

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151471-1	E	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2151471-2	E	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151471-1	E	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2151471-2	E	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2151471-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.57 mm [.062]	F
STABILIZER	1.78 mm [.070]	F
INSUL	1.78 mm [.070]	F

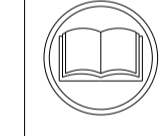
APPLICATOR INSTRUCTIONS
408-35042

TERMINAL DATA: TE TERMINAL				TE CRIMP SPECIFICATION			
TERMINAL NAME: .040 SERIES RECEPTACLE							
WIRE STRIP LENGTH				INSULATION DIAMETER RANGE			
3.20-3.80 mm [.126-.150 IN]				Ø1.10-1.40 mm [.043-.055 IN]			
TERMINAL APPLICATION SPECIFICATION (A)114-5162							
TERMINALS APPLIED ⑥							
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
(A) 175180-1	(A) 175180-2						

TERMINAL DATA: TE TERMINAL				TE CRIMP SPECIFICATION			
TERMINAL NAME: .040 SERIES TAB							
WIRE STRIP LENGTH				INSULATION DIAMETER RANGE			
3.20-3.80 mm [.126-.150 IN]				Ø1.00-1.70 mm [.039-.067 IN]			
TERMINAL APPLICATION SPECIFICATION (A)114-5162							
TERMINAL APPLICATION SPECIFICATION (B)114-5155							
TERMINALS APPLIED ⑥							
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
(B) 175206-1							

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.50mm2	1.02 +/- 0.05 [.040 +/- .002]	6.6
0.30mm2	0.92 +/- 0.05 [.036 +/- .002]	7.6

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.50mm2	1.02 +/- 0.05 [.040 +/- .002]	6.6
0.30mm2	0.92 +/- 0.05 [.036 +/- .002]	7.6



- 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 SEE TERMINAL APPLICATION SPEC FOR CORRECT STABILIZER CRIMP HEIGHT.
 - ⑥ TERMINAL LUBRICANT IS RECOMMENDED.
7. 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			
		REV	DATE	BY	CHKD
A	66	C	22OCT2018	MS	CT
		C1	17MAR2020	JWC	RK
		D	04AUG2021	FJ	TE
		E	19AUG2021	FJ	RK

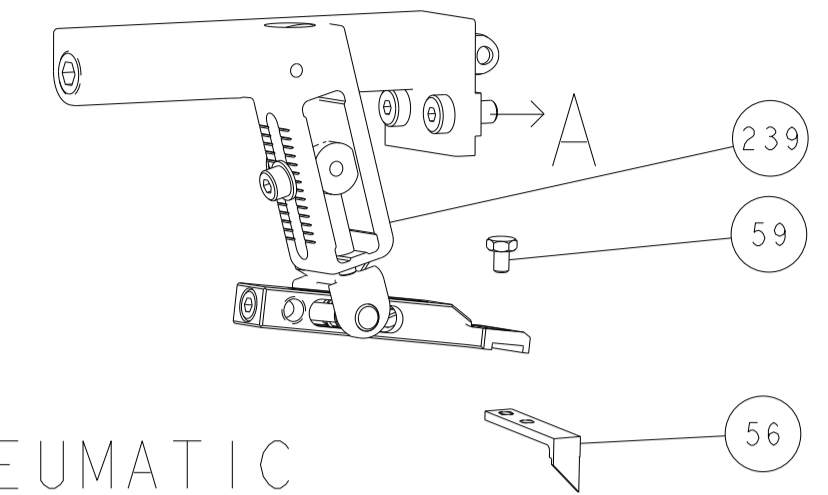
①	-	1	1	1	1	2119786-2	CRIMPER, STABILIZER "F" PREMIUM	258
	-	1	1	1	1	4-238011-0	BLOCK, CRIMPER SPACER	257
	-	1	1	1	1	2119348-8	SNAIL CAM, STABILIZER CRIMP ADJUSTMENT	256
	-	2	2	2	2	2079844-1	SPRING PLUNGER, M4	255
	-	1	1	1	1	2119347-1	KNOB, STABILIZER CRIMP ADJUSTMENT	254
	-	1	1	1	1	18032-1	SCR, SET, FLT PNT, M3 X 5.0	253
	-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248
	-	1	1	1	1	2119082-4	CAM, SNAIL, INSULATION ADJUSTMENT	244
	-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
③	-	1	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
⑥	-	1	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	455888-4	SPACER, CRIMPER	82
	-	1	1	1	1	5-547505-2	SPRING, COMPRESSION	77
	-	1	1	1	1	854769-4	HOLDER, INS	74
	-	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	21028-2	PIN, SLOTTED SPRING .062 X .250	58
	-	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	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	53
	-	1	1	1	1	5018030-1	NUT, HEX, REG, RoHS, M3	52
	-	1	1	1	1	811242-5	BUMPER, HOLD DOWN	51
	-	1	1	1	1	690753-2	SPACER, TONKER	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	1752356-3	SUPPORT, TERMINAL	34
	-	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
	-	2	2	2	2	3-2844962-0	SPACER, CYLINDRICAL, STRIP GUIDE	30
	-	1	1	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29
	-	1	1	1	1	2119797-2	SPACER, CRIMPER, SPECIAL	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
	-	2	2	2	2	1-18028-2	WASHER, FLAT, REG M4	20
	-	1	1	1	1	2119533-1	STRIPPER, SIDE FEED	19
①	-	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	1	1803095-1	FLOATING SHEAR, FRONT	9
①	1	2	2	1	1	3-1633918-1	ANVIL, COMBINATION	8
	-	-	-	-	-	-	-	7
	-	-	-	-	-	-	-	6
	-	1	1	1	1	2119790-1	SHEAR DEPRESSOR, STAB. CRIMP ADJ.	5
①	1	2	2	1	1	2119794-4	CRIMPER, INSUL F PREM, SPECIAL	3
	-	1	1	1	1	455888-7	SPACER, CRIMPER	2
①	1	2	2	1	1	3-456403-4	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)

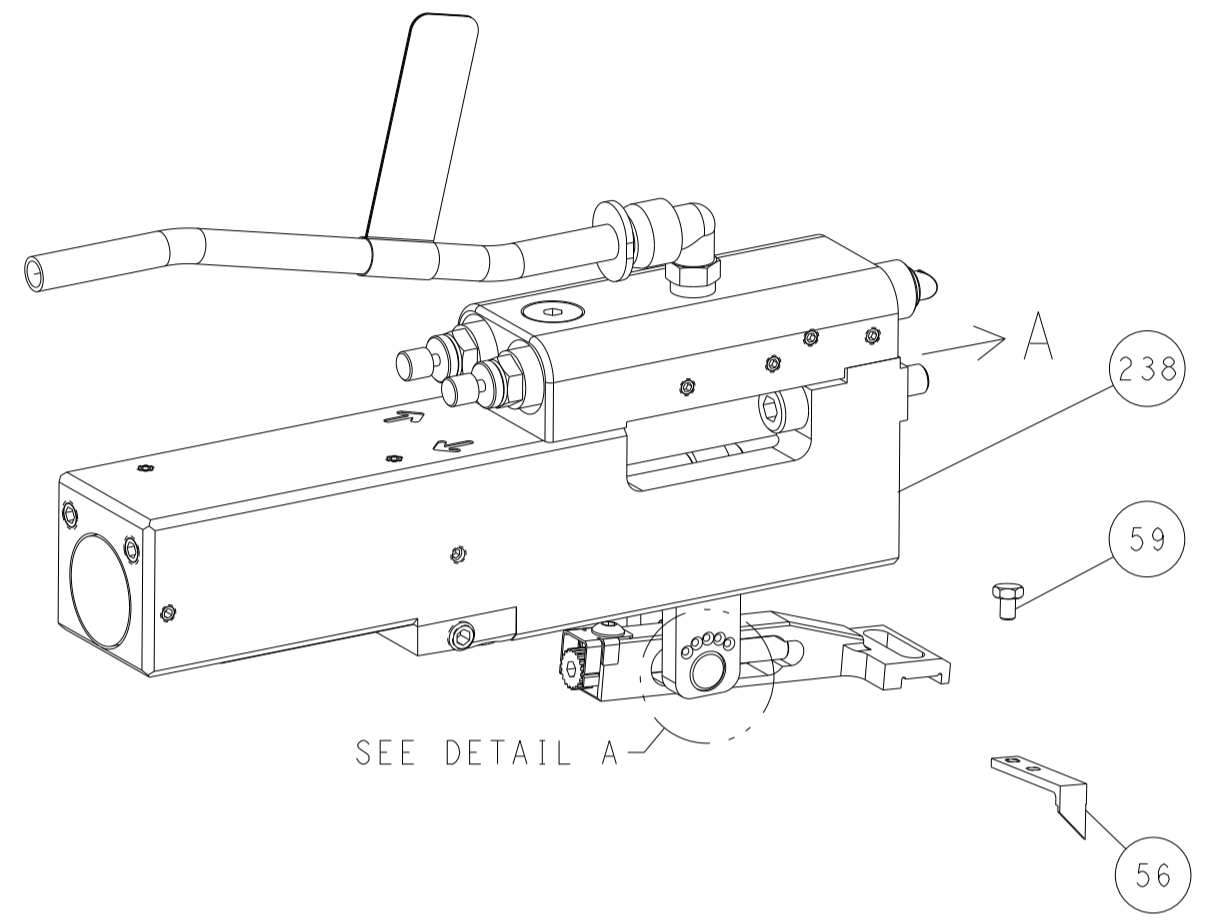
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MATERIAL:		FINISH:		APVD: T. ELBIN 22JUL2015	NAME: Ocean Side Feed Applicator
				WEIGHT:	SIZE: A1
				CAGE CODE: 00779	DRAWING NO: 2151471
				RESTRICTED TO:	SCALE: 1:2
				CUSTOMER ACCESSIBLE PRODUCTION DRAWING	SHEET 1 OF 4
				REV: E	

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

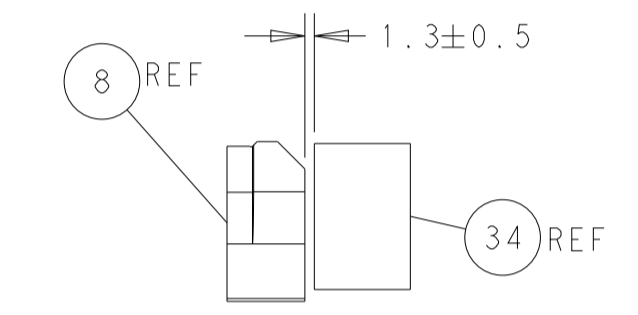
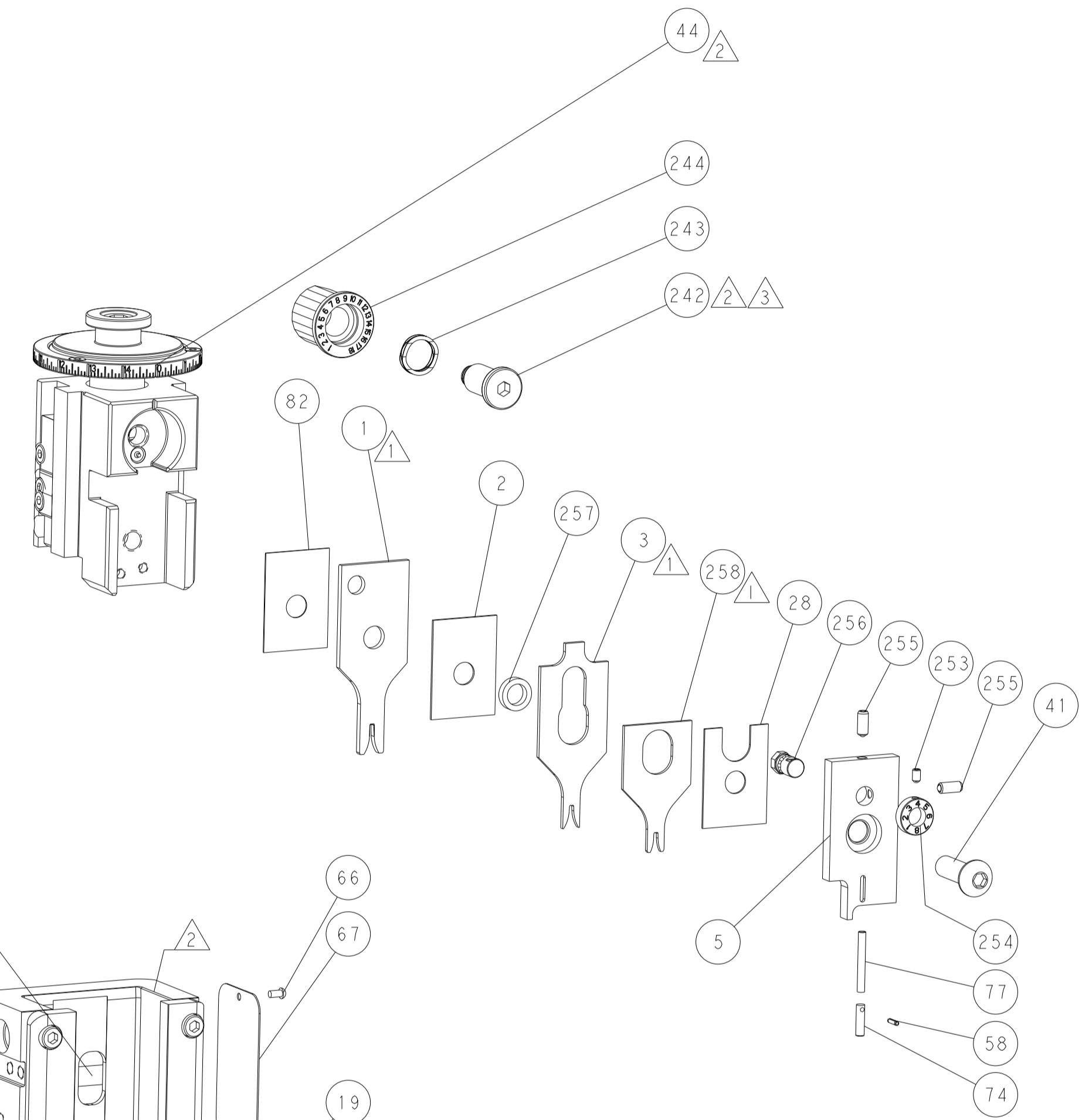
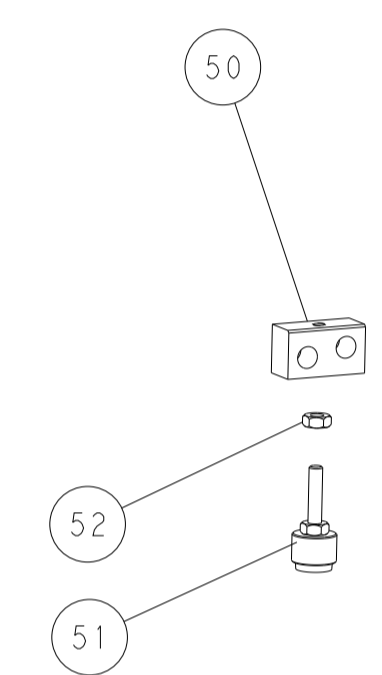
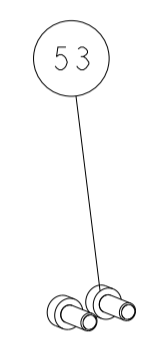
FEED TYPE MECHANICAL



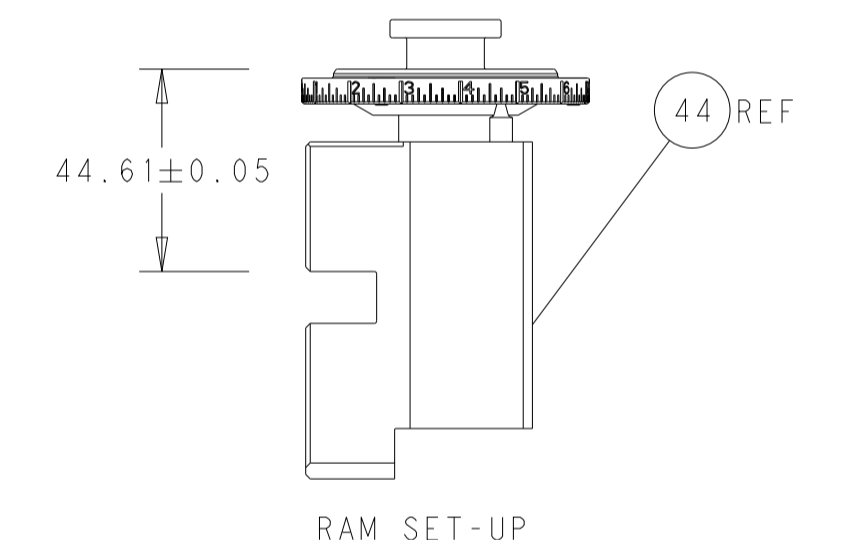
PNEUMATIC



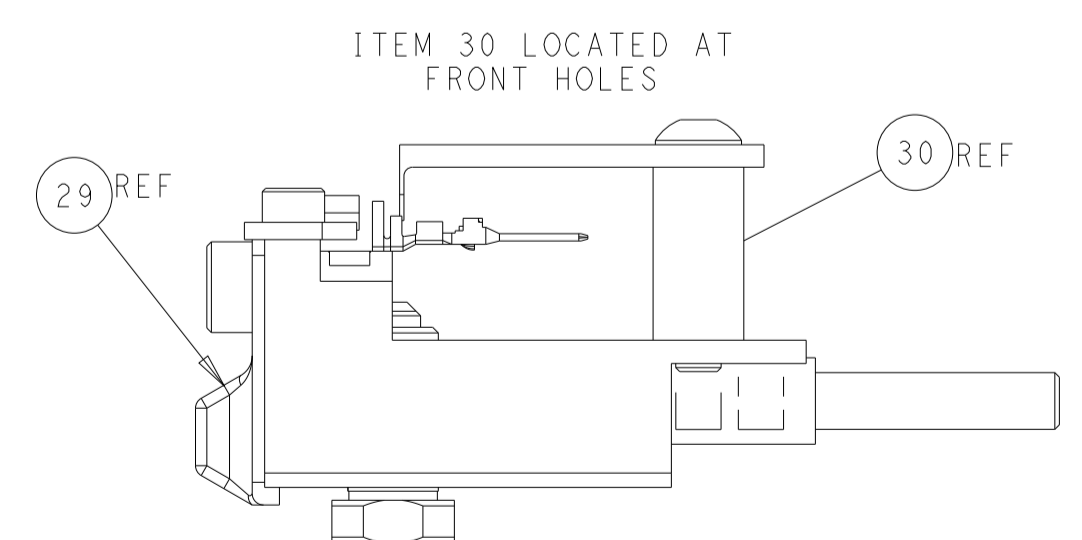
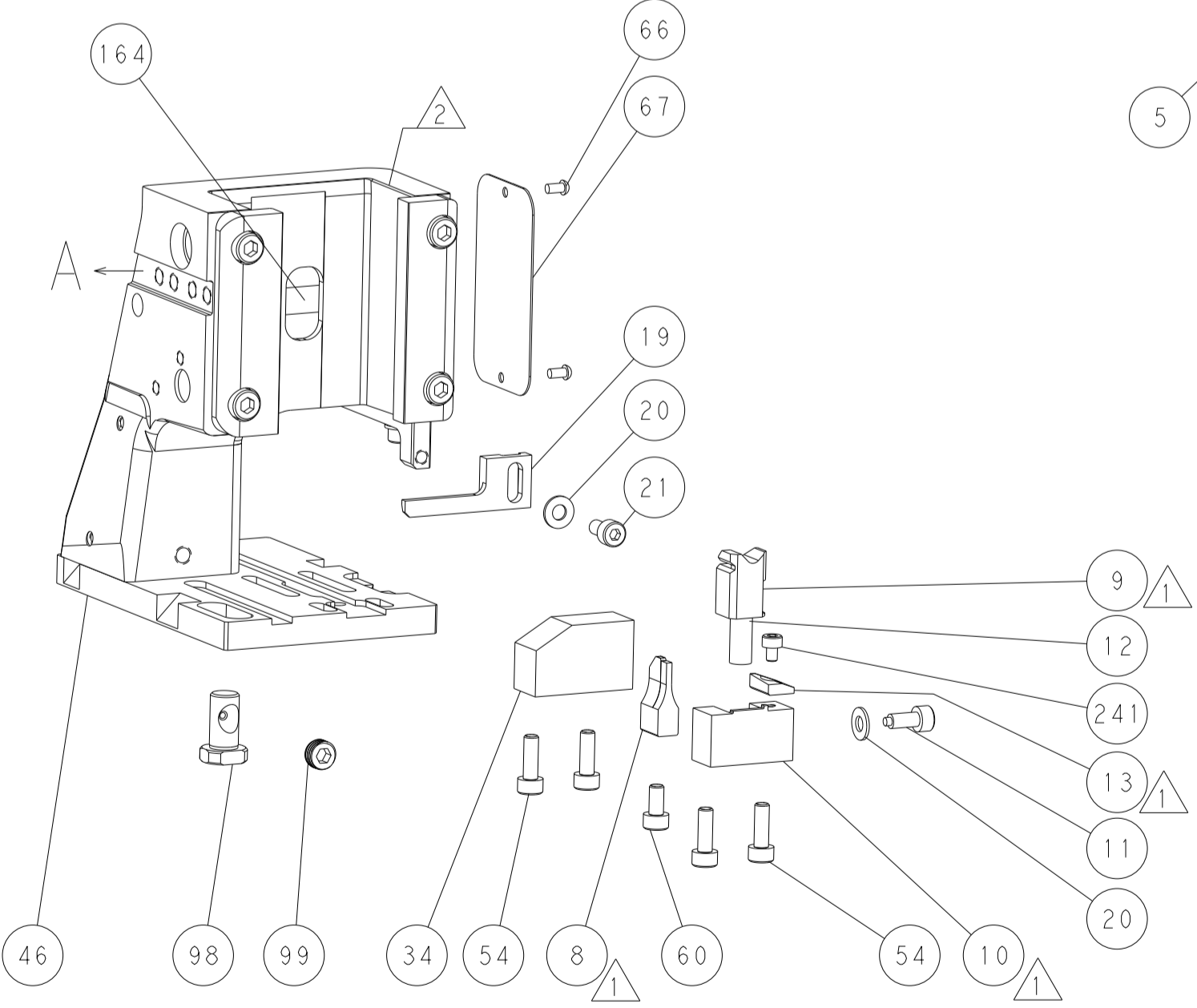
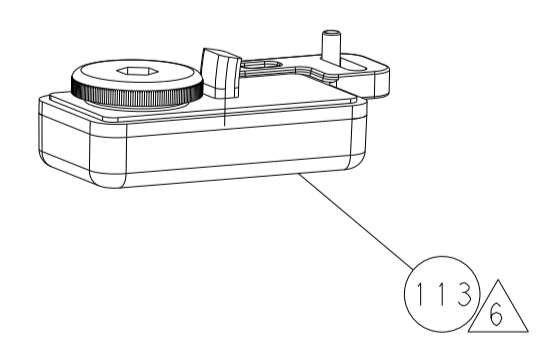
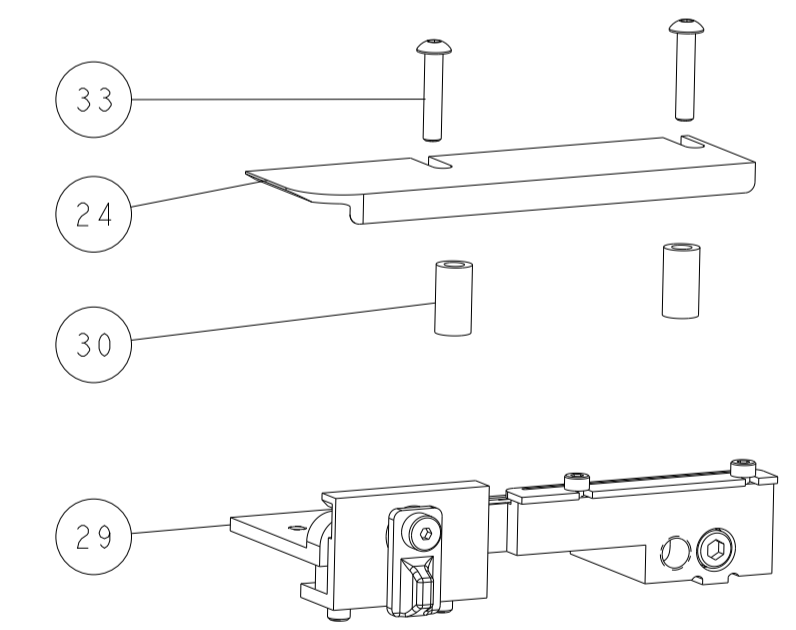
FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



TERMINAL SUPPORT LOCATION

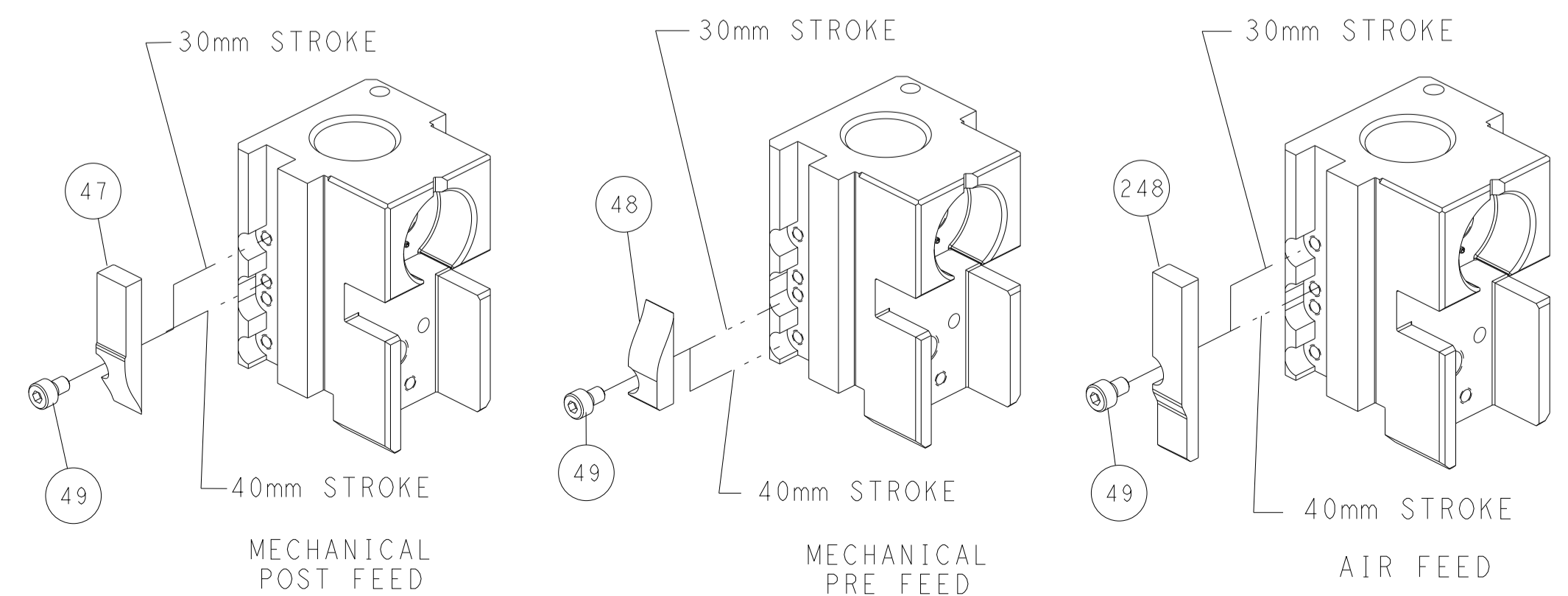


RAM SET-UP



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 B. WEAVER 22JUL2015 CHK T. ELBIN 22JUL2015 APVD T. ELBIN 22JUL2015 PRODUCT SPEC APPLICATION SPEC WEIGHT Customer Accessible Production Drawing		NAME Ocean Side Feed Applicator SIZE CAGE CODE DRAWING NO. RESTRICTED TO A1 00779 ©=2151471 SCALE 1:2 SHEET 2 OF 4 REV E	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2151471-1	E	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2151471-2	E	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151471-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
 INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.57 mm [.062]	F
STABILIZER	1.78 mm [.070]	F
INSUL	1.78 mm [.070]	F

APPLICATOR INSTRUCTIONS
 408-35042

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: .040 SERIES RECEPTACLE			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
3.20-3.80 mm [1.26-.150 IN]		∅1.10-1.40 mm [.043-.055 IN]	
TERMINAL APPLICATION SPECIFICATION	(A)114-5162	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
(A) 175180-1	(A) 175180-2		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: .040 SERIES TAB			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
3.20-3.80 mm [1.26-.150 IN]		∅1.00-1.70 mm [.039-.067 IN]	
TERMINAL APPLICATION SPECIFICATION	(A)114-5162	-	-
	(B)114-5155	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
(B) 175206-1			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.50mm2	1.02+/-0.05 [.040+/- .002]	6.6
0.30mm2	0.92+/-0.05 [.036+/- .002]	7.6

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.50mm2	1.02+/-0.05 [.040+/- .002]	6.6
0.30mm2	0.92+/-0.05 [.036+/- .002]	7.6



- 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.
- SEE TERMINAL APPLICATION SPEC FOR CORRECT STABILIZER CRIMP HEIGHT.
- TERMINAL LUBRICANT IS RECOMMENDED.
- 7. 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	2119786-2	CRIMPER, STABILIZER "F" PREMIUM	258
-	1	1	4-238011-0	BLOCK, CRIMPER SPACER	257	
-	1	1	2119348-8	SNAIL CAM, STABILIZER CRIMP ADJUSTMENT	256	
-	2	2	2079844-1	SPRING PLUNGER, M4	255	
-	1	1	2119347-1	KNOB, STABILIZER CRIMP ADJUSTMENT	254	
-	1	1	18032-1	SCR, SET, FLT PNT, M3 X 5.0	253	
-	1	1	2119082-4	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	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113
-	1	1	2844908-1	SCREW, LOCKING	99	
-	1	1	2844907-1	POST, LOCKING	98	
-	1	1	455888-4	SPACER, CRIMPER	82	
-	1	1	5-547505-2	SPRING, COMPRESSION	77	
-	1	1	854769-4	HOLDER, INS	74	
-	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	21028-2	PIN, SLOTTED SPRING .062 X .250	58	
-	1	1	1338685-1	PAWL, FEED	56	
-	2	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	53	
-	1	1	5018030-1	NUT, HEX, REG, RoHS, M3	52	
-	1	1	811242-5	BUMPER, HOLD DOWN	51	
-	1	1	690753-2	SPACER, TONKER	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	1752356-3	SUPPORT, TERMINAL	34	
-	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33	
-	2	2	3-2844962-0	SPACER, CYLINDRICAL, STRIP GUIDE	30	
-	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29	
-	1	1	2119797-2	SPACER, CRIMPER, SPECIAL	28	
-	1	1	1320928-2	STRIP GUIDE	24	
-	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21	
-	2	2	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	3-1633918-1	ANVIL, COMBINATION	8
-	-	-	-	-	7	
-	-	-	-	-	6	
-	1	1	2119790-1	SHEAR DEPRESSOR, STAB. CRIMP ADJ.	5	
	1	1	1	2119794-4	CRIMPER, INSUL F PREM, SPECIAL	3
-	1	1	1	455888-7	SPACER, CRIMPER	2
	1	1	1	3-456403-4	CRIMPER, WIRE PREMIUM	1

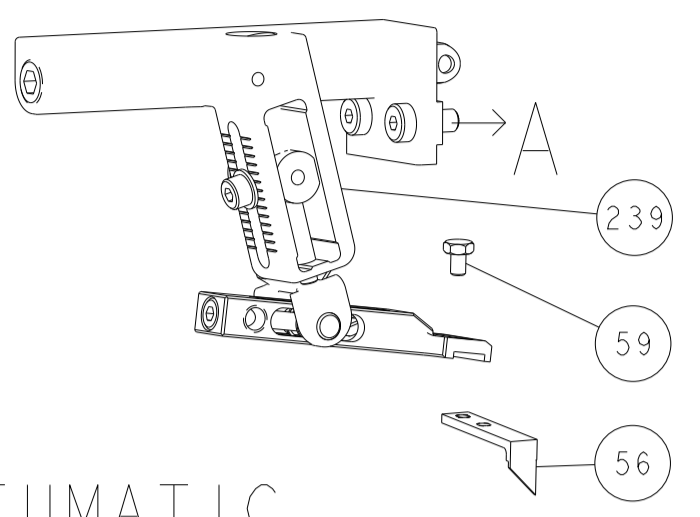
PACIFIC VERSION
 Shown on sheets 3 of 4 & 4 of 4
 (Atlantic version shown on sheets 1 of 4 & 2 of 4)

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

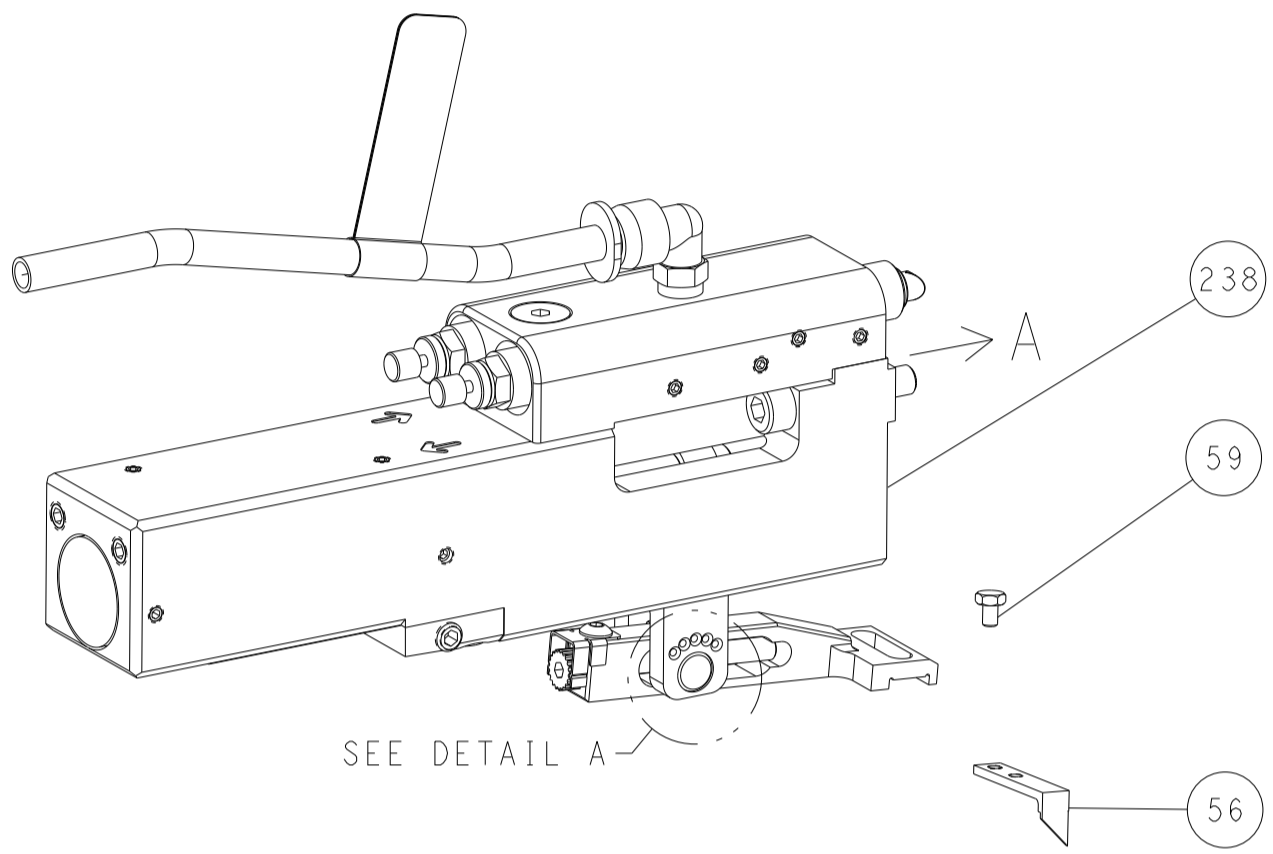
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CHK	T. ELBIN	22 JUL 2015
APVD	T. ELBIN	22 JUL 2015
PRODUCT SPEC		
APPLICATION SPEC		
WEIGHT		
CAGE CODE	00779	DRAWING NO
SCALE	1:2	SHEET 3 OF 4
REV	E	

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

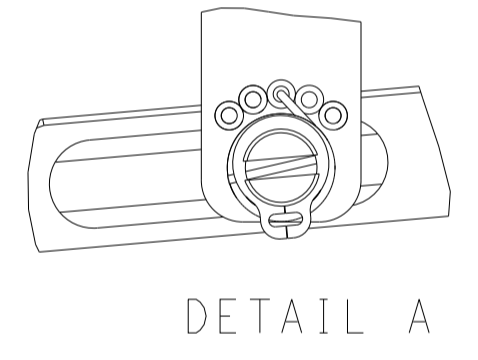
FEED TYPE MECHANICAL



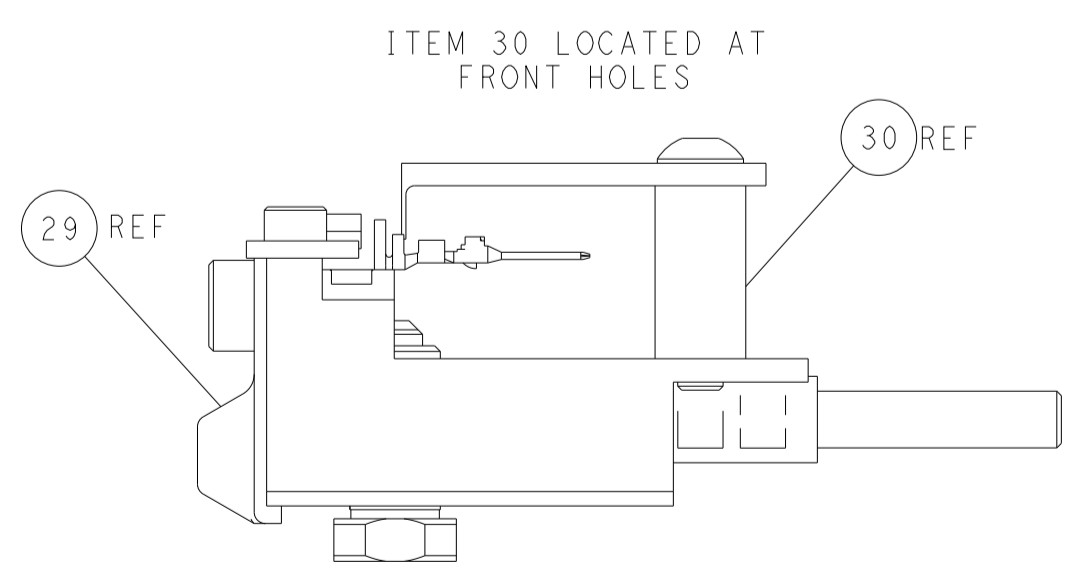
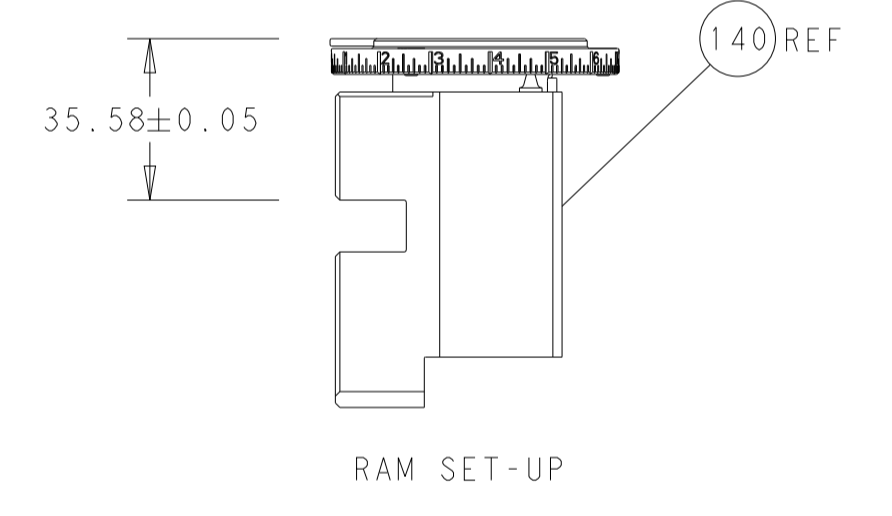
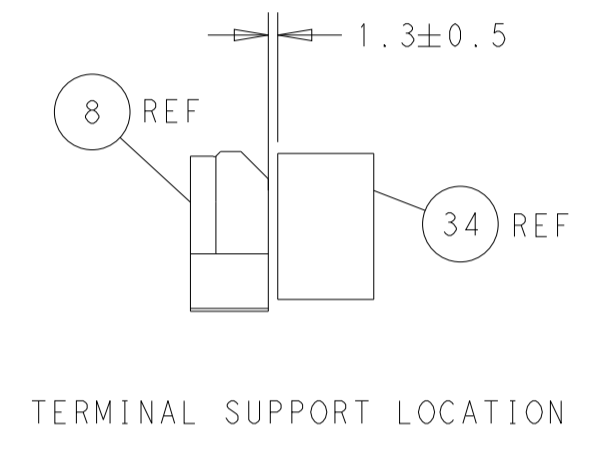
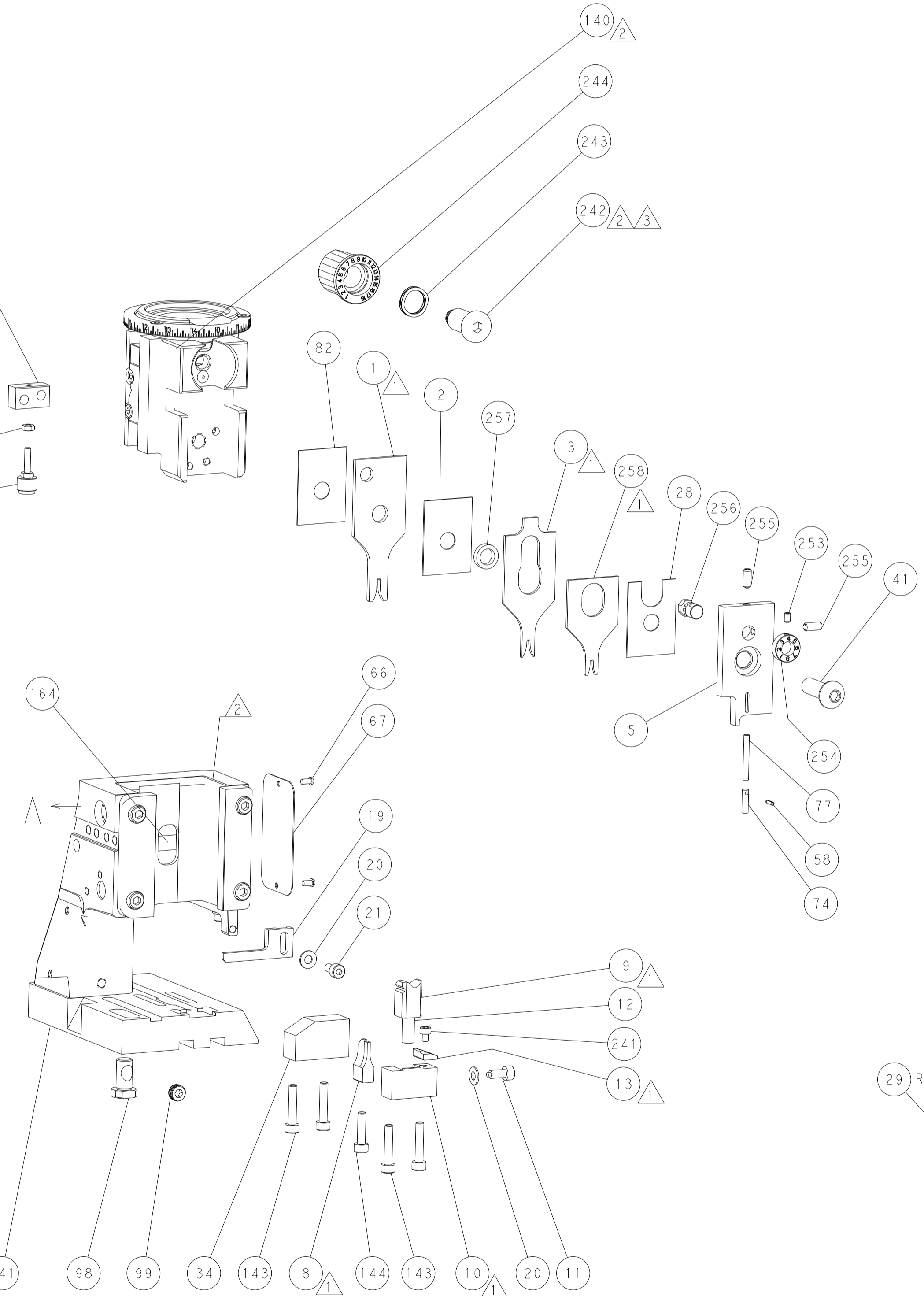
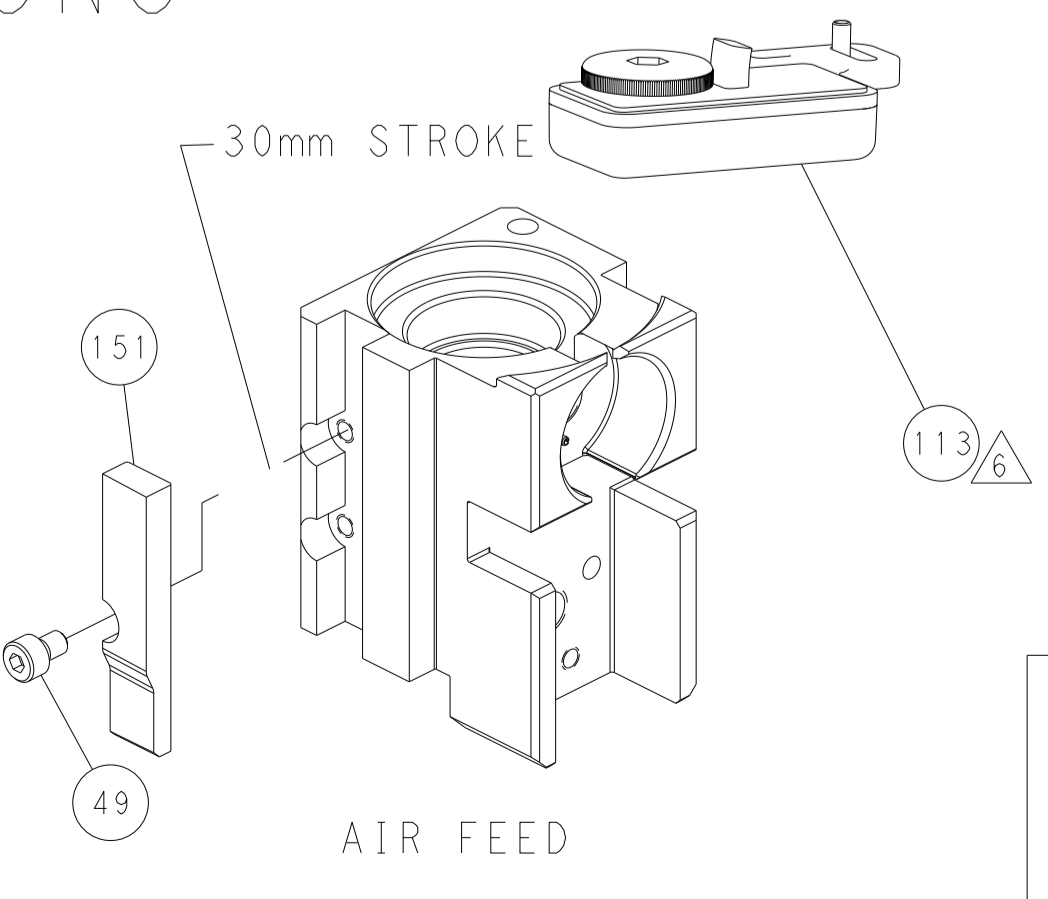
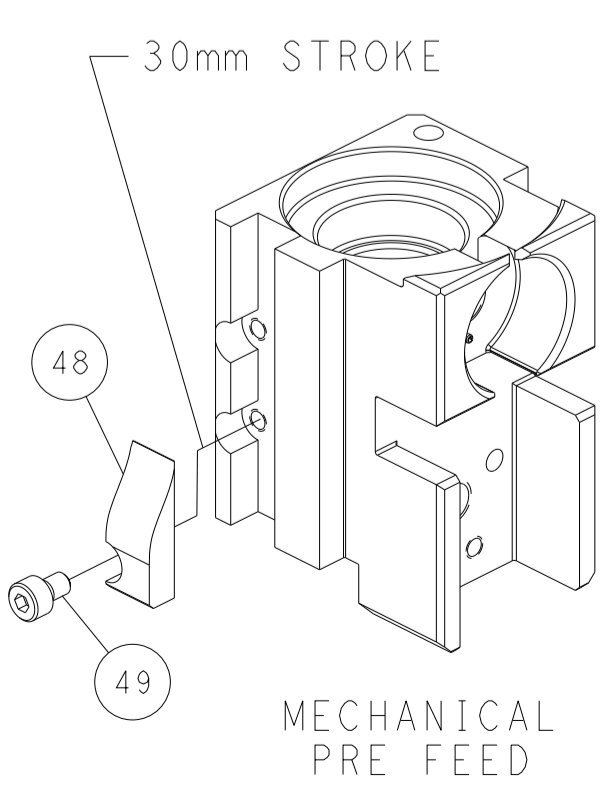
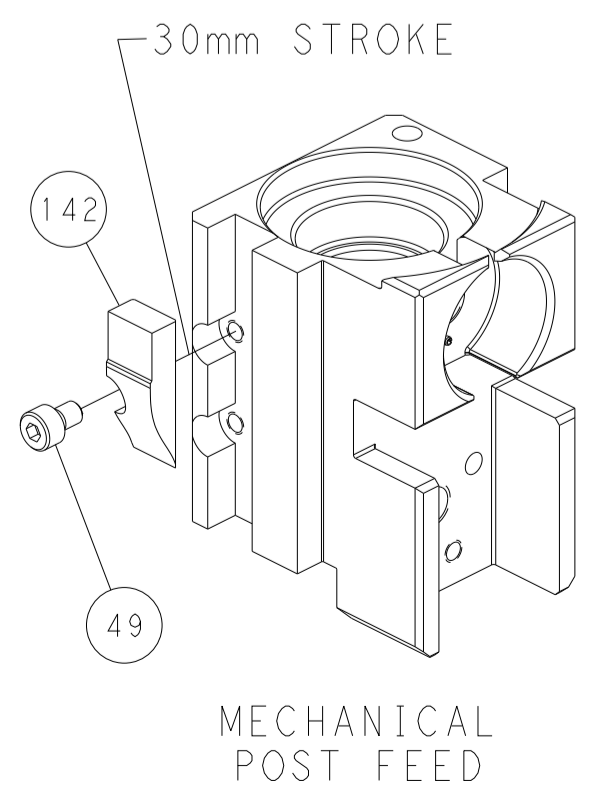
PNEUMATIC



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)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		OWN		TE Connectivity	
mm	0 PLC	±	0.05	B. WEAVER	22JUL2015	Harrisburg, PA 17105-3608	
	1 PLC	±	0.10	CHE T. ELBIN	22JUL2015	NAME	
	2 PLC	±	0.15	APVD	22JUL2015	Ocean Side Feed	
	3 PLC	±	0.20	T. ELBIN	22JUL2015	Applicator	
	4 PLC	±	0.25	PRODUCT SPEC		-	
	ANGLES	±	0.10	APPLICATION SPEC		-	
MATERIAL	FINISH			WEIGHT		SIZE	CAGE CODE
						A1	00779
Customer Accessible Production Drawing		SCALE		SHEET		REV	
		1:2		4 of 4		E	

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