

8 7 6 5 4 3 2 1

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ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART						
					CONVERT TO	PART NUMBERS REQUIRED					
	2266822-1	A	FINE CRIMP HEIGHT ADJUST	MECHANICAL	PNEUMATIC FEED	2119950-1	1338683-8	5-18022-5	2119641-1	2119799-1	2063440-1
	2266822-2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	SERVO LATCH PLATE	2119951-1	-	8-2266822-5	1901094-3	-	2168400-6 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2266822-4	-	-	
					MECHANICAL FEED	2119949-1	1338683-8	5-18022-5	2119653-1	-	
	2266822-5	A	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE 4	SERVO LATCH PLATE 4	2119951-1	-	8-2266822-5	1901094-3	-	2168400-6 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2266822-4	-	-	
					MECHANICAL FEED	2119949-1	1338683-8	5-18022-5	2119653-1	-	
	2266822-6	A	NON-CRIMP HEIGHT ADJUST	SERVO LATCH PLATE 4	PNEUMATIC FEED	2119950-1	1338683-8	5-18022-5	2119641-1	2119799-1	2063440-1
-					-	-	-	-	-		
2266822-7	A	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	-	
7-2266822-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-	

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.54 mm [ .100 ]	F
INSUL	4.42 mm [ .174 ]	O

APPLICATOR INSTRUCTIONS 408-10389

TERMINAL DATA: YAZAKI TERMINAL	TERMINAL YAZAKI CRIMP SPECIFICATION
TERMINAL NAME: YAZAKI TERMINAL	WIRE STRIP LENGTH: 5.00-5.50 mm [ .197-.217 IN ]
	INSULATION DIAMETER RANGE: ∅ 1.3
	TERMINAL APPLICATION SPECIFICATION: (A) 7114-4140-02 Rev WA1738

TERMINALS APPLIED				
TE TERMINAL	YAZAKI TERMINAL	TE SEAL	YAZAKI SEAL	CABLE DIAMETER
(A) 1572595-1	(A) 7114-4140-02	1572596-1	7158-3081-50	∅ 1.40-2.10 mm

WIRE SIZE	CRIMP HEIGHT mm [ INCH ]	CRIMP HEIGHT REFERENCE SETTING
1.25mm <sup>2</sup>	1.45 +/- 0.05 [ .057 +/- .002 ]	6.4
1.00mm <sup>2</sup>	1.45 +/- 0.05 [ .057 +/- .002 ]	6.4
0.80mm <sup>2</sup>	1.35 +/- 0.05 [ .053 +/- .002 ]	7.4
0.50mm <sup>2</sup>	1.25 +/- 0.05 [ .049 +/- .002 ]	8.5



- 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:  
 MECHANICAL FEED WITH "SMART APPLICATOR" CONVERSION: 8-2266822-4  
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2266822-4  
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2266822-5  
 SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2266822-6
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 ITEM 62. 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 ITEM 37.
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. SPARE FEED CAM STORAGE LOCATION REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.
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 4.35.
13. THIS APPLICATOR APPLIES TERMINAL WITH A SEAL.
14. APPLY TORO-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.

TERMINAL DATA: YAZAKI TERMINAL	TERMINAL YAZAKI CRIMP SPECIFICATION
TERMINAL NAME: YAZAKI TERMINAL	WIRE STRIP LENGTH: 5.00-5.50 mm [ .197-.217 IN ]
	INSULATION DIAMETER RANGE: ∅ 1.3
	TERMINAL APPLICATION SPECIFICATION: (A) 7114-4140-02 Rev WA1738

TERMINALS APPLIED				
TE TERMINAL	YAZAKI TERMINAL	TE SEAL	YAZAKI SEAL	CABLE DIAMETER
(B) 1572594-1	(B) 7116-4140-02	1572596-1	7158-3081-50	∅ 1.40-2.10 mm

WIRE SIZE	CRIMP HEIGHT mm [ INCH ]	CRIMP HEIGHT REFERENCE SETTING
1.25mm <sup>2</sup>	1.55 +/- 0.05 [ .061 +/- .002 ]	6.4
1.00mm <sup>2</sup>	1.55 +/- 0.05 [ .061 +/- .002 ]	6.4
0.80mm <sup>2</sup>	1.40 +/- 0.05 [ .055 +/- .002 ]	7.4
0.50mm <sup>2</sup>	1.30 +/- 0.05 [ .051 +/- .002 ]	8.5



3. CUT TO LENGTH AT ASSEMBLY.
- \*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  | 1  | 1  | 1803078-3 | SPACER, PRECISION               | 259     |
| -   | 1  | -  | 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 | -1 | PART NO   | DESCRIPTION                     | ITEM NO |

REVISED	DATE	BY	APPV
1	DEVELOPMENT	19JUN2015	JH UG
A	RELEASED	21JUL2015	JH CT

-	1	-	1	1	1	2119798-1	DETENT PIN	247
-	1	-	1	1	1	1-22279-3	SPRING, COMPRESSION	246
-	-	1	-	-	-	2161314-1	RAM, STEPPED, ATLANTIC, SF, NON-ADJ	245
-	1	1	1	1	1	2119082-1	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	-	2	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
-	-	1	1	-	-	2119740-2	TAG, IDENTIFICATION	213
-	-	1	1	-	-	1901094-3	SPACER, FEEDER	198
-	-	-	-	2	-	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172
-	1	1	1	1	1	994969-1	MAGNET, RARE EARTH HIGH ENERGY	166
-	REF	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	1	1-690438-0	FRONT STRIP GUIDE	96
-	1	1	1	1	1	455888-5	SPACER, CRIMPER	82
-	2	2	2	2	2	2079383-4	SCR, BHSC, RoHS (M4 X 8)	79
-	1	1	1	1	1	1803096-1	EXTENSION PLATE	78
-	1	1	1	1	1	2119956-1	DOCUMENTATION PACKAGE	71
-	1	-	-	1	1	2119740-1	TAG, IDENTIFICATION	67
-	2	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	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	1	1	1	1	1-2168083-3	SCR, SKT HD CAP, RoHS, M3 X 16	57
-	-	-	-	-	1	1338683-8	FEED PAWL	56
-	4	4	4	4	4	2168400-1	SHCS, LOW HEAD, RoHS, M4 X 12	54
-	2	2	2	2	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	53
-	1	1	1	1	1	5018030-1	NUT, HEX, REG, RoHS, M3	52
-	1	1	1	1	1	811242-5	BUMPER, HOLD DOWN	51
-	1	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	2119653-1	FEED CAM, POST FEED	47
-	1	1	1	1	1	1-2119656-7	APPLICATOR BASIC ASSEMBLY, SF	46
-	1	-	1	1	1	2161311-1	RAM, STEPPED, AMP STYLE, SIDE FEED	44
-	1	1	1	1	1	1-2079383-5	SCR, BHSC, RoHS (M8 X 40)	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	1-2119644-2	RAM WASHER, PRECISION	38
-	1	1	1	1	1	2119085-1	FA HEAD, ATLANTIC STYLE	37
-	1	-	1	1	1	2119092-1	BOLT, ADJUSTMENT	35
-	1	1	1	1	1	1752356-3	SUPPORT, TERMINAL	34
-	2	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	1	1	1	1	1	2161328-1	HEX HEAD, FLANGED, M5 x 8mm LONG	32
-	1	1	1	1	1	1320908-8	SPACER, STRIP GUIDE	30
-	1	1	1	1	1	2119959-6	ASSEMBLY, STRIP GUIDE	29
-	1	1	1	1	1	455888-3	SPACER, CRIMPER	28
-	2	2	2	2	2	22283-1	SPRING, COMPRESSION	27
-	1	1	1	1	1	240792-1	DRAG, TERMINAL	25
-	1	1	1	1	1	1320928-4	STRIP GUIDE	24
-	1	1	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
-	2	2	2	2	2	1-18028-2	WASHER, FLAT, REG M4	20
-	1	1	1	1	1	1803013-1	STRIPPER, SIDE FEED	19
-	1	1	1	1	1	3-22280-3	SPRING, COMPRESSION	12
-	1	1	1	1	1	1-356885-4	STOP, SHEAR	11
-	1	1	1	1	1	2119805-7	SHEAR HOLDER, FRONT	10
-	1	1	1	1	1	318059-9	FLOATING SHEAR, FRONT	9
-	1	1	1	1	1	2-1633922-7	ANVIL, COMBINATION	8
-	-	-	-	-	-	-	-	7
-	-	-	-	-	-	-	-	6
-	1	1	1	1	1	1-1803080-1	DEPRESSOR, SHEAR	5
-	1	1	1	1	1	2-238011-7	BLOCK, CRIMPER SPACER	4
-	1	1	1	1	1	1803248-3	CRIMPER, INSULATION PREMIUM	3
-	1	1	1	1	1	1-455888-6	SPACER, CRIMPER	2
-	1	1	1	1	1	3-456407-8	CRIMPER, WIRE PREMIUM	1
-77	-7	-6	-5	-2	-1	PART NO	DESCRIPTION	ITEM NO

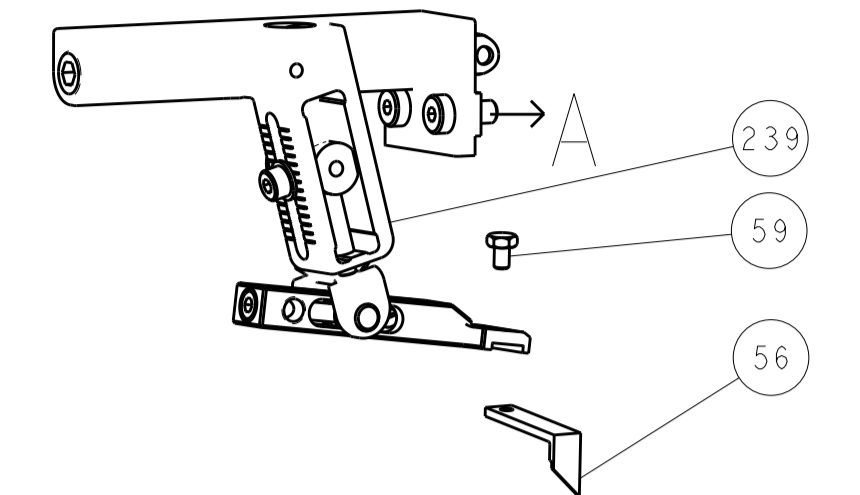
THIS IS AN INSTRUCTION TO CRIMP AND TO HOLD TO THE SPECIFIED CRIMP HEIGHT. THE CRIMP HEIGHT SHOULD BE CONFIRMED FOR THE LATEST REVISION.

DIMENSIONS:	TOLERANCES UNLESS OTHERWISE SPECIFIED:	OWN	19JUN2015
mm	0 PLC ±	CHK	L. HOU
1 PLC ±	1 PLC ±	APPV	L. ZHANG
2 PLC ±	2 PLC ±	DATE	19JUN2015
3 PLC ±	3 PLC ±	NAME	
4 PLC ±	4 PLC ±	PRODUCT SPEC	
ANGLES	FINISH	APPLICATION SPEC	
MATERIAL		SIZE	CAGE CODE DRAWING NO
		RESTRICTED TO	
		WEIGHT	A1 00779 C=2266822
		CUSTOMER ACCESSIBLE PRODUCTION DRAWING	SCALE 1:2 SHEET 1 OF 4 REV A

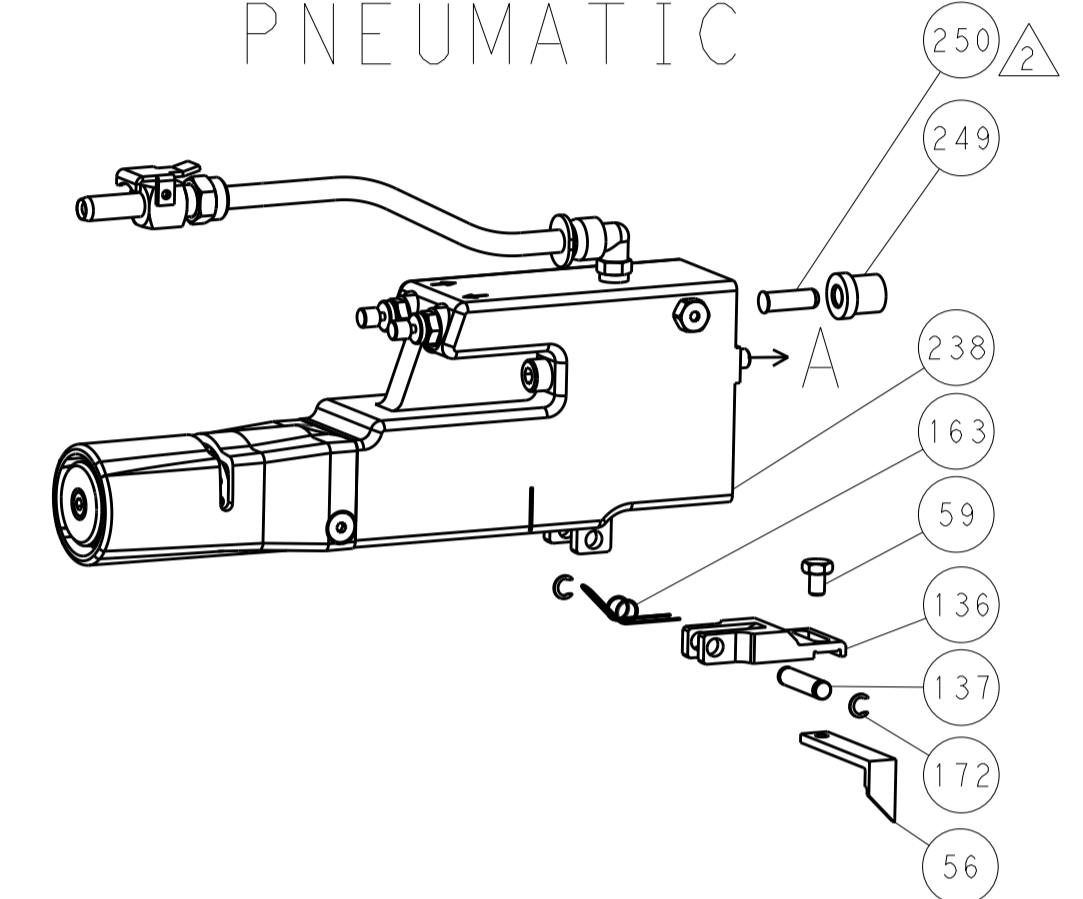
ATLANTIC VERSION  
 Shown on sheets 1 of 4 & 2 of 4  
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

LOC	DIST	REV	DATE	BY	APP'D
A	66				

### FEED TYPE MECHANICAL



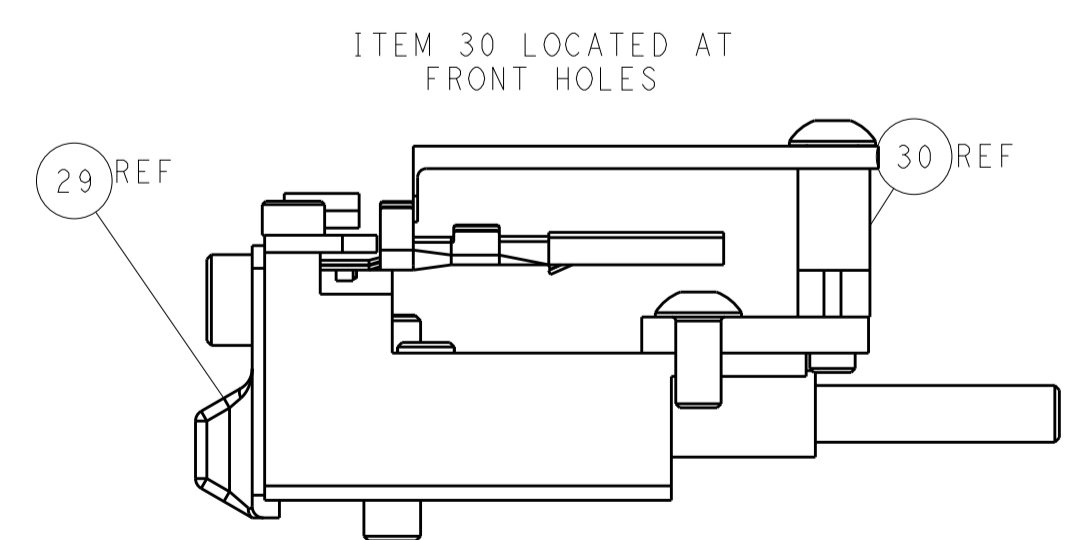
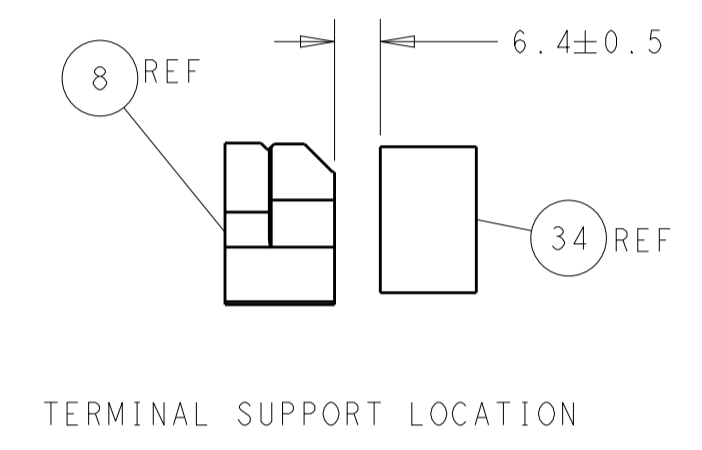
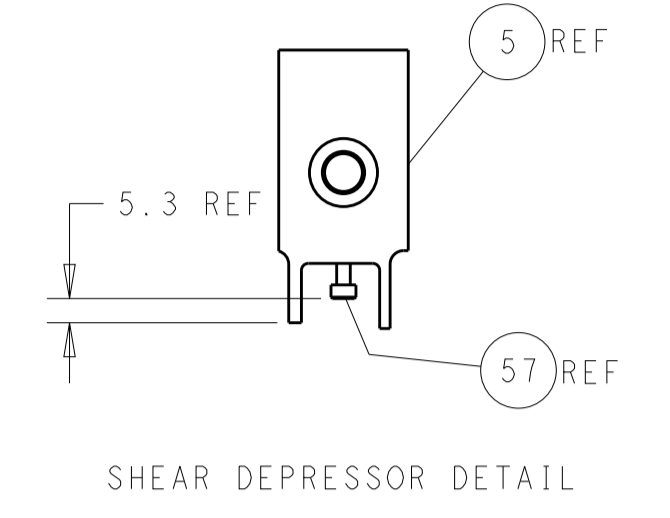
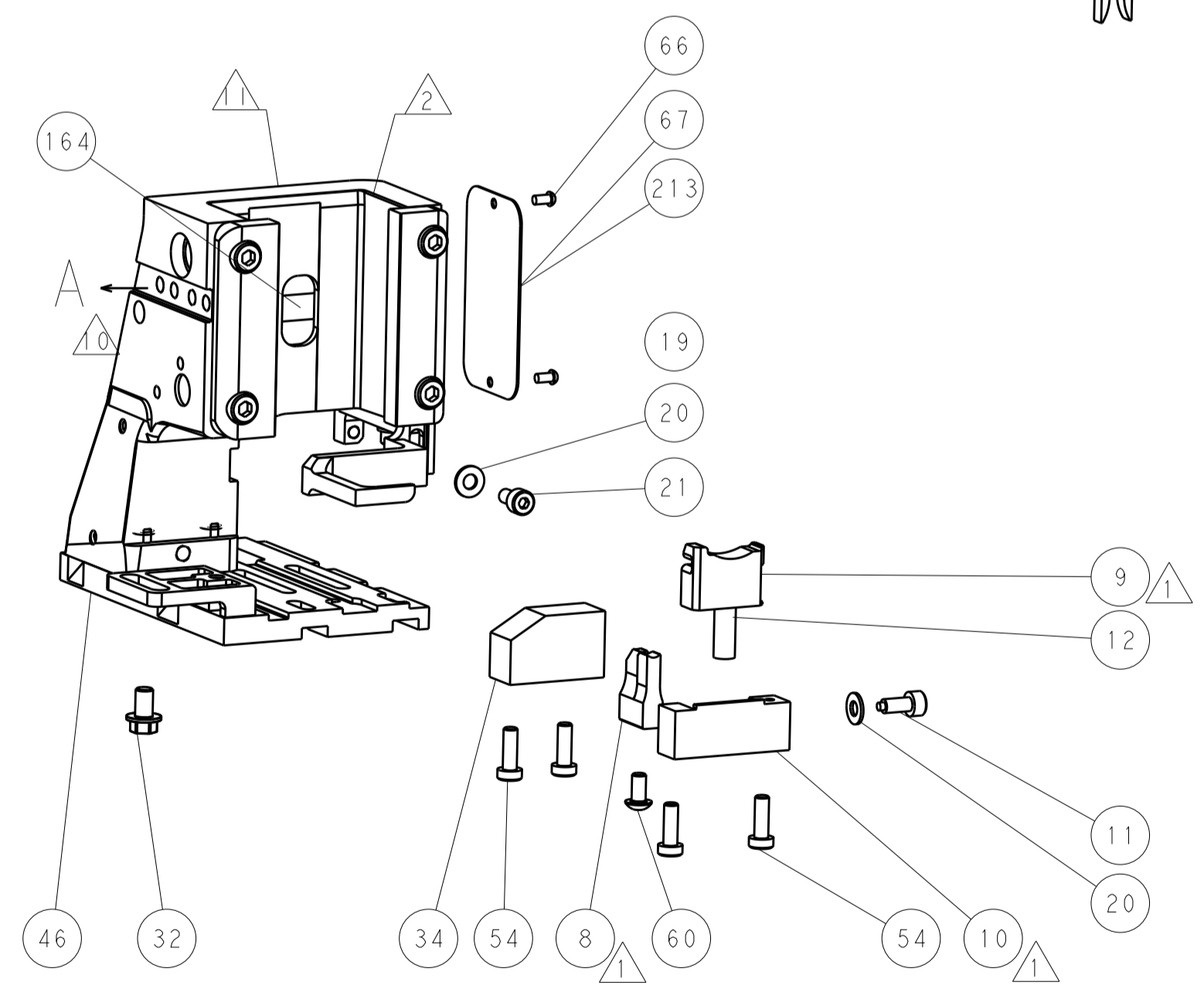
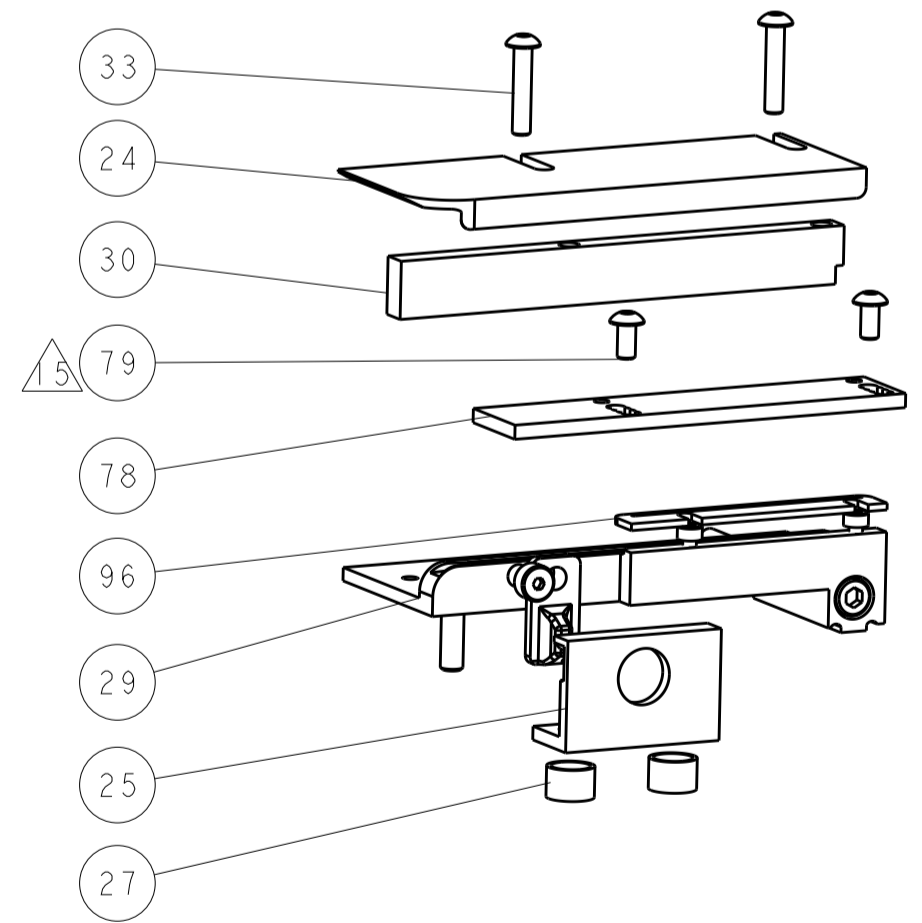
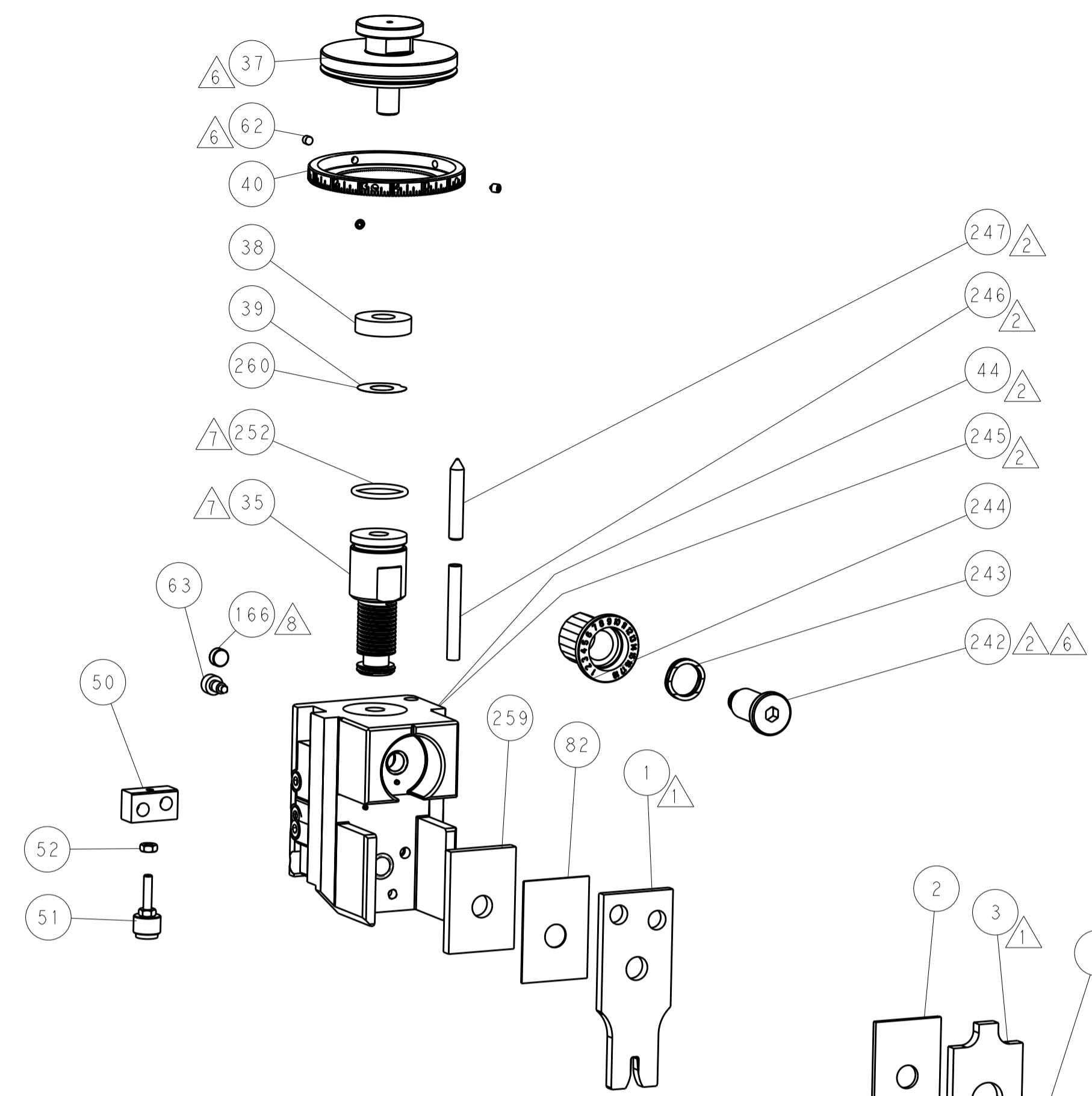
### PNEUMATIC



### SERVO LATCH PLATE



### 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:		DWG: J. HOU 19JUN2015		TE Connectivity	
mm		0 PLC ±		CHK: L. ZHANG 19JUN2015		Harrisburg, PA 17105-3608	
Ø		1 PLC ±		APP'D: H. GUO 19JUN2015		NAME: Ocean Side Feed Applicator	
FINISH:		2 PLC ±		PRODUCT SPEC:		SIZE: CAGE CODE: DRAWING NO:	
MATERIAL:		3 PLC ±		APPLICATION SPEC:		RESTRICTED TO:	
		4 PLC ±		WEIGHT:		A1 00779 ©=2266822	
		ANGLES ±		Customer Accessible Production Drawing		SCALE: 1:2 SHEET 2 OF 4 REV A	

Table with columns: PACIFIC VERSION TERMINATOR INTERFACE ADAPTER, PART NUMBER, REVISION, DESCRIPTION, FEED TYPE, CONVERT TO, PART NUMBERS REQUIRED. Includes a drawing of the terminator interface adapter.

Table: APPLICATOR DATA. Columns: CRIMP, SIZE, TYPE. Includes WIRE (2.54 mm), INSUL (4.42 mm).

Table: TERMINAL DATA: YAZAKI TERMINAL. Columns: WIRE STRIP LENGTH, INSULATION DIAMETER RANGE, TERMINAL APPLICATION SPECIFICATION, TERMINALS APPLIED.

Table: TERMINAL DATA: YAZAKI TERMINAL. Columns: WIRE STRIP LENGTH, INSULATION DIAMETER RANGE, TERMINAL APPLICATION SPECIFICATION, TERMINALS APPLIED.

Table: WIRE SIZE vs CRIMP HEIGHT. Columns: WIRE SIZE, CRIMP HEIGHT mm [INCH], CRIMP HEIGHT REFERENCE SETTING.

Table: WIRE SIZE vs CRIMP HEIGHT. Columns: WIRE SIZE, CRIMP HEIGHT mm [INCH], CRIMP HEIGHT REFERENCE SETTING.

- RECOMMENDED SPARE PARTS
GREASE BEARING SURFACES LIGHTLY
LUBRICATE DAILY PER THE APPLICATOR INSTRUCTION SHEET...
APPLICATOR SPECIFIC DATA TO BE ENTERED INTO BLANK MEMORY CHIP...
ADJUSTMENT OF THE STRIPPER MAY BE REQUIRED...
APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS...
GREASE THREADS, GROOVE AND O-RING ON ITEMS 139 & 152.
MAGNET MUST BE ORIENTED CORRECTLY...
CRIMP HEIGHT REFERENCE SETTING...
SPARE FEED CAM STORAGE LOCATION REFER TO INSTRUCTION SHEET...
TO CONVERT THE APPLICATOR TO A NON-CARRIER CUTTING STYLE...
THIS APPLICATOR APPLIES TERMINAL WITH A SEAL.
APPLY TORO-SEAL IN ALLEN SOCKET TO FILL HOLE AFTER FLAT HD...

\*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 columns: PART NO, DESCRIPTION, ITEM NO. Lists various spare parts like 1803078-3 SPACER, 2119782-1 FINE ADJUST HEAD ASM, etc.

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

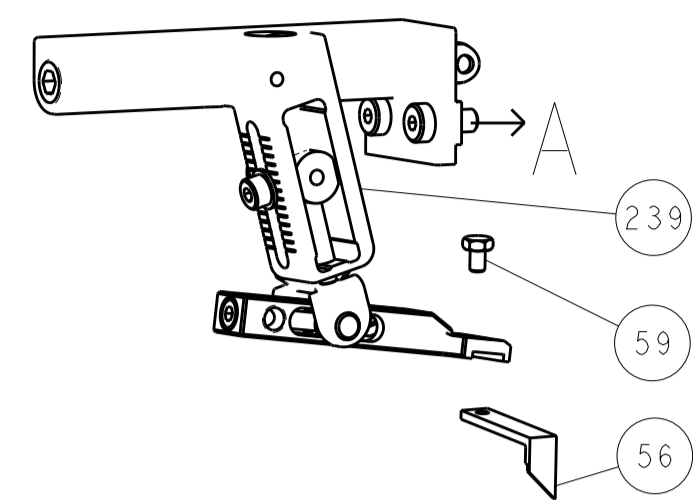
Table: REVISIONS. Columns: P, LTR, DESCRIPTION, DATE, DWN, APVD. Shows revision 66 with description SEE SHEET 1.

Large table with columns: P, LTR, DESCRIPTION, DATE, DWN, APVD. Lists numerous components like SPRING, COMPRESSION; CAM, SNAIL, INSULATION ADJUSTMENT; WASHER, WAVE SPRING, CREST-TO-CREST, etc.

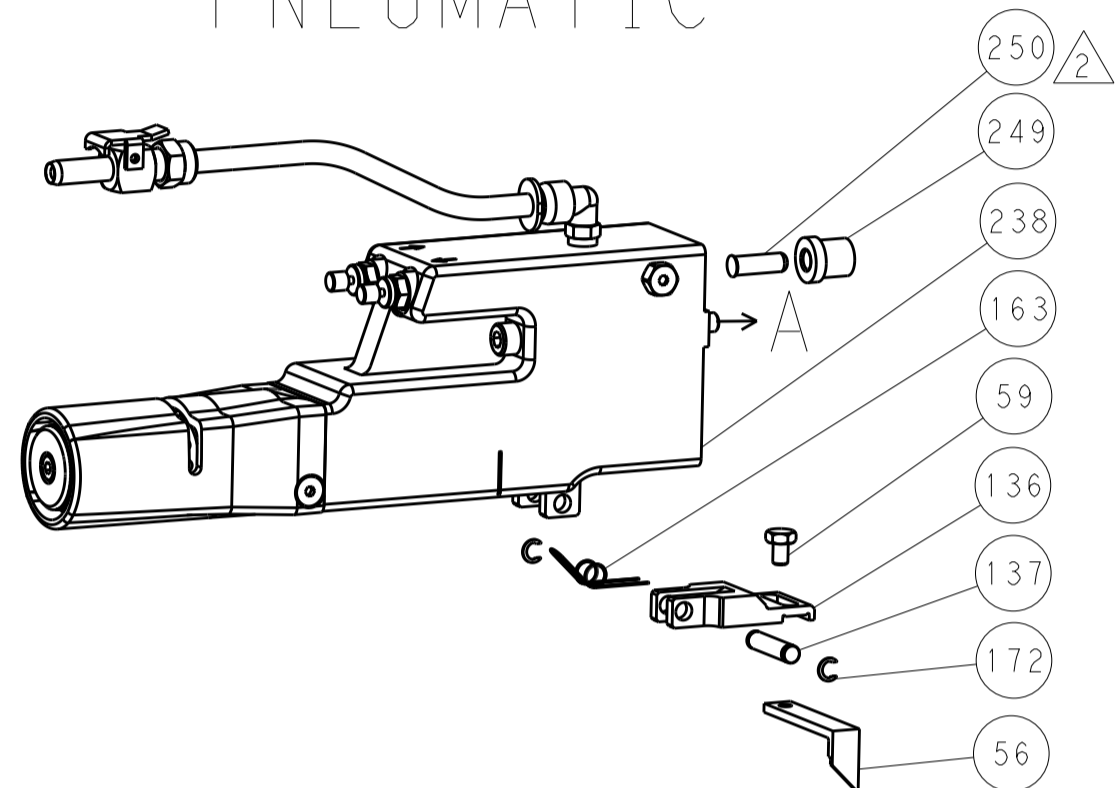
Table: DIMENSIONS, TOLERANCES UNLESS OTHERWISE SPECIFIED, MATERIAL, FINISH, WEIGHT, SCALE, SHEET, REV. Includes a drawing of the applicator tip and technical specifications.

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

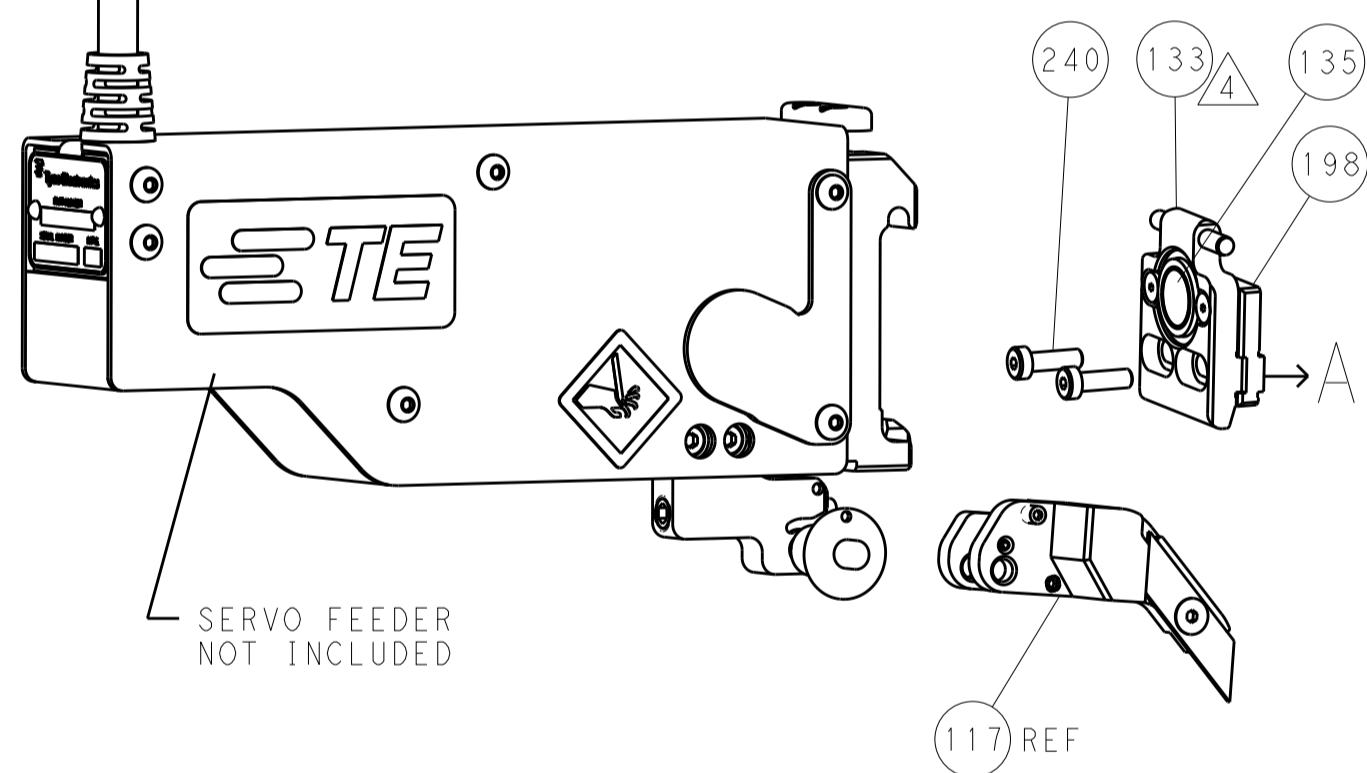
# FEED TYPE MECHANICAL



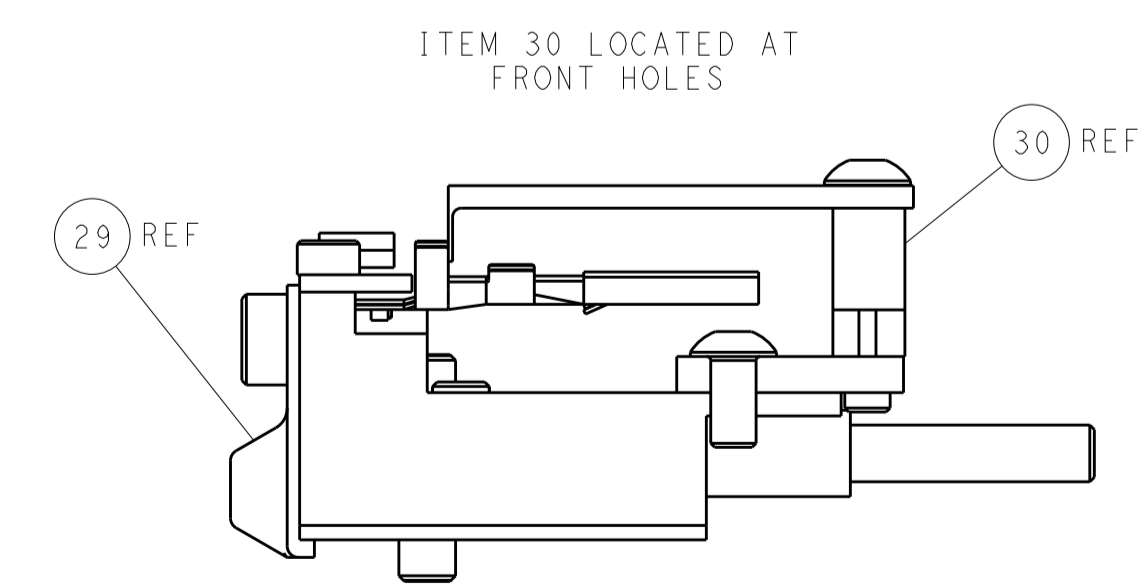
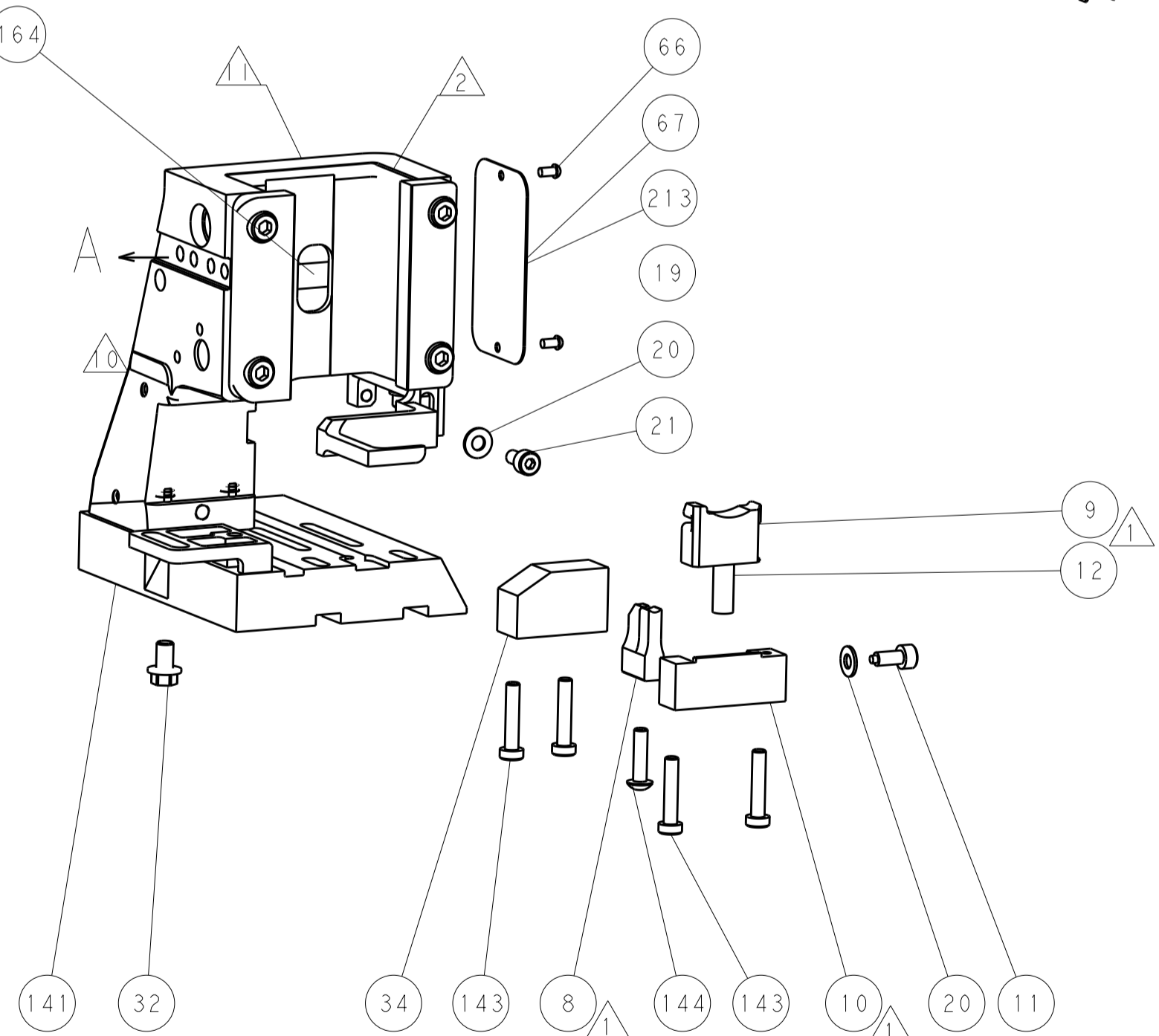
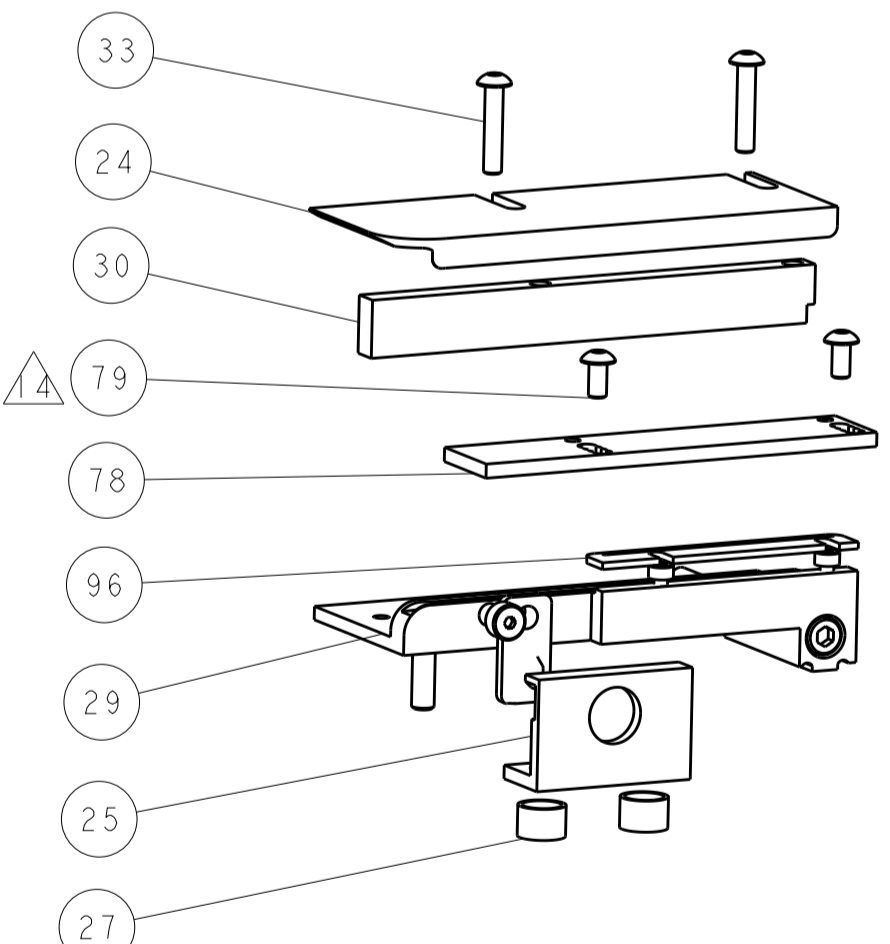
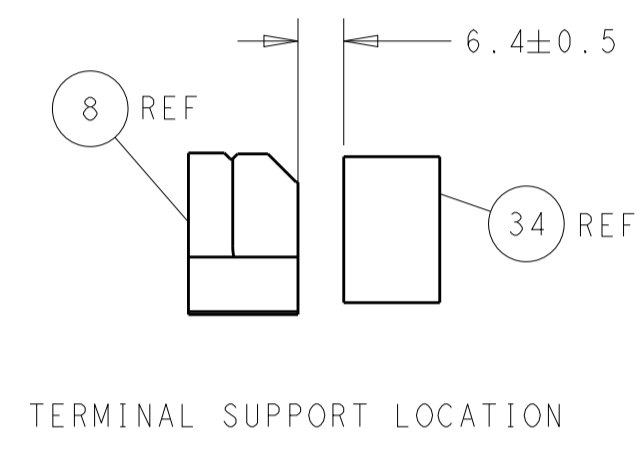
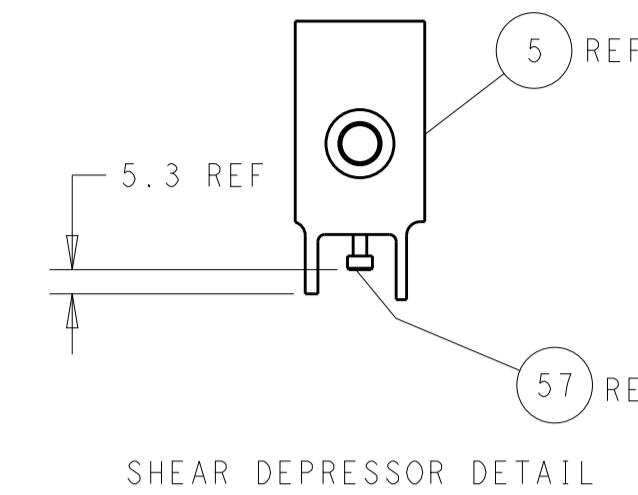
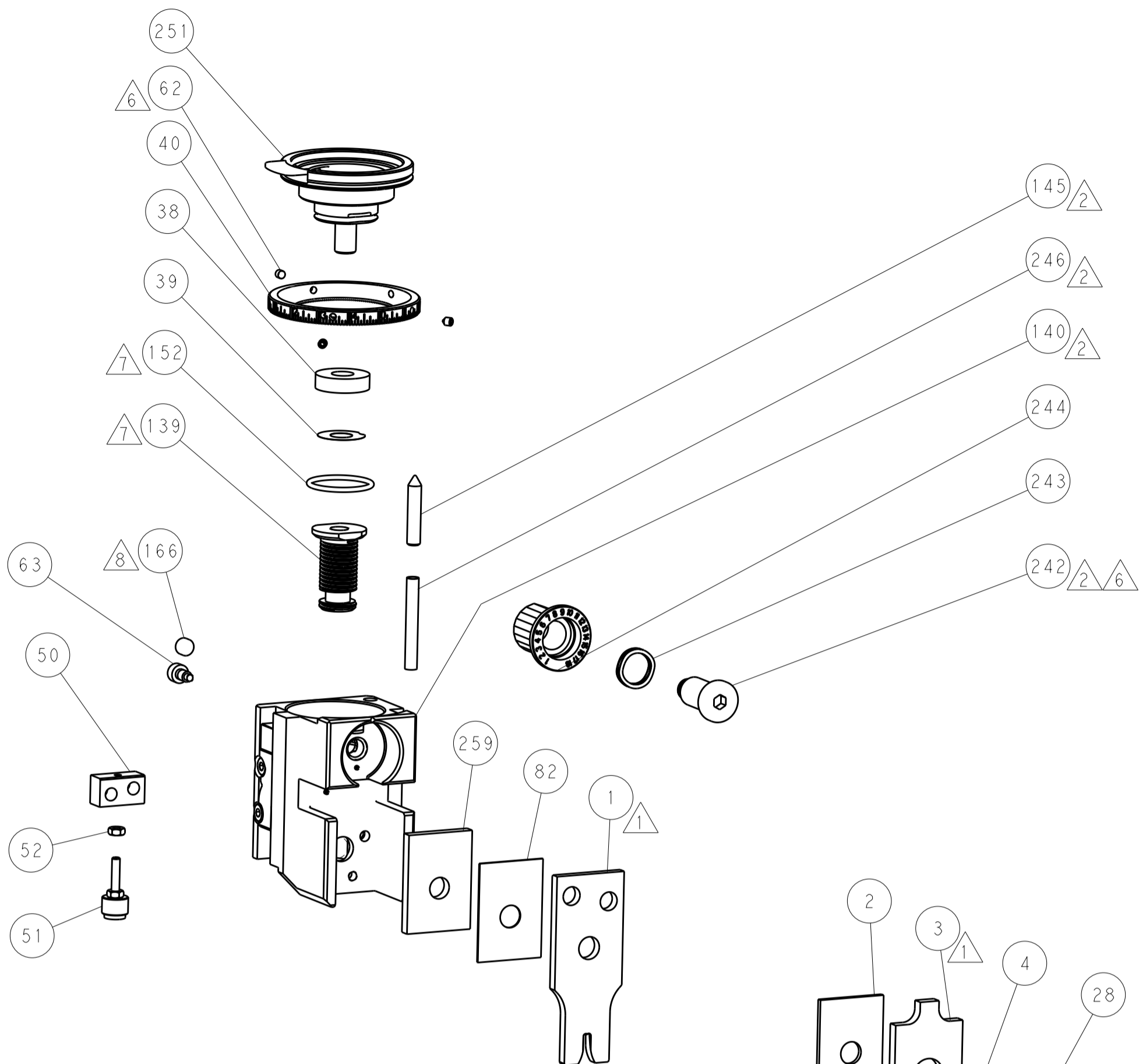
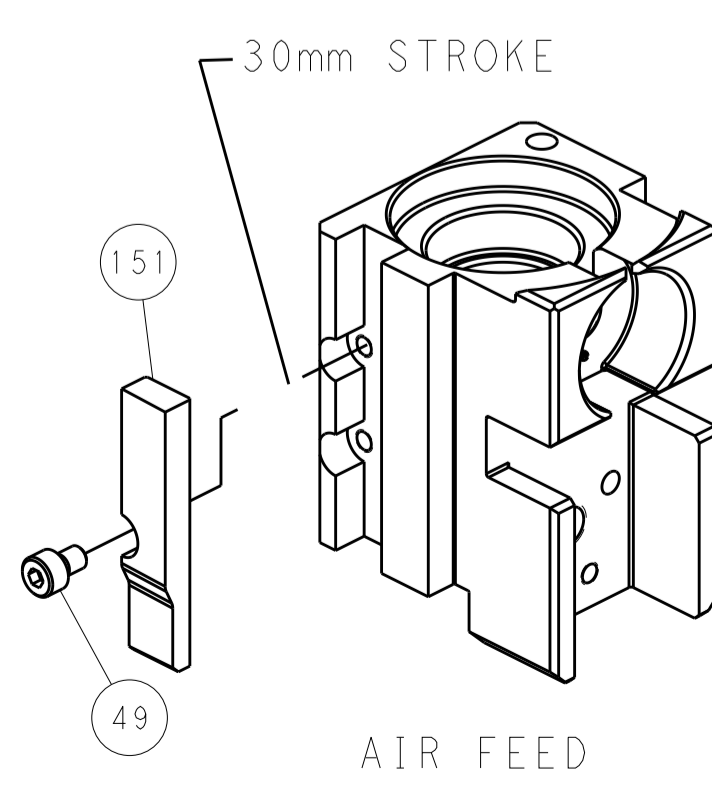
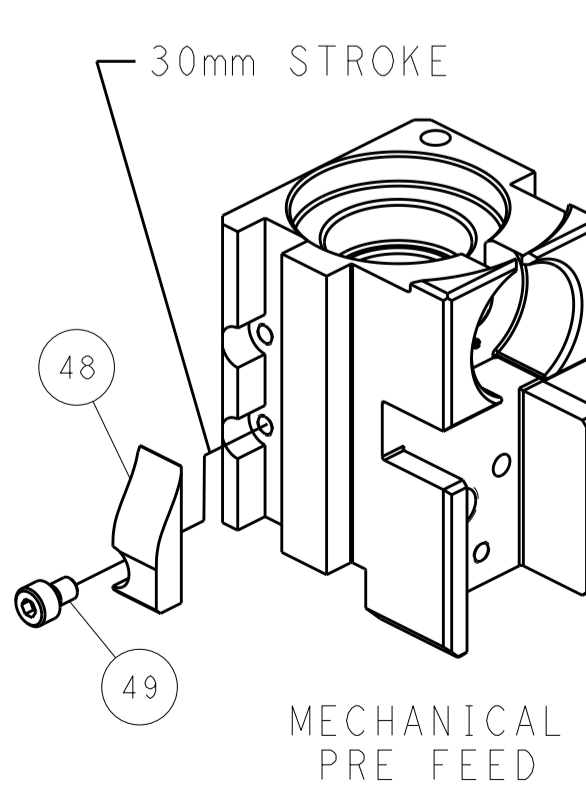
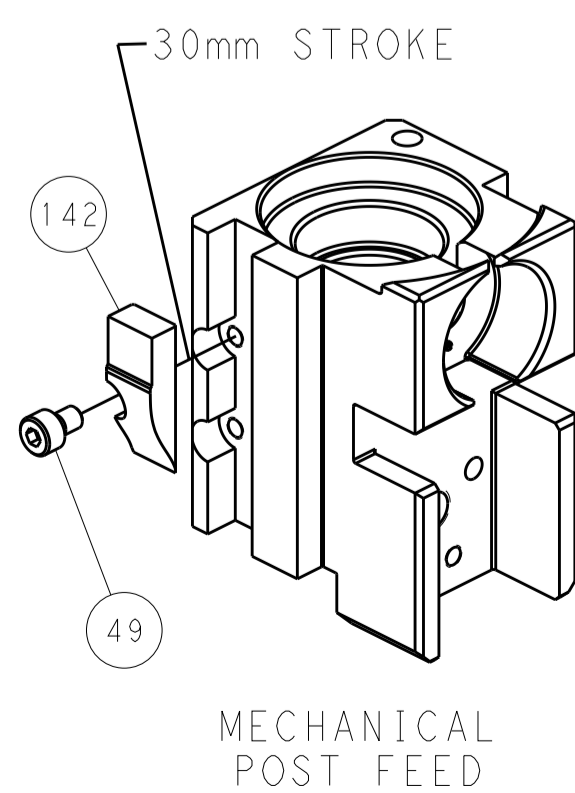
# PNEUMATIC



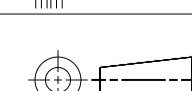
# SERVO LATCH PLATE



# CAM POSITIONS



**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 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		DWG: J.HOU 19JUN2015 CHK: L.ZHANG 19JUN2015 APVD: H.GUO 19JUN2015		NAME: Ocean Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2266822 RESTRICTED TO:	
MATERIAL:		FINISH:		WEIGHT:		SCALE: 1:2 SHEET 4 OF 4 REV A	