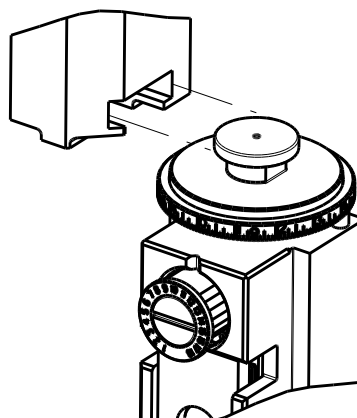


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ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART						
					CONVERT TO	PART NUMBERS REQUIRED					
	2150715-1	D	FINE CRIMP HEIGHT ADJUST	MECHANICAL	PNEUMATIC FEED	2119950-1	2119792-2	-	2119641-1	-	2063440-1
					SERVO LATCH PLATE	2119951-1	1901697-1	8-2150715-5	-	-	2168400-7 (QUANTITY 2)
	SMART APPLICATOR	2161326-1	-	8-2150715-4	-	-	-				
	MECHANICAL FEED	2119949-1	2063961-1	5-18022-5	2119653-1	-	-				
	SERVO LATCH PLATE	2119951-1	1901697-1	8-2150715-5	-	-	2168400-7 (QUANTITY 2)				
	SMART APPLICATOR	2161326-1	-	8-2150715-4	-	-	-				
	MECHANICAL FEED	2119949-1	2063961-1	5-18022-5	2119653-1	-	-				
	PNEUMATIC FEED	2119950-1	2119792-2	-	2119641-1	-	2063440-1				
	-	-	-	-	-	-	-				
	-	-	-	-	-	-	-				
2150715-5	D	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE 	PNEUMATIC FEED	2119950-1	2119792-2	-	2119641-1	-	2063440-1	
2150715-6	D	NON-CRIMP HEIGHT ADJUST	 SERVO LATCH PLATE 	-	-	-	-	-	-	-	
2150715-7	D	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	-	
7-2150715-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-	

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.79 mm [.110]	F
INSUL	-	-

APPL INSTRUCTIONS
408-10390



TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: TAB, RIGHT ANGLE, POKE IN, MAG-MATE			
WIRE STRIP LENGTH 3.94-4.70 mm [.155-.185 IN]		INSULATION DIAMETER RANGE Ø	
TERMINAL APPLICATION SPECIFICATION		114-2050	
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
1217406-1	1217406-3	1217208-1	1217208-2
1217406-2			

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING
16 AWG OR 1.30mm2		1.75+/- 0.05 [.069+/- .002]		4.5
18 AWG OR 0.80mm2		1.65+/- 0.05 [.065+/- .002]		5.5
20 AWG OR 0.50mm2		1.50+/- 0.05 [.059+/- .002]		7.2



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: 8-2150715-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150715-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150715-5
SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2150715-6
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.
FOR -6 ONLY APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 37.
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
13. TERMINAL LUBRICANT IS RECOMMENDED.
14. TERMINAL FLAG ON THE RIGHT SIED.

2				I				
SET UP GAUGE	LOC	DIST	REVISIONS					
2119599-2	A	66	P	LTR	DESCRIPTION	DATE	DWN	APVD
				A	RELEASED	23SEP2016	JH	CT
				B	ECR-17-004320	24MAR2017	TB	GB
				C	ECR-18-012446	06AUG2018	YY	CT
				D	ECR-19-000347	09JAN2019	FJ	YY

7	-	-	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	-	1803259-1	BUSHING, FLANGED	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	
	-	-	2	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	1	-	-	2119740-2	TAG, IDENTIFICATION	213	
	-	-	REF	REF	-	-	1901697-1	FEED FINGER ASSEMBLY,EF	18	
	-	-	-	-	2	-	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172	
	-	1	1	1	1	1	994969-1	MAGNET, RARE EARTH HIGH ENERGY	166	
	-	REF	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164	
	3	-	-	-	-	1	-	240638-1	SPRING, FEED FINGER	163
-		-	-	-	1	-	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854	137	
-		-	REF	REF	-	-	SEE NOTE 4	MEMORY CHIP, PROGRAMMED	135	
-		-	1	1	-	-	1633743-1	SERVO FEED LATCH ASM	133	
-		1	1	1	1	1	2119955-2	ASSY, LUBRICATOR, END FEED	84	
-		1	1	1	1	1	455888-7	SPACER, CRIMPER	82	
-		1	1	1	1	1	2119956-2	DOCUMENTATION PACKAGE	71	
-		2	2	2	2	2	2-18032-2	SCR, SET, FLT PNT, M3 X 10.0	70	
-		1	-	-	1	1	2119740-1	TAG, IDENTIFICATION	67	
-		2	2	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66	
-		1	-	1	1	1	2119793-1	LIMITER, ADJUSTMENT BOLT	63	
6		-	3	-	3	3	3	992763-5	SCR, SET, SOC, CONE PNT, M3 x 4.0	62
		-	1	1	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
		-	4	4	4	4	4	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57
		-	2	2	2	2	2	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	56
	-	2	2	2	2	2	5018030-1	NUT, HEX, REG, RoHS, M3	54	
	-	2	2	2	2	2	986965-8	NUT, LOCK, HEX, TORQUE (M4)	53	
	-	-	-	-	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	1	1	2119655-5	APPLICATOR BASIC ASSEMBLY, EF	46	
	-	1	-	1	1	1	2119369-1	RAM, AMP STYLE, END FEED	44	
	-	1	1	1	1	1	2079383-7	SCR, BHSC, RoHS (M8 X 25)	41	
	-	1	-	1	1	1	2119645-1	DISC, NUMBERED FA WIRE ADJUSTMENT	40	
	7	-	1	-	1	1	1	2119957-1	APPLICATOR SHIM PACK	39
-		1	1	1	1	1	1-2119644-2	RAM WASHER, PRECISION	38	
-		1	1	1	1	1	2119085-1	FA HEAD, ATLANTIC STYLE	37	
-		1	-	1	1	1	2119092-1	BOLT, ADJUSTMENT	35	
-		8	8	8	8	8	1-18028-2	WASHER, FLAT, REG M4	33	
-		2	2	2	2	2	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	31	
-		2	2	2	2	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	29	
-		1	1	1	1	1	240639-1	STRIPPER (MACHINING)	27	
-		2	2	2	2	2	1-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 30	25	
-		1	1	1	1	1	1752371-1	PLATE, STRIP GUIDE	24	
-		2	2	2	2	2	2-22281-3	SPRING, COMPRESSION	22	
-		1	1	1	1	1	1803292-1	DRAG	20	
-		1	1	1	1	1	2-1901696-7	STRIP GUIDE, REAR	19	
-		1	1	1	1	1	2-1901695-7	STRIP GUIDE, FRONT	18	
-		4	4	4	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17	
-		1	1	1	1	1	240644-1	PLATE, REAR SHEAR	11	
1		-	2	2	2	2	2	8-240645-9	SPACER, SHEAR PLATE	10
	-	1	1	1	1	1	240642-1	PLATE, FRONT SHEAR	9	
	1	1	1	1	1	1	2-1803002-5	ANVIL, COMBINATION, END FEED	8	
	-	1	1	1	1	1	1803366-7	BLADE, SLUG -	7	
	-	-	-	-	-	-	-	-	6	
	-	1	1	1	1	1	6-240641-7	SPACER	5	
	-	-	-	-	-	-	-	-	4	
	-	-	-	-	-	-	-	-	3	
	-	-	-	-	-	-	-	-	2	
	1	1	1	1	1	1	1-456408-7	CRIMPER, WIRE PREMIUM	1	
	-77	-7	-6	-5	-2	-1	PART NO	DESCRIPTION	ITEM NO	

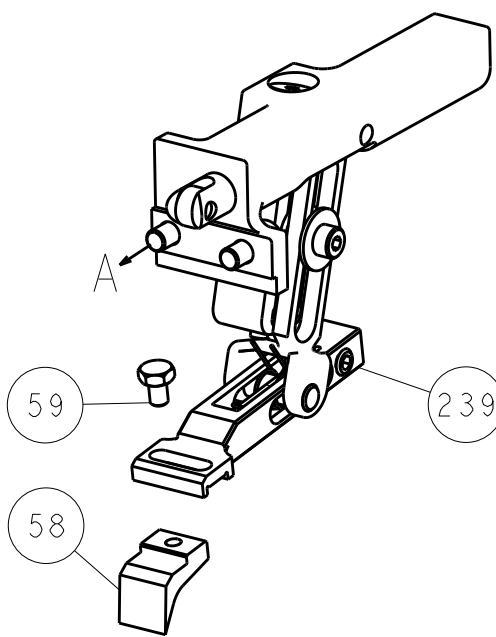
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						CHG ZHANG		11AUG2016		Harrisburg PA 17105-3608			
DIMENSIONS: mm						TOLERANCES UNLESS OTHERWISE SPECIFIED:						NAME	
						PRODUCT SPEC						Ocean End Feed Applicator	
						APPLICATION SPEC						-	
MATERIAL						WEIGHT						SIZE CAGE CODE DRAWING NO	
FINISH						Customer Accessible Production Drawing						A 00779 C=2150715	
SCALE						SHEET						REV D	

SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

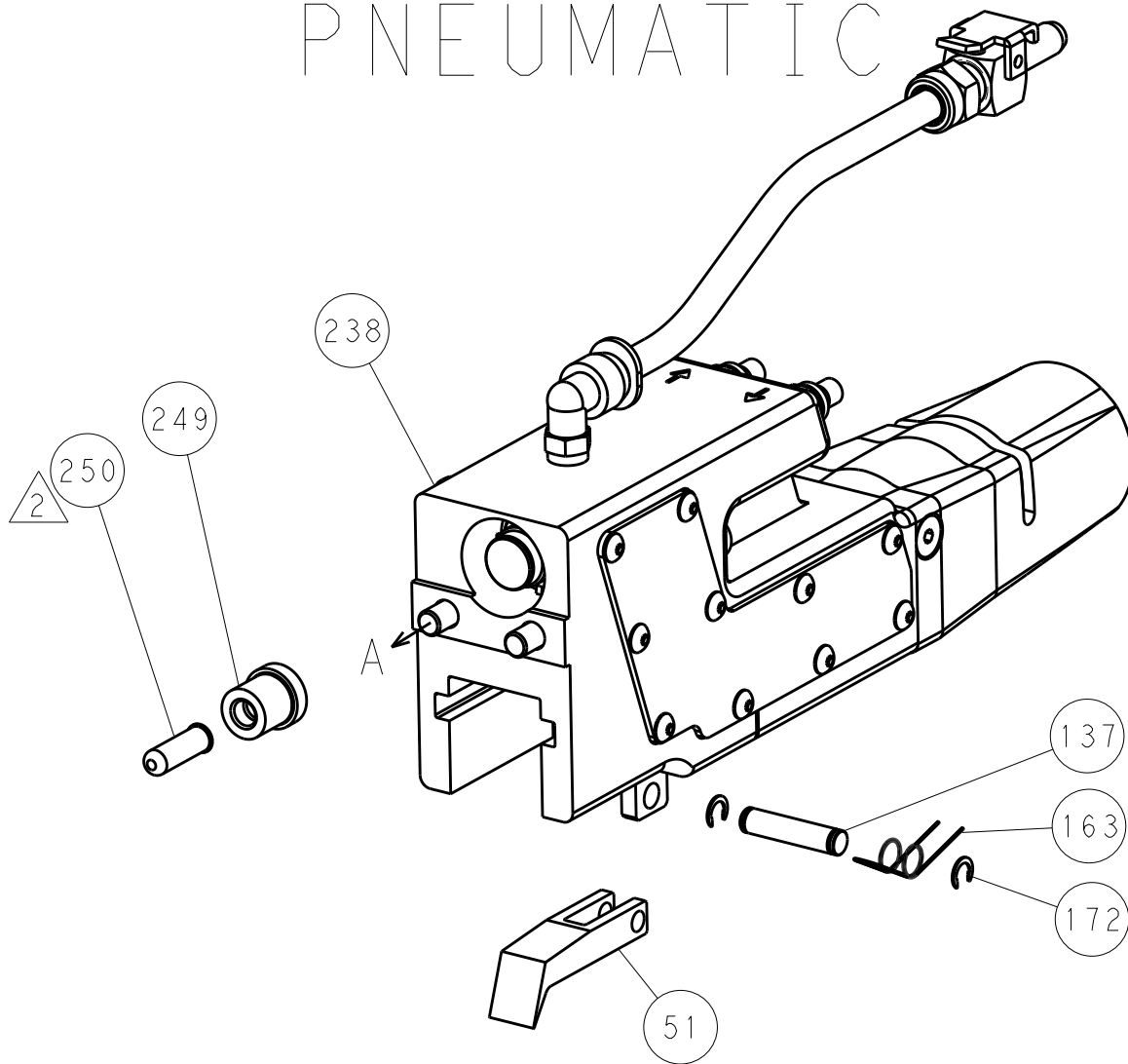
AMP 4805 REV 31MAR2000

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		-		SEE SHEET 1	-	-	-

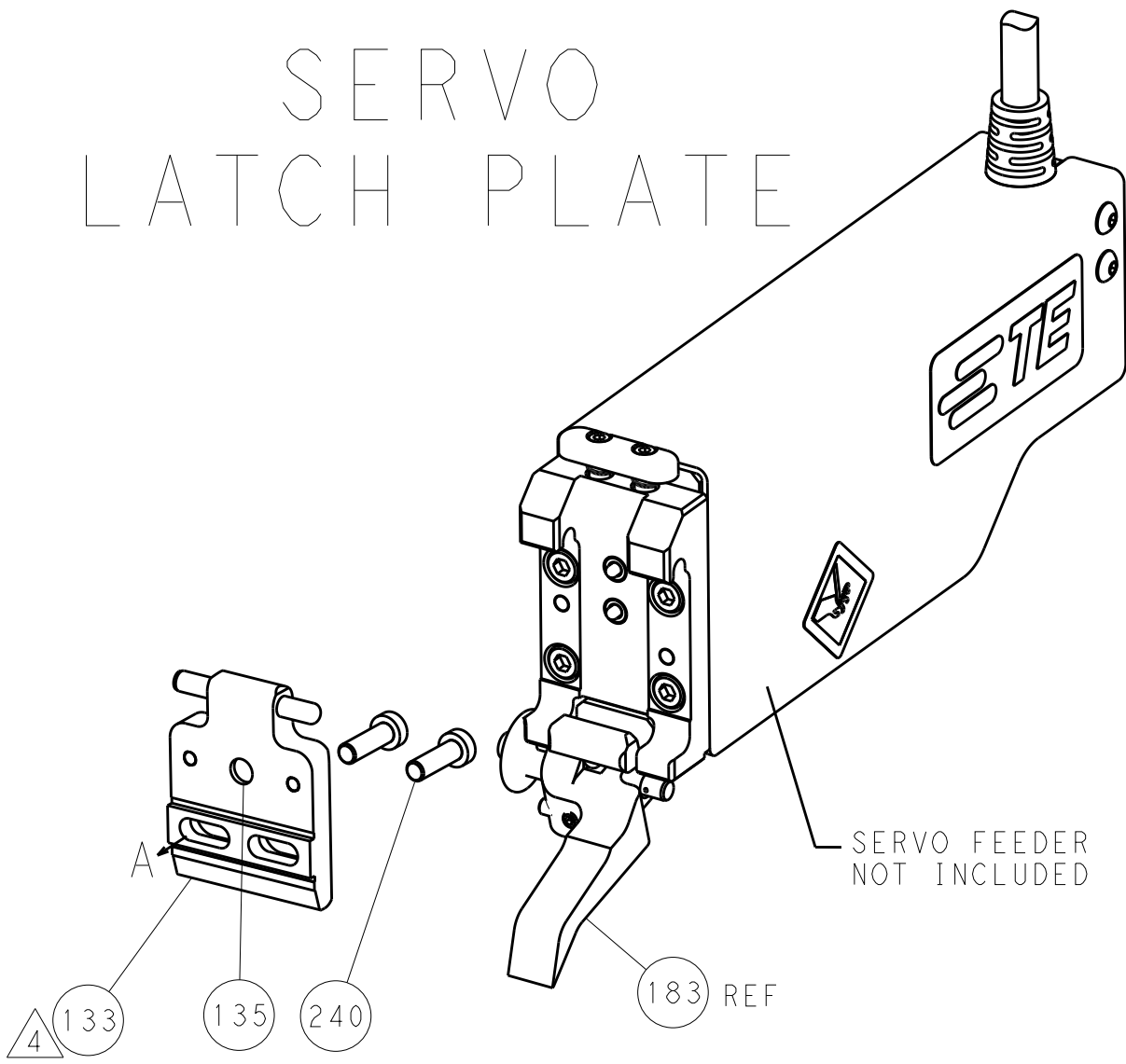
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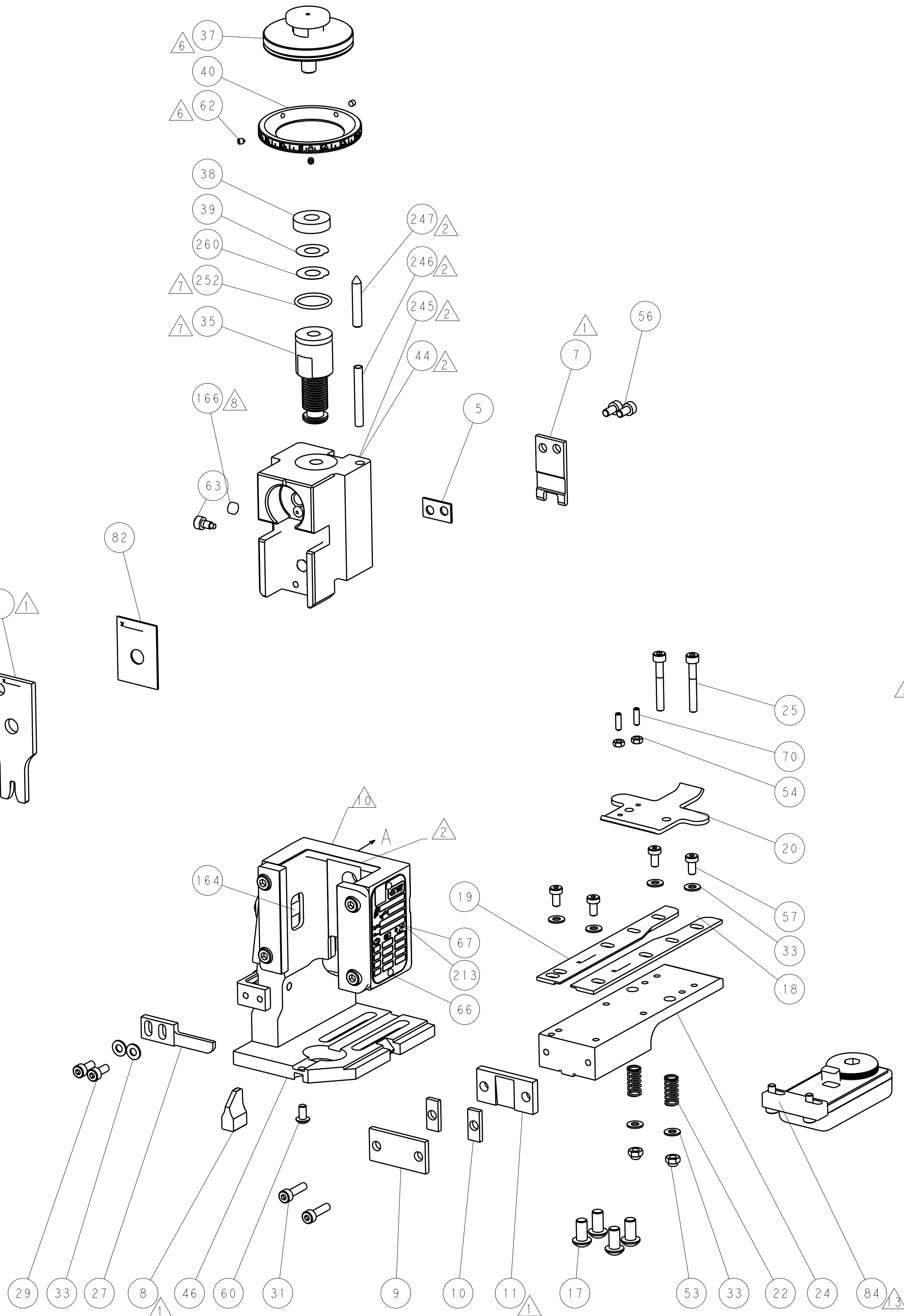
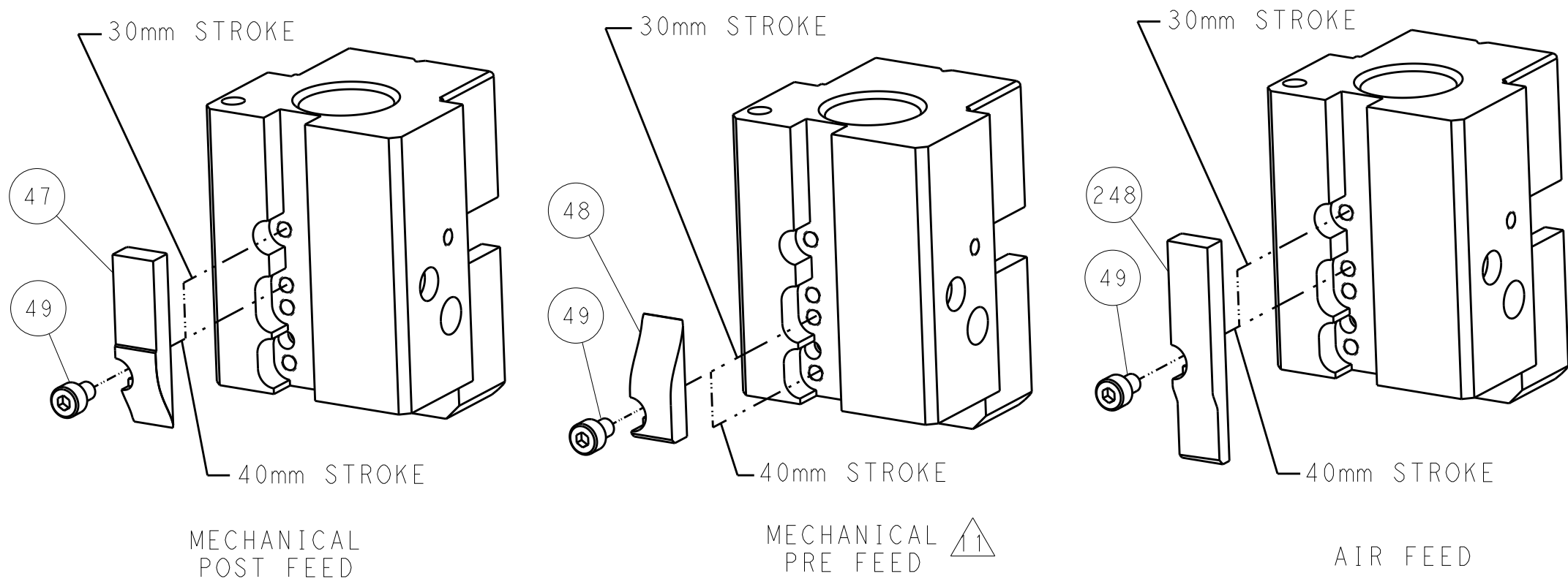
PNEUMATIC



SERVO
LATCH PLATE



CAM POSITIONS

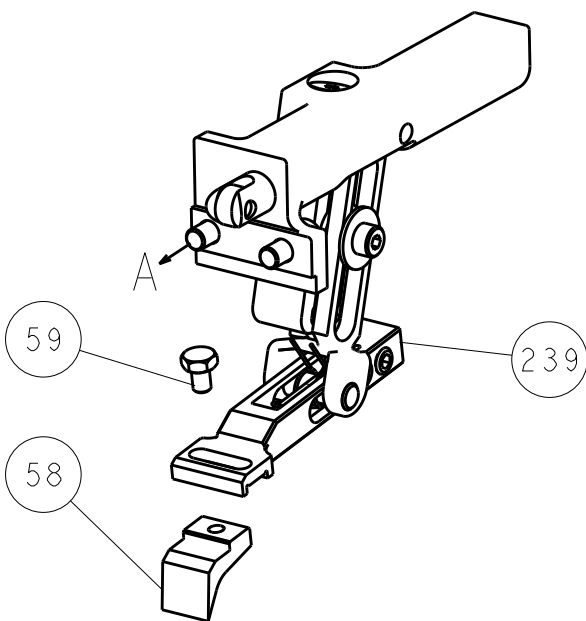


ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

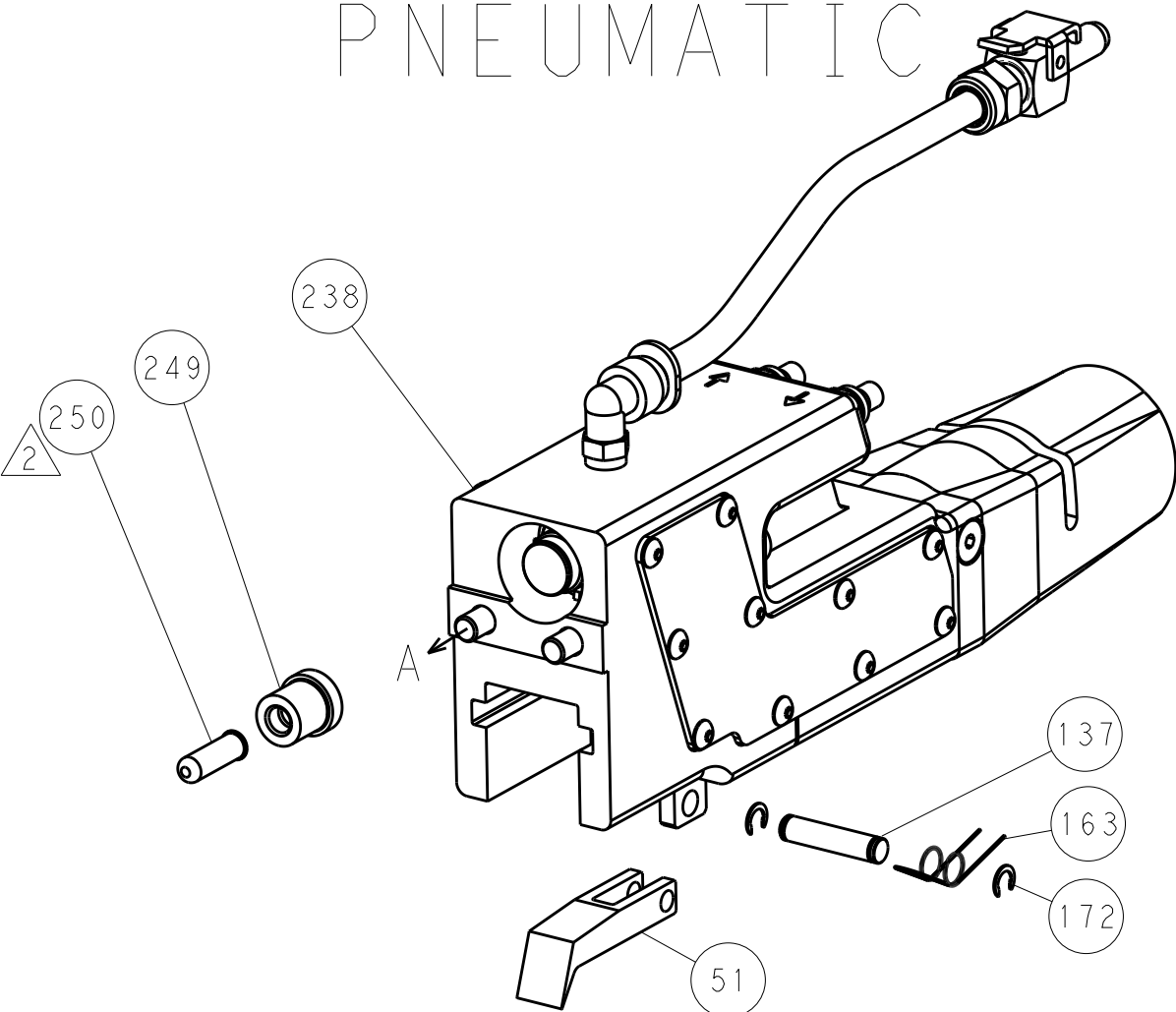
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CHK L. ZHANG 11AUG2016		NAME Ocean End Feed Applicator	
APVD L. ZHANG 11AUG2016		PRODUCT SPEC	
		APPLICATION SPEC	
		SIZE A1	CAGE CODE 00779
		DRAWING NO. C=2150715	RESTRICTED TO -
MATERIAL -		WEIGHT -	SCALE 1:1
		Customer Accessible Production Drawing	SHEET 2 OF 4
			REV D

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

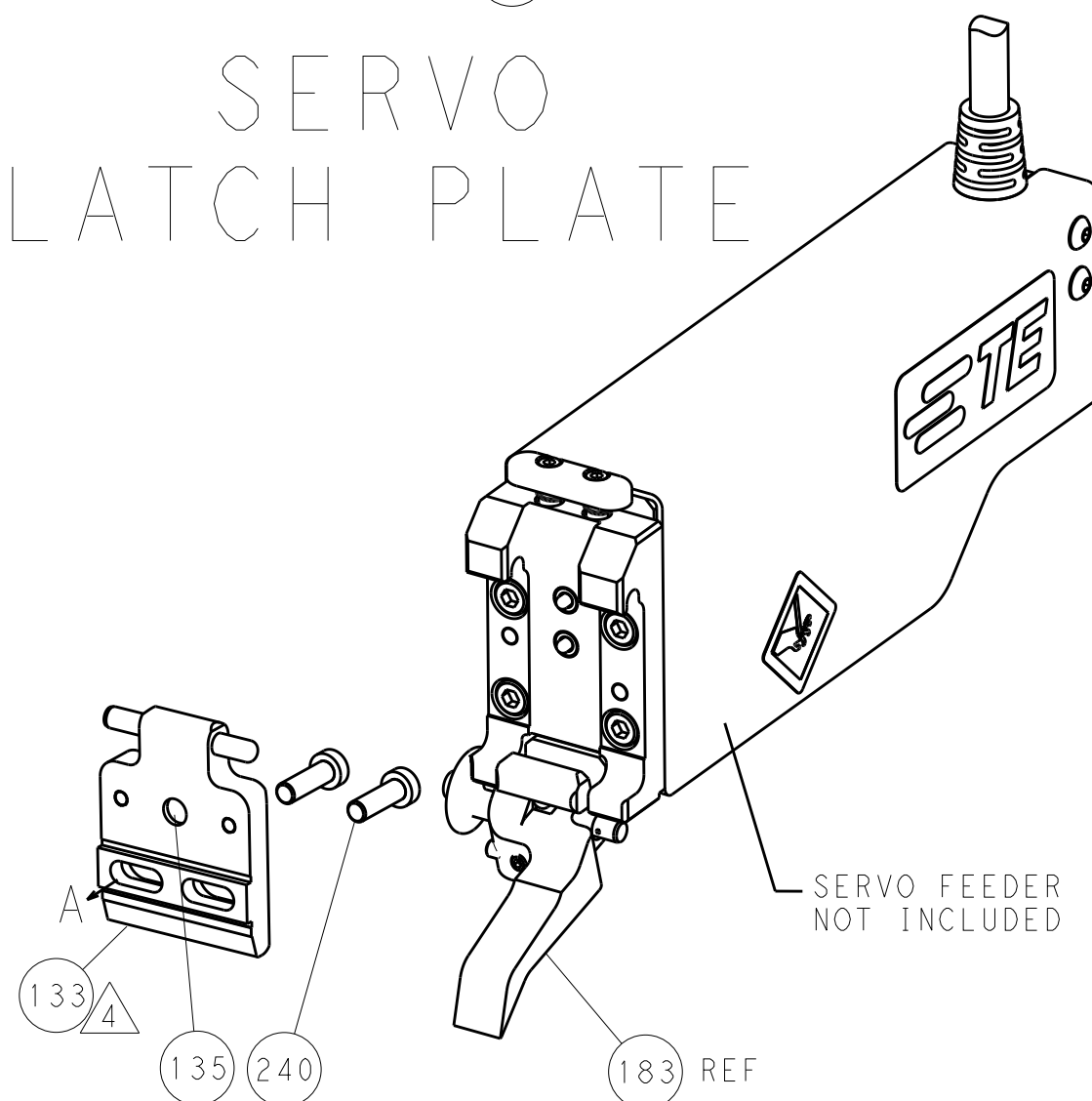
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MECHANICAL



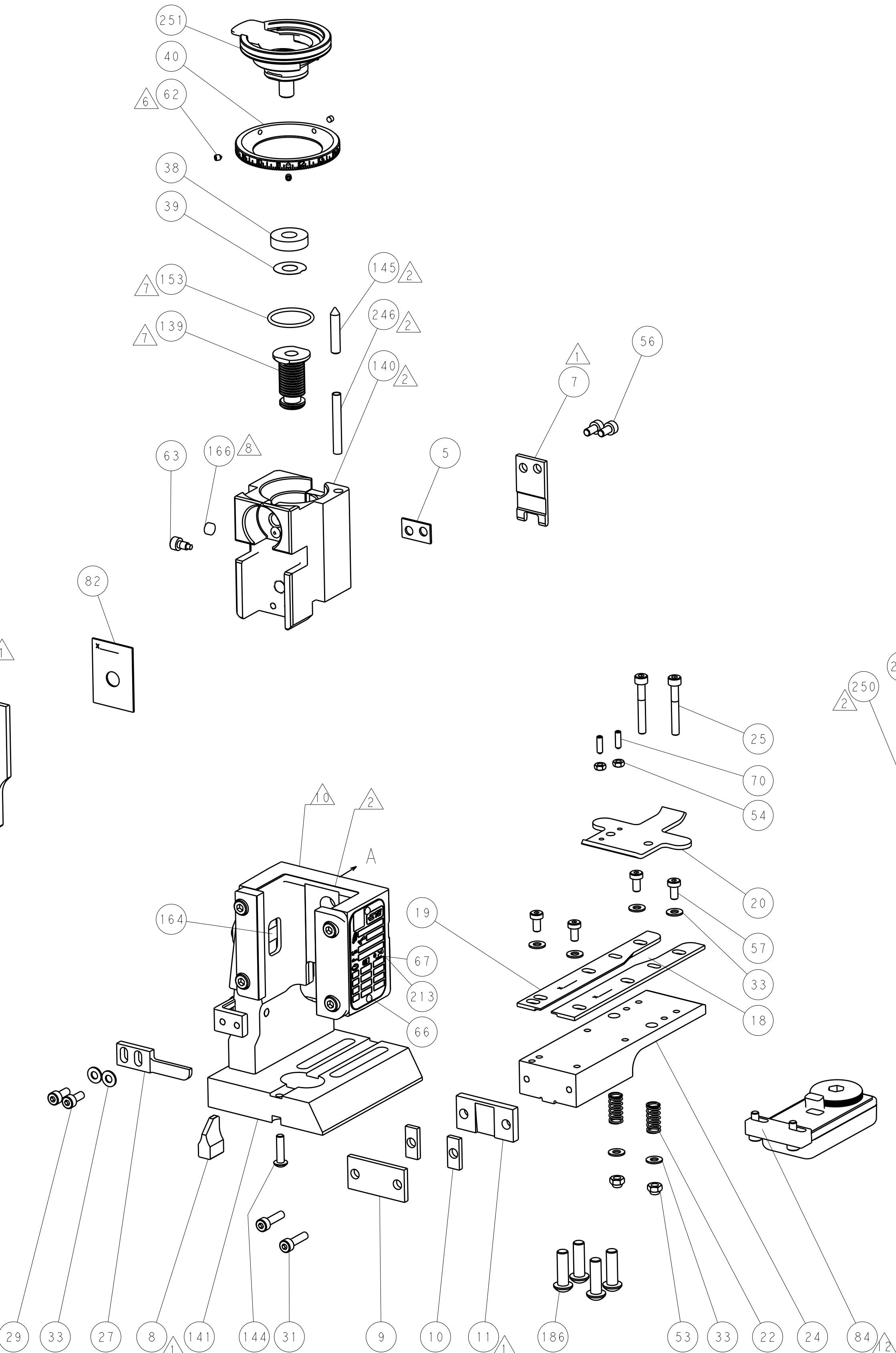
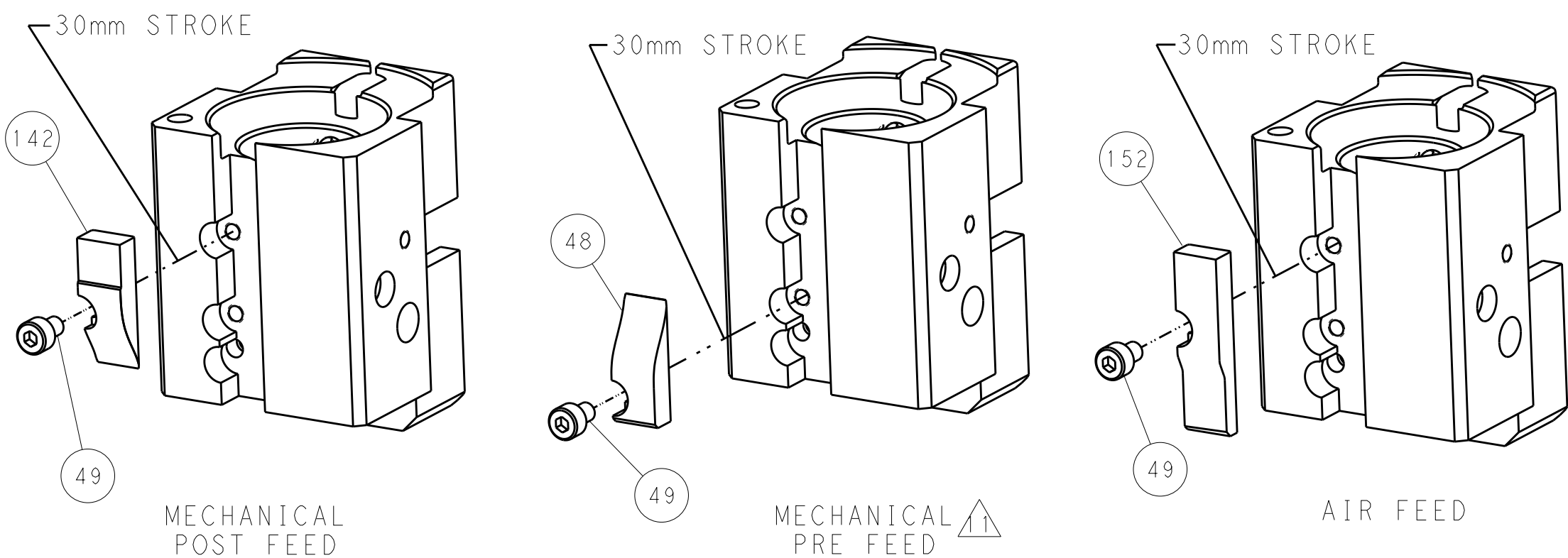
PNEUMATIC



SERVO
LATCH PLATE



CAM POSITIONS



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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DIMENSIONS:				CHK L. ZHANG 11AUG2016				NAME Ocean End Feed Applicator			
mm				APVD L. ZHANG 11AUG2016				SIZE CAGE CODE DRAWING NO			
0 PLC ±				PRODUCT SPEC				RESTRICTED TO			
1 PLC ±				APPLICATION SPEC				A 00779 C=2150715			
2 PLC ±				WEIGHT				SCALE 1:1			
3 PLC ±				MATERIAL				SHEET 4 OF 4			
4 PLC ±				FINISH				REV D			
ANGLES				Customer Accessible Production Drawing							

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