03 [.039 +/- .001]	7.9

- $\Delta$  RECOMMENDED SPARE PARTS
- $\Delta$  REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- $\Delta$  APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242. APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 180.
- $\Delta$  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.
- $\Delta$  THIS APPLICATOR IS EQUIPPED WITH THE DOUBLE ACTING FEED WITH SENSORS AND IS APPLICATION SPECIFIC. IT DOES NOT REQUIRE ITEMS 49 & 248.

**\*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					
A	66	P	LTN	DESCRIPTION	DATE	OWN	APPD
		D1		ECR-19-015254	30SEP2019	FZ	RK
		E		ECR-20-005757	21APR2020	FZ	GB
		E1		ECR-22-160824	09DEC2022	FZ	JAH
		E2		ADDED -32	28MAY2024	ROY	GEB

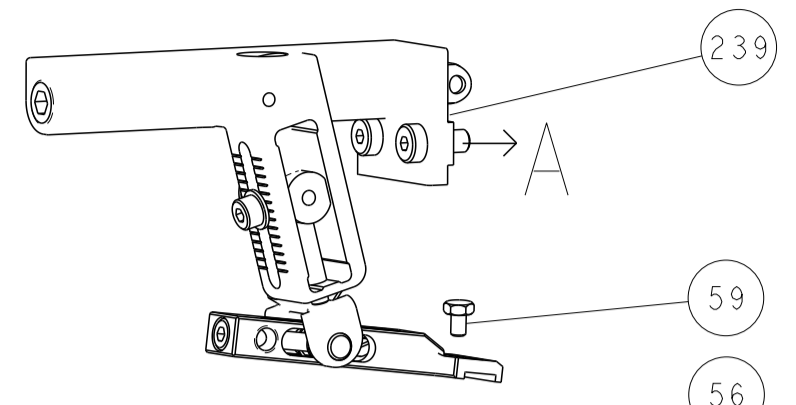
-	1	1	-	-	-	2-1803583-1	APPLICATOR BASIC ASSEMBLY, SF	292
-	-	-	1	-	-	2844950-1	AIR FEED MODULE	290
-	1	1	1	1	1	1803078-4	SPACER, PRECISION	259
-	1	-	-	1	-	2119641-1	FEED CAM, AIR FEED	248
-	1	1	1	1	1	2119082-5	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	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	-	2844940-1	AIR FEED MODULE	238
-	1	1	-	-	-	1803237-3	STRIPPER, SIDE FEED	182
-	1	1	-	-	-	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	181
-	1	1	-	-	-	2-1752354-3	STANDOFF, HOLD-DOWN	180
-	1	1	-	-	-	6-993111-6	PIN, SLOTTED SPRING 3.0 X 14.0	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	2844908-1	SCREW, LOCKING	99
-	1	1	1	1	1	2844907-1	POST, LOCKING	98
-	1	1	1	1	1	455888-4	SPACER, CRIMPER -	82
-	2	2	2	2	2	18024-6	SCR, BTN SKT HD CAP (M4 X 8.0)	79
-	1	1	1	1	1	1803096-1	EXTENSION PLATE	78
-	2	2	2	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	77
-	1	1	1	1	1	1633782-2	FENCE	76
-	1	1	1	1	1	1803607-3	DOCUMENTATION PACKAGE	71
-	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	1803382-2	HOLD DOWN, SPRING LOADED	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	1803583-9	APPLICATOR BASIC ASSEMBLY, SF	46
-	1	1	1	1	1	1803515-2	RAM ASSEMBLY, SF ATLANTIC	44
-	1	1	1	1	1	1803602-2	SCR, BHSC, RoHS (M8 X 40)	41
-	1	1	1	1	1	1-1752356-6	SUPPORT, TERMINAL	34
-	2	2	2	2	2	2079383-8	SCR, BHSC, RoHS (M4 X 16)	33
-	2	2	2	2	2	1-2844962-4	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	1	1	1	2844992-2	ASSEMBLY, STRIP GUIDE -	29
-	1	1	1	1	1	1-455888-5	SPACER, CRIMPER -	28
-	1	1	1	1	1	1320928-4	STRIP GUIDE -	24
-	-	-	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
-	1	1	2	2	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	1-356885-4	STOP, SHEAR	11
-	1	1	1	1	1	2119805-5	SHEAR HOLDER, FRONT -	10
-	1	1	1	1	1	1-454276-2	FLOATING SHEAR, FRONT	9
-	1	1	1	1	1	1633216-2	ANVIL, COMBINATION	8
-	-	-	-	-	-	-	-	7
-	-	-	-	-	-	-	-	6
-	1	1	1	1	1	2119757-1	DEPRESSOR, SHEAR	5
-	1	1	1	1	1	238011-9	BLOCK, CRIMPER SPACER	4
-	1	1	1	1	1	1-2119784-8	CRIMPER, INSULATION O PREMIUM	3
-	1	1	1	1	1	455888-5	SPACER, CRIMPER -	2
-	1	1	1	1	1	1-456403-3	CRIMPER, WIRE PREMIUM	1

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		OWN	CHK	DATE	NAME
mm	0 PLC ±	1 PLC ±	2 PLC ±	H. HUANG	L. ZHANG	09APR2013	TE Connectivity
	3 PLC ±	4 PLC ±	ANGLES ±	J. GUO		09APR2013	Harrisburg, PA 17105-3608
MATERIAL	FINISH	WEIGHT	SCALE	Customer Accessible Production Drawing		SHEET 1 OF 4	REV E2

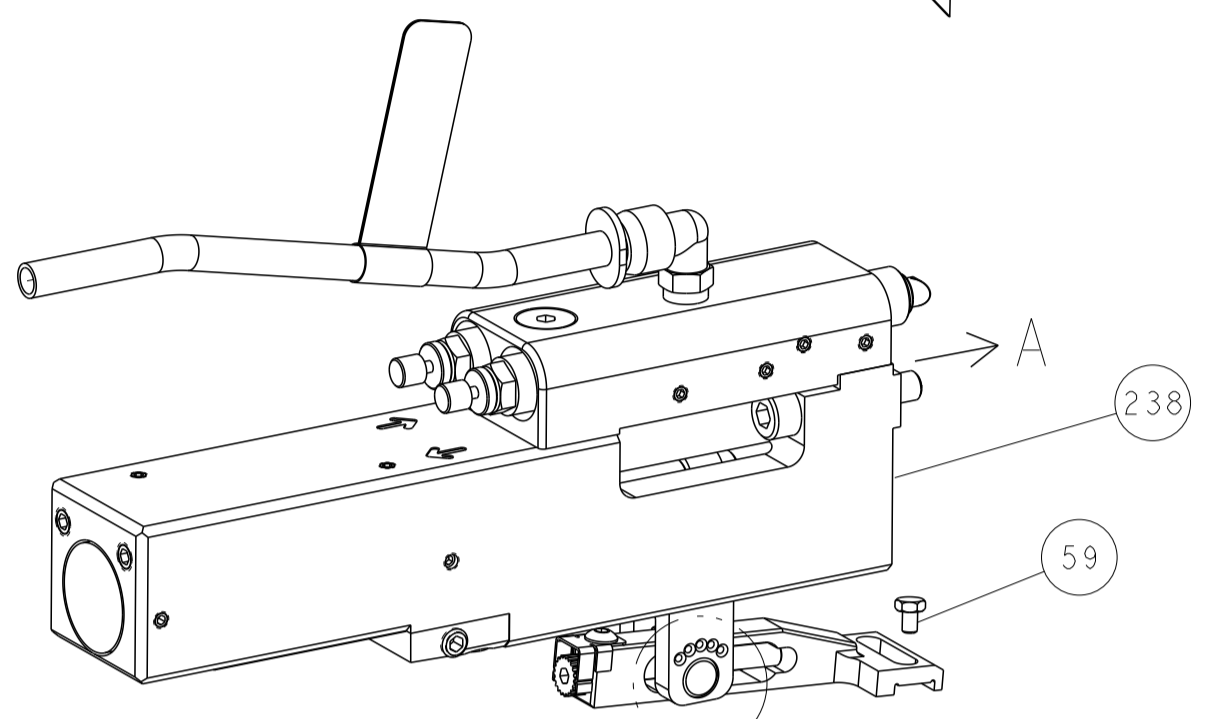
Customer Accessible Production Drawing SCALE 1:2 SHEET 1 OF 4 REV E2

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

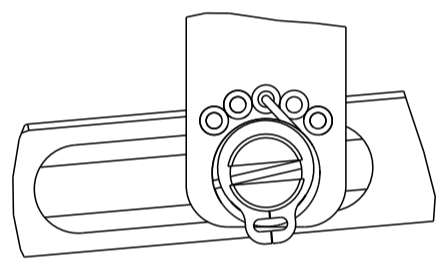
# FEED TYPE MECHANICAL



# PNEUMATIC

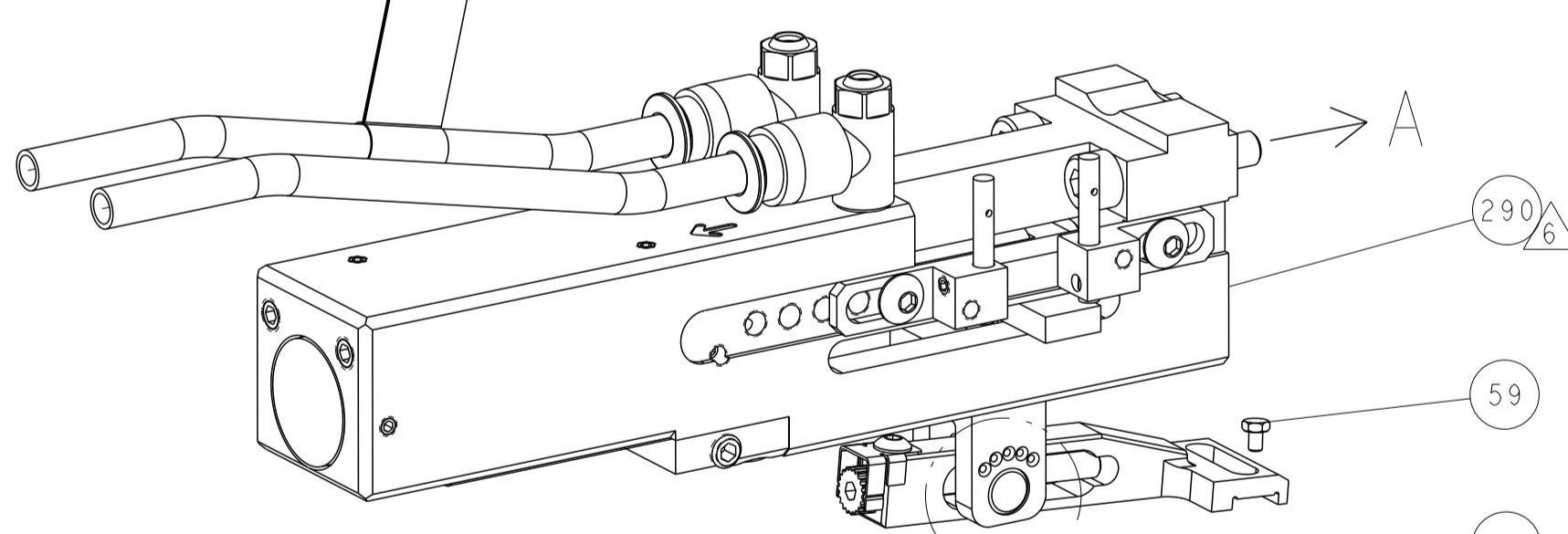


SEE DETAIL A  
 FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



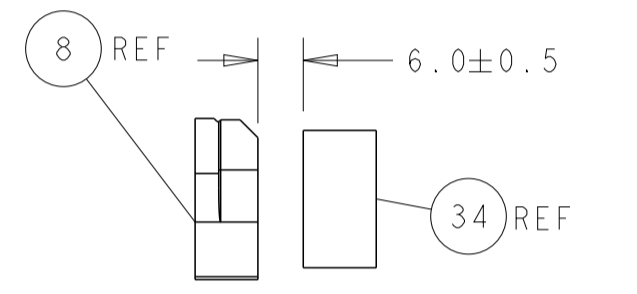
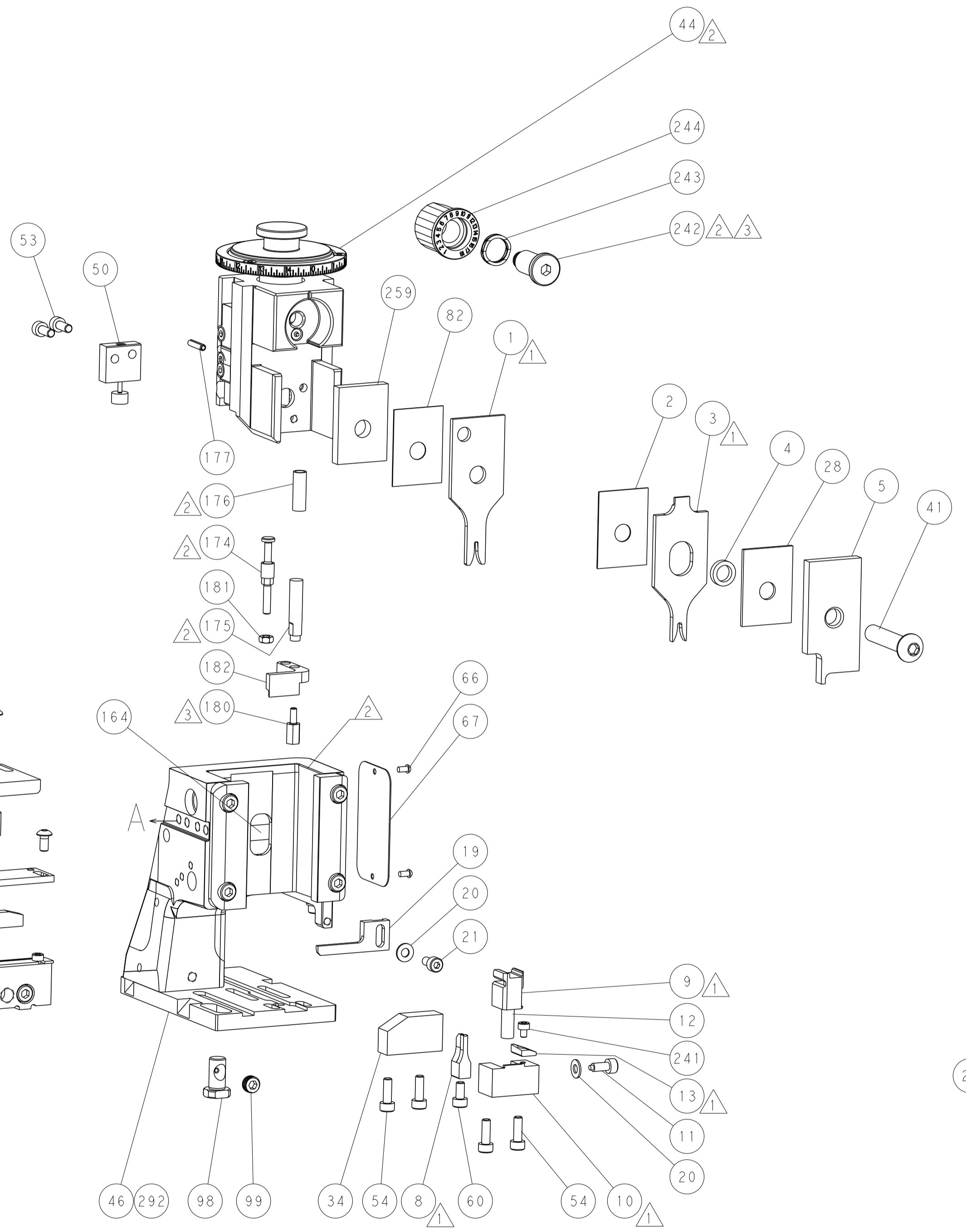
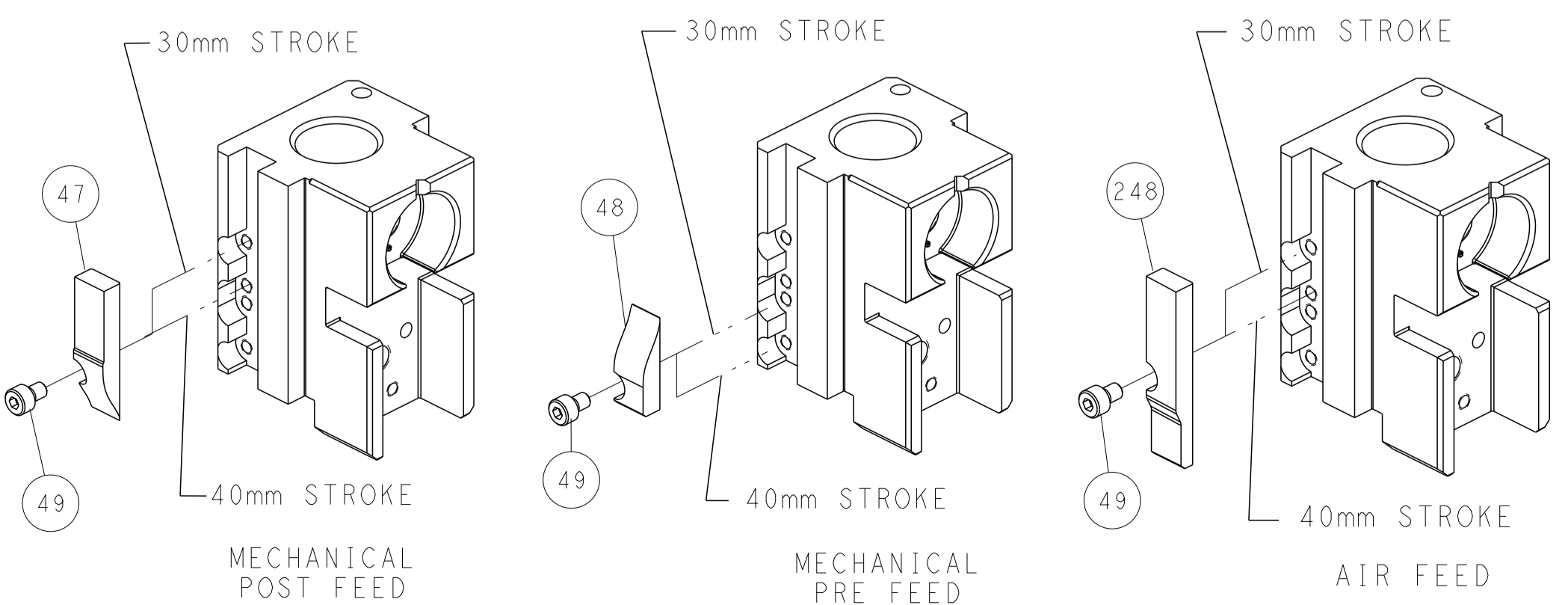
DETAIL A

# DOUBLE ACTING PNEUMATIC WITH SENSORS

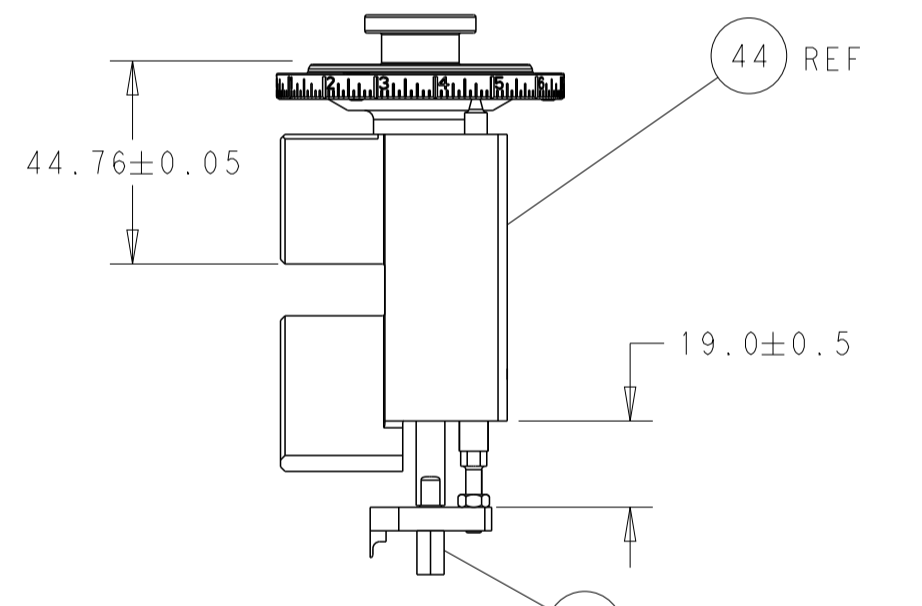


SEE DETAIL A

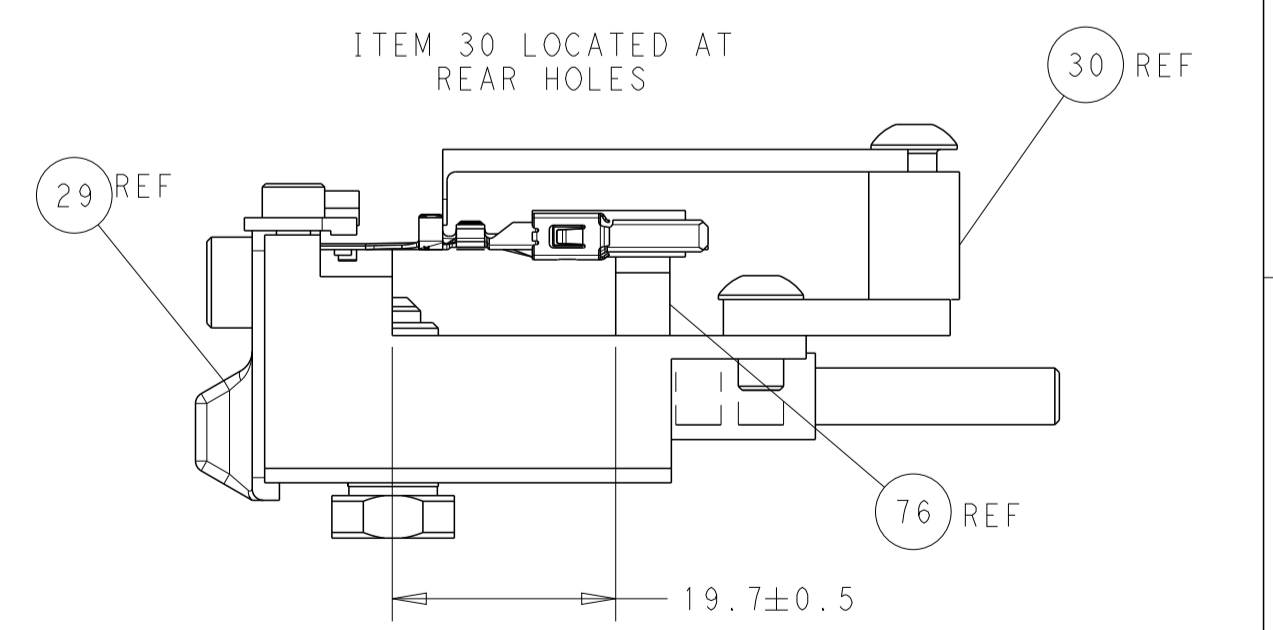
# CAM POSITIONS



TERMINAL SUPPORT LOCATION



RAM AND HOLD-DOWN SET-UP



FEED TRACK POSITION GUIDE BY INSULATION BARREL

DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± MATERIAL: - FINISH: -		DWN: R. HUANG 09APR2013 CHK: L. ZHANG 09APR2013 APVD: H. GUO 09APR2013 NAME: Ocean Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2151921 SCALE: 1:2 SHEET: 2 of 4 REV: E2		TE Connectivity Harrisburg, PA 17105-3608 RESTRICTED TO: -	
THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION. IT IS THE PROPERTY OF TYCO ELECTRONICS CORPORATION AND IS NOT TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, INCLUDING PHOTOCOPYING, RECORDING, OR BY ANY INFORMATION STORAGE AND RETRIEVAL SYSTEM. PERMISSION TO REPRODUCE THIS DRAWING IS GRANTED BY TYCO ELECTRONICS CORPORATION TO THE USER OF THIS DRAWING FOR THE USER'S OWN USE ONLY.		CUSTOMER ACCESSIBLE PRODUCTION DRAWING		SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION	