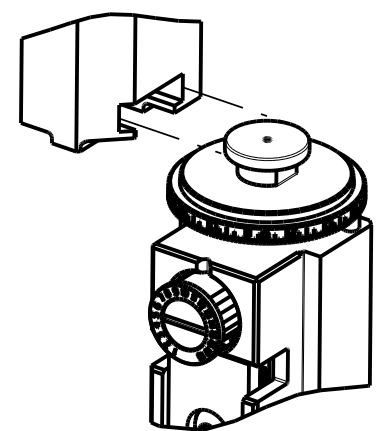


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151068-1	N	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2151068-2	P	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
3-2151068-2	P	FINE CRIMP HEIGHT ADJUST	DOUBLE ACTING PNEUMATIC WITH SENSORS <sup>6</sup>
5-2151068-1	N	SEAL STRIPPER CRIMPER TERMINATING UNIT	MECHANICAL
5-2151068-2	P	SEAL STRIPPER CRIMPER TERMINATING UNIT	PNEUMATIC
7-2151068-1	N	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2151068-2	P	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2151068-7	N	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.57 mm [.062]	F
INSUL	1.83 mm [.072]	O

APPLICATOR INSTRUCTIONS  
408-35042

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: MCON-1.2 CB			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
3.00-3.60 mm [.118-.142 IN]		Ø1.40-1.90 mm [.055-.075 IN]	
TERMINAL APPLICATION SPECIFICATION	114-18464		
TERMINALS APPLIED <sup>5</sup> <sup>6</sup>			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
1670144-1	1670144-2	1670144-3	

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.75mm2	0.95+/-0.03 [.037+/-0.001]	5.4
20 AWG OR 0.50mm2	0.84+/-0.03 [.033+/-0.001]	6.5

- <sup>1</sup> RECOMMENDED SPARE PARTS
  - <sup>2</sup> REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
  - <sup>3</sup> APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 180. 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 & 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.

LOC	DIST	REVISIONS			
A	66	REV	DATE	BY	APPV
		N	ECR-19-009184	11JUN2019	MEH GB
		P	ECR-19-011870	27JUL2019	TB TE
		P1	ECR-20-017914	17DEC2020	JWC GB
		P2	ECR-21-003615	25MAR2021	FZ YY

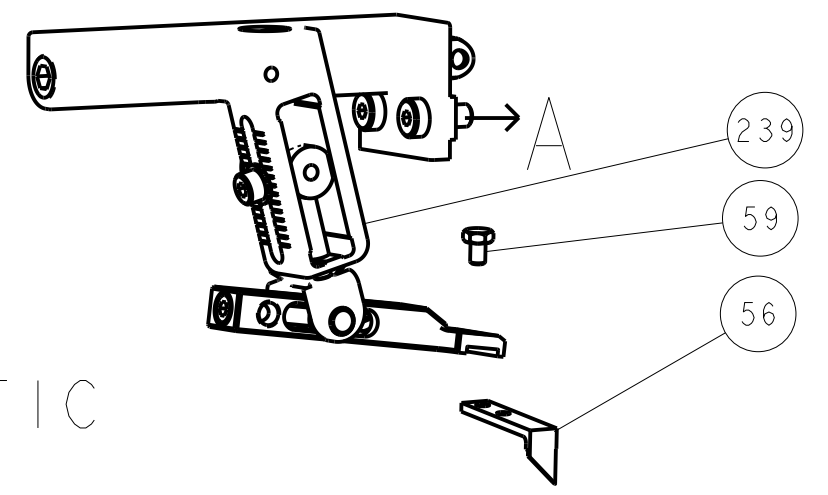
-	-	-	1	1	-	-	-	1803515-3	RAM ASSEMBLY, SF ATLANTIC	293
-	-	-	1	1	-	-	-	2-1803583-1	APPLICATOR BASIC ASSEMBLY, SF	292
-	-	-	-	-	1	-	-	2844950-1	AIR FEED MODULE	290
-	1	-	1	-	-	1	-	2119641-1	FEED CAM, AIR FEED	248
-	1	1	1	1	1	1	1	2119082-4	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	1	1	1	1	2079764-1	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	-	-	-	1-1752354-6	STANDOFF, HOLD-DOWN	180
-	-	-	1	1	-	-	-	9931111-1	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
-	2	2	2	2	2	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	79
-	1	1	1	1	1	1	1	1633782-2	FENCE	78
-	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	2-1752356-4	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	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	1803095-6	FLOATING SHEAR, FRONT	9
-	1	2	2	1	1	1	1	2-1803751-8	ANVIL, COMBINATION	8
-	1	1	1	1	1	1	1	2-240641-4	SPACER	7
-	-	-	-	-	-	-	-	-	-	6
-	1	1	1	1	1	1	1	2119757-8	DEPRESSOR, SHEAR	5
-	1	1	1	1	1	1	1	238011-2	BLOCK, CRIMPER SPACER	4
-	1	2	2	1	1	1	1	1-1803453-1	CRIMPER, INSULATION O	3
-	-	-	-	-	-	-	-	-	-	2
-	1	2	2	1	1	1	1	3-456403-8	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)

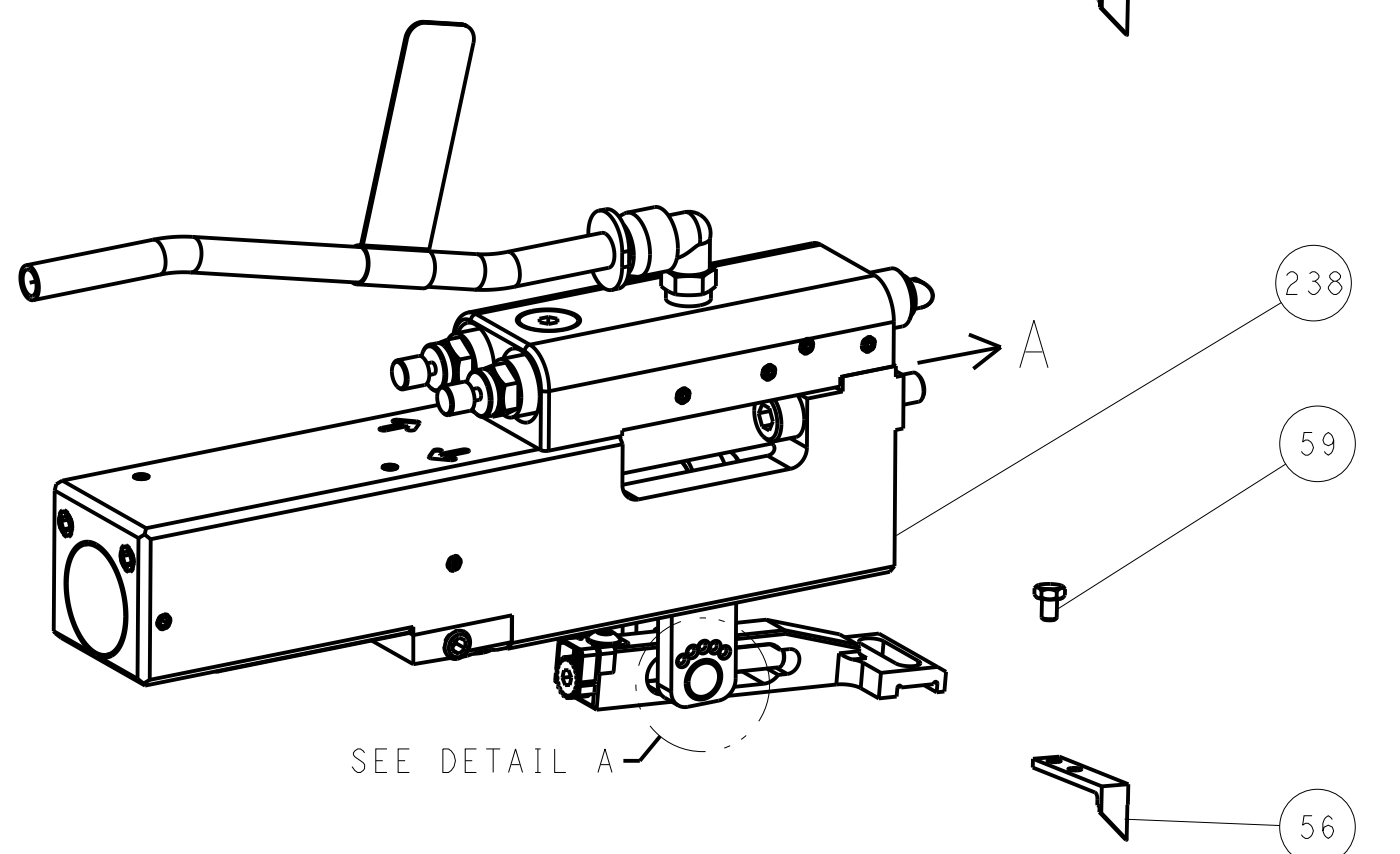
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mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±
	ANGLES ±				
MATERIAL	FINISH	WEIGHT	SCALE	SHEET	REV
			1:2	1 OF 4	P2

Customer Accessible Production Drawing

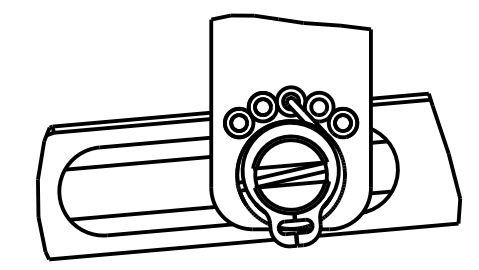
# FEED TYPE MECHANICAL



PNEUMATIC

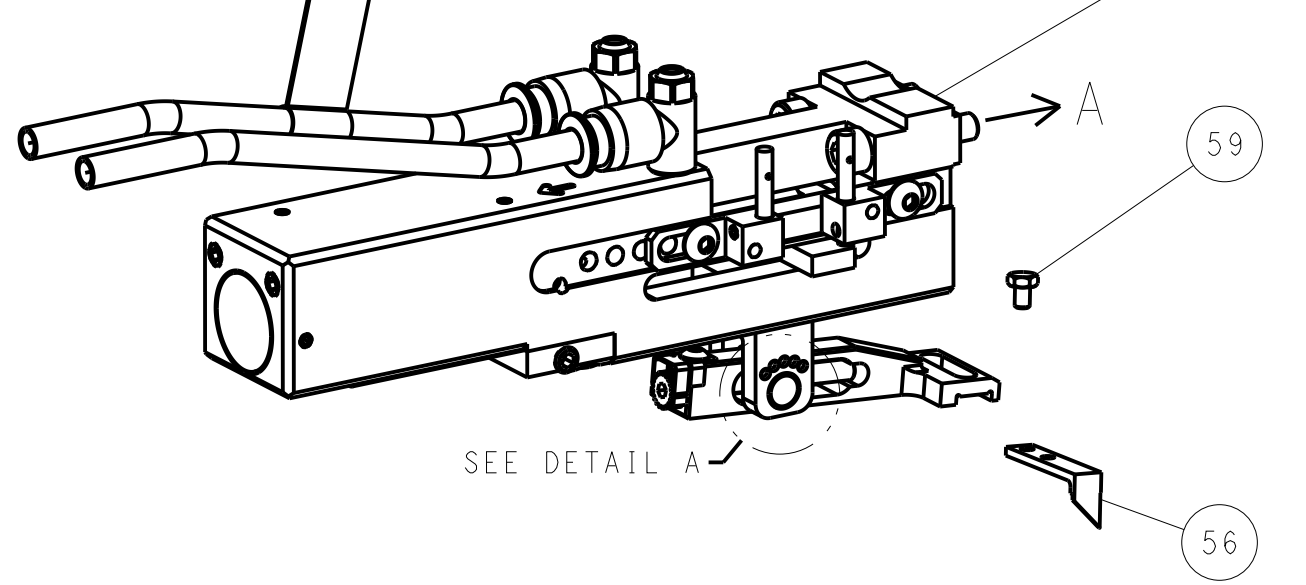


FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)

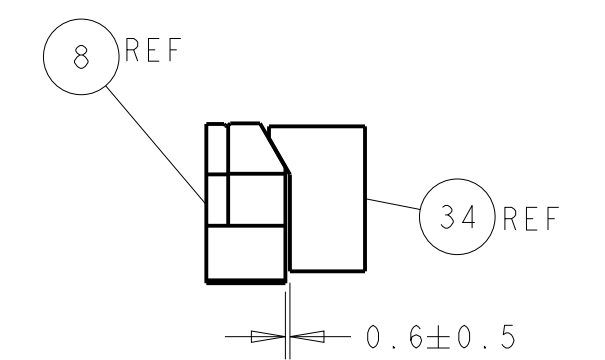
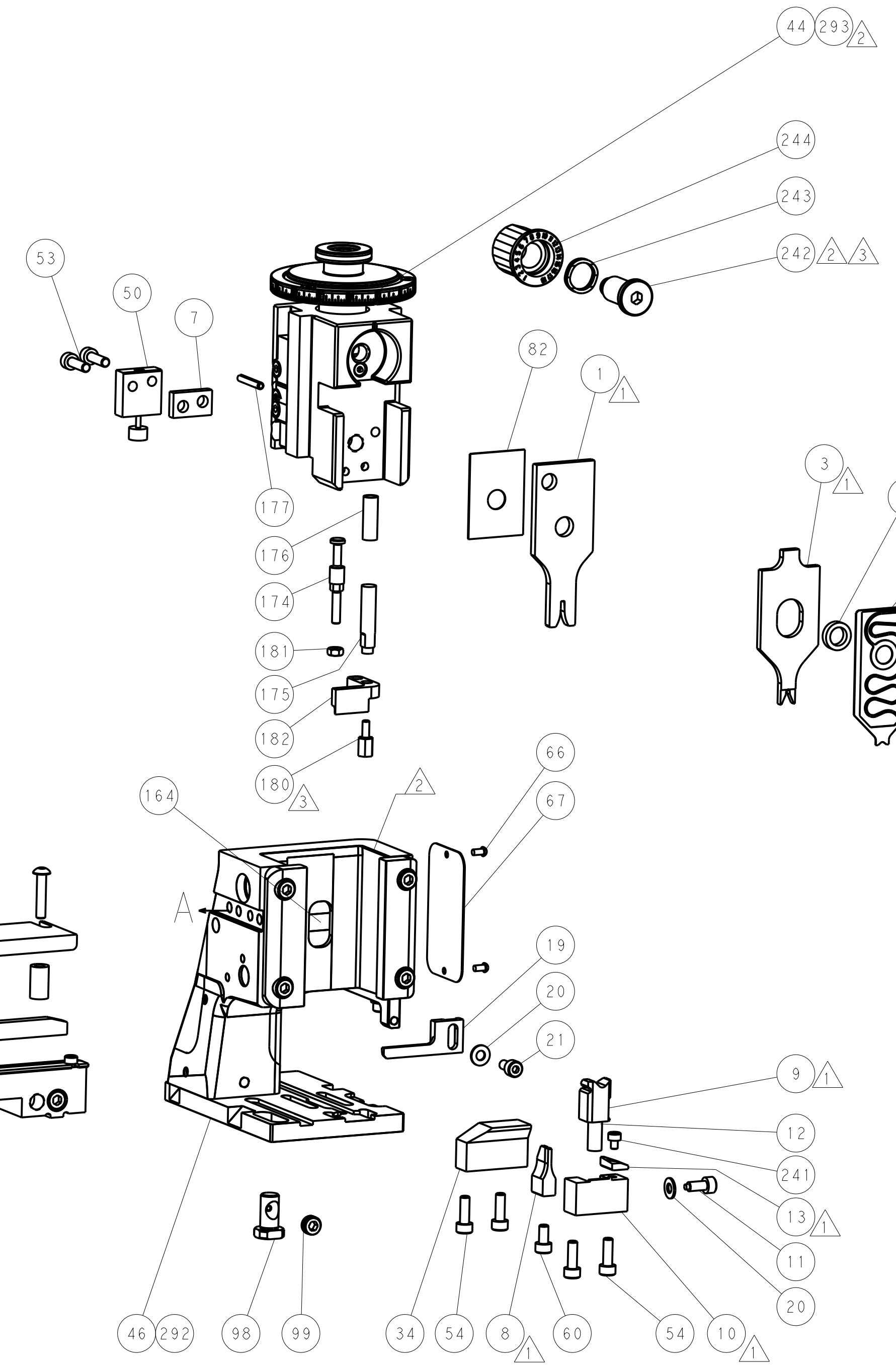
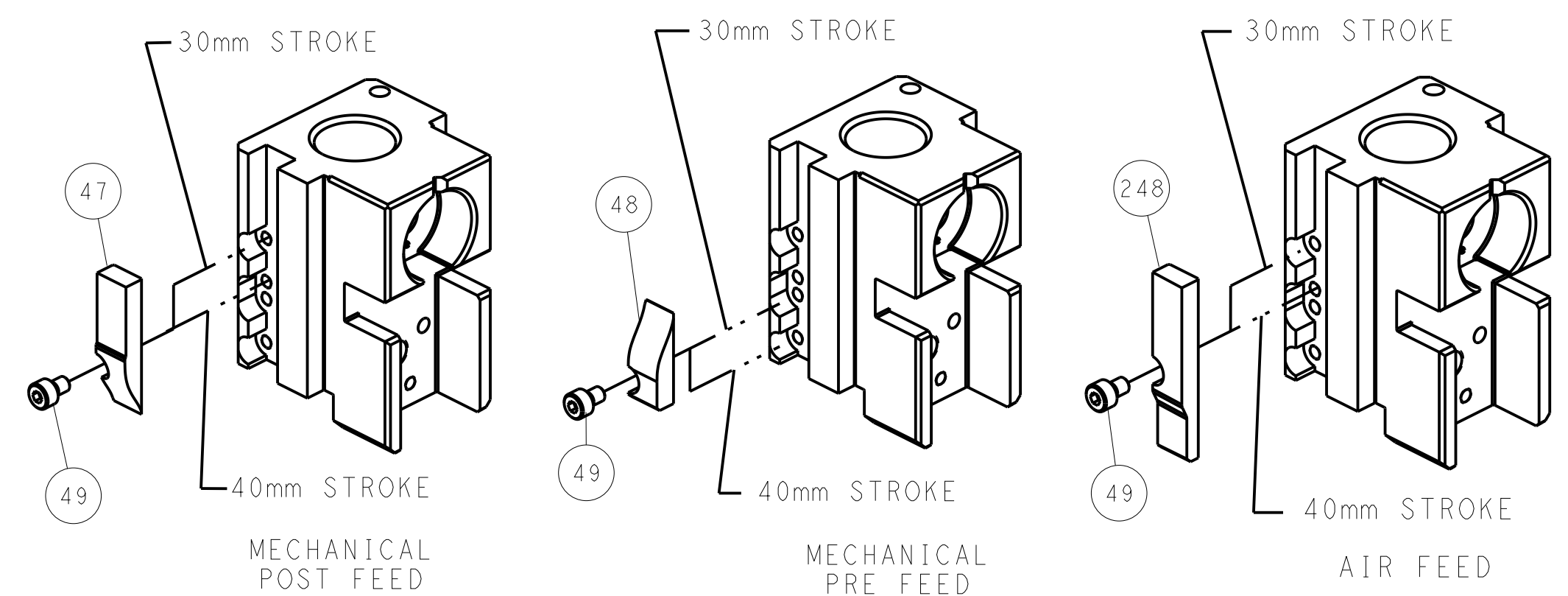


DETAIL A

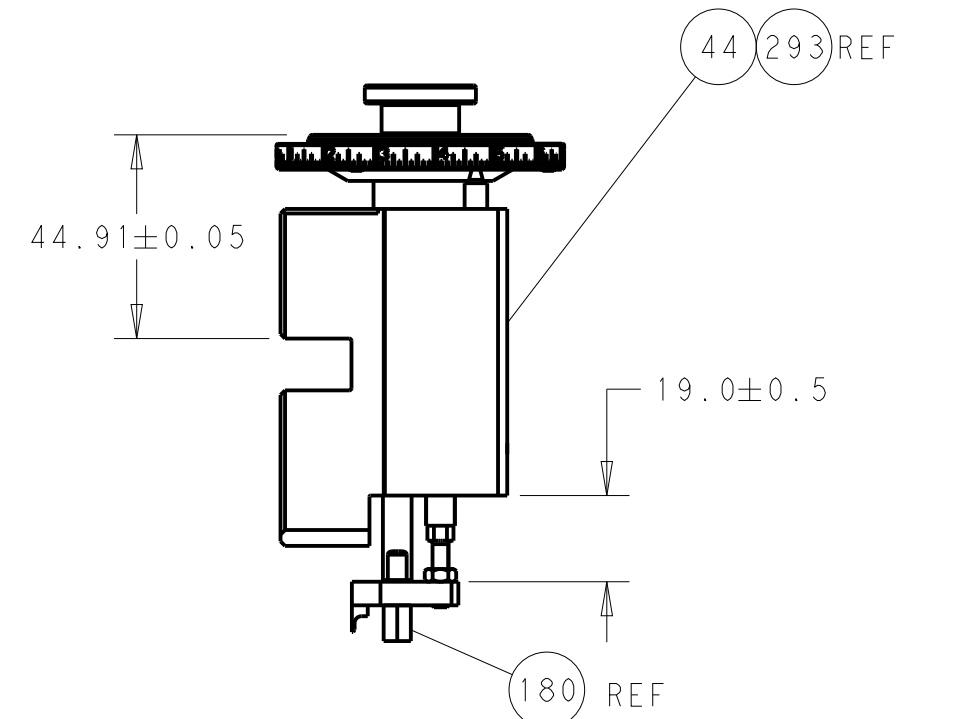
DOUBLE ACTING PNEUMATIC WITH SENSORS



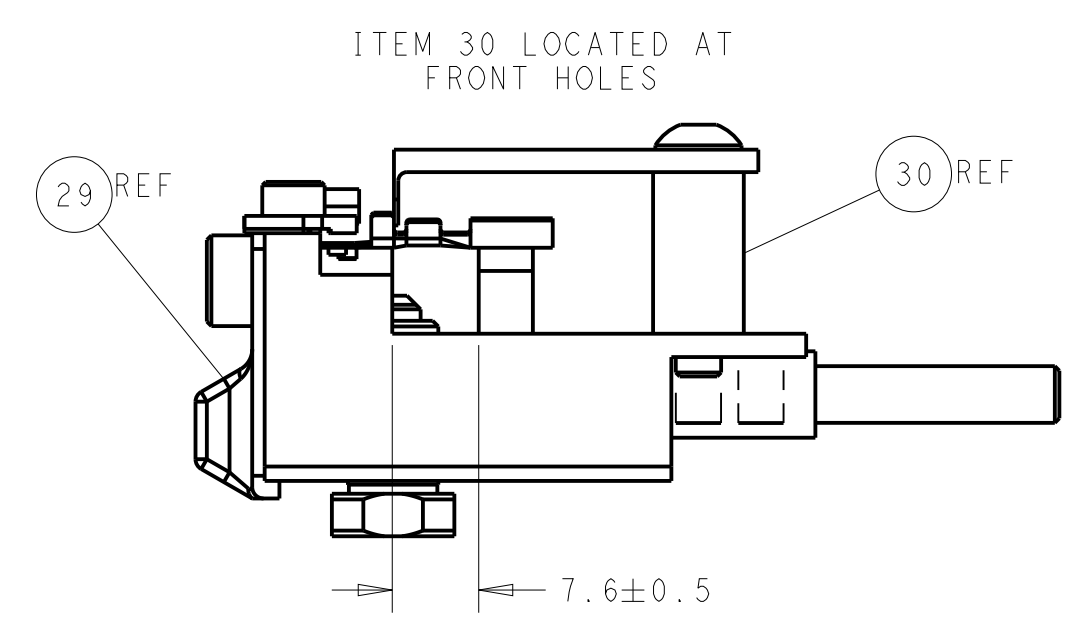
## CAM POSITIONS



TERMINAL SUPPORT LOCATION



RAM & 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)

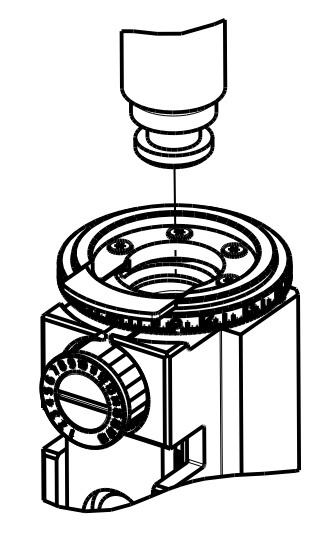
LOC	DIST	REV	DATE	BY	CHK	APPV
A	66					

REVISIONS						
REV	DATE	BY	CHK	APPV	DESCRIPTION	DATE
-	-	-	-	-	SEE SHEET 1	-

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DRAWN: R. KNEPPER 21MAY2013		TE Connectivity	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	5 PLC ±	Harrisburg, PA 17105-3608
MATERIAL:		FINISH:		NAME: Ocean Side Feed Applicator		RESTRICTED TO:	
				SIZE: A1		CAGE CODE: 00779	
				DRAWING NO: 21MAY2013		SCALE: 1:2	
				WEIGHT:		SHEET 2 OF 4	
				Customer Accessible Production Drawing		REV P2	

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2151068-1	N	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2151068-2	P	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
4-2151068-2	P	FINE CRIMP HEIGHT ADJUST	DOUBLE ACTING PNEUMATIC WITH SENSORS
7-2151068-7	N	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA

CRIMP	SIZE	TYPE
WIRE	1.57 mm [.062]	F
INSUL	1.83 mm [.072]	O

APPLICATOR INSTRUCTIONS  
408-35042

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION

TERMINAL NAME: MCON-1.2 CB

WIRE STRIP LENGTH	INSULATION DIAMETER RANGE
3.00-3.60 mm [.118-.142 IN]	1.40-1.90 mm [.055-.075 IN]

TERMINAL APPLICATION SPECIFICATION

TERMINALS APPLIED

TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
1670144-1	1670144-2	1670144-3	

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.75mm <sup>2</sup>	0.95+/-0.03 [.037+/-0.001]	5.4
20 AWG OR 0.50mm <sup>2</sup>	0.84+/-0.03 [.033+/-0.001]	6.5

**\*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.

- 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.
  - 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.
7. 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
8-2151068-1	2151068-1	1	WIRE CRIMPER	3-1803547-8
8-2151068-2	2151068-2	3	INSULATION CRIMPER	1-1803652-1
9-2151068-1	2-2151068-1	46	BASIC SUB -ASSEMBLY	1803940-9
9-2151068-2	2-2151068-2	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)

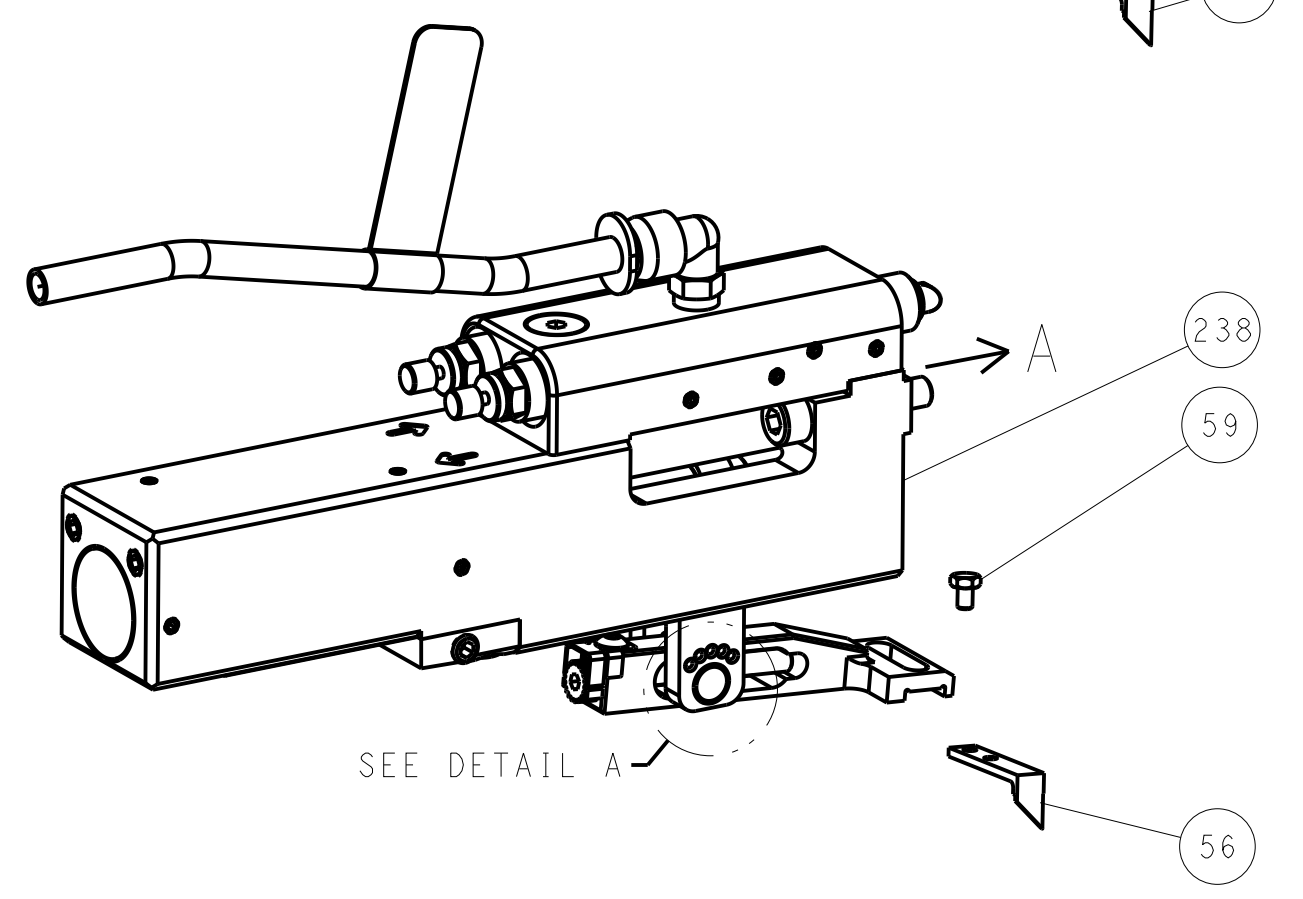
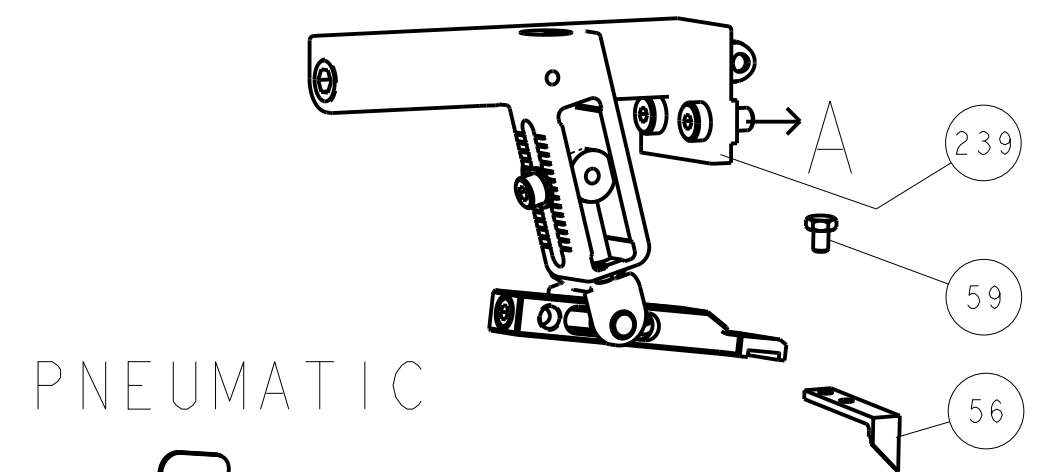
LOC	DIST	REV	DATE	BY	APPV
A	66				

REV	DATE	BY	APPV	DESCRIPTION	ITEM NO
-	1	-	-	2844950-1 AIR FEED MODULE	290
-	1	1	1	2119082-4 CAM, SNAIL, 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
-	-	-	-	2119580-1 MECHANICAL FEED ASSEMBLY	239
-	-	1	-	2844940-1 AIR FEED MODULE	238
-	REF	REF	REF	994970-2 COUNTER, MAGNETIC	164
6	-	-	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
5	-	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
-	2	2	2	2168083-1 SCR, SKT HD CAP, RoHS, M3 X 8.0	79
-	1	1	1	1633782-2 FENCE	78
-	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
6	-	1	2	18023-9 SCR, SKT HD CAP M4 X 6.0	49
-	-	-	-	2119652-1 FEED CAM, PRE FEED	48
-	1	1	1	1803602-1 SCR, BHSC, RoHS (M8 X 25)	41
-	1	1	1	2-1752356-4 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	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	2119805-1 SHEAR HOLDER, FRONT	10
1	-	1	1	1803095-6 FLOATING SHEAR, FRONT	9
1	1	1	1	2-1803751-8 ANVIL, COMBINATION	8
-	1	1	1	2-240641-4 SPACER	7
-	-	-	-	-	6
-	1	1	1	2119757-8 DEPRESSOR, SHEAR	5
-	1	1	1	238011-2 BLOCK, CRIMPER SPACER	4
1	1	1	1	1-1803453-1 CRIMPER, INSULATION O	3
-	-	-	-	-	2
1	1	1	1	3-456403-8 CRIMPER, WIRE PREMIUM	1
-77	-42	-22	-21	PART NO	DESCRIPTION

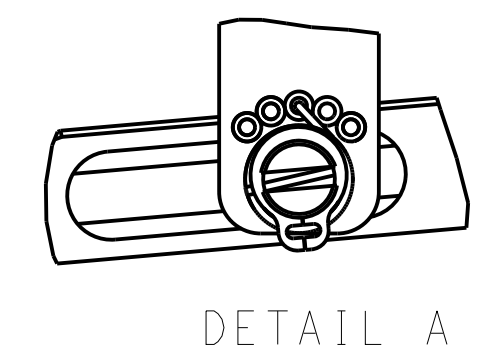
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0 PLC ±		1 PLC ±		2 PLC ±		3 PLC ±		4 PLC ±		SIZE: A1	
ANGLES ±		FINISH		WEIGHT		SCALE: 1:2		SHEET: 3 OF 4		REV: P2	
MATERIAL		FINISH		WEIGHT		SCALE: 1:2		SHEET: 3 OF 4		REV: P2	

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

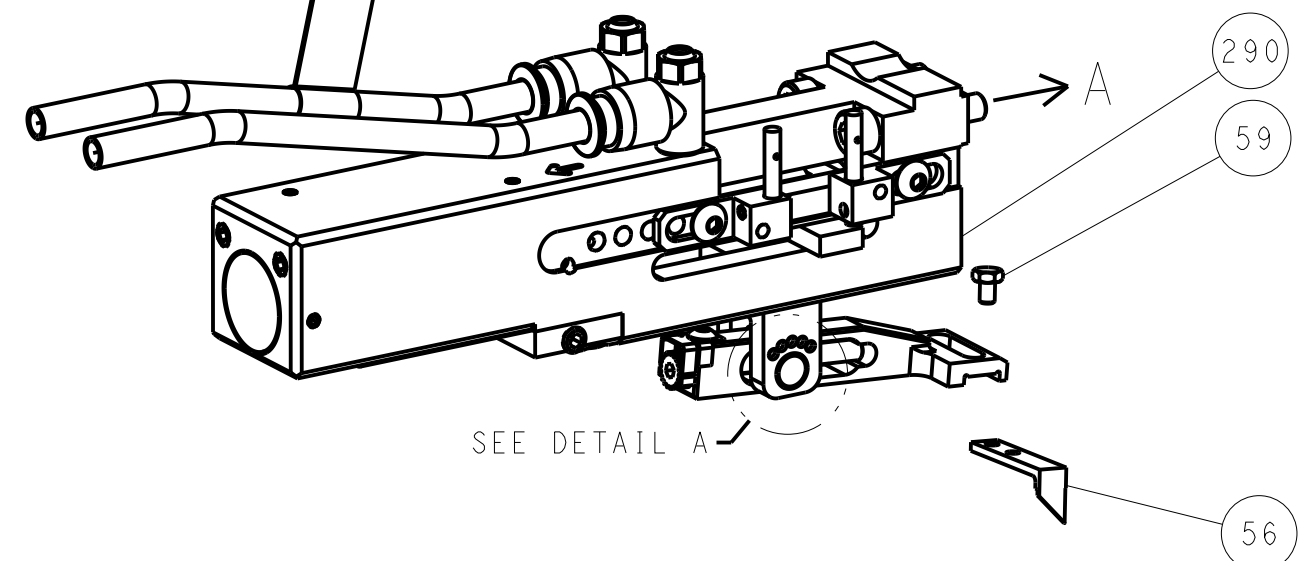
# FEED TYPE MECHANICAL



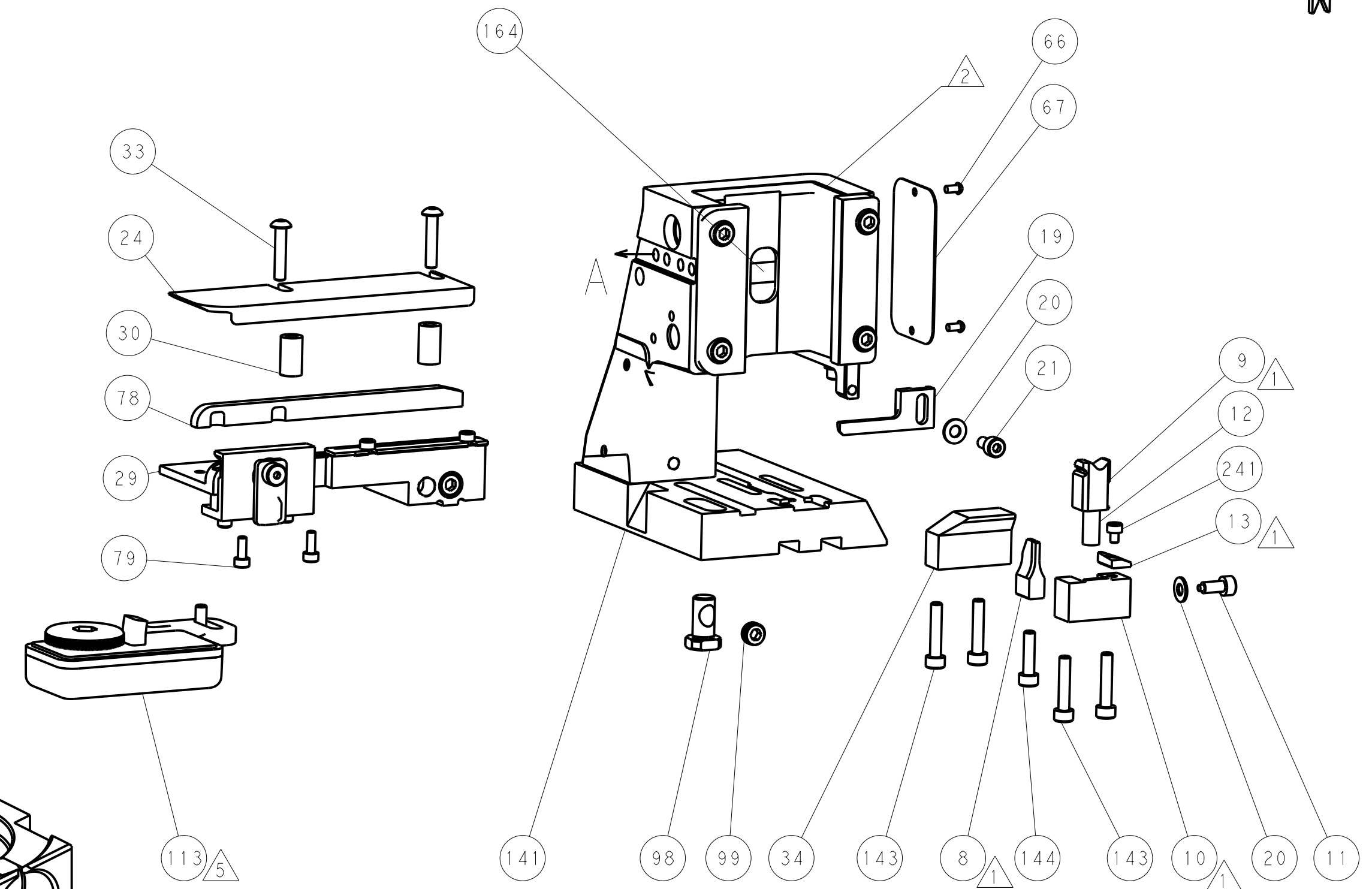
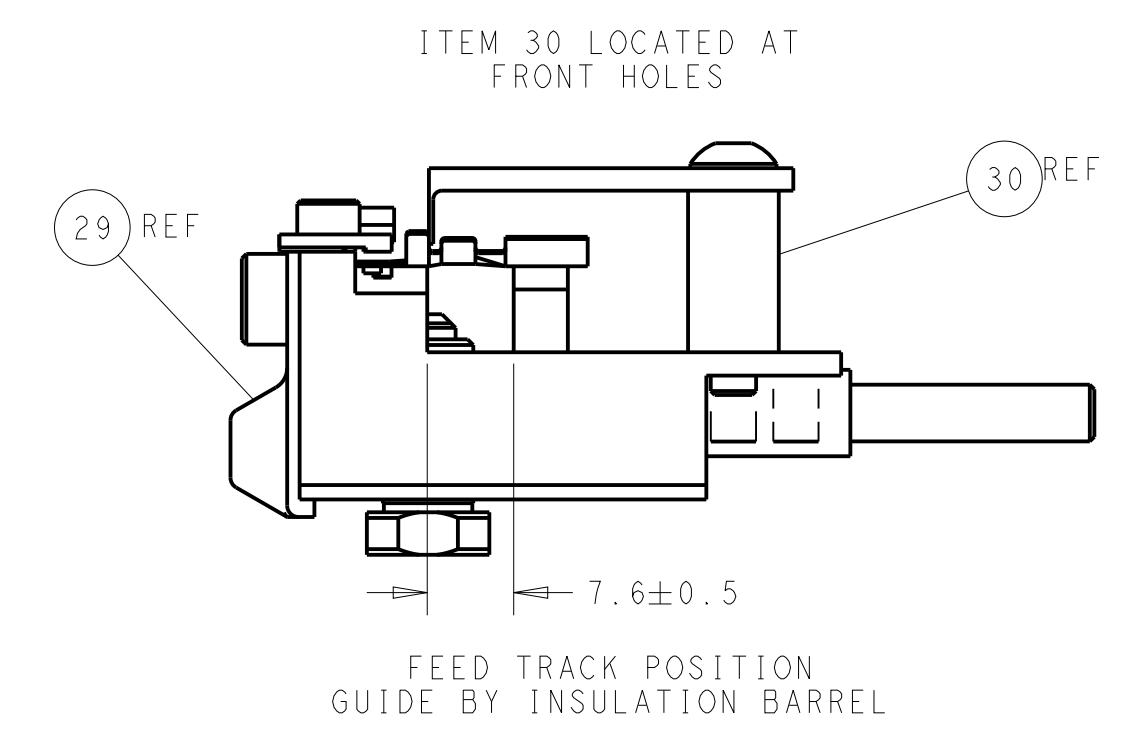
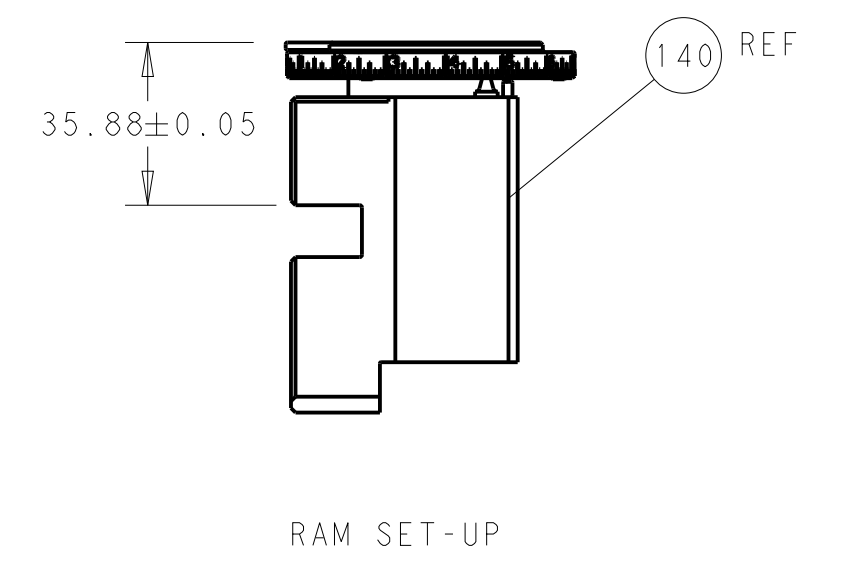
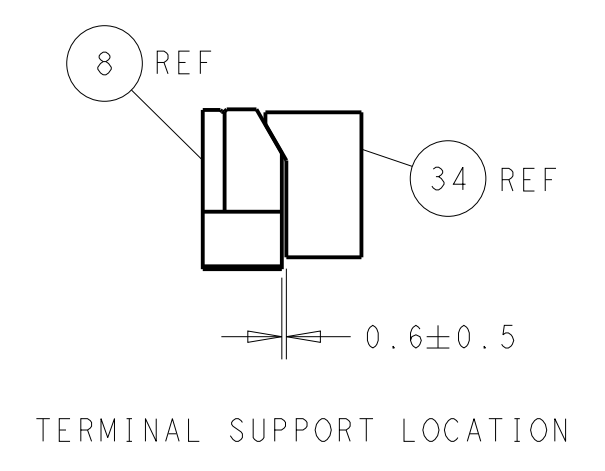
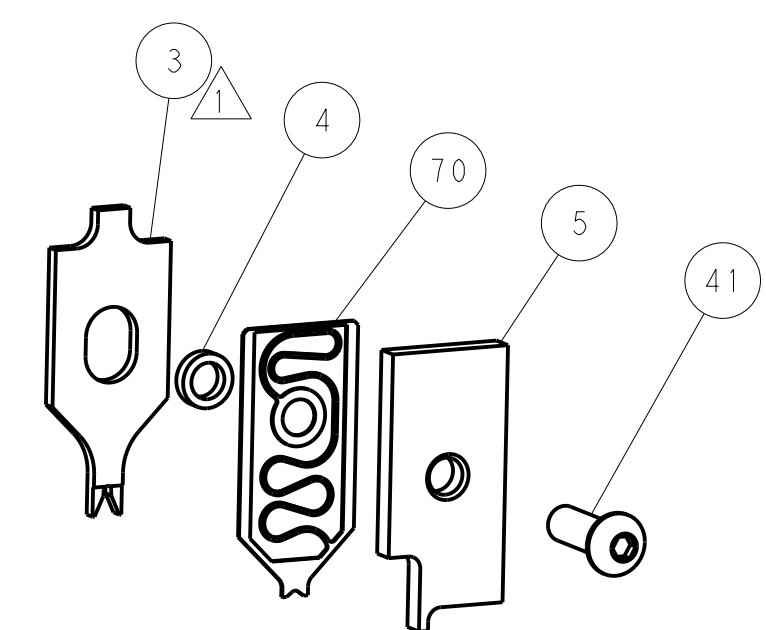
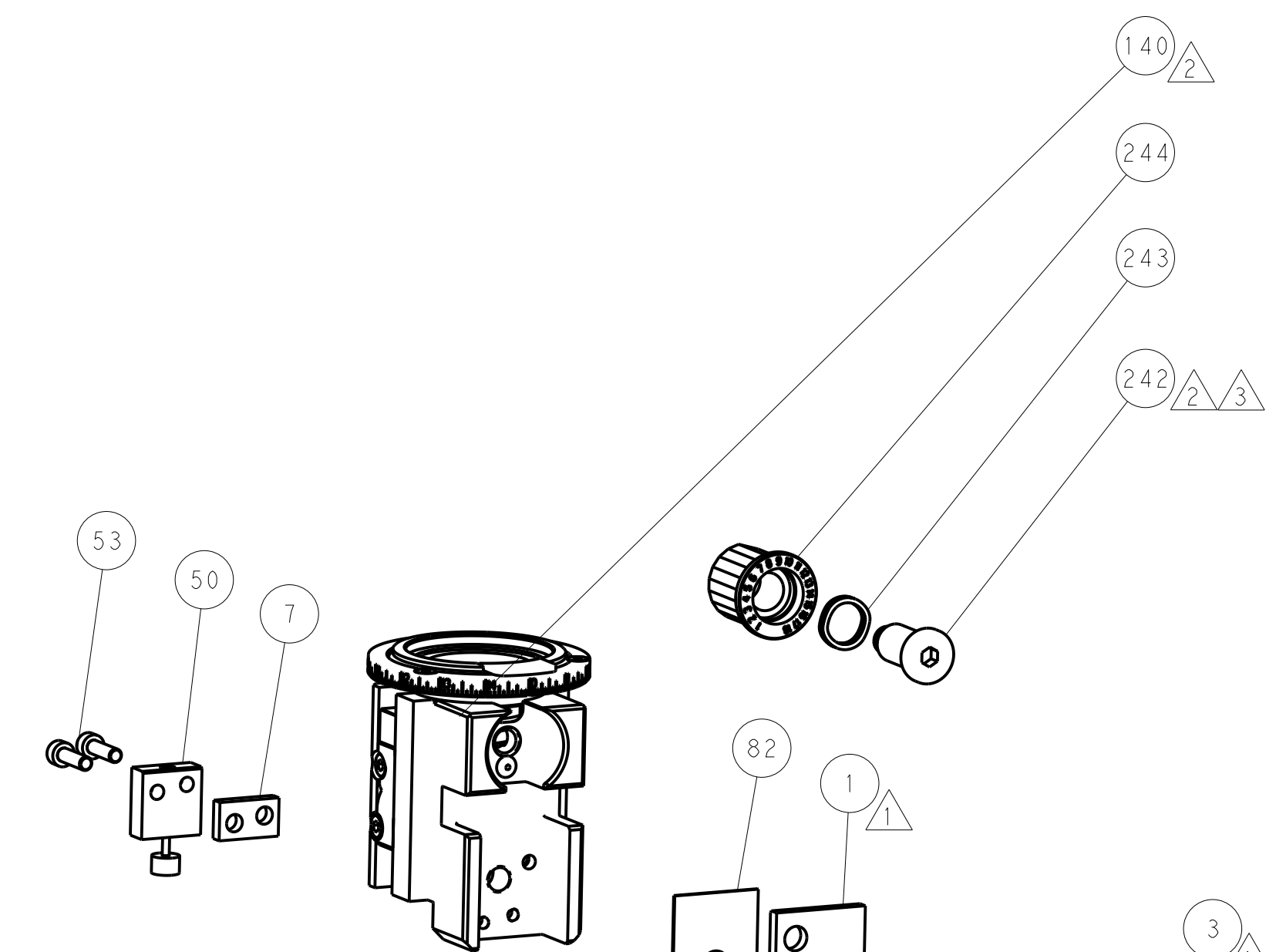
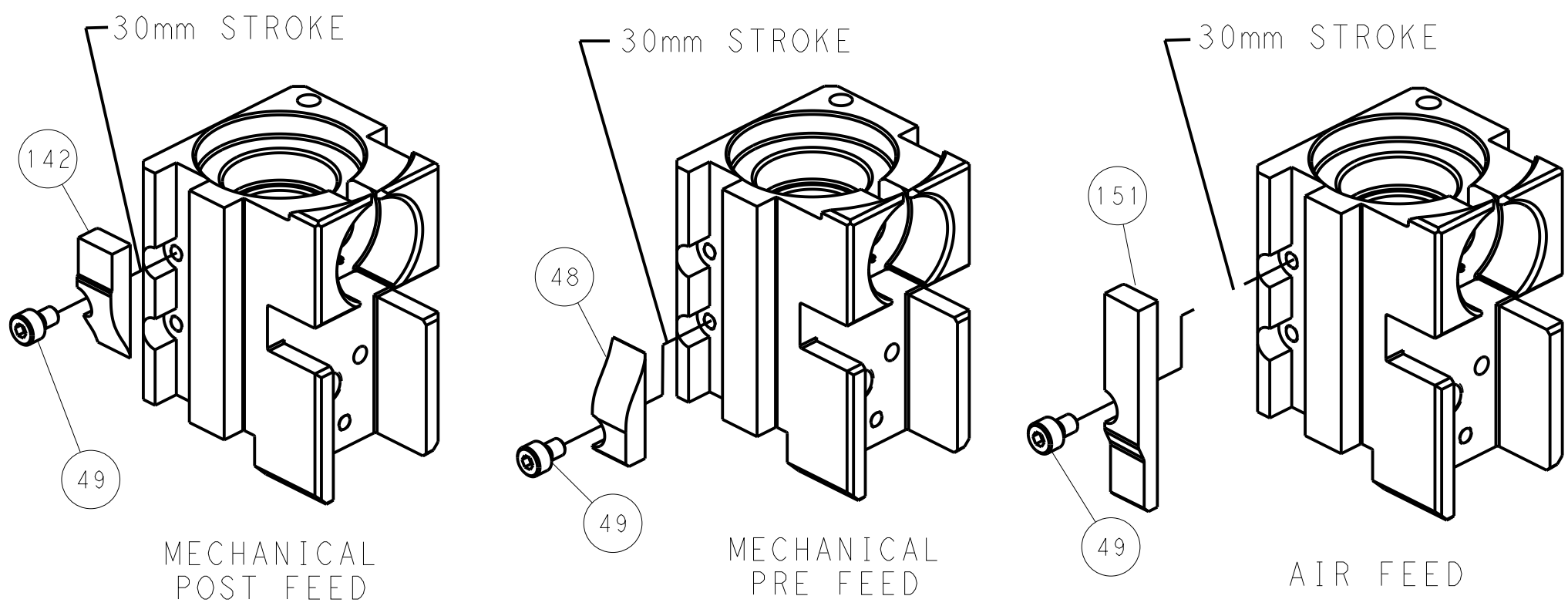
FEED SPRING SETTING POSITION  
(SHOWN FROM REAR SIDE)



DOUBLE ACTING PNEUMATIC WITH SENSORS



# CAM POSITIONS



**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:		DWN: R. KNEPPER 21MAY2013		TE Connectivity	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	5 PLC ±	Harrisburg, PA 17105-3608
MATERIAL:	FINISH:	WEIGHT:	APVD: M. CLIFFORD 21MAY2013	NAME:	SIZE:	CAGE CODE:	DRAWING NO:
			PRODUCT SPEC:	Ocean Side Feed	A11	00779	©=2151068
			APPLICATION SPEC:	Applicator	SCALE:	SHEET:	REV:
			RESTRICTED TO:		1:2	4	P2