

8		7	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151680-1	E	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2151680-2	E	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151680-1	E	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2151680-2	E	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2151680-7	C	CRIMP TOOLING KIT	-

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.55 mm [.061]	F
INSUL	1.50 mm [.059]	O
APPLICATOR INSTRUCTIONS 408-35042		

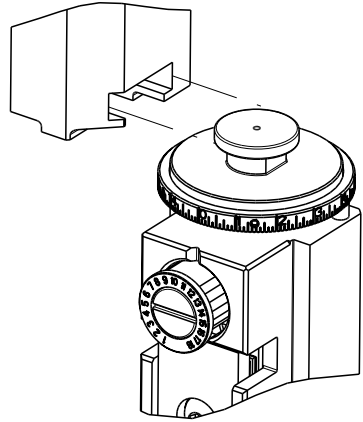
TERMINAL DATA: YAZAKI TERMINAL		YAZAKI CRIMP SPECIFICATION	
TERMINAL NAME: KAIZEN 0.64 TERMINAL, FEMALE			
WIRE STRIP LENGTH 4.00-4.50 mm [.157-.177 IN]			INSULATION DIAMETER RANGE Ø1.50-1.60 mm [.059-.063 IN]
TERMINAL APPLICATION SPECIFICATION		YAZAKI 7116-4619-02 Rev WA1866	
		-	-
TERMINALS APPLIED 			
TE TERMINAL	YAZAKI TERMINAL	TE TERMINAL	YAZAKI TERMINAL
2113274-1	7116-4619-02	2113274-2	7116-4619-08
2113274-3	7116-5232-08		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.75mm2	1.05+/-0.05 [.041+/- .002]	7.8



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

ATLANTIC VERSION TERMINATOR
INTERFACE ADAPTER



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
		B		ECR-14-012495			20AUG2014	JH	TE
		C		ECR-18-013725			30AUG2018	FZ	KZ
		D		ECR-20-001933			11FEB2020	FJ	TE
		E		ECR-21-003817			30MAR2021	JWC	GB

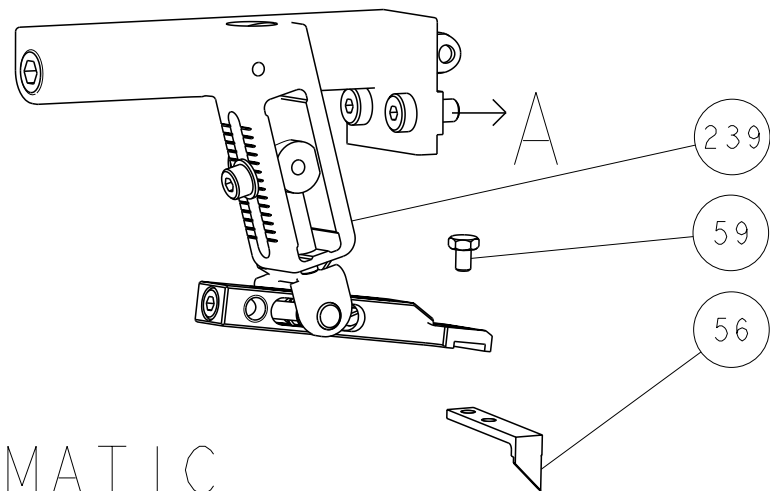
-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248
-	1	1	1	1	2119082-4	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
3	-	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	1	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
-	-	1	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	1	-	1	-	2844940-1	AIR FEED MODULE	238
-	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	1	1	1	1	1-18028-2	WASHER, FLAT, REG M4	119
6	-	1	1	1	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113
-	1	1	1	1	2844908-1	SCREW, LOCKING	99
-	1	1	1	1	2844907-1	POST, LOCKING	98
-	1	1	1	1	455888-4	SPACER, CRIMPER	82
-	1	1	1	1	1803607-3	DOCUMENTATION PACKAGE	71
-	1	1	1	1	2119740-1	TAG, IDENTIFICATION	67
-	2	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	1	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	60
-	1	1	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	1	1	1	1	1338685-1	PAWL, FEED	56
-	4	4	4	4	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	54
-	2	2	2	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	53
-	1	1	1	1	1803382-6	HOLD DOWN, SPRING LOADED	50
-	1	2	1	2	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	-	1	-	1	2119652-1	FEED CAM, PRE FEED	48
-	-	1	-	1	2119653-1	FEED CAM, POST FEED	47
-	1	1	1	1	1803583-9	APPLICATOR BASIC ASSEMBLY, SF	46
-	1	1	1	1	1803515-1	RAM ASSEMBLY, SF ATLANTIC	44
-	1	1	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
-	1	1	1	1	1752356-3	SUPPORT, TERMINAL	34
-	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	2	2	2-2844962-6	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	1	1	2844992-2	ASSEMBLY, STRIP GUIDE	29
-	1	1	1	1	455888-3	SPACER, CRIMPER	28
-	1	1	1	1	1320928-2	STRIP GUIDE	24
-	1	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
-	1	1	1	1	1-18028-2	WASHER, FLAT, REG M4	20
-	1	1	1	1	2119533-1	STRIPPER, SIDE FEED	19
1	-	1	1	1	2119806-1	INSERT, SHEAR	13
-	1	1	1	1	3-22280-3	SPRING, COMPRESSION	12
-	1	1	1	1	1-356885-4	STOP, SHEAR	11
1	-	1	1	1	2119805-1	SHEAR HOLDER, FRONT	10
1	-	1	1	1	1803095-6	FLOATING SHEAR, FRONT	9
1	1	2	2	1	1-1633932-1	ANVIL, COMBINATION	8
-	-	-	-	-	-	-	7
-	-	-	-	-	-	-	6
-	1	1	1	1	1-2119757-3	DEPRESSOR, SHEAR	5
-	1	1	1	1	3-238011-1	BLOCK, CRIMPER SPACER	4
1	1	2	2	1	9-1803019-2	CRIMPER, INSULATION O	3
-	1	1	1	1	455888-3	SPACER, CRIMPER	2
1	1	2	2	1	1-1633305-6	CRIMPER, WIRE PREMIUM	1
-	77-72	-71	-2	-1	PART NO	DESCRIPTION	ITEM NO

THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE AND TO BE CONTROLLED BY THE ENGINEERING DEPARTMENT. IT SHOULD BE CONTACTED FOR THE LATEST REVISION.				DWN BOB HIGHMAN 05JUN2012		TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS:				CHK T. ELBIN 05JUN2012		NAME Ocean Side Feed Applicator	
mm				APVD M. CLIFFORD 05JUN2012		PRODUCT SPEC - APPLICATION SPEC - SIZE A 00779 C=2151680 SCALE 1:2 SHEET 1 OF 4 REV E	
TOLERANCES UNLESS OTHERWISE SPECIFIED:				NAME			
0 PLC ±				- APPLICATION SPEC			
1 PLC ±				- SIZE			
2 PLC ±				CAGE CODE			
3 PLC ±				DRAWING NO			
4 PLC ±				RESTRICTED TO			
ANGLES ±				- Customer Accessible Production Drawing			
FINISH				- SCALE			
MATERIAL				- SHEET			
-				1 OF 4			
-				REV E			

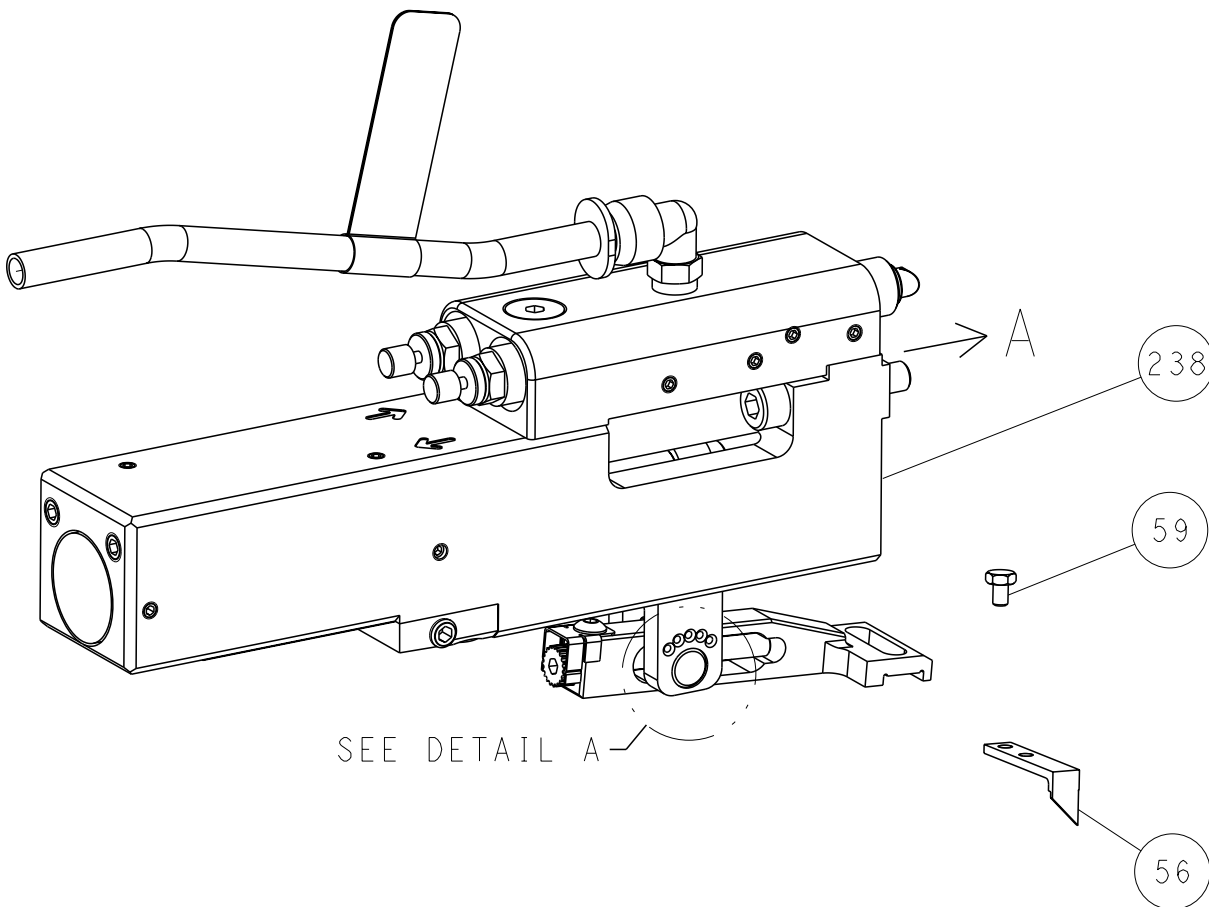
SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

LOC		DIST		REVISONS				
A	66	P	LYR	DESCRIPTION	DATE	DWN	APVD	
		-	-	SEE SHEET 1	-	-	-	

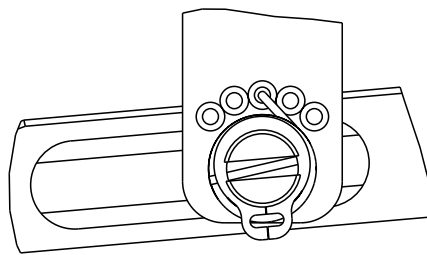
FEED TYPE MECHANICAL



PNEUMATIC

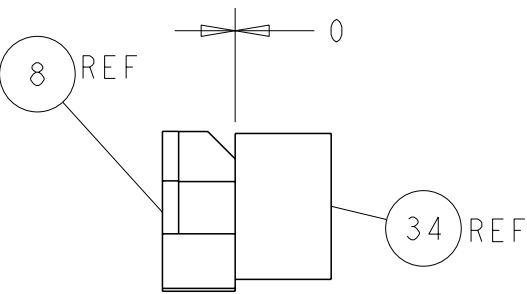
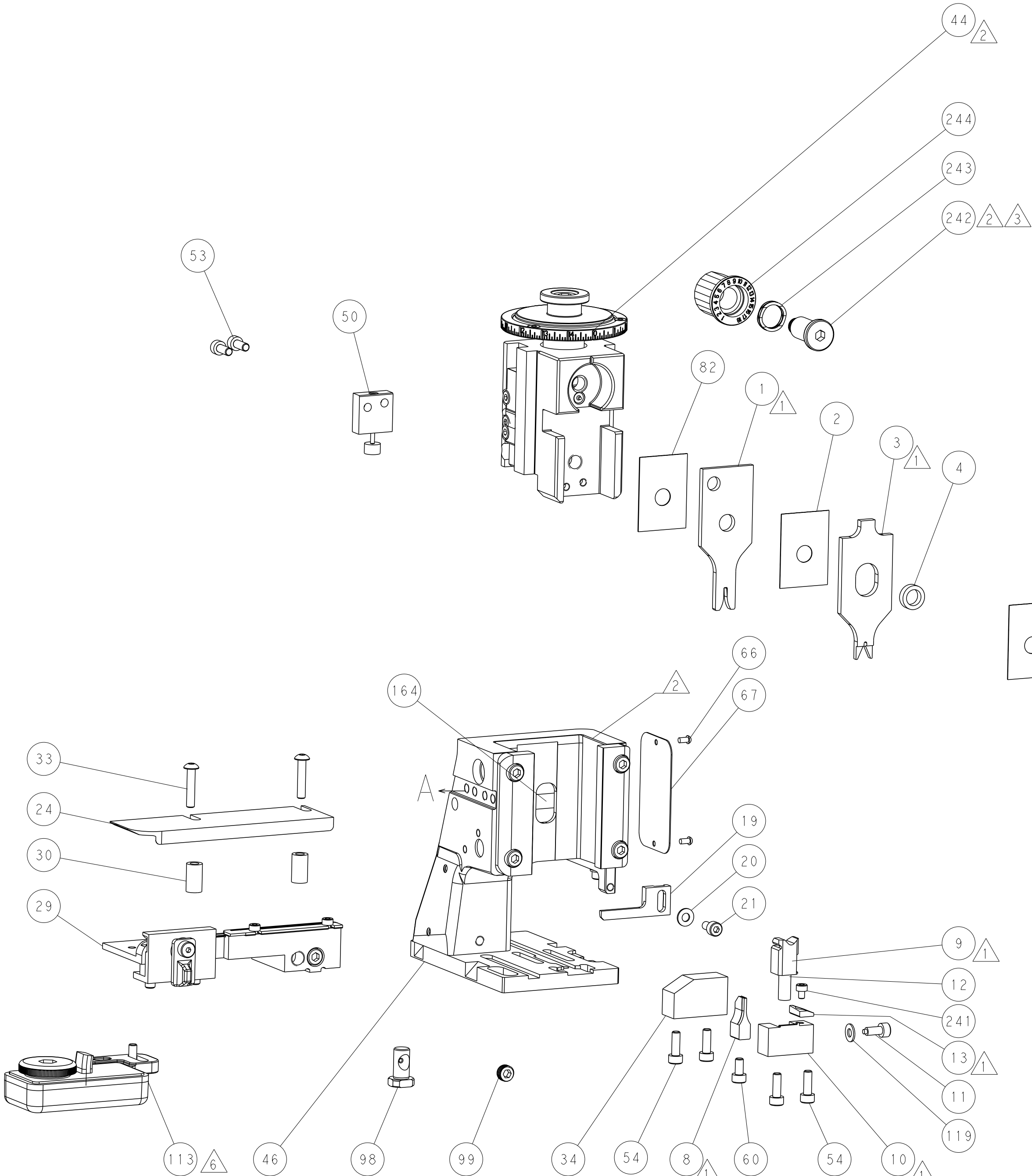
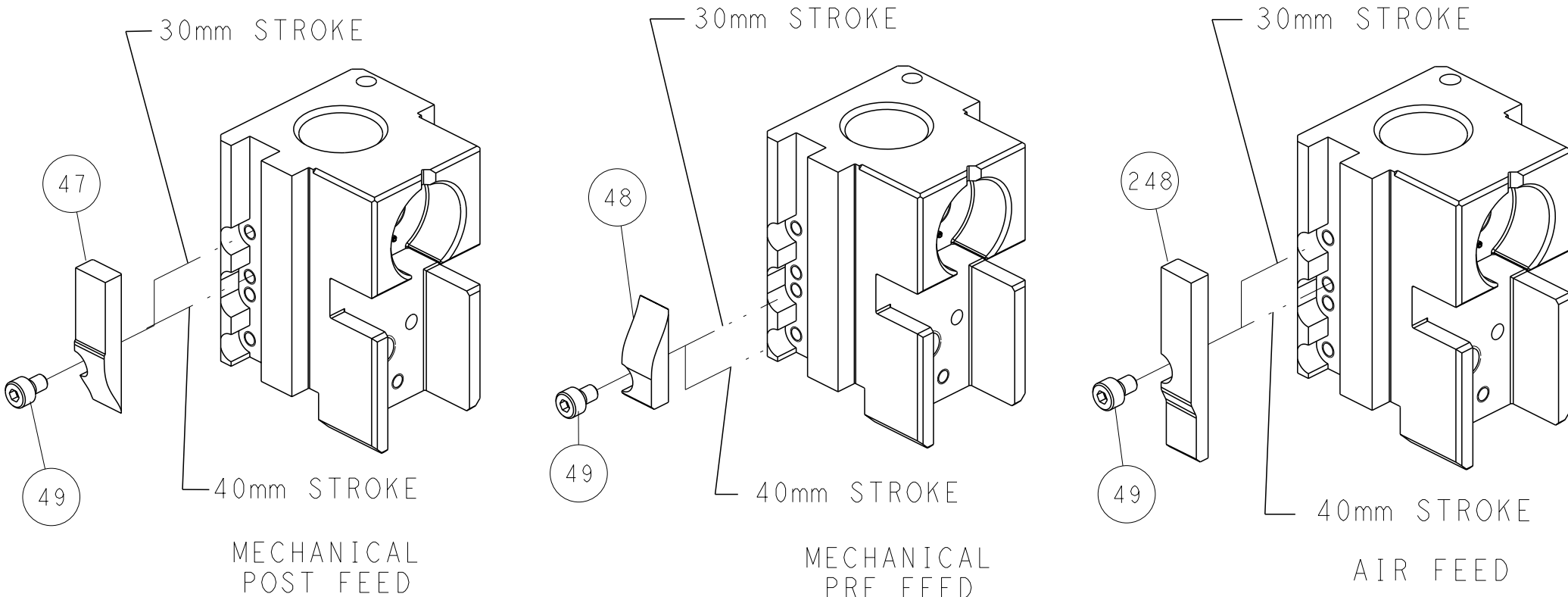


FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)

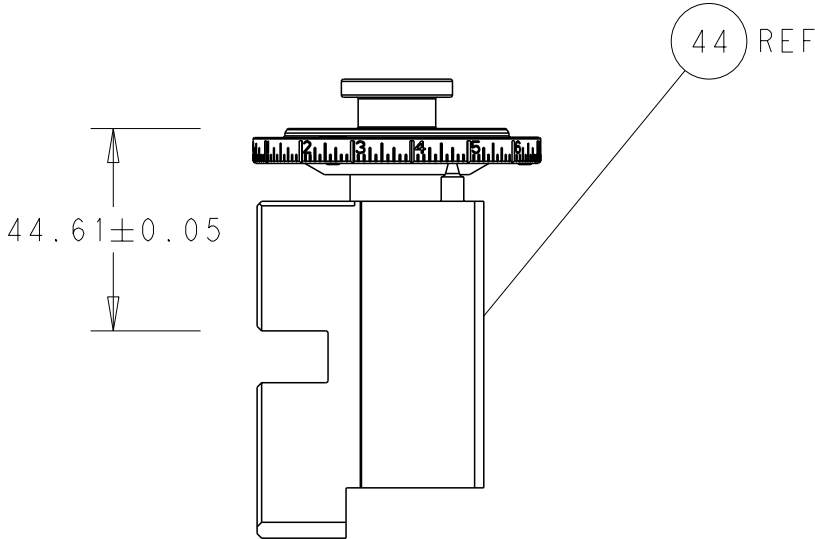


DETAIL A

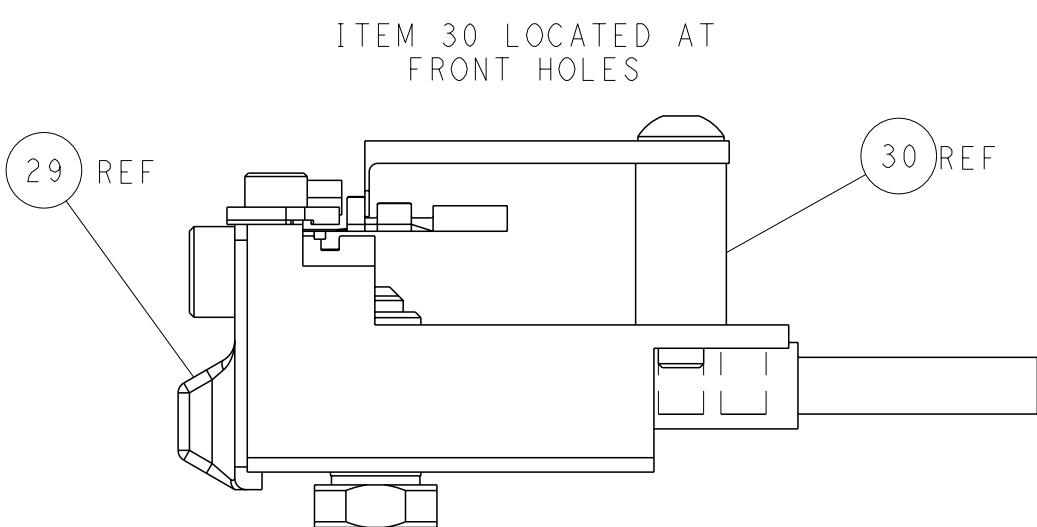
CAM POSITIONS



TERMINAL SUPPORT LOCATION



RAM SET-UP



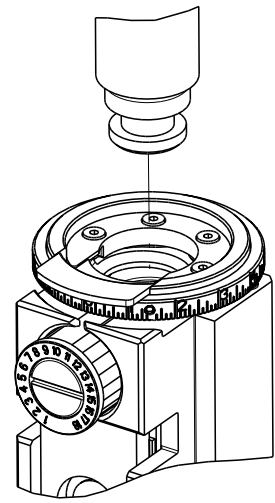
FEED TRACK POSITION
GUIDE BY INSULATION BARREL

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 A CONTROLLED DOCUMENT FOR YOUR ELECTRONICS CORPORATION IT IS SUBJECT TO CHANGE AND TO CONTROL AND ENGINEERING DISCRETION SHALL BE CONTACTED FOR THE LATEST REVISION				DWN BOB HIGMAN 05JUN2012	TE Connectivity Harrisburg, PA 17105-3608			
DIMENSIONS: mm				CHK T. ELBIN 05JUN2012	NAME Ocean Side Feed Applicator			
TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH				APVD M. CLIFFORD 05JUN2012	SIZE A1			
MATERIAL -				PRODUCT SPEC -	CAGE CODE 00779			
-				APPLICATION SPEC -	DRAWING NO 2151680			
-				WEIGHT -	RESTRICTED TO -			
-				Customer Accessible Production Drawing	SCALE 1:2	SHEET 2	OF 4	REV E

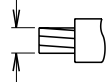
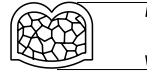
8		7	
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20		20	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2151680-1	E	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2151680-2	E	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151680-7	C	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.55 mm [.061]	F
INSUL	1.50 mm [.059]	O
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: YAZAKI TERMINAL		YAZAKI CRIMP SPECIFICATION	
TERMINAL NAME: KAIZEN 0.64 TERMINAL, FEMALE			
WIRE STRIP LENGTH 4.00-4.50 mm [.157-.177 IN]			INSULATION DIAMETER RANGE Ø1.50-1.60 mm [.059-.063 IN]
TERMINAL APPLICATION SPECIFICATION		YAZAKI 7116-4619-02 Rev WA1866	-
TERMINALS APPLIED 			
TE TERMINAL	YAZAKI TERMINAL	TE TERMINAL	YAZAKI TERMINAL
2113274-1	7116-4619-02	2113274-2	7116-4619-08
2113274-3	7116-5232-08		

WIRE SIZE			CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING 
0.75mm2			1.05+/-0.05 [.041+/-0.002]		7.8



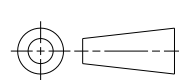
-  RECOMMENDED SPARE PARTS
-  REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
-  APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242.
-  CRIMP HEIGHT REFERENCE SETTING WAS THE SETTING USED WHEN THE APPLICATOR WAS QUALIFIED AT THE FACTORY. ADJUSTMENT MAY BE NECESSARY WHEN RUNNING APPLICATOR IN THE FIELD.
5. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
-  TERMINAL LUBRICANT IS RECOMMENDED.

*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				
A	66	#	LYR	DESCRIPTION	DATE	OWN
			-	SEE SHEET 1	-	-

-	1	1	2119082-4	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	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
-	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	1	-	2844940-1	AIR FEED MODULE	238
-	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	1	-	2119641-2	FEED CAM, AIR FEED	151
-	1	1	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	144
-	4	4	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	143
-	-	1	2119653-2	FEED CAM, POST FEED	142
-	1	1	1-1803583-0	APPLICATOR BASIC ASSEMBLY, SF	141
-	1	1	1803516-1	RAM ASSEMBLY, SF PACIFIC	140
-	1	1	1-18028-2	WASHER, FLAT, REG M4	119
	1	1	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113
-	1	1	2844908-1	SCREW, LOCKING	99
-	1	1	2844907-1	POST, LOCKING	98
-	1	1	455888-4	SPACER, CRIMPER	82
-	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
-	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	1	1	1338685-1	PAWL, FEED	56
-	2	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	53
-	1	1	1803382-6	HOLD DOWN, SPRING LOADED	50
-	1	2	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	-	1	2119652-1	FEED CAM, PRE FEED	48
-	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
-	1	1	1752356-3	SUPPORT, TERMINAL	34
-	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	2-2844962-6	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	2844992-2	ASSEMBLY, STRIP GUIDE	29
-	1	1	455888-3	SPACER, CRIMPER	28
-	1	1	1320928-2	STRIP GUIDE	24
-	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	2119533-1	STRIPPER, SIDE FEED	19
	1	1	2119806-1	INSERT, SHEAR	13
-	1	1	3-22280-3	SPRING, COMPRESSION	12
-	1	1	1-356885-4	STOP, SHEAR	11
	1	1	2119805-1	SHEAR HOLDER, FRONT	10
	1	1	1803095-6	FLOATING SHEAR, FRONT	9
	1	1	1-1633932-1	ANVIL, COMBINATION	8
-	-	-	-	-	7
-	-	-	-	-	6
-	1	1	1-2119757-3	DEPRESSOR, SHEAR	5
-	1	1	3-238011-1	BLOCK, CRIMPER SPACER	4
	1	1	9-1803019-2	CRIMPER, INSULATION O	3
-	1	1	455888-3	SPACER, CRIMPER	2
	1	1	1-1633305-6	CRIMPER, WIRE PREMIUM	1

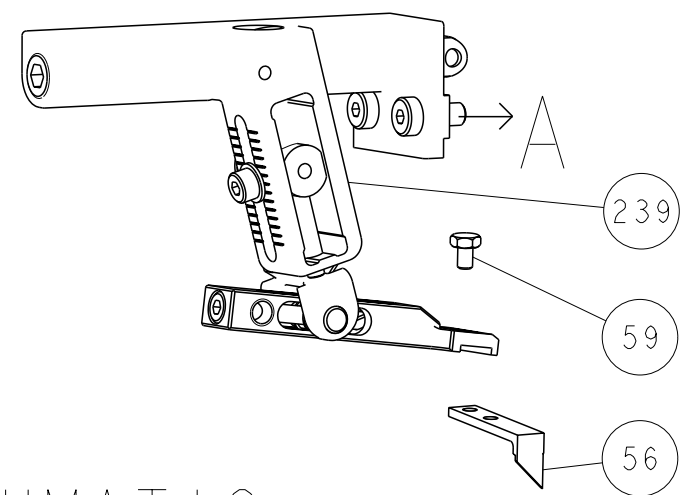
THIS DRAWING IS CONTROLLED DOCUMENT FOR THE ELECTRONIC COMPONENTS INDUSTRY. IT IS SUBJECT TO CHANGE AND TO THE RIGHT OF THE ENGINEERING ORGANIZATION TO BE CONTACTED FOR THE LATEST REVISION.		OWN BOB HIGMAN CHK T. ELBIN APVD M. CLIFFORD	05JUN2012 05JUN2012 05JUN2012	TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		NAME Ocean Side Feed Applicator	
		APPLICATION SPEC		SIZE A1	
MATERIAL -		WEIGHT -		CAGE CODE 00779	
				DRAWING NO 2151680	
				RESTRICTED TO -	
				Customer Accessible Production Drawing	
				SCALE 1:2	
				SHEET 3	
				OF 4	
				REV E	

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

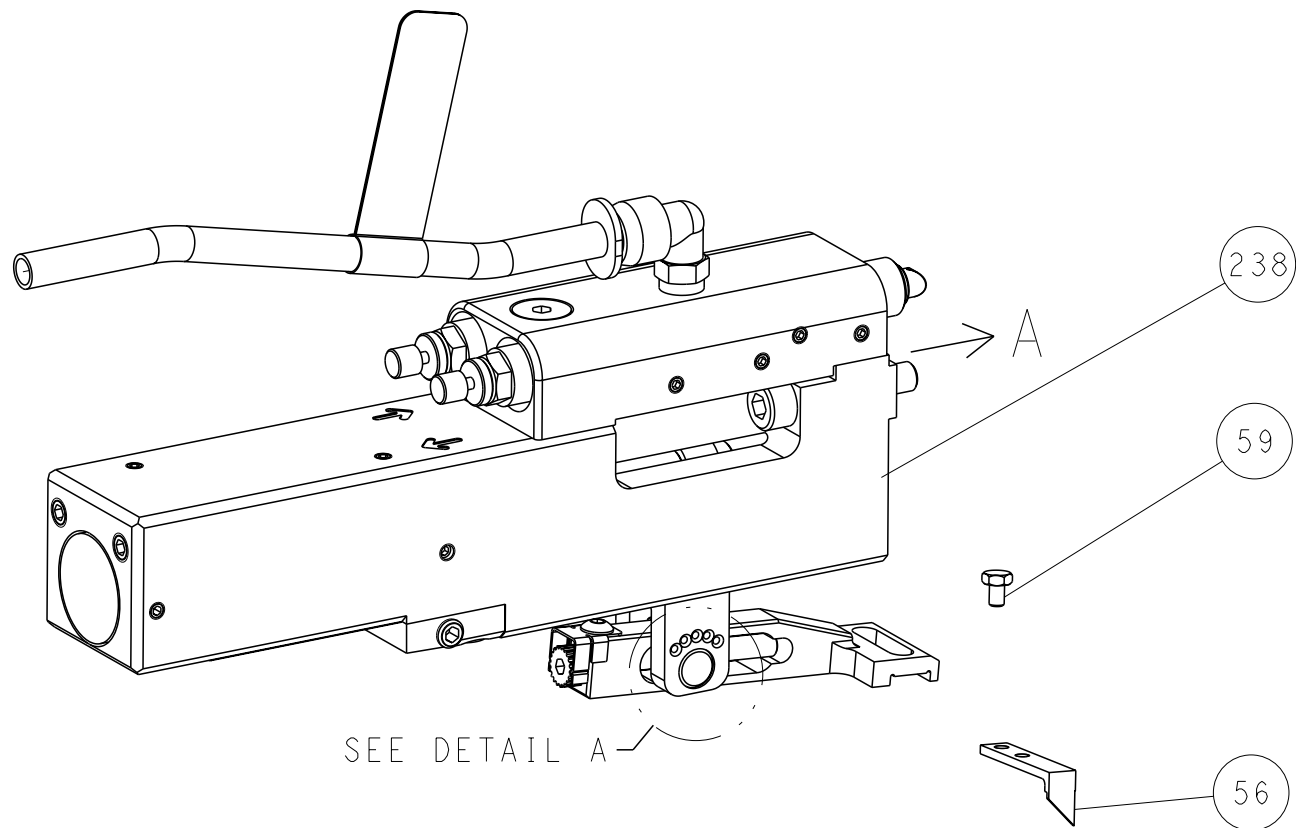
LOC		DIST		REVISIONS					
A		66		P	LYR	DESCRIPTION	DATE	DWN	APVD
				-		SEE SHEET 1	-	-	-

FEED TYPE

MECHANICAL

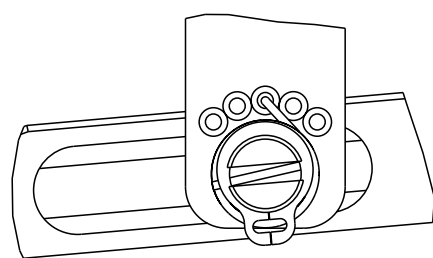


PNEUMATIC



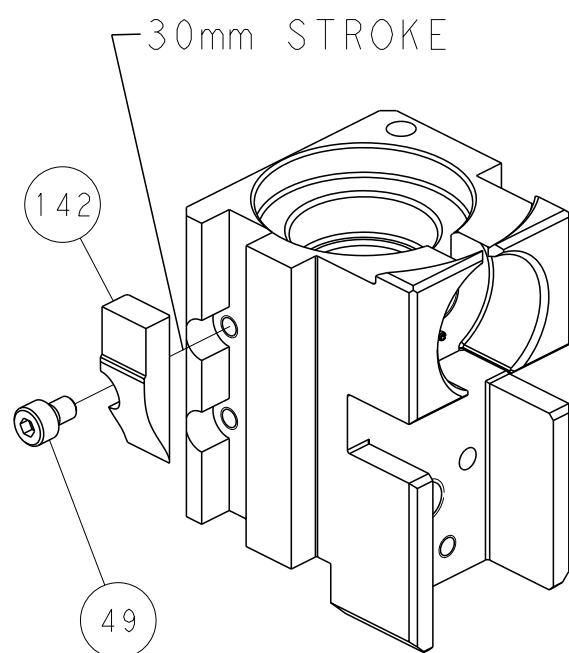
FEED SPRING SETTING POSITION

(SHOWN FROM REAR SIDE)



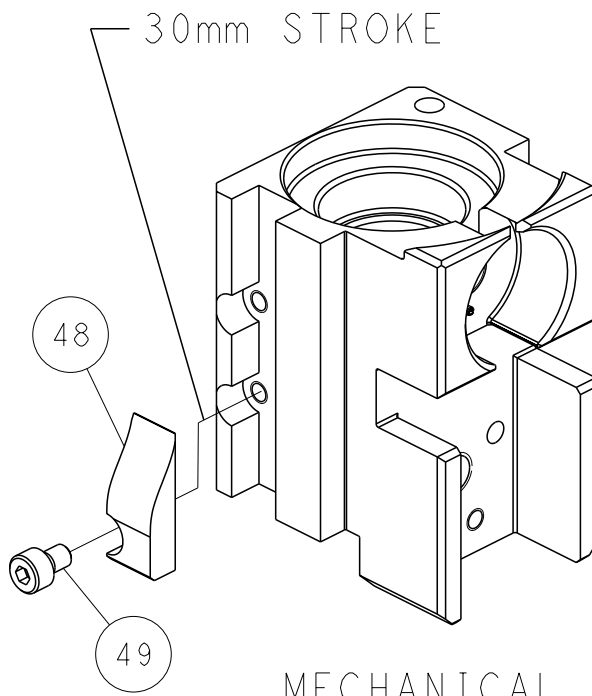
DETAIL A

CAM POSITIONS



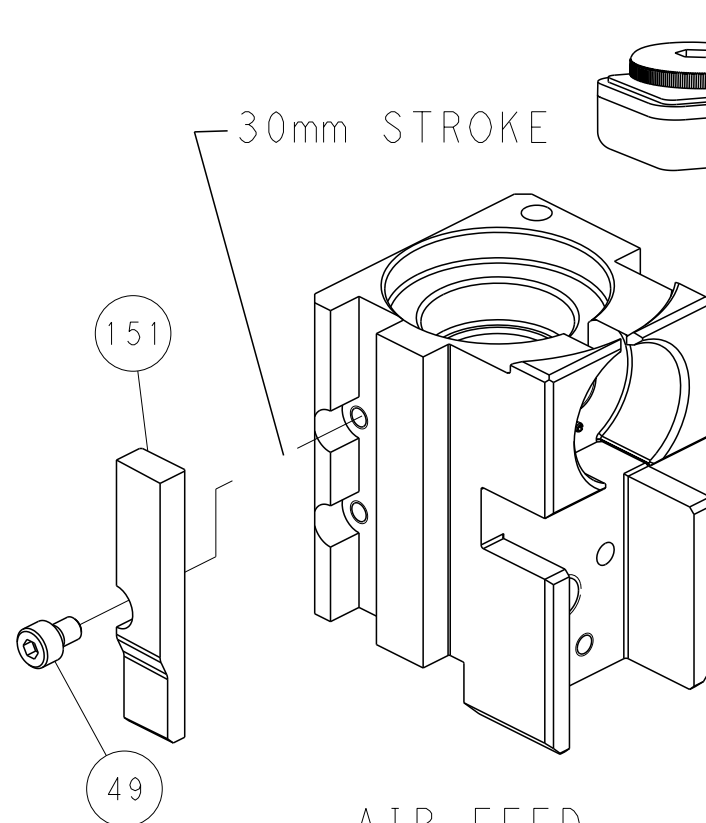
MECHANICAL

POST FEED



MECHANICAL

PRE FEED

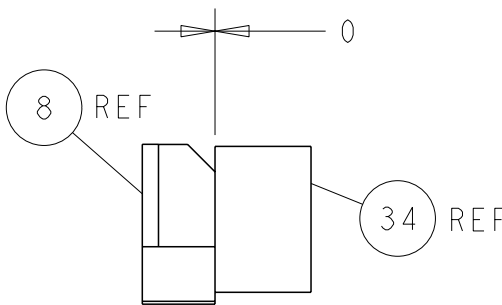


AIR FEED

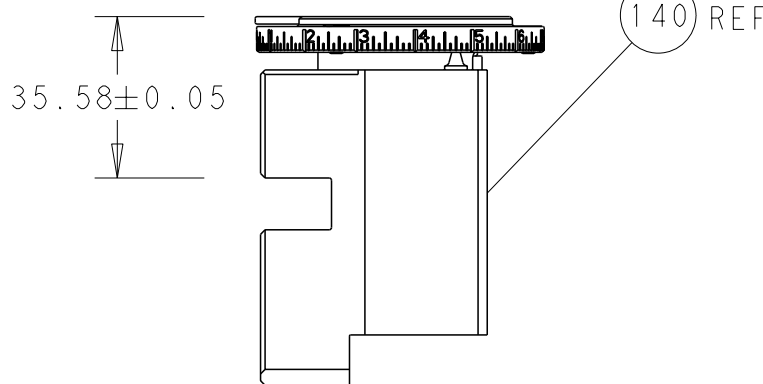
PACIFIC VERSION

Shown on sheets 3 of 4 & 4 of 4

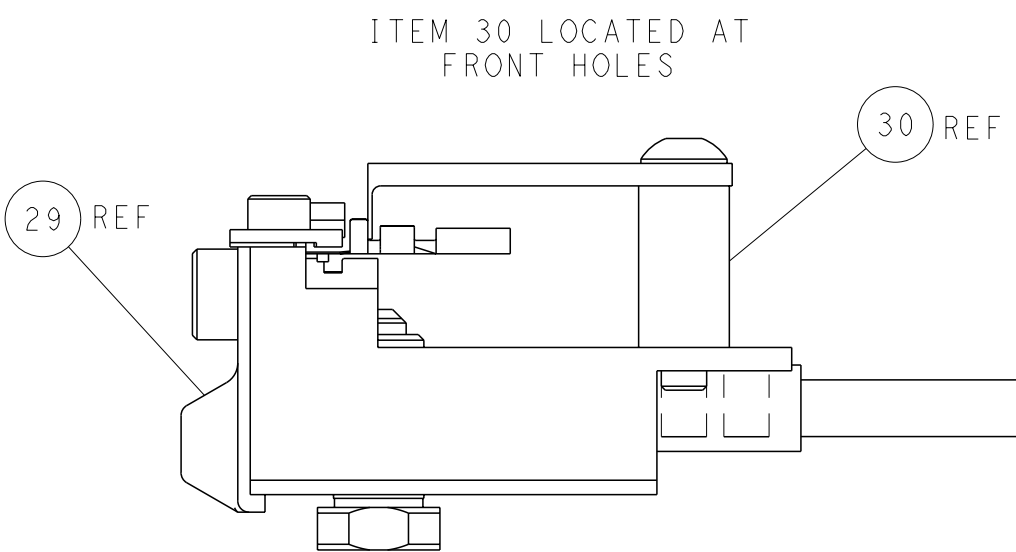
(Atlantic version shown on sheets 1 of 4 & 2 of 4)



TERMINAL SUPPORT LOCATION

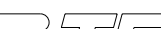


RAM SET-UP



FEED TRACK POSITION

GUIDE BY INSULATION BARREL

THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE AND TO CONTROL AND ENGINEERING DEPARTMENT SHOULD BE CONTACTED FOR THE LATEST REVISION.				DWN	BOB HIGMAN	05JUN2012	 TE Connectivity Harrisburg, PA 17105-3608																		
				CHK	T. ELBIN	05JUN2012																			
				APVD	M. CLIFFORD	05JUN2012																			
				PRODUCT SPEC																					
DIMENSIONS:				TOLERANCES UNLESS OTHERWISE SPECIFIED:			NAME		Ocean Side Feed Applicator																
mm																									
		0 PLC	±		APPLICATION SPEC		SIZE		CAGE CODE		DRAWING NO		RESTRICTED TO												
		1 PLC	±																						
		2 PLC	±																						
		3 PLC	±																						
		4 PLC	±																						
ANGLES		±																							
MATERIAL		-		FINISH		-		WEIGHT		-		A		00779		C=2151680		-							
Customer Accessible Production Drawing														SCALE		1:2		SHEET		4 of 4		REV		E	

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

Mouser Electronics

Authorized Distributor

Click to View Pricing, Inventory, Delivery & Lifecycle Information:

[TE Connectivity:](#)

[2151680-2](#)