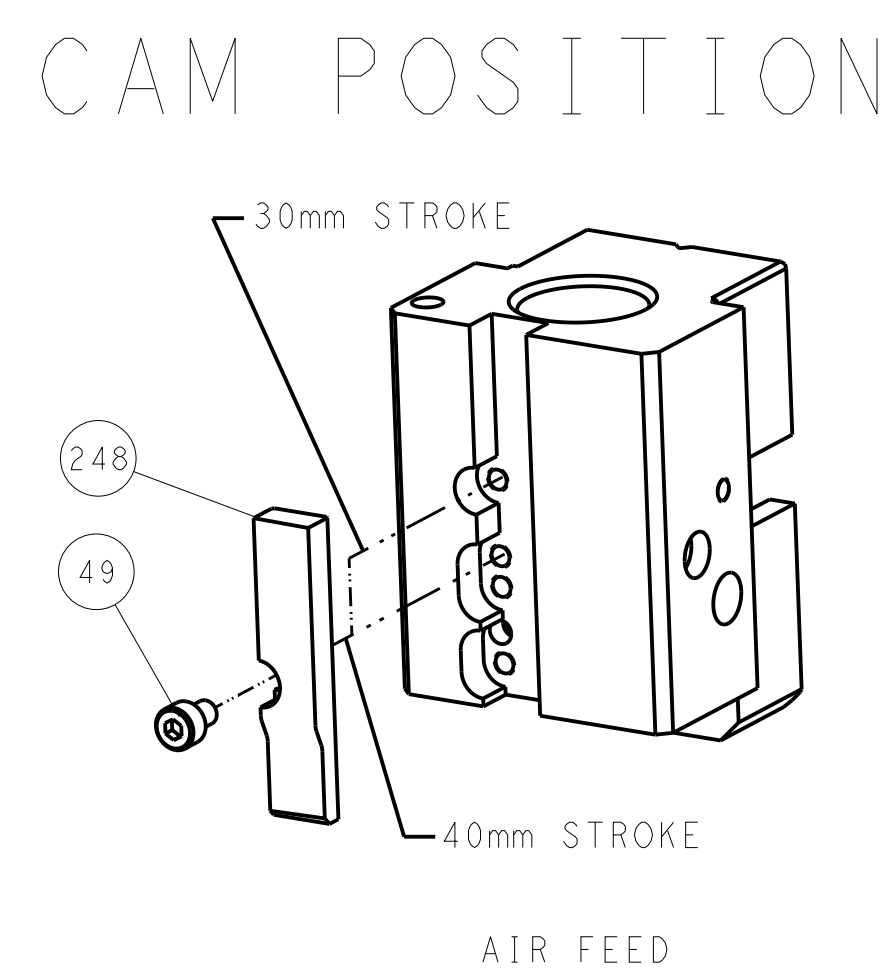
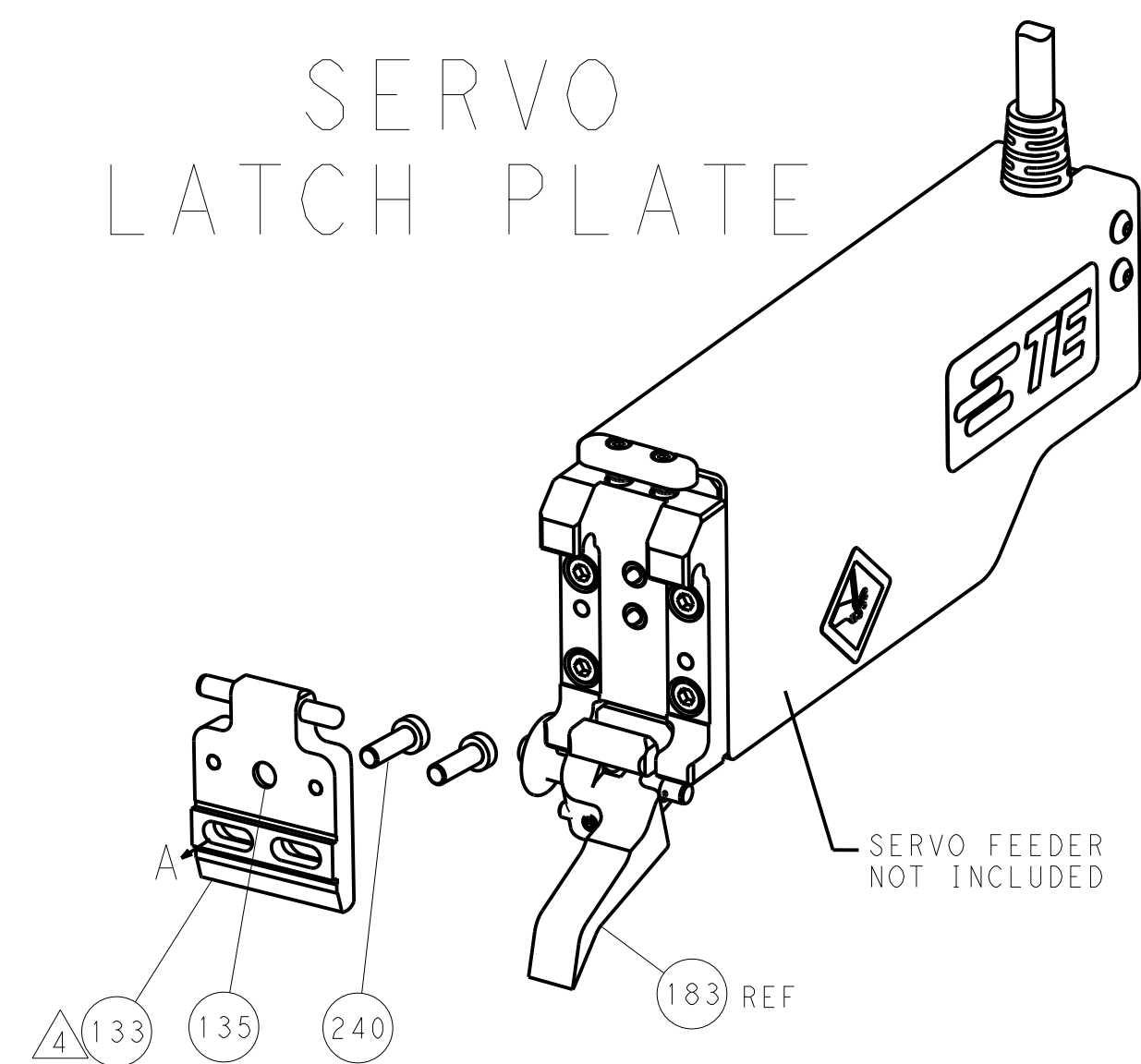
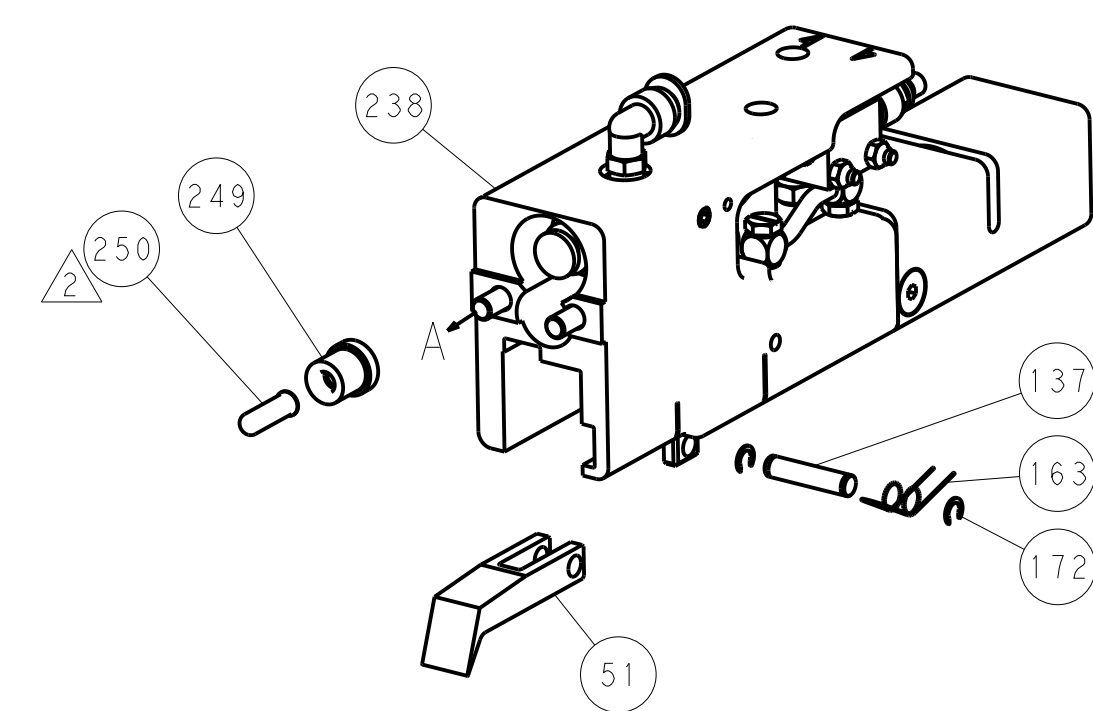
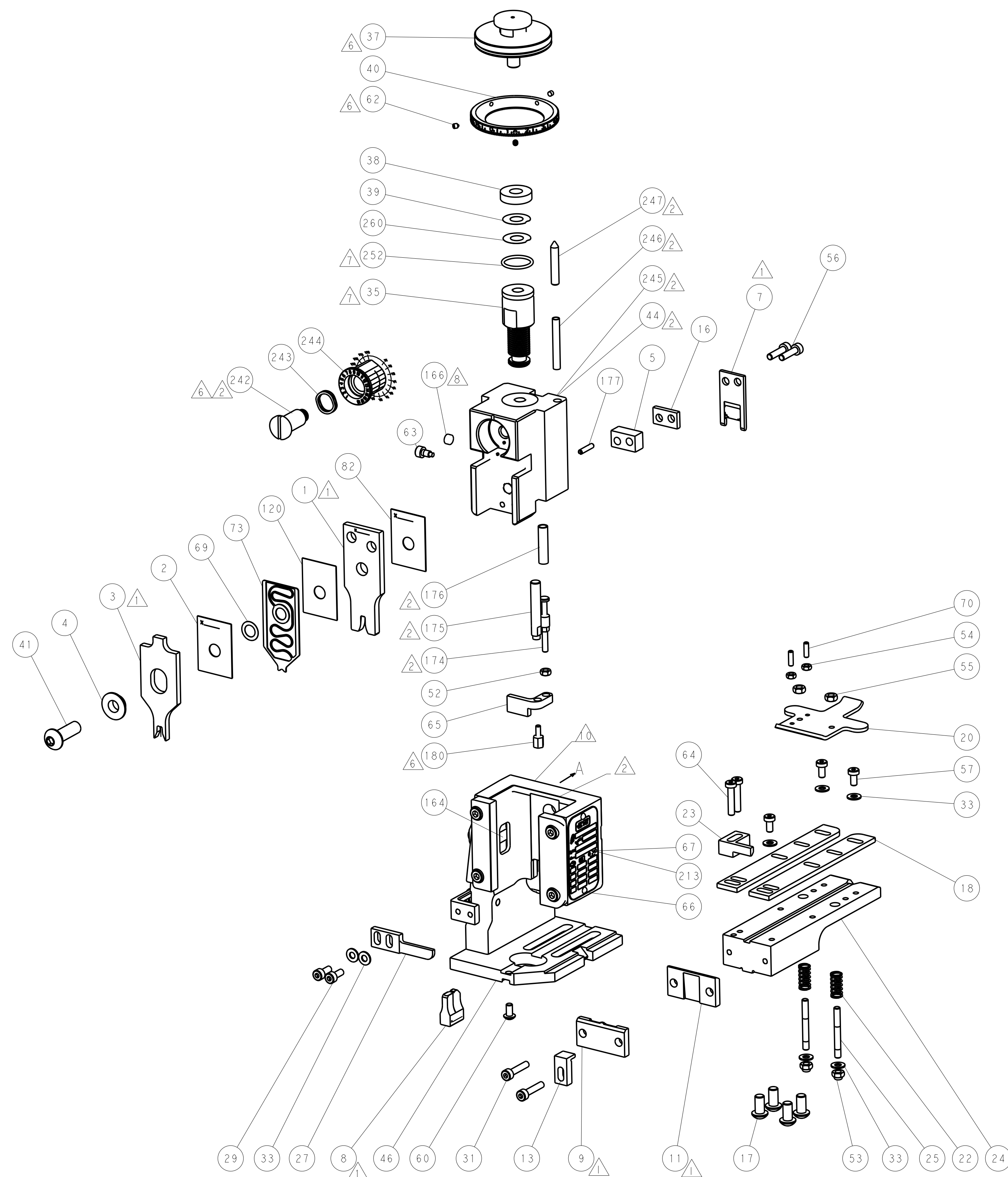
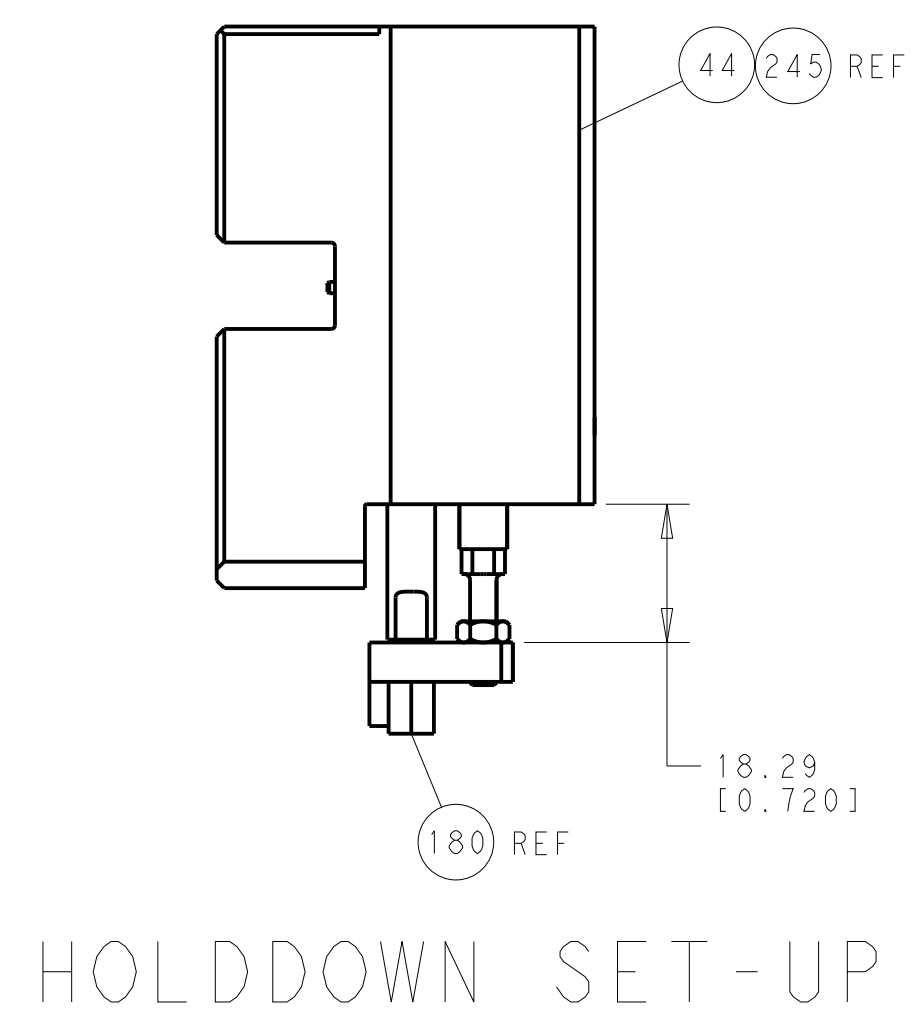
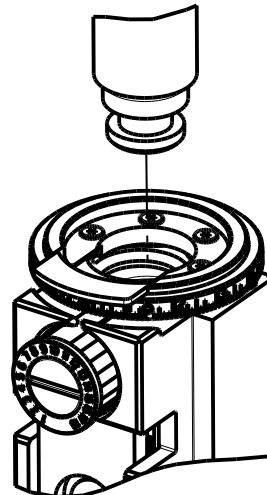




ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

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DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.01 1 PLC ±0.5 2 PLC ±0.13 3 PLC ±0.013 4 PLC ±0.0001 ANGLES °		NAME Ocean End Feed Applicator -	
MATERIAL FINISH - -		WEIGHT -		SIZE A1 00779	
				CAGE CODE C-2150399	
				DRAWING NO -	
				RESTRICTED TO -	
Customer Accessible Production Drawing				SCALE 1:1 SHEET 2 OF 4 REV A	

8		7	
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PACIFIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION
	2-2150399-2	A	FINE CRIMP HEIGHT ADJUST
	2-2150399-5	A	FINE CRIMP HEIGHT ADJUST
	2-2150399-7	A	FINE CRIMP HEIGHT ADJUST
	7-2150399-7	A	CRIMP TOOLING KIT

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	3.18 mm [.125]	F
INSUL	4.06 mm [.160]	F
APPLICATOR INSTRUCTIONS 408-10390		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: PRONER CLIP 8 mm (GAMME 1)			
WIRE STRIP LENGTH 6.00-6.80 mm [.236-.268 IN]		INSULATION DIAMETER RANGE Ø2.15-3.80 mm [.085-.150 IN]	
TERMINAL APPLICATION SPECIFICATION		PRONER C10657/C1544455	
TERMINALS APPLIED			
TE TERMINAL 1544455-1	TE TERMINAL	TE TERMINAL	TE TERMINAL

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING ⁹
3.00mm2		2.35+/-0.05 [.093+/- .002]		4.5
1.00mm2		1.85+/-0.05 [.073+/- .002]		9.0



- 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:
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150399-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150399-5
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 ITEMS 62, 180 & 242.
- ⁷ GREASE THREADS, GROOVE AND O-RING ON ITEMS 139 & 153.
- 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 TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- 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.

*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	2119782-1	FINE ADJUST HEAD ASM, PACIFIC STYLE	251
-	-	-	1	2119640-1	PUSH ROD, AIR FEED	250
-	-	-	1	2079988-1	BUSHING, LCH5-12, MISUMI	249
-	1	1	1	1-22279-3	SPRING, COMPRESSION	246
-	1	1	1	2119082-7	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-77-27-25-22				PART NO	DESCRIPTION	ITEM NO

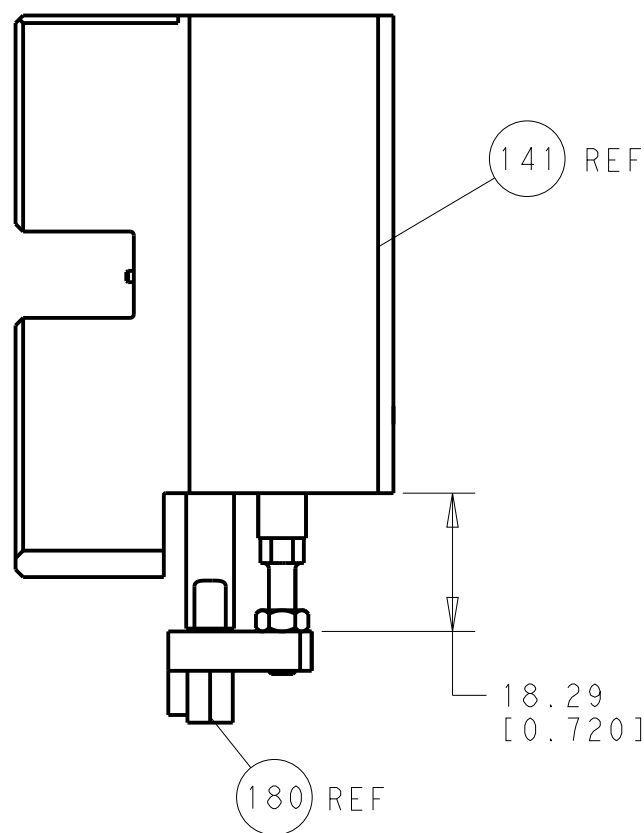
PACIFIC VERSION
Shown on sheets 3 of 4 & 4 of 4
(Atlantic version shown on sheets 1 of 4 & 2 of 4)

SET UP GAUGE 2119599-2		LOC A	DIST 66	REVISIONS			
				P	LTR	DESCRIPTION	DATE
					-	SEE SHEET 1	-
⁶	-	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
	-	-	2	-	2168400-7	SHCS, LOW HEAD, RoHS, M5 X 10	240
⁶	-	-	-	1	2063440-2	AIR FEED MODULE	238
	-	-	1	-	2119740-2	TAG, IDENTIFICATION	213
⁶	-	4	4	4	2079383-9	SCR, BHSC, RoHS (M6 X 20)	186
	-	-	REF	-	1901697-1	FEED FINGER ASSEMBLY, EF	183
⁶	-	1	1	1	1-1752354-2	STANDOFF, HOLD-DOWN	180
	-	1	1	1	6-993111-6	PIN, SLOTTED SPRING 3.0 X 14.0	177
⁶	-	1	1	1	8-22280-7	SPRING, COMPRESSION	176
	-	1	1	1	1752353-2	GUIDE PIN, HOLDDOWN	175
⁶	-	1	1	1	1901680-2	GUIDE PIN, HOLDDOWN	174
	-	-	-	2	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172
⁶	-	1	1	1	994969-1	MAGNET, RARE EARTH HIGH ENERGY	166
	-	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
⁶	-	-	-	1	240638-1	SPRING, FEED FINGER	163
	-	1	1	1	8-21084-1	O-RING, .801 ID, .070 DIA. MAT.	153
⁶	-	-	-	1	2119641-2	FEED CAM, AIR FEED	152
	-	1	1	1	2119798-2	DETENT PIN	145
⁶	-	1	1	1	2079383-8	SCR, BHSC, RoHS (M4 X 16)	144
	-	1	1	1	2119655-6	APPLICATOR BASIC ASSEMBLY, EF	141
⁶	-	1	1	1	2119651-1	RAM, ASIAN STYLE, END FEED	140
	-	1	1	1	2119092-2	BOLT, ADJUSTMENT	139
⁶	-	-	-	1	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854	137
	-	-	REF	-	SEE NOTE 4	MEMORY CHIP, PROGRAMMED	135
⁶	-	-	1	-	1633743-1	SERVO FEED LATCH ASM	133
	-	1	1	1	455888-3	SPACER, CRIMPER	120
⁶	-	1	1	1	455888-4	SPACER, CRIMPER	82
	-	1	1	1	2119791-5	DEPRESSOR, WIRE	73
⁶	-	1	1	1	2119956-2	DOCUMENTATION PACKAGE	71
	-	2	2	2	2-18032-2	SCR, SET, FLT POINT M3 X 10.0	70
⁶	-	1	1	1	2119943-1	WASHER, SPACER	69
	-	1	-	1	2119740-1	TAG, IDENTIFICATION	67
⁶	-	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
	-	1	1	1	1901681-1	HOLDDOWN, TERMINAL	65
⁶	-	2	2	2	2168400-5	SHCS, LOW HEAD, RoHS, M4 X 20	64
	-	1	1	1	2119793-1	LIMITER, ADJUSTMENT BOLT	63
⁶	-	3	3	3	992763-5	SCR, SET, SOC, CONE POINT, M3 x 4.0	62
	-	-	-	-	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
⁶	-	3	3	3	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57
	-	2	2	2	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	56
⁶	-	2	2	2	5018030-2	NUT, HEX, REG, RoHS, M4	55
	-	2	2	2	5018030-1	NUT, HEX, REG, RoHS, M3	54
⁶	-	2	2	2	986965-8	NUT, LOCK, HEX, TORQUE (M4)	53
	-	1	1	1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52
⁶	-	-	-	1	2119792-2	PAWL, EF, AIR	51
	-	-	-	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49
⁶	-	1	1	1	2079383-7	SCR, BHSC, RoHS (M8 X 25)	41
	-	1	1	1	2119645-1	DISC, NUMBERED FA WIRE ADJUSTMENT	40
⁶	-	1	1	1	2119957-1	APPLICATOR SHIM PACK	39
	-	1	1	1	2119644-2	RAM WASHER, PRECISION	38
⁶	-	7	7	7	1-18028-2	WASHER, FLAT, REG M4	33
	-	2	2	2	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	31
⁶	-	2	2	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	29
	-	1	1	1	240639-1	STRIPPER (MACHINING)	27
⁶	-	2	2	2	1320906-1	STUD, THREADED	25
	-	1	1	1	2-1752371-2	PLATE, STRIP GUIDE	24
⁶	-	1	1	1	240825-3	PLATE, STRIP HOLD DOWN	23
	-	2	2	2	2-22281-3	SPRING, COMPRESSION	22
⁶	-	1	1	1	1752373-1	DRAG	20
	-	2	2	2	1901259-6	GUIDE, LOWER STRIP	18
⁶	-	1	1	1	240641-5	SPACER	16
	-	1	1	1	1752360-1	SPACER, HOLD-DOWN	13
⁶	-	1	1	1	240833-4	PLATE, REAR SHEAR	11
	-	-	-	-	-	-	10
⁶	-	1	1	1	2-690495-2	PLATE, FRONT SHEAR	9
	1	1	1	1	1333226-9	ANVIL EF SPECIAL	8
⁶	-	1	1	1	1-2217206-0	BLADE, SLUG	7
	-	-	-	-	-	-	6
⁶	-	1	1	1	4-240641-7	SPACER	5
	-	1	1	1	3-238009-3	BLOCK, FL CRIMPER SPACER	4
⁶	1	1	1	1	5-1633962-3	CRIMPER, INSULATION F PREMIUM	3
	-	1	1	1	455888-4	SPACER, CRIMPER	2
⁶	1	1	1	1	5-1633305-0	CRIMPER, WIRE PREMIUM	1
	-77-27-25-22				PART NO	DESCRIPTION	ITEM NO

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DIMENSIONS: mm		APVD H. GUO	26NOV2013	NAME Ocean End Feed Applicator	
TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.5 1 PLC ±.13 3 PLC ±.013 4 PLC ±.0001 ANGLES ±.1		PRODUCT SPEC -		SIZE A	
MATERIAL -		APPLICATION SPEC -		CAGE CODE 00779	
FINISH -		WEIGHT -		DRAWING NO C=2150399	
Customer Accessible Production Drawing		SCALE 1:1		SHEET 3 OF 4	
REV A		REV A		REV A	

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

HOLDDOWN SET-UP

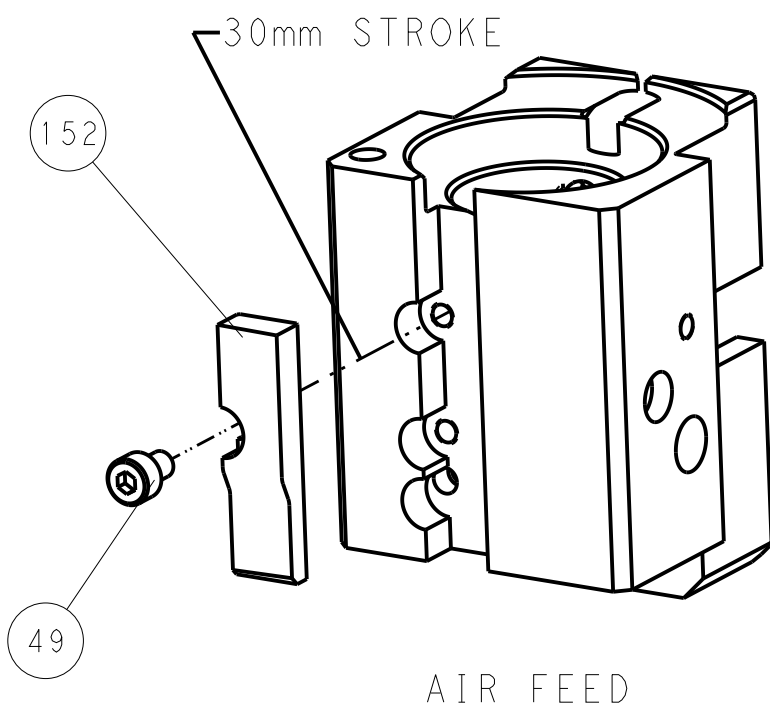


FEED TYPE

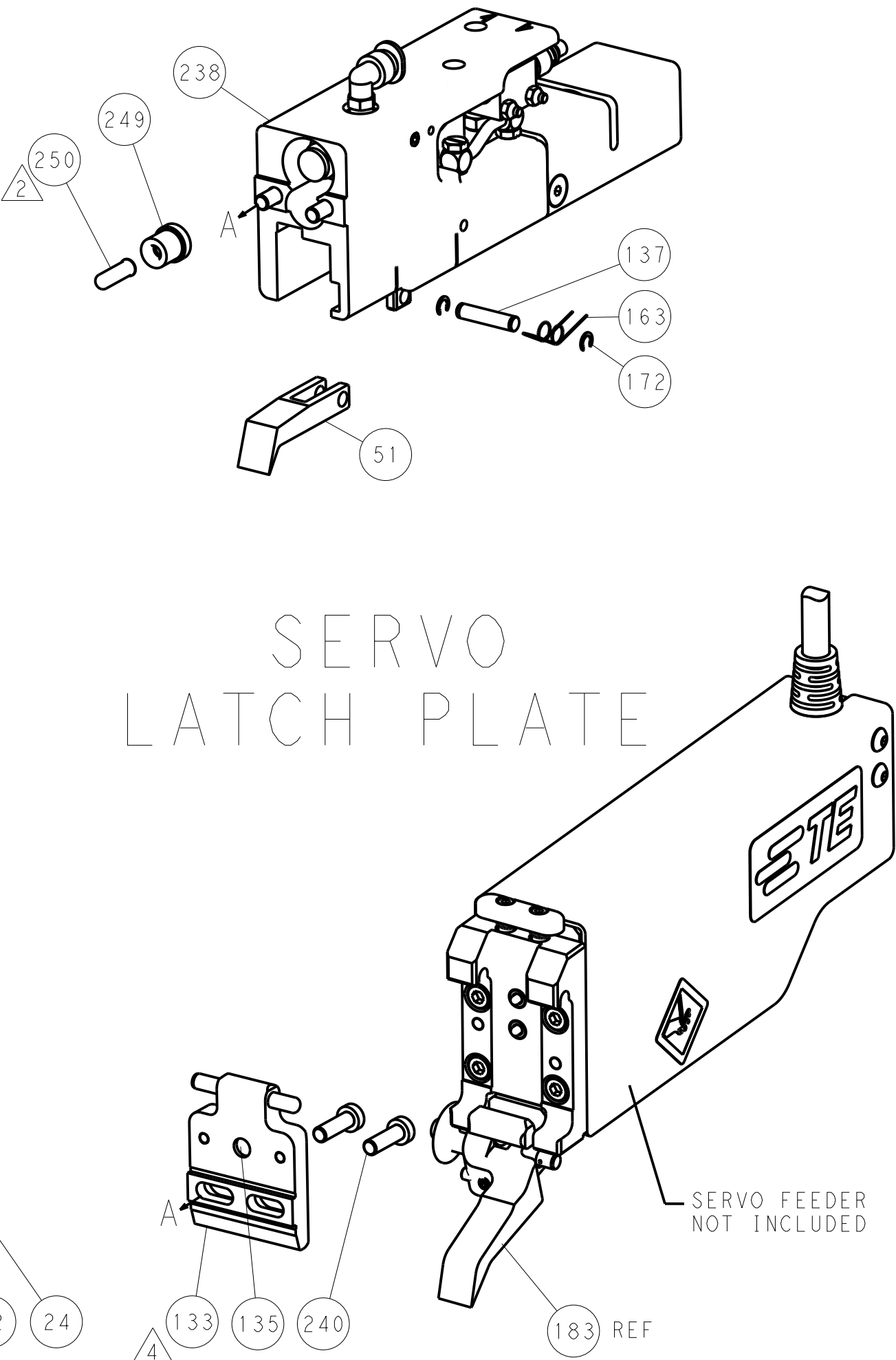
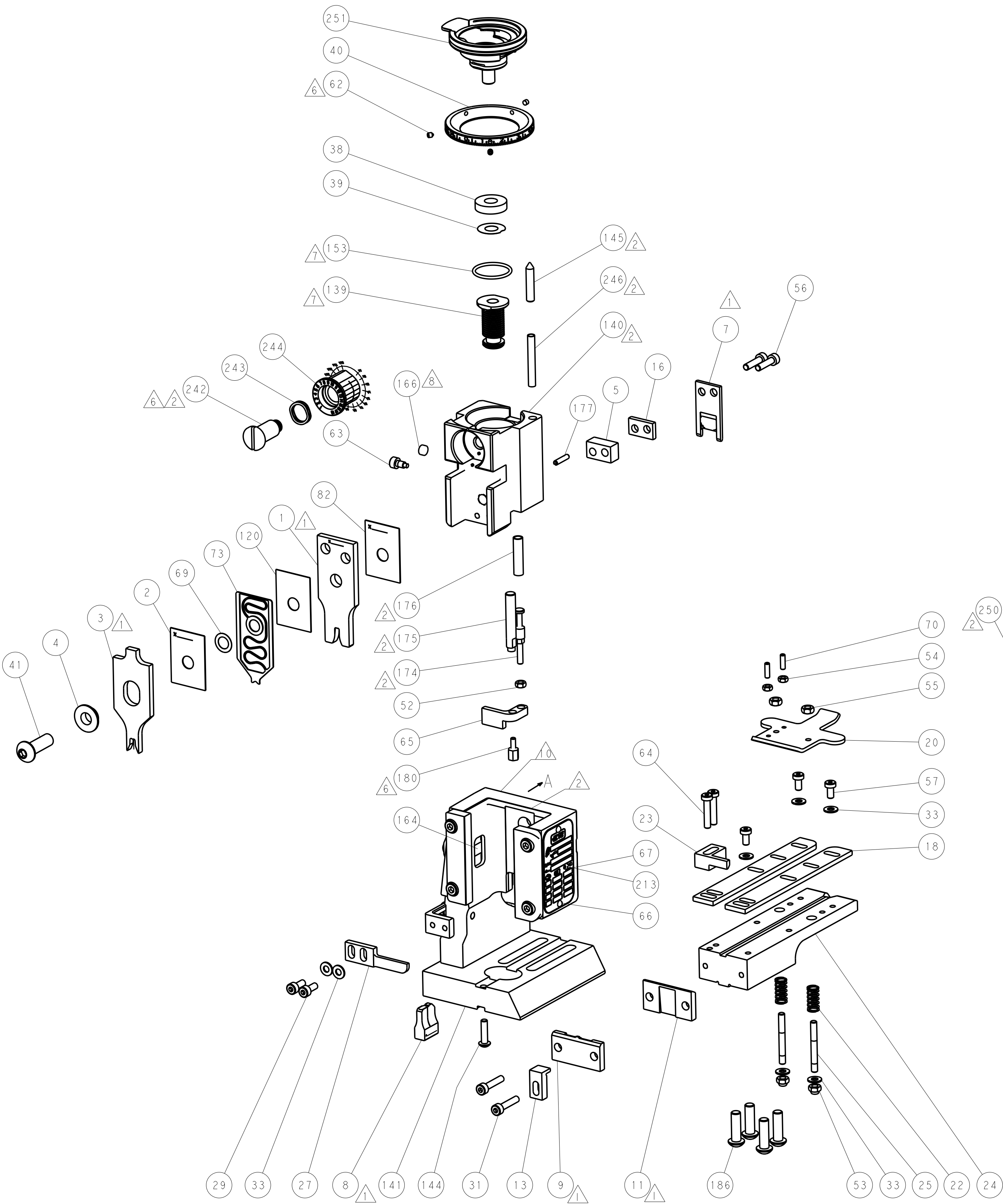
PNEUMATIC

SERVO LATCH PLATE

CAM POSITION



AIR FEED



PACIFIC VERSION
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DIMENSIONS: mm		CHK L. ZHANG 26NOV2013	NAME Ocean End Feed Applicator	
TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.5 1 PLC ±.13 2 PLC ±.13 3 PLC ±.013 4 PLC ±.0001 ANGLES ±.1		APVD J. GUO 26NOV2013	SIZE A1 00779 C=2150399	
MATERIAL -		PRODUCT SPEC -	RESTRICTED TO -	
FINISH -		APPLICATION SPEC -	Customer Accessible Production Drawing	
		WEIGHT -	SCALE 1:1 SHEET 4 OF 4 REV A	