

ATLANTIC VERSION TERMINATOR  
 INTERFACE ADAPTER



PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151484-1	P	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2151484-2	P	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
5-2151484-1	P	SEAL STRIPPER CRIMPER TERMINATING UNIT	MECHANICAL
5-2151484-2	P	SEAL STRIPPER CRIMPER TERMINATING UNIT	PNEUMATIC
7-2151484-1	P	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2151484-2	P	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2151484-7	A	CRIMP TOOLING KIT	-

APPLICATOR DATA

CRIMP	SIZE	TYPE
WIRE	1.57 mm [.062]	F
INSUL	3.94 mm [.155]	O

APPLICATOR INSTRUCTIONS  
 408-35042

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION

TERMINAL NAME: AMP MCP 2.8K FLAT TYPE RECEPTACLE

WIRE STRIP LENGTH	INSULATION DIAMETER RANGE
3.40-4.00 mm [.134-.157 IN]	Ø1.10-1.40 mm [.043-.055 IN]

TERMINAL APPLICATION SPECIFICATION 114-18387

TERMINALS APPLIED

TE TERMINAL	TE TERMINAL	TE SEAL	TE SEAL	SEAL INSULATION DIAMETER RANGE
1564984-1	1564984-3		963294-1	Ø1.2-2.0
1564984-2				

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.35mm2	1.11+/-0.03 [.044+/- .001]	5.8
0.22mm2	1.05+/-0.03 [.041+/- .001]	6.6

- 1 RECOMMENDED SPARE PARTS
  - 2 REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION & STORAGE OF APPLICATOR.
  - 3 APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 180. 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 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.
  - 6 TERMINAL LUBRICANT IS RECOMMENDED.
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.

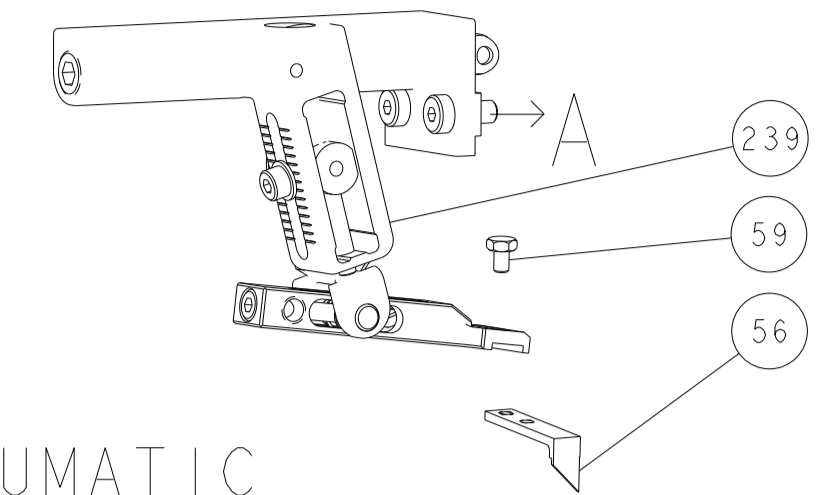
LOC	DIST	REV	DATE	BY	CHK	APP'D
A	66	M	19SEP2022	ROY	JAH	
		N	18AUG2023	FZ	TE	
		N1	03OCT2023	ROY	JAH	
		P	21NOV2023	TB	JAH	

REV	DATE	BY	CHK	APP'D	DESCRIPTION	ITEM NO			
-	-	-	1	1	-	1803515-3	RAM ASSEMBLY, SF ATLANTIC	293	
-	-	-	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	2119082-7	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	-	1	2844940-1	AIR FEED MODULE	238	
-	-	-	1	1	-	4-1722335-3	STRIPPER, SIDE FEED	182	
-	-	-	1	1	-	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	181	
-	-	-	1	1	-	2-1752354-6	STANDOFF,HOLD-DOWN	180	
-	-	-	1	1	-	993111-1	PIN, SLOTTED SPRING 3.0 X 20.0	177	
-	-	-	1	1	-	5-22280-0	SPRING, COMPRESSION	176	
-	-	-	1	1	-	1752353-3	GUIDE PIN,HOLDDOWN	175	
-	-	-	1	1	-	1901680-2	GUIDE PIN,HOLDDOWN	174	
-	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	455888-4	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	
-	1	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	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	53	
-	1	1	1	1	1	1803382-2	HOLD DOWN, SPRING LOADED	50	
-	1	2	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	1803583-9	APPLICATOR BASIC ASSEMBLY, SF	46	
-	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	1-1752356-7	SUPPORT, TERMINAL	34	
-	2	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33	
-	2	2	2	2	2	2-2844962-8	SPACER, CYLINDRICAL, STRIP GUIDE	30	
-	1	1	1	1	1	2844992-1	ASSEMBLY, STRIP GUIDE -	29	
-	1	1	1	1	1	455888-4	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	
-	2	2	1	1	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	2	2	1	1	1	3-1633129-7	ANVIL, COMBINATION .062	8
-	1	1	1	1	1	1	2-240641-8	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	2	2	1	1	1	2-2119784-9	CRIMPER, INSULATION O PREMIUM	3
-	1	1	1	1	1	1	455888-9	SPACER, CRIMPER -	2
-	1	2	2	1	1	1	1-456403-3	CRIMPER, WIRE PREMIUM	1

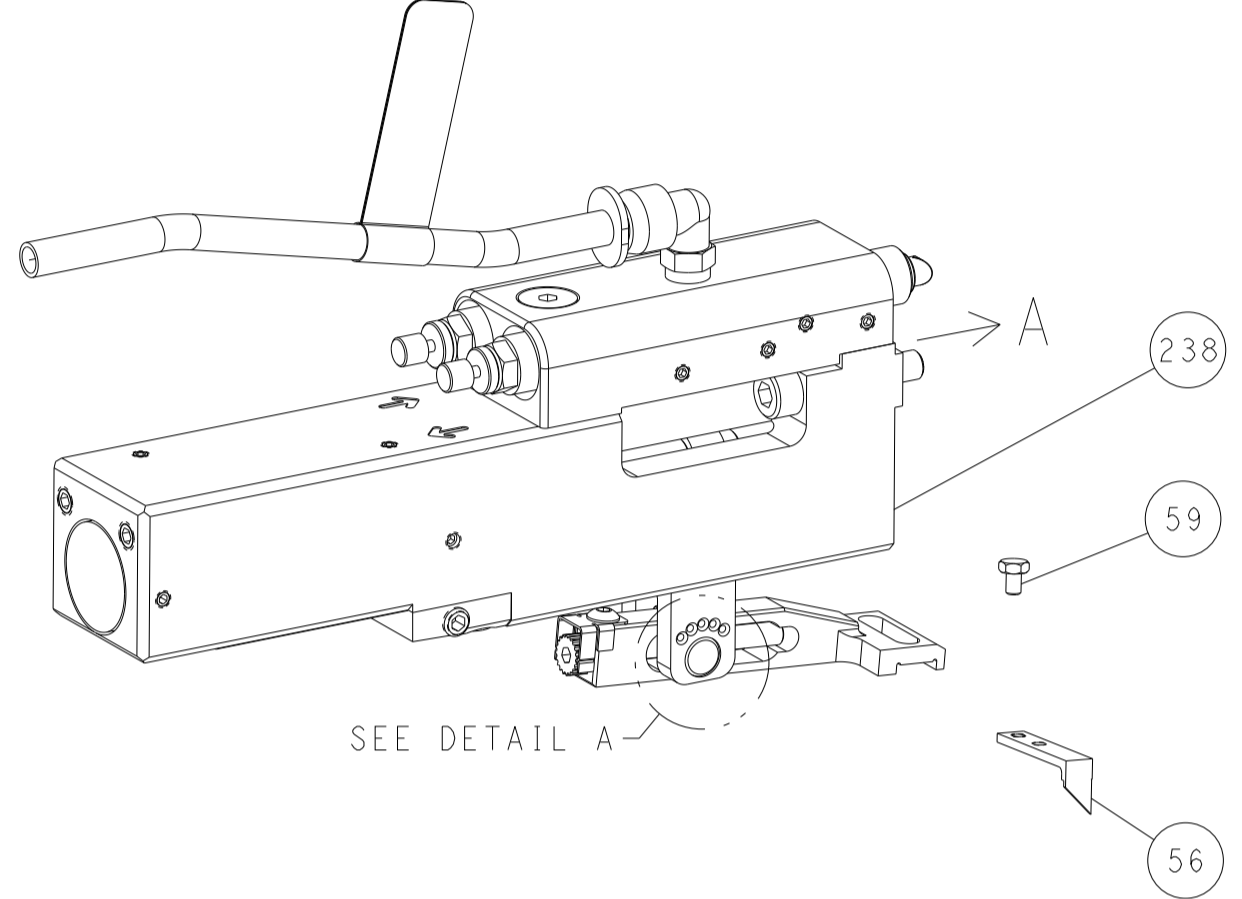
REV	DATE	BY	CHK	APP'D	DESCRIPTION	ITEM NO		
-77	-72	-71	-52	-51	-2	-1	PART NO	
DIMENSIONS:  TOLERANCES UNLESS OTHERWISE SPECIFIED:					DWG: H. HUANG 12MAR2012 CHK: S. XI 12MAR2012 APP'D: S. XI 12MAR2012			
MATERIAL:  FINISH:					NAME: Ocean Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2151484 RESTRICTED TO:			
WEIGHT:					SCALE: 1:2 SHEET 1 OF 4 REV P			

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

# FEED TYPE MECHANICAL



## PNEUMATIC

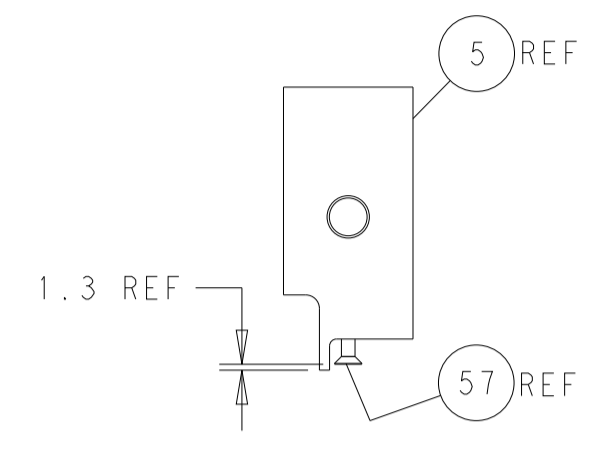
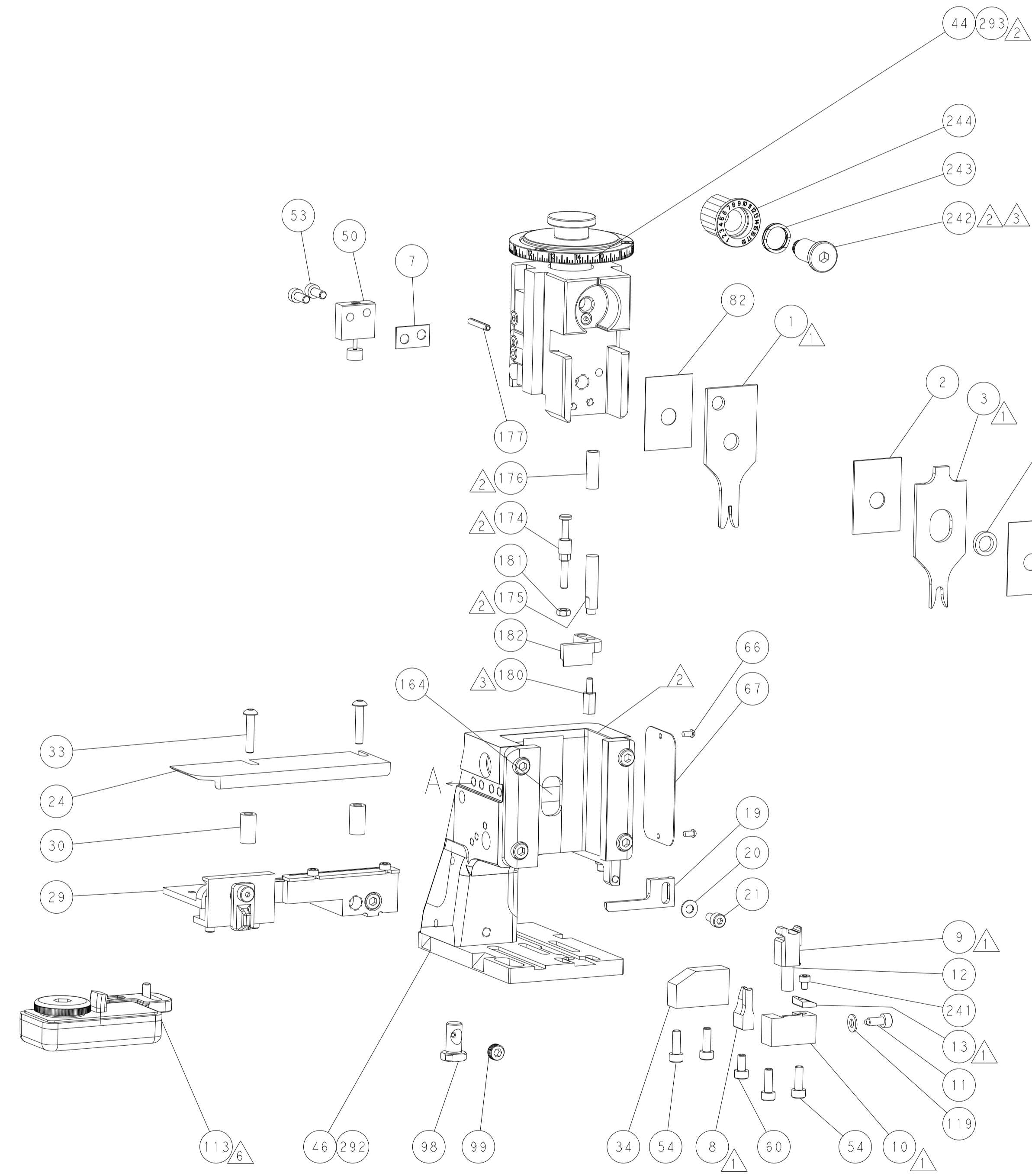


## FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)

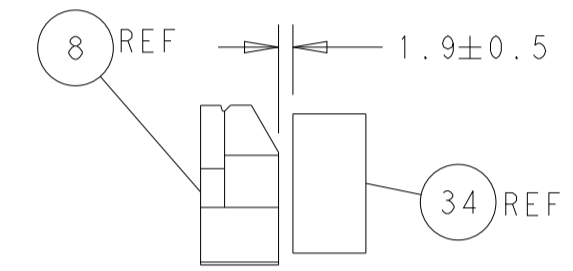


DETAIL A

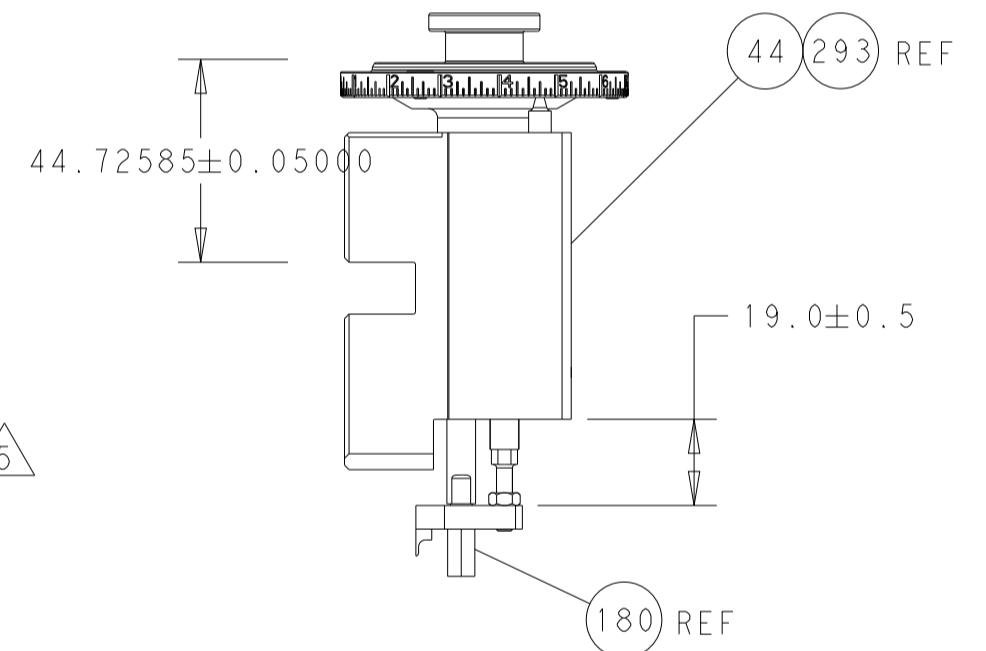
# CAM POSITIONS



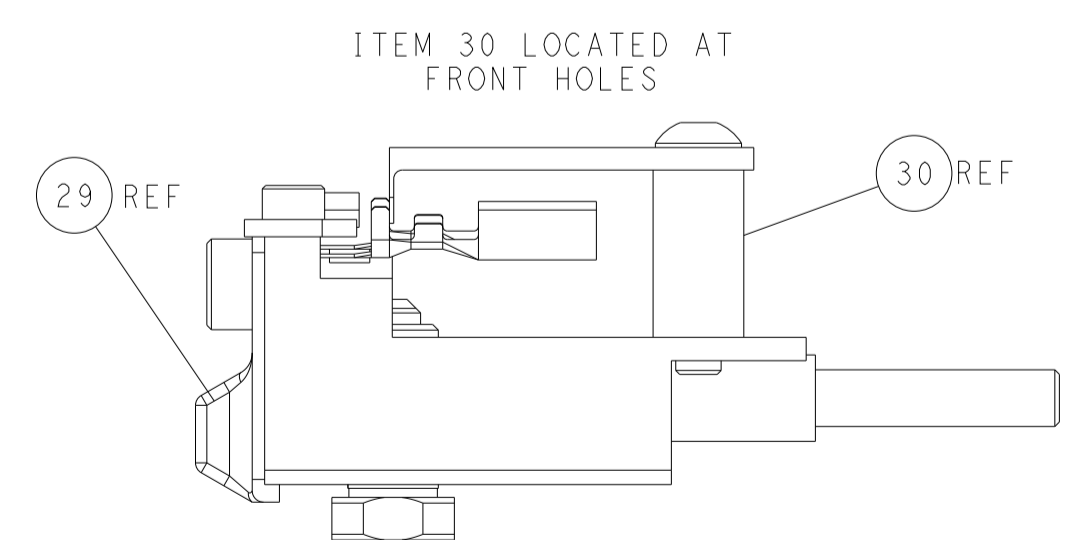
SHEAR DEPRESSOR DETAIL



TERMINAL SUPPORT LOCATION



RAM & HOLD DOWN SET-UP



FEED TRACK POSITION GUIDE BY INSULATION BARREL

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN		TE Connectivity	
mm	0 PLC ±	1 PLC ±	2 PLC ±	H. HUANG	12MAR2012	Harrisburg, PA 17105-3608	
	3 PLC ±	4 PLC ±	ANGLES ±	CHK S.XI	12MAR2012	NAME	
	FINISH			APVD S.XI	12MAR2012	Ocean Side Feed Applicator	
MATERIAL		WEIGHT		SIZE CAGE CODE DRAWING NO		RESTRICTED TO	
				A1 00779 C=2151484			
Customer Accessible Production Drawing				SCALE	1:2	SHEET	2 of 4 REV P

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2151484-1	N	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2151484-2	N	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151484-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR  
 INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.57 mm [.062]	F
INSUL	3.94 mm [.155]	O
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: AMP MCP 2.8K FLAT TYPE RECEPTACLE			
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE		
3.40-4.00 mm [1.34-.157 IN]	Ø1.10-1.40 mm [1.043-.055 IN]		
TERMINAL APPLICATION SPECIFICATION	114-18387		

TERMINALS APPLIED				SEAL INSULATION DIAMETER RANGE
TE TERMINAL	TE TERMINAL	TE SEAL	TE SEAL	
1564984-1	1564984-3		963294-1	Ø1.2-2.0
1564984-2				

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.35mm2	1.11+/-0.03 [1.044+/-0.001]	5.8
0.22mm2	1.05+/-0.03 [1.041+/-0.001]	6.6

- 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 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.
  - 6 TERMINAL LUBRICANT IS RECOMMENDED.
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
8-2151484-1	2151484-1	1	WIRE CRIMPER	1-1803547-3
8-2151484-2	2151484-2	3	INSULATION CRIMPER	2-1803604-9
9-2151484-1	2-2151484-1	46	BASIC SUB -ASSEMBLY	1803940-9
9-2151484-2	2-2151484-2	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					
A	66	P	LTN	DESCRIPTION	DATE	OWN	APVD
		-		SEE SHEET 1	-	-	-

-	1	1	2119082-7	CAM, SNAIL, INSULATION ADJUSTMENT	244	
-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243	
-	1	1	2119083-1	RETAINER, INSULATION DIAL	242	
3	-	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	1	994970-2	COUNTER, MAGNETIC	164
-	1	-	1	2119641-2	FEED CAM, AIR FEED	151
-	1	1	1	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	144
-	4	4	1	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	143
-	-	1	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
6	-	1	1	2844908-1	SCREW, LOCKING	99
-	1	1	1	2844907-1	POST, LOCKING	98
-	1	1	1	455888-4	SPACER, CRIMPER -	82
-	1	1	1	1803607-3	DOCUMENTATION PACKAGE	71
-	1	1	1	2119740-1	TAG, IDENTIFICATION	67
-	2	2	1	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	985575-3	SCR, FLT SKT HD CAP M3 X 10.0	57
5	-	1	1	1338685-1	PAWL, FEED	56
-	2	2	1	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	53
-	1	1	1	1803382-2	HOLD DOWN, SPRING LOADED	50
-	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	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
-	1	1	1	1-1752356-7	SUPPORT, TERMINAL	34
-	2	2	1	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	1	2-2844962-8	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	1	2844992-1	ASSEMBLY, STRIP GUIDE -	29
-	1	1	1	455888-4	SPACER, CRIMPER -	28
-	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	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
7	-	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
7	-	1	1	318707-1	FLOATING SHEAR, FRONT	9
7	1	1	1	3-1633129-7	ANVIL, COMBINATION .062	8
7	-	1	1	2-240641-8	SPACER	7
-	-	-	-	-	-	7
-	-	-	-	-	-	6
-	1	1	1	2119781-1	DEPRESSOR, SHEAR	5
-	1	1	1	238011-4	BLOCK, CRIMPER SPACER	4
7	1	1	1	2-2119784-9	CRIMPER, INSULATION O PREMIUM	3
-	1	1	1	455888-9	SPACER, CRIMPER -	2
7	1	1	1	1-456403-3	CRIMPER, WIRE PREMIUM	1

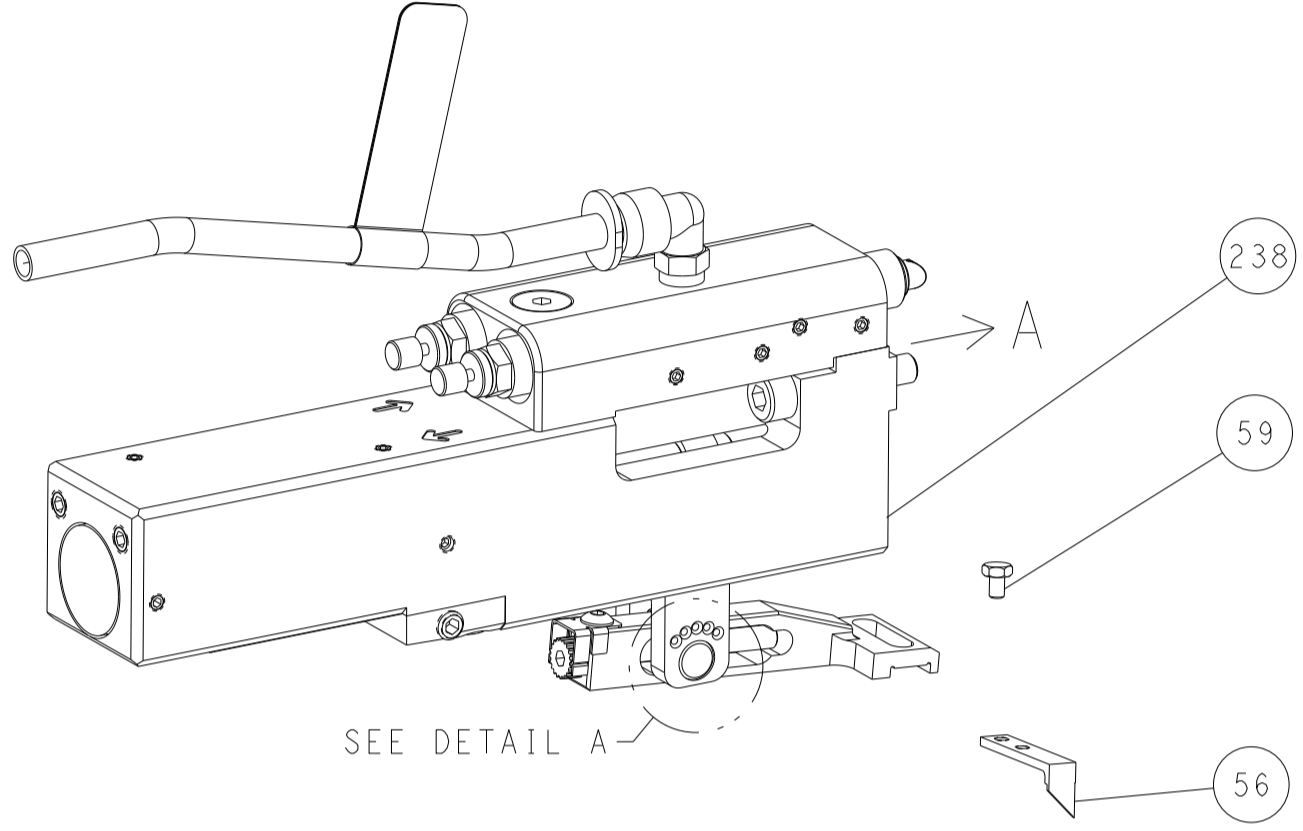
DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH		DWN H. HUANG 12MAR2012 CHK S. XI 12MAR2012 APVD S. XI 12MAR2012 PRODUCT SPEC APPLICATION SPEC WEIGHT SCALE 1:2 SHEET 3 OF 4 REV P		NAME Ocean Side Feed Applicator SIZE CAGE CODE DRAWING NO RESTRICTED TO A1 00779 C=2151484 Customer Accessible Production Drawing	
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LOC	DIST	REVISIONS					
A	66	P	LTM	DESCRIPTION	DATE	DWN	APVD
		-		SEE SHEET 1			

# FEED TYPE MECHANICAL



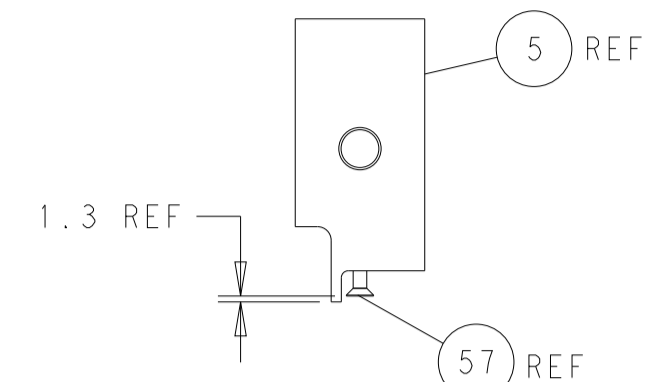
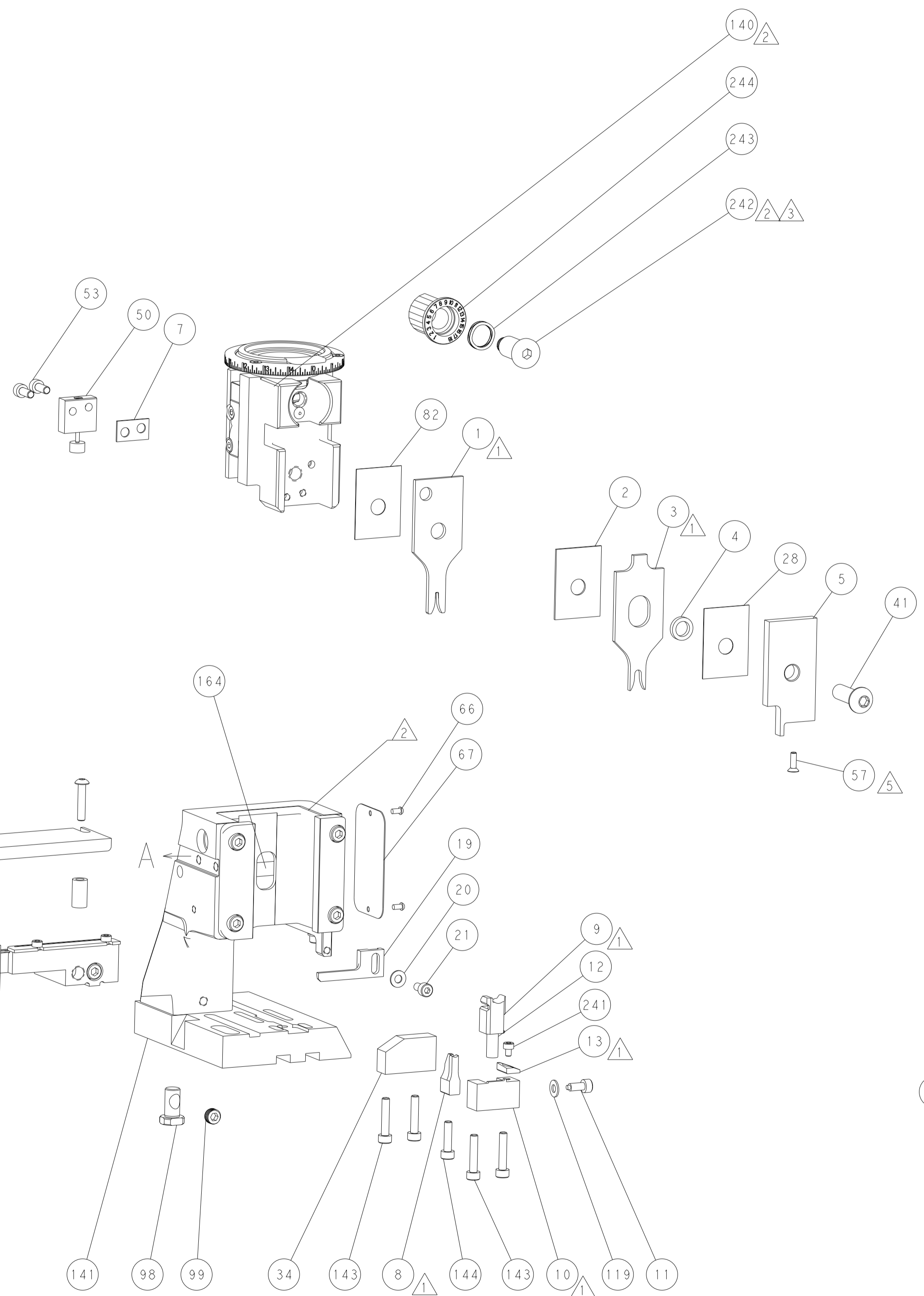
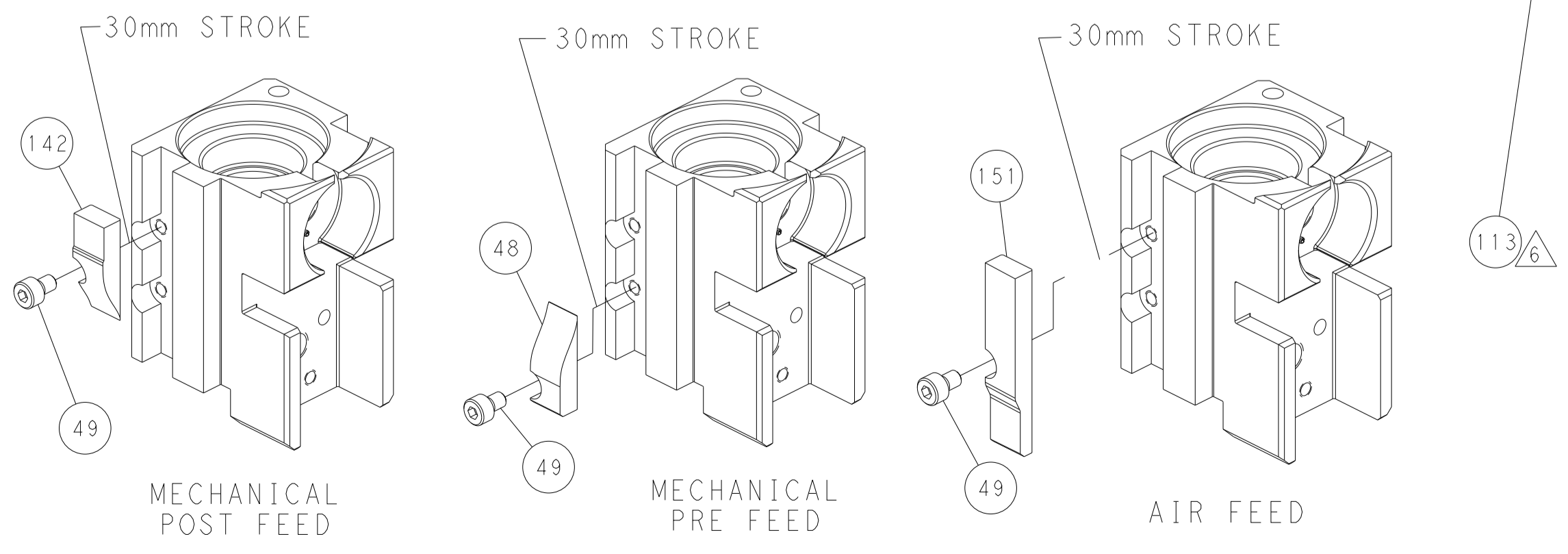
## PNEUMATIC



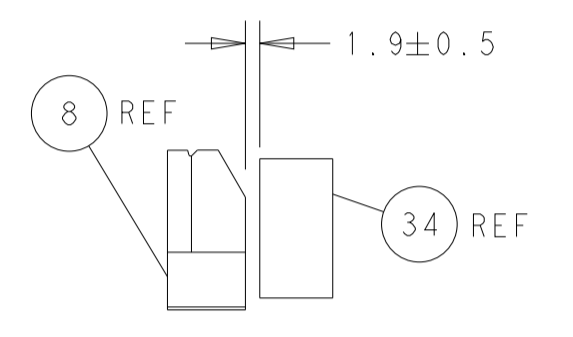
## FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



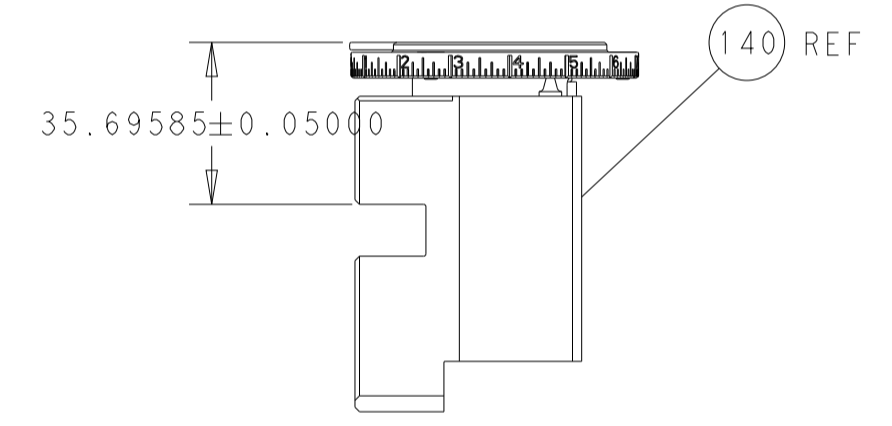
## CAM POSITIONS



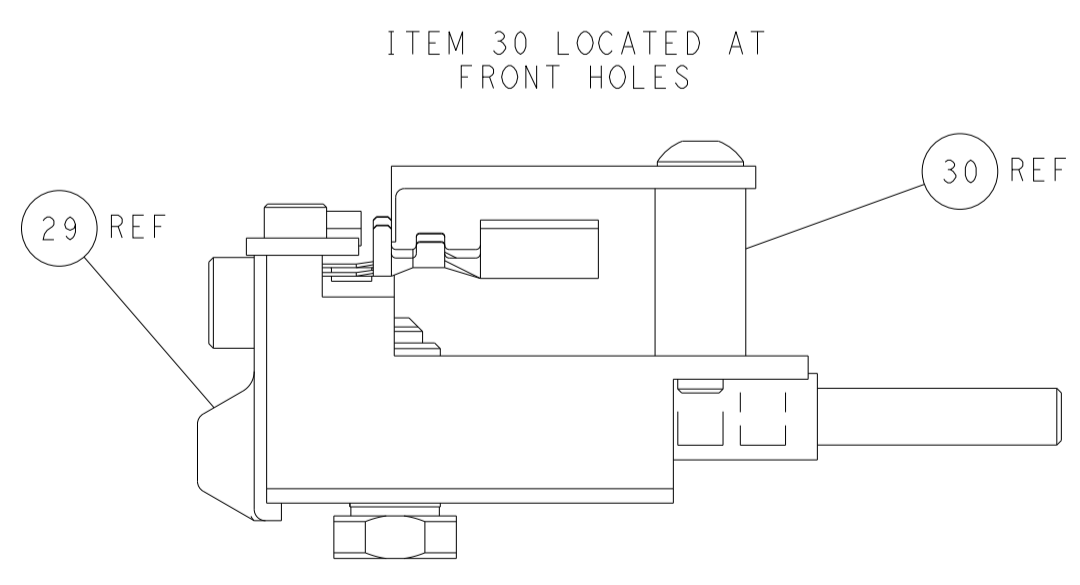
SHEAR DEPRESSOR DETAIL



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)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN K. HUANG 12MAR2012		TE Connectivity Harrisburg, PA 17105-3608	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	APVD S. XI 12MAR2012	NAME Ocean Side Feed Applicator
MATERIAL	FINISH	WEIGHT	SCALE	SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
			1:2	A1	00779	©=2151484	
Customer Accessible Production Drawing				SHEET	4	OF	4
				REV	P		