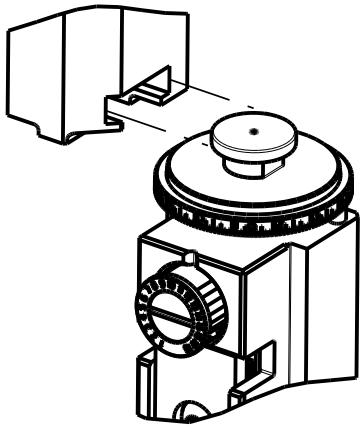


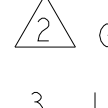
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ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION
	2151542-1	A	FINE CRIMP HEIGHT ADJUST
	2151542-2	A	FINE CRIMP HEIGHT ADJUST
	2151542-5	A	FINE CRIMP HEIGHT ADJUST
	2151542-6	A	NON-CRIMP HEIGHT ADJUST
	2151542-7	A	FINE CRIMP HEIGHT ADJUST
	7-2151542-7	A	CRIMP TOOLING KIT

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	3.05 mm [.120]	F
INSUL	-	-
APPLICATOR INSTRUCTIONS 408-10389		

TERMINAL DATA: TE TERMINAL		TE CONNECTIVITY CRIMP SPEC	
TERMINAL NAME: CONTACT, AMP POWER SERIES 15			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
4.30-6.48 mm [.169-.255 IN]		-	
TERMINAL APPLICATION SPECIFICATION	114-13127 Rev B	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
1604113-1	1604113-2		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
16 AWG	1.75+/-0.05 [.069+/- .002]	6.6
18 AWG	1.63+/-0.05 [.064+/- .002]	7.8
20 AWG	1.50+/-0.05 [.059+/- .002]	9.1

- 

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:
MECHANICAL FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151542-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151542-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151542-5
SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2151542-6
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 50, 62. FOR -6 ONLY APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 37, 50.
- 

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.
- 

SPARE FEED CAM STORAGE LOCATION REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.
- 

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.

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

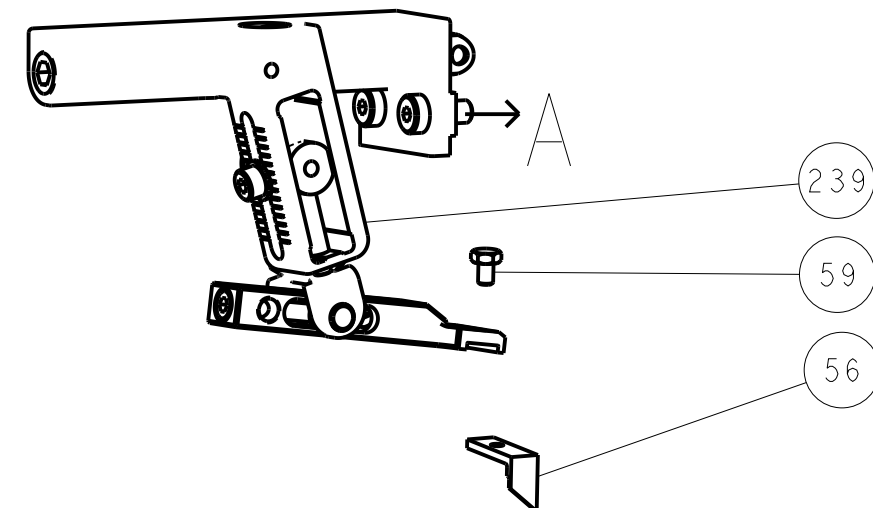
SET UP GAUGE 2119599-1	LOC A	DIST 66	REVISIONS			
			P	LTR	DESCRIPTION	DATE
			A		RELEASED	24MAR2012
			-	-		

-	-	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	-	-	-	2119758-1	RAM, AMP STYLE, SIDE FEED, NON-ADJ.	245
-	-	2	2	-	-	2168400-6	SHCS, LOW HEAD, RoHS, M5 X 16	240
-	-	-	-	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	-	-	-	1	-	2063440-1	AIR FEED MODULE	238
-	-	1	1	-	-	2119740-2	TAG,IDENTIFICATION	213
-	-	1	1	-	-	1901094-3	SPACER, FEEDER	198
-	-	-	-	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
-	-	-	-	1	-	2119799-1	HOLDER,FEED FINGER, AF	136
-	-	REF	REF	-	-	SEE NOTE 4	MEMORY CHIP, PROGRAMMED	135
-	-	1	1	-	-	1633743-1	SERVO FEED LATCH ASM	133
-	1	1	1	1	1	1-22281-8	SPRING, COMPRESSION	121
-	-	REF	REF	-	-	2119944-1	FEED FINGER ASSEMBLY,SF	117
-	1	1	1	1	1	1-690712-7	FRONT STRIP GUIDE	115
-	1	1	1	1	1	980371-4	SCR, SKT HD SHLDR 5.0 DIA X 6.0	100
-	1	1	1	1	1	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	98
-	2	2	2	2	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	98
-	2	2	2	2	2	4-18024-4	SCR, BTN SKT HD CAP (M4 X 6.0)	97
-	1	1	1	1	1	1633055-1	GUIDE, STOCK	94
-	1	1	1	1	1	2168083-6	SCR, SKT HD CAP, RoHS, M5 X 65	93
-	2	2	2	2	2	2-18032-5	SCR, SET, FLT POINT M5 X 20.0	91
-	2	2	2	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	85
-	1	1	1	1	1	1-455888-2	SPACER, CRIMPER	82
-	2	2	2	2	2	2079383-2	SCR, BHSC, RoHS (M3 X 10)	79
-	1	1	1	1	1	1-2119928-7	FENCE	78
-	1	1	1	1	1	2119956-1	DOCUMENTATION PACKAGE	71
-	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	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	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	-	-	-	1	1	1338683-9	FEED PAWL	56
-	2	2	2	2	2	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	53
-	1	1	1	1	1	2-18031-1	SCR, SET, CUP POINT M3 X 3.0	52
-	1	1	1	1	1	1-811242-0	BUMPER, HOLD DOWN	51
-	1	1	1	1	1	1-1803011-2	HOLDER, SLUG BLADE	50
-	-	-	-	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	2119656-1	APPLICATOR BASIC ASSEMBLY, SF	46
-	1	-	1	1	1	2119370-1	RAM, AMP STYLE, SIDE 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
-	2	2	2	2	2	2079383-8	SCR, BHSC, RoHS (M4 X 16)	33
-	1	1	1	1	1	2161328-1	HEX HEAD, FLANGED, M5 x 8mm LONG	32
-	1	1	1	1	1	1-1320908-1	SPACER, STRIP GUIDE	30
-	1	1	1	1	1	1-1901086-9	PLATE, STRIP GUIDE	29
-	2	2	2	2	2	22283-1	SPRING, COMPRESSION	27
-	1	1	1	1	1	356835-1	LEVER, DRAG RELEASE	26
-	1	1	1	1	1	6-690754-6	DRAG, SPECIAL	25
-	1	1	1	1	1	1803053-7	STRIP GUIDE, REAR	23
-	1	1	1	1	1	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	21
-	1	1	1	1	1	1-18028-2	WASHER, FLAT, REG M4	20
-	1	1	1	1	1	2119533-1	STRIPPER, SIDE FEED	19
-	1	1	1	1	1	1633579-5	BLADE, SLUG	10
-	1	1	1	1	1	2-1803012-4	PLATE, REAR SHEAR	9
1	1	1	1	1	1	1803050-4	ANVIL, SPECIAL, COMBINATION	8
1	1	1	1	1	1	2-456409-3	CRIMPER, WIRE .120 "F" PREMIUM	1

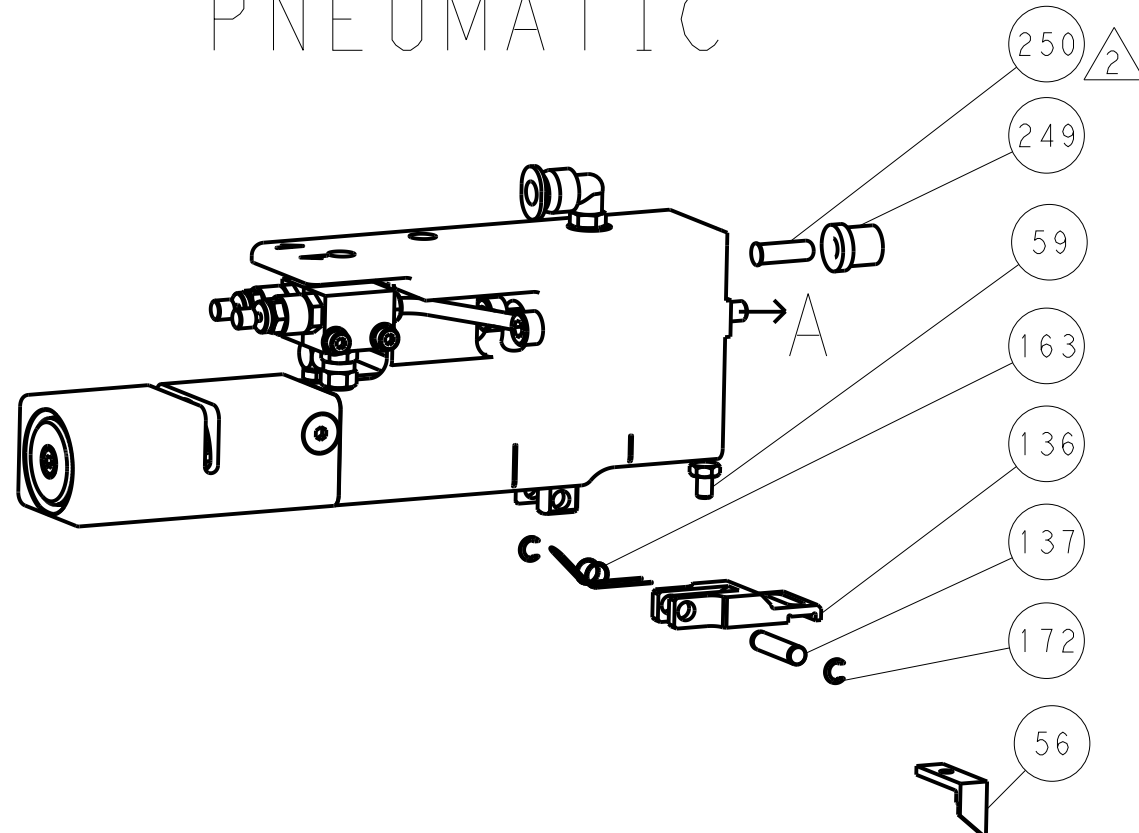
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DIMENSIONS:		CHK K.J.STAKEM 19MAR2012	NAME	
mm	TOLERANCES UNLESS OTHERWISE SPECIFIED:	APVD T.L.FLIN 19MAR2012	Ocean Side Feed Applicator	
	0 PLC ±.5 1 PLC ±0.13 2 PLC ±0.13 3 PLC ±0.013 4 PLC ±0.0001 ANGLES ±.5	PRODUCT SPEC - APPLICATION SPEC -	SIZE CASE CODE DRAWING NO A1 00779 ©=2151542	
MATERIAL	FINISH	WEIGHT	RESTRICTED TO	
-	-	-	-	
Customer Accessible Production Drawing			SCALE 1:2	SHEET 1 OF 4 REV A

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

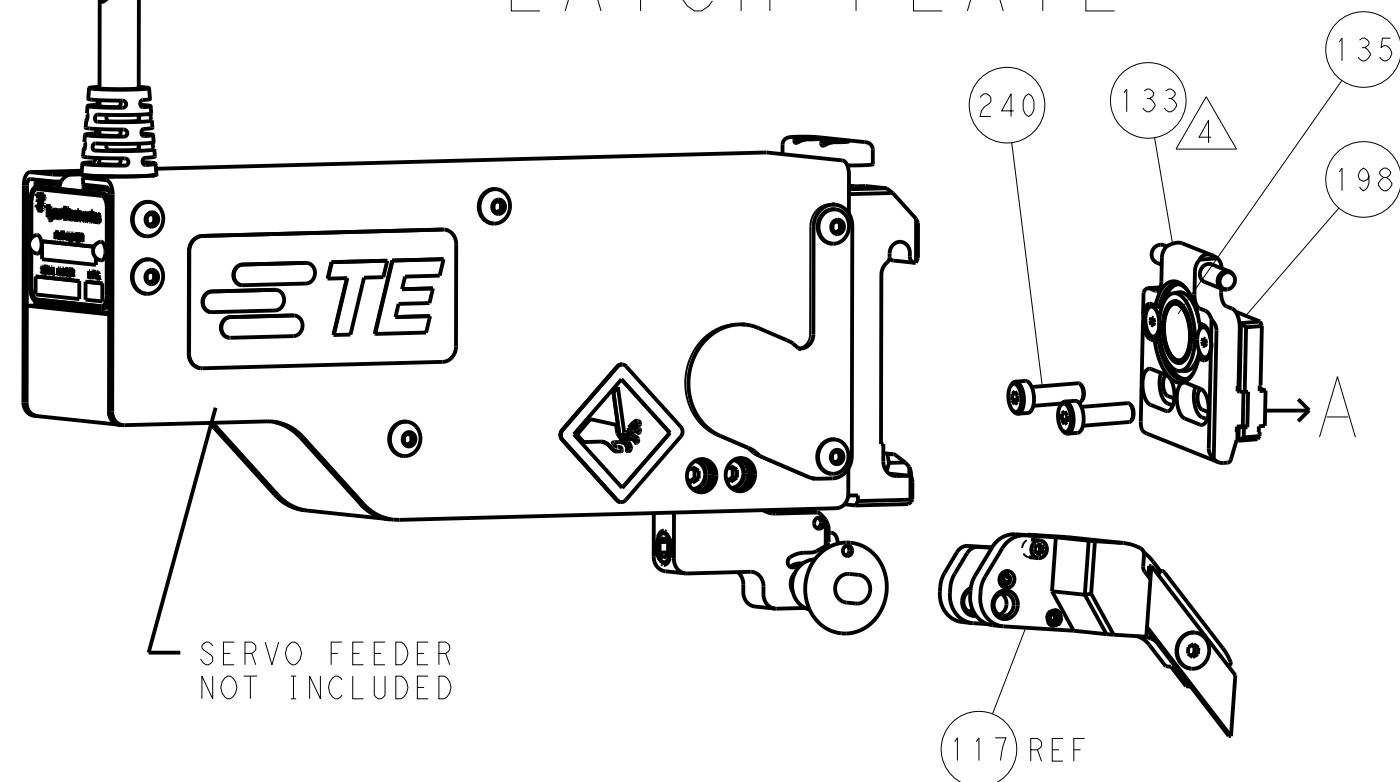
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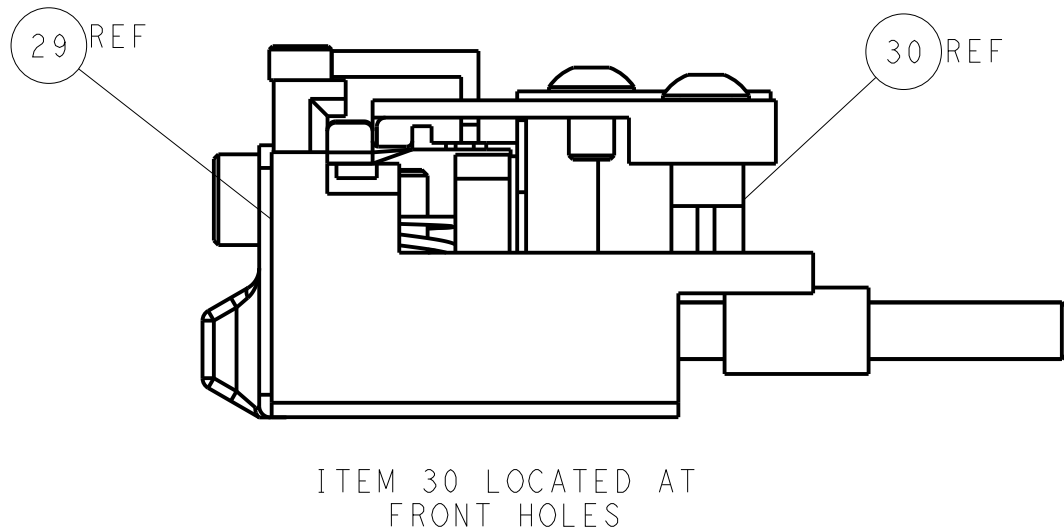
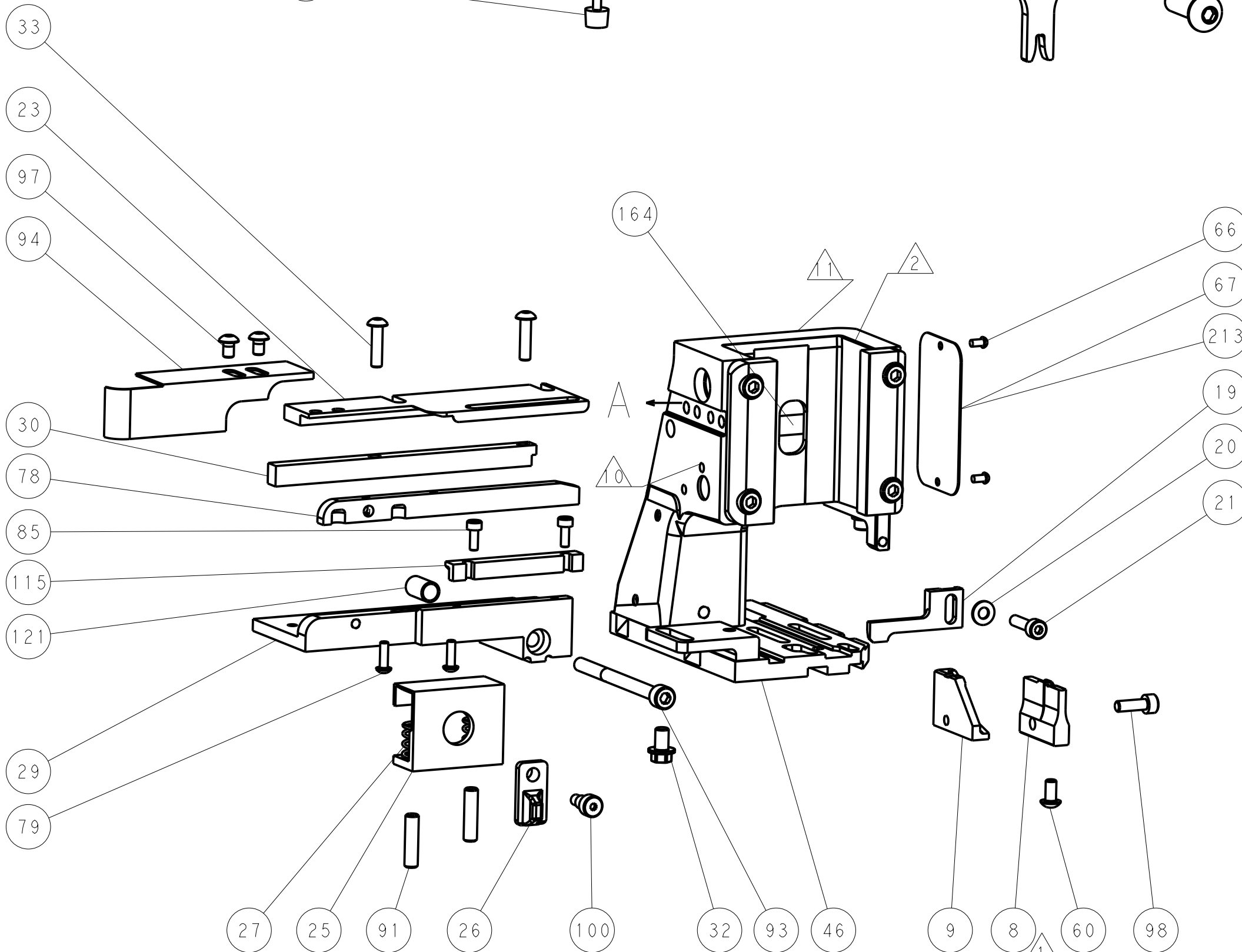
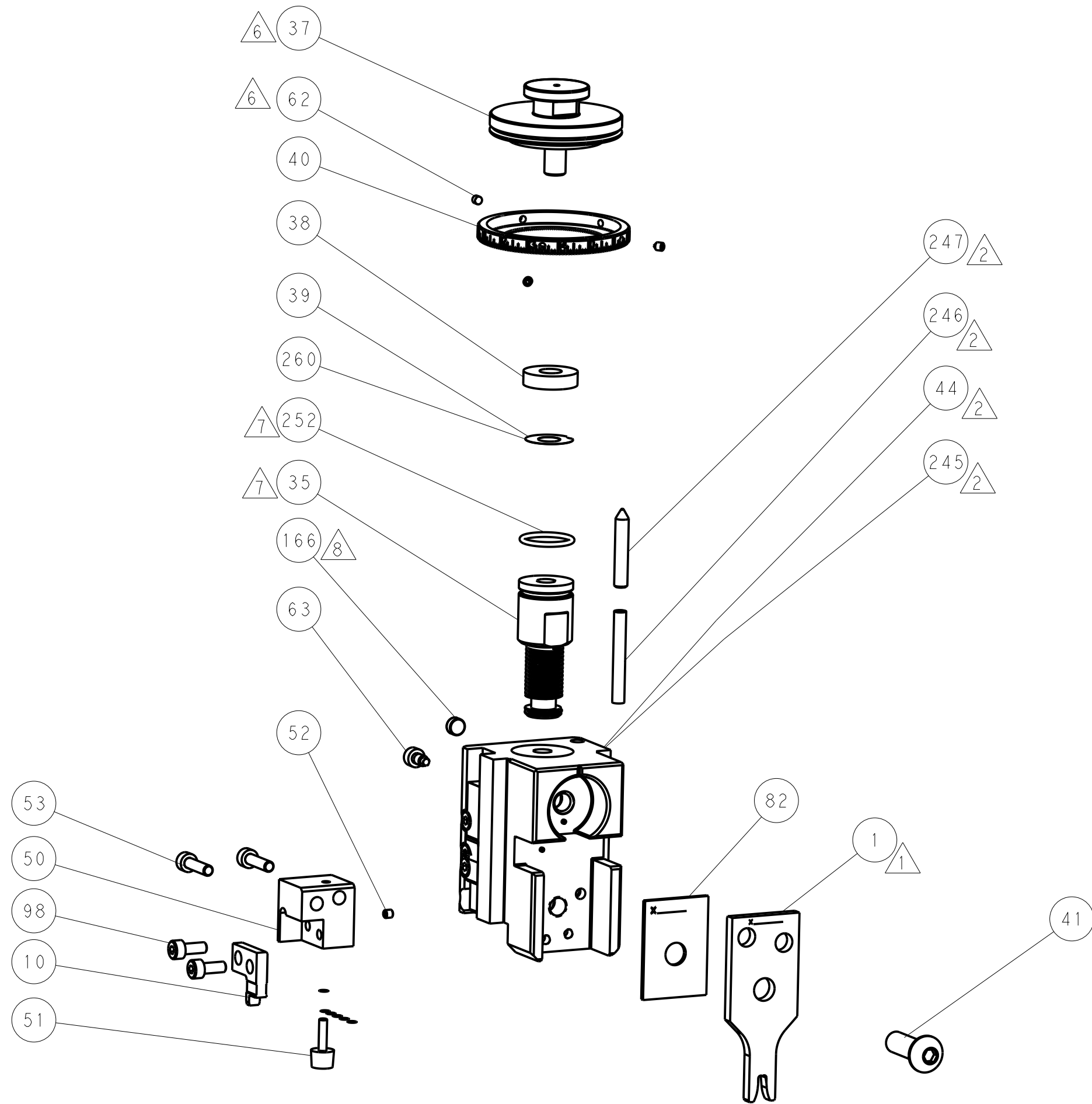
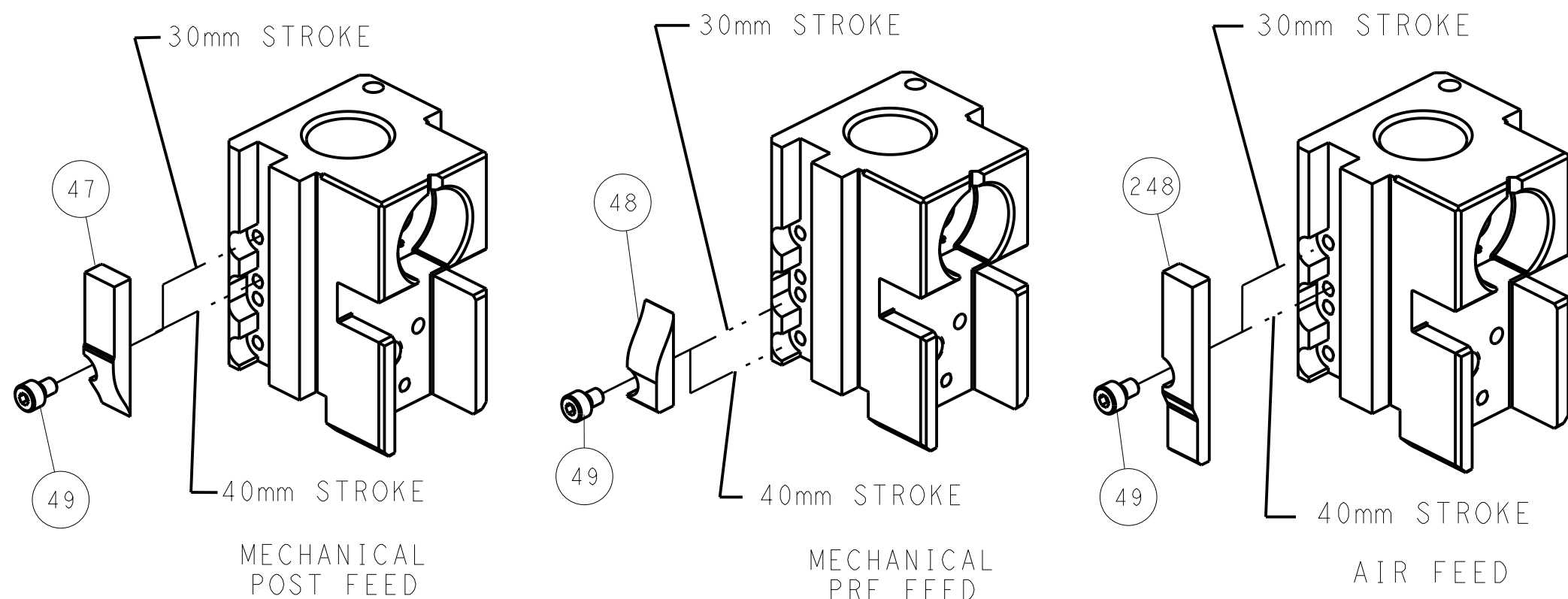
PNEUMATIC



SERVO
LATCH PLATE



CAM POSITIONS

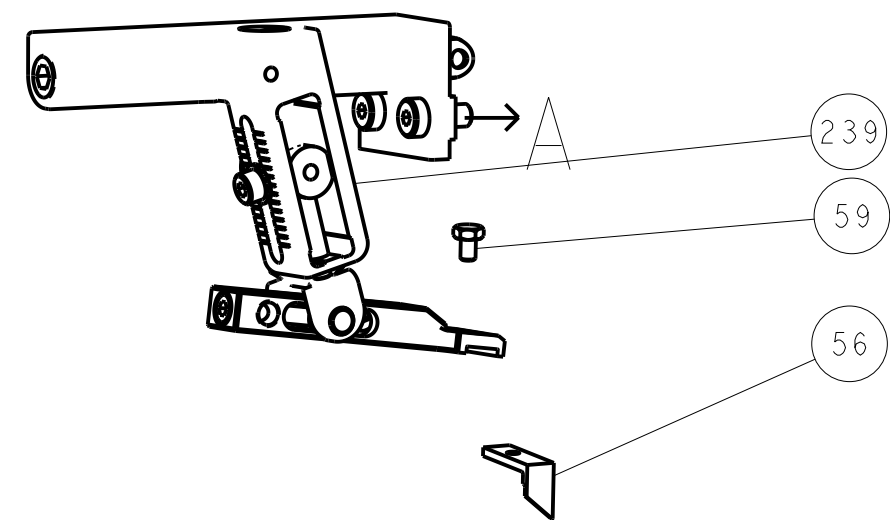


FEED TRACK POSITION
GUIDE BY INSULATION AND BODY

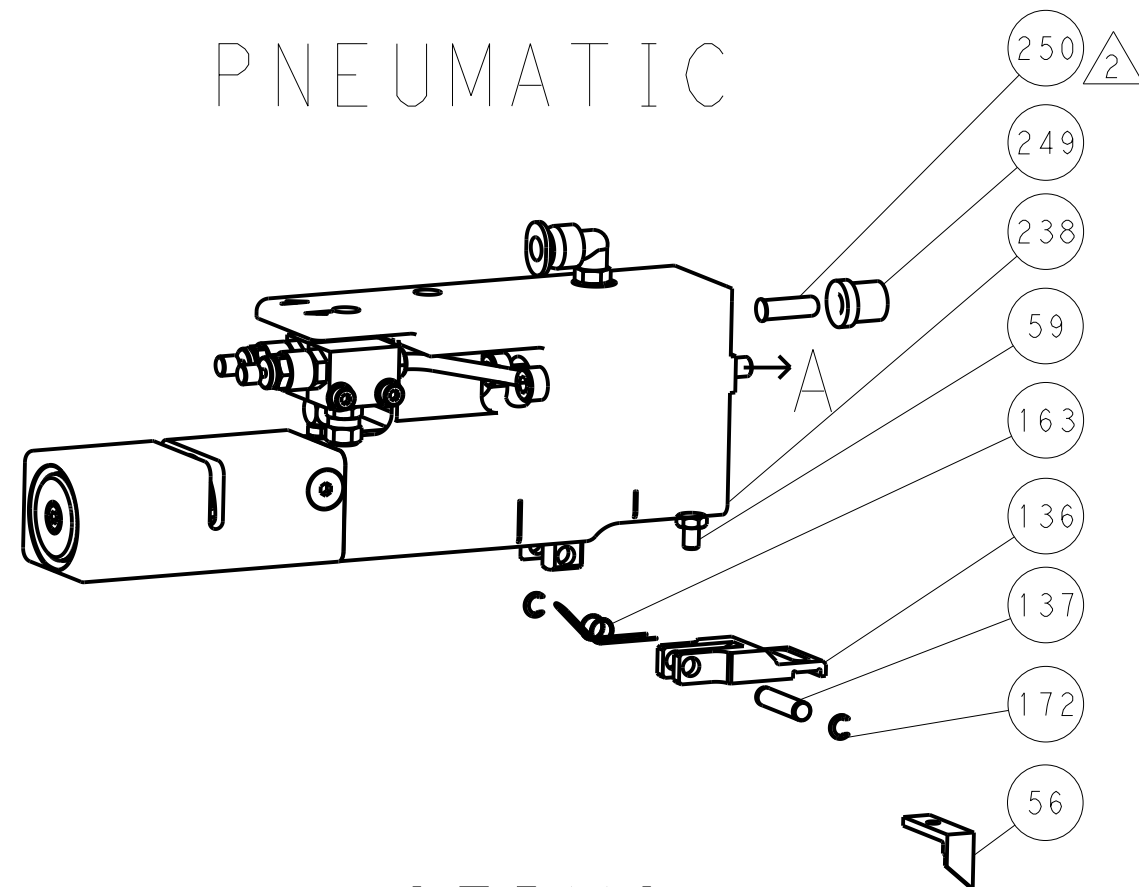
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

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DIMENSIONS: mm				TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.5 1 PLC ±.5 2 PLC ±.13 3 PLC ±.013 4 PLC ±.0001 ANGLES ±.0001				NAME Ocean Side Feed Applicator			
MATERIAL				FINISH				SIZE A1			
				WEIGHT				CAGE CODE 00779			
								DRAWING NO C=2151542			
								RESTRICTED TO			
								Customer Accessible Production Drawing			
								SCALE 1:2			
								SHEET 2 OF 4			
								REV A			

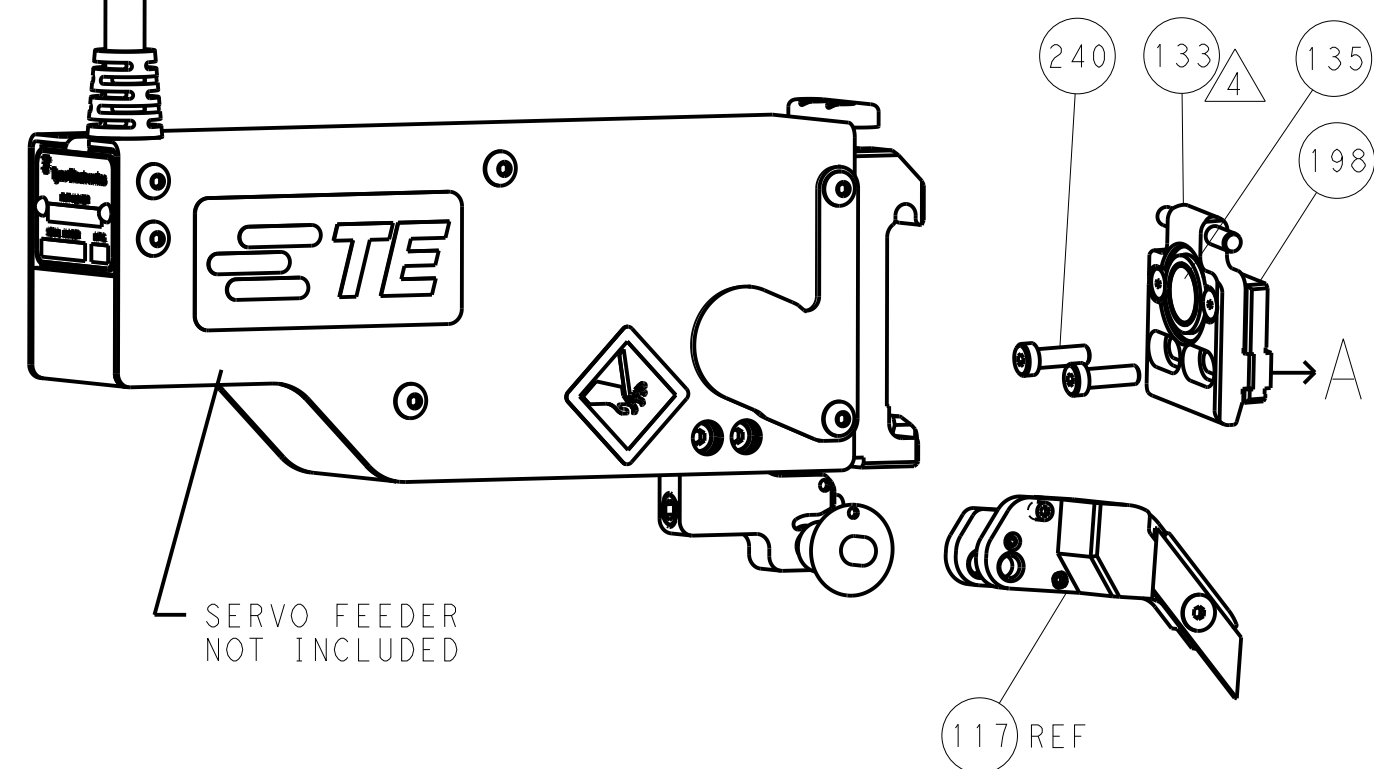
FEED TYPE MECHANICAL



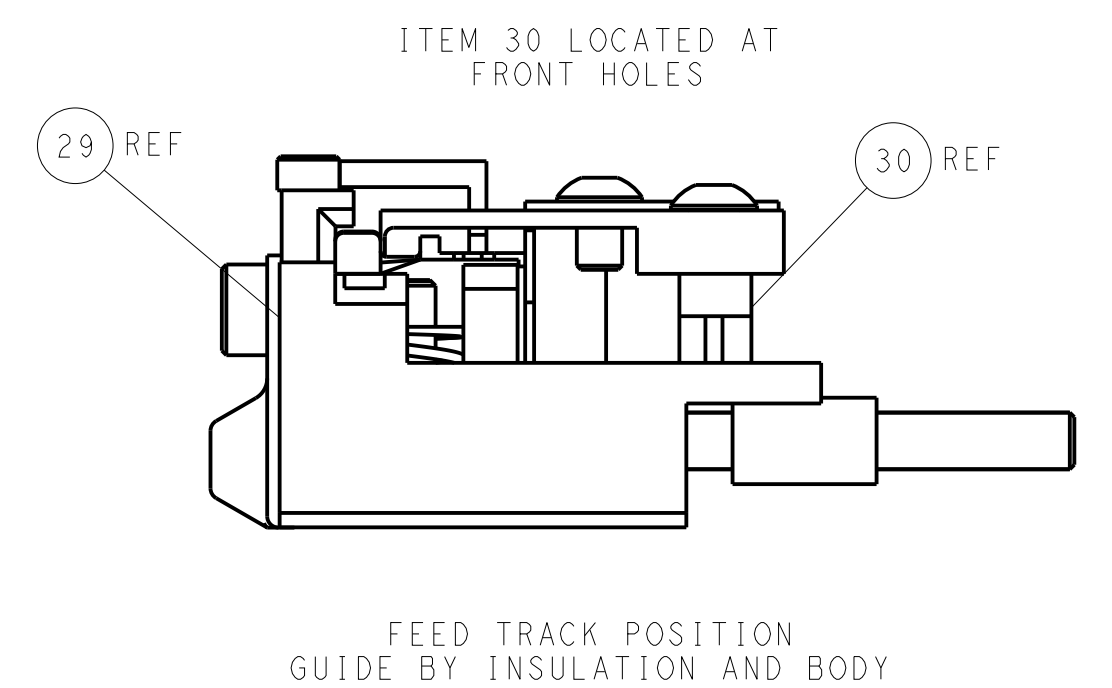
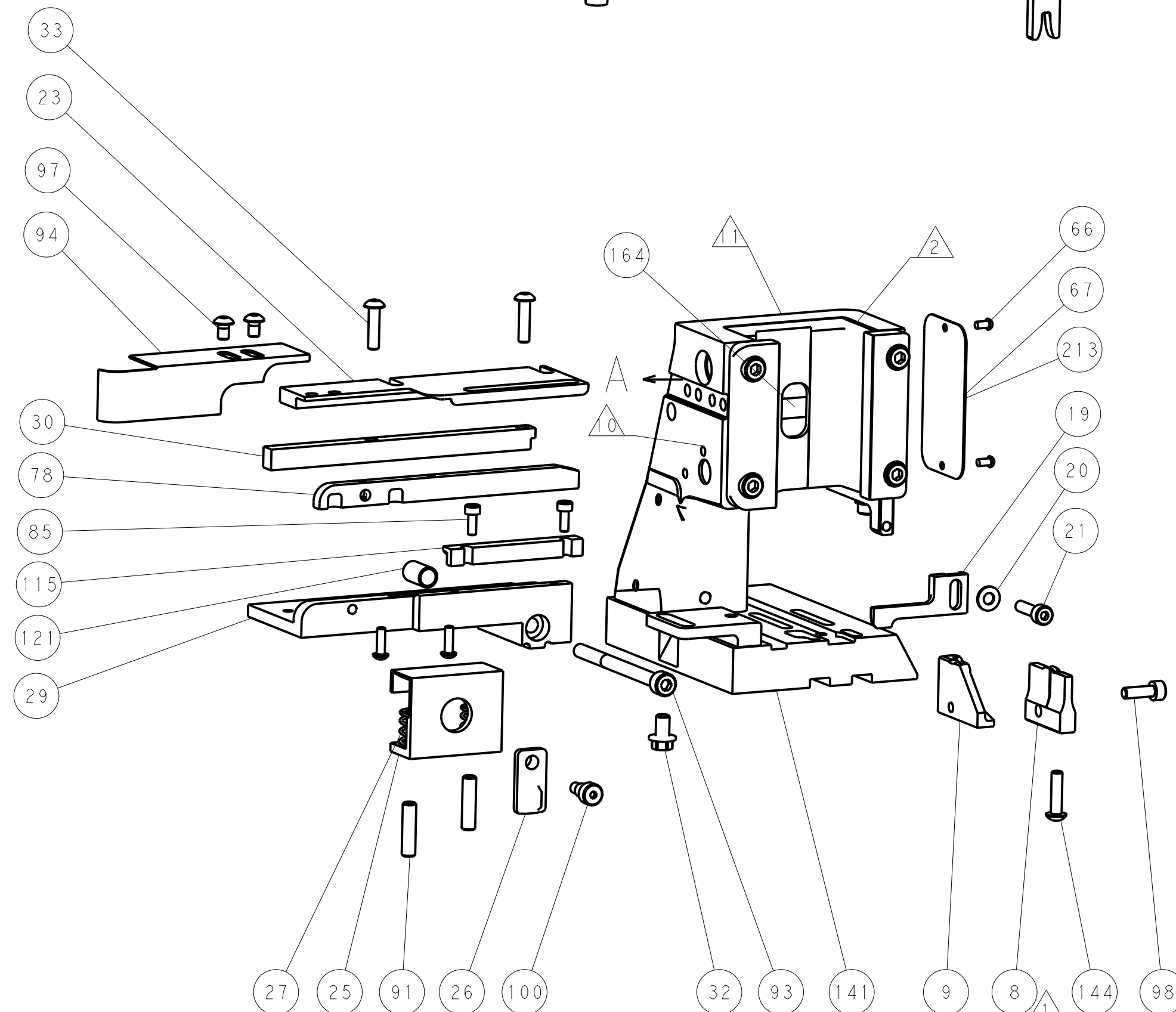
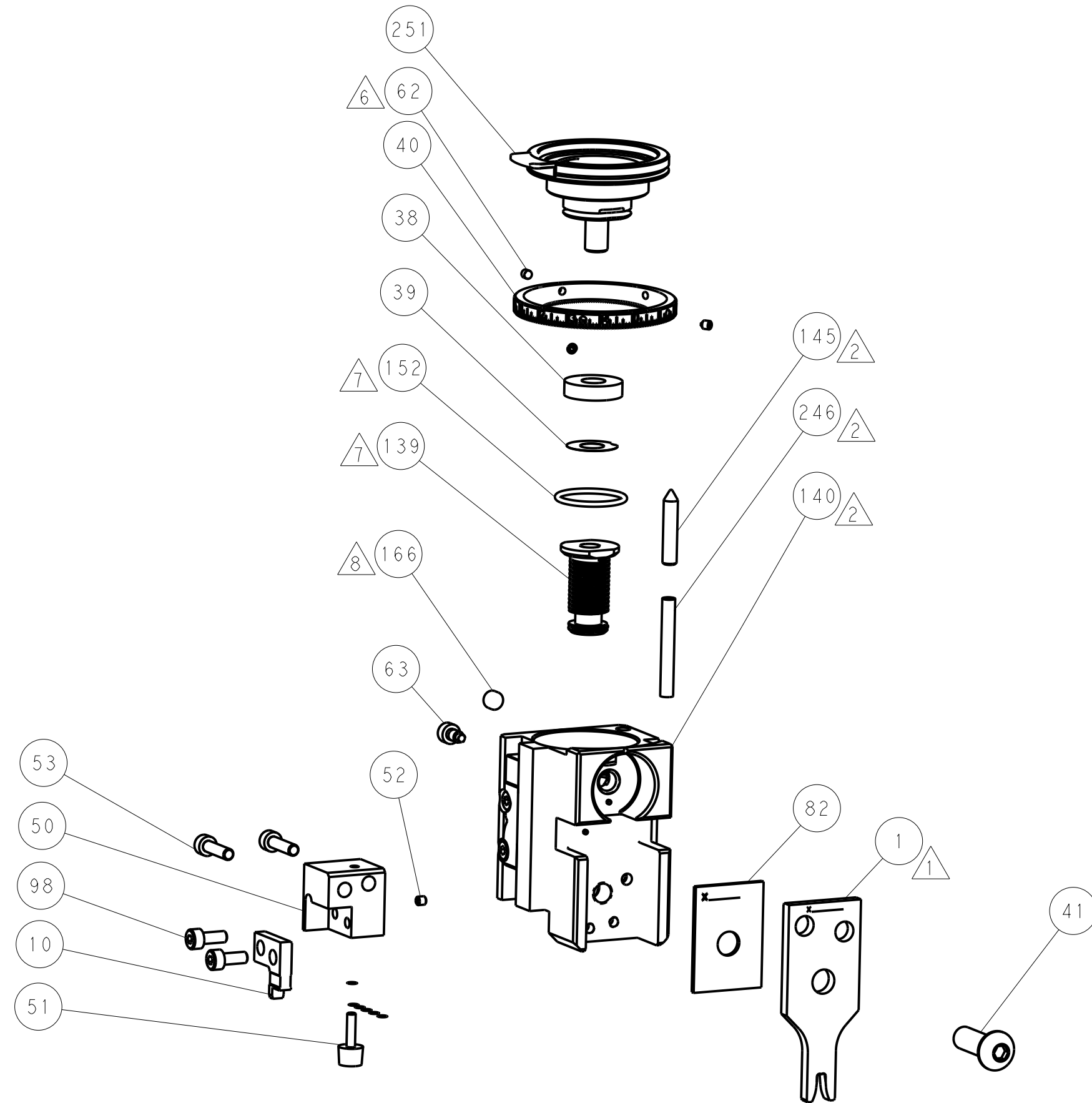
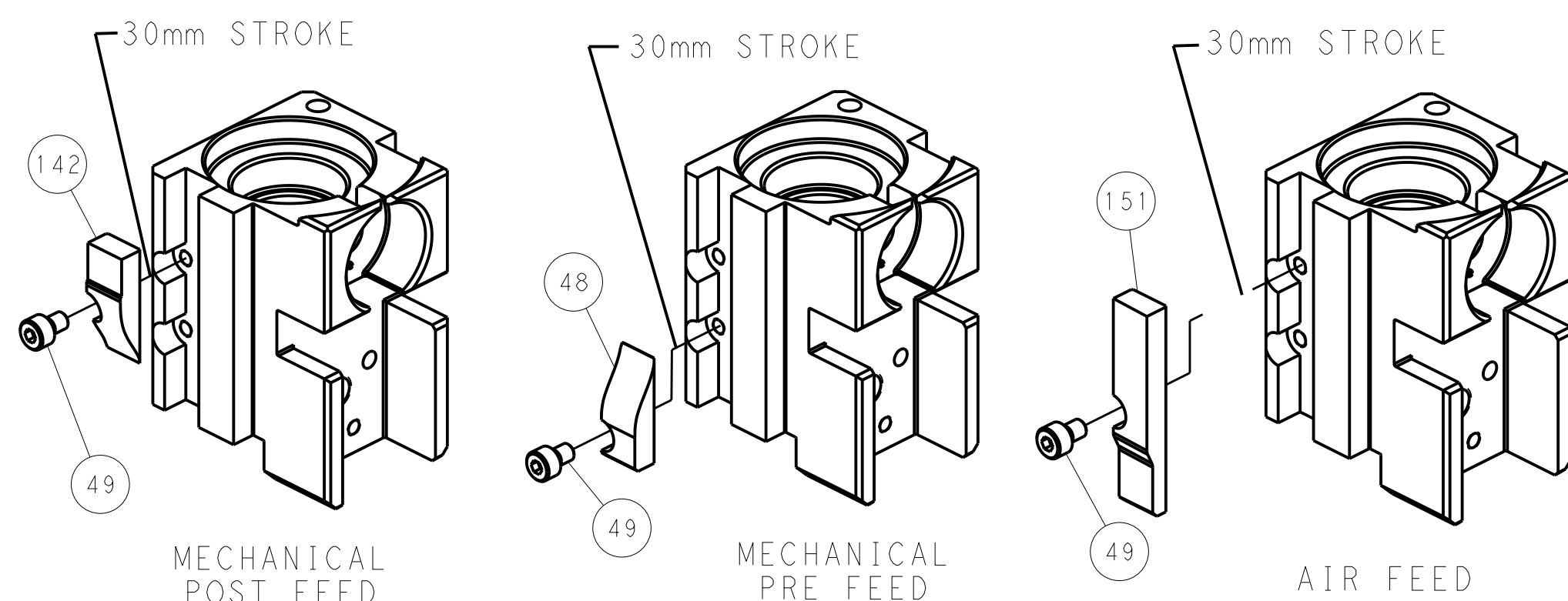
PNEUMATIC



SERVO LATCH PLATE



CAM POSITIONS



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 ±.5 1 PLC ±.13 2 PLC ±.13 3 PLC ±.13 4 PLC ±.0001 ANGLES FINISH	PRODUCT SPEC APPLICATION SPEC WEIGHT	SIZE A1	CAGE CODE 00779	DRAWING NO C=2151542
MATERIAL		Customer Accessible Production Drawing	SCALE 1:2	SHEET 4	OF 4 REV A

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION