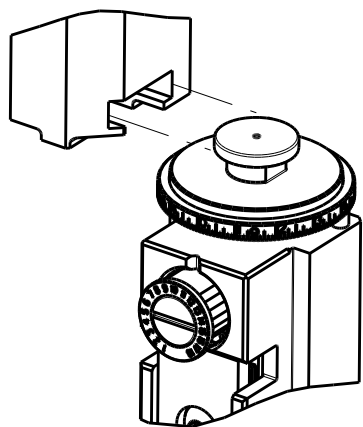


8		7	
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ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION
	2150388-1	A	FINE CRIMP HEIGHT ADJUST
	2150388-2	A	FINE CRIMP HEIGHT ADJUST
	2150388-5	A	FINE CRIMP HEIGHT ADJUST
	2150388-6	A	NON-CRIMP HEIGHT ADJUST
	2150388-7	A	FINE CRIMP HEIGHT ADJUST
	7-2150388-7	A	CRIMP TOOLING KIT

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.64 mm [.104]	F
INSUL	3.68 mm [.145]	OV
APPLICATOR INSTRUCTIONS 408-10390		

TERMINAL DATA: G & H TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: FLACHSTECKHULSE 4.80 x 0.8 FASTON			
WIRE STRIP LENGTH 5.00-5.00 mm [.197-.197 IN]		INSULATION DIAMETER RANGE Ø2.10-3.10 mm [.083-.122 IN]	
TERMINAL APPLICATION SPECIFICATION		25312	
TERMINAL APPLICATION SPECIFICATION		-	
TERMINALS APPLIED			
TE TERMINAL	G & H TERMINAL	TE TERMINAL	G & H TERMINAL
1572180-1	25312.213.011	1572180-8	25312.123.327
1572180-2	25312.417.328	1572180-9	25312.123.324
1572180-3	25312.417.031	1-1572180-0	25312.123.210
1572180-4	25312.213.178	1-1572180-1	25312.123.211
1572180-5	25312.213.042	1-1572180-2	25312.123.204
1572180-6	25312.213.004	1-1572180-3	25312.123.178
1572180-7	25312.123.330		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
2 X 1.00mm2	1.75+/-0.05 [.069+/- .002]	4.4
2.50mm2	1.70+/-0.05 [.067+/- .002]	5.0
1.50mm2	1.50+/-0.05 [.059+/- .002]	7.0



- 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:
MECHANICAL FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150388-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150388-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150388-5
SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2150388-6
- 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, 180 & 242.
FOR -6 ONLY APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 37, 180 & 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

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.
- 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.

-	-	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
-77	-7	-6	-5	-2	-1	PART NO	DESCRIPTION	ITEM NO

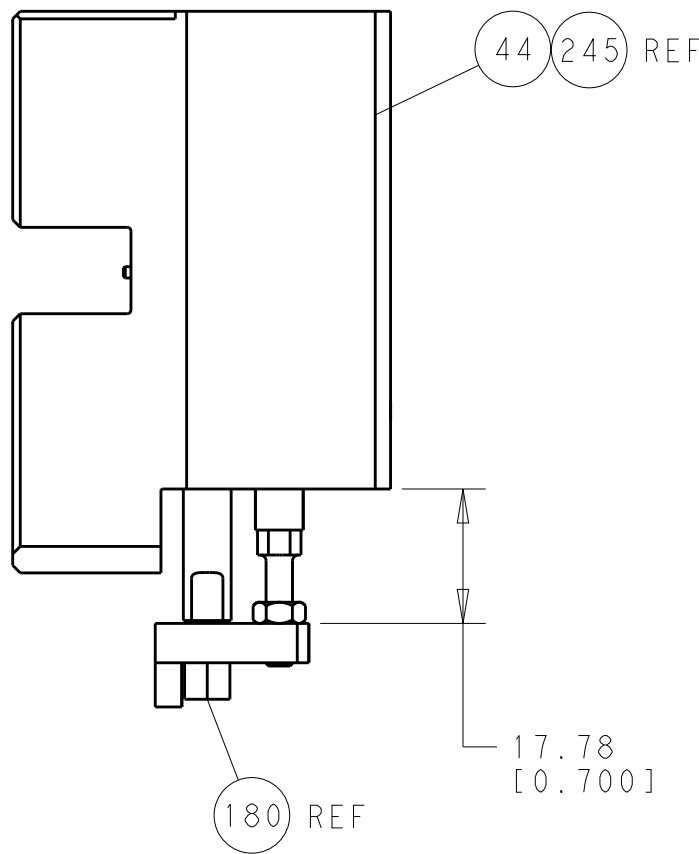
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

SET UP GAUGE 2119599-2	LOC A	DIST 66	REVISIONS				
			P	LTR	DESCRIPTION	DATE	DWN
				A	RELEASED	18DEC2013	LG

-	1	-	1	1	1	2119798-1	DETENT PIN	247
-	1	-	1	1	1	1-22279-3	SPRING, COMPRESSION	246
-	-	1	-	-	-	2119759-1	RAM, AMP STYLE, END FEED, NON-ADJUST	245
-	1	1	1	1	1	2119082-9	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
-	-	2	2	-	-	2168400-7	SHCS, LOW HEAD, RoHS, M5 X 10	240
-	-	-	-	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	-	-	-	1	-	2063440-1	AIR FEED MODULE	238
-	-	1	1	-	-	2119740-2	TAG, IDENTIFICATION	213
-	-	REF	REF	-	-	1901697-1	FEED FINGER ASSEMBLY, EF	183
-	1	1	1	1	1	1752354-4	STANDOFF, HOLD-DOWN	180
-	1	1	1	1	1	6-993111-6	PIN, SLOTTED SPRING 3.0 X 14.0	177
-	1	1	1	1	1	8-22280-7	SPRING, COMPRESSION	176
-	1	1	1	1	1	1752353-2	GUIDE PIN, HOLDDOWN	175
-	1	1	1	1	1	1901680-2	GUIDE PIN, HOLDDOWN	174
-	-	-	-	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
-	-	REF	REF	-	-	SEE NOTE 4	MEMORY CHIP, PROGRAMMED	135
-	-	1	1	-	-	1633743-1	SERVO FEED LATCH ASM	133
-	1	1	1	1	1	455888-6	SPACER, CRIMPER	82
-	1	1	1	1	1	2119956-2	DOCUMENTATION PACKAGE	71
-	2	2	2	2	2	2-18032-2	SCR, SET, FLT POINT M3 X 10.0	70
-	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	1	1901681-5	HOLDDOWN, TERMINAL	65
-	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	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	-	-	-	-	1	2063961-1	FEED FINGER	58
-	4	4	4	4	4	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57
-	2	2	2	2	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	56
-	2	2	2	2	2	5018030-2	NUT, HEX, REG, RoHS, M4	55
-	2	2	2	2	2	5018030-1	NUT, HEX, REG, RoHS, M3	54
-	2	2	2	2	2	986965-8	NUT, LOCK, HEX, TORQUE (M4)	53
-	1	1	1	1	1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52
-	-	-	-	1	-	2119792-1	PAWL, EF, AIR	51
-	-	-	-	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	2119655-5	APPLICATOR BASIC ASSEMBLY, EF	46
-	1	-	1	1	1	2119369-1	RAM, AMP STYLE, END 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	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
-	8	8	8	8	8	1-18028-2	WASHER, FLAT, REG M4	33
-	2	2	2	2	2	2079383-8	SCR, BHSC, RoHS (M4 X 16)	31
-	2	2	2	2	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	29
-	1	1	1	1	1	240639-1	STRIPPER (MACHINING)	27
-	2	2	2	2	2	1320906-1	STUD, THREADED	25
-	1	1	1	1	1	1752371-5	PLATE, STRIP GUIDE	24
-	2	2	2	2	2	2-22281-3	SPRING, COMPRESSION	22
-	1	1	1	1	1	1752373-4	DRAG	20
-	2	2	2	2	2	1901259-5	GUIDE, LOWER STRIP	18
-	4	4	4	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17
-	1	1	1	1	1	240644-1	PLATE, REAR SHEAR	11
-	-	-	-	-	-	-	-	10
-	1	1	1	1	1	1-690482-2	PLATE, FRONT SHEAR	9
1	1	1	1	1	1	3-1803001-3	ANVIL, COMBINATION, END FEED	8
-	1	1	1	1	1	2217206-7	BLADE, SLUG	7
-	-	-	-	-	-	-	-	6
-	1	1	1	1	1	4-240641-1	SPACER	5
-	1	1	1	1	1	238009-1	BLOCK, FL CRIMPER SPACER	4
1	1	1	1	1	1	1633963-5	CRIMPER, INSULATION OVERLAP PREMIUM	3
-	1	1	1	1	1	455888-5	SPACER, CRIMPER	2
1	1	1	1	1	1	9-1633305-1	CRIMPER, WIRE PREMIUM	1
-77	-7	-6	-5	-2	-1	PART NO	DESCRIPTION	ITEM NO

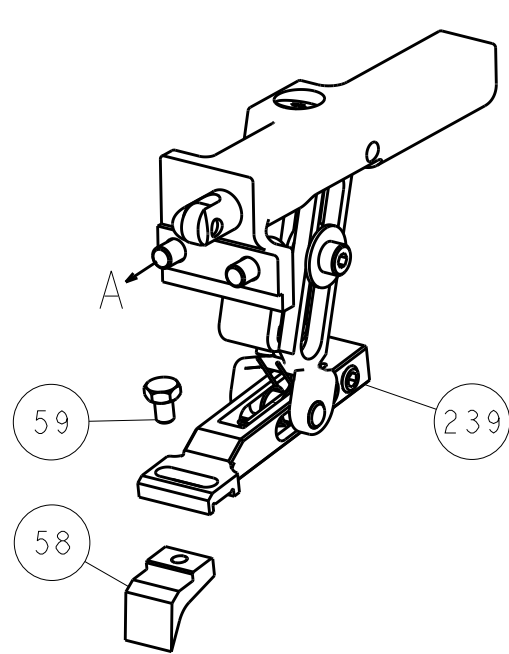
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DIMENSIONS:		CHK L. ZHANG	18OCT2013	NAME	
mm		APVD J. GUO	18OCT2013	Ocean End Feed Applicator	
TOLERANCES UNLESS OTHERWISE SPECIFIED:		PRODUCT SPEC		SIZE	
0 PLC ±.5		APPLICATION SPEC		CASE CODE	
1 PLC ±0.5		WEIGHT		DRAWING NO	
2 PLC ±0.13		Customer Accessible Production Drawing		RESTRICTED TO	
3 PLC ±0.013		SCALE		1:1	
4 PLC ±0.0001		SHEET		1 OF 4	
ANGLES ±.0001		REV		A	
FINISH		DATE		©=2150388	

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

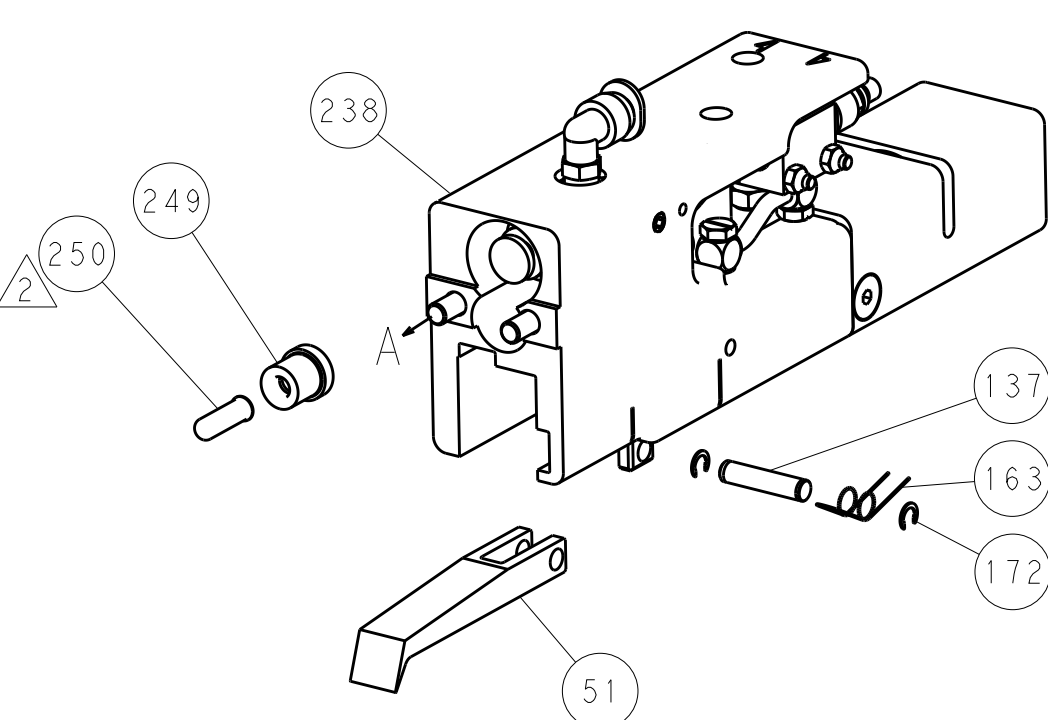


HOLDDOWN SET-UP

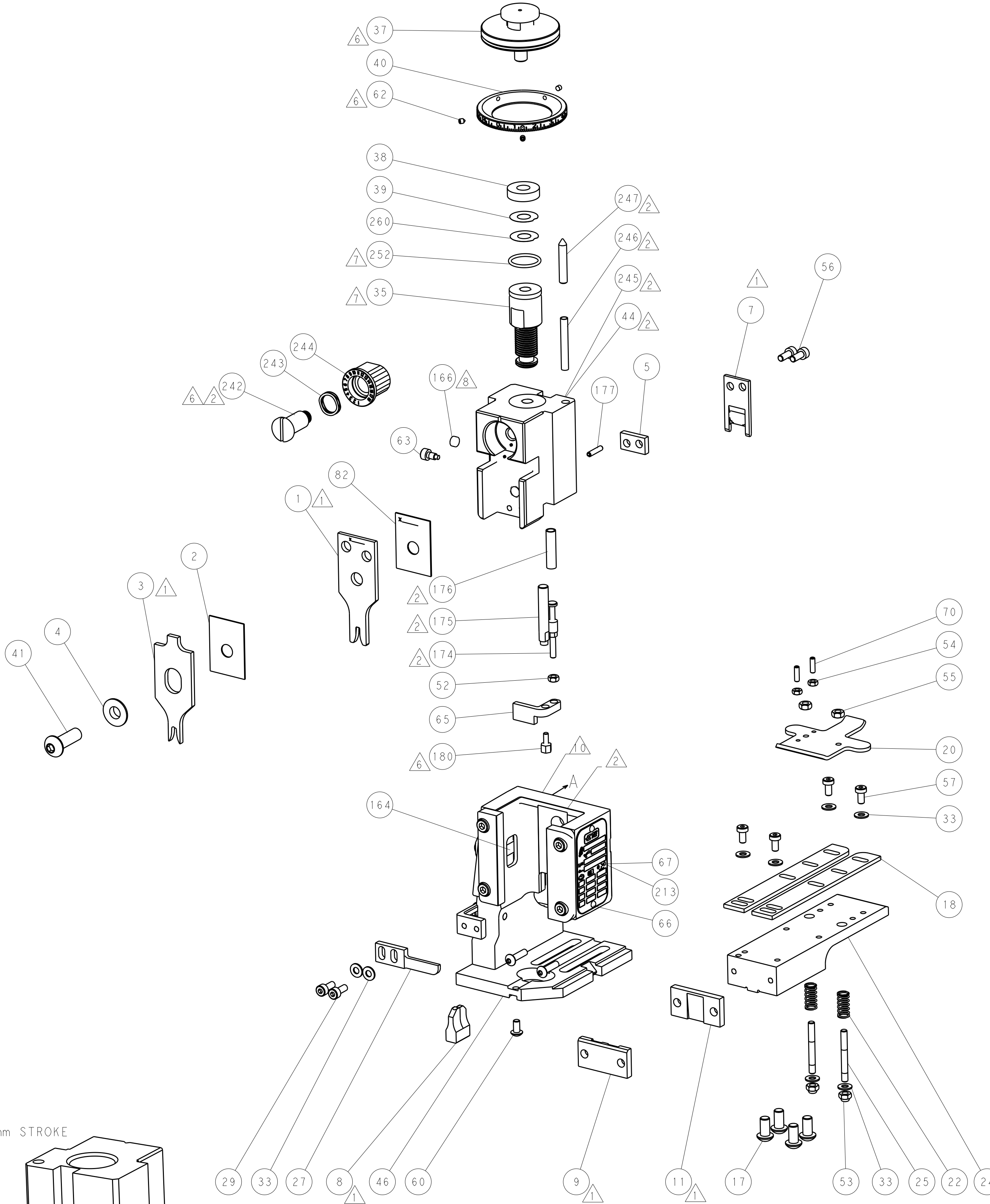
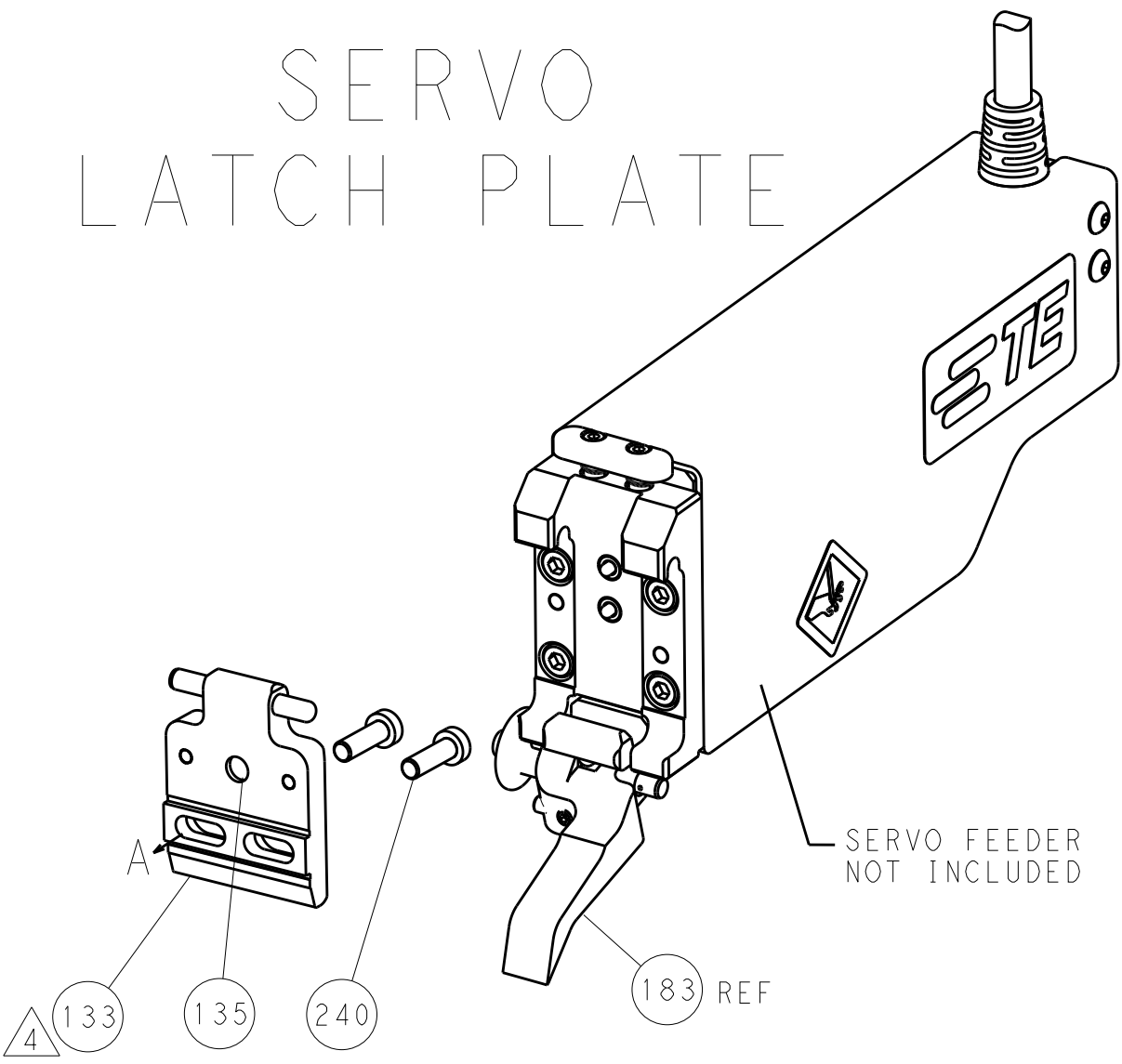
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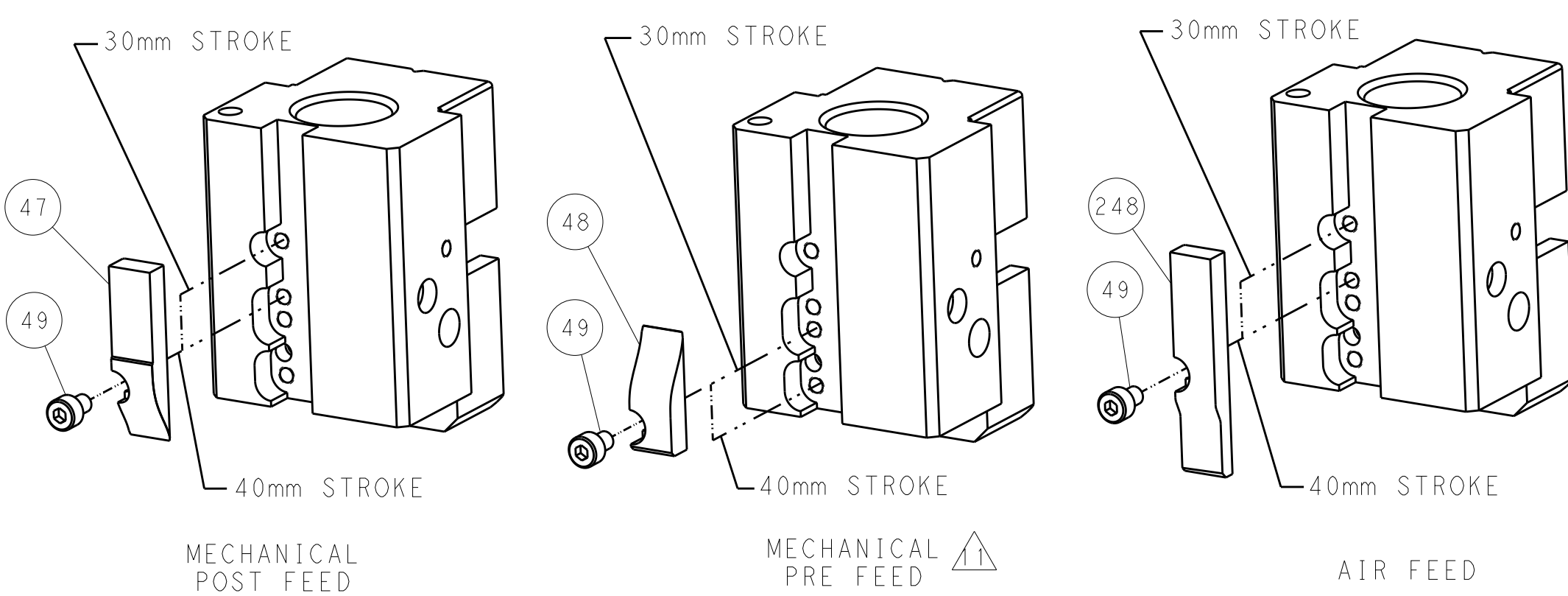
PNEUMATIC



SERVO
LATCH PLATE



CAM POSITIONS

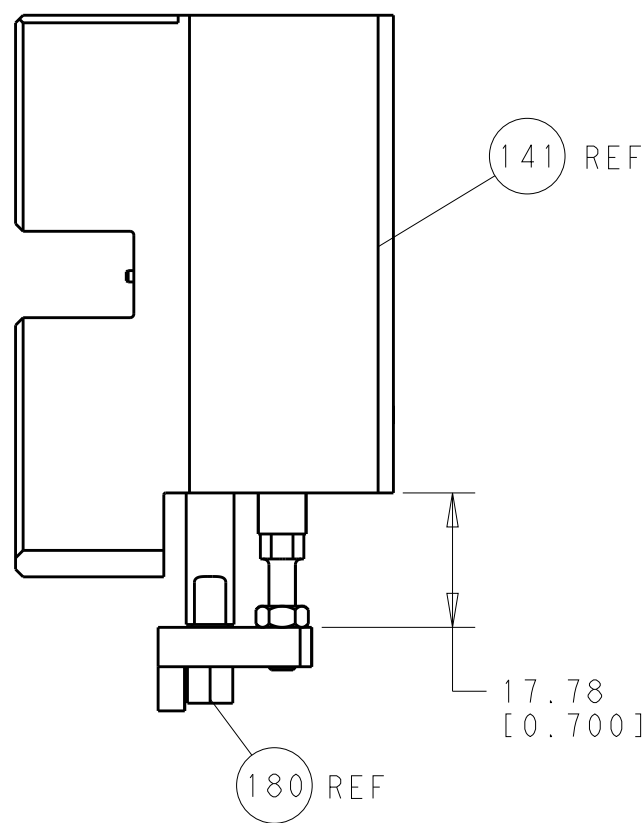


ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

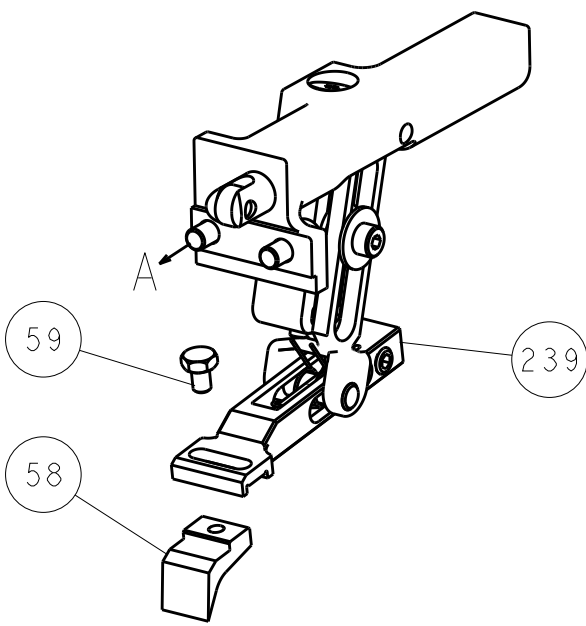
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DIMENSIONS: mm		CHK L. ZHANG 18OCT2013	NAME Ocean End Feed Applicator	
TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±0.5 1 PLC ±0.13 2 PLC ±0.13 3 PLC ±0.013 4 PLC ±0.0001 ANGLES ±0.0001		APVD J. GUO 18OCT2013	PRODUCT SPEC APPLICATION SPEC	
MATERIAL		FINISH	SIZE A11 00779 C=2150388	
Customer Accessible Production Drawing		SCALE 1:1	SHEET 2 OF 4	
			REV A	

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

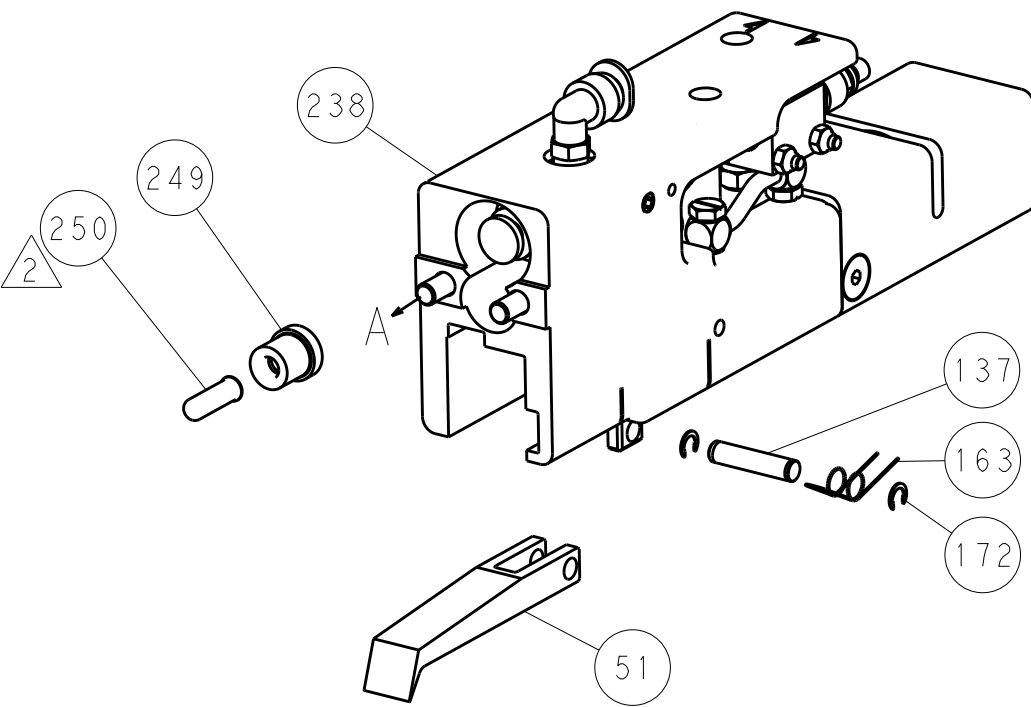
HOLDDOWN SET-UP



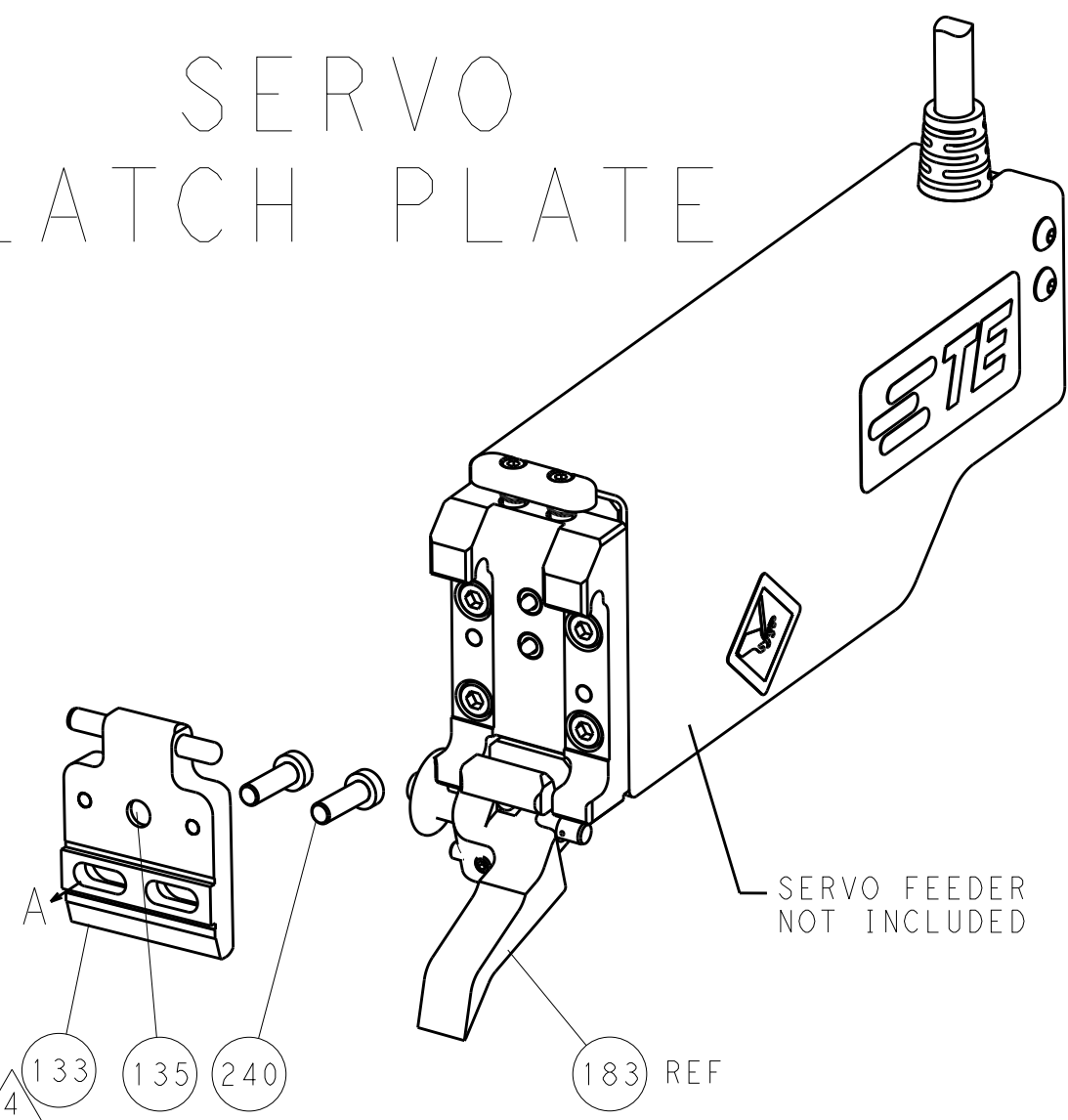
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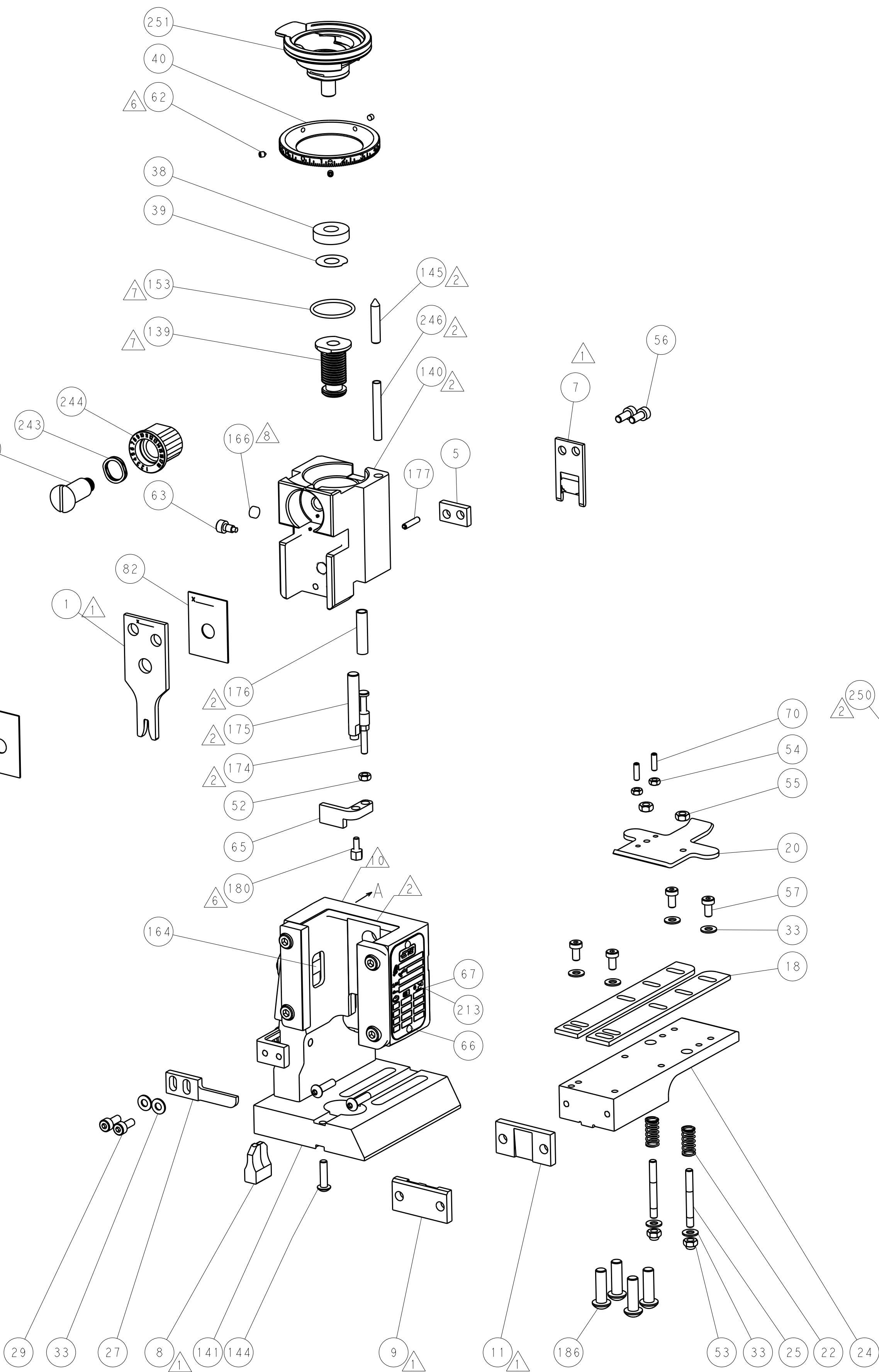
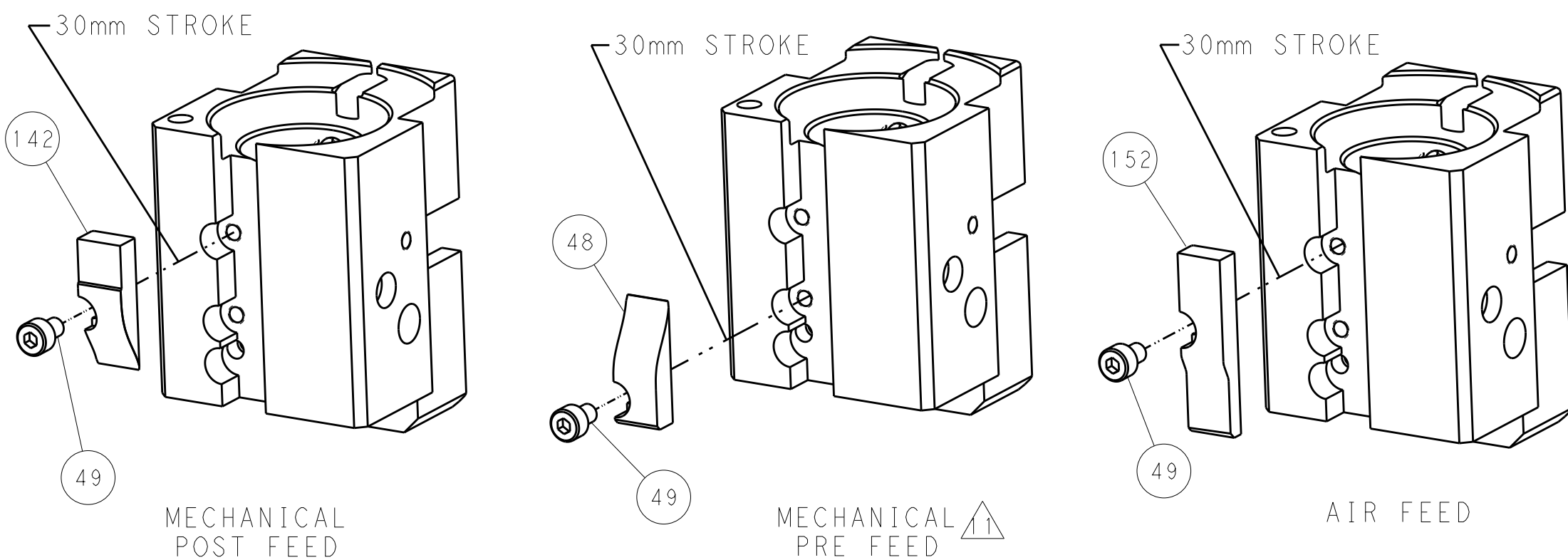
PNEUMATIC



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		CHK		APVD		NAME	
mm		0 PLC ±0.5		K. HUANG		L. ZHANG		U. GUO		Ocean End Feed Applicator	
1 PLC ±0.13		2 PLC ±0.13		3 PLC ±0.13		4 PLC ±0.0001		PRODUCT SPEC		SIZE	
MATERIAL		FINISH		WEIGHT		Customer Accessible Production Drawing		SCALE		SHEET	