

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151462-1	A	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2151462-2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151462-1	A	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2151462-2	A	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2151462-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.54 mm [.100]	F
INSUL	4.90 mm [.193]	O

APPLICATOR INSTRUCTIONS 408-35042

TERMINAL DATA: DELPHI TERMINAL DELPHI CRIMP SPECIFICATION	
TERMINAL NAME: FEMALE METRI-PACK 280	
WIRE STRIP LENGTH 4.22-4.98 mm [.166-.196 IN]	TERMINAL INSULATION DIAMETER RANGE Ø3.38-4.50 mm [.133-.177 IN]
TERMINAL APPLICATION SPECIFICATION DEC00413170 Rev 05	AT9106

TERMINALS APPLIED				SEAL INSULATION DIAMETER RANGE
TE TERMINAL	DELPHI TERMINAL	TE SEAL	DELPHI SEAL	
1572376-1	15363933	1949807-1	15324982	Ø2.00-2.85
		1949807-2	15324984	Ø2.00-2.42

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
2.00mm2	1.90+/-0.05 [.075+/- .002]	5.7
1.50mm2	1.80+/-0.05 [.071+/- .002]	6.7
1.00mm2	1.70+/-0.05 [.067+/- .002]	7.7

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

***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)

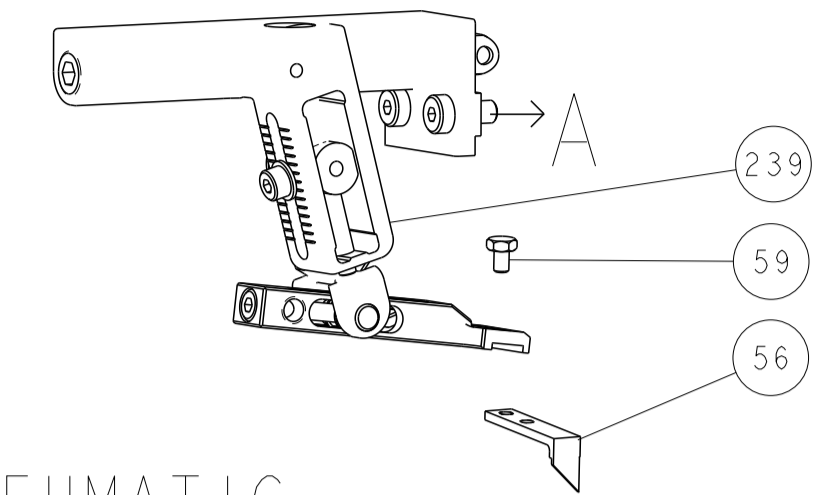
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		P	LTN	DESCRIPTION	DATE	DWN	APVD
A	66			RELEASED	07JUN2022	LG	TE

-	1	1	1	1	1803945-4	TONKER	300	
-	1	1	1	1	22278-9	SPRING, COMPRESSION	299	
-	2	2	2	2	4-18032-3	SCR, SET, FLT PNT, M3 X 6.0	298	
-	1	1	1	1	1803944-1	SPACER, TONKER	297	
-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248	
-	1	1	1	1	2119082-7	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	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	994970-2	COUNTER, MAGNETIC	164	
-	1	1	1	1	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113	
-	1	1	1	1	2844908-1	SCREW, LOCKING	99	
-	1	1	1	1	2844907-1	POST, LOCKING	98	
-	1	1	1	1	455888-4	SPACER, CRIMPER	82	
-	1	1	1	1	1803607-3	DOCUMENTATION PACKAGE	71	
-	1	1	1	1	2119791-5	DEPRESSOR, WIRE	70	
-	1	1	1	1	2119943-1	WASHER, SPACER	69	
-	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	985575-3	SCR, FLT SKT HD CAP M3 X 10.0	57	
-	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	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	1752356-3	SUPPORT, TERMINAL	34	
-	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33	
-	2	2	2	2	2-2844962-8	SPACER, CYLINDRICAL, STRIP GUIDE	30	
-	1	1	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29	
-	1	1	1	1	455888-5	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	
-	2	2	2	2	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	1-356885-3	STOP, SHEAR	11	
-	1	1	1	1	2119805-1	SHEAR HOLDER, FRONT	10	
-	1	1	1	1	318707-1	FLOATING SHEAR, FRONT	9	
-	1	2	2	1	1	7-1803764-9	ANVIL, COMBINATION	8
-	-	-	-	-	-	-	7	
-	-	-	-	-	-	-	6	
-	1	1	1	1	2-2119781-4	DEPRESSOR, SHEAR	5	
-	1	1	1	1	238011-2	BLOCK, CRIMPER SPACER	4	
-	1	2	2	1	1	1803317-8	CRIMPER, INSULATION O	3
-	1	1	1	1	455888-4	SPACER, CRIMPER	2	
-	1	2	2	1	1	456407-5	CRIMPER, WIRE PREMIUM	1
-	77	72	71	2	-1	PART NO	DESCRIPTION	ITEM NO

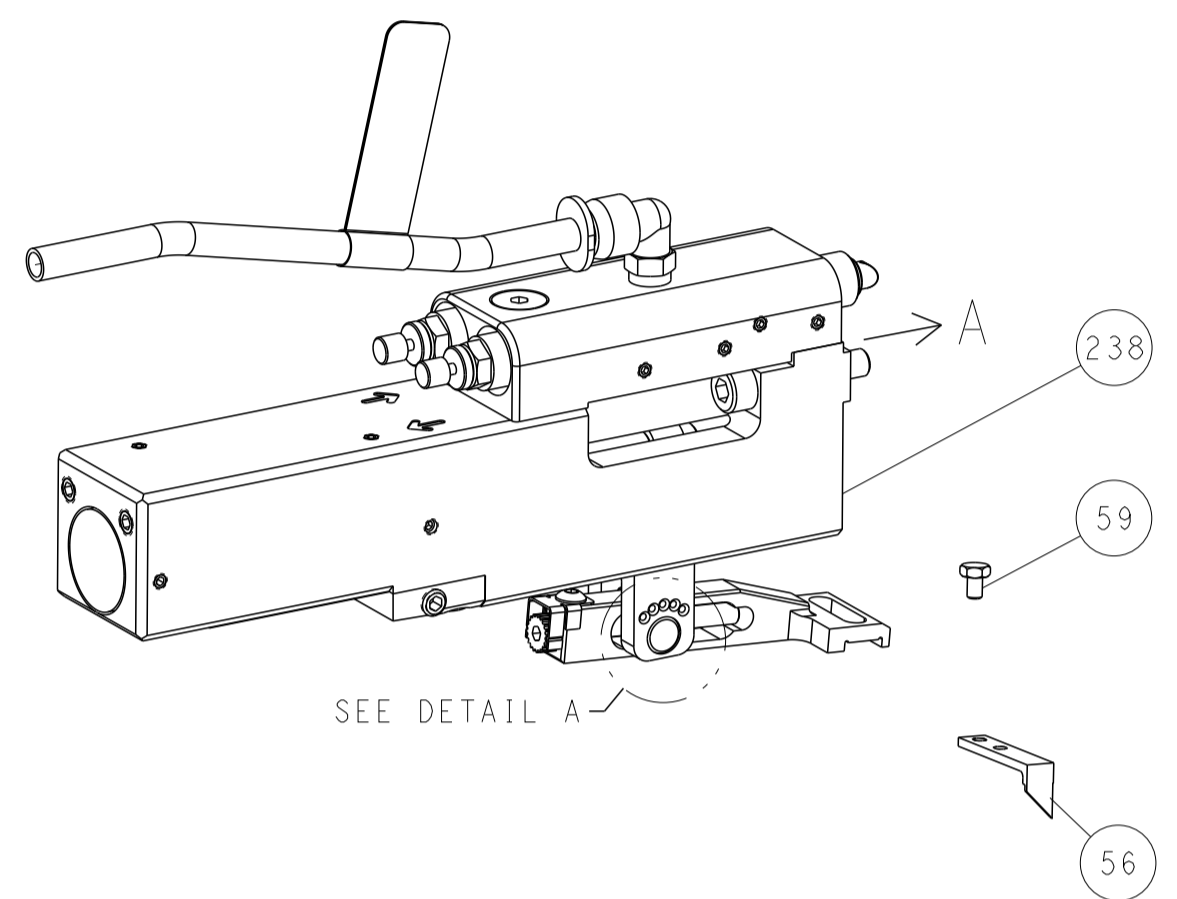
<small>THIS DRAWING IS UNPUBLISHED. IT IS THE PROPERTY OF TYCO ELECTRONICS CORPORATION. IT IS TO BE KEPT IN CONFIDENTIALITY AND NOT TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, INCLUDING PHOTOCOPYING, RECORDING, OR BY ANY INFORMATION STORAGE AND RETRIEVAL SYSTEM, WITHOUT PERMISSION IN WRITING FROM TYCO ELECTRONICS CORPORATION. SHOULD BE CONTACTED FOR THE LATEST REVISION.</small>		DWN EL GROSS 28APR2022 CHE T. ELBIN 28APR2022	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 G. BEAVER 28APR2022 PRODUCT SPEC APPLICATION SPEC SIZE CAGE CODE DRAWING NO RESTRICTED TO A1 00779 ©=2151462 Customer Accessible Production Drawing SCALE 1:2 SHEET 1 OF 4 REV A

LOC	DIST	REVISIONS					
		P	LTN	DESCRIPTION	DATE	OWN	APVD
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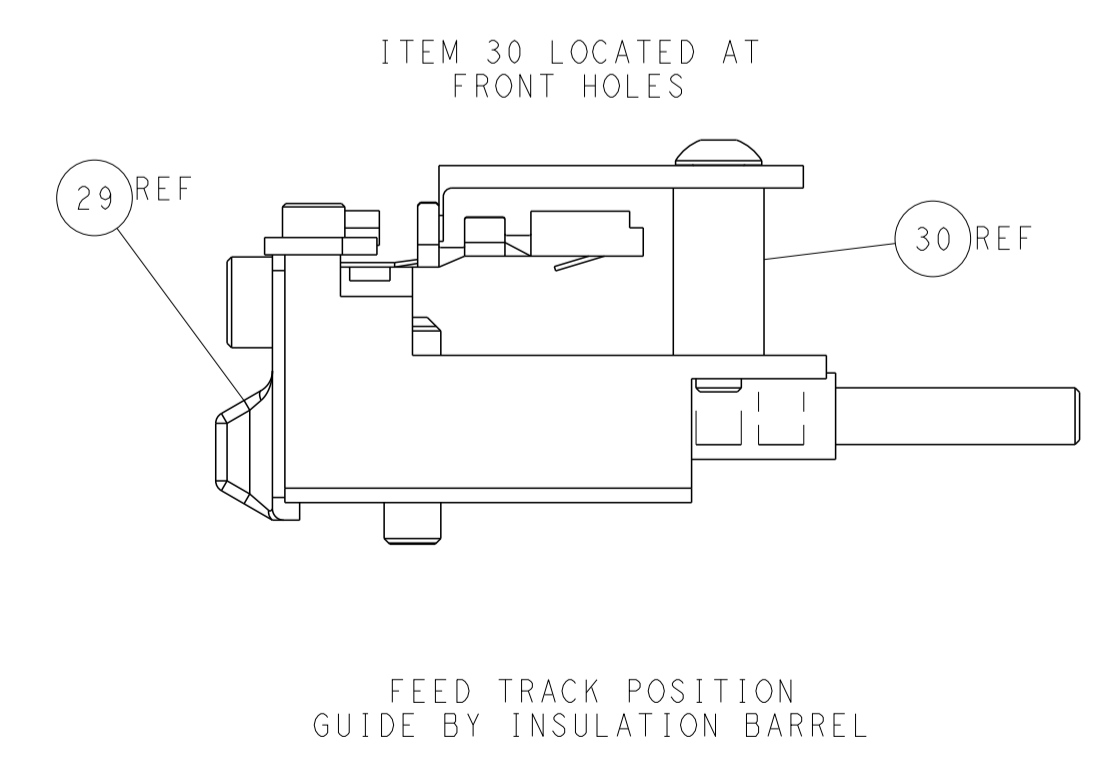
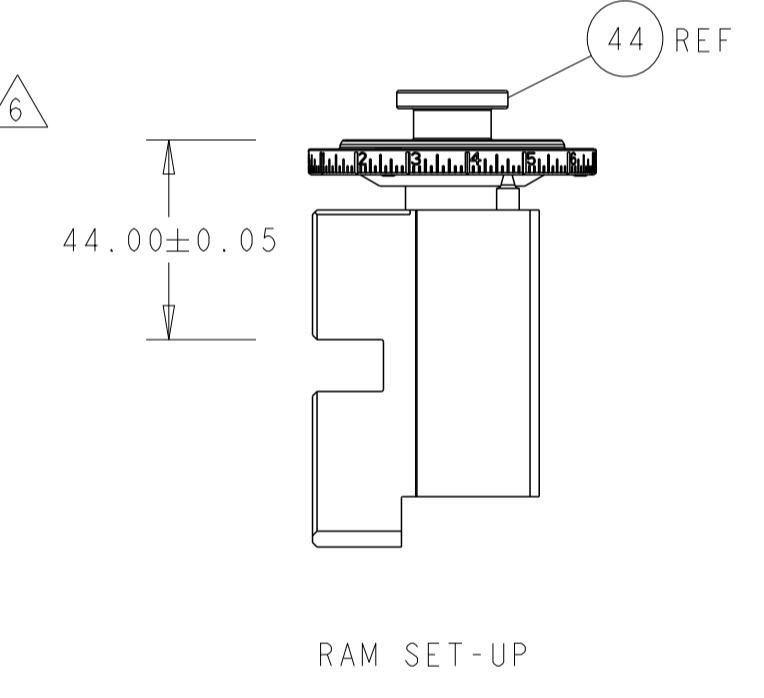
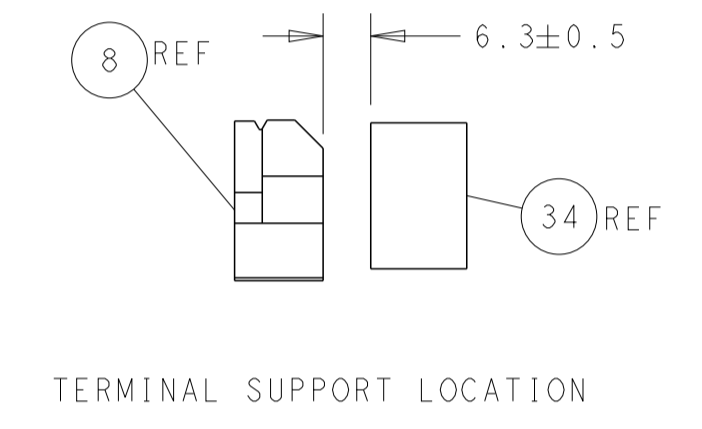
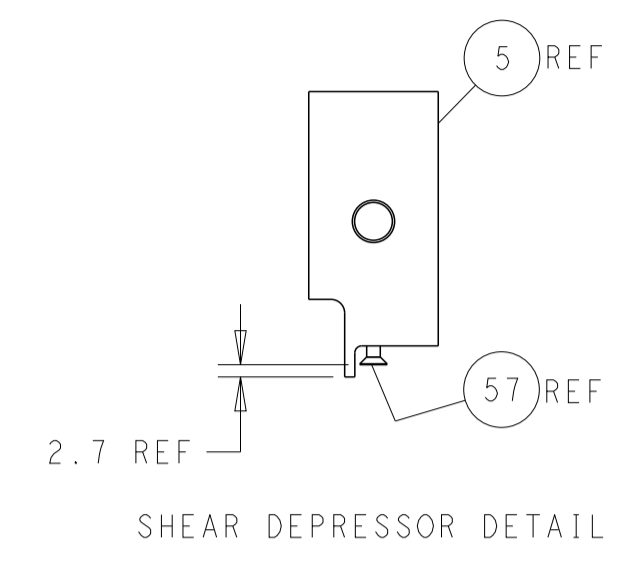
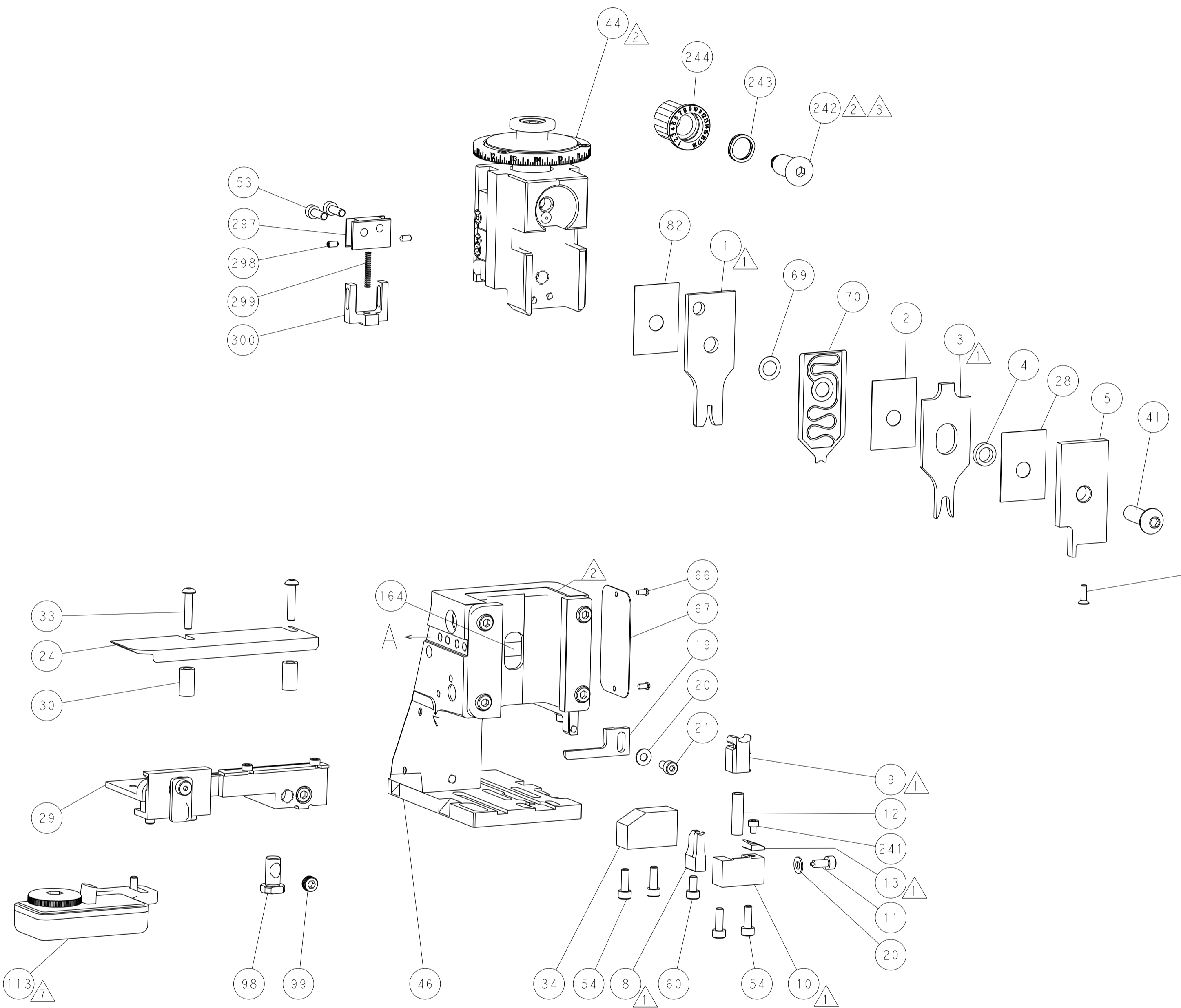
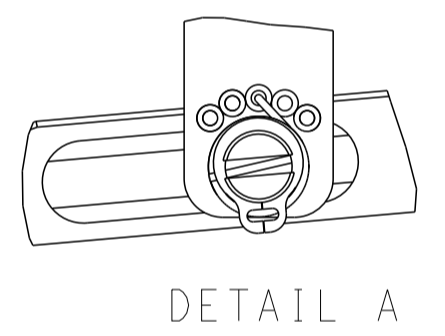
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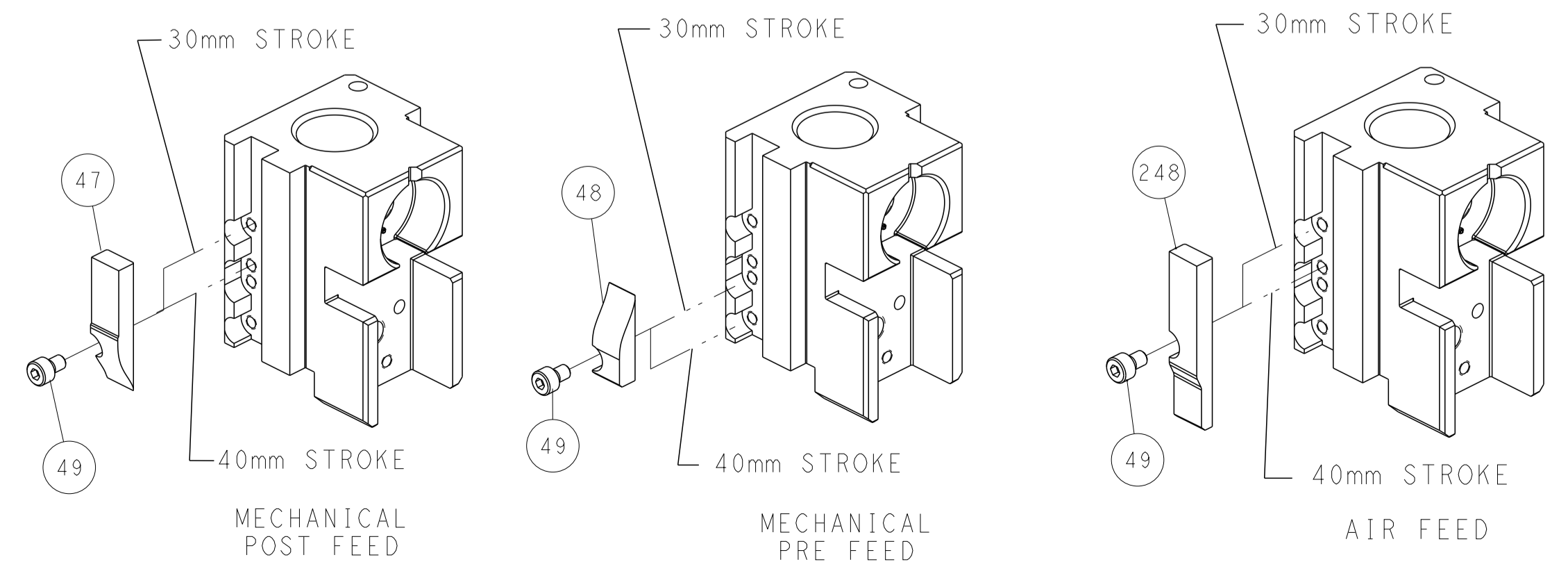
PNEUMATIC



FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



CAM POSITIONS



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

<small>THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.</small>		DWN: L. GROSS 28APR2022 CHK: T. ELBIN 28APR2022 APVD: G. BEAVER 28APR2022	STE 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 2.0 Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2151462 RESTRICTED TO: -
MATERIAL: -		WEIGHT: - SCALE: 1:2 SHEET: 2 of 4 REV: A	Customer Accessible Production Drawing

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2151462-1	A	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2151462-2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151462-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
 INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.54 mm [.100]	F
INSUL	4.90 mm [.193]	O

APPLICATOR INSTRUCTIONS
 408-35042

TERMINAL DATA: DELPHI TERMINAL DELPHI CRIMP SPECIFICATION			
TERMINAL NAME: FEMALE METRI -PACK 280			
WIRE STRIP LENGTH 4.22-4.98 mm [1.66-.196 IN]		TERMINAL INSULATION DIAMETER RANGE Ø3.38-4.50 mm [1.33-.177 IN]	
TERMINAL APPLICATION SPECIFICATION DEC00413170 Rev 05			AT9106
TERMINALS APPLIED			
TE TERMINAL	DELPHI TERMINAL	TE SEAL	DELPHI SEAL
1572376-1	15363933	1949807-1	15324982
		1949807-2	15324984

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
2.00mm2	1.90+/-0.05 [1.075+/-0.002]	5.7
1.50mm2	1.80+/-0.05 [1.071+/-0.002]	6.7
1.00mm2	1.70+/-0.05 [1.067+/-0.002]	7.7

- 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.
- 6. 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.
- 7. TERMINAL LUBRICANT IS RECOMMENDED.

***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)

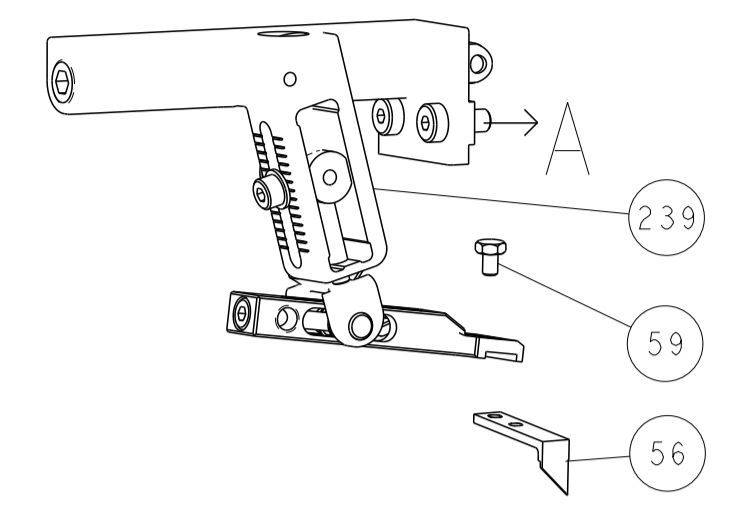
LOC	DIST	REV	DATE	BY	CHKD	APPD
A	66	-	-	-	-	-

REV	DATE	BY	CHKD	APPD	DESCRIPTION	ITEM NO
-	1	1			1803945-4 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			2119082-7 CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1			2079764-1 WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1			2119083-1 RETAINER, INSULATION DIAL	242
-	1	1			7-18023-7 SCR, SKT HD CAP M3 X 4.0	241
-	-	-			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			2119955-1 ASSY, LUBRICATOR, SIDE FEED	113
-	1	1			2844908-1 SCREW, LOCKING	99
-	1	1			2844907-1 POST, LOCKING	98
-	1	1			455888-4 SPACER, CRIMPER	82
-	1	1			1803607-3 DOCUMENTATION PACKAGE	71
-	1	1			2119791-5 DEPRESSOR, WIRE	70
-	1	1			2119943-1 WASHER, SPACER	69
-	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			2168083-3 SCR, SKT HD CAP, RoHS, M4 X 12.0	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			1752356-3 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			455888-5 SPACER, CRIMPER	28
-	1	1			1320928-2 STRIP GUIDE	24
-	1	1			2168083-2 SCR, SKT HD CAP, RoHS, M4 X 8.0	21
-	2	2			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			1-356885-3 STOP, SHEAR	11
-	1	1			2119805-1 SHEAR HOLDER, FRONT	10
-	1	1			318707-1 FLOATING SHEAR, FRONT	9
-	1	1			7-1803764-9 ANVIL, COMBINATION	8
-	-	-			-	7
-	-	-			-	6
-	1	1			2-2119781-4 DEPRESSOR, SHEAR	5
-	1	1			238011-2 BLOCK, CRIMPER SPACER	4
-	1	1			1803317-8 CRIMPER, INSULATION O	3
-	1	1			455888-4 SPACER, CRIMPER	2
-	1	1			456407-5 CRIMPER, WIRE PREMIUM	1

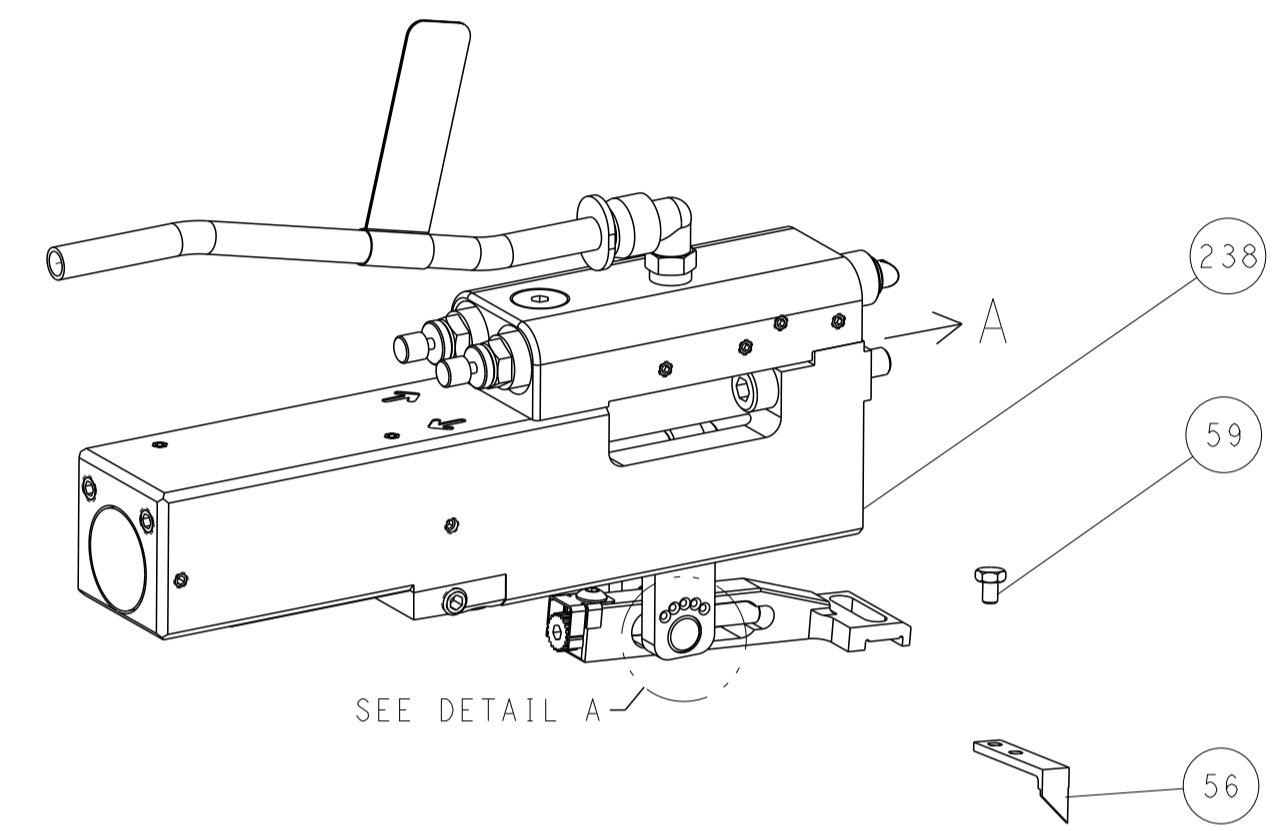
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0 PLC	±	1 PLC	±	APVD: G. BEAVER 28APR2022	PRODUCT SPEC		SIZE: A1		
2 PLC	±	3 PLC	±	APPLICATION SPEC		CAGE CODE: 00779		DRAWING NO: 2151462	
4 PLC	±	ANGLES	±	WEIGHT		SCALE: 1:2		SHEET: 3 OF 4	
MATERIAL		FINISH		Customer Accessible Production Drawing		REV: A			

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

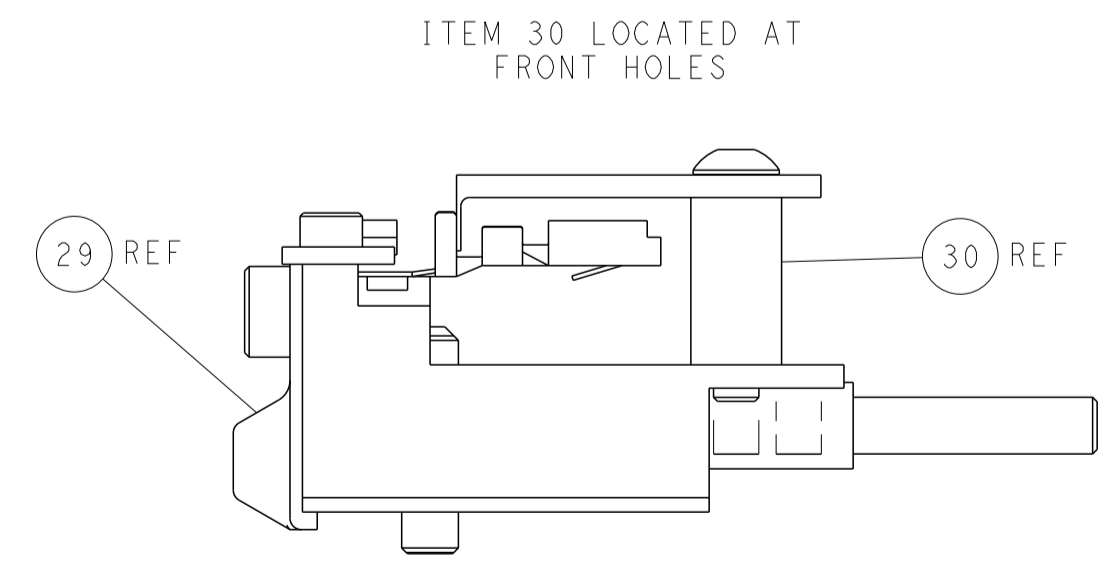
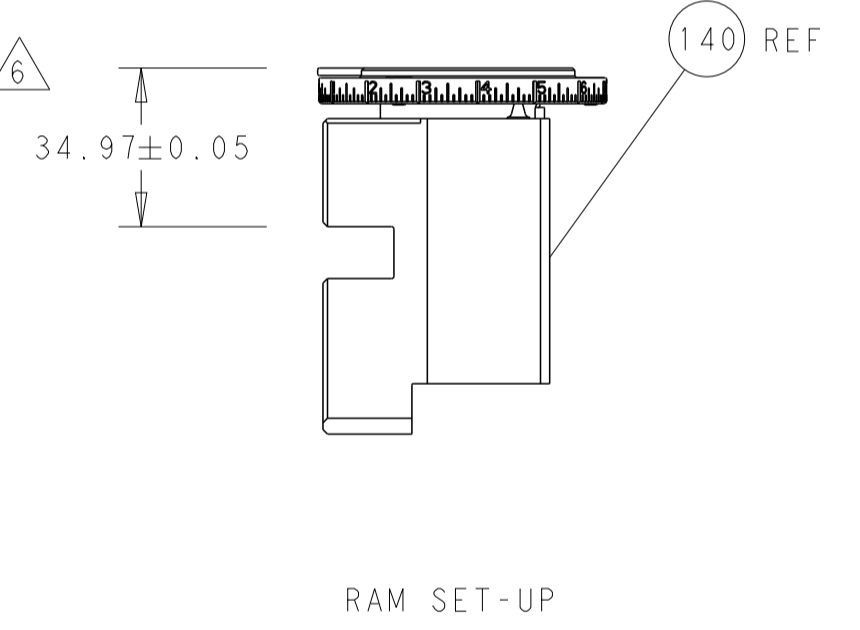
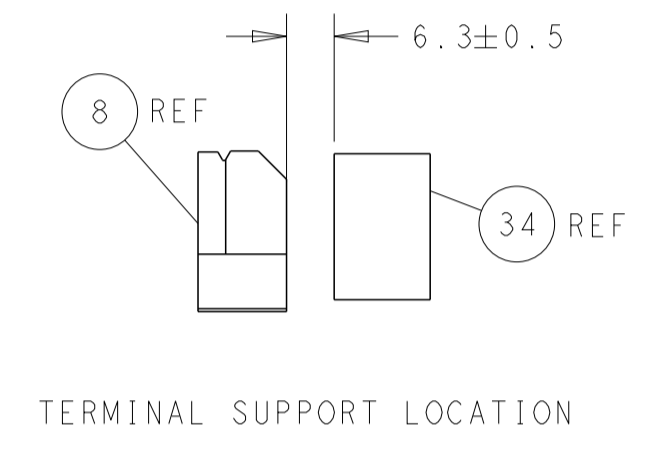
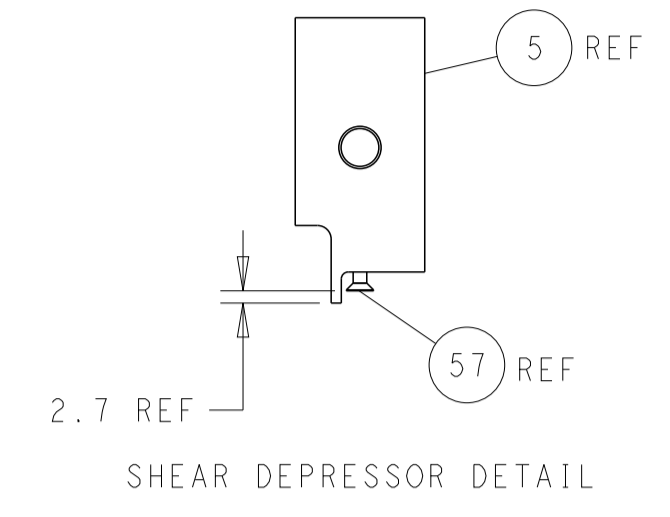
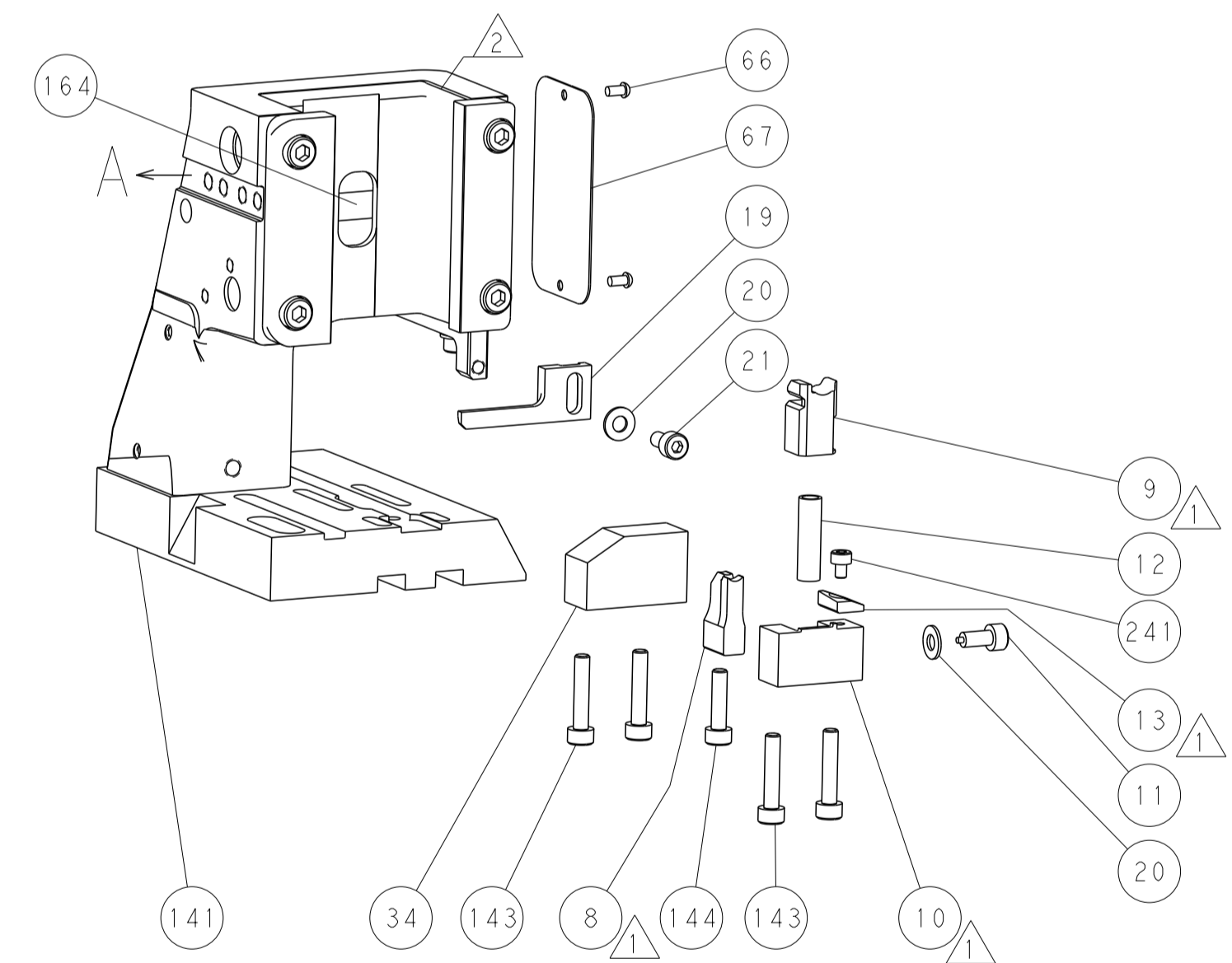
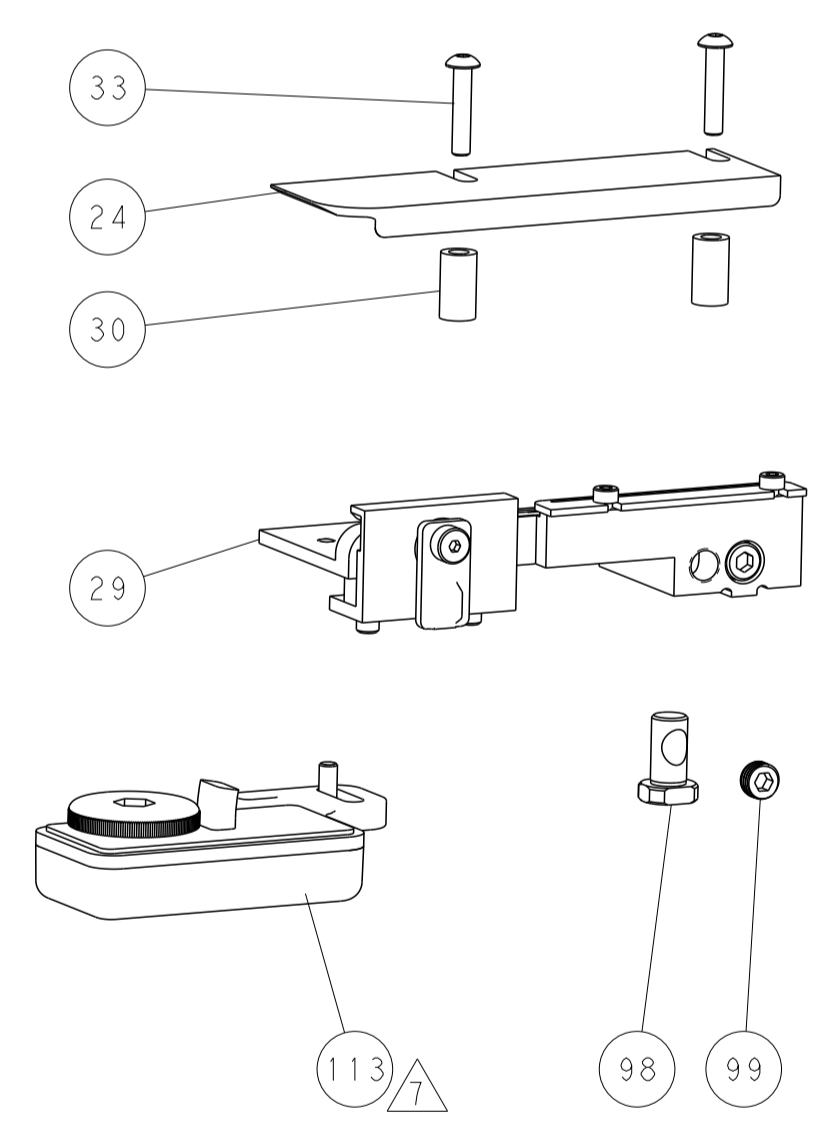
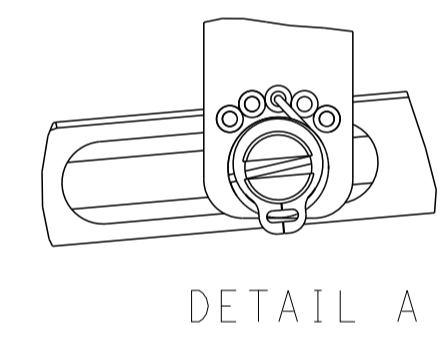
FEED TYPE MECHANICAL



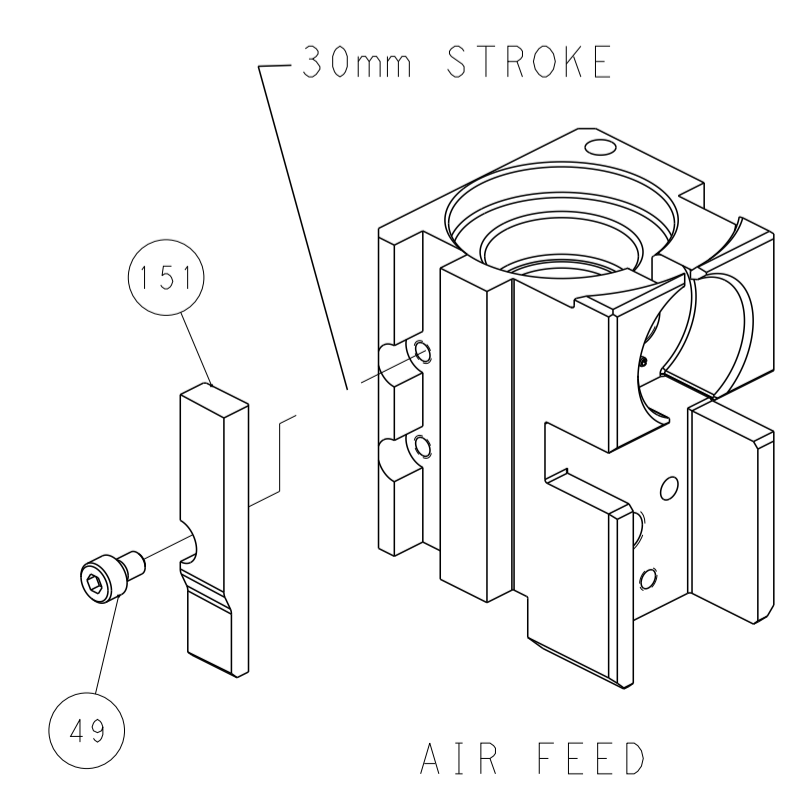
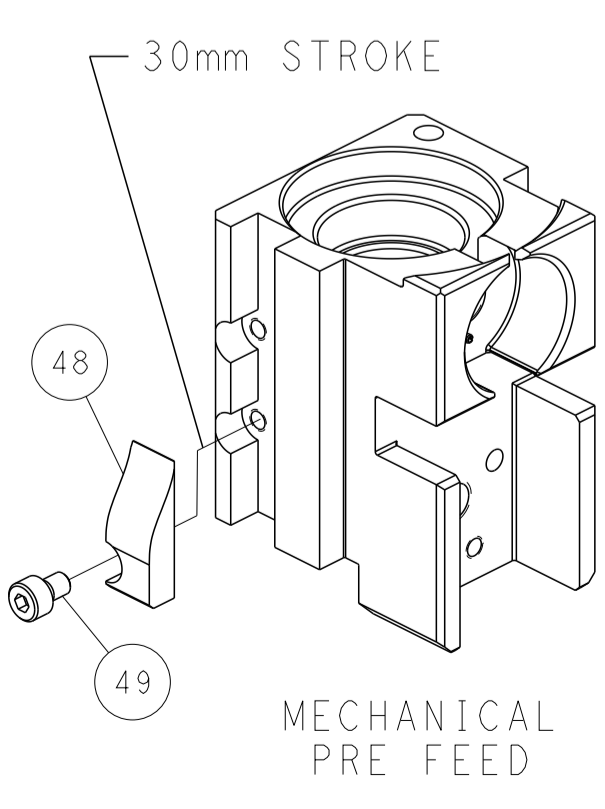
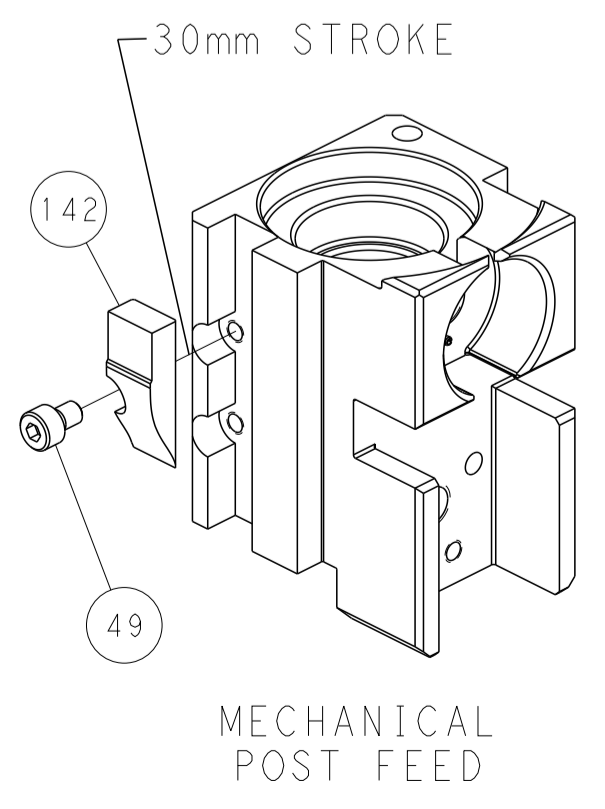
PNEUMATIC



FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



CAM POSITIONS



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 L.GROSS 28APR2022		TE Connectivity	
mm		0 PLC	±	CHK T.ELBIN 28APR2022		Harrisburg, PA 17105-3608	
Ø		1 PLC	±	APP'D G.BEAVER 28APR2022		NAME	
H		2 PLC	±	PRODUCT SPEC		OCEAN 2.0 Side Feed Applicator	
L		3 PLC	±	APPLICATION SPEC		SIZE CAGE CODE DRAWING NO	
R		4 PLC	±	MATERIAL		A1 00779 C=2151462	
ANGLES		FINISH	±	WEIGHT		RESTRICTED TO	
				Customer Accessible Production Drawing		SCALE 1:2 SHEET 4 OF 4 REV A	