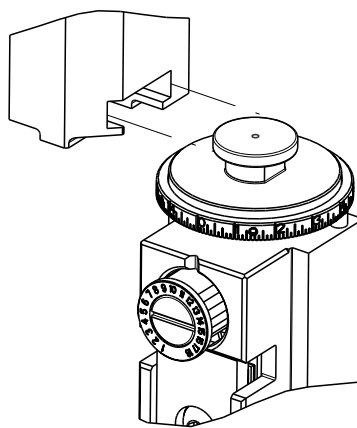


8	7	6	5	4	3	2	1
THIS DRAWING IS UNPUBLISHED.		RELEASED FOR PUBLICATION					
© COPYRIGHT 20		BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.					
PART NUMBER	REVISION	DESCRIPTION	FEED TYPE				
2151037-1	P	FINE CRIMP HEIGHT ADJUST	MECHANICAL				
2151037-2	R	FINE CRIMP HEIGHT ADJUST	PNEUMATIC				
3-2151037-2	R	FINE CRIMP HEIGHT ADJUST	DOUBLE ACTING PNEUMATIC WITH SENSORS				
7-2151037-1	P	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL				
7-2151037-2	R	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC				
7-2151037-7	N	CRIMP TOOLING KIT	-				

ATLANTIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.40 mm [.055]	F
INSUL	1.83 mm [.072]	SP
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: MCP 1.2MM CONTACT ASSEMBLY			
WIRE STRIP LENGTH			INSULATION DIAMETER RANGE
3.30-3.90 mm [.130-.154 IN]			Ø1.40-1.90 mm [.055-.075 IN]
TERMINAL APPLICATION SPECIFICATION	 114-18464	-	-
	-	-	-
TERMINALS APPLIED 			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
1452656-1	1452656-2	1452656-3	6-1452656-2
7-1452656-1	7-1452656-2	7-1452656-3	
1718350-1	1718350-2	1718350-3	

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.75mm2	1.05+/-0.03 [.041+/- .001]	6.5
0.50mm2	0.93+/-0.03 [.037+/- .001]	7.5
20 AWG	0.93+/-0.03 [.037+/- .001]	7.5



- 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 TERMINAL LUBRICANT IS RECOMMENDED.
- 6 THIS APPLICATOR IS EQUIPPED WITH THE DOUBLE ACTING FEED WITH SENSORS AND IS APPLICATION SPECIFIC. IT DOES NOT REQUIRE ITEMS 49 & 248.
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.

LOC	DIST	REVISIONS					
A	66	P	LTR	DESCRIPTION	DATE	DWN	APVD
			M1	ECR-17-003777	15MAR2017	BW	JT
			N	ECR-17-010466	19JUL2017	KH	JDG
			P	ECR-18-004053	19MAR2018	JAH	JDG
			R	ECR-19-005393	03APR2019	JAH	CT

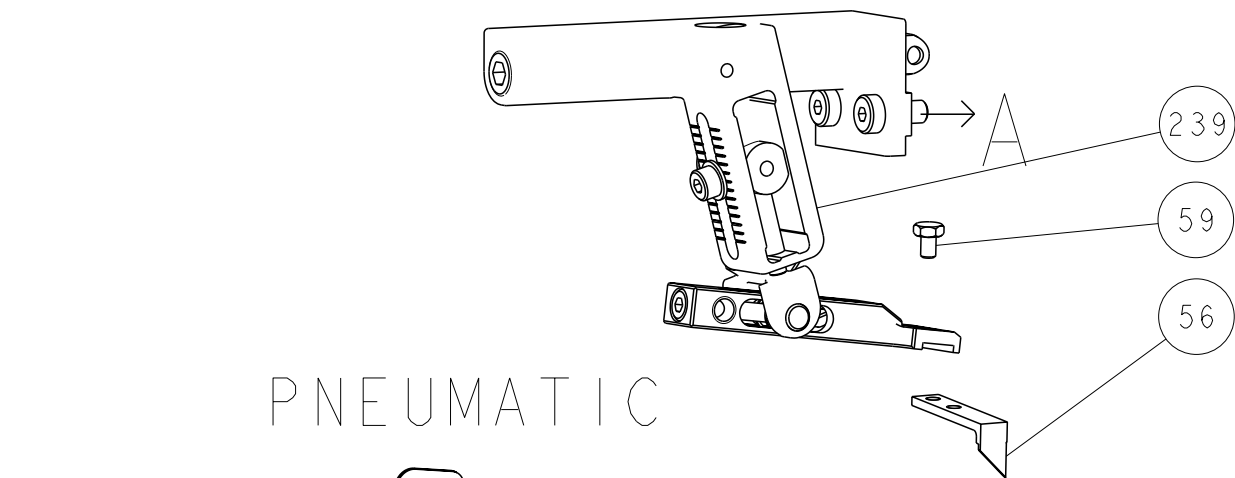
-	-	-	1	-	-	2844950-1	AIR FEED MODULE	290
-	1	-	-	1	-	2119641-1	FEED CAM, AIR FEED	248
-	1	1	1	1	1	2119082-5	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
3	-	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	1	1	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
-	-	1	-	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	1	-	-	1	-	2844940-1	AIR FEED MODULE	238
-	REF	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	1	1	1	1	1	1-18028-2	WASHER, FLAT, REG M4	119
5	-	1	1	1	1	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113
-	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	455888-5	SPACER, CRIMPER	82
-	1	1	1	1	1	1803607-3	DOCUMENTATION PACKAGE	71
-	1	1	1	1	1	2119791-5	DEPRESSOR, WIRE	70
-	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
-	2	2	2	2	2	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	57
-	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
-	1	1	1	1	1	5018030-1	NUT, HEX, REG, RoHS, M3	52
-	1	1	1	1	1	811242-5	BUMPER, HOLD DOWN	51
-	1	1	1	1	1	690753-2	SPACER, TONKER	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	1	1	1803583-9	APPLICATOR BASIC ASSEMBLY, SF	46
-	1	1	1	1	1	1803515-1	RAM ASSEMBLY, SF ATLANTIC	44
-	1	1	1	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
-	1	1	1	1	1	1752356-6	SUPPORT, TERMINAL	34
-	2	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	2	2	2	2-2844962-6	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	1	1	1	2844992-2	ASSEMBLY, STRIP GUIDE	29
-	1	1	1	1	1	1320928-6	STRIP GUIDE	24
-	1	1	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
-	1	1	1	1	1	1-18028-2	WASHER, FLAT, REG M4	20
-	1	1	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	2119805-1	SHEAR HOLDER, FRONT	10
1	-	1	1	1	1	1803095-1	FLOATING SHEAR, FRONT	9
1	1	2	2	1	1	1333231-9	ANVIL, COMBINATION, SPECIAL	8
-	1	1	1	1	1	5-240641-0	SPACER	7
-	1	1	1	1	1	2119757-8	DEPRESSOR, SHEAR	5
-	1	1	1	1	1	4-238011-2	BLOCK, CRIMPER SPACER	4
1	1	2	2	1	1	1633989-1	CRIMPER, INSULATION, SPECIAL	3
1	1	2	2	1	1	3-456402-3	CRIMPER, WIRE PREMIUM	1
-	77	-72	-71	-32	-2	-1	PART NO	ITEM NO

THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE AND TO BE CONTROLLED BY THE ENGINEERING ORGANIZATION. IT SHOULD BE CONTACTED FOR THE LATEST REVISION.		DWN C. CHEN CHK S. XI APVD J. CRUZ	08SEP2011 08SEP2011 08SEP2011	TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		NAME Ocean Side Feed Applicator	
MATERIAL -		FINISH -		SIZE A1	
		WEIGHT -		CAGE CODE 00779	
				DRAWING NO 2151037	
				RESTRICTED TO -	
				Customer Accessible Production Drawing	
				SCALE 1:2	
				SHEET 1	
				OF 4	
				REV R	

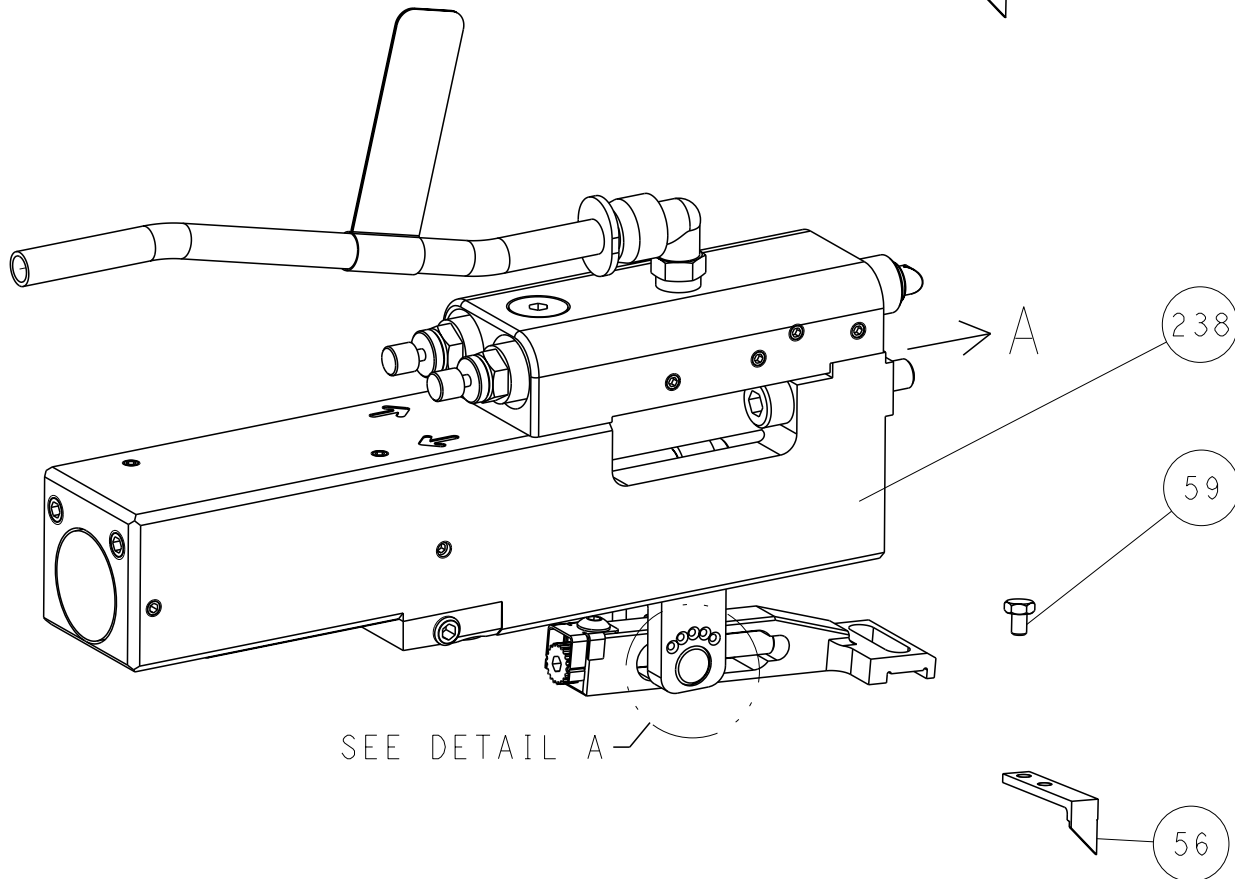
SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

LOC		DIST		REVISIONS					
A		66		P	LYR	DESCRIPTION	DATE	DWN	APVD
				-	-	SEE SHEET 1	-	-	-

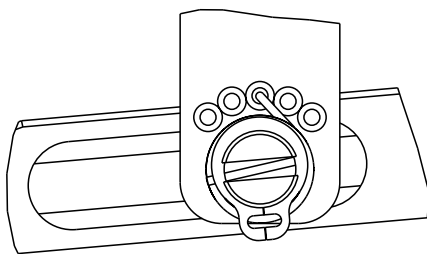
FEED TYPE MECHANICAL



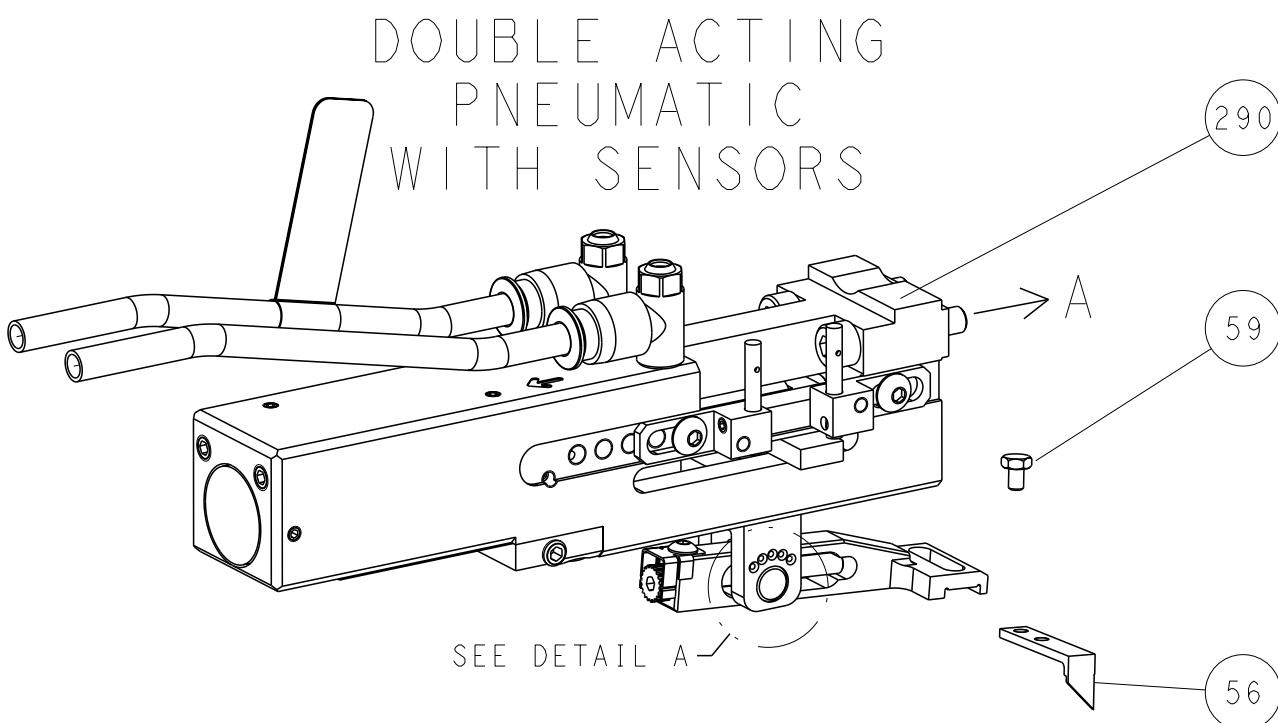
PNEUMATIC



FEED SPRING SETTING POSITION
(SHOWN FROM REAR SIDE)

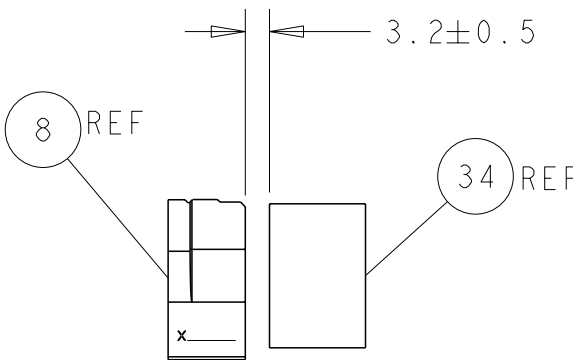
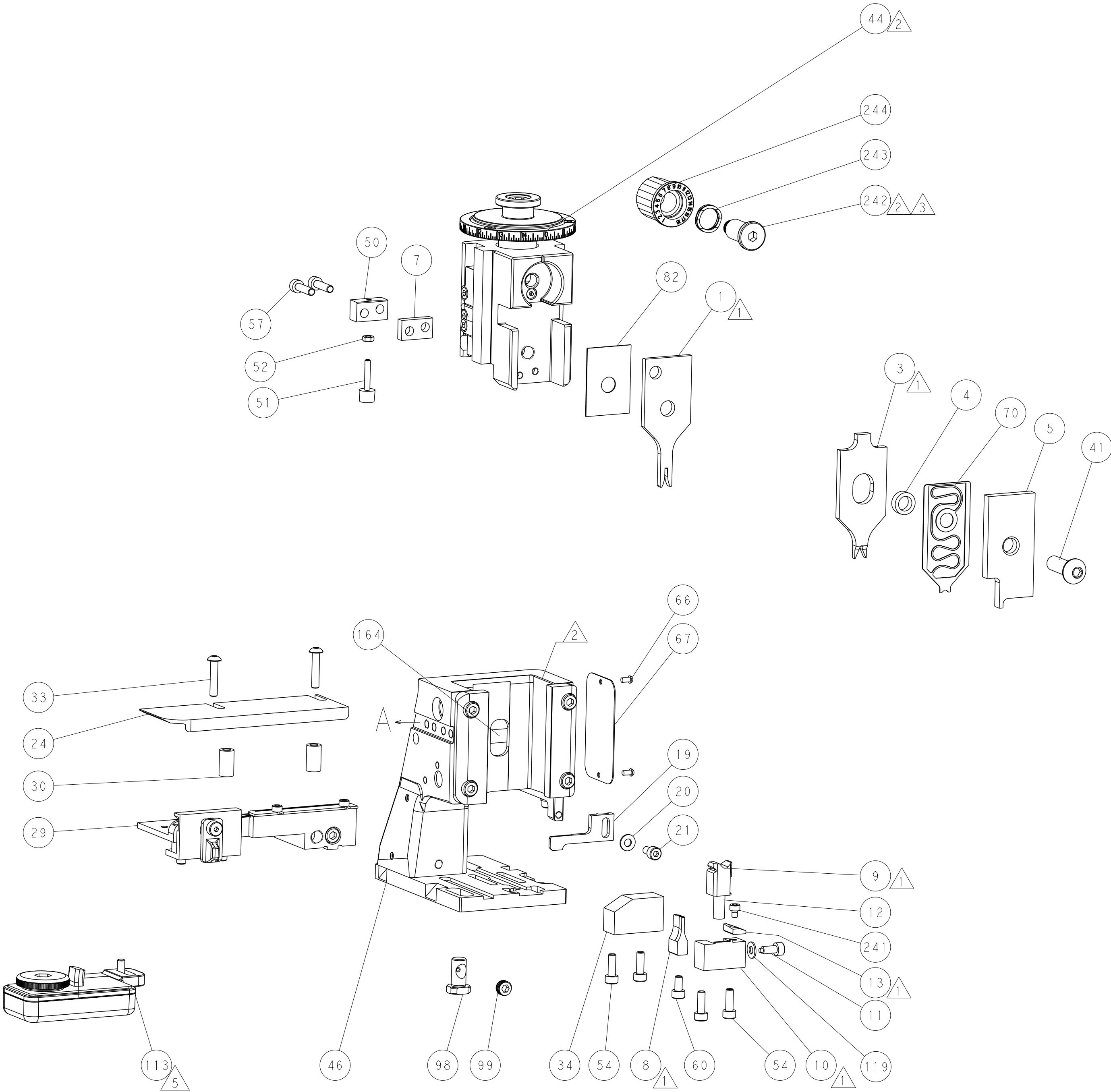
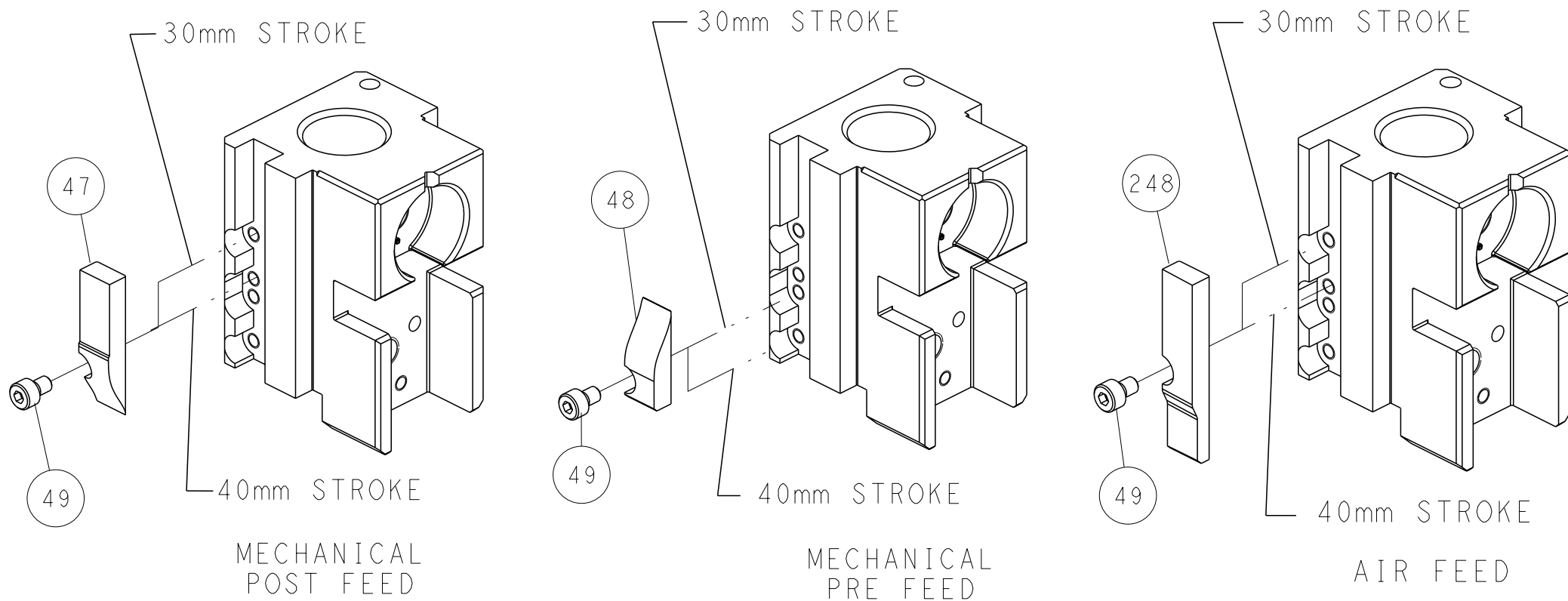


DETAIL A

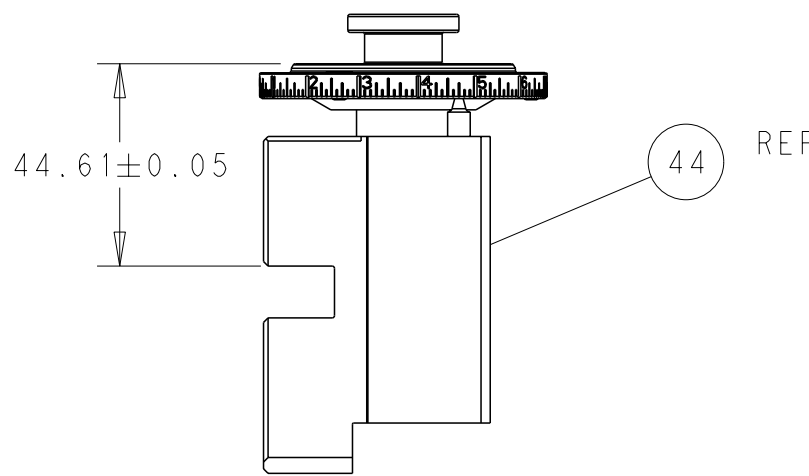


DOUBLE ACTING
PNEUMATIC
WITH SENSORS

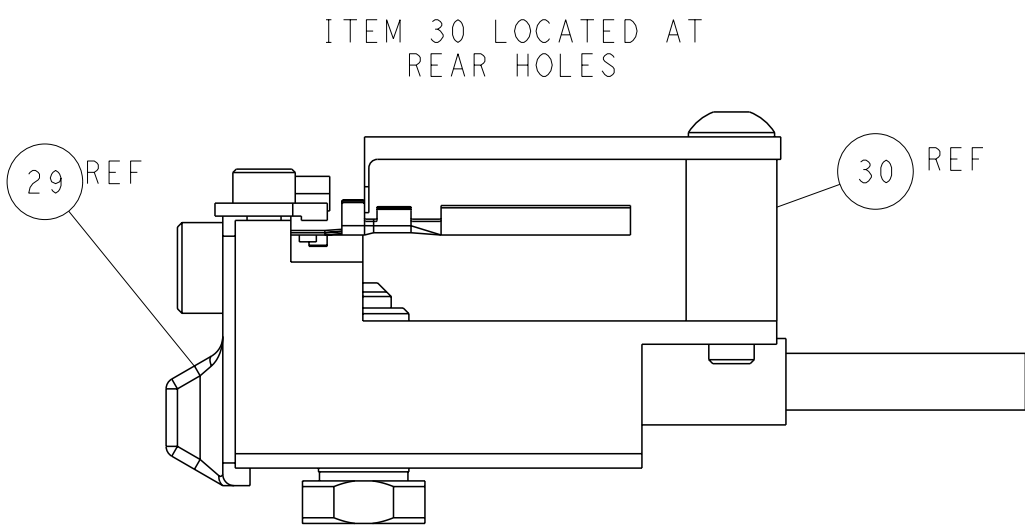
CAM POSITIONS



TERMINAL SUPPORT LOCATION



RAM SET-UP



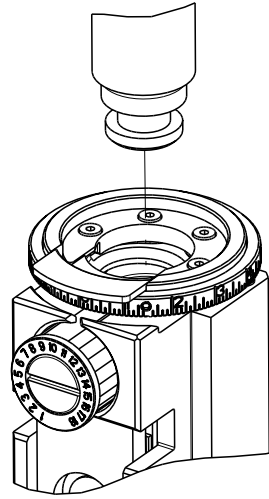
FEED TRACK POSITION
GUIDE BY INSULATION BARREL

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

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN	08SEP2011	TE Connectivity Harrisburg, PA 17105-3608	
mm		0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		CHK	08SEP2011		
FINISH		-		APVD	08SEP2011	NAME	
MATERIAL		-		PRODUCT SPEC		Ocean Side Feed Applicator	
				APPLICATION SPEC		SIZE	
				WEIGHT		CAGE CODE	
				Customer Accessible Production Drawing		DRAWING NO	
				SCALE		00779 ©=2151037	
				SHEET		2 of 4	
				REV		R	

8		7	
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20		20	
© COPYRIGHT 20		BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.	
PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2151037-1	P	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2151037-2	R	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
4-2151037-2	R	FINE CRIMP HEIGHT ADJUST	DOUBLE ACTING PNEUMATIC WITH SENSORS
7-2151037-7	N	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.40 mm [.055]	F
INSUL	1.83 mm [.072]	SP
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: MCP 1.2MM CONTACT ASSEMBLY			
WIRE STRIP LENGTH			INSULATION DIAMETER RANGE
3.30-3.90 mm [.130-.154 IN]			Ø1.40-1.90 mm [.055-.075 IN]
TERMINAL APPLICATION SPECIFICATION		114-18464	- - -
TERMINALS APPLIED 			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
1452656-1	1452656-2	1452656-3	6-1452656-2
7-1452656-1	7-1452656-2	7-1452656-3	
1718350-1	1718350-2	1718350-3	

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.75mm2	1.05+/-0.03 [.041+/-0.001]	6.5
0.50mm2	0.93+/-0.03 [.037+/-0.001]	7.5
20 AWG	0.93+/-0.03 [.037+/-0.001]	7.5



- 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 TERMINAL LUBRICANT IS RECOMMENDED.
- 6 THIS APPLICATOR IS EQUIPPED WITH THE DOUBLE ACTING FEED WITH SENSORS AND IS APPLICATION SPECIFIC. IT DOES NOT REQUIRE ITEMS 49 & 151.
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)

SET UP GAUGE 2119599-1		LOC A	DIST 66	REVISIONS			
P	LYR	DESCRIPTION		DATE	DWN	APVD	
	-	SEE SHEET 1		-	-	-	

-	1	-	-	2844950-1	AIR FEED MODULE	290
-	1	1	1	2119082-5	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	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	-	1	-	2844940-1	AIR FEED MODULE	238
-	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	-	1	-	2119641-2	FEED CAM, AIR FEED	151
-	1	1	1	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	144
-	4	4	4	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	143
-	-	-	1	2119653-2	FEED CAM, POST FEED	142
-	1	1	1	1-1803583-0	APPLICATOR BASIC ASSEMBLY, SF	141
-	1	1	1	1803516-1	RAM ASSEMBLY, SF PACIFIC	140
-	1	1	1	1-18028-2	WASHER, FLAT, REG M4	119
-	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	455888-5	SPACER, CRIMPER	82
-	1	1	1	1803607-3	DOCUMENTATION PACKAGE	71
-	1	1	1	2119791-5	DEPRESSOR, WIRE	70
-	1	1	1	2119740-1	TAG, IDENTIFICATION	67
-	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	1	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	2	2	2	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	57
-	1	1	1	1338685-1	PAWL, FEED	56
-	1	1	1	5018030-1	NUT, HEX, REG, RoHS, M3	52
-	1	1	1	811242-5	BUMPER, HOLD DOWN	51
-	1	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	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
-	1	1	1	1752356-6	SUPPORT, TERMINAL	34
-	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	2	2-2844962-6	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	1	2844992-2	ASSEMBLY, STRIP GUIDE	29
-	1	1	1	1320928-6	STRIP GUIDE	24
-	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
-	1	1	1	1-18028-2	WASHER, FLAT, REG M4	20
-	1	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	1	1	1	1333231-9	ANVIL, COMBINATION, SPECIAL	8
-	1	1	1	5-240641-0	SPACER	7
-	1	1	1	2119757-8	DEPRESSOR, SHEAR	5
-	1	1	1	4-238011-2	BLOCK, CRIMPER SPACER	4
1	1	1	1	1633989-1	CRIMPER, INSULATION, SPECIAL	3
1	1	1	1	3-456402-3	CRIMPER, WIRE PREMIUM	1
-77	-42	-22	-21	PART NO	DESCRIPTION	ITEM NO

THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE AND TO BE CONTROLLED BY THE ENGINEERING ORGANIZATION. IT SHOULD BE CONTACTED FOR THE LATEST REVISION.				DWN S. CHEN CHK S. XI APVD J. CRUZ	08SEP2011 08SEP2011 08SEP2011	TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		NAME		Ocean Side Feed Applicator	
mm		0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ±		PRODUCT SPEC		SIZE	
MATERIAL		FINISH		APPLICATION SPEC		CAGE CODE	
-		-		WEIGHT		DRAWING NO	
-		-		Customer Accessible Production Drawing		RESTRICTED TO	
-		-		SCALE		SHEET 3 OF 4	
-		-		REV		R	

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

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

D

C

B

A

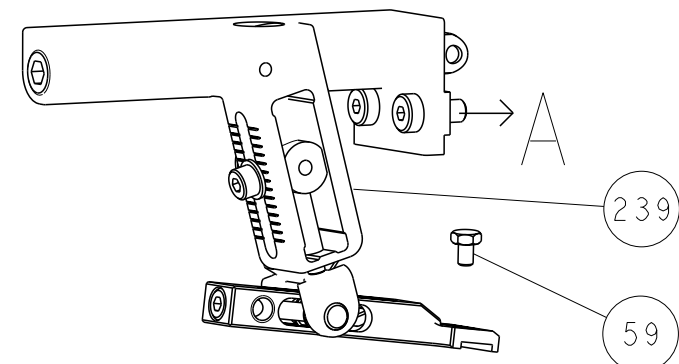
D

C

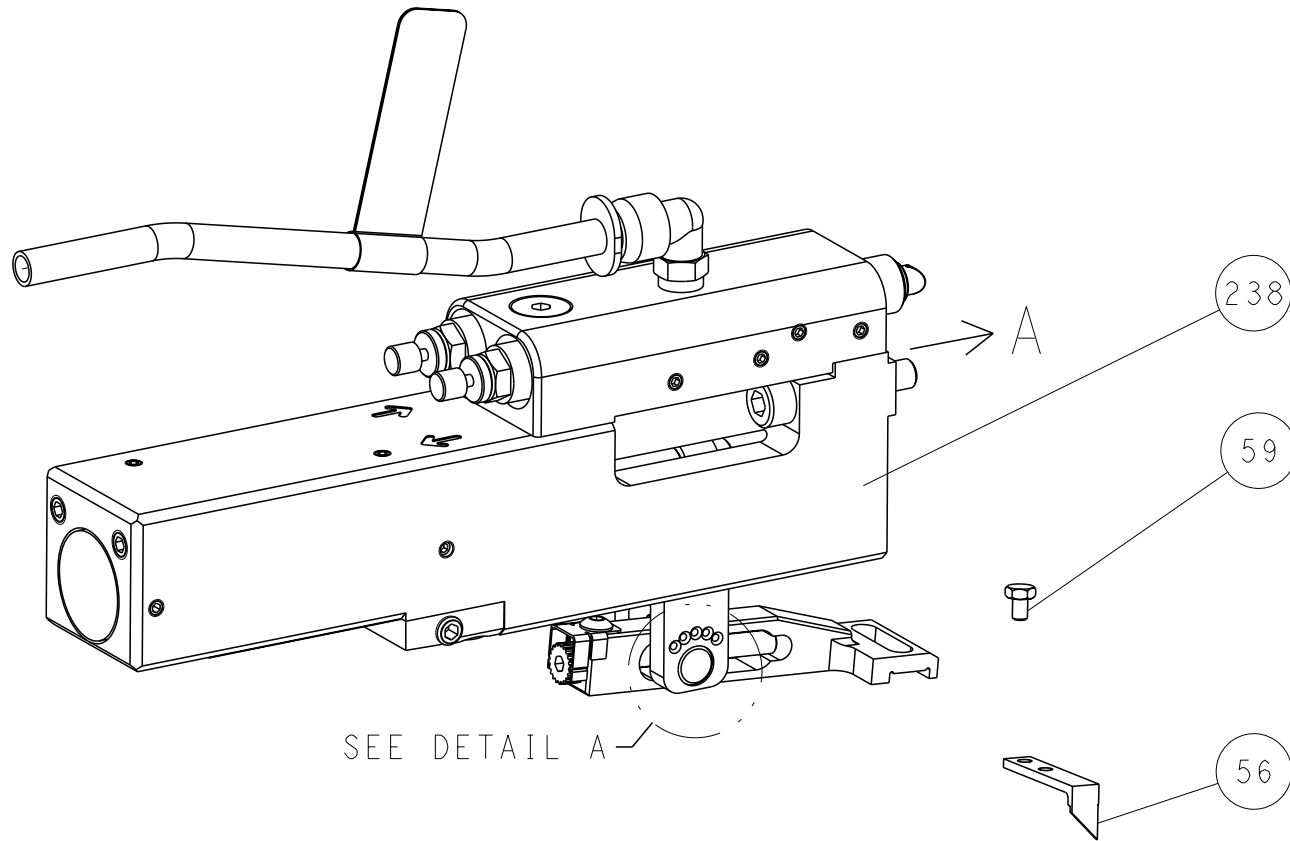
B

A

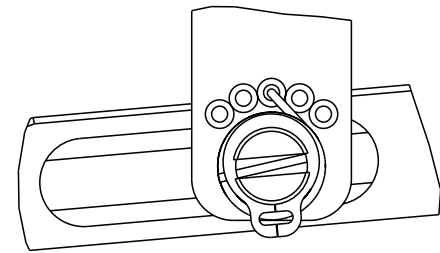
FEED TYPE MECHANICAL



PNEUMATIC

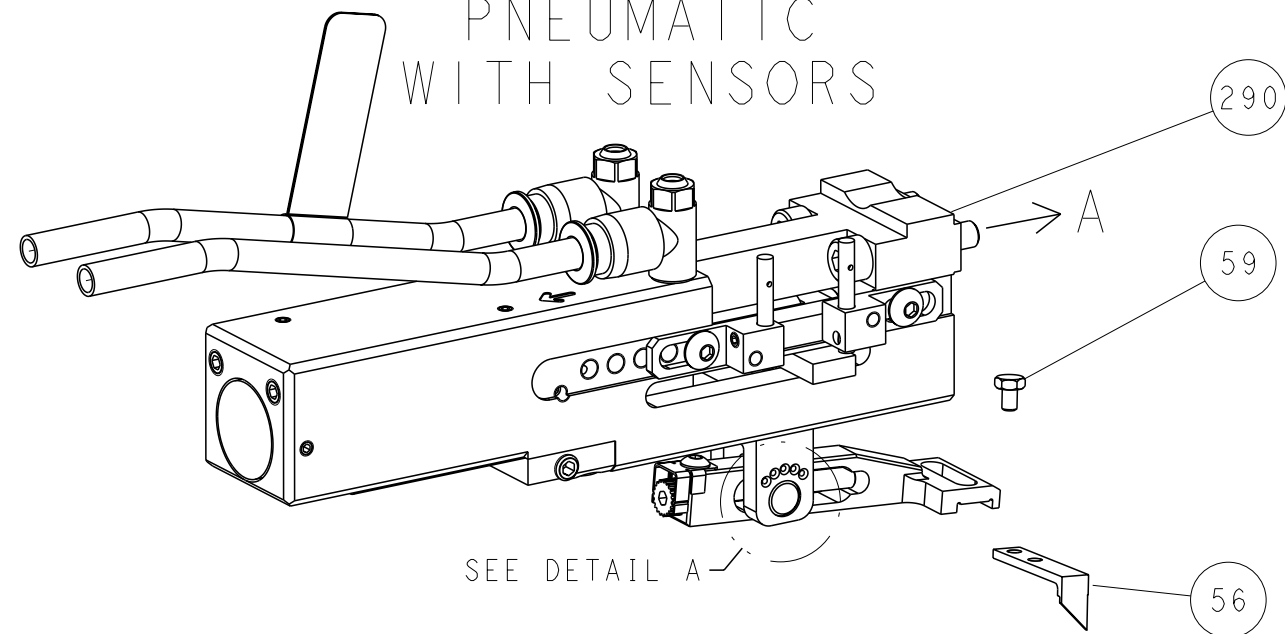


FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)

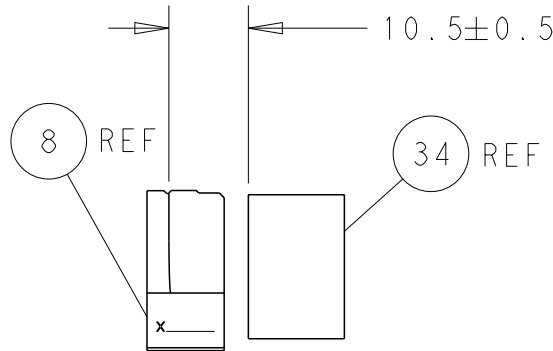
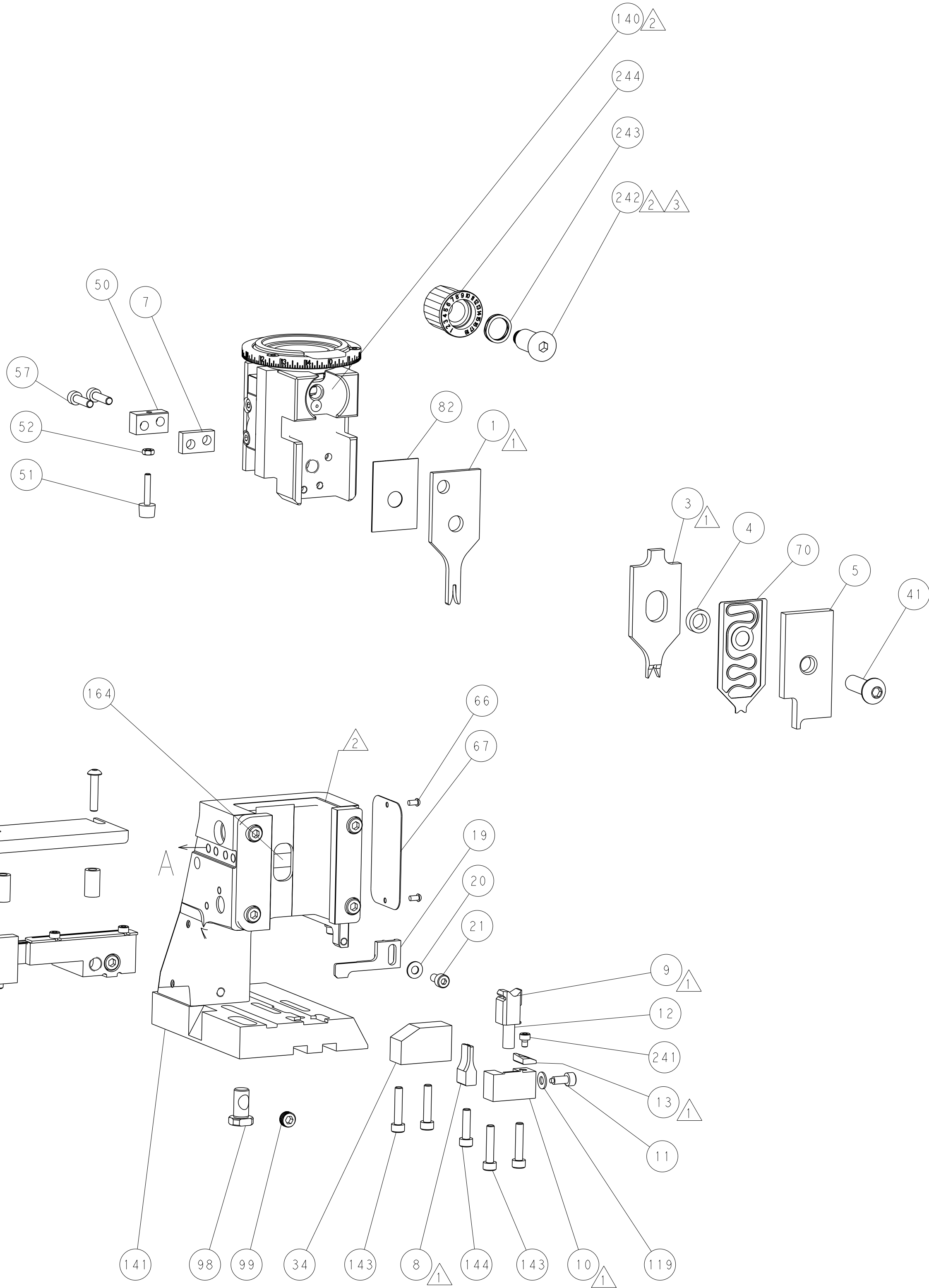
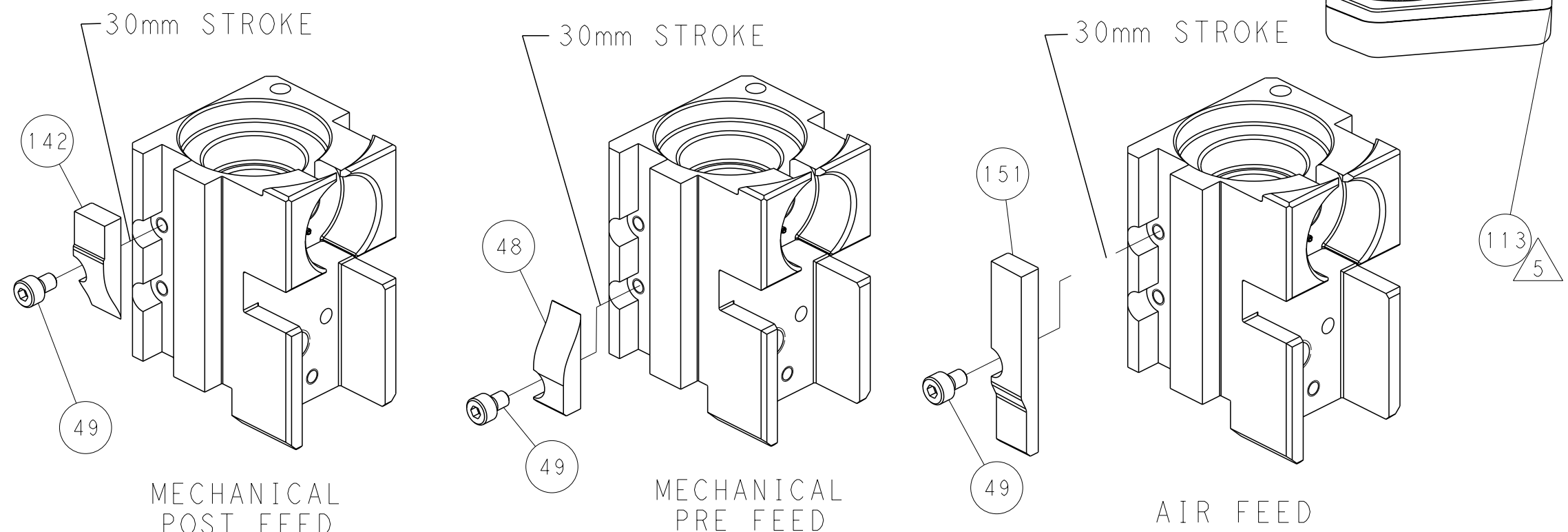


DETAIL A

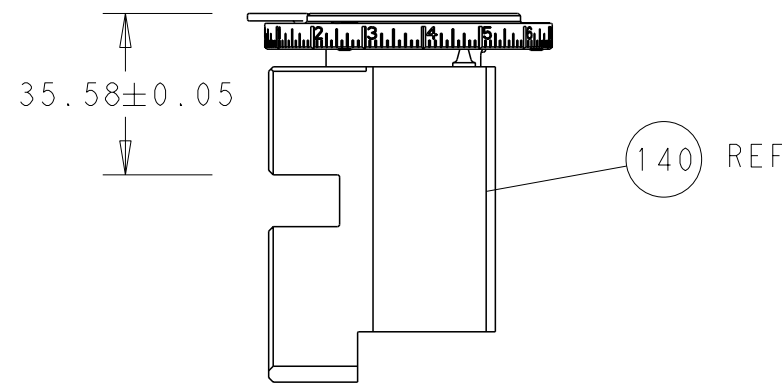
DOUBLE ACTING PNEUMATIC WITH SENSORS



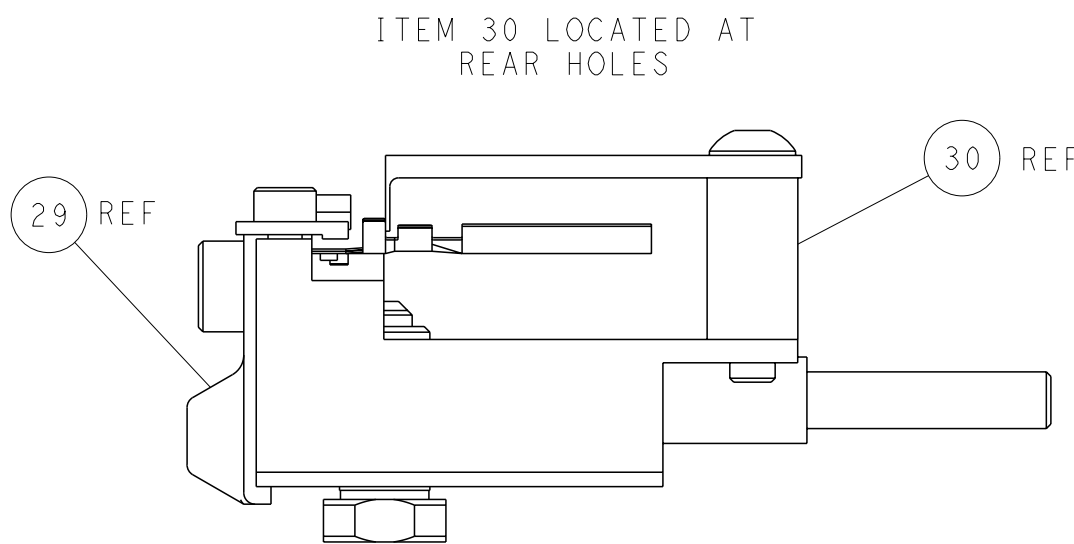
CAM POSITIONS



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)

1:11 DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION IT IS SUBJECT TO CHANGE AND TO CONTROL AND ENGINEERING ORGANIZATION SHALL BE CONTACTED FOR THE LATEST REVISION		DWN C. CHEN CHK S. XI APVD J. CRUZ	08SEP2011 08SEP2011 08SEP2011	TE Connectivity Harrisburg, PA 17105-3608		
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH		NAME Ocean Side Feed Applicator		
MATERIAL -		WEIGHT -		SIZE A1		
				CAGE CODE DRAWING NO 00779 C=2151037		
				Customer Accessible Production Drawing		
				SCALE 1:2		
				SHEET 4		
				OF 4		
				REV R		