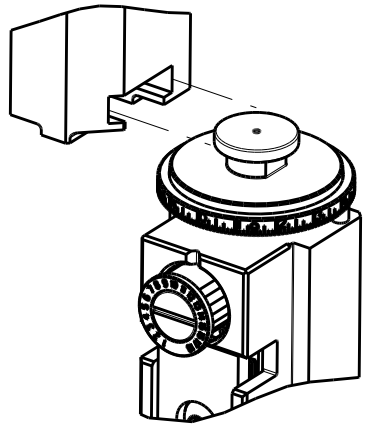


8		7		6		5		4		3		
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ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER		PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART						
						CONVERT TO	PART NUMBERS REQUIRED					
		2150373-1	A	FINE CRIMP HEIGHT ADJUST	MECHANICAL	PNEUMATIC FEED	2119950-1	2119792-2	-	2119641-1	-	2063440-1
						SERVO LATCH PLATE	2119951-1	1901697-1	8-2150373-5	-	-	2168400-7 (QUANTITY 2)
						SMART APPLICATOR	2161326-1	-	8-2150373-4	-	-	-
		2150373-2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	MECHANICAL FEED	2119949-1	2063961-1	5-18022-5	2119653-1	-	-
						SERVO LATCH PLATE	2119951-1	1901697-1	8-2150373-5	-	-	2168400-7 (QUANTITY 2)
						SMART APPLICATOR	2161326-1	-	8-2150373-4	-	-	-
		2150373-5	A	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE 	MECHANICAL FEED	2119949-1	2063961-1	5-18022-5	2119653-1	-	-
						PNEUMATIC FEED	2119950-1	2119792-2	-	2119641-1	-	2063440-1
		2150373-6	A	NON-CRIMP HEIGHT ADJUST	 SERVO LATCH PLATE 	-	-	-	-	-	-	-
						-	-	-	-	-	-	-
2150373-7	A	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	-		
7-2150373-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-		

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.40 mm [.055]	F
INSUL	2.03 mm [.080]	F
APPLICATOR INSTRUCTIONS 408-10390		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: .110 SERIE		FASTON RECEPTACLE	
WIRE STRIP LENGTH 3.20-4.00 mm [.126-.157 IN]		INSULATION DIAMETER RANGE Ø0.89-1.65 mm [.035-.065 IN]	
TERMINAL APPLICATION 		-	
SPECIFICATION		-	
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
160666-1	160666-4	160666-5	

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING
22 AWG		0.81+/-0.05 [.032+/- .002]		6.1
24 AWG		0.74+/-0.05 [.029+/- .002]		7.0
26 AWG		0.66+/-0.05 [.026+/- .002]		7.9



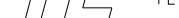
- ① RECOMMENDED SPARE PARTS
- ② GREASE BEARING SURFACES LIGHTLY
3. LUBRICATE DAILY PER THE APPLICATOR INSTRUCTION SHEET SUPPLIED WITH THE APPLICATOR.
- ④ APPLICATOR SPECIFIC DATA TO BE ENTERED INTO BLANK MEMORY CHIP AT ASSEMBLY. SEE BELOW FOR PART NUMBER:
MECHANICAL FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150373-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150373-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150373-5
SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2150373-6
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 ITEMS 62, 180 & 242.
FOR -6 ONLY APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 37, 180 & 242.
- 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 THE RECOMMENDED SET-UP FOR END FEED APPLICATORS IS POST-FEED WITH ITEM 2119653-1. THE APPLICATOR CAN BE CONFIGURED FOR PRE-FEED WITH ITEM 2119652-1 BUT MAY ENCOUNTER PROBLEMS WITH SOME APPLICATIONS. FEED ISSUES OR TERMINAL JAMMING MAY OCCUR IN THE PRE-FEED CONFIGURATION.
- ⑫ WHEN ASSEMBLING -6 NON-CRIMP HEIGHT ADJUST APPLICATOR USE SHIM PACK 2119957-2 TO ALIGN APPLICATOR'S MAXIMUM WIRE CRIMP HEIGHT AT NORMAL TERMINATOR SHUT HEIGHT

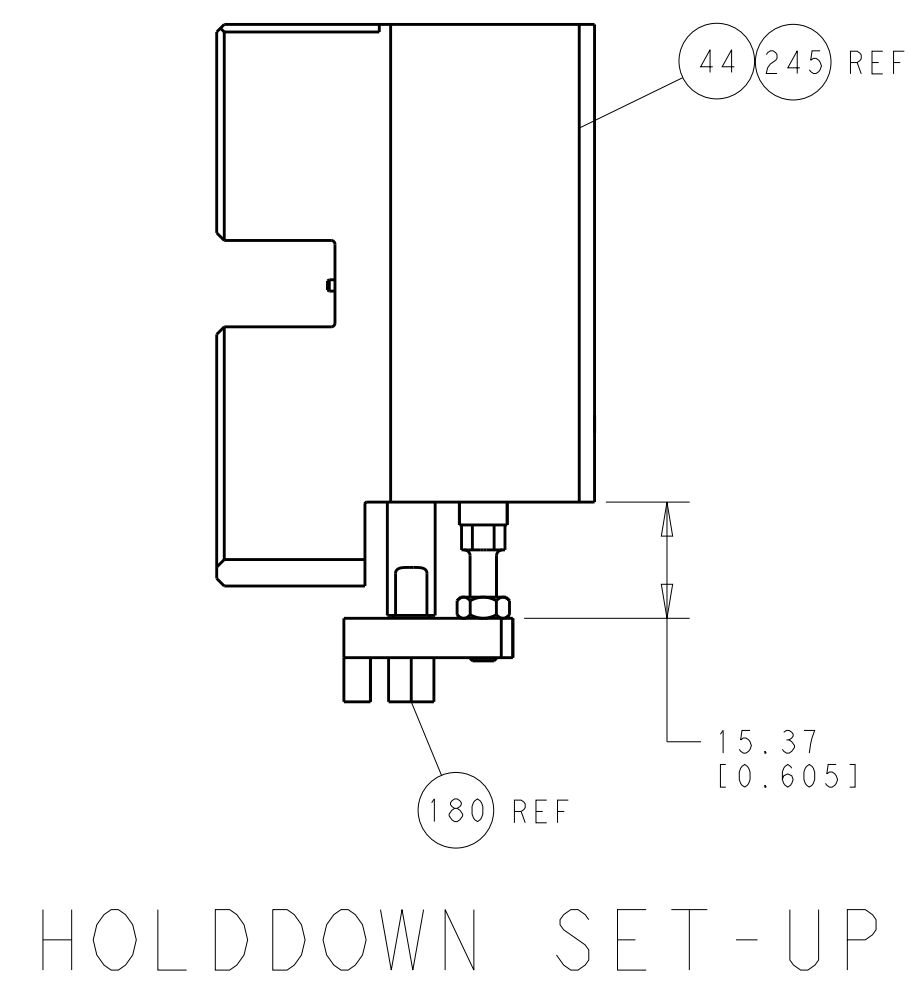
*WARNING
ON INSTALLATION, SET WIRE DISC, ITEM 40 TO
LARGEST WIRE SIZE SETTING. USE OF SETTINGS
BELOW MINIMUM REQUIRED CRIMP HEIGHT SETTING
WILL CAUSE DAMAGE TO CRIMP TOOLING.

-	-	1	-	-	-	2119957-2	APPLICATOR SHIM PACK	260
-	1	-	1	1	1	8-21084-0	O-RING, .676 ID, .070 DIA. MAT.	252
-	-	-	-	1	-	2119640-1	PUSH ROD, AIR FEED	250
-	-	-	-	1	-	2079988-1	BUSHING, LCH5-12, MISUMI	249
-	-	-	-	1	-	2119641-1	FEED CAM, AIR FEED	248
-	1	-	1	1	1	2119798-1	DETENT PIN	247
-	1	-	1	1	1	1-22279-3	SPRING, COMPRESSION	246
-	-	1	-	-	-	2119759-1	RAM, AMP STYLE, END FEED, NON-ADJUST	245
-77	-7	-6	-5	-2	-1	PART NO	DESCRIPTION	ITEM NO

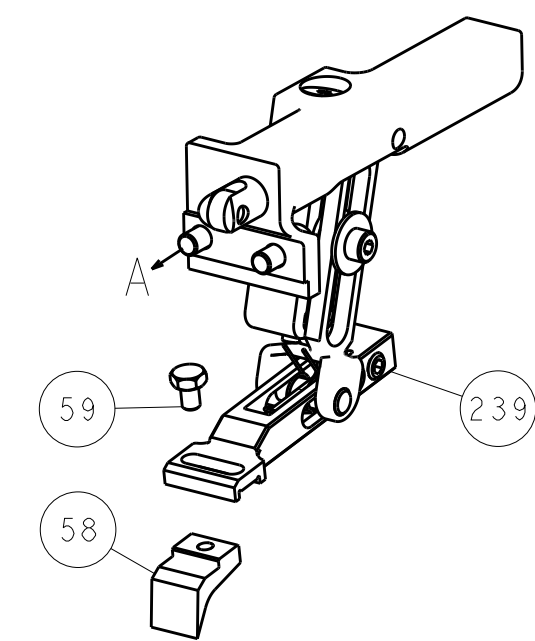
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

SET UP GAUGE 2119599-2				LOC A	DIST 66	REVISIONS					
						P	LTR	DESCRIPTION	DATE	OWN	APVD
							I	DEVELOPMENT	29SEP2013	KH	UG
							A	RELEASED	28OCT2013	BH	TE
1	1	1		2119082-8	CAM, SNAIL, INSULATION ADJUSTMENT						244
1	1	1		2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST						243
1	1	1		2119083-1	RETAINER, INSULATION DIAL						242
2	-	-		2168400-7	SHCS, LOW HEAD, RoHS, M5 X 10						240
-	-	1		2119580-1	MECHANICAL FEED ASSEMBLY						239
-	1	-		2063440-1	AIR FEED MODULE						238
1	-	-		2119740-2	TAG, IDENTIFICATION						213
REF	-	-		1901697-1	FEED FINGER ASSEMBLY,EF						183
1	1	1		1752354-8	STANDOFF,HOLD-DOWN						180
1	1	1		6-993111-6	PIN, SLOTTED SPRING 3.0 X 14.0						177
1	1	1		8-22280-7	SPRING, COMPRESSION						176
1	1	1		1752353-2	GUIDE PIN,HOLDDOWN						175
1	1	1		1901680-2	GUIDE PIN,HOLDDOWN						174
-	2	-		21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT						172
1	1	1		994969-1	MAGNET, RARE EARTH HIGH ENERGY						166
REF	REF	REF		994970-2	COUNTER, MAGNETIC						164
-	1	-		240638-1	SPRING, FEED FINGER						163
-	1	-		3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854						137
REF	-	-		SEE NOTE 4	MEMORY CHIP, PROGRAMMED						135
1	-	-		1633743-1	SERVO FEED LATCH ASM						133
1	1	1		455888-5	SPACER, CRIMPER						82
1	1	1		2119956-2	DOCUMENTATION PACKAGE						71
2	2	2		2-18032-2	SCR, SET, FLT POINT M3 X 10.0						70
-	1	1		2119740-1	TAG,IDENTIFICATION						67
2	2	2		2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188						66
1	1	1		1-1901681-3	HOLDDOWN, TERMINAL						65
2	2	2		2168400-8	SHCS, LOW HEAD, RoHS, M4 X 16						64
1	1	1		2119793-1	LIMITER, ADJUSTMENT BOLT						63
3	3	3		992763-5	SCR, SET, SOC, CONE POINT, M3 x 4.0						62
1	1	1		2079383-4	SCR, BHSC, RoHS (M4 X 8)						60
-	-	1		5-18022-5	SCR, HEX HD CAP, M4 X 6.0						59
-	-	1		2063961-1	FEED FINGER						58
3	3	3		2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8						57
2	2	2		1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10						56
2	2	2		5018030-2	NUT, HEX, REG, RoHS, M4						55
2	2	2		5018030-1	NUT, HEX, REG, RoHS, M3						54
2	2	2		986965-8	NUT, LOCK, HEX, TORQUE (M4)						53
1	1	1		1-5018030-0	NUT, HEX, REG, RoHS, M3.5						52
-	1	-		2119792-2	PAWL, EF, AIR						51
-	1	2		18023-9	SCR, SKT HD CAP M4 X 6.0						49
-	-	1		2119652-1	FEED CAM, PRE FEED						48
-	-	1		2119653-1	FEED CAM, POST FEED						47
1	1	1		2119655-5	APPLICATOR BASIC ASSEMBLY, EF						46
1	1	1		2119369-1	RAM,AMP STYLE, END FEED						44
1	1	1		2079383-7	SCR, BHSC, RoHS (M8 X 25)						41
1	1	1		2119645-1	DISC, NUMBERED FA WIRE ADJUSTMENT						40
1	1	1		2119957-1	APPLICATOR SHIM PACK						39
1	1	1		1-2119644-4	RAM WASHER, PRECISION						38
1	1	1		2119085-1	FA HEAD, ATLANTIC STYLE						37
1	1	1		2119092-1	BOLT, ADJUSTMENT						35
7	7	7		1-18028-2	WASHER, FLAT, REG M4						33
2	2	2		2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20						31
2	2	2		1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10						29
1	1	1		240639-2	STRIPPER (MACHINING)						27
2	2	2		1320906-1	STUD, THREADED						25
1	1	1		1-1752371-2	PLATE, STRIP GUIDE						24
1	1	1		240825-9	PLATE, STRIP HOLD DOWN						23
2	2	2		2-22281-3	SPRING, COMPRESSION						22
1	1	1		1752373-4	DRAG						20
2	2	2		1901259-2	GUIDE, LOWER STRIP						18
4	4	4		1-2079383-1	SCR, BHSC, RoHS (M6 X 12)						17
1	1	1		5-240641-9	SPACER						16
1	1	1		240833-3	PLATE, REAR SHEAR						11
2	2	2		3-240645-4	SPACER, SHEAR PLATE						10
1	1	1		240642-1	PLATE, FRONT SHEAR						9
1	1	1		3-1633383-3	ANVIL, COMBINATION						8
1	1	1		4-240651-3	BLADE, SLUG						7
-	-	-		-	-						6
1	1	1		3-240641-4	SPACER						5
1	1	1		238009-1	BLOCK, FL CRIMPER SPACER						4
1	1	1		1-1803017-5	CRIMPER, INSULATION F						3
-	-	-		-	-						2
1	1	1		1-456402-7	CRIMPER, WIRE PREMIUM						1
-5	-2	-1		PART NO	DESCRIPTION						ITEM NO

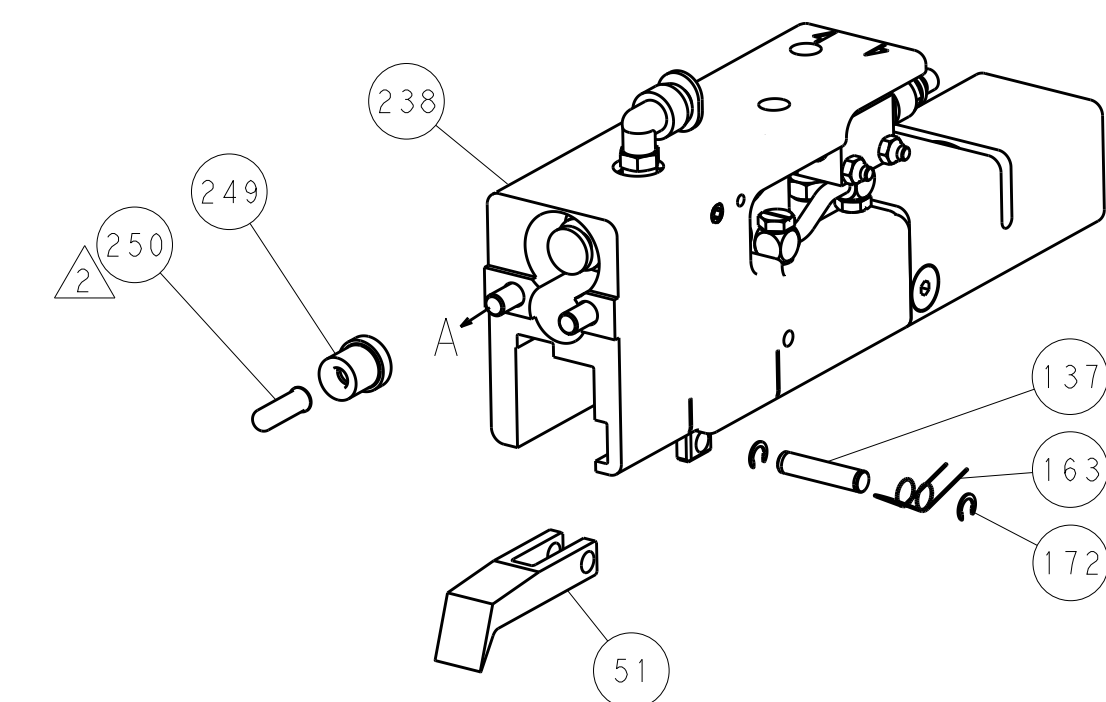
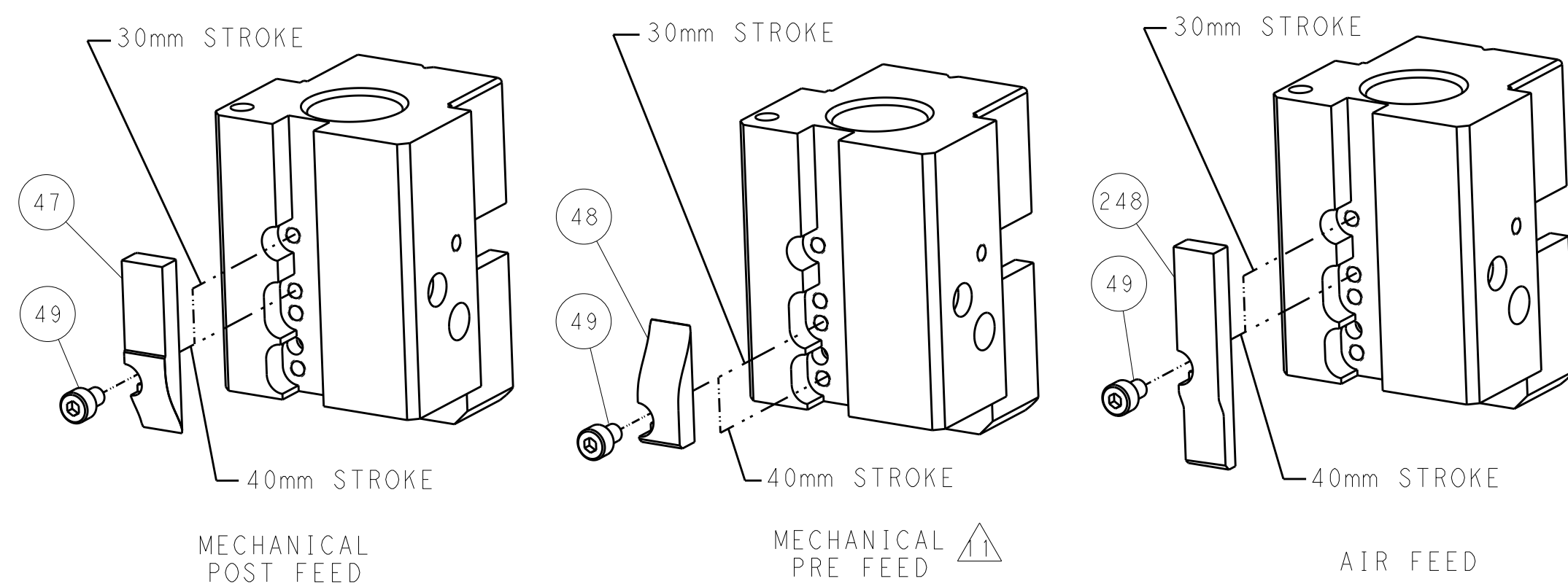
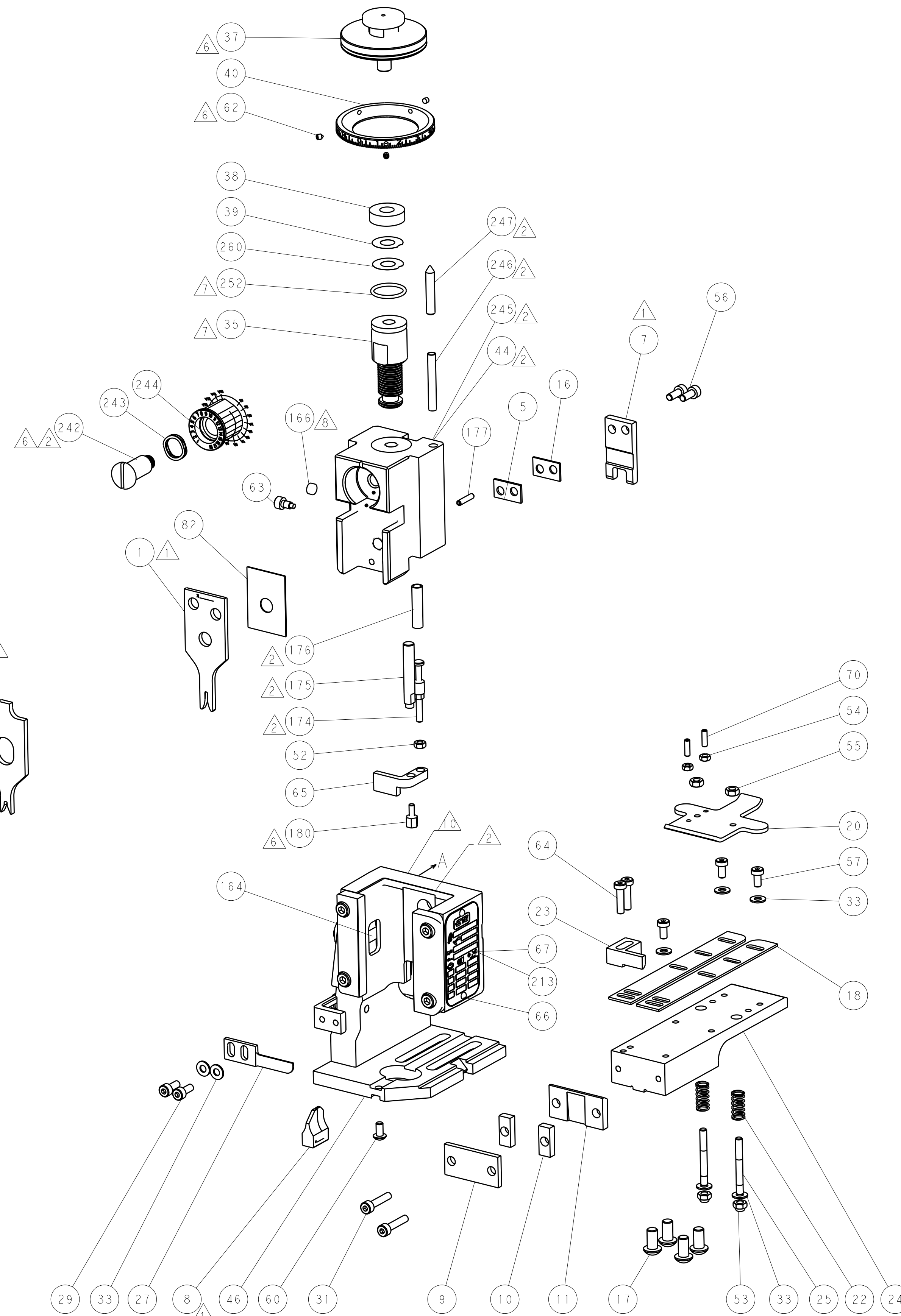
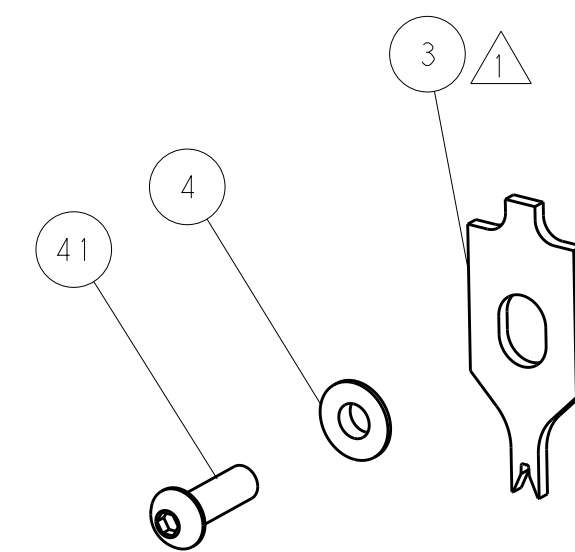
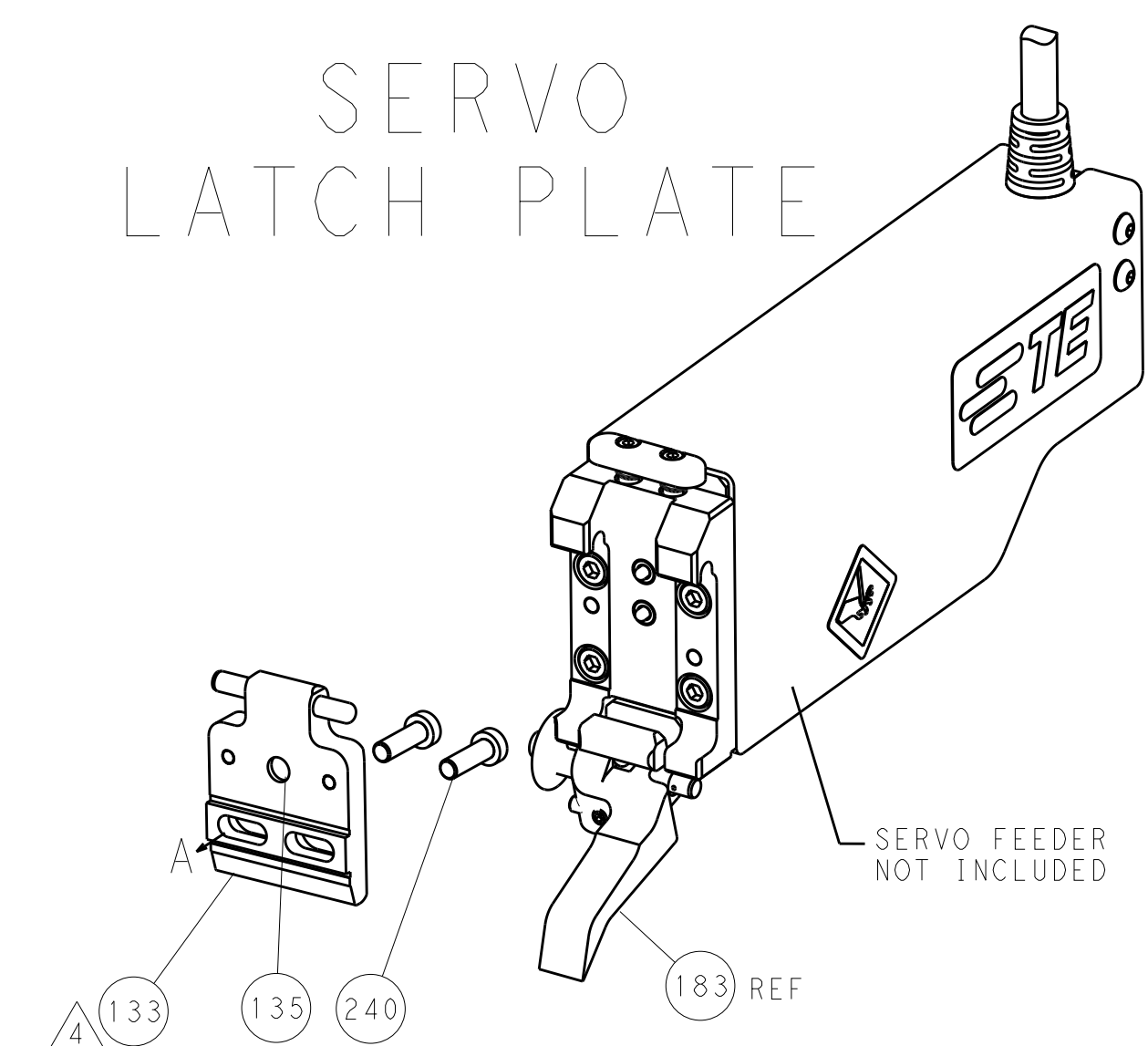
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DIMENSIONS: mm		TOLERANCES, UNLESS OTHERWISE SPECIFIED:		NAME Ocean End Feed Applicator	
		PRODUCT SPEC		SIZE	
		APPLICATION SPEC		CODE	
MATERIAL		WEIGHT		DRAWING NO.	
FINISH		CUSTOMER ACCESSIBLE PRODUCTION DRAWING		SCALE 1:1	
				SHEET 1 OF 4	
				REV A	



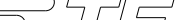
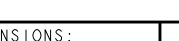
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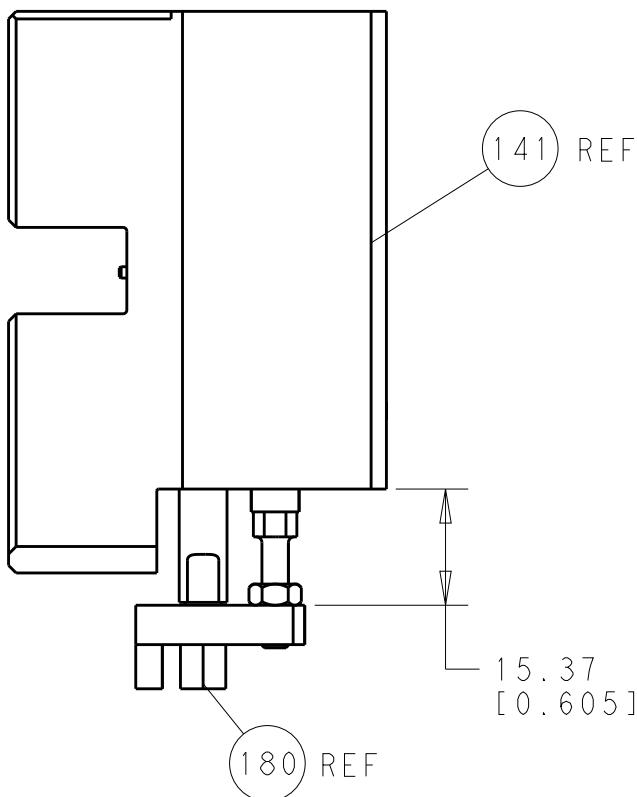
PNEUMATIC

SERVO
LATCH PLATE

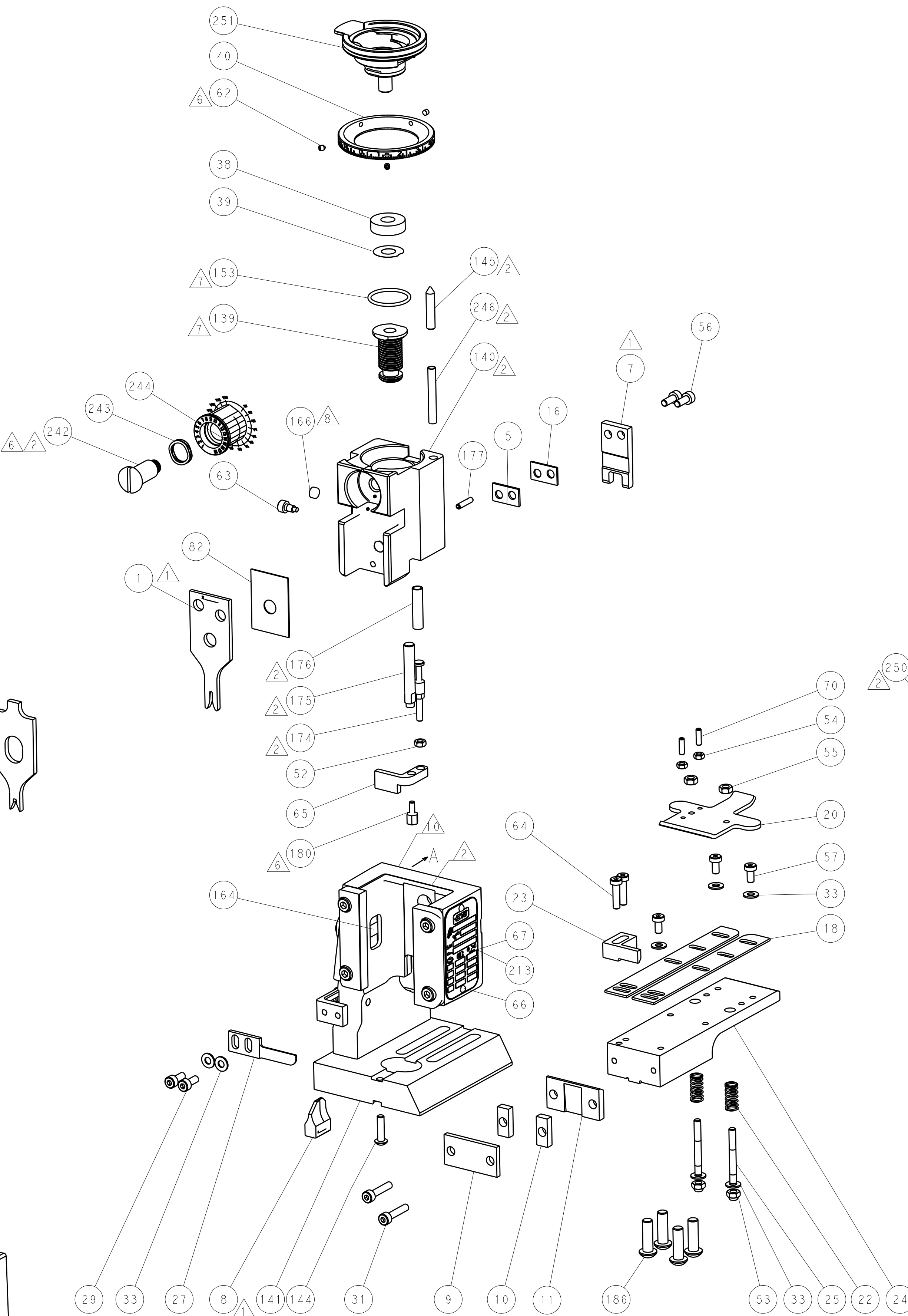
ATLANTIC VERSION
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(Pacific version shown on sheets 3 of 4 & 4 of 4)

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DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		NAME Ocean End Feed Applicator	
		0 PLC ±.1 1 PLC ±0.5 2 PLC ±0.13 3 PLC ±0.013 4 PLC ±0.001 ANGLES ±.1		PRODUCT SPEC - APPLICATION SPEC -	
MATERIAL -		FINISH -		WEIGHT -	
Customer Accessible Production Drawing				SIZE A1 CAGE CODE 00779 DRAWING NO. C-2150373	
SCALE 1:1				SHEET 2 OF 4 REV A	

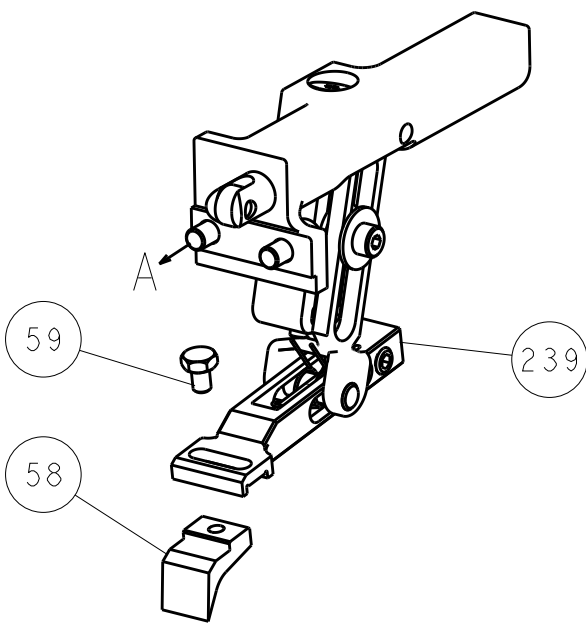
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A	66	P	LTR	DESCRIPTION	DATE	DWN	APVD
		-		SEE SHEET 1	-	-	-



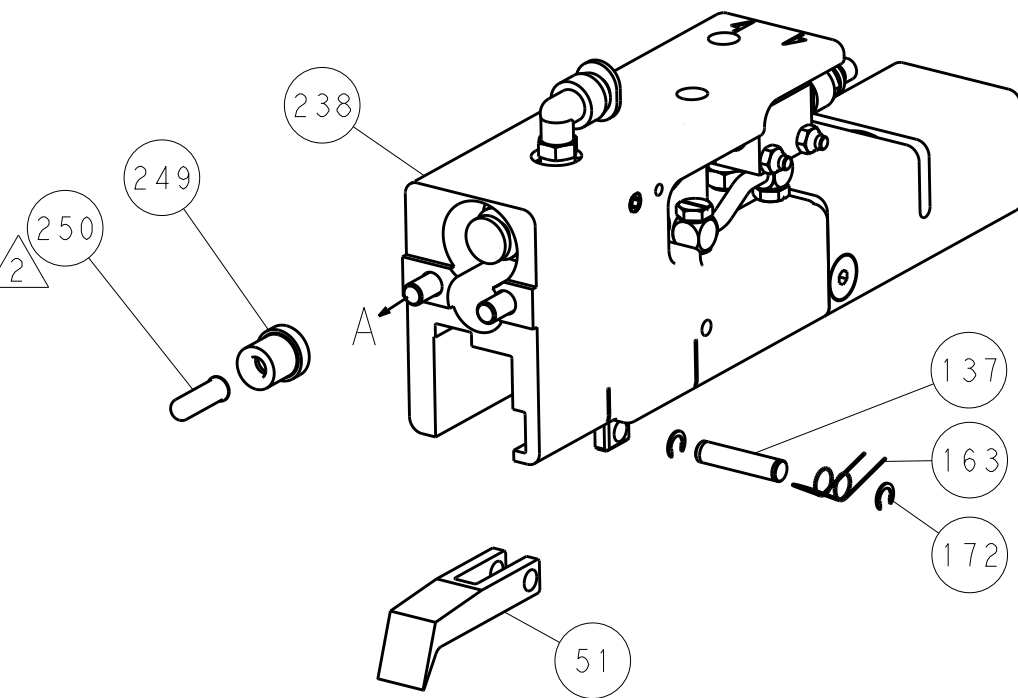
HOLDDOWN SET-UP



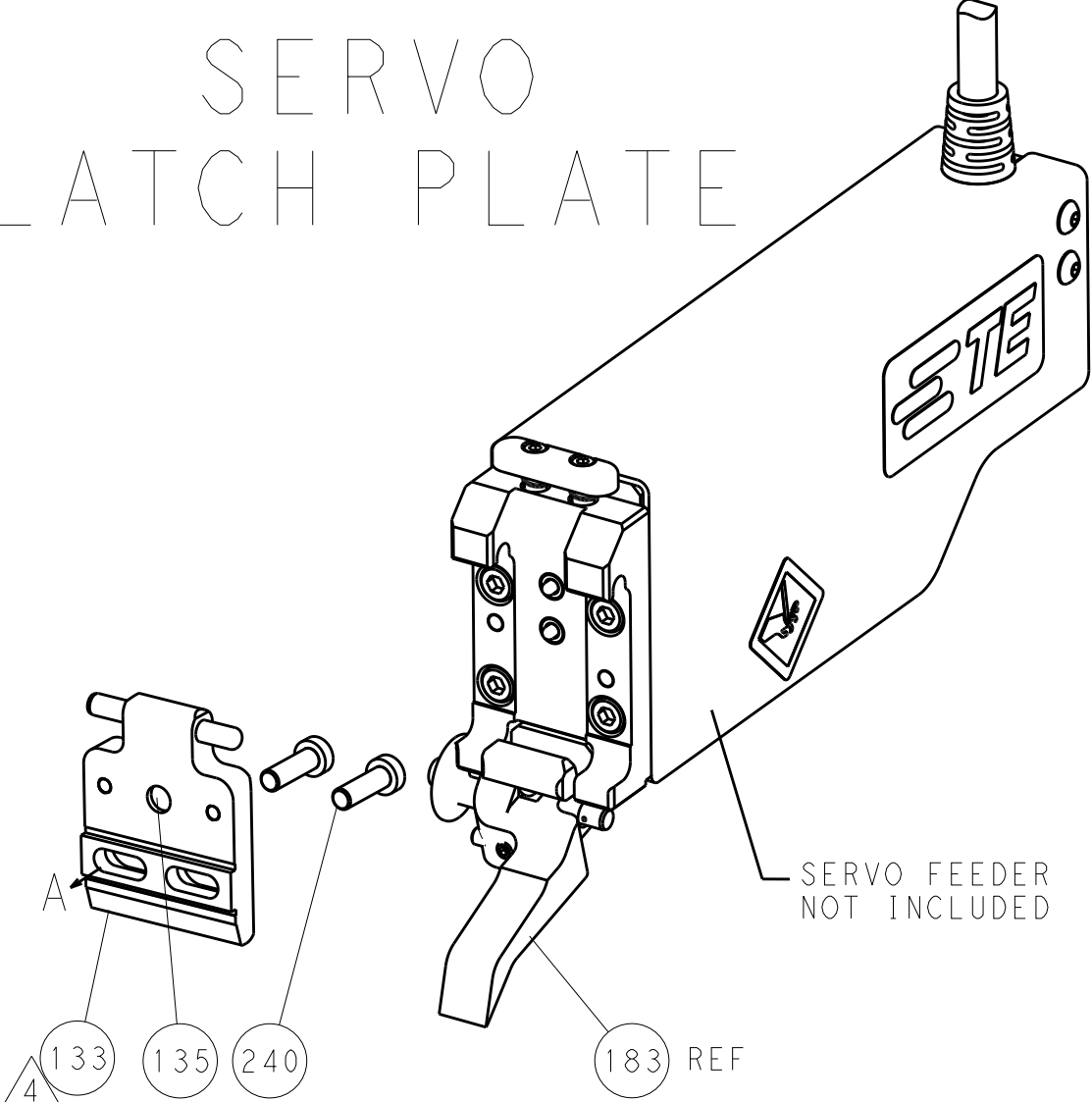
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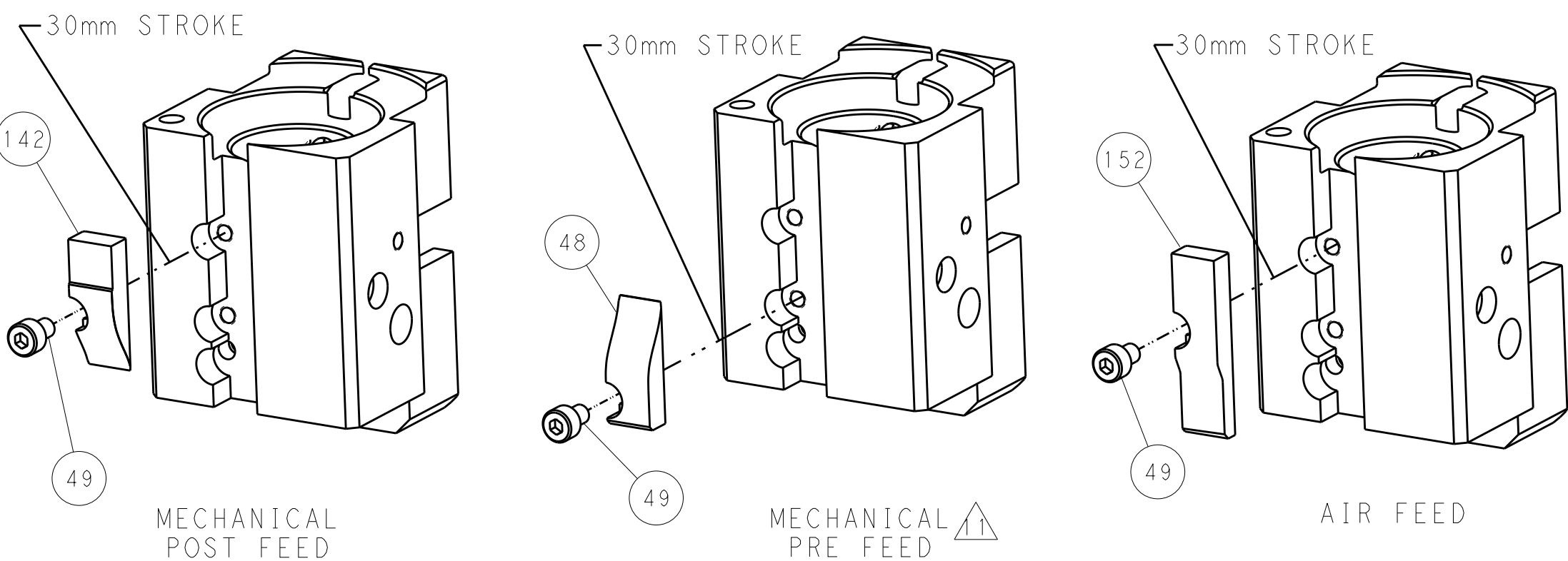
PNEUMATIC



SERVO
LATCH PLATE



CAM POSITIONS



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

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DIMENSIONS: mm		CHK L. ZHANG 29SEP2013	NAME Ocean End Feed Applicator	
TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.5 1 PLC ±.13 2 PLC ±.13 3 PLC ±.013 4 PLC ±.0001 ANGLES FINISH		APVD J. GUO 29SEP2013	SIZE A1 00779 C=2150373	
MATERIAL		PRODUCT SPEC	RESTRICTED TO	
		APPLICATION SPEC	Customer Accessible Production Drawing	
		WEIGHT	SCALE 1:1 SHEET 4 OF 4 REV A	