

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

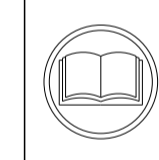
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE
3.70-4.50 mm [.146-.177 IN]	∅1.20-2.10 mm [.047-.083 IN]

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 <sup>2</sup>	1.36+/-0.05 [.053+/- .002]	4.6
0.75mm <sup>2</sup> or 18AWG	1.27+/-0.05 [.050+/- .002]	5.3
0.50mm <sup>2</sup>	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 A DIST 66

REV	DATE	DESCRIPTION	DATE	BY	APPV
G	21JUN2021	ECR-21-006398	21JUN2021	MEH	TE
H	17MAR2022	ECR-22-132838	17MAR2022	FJ	TE
H1	06MAY2023	ECR-23-174481	06MAY2023	FZ	JAH
H2	17AUG2023	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
3	-	-	-	1	1	-	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	181
-	-	-	-	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
5	-	1	1	1	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	1	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	1	2	2	1	1	1	3-2119784-1	CRIMPER, INSULATION O PREMIUM	3
-	1	1	1	1	1	1	455888-7	SPACER, CRIMPER	2
1	1	2	2	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	CHK	APPV	NAME	SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
mm	0 PLC ±	1 PLC ±	2 PLC ±	Y. YIN	G. BAILEY	S. XI	Ocean Side Feed Applicator	A1	00779	2151392	-
	3 PLC ±	4 PLC ±	ANGLES ±	02DEC2011		02DEC2011		02DEC2011		02DEC2011	
MATERIAL	FINISH	WEIGHT		Customer Accessible Production Drawing		SCALE	1:2	SHEET	1	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	

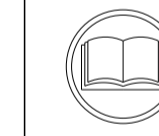
TERMINALS APPLIED

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 <sup>2</sup>	1.36+/-0.05 [.053+/- .002]	4.6
0.75mm <sup>2</sup> or 18AWG	1.27+/-0.05 [.050+/- .002]	5.3
0.50mm <sup>2</sup>	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
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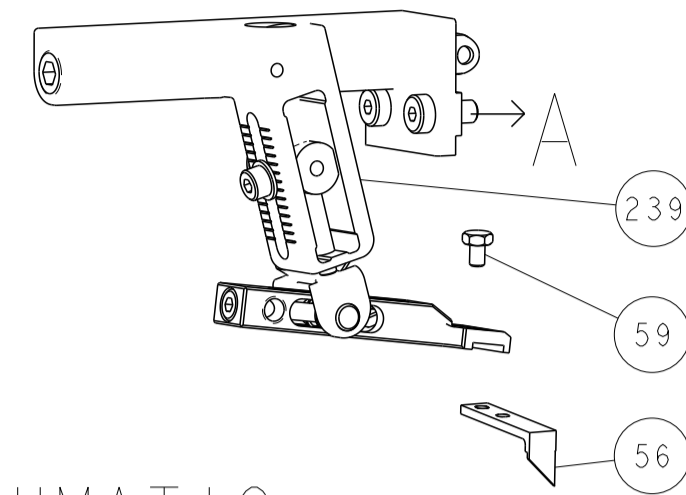
REV	DATE	BY	APPV	DESCRIPTION	ITEM NO
-	1	1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
-	-	-	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	1	-	2844940-1	AIR 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
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-	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	2-2844962-3	SPACER, CYLINDRICAL, STRIP GUIDE	30
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-	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)

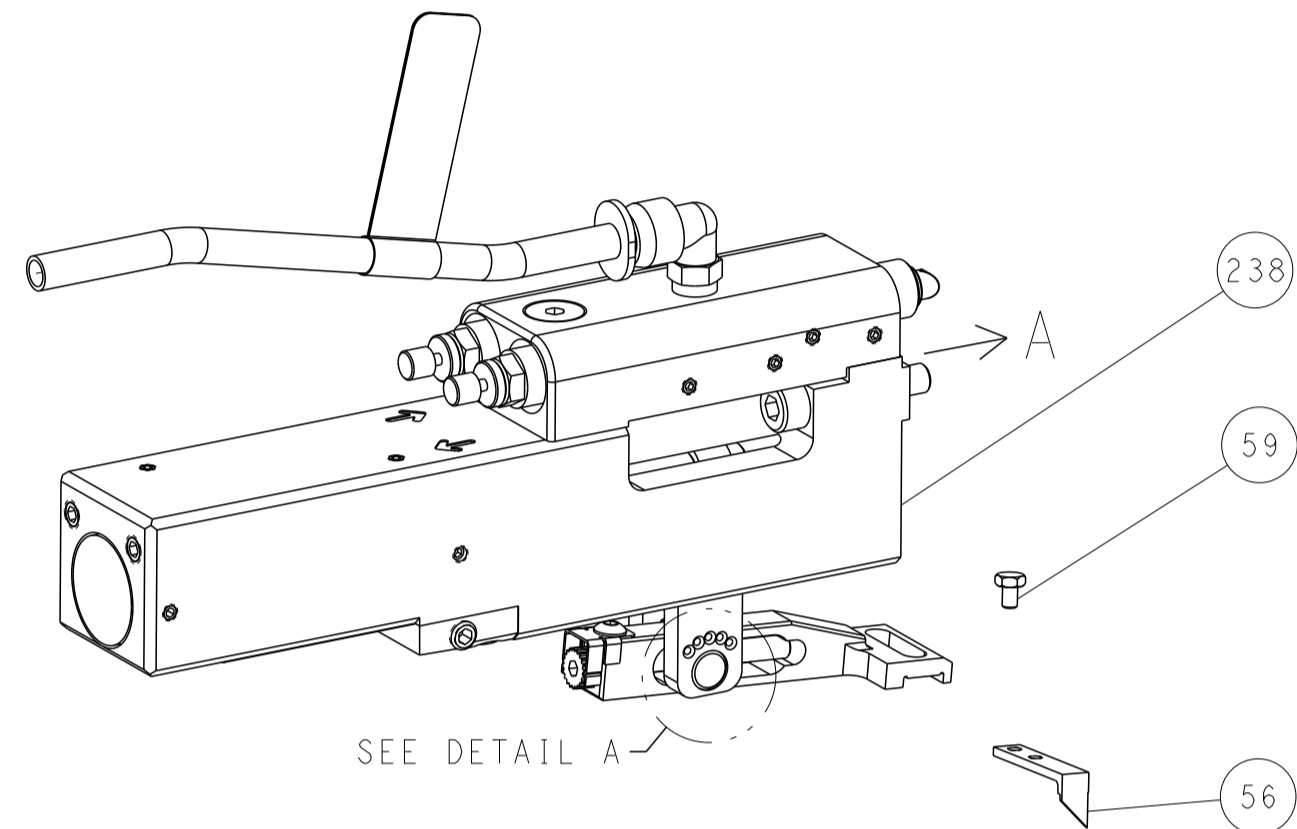
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG: Y.YIN 02DEC2011		CHK: G.BAILEY 02DEC2011		NAME: Ocean Side Feed Applicator	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	APVD: S.XI 02DEC2011	PRODUCT SPEC	SIZE: A1	CAGE CODE: 00779
MATERIAL:	FINISH:	WEIGHT:	SCALE: 1:2	SHEET: 3	OF: 4	REV: H2	Customer Accessible Production Drawing		

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

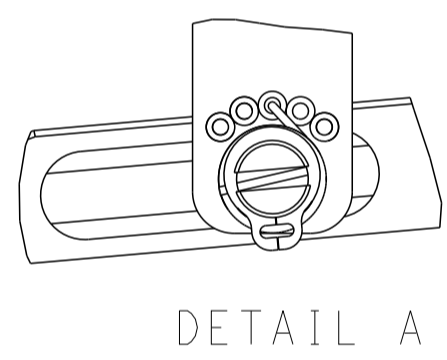
# FEED TYPE MECHANICAL



## PNEUMATIC

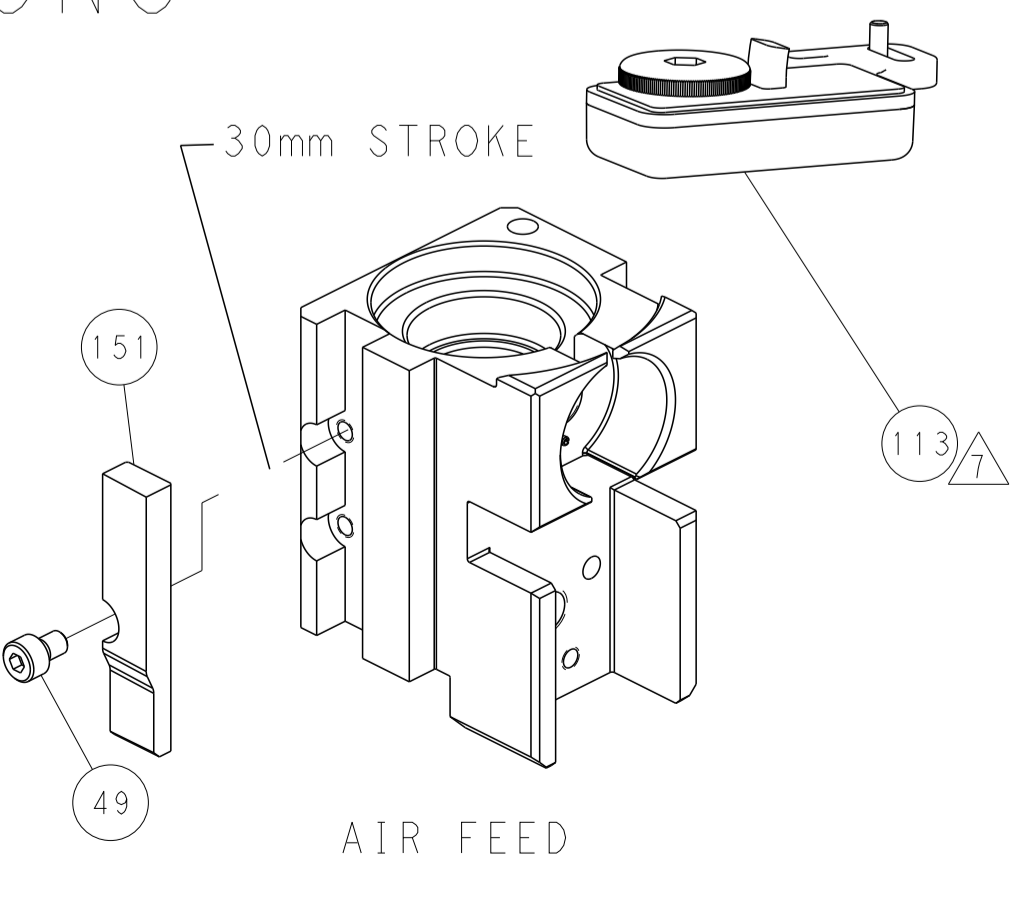
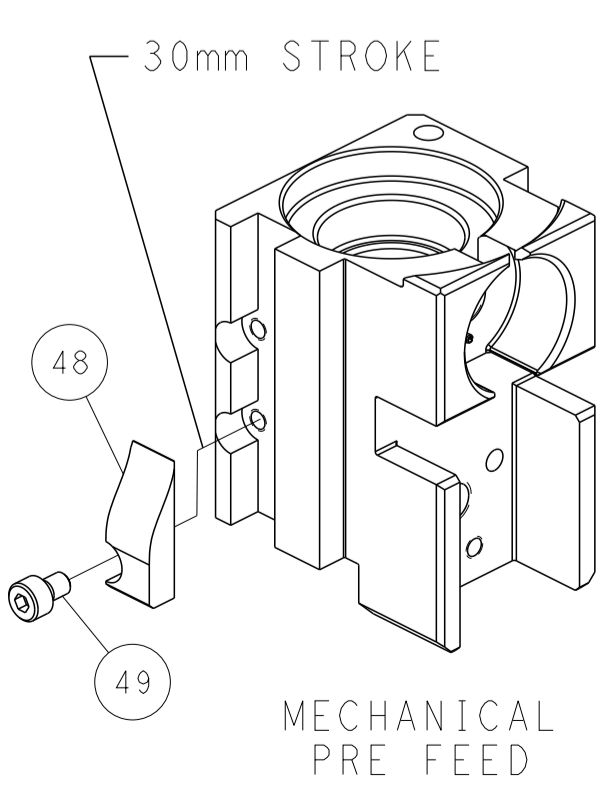
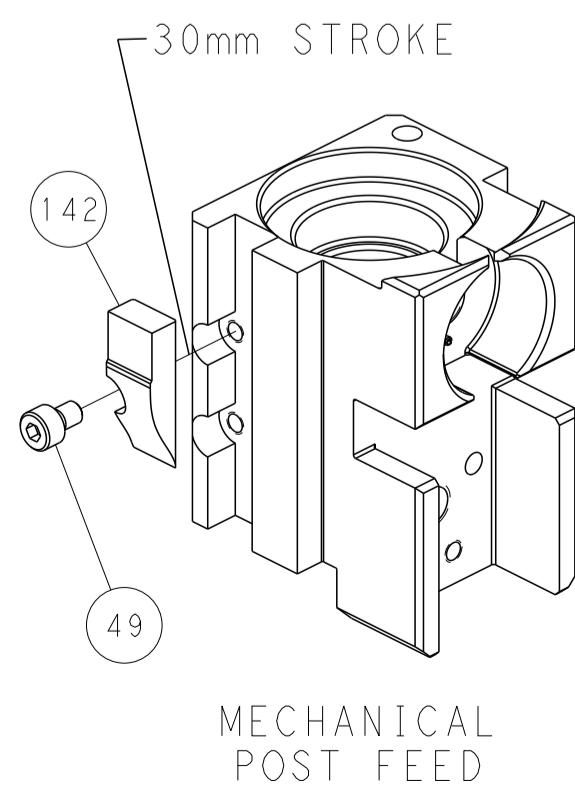


## FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)

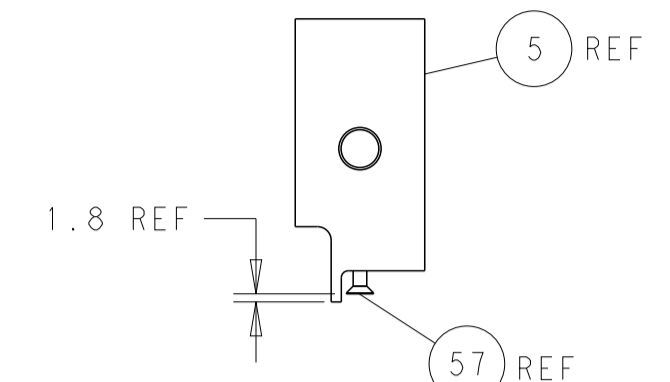
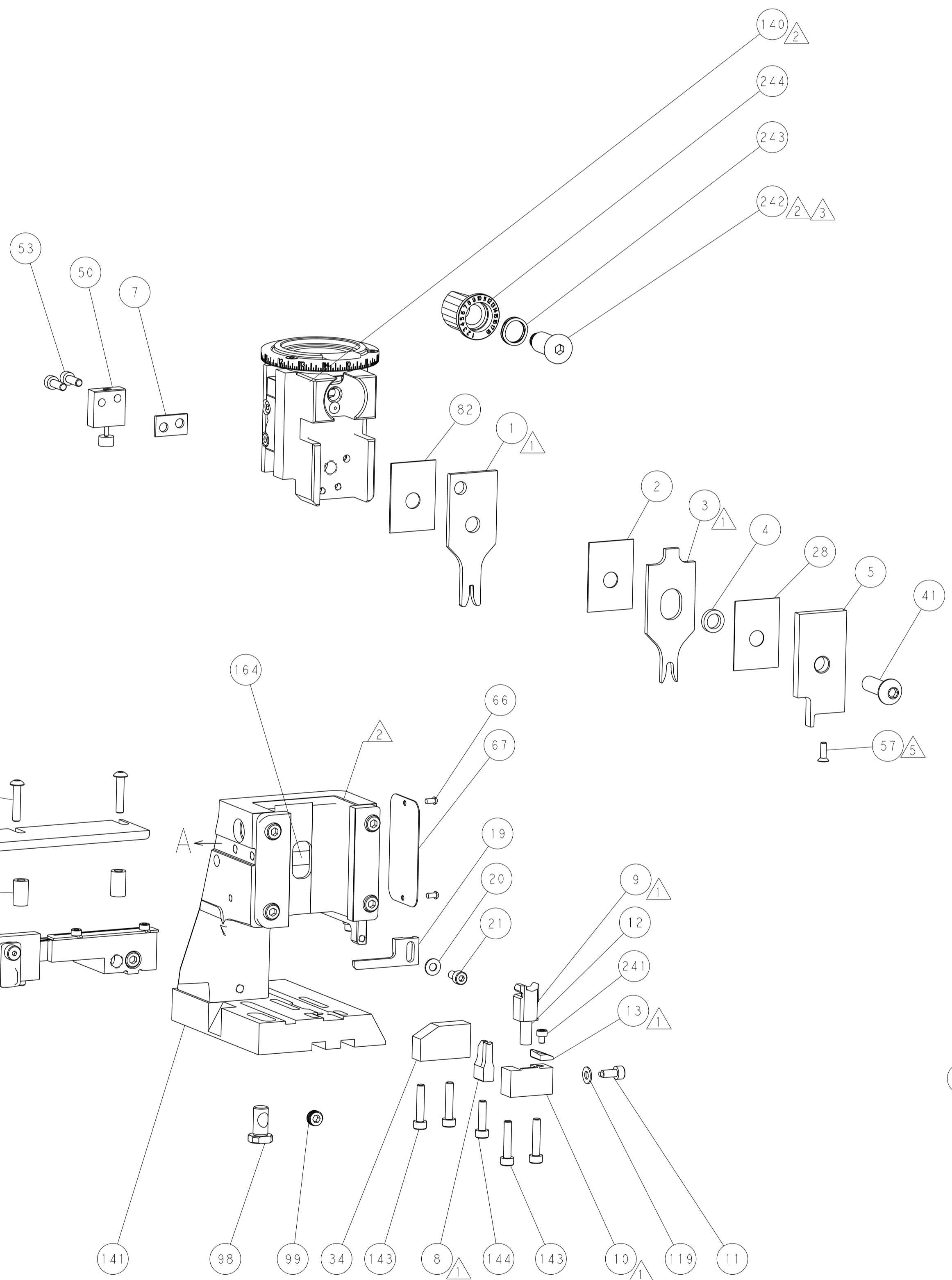


DETAIL A

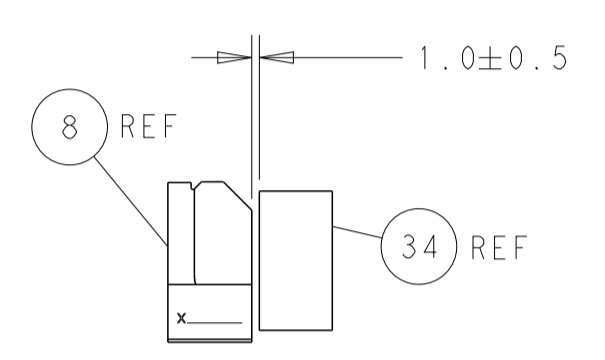
## CAM POSITIONS



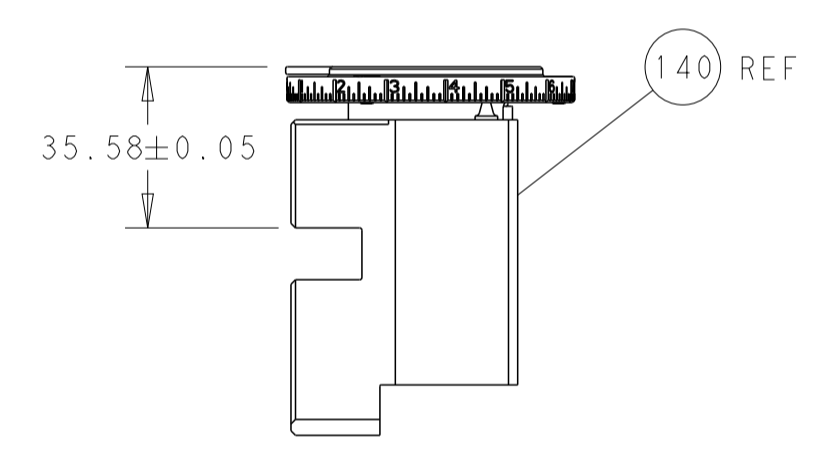
**PACIFIC VERSION**  
 Shown on sheets 3 of 4 & 4 of 4  
 (Atlantic version shown on sheets 1 of 4 & 2 of 4)



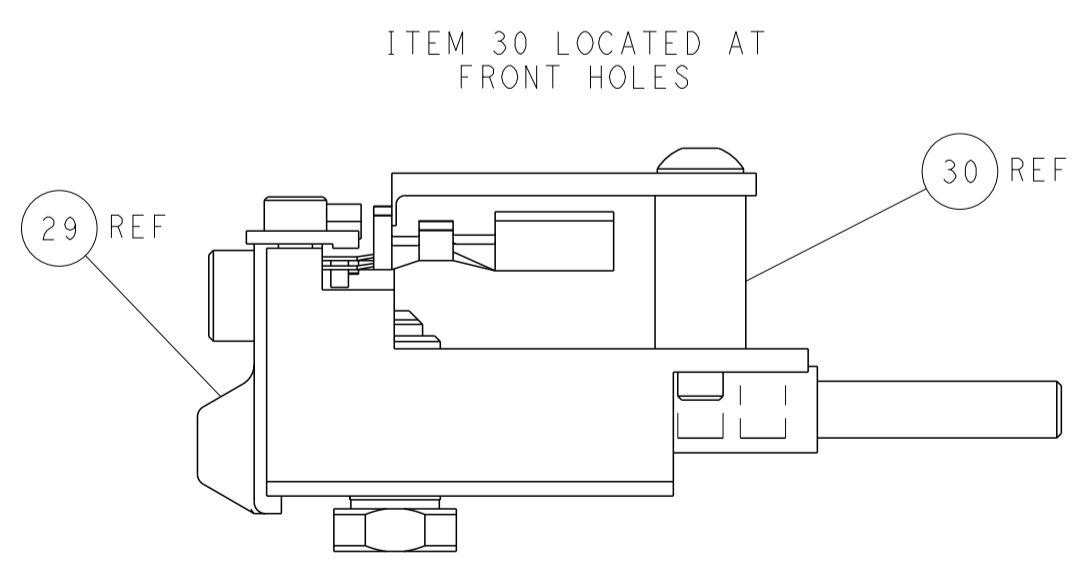
SHEAR DEPRESSOR DETAIL



TERMINAL SUPPORT LOCATION



RAM SET-UP



FEED TRACK POSITION GUIDE BY INSULATION BARREL

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG Y. YIN 02DEC2011		TE Connectivity	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	Harrisburg, PA 17105-3608	
MATERIAL:		FINISH:		CHK G. BAILEY 02DEC2011		NAME	
				S. XI 02DEC2011		Ocean Side Feed Applicator	
				APVD		RESTRICTED TO	
				PRODUCT SPEC		SIZE CAGE CODE DRAWING NO	
				APPLICATION SPEC		A1 00779 C=2151392	
				WEIGHT		SCALE 1:2 SHEET 4 OF 4 REV H2	
				Customer Accessible Production Drawing		SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION	