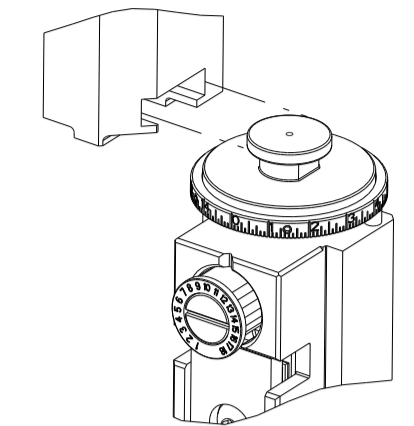


ATLANTIC VERSION TERMINATOR  
 INTERFACE ADAPTER



PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151478-1	G	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2151478-2	G	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
3-2151478-2	G	FINE CRIMP HEIGHT ADJUST	DOUBLE ACTING PNEUMATIC WITH SENSORS
7-2151478-1	G	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2151478-2	G	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2151478-7	G	CRIMP TOOLING KIT	-

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 SPECIFICATION	114-18464		
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

- 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.
- MAXIMUM INSULATION CRIMP WIDTH 2.05mm & MAXIMUM INSULATION CRIMP HEIGHT 2.05mm. SEE APPLICATION SPECIFICATION TO CLARIFY.
- 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 & 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.

LOC	DIST	REVISIONS					
A	66	P	LTN	DESCRIPTION	DATE	OWN	APVD
		E		ECR-18-008490	04JUN2018	MZ	KZ
		F		ECR-19-010974	15JUL2019	FJ	TE
		F1		ECR-21-005485	17MAY2021	AJ	YY
		G		ECR-22-133686	24MAR2022	FZ	GB

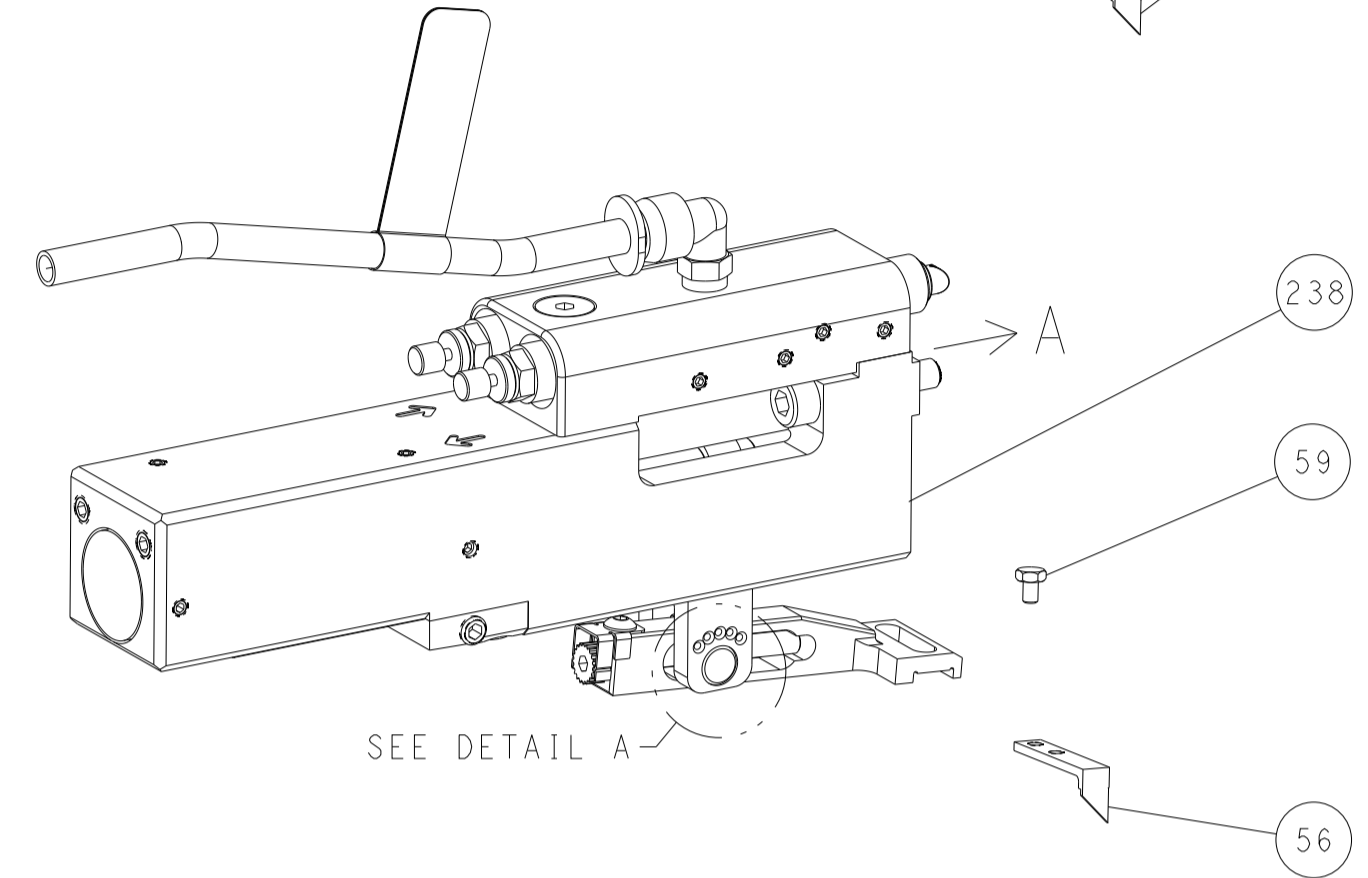
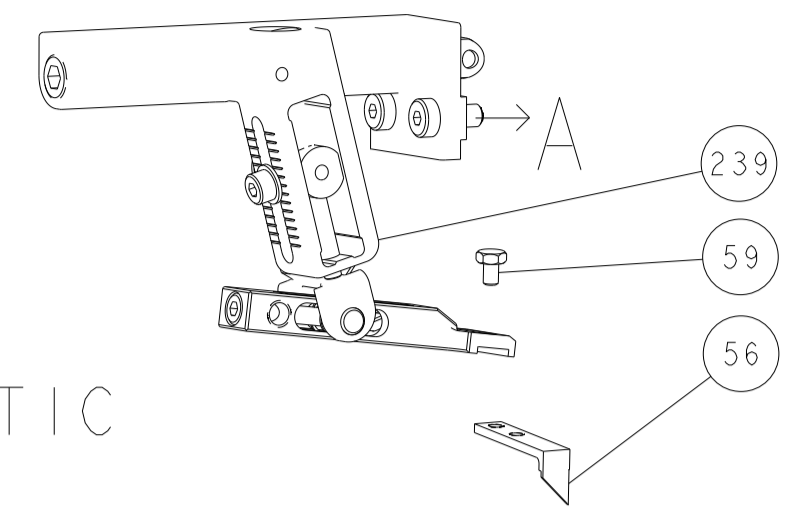
	-	-	-	1	-	-	2844950-1	AIR FEED MODULE	290
	-	1	-	-	1	-	2119641-1	FEED CAM, AIR FEED	248
	-	1	1	1	1	1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244
	-	1	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
	-	1	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
	-	1	1	1	1	1	7-18023-7	SCR, SKT HD CAP 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
	-	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
	-	1	2	-	-	1	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	7-1752356-7	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	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	1803095-3	FLOATING SHEAR, FRONT	9
	1	2	2	1	1	1	1333231-9	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	2	2	1	1	1	1-1633989-5	CRIMPER, INSULATION, SPECIAL	3
	-	-	-	-	-	-	-	-	2
	1	2	2	1	1	1	3-456402-3	CRIMPER, WIRE PREMIUM	1
	-	77	-72	-71	-32	-2	-1	PART NO	ITEM NO
								DESCRIPTION	

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

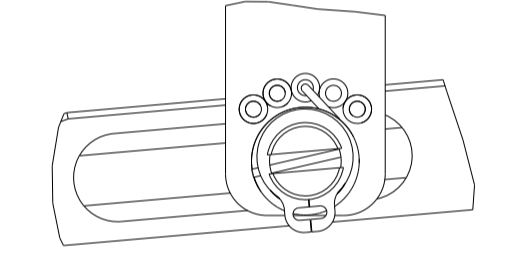
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mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES ±	FINISH
MATERIAL				WEIGHT	SCALE	SHEET	REV
Customer Accessible Production Drawing				SCALE	1:2	SHEET 1 OF 4	REV G

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

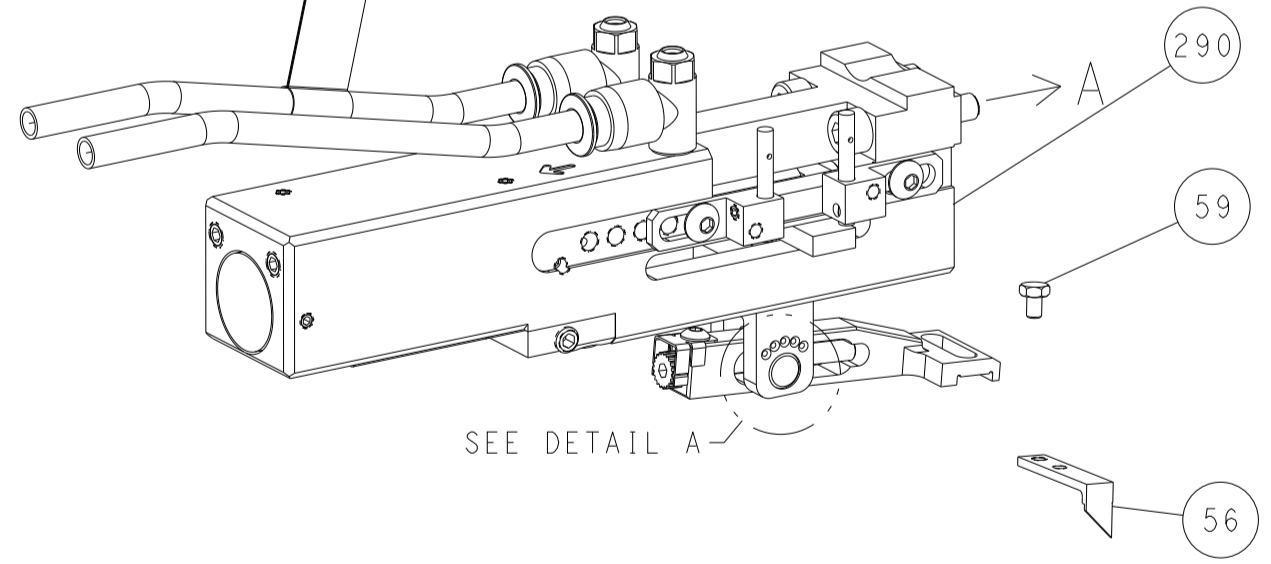
# FEED TYPE MECHANICAL



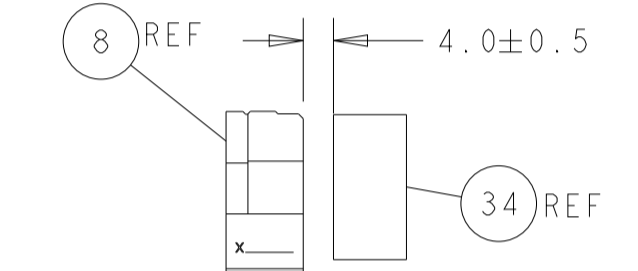
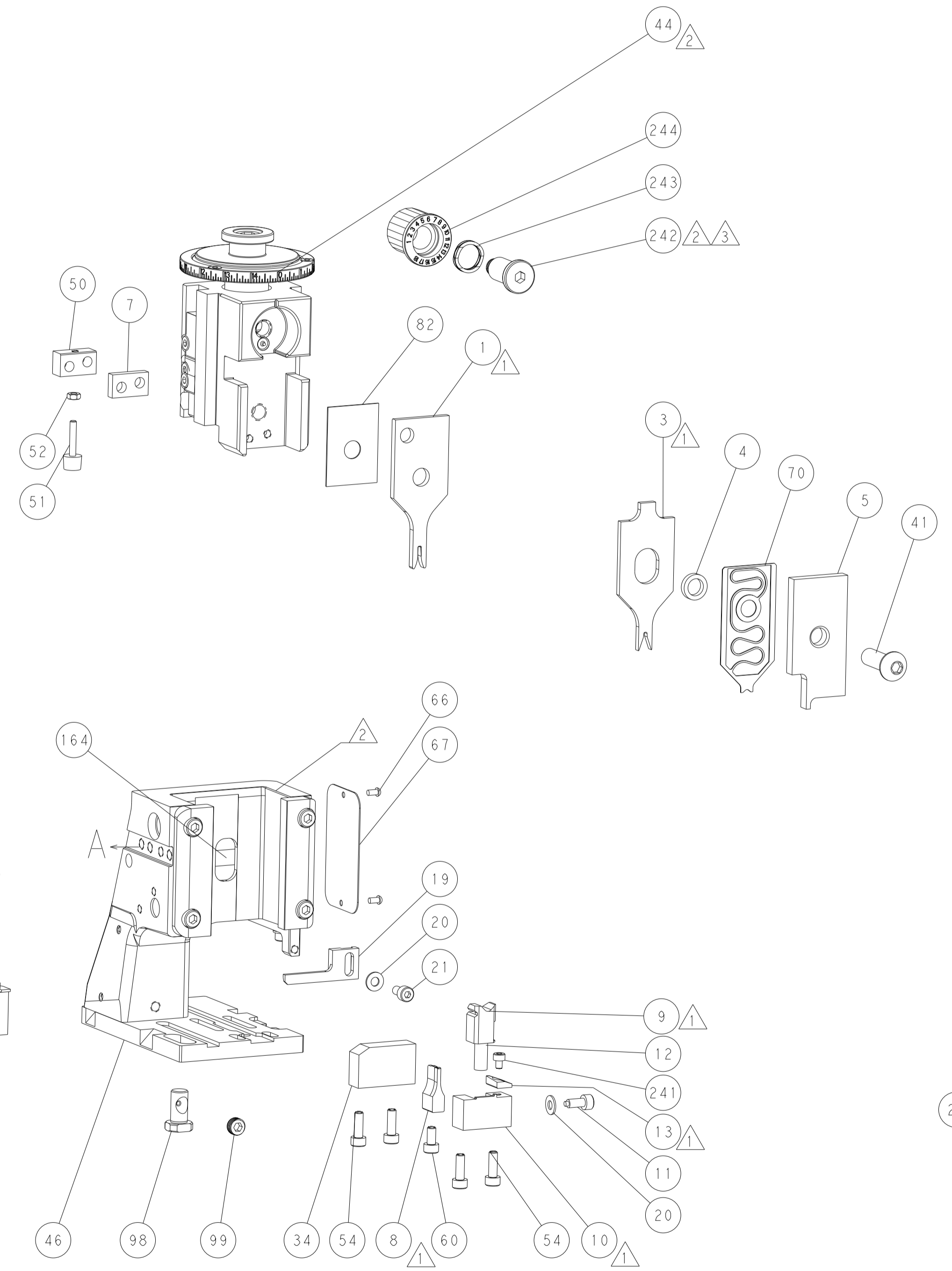
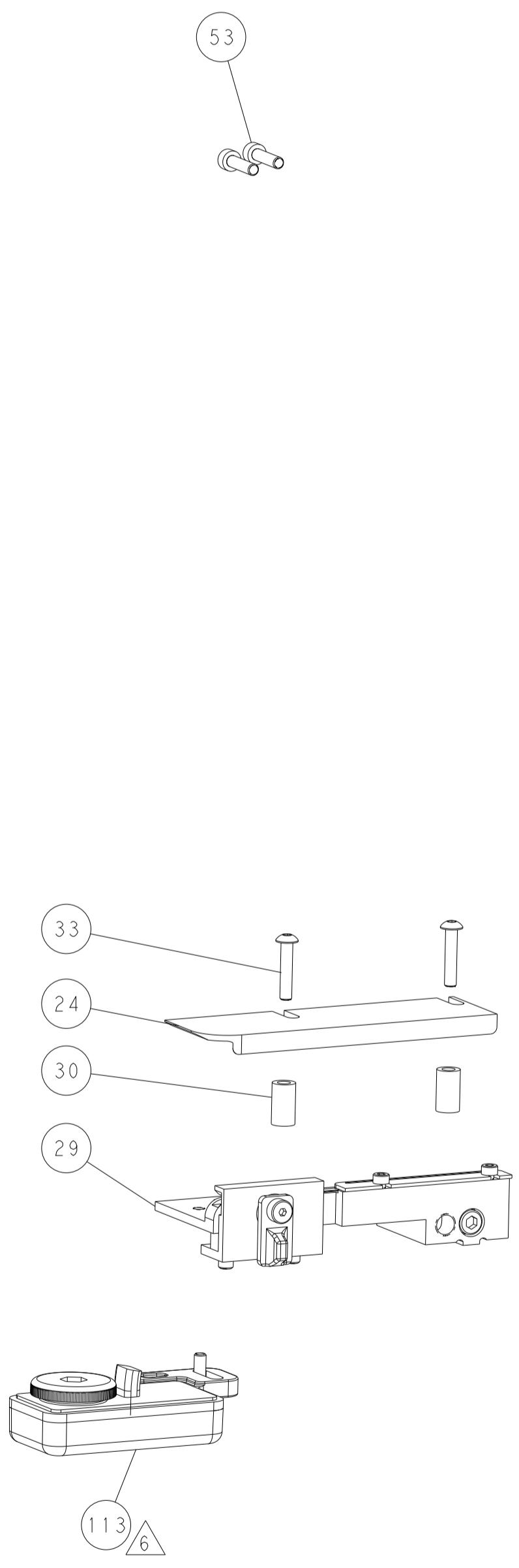
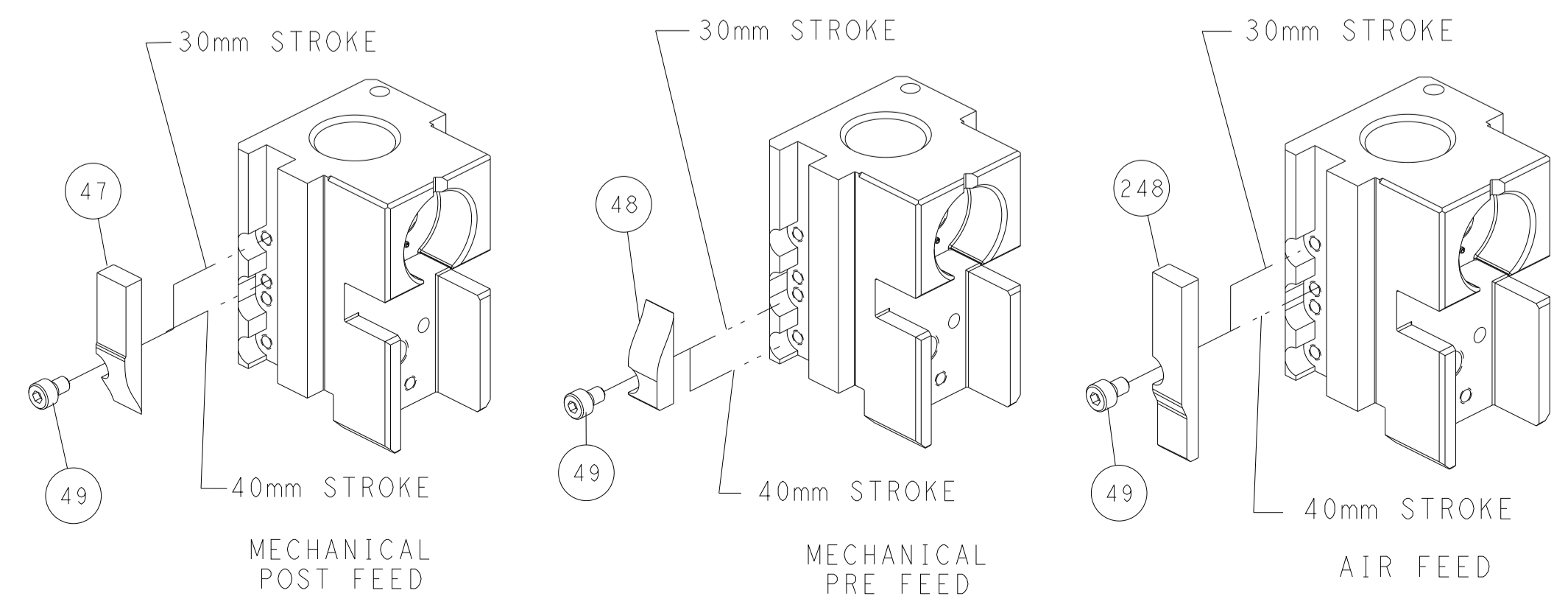
FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



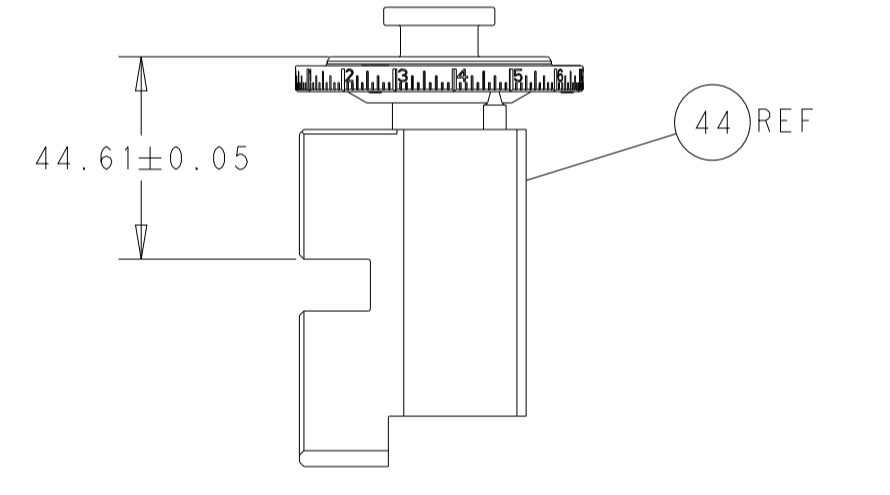
DOUBLE ACTING PNEUMATIC WITH SENSORS



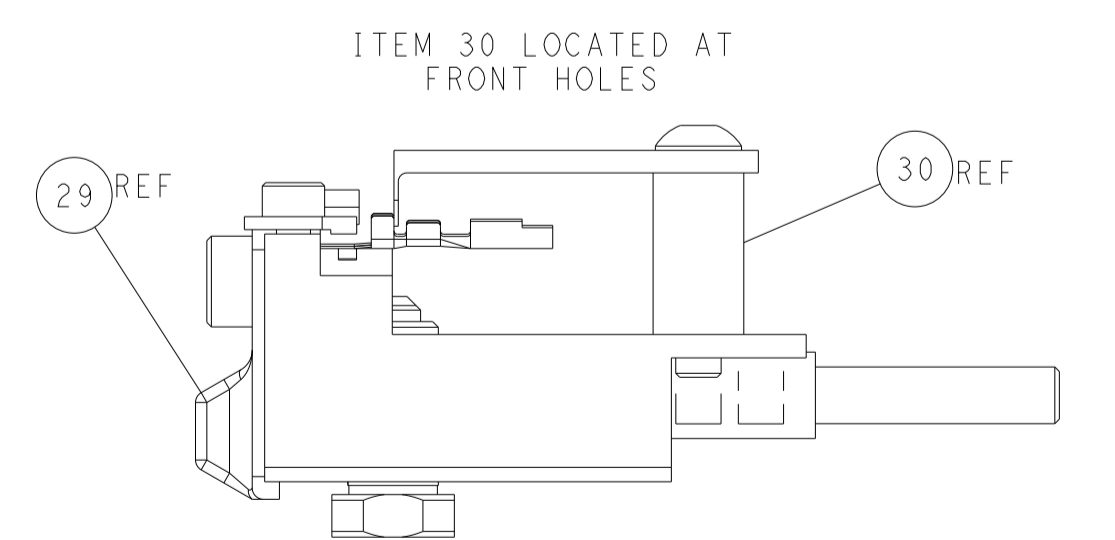
## CAM POSITIONS



TERMINAL SUPPORT LOCATION



RAM SET-UP



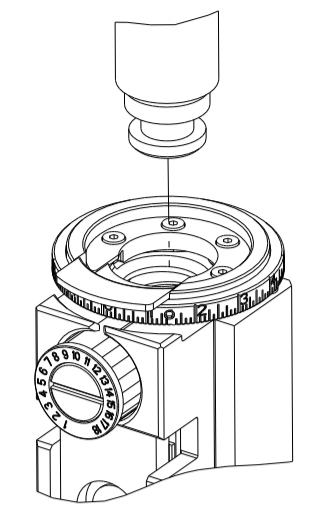
FEED TRACK POSITION GUIDE BY INSULATION BARREL

**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 R. HUANG 27AUG2012		TE Connectivity Harrisburg, PA 17105-3608	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	NAME Ocean Side Feed Applicator	RESTRICTED TO
MATERIAL:	FINISH:	WEIGHT:	SCALE: 1:2	SHEET: 2 of 4	REV: G	Customer Accessible Production Drawing	

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2151478-1	G	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2151478-2	G	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
4-2151478-2	G	FINE CRIMP HEIGHT ADJUST	DOUBLE ACTING PNEUMATIC WITH SENSORS
7-2151478-7	G	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: MCON-1.2 LL			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
3.30-3.90 mm [1.130-.154 IN]		Ø1.40-1.60 mm [1.055-.063 IN]	
TERMINAL APPLICATION SPECIFICATION	114-18464		
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 [1.034+/-0.011]	7.8

- 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.
  - MAXIMUM INSULATION CRIMP WIDTH 2.05mm & MAXIMUM INSULATION CRIMP HEIGHT 2.05mm. SEE APPLICATION SPECIFICATION TO CLARIFY.
  - 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)

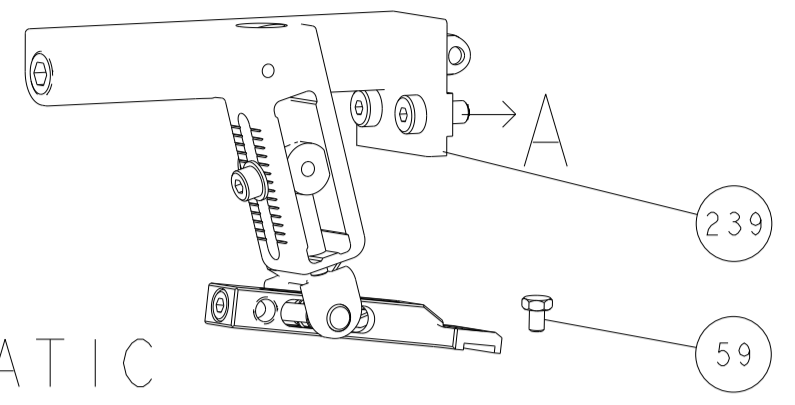
LOC	DIST	REVISIONS					
A	66	P	LTN	DESCRIPTION	DATE	OWN	APVD
		-	-	SEE SHEET 1	-	-	-

-	1	-	-	2844950-1	AIR FEED MODULE	290	
-	1	1	1	2119082-9	CAM, SNATL, INSULATION ADJUSTMENT	244	
-	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243	
3	-	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	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	7-1752356-7	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	-	-	-	-	-	13	
-	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	-	-	-	-	-	10	
1	-	-	-	-	-	9	
1	1	1	1	1333231-9	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	1-1633989-5	CRIMPER, INSULATION, SPECIAL	3	
-	-	-	-	-	-	2	
1	1	1	1	3-456402-3	CRIMPER, WIRE PREMIUM	1	
-77	-42	-22	-21	PART NO	DESCRIPTION	ITEM NO	

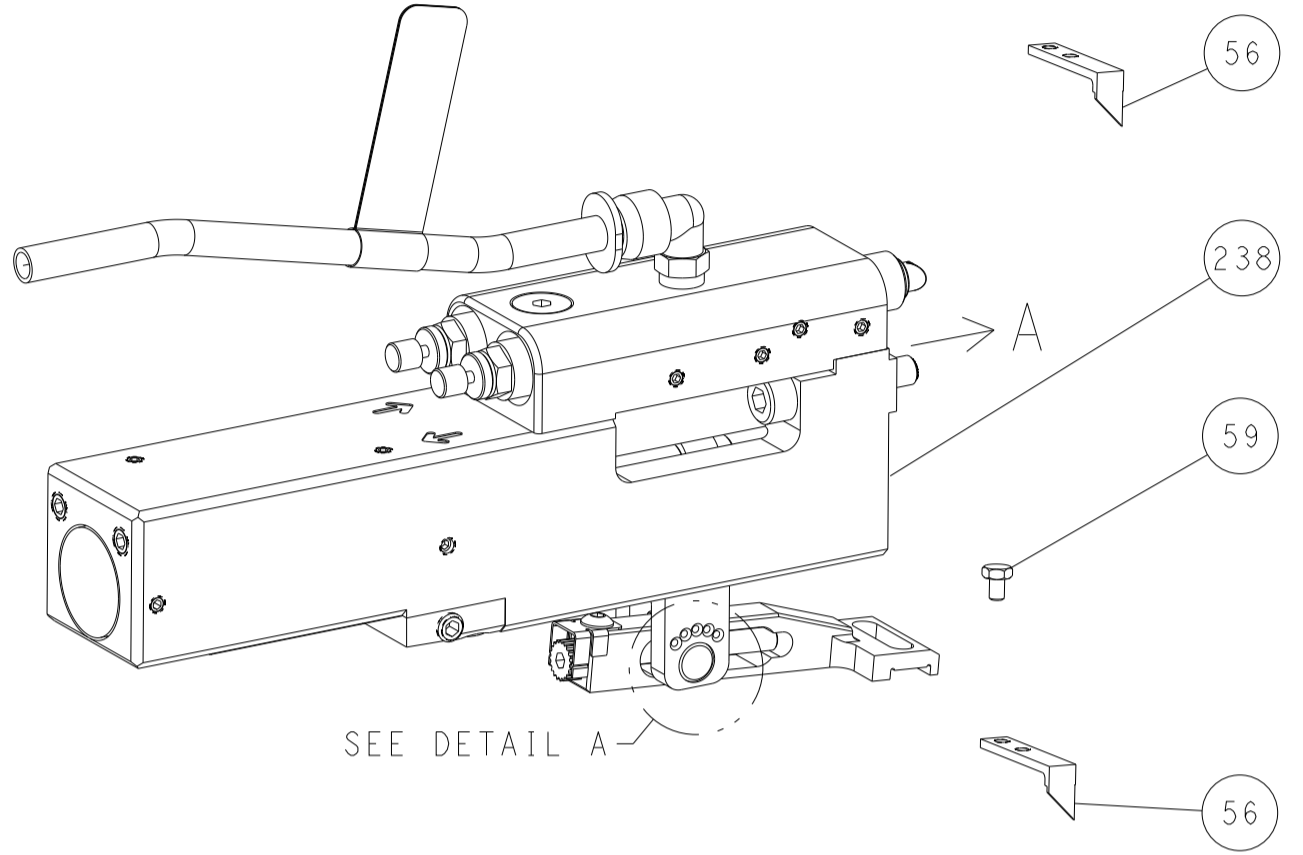
<small>THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION 20</small> <small>© COPYRIGHT 20 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.</small>		DWN CHK S.XI APVD S.XI	27AUG2012 27AUG2012 27AUG2012	TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH		NAME Ocean Side Feed Applicator
MATERIAL:		WEIGHT:	SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2151478	RESTRICTED TO:
Customer Accessible Production Drawing		SCALE: 1:2	SHEET: 3 OF 4	REV: G

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

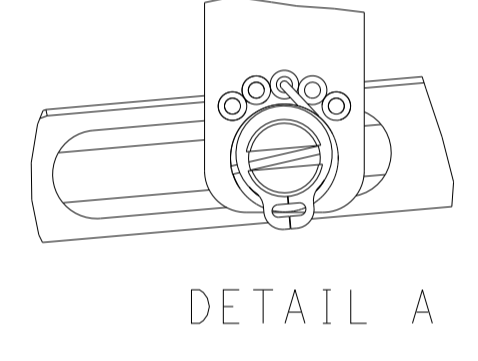
# FEED TYPE MECHANICAL



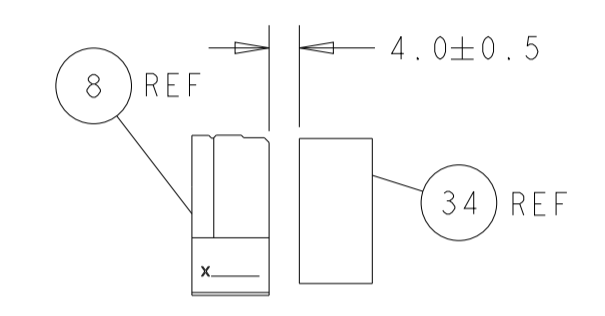
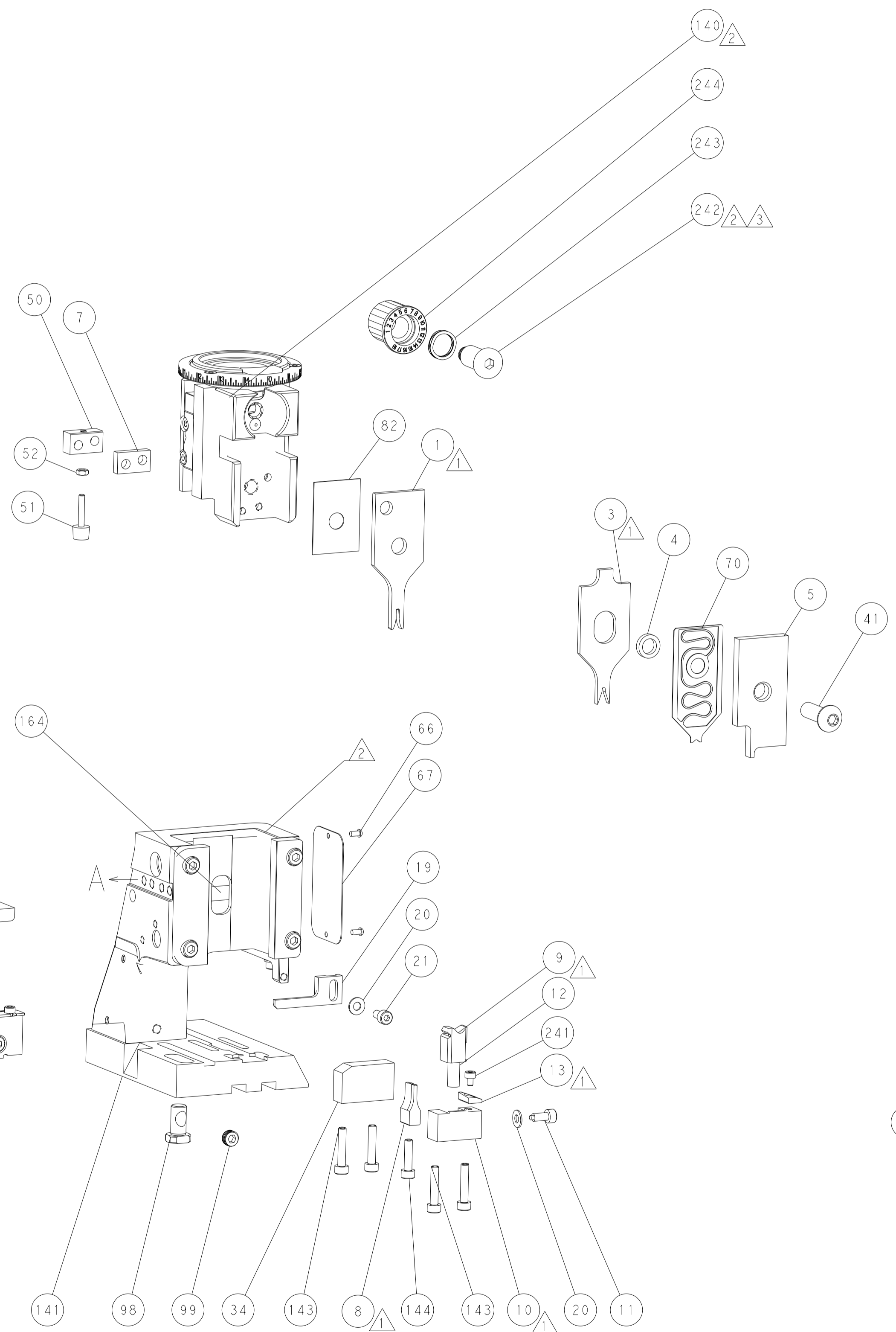
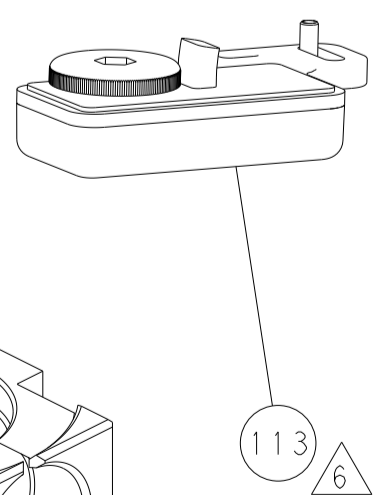
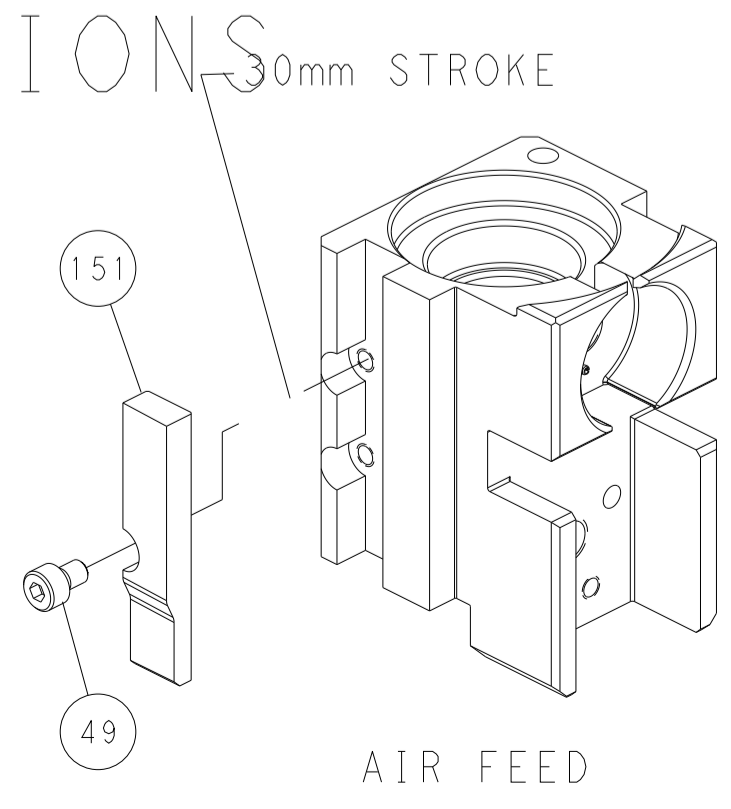
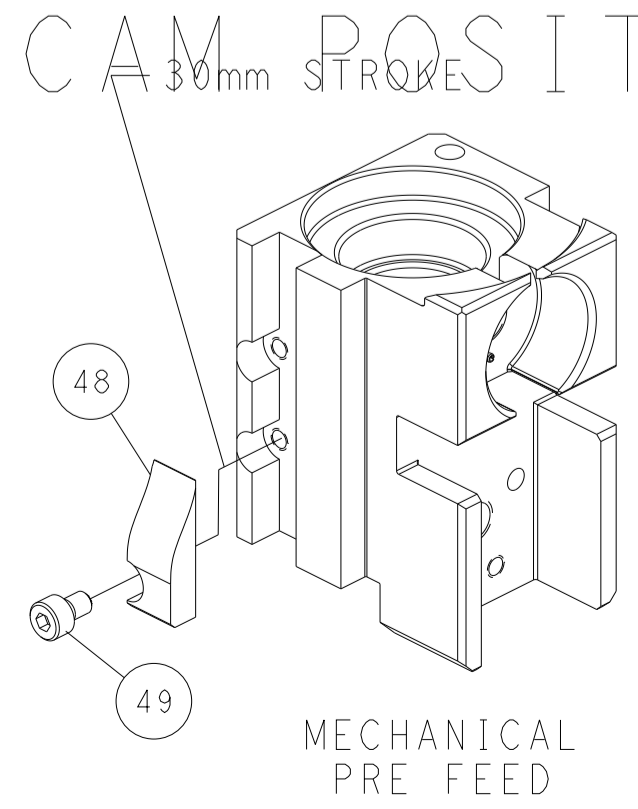
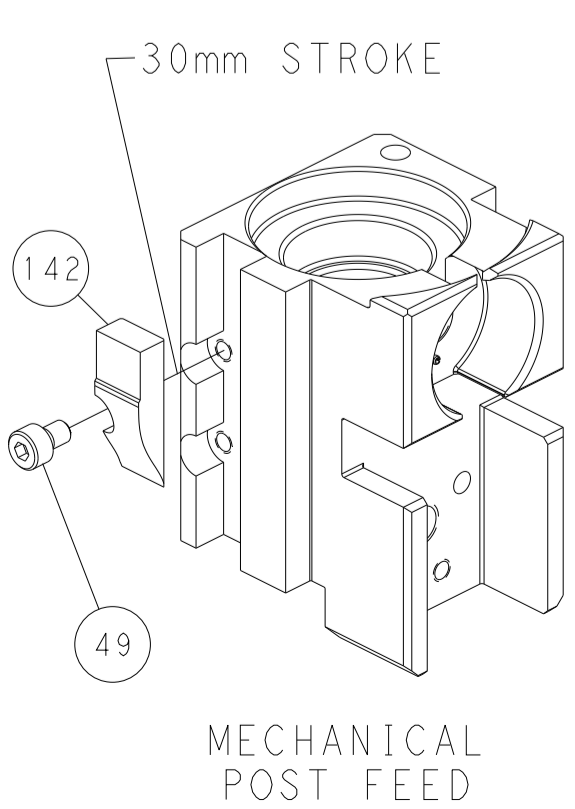
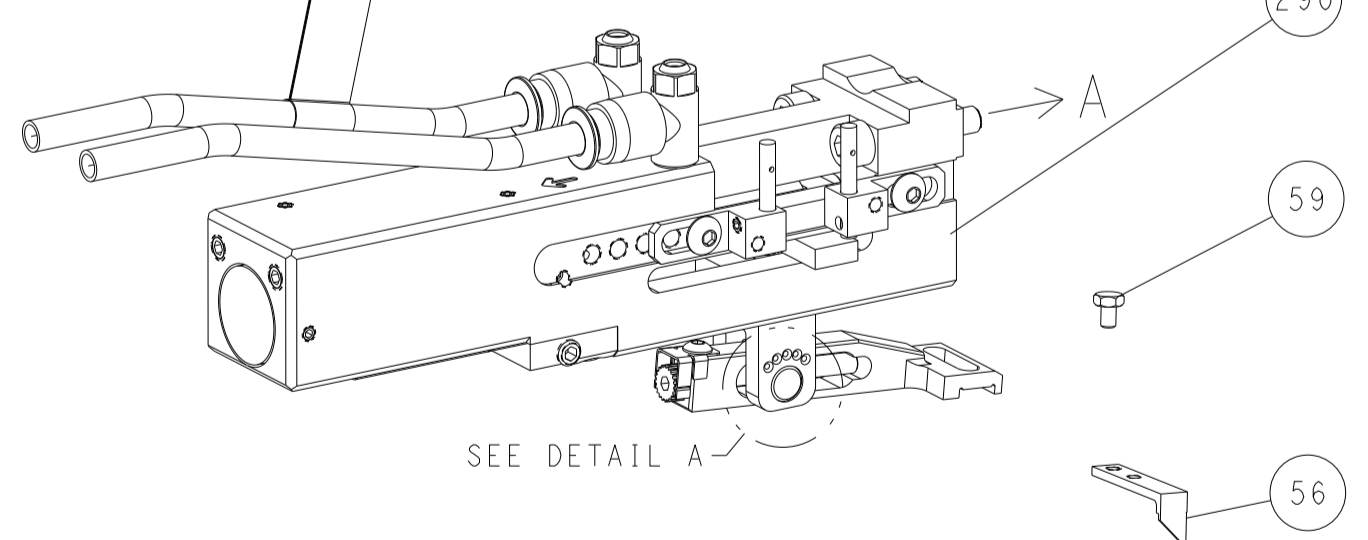
# PNEUMATIC



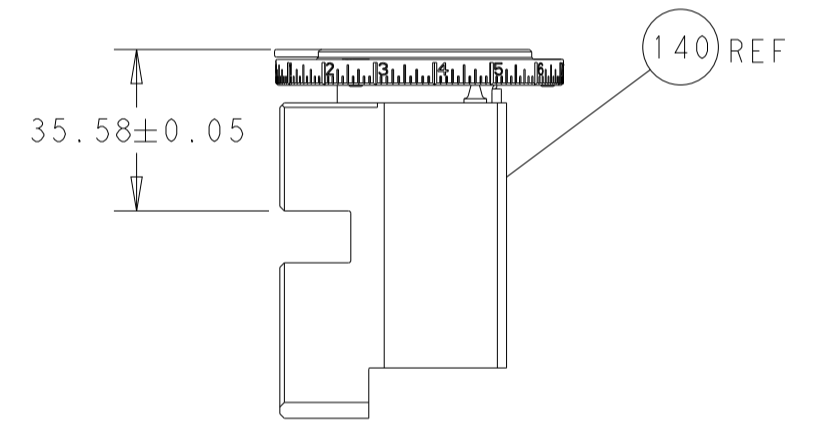
# FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



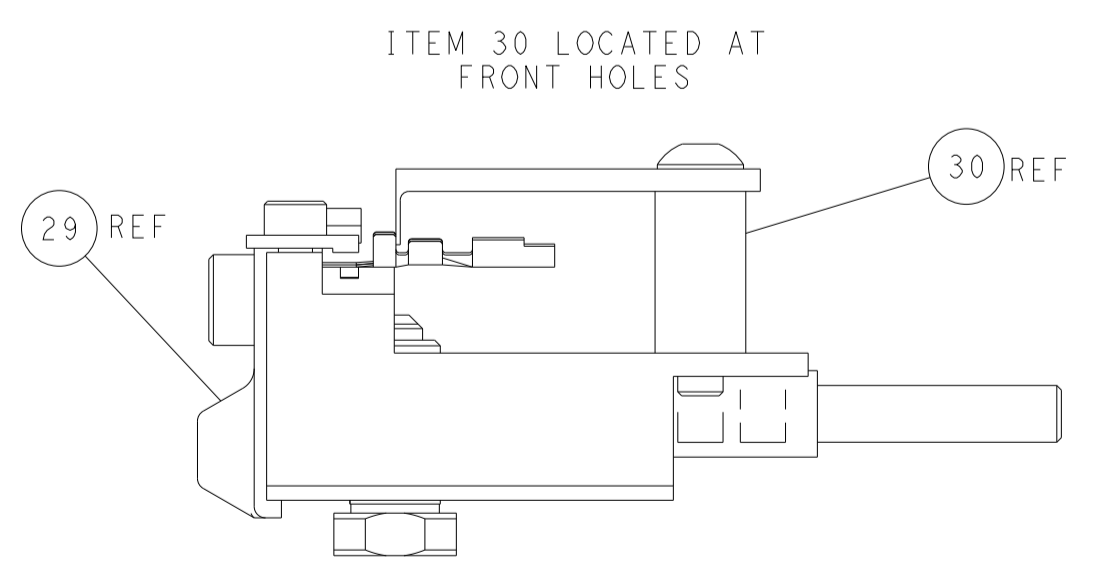
# DOUBLE ACTING PNEUMATIC WITH SENSORS



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:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG: H. HUANG 27AUG2012		TE Connectivity	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	Harrisburg, PA 17105-3608	
MATERIAL:		FINISH:		CHK: S. XI 27AUG2012		NAME: Ocean Side Feed Applicator	
				APVD: S. XI 27AUG2012		SIZE: A1	
				PRODUCT SPEC:		CAGE CODE: 00779	
				APPLICATION SPEC:		DRAWING NO: 2151478	
				WEIGHT:		SCALE: 1:2	
				Customer Accessible Production Drawing		SHEET 4 OF 4 REV G	