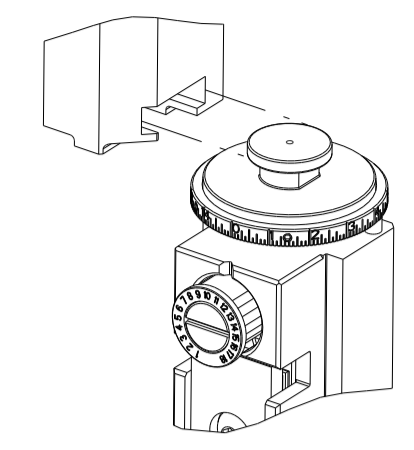


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151041-1	K	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2151041-2	K	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
5-2151041-1	K	STRIPPER SEAL TERMINATING UNIT	MECHANICAL
5-2151041-2	K	STRIPPER SEAL TERMINATING UNIT	PNEUMATIC
7-2151041-1	K	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2151041-2	K	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2151041-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.27 mm [.050]	F
INSUL	3.05 mm [.120]	O

APPLICATOR INSTRUCTIONS 408-35042

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: AMP MCP 1.2 LL SWS			
WIRE STRIP LENGTH	TERMINAL INSULATION DIAMETER RANGE		
3.00-3.60 mm [.118-.142 IN]	Ø1.10-1.75 mm [.043-.069 IN]		
TERMINAL APPLICATION SPECIFICATION	114-18464		

TERMINALS APPLIED				
TE TERMINAL	TE TERMINAL	TE SEAL	TE SEAL	CABLE DIAMETER
1452665-1	1452665-2		967067-1	Ø1.40-1.75mm
1452665-3	7-1452665-1		963142-2	Ø1.10-1.30mm
7-1452665-2	7-1452665-3		967067-2	Ø1.10-1.40mm

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.35mm ²	0.84 +/- 0.03 [.033 +/- .001]	7.7
22AWG	0.83 +/- 0.03 [.033 +/- .001]	7.8
0.25mm ²	0.78 +/- 0.03 [.031 +/- .001]	8.3
24AWG	0.75 +/- 0.03 [.030 +/- .001]	8.6

- 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 ITEMS 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. 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. DUE TO THE DEMANDS OF APPLICATION SPEC 114-18464 IT IS IMPORTANT, IF THE ANVIL IS MOVED OR REPLACED, THAT IT IS BAISED TOWARDS THE OPERATORS POSITION AS FOR AS POSSIBLE WHEN RESCUING TO THE BASE PLATE.
- 7. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- 8. TERMINAL LUBRICANT IS RECOMMENDED.

***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
		G		ECR-18-011041	16JUL2018	YY	CT
		H		ECR-19-008142	23MAY2019	MZ	YY
		J		ECR-19-009410	15JUN2019	TB	TE
		K		ECR-21-110406	17AUG2021	FJ	TE

-	-	-	1	1	-	-	1803515-3	RAM ASSEMBLY, SF ATLANTIC	293
-	-	-	1	1	-	-	2-1803583-1	APPLICATOR BASIC ASSEMBLY, SF	292
-	1	-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248
-	1	1	1	1	1	1	2119082-4	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	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	994970-2	COUNTER, MAGNETIC	164
-	1	1	1	1	1	1	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113
-	1	1	1	1	1	1	2844908-1	SCREW, LOCKING	99
-	1	1	1	1	1	1	2844907-1	POST, LOCKING	98
-	1	1	1	1	1	1	455888-4	SPACER, CRIMPER	82
-	1	1	1	1	1	1	1803607-3	DOCUMENTATION PACKAGE	71
-	1	1	1	1	1	1	2119740-1	TAG, IDENTIFICATION	67
-	2	2	2	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	1	1	1	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	60
-	1	1	1	1	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	1	1	1	1	1	1	985575-4	SCR, FLT SKT HD CAP M3 X 12.0	57
-	1	1	1	1	1	1	1338685-1	PAWL, FEED	56
-	4	4	4	4	4	4	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	54
-	2	2	2	2	2	2	2-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 14	53
-	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	1803583-9	APPLICATOR BASIC ASSEMBLY, SF	46
-	1	1	-	-	1	1	1803515-1	RAM ASSEMBLY, SF ATLANTIC	44
-	1	1	1	1	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
-	1	1	1	1	1	1	1752356-3	SUPPORT, TERMINAL	34
-	2	2	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	2	2	2	2	2-2844962-8	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	1	1	1	1	2844992-2	ASSEMBLY, STRIP GUIDE	29
-	1	1	1	1	1	1	455888-3	SPACER, CRIMPER	28
-	1	1	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	1	1	2	2	1-18028-2	WASHER, FLAT, REG M4	20
-	1	1	-	-	1	1	2119533-1	STRIPPER, SIDE FEED	19
-	1	1	1	1	1	1	2119806-1	INSERT, SHEAR	13
-	1	1	1	1	1	1	3-22280-3	SPRING, COMPRESSION	12
-	1	1	1	1	1	1	1-356885-4	STOP, SHEAR	11
-	1	1	1	1	1	1	2119805-1	SHEAR HOLDER, FRONT	10
-	1	1	1	1	1	1	318707-9	FLOATING SHEAR, FRONT	9
1	2	2	1	1	1	1	3-1333225-9	ANVIL, COMBINATION	8
-	1	1	1	1	1	1	2-240641-4	SPACER	7
-	1	1	1	1	1	1	2119781-1	DEPRESSOR, SHEAR	5
-	1	1	1	1	1	1	238011-4	BLOCK, CRIMPER SPACER	4
1	2	2	1	1	1	1	1633965-2	CRIMPER, INSULATION O PREMIUM	3
-	1	1	1	1	1	1	455888-9	SPACER, CRIMPER	2
1	2	2	1	1	1	1	1-1673600-0	CRIMPER, WIRE	1

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

ITEM NO	PART NO	DESCRIPTION
-77	-72	-71
-52	-51	-2
-1		

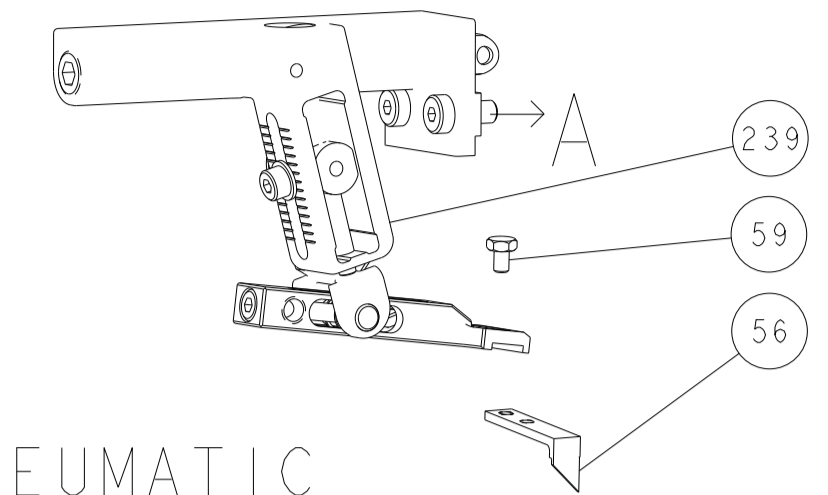
OWN	S. ZOU	11MAR2011
CHK	T. ELBIN	11MAR2011
APVD	S. XI	11MAR2011

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

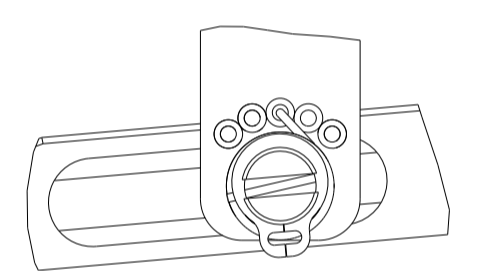
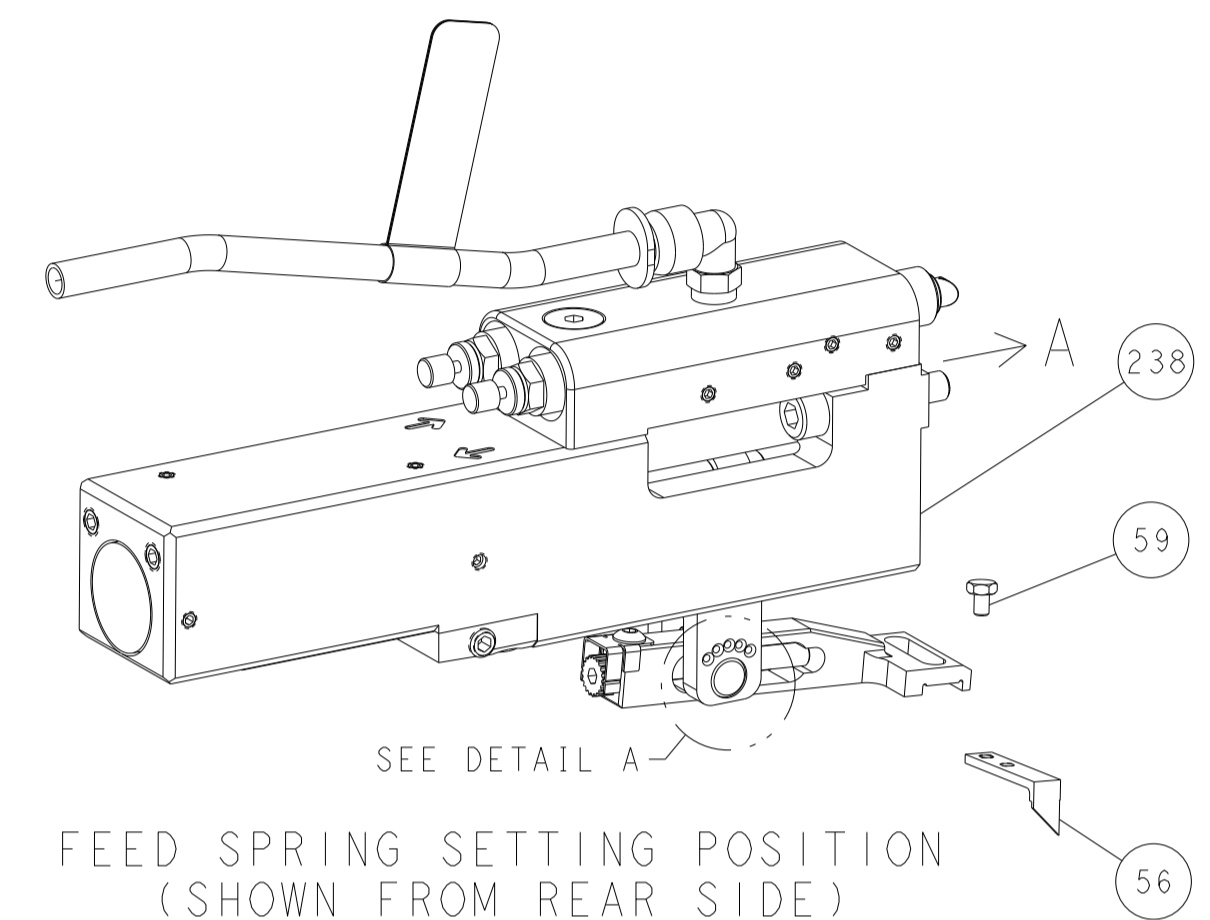
NAME	Ocean Side Feed Applicator		
SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
A1	00779	2151041	-
CUSTOMER ACCESSIBLE PRODUCTION DRAWING		SCALE	SHEET 1 OF 4
		1:2	REV K

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

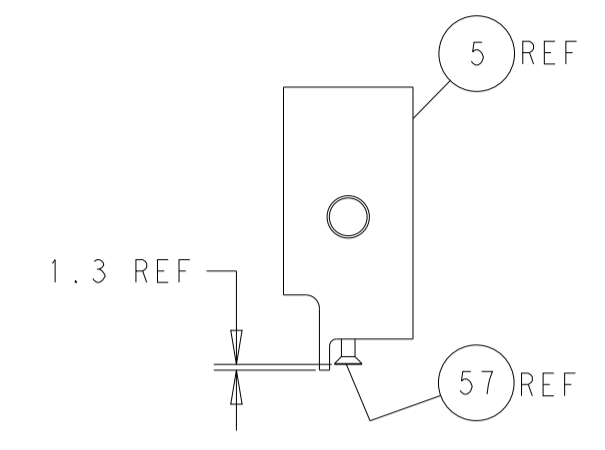
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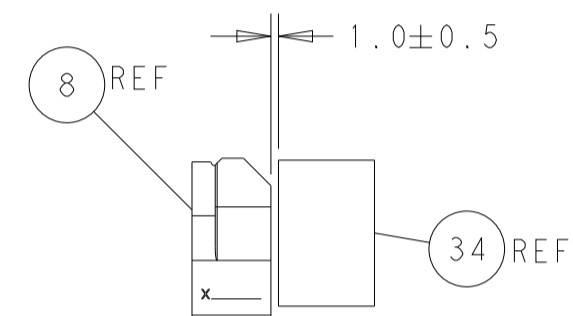
PNEUMATIC



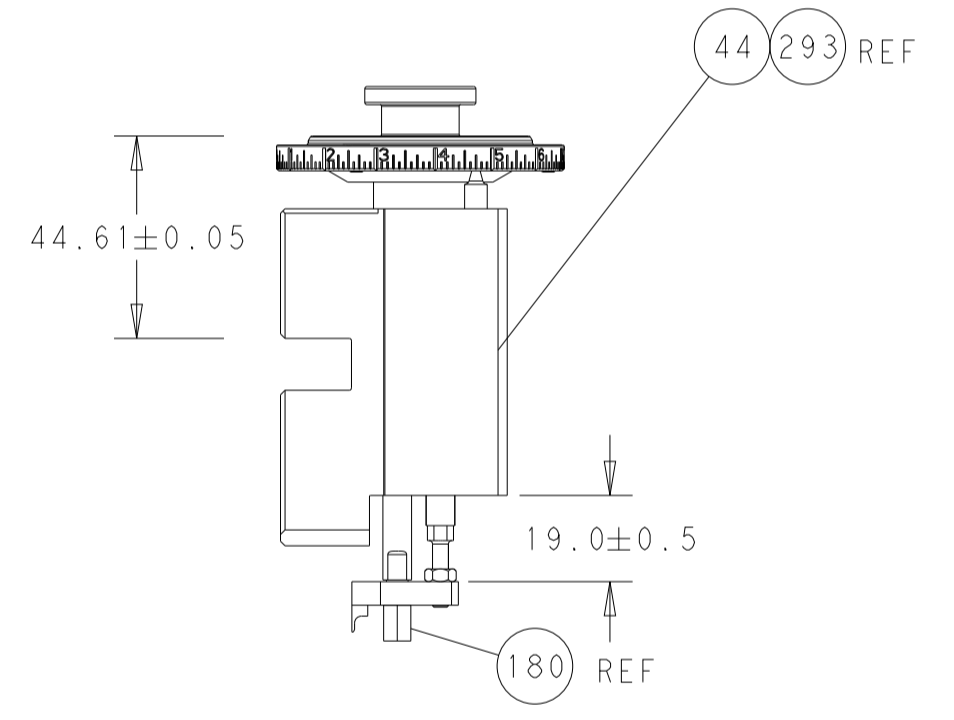
DETAIL A



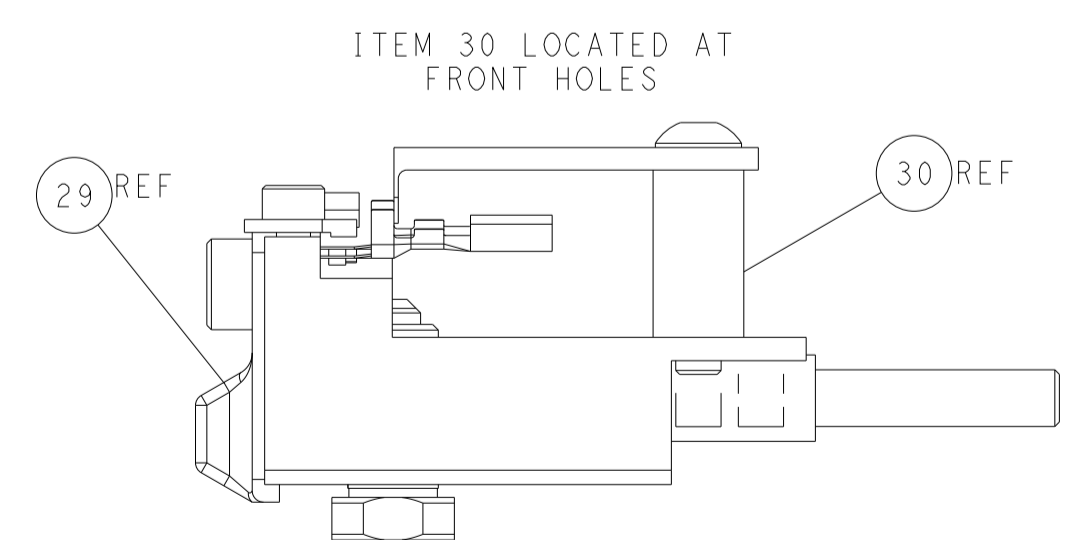
SHEAR DEPRESSOR DETAIL



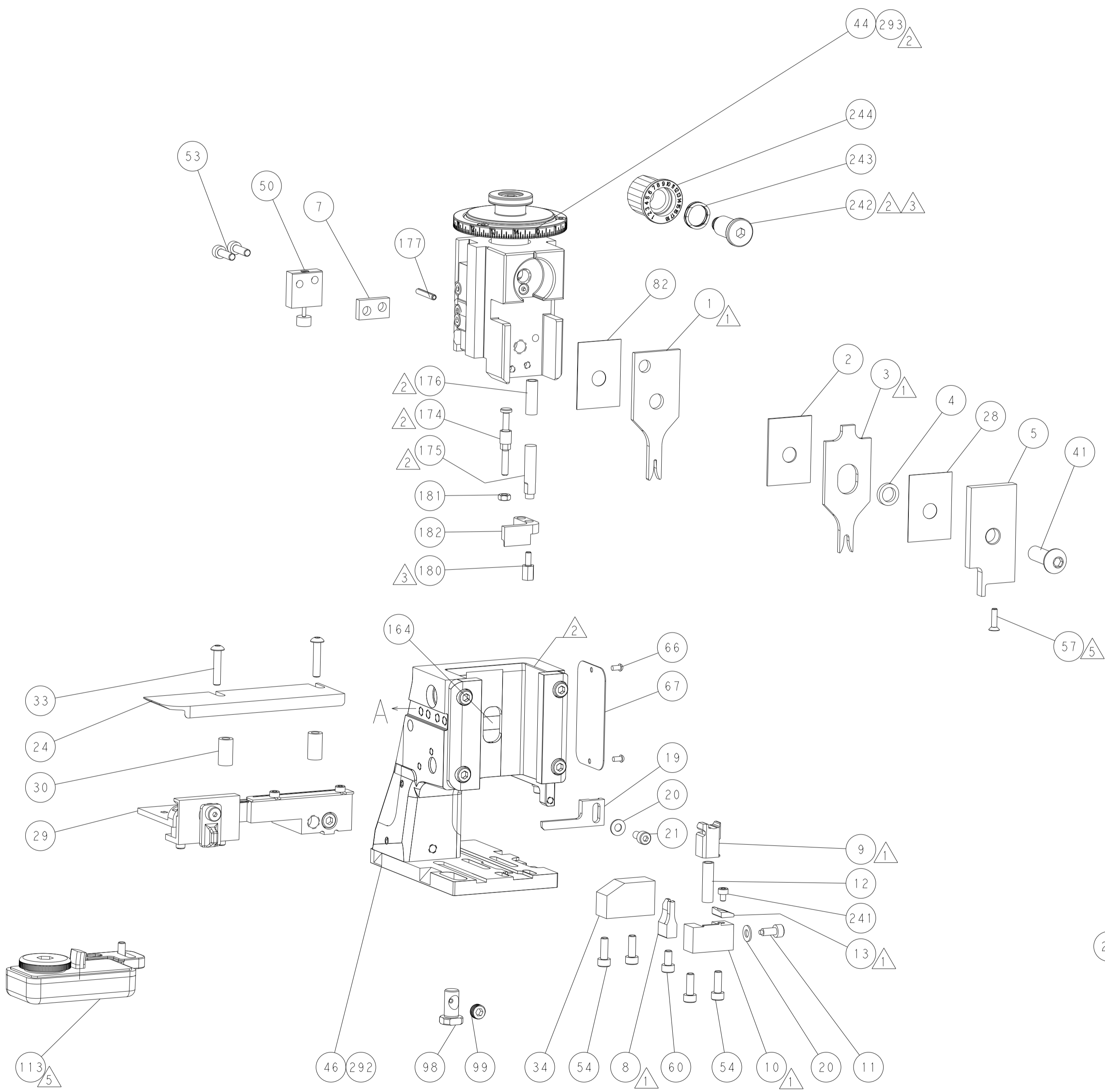
TERMINAL SUPPORT LOCATION



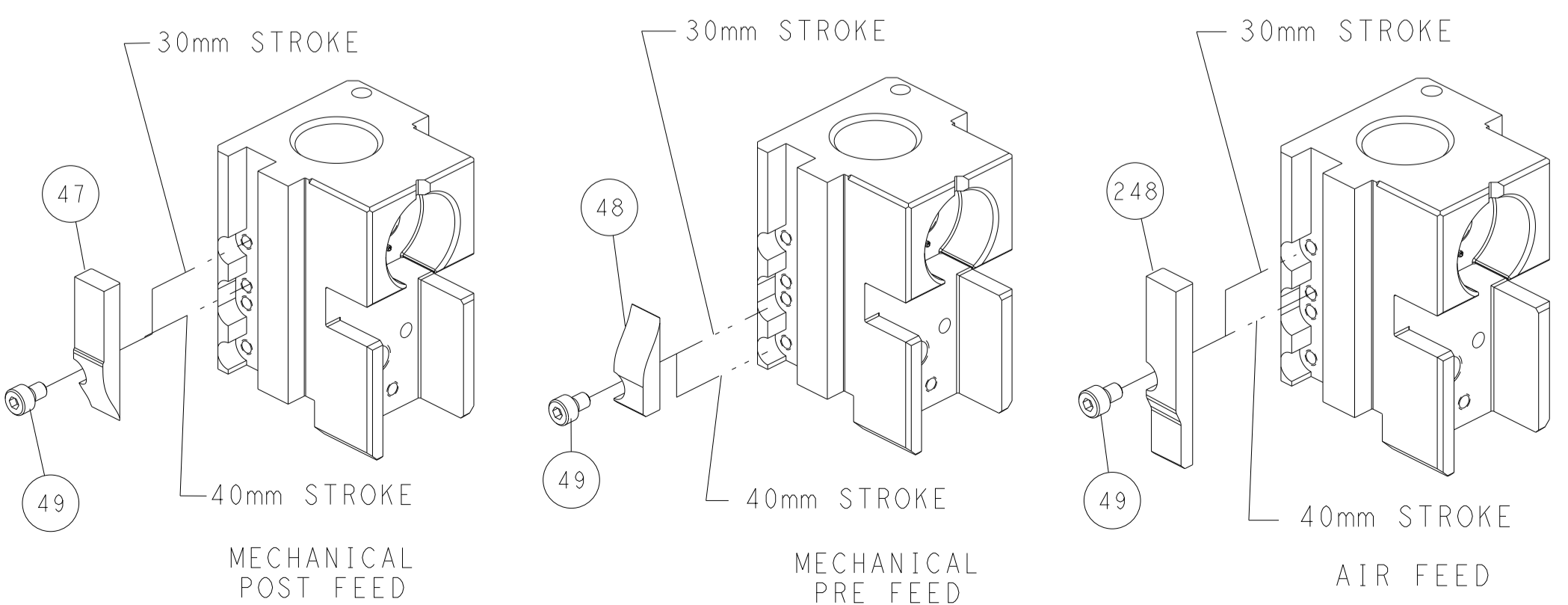
RAM AND HOLDDOWN SET-UP



FEED TRACK POSITION GUIDE BY INSULATION BARREL



CAM POSITIONS

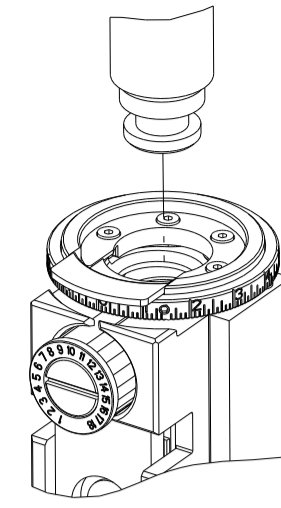


ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		OWN	S_ZOU	11MAR2011	TE Connectivity Harrisburg, PA 17105-3608
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES FINISH	
MATERIAL:		WEIGHT:		APVD	S_XI	11MAR2011	NAME
							Ocean Side Feed Applicator
							SIZE
							CAGE CODE
							DRAWING NO
							RESTRICTED TO
							A1 00779 ©=2151041
							CUSTOMER ACCESSIBLE PRODUCTION DRAWING
							SCALE
							1:2
							SHEET
							2 OF 4
							REV
							K

THIS DRAWING IS UNPUBLISHED.	RELEASED FOR PUBLICATION		
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2151041-1	K	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2151041-2	K	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151041-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.27 mm [.050]	F
INSUL	3.05 mm [.120]	O
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: AMP MCP 1.2 LL SWS			
WIRE STRIP LENGTH 3.00-3.60 mm [.118-.142 IN]		TERMINAL INSULATION DIAMETER RANGE Ø1.10-1.75 mm [.043-.069 IN]	
TERMINAL APPLICATION SPECIFICATION	114-18464	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE SEAL	TE SEAL
1452665-1	1452665-2		967067-1
1452665-3	7-1452665-1		963142-2
7-1452665-2	7-1452665-3		967067-2
			CABLE DIAMETER
			Ø1.40-1.75mm
			Ø1.10-1.30mm
			Ø1.10-1.40mm

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.35mm2	0.84 +/- 0.03 [.033 +/- .001]	7.7
22AWG	0.83 +/- 0.03 [.033 +/- .001]	7.8
0.25mm2	0.78 +/- 0.03 [.031 +/- .001]	8.3
24AWG	0.75 +/- 0.03 [.030 +/- .001]	8.6

- 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 DUE TO THE DEMANDS OF APPLICATION SPEC 114-18464 IT IS IMPORTANT, IF THE ANVIL IS MOVED OR REPLACED, THAT IT IS BAISED TOWARDS THE OPERATORS POSITION AS FOR AS POSSIBLE WHEN RESCUING TO THE BASE PLATE.
- 7. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- 8 TERMINAL LUBRICANT IS RECOMMENDED.

***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
		-		SEE SHEET 1			

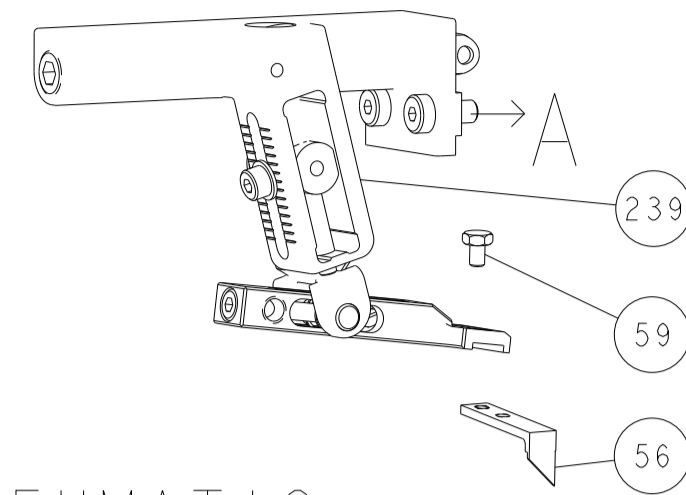
	-	1	1	2119082-4	CAM, SNAIL, INSULATION ADJUSTMENT	244
	-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
3	-	1	1	2119083-1	RETAINER, INSULATION DIAL	242
	-	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
	-	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
	-	1	-	2844940-1	AIR FEED MODULE	238
	-	REF	REF	994970-2	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
	-	1	1	1803516-1	RAM ASSEMBLY, SF PACIFIC	140
8	-	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	1	985575-4	SCR, FLT SKT HD CAP M3 X 12.0	57
	-	1	1	1338685-1	PAWL, FEED	56
	-	2	2	2-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 14	53
	-	1	1	1803382-6	HOLD DOWN, SPRING LOADED	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	2-2844962-8	SPACER, CYLINDRICAL, STRIP GUIDE	30
	-	1	1	2844992-2	ASSEMBLY, STRIP GUIDE	29
	-	1	1	455888-3	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	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	318707-9	FLOATING SHEAR, FRONT	9
6	1	1	1	3-1333225-9	ANVIL, COMBINATION	8
	-	1	1	2-240641-4	SPACER	7
	-	1	1	2119781-1	DEPRESSOR, SHEAR	5
	-	1	1	238011-4	BLOCK, CRIMPER SPACER	4
1	1	1	1	1633965-2	CRIMPER, INSULATION O PREMIUM	3
	-	1	1	455888-9	SPACER, CRIMPER	2
1	1	1	1	1-1673600-0	CRIMPER, WIRE	1

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

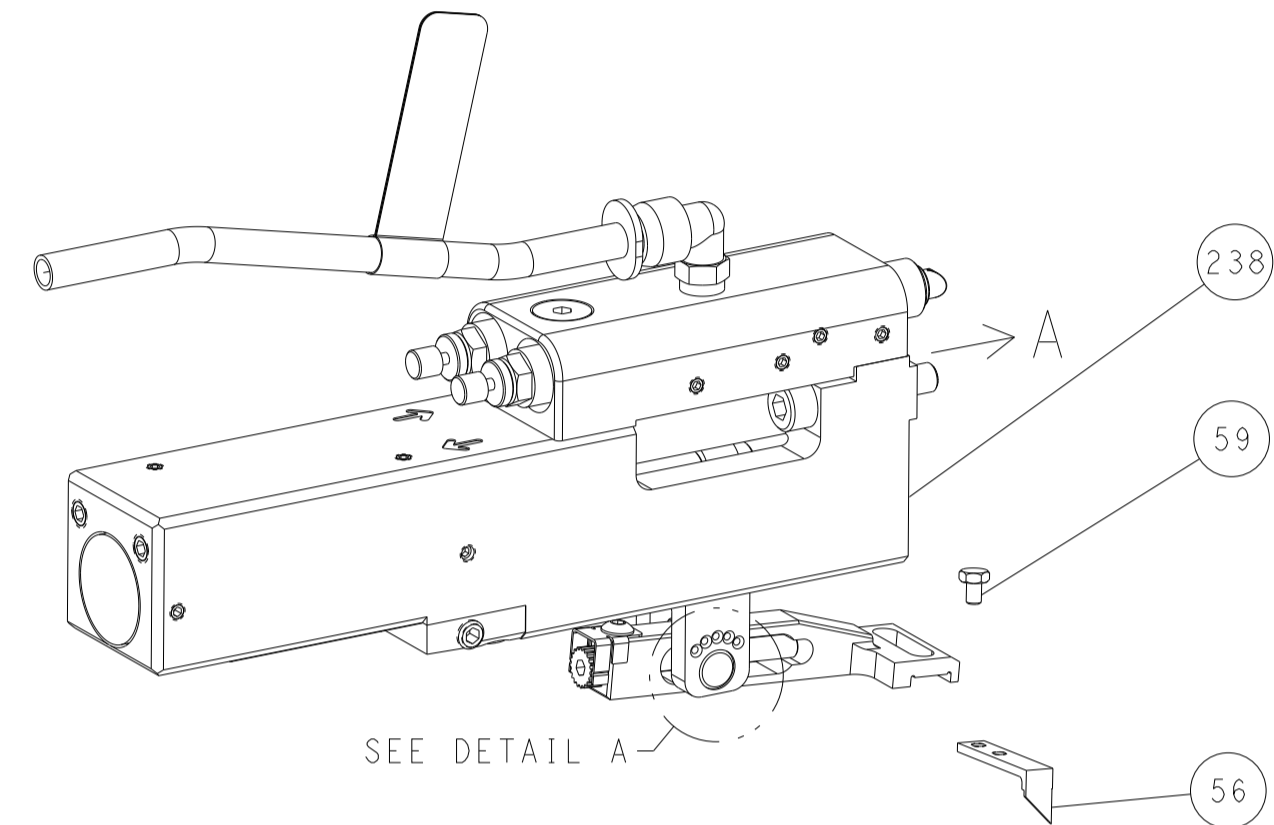
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DRAWING NO		DESCRIPTION		ITEM NO	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES ±	FINISH	0779	2151041
MATERIAL		FINISH		WEIGHT		SCALE		SHEET 3 OF 4	
-		-		-		1:2		REV K	

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

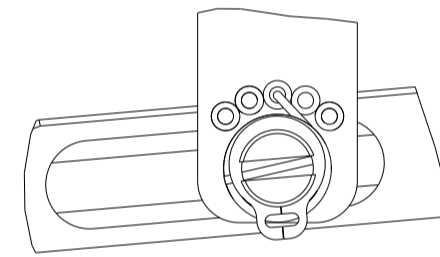
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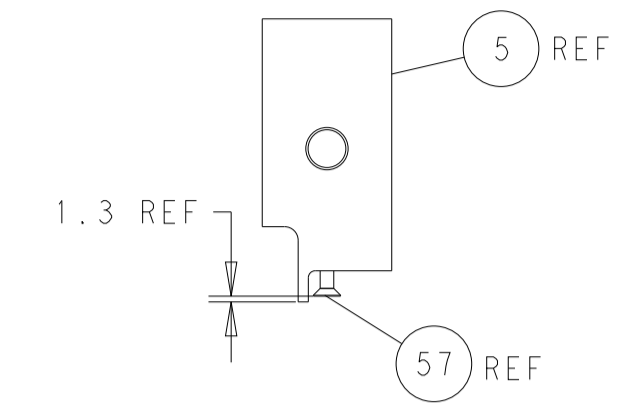
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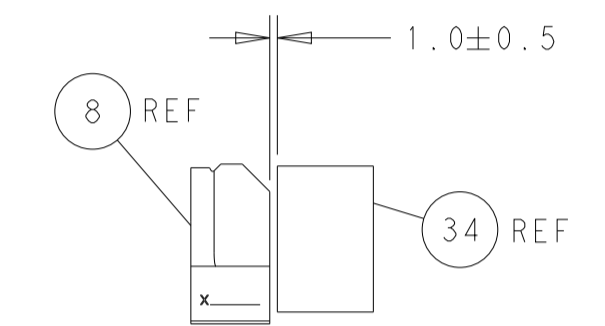
FEED SPRING SETTING POSITION
(SHOWN FROM REAR SIDE)



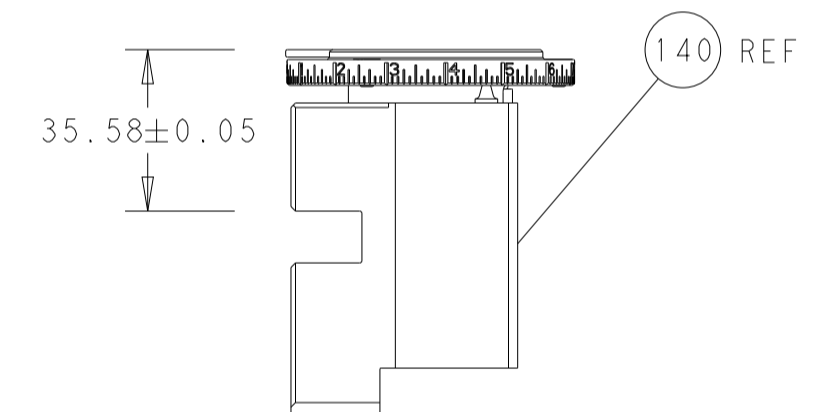
DETAIL A



SHEAR DEPRESSOR DETAIL

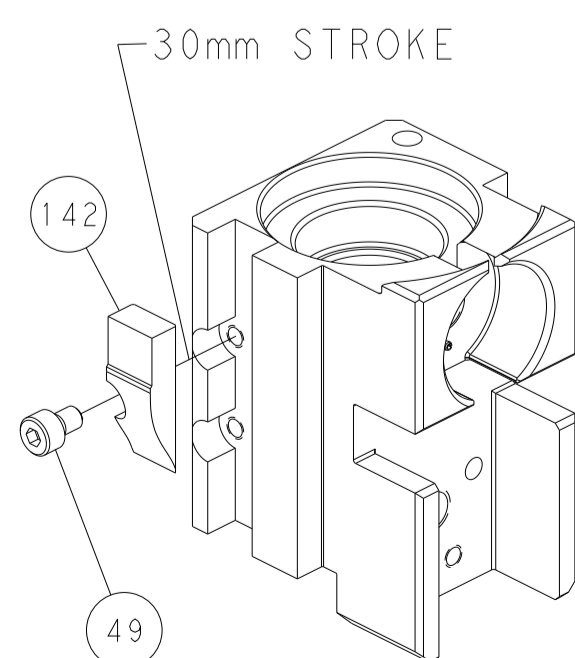


TERMINAL SUPPORT LOCATION

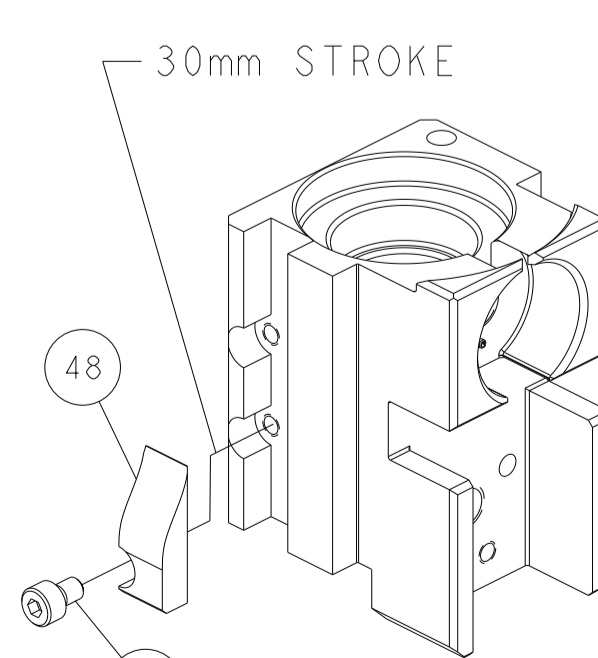


RAM SET-UP

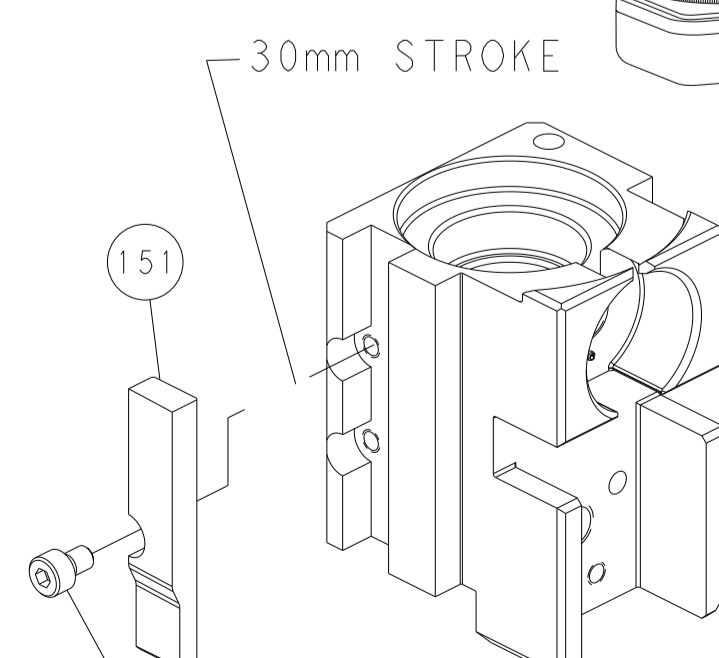
CAM POSITIONS



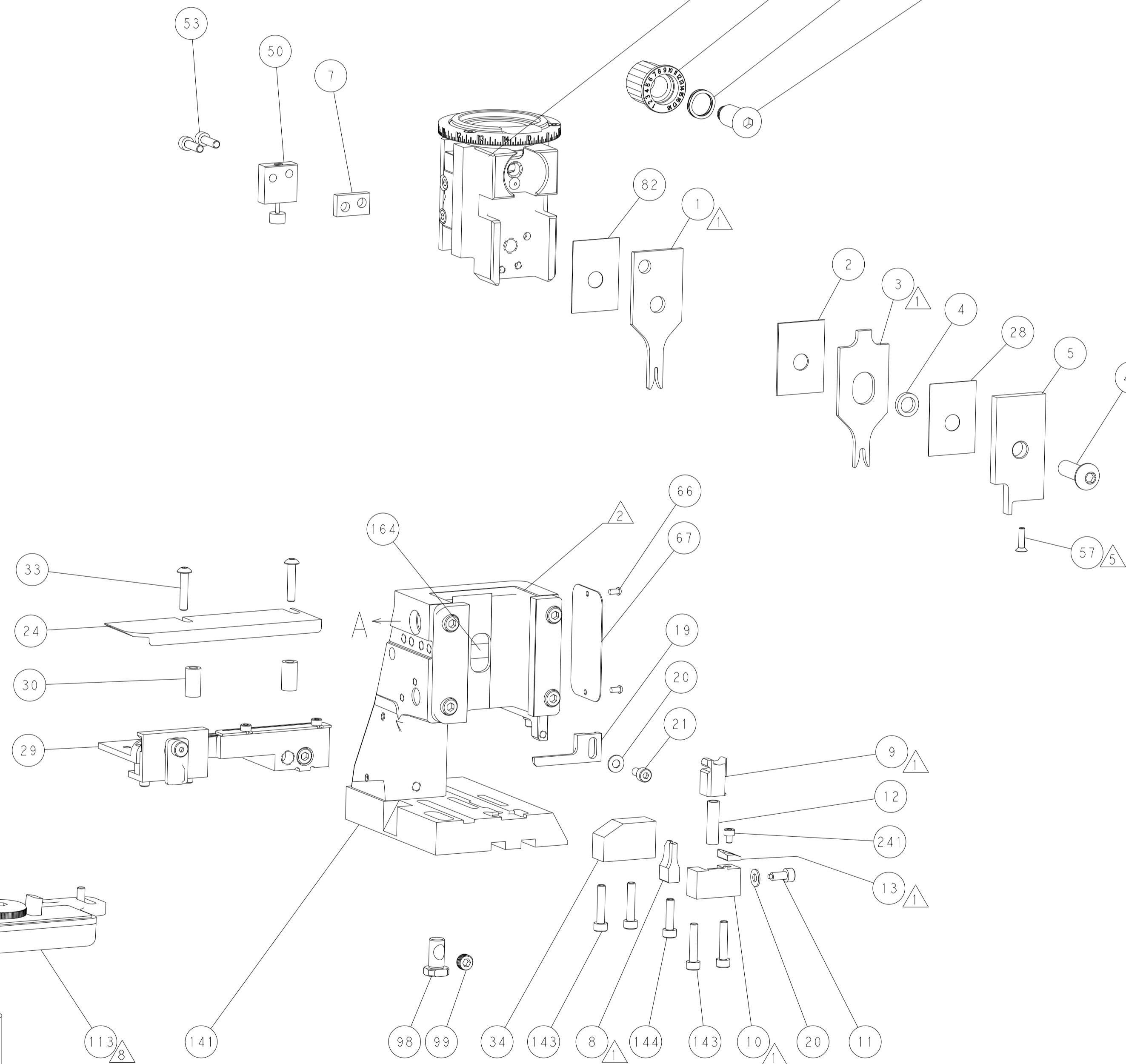
MECHANICAL
POST FEED



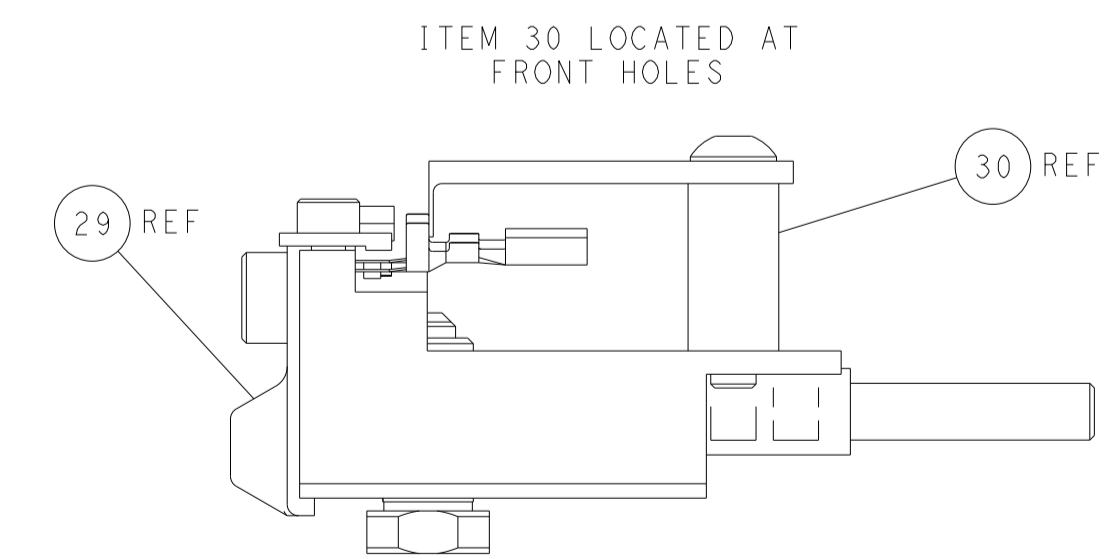
MECHANICAL
PRE FEED



AIR FEED



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



FEED TRACK POSITION
GUIDE BY INSULATION BARREL

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DIMENSIONS: mm 	TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH ±	NAME: Ocean Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: C-2151041 SCALE: 1:2 SHEET: 4 OF 4 REV: K	RESTRICTED TO:
MATERIAL:		CUSTOMER ACCESSIBLE PRODUCTION DRAWING	