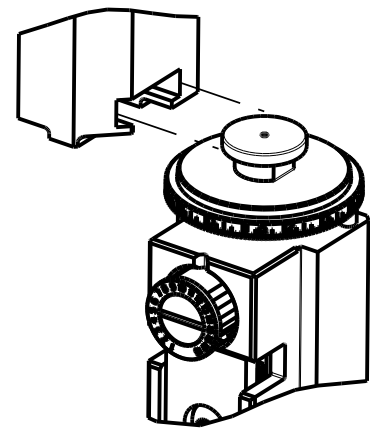
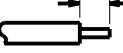


8		7	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151478-1	E	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2151478-2	F	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
3-2151478-2	F	FINE CRIMP HEIGHT ADJUST	DOUBLE ACTING PNEUMATIC WITH SENSORS
7-2151478-1	E	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2151478-2	F	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2151478-7	C	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: MCON-1.2 LL			
WIRE STRIP LENGTH			INSULATION DIAMETER RANGE
3.30-3.90 mm [.130-.154 IN]			Ø1.40-1.60 mm [.055-.063 IN]
TERMINAL APPLICATION 		114-18464 	-
SPECIFICATION		-	-
TERMINALS APPLIED 			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
1563888-1			
WIRE SIZE 	CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING 
0.50mm2	0.86+/-0.03 [.034+/- .001]		7.8 



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. MAXIMUM INSULATION CRIMP WIDTH 2.05mm & MAXIMUM INSULATION CRIMP HEIGHT 2.05mm. SEE APPLICATION SPECIFICATION TO CLARIFY.
6. TERMINAL LUBRICANT IS RECOMMENDED.
7. THIS APPLICATOR IS EQUIPPED WITH THE DOUBLE ACTING FEED WITH SENSORS AND IS APPLICATION SPECIFIC. IT DOES NOT REQUIRE ITEMS 49 & 248.
8. 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)

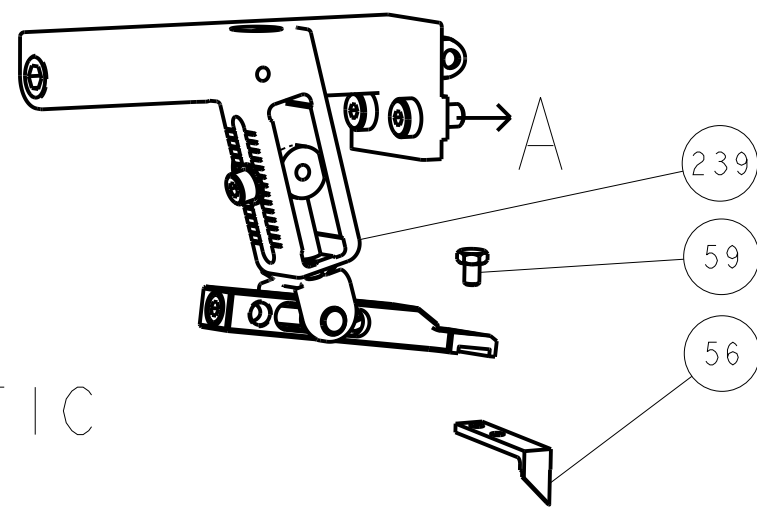
LOC		DIST		REVISONS			
A		66		P	LTR	DESCRIPTION	DATE
							DWN
							APVD
				D1		ECR-18-002454	19FEB2018
				E		ECR-18-008490	04JUN2018
				F		ECR-19-010974	15JUL2019
				F1		ECR-21-005485	17MAY2021

7	-	-	-	1	-	-	2844950-1	AIR FEED MODULE	290
	-	1	-	-	1	-	2119641-1	FEED CAM, AIR FEED	248
	-	1	1	1	1	1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244
	-	1	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
3	-	1	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
6	-	1	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
	-	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
	-	2	2	2	2	2	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	53
	-	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
7	-	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	1-1752356-8	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	1320928-2	STRIP GUIDE	24
	-	1	1	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
	-	2	2	2	2	2	1-18028-2	WASHER, FLAT, REG M4	20
	-	1	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	3-22280-3	SPRING, COMPRESSION	12
	-	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	1	2	2	1	1	1	1333231-4	ANVIL, COMBINATION, SPECIAL	8
	-	1	1	1	1	1	240641-4	SPACER	7
	-	-	-	-	-	-	-	-	6
	-	1	1	1	1	1	2119757-8	DEPRESSOR, SHEAR	5
	-	1	1	1	1	1	238011-9	BLOCK, CRIMPER SPACER	4
1	1	2	2	1	1	1	1-1633989-5	CRIMPER, INSULATION, SPECIAL	3
	-	-	-	-	-	-	-	-	2
1	1	2	2	1	1	1	3-456402-3	CRIMPER, WIRE PREMIUM	1
	-77	-72	-71	-32	-2	-1	PART NO	DESCRIPTION	ITEM NO

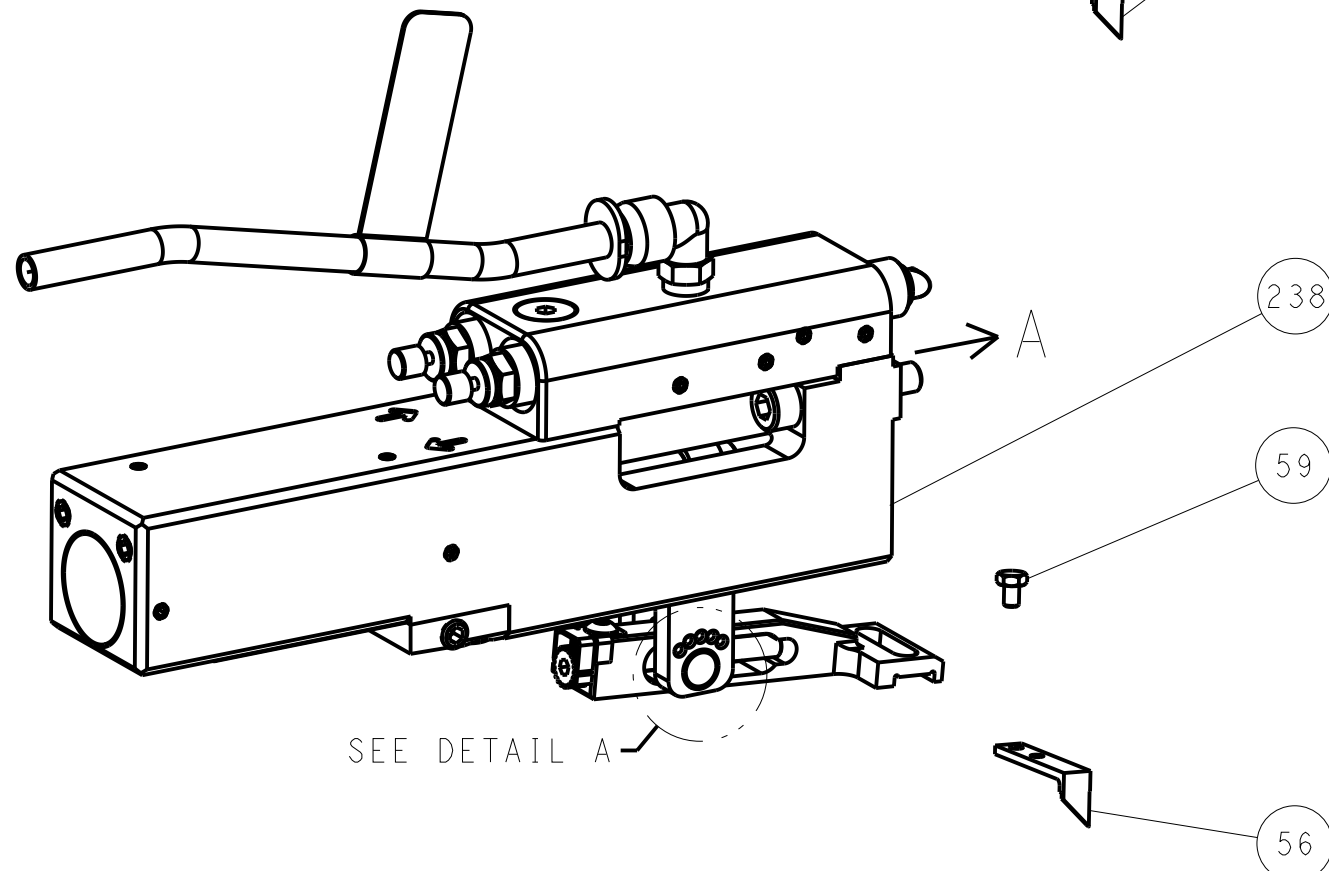
THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE AND TO BE CONTROLLED BY THE ORGANIZATION THAT ISSUED IT. ANY REVISIONS SHOULD BE CONTACTED FOR THE LATEST EDITION.				DWN A. HUANG	27AUG2012	TE Connectivity Harrisburg, PA 17105-3608	
CHK S. XI				APVD S. XI	27AUG2012	NAME Ocean Side Feed Applicator	
DIMENSIONS: mm				TOLERANCES UNLESS OTHERWISE SPECIFIED:		PRODUCT SPEC	
				0 PLC ±		APPLICATION SPEC	
				1 PLC ±		SIZE	
				2 PLC ±		CAGE CODE	
				3 PLC ±		DRAWING NO	
				4 PLC ±		RESTRICTED TO	
				ANGLES		100779	
				FINISH		C=2151478	
MATERIAL				WEIGHT		Customer Accessible Production Drawing	
						SCALE 1:2	
						SHEET 1 OF 4	
						REV F1	

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

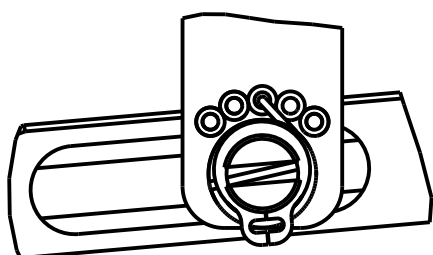
FEED TYPE MECHANICAL



PNEUMATIC

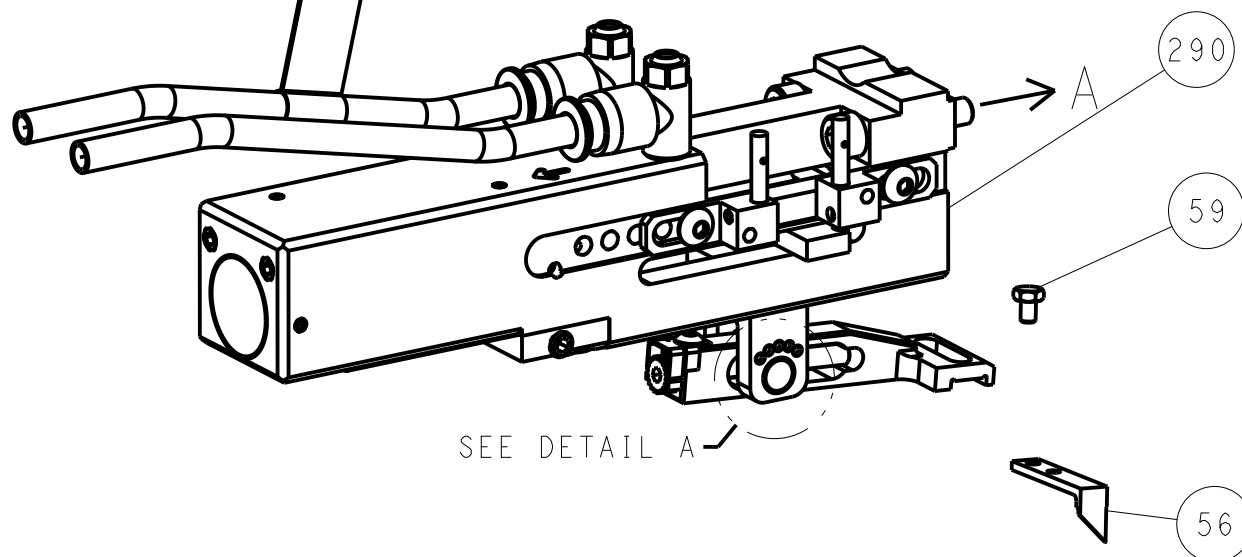


FEED SPRING SETTING POSITION
(SHOWN FROM REAR SIDE)

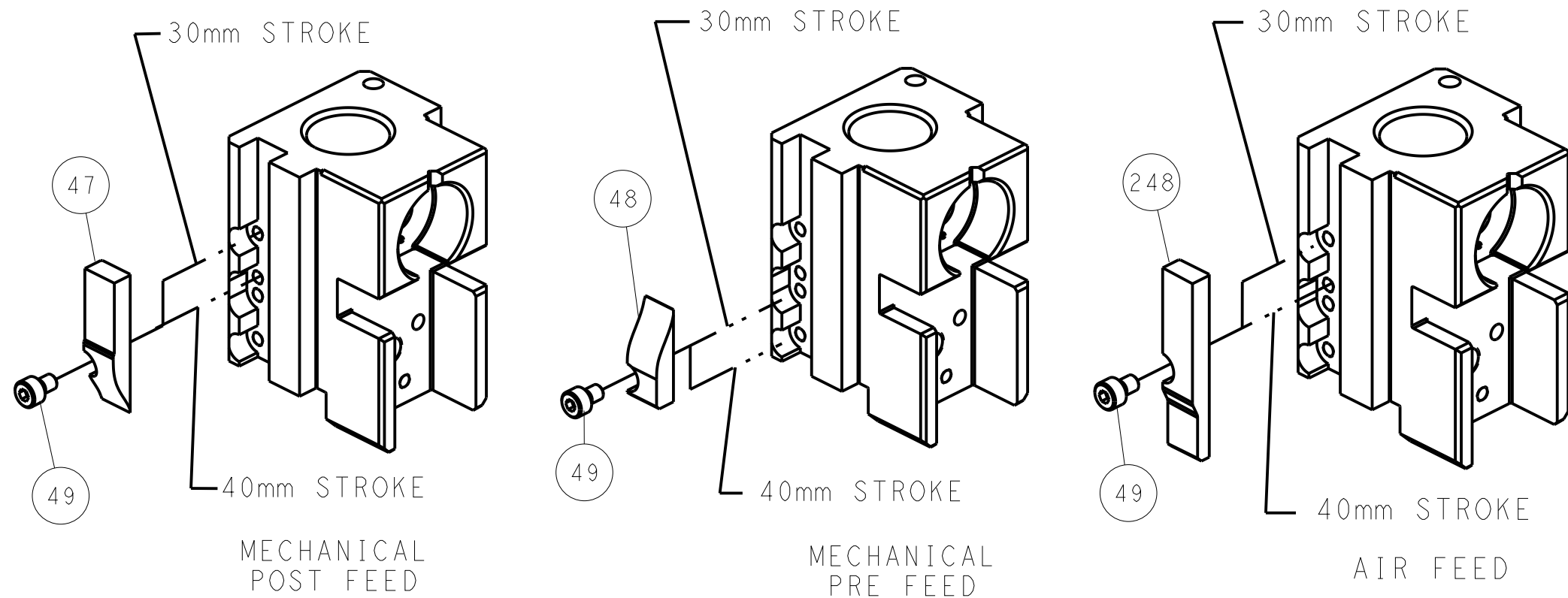


DETAIL A

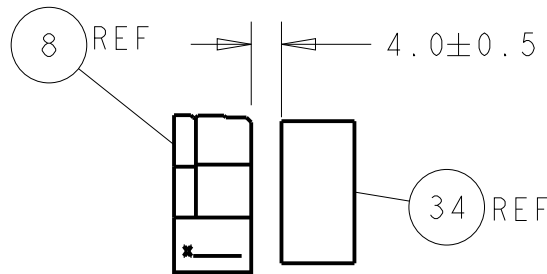
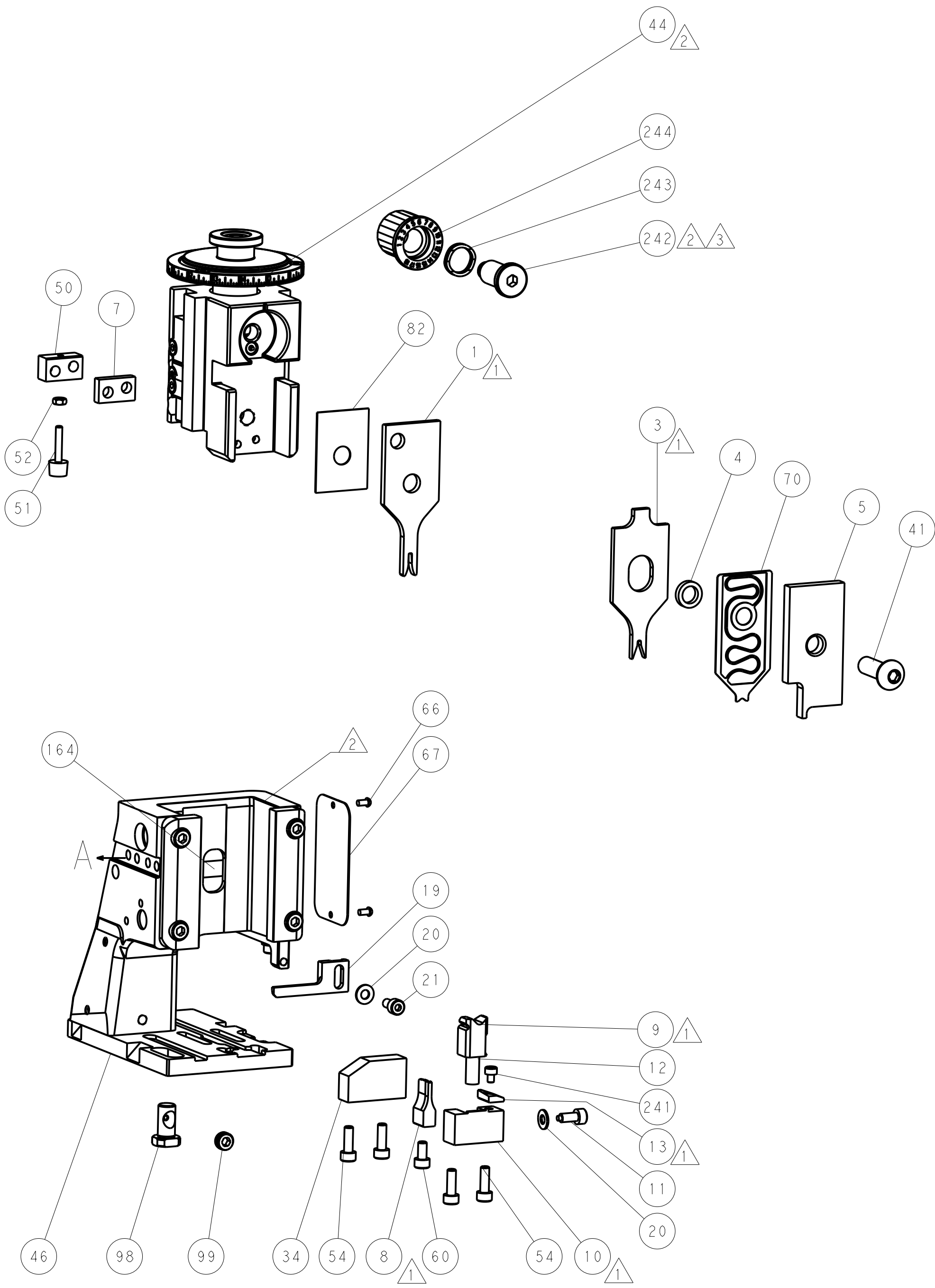
DOUBLE ACTING
PNEUMATIC
WITH SENSORS



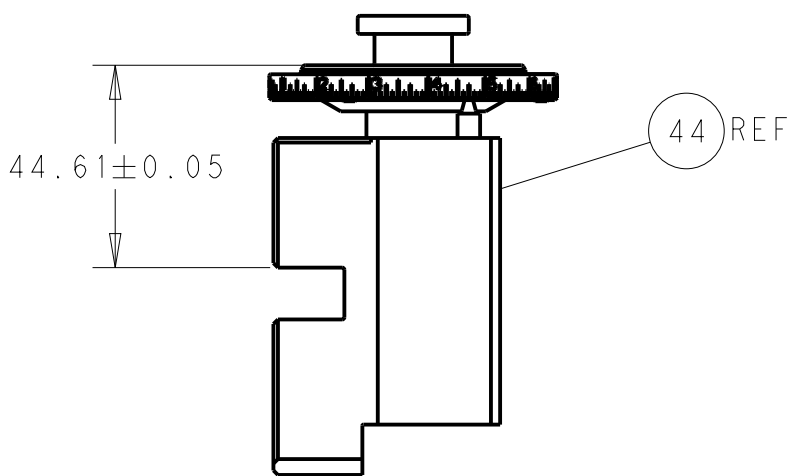
CAM POSITIONS



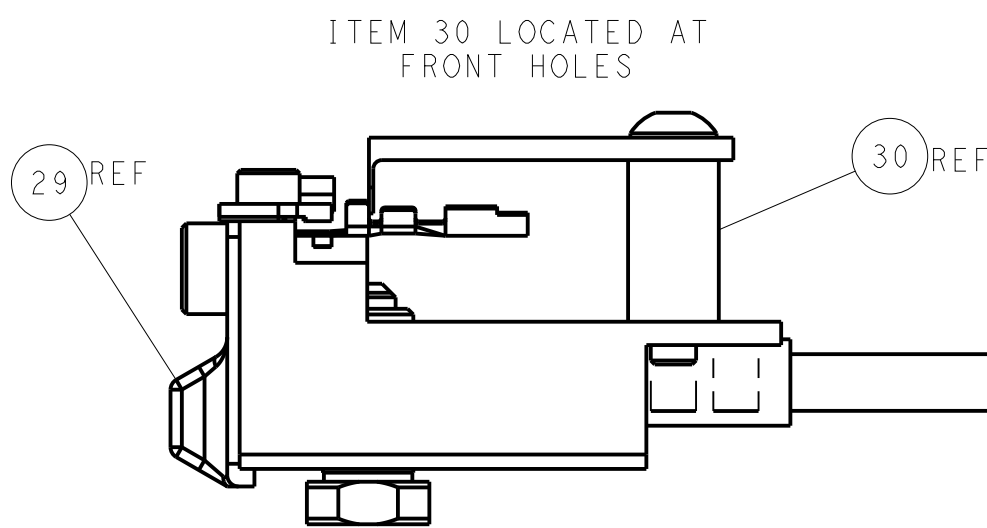
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)



TERMINAL SUPPORT LOCATION



RAM SET-UP



FEED TRACK POSITION
GUIDE BY INSULATION BARREL

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN A. HUANG CHK S. XI APVD S. XI		27AUG2012 27AUG2012 27AUG2012		TE Connectivity Harrisburg, PA 17105-3608	
mm		0 PLC ±.1 1 PLC ±.1 2 PLC ±.1 3 PLC ±.1 4 PLC ±.1		PRODUCT SPEC		NAME		Ocean Side Feed Applicator	
MATERIAL		FINISH		APPLICATION SPEC		SIZE		CAGE CODE	
-		-		WEIGHT		A1 00779		DRAWING NO	
-		-		Customer Accessible Production Drawing		SCALE		1:2	
						SHEET		2 OF 4	
						REV		F1	

8

7

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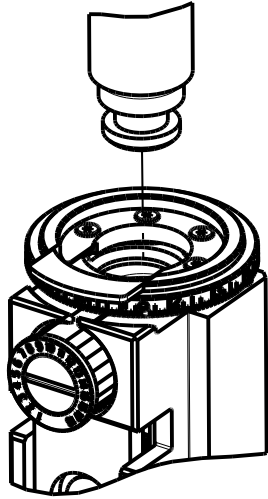
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2151478-1	E	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2151478-2	F	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
4-2151478-2	F	FINE CRIMP HEIGHT ADJUST	DOUBLE ACTING PNEUMATIC WITH SENSORS
7-2151478-7	C	CRIMP TOOLING KIT	-

7

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: MCON-1.2 LL			
WIRE STRIP LENGTH 3.30-3.90 mm [1.130-1.154 IN]			INSULATION DIAMETER RANGE Ø1.40-1.60 mm [.055-.063 IN]
TERMINAL APPLICATION SPECIFICATION		114-18464	
		-	-
TERMINALS APPLIED			-
TE TERMINAL 1563888-1	TE TERMINAL	TE TERMINAL	TE TERMINAL

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.50mm2	0.86+/-0.03 [.034+/-0.001]	7.8



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. MAXIMUM INSULATION CRIMP WIDTH 2.05mm & MAXIMUM INSULATION CRIMP HEIGHT 2.05mm. SEE APPLICATION SPECIFICATION TO CLARIFY.
6. TERMINAL LUBRICANT IS RECOMMENDED.

THIS APPLICATOR IS EQUIPPED WITH THE DOUBLE ACTING FEED WITH SENSORS AND IS APPLICATION SPECIFIC. IT DOES NOT REQUIRE ITEMS 49 & 151.

8. 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
8-2151478-1	2151478-1	1	WIRE CRIMPER	3-1803530-3
8-2151478-2	2151478-2	3	INSULATION CRIMPER	1-1803623-5
9-2151478-1	2-2151478-1	46	BASIC SUB -ASSEMBLY	1803940-9
9-2151478-2	2-2151478-2	141	BASIC SUB -ASSEMBLY	1-1803940-0
			LUBRICATOR	DELETE

*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)

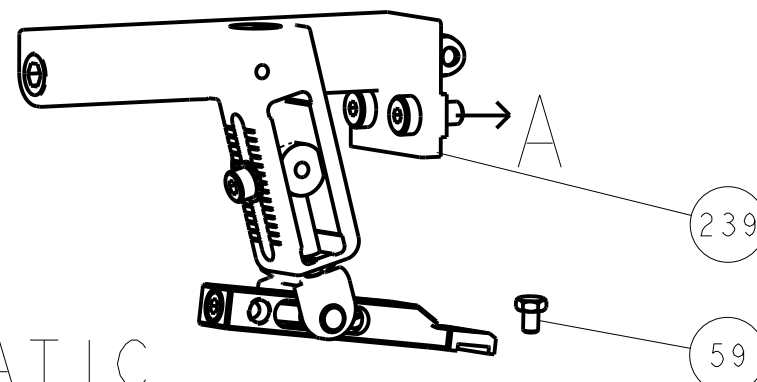
LOC		DIST		REVISONS			
A		66		P	LTR	DESCRIPTION	DATE
						SEE SHEET 1	

	-	1	-	-	2844950-1	AIR FEED MODULE	290
	-	1	1	1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244
	-	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
3	-	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
7	-	-	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
6	-	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
	-	1	1	1	1338685-1	PAWL, FEED	56
	-	2	2	2	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	53
	-	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
7	-	-	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	1-1752356-8	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	1320928-2	STRIP GUIDE	24
	-	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
	-	2	2	2	1-18028-2	WASHER, FLAT, REG M4	20
	-	1	1	1	2119533-1	STRIPPER, SIDE FEED	19
1	-	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	1	2119805-1	SHEAR HOLDER, FRONT	10
1	-	1	1	1	1803095-3	FLOATING SHEAR, FRONT	9
1	1	1	1	1	1333231-4	ANVIL, COMBINATION, SPECIAL	8
	-	1	1	1	240641-4	SPACER	7
	-	-	-	-	-	-	6
	-	1	1	1	2119757-8	DEPRESSOR, SHEAR	5
	-	1	1	1	238011-9	BLOCK, CRIMPER SPACER	4
1	1	1	1	1	1-1633989-5	CRIMPER, INSULATION, SPECIAL	3
	-	-	-	-	-	-	2
1	1	1	1	1	3-456402-3	CRIMPER, WIRE PREMIUM	1
	-77	-42	-22	-21	PART NO	DESCRIPTION	ITEM NO

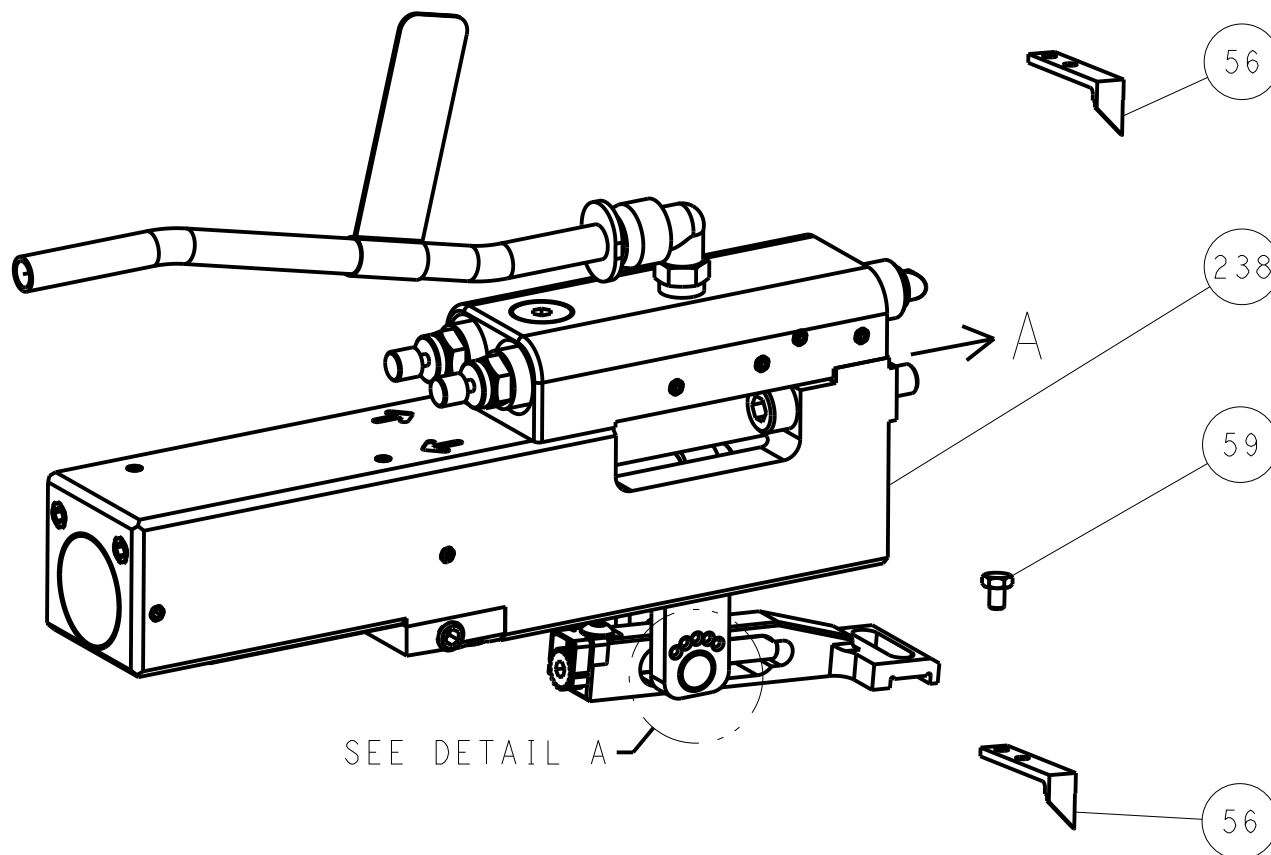
THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE AND THE USER SHALL BE RESPONSIBLE FOR VERIFYING THE LATEST REVISIONS. NO OTHER ORGANIZATION SHALL BE CONTACTED FOR THE LATEST REVISIONS.				OWN CH S.XI APVD S.XI	27AUG2012 27AUG2012 27AUG2012	TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		PRODUCT SPEC		NAME Ocean Side Feed Applicator	
0 PLC 1 PLC 2 PLC 3 PLC 4 PLC ANGLES FINISH		± ± ± ± ± ± ±		APPLICATION SPEC		SIZE 00779	
MATERIAL		FINISH		WEIGHT		SCALE 1:2	
				Customer Accessible Production Drawing		SHEET 3 OF 4	
						REV F1	

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

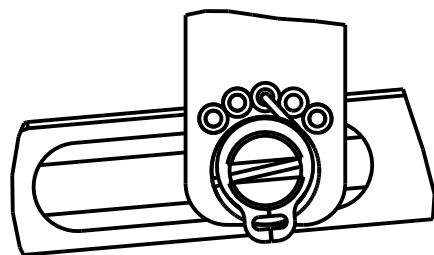
FEED TYPE
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PNEUMATIC

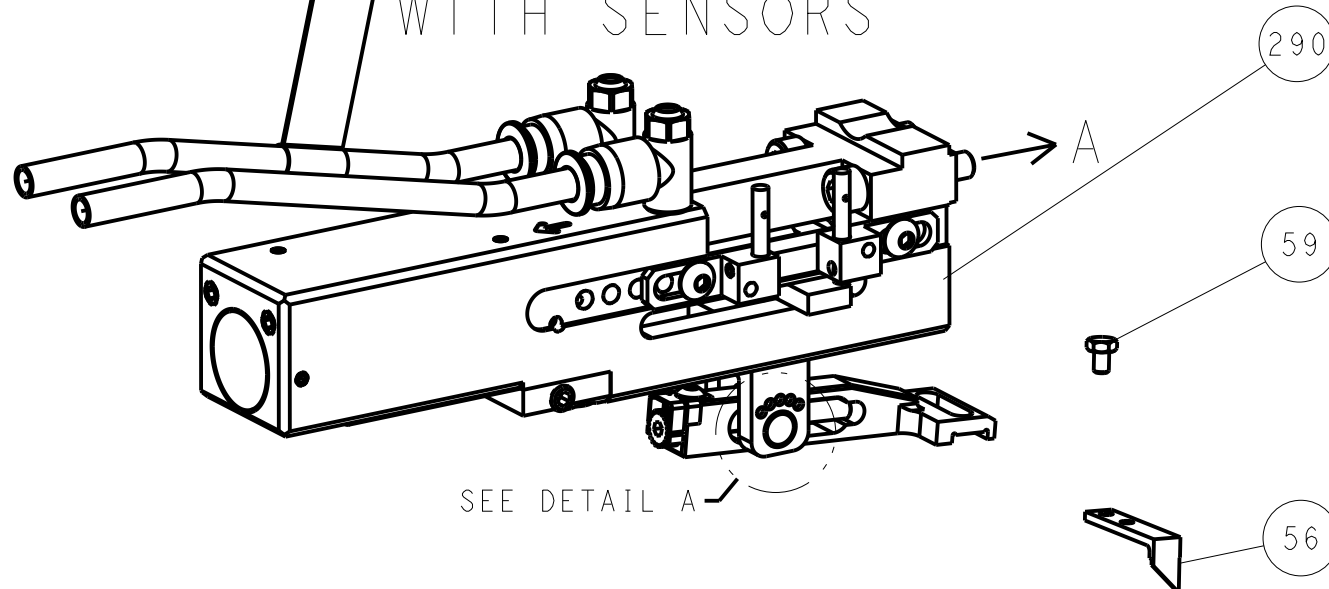


FEED SPRING SETTING POSITION
(SHOWN FROM REAR SIDE)



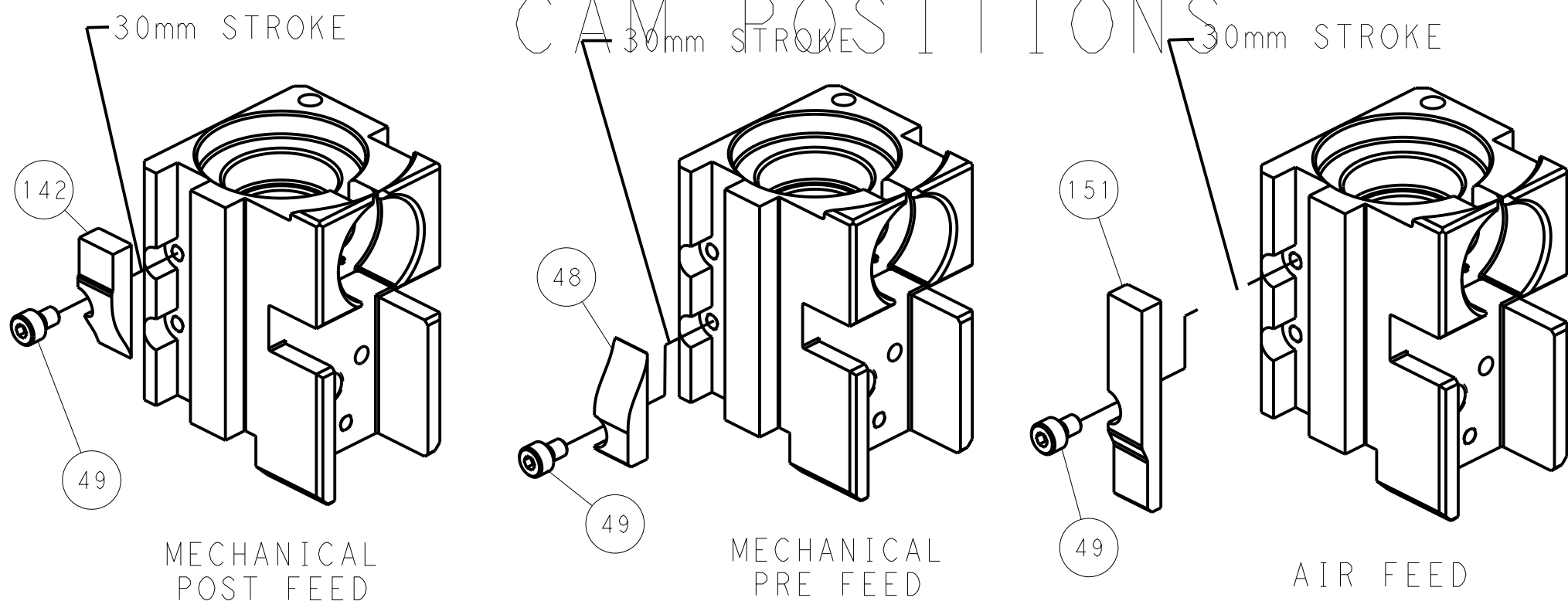
DETAIL A

DOUBLE ACTING
PNEUMATIC
WITH SENSORS



SEE DETAIL A

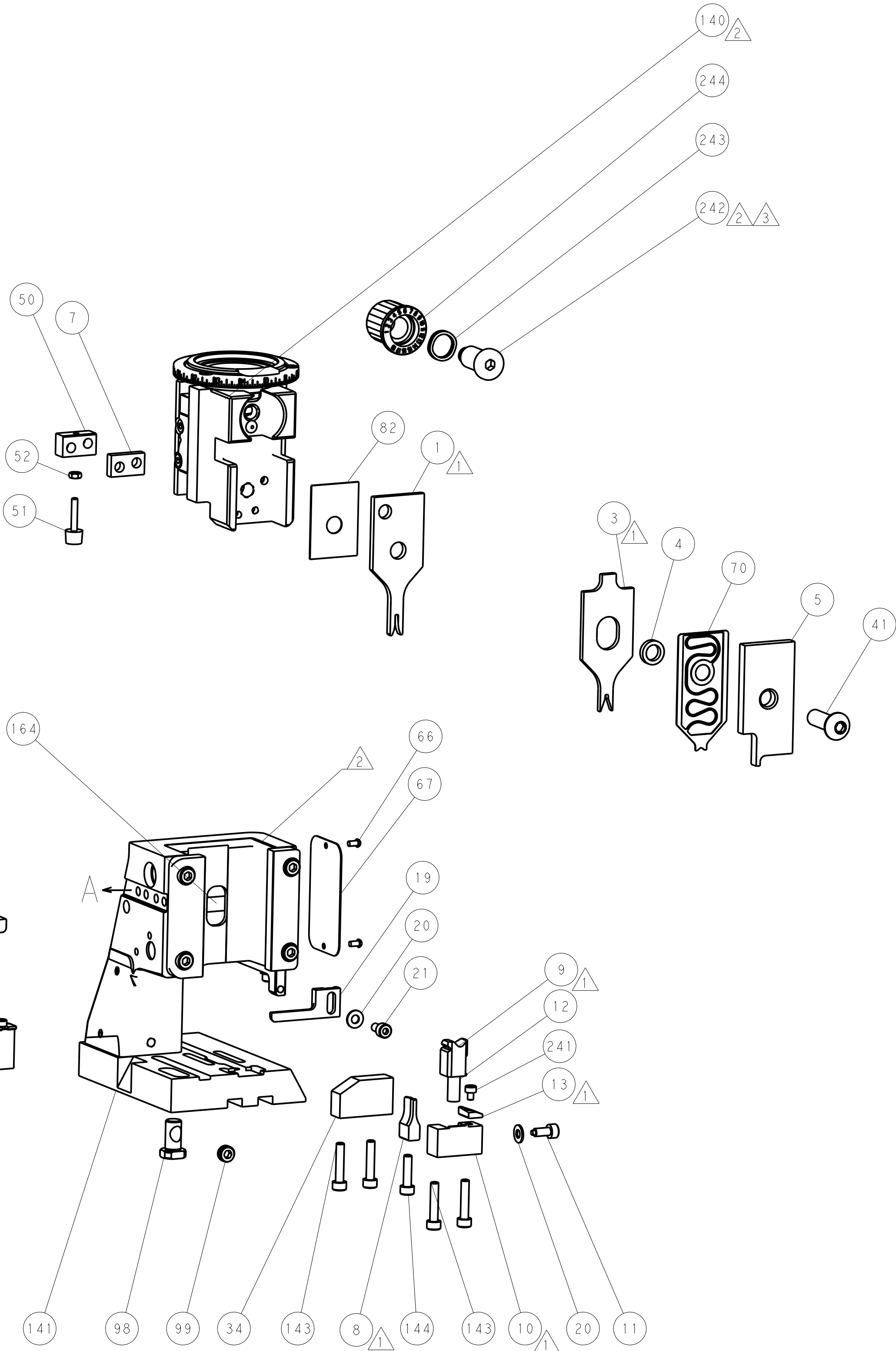
CAM POSITIONS



MECHANICAL
POST FEED

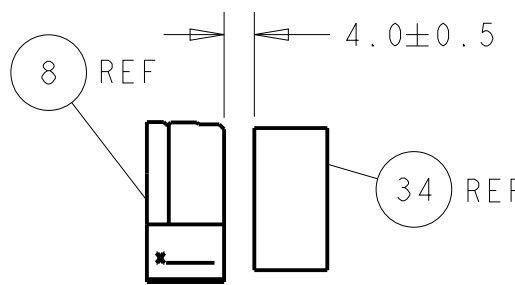
MECHANICAL
PRE FEED

AIR FEED

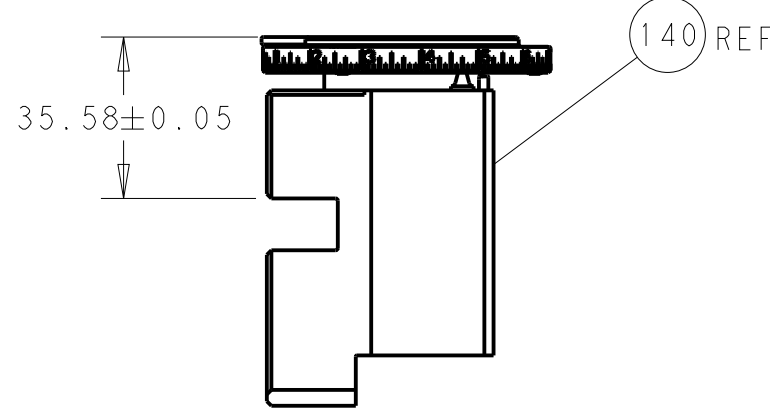


PACIFIC VERSION

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

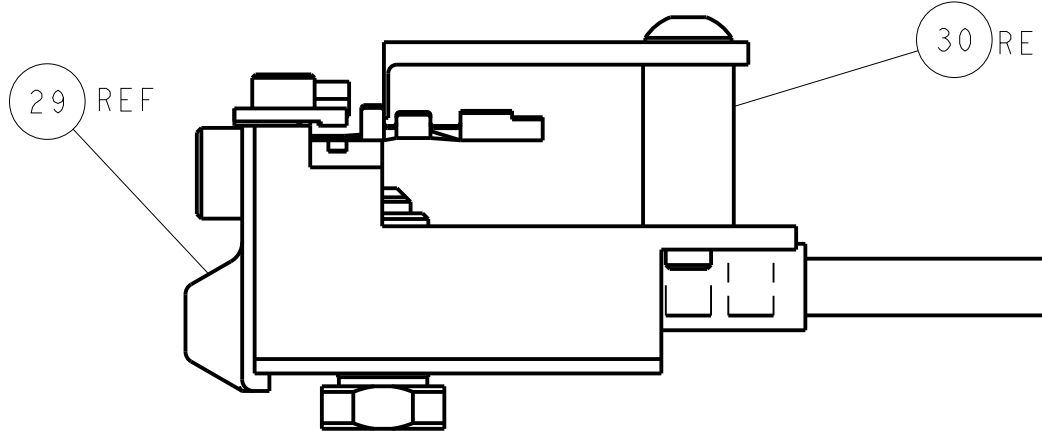


TERMINAL SUPPORT LOCATION



RAM SET-UP

ITEM 30 LOCATED AT
FRONT HOLES



FEED TRACK POSITION
GUIDE BY INSULATION BARREL

THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. ANY CHANGES TO THIS DRAWING SHOULD BE CONTACTED FOR THE LATEST REVISION.				OWN: K. HUANG 27AUG2012 CHK: S. XI 27AUG2012 APVD: S. XI 27AUG2012				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: -				PRODUCT SPEC: - APPLICATION SPEC: - WEIGHT: -				SIZE: A1 CAGE CODE: 00779 DRAWING NO: C-2151478			
				Customer Accessible Production Drawing				SCALE: 1:2 SHEET: 4 of 4 REV: F1			

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

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