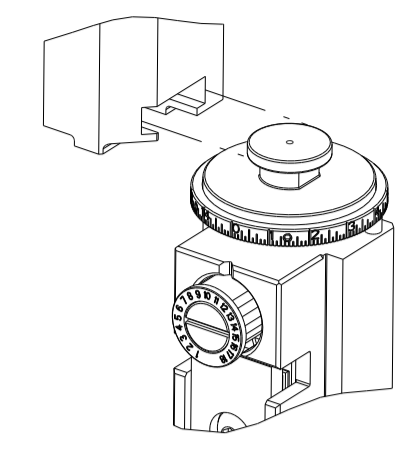


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151041-1	K	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2151041-2	K	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
5-2151041-1	K	STRIPPER SEAL TERMINATING UNIT	MECHANICAL
5-2151041-2	K	STRIPPER SEAL TERMINATING UNIT	PNEUMATIC
7-2151041-1	K	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
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 [1.18-.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
		H		ECR-19-008142	23MAY2019	MZ	YY
		J		ECR-19-009410	15JUN2019	TB	TE
		K		ECR-21-110406	17AUG2021	FJ	TE
		K1		ECR-22-148127	02AUG2022	FJ	YY

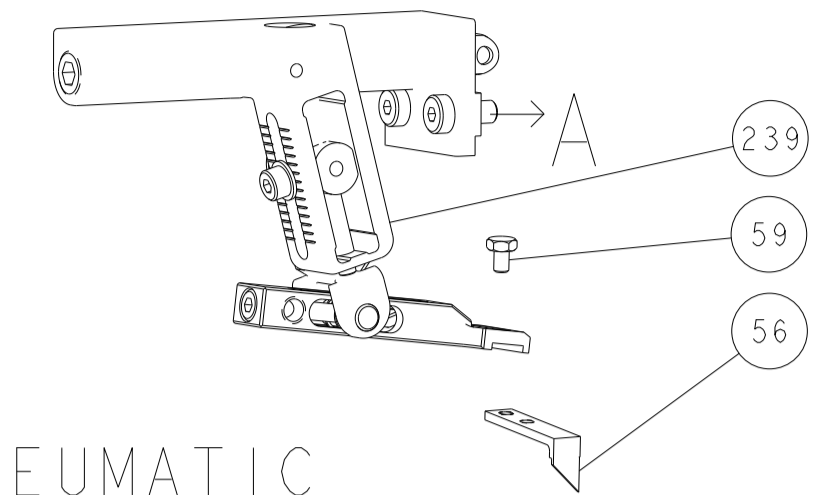
-	-	-	1	1	-	-	1803515-3	RAM ASSEMBLY, SF ATLANTIC	293
-	-	-	1	1	-	-	2-1803583-1	APPLICATOR BASIC ASSEMBLY, SF	292
-	1	-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248
-	1	1	1	1	1	1	2119082-4	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1	1	1	1	1	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)

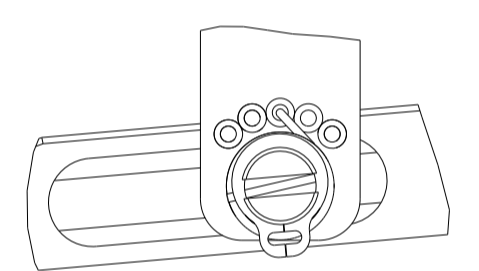
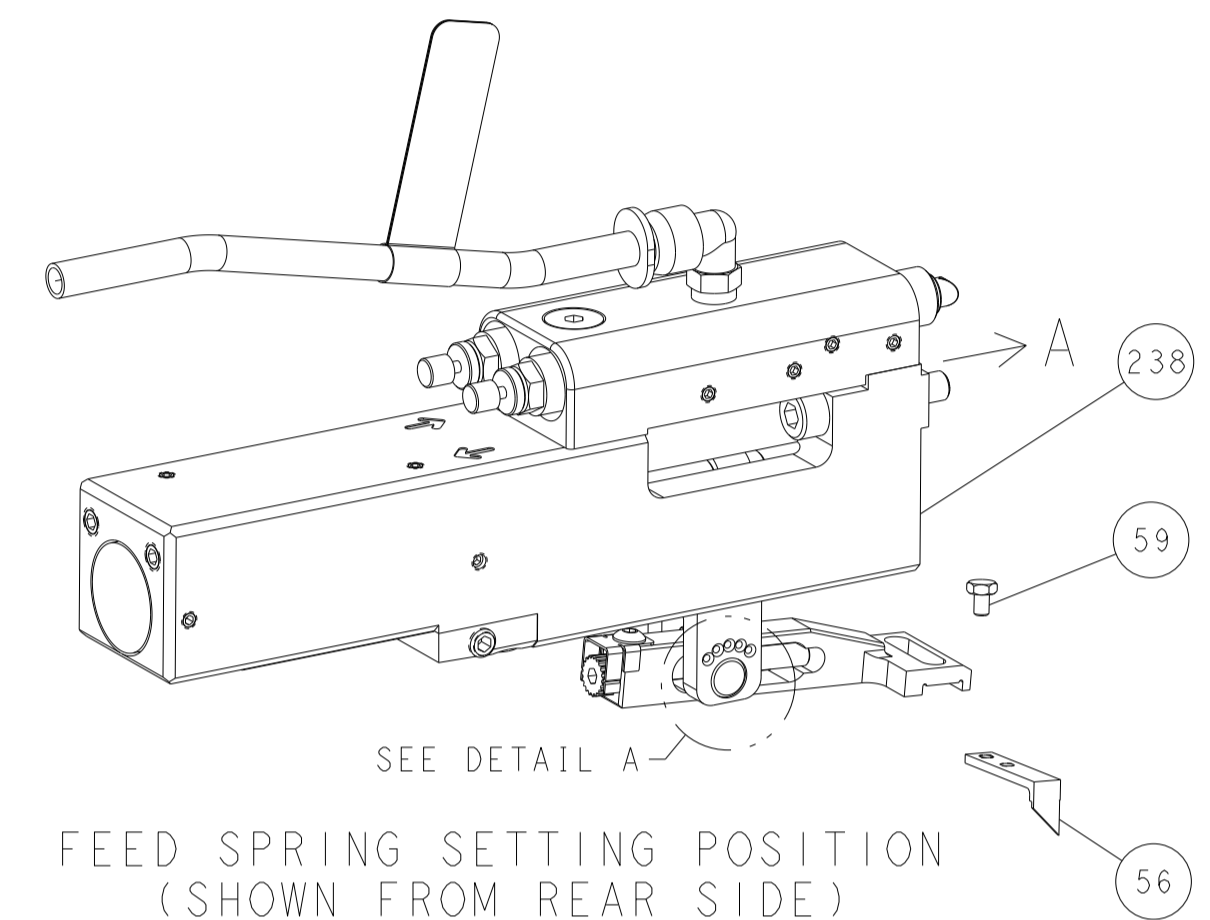
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								T. ELBIN	11MAR2011	Harrisburg, PA 17105-3608
								S. XI	11MAR2011	
										Ocean Side Feed Applicator
										SIZE CAGE CODE DRAWING NO RESTRICTED TO
										A1 00779 C=2151041
										CUSTOMER ACCESSIBLE PRODUCTION DRAWING SCALE 1:2 SHEET 1 OF 4 REV K1

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

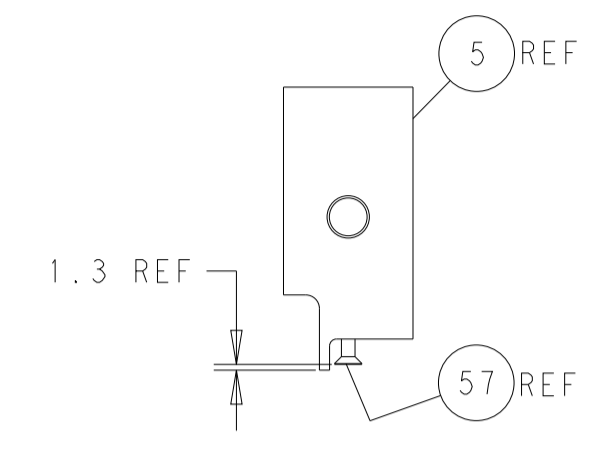
FEED TYPE MECHANICAL



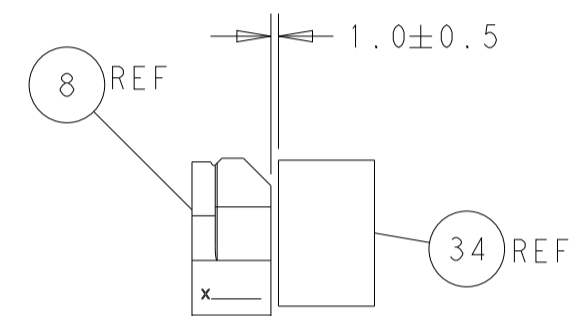
PNEUMATIC



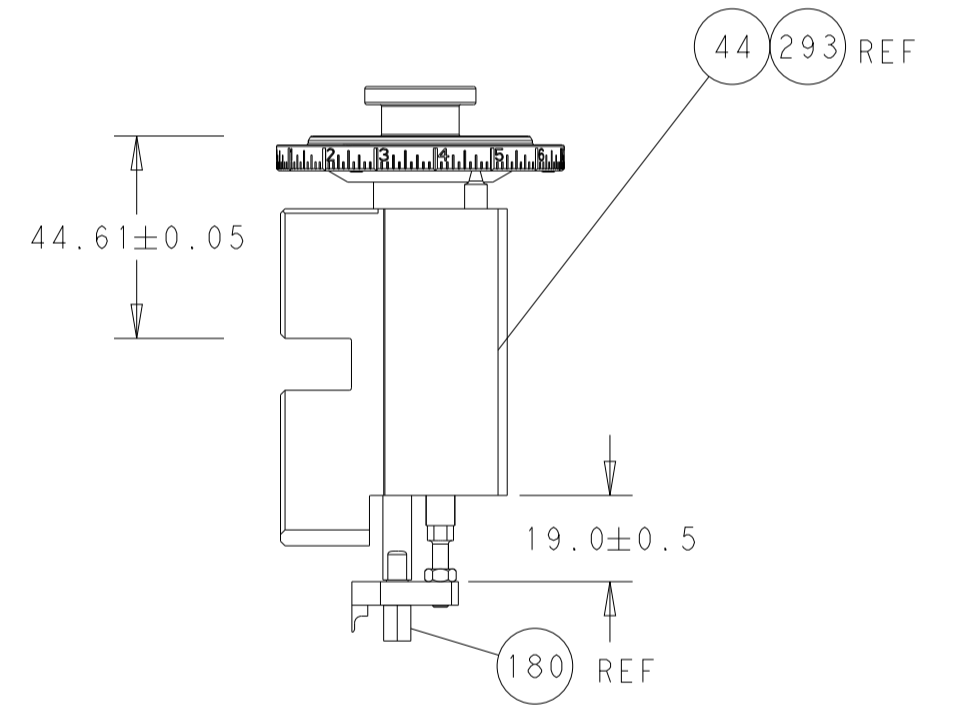
DETAIL A



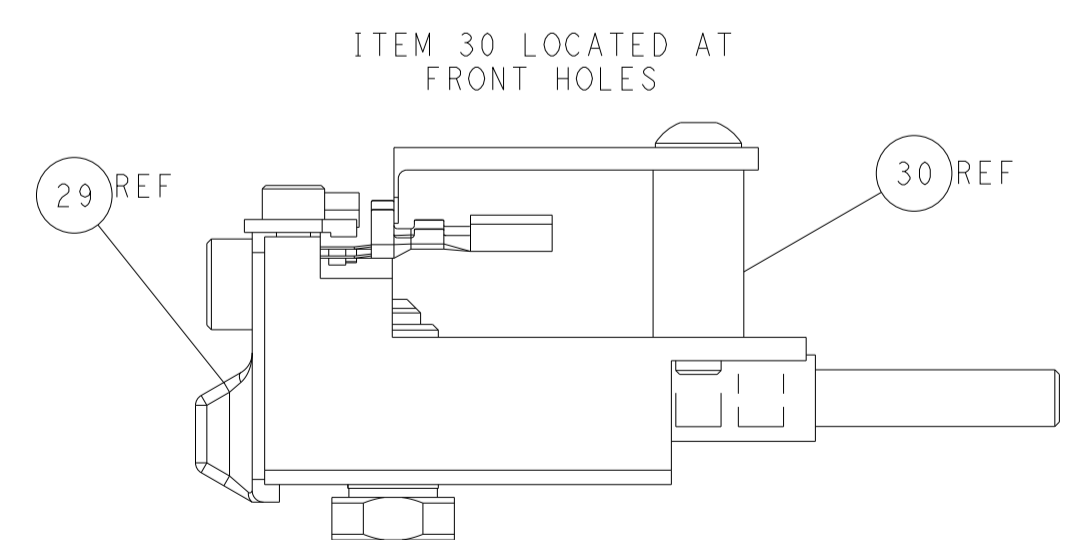
SHEAR DEPRESSOR DETAIL



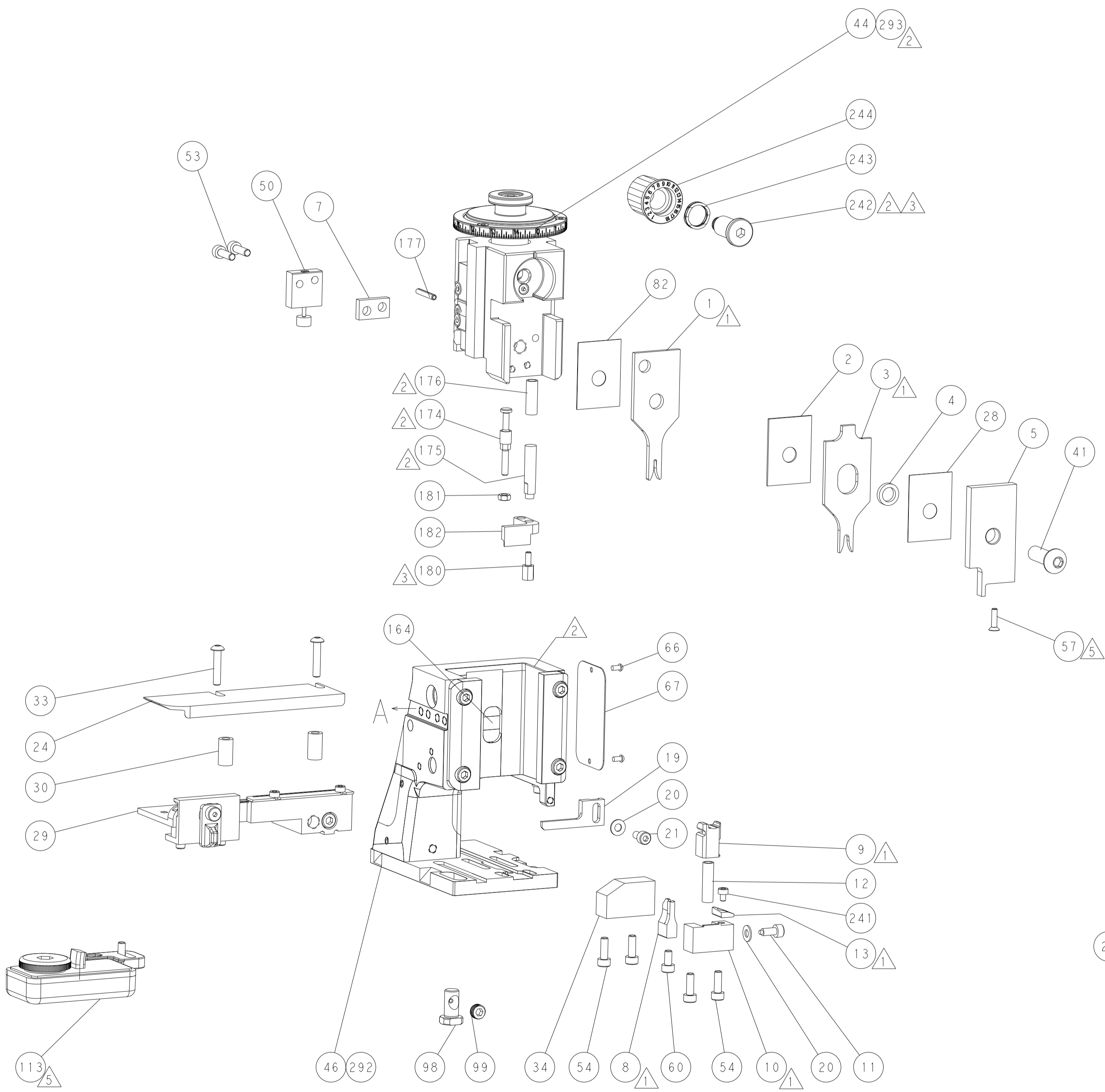
TERMINAL SUPPORT LOCATION



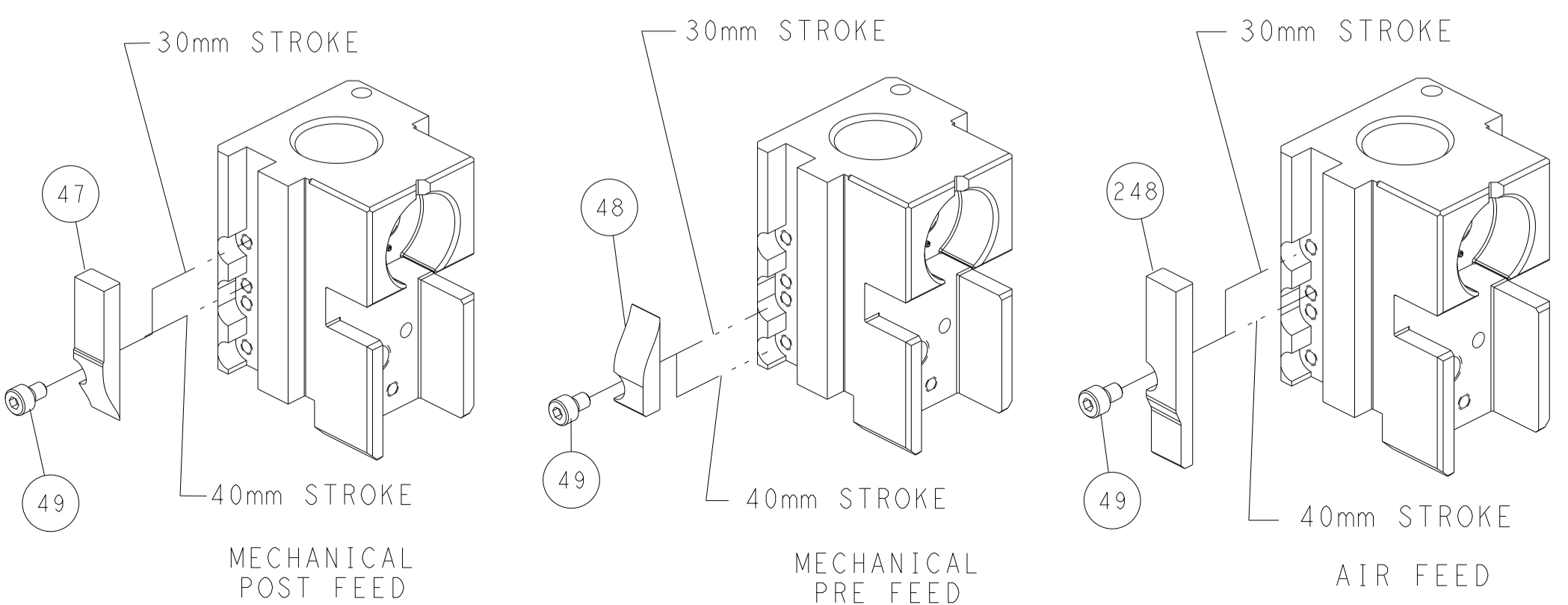
RAM AND HOLDDOWN SET-UP



FEED TRACK POSITION GUIDE BY INSULATION BARREL



CAM POSITIONS

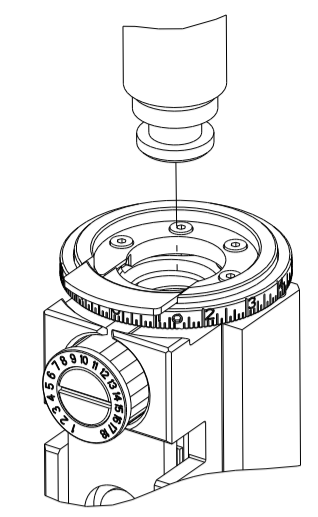


ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

<small>THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.</small>		DWN: S_ZOU 11MAR2011 CHK: T_ELFIN 11MAR2011 APVD: S_XI 11MAR2011	NAME: TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH	PRODUCT SPEC APPLICATION SPEC WEIGHT SCALE: 1:2	SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2151041 SHEET 2 OF 4	RESTRICTED TO: K1

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		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
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+/-0.001]	7.7
22AWG	0.83+/-0.03 [.033+/-0.001]	7.8
0.25mm2	0.78+/-0.03 [.031+/-0.001]	8.3
24AWG	0.75+/-0.03 [.030+/-0.001]	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.

ENTRY LEVEL APPLICATOR		ITEM SUBSTITUTION LIST		
PART NUMBER	SAME AS	ITEM	ITEM DESCRIPTION	SUBSTITUTE PART NUMBER
8-2151041-1	2151041-1	1	WIRE CRIMPER	1-1803548-0
8-2151041-2	2151041-2	3	INSULATION CRIMPER	1803624-2
9-2151041-1	2-2151041-1	46	BASIC SUB -ASSEMBLY	1803940-9
9-2151041-2	2-2151041-2	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)

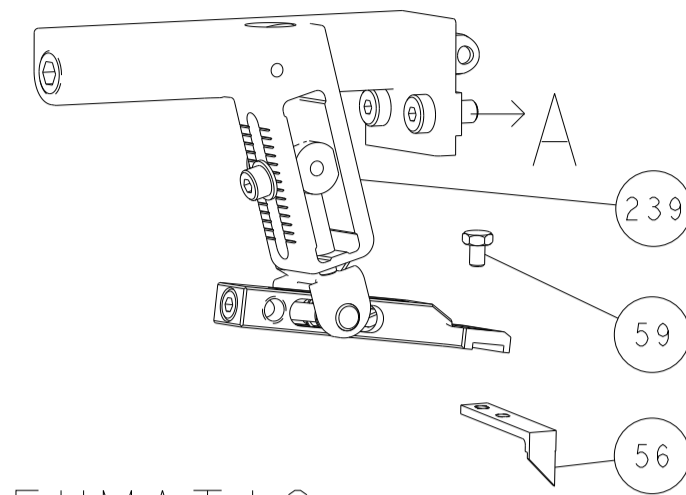
LOC	DIST	REVISIONS					
A	66	P	LTN	DESCRIPTION	DATE	OWN	APVD
-	-	-	-	SEE SHEET 1	-	-	-

-	1	1	2119082-4	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
-	1	1	1803516-1	RAM ASSEMBLY, SF PACIFIC	140
8	-	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	985575-4	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	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	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	1633965-2	CRIMPER, INSULATION O PREMIUM	3
-	1	1	455888-9	SPACER, CRIMPER	2
1	1	1	1-1673600-0	CRIMPER, WIRE	1

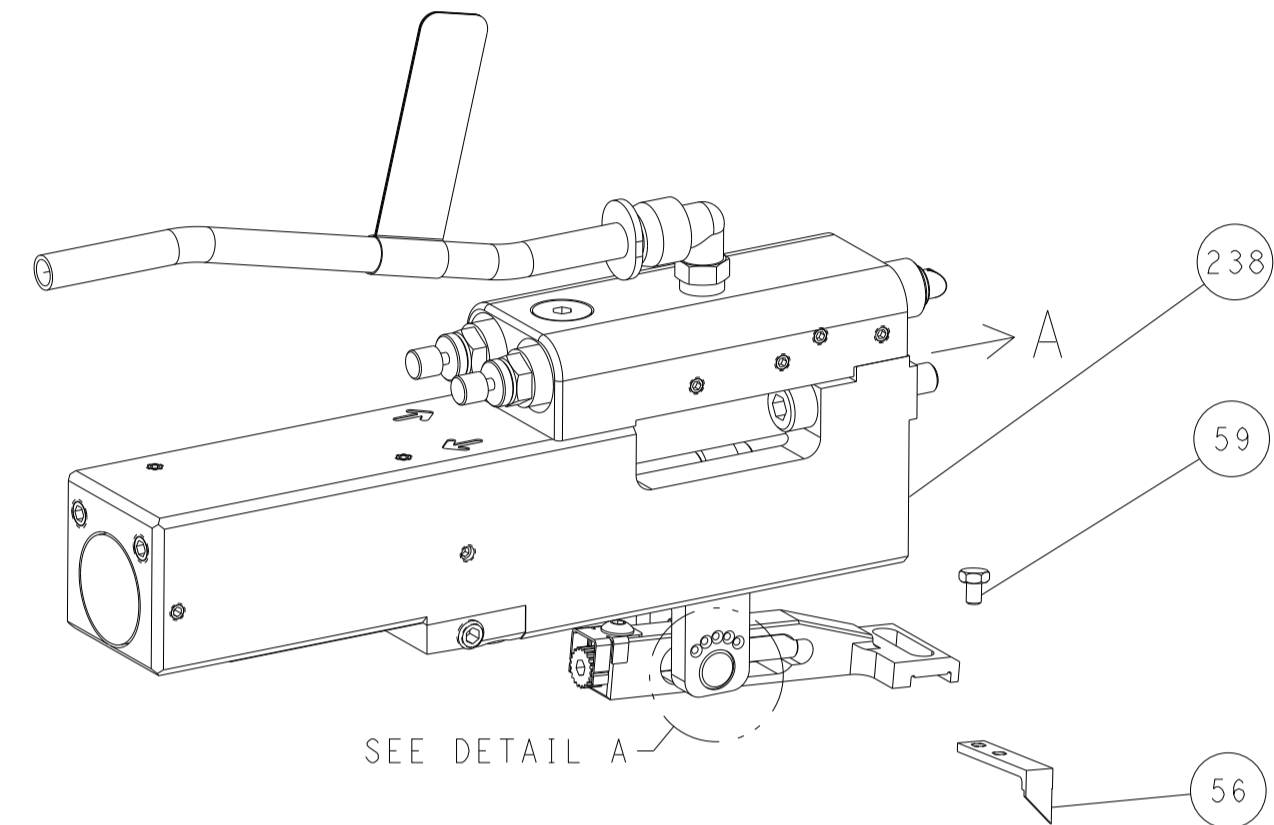
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MATERIAL				WEIGHT	SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
-				-	A1	00779	©=2151041	-
CUSTOMER ACCESSIBLE PRODUCTION DRAWING				SCALE	SHEET	3	OF	4
				SCALE	1:2	SHEET	3	OF
				REV	K1			

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

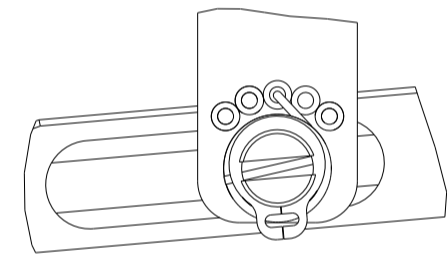
FEED TYPE MECHANICAL



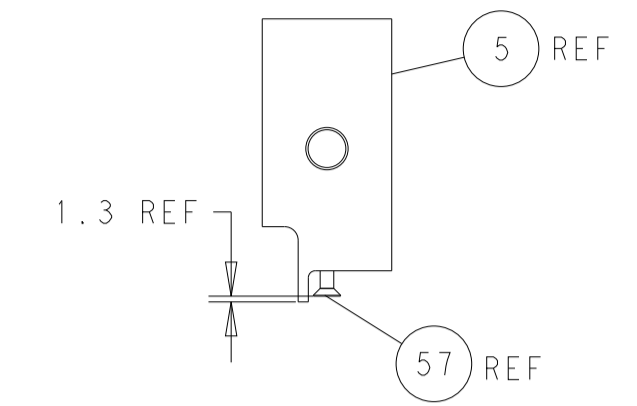
PNEUMATIC



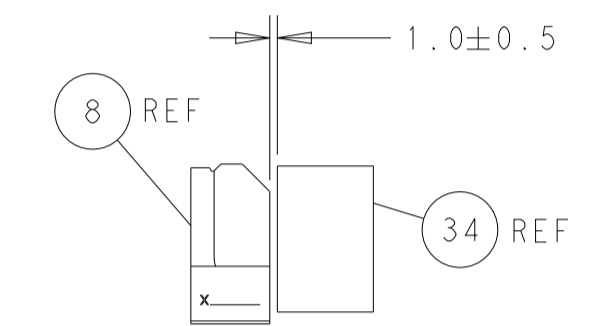
FEED SPRING SETTING POSITION
(SHOWN FROM REAR SIDE)



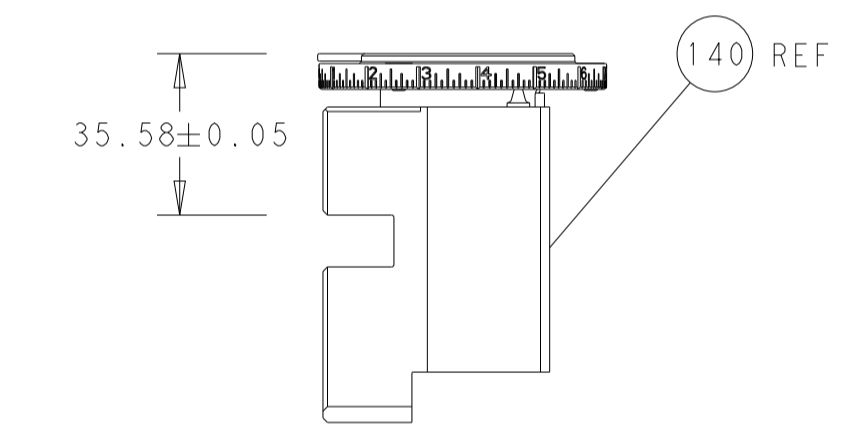
DETAIL A



SHEAR DEPRESSOR DETAIL

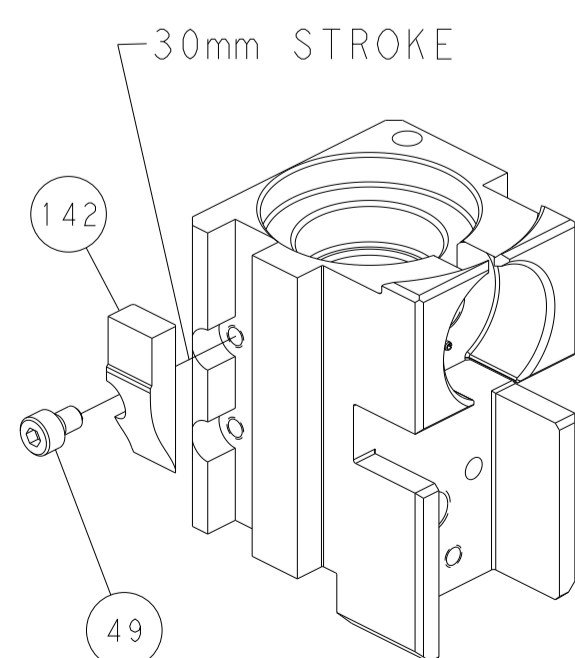


TERMINAL SUPPORT LOCATION

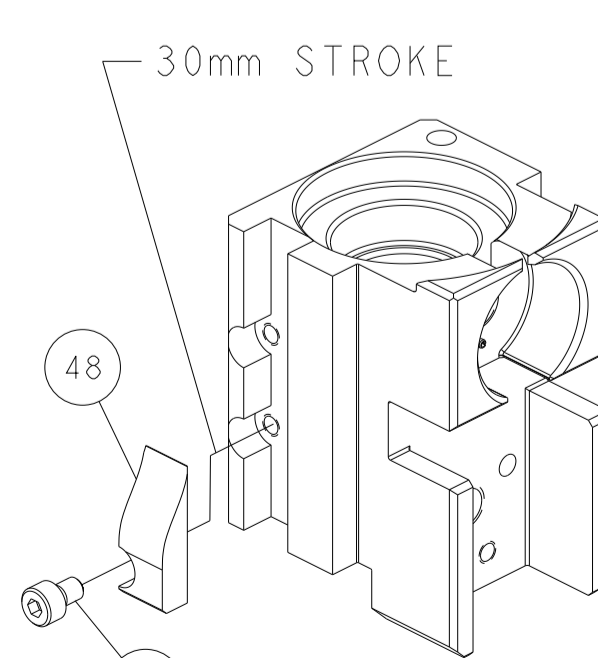


RAM SET-UP

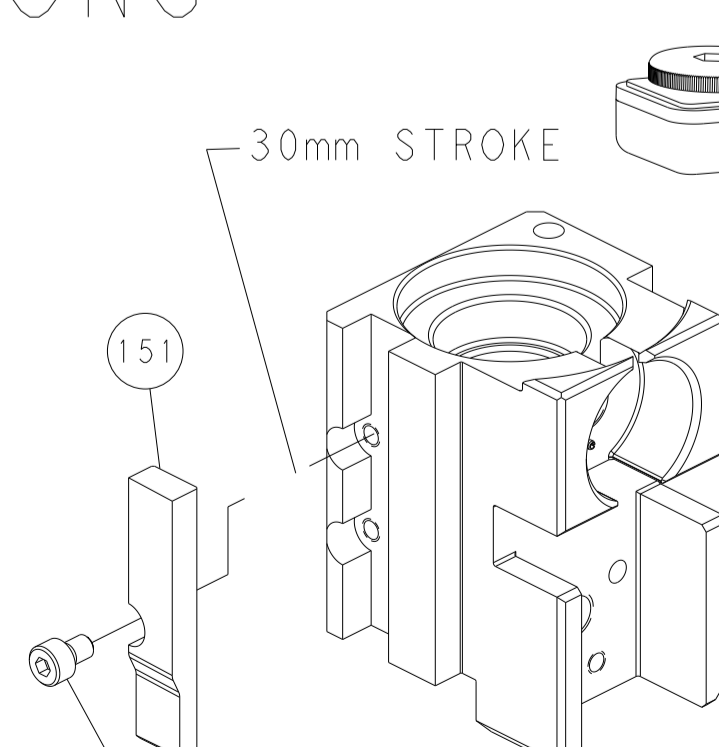
CAM POSITIONS



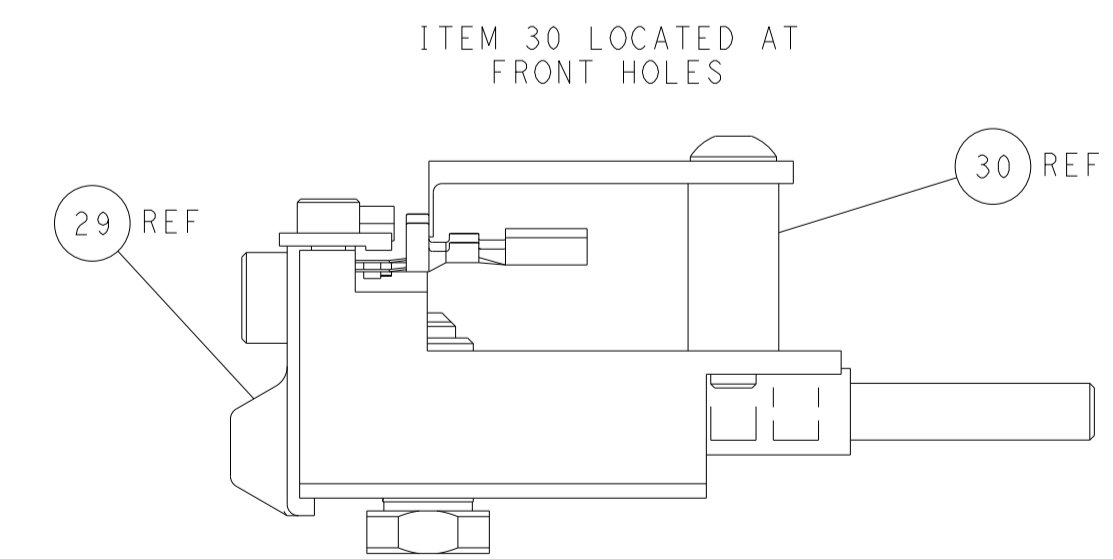
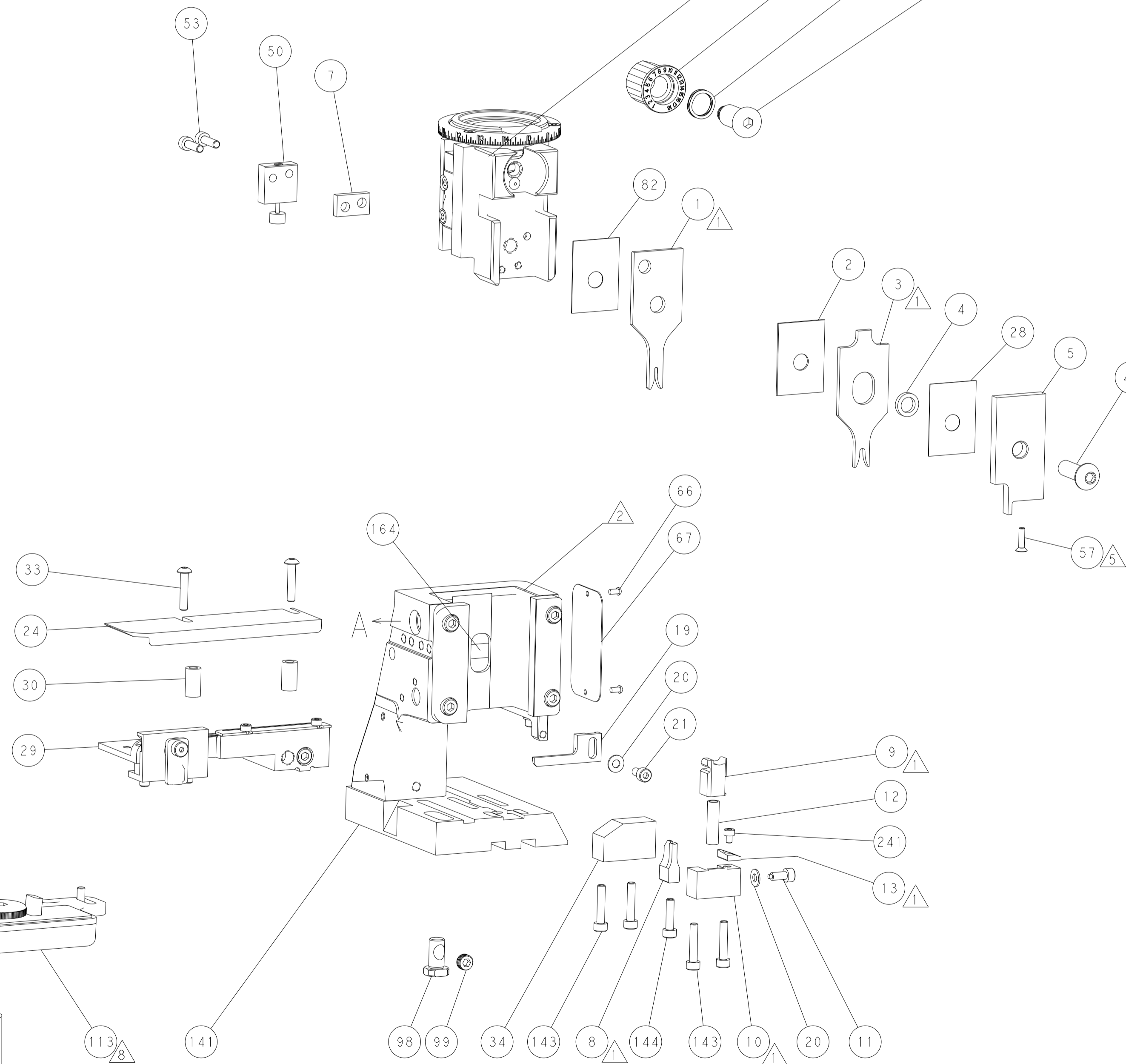
MECHANICAL
POST FEED



MECHANICAL
PRE FEED



AIR FEED



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)

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DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± MATERIAL: - FINISH: -		NAME: Ocean Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2151041 SCALE: 1:2 SHEET: 4 OF 4 REV: K1	RESTRICTED TO: -
CUSTOMER ACCESSIBLE PRODUCTION DRAWING		SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION	