

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART						
					CONVERT TO	PART NUMBERS REQUIRED					
	2151759-2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	SERVO LATCH PLATE	2119951-1	-	8-2151759-5	1901094-3	-	2168400-6 (QUANTITY 2)
	2151759-5	A	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE	SMART APPLICATOR	2161326-1	-	8-2151759-4	-	-	-
	2151759-6	A	NON-CRIMP HEIGHT ADJUST	SERVO LATCH PLATE	PNEUMATIC FEED	2119950-1	1338683-8	5-18022-5	2119641-1	2119799-1	2063440-1
	2151759-7	A	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	-
	7-2151759-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-

APPLICATOR DATA		
CRIMP SIZE	TYPE	
WIRE 4.00 mm [.157]	F	
INSUL 8.50 mm [.335]	F	
APPLICATOR INSTRUCTIONS 408-10389		

TERMINAL DATA: YAZAKI TERMINAL		YAZAKI CRIMP SPECIFICATION	
TERMINAL NAME: L TYPE CONNECTOR, MALE TERMINAL			
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE		
7.50-8.50 mm [.295-.335 IN]	Ø3.80-4.90 mm [.150-.193 IN]		
TERMINAL APPLICATION SPECIFICATION	72-WT08-076 Rev WA1743		
TERMINALS APPLIED			
TE TERMINAL	YAZAKI TERMINAL	TE TERMINAL	YAZAKI TERMINAL
1949968-1	7114-3251		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
4.00mm2	2.65+/-0.05 [.104+/- .002]	3.5
3.00mm2	2.30+/-0.05 [.091+/- .002]	7.8

- 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. SEE BELOW FOR PART NUMBER:  
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151759-4  
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151759-5  
 SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2151759-6
- 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. FOR -6 ONLY APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 37 & 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. ADJUSTMENT MAY BE NECESSARY WHEN RUNNING APPLICATOR IN THE FIELD.
- 10 TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- 11 TO CONVERT THE APPLICATOR TO A NON-CARRIER CUTTING STYLE, REMOVE ITEM 13 AND ATTACH TO THE LOCATION ON THE BACK SIDE OF THE HOUSING. REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.
- 12 WHEN ASSEMBLING A NON CRIMP HEIGHT ADJUST APPLICATOR (-6) USE SHIMS FROM ITEM 260 TO ACHIEVE A NOMINAL SHIM HEIGHT OF 3.15.

**\*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.

ITEM NO	DESCRIPTION	ITEM NO
- 2	SCR, SKT HD CAP, RoHS, M3 X 8.0	269
- 1	FENCE	267
- 1	APPLICATOR SHIM PACK	260
- 1	SPACER, PRECISION	259
- 1	O-RING, .676 ID, .070 DIA. MAT.	252
- 1	PUSH ROD, AIR FEED	250
- 1	BUSHING, LCH5-12, MISUMI	249
- 1	FEED CAM, AIR FEED	248
- 1	DETENT PIN	247
- 1	SPRING, COMPRESSION	246
-77	PART NO	DESCRIPTION

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

SET UP GAUGE	LOC	DIST	REVISIONS			
2119599-1	A	66	REV	DATE	BY	APPV
			A	RELEASED	08FEB2013	RK

REV	DATE	BY	APPV	DESCRIPTION	DATE	BY	APPV
-	-	1	-	2161314-1	RAM, STEPPED, AMP STYLE, SIDE FEED, NON-ADJUST		245
-	1	1	1	2119082-8	CAM, SNAIL, INSULATION ADJUSTMENT		244
-	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST		243
-	1	1	1	2119083-1	RETAINER, INSULATION DIAL		242
-	1	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0		241
-	-	2	2	2168400-6	SHCS, LOW HEAD, RoHS, M5 X 16		240
-	-	-	-	2063440-1	AIR FEED MODULE		238
-	-	1	1	2119740-2	TAG, IDENTIFICATION		213
-	-	1	1	1901094-3	SPACER, FEEDER		198
-	-	-	-	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT		172
-	1	1	1	994969-1	MAGNET, RARE EARTH HIGH ENERGY		166
-	REF	REF	REF	994970-2	COUNTER, MAGNETIC		164
-	-	-	-	240638-1	SPRING, FEED FINGER		163
-	-	-	-	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854		137
-	-	-	-	2119799-1	HOLDER, FEED FINGER, AF		136
-	-	REF	REF	SEE NOTE 4	MEMORY CHIP, PROGRAMMED		135
-	-	1	1	1633743-1	SERVO FEED LATCH ASM		133
-	1	1	1	1-18028-2	WASHER, FLAT, REG M4		119
-	-	REF	REF	2119944-1	FEED FINGER ASSEMBLY, SF		117
-	1	1	1	1-690438-0	FRONT STRIP GUIDE		96
-	2	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0		95
-	1	1	1	1-455888-3	SPACER, CRIMPER		82
-	2	2	2	2079383-4	SCR, BHSC, RoHS (M4 X 8)		79
-	1	1	1	1633470-2	EXTENSION PLATE		78
-	1	1	1	2119956-1	DOCUMENTATION PACKAGE		71
-	1	-	-	2119740-1	TAG, IDENTIFICATION		67
-	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS		66
-	1	-	1	2119793-1	LIMITER, ADJUSTMENT BOLT		63
-	3	-	3	992763-5	SCR, SET, SOC, CONE POINT, M3 X 4.0		62
-	2	2	2	2-18032-5	SCR, SET, FLT POINT M5 X 20.0		61
-	1	1	1	2079383-4	SCR, BHSC, RoHS (M4 X 8)		60
-	-	-	-	5-18022-5	SCR, HEX HD CAP, M4 X 6.0		59
-	-	-	-	1338683-8	FEED PAWL		56
-	4	4	4	2168400-1	SHCS, LOW HEAD, RoHS, M4 X 12		54
-	2	2	2	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16		53
-	1	1	1	5018030-1	NUT, HEX, REG, RoHS, M3		52
-	1	1	1	811242-5	BUMPER, HOLD DOWN		51
-	1	1	1	690753-2	SPACER, TONKER		50
-	-	-	-	18023-9	SCR, SKT HD CAP M4 X 6.0		49
-	1	1	1	2119656-9	APPLICATOR BASIC ASSEMBLY, SF		46
-	1	-	1	2161311-1	RAM, STEPPED, AMP STYLE, SIDE FEED		44
-	1	1	1	1-2079383-5	SCR, BHSC, RoHS (M8 X 40)		41
-	1	-	1	2119645-1	DISC, NUMBERED FA WIRE ADJUSTMENT		40
-	1	-	1	2119957-1	APPLICATOR SHIM PACK		39
-	1	1	1	2119644-2	RAM WASHER, PRECISION		38
-	1	1	1	2119085-1	FA HEAD, ATLANTIC STYLE		37
-	1	-	1	2119092-1	BOLT, ADJUSTMENT		35
-	1	1	1	2-1752356-0	SUPPORT, TERMINAL		34
-	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)		33
-	1	1	1	2161328-1	HEX HEAD, FLANGED, M5 X 8mm LONG		32
-	1	1	1	1320908-8	SPACER, STRIP GUIDE		30
-	1	1	1	2119959-3	ASSEMBLY, STRIP GUIDE		29
-	1	1	1	1-455888-0	SPACER, CRIMPER		28
-	2	2	2	22283-1	SPRING, COMPRESSION		27
-	1	1	1	356835-1	LEVER, DRAG RELEASE		26
-	1	1	1	240792-1	DRAG, TERMINAL		25
-	1	1	1	1320928-6	STRIP GUIDE		24
-	1	1	1	980371-4	SCR, SKT HD SHLDR 5.0 DIA X 6.0		23
-	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0		21
-	1	1	1	1-18028-2	WASHER, FLAT, REG M4		20
-	1	1	1	2119533-1	STRIPPER, SIDE FEED		19
-	1	1	1	2119806-1	INSERT, SHEAR		13
-	1	1	1	3-22280-3	SPRING, COMPRESSION		12
-	1	1	1	1-356885-3	STOP, SHEAR		11
-	1	1	1	2119805-1	SHEAR HOLDER, FRONT		10
-	1	1	1	318707-1	FLOATING SHEAR, FRONT		9
1	1	1	1	1-1633930-1	ANVIL, COMBINATION		8
-	1	1	1	240641-3	SPACER		7
-	1	1	1	1-2119757-0	DEPRESSOR, SHEAR		5
-	1	1	1	238011-3	BLOCK, CRIMPER SPACER		4
1	1	1	1	6-2119582-3	CRIMPER, INSULATION F PREMIUM		3
-	1	1	1	1-455888-2	SPACER, CRIMPER		2
1	1	1	1	1-1633738-1	CRIMPER, WIRE		1
-77	-7	-6	-5	-2	PART NO	DESCRIPTION	ITEM NO

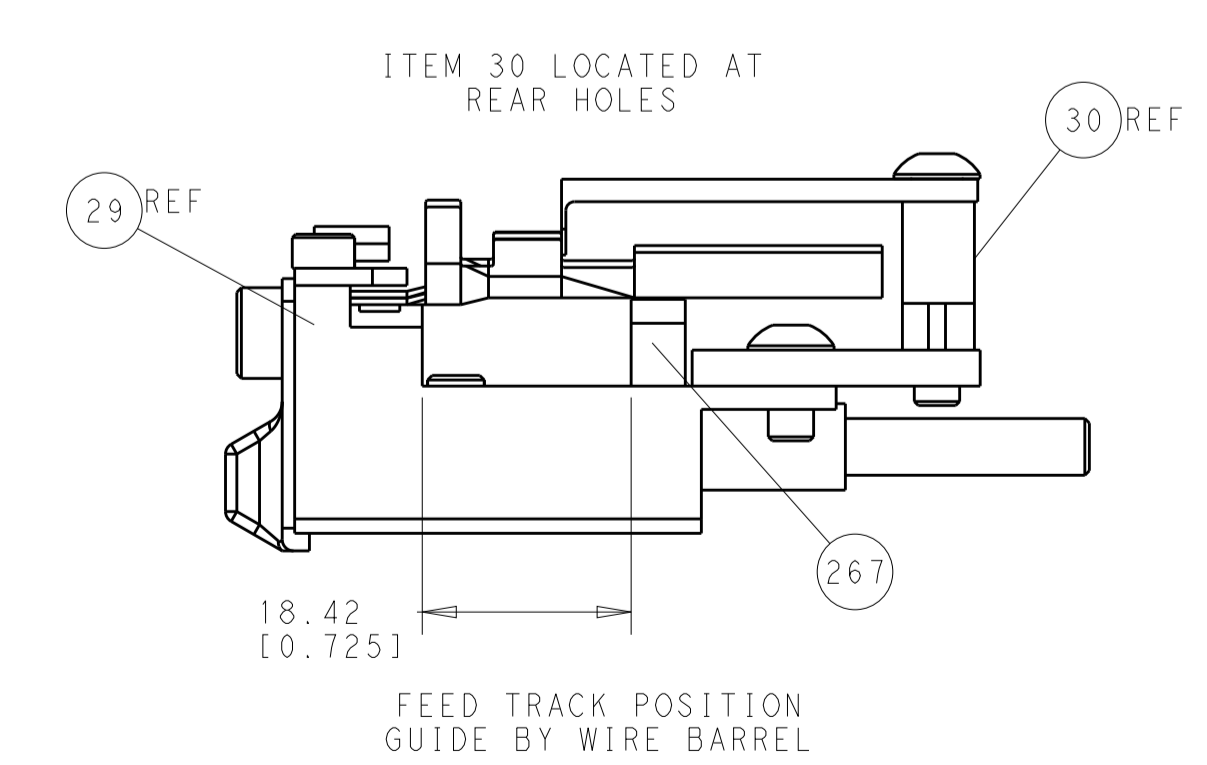
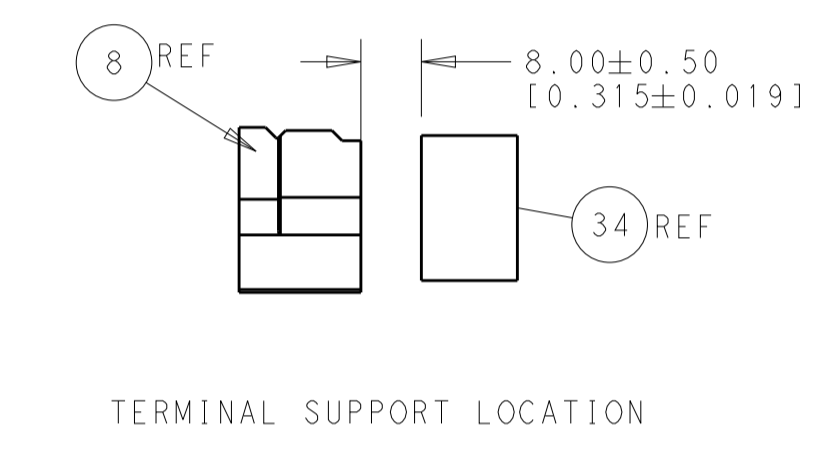
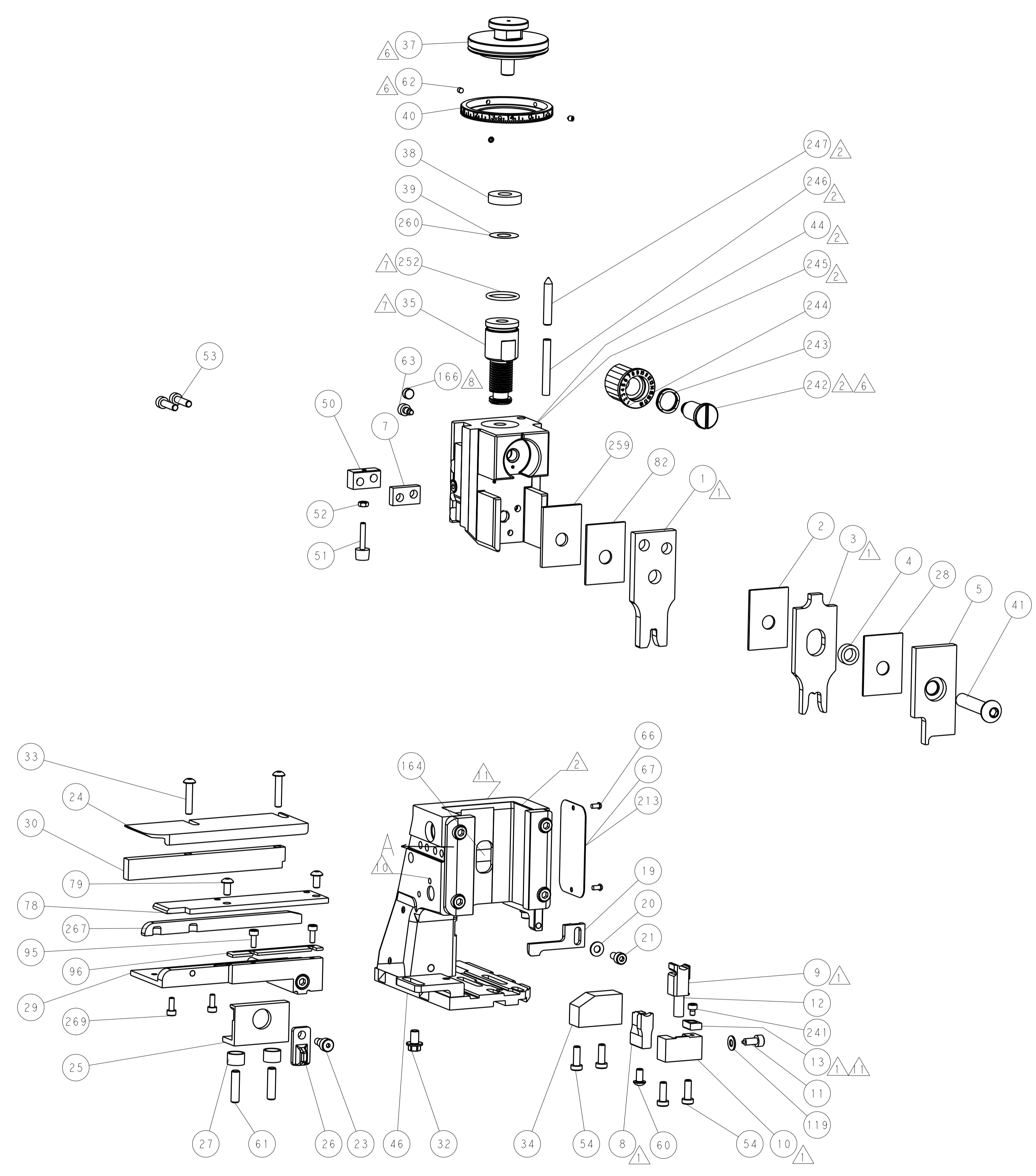
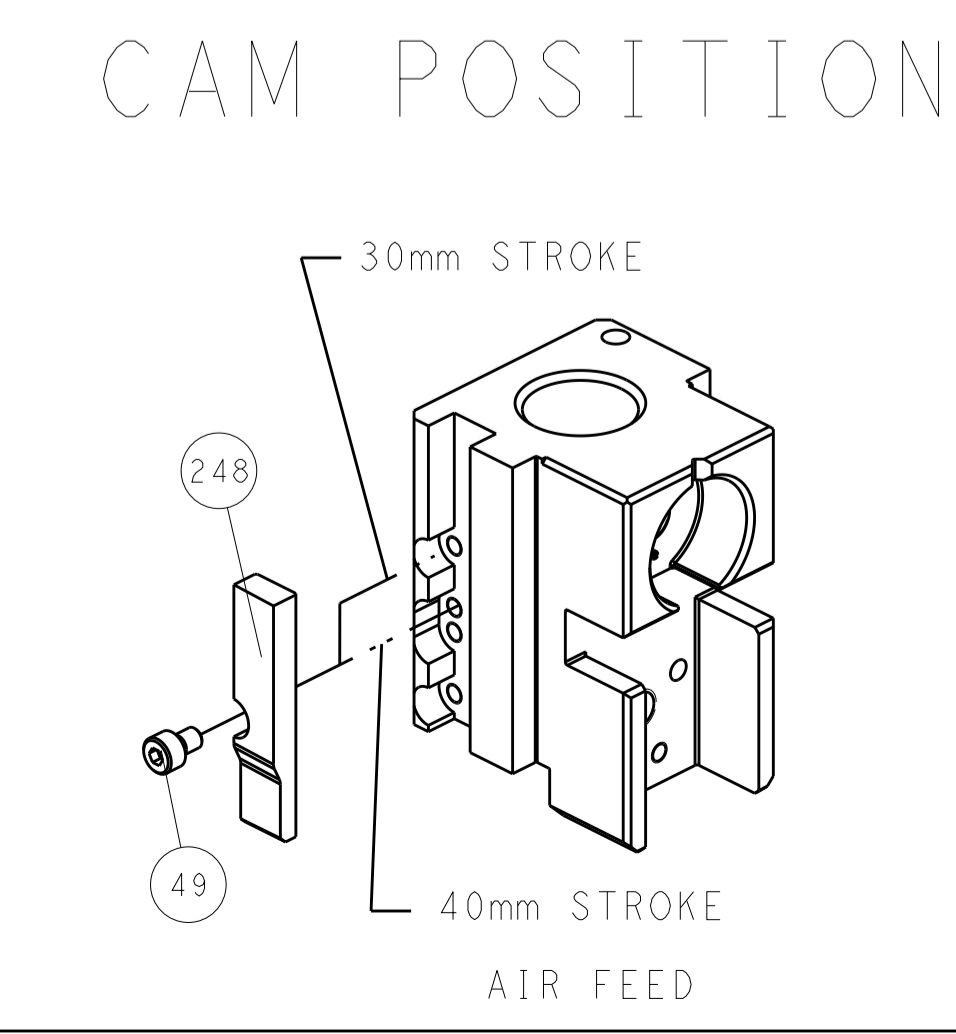
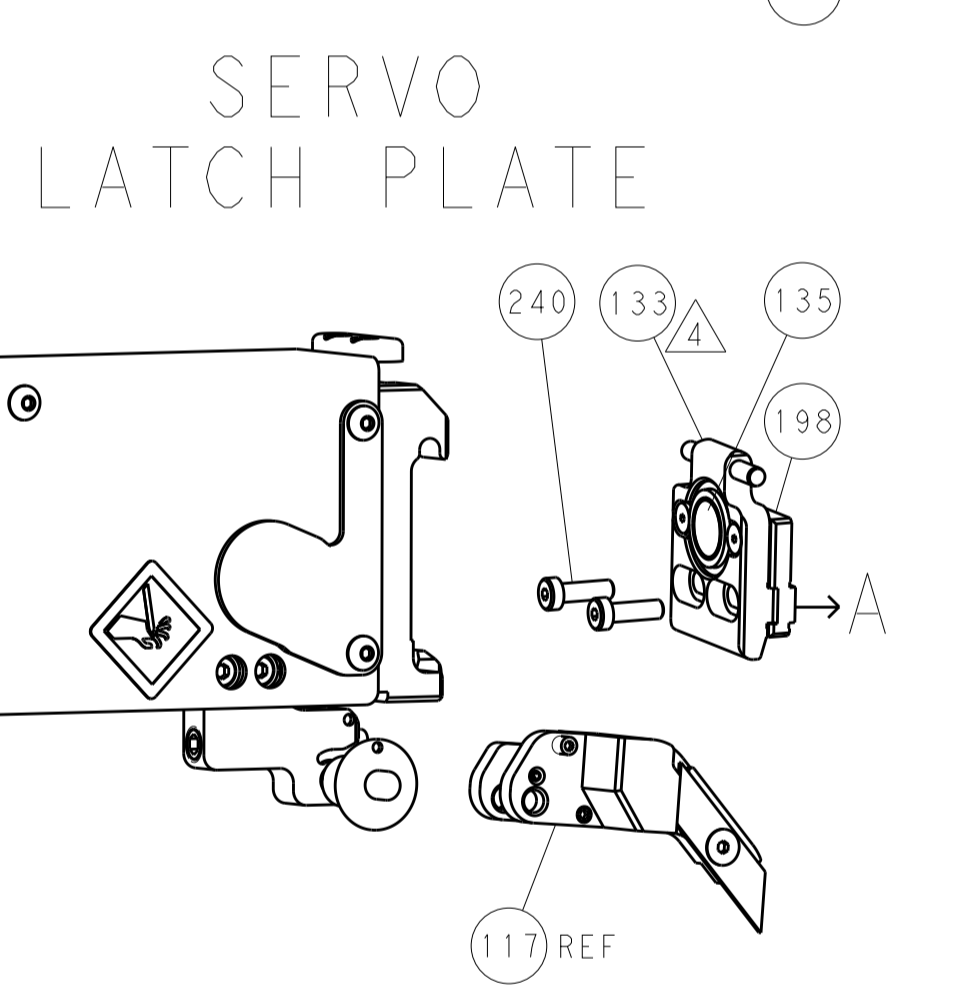
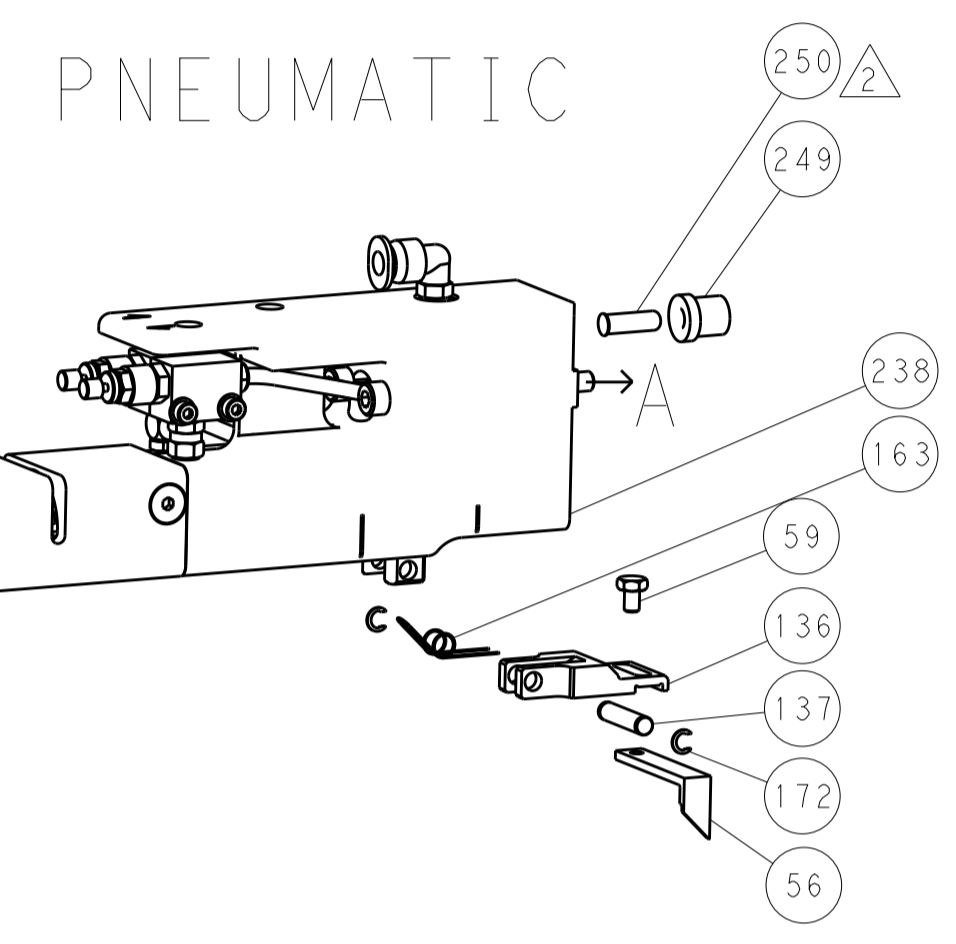
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		MATERIAL:		FINISH:	
mm	0 PLC ±.1	1 PLC ±0.1	2 PLC ±0.02	3 PLC ±0.005	4 PLC ±0.0005	ANGLES ±.1	

DATE	BY	CHK	APPV	NAME	SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
13NOV2012	BOB HIGMAN				A1	00779	2151759	
13NOV2012	G. BAILEY							
13NOV2012	M. CLIFFORD							

Customer Accessible Production Drawing SCALE 1:1 SHEET 1 OF 4 REV A

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

DIMENSIONING AND TOLERANCING PER ASME Y14.5M-2009



**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:		DWG: BOB HIGMAN 13NOV2012		TE Connectivity	
mm	0 PLC ±0.1	1 PLC ±0.1	2 PLC ±0.02	3 PLC ±0.005	4 PLC ±0.0005	CHG: G. BAILEY 13NOV2012	Harrisburg, PA 17105-3608
MATERIAL:		FINISH:		APVD: M. CLIFFORD 13NOV2012		NAME: Ocean Side Feed Applicator	
Customer Accessible Production Drawing		SCALE: 1:1		SHEET 2 OF 4		REV A	

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART							
				CONVERT TO	PART NUMBERS REQUIRED						
2-2151759-2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	SERVO LATCH PLATE	2119951-1	-	8-2151759-5	1901094-3	-	-	2168400-6 (QUANTITY 2)
				SMART APPLICATOR	2161326-1	-	8-2151759-4	-	-	-	-
2-2151759-5	A	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE	-	-	-	-	-	-	-	-
2-2151759-7	A	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	-	-
7-2151759-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-	-

SET UP GAUGE	LOC	DIST	REVISIONS				
2119599-1	A	66	P	LTN	DATE	DWN	APVD
			-	-	SEE SHEET 1	-	-

APPLICATOR DATA		
CRIMP WIRE	SIZE	TYPE
	4.00 mm [ .157 ]	F
INSUL	8.50 mm [ .335 ]	F
APPLICATOR INSTRUCTIONS 408-10389		

TERMINAL DATA: YAZAKI TERMINAL YAZAKI CRIMP SPECIFICATION	
TERMINAL NAME: L TYPE CONNECTOR, MALE TERMINAL	
WIRE STRIP LENGTH 7.50-8.50 mm [ .295-.335 IN ]	INSULATION DIAMETER RANGE ∅3.80-4.90 mm [ .150-.193 IN ]
TERMINAL APPLICATION SPECIFICATION 72-WT08-076 Rev WA1743	
TERMINALS APPLIED	
TE TERMINAL	YAZAKI TERMINAL
1949968-1	7114-3251

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
4.00mm2	2.65+/-0.05 [ .104+/- .002 ]	3.5
3.00mm2	2.30+/-0.05 [ .091+/- .002 ]	7.8

- RECOMMENDED SPARE PARTS
- GREASE BEARING SURFACES LIGHTLY
- 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:  
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151759-4  
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151759-5
- 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.
- TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- 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.

ITEM NO	DESCRIPTION	ITEM NO
269	SCR, SKT HD CAP, RoHS, M3 X 8.0	269
267	FENCE	267
259	SPACER, PRECISION	259
251	FINE ADJUST HEAD ASM, PACIFIC STYLE	251
250	PUSH ROD, AIR FEED	250
249	BUSHING, LCH5-12, MISUMI	249
246	SPRING, COMPRESSION	246
244	CAM, SNAIL, INSULATION ADJUSTMENT	244
243	WASHER, WAVE SPRING, CREST-TO-CREST	243
242	RETAINER, INSULATION DIAL	242
-77	PART NO	-77

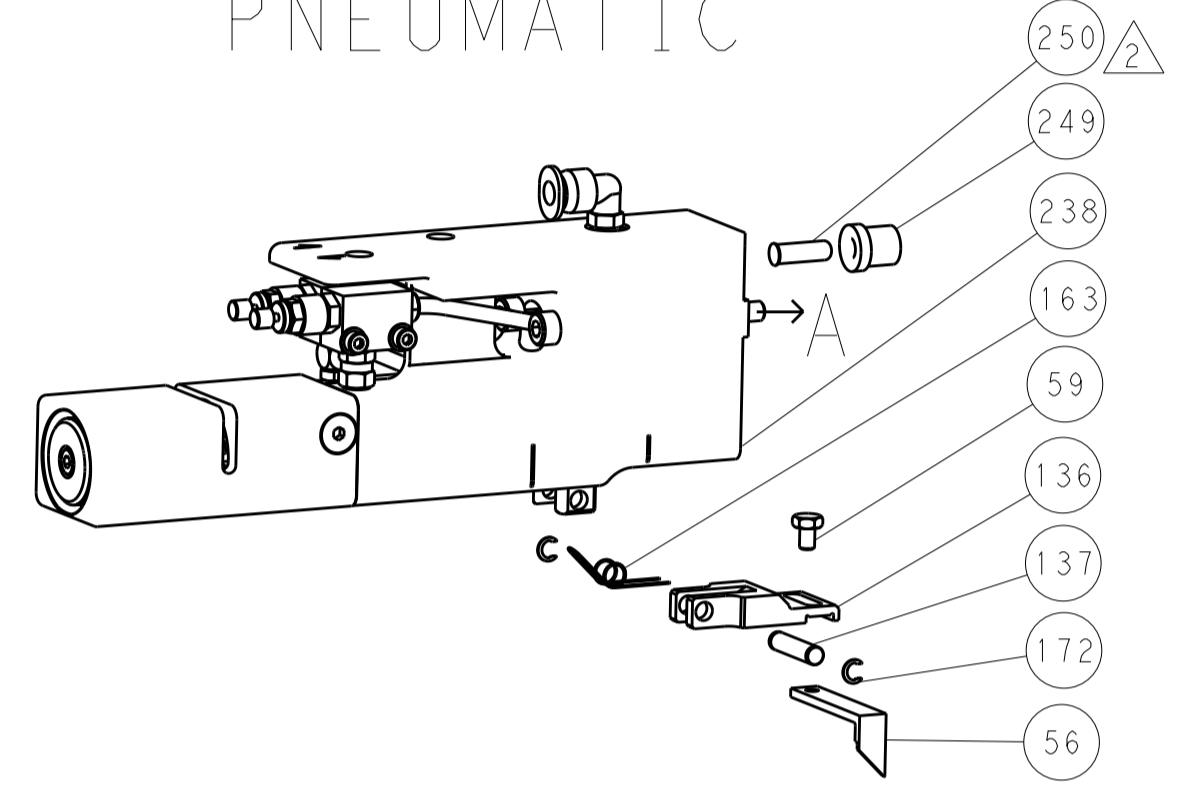
ITEM NO	DESCRIPTION	ITEM NO
241	SCR, SKT HD CAP M3 X 4.0	241
240	SHCS, LOW HEAD, RoHS, M5 X 16	240
238	AIR FEED MODULE	238
213	TAG, IDENTIFICATION	213
198	SPACER, FEEDER	198
172	RING, RETAIN, EXTERN, 3/16 CRESCENT	172
166	MAGNET, RARE EARTH HIGH ENERGY	166
164	COUNTER, MAGNETIC	164
163	SPRING, FEED FINGER	163
152	O-RING, .801 ID, .070 DIA. MAT.	152
151	FEED CAM, AIR FEED	151
145	DETENT PIN	145
144	SCR, BHSC, RoHS (M4 X 16)	144
143	SHCS, LOW HEAD, RoHS, M4 X 20	143
142	FEED CAM, POST FEED	142
141	APPLICATOR BASIC ASSEMBLY, SF	141
140	RAM, STEPPED, ASIAN STYLE, SIDE FEED	140
139	BOLT, ADJUSTMENT	139
137	PIN, RETAIN, GRVD, 3/16 X .854	137
136	HOLDER, FEED FINGER, AF	136
135	MEMORY CHIP, PROGRAMMED	135
133	SERVO FEED LATCH ASM	133
119	WASHER, FLAT, REG M4	119
117	FEED FINGER ASSEMBLY, SF	117
96	FRONT STRIP GUIDE	96
95	SCR, SKT HD CAP, RoHS, M3 X 8.0	95
82	SPACER, CRIMPER	82
79	SCR, BHSC, RoHS (M4 X 8)	79
78	EXTENSION PLATE	78
71	DOCUMENTATION PACKAGE	71
67	TAG, IDENTIFICATION	67
66	SCREW, DRIVE, RH, RoHS	66
63	LIMITER, ADJUSTMENT BOLT	63
62	SCR, SET, SOC, CONE POINT, M3 X 4.0	62
61	SCR, SET, FLT POINT M5 X 20.0	61
59	SCR, HEX HD CAP, M4 X 6.0	59
56	FEED PAWL	56
54	SHCS, LOW HEAD, RoHS, M4 X 12	54
53	SCR, SKT HD CAP, RoHS, M4 X 16	53
52	NUT, HEX, REG, RoHS, M3	52
51	BUMPER, HOLD DOWN	51
50	SPACER, TONKER	50
49	SCR, SKT HD CAP M4 X 6.0	49
41	SCR, BHSC, RoHS (M8 X 40)	41
40	DISC, NUMBERED FA WIRE ADJUSTMENT	40
39	APPLICATOR SHIM PACK	39
38	RAM WASHER, PRECISION	38
34	SUPPORT, TERMINAL	34
33	SCR, BHSC, RoHS (M4 X 20)	33
32	HEX HEAD, FLANGED, M5 X 8mm LONG	32
30	SPACER, STRIP GUIDE	30
29	ASSEMBLY, STRIP GUIDE	29
28	SPACER, CRIMPER	28
27	SPRING, COMPRESSION	27
26	LEVER, DRAG RELEASE	26
25	DRAG, TERMINAL	25
24	STRIP GUIDE	24
23	SCR, SKT HD SHLDR 5.0 DIA X 6.0	23
21	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
20	WASHER, FLAT, REG M4	20
19	STRIPPER, SIDE FEED	19
13	INSERT, SHEAR	13
12	SPRING, COMPRESSION	12
11	STOP, SHEAR	11
10	SHEAR HOLDER, FRONT	10
9	FLOATING SHEAR, FRONT	9
8	ANVIL, COMBINATION	8
7	SPACER	7
5	DEPRESSOR, SHEAR	5
4	BLOCK, CRIMPER SPACER	4
3	CRIMPER, INSULATION F PREMIUM	3
2	SPACER, CRIMPER	2
1	CRIMPER, WIRE	1
-77	PART NO	-77

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

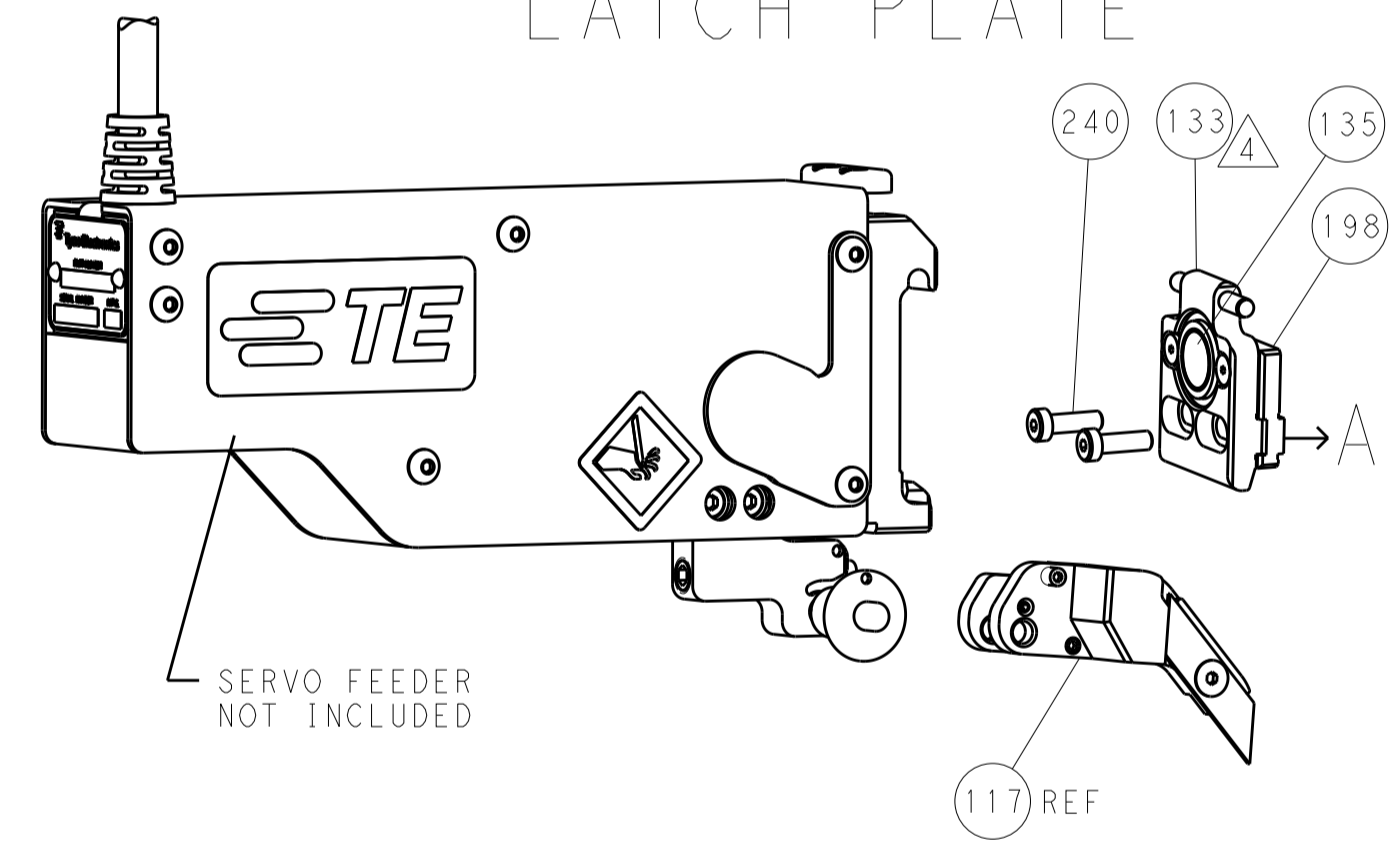
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LOC		DIST		REVISIONS			
A	66	P	LTM	DESCRIPTION	DATE	DMN	APVD
		-	-	SEE SHEET 1	-	-	-

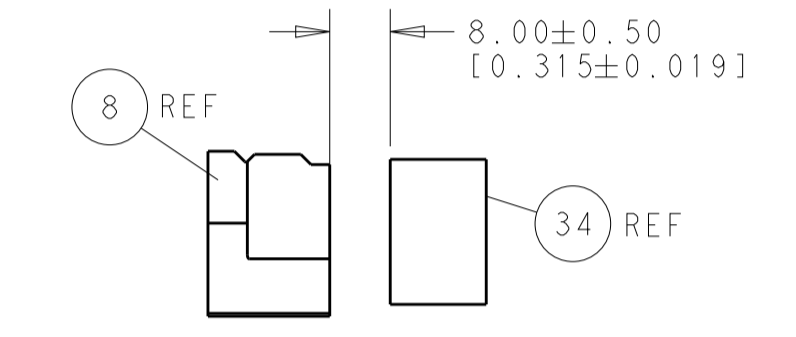
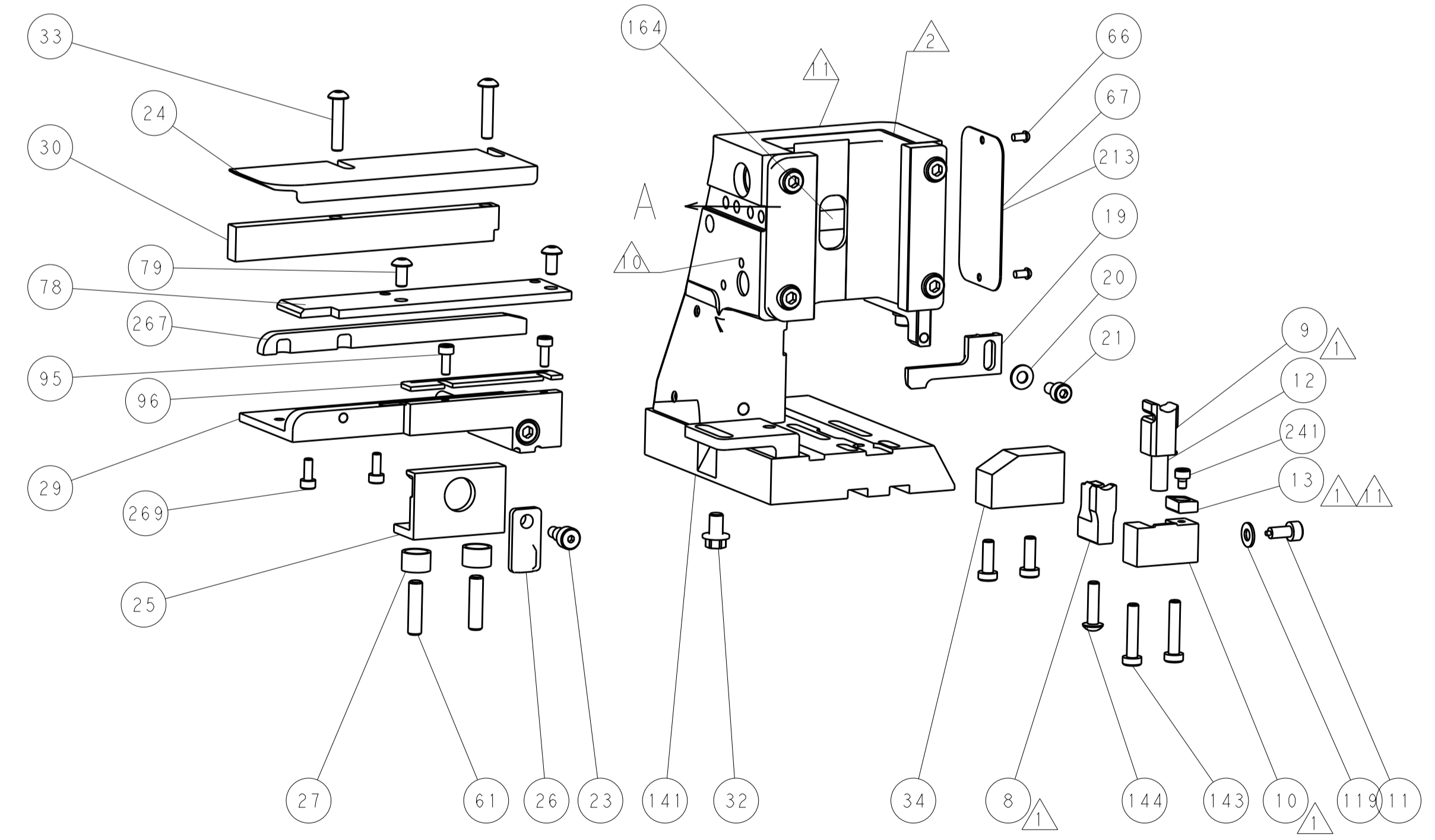
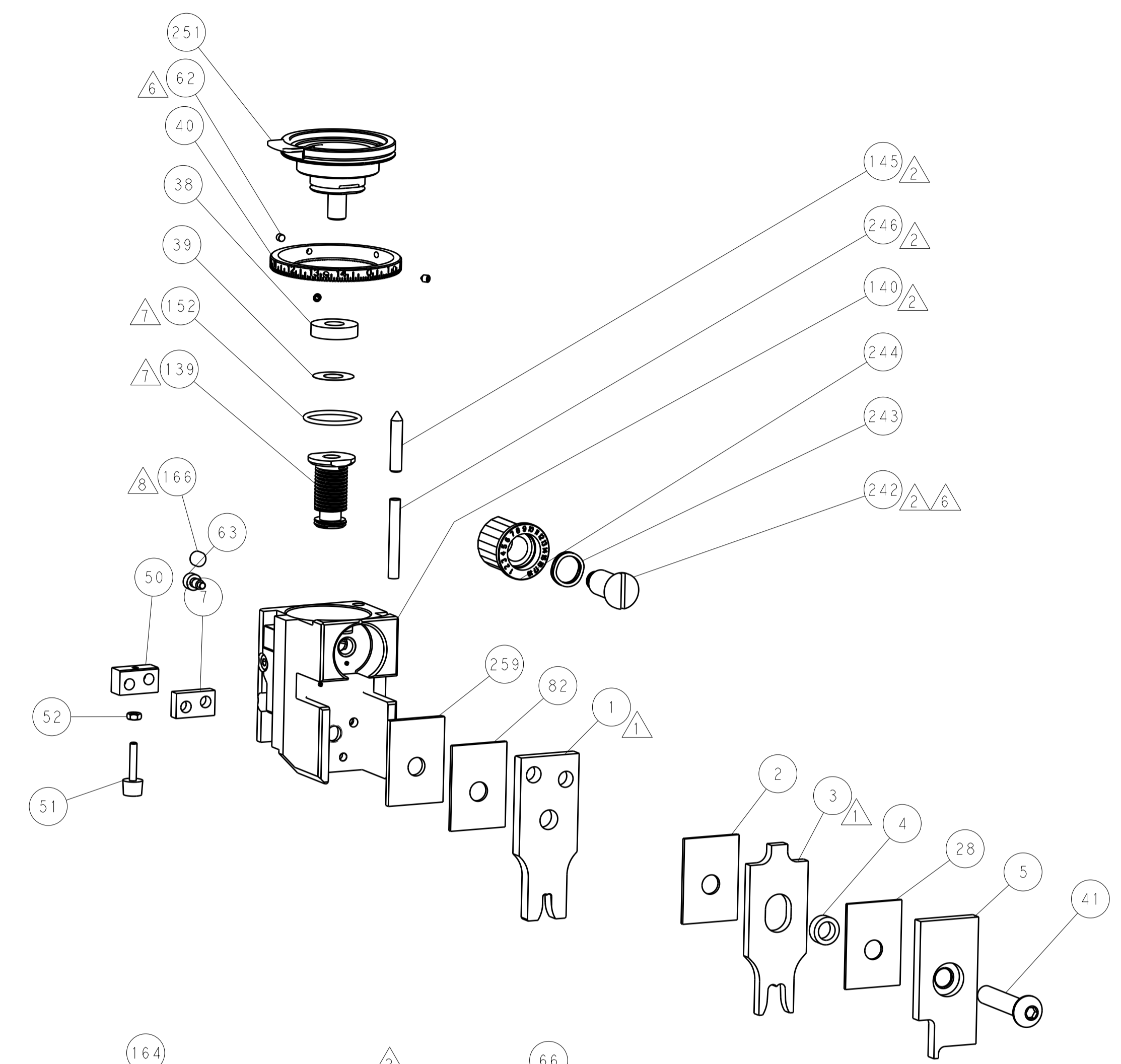
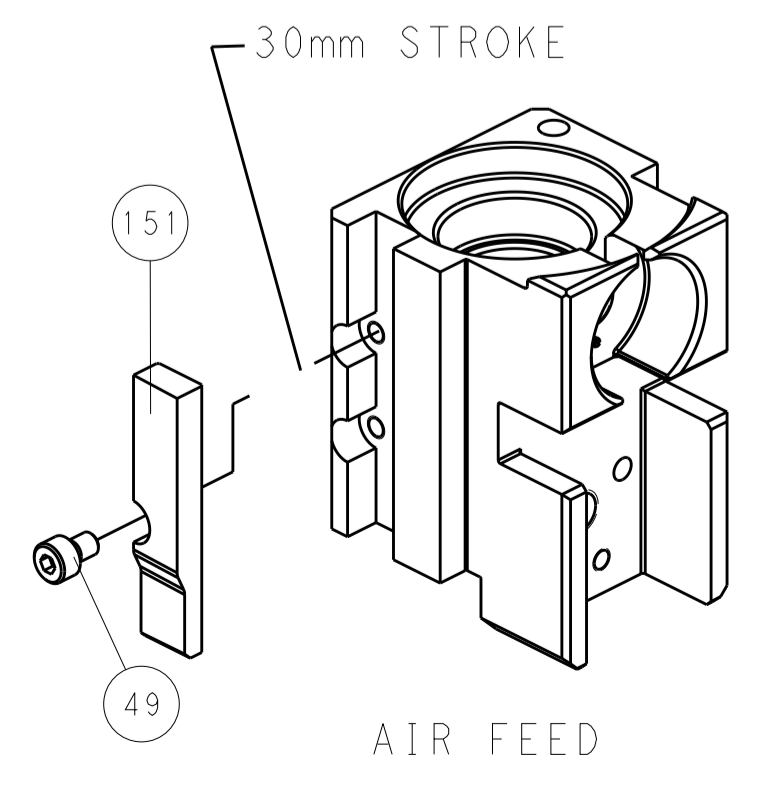
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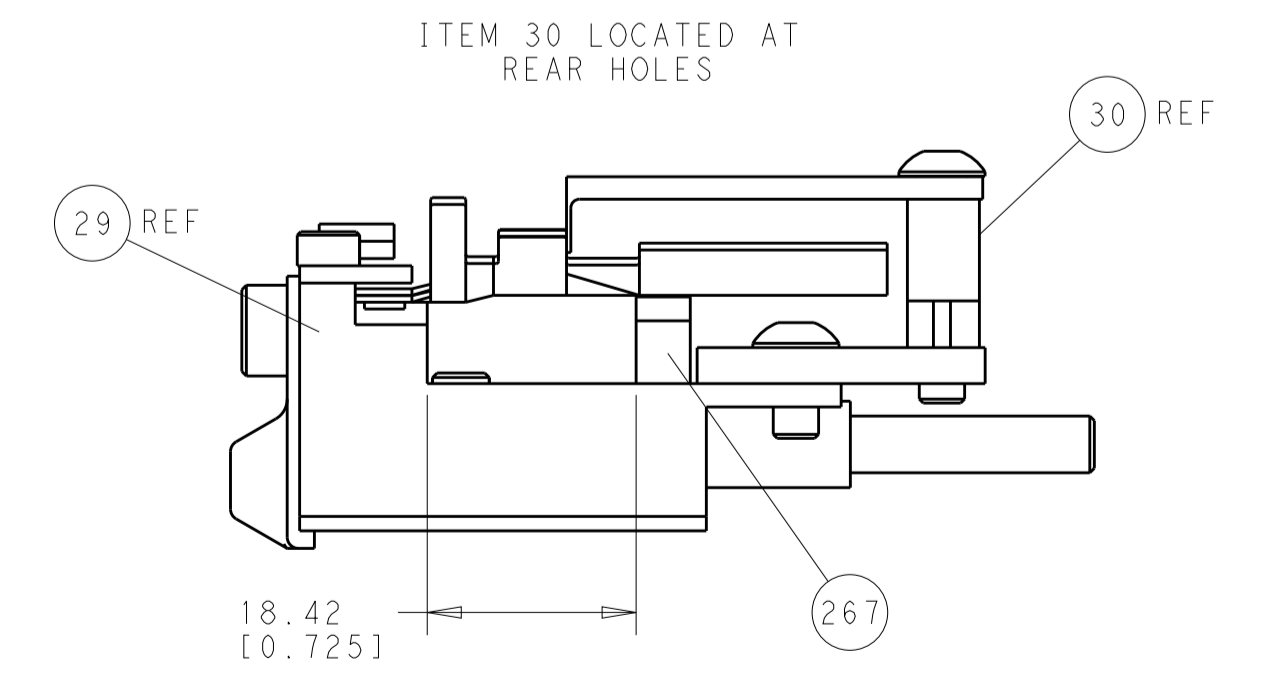
SERVO LATCH PLATE



CAM POSITION



TERMINAL SUPPORT LOCATION



FEED TRACK POSITION GUIDE BY WIRE 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:		DWG: BOB HIGMAN 13NOV2012		TE Connectivity	
mm	0 PLC ±0.1	1 PLC ±0.1	2 PLC ±0.02	3 PLC ±0.005	4 PLC ±0.0005	APVD: M. CLIFFORD 13NOV2012	Harrisburg, PA 17105-3608
MATERIAL:		FINISH:		NAME: Ocean Side Feed Applicator		RESTRICTED TO:	
				SIZE: A1		CAGE CODE: 00779	
				DRAWING NO: C=2151759		SCALE: 1:1	
				SHEET: 4		OF: 4	
				REV: A			