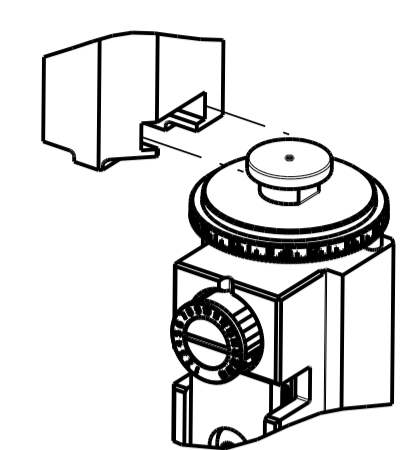


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151478-1	E	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2151478-2	F	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
3-2151478-2	F	FINE CRIMP HEIGHT ADJUST	DOUBLE ACTING PNEUMATIC WITH SENSORS
7-2151478-1	E	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2151478-2	F	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2151478-7	C	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA

CRIMP	SIZE	TYPE
WIRE	1.40 mm [.055]	F
INSUL	1.83 mm [.072]	SP

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 [1.30-.154 IN]	Ø1.40-1.60 mm [0.055-.063 IN]

TERMINAL APPLICATION SPECIFICATION

TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
1563888-1			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.50mm2	0.86+/-0.03 [0.034+/-0.001]	7.8

- 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 MAXIMUM INSULATION CRIMP WIDTH 2.05mm & MAXIMUM INSULATION CRIMP HEIGHT 2.05mm. SEE APPLICATION SPECIFICATION TO CLARIFY.
- 6 TERMINAL LUBRICANT IS RECOMMENDED.
- 7 THIS APPLICATOR IS EQUIPPED WITH THE DOUBLE ACTING FEED WITH SENSORS AND IS APPLICATION SPECIFIC. IT DOES NOT REQUIRE ITEMS 49 & 248.
- 8. 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)

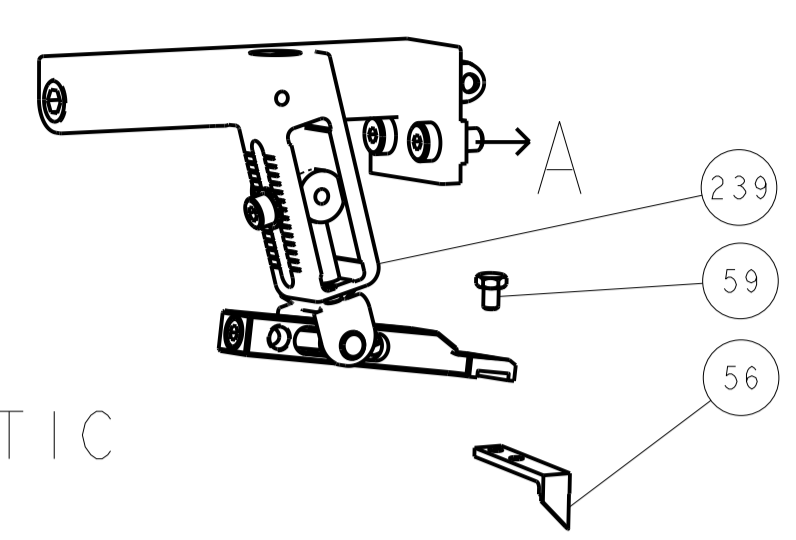
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		E		ECR-18-008490	04JUN2018	MZ	KZ
		F		ECR-19-010974	15JUL2019	FJ	TE
		F1		ECR-21-005485	17MAY2021	AJ	YY

7	-	-	-	1	-	-	2844950-1	AIR FEED MODULE	290	
	-	1	-	-	1	-	2119641-1	FEED CAM, AIR FEED	248	
	-	1	1	1	1	1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244	
	-	1	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243	
3	-	1	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242	
	-	1	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	REF	994970-2	COUNTER, MAGNETIC	164	
6	-	1	1	1	1	1	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113	
	-	1	1	1	1	1	2844908-1	SCREW, LOCKING	99	
	-	1	1	1	1	1	2844907-1	POST, LOCKING	98	
	-	1	1	1	1	1	455888-5	SPACER, CRIMPER	82	
	-	1	1	1	1	1	1803607-3	DOCUMENTATION PACKAGE	71	
	-	1	1	1	1	1	2119791-5	DEPRESSOR, WIRE	70	
	-	1	1	1	1	1	2119740-1	TAG, IDENTIFICATION	67	
	-	2	2	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66	
	-	1	1	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	60	
	-	1	1	1	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59	
	-	1	1	1	1	1	1338685-1	PAWL, FEED	56	
	-	4	4	4	4	4	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	54	
	-	2	2	2	2	2	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	53	
	-	1	1	1	1	1	5018030-1	NUT, HEX, REG, RoHS, M3	52	
	-	1	1	1	1	1	811242-5	BUMPER, HOLD DOWN	51	
	-	1	1	1	1	1	690753-2	SPACER, TONKER	50	
7	-	1	2	-	-	1	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	1	1803583-9	APPLICATOR BASIC ASSEMBLY, SF	46	
	-	1	1	1	1	1	1803515-1	RAM ASSEMBLY, SF ATLANTIC	44	
	-	1	1	1	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41	
	-	1	1	1	1	1	1-1752356-8	SUPPORT, TERMINAL	34	
	-	2	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33	
	-	2	2	2	2	2	2-2844962-6	SPACER, CYLINDRICAL, STRIP GUIDE	30	
	-	1	1	1	1	1	2844992-2	ASSEMBLY, STRIP GUIDE	29	
	-	1	1	1	1	1	1320928-2	STRIP GUIDE	24	
	-	1	1	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21	
	-	2	2	2	2	2	1-18028-2	WASHER, FLAT, REG M4	20	
	-	1	1	1	1	1	2119533-1	STRIPPER, SIDE FEED	19	
	-	1	1	1	1	1	2119806-1	INSERT, SHEAR	13	
	-	1	1	1	1	1	3-22280-3	SPRING, COMPRESSION	12	
	-	1	1	1	1	1	1-356885-4	STOP, SHEAR	11	
	-	1	1	1	1	1	2119805-1	SHEAR HOLDER, FRONT	10	
	-	1	1	1	1	1	1803095-3	FLOATING SHEAR, FRONT	9	
	-	1	2	2	1	1	1332231-4	ANVIL, COMBINATION, SPECIAL	8	
	-	1	1	1	1	1	240641-4	SPACER	7	
	-	-	-	-	-	-	-	-	6	
	-	1	1	1	1	1	2119757-8	DEPRESSOR, SHEAR	5	
	-	1	1	1	1	1	238011-9	BLOCK, CRIMPER SPACER	4	
	-	1	2	2	1	1	1-1633989-5	CRIMPER, INSULATION, SPECIAL	3	
	-	-	-	-	-	-	-	-	2	
	-	1	2	2	1	1	3-456402-3	CRIMPER, WIRE PREMIUM	1	
	-	77	72	71	32	2	-1	PART NO	DESCRIPTION	ITEM NO

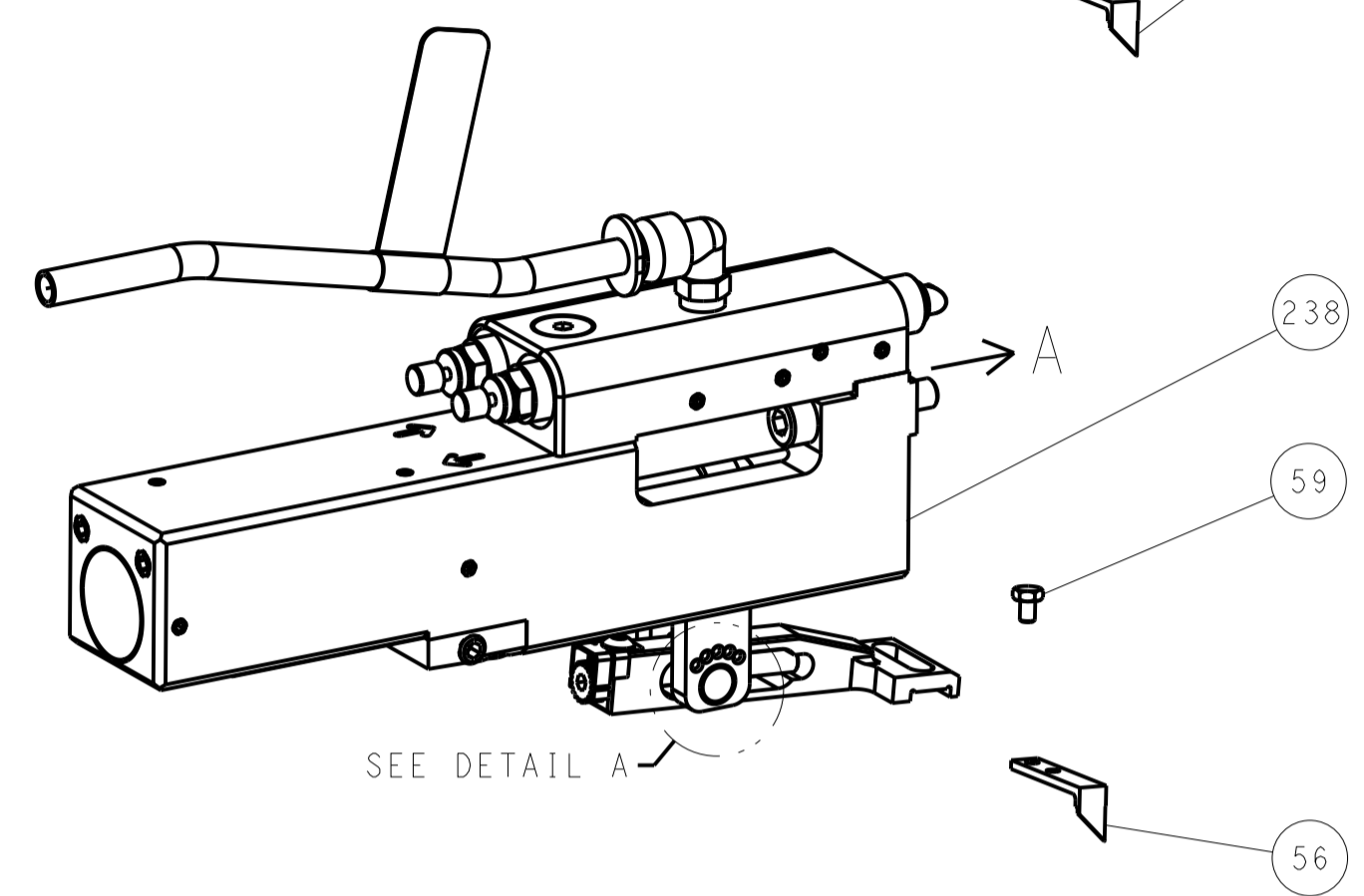
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mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	PRODUCT SPEC		APPLICATION SPEC		SIZE: 00779 C=2151478	
MATERIAL:		FINISH:		WEIGHT:		SCALE: 1:2		SHEET 1 OF 4		REV: F1	

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

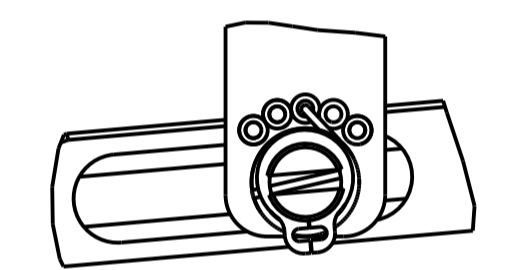
FEED TYPE MECHANICAL



PNEUMATIC

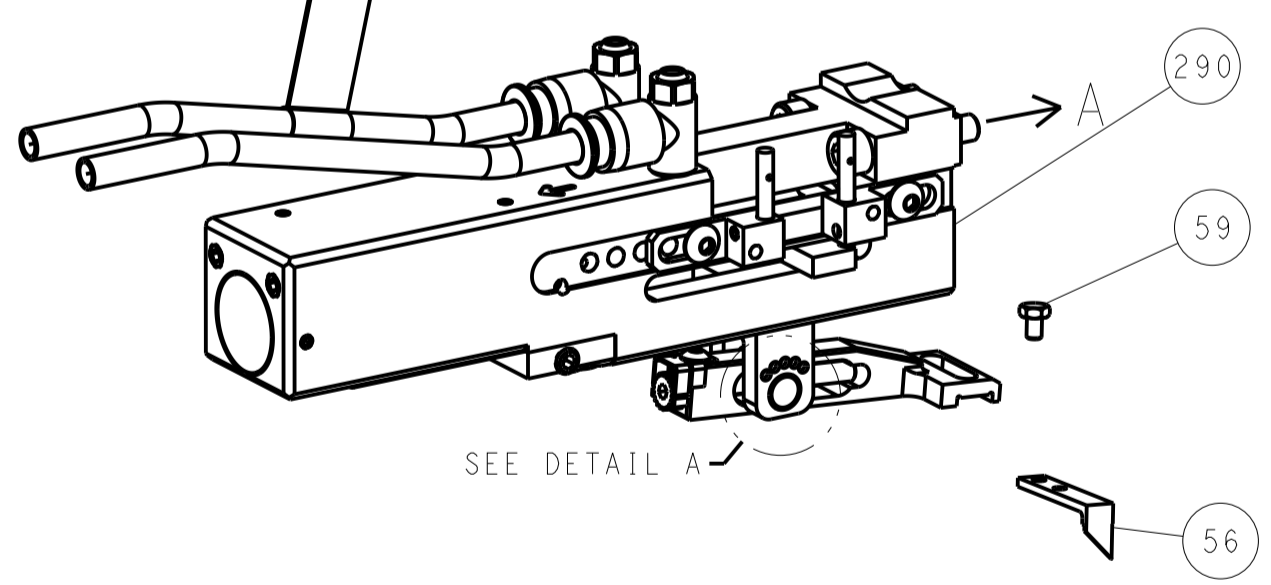


FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)

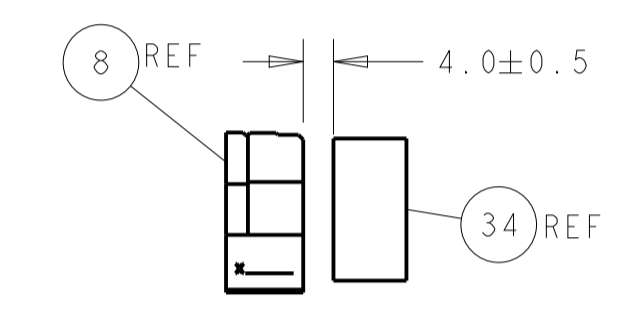
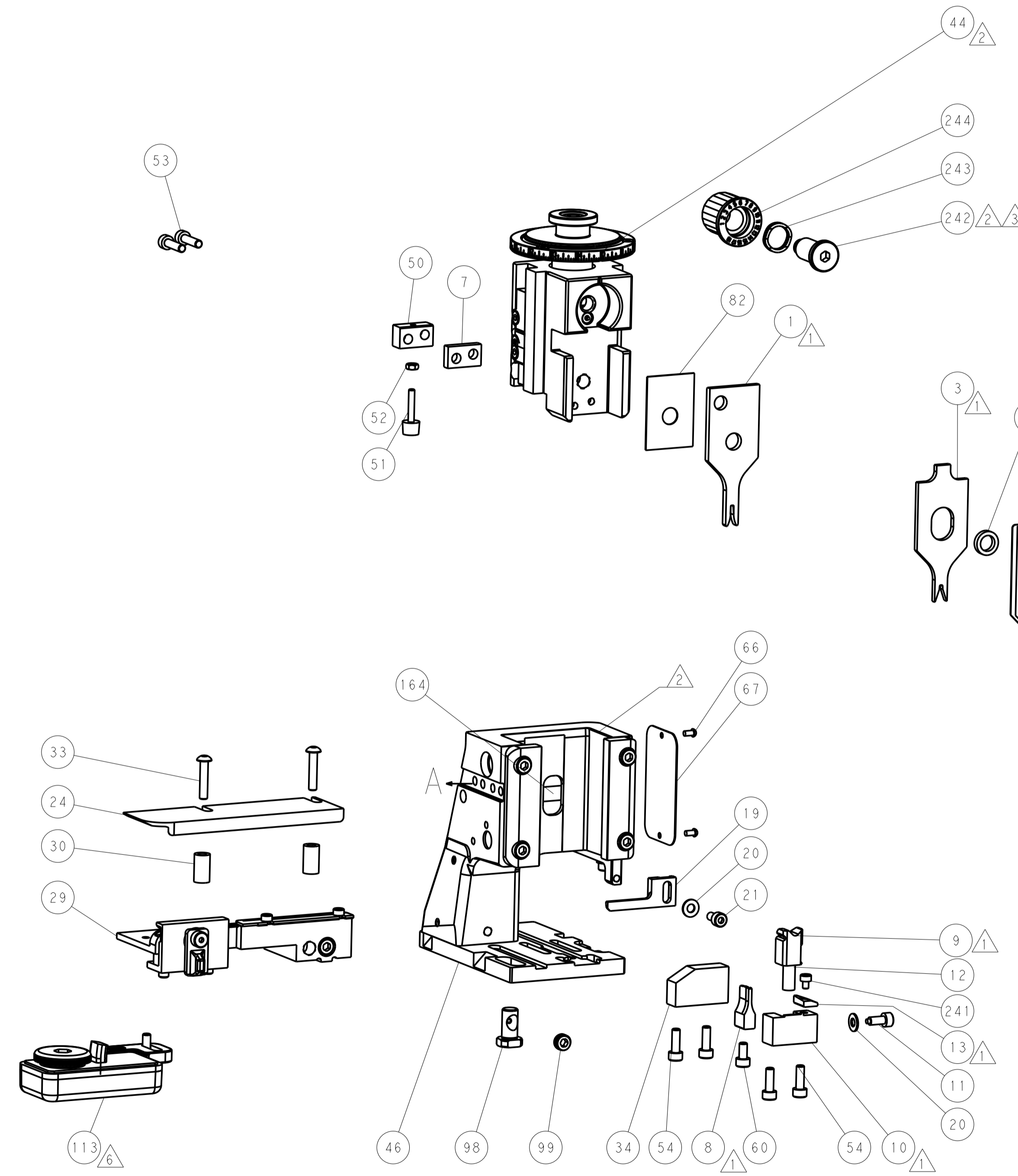
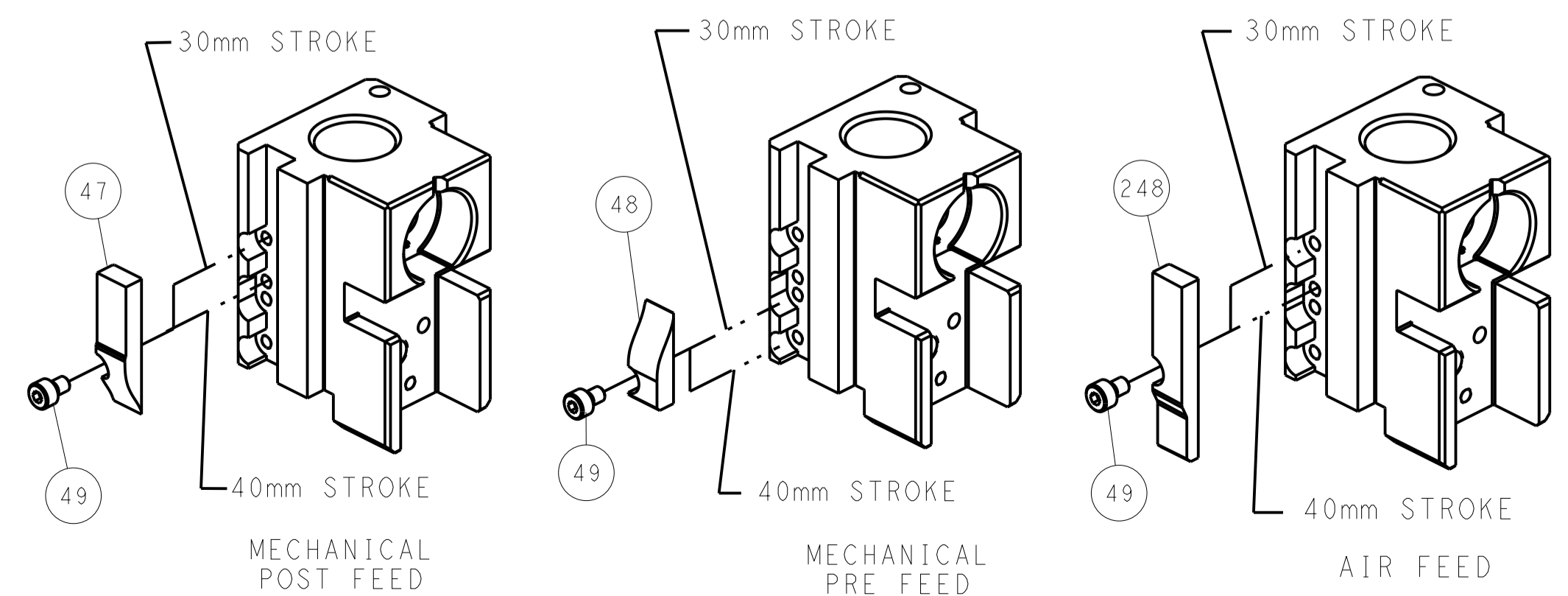


DETAIL A

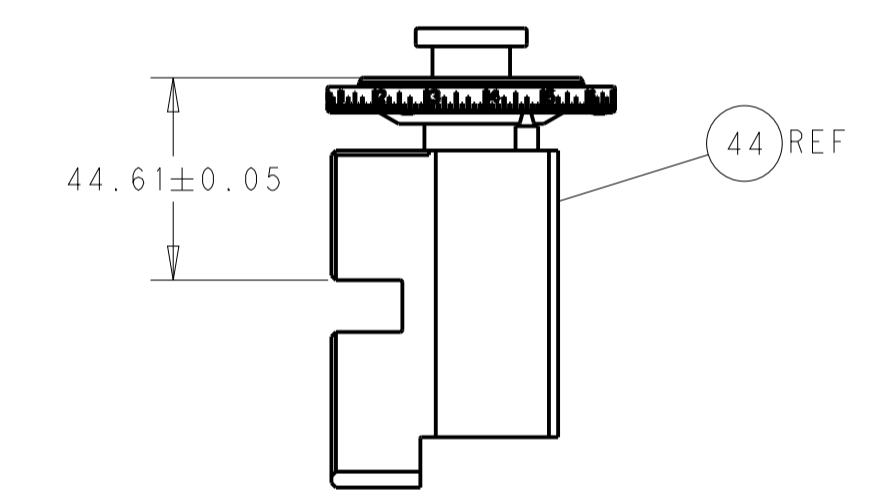
DOUBLE ACTING PNEUMATIC WITH SENSORS



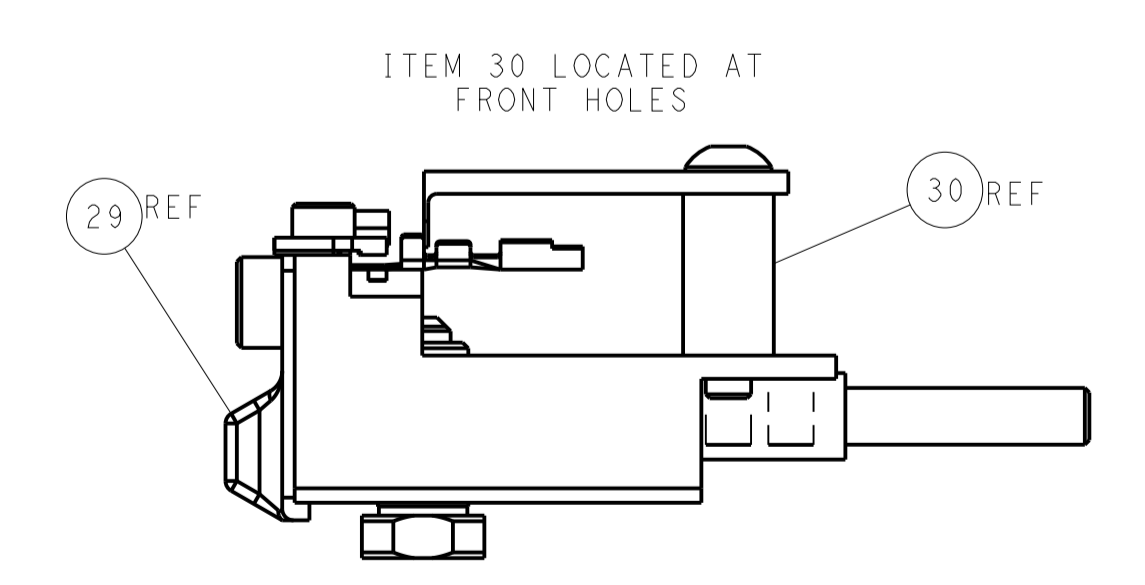
CAM POSITIONS



TERMINAL SUPPORT LOCATION



RAM SET-UP



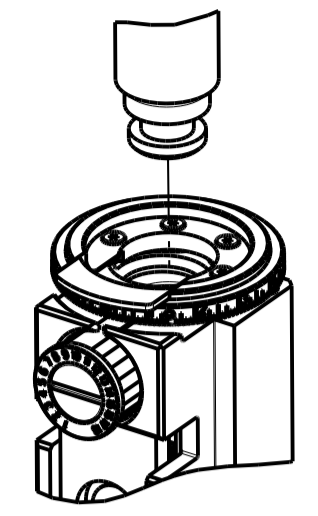
FEED TRACK POSITION GUIDE BY INSULATION BARREL

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:		DWN: H. HUANG 27AUG2012		TE Connectivity	
mm		0 PLC ±		CHK: S. XI 27AUG2012		Harrisburg, PA 17105-3608	
Ø		1 PLC ±		APPV: S. XI 27AUG2012		NAME: Ocean Side Feed Applicator	
H		2 PLC ±		PRODUCT SPEC		SIZE: CAGE CODE: DRAWING NO: RESTRICTED TO	
L		3 PLC ±		APPLICATION SPEC		A1 00779 ©=2151478	
R		4 PLC ±		WEIGHT		Customer Accessible Production Drawing	
S		5 PLC ±		FINISH		SCALE: 1:2 SHEET 2 OF 4 REV 1	
T		6 PLC ±		MATERIAL		SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION	

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2151478-1	E	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2151478-2	F	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
4-2151478-2	F	FINE CRIMP HEIGHT ADJUST	DOUBLE ACTING PNEUMATIC WITH SENSORS
7-2151478-7	C	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.40 mm [.055]	F
INSUL	1.83 mm [.072]	SP
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 [1.130-.154 IN]		Ø1.40-1.60 mm [1.055-.063 IN]	
TERMINAL APPLICATION SPECIFICATION	114-18464		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
1563888-1			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.50mm2	0.86+/-0.03 [1.034+/-0.011]	7.8

- RECOMMENDED SPARE PARTS
 - REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND 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.
 - MAXIMUM INSULATION CRIMP WIDTH 2.05mm & MAXIMUM INSULATION CRIMP HEIGHT 2.05mm. SEE APPLICATION SPECIFICATION TO CLARIFY.
 - TERMINAL LUBRICANT IS RECOMMENDED.
 - THIS APPLICATOR IS EQUIPPED WITH THE DOUBLE ACTING FEED WITH SENSORS AND IS APPLICATION SPECIFIC. IT DOES NOT REQUIRE ITEMS 49 & 151.
8. 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
8-2151478-1	2151478-1	1	WIRE CRIMPER	3-1803530-3
8-2151478-2	2151478-2	3	INSULATION CRIMPER	1-1803623-5
9-2151478-1	2-2151478-1	46	BASIC SUB -ASSEMBLY	1803940-9
9-2151478-2	2-2151478-2	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)

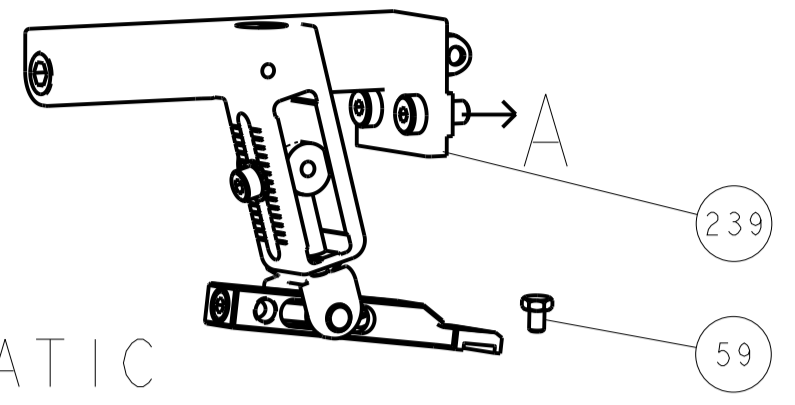
LOC	DIST	REV	DATE	BY	APPV
A	66				

REV	DATE	BY	APPV	DESCRIPTION	QTY	ITEM NO
-	1	-	-	2844950-1	AIR FEED MODULE	290
-	1	1	1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
3	-	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	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	REF	994970-2	COUNTER, MAGNETIC	164
7	-	-	1	2119641-2	FEED CAM, AIR FEED	151
-	1	1	1	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	144
-	4	4	4	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	143
-	-	-	1	2119653-2	FEED CAM, POST FEED	142
-	1	1	1	1-1803583-0	APPLICATOR BASIC ASSEMBLY, SF	141
-	1	1	1	1803516-1	RAM ASSEMBLY, SF PACIFIC	140
6	-	1	1	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113
-	1	1	1	2844908-1	SCREW, LOCKING	99
-	1	1	1	2844907-1	POST, LOCKING	98
-	1	1	1	455888-5	SPACER, CRIMPER	82
-	1	1	1	1803607-3	DOCUMENTATION PACKAGE	71
-	1	1	1	2119791-5	DEPRESSOR, WIRE	70
-	1	1	1	2119740-1	TAG, IDENTIFICATION	67
-	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	1	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	1	1	1	1338685-1	PAWL, FEED	56
-	2	2	2	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	53
-	1	1	1	5018030-1	NUT, HEX, REG, RoHS, M3	52
-	1	1	1	811242-5	BUMPER, HOLD DOWN	51
-	1	1	1	690753-2	SPACER, TONKER	50
7	-	-	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	-	-	1	2119652-1	FEED CAM, PRE FEED	48
-	1	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
-	1	1	1	1-1752356-8	SUPPORT, TERMINAL	34
-	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	2	2-2844962-6	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	1	2844992-2	ASSEMBLY, STRIP GUIDE	29
-	1	1	1	1320928-2	STRIP GUIDE	24
-	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
-	2	2	2	1-18028-2	WASHER, FLAT, REG M4	20
-	1	1	1	2119533-1	STRIPPER, SIDE FEED	19
1	-	-	1	2119806-1	INSERT, SHEAR	13
-	1	1	1	3-22280-3	SPRING, COMPRESSION	12
-	1	1	1	1-356885-4	STOP, SHEAR	11
1	-	-	1	2119805-1	SHEAR HOLDER, FRONT	10
1	-	-	1	1803095-3	FLOATING SHEAR, FRONT	9
1	-	-	1	1333231-4	ANVIL, COMBINATION, SPECIAL	8
-	1	1	1	240641-4	SPACER	7
-	-	-	-	-	-	6
-	1	1	1	2119757-8	DEPRESSOR, SHEAR	5
-	1	1	1	238011-9	BLOCK, CRIMPER SPACER	4
1	-	-	1	1-1633989-5	CRIMPER, INSULATION, SPECIAL	3
-	-	-	-	-	-	2
1	-	-	1	3-456402-3	CRIMPER, WIRE PREMIUM	1
-77	-42	-22	-21	PART NO	DESCRIPTION	ITEM NO

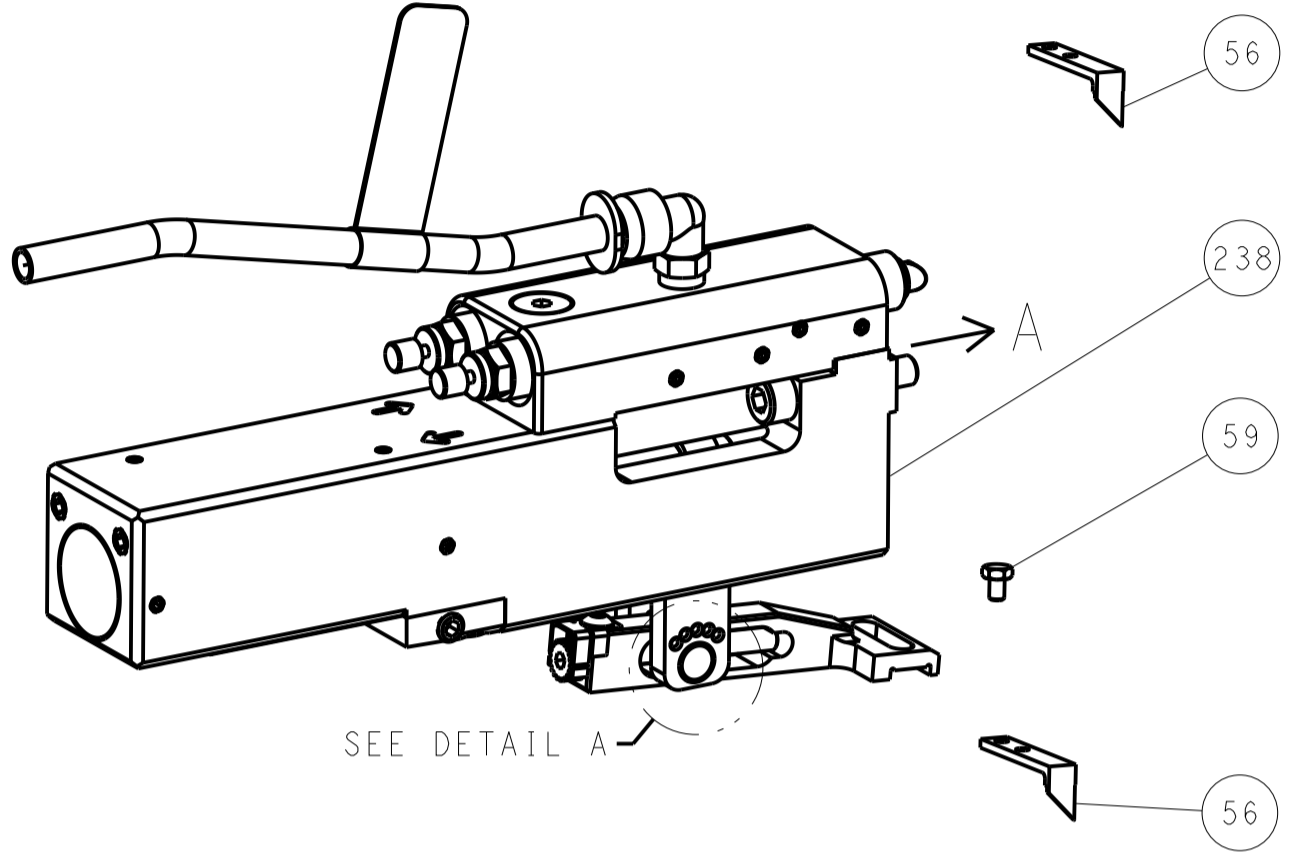
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		0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH		PRODUCT SPEC APPLICATION SPEC WEIGHT SCALE: 1:2		SIZE: 00779 CAGE CODE: 2151478 DRAWING NO: 2151478		RESTRICTED TO: Customer Accessible Production Drawing		SHEET 3 OF 4 REV: F1	

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

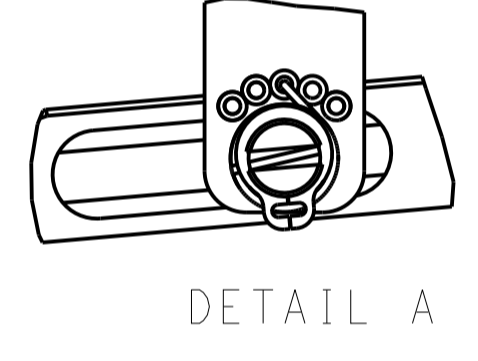
FEED TYPE MECHANICAL



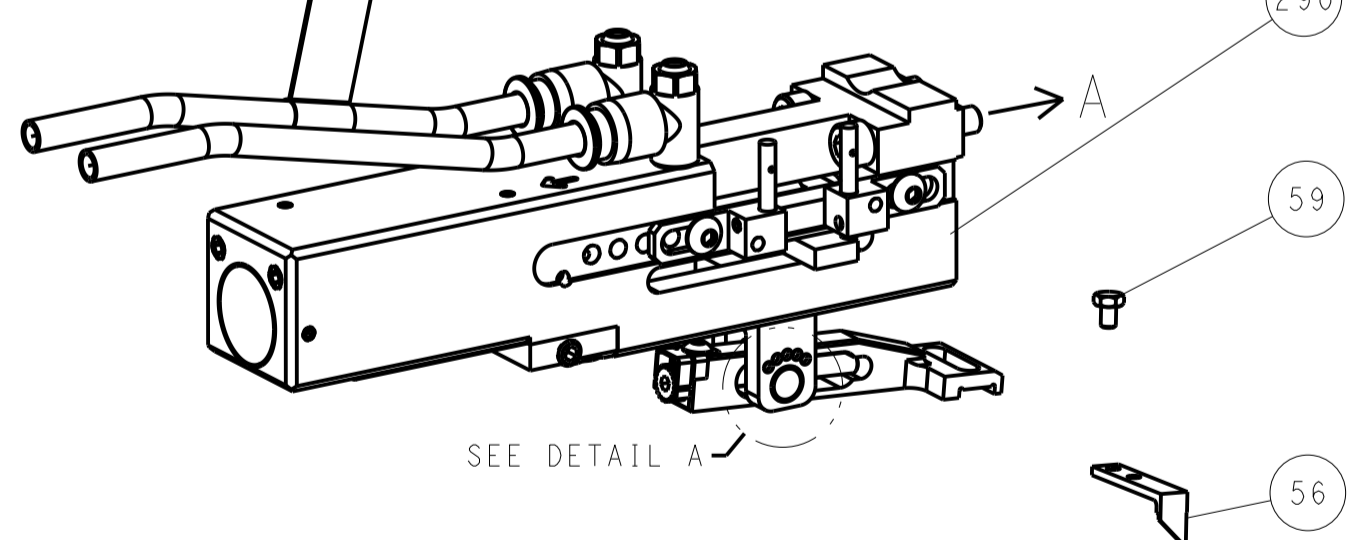
PNEUMATIC



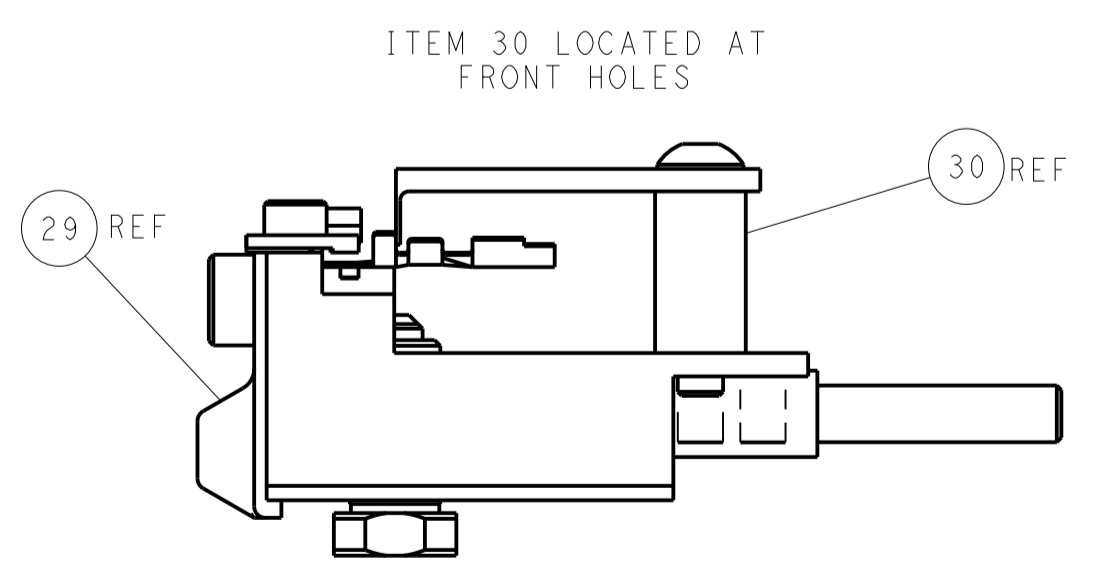
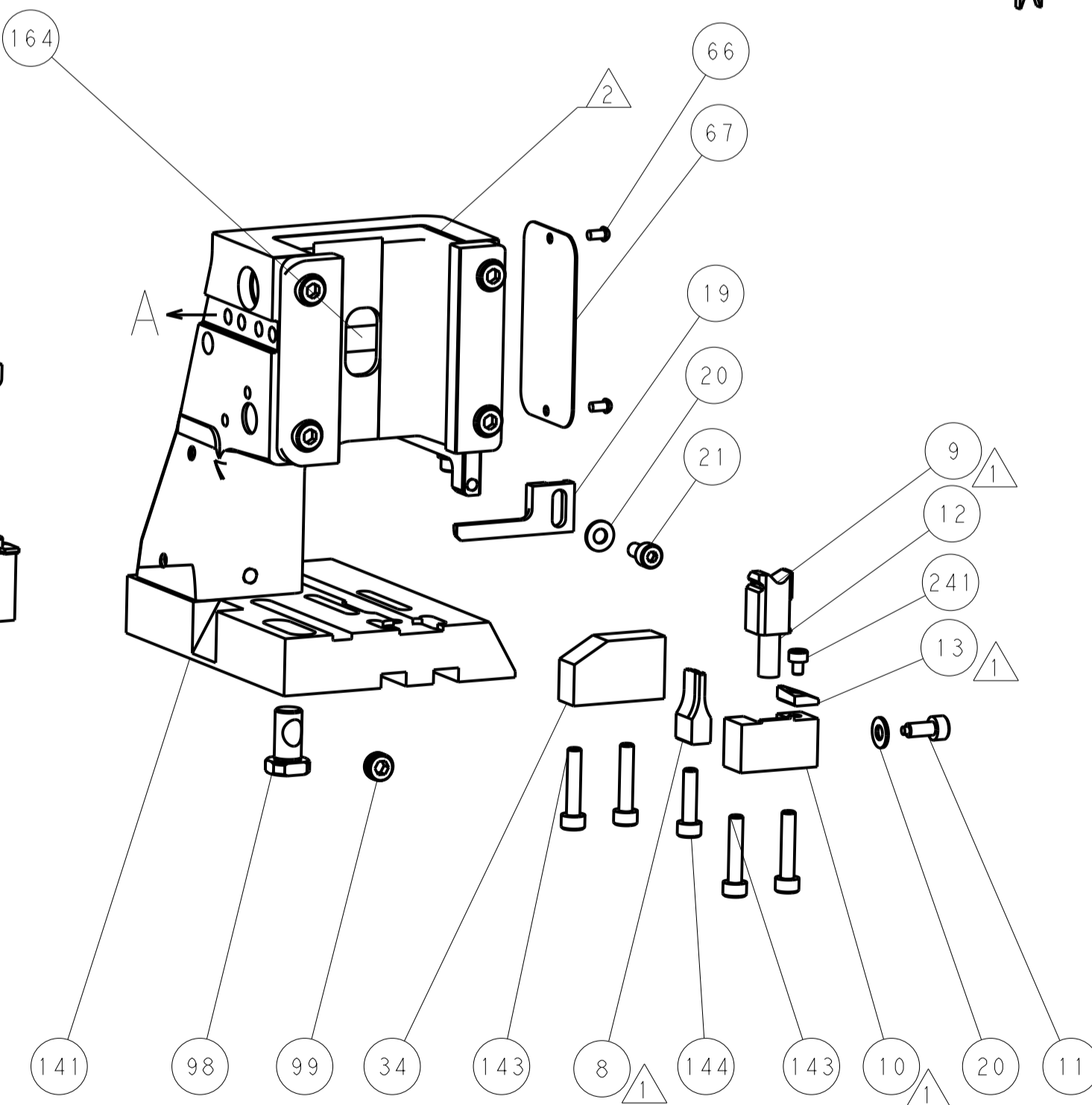
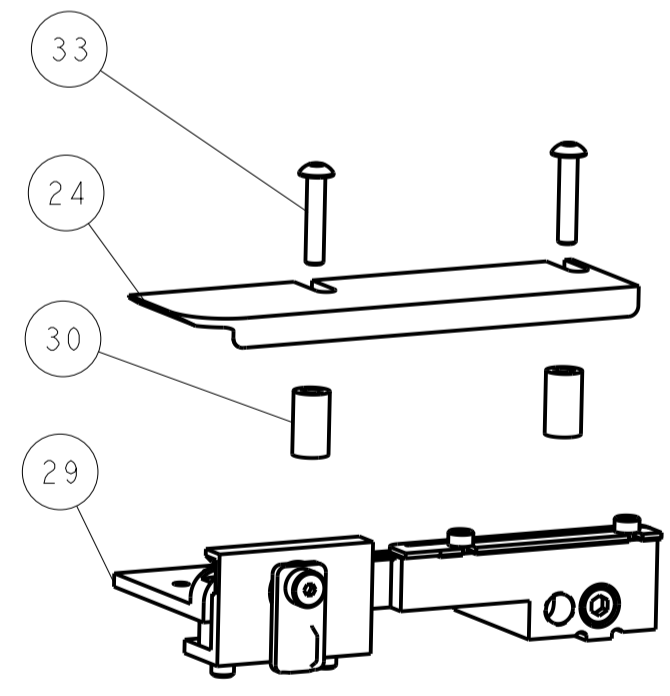
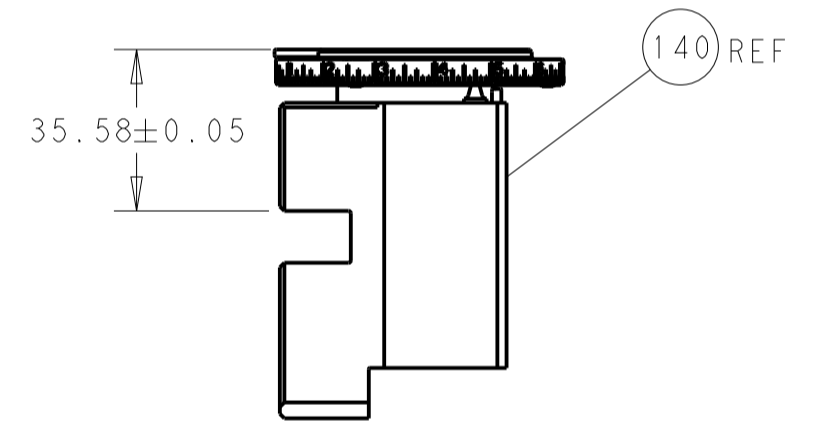
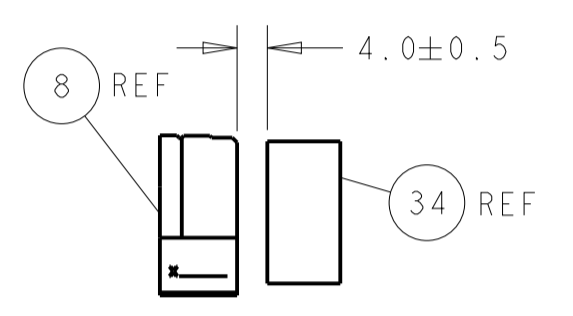
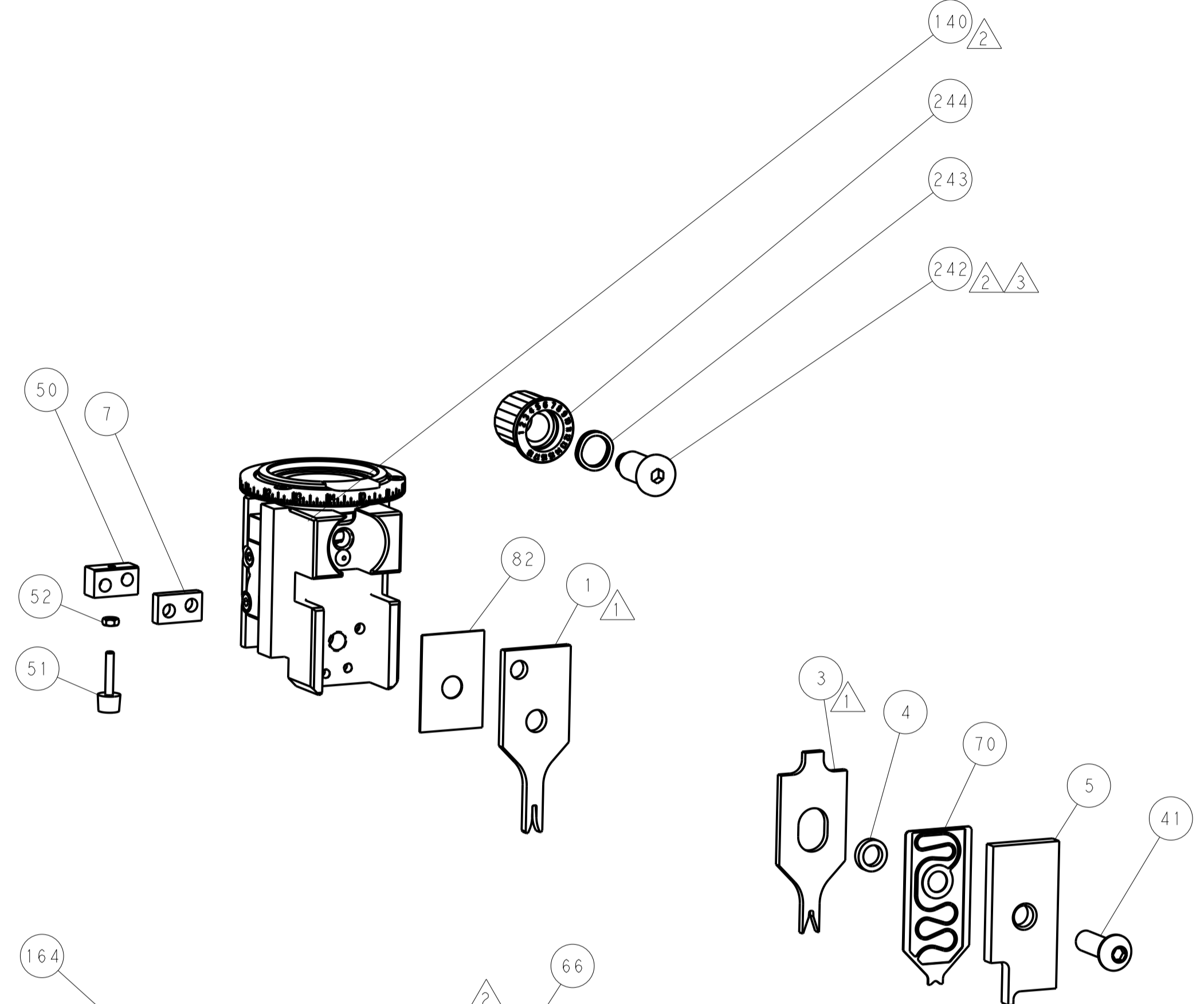
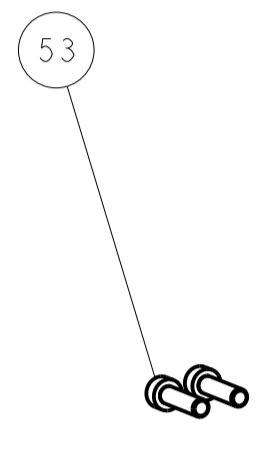
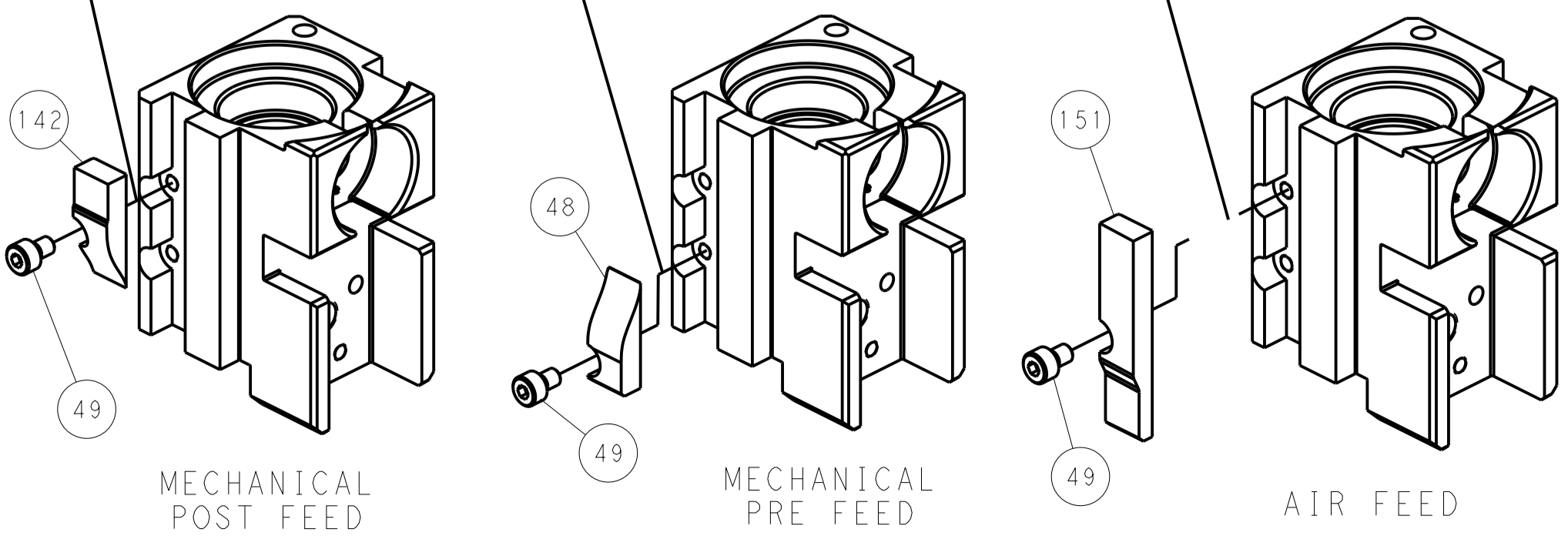
FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



DOUBLE ACTING PNEUMATIC WITH SENSORS



CAM POSITIONS



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:		DWN: H. HUANG 27AUG2012		TE Connectivity	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	5 PLC ±	Harrisburg, PA 17105-3608
MATERIAL:	FINISH:	WEIGHT:	ANGLES:	CHK: S. XI 27AUG2012	APVD: S. XI 27AUG2012	NAME: Ocean Side Feed Applicator	RESTRICTED TO:
Customer Accessible Production Drawing				SCALE: 1:2	SHEET: 4	OF: 4	REV: F1