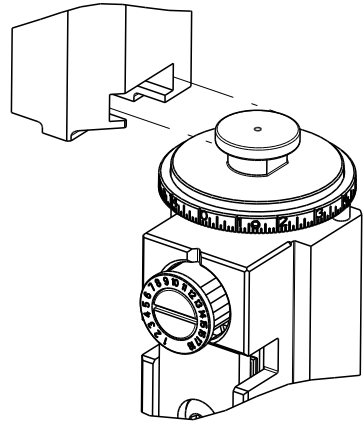


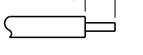
8	7	6	5	4	3	2	1
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE				
2151413-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL				
2151413-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC				
7-2151413-1	C	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL				
7-2151413-2	C	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC				
7-2151413-7	A	CRIMP TOOLING KIT	-				

ATLANTIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.54 mm [.100]	F
INSUL	4.19 mm [.165]	O

APPLICATOR INSTRUCTIONS
408-35042

TERMINAL DATA: BOSCH TERMINAL		BOSCH CRIMP SPECIFICATION	
TERMINAL NAME: BOSCH DAMPING CONTACT 2.8			
WIRE STRIP LENGTH 4.70-5.08 mm [.185-.200 IN]			INSULATION DIAMETER RANGE Ø 3.40 mm [.134 IN] MAX
TERMINAL APPLICATION SPECIFICATION	 NONE	-	-
TERMINALS APPLIED			
TE TERMINAL	BOSCH TERMINAL	TE SEAL	BOSCH SEAL
1572888-1	1 928 498 055	2113409-1	1 928 300 600
1572888-2	1 928 498 057		
1572888-3	1 928 498 059		
1572888-4	1 928 498 063		
1572888-5	1 928 498 061		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
2.50mm2	1.80+/-0.05 [.071+/- .002]	4.0
2.00mm2	1.70+/-0.05 [.067+/- .002]	5.4
1.50mm2	1.57+/-0.05 [.062+/- .002]	6.7



- 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 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. 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.

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				
A	66	P	LTR	DESCRIPTION	DATE	DWN APVD
		I		DEVELOPMENT	13NOV2013	KH UG
		A		RELEASED	13DEC2013	YY UG
		B		ECR-18-007520	16MAY2018	FZ KZ
		C		ECR-20-004674	30MAR2020	TB RK

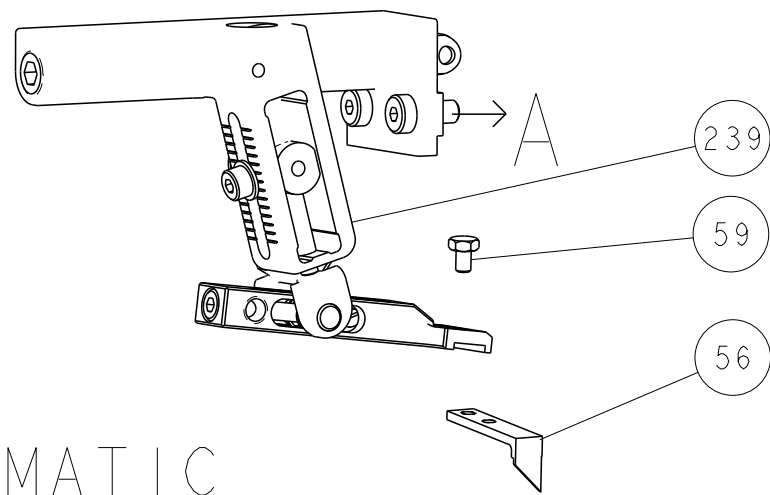
-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248
-	1	1	1	1	2119082-7	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
3	-	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	1	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
-	-	1	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	1	-	1	-	2844940-1	AIR FEED MODULE	238
-	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	1	1	1	1	1-18028-2	WASHER, FLAT, REG M4	119
-	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	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
5	-	1	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	1	1	1	1	985575-3	SCR, FLT SKT HD CAP M3 X 10.0	57
-	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	1803382-2	HOLD DOWN, SPRING LOADED	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	1-1752356-7	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	2844992-2	ASSEMBLY, STRIP GUIDE	29
-	1	1	1	1	455888-3	SPACER, CRIMPER	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
-	1	1	1	1	1-18028-2	WASHER, FLAT, REG M4	20
-	1	1	1	1	2119533-1	STRIPPER, SIDE FEED	19
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	318707-1	FLOATING SHEAR, FRONT	9
1	1	2	2	1	1-1633922-7	ANVIL, COMBINATION	8
-	-	-	-	-	-	-	7
-	-	-	-	-	-	-	6
-	1	1	1	1	2119781-1	DEPRESSOR, SHEAR	5
-	1	1	1	1	238011-4	BLOCK, CRIMPER SPACER	4
1	1	2	2	1	5-1633965-0	CRIMPER, INSULATION O PREMIUM	3
-	1	1	1	1	1-455888-1	SPACER, CRIMPER	2
1	1	2	2	1	2-456407-6	CRIMPER, WIRE PREMIUM	1

THIS DRAWING IS TO BE CONSIDERED VALID FOR THE ENTIRE LIFE OF THE PRODUCT UNLESS OTHERWISE SPECIFIED. IT IS SUBJECT TO CHANGE WITHOUT NOTICE AND THE MANUFACTURING ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST REVISION.		DWN R. HUANG CHK L. ZHANG APVD J. GUO	13NOV2013 13NOV2013 13NOV2013	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 Applicator	
MATERIAL -		WEIGHT -		SIZE A	CAGE CODE 00779
				DRAWING NO C=2151413	RESTRICTED TO -
				Customer Accessible Production Drawing	
				SCALE 1:2	SHEET 1 OF 4
				REV C	

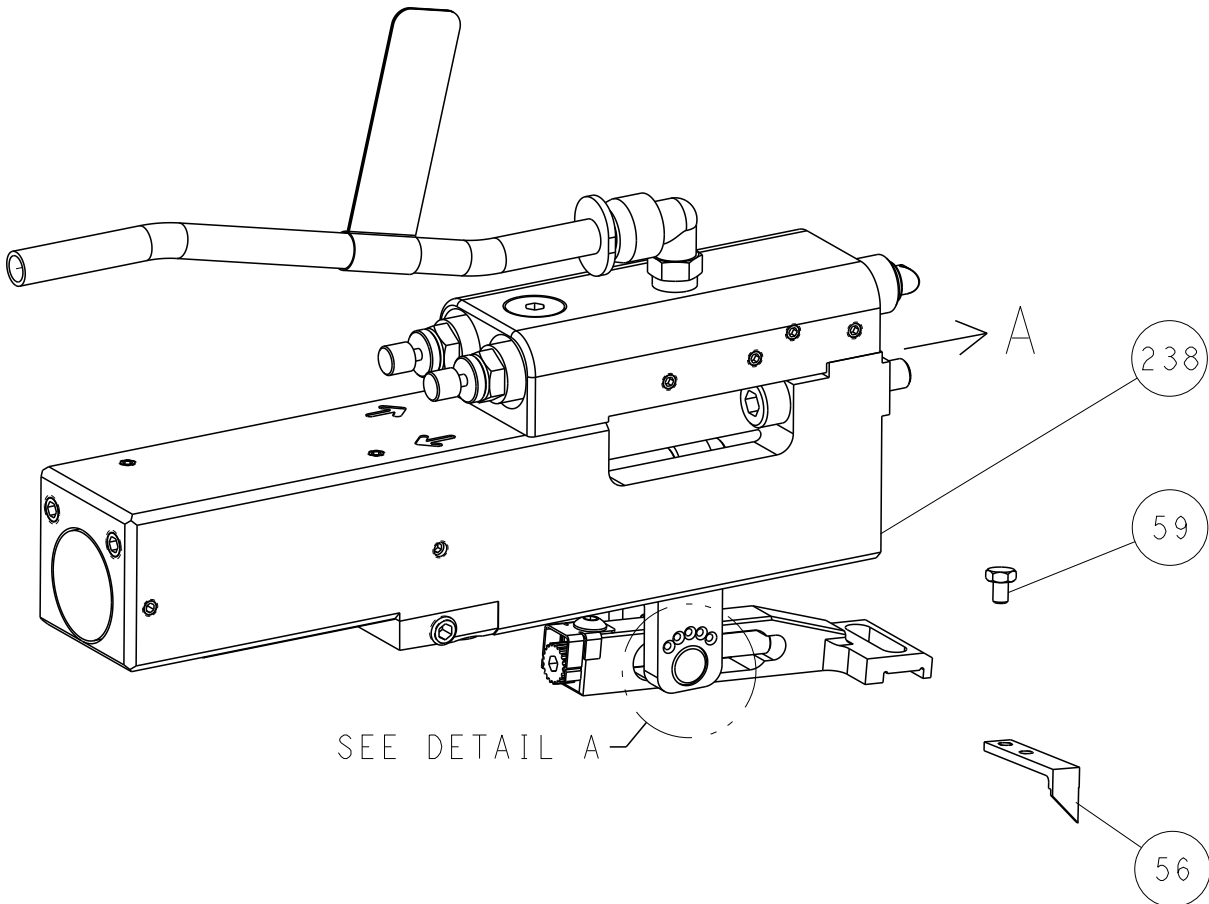
SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

LOC		DIST		REVISIONS				
A	66	P	LYR	DESCRIPTION	DATE	DWN	APVD	
		-		SEE SHEET 1	-	-	-	

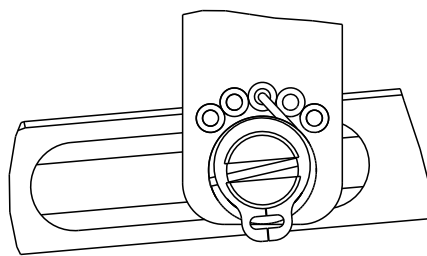
FEED TYPE MECHANICAL



PNEUMATIC

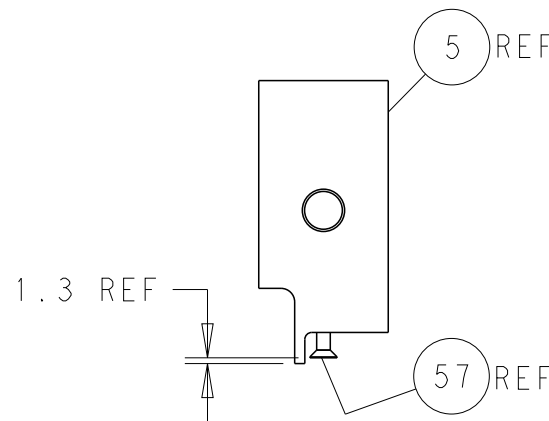
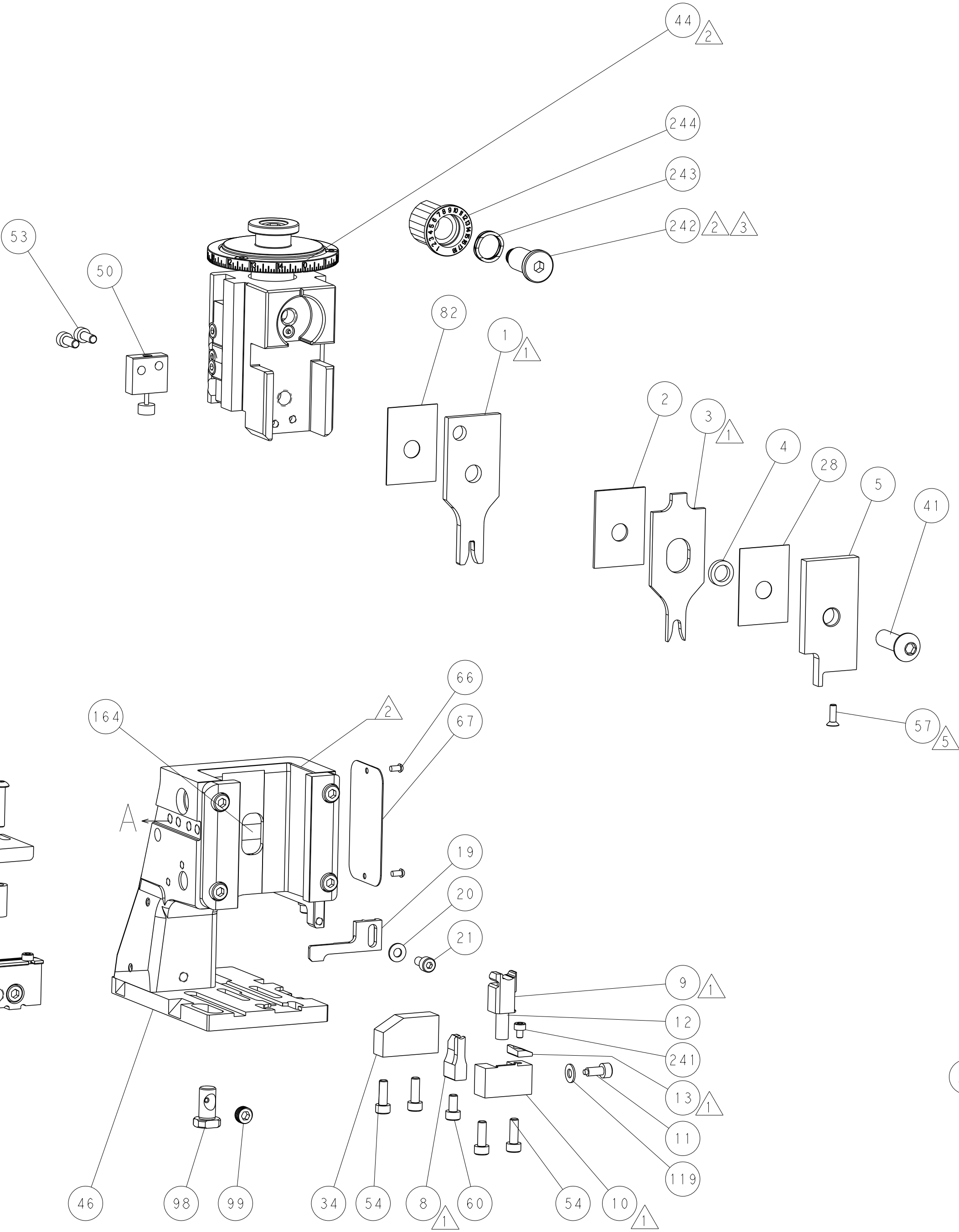
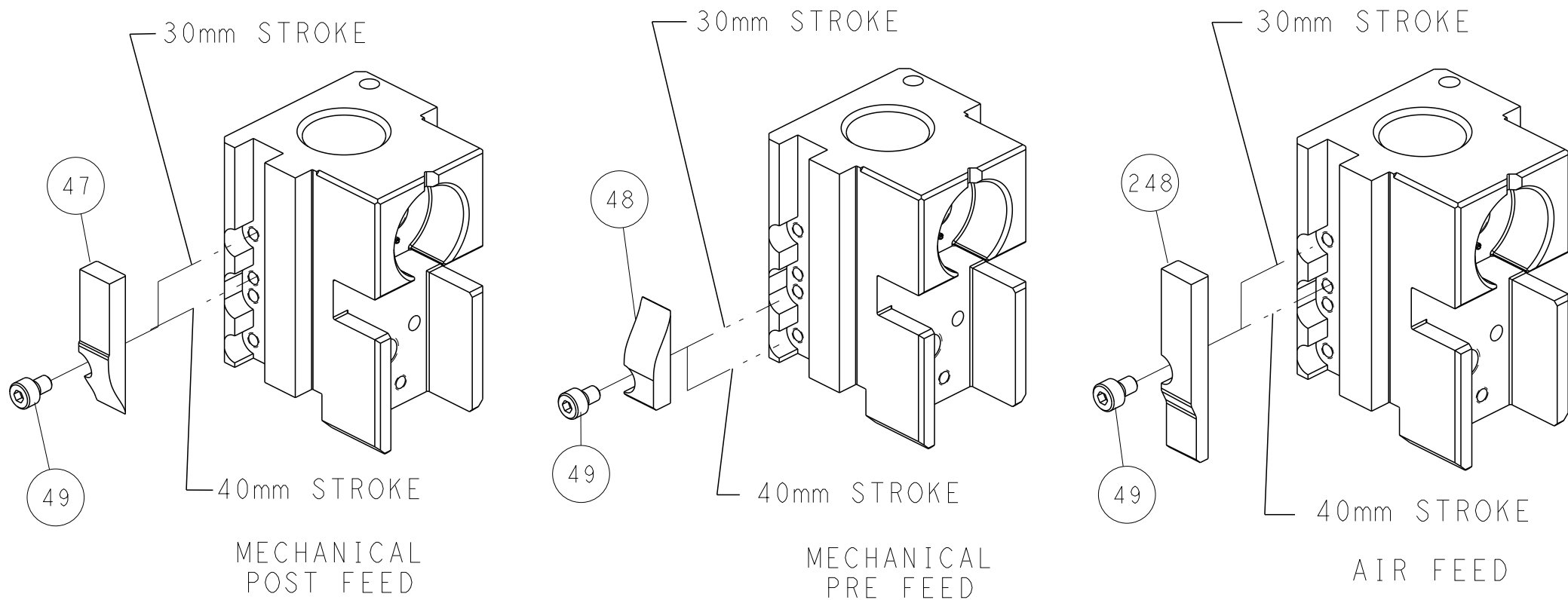


FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)

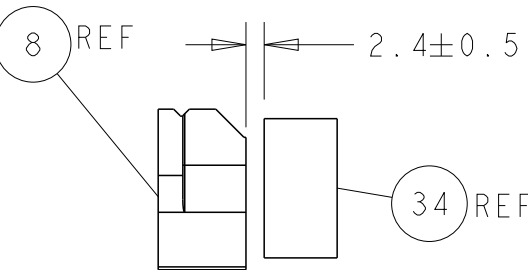


DETAIL A

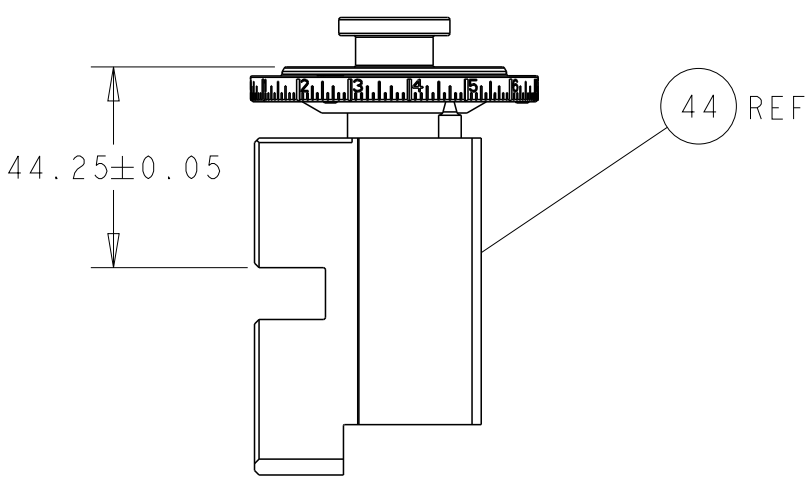
CAM POSITIONS



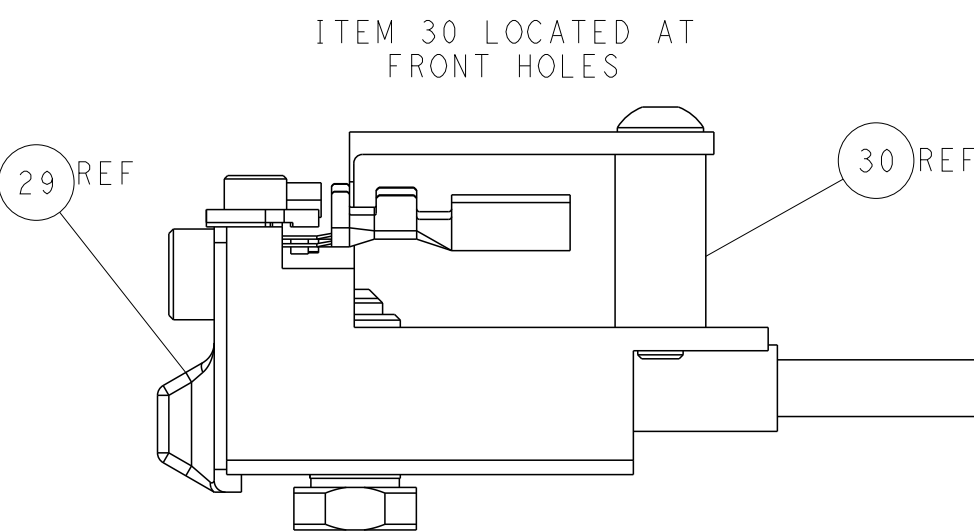
SHEAR DEPRESSOR DETAIL



TERMINAL SUPPORT LOCATION



RAM SET-UP



FEED TRACK POSITION
GUIDE BY INSULATION BARREL

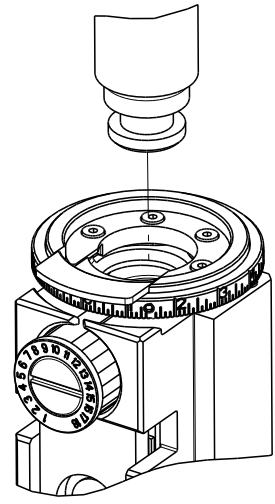
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE WITHOUT NOTICE AND THE MANUFACTURING ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST REVISION.				DWN K. HUANG 13NOV2013	 TE Connectivity Harrisburg, PA 17105-3608						
				CHK L. ZHANG 13NOV2013					APVD J. GUO 13NOV2013		
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		NAME		Ocean Side Feed Applicator					
		0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH ±		PRODUCT SPEC APPLICATION SPEC							
MATERIAL -		WEIGHT -		SIZE A1		CAGE CODE 00779		DRAWING NO C=2151413		RESTRICTED TO -	
Customer Accessible Production Drawing						SCALE 1:2		SHEET 2		OF 4	
								REV C			

SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

8		7	
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20		20	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2151413-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2151413-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151413-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.54 mm [.100]	F
INSUL	4.19 mm [.165]	O
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: BOSCH TERMINAL		BOSCH CRIMP SPECIFICATION	
TERMINAL NAME: BOSCH DAMPING CONTACT 2.8			
WIRE STRIP LENGTH 4.70-5.08 mm [.185-.200 IN]			INSULATION DIAMETER RANGE Ø 3.40 mm [.134 IN] MAX
TERMINAL APPLICATION SPECIFICATION	NONE	-	-
TERMINALS APPLIED			
TE TERMINAL	BOSCH TERMINAL	TE SEAL	BOSCH SEAL
1572888-1	1 928 498 055	2113409-1	1 928 300 600
1572888-2	1 928 498 057		
1572888-3	1 928 498 059		
1572888-4	1 928 498 063		
1572888-5	1 928 498 061		

SEAL INSULATION DIAMETER RANGE
Ø 2.2-3.0 mm

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING
2.50mm2		1.80+/-0.05 [.071+/- .002]		4.0
2.00mm2		1.70+/-0.05 [.067+/- .002]		5.4
1.50mm2		1.57+/-0.05 [.062+/- .002]		6.7



- 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 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. 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.

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				
		P	LTR	DESCRIPTION	DATE	DWN
A	66	-	-	SEE SHEET 1	-	-

	-	1	1	2119082-7	CAM, SNAIL, INSULATION ADJUSTMENT	244
	-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
3	-	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	2844908-1	SCREW, LOCKING	99
	-	1	1	2844907-1	POST, LOCKING	98
	-	1	1	455888-4	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
5	-	1	1	985575-3	SCR, FLT SKT HD CAP M3 X 10.0	57
	-	1	1	1338685-1	PAWL, FEED	56
	-	2	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	53
	-	1	1	1803382-2	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	1-1752356-7	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	2844992-2	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	2119533-1	STRIPPER, SIDE FEED	19
1	-	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	1	2119805-1	SHEAR HOLDER, FRONT	10
	-	1	1	318707-1	FLOATING SHEAR, FRONT	9
1	1	1	1	1-1633922-7	ANVIL, COMBINATION	8
	-	-	-	-	-	7
	-	-	-	-	-	6
	-	1	1	2119781-1	DEPRESSOR, SHEAR	5
	-	1	1	238011-4	BLOCK, CRIMPER SPACER	4
1	1	1	1	5-1633965-0	CRIMPER, INSULATION O PREMIUM	3
	-	1	1	1-455888-1	SPACER, CRIMPER	2
1	1	1	1	2-456407-6	CRIMPER, WIRE PREMIUM	1

-77	-22	-21	PART NO	DESCRIPTION	ITEM NO
			STE TE Connectivity Harrisburg, PA 17105-3608		
			Ocean Side Feed Applicator		
			SIZE	CAGE CODE	DRAWING NO
			A1	00779	C=2151413
			Customer Accessible Production Drawing	SCALE	1:2
			SHEET	3	OF 4
			REV	C	

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

LOC		DIST		REVISIONS					
A		66		P	LTR	DESCRIPTION	DATE	DWN	APVD
					-	SEE SHEET 1	-	-	-

D

C

B

A

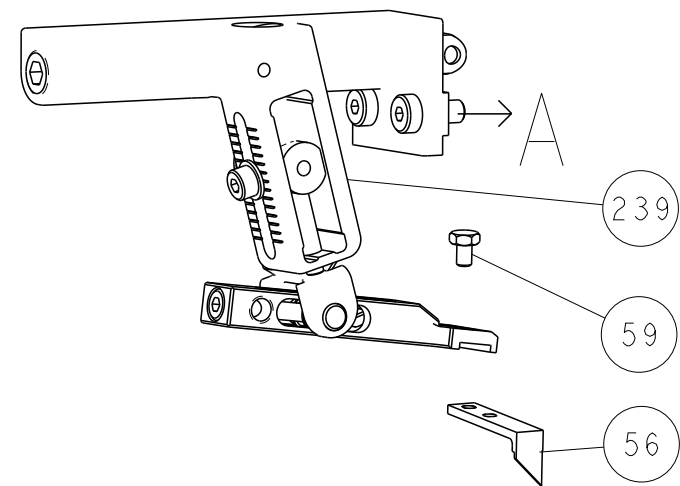
D

C

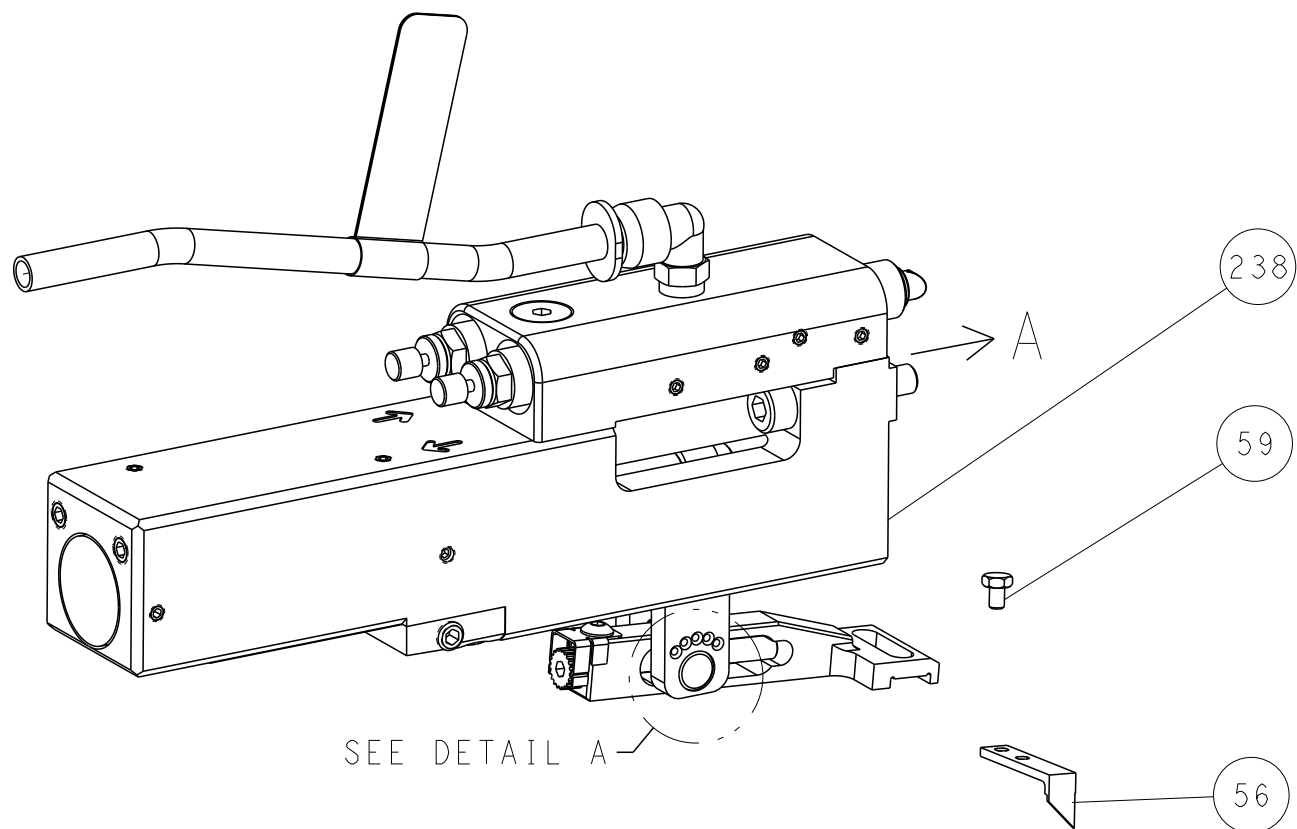
B

A

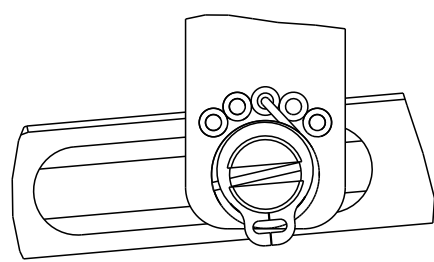
FEED TYPE MECHANICAL



PNEUMATIC

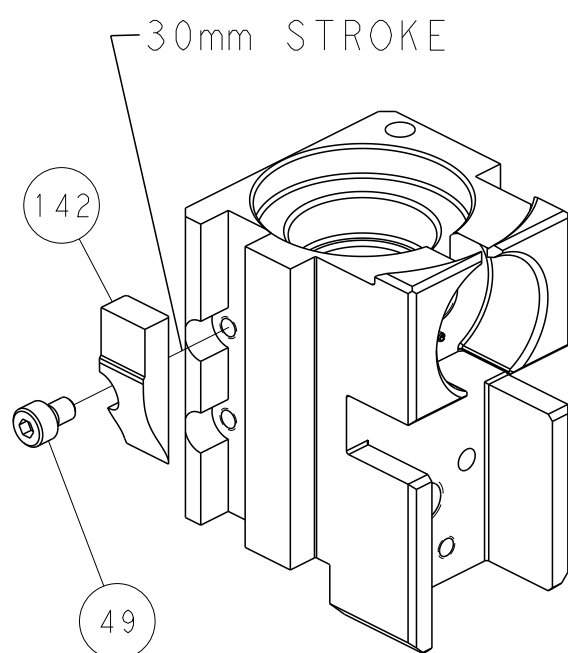


FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)

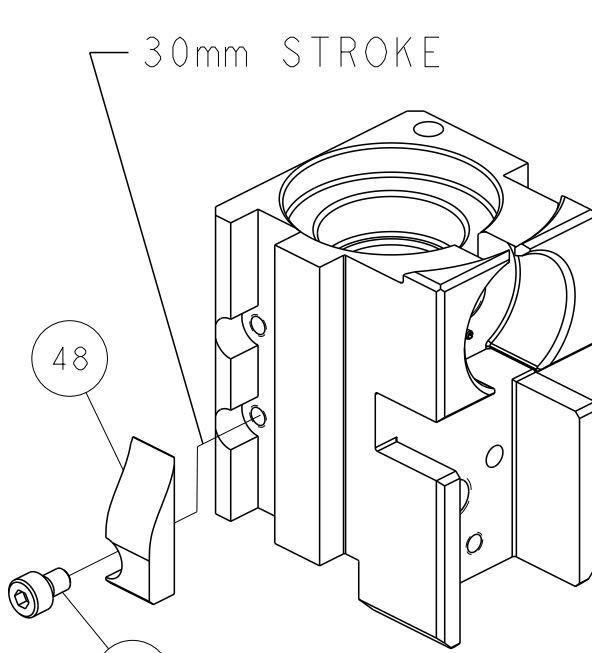


DETAIL A

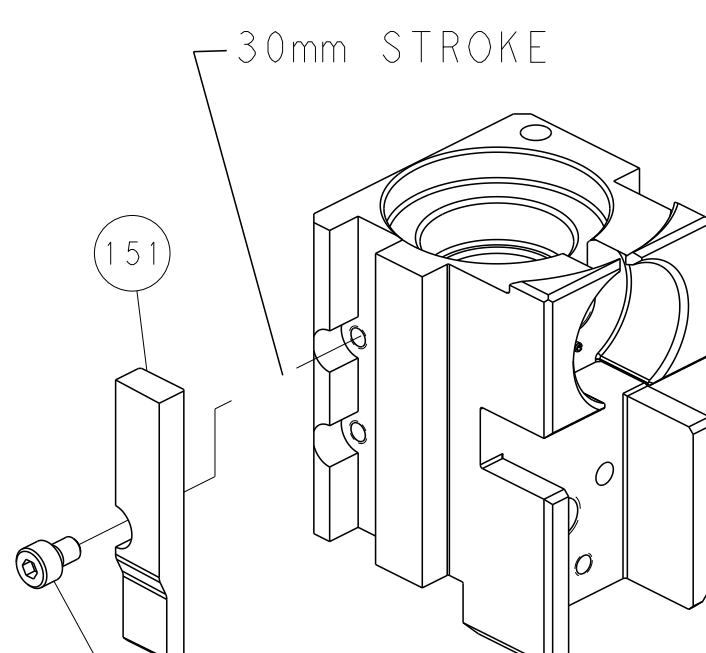
CAM POSITIONS



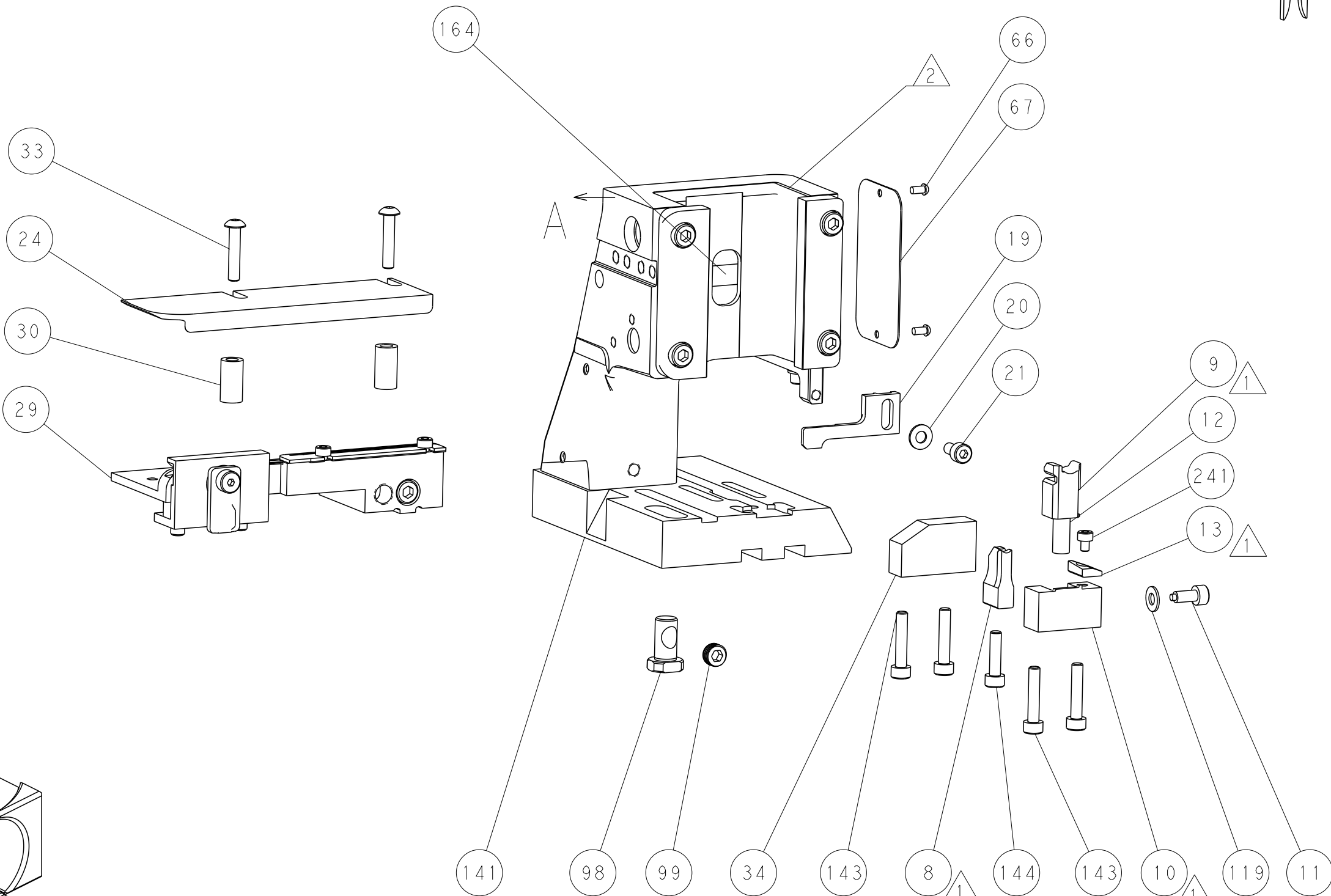
MECHANICAL
POST FEED



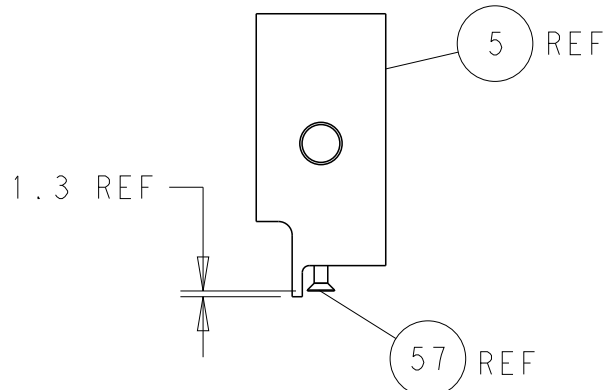
MECHANICAL
PRE FEED



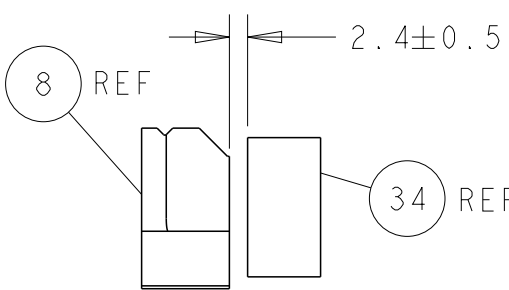
AIR FEED



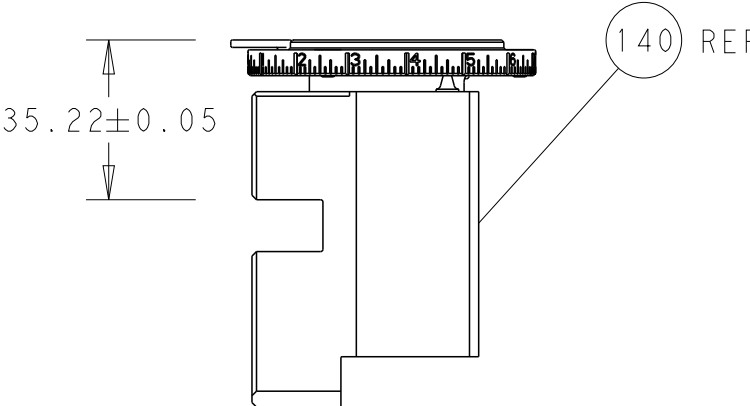
PACIFIC VERSION
Shown on sheets 3 of 4 & 4 of 4
(Atlantic version shown on sheets 1 of 4 & 2 of 4)



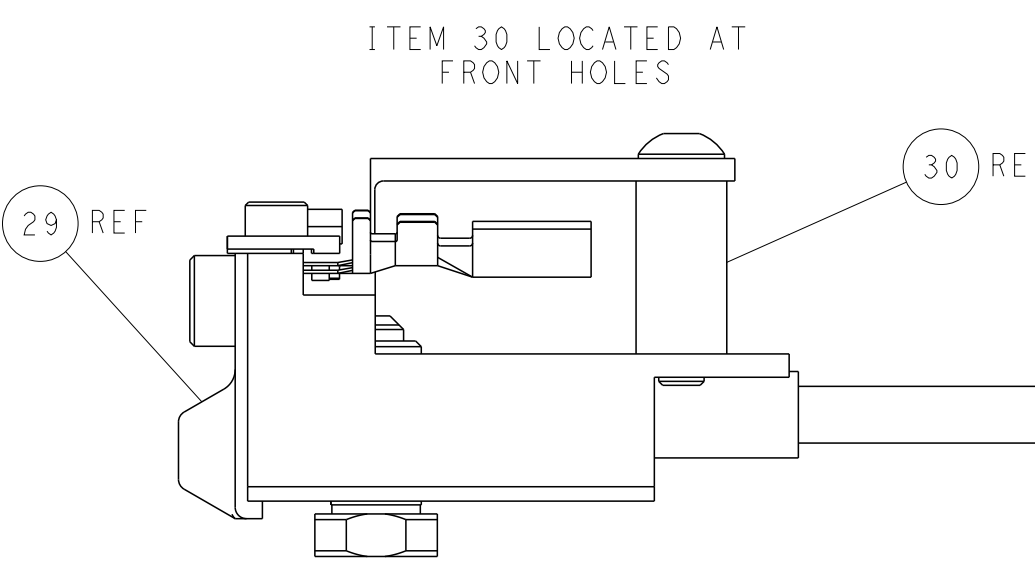
SHEAR DEPRESSOR DETAIL



TERMINAL SUPPORT LOCATION



RAM SET-UP



FEED TRACK POSITION
GUIDE BY INSULATION BARREL

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										CHK L. ZHANG 13NOV2013							
										APVD J. GUO 13NOV2013		NAME Ocean Side Feed Applicator -					
										PRODUCT SPEC							
										APPLICATION SPEC							
										WEIGHT						RESTRICTED TO	
										MATERIAL						Customer Accessible Production Drawing	
										SCALE						SHEET 4 of 4	
										REV						C	

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

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