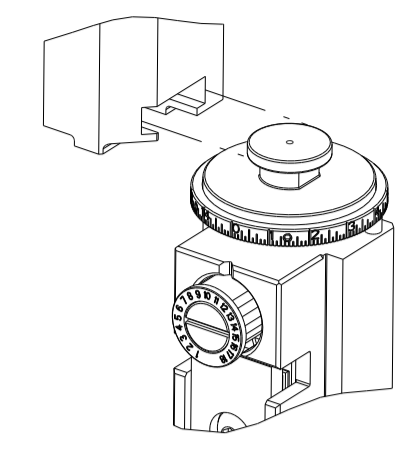


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151518-1	E	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2151518-2	E	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
5-2151518-1	E	SEAL STRIPPER CRIMPER TERMINATING UNIT	MECHANICAL
5-2151518-2	E	SEAL STRIPPER CRIMPER TERMINATING UNIT	PNEUMATIC
7-2151518-1	E	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2151518-2	E	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2151518-7	B	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



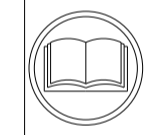
APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.40 mm [.055]	F
INSUL	3.30 mm [.130]	O

APPLICATOR INSTRUCTIONS 408-35042

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: HPF 1.5 MM SENSORCONTACT			
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE		
3.75-4.05 mm [.148-.159 IN]	Ø		
TERMINAL APPLICATION SPECIFICATION	114-18912		

TERMINALS APPLIED				
TE TERMINAL	TE TERMINAL	TE SEAL	TE SEAL	INSULATION RANGE
1563621-2	2296545-2		964971-1	Ø1.2-1.6mm
2208363-3	2292289-1		967067-2	Ø0.9-1.4mm
2290339-3			2297816-1	Ø1.2-1.4mm
		2300384-1	2297816-2	Ø1.2-1.4mm

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.35mm <sup>2</sup>	0.89+/-0.03 [.035+/- .001]	8.2



- 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 TERMINAL LUBRICANT IS RECOMMENDED.
- 6. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- 7 APPLY TORO-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.

**\*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	REVISIONS					
A	66	P	LTN	DESCRIPTION	DATE	OWN	APVD
		D		ECR-19-011319	18JUL2019	FJ	TE
		D1		ECR-21-001818	17FEB2021	JWC	RR
		E		ECR-22-148547	04AUG2022	TB	TE
		E1		ECR-23-178305	13JUN2023	FZ	RR

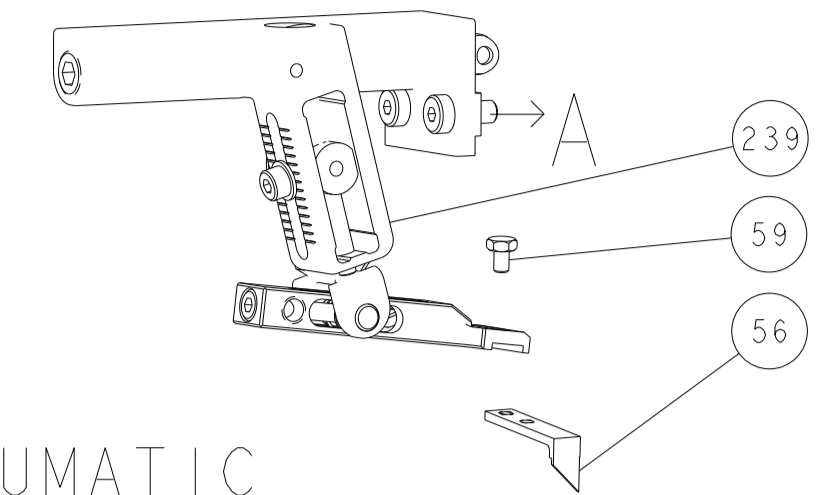
-	1	1	1	1	1	1	1803945-8	TONKER	300
-	1	1	1	1	1	1	22278-9	SPRING, COMPRESSION	299
-	2	2	2	2	2	2	4-18032-3	SCR, SET, FLT PNT, M3 X 6.0	298
-	1	1	1	1	1	1	1803944-1	SPACER, TONKER	297
-	-	-	1	1	-	-	2-1803583-1	APPLICATOR BASIC ASSEMBLY, SF	292
-	1	-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248
-	1	1	1	1	1	1	2119082-8	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
3	1	1	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	1	1	1	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
-	-	1	-	1	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	1	-	1	-	1	-	2844940-1	AIR FEED MODULE	238
-	REF	REF	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	1	1	1	1	1	1	1-18028-2	WASHER, FLAT, REG M4	119
5	1	1	1	1	1	1	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113
-	1	1	1	1	1	1	2844908-1	SCREW, LOCKING	99
-	1	1	1	1	1	1	2844907-1	POST, LOCKING	98
-	1	1	1	1	1	1	455888-7	SPACER, CRIMPER	82
-	1	1	1	1	1	1	1803607-3	DOCUMENTATION PACKAGE	71
-	1	1	1	1	1	1	2119740-1	TAG, IDENTIFICATION	67
-	2	2	2	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	1	1	1	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	60
-	1	1	1	1	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
7	1	1	1	1	1	1	985575-3	SCR, FLT SKT HD CAP M3 X 10.0	57
-	1	1	1	1	1	1	1338685-1	PAWL, FEED	56
-	4	4	4	4	4	4	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	54
-	2	2	2	2	2	2	2-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 14	53
-	1	2	1	2	1	2	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	-	1	-	1	-	1	2119652-1	FEED CAM, PRE FEED	48
-	-	1	-	1	-	1	2119653-1	FEED CAM, POST FEED	47
-	1	1	-	-	1	1	1803583-9	APPLICATOR BASIC ASSEMBLY, SF	46
-	1	1	1	1	1	1	1803515-1	RAM ASSEMBLY, SF ATLANTIC	44
-	1	1	1	1	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
-	1	1	1	1	1	1	1752356-6	SUPPORT, TERMINAL	34
-	2	2	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	2	2	2	2	2-2844962-8	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	1	1	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29
-	1	1	1	1	1	1	455888-3	SPACER, CRIMPER	28
-	1	1	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
-	2	2	1	1	2	2	1-18028-2	WASHER, FLAT, REG M4	20
-	1	1	-	-	1	1	2119533-1	STRIPPER, SIDE FEED	19
1	1	1	1	1	1	1	2119806-1	INSERT, SHEAR	13
-	1	1	1	1	1	1	3-22280-3	SPRING, COMPRESSION	12
-	1	1	1	1	1	1	1-356885-4	STOP, SHEAR	11
1	1	1	1	1	1	1	2119805-1	SHEAR HOLDER, FRONT	10
1	1	1	1	1	1	1	318707-1	FLOATING SHEAR, FRONT	9
1	1	2	2	1	1	1	1333332-1	ANVIL, COMBINATION, SPECIAL	8
-	1	1	1	1	1	1	1-240641-3	SPACER	7
-	-	-	-	-	-	-	-	-	6
-	1	1	1	1	1	1	2119781-1	DEPRESSOR, SHEAR	5
-	1	1	1	1	1	1	238011-4	BLOCK, CRIMPER SPACER	4
1	1	2	2	1	1	1	2-1633996-7	CRIMPER, INSULATION SPECIAL	3
-	1	1	1	1	1	1	1-455888-3	SPACER, CRIMPER	2
1	1	2	2	1	1	1	5-1633860-6	CRIMPER, WIRE	1

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

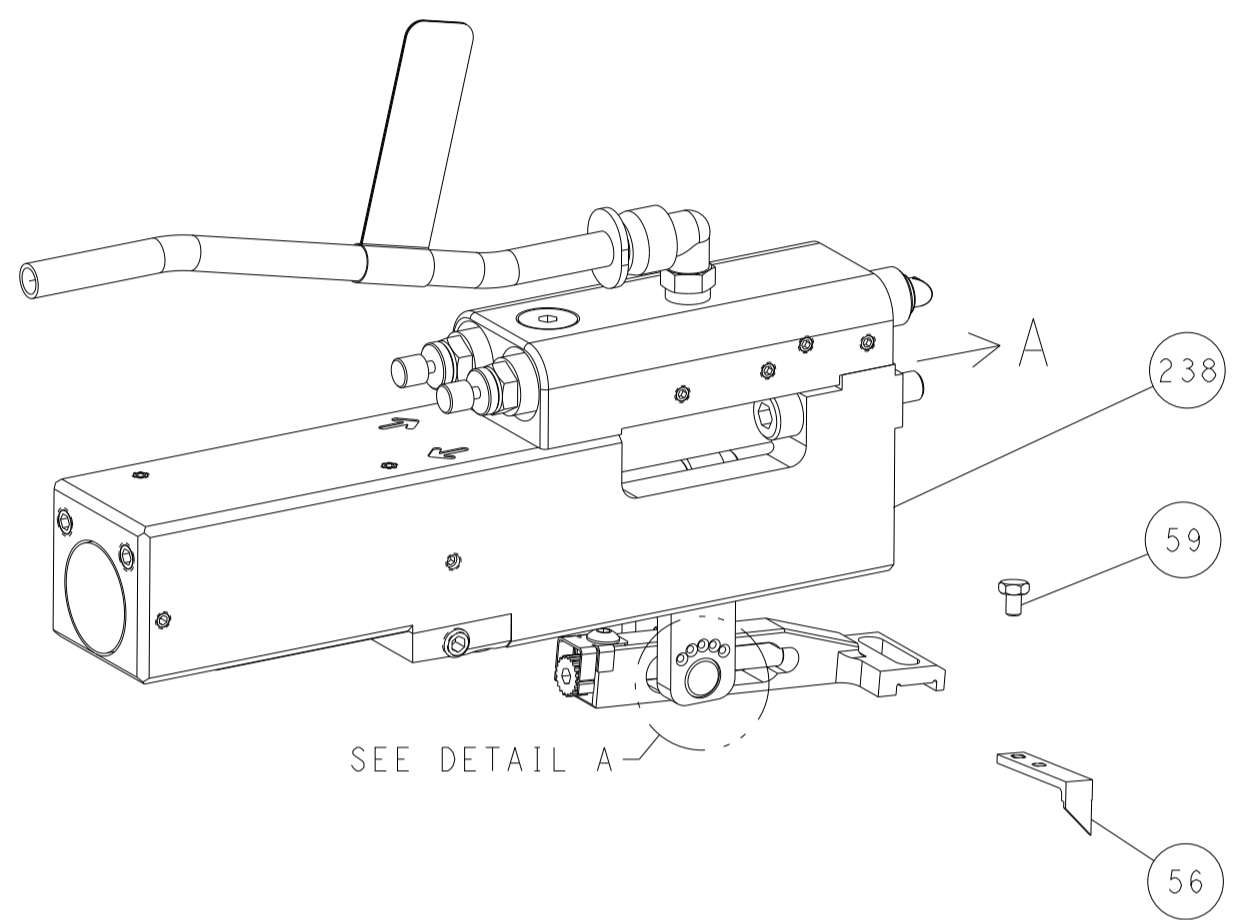
DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ° ± FINISH		DWN X ZHAO 14MAR2013 CHK L ZHANG 14MAR2013 APVD L ZHANG 14MAR2013 PRODUCT SPEC APPLICATION SPEC MATERIAL FINISH		NAME Ocean Side Feed Applicator SIZE CAGE CODE DRAWING NO RESTRICTED TO A1 00779 C=2151518 SCALE 1:2 SHEET 1 OF 4 REV E1	
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LOC	DIST	REVISIONS					
A	66	P	LTN	DESCRIPTION	DATE	DWN	APVD
		-		SEE SHEET 1	-	-	-

# FEED TYPE MECHANICAL



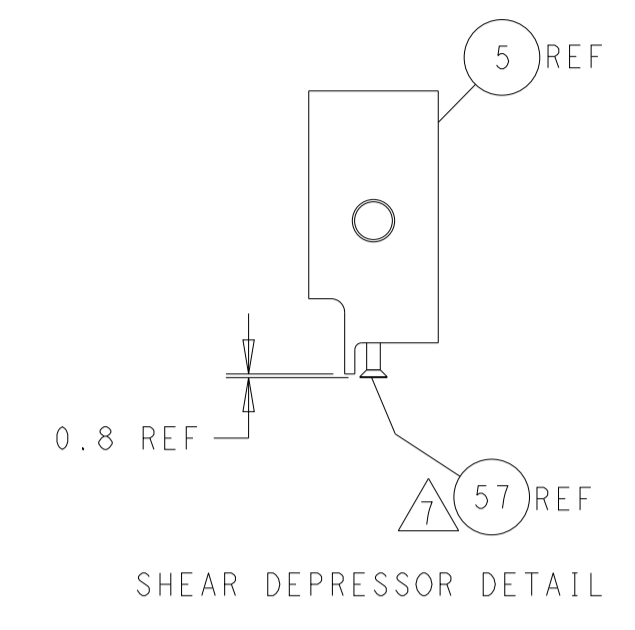
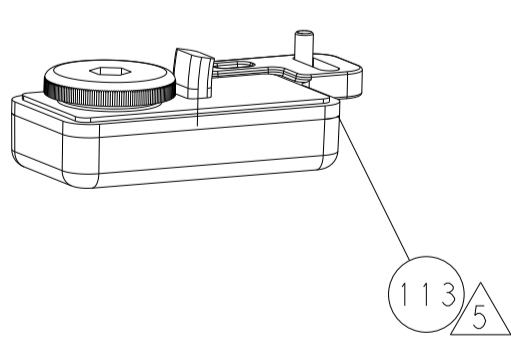
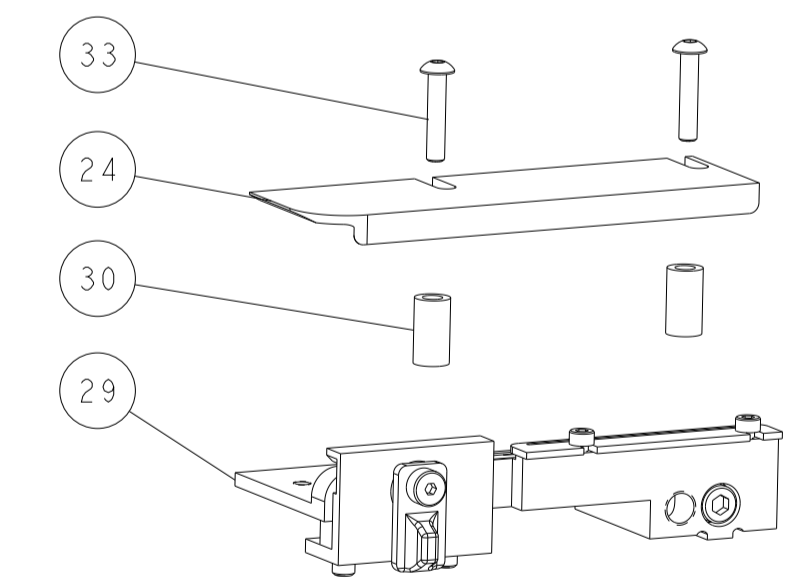
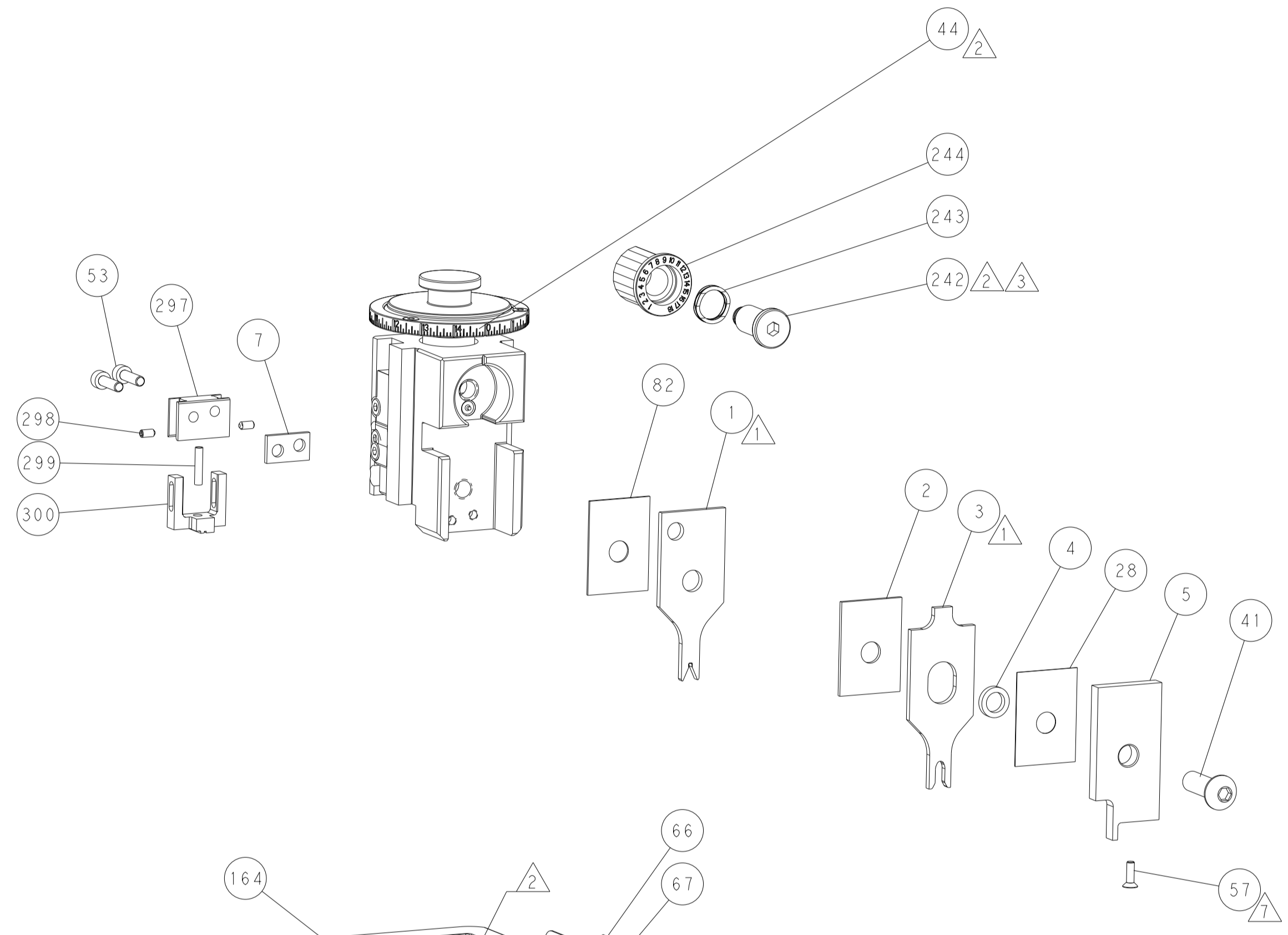
## PNEUMATIC



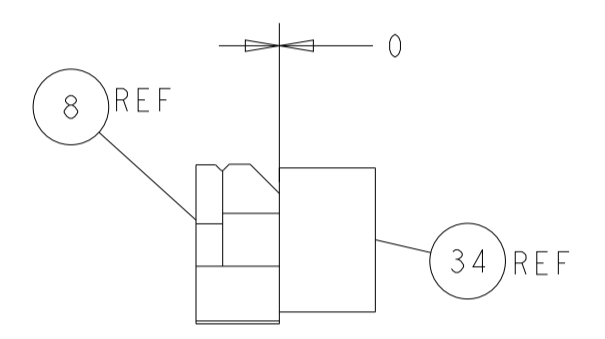
## FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



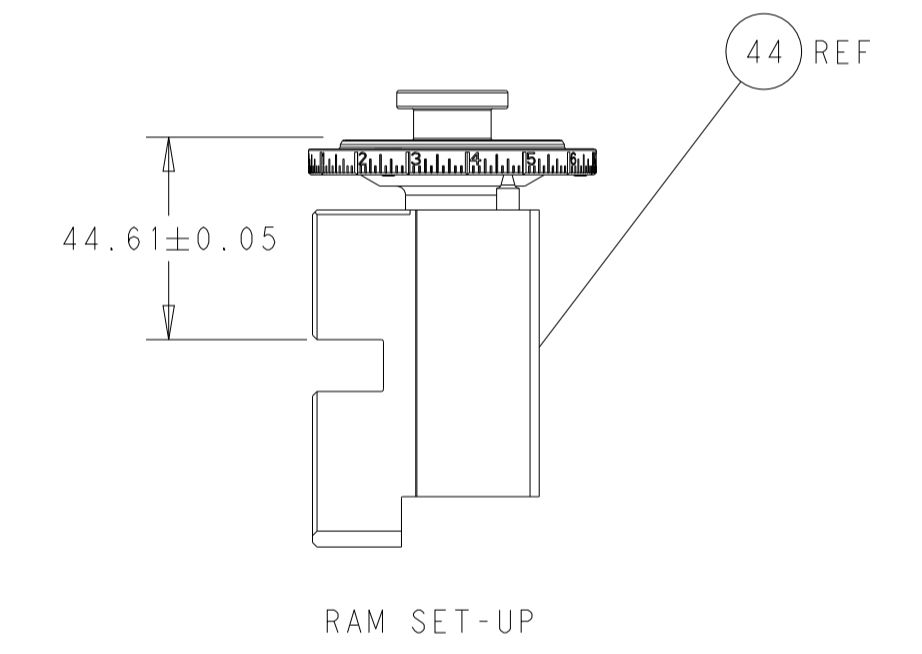
DETAIL A



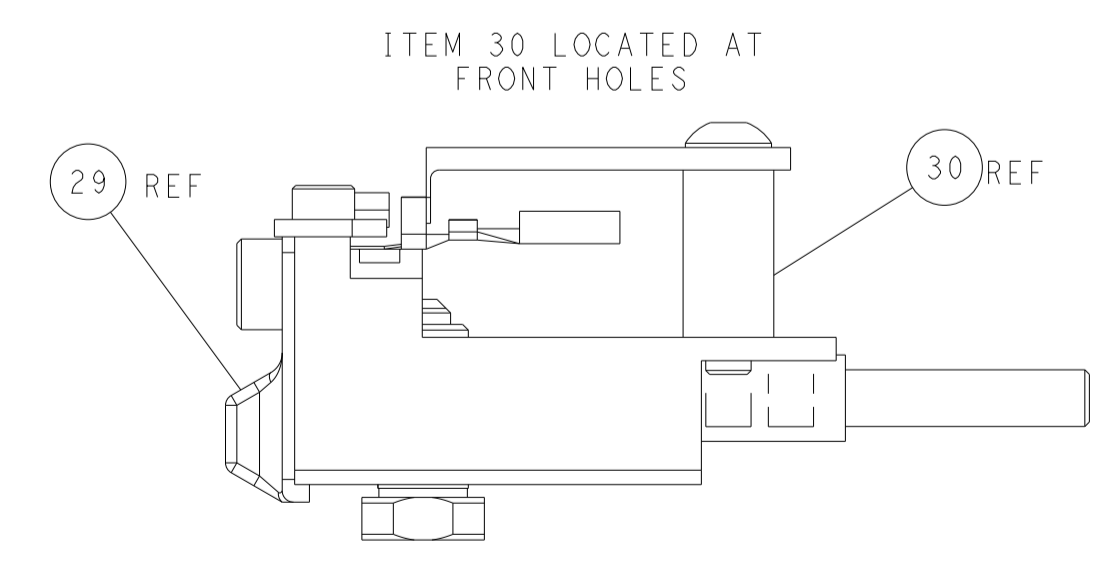
SHEAR DEPRESSOR DETAIL



TERMINAL SUPPORT LOCATION

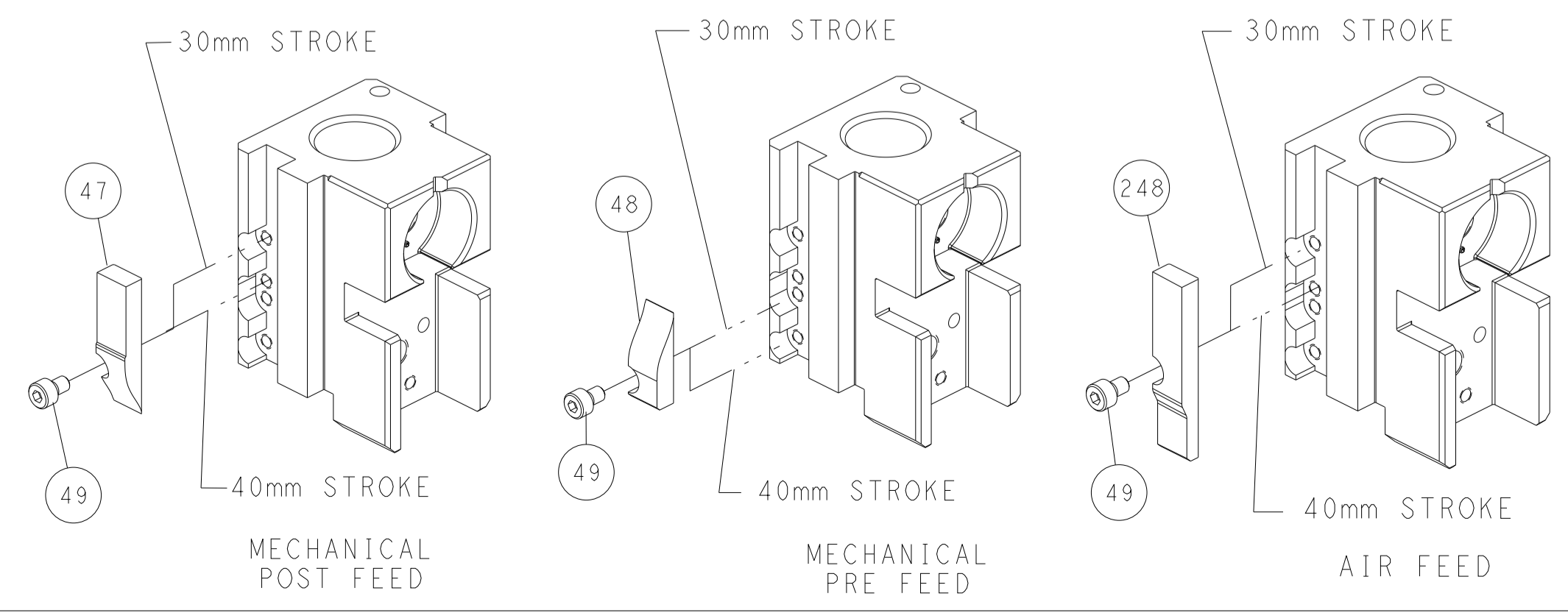


RAM SET-UP



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:		DWG		TE Connectivity	
mm	0 PLC ±	1 PLC ±	2 PLC ±	X. ZHAO	14MAR2013	Harrisburg, PA 17105-3608	
	3 PLC ±	4 PLC ±	ANGLES ±	L. ZHANG	14MAR2013	NAME	
MATERIAL:	FINISH:	WEIGHT:	SCALE:	APVD:	L. ZHANG	14MAR2013	PRODUCT SPEC
			1:2	Customer Accessible Production Drawing			APPLICATION SPEC
			SHEET 2 OF 4	Customer Accessible Production Drawing			RESTRICTED TO
			REV E1	Customer Accessible Production Drawing			SIZE
				Customer Accessible Production Drawing			CAGE CODE
				Customer Accessible Production Drawing			DRAWING NO
				Customer Accessible Production Drawing			©=2151518

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2151518-1	E	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2151518-2	E	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151518-7	B	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR  
 INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.40 mm [.055]	F
INSUL	3.30 mm [.130]	O

APPLICATOR INSTRUCTIONS  
 408-35042

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: HPF 1.5 MM SENSORKONTACT			
WIRE STRIP LENGTH 3.75-4.05 mm [1.48-.159 IN]		INSULATION DIAMETER RANGE Ø	
TERMINAL APPLICATION SPECIFICATION	114-18912	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE SEAL	TE SEAL
1563621-2	2296545-2		964971-1
2208363-3	2292289-1		967067-2
2290339-3			2297816-1
		2300384-1	2297816-2
			INSULATION RANGE Ø1.2-1.6mm Ø0.9-1.4mm Ø1.2-1.4mm Ø1.2-1.4mm

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.35mm <sup>2</sup>	0.89+/-0.03 [.035+/-0.011]	8.2

- 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.
- TERMINAL LUBRICANT IS RECOMMENDED.
- UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- 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.

**\*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	REVISIONS					
A	66	P	LTN	DESCRIPTION	DATE	OWN	APVD
-	-	-	-	SEE SHEET 1	-	-	-

-	1	1	1803945-8	TONKER	300
-	1	1	22278-9	SPRING, COMPRESSION	299
-	2	2	4-18032-3	SCR, SET, FLT PNT, M3 X 6.0	298
-	1	1	1803944-1	SPACER, TONKER	297
-	1	1	2119082-8	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	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	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	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113
-	1	1	2844908-1	SCREW, LOCKING	99
-	1	1	2844907-1	POST, LOCKING	98
-	1	1	455888-7	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	985575-3	SCR, FLT SKT HD CAP M3 X 10.0	57
-	1	1	1338685-1	PAWL, FEED	56
-	2	2	2-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 14	53
-	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	1752356-6	SUPPORT, TERMINAL	34
-	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	2-2844962-8	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29
-	1	1	455888-3	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	318707-1	FLOATING SHEAR, FRONT	9
-	1	1	1333332-1	ANVIL, COMBINATION, SPECIAL	8
-	1	1	1-240641-3	SPACER	7
-	-	-	-	-	6
-	1	1	2119781-1	DEPRESSOR, SHEAR	5
-	1	1	238011-4	BLOCK, CRIMPER SPACER	4
-	1	1	2-1633996-7	CRIMPER, INSULATION SPECIAL	3
-	1	1	1-455888-3	SPACER, CRIMPER	2
-	1	1	5-1633860-6	CRIMPER, WIRE	1

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:		MATERIAL:		FINISH:	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES ±	FINISH

ITEM NO	PART NO	DESCRIPTION
-77-22-21		

OWN	X. ZHAO	14MAR2013
CHK	L. ZHANG	14MAR2013
APVD	L. ZHANG	14MAR2013

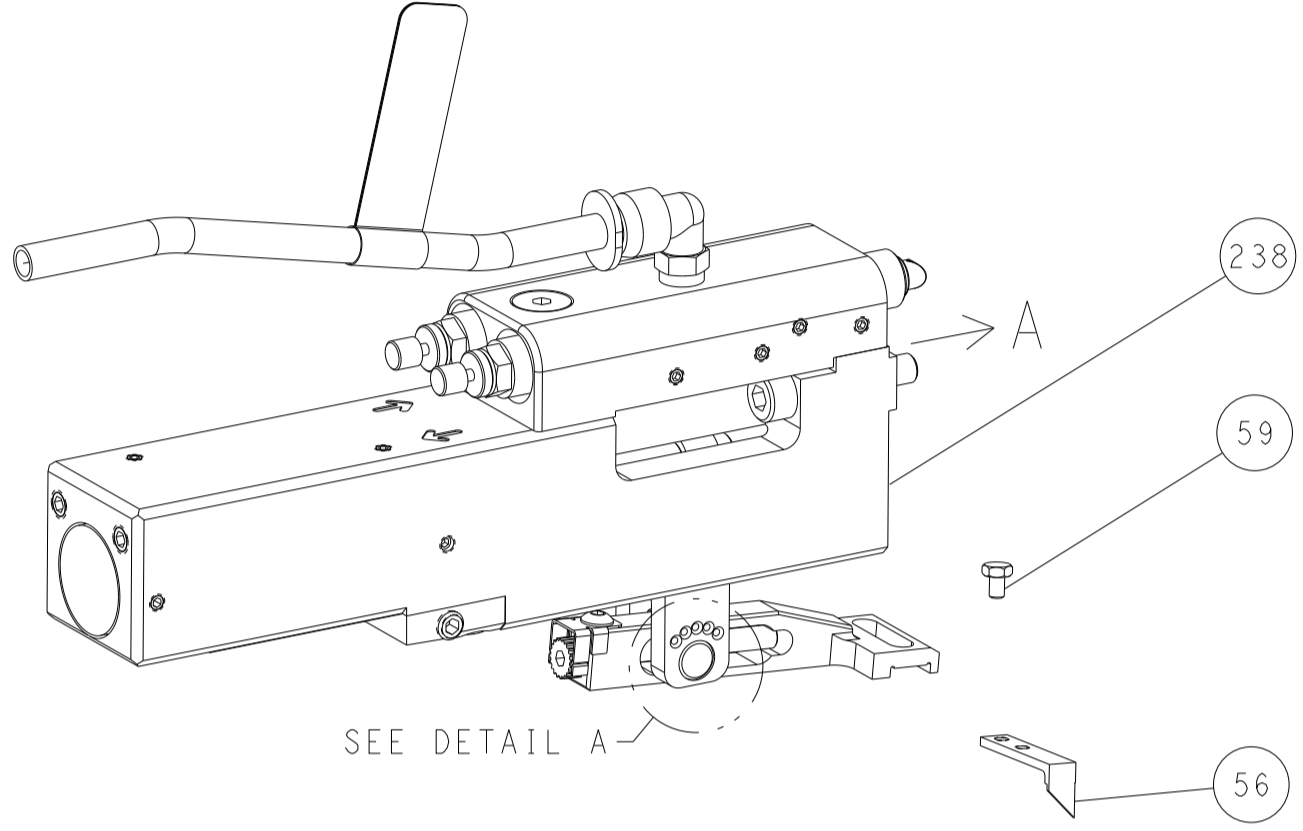
Customer Accessible Production Drawing

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

# FEED TYPE MECHANICAL



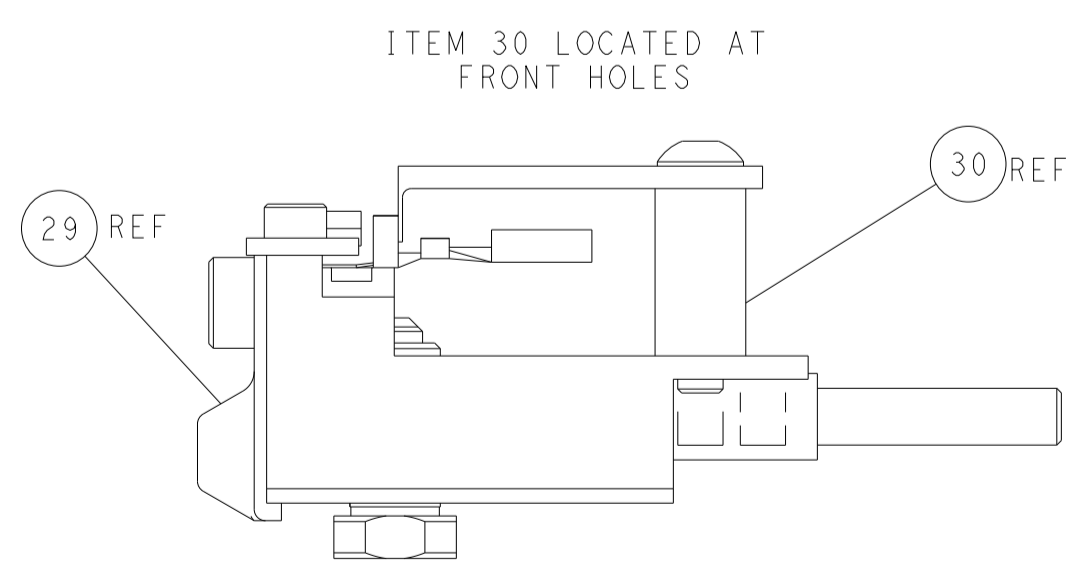
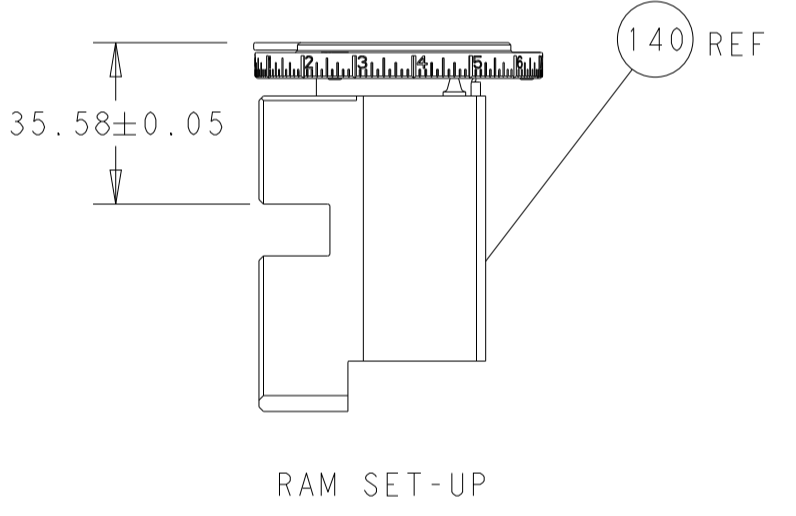
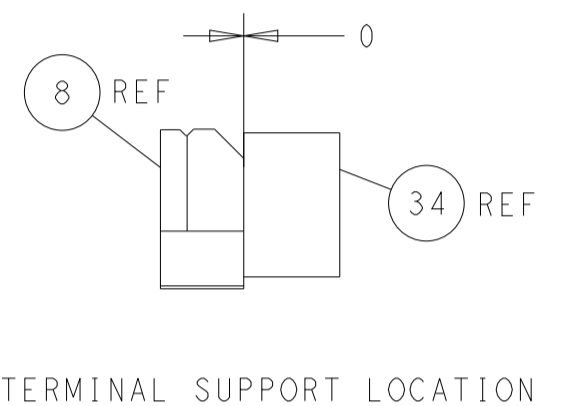
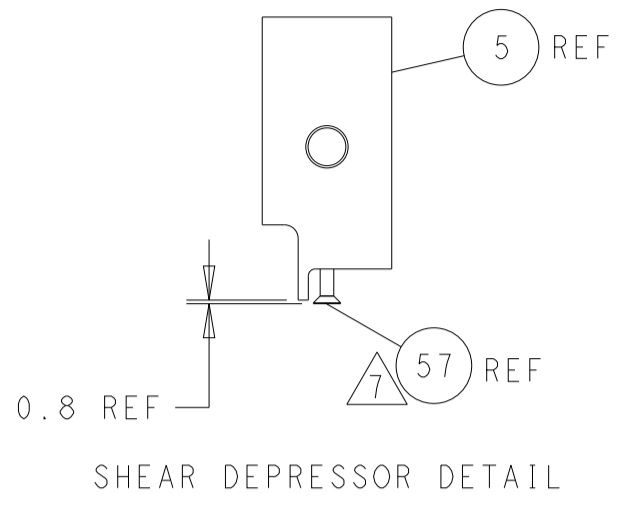
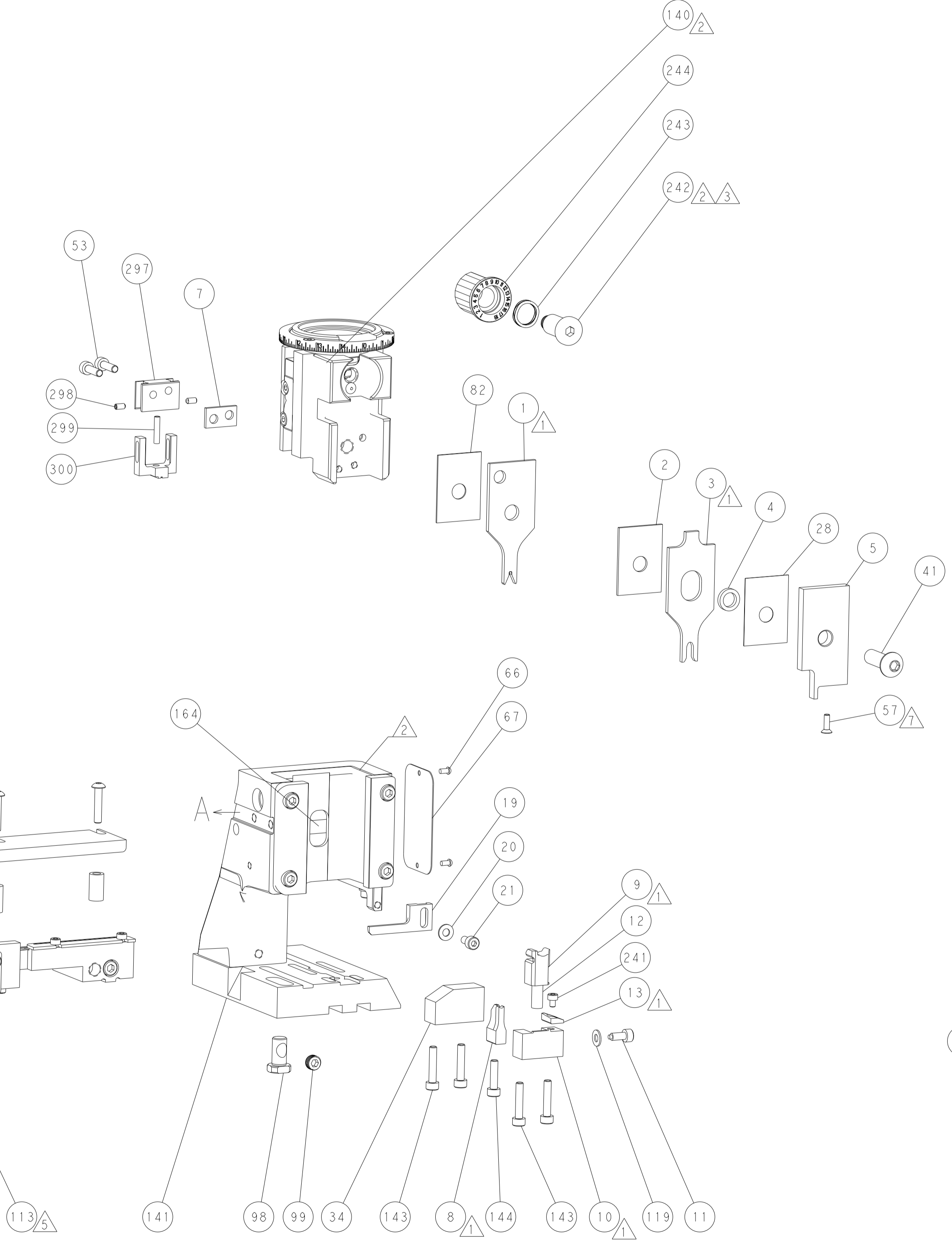
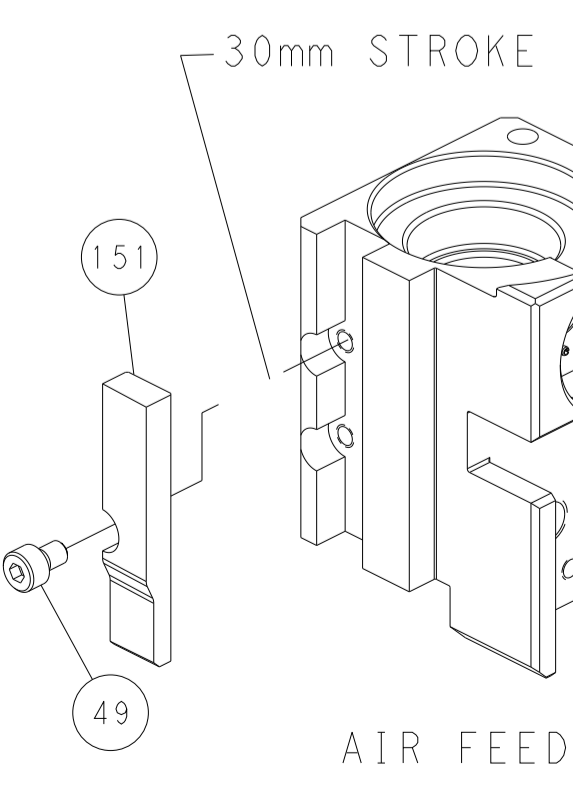
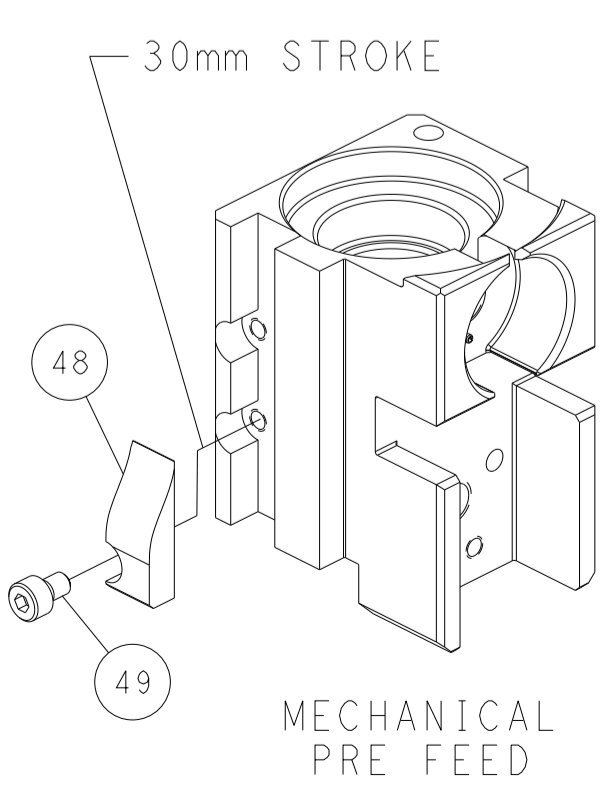
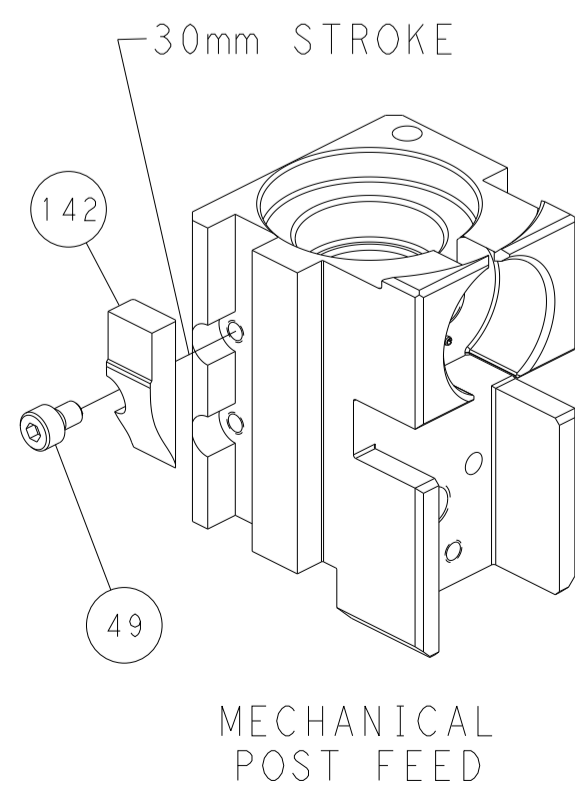
## PNEUMATIC



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



# CAM POSITIONS



**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 A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION. IT IS THE PROPERTY OF COMPANY AND CONTAINS PROPRIETARY INFORMATION. IT IS TO BE KEPT IN CONFIDENTIALITY AND NOT TO BE REPRODUCED OR DISSEMINATED WITHOUT THE WRITTEN PERMISSION OF TYCO ELECTRONICS CORPORATION.</small>		DWN: X.ZHAO 14MAR2013 CHK: L.ZHANG 14MAR2013 APVD: L.ZHANG 14MAR2013	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 APPLICATION SPEC: - PRODUCT SPEC: - SCALE: 1:2 SHEET 4 OF 4 REV E1	RESTRICTED TO: - WEIGHT: - CUSTOMER ACCESSIBLE PRODUCTION DRAWING