

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151857-1	D	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2151857-2	E	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151857-1	D	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2151857-2	E	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2151857-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.57 mm [.062]	F
INSUL	3.18 mm [.125]	O

APPLICATOR INSTRUCTIONS  
408-35042

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: SINGLE WIRE SEAL, 1.2, MCON			
WIRE STRIP LENGTH		TERMINAL INSULATION RANGE	
3.30-3.90 mm [.130-.154 IN]		1.40-1.70 mm [.055-.067 IN]	
TERMINAL APPLICATION SPECIFICATION	114-32121		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE SEAL	TE SEAL
2138597-2	2203830-2	967067-1	963142-1
2321538-2	2-2203830-2		
2364195-2	2-2321973-2		
2288917-2			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.50mm2	0.80+/-0.03 [.031+/-0.001]	8.7

- 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 LOCTITE TO THREADS.
- 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.

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

LOC	DIST	REVISIONS					
A	66	P	LTN	DESCRIPTION	DATE	OWN	APPV
		B		ECR-16-016833	29NOV2016	TB	TE
		C		ECR-17-011907	16AUG2017	FZ	KZ
		D		ECR-18-003802	13MAR2018	JAH	JDG
		E		ECR-22-138741	11MAY2022	FZ	JAH

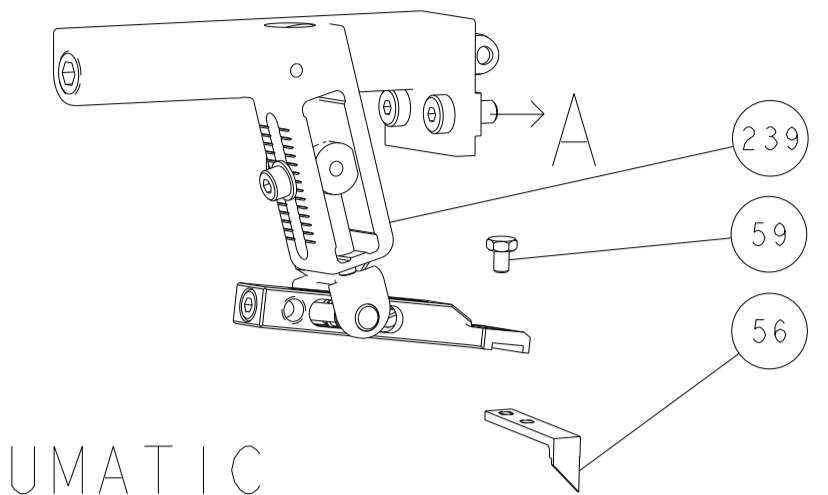
-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248
-	1	1	1	1	2119082-8	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
3	-	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	1	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
-	-	1	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	1	-	1	-	2844940-1	AIR FEED MODULE	238
-	2	2	2	2	1-2079383-0	SCR, BHSC, RoHS (M3 X 6)	230
3	-	1	1	1	1-1752354-8	STANDOFF, HOLD-DOWN	180
-	1	1	1	1	1976053-4	LOCATER BLOCK, TERMINAL	179
-	1	1	1	1	9931111-1	PIN, SLOTTED SPRING 3.0 X 20.0	177
-	1	1	1	1	8-22280-7	SPRING, COMPRESSION	176
-	1	1	1	1	1752353-2	GUIDE PIN, HOLDDOWN	175
-	1	1	1	1	1901680-2	GUIDE PIN, HOLDDOWN	174
-	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	1	1	1	1	1-18028-2	WASHER, FLAT, REG M4	119
-	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	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
5	-	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
-	1	1	1	1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52
-	1	1	1	1	1901681-4	HOLDDOWN, TERMINAL	51
-	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	1803515-3	RAM ASSEMBLY, SF ATLANTIC	44
-	1	1	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
-	1	1	1	1	2-1752356-0	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	455888-3	SPACER, CRIMPER	28
-	1	1	1	1	1320928-6	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
1	-	1	1	1	2119806-1	INSERT, SHEAR	13
-	1	1	1	1	3-22280-3	SPRING, COMPRESSION	12
-	1	1	1	1	1-356885-4	STOP, SHEAR	11
1	-	1	1	1	2119805-1	SHEAR HOLDER, FRONT	10
1	-	1	1	1	318707-1	FLOATING SHEAR, FRONT	9
1	1	2	2	1	1633918-9	ANVIL, COMBINATION	8
-	-	-	-	-	-	-	7
-	-	-	-	-	-	-	6
-	1	1	1	1	2119781-1	DEPRESSOR, SHEAR	5
-	1	1	1	1	238011-4	BLOCK, CRIMPER SPACER	4
1	1	2	2	1	1633965-1	CRIMPER, INSULATION O PREMIUM	3
-	1	1	1	1	1-455888-0	SPACER, CRIMPER	2
1	1	2	2	1	1-456403-9	CRIMPER, WIRE PREMIUM	1

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		MATERIAL:		FINISH:	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES ±	FINISH ±

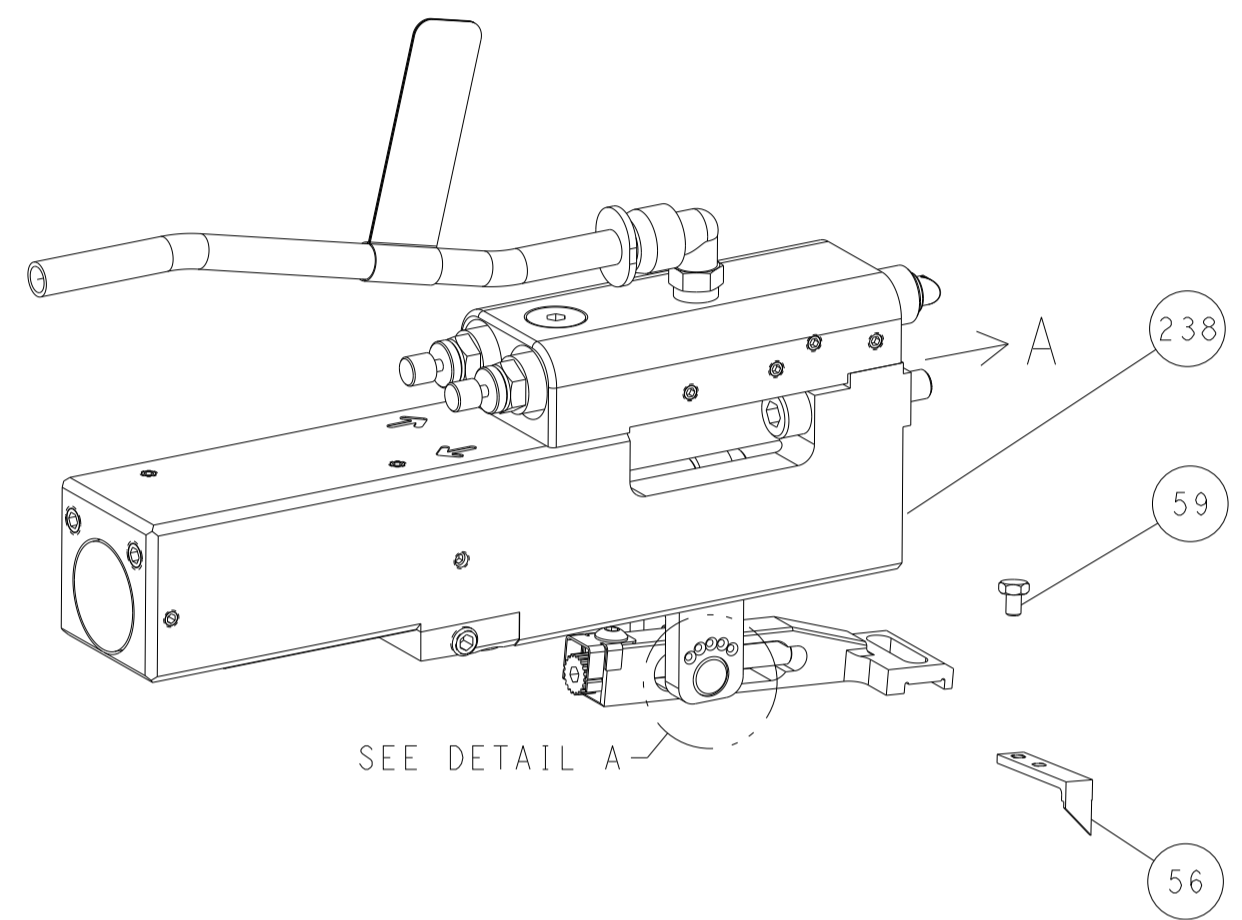
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CHK	S. XI	16JAN2013
APPV	S. XI	16JAN2013
PRODUCT SPEC		
APPLICATION SPEC		
SIZE	CAGE CODE	DRAWING NO
A1	00779	2151857
Customer Accessible Production Drawing		
SCALE	1:2	SHEET 1 OF 4
REV	E	

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

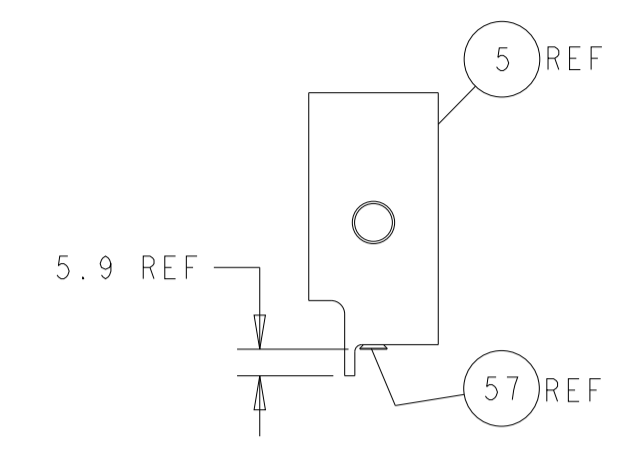
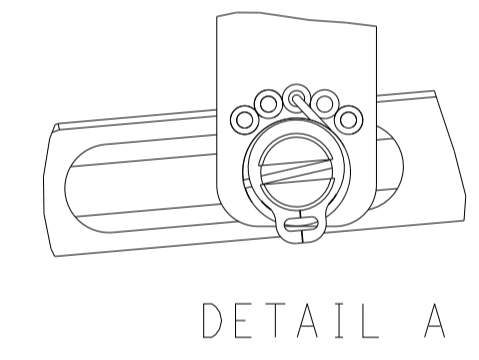
# FEED TYPE MECHANICAL



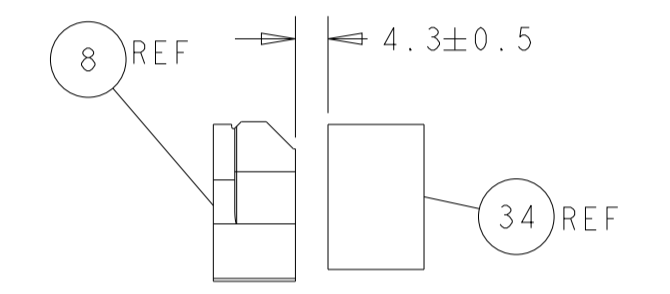
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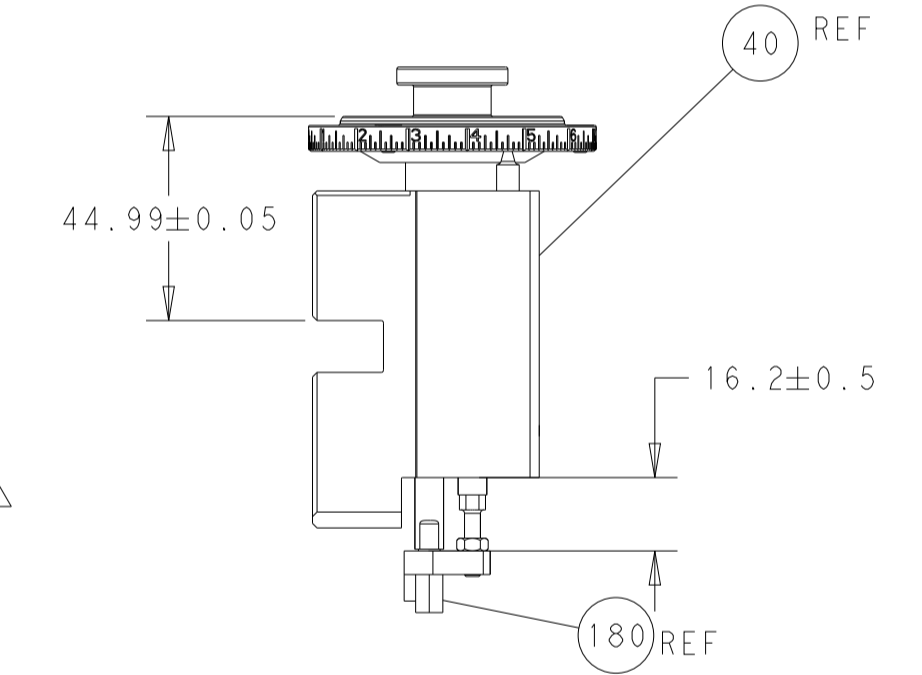
## FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



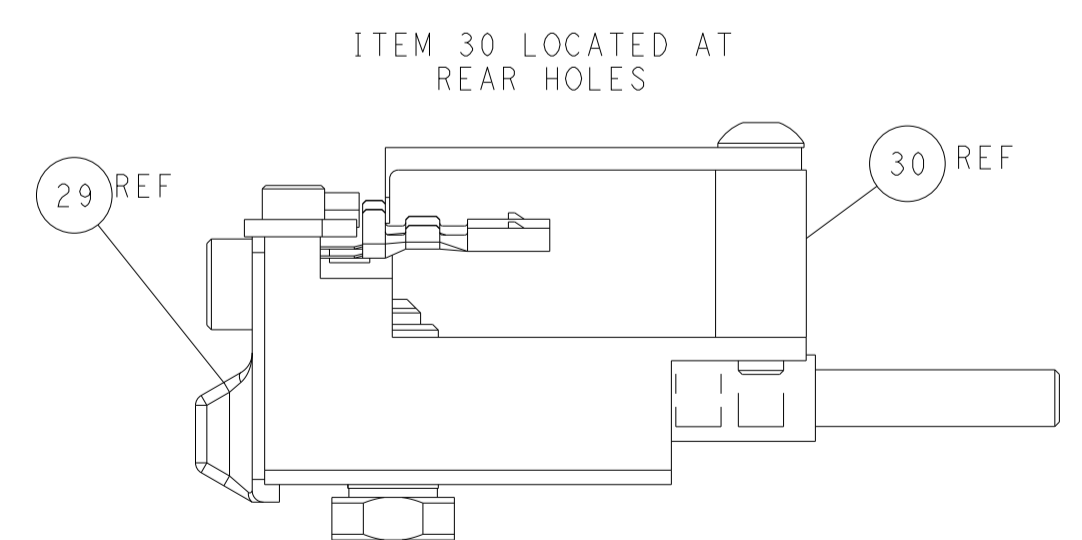
SHEAR DEPRESSOR DETAIL



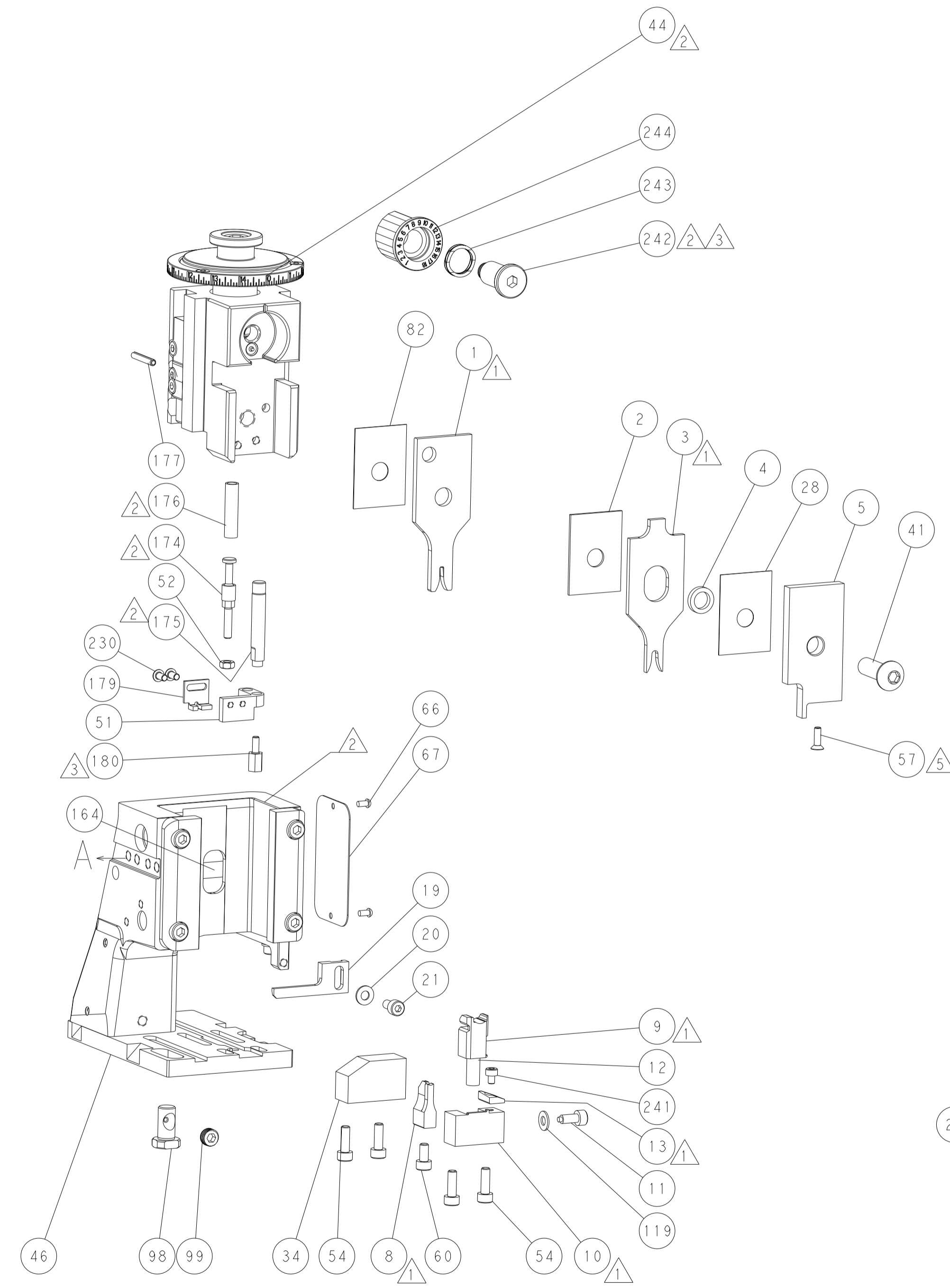
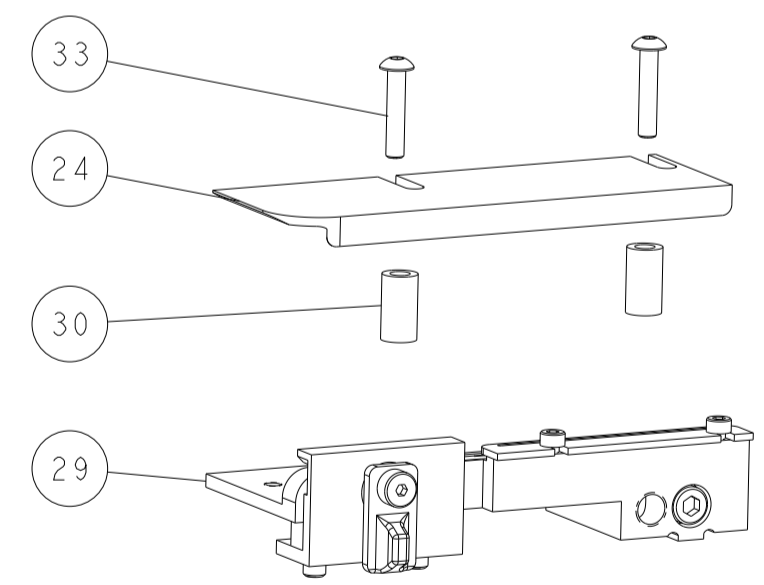
TERMINAL SUPPORT LOCATION



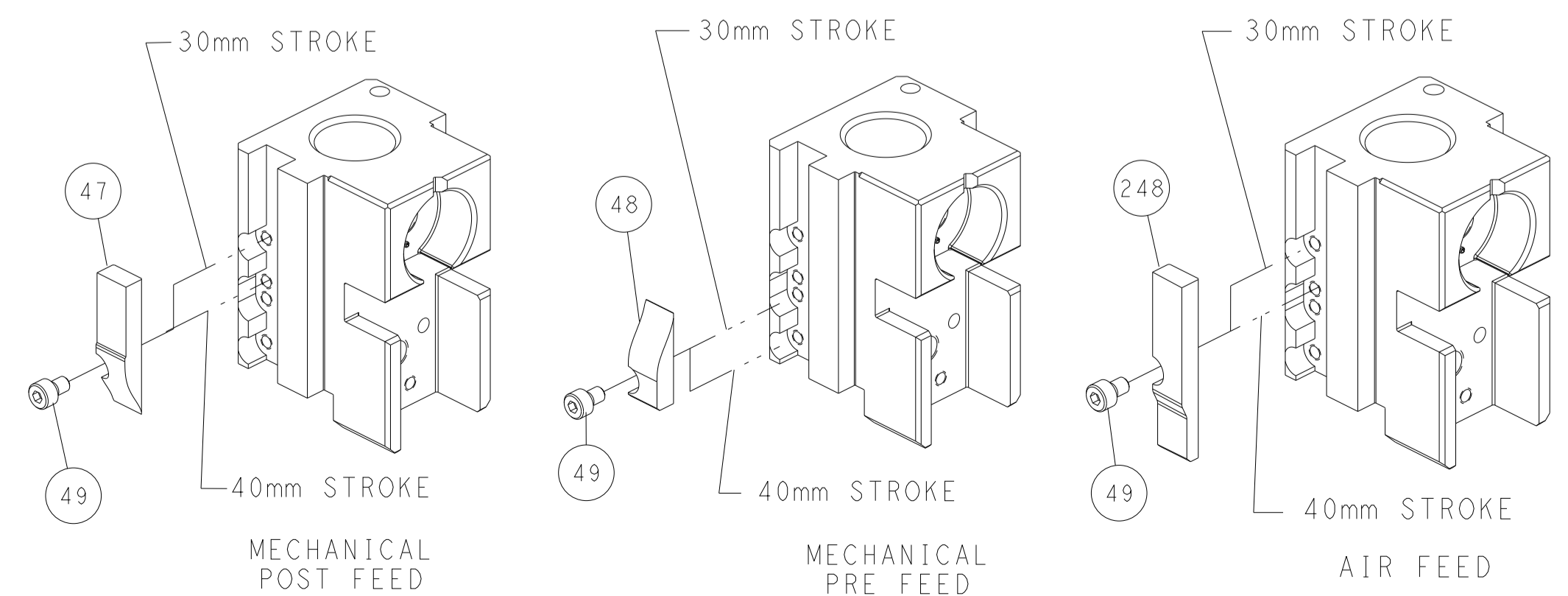
RAM AND HOLDDOWN SET-UP



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: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH		DWN R. HUANG 16JAN2013 CHK S. XI 16JAN2013 APVD S. XI 16JAN2013 PRODUCT SPEC APPLICATION SPEC WEIGHT Customer Accessible Production Drawing		NAME Ocean Side Feed Applicator SIZE A1 CAGE CODE 00779 DRAWING NO. ©=2151857 SCALE 1:2 SHEET 2 OF 4 REV E	
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COPYRIGHT 20 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.			
PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2151857-1	D	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2151857-2	E	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151857-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR  
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.57 mm [.062]	F
INSUL	3.18 mm [.125]	O
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: SINGLE WIRE SEAL, 1.2, MCON			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
3.30-3.90 mm [1.30-.154 IN]		Ø1.40-1.70 mm [0.055-.067 IN]	
TERMINAL APPLICATION SPECIFICATION	114-32121	-	-

TERMINALS APPLIED				SEAL INSULATION DIAMETER RANGE
TE TERMINAL	TE TERMINAL	TE SEAL	TE SEAL	
2138597-2	2203830-2	967067-1	963142-1	1.4-2.1 mm
2321538-2	2-2203830-2			
2364195-2	2-2321973-2			
2288917-2				

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.50mm2	0.80+/-0.03 [0.031+/-0.001]	8.7

- RECOMMENDED SPARE PARTS
- REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION & STORAGE OF APPLICATOR
- APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 180. 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 LOCTITE TO THREADS.
- 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	REVISIONS					
A	66	P	LTN	DESCRIPTION	DATE	OWN	APVD
		-		SEE SHEET 1	-	-	-

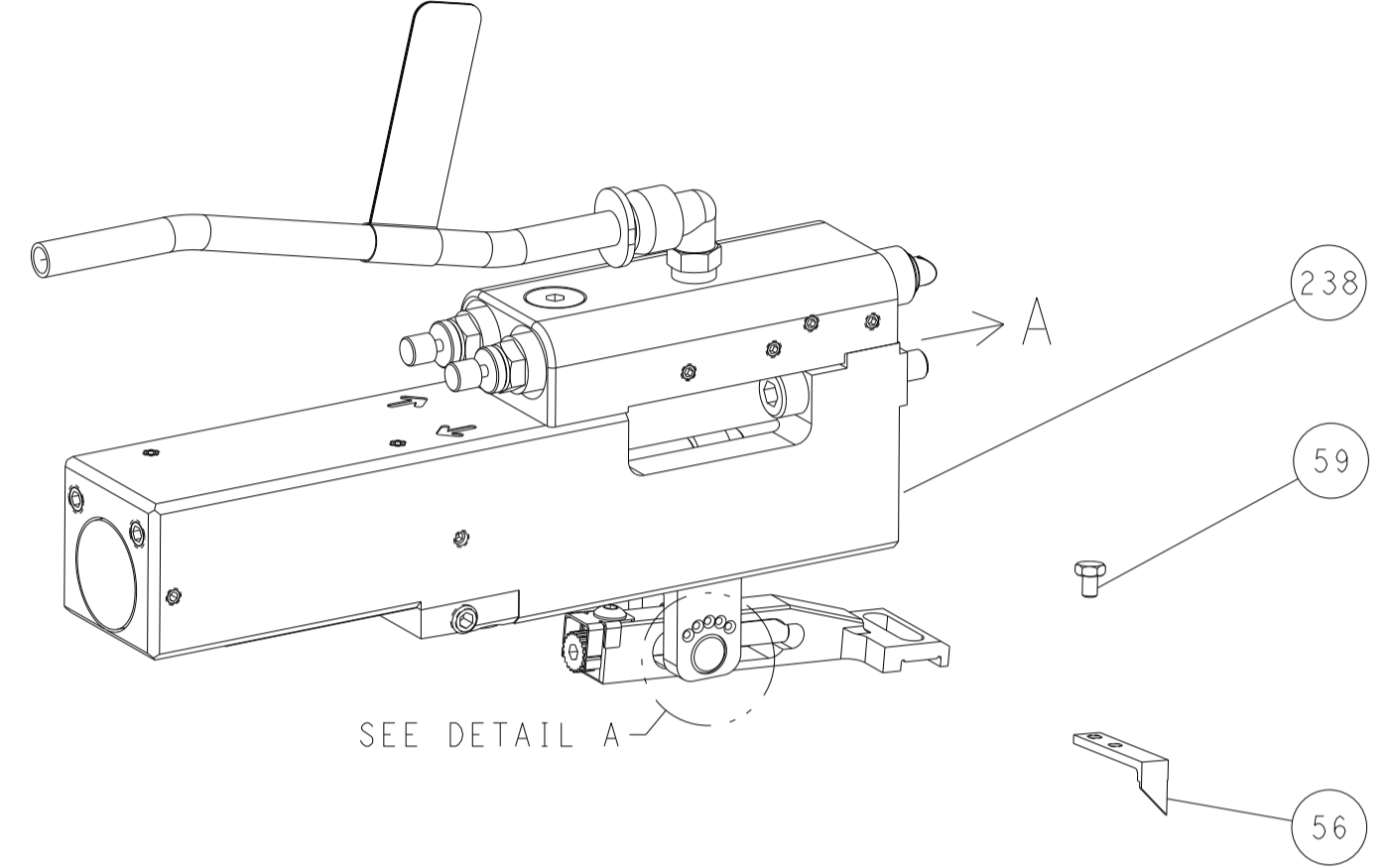
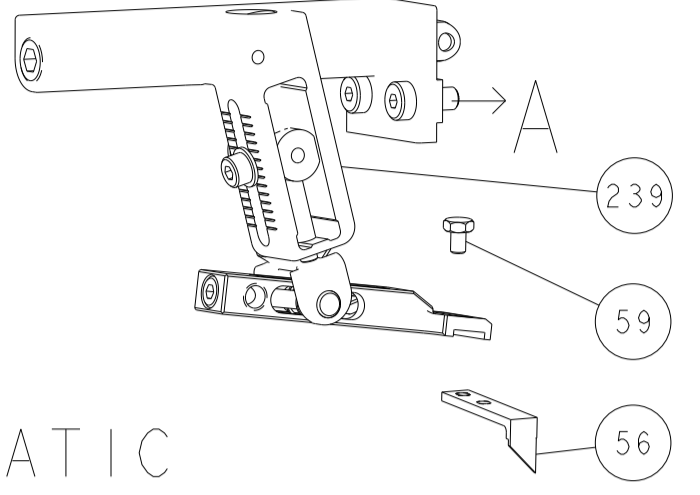
-	1	1	2119082-8	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
-	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	1	-	2844940-1	AIR FEED MODULE	238
-	2	2	1-2079383-0	SCR, BHSC, RoHS (M3 X 6)	230
-	1	1	1-1752354-8	STANDOFF, HOLD-DOWN	180
-	1	1	1976053-4	LOCATER BLOCK, TERMINAL	179
-	1	1	993111-1	PIN, SLOTTED SPRING 3.0 X 20.0	177
-	1	1	8-22280-7	SPRING, COMPRESSION	176
-	1	1	1752353-2	GUIDE PIN, HOLDDOWN	175
-	1	1	1901680-2	GUIDE PIN, HOLDDOWN	174
-	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	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	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
-	1	1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52
-	1	1	1901681-4	HOLDDOWN, TERMINAL	51
-	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	2-1752356-0	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	1320928-6	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	1	1633918-9	ANVIL, COMBINATION	8
-	-	-	-	-	7
-	-	-	-	-	6
-	1	1	2119781-1	DEPRESSOR, SHEAR	5
-	1	1	238011-4	BLOCK, CRIMPER SPACER	4
1	1	1	1633965-1	CRIMPER, INSULATION O PREMIUM	3
-	1	1	1-455888-0	SPACER, CRIMPER	2
1	1	1	1-456403-9	CRIMPER, WIRE PREMIUM	1

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

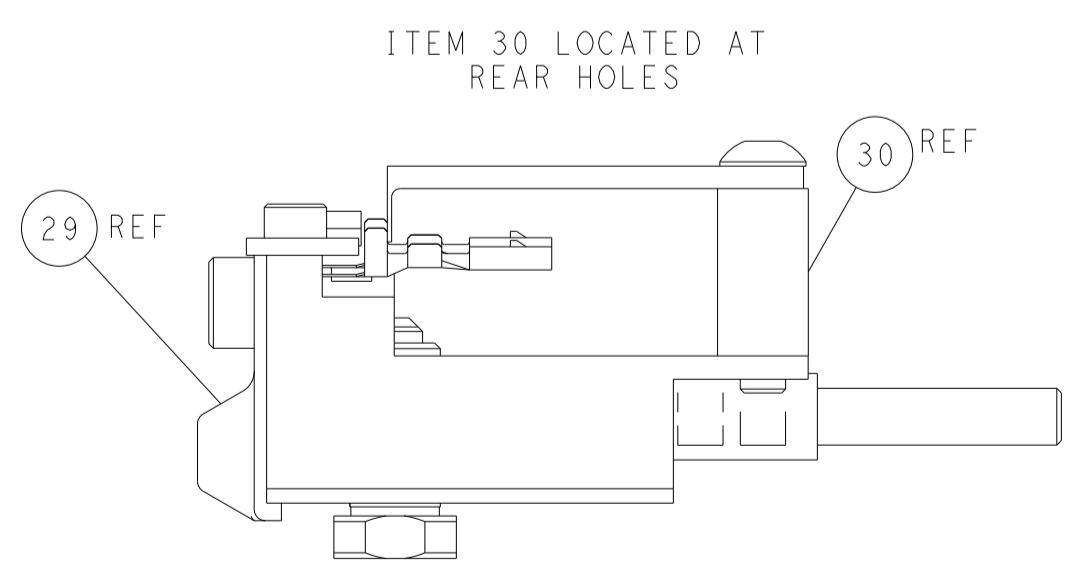
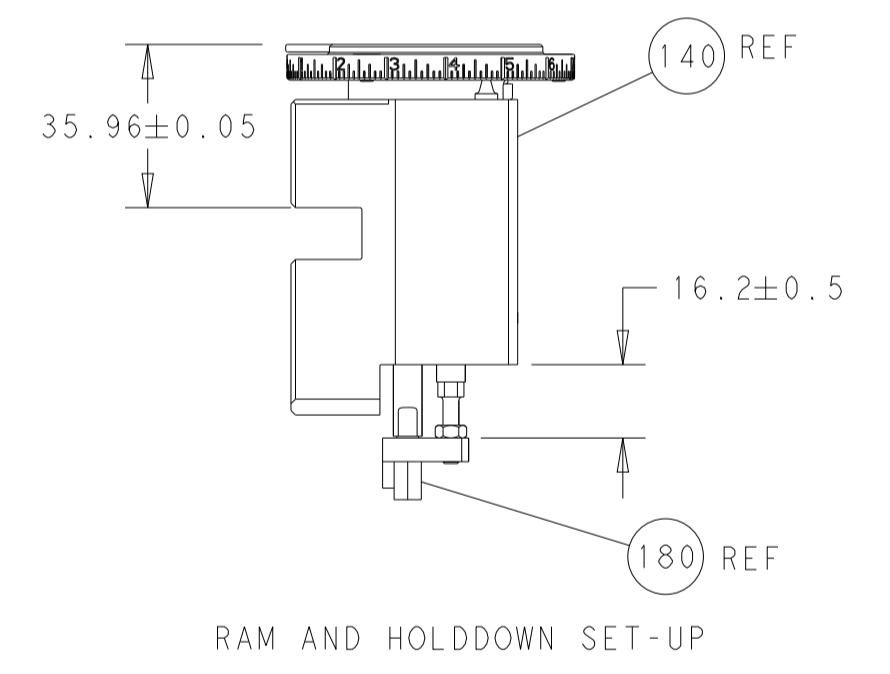
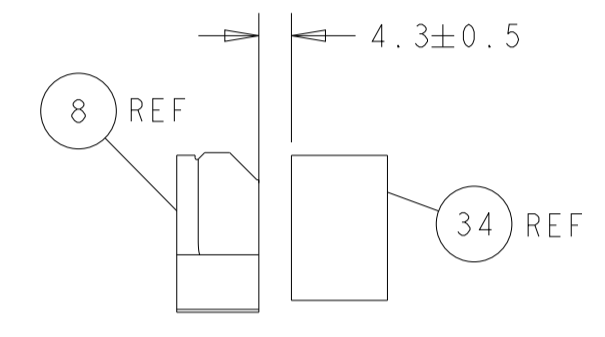
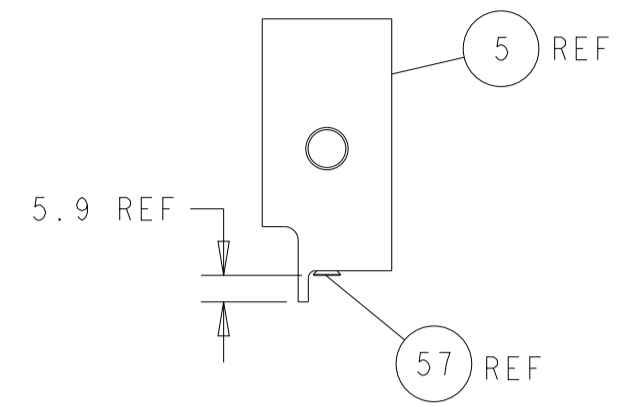
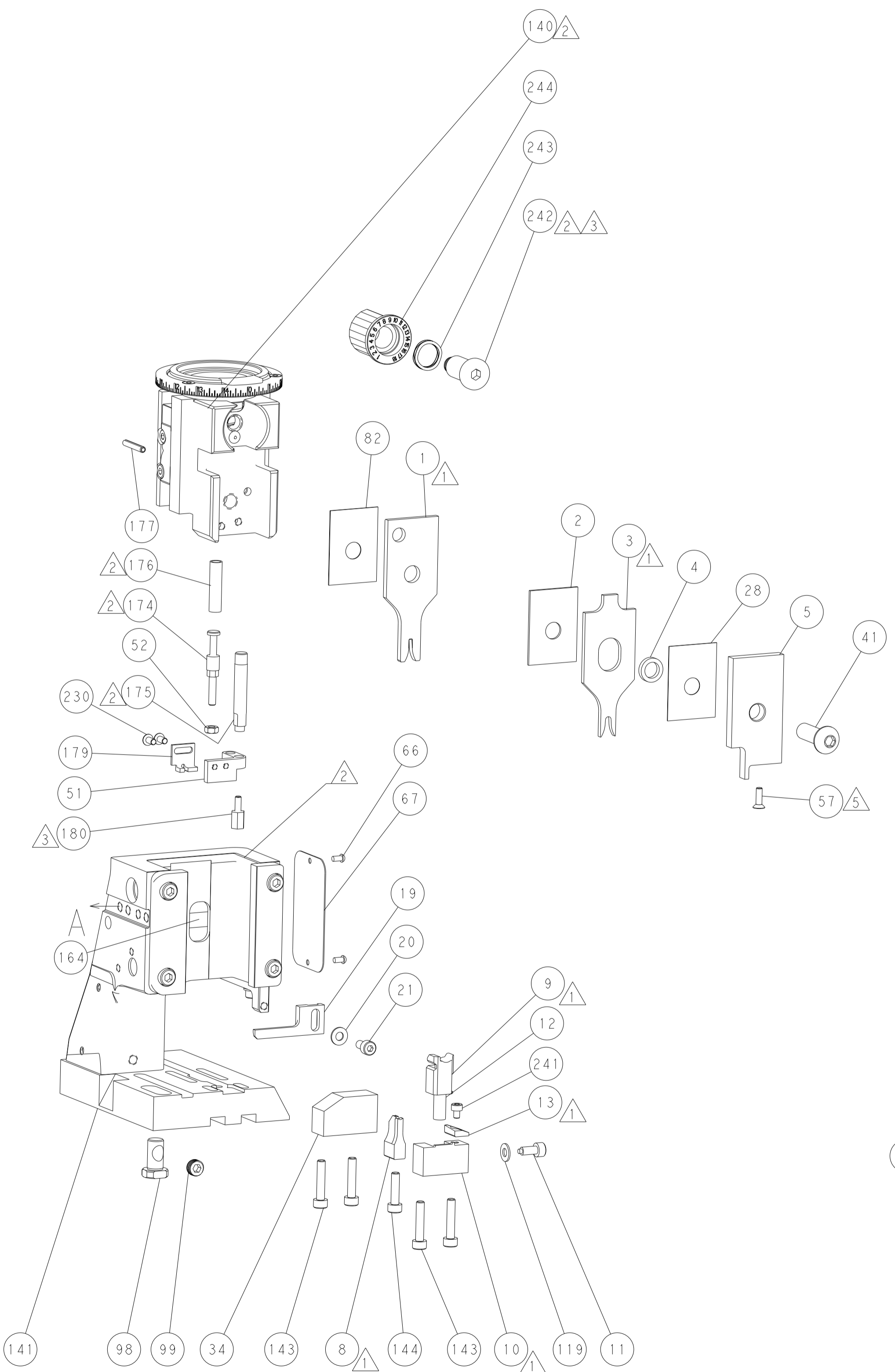
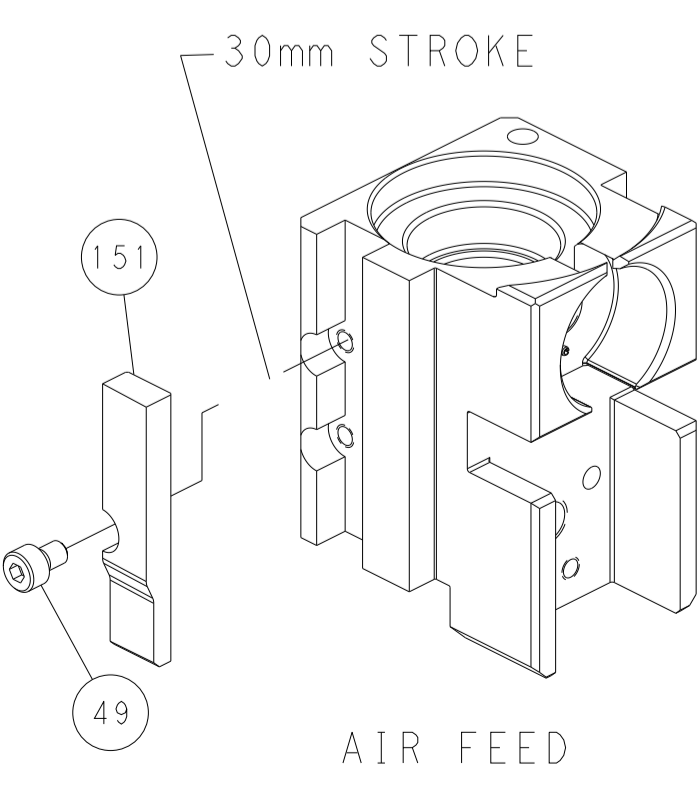
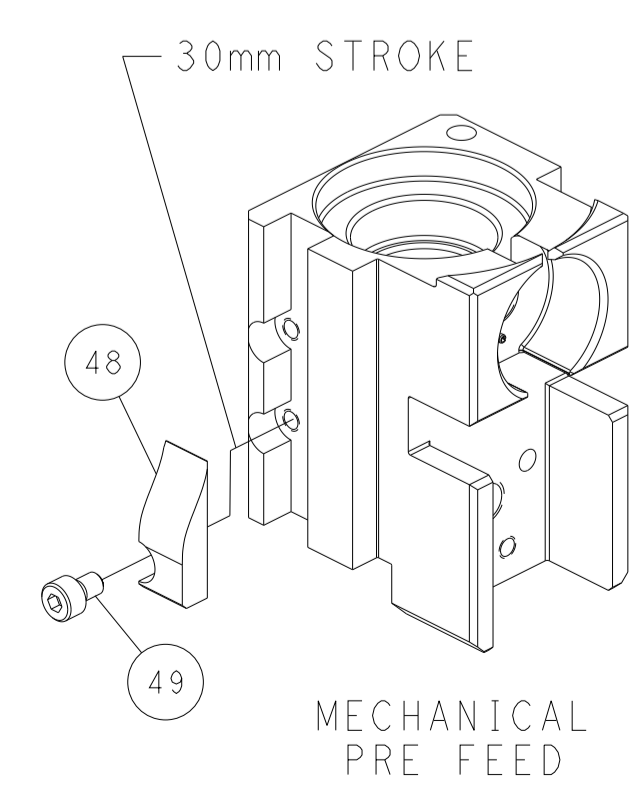
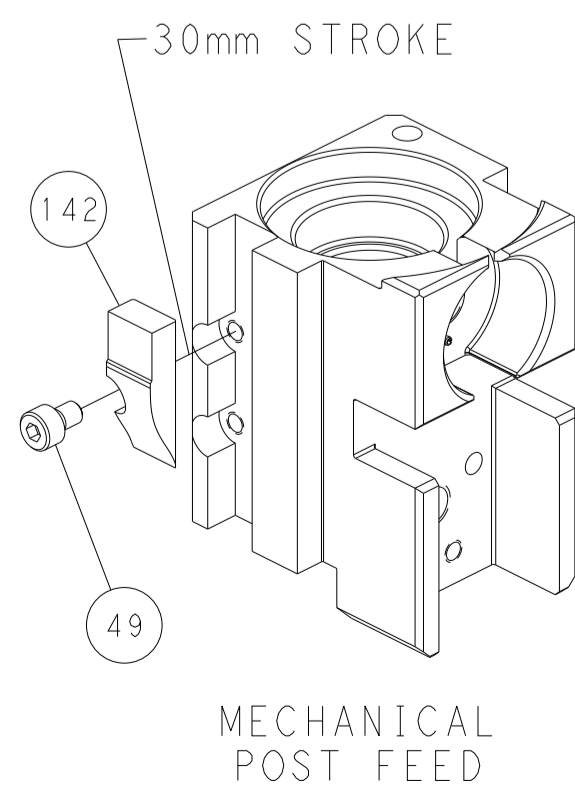
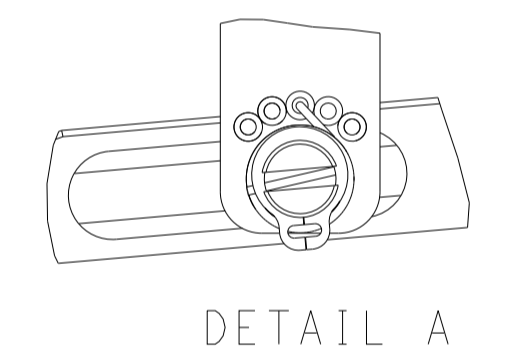
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		OWN	H. HUANG	16 JAN 2013	TE Connectivity Harrisburg, PA 17105-3608
mm	0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH	±	±	CHK	S. XI	16 JAN 2013	
MATERIAL		WEIGHT		APVD	S. XI	16 JAN 2013	NAME
				PRODUCT SPEC			Ocean Side Feed Applicator
				APPLICATION SPEC			SIZE
							CAGE CODE
							DRAWING NO
							RESTRICTED TO
							A1 00779 ©=2151857
							Customer Accessible Production Drawing
							SCALE 1:2 SHEET 3 OF 4 REV E

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

# FEED TYPE MECHANICAL



FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



**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 ± FINISH		DWN H. HUANG 16JAN2013 CHK S. XI 16JAN2013 APVD S. XI 16JAN2013 PRODUCT SPEC APPLICATION SPEC WEIGHT Customer Accessible Production Drawing		NAME Ocean Side Feed Applicator SIZE CAGE CODE DRAWING NO A1 00779 C-2151857 SCALE 1:2 SHEET 4 OF 4 REV E	
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