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RELEASED FOR PUBLICATION

20

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ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER

PART NUMBER

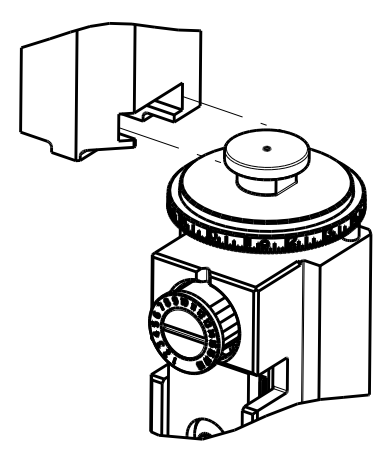
REVISION

DESCRIPTION

FEED TYPE

CONVERT TO

PART NUMBERS REQUIRED



2151864-1

A

FINE CRIMP HEIGHT ADJUST

MECHANICAL

PNEUMATIC FEED

SERVO LATCH PLATE

SMART APPLICATOR

2119950-1

2119951-1

2161326-1

1338685-1

5-18022-5

2119641-1

2119799-1

2063440-1

2168400-6 (QUANTITY 2)

2168400-6 (QUANTITY 2)

2151864-2

A

FINE CRIMP HEIGHT ADJUST

PNEUMATIC

MECHANICAL FEED

SERVO LATCH PLATE

SMART APPLICATOR

2119949-1

2119951-1

2161326-1

1338685-1

5-18022-5

2119653-1

-

2168400-6 (QUANTITY 2)

-

2151864-5

A

FINE CRIMP HEIGHT ADJUST

SERVO LATCH PLATE⁴

MECHANICAL FEED

PNEUMATIC FEED

2119949-1

2119950-1

1338685-1

5-18022-5

2119653-1

2119799-1

2063440-1

-

2151864-6

A

NON-CRIMP HEIGHT ADJUST

SERVO LATCH PLATE⁴

-

-

-

-

-

-

-

2151864-7

A

FINE CRIMP HEIGHT ADJUST

NONE

-

-

-

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-

-

7-2151864-7

A

CRIMP TOOLING KIT

-

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-

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APPLICATOR DATA

CRIMP

SIZE

TYPE

WIRE

2.54 mm [1.00]

F

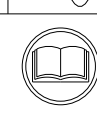
INSUL

3.70 mm [1.46]

O

APPLICATOR INSTRUCTIONS

408-10389



TERMINAL DATA: FURUKAWA TERMINAL FURUKAWA CRIMP SPECIFICATION

TERMINAL NAME: TERMINAL FW-F-B

WIRE STRIP LENGTH

INSULATION DIAMETER RANGE

4.30-4.80 mm [1.69-.189 IN]

Ø2.50-2.90 mm [1.098-.114 IN]

TERMINAL APPLICATION SPECIFICATION

FW-SE-TM00-2

-

-

TERMINALS APPLIED

TE TERMINAL

FURUKAWA TERMINAL

TE SEAL

FURUKAWA SEAL

1572252-1

FW-M-200

1572251-1

FW-W-201

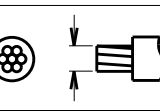
1572252-2

FW-F-B200

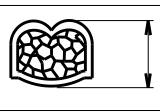
-

-

WIRE SIZE



CRIMP HEIGHT mm [INCH]



CRIMP HEIGHT REFERENCE SETTING

2.00mm2

1.57+/-0.05 [1.062+/-0.002]

8.2

16 AWG OR 1.25mm2

1.37+/-0.05 [1.054+/-0.002]

10.5

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: 8-2151864-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151864-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151864-5
SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2151864-6

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 & 242. FOR -6 ONLY APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 37 & 242.

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 4.23.

13

THIS APPLICATOR APPLIES TERMINAL WITH A SEAL.

14

APPLY TORO-SEAL IN ALLEN SOCKET TO FILL HOLE AFTER FLAT HD HAS BEEN ADJUSTED TO CORRECT HEIGHT AT QUALIFICATION. APPLY #1-23419-5 LOC-TITE TO THREADS.

*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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2119957-2

APPLICATOR SHIM PACK

260

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1

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1

1

1

8-21084-0

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

252

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-

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-

1

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2119640-1

PUSH ROD, AIR FEED

250

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-

-

-

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

28MAR2013

LG

TE

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2119641-1

FEED CAM, AIR FEED

248

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1

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2119798-1

DETENT PIN

247

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1-22279-3

SPRING, COMPRESSION

246

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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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1

2119082-7

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

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2119083-1

RETAINER, INSULATION DIAL

242

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7-18023-7

SCR, SKT HD CAP M3 X 4.0

241

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2

2

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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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1

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2063440-1

AIR FEED MODULE

238

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2119740-2

TAG, IDENTIFICATION

213

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1

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1901094-3

SPACER, FEEDER

198

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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

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1

994969-1

MAGNET, RARE EARTH HIGH ENERGY

166

-

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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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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2119956-1

DOCUMENTATION PACKAGE

71

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2119791-5

DEPRESSOR, WIRE

70

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1

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2119740-1

TAG, IDENTIFICATION

67

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2

2

2

2

2

2168078-1

SCREW, DRIVE, RH, RoHS

66

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1

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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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1

1

1

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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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985575-3

SCR, FLT SKT HD CAP M3 X 10.0

57

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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

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2

1-2168083-0

SCR, SKT HD CAP, RoHS, M4 X 10

53

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5018030-1

NUT, HEX, REG, RoHS, M3

52

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811242-5

BUMPER, HOLD DOWN

51

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1

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690753-2

SPACER, TONKER

50

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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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2119656-9

APPLICATOR BASIC ASSEMBLY, SF

46

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2119370-1

RAM, AMP STYLE, SIDE FEED

44

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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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2119957-1

APPLICATOR SHIM PACK

39

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2119644-2

RAM WASHER, PRECISION

38

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2119085-1

FA HEAD, ATLANTIC STYLE

37

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2119092-1

BOLT, ADJUSTMENT

35

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1752356-1

SUPPORT, TERMINAL

34

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2

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2

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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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1320908-7

SPACER, STRIP GUIDE

30

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2119959-1

ASSEMBLY, STRIP GUIDE

29

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455888-3

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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1-18028-2

WASHER, FLAT, REG M4

20

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2119533-1

STRIPPER, SIDE FEED

19

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2119806-1

INSERT, SHEAR

13

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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

2119805-1

SHEAR HOLDER, FRONT

10

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1

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318707-1

FLOATING SHEAR, FRONT

9

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3-1633927-2

ANVIL, COMBINATION

8

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2119781-5

DEPRESSOR, SHEAR

5

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2-238011-1

BLOCK, CRIMPER SPACER

4

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2-1633965-5

CRIMPER, INSULATION O PREMIUM

3

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455888-4

SPACER, CRIMPER

2

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456407-3

CRIMPER, WIRE PREMIUM

1

-77

-7

-6

-5

-2

-1

PART NO

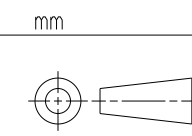
DESCRIPTION

ITEM NO

THIS IS SUBJECT TO CHANGE WITHOUT NOTICE. THE USER OF THIS DRAWING SHOULD BE CONTACTED FOR THE LATEST REVISION.

DIMENSIONS:

mm



0 PLC

1 PLC

2 PLC

3 PLC

4 PLC

ANGLES

FINISH

±

±0.1

±0.02

±0.005

±0.0005

±

MATERIAL

-

-

-

OWN

29JAN2013

CHK

L. ZHANG

29JAN2013

APVD

S. XI

29JAN2013

NAME

Ocean Side Feed Applicator

SIZE

CAGE CODE

DRAWING NO

RESTRICTED TO

00779

©=2151864

-

Customer Accessible Production Drawing

SCALE

1:1

SHEET

1

OF

4

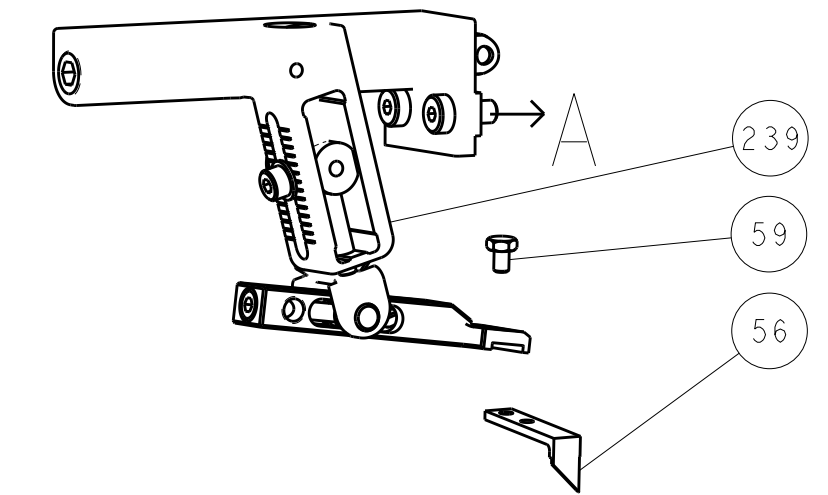
REV

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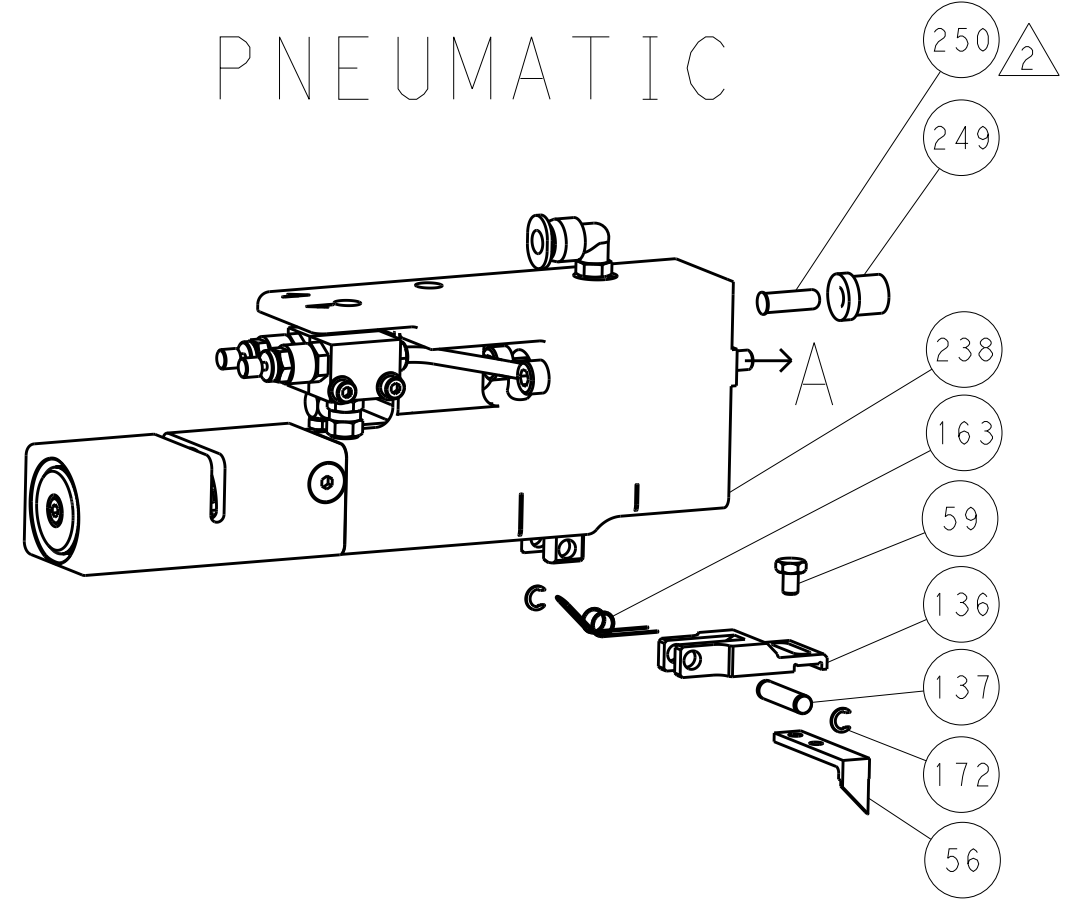
SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

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

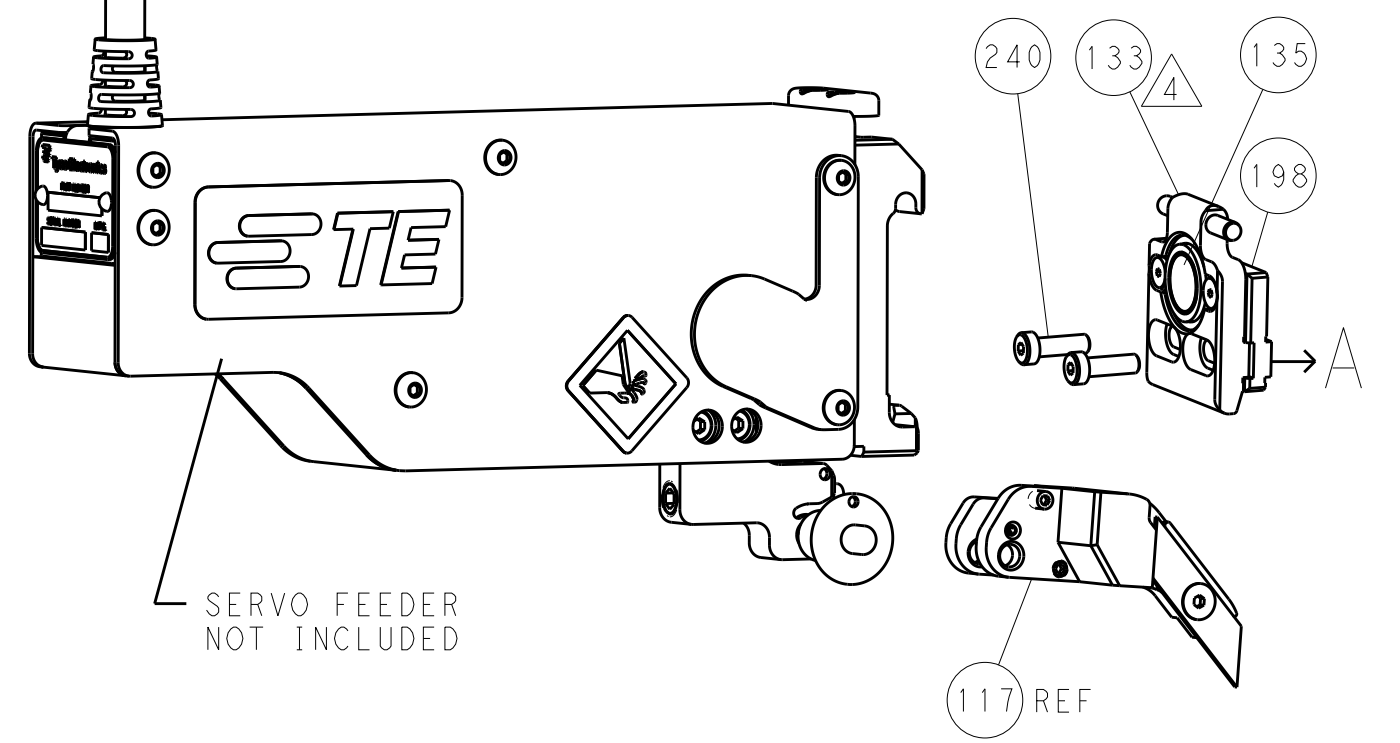
FEED TYPE MECHANICAL



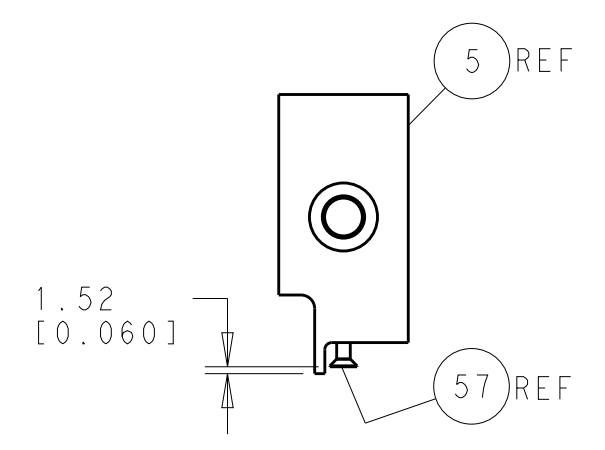
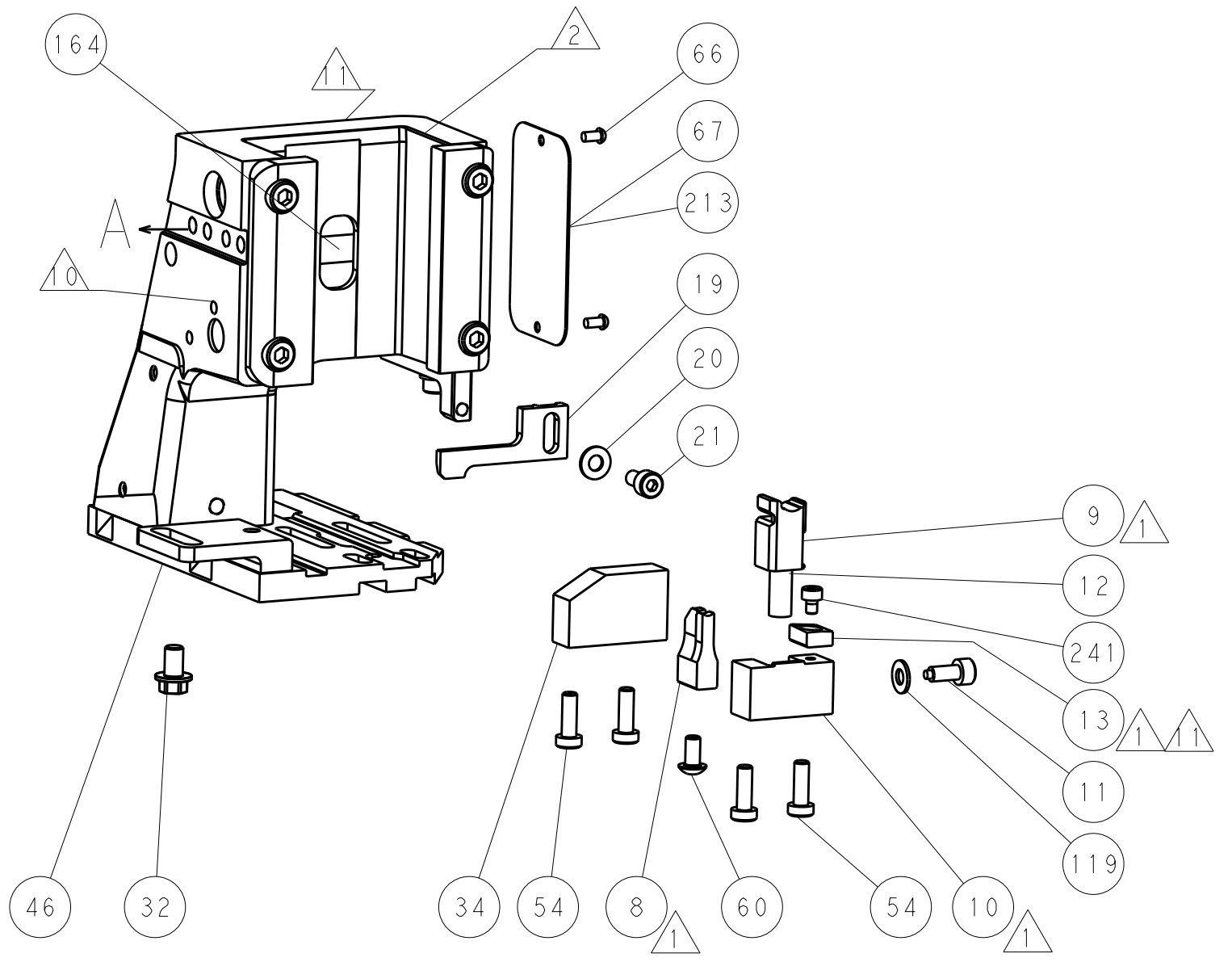
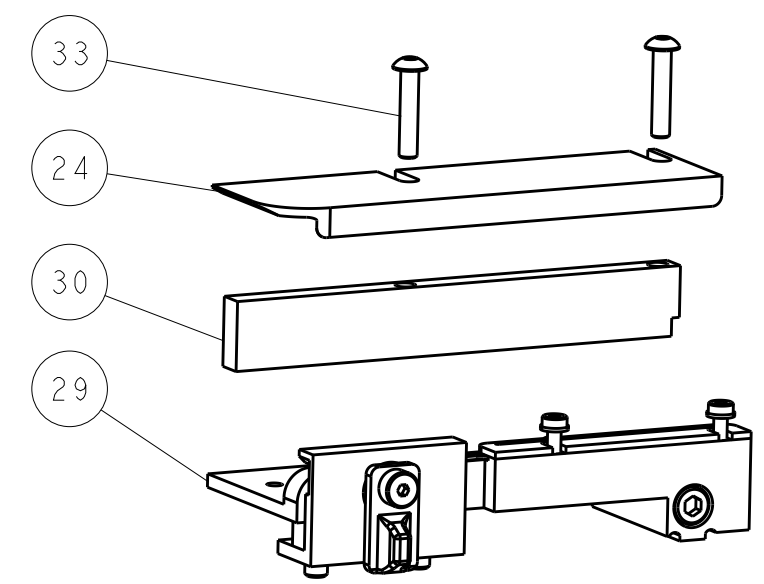
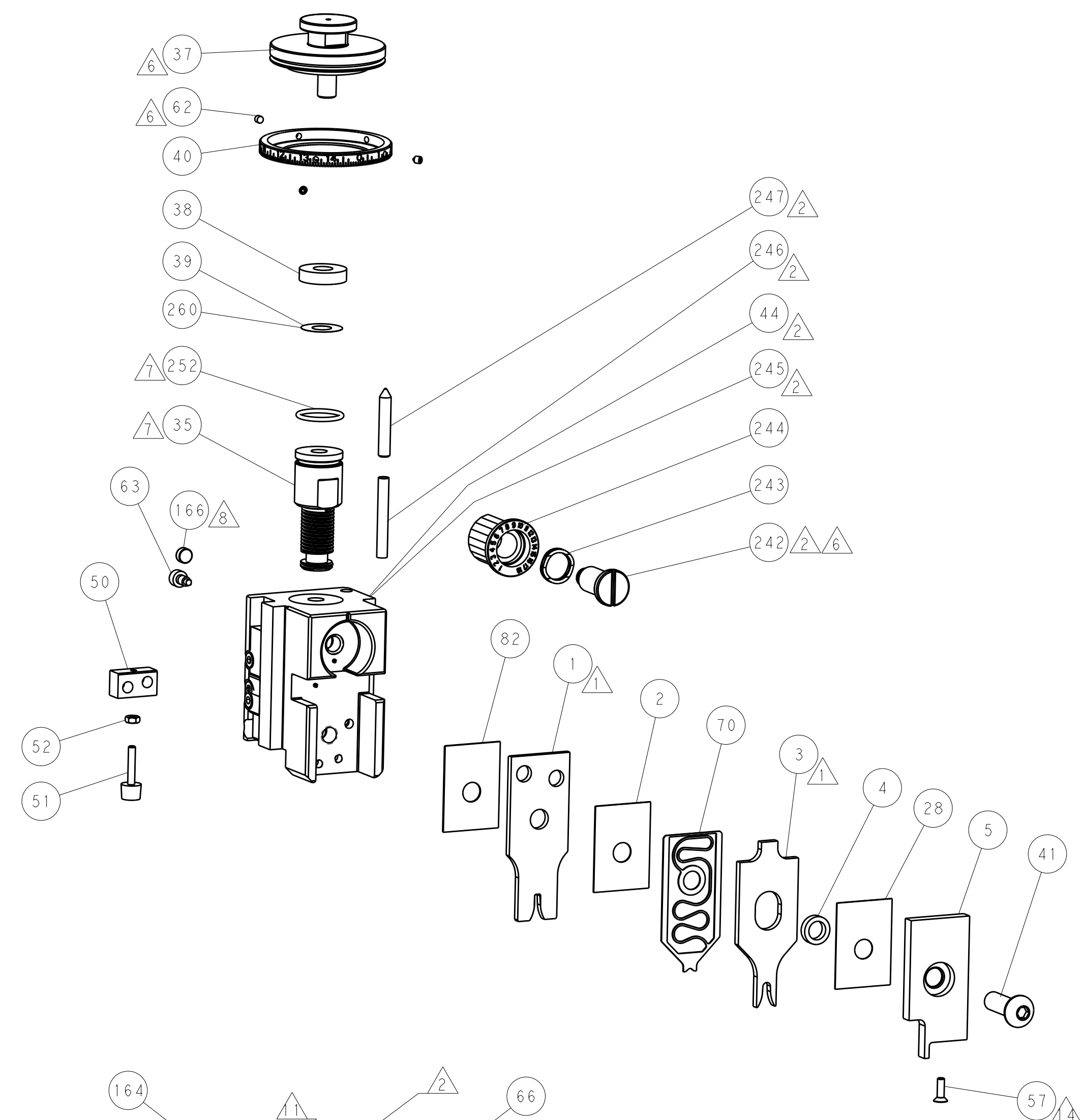
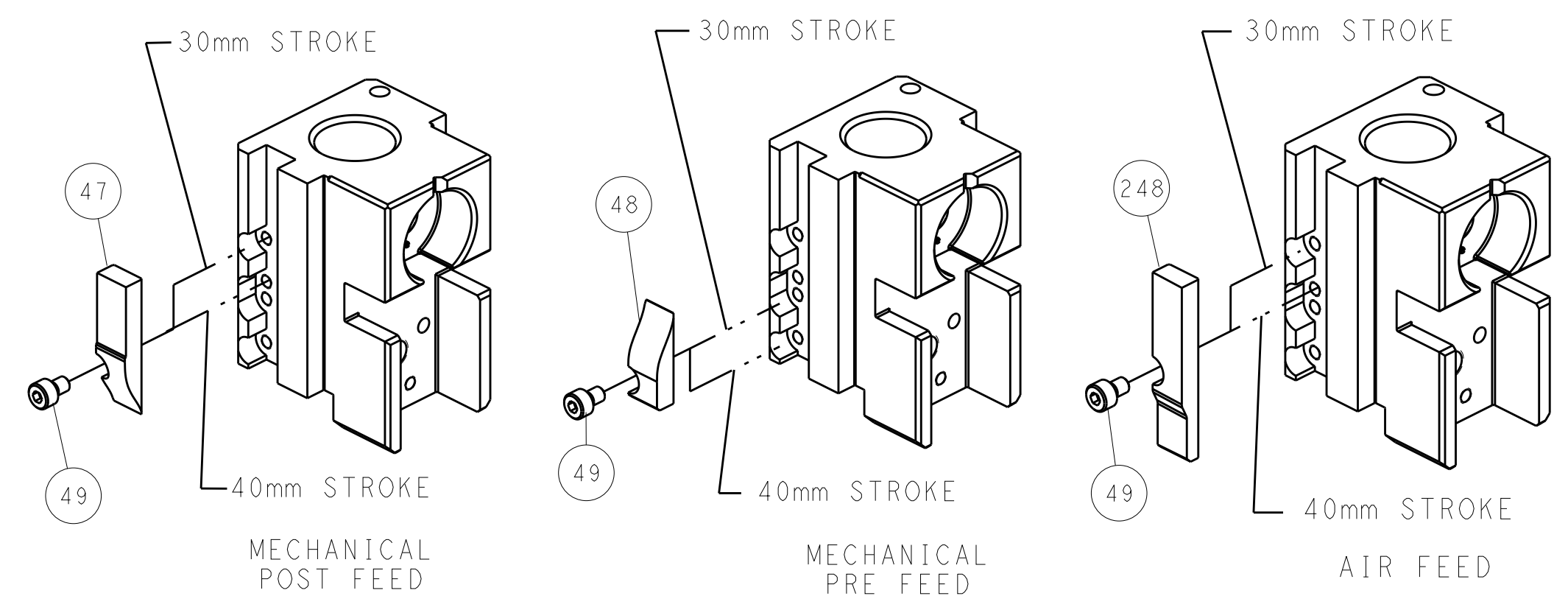
PNEUMATIC



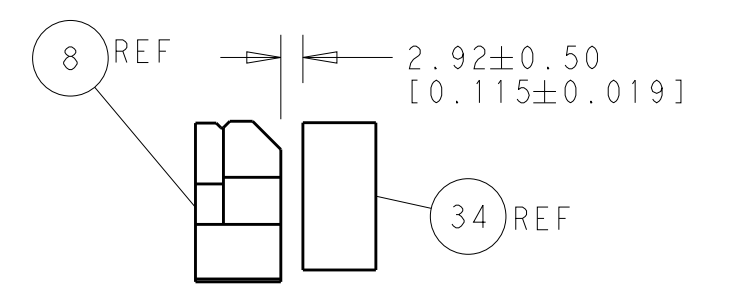
SERVO LATCH PLATE



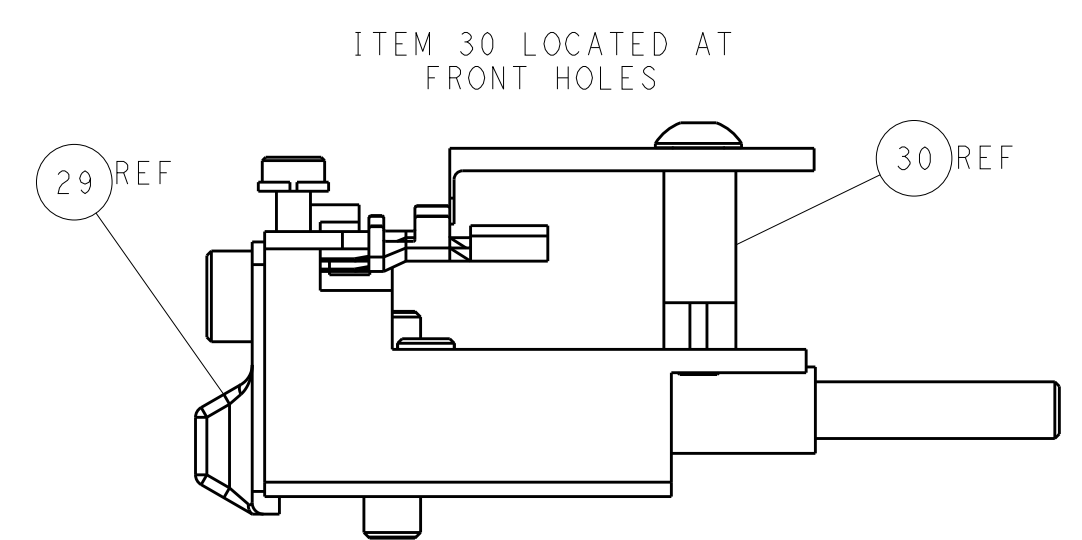
CAM POSITIONS



SHEAR DEPRESSOR DETAIL



TERMINAL SUPPORT LOCATION



FEED TRACK POSITION
GUIDE BY WIRE 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:		CHK	29JAN2013	Harrisburg, PA 17105-3608	
mm		APVD	29JAN2013	NAME	
TOLERANCES UNLESS OTHERWISE SPECIFIED:		PRODUCT SPEC		Ocean Side Feed Applicator	
0 PLC ±.1		APPLICATION SPEC		SIZE	
1 PLC ±0.1				CAGE CODE	
2 PLC ±0.02				DRAWING NO	
3 PLC ±0.005				RESTRICTED TO	
4 PLC ±0.0005				A1 00779 ©=2151864	
ANGLES		WEIGHT		Customer Accessible Production Drawing	
FINISH		SCALE	1:1	SHEET 2 of 4	
MATERIAL		REV	A	SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION	

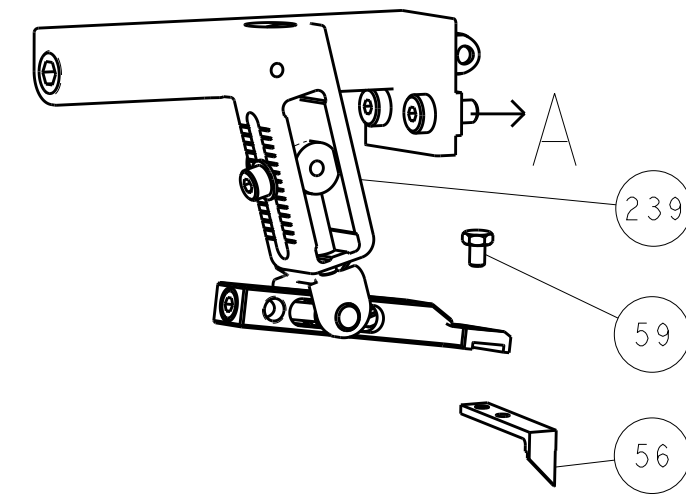
DIMENSIONING AND TOLERANCING PER ASME Y14.5M-2003

C

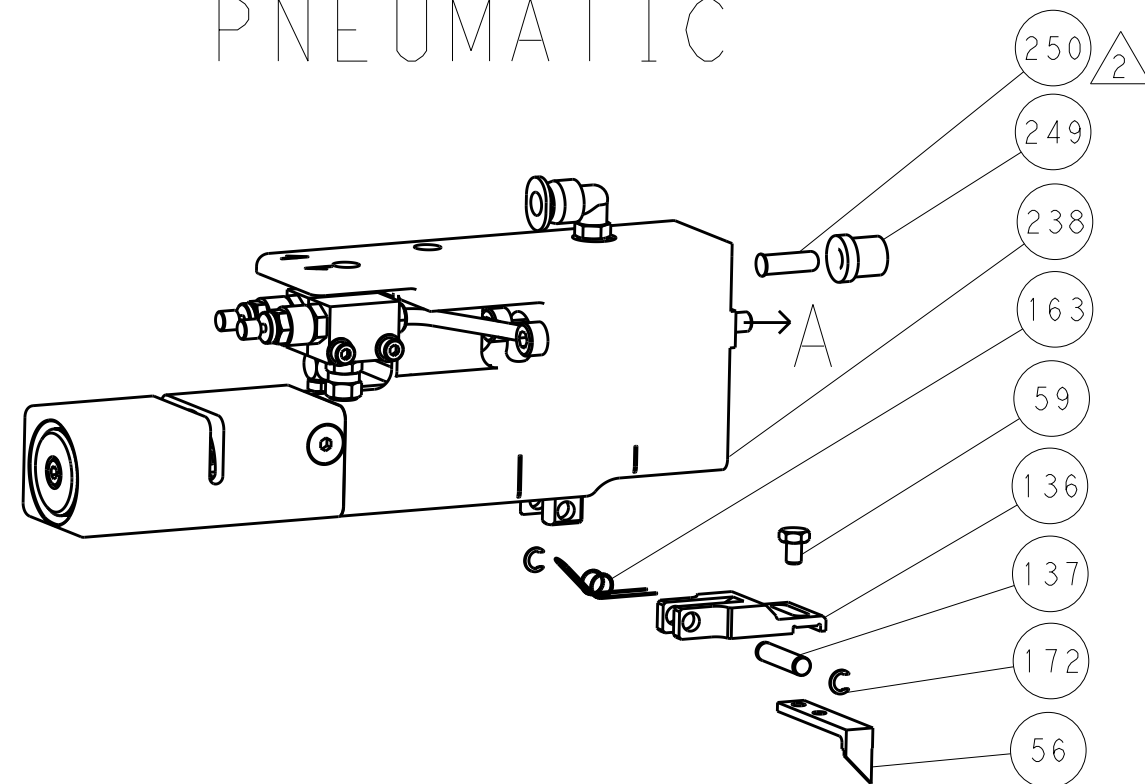
B

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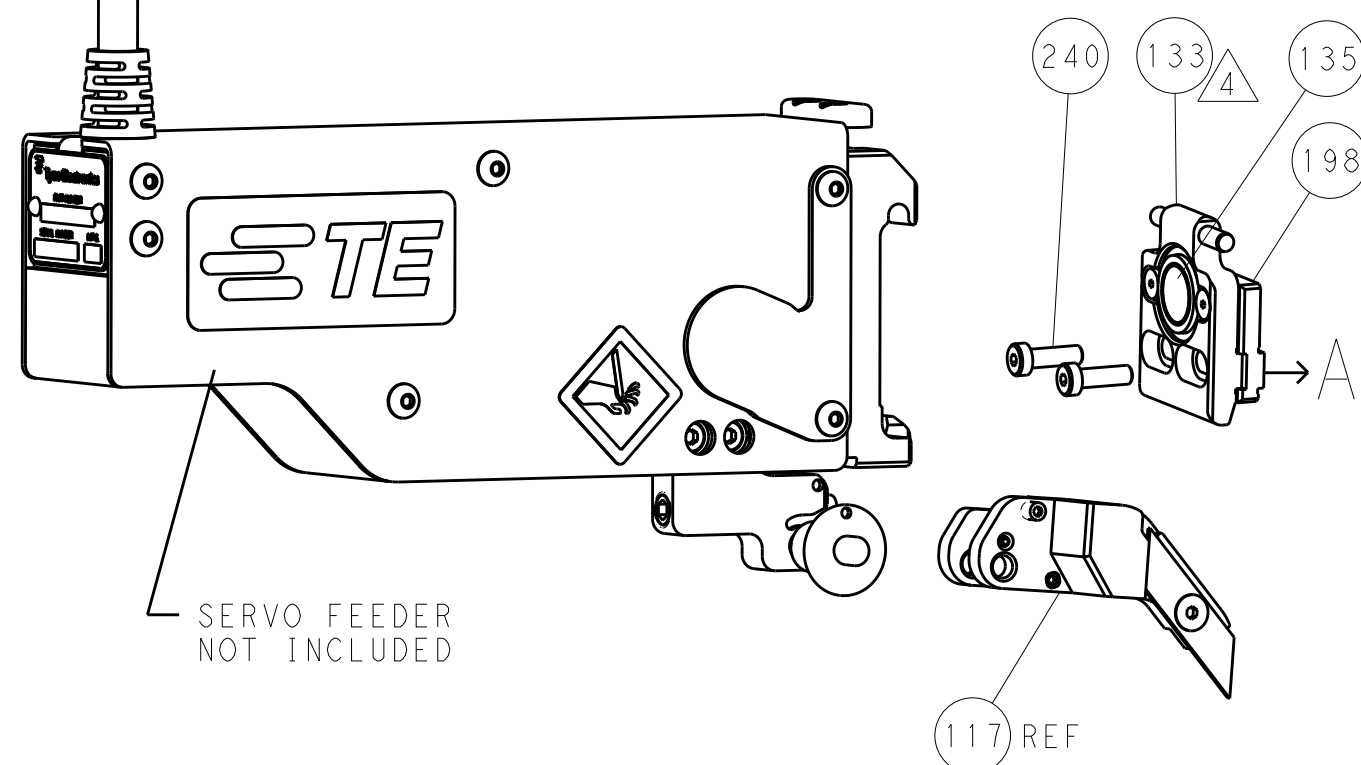
FEED TYPE MECHANICAL



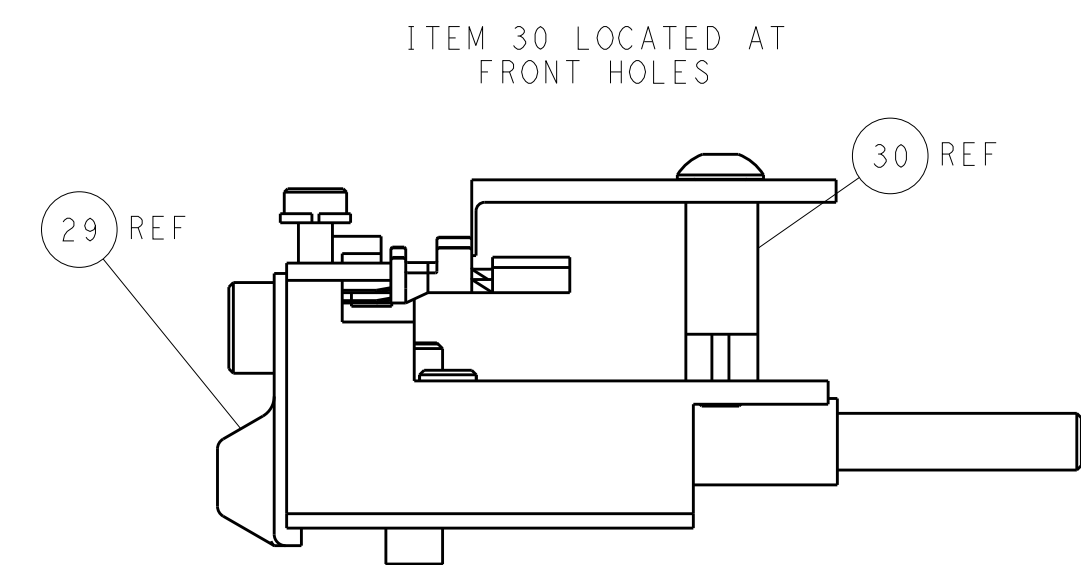
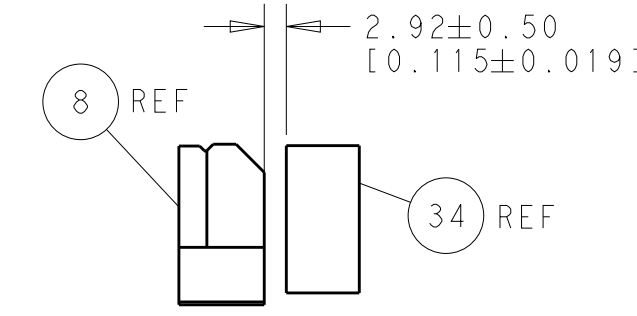
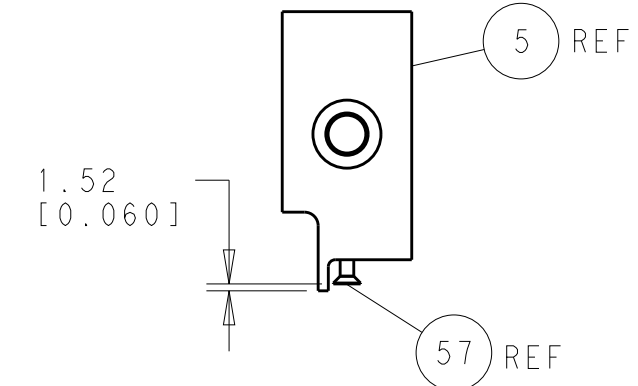
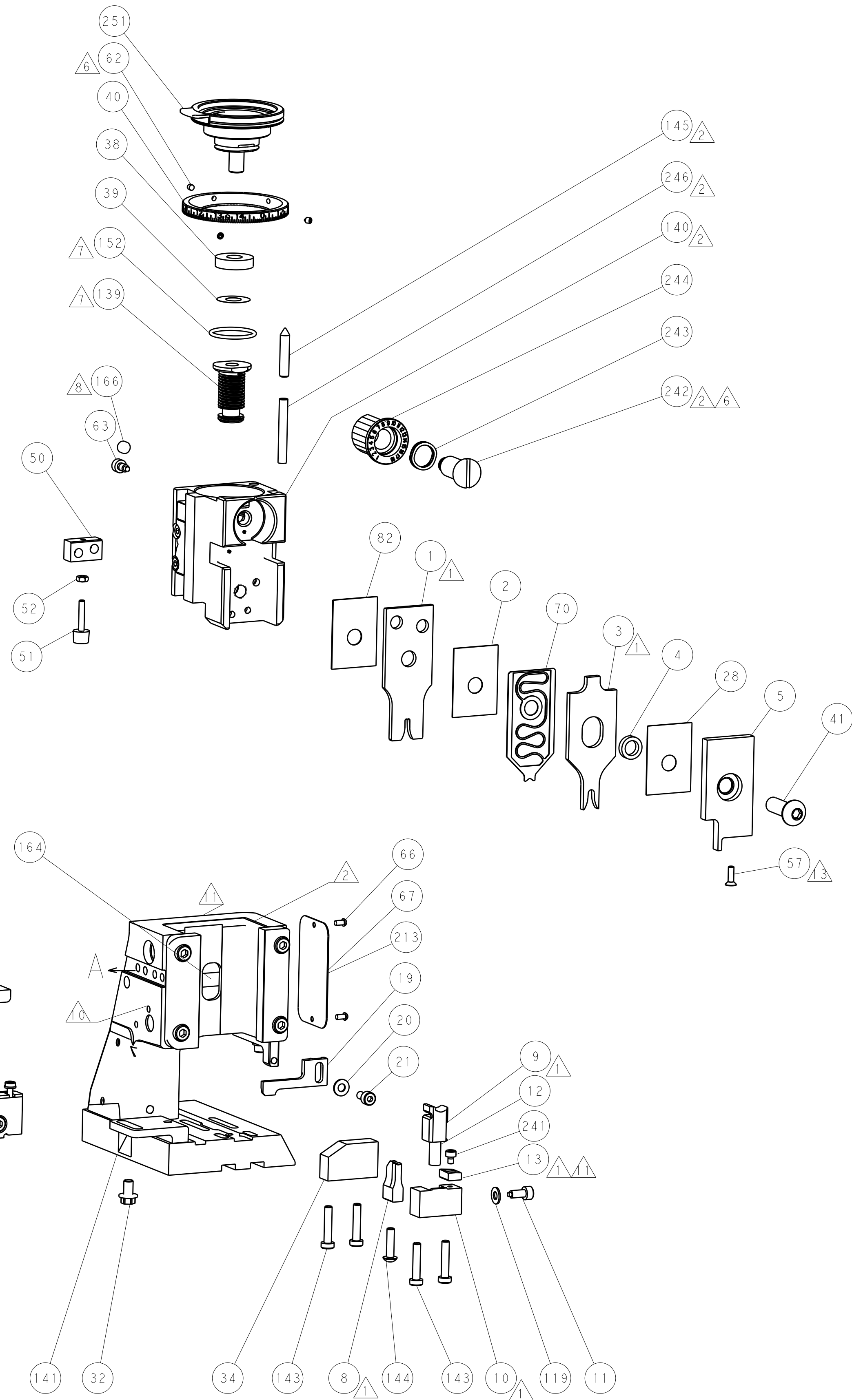
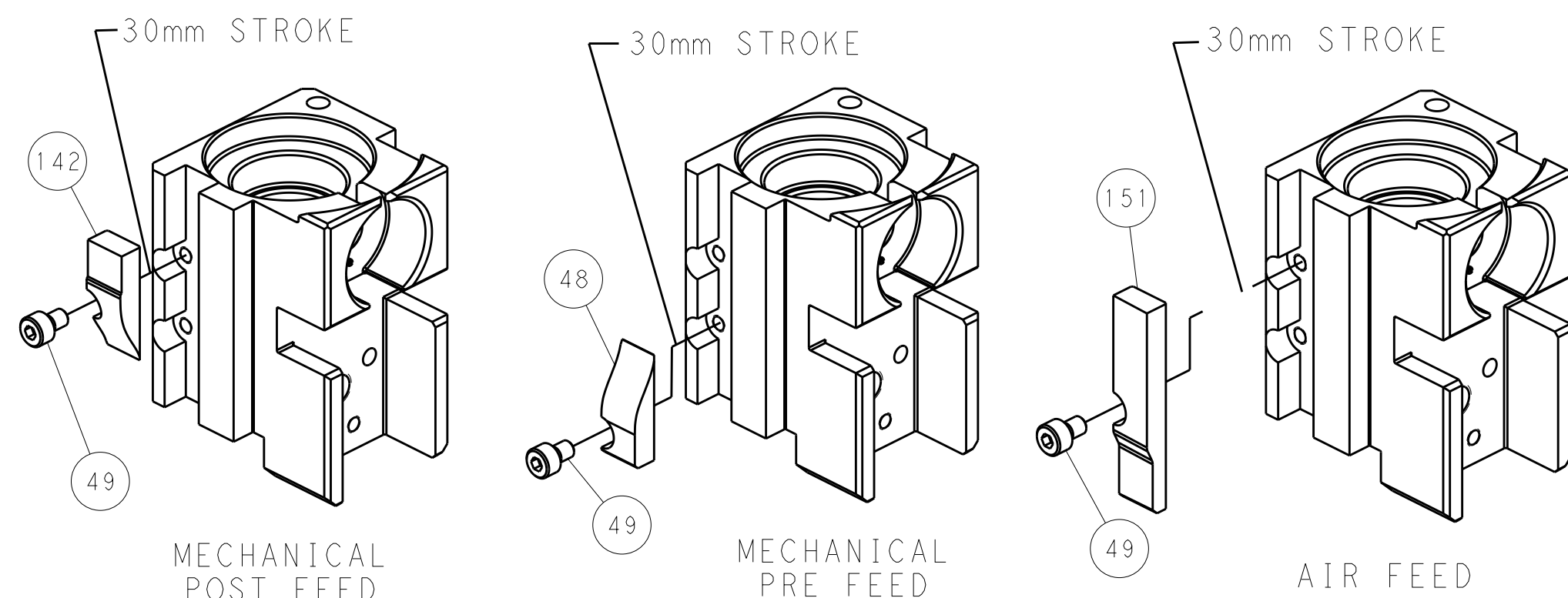
PNEUMATIC



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)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN		REV		DATE		DESCRIPTION		DATE		DWN		APVD	
mm		0 PLC ±0.1		L. ZHANG		S. X1		29JAN2013		SEE SHEET 1		-		-		-	
1 PLC ±0.02		2 PLC ±0.02		3 PLC ±0.005		4 PLC ±0.0005		ANGLES FINISH		PRODUCT SPEC		APPLICATION SPEC		SIZE		CAGE CODE	
MATERIAL		-		-		-		-		WEIGHT		-		A1		00779	
Customer Accessible Production Drawing		SCALE		1:1		SHEET		4		OF		4		REV		A	