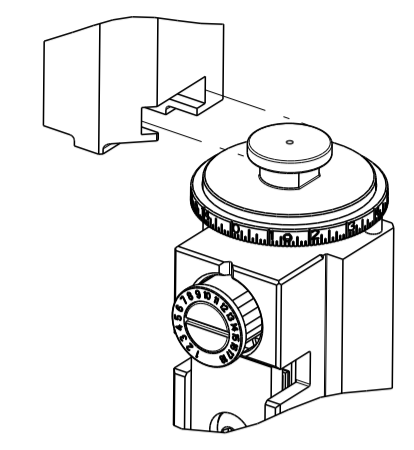


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151064-1	N	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2151064-2	N	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
3-2151064-2	N	FINE CRIMP HEIGHT ADJUST	DOUBLE ACTING PNEUMATIC WITH SENSORS/6
5-2151064-1	N	SEAL STRIPPER CRIMPER TERMINATING UNIT	MECHANICAL
5-2151064-2	N	SEAL STRIPPER CRIMPER TERMINATING UNIT	PNEUMATIC
7-2151064-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA

CRIMP	SIZE	TYPE
WIRE	1.78 mm [.070]	F
INSUL	3.18 mm [.125]	O

APPLICATOR INSTRUCTIONS  
408-35042

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION

TERMINAL NAME: AMP MCP 1.5K SINGLE-WIRE SEALING

WIRE STRIP LENGTH	INSULATION DIAMETER RANGE
3.70-4.30 mm [.146-.169 IN]	Ø1.40-2.10 mm [.055-.083 IN]

TERMINAL APPLICATION SPECIFICATION

TERMINAL	114-18386
APPLICATOR	

TERMINALS APPLIED

TE TERMINAL	TE TERMINAL	TE SEAL	TE SEAL	CABLE Ø
1241380-1	1-1241380-3		964971-1	Ø1.2-1.6mm
1241380-2	2-1241380-3		964972-1	Ø1.9-2.4mm
1241380-3	1534162-1		963530-1	Ø1.4-1.9mm

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.00mm2	1.26+/-0.05 [.050+/- .002]	5.1
0.75mm2	1.15+/-0.05 [.045+/- .002]	6.1
0.50mm2	1.04+/-0.05 [.041+/- .002]	7.3

- 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.
- APPLY TORQ-SEAL IN ALLEN SOCKET TO FILL HOLE AFTER FLAT HD HAS BEEN ADJUSTED TO CORRECT HEIGHT AT QUALIFICATION. APPLY #1-23419-5 LOC-TITE TO THREADS.
- THIS APPLICATOR IS EQUIPPED WITH THE DOUBLE ACTING PNEUMATIC FEED WITH SENORS, AND IS APPLICATION SPECIFIC AND DOES NOT REQUIRE ITEMS 49 & 248.
- TERMINAL LUBRICANT IS RECOMMENDED.

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.

LOC	DIST	REV	DATE	BY	CHK	APPV
A	66	L	15SEP2020	JWC	RK	
		L1	19JAN2021	FZ	YY	
		M	23SEP2021	FZ	TE	
		N	21MAR2024	MEH	GB	

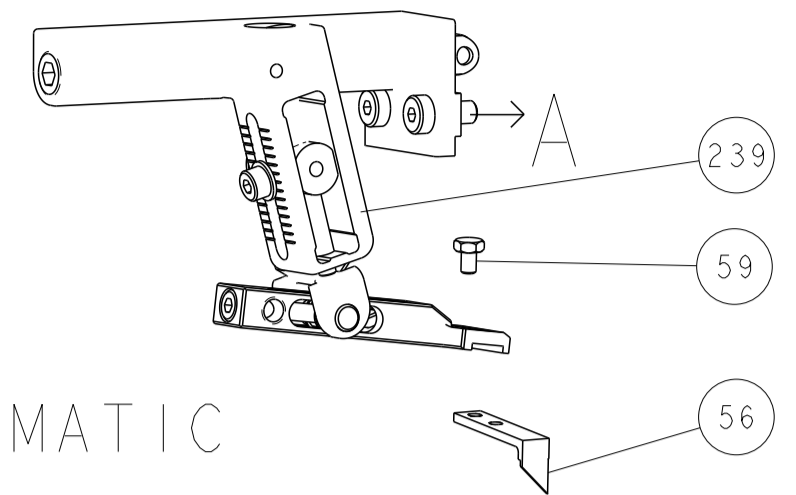
-	1	1	1	1	1	2-1803945-2	TONKER -	300	
-	1	1	1	1	1	22278-9	SPRING, COMPRESSION	299	
-	2	2	2	2	2	4-18032-3	SCR, SET, FLT PNT, M3 X 6.0	298	
-	1	1	1	1	1	1803944-1	SPACER, TONKER	297	
-	1	1	-	-	-	2-1803583-1	APPLICATOR BASIC ASSEMBLY, SF	292	
-	-	-	1	-	-	2844950-1	AIR FEED MODULE	290	
6	-	1	-	-	1	2119641-1	FEED CAM, AIR FEED	248	
-	1	1	1	1	1	2119082-8	CAM, SNAIL, INSULATION ADJUSTMENT	244	
-	1	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243	
3	-	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	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	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	
5	-	1	1	1	1	985575-3	SCR, FLT SKT HD CAP M3 X 10.0	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	
-	2	2	2	2	2	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	53	
6	-	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	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	1-1752356-3	SUPPORT, TERMINAL	34	
-	2	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33	
-	2	2	2	2	2	3-2844962-0	SPACER, CYLINDRICAL, STRIP GUIDE	30	
-	1	1	1	1	1	2844992-2	ASSEMBLY, STRIP GUIDE -	29	
-	1	1	1	1	1	1-455888-0	SPACER, CRIMPER -	28	
-	1	1	1	1	1	1320928-2	STRIP GUIDE	24	
-	-	-	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21	
-	1	1	2	2	2	1-18028-2	WASHER, FLAT, REG M4	20	
-	-	-	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	318707-1	FLOATING SHEAR, FRONT	9	
1	-	1	1	1	1	3-1333203-1	ANVIL, COMBINATION	8	
-	-	-	-	-	-	-	-	7	
-	1	1	1	1	1	2119781-1	DEPRESSOR, SHEAR	5	
-	1	1	1	1	1	238011-2	BLOCK, CRIMPER SPACER	4	
1	1	1	1	1	1	1633996-4	CRIMPER, INSULATION SPECIAL	3	
-	1	1	1	1	1	455888-5	SPACER, CRIMPER -	2	
1	1	1	1	1	1	3-456404-0	CRIMPER, WIRE PREMIUM	1	

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG: Y.YIN 25APR2011		CHK: G.BAILEY 25APR2011		APVD: S.XI 25APR2011		NAME: Ocean Side Feed Applicator	
mm		0 PLC ±		0 PLC ±		0 PLC ±		0 PLC ±		SIZE: A1	
MATERIAL:		FINISH:		WEIGHT:		SCALE: 1:2		SHEET 1 OF 4		REV N	

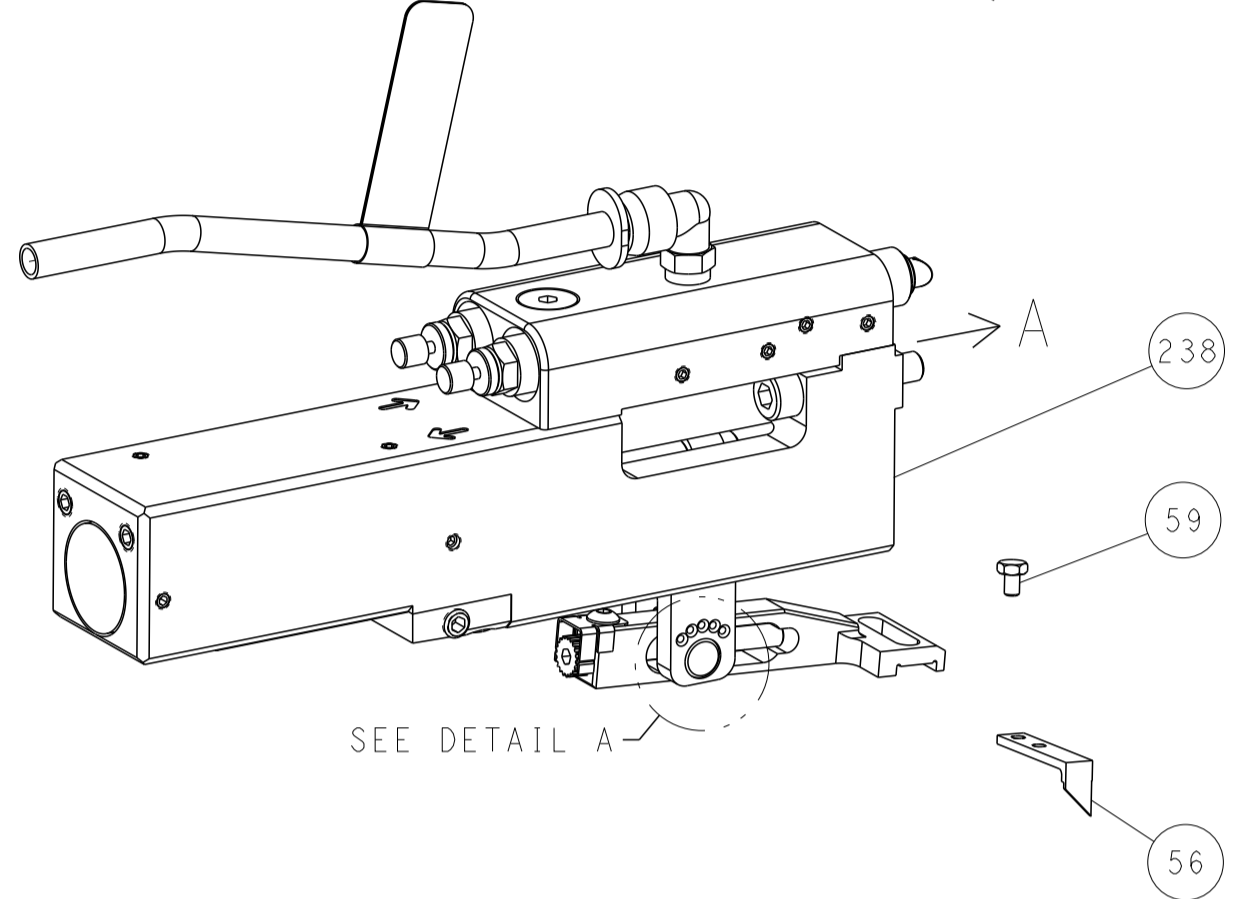
Customer Accessible Production Drawing

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

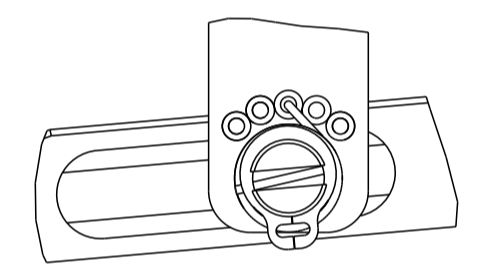
# FEED TYPE MECHANICAL



## PNEUMATIC

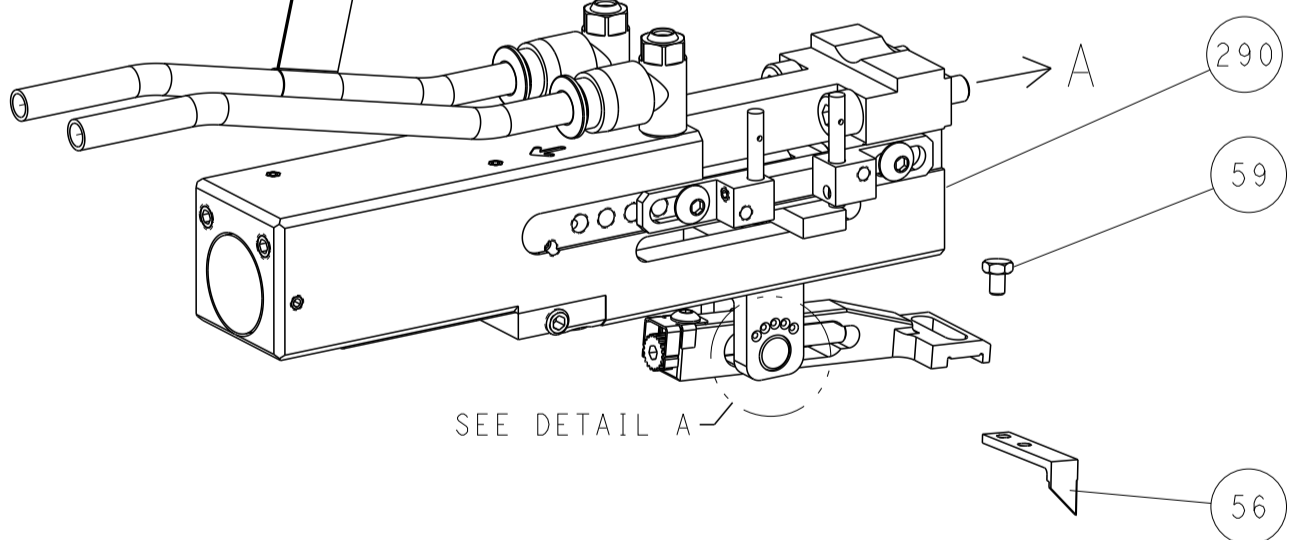


## FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)

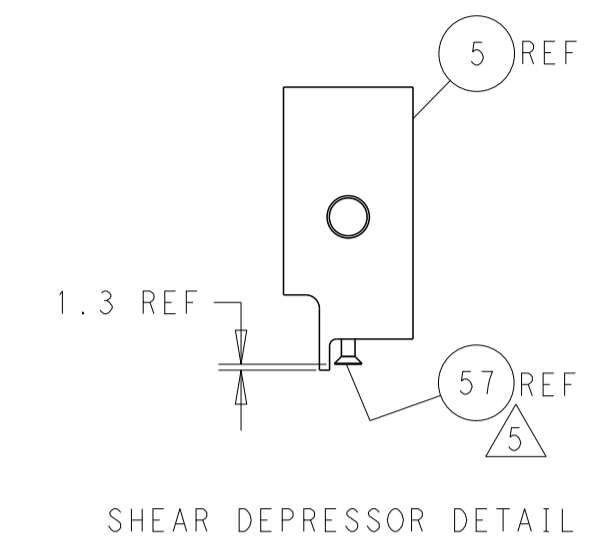
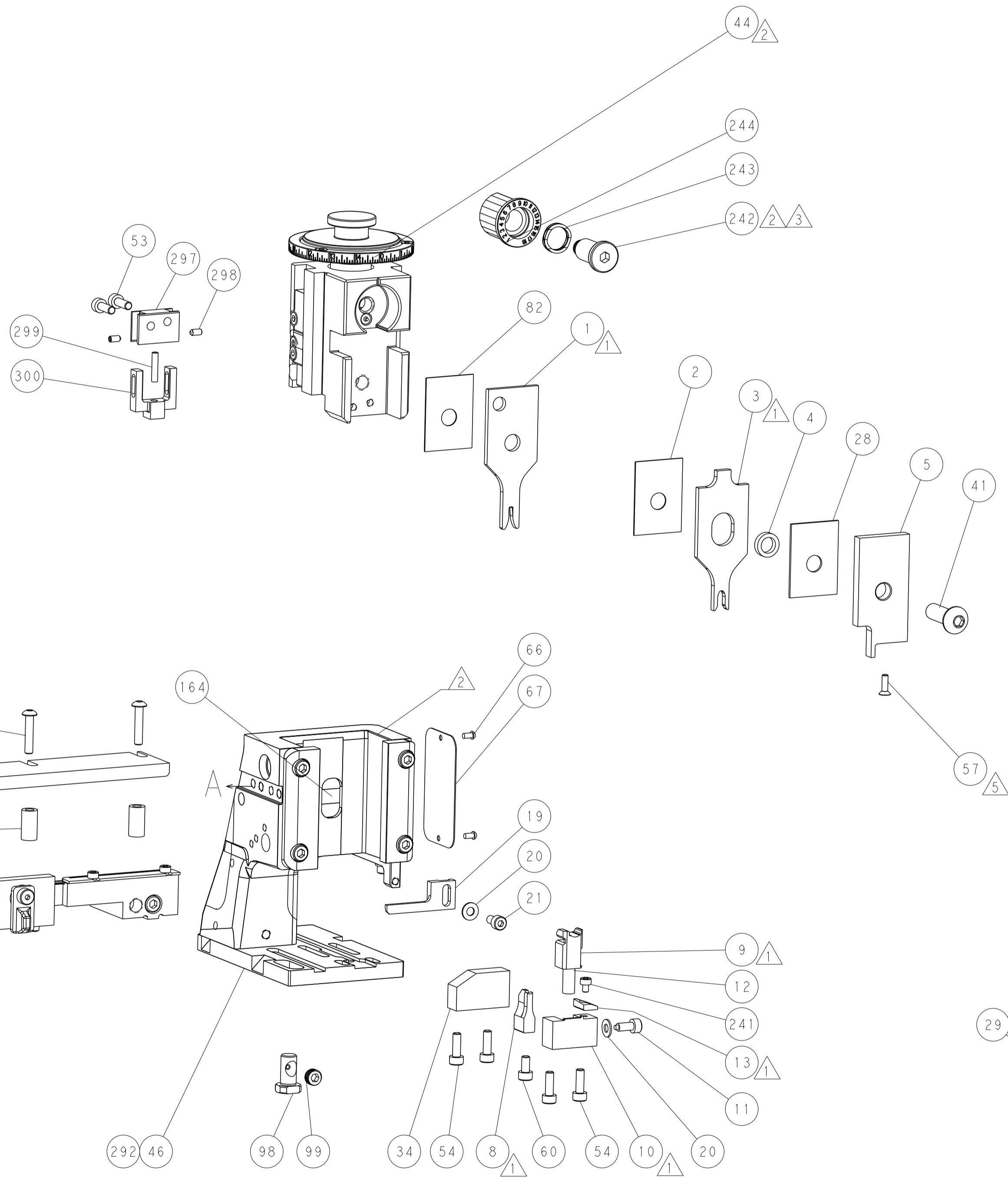
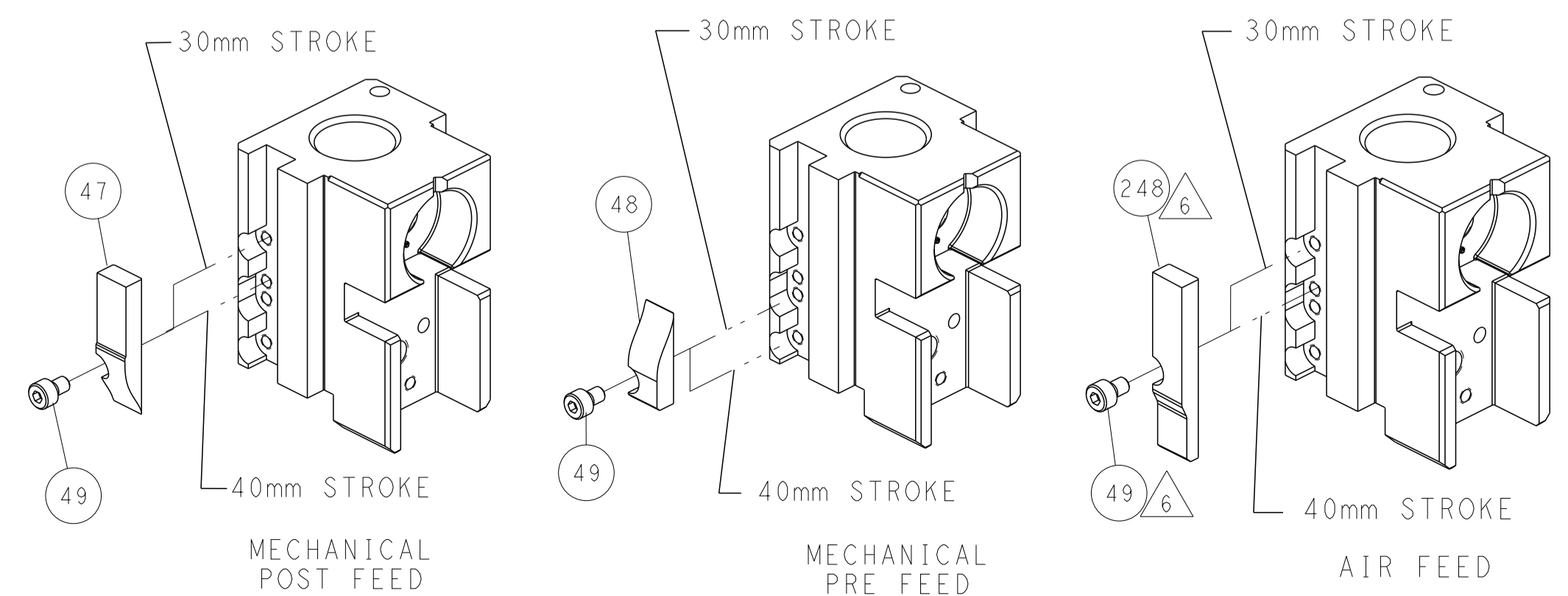


DETAIL A

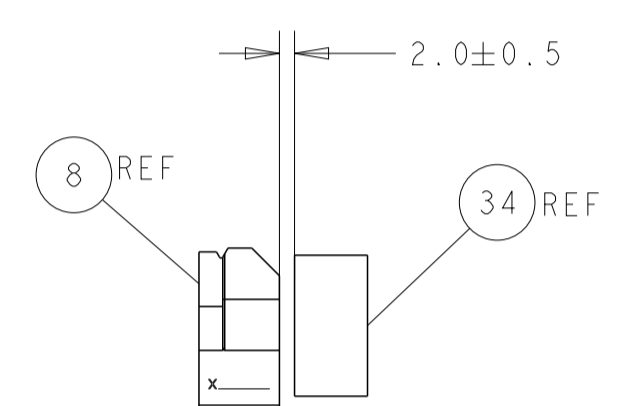
## DOUBLE ACTING PNEUMATIC WITH SENSORS



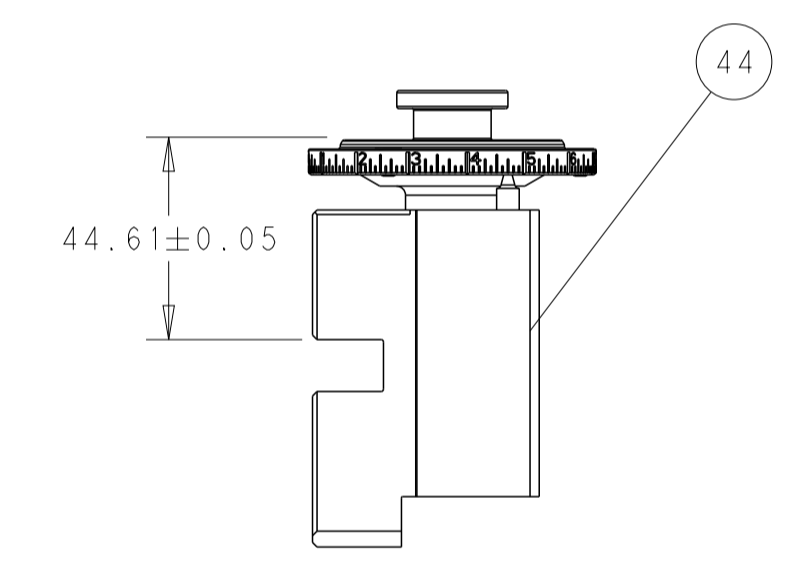
# CAM POSITIONS



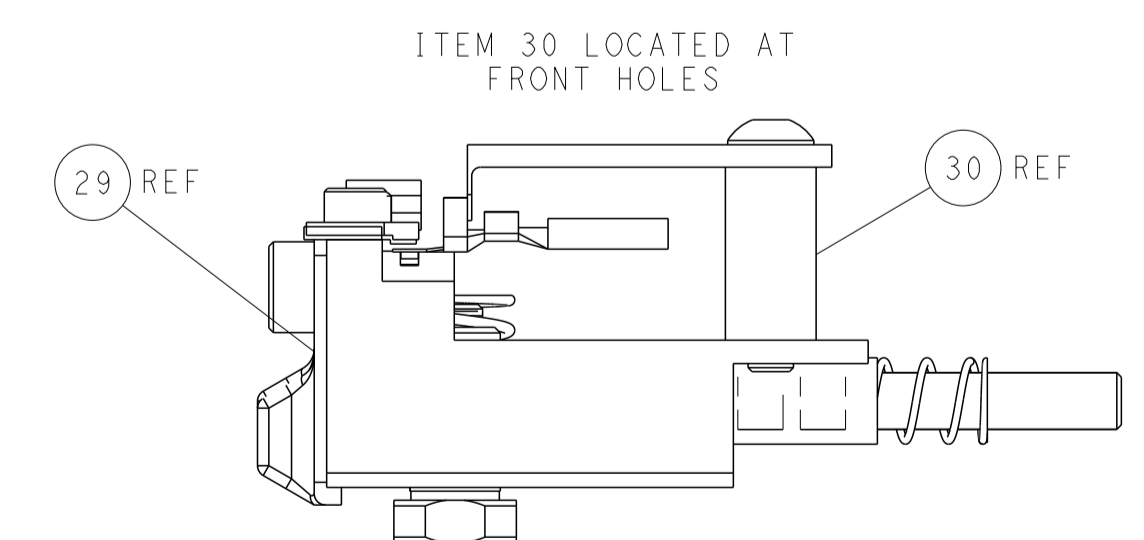
SHEAR DEPRESSOR DETAIL



TERMINAL SUPPORT LOCATION



RAM AND HOLD DOWN SET-UP



FEED TRACK POSITION GUIDE BY INSULATION BARREL

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN Y. YIN 25APR2011		TE Connectivity Harrisburg, PA 17105-3608	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	APVD S. XI 25APR2011	NAME
	ANGLES ±	FINISH ±					Ocean Side Feed Applicator
MATERIAL						SIZE CAGE CODE DRAWING NO	RESTRICTED TO
						A1 00779 C=2151064	
Customer Accessible Production Drawing				SCALE 1:2	SHEET 2 OF 4	REV N	