

APPLICATOR STYLE CONVERSION CHART. Table with columns: PART NUMBER, REVISION, DESCRIPTION, FEED TYPE, CONVERT TO, PART NUMBERS REQUIRED.

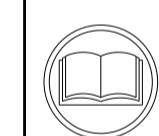
APPLICATOR DATA. Table with columns: CRIMP, SIZE, TYPE. Includes WIRE, INSUL, and APPLICATOR INSTRUCTIONS.

TERMINAL DATA: YAZAKI TERMINAL. YAZAKI CRIMP SPECIFICATION. Includes WIRE STRIP LENGTH, INSULATION DIAMETER RANGE, and TERMINALS APPLIED.

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WIRE SIZE, CRIMP HEIGHT mm [INCH], CRIMP HEIGHT REFERENCE SETTING. Table with 3 columns.

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- 1 RECOMMENDED SPARE PARTS
2 GREASE BEARING SURFACES LIGHTLY
3. LUBRICATE DAILY PER THE APPLICATOR INSTRUCTION SHEET SUPPLIED WITH THE APPLICATOR.
4 APPLICATOR SPECIFIC DATA TO BE ENTERED INTO BLANK MEMORY CHIP AT ASSEMBLY...
5. ADJUSTMENT OF THE STRIPPER MAY BE REQUIRED WHEN MOVING THE APPLICATOR BETWEEN BENCH AND LEADMAKER APPLICATIONS.
6 APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 62 & 242.
7 GREASE THREADS, GROOVE AND O-RING ON ITEMS 35 & 252.
8 MAGNET, ITEM 166 MUST BE ORIENTED CORRECTLY IN ORDER TO PROPERLY ACTUATE THE COUNTER.
9 CRIMP HEIGHT REFERENCE SETTING WAS THE SETTING USED WHEN THE APPLICATOR WAS QUALIFIED AT THE FACTORY...
10 SPARE FEED CAM STORAGE LOCATION REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.
11 TO CONVERT THE APPLICATOR TO A NON-CARRIER CUTTING STYLE...
12 WHEN ASSEMBLING A NON CRIMP HEIGHT ADJUST APPLICATOR (-6) USE SHIMS FROM ITEM 260 TO ACHIEVE A NOMINAL SHIM HEIGHT OF 4.30.

\*WARNING
ON INSTALLATION, SET WIRE DISC, ITEM 40 TO LARGEST WIRE SIZE SETTING. USE OF SETTINGS BELOW MINIMUM REQUIRED CRIMP HEIGHT SETTING WILL CAUSE DAMAGE TO CRIMP TOOLING.

Table with 3 columns: PART NO, DESCRIPTION, ITEM NO. Includes entries for APPLICATOR SHIM PACK and O-RING.

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

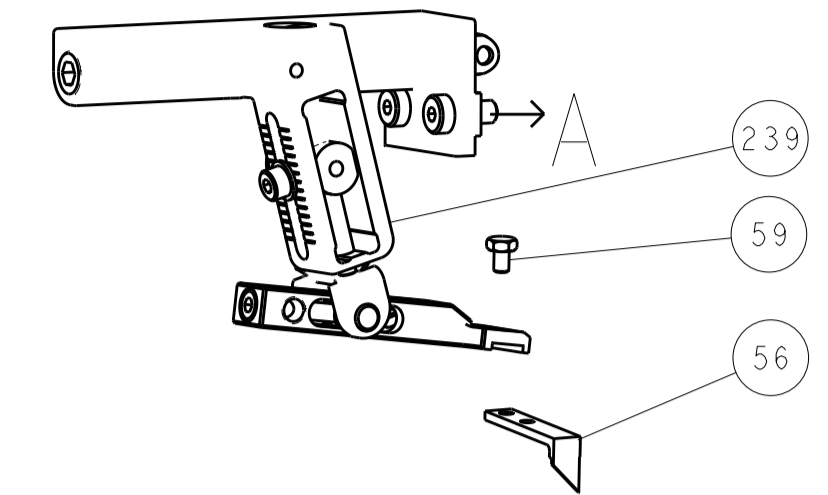
REVISIONS table with columns: P, LTR, DESCRIPTION, DATE, DWN, APVD. Includes SET UP GAUGE 2119599-1.

Main parts list table with columns: P, LTR, DESCRIPTION, DATE, DWN, APVD. Lists various components like PUSH ROD, BUSHING, FEED CAM, etc.

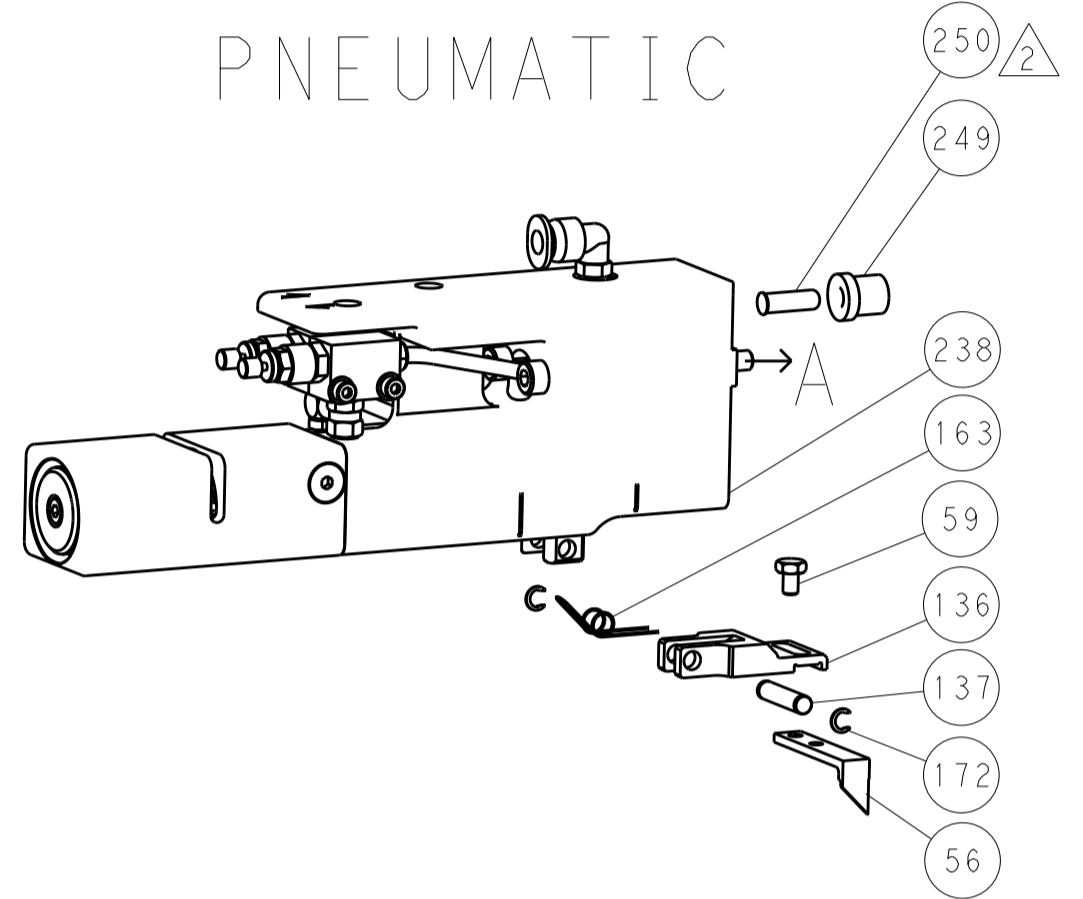
Customer Accessible Production Drawing form with fields for DIMENSIONS, TOLERANCES, MATERIAL, FINISH, WEIGHT, SCALE, SHEET 1 of 4, REV A.

REVISONS		DATE	OWN	APVD
LOC	DIST			
A	66			
P	LTM	DESCRIPTION		
		SEE SHEET 1		

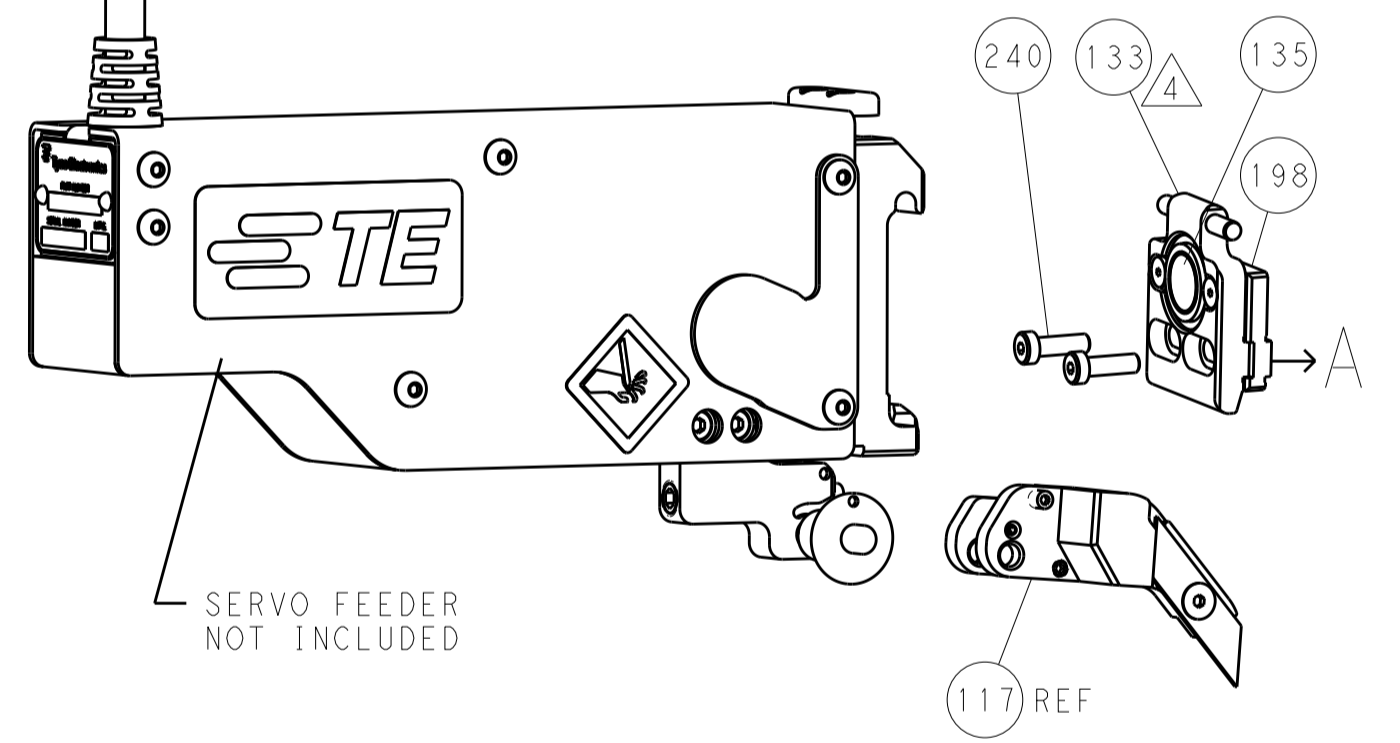
### FEED TYPE MECHANICAL



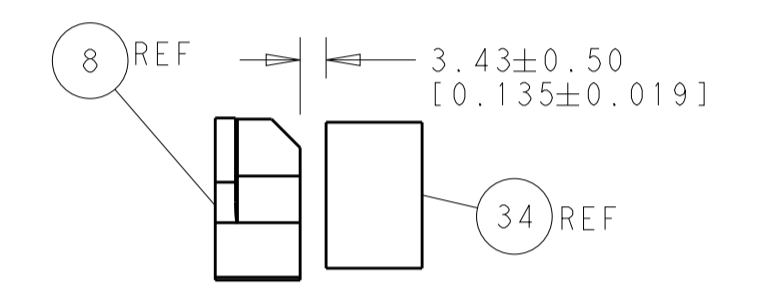
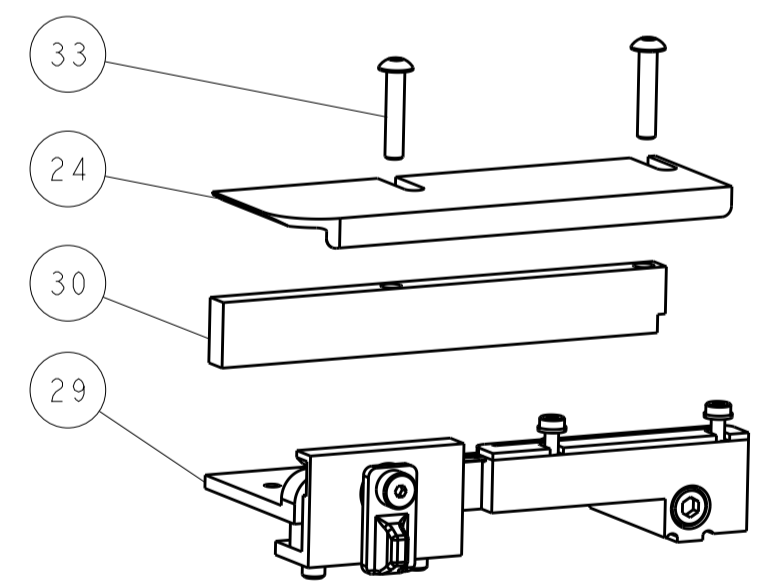
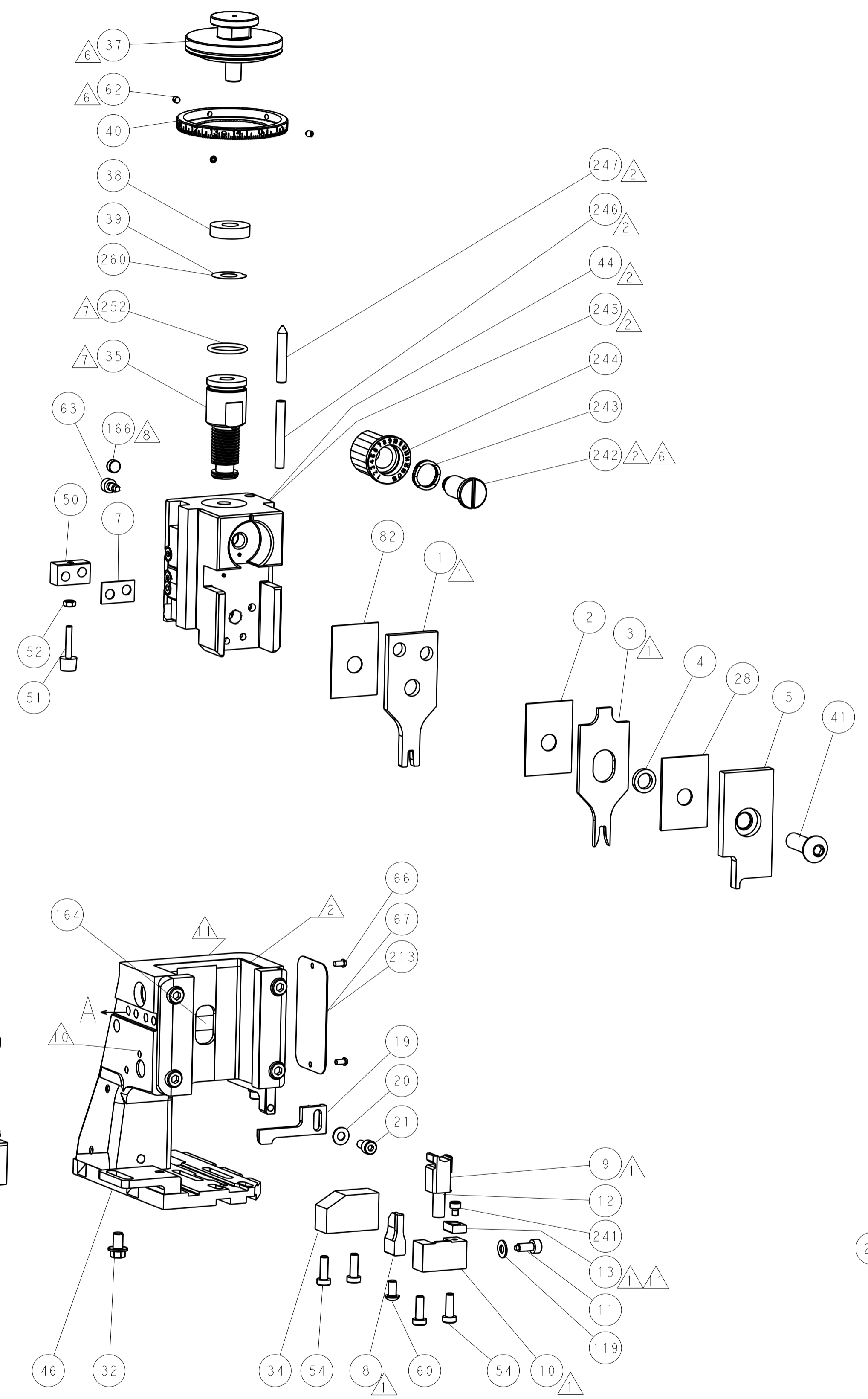
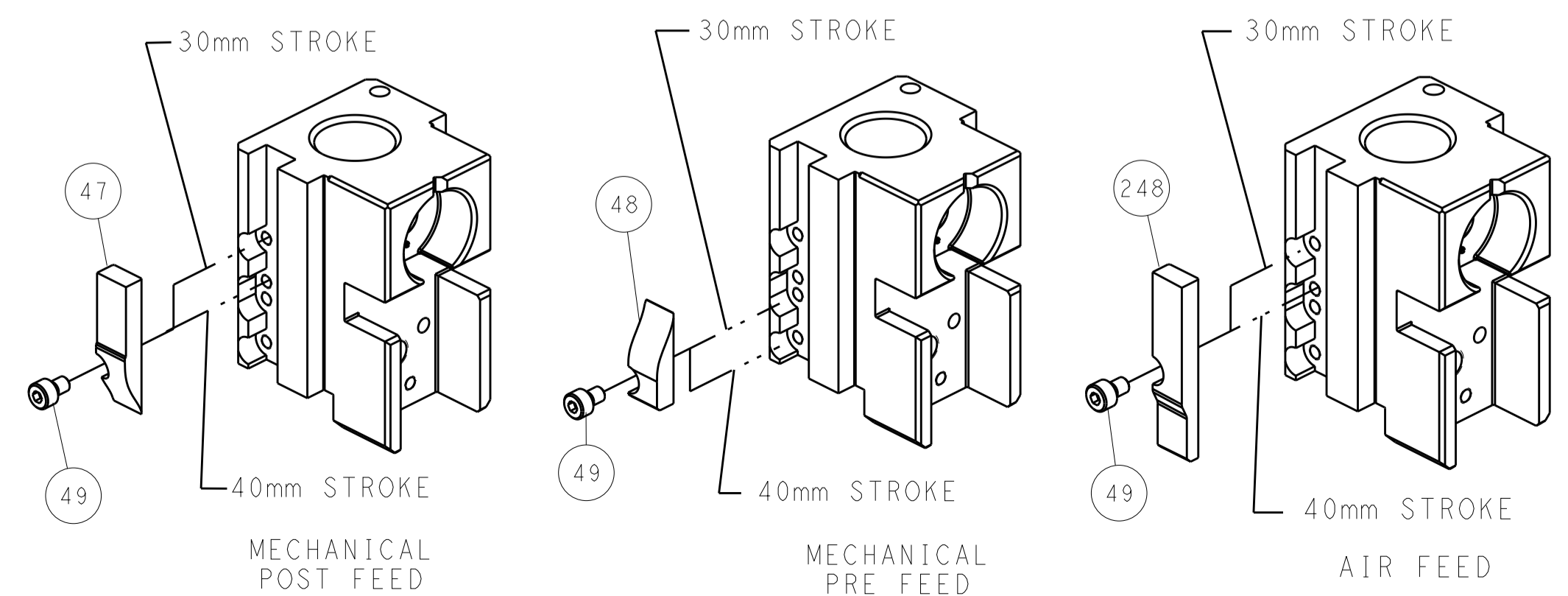
### PNEUMATIC



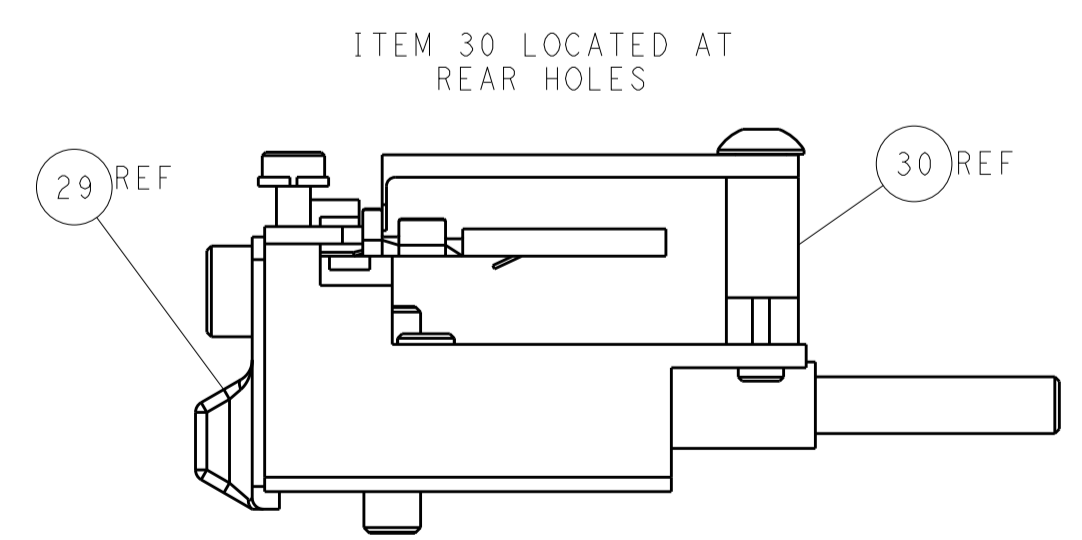
### SERVO LATCH PLATE



### CAM POSITIONS



TERMINAL SUPPORT LOCATION



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 R. HUANG 22MAY2013		TE Connectivity	
mm	0 PLC ±0.1	1 PLC ±0.1	2 PLC ±0.02	3 PLC ±0.005	4 PLC ±0.0005	APVD L. ZHANG 22MAY2013	Harrisburg, PA 17105-3608
MATERIAL:		FINISH:		NAME Ocean Side Feed Applicator		RESTRICTED TO	
				SIZE CAGE CODE DRAWING NO. A11 00779 ©=2151955		SCALE 1:1 SHEET 2 OF 4 REV A	
Customer Accessible Production Drawing				SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION			

DIMENSIONING AND TOLERANCING PER ASME Y14.5M-2003

SET UP GAUGE 2119599-1		LOC A	DIST 66	REVISIONS				
F	LTM	DESCRIPTION		DATE	OWN	APVD		
-	-	SEE SHEET 1		-	-	-		

PACIFIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART						
					CONVERT TO	PART NUMBERS REQUIRED					
						PNEUMATIC FEED	2119950-1	1338685-1	5-18022-5	2119641-2	2119799-1
	2-2151955-1	A	FINE CRIMP HEIGHT ADJUST	MECHANICAL	SERVO LATCH PLATE	2119951-1	-	8-2151955-5	1901094-3	1-1752354-8	2168400-6 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2151955-4	-	-	-
	2-2151955-2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-2	-	-
					SERVO LATCH PLATE	2119951-1	-	8-2151955-5	1901094-3	1-1752354-8	2168400-6 (QUANTITY 2)
	2-2151955-5	A	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE	MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-2	-	-
PNEUMATIC FEED						2119950-1	1338685-1	5-18022-5	2119641-2	2119799-1	2063440-1
2-2151955-7	A	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	-	
7-2151955-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-	

APPLICATOR DATA		
CRIMP SIZE	TYPE	
WIRE 2.60 mm [ .102 ]	F	
INSUL 3.60 mm [ .142 ]	F	
APPLICATOR INSTRUCTIONS 408-10389		

TERMINAL DATA: YAZAKI TERMINAL YAZAKI CRIMP SPECIFICATION			
TERMINAL NAME: .187 TYPE UNSEALED MALE TERMINAL			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
5.00-6.00 mm [ .197-.236 IN ]		∅ 3.56mm [ .140 IN ]MAX	
TERMINAL APPLICATION SPECIFICATION		YAZAKI SPEC 7114-4031	-
TERMINALS APPLIED			
TE TERMINAL	YAZAKI TERMINAL	TE TERMINAL	YAZAKI TERMINAL
(A) 1949217-2	(A) 7114-4031		

TERMINAL DATA: YAZAKI TERMINAL YAZAKI CRIMP SPECIFICATION			
TERMINAL NAME: .187 TYPE UNSEALED FEMALE TERMINAL			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
5.00-6.00 mm [ .197-.236 IN ]		∅ 3.56mm [ .140 IN ]MAX	
TERMINAL APPLICATION SPECIFICATION		YAZAKI SPEC 7116-4031 Rev	-
TERMINALS APPLIED			
TE TERMINAL	YAZAKI TERMINAL	TE TERMINAL	YAZAKI TERMINAL
(B) 1949217-1	(B) 7116-4031		

WIRE SIZE	CRIMP HEIGHT mm [ INCH ]	CRIMP HEIGHT REFERENCE SETTING
1.25mm <sup>2</sup>	1.50 +/- 0.05 [ .059 +/- .002 ]	7.8
0.85mm <sup>2</sup>	1.40 +/- 0.05 [ .055 +/- .002 ]	8.7
0.50mm <sup>2</sup>	1.30 +/- 0.05 [ .051 +/- .002 ]	9.7

WIRE SIZE	CRIMP HEIGHT mm [ INCH ]	CRIMP HEIGHT REFERENCE SETTING
14 AWG OR 1.50mm <sup>2</sup>	1.60 +/- 0.05 [ .063 +/- .002 ]	7.1
16 AWG OR 1.25mm <sup>2</sup>	1.50 +/- 0.05 [ .059 +/- .002 ]	8.3
18 AWG OR 0.85mm <sup>2</sup>	1.40 +/- 0.05 [ .055 +/- .002 ]	9.4

- RECOMMENDED SPARE PARTS
- GREASE BEARING SURFACES LIGHTLY
- 3. LUBRICATE DAILY PER THE APPLICATOR INSTRUCTION SHEET SUPPLIED WITH THE APPLICATOR.
- APPLICATOR SPECIFIC DATA TO BE ENTERED INTO BLANK MEMORY CHIP AT ASSEMBLY. SEE BELOW FOR PART NUMBER:  
 MECHANICAL FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151955-4  
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151955-4  
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151955-5
- 5. ADJUSTMENT OF THE STRIPPER MAY BE REQUIRED WHEN MOVING THE APPLICATOR BETWEEN BENCH AND LEADMAKER APPLICATIONS.
- APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 62 & 242.
- GREASE THREADS, GROOVE AND O-RING ON ITEMS 139 & 152.
- MAGNET MUST BE ORIENTED CORRECTLY IN ORDER TO PROPERLY ACTUATE THE COUNTER.
- 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.
- SPARE FEED CAM STORAGE LOCATION REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.
- TO CONVERT THE APPLICATOR TO A NON-CARRIER CUTTING STYLE, REMOVE ITEM 13 AND ATTACH TO THE LOCATION ON BACK SIDE OF THE HOUSING. REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.

**\*WARNING**  
 ON INSTALLATION, SET WIRE DISC, ITEM 40 TO LARGEST WIRE SIZE SETTING. USE OF SETTINGS BELOW MINIMUM REQUIRED CRIMP HEIGHT SETTING WILL CAUSE DAMAGE TO CRIMP TOOLING.

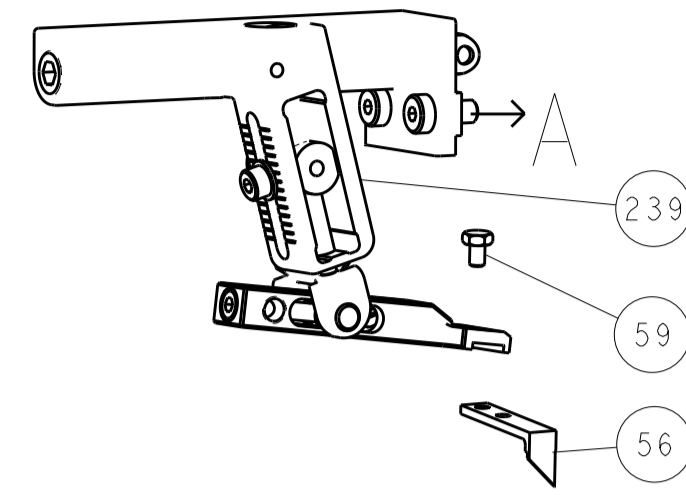
-	1	1	1	1	2119782-1	FINE ADJUST HEAD ASM, PACIFIC STYLE	251
-	-	-	1	-	2119640-1	PUSH ROD, AIR FEED	250
-	-	-	1	-	2079988-1	BUSHING, LCH5-12, MISUMI	249
-	1	1	1	1	1-22279-3	SPRING, COMPRESSION	246
-	1	1	1	1	2119082-8	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	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
-	-	2	-	-	2168400-6	SHCS, LOW HEAD, RoHS, M5 X 16	240
-	-	-	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	-	-	-	1	2063440-1	AIR FEED MODULE	238
-	-	-	-	-	2119740-2	TAG, IDENTIFICATION	213
-	-	1	-	-	1901094-3	SPACER, FEEDER	198
-	-	-	-	2	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172
-	1	1	1	1	994969-1	MAGNET, RARE EARTH HIGH ENERGY	166
-	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	-	-	1	-	240638-1	SPRING, FEED FINGER	163
-	1	1	1	1	8-21084-1	O-RING, .801 ID, .070 DIA, MAT.	152
-	-	-	1	-	2119641-2	FEED CAM, AIR FEED	151
-	1	1	1	1	2119798-2	DETENT PIN	145
-	1	1	1	1	2079383-8	SCR, BHSC, RoHS (M4 X 16)	144
-	4	4	4	4	2168400-5	SHCS, LOW HEAD, RoHS, M4 X 20	143
-	-	-	-	1	2119653-2	FEED CAM, POST FEED	142
-	1	1	1	1	1-2119656-0	APPLICATOR BASIC ASSEMBLY, SF	141
-	1	1	1	1	2119650-1	RAM, ASIAN STYLE, SIDE FEED	140
-	1	1	1	1	2119092-2	BOLT, ADJUSTMENT	139
-	-	-	1	-	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854	137
-	-	-	-	1	2119799-1	HOLDER, FEED FINGER, AF	136
-	-	REF	-	-	SEE NOTE 4	MEMORY CHIP, PROGRAMMED	135
-	-	1	-	-	1633743-1	SERVO FEED LATCH ASM	133
-	1	1	1	1	1-18028-2	WASHER, FLAT, REG M4	119
-	-	REF	-	-	2119944-1	FEED FINGER ASSEMBLY, SF	117
-	1	1	1	1	455888-5	SPACER, CRIMPER	82
-	1	1	1	1	2119956-1	DOCUMENTATION PACKAGE	71
-	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	2119793-1	LIMITER, ADJUSTMENT BOLT	63
-	3	3	3	3	992763-5	SCR, SET, SOC, CONE POINT, M3 X 4.0	62
-	-	-	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	-	-	-	1	1338685-1	PAWL, FEED	56
-	2	2	2	2	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	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	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	-	-	-	1	2119652-1	FEED CAM, PRE FEED	48
-	1	1	1	1	2079383-7	SCR, BHSC, RoHS (M8 X 25)	41
-	1	1	1	1	2119645-1	DISC, NUMBERED FA WIRE ADJUSTMENT	40
-	1	1	1	1	2119957-1	APPLICATOR SHIM PACK	39
-	1	1	1	1	1-2119644-2	RAM WASHER, PRECISION	38
-	1	1	1	1	1752356-3	SUPPORT, TERMINAL	34
-	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	1	1	1	1	2161328-1	HEX HEAD, FLANGED, M5 X 8mm LONG	32
-	1	1	1	1	1-1320908-0	SPACER, STRIP GUIDE	30
-	1	1	1	1	2119959-1	ASSEMBLY, STRIP GUIDE	29
-	1	1	1	1	1-455888-0	SPACER, CRIMPER	28
-	1	1	1	1	1320928-6	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	1	1	2-1633932-8	ANVIL, COMBINATION	8
-	1	1	1	1	1-240641-9	SPACER	7
-	-	-	-	-	-	-	6
-	1	1	1	1	2119757-9	DEPRESSOR, SHEAR	5
-	1	1	1	1	1-238011-7	BLOCK, CRIMPER SPACER	4
-	1	1	1	1	4-2119582-4	CRIMPER, INSULATION F PREMIUM	3
-	1	1	1	1	455888-8	SPACER, CRIMPER	2
-	1	1	1	1	1-1633664-0	CRIMPER, WIRE	1

THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION. IT IS THE USER'S RESPONSIBILITY TO OBTAIN THE LATEST REVISIONS OF THIS DRAWING. DIMENSIONS SHALL BE COMPARED TO THE LATEST REVISION.				OWN: H. HUANG Z2MAY2013 CHK: L. ZHANG Z2MAY2013 APVD: H. GUO Z2MAY2013			
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:					
mm	0 PLC ± .1	1 PLC ± .1	2 PLC ± .1	3 PLC ± .05	4 PLC ± .0005	ANGLES ± .0005	
MATERIAL:	FINISH:	WEIGHT:	SCALE:	A 00779 ©=2151955		RESTRICTED TO:	
Customer Accessible Production Drawing				SCALE	SHEET 3 OF 4	REV A	

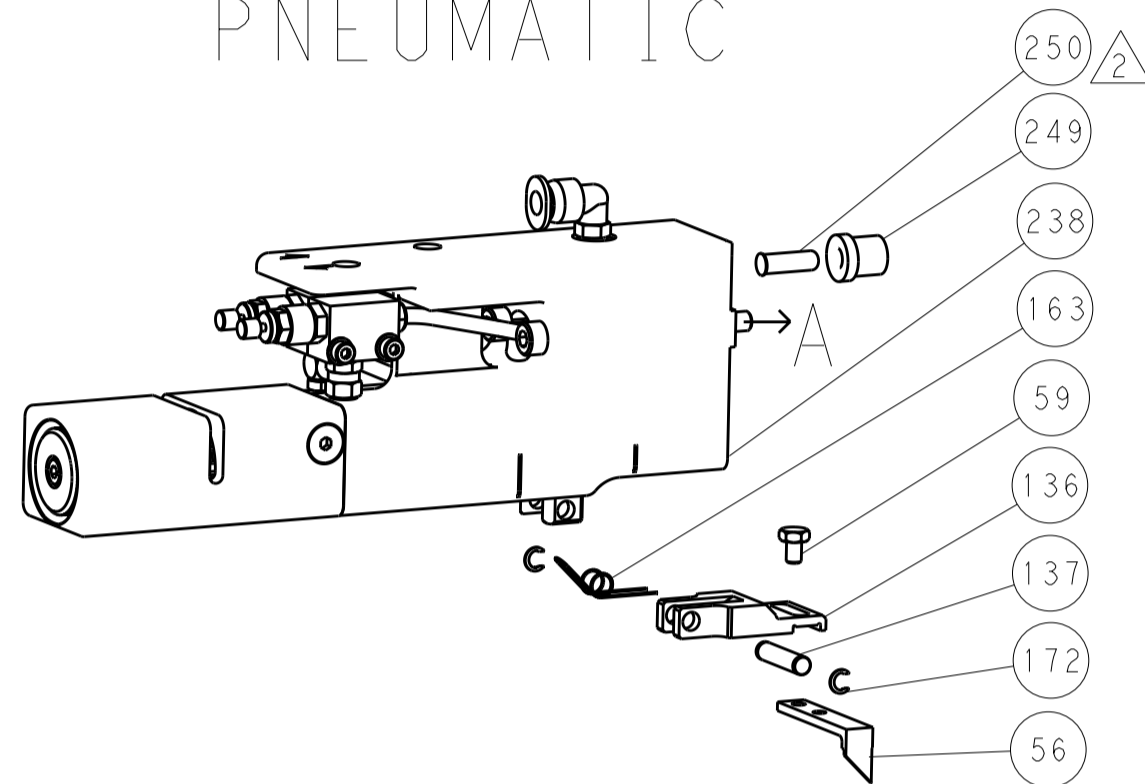
**PACIFIC VERSION**  
 Shown on sheets 3 of 4 & 4 of 4  
 (Atlantic version shown on sheets 1 of 4 & 2 of 4)

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

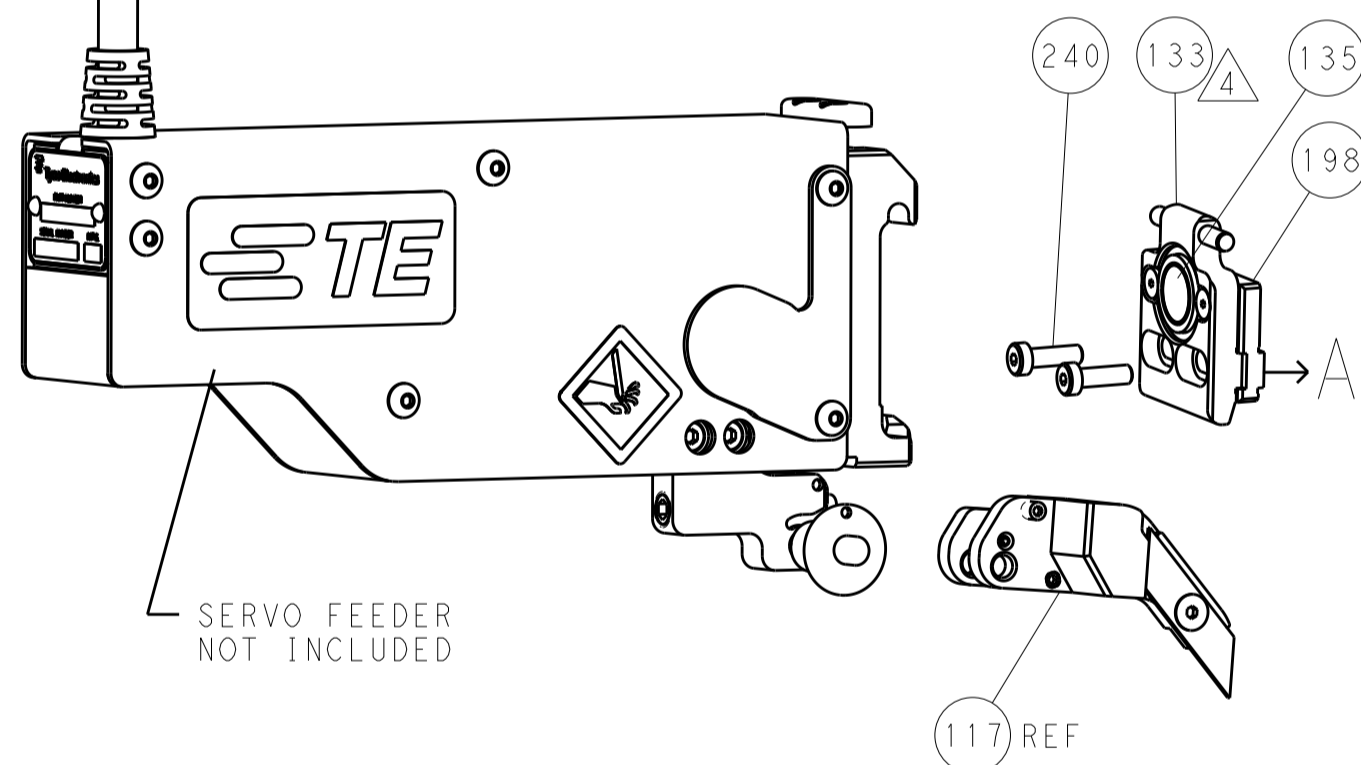
# FEED TYPE MECHANICAL



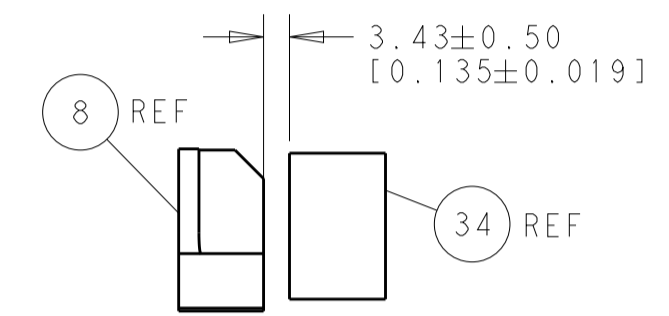
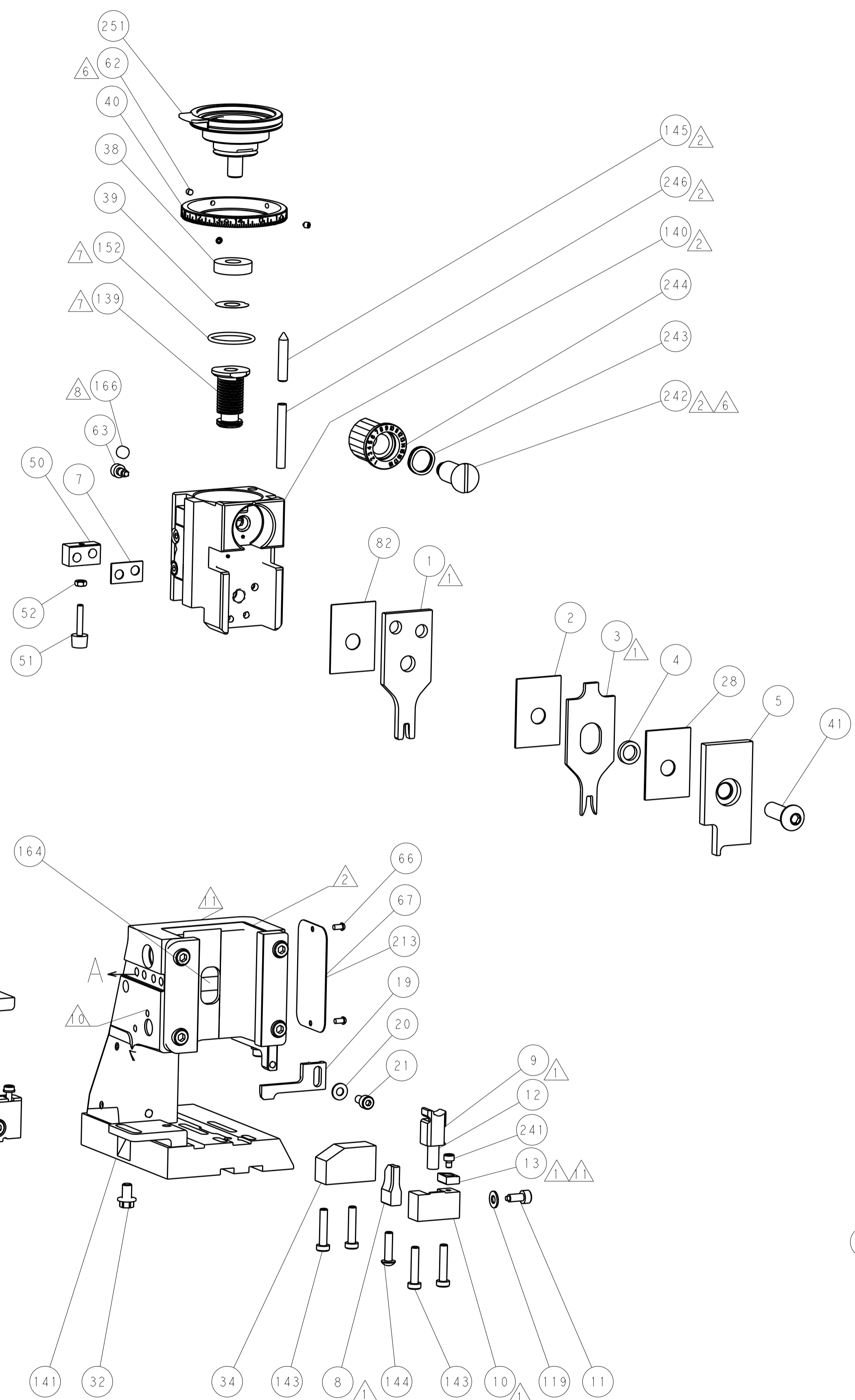
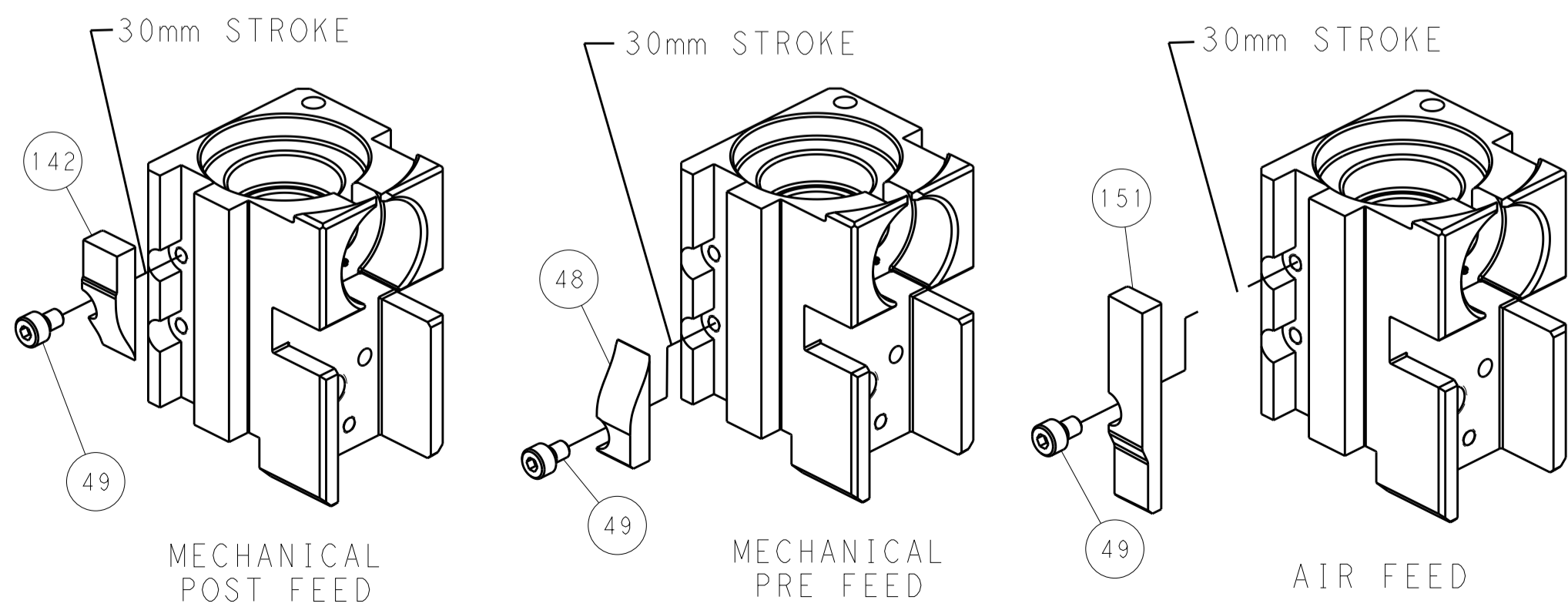
# PNEUMATIC



# SERVO LATCH PLATE

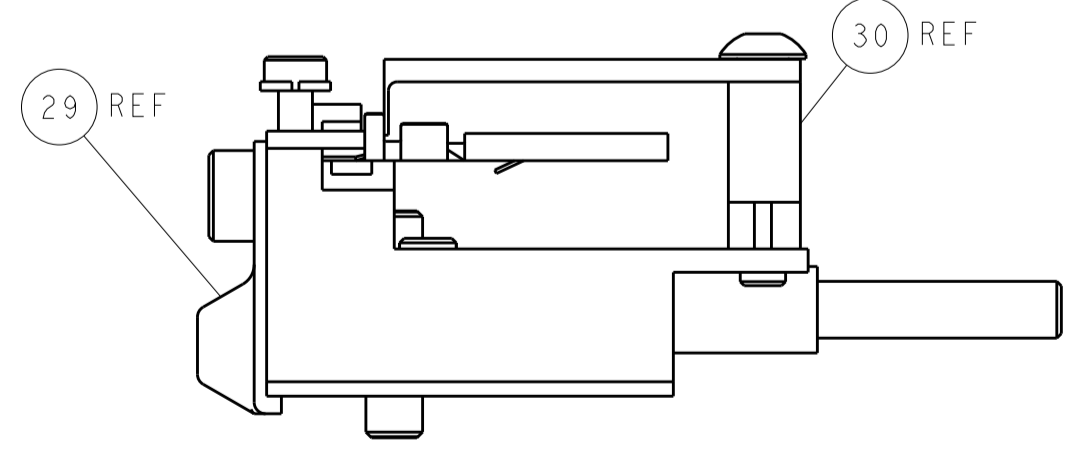


# CAM POSITIONS



TERMINAL SUPPORT LOCATION

ITEM 30 LOCATED AT REAR HOLES



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)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN R. HUANG 22MAY2013		STE TE Connectivity	
mm	0 PLC ±0.1	1 PLC ±0.1	2 PLC ±0.02	3 PLC ±0.005	4 PLC ±0.0005	ANGLES ±	CHK L. ZHANG 22MAY2013
MATERIAL:		FINISH:		APVD H. GUO 22MAY2013		NAME Ocean Side Feed Applicator	
-		-		WEIGHT		SIZE CAGE CODE DRAWING NO. A1 00779 C=2151955	
-		-		Customer Accessible Production Drawing		RESTRICTED TO SCALE 1:1 SHEET 4 OF 4 REV A	