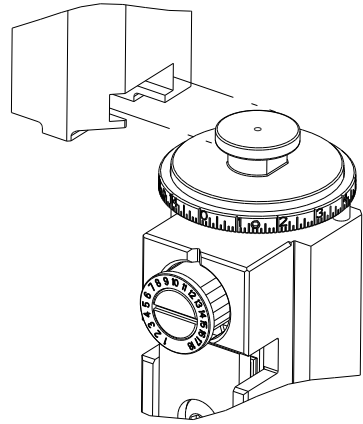


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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151463-1	J	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2151463-2	J	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151463-1	J	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2151463-2	J	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2151463-7	E	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.01 mm [.079]	F
INSUL	2.49 mm [.098]	O
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: FCI TERMINAL		FORD CRIMP SPECIFICATION	
TERMINAL NAME: 2.80MM WIRE		SNAP ON FEMALE TERMINAL	
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
4.71-4.72 mm [.185-.186 IN]		Ø 1.90 mm [.075 IN] MAX	
TERMINAL APPLICATION SPECIFICATION	FORD Rev A	-	-
	FCI WLBD100 Rev 10.4	-	-
TERMINALS APPLIED 			
TE TERMINAL	FCI TERMINAL	TE TERMINAL	INTERLOCK TERMINAL
1572901-1	10757690	1572901-4	JTP 1811-29
1572901-8	54001802	1572901-9	JTP 1811-29G
1-1572901-5	54001839	1572901-3	JTP 1811-66AU
1832575-1	54001803	TE TERMINAL	DAIMLER CHRYSLER
TE TERMINAL	NON-CHRYSLER TERMINAL	1572901-7	04687767
1572901-6	JS-1811-29	1-1572901-1	04707172
1-1572901-0	JS-1811-29G	1-1572901-3	04667819
1-1572901-2	JS-1811-66AU	TE TERMINAL	DELPHI PACKARD
TE TERMINAL	FORD TERMINAL	1-1572901-4	10890230
1572901-5	F8V8-14474-BA	1-1572901-6	15512735
		1-1572901-7	54001800

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.00mm2	1.40+/-0.05 [.055+/- .002]	7.8
18 AWG	1.35+/-0.05 [.053+/- .002]	8.3
0.75mm2	1.30+/-0.05 [.051+/- .002]	8.9
0.50mm2	1.25+/-0.05 [.049+/- .002]	9.3



- 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 CUT TO LENGTH AT ASSEMBLY.
- 6 TERMINAL LUBRICANT IS RECOMMENDED.
7. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.

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				
		P	LTR	DESCRIPTION	DATE	DWN
A	66		G1	ECR-17-014398	28SEP2017	RS
			H	ECR-18-006916	04MAY2018	VLA
			H1	ECR-19-017063	04NOV2019	FZ
			J	ECR-21-111802	27AUG2021	FJ

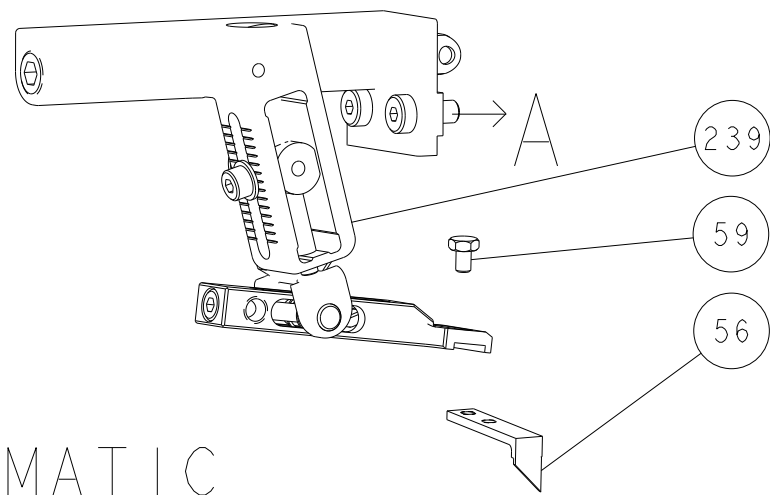
-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248
-	1	1	1	1	2119082-4	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	1	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
-	-	1	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	1	-	1	-	2844940-1	AIR FEED MODULE	238
-	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	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	318563-1	GUARD, FRONT CHIP	89
-	1	1	1	1	455888-6	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
-	1	1	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	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	2-2844962-3	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	1-356885-3	STOP, SHEAR	11
-	1	1	1	1	2119805-1	SHEAR HOLDER, FRONT	10
-	1	1	1	1	1803095-6	FLOATING SHEAR, FRONT	9
1	2	2	1	1	1633932-4	ANVIL, COMBINATION	8
-	-	-	-	-	-	-	7
-	-	-	-	-	-	-	6
-	1	1	1	1	2119757-8	DEPRESSOR, SHEAR	5
-	1	1	1	1	2-238011-1	BLOCK, CRIMPER SPACER	4
1	2	2	1	1	1-1803018-1	CRIMPER, INSULATION O	3
-	1	1	1	1	455888-4	SPACER, CRIMPER	2
1	2	2	1	1	3-1633305-2	CRIMPER, WIRE PREMIUM	1

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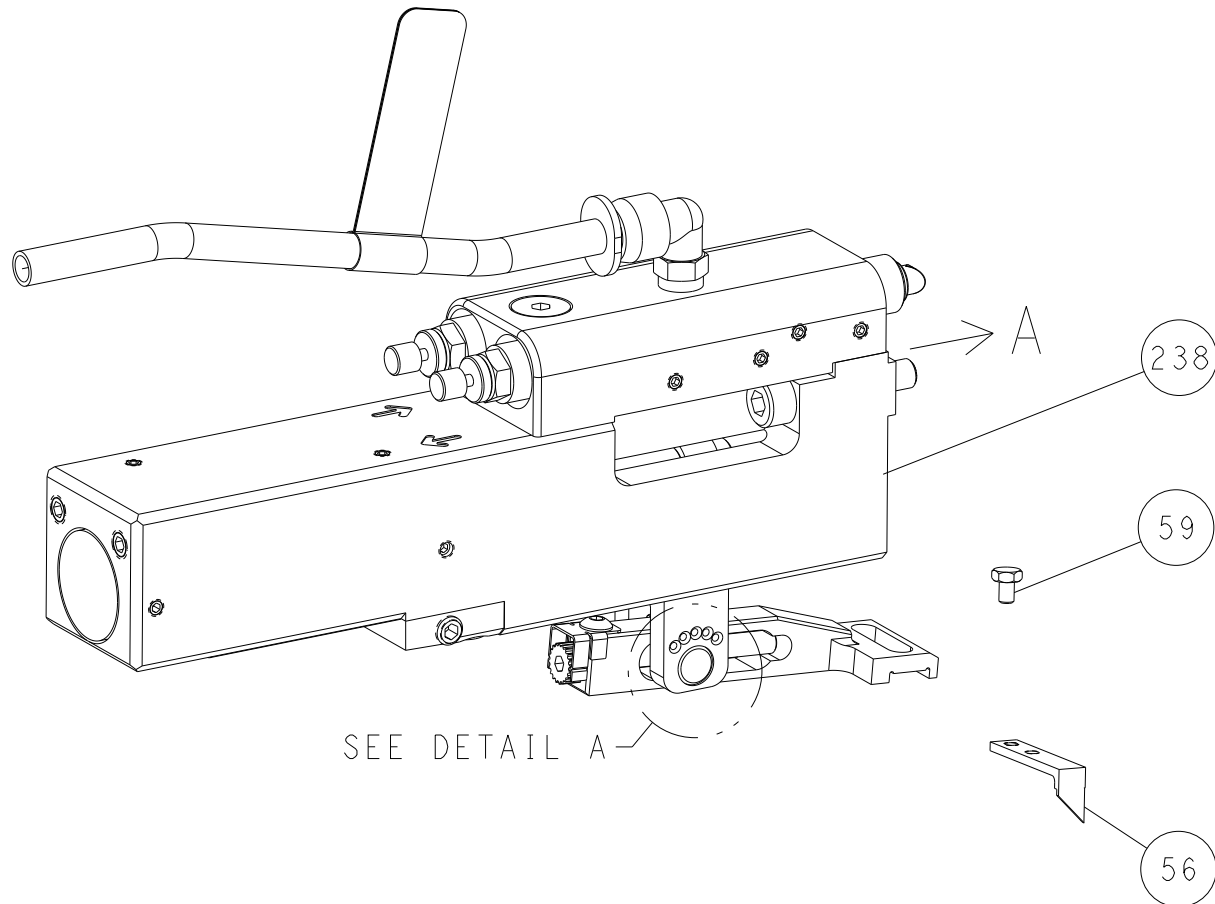
SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

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

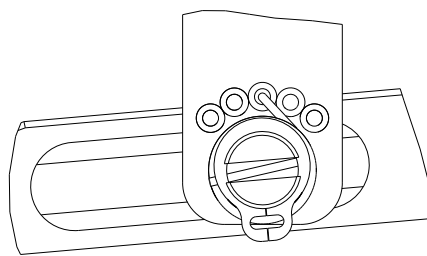
FEED TYPE
MECHANICAL



PNEUMATIC

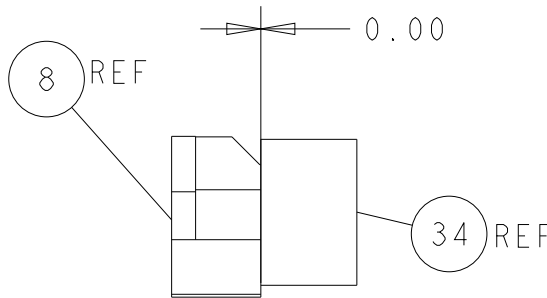
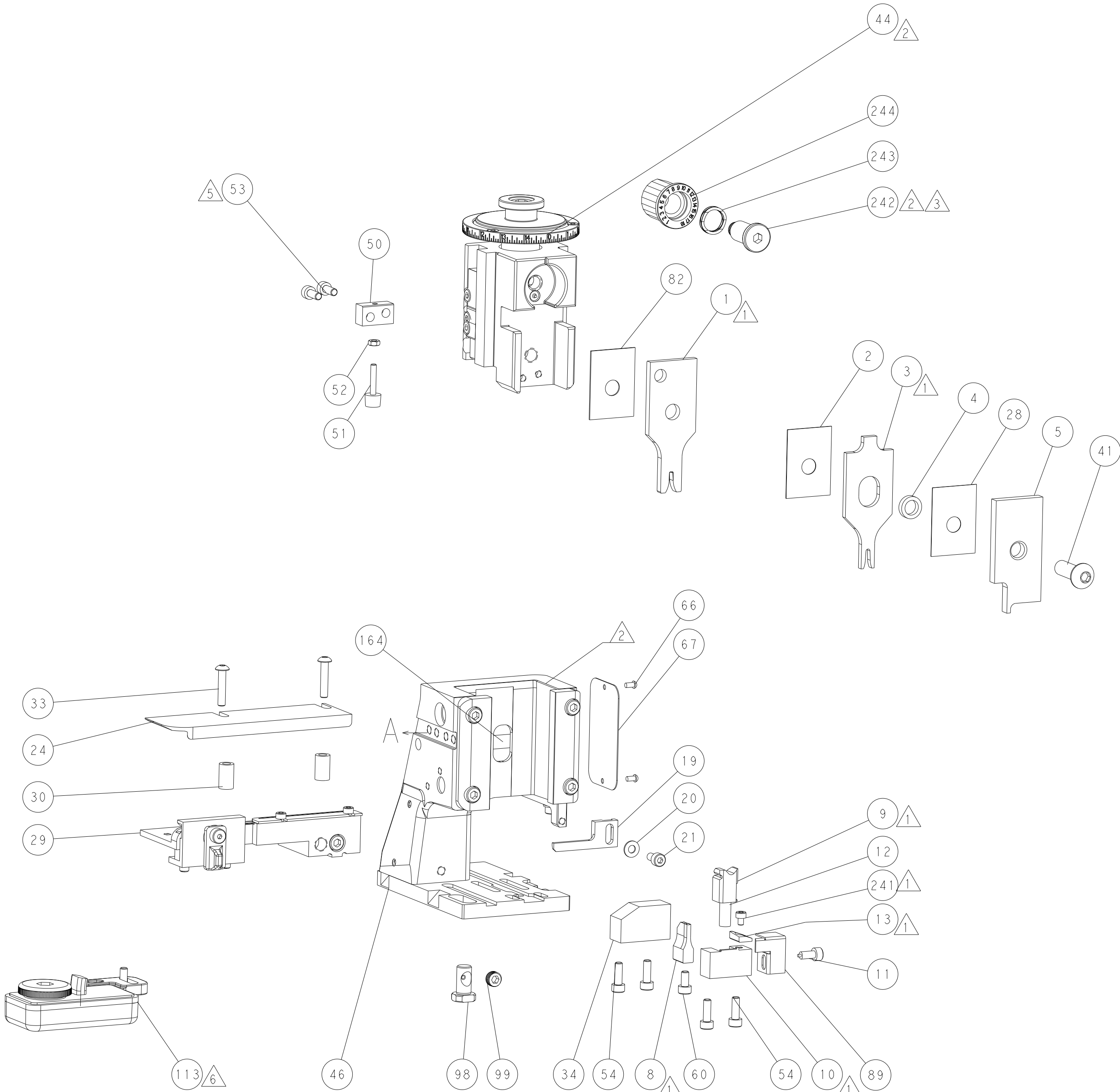
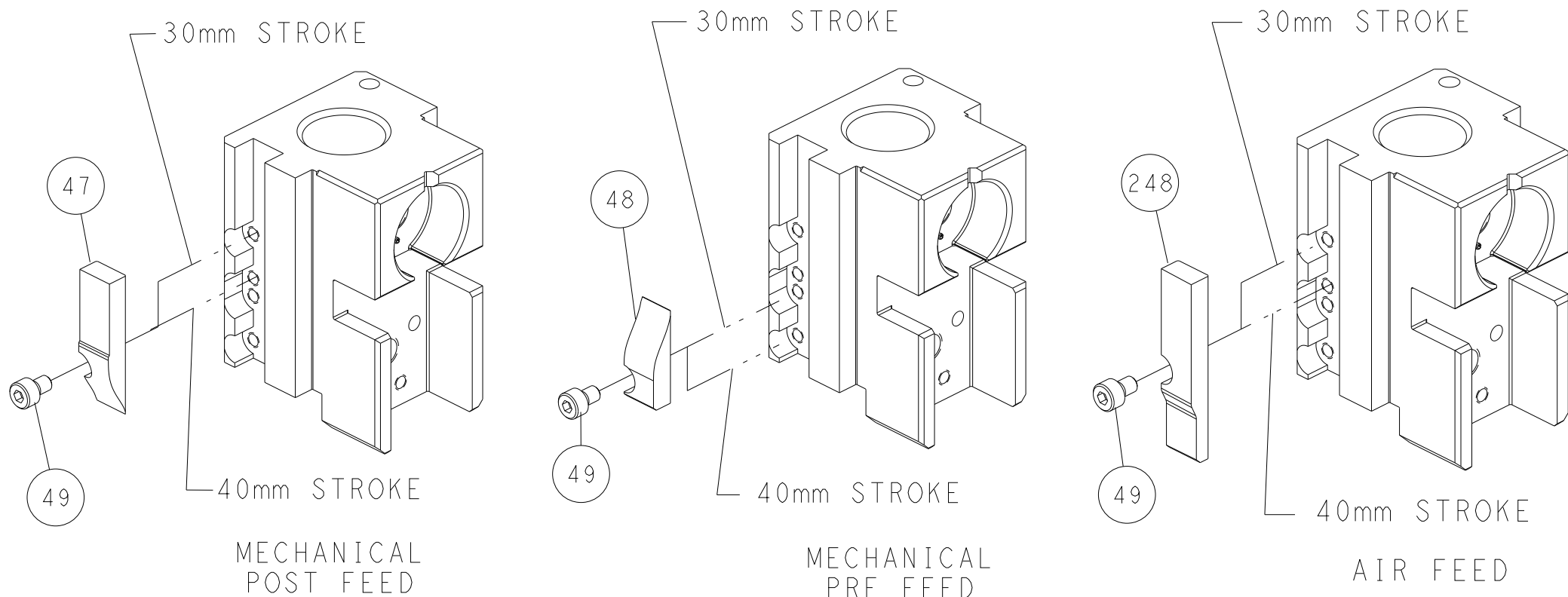


FEED SPRING SETTING POSITION
(SHOWN FROM REAR SIDE)

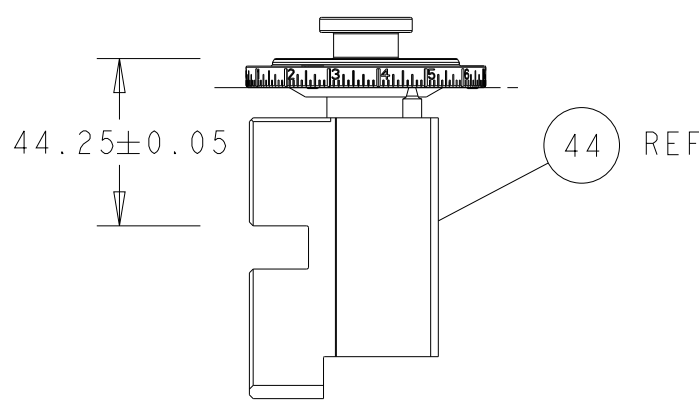


DETAIL A

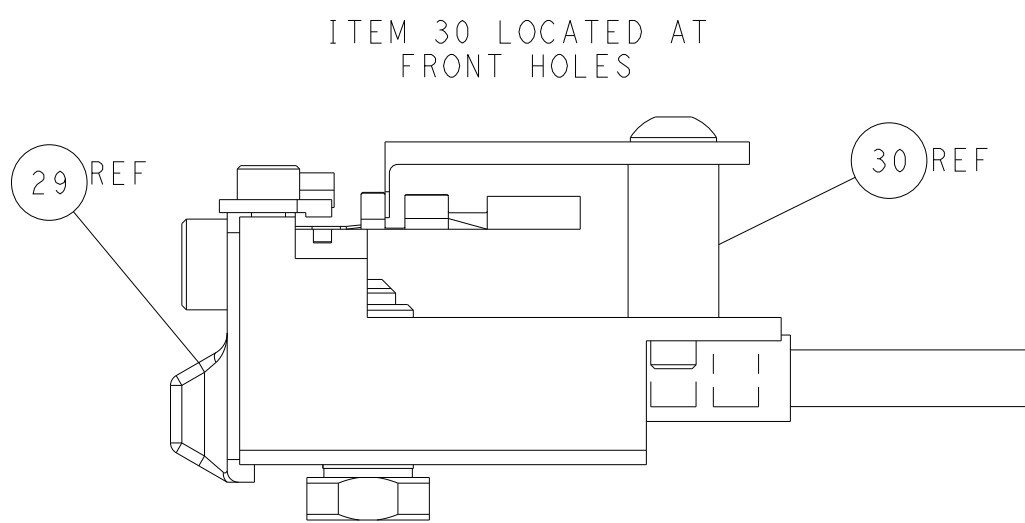
CAM POSITIONS



TERMINAL SUPPORT LOCATION



RAM SET-UP



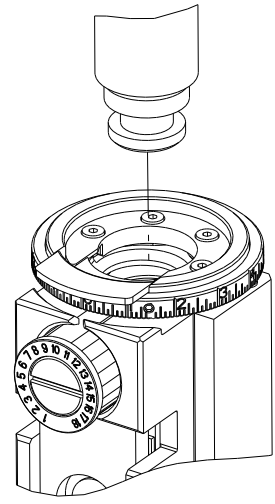
FEED TRACK POSITION
GUIDE BY INSULATION BARREL

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

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN BOB HIGMAN 08MAR2012		CHK T. ELBIN 08MAR2012		APVD M. CLIFFORD 08MAR2012		NAME Ocean Side Feed Applicator	
mm		0 PLC ±		1 PLC ±		2 PLC ±		3 PLC ±		4 PLC ±	
MATERIAL		FINISH		WEIGHT		SIZE		CAGE CODE		DRAWING NO	
-		-		-		A1		00779		C=2151463	
Customer Accessible Production Drawing		SCALE		1:2		SHEET		2 of 4		REV	
										J	

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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2151463-1	J	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2151463-2	J	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151463-7	E	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.01 mm [.079]	F
INSUL	2.49 mm [.098]	O
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: FCI TERMINAL FORD CRIMP SPECIFICATION			
TERMINAL NAME: 2.80MM WIRE SNAP ON FEMALE TERMINAL			
WIRE STRIP LENGTH 4.71-4.72mm [.185-.186 IN]		INSULATION DIAMETER RANGE Ø 1.90 mm [.075 IN] MAX	
TERMINAL APPLICATION SPECIFICATION	FORD Rev A	-	-
TERMINALS APPLIED			
TE TERMINAL	FCI TERMINAL	TE TERMINAL	INTERLOCK TERMINAL
1572901-1	10757690	1572901-4	JTP 1811-29
1572901-8	54001802	1572901-9	JTP 1811-29G
1-1572901-5	54001839	1572901-3	JTP 1811-66AU
1832575-1	54001803	TE TERMINAL	DAIMLER CHRYSLER
TE TERMINAL	NON-CHRYSLER TERMINAL	1572901-7	04687767
1572901-6	JS-1811-29	1-1572901-1	04707172
1-1572901-0	JS-1811-29G	1-1572901-3	04667819
1-1572901-2	JS-1811-66AU	TE TERMINAL	DELPHI PACKARD
TE TERMINAL	FORD TERMINAL	1-1572901-4	10890230
1572901-5	F8V8-14474-BA	1-1572901-6	15512735
		1-1572901-7	54001800

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.00mm2	1.40+/-0.05 [.055+/- .002]	7.8
18 AWG	1.35+/-0.05 [.053+/- .002]	8.3
0.75mm2	1.30+/-0.05 [.051+/- .002]	8.9
0.50mm2	1.25+/-0.05 [.049+/- .002]	9.3



- 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 CUT TO LENGTH AT ASSEMBLY.
- 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.

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

LOC	DIST	REVISONS			
A	66	P	LTR	DESCRIPTION	DATE
		-		SEE SHEET 1	-

	-	1	1	2119082-4	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
6	-	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	318563-1	GUARD, FRONT CHIP	89
	-	1	1	455888-6	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	1338685-1	PAWL, FEED	56
5	-	2	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	53
	-	1	1	5018030-1	NUT, HEX, REG, RoHS, M3	52
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	-	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	2-2844962-3	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	1-356885-3	STOP, SHEAR	11
1	-	1	1	2119805-1	SHEAR HOLDER, FRONT	10
1	-	1	1	1803095-6	FLOATING SHEAR, FRONT	9
1	1	1	1	1633932-4	ANVIL, COMBINATION	8
	-	-	-	-	-	7
	-	-	-	-	-	6
	-	1	1	2119757-8	DEPRESSOR, SHEAR	5
	-	1	1	2-238011-1	BLOCK, CRIMPER SPACER	4
1	1	1	1	1-1803018-1	CRIMPER, INSULATION O	3
	-	1	1	455888-4	SPACER, CRIMPER	2
1	1	1	1	3-1633305-2	CRIMPER, WIRE PREMIUM	1

-77	-22	-21	PART NO	DESCRIPTION	ITEM NO
THE DRAWING IS A CONTROLLED DOCUMENT AND ITS DISTRIBUTION OUTSIDE THE ORGANIZATION IT IS SUBJECT TO CONTROLLED DOCUMENT AND DISTRIBUTION ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST EDITION.			DWN BOB HIGMAN 08MAR2012 CHK T.ELBIN 08MAR2012 APVD M.CLIFFORD 08MAR2012	STE TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm			PRODUCT SPEC	NAME Ocean Side Feed Applicator	
TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH			APPLICATION SPEC	SIZE A	
MATERIAL -			WEIGHT -	CAGE CODE 00779	
Customer Accessible Production Drawing			SCALE 1:2	SHEET 3	REV J

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

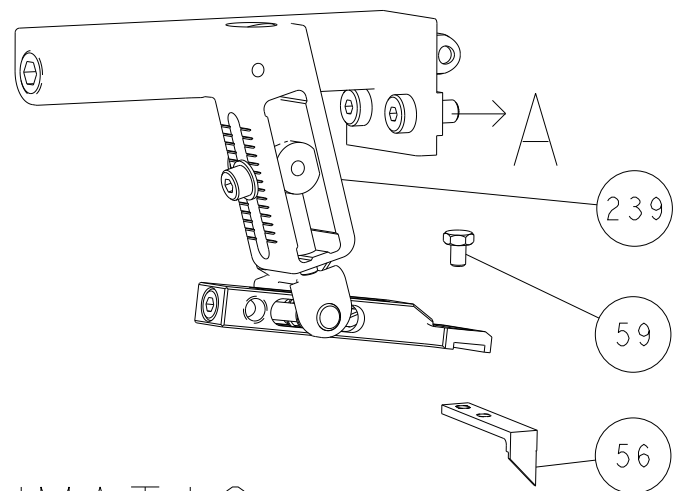
D

C

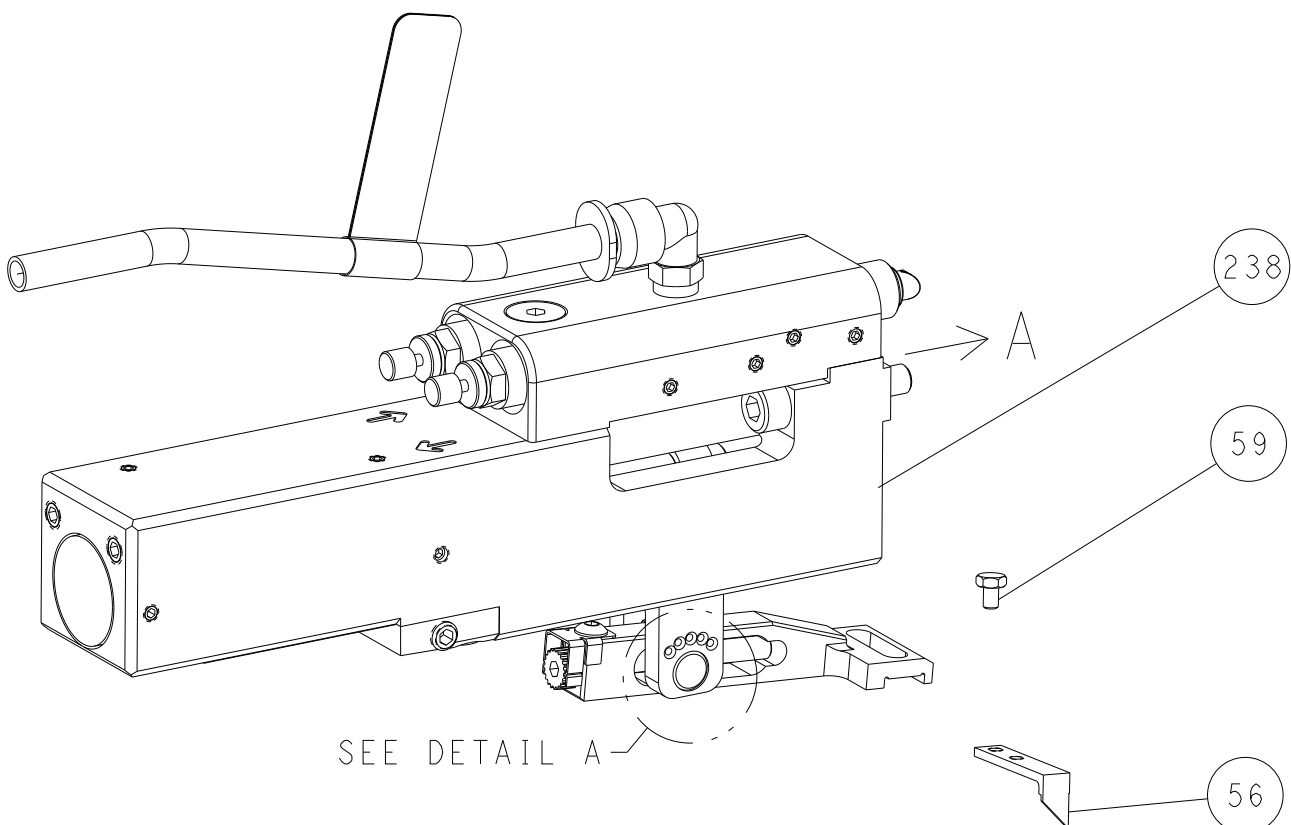
B

A

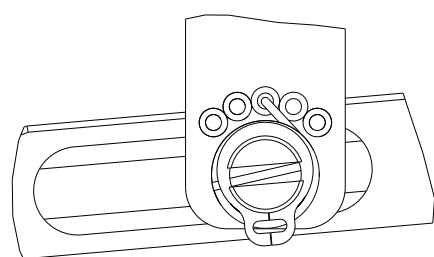
FEED TYPE MECHANICAL



PNEUMATIC

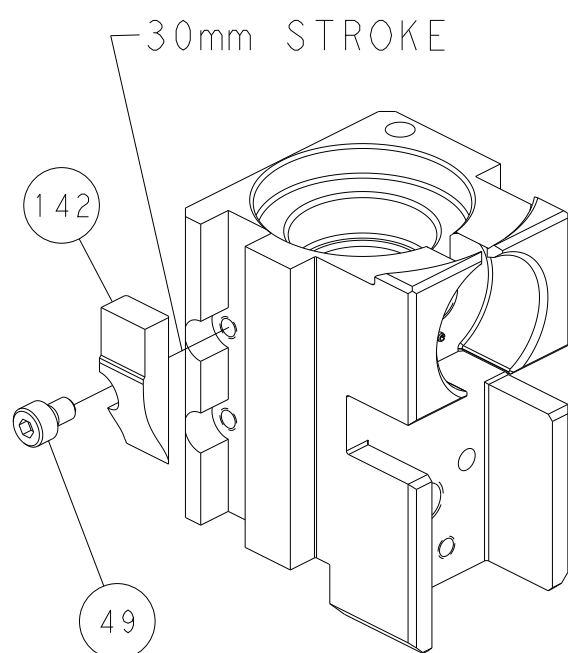


FEED SPRING SETTING POSITION
(SHOWN FROM REAR SIDE)

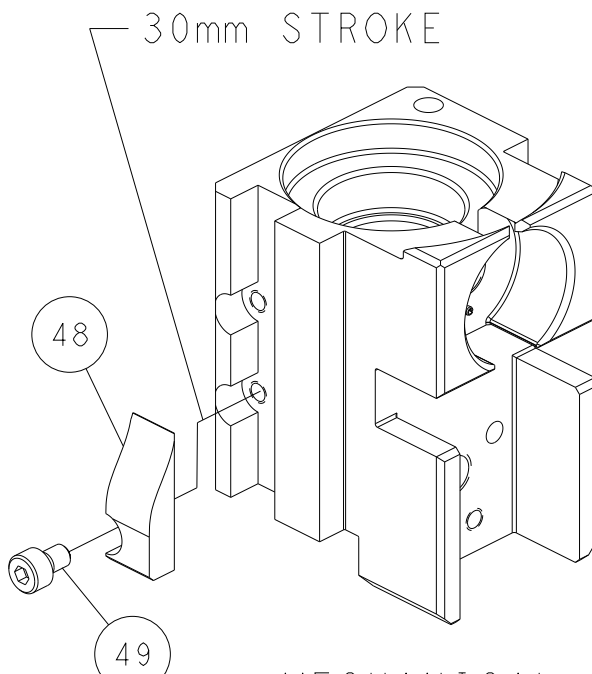


DETAIL A

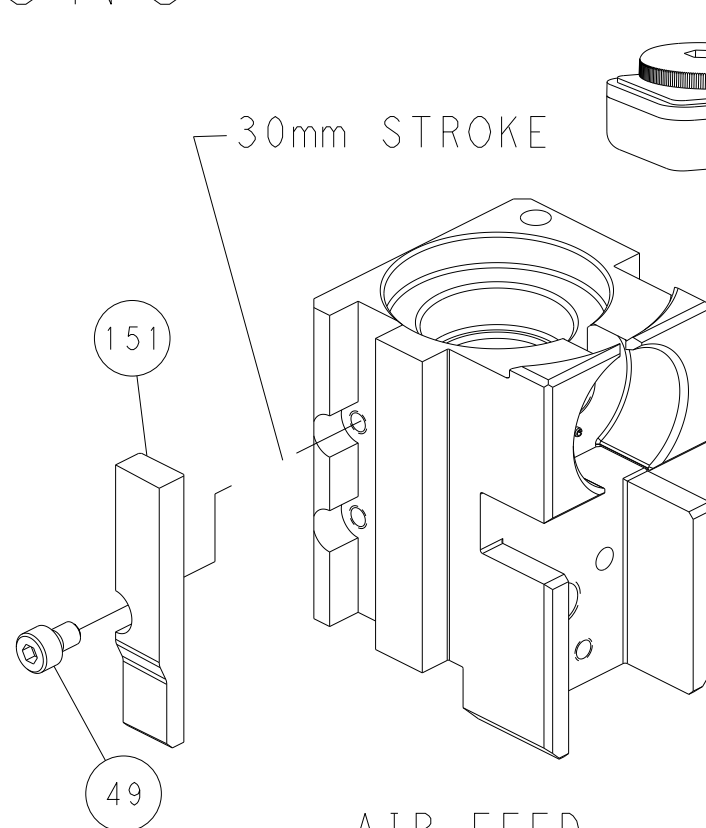
CAM POSITIONS



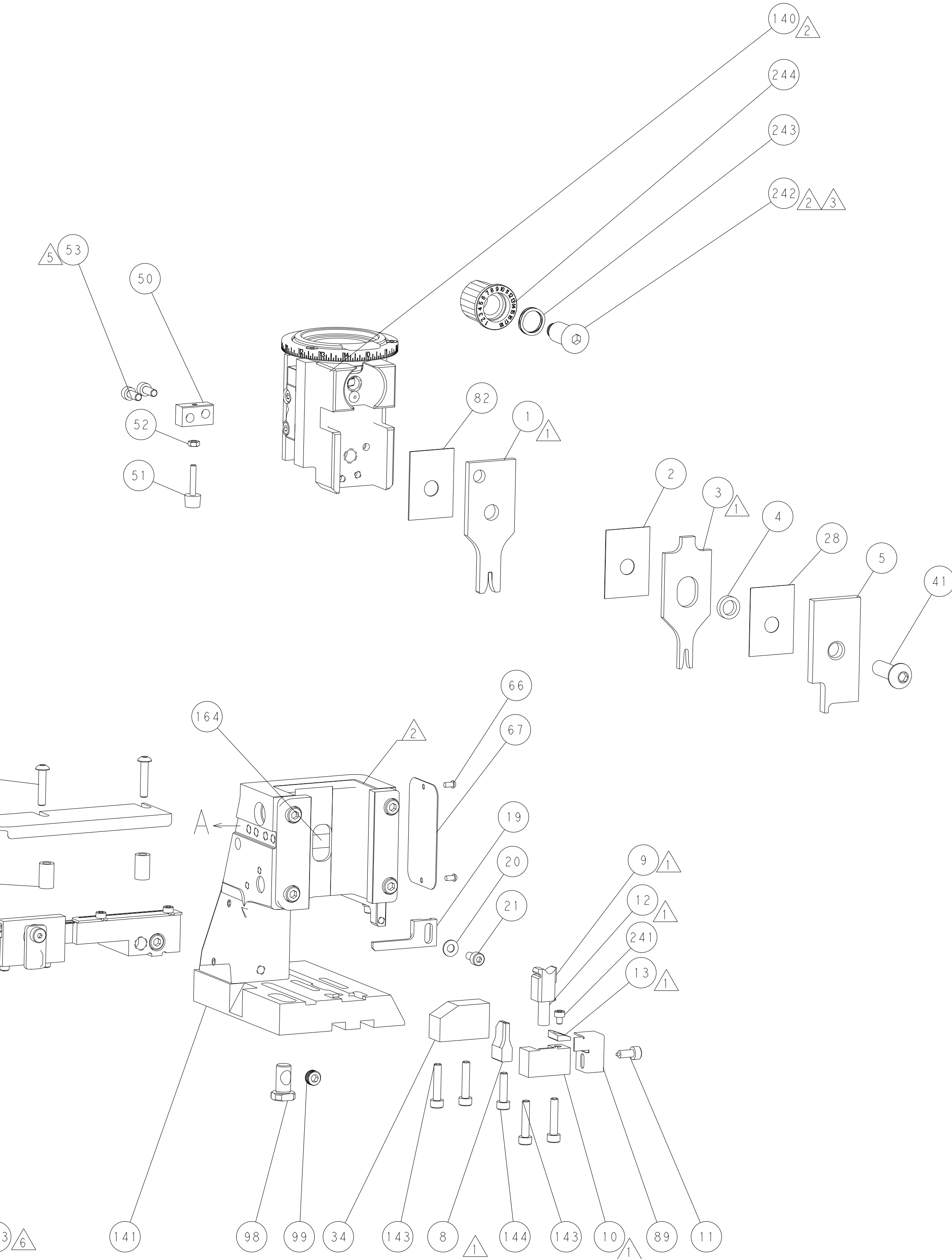
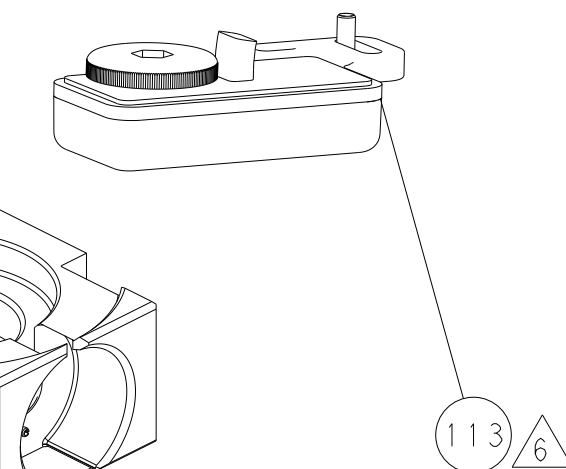
MECHANICAL
POST FEED



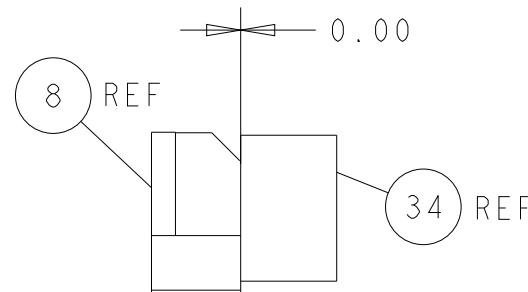
MECHANICAL
PRE FEED



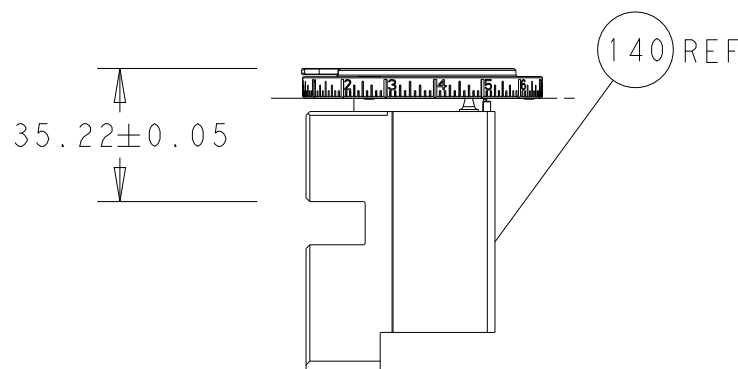
AIR FEED



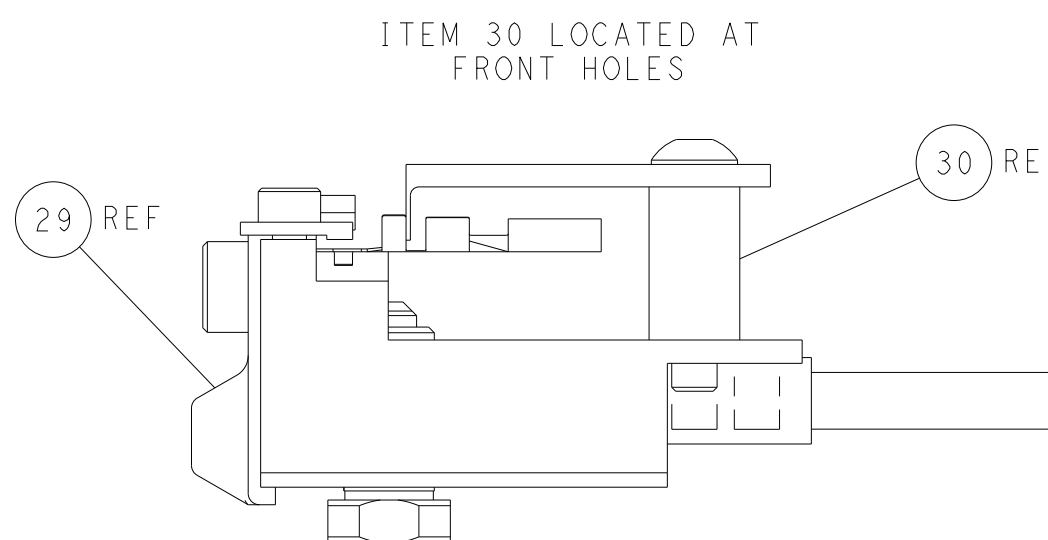
PACIFIC VERSION
Shown on sheets 3 of 4 & 4 of 4
(Atlantic version shown on sheets 1 of 4 & 2 of 4)



TERMINAL SUPPORT LOCATION



RAM SET-UP



FEED TRACK POSITION
GUIDE BY INSULATION BARREL

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DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		NAME		Ocean Side Feed Applicator	
mm				PRODUCT SPEC			
		0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH		APPLICATION SPEC		RESTRICTED TO	
MATERIAL				WEIGHT		SIZE CAGE CODE DRAWING NO	
-		-		-		A 00779 C=2151463	
Customer Accessible Production Drawing				SCALE 1:2		SHEET 4 OF 4 REV J	

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

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