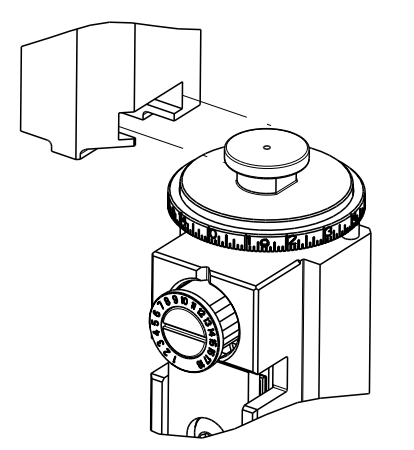


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REV	DATE	BY	CHK	APP'D	DESCRIPTION
A	21JUN2013	RW	GB		RELEASED
A1	12JUN2014	JH	TE		ECR-14-008825
A2	30SEP2014	XZ	TE		ECR-14-013927
B	16NOV2016	YY	CT		ECR-16-016218

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	PART NUMBERS REQUIRED						
				CONVERT TO	2119950-1	1338685-1	5-18022-5	2119641-1	2119799-1	2063440-1
2151965-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL	PNEUMATIC FEED	2119950-1	1338685-1	5-18022-5	2119641-1	2119799-1	2063440-1
				SERVO LATCH PLATE	2119951-1	-	8-2151965-5	1901094-3	1-1752354-9	2168400-6 (QUANTITY 2)
				SMART APPLICATOR	2161326-1	-	8-2151965-4	-	-	-
2151965-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-1	-	-
				SERVO LATCH PLATE	2119951-1	-	8-2151965-5	1901094-3	1-1752354-9	2168400-6 (QUANTITY 2)
				SMART APPLICATOR	2161326-1	-	8-2151965-4	-	-	-
2151965-5	B	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE <sup>4</sup>	MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-1	-	
				PNEUMATIC FEED	2119950-1	1338685-1	5-18022-5	2119641-1	2119799-1	2063440-1
2151965-6	B	NON-CRIMP HEIGHT ADJUST	SERVO LATCH PLATE <sup>4</sup>	-	-	-	-	-	-	
				-	-	-	-	-	-	
2151965-7	B	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	
				-	-	-	-	-	-	
7-2151965-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-	



**APPLICATOR DATA**

CRIMP	SIZE	TYPE
WIRE	1.68 mm [.066]	F
INSUL	3.40 mm [.134]	O

**APPLICATOR INSTRUCTIONS**  
408-10389

**TERMINAL DATA: YAZAKI TERMINAL YAZAKI CRIMP SPECIFICATION**

TERMINAL NAME: 1.5 SYSTEM SEALED CONNECTOR, MALE

WIRE STRIP LENGTH	INSULATION DIAMETER RANGE
5.00-5.50 mm [.197-.217 IN]	Ø1.10-2.20 mm [.043-.087 IN]

TERMINAL APPLICATION SPECIFICATION: 72-WT08-767 Rev WA1927

**TERMINALS APPLIED<sup>3</sup>**

TE TERMINAL	YAZAKI TERMINAL	TE SEAL	YAZAKI SEAL
(A) 1655086-1	(A) 7114-4102-02	1572025-1	7158-3030-50
(A) 1655086-2	(A) 7114-4102-08	1572025-2	7158-3030-90
(A) 1642494-1	(A) 7114-4102-02	1832579-1	7158-3031-90
		TE SEAL	FORD SEAL
		1949248-1	97BG-10C930-SBA
		1448692-1	XW43-14603-AA

**TERMINAL DATA: YAZAKI TERMINAL YAZAKI CRIMP SPECIFICATION**

TERMINAL NAME: 1.5 SYSTEM SEALED CONNECTOR, FEMALE

WIRE STRIP LENGTH	INSULATION DIAMETER RANGE
5.00-5.50 mm [.197-.217 IN]	Ø1.10-2.40 mm [.043-.094 IN]

TERMINAL APPLICATION SPECIFICATION: 72-WT10-1635 Rev WA1986

**TERMINALS APPLIED<sup>3</sup>**

TE TERMINAL	YAZAKI TERMINAL	TE SEAL	YAZAKI SEAL
(B) 1832234-1	(B) 7116-4102-02	1572025-1	7158-3030-50
(B) 1448691-1	(B) 7116-4102-08	1572025-2	7158-3030-90
		1832579-1	7158-3031-90
		TE SEAL	FORD SEAL
		1949248-1	97BG-10C930-SBA
		1448692-1	XW43-14603-AA

**WIRE SIZE**

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.50mm2	1.05+/-0.05 [.041+/-0.002]	7.7
0.30mm2 OR 0.35mm2	1.00+/-0.05 [.039+/-0.002]	8.2

**WIRE SIZE**

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.50mm2	1.00+/-0.05 [.039+/-0.002]	8.8
0.35mm2	0.95+/-0.05 [.037+/-0.002]	9.3
0.30mm2	0.90+/-0.04 [.035+/-0.002]	9.9

- RECOMMENDED SPARE PARTS**
- 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: 8-2151965-4  
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151965-4  
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151965-5  
 SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2151965-6
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 4.75.
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.

**\*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.

QTY	DESCRIPTION	ITEM NO
-	APPLICATOR SHIM PACK	260
-	O-RING, .676 ID, .070 DIA. MAT.	252
-	PUSH ROD, AIR FEED	250
-	BUSHING, LCH5-12, MISUMI	249
-	FEED CAM, AIR FEED	248
-	DETENT PIN	247
-	SPRING, COMPRESSION	246
-	RAM, AMP STYLE, SIDE FEED, NON-ADJ.	245
-	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	RETAINER, INSULATION DIAL	242
-	SCR, SKT HD CAP M3 X 4.0	241
-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)

REV	DATE	BY	CHK	APP'D	DESCRIPTION	DATE	OWN	APVD
-	-	-	-	-	2168400-6	SHCS, LOW HEAD, RoHS, M5 X 16		240
-	-	-	-	-	2119580-1	MECHANICAL FEED ASSEMBLY		239
-	-	-	-	-	2063440-1	AIR FEED MODULE		238
-	-	-	-	-	2119740-2	TAG, IDENTIFICATION		213
-	-	-	-	-	1901094-3	SPACER, FEEDER		198
-	-	-	-	-	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT		172
-	-	-	-	-	994969-1	MAGNET, RARE EARTH HIGH ENERGY		166
-	-	-	-	-	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
-	-	-	-	-	SEE NOTE 4	MEMORY CHIP, PROGRAMMED		135
-	-	-	-	-	1633743-1	SERVO FEED LATCH ASM		133
-	-	-	-	-	1-22281-8	SPRING, COMPRESSION		121
-	-	-	-	-	1-18028-2	WASHER, FLAT, REG M4		119
-	-	-	-	-	2119944-1	FEED FINGER ASSEMBLY,SF		117
-	-	-	-	-	2-690438-2	FRONT STRIP GUIDE		96
-	-	-	-	-	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0		95
-	-	-	-	-	2168083-6	SCR, SKT HD CAP, RoHS, M5 X 65		93
-	-	-	-	-	455888-5	SPACER, CRIMPER		82
-	-	-	-	-	2119956-1	DOCUMENTATION PACKAGE		71
-	-	-	-	-	2119740-1	TAG, IDENTIFICATION		67
-	-	-	-	-	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188		66
-	-	-	-	-	2119793-1	LIMITER, ADJUSTMENT BOLT		63
-	-	-	-	-	992763-5	SCR, SET, SOC, CONE POINT, M3 x 4.0		62
-	-	-	-	-	2-18032-5	SCR, SET, FLT POINT M5 X 20.0		61
-	-	-	-	-	2079383-4	SCR, BHSC, RoHS (M4 X 8)		60
-	-	-	-	-	5-18022-5	SCR, HEX HD CAP, M4 X 6.0		59
-	-	-	-	-	985575-3	SCR, FLT SKT HD CAP M3 X 10.0		57
-	-	-	-	-	1338685-1	PAWL, FEED		56
-	-	-	-	-	2168400-1	SHCS, LOW HEAD, RoHS, M4 X 12		54
-	-	-	-	-	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0		53
-	-	-	-	-	5018030-1	NUT, HEX, REG, RoHS, M3		52
-	-	-	-	-	811242-5	BUMPER, HOLD DOWN		51
-	-	-	-	-	690753-2	SPACER, TONKER		50
-	-	-	-	-	18023-9	SCR, SKT HD CAP M4 X 6.0		49
-	-	-	-	-	2119652-1	FEED CAM, PRE FEED		48
-	-	-	-	-	2119653-1	FEED CAM, POST FEED		47
-	-	-	-	-	2119656-9	APPLICATOR BASIC ASSEMBLY, SF		46
-	-	-	-	-	2119370-1	RAM, AMP STYLE, SIDE FEED		44
-	-	-	-	-	2079383-7	SCR, BHSC, RoHS (M8 X 25)		41
-	-	-	-	-	2119645-1	DISC, NUMBERED FA WIRE ADJUSTMENT		40
-	-	-	-	-	2119957-1	APPLICATOR SHIM PACK		39
-	-	-	-	-	2119644-1	RAM WASHER, PRECISION		38
-	-	-	-	-	2119085-1	FA HEAD, ATLANTIC STYLE		37
-	-	-	-	-	2119092-1	BOLT, ADJUSTMENT		35
-	-	-	-	-	1752356-3	SUPPORT, TERMINAL		34
-	-	-	-	-	2079383-5	SCR, BHSC, RoHS (M4 X 20)		33
-	-	-	-	-	2161328-1	HEX HEAD, FLANGED, M5 x 8mm LONG		32
-	-	-	-	-	1-1320908-2	SPACER, STRIP GUIDE		30
-	-	-	-	-	1901086-5	PLATE, STRIP GUIDE		29
-	-	-	-	-	455888-3	SPACER, CRIMPER		28
-	-	-	-	-	22281-8	SPRING, COMPRESSION		27
-	-	-	-	-	356835-1	LEVER, DRAG RELEASE		26
-	-	-	-	-	240792-2	DRAG, TERMINAL		25
-	-	-	-	-	1320928-6	STRIP GUIDE		24
-	-	-	-	-	980371-4	SCR, SKT HD SHLDR 5.0 DIA X 6.0		23
-	-	-	-	-	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0		21
-	-	-	-	-	1-18028-2	WASHER, FLAT, REG M4		20
-	-	-	-	-	2119533-1	STRIPPER, SIDE FEED		19
-	-	-	-	-	2119806-1	INSERT, SHEAR		13
-	-	-	-	-	3-22280-3	SPRING, COMPRESSION		12
-	-	-	-	-	1-356885-4	STOP, SHEAR		11
-	-	-	-	-	2119805-1	SHEAR HOLDER, FRONT		10
-	-	-	-	-	318707-1	FLOATING SHEAR, FRONT		9
-	-	-	-	-	4-1633927-8	ANVIL, COMBINATION		8
-	-	-	-	-	-	-		7
-	-	-	-	-	-	-		6
-	-	-	-	-	2119781-1	DEPRESSOR, SHEAR		5
-	-	-	-	-	5-238011-5	BLOCK, CRIMPER SPACER		4
-	-	-	-	-	1803018-3	CRIMPER, INSULATION O		3
-	-	-	-	-	1-455888-2	SPACER, CRIMPER		2
-	-	-	-	-	1-568176-4	CRIMPER, WIRE		1
-77	-7	-6	-5	-2	-1	PART NO	DESCRIPTION	ITEM NO

**STE** TE Connectivity  
 Harrisburg, PA 17105-3608

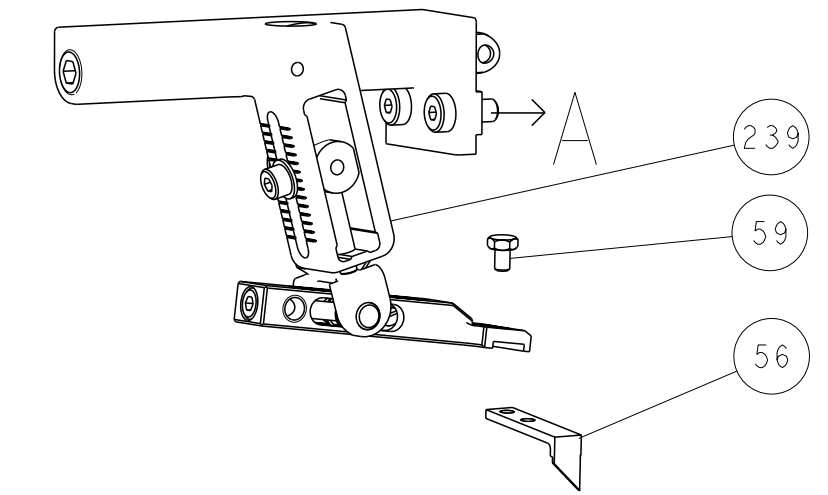
NAME: Ocean Side Feed Applicator

SIZE: A1 CASE CODE: 00779 DRAWING NO: ©=2151965

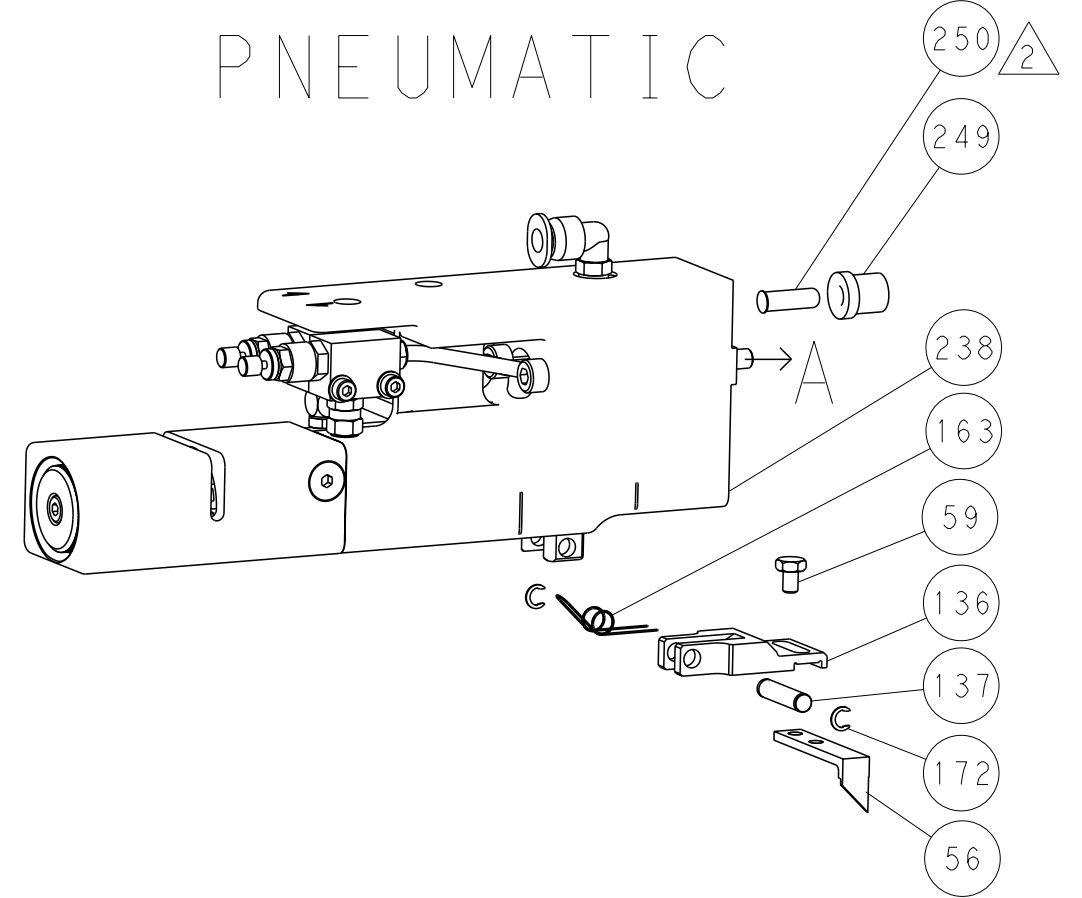
RESTRICTED TO: Customer Accessible Production Drawing SCALE: 1:2 SHEET 1 OF 4 REV B

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

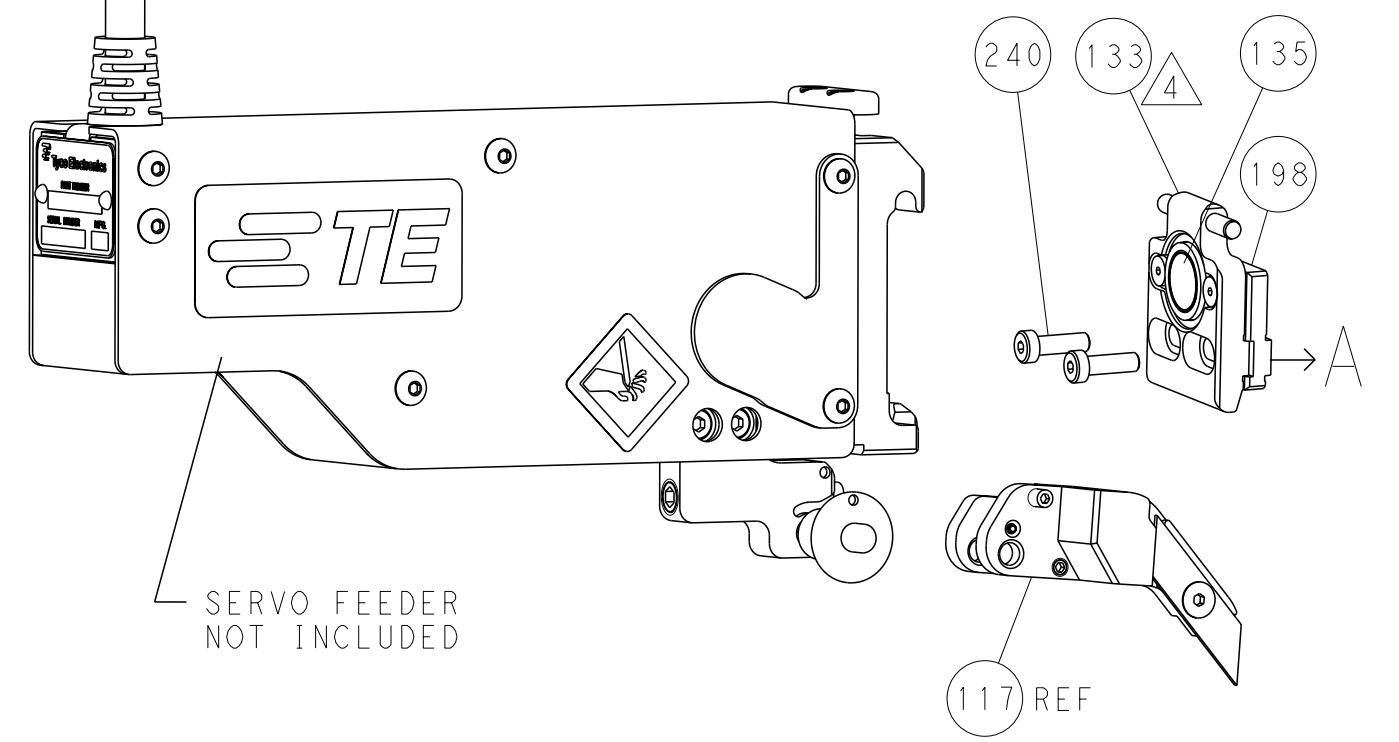
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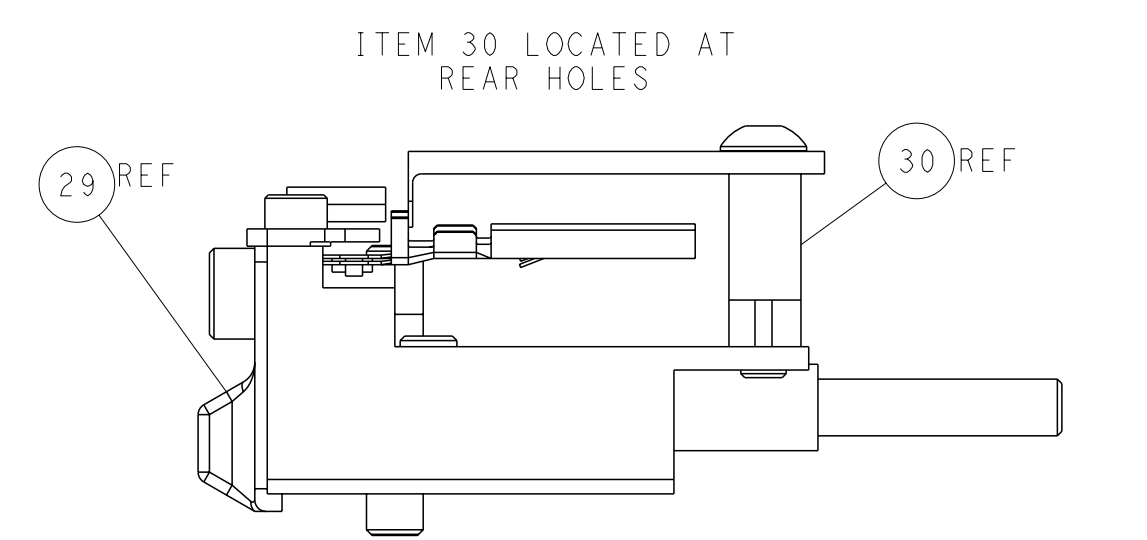
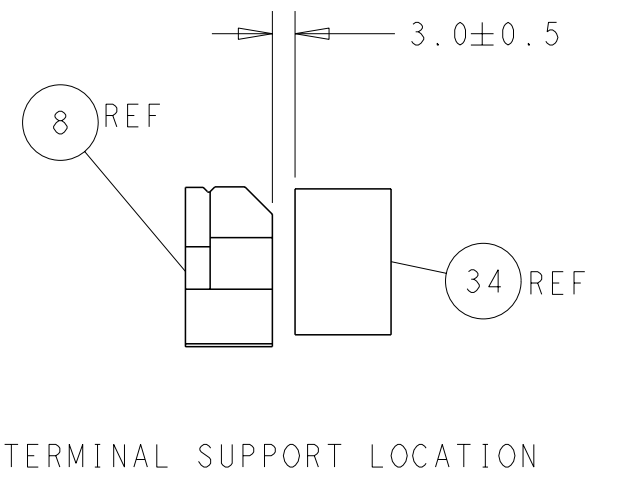
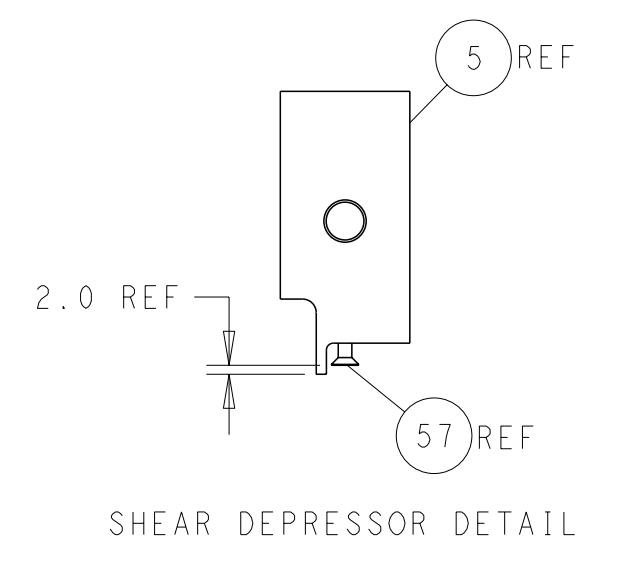
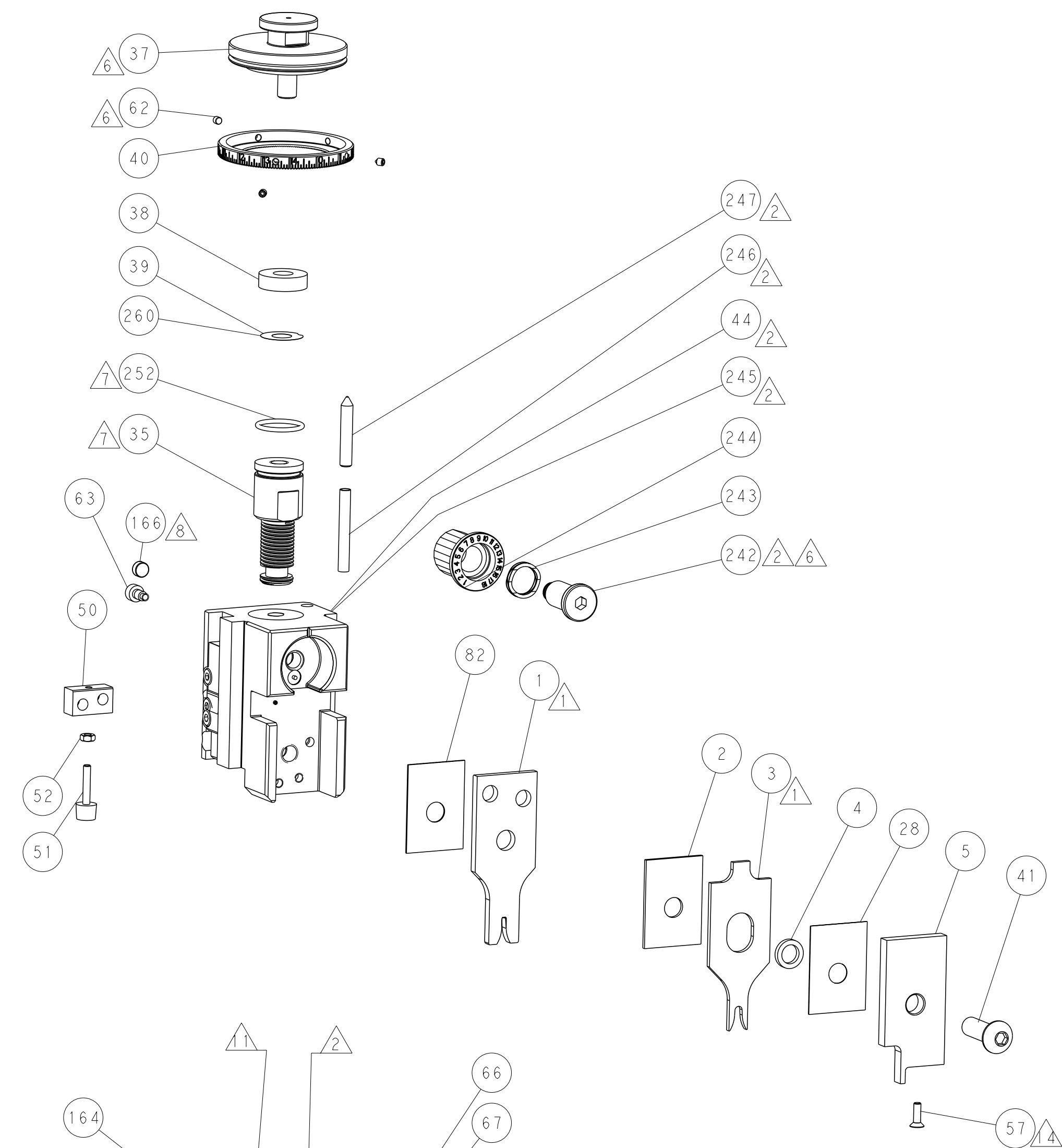
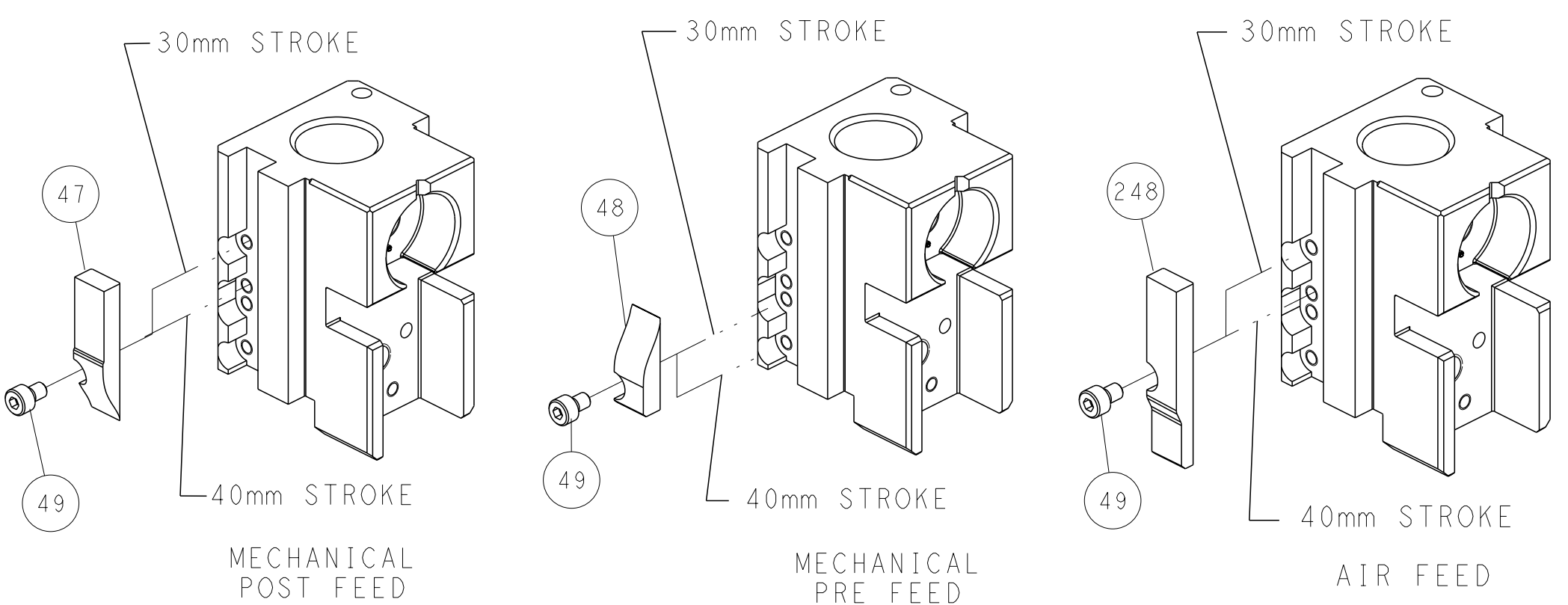
### PNEUMATIC



### 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)

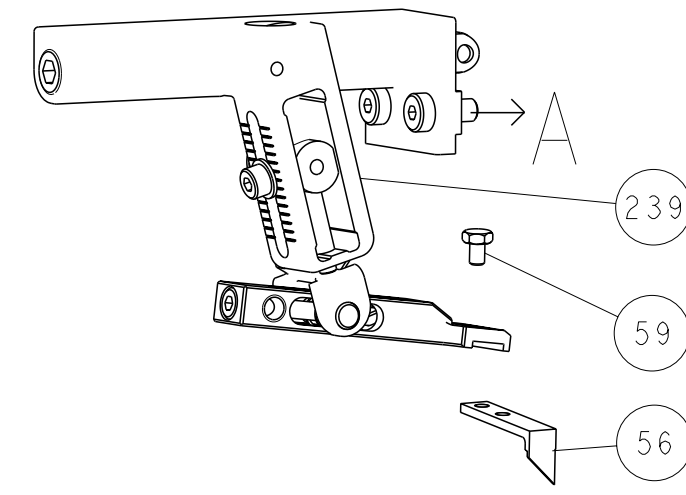
<small>THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE AND THE CONTROL AND REVISIONS ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST REVISION.</small>		OWN: R. O. WILSON 22MAY2013 CHK: K. J. STAKEM 22MAY2013 APVD: J. L. ELBIN 22MAY2013	TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.5 1 PLC ±0.13 2 PLC ±0.13 3 PLC ±0.013 4 PLC ±0.0013 ANGLES FINISH: -		NAME: Ocean Side Feed Applicator PRODUCT SPEC: - APPLICATION SPEC: - WEIGHT: -	SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2151965 RESTRICTED TO: -
MATERIAL: - FINISH: -		SCALE: 1:2 SHEET: 2 of 4 REV: B	Customer Accessible Production Drawing



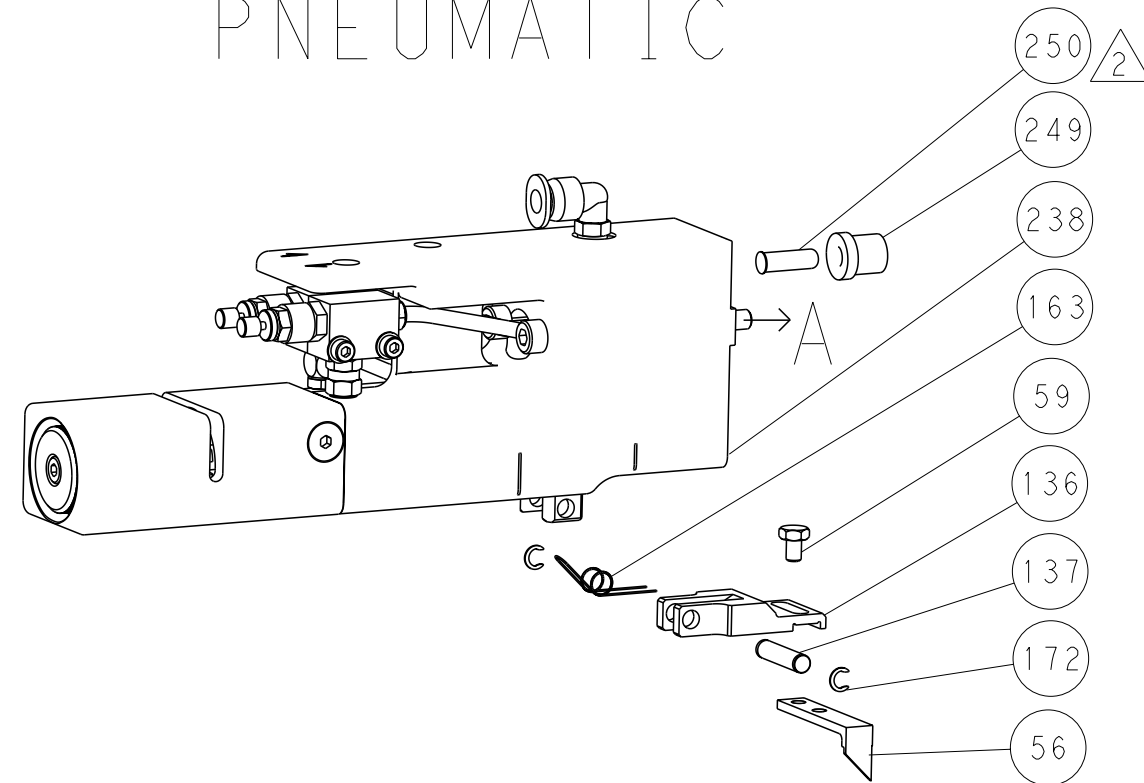


LOC	DIST	REVISIONS			
A	66	REV	DATE	OWN	APVD
-	SEE SHEET 1	-	-	-	-

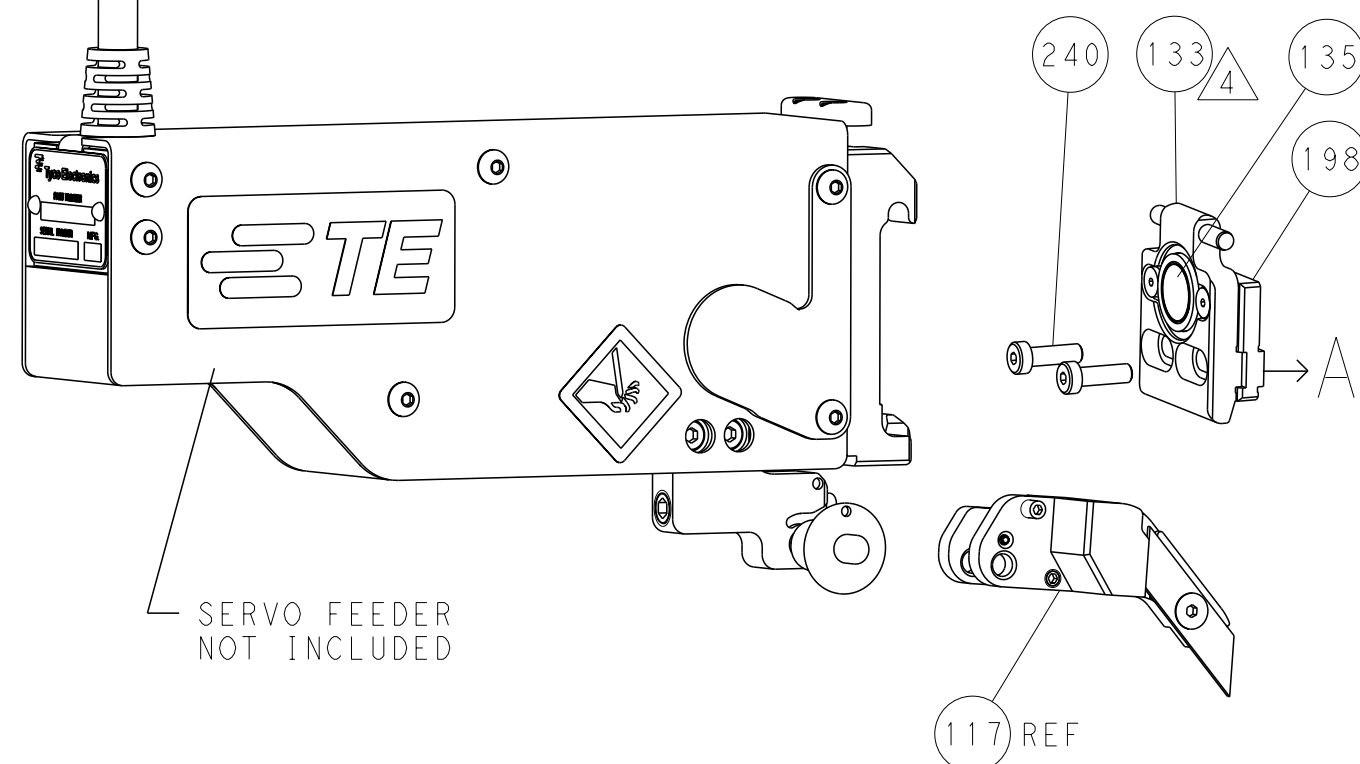
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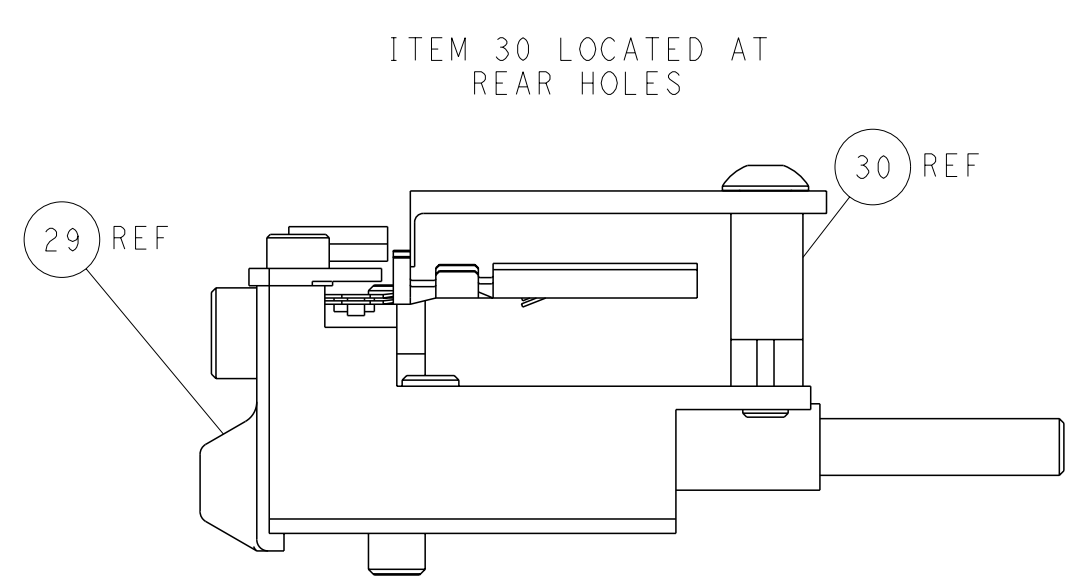
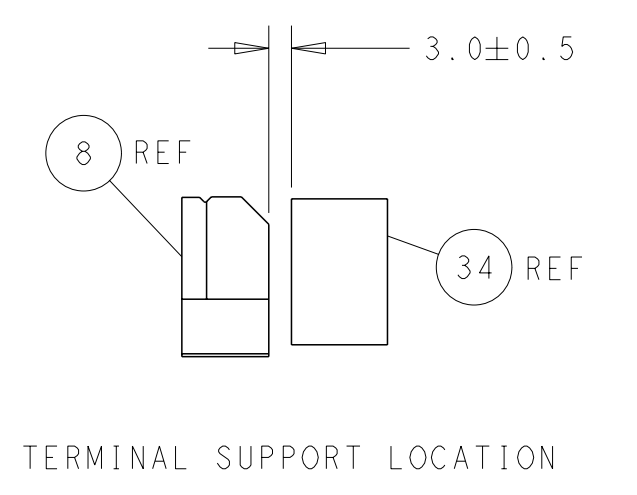
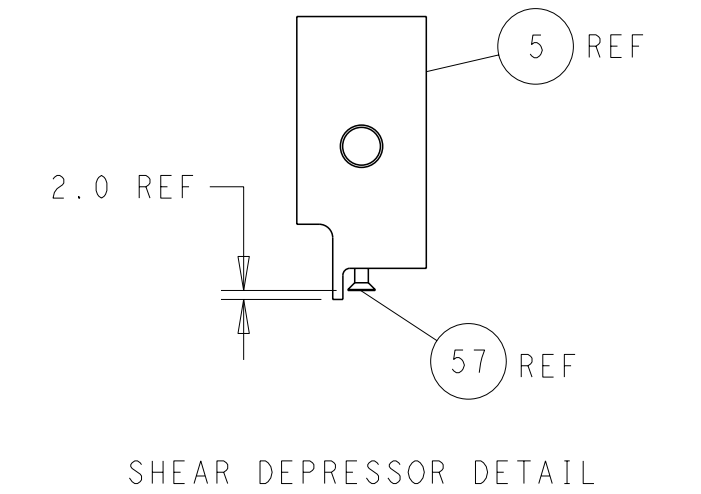
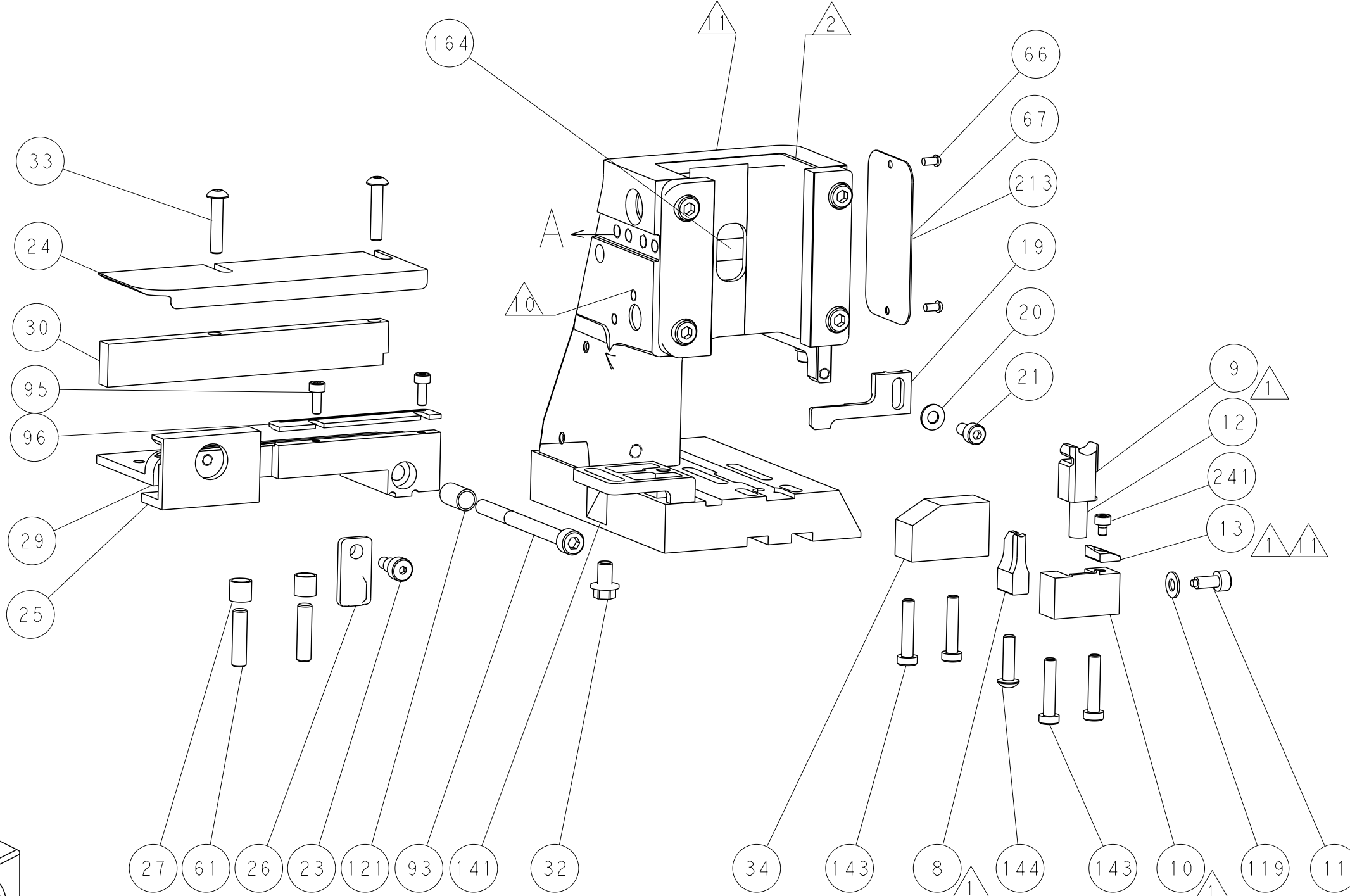
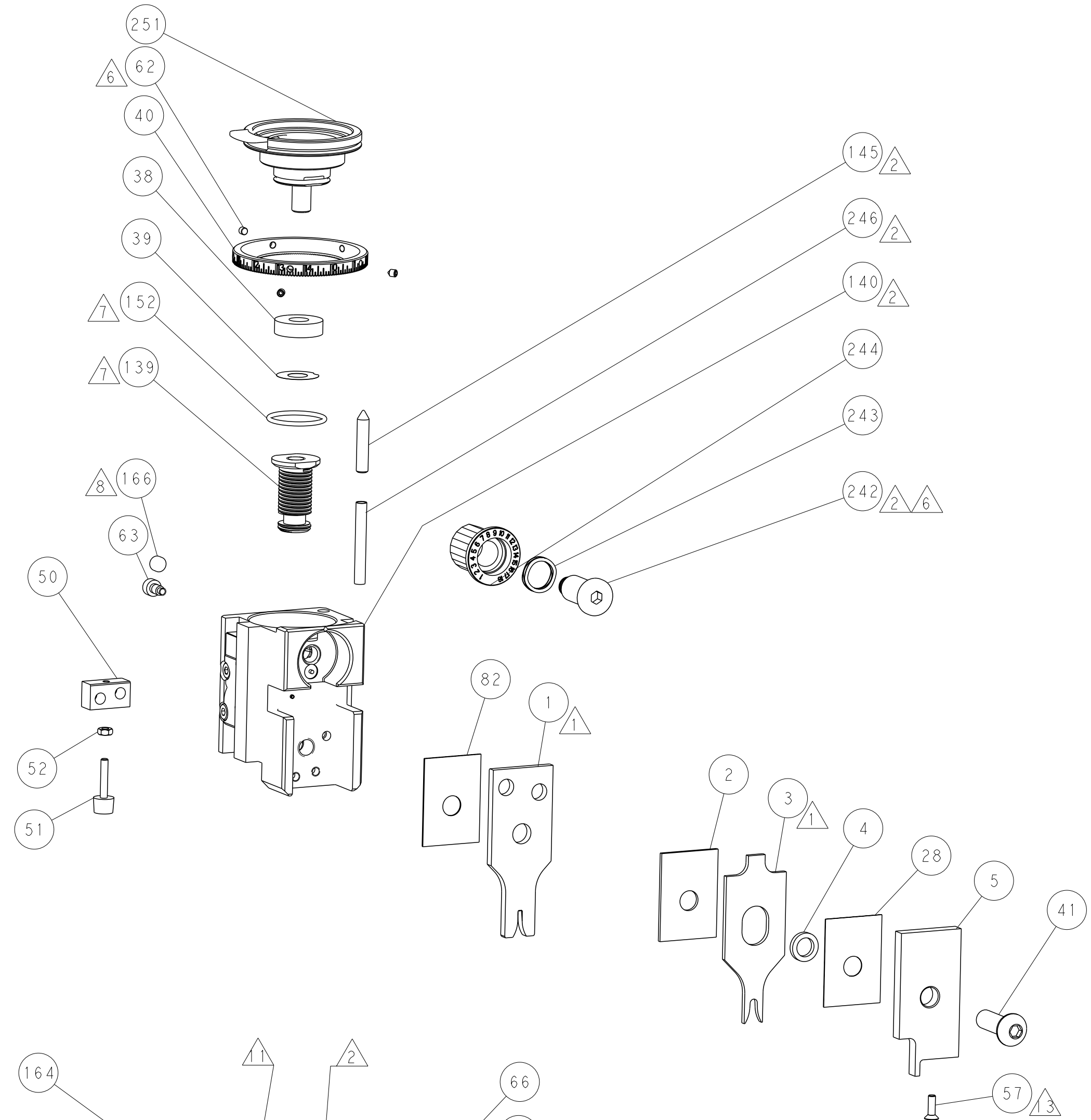
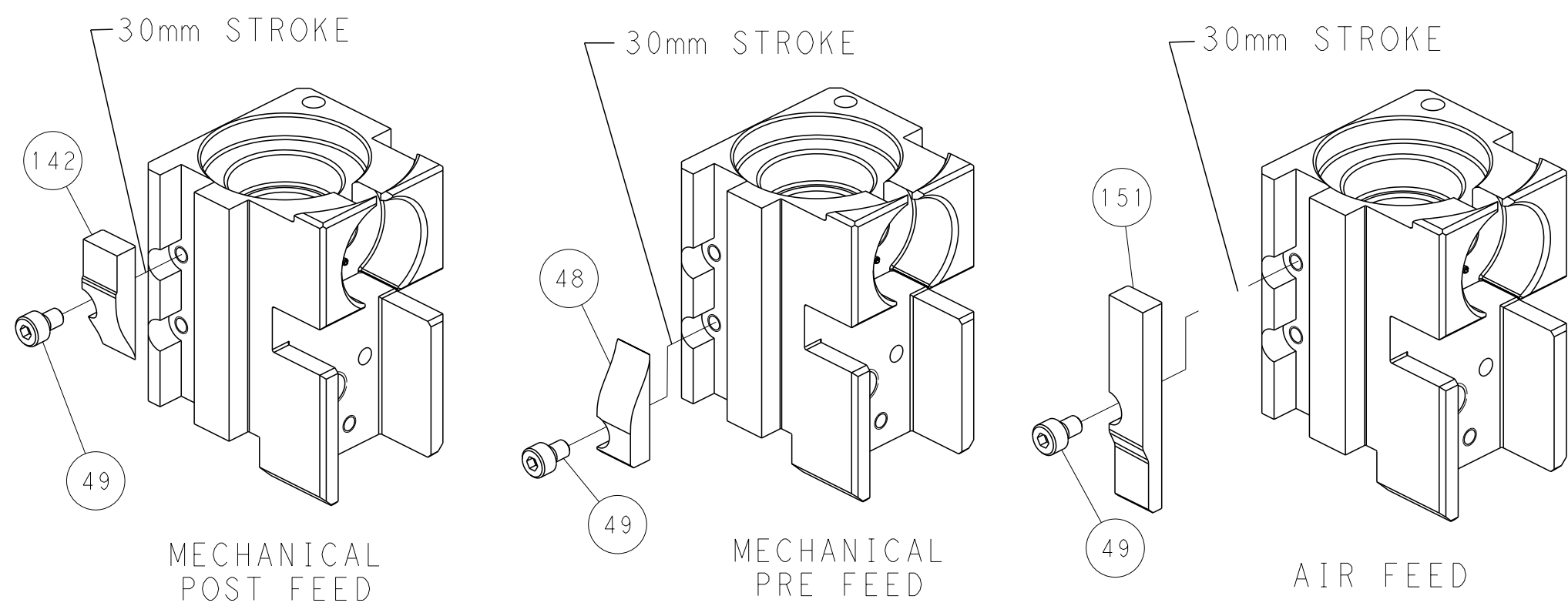
# PNEUMATIC



# 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 ±.5 1 PLC ±0.5 2 PLC ±0.13 3 PLC ±0.013 4 PLC ±0.0001 ANGLES FINISH: *	PRODUCT SPEC: - APPLICATION SPEC: - WEIGHT: - MATERIAL: -	SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2151965	RESTRICTED TO: - SCALE: 1:2 SHEET: 4 of 4 REV: B