

| ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER | PART NUMBER | REVISION | DESCRIPTION              | FEED TYPE         | APPLICATOR STYLE CONVERSION CHART |                       |           |             |           |             |                        |
|---|-------------|----------|--------------------------|-------------------|-----------------------------------|-----------------------|-----------|-------------|-----------|-------------|------------------------|
|   |             |          |                          |                   | CONVERT TO                        | PART NUMBERS REQUIRED |           |             |           |             |                        |
|   | 2151403-2   | B        | FINE CRIMP HEIGHT ADJUST | PNEUMATIC         | -                                 | -                     | -         | -           | -         | -           |                        |
|   | 2151403-5   | B        | FINE CRIMP HEIGHT ADJUST | SERVO LATCH PLATE | SERVO LATCH PLATE                 | 2119951-1             | -         | 8-2151403-5 | 1901094-3 | 2-1752354-2 | 2168400-6 (QUANTITY 2) |
|   | 2151403-6   | B        | NON-CRIMP HEIGHT ADJUST  | SERVO LATCH PLATE | PNEUMATIC FEED                    | 2119950-1             | 1338683-8 | 5-18022-5   | 2119641-1 | 2119799-1   | 2063440-1              |
|   | 2151403-7   | B        | FINE CRIMP HEIGHT ADJUST | NONE              | -                                 | -                     | -         | -           | -         | -           | -                      |
|   | 7-2151403-7 | B        | CRIMP TOOLING KIT        | -                 | -                                 | -                     | -         | -           | -         | -           | -                      |
|   |             |          |                          |                   |                                   |                       |           |             |           |             |                        |
|   |             |          |                          |                   |                                   |                       |           |             |           |             |                        |

| APPLICATOR DATA |                |      |
|-----------------|----------------|------|
| CRIMP           | SIZE           | TYPE |
| WIRE            | 3.05 mm [.120] | F    |
| INSUL           | 3.81 mm [.150] | OV   |

APPLICATOR INSTRUCTIONS  
408-10389

| TERMINAL DATA: YAZAKI TERMINAL YAZAKI CRIMP SPECIFICATION |                                |                              |                 |
|---|--------------------------------|------------------------------|-----------------|
| TERMINAL NAME: 6.3mm YESC UNSEALED MALE TERMINAL          |                                |                              |                 |
| WIRE STRIP LENGTH   |                                | INSULATION DIAMETER RANGE    |                 |
| 5.00-5.50 mm [.197-.217 IN]                               |                                | Ø2.20-3.40 mm [.087-.134 IN] |                 |
| TERMINAL APPLICATION SPECIFICATION                        | YPES-72-WT10-1433-1 Rev WA1916 |                              |                 |
| TERMINALS APPLIED   |                                |                              |                 |
| TE TERMINAL   | YAZAKI TERMINAL                | TE TERMINAL                  | YAZAKI TERMINAL |
| 1949106-1   | 7114-4121-02                   |                              |                 |

| TERMINAL DATA: YAZAKI TERMINAL YAZAKI CRIMP SPECIFICATION |                                |                              |                 |
|---|--------------------------------|------------------------------|-----------------|
| TERMINAL NAME: 6.3mm YESC UNSEALED FEMALE TERMINAL        |                                |                              |                 |
| WIRE STRIP LENGTH   |                                | INSULATION DIAMETER RANGE    |                 |
| 5.00-5.50 mm [.197-.217 IN]                               |                                | Ø2.20-3.40 mm [.087-.134 IN] |                 |
| TERMINAL APPLICATION SPECIFICATION                        | YPES-72-WT10-1433-1 Rev WA1916 |                              |                 |
| TERMINALS APPLIED   |                                |                              |                 |
| TE TERMINAL   | YAZAKI TERMINAL                | TE TERMINAL                  | YAZAKI TERMINAL |
| 1949107-1   | 7116-4121-02                   |                              |                 |

| WIRE SIZE   | CRIMP HEIGHT mm [INCH]     | CRIMP HEIGHT REFERENCE SETTING |
|-------------|----------------------------|--------------------------------|
| 2.50mm2     | 1.85+/-0.05 [.073+/- .002] | 7.5                            |
| 2.00mm2     | 1.75+/-0.05 [.069+/- .002] | 7.5                            |
| 2 x 0.85mm2 | 1.65+/-0.05 [.065+/- .002] | 9.1                            |
| 1.50mm2     | 1.65+/-0.05 [.065+/- .002] | 9.1                            |

| WIRE SIZE   | CRIMP HEIGHT mm [INCH]     | CRIMP HEIGHT REFERENCE SETTING |
|-------------|----------------------------|--------------------------------|
| 2.50mm2     | 1.85+/-0.05 [.073+/- .002] | 7.5                            |
| 2.00mm2     | 1.75+/-0.05 [.069+/- .002] | 7.5                            |
| 2 x 0.85mm2 | 1.65+/-0.05 [.065+/- .002] | 9.1                            |
| 1.50mm2     | 1.65+/-0.05 [.065+/- .002] | 9.1                            |

- 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: 8-2151403-4  
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151403-5  
 SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2151403-6
- 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 & 180.  
 APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242.  
 FOR -6 ONLY APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 37 & 180.
- GREASE THREADS, GROOVE AND O-RING ON ITEMS 35 & 252.
- MAGNET, ITEM 166 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 THE BACK SIDE OF THE HOUSING. REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.
- WHEN ASSEMBLING A NON CRIMP HEIGHT ADJUST APPLICATOR (-6) USE SHIMS FROM ITEM 260 TO ACHIEVE A NOMINAL SHIM HEIGHT OF 3.95.

**\*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  | -  | -  | 2119957-2 | APPLICATOR SHIM PACK            | 260     |
| -   | 1  | -  | 1  | 1  | 8-21084-0 | O-RING, .676 ID, .070 DIA. MAT. | 252     |
| -   | -  | -  | -  | 1  | 2119640-1 | PUSH ROD, AIR FEED              | 250     |
| -   | -  | -  | -  | 1  | 2079988-1 | BUSHING, LCH5-12, MISUMI        | 249     |
| -   | -  | -  | -  | 1  | 2119641-1 | FEED CAM, AIR FEED              | 248     |
| -77 | -7 | -6 | -5 | -2 | PART NO   | DESCRIPTION                     | ITEM NO |

**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   | P         | LTN | DESCRIPTION   | DATE      | OWN | APVD |
|              |  |     |      | 2         |     | REDESIGN      | 20AUG2014 | BH  | BH   |
|              |  |     |      | A         |     | RELEASED      | 17OCT2014 | BH  | TE   |
|              |  |     |      | B         |     | ECR-17-004921 | 05APR2017 | TB  | JDG  |

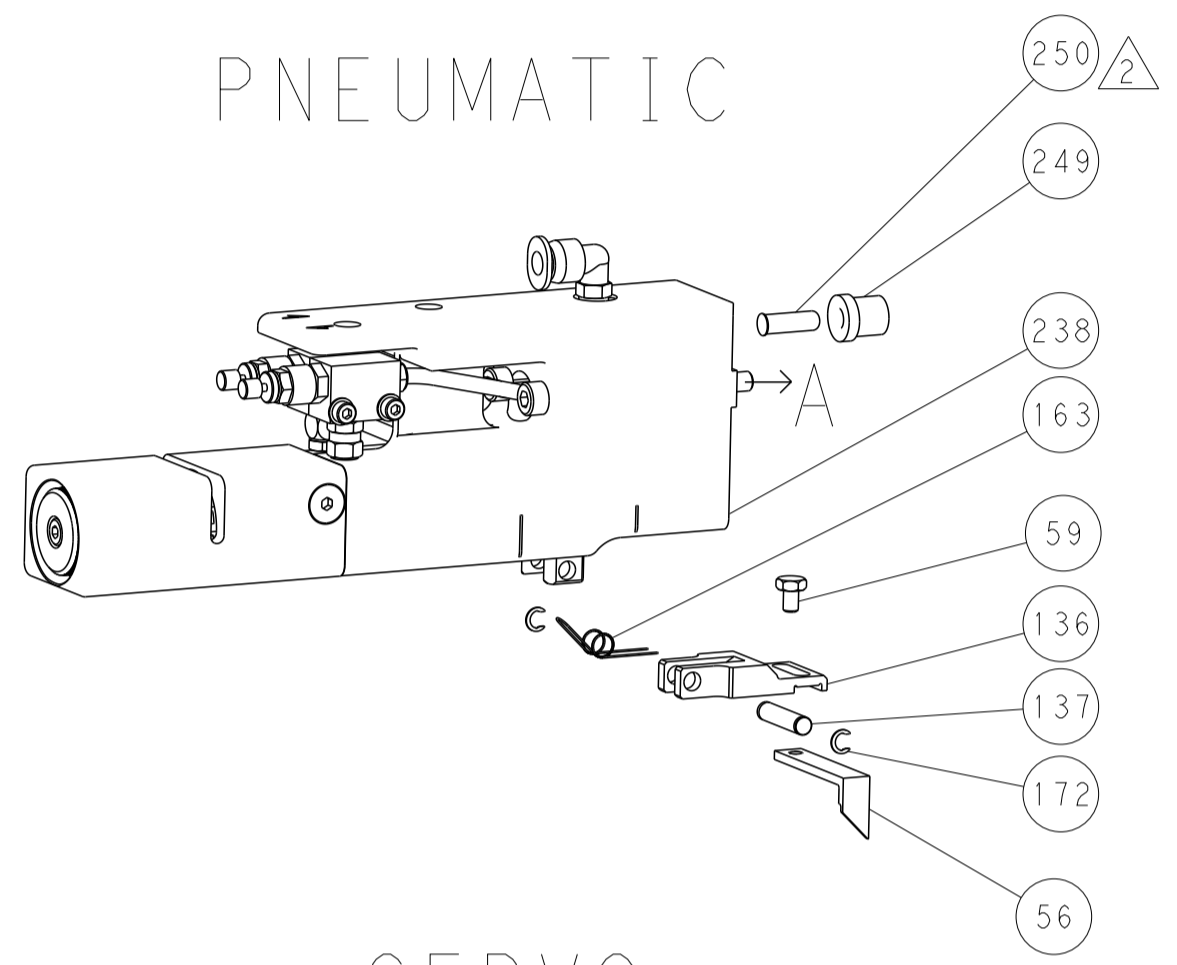
|     |     |     |     |     |             |                                     |         |
|-----|-----|-----|-----|-----|-------------|-------------------------------------|---------|
| -   | 1   | -   | 1   | 1   | 2119798-1   | DETENT PIN                          | 247     |
| -   | 1   | -   | 1   | 1   | 1-22279-3   | SPRING, COMPRESSION                 | 246     |
| -   | -   | 1   | -   | -   | 2119758-1   | RAM, AMP STYLE, SIDE FEED, NON-ADJ. | 245     |
| -   | 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     |
| -   | -   | 2   | 2   | -   | 2168400-6   | SHCS, LOW HEAD, RoHS, M5 X 16       | 240     |
| -   | -   | -   | -   | 1   | 2063440-1   | AIR FEED MODULE                     | 238     |
| -   | -   | 1   | 1   | -   | 2119740-2   | TAG, IDENTIFICATION                 | 213     |
| -   | -   | 1   | 1   | -   | 1901094-3   | SPACER, FEEDER                      | 198     |
| -   | 1   | 1   | 1   | 1   | 2-1752354-2 | STANDOFF, HOLD-DOWN                 | 180     |
| -   | 1   | 1   | 1   | 1   | 993111-1    | PIN, SLOTTED SPRING 3.0 X 20.0      | 177     |
| -   | 1   | 1   | 1   | 1   | 8-22280-7   | SPRING, COMPRESSION                 | 176     |
| -   | 1   | 1   | 1   | 1   | 1752353-2   | GUIDE PIN, HOLDDOWN                 | 175     |
| -   | 1   | 1   | 1   | 1   | 1901680-2   | GUIDE PIN, HOLDDOWN                 | 174     |
| -   | -   | -   | -   | 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   | 3-23627-7   | PIN, RETAIN, GRVD, 3/16 X .854      | 137     |
| -   | -   | -   | -   | 1   | 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     |
| -   | -   | REF | REF | -   | 2119944-1   | FEED FINGER ASSEMBLY, SF            | 117     |
| -   | 1   | 1   | 1   | 1   | 318563-1    | GUARD, FRONT CHIP                   | 89      |
| -   | 1   | 1   | 1   | 1   | 455888-5    | SPACER, CRIMPER                     | 82      |
| -   | 2   | 2   | 2   | 2   | 2079383-4   | SCR, BHSC, RoHS (M4 X 8)            | 79      |
| -   | 1   | 1   | 1   | 1   | 1803096-1   | EXTENSION PLATE                     | 78      |
| -   | 1   | 1   | 1   | 1   | 2119956-1   | DOCUMENTATION PACKAGE               | 71      |
| -   | 1   | 1   | 1   | 1   | 2119791-5   | DEPRESSOR, WIRE                     | 70      |
| -   | 1   | -   | -   | 1   | 2119740-1   | TAG, IDENTIFICATION                 | 67      |
| -   | 2   | 2   | 2   | 2   | 2168078-1   | SCREW, DRIVE, RH, RoHS, 2 x .188    | 66      |
| -   | 1   | -   | 1   | 1   | 2119793-1   | LIMITER, ADJUSTMENT BOLT            | 63      |
| -   | 3   | -   | 3   | 3   | 992763-5    | SCR, SET, SOC, CONE POINT, M3 x 4.0 | 62      |
| -   | 1   | 1   | 1   | 1   | 2079383-4   | SCR, BHSC, RoHS (M4 X 8)            | 60      |
| -   | -   | -   | -   | 1   | 5-18022-5   | SCR, HEX HD CAP, M4 X 6.0           | 59      |
| -   | -   | -   | -   | 1   | 1338683-8   | FEED PAWL                           | 56      |
| -   | 4   | 4   | 4   | 4   | 2168400-1   | SHCS, LOW HEAD, RoHS, M4 X 12       | 54      |
| -   | 1   | 1   | 1   | 1   | 1-5018030-0 | NUT, HEX, REG, RoHS, M3.5           | 52      |
| -   | 1   | 1   | 1   | 1   | 1901681-9   | HOLDDOWN, TERMINAL                  | 51      |
| -   | -   | -   | -   | 1   | 18023-9     | SCR, SKT HD CAP M4 X 6.0            | 49      |
| -   | 1   | 1   | 1   | 1   | 2119656-9   | APPLICATOR BASIC ASSEMBLY, SF       | 46      |
| -   | 1   | -   | 1   | 1   | 2119370-1   | RAM, AMP STYLE, SIDE FEED           | 44      |
| -   | 1   | 1   | 1   | 1   | 2079383-7   | SCR, BHSC, RoHS (M8 X 25)           | 41      |
| -   | 1   | -   | 1   | 1   | 2119645-1   | DISC, NUMBERED FA WIRE ADJUSTMENT   | 40      |
| -   | 1   | -   | 1   | 1   | 2119957-1   | APPLICATOR SHIM PACK                | 39      |
| -   | 1   | 1   | 1   | 1   | 1-2119644-2 | RAM WASHER, PRECISION               | 38      |
| -   | 1   | 1   | 1   | 1   | 2119085-1   | FA HEAD, ATLANTIC STYLE             | 37      |
| -   | 1   | -   | 1   | 1   | 2119092-1   | BOLT, ADJUSTMENT                    | 35      |
| -   | 1   | 1   | 1   | 1   | 1752356-1   | 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   | 1320908-1   | SPACER, STRIP GUIDE                 | 30      |
| -   | 1   | 1   | 1   | 1   | 2119959-2   | ASSEMBLY, STRIP GUIDE               | 29      |
| -   | 1   | 1   | 1   | 1   | 455888-3    | SPACER, CRIMPER                     | 28      |
| -   | 1   | 1   | 1   | 1   | 1320928-4   | 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   | 454276-5    | FLOATING SHEAR, FRONT               | 9       |
| -   | 1   | 1   | 1   | 1   | 1-1803056-8 | ANVIL, COMBINATION                  | 8       |
| -   | -   | -   | -   | -   | -           | -                                   | 7       |
| -   | -   | -   | -   | -   | -           | -                                   | 6       |
| -   | 1   | 1   | 1   | 1   | 2119757-8   | DEPRESSOR, SHEAR                    | 5       |
| -   | 1   | 1   | 1   | 1   | 238011-4    | BLOCK, CRIMPER SPACER               | 4       |
| -   | 1   | 1   | 1   | 1   | 2-1633963-6 | CRIMPER, INSULATION OVERLAP PREMIUM | 3       |
| -   | 1   | 1   | 1   | 1   | 455888-5    | SPACER, CRIMPER                     | 2       |
| -   | 1   | 1   | 1   | 1   | 5-1633305-9 | CRIMPER, WIRE PREMIUM               | 1       |
| -77 | -7  | -6  | -5  | -2  | PART NO     | DESCRIPTION                         | ITEM NO |

|  |         |  |         |  |         |  |         |  |         |  |               |
|--|---------|--|---------|--|---------|--|---------|--|---------|--|---------------|
| DIMENSIONS:                            |         | TOLERANCES UNLESS OTHERWISE SPECIFIED: |         | OWN: BOB HIGMAN 13AUG2014              |         | CHK: G. BAILEY 13AUG2014               |         | APVD: G. BAILEY 13AUG2014              |         | NAME: Ocean Side Feed Applicator       |               |
| mm                                     | 0 PLC ± | 1 PLC ±                                | 2 PLC ± | 3 PLC ±                                | 4 PLC ± | 5 PLC ±                                | 6 PLC ± | 7 PLC ±                                | 8 PLC ± | 9 PLC ±                                | RESTRICTED TO |
| MATERIAL:                              |         | FINISH:                                |         | WEIGHT:                                |         | SCALE: 1:2                             |         | SHEET 1 OF 4                           |         | REV B                                  |               |
| Customer Accessible Production Drawing |         | Customer Accessible Production Drawing |         | Customer Accessible Production Drawing |         | Customer Accessible Production Drawing |         | Customer Accessible Production Drawing |         | Customer Accessible Production Drawing |               |

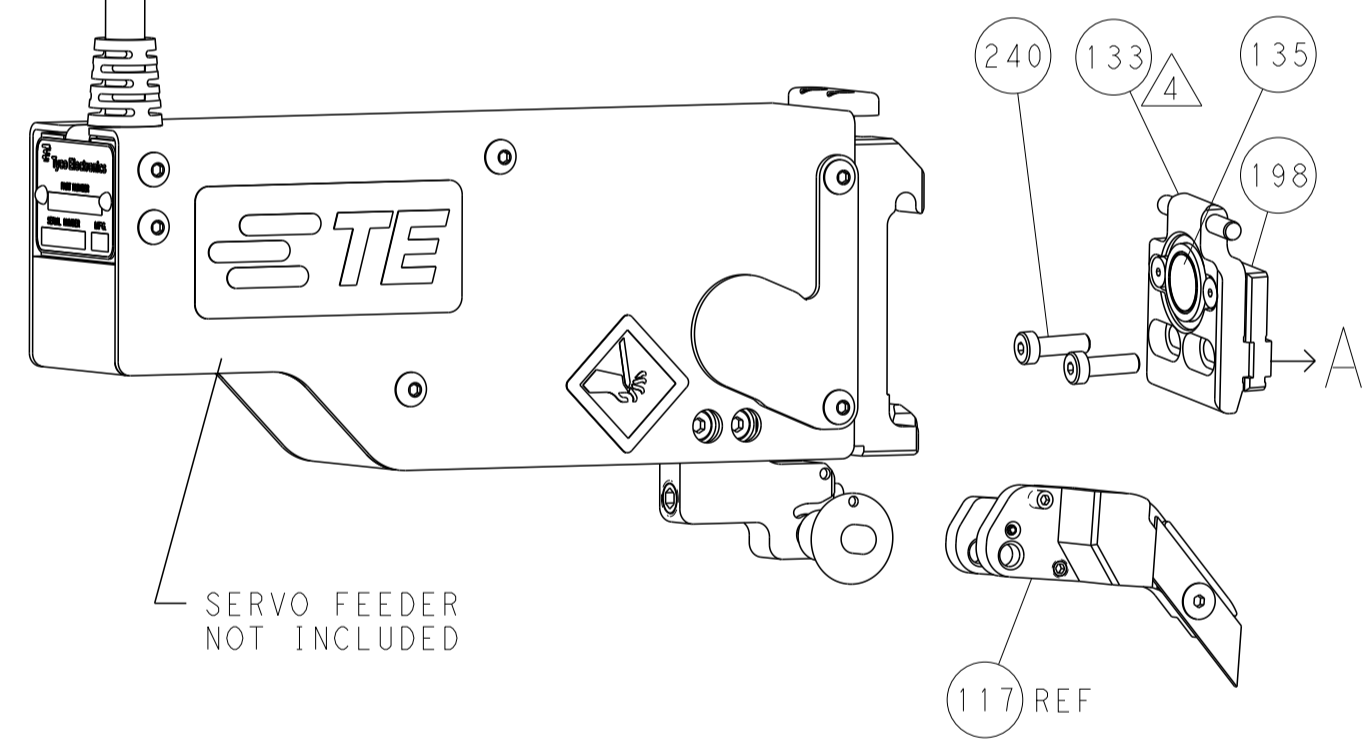
| LOC | DIST | REVISIONS |     |             |      |     |      |
|-----|------|-----------|-----|-------------|------|-----|------|
| A   | 66   | P         | LTN | DESCRIPTION | DATE | DWN | APVD |
|     |      | -         |     | SEE SHEET 1 |      |     |      |

### FEED TYPE

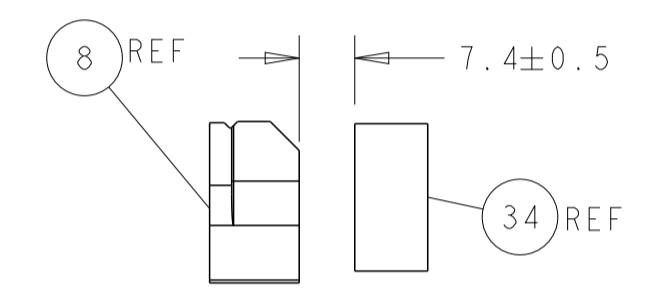
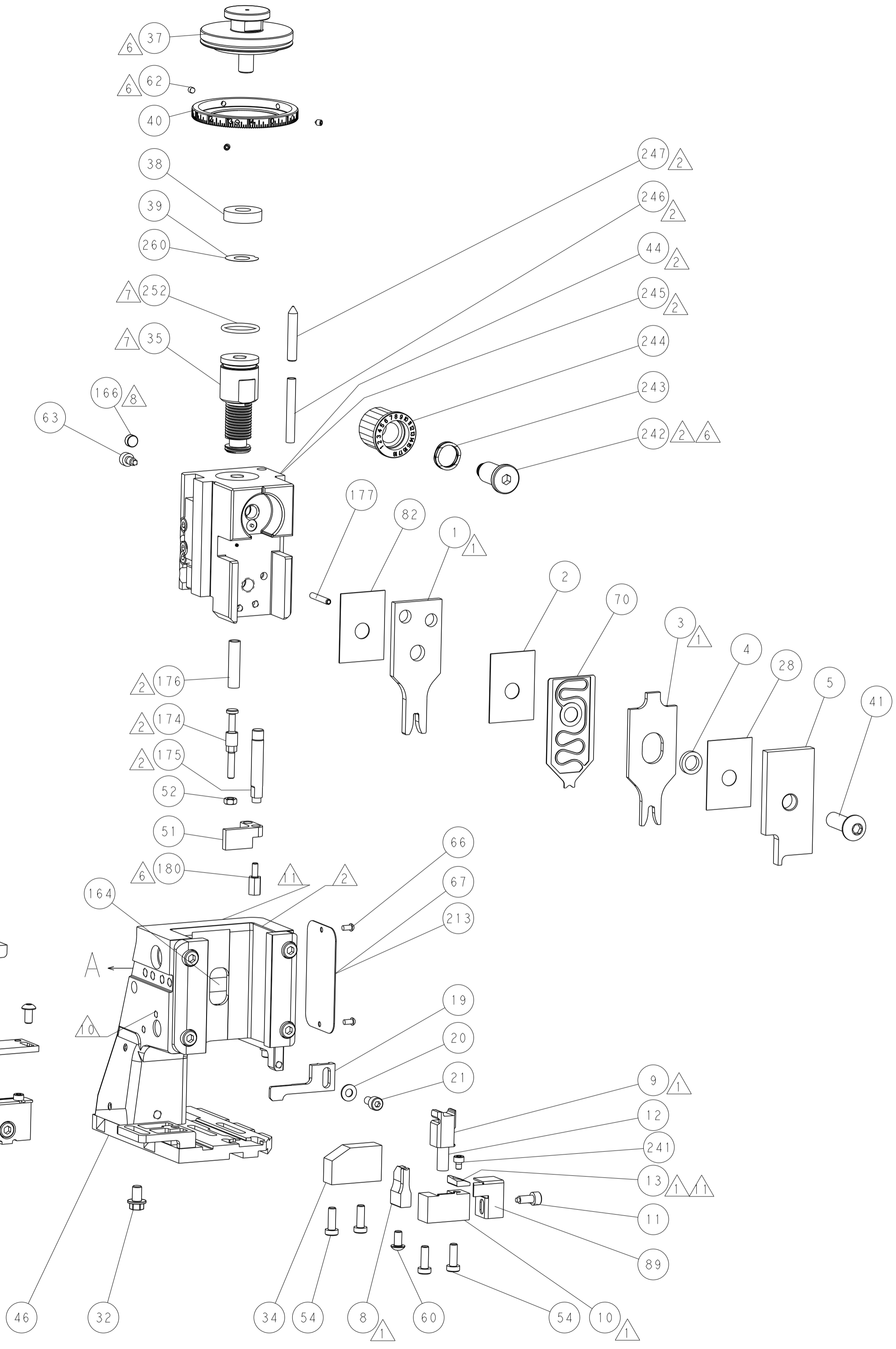
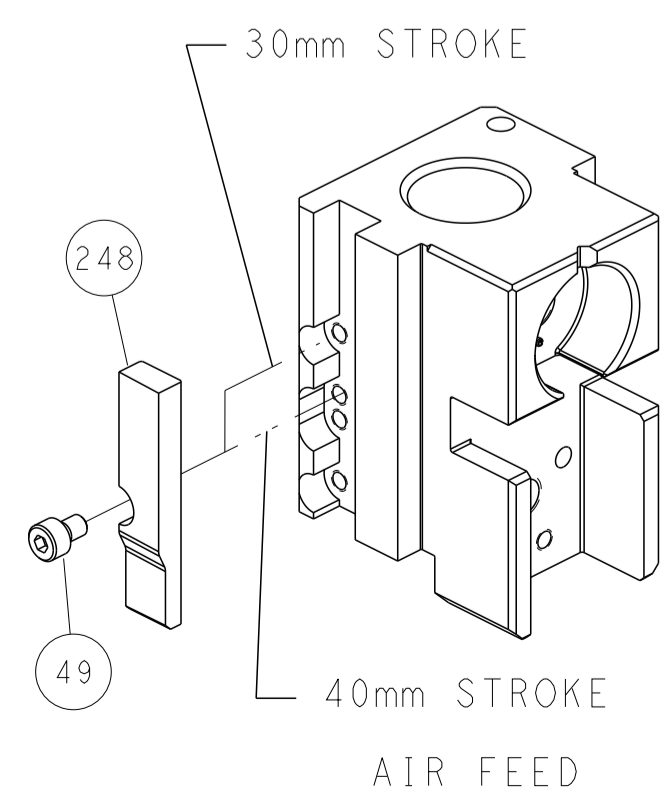
### PNEUMATIC



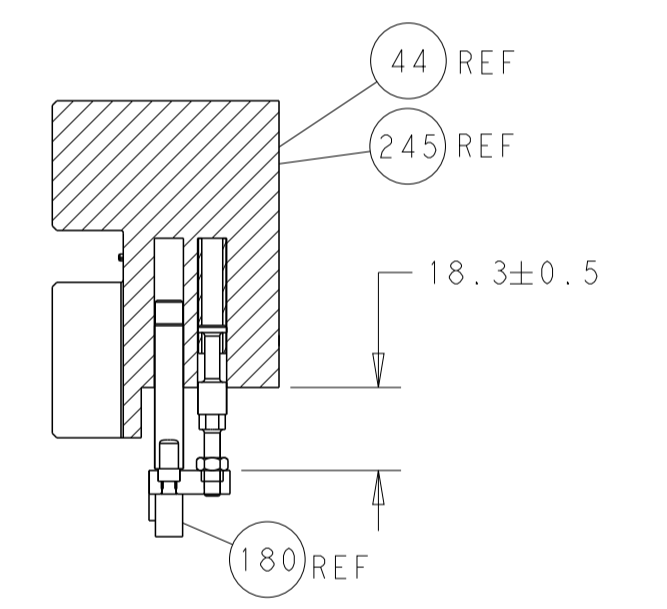
### SERVO LATCH PLATE



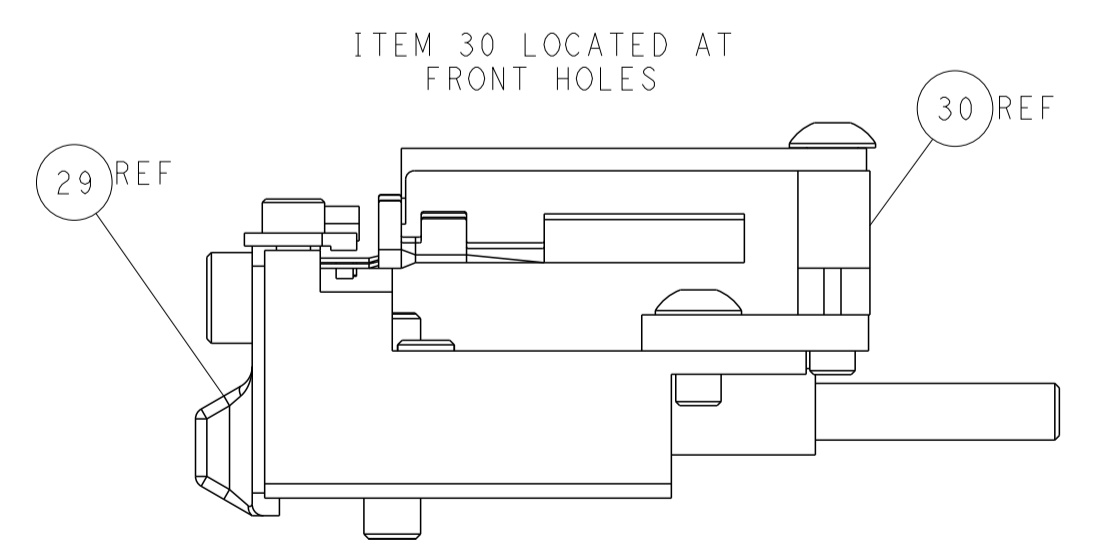
### CAM POSITION



TERMINAL SUPPORT LOCATION



HOLDDOWN SET-UP



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: |         | DWG: BOB HIGMAN 13AUG2014              |         | TE Connectivity                  |  |
| mm          | 0 PLC ± | 1 PLC ±                                | 2 PLC ± | 3 PLC ±                                | 4 PLC ± | Harrisburg, PA 17105-3608        |  |
| MATERIAL:   |         | FINISH:                                |         | CHK: G. BAILEY 13AUG2014               |         | NAME: Ocean Side Feed Applicator |  |
|             |         |  |         | APVD: G. BAILEY 13AUG2014              |         | SIZE: A1                         |  |
|             |         |  |         | PRODUCT SPEC:                          |         | CAGE CODE: 00779                 |  |
|             |         |  |         | APPLICATION SPEC:                      |         | DRAWING NO: 2151403              |  |
|             |         |  |         | WEIGHT:                                |         | SCALE: 1:2                       |  |
|             |         |  |         | Customer Accessible Production Drawing |         | SHEET 2 OF 4 REV B               |  |

| PACIFIC VERSION TERMINATOR INTERFACE ADAPTER | PART NUMBER | REVISION | DESCRIPTION              | FEED TYPE                      |
|--|-------------|----------|--------------------------|--------------------------------|
|  | 2-2151403-2 | B        | FINE CRIMP HEIGHT ADJUST | PNEUMATIC                      |
|  | 2-2151403-5 | B        | FINE CRIMP HEIGHT ADJUST | SERVO LATCH PLATE <sup>4</sup> |
|  | 2-2151403-7 | B        | FINE CRIMP HEIGHT ADJUST | NONE                           |
|  | 7-2151403-7 | B        | CRIMP TOOLING KIT        | -                              |

| APPLICATOR DATA                      |                |      |
|--------------------------------------|----------------|------|
| CRIMP                                | SIZE           | TYPE |
| WIRE                                 | 3.05 mm [.120] | F    |
| INSUL                                | 3.81 mm [.150] | OV   |
| APPLICATOR INSTRUCTIONS<br>408-10389 |                |      |

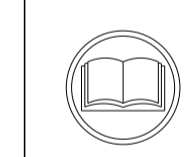
| TERMINAL DATA: YAZAKI TERMINAL YAZAKI CRIMP SPECIFICATION |                                |                              |                 |
|---|--------------------------------|------------------------------|-----------------|
| TERMINAL NAME: 6.3mm YESC UNSEALED MALE TERMINAL          |                                |                              |                 |
| WIRE STRIP LENGTH   |                                | INSULATION DIAMETER RANGE    |                 |
| 5.00-5.50 mm [.197-.217 IN]                               |                                | Ø2.20-3.40 mm [.087-.134 IN] |                 |
| TERMINAL APPLICATION SPECIFICATION                        | YPES-72-WT10-1433-1 Rev WA1916 | -                            | -               |
| TERMINALS APPLIED <sup>10</sup>                           |                                |                              |                 |
| TE TERMINAL   | YAZAKI TERMINAL                | TE TERMINAL                  | YAZAKI TERMINAL |
| 1949106-1   | 7114-4121-02                   | -                            | -               |

| WIRE SIZE   | CRIMP HEIGHT mm [INCH]     | CRIMP HEIGHT REFERENCE SETTING <sup>9</sup> |
|-------------|----------------------------|---|
| 2.50mm2     | 1.85+/-0.05 [.073+/- .002] | 7.5   |
| 2.00mm2     | 1.75+/-0.05 [.069+/- .002] | 7.5   |
| 2 x 0.85mm2 | 1.65+/-0.05 [.065+/- .002] | 9.5   |
| 1.50mm2     | 1.65+/-0.05 [.065+/- .002] | 9.1   |

| TERMINAL DATA: YAZAKI TERMINAL YAZAKI CRIMP SPECIFICATION |                                |                              |                 |
|---|--------------------------------|------------------------------|-----------------|
| TERMINAL NAME: 6.3mm YESC UNSEALED FEMALE TERMINAL        |                                |                              |                 |
| WIRE STRIP LENGTH   |                                | INSULATION DIAMETER RANGE    |                 |
| 5.00-5.50 mm [.197-.217 IN]                               |                                | Ø2.20-3.40 mm [.087-.134 IN] |                 |
| TERMINAL APPLICATION SPECIFICATION                        | YPES-72-WT10-1433-1 Rev WA1916 | -                            | -               |
| TERMINALS APPLIED <sup>10</sup>                           |                                |                              |                 |
| TE TERMINAL   | YAZAKI TERMINAL                | TE TERMINAL                  | YAZAKI TERMINAL |
| 1949107-1   | 7116-4121-02                   | -                            | -               |

| WIRE SIZE   | CRIMP HEIGHT mm [INCH]     | CRIMP HEIGHT REFERENCE SETTING <sup>9</sup> |
|-------------|----------------------------|---|
| 2.50mm2     | 1.85+/-0.05 [.073+/- .002] | 7.5   |
| 2.00mm2     | 1.75+/-0.05 [.069+/- .002] | 7.5   |
| 2 x 0.85mm2 | 1.65+/-0.05 [.065+/- .002] | 8.4   |
| 1.50mm2     | 1.65+/-0.05 [.065+/- .002] | 9.1   |

**\*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.



- <sup>1</sup> RECOMMENDED SPARE PARTS
- <sup>2</sup> GREASE BEARING SURFACES LIGHTLY
- 3. LUBRICATE DAILY PER THE APPLICATOR INSTRUCTION SHEET SUPPLIED WITH THE APPLICATOR.
- <sup>4</sup> APPLICATOR SPECIFIC DATA TO BE ENTERED INTO BLANK MEMORY CHIP AT ASSEMBLY. SEE BELOW FOR PART NUMBER:  
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151403-4  
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151403-5
- 5. ADJUSTMENT OF THE STRIPPER MAY BE REQUIRED WHEN MOVING THE APPLICATOR BETWEEN BENCH AND LEADMAKER APPLICATIONS.
- <sup>6</sup> APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 62 & 180.  
APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242.
- <sup>7</sup> GREASE THREADS, GROOVE AND O-RING ON ITEMS 139 & 152.
- <sup>8</sup> MAGNET MUST BE ORIENTED CORRECTLY IN ORDER TO PROPERLY ACTUATE THE COUNTER.
- <sup>9</sup> 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.
- <sup>10</sup> TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- <sup>11</sup> 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.

| -77 | -27 | -25 | -22 | PART NO   | DESCRIPTION                         | ITEM NO |
|-----|-----|-----|-----|-----------|-------------------------------------|---------|
| -   | 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     |

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

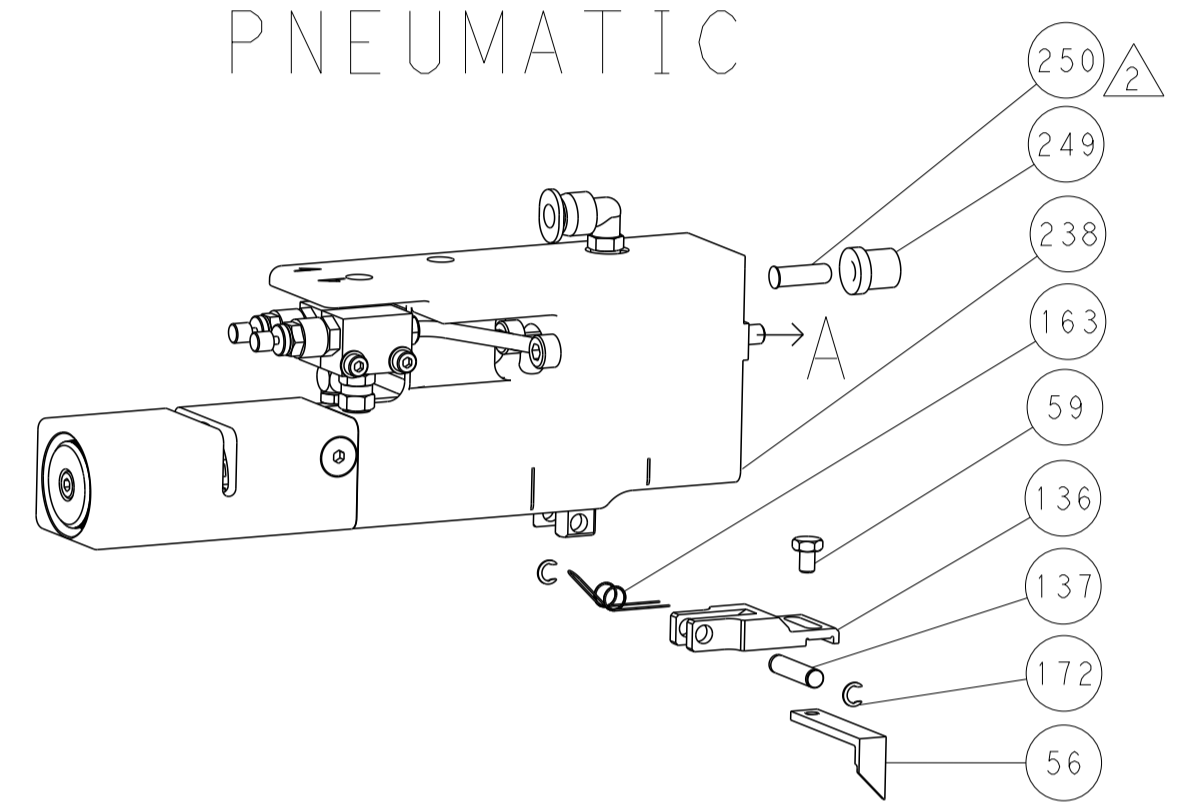
| SET UP GAUGE | LOC | DIST | REVISIONS |     |             |      |     |      |
|--------------|-----|------|-----------|-----|-------------|------|-----|------|
| 2119599-1    | A   | 66   | P         | LTN | DESCRIPTION | DATE | OWN | APVD |
| -            | -   | -    | -         | -   | SEE SHEET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

|               |   |     |     |             |                                     |     |
|---------------|---|-----|-----|-------------|-------------------------------------|-----|
| -             | 1 | 1   | 1   | 1-22279-3   | SPRING, COMPRESSION                 | 246 |
| -             | 1 | 1   | 1   | 2119082-4   | CAM, SNAIL, INSULATION ADJUSTMENT   | 244 |
| -             | 1 | 1   | 1   | 2079764-1   | WASHER, WAVE SPRING, CREST-TO-CREST | 243 |
| <sup>6</sup>  | - | 1   | 1   | 2119083-1   | RETAINER, INSULATION DIAL           | 242 |
| -             | 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   | 2063440-1   | AIR FEED MODULE                     | 238 |
| -             | - | 1   | -   | 2119740-2   | TAG, IDENTIFICATION                 | 213 |
| -             | - | 1   | -   | 1901094-3   | SPACER, FEEDER                      | 198 |
| <sup>6</sup>  | - | 1   | 1   | 2-1752354-2 | STANDOFF, HOLD-DOWN                 | 180 |
| -             | 1 | 1   | 1   | 993111-1    | PIN, SLOTTED SPRING 3.0 X 20.0      | 177 |
| -             | 1 | 1   | 1   | 8-22280-7   | SPRING, COMPRESSION                 | 176 |
| -             | 1 | 1   | 1   | 1752353-2   | GUIDE PIN, HOLDDOWN                 | 175 |
| -             | 1 | 1   | 1   | 1901680-2   | GUIDE PIN, HOLDDOWN                 | 174 |
| -             | - | -   | 2   | 21045-3     | RING, RETAIN, EXTERN, 3/16 CRESCENT | 172 |
| -             | 1 | 1   | 1   | 994969-1    | MAGNET, RARE EARTH HIGH ENERGY      | 166 |
| -             | - | REF | REF | 994970-2    | COUNTER, MAGNETIC                   | 164 |
| -             | - | -   | 1   | 240638-1    | SPRING, FEED FINGER                 | 163 |
| <sup>7</sup>  | - | 1   | 1   | 8-21084-1   | O-RING, .801 ID, .070 DIA. MAT.     | 152 |
| -             | - | -   | 1   | 2119641-2   | FEED CAM, AIR FEED                  | 151 |
| -             | 1 | 1   | 1   | 2119798-2   | DETENT PIN                          | 145 |
| -             | 1 | 1   | 1   | 2079383-8   | SCR, BHSC, RoHS (M4 X 16)           | 144 |
| -             | 4 | 4   | 4   | 2168400-5   | SHCS, LOW HEAD, RoHS, M4 X 20       | 143 |
| -             | 1 | 1   | 1   | 1-2119656-0 | APPLICATOR BASIC ASSEMBLY, SF       | 141 |
| -             | 1 | 1   | 1   | 2119650-1   | RAM, ASIAN STYLE, SIDE FEED         | 140 |
| <sup>7</sup>  | - | 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 |
| -             | - | REF | -   | 2119944-1   | FEED FINGER ASSEMBLY, SF            | 117 |
| -             | 1 | 1   | 1   | 318563-1    | GUARD, FRONT CHIP                   | 89  |
| -             | 1 | 1   | 1   | 455888-5    | SPACER, CRIMPER                     | 82  |
| -             | 2 | 2   | 2   | 2079383-4   | SCR, BHSC, RoHS (M4 X 8)            | 79  |
| -             | 1 | 1   | 1   | 1803096-1   | EXTENSION PLATE                     | 78  |
| -             | 1 | 1   | 1   | 2119956-1   | DOCUMENTATION PACKAGE               | 71  |
| -             | 1 | 1   | 1   | 2119791-5   | DEPRESSOR, WIRE                     | 70  |
| -             | 1 | -   | 1   | 2119740-1   | TAG, IDENTIFICATION                 | 67  |
| -             | 2 | 2   | 2   | 2168078-1   | SCREW, DRIVE, RH, RoHS, 2 x .188    | 66  |
| -             | 1 | 1   | 1   | 2119793-1   | LIMITER, ADJUSTMENT BOLT            | 63  |
| <sup>6</sup>  | - | 3   | 3   | 992763-5    | SCR, SET, SOC, CONE POINT, M3 X 4.0 | 62  |
| -             | - | -   | 1   | 5-18022-5   | SCR, HEX HD CAP, M4 X 6.0           | 59  |
| -             | - | -   | 1   | 1338683-8   | FEED PAWL                           | 56  |
| -             | 1 | 1   | 1   | 1-5018030-0 | NUT, HEX, REG, RoHS, M3.5           | 52  |
| -             | 1 | 1   | 1   | 1901681-9   | HOLDDOWN, TERMINAL                  | 51  |
| -             | - | -   | 1   | 18023-9     | SCR, SKT HD CAP M4 X 6.0            | 49  |
| -             | 1 | 1   | 1   | 2079383-7   | SCR, BHSC, RoHS (M8 X 25)           | 41  |
| -             | 1 | 1   | 1   | 2119645-1   | DISC, NUMBERED FA WIRE ADJUSTMENT   | 40  |
| -             | 1 | 1   | 1   | 2119957-1   | APPLICATOR SHIM PACK                | 39  |
| -             | 1 | 1   | 1   | 1-2119644-2 | RAM WASHER, PRECISION               | 38  |
| -             | 1 | 1   | 1   | 1752356-1   | 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   | 1320908-1   | SPACER, STRIP GUIDE                 | 30  |
| -             | 1 | 1   | 1   | 2119959-2   | ASSEMBLY, STRIP GUIDE               | 29  |
| -             | 1 | 1   | 1   | 455888-3    | SPACER, CRIMPER                     | 28  |
| -             | 1 | 1   | 1   | 1320928-4   | STRIP GUIDE                         | 24  |
| -             | 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  |
| <sup>11</sup> | - | 1   | 1   | 2119806-1   | INSERT, SHEAR                       | 13  |
| -             | 1 | 1   | 1   | 3-22280-3   | SPRING, COMPRESSION                 | 12  |
| -             | 1 | 1   | 1   | 1-356885-4  | STOP, SHEAR                         | 11  |
| <sup>1</sup>  | - | 1   | 1   | 2119805-1   | SHEAR HOLDER, FRONT                 | 10  |
| <sup>1</sup>  | - | 1   | 1   | 454276-5    | FLOATING SHEAR, FRONT               | 9   |
| <sup>1</sup>  | 1 | 1   | 1   | 1-1803056-8 | ANVIL, COMBINATION                  | 8   |
| -             | - | -   | -   | -           | -                                   | 7   |
| -             | - | -   | -   | -           | -                                   | 6   |
| -             | 1 | 1   | 1   | 2119757-8   | DEPRESSOR, SHEAR                    | 5   |
| -             | 1 | 1   | 1   | 238011-4    | BLOCK, CRIMPER SPACER               | 4   |
| <sup>1</sup>  | 1 | 1   | 1   | 2-1633963-6 | CRIMPER, INSULATION OVERLAP PREMIUM | 3   |
| -             | 1 | 1   | 1   | 455888-5    | SPACER, CRIMPER                     | 2   |
| <sup>1</sup>  | 1 | 1   | 1   | 5-1633305-9 | CRIMPER, WIRE PREMIUM               | 1   |

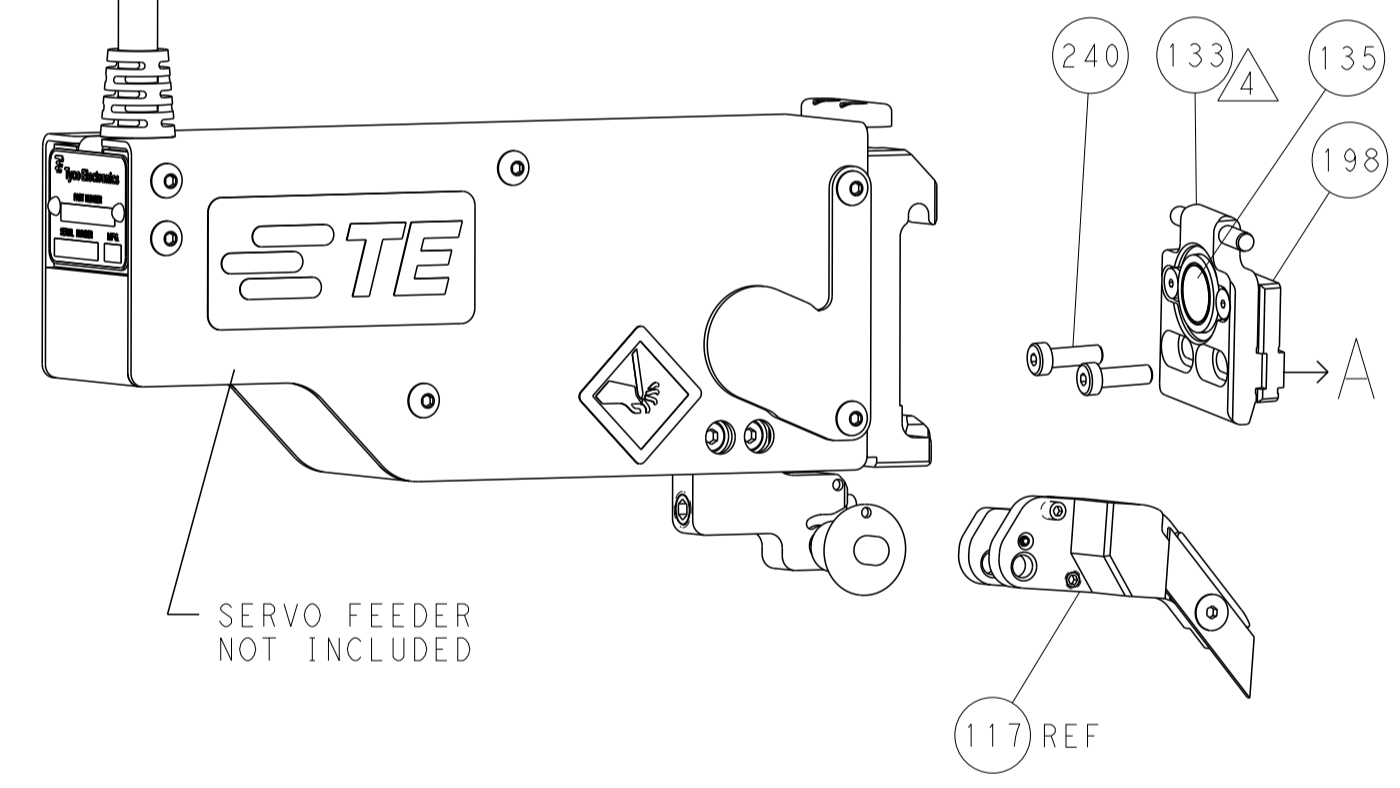
| DIMENSIONS: |         | TOLERANCES UNLESS OTHERWISE SPECIFIED: |         | DWG                  |         | NAME  |               |
|-------------|---------|--|---------|----------------------|---------|---|---------------|
| mm          | 0 PLC ± | 1 PLC ±                                | 2 PLC ± | 3 PLC ±              | 4 PLC ± | 5 PLC ±   | ANGLES FINISH |
|             |         |  |         | BOB HIGMAN 13AUG2014 |         | TE Connectivity<br>Harrisburg, PA 17105-3608                        |               |
|             |         |  |         | G. BAILEY 13AUG2014  |         | Ocean Side Feed<br>Applicator                                       |               |
|             |         |  |         | APVD                 |         | SIZE CAGE CODE DRAWING NO RESTRICTED TO                             |               |
|             |         |  |         | APPLICATION SPEC     |         | A1 00779 ©=2151403  |               |
|             |         |  |         | MATERIAL             |         | Customer Accessible Production Drawing SCALE 1:2 SHEET 3 of 4 REV B |               |

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

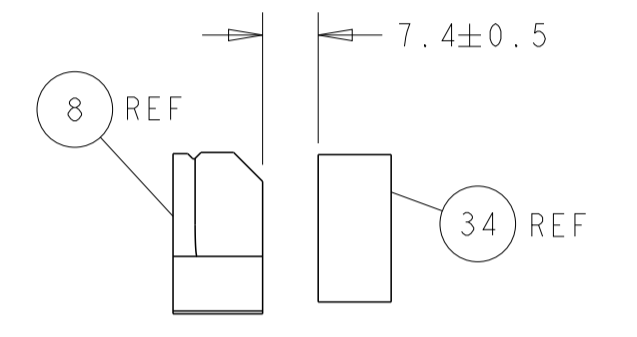
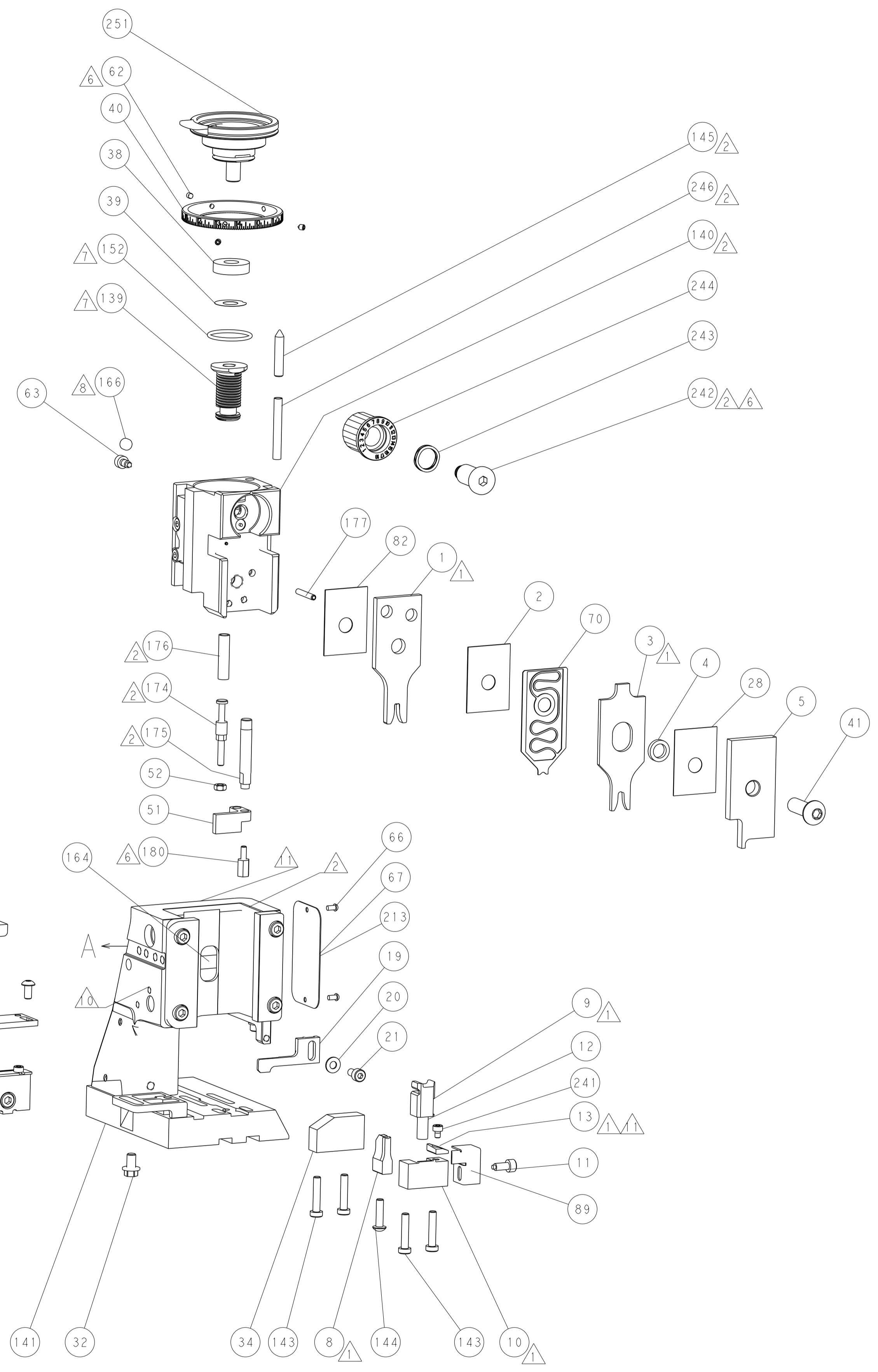
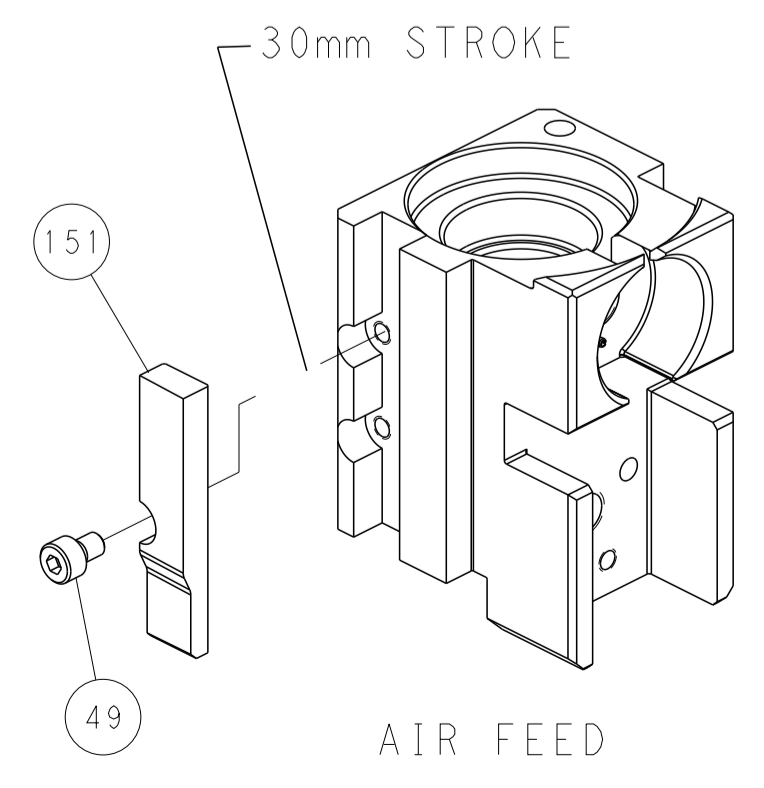
### FEED TYPE PNEUMATIC



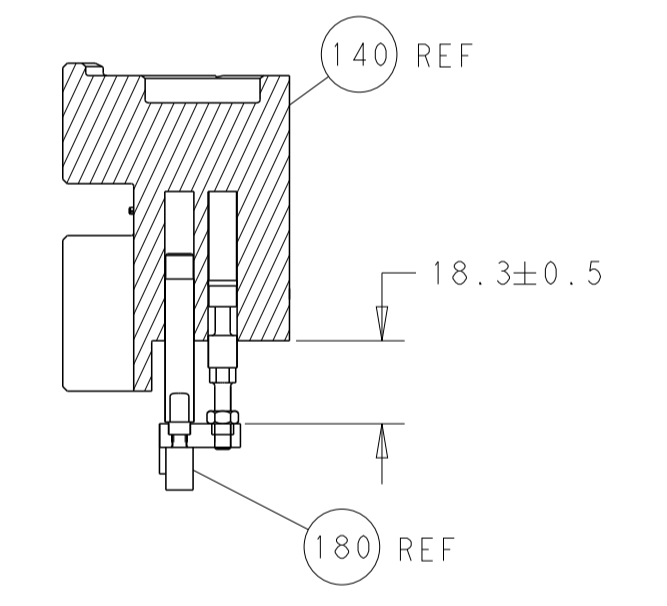
### SERVO LATCH PLATE



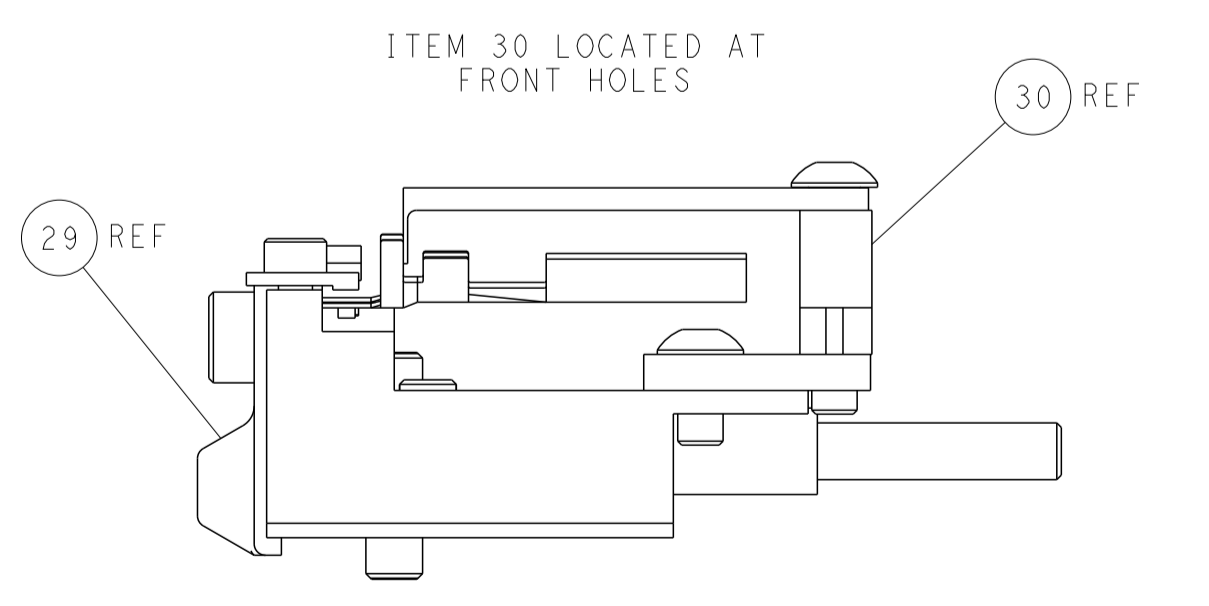
### CAM POSITION



TERMINAL SUPPORT LOCATION



HOLDDOWN 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)

|   |  |  |  |
|---|--|--|--|
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| DIMENSIONS: mm<br>TOLERANCES UNLESS OTHERWISE SPECIFIED:<br>0 PLC ±<br>1 PLC ±<br>2 PLC ±<br>3 PLC ±<br>4 PLC ±<br>ANGLES ±<br>MATERIAL: -<br>FINISH: -   | APPLICATION SPEC: -<br>WEIGHT: -<br>SCALE: 1:2 | SIZE: A1<br>CAGE CODE: 00779<br>DRAWING NO: 2151403<br>SHEET 4 OF 4                | RESTRICTED TO: -<br>REV: B                         |