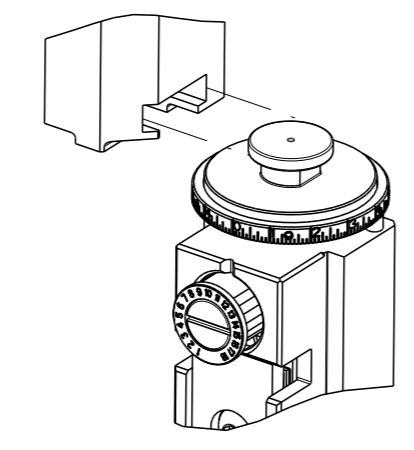


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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151469-1	F	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2151469-2	G	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
5-2151469-1	F	SEAL STRIPPER CRIMPER TERMINATING UNIT	MECHANICAL
5-2151469-2	G	SEAL STRIPPER CRIMPER TERMINATING UNIT	PNEUMATIC
7-2151469-1	F	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2151469-2	G	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2151469-7	C	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.40 mm [.055]	F
INSUL	3.18 mm [.125]	O

APPLICATOR INSTRUCTIONS  
408-35042

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: AMP MCP 1.5K SINGLE WIRE SEALING			
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE		
3.20-3.80 mm [.126-.150 IN]	∅		
TERMINAL APPLICATION SPECIFICATION	114-18386	-	-
TERMINALS APPLIED			

TE TERMINAL	TE TERMINAL	TE SEAL	TE SEAL	CABLE DIAMETER
1564324-1	1564324-2	1394133	964971	1.2-1.6mm
1564324-3	2350440-1	1718705-1		0.9-1.2mm

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.35mm2	0.93+/-0.03 [.037+/- .001]	8.6
0.22mm2	0.86+/-0.03 [.034+/- .001]	9.3

- 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. APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 180.
- 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.

LOC	DIST	REVISIONS					
		P	LYR	DESCRIPTION	DATE	OWN	APVD
A	66	E		ECR-17-006518	05MAY2017	TB	CT
		F		ECR-18-005296	10APR2018	JAH	JDG
		G		ECR-19-005049	29MAR2019	LG	TE
		G1		ECR-20-004881	02APR2020	JWC	TE

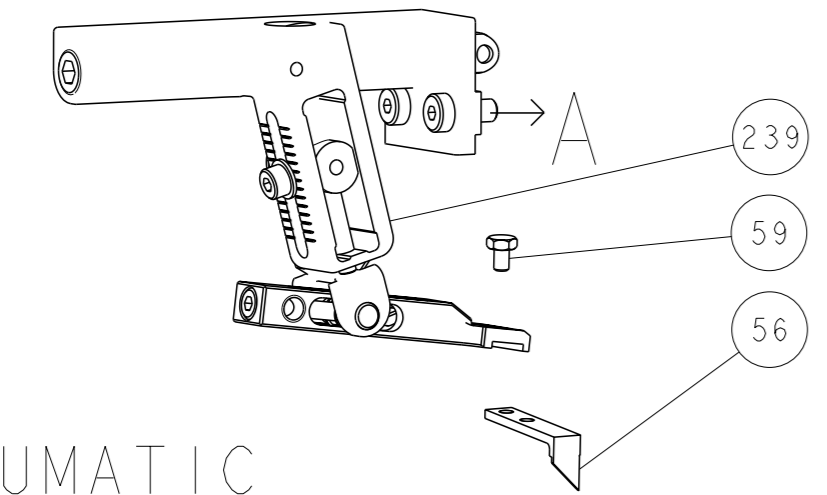
-	-	-	1	1	-	-	1803515-3	RAM ASSEMBLY, SF ATLANTIC	293
-	-	-	1	1	-	-	2-1803583-1	APPLICATOR BASIC ASSEMBLY, SF	292
-	1	-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248
-	1	1	1	1	1	1	2119082-4	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1	1	1	1	1	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	-	-	2-1752354-1	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
-	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	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	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	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	1-1752356-7	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	1-455888-0	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	318707-1	FLOATING SHEAR, FRONT	9
1	2	2	1	1	1	1	2-1633128-3	ANVIL, COMBINATION .055	8
-	1	1	1	1	1	1	1-240641-3	SPACER	7
-	1	1	1	1	1	1	2119781-1	DEPRESSOR, SHEAR	5
-	1	1	1	1	1	1	6-238011-9	BLOCK, CRIMPER SPACER	4
1	2	2	1	1	1	1	1633996-4	CRIMPER, INSULATION SPECIAL	3
1	2	2	1	1	1	1	456402-1	CRIMPER, WIRE PREMIUM	1

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

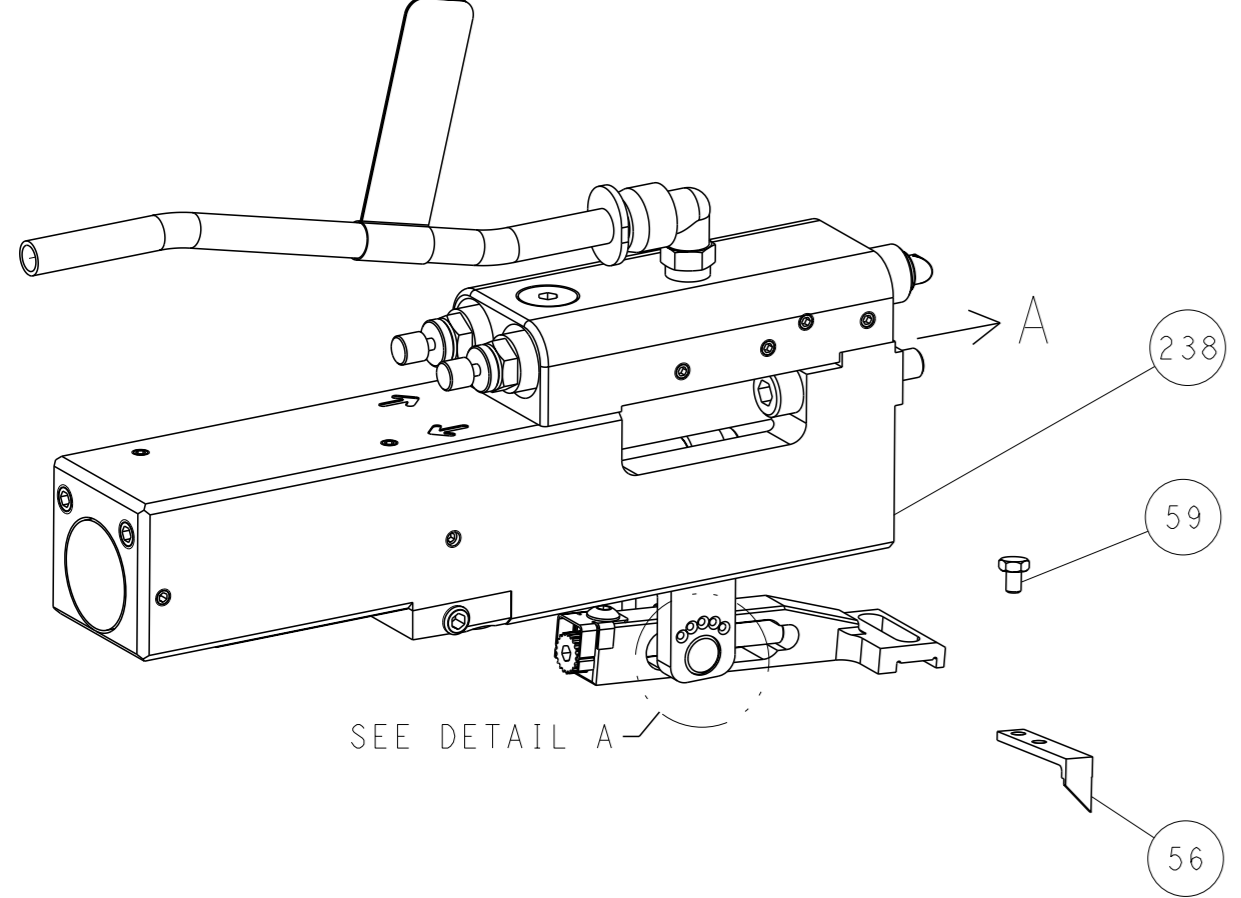
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mm		0 PLC ±		CHK C. MOYER 25AUG2011		Harrisburg, PA 17105-3608	
1 PLC ±		2 PLC ±		APVD T. ELBIN 25AUG2011		NAME Ocean Side Feed Applicator	
3 PLC ±		4 PLC ±		PRODUCT SPEC		SIZE CAGE CODE DRAWING NO RESTRICTED TO	
5 PLC ±		FINISH		APPLICATION SPEC		A1 00779 C=2151469	
MATERIAL		WEIGHT		CUSTOMER ACCESSIBLE PRODUCTION DRAWING		SCALE 1:2 SHEET 1 OF 4 REV G1	

LOC	DIST	REVISIONS			
A	66	REV	DATE	OWN	APVD
-	-	SEE SHEET 1	-	-	-

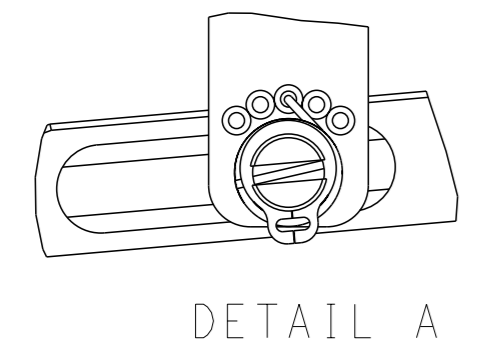
# FEED TYPE MECHANICAL



# PNEUMATIC

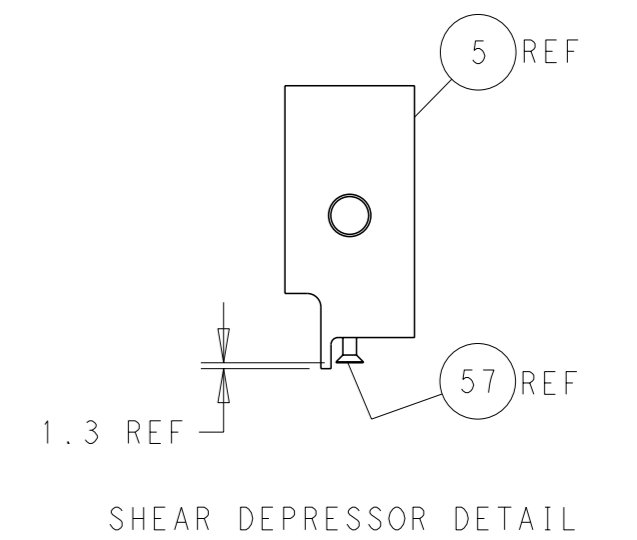
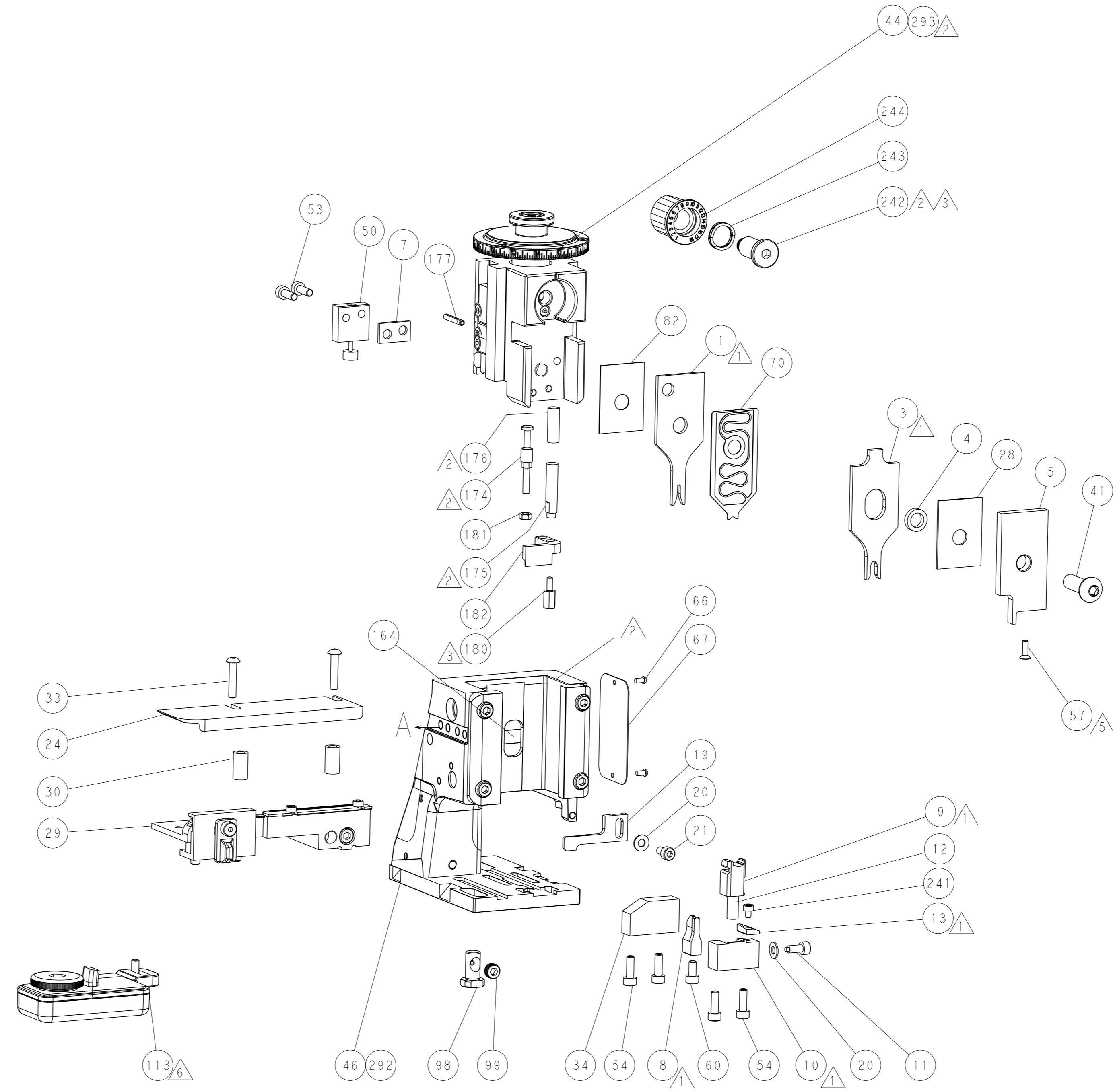
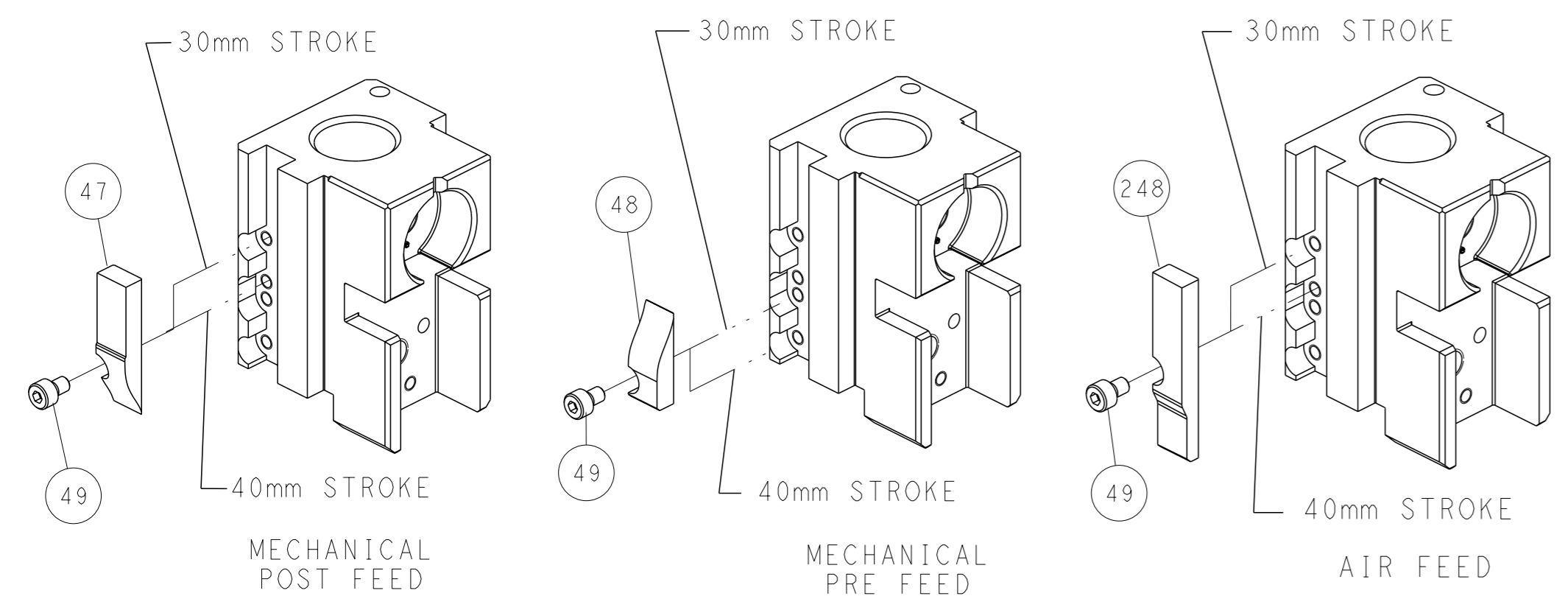


# FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)

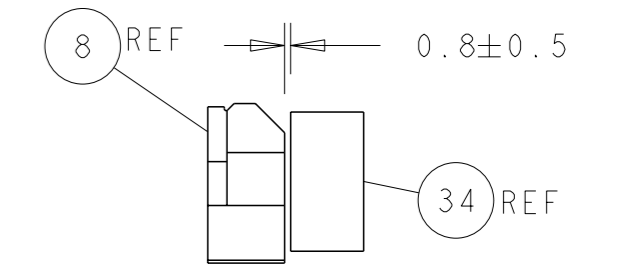


DETAIL A

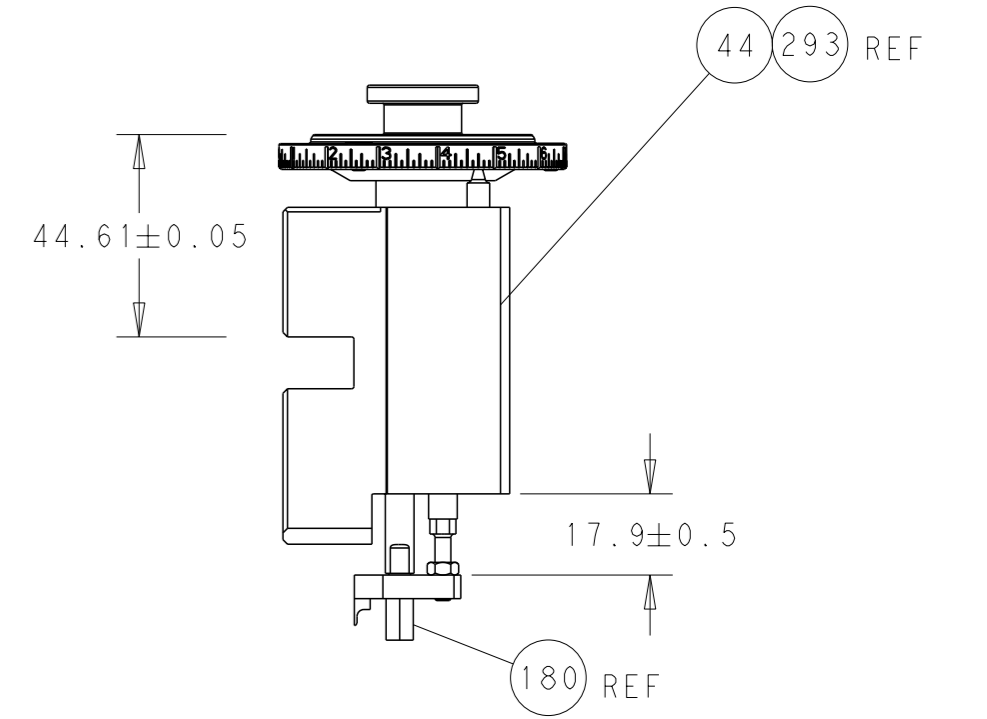
# CAM POSITIONS



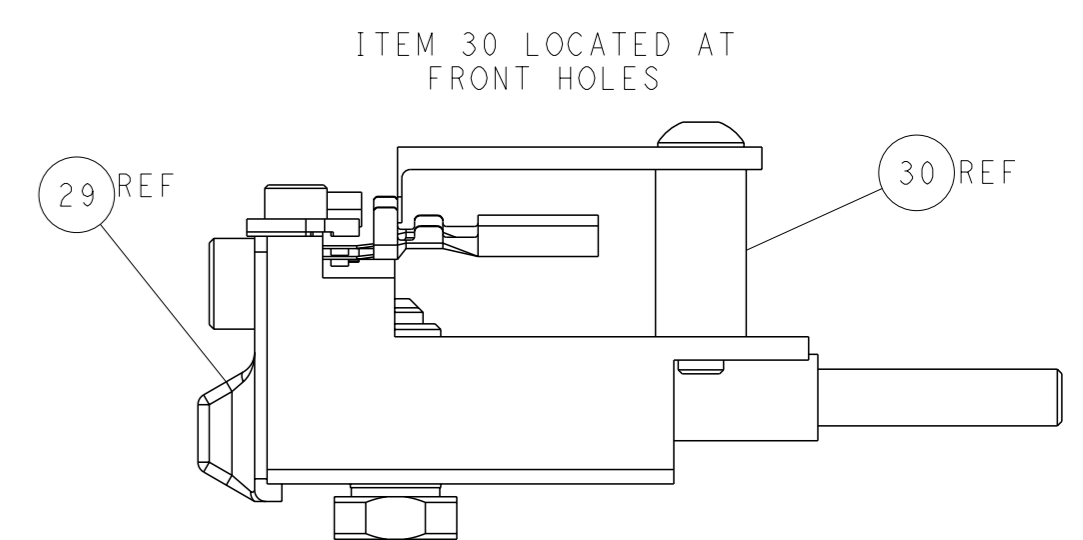
SHEAR DEPRESSOR DETAIL



TERMINAL SUPPORT LOCATION



RAM AND HOLD DOWN SET-UP



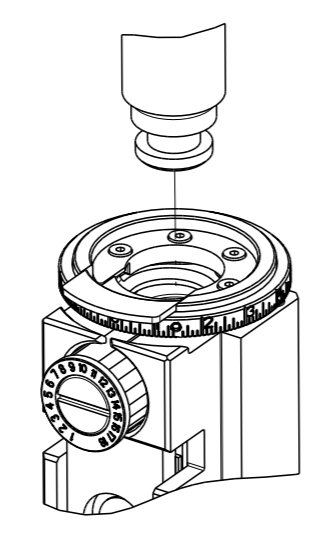
FEED TRACK POSITION GUIDE BY INSULATION BARREL

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

<small>THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE AND THE CONTROL AND ENGINEERING ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST REVISION.</small>		OWN: B. WEAVER 25AUG2011 CHK: C. MOYER 25AUG2011 APVD: T. ELBIN 25AUG2011	NAME: Ocean Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2151469 SCALE: 1:2 SHEET: 2 of 4 REV: G1
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±	MATERIAL:	WEIGHT:	RESTRICTED TO:

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2151469-1	F	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2151469-2	G	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151469-7	C	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR  
 INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.40 mm (.055)	F
INSUL	3.18 mm (.125)	O
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: AMP MCP 1.5K SINGLE WIRE SEALING			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
3.20-3.80 mm (.126-.150 IN)		Ø	
TERMINAL APPLICATION SPECIFICATION	114-18386	-	-

TERMINALS APPLIED				
TE TERMINAL	TE TERMINAL	TE SEAL	TE SEAL	CABLE DIAMETER
1564324-1	1564324-2	1394133	964971	1.2-1.6mm
1564324-3	2350440-1	1718705-1		0.9-1.2mm

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.35mm <sup>2</sup>	0.93 +/- 0.03 [.037 +/- .001]	8.6
0.22mm <sup>2</sup>	0.86 +/- 0.03 [.034 +/- .001]	9.3

- 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 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.
- 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.

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

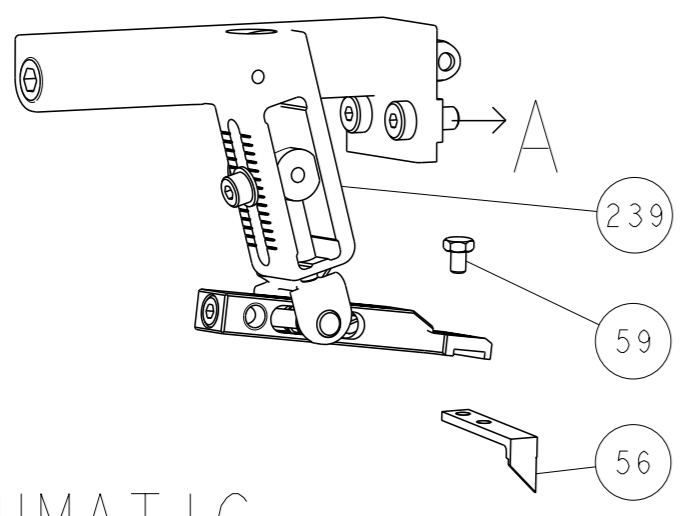
-	1	1	2119082-4	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
-	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	1	-	2844940-1	AIR FEED MODULE	238
-	REF	REF	994970-2	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	985575-3	SCR, FLT SKT HD CAP M3 X 10.0	57
-	1	1	1338685-1	PAWL, FEED	56
-	2	2	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	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	1-1752356-7	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	1-455888-0	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	318707-1	FLOATING SHEAR, FRONT	9
-	1	1	2-1633128-3	ANVIL, COMBINATION .055	8
-	1	1	1-240641-3	SPACER	7
-	1	1	2119781-1	DEPRESSOR, SHEAR	5
-	1	1	6-238011-9	BLOCK, CRIMPER SPACER	4
-	1	1	1633996-4	CRIMPER, INSULATION SPECIAL	3
-	1	1	456402-1	CRIMPER, WIRE PREMIUM	1

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

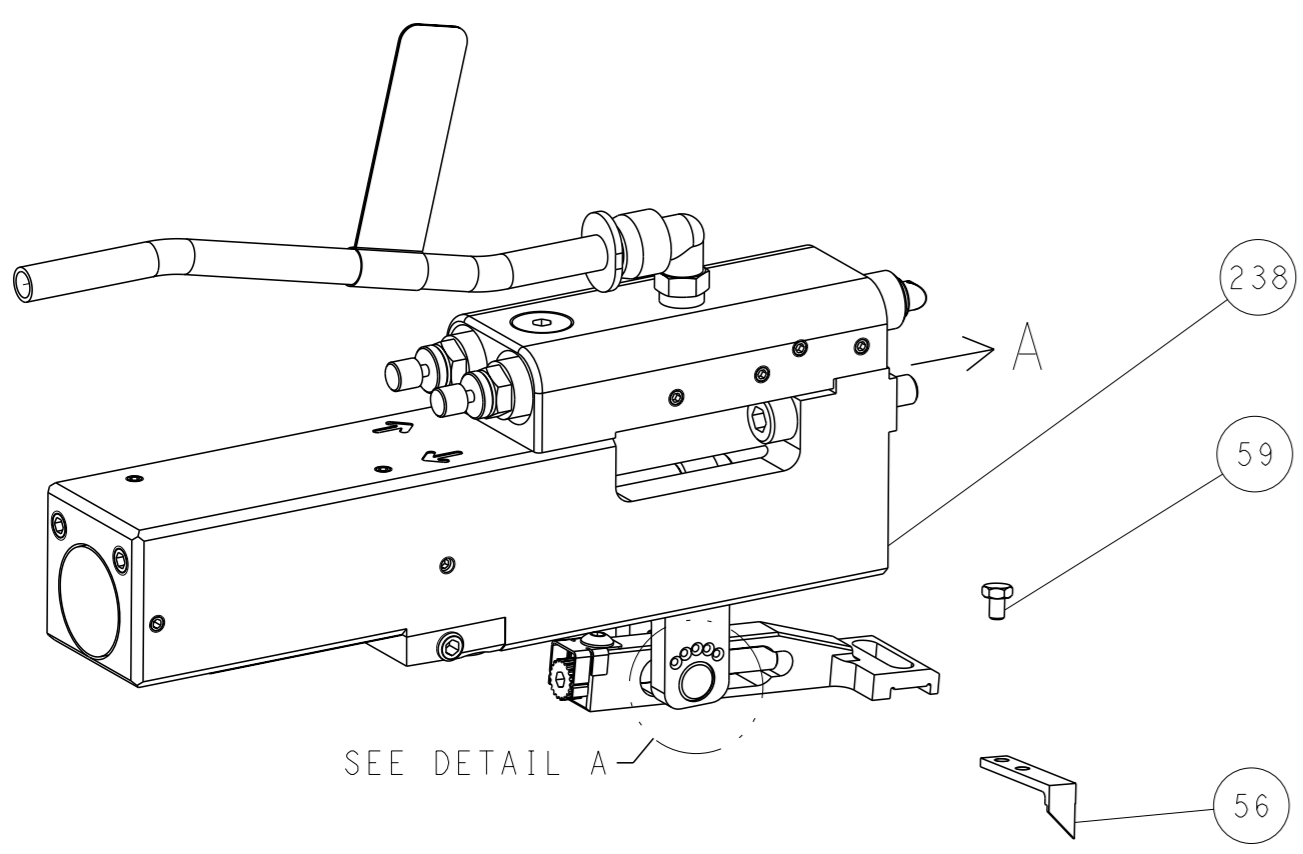
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MATERIAL		WEIGHT		SIZE CAGE CODE DRAWING NO		RESTRICTED TO	
				A1 00779 ©=2151469		CUSTOMER ACCESSIBLE PRODUCTION DRAWING SCALE 1:2 SHEET 3 of 4 REV G1	

LOC	DIST	REVISIONS			
A	66	REV	DATE	OWN	APVD
		-	SEE SHEET 1	-	-

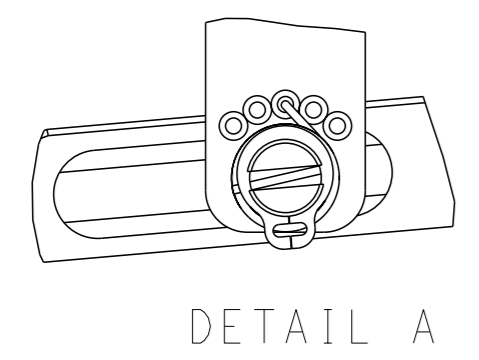
# FEED TYPE MECHANICAL



## PNEUMATIC

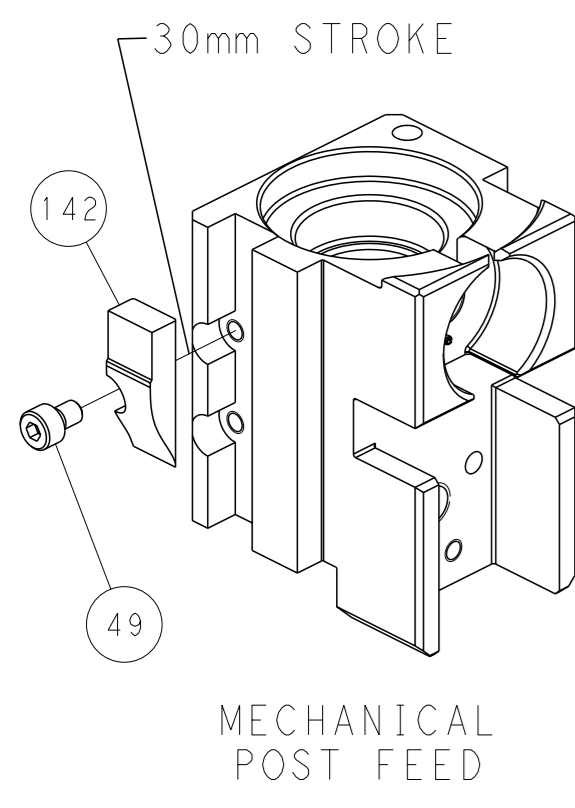


## FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)

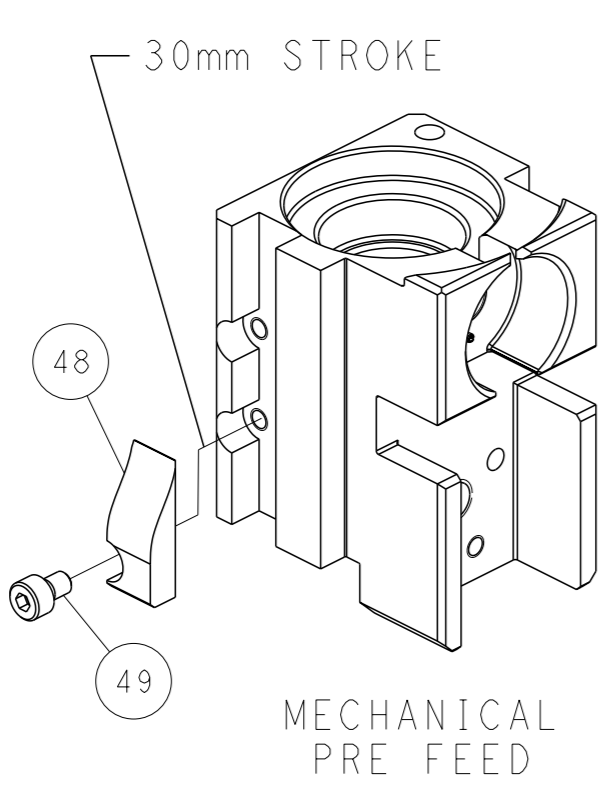


DETAIL A

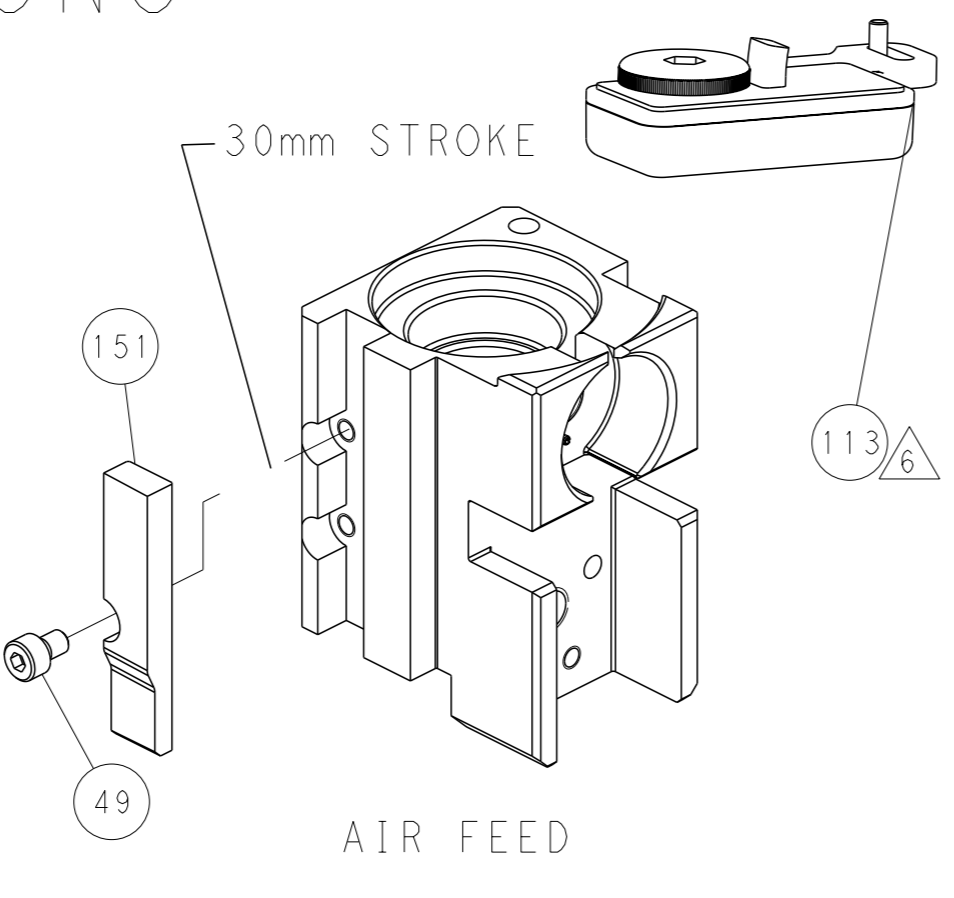
# CAM POSITIONS



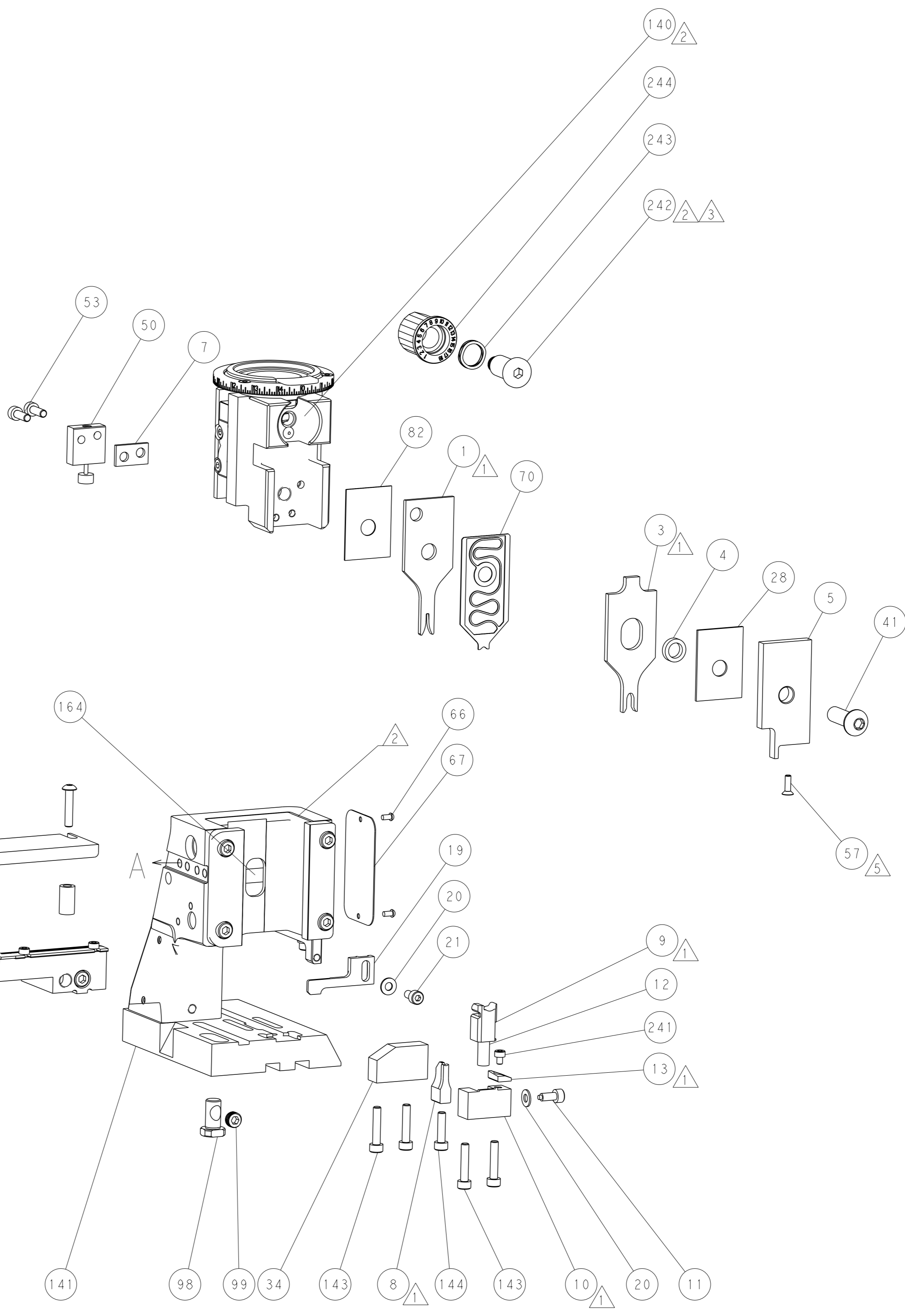
MECHANICAL POST FEED



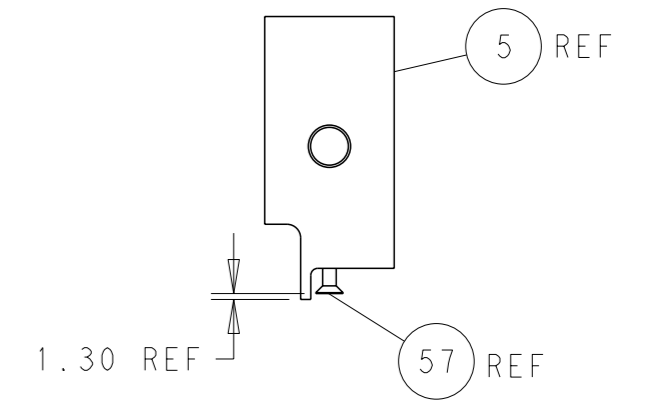
MECHANICAL PRE FEED



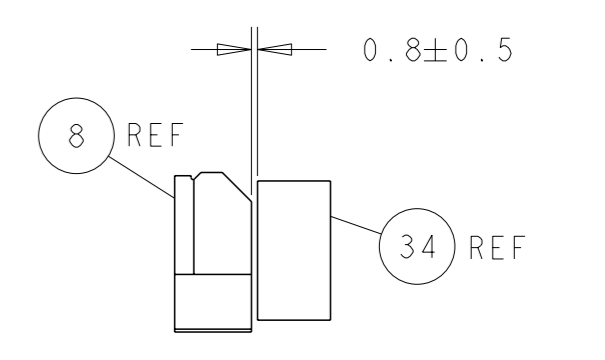
AIR FEED



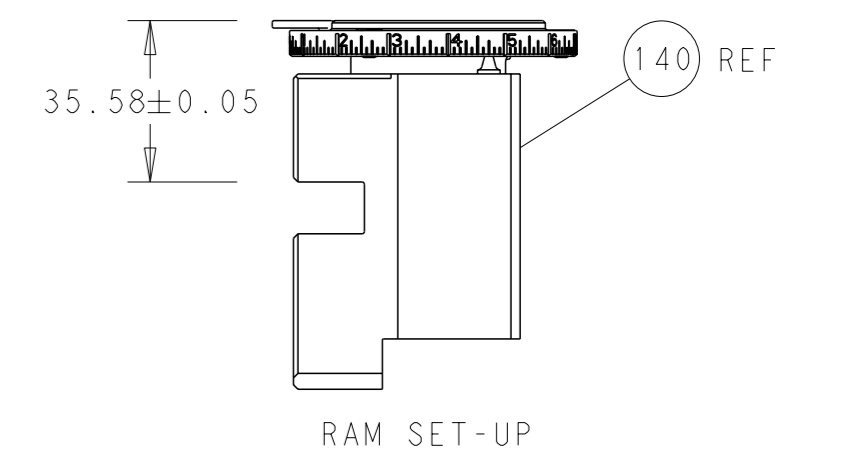
**PACIFIC VERSION**  
 Shown on sheets 3 of 4 & 4 of 4  
 (Atlantic version shown on sheets 1 of 4 & 2 of 4)



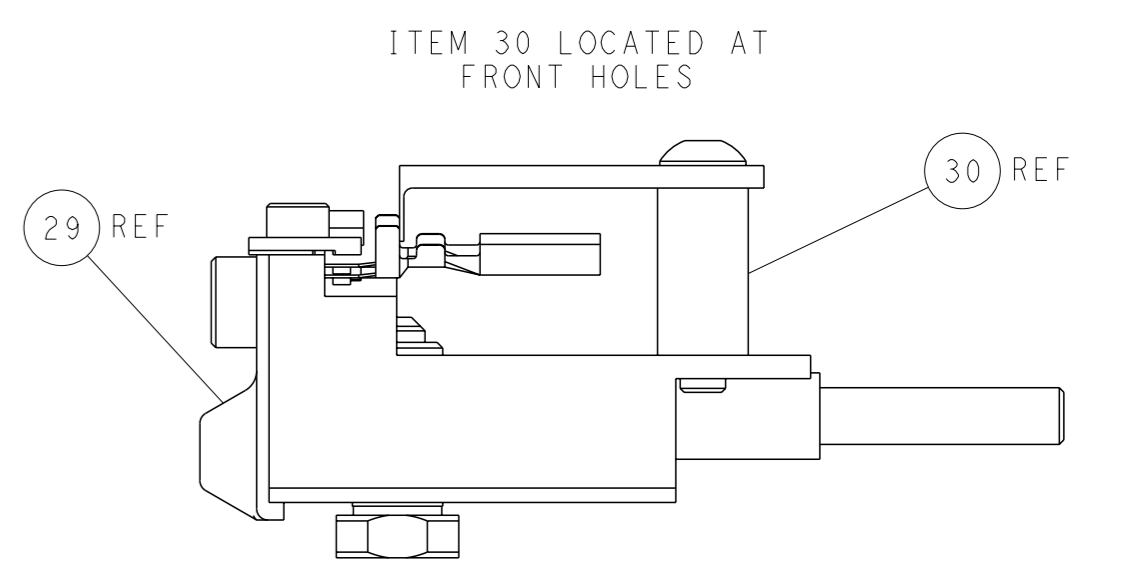
SHEAR DEPRESSOR DETAIL



TERMINAL SUPPORT LOCATION



RAM SET-UP



FEED TRACK POSITION GUIDE BY INSULATION BARREL

DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH ±		OWN: B. WEAVER 25AUG2011 CHK: C. MOYER 25AUG2011 APVD: T. ELBIN 25AUG2011		NAME: Ocean Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2151469		RESTRICTED TO: - SCALE: 1:2 SHEET: 4 of 4 REV: G1	
MATERIAL: - FINISH: -				WEIGHT: - CUSTOMER ACCESSIBLE PRODUCTION DRAWING		TE Connectivity Harrisburg, PA 17105-3608		SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION	