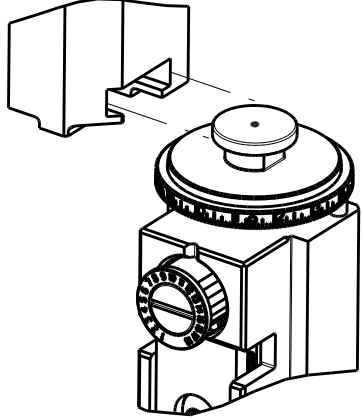


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ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION
	2150435-2	A	FINE CRIMP HEIGHT ADJUST
	2150435-5	A	FINE CRIMP HEIGHT ADJUST
	2150435-6	A	NON-CRIMP HEIGHT ADJUST
	2150435-7	A	FINE CRIMP HEIGHT ADJUST
	7-2150435-7	A	CRIMP TOOLING KIT

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.29 mm [.090]	F
INSUL	3.30 mm [.130]	F
APPLICATOR INSTRUCTIONS 408-10390 		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: .312 FASTIN-FASTON			
WIRE STRIP LENGTH 5.15-5.91 mm [.203-.233 IN]		INSULATION DIAMETER RANGE Ø2.29-3.30 mm [.090-.130 IN]	
TERMINAL APPLICATION SPECIFICATION		114-20021	
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
160557-1	160557-2	160557-4	

WIRE SIZE 	CRIMP HEIGHT mm [INCH] 	CRIMP HEIGHT REFERENCE SETTING 
1.50mm2	1.57+/-0.05 [.062+/- .002]	6.7
1.00mm2	1.52+/-0.05 [.060+/- .002]	7.3
0.75mm2	1.47+/-0.05 [.058+/- .002]	7.9
0.50mm2	1.42+/-0.05 [.056+/- .002]	8.3

-  RECOMMENDED SPARE PARTS
-  GREASE BEARING SURFACES LIGHTLY
3. LUBRICATE DAILY PER THE APPLICATOR INSTRUCTION SHEET SUPPLIED WITH THE APPLICATOR.
-  APPLICATOR SPECIFIC DATA TO BE ENTERED INTO BLANK MEMORY CHIP AT ASSEMBLY. SEE BELOW FOR PART NUMBER:
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150435-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150435-5
SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2150435-6
5. ADJUSTMENT OF THE STRIPPER MAY BE REQUIRED WHEN MOVING THE APPLICATOR BETWEEN BENCH AND LEADMAKER APPLICATIONS.
-  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.
-  GREASE THREADS, GROOVE AND O-RING ON ITEMS 35 & 252.
-  MAGNET, ITEM 166 MUST BE ORIENTED CORRECTLY IN ORDER TO PROPERLY ACTUATE THE COUNTER.
-  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.
-  TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
-  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
-  CUT TO LENGTH AT ASSEMBLY.

*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.

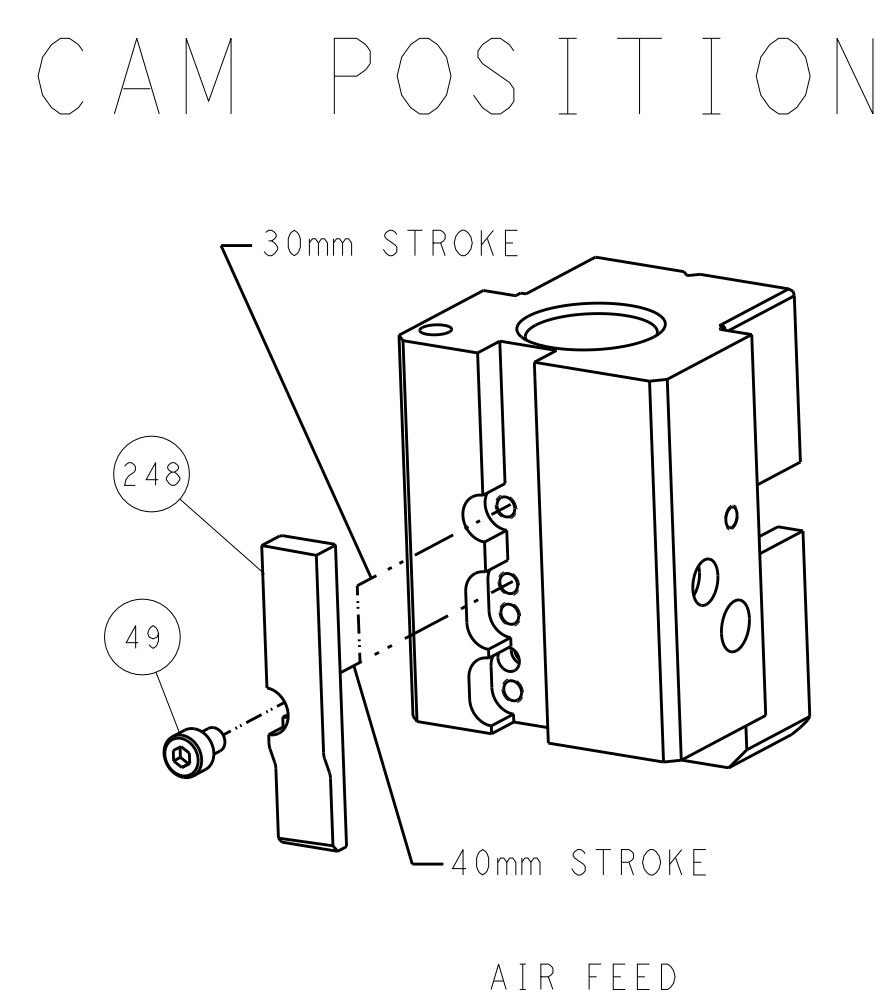
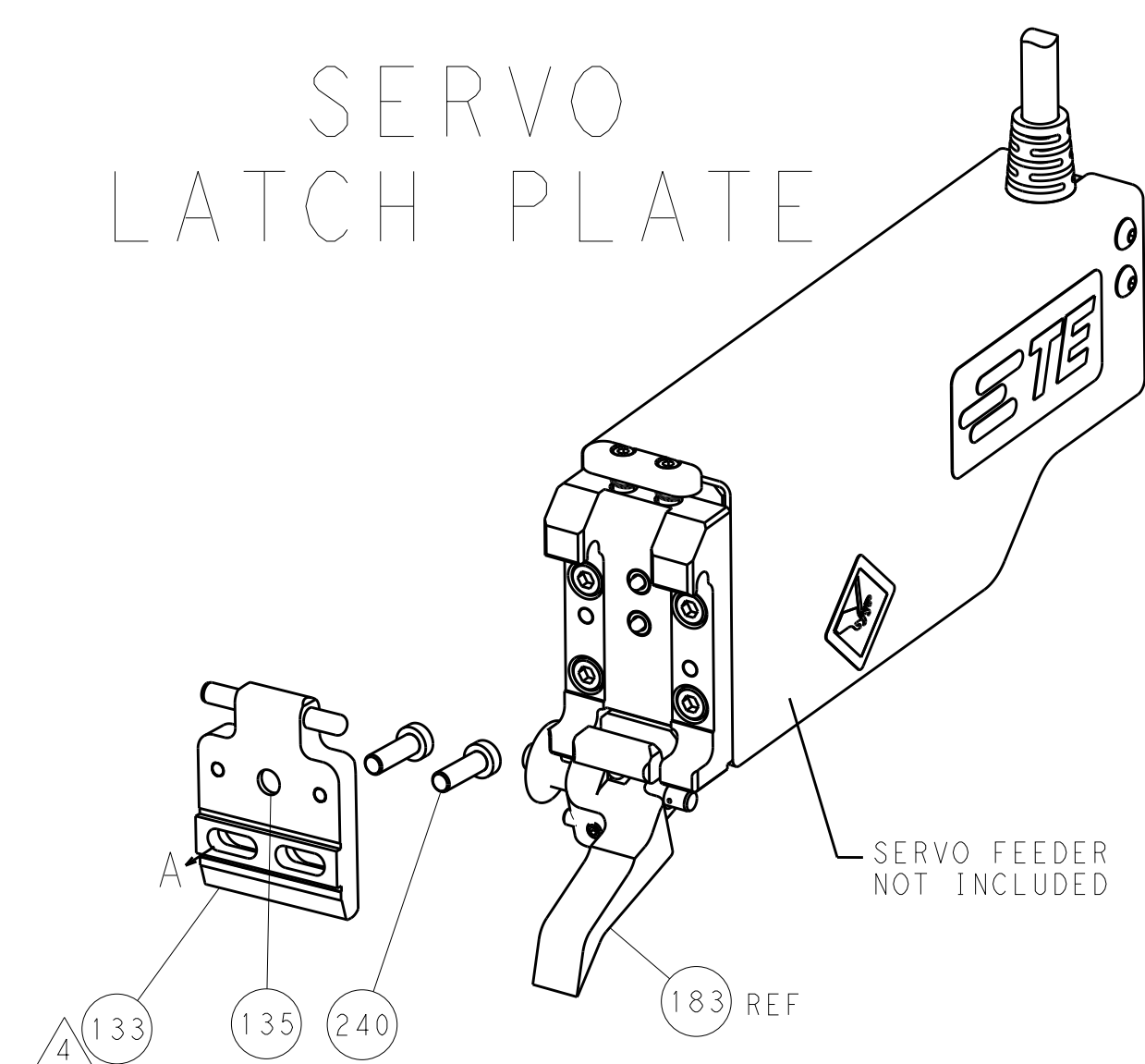
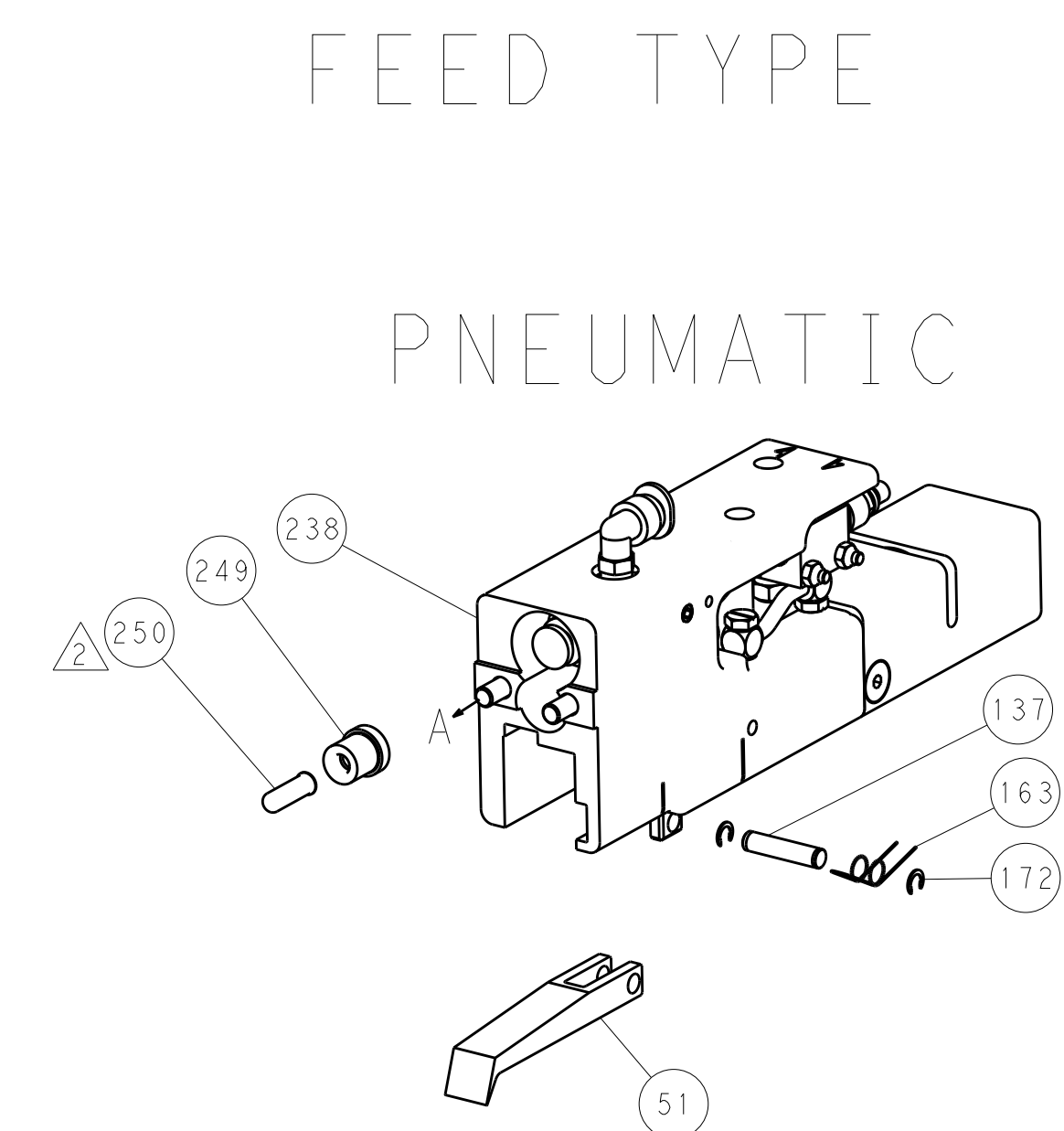
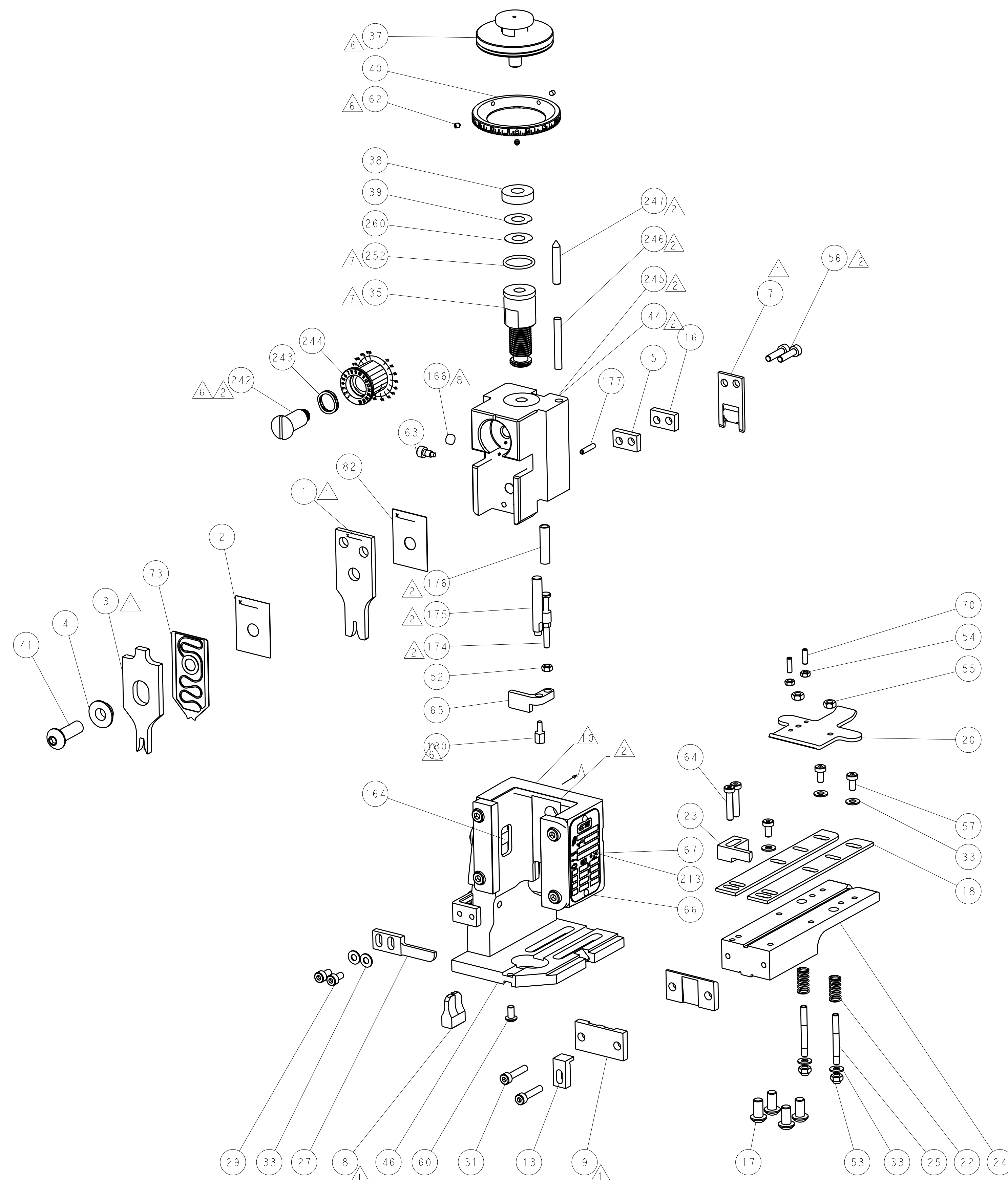
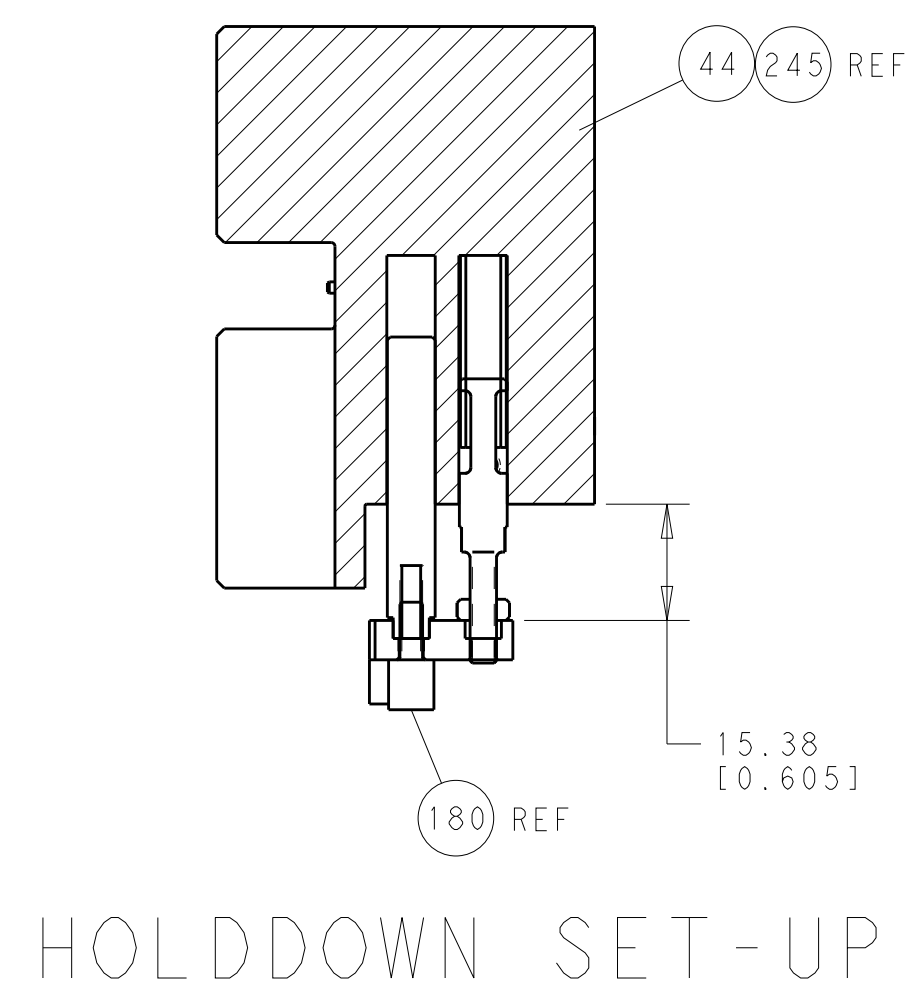
-	-	1	-	-	2119957-2	APPLICATOR SHIM PACK	260
-	1	-	1	1	8-21084-0	O-RING, .676 ID, .070 DIA. MAT.	252
-	-	-	-	1	2119640-1	PUSH ROD, AIR FEED	250
-	-	-	-	1	2079988-1	BUSHING, LCH5-12, MISUMI	249
-	-	-	-	1	2119641-1	FEED CAM, AIR FEED	248
-	1	-	1	1	2119798-1	DETENT PIN	247
-77	-7	-6	-5	-2	PART NO	DESCRIPTION	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
				1	DEVELOPMENT	17APR2014
				A	RELEASED	12JUN2014

-	1	-	1	1	1-22279-3	SPRING, COMPRESSION	246
-	-	1	-	-	2119759-1	RAM, AMP STYLE, END FEED, NON-ADJUST	245
-	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
-	-	2	2	-	2168400-7	SHCS, LOW HEAD, RoHS, M5 X 10	240
-	-	-	-	-	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	-	-	-	1	2063440-2	AIR FEED MODULE	238
-	-	1	1	-	2119740-2	TAG, IDENTIFICATION	213
-	-	REFREF	-	-	1901697-1	FEED FINGER ASSEMBLY,EF	183
-	1	1	1	1	1-1752354-1	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	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172
-	1	1	1	1	994969-1	MAGNET, RARE EARTH HIGH ENERGY	166
-	REFREFREFREF	-	-	-	994970-2	COUNTER, MAGNETIC	164
-	-	-	-	1	240638-1	SPRING, FEED FINGER	163
-	-	-	-	1	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854	137
-	-	REFREF	-	-	SEE NOTE 4	MEMORY CHIP, PROGRAMMED	135
-	-	1	1	-	1633743-1	SERVO FEED LATCH ASM	133
-	1	1	1	1	455888-4	SPACER, CRIMPER	82
-	1	1	1	1	2119791-9	DEPRESSOR, WIRE	73
-	1	1	1	1	2119956-2	DOCUMENTATION PACKAGE	71
-	2	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	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	1	1	1	1	1901681-1	HOLDDOWN, TERMINAL	65
-	2	2	2	2	2168400-5	SHCS, LOW HEAD, RoHS, M4 X 20	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	1	2079383-4	SCR, BHSC, RoHS (M4 X 8)	60
-	3	3	3	3	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57
-	2	2	2	2	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	56
-	2	2	2	2	5018030-2	NUT, HEX, REG, RoHS, M4	55
-	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	2119792-1	PAWL, EF, AIR	51
-	-	-	-	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	1	1	1	1	2119655-5	APPLICATOR BASIC ASSEMBLY, EF	46
-	1	-	1	1	2119369-1	RAM,AMP STYLE, END FEED	44
-	1	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	1-2119644-2	RAM WASHER, PRECISION	38
-	1	1	1	1	2119085-1	FA HEAD, ATLANTIC STYLE	37
-	1	-	1	1	2119092-1	BOLT, ADJUSTMENT	35
-	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	1320906-1	STUD, THREADED	25
-	1	1	1	1	1-1752371-4	PLATE, STRIP GUIDE	24
-	1	1	1	1	240825-1	PLATE, STRIP HOLD DOWN	23
-	2	2	2	2	2-22281-3	SPRING, COMPRESSION	22
-	1	1	1	1	1752373-4	DRAG	20
-	2	2	2	2	1901259-4	GUIDE, LOWER STRIP	18
-	4	4	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17
-	1	1	1	1	240641-4	SPACER	16
-	1	1	1	1	1752360-1	SPACER,HOLD-DOWN	13
-	1	1	1	1	240833-4	PLATE, REAR SHEAR	11
-	-	-	-	-	-	-	10
-	1	1	1	1	6-690482-0	PLATE, FRONT SHEAR	9
-	1	1	1	1	5-1803000-0	ANVIL, COMBINATION, END FEED	8
-	1	1	1	1	2217206-8	BLADE, SLUG	7
-	-	-	-	-	-	-	6
-	1	1	1	1	6-240641-9	SPACER	5
-	1	1	1	1	3-238009-8	BLOCK, FL CRIMPER SPACER	4
-	1	1	1	1	8-1633961-1	CRIMPER, INSULATION F PREMIUM	3
-	1	1	1	1	455888-1	SPACER, CRIMPER	2
-	1	1	1	1	1-456406-6	CRIMPER, WIRE PREMIUM	1
-77	-7	-6	-5	-2	PART NO	DESCRIPTION	ITEM NO

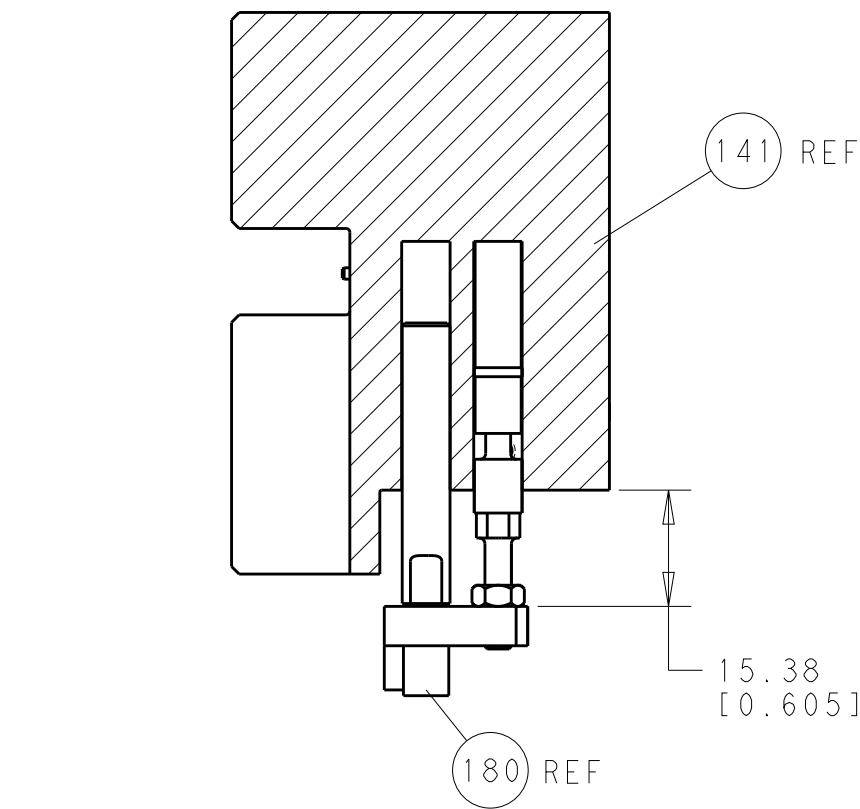
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DIMENSIONS:		CHK	17APR2014	NAME	
mm		G.BAILEY	17APR2014	Ocean End Feed Applicator	
TOLERANCES UNLESS OTHERWISE SPECIFIED:		APVD	17APR2014	SIZE	
0 PLC ±.5		PRODUCT SPEC		CASE CODE	
1 PLC ±0.5		APPLICATION SPEC		DRAWING NO	
2 PLC ±0.13		WEIGHT		RESTRICTED TO	
3 PLC ±0.013		Customer Accessible Production Drawing		SCALE	
4 PLC ±0.0001		1:1		SHEET 1 OF 4	
ANGLES ±.0001		00779		REV A	
FINISH		©=2150435			



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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DIMENSIONS:		CHK G BAILEY 17APR2014			
TOLERANCES UNLESS OTHERWISE SPECIFIED:		NAME U GUO 17APR2014			
mm		PRODUCT SPEC -		APPLICATION SPEC -	
		APPLICATION SPEC -		SIZE A	
MATERIAL -		FINISH -		CAGE CODE 00779	
-		WEIGHT -		DRAWING NO C=2150435	
-		-		RESTRICTED TO -	
Customer Accessible Production Drawing				SCALE 1:1 SHEET 2 OF 4 REV A	

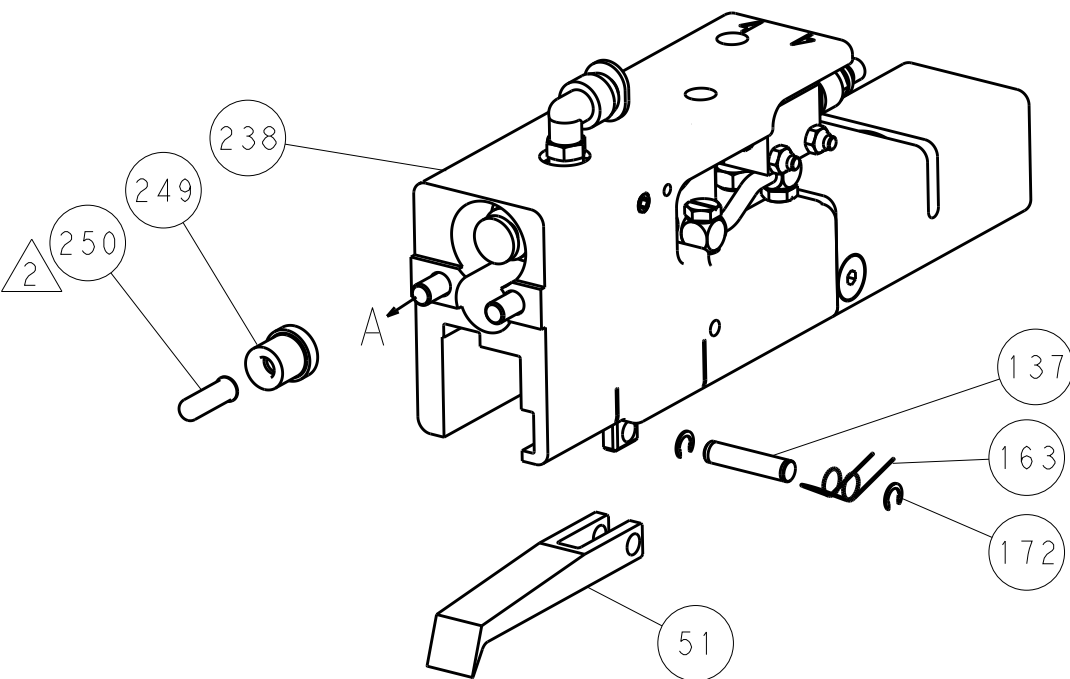
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		P	LTR	DESCRIPTION	DATE	DWN	APVD
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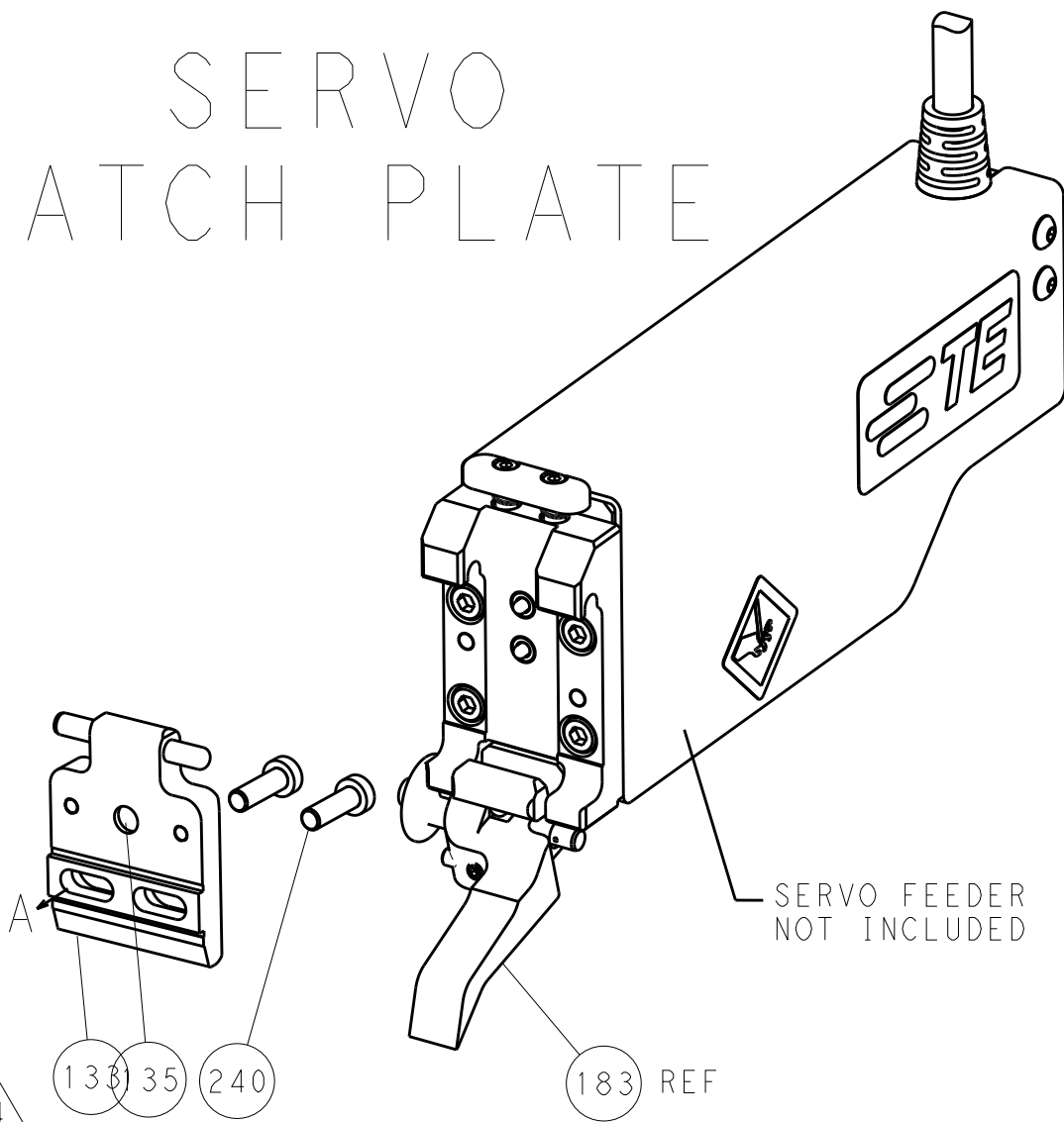
HOLDDOWN SET-UP

FEED TYPE

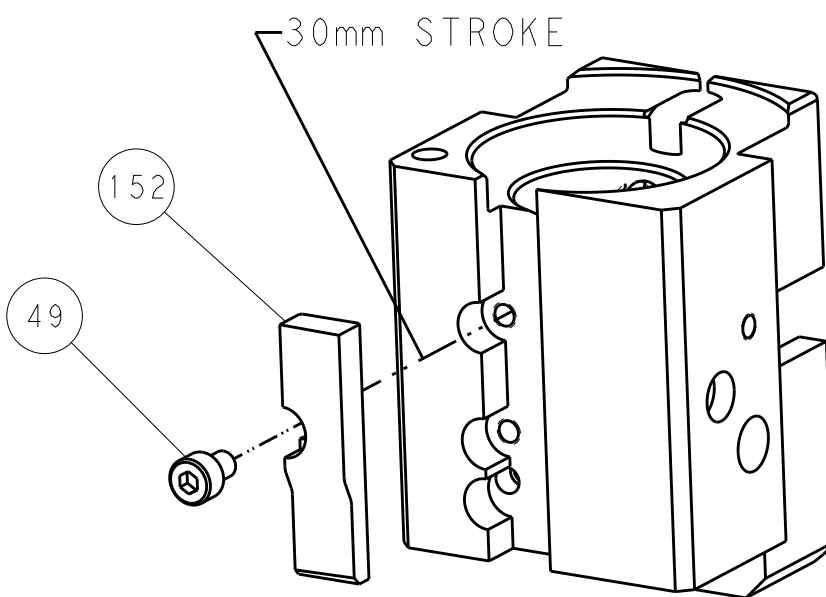
PNEUMATIC



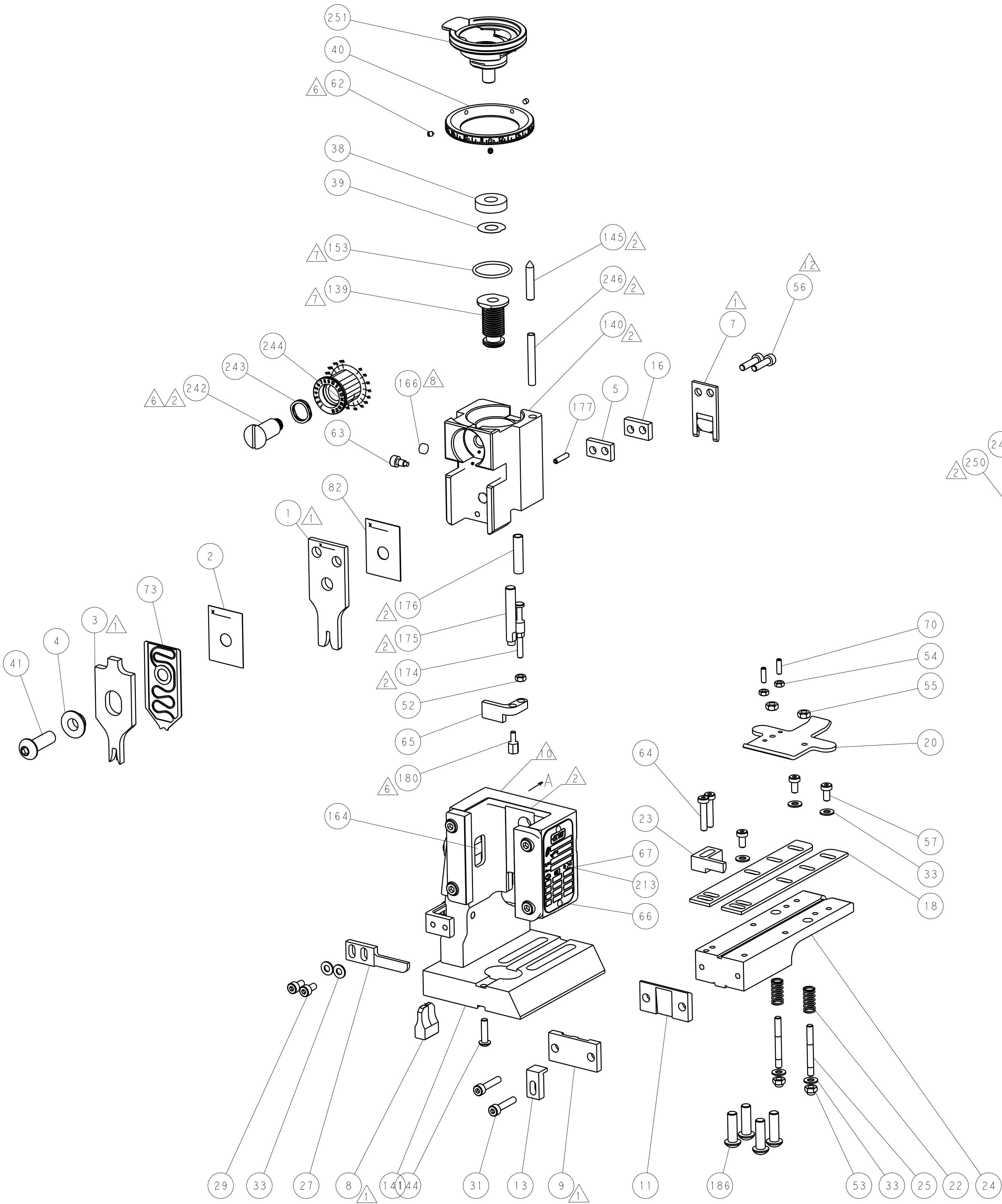
SERVO
LATCH PLATE



CAM POSITION



AIR FEED



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

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		CHK	G. BAILEY	17APR2014						
		APVD	J. GUO	17APR2014						
		NAME	Ocean End Feed Applicator							
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		PRODUCT SPEC	SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO		
mm		0 PLC ±.5		APPLICATION SPEC						
		1 PLC ±0.13								
		2 PLC ±0.13								
		3 PLC ±0.013								
		4 PLC ±0.001								
		FINISH		WEIGHT	A 00779 ©=2150435		-			
MATERIAL				Customer Accessible Production Drawing	SCALE		1:1			
					SHEET		4 OF 4			
					REV		A			

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