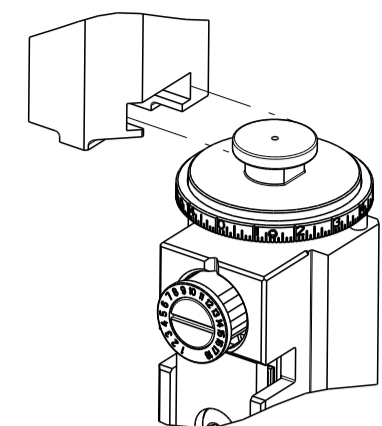


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151954-2	F	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
5-2151954-2	F	SEAL STRIPPER CRIMPER TERMINATING UNIT	PNEUMATIC
7-2151954-2	F	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2151954-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



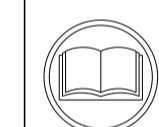
APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	3.25 mm [.128]	F
INSUL	4.45 mm [.175]	O

APPLICATOR INSTRUCTIONS 408-35042

TERMINAL DATA: DELPHI TERMINAL DELPHI CRIMP SPECIFICATION	
TERMINAL NAME: MALE METRI-PACK 280	
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE
4.90-5.28 mm [.193-.208 IN]	∅2.45-3.25 mm [.096-.128 IN]
TERMINAL APPLICATION SPECIFICATION	DELPHI Rev -
	CODE LEGEND 1005

TERMINALS APPLIED				
TE TERMINAL	DELPHI TERMINAL	TE SEAL	DELPHI SEAL	SEAL INSULATION DIAMETER RANGE
286945-1	12129497	1572716-3	15324980	∅2.81-3.49mm
		1949807-1	15324982	∅2.03-2.85mm
		1949896-1	15324981	∅3.45-4.30mm
		286953-3	12015284	∅2.85-2.03mm

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
3.00mm2	1.90 +/- 0.05 [.075 +/- .002]	6.2
2.00mm2	1.65 +/- 0.05 [.065 +/- .002]	8.8



- 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.
- TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- 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.
- UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- WIRE SIZE NOT RECOMMENDED FOR SEAL STRIPPER CRIMPER TERMINATING UNIT.
- 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.

**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			
P	LTN	DESCRIPTION	DATE	OWN	APPD		
A	66	D5	ECR-18-012060	27JUL2018	VLA	CT	
		E	ECR-19-009011	08JUN2019	TB	TE	
		F	ECR-22-129003	03MAR2022	LG	TE	

-	1	1	1	1803945-4	TONKER	300
-	1	1	1	22278-9	SPRING, COMPRESSION	299
-	2	2	2	4-18032-3	SCR, SET, FLT PNT, M3 X 6.0	298
-	1	1	1	1803944-1	SPACER, TONKER	297
-	-	1	-	2-1803583-1	APPLICATOR BASIC ASSEMBLY, SF	292
-	1	1	1	2119641-1	FEED CAM, AIR FEED	248
-	1	1	1	2119082-7	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
-	1	1	1	2844940-1	AIR FEED MODULE	238
-	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	1	1	1	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113
-	1	1	1	2844908-1	SCREW, LOCKING	99
-	1	1	1	2844907-1	POST, LOCKING	98
-	1	1	1	455888-4	SPACER, CRIMPER	82
-	2	2	2	18024-6	SCR, BTN SKT HD CAP (M4 X 8.0)	79
-	1	1	1	1803096-1	EXTENSION PLATE	78
-	1	1	1	1803607-3	DOCUMENTATION PACKAGE	71
-	1	1	1	2119791-5	DEPRESSOR, WIRE	70
-	1	1	1	2119943-1	WASHER, SPACER	69
-	1	1	1	2119740-1	TAG, IDENTIFICATION	67
-	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	60
-	1	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	1	1	1	985575-3	SCR, FLT SKT HD CAP M3 X 10.0	57
-	1	1	1	1338683-8	FEED PAWL	56
-	4	4	4	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	54
-	2	2	2	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	53
-	1	1	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	1	-	1	1803583-9	APPLICATOR BASIC ASSEMBLY, SF	46
-	1	1	1	1803515-1	RAM ASSEMBLY, SF ATLANTIC	44
-	1	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
-	1	1	1	1752356-1	SUPPORT, TERMINAL	34
-	2	2	2	2079383-8	SCR, BHSC, RoHS (M4 X 16)	33
-	2	2	2	1-2844962-7	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29
-	1	1	1	455888-3	SPACER, CRIMPER	28
-	1	1	1	1320928-4	STRIP GUIDE	24
-	1	-	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
-	2	1	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	1	3-22280-3	SPRING, COMPRESSION	12
-	1	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	2	1	1	2-1633928-5	ANVIL, COMBINATION	8
-	1	1	1	8-240641-5	SPACER	7
-	-	-	-	-	-	6
-	1	1	1	1-2119781-0	DEPRESSOR, SHEAR	5
-	1	1	1	5-238011-5	BLOCK, CRIMPER SPACER	4
1	2	1	1	5-1633965-9	CRIMPER, INSULATION O PREMIUM	3
-	1	1	1	1-455888-0	SPACER, CRIMPER	2
1	2	1	1	3-1673600-2	CRIMPER, WIRE	1

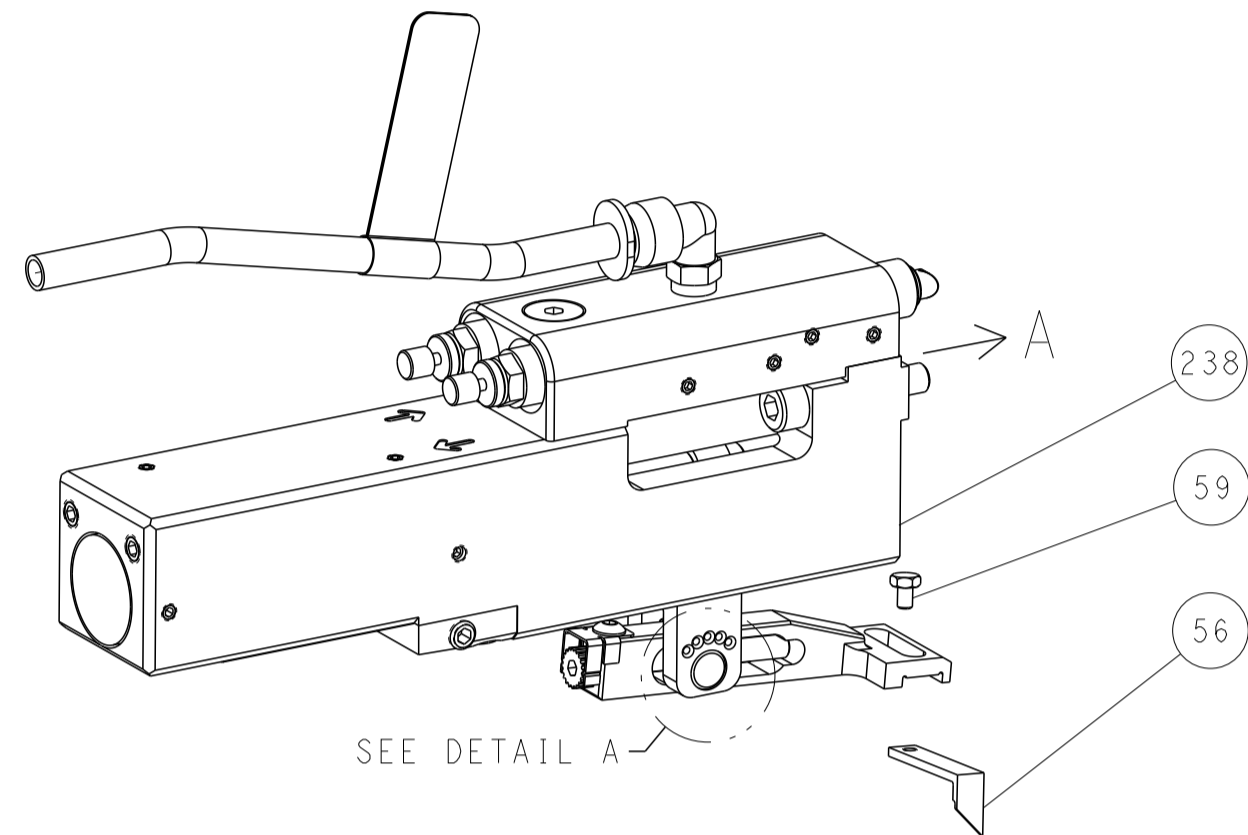
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG		NAME	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	APVD	NAME
	ANGLES	FINISH					
MATERIAL				WEIGHT		SCALE	SHEET 1 OF 4

Customer Accessible Production Drawing

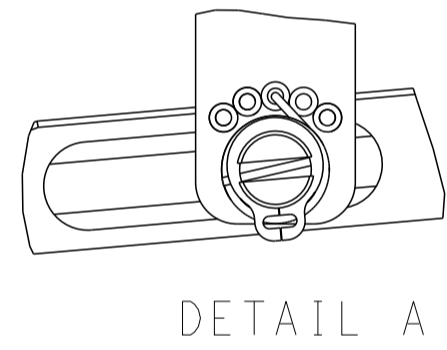
LOC	DIST	REVISIONS					
		P	LTN	DESCRIPTION	DATE	OWN	APVD
A	66	-	-	SEE SHEET 1	-	-	-

# FEED TYPE

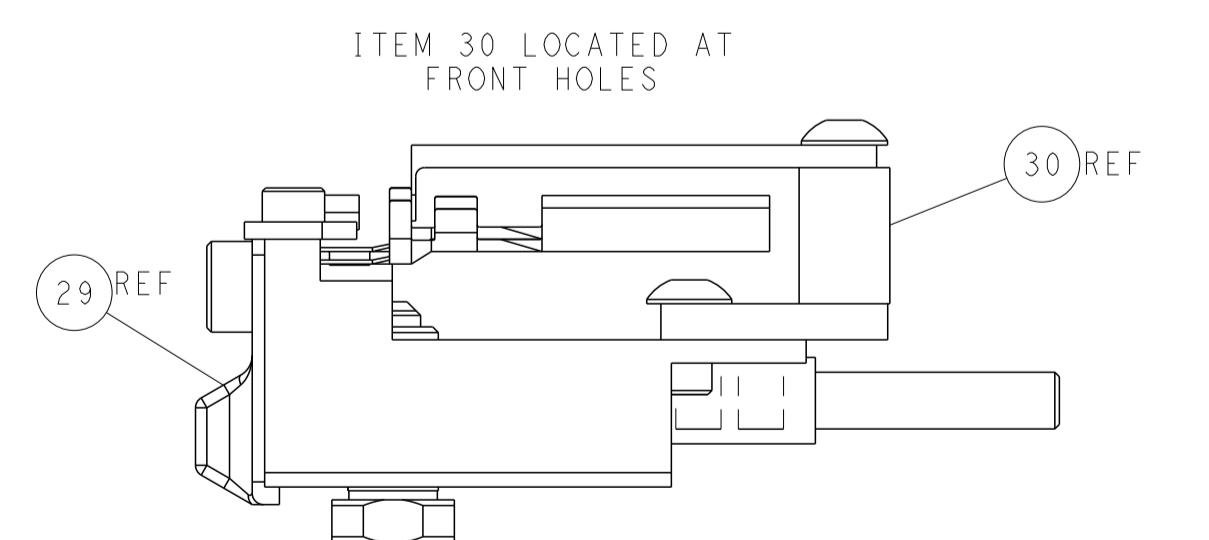
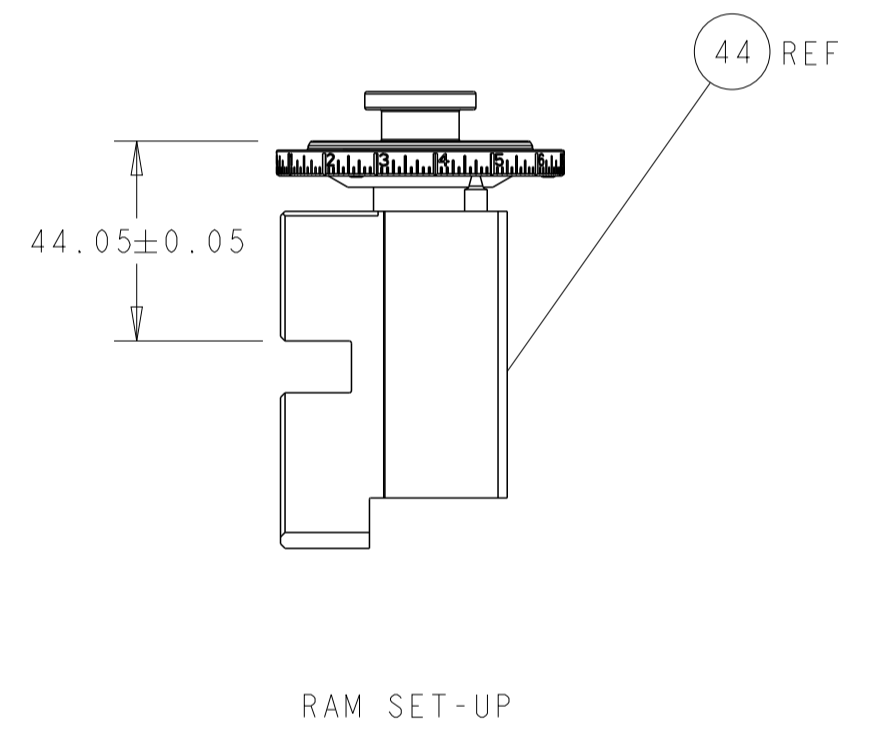
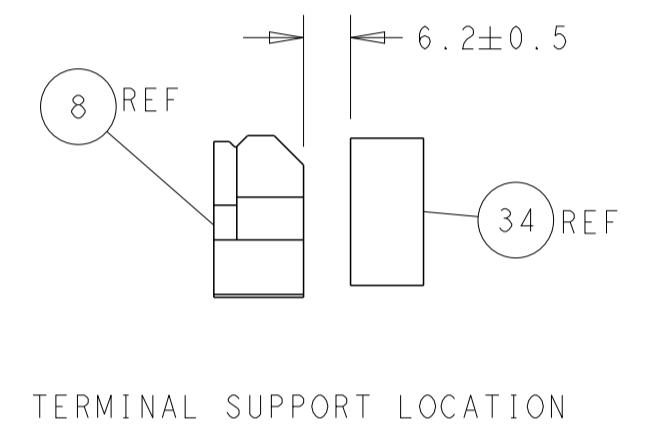
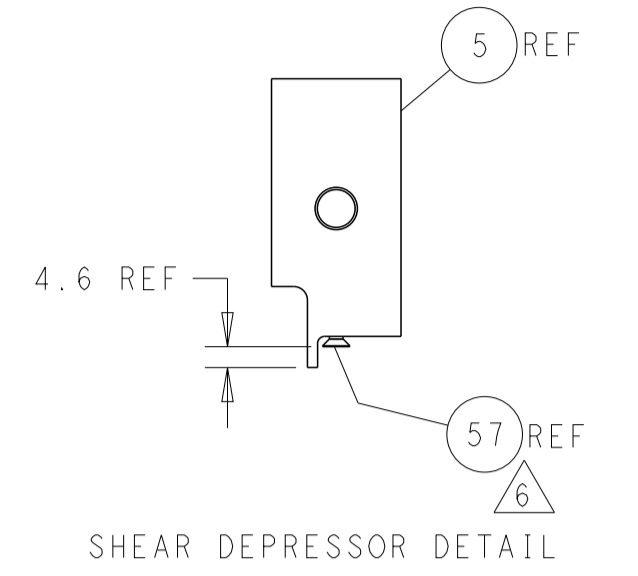
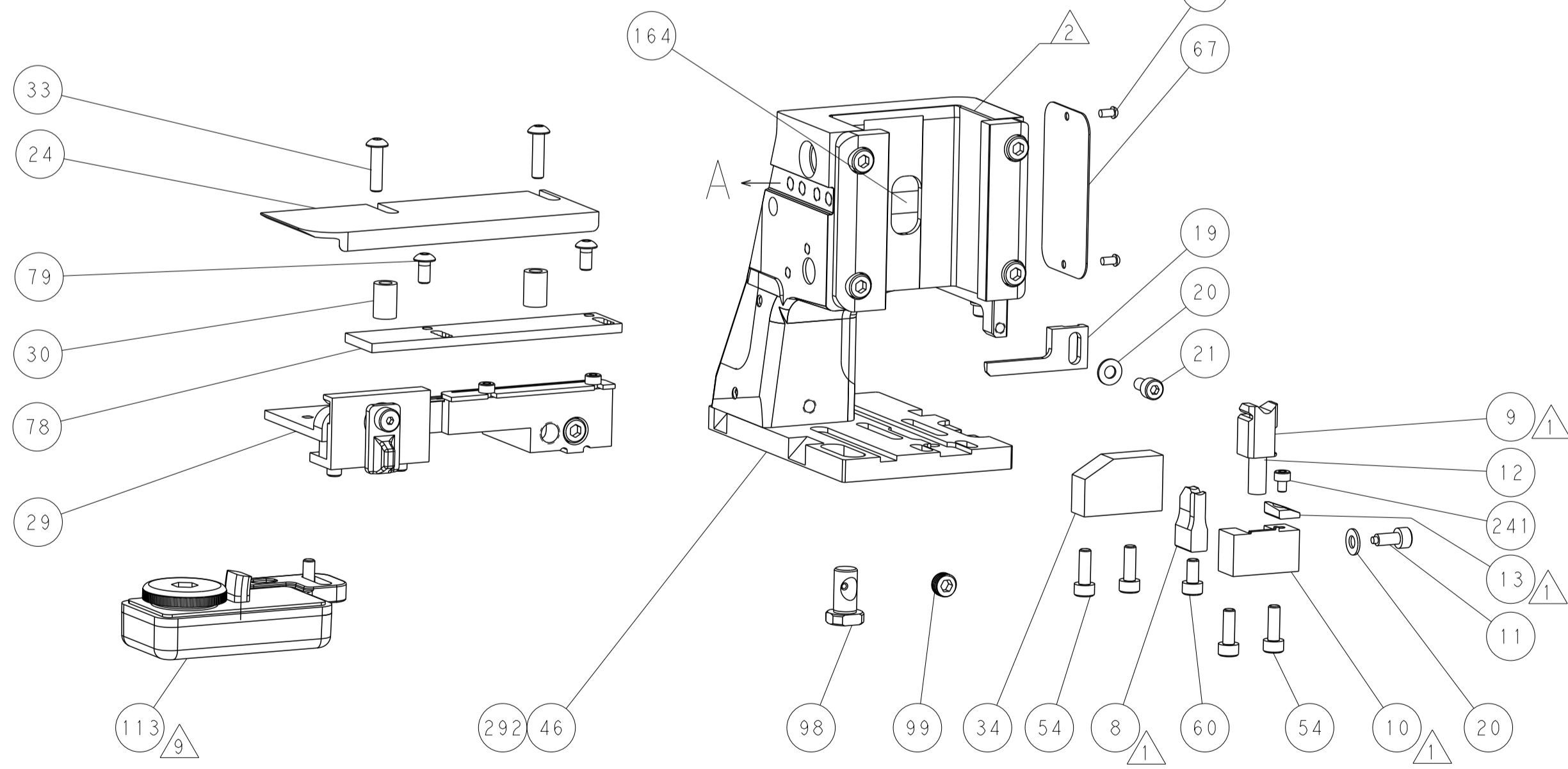
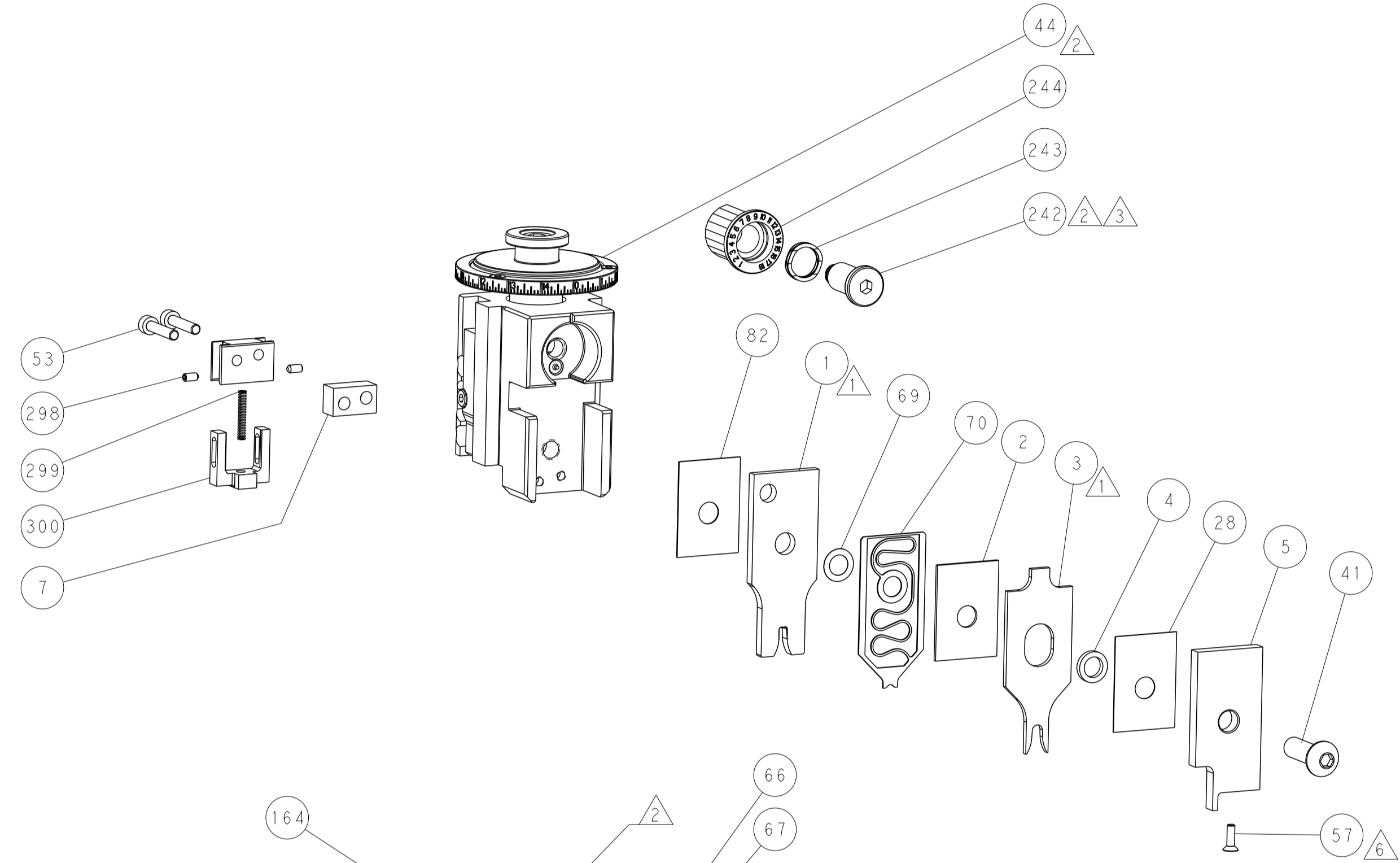
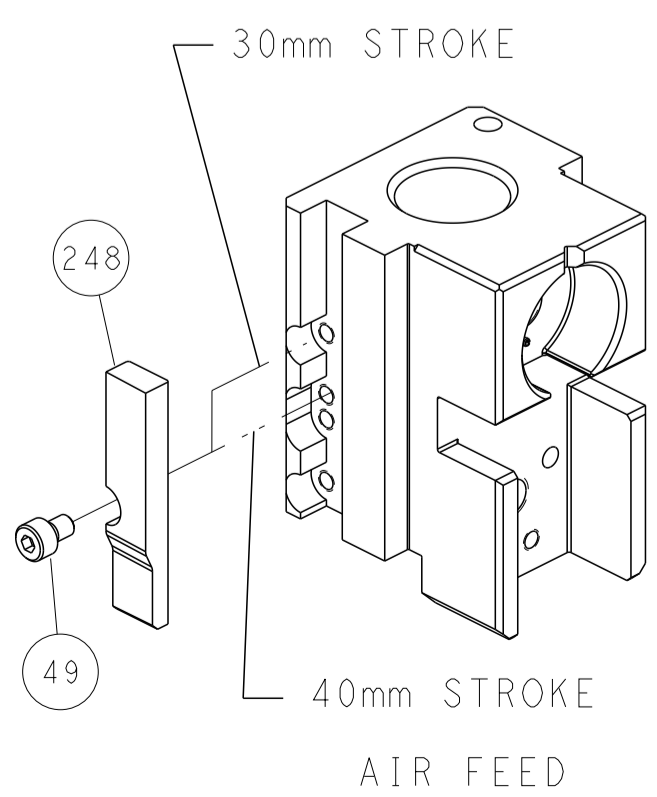
## PNEUMATIC



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



## CAM POSITION



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

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		OWN: HOFFNER 30MAY2013		TE Connectivity	
mm		0 PLC ±		CHK: T. ELBIN 31MAY2013		Harrisburg, PA 17105-3608	
Ø		1 PLC ±		APVD: T. ELBIN 31MAY2013		NAME: Ocean Side Feed Applicator	
H		2 PLC ±		PRODUCT SPEC		SIZE: CAGE CODE DRAWING NO	
L		3 PLC ±		APPLICATION SPEC		RESTRICTED TO	
R		4 PLC ±		WEIGHT		A1 00779 ©=2151954	
ANGLES		FINISH		Customer Accessible Production Drawing		SCALE: 1:2 SHEET 2 OF 4 REV F	

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2151954-2	F	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151954-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR  
 INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	3.25 mm [.128]	F
INSUL	4.45 mm [.175]	O

APPLICATOR INSTRUCTIONS  
 408-35042

TERMINAL DATA: DELPHI TERMINAL DELPHI CRIMP SPECIFICATION	
TERMINAL NAME: MALE METRI-PACK 280	
WIRE STRIP LENGTH 4.90-5.28 mm [1.93-.208 IN]	INSULATION DIAMETER RANGE Ø 2.45-3.25 mm [0.96-.128 IN]
TERMINAL APPLICATION SPECIFICATION DELPHI Rev - CODE LEGEND 1005	

TERMINALS APPLIED				
TE TERMINAL	DELPHI TERMINAL	TE SEAL	DELPHI SEAL	SEAL INSULATION DIAMETER RANGE
286945-1	12129497	1572716-3	15324980	Ø 2.81-3.49mm
		1949807-1	15324982	Ø 2.03-2.85mm
		1949896-1	15324981	Ø 3.45-4.30mm
		286953-3	12015284	Ø 2.85-2.03mm

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
3.00mm2	1.90 +/- 0.05 [0.75 +/- .002]	6.2
2.00mm2	1.65 +/- 0.05 [0.65 +/- .002]	8.8



- 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 TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- 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. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- 8 WIRE SIZE NOT RECOMMENDED FOR SEAL STRIPPER CRIMPER TERMINATING UNIT.
- 9 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.

**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	LTN	DESCRIPTION	DATE	DWN	APVD
		-	-	SEE SHEET 1		-	-

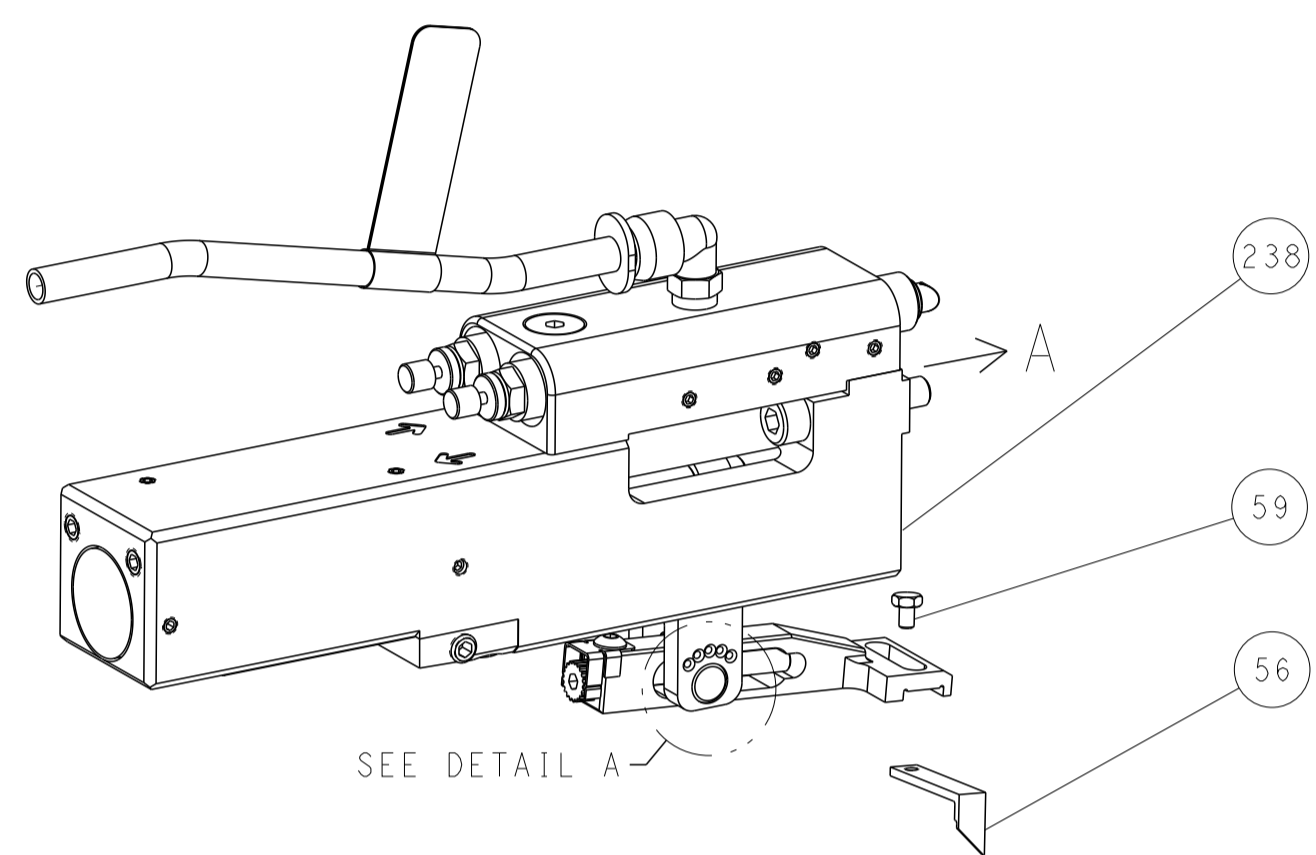
-	1	1803945-4	TONKER	300
-	1	22278-9	SPRING, COMPRESSION	299
-	2	4-18032-3	SCR, SET, FLT PNT, M3 X 6.0	298
-	1	1803944-1	SPACER, TONKER	297
-	1	2119082-7	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
3	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
-	1	2844940-1	AIR FEED MODULE	238
-	REF	994970-2	COUNTER, MAGNETIC	164
-	1	2119641-2	FEED CAM, AIR FEED	151
-	1	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	144
-	4	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	143
-	1	1-1803583-0	APPLICATOR BASIC ASSEMBLY, SF	141
-	1	1803516-1	RAM ASSEMBLY, SF PACIFIC	140
9	1	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113
-	1	2844908-1	SCREW, LOCKING	99
-	1	2844907-1	POST, LOCKING	98
-	1	455888-4	SPACER, CRIMPER	82
-	2	18024-6	SCR, BTN SKT HD CAP (M4 X 8.0)	79
-	1	1803096-1	EXTENSION PLATE	78
-	1	1803607-3	DOCUMENTATION PACKAGE	71
-	1	2119791-5	DEPRESSOR, WIRE	70
-	1	2119943-1	WASHER, SPACER	69
-	1	2119740-1	TAG IDENTIFICATION	67
-	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
6	1	985575-3	SCR, FLT SKT HD CAP M3 X 10.0	57
-	1	1338683-8	FEED PAWL	56
-	2	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	53
-	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
-	1	1752356-1	SUPPORT, TERMINAL	34
-	2	2079383-8	SCR, BHSC, RoHS (M4 X 16)	33
-	2	1-2844962-7	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	2844992-1	ASSEMBLY, STRIP GUIDE	29
-	1	455888-3	SPACER, CRIMPER	28
-	1	1320928-4	STRIP GUIDE	24
-	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
-	2	1-18028-2	WASHER, FLAT, REG M4	20
-	1	2119533-1	STRIPPER, SIDE FEED	19
-	1	2119806-1	INSERT, SHEAR	13
-	1	3-22280-3	SPRING, COMPRESSION	12
-	1	1-356885-4	STOP, SHEAR	11
-	1	2119805-1	SHEAR HOLDER, FRONT	10
-	1	1803095-1	FLOATING SHEAR, FRONT	9
-	1	2-1633928-5	ANVIL, COMBINATION	8
-	1	8-240641-5	SPACER	7
-	-	-	-	6
-	1	1-2119781-0	DEPRESSOR, SHEAR	5
-	1	5-238011-5	BLOCK, CRIMPER SPACER	4
1	1	5-1633965-9	CRIMPER, INSULATION O PREMIUM	3
-	1	1-455888-0	SPACER, CRIMPER	2
1	1	3-1673600-2	CRIMPER, WIRE	1

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		MATERIAL:		FINISH:		WEIGHT:		SCALE:	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES	FINISH			SCALE	1:2

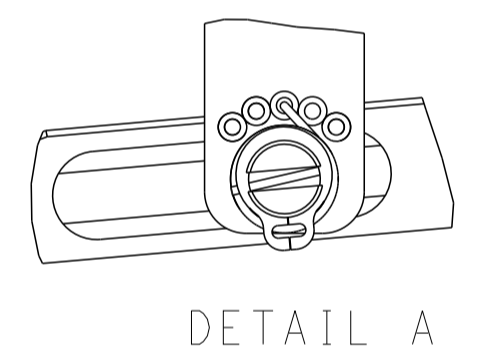
OWN	HOFFNER	30MAY2013
CHK	T. ELBIN	31MAY2013
APVD	T. ELBIN	31MAY2013
PRODUCT SPEC		
APPLICATION SPEC		
SIZE	CAGE CODE	DRAWING NO
A1	00779	2151954
Customer Accessible Production Drawing		REV F

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

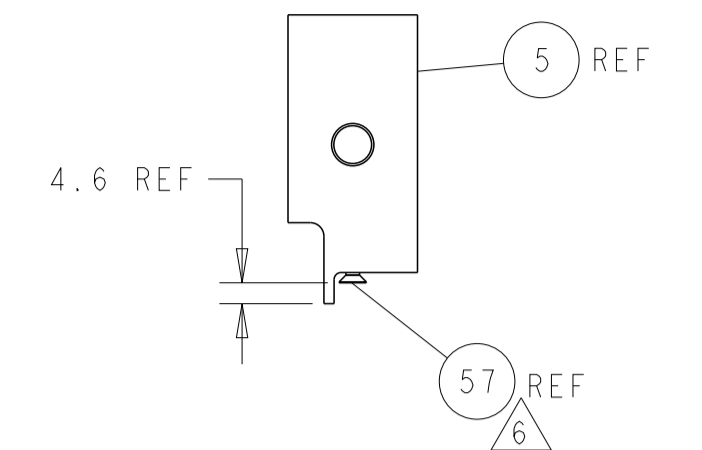
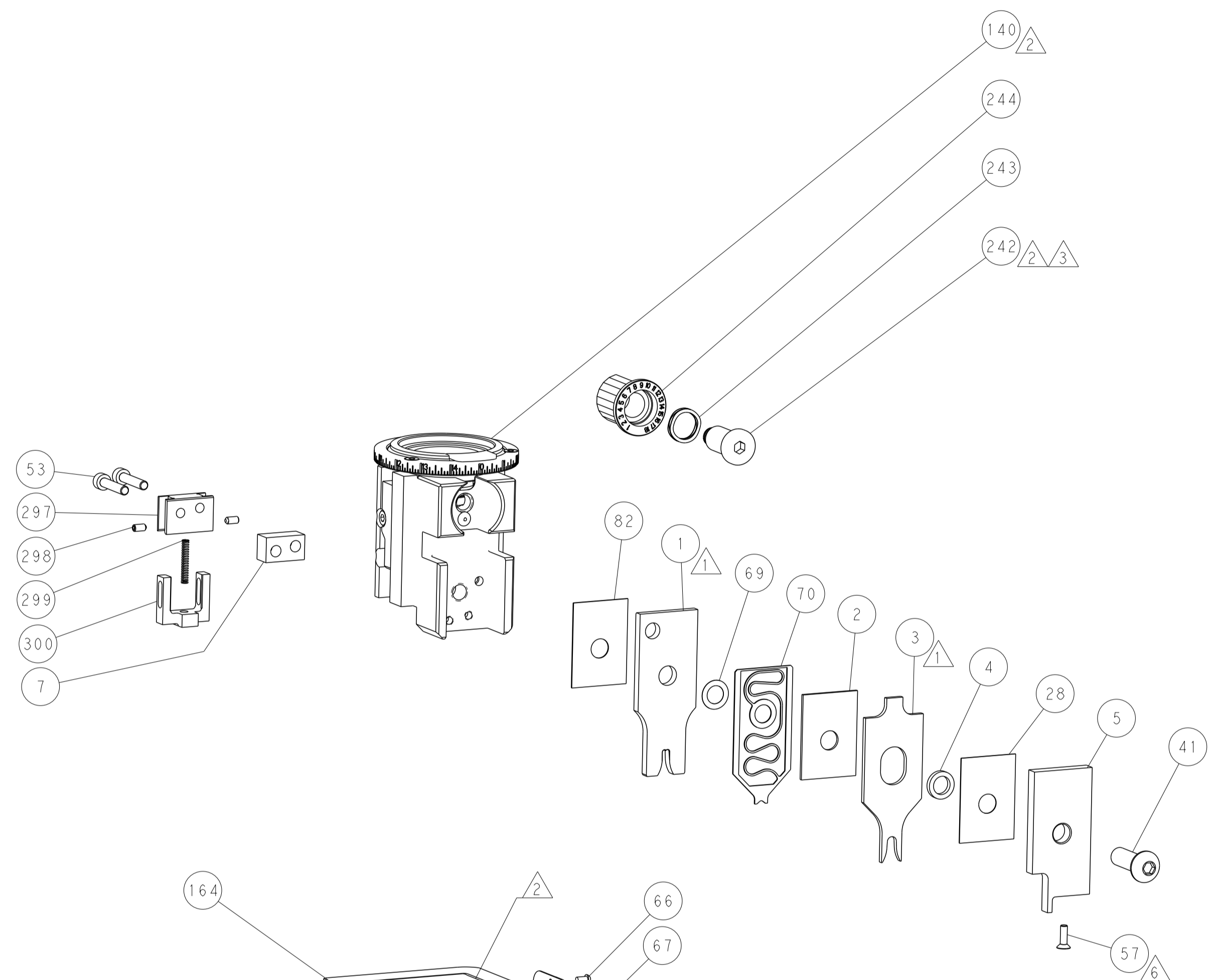
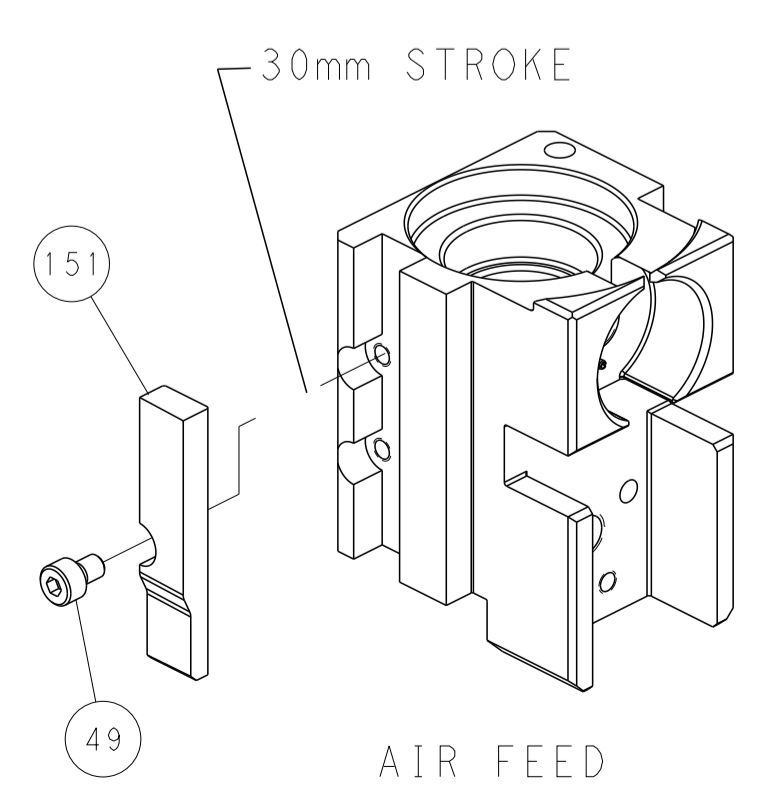
### FEED TYPE PNEUMATIC



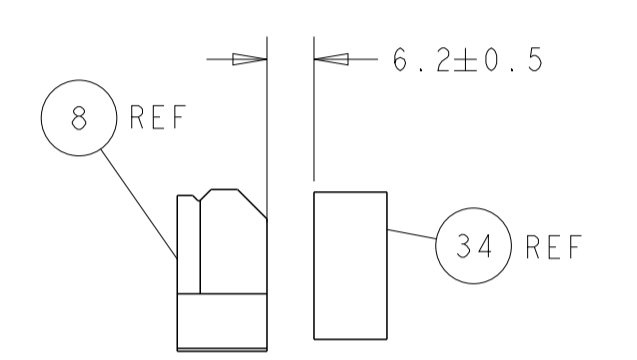
### FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



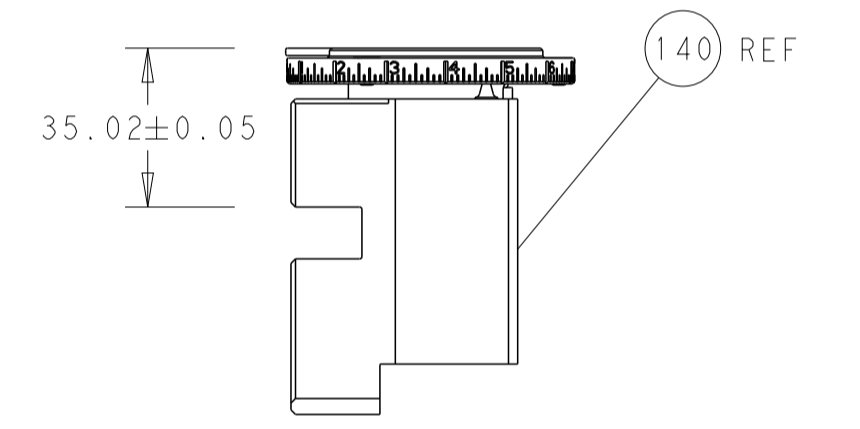
### CAM POSITION



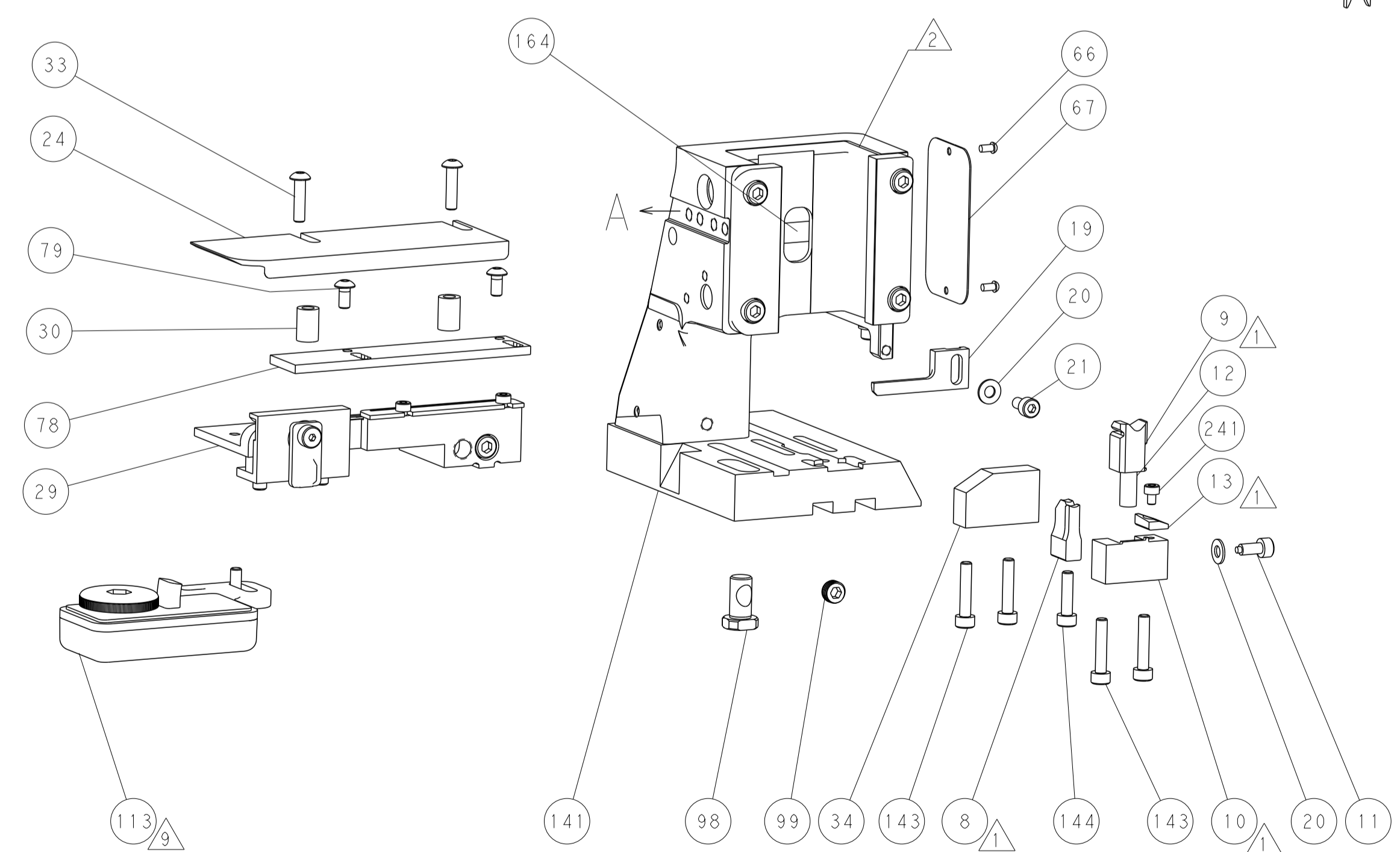
SHEAR DEPRESSOR DETAIL



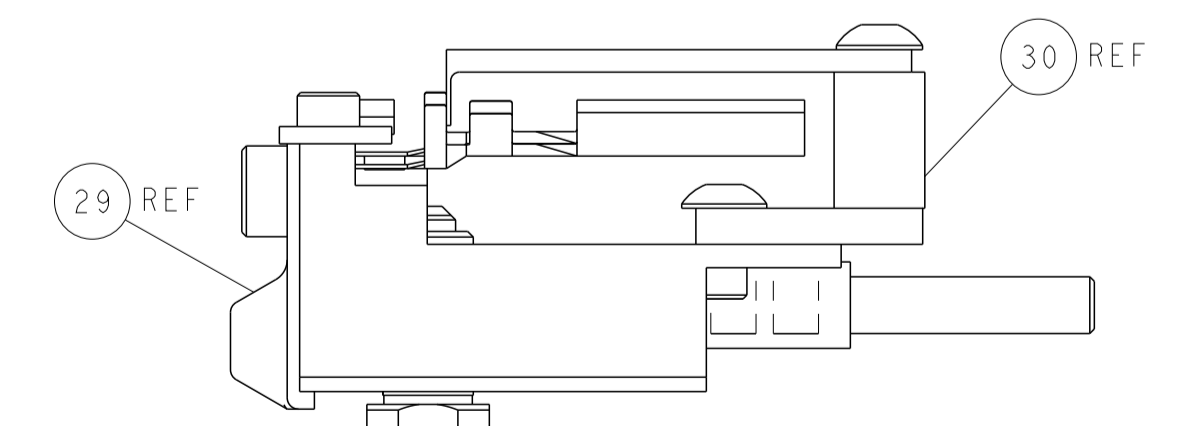
TERMINAL SUPPORT LOCATION



RAM SET-UP



ITEM 30 LOCATED AT FRONT HOLES



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)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN HOFFNER 30MAY2013		TE Connectivity	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	5 PLC ±	Harrisburg, PA 17105-3608
	ANGLES	FINISH		APVD T. ELBIN 31MAY2013	NAME	Ocean Side Feed Applicator	
MATERIAL				PRODUCT SPEC	APPLICATION SPEC	SIZE	RESTRICTED TO
				WEIGHT	SCALE	1:2	
				Customer Accessible Production Drawing	SCALE	1:2	SHEET 4 OF 4 REV F