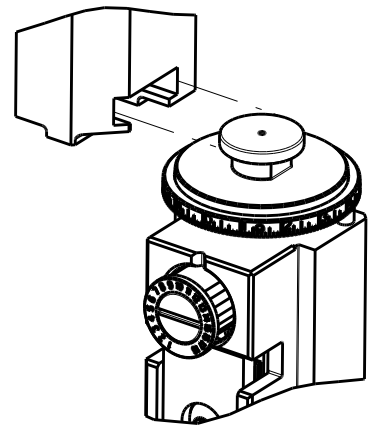




APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	4.00 mm [.157]	F
INSUL	8.50 mm [.335]	F
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: YAZAKI TERMINAL				YAZAKI CRIMP SPECIFICATION			
TERMINAL NAME: L TYPE CONNECTOR							
WIRE STRIP LENGTH				INSULATION DIAMETER RANGE			
7.50-8.50 mm [1.295-.335 IN]				 $\varnothing 3.80-4.90$ mm [1.50-.193 IN]			
TERMINAL APPLICATION				TERMINAL APPLICATION			
 (A)72-WT08-076 Rev WA1743 -				(B)72-WT10-068 Rev WA1449 -			
TERMINALS APPLIED							
TE TERMINAL		YAZAKI TERMINAL		TE TERMINAL		YAZAKI TERMINAL	
1949968-1(A)		7114-3251(A)		286609-1(B)		7116-3251(B)	

WIRE SIZE			CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING 
4.00mm ²			2.65+/-0.05 [.104+/- .002]		3.5
3.00mm ²			2.30+/-0.05 [.091+/- .002]		7.8



 RECOMMENDED SPARE PARTS

2. REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.

3 APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242.

4 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.

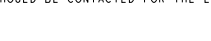
5 TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.

6. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.

*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.

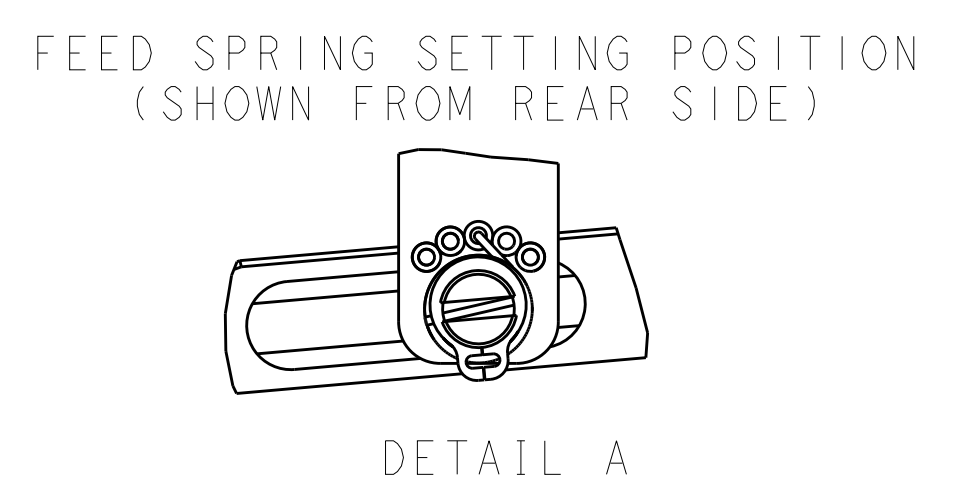
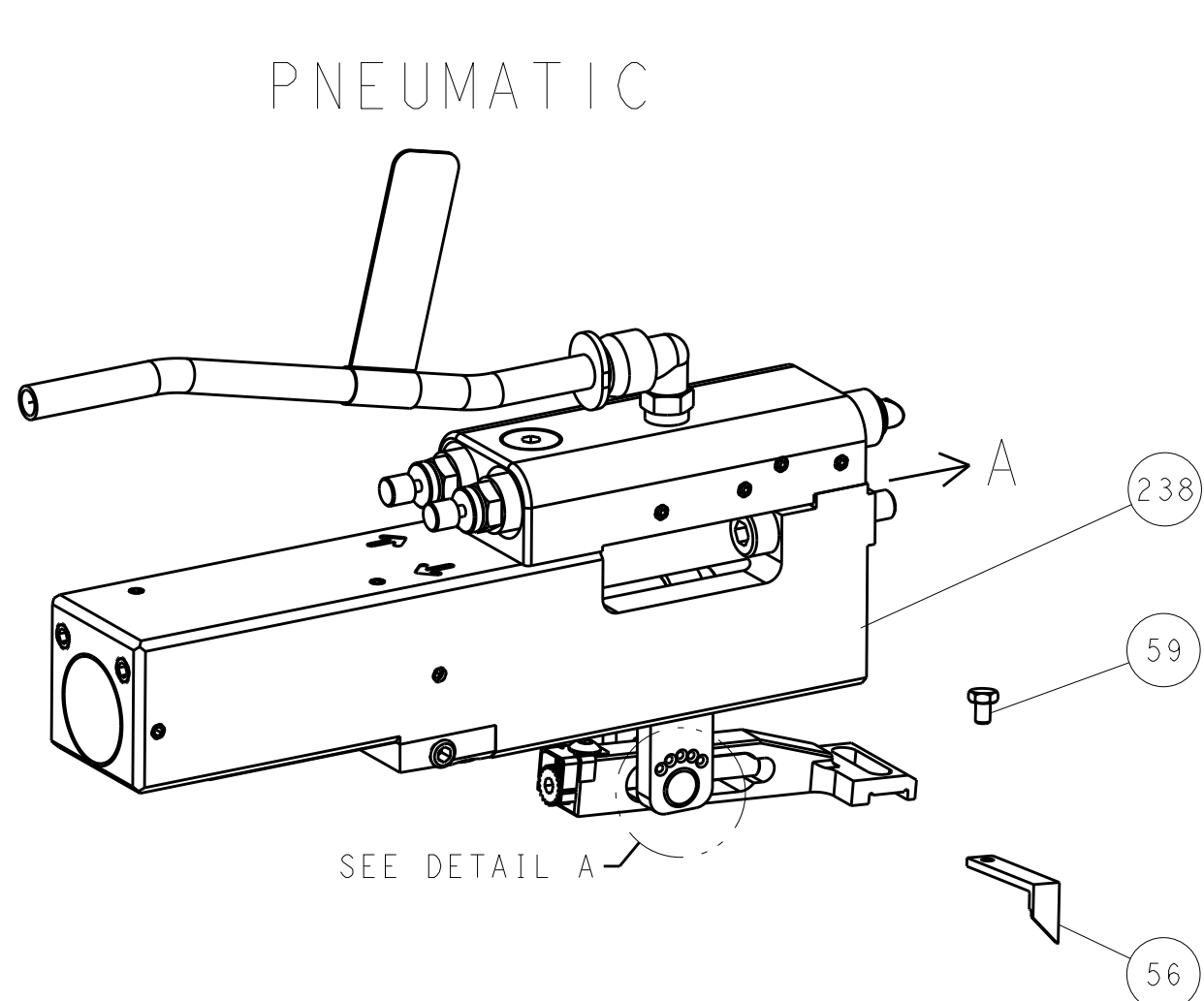
LOC	DIST	REVISIONS						
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			B	ECR-17-005190	11APR2017	TB	CT	
			C	ECR-18-015444	03OCT2018	MS	CT	
			D	ECR-19-009716	21JUN2019	FJ	TE	
			E	ECR-19-010700	09JUL2019	FZ	TE	

	-	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	269
	-	1	1	1633782-2	FENCE	267
	-	1	1	1803078-2	SPACER, PRECISION	259
	-	1	1	2119641-1	FEED CAM, AIR FEED	248
	-	1	1	2119082-7	CAM, SNAIL, INSULATION ADJUSTMENT	244
3	-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
	-	1	1	2119083-1	RETAINER, INSULATION DIAL	242
	-	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
	-	1	1	2844940-2	AIR FEED MODULE	238
	-	REF	REF	994970-2	COUNTER, MAGNETIC	164
	-	1	1	1-18028-2	WASHER, FLAT, REG M4	119
	-	1	1	2844908-1	SCREW, LOCKING	99
	-	1	1	2844907-1	POST, LOCKING	98
	-	1	1	1-690438-0	FRONT STRIP GUIDE	96
	-	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	95
	-	1	1	1-455888-3	SPACER, CRIMPER	82
	-	2	2	2079383-4	SCR, BHSC, RoHS (M4 X 8)	79
	-	1	1	1803096-1	EXTENSION PLATE	78
	-	1	1	1803607-3	DOCUMENTATION PACKAGE	71
	-	1	1	2119740-1	TAG, IDENTIFICATION	67
	-	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
	-	2	2	2-18032-5	SCR, SET, FLT PNT, M5 X 20.0	61
	-	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	1338683-8	FEED PAWL	56
	-	4	4	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	54
	-	2	2	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	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	1803583-9	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	2-1752356-0	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	2844992-3	ASSEMBLY, STRIP GUIDE	29
	-	1	1	1-455888-0	SPACER, CRIMPER	28
	-	2	2	22283-1	SPRING, COMPRESSION	27
	-	1	1	356835-1	LEVER, DRAG RELEASE	26
	-	1	1	240792-1	DRAG, TERMINAL	25
	-	1	1	1320928-6	STRIP GUIDE	24
	-	1	1	980371-4	SCR, SKT HD SHLDR 5.0 DIA X 6.0	23
	-	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
	-	1	1	1-18028-2	WASHER, FLAT, REG M4	20
1	-	1	1	2119533-1	STRIPPER, SIDE FEED	19
	-	1	1	2119806-1	INSERT, SHEAR	13
	-	1	1	3-22280-3	SPRING, COMPRESSION	12
	-	1	1	1-356885-3	STOP, SHEAR	11
	-	1	1	2119805-1	SHEAR HOLDER, FRONT	10
	-	1	1	318707-1	FLOATING SHEAR, FRONT	9
	1	2	1	1-1633930-1	ANVIL, COMBINATION	8
	-	1	1	240641-3	SPACER	7
	-	1	1	1-2119757-0	DEPRESSOR, SHEAR	5
	-	1	1	238011-3	BLOCK, CRIMPER SPACER	4
	1	2	1	6-2119582-3	CRIMPER, INSULATION F PREMIUM	3
	-	1	1	1-455888-2	SPACER, CRIMPER	2
	1	2	1	1-1633738-1	CRIMPER, WIRE	1
	-77	-72	-2	PART NO	DESCRIPTION	ITEM NO

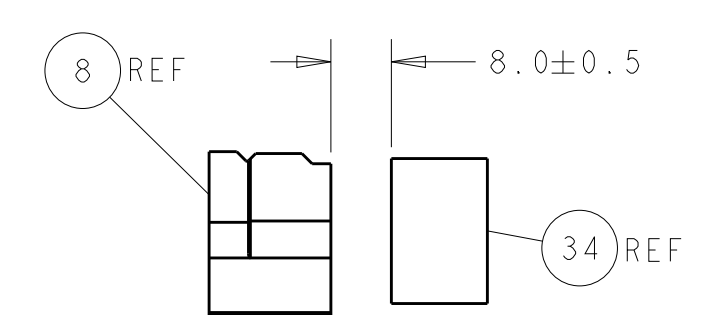
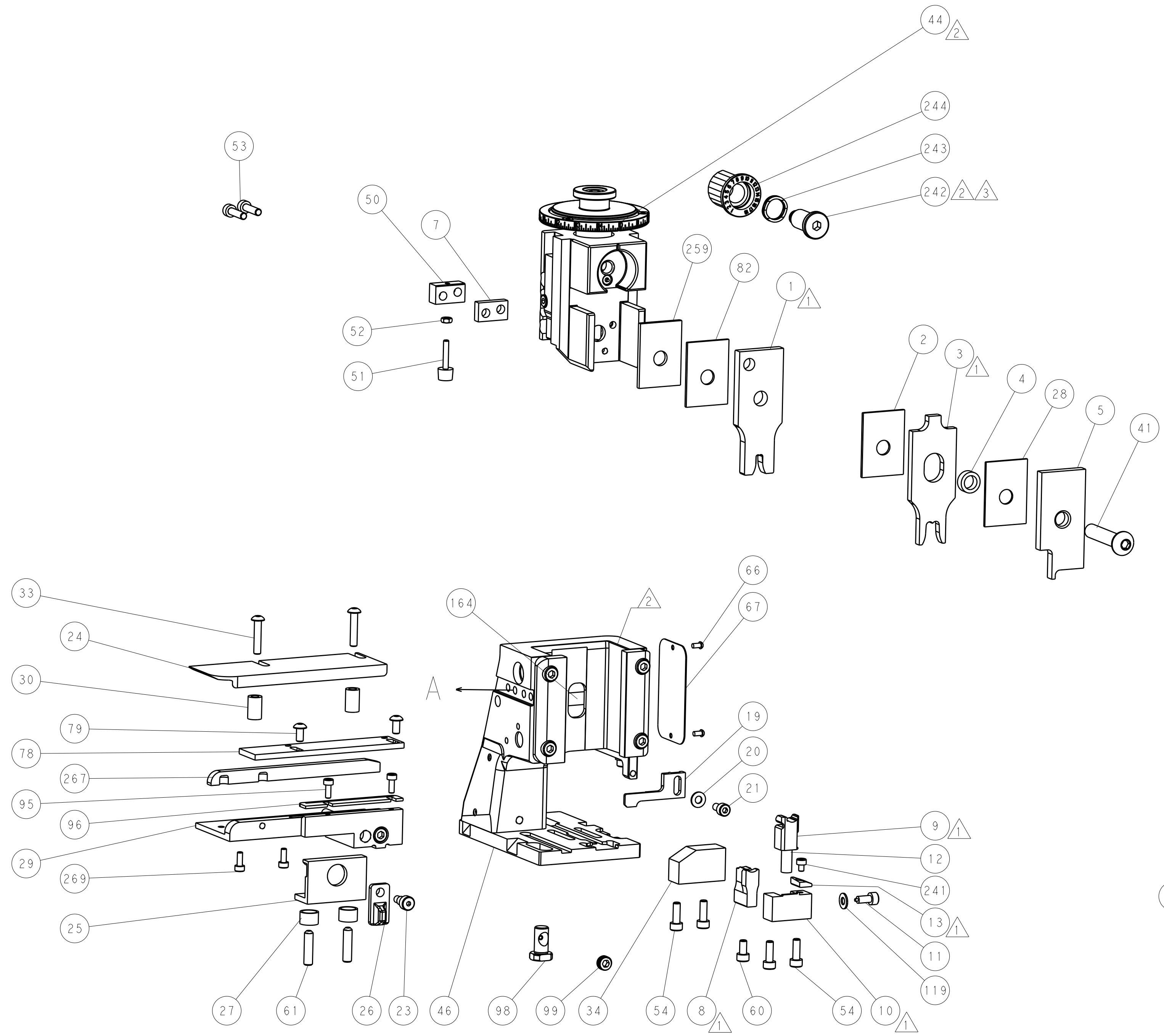
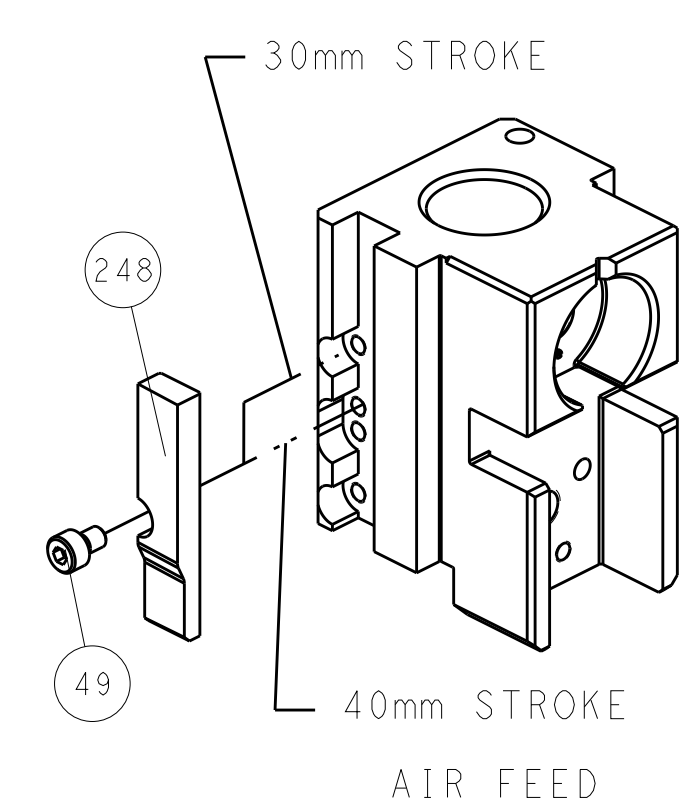
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TOLERANCES UNLESS OTHERWISE SPECIFIED:						CNC BAILEY 13NOV2012		Harrisburg PA 17105-3608	
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		APPROVED BY M CLIFFORD 13NOV2012		NAME Ocean Side Feed Applicator			
		0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± ANGLES ±		PRODUCT SPEC -					
				APPLICATION SPEC -		SIZE CAGE CODE DRAWING NO		RESTRICTED TO	
MATERIAL -		FINISH -		WEIGHT -		A 00779 C=2151759		-	
Customer Accessible Production Drawing						SCALE 1:2 SHEET 1 OF 4 REV E			

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

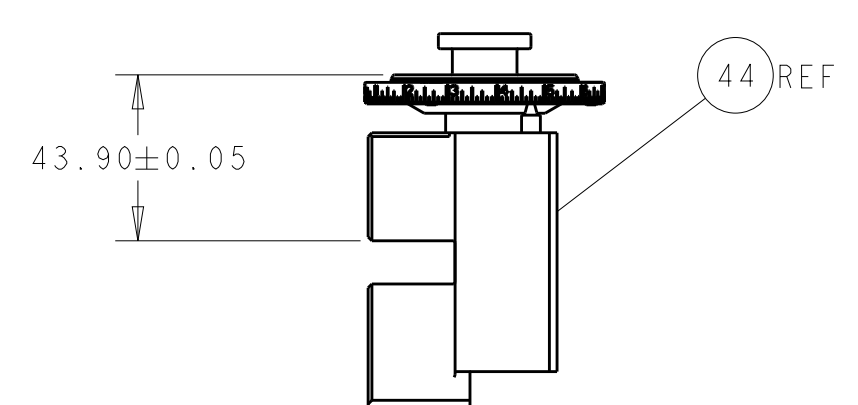
LOC	DIST	REVISIONS					
		P	LTR	DESCRIPTION	DATE	DWN	APVD
A	66	-	-	SEE SHEET 1	-	-	-



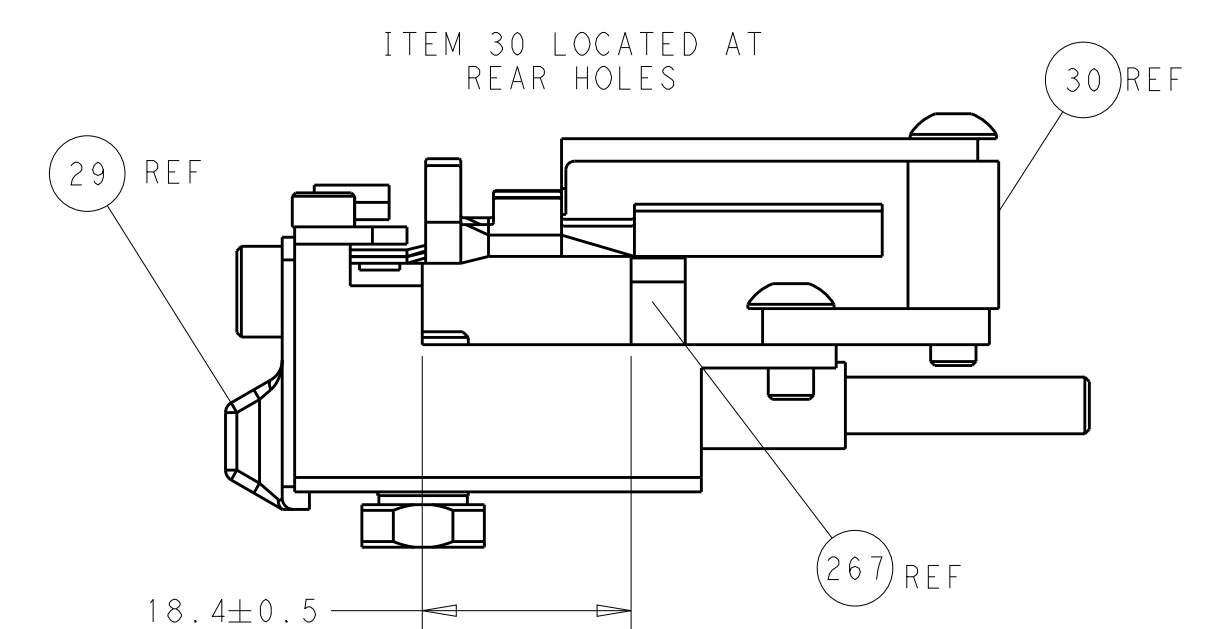
CAM POSITION



TERMINAL SUPPORT LOCATION



RAM SETUP



FEED TRACK POSITION
GUIDE BY WIRE BARREL

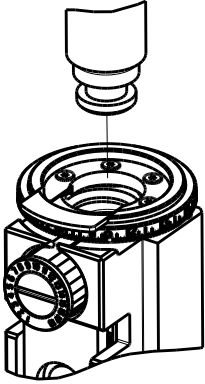
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. ANY CHANGES TO THIS DRAWING SHOULD BE CONTACTED FOR THE LATEST REVISION.				DWN: BOB HIGMAN 13NOV2012 CHK: G. BAILEY 13NOV2012 APVD: M. CLIFFORD 13NOV2012		 TE Connectivity Harrisburg, PA 17105-3608					
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		PRODUCT SPEC		NAME		Ocean Side Feed Applicator			
mm		0 PLC ±.1 1 PLC ±.1 2 PLC ±.1 3 PLC ±.1 4 PLC ±.1 ANGLES ±.1		APPLICATION SPEC		SIZE		CAGE CODE		DRAWING NO	
						A1		00779		C=2151759	
MATERIAL		FINISH		WEIGHT		Customer Accessible Production Drawing		SCALE		SHEET	
								1:2		2 OF 4	
										REV E	

SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

8		7	
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20		20	
(C) COPYRIGHT 20			
BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.			
PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2151759-2	E	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151759-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	4.00 mm [.157]	F
INSUL	8.50 mm [.335]	F
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: YAZAKI TERMINAL YAZAKI CRIMP SPECIFICATION			
TERMINAL NAME: L TYPE CONNECTOR			
WIRE STRIP LENGTH 7.50-8.50 mm [.295-.335 IN]		INSULATION DIAMETER RANGE Ø3.80-4.90 mm [.150-.193 IN]	
TERMINAL APPLICATION SPECIFICATION	(A)72-WT08-076 Rev WA1743	-	-
	(B)72-WT10-068 Rev WA1449	-	-
TERMINALS APPLIED			
TE TERMINAL	YAZAKI TERMINAL	TE TERMINAL	YAZAKI TERMINAL
1949968-1(A)	7114-3251(A)	286609-1(B)	7116-3251(B)

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
- 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.

*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)

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

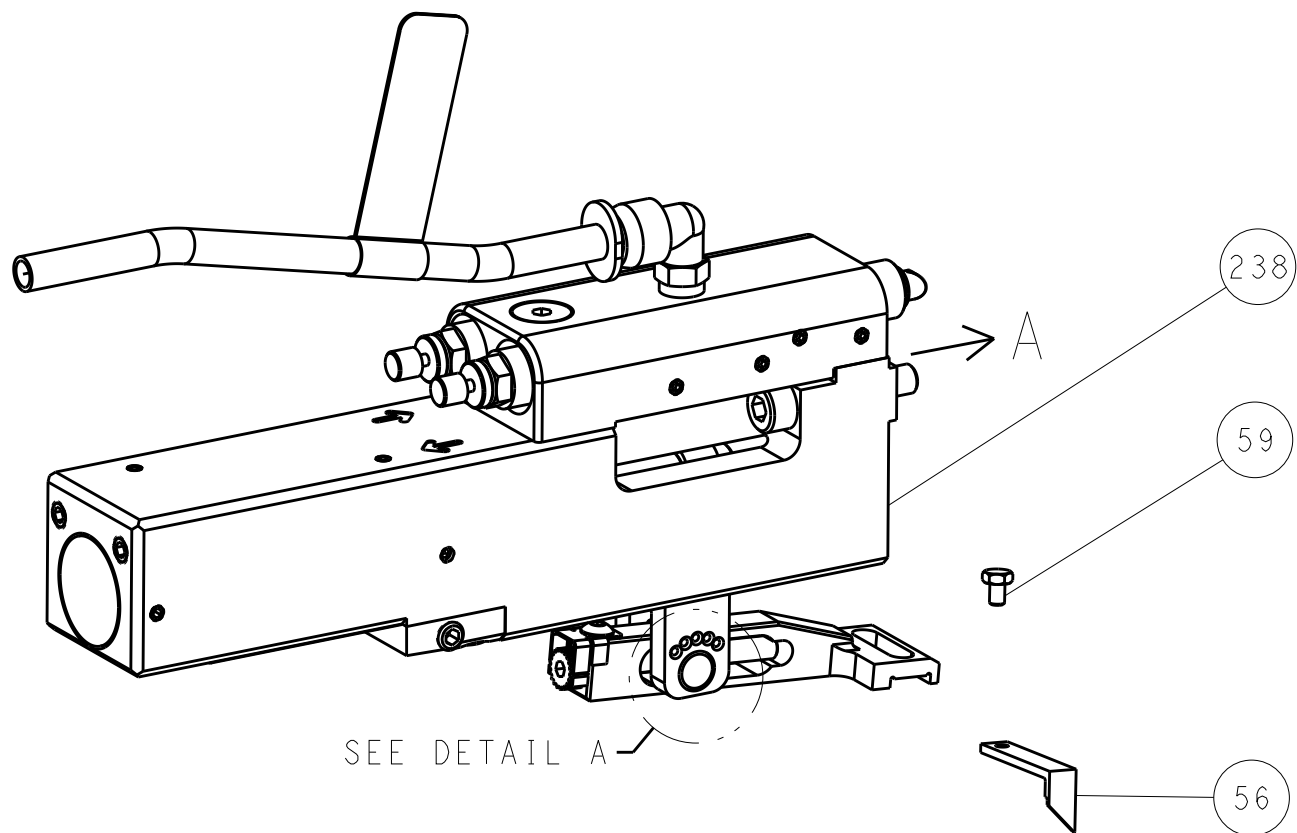
-	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	269
-	1	1633782-2	FENCE	267
-	1	1803078-2	SPACER, PRECISION	259
-	1	2119082-7	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
-	1	2844940-2	AIR FEED MODULE	238
-	REF	994970-2	COUNTER, MAGNETIC	164
-	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	1-1803583-0	APPLICATOR BASIC ASSEMBLY, SF	141
-	1	1803516-2	RAM ASSEMBLY, SF PACIFIC	140
-	1	1-18028-2	WASHER, FLAT, REG M4	119
-	1	2844908-1	SCREW, LOCKING	99
-	1	2844907-1	POST, LOCKING	98
-	1	1-690438-0	FRONT STRIP GUIDE	96
-	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	95
-	1	1-455888-3	SPACER, CRIMPER	82
-	2	2079383-4	SCR, BHSC, RoHS (M4 X 8)	79
-	1	1803096-1	EXTENSION PLATE	78
-	1	1803607-3	DOCUMENTATION PACKAGE	71
-	1	2119740-1	TAG, IDENTIFICATION	67
-	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	2	2-18032-5	SCR, SET, FLT PNT, M5 X 20.0	61
-	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	1	1338683-8	FEED PAWL	56
-	2	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	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	2-1752356-0	SUPPORT, TERMINAL	34
-	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2-2844962-1	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	2844992-3	ASSEMBLY, STRIP GUIDE	29
-	1	1-455888-0	SPACER, CRIMPER	28
-	2	22283-1	SPRING, COMPRESSION	27
-	1	356835-1	LEVER, DRAG RELEASE	26
-	1	240792-1	DRAG, TERMINAL	25
-	1	1320928-6	STRIP GUIDE	24
-	1	980371-4	SCR, SKT HD SHLDR 5.0 DIA X 6.0	23
-	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
-	1	1-18028-2	WASHER, FLAT, REG M4	20
-	1	2119533-1	STRIPPER, SIDE FEED	19
	1	2119806-1	INSERT, SHEAR	13
-	1	3-22280-3	SPRING, COMPRESSION	12
-	1	1-356885-3	STOP, SHEAR	11
	1	2119805-1	SHEAR HOLDER, FRONT	10
	1	318707-1	FLOATING SHEAR, FRONT	9
	1	1-1633930-1	ANVIL, COMBINATION	8
-	1	240641-3	SPACER	7
-	1	1-2119757-0	DEPRESSOR, SHEAR	5
-	1	238011-3	BLOCK, CRIMPER SPACER	4
	1	1-62119582-3	CRIMPER, INSULATION F PREMIUM	3
-	1	1-455888-2	SPACER, CRIMPER	2
	1	1-1633738-1	CRIMPER, WIRE	1
-	77	-22	PART NO	ITEM NO

THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. THE USER SHALL BE RESPONSIBLE FOR VERIFYING THE LATEST REVISION. SHOULD BE CONTACTED FOR THE LATEST REVISION.		DWN BOB HIGMAN CHK G.BAILEY APVD M.C. LEEFORD	13NOV2012 13NOV2012 13NOV2012	STE TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.01 1 PLC ±.01 2 PLC ±.01 3 PLC ±.01 4 PLC ±.01 ANGLES ±.01 FINISH		NAME Ocean Side Feed Applicator	
MATERIAL -		WEIGHT -		SIZE A1	
		Customer Accessible Production Drawing		SCALE 1:2	
		SHEET 3		REV E	

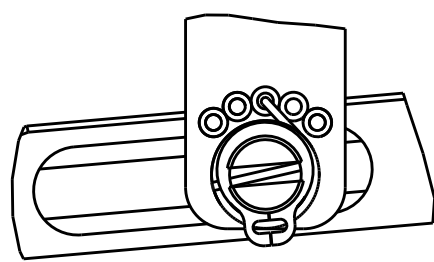
SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

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

PNEUMATIC

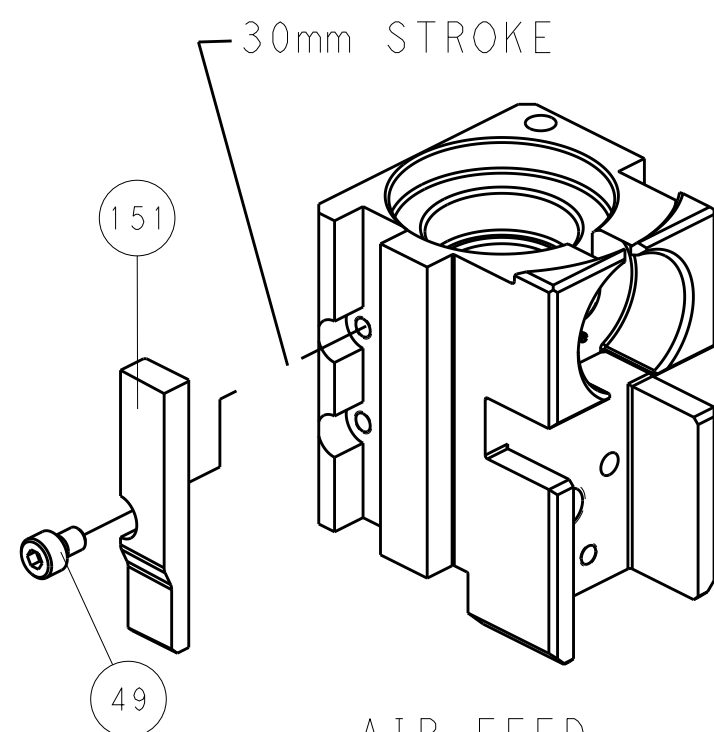


FEED SPRING SETTING POSITION
(SHOWN FROM REAR SIDE)

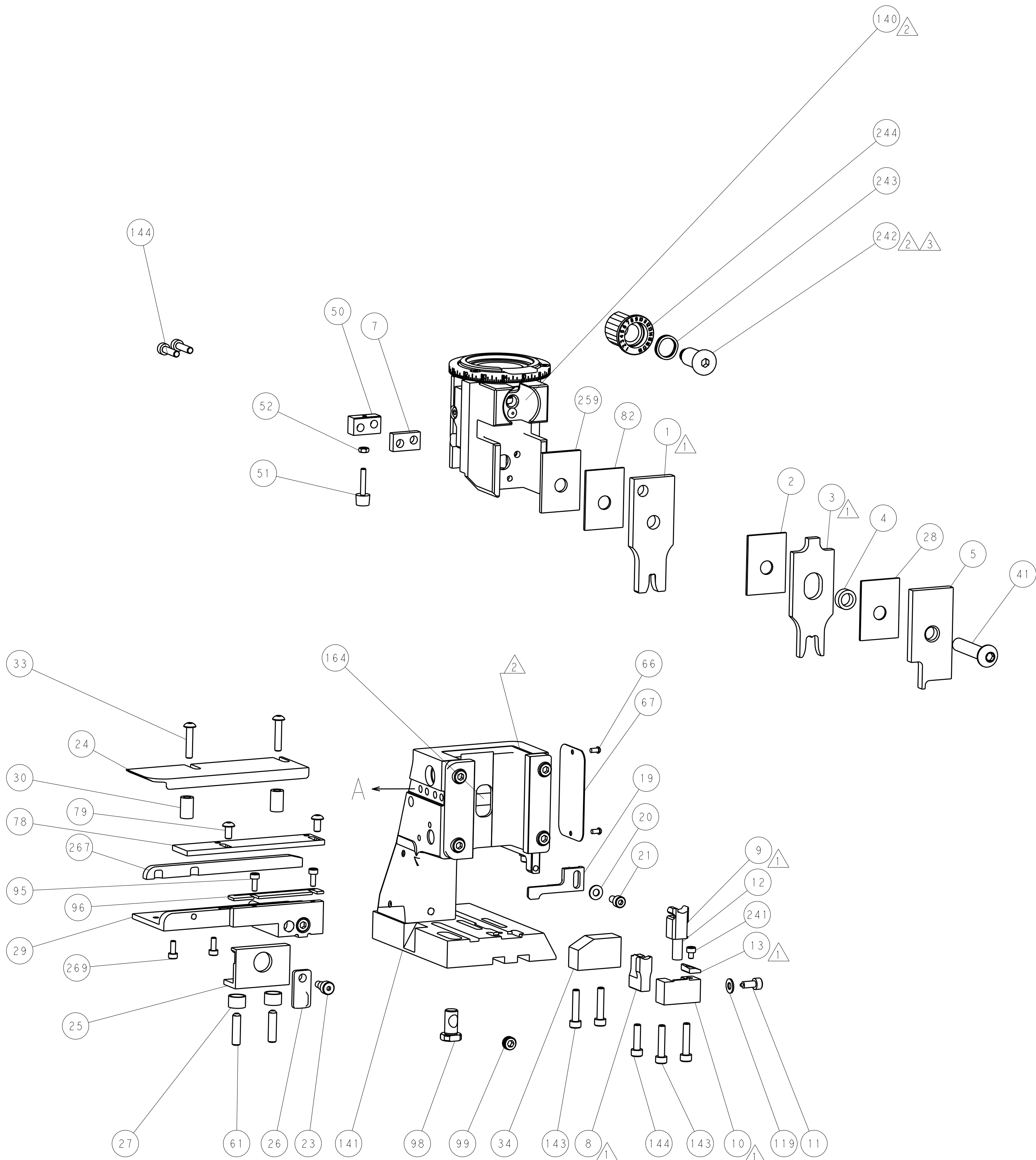


DETAIL A

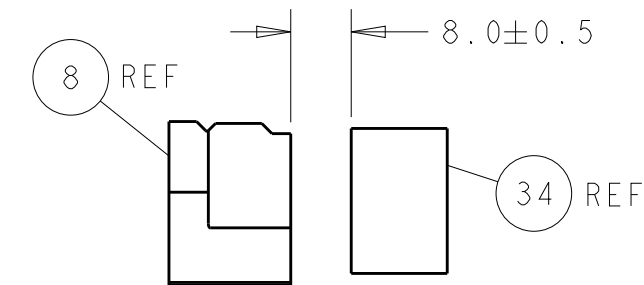
CAM POSITION



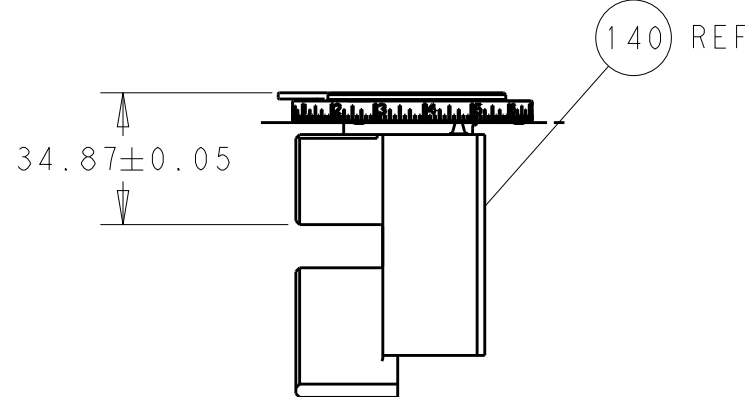
AIR FEED



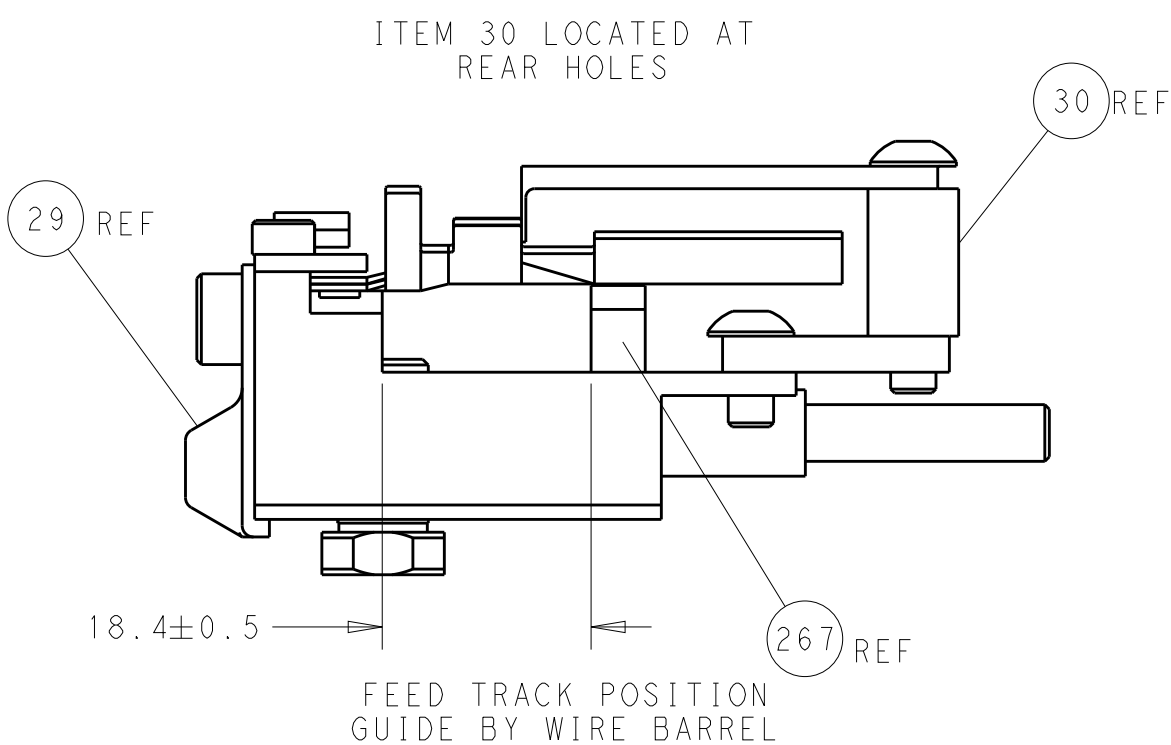
PACIFIC VERSION
Shown on sheets 3 of 4 & 4 of 4
(Atlantic version shown on sheets 1 of 4 & 2 of 4)



TERMINAL SUPPORT LOCATION



RAM SETUP



FEED TRACK POSITION
GUIDE BY WIRE BARREL

THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. ANY CHANGES TO THIS DRAWING SHOULD BE CONTACTED FOR THE LATEST VERSION.										DWN BOB HIGMAN 13NOV2012		 TE Connectivity Harrisburg, PA 17105-3608			
										CHK G. BAILEY 13NOV2012					
										APVD M. CLIFFORD 13NOV2012					
DIMENSIONS:										TOLERANCES UNLESS OTHERWISE SPECIFIED:		NAME		Ocean Side Feed Applicator	
mm												PRODUCT SPEC			