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RELEASED FOR PUBLICATION

20

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ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER

PART NUMBER

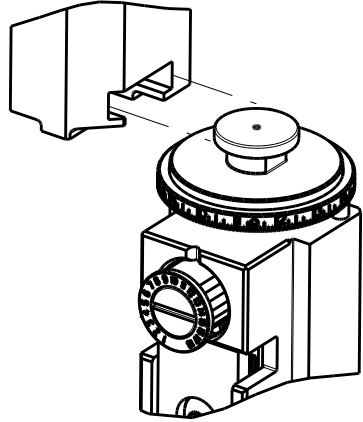
REVISION

DESCRIPTION

FEED TYPE

CONVERT TO

PART NUMBERS REQUIRED



2150147-1

A

FINE CRIMP HEIGHT ADJUST

MECHANICAL

PNEUMATIC FEED

SERVO LATCH PLATE

SMART APPLICATOR

2119950-1

2119792-1

-

2119641-1

-

2063440-1

2150147-2

A

FINE CRIMP HEIGHT ADJUST

PNEUMATIC

MECHANICAL FEED

SERVO LATCH PLATE

SMART APPLICATOR

2119949-1

2063961-1

5-18022-5

2119653-1

-

-

2150147-5

A

FINE CRIMP HEIGHT ADJUST

SERVO LATCH PLATE⁴

MECHANICAL FEED

PNEUMATIC FEED

2119949-1

2063961-1

5-18022-5

2119653-1

-

2063440-1

2150147-6

A

NON-CRIMP HEIGHT ADJUST

SERVO LATCH PLATE⁴¹²

-

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-

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-

2150147-7

A

FINE CRIMP HEIGHT ADJUST

NONE

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-

7-2150147-7

A

CRIMP TOOLING KIT

-

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-

-

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-

-

APPLICATOR DATA

CRIMP

SIZE

TYPE

WIRE

2.29 mm [.090]

F

INSUL

4.57 mm [.180]

F

APPL INSTRUCTIONS

408-10390

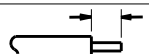


TERMINAL DATA: TE TERMINAL

TE CRIMP SPECIFICATION

TERMINAL NAME: RING AMPLIVAR

WIRE STRIP LENGTH



INSULATION DIAMETER RANGE

4.48-5.08 mm [.176-.200 IN]

Ø3.18-4.19 mm [.125-.165 IN]

TERMINAL APPLICATION SPECIFICATION

114-2084

-

-

TERMINALS APPLIED

TE TERMINAL

TE TERMINAL

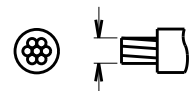
TE TERMINAL

TE TERMINAL

60323-2

60325-2

WIRE SIZE



CRIMP HEIGHT mm [INCH]



CRIMP HEIGHT REFERENCE SETTING⁹

19 AWG

1.12+/-0.05 [.044+/- .002]

7.4

20 AWG

1.07+/-0.05 [.042+/- .002]

7.9

21, 22, 23

1.02+/-0.05 [.040+/- .002]

8.4



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: 8-2150147-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150147-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150147-5
SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2150147-6

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 50, 62 & 242.
FOR -6 ONLY APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 37, 50 & 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

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100

SET UP GAUGE

2119599-2

LOC

A

DIST

66

P

LTR

DESCRIPTION

DATE

OWN

APVD

I

DEVELOPMENT

09JAN2013

YY

SX

A

RELEASED

27AUG2013

YY

UG

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1-22279-3

SPRING, COMPRESSION

246

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2119759-1

RAM, AMP STYLE, END FEED, NON-ADJUST

245

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2119082-9

CAM, SNAIL, INSULATION ADJUSTMENT

244

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2079764-1

WASHER, WAVE SPRING, CREST-TO-CREST

243

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2119083-1

RETAINER, INSULATION DIAL

242

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2168400-7

SHCS, LOW HEAD, RoHS, M5 X 10

240

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2119580-1

MECHANICAL FEED ASSEMBLY

239

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2063440-1

AIR FEED MODULE

238

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2119740-2

TAG, IDENTIFICATION

213

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-

REF

REF

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1901697-1

FEED FINGER ASSEMBLY, EF

183

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6-993111-6

PIN, SLOTTED SPRING 3.0 X 14.0

177

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8-22280-7

SPRING, COMPRESSION

176

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1752353-2

GUIDE PIN, HOLDDOWN

175

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1901680-2

GUIDE PIN, HOLDDOWN

174

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21045-3

RING, RETAIN, EXTERN, 3/16 CRESCENT

172

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994969-1

MAGNET, RARE EARTH HIGH ENERGY

166

-

REF

REF

REF

REF

REF

994970-2

COUNTER, MAGNETIC

164

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240638-1

SPRING, FEED FINGER

163

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3-23627-7

PIN, RETAIN, GRVD, 3/16 X .854

137

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REF

REF

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SEE NOTE 4

MEMORY CHIP, PROGRAMMED

135

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1633743-1

SERVO FEED LATCH ASM

133

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455888-5

SPACER, CRIMPER

82

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2119956-2

DOCUMENTATION PACKAGE

71

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2

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2-18032-2

SCR, SET, FLT POINT M3 X 10.0

70

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1

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2119740-1

TAG, IDENTIFICATION

67

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2

2

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2

2168078-1

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

66

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1901681-1

HOLDDOWN, TERMINAL

65

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2119793-1

LIMITER, ADJUSTMENT BOLT

63

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992763-5

SCR, SET, SOC, CONE POINT, M3 x 4.0

62

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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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2063961-1

FEED FINGER

58

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4

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2168400-4

SHCS, LOW HEAD, RoHS, M4 X 8

57

-

2

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2

2168083-2

SCR, SKT HD CAP, RoHS, M4 X 8.0

56

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5018030-2

NUT, HEX, REG, RoHS, M4

55

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2

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2

5018030-1

NUT, HEX, REG, RoHS, M3

54

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986965-8

NUT, LOCK, HEX, TORQUE (M4)

53

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1-5018030-0

NUT, HEX, REG, RoHS, M3.5

52

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2119792-1

PAWL, EF, AIR

51

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4-1752354-1

STANDOFF, HOLD-DOWN

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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2119655-5

APPLICATOR BASIC ASSEMBLY, EF

46

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2119369-1

RAM, AMP STYLE, END 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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2119644-1

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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1-18028-2

WASHER, FLAT, REG M4

33

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2168083-9

SCR, SKT HD CAP, RoHS, M4 X 20

31

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1-2168083-0

SCR, SKT HD CAP, RoHS, M4 X 10

29

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240639-1

STRIPPER (MACHINING)

27

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1320906-1

STUD, THREADED

25

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1752371-5

PLATE, STRIP GUIDE

24

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4-22281-1

SPRING, COMPRESSION

22

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1752373-1

DRAG

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1901696-3

STRIP GUIDE, REAR

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1901695-3

STRIP GUIDE, FRONT

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1-2079383-1

SCR, BHSC, RoHS (M6 X 12)

17

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1752360-1

SPACER, HOLD-DOWN

13

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240644-1

PLATE, REAR SHEAR

11

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690482-5

PLATE, FRONT SHEAR

9

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1803064-3

ANVIL, COMBINATION

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690474-5

BLADE, SLUG

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1-240641-0

SPACER

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3-238009-8

BLOCK, FL CRIMPER SPACER

4

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7-1633961-2

CRIMPER, INSULATION F PREMIUM

3

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455888-3

SPACER, CRIMPER

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7-456406-8

CRIMPER, WIRE PREMIUM

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PART NO

DESCRIPTION

ITEM NO

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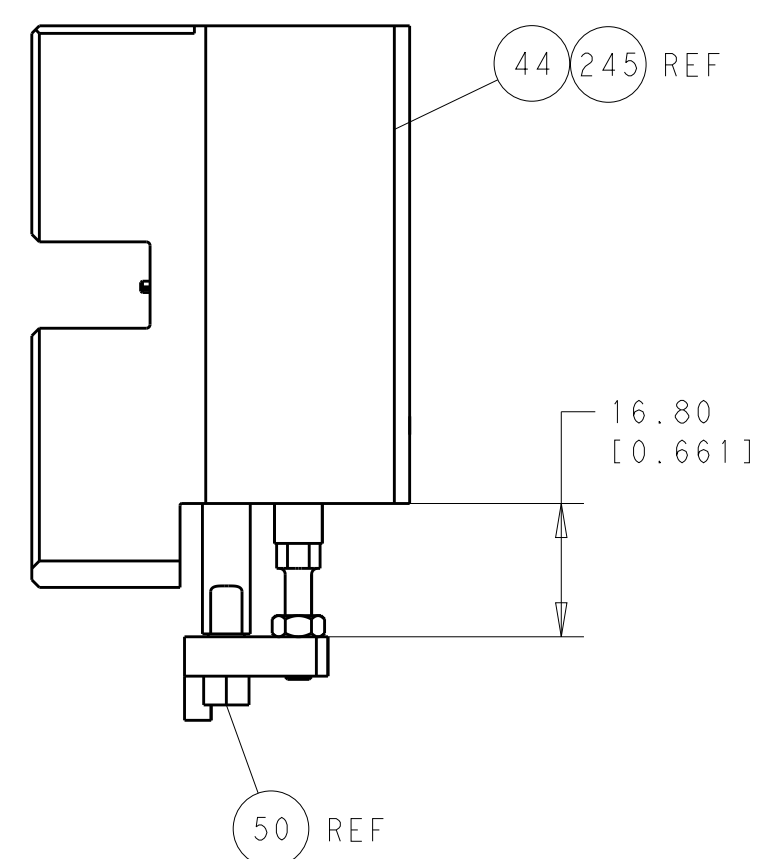
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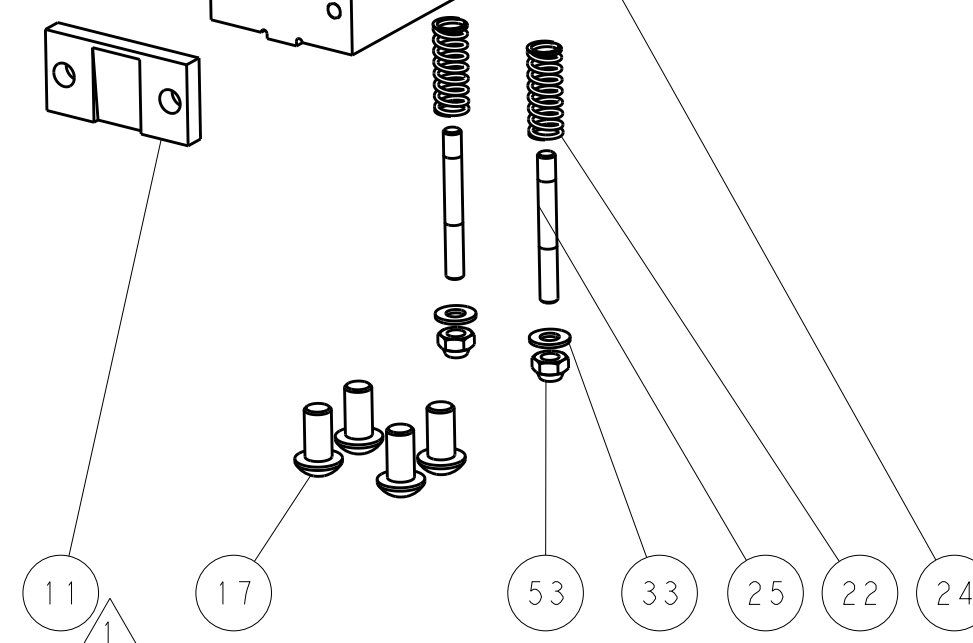
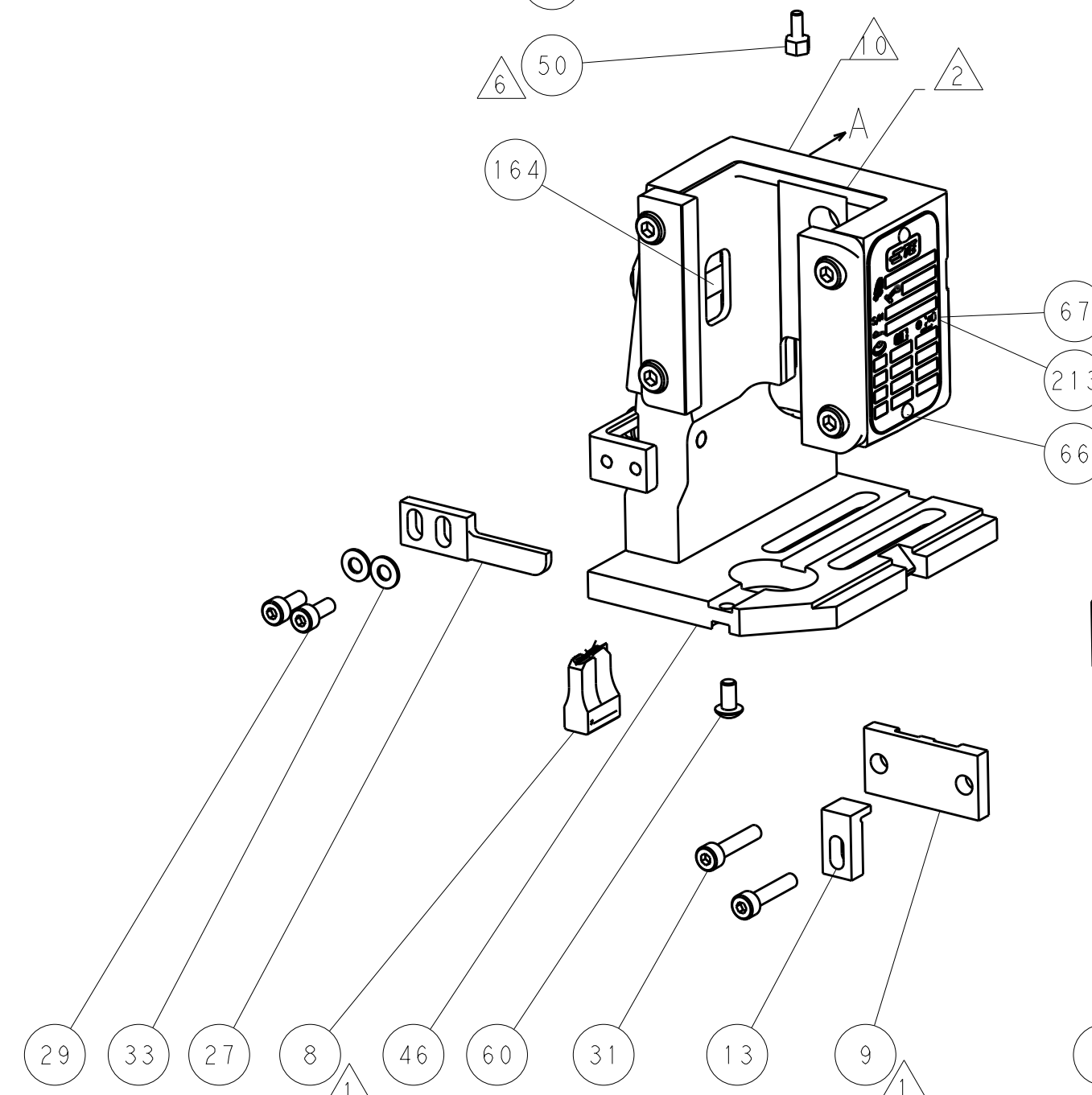
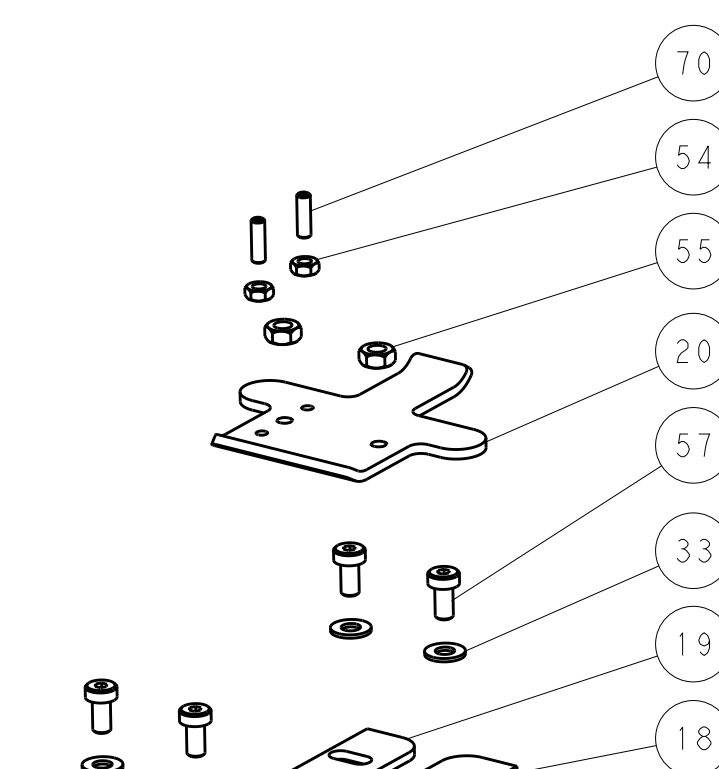
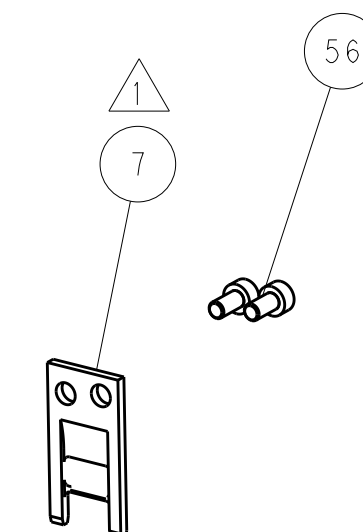
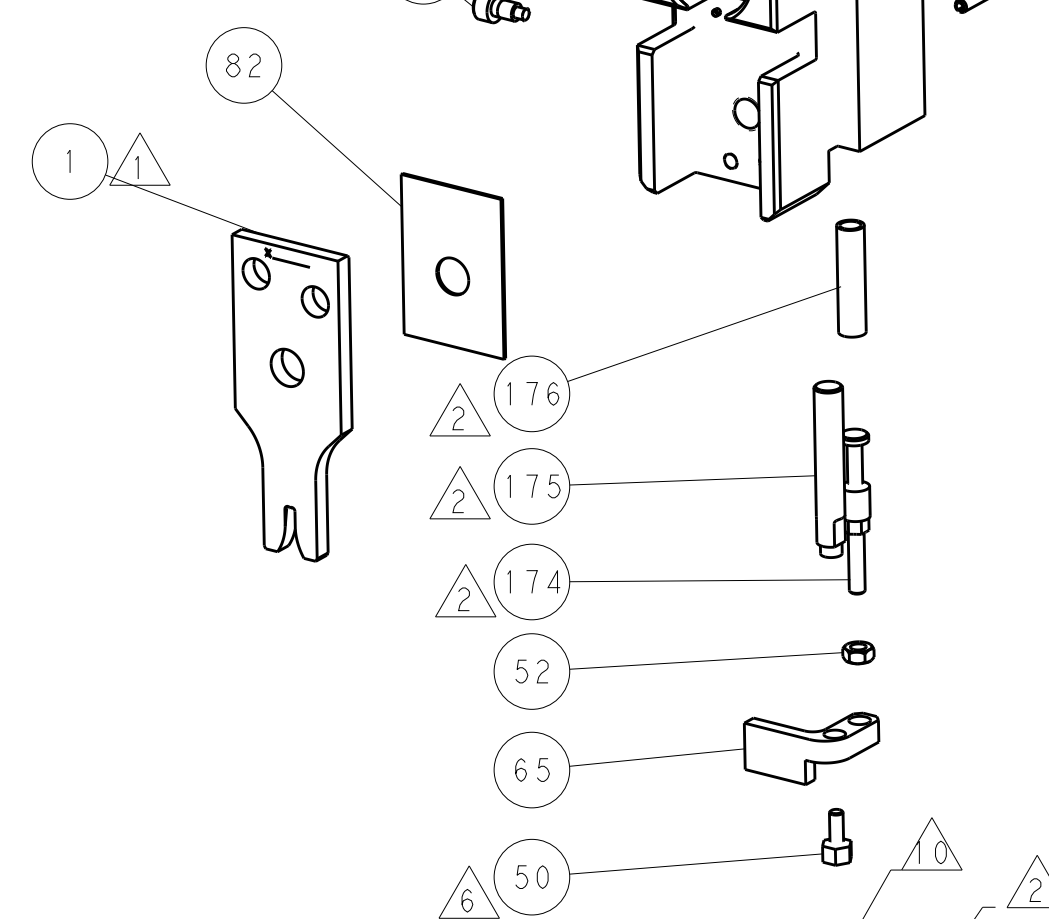
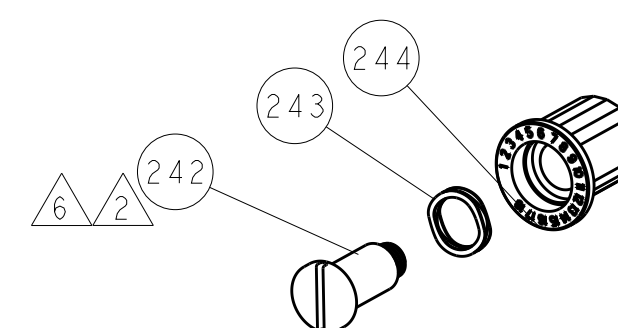
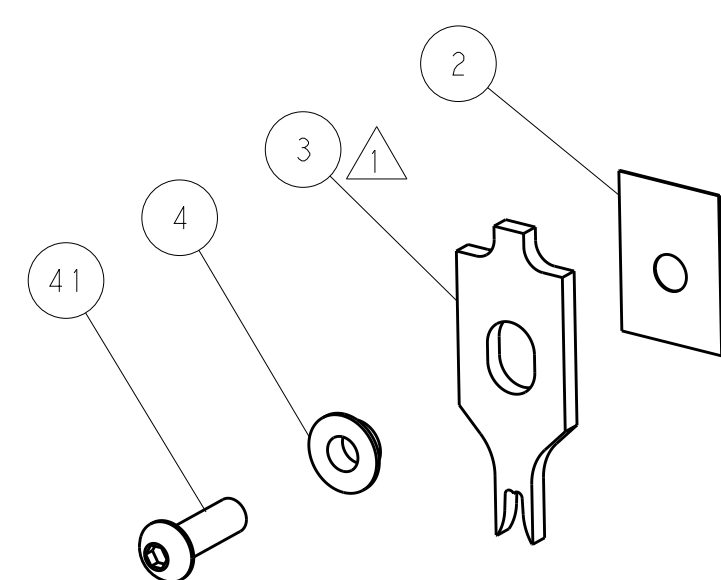
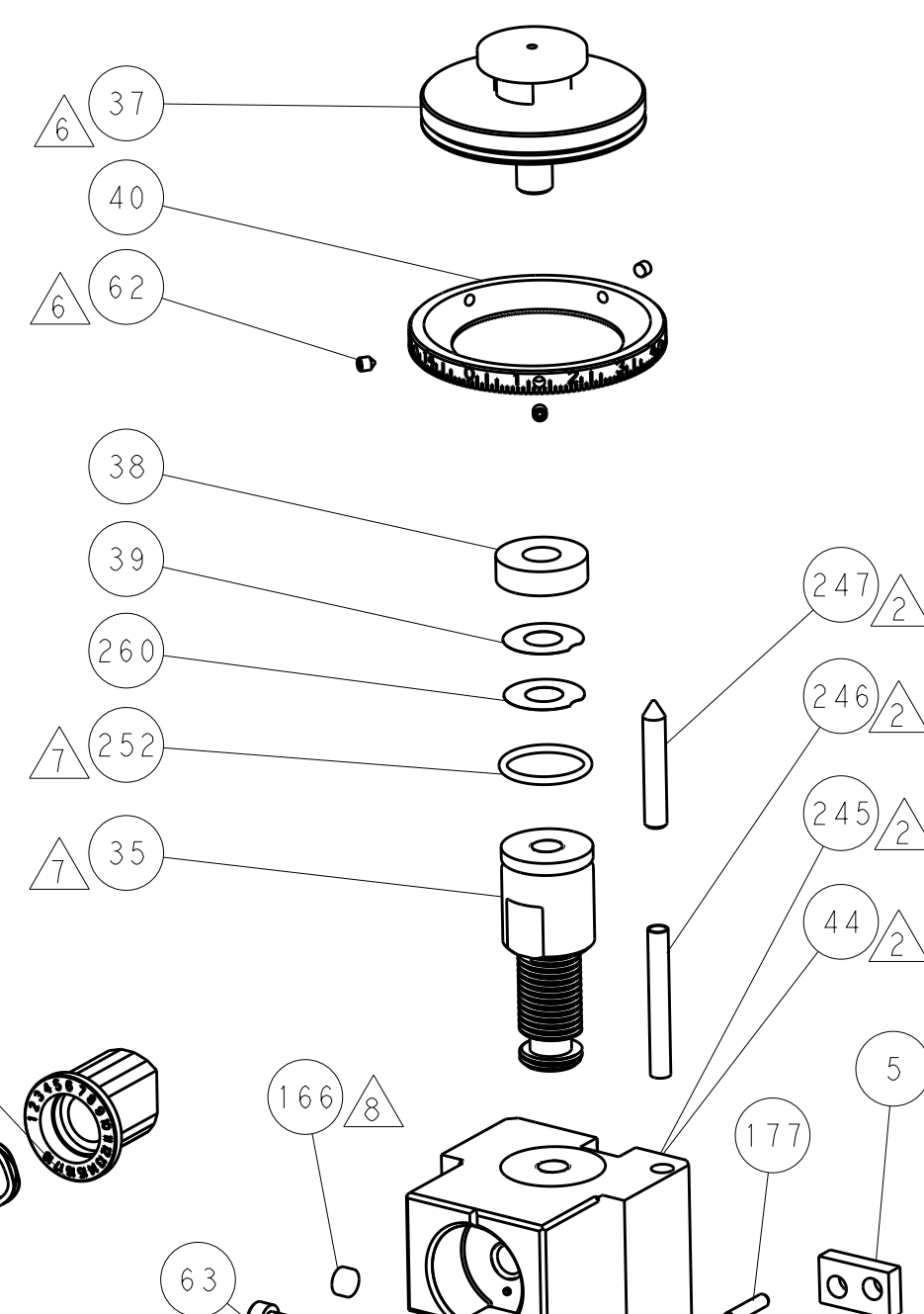
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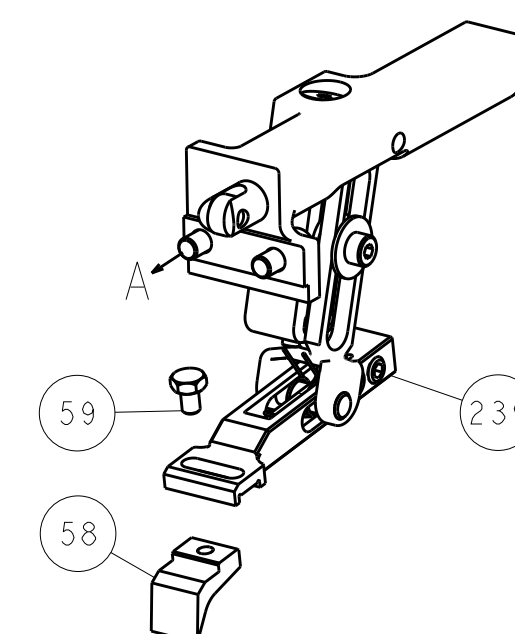
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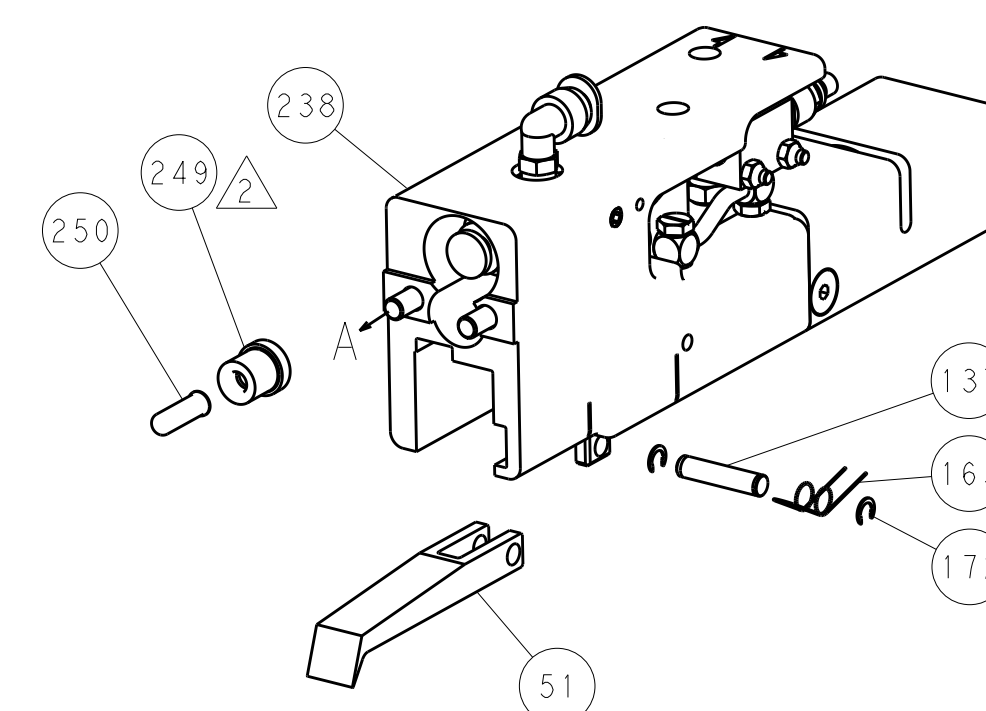
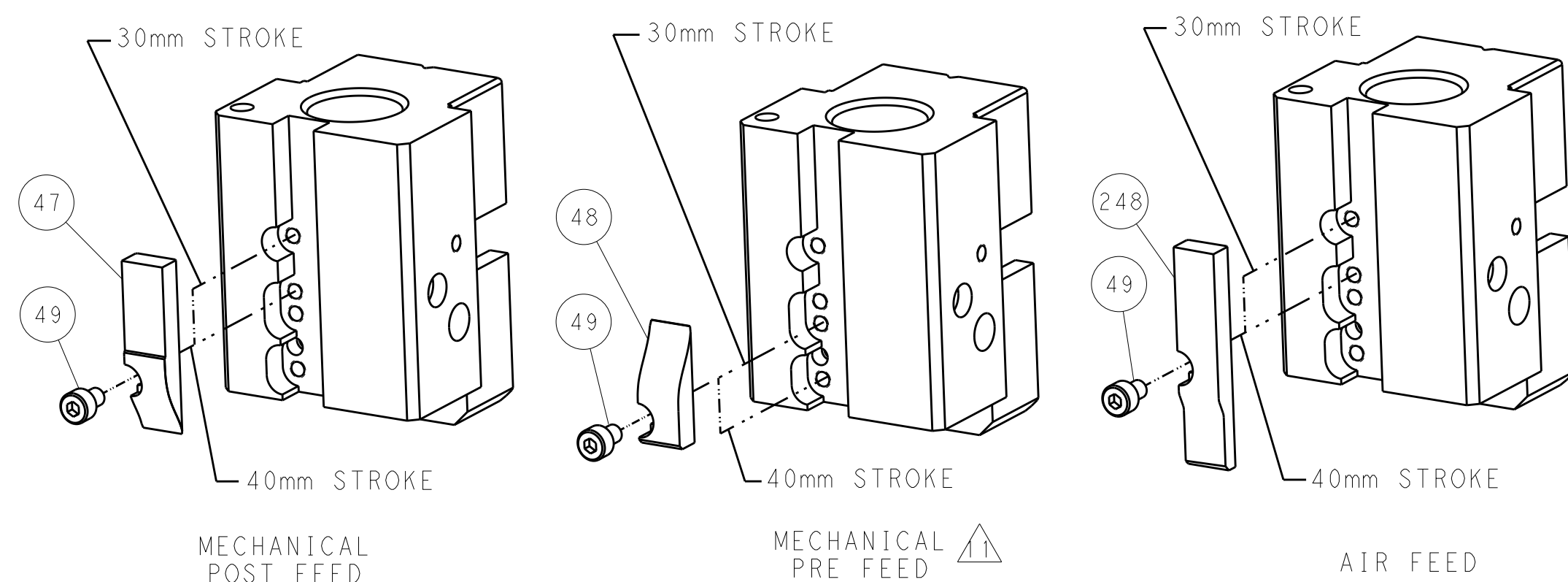
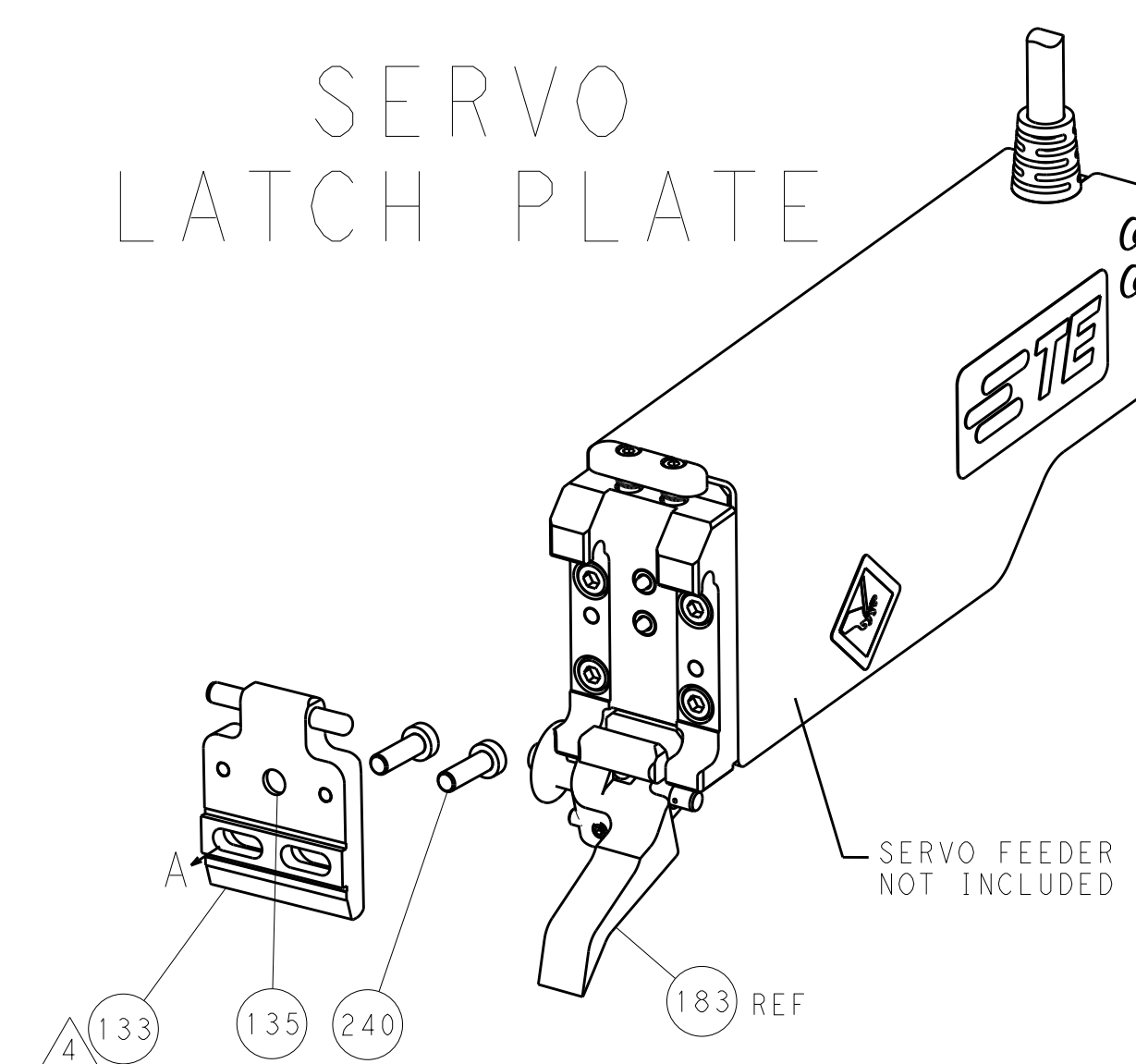
HOLDDOWN SET-UP



FEED TYPE
MECHANICAL

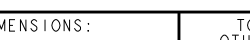


PNEUMATIC

SERVO
LATCH PLATE

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 G BAILEY 09 JAN 2013			
TOLERANCES, UNLESS OTHERWISE SPECIFIED:		APVD S XI 09 JAN 2013			
mm		PRODUCT SPEC		NAME	
		APPLICATION SPEC		Ocean End Feed Applicator	
MATERIAL		FINISH		RESTRICTED TO	
-		-		-	
		WEIGHT		-	
		-		-	
		Customer Accessible Production Drawing		SCALE 1:1 SHEET 2 of 4 REV A A 00779 ©=2150147	

