

8

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ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER

PART NUMBER

REVISION

DESCRIPTION

FEED TYPE

CONVERT TO

PART NUMBERS REQUIRED

2266630-1

A

FINE CRIMP HEIGHT ADJUST

MECHANICAL

PNEUMATIC FEED

SERVO LATCH PLATE

SMART APPLICATOR

2119950-1

2119951-1

2161326-1

1338685-1

-

-

5-18022-5

8-2266630-5

8-2266630-4

2119641-1

1901094-3

-

2119799-1

-

-

2063440-1

2168400-6 (QUANTITY 2)

-

2266630-2

A

FINE CRIMP HEIGHT ADJUST

PNEUMATIC

MECHANICAL FEED

SERVO LATCH PLATE

SMART APPLICATOR

2119949-1

2119951-1

2161326-1

1338685-1

-

-

5-18022-5

8-2266630-5

8-2266630-4

2119653-1

1901094-3

-

-

-

-

-

-

-

-

2168400-6 (QUANTITY 2)

-

2266630-5

A

FINE CRIMP HEIGHT ADJUST

SERVO LATCH PLATE⁴

MECHANICAL FEED

PNEUMATIC FEED

2119949-1

2119950-1

1338685-1

-

5-18022-5

5-18022-5

2119653-1

2119641-1

-

2119799-1

-

2063440-1

2266630-6

A

NON-CRIMP HEIGHT ADJUST

SERVO LATCH PLATE⁴¹²

-

-

-

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2266630-7

A

FINE CRIMP HEIGHT ADJUST

NONE

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-

7-2266630-7

A

CRIMP TOOLING KIT

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-

APPLICATOR DATA

CRIMP

SIZE

TYPE

WIRE

3.56 mm [1.140]

F

INSUL

5.33 mm [1.210]

F

APPLICATOR INSTRUCTIONS

408-10389

TERMINAL DATA: TE TERMINAL

TE CRIMP SPECIFICATION

TERMINAL NAME: .156 MATE-N-LOK TERMINAL

WIRE STRIP LENGTH

INSULATION DIAMETER RANGE

4.95-5.71 mm [1.95-.225 IN]

4.70mm [1.85 IN] MAX

TERMINAL APPLICATION SPECIFICATION

114-1109

-

-

TERMINALS APPLIED³

TE TERMINAL

TE TERMINAL

TE TERMINAL

TE TERMINAL

1586487-1

1586486-1

61234-1

61233-1

WIRE SIZE

CRIMP HEIGHT mm [INCH]

CRIMP HEIGHT REFERENCE SETTING⁹

10 AWG

2.70+/-0.05 [1.106+/-0.002]

4.8

12 AWG

2.21+/-0.05 [1.087+/-0.002]

9.9

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: 8-2266630-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2266630-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2266630-5
SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2266630-6

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 A NON CRIMP HEIGHT ADJUST APPLICATOR (-6) USE SHIMS FROM ITEM 260 TO ACHIEVE A NOMINAL SHIM HEIGHT OF 3.10.

13

FEED ADJUSTMENTS MAY BE REQUIRED WHEN SWITCHING TERMINALS.

*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.

-

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1

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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

-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

2119599-1

LOC

A

DIST

66

P

LTR

DESCRIPTION

DATE

OWN

APVD

A

RELEASED

27JAN2015

KH

TE

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1

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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

2119082-5

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

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-

1

1

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-

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

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-

1

1

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-

1633743-1

SERVO FEED LATCH ASM

133

-

-

REF

REF

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2119944-1

FEED FINGER ASSEMBLY,SF

117

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1

1

1

1

1

455888-6

SPACER, CRIMPER

82

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1

1

1

1

1

1-22278-0

SPRING, COMPRESSION

77

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1

1

1

1

1

854769-4

HOLDER, INS

74

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1

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2119956-1

DOCUMENTATION PACKAGE

71

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1

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1

2119740-1

TAG,IDENTIFICATION

67

-

2

2

2

2

2

2168078-1

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

66

-

1

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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

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1

1

1

1

1

2079383-4

SCR, BHSC, RoHS (M4 X 8)

60

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1

5-18022-5

SCR, HEX HD CAP, M4 X 6.0

59

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1

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1

21028-2

PIN, SLOTTED SPRING .062 X .250

58

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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

-

-

-

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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

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1

1

1

2119645-1

DISC, NUMBERED FA WIRE ADJUSTMENT

40

-

1

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1

1

1

2119957-1

APPLICATOR SHIM PACK

39

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1

1

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1

1-2119644-3

RAM WASHER, PRECISION

38

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1

1

1

1

1

2119085-1

FA HEAD, ATLANTIC STYLE

37

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1

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1

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1

2119092-1

BOLT, ADJUSTMENT

35

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1

1

1

1

1

3-1752356-3

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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1

1

1

1

1

2161328-1

HEX HEAD, FLANGED, M5 x 8mm LONG

32

-

1

1

1

1

1

2-1320908-2

SPACER, STRIP GUIDE

30

-

1

1

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1

2119959-1

ASSEMBLY, STRIP GUIDE

29

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1

1

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1

455888-3

SPACER, CRIMPER

28

-

1

1

1

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1

1320928-2

STRIP GUIDE

24

-

1

1

1

1

1

2168083-2

SCR, SKT HD CAP, RoHS, M4 X 8.0

21

-

2

2

2

2

2

1-18028-2

WASHER, FLAT, REG M4

20

-

1

1

1

1

1

2119533-1

STRIPPER, SIDE FEED

19

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1

1

1

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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

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1

1

1

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1

1-1633137-3

ANVIL, COMBINATION .140

8

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7

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6

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1

1-2119780-4

DEPRESSOR, SHEAR

5

-

1

1

1

1

1

1-238011-7

BLOCK, CRIMPER SPACER

4

-

1

1

1

1

1

1-1633961-6

CRIMPER, INSULATION F PREMIUM

3

-

1

1

1

1

1

455888-6

SPACER, CRIMPER

2

-

1

1

1

1

1

456411-3

CRIMPER, WIRE PREMIUM

1

-77

-7

-6

-5

-2

-1

PART NO

DESCRIPTION

ITEM NO

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APVD

U. GUO

18DEC2014

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

Customer Accessible Production Drawing

SCALE

1:2

SHEET

1

OF

4

REV

A

OWN

X. HUANG

18DEC2014

CHK

L. ZHANG

18DEC2014

NAME

Ocean Side Feed Applicator

SIZE

A1

CAGE CODE

00779

DRAWING NO

©=2266630

RESTRICTED TO

-

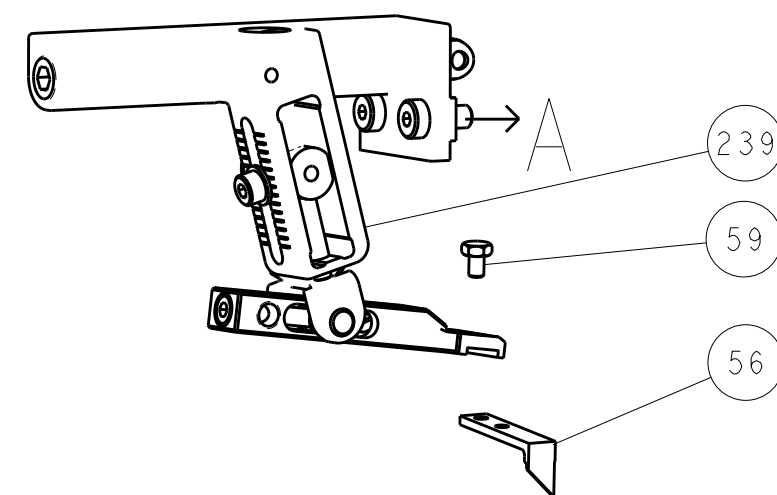
APPROVED FOR PUBLICATION

4805 REV 31MAR2000

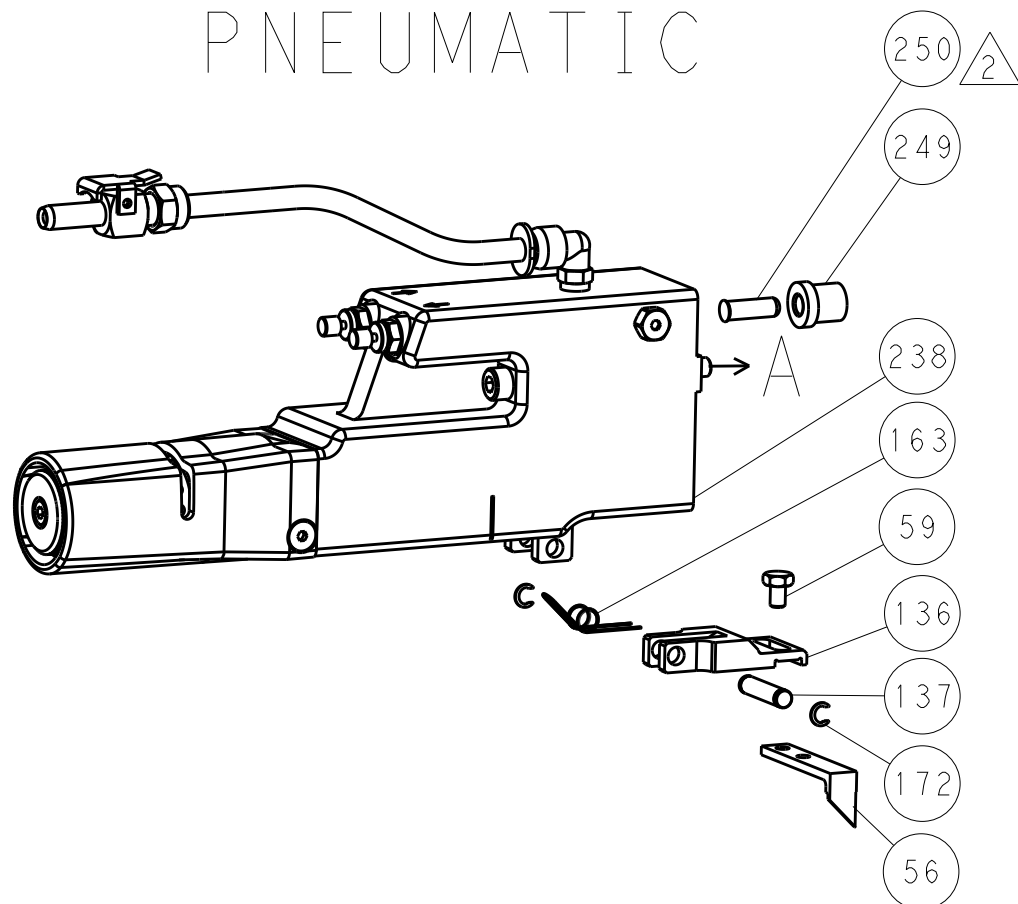
SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

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

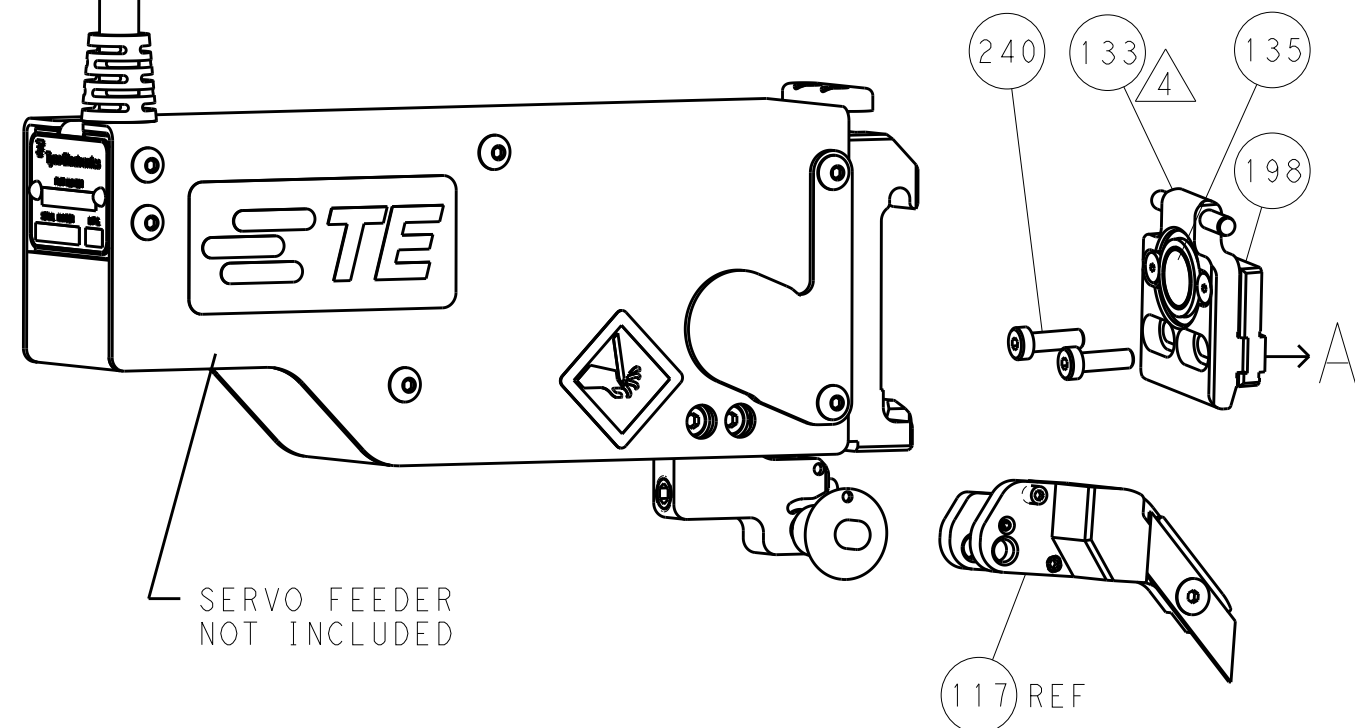
FEED TYPE MECHANICAL



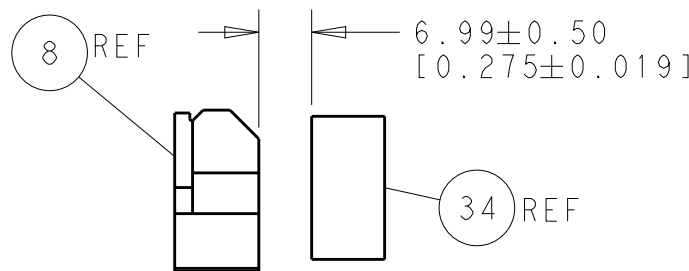
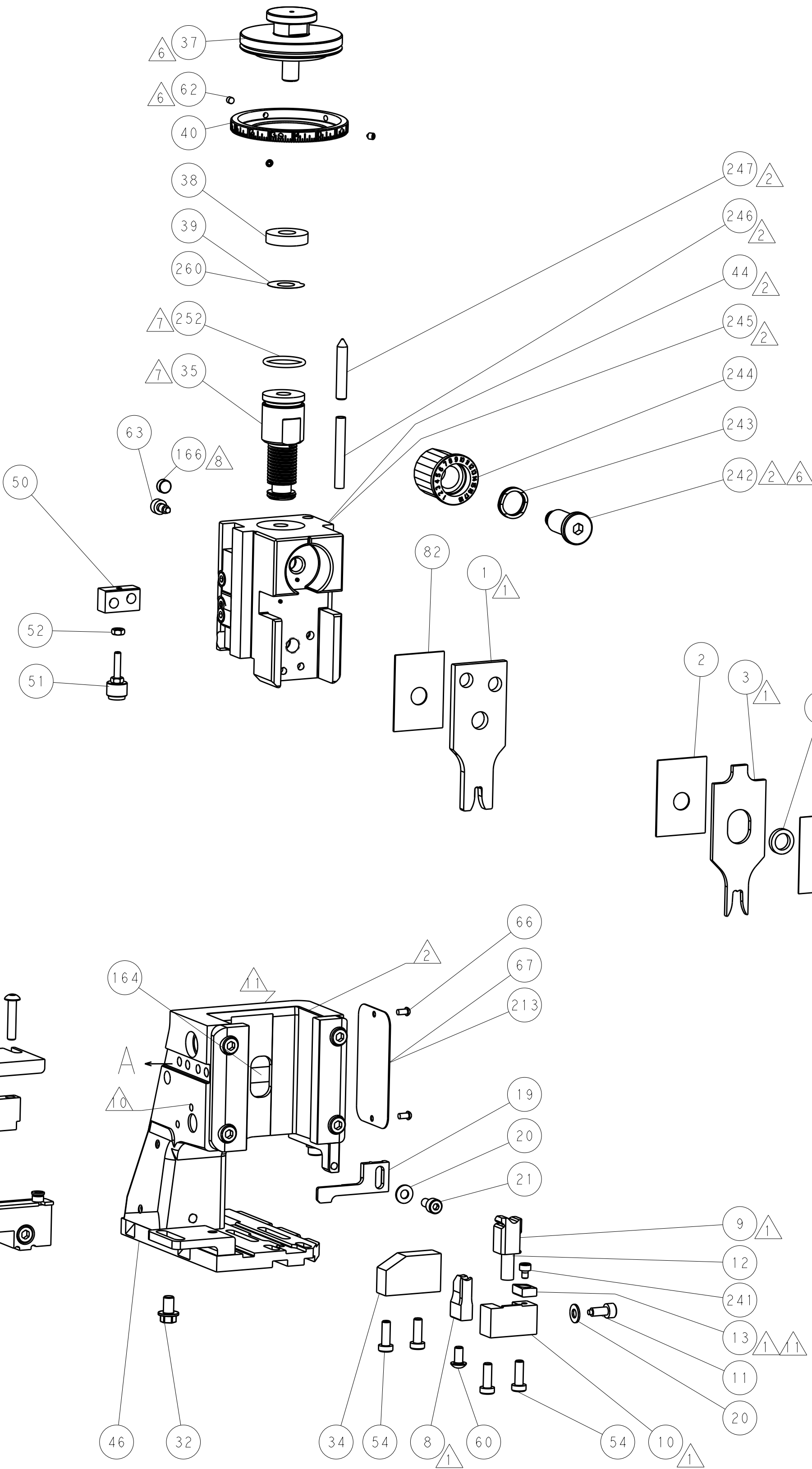
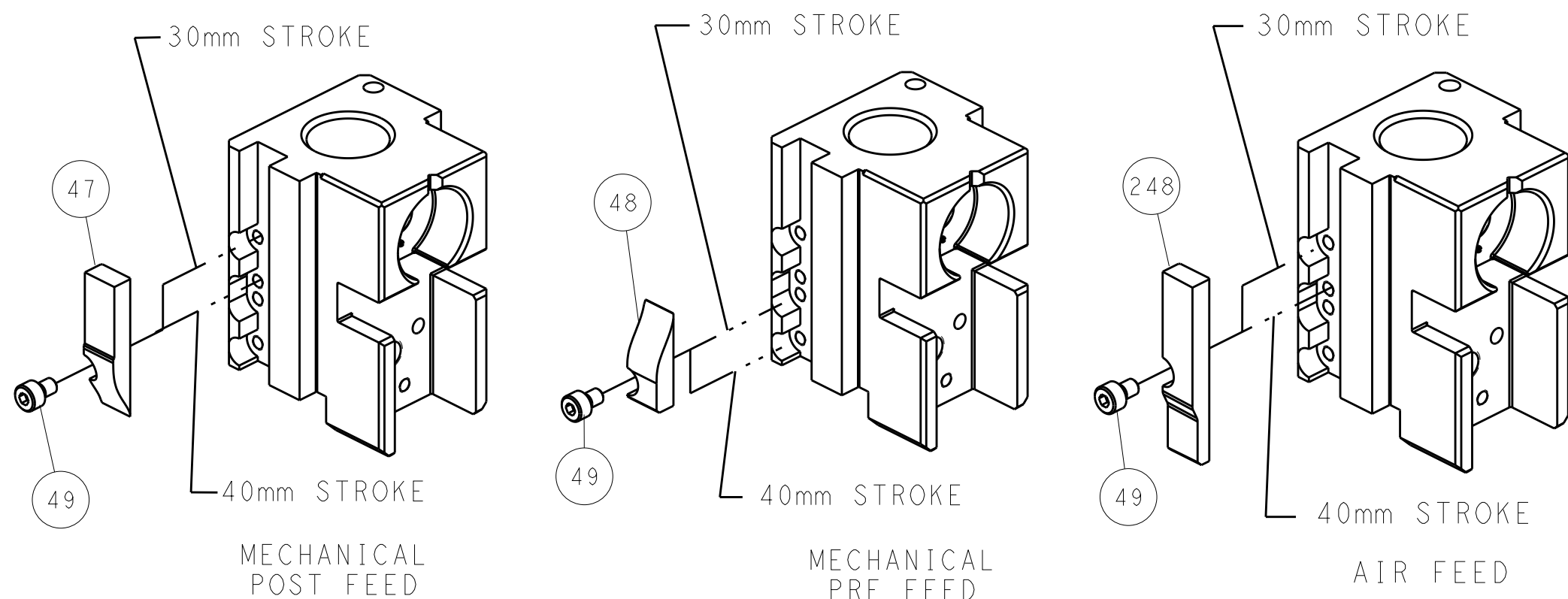
PNEUMATIC



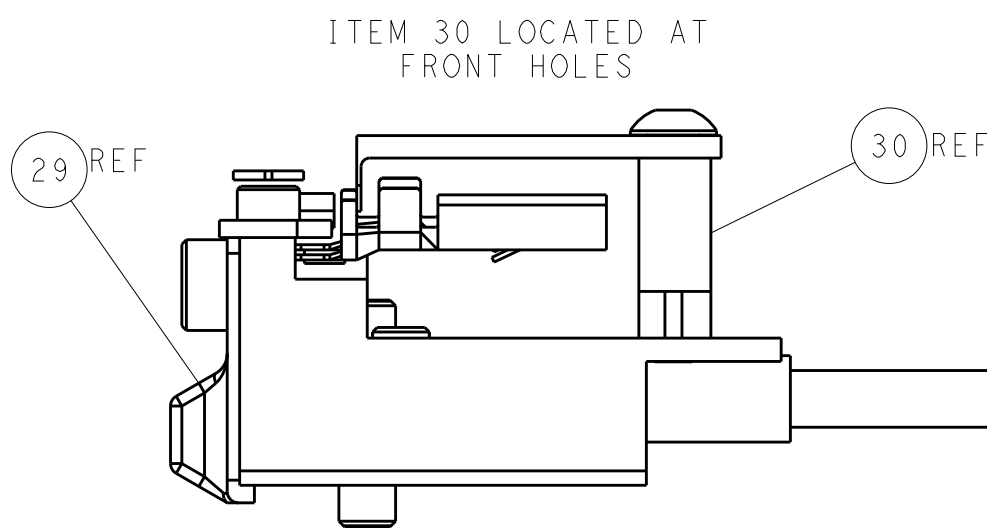
SERVO LATCH PLATE



CAM POSITIONS



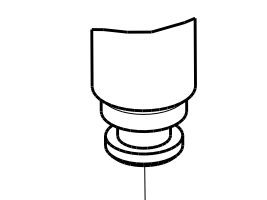
TERMINAL SUPPORT LOCATION



FEED TRACK POSITION
GUIDE BY INSULATION BARREL

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 FINISH				NAME: Ocean Side Feed Applicator			
MATERIAL: -				WEIGHT: -				SIZE: A1 00779 C=2266630			
Customer Accessible Production Drawing				SCALE: 1:2				SHEET 2 OF 4 REV A			

8		7		6		5		4		3	
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	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART						
					CONVERT TO	PART NUMBERS REQUIRED					
	PNEUMATIC FEED	2119950-1	1338685-1	5-18022-5	2119641-2	2119799-1	2063440-1				
		SERVO LATCH PLATE	2119951-1	-	8-2266630-5	1901094-3	-	2168400-6 (QUANTITY 2)			
	SMART APPLICATOR	2161326-1	-	8-2266630-4	-	-	-				
	MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-2	-	-				
	SERVO LATCH PLATE	2119951-1	-	8-2266630-5	1901094-3	-	2168400-6 (QUANTITY 2)				
	SMART APPLICATOR	2161326-1	-	8-2266630-4	-	-	-				
	MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-2	-	-				
	PNEUMATIC FEED	2119950-1	1338685-1	5-18022-5	2119641-2	2119799-1	2063440-1				
-	-	-	-	-	-	-	-	-	-		
-	-	-	-	-	-	-	-	-	-		

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	3.56 mm [.140]	F
INSUL	5.33 mm [.210]	F

APPLICATOR INSTRUCTIONS
408-10389



TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: .156 MATE-N-LOK TERMINAL			
WIRE STRIP LENGTH 		INSULATION DIAMETER RANGE	
4.95-5.71 mm [.195-.225 IN]		Ø 4.70mm [.185 IN] MAX	
TERMINAL APPLICATION 	114-1109	-	-
SPECIFICATION	-	-	-
TERMINALS APPLIED 			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
1586487-1	1586486-1	61234-1	61233-1

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING 
10 AWG		2.70+/-0.05 [1.06+/- .002]		4.8
12 AWG		2.21+/-0.05 [1.08+/- .002]		9.9

*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 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: 8-2266630-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2266630-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2266630-5
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.
- 7 GREASE THREADS, GROOVE AND O-RING ON ITEMS 139 & 152.
- 8 MAGNET 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 BACK SIDE OF THE HOUSING. REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.
- 12 FEED ADJUSTMENTS MAY BE REQUIRED WHEN SWITCHING TERMINALS.

-	1	1	1	1	2119782-1	FINE ADJUST HEAD ASM, PACIFIC STYLE	251
-	-	-	1	-	2119640-1	PUSH ROD, AIR FEED	250
-77	-27	-25	-22	-21	PART NO	DESCRIPTION	ITEM NO

PACIFIC VERSION
Shown on sheets 3 of 4 & 4 of 4
(Atlantic version shown on sheets 1 of 4 & 2 of 4)

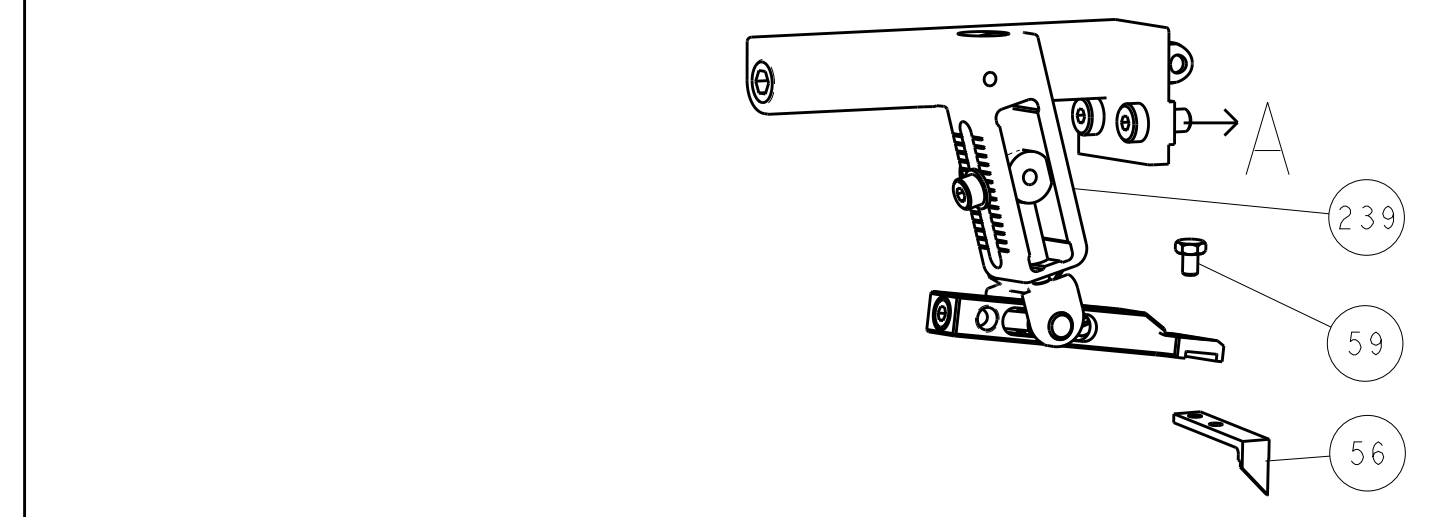
2				I		
SET UP GAUGE 2119599-1		LOC A	QIST 66	REVISIONS		
P	LTR	DESCRIPTION		DATE	OWN	APVD
	-	SEE SHEET 1		-	-	-

-	-	-	1	-	2079988-1	BUSHING, LCH5-12, MISUMI	249
-	1	1	1	1	1-22279-3	SPRING, COMPRESSION	246
-	1	1	1	1	2119082-5	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
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1	1	1	1	1	456411-3	CRIMPER, WIRE PREMIUM	1
-77	-27	-25	-22	-21	PART NO	DESCRIPTION	ITEM NO

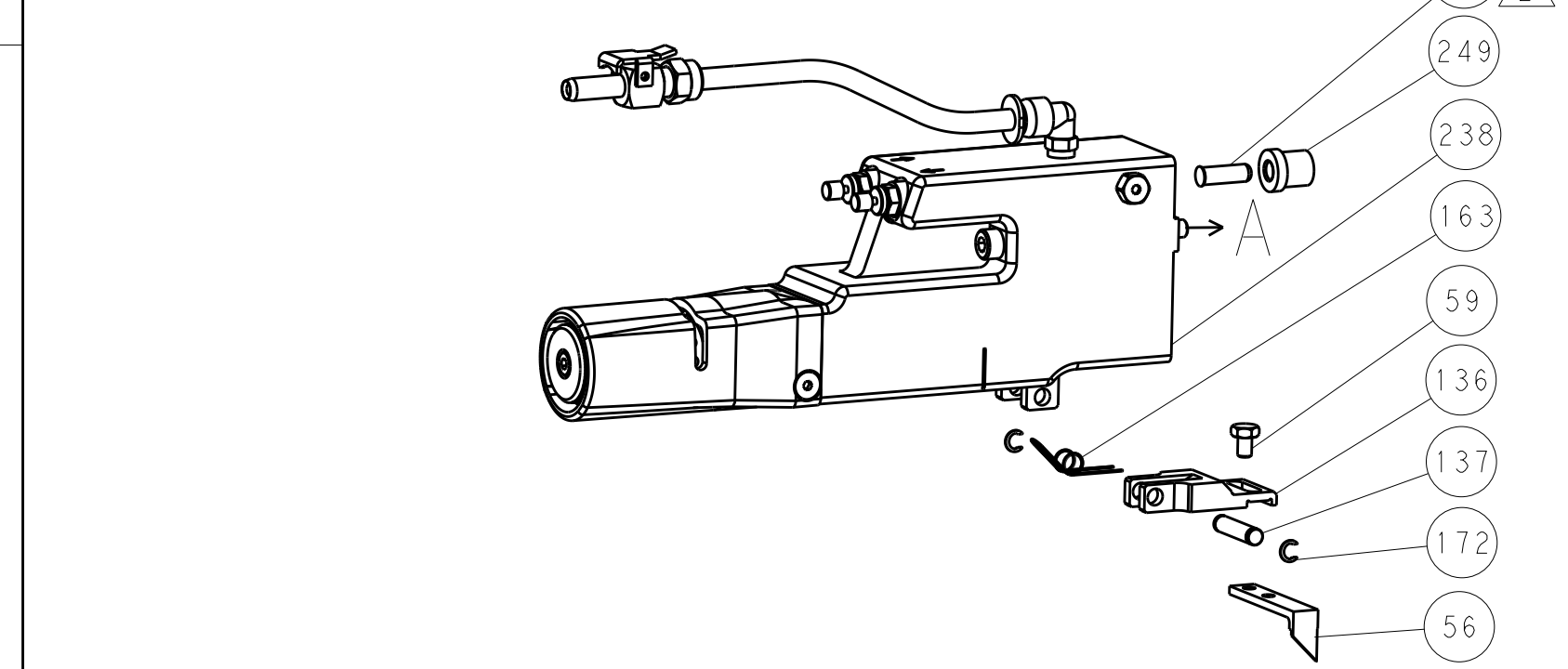
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DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.05 1 PLC ±0.5 2 PLC ±0.13 3 PLC ±0.013 4 PLC ±0.0001 ANGLES ±.		NAME			
		PRODUCT SPEC -					
		APPLICATION SPEC -					
MATERIAL		FINISH -		SIZE A	CAGE CODE 00779	DRAWING NO C=2266630	RESTRICTED TO -
Customer Accessible Production Drawing				SCALE 1:2	SHEET 3	OF 4	REV A

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

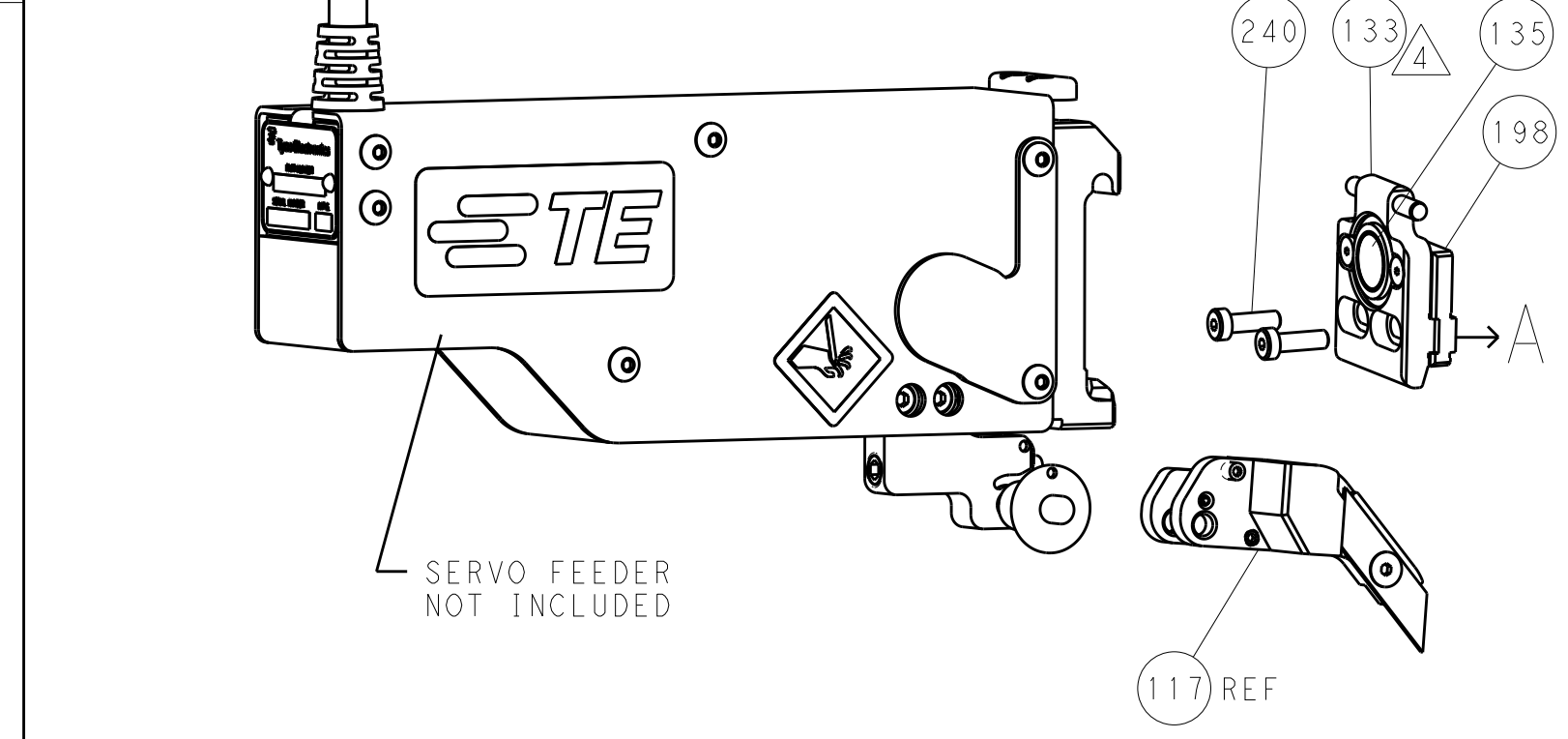
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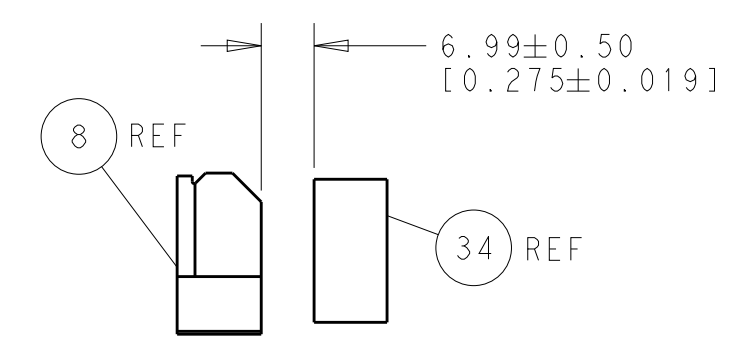
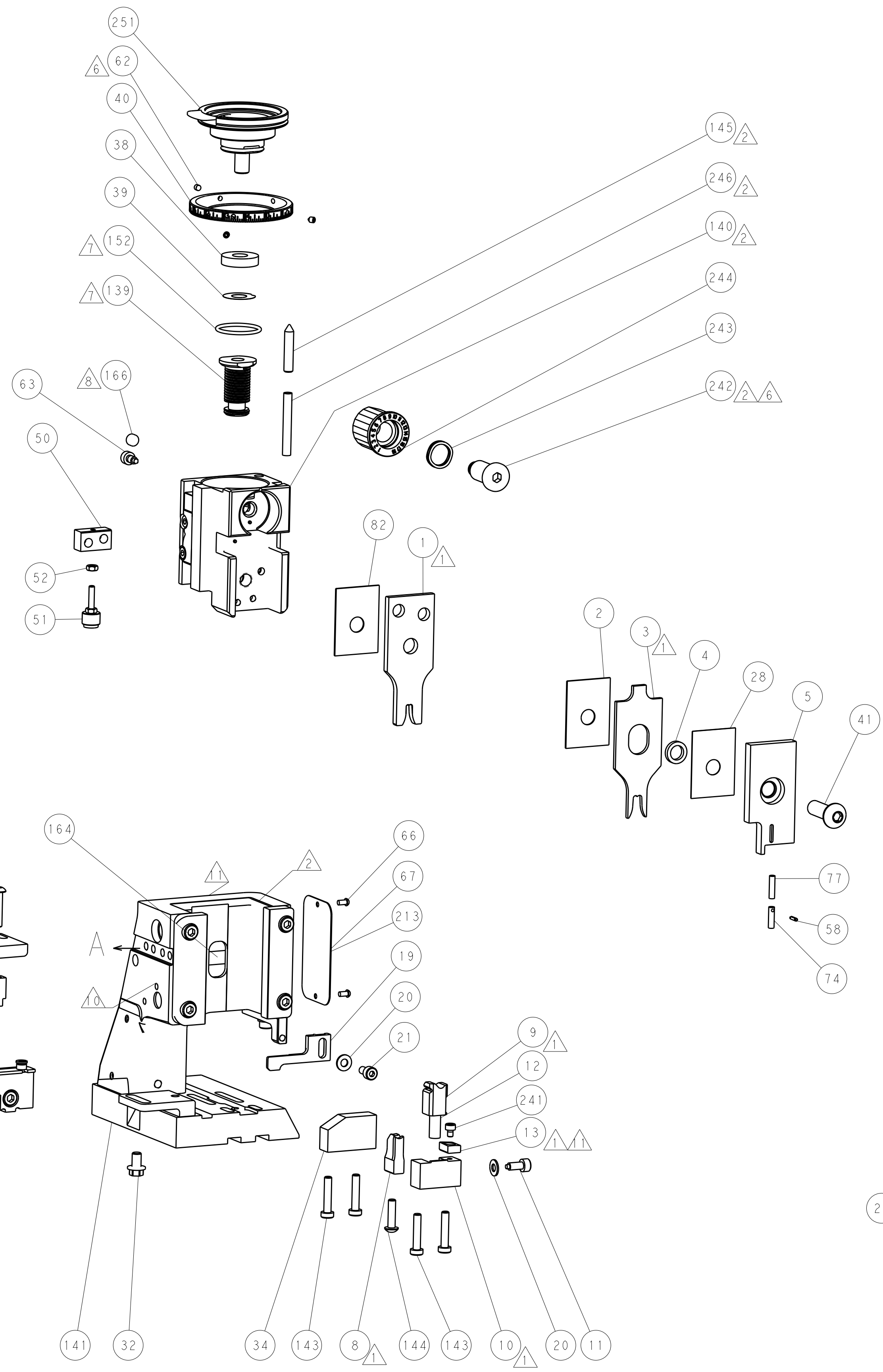
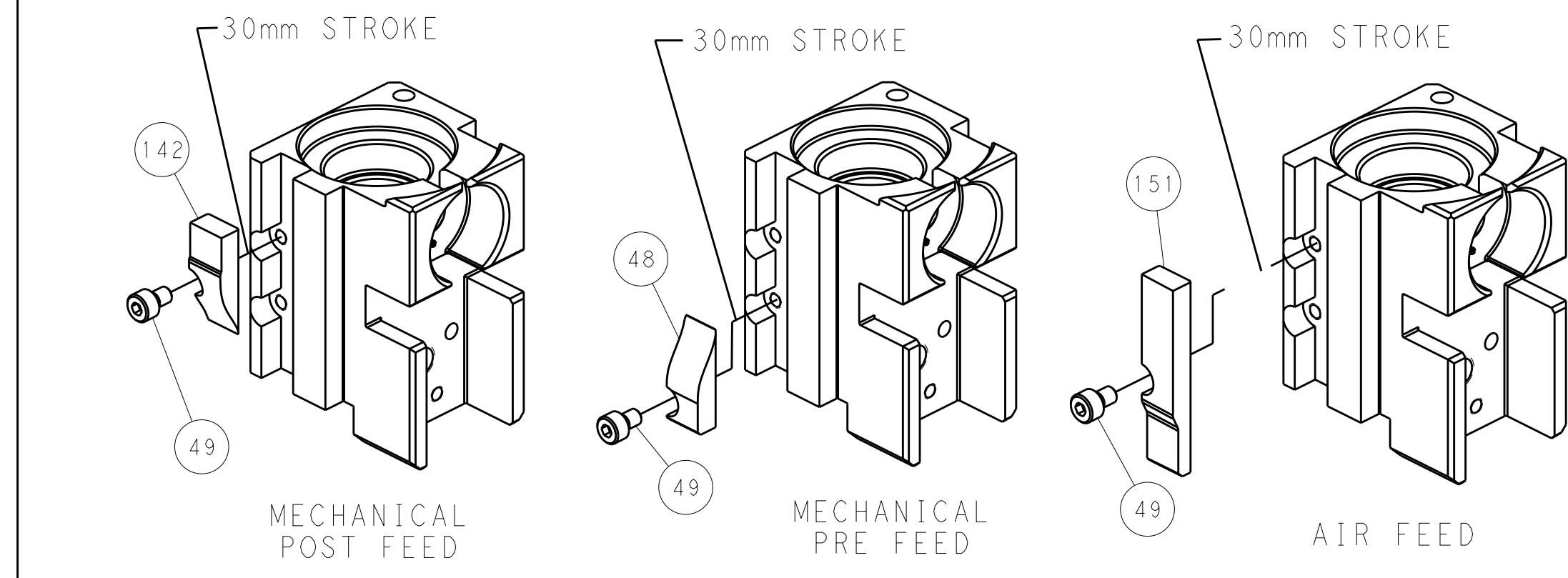
PNEUMATIC



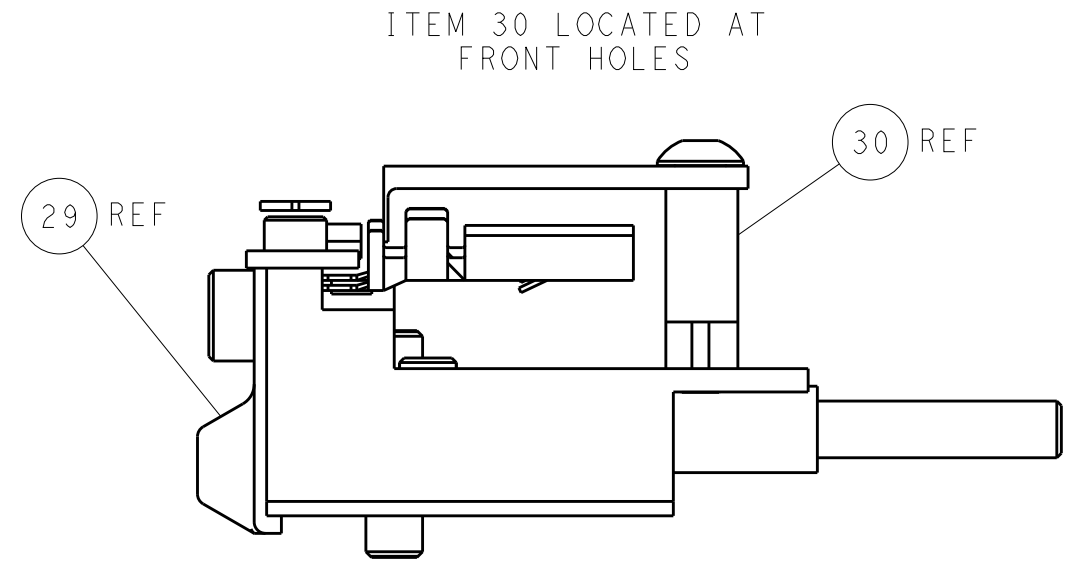
SERVO LATCH PLATE



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)

DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN K. HUANG CHK L. ZHANG APVD J. GUO		18DEC2014 18DEC2014 18DEC2014		NAME Ocean Side Feed Applicator	
0 PLC ±.5 1 PLC ±0.5 2 PLC ±0.13 3 PLC ±0.013 4 PLC ±0.001		FINISH		PRODUCT SPEC		APPLICATION SPEC		SIZE A1	
MATERIAL		WEIGHT		Customer Accessible Production Drawing		SCALE 1:2		SHEET 4 OF 4	
								REV A	