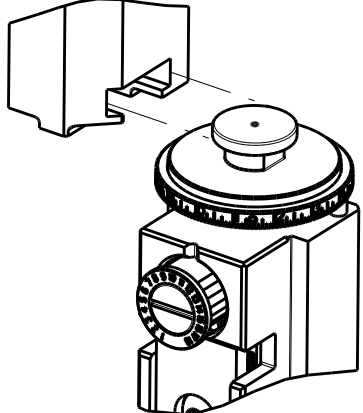
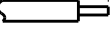
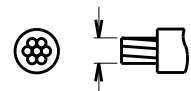


8		7	
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ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION
	2150522-2	A	FINE CRIMP HEIGHT ADJUST
	2150522-5	A	FINE CRIMP HEIGHT ADJUST
	2150522-6	A	NON-CRIMP HEIGHT ADJUST
	2150522-7	A	FINE CRIMP HEIGHT ADJUST
	7-2150522-7	A	CRIMP TOOLING KIT

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

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: TAB, FASTIN-FASTON, .187 SERIES			
WIRE STRIP LENGTH 4.20-5.10 mm [.165-.201 IN]		 INSULATION DIAMETER RANGE Ø2.79-3.81 mm [.110-.150 IN]	
TERMINAL APPLICATION SPECIFICATION	 NONE	-	-
TERMINALS APPLIED 			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
1742800-1			

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING ⁹
14 AWG		2.24+/-0.05 [.088+/- .002]		3.2
16 AWG		1.98+/-0.05 [.078+/- .002]		6.2
18 AWG		1.83+/-0.05 [.072+/- .002]		7.8



- 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: 8-2150522-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150522-5
SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2150522-6
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

*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.

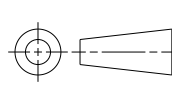
-	-	1	-	-	2119957-2	APPLICATOR SHIM PACK	260
-	1	-	1	1	8-21084-0	O-RING, .676 ID, .070 DIA. MAT.	252
-	-	-	-	1	2119640-1	PUSH ROD, AIR FEED	250
-	-	-	-	1	2079988-1	BUSHING, LCH5-12, MISUMI	249
-	-	-	-	1	2119641-1	FEED CAM, AIR FEED	248
-	1	-	1	1	2119798-1	DETENT PIN	247
-	1	-	1	1	1-22279-3	SPRING, COMPRESSION	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
-77	-7	-6	-5	-2	PART NO	DESCRIPTION	ITEM NO

⁶

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
				A	RELEASED	19FEB2015

-	-	-	-	-	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	-	-	-	1	2063440-2	AIR FEED MODULE	238
-	-	1	1	-	2119740-2	TAG, IDENTIFICATION	213
-	-	REF	REF	-	1901697-1	FEED FINGER ASSEMBLY, EF	183
⁶ -	1	1	1	1	1-1752354-0	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
-	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	-	-	-	1	240638-1	SPRING, FEED FINGER	163
-	2	2	2	2	18024-1	SCR, BTN SKT HD CAP (M3 X 6.0)	144
-	1	1	1	1	1-1976053-3	LOCATER BLOCK, TERMINAL	143
-	-	-	-	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	455888-4	SPACER, CRIMPER	82
-	1	1	1	1	2119791-5	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	1	1	2119943-1	WASHER, SPACER	69
-	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	1901681-8	HOLDDOWN, TERMINAL	65
⁶ -	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
-	-	-	-	-	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	-	-	-	-	2063961-1	FEED FINGER	58
-	4	4	4	4	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57
-	2	2	2	2	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	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	2119792-2	PAWL, EF, AIR	51
-	-	-	-	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	-	-	-	-	2119652-1	FEED CAM, PRE FEED	48
-	-	-	-	-	2119653-1	FEED CAM, POST FEED	47
-	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
⁶ -	1	1	1	1	2119085-1	FA HEAD, ATLANTIC STYLE	37
-	1	-	1	1	2119092-1	BOLT, ADJUSTMENT	35
-	8	8	8	8	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	1320906-1	STUD, THREADED	25
-	1	1	1	1	1752371-5	PLATE, STRIP GUIDE	24
-	2	2	2	2	2-22281-3	SPRING, COMPRESSION	22
-	1	1	1	1	1752373-4	DRAG	20
-	1	1	1	1	1-1901696-9	STRIP GUIDE, REAR	19
-	1	1	1	1	1-1901695-9	STRIP GUIDE, FRONT	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	1	240644-1	PLATE, REAR SHEAR	11
-	2	2	2	2	1-240645-4	SPACER, SHEAR PLATE	10
¹ -	1	1	1	1	240642-4	PLATE, FRONT SHEAR	9
¹ -	1	1	1	1	6-1633383-6	ANVIL, COMBINATION	8
¹ -	1	1	1	1	9-240651-1	BLADE, SLUG	7
-	-	-	-	-	-	-	6
-	1	1	1	1	5-240641-5	SPACER	5
-	1	1	1	1	238009-1	BLOCK, FL CRIMPER SPACER	4
¹ -	1	1	1	1	6-2119784-0	CRIMPER, INSULATION O PREMIUM	3
-	1	1	1	1	455888-3	SPACER, CRIMPER	2
¹ -	1	1	1	1	456407-4	CRIMPER, WIRE PREMIUM	1
-77	-7	-6	-5	-2	PART NO	DESCRIPTION	ITEM NO

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DIMENSIONS:		CHK G. BAILEY	23DEC2014	NAME	
mm		APVD G. BAILEY	23DEC2014	Ocean End Feed Applicator	
		TOLERANCES UNLESS OTHERWISE SPECIFIED:		PRODUCT SPEC	
				APPLICATION SPEC	
MATERIAL		FINISH		WEIGHT	
-		-		-	
				Customer Accessible Production Drawing	
				SCALE 1:1	
				SHEET 1 OF 4	
				REV A	

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: TAB, FASTIN-FASTON, .187 SERIES			
WIRE STRIP LENGTH 4.20-5.10 mm [.165-.201 IN]		INSULATION DIAMETER RANGE Ø2.79-3.81 mm [.110-.150 IN]	
TERMINAL APPLICATION 		NONE - -	
SPECIFICATION		- -	
TERMINALS APPLIED 			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
1742800-1			



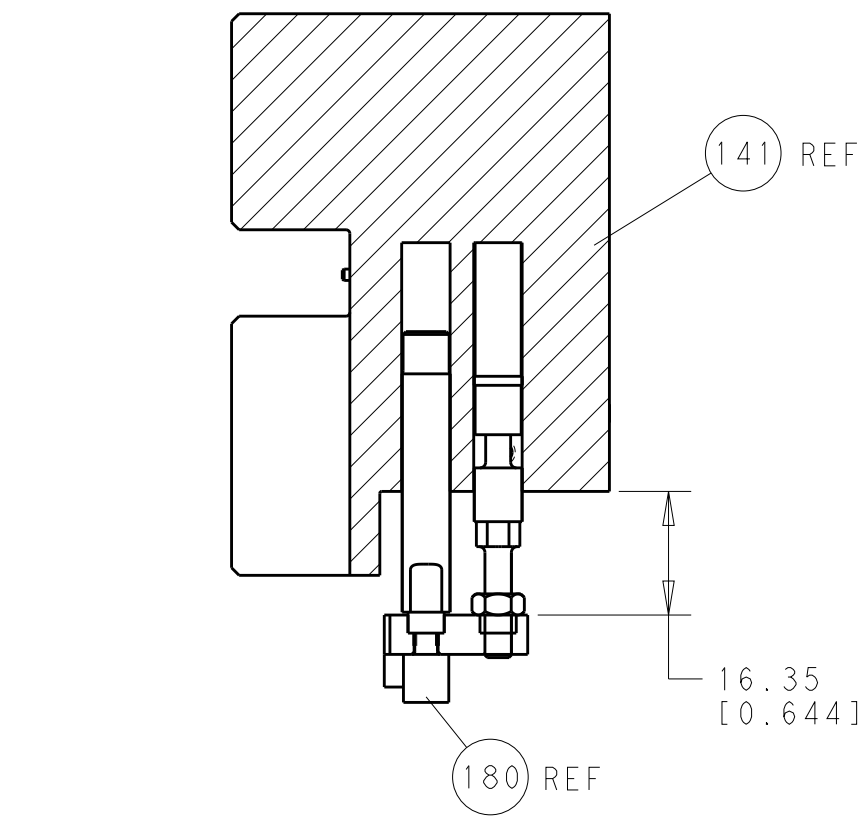
- ```
*WARNING
ON INSTALLATION, SET WIRE DISC, ITEM 40 TO
LARGEST WIRE SIZE SETTING. USE OF SETTINGS
BELOW MINIMUM REQUIRED CRIMP HEIGHT SETTING
WILL CAUSE DAMAGE TO CRIMP TOOLING.
```

△  
6

| SET UP GAUGE<br>2119599-2 |     |             |     | LOC<br>A    | DIST<br>66                          | REVISIONS |      |  |  |  |
|---------------------------|-----|-------------|-----|-------------|-------------------------------------|-----------|------|--|--|--|
| P                         | LTR | DESCRIPTION |     |             | DATE                                | DWN       | APVD |  |  |  |
|                           | -   | SEE SHEET 1 |     |             | -                                   | -         | -    |  |  |  |
|                           |     |             |     |             |                                     |           |      |  |  |  |
|                           |     |             |     |             |                                     |           |      |  |  |  |
|                           |     |             |     |             |                                     |           |      |  |  |  |
| -                         | -   | 1           | -   | 2119740-2   | TAG, IDENTIFICATION                 |           | 213  |  |  |  |
| -                         | 4   | 4           | 4   | 2079383-9   | SCR, BHSC, RoHS (M6 X 20)           |           | 186  |  |  |  |
| -                         | -   | REF         | -   | 1901697-1   | FEED FINGER ASSEMBLY, EF            |           | 183  |  |  |  |
| -                         | 1   | 1           | 1   | 1-1752354-0 | STANDOFF, HOLD-DOWN                 |           | 180  |  |  |  |
| -                         | 1   | 1           | 1   | 6-993111-6  | PIN, SLOTTED SPRING 3.0 X 14.0      |           | 177  |  |  |  |
| -                         | 1   | 1           | 1   | 8-22280-7   | SPRING, COMPRESSION                 |           | 176  |  |  |  |
| -                         | 1   | 1           | 1   | 1752353-2   | GUIDE PIN, HOLDDOWN                 |           | 175  |  |  |  |
| -                         | 1   | 1           | 1   | 1901680-2   | GUIDE PIN, HOLDDOWN                 |           | 174  |  |  |  |
| -                         | -   | -           | 2   | 21045-3     | RING, RETAIN, EXTERN, 3/16 CRESCENT |           | 172  |  |  |  |
| -                         | 1   | 1           | 1   | 994969-1    | MAGNET, RARE EARTH HIGH ENERGY      |           | 166  |  |  |  |
| -                         | REF | REF         | REF | 994970-2    | COUNTER, MAGNETIC                   |           | 164  |  |  |  |
| -                         | -   | -           | 1   | 240638-1    | SPRING, FEED FINGER                 |           | 163  |  |  |  |
| -                         | 1   | 1           | 1   | 8-21084-1   | O-RING, .801 ID, .070 DIA. MAT.     |           | 153  |  |  |  |
| -                         | -   | -           | 1   | 2119641-2   | FEED CAM, AIR FEED                  |           | 152  |  |  |  |
| -                         | 1   | 1           | 1   | 2119798-2   | DETENT PIN                          |           | 145  |  |  |  |
| -                         | 2   | 2           | 2   | 18024-1     | SCR, BTN SKT HD CAP (M3 X 6.0)      |           | 144  |  |  |  |
| -                         | 1   | 1           | 1   | 2079383-8   | SCR, BHSC, RoHS (M4 X 16)           |           | 144  |  |  |  |
| -                         | 1   | 1           | 1   | 1-1976053-3 | LOCATER BLOCK, TERMINAL             |           | 143  |  |  |  |
| -                         | -   | -           | -   | 2119653-2   | FEED CAM, POST FEED                 |           | 142  |  |  |  |
| -                         | 1   | 1           | 1   | 2119655-6   | APPLICATOR BASIC ASSEMBLY, EF       |           | 141  |  |  |  |
| -                         | 1   | 1           | 1   | 2119651-1   | RAM, ASIAN STYLE, END FEED          |           | 140  |  |  |  |
| -                         | 1   | 1           | 1   | 2119092-2   | BOLT, ADJUSTMENT                    |           | 139  |  |  |  |
| -                         | -   | -           | 1   | 3-23627-7   | PIN, RETAIN, GRVD, 3/16 X .854      |           | 137  |  |  |  |
| -                         | -   | REF         | -   | SEE NOTE 4  | MEMORY CHIP, PROGRAMMED             |           | 135  |  |  |  |
| -                         | -   | 1           | -   | 1633743-1   | SERVO FEED LATCH ASM                |           | 133  |  |  |  |
| -                         | 1   | 1           | 1   | 455888-4    | SPACER, CRIMPER                     |           | 82   |  |  |  |
| -                         | 1   | 1           | 1   | 2119791-5   | DEPRESSOR, WIRE                     |           | 73   |  |  |  |
| -                         | 1   | 1           | 1   | 2119956-2   | DOCUMENTATION PACKAGE               |           | 71   |  |  |  |
| -                         | 2   | 2           | 2   | 2-18032-2   | SCR, SET, FLT POINT M3 X 10.0       |           | 70   |  |  |  |
| -                         | 1   | 1           | 1   | 2119943-1   | WASHER, SPACER                      |           | 69   |  |  |  |
| -                         | 1   | -           | 1   | 2119740-1   | TAG, IDENTIFICATION                 |           | 67   |  |  |  |
| -                         | 2   | 2           | 2   | 2168078-1   | SCREW, DRIVE, RH, RoHS, 2 x .188    |           | 66   |  |  |  |
| -                         | 1   | 1           | 1   | 1901681-8   | HOLDDOWN, TERMINAL                  |           | 65   |  |  |  |
| -                         | 1   | 1           | 1   | 2119793-1   | LIMITER, ADJUSTMENT BOLT            |           | 63   |  |  |  |
| -                         | 3   | 3           | 3   | 992763-5    | SCR, SET, SOC, CONE POINT, M3 X 4.0 |           | 62   |  |  |  |
| -                         | -   | -           | -   | 5-18022-5   | SCR, HEX HD CAP, M4 X 6.0           |           | 59   |  |  |  |
| -                         | -   | -           | -   | 2063961-1   | FEED FINGER                         |           | 58   |  |  |  |
| -                         | 4   | 4           | 4   | 2168400-4   | SHCS, LOW HEAD, RoHS, M4 X 8        |           | 57   |  |  |  |
| -                         | 2   | 2           | 2   | 2168083-9   | SCR, SKT HD CAP, RoHS, M4 X 20      |           | 56   |  |  |  |
| -                         | 2   | 2           | 2   | 5018030-2   | NUT, HEX, REG, RoHS, M4             |           | 55   |  |  |  |
| -                         | 2   | 2           | 2   | 5018030-1   | NUT, HEX, REG, RoHS, M3             |           | 54   |  |  |  |
| -                         | 2   | 2           | 2   | 986965-8    | NUT, LOCK, HEX, TORQUE (M4)         |           | 53   |  |  |  |
| -                         | 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   |  |  |  |
| -                         | -   | -           | -   | 2119652-1   | FEED CAM, PRE FEED                  |           | 48   |  |  |  |
| -                         | 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   |  |  |  |
| -                         | 8   | 8           | 8</ |             |                                     |           |      |  |  |  |

 $\wedge$  $\triangle$  $\Delta$

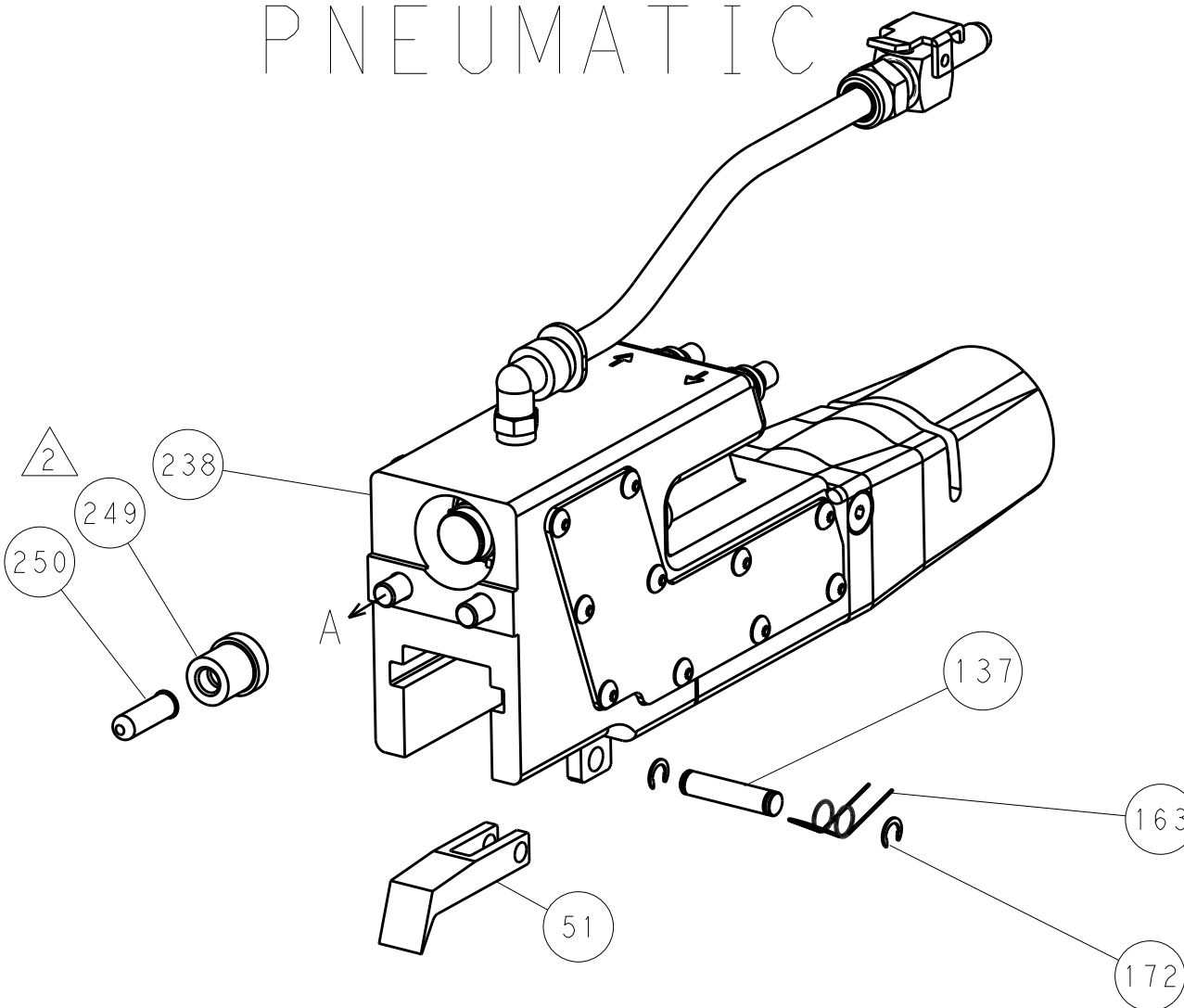
| LOC |  | DIST |  | REVISIONS |     |             |      |     |      |
|-----|--|------|--|-----------|-----|-------------|------|-----|------|
| A   |  | 66   |  | P         | LTR | DESCRIPTION | DATE | DWN | APVD |
|     |  |      |  |           | -   | SEE SHEET 1 | -    | -   | -    |
|     | 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



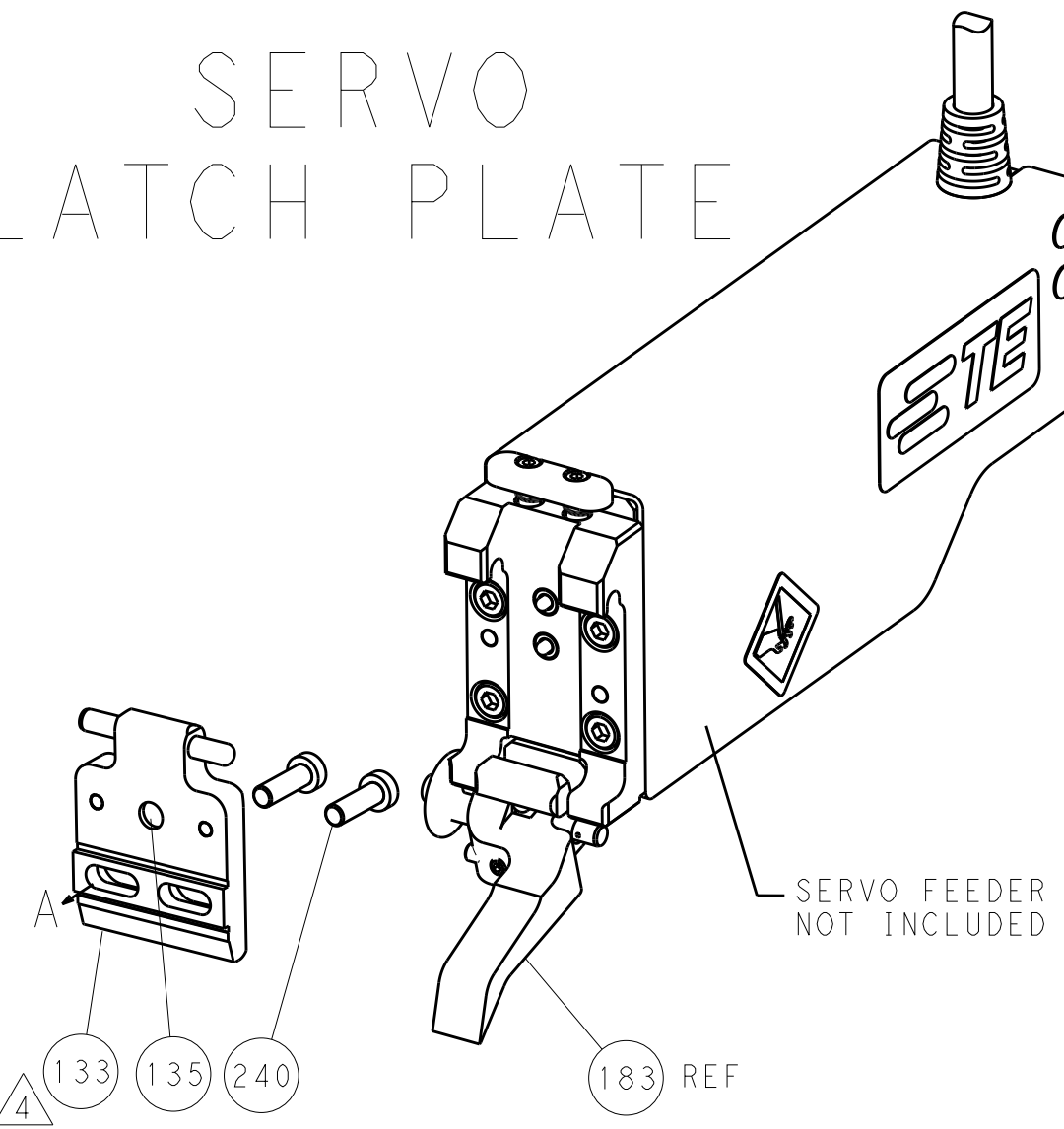
HOLDDOWN SET-UP

FEED TYPE

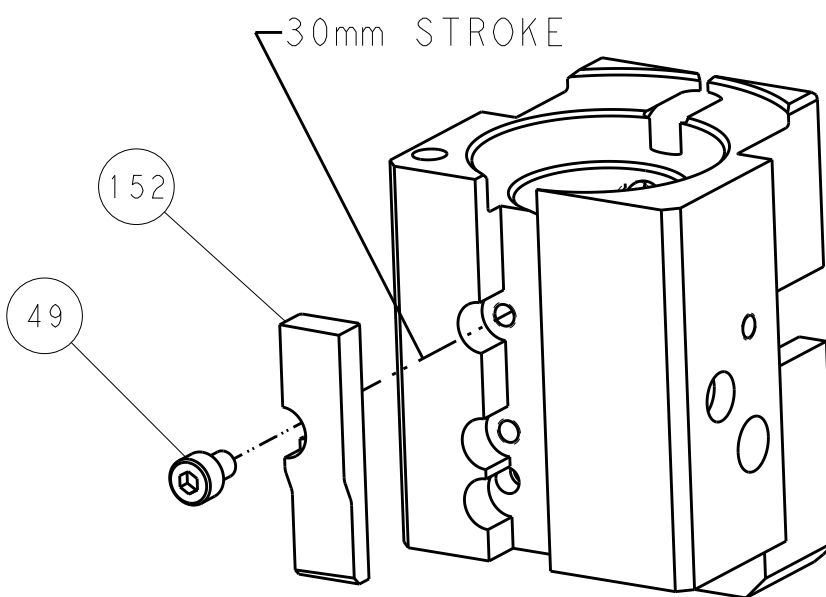
PNEUMATIC



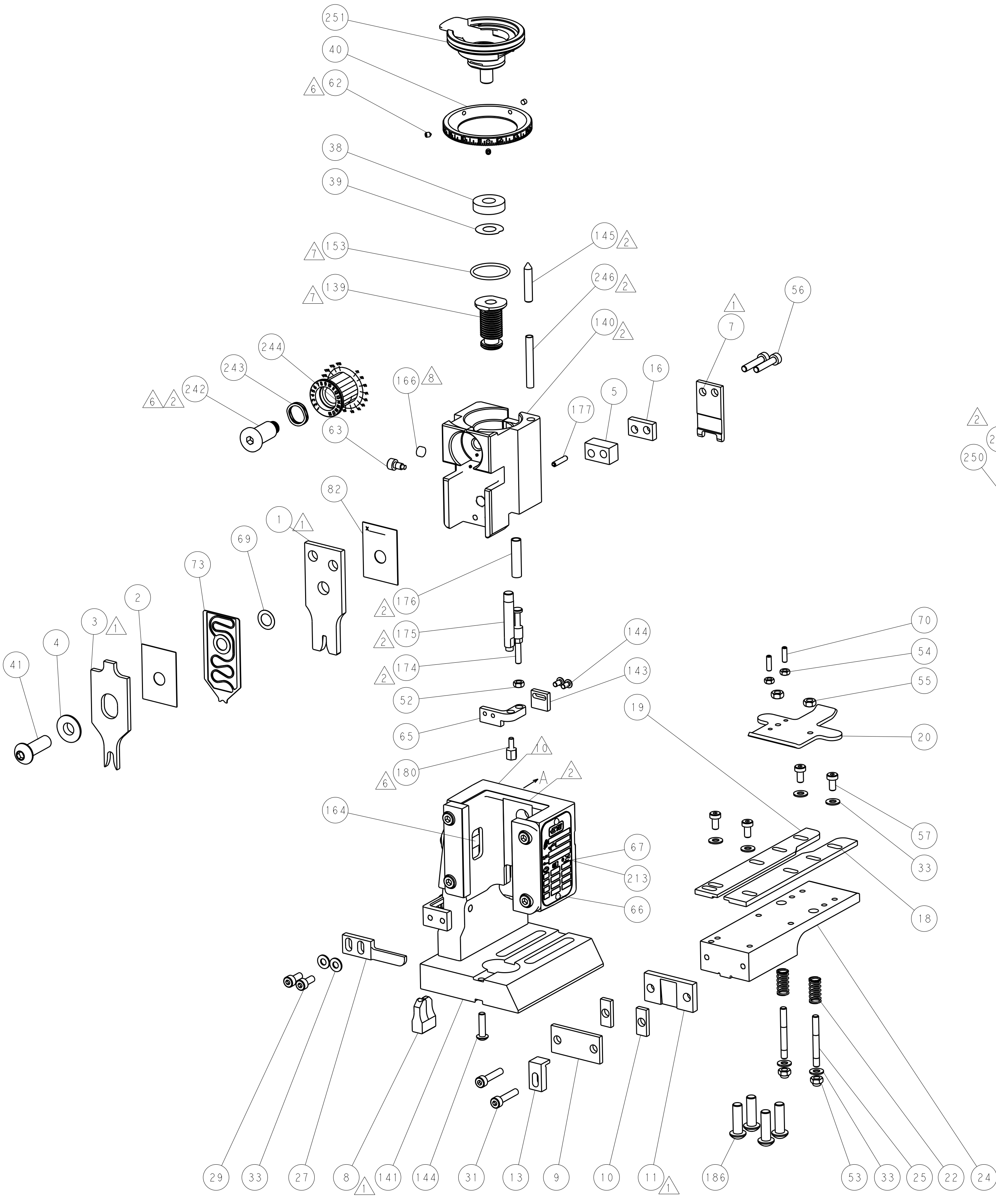
SERVO  
LATCH PLATE



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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|                                                                                                                                                                                                |  |  |  | CHK<br>G. BAILEY 23DEC2014             |                                                                                                                                    |  |
|                                                                                                                                                                                                |  |  |  | APVD<br>G. BAILEY 23DEC2014            | NAME<br>Ocean End Feed<br>Applicator                                                                                               |  |
|                                                                                                                                                                                                |  |  |  | PRODUCT SPEC                           |                                                                                                                                    |  |
|                                                                                                                                                                                                |  |  |  | APPLICATION SPEC                       |                                                                                                                                    |  |
|                                                                                                                                                                                                |  |  |  | WEIGHT                                 |                                                                                                                                    |  |
|                                                                                                                                                                                                |  |  |  | Customer Accessible Production Drawing |                                                                                                                                    |  |
|                                                                                                                                                                                                |  |  |  | SCALE<br>1:1                           | SHEET<br>4 OF 4                                                                                                                    |  |
|                                                                                                                                                                                                |  |  |  |                                        | REV<br>A                                                                                                                           |  |