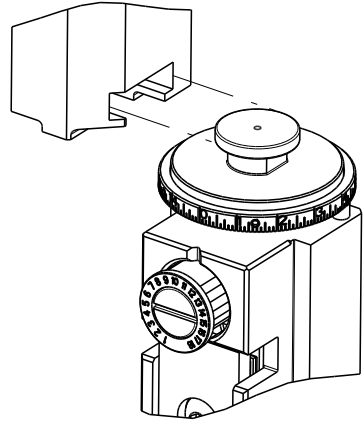
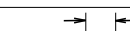


8		7	
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20		20	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2266822-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266822-2	B	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2266822-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR
INTERFACE ADAPTER



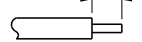
APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.54 mm [.100]	F
INSUL	4.42 mm [.174]	O
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: YAZAKI					TERMINAL YAZAKI					CRIMP SPECIFICATION														
TERMINAL NAME: YAZAKI															TERMINAL									
WIRE STRIP LENGTH										INSULATION DIAMETER RANGE														
5.00-5.50 mm [.197-.217 IN]										Ø														
TERMINAL APPLICATION SPECIFICATION										(A) 71114-4140-02 Rev WA1738					-									
										-														
TERMINALS APPLIED																								
TE TERMINAL					YAZAKI TERMINAL					TE SEAL					YAZAKI SEAL					SEAL INSULATION DIAMETER RANGE				
(A) 1572595-1					(A) 7114-4140-02					1572596-1					7158-3081-50					Ø 1.40-2.10 mm				

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.25mm2	1.45+/-0.05 [.057+/- .002]	6.4
1.00mm2	1.45+/-0.05 [.057+/- .002]	6.4
0.80mm2	1.35+/-0.05 [.053+/- .002]	7.4
0.50mm2	1.25+/-0.05 [.049+/- .002]	8.5



- RECOMMENDED SPARE PARTS
- REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242.
- 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.
- UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- 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.
- CUT TO LENGTH AT ASSEMBLY.

TERMINAL DATA: YAZAKI TERMINAL					YAZAKI CRIMP SPECIFICATION		
TERMINAL NAME: YAZAKI TERMINAL							
WIRE STRIP LENGTH 5.00-5.50 mm [.197-.217 IN]			 INSULATION DIAMETER RANGE Ø				
TERMINAL APPLICATION SPECIFICATION				-		-	
(B) 71116-4140-02 Rev WA1809				-			
TERMINALS APPLIED							
TE TERMINAL		YAZAKI TERMINAL		TE SEAL		YAZAKI SEAL	SEAL INSULATION DIAMETER RANGE
(B) 1572594-1		(B) 71116-4140-02		1572596-1		7158-3081-50	Ø 1.40-2.10 mm

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.25mm2	1.55+/-0.05 [.061+/- .002]	6.4
1.00mm2	1.55+/-0.05 [.061+/- .002]	6.4
0.80mm2	1.40+/-0.05 [.055+/- .002]	7.4
0.50mm2	1.30+/-0.05 [.051+/- .002]	8.5

*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)

2				1						
LOC	DIST	REVISIONS								
A	66	P	LTR	DESCRIPTION				DATE	DWN	APVD
			I	DEVELOPMENT				19JUN2015	JH	UG
			A	RELEASED				21JUL2015	JH	CT
			B	ECR-18-017771				12NOV2018	TB	CT

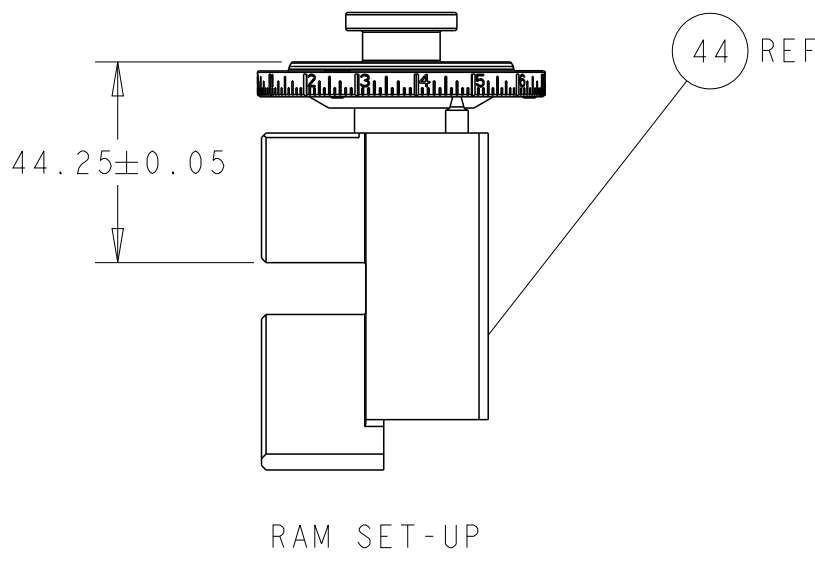
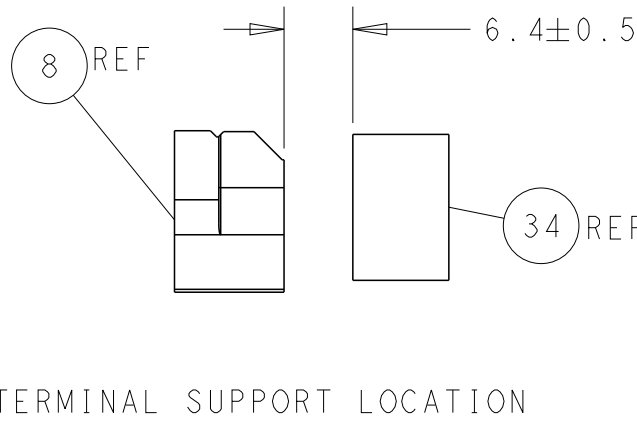
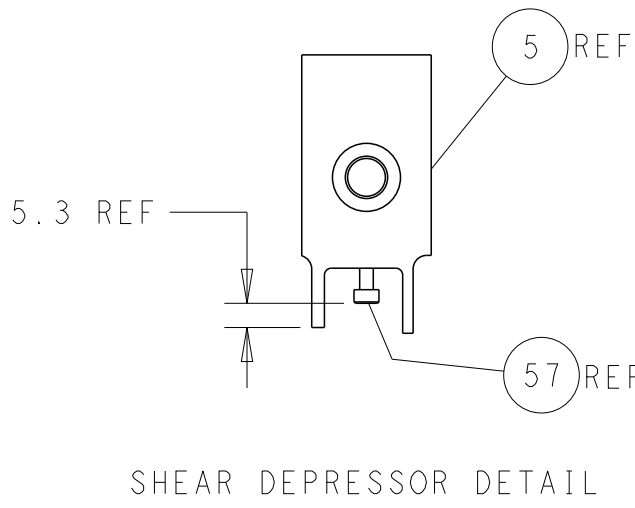
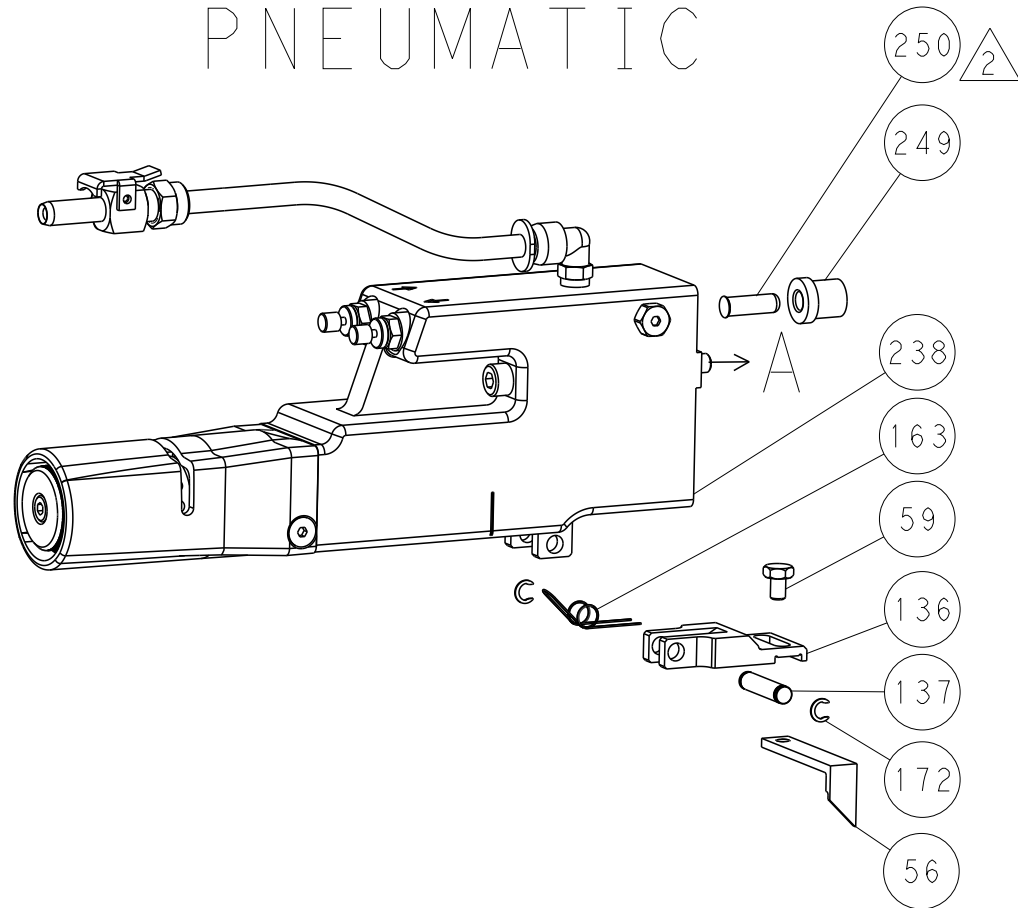
3	-	1	1	1803078-3	SPACER, PRECISION	259
	-	1	1	2119640-1	PUSH ROD, AIR FEED	250
	-	1	1	2079988-1	BUSHING, LCH5-12, MISUMI	249
	-	1	1	2119641-1	FEED CAM, AIR FEED	248
	-	1	1	2119082-1	CAM, SNAIL, INSULATION ADJUSTMENT	244
	-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
	-	1	1	2119083-1	RETAINER, INSULATION DIAL	242
	-	1	1	2063440-1	AIR FEED MODULE	238
	-	2	2	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172
	-	REF	REF	994970-2	COUNTER, MAGNETIC	164
8	-	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	2844908-1	SCREW, LOCKING	99
	-	1	1	2844907-1	POST, LOCKING	98
	-	1	1	1-690438-0	FRONT STRIP GUIDE	96
	-	1	1	455888-5	SPACER, CRIMPER	82
	-	2	2	2079383-4	SCR, BHSC, RoHS (M4 X 8)	79
	-	1	1	1803096-1	EXTENSION PLATE	78
	-	1	1	1803607-1	DOCUMENTATION PACKAGE	71
A	-	1	1	2119740-1	TAG,IDENTIFICATION	67
	-	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
	-	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	60
	-	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
	-	1	1	1-2168083-3	SCR, SKT HD CAP, RoHS, M3 X 16	57
	-	1	1	1338683-8	FEED PAWL	56
	-	4	4	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	54
	-	2	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	53
	-	1	1	5018030-1	NUT, HEX, REG, RoHS, M3	52
	-	1	1	811242-5	BUMPER, HOLD DOWN	51
	-	1	1	690753-2	SPACER, TONKER	50
	-	1	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49
	-	1	1	1-1803583-7	APPLICATOR BASIC ASSEMBLY, SF	46
	-	1	1	1803515-2	RAM ASSEMBLY, SF ATLANTIC	44
	-	1	1	1803602-2	SCR, BHSC, RoHS (M8 X 40)	41
	-	1	1	1752356-3	SUPPORT, TERMINAL	34
	-	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
	-	2	2	2-2844962-1	SPACER, CYLINDRICAL, STRIP GUIDE	30
	-	1	1	2844992-6	ASSEMBLY, STRIP GUIDE	29
	-	1	1	455888-3	SPACER, CRIMPER	28
	-	2	2	22283-1	SPRING, COMPRESSION	27
	-	1	1	240792-1	DRAG, TERMINAL	25
	-	1	1	1320928-4	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	1803013-1	STRIPPER, SIDE FEED	19
	-	1	1	3-22280-3	SPRING, COMPRESSION	12
	-	1	1	1-356885-4	STOP, SHEAR	11
	-	1	1	2119805-7	SHEAR HOLDER, FRONT	10
	-	1	1	318059-9	FLOATING SHEAR, FRONT	9
	1	2	1	2-1633922-7	ANVIL, COMBINATION	8
	-	-	-	-	-	7
	-	-	-	-	-	6
	-	1	1	1-1803080-1	DEPRESSOR, SHEAR	5
	-	1	1	2-238011-7	BLOCK, CRIMPER SPACER	4
	1	2	1	1803248-3	CRIMPER, INSULATION O PREMIUM	3
	-	1	1	1-455888-6	SPACER, CRIMPER	2
	1	2	1	3-456407-8	CRIMPER, WIRE PREMIUM	1

-77-72	-2	PART NO	DESCRIPTION	ITEM NO
Customer Accessible Production Drawing				

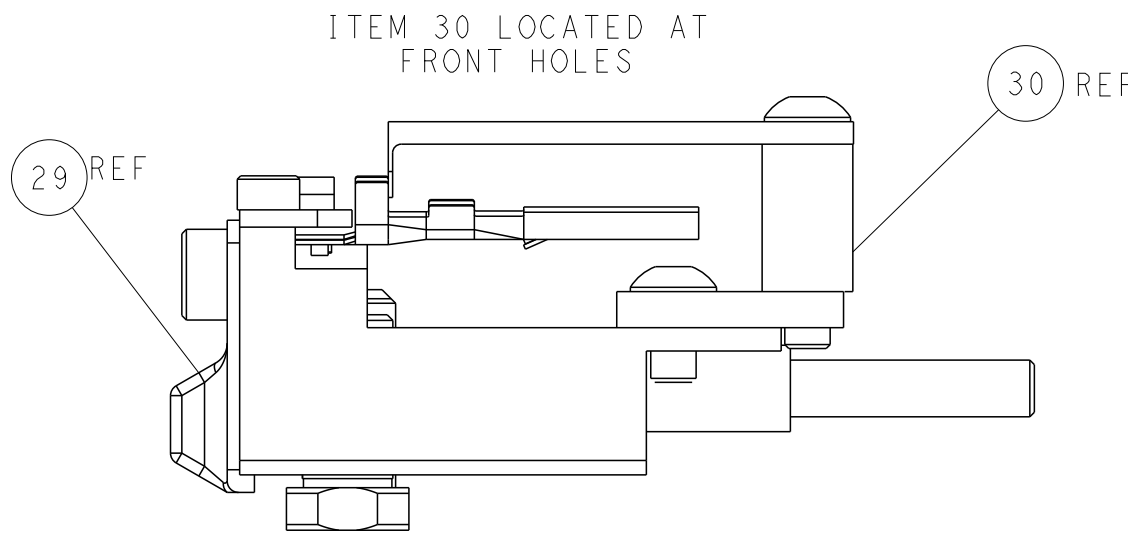
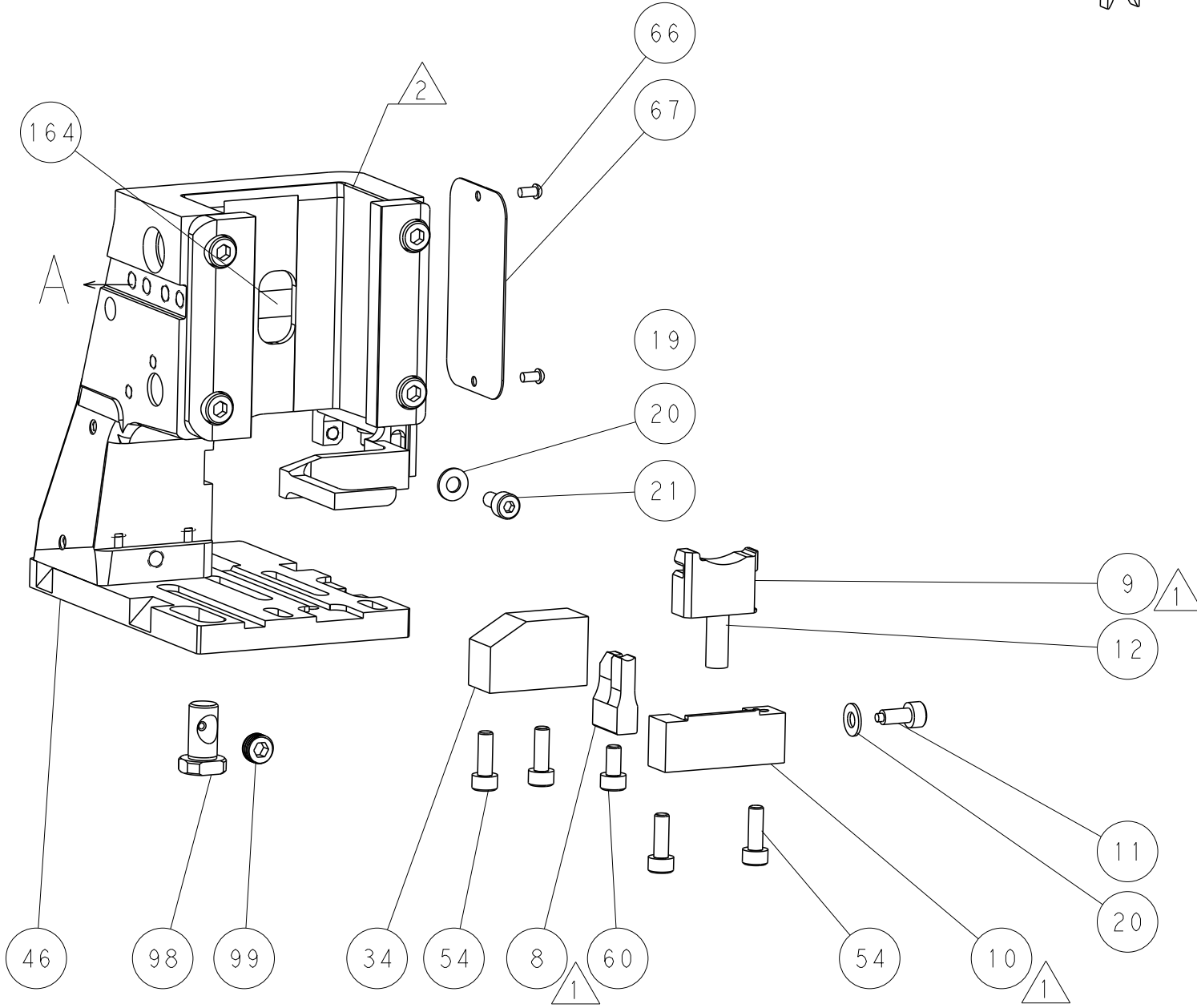
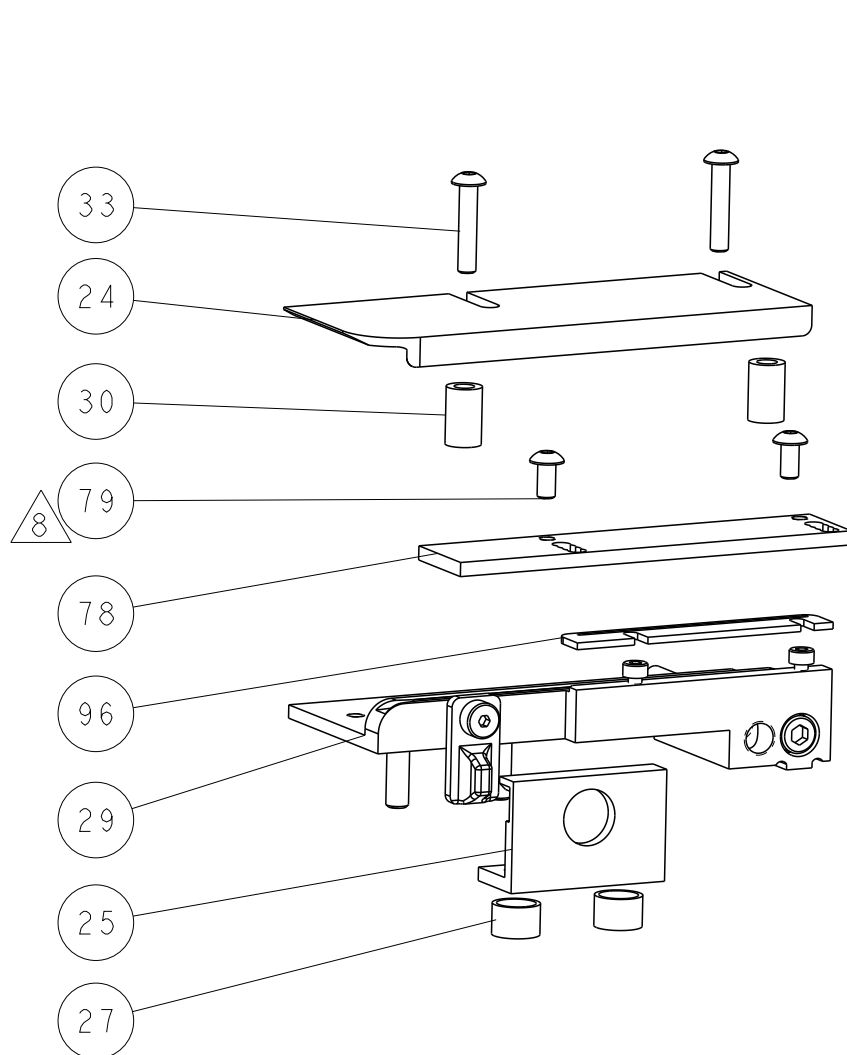
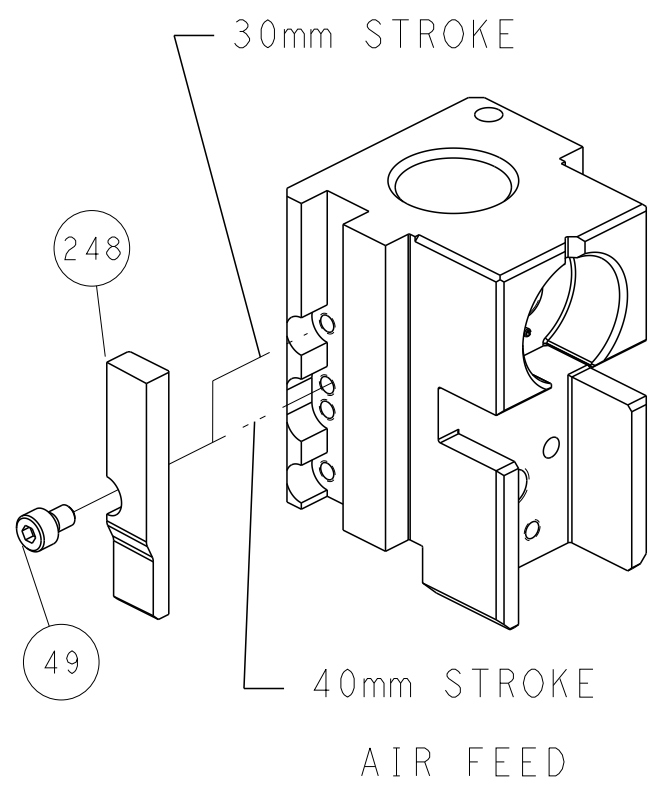
THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. ANY CHANGES TO THIS DRAWING SHOULD BE CONTACTED FOR THE LATEST REVISION.		DWN J. HOU 19JUN2015		CHK L. ZHANG 19JUN2015		APVD J. GUO 19JUN2015		NAME Ocean Side Feed Applicator	
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		PRODUCT SPEC		APPLICATION SPEC		SIZE A	
MATERIAL		FINISH		WEIGHT		SCALE 1:2		SHEET 1 OF 4	

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

FEED TYPE
PNEUMATIC



CAM POSITION



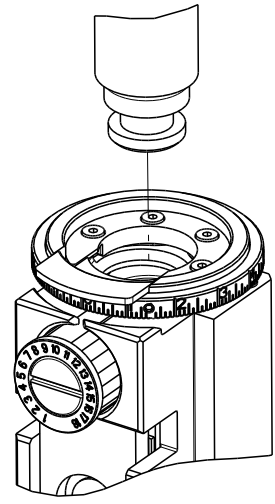
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION IT IS SUBJECT TO COMPANY CONTROL AND ENGINEERING ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST EDITION.				DWN J. HOU 19JUN2015	 TE Connectivity Harrisburg, PA 17105-3608				
				CHK L. ZHANG 19JUN2015					
				APVD J. GUO 19JUN2015	NAME Ocean Side Feed Applicator				
				PRODUCT SPEC -		SIZE A1			
				APPLICATION SPEC -					
				WEIGHT -		CAGE CODE 00779		RESTRICTED TO -	
				SCALE 1:2		SHEET 2 of 4		REV B	

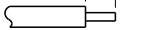
SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

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20		20	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2266822-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266822-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.54 mm [.100]	F
INSUL	4.42 mm [.174]	O
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: YAZAKI TERMINAL YAZAKI CRIMP SPECIFICATION				
TERMINAL NAME: YAZAKI TERMINAL				
WIRE STRIP LENGTH			INSULATION DIAMETER RANGE	
5.00-5.50 mm [.197-.217 IN]			Ø	
TERMINAL APPLICATION SPECIFICATION (A)7114-4140-02 Rev WA1738 - -				
TERMINALS APPLIED				
SEAL INSULATION DIAMETER RANGE				
TE TERMINAL	YAZAKI TERMINAL	TE SEAL	YAZAKI SEAL	Ø 1.40-2.10 mm
(A) 1572595-1	(A) 7114-4140-02	1572596-1	7158-3081-50	

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.25mm2	1.45+/-0.05 [.057+/- .002]	6.4
1.00mm2	1.45+/-0.05 [.057+/- .002]	6.4
0.80mm2	1.35+/-0.05 [.053+/- .002]	7.4
0.50mm2	1.25+/-0.05 [.049+/- .002]	8.5

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.25mm2	1.55+/-0.05 [.061+/- .002]	6.4
1.00mm2	1.55+/-0.05 [.061+/- .002]	6.4
0.80mm2	1.40+/-0.05 [.055+/- .002]	7.4
0.50mm2	1.30+/-0.05 [.051+/- .002]	8.5



- RECOMMENDED SPARE PARTS
- REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242.
- 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.
6. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- APPLY TORQ-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.
- CUT TO LENGTH AT ASSEMBLY.

*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)

2				1					
LOC		DIST		REVISIONS					
A		66		P	LTR	DESCRIPTION	DATE	DWN	APVD
				-	-	SEE SHEET 1	-	-	-

-	1	1803078-3	SPACER, PRECISION	259
-	1	2119640-1	PUSH ROD, AIR FEED	250
-	1	2079988-1	BUSHING, LCH5-12, MISUMI	249
-	1	2119082-1	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	2063440-1	AIR FEED MODULE	238
-	2	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172
-	REF	994970-2	COUNTER, MAGNETIC	164
-	1	240638-1	SPRING, FEED FINGER	163
-	1	2119641-2	FEED CAM, AIR FEED	151
-	1	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	144
-	4	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	143
-	1	1-1803583-8	APPLICATOR BASIC ASSEMBLY, SF	141
-	1	1803516-2	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	2844908-1	SCREW, LOCKING	99
-	1	2844907-1	POST, LOCKING	98
-	1	1-690438-0	FRONT STRIP GUIDE	96
-	1	455888-5	SPACER, CRIMPER	82
-	2	2079383-4	SCR, BHSC, RoHS (M4 X 8)	79
-	1	1803096-1	EXTENSION PLATE	78
-	1	1803607-1	DOCUMENTATION PACKAGE	71
-	1	2119740-1	TAG,IDENTIFICATION	67
-	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	1	1-2168083-3	SCR, SKT HD CAP, RoHS, M3 X 16	57
-	1	1338683-8	FEED PAWL	56
-	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	53
-	1	5018030-1	NUT, HEX, REG, RoHS, M3	52
-	1	811242-5	BUMPER, HOLD DOWN	51
-	1	690753-2	SPACER, TONKER	50
-	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	1	1803602-2	SCR, BHSC, RoHS (M8 X 40)	41
-	1	1752356-3	SUPPORT, TERMINAL	34
-	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2-2844962-1	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	2844992-6	ASSEMBLY, STRIP GUIDE	29
-	1	455888-3	SPACER, CRIMPER	28
-	2	22283-1	SPRING, COMPRESSION	27
-	1	240792-1	DRAG, TERMINAL	25
-	1	1320928-4	STRIP GUIDE	24
-	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
-	2	1-18028-2	WASHER, FLAT, REG M4	20
-	1	1803013-1	STRIPPER, SIDE FEED	19
-	1	3-22280-3	SPRING, COMPRESSION	12
-	1	1-356885-4	STOP, SHEAR	11
-	1	2119805-7	SHEAR HOLDER, FRONT	10
-	1	318059-9	FLOATING SHEAR, FRONT	9
1	1	2-1633922-7	ANVIL, COMBINATION	8
-	-	-	-	7
-	-	-	-	6
-	1	1-1803080-1	DEPRESSOR, SHEAR	5
-	1	2-238011-7	BLOCK, CRIMPER SPACER	4
1	1	1803248-3	CRIMPER, INSULATION O PREMIUM	3
-	1	1-455888-6	SPACER, CRIMPER	2
1	1	3-456407-8	CRIMPER, WIRE PREMIUM	1

-77	-22	PART NO	DESCRIPTION	ITEM NO
DWN		19JUN2015	STE TE Connectivity Harrisburg, PA 17105-3608	
CHK		19JUN2015	NAME	
L.ZHANG			Ocean Side Feed Applicator	
APVD		19JUN2015	SIZE	
U.GUO			CAGE CODE	
PRODUCT SPEC			DRAWING NO	
APPLICATION SPEC			RESTRICTED TO	
WEIGHT			A1 00779	
MATERIAL			C=2266822	
Customer Accessible Production Drawing		SCALE	1:2	SHEET 3 OF 4
		REV	B	

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

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

D

C

B

A

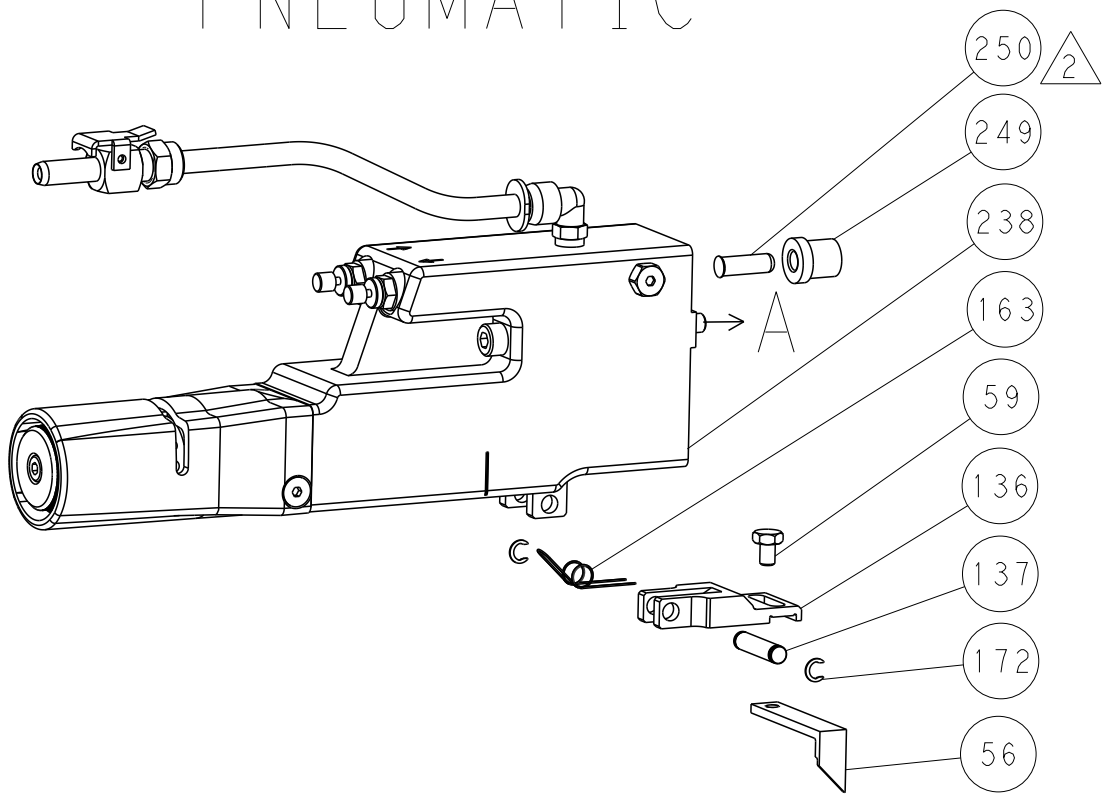
D

C

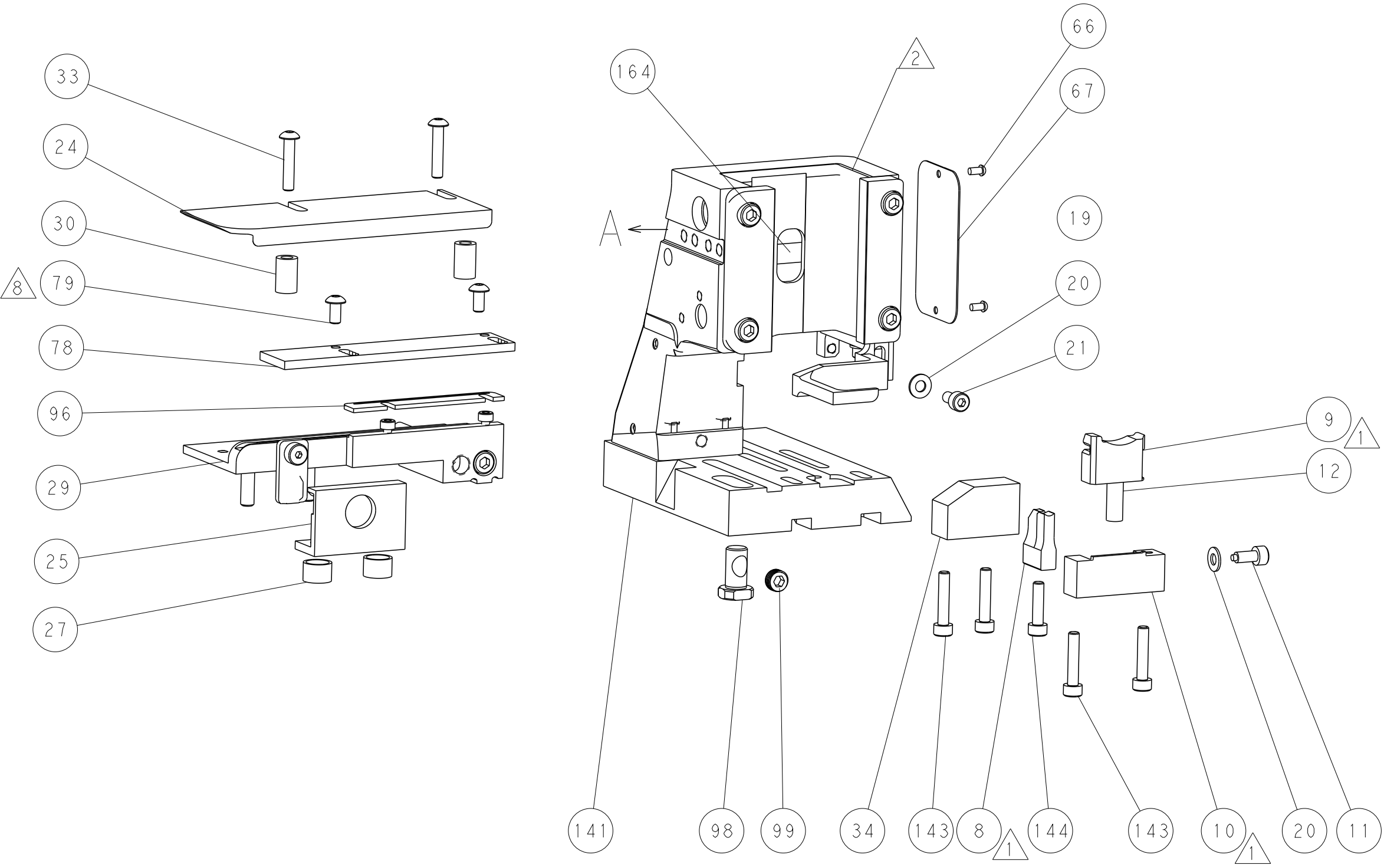
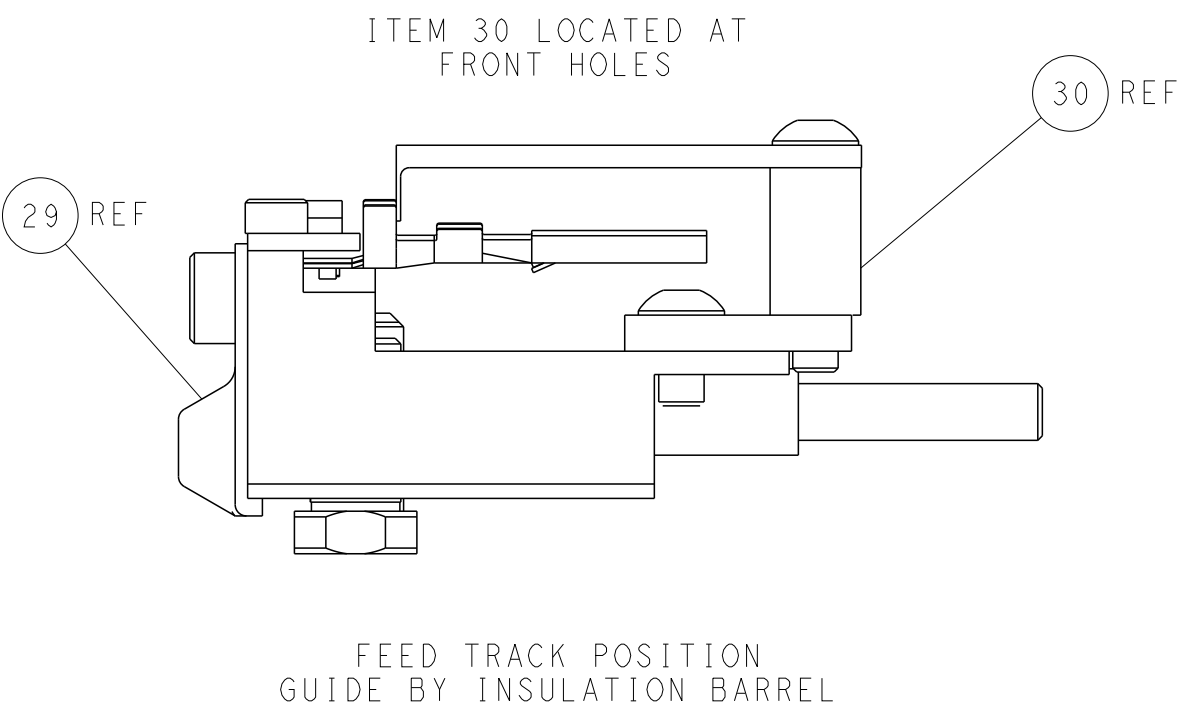
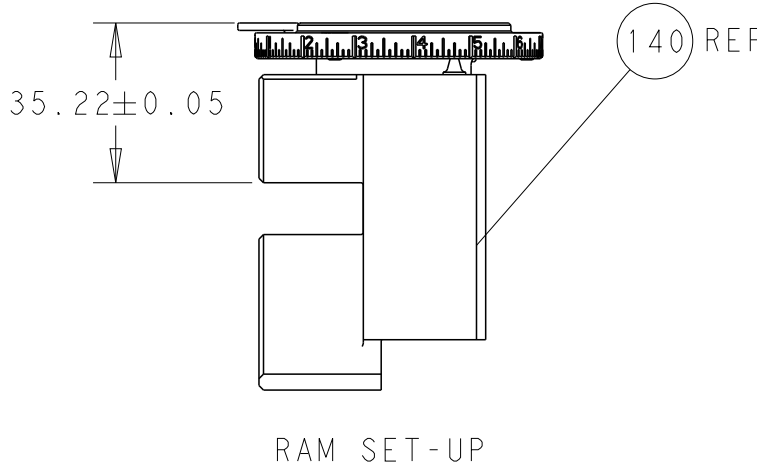
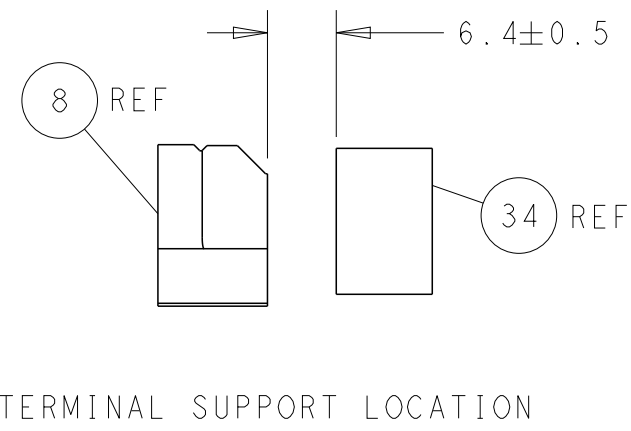
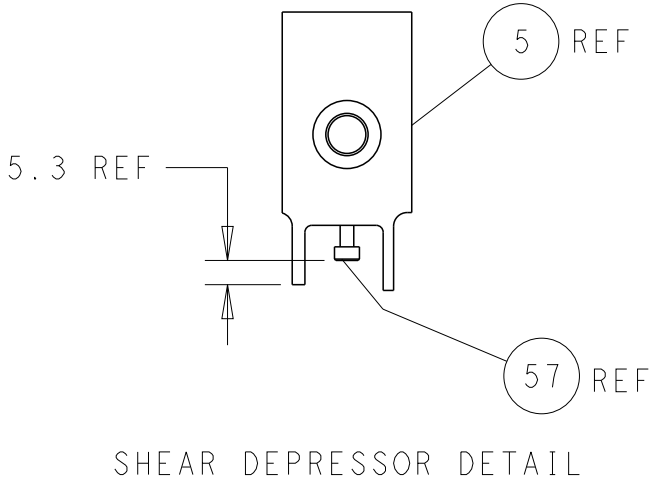
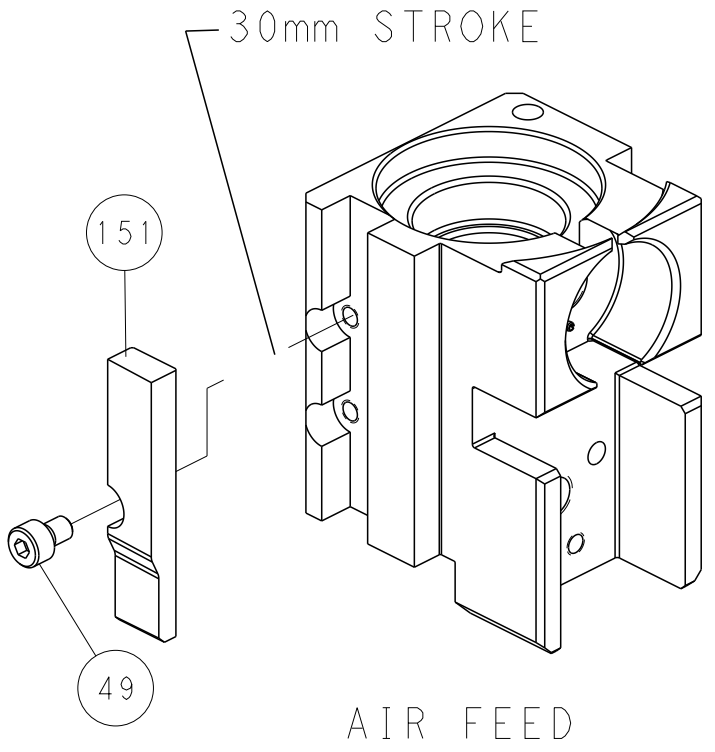
B

A

FEED TYPE
PNEUMATIC



CAM POSITION



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

THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. IT IS THE RESPONSIBILITY OF THE USER TO CONTACT THE ORGANIZATION FOR THE LATEST REVISION.				DWN	J. HOU	19JUN2015	 TE Connectivity Harrisburg, PA 17105-3608				
				CHK	L. ZHANG	19JUN2015					
				APVD	J. GUO	19JUN2015	NAME				
				PRODUCT SPEC				Ocean Side Feed Applicator			
				APPLICATION SPEC							
				WEIGHT				RESTRICTED TO			
				Customer Accessible Production Drawing				REV B			

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION