

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151466-1	J	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2151466-2	K	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
5-2151466-1	J	SEAL STRIPPER CRIMPER TERMINATING UNIT	MECHANICAL
5-2151466-2	K	SEAL STRIPPER CRIMPER TERMINATING UNIT	PNEUMATIC
7-2151466-1	J	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2151466-2	K	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2151466-7	J	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	4.07 mm [.160]	F
INSUL	6.86 mm [.270]	O

APPLICATOR INSTRUCTIONS
408-35042

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: AMP MCP 6.3/4.8K RECEPTACLE			
WIRE STRIP LENGTH	TERMINAL INSULATION DIAMETER RANGE		
5.10-5.70 mm [.201-.224 IN]	∅ 3.4-4.3mm [1.134-1.169 IN]		
TERMINAL APPLICATION SPECIFICATION	114-18388		

TERMINALS APPLIED				SEAL INSULATION DIAMETER RANGE
TE TERMINAL	TE TERMINAL	VW SEAL	TE SEAL	
1241418-4	1-1241418-3		1394512-1	∅ 3.4-3.7mm
2-1241418-3	1-2327632-3		1719043-1	∅ 4.0-4.5mm
		357972742C	1572663-1	∅ 4.0-4.5mm
		357973742C	1572663-2	∅ 4.0-4.5mm

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
6.00mm2	2.58+/-0.05 [1.102+/-0.002]	5.5
5.00mm2	2.21+/-0.05 [1.087+/-0.002]	8.3
4.00mm2	2.06+/-0.05 [1.081+/-0.002]	9.8

- △ RECOMMENDED SPARE PARTS
- △ REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION & 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.
- △ 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.
- △ TERMINAL LUBRICANT IS RECOMMENDED.
- 7. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- △ THIS CRIMP PARAMETER IS PROVIDED TO MEET A CUSTOM AND UNIQUE CUSTOMER REQUIREMENT. IT HAS BEEN EVALUATED AND IS CONDITIONALLY SPECIFIED BY TE CONNECTIVITY. THIS CUSTOMIZED CRIMP PARAMETER IS NOT LISTED AS AN APPROVED APPLICATION WITHIN A TE CONNECTIVITY APPLICATION SPECIFICATION; HOWEVER, IT HAS BEEN VALIDATED ACCORDING TO TE CONNECTIVITY SPECIFICATIONS 109-18079(TEST GROUP 1) AND 114-18022. TE CONNECTIVITY EXPRESSLY DISCLAIMS ANY AND ALL WARRANTIES THAT THE PRODUCT WILL PERFORM SIMILARLY

***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					
		P	LTN	DESCRIPTION	DATE	OWN	APPD
A	66	J		ECR-19-005454	04APR2019	FL	CT
		K		ECR-19-009412	17JUN2019	TB	TE
		K1		ECR-20-010237	20JUL2020	FZ	RK
		K2		ECR-21-112514	02SEP2021	JWC	TE

-	-	-	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	1	2119082-8	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	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	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	-	3-1752354-3	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	994970-2	COUNTER, MAGNETIC	164
△	-	1	1	1	1	1	1-18028-2	WASHER, FLAT, REG M4	119
-	1	1	1	1	1	1	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113
-	1	1	1	1	1	1	2844908-1	SCREW, LOCKING	99
-	1	1	1	1	1	1	2844907-1	POST, LOCKING	98
-	1	1	1	1	1	1	455888-7	SPACER, CRIMPER	82
-	1	1	1	1	1	1	1803607-3	DOCUMENTATION PACKAGE	71
-	1	1	1	1	1	1	2119791-5	DEPRESSOR, WIRE	70
-	1	1	1	1	1	1	2119943-1	WASHER, SPACER	69
-	1	1	1	1	1	1	2119740-1	TAG, IDENTIFICATION	67
-	2	2	2	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	1	1	1	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	60
-	1	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	1	1338685-1	PAWL, FEED	56
-	4	4	4	4	4	4	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	54
-	2	2	2	2	2	2	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	53
-	1	1	1	1	1	1	1803382-4	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	1803583-9	APPLICATOR BASIC ASSEMBLY, SF	46
-	1	1	-	-	1	1	1803515-1	RAM ASSEMBLY, SF ATLANTIC	44
-	1	1	1	1	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
-	1	1	1	1	1	1	1-1752356-5	SUPPORT, TERMINAL	34
-	2	2	2	2	2	2	1-2079383-3	SCR, BHSC, RoHS (M4 X 25)	33
-	2	2	2	2	2	2	3-2844962-5	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	1	1	1	1	2844992-2	ASSEMBLY, STRIP GUIDE	29
-	1	1	1	1	1	1	455888-3	SPACER, CRIMPER	28
-	1	1	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	1	1	2	2	1-18028-2	WASHER, FLAT, REG M4	20
-	1	1	-	-	1	1	1803013-1	STRIPPER, SIDE FEED	19
-	1	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	1333229-9	ANVIL, COMBINATION	8
-	1	1	1	1	1	1	3-240641-3	SPACER	7
-	1	1	1	1	1	1	1-2119781-0	DEPRESSOR, SHEAR	5
-	1	1	1	1	1	1	238011-2	BLOCK, CRIMPER SPACER	4
△	1	2	2	1	1	1	6-1633996-5	CRIMPER, INSULATION SPECIAL	3
-	1	1	1	1	1	1	455888-3	SPACER, CRIMPER	2
△	1	2	2	1	1	1	8-458141-0	CRIMPER, WIRE PREMIUM	1

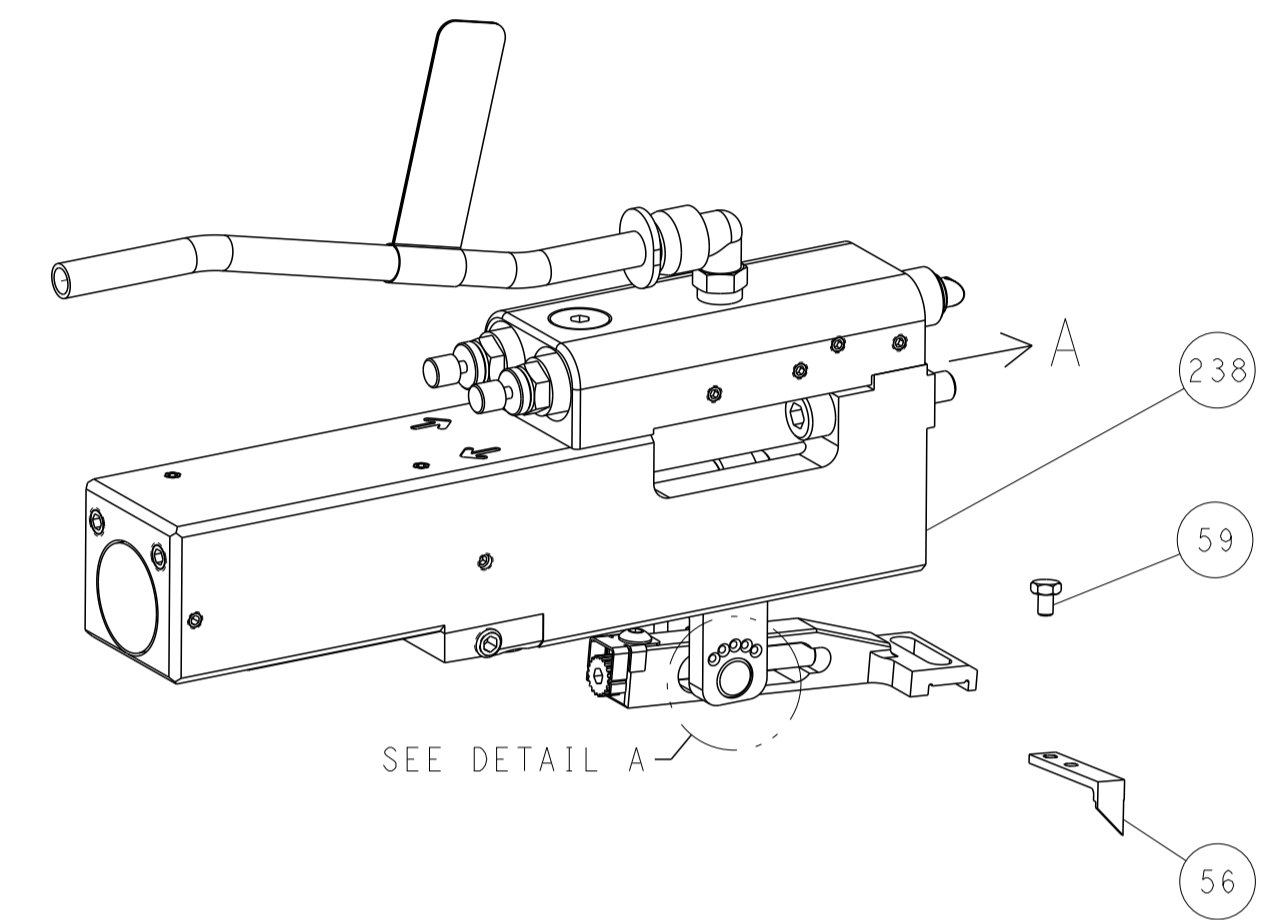
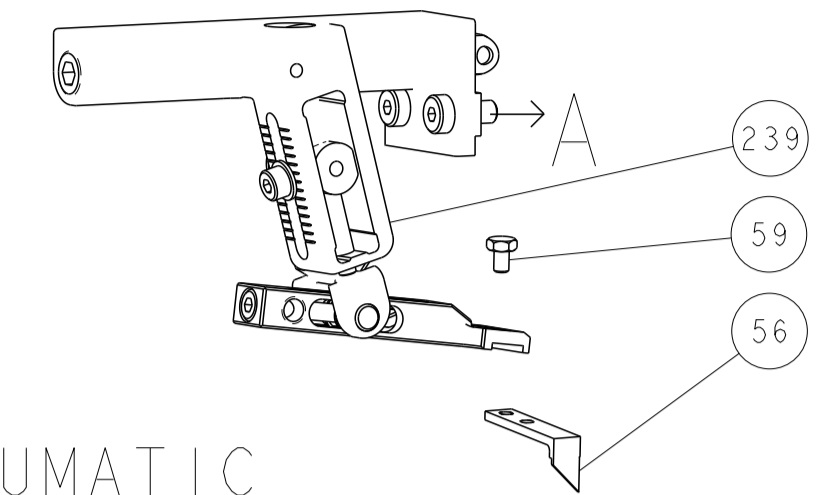
ITEM NO	PART NO	DESCRIPTION
-77	-72	-71
-52	-51	-2
-1		

DATE	16AUG2011	CHK	L. ZHANG
DATE	16AUG2011	CHK	L. ZHANG
DATE	16AUG2011	CHK	L. ZHANG
DATE	16AUG2011	CHK	L. ZHANG

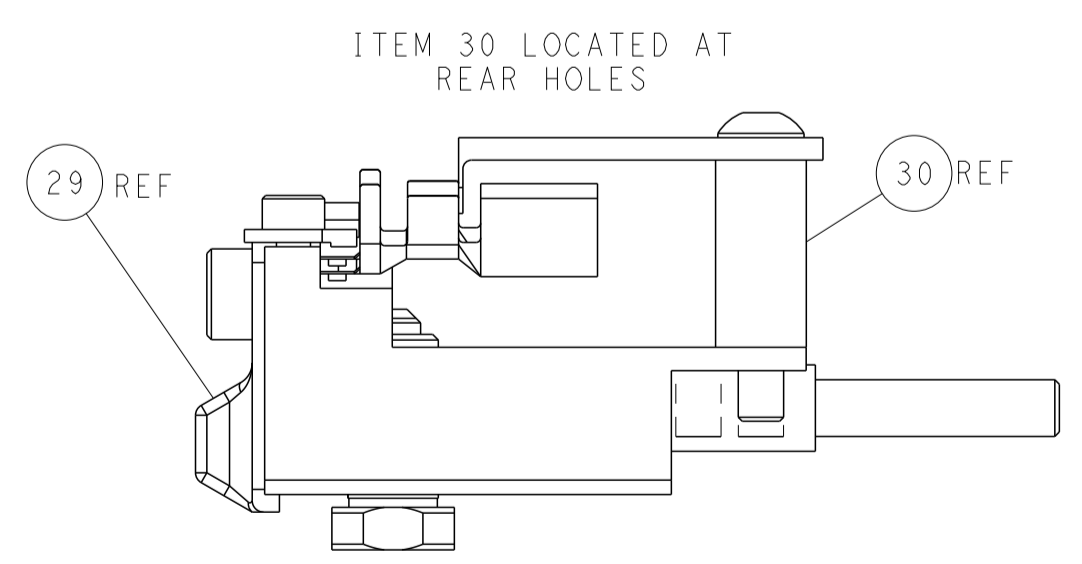
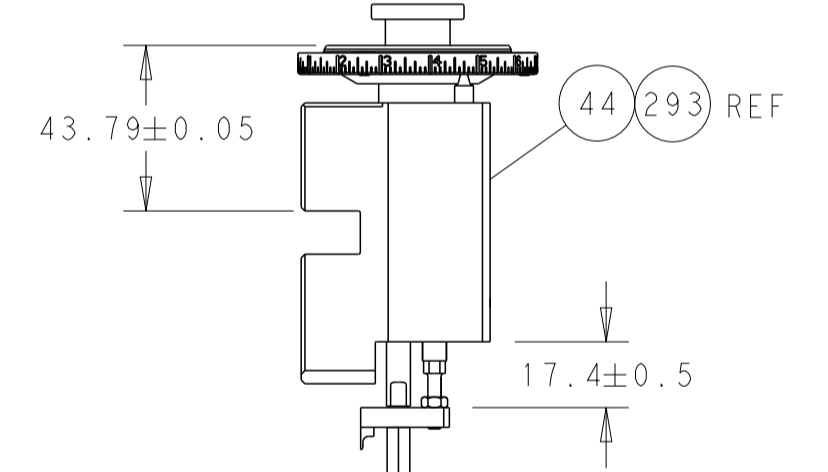
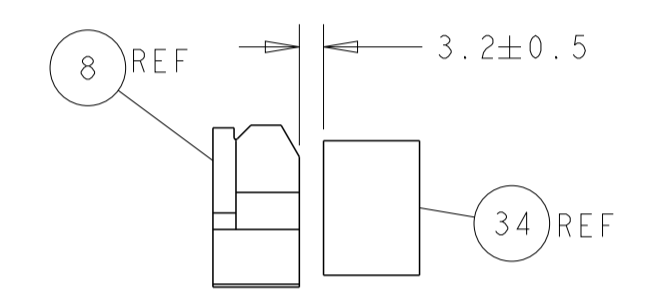
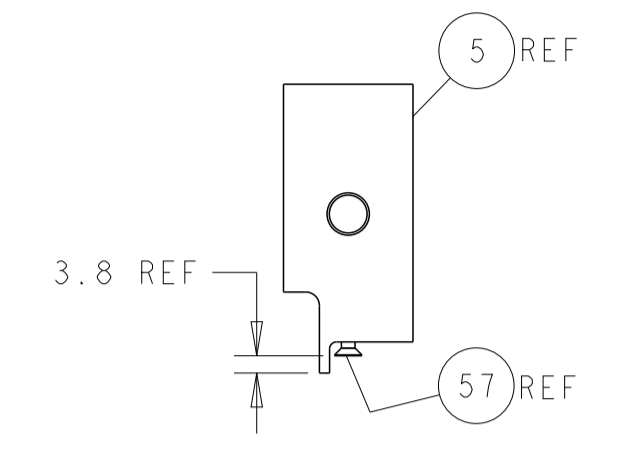
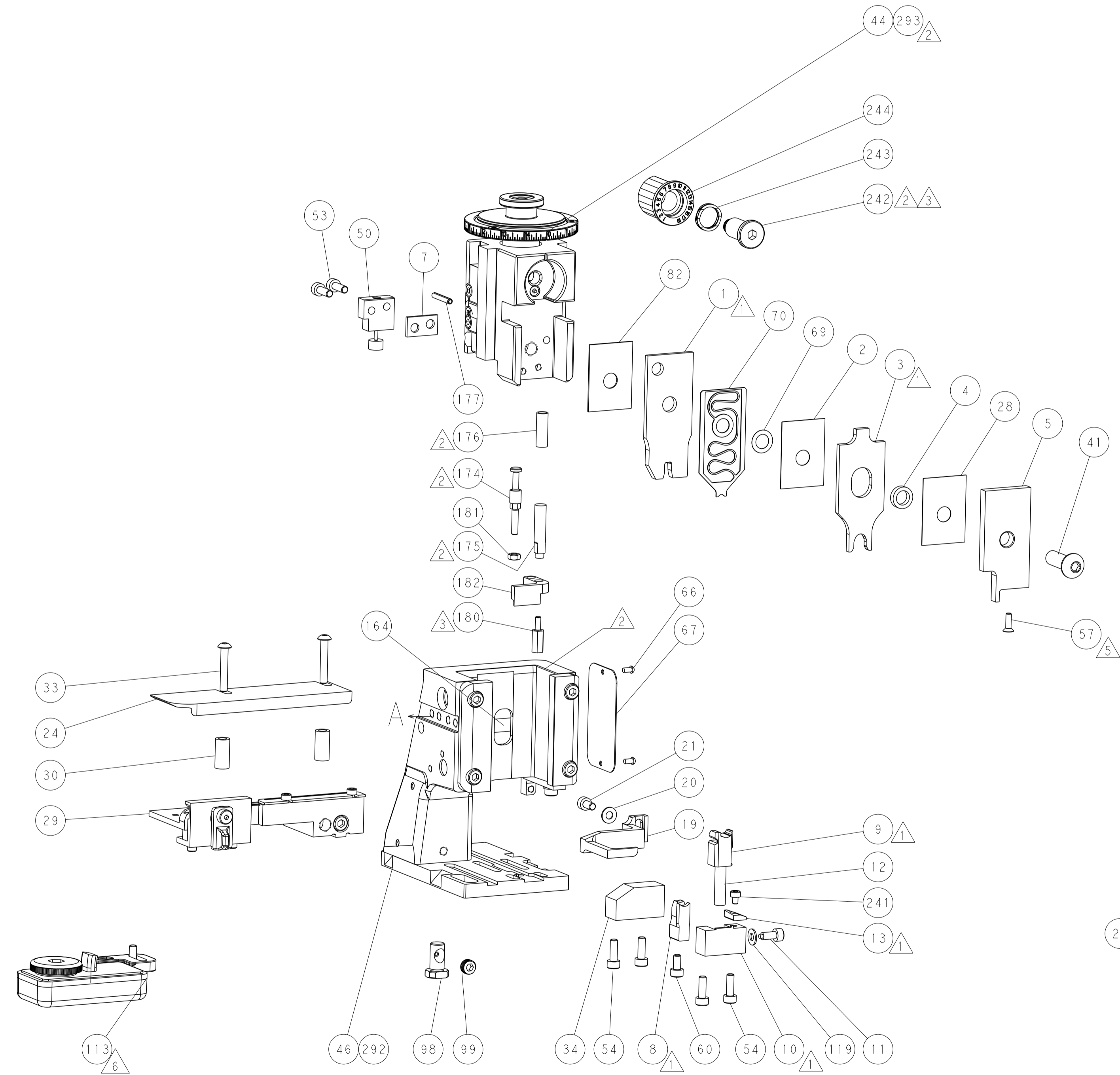
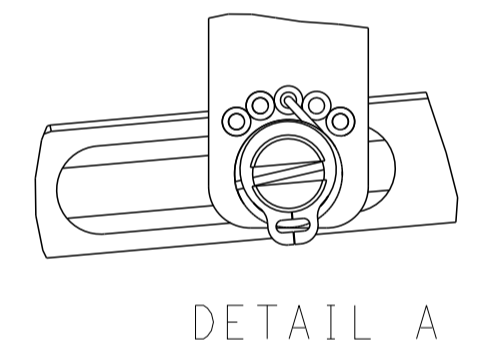
TE Connectivity	Harrisburg, PA 17105-3608		
Ocean Side Feed Applicator			
SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
A1	00779	2151466	
Customer Accessible Production Drawing		SCALE	1:2
SHEET		1	OF 4
REV		K2	

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

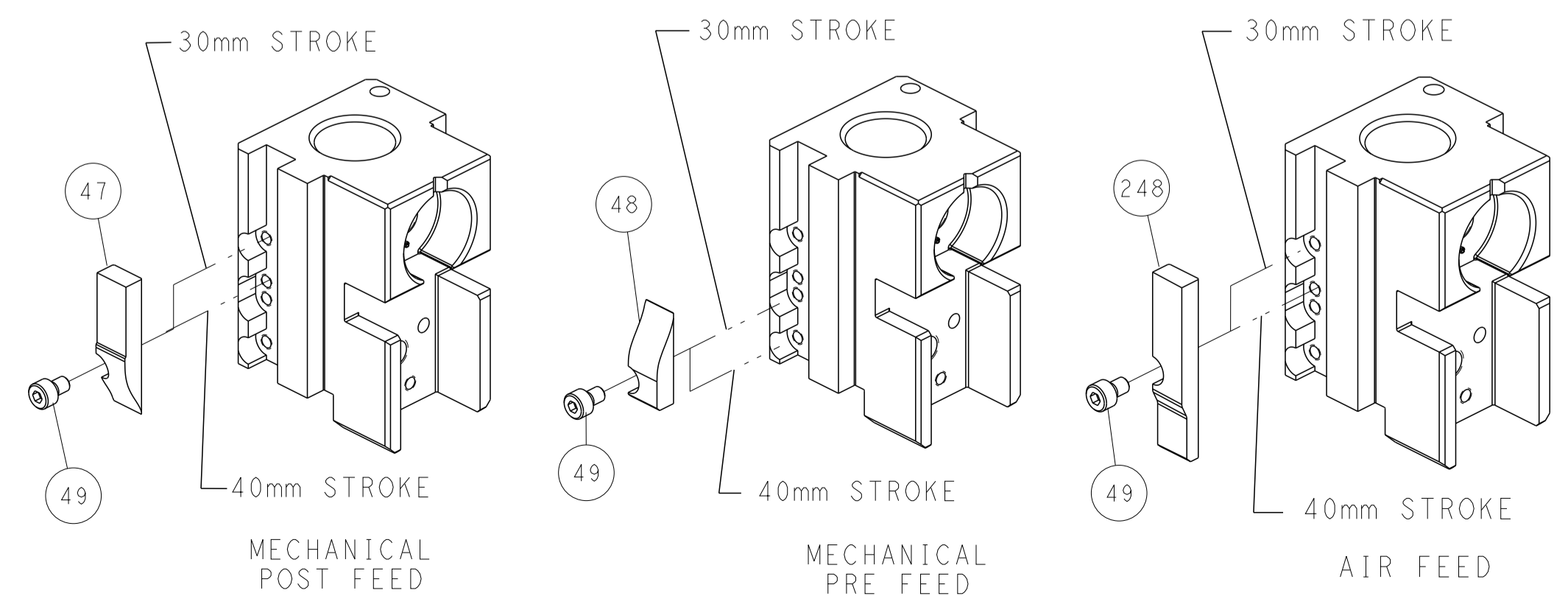
FEED TYPE MECHANICAL



FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



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 L. ZHANG 16AUG2011 CHK L. ZHANG 16AUG2011 APVD S. XI 16AUG2011 PRODUCT SPEC APPLICATION SPEC WEIGHT MATERIAL		NAME Ocean Side Feed Applicator SIZE CAGE CODE DRAWING NO. A1 00779 C=2151466 RESTRICTED TO	
Customer Accessible Production Drawing		SCALE 1:2		SHEET 2 OF 4 REV K2	

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2151466-1	J	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2151466-2	K	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151466-7	J	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
 INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	4.07 mm [1.60]	F
INSUL	6.86 mm [2.70]	O

APPLICATOR INSTRUCTIONS
 408-35042

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: AMP MCP 6.3/4.8K RECEPTACLE			
WIRE STRIP LENGTH	TERMINAL INSULATION DIAMETER RANGE		
5.10-5.70 mm [1.201-.224 IN]	∅ 3.4-4.3mm [1.34-.169 IN]		
TERMINAL APPLICATION SPECIFICATION	114-18388		

TERMINALS APPLIED				SEAL INSULATION DIAMETER RANGE
TE TERMINAL	TE TERMINAL	VW SEAL	TE SEAL	
1241418-4	1-1241418-3		1394512-1	∅ 3.4-3.7mm
2-1241418-3	1-2327632-3		1719043-1	∅ 4.0-4.5mm
		357972742C	1572663-1	∅ 4.0-4.5mm
		357973742C	1572663-2	∅ 4.0-4.5mm

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
6.00mm2	2.58+/-0.05 [1.02+/-0.02]	5.5
5.00mm2	2.21+/-0.05 [1.087+/-0.02]	8.3
4.00mm2	2.06+/-0.05 [1.081+/-0.02]	9.8

- 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.
- 8 THIS CRIMP PARAMETER IS PROVIDED TO MEET A CUSTOM AND UNIQUE CUSTOMER REQUIREMENT. IT HAS BEEN EVALUATED AND IS CONDITIONALLY SPECIFIED BY TE CONNECTIVITY. THIS CUSTOMIZED CRIMP PARAMETER IS NOT LISTED AS AN APPROVED APPLICATION WITHIN A TE CONNECTIVITY APPLICATION SPECIFICATION; HOWEVER, IT HAS BEEN VALIDATED ACCORDING TO TE CONNECTIVITY SPECIFICATIONS 109-18079 (TEST GROUP 1) AND 114-18022. TE CONNECTIVITY EXPRESSLY DISCLAIMS ANY AND ALL WARRANTIES THAT THE PRODUCT WILL PERFORM SIMILARLY

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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	DWN	APVD
		-		SEE SHEET 1	-	-	-

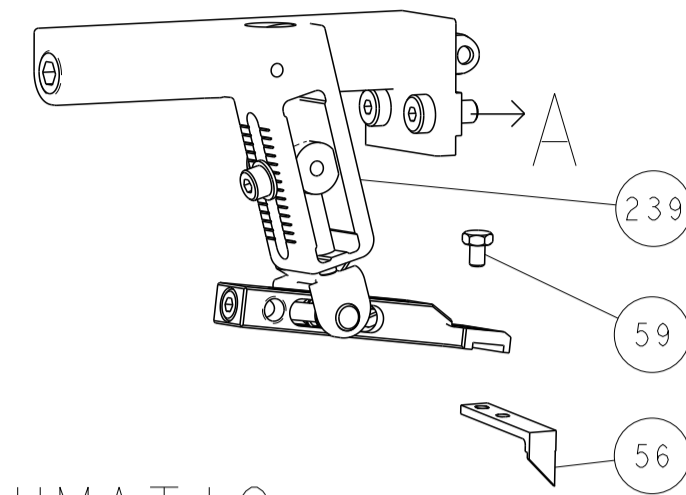
-	1	1	2119082-8	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
-	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	1	-	2844940-1	AIR FEED MODULE	238
-	REF	REF	994970-2	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	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113
-	1	1	2844908-1	SCREW, LOCKING	99
-	1	1	2844907-1	POST, LOCKING	98
-	1	1	455888-7	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	1	1803382-4	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	1-1752356-5	SUPPORT, TERMINAL	34
-	2	2	1-2079383-3	SCR, BHSC, RoHS (M4 X 25)	33
-	2	2	3-2844962-5	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	2844992-2	ASSEMBLY, STRIP GUIDE	29
-	1	1	455888-3	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	1803013-1	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	1333229-9	ANVIL, COMBINATION	8
-	1	1	3-240641-3	SPACER	7
-	1	1	1-2119781-0	DEPRESSOR, SHEAR	5
-	1	1	238011-2	BLOCK, CRIMPER SPACER	4
1	1	1	6-1633996-5	CRIMPER, INSULATION SPECIAL	3
-	1	1	455888-3	SPACER, CRIMPER	2
1	1	1	8-458141-0	CRIMPER, WIRE PREMIUM	1

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DRAWING NO		RESTRICTED TO	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	5 PLC ±	ANGLES ±
MATERIAL:				FINISH:	WEIGHT:	SCALE:	REV:

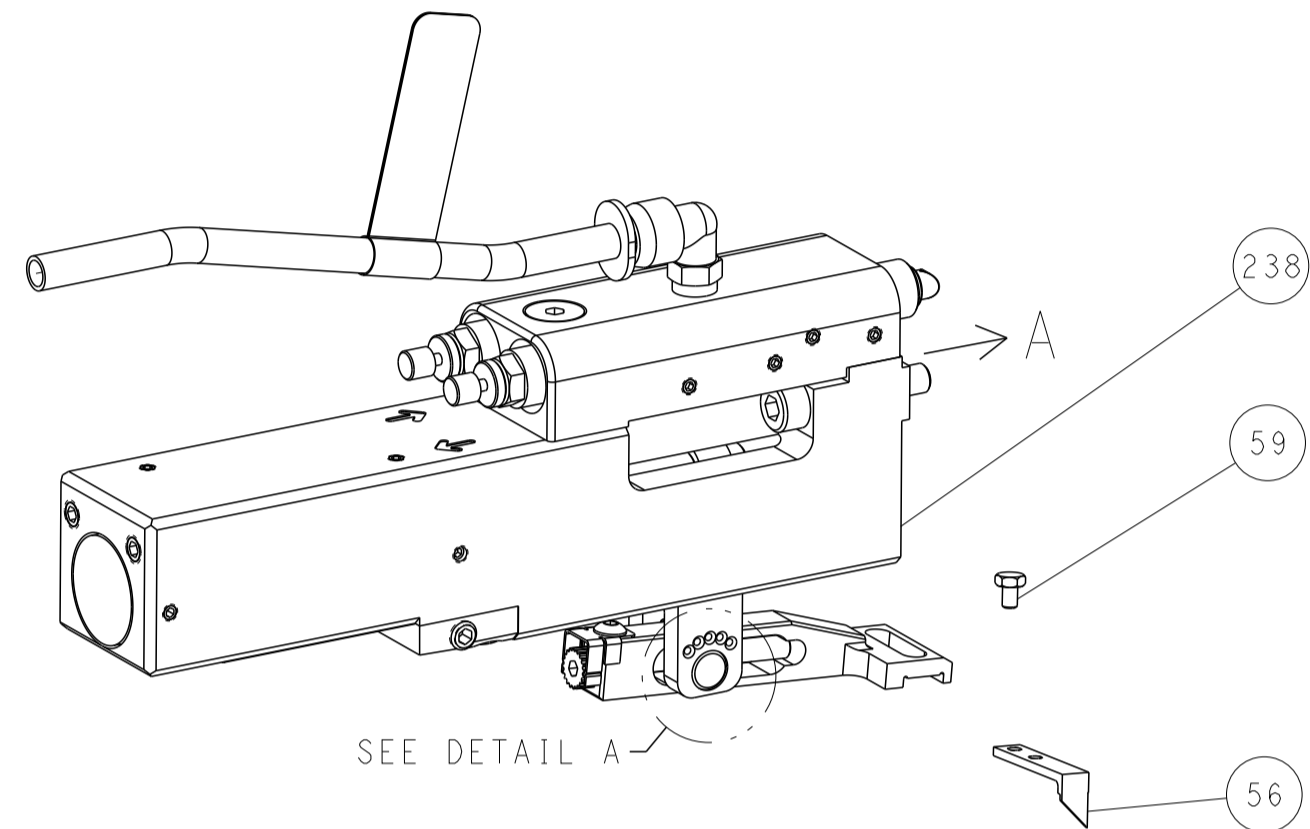
ITEM NO	PART NO	DESCRIPTION			
-77	-22	-21	PART NO	DESCRIPTION	ITEM NO

APVD	L. ZHANG	16AUG2011
CHK	L. ZHANG	16AUG2011
DWN	L. ZHANG	16AUG2011
NAME		
Ocean Side Feed Applicator		
SIZE	CAGE CODE	DRAWING NO
A1	00779	2151466
Customer Accessible Production Drawing		
SCALE	1:2	SHEET 3 OF 4
REV	K2	

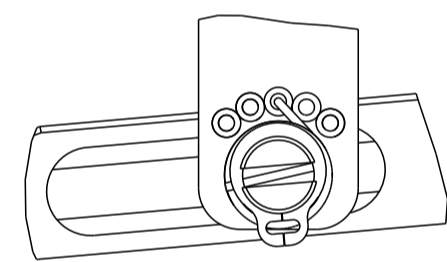
FEED TYPE MECHANICAL



PNEUMATIC

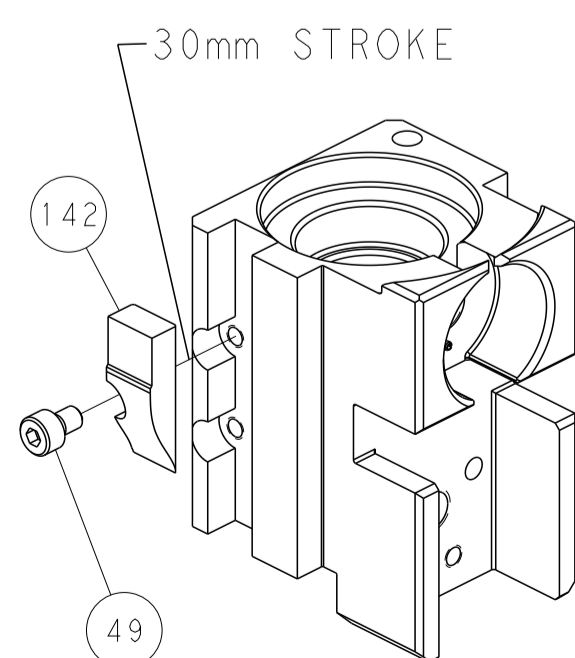


FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)

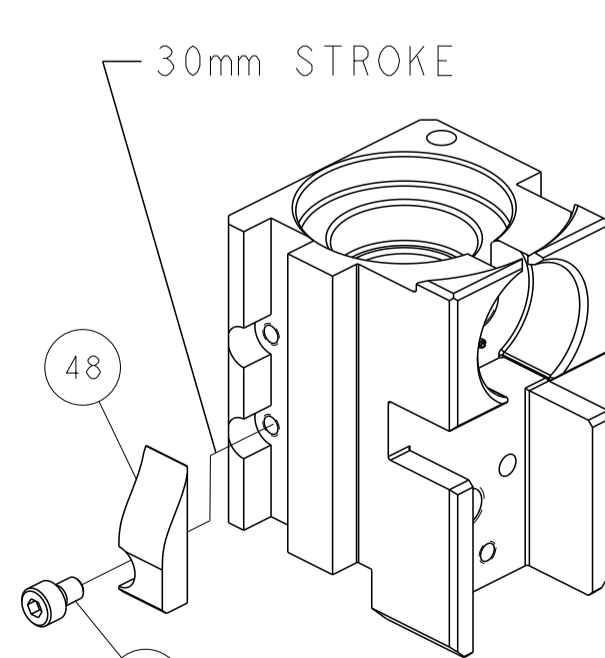


DETAIL A

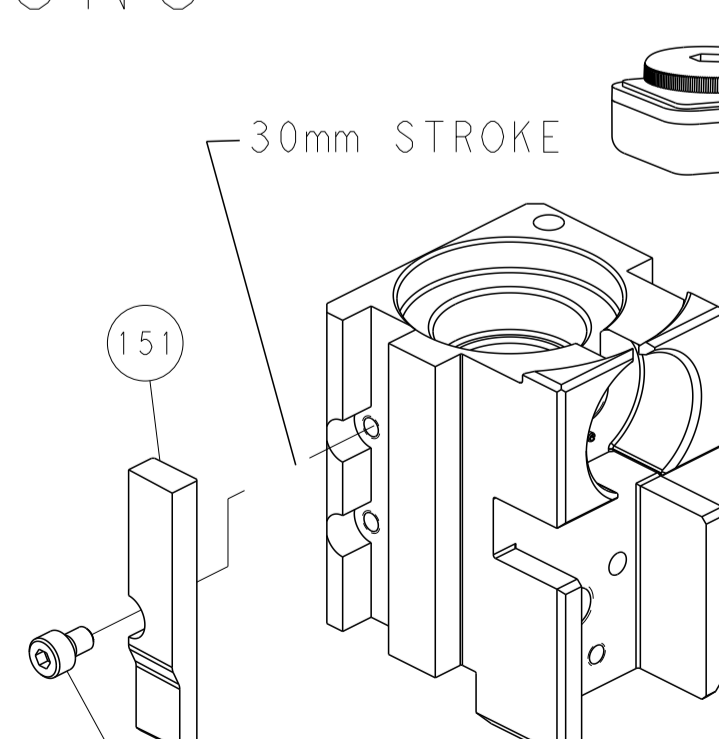
CAM POSITIONS



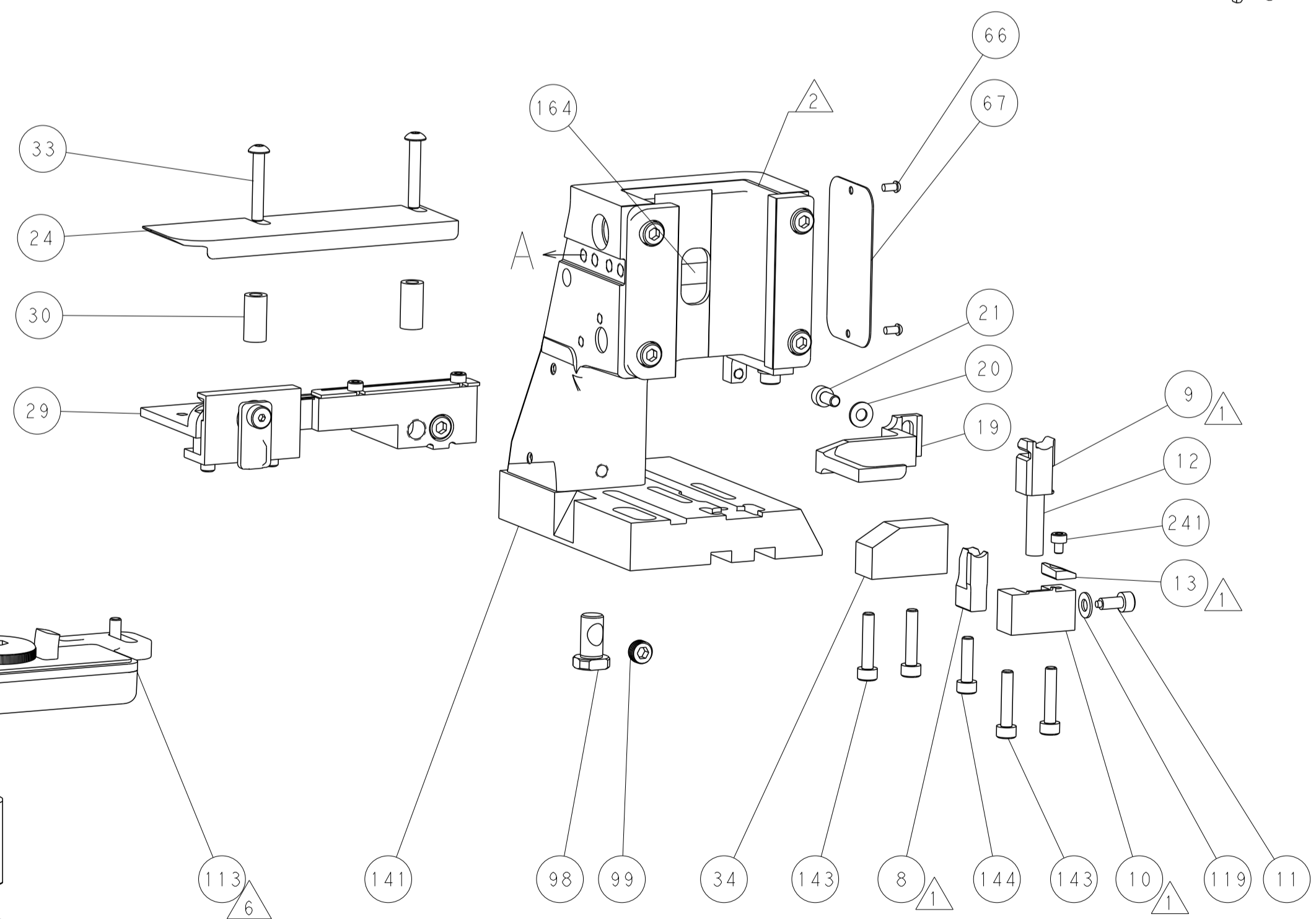
MECHANICAL
POST FEED



MECHANICAL
PRE FEED

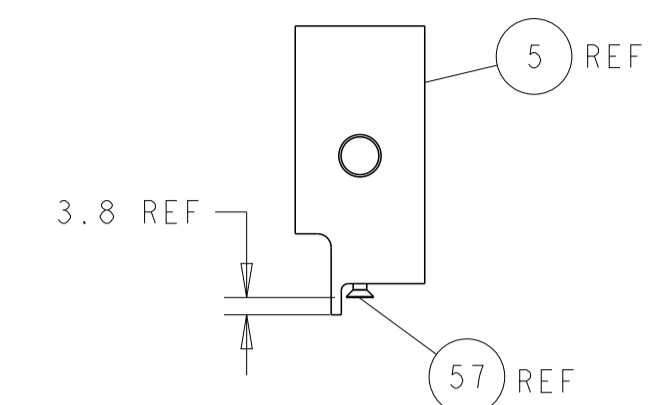


AIR FEED

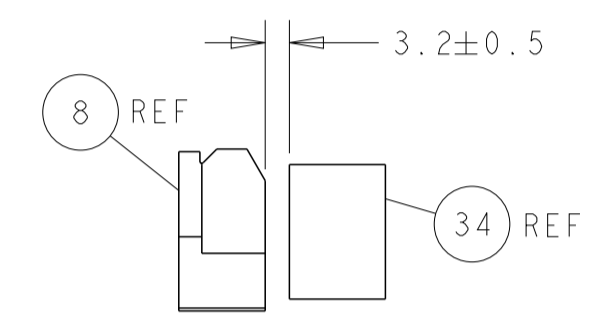


PACIFIC VERSION
Shown on sheets 3 of 4 & 4 of 4
(Atlantic version shown on sheets 1 of 4 & 2 of 4)

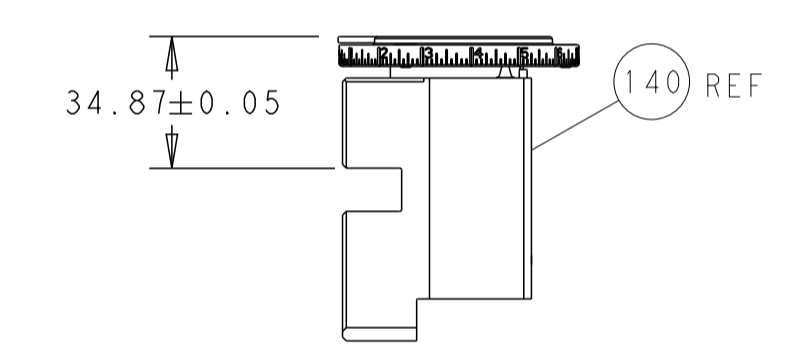
LOC	DIST	REVISIONS					
A	66	P	LTN	DESCRIPTION	DATE	OWN	APVD
		-		SEE SHEET 1			



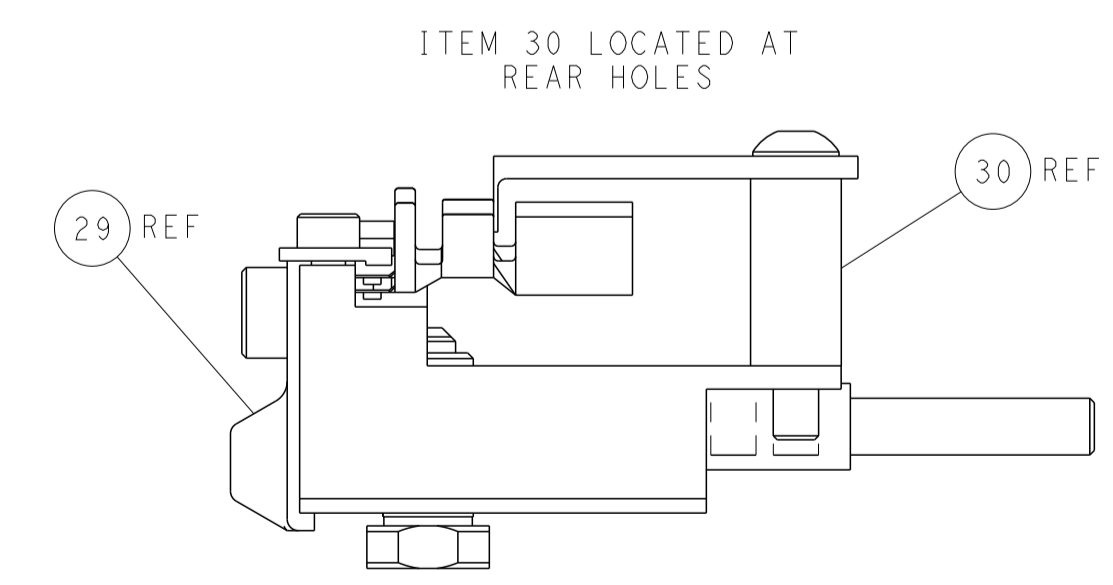
SHEAR DEPRESSOR DETAIL



TERMINAL SUPPORT LOCATION



RAM SET-UP



FEED TRACK POSITION
GUIDE BY WIRE BARREL

<small>THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION 20</small> <small>THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION 20</small> <small>THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION 20</small>		DWN L. ZHANG 16AUG2011 CHK L. ZHANG 16AUG2011 S. XI 16AUG2011 APVD S. XI 16AUG2011	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 Side Feed Applier APPLICATION SPEC PRODUCT SPEC SIZE CAGE CODE DRAWING NO A1 00779 C=2151466	RESTRICTED TO SCALE 1:2 SHEET 4 OF 4 REV K2
MATERIAL:		WEIGHT:	Customer Accessible Production Drawing

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION