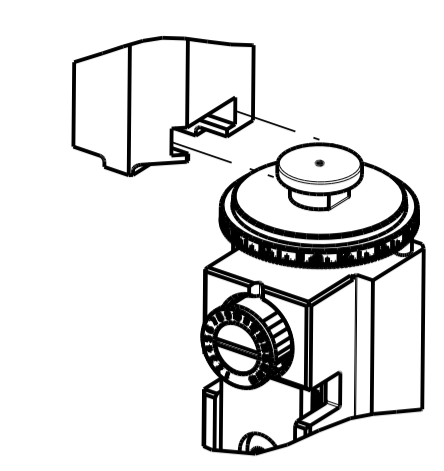


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151483-1	D	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2151483-2	E	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151483-1	D	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2151483-2	E	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2151483-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.57 mm [.062]	F
INSUL	2.03 mm [.080]	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	
3.1-3.7 mm [.122-.146 IN]		Ø1.10-1.40 mm [.043-.055 IN]	
TERMINAL APPLICATION SPECIFICATION	114-18387		
TERMINALS APPLIED <sup>5</sup>			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
1564982-1	1564982-2	1564982-3	

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.35mm2	1.11 +/- 0.03 [.044 +/- .001]	7.1
0.22mm2	1.05 +/- 0.03 [.041 +/- .001]	7.7

- RECOMMENDED SPARE PARTS
- <sup>2</sup> REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- <sup>3</sup> APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242.
- <sup>4</sup> 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.
- <sup>5</sup> TERMINAL LUBRICANT IS RECOMMENDED.
- 6. 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	LTN	DESCRIPTION	DATE	OWN	APPV
A	66	C		ECR-17-004636	30MAR2017	TB	TE
		D		ECR-18-006131	23APR2018	TB	JDG
		E		ECR-19-006015	15APR2019	FJ	CT
		E1		ECR-21-005672	21MAY2021	FJ	YY

-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248
-	1	1	1	1	2119082-5	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
<sup>3</sup>	-	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	1-18028-2	WASHER, FLAT, REG M4	119
<sup>5</sup>	-	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	455888-3	SPACER, CRIMPER	82
-	1	1	1	1	1803607-3	DOCUMENTATION PACKAGE	71
-	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	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	1	1	1	1803382-2	HOLD DOWN, SPRING LOADED	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	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	1-1752356-3	SUPPORT, TERMINAL	34
-	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	2	2	2-2844962-4	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29
-	1	1	1	1	1-455888-0	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
-	1	1	1	1	1-18028-2	WASHER, FLAT, REG M4	20
-	1	1	1	1	2119533-1	STRIPPER, SIDE FEED	19
<sup>1</sup>	-	1	1	1	2119806-1	INSERT, SHEAR	13
-	1	1	1	1	3-22280-3	SPRING, COMPRESSION	12
-	1	1	1	1	1-356885-4	STOP, SHEAR	11
<sup>1</sup>	-	1	1	1	2119805-1	SHEAR HOLDER, FRONT	10
<sup>1</sup>	-	1	1	1	1803095-1	FLOATING SHEAR, FRONT	9
<sup>1</sup>	1	2	2	1	3-1633129-6	ANVIL, COMBINATION .062	8
-	1	1	1	1	1-240641-1	SPACER	7
-	1	1	1	1	2119757-8	DEPRESSOR, SHEAR	5
-	1	1	1	1	1-238011-0	BLOCK, CRIMPER SPACER	4
<sup>1</sup>	1	2	2	1	2119784-3	CRIMPER, INSULATION O PREMIUM	3
-	1	1	1	1	455888-4	SPACER, CRIMPER	2
<sup>1</sup>	1	2	2	1	1333281-4	CRIMPER, WIRE PREMIUM	1
-77	-72	-71	-2	-1	PART NO	DESCRIPTION	ITEM NO

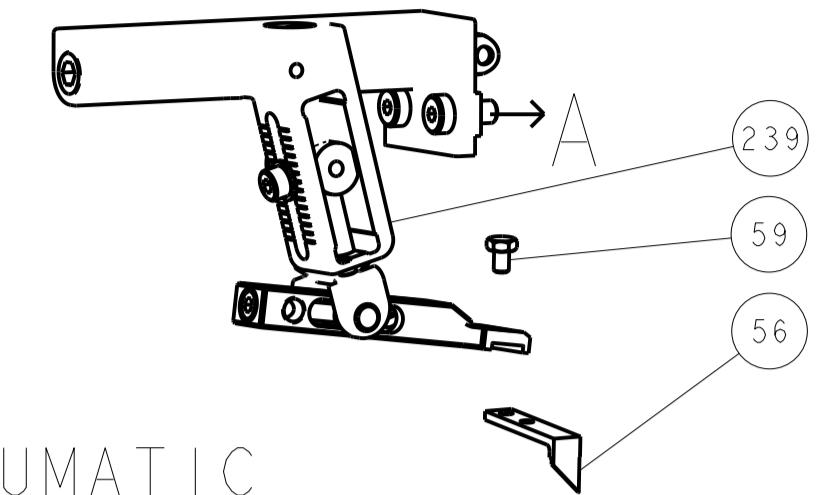
ATLANTIC VERSION  
Shown on sheets 1 of 4 & 2 of 4  
(Pacific version shown on sheets 3 of 4 & 4 of 4)

DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG: C. CHEN 12AUG2011		CHK: S. XI 12AUG2011		APVD: J. CRUZ 12AUG2011		NAME: Ocean Side Feed Applicator	
0 PLC ±		1 PLC ±		2 PLC ±		3 PLC ±		4 PLC ±		SIZE: A1	
ANGLES		FINISH		WEIGHT		SCALE: 1:2		SHEET 1 OF 4		REV: E1	
MATERIAL		FINISH		WEIGHT		SCALE: 1:2		SHEET 1 OF 4		REV: E1	

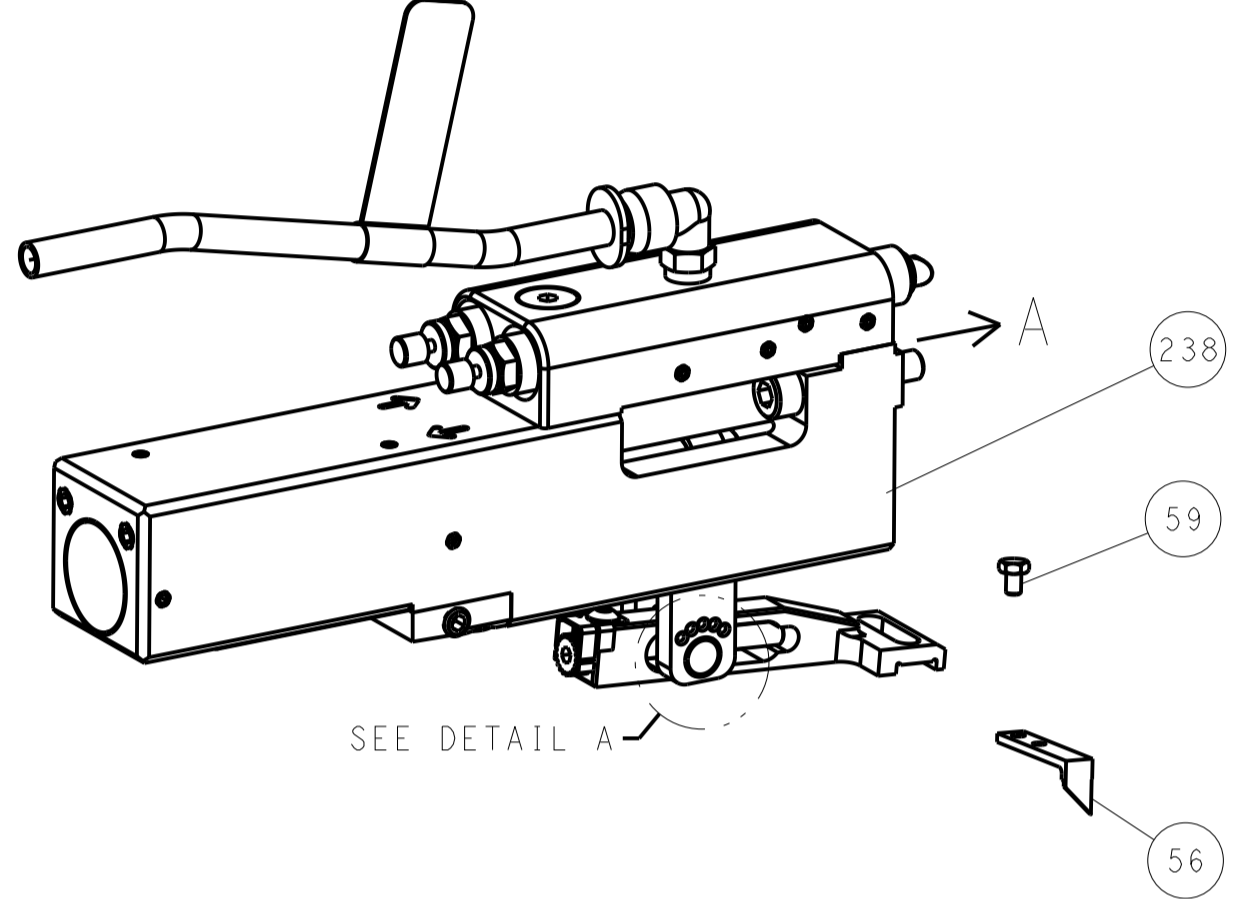
Customer Accessible Production Drawing

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

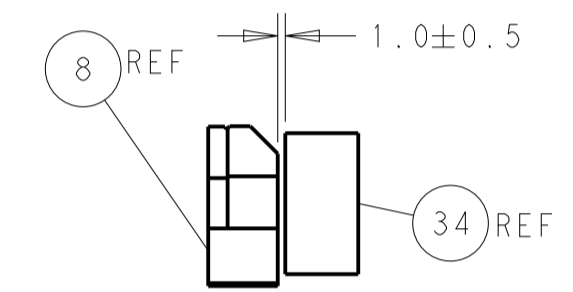
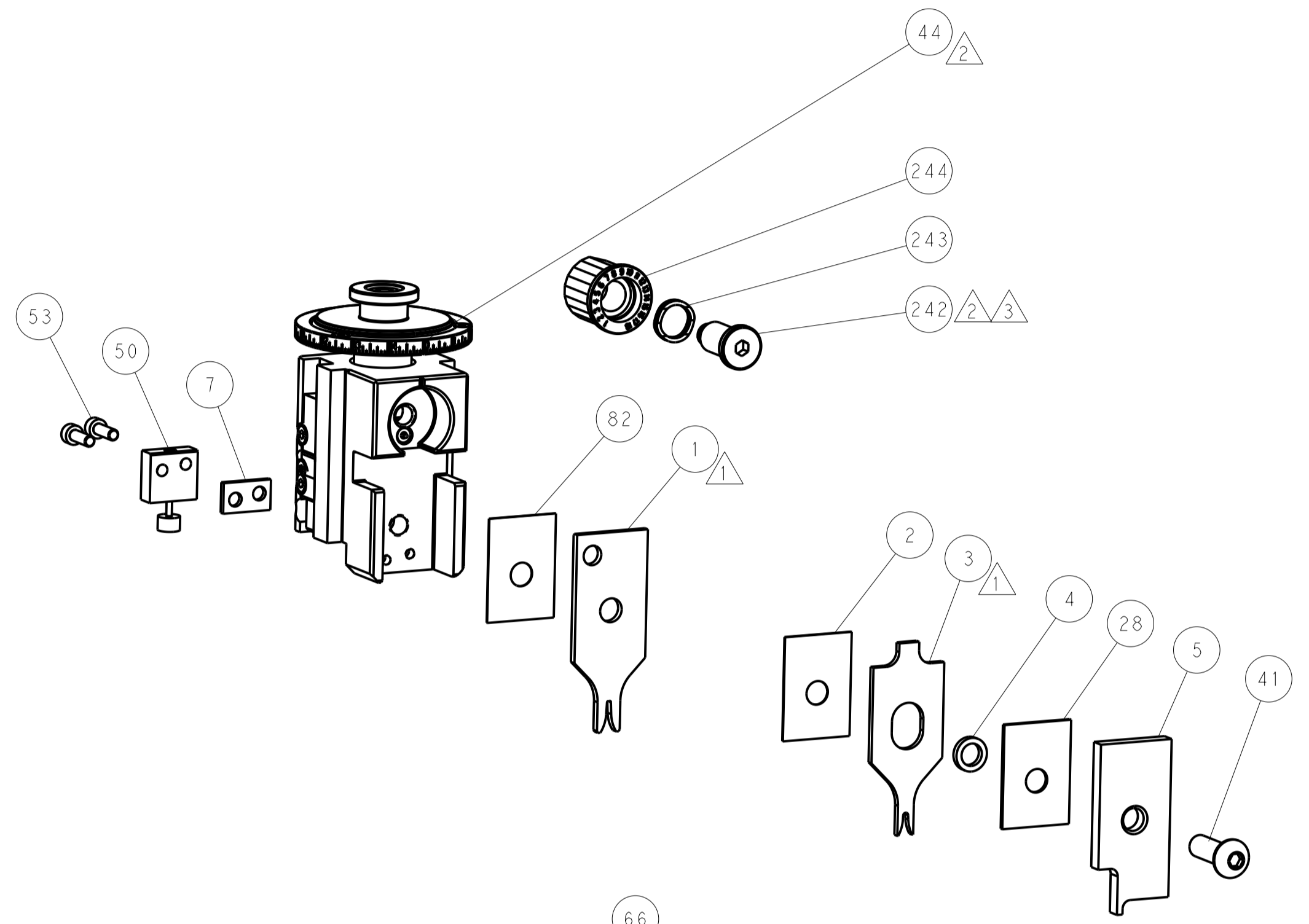
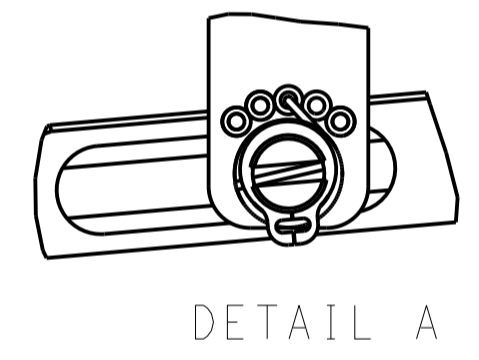
# FEED TYPE MECHANICAL



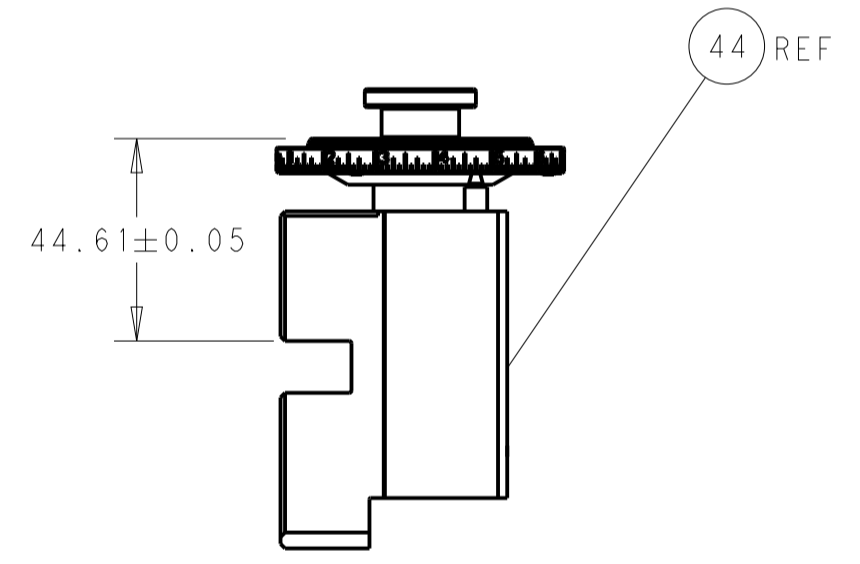
## PNEUMATIC



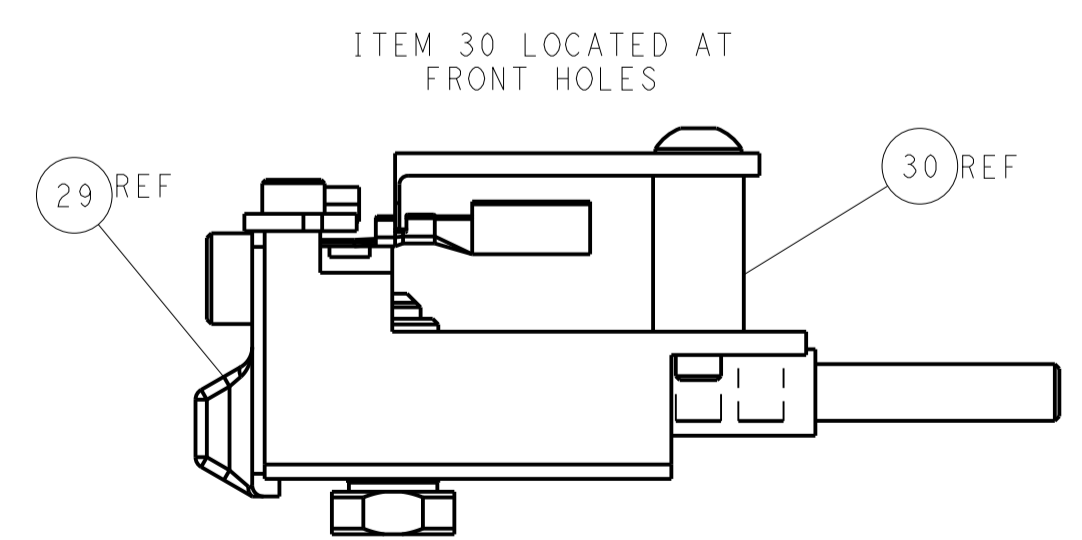
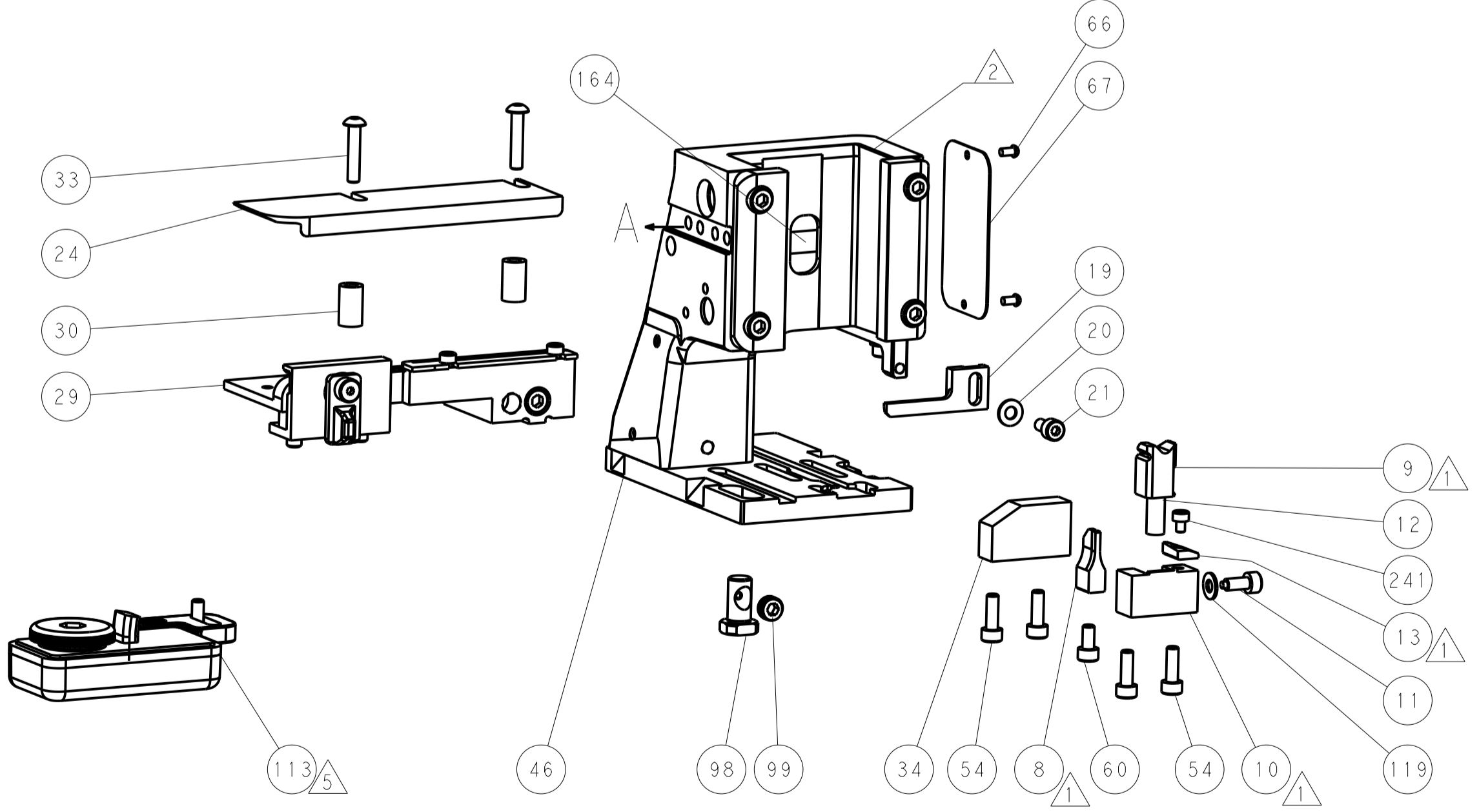
### FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



TERMINAL SUPPORT LOCATION

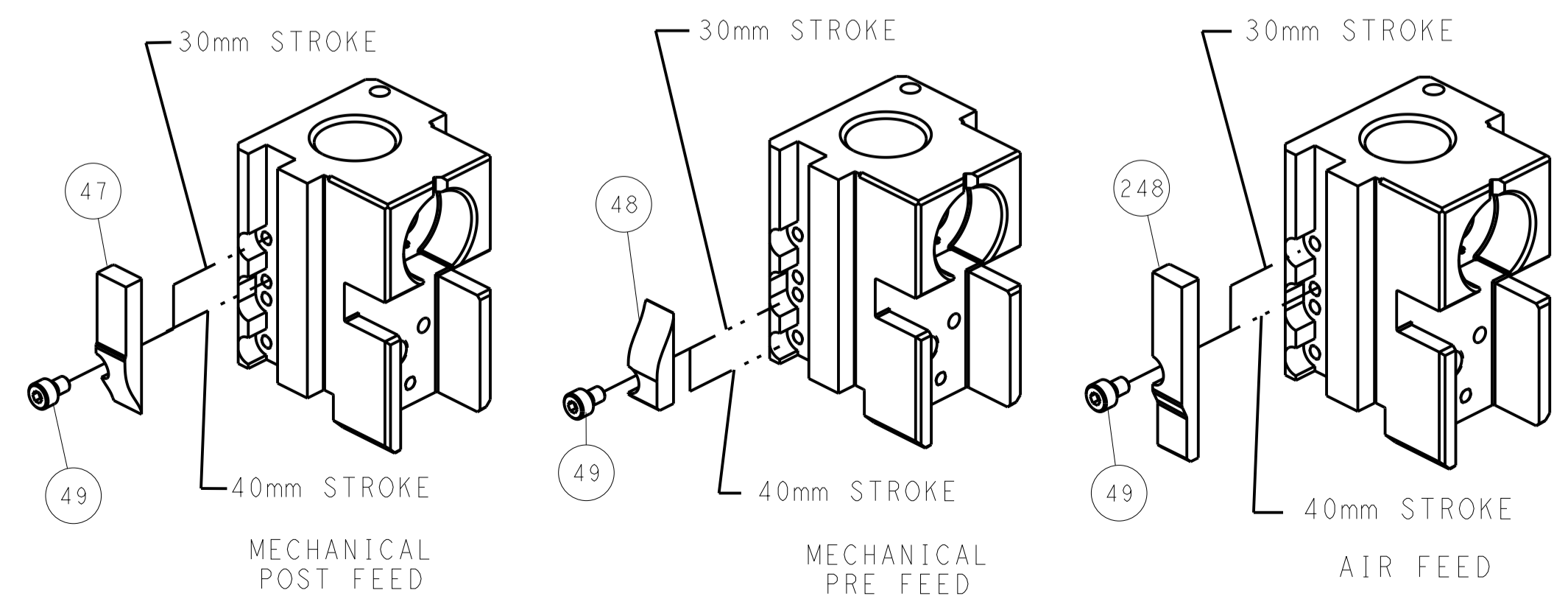


RAM SET-UP



ITEM 30 LOCATED AT FRONT HOLES

# CAM POSITIONS

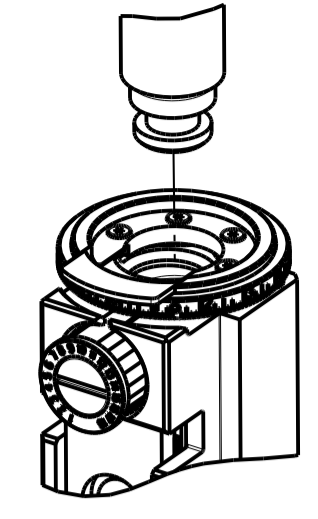


**ATLANTIC VERSION**  
 Shown on sheets 1 of 4 & 2 of 4  
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN 12AUG2011		TE Connectivity	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	Harrisburg, PA 17105-3608	
ANGLES	FINISH	WEIGHT	SCALE	SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
			1:2	A1	00779	©=2151483	
Customer Accessible Production Drawing				SHEET 2 OF 4 REV E1			

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2151483-1	D	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2151483-2	E	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151483-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR  
 INTERFACE ADAPTER

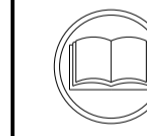


APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.57 mm [.062]	F
INSUL	2.03 mm [.080]	O

APPLICATOR INSTRUCTIONS  
 408-35042

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: AMP MCP 2.8K FLAT TYPE RECEPTACLE			
WIRE STRIP LENGTH 3.1-3.7 mm [.122-.146 IN]		INSULATION DIAMETER RANGE Ø1.10-1.40 mm [.043-.055 IN]	
TERMINAL APPLICATION SPECIFICATION	114-18387	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
1564982-1	1564982-2	1564982-3	

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.35mm2	1.11+/-0.03 [.044+/-0.001]	7.1
0.22mm2	1.05+/-0.03 [.041+/-0.001]	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.
- TERMINAL LUBRICANT IS RECOMMENDED.
- 6. 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
8-2151483-1	2151483-1	1	WIRE CRIMPER	1803545-4
8-2151483-2	2151483-2	3	INSULATION CRIMPER	1803604-3
9-2151483-1	2-2151483-1	46	BASIC SUB -ASSEMBLY	1803940-9
9-2151483-2	2-2151483-2	141	BASIC SUB -ASSEMBLY	1-1803940-0
			LUBRICATOR	DELETE

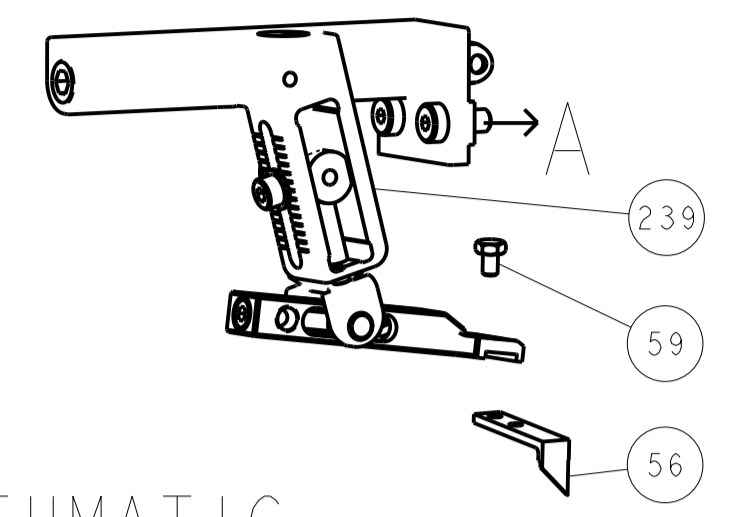
LOC		DIST		REVISIONS			
A	66	P	LTN	DESCRIPTION	DATE	OWN	APVD
-	-	-	-	SEE SHEET 1	-	-	-
-	1	1	2119082-5	CAM, SNAIL, INSULATION ADJUSTMENT			244
-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST			243
3	-	1	2119083-1	RETAINER, INSULATION DIAL			242
-	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0			241
-	-	1	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
5	-	1	2119955-1	ASSY, LUBRICATOR, SIDE FEED			113
-	1	1	2844908-1	SCREW, LOCKING			99
-	1	1	2844907-1	POST, LOCKING			98
-	1	1	455888-3	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	1338685-1	PAWL, FEED			56
-	2	2	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0			53
-	1	1	1803382-2	HOLD DOWN, SPRING LOADED			50
-	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	1-1752356-3	SUPPORT, TERMINAL			34
-	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)			33
-	2	2	2-2844962-4	SPACER, CYLINDRICAL, STRIP GUIDE			30
-	1	1	2844992-1	ASSEMBLY, STRIP GUIDE			29
-	1	1	1-455888-0	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	1803095-1	FLOATING SHEAR, FRONT			9
1	1	1	3-1633129-6	ANVIL, COMBINATION .062			8
-	1	1	1-240641-1	SPACER			7
-	1	1	2119757-8	DEPRESSOR, SHEAR			5
-	1	1	1-238011-0	BLOCK, CRIMPER SPACER			4
1	1	1	2119784-3	CRIMPER, INSULATION O PREMIUM			3
-	1	1	455888-4	SPACER, CRIMPER			2
1	1	1	1333281-4	CRIMPER, WIRE PREMIUM			1
-	-	-	-77-22-21	PART NO			
				DESCRIPTION			ITEM NO

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

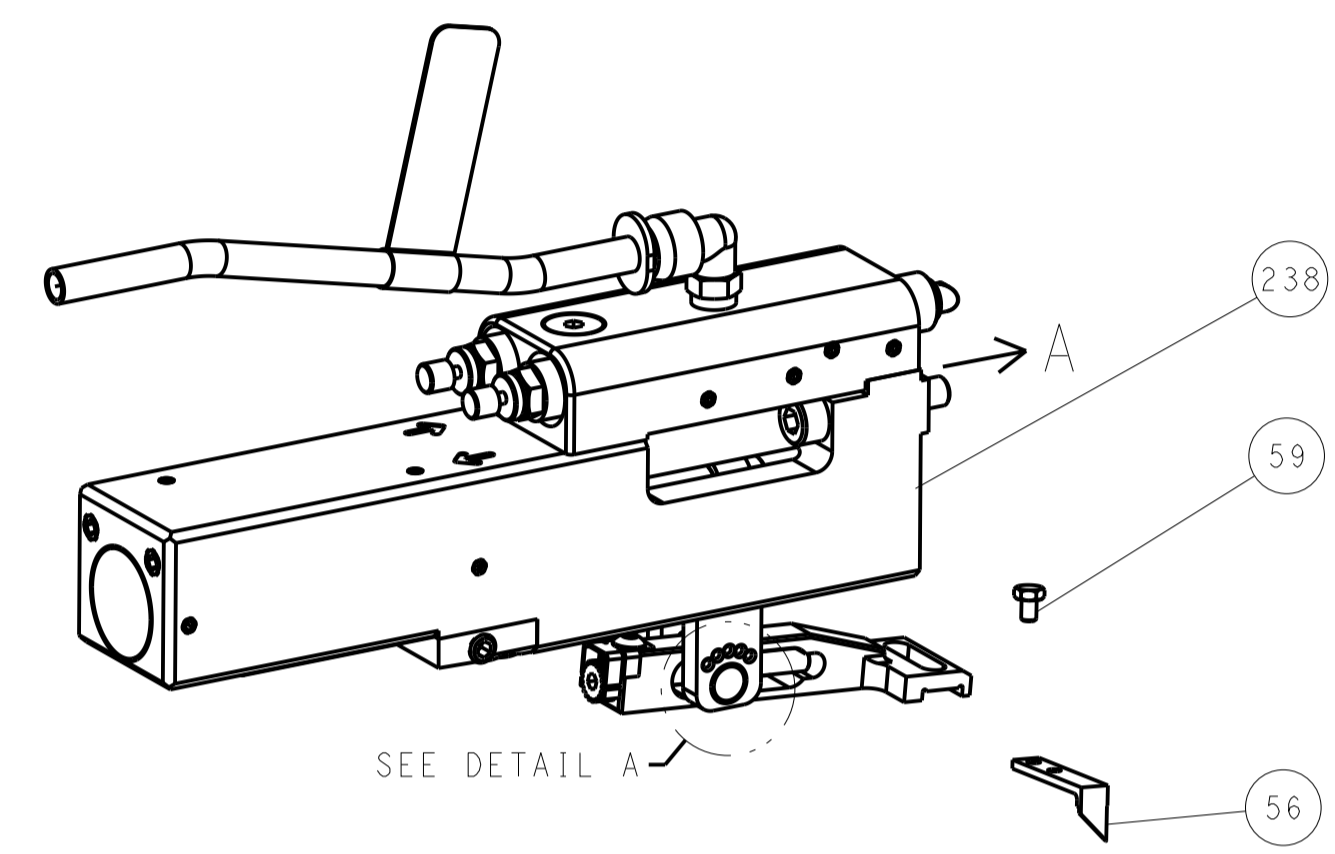
DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		DWG: C.CHEN 12AUG2011 CHK: S.XI 12AUG2011 APVD: I.CRUZ 12AUG2011		NAME: Ocean Side Feed Applicator SIZE: 00779 ©=2151483 SCALE: 1:2 SHEET 3 OF 4 REV: E1	
MATERIAL: -		FINISH: -		WEIGHT: -		RESTRICTED TO: -	

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

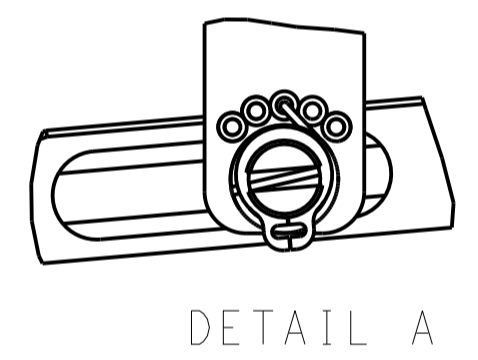
# FEED TYPE MECHANICAL



## PNEUMATIC

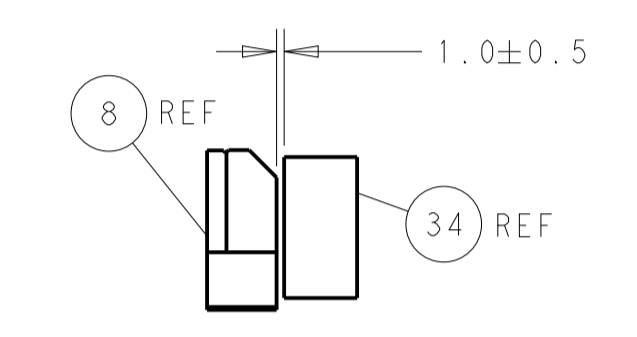
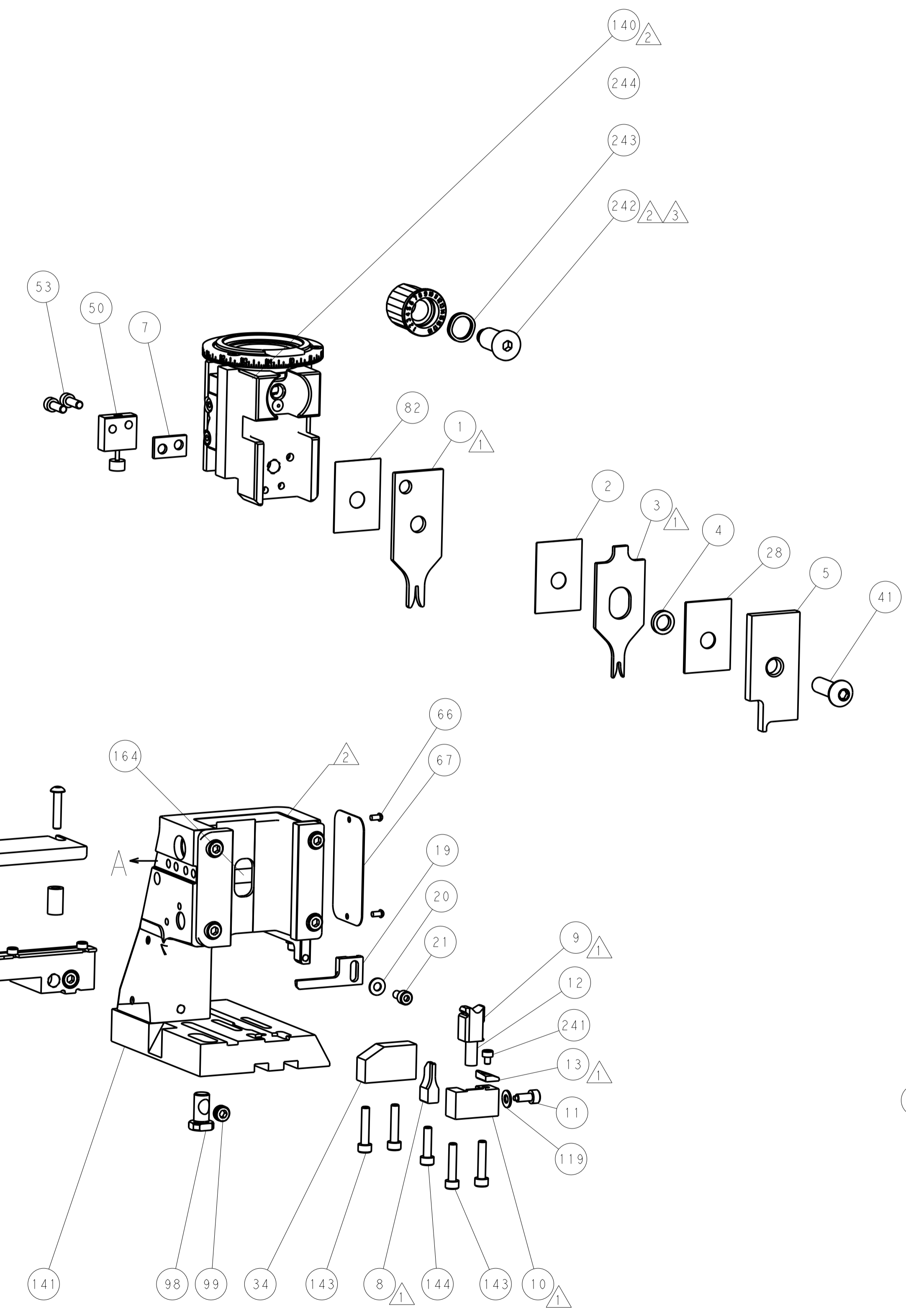
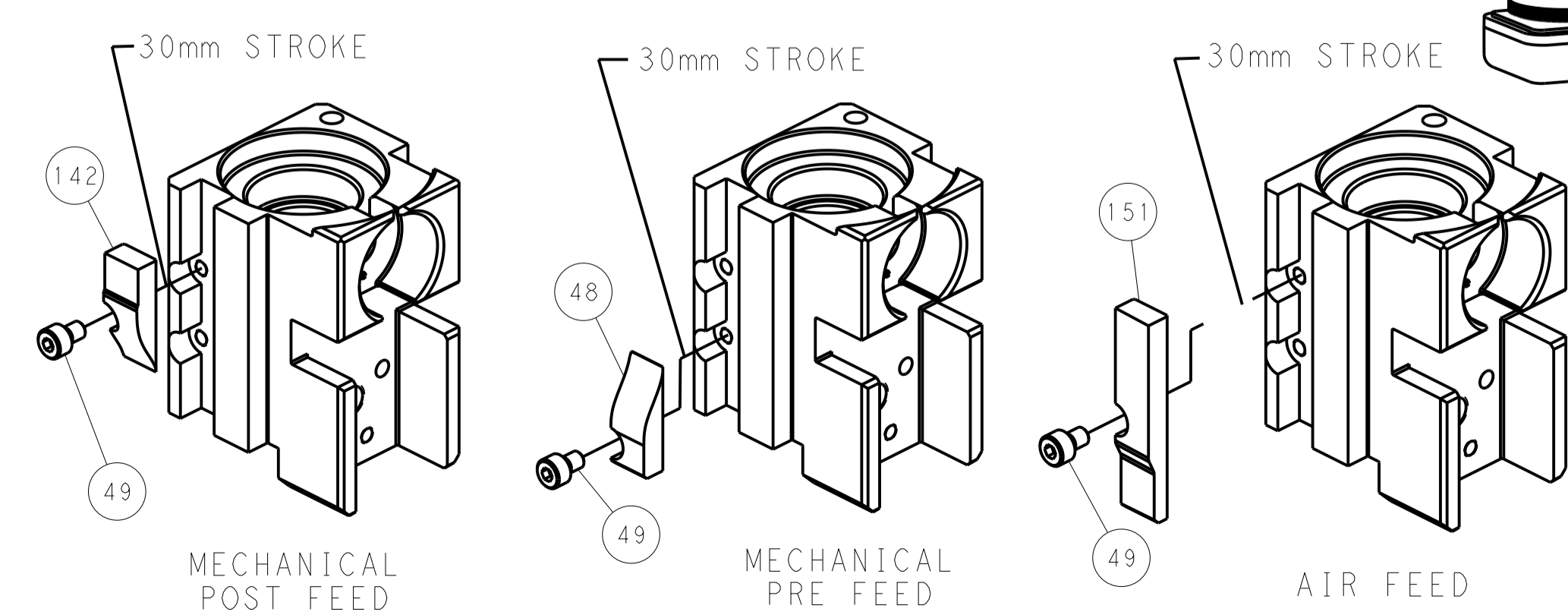


## FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)

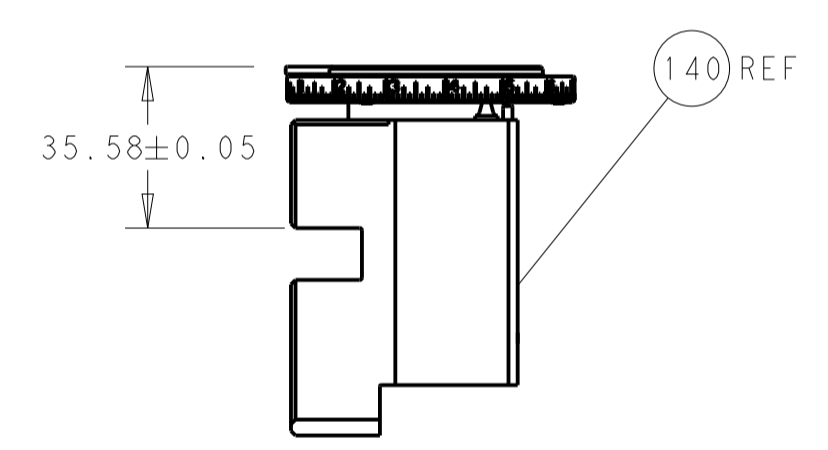


DETAIL A

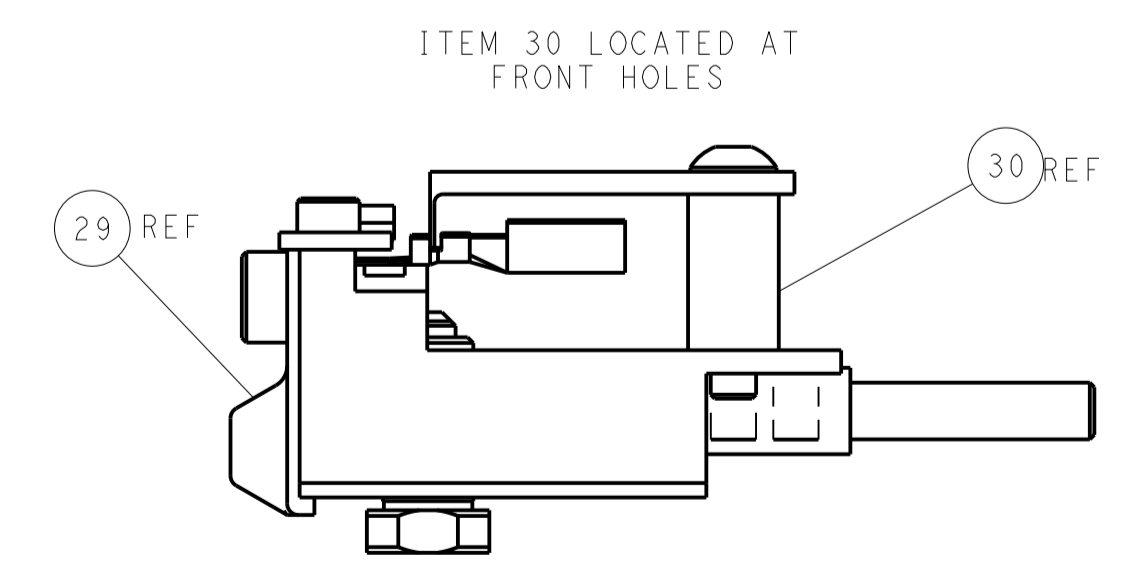
# CAM POSITIONS



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)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN: C. CHEN 12AUG2011		STE TE Connectivity	
mm	0 PLC	±		CHK: S. XI 12AUG2011	NAME: Ocean Side Feed Applicator		Harrisburg, PA 17105-3608
	1 PLC	±		APVD: J. CRUZ 12AUG2011	SIZE: CAGE CODE: DRAWING NO: A11 00779 ©=2151483		RESTRICTED TO
	2 PLC	±		PRODUCT SPEC:		SCALE: 1:2 SHEET 4 OF 4 REV E1	
	3 PLC	±		APPLICATION SPEC:			
	4 PLC	±		WEIGHT:			
	ANGLES	±		MATERIAL:			
				FINISH:			