



**1. INTRODUCTION**

The redesigned Power Triple Lock (PTL) product requires a new anvil to properly crimp the updated terminals. For some wire ranges, an additional modification is required to the spacer located between the wire and insulation crimper. On other wire ranges, an updated insulation crimper is required. This guideline details which terminals and applicators need updated tooling and the procedure for replacing these three components in a TE Connectivity Ocean Applicator.

**2. REFERENCE MATERIAL**

**2.1. Revision Summary**

**Revision C:**

- 1. Added table detailing replacement anvil part number instead of referring to applicator product drawing.
- 2. Minor formatting edits.

**Revision B:**

- 1. Added section 3.3 specifying crimper changes.
- 2. Added section 6 detailing crimper change procedure.

**2.2. Detailed Instructional Material:**

[408-10389](#) Ocean Side-Feed Applicators 2151741-1, 2151742-1, 2151743-1, 2151744-1, 2151745-1, and 2151746-1

**3. APPLICATORS**

**3.1. Anvil Changes**

All PTL applicators will require a new, modified anvil. Table 1 details the replacement anvil part number for each applicator. The anvil replacement procedure is detailed further below.

**Table 1:** Replacement anvil part number for each terminal and applicator.

Tab Part Number	Receptacle Part Number	Applicator Base Number	Replacement Anvil Part Number
1971780	1971779	2151741	1803079-9
1971782	1971781	2151742	1-1803079-2
1971784	1971783	2151743	1-1803079-3
1971786	1971785	2151744	1-1803079-0
1971788	1971787	2151745	1-1803079-1
1971238	1971237	2151746	1-1803079-4
2238066	2238067	2151743	1-1803079-3

### 3.2. Spacer Changes

Some PTL terminals require replacement spacers. Table 2 details the terminals that require the replacement spacers in their applicator, the applicator used to crimp those terminals, and the applicable replacement spacer number.

**Table 2:** Terminals which require replacement spacers, associated applicator, and replacement spacer number for that applicator

Tab Part Number	Receptacle Part Number	Applicator Base Number	Replacement Spacer Part Number
1971784	1971783	2151743	455888-2
2238066	2238067	2151743	455888-2



**NOTE**

- a. If your part number or applicator is not listed here, it does not need a replacement spacer.

### 3.3. Crimper Changes

Some PTL terminals require a new, modified crimper. Table 3 details the terminals that require the updated crimper in their applicator, the applicator used to crimp those terminals, and the applicable replacement crimper number.

**Table 3:** Wire ranges/terminals which require updated crimpers, associated applicator, and updated crimper number for that applicator.

Tab Part Number	Receptacle Part Number	Applicator Base Number	Replacement Insulation Crimper Part Number
1971780	1971779	2151741	8-1803187-6
1971782	1971781	2151742	TBD
1971786	1971785	2151744	8-1803187-7
1971788	1971787	2151745	TBD
1971237	1971238	2151746	TBD

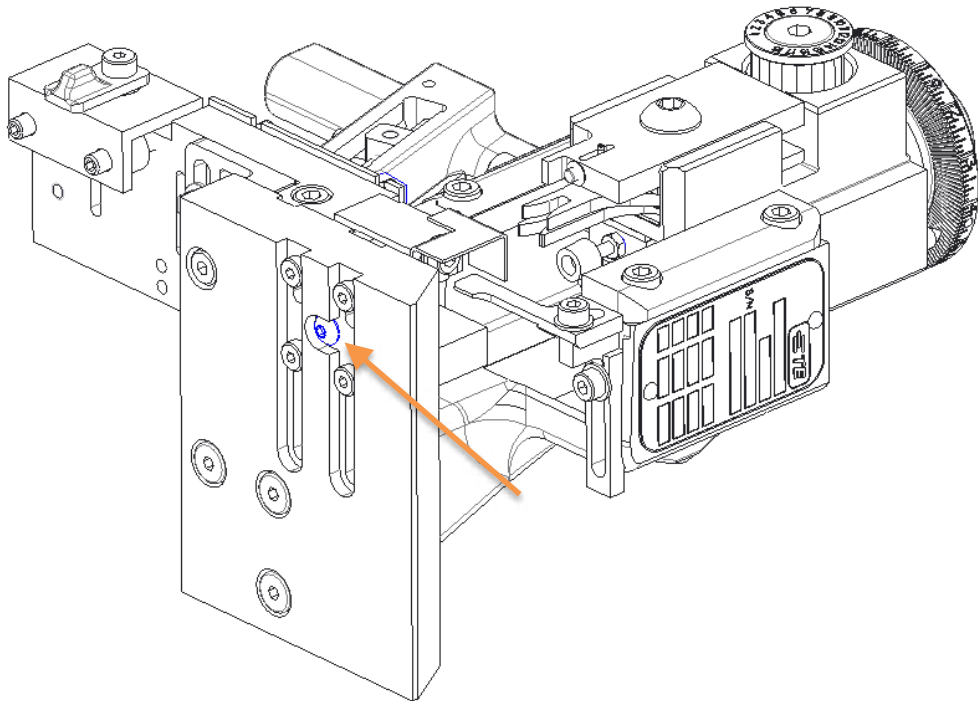


**NOTE**

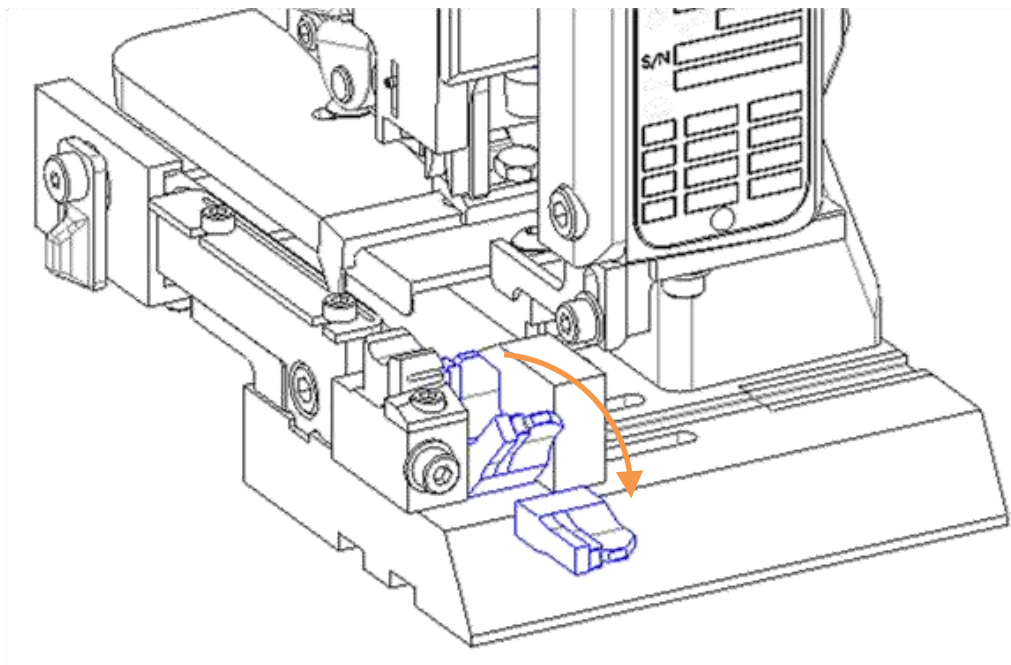
- a. If your part number or applicator is not listed here, it does not need a replacement spacer.

#### 4. ANVIL REPLACEMENT PROCEDURE

1. From the bottom of the base plate, remove the screw that holds the anvil to the base plate.



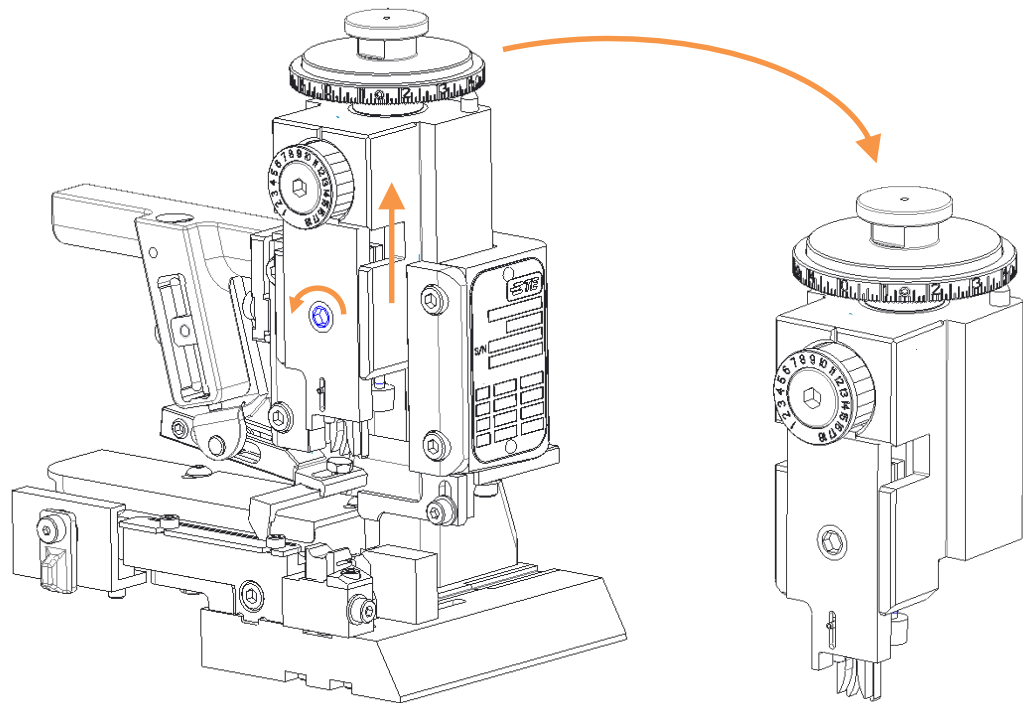
2. Remove the anvil from the groove in the top of the base plate.



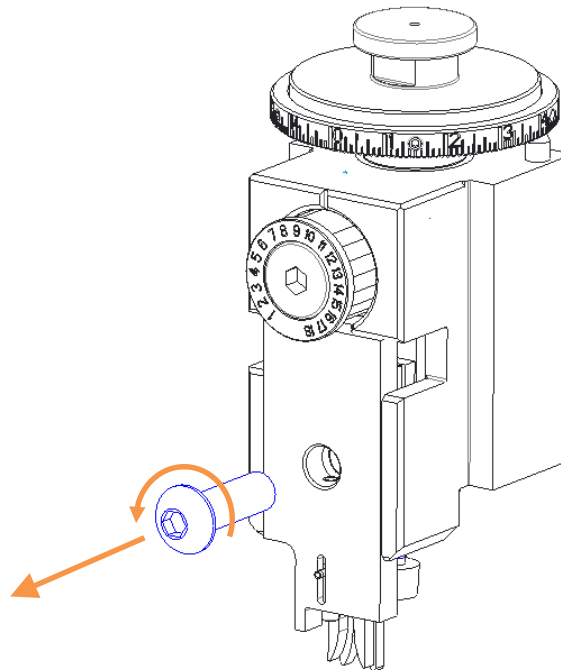
3. Install the modified anvil using the reverse of the installation procedure.

## 5. SPACER REPLACEMENT PROCEDURE

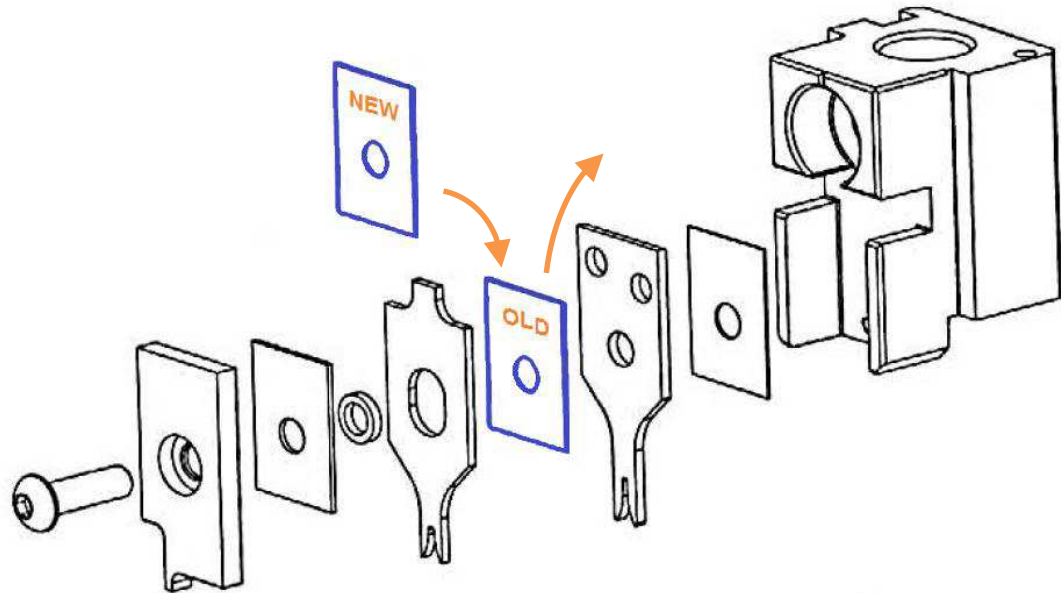
1. Loosen the crimper bolt slightly and remove the ram assembly from applicator by pulling upward. It may be necessary to move the feed pawl forward to release the ram assembly.



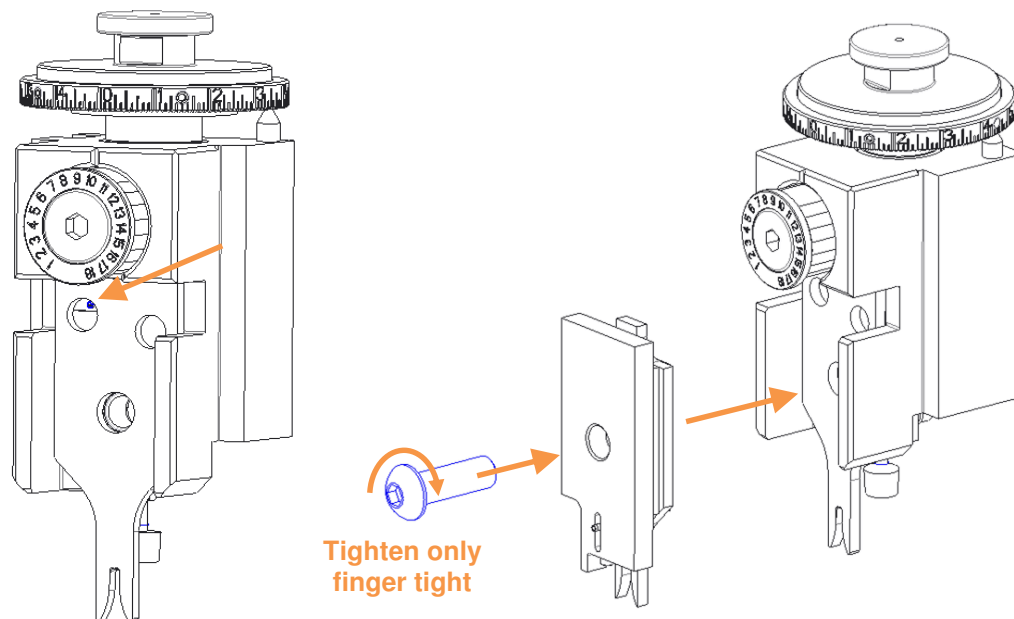
2. Remove the crimper bolt that holds the front shear depressor, front shear depressor spacer, tubular spacer, insulation crimper, crimper spacer, and wire crimper in place on the ram assembly. Note position of parts for re-installation.



- Remove the spacer located between the wire crimper and insulation crimper and replace it with the new, thinner spacer. See Table 2 for new spacer part number.

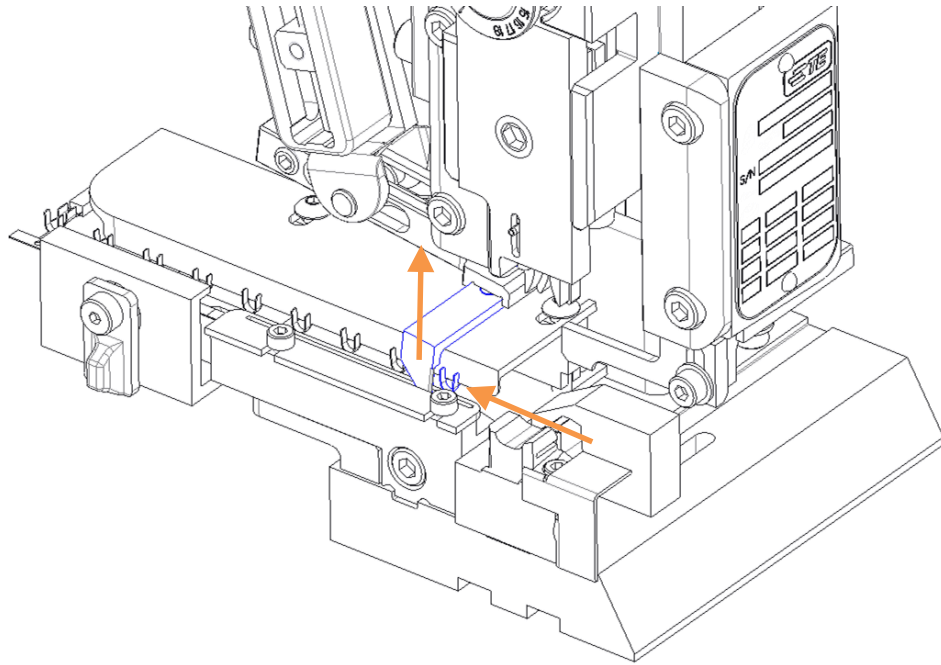


- Re-install the parts using the reverse of the installation procedure. The upper end of the wire crimper must be up against shoulder of the ram assembly and the top hole on the crimper must mate with the roll pin in the ram assembly. Tighten the crimper bolt only finger-tight.

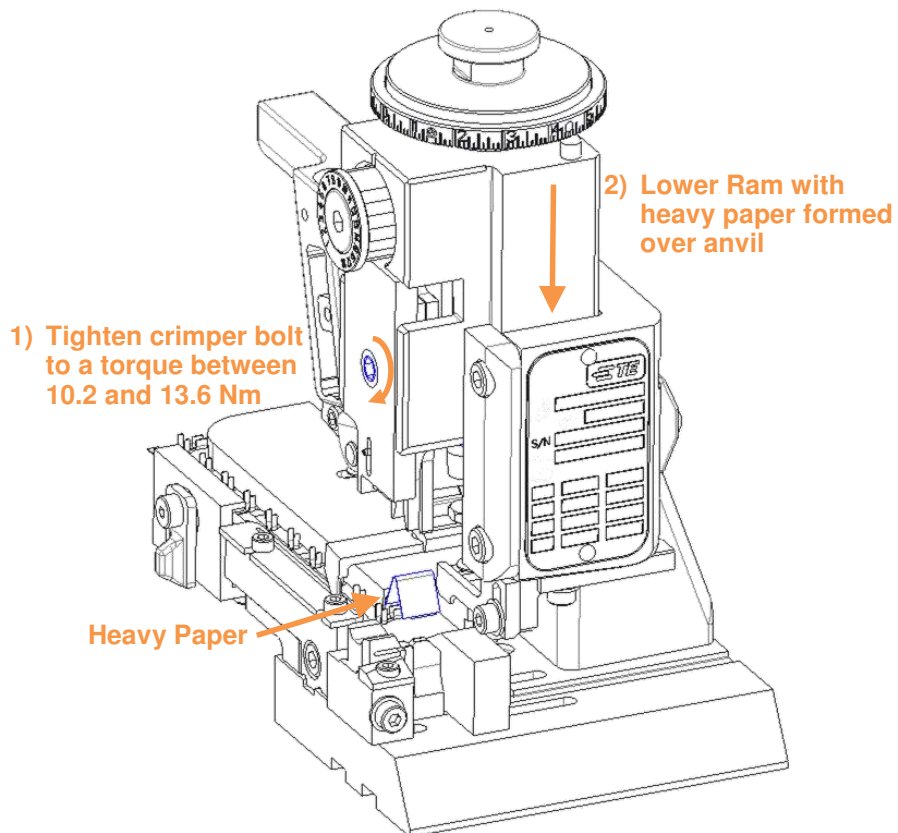


- Put the ram assembly back into the applicator, and install the applicator in machine.

- Lift the feed pawl and pull the terminal strip back until the lead terminal is between the strip guides.

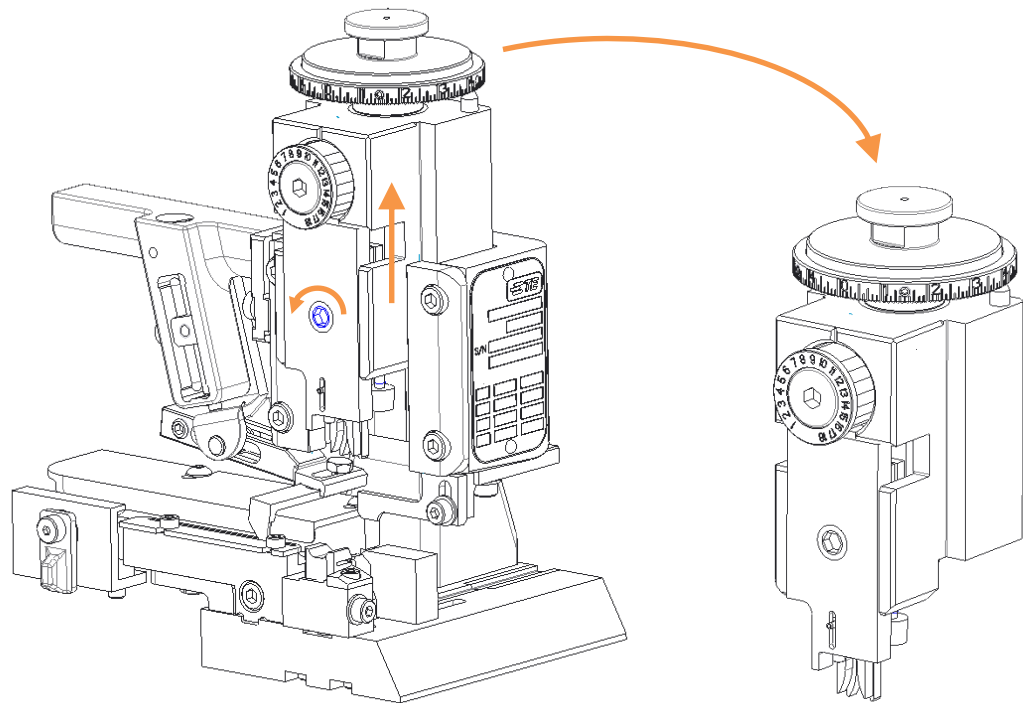


- Form a piece of heavy paper over the anvil, then slowly hand-cycle the machine while watching the alignment of the crimpers with the anvil. When the ram assembly has reached the bottom of the stroke, carefully tighten the crimper bolt to a torque between 10.2 and 13.6 Nm [8 and 10 lb]. The crimper must move freely over the anvil after the heavy paper is removed.

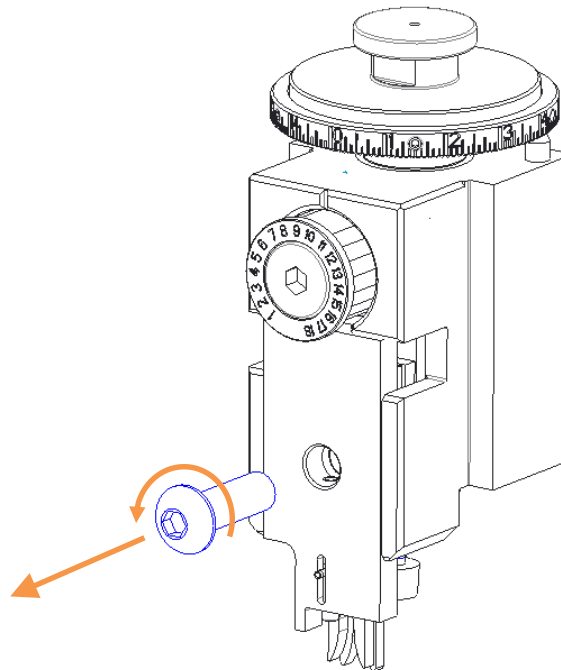


## 6. INSULATION CRIMPER REPLACEMENT PROCEDURE

1. Loosen the crimper bolt slightly and remove the ram assembly from applicator by pulling upward. It may be necessary to move the feed pawl forward to release the ram assembly.

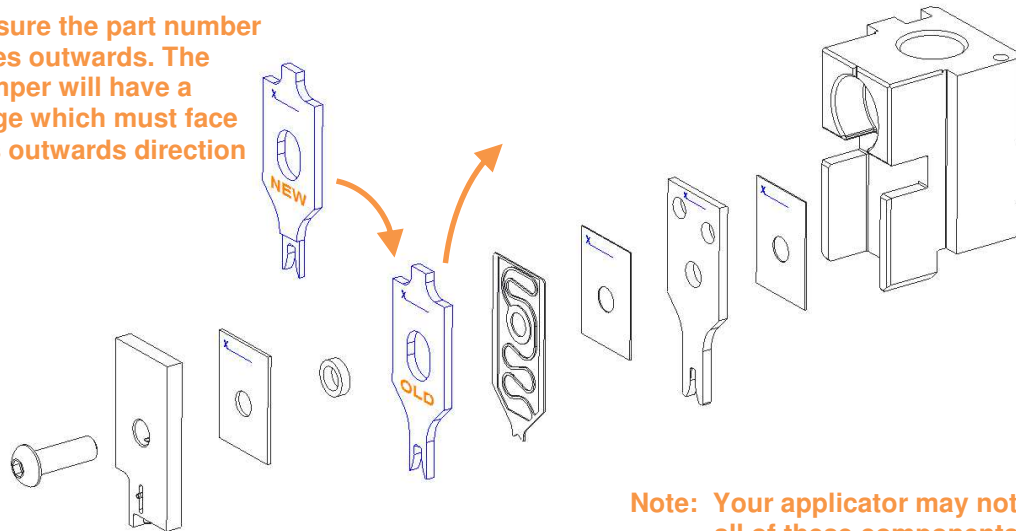


2. Remove the crimper bolt that holds the front shear depressor, front shear depressor spacer, tubular spacer, insulation crimper, crimper spacer, and wire crimper in place on the ram assembly. Note position of parts for re-installation.

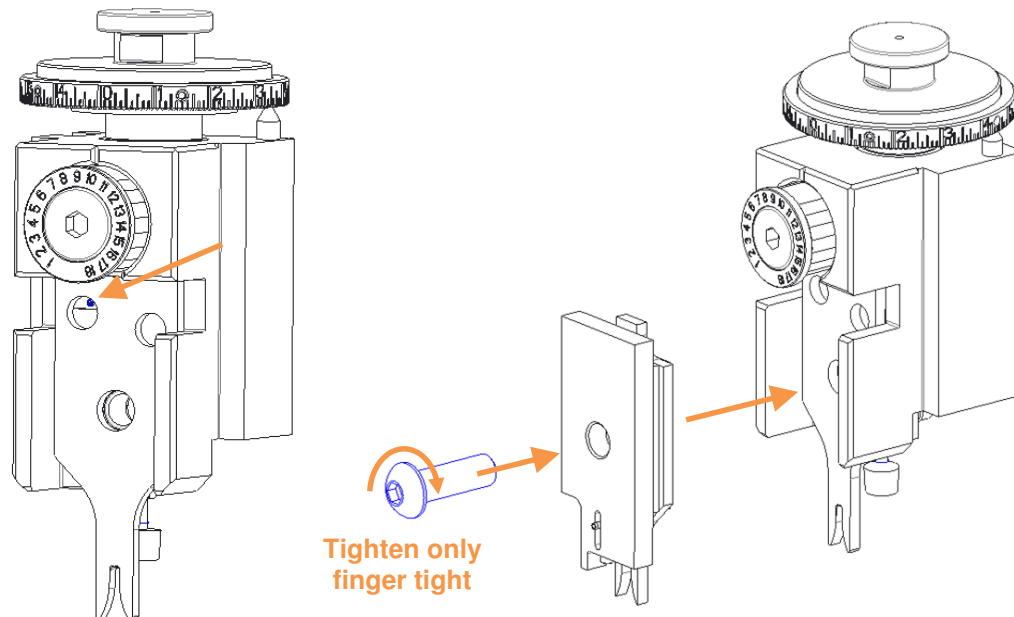


- Remove the insulation crimper and replace it with the new, modified crimper. The new crimper has a thinner crimping section than the old crimper. Be sure to orient the crimper so that the part number on the crimper is facing outwards. See Table 2 for new spacer part number.

**Be sure the part number faces outwards. The crimper will have a ledge which must face this outwards direction**



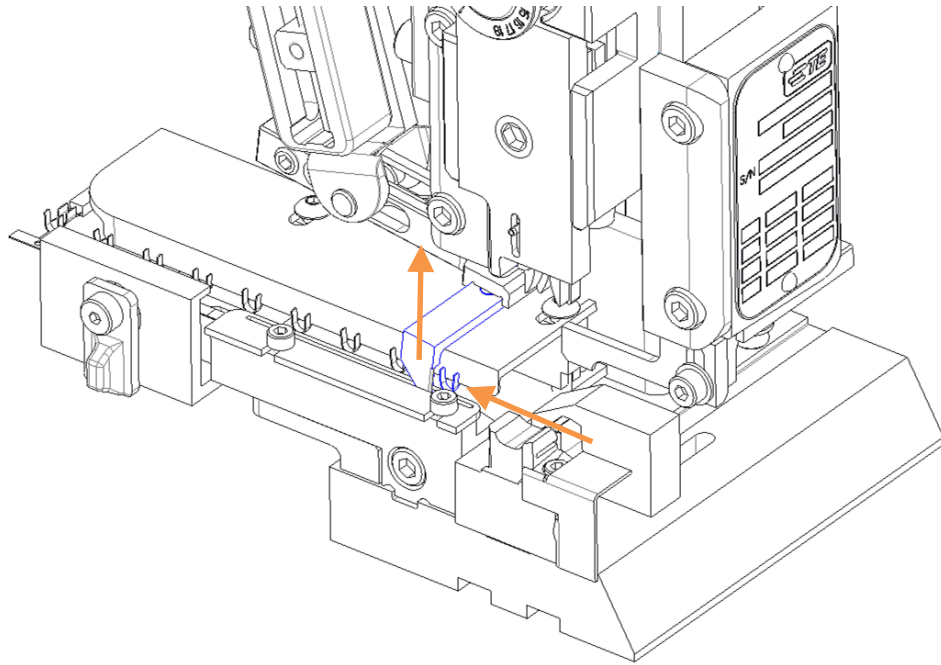
- Re-install the parts using the reverse of the installation procedure. The upper end of the wire crimper must be up against shoulder of the ram assembly and the top hole on the crimper must mate with the roll pin in the ram assembly. Tighten the crimper bolt only finger-tight.



- Put the ram assembly back into the applicator, and install the applicator in machine.



6. Lift the feed pawl and pull the terminal strip back until the lead terminal is between the strip guides.



7. Form a piece of heavy paper over the anvil, then slowly hand-cycle the machine while watching the alignment of the crimpers with the anvil. When the ram assembly has reached the bottom of the stroke, carefully tighten the crimper bolt to a torque between 10.2 and 13.6 Nm [8 and 10 ft-lb]. The crimper must move freely over the anvil after the heavy paper is removed.

