

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)

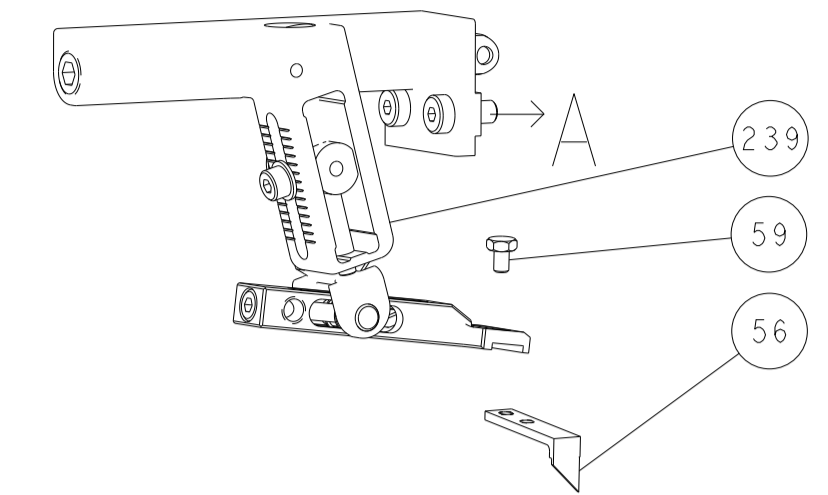
REVISIONS				
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F		ECR-18-006541	27APR2018	MEH JDG
G		ECR-18-010968	11JUL2018	AW GB
H		ECR-19-005517	05APR2019	LG TE
H1		ECR-22-149253	12AUG2022	FZ YY

	-	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

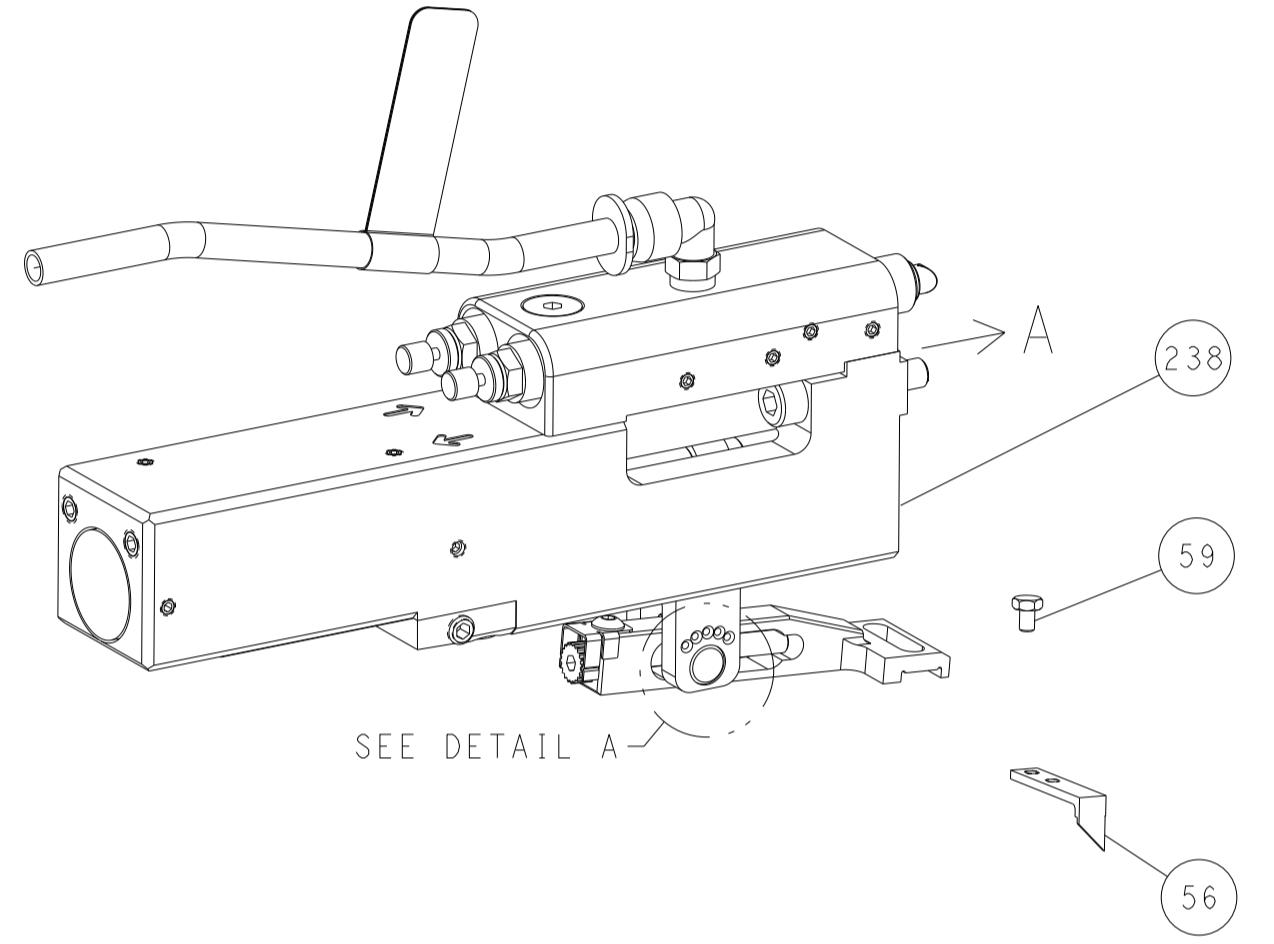
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DIMENSIONS:		CHK G. BAILEY	23SEP2011		
TOLERANCES UNLESS OTHERWISE SPECIFIED:		APVD S. XI	23SEP2011		
mm		PRODUCT SPEC			
 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH ±		APPLICATION SPEC		NAME Ocean Side Feed Applicator	
MATERIAL		SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
		A1	-	©=2151045	
		CUSTOMER ACCESSIBLE PRODUCTION DRAWING		SCALE	1:2
		SHEET		1	OF 4
		REV		H1	

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

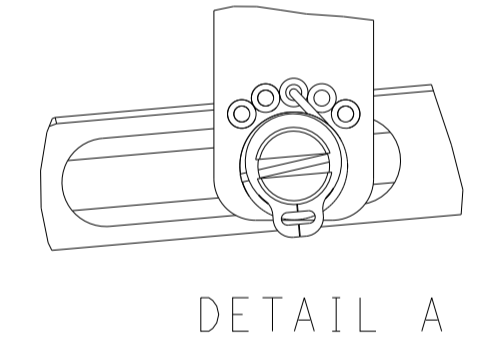
# FEED TYPE MECHANICAL



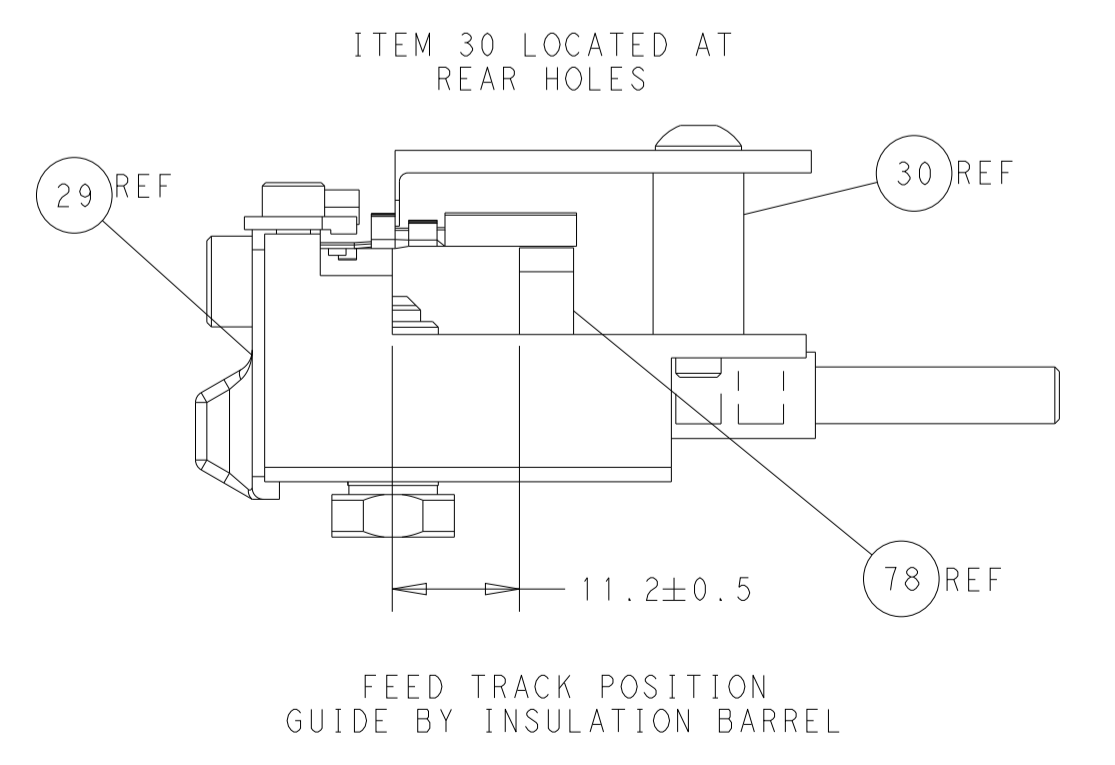
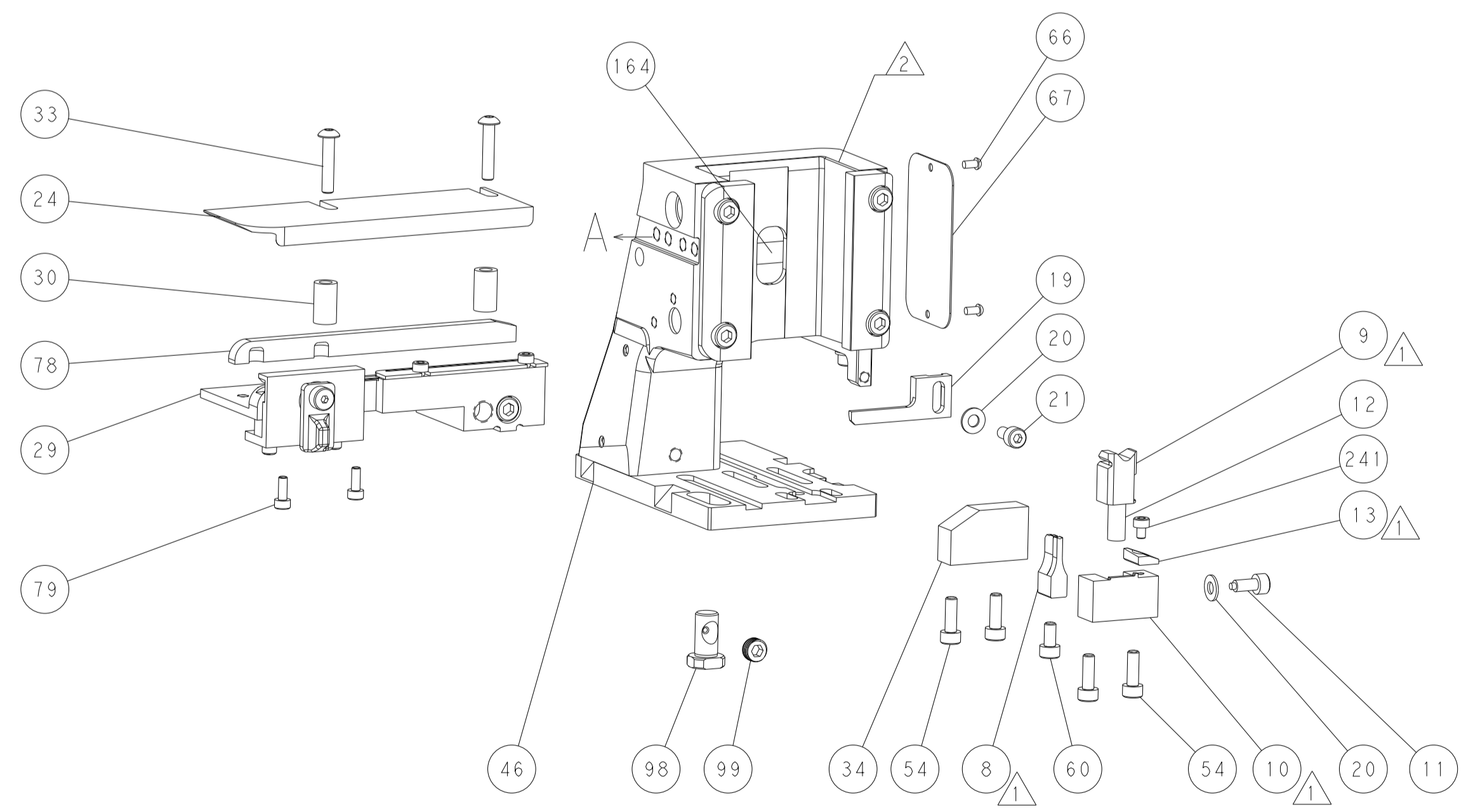
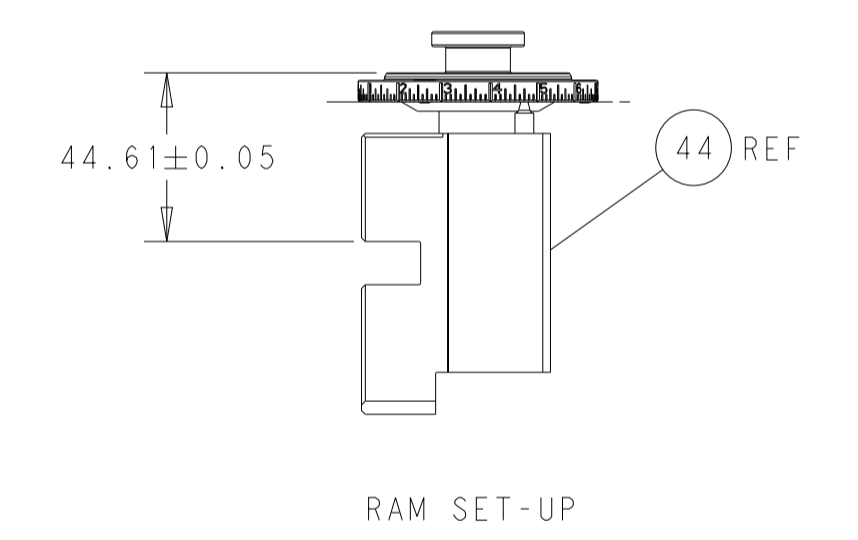
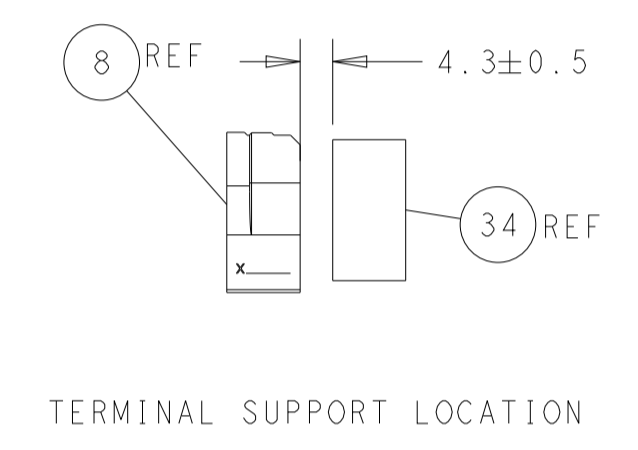
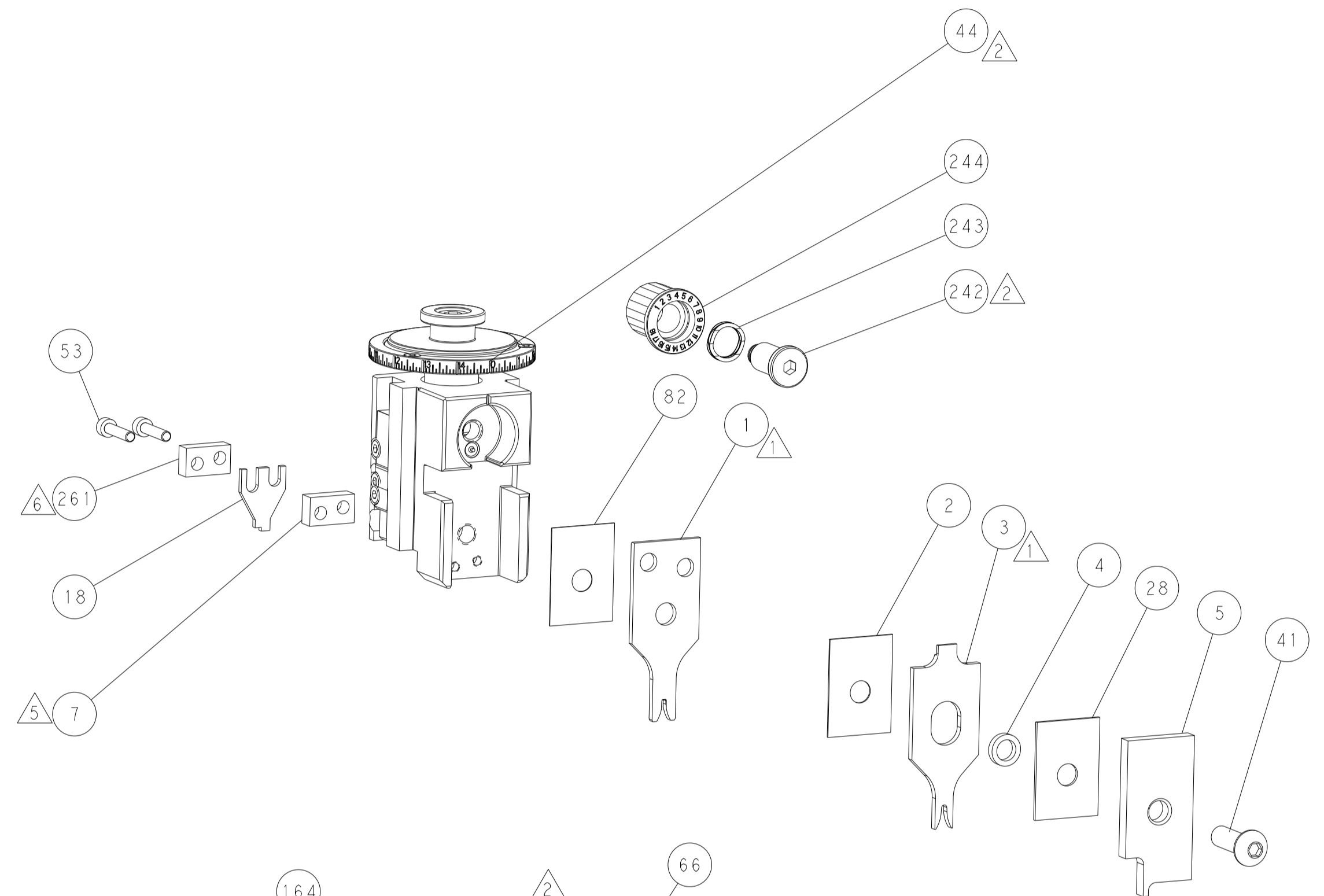
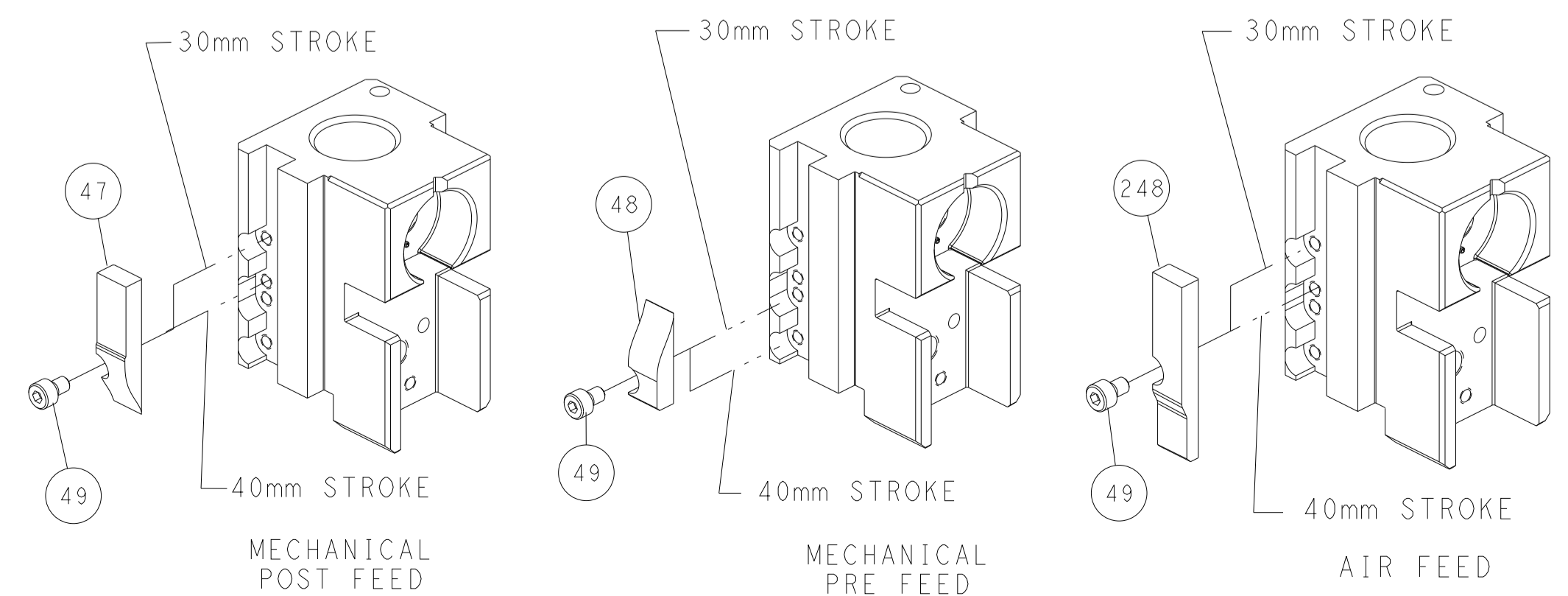
# PNEUMATIC



# FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



# CAM POSITIONS



**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	NAME: Ocean Side Feed Applicator
0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH ±		PRODUCT SPEC	SIZE: A1
MATERIAL:		APPLICATION SPEC	CAGE CODE: -
		WEIGHT:	DRAWING NO: C=2151045
		CUSTOMER ACCESSIBLE PRODUCTION DRAWING	RESTRICTED TO: -
		SCALE: 1:2	SHEET 2 OF 4
			REV: H1

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



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 [1.26-.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 [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)

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

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.

APVD: G. BAILEY, S. XI, 23SEP2011

NAME: Ocean Side Feed Applicator

SIZE: A1, CAGE CODE: -

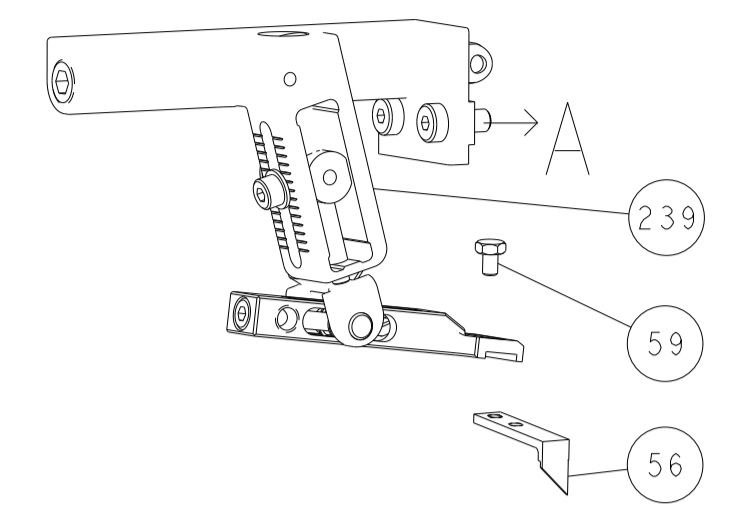
SCALE: 1:2, SHEET: 3 OF 4

CUSTOMER ACCESSIBLE PRODUCTION DRAWING

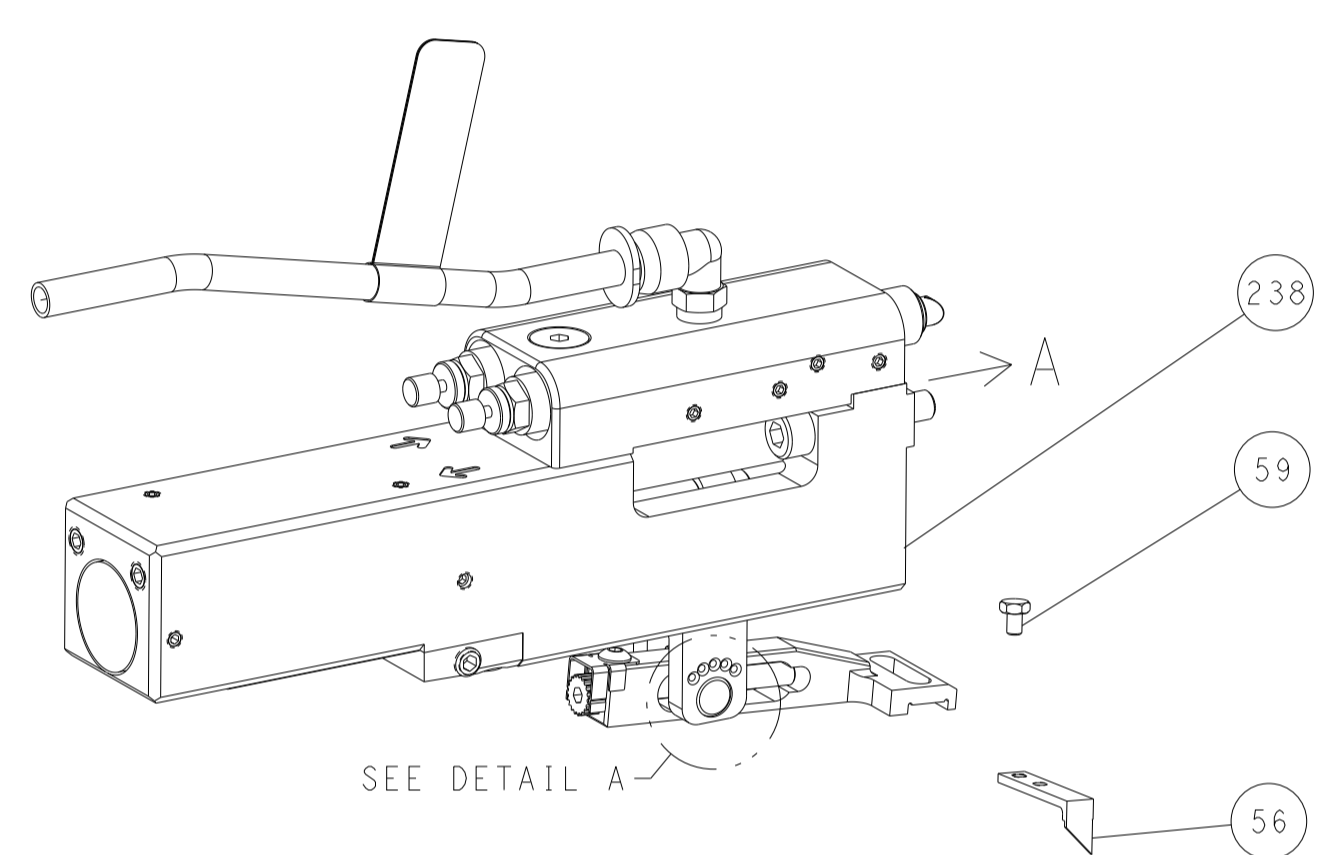
RESTRICTED TO: REV: H1

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

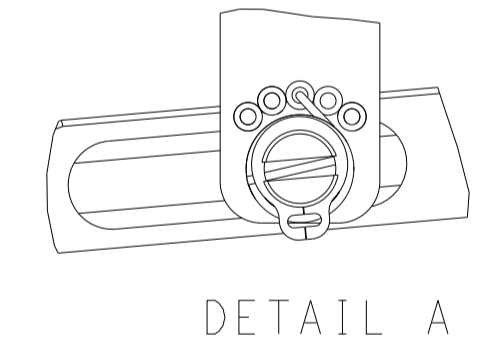
# FEED TYPE MECHANICAL



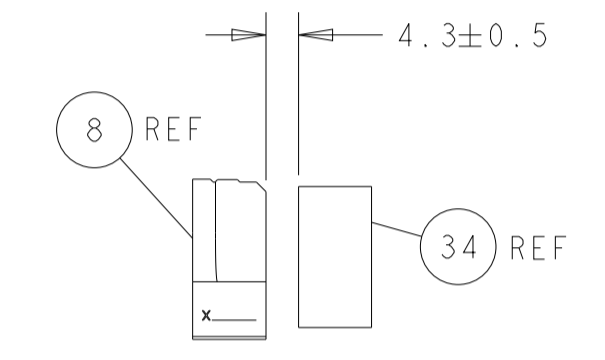
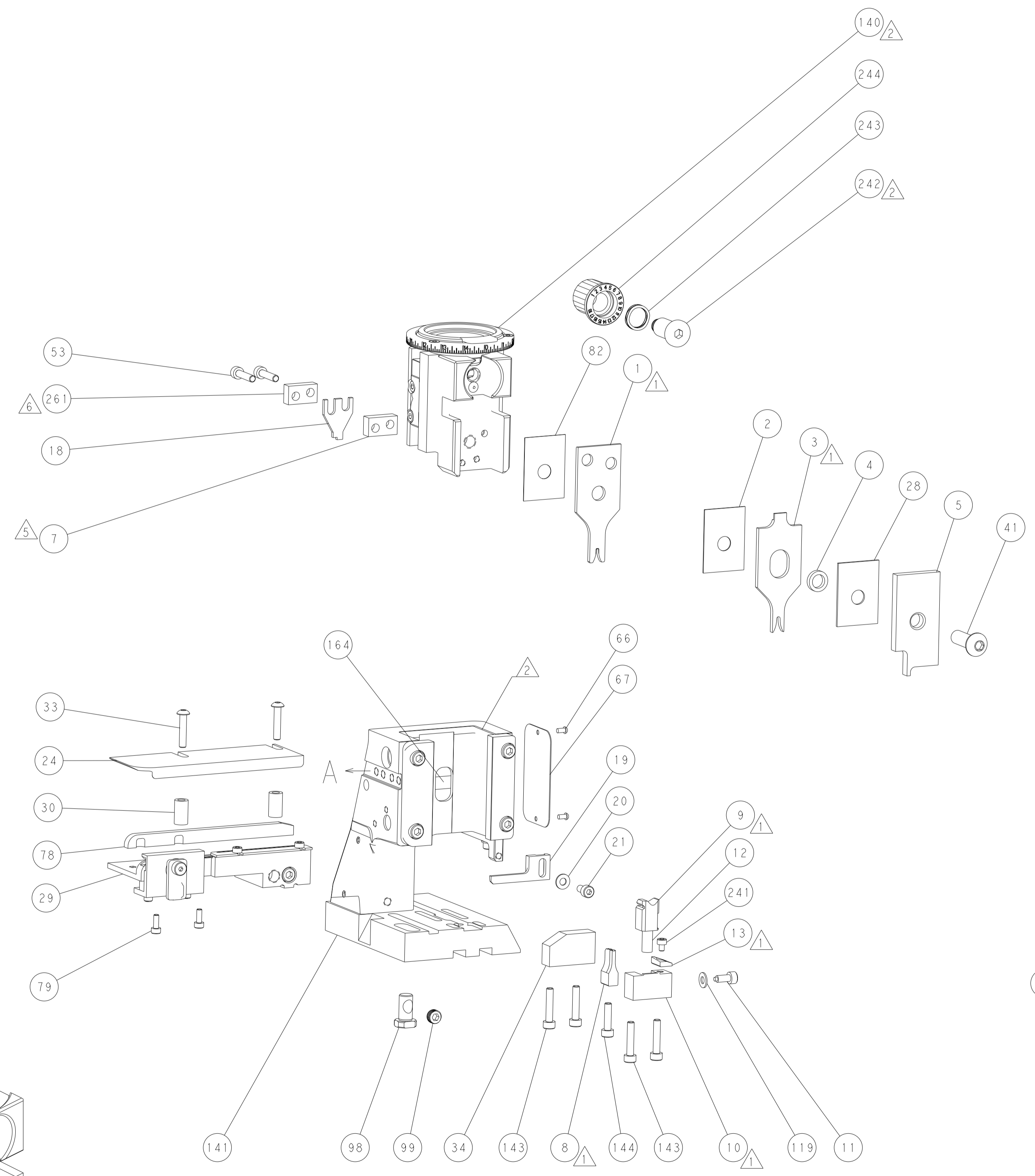
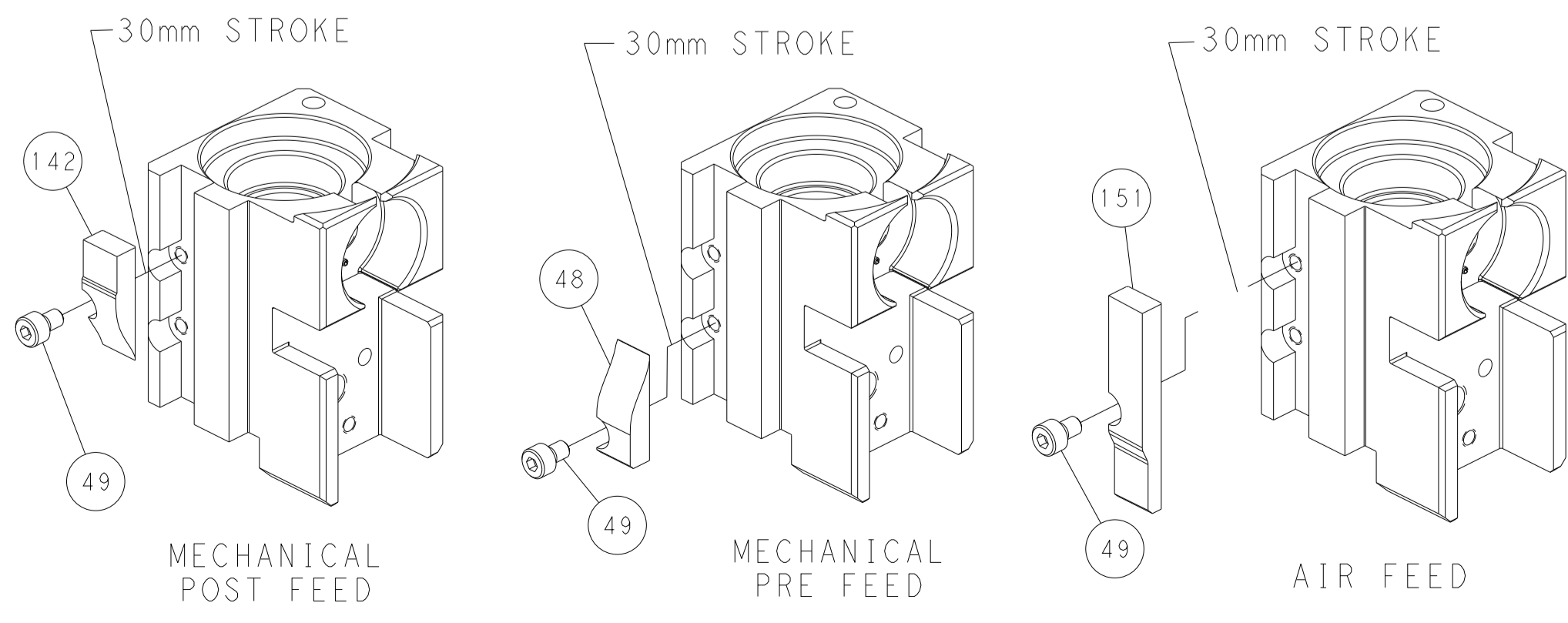
# PNEUMATIC



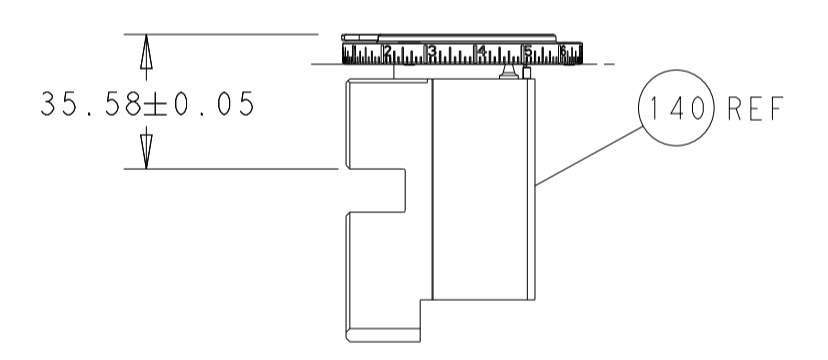
# FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



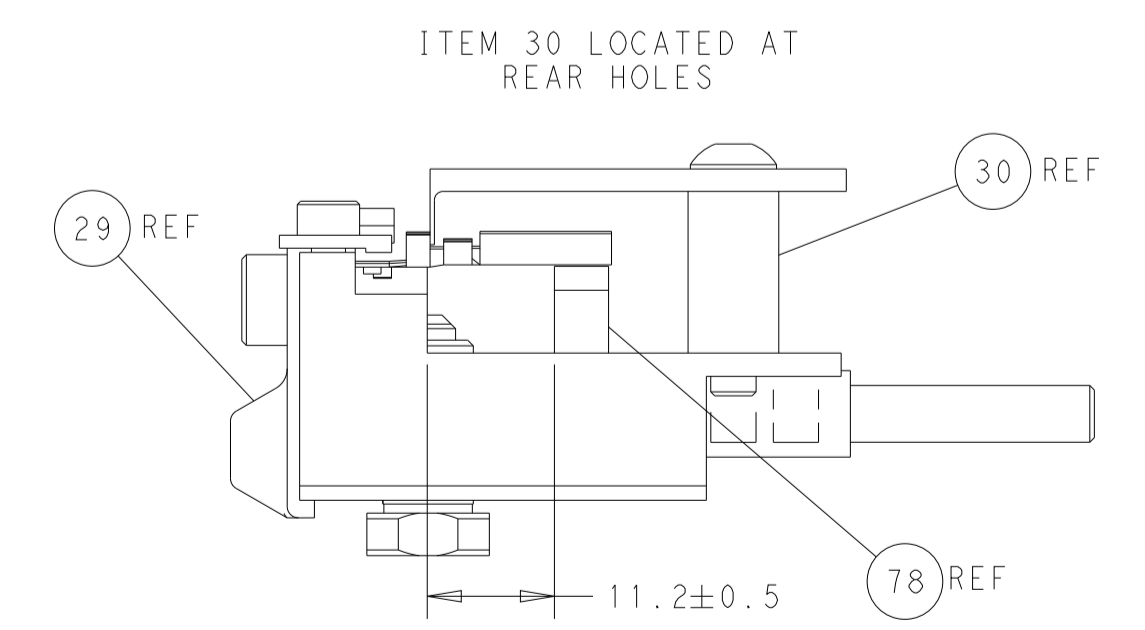
# CAM POSITIONS



TERMINAL SUPPORT LOCATION



RAM SET-UP



FEED TRACK POSITION  
GUIDE BY INSULATION BARREL

**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	
TOLERANCES UNLESS OTHERWISE SPECIFIED:		APVD: -	NAME: Ocean Side Feed Applicator
0 PLC	±	PRODUCT SPEC	APPLICATION SPEC
1 PLC	±	APPLICATION SPEC	SIZE: A1
2 PLC	±	APPLICATION SPEC	CAGE CODE: -
3 PLC	±	APPLICATION SPEC	DRAWING NO: C=2151045
4 PLC	±	APPLICATION SPEC	RESTRICTED TO: -
ANGLES	±	WEIGHT: -	SCALE: 1:2
FINISH	-	CUSTOMER ACCESSIBLE PRODUCTION DRAWING	SHEET 4 OF 4
MATERIAL: -	-	REV: H1	