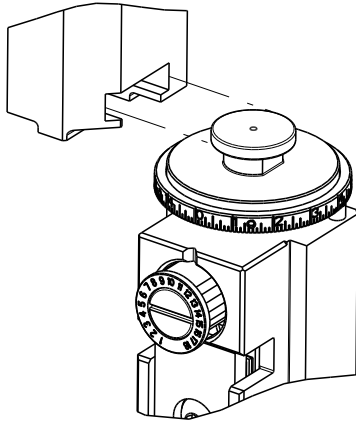


8		7	
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20		20	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150086-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2150086-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150086-1	C	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2150086-2	C	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150086-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.29 mm [.090]	F
INSUL	2.54 mm [.100]	Ø
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: .250 SERIES FASTON RECEPTACLE			
WIRE STRIP LENGTH .205-.235 IN [5.21-5.97 mm]		INSULATION DIAMETER RANGE Ø.060-.087 IN [1.52-2.21 mm]	
TERMINAL APPLICATION SPECIFICATION		114-2036	
TERMINAL APPLICATION SPECIFICATION		-	
TERMINALS APPLIED 5			
TE TERMINAL 62866-1	TE TERMINAL 42640-1	TE TERMINAL 42640-2	TE TERMINAL

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING 4
18 AWG		1.42+/-0.05 [1.056+/-0.002]		4.3
20 AWG		1.30+/-0.05 [1.051+/-0.002]		5.6
22 AWG or 0.35mm2		1.24+/-0.05 [1.049+/-0.002]		6.3



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.

*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.

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

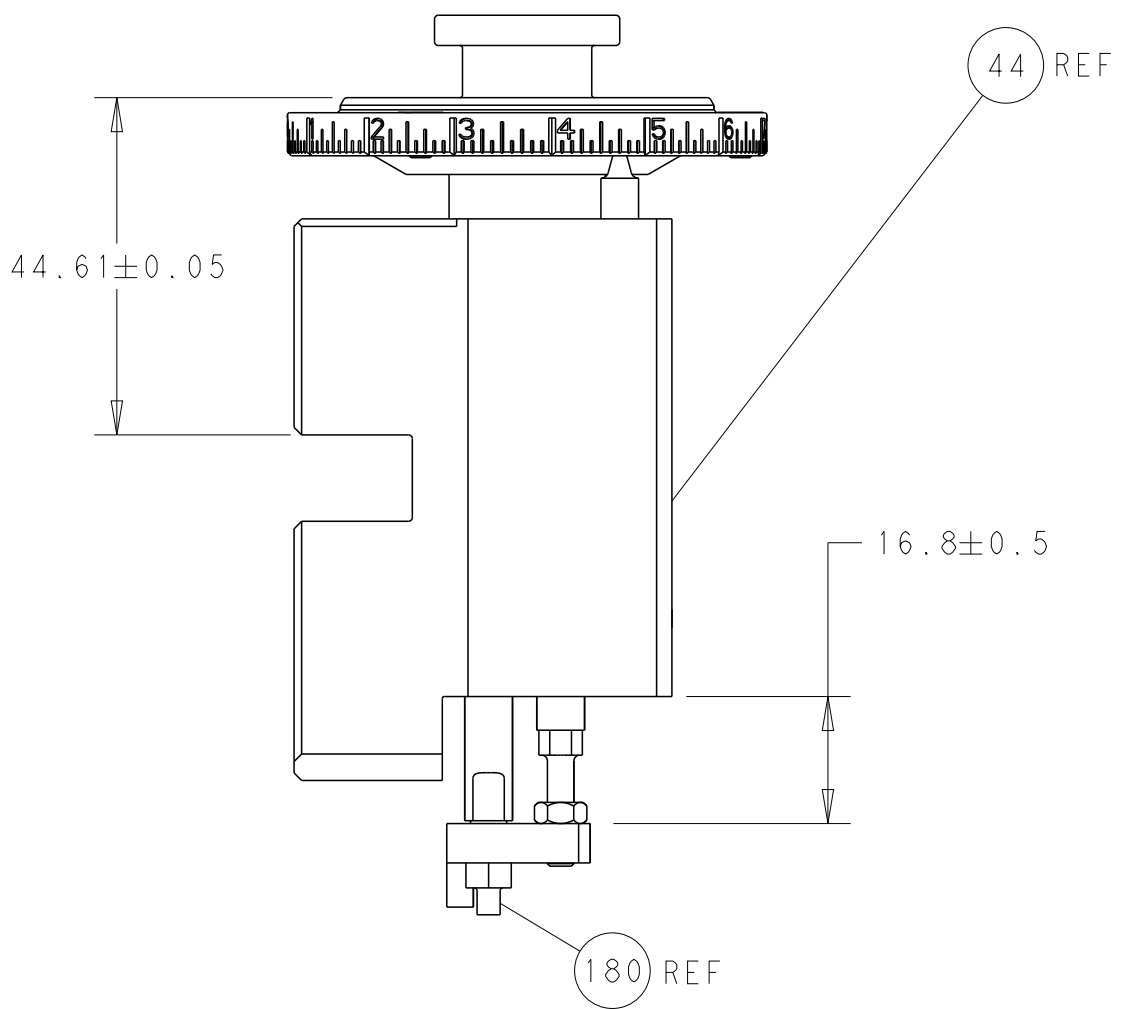
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LOC	DIST	REVISIONS					
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		B		ECR-14-002777	26FEB2014	XZ	JG
		C		ECR-19-001359	25JAN2019	TB	CT

	-	1	-	1	-	2119640-1	PUSH ROD, AIR FEED	250
	-	1	-	1	-	1803259-1	BUSHING, FLANGED	249
	-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248
	-	1	1	1	1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244
	-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
3	-	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
	-	-	1	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
	-	1	-	1	-	2063440-1	AIR FEED MODULE	238
	-	1	1	1	1	1-18028-0	WASHER, FLAT, REG M8	192
3	-	1	1	1	1	1-1976055-2	STANDOFF, HOLD-DOWN	180
	-	1	1	1	1	6-993111-6	PIN, SLOTTED SPRING 3.0 X 14.0	177
	-	1	1	1	1	8-22280-7	SPRING, COMPRESSION	176
	-	1	1	1	1	1752353-2	GUIDE PIN,HOLDDOWN	175
	-	1	1	1	1	1901680-2	GUIDE PIN,HOLDDOWN	174
	-	2	-	2	-	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172
	-	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
	-	1	-	1	-	240638-1	SPRING, FEED FINGER	163
	-	1	-	1	-	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854	137
5	-	1	1	1	1	2119955-2	ASSY, LUBRICATOR, END FEED	84
	-	1	1	1	1	455888-4	SPACER, CRIMPER	82
	-	1	1	1	1	2119791-9	DEPRESSOR, WIRE	73
	-	1	1	1	1	1803607-2	DOCUMENTATION PACKAGE	71
	-	2	2	2	2	2-18032-2	SCR, SET, FLT PNT, M3 X 10.0	70
	-	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	1901681-1	HOLDDOWN, TERMINAL	65
	-	2	2	2	2	2168400-8	SHCS, LOW HEAD, RoHS, M4 X 16	64
	-	1	1	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	2063961-1	FEED FINGER	58
	-	3	3	3	3	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57
	-	2	2	2	2	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	56
	-	2	2	2	2	5018030-1	NUT, HEX, REG, RoHS, M3	54
	-	2	2	2	2	986965-8	NUT, LOCK, HEX, TORQUE (M4)	53
	-	1	1	1	1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52
	-	1	-	1	-	2119792-2	PAWL, EF, AIR	51
	-	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	2119655-5	APPLICATOR BASIC ASSEMBLY, EF	46
	-	1	1	1	1	1803517-1	RAM ASSEMBLY, EF ATLANTIC	44
	-	1	1	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
	-	7	7	7	7	1-18028-2	WASHER, FLAT, REG M4	33
	-	2	2	2	2	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	31
	-	2	2	2	2	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	29
	-	1	1	1	1	240639-1	STRIPPER (MACHINING)	27
	-	2	2	2	2	1-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 30	25
	-	1	1	1	1	1752371-5	PLATE, STRIP GUIDE	24
	-	1	1	1	1	240825-7	PLATE, STRIP HOLD DOWN	23
	-	2	2	2	2	2-22281-3	SPRING, COMPRESSION	22
	-	1	1	1	1	1803292-4	DRAG	20
	-	2	2	2	2	1901259-3	GUIDE, LOWER STRIP	18
	-	4	4	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17
	-	1	1	1	1	1752360-1	SPACER,HOLD-DOWN	13
1	-	1	1	1	1	240644-9	PLATE, REAR SHEAR	11
	-	-	-	-	-	-	-	10
1	-	1	1	1	1	2-690495-6	PLATE, FRONT SHEAR	9
1	1	2	2	1	1	1633384-5	ANVIL, COMBINATION	8
1	-	1	1	1	1	1-2217206-3	BLADE, SLUG	7
	-	-	-	-	-	-	-	6
	-	1	1	1	1	8-240641-8	SPACER	5
	-	1	1	1	1	4-238011-5	BLOCK, CRIMPER SPACER	4
1	1	2	2	1	1	2-2119784-3	CRIMPER, INSULATION O PREMIUM	3
	-	-	-	-	-	-	-	2
1	1	2	2	1	1	1-456406-2	CRIMPER, WIRE PREMIUM	1
	-77	-72	-71	-2	-1	PART NO	DESCRIPTION	ITEM NO

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				CHK U. GUO 06MAR2013	APVD J. CRUZ 06MAR2013	NAME Ocean End Feed Applicator		
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		PRODUCT SPEC		APPLICATION SPEC		
		0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		-		-		
FINISH		-		WEIGHT		-		
MATERIAL		-		SIZE		A1		
		-		CAGE CODE		00779		
		-		DRAWING NO		C=2150086		
		-		RESTRICTED TO		-		
Customer Accessible Production Drawing						SCALE 1:1 SHEET 1 OF 4 REV C		

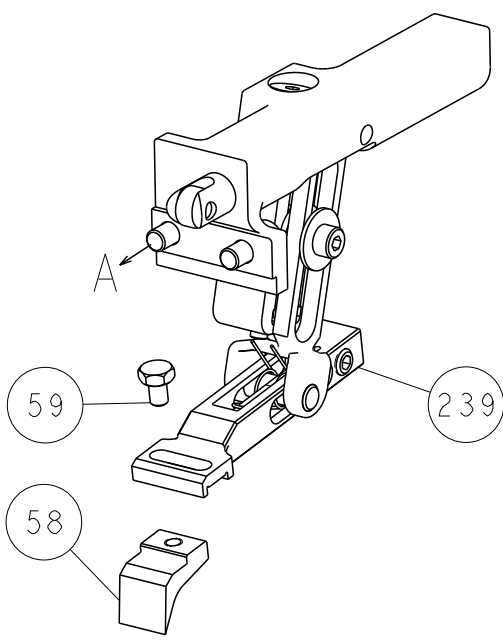
SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

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A	66	P	LTR	DESCRIPTION	DATE	DWN	APVD
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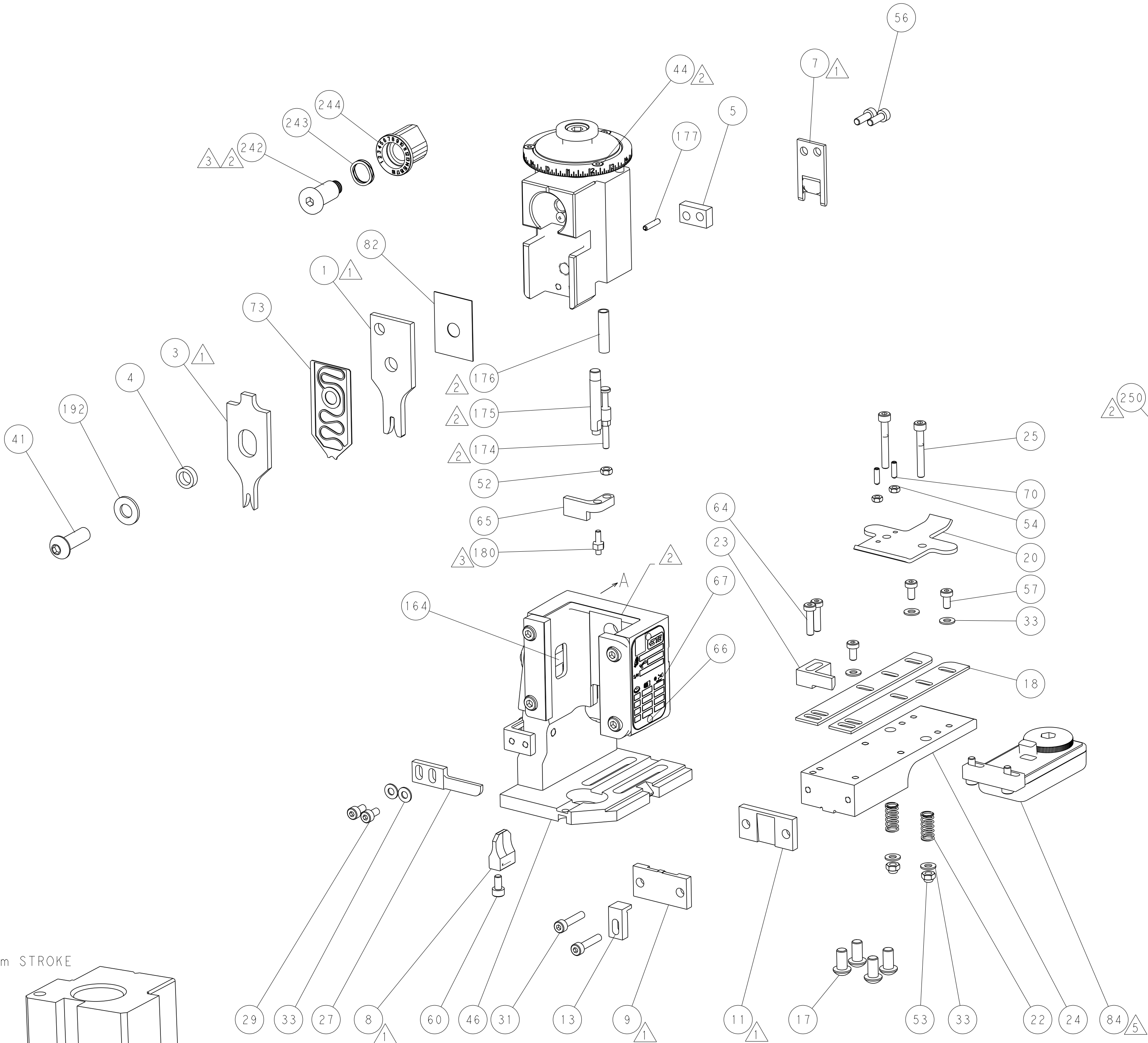
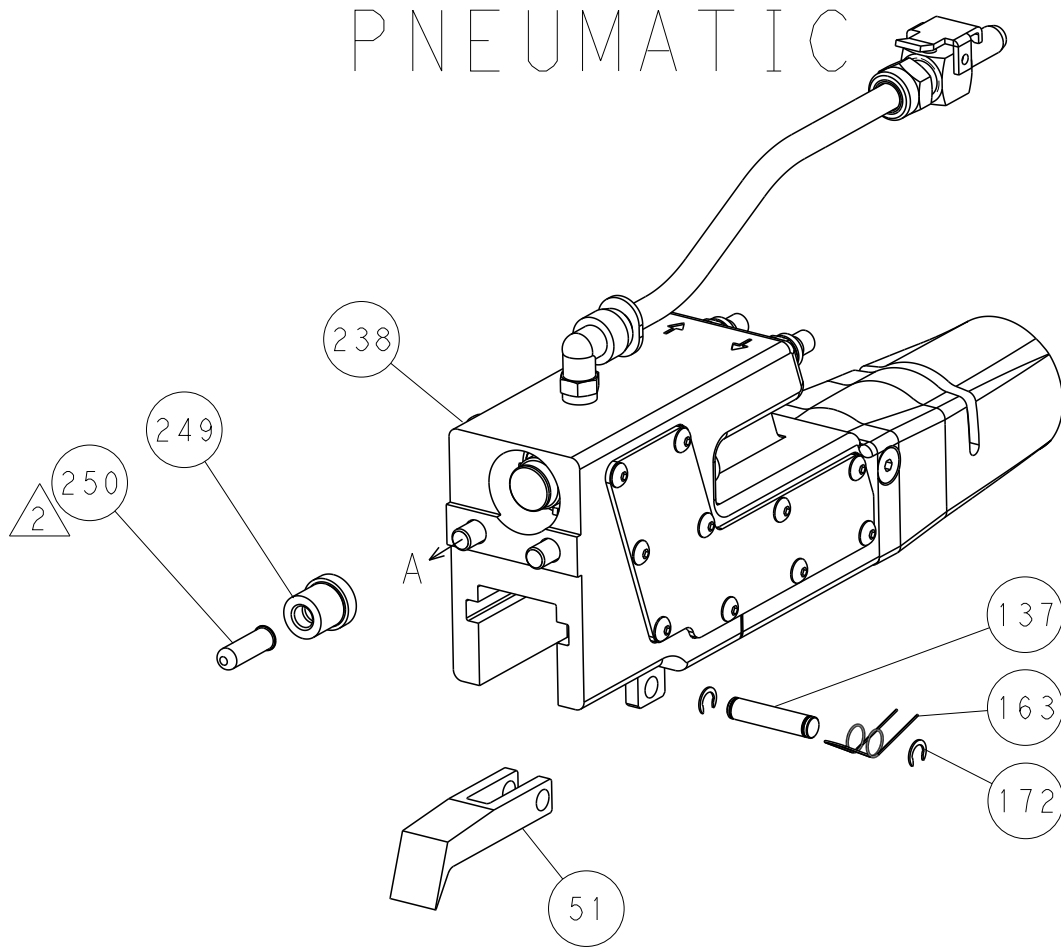


HOLD-DOWN AND RAM SET-UP

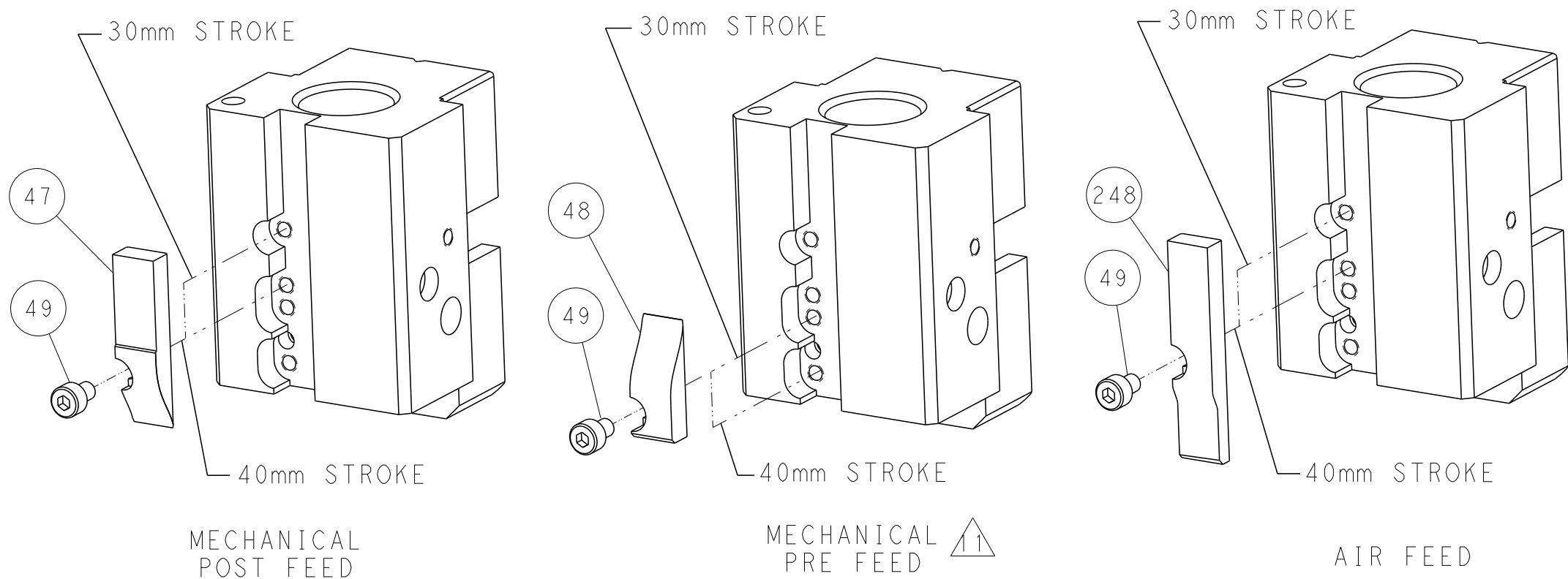
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MECHANICAL



PNEUMATIC



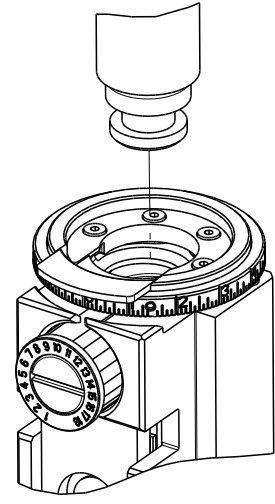
CAM POSITIONS



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

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				CHK U. GUO 06MAR2013		
				APVD J. CRUZ 06MAR2013	NAME Ocean End Feed Applicator	
				PRODUCT SPEC		
				APPLICATION SPEC		
				WEIGHT		
				Customer Accessible Production Drawing		
				SCALE 1:1	SHEET 2 of 4	
					REV C	

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150086-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2150086-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150086-7	A	CRIMP TOOLING KIT	-



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.29 mm [.090]	F
INSUL	2.54 mm [.100]	O
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: .250 SERIES FASTON RECEPTACLE			
WIRE STRIP LENGTH .205-.235 IN [5.21-5.97 mm]		INSULATION DIAMETER RANGE Ø.060-.087 IN [1.52-2.21 mm]	
TERMINAL APPLICATION 		114-2036	
SPECIFICATION		-	
TERMINALS APPLIED 		-	
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
62866-1	42640-1	42640-2	

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING
18 AWG		1.42+/-0.05 [0.056+/-0.002]		4.3
20 AWG		1.30+/-0.05 [0.051+/-0.002]		5.6
22 AWG or 0.35mm2		1.24+/-0.05 [0.049+/-0.002]		6.3

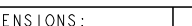


- ① RECOMMENDED SPARE PARTS
 - ② REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
 - ③ APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242.
APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 180.
 - ④ CRIMP HEIGHT REFERENCE SETTING WAS THE SETTING USED 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.

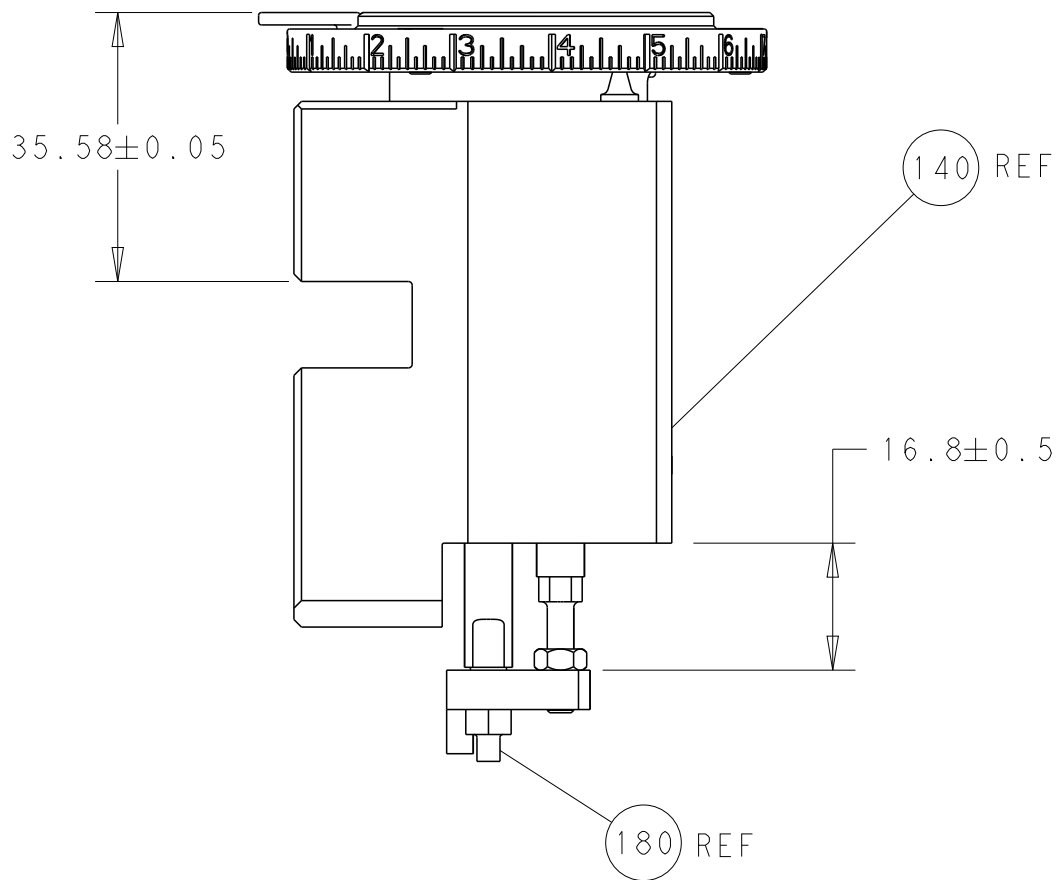
*WARNING
ON INSTALLATION, SET WIRE DISC TO CRIMP HEIGHT REFERENCE
SETTING FOR LARGEST WIRE SIZE. CRIMP HEIGHT REFERENCE
SETTINGS GREATER THAN THE VALUE SHOWN MAY CAUSE DAMAGE TO
THE CRIMP TOOLING. REFER TO THE INSTRUCTION SHEET FOR
PROPER SETUP AND ADJUSTMENTS.

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

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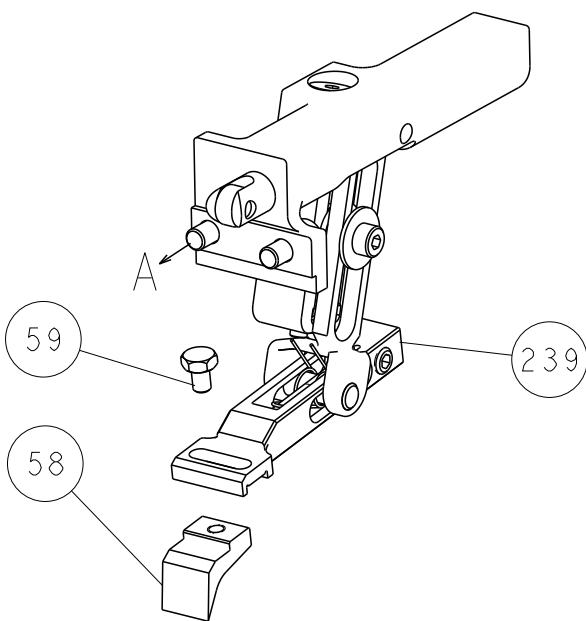
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DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		NAME Ocean End Feed Applicator -	
		PRODUCT SPEC - APPLICATION SPEC -		SIZE CAGE CODE DRAWING NO A1 00779 C=2150086	
MATERIAL -		FINISH - WEIGHT -		RESTRICTED TO - REV C	
Customer Accessible Production Drawing				SCALE 1:1 SHEET 3 OF 4	

LOC		DIST		REVISONS			
P	LTR	DESCRIPTION		DATE		DWN	
		-	SEE SHEET 1	-	-	-	-

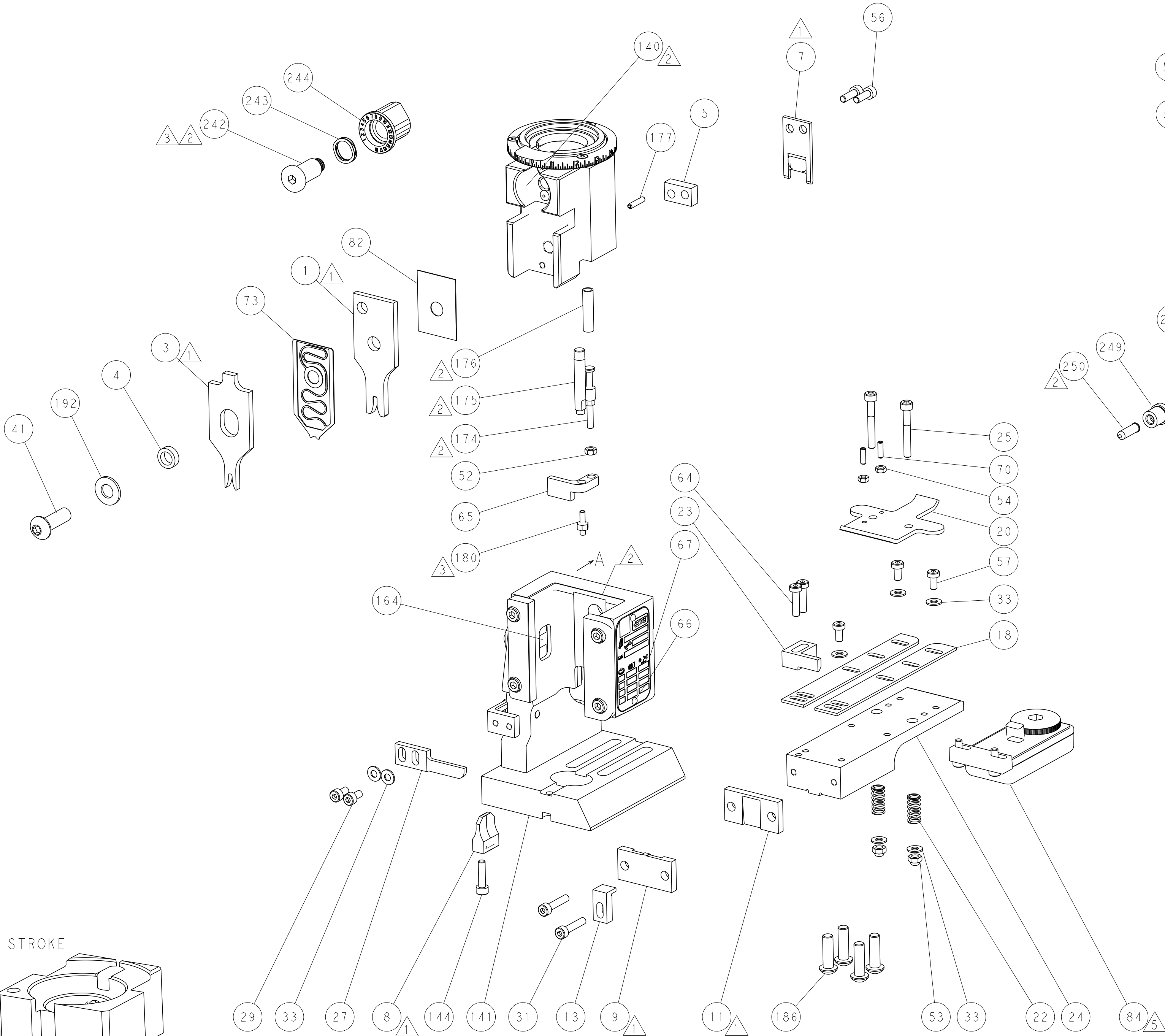
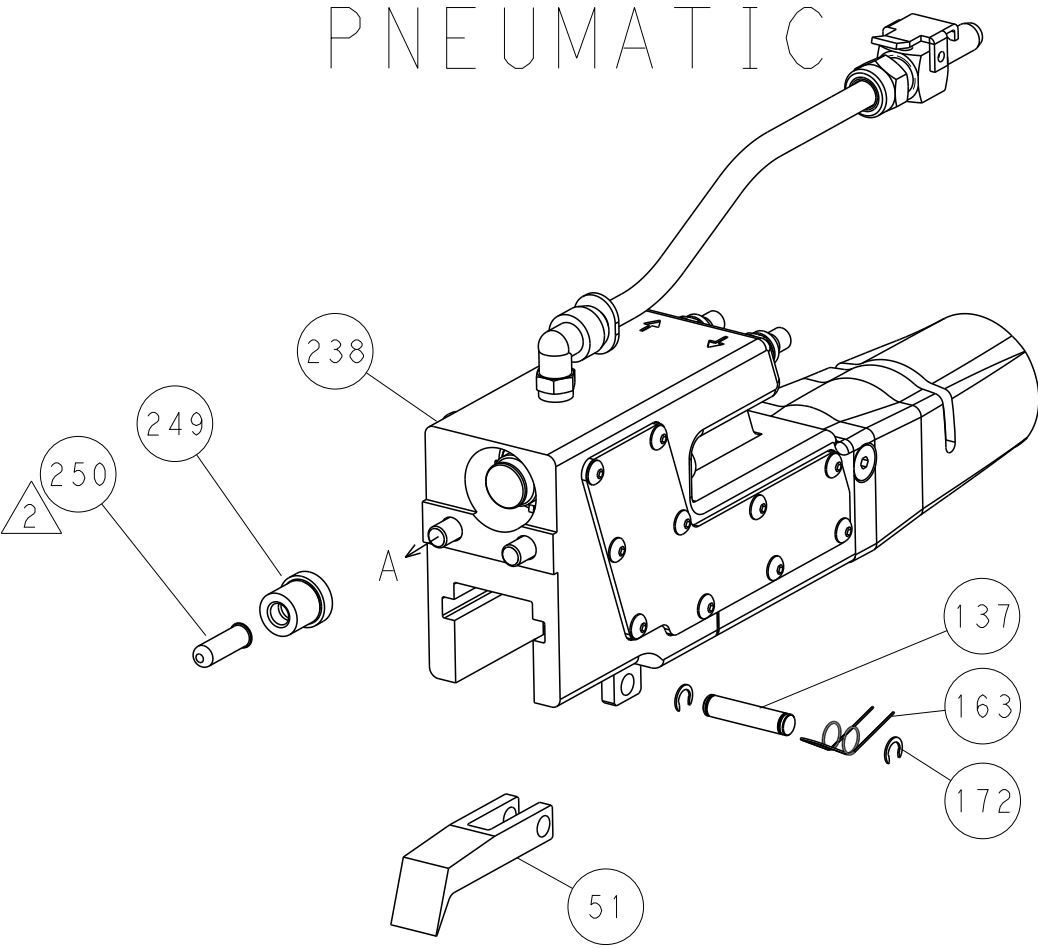


HOLD-DOWN AND RAM SET-UP

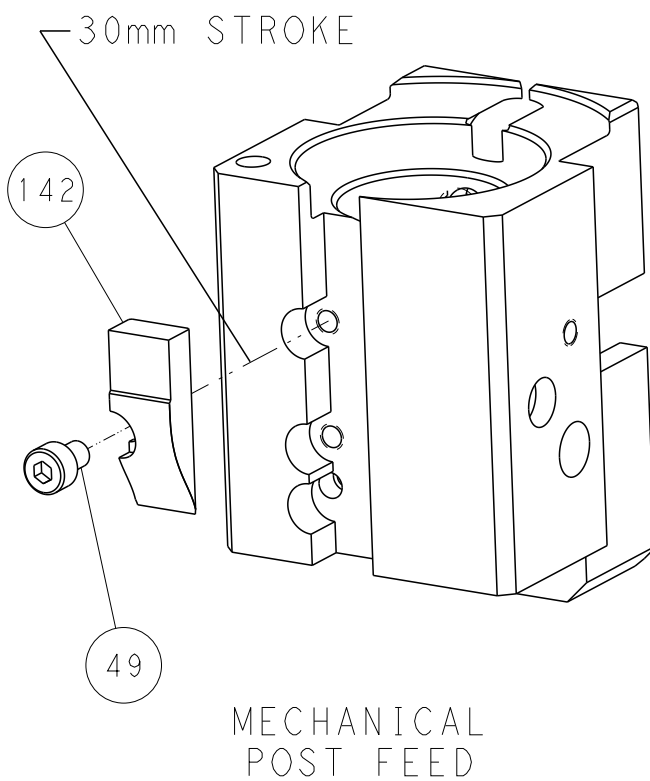
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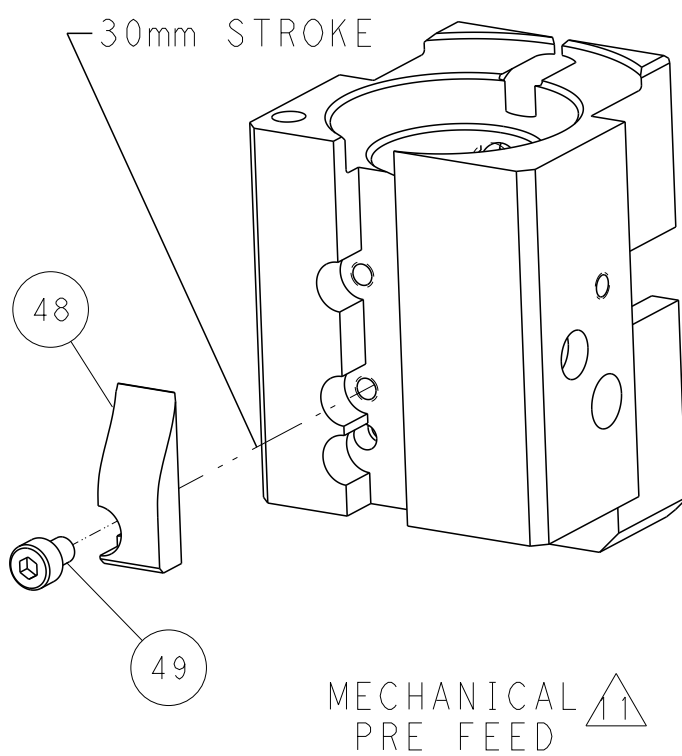
PNEUMATIC



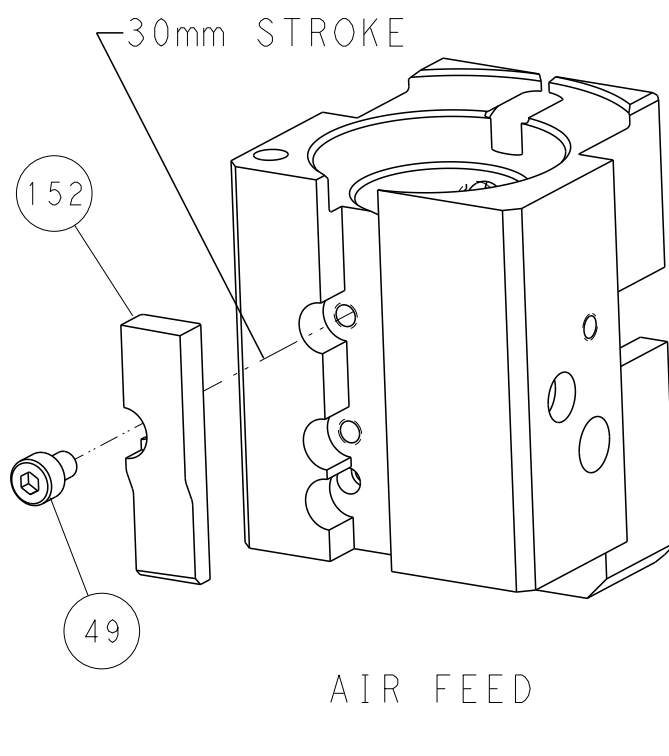
CAM POSITIONS



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)

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CHK U. GUO 06MAR2013				APVD J. CRUZ 06MAR2013		NAME Ocean End Feed Applicator	
DIMENSIONS: mm				TOLERANCES UNLESS OTHERWISE SPECIFIED:		SIZE A1	
0 PLC 1 PLC 2 PLC 3 PLC 4 PLC ANGLES FINISH				± ± ± ± ± ± ±		DRAWING NO 00779	
MATERIAL -				WEIGHT -		CAGE CODE 2150086	
Customer Accessible Production Drawing				SCALE 1:1		SHEET 4	
						OF 4	
						REV C	

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[2-2150086-1](#)