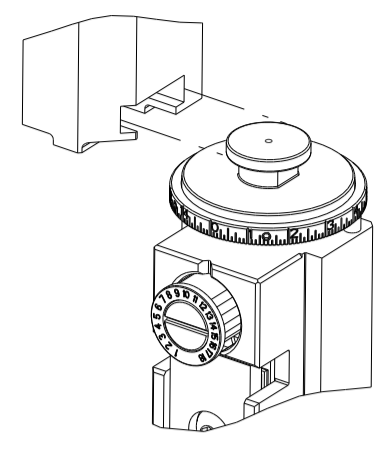


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151037-1	S	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2151037-2	S	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
3-2151037-2	S	FINE CRIMP HEIGHT ADJUST	DOUBLE ACTING PNEUMATIC WITH SENSORS
7-2151037-1	S	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2151037-2	S	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2151037-7	N	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: MCP 1.2MM CONTACT ASSEMBLY			
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE		
3.30-3.90 mm [.130-.154 IN]	Ø1.40-1.90 mm [.055-.075 IN]		
TERMINAL APPLICATION SPECIFICATION	114-18464		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
1452656-1	1452656-2	1452656-3	6-1452656-2
7-1452656-1	7-1452656-2	7-1452656-3	
1718350-1	1718350-2	1718350-3	

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.75mm <sup>2</sup>	1.05+/-0.03 [.041+/-0.001]	6.5
0.50mm <sup>2</sup>	0.93+/-0.03 [.037+/-0.001]	7.5
20 AWG	0.93+/-0.03 [.037+/-0.001]	7.5

- 1 RECOMMENDED SPARE PARTS
  - 2 REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION & 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 TERMINAL LUBRICANT IS RECOMMENDED.
  - 6 THIS APPLICATOR IS EQUIPPED WITH THE DOUBLE ACTING FEED WITH SENSORS AND IS APPLICATION SPECIFIC. IT DOES NOT REQUIRE ITEMS 49 & 248.
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.

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

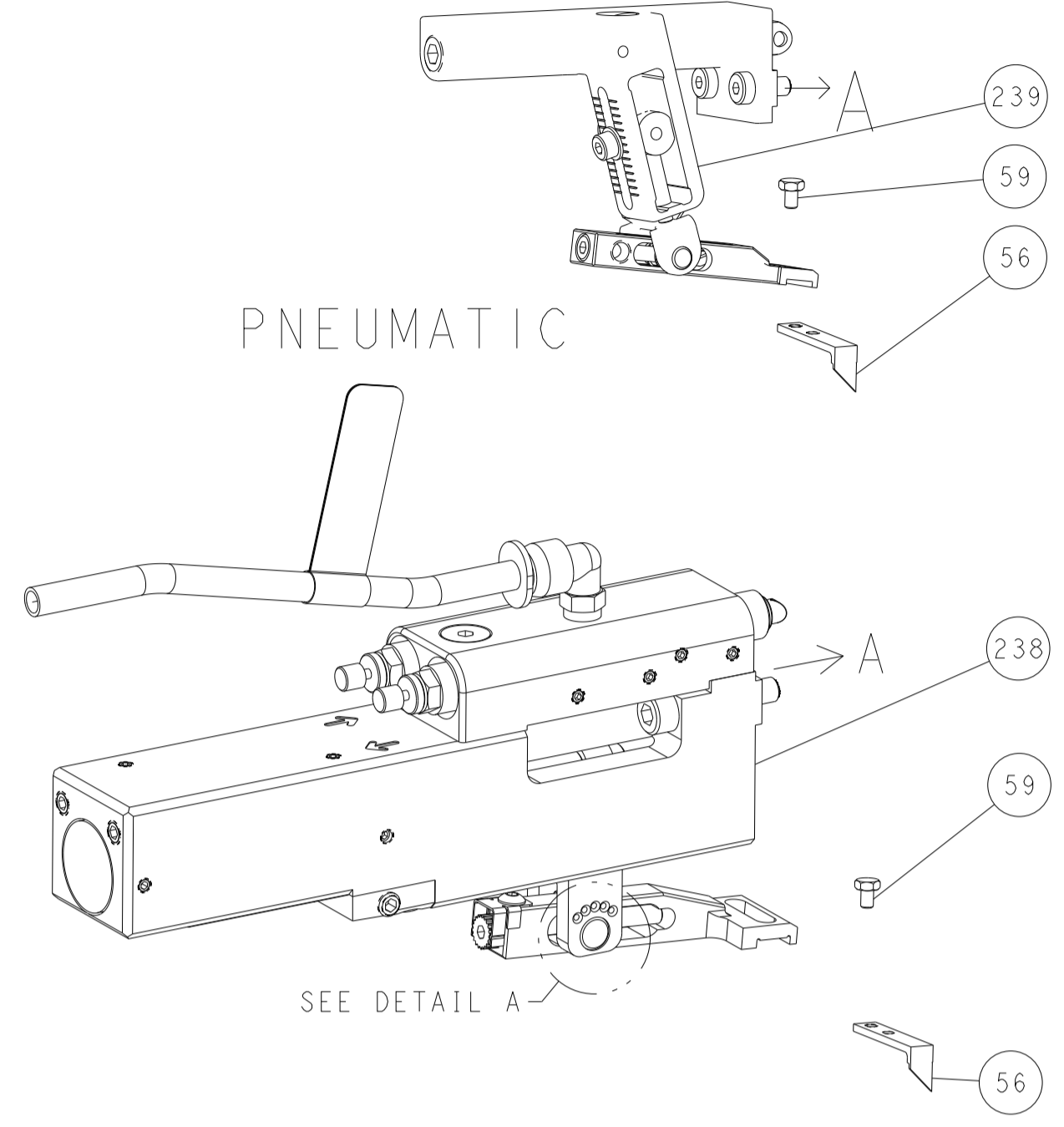
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P	LTN	DESCRIPTION	DATE	OWN	APVD
A	66				
P		ECR-18-004053	19MAR2018	JAH	JDG
R		ECR-19-005393	03APR2019	JAH	CT
R1		ECR-21-003615	25MAR2021	FZ	YY
S		ECR-23-178967	20JUN2023	FZ	JAH

-	-	-	1	-	-	2844950-1	AIR FEED MODULE	290
-	1	-	-	1	-	2119641-1	FEED CAM, AIR FEED	248
-	1	1	1	1	1	2119082-5	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	1-18028-2	WASHER, FLAT, REG M4	119
-	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
-	2	2	2	2	2	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	57
-	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
-	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	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	1752356-6	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	1320928-6	STRIP GUIDE	24
-	1	1	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
-	1	1	1	1	1	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	1803095-1	FLOATING SHEAR, FRONT	9
-	1	2	2	1	1	1332231-9	ANVIL, COMBINATION, SPECIAL	8
-	1	1	1	1	1	240641-4	SPACER	7
-	1	1	1	1	1	2119757-8	DEPRESSOR, SHEAR	5
-	1	1	1	1	1	4-238011-2	BLOCK, CRIMPER SPACER	4
-	1	2	2	1	1	1633989-1	CRIMPER, INSULATION, SPECIAL	3
-	1	2	2	1	1	3-456402-3	CRIMPER, WIRE PREMIUM	1

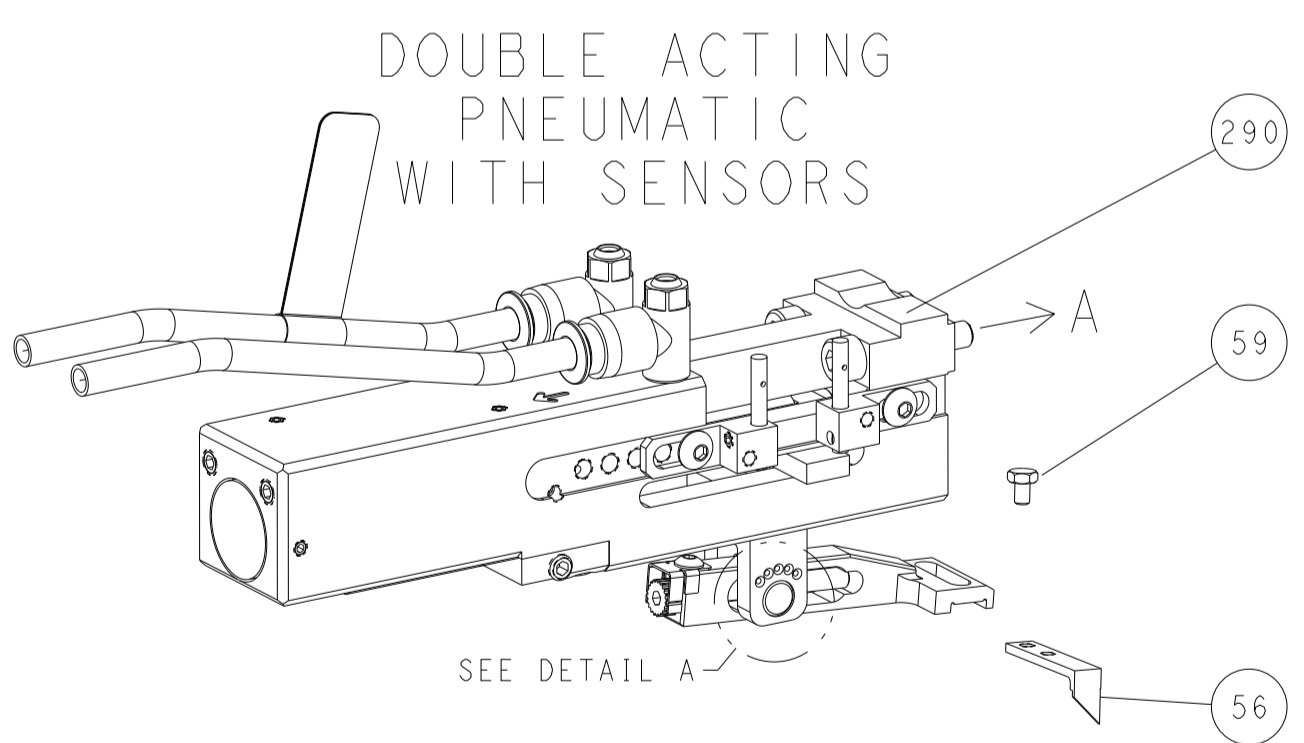
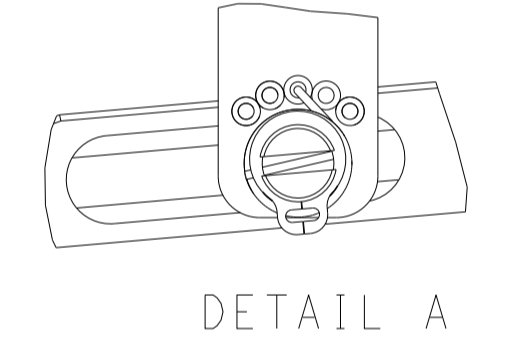
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mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES	FINISH				1:2	1	4	S	

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

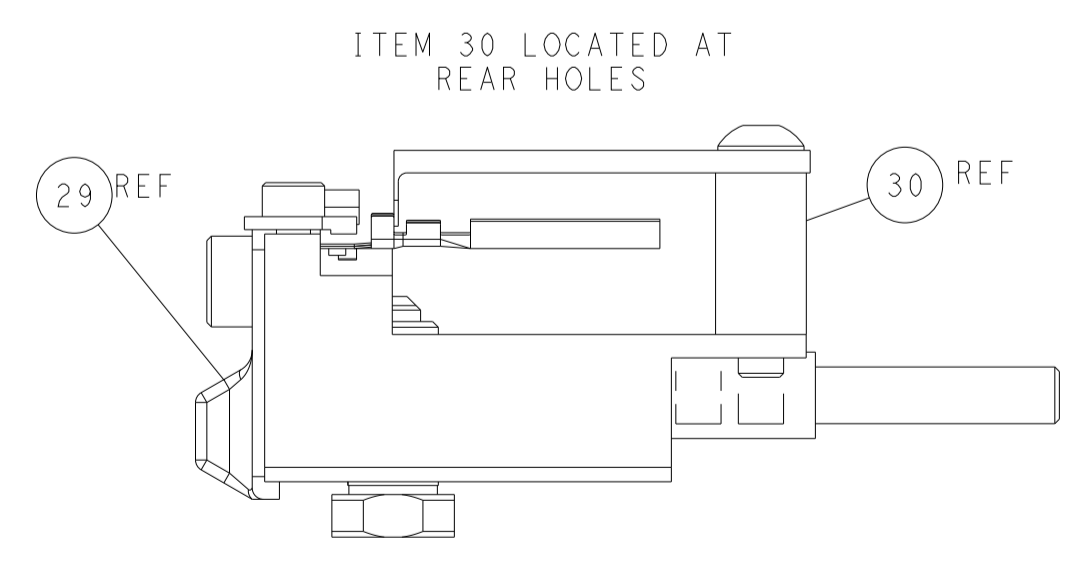
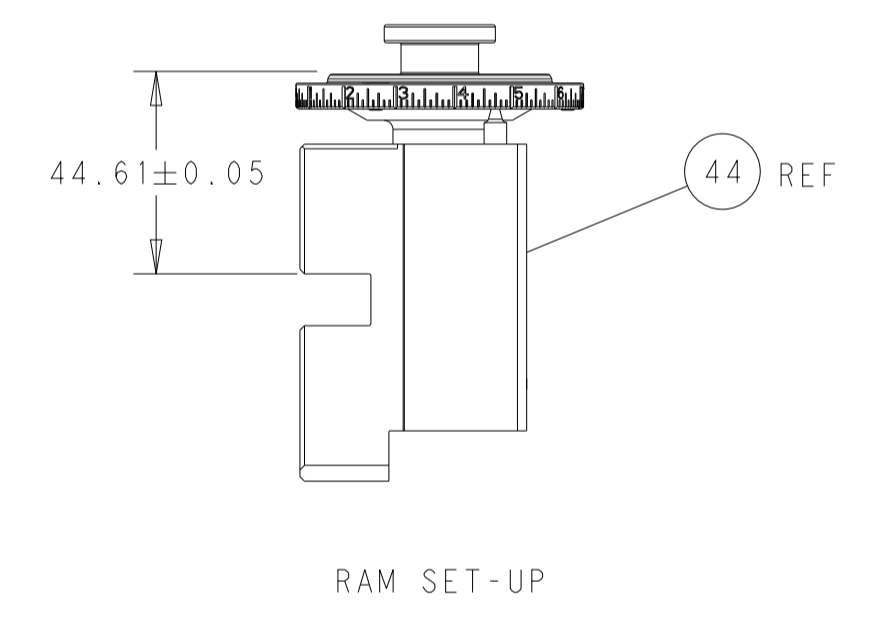
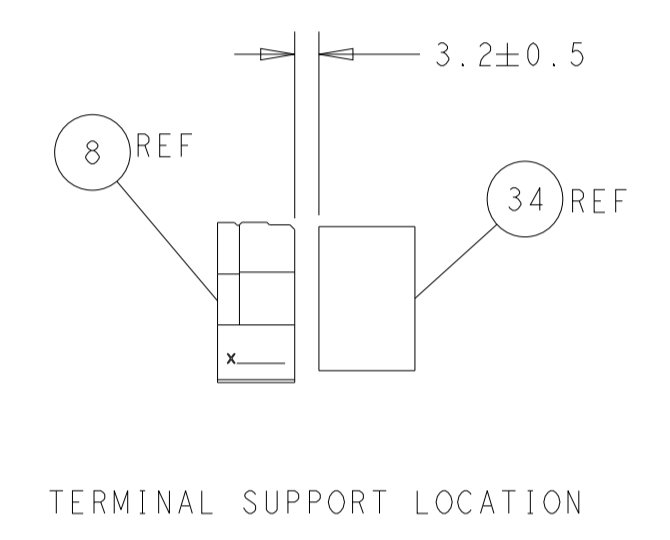
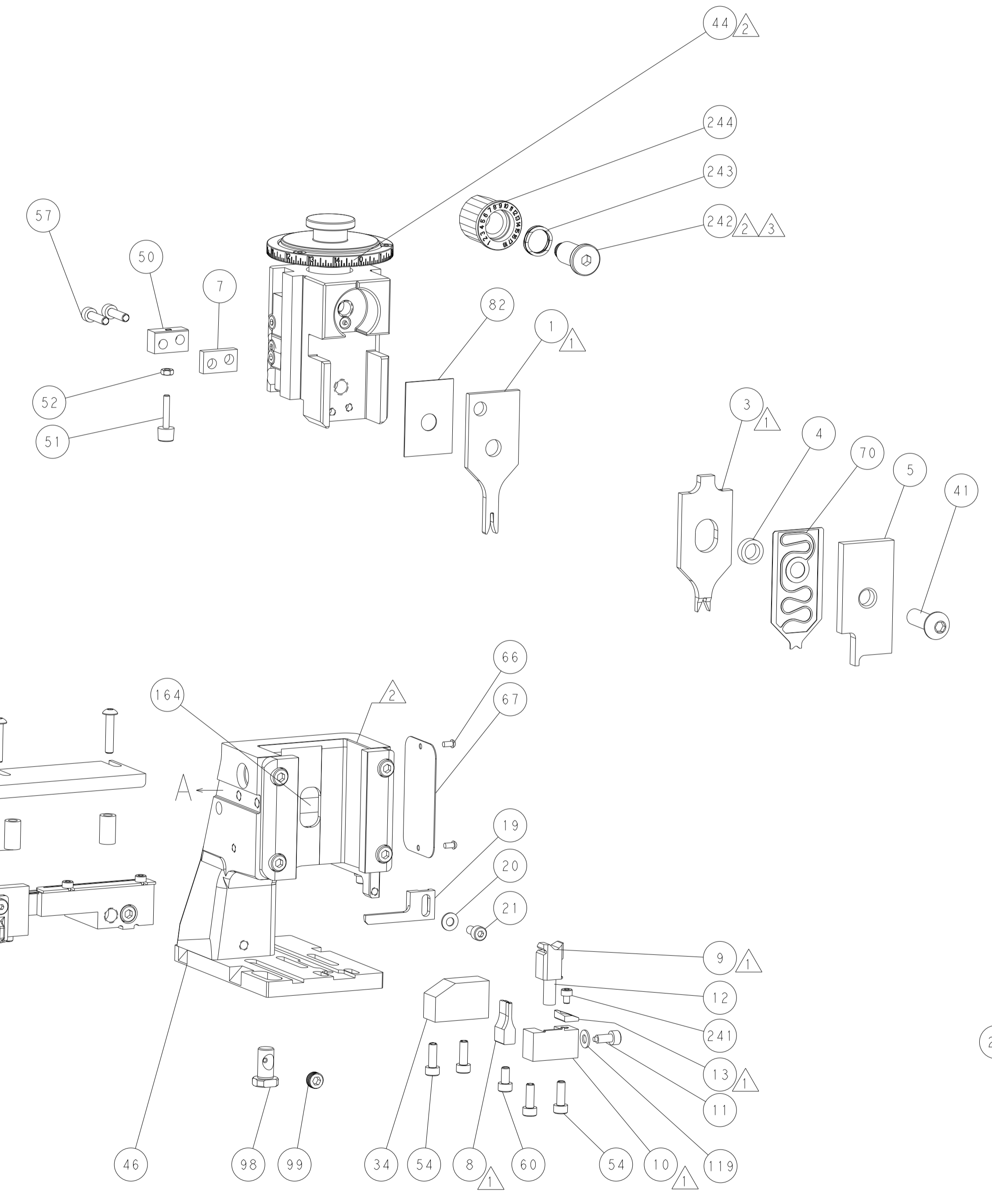
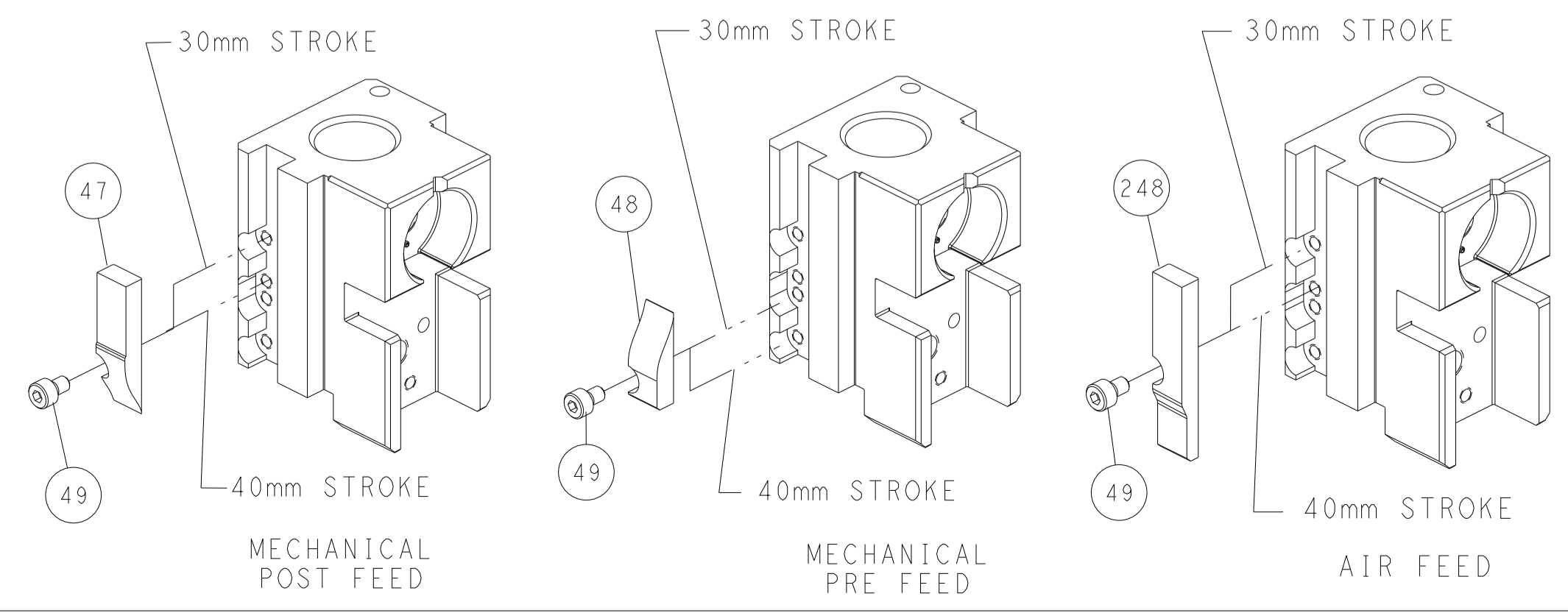
# FEED TYPE MECHANICAL



FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



# CAM POSITIONS



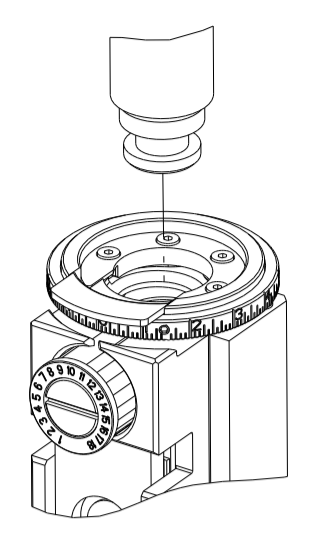
FEED TRACK POSITION GUIDE BY INSULATION BARREL

**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		TE Connectivity	
mm		0 PLC	±	C. CHEN	08SEP2011	Harrisburg, PA 17105-3608	
0 PLC	±	1 PLC	±	CHK S. XI	08SEP2011	NAME	
2 PLC	±	3 PLC	±	APVD J. CRUZ	08SEP2011	Ocean Side Feed Applicator	
4 PLC	±	ANGLES	±	PRODUCT SPEC		SIZE	CAGE CODE
MATERIAL		FINISH		APPLICATION SPEC		A1	00779
				WEIGHT		©=2151037	RESTRICTED TO
				Customer Accessible Production Drawing	SCALE 1:2	SHEET 2 OF 4	REV S

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2151037-1	S	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2151037-2	S	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
4-2151037-2	S	FINE CRIMP HEIGHT ADJUST	DOUBLE ACTING PNEUMATIC WITH SENSORS
7-2151037-7	N	CRIMP TOOLING KIT	-

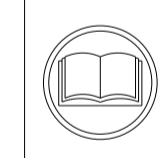
PACIFIC VERSION TERMINATOR INTERFACE ADAPTER



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: MCP 1.2MM CONTACT ASSEMBLY			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
3.30-3.90 mm [1.30-.154 IN]		Ø1.40-1.90 mm [.055-.075 IN]	
TERMINAL APPLICATION SPECIFICATION	114-18464	-	-
TERMINALS APPLIED <sup>5</sup> / <sub>6</sub>			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
1452656-1	1452656-2	1452656-3	6-1452656-2
7-1452656-1	7-1452656-2	7-1452656-3	
1718350-1	1718350-2	1718350-3	

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.75mm2	1.05 +/- 0.03 [.041 +/- .001]	6.5
0.50mm2	0.93 +/- 0.03 [.037 +/- .001]	7.5
20 AWG	0.93 +/- 0.03 [.037 +/- .001]	7.5



- <sup>1</sup> RECOMMENDED SPARE PARTS
  - <sup>2</sup> REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION & STORAGE OF APPLICATOR.
  - <sup>3</sup> APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242.
  - <sup>4</sup> 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.
  - <sup>5</sup> TERMINAL LUBRICANT IS RECOMMENDED.
  - <sup>6</sup> THIS APPLICATOR IS EQUIPPED WITH THE DOUBLE ACTING FEED WITH SENSORS AND IS APPLICATION SPECIFIC. IT DOES NOT REQUIRE ITEMS 49 & 151.
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.

ENTRY LEVEL APPLICATOR		ITEM SUBSTITUTION LIST		
PART NUMBER	SAME AS	ITEM	ITEM DESCRIPTION	SUBSTITUTE PART NUMBER
8-2151037-1	2151037-1	1	WIRE CRIMPER	3-1803530-3
8-2151037-2	2151037-2	3	INSULATION CRIMPER	1803623-1
9-2151037-1	2-2151037-1	46	BASIC SUB -ASSEMBLY	1803940-9
9-2151037-2	2-2151037-2	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)

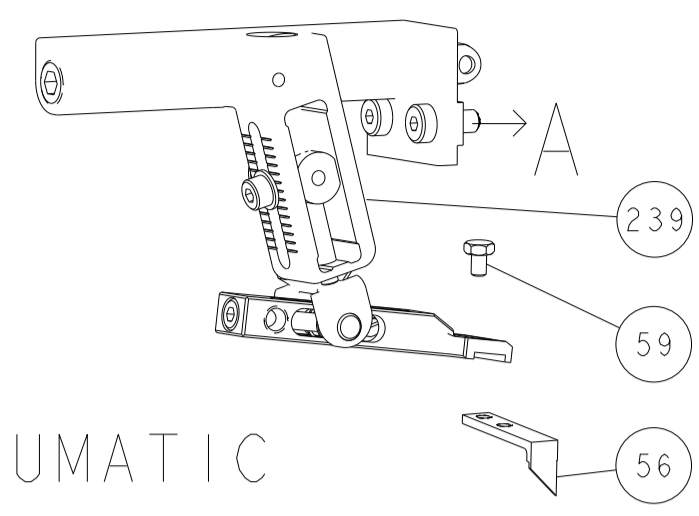
LOC	DIST	REVISIONS					
A	66	P	LTN	DESCRIPTION	DATE	OWN	APVD
		-	-	SEE SHEET 1	-	-	-

-	1	-	-	2844950-1	AIR FEED MODULE	290	
-	1	1	1	2119082-5	CAM, SNAIL, INSULATION ADJUSTMENT	244	
-	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243	
<sup>3</sup>	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	
<sup>6</sup>	-	-	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	
-	1	1	1	1-18028-2	WASHER, FLAT, REG M4	119	
<sup>5</sup>	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	
-	2	2	2	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	57	
-	1	1	1	1338685-1	PAWL, FEED	56	
-	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	
<sup>6</sup>	-	-	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	1320928-6	STRIP GUIDE	24	
-	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21	
-	1	1	1	1-18028-2	WASHER, FLAT, REG M4	20	
-	1	1	1	2119533-1	STRIPPER, SIDE FEED	19	
<sup>1</sup>	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	
<sup>1</sup>	1	1	1	2119805-1	SHEAR HOLDER, FRONT	10	
<sup>1</sup>	1	1	1	1803095-1	FLOATING SHEAR, FRONT	9	
<sup>1</sup>	1	1	1	1333231-9	ANVIL, COMBINATION, SPECIAL	8	
-	1	1	1	240641-4	SPACER	7	
-	1	1	1	2119757-8	DEPRESSOR, SHEAR	5	
-	1	1	1	4-238011-2	BLOCK, CRIMPER SPACER	4	
<sup>1</sup>	1	1	1	1633989-1	CRIMPER, INSULATION, SPECIAL	3	
<sup>1</sup>	1	1	1	3-456402-3	CRIMPER, WIRE PREMIUM	1	

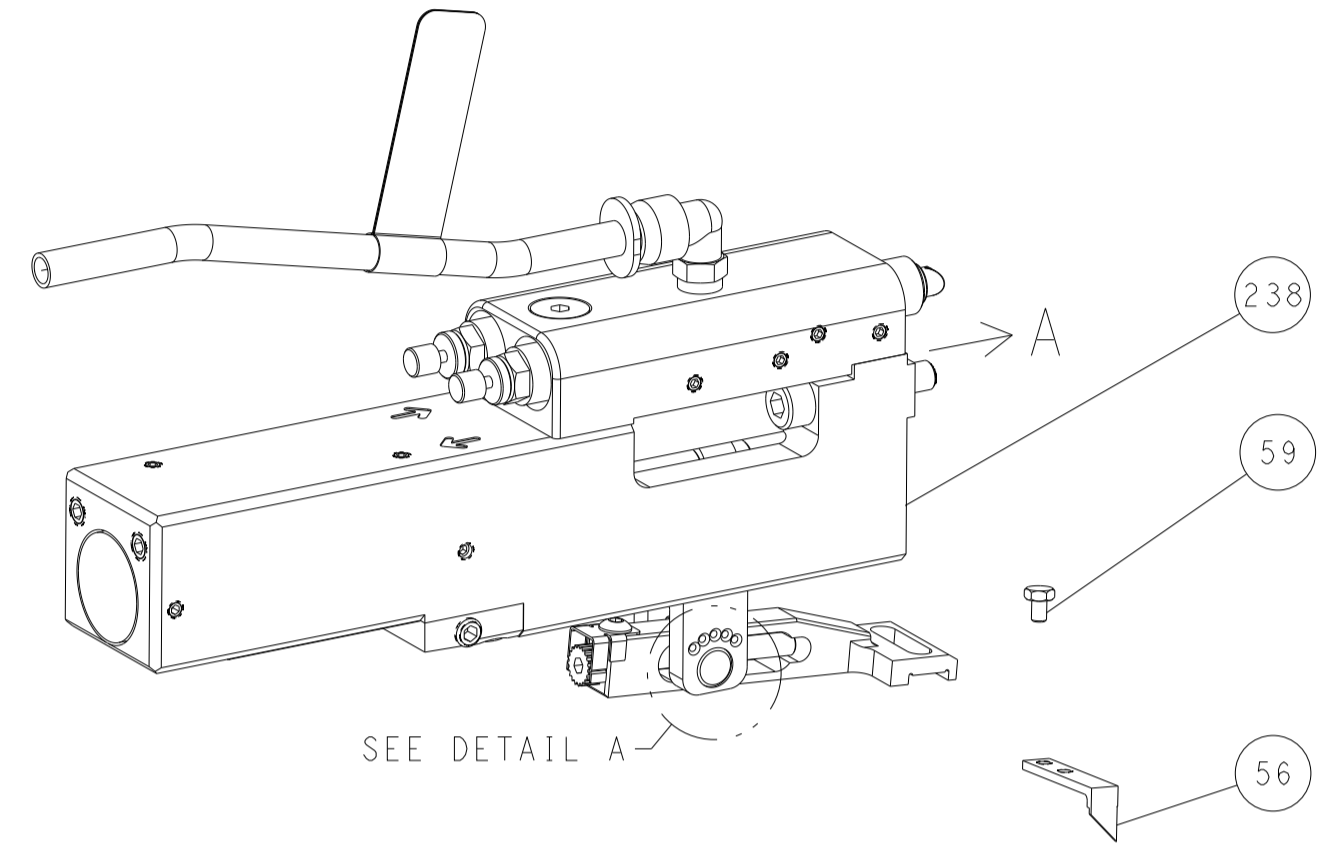
DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH		DWN C. CHEN 08SEP2011 CHK S. XI 08SEP2011 APVD J. CRUZ 08SEP2011 PRODUCT SPEC APPLICATION SPEC WEIGHT MATERIAL		NAME Ocean Side Feed Applicator SIZE CAGE CODE DRAWING NO A1 00779 C=2151037 RESTRICTED TO	
Customer Accessible Production Drawing				SCALE 1:2		SHEET 3 OF 4 REV S	

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

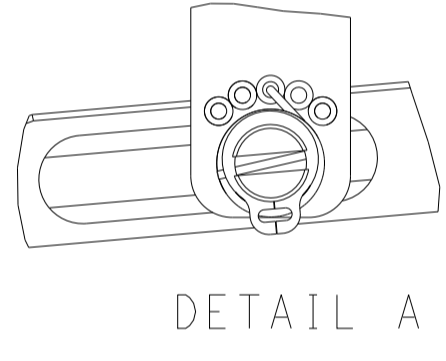
# FEED TYPE MECHANICAL



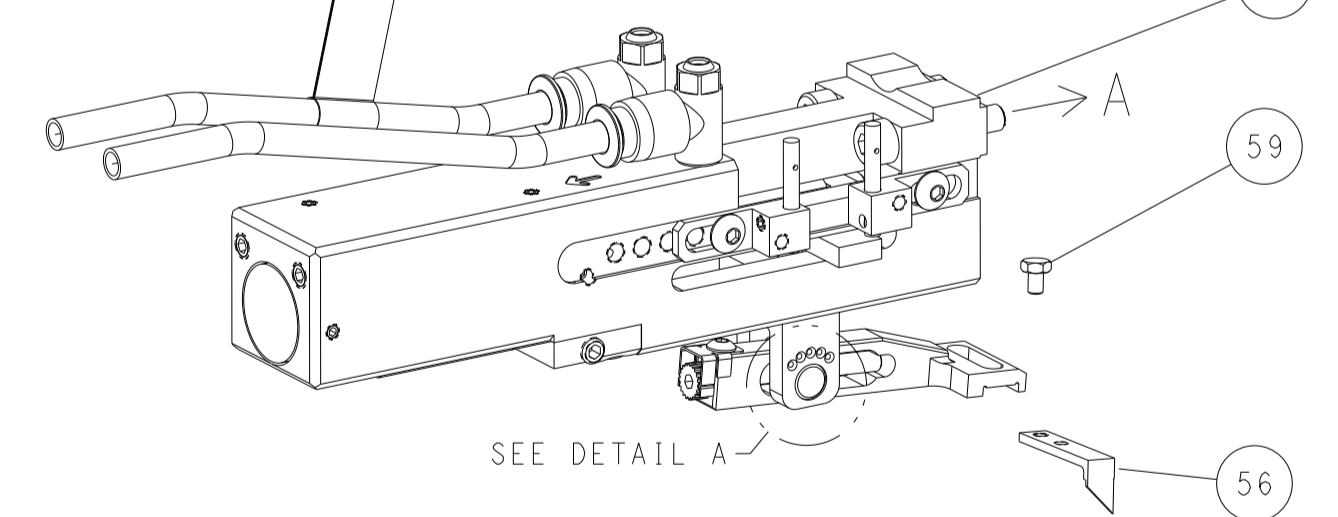
## PNEUMATIC



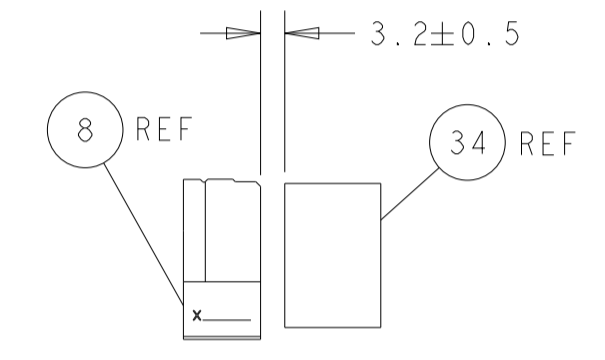
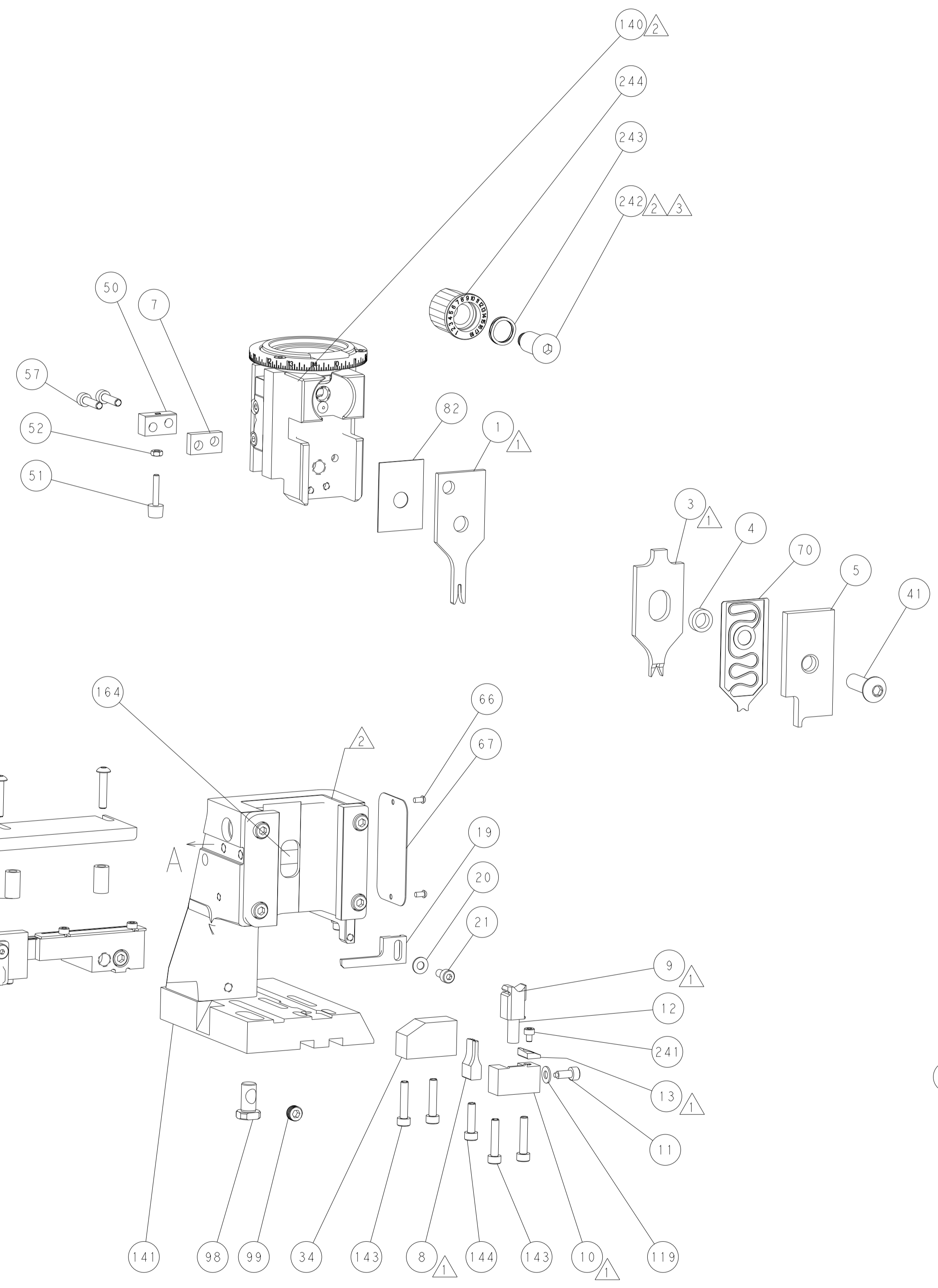
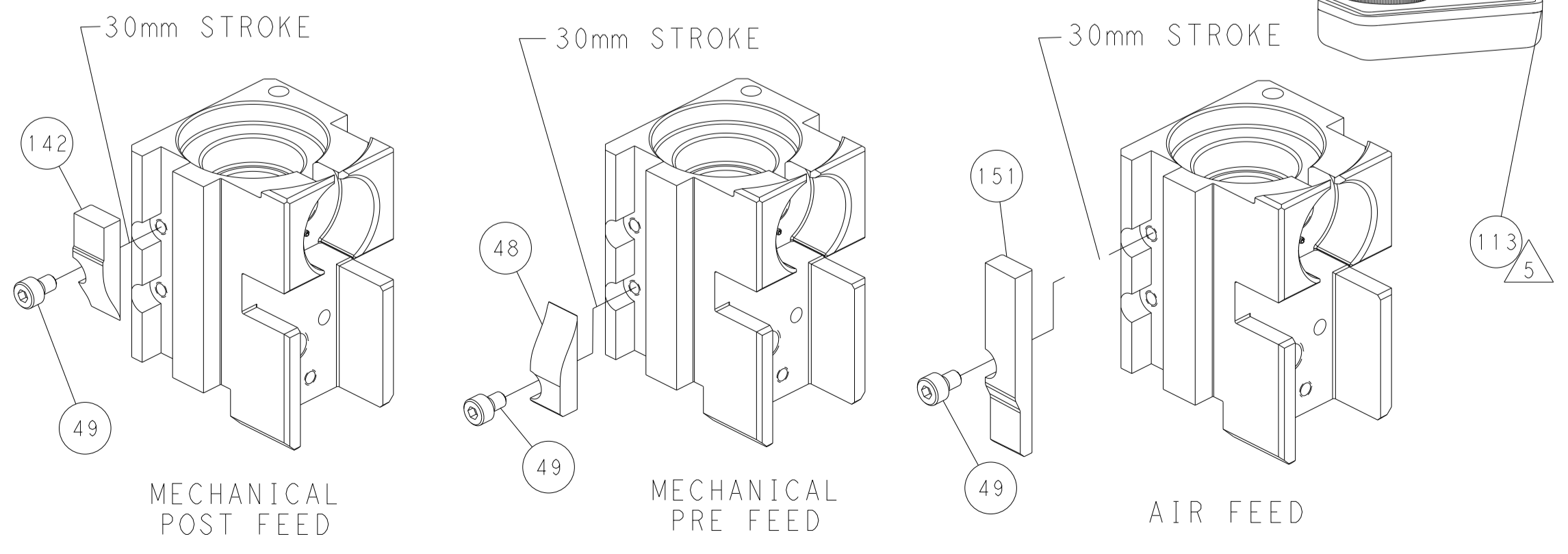
## FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



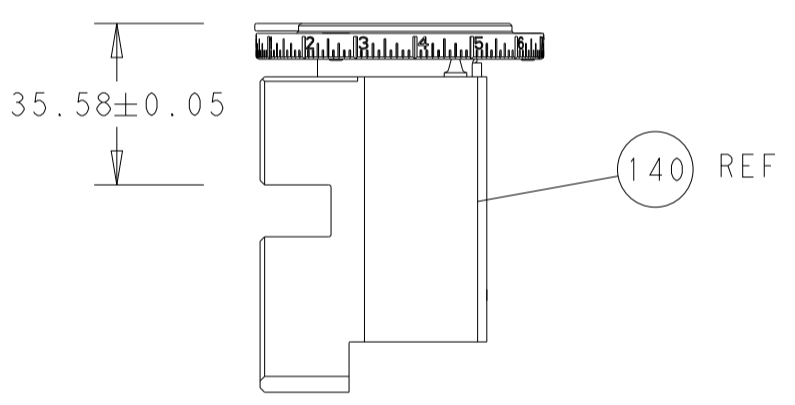
## DOUBLE ACTING PNEUMATIC WITH SENSORS



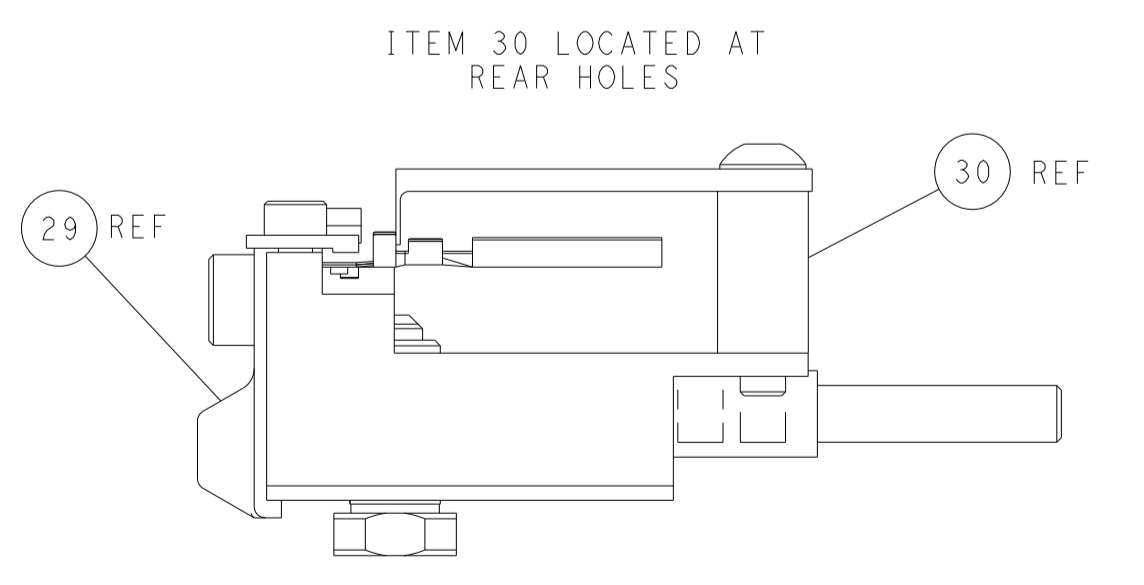
## CAM POSITIONS



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)

<small>THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION. IT IS THE PROPERTY OF TYCO ELECTRONICS CORPORATION. IT IS TO BE USED ONLY FOR THE PURPOSES AND IN THE QUANTITIES SPECIFIED IN THE ORDER. IT IS NOT TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, INCLUDING PHOTOCOPYING, RECORDING, OR BY ANY INFORMATION STORAGE AND RETRIEVAL SYSTEM, WITHOUT THE WRITTEN PERMISSION OF TYCO ELECTRONICS CORPORATION.</small>		DWN C. CHEN 08SEP2011 CHK S. XI 08SEP2011 APVD J. CRUZ 08SEP2011	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 Applier APPLICATION SPEC SIZE CAGE CODE DRAWING NO A1 00779 C-2151037	RESTRICTED TO SCALE 1:2 SHEET 4 OF 4 REV S
MATERIAL:		WEIGHT:	Customer Accessible Production Drawing