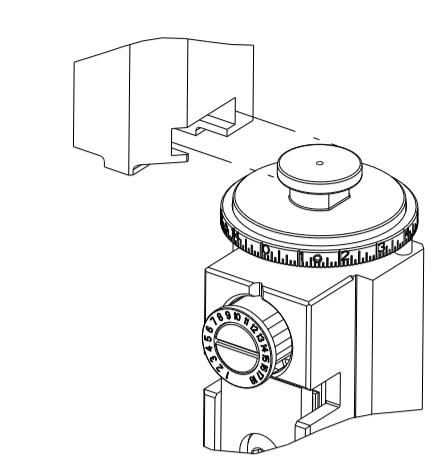


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151634-1	J	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2151634-2	J	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151634-1	J	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2151634-2	J	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2151634-7	D	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	3.05 mm [.120]	F
INSUL	4.06 mm [.160]	OV

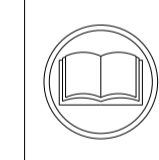
APPLICATOR INSTRUCTIONS
408-35042

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: AMP MCP 2.8K FLAT TYPE RECEPTACLE			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
5.30-5.90 mm [.209-.232 IN]		Ø3.40-3.70 mm [.134-.146 IN]	
TERMINAL APPLICATION SPECIFICATION	114-18051		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
(A) 2-2141600-2	(A) 1-968946-1	1-968946-2	(A) 2-968946-1
(A) 2-968946-2	(A) 3-968946-1		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: AMP MCP 2.8K FLAT TYPE RECEPTACLE			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
5.30-5.90 mm [.209-.232 IN]		Ø2.70-3.70 mm [.106-.146 IN]	
TERMINAL APPLICATION SPECIFICATION	(B)114-18148		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
(B) 1-968853-1	(B) 1-968853-3	(B) 1-1355880-1	

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
4.00mm2	2.15+/-0.05 [.085+/- .002]	5.9

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
4.00mm2	2.10+/-0.05 [.083+/- .002]	5.9
3.00mm2 JASO	1.92+/-0.05 [.076+/- .002]	7.7
12 AWG	1.90+/-0.05 [.075+/- .002]	7.9



- RECOMMENDED SPARE PARTS
 - REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION & 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.
 - 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.

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	LTN	DESCRIPTION	DATE	OWN	APVD
		J		ECR-21-006205	11JUN2021	FZ	RK
		J1		ECR-22-147641	28JUL2022	FJ	YY
		J2		ECR-22-149474	16AUG2022	FJ	JAH
		J3		ECR-22-158220	14NOV2022	FZ	GB

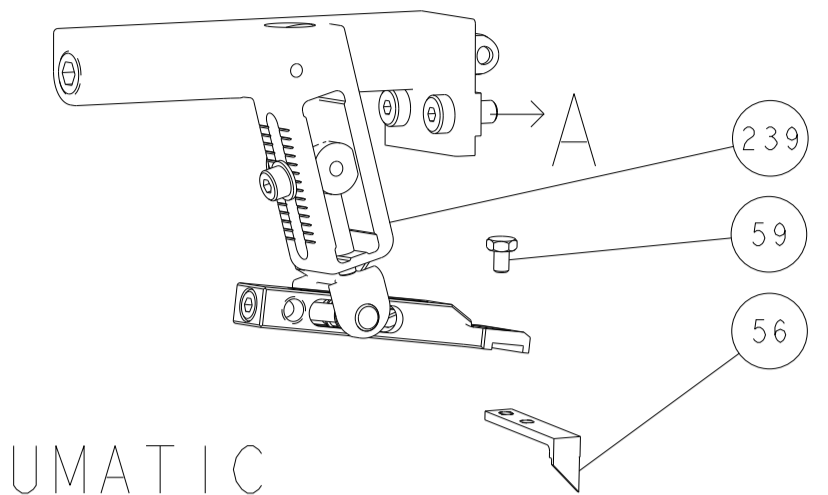
-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248	
-	1	1	1	1	2119082-8	CAM, SNAIL, INSULATION ADJUSTMENT	244	
-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243	
-	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242	
-	1	1	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241	
-	-	1	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239	
-	1	-	1	-	2844940-1	AIR FEED MODULE	238	
-	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164	
-	1	1	1	1	1-22281-8	SPRING, COMPRESSION	121	
-	1	1	1	1	1-18028-2	WASHER, FLAT, REG M4	119	
-	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	2-690438-8	FRONT STRIP GUIDE	96	
-	2	2	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	95	
-	1	1	1	1	2168083-6	SCR, SKT HD CAP, RoHS, M5 X 65	93	
-	1	1	1	1	455888-5	SPACER, CRIMPER	82	
-	2	2	2	2	2079383-4	SCR, BHSC, RoHS (M4 X 8)	79	
-	1	1	1	1	1803096-1	EXTENSION PLATE	78	
-	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	
-	2	2	2	2	2-18032-5	SCR, SET, FLT PNT, M5 X 20.0	61	
-	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	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	1	1	1	1803382-6	HOLD DOWN, SPRING LOADED	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	1752356-4	SUPPORT, TERMINAL	34	
-	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33	
-	2	2	2	2	1-2844962-7	SPACER, CYLINDRICAL, STRIP GUIDE	30	
-	1	1	1	1	1-2844938-8	PLATE, STRIP GUIDE	29	
-	1	1	1	1	1-455888-0	SPACER, CRIMPER	28	
-	2	2	2	2	22283-9	SPRING, COMPRESSION	27	
-	1	1	1	1	356835-1	LEVER, DRAG RELEASE	26	
-	1	1	1	1	240792-1	DRAG, TERMINAL	25	
-	1	1	1	1	1320928-4	STRIP GUIDE	24	
-	1	1	1	1	980371-4	SCR, SKT HD SHLDR 5.0 DIA X 6.0	23	
-	1	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21	
-	1	1	1	1	1-18028-2	WASHER, FLAT, REG M4	20	
-	1	1	1	1	2119533-1	STRIPPER, SIDE FEED	19	
-	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	454276-5	FLOATING SHEAR, FRONT	9	
-	1	2	2	1	1-1333208-8	ANVIL, COMBINATION .120	8	
-	-	-	-	-	-	-	7	
-	-	-	-	-	-	-	6	
-	1	1	1	1	1-2119757-0	DEPRESSOR, SHEAR	5	
-	1	1	1	1	238011-4	BLOCK, CRIMPER SPACER	4	
-	1	2	2	1	1-5-2119785-2	CRIMPER, INSULATION OVERLAP PREMIUM	3	
-	1	1	1	1	1-455888-6	SPACER, CRIMPER	2	
-	1	2	2	1	456409-8	CRIMPER, WIRE .120 "F" PREMIUM	1	
-	77	-72	-71	-2	-1	PART NO	DESCRIPTION	ITEM NO

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

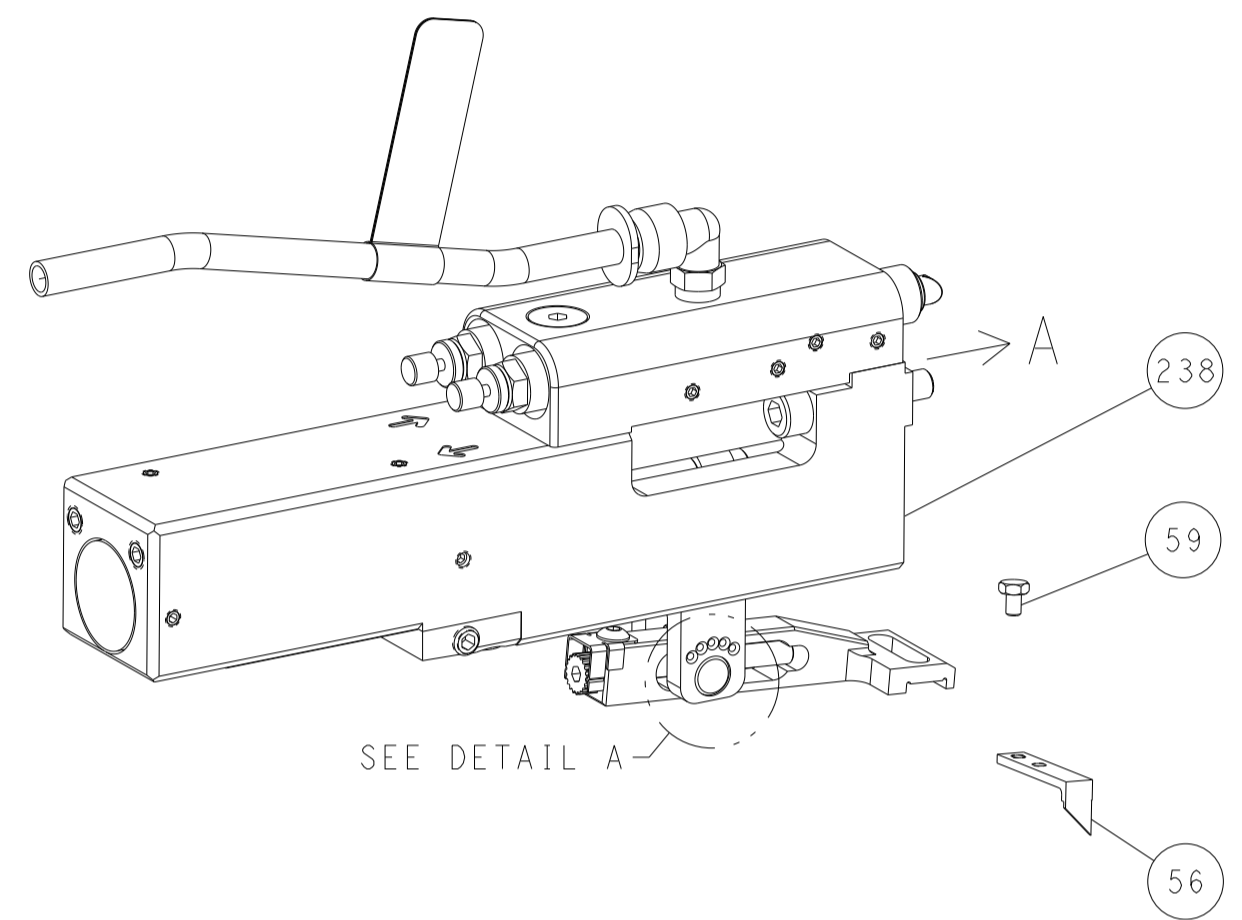
OWN	R.O. WILSON	30MAR2012	CHK	L.A. GROSS	05APR2012
APVD	T.L. ELBIN	05APR2012	NAME	Ocean Side Feed Applicator	
PRODUCT SPEC	APPLICATION SPEC				
SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO		
A1	00779	2151634	Customer Accessible Production Drawing	SCALE	1:2 SHEET 1 OF 4 REV J3

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

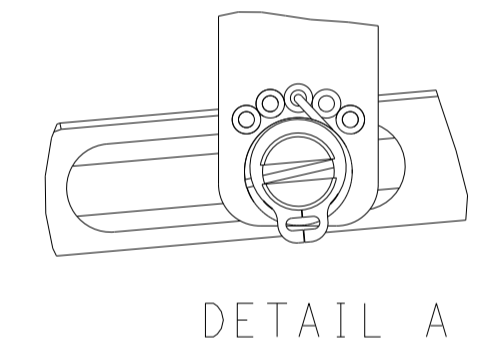
FEED TYPE MECHANICAL



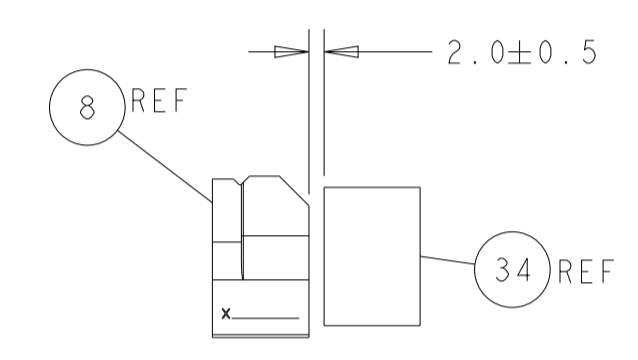
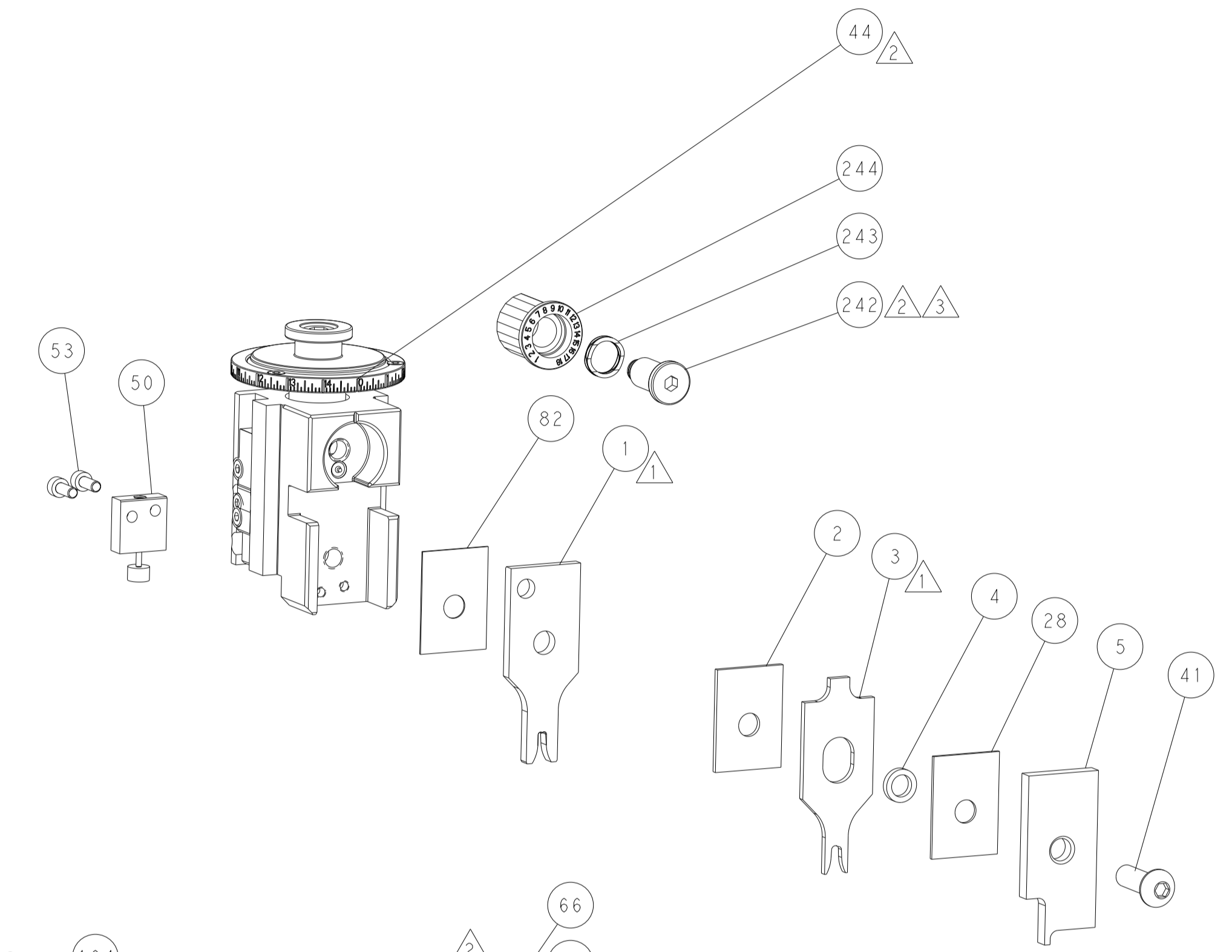
PNEUMATIC



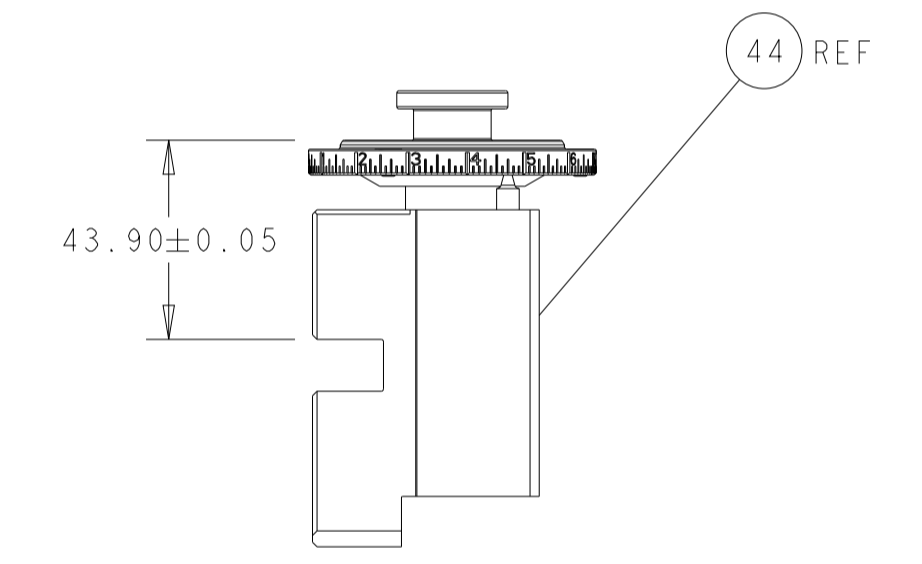
FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



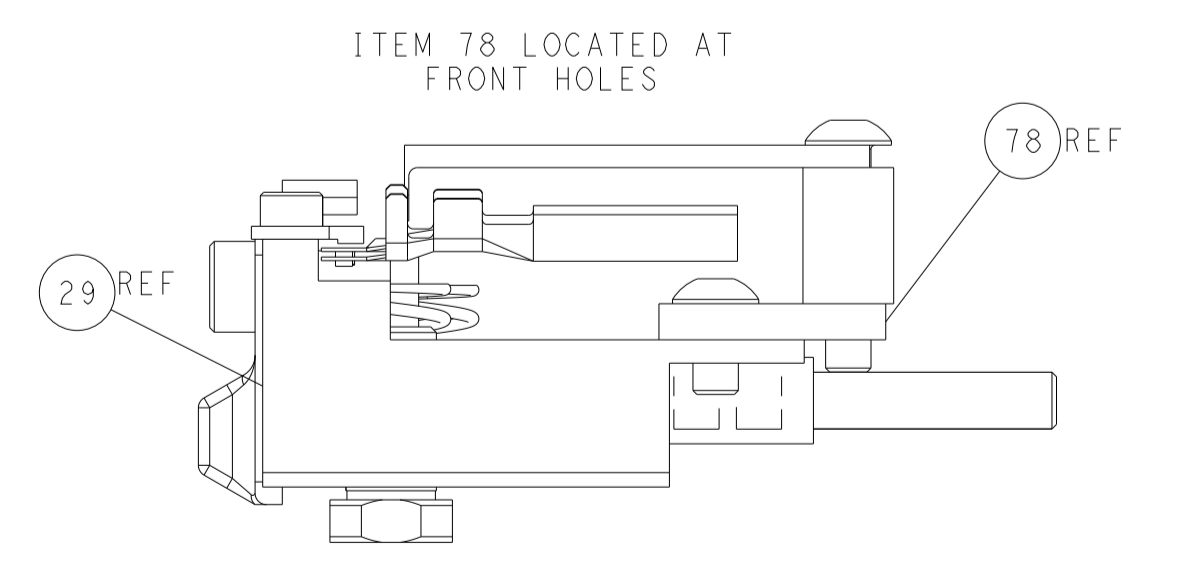
DETAIL A



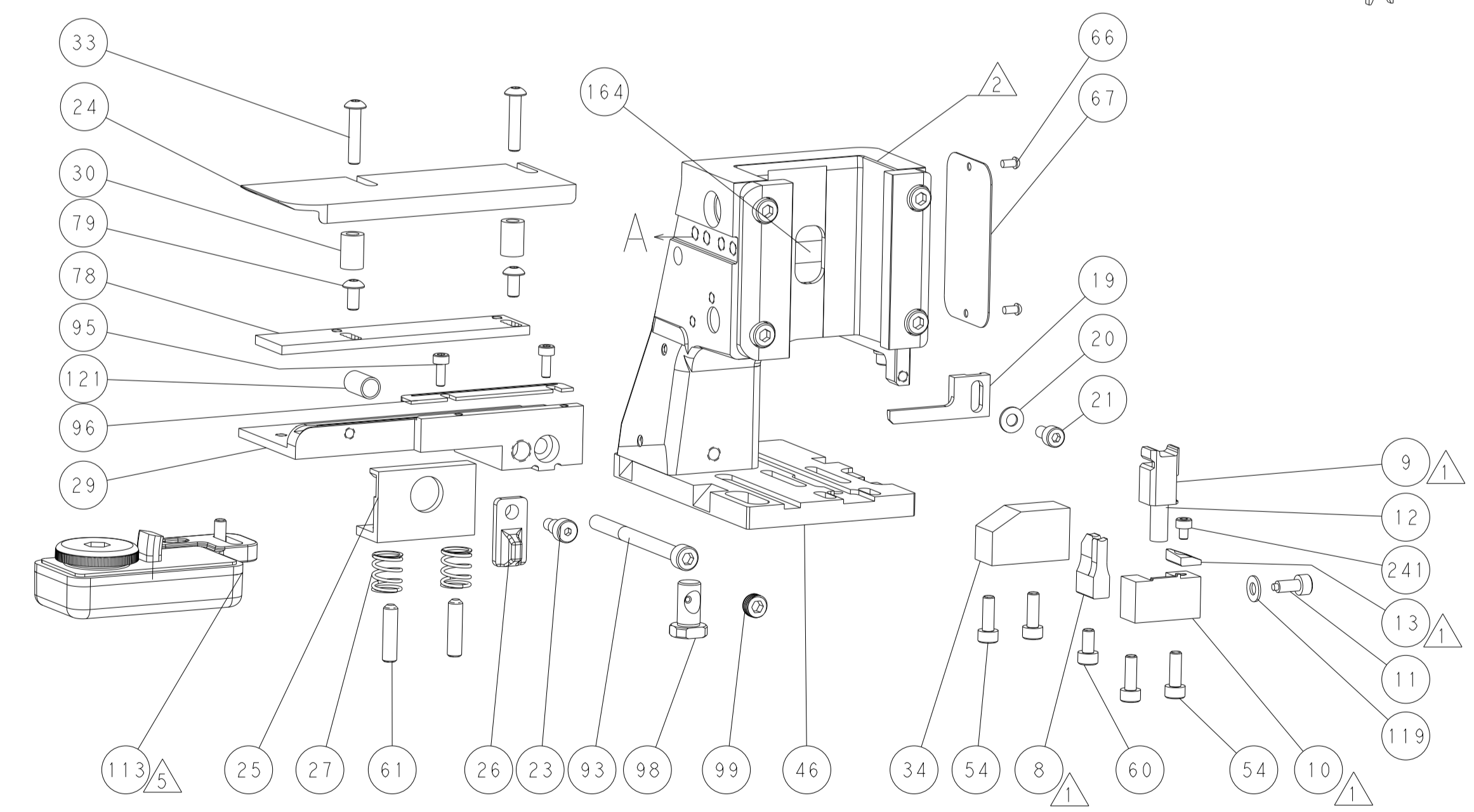
TERMINAL SUPPORT LOCATION



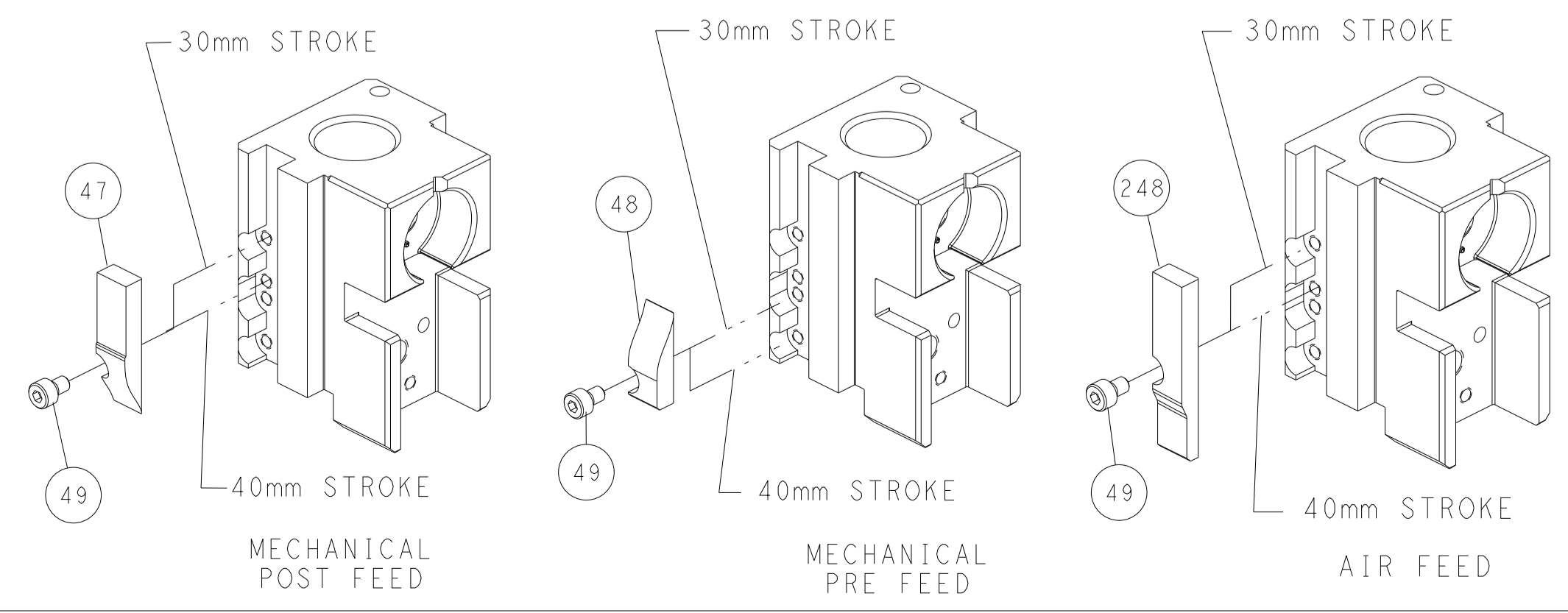
RAM SET-UP



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 R.O. WILSON 30MAR2012 CHK L.A. GROSS 05APR2012 APVD T.L. ELBIN 05APR2012	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 SIZE CAGE CODE DRAWING NO RESTRICTED TO A1 00779 C=2151634
MATERIAL:		WEIGHT:	SCALE 1:2 SHEET 2 OF 4 REV J3 Customer Accessible Production Drawing

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2151634-1	J	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2151634-2	J	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151634-7	D	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
 INTERFACE ADAPTER



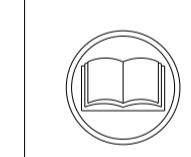
APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	3.05 mm [.120]	F
INSUL	4.06 mm [.160]	OV
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: AMP MCP 2.8K FLAT TYPE RECEPTACLE			
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE		
5.30-5.90 mm [.209-.232 IN]	Ø3.40-3.70 mm [.134-.146 IN]		
TERMINAL APPLICATION SPECIFICATION	114-18051		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
(A) 2-2141600-2	(A) 1-968946-1	1-968946-2	(A) 2-968946-1
(A) 2-968946-2	(A) 3-968946-1		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: AMP MCP 2.8K FLAT TYPE RECEPTACLE			
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE		
5.30-5.90 mm [.209-.232 IN]	Ø2.70-3.70 mm [.106-.146 IN]		
TERMINAL APPLICATION SPECIFICATION	(B)114-18148		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
(B) 1-968853-1	(B) 1-968853-3	(B) 1-1355880-1	

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
4.00mm2	2.15+/-0.05 [.085+/-0.002]	5.9

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
4.00mm2	2.10+/-0.05 [.083+/-0.002]	5.9
3.00mm2 JASO	1.92+/-0.05 [.076+/-0.002]	7.7
12 AWG	1.90+/-0.05 [.075+/-0.002]	7.9



- 1 RECOMMENDED SPARE PARTS
- 2 REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION & 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.

ENTRY LEVEL APPLICATOR		ITEM SUBSTITUTION LIST		
PART NUMBER	SAME AS	ITEM	ITEM DESCRIPTION	SUBSTITUTE PART NUMBER
8-2151634-1	2151634-1	1	WIRE CRIMPER	1803587-8
8-2151634-2	2151634-2	3	INSULATION CRIMPER	5-1803625-2
9-2151634-1	2-2151634-1	46	BASIC SUB -ASSEMBLY	1803940-9
9-2151634-2	2-2151634-2	141	BASIC SUB -ASSEMBLY	1-1803940-0
			LUBRICATOR	DELETE

***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	OWN	APVD
-	-	-	-	SEE SHEET 1	-	-	-

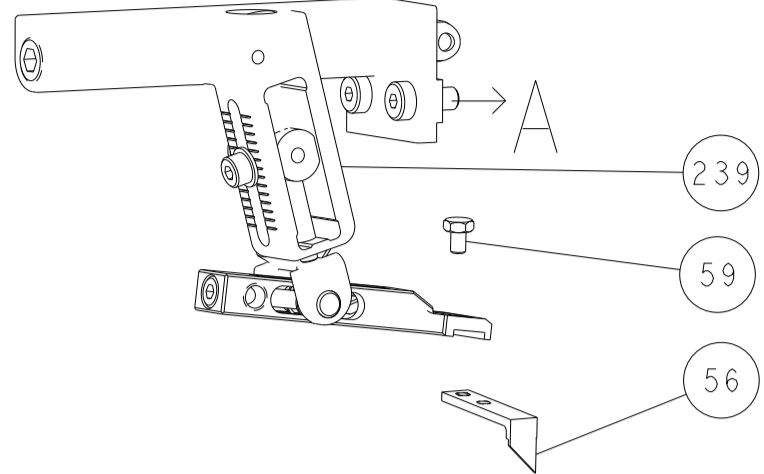
-	1	1	2119082-8	CAM, SNAIL, INSULATION ADJUSTMENT	244	
-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243	
3	-	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241	
-	-	1	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	1	-	2844940-1	AIR FEED MODULE	238	
-	REF	REF	994970-2	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	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	
-	1	1	1-22281-8	SPRING, COMPRESSION	121	
-	1	1	1-18028-2	WASHER, FLAT, REG M4	119	
5	-	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	2-690438-8	FRONT STRIP GUIDE	96	
-	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	95	
-	1	1	2168083-6	SCR, SKT HD CAP, RoHS, M5 X 6.5	93	
-	1	1	455888-5	SPACER, CRIMPER	82	
-	2	2	2079383-4	SCR, BHSC, RoHS (M4 X 8)	79	
-	1	1	1803096-1	EXTENSION PLATE	78	
-	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	
-	2	2	2-18032-5	SCR, SET, FLT PNT, M5 X 20.0	61	
-	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59	
-	1	1	1338685-1	PAWL, FEED	56	
-	2	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	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	1752356-4	SUPPORT, TERMINAL	34	
-	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33	
-	2	2	1-2844962-7	SPACER, CYLINDRICAL, STRIP GUIDE	30	
-	1	1	1-2844938-8	PLATE, STRIP GUIDE	29	
-	1	1	1-455888-0	SPACER, CRIMPER	28	
-	2	2	22283-9	SPRING, COMPRESSION	27	
-	1	1	356835-1	LEVER, DRAG RELEASE	26	
-	1	1	240792-1	DRAG, TERMINAL	25	
-	1	1	1320928-4	STRIP GUIDE	24	
-	1	1	980371-4	SCR, SKT HD SHLDR 5.0 DIA X 6.0	23	
-	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21	
-	1	1	1-18028-2	WASHER, FLAT, REG M4	20	
-	1	1	2119533-1	STRIPPER, SIDE FEED	19	
7	-	1	1	2119806-1	INSERT, SHEAR	13
-	1	1	3-22280-3	SPRING, COMPRESSION	12	
-	1	1	1-356885-4	STOP, SHEAR	11	
8	-	1	1	2119805-1	SHEAR HOLDER, FRONT	10
9	-	1	1	454276-5	FLOATING SHEAR, FRONT	9
10	1	1	1	1-1333208-8	ANVIL, COMBINATION .120	8
-	-	-	-	-	7	
-	-	-	-	-	6	
-	1	1	1-2119757-0	DEPRESSOR, SHEAR	5	
-	1	1	238011-4	BLOCK, CRIMPER SPACER	4	
11	1	1	1	5-2119785-2	CRIMPER, INSULATION OVERLAP PREMIUM	3
-	1	1	1	1-455888-6	SPACER, CRIMPER	2
12	1	1	1	456409-8	CRIMPER, WIRE .120 "F" PREMIUM	1

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DRAWING NO		DESCRIPTION		ITEM NO	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	5 PLC ±	6 PLC ±	7 PLC ±	8 PLC ±
MATERIAL:		FINISH:		WEIGHT:		SCALE:		REV:	
-		-		-		1:2		J3	

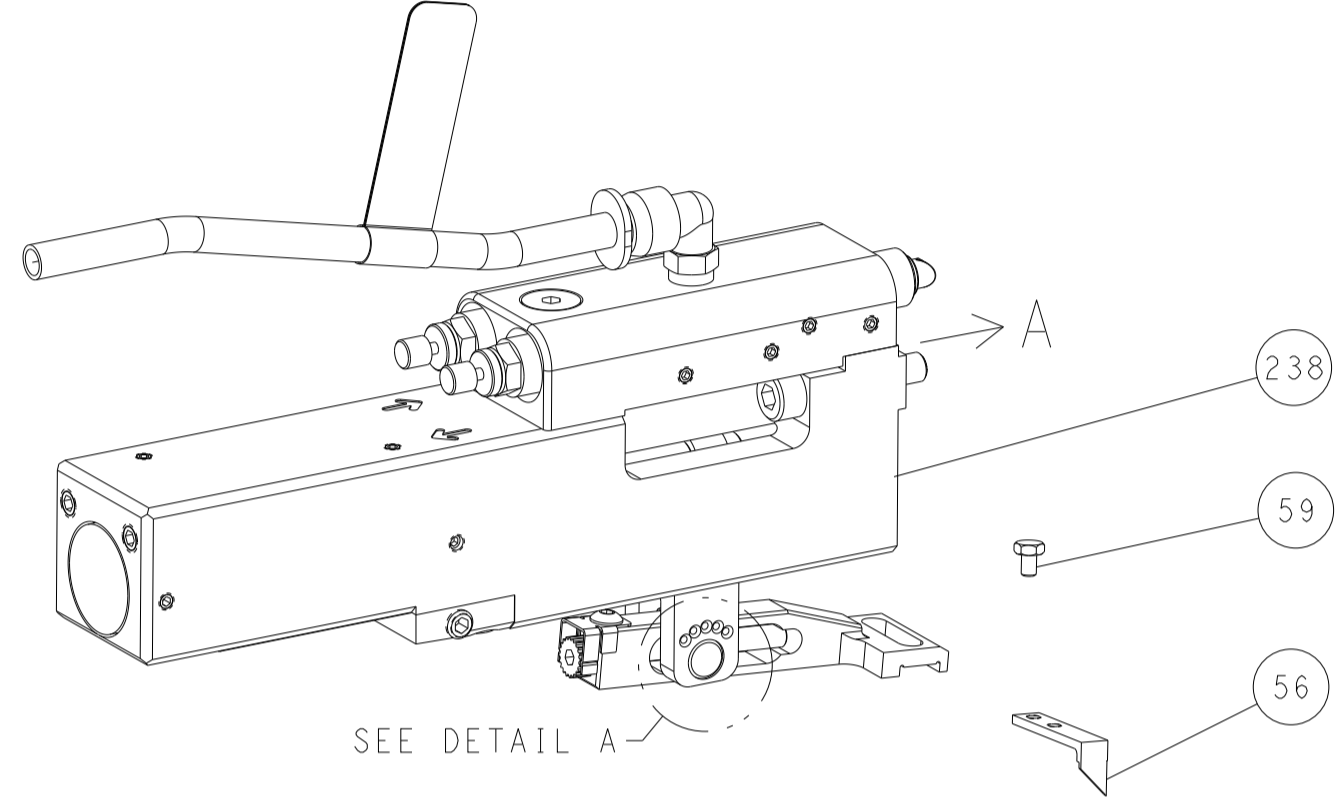
Customer Accessible Production Drawing

LOC	DIST	REVISIONS			
A	66	REV	DATE	BY	APPV
-	SEE SHEET 1	-	-	-	-

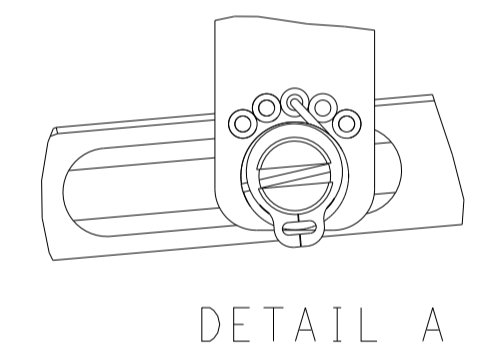
FEED TYPE MECHANICAL



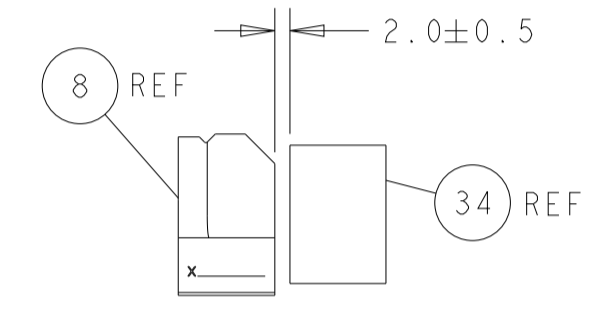
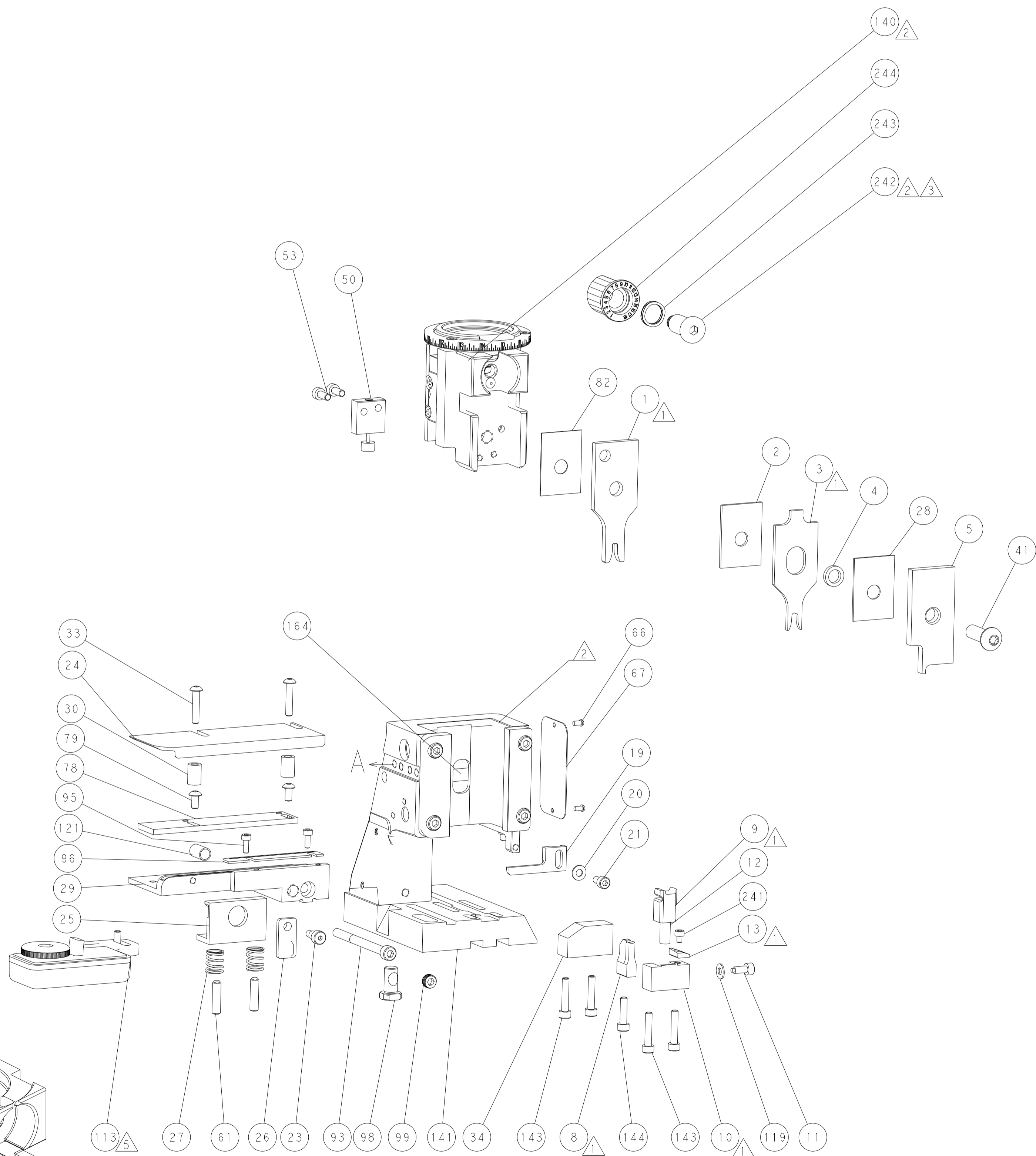
PNEUMATIC



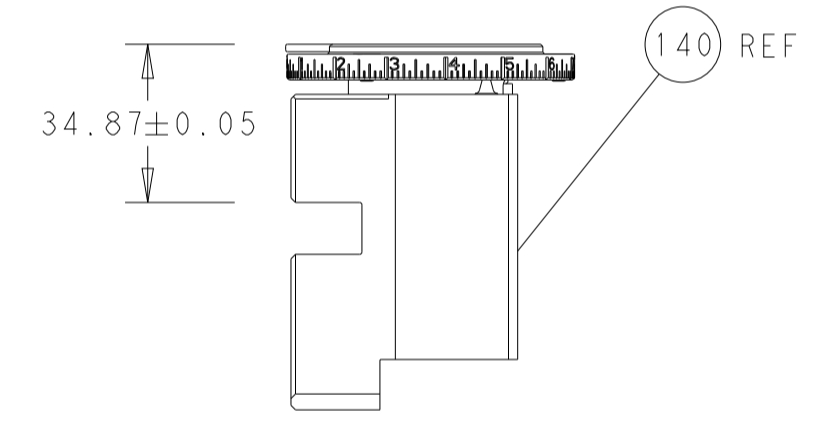
FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



DETAIL A

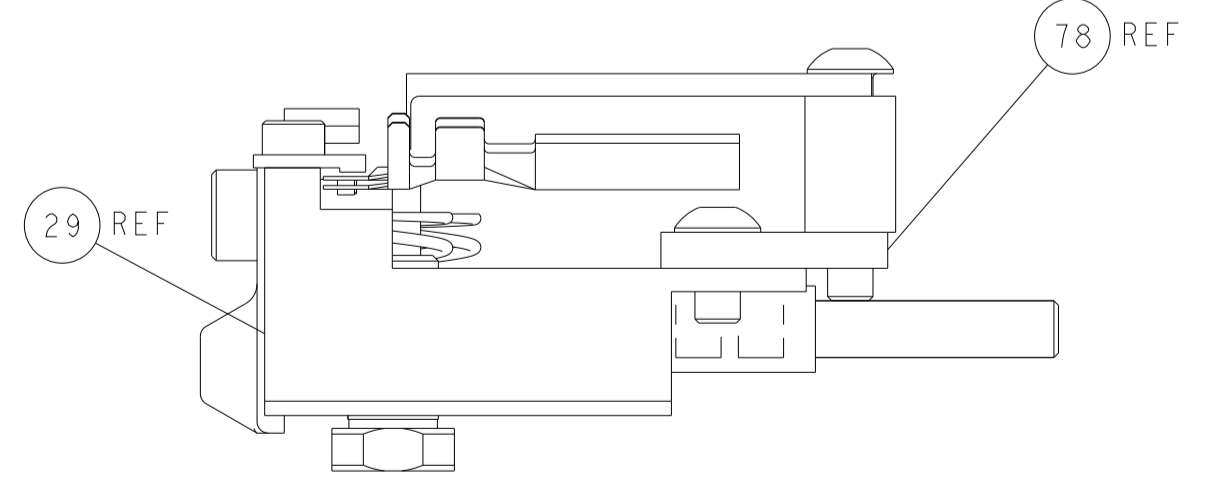


TERMINAL SUPPORT LOCATION



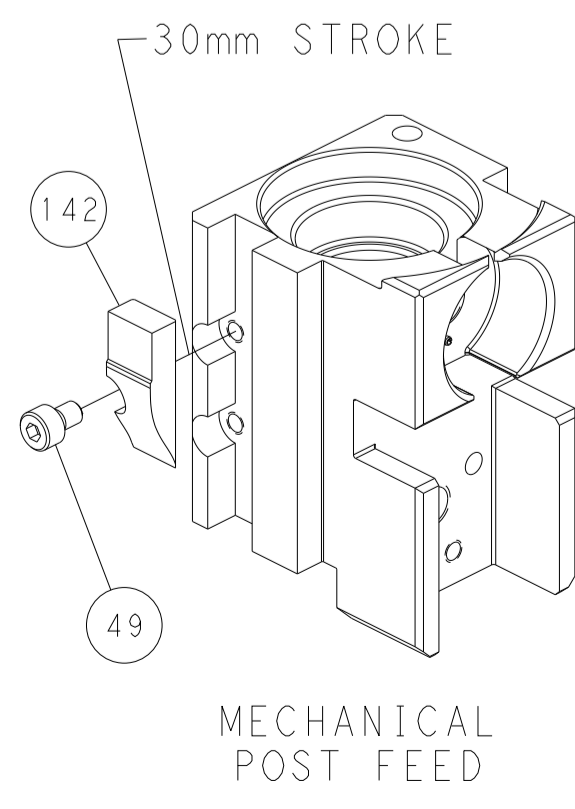
RAM SET-UP

ITEM 78 LOCATED AT FRONT HOLES

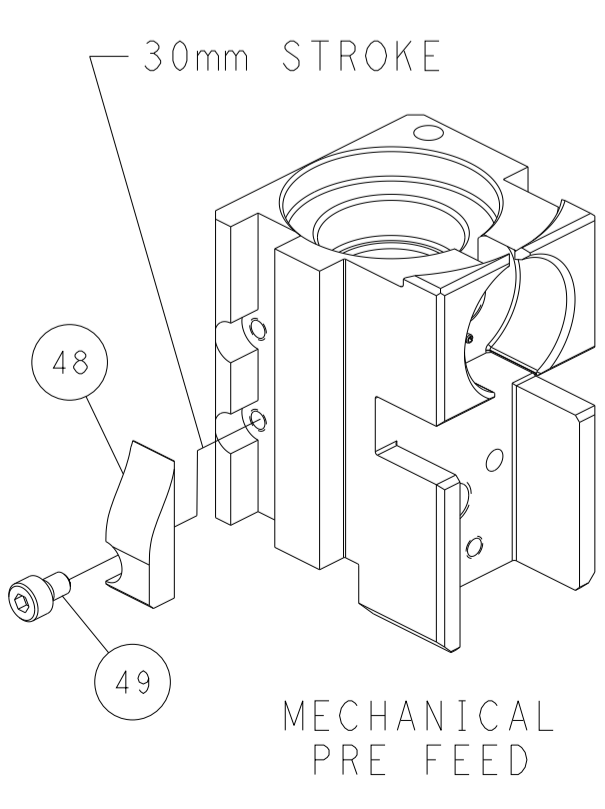


FEED TRACK POSITION GUIDE BY INSULATION BARREL

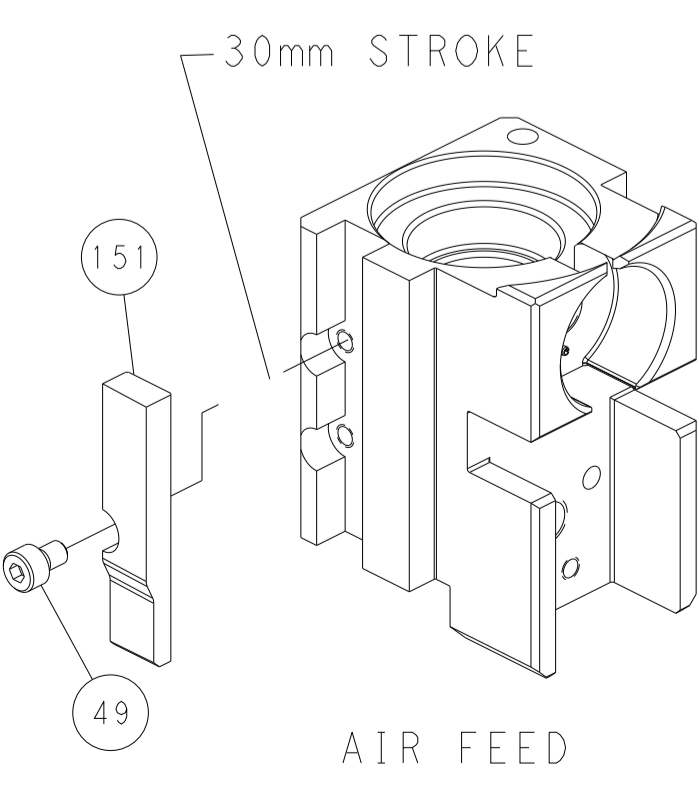
CAM POSITIONS



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)

<small>THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION. ALL RIGHTS RESERVED.</small> <small>THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION. ALL RIGHTS RESERVED.</small>		DWN: R.O. WILSON 30MAR2012 CHK: L.A. GROSS 05APR2012 APVD: T.L. ELBIN 05APR2012 PRODUCT SPEC: - APPLICATION SPEC: - WEIGHT: - MATERIAL: -	NAME: Ocean Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: C-2151634 SCALE: 1:2 SHEET: 4 OF 4 REV: J3	TE Connectivity Harrisburg, PA 17105-3608
--	--	---	---	--