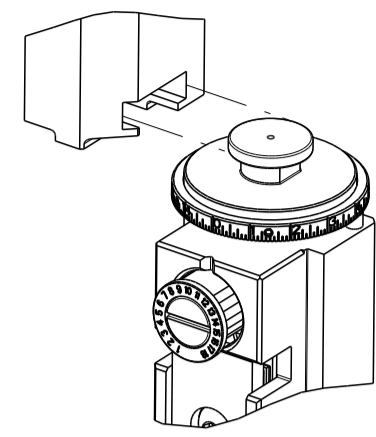


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151422-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2151422-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151422-1	C	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2151422-2	C	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2151422-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER

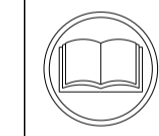


APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.35 mm [.053]	F
INSUL	1.55 mm [.061]	O

APPLICATOR INSTRUCTIONS
408-35042

TERMINAL DATA: YAZAKI TERMINAL YAZAKI CRIMP SPECIFICATION			
TERMINAL NAME: KAIZEN 0.64 TERMINAL MALE			
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE		
4.50-5.00 mm [.177-.197 IN]	Ø1.50-1.85 mm [.059-.073 IN]		
TERMINAL APPLICATION SPECIFICATION	YAZAKI Rev WA1791		
TERMINALS APPLIED			
TE TERMINAL	YAZAKI TERMINAL	TE TERMINAL	YAZAKI TERMINAL
1642948-1	7114-4618-02	1642772-1	7116-4618-02
1949674-1	7116-5231-08	3311490-1	7116-4618-08

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
20 AWG OR 0.50mm2	0.95+/-0.05 [.037+/-0.002]	4.3
22 AWG OR 0.35mm2	0.90+/-0.05 [.035+/-0.002]	4.9



- 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.
- 6 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.

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

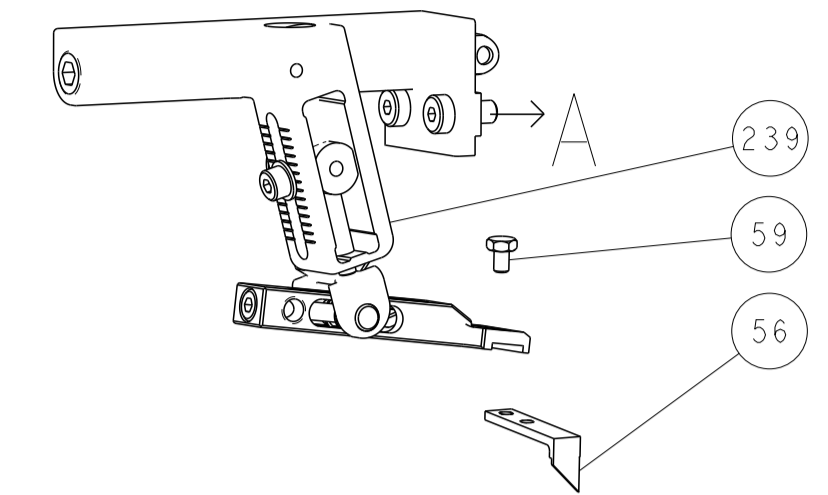
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		B		ECR-18-007829	22MAY2018	MEH	JDG
		C		ECR-19-002277	12FEB2019	LG	CT
		CI		ECR-19-007375	08MAY2019	RK	TE

-	1	-	1	-	2119640-1	PUSH ROD, AIR FEED	250	
-	1	-	1	-	2079988-1	BUSHING, LCH5-12, MISUMI	249	
-	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	-	2063440-1	AIR FEED MODULE	238	
-	2	-	2	-	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172	
-	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164	
-	1	-	1	-	240638-1	SPRING, FEED FINGER	163	
-	1	-	1	-	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854	137	
-	1	-	1	-	2119799-1	HOLDER, FEED FINGER, AF	136	
-	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	455888-6	SPACER, CRIMPER	82	
-	1	1	1	1	1803607-1	DOCUMENTATION PACKAGE	71	
-	1	1	1	1	2119791-9	DEPRESSOR, WIRE	70	
-	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	1803382-6	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	1752356-3	SUPPORT, TERMINAL	34	
-	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33	
-	2	2	2	2	2-2844962-4	SPACER, CYLINDRICAL, STRIP GUIDE	30	
-	1	1	1	1	2844992-2	ASSEMBLY, STRIP GUIDE	29	
-	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	1803095-6	FLOATING SHEAR, FRONT	9	
-	1	2	2	1	1	6-1633139-7	ANVIL, COMBINATION	8
-	-	-	-	-	-	-	7	
-	-	-	-	-	-	-	6	
-	1	1	1	1	2119757-3	DEPRESSOR, SHEAR	5	
-	1	1	1	1	1-238011-0	BLOCK, CRIMPER SPACER	4	
-	1	2	2	1	1	1-1803019-5	CRIMPER, INSULATION O	3
-	1	1	1	1	455888-3	SPACER, CRIMPER	2	
-	1	2	2	1	1	1333281-3	CRIMPER, WIRE PREMIUM	1
-	77	-72	-71	-2	-1	PART NO	DESCRIPTION	ITEM NO

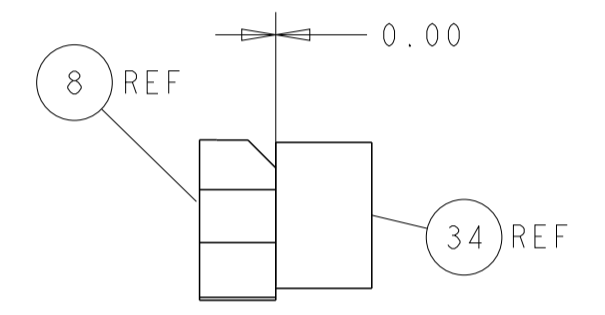
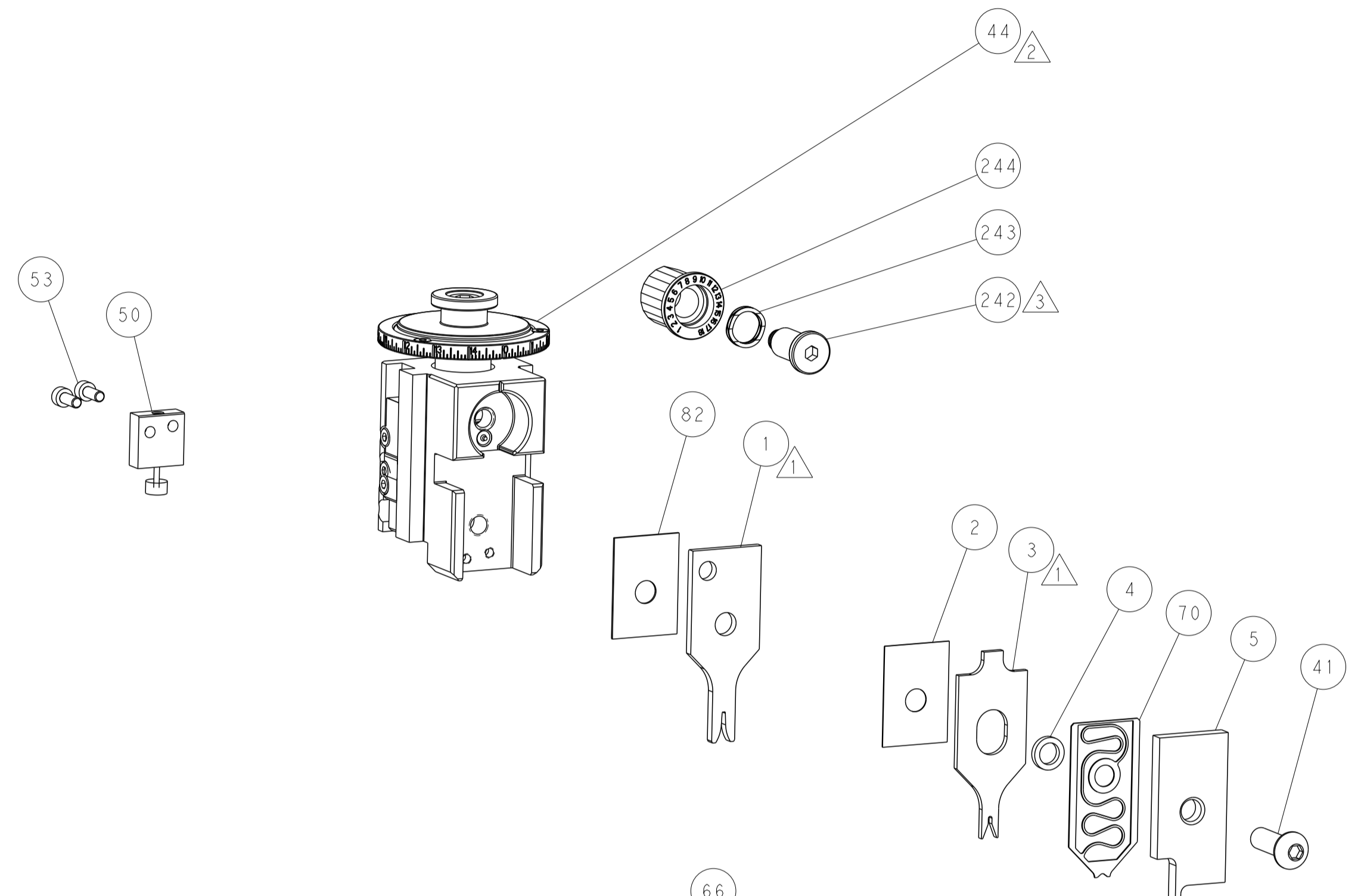
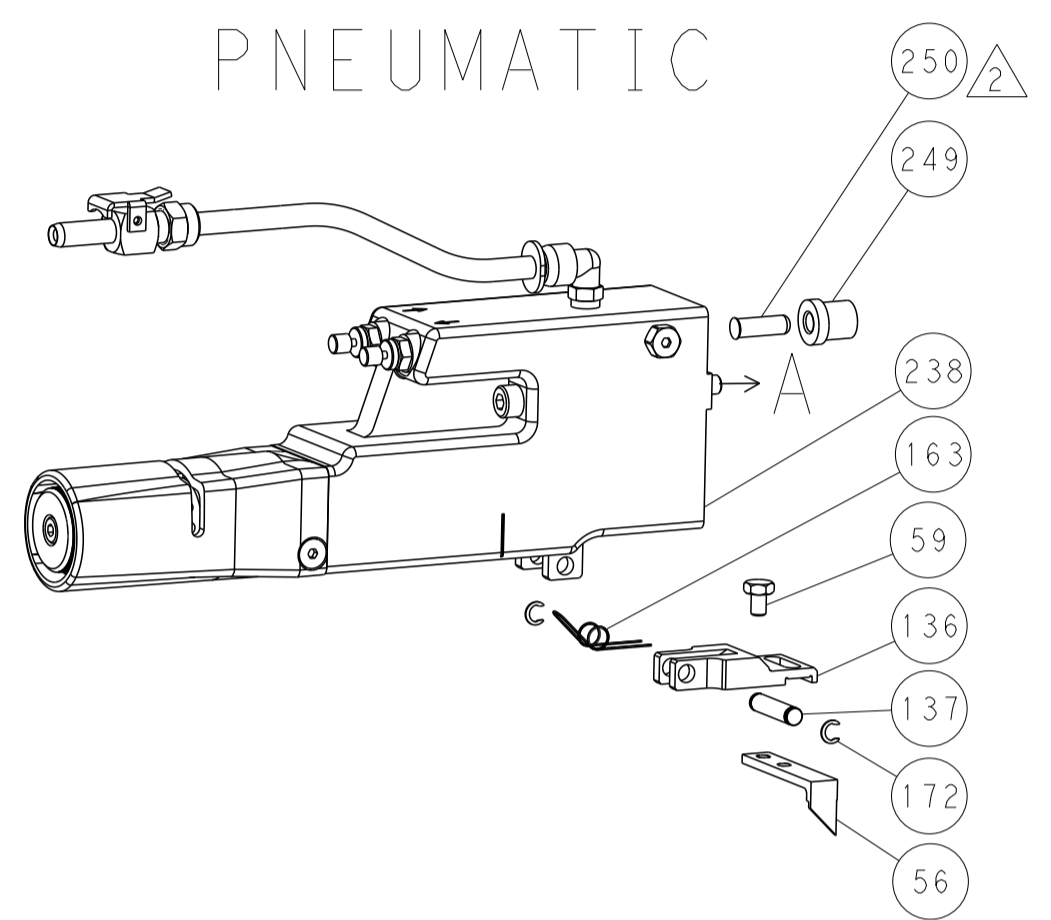
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		MATERIAL:		FINISH:	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES	FINISH
CUSTOMER ACCESSIBLE PRODUCTION DRAWING SCALE: 1:2 SHEET 1 OF 4 REV: C1				DWG: H. HUANG 18DEC2012 CHK: S. XI 18DEC2012 APVD: S. XI 18DEC2012 NAME: Ocean Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2151422 SCALE: 1:2 SHEET 1 OF 4 REV: C1			

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

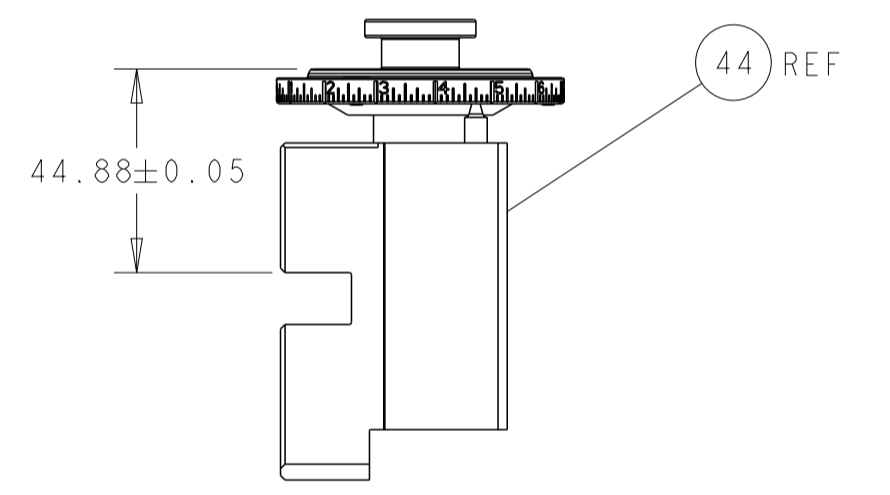
FEED TYPE MECHANICAL



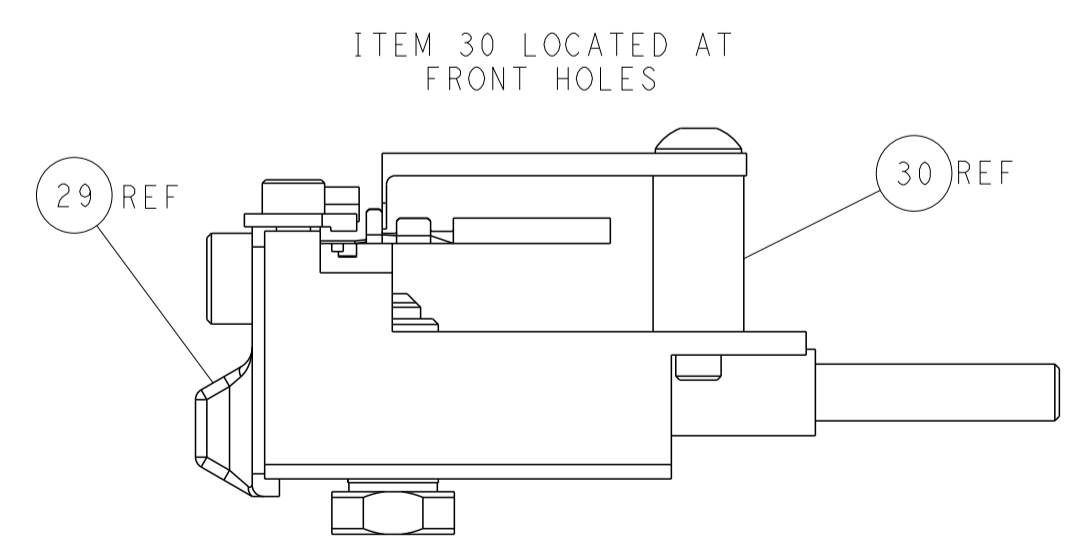
PNEUMATIC



TERMINAL SUPPORT LOCATION

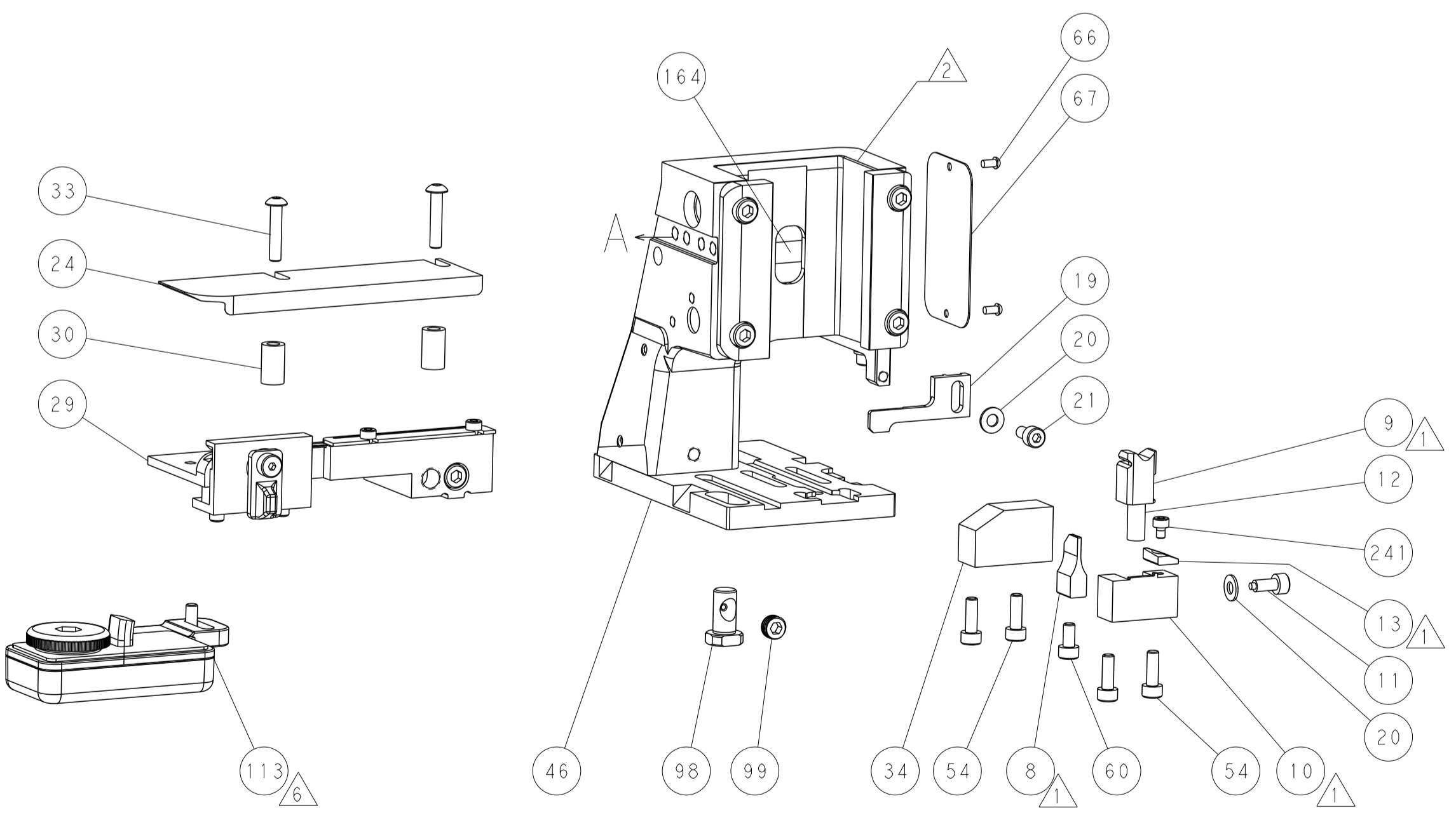
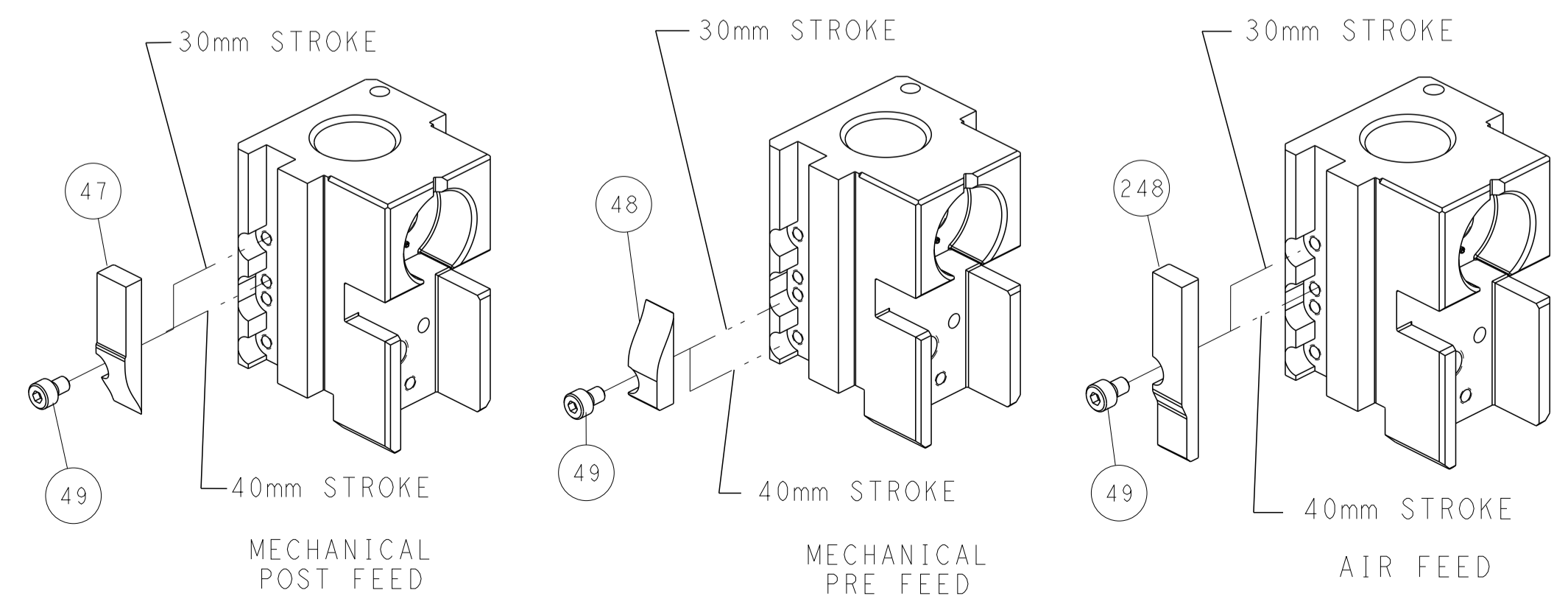


RAM SET-UP



FEED TRACK POSITION GUIDE BY INSULATION BARREL

CAM POSITIONS



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 18DEC2012		TE Connectivity Harrisburg, PA 17105-3608	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	NAME Ocean Side Feed Applicator	RESTRICTED TO
	ANGLES ±	FINISH		APVD S. XI 18DEC2012	PRODUCT SPEC	SIZE A1	CAGE CODE 00779
MATERIAL				APVD S. XI 18DEC2012	APPLICATION SPEC	DRAWING NO 2151422	REV C1
				WEIGHT	Customer Accessible Production Drawing	SCALE 1:2	SHEET 2 of 4

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2151422-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2151422-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151422-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
 INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.35 mm [.053]	F
INSUL	1.55 mm [.061]	O
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: YAZAKI TERMINAL YAZAKI CRIMP SPECIFICATION			
TERMINAL NAME: KAIZEN 0.64		TERMINAL MALE	
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
4.50-5.00 mm [1.177-.197 IN]		∅1.50-1.85 mm [.059-.073 IN]	
TERMINAL APPLICATION SPECIFICATION		YAZAKI Rev WA1791	
TERMINALS APPLIED			
TE TERMINAL	YAZAKI TERMINAL	TE TERMINAL	YAZAKI TERMINAL
1642948-1	7114-4618-02	1642772-1	7116-4618-02
1949674-1	7116-5231-08	3311490-1	7116-4618-08

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
20 AWG OR 0.50mm2	0.95 +/- 0.05 [.037 +/- .002]	4.3
22 AWG OR 0.35mm2	0.90 +/- 0.05 [.035 +/- .002]	4.9



- 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.
- 6 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.

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

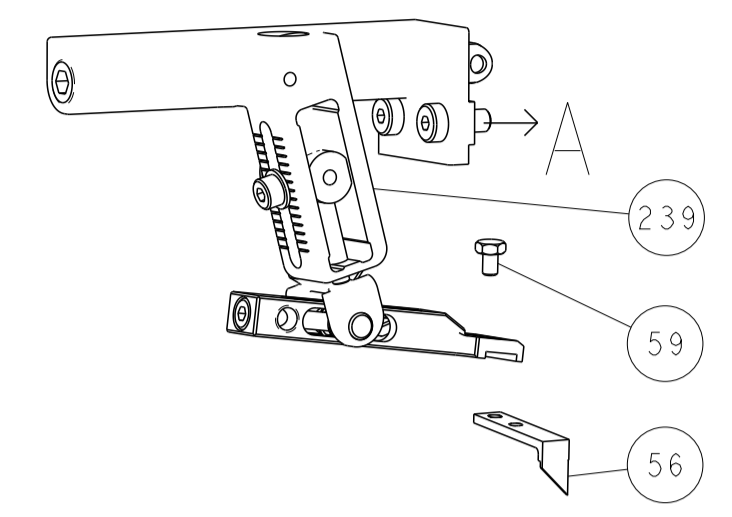
LOC	DIST	REVISIONS					
A	66	P	LTN	DESCRIPTION	DATE	OWN	APVD
-	-	-	-	SEE SHEET 1	-	-	-

-	1	-	2119640-1	PUSH ROD, AIR FEED	250		
-	1	-	2079988-1	BUSHING, LCH5-12, MISUMI	249		
-	1	1	2119082-4	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	-	2063440-1	AIR FEED MODULE	238		
-	2	-	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172		
-	REF	REF	994970-2	COUNTER, MAGNETIC	164		
-	1	-	240638-1	SPRING, FEED FINGER	163		
-	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	-	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854	137		
-	1	-	2119799-1	HOLDER, FEED FINGER, AF	136		
-	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	455888-6	SPACER, CRIMPER	82		
-	1	1	1803607-1	DOCUMENTATION PACKAGE	71		
-	1	1	2119791-9	DEPRESSOR, WIRE	70		
-	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		
-	2	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	53		
-	1	1	1803382-6	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	1752356-3	SUPPORT, TERMINAL	34		
-	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33		
-	2	2	2-2844962-4	SPACER, CYLINDRICAL, STRIP GUIDE	30		
-	1	1	2844992-2	ASSEMBLY, STRIP GUIDE	29		
-	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	1803095-6	FLOATING SHEAR, FRONT	9		
-	1	1	1-1633139-7	ANVIL, COMBINATION	8		
-	-	-	-	-	7		
-	-	-	-	-	6		
-	1	1	2119757-3	DEPRESSOR, SHEAR	5		
-	1	1	1-238011-0	BLOCK, CRIMPER SPACER	4		
-	1	1	1-1803019-5	CRIMPER, INSULATION O	3		
-	1	1	455888-3	SPACER, CRIMPER	2		
-	1	1	1333281-3	CRIMPER, WIRE PREMIUM	1		
-	77	-	22	-21	PART NO	DESCRIPTION	ITEM NO

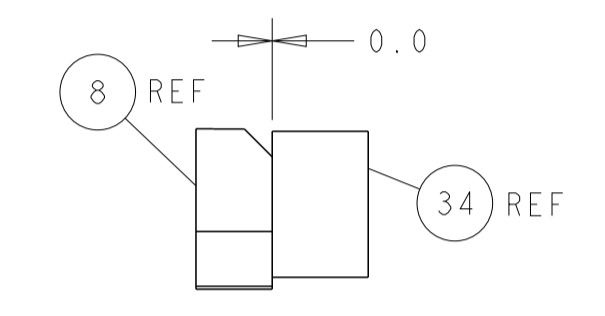
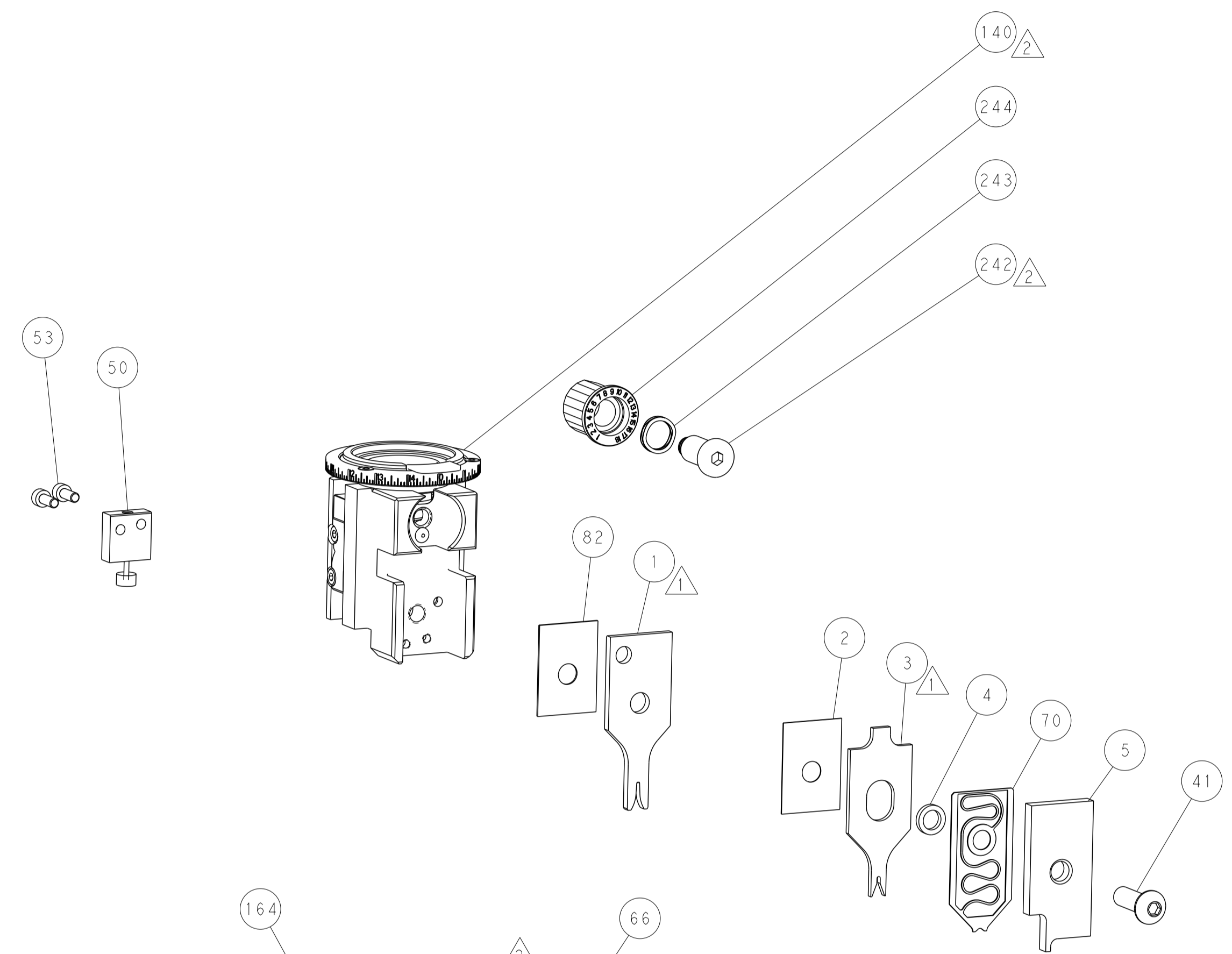
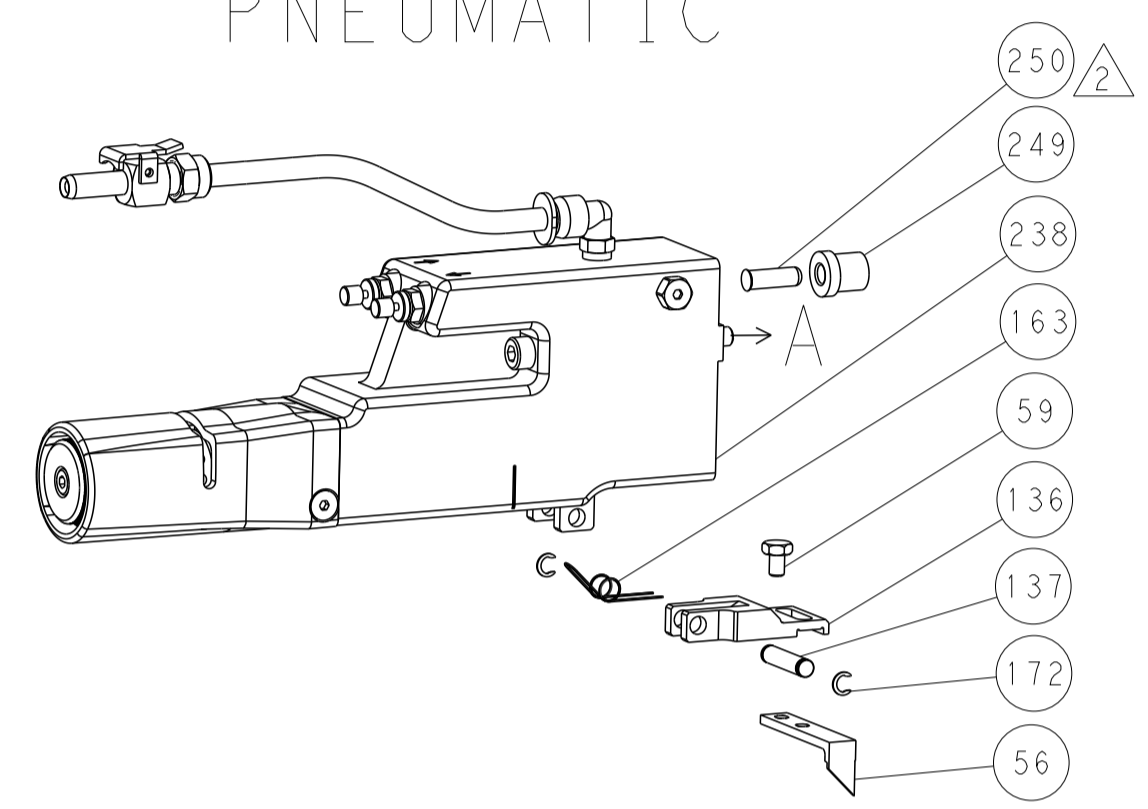
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LOC		DIST		REVISIONS			
A	66	P	LYN	DESCRIPTION	DATE	OWN	APVD
		-		SEE SHEET 1			

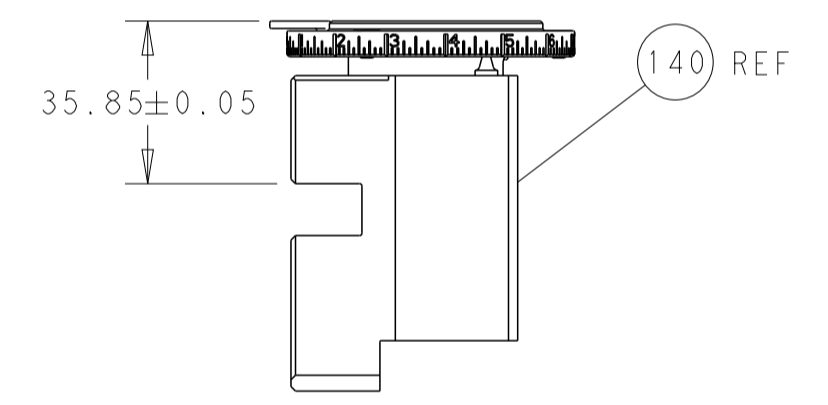
FEED TYPE MECHANICAL



PNEUMATIC

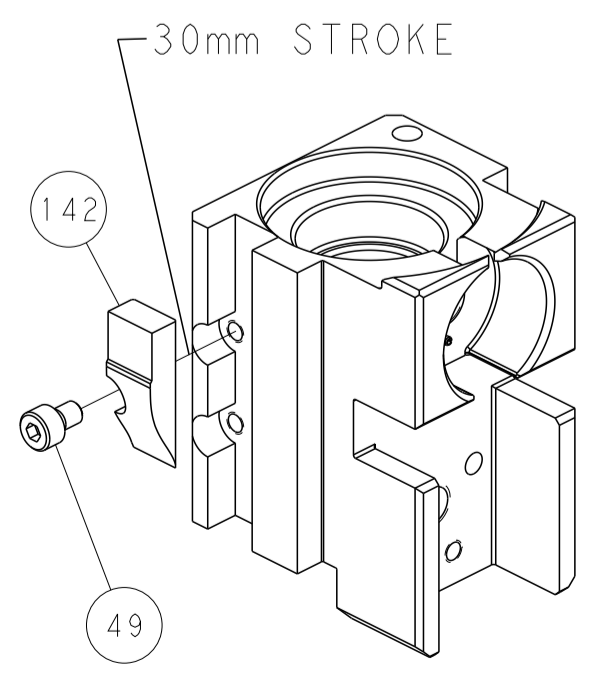


TERMINAL SUPPORT LOCATION

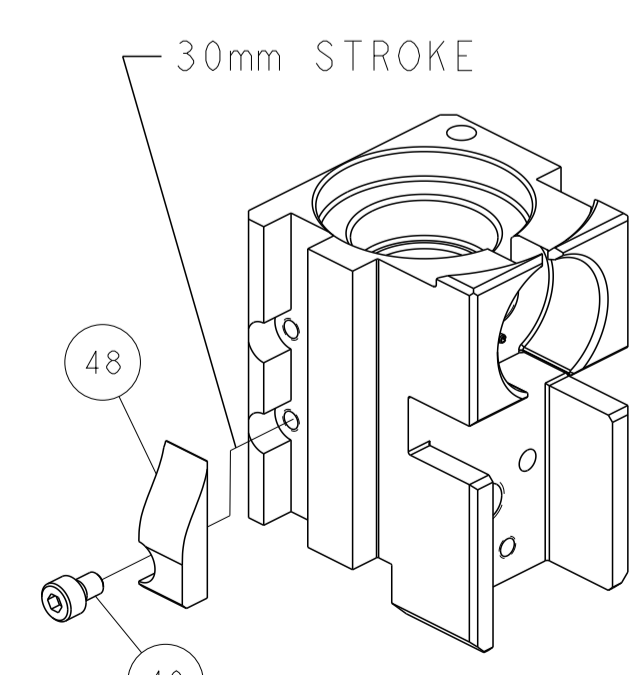


RAM SET-UP

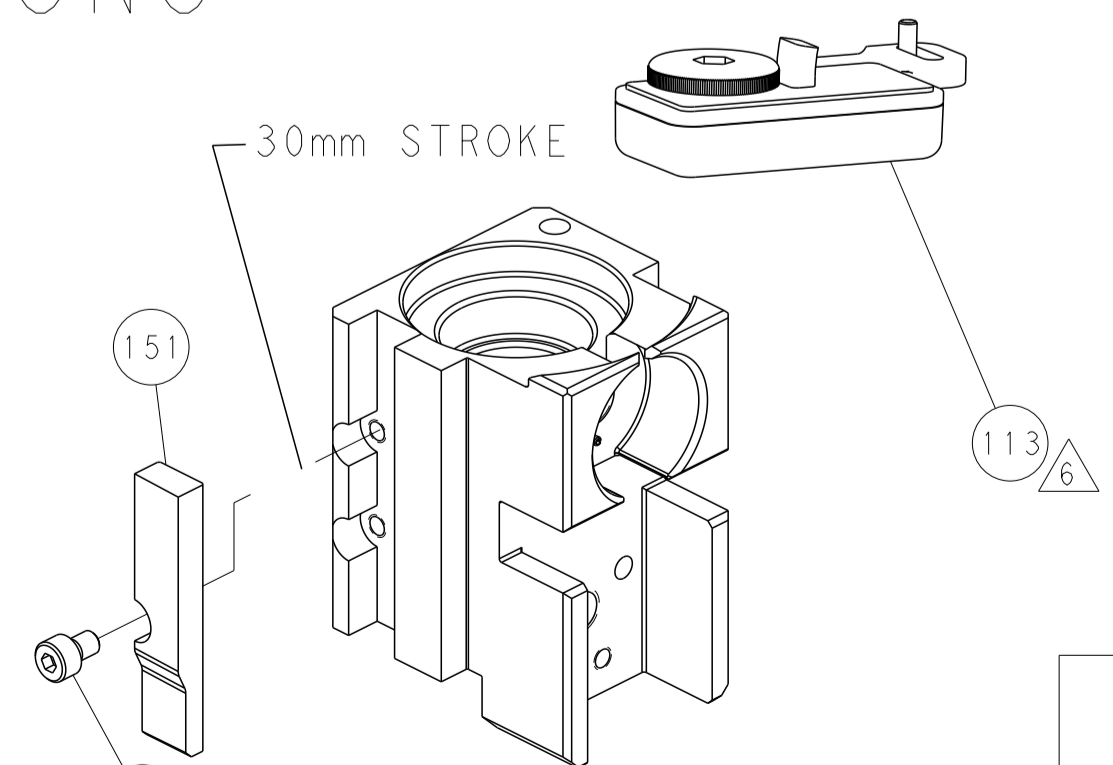
CAM POSITIONS



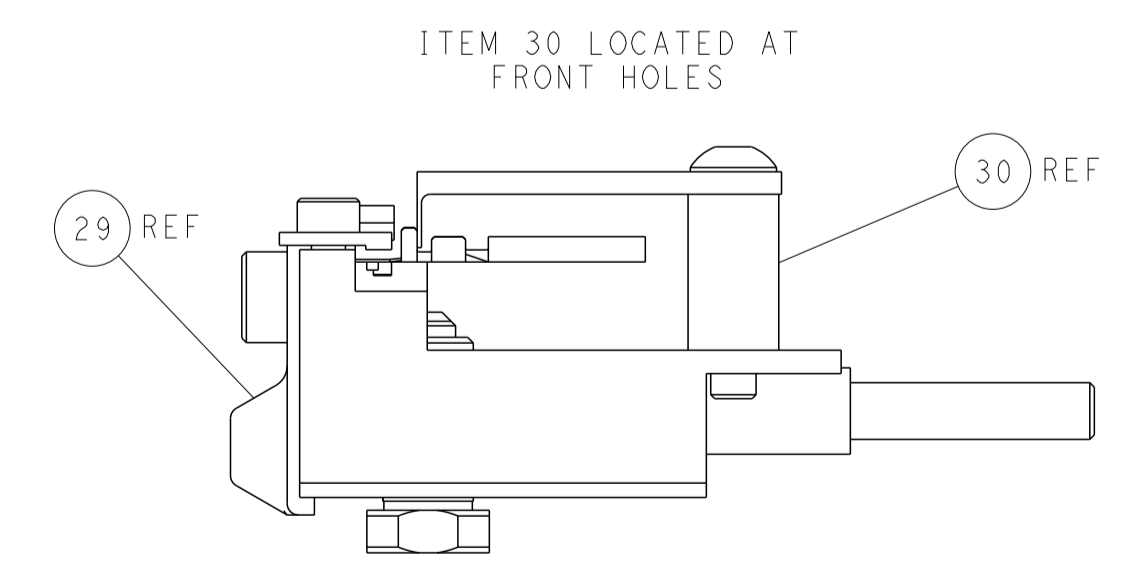
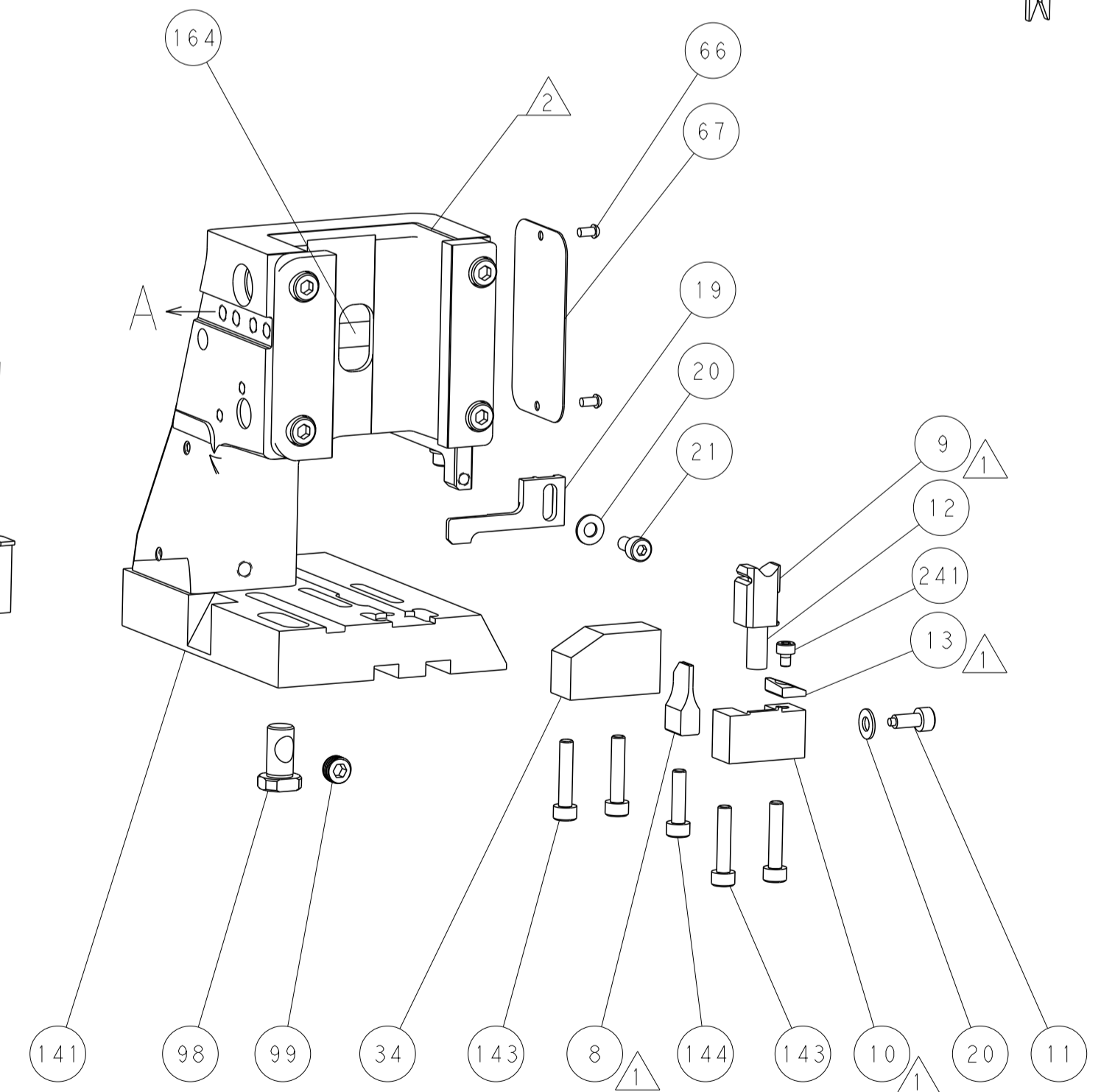
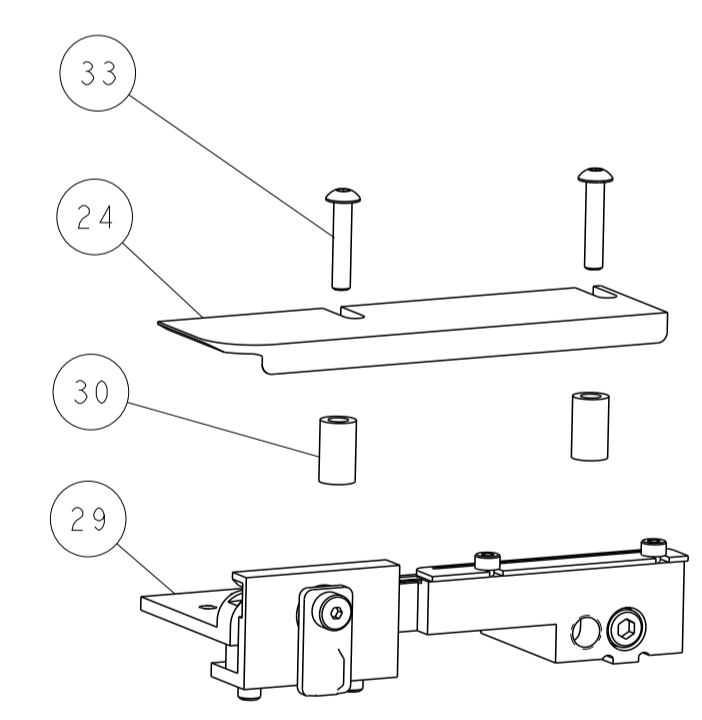
MECHANICAL POST FEED



MECHANICAL PRE FEED



AIR FEED



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 18DEC2012		TE Connectivity Harrisburg, PA 17105-3608	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	APVD S. XI 18DEC2012	NAME Ocean Side Feed Applicator
MATERIAL	FINISH	WEIGHT	SCALE	SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
			1:2	A1	00779	©=2151422	
Customer Accessible Production Drawing				SHEET 4 OF 4 REV C1			