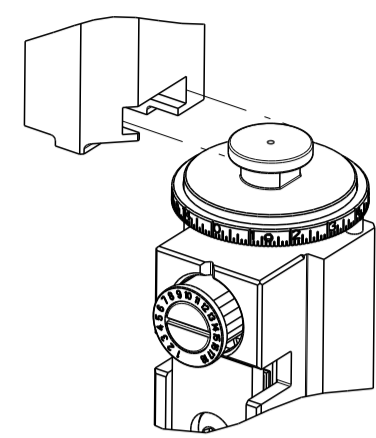


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151582-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2151582-2	D	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151582-1	C	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2151582-2	D	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2151582-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



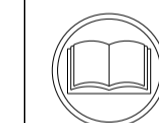
APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.79 mm [.110]	F
INSUL	4.19 mm [.165]	O

APPLICATOR INSTRUCTIONS 408-35042

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: MCON 2.8-RECEPTACLE-SWS			
WIRE STRIP LENGTH		TERMINAL INSULATION DIAMETER RANGE	
4.50-5.10 mm [.177-.201 IN]		∅ 3.40 mm [.134 IN] MAX	
TERMINAL APPLICATION SPECIFICATION	114-18718		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE SEAL	TE SEAL
1670804-1	1670804-3	828905-1	

SEAL INSULATION DIAMETER RANGE  
∅ 2.2 - 3.0mm

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
2.50mm2	1.67+/-0.05 [1.066+/-0.002]	7.5
1.50mm2	1.43+/-0.05 [1.056+/-0.002]	10.0



- 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.
  - 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.
  - 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	LTN	DESCRIPTION	DATE	DWN	APVD
		B		ECR-16-011976	19AUG2016	MR	CT
		C		ECR-18-007764	24MAY2018	MZ	JDG
		D		ECR-20-017346	07DEC2020	TB	RK

-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248
-	1	1	1	1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
	-	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	1	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
-	-	1	-	-	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	1	-	1	-	2844940-1	AIR FEED MODULE	238
-	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
	-	1	1	1	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113
-	1	1	1	1	2844908-1	SCREW, LOCKING	99
-	1	1	1	1	2844907-1	POST, LOCKING	98
-	1	1	1	1	455888-4	SPACER, CRIMPER	82
-	1	1	1	1	1803607-3	DOCUMENTATION PACKAGE	71
-	1	1	1	1	2119740-1	TAG, IDENTIFICATION	67
-	2	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	1	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	60
	-	1	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	1	1	1	1	985575-3	SCR, FLT SKT HD CAP M3 X 10.0	57
-	1	1	1	1	1338685-1	PAWL, FEED	56
-	4	4	4	4	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	54
-	2	2	2	2	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	53
-	1	1	1	1	5018030-1	NUT, HEX, REG, RoHS, M3	52
-	1	1	1	1	811242-5	BUMPER, HOLD DOWN	51
-	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	1803583-9	APPLICATOR BASIC ASSEMBLY, SF	46
-	1	1	1	1	1803515-1	RAM ASSEMBLY, SF ATLANTIC	44
-	1	1	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
-	1	1	1	1	1752356-3	SUPPORT, TERMINAL	34
-	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	2	2	3-2844962-0	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29
-	1	1	1	1	455888-5	SPACER, CRIMPER	28
-	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	2	2	1-18028-2	WASHER, FLAT, REG M4	20
-	1	1	1	1	2119533-1	STRIPPER, SIDE FEED	19
	-	1	1	1	2119806-1	INSERT, SHEAR	13
-	1	1	1	1	3-22280-3	SPRING, COMPRESSION	12
-	1	1	1	1	1-356885-4	STOP, SHEAR	11
	-	1	1	1	2119805-1	SHEAR HOLDER, FRONT	10
	-	1	1	1	318707-1	FLOATING SHEAR, FRONT	9
	1	2	2	1	1-1633134-5	ANVIL, COMBINATION .110	8
-	1	1	1	1	240641-3	SPACER	7
-	-	-	-	-	-	-	6
-	1	1	1	1	2119781-5	DEPRESSOR, SHEAR	5
-	1	1	1	1	2-238011-1	BLOCK, CRIMPER SPACER	4
	1	2	2	1	1-1633996-3	CRIMPER, INSULATION SPECIAL	3
-	1	1	1	1	1-455888-5	SPACER, CRIMPER	2
	1	2	2	1	456408-3	CRIMPER, WIRE PREMIUM	1

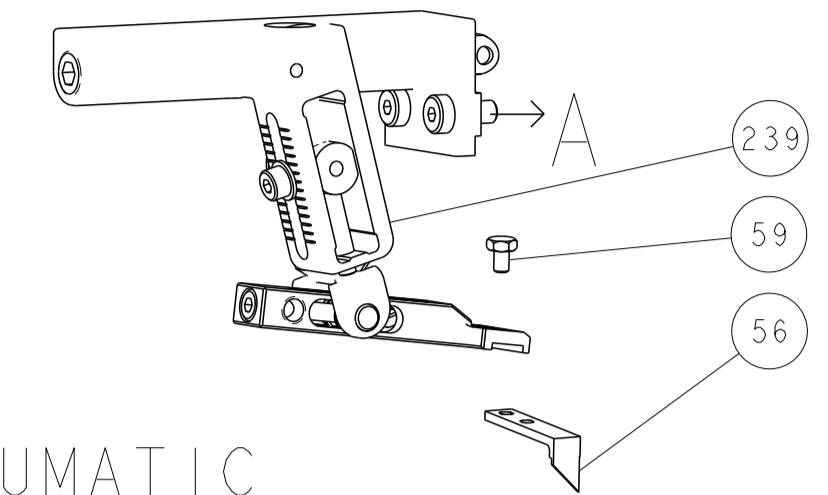
ATLANTIC VERSION  
Shown on sheets 1 of 4 & 2 of 4  
(Pacific version shown on sheets 3 of 4 & 4 of 4)

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

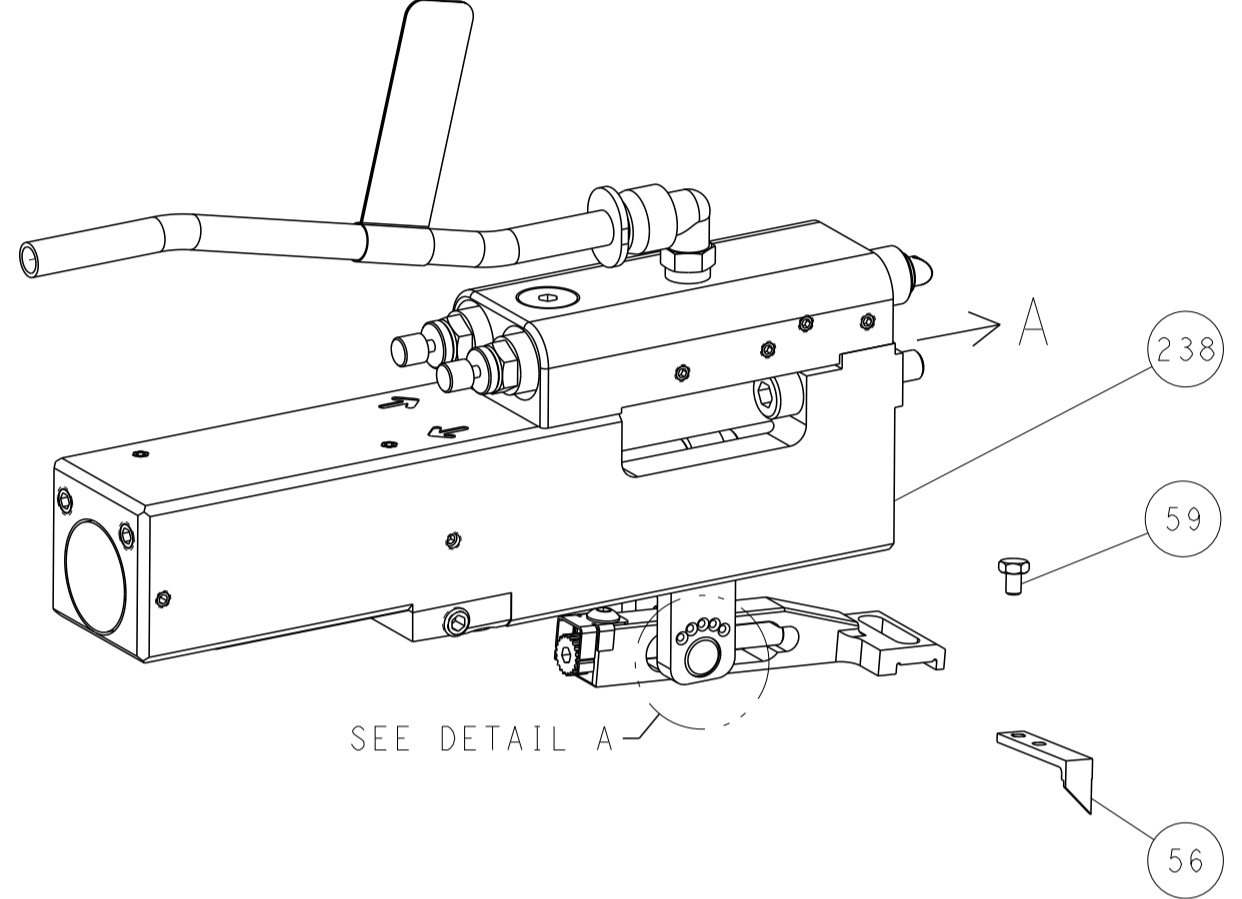
OWN	L. ZHANG	11OCT2012
CHK	L. ZHANG	11OCT2012
APVD	S. XI	11OCT2012
PRODUCT SPEC		
APPLICATION SPEC		
SIZE	CAGE CODE	DRAWING NO
A1	00779	2151582
CUSTOMER ACCESSIBLE PRODUCTION DRAWING		
SCALE	1:2	SHEET 1 OF 4
REV	D	

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

# FEED TYPE MECHANICAL



## PNEUMATIC

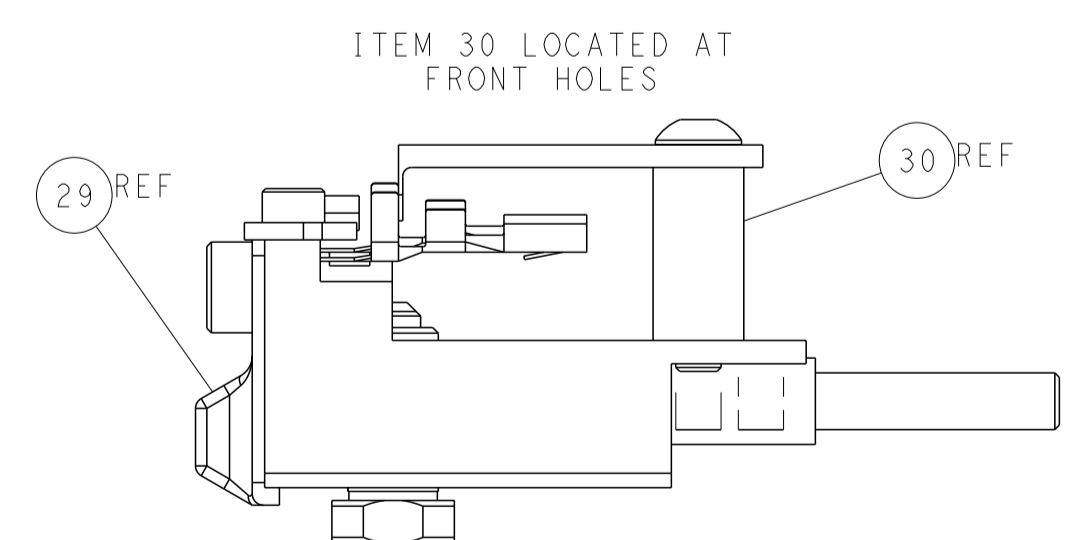
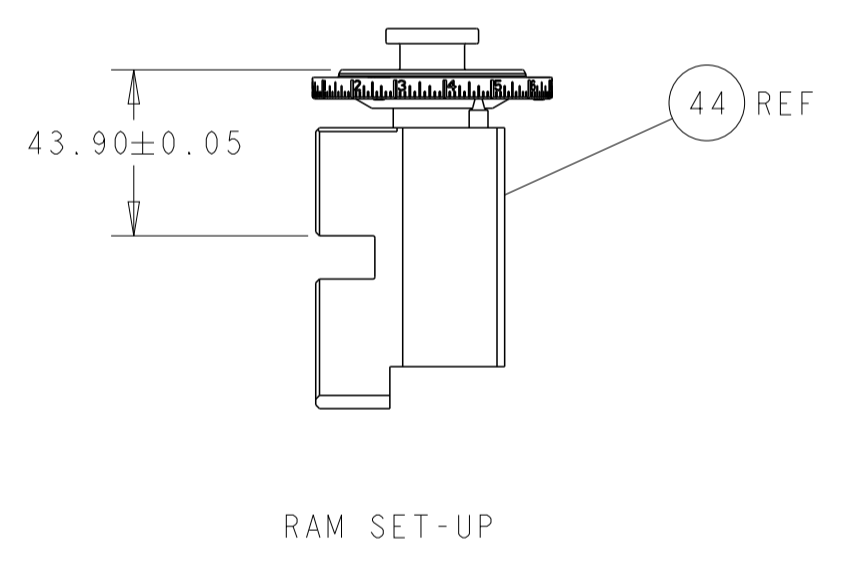
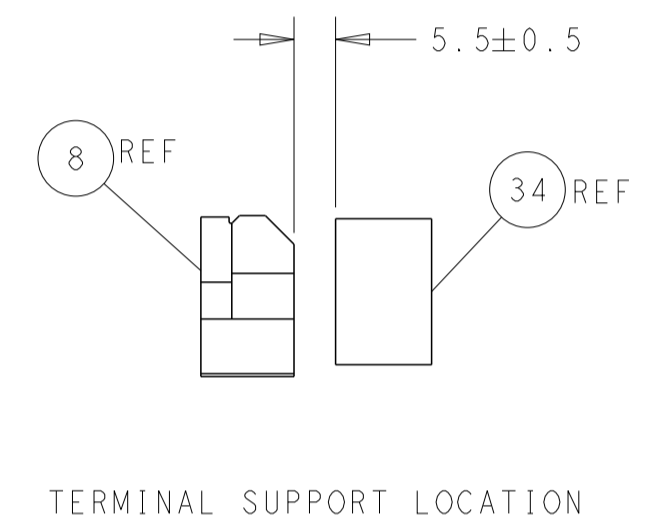
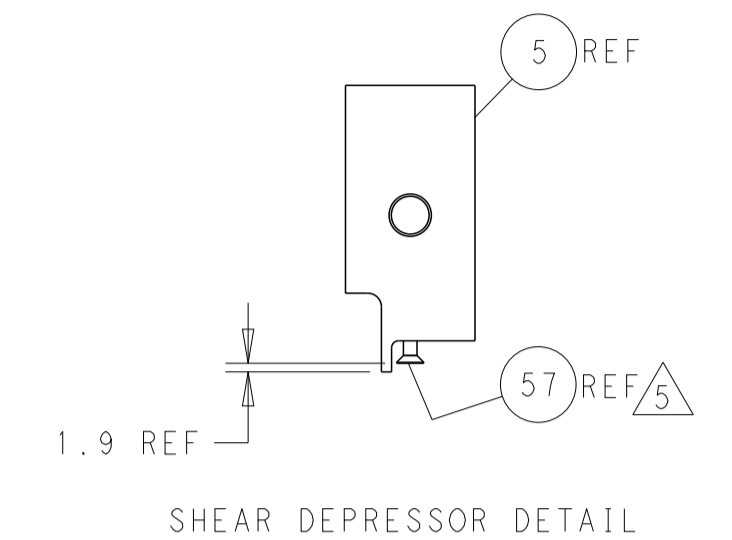
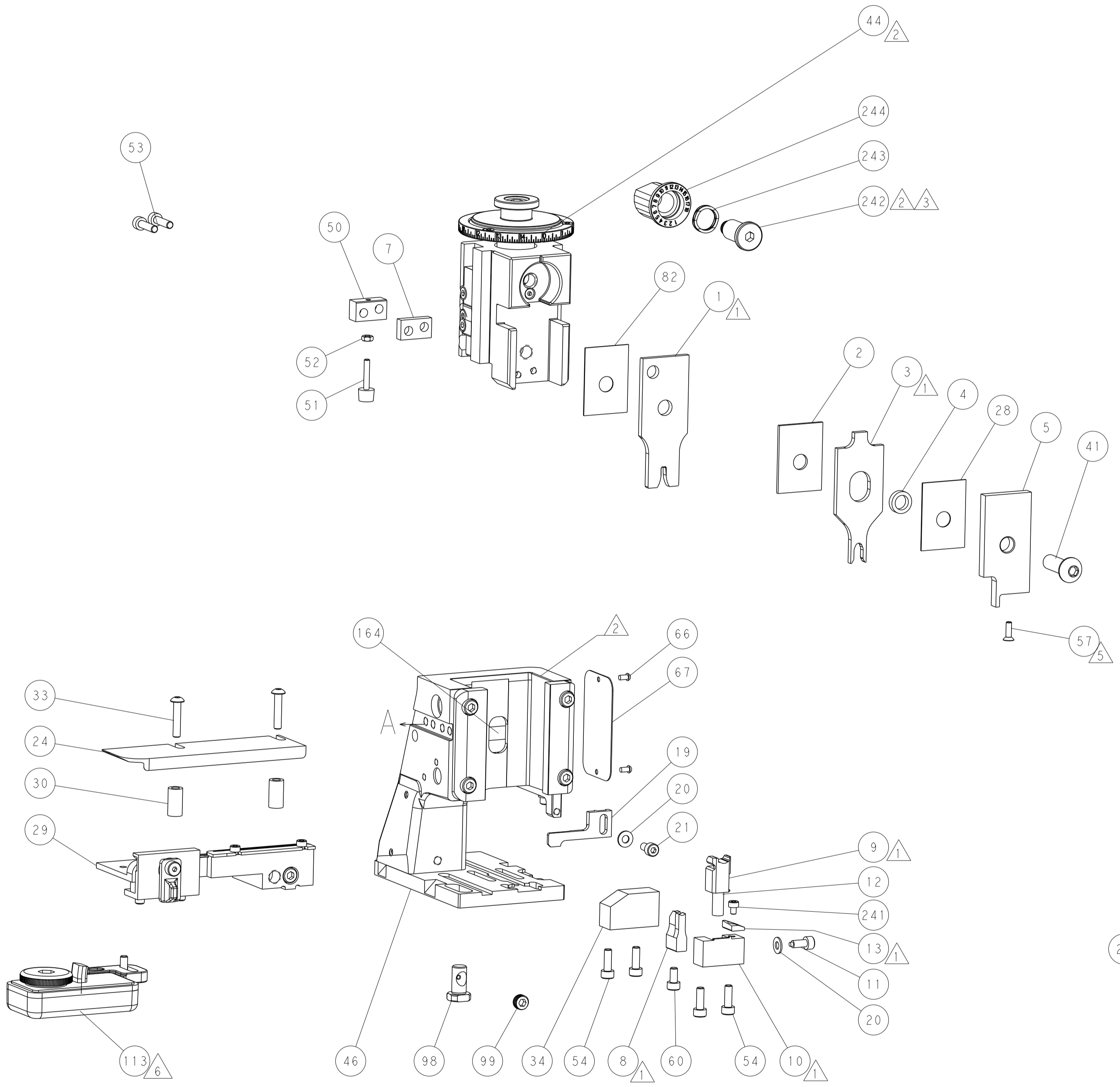
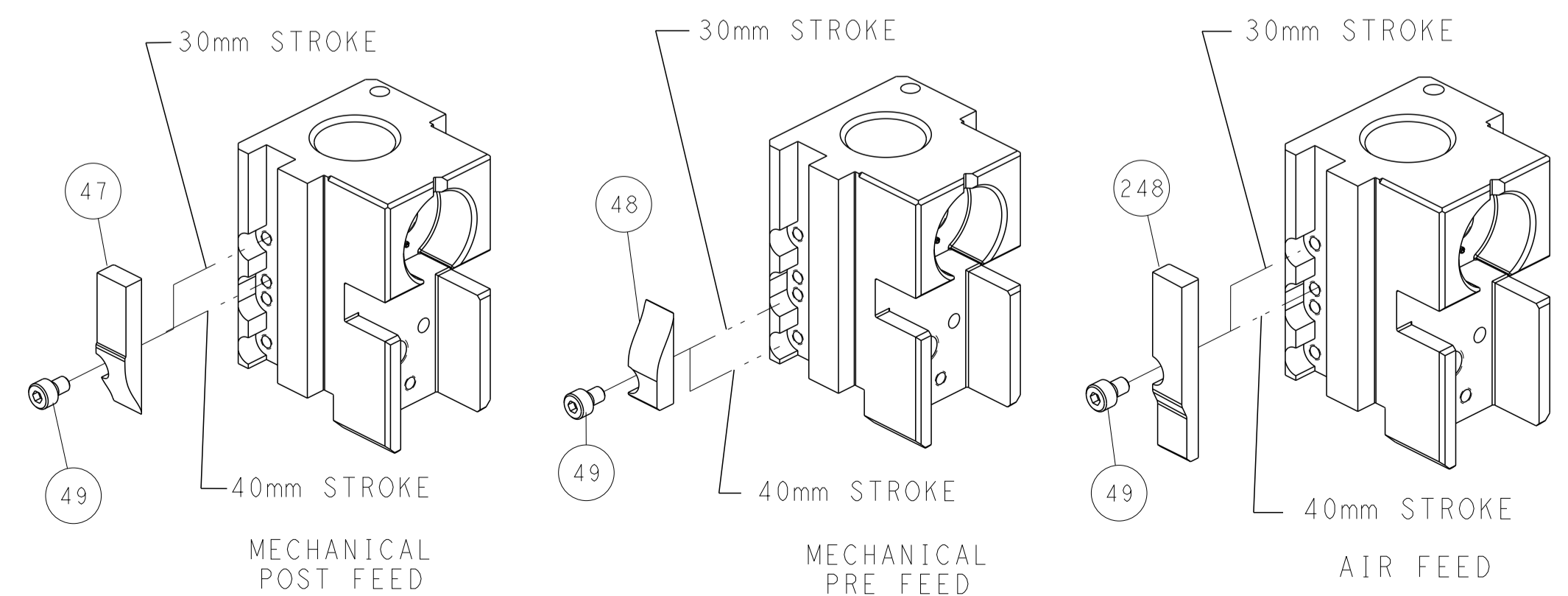


## FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



DETAIL A

# CAM POSITIONS



**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 L. ZHANG 17OCT2012		TE Connectivity	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	Harrisburg, PA 17105-3608	
MATERIAL:		FINISH:		CHK L. ZHANG 17OCT2012		NAME Ocean Side Feed Applicator	
				S. XI 17OCT2012		SIZE CAGE CODE DRAWING NO RESTRICTED TO	
				APVD S. XI 17OCT2012		A1 00779 ©=2151582	
				PRODUCT SPEC		CUSTOMER ACCESSIBLE PRODUCTION DRAWING	
				APPLICATION SPEC		SCALE 1:2 SHEET 2 OF 4 REV D	
				WEIGHT		SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION	

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2151582-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2151582-2	D	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151582-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR  
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.79 mm [.110]	F
INSUL	4.19 mm [.165]	O
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION
TERMINAL NAME: MCON 2.8-RECEPTACLE-SWS		
WIRE STRIP LENGTH 4.50-5.10 mm [1.77-.201 IN]		TERMINAL INSULATION DIAMETER RANGE Ø 3.40 mm [1.34 IN] MAX
TERMINAL APPLICATION SPECIFICATION 114-18718	-	-

TERMINALS APPLIED				SEAL INSULATION DIAMETER RANGE
TE TERMINAL	TE TERMINAL	TE SEAL	TE SEAL	Ø 2.2 - 3.0mm
1670804-1	1670804-3	828905-1		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
2.50mm2	1.67+/-0.05 [1.066+/-0.002]	7.5
1.50mm2	1.43+/-0.05 [1.056+/-0.002]	10.0

- 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 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.

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

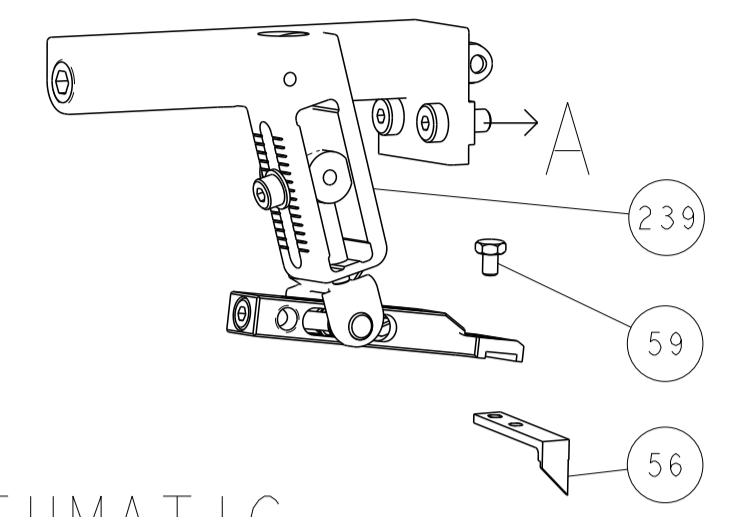
LOC	DIST	REVISIONS					
A	66	P	LTN	DESCRIPTION	DATE	DWN	APVD
		-		SEE SHEET 1			

-	1	1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
3	-	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
6	-	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	455888-4	SPACER, CRIMPER	82
-	1	1	1803607-3	DOCUMENTATION PACKAGE	71
-	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
5	-	1	985575-3	SCR, FLT SKT HD CAP M3 X 10.0	57
-	1	1	1338685-1	PAWL, FEED	56
-	2	2	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	53
-	1	1	5018030-1	NUT, HEX, REG, RoHS, M3	52
-	1	1	811242-5	BUMPER, HOLD DOWN	51
-	1	1	690753-2	SPACER, TONKER	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	1752356-3	SUPPORT, TERMINAL	34
-	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	3-2844962-0	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29
-	1	1	455888-5	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	1	1-1633134-5	ANVIL, COMBINATION .110	8
-	1	1	240641-3	SPACER	7
-	-	-	-	-	6
-	1	1	2119781-5	DEPRESSOR, SHEAR	5
-	1	1	2-238011-1	BLOCK, CRIMPER SPACER	4
1	1	1	1-1633996-3	CRIMPER, INSULATION SPECIAL	3
-	1	1	1-455888-5	SPACER, CRIMPER	2
1	1	1	456408-3	CRIMPER, WIRE PREMIUM	1
-77	-22	-21	PART NO	DESCRIPTION	ITEM NO

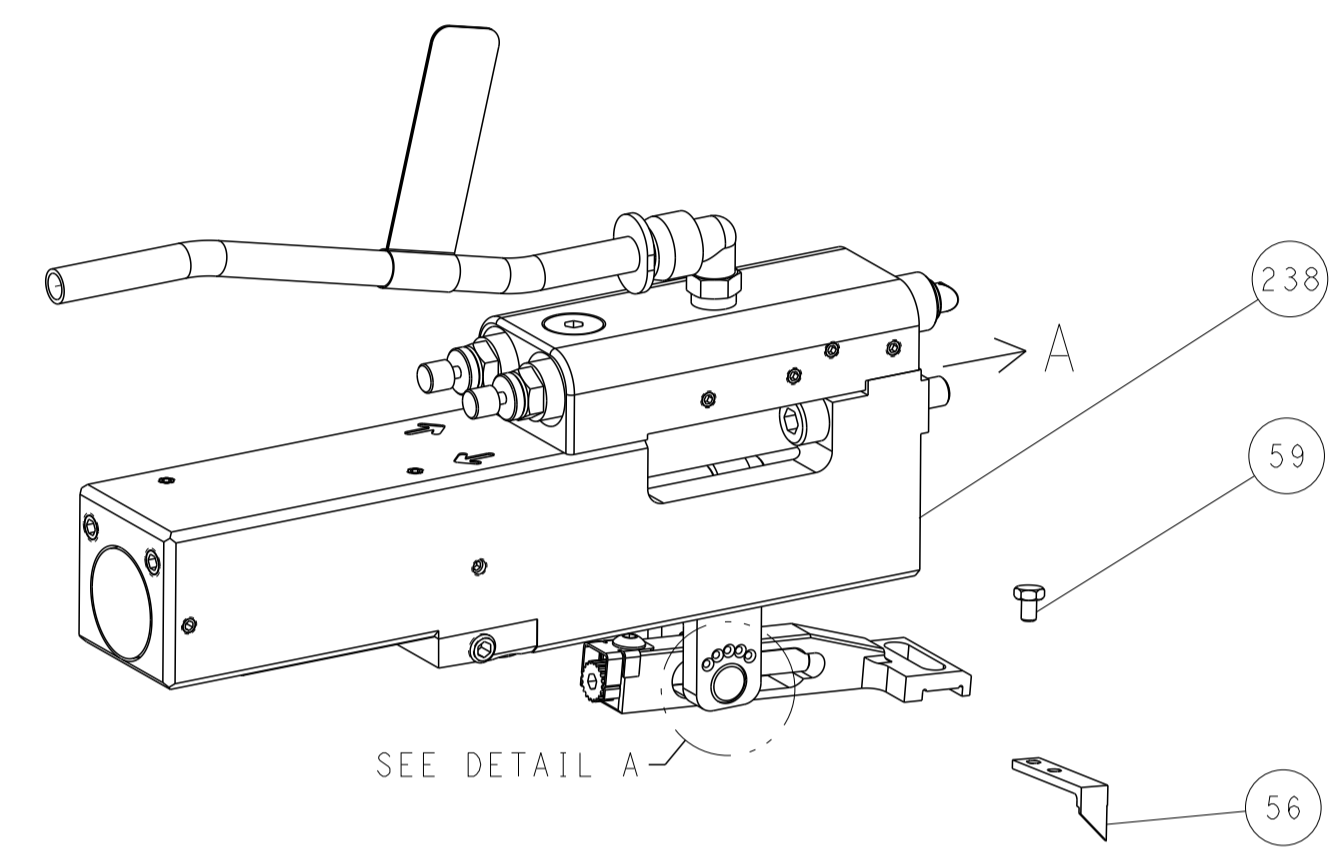
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN L. ZHANG 11OCT2012	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±
ANGLES	FINISH			CHK L. ZHANG 11OCT2012	
MATERIAL				APVD S. XI 11OCT2012	
CUSTOMER ACCESSIBLE PRODUCTION DRAWING		SCALE	1:2	SHEET	3 OF 4
REV D		REV D		REV D	

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

# FEED TYPE MECHANICAL



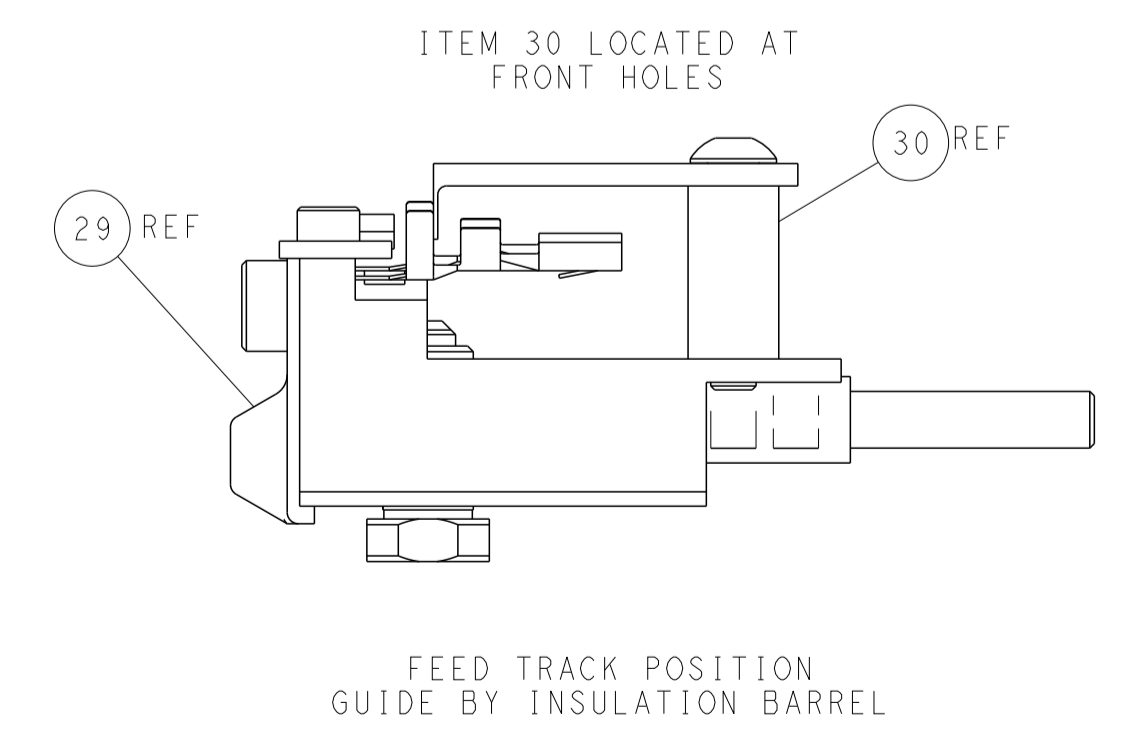
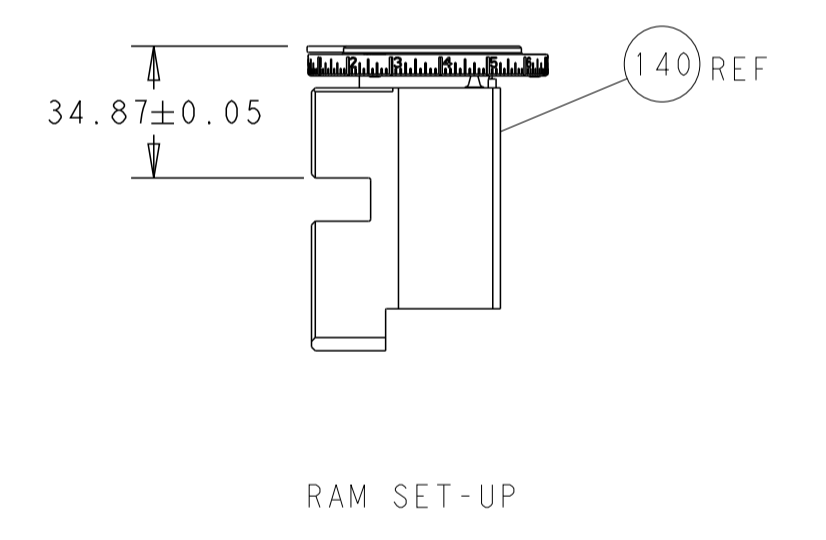
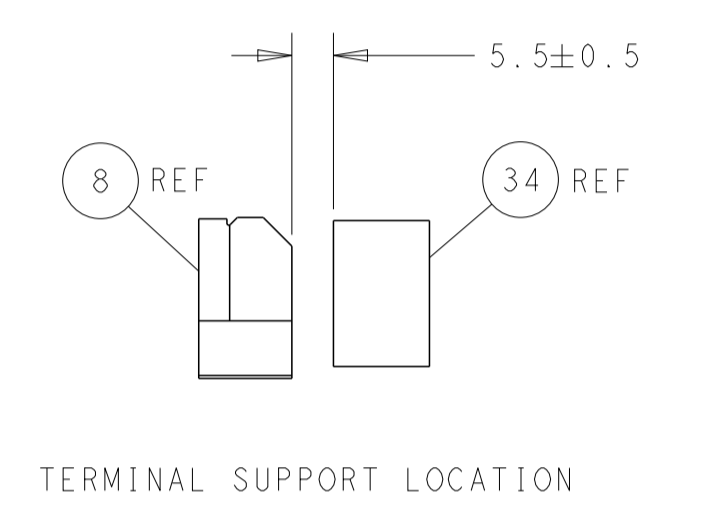
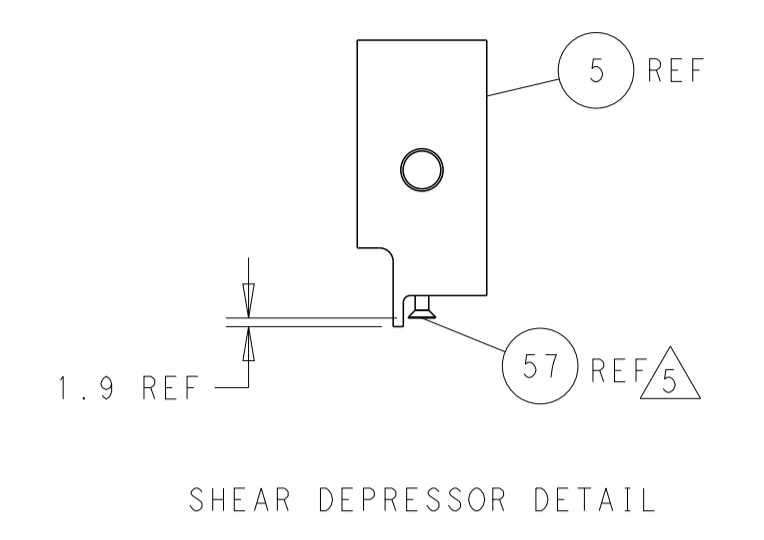
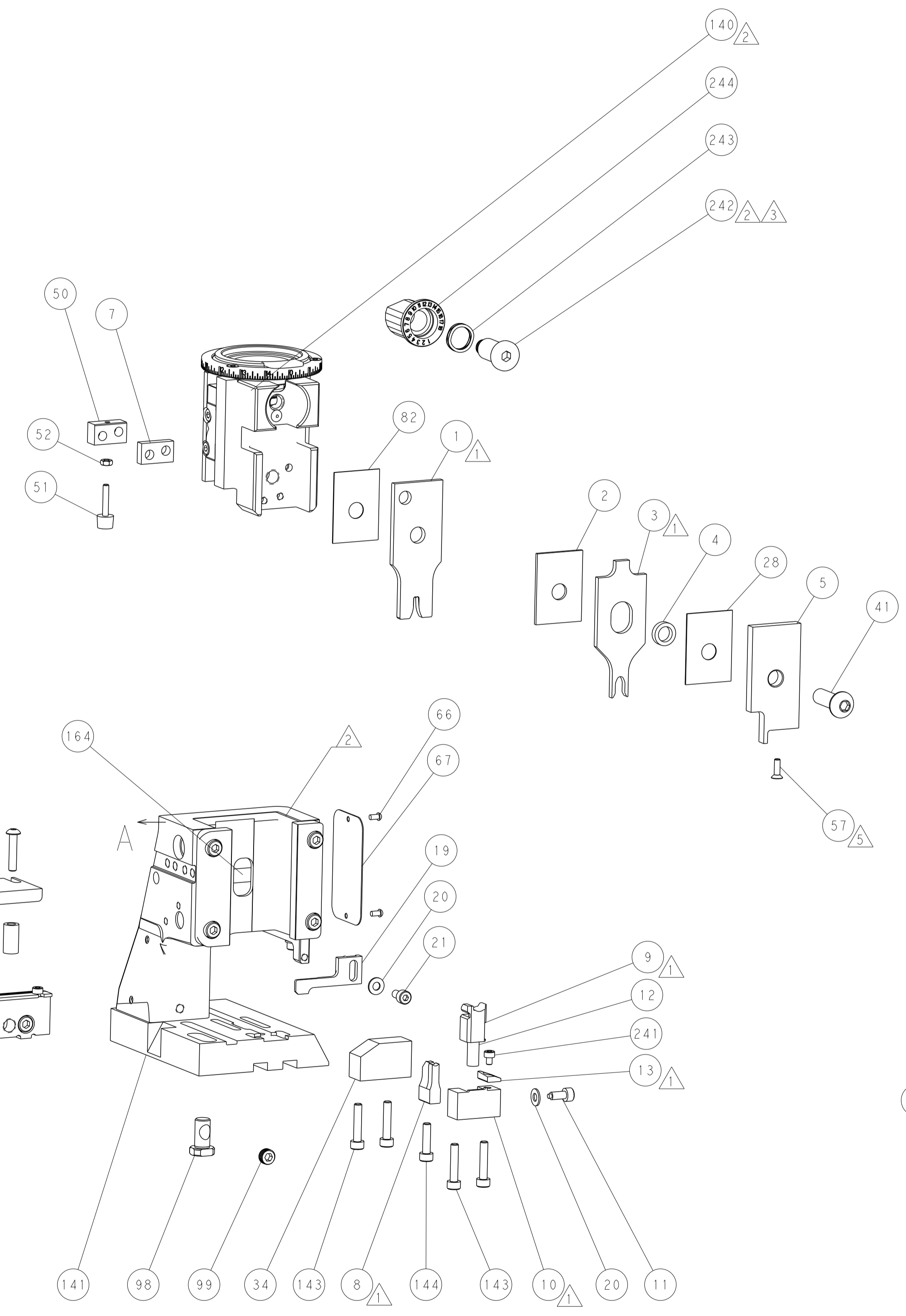
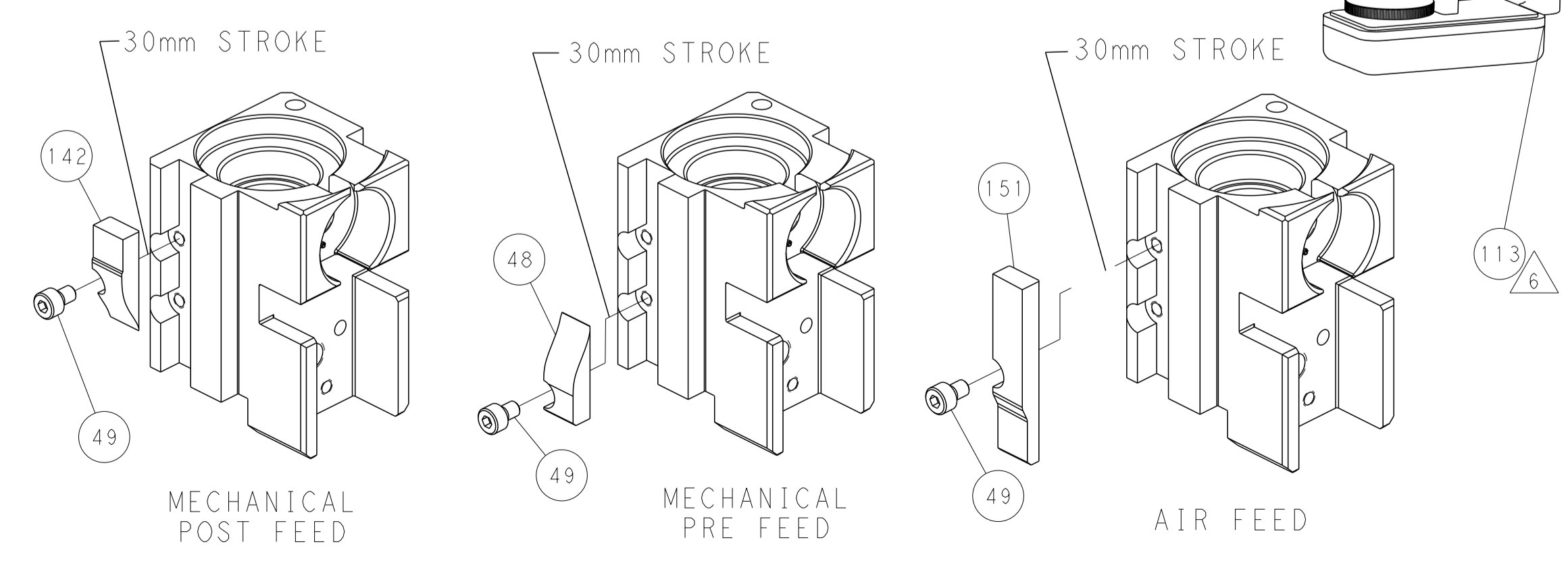
## PNEUMATIC



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



# 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: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH ±		DWN L. ZHANG 17OCT2012 CHK L. ZHANG 17OCT2012 S. XI 17OCT2012 APVD PRODUCT SPEC APPLICATION SPEC WEIGHT CUSTOMER ACCESSIBLE PRODUCTION DRAWING		NAME Ocean Side Feed Applicator SIZE CAGE CODE DRAWING NO A1 00779 C=2151582 SCALE 1:2 SHEET 4 OF 4 REV D		TE Connectivity Harrisburg, PA 17105-3608 RESTRICTED TO	
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