

| PART NUMBER | REVISION | DESCRIPTION | FEED TYPE |
|-------------|----------|----------------------------------|------------|
| 2151344-1 | E | FINE CRIMP HEIGHT ADJUST | MECHANICAL |
| 2151344-2 | E | FINE CRIMP HEIGHT ADJUST | PNEUMATIC |
| 7-2151344-1 | E | MECHANICAL AND CRIMP TOOLING KIT | MECHANICAL |
| 7-2151344-2 | E | PNEUMATIC AND CRIMP TOOLING KIT | PNEUMATIC |
| 7-2151344-7 | A | CRIMP TOOLING KIT | - |

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



| APPLICATOR DATA | | |
|-----------------|----------------|------|
| CRIMP | SIZE | TYPE |
| WIRE | 1.57 mm [.062] | F |
| INSUL | 2.30 mm [.091] | O |

APPLICATOR INSTRUCTIONS
408-35042

| TERMINAL DATA: TE TERMINAL | | TE CRIMP SPECIFICATION | |
|--|-------------|------------------------------|-------------|
| TERMINAL NAME: AMP MCP2.8 FLAT TYPE RECEPTACLE | | | |
| WIRE STRIP LENGTH | | INSULATION DIAMETER RANGE | |
| 3.30-3.90 mm [.130-.154 IN] | | Ø1.20-1.40 mm [.047-.055 IN] | |
| TERMINAL APPLICATION SPECIFICATION | 114-18148 | | |
| TERMINALS APPLIED | | | |
| TE TERMINAL | TE TERMINAL | TE TERMINAL | TE TERMINAL |
| 1-968880-1 | 1-968880-3 | 1-1355876-1 | |

| WIRE SIZE | CRIMP HEIGHT mm [INCH] | CRIMP HEIGHT REFERENCE SETTING |
|-----------|-------------------------------|--------------------------------|
| 0.50mm2 | 1.14 +/- 0.05 [.045 +/- .002] | 6.1 |
| 0.35mm2 | 1.08 +/- 0.05 [.043 +/- .002] | 6.6 |
| 0.25mm2 | 1.02 +/- 0.05 [.040 +/- .002] | 7.3 |
| 0.20mm2 | 1.00 +/- 0.05 [.039 +/- .002] | 7.5 |

- 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. 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 | DWN | APVD |
| | | C | | ECR-18-006131 | 22APR2018 | TB | JDG |
| | | D | | ECR-19-005482 | 04APR2019 | JAH | CT |
| | | E | | ECR-20-009317 | 02JUL2020 | FZ | RK |
| | | E1 | | ECR-20-015405 | 29OCT2020 | FJ | RK |

| | | | | | | | | |
|---|-----|-----|-----|-----|-------------|-------------------------------------|-------------------------------|---------|
| - | 1 | - | 1 | - | 2119641-1 | FEED CAM, AIR FEED | 248 | |
| - | 1 | 1 | 1 | 1 | 2119082-9 | 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 | 18023-1 | SCR, SKT HD CAP M3 X 5.0 | 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 | 1-18028-2 | WASHER, FLAT, REG M4 | 119 | |
| - | 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 | 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 | 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 | 2168083-3 | SCR, SKT HD CAP, RoHS, M4 X 12.0 | 53 | |
| - | 1 | 1 | 1 | 1 | 1803382-2 | 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 | 1-1752356-6 | SUPPORT, TERMINAL | 34 | |
| - | 2 | 2 | 2 | 2 | 2079383-5 | SCR, BHSC, RoHS (M4 X 20) | 33 | |
| - | 2 | 2 | 2 | 2 | 2-2844962-4 | SPACER, CYLINDRICAL, STRIP GUIDE | 30 | |
| - | 1 | 1 | 1 | 1 | 2844992-2 | ASSEMBLY, STRIP GUIDE | 29 | |
| - | 1 | 1 | 1 | 1 | 455888-8 | 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 | |
| - | 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 | 1803095-5 | FLOATING SHEAR, FRONT | 9 | |
| - | 1 | 2 | 2 | 1 | 1 | 4-1333202-5 | ANVIL, COMBINATION | 8 |
| - | 1 | 1 | 1 | 1 | 240641-7 | SPACER | 7 | |
| - | - | - | - | - | - | - | 6 | |
| - | 1 | 1 | 1 | 1 | 2119757-6 | DEPRESSOR, SHEAR | 5 | |
| - | 1 | 1 | 1 | 1 | 238011-4 | BLOCK, CRIMPER SPACER | 4 | |
| - | 1 | 2 | 2 | 1 | 1 | 1633965-4 | CRIMPER, INSULATION O PREMIUM | 3 |
| - | 1 | 1 | 1 | 1 | 455888-3 | SPACER, CRIMPER | 2 | |
| - | 1 | 2 | 2 | 1 | 1 | 1-456403-3 | CRIMPER, WIRE PREMIUM | 1 |
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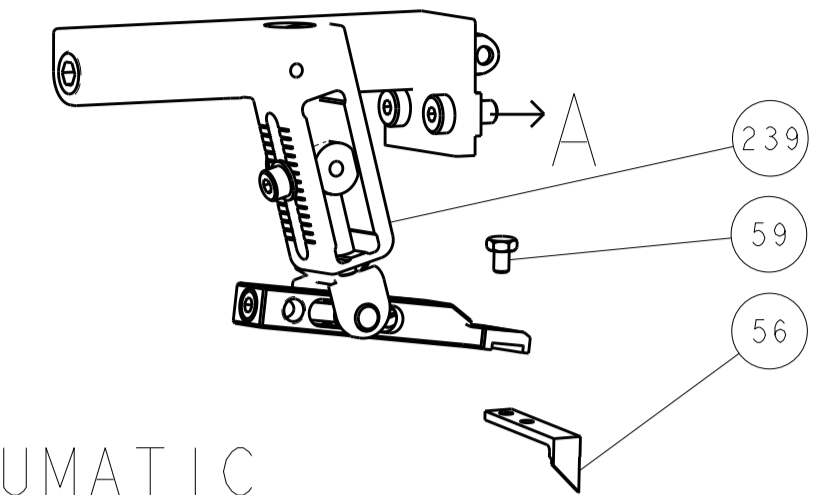
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|-------------|---------|--|---------|-----------|---------|---------|--------|
| mm | 0 PLC ± | 1 PLC ± | 2 PLC ± | 3 PLC ± | 4 PLC ± | ANGLES | FINISH |
| | | | | | | | |

| | | | |
|--|----------------------------|------------|---------------------------|
| OWN | L. ZHANG | 04NOV2011 | TE Connectivity |
| CHK | L. ZHANG | 04NOV2011 | Harrisburg, PA 17105-3608 |
| APVD | S. XI | 04NOV2011 | |
| NAME | Ocean Side Feed Applicator | | |
| PRODUCT SPEC | | | |
| APPLICATION SPEC | | | |
| SIZE | CAGE CODE | DRAWING NO | RESTRICTED TO |
| A1 | 00779 | 2151344 | |
| Customer Accessible Production Drawing | | SCALE | SHEET 1 OF 4 |
| | | REV | E1 |

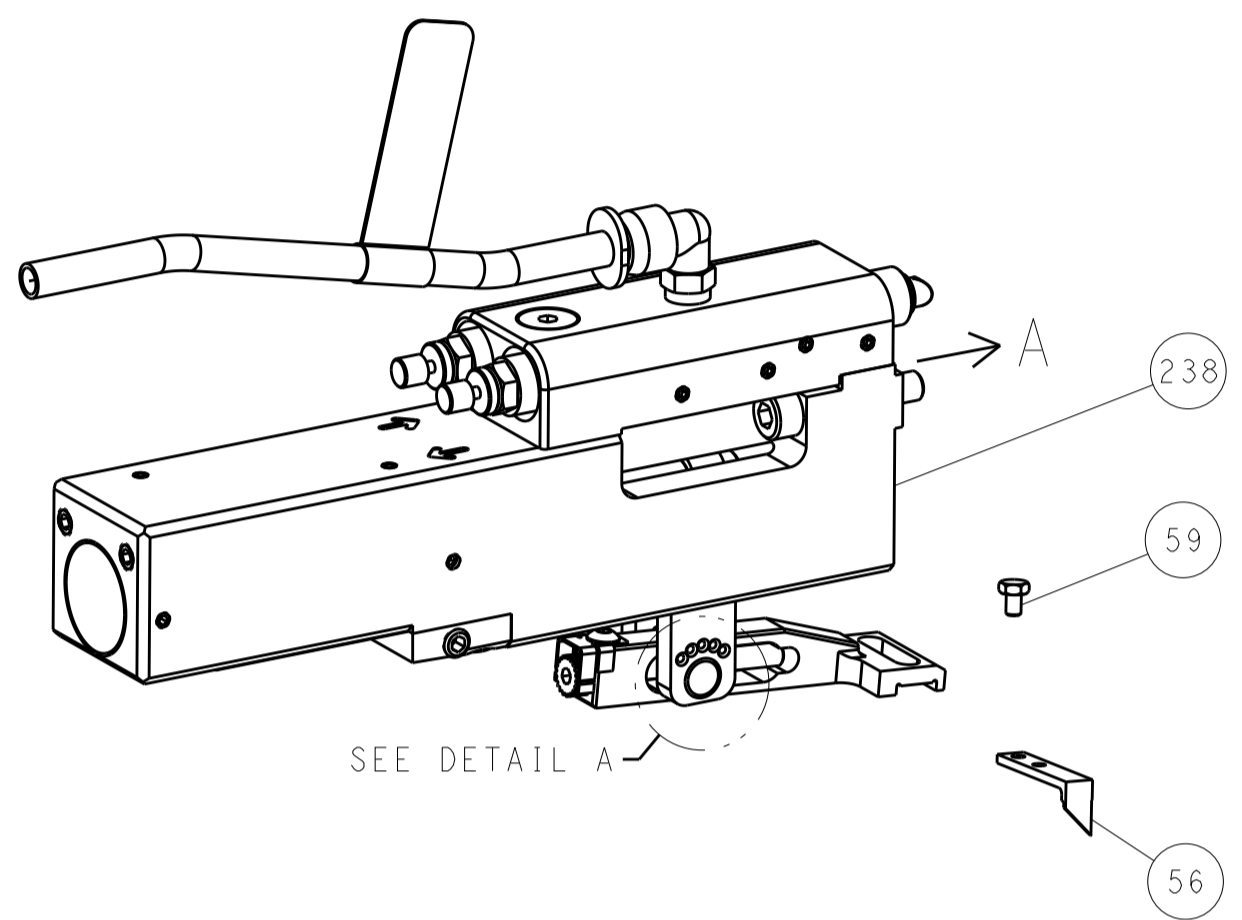
| LOC | DIST | REV | DATE | BY | APP'D |
|-----|------|-----|------|----|-------|
| A | 66 | | | | |

| REVISIONS | | | |
|-----------|------|-------------|----|
| REV | DATE | DESCRIPTION | BY |
| - | - | SEE SHEET 1 | - |

FEED TYPE MECHANICAL



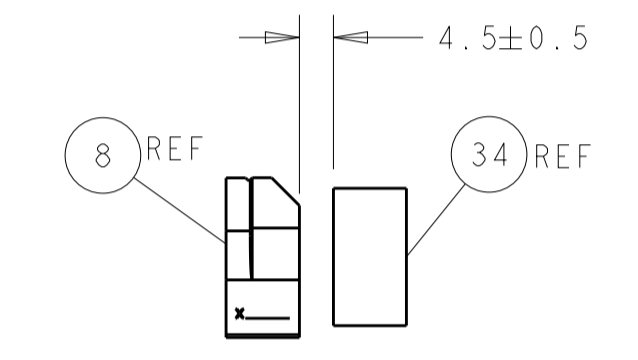
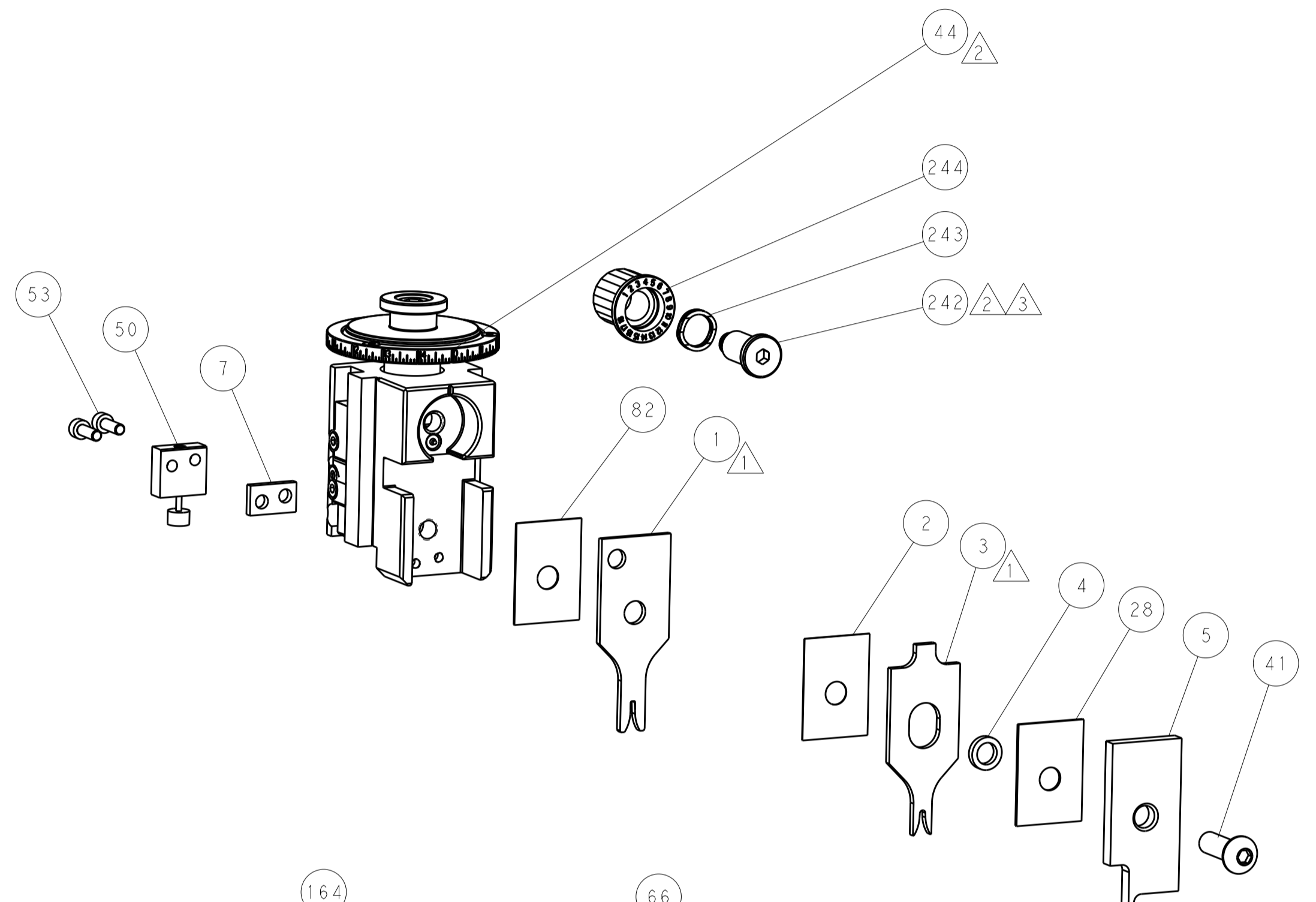
PNEUMATIC



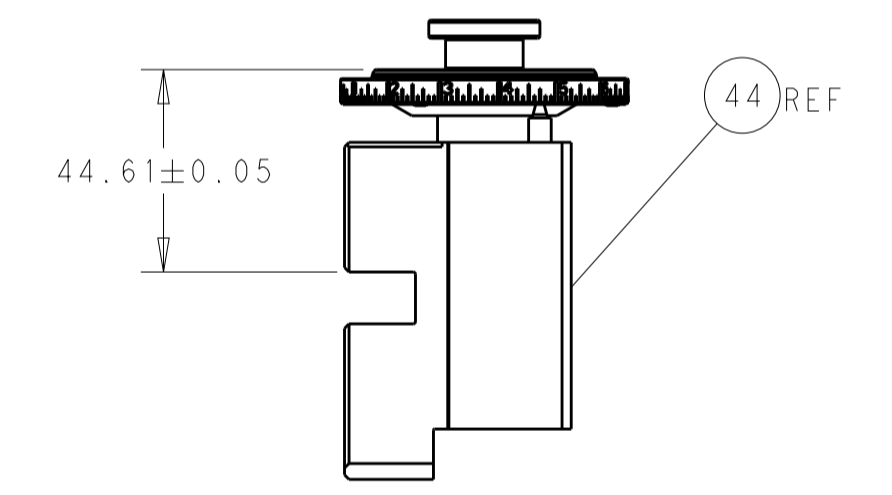
FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



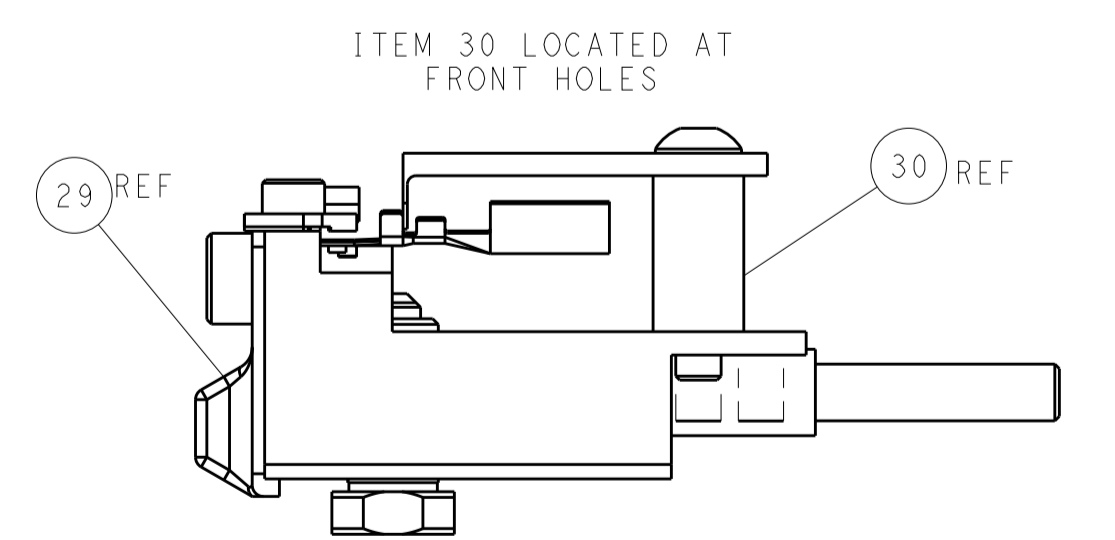
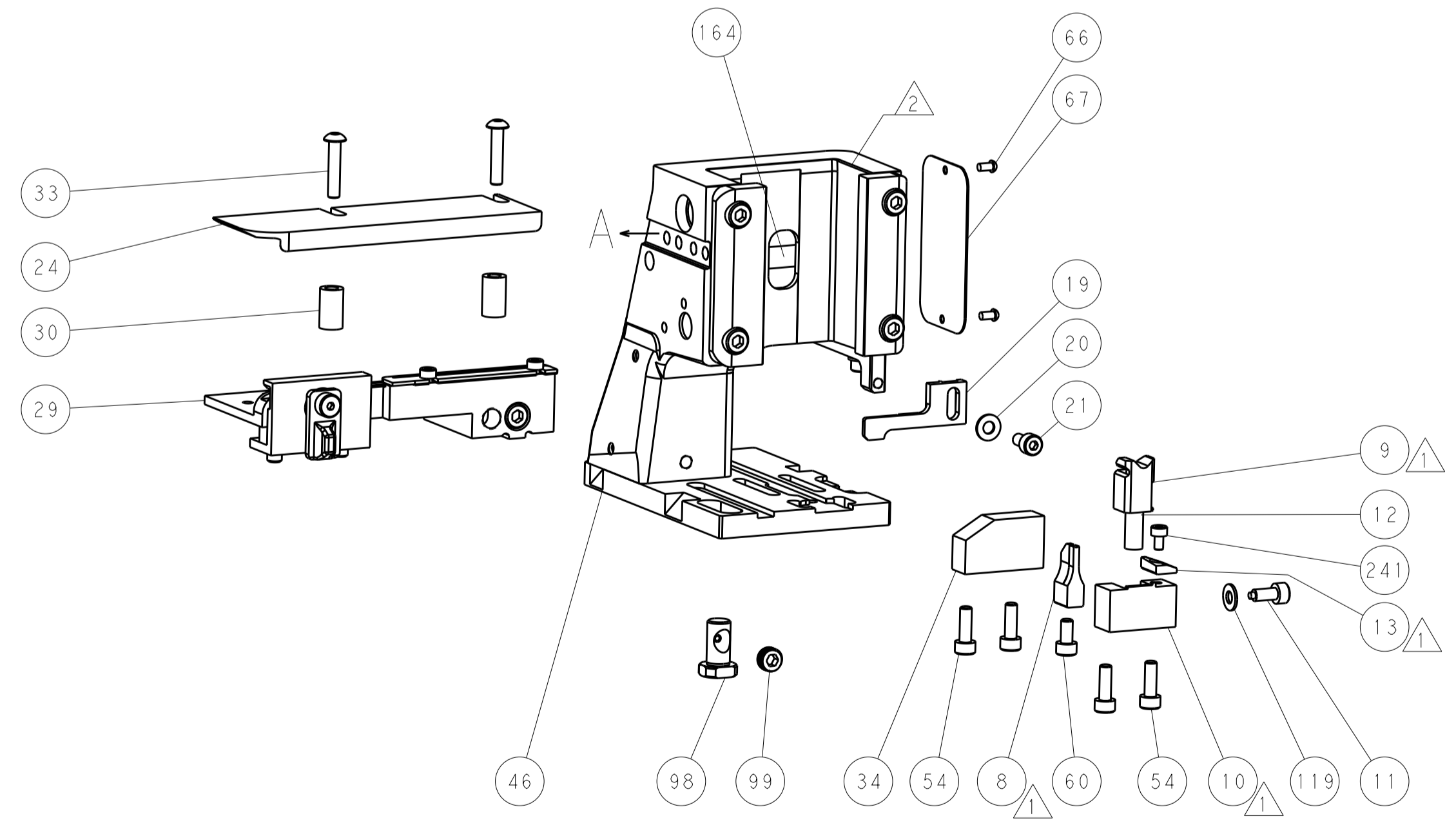
DETAIL A



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)

| | | | | | | | |
|-------------|---------|--|---------|----------------------------------|---------|----------------------|---------------------------|
| DIMENSIONS: | | TOLERANCES UNLESS OTHERWISE SPECIFIED: | | DWN L. ZHANG 04NOV2011 | | TE Connectivity | |
| mm | 0 PLC ± | 1 PLC ± | 2 PLC ± | 3 PLC ± | 4 PLC ± | APVD S. XI 04NOV2011 | Harrisburg, PA 17105-3608 |
| MATERIAL: | | FINISH: | | NAME: Ocean Side Feed Applicator | | RESTRICTED TO: | |
| | | | | SIZE: A1 | | CAGE CODE: 00779 | |
| | | | | DRAWING NO: 2151344 | | SCALE: 1:2 | |
| | | | | SHEET: 2 of 4 | | REV: E1 | |

| PART NUMBER | REVISION | DESCRIPTION | FEED TYPE |
|-------------|----------|--------------------------|------------|
| 2-2151344-1 | E | FINE CRIMP HEIGHT ADJUST | MECHANICAL |
| 2-2151344-2 | E | FINE CRIMP HEIGHT ADJUST | PNEUMATIC |
| 7-2151344-7 | A | CRIMP TOOLING KIT | - |

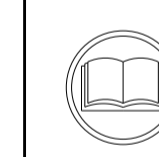
PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



| APPLICATOR DATA | | |
|--------------------------------------|----------------|------|
| CRIMP | SIZE | TYPE |
| WIRE | 1.57 mm [.062] | F |
| INSUL | 2.30 mm [.091] | O |
| APPLICATOR INSTRUCTIONS 408-35042 | | |

| | | | |
|--|-------------|---|-------------|
| TERMINAL DATA: TE TERMINAL | | TE CRIMP SPECIFICATION | |
| TERMINAL NAME: AMP MCP2.8 FLAT TYPE RECEPTACLE | | | |
| WIRE STRIP LENGTH 3.30-3.90 mm [.130-.154 IN] | | INSULATION DIAMETER RANGE Ø1.20-1.40 mm [.047-.055 IN] | |
| TERMINAL APPLICATION SPECIFICATION | 114-18148 | - | - |
| TERMINALS APPLIED | | | |
| TE TERMINAL | TE TERMINAL | TE TERMINAL | TE TERMINAL |
| 1-968880-1 | 1-968880-3 | 1-1355876-1 | |

| WIRE SIZE | CRIMP HEIGHT mm [INCH] | CRIMP HEIGHT REFERENCE SETTING |
|-----------|----------------------------|--------------------------------|
| 0.50mm2 | 1.14+/-0.05 [.045+/-0.002] | 6.1 |
| 0.35mm2 | 1.08+/-0.05 [.043+/-0.002] | 6.6 |
| 0.25mm2 | 1.02+/-0.05 [.040+/-0.002] | 7.3 |
| 0.20mm2 | 1.00+/-0.05 [.039+/-0.002] | 7.5 |



- 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. 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 | REV | DATE | BY | APPV |
|-----|------|-----|------|----|------|
| A | 66 | - | - | - | - |

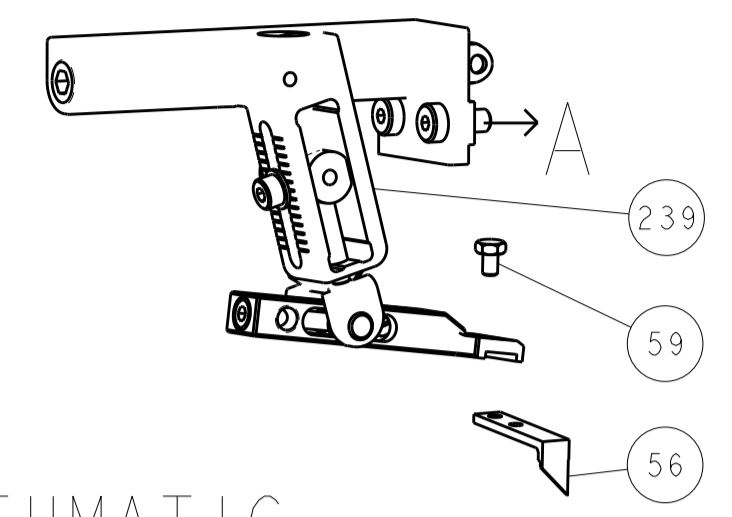
| REV | DATE | BY | APPV | DESCRIPTION | ITEM NO |
|-----|------|-----|-------------|-------------------------------------|---------|
| - | - | - | - | SEE SHEET 1 | - |
| - | 1 | 1 | 2119082-9 | CAM, SNAIL, INSULATION ADJUSTMENT | 244 |
| - | 1 | 1 | 2079764-1 | WASHER, WAVE SPRING, CREST-TO-CREST | 243 |
| - | 1 | 1 | 2119083-1 | RETAINER, INSULATION DIAL | 242 |
| - | 1 | 1 | 18023-1 | SCR, SKT HD CAP M3 X 5.0 | 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 |
| - | 1 | 1 | 1-18028-2 | WASHER, FLAT, REG M4 | 119 |
| - | 1 | 1 | 2844908-1 | SCREW, LOCKING | 99 |
| - | 1 | 1 | 2844907-1 | POST, LOCKING | 98 |
| - | 1 | 1 | 455888-5 | 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 |
| - | 1 | 1 | 1338685-1 | PAWL, FEED | 56 |
| - | 2 | 2 | 2168083-3 | SCR, SKT HD CAP, RoHS, M4 X 12.0 | 53 |
| - | 1 | 1 | 1803382-2 | 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 | 1-1752356-6 | SUPPORT, TERMINAL | 34 |
| - | 2 | 2 | 2079383-5 | SCR, BHSC, RoHS (M4 X 20) | 33 |
| - | 2 | 2 | 2-2844962-4 | SPACER, CYLINDRICAL, STRIP GUIDE | 30 |
| - | 1 | 1 | 2844992-2 | ASSEMBLY, STRIP GUIDE | 29 |
| - | 1 | 1 | 455888-8 | SPACER, CRIMPER | 28 |
| - | 1 | 1 | 1320928-2 | STRIP GUIDE | 24 |
| - | 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 |
| - | 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 | 1803095-5 | FLOATING SHEAR, FRONT | 9 |
| - | 1 | 1 | 4-1333202-5 | ANVIL, COMBINATION | 8 |
| - | 1 | 1 | 240641-7 | SPACER | 7 |
| - | - | - | - | - | 6 |
| - | 1 | 1 | 2119757-6 | DEPRESSOR, SHEAR | 5 |
| - | 1 | 1 | 238011-4 | BLOCK, CRIMPER SPACER | 4 |
| - | 1 | 1 | 1633965-4 | CRIMPER, INSULATION O PREMIUM | 3 |
| - | 1 | 1 | 455888-3 | SPACER, CRIMPER | 2 |
| - | 1 | 1 | 1-456403-3 | CRIMPER, WIRE PREMIUM | 1 |
| -77 | -22 | -21 | PART NO | DESCRIPTION | ITEM NO |

PACIFIC VERSION
Shown on sheets 3 of 4 & 4 of 4
(Atlantic version shown on sheets 1 of 4 & 2 of 4)

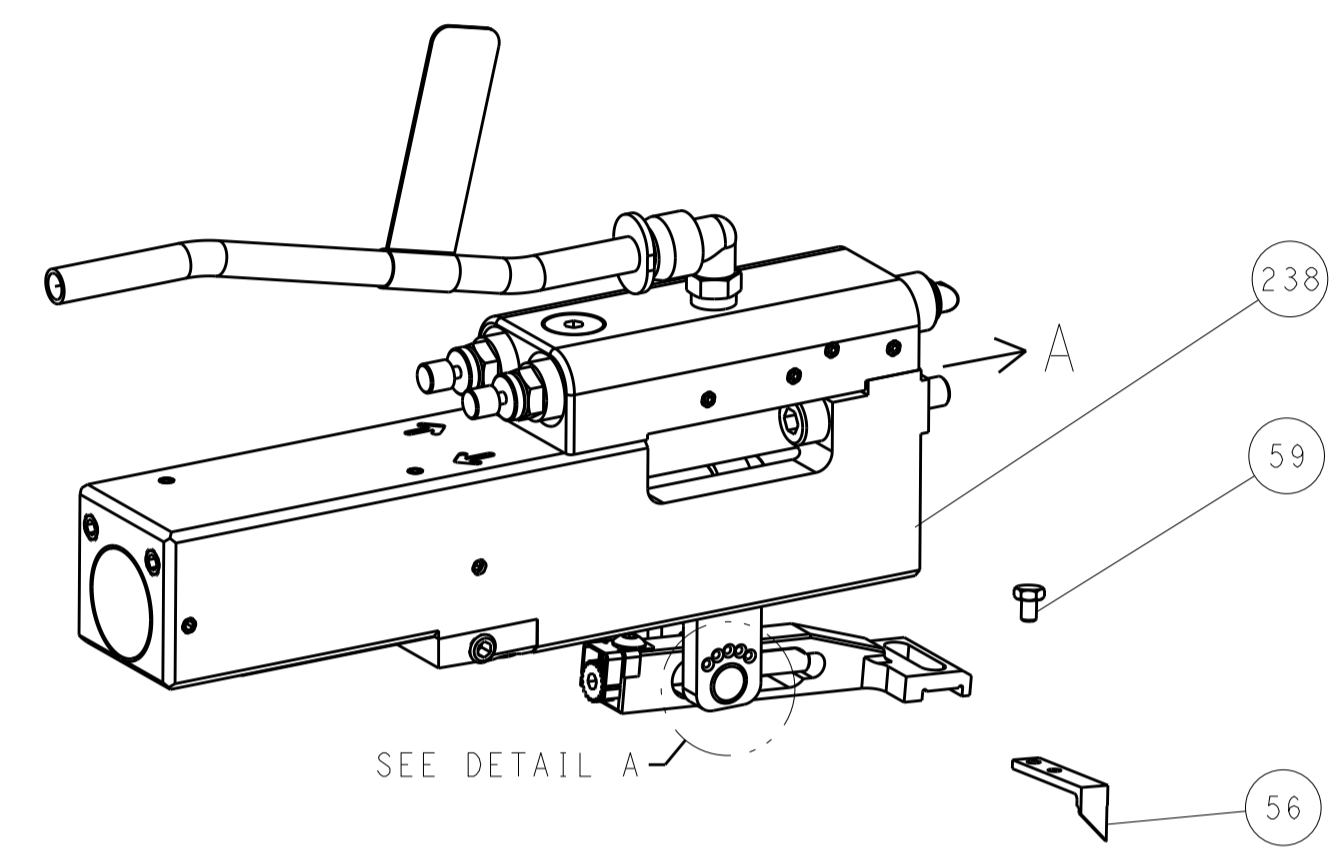
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|--|---------|--|---------|---------------------------|---------|
| DIMENSIONS: | | TOLERANCES UNLESS OTHERWISE SPECIFIED: | | DWN L. ZHANG 04NOV2011 | |
| mm | 0 PLC ± | 1 PLC ± | 2 PLC ± | 3 PLC ± | 4 PLC ± |
| ANGLES | FINISH | | | CHK L. ZHANG 04NOV2011 | |
| MATERIAL | | | | APPV S. XI 04NOV2011 | |
| Customer Accessible Production Drawing | | SCALE 1:2 | | SHEET 3 OF 4 | |

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

FEED TYPE MECHANICAL



PNEUMATIC

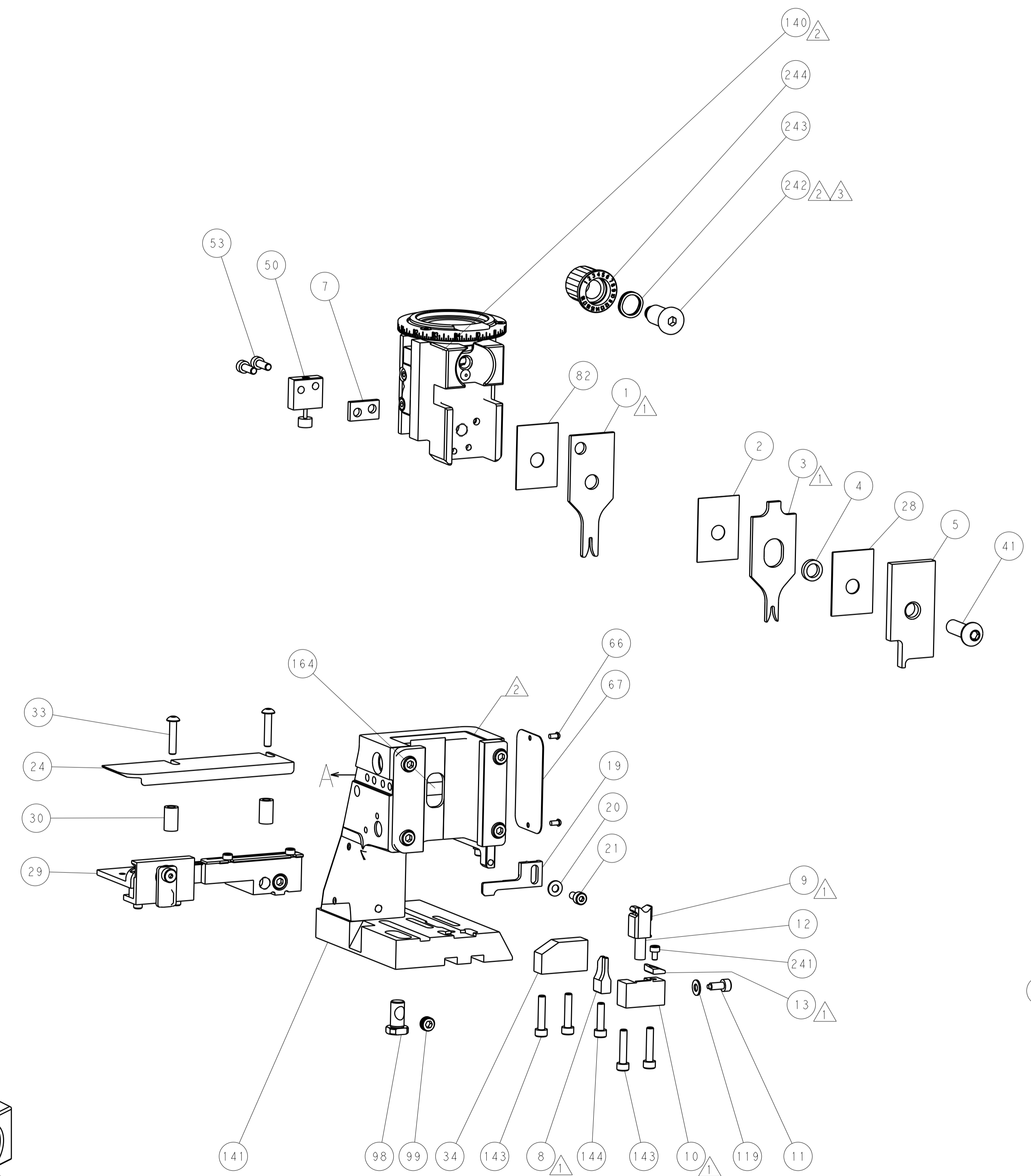
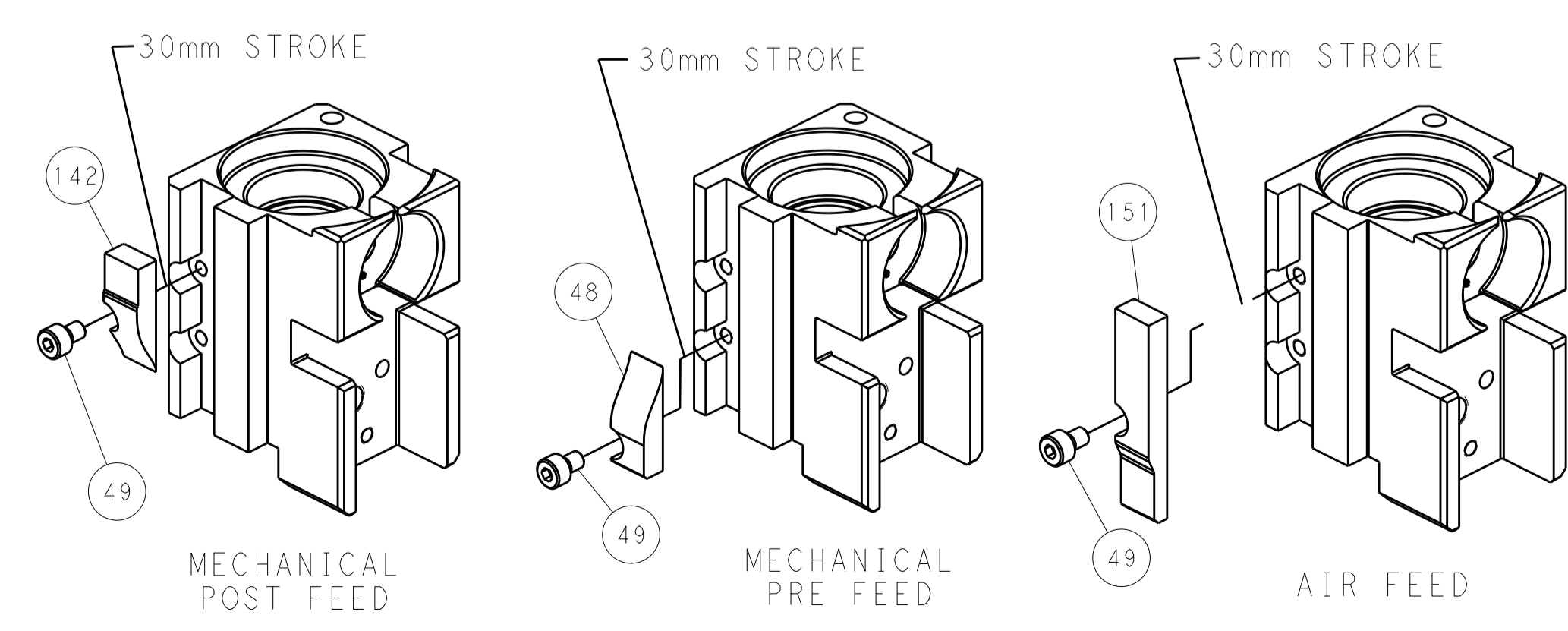


FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)

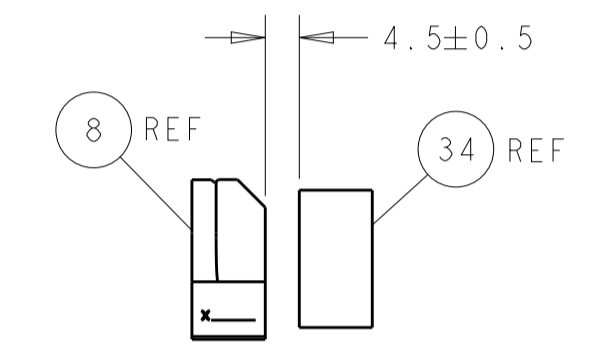


DETAIL A

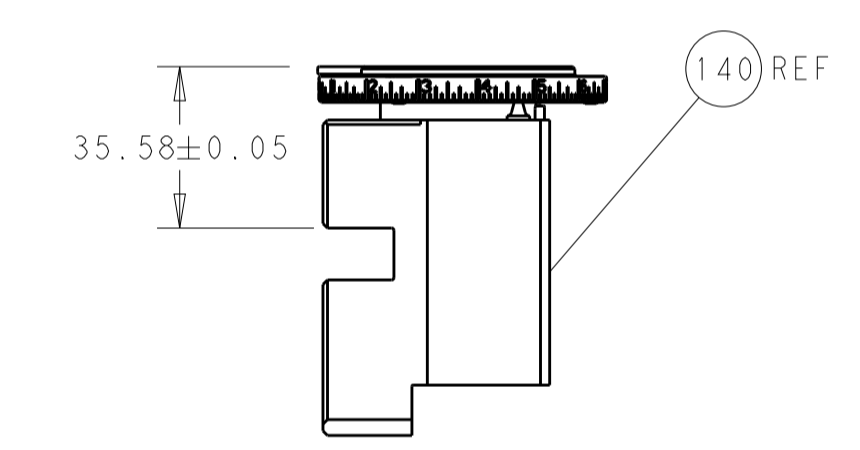
CAM POSITIONS



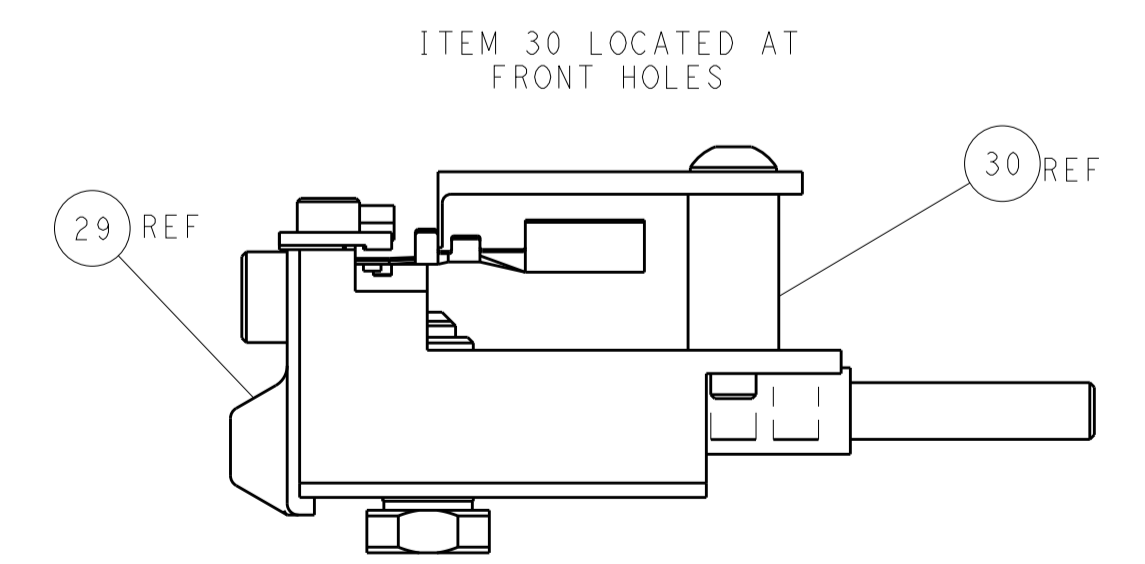
PACIFIC VERSION
 Shown on sheets 3 of 4 & 4 of 4
 (Atlantic version shown on sheets 1 of 4 & 2 of 4)



TERMINAL SUPPORT LOCATION



RAM SET-UP



FEED TRACK POSITION GUIDE BY INSULATION BARREL

| | | | | | |
|-----------------------|--|---|--|---|--|
| DIMENSIONS: mm | | TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± | | DWN L. ZHANG 04NOV2011 CHK L. ZHANG 04NOV2011 S. XI 04NOV2011 NAME PRODUCT SPEC APPLICATION SPEC SIZE CAGE CODE DRAWING NO A1 00779 C=2151344 RESTRICTED TO | |
| MATERIAL FINISH | | WEIGHT SCALE 1:2 SHEET 4 OF 4 REV E1 | | CUSTOMER ACCESSIBLE PRODUCTION DRAWING | |