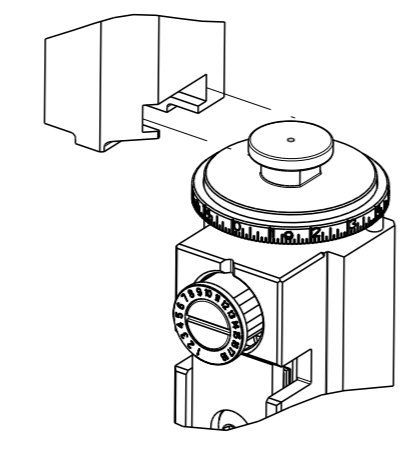


| PART NUMBER | REVISION | DESCRIPTION | FEED TYPE |
|-------------|----------|--|------------|
| 2151424-1 | H | FINE CRIMP HEIGHT ADJUST | MECHANICAL |
| 2151424-2 | H | FINE CRIMP HEIGHT ADJUST | PNEUMATIC |
| 5-2151424-1 | H | SEAL STRIPPER CRIMPER TERMINATING UNIT | MECHANICAL |
| 5-2151424-2 | H | SEAL STRIPPER CRIMPER TERMINATING UNIT | PNEUMATIC |
| 7-2151424-1 | H | MECHANICAL AND CRIMP TOOLING KIT | MECHANICAL |
| 7-2151424-2 | H | PNEUMATIC AND CRIMP TOOLING KIT | PNEUMATIC |
| 7-2151424-7 | B | CRIMP TOOLING KIT | - |

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



| APPLICATOR DATA | | |
|-----------------|----------------|------|
| CRIMP | SIZE | TYPE |
| WIRE | 2.03 mm [.080] | F |
| INSUL | 3.43 mm [.135] | O |

APPLICATOR INSTRUCTIONS 408-35042

| TERMINAL DATA: TE TERMINAL | | TE CRIMP SPECIFICATION | |
|--|------------------------------|------------------------|----------|
| TERMINAL NAME: AMP MCP 1.5 SINGLE-WIRE_SEALING | | | |
| WIRE STRIP LENGTH | INSULATION DIAMETER RANGE | | |
| 3.70-4.30 mm [.146-.169 IN] | Ø2.20-2.40 mm [.087-.094 IN] | | |
| TERMINAL APPLICATION SPECIFICATION | 114-18386 | | |
| TERMINALS APPLIED | | | |
| TE TERMINAL | TE TERMINAL | TE SEAL | TE SEAL |
| 1418884-1 | 1418884-3 | 964972-1 | 964972-1 |

| TERMINAL DATA: TE TERMINAL | | TE CRIMP SPECIFICATION | |
|--|------------------------------------|------------------------|----------|
| TERMINAL NAME: AMP MCP 1.5 SINGLE-WIRE_SEALING | | | |
| WIRE STRIP LENGTH | TERMINAL INSULATION DIAMETER RANGE | | |
| 3.70-4.30 mm [.146-.169 IN] | Ø1.90-2.40 mm [.075-.094 IN] | | |
| TERMINAL APPLICATION SPECIFICATION | 114-18386 | | |
| TERMINALS APPLIED | | | |
| TE TERMINAL | TE TERMINAL | TE SEAL | TE SEAL |
| 1718558-1 | | 964972-1 | 964972-1 |

| WIRE SIZE | CRIMP HEIGHT mm [INCH] | CRIMP HEIGHT REFERENCE SETTING |
|-----------|----------------------------|--------------------------------|
| 1.50mm2 | 1.44+/-0.05 [.057+/-0.002] | 9.9 |
| 16 AWG | 1.34+/-0.05 [.053+/-0.002] | 11.0 |

- RECOMMENDED SPARE PARTS
- REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION & STORAGE OF APPLICATOR.
- APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 180. 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.
- UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- 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.

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

| LOC | DIST | REVISIONS | | | | | |
|-----|------|-----------|-----|---------------|-----------|-----|------|
| A | 66 | P | LY# | DESCRIPTION | DATE | OWN | APVD |
| | | E | | ECR-18-017847 | 13NOV2018 | RK | CT |
| | | F | | ECR-19-002011 | 06FEB2019 | LG | GB |
| | | G | | ECR-20-014401 | 12OCT2020 | FZ | TE |
| | | H | | ECR-20-015680 | 04NOV2020 | JAH | RK |

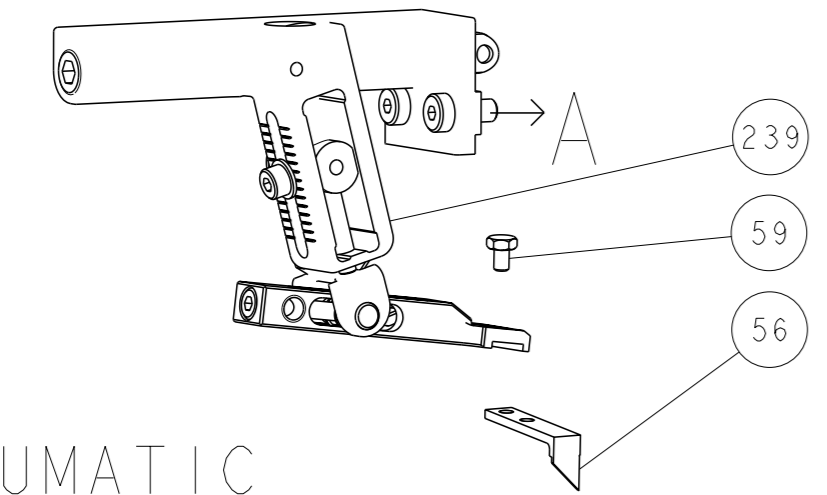
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|---|-----|-----|-----|-----|-----|-----|-------------|-------------------------------------|-----|
| - | - | - | 1 | 1 | - | - | 1803515-3 | RAM ASSEMBLY, SF ATLANTIC | 293 |
| - | - | - | 1 | 1 | - | - | 2-1803583-1 | APPLICATOR BASIC ASSEMBLY, SF | 292 |
| - | 1 | - | 1 | - | 1 | - | 2119641-1 | FEED CAM, AIR FEED | 248 |
| - | 1 | 1 | 1 | 1 | 1 | 1 | 2119082-8 | 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 | - | - | 1-1752354-8 | STANDOFF,HOLD-DOWN | 180 |
| - | - | - | 1 | 1 | - | - | 993111-1 | 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 | 1-18028-2 | WASHER, FLAT, REG M4 | 119 |
| - | 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 | 455888-5 | SPACER, CRIMPER | 82 |
| - | 1 | 1 | 1 | 1 | 1 | 1 | 1803607-3 | DOCUMENTATION PACKAGE | 71 |
| - | 1 | 1 | 1 | 1 | 1 | 1 | 2119791-5 | DEPRESSOR, WIRE | 70 |
| - | 1 | 1 | 1 | 1 | 1 | 1 | 2119943-1 | WASHER, SPACER | 69 |
| - | 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 | 985575-3 | SCR, FLT SKT HD CAP M3 X 10.0 | 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 | 2168083-3 | SCR, SKT HD CAP, RoHS, M4 X 12.0 | 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 | 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 | 2-2844962-6 | SPACER, CYLINDRICAL, STRIP GUIDE | 30 |
| - | 1 | 1 | 1 | 1 | 1 | 1 | 2844992-2 | ASSEMBLY, STRIP GUIDE | 29 |
| - | 1 | 1 | 1 | 1 | 1 | 1 | 1-455888-0 | 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 | 318707-1 | FLOATING SHEAR, FRONT | 9 |
| 1 | 2 | 2 | 1 | 1 | 1 | 1 | 8-1333204-8 | ANVIL, COMBINATION | 8 |
| - | 1 | 1 | 1 | 1 | 1 | 1 | 5-240641-9 | SPACER | 7 |
| - | - | - | - | - | - | - | - | - | 6 |
| - | 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 | 4-1722335-9 | CRIMPER, INSULATION O | 3 |
| - | 1 | 1 | 1 | 1 | 1 | 1 | 455888-3 | SPACER, CRIMPER | 2 |
| 1 | 2 | 2 | 1 | 1 | 1 | 1 | 1-456405-6 | CRIMPER, WIRE PREMIUM | 1 |

| ITEM NO | PART NO | DESCRIPTION | ITEM NO |
|---------|---------|-------------|---------|
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| -51 | -2 | -1 | |

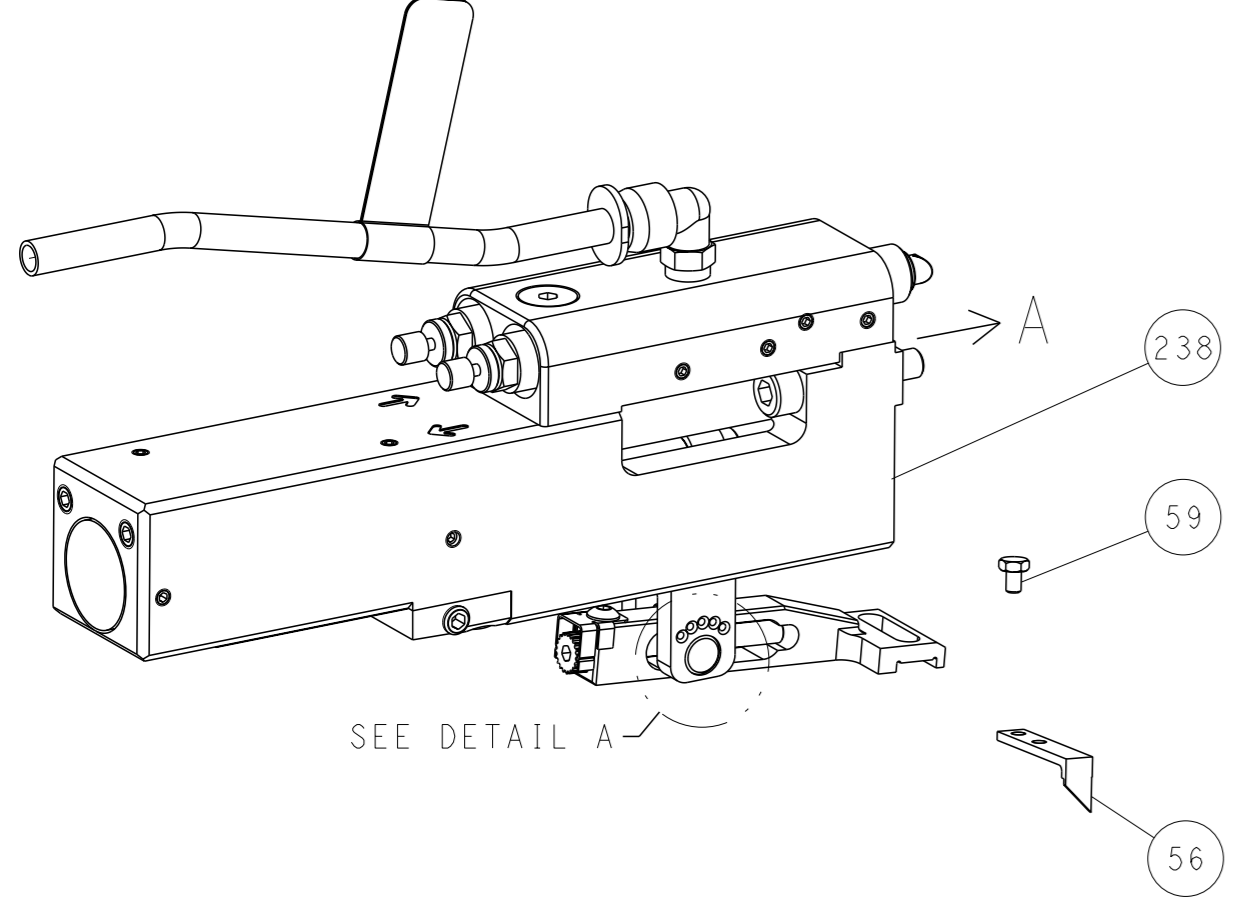
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| CHK | L. ZHANG | 06DEC2011 |
| APVD | S. XI | 06DEC2011 |
| PRODUCT SPEC | | |
| APPLICATION SPEC | | |
| SIZE | CAGE CODE | DRAWING NO |
| A1 | 00779 | 2151424 |
| CUSTOMER ACCESSIBLE PRODUCTION DRAWING | SCALE | 1:2 |
| SHEET | 1 | OF 4 |
| REV | H | |

| LOC | DIST | REVISIONS | | | |
|-----|------|-------------|------|-----|------|
| A | 66 | REV | DATE | OWN | APVD |
| - | - | SEE SHEET 1 | - | - | - |

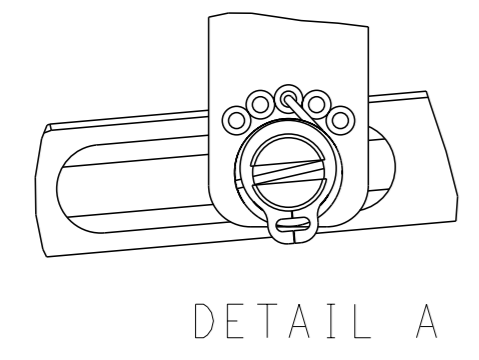
FEED TYPE MECHANICAL



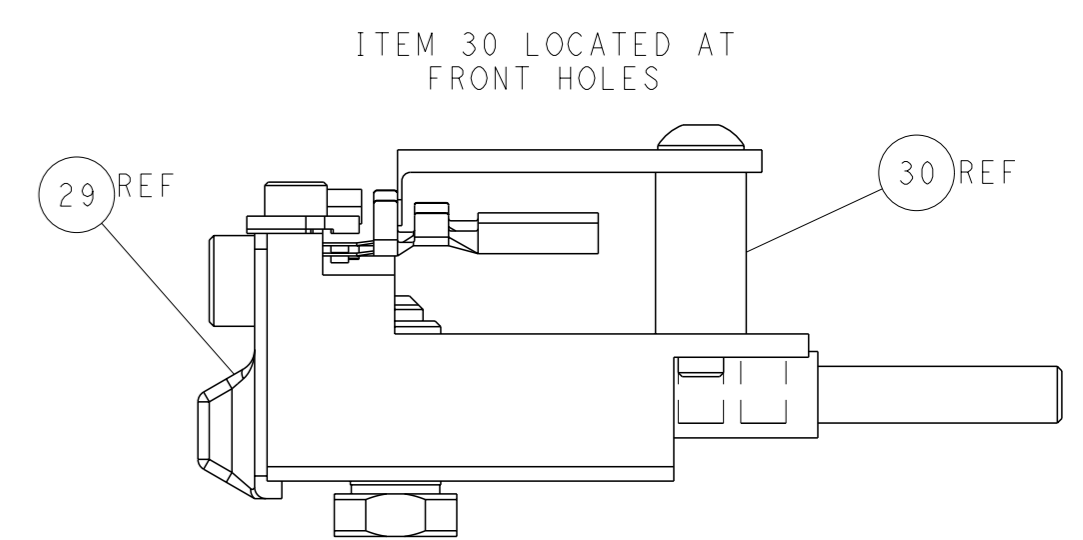
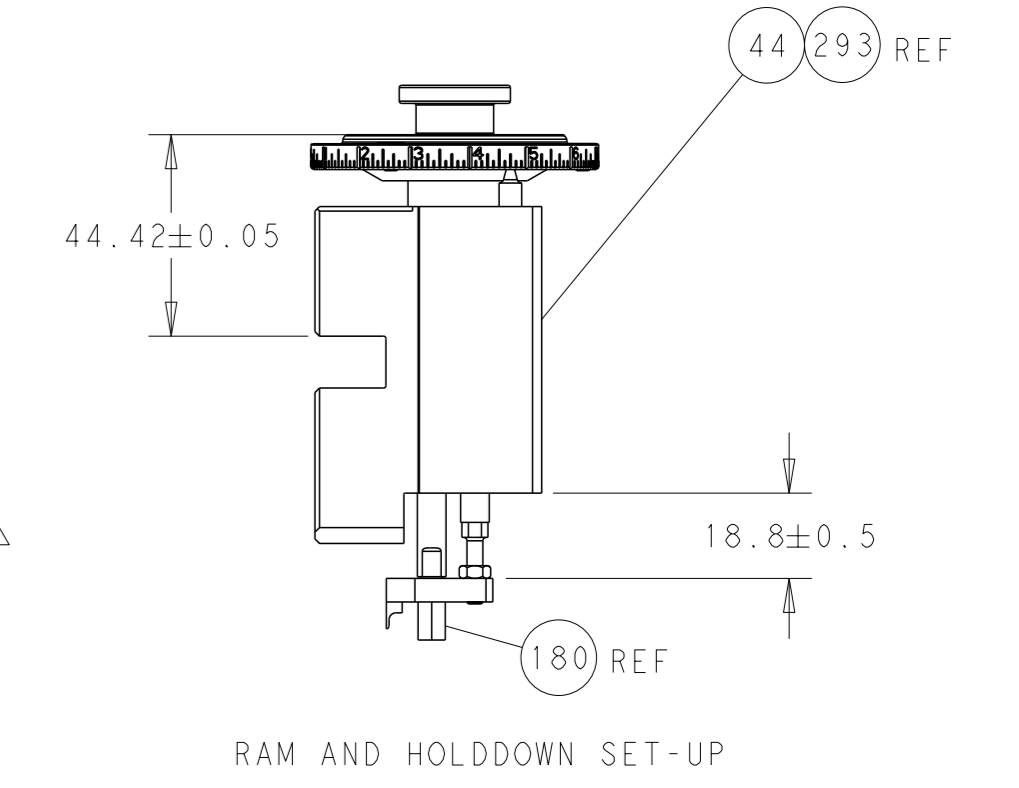
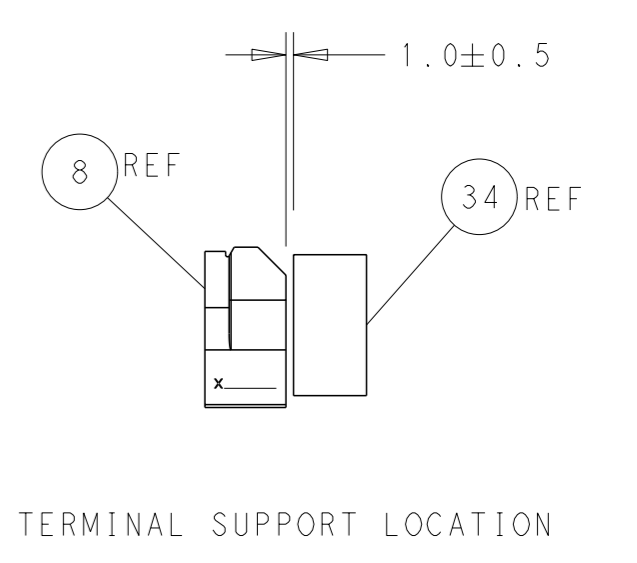
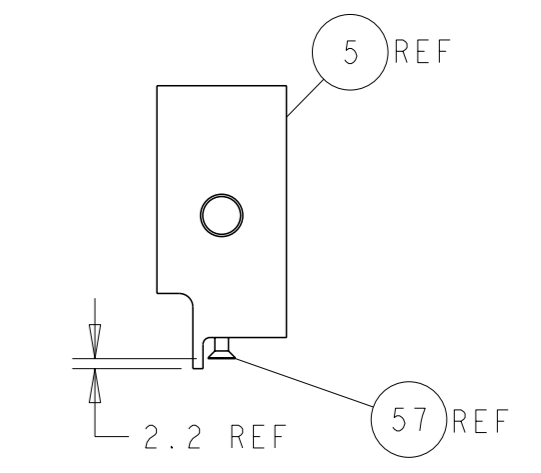
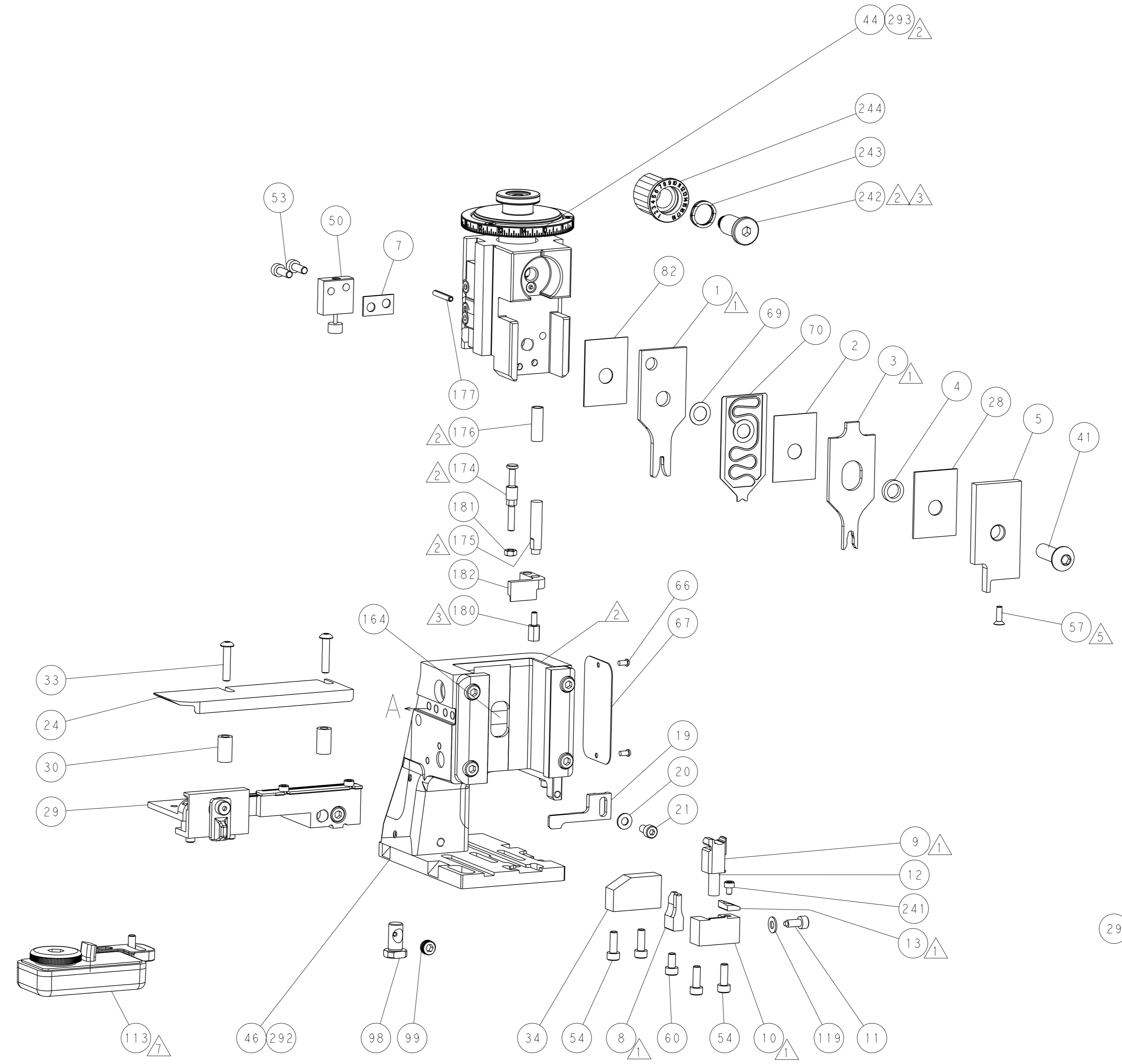
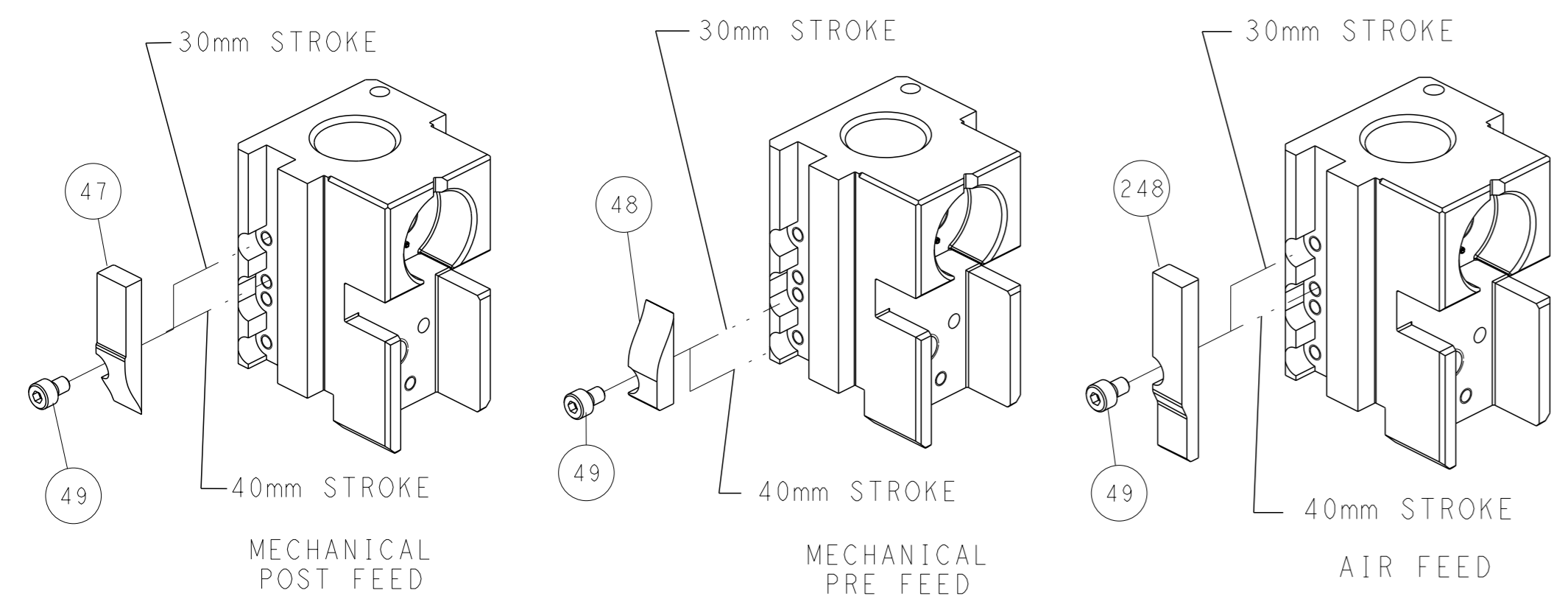
PNEUMATIC



FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



CAM POSITIONS

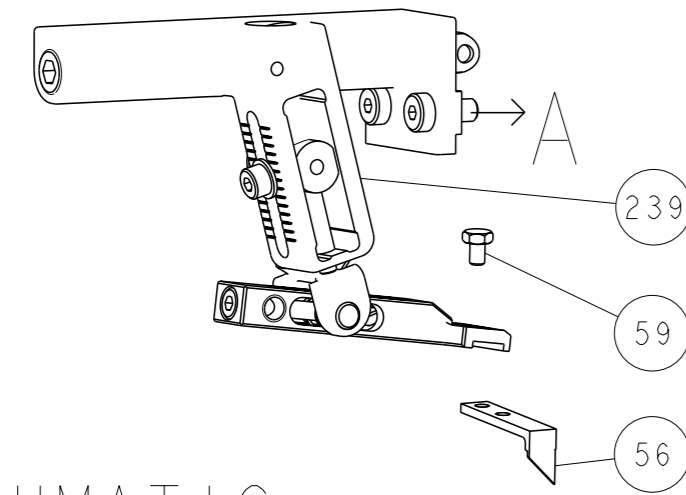


ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

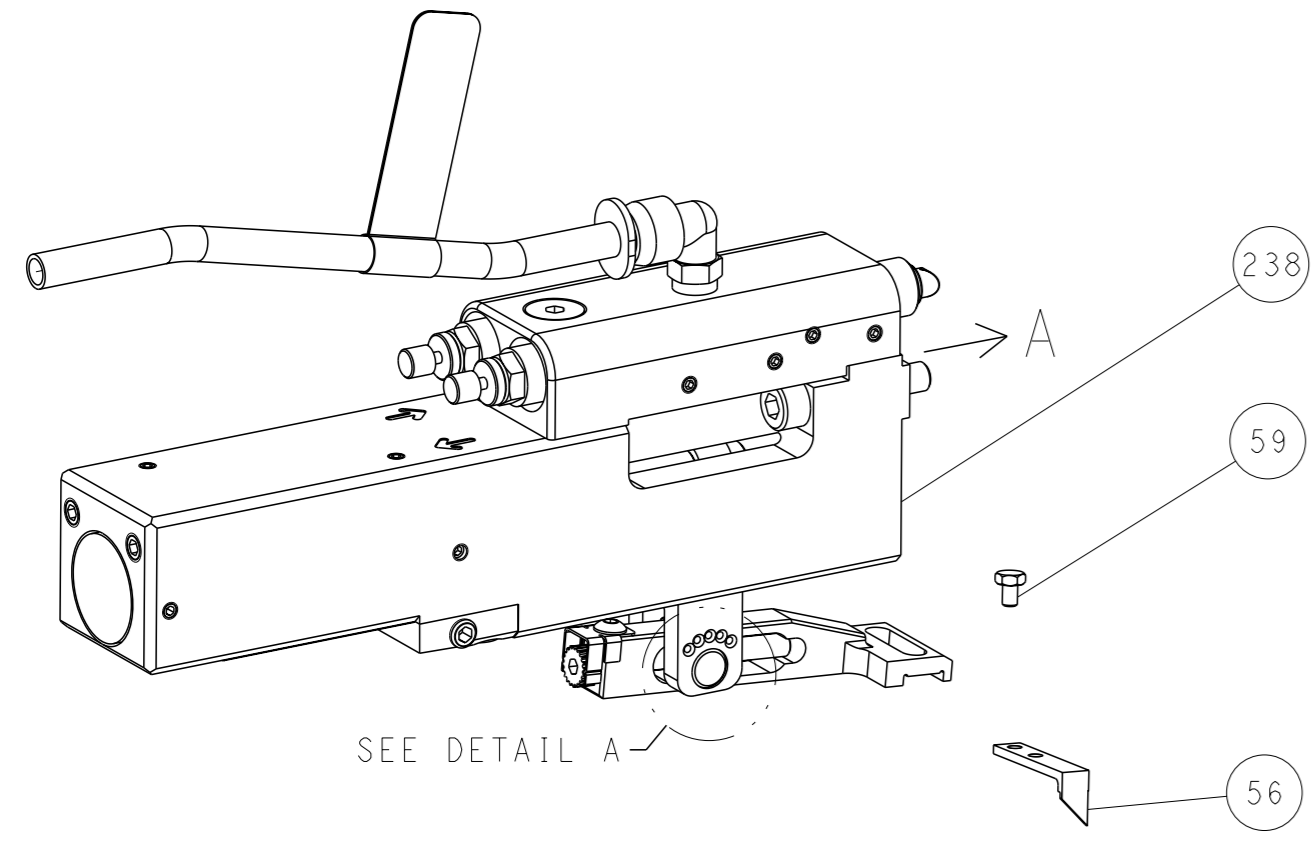
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| DIMENSIONS: mm | | TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH | | DWN L. ZHANG 06DEC2011 CHK L. ZHANG 06DEC2011 APVD L. ZHANG 06DEC2011 PRODUCT SPEC APPLICATION SPEC WEIGHT CUSTOMER ACCESSIBLE PRODUCTION DRAWING | | NAME Ocean Side Feed Applicator SIZE A1 CAGE CODE 00779 DRAWING NO. ©=2151424 SCALE 1:2 SHEET 2 of 4 REV H | | TE Connectivity Harrisburg, PA 17105-3608 RESTRICTED TO | |
|-----------------------|--|---|--|---|--|--|--|---|--|

| LOC | DIST | REVISIONS | | | |
|-----|------|-----------|-------------|-----|------|
| A | 66 | REV | DATE | OWN | APVD |
| | | - | SEE SHEET 1 | - | - |

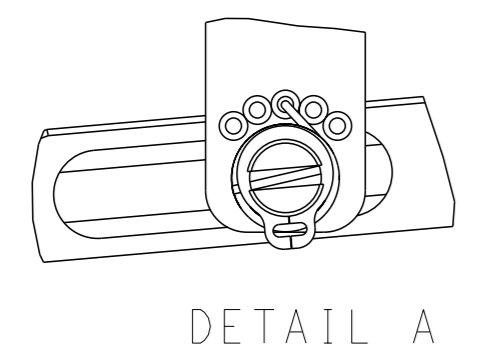
FEED TYPE MECHANICAL



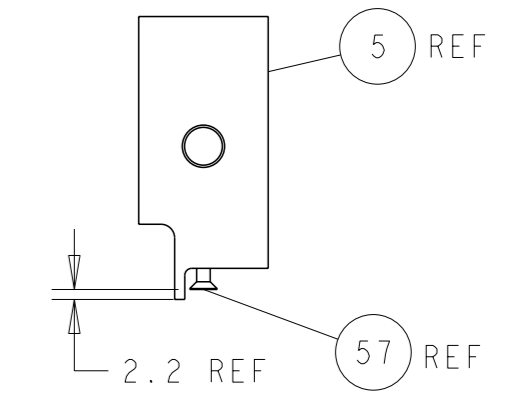
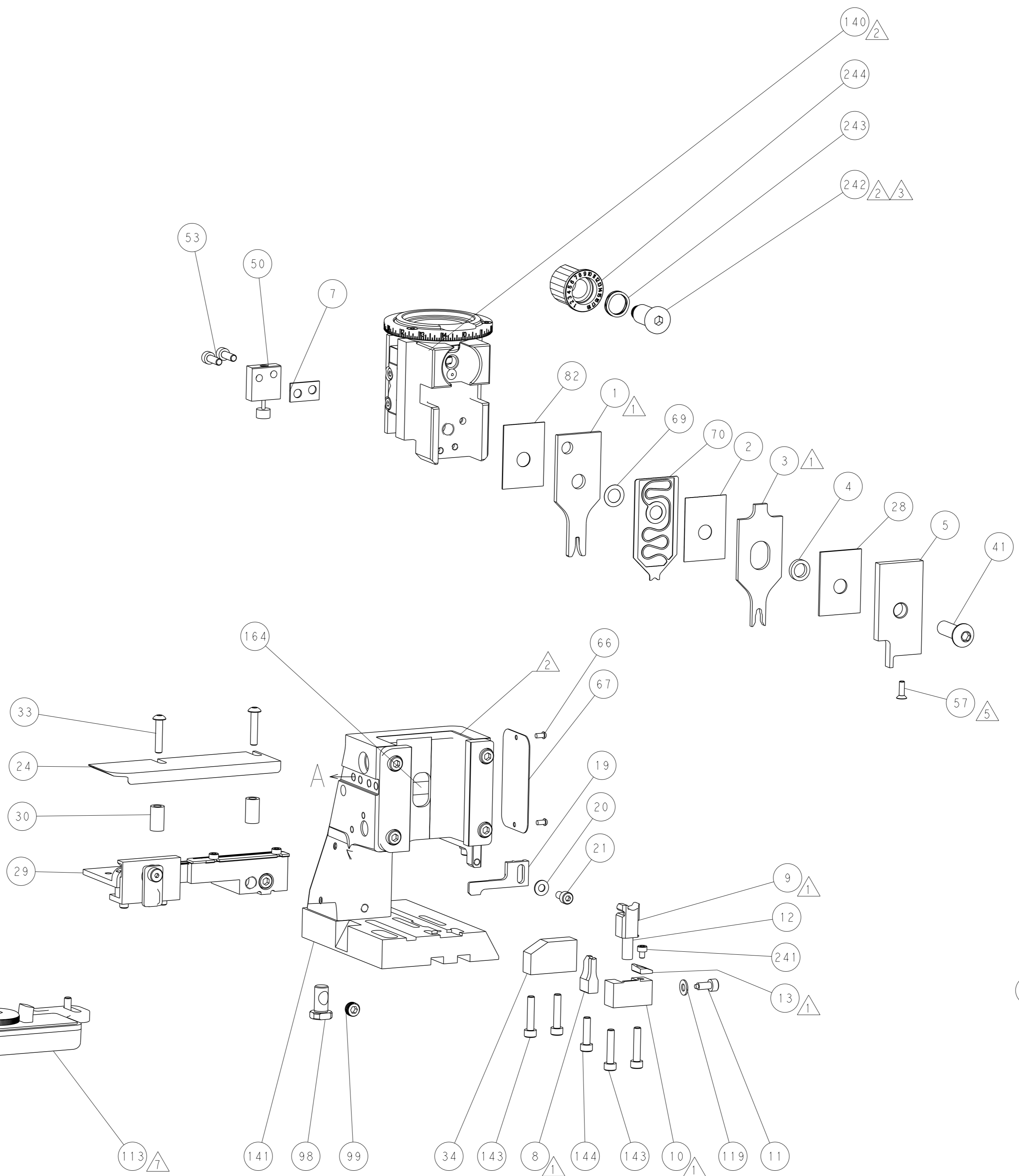
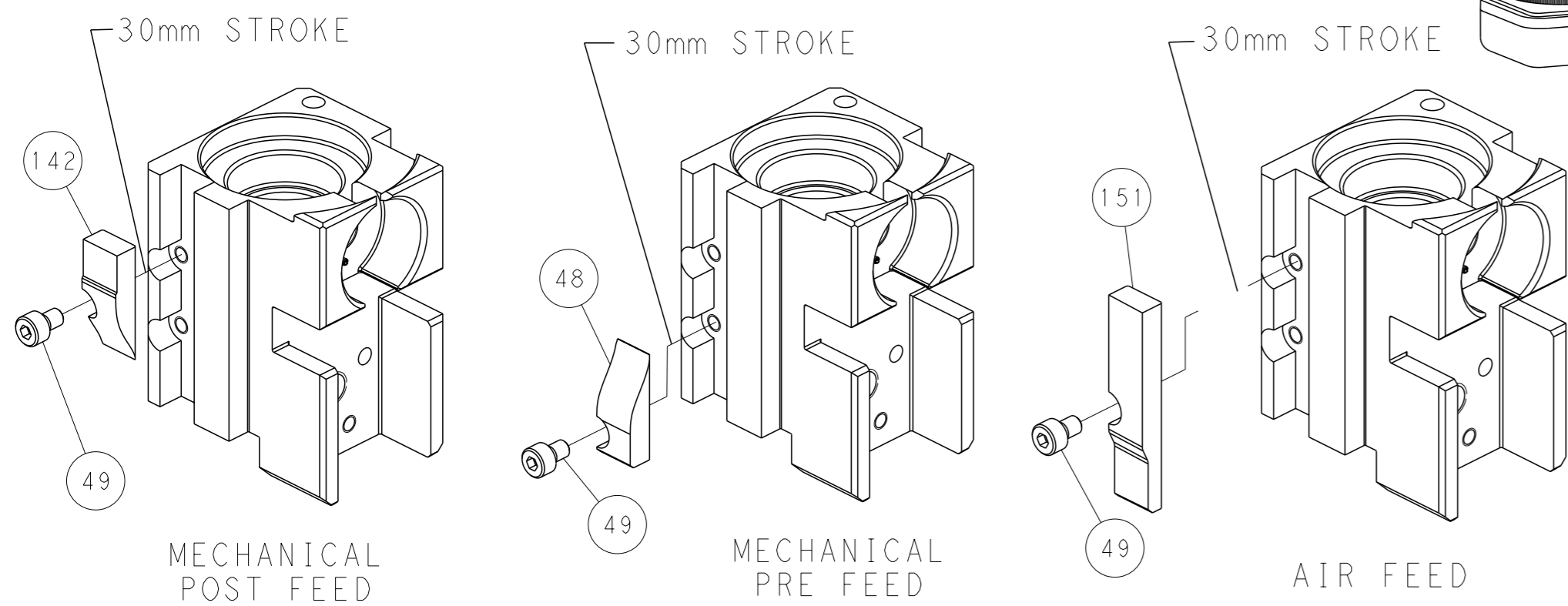
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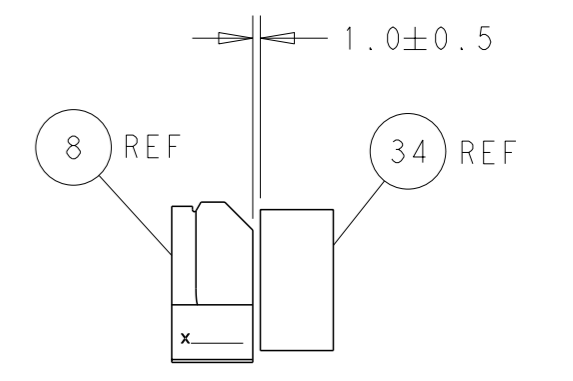
FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



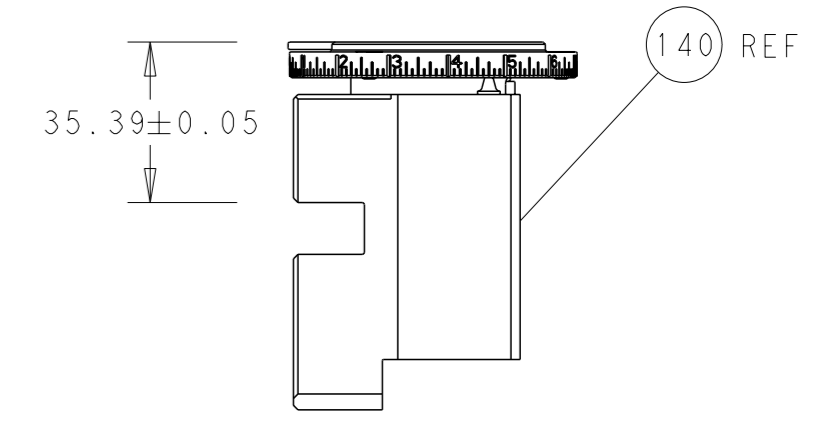
CAM POSITIONS



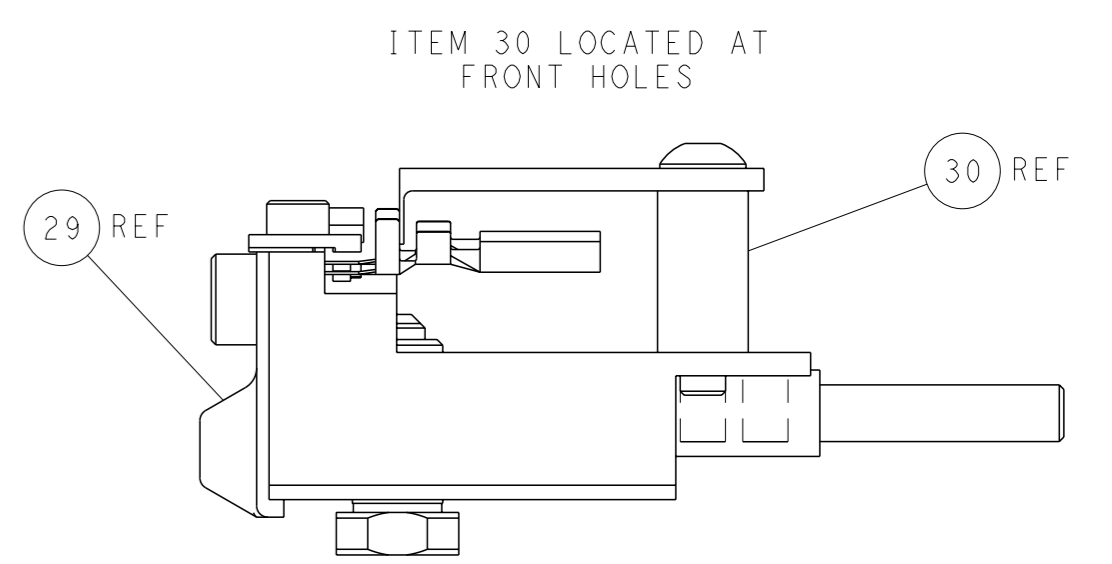
SHEAR DEPRESSOR DETAIL



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 A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE AND THE CONTROLLING ENGINEERING ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST REVISION.</small> | | DWN L. ZHANG 06DEC2011 CHK L. ZHANG 06DEC2011 APVD S. XI 06DEC2011 | 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 Applicator APPLICATION SPEC SIZE CAGE CODE DRAWING NO. A1 00779 C=2151424 WEIGHT CUSTOMER ACCESSIBLE PRODUCTION DRAWING | RESTRICTED TO SCALE 1:2 SHEET 4 OF 4 REV H |