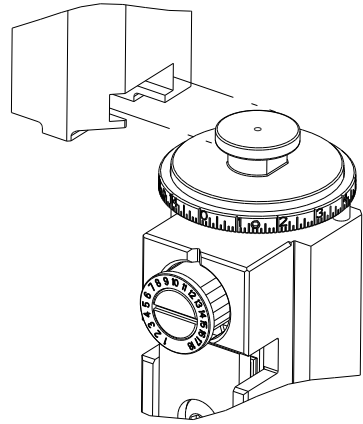


8		7	
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20		20	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151984-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2151984-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151984-1	C	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2151984-2	C	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2151984-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.38 mm [.054]	F
INSUL	1.75 mm [.069]	O
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: BOSCH TERMINAL		BOSCH CRIMP SPECIFICATION	
TERMINAL NAME: TERMINAL MATRIX 1.2			
WIRE STRIP LENGTH 3.20-3.80 mm [.126-.150 IN]		 INSULATION DIAMETER RANGE Ø1.20-1.60 mm [.047-.063 IN]	
TERMINAL APPLICATION SPECIFICATION		1928A0047M-EN	
APPLICATION SPECIFICATION		- - -	
TERMINALS APPLIED			
TE TERMINAL	BOSCH TERMINAL	TE TERMINAL	BOSCH TERMINAL
2113273-1	1928498131	2113351-1	1928498676
2113273-2	1928498134	2113351-2	1928498673
2113273-3	1928498137	2113351-3	1928498679

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.50mm2	0.88+/-0.03 [.035+/-0.011]	7.5
0.35mm2	0.83+/-0.03 [.033+/-0.011]	8.0



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. 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)

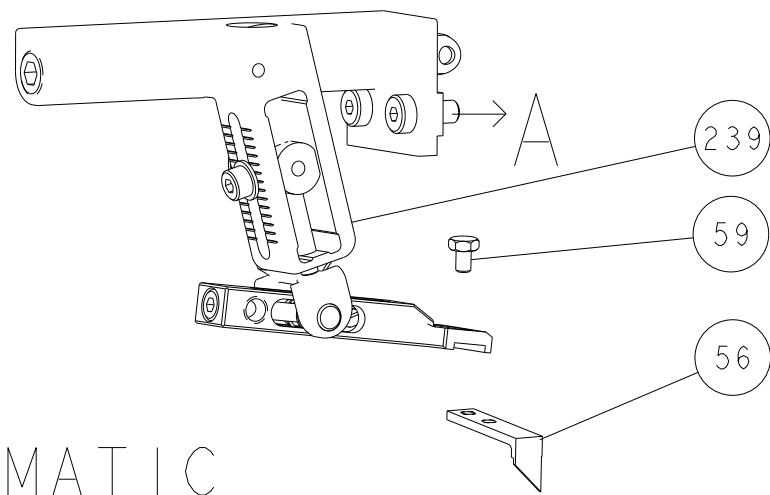
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LOC	DIST	REVISIONS							
A	66	P	LTR	DESCRIPTION			DATE	DWN	APVD
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		B		ECR-18-018133			20NOV2018	MZ	KZ
		C		ECR-21-124373			16DEC2021	FJ	RK

-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248
-	1	1	1	1	2119082-5	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	2844908-1	SCREW, LOCKING	99
-	1	1	1	1	455888-5	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	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	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	3-1752356-3	SUPPORT, TERMINAL	34
-	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	2	2	2-2844962-6	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29
-	1	1	1	1	1-455888-0	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
-	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	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	1803095-1	FLOATING SHEAR, FRONT	9
1	2	2	1	1	5-1633927-0	ANVIL, COMBINATION	8
-	1	1	1	1	240641-4	SPACER	7
-	-	-	-	-	-	-	6
-	1	1	1	1	1-2119780-1	DEPRESSOR, SHEAR	5
-	1	1	1	1	238011-4	BLOCK, CRIMPER SPACER	4
1	2	2	1	1	2-1803018-2	CRIMPER, INSULATION O	3
-	1	1	1	1	455888-7	SPACER, CRIMPER	2
1	2	2	1	1	2-1633305-2	CRIMPER, WIRE PREMIUM	1
-77	-72	-71	-2	-1	PART NO	DESCRIPTION	ITEM NO

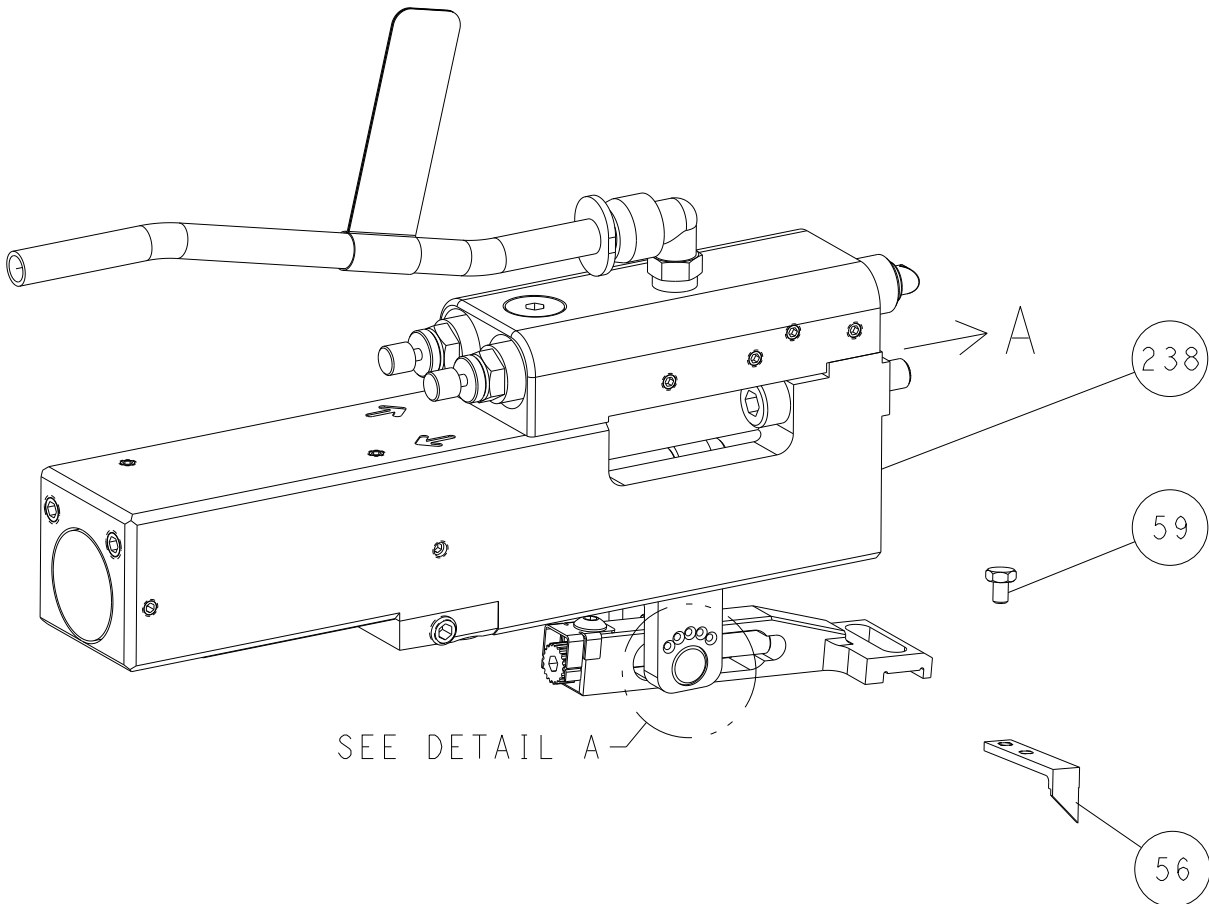
THIS DOCUMENT IS TO REMAIN UNPUBLISHED FOR THE ENTIRE LIFE OF THE PRODUCT. IT IS SUBJECT TO CHANGE WITHOUT NOTICE AND WITHOUT NOTICE TO THE USER. IT IS SUBJECT TO CHANGE WITHOUT NOTICE AND WITHOUT NOTICE TO THE USER. IT IS SUBJECT TO CHANGE WITHOUT NOTICE AND WITHOUT NOTICE TO THE USER.				DWN BOB HIGMAN 14JUN2013	TE Connectivity Harrisburg, PA 17105-3608			
DIMENSIONS:				CHK T.ELBIN 14JUN2013	NAME			
mm				APVD M.CLIFFORD 14JUN2013	Ocean Side Feed Applicator			
TOLERANCES UNLESS OTHERWISE SPECIFIED:				PRODUCT SPEC	SIZE			
0 PLC ±.005				APPLICATION SPEC	CAGE CODE			
1 PLC ±.005				WEIGHT	DRAWING NO			
2 PLC ±.005				RESTRICTED TO	00779			
3 PLC ±.005				SCALE	1:2			
4 PLC ±.005				SHEET	1 OF 4			
ANGLES FINISH				REV	C			
MATERIAL				Customer Accessible Production Drawing				

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

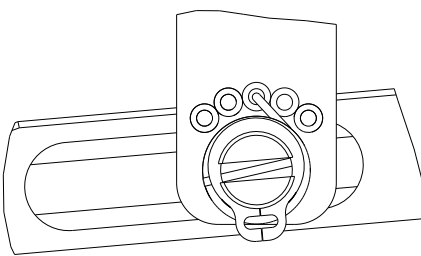
FEED TYPE
MECHANICAL



PNEUMATIC

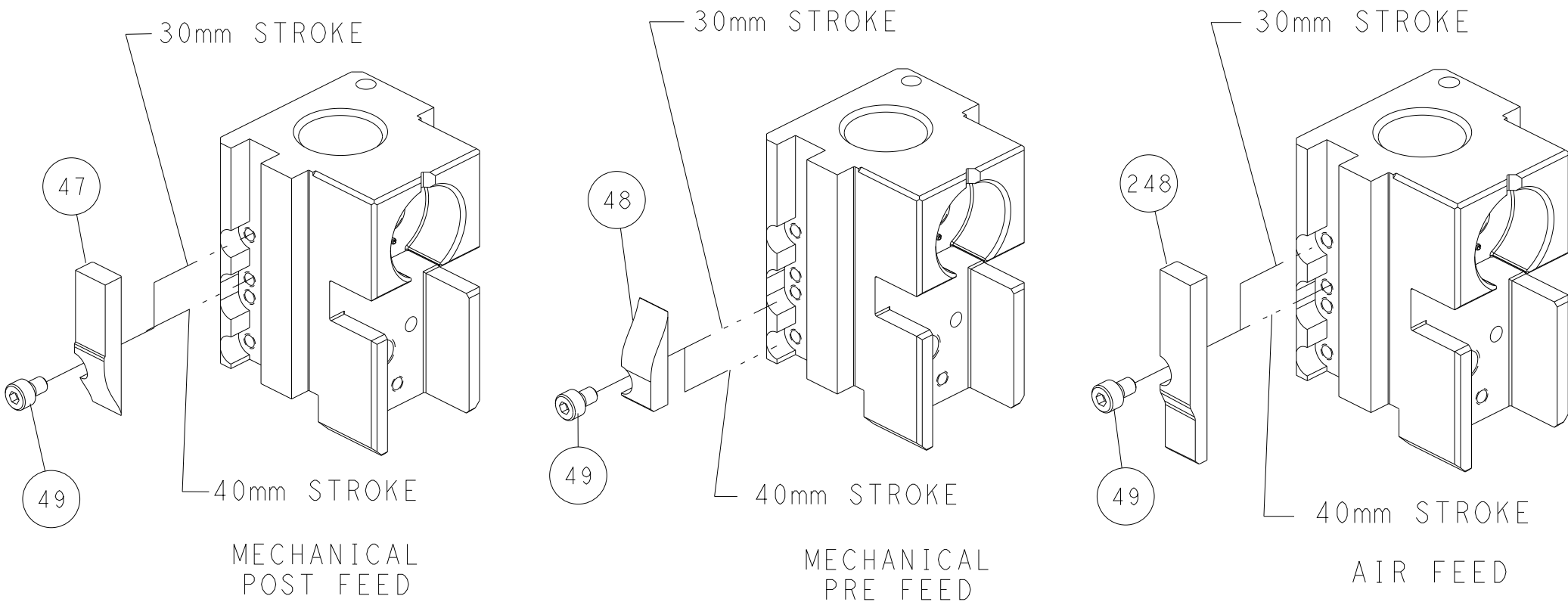


FEED SPRING SETTING POSITION
(SHOWN FROM REAR SIDE)

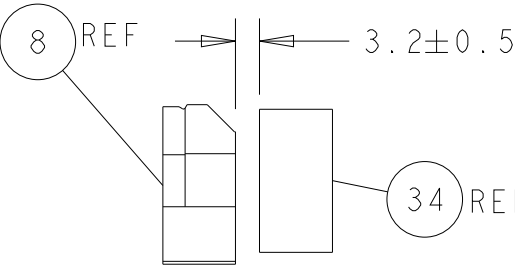
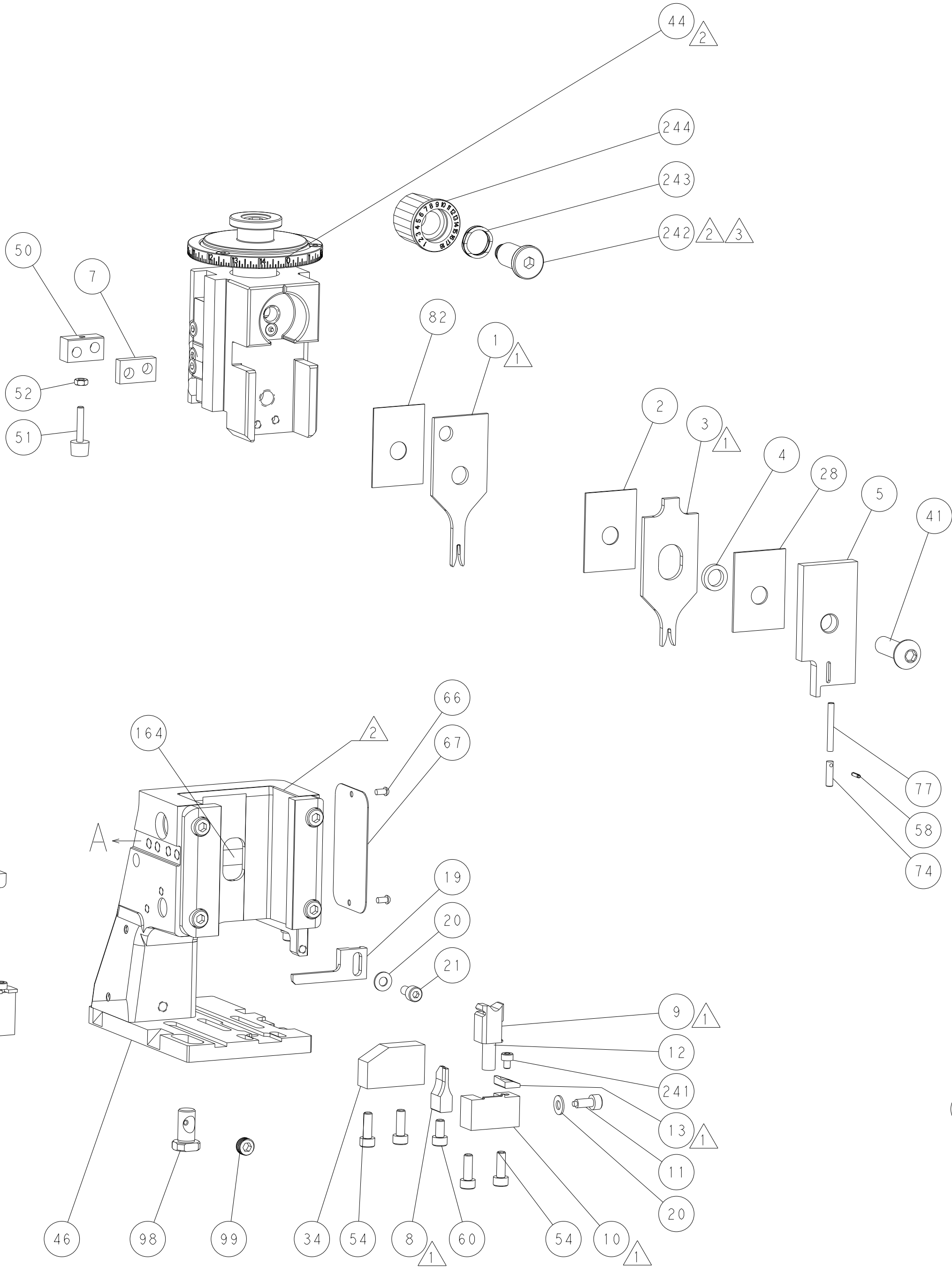


DETAIL A

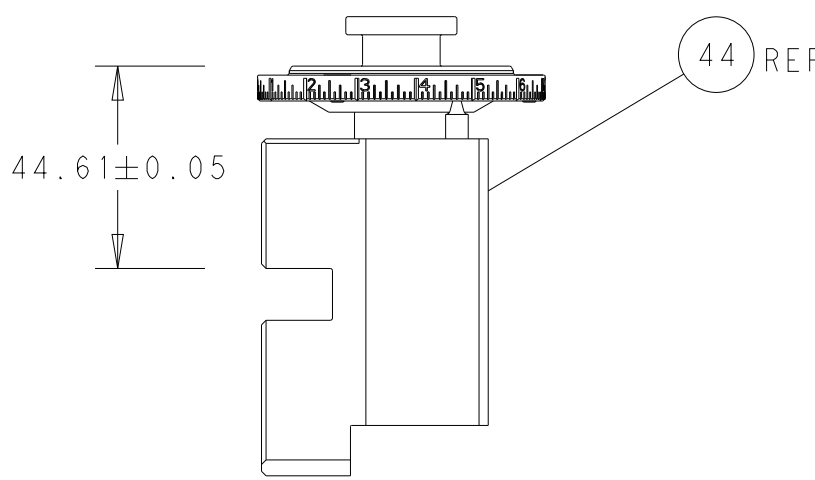
CAM POSITIONS



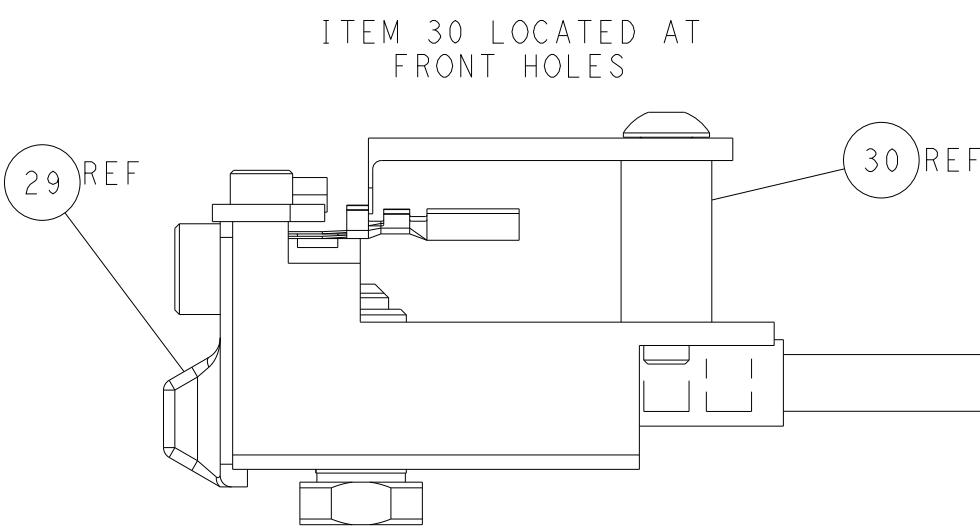
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)



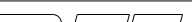
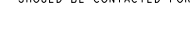
TERMINAL SUPPORT LOCATION



RAM SET-UP

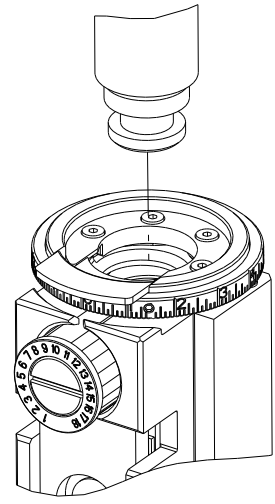


FEED TRACK POSITION
GUIDE BY INSULATION BARREL

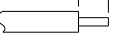
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DIMENSIONS: mm 										CHK		T. ELBIN		14JUN2013				NAME	
										APVD		M. CLIFFORD		14JUN2013				NAME	
										APPLICATION SPEC		SIZE		CAGE CODE		DRAWING NO		RESTRICTED TO	
MATERIAL										WEIGHT		A 00779		C = 2151984					

8		7	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2151984-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2151984-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151984-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.38 mm [.054]	F
INSUL	1.75 mm [.069]	O
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: BOSCH TERMINAL		BOSCH CRIMP SPECIFICATION	
TERMINAL NAME: TERMINAL MATRIX 1.2			
WIRE STRIP LENGTH 3.20-3.80 mm [.126-.150 IN]		 INSULATION DIAMETER RANGE Ø1.20-1.60 mm [.047-.063 IN]	
TERMINAL APPLICATION SPECIFICATION		1928A0047M-EN	
-		-	
-		-	
TERMINALS APPLIED			
TE TERMINAL	BOSCH TERMINAL	TE TERMINAL	BOSCH TERMINAL
2113273-1	1928498131	2113351-1	1928498676
2113273-2	1928498134	2113351-2	1928498673
2113273-3	1928498137	2113351-3	1928498679

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING	
0.50mm2		0.88+/-0.03 [.035+/- .001]		7.5	
0.35mm2		0.83+/-0.03 [.033+/- .001]		8.0	



- 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.
5. 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	DWN
					-	SEE SHEET 1		-	-

-	1	1	2119082-5	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	2844908-1	SCREW, LOCKING	99
-	1	1	2844907-1	POST, LOCKING	98
-	1	1	455888-5	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	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	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	3-1752356-3	SUPPORT, TERMINAL	34
-	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	2-2844962-6	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29
-	1	1	1-455888-0	SPACER, CRIMPER	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	5-1633927-0	ANVIL, COMBINATION	8
-	1	1	240641-4	SPACER	7
-	-	-	-	-	6
-	1	1	1-2119780-1	DEPRESSOR, SHEAR	5
-	1	1	238011-4	BLOCK, CRIMPER SPACER	4
1	1	1	2-1803018-2	CRIMPER, INSULATION O	3
-	1	1	455888-7	SPACER, CRIMPER	2
1	1	1	2-1633305-2	CRIMPER, WIRE PREMIUM	1

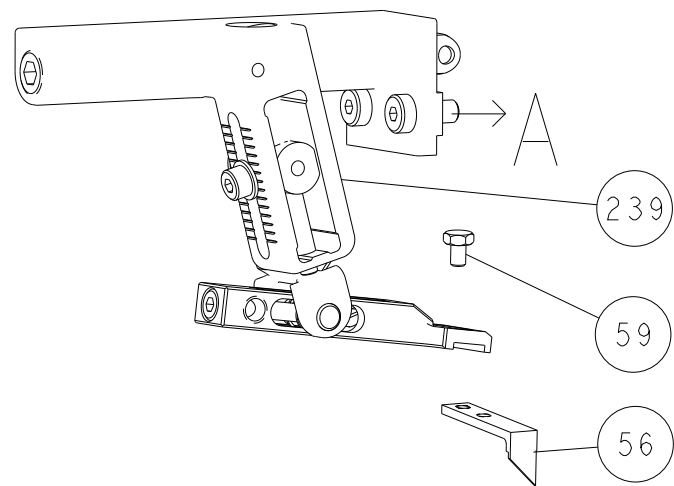
-77	-22	-21	PART NO	DESCRIPTION		ITEM NO
			OWN BOB HIGMAN CHK T.ELBIN APVD M.CLIFFORD	TE Connectivity Harrisburg, PA 17105-3608		
			NAME Ocean Side Feed Applicator			
			SIZE A	CAGE CODE 00779	DRAWING NO C=2151984	RESTRICTED TO -
			WEIGHT -	Customer Accessible Production Drawing		
			SCALE 1:2	SHEET 3	OF 4	REV C

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

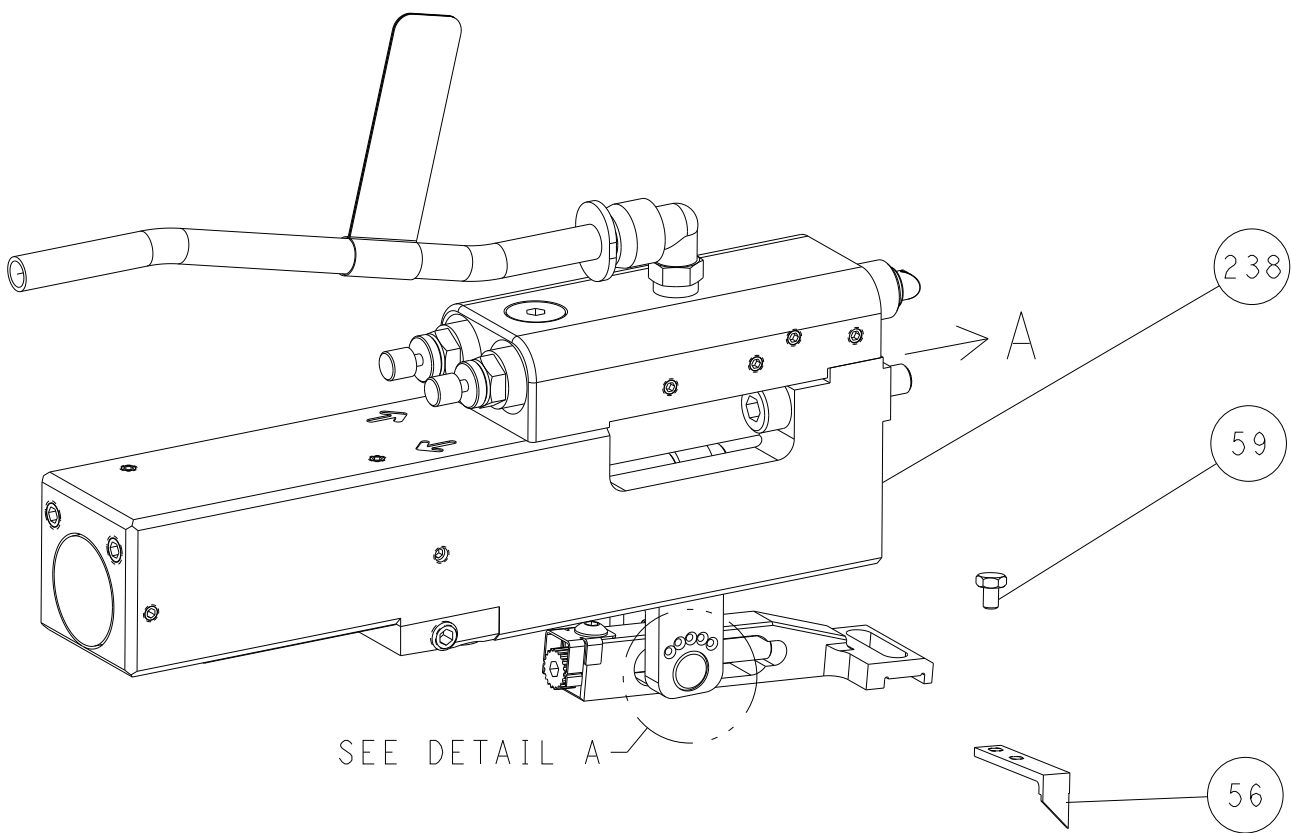
LOC		DIST		REVISIONS				
A	66	P	LTR	DESCRIPTION	DATE	DWN	APVD	
		-	-	SEE SHEET 1	-	-	-	

FEED TYPE

MECHANICAL

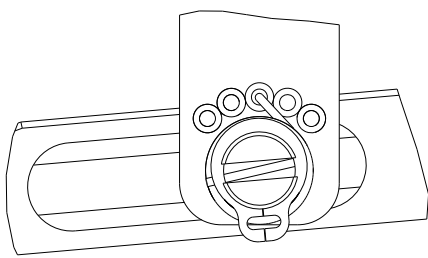


PNEUMATIC



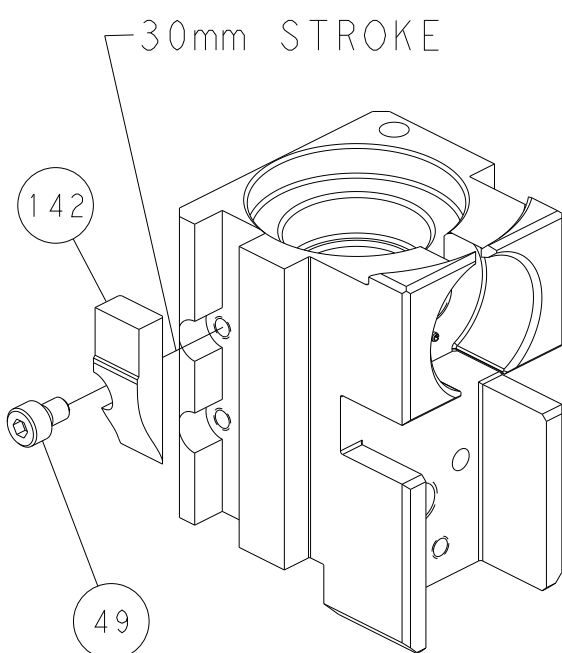
FEED SPRING SETTING POSITION

(SHOWN FROM REAR SIDE)



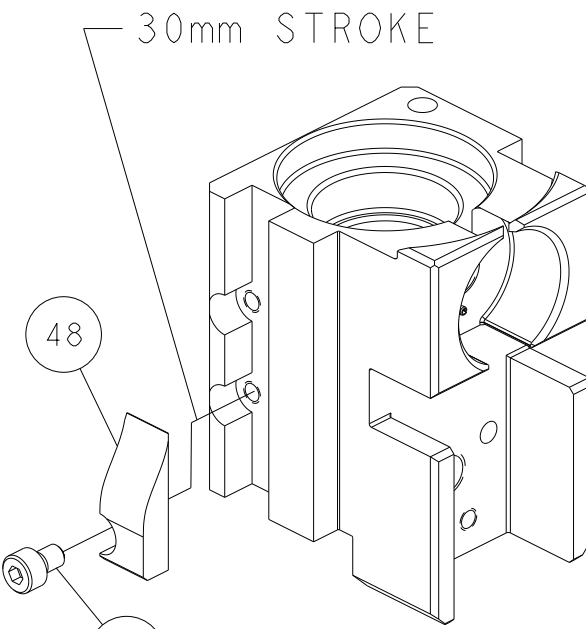
DETAIL A

CAM POSITIONS



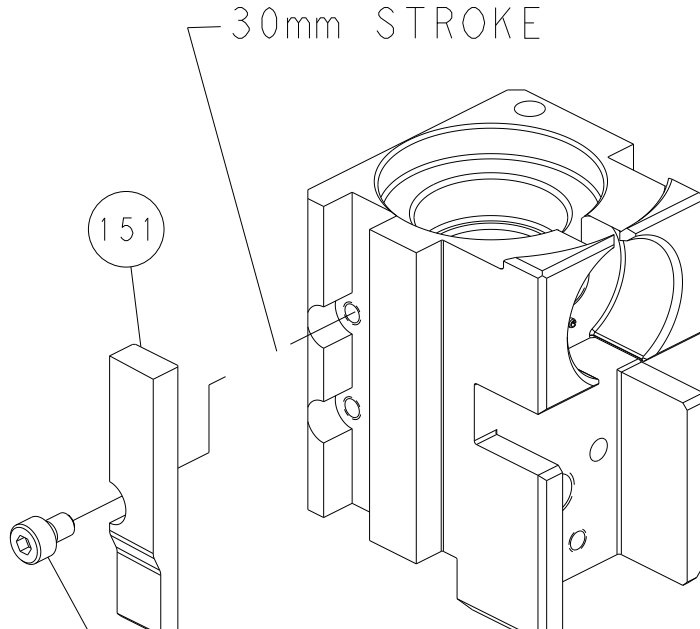
MECHANICAL

POST FEED

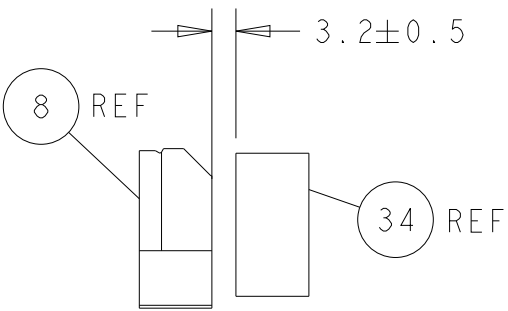
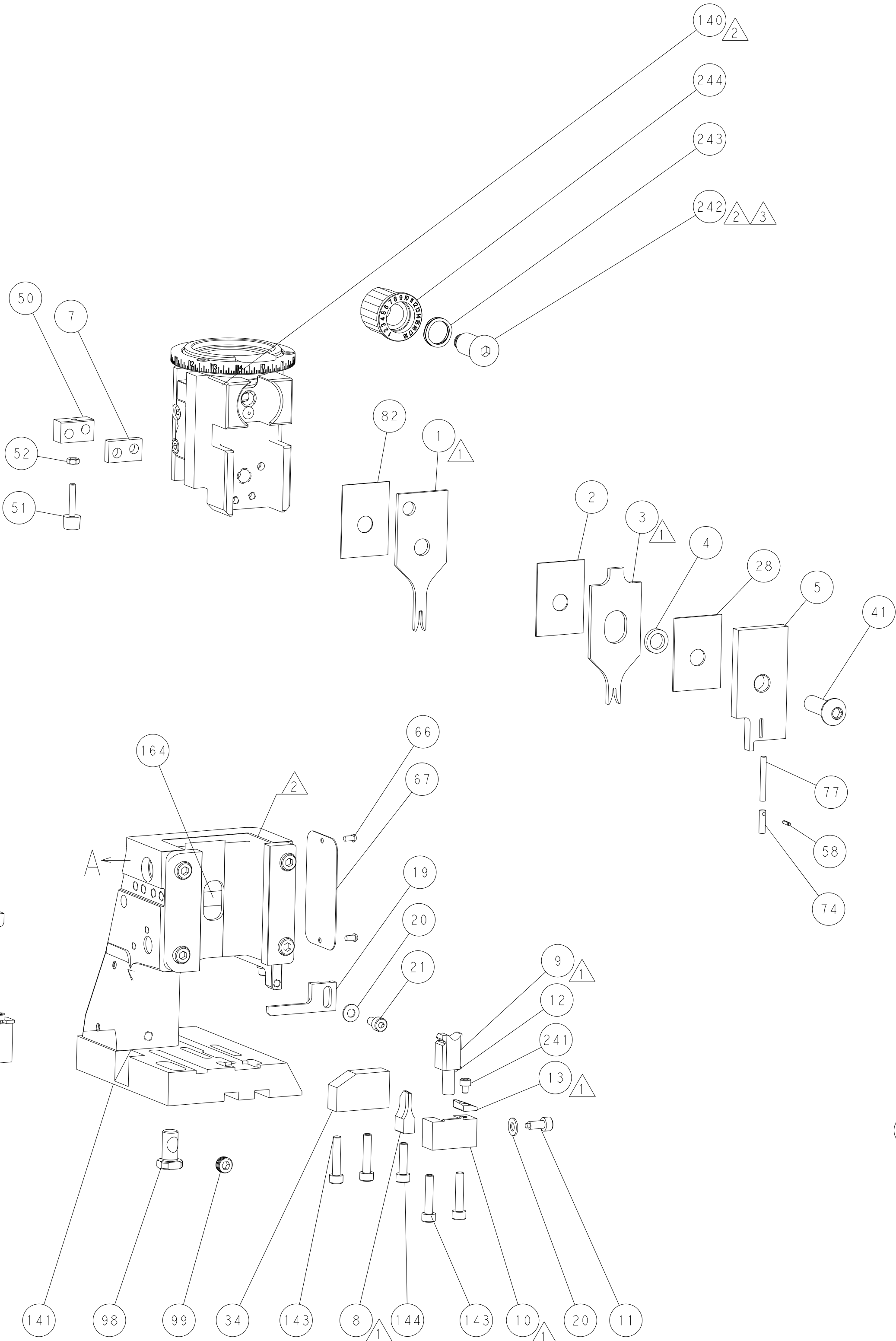
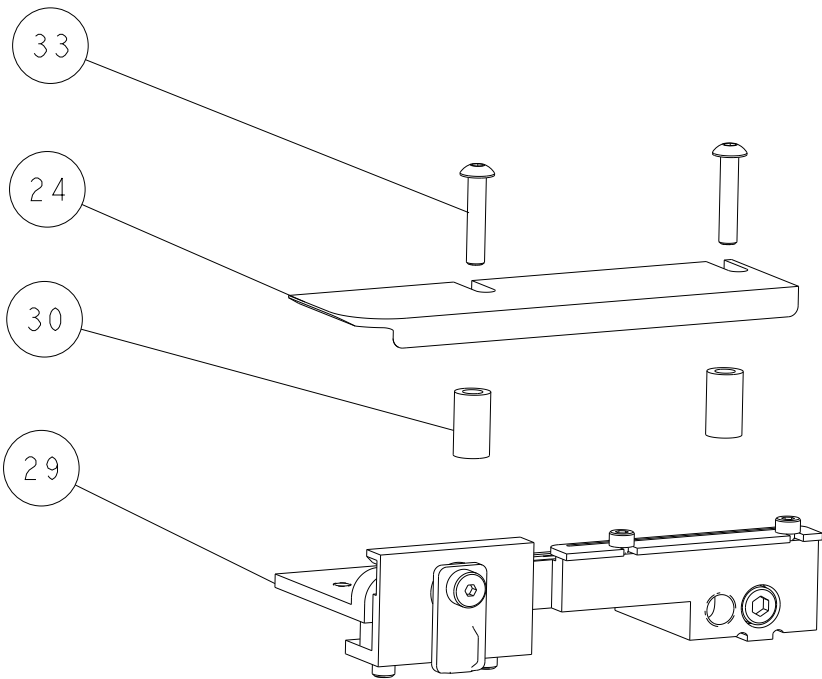


MECHANICAL

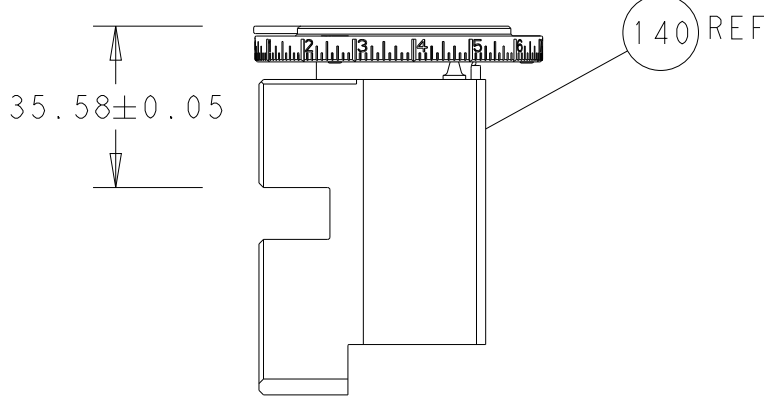
PRE FEED



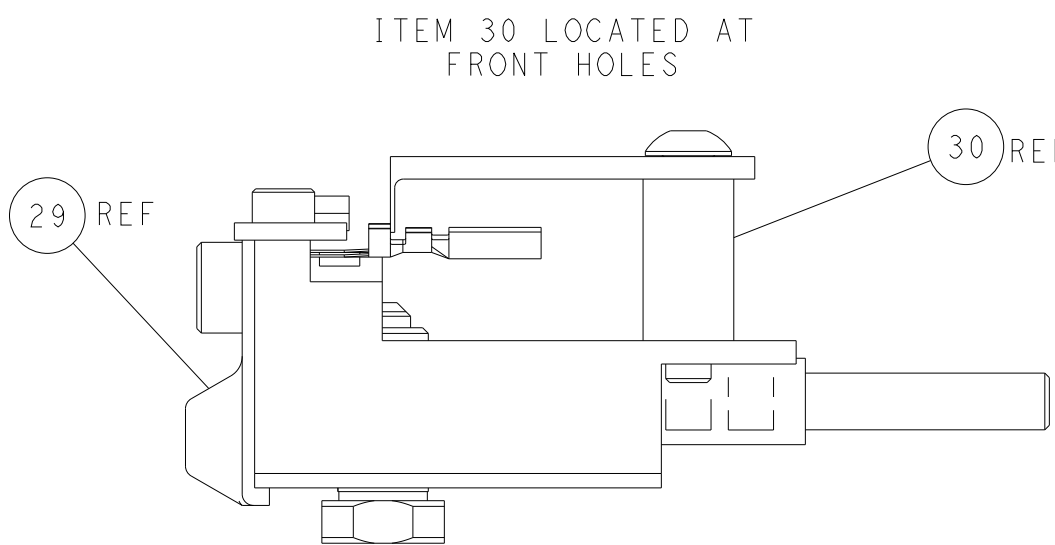
AIR FEED



TERMINAL SUPPORT LOCATION



RAM SET-UP



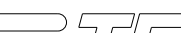
FEED TRACK POSITION

GUIDE BY INSULATION BARREL

PACIFIC VERSION

Shown on sheets 3 of 4 & 4 of 4

(Atlantic version shown on sheets 1 of 4 & 2 of 4)

THE DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. ANY CHANGES TO THIS DRAWING SHOULD BE CONTACTED FOR THE LATEST VERSION.										DWN		14JUN2013		 TE Connectivity Harrisburg, PA 17105-3608																																					
										BOB HIGMAN		14JUN2013																																							
										CHK		T.ELBIN				14JUN2013																																			
										APVD		M. CLIFFORD				14JUN2013																																			
										PRODUCT SPEC						NAME																																			
DIMENSIONS:										TOLERANCES UNLESS OTHERWISE SPECIFIED:						Ocean Side Feed																																			
mm																Applicator																																			
										0 PLC ±.1						SIZE				CASE CODE				DRAWING NO				RESTRICTED TO																							
										1 PLC ±.1																																									
										2 PLC ±.1																																									
										3 PLC ±.1																																									
										4 PLC ±.1																																									
ANGLES										±.1																																									
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SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

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