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1

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RELEASED FOR PUBLICATION

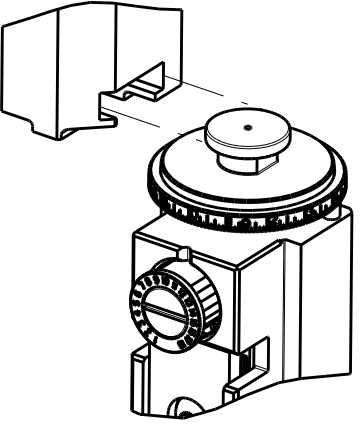
20

20

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ATLANTIC VERSION
TERMINATOR
INTERFACE ADAPTER



PART
NUMBER

2151353-1

REVISION

G

DESCRIPTION

FINE CRIMP HEIGHT ADJUST

FEED TYPE

MECHANICAL

CONVERT TO

PNEUMATIC FEED

PART NUMBERS REQUIRED

2119950-1

2119951-1

2119944-1

2161326-1

2119949-1

2119951-1

2161326-1

2119949-1

1338685-1

2119950-1

-

-

-

2151353-2

G

FINE CRIMP HEIGHT ADJUST

PNEUMATIC

MECHANICAL FEED

2119949-1

1338685-1

5-18022-5

2119653-1

-

-

-

2151353-5

G

FINE CRIMP HEIGHT ADJUST

SERVO
LATCH PLATE⁴

MECHANICAL FEED

2119949-1

1338685-1

5-18022-5

2119653-1

-

-

-

2151353-6

G

NON-CRIMP HEIGHT ADJUST

SERVO
LATCH PLATE⁴¹²

-

-

-

-

-

-

2151353-7

G

FINE CRIMP HEIGHT ADJUST

NONE

-

-

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-

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-

7-2151353-7

A

CRIMP TOOLING KIT

-

-

-

-

-

-

APPLICATOR DATA

CRIMP	SIZE	TYPE
WIRE	1.78 mm [.070]	F
INSUL	2.29 mm [.090]	BX

APPLICATOR INSTRUCTIONS
408-10389



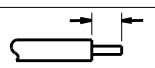
TERMINAL DATA: TE TERMINAL

TE CRIMP SPECIFICATION

TERMINAL NAME: MCON 1.2 LL

WIRE STRIP LENGTH

3.30-3.90 mm [.130-.154 IN]



INSULATION DIAMETER RANGE

Ø1.90-2.40 mm [.075-.094 IN]

TERMINAL APPLICATION SPECIFICATION

114-18464

-

-

TERMINALS APPLIED

TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
1452659-1	1452659-2	1452659-3	
7-1452659-1	7-1452659-2	7-1452659-3	

WIRE SIZE



CRIMP HEIGHT mm [INCH]



CRIMP HEIGHT REFERENCE SETTING



1.50mm2	1.31+/-0.05 [.052+/- .002]	8.0
16 AWG	1.26+/-0.05 [.050+/- .002]	8.5
1.00mm2	1.10+/-0.05 [.043+/- .002]	10.0
18 AWG	1.05+/-0.05 [.041+/- .002]	10.6

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: 8-2151353-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151353-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151353-5
SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2151353-6

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 -6 NON-CRIMP HEIGHT ADJUST APPLICATOR USE SHIM PACK 2119957-2 TO ALIGN APPLICATOR'S MAXIMUM WIRE CRIMP HEIGHT AT NORMAL TERMINATOR SHUT HEIGHT

ATLANTIC VERSION

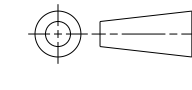
Shown on sheets 1 of 4 & 2 of 4

(Pacific version shown on sheets 3 of 4 & 4 of 4)

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DIMENSIONS:

mm



TOLERANCES UNLESS OTHERWISE SPECIFIED:

0 PLC ±.5

1 PLC ±0.13

2 PLC ±0.13

3 PLC ±0.013

4 PLC ±0.0001

ANGLES ±.5

FINISH

MATERIAL

-

DWN

L. ZHANG

26 JUL 2012

CHK

L. ZHANG

26 JUL 2012

APVD

S. XI

26 JUL 2012

NAME

Ocean Side Feed Applicator

SIZE

CAGE CODE

DRAWING NO

00779

©=2151353

RESTRICTED TO

-

Customer Accessible Production Drawing

SCALE

1:2

SHEET

1

OF

4

REV

G

SET UP GAUGE

2119599-1

LOC

A

DIST

66

REVISIONS

P	LTR	DESCRIPTION	DATE	DWN	APVD
E		ECR-15-012530	09SEP2015	MR	CT
F		ECR-15-014230	28SEP2015	JH	TE
G		ECR-15-014766	10OCT2015	JH	TE

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1

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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

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1

1

1

1-22279-3

SPRING, COMPRESSION

246

-

-

1

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-

-

2119758-1

RAM, AMP STYLE, SIDE FEED, NON-ADJ.

245

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1

1

1

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2119082-4

CAM, SNAIL, INSULATION ADJUSTMENT

244

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1

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2079764-1

WASHER, WAVE SPRING, CREST-TO-CREST

243

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1

1

1

1

1

2119083-1

RETAINER, INSULATION DIAL

242

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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

-

-

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-

-

1

2119580-1

MECHANICAL FEED ASSEMBLY

239

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-

-

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1

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2063440-1

AIR FEED MODULE

238

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1

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2119740-2

TAG, IDENTIFICATION

213

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-

1

1

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1901094-3

SPACER, FEEDER

198

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-

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2

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21045-3

RING, RETAIN, EXTERN, 3/16 CRESCENT

172

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1

1

1

1

1

994969-1

MAGNET, RARE EARTH HIGH ENERGY

166

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REF

REF

REF

REF

REF

994970-2

COUNTER, MAGNETIC

164

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1

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240638-1

SPRING, FEED FINGER

163

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1

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3-23627-7

PIN, RETAIN, GRVD, 3/16 X .854

137

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1

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2119799-1

HOLDER, FEED FINGER, AF

136

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REF

REF

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SEE NOTE 4

MEMORY CHIP, PROGRAMMED

135

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1

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1633743-1

SERVO FEED LATCH ASM

133

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1-18028-2

WASHER, FLAT, REG M4

119

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REF

REF

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2119944-1

FEED FINGER ASSEMBLY, SF

117

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455888-5

SPACER, CRIMPER

82

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22278-8

SPRING, COMPRESSION

77

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854769-4

HOLDER, INS

74

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2119956-1

DOCUMENTATION PACKAGE

71

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1

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1

2119740-1

TAG, IDENTIFICATION

67

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2

2

2

2

2

2168078-1

SCREW, DRIVE, RH, RoHS, 2 x .188

66

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1

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1

1

2119793-1

LIMITER, ADJUSTMENT BOLT

63

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3

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3

3

3

992763-5

SCR, SET, SOC, CONE POINT, M3 x 4.0

62

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2079383-4

SCR, BHSC, RoHS (M4 X 8)

60

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5-18022-5

SCR, HEX HD CAP, M4 X 6.0

59

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1

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21028-2

PIN, SLOTTED SPRING .062 X .250

58

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1

1

1338685-1

PAWL, FEED

56

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4

4

4

4

4

2168400-1

SHCS, LOW HEAD, RoHS, M4 X 12

54

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2

2

2

2

2

1-2168083-0

SCR, SKT HD CAP, RoHS, M4 X 10

53

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2

18023-9

SCR, SKT HD CAP M4 X 6.0

49

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2119652-1

FEED CAM, PRE FEED

48

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2119653-1

FEED CAM, POST FEED

47

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1

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2119656-9

APPLICATOR BASIC ASSEMBLY, SF

46

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1

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2119370-1

RAM, AMP STYLE, SIDE FEED

44

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1

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2079383-7

SCR, BHSC, RoHS (M8 X 25)

41

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2119645-1

DISC, NUMBERED FA WIRE ADJUSTMENT

40

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1

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2119957-1

APPLICATOR SHIM PACK

39

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1

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1-2119644-2

RAM WASHER, PRECISION

38

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1

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2119085-1

FA HEAD, ATLANTIC STYLE

37

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2119092-1

BOLT, ADJUSTMENT

35

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1752356-6

SUPPORT, TERMINAL

34

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2

2

2

2

2

2079383-5

SCR, BHSC, RoHS (M4 X 20)

33

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2161328-1

HEX HEAD, FLANGED, M5 x 8mm LONG

32

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1

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1320908-3

SPACER, STRIP GUIDE

30

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2119959-2

ASSEMBLY, STRIP GUIDE

29

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455888-4

SPACER, CRIMPER

28

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1320928-2

STRIP GUIDE

24

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2168083-2

SCR, SKT HD CAP, RoHS, M4 X 8.0

21

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3

3

3

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3

1-18028-2

WASHER, FLAT, REG M4

20

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2119533-1

STRIPPER, SIDE FEED

19

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1333264-1

HOLD DOWN

18

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1

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2119806-1

INSERT, SHEAR

13

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1

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3-22280-3

SPRING, COMPRESSION

12

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1-356885-4

STOP, SHEAR

11

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1

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1

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1

2119805-1

SHEAR HOLDER, FRONT

10

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1633861-1

SHEAR, FLOATING

9

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4-1333203-2

ANVIL, COMBINATION

8

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1-2119780-1

DEPRESSOR, SHEAR

5

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1

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4-238011-1

BLOCK, CRIMPER SPACER

4

1

1

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1

1633989-8

CRIMPER, INSULATION, SPECIAL

3

1

1

1

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1

1633169-2

CRIMPER, WIRE, SPECIAL

1

-77

-7

-6

-5

-2

-1

PART NO

DESCRIPTION

ITEM NO

-

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1

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2119957-2

APPLICATOR SHIM PACK

260

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8-21084-0

O-RING, .676 ID, .070 DIA. MAT.

252

ATLANTIC VERSION

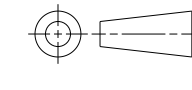
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DIMENSIONS:

mm



TOLERANCES UNLESS OTHERWISE SPECIFIED:

0 PLC ±.5

1 PLC ±0.13

2 PLC ±0.13

3 PLC ±0.013

4 PLC ±0.0001

ANGLES ±.5

FINISH

MATERIAL

-

DWN

L. ZHANG

26 JUL 2012

CHK

L. ZHANG

26 JUL 2012

APVD

S. XI

26 JUL 2012

NAME

Ocean Side Feed Applicator

SIZE

CAGE CODE

DRAWING NO

00779

©=2151353

RESTRICTED TO

-

Customer Accessible Production Drawing

SCALE

1:2

SHEET

1

OF

4

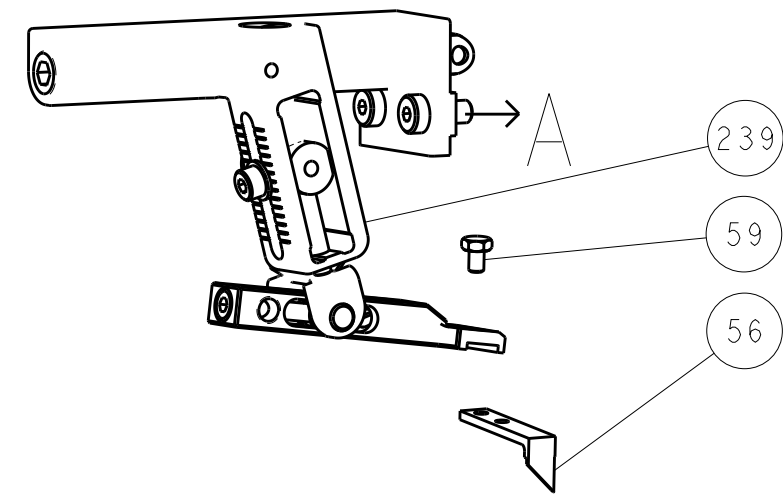
REV

G

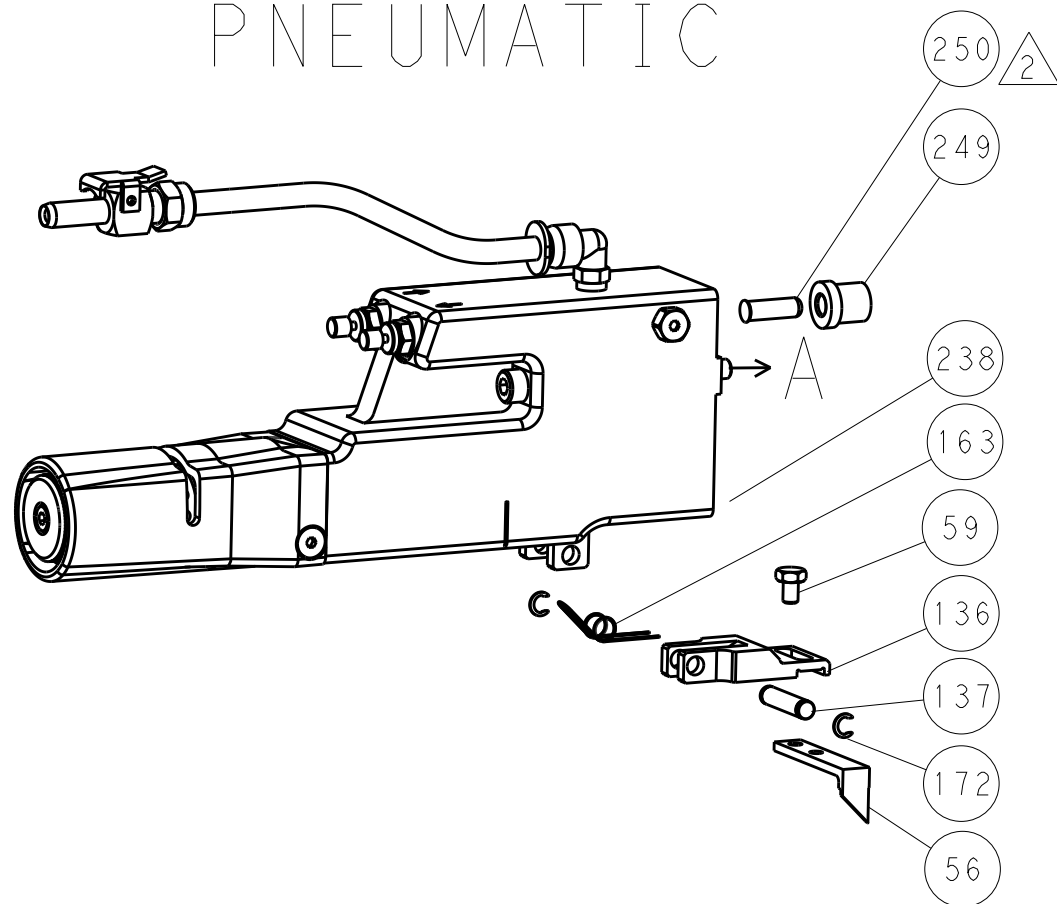
SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

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

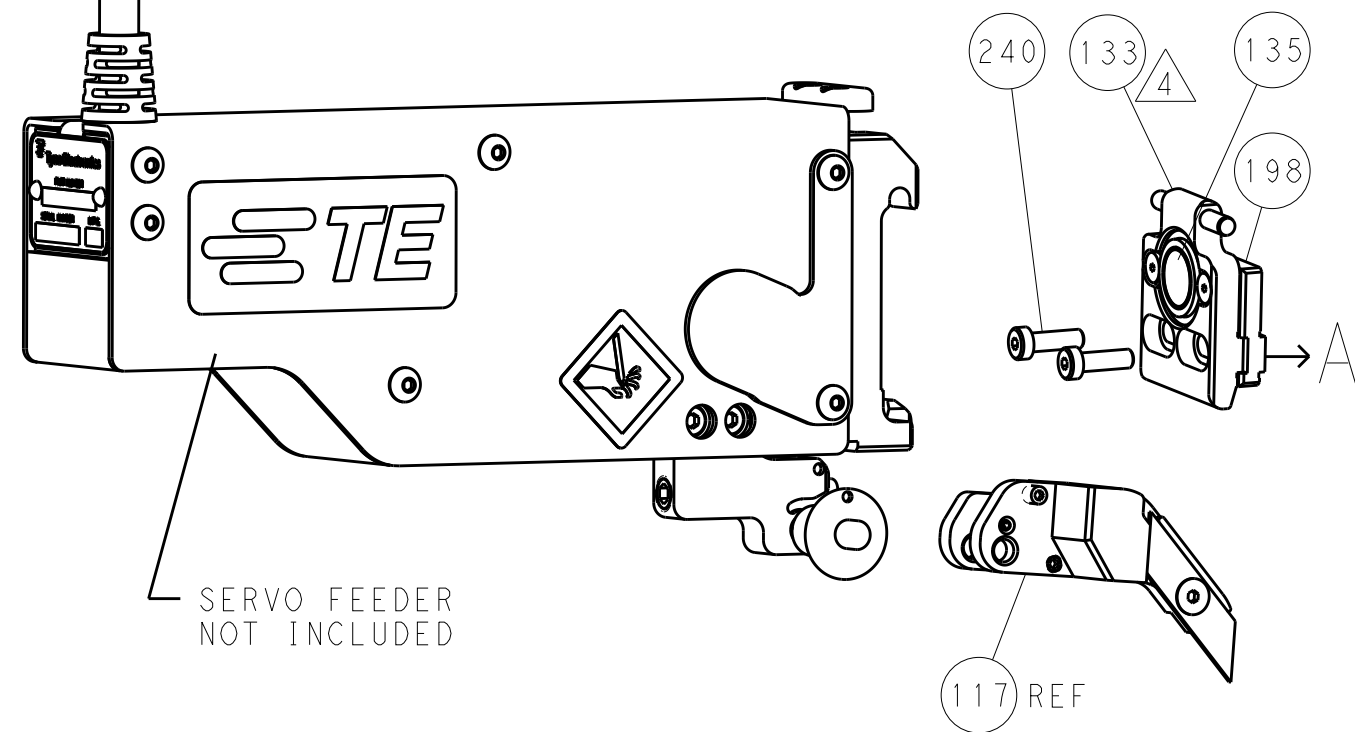
FEED TYPE
MECHANICAL



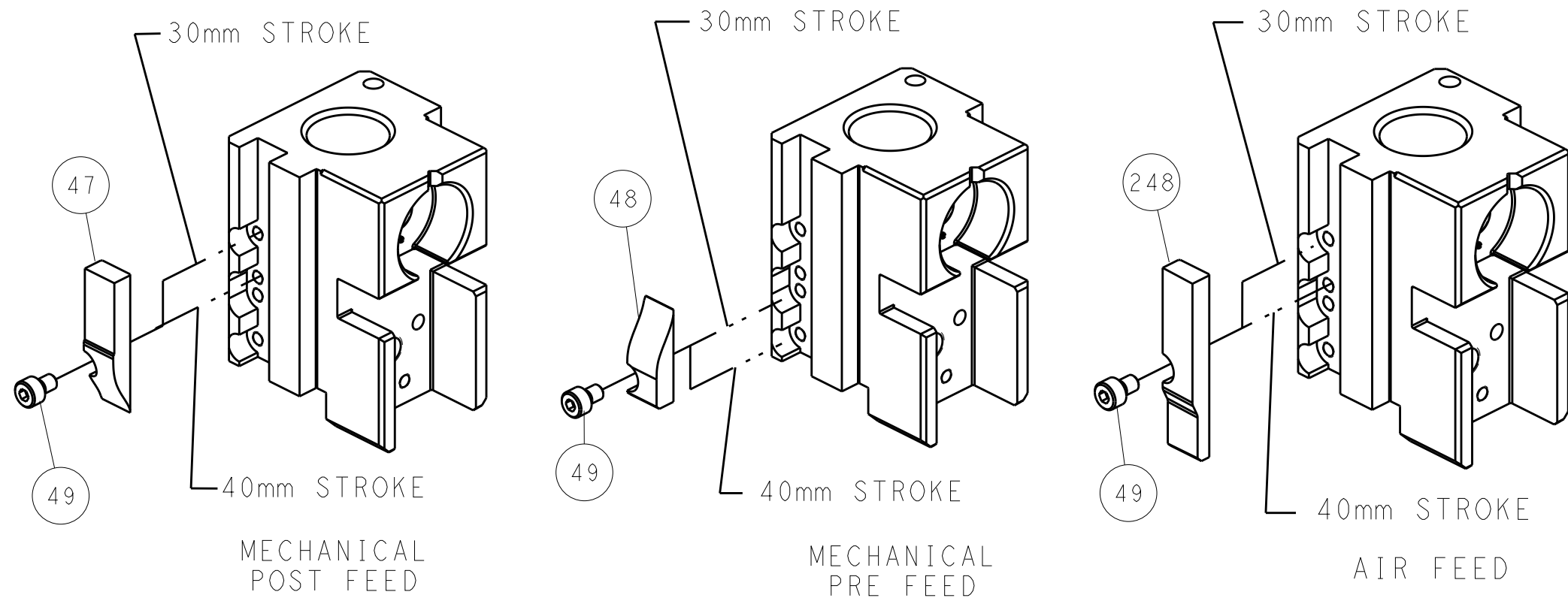
PNEUMATIC



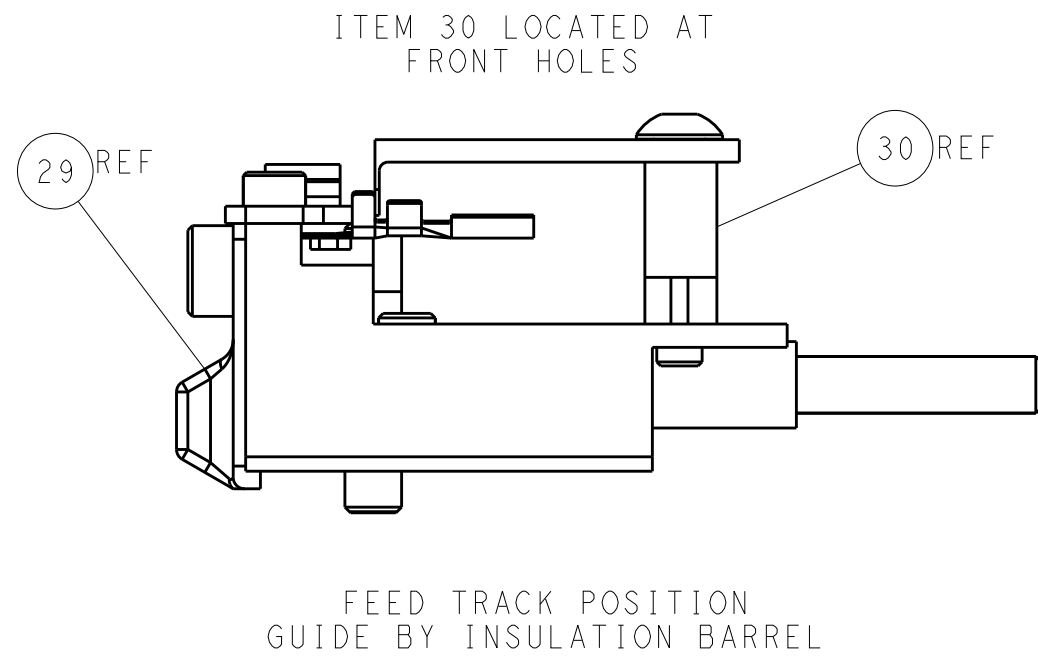
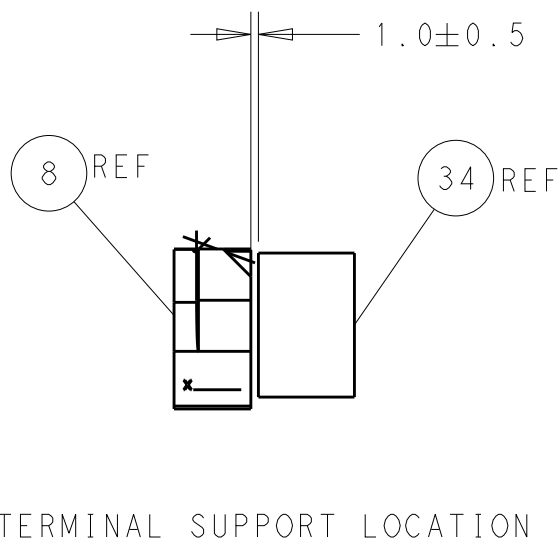
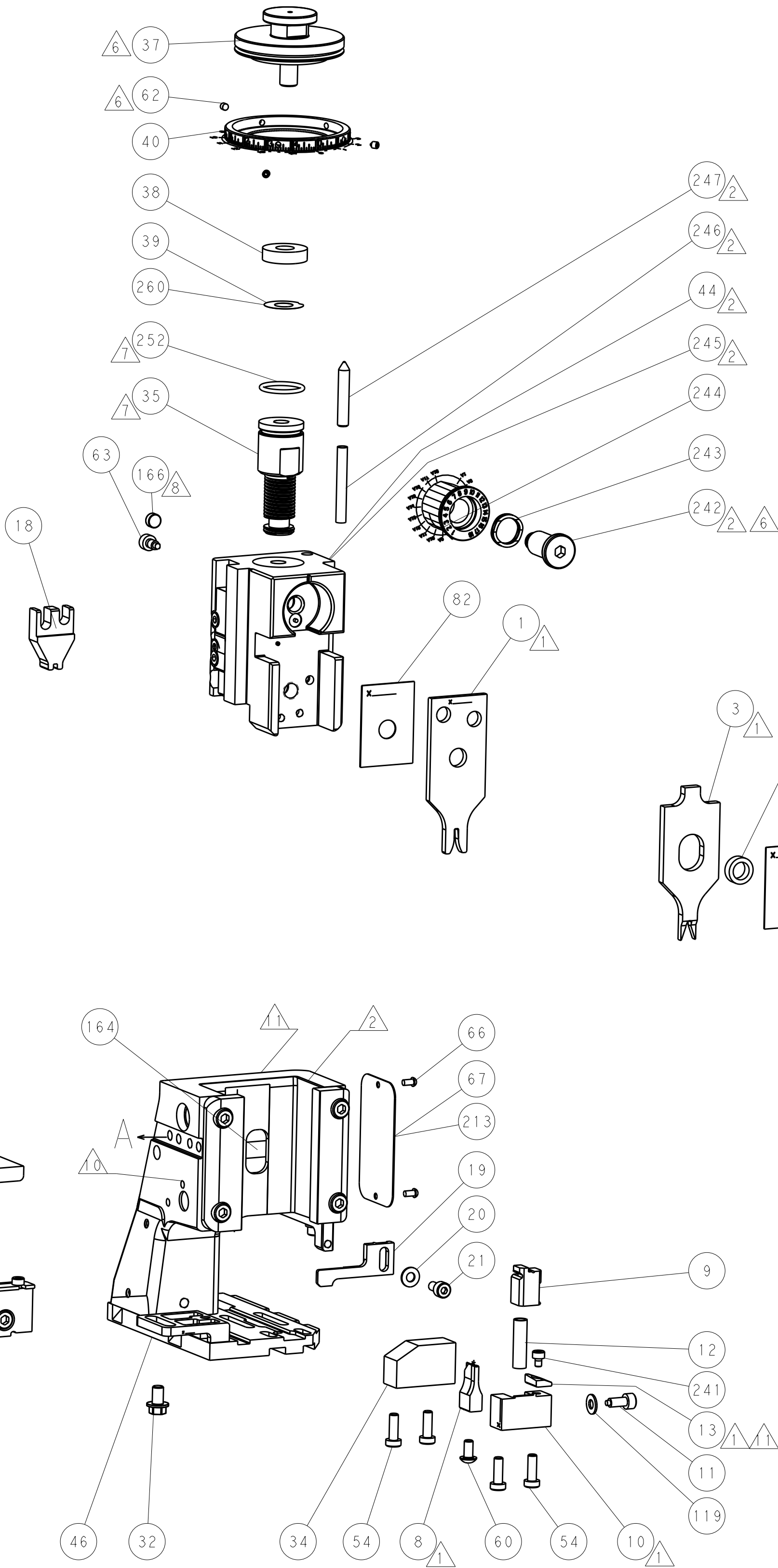
SERVO
LATCH PLATE



CAM POSITIONS



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

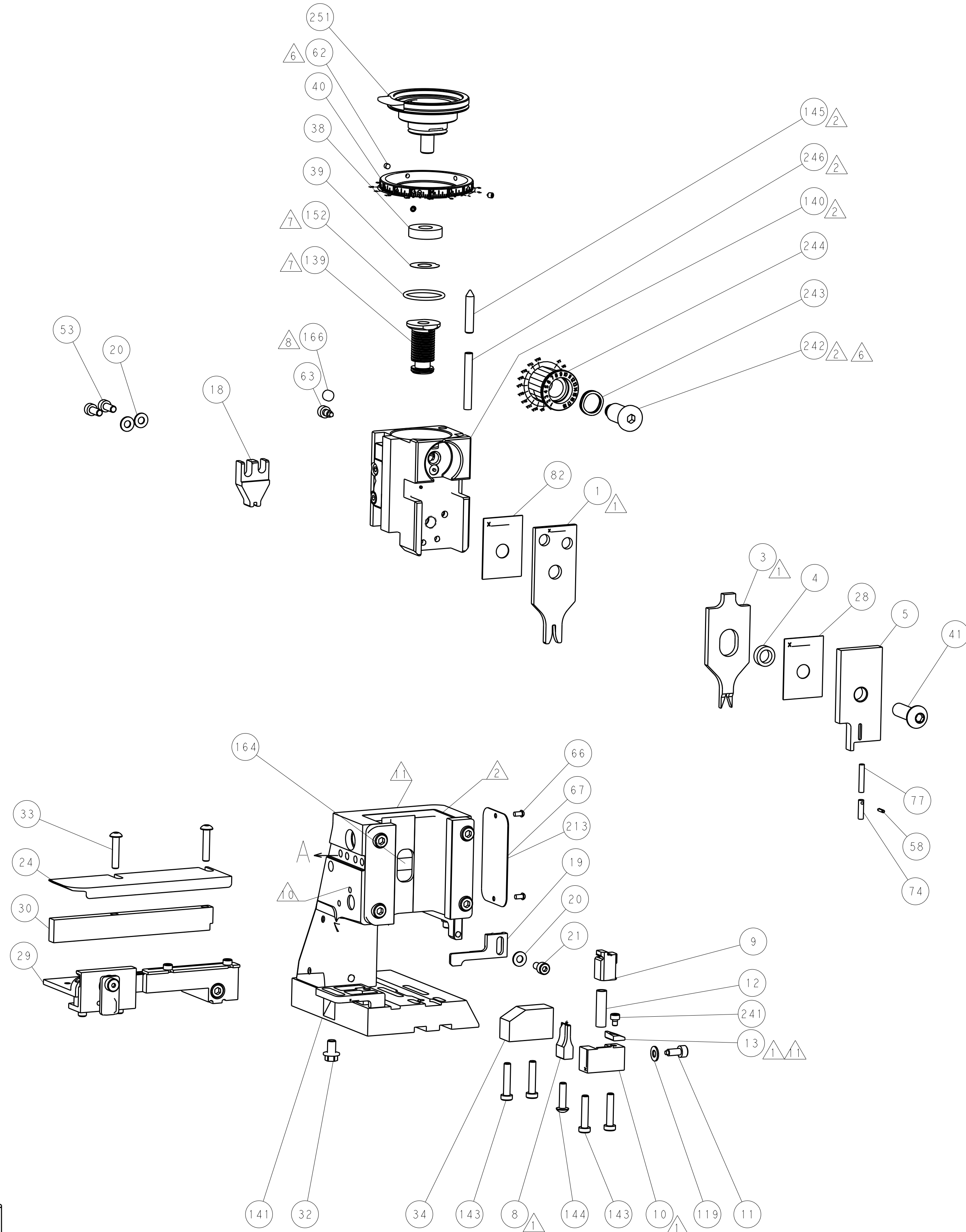


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DIMENSIONS: mm		CHK L. ZHANG 26JUL2012	NAME Ocean Side Feed Applicator	
TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.5 1 PLC ±0.13 2 PLC ±0.13 3 PLC ±0.013 4 PLC ±0.0001 ANGLES ±.5		APVD S. XI 26JUL2012	SIZE A1	
MATERIAL -		FINISH -	WEIGHT -	
Customer Accessible Production Drawing		SCALE 1:2	SHEET 2 of 4	
			REV G	

PNEUMATIC

SERVO
LATCH PLATE

CAM POSITIONS



1.0±0.5

8 REF

34 REF

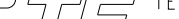
TERMINAL SUPPORT LOCATION

ITEM 30 LOCATED AT FRONT HOLES

30 REF

FEED TRACK POSITION DETERMINED BY INSULATION BARREL

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

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DIMENSIONS:		TOLERANCES, UNLESS OTHERWISE SPECIFIED:		NAME Ocean Side Feed Applicator	
mm		0 PLC ±.01 1 PLC ±0.5 2 PLC ±0.13 3 PLC ±0.013 4 PLC ±0.0001 ANGLES ±.		PRODUCT SPEC APPLICATION SPEC	
		WEIGHT		SIZE CAGE CODE DRAWING NO A1 00779 C=2151353	
MATERIAL FINISH		RESTRICTED TO		SCALE 1:2 SHEET 4 OF 4 REV G	
Customer Accessible Production Drawing					