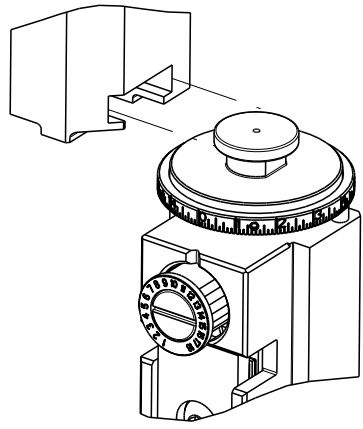





8	7	6	5	4	3	2	1
THIS DRAWING IS UNPUBLISHED.		RELEASED FOR PUBLICATION					
© COPYRIGHT 20		BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.					
PART NUMBER	REVISION	DESCRIPTION	FEED TYPE				
2151037-1	P	FINE CRIMP HEIGHT ADJUST	MECHANICAL				
2151037-2	R	FINE CRIMP HEIGHT ADJUST	PNEUMATIC				
3-2151037-2	R	FINE CRIMP HEIGHT ADJUST	DOUBLE ACTING PNEUMATIC WITH SENSORS				
7-2151037-1	P	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL				
7-2151037-2	R	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC				
7-2151037-7	N	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: MCP 1.2MM CONTACT ASSEMBLY			
WIRE STRIP LENGTH			INSULATION DIAMETER RANGE
3.30-3.90 mm [.130-.154 IN]			Ø1.40-1.90 mm [.055-.075 IN]
TERMINAL APPLICATION SPECIFICATION		114-18464	- -
TERMINALS APPLIED 			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
1452656-1	1452656-2	1452656-3	6-1452656-2
7-1452656-1	7-1452656-2	7-1452656-3	
1718350-1	1718350-2	1718350-3	

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.75mm2	1.05+/-0.03 [.041+/- .001]	6.5
0.50mm2	0.93+/-0.03 [.037+/- .001]	7.5
20 AWG	0.93+/-0.03 [.037+/- .001]	7.5



- 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 THIS APPLICATOR IS EQUIPPED WITH THE DOUBLE ACTING FEED WITH SENSORS AND IS APPLICATION SPECIFIC. IT DOES NOT REQUIRE ITEMS 49 & 248.
7. 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)

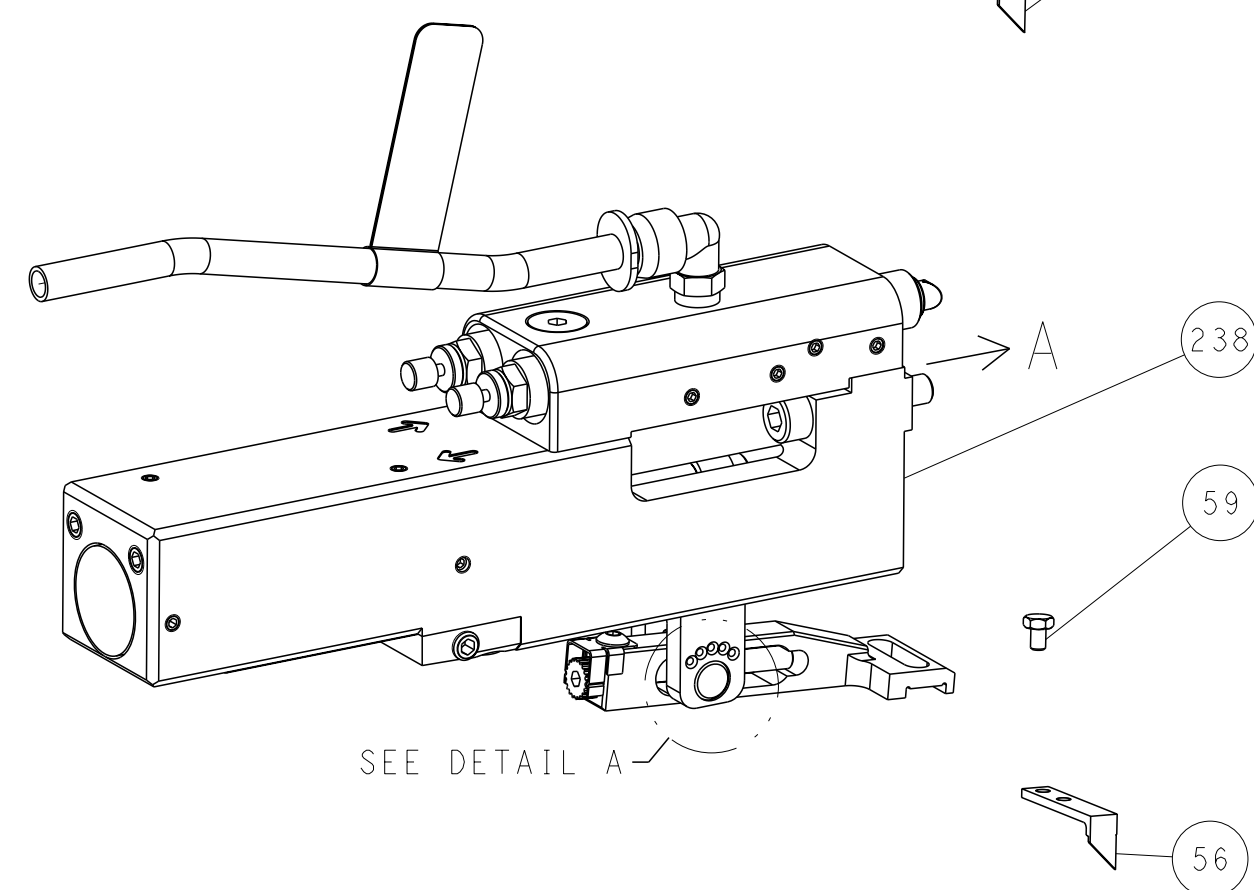
LOC	DIST	REVISIONS					
A	66	P	LYR	DESCRIPTION	DATE	DWN	APVD
			N	ECR-17-010466	19JUL2017	KH	JDG
			P	ECR-18-004053	19MAR2018	JAH	JDG
			R	ECR-19-005393	03APR2019	JAH	CT
			R1	ECR-21-003615	25MAR2021	FZ	YY

-	-	-	1	-	-	2844950-1	AIR FEED MODULE	290
-	1	-	-	1	-	2119641-1	FEED CAM, AIR FEED	248
-	1	1	1	1	1	2119082-5	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	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
-	1	1	1	1	1	1-18028-2	WASHER, FLAT, REG M4	119
-	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
-	2	2	2	2	2	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	57
-	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
-	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
-	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	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	1752356-6	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	1320928-6	STRIP GUIDE	24
-	1	1	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
-	1	1	1	1	1	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	1803095-1	FLOATING SHEAR, FRONT	9
-	1	2	2	1	1	133231-9	ANVIL, COMBINATION, SPECIAL	8
-	1	1	1	1	1	5-240641-0	SPACER	7
-	1	1	1	1	1	2119757-8	DEPRESSOR, SHEAR	5
-	1	1	1	1	1	4-238011-2	BLOCK, CRIMPER SPACER	4
-	1	2	2	1	1	1633989-1	CRIMPER, INSULATION, SPECIAL	3
-	1	2	2	1	1	3-456402-3	CRIMPER, WIRE PREMIUM	1
-	77	-72	-71	-32	-2	-1	PART NO	ITEM NO
							DESCRIPTION	

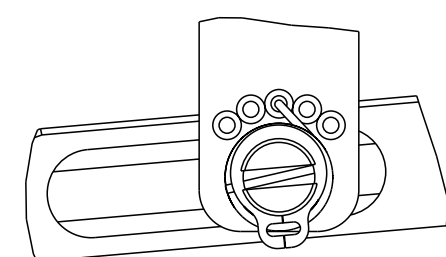
THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE AND TO BE OBSOLETE WITHOUT NOTICE. FOR THE LATEST REVISION, CONTACT THE ENGINEERING ORGANIZATION. SHOULD BE CONTACTED FOR THE LATEST REVISION.				DWN C. CHEN 08SEP2011	TE Connectivity Harrisburg, PA 17105-3608			
DIMENSIONS: mm				CHK S. XI 08SEP2011	NAME Ocean Side Feed Applicator			
TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±				APVD J. CRUZ 08SEP2011	SIZE CAGE CODE DRAWING NO RESTRICTED TO			
MATERIAL -				PRODUCT SPEC -	100779 ©=2151037			
FINISH -				APPLICATION SPEC -	Customer Accessible Production Drawing			
				WEIGHT -	SCALE 1:2 SHEET 1 OF 4 REV R1			

SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

PNEUMATIC

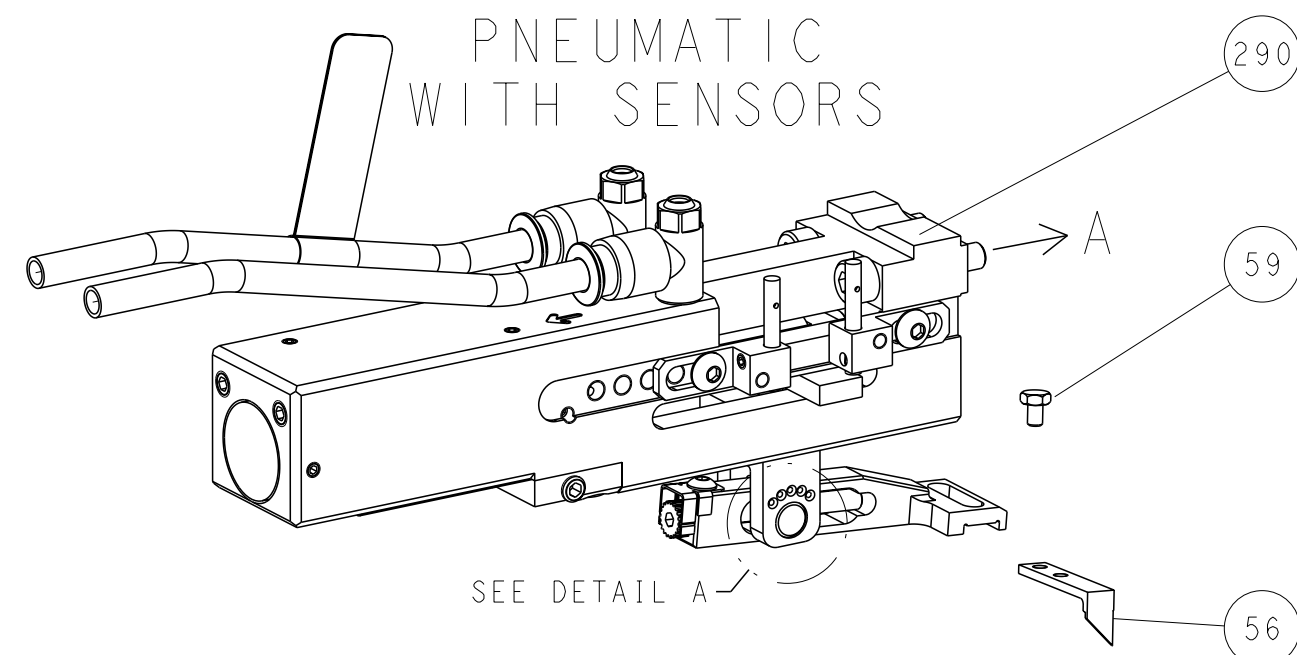


FEED SPRING SETTING POSITION
(SHOWN FROM REAR SIDE)

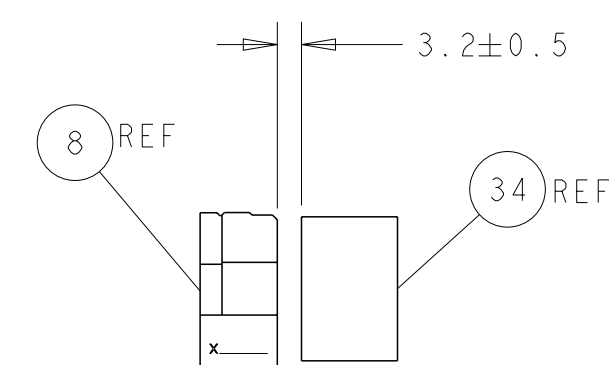
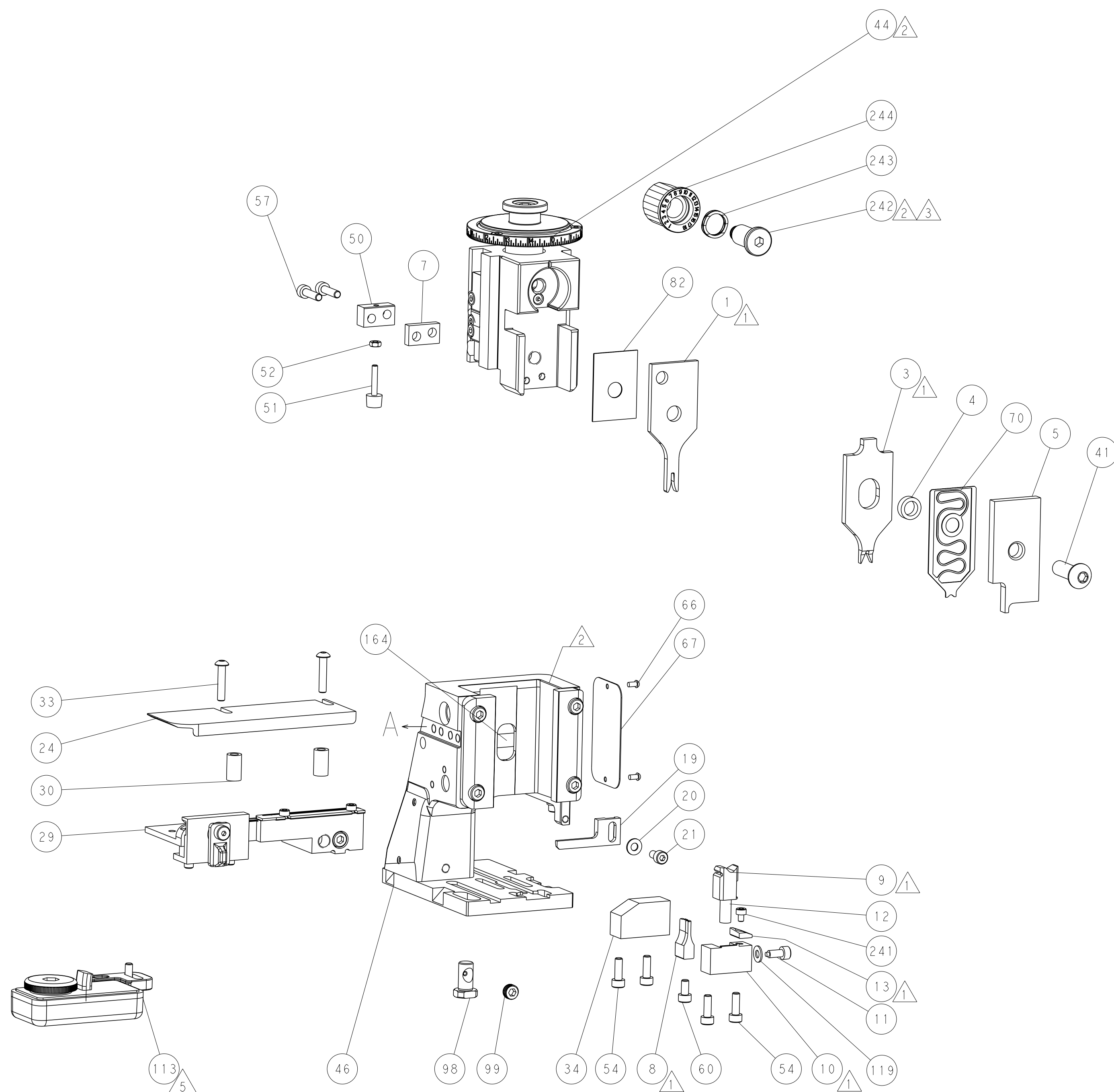
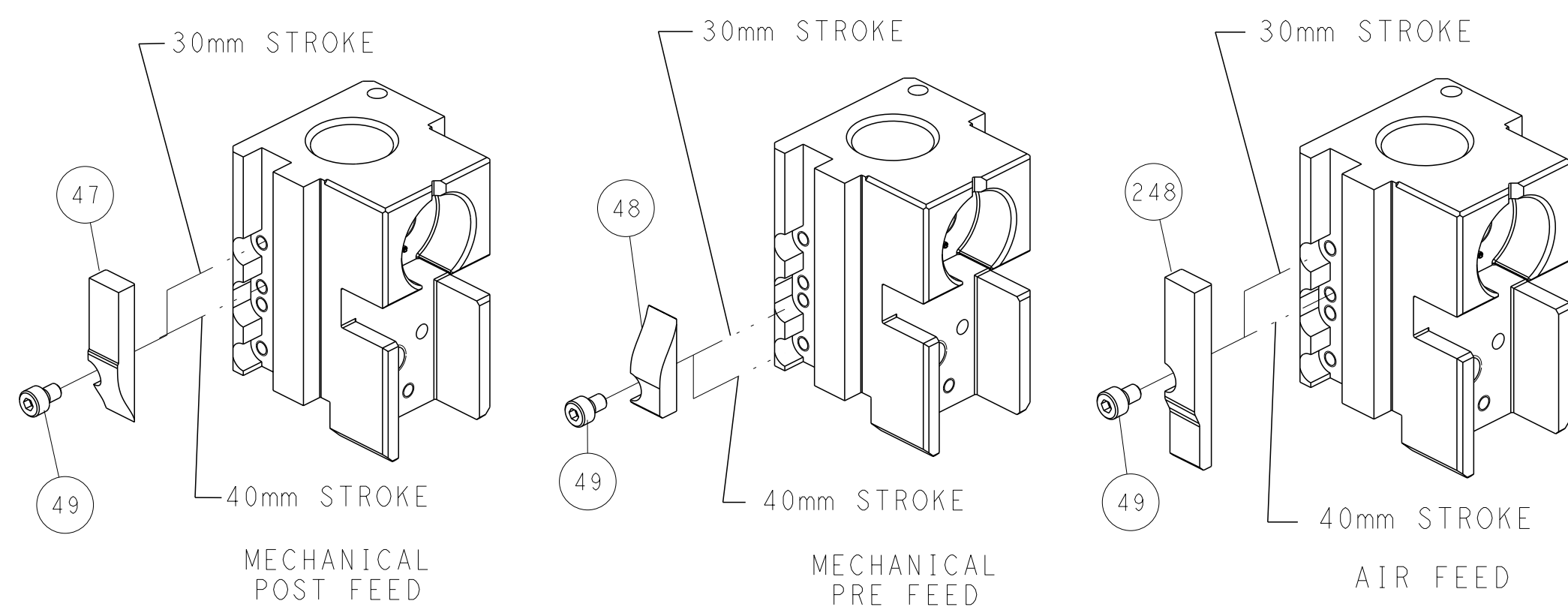


DETAIL A

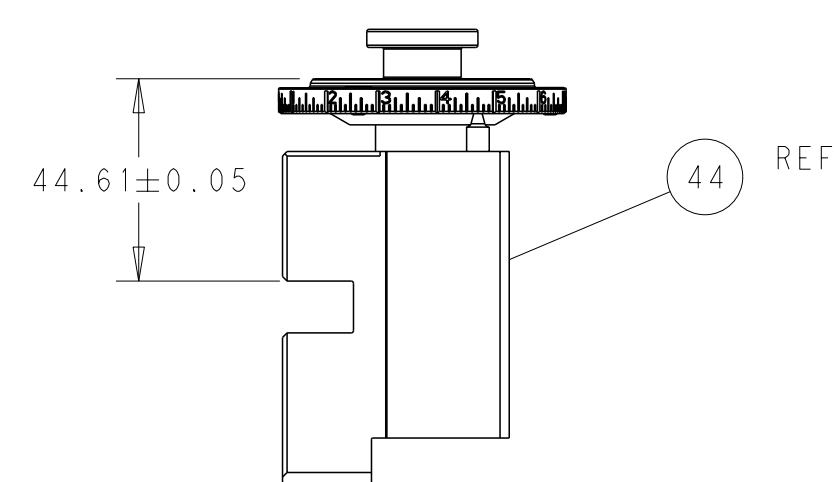
DOUBLE ACTING
PNEUMATIC
WITH SENSORS



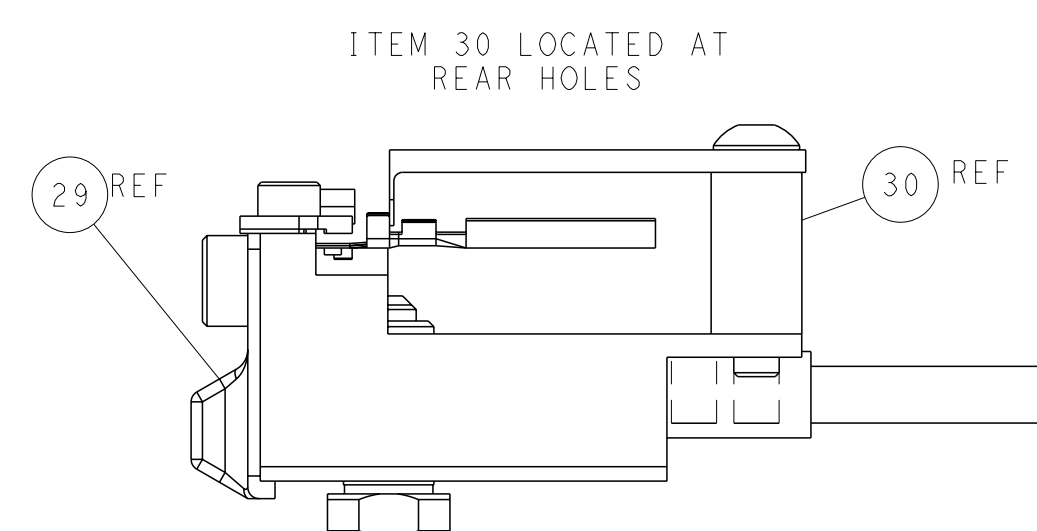
CAM POSITIONS



TERMINAL SUPPORT LOCATION




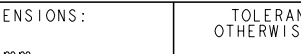
RAM SET-UP



FEED TRACK POSITION GUIDE BY INSULATION BARREL

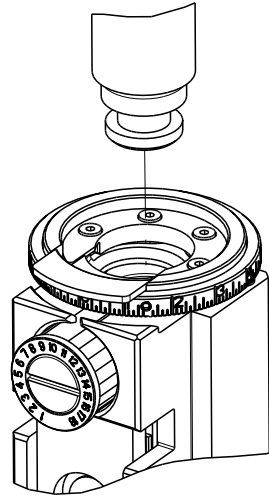
ATLANTIC VERSION

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

<small>*131 DRAWING IS A CONTROLLED DOCUMENT FOR THE INFORMATION OF THE CUSTOMER. THIS DOCUMENT IS THE PROPERTY OF THE ORGANIZATION AND SHOULD BE RETURNED TO THE ORIGINATOR FOR THE LATEST REVISION.</small>		<small>DWN</small> 08SEP2011 <small>CHK</small> C. CHEN 08SEP2011 <small>S.I.</small> 08SEP2011 <small>APVD</small> I. CRUZ 08SEP2011		 TE Connectivity Harrisburg, PA 17105-3608	
<small>DIMENSIONS:</small> mm		<small>TOLERANCES UNLESS OTHERWISE SPECIFIED:</small> 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		<small>NAME</small> Ocean Side Feed Applicator	
		<small>PRODUCT SPEC</small> - <small>APPLICATION SPEC</small> -		<small>SIZE</small> A <small>CAGE CODE</small> 00779 <small>DRAWING NO</small> C=2151037	
<small>MATERIAL</small> -		<small>FINISH</small> -		<small>RESTRICTED TO</small> -	
Customer Accessible Production Drawing				SCALE 1:2 SHEET 2 of 4 REV R	

8	7	6	5	4	3	2	1
THIS DRAWING IS UNPUBLISHED.		RELEASED FOR PUBLICATION					
© COPYRIGHT 20		BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.					
PART NUMBER	REVISION	DESCRIPTION	FEED TYPE				
2-2151037-1	P	FINE CRIMP HEIGHT ADJUST	MECHANICAL				
2-2151037-2	R	FINE CRIMP HEIGHT ADJUST	PNEUMATIC				
4-2151037-2	R	FINE CRIMP HEIGHT ADJUST	DOUBLE ACTING PNEUMATIC WITH SENSORS				
7-2151037-7	N	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: MCP 1.2MM CONTACT ASSEMBLY				
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE		
3.30-3.90 mm [.130-.154 IN]		Ø1.40-1.90 mm [.055-.075 IN]		
TERMINAL APPLICATION SPECIFICATION	114-18464	-	-	-
TERMINALS APPLIED				
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL	
1452656-1	1452656-2	1452656-3	6-1452656-2	
7-1452656-1	7-1452656-2	7-1452656-3		
1718350-1	1718350-2	1718350-3		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.75mm2	1.05+/-0.03 [.041+/- .001]	6.5
0.50mm2	0.93+/-0.03 [.037+/- .001]	7.5
20 AWG	0.93+/-0.03 [.037+/- .001]	7.5



- 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 THIS APPLICATOR IS EQUIPPED WITH THE DOUBLE ACTING FEED WITH SENSORS AND IS APPLICATION SPECIFIC. IT DOES NOT REQUIRE ITEMS 49 & 151.
7. 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
8-2151037-1	2151037-1	1	WIRE CRIMPER	3-1803530-3
8-2151037-2	2151037-2	3	INSULATION CRIMPER	1803623-1
9-2151037-1	2-2151037-1	46	BASIC SUB -ASSEMBLY	1803940-9
9-2151037-2	2-2151037-2	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				
		P	LYR	DESCRIPTION	DATE	OWN
A	66	-	-	SEE SHEET 1	-	-

-	1	-	-	2844950-1	AIR FEED MODULE	290
-	1	1	1	2119082-5	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	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
-	-	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
-	1	1	1	1-18028-2	WASHER, FLAT, REG M4	119
-	1	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
-	2	2	2	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	57
-	1	1	1	1338685-1	PAWL, FEED	56
-	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
-	-	1	2	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	1752356-6	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	1320928-6	STRIP GUIDE	24
-	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
-	1	1	1	1-18028-2	WASHER, FLAT, REG M4	20
-	1	1	1	2119533-1	STRIPPER, SIDE FEED	19
-	1	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	1	2119805-1	SHEAR HOLDER, FRONT	10
-	1	1	1	1803095-1	FLOATING SHEAR, FRONT	9
-	1	1	1	1333231-9	ANVIL, COMBINATION, SPECIAL	8
-	1	1	1	5-240641-0	SPACER	7
-	1	1	1	2119757-8	DEPRESSOR, SHEAR	5
-	1	1	1	4-238011-2	BLOCK, CRIMPER SPACER	4
-	1	1	1	1633989-1	CRIMPER, INSULATION, SPECIAL	3
-	1	1	1	3-456402-3	CRIMPER, WIRE PREMIUM	1
-77	-42	-22	-21	PART NO	DESCRIPTION	ITEM NO

THIS DRAWING IS CONTROLLED FOR THE ENTIRE PRODUCT LIFE CYCLE. ANY CHANGES TO THE DESIGN OR CONSTRUCTION OF THE PRODUCT MUST BE APPROVED BY THE DESIGN ENGINEER AND THE MANUFACTURING ENGINEER. ANY CHANGES TO THE DRAWING MUST BE APPROVED BY THE DESIGN ENGINEER AND THE MANUFACTURING ENGINEER. ANY CHANGES TO THE DRAWING MUST BE APPROVED BY THE DESIGN ENGINEER AND THE MANUFACTURING ENGINEER.				OWN S. CHEN 08SEP2011	TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm				CHK S. XI 08SEP2011		
TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH ±				APVD J. CRUZ 08SEP2011	NAME Ocean Side Feed Applicator	
MATERIAL -				PRODUCT SPEC -	SIZE 00779	
				APPLICATION SPEC -	CAGE CODE -	
				WEIGHT -	DRAWING NO 2151037	
				RESTRICTED TO -	Customer Accessible Production Drawing	
				SCALE 1:2	SHEET 3 OF 4	
				REV R1		

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

D

C

B

A

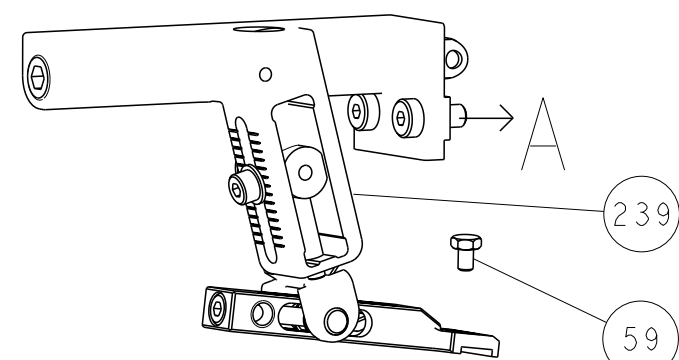
D

C

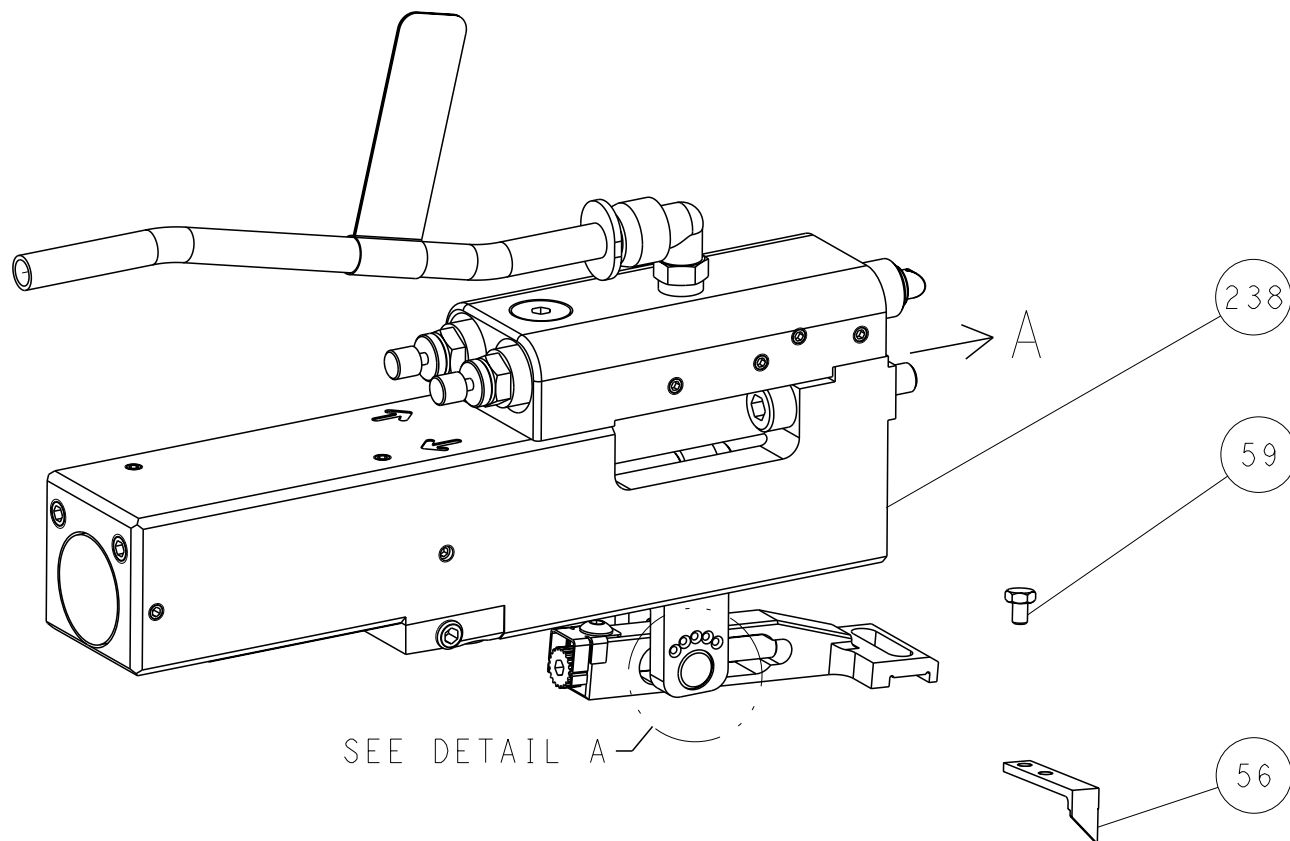
B

A

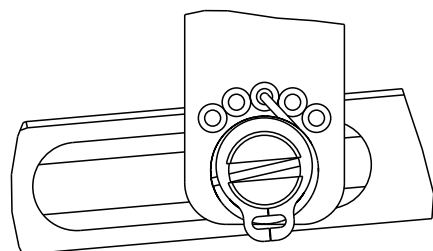
FEED TYPE MECHANICAL



PNEUMATIC

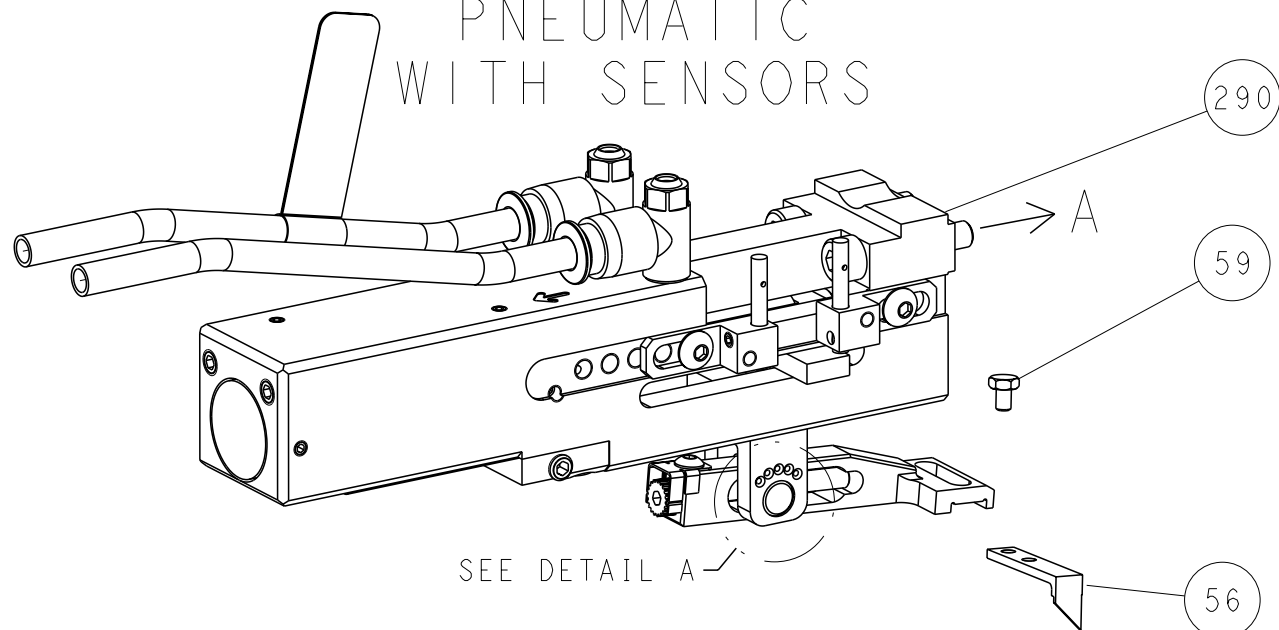


FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)

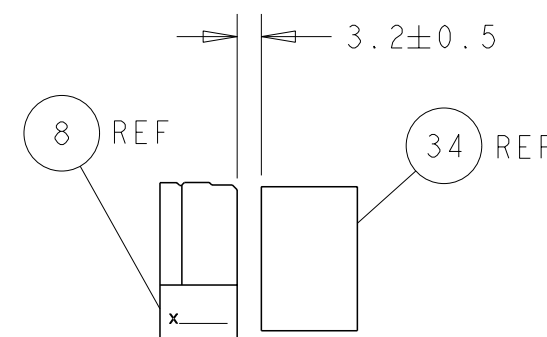
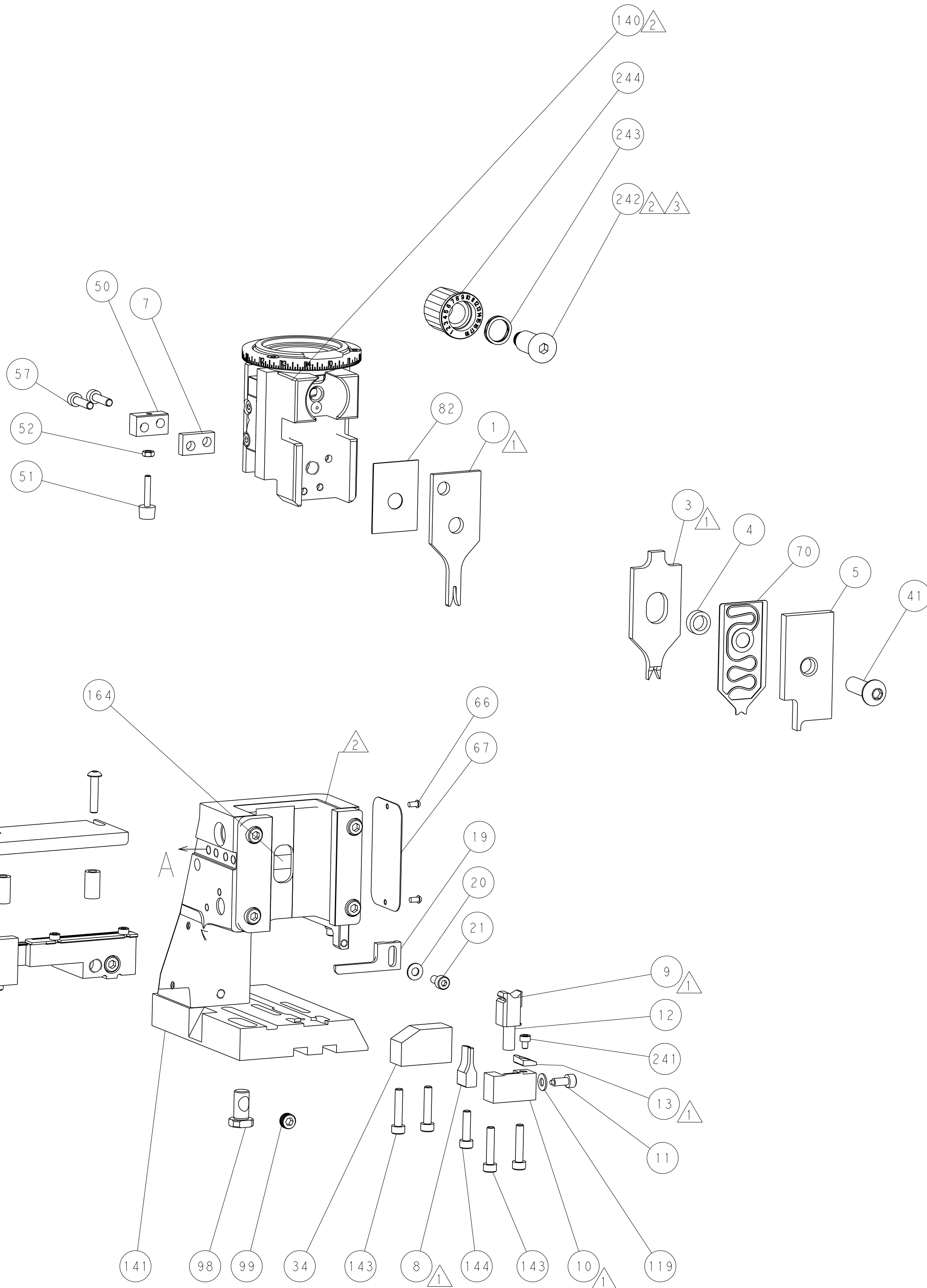
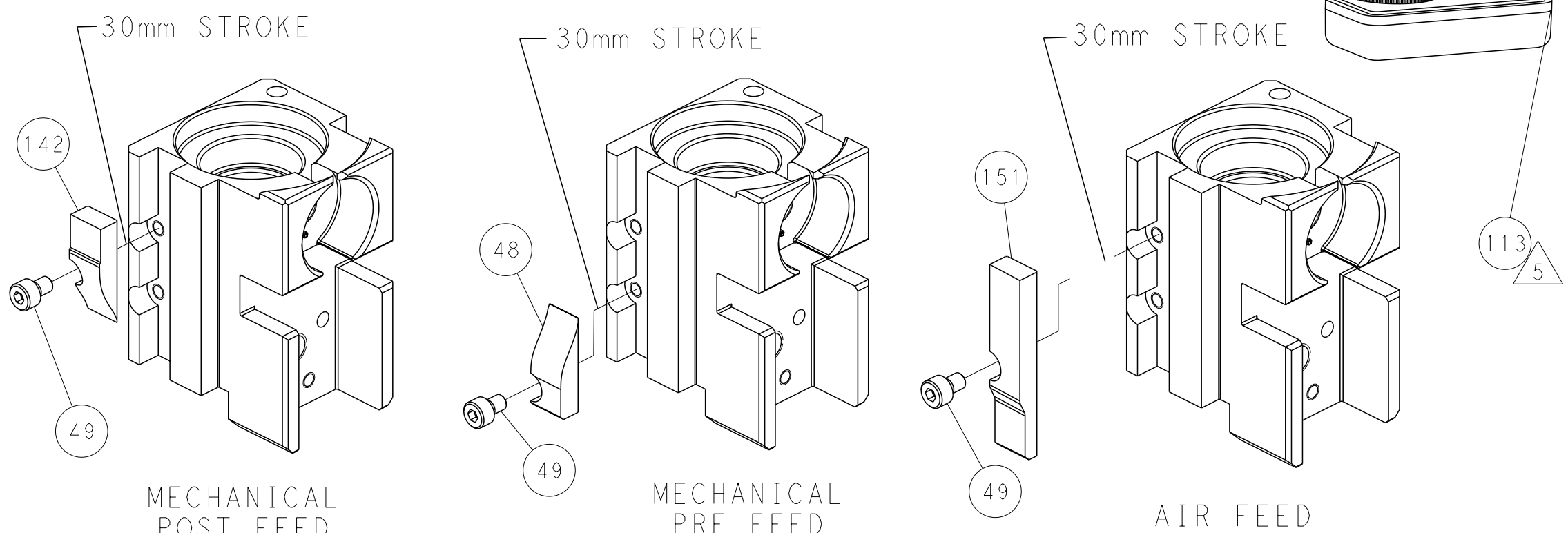


DETAIL A

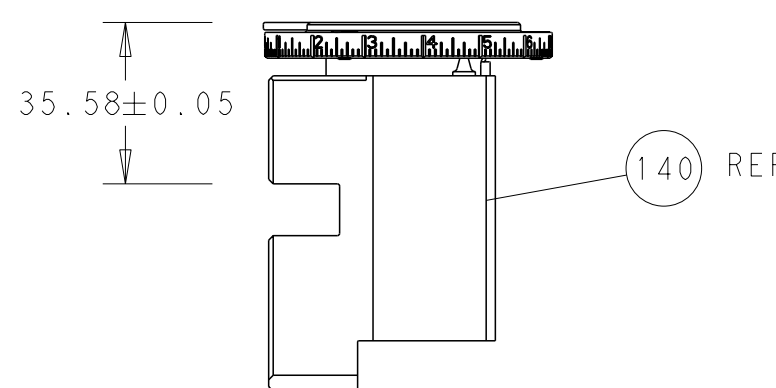
DOUBLE ACTING PNEUMATIC WITH SENSORS



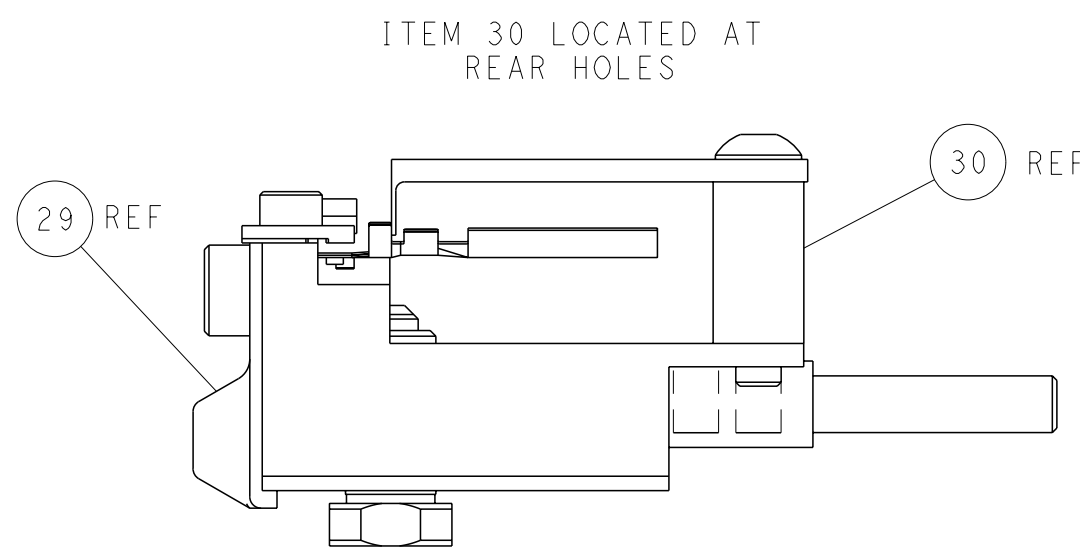
CAM POSITIONS



TERMINAL SUPPORT LOCATION




RAM SET-UP



FEED TRACK POSITION GUIDE BY INSULATION BARREL

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

THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE AND TO CORRECTION. THE USER SHALL BE RESPONSIBLE FOR OBTAINING THE LATEST REVISION. SHOULD BE CONTACTED FOR THE LATEST REVISION.		DWN C. CHEN	08SEP2011	 TE Connectivity Harrisburg, PA 17105-3608	
		CHK S. XI	08SEP2011		
		APVD J. CRUZ	08SEP2011	NAME Ocean Side Feed Applicator	
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		PRODUCT SPEC	
		0 PLC ±		APPLICATION SPEC	
		1 PLC ±		-	
		2 PLC ±		-	
		3 PLC ±		-	
		4 PLC ±		-	
		ANGLES		FINISH	
		-		-	
MATERIAL		-		WEIGHT	
-		-		-	
				Customer Accessible Production Drawing	
				SCALE 1:2	
				SHEET 4 OF 4	
				REV R1	

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

Mouser Electronics

Authorized Distributor

Click to View Pricing, Inventory, Delivery & Lifecycle Information:

[TE Connectivity:](#)

[7-2151037-7](#)