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1

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RELEASED FOR PUBLICATION

20

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ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER

PART NUMBER

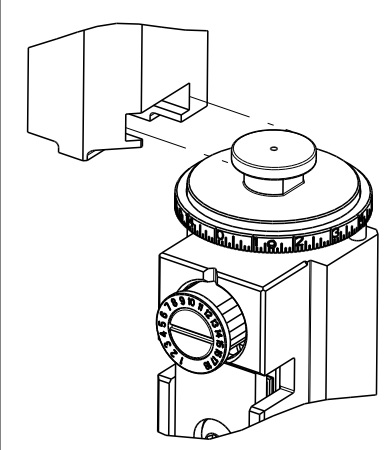
REVISION

DESCRIPTION

FEED TYPE

CONVERT TO

PART NUMBERS REQUIRED



2266397-1

A

FINE CRIMP HEIGHT ADJUST

MECHANICAL

PNEUMATIC FEED

2119950-1

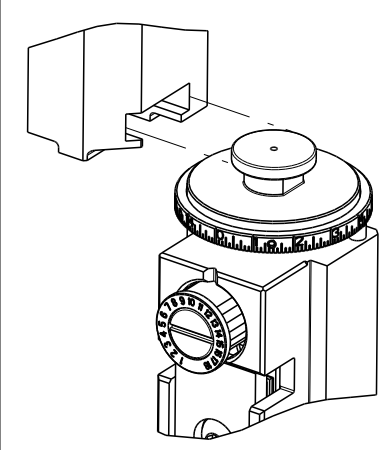
1338685-1

5-18022-5

2119641-1

2119799-1

2063440-1



2266397-2

A

FINE CRIMP HEIGHT ADJUST

PNEUMATIC

SERVO LATCH PLATE

2119951-1

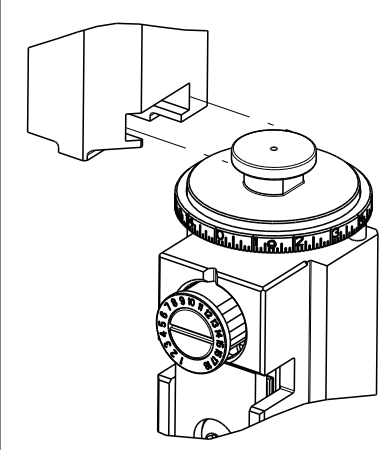
-

8-2266397-5

1901094-3

-

2168400-6 (QUANTITY 2)



2266397-5

A

FINE CRIMP HEIGHT ADJUST

SERVO LATCH PLATE

4

2119949-1

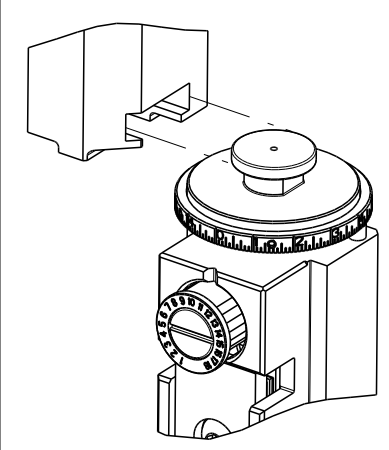
1338685-1

5-18022-5

2119653-1

-

-



2266397-6

A

NON-CRIMP HEIGHT ADJUST

SERVO LATCH PLATE

4

12

2119951-1

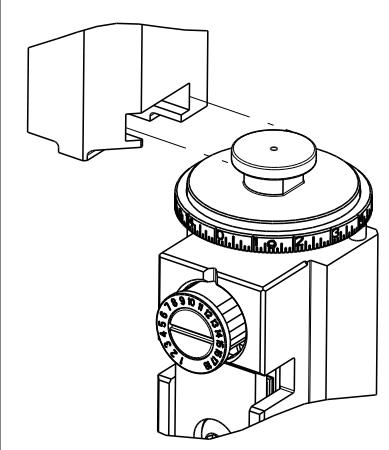
-

8-2266397-5

1901094-3

-

2168400-6 (QUANTITY 2)



2266397-7

A

FINE CRIMP HEIGHT ADJUST

NONE

-

-

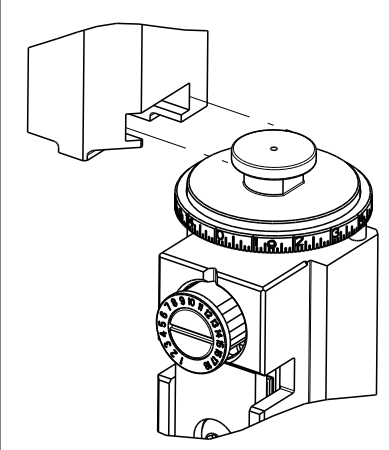
-

-

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-

-



7-2266397-7

A

CRIMP TOOLING KIT

-

-

-

-

-

-

-

APPLICATOR DATA

CRIMP SIZE TYPE

WIRE 1.65 mm [.065] F

INSUL 3.94 mm [.155] O

APPLICATOR INSTRUCTIONS 408-10389

TERMINAL DATA: HULANE TERMINAL TE CRIMP SPECIFICATION

TERMINAL NAME: TERMINAL

WIRE STRIP LENGTH 4.96-5.72 mm [.195-.225 IN]

INSULATION DIAMETER RANGE

TERMINAL APPLICATION SPECIFICATION

TERMINALS APPLIED

TE TERMINAL

HULANE TERMINAL

TE SEAL

HULANE SEAL

CABLE DIAMETER

WIRE SIZE

CRIMP HEIGHT mm [INCH]

CRIMP HEIGHT REFERENCE SETTING

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: 8-2266397-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2266397-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2266397-5
SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2266397-6

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 ITEM 62. APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242. FOR -6 ONLY APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 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 TO CONVERT THE APPLICATOR TO A NON-CARRIER CUTTING STYLE, REMOVE ITEM 13 AND ATTACH TO THE LOCATION ON THE BACK SIDE OF THE HOUSING. REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.

12 WHEN ASSEMBLING A NON CRIMP HEIGHT ADJUST APPLICATOR (-6) USE SHIMS FROM ITEM 260 TO ACHIEVE A NOMINAL SHIM HEIGHT OF 4.85. THIS APPLICATOR APPLIES TERMINAL WITH A SEAL.

14 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.

*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

-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 2119599-1

LOC A

DIST 66

REVISIONS

DESCRIPTION

DATE

OWN

APVD

- - - - 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 - - - 2119758-1 RAM, AMP STYLE, SIDE FEED, NON-ADJ. 245

- 1 1 1 1 1 2119082-3 CAM, SNAIL, INSULATION ADJUSTMENT 244

- 1 1 1 1 1 2079764-1 WASHER, WAVE SPRING, CREST-TO-CREST 243

- 1 1 1 1 1 2119083-1 RETAINER, INSULATION DIAL 242

- 1 1 1 1 1 7-18023-7 SCR, SKT HD CAP M3 X 4.0 241

- - 2 2 - - 2168400-6 SHCS, LOW HEAD, RoHS, M5 X 16 240

- - - - - 1 2119580-1 MECHANICAL FEED ASSEMBLY 239

- - - - 1 - 2063440-1 AIR FEED MODULE 238

- - 1 1 - - 2119740-2 TAG, IDENTIFICATION 213

- - 1 1 - - 1901094-3 SPACER, FEEDER 198

- - - - 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

- - - - 1 - 240638-1 SPRING, FEED FINGER 163

- - - - 1 - 3-23627-7 PIN, RETAIN, GRVD, 3/16 X .854 137

- - - - 1 - 2119799-1 HOLDER, FEED FINGER, AF 136

- - REF REF - - SEE NOTE 4 MEMORY CHIP, PROGRAMMED 135

- - 1 1 - - 1633743-1 SERVO FEED LATCH ASM 133

- - REF REF - - 2119944-1 FEED FINGER ASSEMBLY, SF 117

- 1 1 1 1 1 455888-5 SPACER, CRIMPER 82

- 1 1 1 1 1 2119956-1 DOCUMENTATION PACKAGE 71

- 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

- 3 - 3 3 3 992763-5 SCR, SET, SOC, CONE POINT, M3 x 4.0 62

- 1 1 1 1 1 2079383-4 SCR, BHSC, RoHS (M4 X 8) 60

- - - - 1 1 5-18022-5 SCR, HEX HD CAP, M4 X 6.0 59

- 1 1 1 1 1 985575-3 SCR, FLT SKT HD CAP M3 X 10.0 57

- - - - 1 1 1338685-1 PAWL, FEED 56

- 4 4 4 4 4 2168400-1 SHCS, LOW HEAD, RoHS, M4 X 12 54

- 2 2 2 2 2 1-2168083-0 SCR, SKT HD CAP, RoHS, M4 X 10 53

- 1 1 1 1 1 5018030-1 NUT, HEX, REG, RoHS, M3 52

- 1 1 1 1 1 811242-5 BUMPER, HOLD DOWN 51

- 1 1 1 1 1 690753-2 SPACER, TONKER 50

- - - - 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 2119656-9 APPLICATOR BASIC ASSEMBLY, SF 46

- 1 - 1 1 1 2119370-1 RAM, AMP STYLE, SIDE 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

- 1 - 1 1 1 2119957-1 APPLICATOR SHIM PACK 39

- 1 1 1 1 1 2119644-1 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

- 1 1 1 1 1 1752356-1 SUPPORT, TERMINAL 34

- 2 2 2 2 2 2079383-5 SCR, BHSC, RoHS (M4 X 20) 33

- 1 1 1 1 1 2161328-1 HEX HEAD, FLANGED, M5 x 8mm LONG 32

- 1 1 1 1 1 1-1320908-2 SPACER, STRIP GUIDE 30

- 1 1 1 1 1 2119959-1 ASSEMBLY, STRIP GUIDE 29

- 1 1 1 1 1 455888-3 SPACER, CRIMPER 28

- 1 1 1 1 1 1320928-2 STRIP GUIDE 24

- 1 1 1 1 1 2168083-2 SCR, SKT HD CAP, RoHS, M4 X 8.0 21

- 2 2 2 2 2 1-18028-2 WASHER, FLAT, REG M4 20

- 1 1 1 1 1 2119533-1 STRIPPER, SIDE FEED 19

- 1 1 1 1 1 2119806-1 INSERT, SHEAR 13

- 1 1 1 1 1 3-22280-3 SPRING, COMPRESSION 12

- 1 1 1 1 1 1-356885-4 STOP, SHEAR 11

- 1 1 1 1 1 2119805-1 SHEAR HOLDER, FRONT 10

- 1 1 1 1 1 318707-1 FLOATING SHEAR, FRONT 9

- 1 1 1 1 1 1-1633918-8 ANVIL, COMBINATION 8

- - - - - - 7

- - - - - - 6

- 1 1 1 1 1 2-2119781-4 DEPRESSOR, SHEAR 5

- 1 1 1 1 1 238011-4 BLOCK, CRIMPER SPACER 4

- 1 1 1 1 1 2-2119784-9 CRIMPER, INSULATION O PREMIUM 3

- 1 1 1 1 1 2-455888-3 SPACER, CRIMPER 2

- 1 1 1 1 1 6-1633664-4 CRIMPER, WIRE 1

-77 -7 -6 -5 -2 -1 PART NO DESCRIPTION ITEM NO

THIS IS SUBJECT TO CHANGE WITHOUT NOTICE. THE USER SHALL BE CONTACTED FOR THE LATEST EDITION.

DIMENSIONS: mm

TOLERANCES UNLESS OTHERWISE SPECIFIED:

MATERIAL

FINISH

APVD

U. GUO

7 JULY 2014

NAME

Ocean Side Feed Applicator

SIZE

CAGE CODE

DRAWING NO

RESTRICTED TO

Customer Accessible Production Drawing

SCALE

1:2

SHEET

1

OF

4

REV

A

APPLICATOR DATA

CRIMP SIZE TYPE

WIRE 1.65 mm [.065] F

INSUL 3.94 mm [.155] O

APPLICATOR INSTRUCTIONS 408-10389

TERMINAL DATA: HULANE TERMINAL TE CRIMP SPECIFICATION

TERMINAL NAME: TERMINAL

WIRE STRIP LENGTH 4.96-5.72 mm [.195-.225 IN]

INSULATION DIAMETER RANGE

TERMINAL APPLICATION SPECIFICATION

TERMINALS APPLIED

TE TERMINAL

HULANE TERMINAL

TE SEAL

HULANE SEAL

CABLE DIAMETER

WIRE SIZE

CRIMP HEIGHT mm [INCH]

CRIMP HEIGHT REFERENCE SETTING

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: 8-2266397-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2266397-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2266397-5
SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2266397-6

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 ITEM 62. APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242. FOR -6 ONLY APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 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 TO CONVERT THE APPLICATOR TO A NON-CARRIER CUTTING STYLE, REMOVE ITEM 13 AND ATTACH TO THE LOCATION ON THE BACK SIDE OF THE HOUSING. REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.

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14 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.

*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

-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 2119599-1

LOC A

DIST 66

REVISIONS

DESCRIPTION

DATE

OWN

APVD

- - - - 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 1 2119798-1 DETENT PIN 247

- 1 - 1 1 1 1 1-22279-3 SPRING, COMPRESSION 246

- - 1 - - - 2119758-1 RAM, AMP STYLE, SIDE FEED, NON-ADJ. 245

- 1 1 1 1 1 2119082-3 CAM, SNAIL, INSULATION ADJUSTMENT 244

- 1 1 1 1 1 2079764-1 WASHER, WAVE SPRING, CREST-TO-CREST 243

- 1 1 1 1 1 2119083-1 RETAINER, INSULATION DIAL 242

- 1 1 1 1 1 7-18023-7 SCR, SKT HD CAP M3 X 4.0 241

- - 2 2 - - 2168400-6 SHCS, LOW HEAD, RoHS, M5 X 16 240

- - - - - 1 2119580-1 MECHANICAL FEED ASSEMBLY 239

- - - - 1 - 2063440-1 AIR FEED MODULE 238

- - 1 1 - - 2119740-2 TAG, IDENTIFICATION 213

- - 1 1 - - 1901094-3 SPACER, FEEDER 198

- - - - 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

- - - - 1 - 240638-1 SPRING, FEED FINGER 163

- - - - 1 - 3-23627-7 PIN, RETAIN, GRVD, 3/16 X .854 137

- - - - 1 - 2119799-1 HOLDER, FEED FINGER, AF 136

- - REF REF - - SEE NOTE 4 MEMORY CHIP, PROGRAMMED 135

- - 1 1 - - 1633743-1 SERVO FEED LATCH ASM 133

- - REF REF - - 2119944-1 FEED FINGER ASSEMBLY, SF 117

- 1 1 1 1 1 455888-5 SPACER, CRIMPER 82

- 1 1 1 1 1 2119956-1 DOCUMENTATION PACKAGE 71

- 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

- 3 - 3 3 3 992763-5 SCR, SET, SOC, CONE POINT, M3 x 4.0 62

- 1 1 1 1 1 2079383-4 SCR, BHSC, RoHS (M4 X 8) 60

- - - - 1 1 5-18022-5 SCR, HEX HD CAP, M4 X 6.0 59

- 1 1 1 1 1 985575-3 SCR, FLT SKT HD CAP M3 X 10.0 57

- - - - 1 1 1338685-1 PAWL, FEED 56

- 4 4 4 4 4 2168400-1 SHCS, LOW HEAD, RoHS, M4 X 12 54

- 2 2 2 2 2 1-2168083-0 SCR, SKT HD CAP, RoHS, M4 X 10 53

- 1 1 1 1 1 5018030-1 NUT, HEX, REG, RoHS, M3 52

- 1 1 1 1 1 811242-5 BUMPER, HOLD DOWN 51

- 1 1 1 1 1 690753-2 SPACER, TONKER 50

- - - - 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 2119656-9 APPLICATOR BASIC ASSEMBLY, SF 46

- 1 - 1 1 1 2119370-1 RAM, AMP STYLE, SIDE FEED 44

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- 2 2 2 2 2 1-18028-2 WASHER, FLAT, REG M4 20

- 1 1 1 1 1 2119533-1 STRIPPER, SIDE FEED 19

- 1 1 1 1 1 2119806-1 INSERT, SHEAR 13

- 1 1 1 1 1 3-22280-3 SPRING, COMPRESSION 12

- 1 1 1 1 1 1-356885-4 STOP, SHEAR 11

- 1 1 1 1 1 2119805-1 SHEAR HOLDER, FRONT 10

- 1 1 1 1 1 318707-1 FLOATING SHEAR, FRONT 9

- 1 1 1 1 1 1-1633918-8 ANVIL, COMBINATION 8

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- 1 1 1 1 1 238011-4 BLOCK, CRIMPER SPACER 4

- 1 1 1 1 1 2-2119784-9 CRIMPER, INSULATION O PREMIUM 3

- 1 1 1 1 1 2-455888-3 SPACER, CRIMPER 2

- 1 1 1 1 1 6-1633664-4 CRIMPER, WIRE 1

-77 -7 -6 -5 -2 -1 PART NO DESCRIPTION ITEM NO

THIS IS SUBJECT TO CHANGE WITHOUT NOTICE. THE USER SHALL BE CONTACTED FOR THE LATEST EDITION.

DIMENSIONS: mm

TOLERANCES UNLESS OTHERWISE SPECIFIED:

MATERIAL

FINISH

APVD

U. GUO

7 JULY 2014

NAME

Ocean Side Feed Applicator

SIZE

CAGE CODE

DRAWING NO

RESTRICTED TO

Customer Accessible Production Drawing

SCALE

1:2

SHEET

1

OF

4

REV

A

APPLICATOR DATA

CRIMP SIZE TYPE

WIRE 1.65 mm [.065] F

INSUL 3.94 mm [.155] O

APPLICATOR INSTRUCTIONS 408-10389

TERMINAL DATA: HULANE TERMINAL TE CRIMP SPECIFICATION

TERMINAL NAME: TERMINAL

WIRE STRIP LENGTH 4.96-5.72 mm [.195-.225 IN]

INSULATION DIAMETER RANGE

TERMINAL APPLICATION SPECIFICATION

TERMINALS APPLIED

TE TERMINAL

HULANE TERMINAL

TE SEAL

HULANE SEAL

CABLE DIAMETER

WIRE SIZE

CRIMP HEIGHT mm [INCH]

CRIMP HEIGHT REFERENCE SETTING

1 RECOMMENDED SPARE PARTS

2 GREASE BEARING SURFACES LIGHTLY

3. LUBRICATE DAILY PER THE APPLICATOR INSTRUCTION SHEET SUPPLIED WITH THE APPLICATOR.

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PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2266397-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2266397-5
SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2266397-6

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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.

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14 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.

*WARNING
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- - 1 - - - 2119957-2 APPLICATOR SHIM PACK 260

- 1 - 1 1 1 8-21084-0 O-RING, .676 ID, .070 DIA. MAT. 252

-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 2119599-1

LOC A

DIST 66

REVISIONS

DESCRIPTION

DATE

OWN

APVD

- - - - 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 1 2119798-1 DETENT PIN 247

- 1 - 1 1 1 1 1-22279-3 SPRING, COMPRESSION 246

- - 1 - - - 2119758-1 RAM, AMP STYLE, SIDE FEED, NON-ADJ. 245

- 1 1 1 1 1 2119082-3 CAM, SNAIL, INSULATION ADJUSTMENT 244

- 1 1 1 1 1 2079764-1 WASHER, WAVE SPRING, CREST-TO-CREST 243

- 1 1 1 1 1 2119083-1 RETAINER, INSULATION DIAL 242

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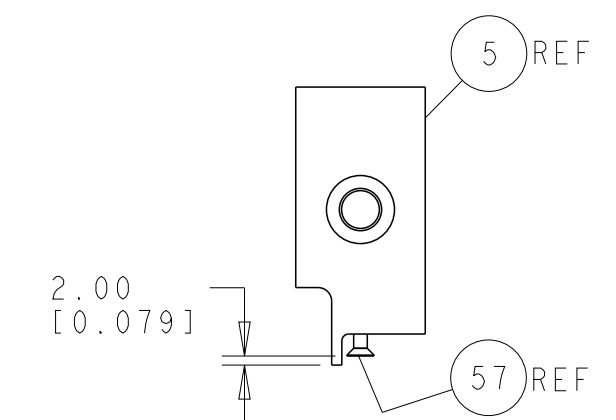
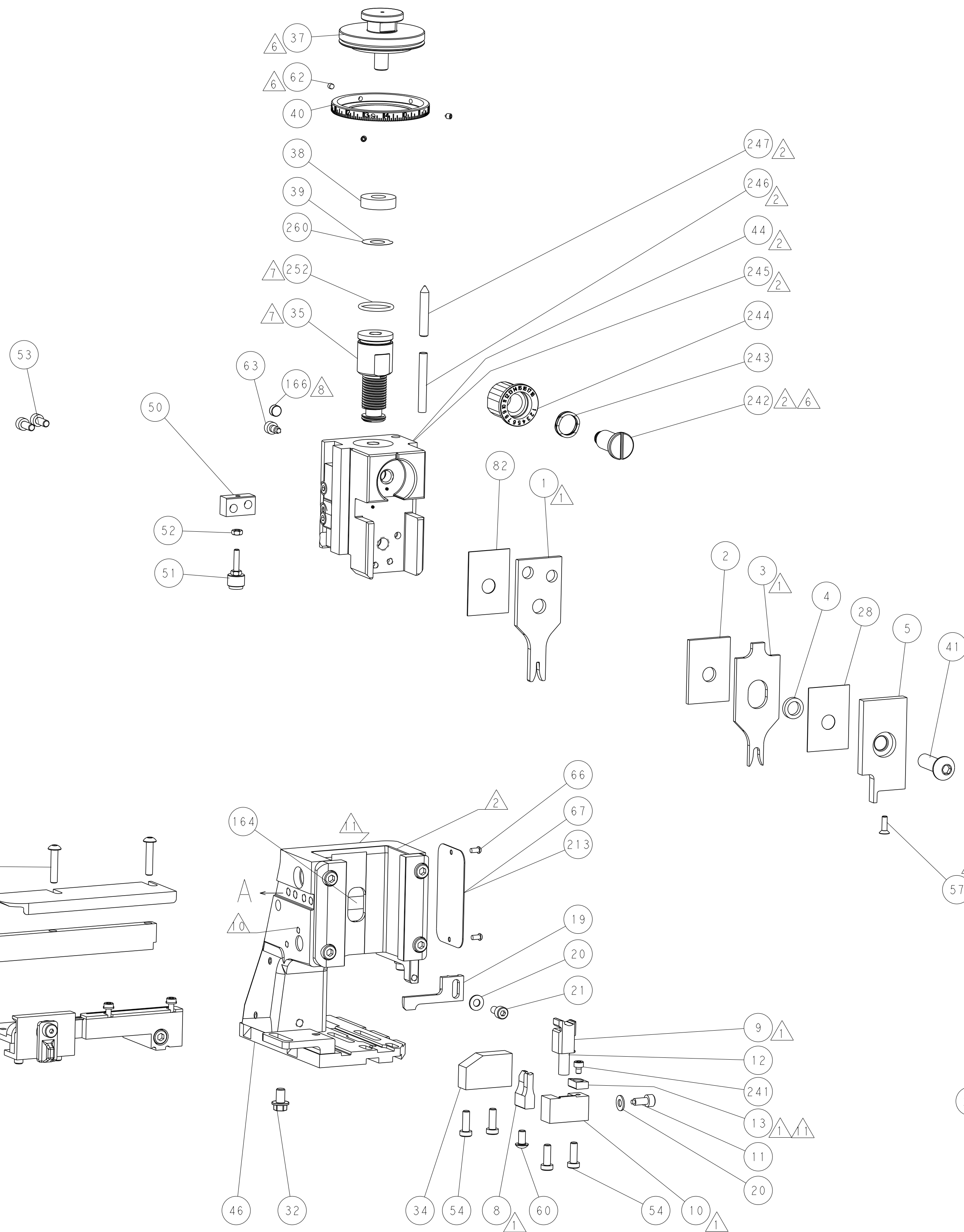
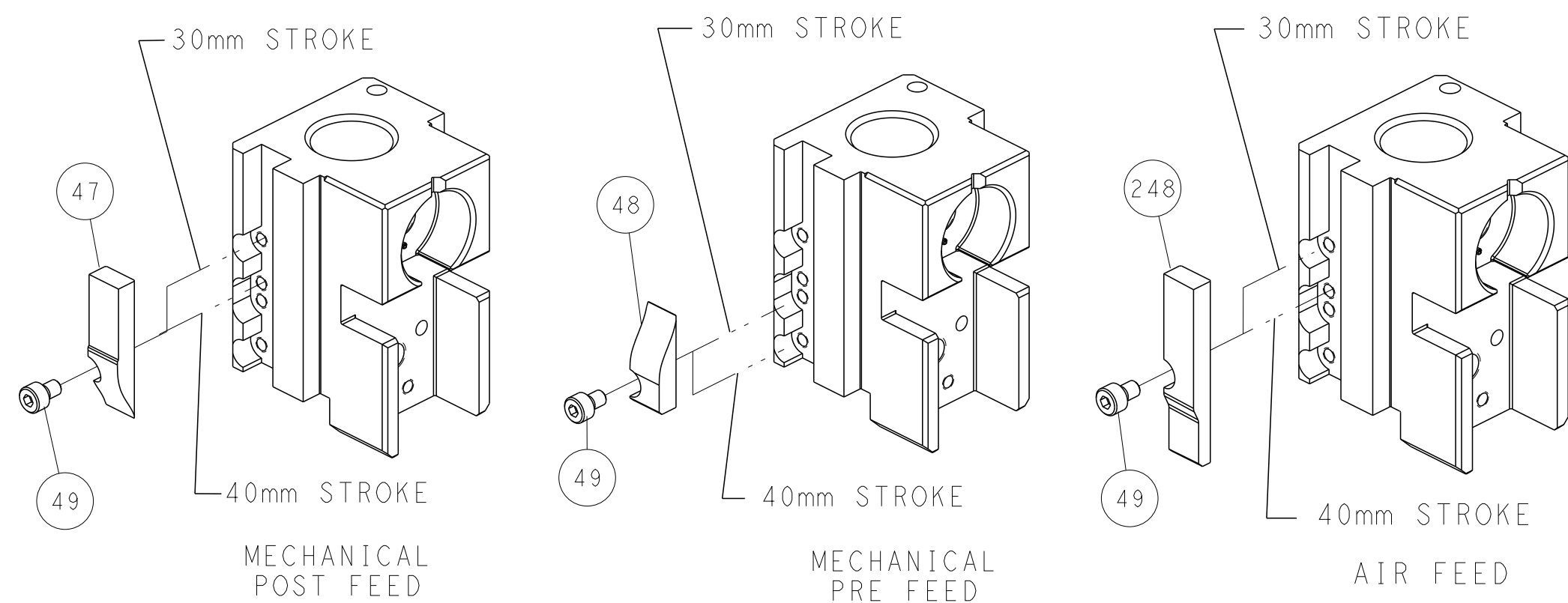
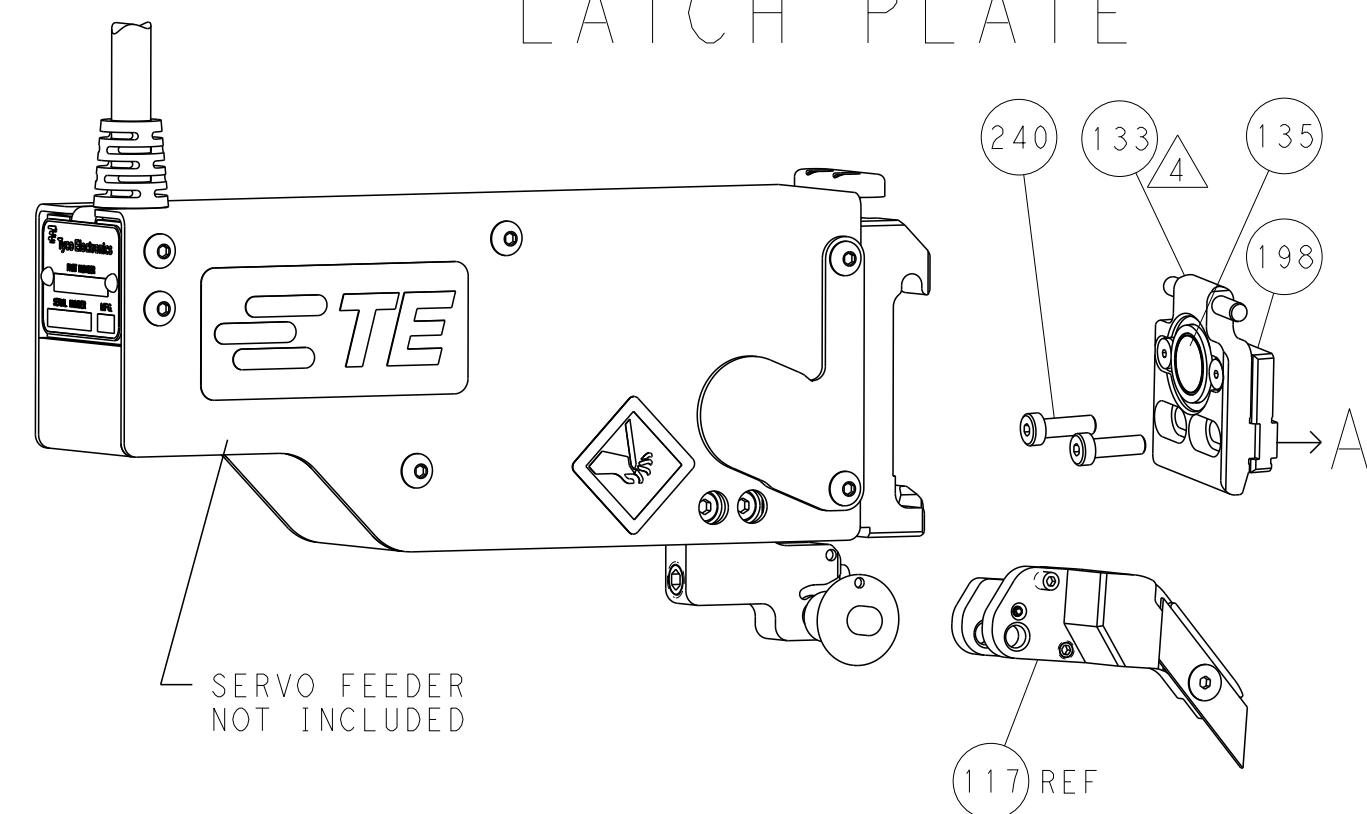
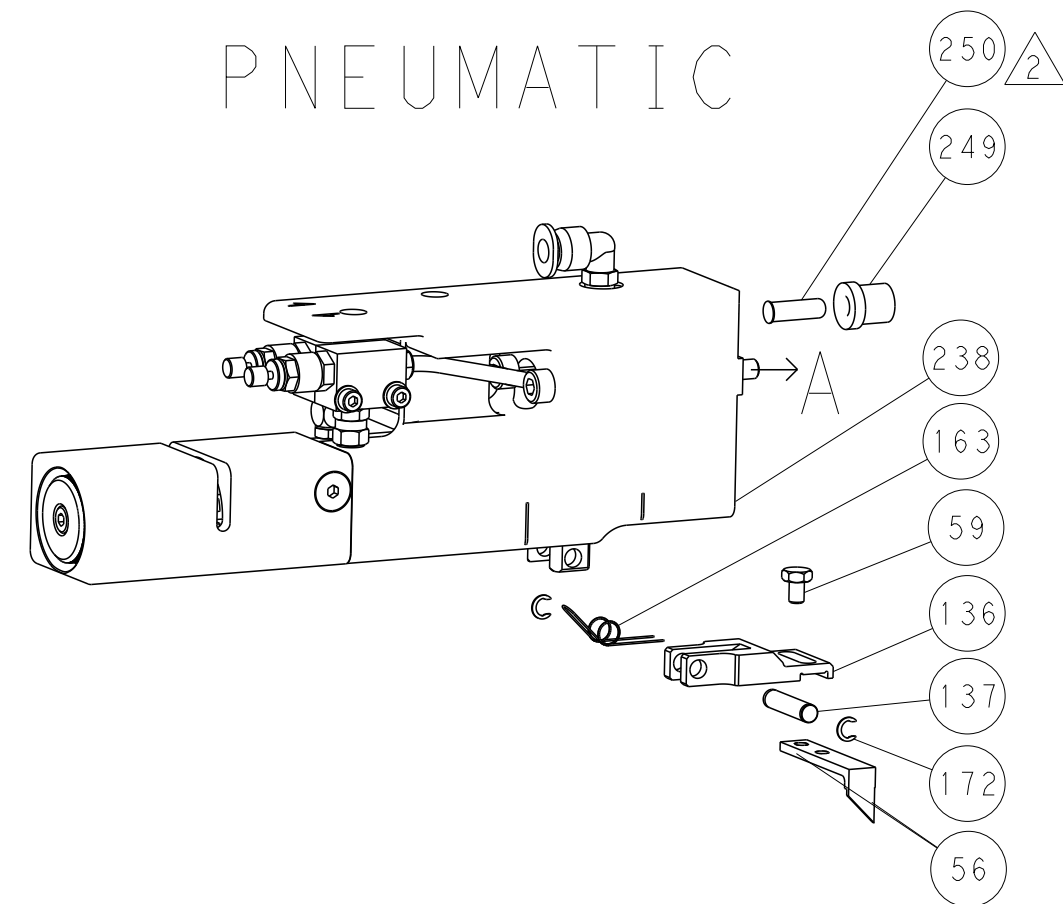
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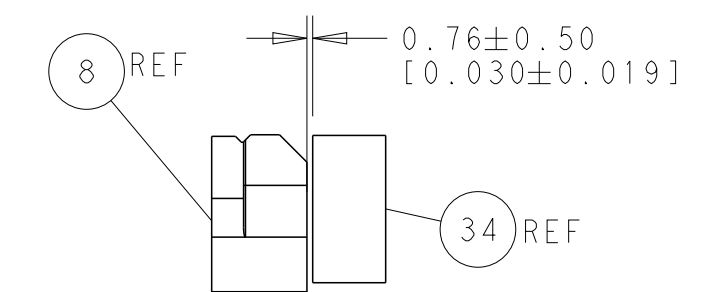
PNEUMATIC

SERVO
LATCH PLATE

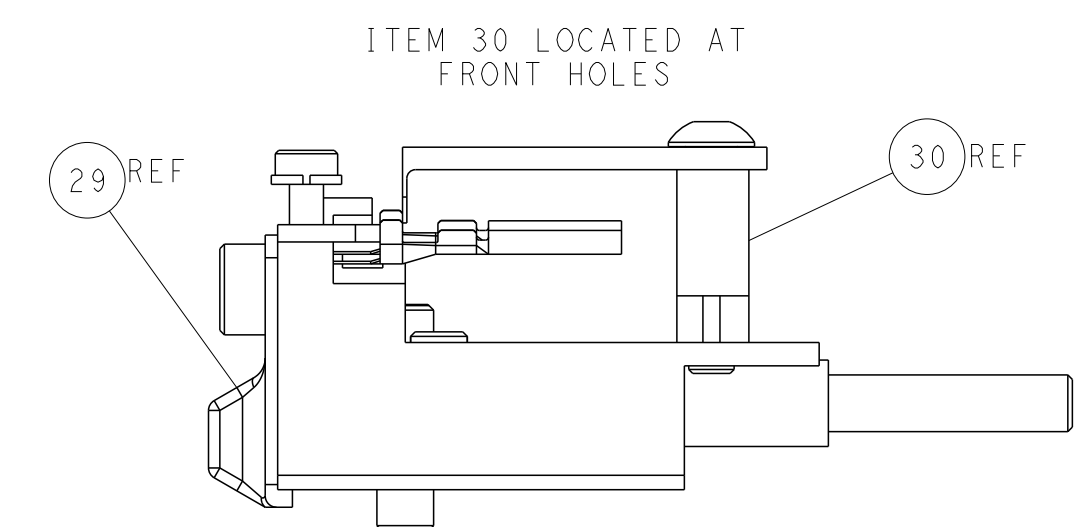
CAM POSITIONS



SHEAR DEPRESSOR DETAIL



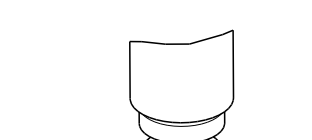
TERMINAL SUPPORT LOCATION



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)

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		CHK Y. YIN 7 JULY 2014			
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		NAME	
mm		0 PLC ±.1 1 PLC ±0.5 2 PLC ±0.13 3 PLC ±0.013 4 PLC ±0.0001 ANGLES ±.1		APVD U. GUO 7 JULY 2014 PRODUCT SPEC - APPLICATION SPEC -	
				SIZE A	
MATERIAL		FINISH		CAGE CODE	
-		-		DRAWING NO	
		WEIGHT		00779 	
				RESTRICTED TO	
				-	
Customer Accessible Production Drawing				SCALE 1:2 SHEET 2 of 4 REV A	

	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART						
					CONVERT TO	PART NUMBERS REQUIRED					
	2-2266397-1	A	FINE CRIMP HEIGHT ADJUST	MECHANICAL	PNEUMATIC FEED	2119950-1	1338685-1	5-18022-5	2119641-2	2119799-1	2063440-1
					SERVO LATCH PLATE	2119951-1	-	8-2266397-5	1901094-3	-	2168400-6 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2266397-4	-	-	-
	2-2266397-2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-2	-	-
					SERVO LATCH PLATE	2119951-1	-	8-2266397-5	1901094-3	-	2168400-6 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2266397-4	-	-	-
	2-2266397-5	A	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE ⁴	MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-2	-	-
					PNEUMATIC FEED	2119950-1	1338685-1	5-18022-5	2119641-2	2119799-1	2063440-1
2-2266397-7	A	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	-	-
7-2266397-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-	-

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.65 mm [.065]	F
INSUL	3.94 mm [.155]	O
APPLICATOR INSTRUCTIONS 408-10389		

TERMINAL DATA: HULANE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: TERMINAL			
WIRE STRIP LENGTH 4.96-5.72 mm [.195-.225 IN]		INSULATION DIAMETER RANGE Ø 	
TERMINAL APPLICATION SPECIFICATION 	NONE	-	-
	-	-	-

TERMINALS APPLIED				
TE TERMINAL	HULANE TERMINAL	TE SEAL	HULANE SEAL	CABLE DIAMETER
2113513-1	618648KSS	2113500-1	7165-33541A	Ø1.30-1.60 mm ¹²

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING ⁹
0.50mm2		0.95+/-0.05 [.037+/- .002]		9.7



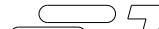
- ¹ RECOMMENDED SPARE PARTS
- ² GREASE BEARING SURFACES LIGHTLY
3. LUBRICATE DAILY PER THE APPLICATOR INSTRUCTION SHEET SUPPLIED WITH THE APPLICATOR.
- ⁴ APPLICATOR SPECIFIC DATA TO BE ENTERED INTO BLANK MEMORY CHIP AT ASSEMBLY. SEE BELOW FOR PART NUMBER:
MECHANICAL FEED WITH "SMART APPLICATOR" CONVERSION: 8-2266397-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2266397-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2266397-5
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 ITEM 62.
APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242.
- ⁷ GREASE THREADS, GROOVE AND O-RING ON ITEMS 139 & 152.
- ⁸ MAGNET 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 TO CONVERT THE APPLICATOR TO A NON-CARRIER CUTTING STYLE, REMOVE ITEM 13 AND ATTACH TO THE LOCATION ON BACK SIDE OF THE HOUSING. REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.
- ¹² THIS APPLICATOR APPLIES TERMINAL WITH A SEAL.
- ¹³ APPLY TORQ-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.

*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.

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

SET UP GAUGE 2119599-1	LOC A	DIST 66	REVISIONS					
			P	LTR	DESCRIPTION	DATE	DWN	APVD
				-	SEE SHEET 1	-	-	-

-	1	1	1	1	2119782-1	FINE ADJUST HEAD ASM, PACIFIC STYLE	251
-	-	-	1	-	2119640-1	PUSH ROD, AIR FEED	250
-	-	-	1	-	2079988-1	BUSHING, LCH5-12, MISUMI	249
-	1	1	1	1	1-22279-3	SPRING, COMPRESSION	246
-	1	1	1	1	2119082-3	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	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
-	-	2	-	-	2168400-6	SHCS, LOW HEAD, RoHS, M5 X 16	240
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-	1	1	1	1	2119793-1	LIMITER, ADJUSTMENT BOLT	63
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-	1	1	1	1	985575-3	SCR, FLT SKT HD CAP M3 X 10.0	57
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-	2	2	2	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	53
-	1	1	1	1	5018030-1	NUT, HEX, REG, RoHS, M3	52
-	1	1	1	1	811242-5	BUMPER, HOLD DOWN	51
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-	-	-	1	2	18023-9	SCR, SKT HD CAP M4 X 6.0	49
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-	2	2	2	2	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	318707-1	FLOATING SHEAR, FRONT	9
-	1	1	1	1	1-1633918-8	ANVIL, COMBINATION	8
-	-	-	-	-	-	-	7
-	-	-	-	-	-	-	6
-	1	1	1	1	2-2119781-4	DEPRESSOR, SHEAR	5
-	1	1	1	1	238011-4	BLOCK, CRIMPER SPACER	4
-	1	1	1	1	2-2119784-9	CRIMPER, INSULATION O PREMIUM	3
-	1	1	1	1	2-455888-3	SPACER, CRIMPER	2
-	1	1	1	1	6-1633664-4	CRIMPER, WIRE	1

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				CHK Y. YIN	7 JULY 2014				
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		APVD J. GUO	7 JULY 2014	NAME Ocean Side Feed Applicator			
		0 PLC ±.5 1 PLC ±0.5 2 PLC ±0.13 3 PLC ±0.13 4 PLC ±0.0001 ANGLES FINISH		PRODUCT SPEC -		SIZE A1		CAGE CODE 00779	
MATERIAL -		FINISH -		APPLICATION SPEC -		DRAWING NO C=2266397		RESTRICTED TO -	
Customer Accessible Production Drawing				SCALE 1:2		SHEET 3 OF 4		REV A	

PNEUMATIC

250
249
238
163
59
136
137
172
56

SERVO FEEDER
NOT INCLUDED

30mm STROKE

142

49

MECHANICAL POST FEED

30mm STROKE

48

49

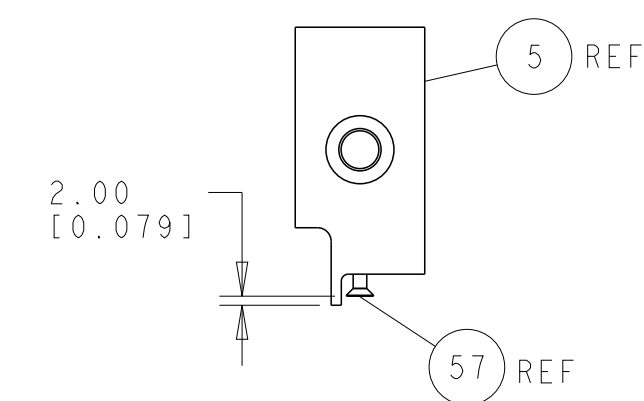
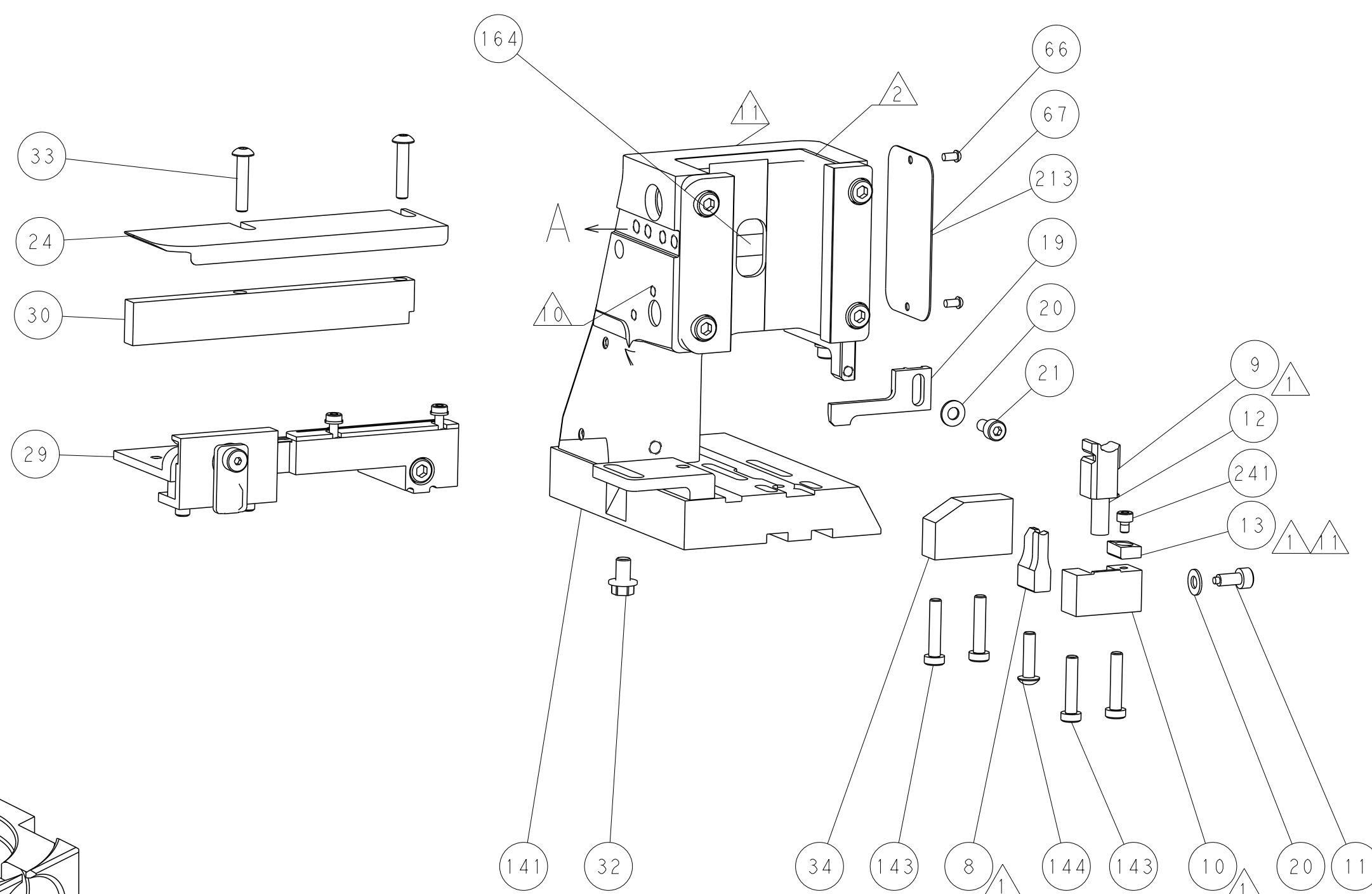
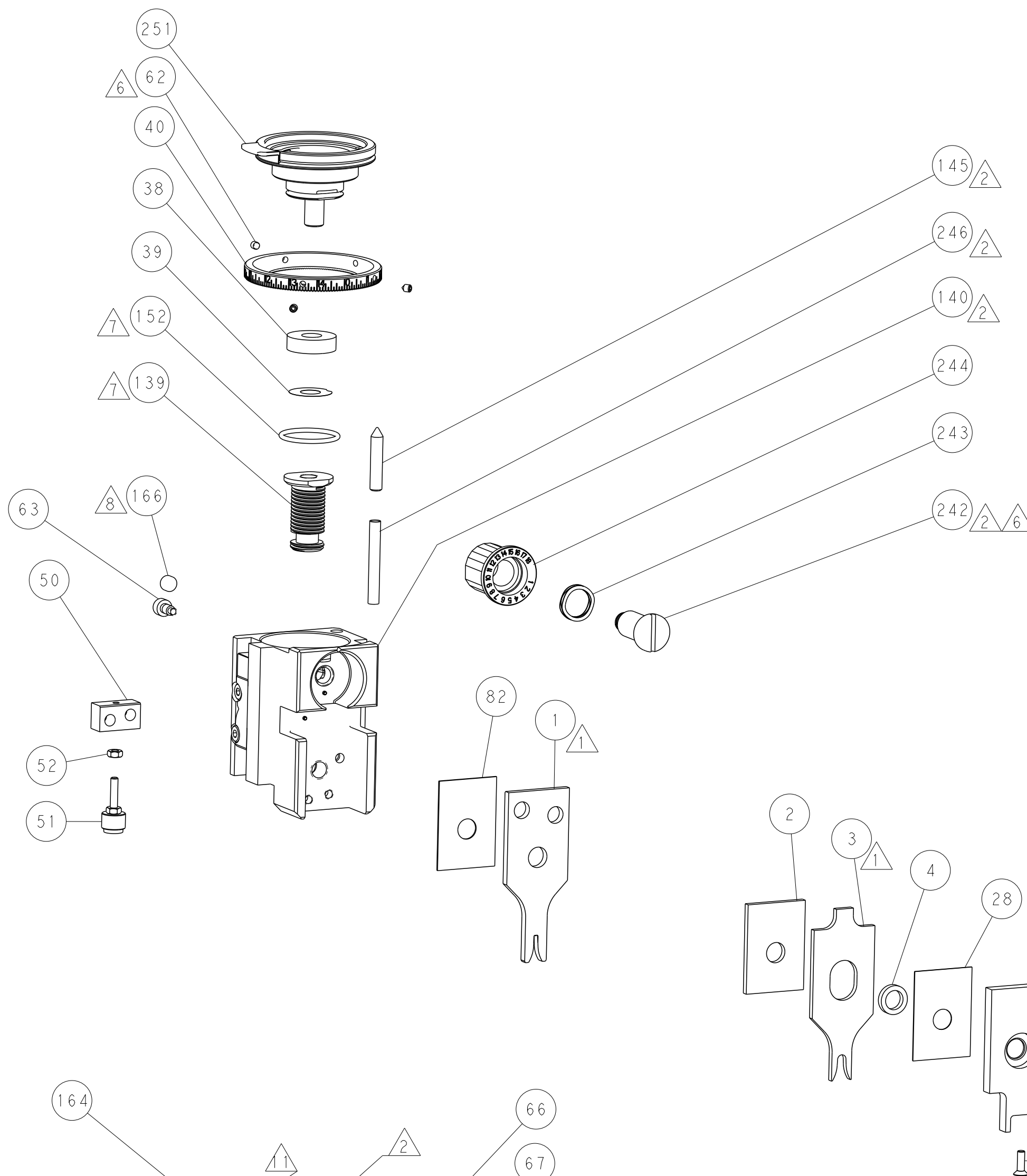
MECHANICAL PRE FEED

30mm STROKE

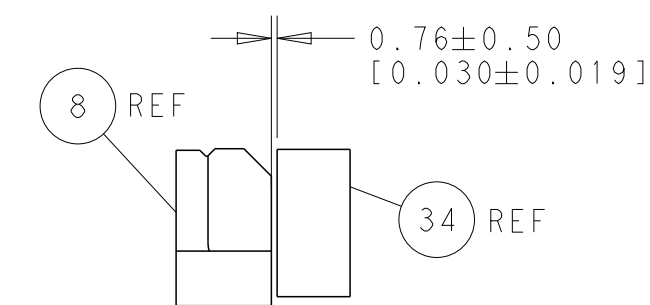
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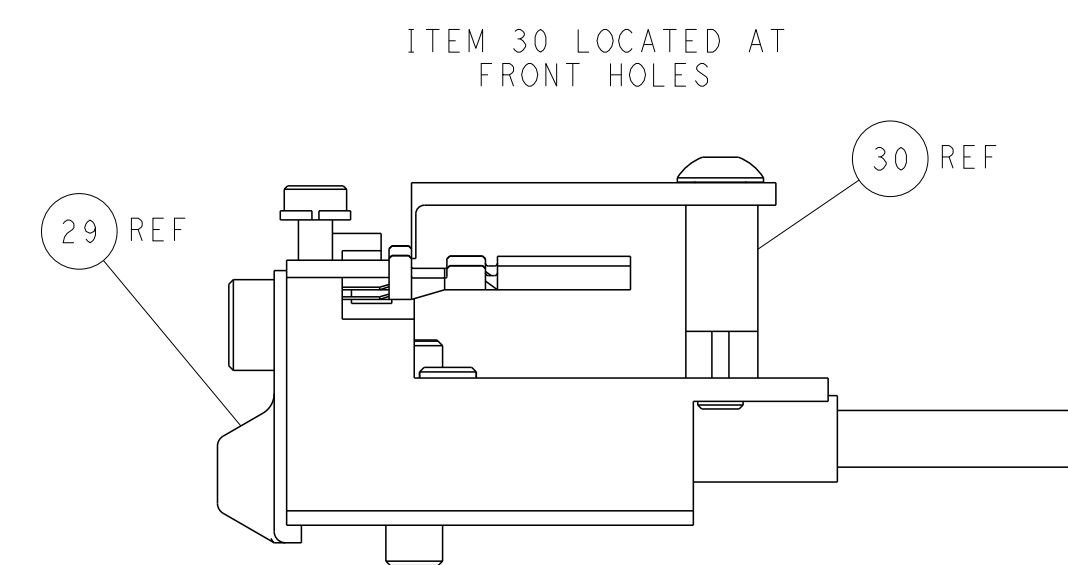
AIR FEED



SHEAR DEPRESSOR DETAIL



TERMINAL SUPPORT LOCATION



FEED TRACK POSITION GUIDE BY INSULATION BARREL

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: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.0 1 PLC ±0.5 2 PLC ±0.13 3 PLC ±0.013 4 PLC ±0.001 ANGLES		NAME Ocean Side Feed Applicator	
		APPLICATION SPEC		SIZE CASE CODE DRAWING NO. RESTRICTED TO	
MATERIAL FINISH		WEIGHT		A 00779 C=2266397	
		Customer Accessible Production Drawing		SCALE 1:2 SHEET 4 OF 4 REV A	

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