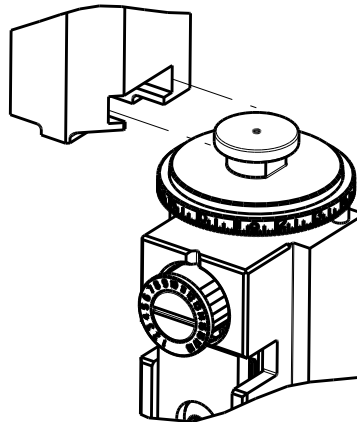
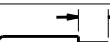
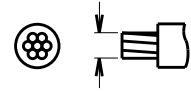


8		7	
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ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION
	2150084-1	B	FINE CRIMP HEIGHT ADJUST
	2150084-2	B	FINE CRIMP HEIGHT ADJUST
	2150084-5	B	FINE CRIMP HEIGHT ADJUST
	2150084-6	B	NON-CRIMP HEIGHT ADJUST
	2150084-7	B	FINE CRIMP HEIGHT ADJUST
	7-2150084-7	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: .205 SERIES FASTON RECEPTACLE			
WIRE STRIP LENGTH 4.40-5.16 mm [.173-.203 IN]			INSULATION DIAMETER RANGE Ø3.30-4.57 mm [.130-.180 IN]
TERMINAL APPLICATION SPECIFICATION	(A)114-2036	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
42233-2	42781-2	170179-1	1742594-1
42233-7		170179-2	

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING ⁹
14 AWG		1.91+/-0.05 [.075+/- .002]		5.0
2X 18 AWG		1.78+/-0.05 [.070+/- .002]		6.5
16 AWG		1.68+/-0.05 [.066+/- .002]		7.4
18 AWG		1.50+/-0.05 [.059+/- .002]		9.2



- 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: 8-2150084-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150084-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150084-5
SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2150084-6
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.
- 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 THE RECOMMENDED SET-UP FOR END FEED APPLICATORS IS POST-FEED WITH ITEM 2119653-1. THE APPLICATOR CAN BE CONFIGURED FOR PRE-FEED WITH ITEM 2119652-1 BUT MAY ENCOUNTER PROBLEMS WITH SOME APPLICATIONS. FEED ISSUES OR TERMINAL JAMMING MAY OCCUR IN THE PRE-FEED CONFIGURATION.
- 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

*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	1	1	1	1	455888-1	SPACER, CRIMPER	263
-	1	1	1	1	1	2119791-9	DEPRESSOR, WIRE	262
-	1	1	1	1	1	1803203-1	BLOCK, FRONT DEPRESSOR	261
-	-	1	-	-	-	2119957-2	APPLICATOR SHIM PACK	260
-	1	-	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	1	2119798-1	DETENT PIN	247
-	1	-	1	1	1	1-22279-3	SPRING, COMPRESSION	246
-	-	1	-	-	-	2119759-1	RAM, AMP STYLE, END FEED, NON-ADJUST	245
-	1	1	1	1	1	2119082-2	CAM, SNAIL, INSULATION ADJUSTMENT	244
-77	-7	-6	-5	-2	-1	PART NO	DESCRIPTION	ITEM NO

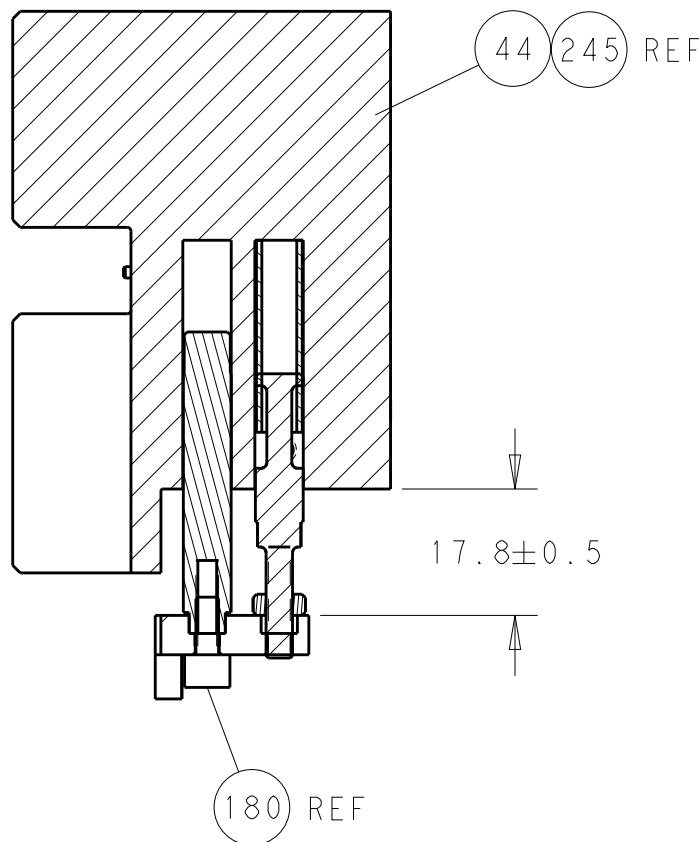
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

SET UP GAUGE 2119599-2	LOC A	DIST 66	REVISIONS			
			P	LTR	DESCRIPTION	DATE
				A	RELEASED	26APR2015
				B	ECR-16-004405	24MAR2016

-	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
-	-	2	2	-	-	2168400-7	SHCS, LOW HEAD, RoHS, M5 X 10	240
-	-	-	-	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	-	-	-	1	-	2063440-1	AIR FEED MODULE	238
-	-	1	1	-	-	2119740-2	TAG, IDENTIFICATION	213
-	-	REF	REF	-	-	1901697-1	FEED FINGER ASSEMBLY, EF	183
-	1	1	1	1	1	1752354-2	STANDOFF, HOLD-DOWN	180
-	1	1	1	1	1	6-993111-6	PIN, SLOTTED SPRING 3.0 X 14.0	177
-	1	1	1	1	1	8-22280-7	SPRING, COMPRESSION	176
-	1	1	1	1	1	1752353-2	GUIDE PIN, HOLDDOWN	175
-	1	1	1	1	1	1901680-2	GUIDE PIN, HOLDDOWN	174
-	-	-	-	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
-	-	REF	REF	-	-	SEE NOTE 4	MEMORY CHIP, PROGRAMMED	135
-	-	1	1	-	-	1633743-1	SERVO FEED LATCH ASM	133
-	1	1	1	1	1	455888-4	SPACER, CRIMPER	82
-	1	1	1	1	1	2119791-5	DEPRESSOR, WIRE	73
-	1	1	1	1	1	2119956-2	DOCUMENTATION PACKAGE	71
-	2	2	2	2	2	2-18032-2	SCR, SET, FLT POINT M3 X 10.0	70
-	1	1	1	1	1	2119943-1	WASHER, SPACER	69
-	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	1	1901681-5	HOLDDOWN, TERMINAL	65
-	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	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	-	-	-	-	1	2063961-1	FEED FINGER	58
-	4	4	4	4	4	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57
-	2	2	2	2	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	56
-	2	2	2	2	2	5018030-2	NUT, HEX, REG, RoHS, M4	55
-	2	2	2	2	2	5018030-1	NUT, HEX, REG, RoHS, M3	54
-	2	2	2	2	2	986965-8	NUT, LOCK, HEX, TORQUE (M4)	53
-	1	1	1	1	1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52
-	-	-	-	1	-	2119792-2	PAWL, EF, AIR	51
-	-	-	-	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	2119655-5	APPLICATOR BASIC ASSEMBLY, EF	46
-	1	-	1	1	1	2119369-1	RAM, AMP STYLE, END 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	2119644-2	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
-	8	8	8	8	8	1-18028-2	WASHER, FLAT, REG M4	33
-	2	2	2	2	2	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	31
-	2	2	2	2	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	29
-	1	1	1	1	1	240639-1	STRIPPER (MACHINING)	27
-	2	2	2	2	2	1320906-1	STUD, THREADED	25
-	1	1	1	1	1	1752371-5	PLATE, STRIP GUIDE	24
-	2	2	2	2	2	2-22281-3	SPRING, COMPRESSION	22
-	1	1	1	1	1	1752373-4	DRAG	20
-	1	1	1	1	1	1803152-1	STRIP GUIDE, REAR	19
-	1	1	1	1	1	1803151-1	STRIP GUIDE, FRONT	18
-	4	4	4	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17
-	1	1	1	1	1	1752360-1	SPACER, HOLD-DOWN	13
-	1	1	1	1	1	240644-1	PLATE, REAR SHEAR	11
-	-	-	-	-	-	-	-	10
-	1	1	1	1	1	690482-6	PLATE, FRONT SHEAR	9
1	1	1	1	1	1	7-1633383-0	ANVIL, COMBINATION	8
-	1	1	1	1	1	2217206-4	BLADE, SLUG	7
-	-	-	-	-	-	-	-	6
-	1	1	1	1	1	240641-1	SPACER	5
-	1	1	1	1	1	238011-4	BLOCK, CRIMPER SPACER	4
1	1	1	1	1	1	2-1633961-7	CRIMPER, INSULATION F PREMIUM	3
-	1	1	1	1	1	455888-5	SPACER, CRIMPER	2
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-77	-7	-6	-5	-2	-1	PART NO	DESCRIPTION	ITEM NO

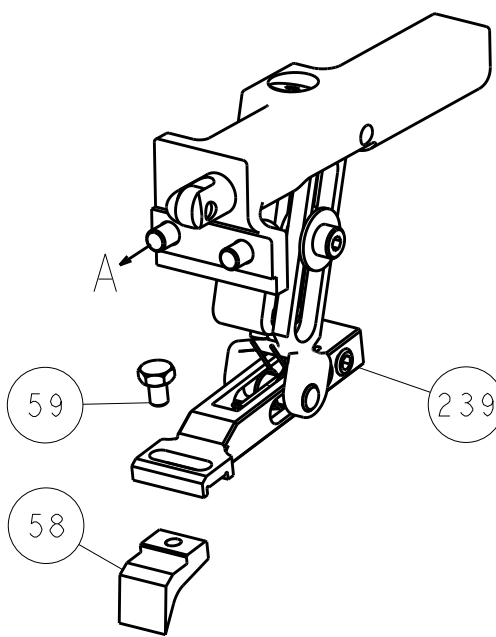
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DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		NAME		Ocean End Feed Applicator																							
		0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± 5 PLC ± 6 PLC ± 7 PLC ± 8 PLC ± 9 PLC ± 10 PLC ± 11 PLC ± 12 PLC ± 13 PLC ± 14 PLC ± 15 PLC ± 16 PLC ± 17 PLC ± 18 PLC ± 19 PLC ± 20 PLC ± 21 PLC ± 22 PLC ± 23 PLC ± 24 PLC ± 25 PLC ± 26 PLC ± 27 PLC ± 28 PLC ± 29 PLC ± 30 PLC ± 31 PLC ± 32 PLC ± 33 PLC ± 34 PLC ± 35 PLC ± 36 PLC ± 37 PLC ± 38 PLC ± 39 PLC ± 40 PLC ± 41 PLC ± 42 PLC ± 43 PLC ± 44 PLC ± 45 PLC ± 46 PLC ± 47 PLC ± 48 PLC ± 49 PLC ± 50 PLC ± 51 PLC ± 52 PLC ± 53 PLC ± 54 PLC ± 55 PLC ± 56 PLC ± 57 PLC ± 58 PLC ± 59 PLC ± 60 PLC ± 61 PLC ± 62 PLC ± 63 PLC ± 64 PLC ± 65 PLC ± 66 PLC ± 67 PLC ± 68 PLC ± 69 PLC ± 70 PLC ± 71 PLC ± 72 PLC ± 73 PLC ± 74 PLC ± 75 PLC ± 76 PLC ± 77 PLC ± 78 PLC ± 79 PLC ± 80 PLC ± 81 PLC ± 82 PLC ± 83 PLC ± 84 PLC ± 85 PLC ± 86 PLC ± 87 PLC ± 88 PLC ± 89 PLC ± 90 PLC ± 91 PLC ± 92 PLC ± 93 PLC ± 94 PLC ± 95 PLC ± 96 PLC ± 97 PLC ± 98 PLC ± 99 PLC ± 100 PLC ±		PRODUCT SPEC		RESTRICTED TO																							
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Customer Accessible Production Drawing														SCALE		1:1		SHEET		1		OF		4		REV		B	

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

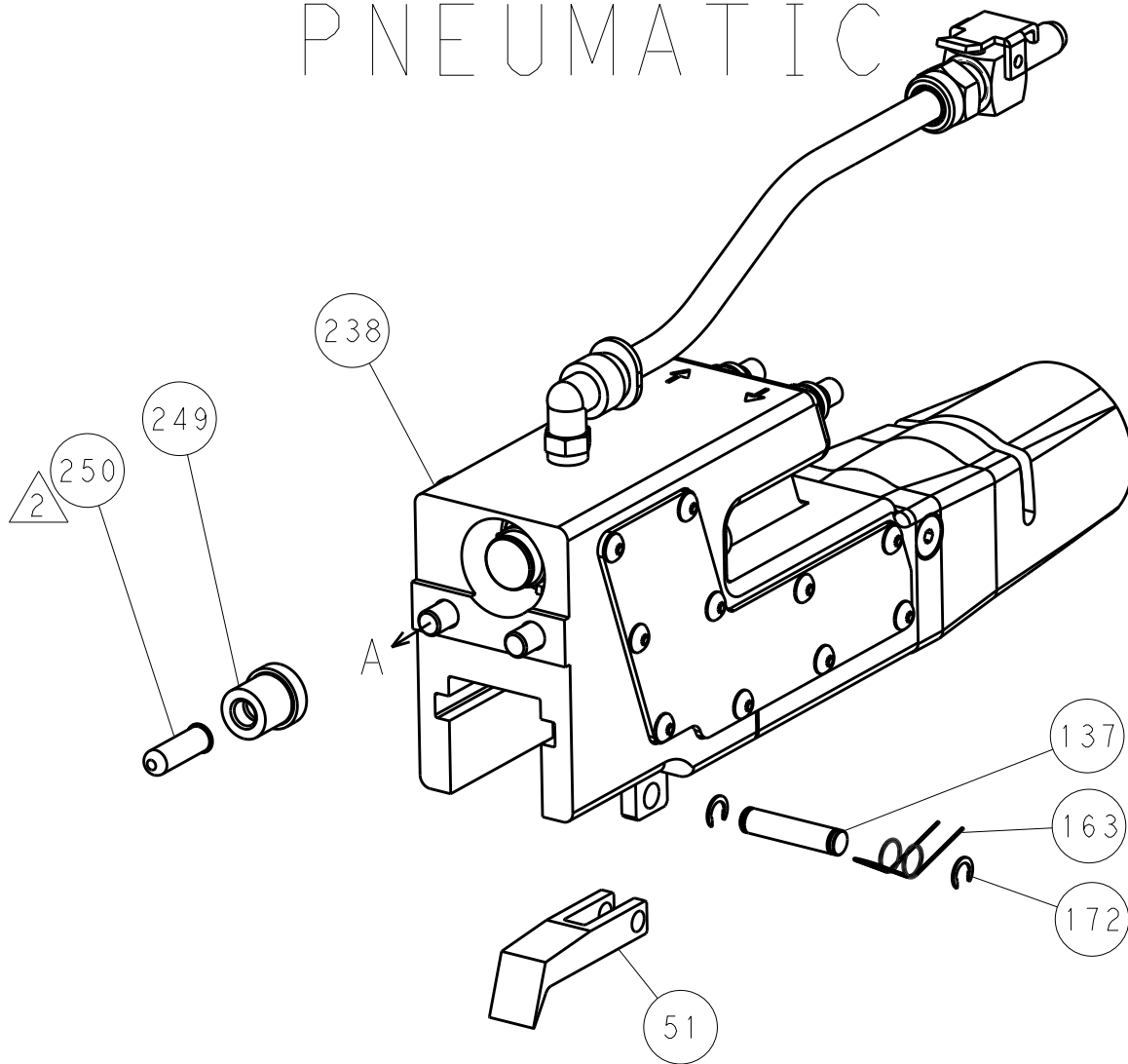


HOLDDOWN SET-UP

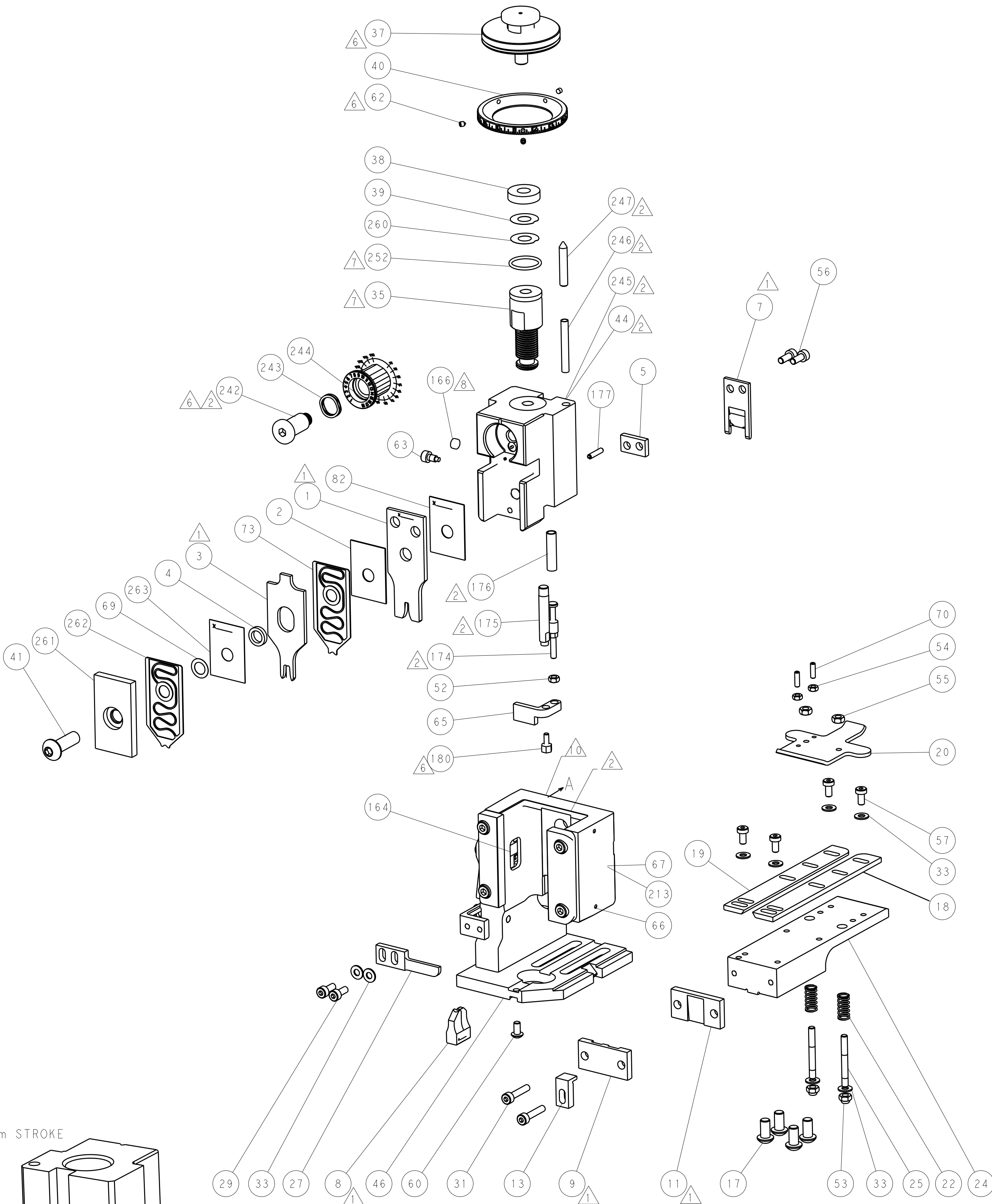
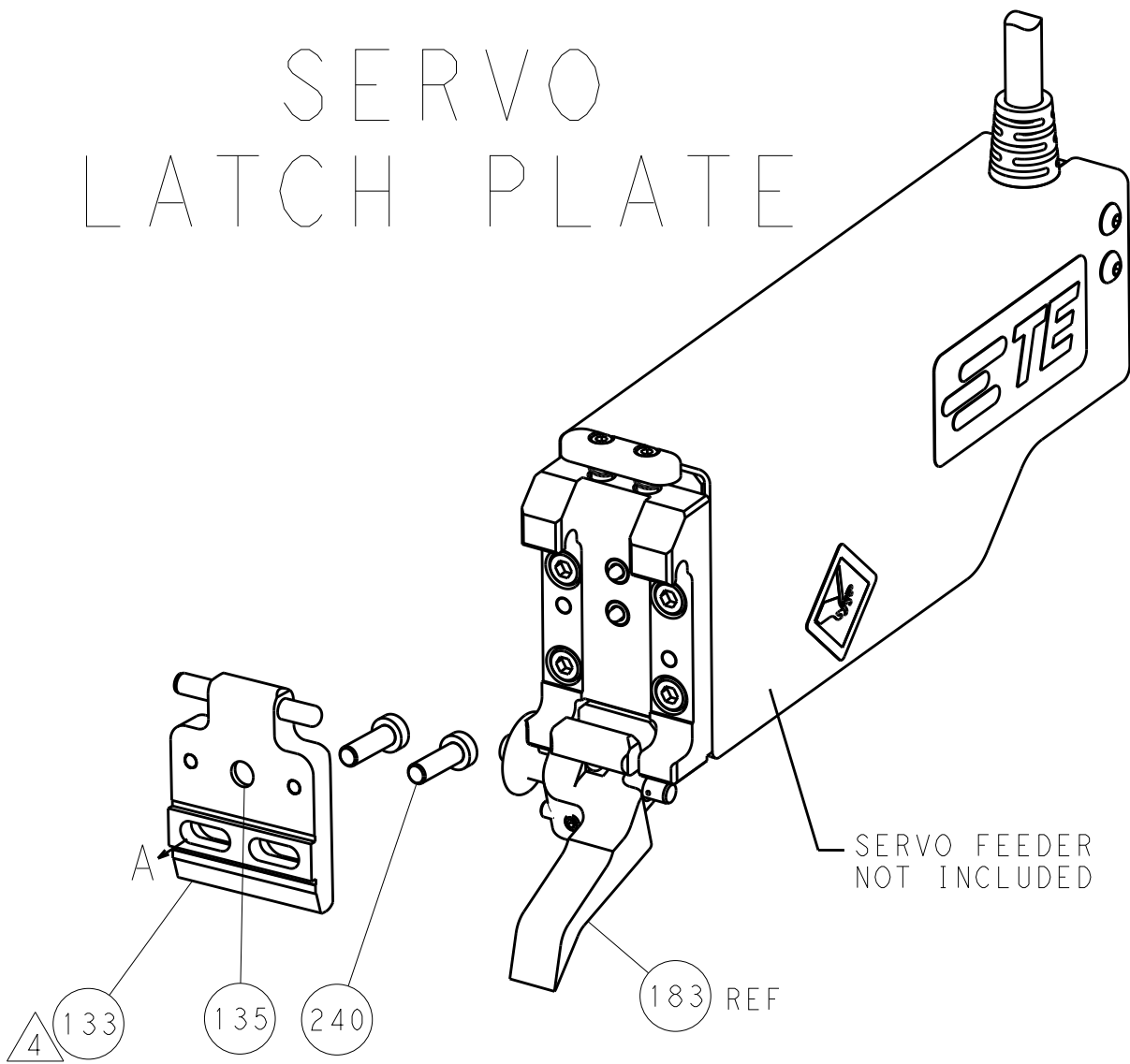
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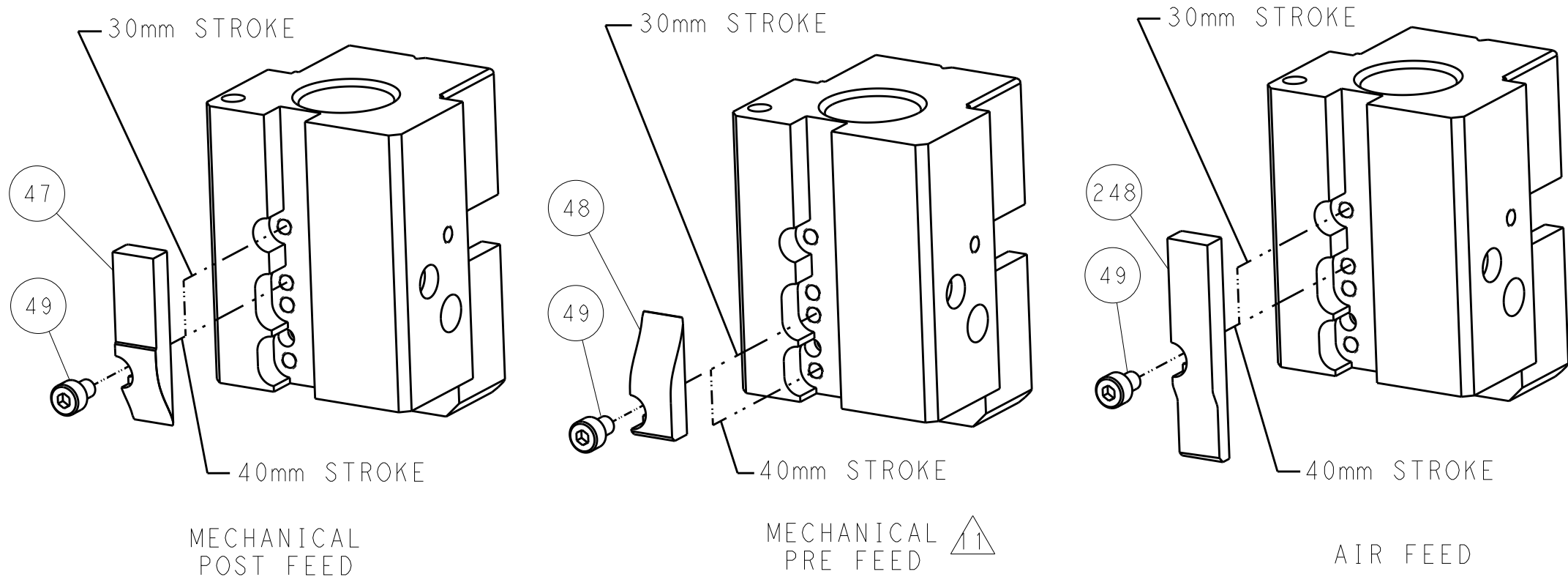
PNEUMATIC



SERVO
LATCH PLATE

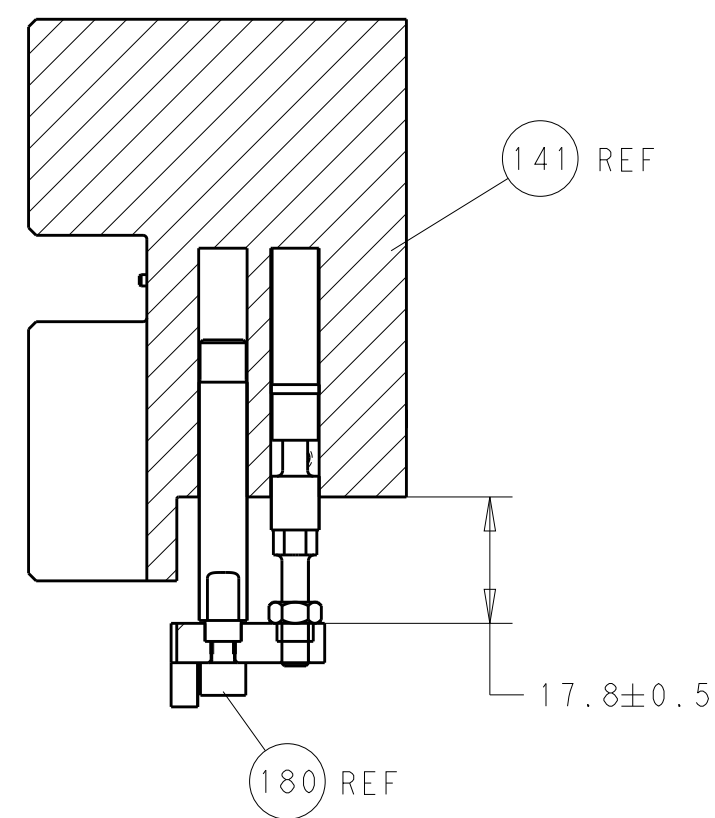


CAM POSITIONS

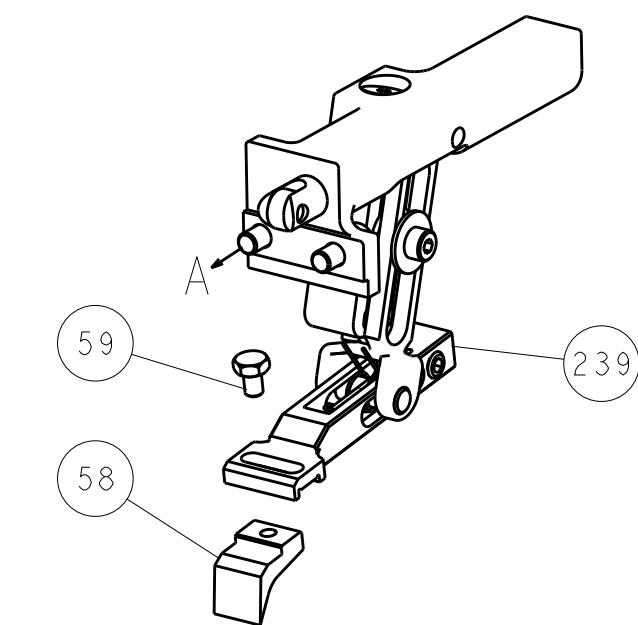
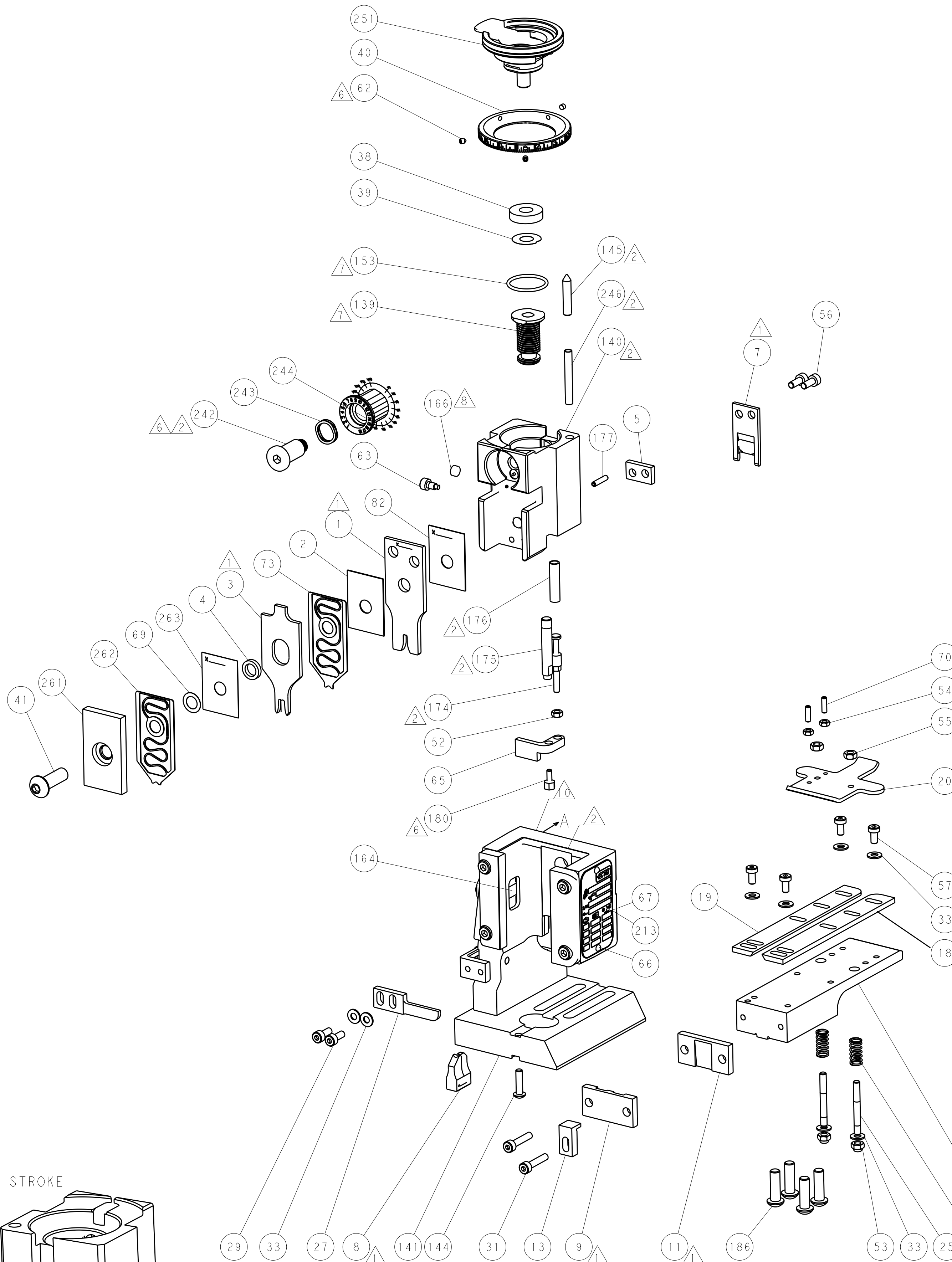


ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

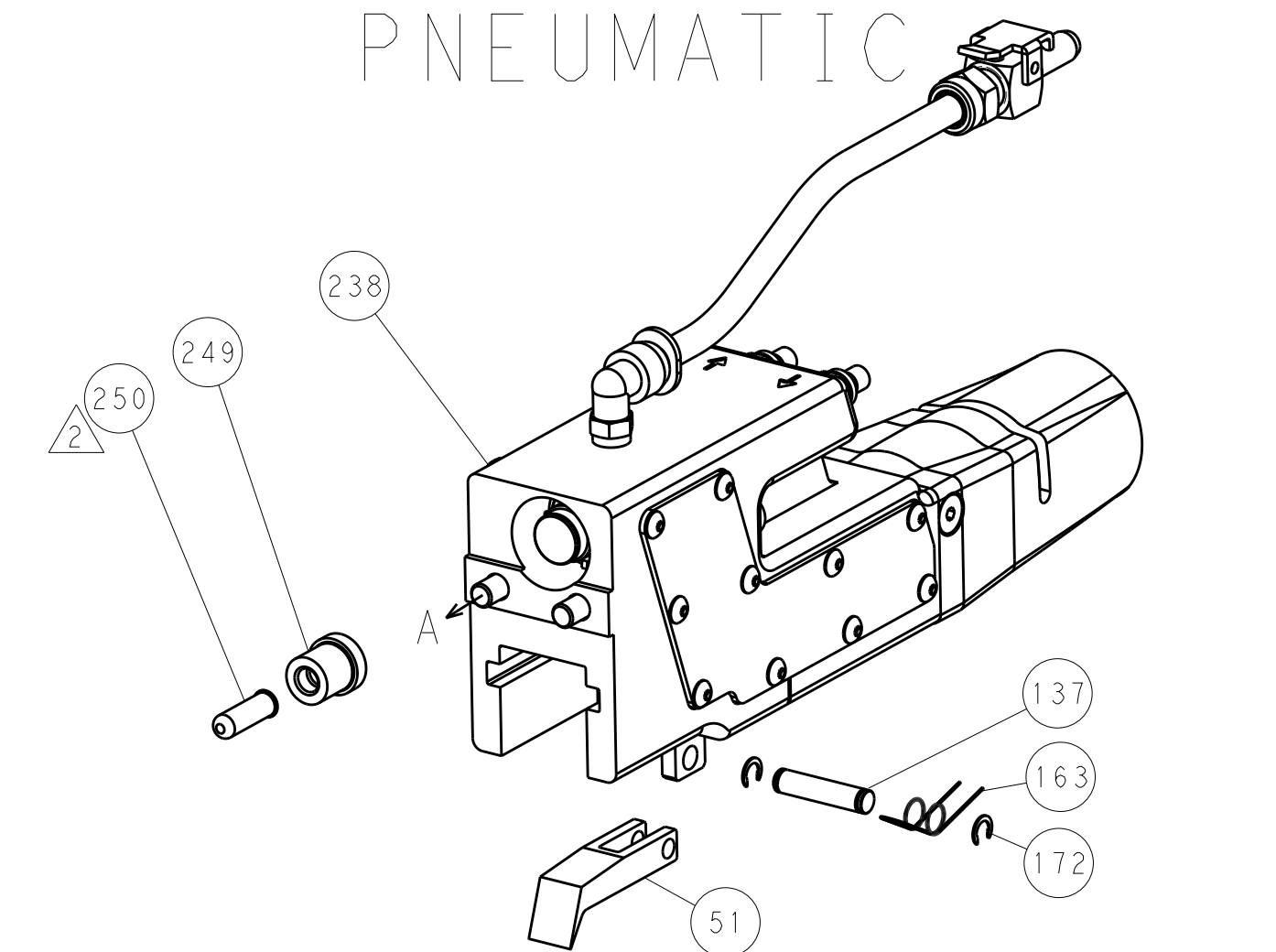
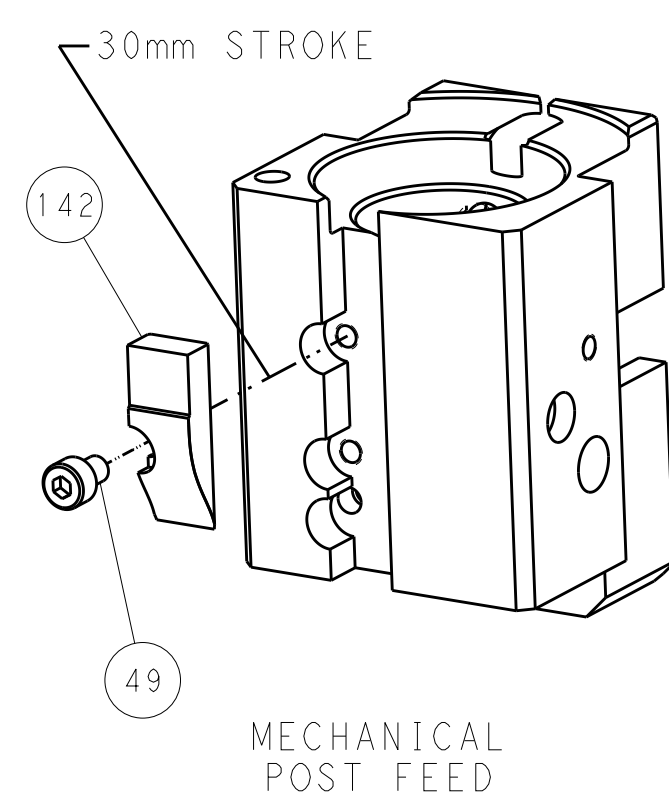
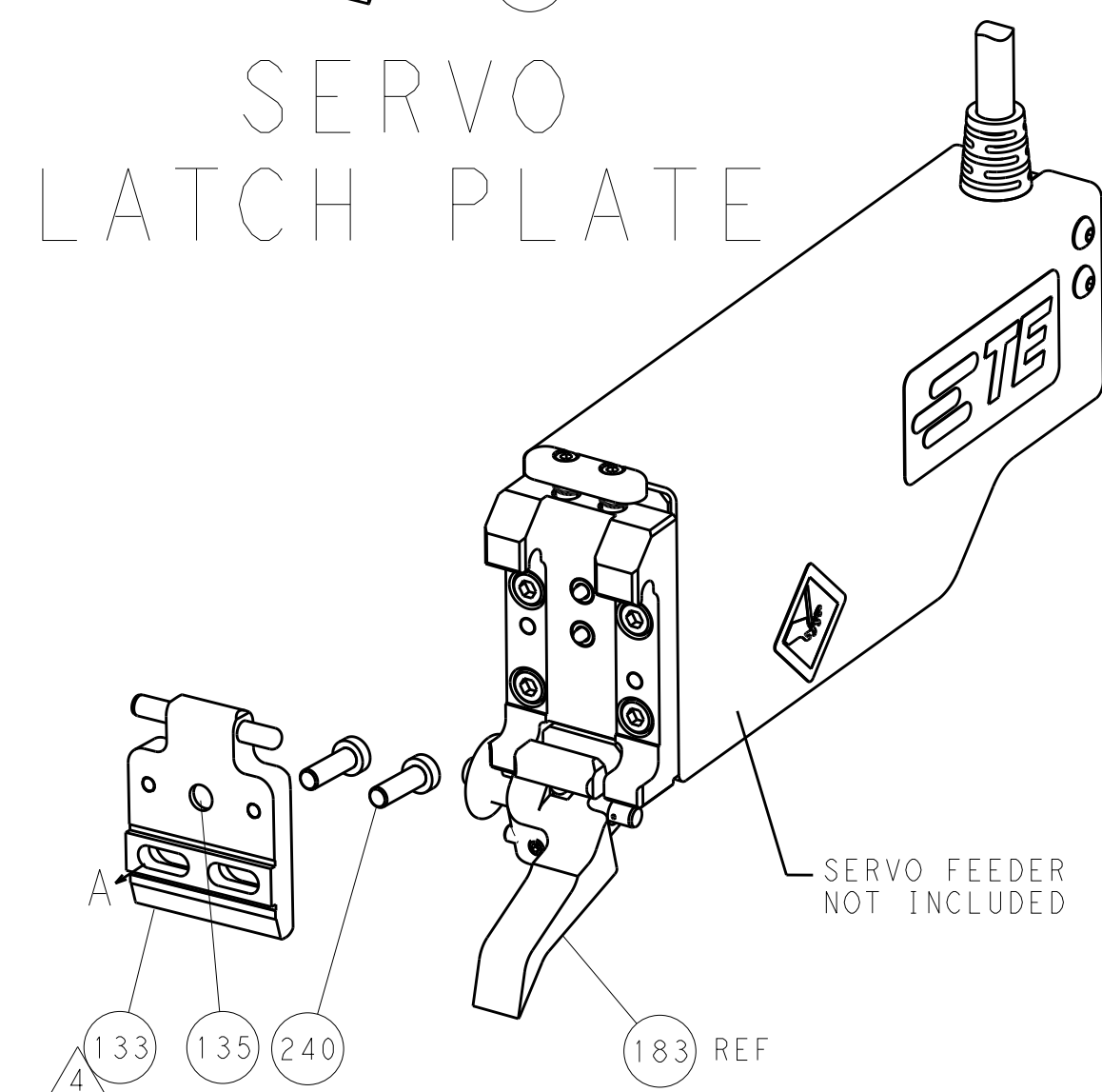
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DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		NAME			
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		1 PLC ±.1		CAGE CODE			
		2 PLC ±.1		DRAWING NO			
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		4 PLC ±.1					
		ANGLES ±.1					
MATERIAL		FINISH					
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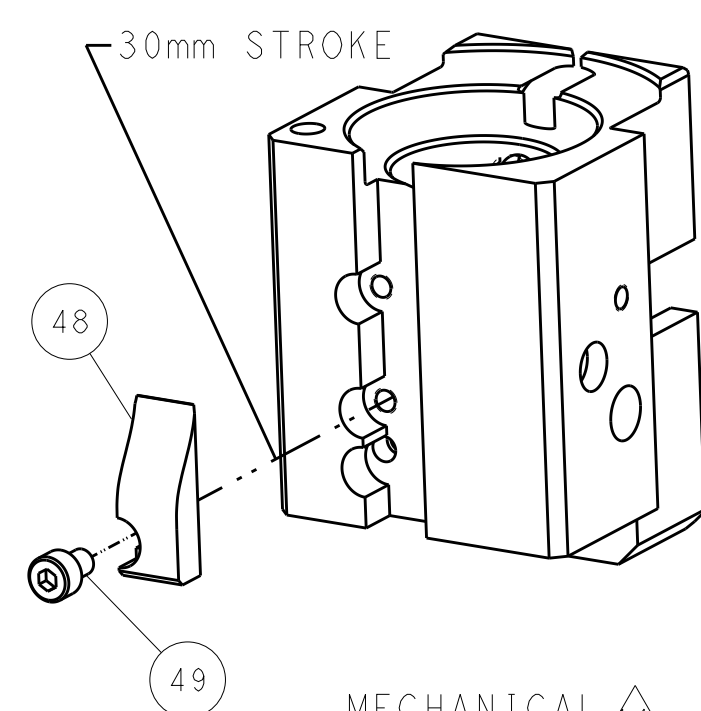
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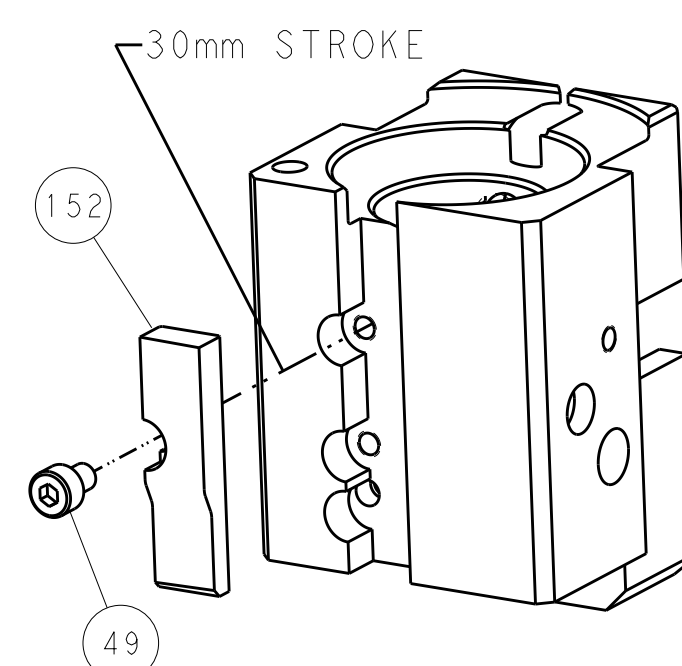
FEED TYPE
MECHANICAL

SERVO
LATCH PLATE

MECHANICAL
POST FEED

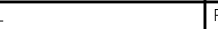
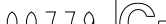


MECHANICAL
PRE FEED



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 						K STARKM	Z0MAR2014	 TE Connectivity Morrisburg, PA 17105-3608					
						CW	Z0MAR2014						
						G BAILEY	Z0MAR2014						
TOLERANCES UNLESS OTHERWISE SPECIFIED:						APVD	T FIBIN	NAME					
0 PLC ± 0.1 PLC ± 0.2 PLC ± 0.3 PLC ± 0.5 PLC ± ANGLES ±°						PRODUCT SPEC		Ocean End Feed Applicator					
						APPLICATION SPEC							
MATERIAL	FINISH	WEIGHT	SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO							
-	-	-	A1	00779	C=2150084								
Customer Accessible Production Drawing						SCALE	1:1	SHEET	4	OF	4	REV	B