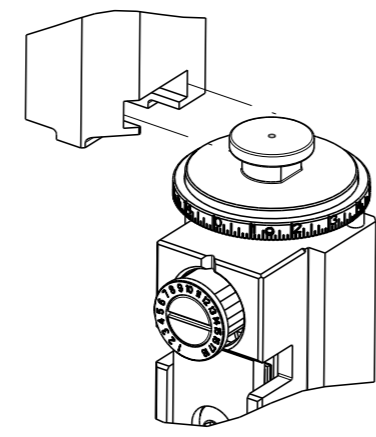


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151036-1	J	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2151036-2	K	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
3-2151036-2	K	FINE CRIMP HEIGHT ADJUST	DOUBLE ACTING PNEUMATIC WITH SENSORS
5-2151036-1	J	SEAL STRIPPER CRIMPER TERMINATING UNIT	MECHANICAL
5-2151036-2	K	SEAL STRIPPER CRIMPER TERMINATING UNIT	PNEUMATIC
7-2151036-1	J	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2151036-2	K	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2151036-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.40 mm [.055]	F
INSUL	3.18 mm [.125]	O
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: MCP 1.2 WITH LOCKING LANCE			
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE		
3.30-3.90 mm [.130-.154 IN]	Ø1.40-1.90 mm [.055-.075 IN]		
TERMINAL APPLICATION SPECIFICATION	114-18464		

TERMINALS APPLIED				
TE TERMINAL	TE TERMINAL	TE SEAL	TE SEAL	CABLE DIAMETER
1452668-1	1718033-3		967067-1	1.4-2.1
1452668-2			963142-2	0.9-1.3
1452668-3			963142-3	1.4-2.4

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.75mm2	1.05+/-0.03 [.041+/-0.001]	6.7
20 AWG OR 0.50mm2	0.93+/-0.03 [.037+/-0.001]	8.0

- RECOMMENDED SPARE PARTS
- REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 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 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.
- THIS APPLICATOR IS EQUIPPED WITH THE DOUBLE ACTING FEED WITH SENSORS AND IS APPLICATION SPECIFIC AND DOES NOT REQUIRE ITEMS 49 & 248.
- TERMINAL LUBRICANT IS RECOMMENDED.
- 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.

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: MCP 1.2 WITH LOCKING LANCE			
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE		
3.30-3.90 mm [.130-.154 IN]	Ø1.40-1.90 mm [.055-.075 IN]		
TERMINAL APPLICATION SPECIFICATION	114-18464		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.75mm2	0.98+/-0.03 [.039+/-0.001]	7.1
20 AWG OR 0.50mm2	0.93+/-0.03 [.037+/-0.001]	8.0

LOC	DIST	REVISIONS					
		P	LY#	DESCRIPTION	DATE	OWN	APVD
A	66	H		ECR-17-014319	27SEP2017	JAH	GB
		J		ECR-18-006382	25APR2018	JAH	JDG
		J1		ECR-18-017390	05NOV2018	YY	TE
		K		ECR-19-004653	28MAR2019	LG	TE

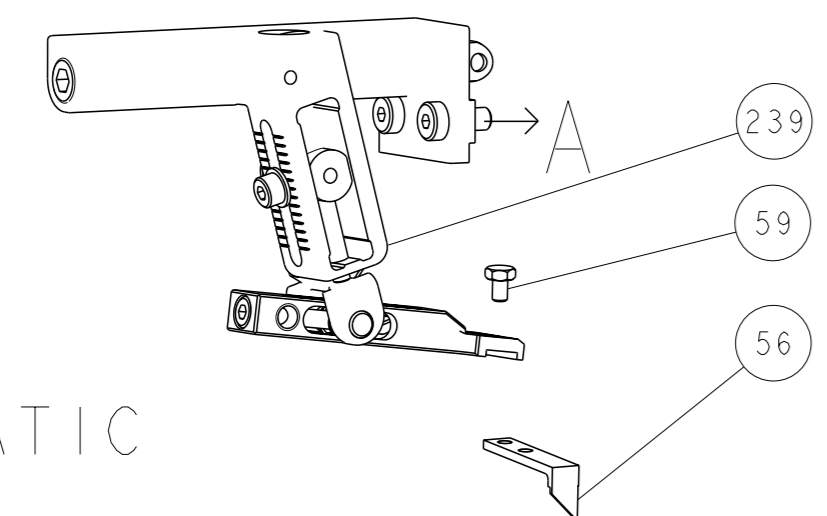
-	-	-	1	1	-	-	-	1803515-3	RAM ASSEMBLY, SF ATLANTIC	293
-	-	-	1	1	-	-	-	2-1803583-1	APPLICATOR BASIC ASSEMBLY, SF	292
-	-	-	-	-	1	-	-	2844950-1	AIR FEED MODULE	290
-	1	-	1	-	-	1	-	2119641-1	FEED CAM, AIR FEED	248
-	1	1	1	1	1	1	1	2119082-4	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1	1	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	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
-	-	-	1	1	-	-	-	4-1722335-3	STRIPPER, SIDE FEED	182
-	-	-	1	1	-	-	-	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	181
-	-	-	1	1	-	-	-	1-1752354-8	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	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	1	1	1	1	1	1	1	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113
-	1	1	1	1	1	1	1	2844908-1	SCREW, LOCKING	99
-	1	1	1	1	1	1	1	2844907-1	POST, LOCKING	98
-	1	1	1	1	1	1	1	455888-5	SPACER, CRIMPER	82
-	2	2	2	2	2	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	79
-	1	1	1	1	1	1	1	1633782-2	FENCE	78
-	1	1	1	1	1	1	1	1803607-3	DOCUMENTATION PACKAGE	71
-	1	1	1	1	1	1	1	2119740-1	TAG, IDENTIFICATION	67
-	2	2	2	2	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	1	1	1	1	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	60
-	1	1	1	1	1	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	1	1	1	1	1	1	1	985575-4	SCR, FLT SKT HD CAP M3 X 12.0	57
-	1	1	1	1	1	1	1	1338685-1	PAWL, FEED	56
-	4	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	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	53
-	1	1	1	1	1	1	1	1803382-6	HOLD DOWN, SPRING LOADED	50
-	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	1	1803583-9	APPLICATOR BASIC ASSEMBLY, SF	46
-	1	1	-	-	1	1	1	1803515-1	RAM ASSEMBLY, SF ATLANTIC	44
-	1	1	1	1	1	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
-	1	1	1	1	1	1	1	1752356-6	SUPPORT, TERMINAL	34
-	2	2	2	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	2	2	2	2	2	2-2844962-8	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	1	1	1	1	1	2844992-2	ASSEMBLY, STRIP GUIDE	29
-	1	1	1	1	1	1	1	455888-3	SPACER, CRIMPER	28
-	1	1	1	1	1	1	1	1320928-2	STRIP GUIDE	24
-	1	1	-	-	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
-	2	2	1	1	2	2	2	1-18028-2	WASHER, FLAT, REG M4	20
-	1	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	1	3-22280-3	SPRING, COMPRESSION	12
-	1	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	2	2	1	1	1	1	6-1333201-7	ANVIL, COMBINATION	8
-	1	1	1	1	1	1	1	240641-7	SPACER	7
-	1	1	1	1	1	1	1	2119781-1	DEPRESSOR, SHEAR	5
-	1	1	1	1	1	1	1	238011-4	BLOCK, CRIMPER SPACER	4
-	1	2	2	1	1	1	1	1633965-1	CRIMPER, INSULATION O PREMIUM	3
-	1	1	1	1	1	1	1	455888-7	SPACER, CRIMPER	2
-	1	2	2	1	1	1	1	1-456402-7	CRIMPER, WIRE PREMIUM	1

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

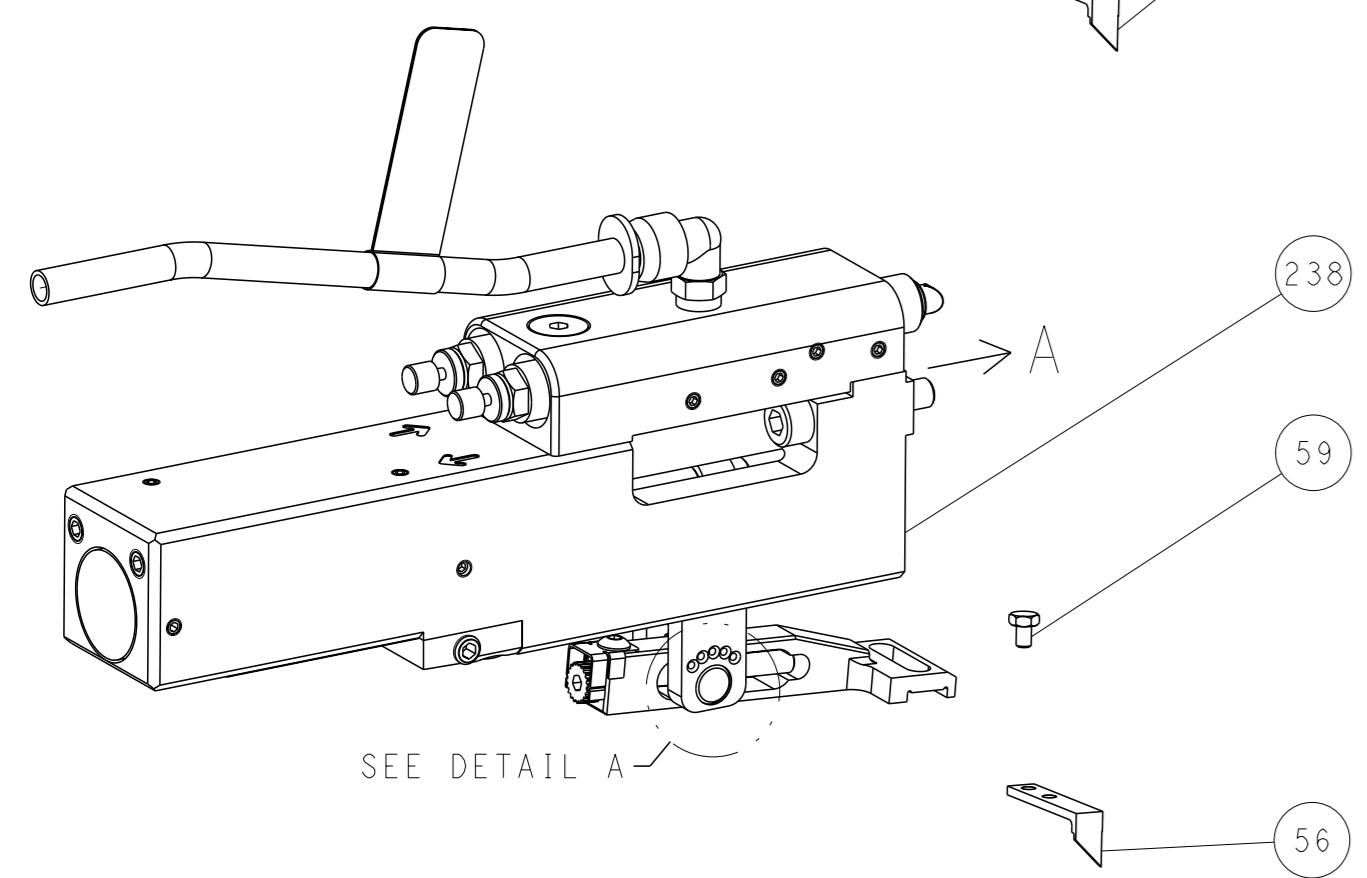
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mm	PLC	mm	PLC	DATE	NAME	SCALE	SHEET
	0 PLC ±		0 PLC ±	02SEP2011	H. HUANG	1:2	1 of 4
	1 PLC ±		1 PLC ±	02SEP2011	S. YI		
	2 PLC ±		2 PLC ±				
	3 PLC ±		3 PLC ±				
	4 PLC ±		4 PLC ±				
	ANGLES		FINISH				

LOC	DIST	REV	DESCRIPTION	DATE	OWN	APVD
A	66		SEE SHEET 1			

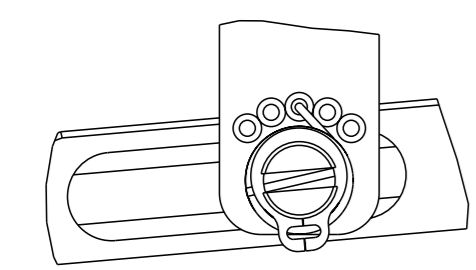
# FEED TYPE MECHANICAL



## PNEUMATIC

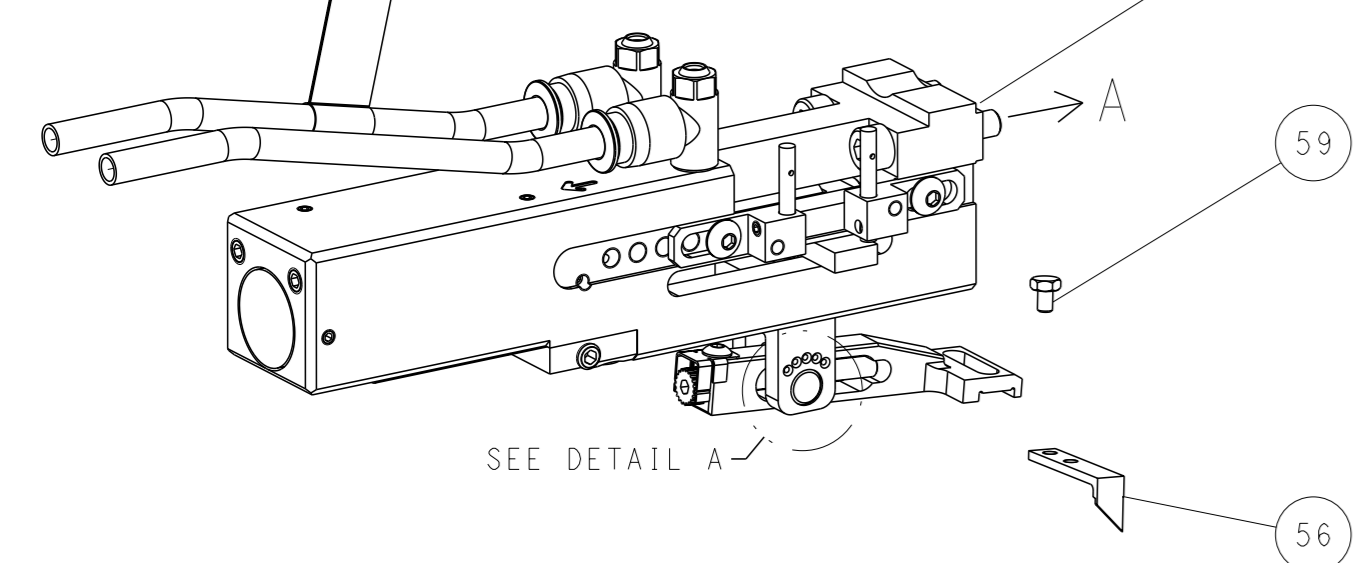


## FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)

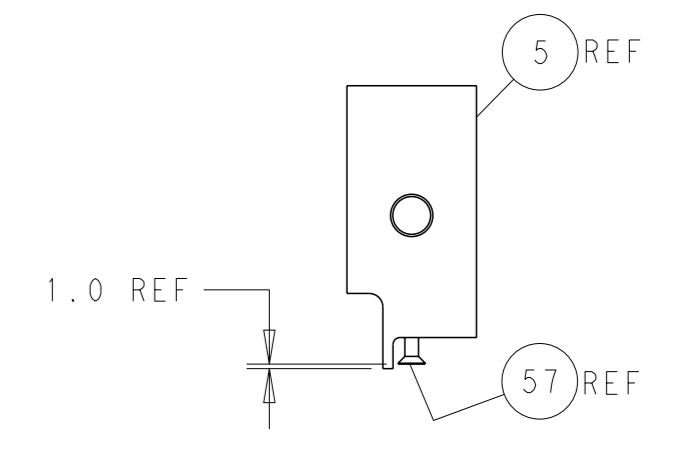
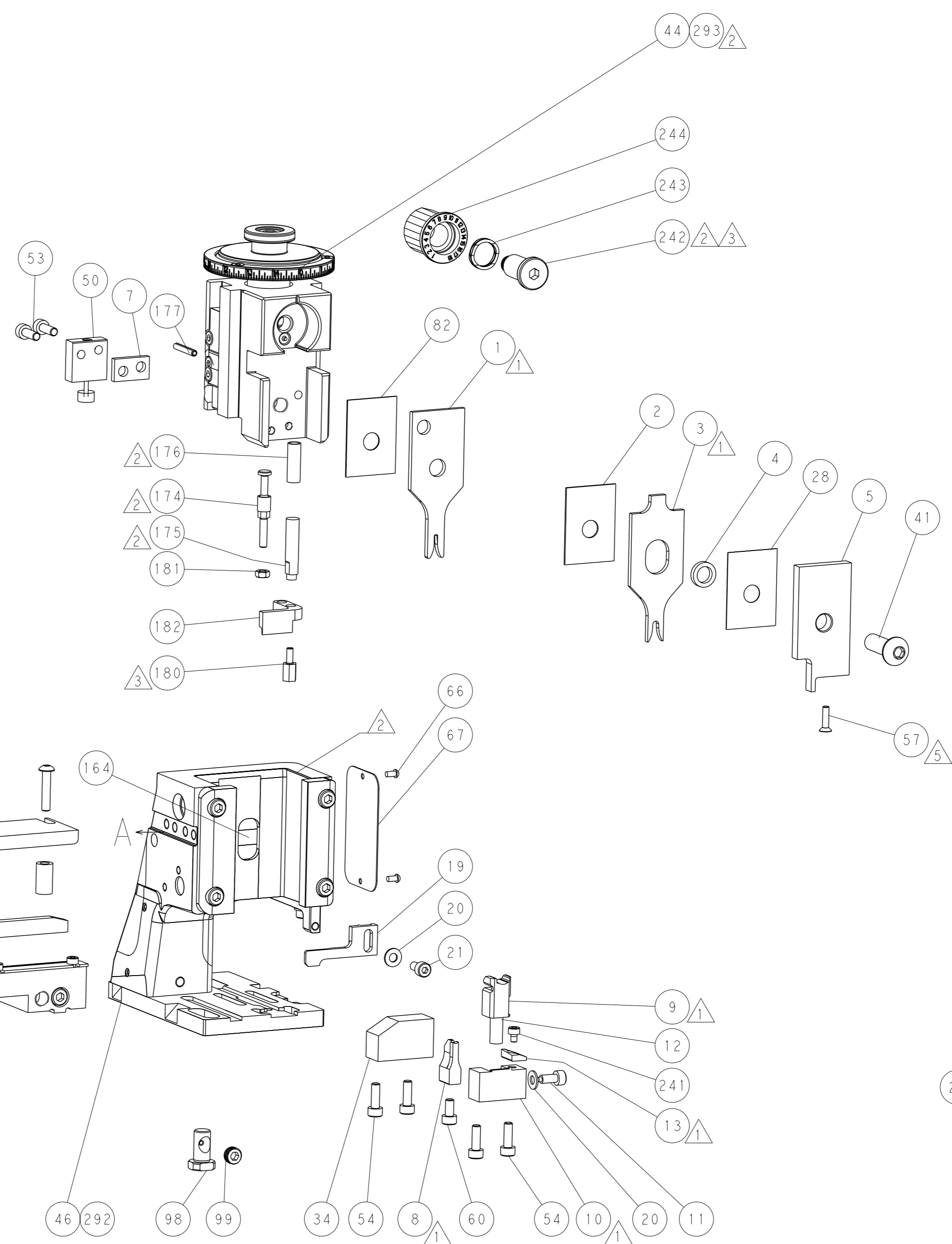
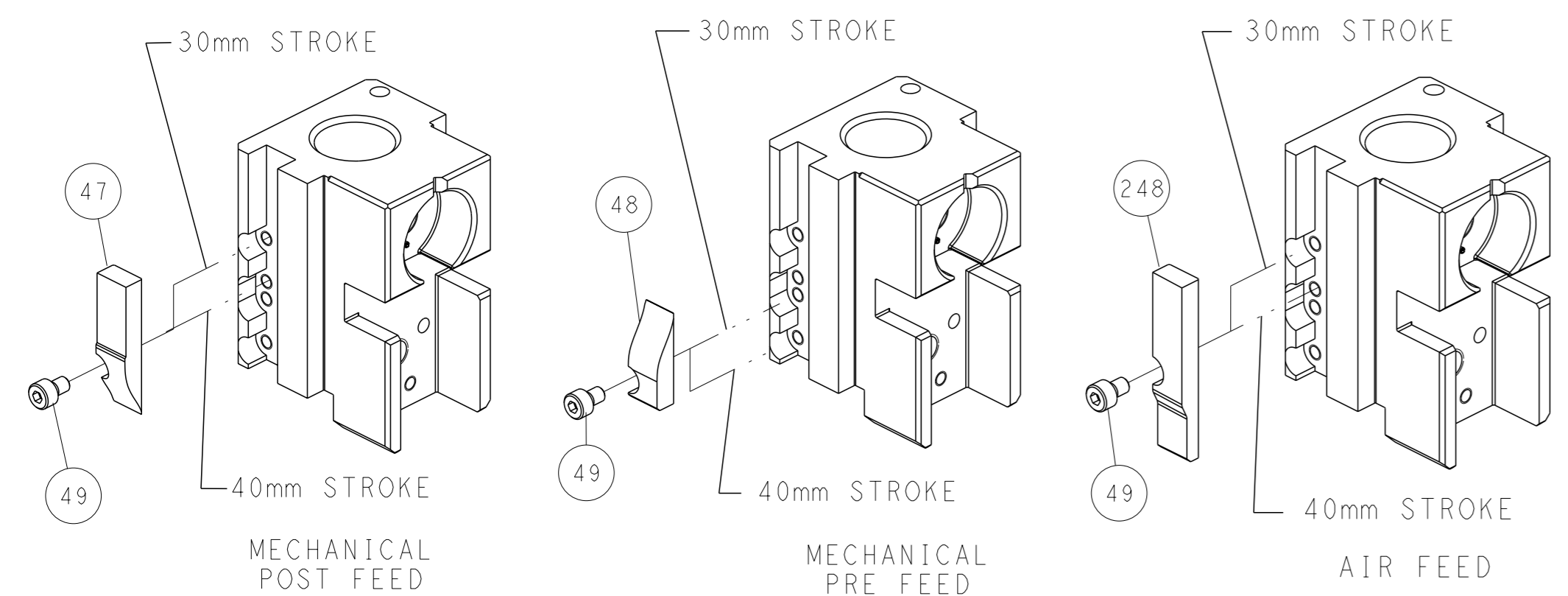


DETAIL A

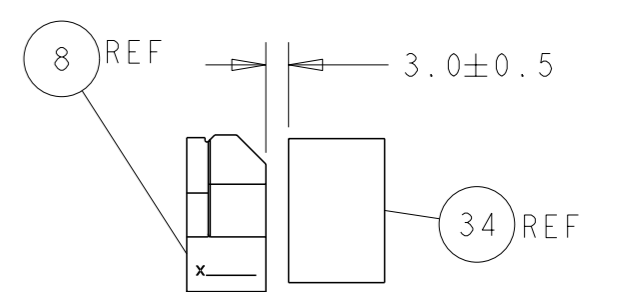
## DOUBLE ACTING PNEUMATIC WITH SENSORS



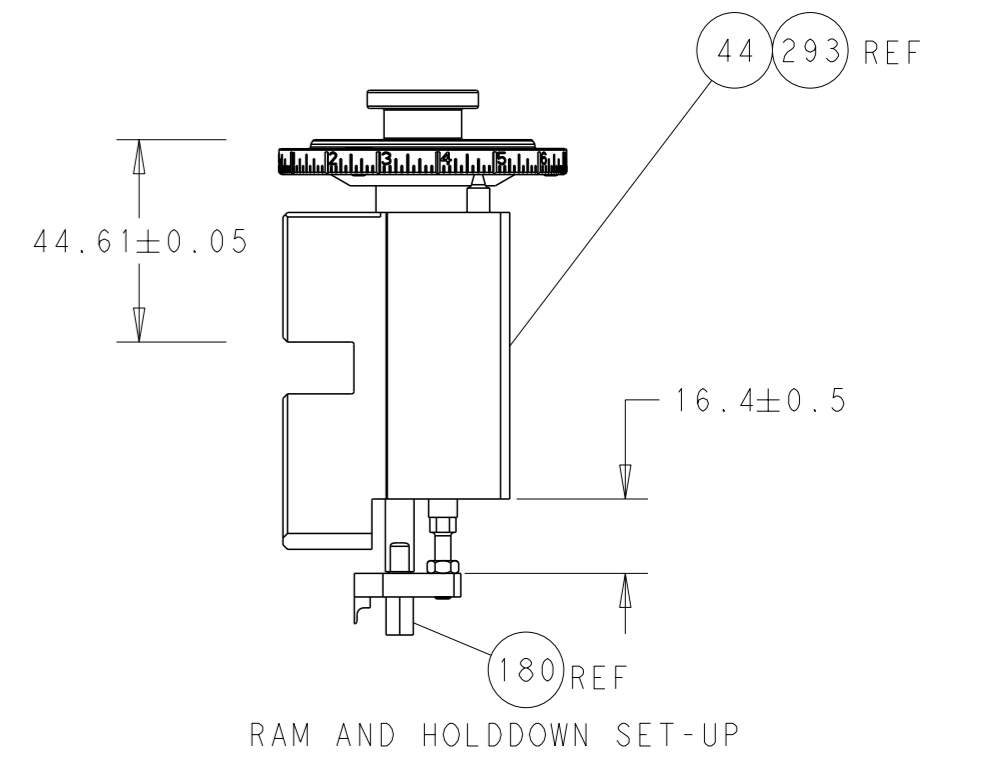
# CAM POSITIONS



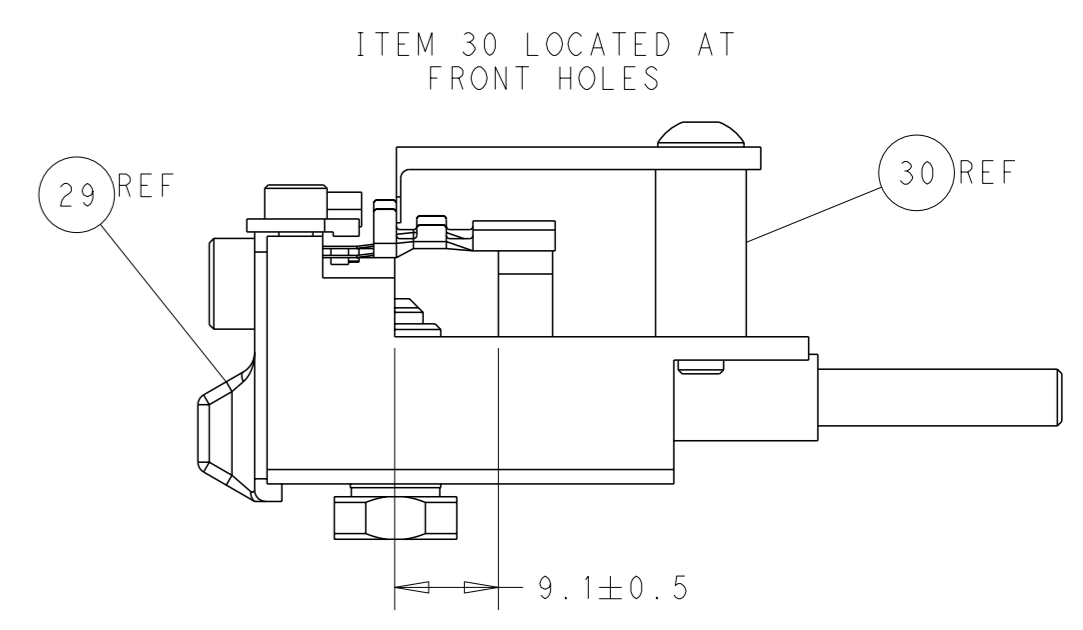
SHEAR DEPRESSOR DETAIL



TERMINAL SUPPORT LOCATION



RAM AND HOLDDOWN SET-UP



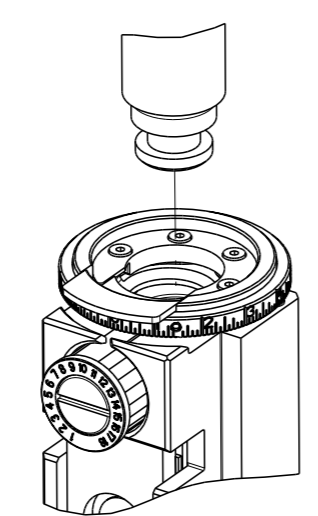
FEED TRACK POSITION GUIDE BY INSULATION BARREL

**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 ±		OWN: H. HUANG 02SEP2011 CHK: S. XI 02SEP2011 APVD: S. XI 02SEP2011 PRODUCT SPEC APPLICATION SPEC		NAME: Ocean Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2151036 RESTRICTED TO:	
MATERIAL:		WEIGHT:		SCALE: 1:2		SHEET 2 OF 4 REV K	

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2151036-1	J	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2151036-2	K	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
4-2151036-2	K	FINE CRIMP HEIGHT ADJUST	DOUBLE ACTING PNEUMATIC WITH SENSORS
7-2151036-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA

CRIMP	SIZE	TYPE
WIRE	1.40 mm [.055]	F
INSUL	3.18 mm [.125]	O

APPLICATOR INSTRUCTIONS  
408-35042

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION

TERMINAL NAME: MCP 1.2 WITH LOCKING LANCE

WIRE STRIP LENGTH	INSULATION DIAMETER RANGE
3.30-3.90 mm [.130-.154 IN]	Ø1.40-1.90 mm [.055-.075 IN]

TERMINAL APPLICATION SPECIFICATION 114-18464

TERMINALS APPLIED

TE TERMINAL	TE TERMINAL	TE SEAL	TE SEAL	CABLE DIAMETER
1452668-1	1718033-3		967067-1	1.4-2.1
1452668-2		963142-2		0.9-1.3
1452668-3		963142-3		1.4-2.4

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.75mm2	1.05+/-0.03 [.041+/-0.001]	6.7
20 AWG OR 0.50mm2	0.93+/-0.03 [.037+/-0.001]	8.0

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION

TERMINAL NAME: MCP 1.2 WITH LOCKING LANCE

WIRE STRIP LENGTH	INSULATION DIAMETER RANGE
3.30-3.90 mm [.130-.154 IN]	Ø1.40-1.90 mm [.055-.075 IN]

TERMINAL APPLICATION SPECIFICATION 114-18464

TERMINALS APPLIED

TE TERMINAL	TE TERMINAL	TE SEAL	TE SEAL	CABLE DIAMETER
7-1452668-1			967067-1	1.4-2.1
7-1452668-2		963142-2		0.9-1.3
7-1452668-3		963142-3		1.4-2.4

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.75mm2	0.98+/-0.03 [.039+/-0.001]	7.1
20 AWG OR 0.50mm2	0.93+/-0.03 [.037+/-0.001]	8.0

- 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 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.
- 6 THIS APPLICATOR IS EQUIPPED WITH THE DOUBLE ACTING FEED WITH SENSORS AND IS APPLICATION SPECIFIC AND DOES NOT REQUIRE ITEMS 49 & 151.
- 7 TERMINAL LUBRICANT IS RECOMMENDED.
- 8. 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.

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

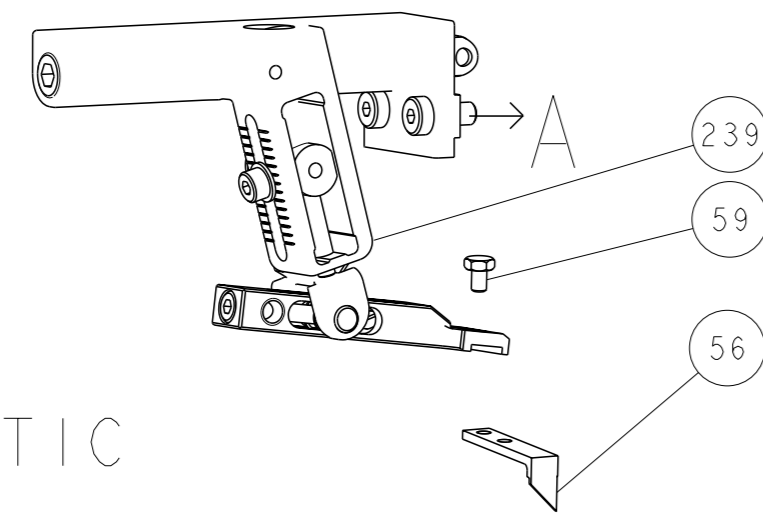
LOC A DIST 66

REV	LYR	DESCRIPTION	DATE	OWN	APVD
-	-	SEE SHEET 1	-	-	-

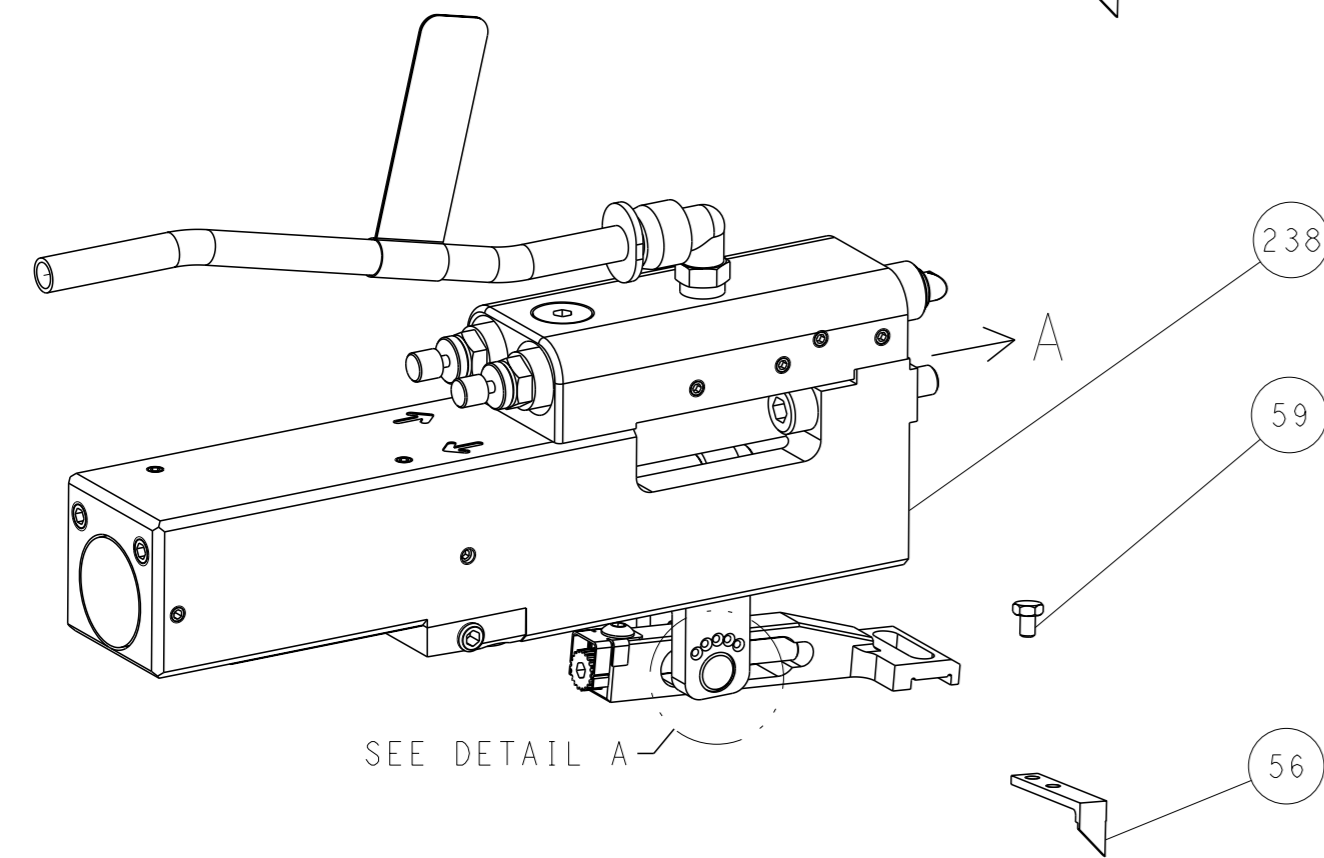
-	1	-	-	2844950-1	AIR FEED MODULE	290
-	1	1	1	2119082-4	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
3	-	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
-	-	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	-	1	-	2844940-1	AIR FEED MODULE	238
-	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	-	1	-	2119641-2	FEED CAM, AIR FEED	151
-	1	1	1	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	144
-	4	4	4	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	143
-	-	-	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	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113
-	1	1	1	2844908-1	SCREW, LOCKING	99
-	1	1	1	2844907-1	POST, LOCKING	98
-	1	1	1	455888-5	SPACER, CRIMPER	82
-	2	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	79
-	1	1	1	1633782-2	FENCE	78
-	1	1	1	1803607-3	DOCUMENTATION PACKAGE	71
-	1	1	1	2119740-1	TAG, IDENTIFICATION	67
-	2	2	2	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
5	-	1	1	985575-4	SCR, FLT SKT HD CAP M3 X 12.0	57
-	1	1	1	1338685-1	PAWL, FEED	56
-	2	2	2	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	53
-	1	1	1	1803382-6	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	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
-	1	1	1	1752356-6	SUPPORT, TERMINAL	34
-	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	2	2-2844962-8	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	1	2844992-2	ASSEMBLY, STRIP GUIDE	29
-	1	1	1	455888-3	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
-	2	2	2	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
-	1	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
-	1	1	1	318707-1	FLOATING SHEAR, FRONT	9
1	1	1	1	6-1333201-7	ANVIL, COMBINATION	8
-	1	1	1	240641-7	SPACER	7
-	1	1	1	2119781-1	DEPRESSOR, SHEAR	5
-	1	1	1	238011-4	BLOCK, CRIMPER SPACER	4
1	1	1	1	1633965-1	CRIMPER, INSULATION O PREMIUM	3
-	1	1	1	455888-7	SPACER, CRIMPER	2
1	1	1	1	1-456402-7	CRIMPER, WIRE PREMIUM	1

DIMENSIONS:	TOLERANCES UNLESS OTHERWISE SPECIFIED:	OWN	DATE	NAME	RESTRICTED TO
mm	0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±	H. HUANG	02SEP2011	Ocean Side Feed Applicator	-
MATERIAL:	FINISH:	APVD	SCALE	SIZE	REV
-	-	S. XI	1:2	00779	3 of 4

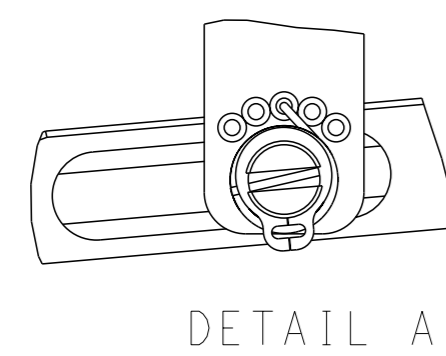
# FEED TYPE MECHANICAL



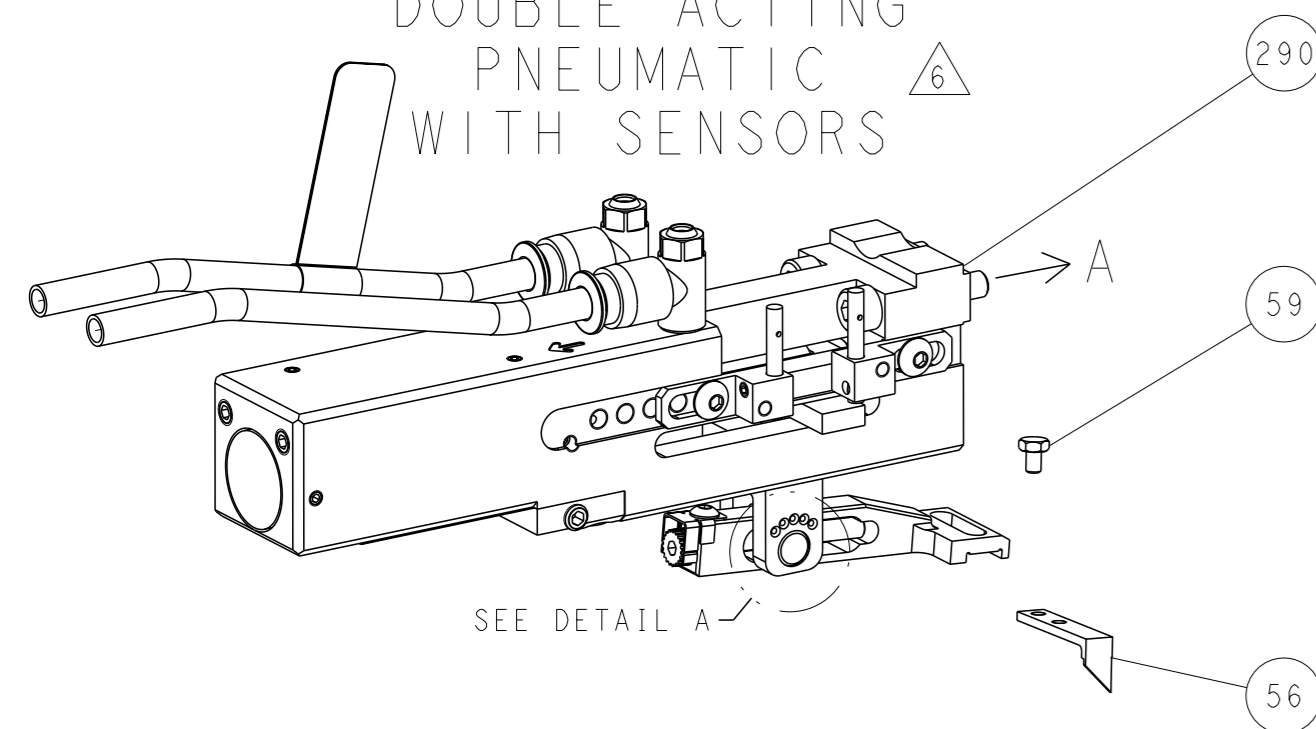
## PNEUMATIC



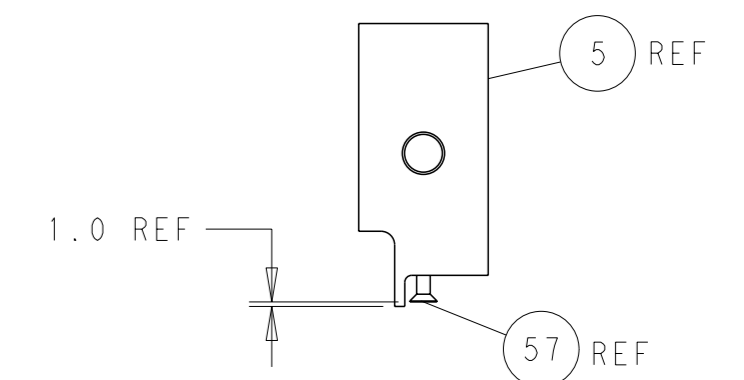
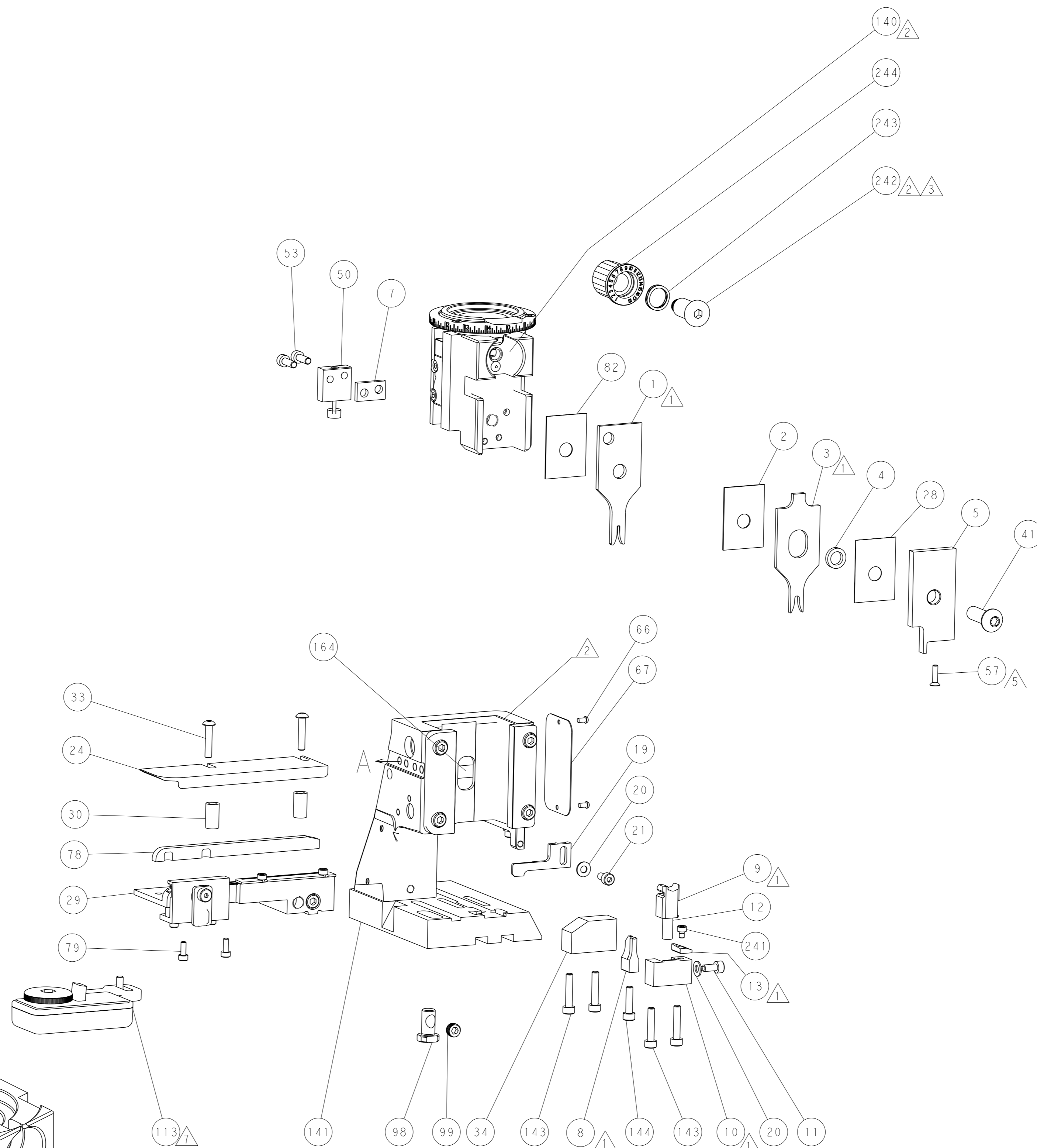
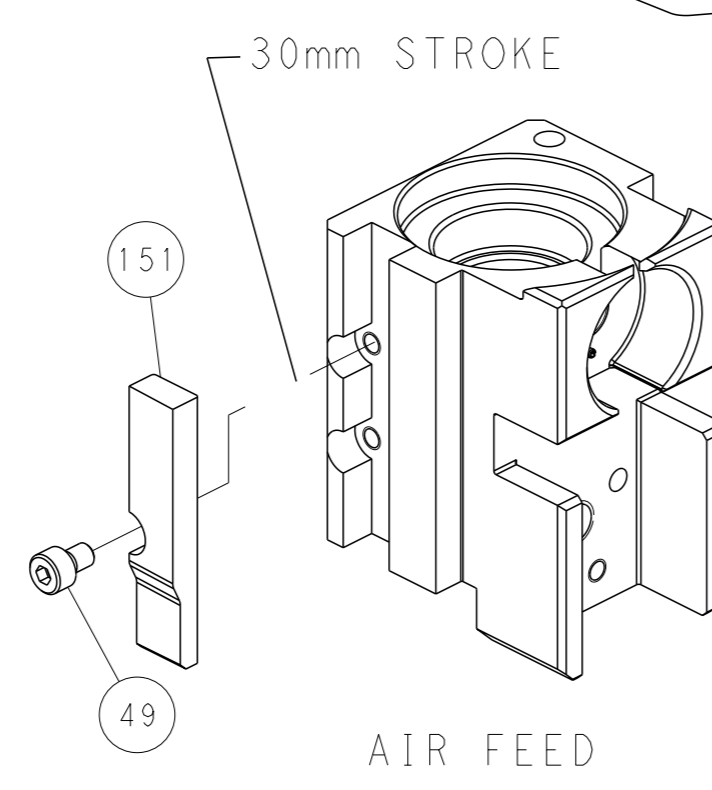
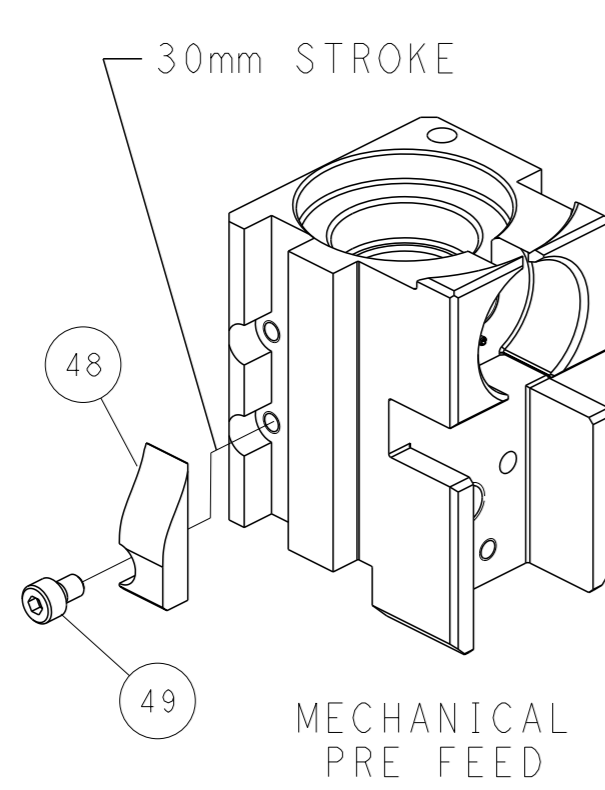
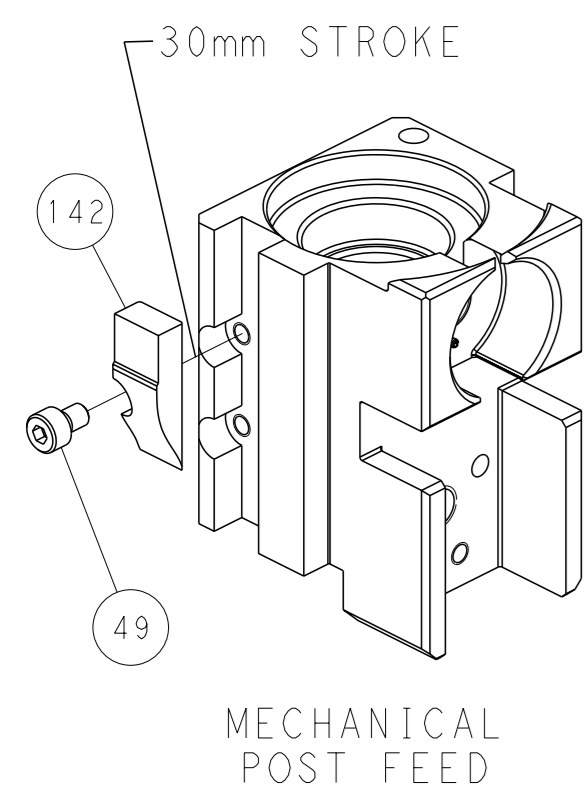
## FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



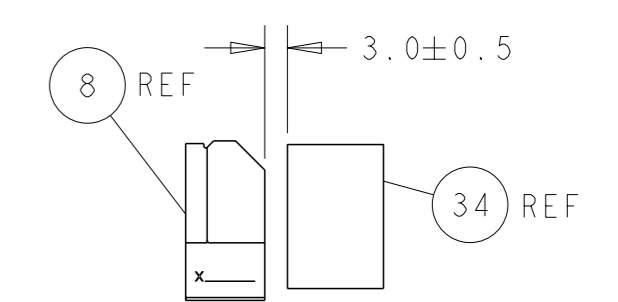
## DOUBLE ACTING PNEUMATIC WITH SENSORS



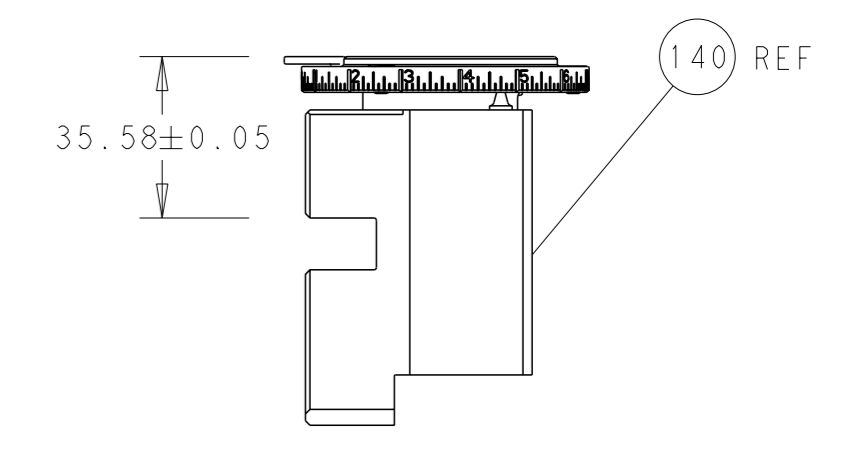
## CAM POSITIONS



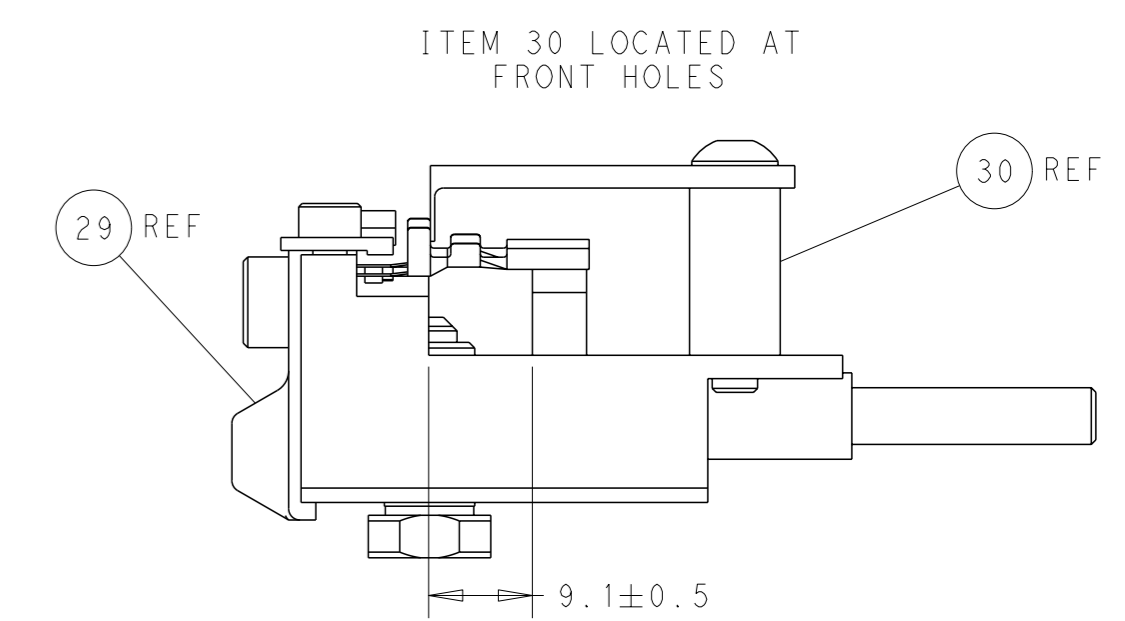
SHEAR DEPRESSOR DETAIL



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: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		OWN: H. HUANG CHK: S. XI APVD: S. XI PRODUCT SPEC APPLICATION SPEC WEIGHT: - MATERIAL: -		REVISIONS P. LYN - SEE SHEET 1 DATE: - OWN: - APVD: -	
CUSTOMER ACCESSIBLE PRODUCTION DRAWING		SCALE: 1:2		SHEET 4 OF 4		REV: K	