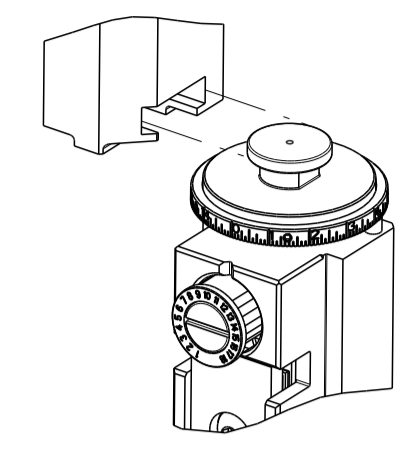


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151392-1	H	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2151392-2	H	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
5-2151392-1	H	SEAL STRIPPER CRIMPER TERMINATING UNIT	MECHANICAL
5-2151392-2	H	SEAL STRIPPER CRIMPER TERMINATING UNIT	PNEUMATIC
7-2151392-1	H	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2151392-2	H	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2151392-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA

CRIMP	SIZE	TYPE
WIRE	2.03 mm [.080]	F
INSUL	4.06 mm [.160]	O

APPLICATOR INSTRUCTIONS 408-35042

TERMINAL DATA: BOSCH TERMINAL BOSCH CRIMP SPECIFICATION

TERMINAL NAME: TERMINAL

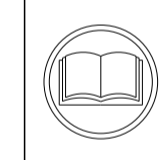
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE
3.70-4.50 mm [.146-.177 IN]	∅1.20-2.10 mm [.047-.083 IN]

TERMINAL APPLICATION SPECIFICATION 1 928 F00 025-EN

TERMINALS APPLIED

TE TERMINAL	BOSCH TERMINAL	TE SEAL	BOSCH SEAL	SEAL INSULATION DIAMETER RANGE
1572253-1	1928498054	1572254-1	1928300599	-
2320786-1	1928498056	828904-1	1-928-300-559	∅1.2-2.1
1572253-3	1928498058	828904-2		∅1.2-2.1
		828904-3		∅1.2-2.1
		1572276-1		-

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.00mm ²	1.36+/-0.05 [.053+/- .002]	4.6
0.75mm ² or 18AWG	1.27+/-0.05 [.050+/- .002]	5.3
0.50mm ²	1.18+/-0.05 [.046+/- .002]	6.8



- 1 RECOMMENDED SPARE PARTS
- 2 REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- 3 APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 180. 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 UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- 7 TERMINAL LUBRICANT IS RECOMMENDED.

***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
		G		ECR-21-006398	21JUN2021	MEH	TE
		H		ECR-22-132838	17MAR2022	FJ	TE
		H1		ECR-23-174481	06MAY2023	FZ	JAH
		H2		ECR-23-184483	17AUG2023	JWC	JH

-	-	-	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	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
3	-	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	-	-	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
3	-	-	1	1	-	-	1-1752354-9	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	1-18028-2	WASHER, FLAT, REG M4	119
7	-	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	455888-8	SPACER, CRIMPER	82
-	1	1	1	1	1	1	1803607-3	DOCUMENTATION PACKAGE	71
-	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
5	-	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	1803382-6	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	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	1-1752356-7	SUPPORT, TERMINAL	34
-	2	2	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	2	2	2	2	2-2844962-3	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	1	1	1	1	2844992-2	ASSEMBLY, STRIP GUIDE	29
-	1	1	1	1	1	1	455888-4	SPACER, CRIMPER	28
-	1	1	1	1	1	1	1320928-1	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	1	2119806-1	INSERT, SHEAR	13
-	1	1	1	1	1	1	3-22280-3	SPRING, COMPRESSION	12
-	1	1	1	1	1	1	1-356885-4	STOP, SHEAR	11
1	-	1	1	1	1	1	2119805-1	SHEAR HOLDER, FRONT	10
1	-	1	1	1	1	1	318707-1	FLOATING SHEAR, FRONT	9
1	2	2	1	1	1	1	2-1333204-6	ANVIL, COMBINATION	8
-	1	1	1	1	1	1	3-240641-3	SPACER	7
-	-	-	-	-	-	-	-	-	6
-	1	1	1	1	1	1	2119781-1	DEPRESSOR, SHEAR	5
-	1	1	1	1	1	1	3-238011-3	BLOCK, CRIMPER SPACER	4
1	2	2	1	1	1	1	3-2119784-1	CRIMPER, INSULATION O PREMIUM	3
-	1	1	1	1	1	1	455888-7	SPACER, CRIMPER	2
1	2	2	1	1	1	1	1-456405-6	CRIMPER, WIRE PREMIUM	1

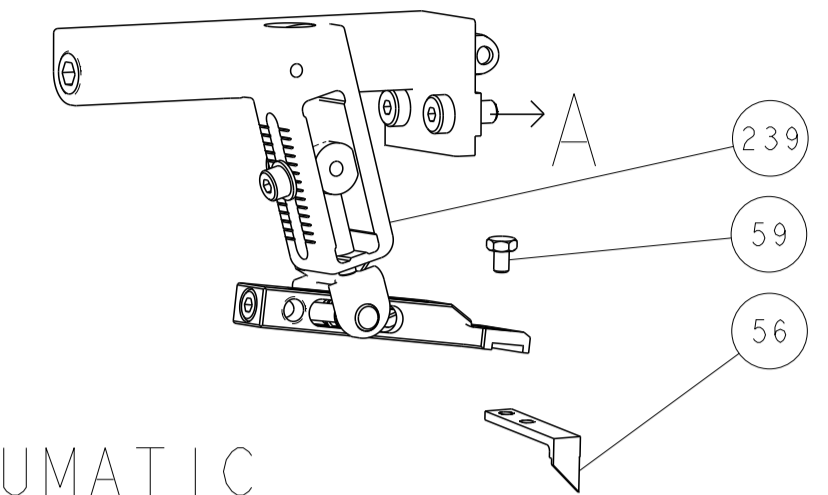
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		OWN: Y. YIN 02DEC2011		CHK: G. BAILEY 02DEC2011		APVD: S. XI 02DEC2011		NAME: Ocean Side Feed Applicator	
mm		0 PLC ±		SIZE: A1		CAGE CODE: 00779		DRAWING NO: C=2151392		RESTRICTED TO: -	
MATERIAL: -		FINISH: -		WEIGHT: -		SCALE: 1:2		SHEET: 1 of 4		REV: H2	

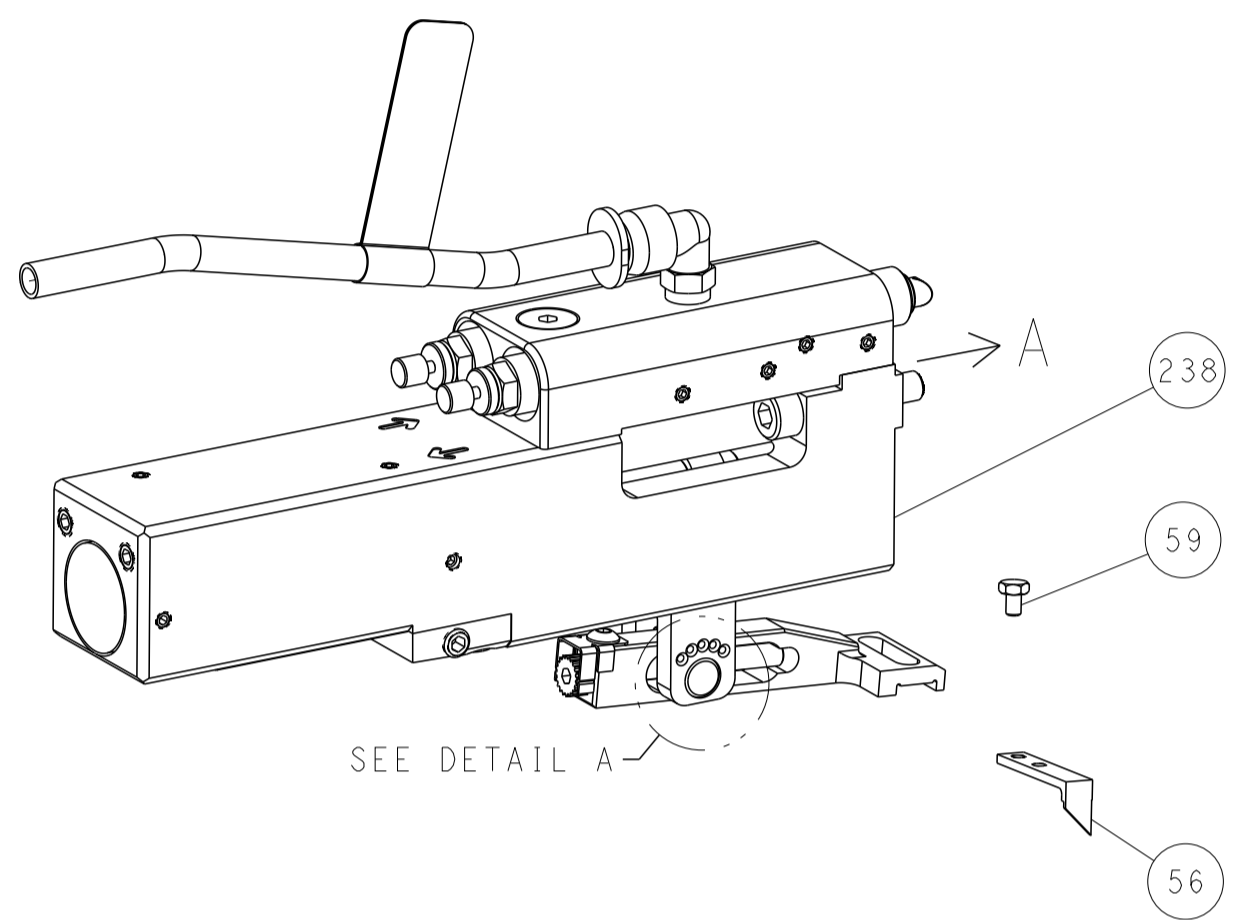
Customer Accessible Production Drawing

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

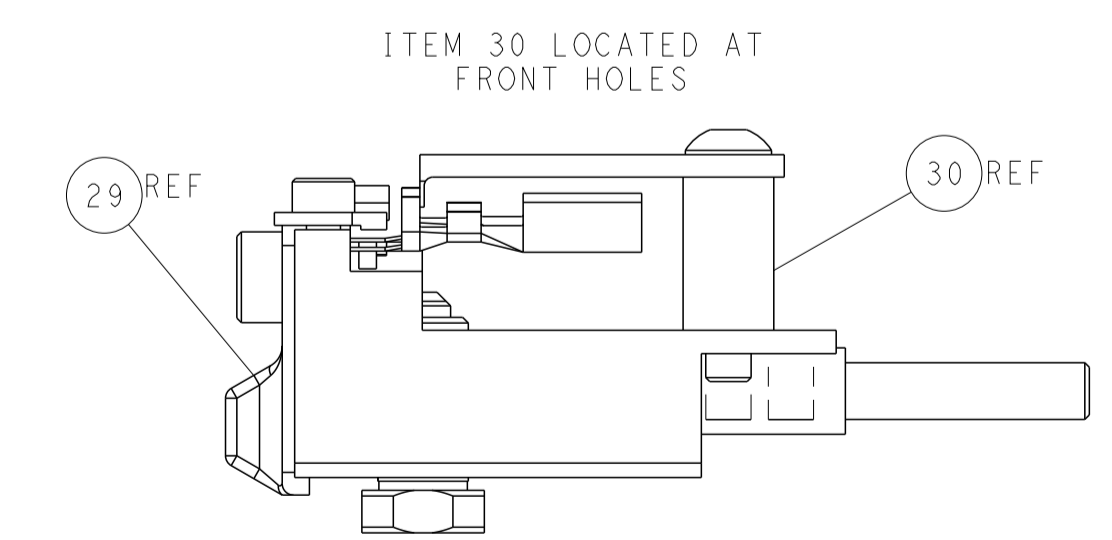
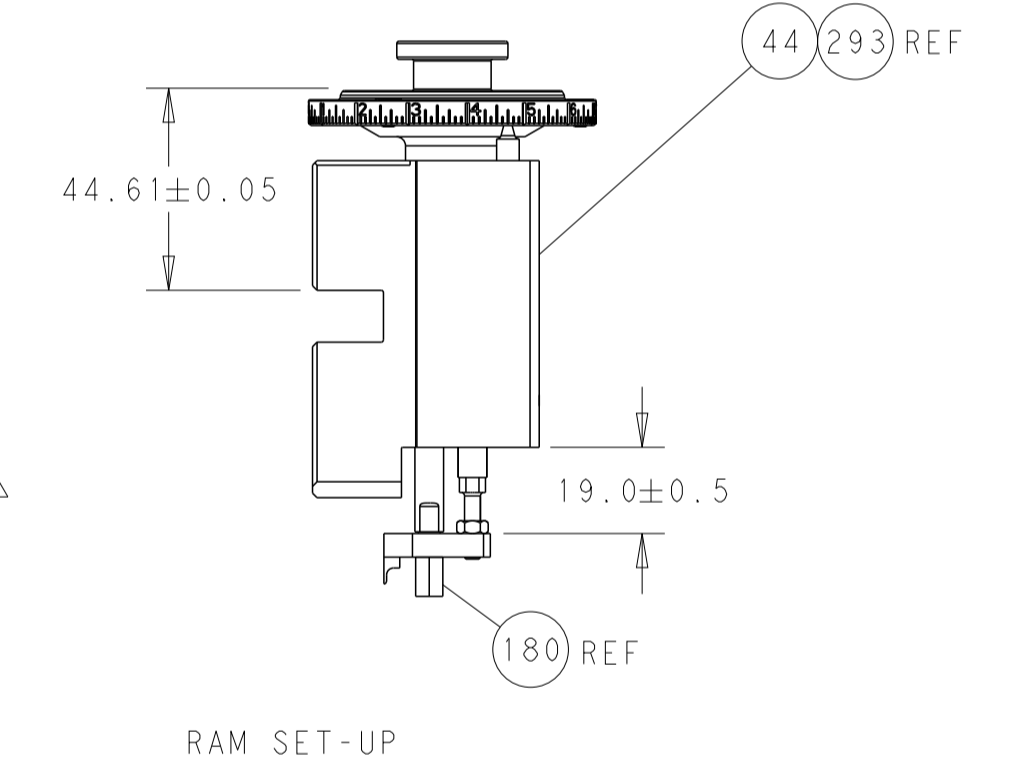
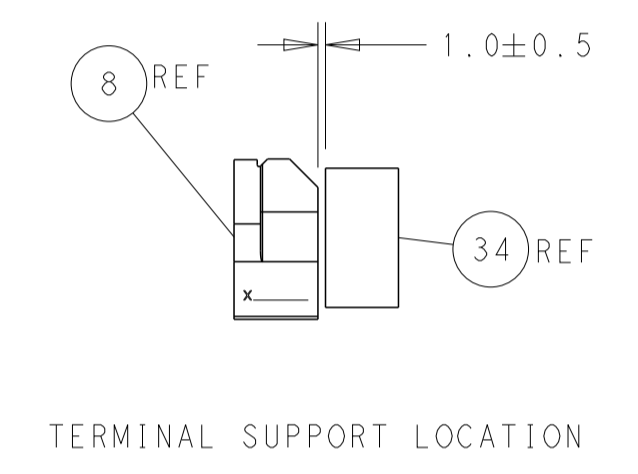
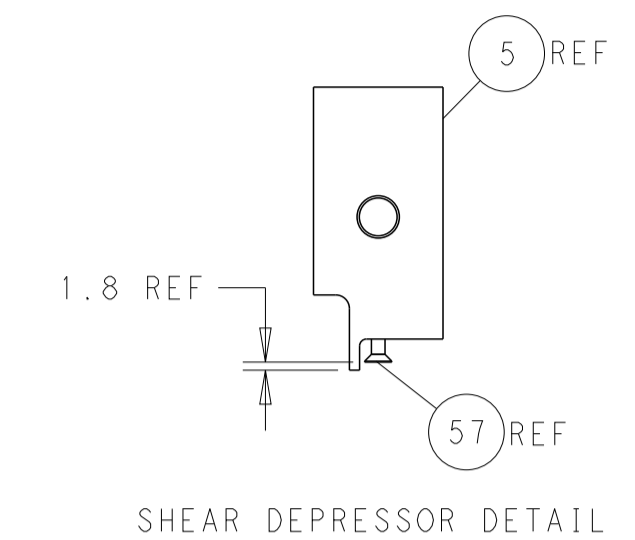
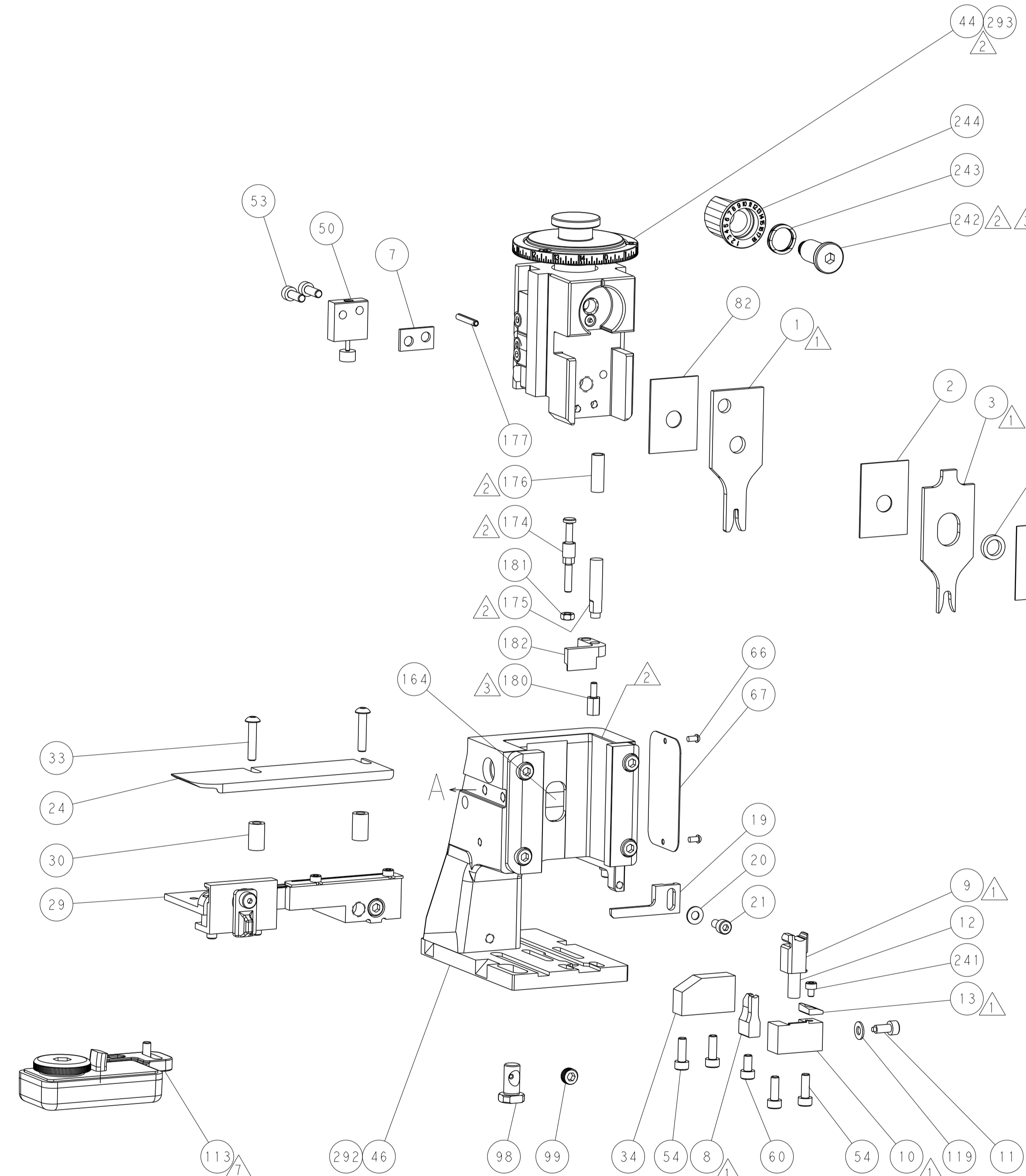
FEED TYPE MECHANICAL



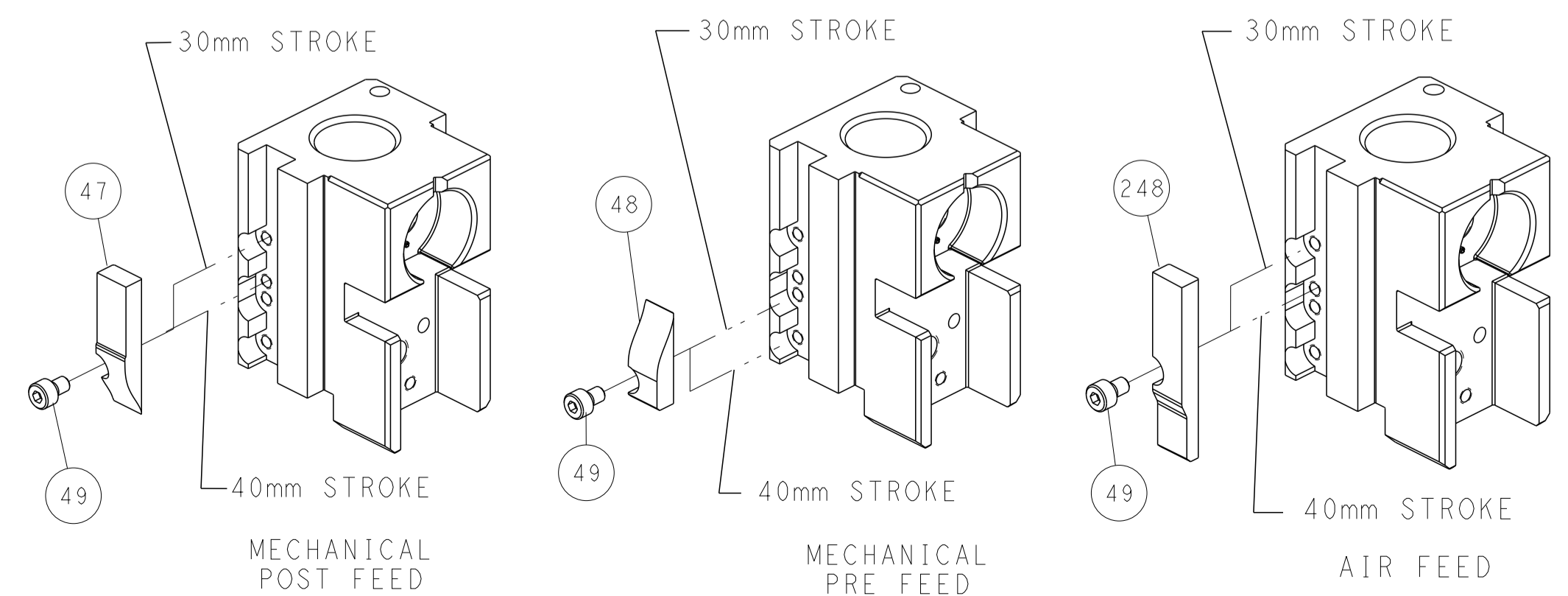
PNEUMATIC



FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



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 ±		DWN Y. YIN 02DEC2011 CHK G. BAILEY 02DEC2011 APVD S. XI 02DEC2011 NAME Ocean Side Feed Applicator	
MATERIAL:		FINISH:		SIZE CAGE CODE DRAWING NO RESTRICTED TO A1 00779 ©=2151392	
WEIGHT:		SCALE: 1:2		SHEET 2 OF 4 REV H2	

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2151392-1	H	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2151392-2	H	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151392-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.03 mm [.080]	F
INSUL	4.06 mm [.160]	O

APPLICATOR INSTRUCTIONS
408-35042

TERMINAL DATA: BOSCH TERMINAL BOSCH CRIMP SPECIFICATION

TERMINAL NAME: TERMINAL	
WIRE STRIP LENGTH 3.70-4.50 mm [.146-.177 IN]	INSULATION DIAMETER RANGE Ø1.20-2.10 mm [.047-.083 IN]
TERMINAL APPLICATION SPECIFICATION 1 928 F00 025-EN	

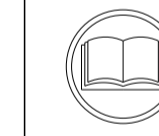
TERMINALS APPLIED

TE TERMINAL	BOSCH TERMINAL	TE SEAL	BOSCH SEAL	SEAL INSULATION DIAMETER RANGE
1572253-1	1928498054	1572254-1	1928300599	-
2320786-1	1928498056	828904-1	1-928-300-559	Ø1.2-2.1
1572253-3	1928498058	828904-2		Ø1.2-2.1
		828904-3		Ø1.2-2.1
		1572276-1		-

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.00mm ²	1.36+/-0.05 [.053+/- .002]	4.6
0.75mm ² or 18AWG	1.27+/-0.05 [.050+/- .002]	5.3
0.50mm ²	1.18+/-0.05 [.046+/- .002]	6.8

*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.



- 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.
- 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.
- UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- TERMINAL LUBRICANT IS RECOMMENDED.

LOC	DIST	REV	DATE	BY	APPV
A	66				

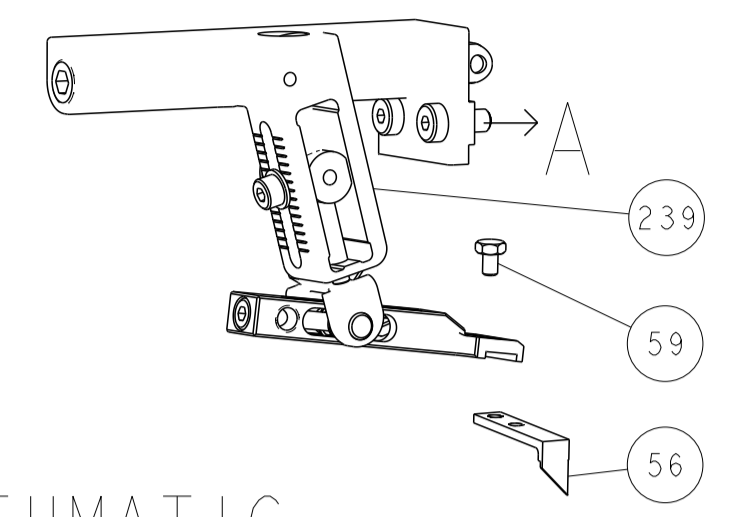
REV	DATE	DESCRIPTION	DATE	BY	APPV
-	1 1	2119082-9 CAM, SNAIL, INSULATION ADJUSTMENT			244
-	1 1	2079764-1 WASHER, WAVE SPRING, CREST-TO-CREST			243
-	1 1	2119083-1 RETAINER, INSULATION DIAL			242
-	1 1	7-18023-7 SCR, SKT HD CAP M3 X 4.0			241
-	-	2119580-1 MECHANICAL FEED ASSEMBLY			239
-	1 -	2844940-1 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
-	-	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	455888-8 SPACER, CRIMPER			82
-	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	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	1803382-6 HOLD DOWN, SPRING LOADED			50
-	1 2	18023-9 SCR, SKT HD CAP M4 X 6.0			49
-	-	2119652-1 FEED CAM, PRE FEED			48
-	1 1	1803602-1 SCR, BHSC, RoHS (M8 X 25)			41
-	1 1	1-1752356-7 SUPPORT, TERMINAL			34
-	2 2	2079383-5 SCR, BHSC, RoHS (M4 X 20)			33
-	2 2	2-2844962-3 SPACER, CYLINDRICAL, STRIP GUIDE			30
-	1 1	2844992-2 ASSEMBLY, STRIP GUIDE			29
-	1 1	455888-4 SPACER, CRIMPER			28
-	1 1	1320928-1 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	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	318707-1 FLOATING SHEAR, FRONT			9
-	1 1	2-1333204-6 ANVIL, COMBINATION			8
-	1 1	3-240641-3 SPACER			7
-	-	-			6
-	1 1	2119781-1 DEPRESSOR, SHEAR			5
-	1 1	3-238011-3 BLOCK, CRIMPER SPACER			4
-	1 1	3-2119784-1 CRIMPER, INSULATION O PREMIUM			3
-	1 1	455888-7 SPACER, CRIMPER			2
-	1 1	1-456405-6 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)

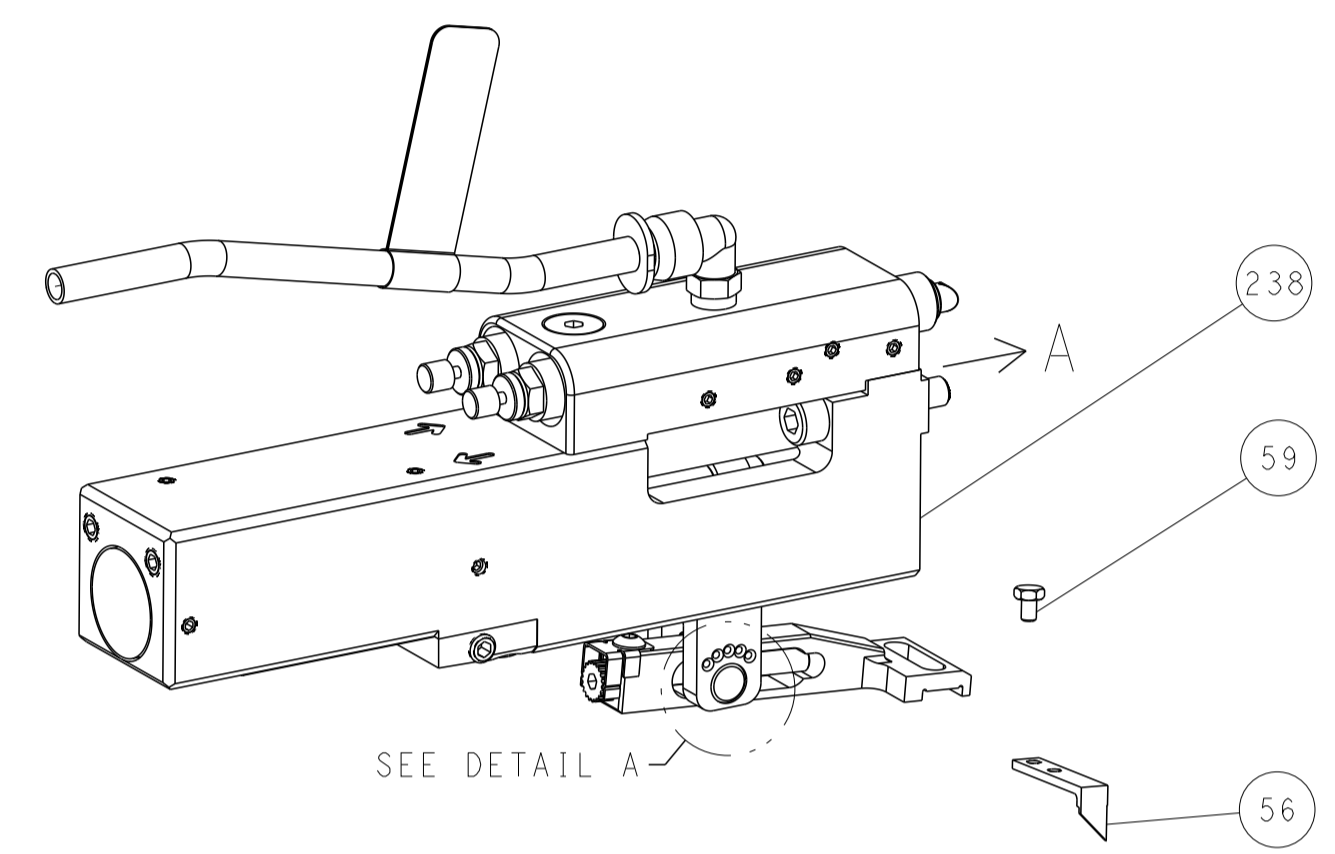
<small>THIS DRAWING IS CONTROLLED DOCUMENT AND IS THE PROPERTY OF STE CONNECTIVITY. IT IS TO BE USED ONLY FOR THE PROJECT AND FOR THE CUSTOMER'S USE. IT IS TO BE DESTROYED OR RECYCLED UPON COMPLETION OF THE PROJECT. ANY REPRODUCTION OR DISTRIBUTION OF THIS DRAWING WITHOUT THE WRITTEN PERMISSION OF STE CONNECTIVITY IS PROHIBITED.</small>		DWN Y.YIN 02DEC2011 CHK G.BAILEY 02DEC2011 APPV S.XI 02DEC2011	NAME Ocean Side Feed Applicator
DIMENSIONS: mm 	TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH	SIZE A1 CAGE CODE 00779 DRAWING NO C=2151392	RESTRICTED TO Customer Accessible Production Drawing SCALE 1:2 SHEET 3 OF 4 REV H2

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

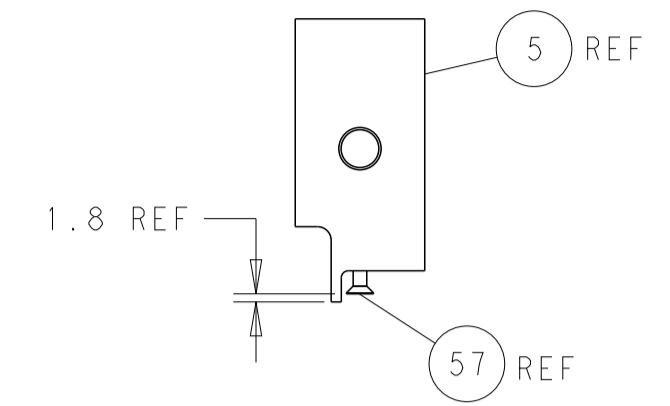
FEED TYPE MECHANICAL



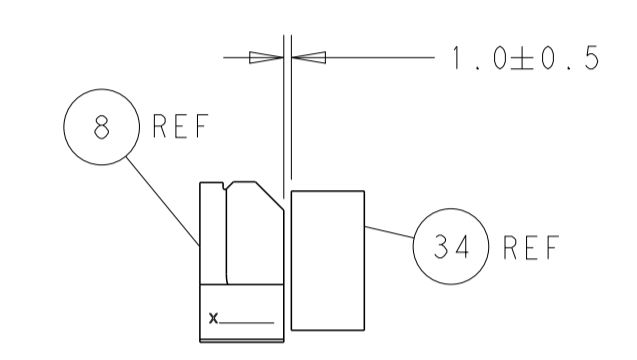
PNEUMATIC



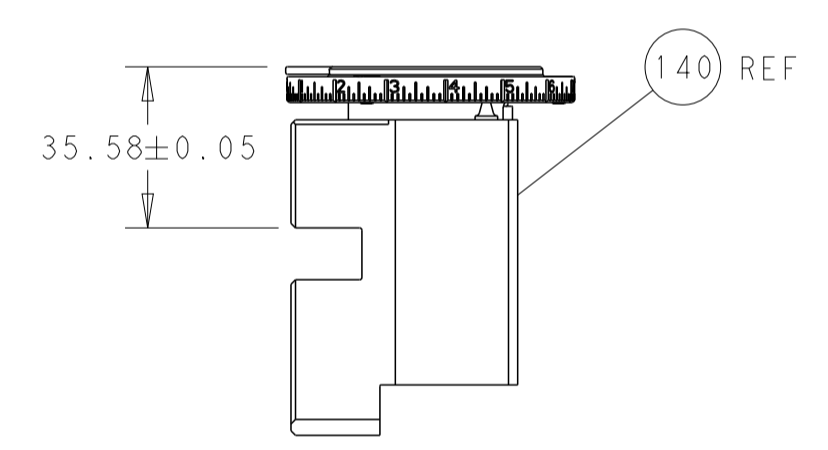
FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



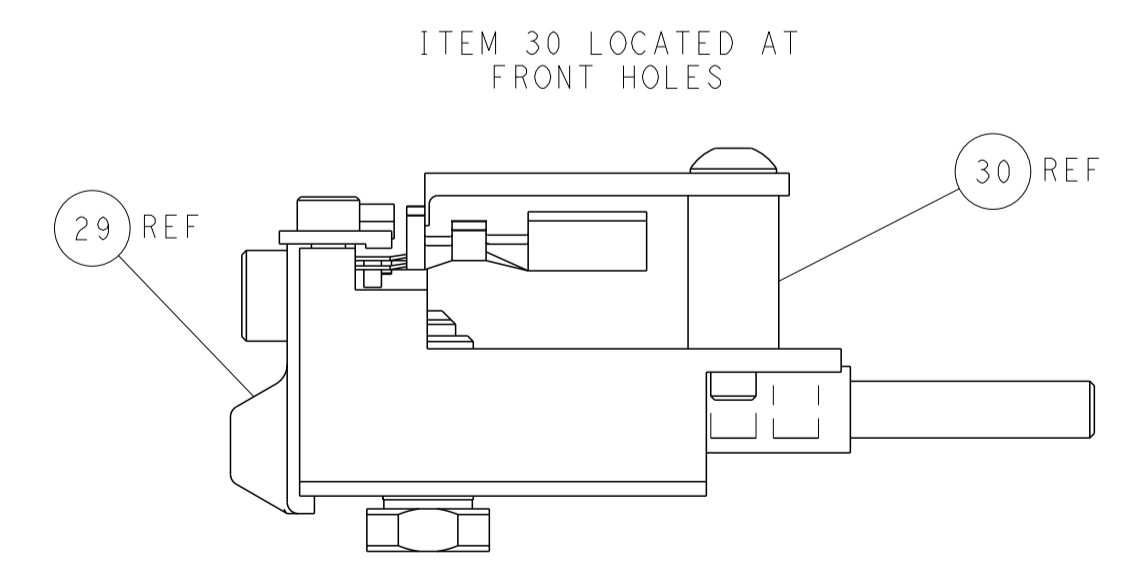
SHEAR DEPRESSOR DETAIL



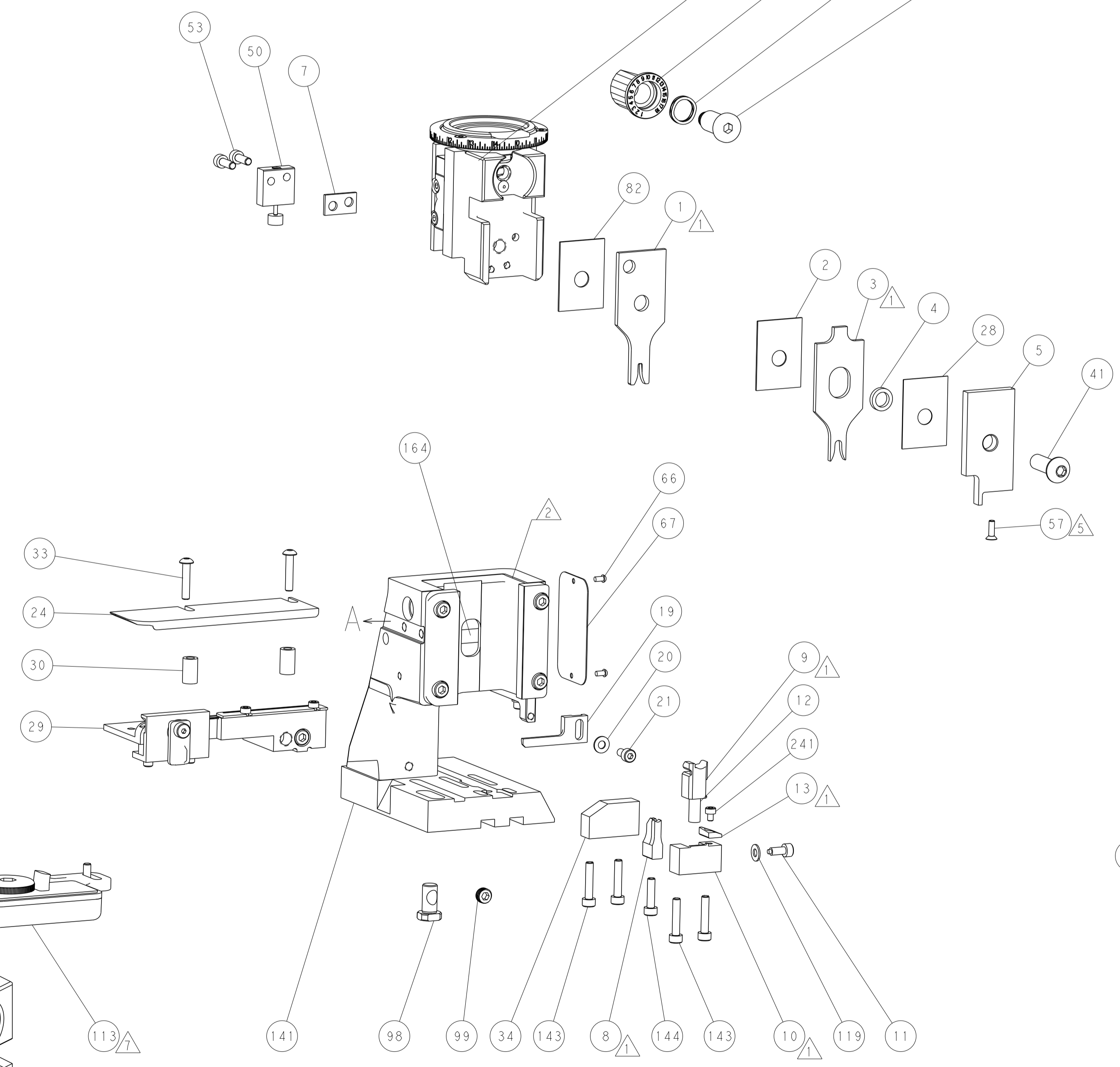
TERMINAL SUPPORT LOCATION



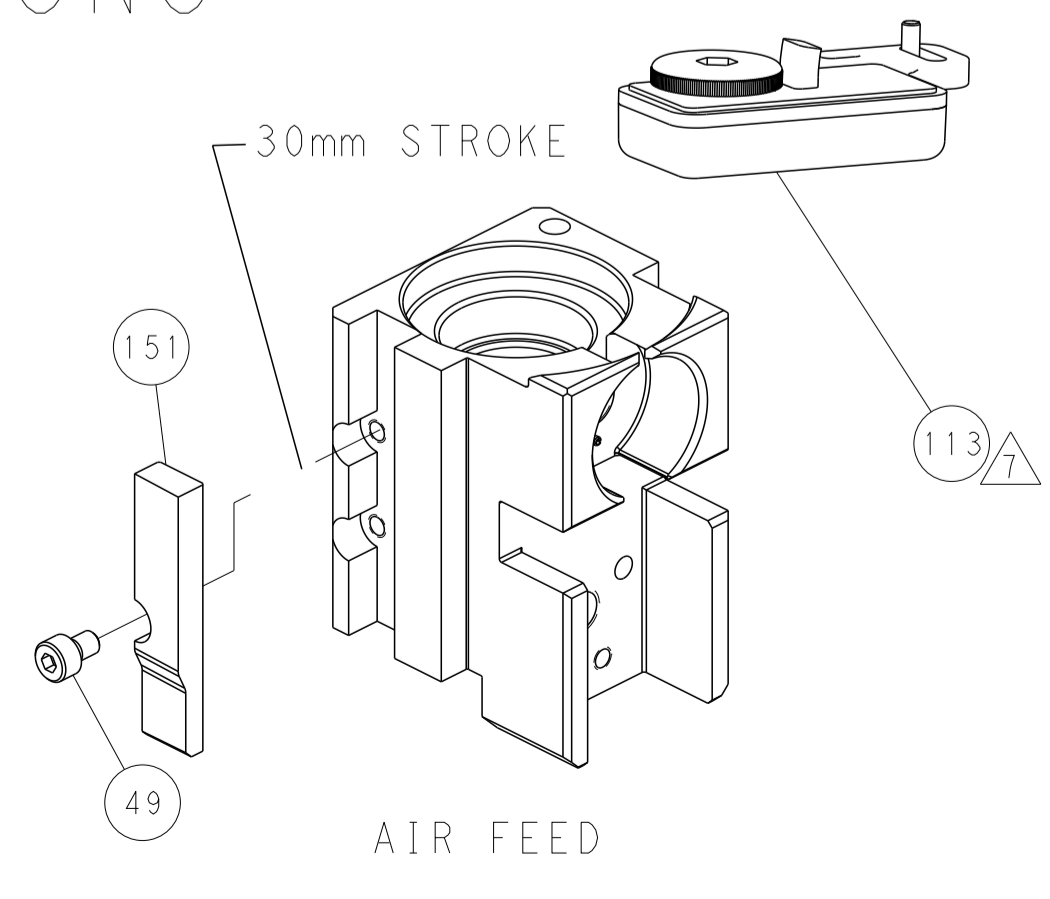
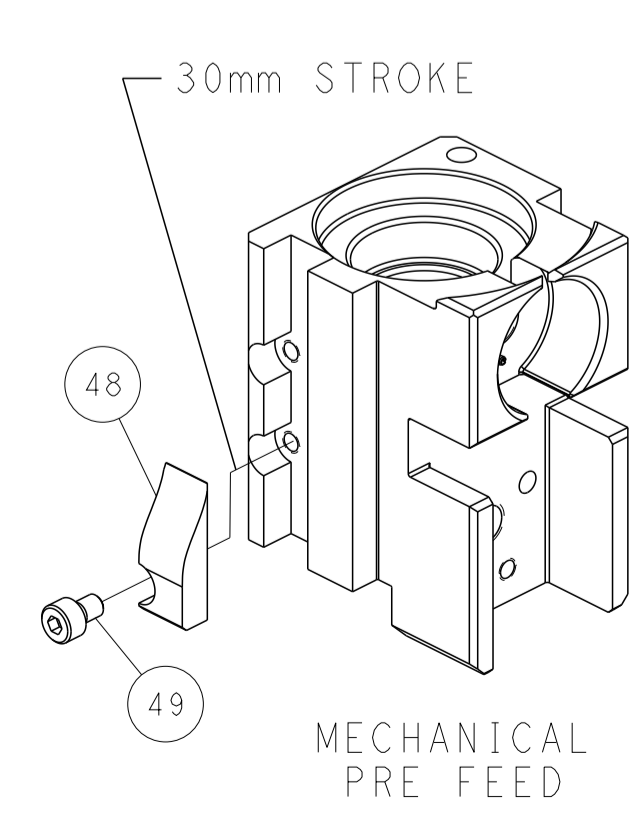
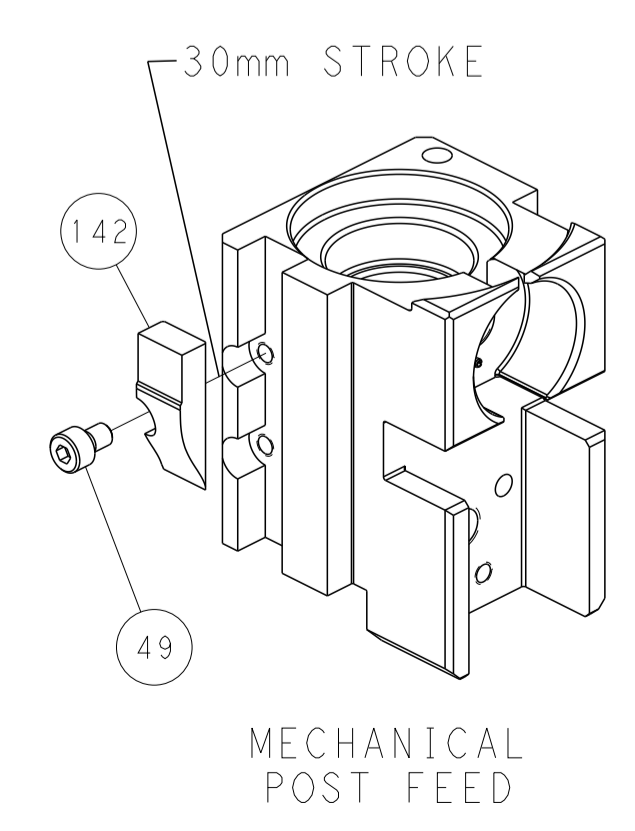
RAM SET-UP



FEED TRACK POSITION GUIDE BY INSULATION BARREL



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 TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH		NAME Ocean Side Feed Applicator APPLICATION SPEC PRODUCT SPEC SIZE CAGE CODE DRAWING NO A1 00779 C=2151392	RESTRICTED TO SCALE 1:2 SHEET 4 OF 4 REV H2
MATERIAL:		WEIGHT:	Customer Accessible Production Drawing