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THIS DRAWING IS UNPUBLISHED.

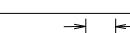
RELEASED FOR PUBLICATION

2011

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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151470-1	M	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2151470-2	M	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
5-2151470-1	M	SEAL STRIPPER CRIMPER TERMINATING UNIT	MECHANICAL
5-2151470-2	M	SEAL STRIPPER CRIMPER TERMINATING UNIT	PNEUMATIC
7-2151470-1	M	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2151470-2	M	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2151470-7	M	CRIMP TOOLING KIT	-

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.27 mm [.050]	F
INSUL	1.78 mm [.070]	O
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: 1.2MM CONTACT ASSEMBLY (CLEAN BODY)			
WIRE STRIP LENGTH			INSULATION DIAMETER RANGE
2.60-3.20 mm [.102-.126 IN]			Ø1.10-1.75 mm [.043-.069 IN]
TERMINAL APPLICATION SPECIFICATION		114-18464	-
		-	-
TERMINALS APPLIED		-	-
			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
1534594-1	1534594-2	1534594-3	

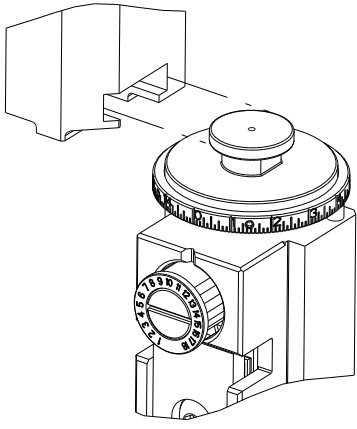
WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
22 AWG	0.86+/-0.03 [.034+/- .001]	8.6
0.35 mm2	0.81+/-0.03 [.032+/- .001]	9.0
24 AWG	0.80+/-0.03 [.031+/- .001]	9.2



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

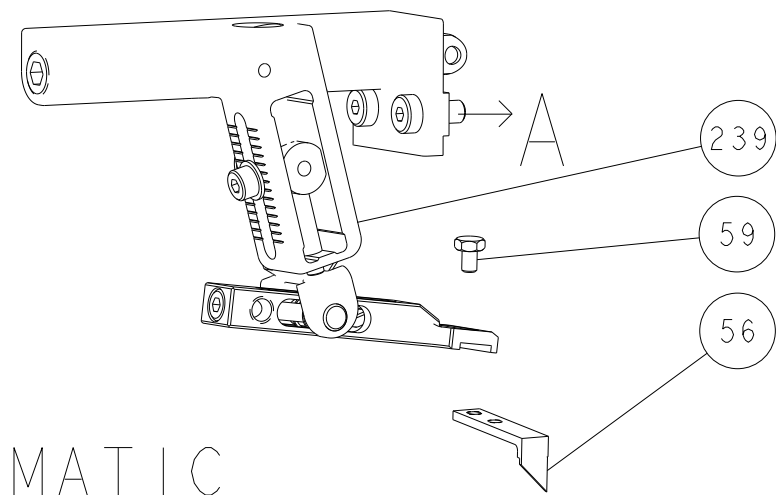
2		1							
LOC	DIST	REVISIONS							
A	66	DESCRIPTION				DATE	DWN	APVD	
		P	LTR						
			K	ECR-19-005049			29MAR2019	LG	TE
			L	ECR-20-013397			21SEP2020	TB	RK
			L1	ECR-21-006034			04JUN2021	LJ	YY
			M	ECR-21-006929			19JUL2021	FZ	MP

-	-	-	1	1	-	-	1803515-3	RAM ASSEMBLY, SF ATLANTIC	293
-	-	-	1	1	-	-	2-1803583-1	APPLICATOR BASIC ASSEMBLY, SF	292
-	1	-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248
-	1	1	1	1	1	1	2119082-8	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	-	2844940-1	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	-	-	1-1752354-7	STANDOFF,HOLD-DOWN	180
-	-	-	1	1	-	-	9931111-1	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
-	REF	REF	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	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	455888-5	SPACER, CRIMPER	82
-	1	1	1	1	1	1	1803607-3	DOCUMENTATION PACKAGE	71
-	1	1	1	1	1	1	2119791-5	DEPRESSOR, WIRE	70
-	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	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	2-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 14	53
-	1	1	1	1	1	1	1803382-6	HOLD DOWN, SPRING LOADED	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	1752356-6	SUPPORT, TERMINAL	34
-	2	2	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	2	2	2	2	2-2844962-6	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	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	1	1320928-2	STRIP GUIDE	24
-	1	1	-	-	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
-	2	2	1	1	2	2	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	1803095-3	FLOATING SHEAR, FRONT	9
1	2	2	1	1	1	1	9-1333225-0	ANVIL, COMBINATION	8
-	1	1	1	1	1	1	5-240641-0	SPACER	7
-	1	1	1	1	1	1	2119757-8	DEPRESSOR, SHEAR	5
-	1	1	1	1	1	1	238011-4	BLOCK, CRIMPER SPACER	4
1	2	2	1	1	1	1	1633965-8	CRIMPER, INSULATION O PREMIUM	3
-	1	1	1	1	1	1	455888-3	SPACER, CRIMPER	2
1	2	2	1	1	1	1	6-1752057-1	CRIMPER, WIRE PREMIUM, STEPPED	1

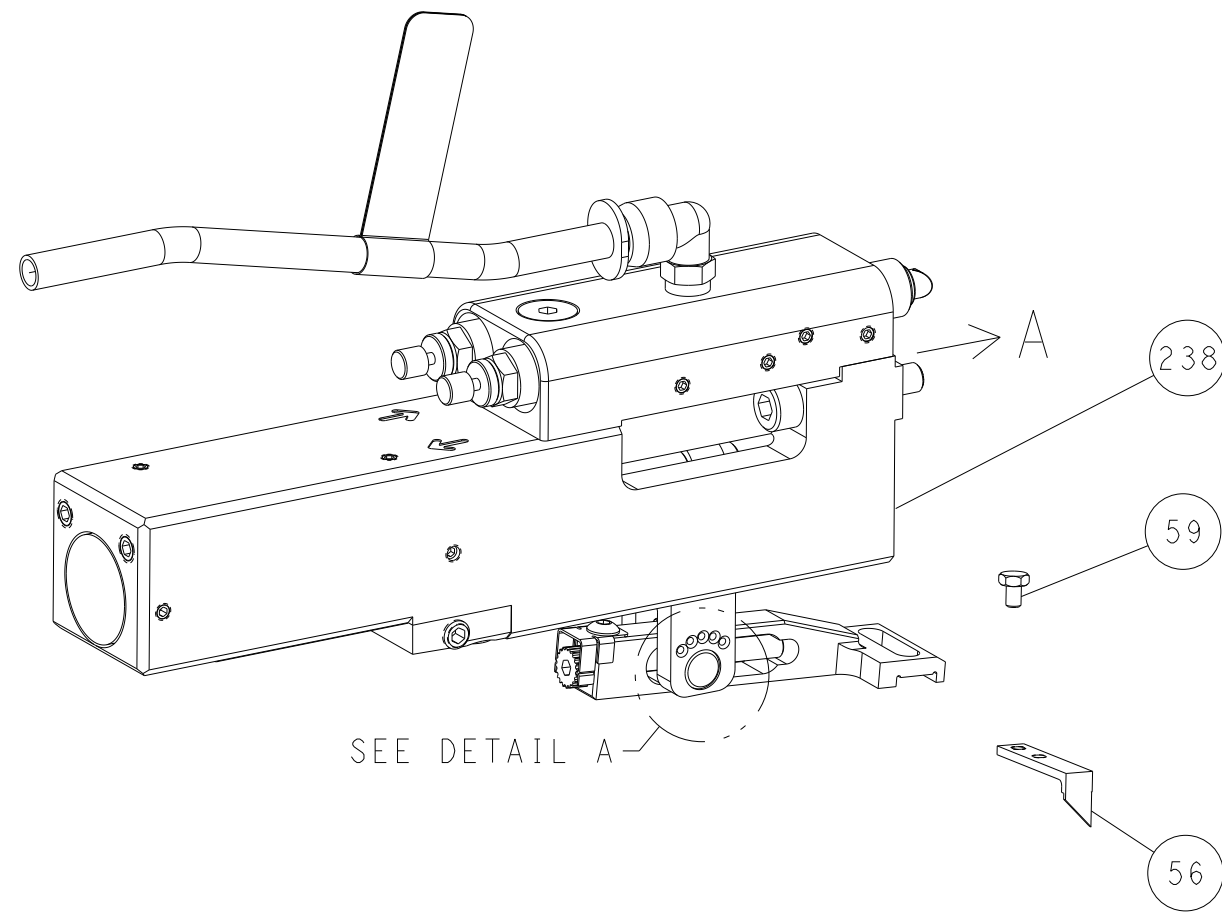
-77	-72	-71	-52	-51	-2	-1	PART NO	DESCRIPTION	ITEM NO
THIS DRAWING IS UNPUBLISHED. IT IS THE POLICY OF TYCO ELECTRONICS CORPORATION TO CONTINUE TO DEVELOP AND IMPROVE ITS PRODUCTS. THE USER SHOULD BE CONTACTED FOR THE LATEST EDITION.							DWN B. WEAVER 25AUG2011	TE Connectivity Harrisburg, PA 17105-3608	
							CHK C. MOYER		
DIMENSIONS:							APVD T. ELBIN 25AUG2011	NAME Ocean Side Feed Applicator	
mm							PRODUCT SPEC		
							APPLICATION SPEC		
MATERIAL							WEIGHT	SIZE A1	CAGE CODE 00779
								DRAWING NO C=2151470	RESTRICTED TO -
							Customer Accessible Production Drawing	SCALE 1:2	SHEET 1 OF 4
								REV M	

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

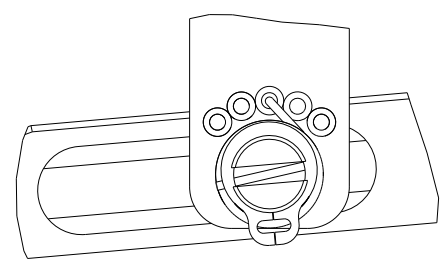
FEED TYPE MECHANICAL



PNEUMATIC

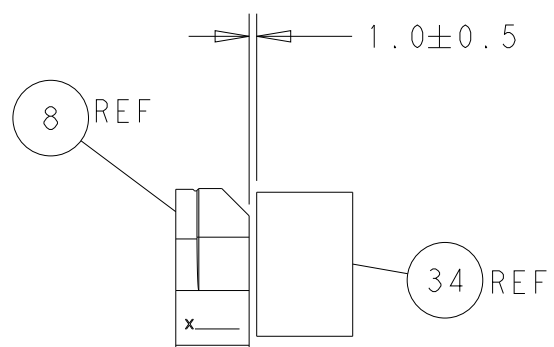
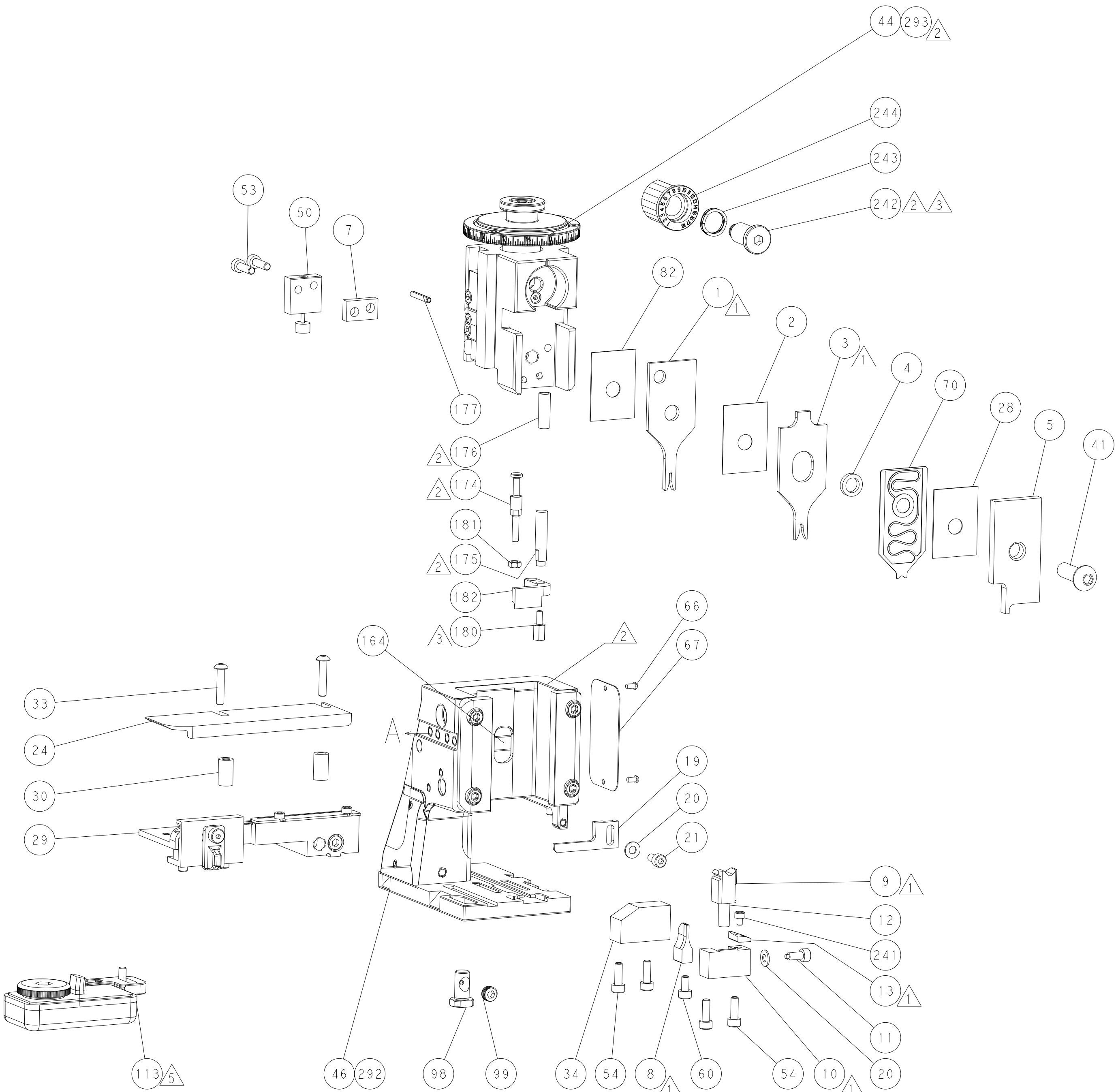
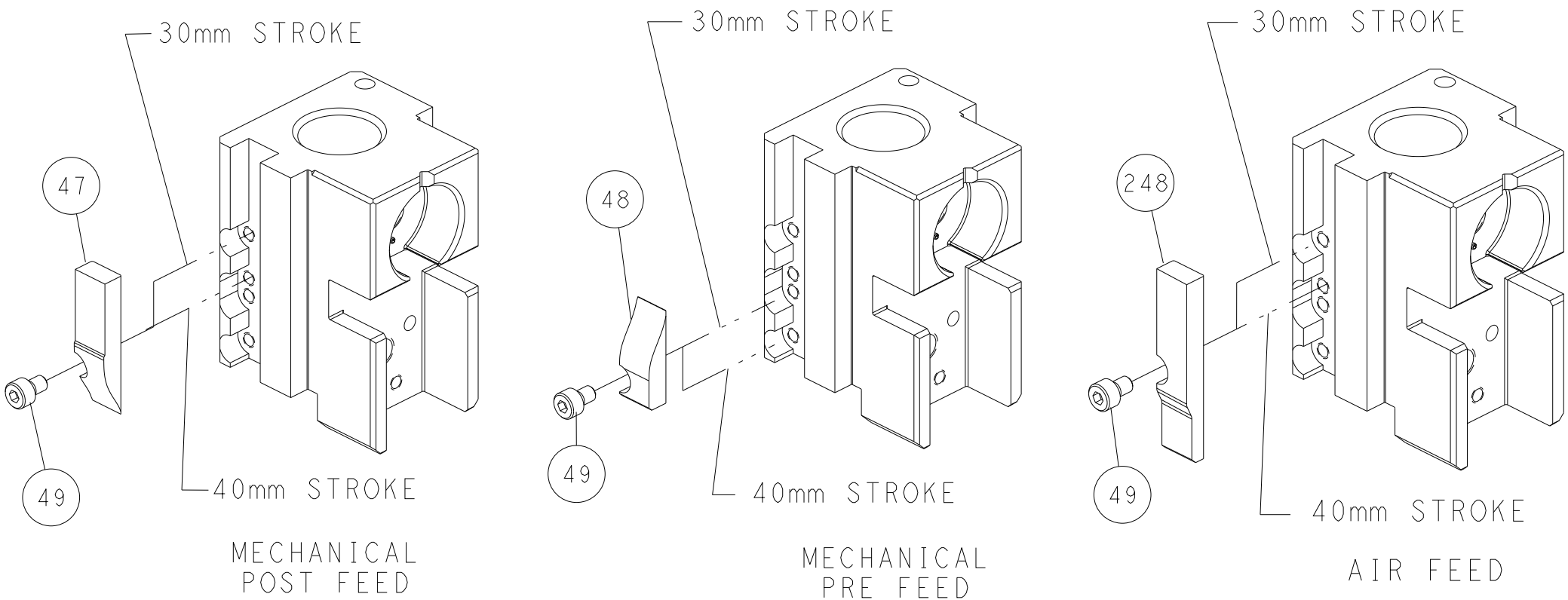


FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)

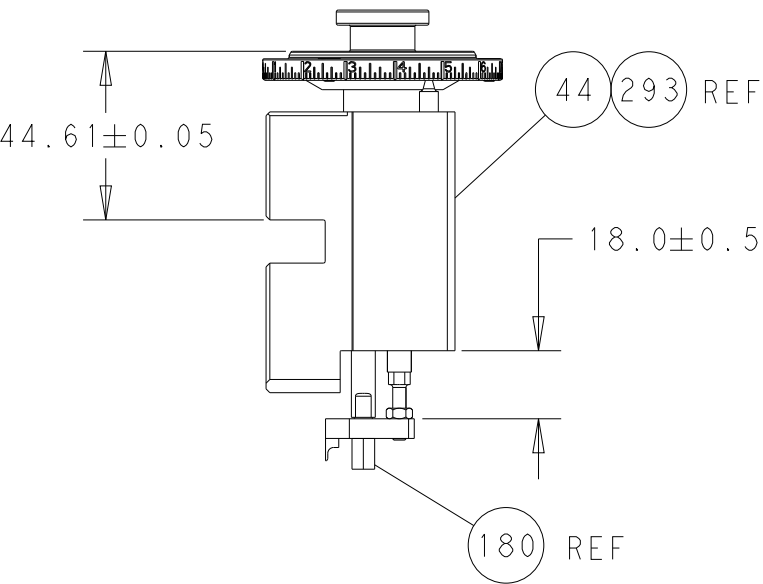


DETAIL A

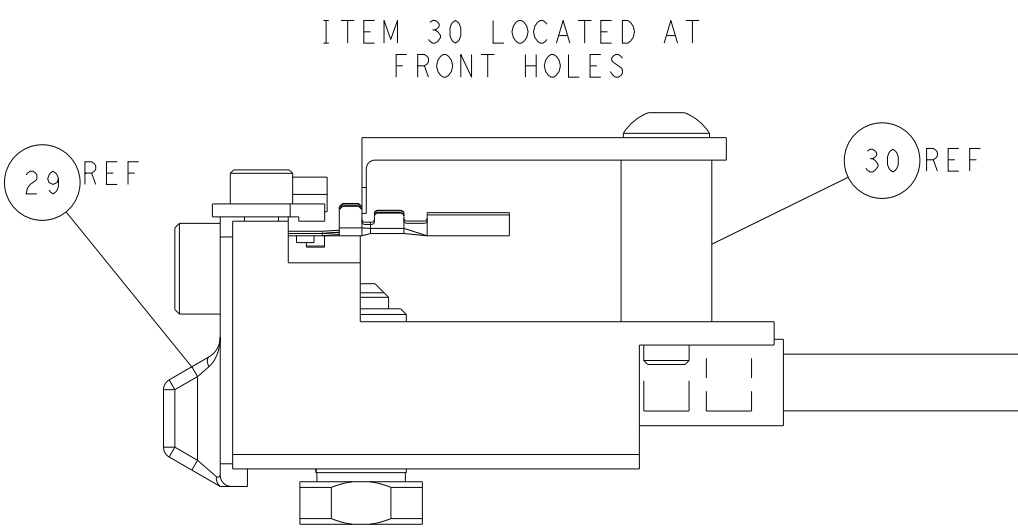
CAM POSITIONS



TERMINAL SUPPORT LOCATION



RAM AND HOLD DOWN SET-UP



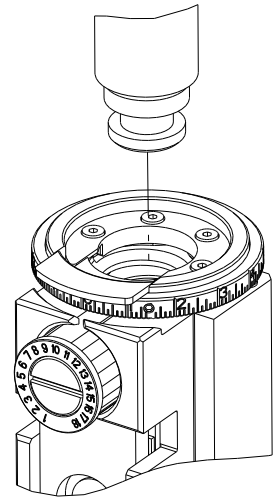
FEED TRACK POSITION
GUIDE BY INSULATION BARREL

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

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				CHK C. MOYER 25AUG2011		
				APVD T. ELBIN 25AUG2011	NAME Ocean Side Feed Applicator	
				PRODUCT SPEC		
				APPLICATION SPEC		
				WEIGHT		
				Customer Accessible Production Drawing		
				SCALE 1:2		
				SHEET 2		
				OF 4		
				REV M		

8		7	
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2011		2011	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2151470-1	M	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2151470-2	M	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151470-7	M	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.27 mm [.050]	F
INSUL	1.78 mm [.070]	O
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: 1.2MM CONTACT ASSEMBLY (CLEAN BODY)			
WIRE STRIP LENGTH 2.60-3.20 mm [.102-.126 IN]			INSULATION DIAMETER RANGE Ø1.10-1.75 mm [.043-.069 IN]
TERMINAL APPLICATION SPECIFICATION	114-18464	-	-
TERMINALS APPLIED 			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
1534594-1	1534594-2	1534594-3	

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
22 AWG	0.86+/-0.03 [.034+/- .001]	8.6
0.35 mm2	0.81+/-0.03 [.032+/- .001]	9.0
24 AWG	0.80+/-0.03 [.031+/- .001]	9.2

*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.

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

ENTRY LEVEL APPLICATOR		ITEM SUBSTITUTION LIST		
PART NUMBER	SAME AS	ITEM	ITEM DESCRIPTION	SUBSTITUTE PART NUMBER
8-2151470-1	2151470-1	1	WIRE CRIMPER	6-1803621-1
8-2151470-2	2151470-2	3	INSULATION CRIMPER	1803624-8
9-2151470-1	2-2151470-1	46	BASIC SUB -ASSEMBLY	1803940-9
9-2151470-2	2-2151470-2	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)

LOC		DIST		REVISONS				
A	66	P	LTR	DESCRIPTION	DATE	DWN	APVD	
		-		SEE SHEET 1	-	-	-	

-	1	1	2119082-8	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	-	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	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113
-	1	1	2844908-1	SCREW, LOCKING	99
-	1	1	2844907-1	POST, LOCKING	98
-	1	1	455888-5	SPACER, CRIMPER	82
-	1	1	1803607-3	DOCUMENTATION PACKAGE	71
-	1	1	2119791-5	DEPRESSOR, WIRE	70
-	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	2-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 14	53
-	1	1	1803382-6	HOLD DOWN, SPRING LOADED	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	1752356-6	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	455888-5	SPACER, CRIMPER	28
-	1	1	1320928-2	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	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	1803095-3	FLOATING SHEAR, FRONT	9
1	1	1	9-1333225-0	ANVIL, COMBINATION	8
-	1	1	5-240641-0	SPACER	7
-	1	1	2119757-8	DEPRESSOR, SHEAR	5
-	1	1	238011-4	BLOCK, CRIMPER SPACER	4
1	1	1	1633965-8	CRIMPER, INSULATION O PREMIUM	3
-	1	1	455888-3	SPACER, CRIMPER	2
1	1	1	6-1752057-1	CRIMPER, WIRE PREMIUM, STEPPED	1

THIS DOCUMENT IS A CONTROLLED DOCUMENT FOR THE EXCLUSIVE USE OF THE CUSTOMER. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. THE CUSTOMER SHOULD BE CONTACTED FOR THE LATEST EDITION.		DWN B. WEAVER 25AUG2011	PART NO		DESCRIPTION		ITEM NO
DIMENSIONS: mm		CHK C. MOYER 25AUG2011	NAME		Ocean Side Feed Applicator		
TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH		APVD T. ELBIN 25AUG2011	PRODUCT SPEC		SIZE CASE CODE DRAWING NO		
MATERIAL		APPLICATION SPEC		WEIGHT		RESTRICTED TO	
-		-		-		-	
Customer Accessible Production Drawing		SCALE 1:2		SHEET 3 OF 4		REV M	

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

DETAIL A

30mm STROKE

142

49

MECHANICAL POST FEED

30mm STROKE

48

49

MECHANICAL PRE FEED

30mm STROKE

151

49

AIR FEED

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

[illegible]

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

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Authorized Distributor

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[2151470-1](#)