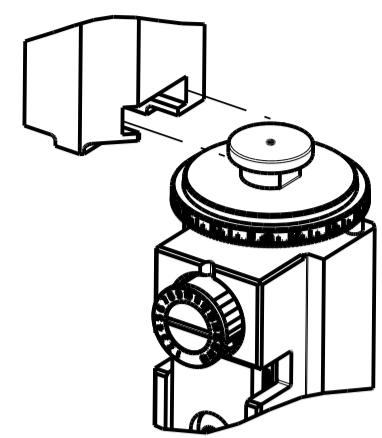


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151353-1	J	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2151353-2	K	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151353-1	J	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2151353-2	K	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2151353-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.78 mm [.070]	F
INSUL	2.29 mm [.090]	BX

APPLICATOR INSTRUCTIONS 408-35042

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: MCON 1.2 LL			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
3.30-3.90 mm [.130-.154 IN]		Ø1.90-2.40 mm [.075-.094 IN]	
TERMINAL APPLICATION SPECIFICATION	114-18464		
TERMINALS APPLIED <sup>5</sup>			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
1452659-1	1452659-2	1452659-3	
7-1452659-1	7-1452659-2	7-1452659-3	

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.50mm2	1.31+/-0.05 [.052+/- .002]	8.0
16 AWG	1.26+/-0.05 [.050+/- .002]	8.5
1.00mm2	1.10+/-0.05 [.043+/- .002]	10.0
18 AWG	1.05+/-0.05 [.041+/- .002]	10.6

- <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 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.
- 6. 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
		H	18APR2017	TB	TE
		J	20APR2018	MEH	JDG
		K	10APR2019	FJ	TE
		K1	17MAY2021	AJ	YY

-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248	
-	1	1	1	1	2119082-4	CAM, SNAIL, INSULATION ADJUSTMENT	244	
-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243	
-	1	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	-	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	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	455888-5	SPACER, CRIMPER	82	
-	1	1	1	1	22278-8	SPRING, COMPRESSION	77	
-	1	1	1	1	854769-4	HOLDER, INS	74	
-	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	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59	
-	1	1	1	1	21028-2	PIN, SLOTTED SPRING .062 X .250	58	
-	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	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	53	
-	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	1752356-6	SUPPORT, TERMINAL	34	
-	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33	
-	2	2	2	2	2-2844962-6	SPACER, CYLINDRICAL, STRIP GUIDE	30	
-	1	1	1	1	2844992-2	ASSEMBLY, STRIP GUIDE	29	
-	1	1	1	1	455888-4	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	
-	4	4	4	4	1-18028-2	WASHER, FLAT, REG M4	20	
-	1	1	1	1	2119533-1	STRIPPER, SIDE FEED	19	
-	1	1	1	1	1333264-1	HOLD DOWN	18	
-	1	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	1	2119805-1	SHEAR HOLDER, FRONT	10	
-	1	1	1	1	1633861-1	SHEAR, FLOATING	9	
-	1	2	2	1	4-1333203-2	ANVIL, COMBINATION	8	
-	-	-	-	-	-	-	7	
-	-	-	-	-	-	-	6	
-	1	1	1	1	1-2119780-1	DEPRESSOR, SHEAR	5	
-	1	1	1	1	4-238011-1	BLOCK, CRIMPER SPACER	4	
-	1	2	2	1	1633989-8	CRIMPER, INSULATION, SPECIAL	3	
-	1	2	2	1	1633169-2	CRIMPER, WIRE, SPECIAL	1	
-	77	72	71	2	1	PART NO	DESCRIPTION	ITEM NO

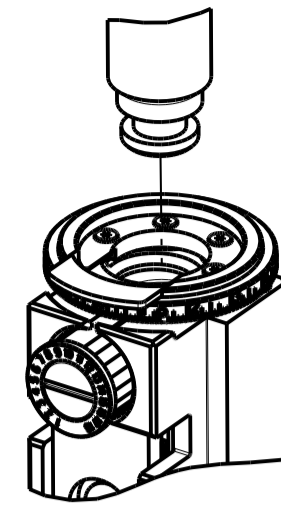
ATLANTIC VERSION  
 Shown on sheets 1 of 4 & 2 of 4  
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DRAWN: L. ZHANG 26 JUL 2012		CHK: L. ZHANG 26 JUL 2012		APV: S. XI 26 JUL 2012		NAME: Ocean Side Feed Applicator	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES	FINISH	WEIGHT	SCALE: 1:2	SHEET 1 OF 4	REV: K1
MATERIAL:		FINISH:		CAGE CODE: 00779		DRAWING NO: 2151353		RESTRICTED TO:		Customer Accessible Production Drawing	



PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2151353-1	J	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2151353-2	K	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151353-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR  
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.78 mm [.070]	F
INSUL	2.29 mm [.090]	BX

APPLICATOR INSTRUCTIONS  
408-35042

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: MCON 1.2 LL			
WIRE STRIP LENGTH 3.30-3.90 mm [1.30-.154 IN]		INSULATION DIAMETER RANGE Ø1.90-2.40 mm [.075-.094 IN]	
TERMINAL APPLICATION SPECIFICATION 114-18464			
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
1452659-1	1452659-2	1452659-3	
7-1452659-1	7-1452659-2	7-1452659-3	

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.50mm2	1.31+/-0.05 [1.052+/-0.002]	8.0
16 AWG	1.26+/-0.05 [1.050+/-0.002]	8.5
1.00mm2	1.10+/-0.05 [1.043+/-0.002]	10.0
18 AWG	1.05+/-0.05 [1.041+/-0.002]	10.6

- 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 TERMINAL LUBRICANT IS RECOMMENDED.
- 6. 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.

ENTRY LEVEL APPLICATOR		ITEM SUBSTITUTION LIST		
PART NUMBER	SAME AS	ITEM	ITEM DESCRIPTION	SUBSTITUTE PART NUMBER
8-2151353-1	2151353-1	1	WIRE CRIMPER	1803661-2
8-2151353-2	2151353-2	3	INSULATION CRIMPER	1803623-8
9-2151353-1	2-2151353-1	46	BASIC SUB -ASSEMBLY	1803940-9
9-2151353-2	2-2151353-2	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)

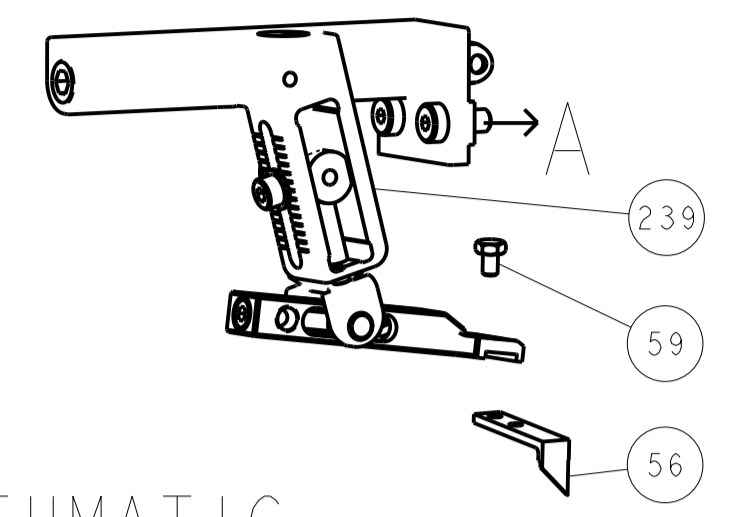
LOC	DIST	REV	DATE	BY	APPV
A	66				

REVISIONS					
REV	DATE	BY	DESCRIPTION	DATE	APPV
-	-	-	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
5	-	1	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113
-	1	1	2844908-1	SCREW, LOCKING	99
-	1	1	2844907-1	POST, LOCKING	98
-	1	1	455888-5	SPACER, CRIMPER	82
-	1	1	22278-8	SPRING, COMPRESSION	77
-	1	1	854769-4	HOLDER, INS	74
-	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
-	1	1	21028-2	PIN, SLOTTED SPRING .062 X .250	58
-	1	1	1338685-1	PAWL, FEED	56
-	2	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	53
-	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	1752356-6	SUPPORT, TERMINAL	34
-	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	2-2844962-6	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	2844992-2	ASSEMBLY, STRIP GUIDE	29
-	1	1	455888-4	SPACER, CRIMPER	28
-	1	1	1320928-2	STRIP GUIDE	24
-	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
-	4	4	1-18028-2	WASHER, FLAT, REG M4	20
-	1	1	2119533-1	STRIPPER, SIDE FEED	19
-	1	1	133264-1	HOLD DOWN	18
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	1633861-1	SHEAR, FLOATING	9
1	1	1	4-1333203-2	ANVIL, COMBINATION	8
-	-	-	-	-	7
-	-	-	-	-	6
-	1	1	1-2119780-1	DEPRESSOR, SHEAR	5
-	1	1	4-238011-1	BLOCK, CRIMPER SPACER	4
1	1	1	1633989-8	CRIMPER, INSULATION, SPECIAL	3
1	1	1	1633169-2	CRIMPER, WIRE, SPECIAL	1
-77	-22	-21	PART NO	DESCRIPTION	ITEM NO

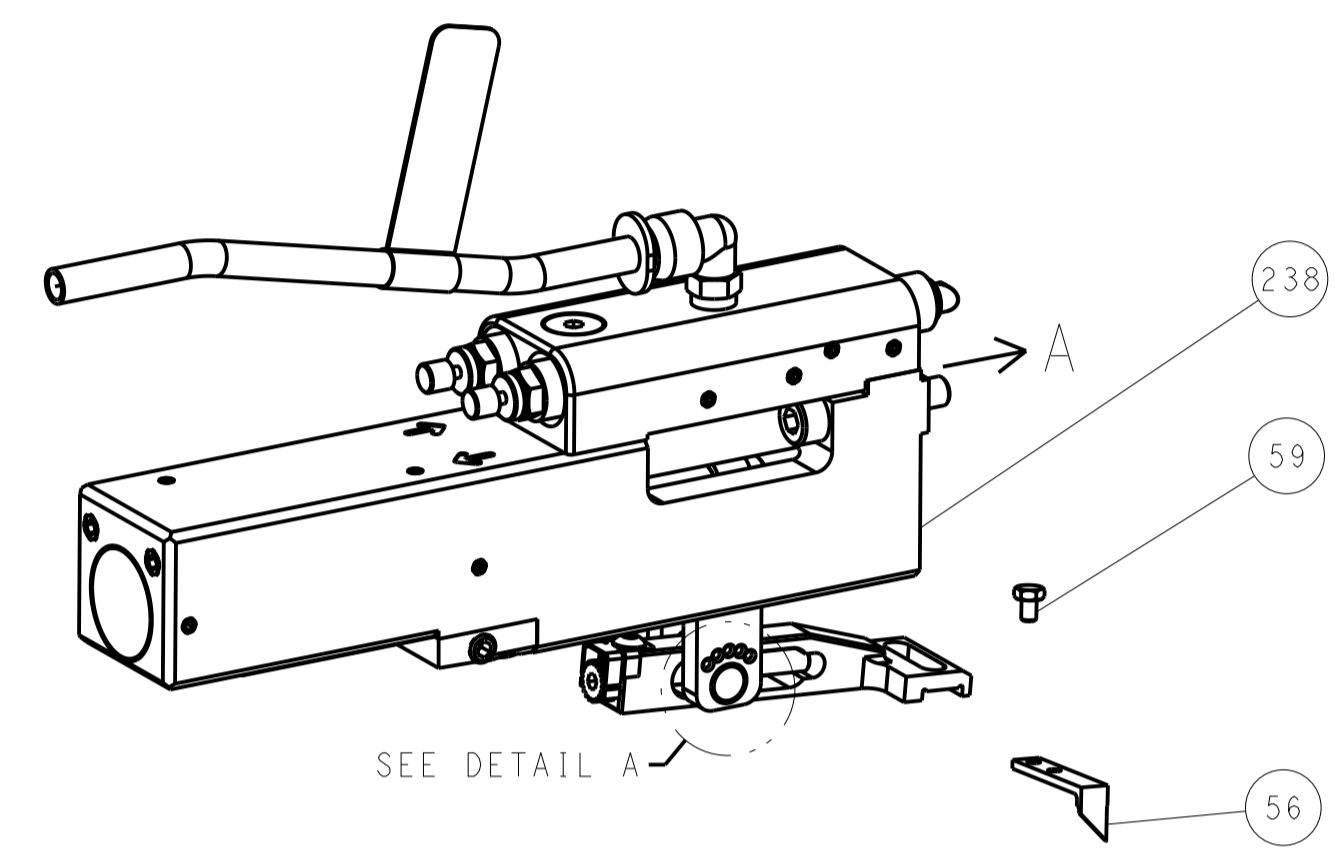
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		DRAWN: L. ZHANG 26 JUL 2012 CHK: L. ZHANG 26 JUL 2012 APPV: S. XI 26 JUL 2012		NAME: Ocean Side Feed Applicator	
MATERIAL: -		FINISH: -		WEIGHT: -		SCALE: 1:2	
Customer Accessible Production Drawing				SHEET 3 OF 4		REV: K1	

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

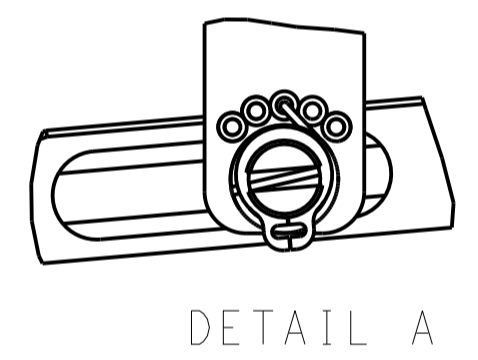
# FEED TYPE MECHANICAL



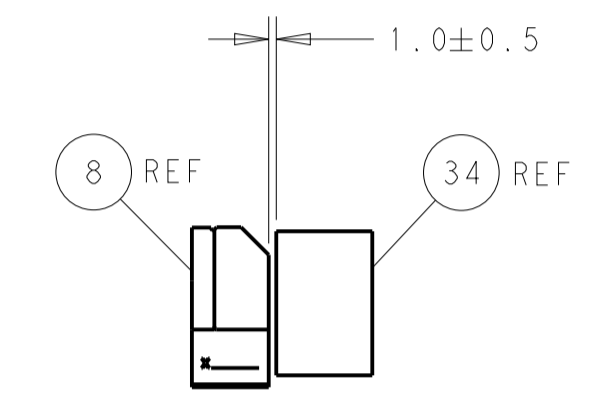
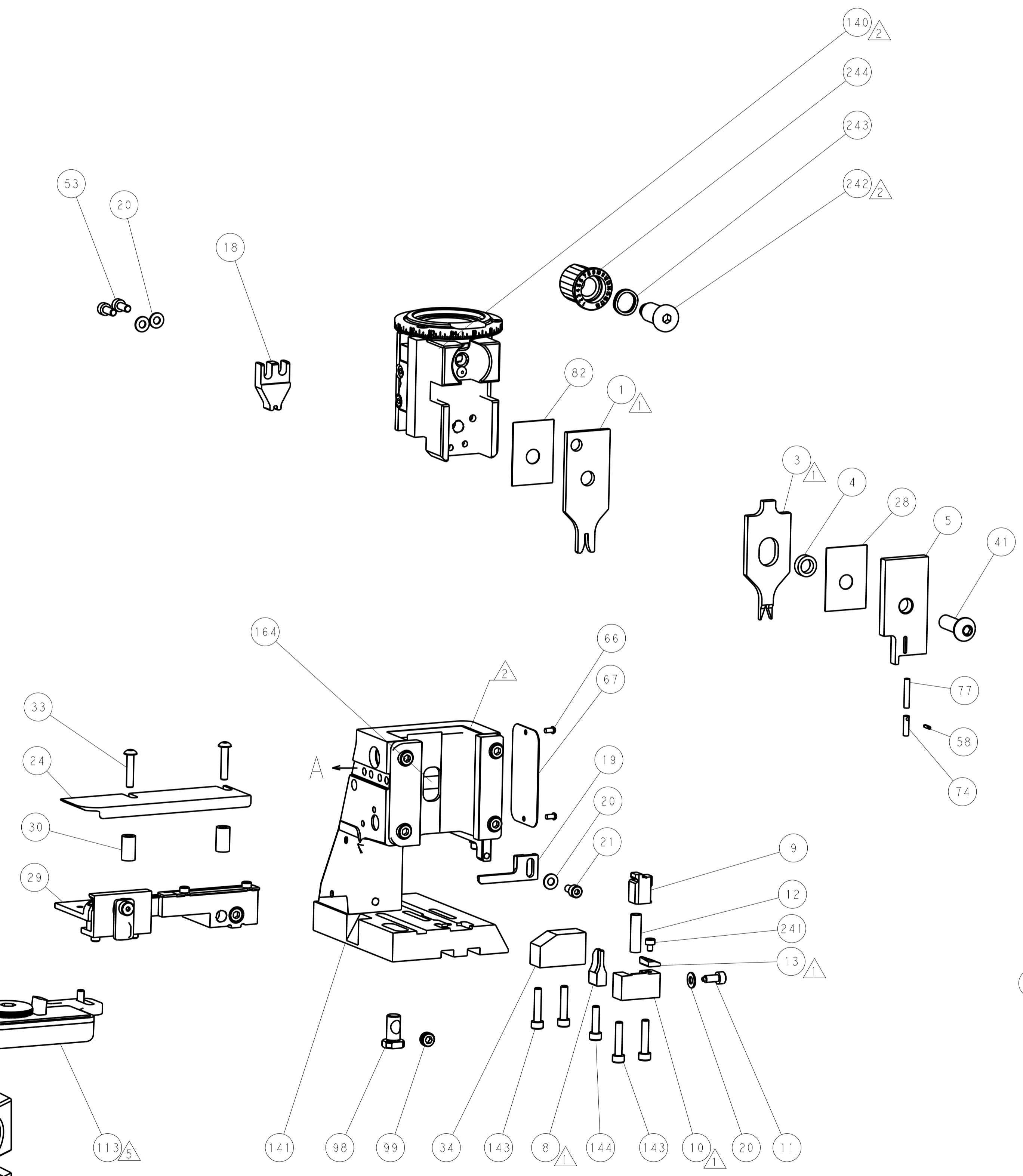
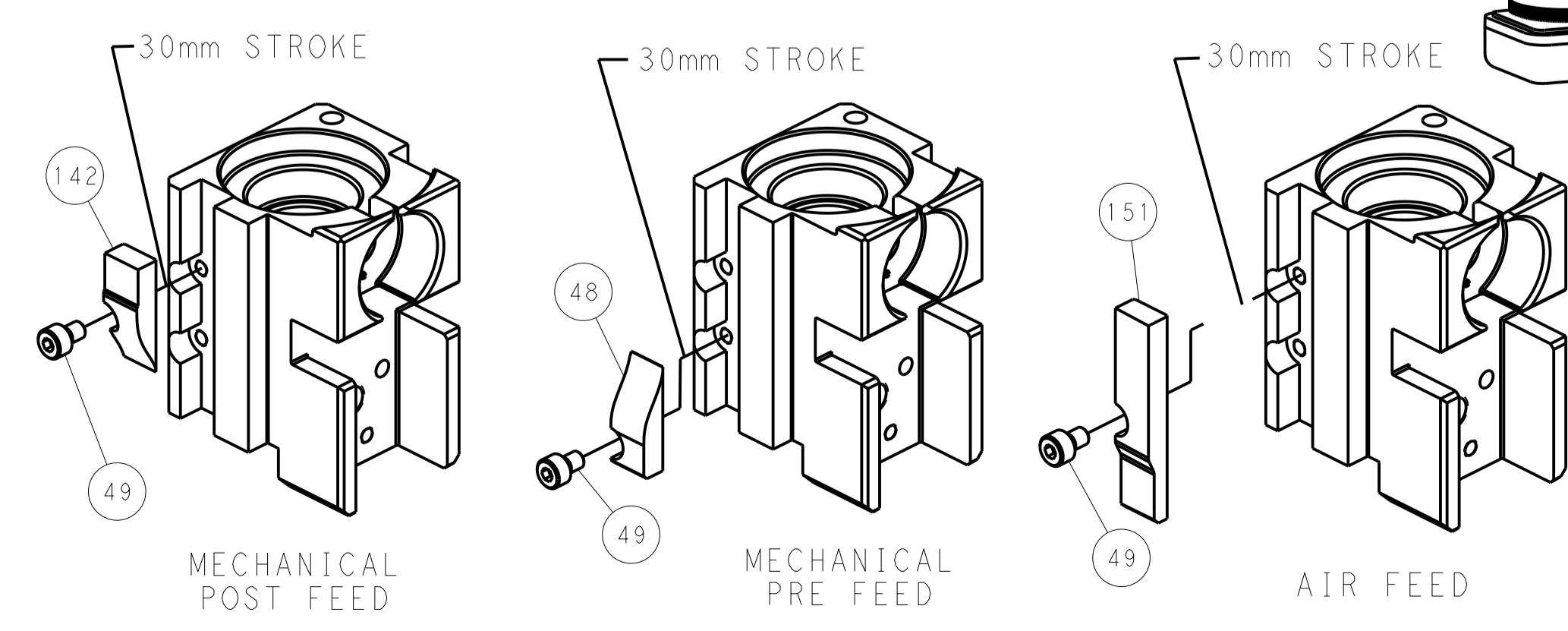
## PNEUMATIC



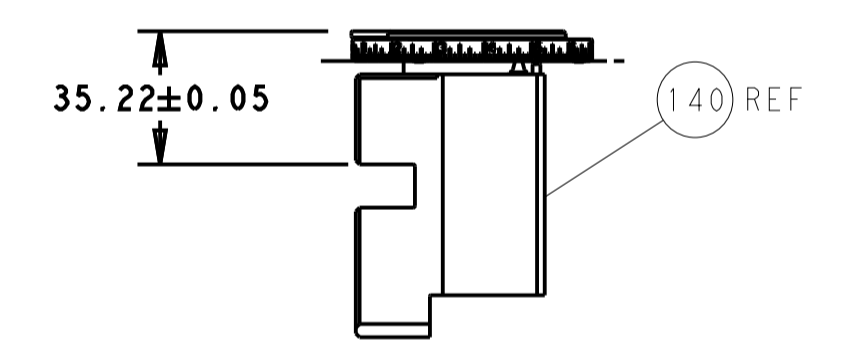
## FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



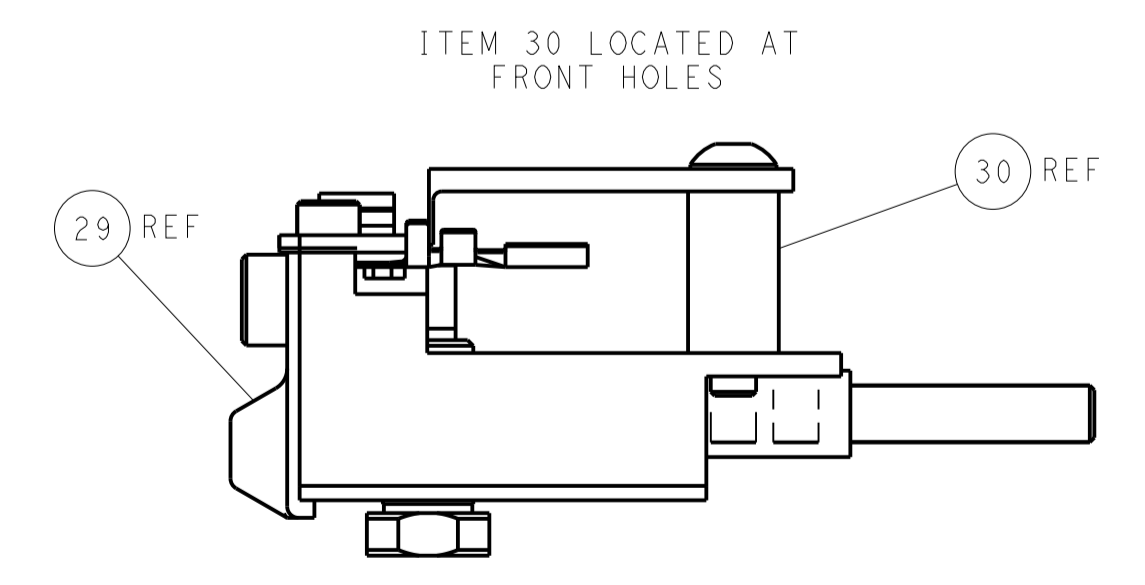
# CAM POSITIONS



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>THE INFORMATION CONTAINED HEREON IS UNCLASSIFIED UNLESS INDICATED OTHERWISE. IT IS SUBJECT TO CHANGE AND WITHOUT WARRANTY OF ACCURACY. THE INFORMATION CONTAINED HEREON IS THE PROPERTY OF TYCO ELECTRONICS CORPORATION AND IS NOT TO BE DISCLOSED TO ANY OTHER ORGANIZATION WITHOUT THE WRITTEN PERMISSION OF TYCO ELECTRONICS CORPORATION.</small>		DWN: L. ZHANG 26 JUL 2012 CHK: L. ZHANG 26 JUL 2012 APVD: S. XI 26 JUL 2012	NAME: Ocean Side Feed Applier SIZE: 1:2 SCALE: 1:2
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±	PRODUCT SPEC: APPLICATION SPEC: WEIGHT: MATERIAL:	PRODUCT SPEC: APPLICATION SPEC: WEIGHT: MATERIAL:	RESTRICTED TO: CUSTOMER ACCESSIBLE PRODUCTION DRAWING SHEET 4 OF 4 REV K1