

8

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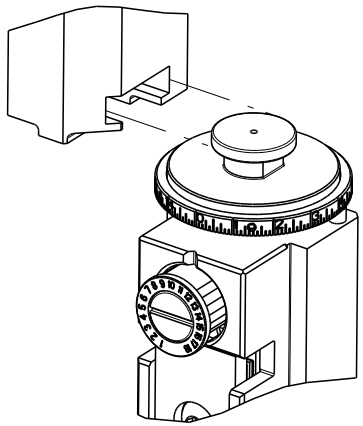
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ATLANTIC VERSION  
TERMINATOR  
INTERFACE ADAPTER

PART  
NUMBER

REVISION

DESCRIPTION



2151198-1

A

FINE CRIMP HEIGHT ADJUST

2151198-2

A

FINE CRIMP HEIGHT ADJUST

2151198-5

A

FINE CRIMP HEIGHT ADJUST

2151198-6

A

NON-CRIMP HEIGHT ADJUST

2151198-7

A

FINE CRIMP HEIGHT ADJUST

7-2151198-7

A

CRIMP TOOLING KIT

|                                      |                 |      |
|--------------------------------------|-----------------|------|
| APPLICATOR DATA                      |                 |      |
| CRIMP                                | SIZE            | TYPE |
| WIRE                                 | 1.78 mm [ .070] | F    |
| INSUL                                | 1.78 mm [ .070] | F    |
| APPLICATOR INSTRUCTIONS<br>408-10389 |                 |      |

|                                                                                   |             |                                                                                   |                                                           |
|-----------------------------------------------------------------------------------|-------------|-----------------------------------------------------------------------------------|-----------------------------------------------------------|
| TERMINAL DATA: TE TERMINAL                                                        |             | TE CRIMP SPECIFICATION                                                            |                                                           |
| TERMINAL NAME: SQUIB CONT 1MM PIN DIA SOCKET                                      |             |                                                                                   |                                                           |
| WIRE STRIP LENGTH<br>4.00-4.50 mm [.157-.177 IN]                                  |             |  | INSULATION DIAMETER RANGE<br>Ø1.40-1.70 mm [.055-.067 IN] |
| TERMINAL APPLICATION SPECIFICATION                                                | 114-5234    | -                                                                                 | -                                                         |
|  |             |                                                                                   |                                                           |
| TERMINALS APPLIED                                                                 |             |                                                                                   |                                                           |
| TE TERMINAL                                                                       | TE TERMINAL | TE TERMINAL                                                                       | TE TERMINAL                                               |
| 353376-3                                                                          | 353376-5    | 353376-6                                                                          | 1-353376-1                                                |
| 1-353376-2                                                                        |             |                                                                                   |                                                           |

|                   |                             |                                |
|-------------------|-----------------------------|--------------------------------|
| WIRE SIZE         | CRIMP HEIGHT mm [INCH]      | CRIMP HEIGHT REFERENCE SETTING |
| 20 AWG OR 0.50mm2 | 1.03+/-0.05 [ .041+/- .002] | 7.2                            |
| 22 AWG OR 0.30mm2 | 0.94+/-0.05 [ .037+/- .002] | 8.2                            |



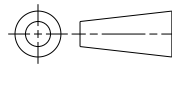
- 1 RECOMMENDED SPARE PARTS
- 2 GREASE BEARING SURFACES LIGHTLY
3. LUBRICATE DAILY PER THE APPLICATOR INSTRUCTION SHEET SUPPLIED WITH THE APPLICATOR.
- 4 APPLICATOR SPECIFIC DATA TO BE ENTERED INTO BLANK MEMORY CHIP AT ASSEMBLY. SEE BELOW FOR PART NUMBER:  
MECHANICAL FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151198-4  
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151198-4  
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151198-5  
SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2151198-6
5. ADJUSTMENT OF THE STRIPPER MAY BE REQUIRED WHEN MOVING THE APPLICATOR BETWEEN BENCH AND LEADMAKER APPLICATIONS.
- 6APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 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 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 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

\*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<br>2119599-1 | LOC<br>A | DIST<br>66  | REVISIONS |           |     |      |
| P                         | LTR      | DESCRIPTION |           | DATE      | OWN | APVD |
|                           | A        | REVISED     |           | 12DEC2014 | RK  | GB   |
|                           |          |             |           |           |     |      |
|                           |          |             |           |           |     |      |
|                           |          |             |           |           |     |      |

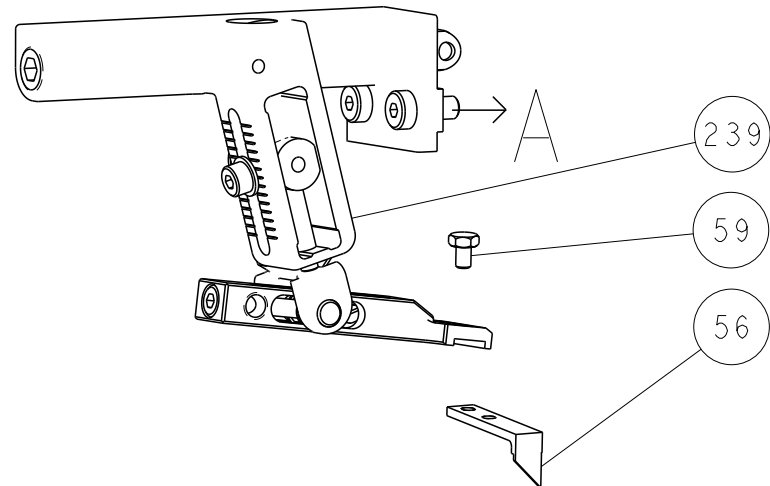
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|---|-----|-----|-----|-----|-----|-------------|-------------------------------------|-----|
| - | -   | 1   | -   | -   | -   | 2119957-2   | APPLICATOR SHIM PACK                | 260 |
| - | 1   | -   | 1   | 1   | 1   | 8-21084-0   | O-RING, .676 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 |
| - | 1   | 1   | 1   | 1   | 1   | 2119082-4   | CAM, SNAIL, INSULATION ADJUSTMENT   | 244 |
| - | 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 |
| - | 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 |
| - | -   | -   | -   | -   | 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 |
| - | -   | REF | REF | -   | -   | 2119944-1   | FEED FINGER ASSEMBLY,SF             | 117 |
| - | 1   | 1   | 1   | 1   | 1   | 455888-6    | SPACER, CRIMPER                     | 82  |
| - | 1   | 1   | 1   | 1   | 1   | 2119956-1   | DOCUMENTATION PACKAGE               | 71  |
| - | 1   | 1   | 1   | 1   | 1   | 2119791-5   | DEPRESSOR, WIRE                     | 70  |
| - | 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   | 1338685-1   | PAWL, FEED                          | 56  |
| - | 4   | 4   | 4   | 4   | 4   | 2168400-1   | SHCS, LOW HEAD, RoHS, M4 X 12       | 54  |
| - | 2   | 2   | 2   | 2   | 2   | 1-2168083-0 | SCR, SKT HD CAP, RoHS, M4 X 10      | 53  |
| - | 1   | 1   | 1   | 1   | 1   | 5018030-1   | NUT, HEX, REG, RoHS, M3             | 52  |
| - | 1   | 1   | 1   | 1   | 1   | 811242-5    | BUMPER, HOLD DOWN                   | 51  |
| - | 1   | 1   | 1   | 1   | 1   | 690753-2    | SPACER, TONKER                      | 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   | 2119656-9   | 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   | 2119644-1   | 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  |
| - | 1   | 1   | 1   | 1   | 1   | 5-1752356-5 | SUPPORT, TERMINAL                   | 34  |
| - | 2   | 2   | 2   | 2   | 2   | 2079383-5   | SCR, BHSC, RoHS (M4 X 20)           | 33  |
| - | 1   | 1   | 1   | 1   | 1   | 2161328-1   | HEX HEAD, FLANGED, M5 x 8mm LONG    | 32  |
| - | 1   | 1   | 1   | 1   | 1   | 1320908-3   | SPACER, STRIP GUIDE                 | 30  |
| - | 1   | 1   | 1   | 1   | 1   | 2119959-1   | ASSEMBLY, STRIP GUIDE               | 29  |
| - | 1   | 1   | 1   | 1   | 1   | 455888-4    | SPACER, CRIMPER                     | 28  |
| - | 1   | 1   | 1   | 1   | 1   | 1320928-2   | STRIP GUIDE                         | 24  |
| - | 1   | 1   | 1   | 1   | 1   | 2168083-2   | SCR, SKT HD CAP, RoHS, M4 X 8.0     | 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   | 2119806-1   | INSERT, SHEAR                       | 13  |
| - | 1   | 1   | 1   | 1   | 1   | 3-22280-3   | SPRING, COMPRESSION                 | 12  |
| - | 1   | 1   | 1   | 1   | 1   | 1-356885-4  | STOP, SHEAR                         | 11  |
| - | 1   | 1   | 1   | 1   | 1   | 2119805-1   | SHEAR HOLDER, FRONT                 | 10  |
| - | 1   | 1   | 1   | 1   | 1   | 1803095-1   | FLOATING SHEAR, FRONT               | 9   |
| - | 1   | 1   | 1   | 1   | 1   | 1333203-7   | ANVIL, COMBINATION                  | 8   |
| - | 1   | 1   | 1   | 1   | 1   | 2119757-8   | DEPRESSOR, SHEAR                    | 5   |
| - | 1   | 1   | 1   | 1   | 1   | 5-238011-5  | BLOCK, CRIMPER SPACER               | 4   |
| - | 1   | 1   | 1   | 1   | 1   | 1-1633961-3 | CRIMPER, INSULATION F PREMIUM       | 3   |
| - | 1   | 1   | 1   | 1   | 1   | 1-456404-8  | CRIMPER, WIRE PREMIUM               | 1   |

|                                                                                                                                       |  |                  |              |                                                    |          |
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| DIMENSIONS:<br>mm                                                                                                                     |  | CHK              | -            | NAME<br>Ocean Side Feed<br>Applicator              |          |
|                                                  |  | APVD<br>S. XI    | 16AUG2011    | SIZE<br>CAGE CODE<br>DRAWING NO<br>00779 ©=2151198 |          |
|                                                                                                                                       |  | PRODUCT SPEC     | -            |                                                    |          |
| MATERIAL<br>-                                                                                                                         |  | APPLICATION SPEC | -            | RESTRICTED TO<br>-                                 |          |
|                                                                                                                                       |  | FINISH           | -            |                                                    |          |
| Customer Accessible Production Drawing                                                                                                |  | WEIGHT<br>-      | SCALE<br>1:2 | SHEET<br>1                                         | REV<br>A |

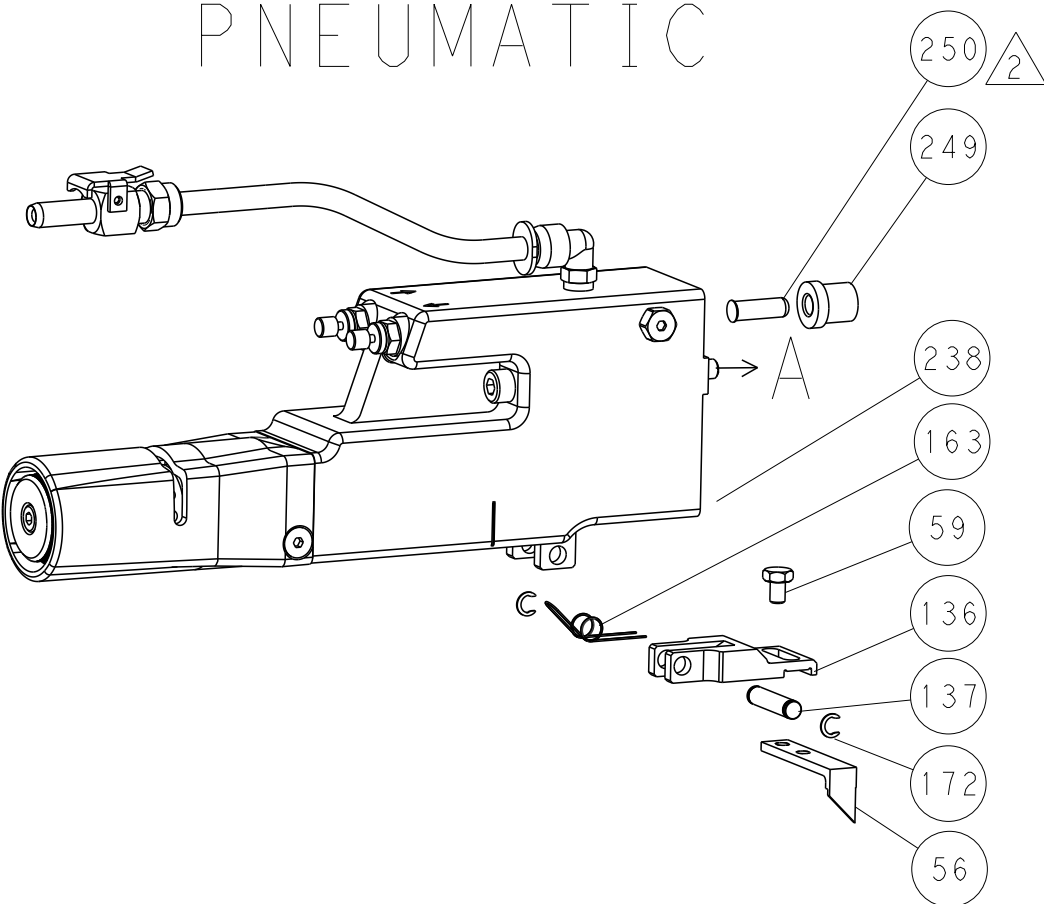
SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

| LOC |     | DIST        |  | REVISONS |     |      |  |
|-----|-----|-------------|--|----------|-----|------|--|
| P   | LTR | DESCRIPTION |  | DATE     | DWN | APVD |  |
| -   | -   | SEE SHEET 1 |  | -        | -   | -    |  |
|     |     |             |  |          |     |      |  |
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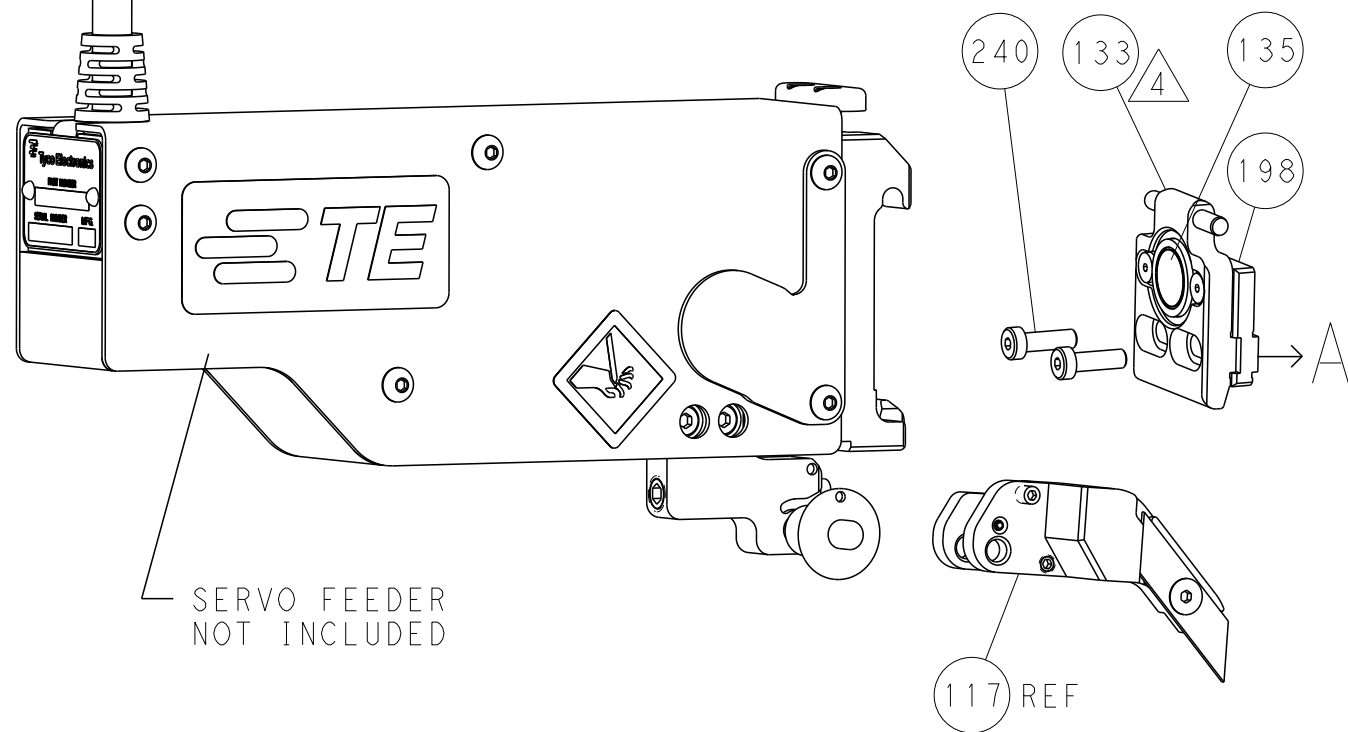
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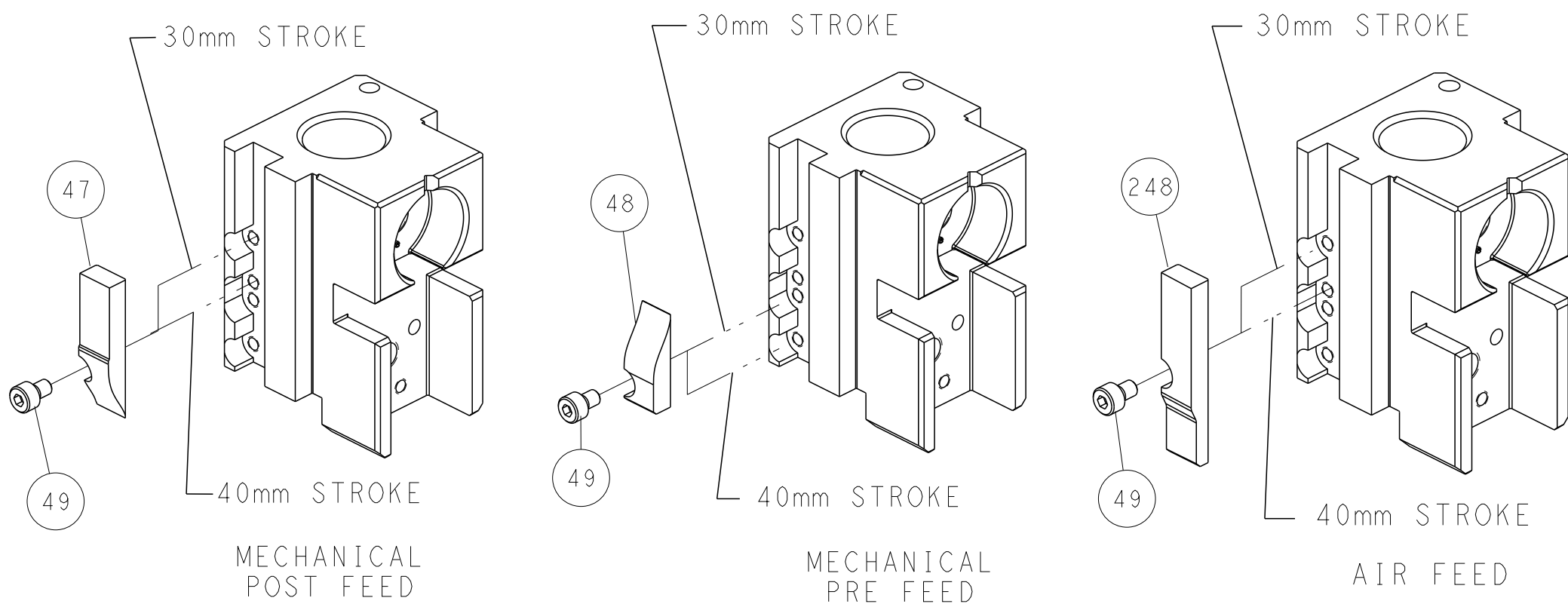
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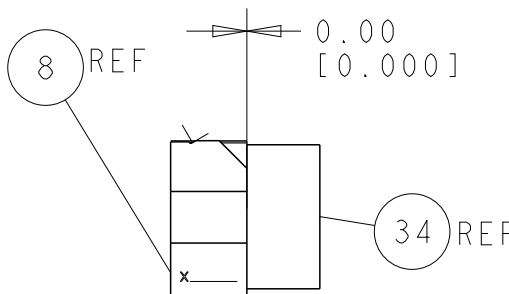
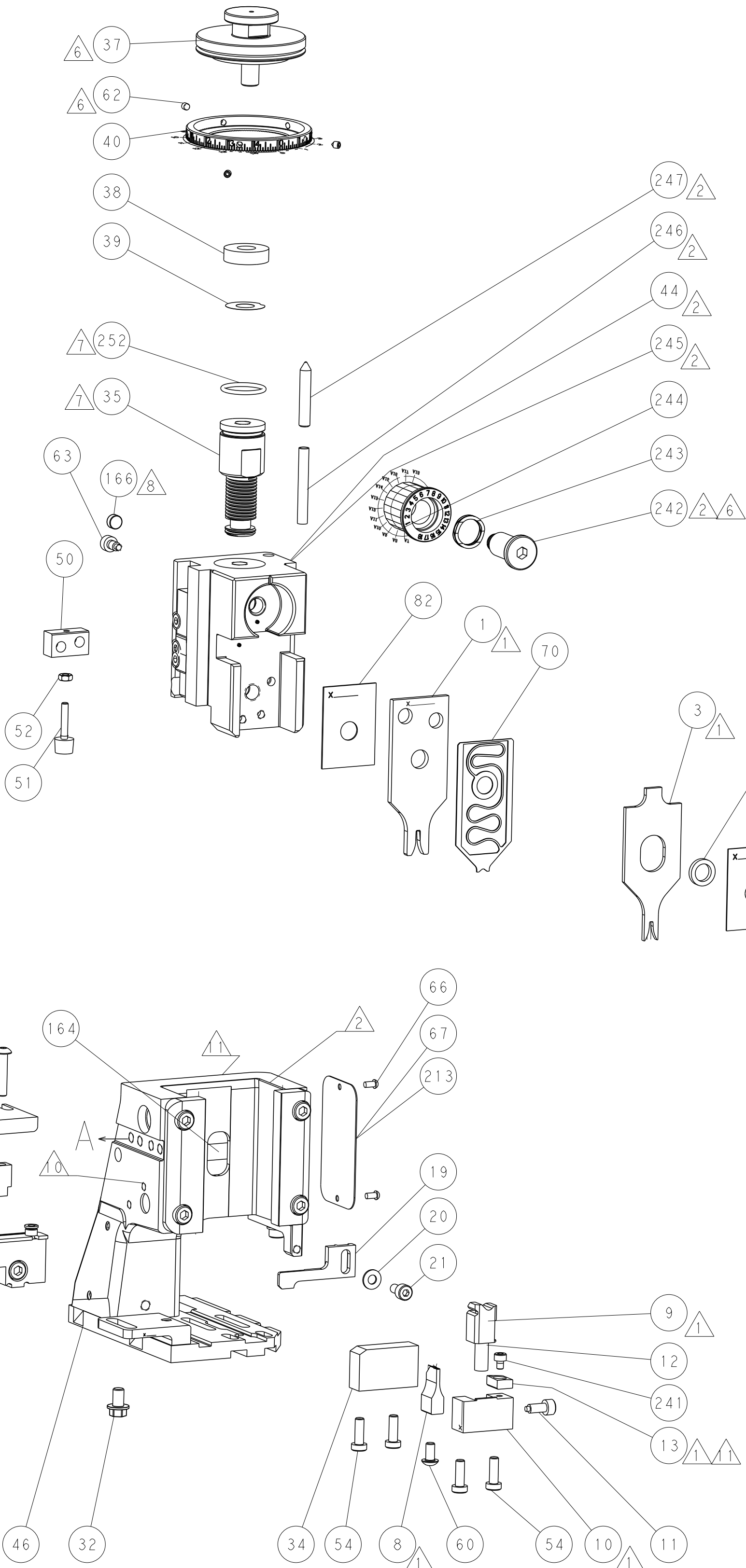
# SERVO LATCH PLATE



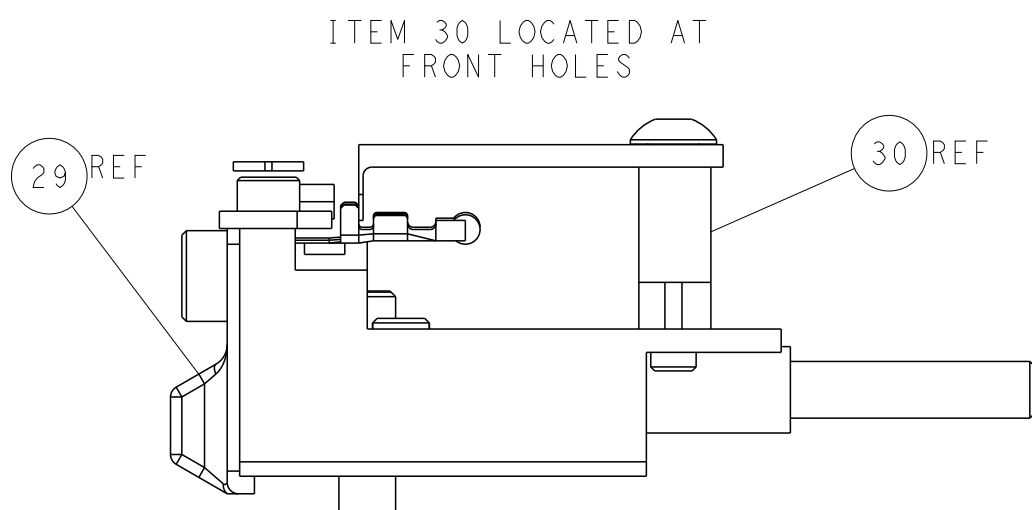
# CAM POSITIONS



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



TERMINAL SUPPORT LOCATION



FEED TRACK POSITION  
GUIDE BY INSULATION BARREL

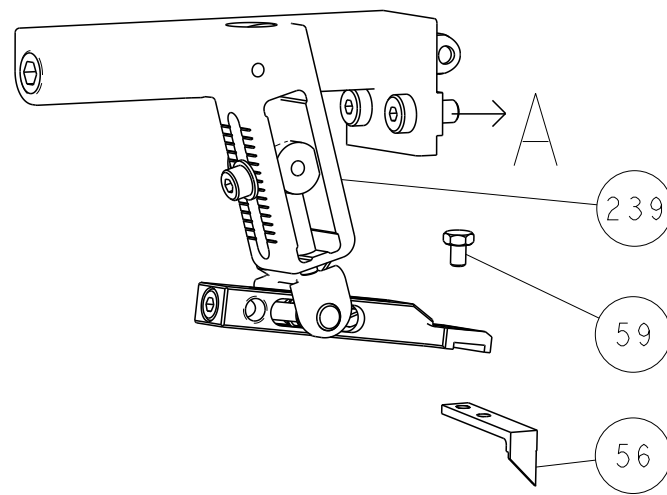
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| DIMENSIONS:<br>mm                                                                                                                                       |  | CHK<br>S. XI    | 16AUG2011 | NAME<br>Ocean Side Feed<br>Applicator        |  |
| TOLERANCES UNLESS OTHERWISE SPECIFIED:<br>0 PLC ±.5<br>1 PLC ±.5<br>2 PLC ±.13<br>3 PLC ±.013<br>4 PLC ±.0001<br>ANGLES FINISH                          |  | APVD<br>S. XI   | 16AUG2011 | PRODUCT SPEC                                 |  |
| MATERIAL                                                                                                                                                |  | APVD<br>S. XI   | 16AUG2011 | APPLICATION SPEC                             |  |
| WEIGHT                                                                                                                                                  |  | APVD<br>S. XI   | 16AUG2011 | RESTRICTED TO                                |  |
| Customer Accessible Production Drawing                                                                                                                  |  | APVD<br>S. XI   | 16AUG2011 | SCALE 1:2 SHEET 2 OF 4 REV A                 |  |

SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

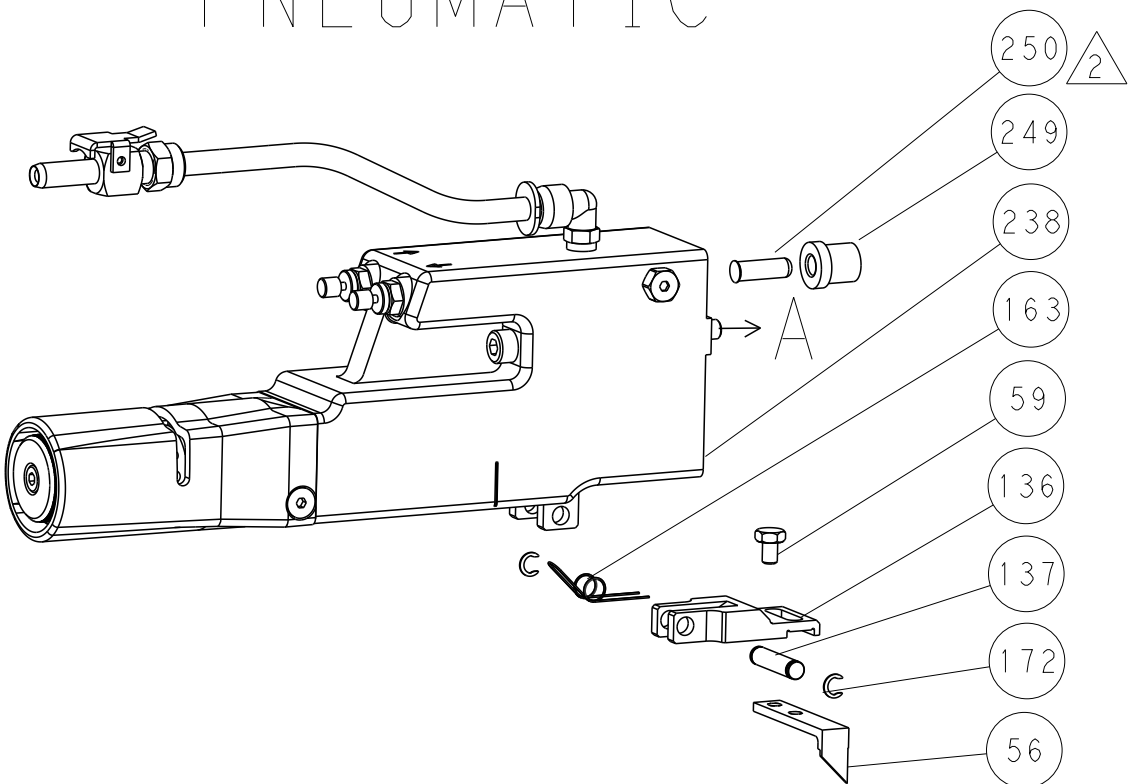


| LOC | DIST | REVISIONS |     |             |      |     |      |
|-----|------|-----------|-----|-------------|------|-----|------|
|     |      | P         | LTR | DESCRIPTION | DATE | DWN | APVD |
| A   | 66   | -         | -   | SEE SHEET 1 | -    | -   | -    |
|     |      |           |     |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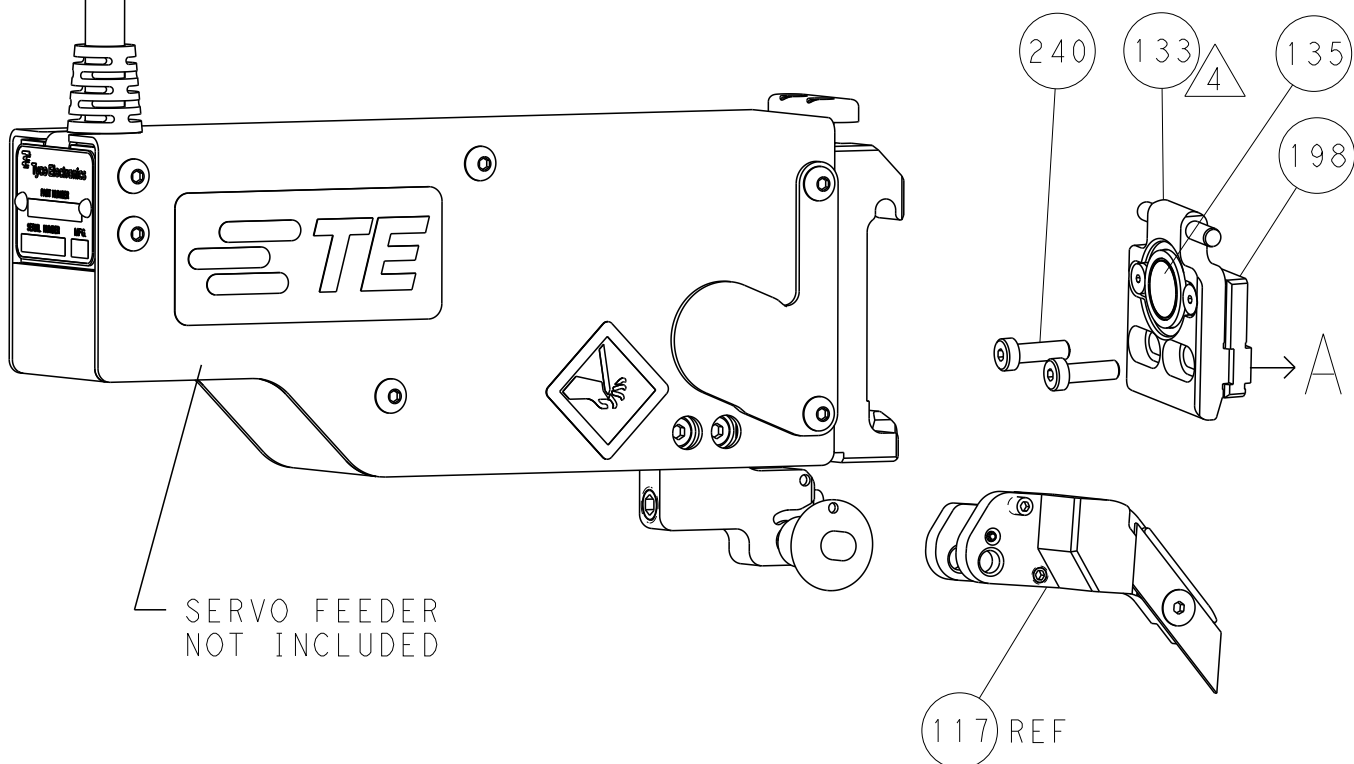
FEED TYPE  
MECHANICAL



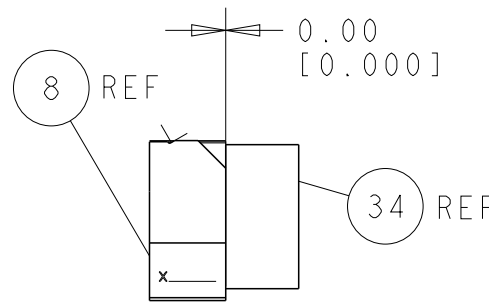
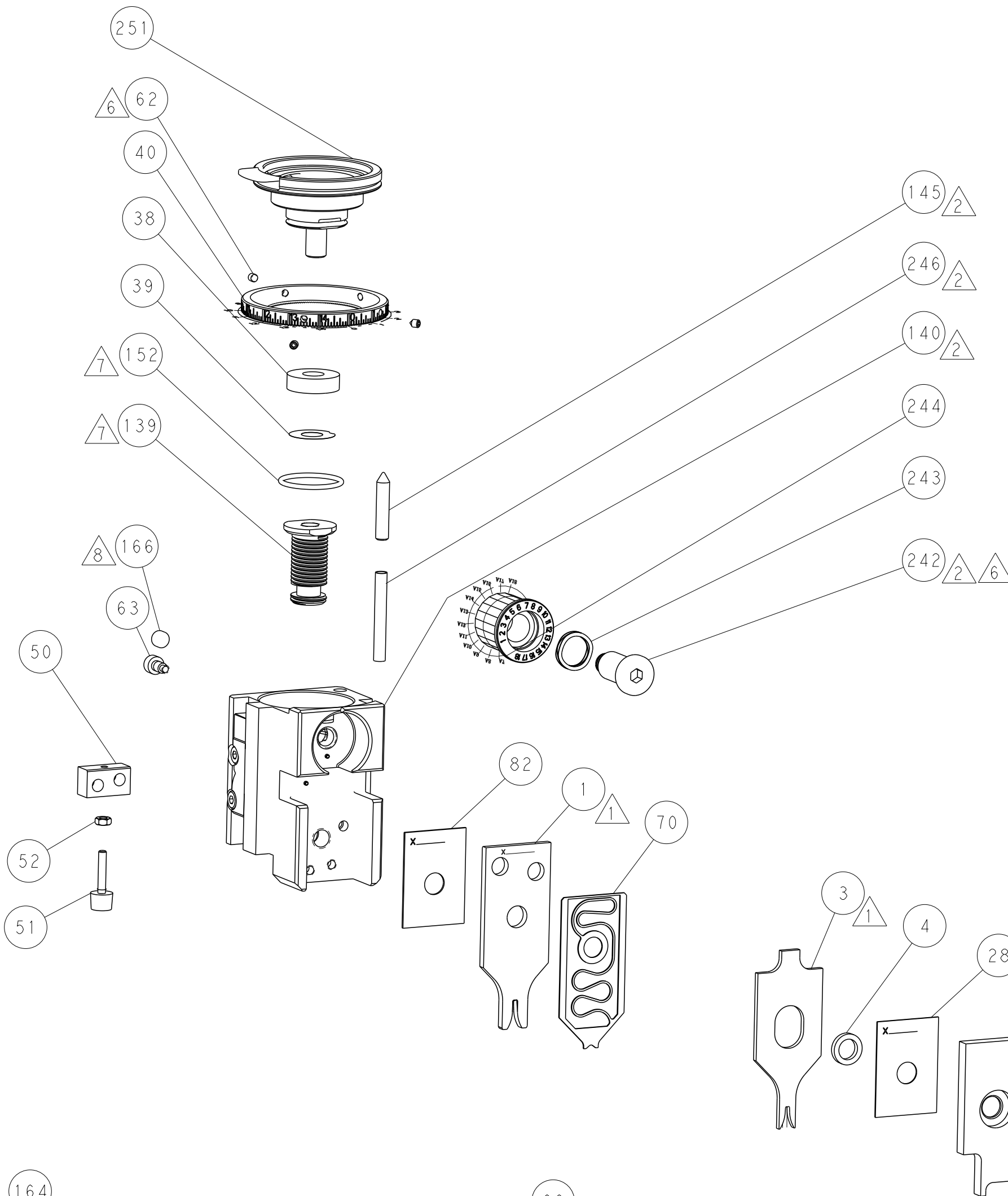
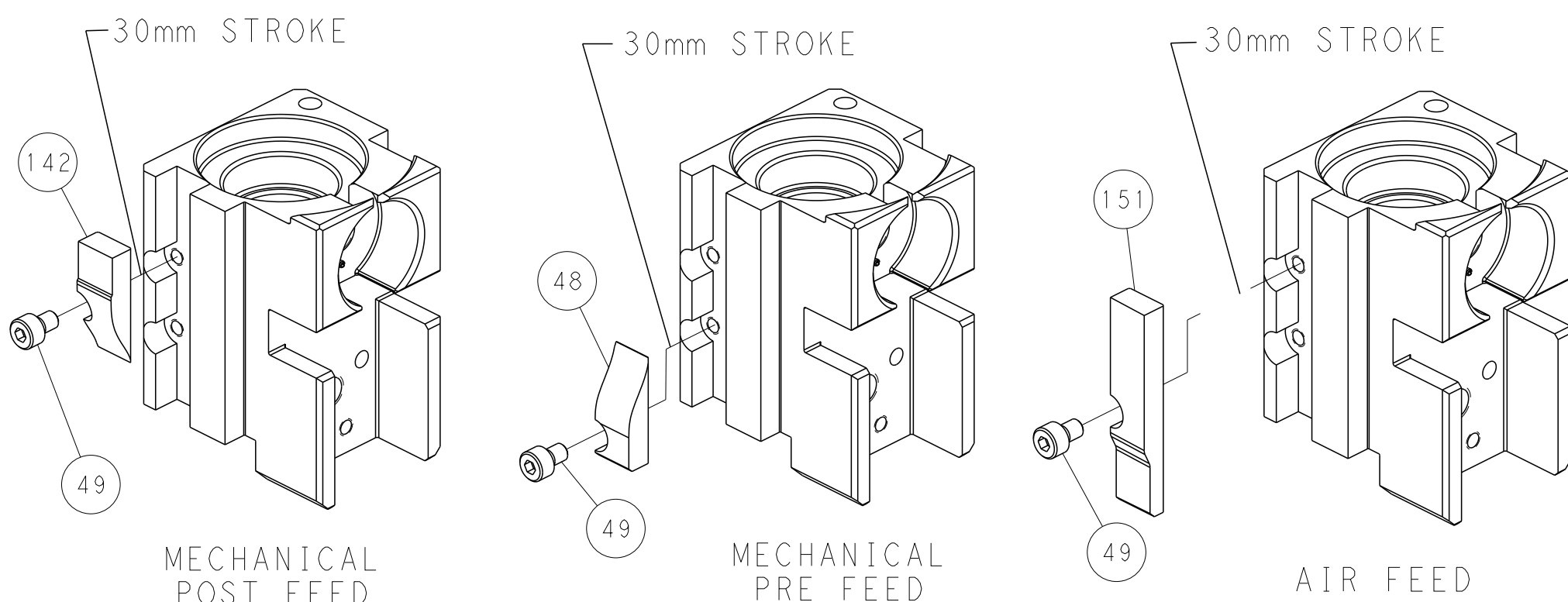
PNEUMATIC



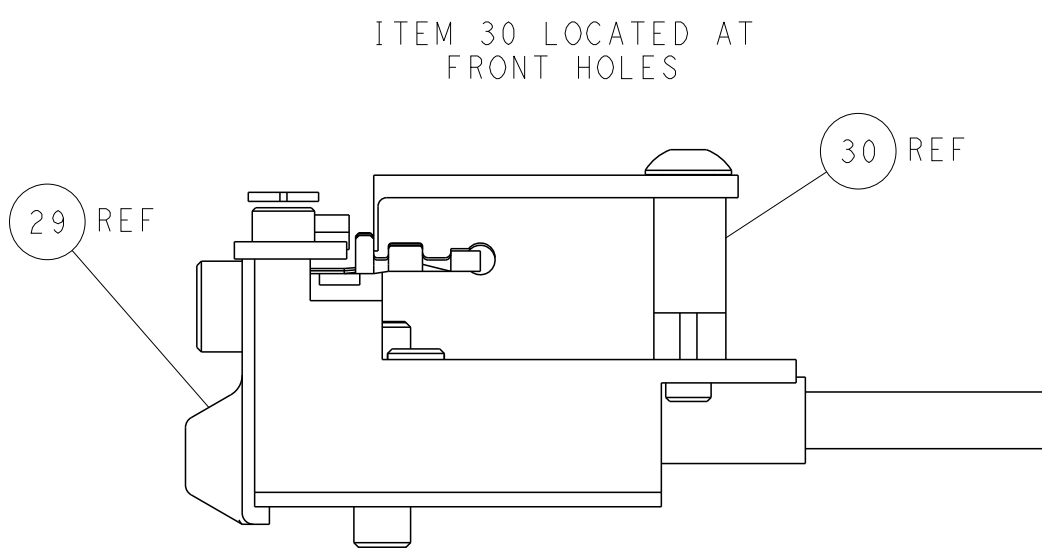
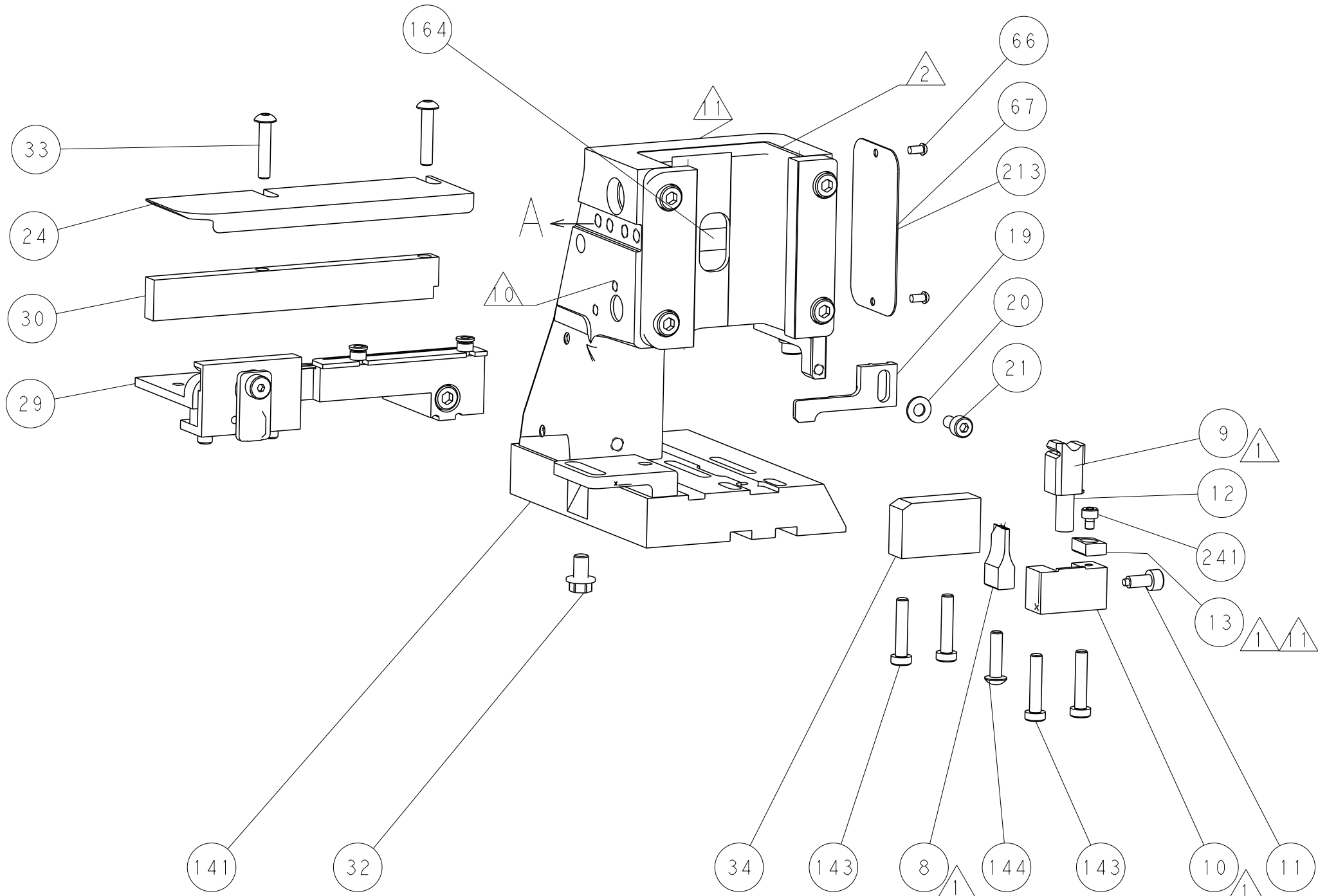
SERVO  
LATCH PLATE



CAM POSITIONS



TERMINAL SUPPORT LOCATION



FEED TRACK POSITION  
GUIDE BY INSULATION BARREL

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                                    | -        | -         | Harrisburg, PA 17105-3608                                                                                                                |  |
| DIMENSIONS:                                                                                                                                          |  | APVD                                   | S. XI    | 16AUG2011 | NAME<br>Ocean Side Feed<br>Applicator<br>-<br><br>SIZE<br>CAGE CODE<br>DRAWING NO<br>RESTRICTED TO<br><br>SCALE<br>SHEET 4 OF 4<br>REV A |  |
| mm                                                                                                                                                   |  | PRODUCT SPEC                           |          |           |                                                                                                                                          |  |
| TOLERANCES UNLESS OTHERWISE SPECIFIED:                                                                                                               |  | APPLICATION SPEC                       |          |           |                                                                                                                                          |  |
| 0 PLC ±.5                                                                                                                                            |  | WEIGHT                                 |          |           |                                                                                                                                          |  |
| 1 PLC ±0.5                                                                                                                                           |  | MATERIAL                               |          |           |                                                                                                                                          |  |
| 2 PLC ±0.13                                                                                                                                          |  | FINISH                                 |          |           |                                                                                                                                          |  |
| 3 PLC ±0.013                                                                                                                                         |  | Customer Accessible Production Drawing |          |           |                                                                                                                                          |  |
| 4 PLC ±0.0001                                                                                                                                        |  | 1:2                                    |          |           |                                                                                                                                          |  |
| ANGLES                                                                                                                                               |  | 4                                      |          |           |                                                                                                                                          |  |
| FINISH                                                                                                                                               |  | REV A                                  |          |           |                                                                                                                                          |  |
| -                                                                                                                                                    |  | A                                      |          |           |                                                                                                                                          |  |
| -                                                                                                                                                    |  | A                                      |          |           |                                                                                                                                          |  |