

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]	Ø 3.4-4.3mm [1.134-1.69 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	Ø 3.4-3.7mm
2-1241418-3	1-2327632-3		1719043-1	Ø 4.0-4.5mm
		357972742C	1572663-1	Ø 4.0-4.5mm
		357973742C	1572663-2	Ø 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)

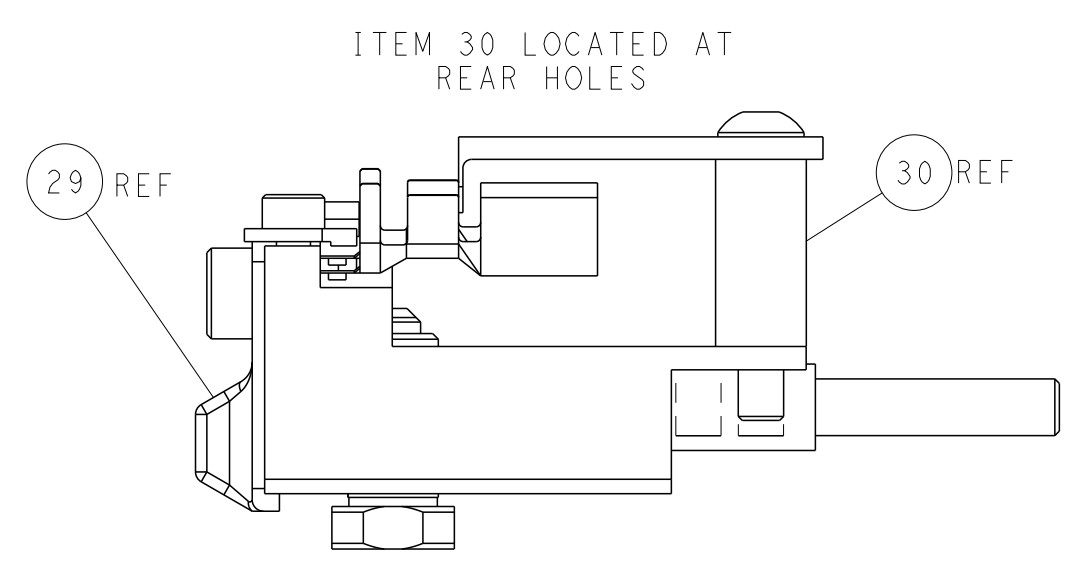
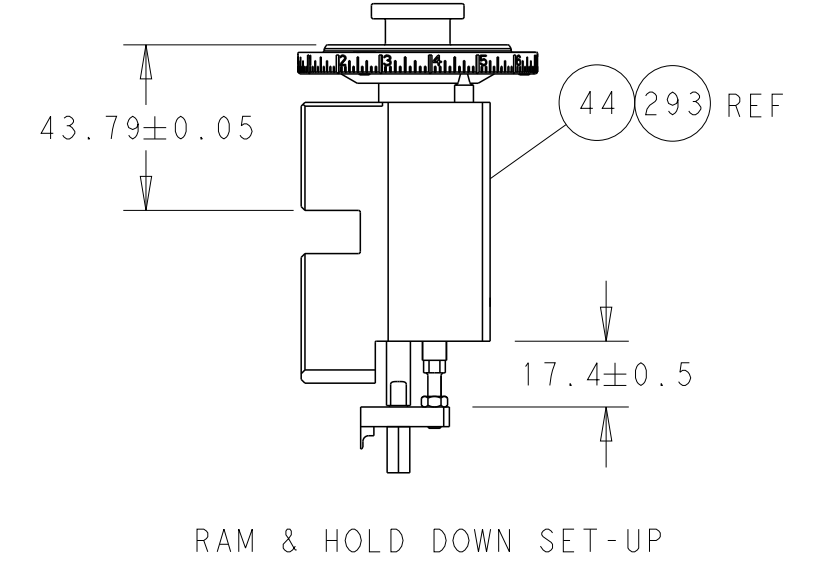
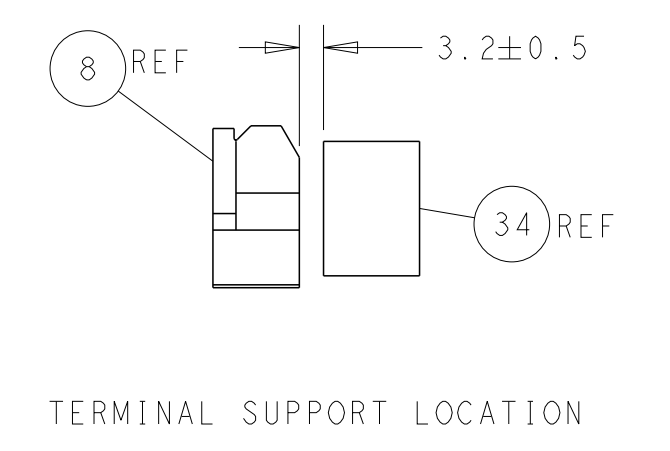
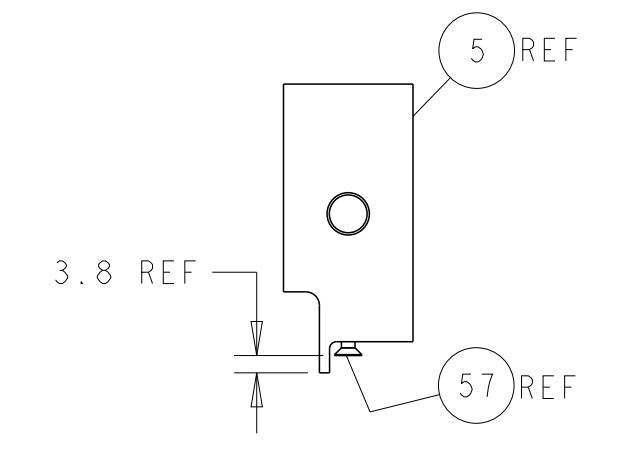
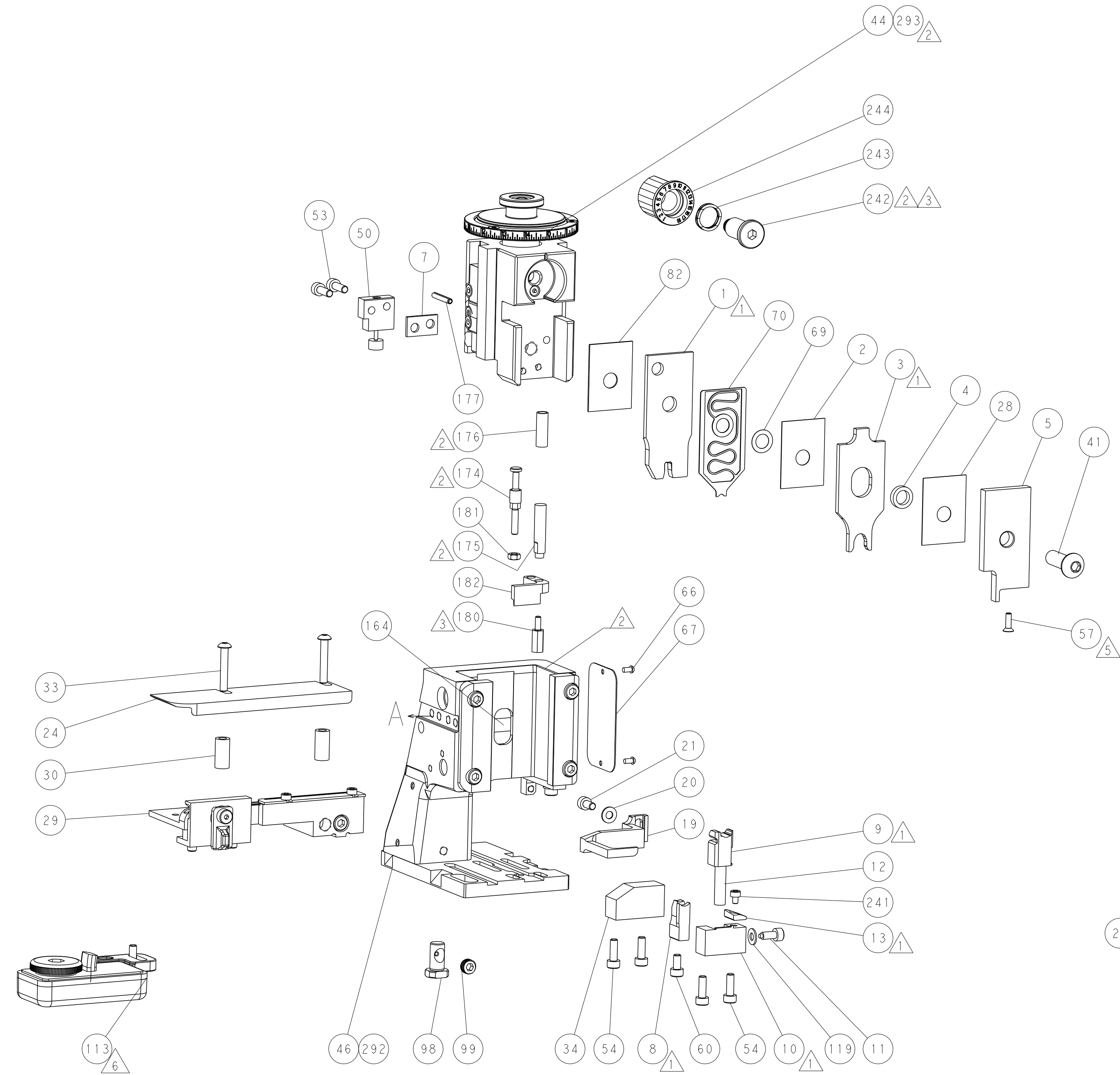
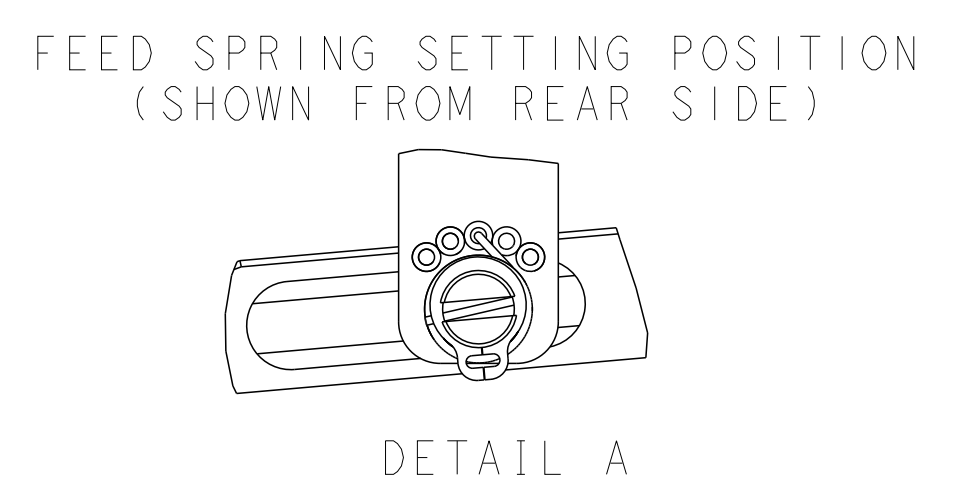
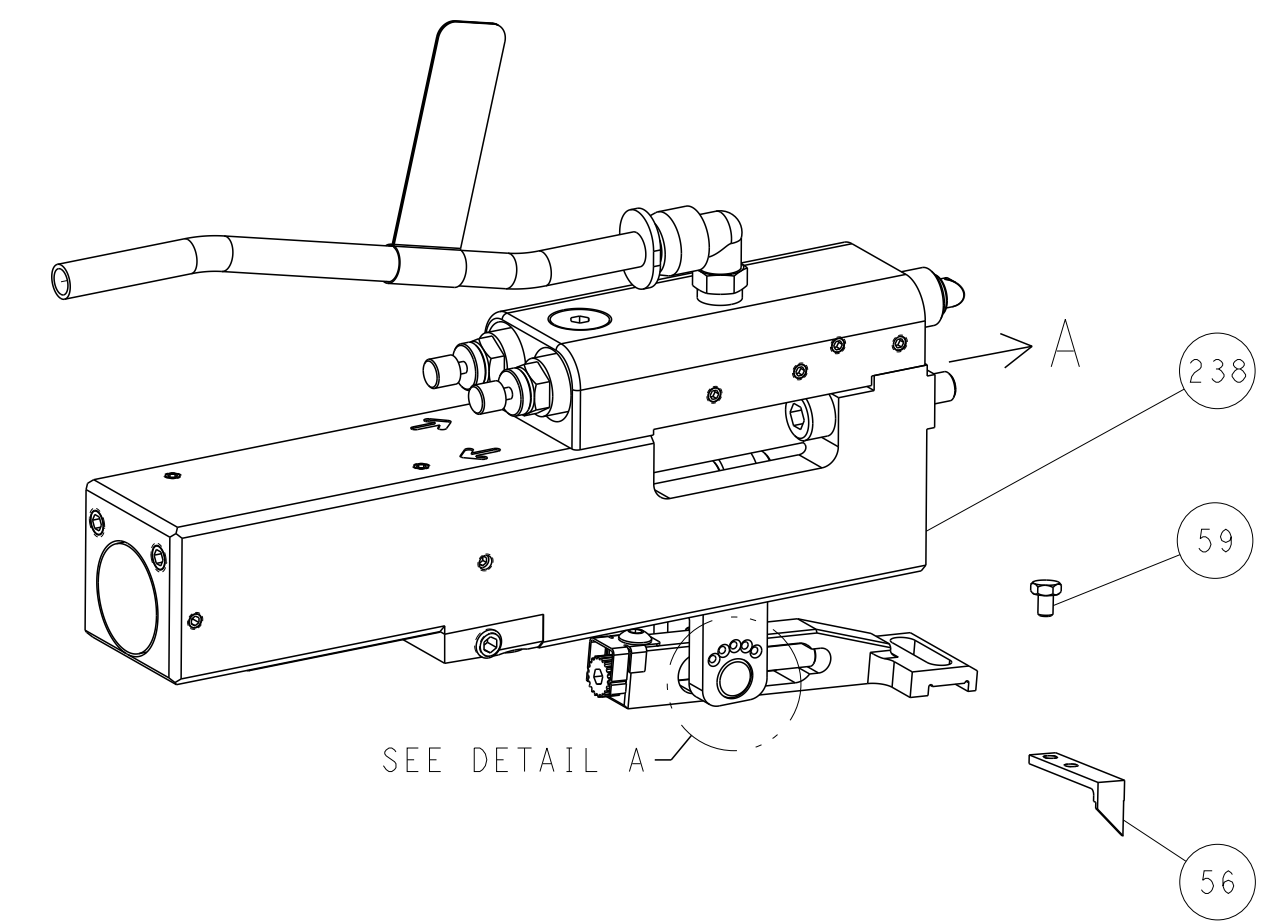
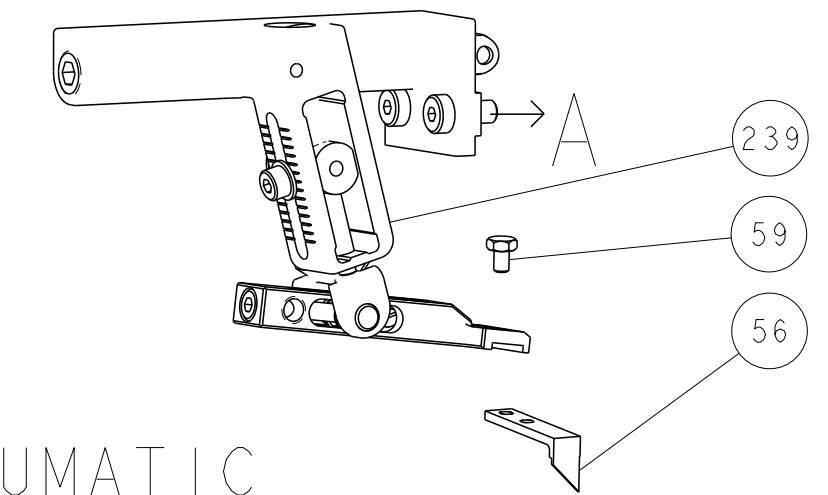
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		K		ECR-19-009412	17JUN2019	TB	TE
		K1		ECR-20-010237	20JUL2020	FZ	RK
		K2		ECR-21-112514	02SEP2021	JWC	TE

-	-	-	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

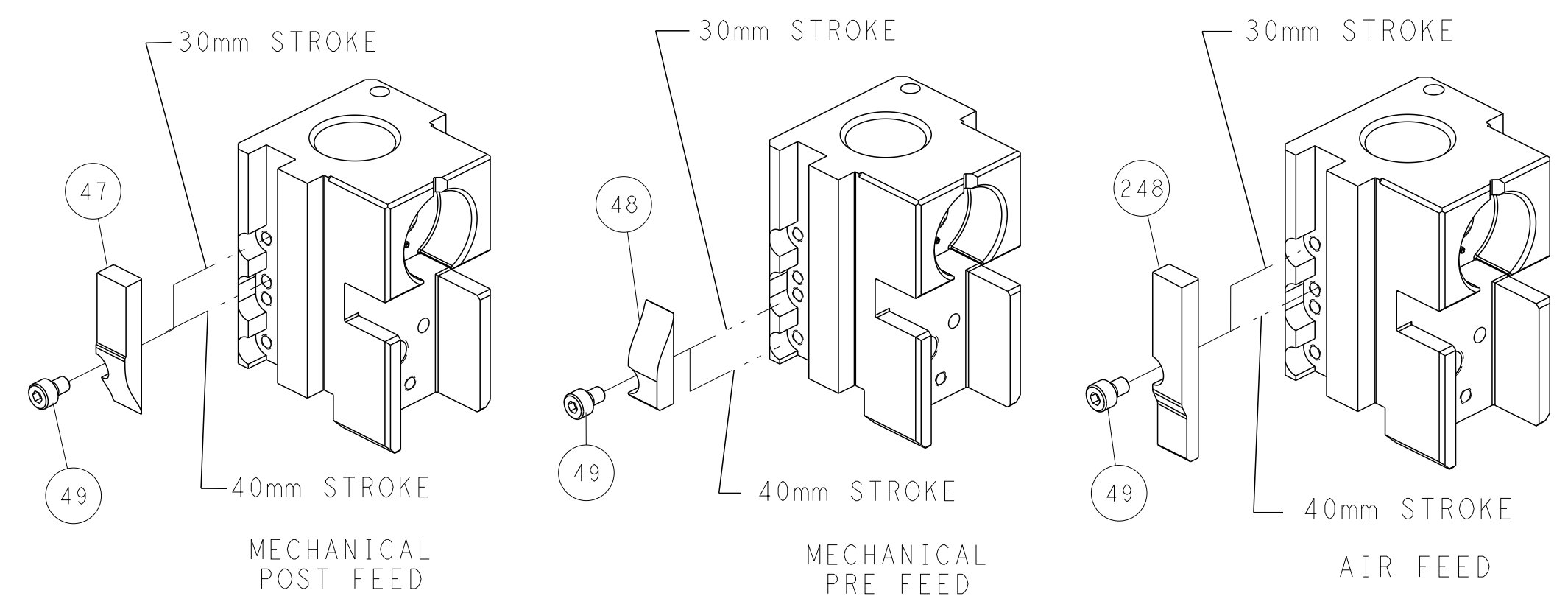
ITEM NO	PART NO	DESCRIPTION	ITEM NO
-77	-72	-71	-52
-51	-2	-1	
THIS IS A PRELIMINARY DRAWING. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. THE CUSTOMER SHALL BE RESPONSIBLE FOR VERIFYING THE DIMENSIONS AND TOLERANCES OF THE PARTS BEFORE PROCEEDING WITH PRODUCTION.		TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:	
0 PLC ±		1 PLC ±	
1 PLC ±		2 PLC ±	
2 PLC ±		3 PLC ±	
3 PLC ±		4 PLC ±	
4 PLC ±		ANGLES ±	
MATERIAL		FINISH	
APPROVED: L. ZHANG 16AUG2011		APPROVED: S. XI 16AUG2011	
CHECKED: L. ZHANG 16AUG2011		NAME: Ocean Side Feed Applicator	
PRODUCT SPEC		APPLICATION SPEC	
SIZE: A1		CAGE CODE: 00779	
DRAWING NO: 2151466		RESTRICTED TO: -	
SCALE: 1:2		SHEET 1 OF 4	
Customer Accessible Production Drawing		REV: K2	

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

# FEED TYPE MECHANICAL



# 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: A1 CAGE CODE: 00779 DRAWING NO: C=2151466 SCALE: 1:2 SHEET: 2 OF 4 REV: K2	
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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.
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**\*WARNING**  
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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)

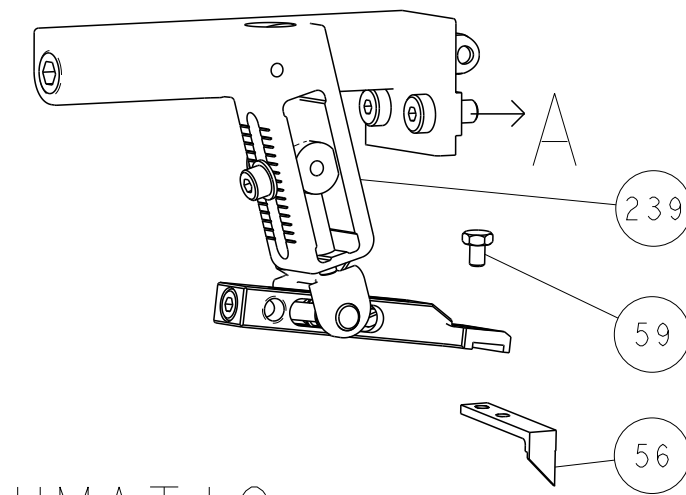
LOC	DIST	REVISIONS					
A	66	P	LTN	DESCRIPTION	DATE	OWN	APVD
		-	-	SEE SHEET 1	-	-	-

-	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
-	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

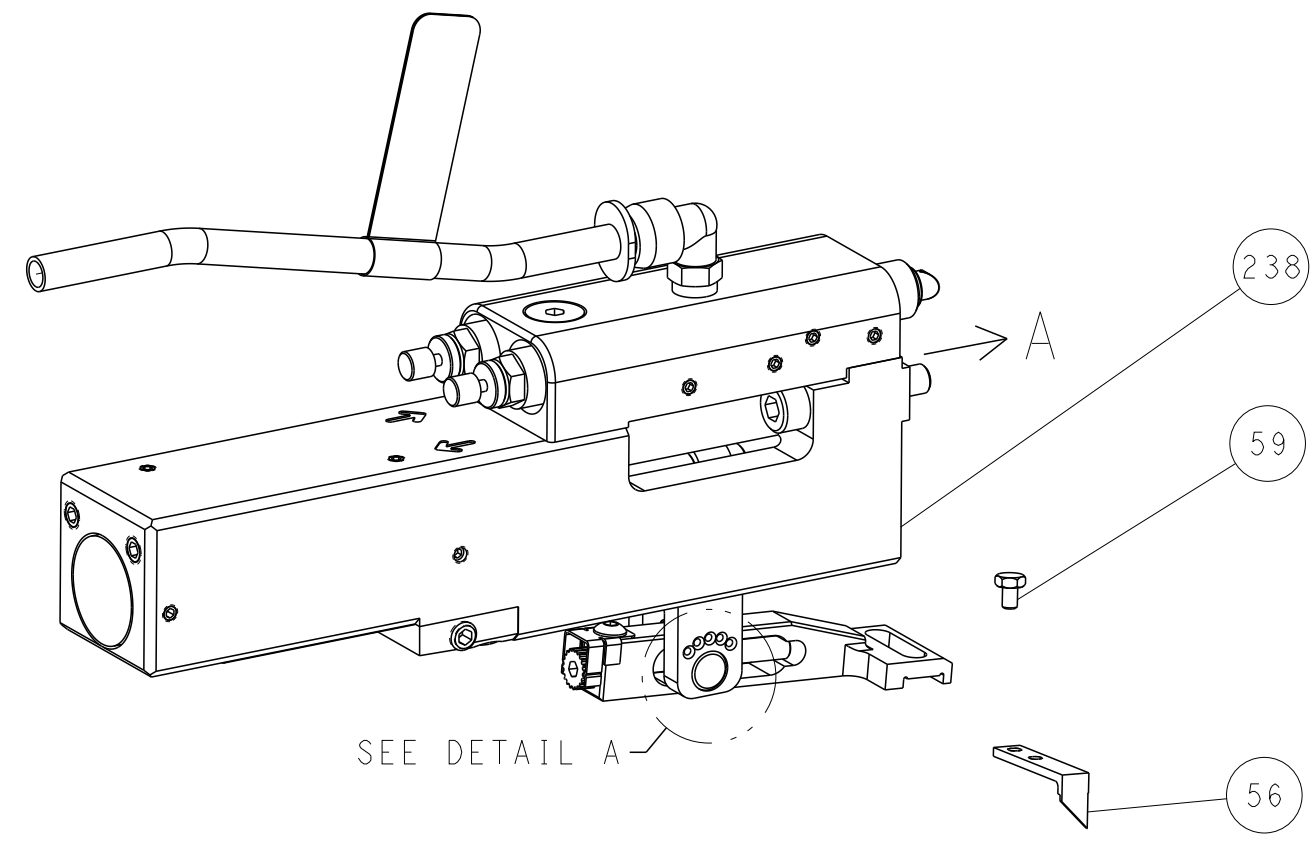
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mm	ANGLES ±	FINISH ±	MATERIAL		WEIGHT		SCALE
				APVD		SHEET	
				CHK		REV	
				DWN		DATE	
				L. ZHANG		16AUG2011	
				L. ZHANG		16AUG2011	
				S. XI		16AUG2011	
				PRODUCT SPEC		NAME	
				APPLICATION SPEC		Ocean Side Feed Applicator	
				SIZE		CAGE CODE	
				A1		00779	
				DRAWING NO		2151466	
				CUSTOMER ACCESSIBLE PRODUCTION DRAWING		SCALE 1:2 SHEET 3 OF 4 REV K2	

LOC		DIST		REVISIONS			
A	66	P	LTM	DESCRIPTION	DATE	OWN	APVD
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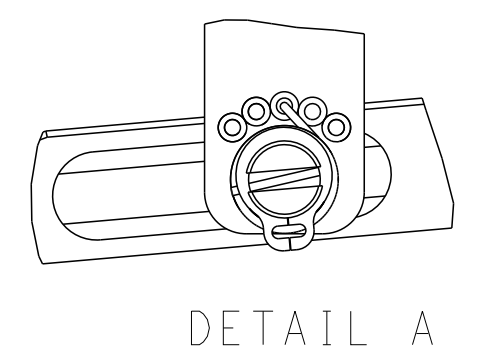
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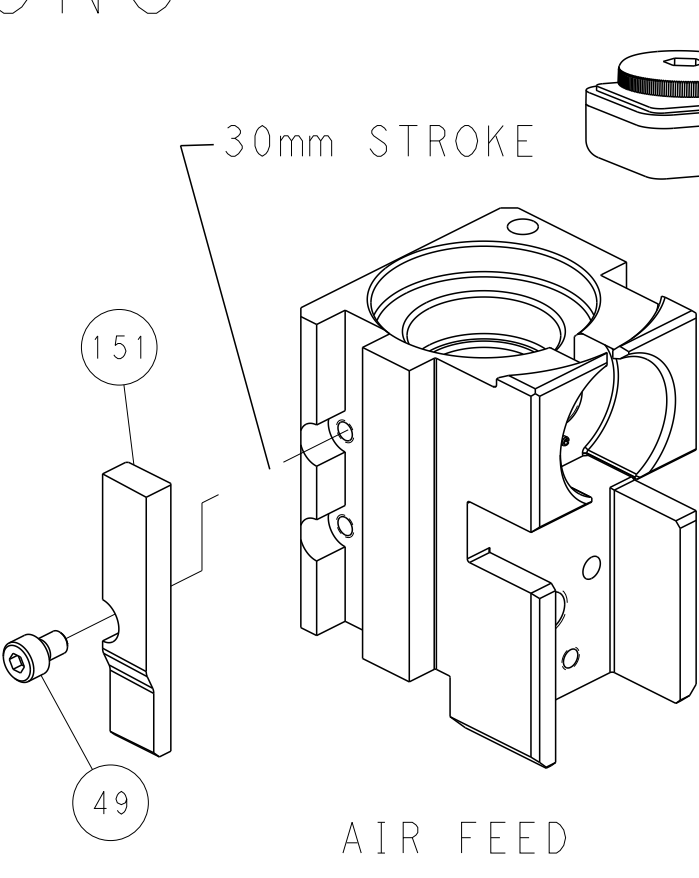
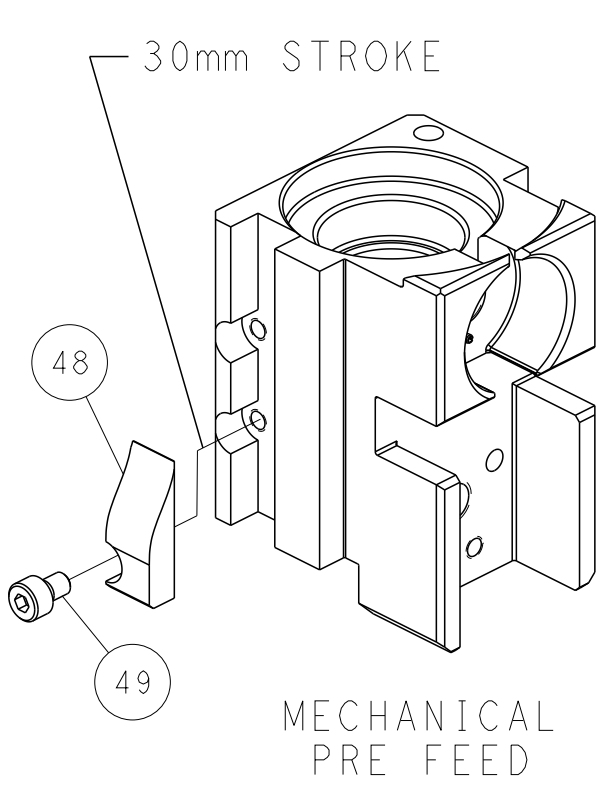
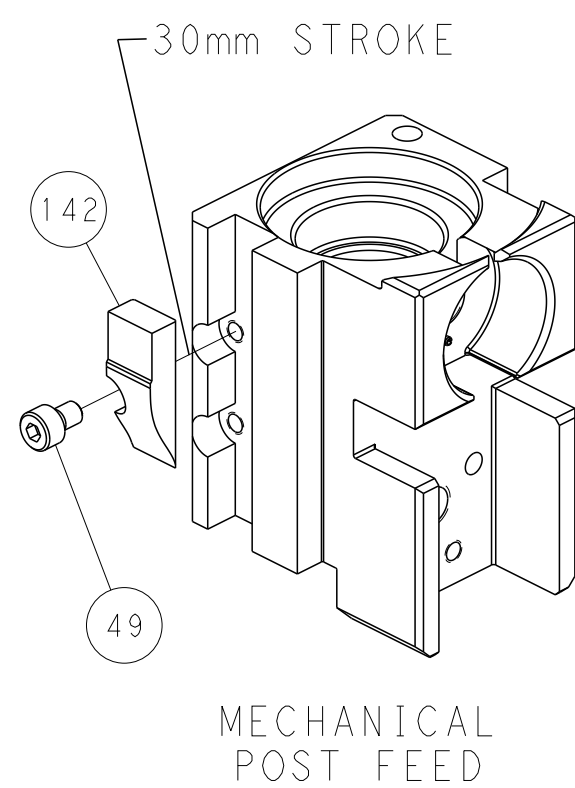
## PNEUMATIC



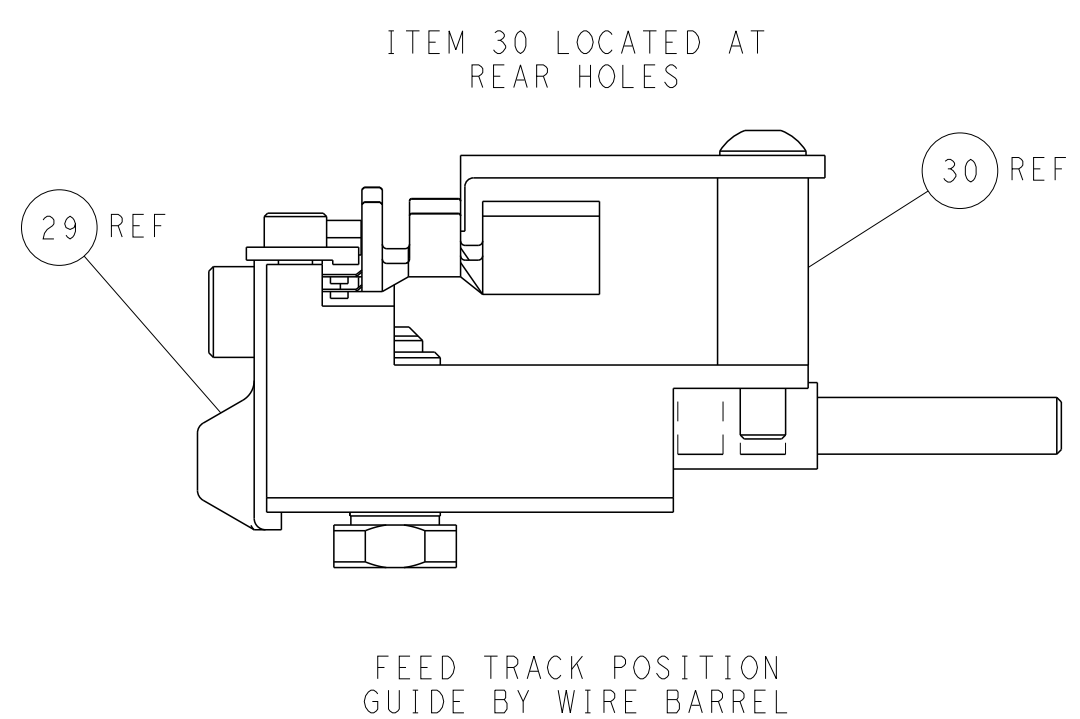
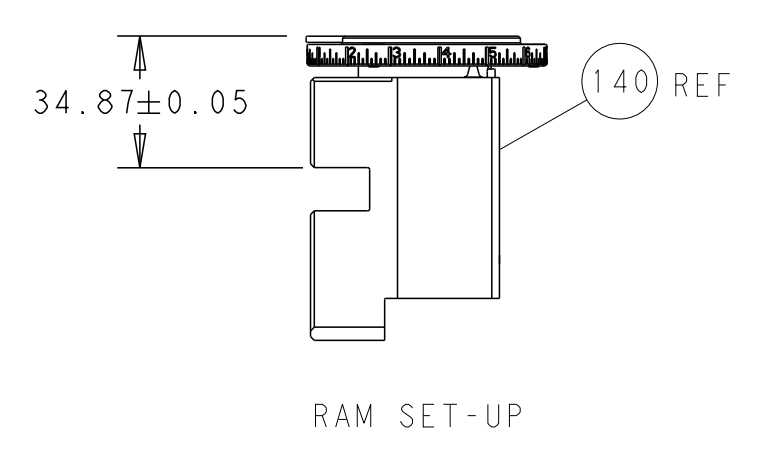
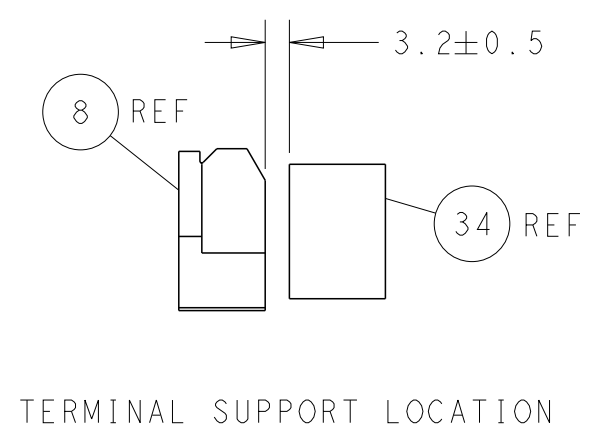
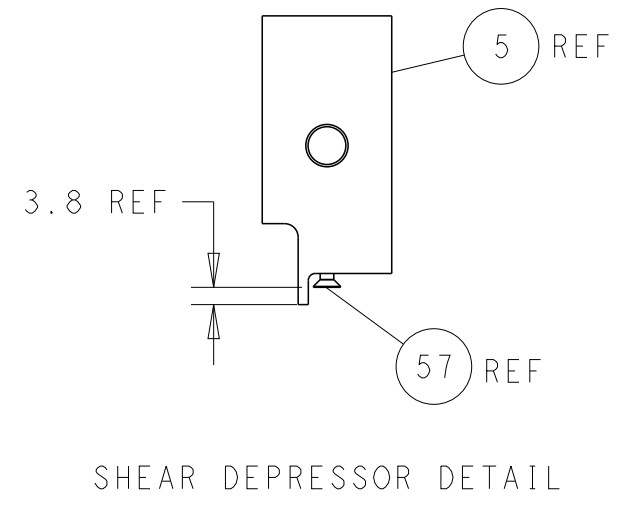
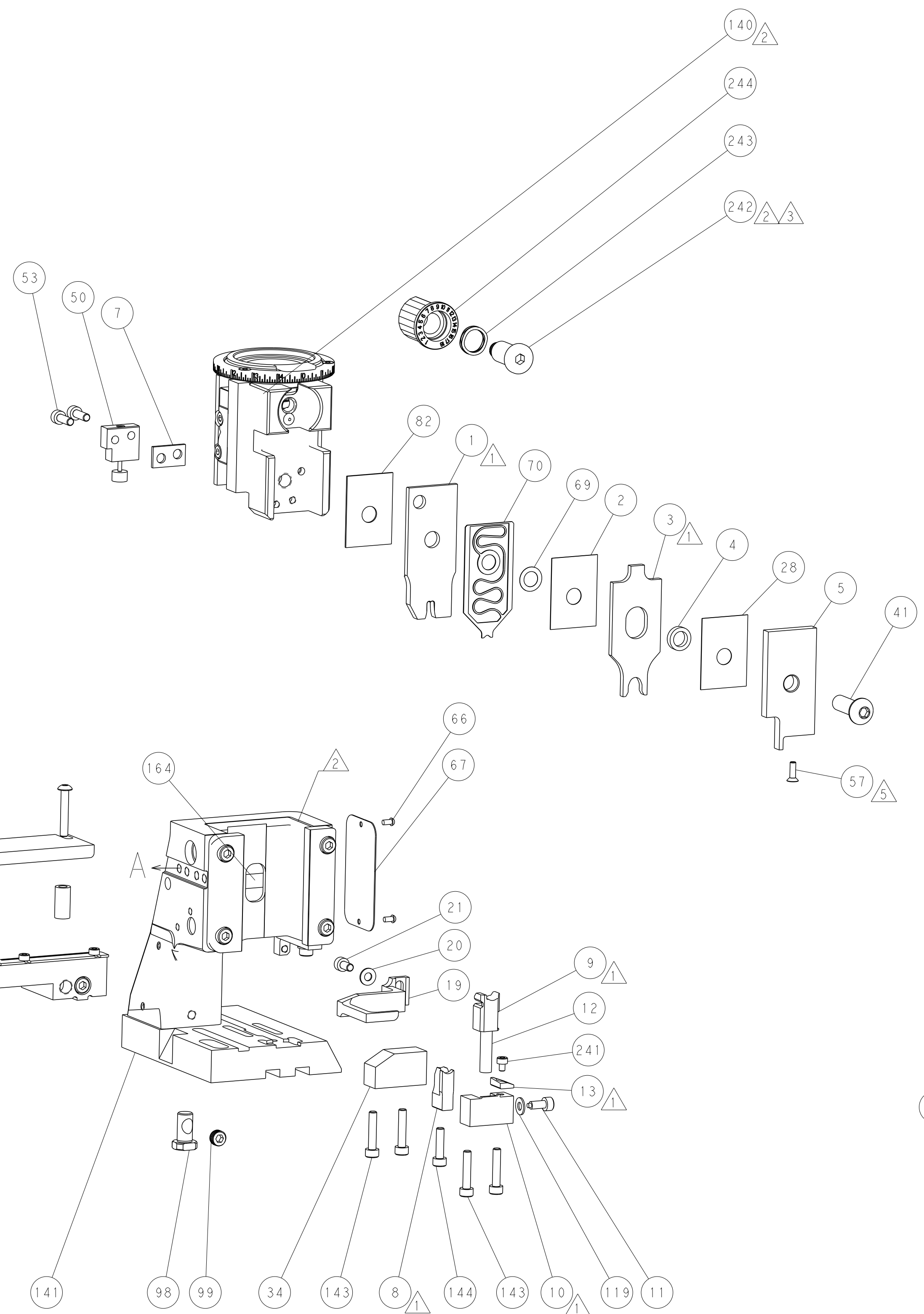
### FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



## CAM POSITIONS



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



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DIMENSIONS: mm 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± MATERIAL FINISH	TOLERANCES UNLESS OTHERWISE SPECIFIED: ± ± ± ± ± ±	WEIGHT - SCALE 1:2 SHEET 4 OF 4 REV K2	Customer Accessible Production Drawing		

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