

8

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1

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ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER

PART NUMBER

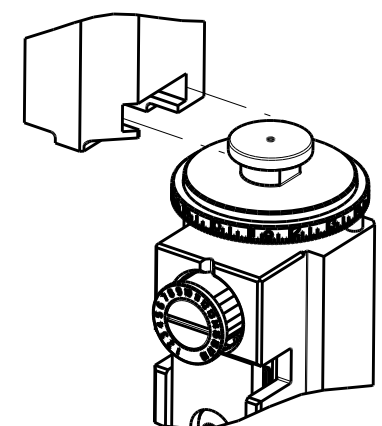
REVISION

DESCRIPTION

FEED TYPE

CONVERT TO

PART NUMBERS REQUIRED



2151107-2

B

FINE CRIMP HEIGHT ADJUST

PNEUMATIC

-

SERVO LATCH PLATE

SMART APPLICATOR

2119951-1

2161326-1

-

1338685-1

-

1338685-1

5-18022-5

8-2151107-5

8-2151107-4

2119653-1

1901094-3

-

-

-

2168400-6 (QUANTITY 2)

2151107-5

B

FINE CRIMP HEIGHT ADJUST

SERVO LATCH PLATE

4

-

PNEUMATIC FEED

-

2119950-1

1338685-1

1338685-1

5-18022-5

5-18022-5

2119653-1

2119641-1

-

2119799-1

2063440-2

2151107-6

B

NON-CRIMP HEIGHT ADJUST

SERVO LATCH PLATE

4

12

-

-

-

-

-

-

-

-

-

-

-

-

-

-

-

2151107-7

B

FINE CRIMP HEIGHT ADJUST

NONE

-

-

-

-

-

-

-

-

-

-

-

-

-

-

-

7-2151107-7

A

CRIMP TOOLING KIT

-

-

-

-

-

-

-

-

-

-

-

-

-

-

-

-

APPLICATOR DATA

CRIMP

SIZE

TYPE

WIRE

2.79 mm [1.110]

F

INSUL

3.55 mm [1.40]

OV

APPLICATOR INSTRUCTIONS

408-10389

TERMINAL DATA: TE TERMINAL

TE CRIMP SPECIFICATION

TERMINAL NAME: POSITIVIE LOCK RECEPTACLE

WIRE STRIP LENGTH

INSULATION DIAMETER RANGE

5.70-6.30 mm [1.224-.248 IN]

Ø2.10-3.10 mm [1.083-.122 IN]

TERMINAL APPLICATION SPECIFICATION

114-18365

-

-

TERMINALS APPLIED

10

3

TE TERMINAL

TE TERMINAL

TE TERMINAL

TE TERMINAL

927854-1

927854-2

927854-3

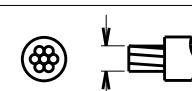
927854-6

927854-7

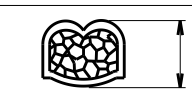
927854-8

927854-9

WIRE SIZE



CRIMP HEIGHT mm [INCH]



CRIMP HEIGHT REFERENCE SETTING

2.50mm2

2.04+/-0.05 [1.080+/-0.002]

6.6

2.00mm2

1.90+/-0.05 [1.075+/-0.002]

8.4

1.50mm2

1.76+/-0.05 [1.069+/-0.002]

10.1

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: 8-2151107-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151107-5
SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2151107-6

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 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

TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.

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 -6 NON-CRIMP HEIGHT ADJUST APPLICATOR USE SHIM PACK 2119957-2 TO ALIGN APPLICATOR'S MAXIMUM WIRE CRIMP HEIGHT AT NORMAL TERMINATOR SHUT HEIGHT

13

TERMINAL LUBRICANT IS RECOMMENDED.

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

REVISIONS

P

LTR

DESCRIPTION

DATE

DWN

APVD

B

ECR-13-001252

22JAN2013

RK

GB

-

-

1

-

-

2119957-2

APPLICATOR SHIM PACK

260

-

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

-

1

-

1

1

2119798-1

DETENT PIN

247

-

1

-

1

1

1-22279-3

SPRING, COMPRESSION

246

-

-

1

-

-

2119758-1

RAM, AMP STYLE, SIDE FEED, NON-ADJ.

245

-

1

1

1

1

2119082-9

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

-

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

2063440-2

AIR FEED MODULE

238

-

-

1

1

-

2119740-2

TAG,IDENTIFICATION

213

-

-

1

1

-

1901094-3

SPACER, FEEDER

198

-

1

1

1

1

9931111-1

PIN, SLOTTED SPRING 3.0 X 20.0

177

-

1

1

1

1

8-22280-7

SPRING, COMPRESSION

176

-

1

1

1

1

1752353-2

GUIDE PIN,HOLDDOWN

175

-

1

1

1

1

1901680-2

GUIDE PIN,HOLDDOWN

174

-

-

-

-

2

21045-3

RING, RETAIN, EXTERN, 3/16 CRESCENT

172

-

1

1

1

1

994969-1

MAGNET, RARE EARTH HIGH ENERGY

166

-

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

-

-

1

1

-

1633743-1

SERVO FEED LATCH ASM

133

-

1

1

1

1

318563-1

GUARD, FRONT CHIP

119

-

-

REF

REF

-

2119944-1

FEED FINGER ASSEMBLY,SF

117

-

1

1

1

1

455888-6

SPACER, CRIMPER

82

-

1

1

1

1

2119956-1

DOCUMENTATION PACKAGE

71

-

1

-

-

1

2119740-1

TAG,IDENTIFICATION

67

-

2

2

2

2

2168078-1

SCREW, DRIVE, RH, RoHS

66

-

1

-

1

1

2119793-1

LIMITER, ADJUSTMENT BOLT

63

-

3

-

3

3

992763-5

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

62

-

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

1338685-1

PAWL, FEED

56

-

4

4

4

4

2168400-1

SHCS, LOW HEAD, RoHS, M4 X 12

54

-

1

1

1

1

1-5018030-0

NUT, HEX, REG, RoHS, M3.5

52

-

1

1

1

1

1901681-9

HOLDDOWN, TERMINAL

51

-

1

1

1

1

2-1752354-5

STANDOFF,HOLD-DOWN

50

-

-

-

-

1

18023-9

SCR, SKT HD CAP M4 X 6.0

49

-

1

1

1

1

2119656-9

APPLICATOR BASIC ASSEMBLY, SF

46

-

1

-

1

1

2119370-1

RAM, AMP STYLE, SIDE FEED

44

-

1

1

1

1

2079383-7

SCR, BHSC, RoHS (M8 X 25)

41

-

1

-

1

1

2119645-1

DISC, NUMBERED FA WIRE ADJUSTMENT

40

-

1

-

1

1

2119957-1

APPLICATOR SHIM PACK

39

-

1

1

1

1

2119644-1

RAM WASHER, PRECISION

38

-

1

1

1

1

2119085-1

FA HEAD, ATLANTIC STYLE

37

-

1

-

1

1

2119092-1

BOLT, ADJUSTMENT

35

-

1

1

1

1

1-1752356-8

SUPPORT, TERMINAL

34

-

2

2

2

2

2079383-5

SCR, BHSC, RoHS (M4 X 20)

33

-

1

1

1

1

2161328-1

HEX HEAD, FLANGED, M5 x 8mm LONG

32

-

1

1

1

1

1-1320908-2

SPACER, STRIP GUIDE

30

-

1

1

1

1

2119959-1

ASSEMBLY, STRIP GUIDE

29

-

1

1

1

1

1-455888-0

SPACER, CRIMPER

28

-

1

1

1

1

1320928-2

STRIP GUIDE

24

-

1

1

1

1

2168083-2

SCR, SKT HD CAP, RoHS, M4 X 8.0

21

-

1

1

1

1

1-18028-2

WASHER, FLAT, REG M4

20

-

1

1

1

1

2119533-1

STRIPPER, SIDE FEED

19

-

1

1

1

1

2119806-1

INSERT, SHEAR

13

-

1

1

1

1

3-22280-3

SPRING, COMPRESSION

12

-

1

1

1

1

1-356885-4

STOP, SHEAR

11

-

1

1

1

1

2119805-1

SHEAR HOLDER, FRONT

10

-

1

1

1

1

454276-5

FLOATING SHEAR, FRONT

9

-

1

1

1

1

1338696-1

ANVIL, COMBINATION

8

-

1

1

1

1

2119757-8

DEPRESSOR, SHEAR

5

-

1

1

1

1

2-238011-2

BLOCK, CRIMPER SPACER

4

-

1

1

1

1

1633963-2

CRIMPER, INSULATION OVERLAP PREMIUM

3

-

1

1

1

1

1-455888-0

SPACER, CRIMPER

2

-

1

1

1

1

6-456408-0

CRIMPER, WIRE PREMIUM

1

-77

-7

-6

-5

-2

PART NO

DESCRIPTION

ITEM NO

THE FOLLOWING IS A SUMMARY OF THE INFORMATION CONTAINED IN THIS DRAWING. IT IS SUBJECT TO CHANGE WITHOUT NOTICE AND WITHOUT LIABILITY TO THE ORGANIZATION THAT IT IS ISSUED BY. FOR THE LATEST REVISIONS, SEE THE DRAWING REVISIONS.

OWN

S. ZOU

02JUN2011

CHK

G. BAILEY

02JUN2011

APVD

S. XI

02JUN2011

NAME

Ocean Side Feed Applicator

SIZE

CAGE CODE

DRAWING NO

RESTRICTED TO

00779

©=2151107

Customer Accessible Production Drawing

SCALE

1:2

SHEET

1

OF

4

REV

B

DIMENSIONS:

mm

0 PLC

1 PLC

2 PLC

3 PLC

4 PLC

ANGLES

FINISH

±

±0.5

±0.13

±0.013

±0.0001

±

MATERIAL

-

AMP 4805 REV 31MAR2000

8

7

6

5

4

3

2

1

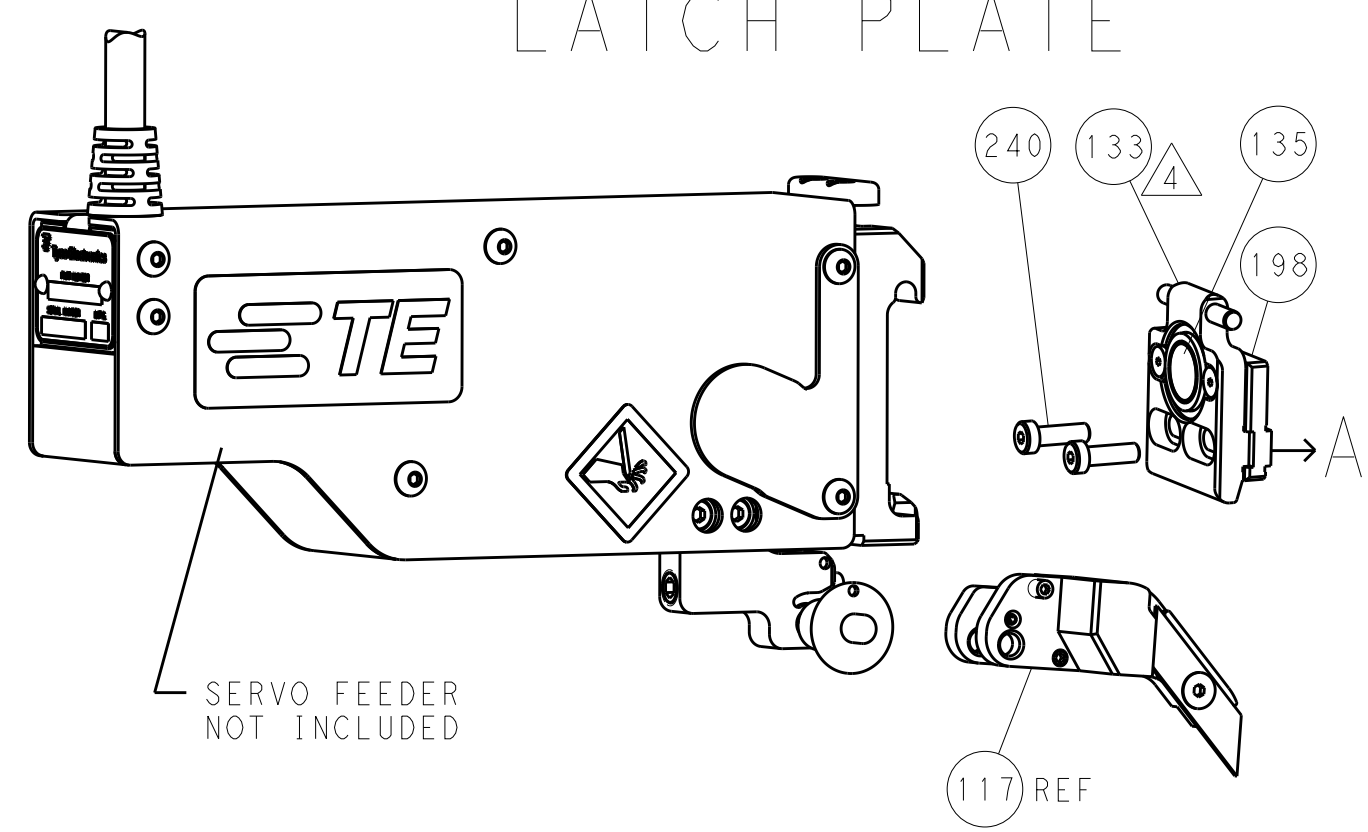
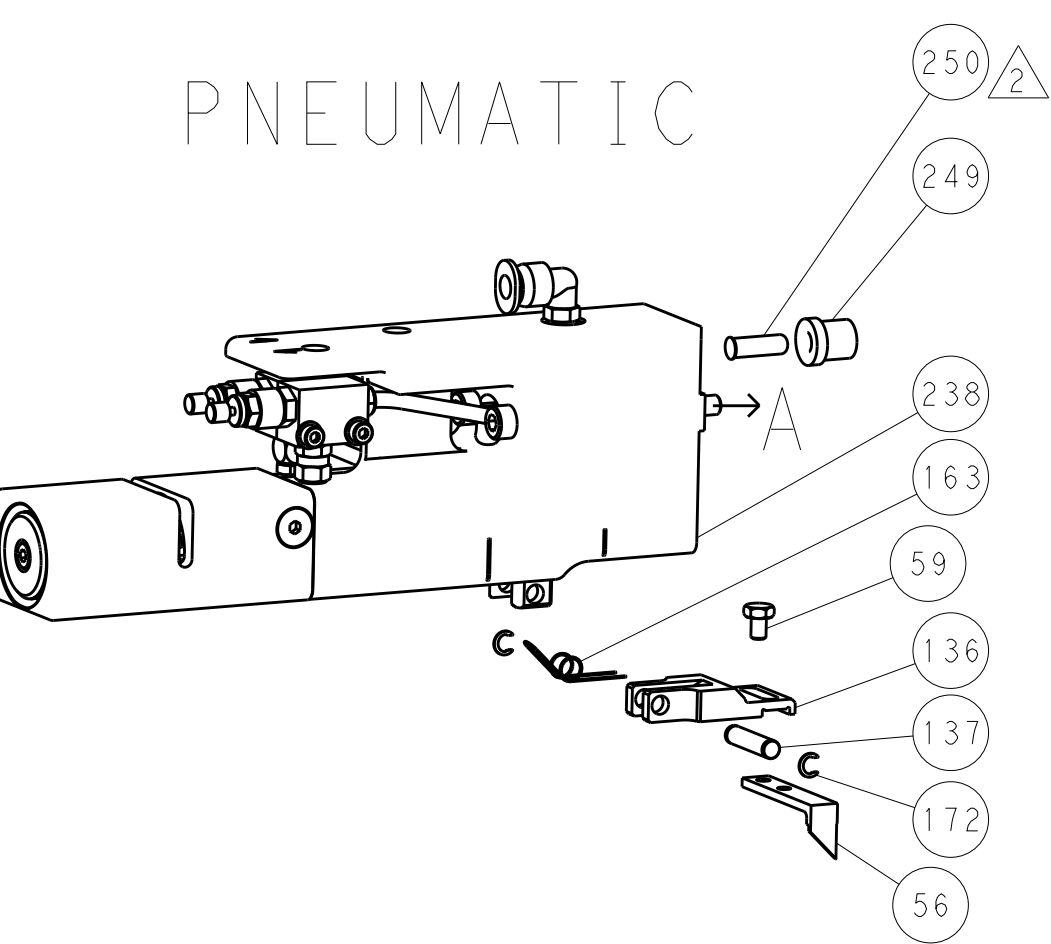
LOC	DIST	REVISIONS					
		P	LTR	DESCRIPTION	DATE	DWN	APVD
A	66	-	-	SEE SHEET 1	-	-	-

DIMENSIONING AND TOLERANCING PER ASME Y14.5M-2003

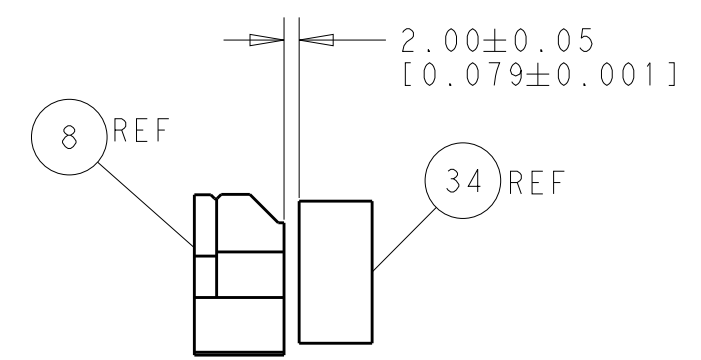
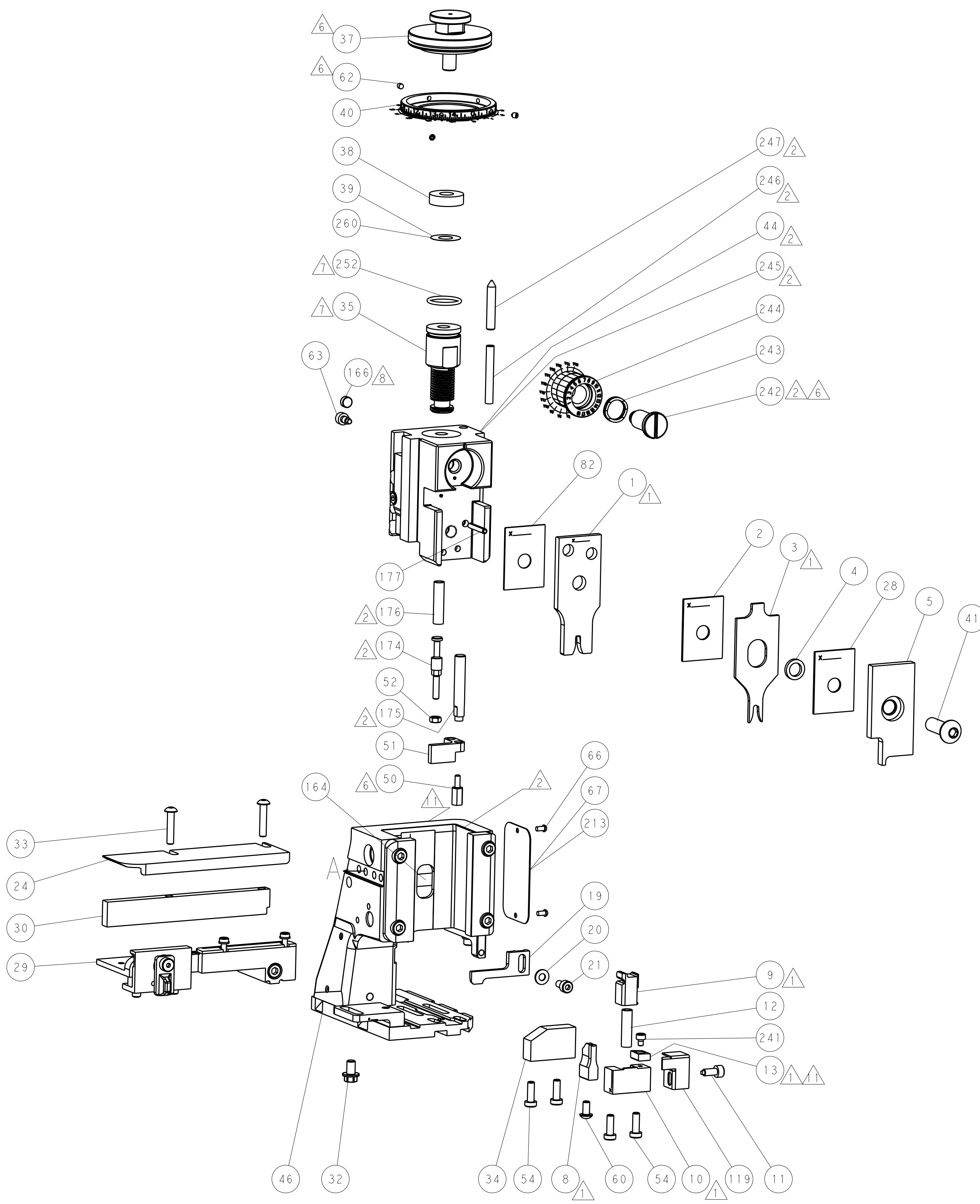
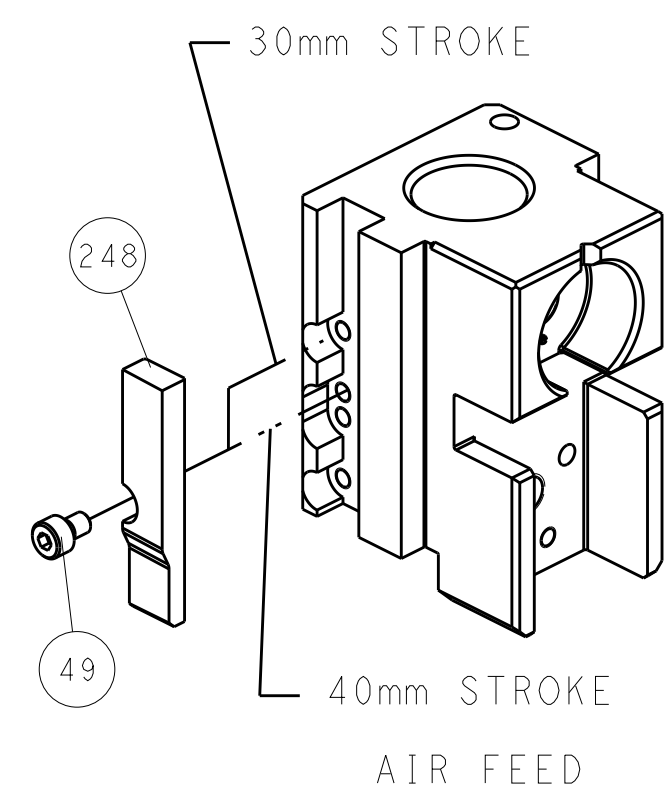
FEED TYPE

PNEUMATIC

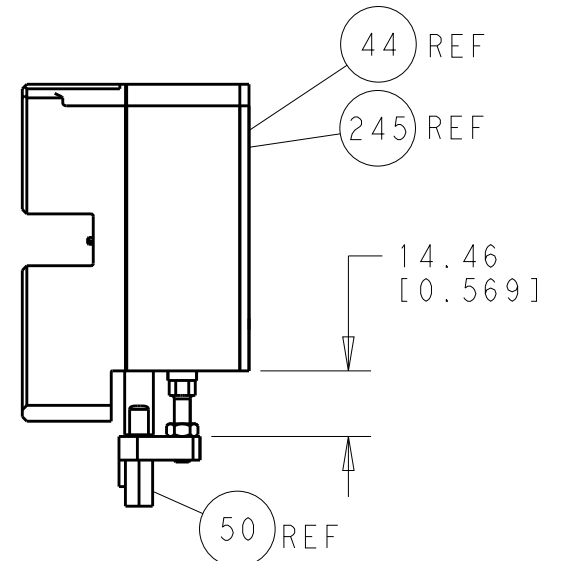
SERVO LATCH PLATE



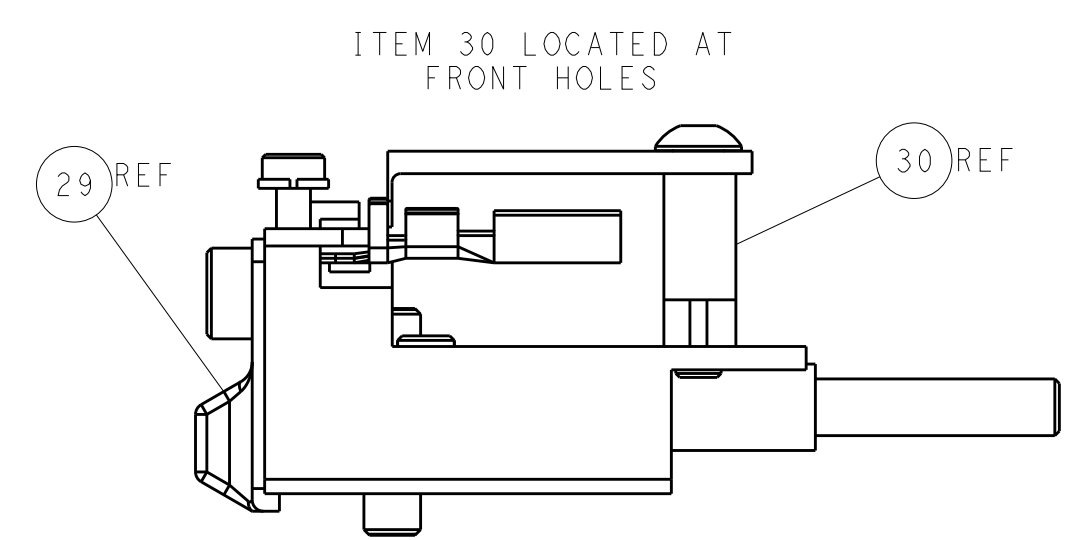
CAM POSITION



TERMINAL SUPPORT LOCATION



HOLDDOWN SET-UP



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		CHK G. BAILEY 02JUN2011	NAME Ocean Side Feed Applicator	
TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.5 1 PLC ±0.13 2 PLC ±0.13 3 PLC ±0.13 4 PLC ±0.0001 ANGLES ±.5		APVD S. XI 02JUN2011	SIZE A1	
MATERIAL -		PRODUCT SPEC -	CAGE CODE 00779	
FINISH -		APPLICATION SPEC -	DRAWING NO 2151107	
-		WEIGHT -	Customer Accessible Production Drawing	
-		SCALE 1:2	SHEET 2 OF 4	
-		REV B	REV B	

SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

8

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4

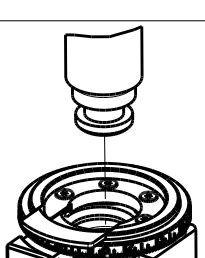
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	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART						
					CONVERT TO	PART NUMBERS REQUIRED					
					-	-	1338685-1	5-18022-5	2119653-2	-	-
	2-2151107-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	SERVO LATCH PLATE	2119951-1	-	8-2151107-5	1901094-3	-	2168400-6 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2151107-4	-	-	-
					-	-	1338685-1	5-18022-5	2119653-2	-	-
					PNEUMATIC FEED	2119950-1	1338685-1	5-18022-5	2119641-2	2119799-1	2063440-2
					-	-	-	-	-	-	-
2-2151107-5	B	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE ⁴	-	-	-	-	-	-	-	
2-2151107-7	B	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	-	
7-2151107-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-	

DIMENSIONING AND TOLERANCING PER ASME Y14.5M-2013

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.79 mm [.110]	F
INSUL	3.55 mm [.140]	OV
APPLICATOR INSTRUCTIONS 408-10389		

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION			
TERMINAL NAME: POSITIVE LOCK RECEPTACLE			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
5.70-6.30 mm [.224-.248 IN]		Ø2.10-3.10 mm [.083-.122 IN]	
TERMINAL APPLICATION SPECIFICATION	114-18365	-	-
TERMINALS APPLIED ¹⁰ ¹³			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
927854-1	927854-2	927854-3	927854-6
927854-7	927854-8	927854-9	

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING ⁹
2.50mm2		2.04+/-0.05 [.080+/- .002]		6.6
2.00mm2		1.90+/-0.05 [.075+/- .002]		8.4
1.50mm2		1.76+/-0.05 [.069+/- .002]		10.1



- 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: 8-2151107-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151107-5
SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2151107-6
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 50, 62 & 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 TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- 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.
- ¹³ TERMINAL LUBRICANT IS RECOMMENDED.

SET UP GAUGE 2119599-1	LOC A	DIST 66	REVISIONS			
			P	LTR	DESCRIPTION	DATE
				-	SEE SHEET 1	-

-	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	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244
⁶	-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
	-	1	1	2119083-1	RETAINER, INSULATION DIAL	242
	-	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
	-	-	2	2168400-6	SHCS, LOW HEAD, RoHS, M5 X 16	240
	-	-	-	2063440-2	AIR FEED MODULE	238
	-	-	1	2119740-2	TAG,IDENTIFICATION	213
	-	-	1	1901094-3	SPACER, FEEDER	198
	-	1	1	993111-1	PIN, SLOTTED SPRING 3.0 X 20.0	177
	-	1	1	8-22280-7	SPRING, COMPRESSION	176
	-	1	1	1752353-2	GUIDE PIN,HOLDDOWN	175
	-	1	1	1901680-2	GUIDE PIN,HOLDDOWN	174
	-	-	2	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172
	-	1	1	994969-1	MAGNET, RARE EARTH HIGH ENERGY	166
	-	REF	REF	994970-2	COUNTER, MAGNETIC	164
	-	-	-	240638-1	SPRING, FEED FINGER	163
	-	1	1	8-21084-1	O-RING, .801 ID, .070 DIA. MAT.	152
	-	-	-	2119641-2	FEED CAM, AIR FEED	151
	-	1	1	2119798-2	DETENT PIN	145
	-	1	1	2079383-8	SCR, BHSC, RoHS (M4 X 16)	144
	-	4	4	2168400-5	SHCS, LOW HEAD, RoHS, M4 X 20	143
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	-	1	1	2119092-2	BOLT, ADJUSTMENT	139
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⁶	-	1	1	2119793-1	LIMITER, ADJUSTMENT BOLT	63
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	-	-	-	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
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⁶	-	1	1	2-1752354-5	STANDOFF,HOLD-DOWN	50
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	-	1	1	2119644-1	RAM WASHER, PRECISION	38
	-	1	1	1-1752356-8	SUPPORT, TERMINAL	34
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	-	1	1	1-1320908-2	SPACER, STRIP GUIDE	30
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	-	1	1	1-455888-0	SPACER, CRIMPER	28
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¹	-	1	1	2119806-1	INSERT, SHEAR	13
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	-	1	1	1-356885-4	STOP, SHEAR	11
¹	-	1	1	2119805-1	SHEAR HOLDER, FRONT	10
¹	-	1	1	454276-5	FLOATING SHEAR, FRONT	9
¹	1	1	1	1338696-1	ANVIL, COMBINATION	8
	-	1	1	2119757-8	DEPRESSOR, SHEAR	5
	-	1	1	2-238011-2	BLOCK, CRIMPER SPACER	4
¹	1	1	1	1633963-2	CRIMPER, INSULATION OVERLAP PREMIUM	3
	-	1	1	1-455888-0	SPACER, CRIMPER	2
¹	1	1	1	6-456408-0	CRIMPER, WIRE PREMIUM	1
	-77	-27	-25	-22	PART NO	ITEM NO
					DESCRIPTION	

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		CHK G. BAILEY 02JUN2011			APVD S. XI 02JUN2011				
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.5 1 PLC ±0.13 3 PLC ±0.013 4 PLC ±0.0001 ANGLES ±.5		NAME Ocean Side Feed Applicator -					
		PRODUCT SPEC -							
MATERIAL -		APPLICATION SPEC -		SIZE A1	CAGE CODE 00779	DRAWING NO C=2151107	RESTRICTED TO -		
FINISH -		WEIGHT -							
		Customer Accessible Production Drawing				SCALE 1:2	SHEET 3	OF 4	REV B

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

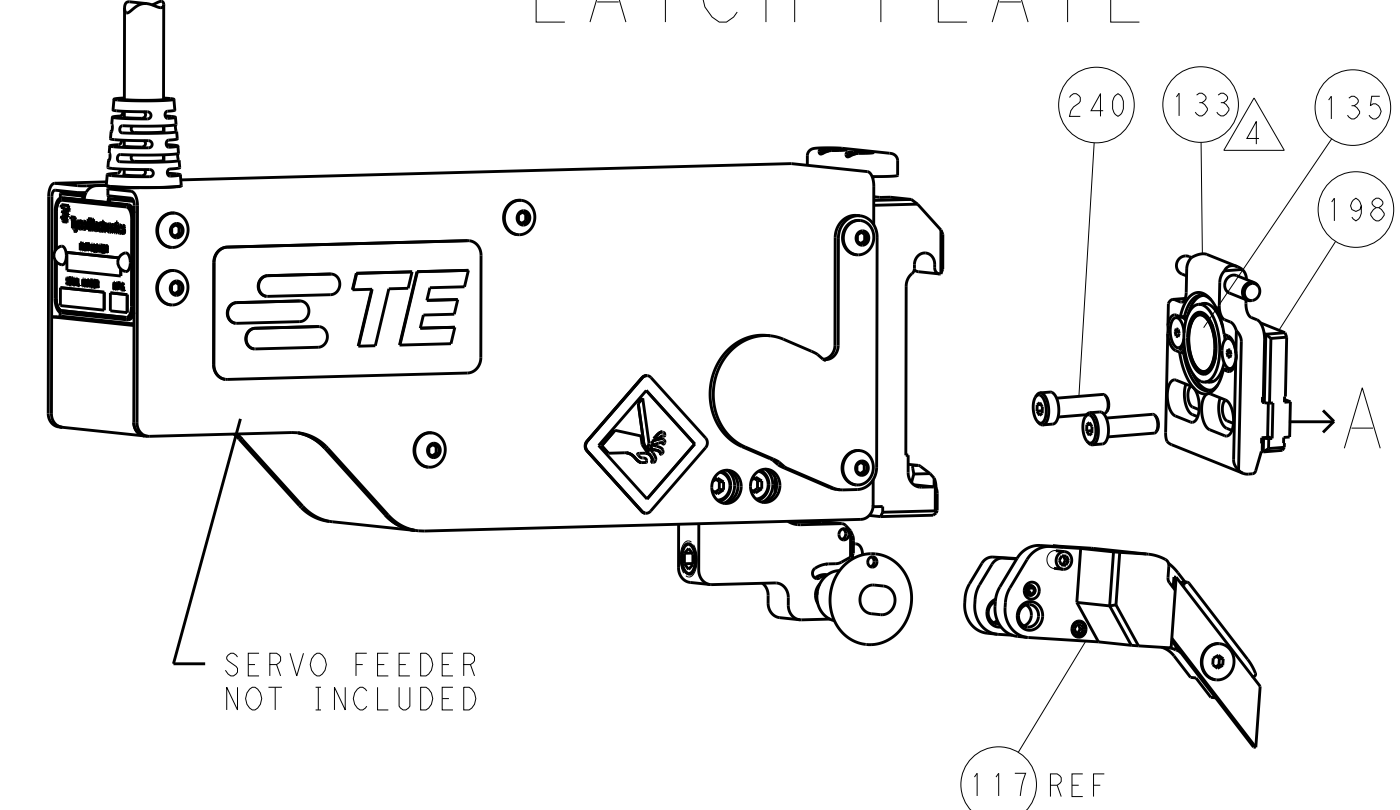
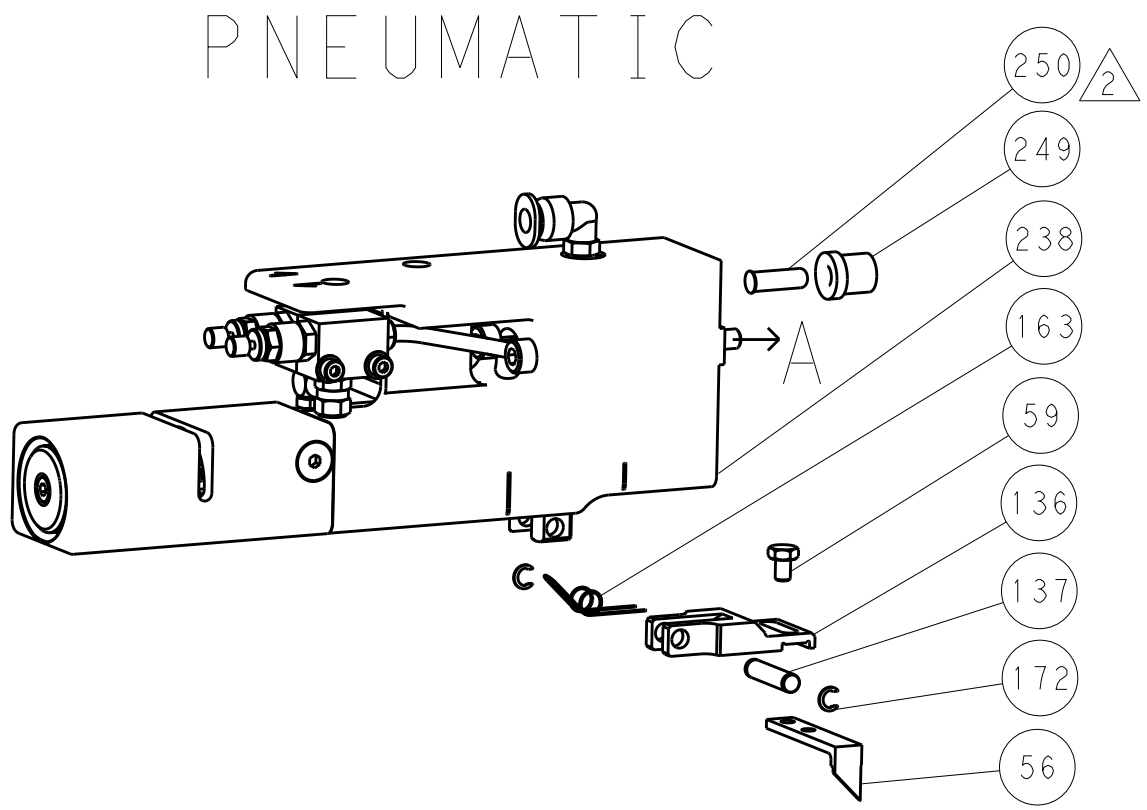
LOC	DIST	REVISIONS					
		P	LTR	DESCRIPTION	DATE	DWN	APVD
A	66	-	-	SEE SHEET 1	-	-	-

DIMENSIONING AND TOLERANCING PER ASME Y14.5M-2003

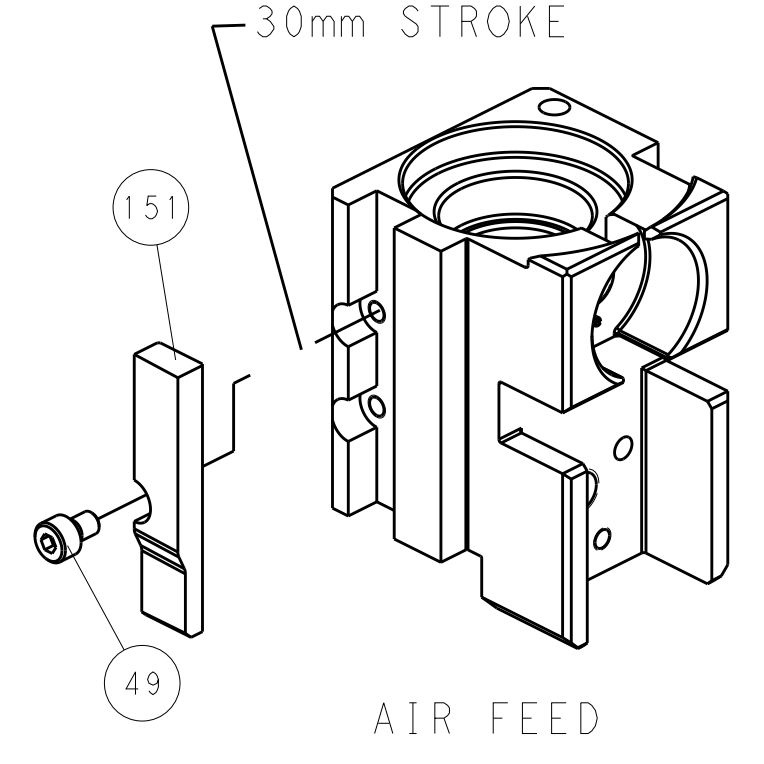
FEED TYPE

PNEUMATIC

SERVO LATCH PLATE



CAM POSITION



AIR FEED

