

8		7	
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20		20	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151981-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2151981-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
5-2151981-1	C	SEAL STRIPPER CRIMPER TERMINATING UNIT	MECHANICAL
5-2151981-2	C	SEAL STRIPPER CRIMPER TERMINATING UNIT	PNEUMATIC
7-2151981-1	C	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2151981-2	C	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2151981-7	A	CRIMP TOOLING KIT	-

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.57 mm [.062]	F
INSUL	3.18 mm [.125]	O
APPLICATOR INSTRUCTIONS 408-35042		

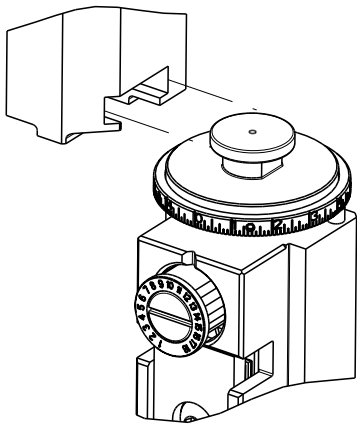
TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: MCP 1.2 -CB RECEPTACLE			
WIRE STRIP LENGTH 3.30-3.90 mm [.130-.154 IN]		INSULATION DIAMETER RANGE Ø1.40-1.90 mm [.055-.075 IN]	
TERMINAL APPLICATION SPECIFICATION		114-18464	
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE SEAL	TE SEAL
1670146-1	1670146-2		963142-2
1670146-3			967067-1
			2098582-1
		SEAL INSULATION DIAMETER RANGE	
		Ø 0.9-1.3mm	
		Ø 1.4-2.1mm	
		Ø 1.35-1.9mm	

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.75mm2	0.95+/-0.03 [.037+/- .001]	7.2
0.5mm2 or 20AWG	0.84+/-0.03 [.033+/- .001]	8.4



- 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 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.
- 6 TERMINAL LUBRICANT IS RECOMMENDED.
7. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.

ATLANTIC VERSION TERMINATOR
INTERFACE ADAPTER



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				
A	66	P	LYR	DESCRIPTION	DATE	DWN
		A		RELEASED	16JUL2013	CC
		A1		ECR-16-015635	4NOV2016	RS
		B		ECR-17-005121	07APR2017	TB
		C		ECR-18-007874	23MAY2018	LG

-	-	-	1	1	-	-	1803515-3	RAM ASSEMBLY, SF ATLANTIC	293
-	-	-	1	1	-	-	2-1803583-1	APPLICATOR BASIC ASSEMBLY, SF	292
-	1	-	1	-	1	-	2119640-1	PUSH ROD, AIR FEED	250
-	1	-	1	-	1	-	1803259-1	BUSHING, FLANGED	249
-	1	-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248
-	1	1	1	1	1	1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	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	-	2063440-1	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	-	-	1-1752354-8	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
-	2	-	2	-	2	-	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172
-	REF	REF	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	1	-	1	-	1	-	240638-1	SPRING, FEED FINGER	163
-	1	-	1	-	1	-	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854	137
-	1	-	1	-	1	-	2119799-1	HOLDER,FEED FINGER, AF	136
-	1	1	1	1	1	1	1-18028-2	WASHER, FLAT, REG M4	119
-	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	455888-4	SPACER, CRIMPER	82
-	1	1	1	1	1	1	1803607-1	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
-	1	1	1	1	1	1	985575-3	SCR, FLT SKT HD CAP M3 X 10.0	57
-	1	1	1	1	1	1	1338685-1	PAWL, FEED	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	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	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	3-1752356-3	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	2844992-2	ASSEMBLY, STRIP GUIDE	29
-	1	1	1	1	1	1	455888-3	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
-	1	1	-	-	1	1	1-18028-2	WASHER, FLAT, REG M4	20
-	1	1	-	-	1	1	2119533-1	STRIPPER, SIDE FEED	19
-	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	318707-1	FLOATING SHEAR, FRONT	9
1	2	2	1	1	1	1	4-1333202-8	ANVIL, COMBINATION	8
-	1	1	1	1	1	1	5-240641-0	SPACER	7
-	-	-	-	-	-	-	-	-	6
-	1	1	1	1	1	1	2119781-1	DEPRESSOR, SHEAR	5
-	1	1	1	1	1	1	238011-4	BLOCK, CRIMPER SPACER	4
1	2	2	1	1	1	1	1633965-1	CRIMPER, INSULATION O PREMIUM	3
-	1	1	1	1	1	1	455888-7	SPACER, CRIMPER	2
1	2	2	1	1	1	1	1-1752057-8	CRIMPER, WIRE PREMIUM, STEPPED	1

-77	-72	-71	-52	-51	-2	-1	PART NO	DESCRIPTION	ITEM NO
THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE AND TO BE CONTROLLED BY THE ENGINEERING ORGANIZATION. ANY CHANGES TO THIS DRAWING SHOULD BE CONTACTED FOR THE LATEST REVISION.							DWN C. CHEN 18JUN2013	STE TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm							CHK U. GUO 18JUN2013	NAME Ocean Side Feed Applicator	
TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±							APVD J. CRUZ 18JUN2013	SIZE CAGE CODE DRAWING NO RESTRICTED TO	
MATERIAL -							PRODUCT SPEC APPLICATION SPEC WEIGHT -	A1 00779 ©=2151981	
Customer Accessible Production Drawing							SCALE 1:2	SHEET 1	OF 4 REV C

PNEUMATIC

250

249

238

163

59

136

137

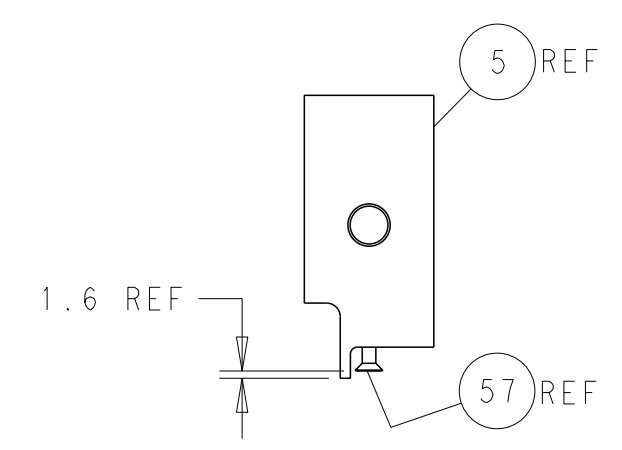
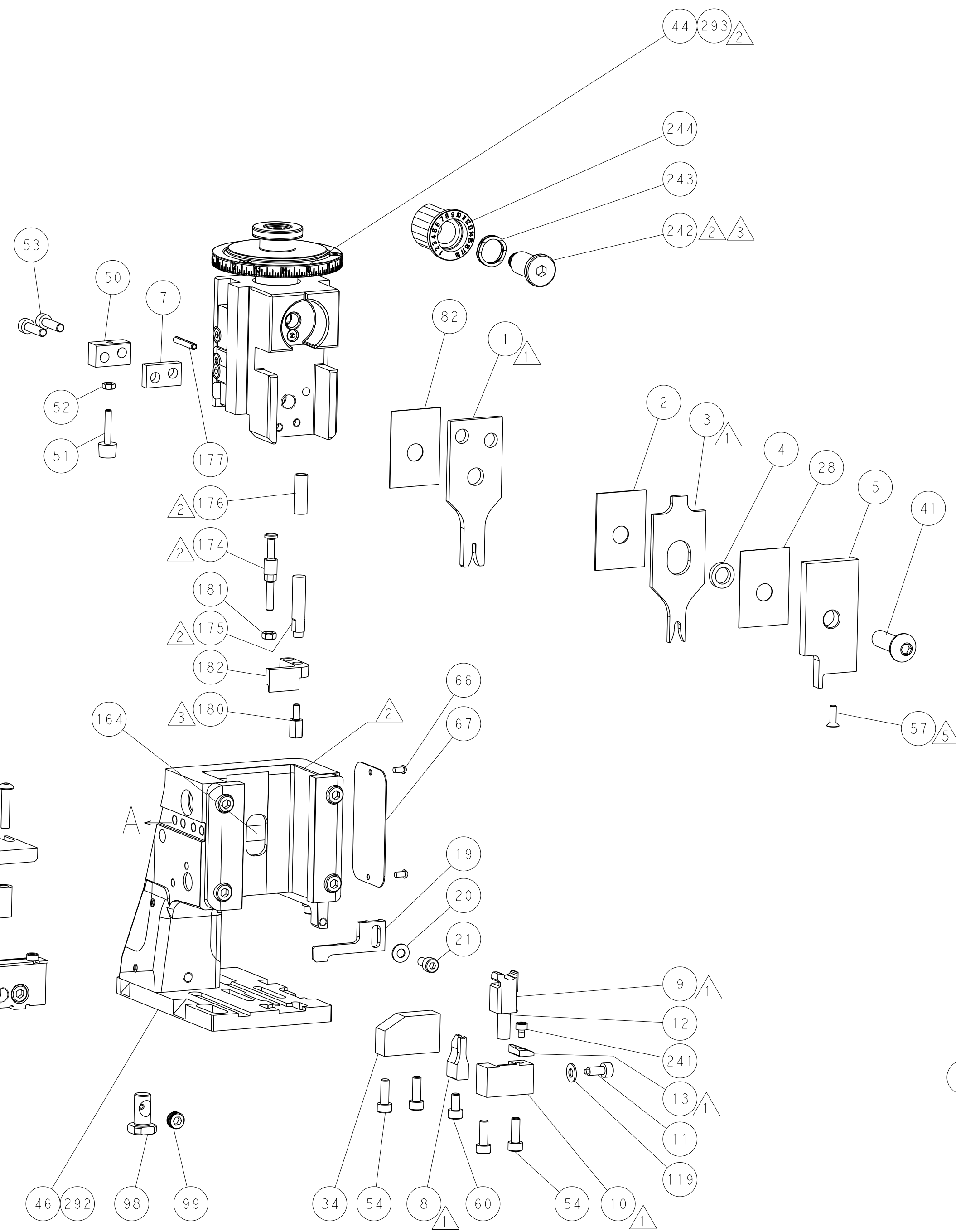
172

56

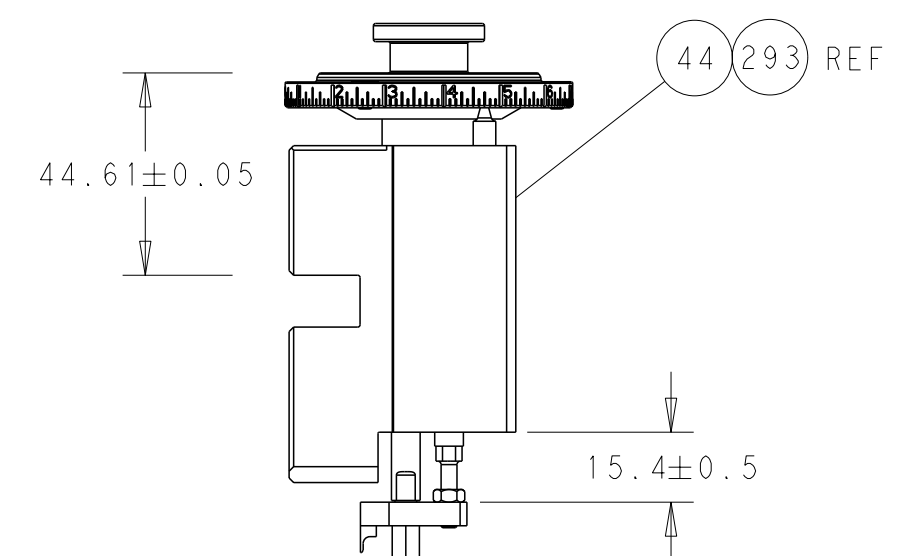
C

The diagrams illustrate the installation of the mechanical post feed unit for three different machine configurations:

- MECHANICAL POST FEED:** Shows the unit with a 30mm STROKE and 40mm STROKE. Callouts include 47 (a small rectangular component), 49 (a screw), and 48 (a wedge-shaped component).
- MECHANICAL PRE FEED:** Shows the unit with a 30mm STROKE and 40mm STROKE. Callouts include 48 (a wedge-shaped component), 49 (a screw), and 248 (a small rectangular component).
- AIR FEED:** Shows the unit with a 30mm STROKE and 40mm STROKE. Callouts include 248 (a small rectangular component) and 49 (a screw).

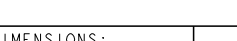


TERMINAL SUPPORT LOCATION



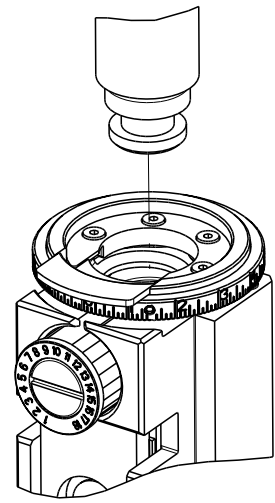
ITEM 30 LOCATED AT FRONT HOLES

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 FOR TFCO INDUSTRIES CORPORATION IT IS SUBJECT TO CHANGE AND THE CONTROLLING ENGINEERING ORGANIZATION SHALL BE NOTIFIED BY CONTACTING TFCO INDUSTRIES CORPORATION		DWN 18JUN2013 CHK 18JUN2013 APO 18JUN2013		 TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm 		NAME Ocean Side Feed Applicator -			
TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		PRODUCT SPEC - APPLICATION SPEC -		SIZE A1	
MATERIAL -		FINISH -		CAGE CODE 00779	
WEIGHT -		DRAWING NO C=2151981		RESTRICTED TO -	
Customer Accessible Production Drawing				SCALE 1:2 SHEET 2 OF 4 REV C	

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PART NUMBER	REVISION	DESCRIPTION
2-2151981-1	C	FINE CRIMP HEIGHT ADJUST
2-2151981-2	C	FINE CRIMP HEIGHT ADJUST
7-2151981-7	A	CRIMP TOOLING KIT
		FEED TYPE
		MECHANICAL
		PNEUMATIC
		-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.57 mm [.062]	F
INSUL	3.18 mm [.125]	O
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: MCP 1.2 -CB RECEPTACLE			
WIRE STRIP LENGTH 3.30-3.90 mm [.130-.154 IN]		INSULATION DIAMETER RANGE Ø1.40-1.90 mm [.055-.075 IN]	
TERMINAL APPLICATION SPECIFICATION 114-18464		-	-
TERMINALS APPLIED △ ₆		-	-
TE TERMINAL	TE TERMINAL	TE SEAL	TE SEAL
1670146-1	1670146-2		963142-2
1670146-3			967067-1
			2098582-1
		SEAL INSULATION DIAMETER RANGE	
		Ø 0.9-1.3mm	
		Ø 1.4-2.1mm	
		Ø 1.35-1.9mm	

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.75mm2	0.95+/-0.03 [.037+/-0.001]	7.2
0.5mm2 or 20AWG	0.84+/-0.03 [.033+/-0.001]	8.4



- 1 RECOMMENDED SPARE PARTS
- 2 REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION & 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 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.
- 6 TERMINAL LUBRICANT IS RECOMMENDED.
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.

PACIFIC VERSION
Shown on sheets 3 of 4 & 4 of 4
(Atlantic version shown on sheets 1 of 4 & 2 of 4)

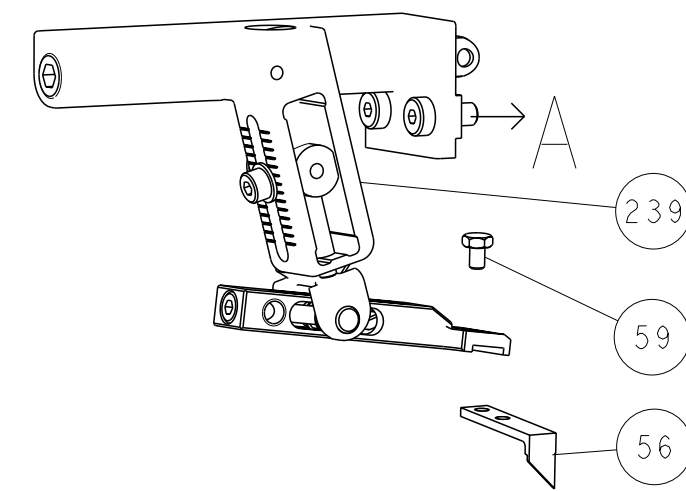
2	1
LOC	DIST
A	66
REVISONS	
P	LYR
-	SEE SHEET 1

-	1	-	2119640-1	PUSH ROD, AIR FEED	250
-	1	-	1803259-1	BUSHING, FLANGED	249
-	1	1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	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	-	2063440-1	AIR FEED MODULE	238
-	2	-	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172
-	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	1	-	240638-1	SPRING, FEED FINGER	163
-	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	-	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854	137
-	1	-	2119799-1	HOLDER,FEED FINGER, AF	136
-	1	1	1-18028-2	WASHER, FLAT, REG M4	119
-	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	455888-4	SPACER, CRIMPER	82
-	1	1	1803607-1	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	985575-3	SCR, FLT SKT HD CAP M3 X 10.0	57
-	1	1	1338685-1	PAWL, FEED	56
-	2	2	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	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	3-1752356-3	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	2844992-2	ASSEMBLY, STRIP GUIDE	29
-	1	1	455888-3	SPACER, CRIMPER	28
-	1	1	1320928-2	STRIP GUIDE	24
-	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
-	1	1	1-18028-2	WASHER, FLAT, REG M4	20
-	1	1	2119533-1	STRIPPER, SIDE FEED	19
-	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	2119805-1	SHEAR HOLDER, FRONT	10
-	1	1	318707-1	FLOATING SHEAR, FRONT	9
1	1	1	4-1333202-8	ANVIL, COMBINATION	8
-	1	1	5-240641-0	SPACER	7
-	-	-	-	-	6
-	1	1	2119781-1	DEPRESSOR, SHEAR	5
-	1	1	238011-4	BLOCK, CRIMPER SPACER	4
1	1	1	1633965-1	CRIMPER, INSULATION O PREMIUM	3
-	1	1	455888-7	SPACER, CRIMPER	2
1	1	1	1-1752057-8	CRIMPER, WIRE PREMIUM, STEPPED	1

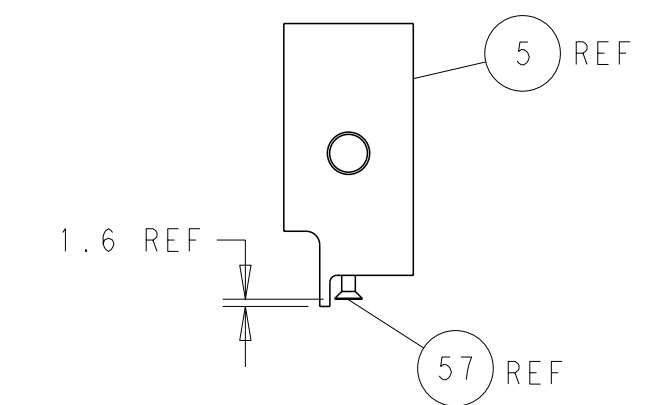
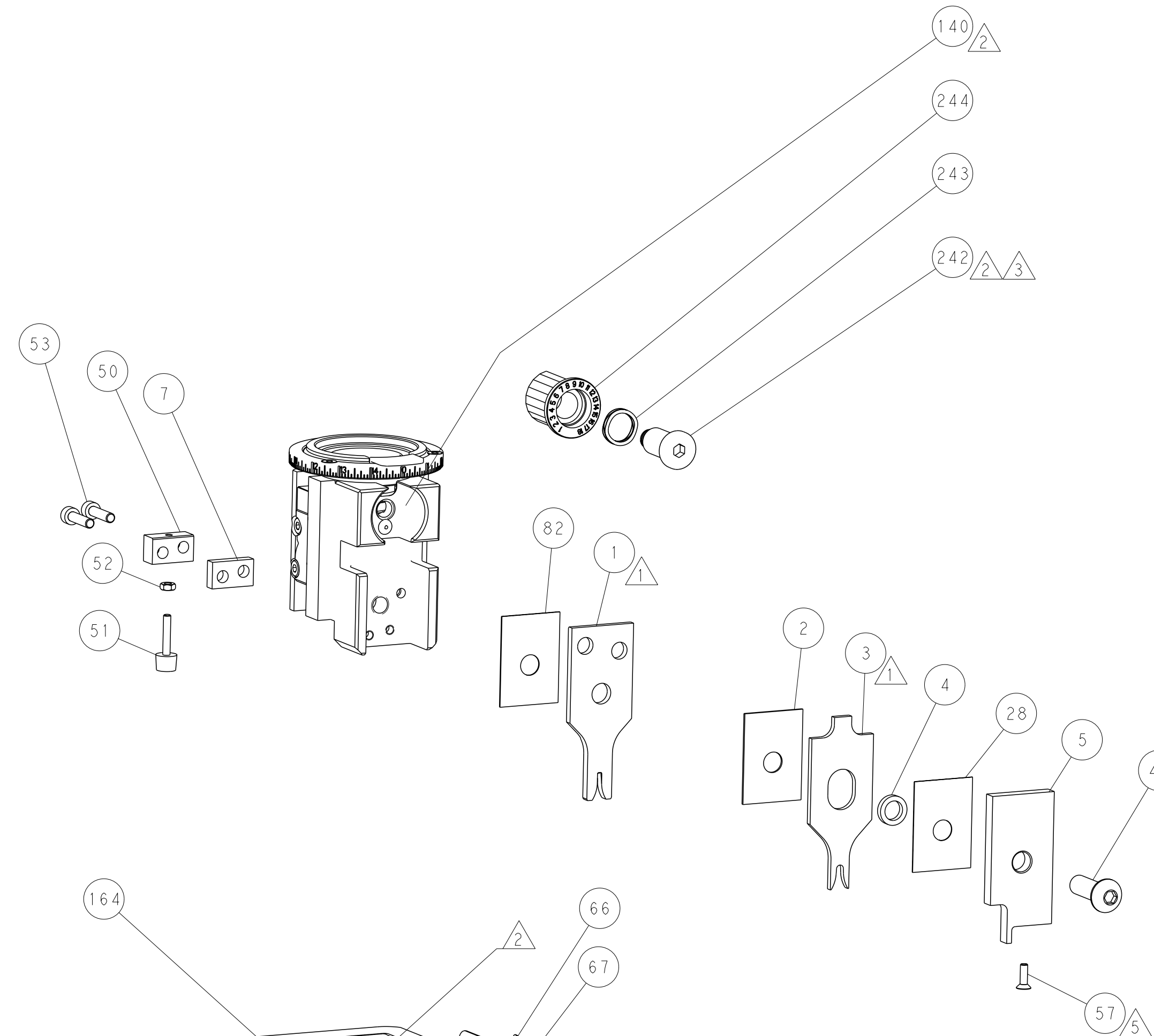
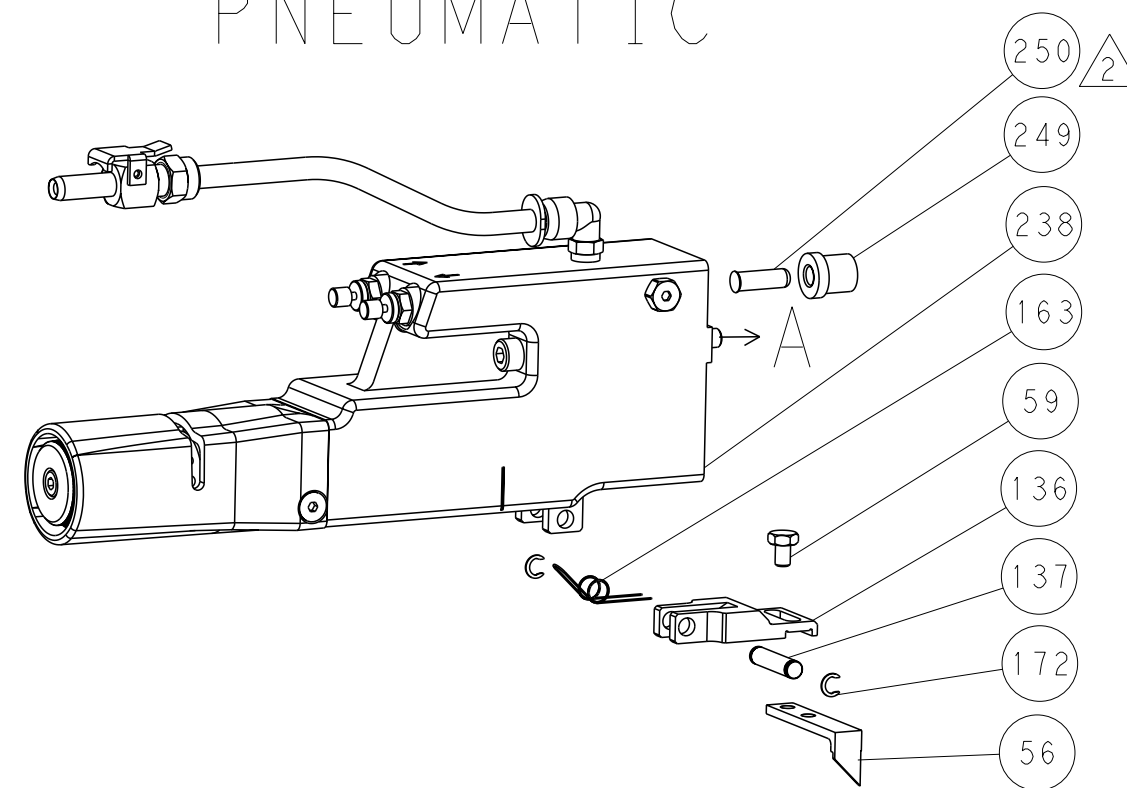
-77	-22	-21	PART NO	DESCRIPTION	ITEM NO
			DWN	18JUN2013	
			CHK	18JUN2013	
			U.GUO		
			APVD	18JUN2013	
			PRODUCT SPEC		
			APPLICATION SPEC		
			SIZE	CAGE CODE	DRAWING NO
			A1	00779	2151981
			WEIGHT		
			Customer Accessible Production Drawing	SCALE	1:2
			SHEET	3	OF 4
			REV	C	

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

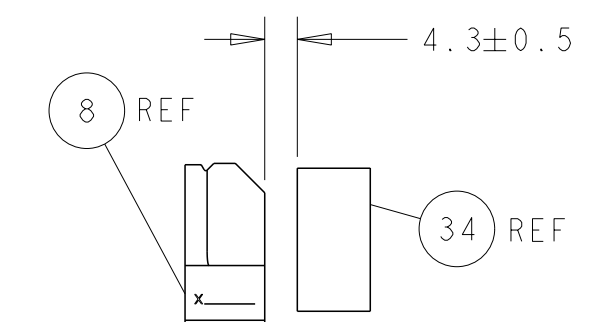
FEED TYPE
MECHANICAL



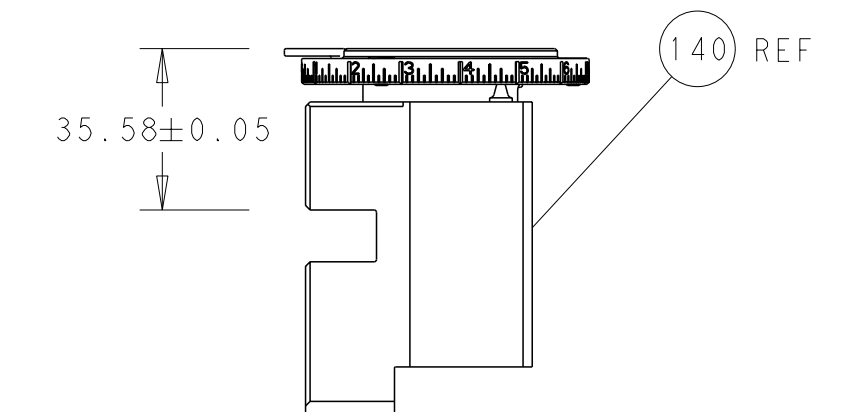
PNEUMATIC



SHEAR DEPRESSOR DETAIL

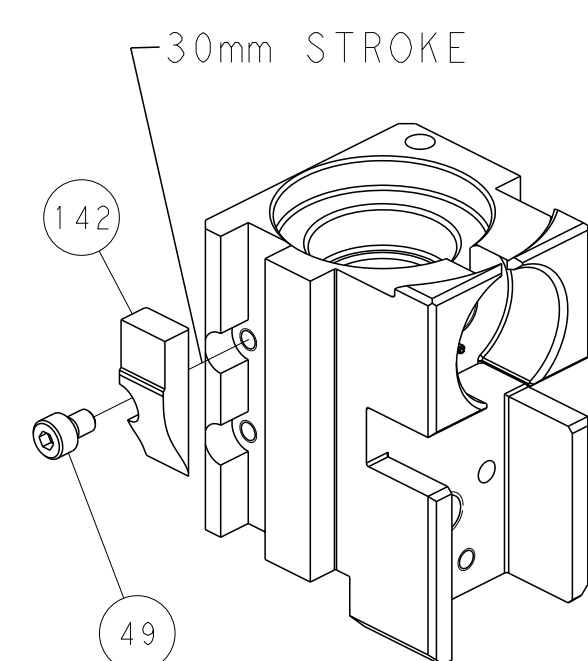


TERMINAL SUPPORT LOCATION

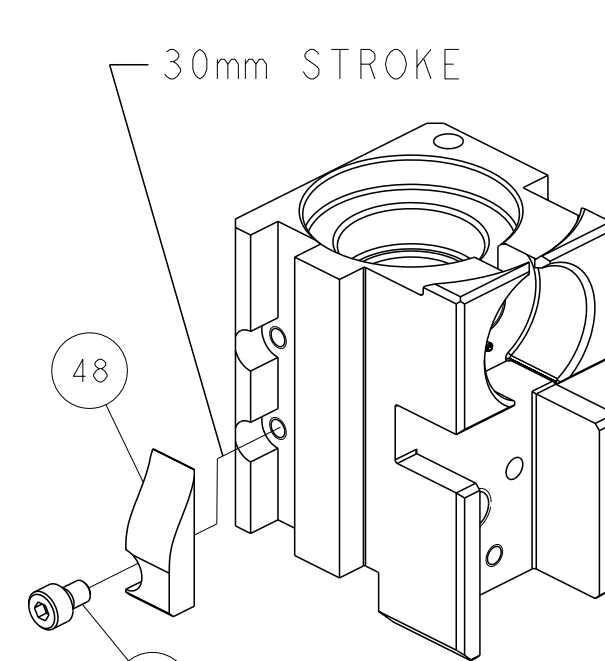


RAM SET-UP

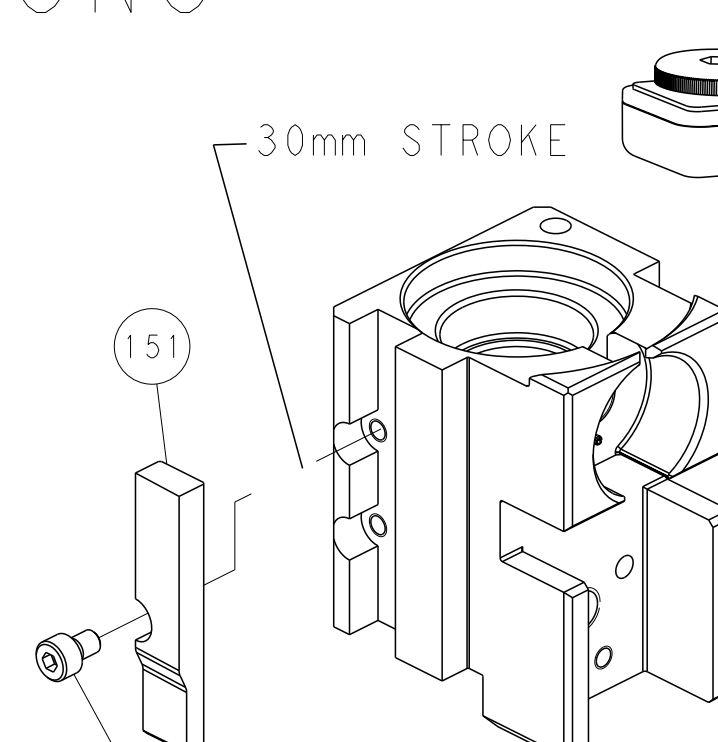
CAM POSITIONS



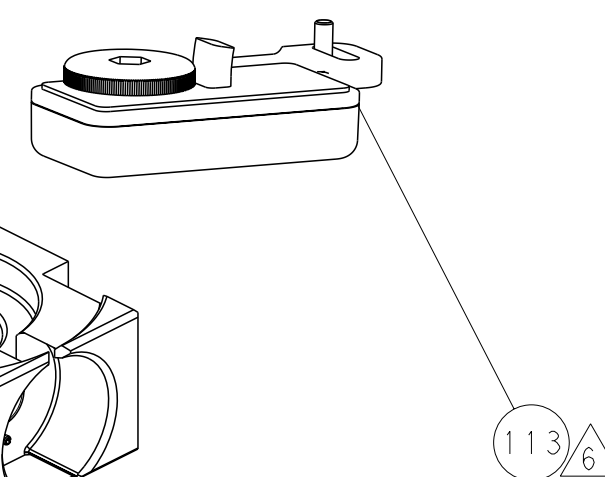
MECHANICAL
POST FEED



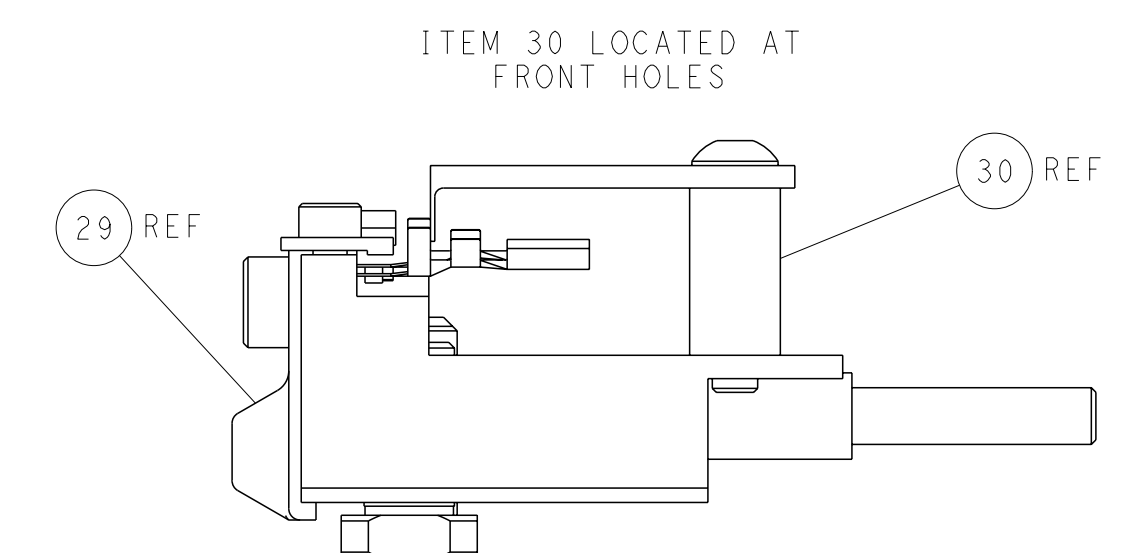
MECHANICAL
PRE FEED



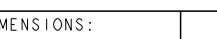
AIR FEED



PACIFIC VERSION
 Shown on sheets 3 of 4 & 4 of 4
 (Atlantic version shown on sheets 1 of 4 & 2 of 4)



FEED TRACK POSITION
GUIDE BY INSULATION BARREL

THIS DRAWING IS A CONTROLLED DOCUMENT FOR STE CONNECTIVITY CORPORATION IT IS SUBJECT TO CHANGE AND THE CONTROLLING ENGINEERING ORGANIZATION SHALL BE NOTIFIED BY CONTACTED FOR THE LATEST REVISION				DWN C. CHEN 18JUN2013	 TE Connectivity Harrisburg, PA 17105-3608									
				CHK G. GUO 18JUN2013										
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:			APVD L. CRUZ 18JUN2013	NAME	Ocean Side Feed Applicator							
mm					PRODUCT SPEC									
		0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ±			APPLICATION SPEC									
ANGLES FINISH		-			SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO						
-		-			WEIGHT	-	A1	00779	C-2151981	-				
Customer Accessible Production Drawing						SCALE		1:2	SHEET	A	OF	A	REV	C