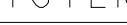


8		7	
THIS DRAWING IS UNPUBLISHED.		RELEASED FOR PUBLICATION	
20		20	
© COPYRIGHT 20 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.			
PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151965-1	E	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2151965-2	F	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
5-2151965-1	E	SEAL STRIPPER CRIMPER TERMINATING UNIT	MECHANICAL
5-2151965-2	F	SEAL STRIPPER CRIMPER TERMINATING UNIT	PNEUMATIC
7-2151965-1	E	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2151965-2	F	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2151965-7	D	CRIMP TOOLING KIT	-

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.68 mm [.066]	F
INSUL	3.40 mm [.134]	O
APPLICATOR INSTRUCTIONS 408-35042		

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]			Ø
TERMINAL APPLICATION SPECIFICATION		(A)72-WT08-767 Rev WA1927	
		-	
TERMINALS APPLIED		△	

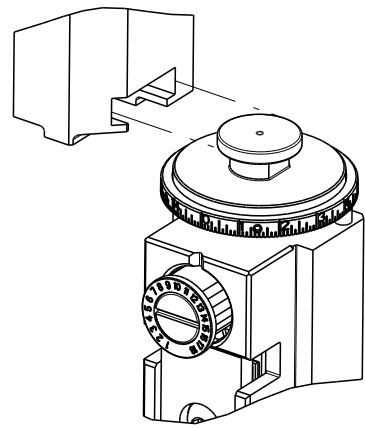
TE TERMINAL	YAZAKI TERMINAL	TE SEAL	YAZAKI SEAL	SEAL INSULATION DIAMETER RANGE
(A) 1655086-1	(A) 7114-4102-02	1572025-1	7158-3030-50	1.2-1.7
(A) 1655086-2	(A) 7114-4102-08	1572025-2	7158-3030-90	1.2-1.7
(A) 1642494-1	(A) 7114-4102-02	1832579-1	7158-3031-90	1.63-2.40
(A) 1557065-1	(A) FORD-97BG-14421-AHA	1642495-1	7158-3031-90	1.63-2.40
(A) 2434978-1	(A) 7114-4102-06	TE SEAL	FORD SEAL	
		1949248-1	97BG-10C930-SBA	1.19-1.65
		1448692-1	XW43-14603-AA	1.6-2.0

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.50mm2	1.05+/-0.05 [.041+/- .002]	7.7
0.30mm2 OR 0.35mm2	1.00+/-0.05 [.039+/- .002]	8.2



- 1 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. APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 180.
- 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 LUBRICANT IS RECOMMENDED.
6. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- 7 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.

ATLANTIC VERSION TERMINATOR
INTERFACE ADAPTER



TERMINAL DATA: YAZAKI TERMINAL		YAZAKI CRIMP SPECIFICATION	
TERMINAL NAME: 1.5 SYSTEM SEALED CONNECTOR, FEMALE			
WIRE STRIP LENGTH 5.00-5.50 mm [.197-.217 IN]		INSULATION DIAMETER RANGE Ø	
TERMINAL APPLICATION SPECIFICATION		(B)72-WT10-1635 Rev WA1986	
TERMINALS APPLIED		△5	

TE TERMINAL	YAZAKI TERMINAL	TE SEAL	YAZAKI SEAL	SEAL INSULATION DIAMETER RANGE
(B) 1832234-1	(B) 7116-4102-02	1572025-1	7158-3030-50	1.2-1.7
(B) 1448691-1	(B) 7116-4102-08	1572025-2	7158-3030-90	1.2-1.7
(B) 1572024-3	(B) 7116-4102-06	1832579-1	7158-3031-90	1.63-2.40
		1642495-1	7158-3031-90	1.63-2.40
		TE SEAL	FORD SEAL	
		1949248-1	97BG-10C930-SBA	1.19-1.65
		1448692-1	XW43-14603-AA	1.6-2.0

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.50mm2	1.00+/-0.05 [.039+/- .002]	8.8
0.35mm2	0.95+/-0.05 [.037+/- .002]	9.3
0.30mm2	0.90+/-0.04 [.035+/- .002]	9.9

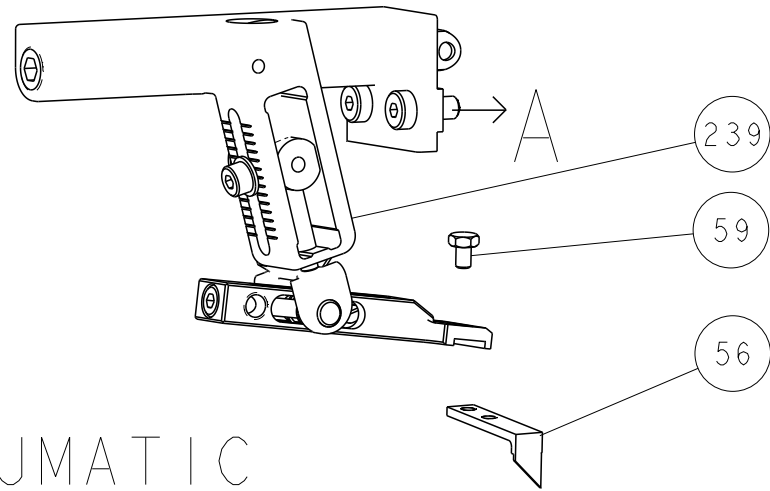
*WARNING
ON INSTALLATION, SET WIRE DISC TO CRIMP HEIGHT REFERENCE SETTINGS FOR LARGEST WIRE SIZE. CRIMP HEIGHT REFERENCE SETTINGS GREATER THAN THE VALUE SHOWN MAY CAUSE DAMAGE TO THE CRIMP TOOLING. REFER TO THE INSTRUCTION SHEET FOR PROPER SETUP AND ADJUSTMENTS.

LOC	DIST	REVISIONS			
A	66	P	LTR	DESCRIPTION	DATE
		F		ECR-19-011449	21JUL2019
		F1		ECR-20-016066	11NOV2020
		F2		ECR-22-155910	18OCT2022
		F3		ECR-26-285227	17JUL2026
					TB
					LG
					TE
					JA
					AP
					AO

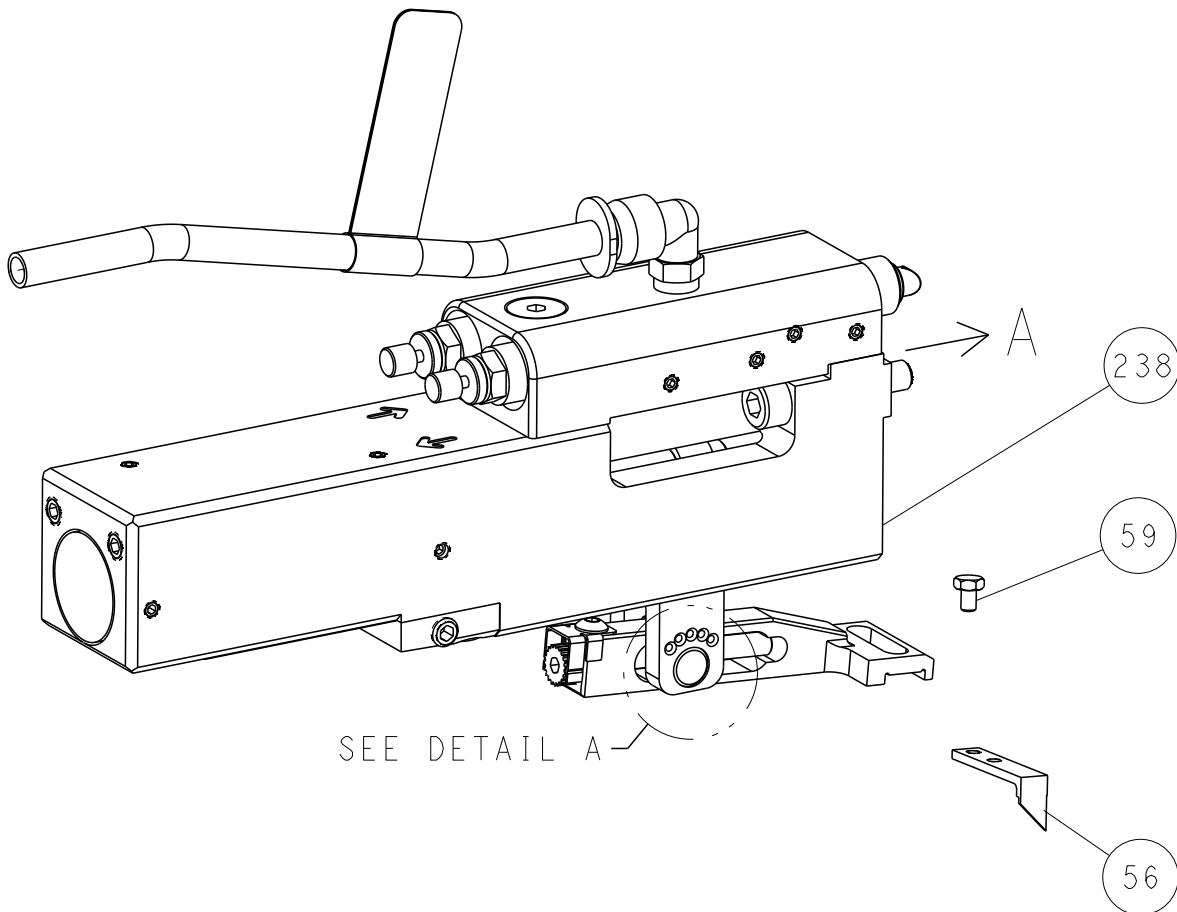
		OBSOLETE		OBSOLETE		SUPERSEDED BY 4170378-1		SUPERSEDED BY 4170378-1		SUPERSEDED BY 4170378-1		SUPERSEDED BY 4170378-1					
3	-	-	-	-	-	-	-	-	-	-	-	-	-	-	1803515-3	RAM ASSEMBLY, SF ATLANTIC	293
	-	-	-	-	-	-	-	-	-	-	-	-	-	-	2-1803583-1	APPLICATOR BASIC ASSEMBLY, SF	292
	-	-	-	-	-	-	-	-	-	-	-	-	-	-	2119641-1	FEED CAM, AIR FEED	248
	-	-	-	-	-	-	-	-	-	-	-	-	-	-	2119082-2	CAM, SNAIL, INSULATION ADJUSTMENT	244
	-	-	-	-	-	-	-	-	-	-	-	-	-	-	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
3	-	-	-	-	-	-	-	-	-	-	-	-	-	-	2119083-1	RETAINER, INSULATION DIAL	242
	-	-	-	-	-	-	-	-	-	-	-	-	-	-	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
	-	-	-	-	-	-	-	-	-	-	-	-	-	-	2119580-1	MECHANICAL FEED ASSEMBLY	239
	-	-	-	-	-	-	-	-	-	-	-	-	-	-	2844940-1	AIR FEED MODULE	238
	-	-	-	-	-	-	-	-	-	-	-	-	-	-	4-1722335-3	STRIPPER, SIDE FEED	182
3	-	-	-	-	-	-	-	-	-	-	-	-	-	-	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	181
	-	-	-	-	-	-	-	-	-	-	-	-	-	-	2-1752354-2	STANDOFF,HOLD-DOWN	180
	-	-	-	-	-	-	-	-	-	-	-	-	-	-	9931111-1	PIN, SLOTTED SPRING 3.0 X 20.0	177
	-	-	-	-	-	-	-	-	-	-	-	-	-	-	5-22280-0	SPRING, COMPRESSION	176
	-	-	-	-	-	-	-	-	-	-	-	-	-	-	1752353-3	GUIDE PIN,HOLDDOWN	175
3	-	-	-	-	-	-	-	-	-	-	-	-	-	-	1901680-2	GUIDE PIN,HOLDDOWN	174
	-	REF	REF	REF	REF	REF	REF	REF	REF	REF	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
	-	-	-	-	-	-	-	-	-	-	-	-	-	-	1-22281-8	SPRING, COMPRESSION	121
	-	-	-	-	-	-	-	-	-	-	-	-	-	-	1-18028-2	WASHER, FLAT, REG M4	119
	-	-	-	-	-	-	-	-	-	-	-	-	-	-	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113
3	-	-	-	-	-	-	-	-	-	-	-	-	-	-	2844908-1	SCREW, LOCKING	99
	-	-	-	-	-	-	-	-	-	-	-	-	-	-	2844907-1	POST, LOCKING	98
	-	-	-	-	-	-	-	-	-	-	-	-	-	-	1-690438-6	FRONT STRIP GUIDE	96
	-	2	2	2	2	2	2	2	2	2	2	2	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	95
	-	-	-	-	-	-	-	-	-	-	-	-	-	-	2168083-6	SCR, SKT HD CAP, RoHS, M5 X 65	93
7	-	-	-	-	-	-	-	-	-	-	-	-	-	-	455888-4	SPACER, CRIMPER -	82
	-	-	-	-	-	-	-	-	-	-	-	-	-	-	1803607-3	DOCUMENTATION PACKAGE	71
	-	-	-	-	-	-	-	-	-	-	-	-	-	-	2119740-1	TAG,IDENTIFICATION	67
	-	2	2	2	2	2	2	2	2	2	2	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
	-	2	2	2	2	2	2	2	2	2	2	2	2	2	2-18032-5	SCR, SET, FLT PNT, M5 X 20.0	61
7	-	-	-	-	-	-	-	-	-	-	-	-	-	-	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	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
	-	4	4	4	4	4	4	4	4	4	4	4	4	4	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	54
7	-	2	2	2	2	2	2	2	2	2	2	2	2	2	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	53
	-	-	-	-	-	-	-	-	-	-	-	-	-	-	1803382-2	HOLD DOWN, SPRING LOADED	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
7	-	-	-	-	-	-	-	-	-	-	-	-	-	-	1803583-9	APPLICATOR BASIC ASSEMBLY, SF	46
	-	-	-	-	-	-	-	-	-	-	-	-	-	-	1803515-1	RAM ASSEMBLY, SF ATLANTIC	44
	-	-	-	-	-	-	-	-	-	-	-	-	-	-	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
	-	-	-	-	-	-	-	-	-	-	-	-	-	-	1752356-3	SUPPORT, TERMINAL	34
	-	2	2	2	2	2	2	2	2	2	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
7	-	2	2	2	2	2	2	2	2	2	2	2	2	2	3-2844962-0	SPACER, CYLINDRICAL, STRIP GUIDE	30
	-	-	-	-	-	-	-	-	-	-	-	-	-	-	2844938-5	PLATE, STRIP GUIDE -	29
	-	-	-	-	-	-	-	-	-	-	-	-	-	-	455888-3	SPACER, CRIMPER -	28
	-	2	2	2	2	2	2	2	2	2	2	2	2	2	22281-8	SPRING, COMPRESSION	27
	-	-	-	-	-	-	-	-	-	-	-	-	-	-	356835-1	LEVER, DRAG RELEASE	26
7	-	-	-	-	-	-	-	-	-	-	-	-	-	-	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
	-	2	2	-	-	-	-	2	2	-	-	-	-	-	1-18028-2	WASHER, FLAT, REG M4	20
7	-	-	-	-	-	-	-	-	-	-	-	-	-	-	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
7	-	-	-	-	-	-	-	-	-	-	-	-	-	-	318707-1	FLOATING SHEAR, FRONT	9
	-	1	2	2	-	-	-	-	-	-	-	-	-	-	4-1633927-8	ANVIL, COMBINATION	8
	-	-	-	-	-	-	-	-	-	-	-	-	-	-	1-240641-1	SPACER	7
	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	6
	-	-	-	-	-	-	-	-	-	-	-	-	-	-	2119781-1	DEPRESSOR, SHEAR	5
7	-	-	-	-	-	-	-	-	-	-	-	-	-	-	5-238011-5	BLOCK, CRIMPER SPACER -	4
	-	1	2	2	-	-	-	-	-	-	-	-	-	-	1803018-3	CRIMPER, INSULATION O	3
	-	-	-	-	-	-	-	-	-	-	-	-	-	-	1-455888-1	SPACER, CRIMPER -	2
	-	1	2	2	-	-	-	-	-	-	-	-	-	-	1490019-2	CRIMPER, WIRE PREMIUM	1
	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-

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

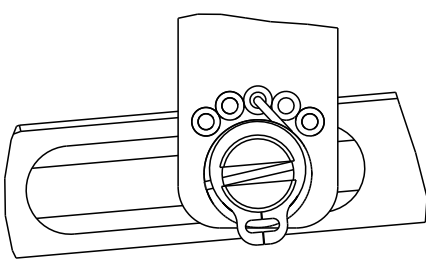
FEED TYPE MECHANICAL



PNEUMATIC

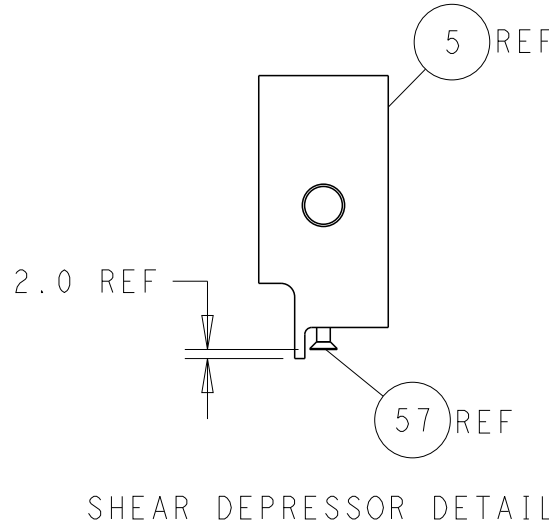
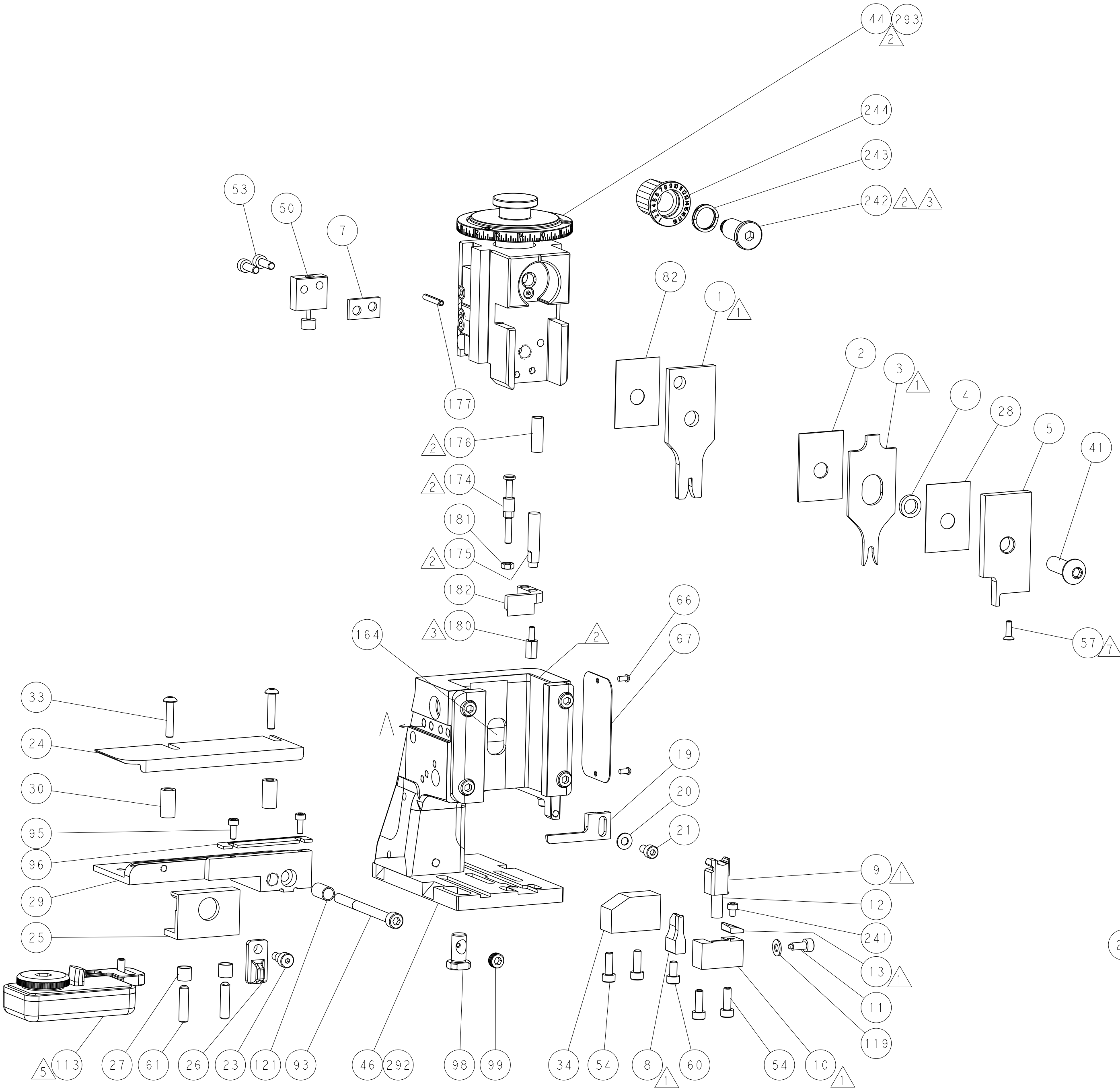
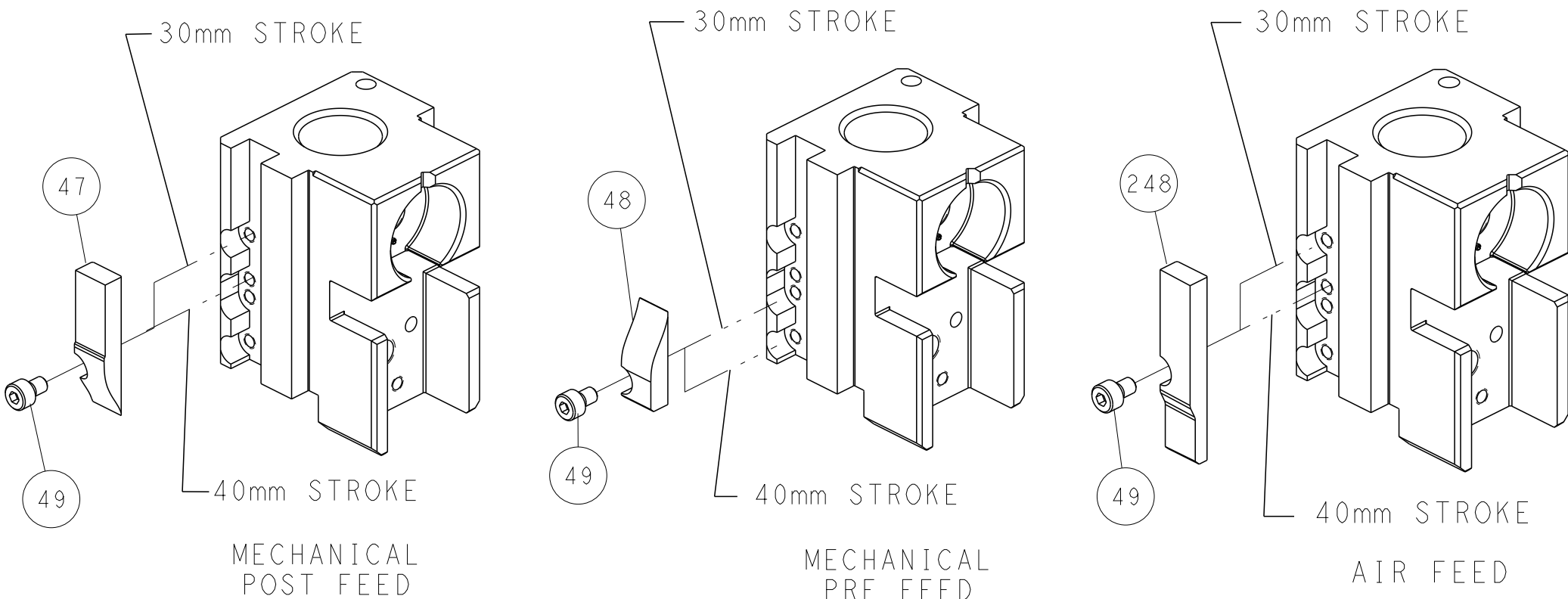


FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)

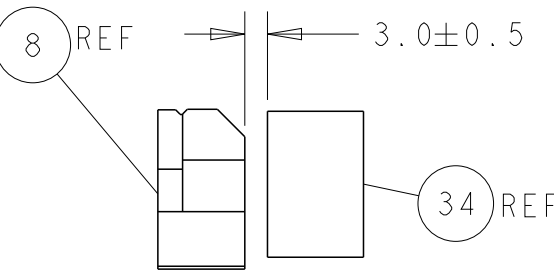


DETAIL A

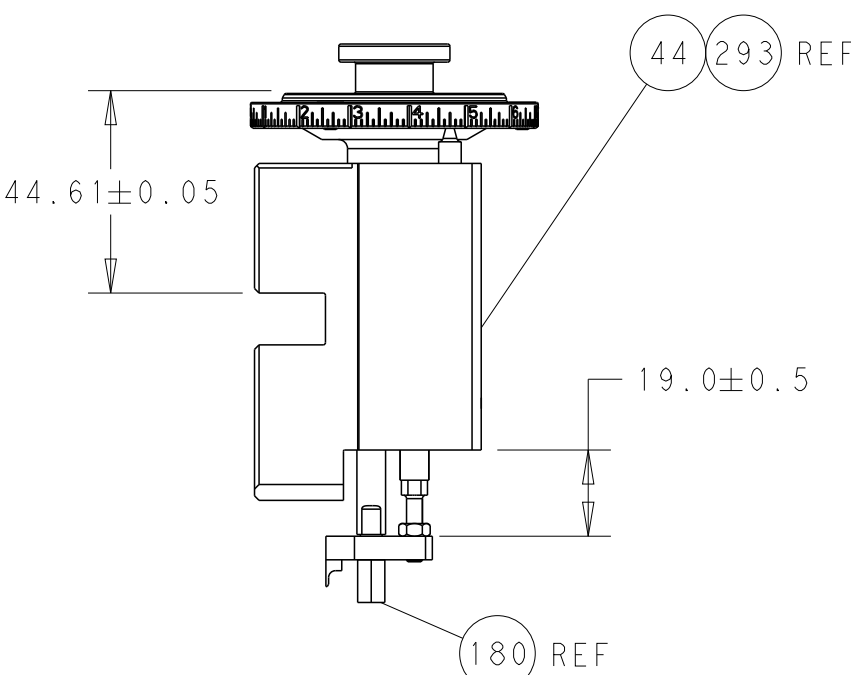
CAM POSITIONS



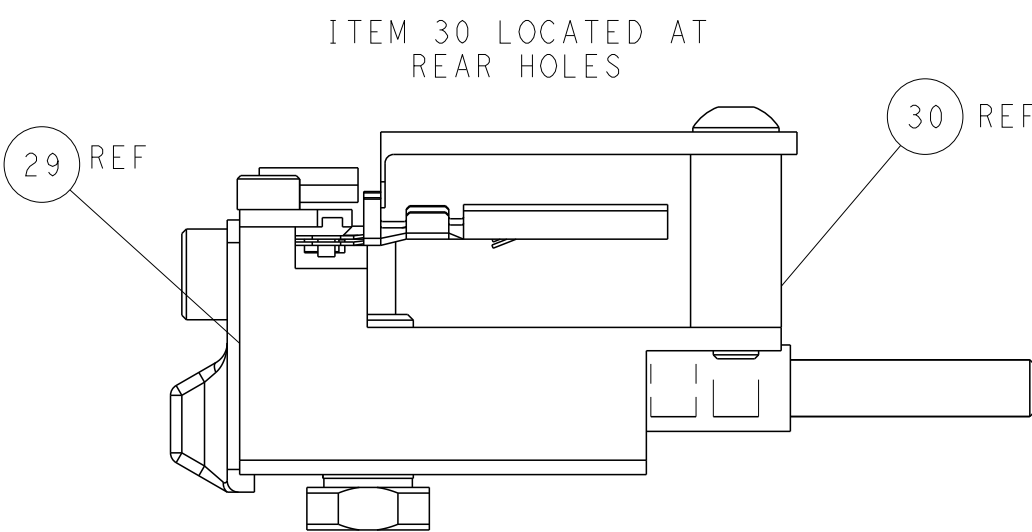
SHEAR DEPRESSOR DETAIL



TERMINAL SUPPORT LOCATION



RAM AND HOLDDOWN SET-UP



FEED TRACK POSITION
GUIDE BY INSULATION BARREL

THIS DRAWING IS UNPUBLISHED. IT IS THE PROPERTY OF TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. NO PART OF THIS DRAWING SHOULD BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, INCLUDING PHOTOCOPYING, RECORDING, OR BY ANY INFORMATION STORAGE AND RETRIEVAL SYSTEM, WITHOUT PERMISSION IN WRITING FROM TYCO ELECTRONICS CORPORATION.				DWN R.O. WILSON 22MAY2013	TE Connectivity Harrisburg, PA 17105-3608	
CHK K.J. STAKEM 22MAY2013				APVD T.L. ELBIN 22MAY2013	NAME Ocean Side Feed Applicator	
DIMENSIONS: mm				TOLERANCES UNLESS OTHERWISE SPECIFIED:		SIZE A1
0 PLC 1 PLC 2 PLC 3 PLC 4 PLC				± ± ± ± ±		CAGE CODE 00779
MATERIAL -				FINISH -		DRAWING NO. C=2151965
				WEIGHT -		RESTRICTED TO -
				Customer Accessible Production Drawing		SCALE 1:2
						SHEET 2 OF 4
						REV F3