

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151470-1	M	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2151470-2	M	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
3-2151470-2	M	FINE CRIMP HEIGHT ADJUST	DOUBLE ACTING PNEUMATIC WITH SENSORS
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	-

ATLANTIC 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	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.
- 7. THIS APPLICATOR IS EQUIPPED WITH THE DOUBLE ACTING FEED WITH SENSORS AND IS APPLICATION SPECIFIC. IT DOES NOT REQUIRE ITEMS 49 & 248.

**\*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	LTN	DESCRIPTION	DATE	OWN	APVD
		L		ECR-20-013397	21SEP2020	TB	RK
		L1		ECR-21-006034	04JUN2021	LJ	YY
		M		ECR-21-006929	19JUL2021	FZ	MP
		M1		ECR-22-143001	20JUN2022	TB	TE

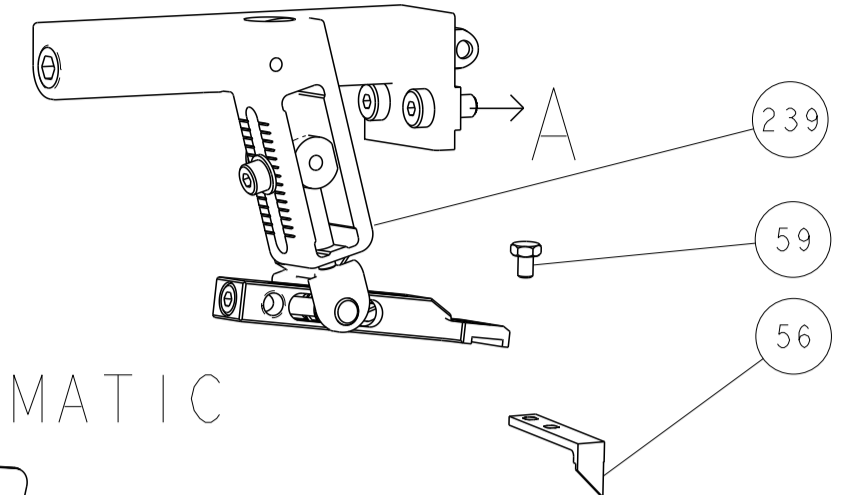
-	-	-	1	1	-	-	-	1803515-3	RAM ASSEMBLY, SF ATLANTIC	293
-	-	-	1	1	-	-	-	2-1803583-1	APPLICATOR BASIC ASSEMBLY, SF	292
-	-	-	-	-	1	-	-	2844950-1	AIR FEED MODULE	290
-	1	-	1	-	-	1	-	2119641-1	FEED CAM, AIR FEED	248
-	1	1	1	1	1	1	1	2119082-8	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1	1	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	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	-	-	-	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	REF	994970-2	COUNTER, MAGNETIC	164
-	1	1	1	1	1	1	1	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113
-	1	1	1	1	1	1	1	2844908-1	SCREW, LOCKING	99
-	1	1	1	1	1	1	1	2844907-1	POST, LOCKING	98
-	1	1	1	1	1	1	1	455888-5	SPACER, CRIMPER	82
-	1	1	1	1	1	1	1	1803607-3	DOCUMENTATION PACKAGE	71
-	1	1	1	1	1	1	1	2119791-5	DEPRESSOR, WIRE	70
-	1	1	1	1	1	1	1	2119740-1	TAG, IDENTIFICATION	67
-	2	2	2	2	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	1	1	1	1	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	60
-	1	1	1	1	1	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	1	1	1	1	1	1	1	1338685-1	PAWL, FEED	56
-	4	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	2-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 14	53
-	1	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	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	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
-	1	1	1	1	1	1	1	1752356-6	SUPPORT, TERMINAL	34
-	2	2	2	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	2	2	2	2	2	2-2844962-6	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	1	1	1	1	1	2844992-2	ASSEMBLY, STRIP GUIDE	29
-	1	1	1	1	1	1	1	455888-5	SPACER, CRIMPER	28
-	1	1	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	1	1	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	1	2119806-1	INSERT, SHEAR	13
-	1	1	1	1	1	1	1	3-22280-3	SPRING, COMPRESSION	12
-	1	1	1	1	1	1	1	1-356885-4	STOP, SHEAR	11
-	1	1	1	1	1	1	1	2119805-1	SHEAR HOLDER, FRONT	10
-	1	1	1	1	1	1	1	1803095-3	FLOATING SHEAR, FRONT	9
1	2	2	1	1	1	1	1	9-1333225-0	ANVIL, COMBINATION	8
-	1	1	1	1	1	1	1	5-240641-0	SPACER	7
-	1	1	1	1	1	1	1	2119757-8	DEPRESSOR, SHEAR	5
-	1	1	1	1	1	1	1	238011-4	BLOCK, CRIMPER SPACER	4
1	2	2	1	1	1	1	1	1633965-8	CRIMPER, INSULATION O PREMIUM	3
-	1	1	1	1	1	1	1	455888-3	SPACER, CRIMPER	2
1	2	2	1	1	1	1	1	6-1752057-1	CRIMPER, WIRE PREMIUM, STEPPED	1

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

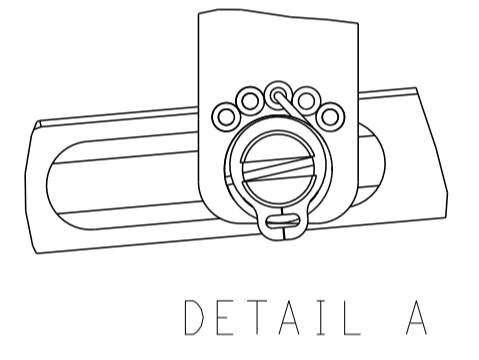
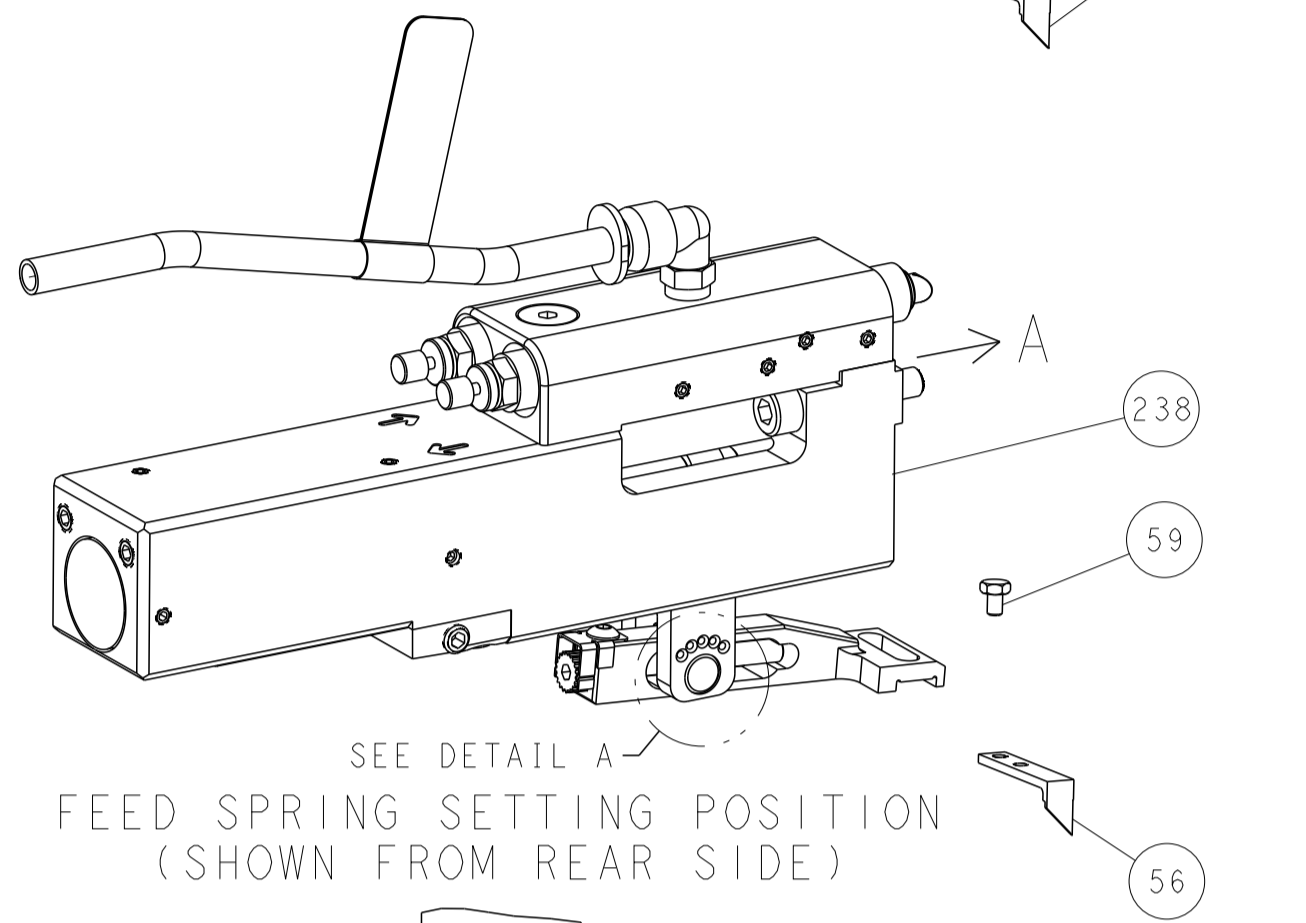
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mm		0 PLC ±		1 PLC ±		2 PLC ±		3 PLC ±		4 PLC ±	
MATERIAL:		FINISH:		WEIGHT:		SCALE: 1:2		SHEET 1 OF 4		REV: M1	

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

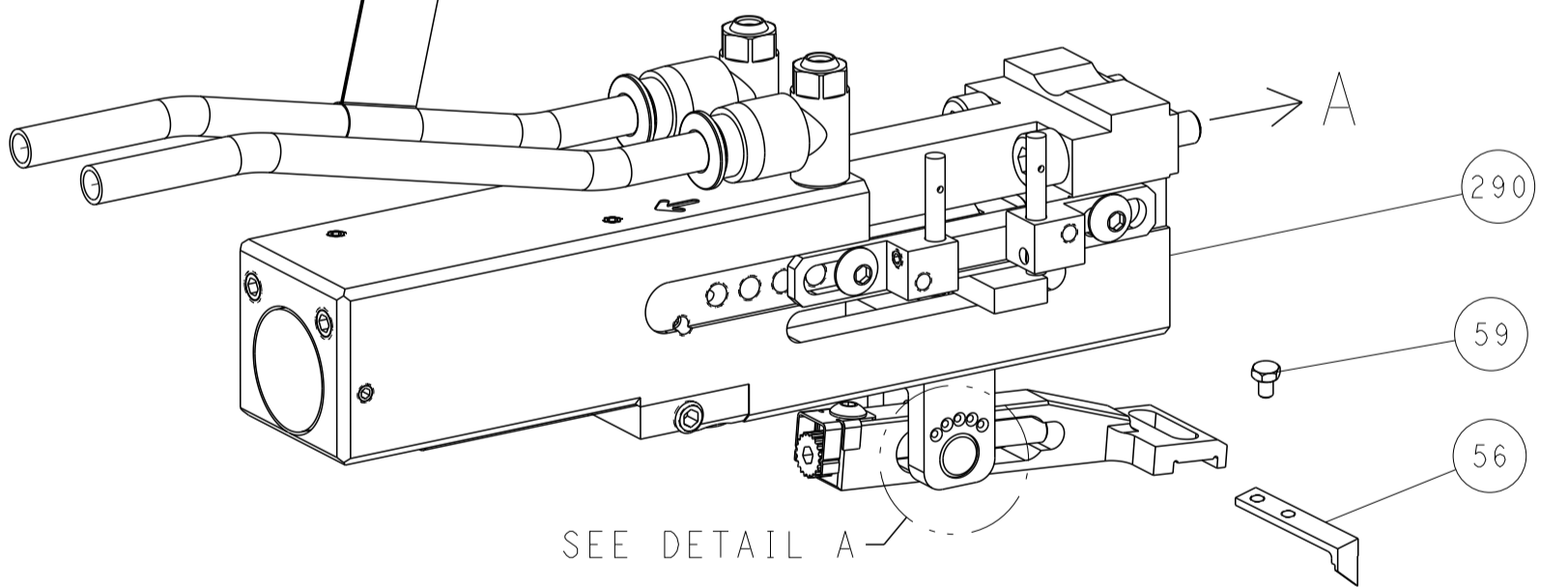
# FEED TYPE MECHANICAL



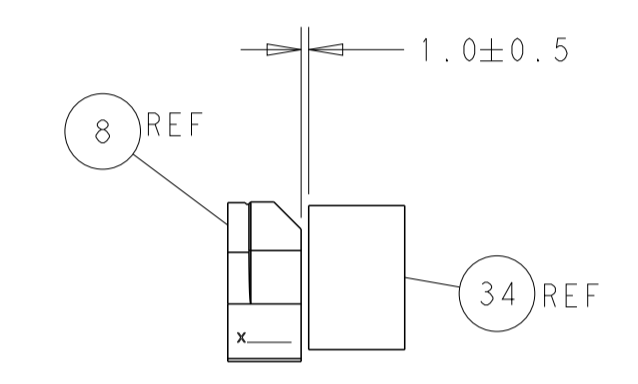
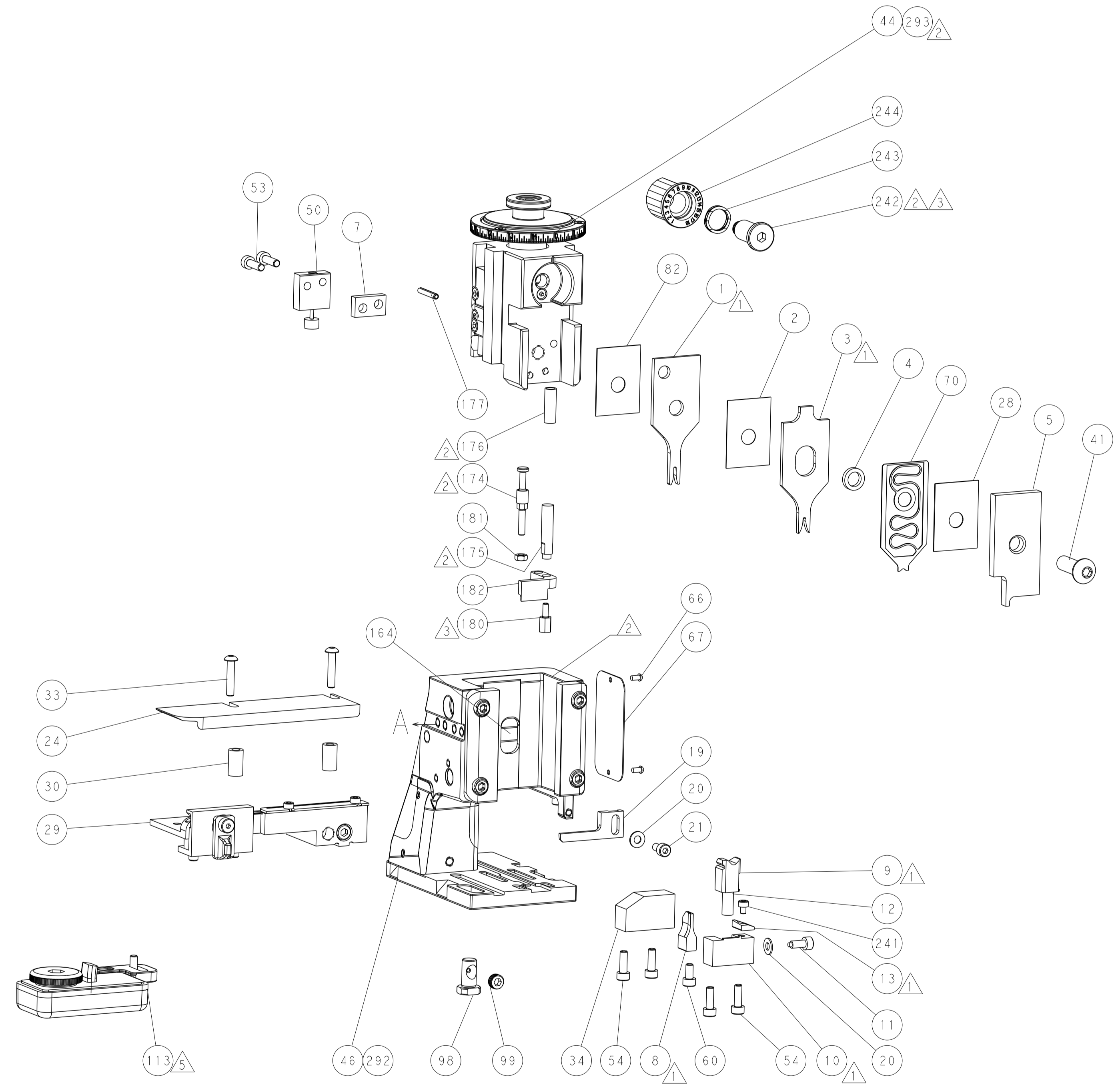
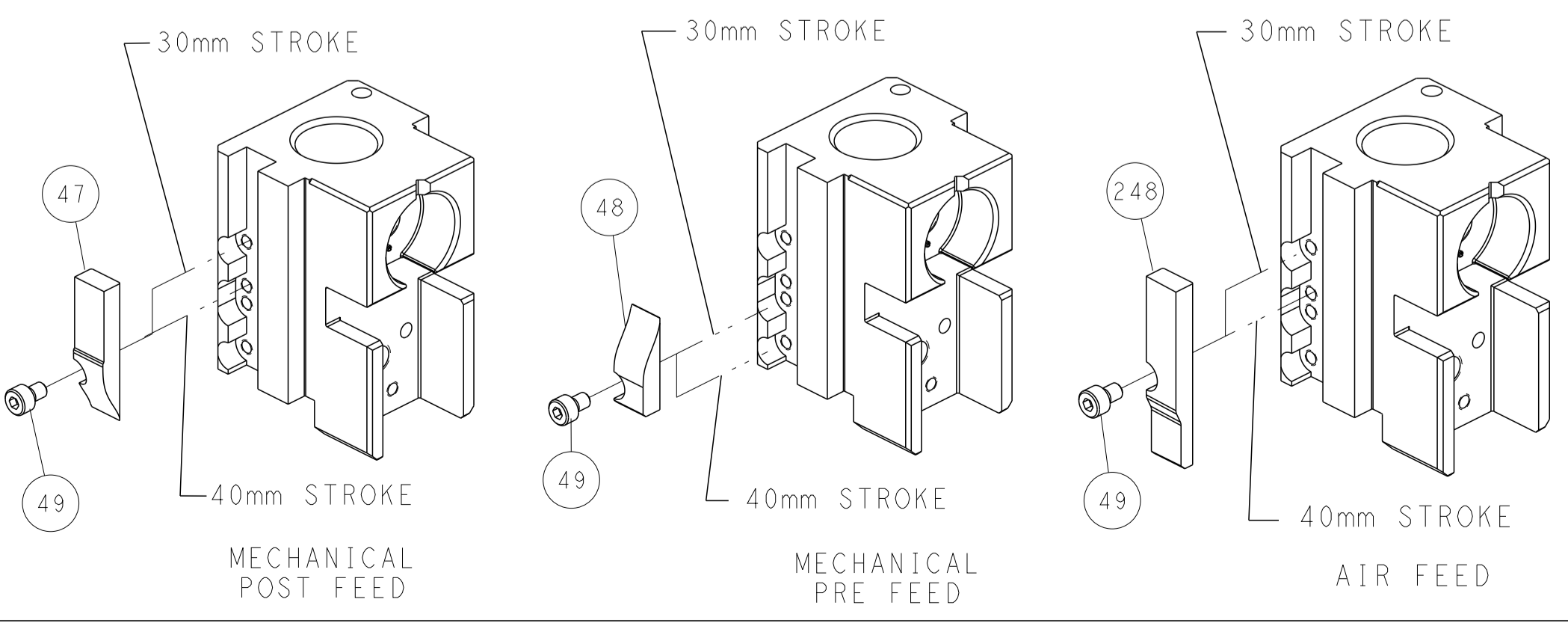
## PNEUMATIC



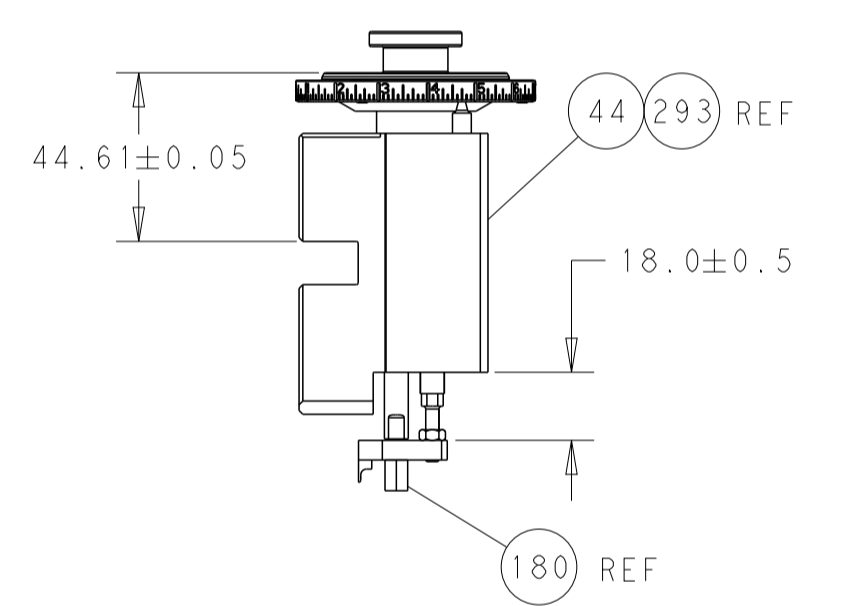
## DOUBLE ACTING PNEUMATIC WITH SENSORS



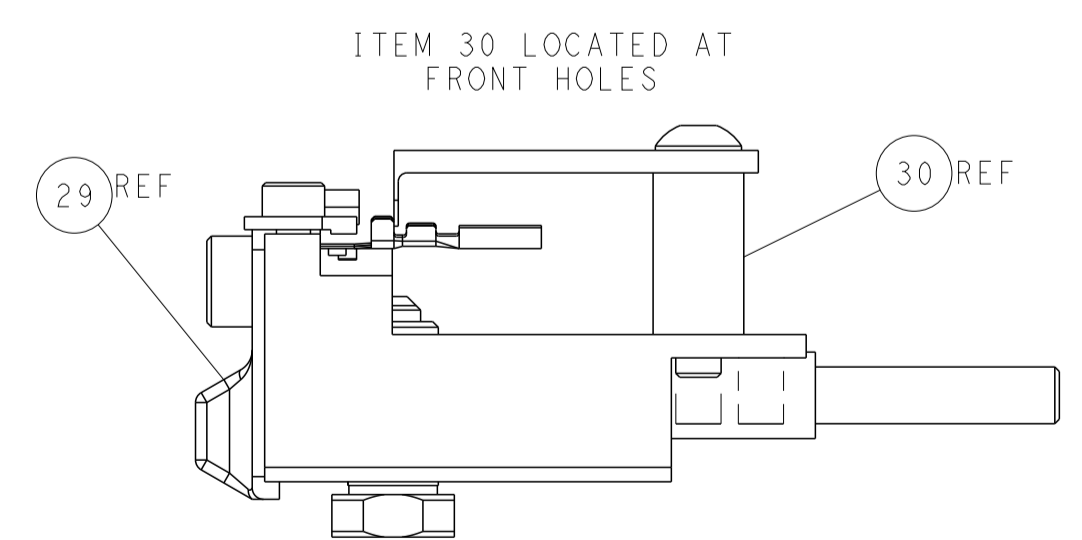
## CAM POSITIONS



TERMINAL SUPPORT LOCATION



RAM AND HOLD DOWN SET-UP



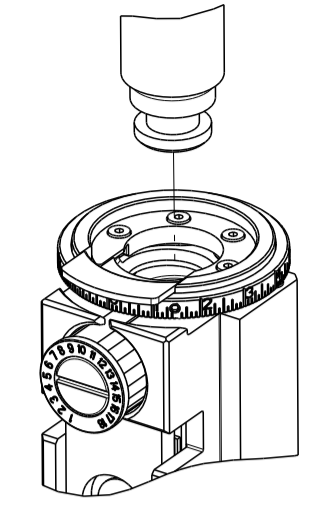
FEED TRACK POSITION GUIDE BY INSULATION BARREL

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

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG: B. WEAVER 25AUG2011		TE Connectivity	
mm	0 PLC	±		CHK: C. MOYER 25AUG2011	NAME: Ocean Side Feed Applicator		Harrisburg, PA 17105-3608
	1 PLC	±		APVD: T. ELBIN 25AUG2011	RESTRICTED TO:		
	2 PLC	±		PRODUCT SPEC:	SIZE: A1		CAGE CODE: 00779
	3 PLC	±		APPLICATION SPEC:	DRAWING NO: 2151470		SCALE: 1:2
	4 PLC	±		WEIGHT:	SHEET 2 OF 4		REV: M1
	ANGLES	±		MATERIAL:	Customer Accessible Production Drawing		

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2151470-1	M	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2151470-2	M	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
4-2151470-2	M	FINE CRIMP HEIGHT ADJUST	DOUBLE ACTING PNEUMATIC WITH SENSORS $\Delta$
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		INSULATION DIAMETER RANGE	
2.60-3.20 mm [.102-.126 IN]		$\varnothing$ 1.10-1.75 mm [.043-.069 IN]	
TERMINAL APPLICATION SPECIFICATION	114-18464	-	-
TERMINALS APPLIED $\Delta$			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
1534594-1	1534594-2	1534594-3	

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING $\Delta$
22 AWG	0.86 +/- 0.03 [.034 +/- .001]	8.6
0.35 mm <sup>2</sup>	0.81 +/- 0.03 [.032 +/- .001]	9.0
24 AWG	0.80 +/- 0.03 [.031 +/- .001]	9.2

- RECOMMENDED SPARE PARTS
- $\Delta$  REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- $\Delta$  APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242.
- $\Delta$  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.
- $\Delta$  TERMINAL LUBRICANT IS RECOMMENDED.
- 6. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- $\Delta$  THIS APPLICATOR IS EQUIPPED WITH THE DOUBLE ACTING FEED WITH SENSORS AND IS APPLICATION SPECIFIC. IT DOES NOT REQUIRE ITEMS 49 & 151.

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

**\*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)

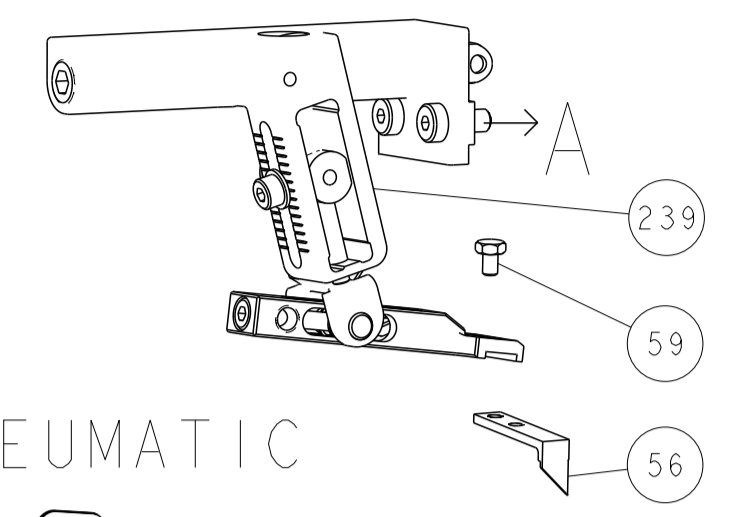
LOC	DIST	REVISIONS					
A	66	P	LTN	DESCRIPTION	DATE	OWN	APVD
		-	-	SEE SHEET 1	-	-	-

-	1	-	-	2844950-1	AIR FEED MODULE	290
-	1	1	1	2119082-8	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
$\Delta$	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
$\Delta$	-	-	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
$\Delta$	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	2-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 14	53
-	1	1	1	1803382-6	HOLD DOWN, SPRING LOADED	50
$\Delta$	-	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	455888-5	SPACER, CRIMPER	28
-	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
$\Delta$	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
$\Delta$	1	1	1	2119805-1	SHEAR HOLDER, FRONT	10
$\Delta$	1	1	1	1803095-3	FLOATING SHEAR, FRONT	9
$\Delta$	1	1	1	9-1333225-0	ANVIL, COMBINATION	8
-	1	1	1	5-240641-0	SPACER	7
-	1	1	1	2119757-8	DEPRESSOR, SHEAR	5
-	1	1	1	238011-4	BLOCK, CRIMPER SPACER	4
$\Delta$	1	1	1	1633965-8	CRIMPER, INSULATION O PREMIUM	3
-	1	1	1	455888-3	SPACER, CRIMPER	2
$\Delta$	1	1	1	6-1752057-1	CRIMPER, WIRE PREMIUM, STEPPED	1

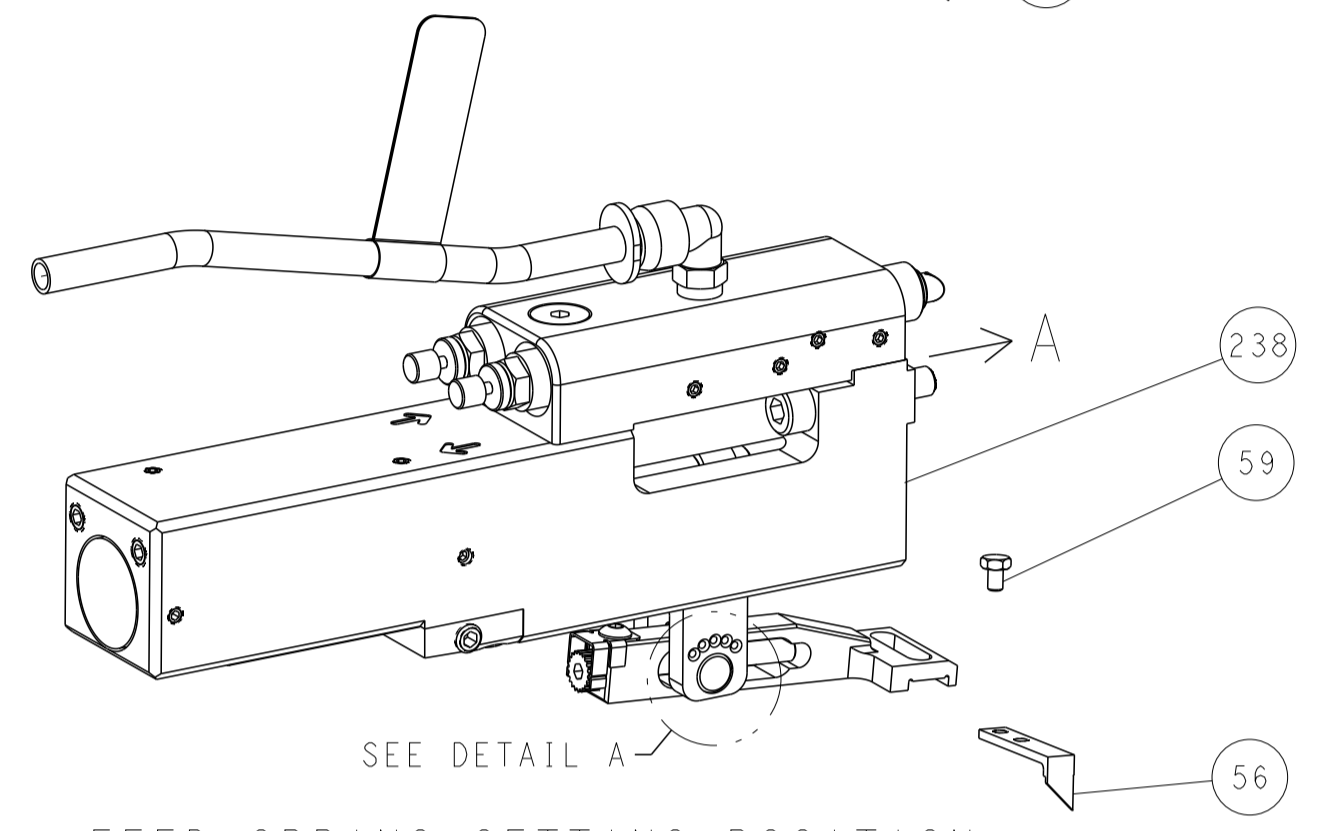
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		MATERIAL:		FINISH:		WEIGHT:		SCALE:	
mm	0 PLC	±									
	1 PLC	±									
	2 PLC	±									
	3 PLC	±									
	4 PLC	±									
	ANGLES	±									

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

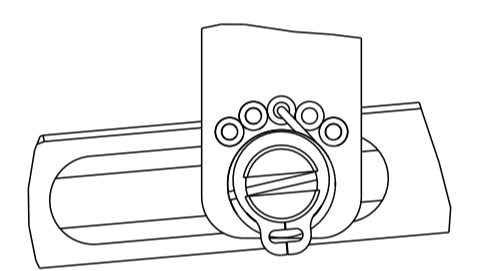
# FEED TYPE MECHANICAL



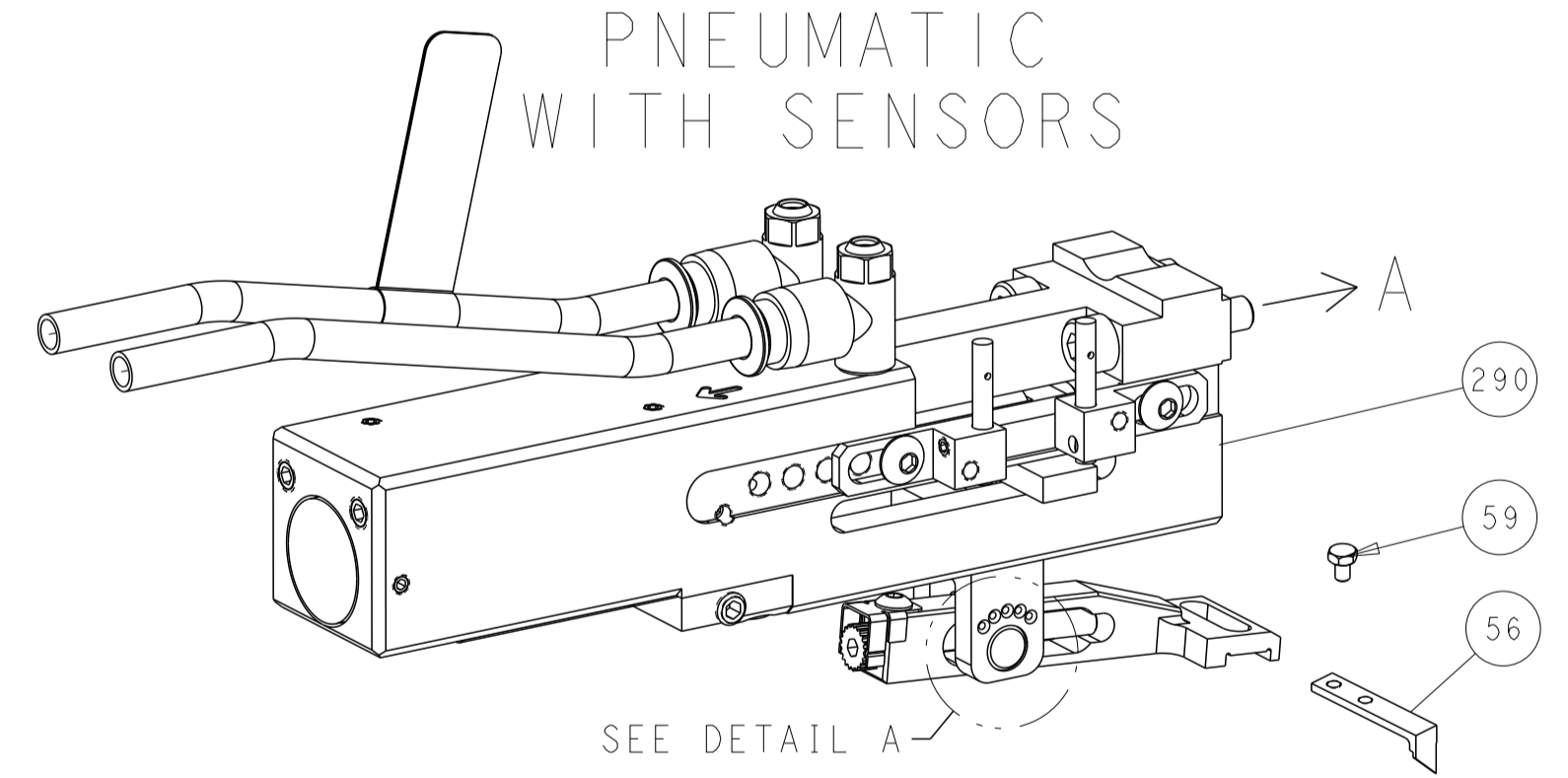
## PNEUMATIC



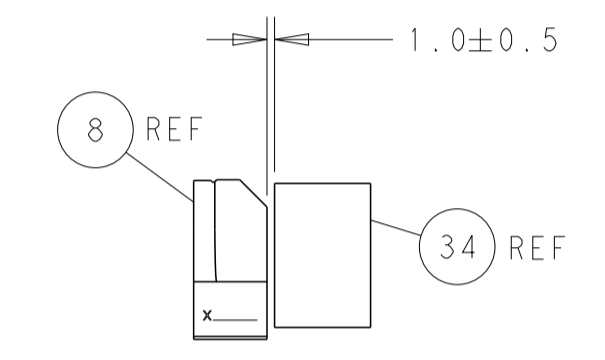
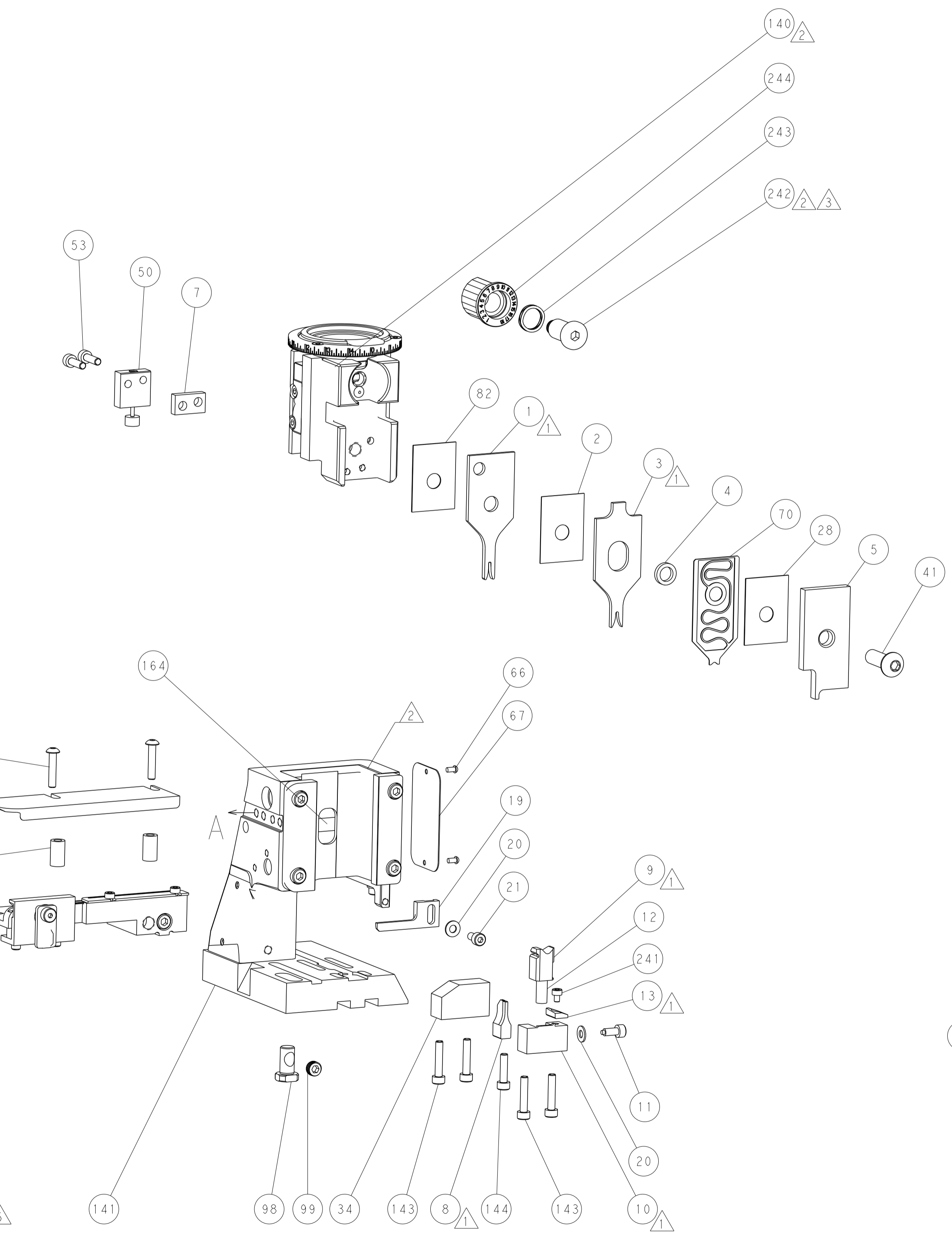
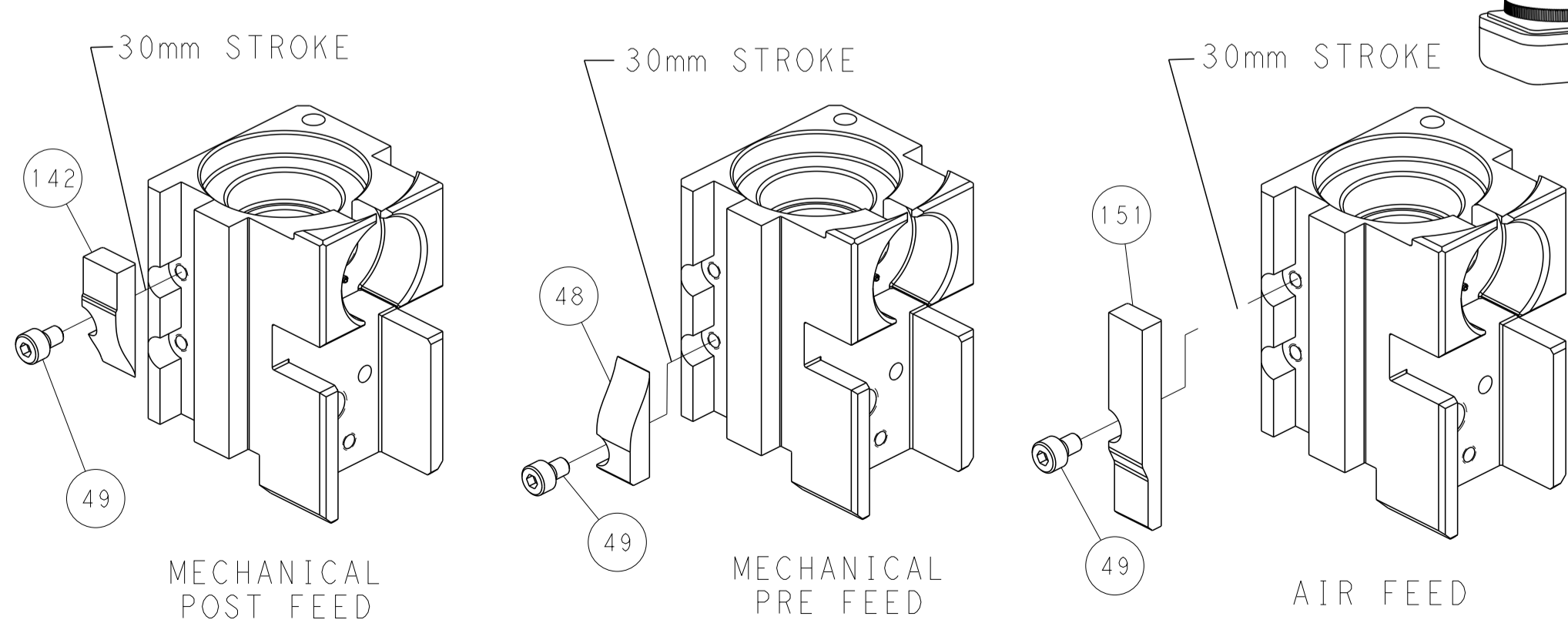
FEED SPRING SETTING POSITION  
(SHOWN FROM REAR SIDE)



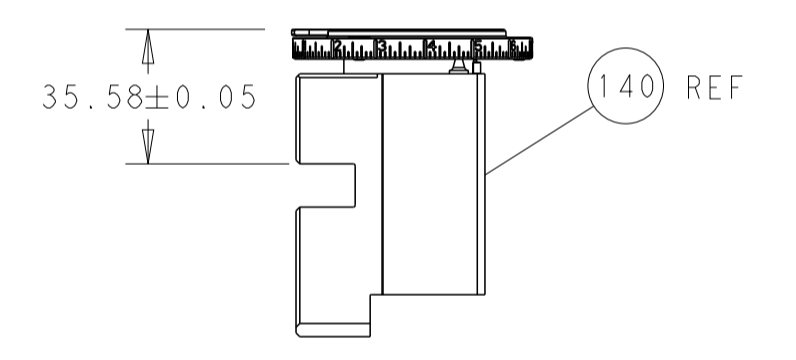
## DOUBLE ACTING PNEUMATIC WITH SENSORS



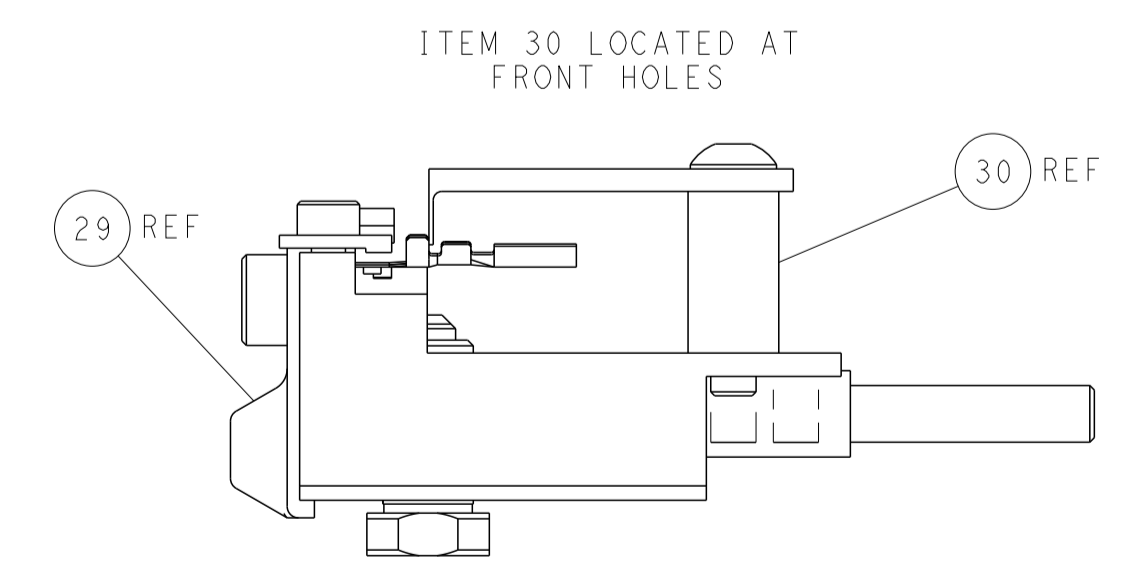
# CAM POSITIONS



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)

DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH ±		DWN B. WEAVER 25AUG2011 CHK C. MOYER 25AUG2011 APVD T. ELBIN 25AUG2011 PRODUCT SPEC APPLICATION SPEC WEIGHT Customer Accessible Production Drawing		NAME Ocean Side Feed Applicator SIZE CAGE CODE DRAWING NO A1 00779 C=2151470 SCALE 1:2 SHEET 4 OF 4 REV M1		RESTRICTED TO - - - -	
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