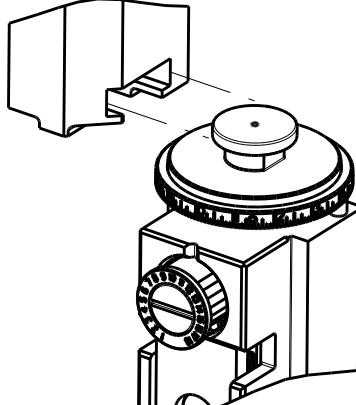
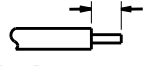


8		7	
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ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION
	2150805-2	A	FINE CRIMP HEIGHT ADJUST
	2150805-5	A	FINE CRIMP HEIGHT ADJUST
	2150805-6	A	NON-CRIMP HEIGHT ADJUST
	2150805-7	A	FINE CRIMP HEIGHT ADJUST
	7-2150805-7	A	CRIMP TOOLING KIT

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.54 mm [.100]	F
INSUL	4.57 mm [.180]	F
APPL INSTRUCTIONS 408-10390		

TERMINAL DATA: TE TERMINAL				TE CRIMP SPECIFICATION
TERMINAL NAME: RECEPTACLE SHUR PLUG .180				
WIRE STRIP LENGTH			INSULATION DIAMETER RANGE	
3.83-4.09 mm [.151-.161 IN]			Ø3.05-4.45 mm [.120-.175 IN]	
TERMINAL APPLICATION SPECIFICATION	114-2017	-	-	-
TERMINALS APPLIED ¹⁰ ¹¹ ¹²				
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL	
61412-1	61412-2			

WIRE SIZE			CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING ⁹
14 AWG			1.96+/-0.05 [.077+/- .002]		6.0
16 AWG			1.70+/-0.05 [.067+/- .002]		8.6
18 AWG			1.52+/-0.05 [.060+/- .002]		10.5



- 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:
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150805-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150805-5
SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2150805-6
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. 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 ITEMS 37 & 180.
- 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 TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- ¹¹ 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
- ¹² TERMINAL LUBRICANT IS RECOMMENDED.

*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	1803259-1	BUSHING, FLANGED	249
-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	DIS 66	REVISIONS						
			P	LTR	DESCRIPTION	DATE	DWN	APVD	
				1	DEVELOPMENT	26APR2017	MZ	KZ	
				A	RELEASED	09MAY2017	YY	KZ	

-	-	-	-	1	2119641-1	FEED CAM, AIR FEED	248
-	1	-	1	1	2119798-1	DETENT PIN	247
-	1	-	1	1	1-22279-3	SPRING, COMPRESSION	246
-	-	1	-	-	2119759-1	RAM, AMP STYLE, END FEED, NON-ADJUST	245
-	1	1	1	1	2119082-9	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
-	-	-	-	1	2063440-1	AIR FEED MODULE	238
-	-	1	1	-	2119740-2	TAG, IDENTIFICATION	213
-	-	REFREF	-	-	1901697-1	FEED FINGER ASSEMBLY, EF	183
-	1	1	1	1	2-1752354-1	STANDOFF, HOLD-DOWN	180
-	1	1	1	1	6-9931111-6	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
-	REFREFREFREFREF	-	-	-	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	2119955-2	ASSY, LUBRICATOR, END FEED	84
-	1	1	1	1	455888-5	SPACER, CRIMPER	82
-	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	2-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 14	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	2119792-2	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	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	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	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	1752371-1	PLATE, STRIP GUIDE	24
-	1	1	1	1	240825-3	PLATE, STRIP HOLD DOWN	23
-	2	2	2	2	22281-8	SPRING, COMPRESSION	22
-	1	1	1	1	1803292-4	DRAG	20
-	2	2	2	2	1901259-6	GUIDE, LOWER STRIP	18
-	4	4	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17
-	1	1	1	1	3-240641-1	SPACER	16
-	1	1	1	1	1752360-1	SPACER, HOLD-DOWN	13
-	1	1	1	1	240644-3	PLATE, REAR SHEAR	11
-	2	2	2	2	1-240645-6	SPACER, SHEAR PLATE	10
-	1	1	1	1	240642-4	PLATE, FRONT SHEAR	9
1	1	1	1	1	8-1803059-2	ANVIL, COMBINATION, END FEED	8
-	1	1	1	1	9-240651-0	BLADE, SLUG	7
-	-	-	-	-	-	-	6
-	1	1	1	1	240641-4	SPACER	5
-	1	1	1	1	238009-1	BLOCK, FL CRIMPER SPACER	4
1	1	1	1	1	2119582-3	CRIMPER, INSULATION F PREMIUM	3
-	1	1	1	1	455888-5	SPACER, CRIMPER	2
1	1	1	1	1	2-456407-2	CRIMPER, WIRE PREMIUM	1
-77	-7	-6	-5	-2	PART NO	DESCRIPTION	ITEM NO

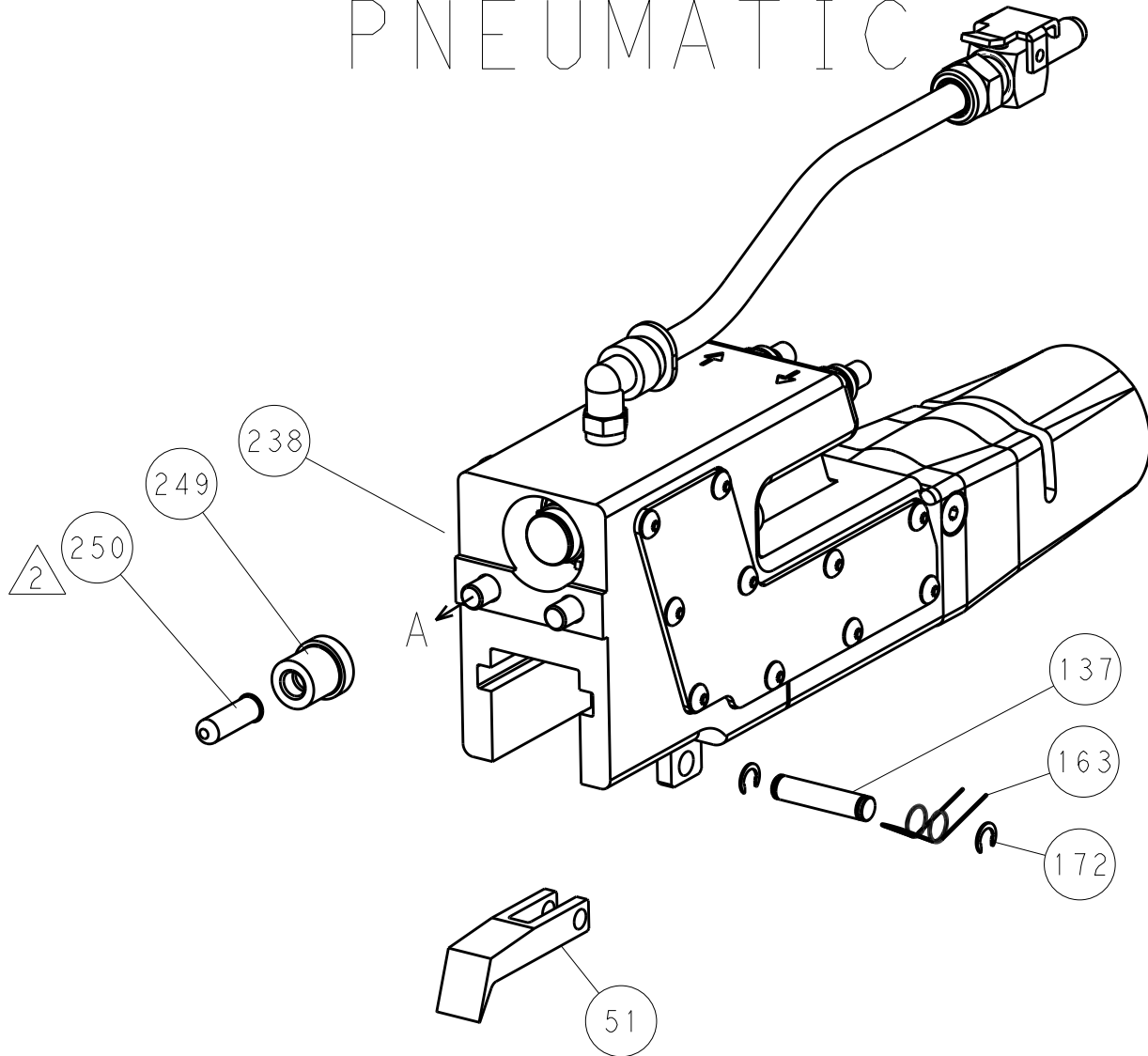
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DIMENSIONS: mm		CHK K. ZHANG 26APR2017	NAME Ocean End Feed Applicator	
TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.1 1 PLC ±.1 2 PLC ±.1 3 PLC ±.1 4 PLC ±.1 ANGLES ±.1		APVD K. ZHANG 26APR2017	PRODUCT SPEC APPLICATION SPEC	
MATERIAL -		FINISH -	SIZE A1	CAGE CODE 00779
Customer Accessible Production Drawing		SCALE 1:1	DRAWING NO ©=2150805	RESTRICTED TO -
SHEET 1 OF 4		REV A		

SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

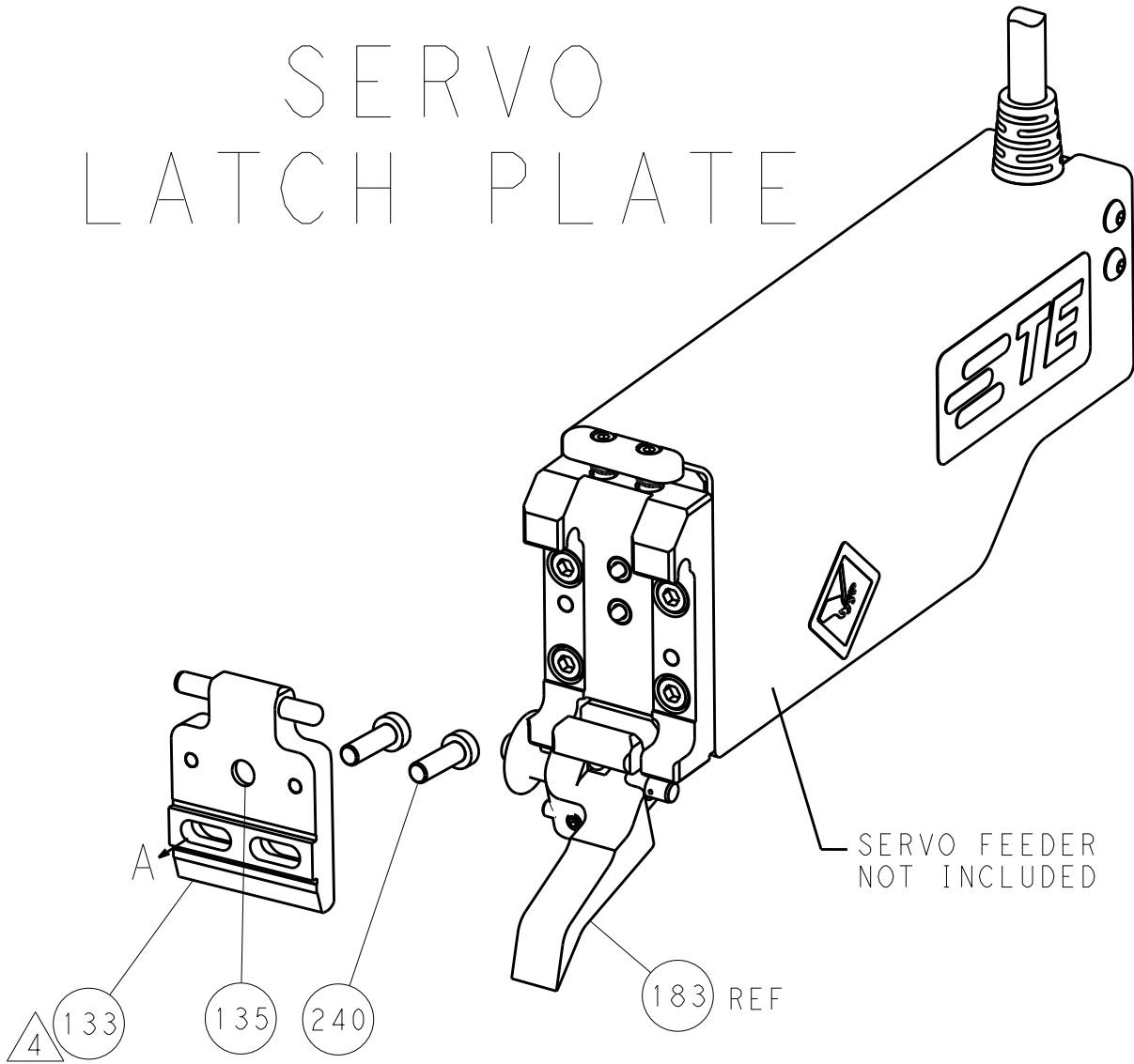
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P	LTR	DESCRIPTION		DATE	DWN	APVD	
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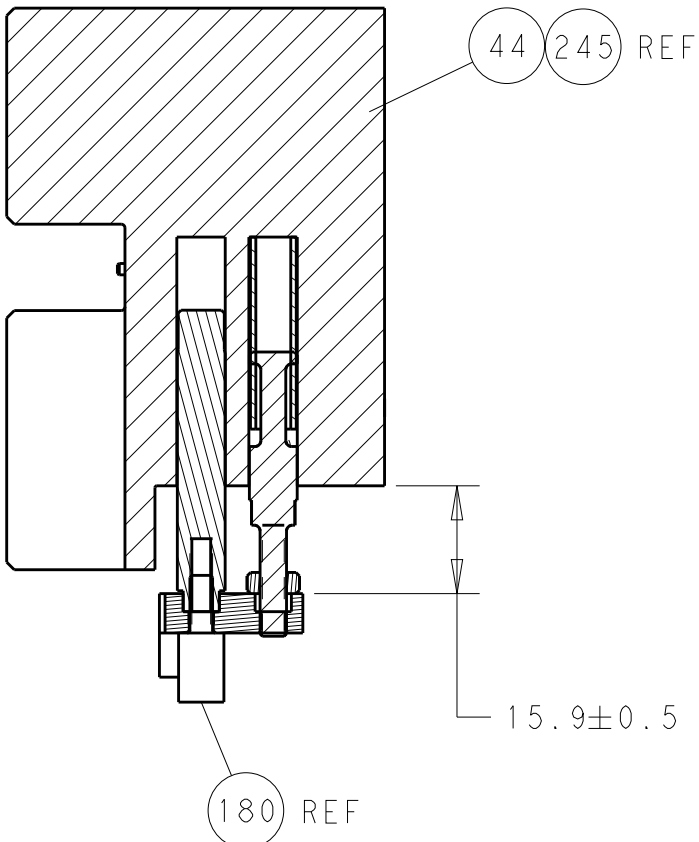
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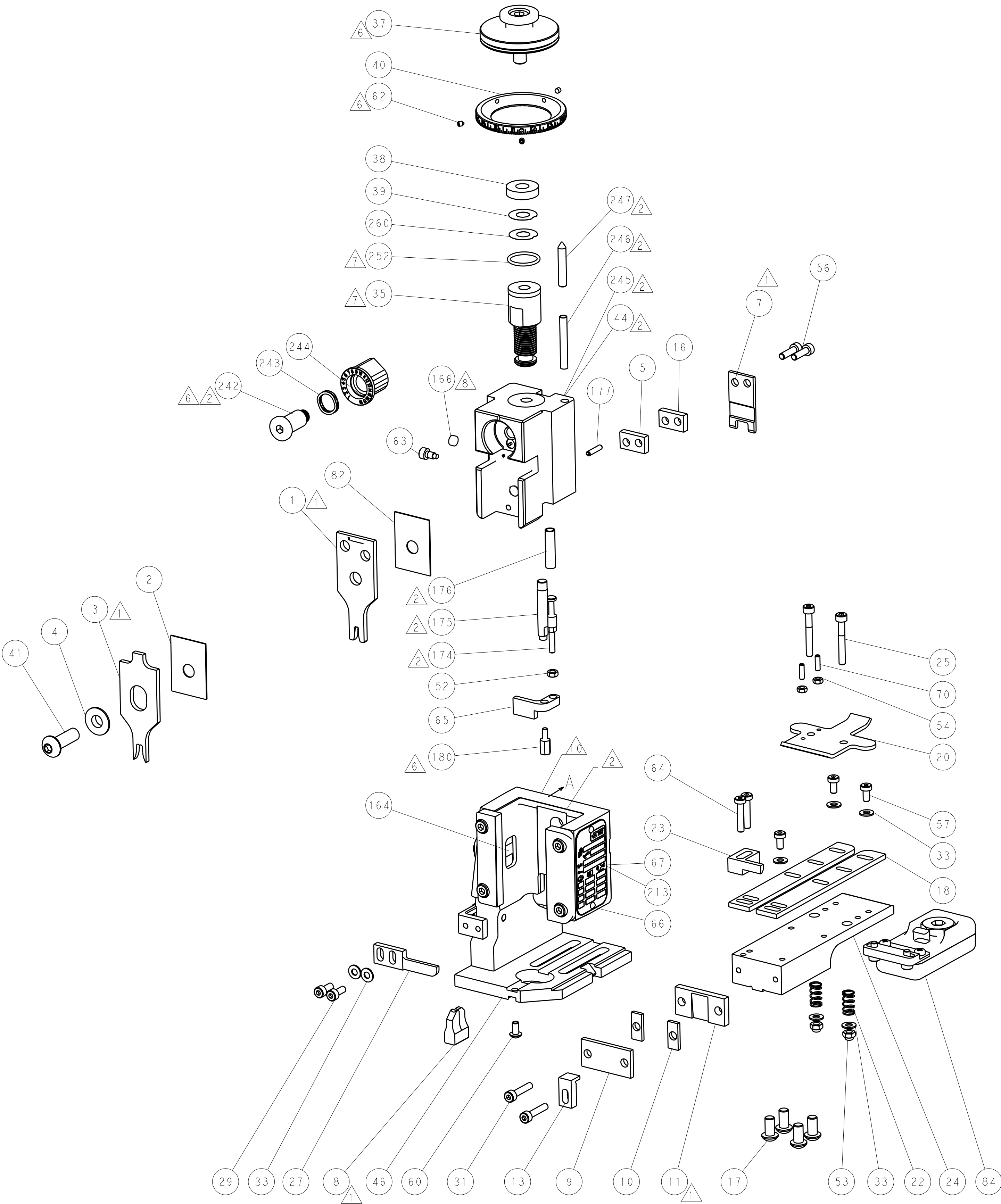
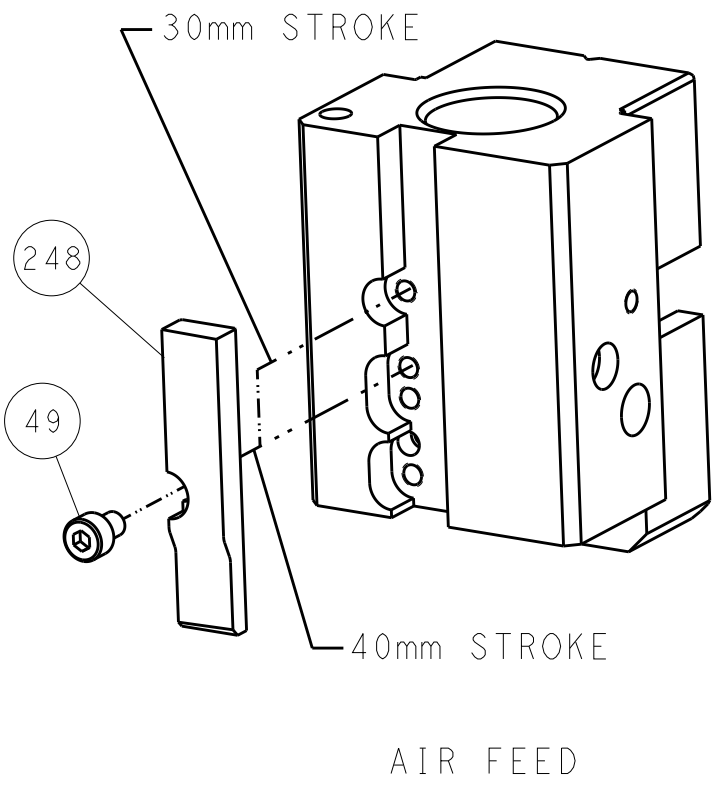
SERVO LATCH PLATE



HOLDDOWN SET-UP



CAM POSITION



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

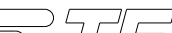
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DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.1 1 PLC ±.1 2 PLC ±.1 3 PLC ±.1 4 PLC ±.1 ANGLES ±.1 FINISH	NAME: Ocean End Feed Applicator	
MATERIAL: -		WEIGHT: -	SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2150805	RESTRICTED TO: -
Customer Accessible Production Drawing		SCALE: 1:1	SHEET: 2 OF 4	REV: A

SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

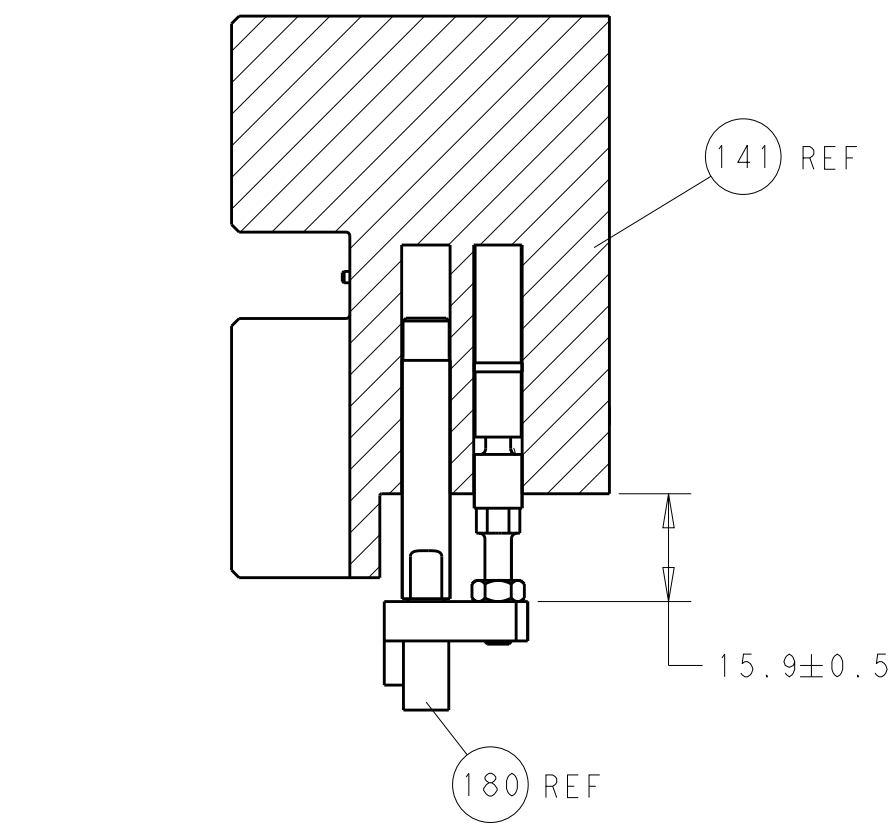
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TERMINAL NAME: RECEPTACLE SHUR PLUG .180			
WIRE STRIP LENGTH 3.83-4.09 mm [.151-.161 IN]		INSULATION DIAMETER RANGE Ø3.05-4.45 mm [.120-.175 IN]	
TERMINAL APPLICATION SPECIFICATION		 114-2017 - -	
TERMINALS APPLIED  			
TE TERMINAL 61412-1	TE TERMINAL 61412-2	TE TERMINAL	TE TERMINAL

AMP 4805 REV 31MAR2000

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: mm				TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±°		NAME Ocean End Feed Applicator -			
				CHK K.ZHANG 26APR2017		PRODUCT SPEC - APPLICATION SPEC -			
				APVD K.ZHANG 26APR2017					
MATERIAL	FINISH			WEIGHT	-	SIZE CASE CODE DRAWING NO A 00779 C=2150805		RESTRICTED TO -	
Customer Accessible Production Drawing						SCALE 1:1		SHEET 3 OF 4	
								REV A	

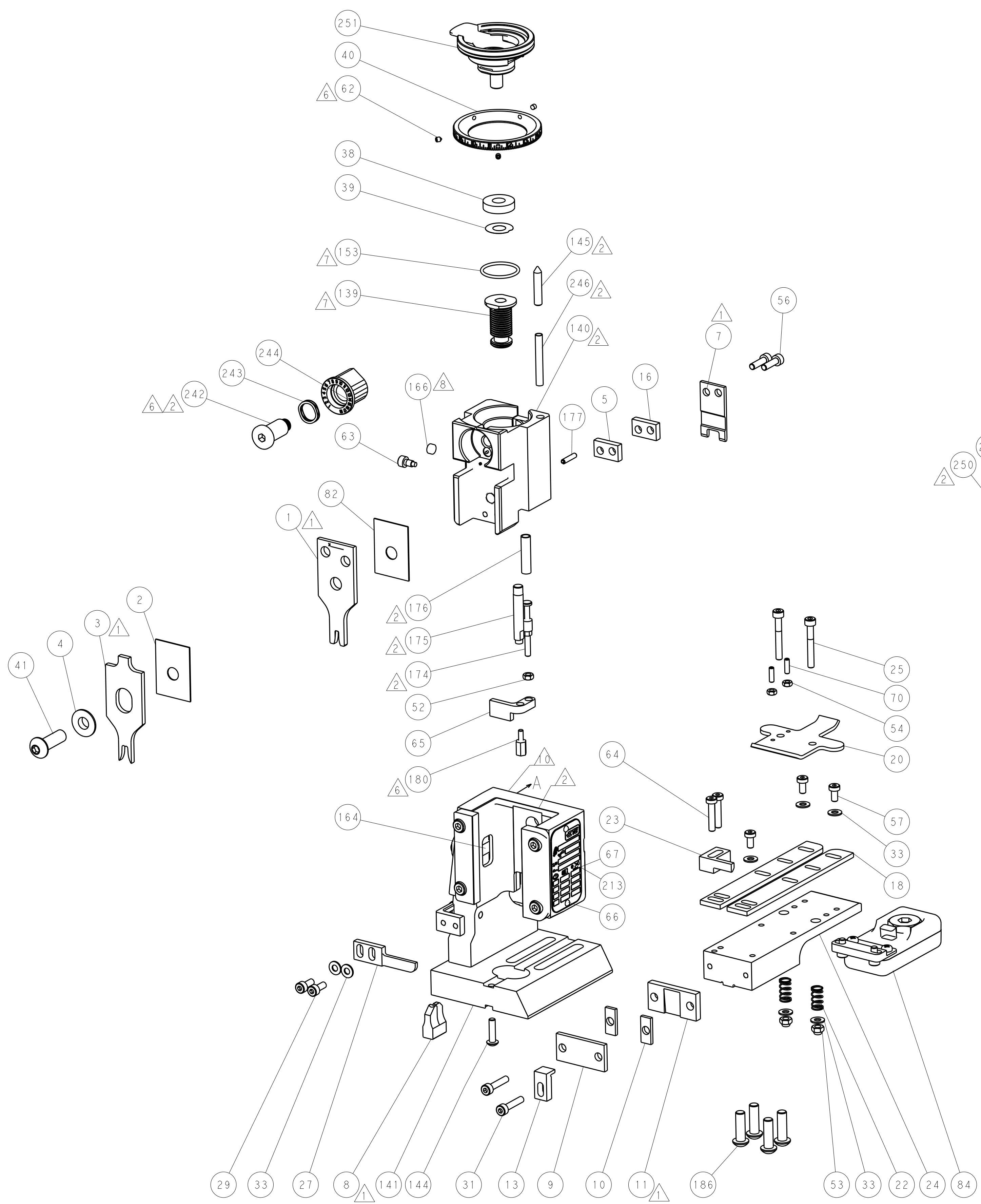
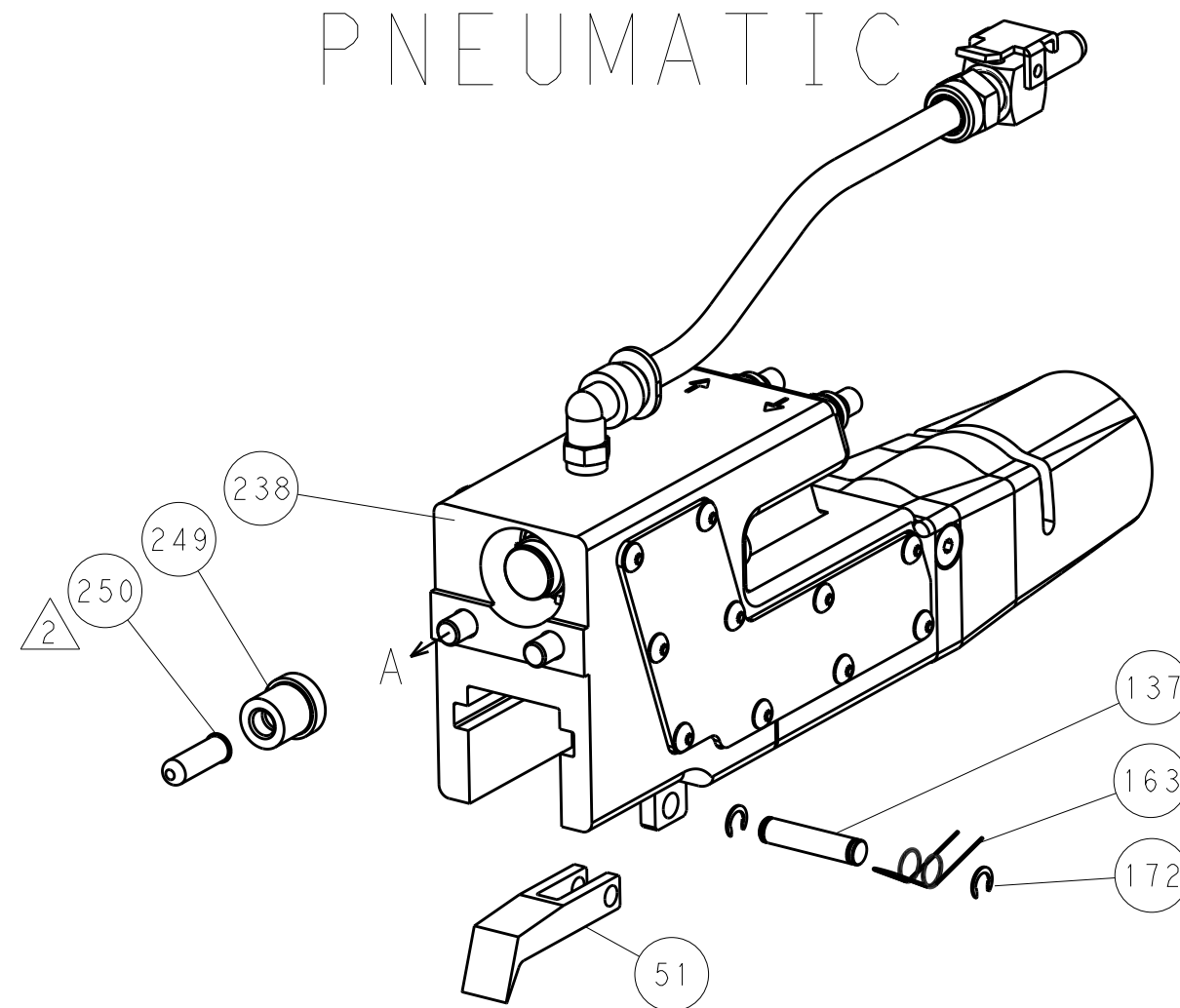
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A	66	P	LTR	DESCRIPTION	DATE	DWN	APVD
		-		SEE SHEET 1	-	-	-



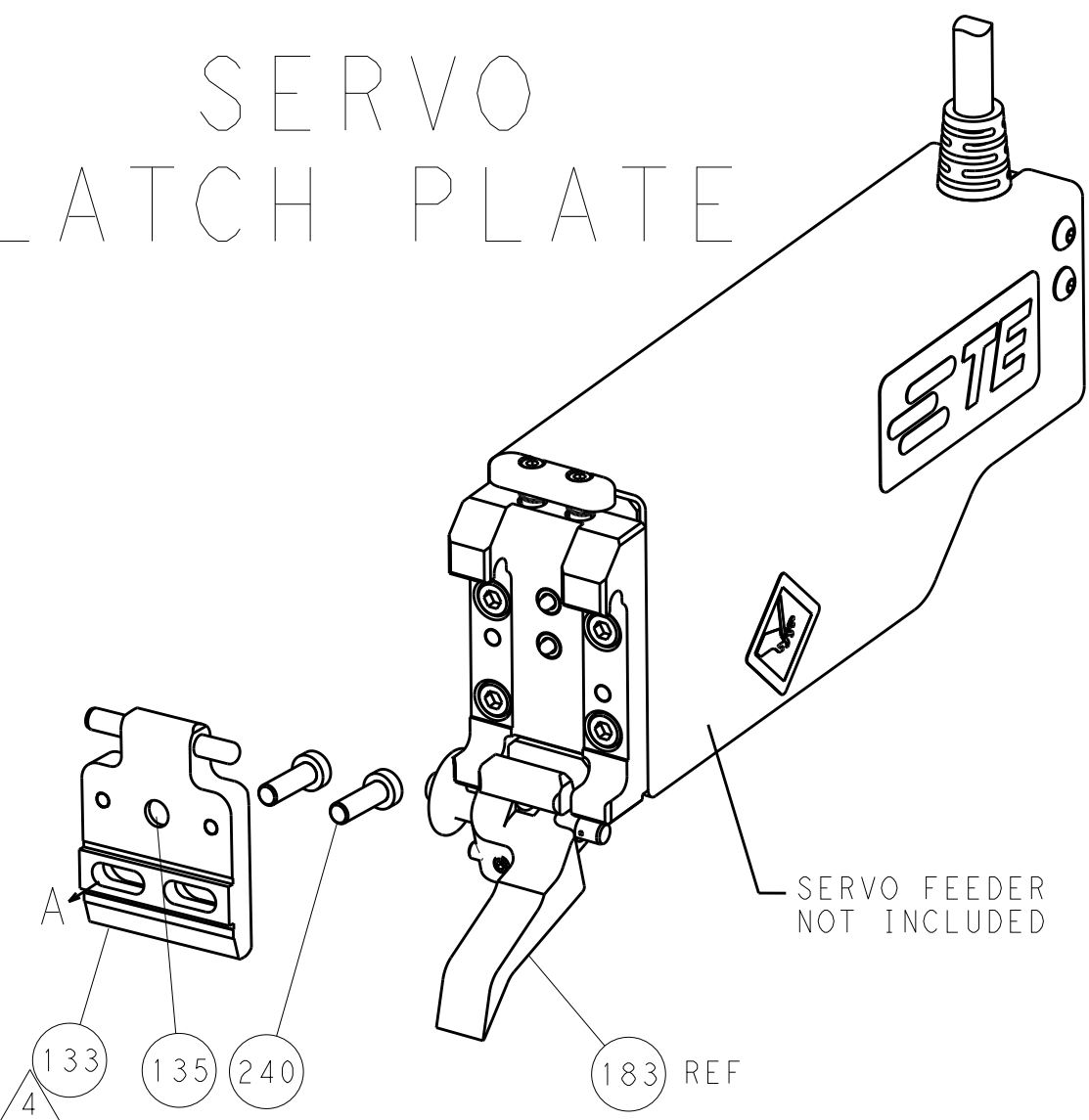
HOLDDOWN SET-UP

FEED TYPE

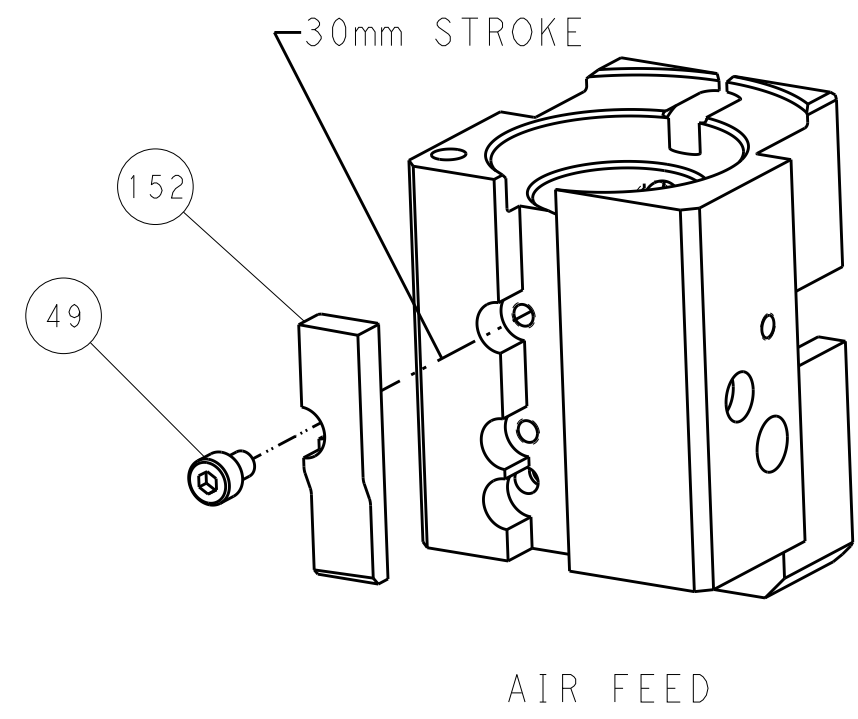
PNEUMATIC



SERVO
LATCH PLATE



CAM POSITION



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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DIMENSIONS: mm		CHK K. ZHANG 26APR2017	NAME Ocean End Feed Applicator	
TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH		APVD K. ZHANG 26APR2017	SIZE A1 00779 C=2150805	
MATERIAL		PRODUCT SPEC	RESTRICTED TO	
		APPLICATION SPEC	Customer Accessible Production Drawing	
		WEIGHT	SCALE 1:1 SHEET 4 OF 4 REV A	

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