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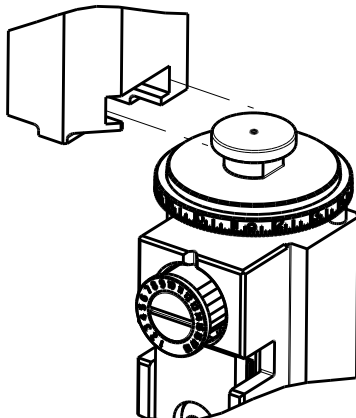
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ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION
	2151539-1	N	FINE CRIMP HEIGHT ADJUST
	2151539-2	N	FINE CRIMP HEIGHT ADJUST
	2151539-5	N	FINE CRIMP HEIGHT ADJUST
	2151539-6	N	NON-CRIMP HEIGHT ADJUST
	2151539-7	N	FINE CRIMP HEIGHT ADJUST
	7-2151539-7	L	CRIMP TOOLING KIT

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.78 mm [.070]	F
INSUL	1.73 mm [.068]	SP
APPLICATOR INSTRUCTIONS 408-10389		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: GET 0.64mm PIN AND SOCKET CONTACTS			
WIRE STRIP LENGTH 4.40 mm [.173 IN]		INSULATION DIAMETER RANGE Ø1.40-2.06 mm [.055-.081 IN]	
TERMINAL APPLICATION SPECIFICATION 		114-13060 - -	
TERMINALS APPLIED 			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
1393366-1	1393365-1	1438299-3	1438299-4
1393366-2	1393365-2	1438299-6	1-1438299-1

WIRE SIZE			CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING	9
18 AWG			1.12 $\pm$ 0.04 [0.044 $\pm$ 0.0016]		7.0	
0.75mm ²			1.10 $\pm$ 0.04 [0.043 $\pm$ 0.0016]		7.1	
0.50mm ²			1.02 $\pm$ 0.04 [0.040 $\pm$ 0.0016]		8.1	
20 AWG			1.02 $\pm$ 0.04 [0.040 $\pm$ 0.0016]		8.1	



 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: 8-2151539-4
	PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151539-4
	SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151539-5
	SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2151539-6

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.
APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242.
FOR -6 ONLY APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 37 & 50.

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 -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 REAR STRIP GUIDE MUST BE ADJUSTED WHEN SWITCHING TERMINALS.

 USE ITEM 34, WHEN CRIMPING MALE TERMINALS.

15 USE ITEM 261, WHEN CRIMPING FEMALE TERMINALS.

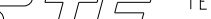
	5		4			
APPLICATOR STYLE CONVERSION CHART						
CONVERT TO	PART NUMBERS REQUIRED					
PNEUMATIC FEED	2119950-1	1338685-1	5-18022-5	2119641-1	2119799-1	20634
SERVO LATCH PLATE	2119951-1	-	8-2151539-5	1901094-3	-	2168400-6 (Q)
SMART APPLICATOR	2161326-1	-	8-2151539-4	-	-	-
MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-1	-	-
SERVO LATCH PLATE	2119951-1	-	8-2151539-5	1901094-3	-	2168400-6 (Q)
SMART APPLICATOR	2161326-1	-	8-2151539-4	-	-	-
MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-1	-	-
PNEUMATIC FEED	2119950-1	1338685-1	5-18022-5	2119641-1	2119799-1	20634
-	-	-	-	-	-	-
-	-	-	-	-	-	-
-	-	-	-	-	-	-
-	-	-	-	-	-	-

4	-	1	1	1	1	1	1-1752356-8	SUPPORT, TERMINAL	261
	-	-	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
5	-	1	-	1	1	1	2119798-1	DETENT PIN	247
	-	1	-	1	1	1	1-22279-3	SPRING, COMPRESSION	246
	-	-	1	-	-	-	2119758-1	RAM, AMP STYLE, SIDE FEED, NON-ADJ.	245
	-	1	1	1	1	1	2119082-7	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
6	-	1	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	2119580-1	MECHANICAL FEED ASSEMBLY	239
	-77	-7	-6	-5	-2	-1	PART NO	DESCRIPTION	ITEM NO

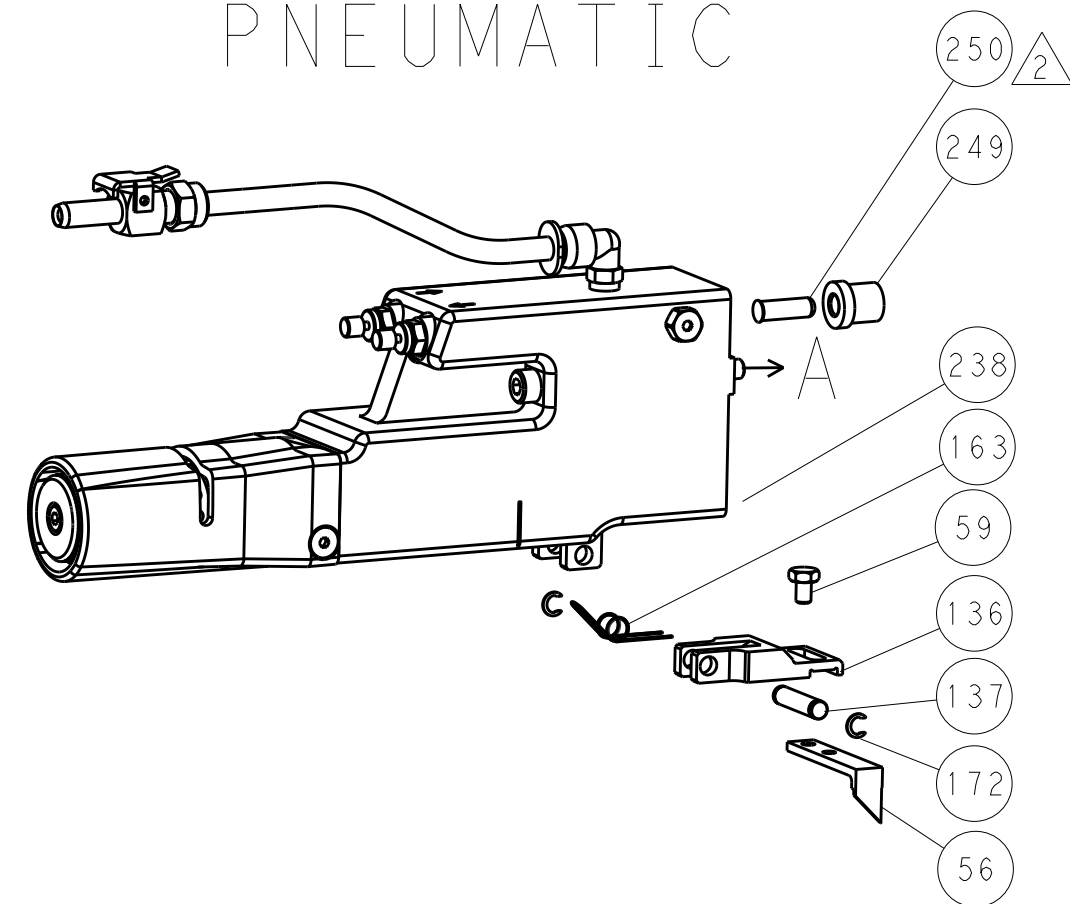
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

2				1				
SET UP GAUGE 2119599-1		LOC A	DIST 66	REVISIONS				
P	LYR	DESCRIPTION			DATE	OWN	APVD	
	L	ECR-16-008691			15JUN2016	MR	JDG	
	L1	ECR-16-010290			15JUL2016	MEH	JDG	
	M	ECR-16-015082			25OCT2016	YY	CT	
	N	ECR-16-015962			11NOV2016	MZ	KZ	

	-	-	-	-	-	2063440-1	AIR FEED MODULE	238
	-	-	1	1	-	2119740-2	TAG, IDENTIFICATION	213
	-	-	1	1	-	1901094-3	SPACER, FEEDER	198
	-	1	1	1	1	993111-1	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
8	-	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	133
	-	-	REF	REF	-	SEE NOTE 4	MEMORY CHIP, PROGRAMMED	133
	-	-	1	1	-	1633743-1	SERVO FEED LATCH ASM	133
	-	1	1	1	1	1-22281-8	SPRING, COMPRESSION	121
	-	1	1	1	1	1-18028-2	WASHER, FLAT, REG M4	119
	-	-	REF	REF	-	2119944-1	FEED FINGER ASSEMBLY,SF	117
	-	1	1	1	1	2-690438-2	FRONT STRIP GUIDE	96
	-	2	2	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	95
	-	1	1	1	1	2168083-6	SCR, SKT HD CAP, RoHS, M5 X 65	93
	-	1	1	1	1	455888-8	SPACER, CRIMPER	82
	-	1	1	1	1	2119956-1	DOCUMENTATION PACKAGE	71
	-	1	1	1	1	2119791-9	DEPRESSOR, WIRE	70
	-	1	-	-	1	2119740-1	TAG,IDENTIFICATION	67
	-	2	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
6	-	1	-	1	1	2119793-1	LIMITER, ADJUSTMENT BOLT	63
	-	3	-	3	3	992763-5	SCR, SET, SOC, CONE POINT, M3 X 4.0	62
	-	2	2	2	2	2-18032-5	SCR, SET, FLT POINT M5 X 20.0	61
	-	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
6	-	1	1	1	1	1901681-5	HOLDDOWN, TERMINAL	51
	-	1	1	1	1	1-1752354-6	STANDOFF,HOLD-DOWN	50
	-	-	-	-	1	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	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
6	-	1	1	1	1	2119644-1	RAM WASHER, PRECISION	38
	-	1	1	1	1	2119085-1	FA HEAD, ATLANTIC STYLE	37
4	-	1	-	1	1	2119092-1	BOLT, ADJUSTMENT	35
	-	1	1	1	1	1752356-6	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	1320908-6	SPACER, STRIP GUIDE	30
	-	1	1	1	1	1901086-5	PLATE, STRIP GUIDE	29
	-	2	2	2	2	22281-8	SPRING, COMPRESSION	27
	-	1	1	1	1	356835-1	LEVER, DRAG RELEASE	26
	-	1	1	1	1	217233-1	DRAG, STOCK	25
	-	1	1	1	1	1320928-6	STRIP GUIDE	24
	-	1	1	1	1	980371-4	SCR, SKT HD SHLDR 5.0 DIA X 6.0	23
	-	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	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	1-356885-4	STOP, SHEAR	11
1	-	1	1	1	1	2119805-1	SHEAR HOLDER, FRONT	10
1	-	1	1	1	1	318707-1	FLOATING SHEAR, FRONT	9
1	1	1	1	1	1	133231-1	ANVIL, COMBINATION, SPECIAL	8
	-	-	-	-	-	-	-	7
	-	-	-	-	-	-	-	6
	-	1	1	1	1	2119757-8	DEPRESSOR, SHEAR	5
1	-	1	1	1	1	3-238011-5	BLOCK, CRIMPER SPACER	4
	1	1	1	1	1	2-1633989-1	CRIMPER, INSULATION, SPECIAL	3
	-	1	1	1	1	455888-1	SPACER, CRIMPER	2
1	1	1	1	1	1	5-562108-2	CRIMPER, WIRE, F	1
	-77	-7	-6	-5	-2	-1	PART NO	ITEM NO

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DIMENSIONS:		TOLERANCES, UNLESS OTHERWISE SPECIFIED:		NAME	
mm		0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± ANGLES ±		Ocean Side Feed Applicator	
		FINISH		SIZE CAGE CODE DRAWING NO	
MATERIAL		WEIGHT		RESTRICTED TO	
-		-		A 00779 C=2151539	
Customer Accessible Processing		SCALE 1:2		SHEET 1 OF 4 REV N	

PNEUMATIC



LATCH PLATE

SERVO FEEDER
NOT INCLUDED

240 133 135 198 4 A

117 REF

30mm STROKE

47

49

40mm STROKE

MECHANICAL POST FEED

30mm STROKE

48

49

40mm STROKE

MECHANICAL PRE FEED

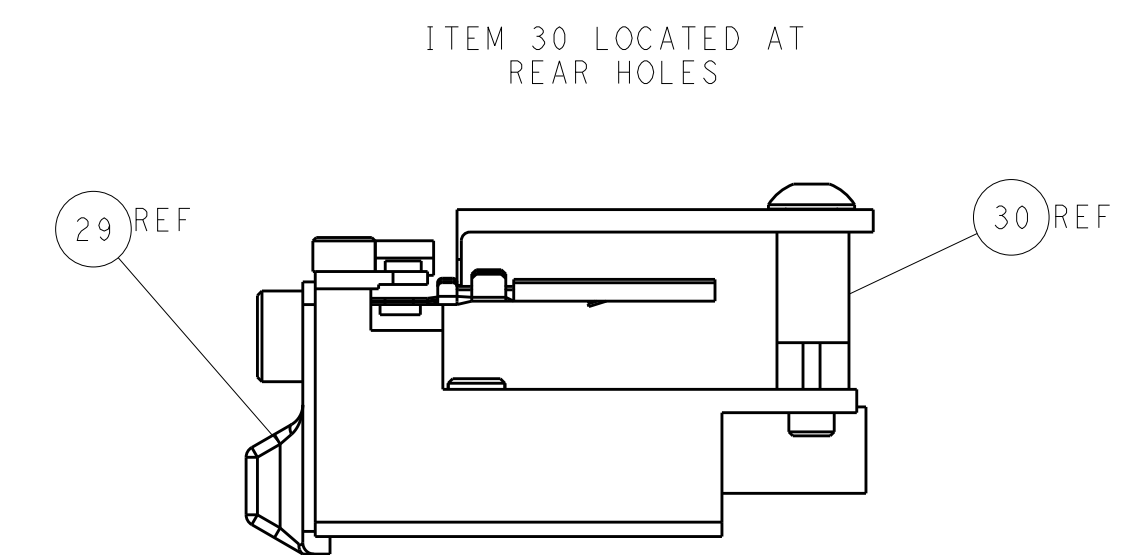
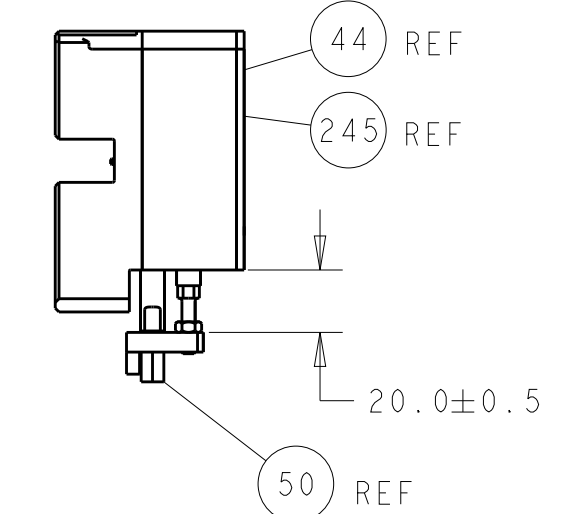
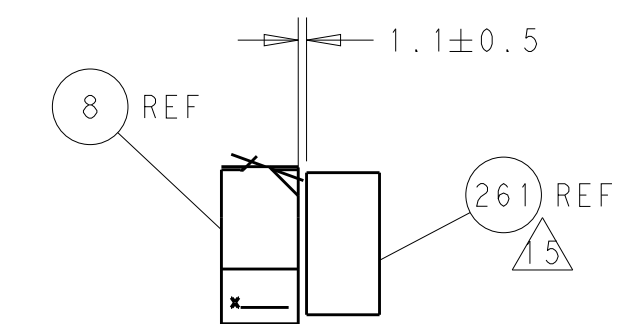
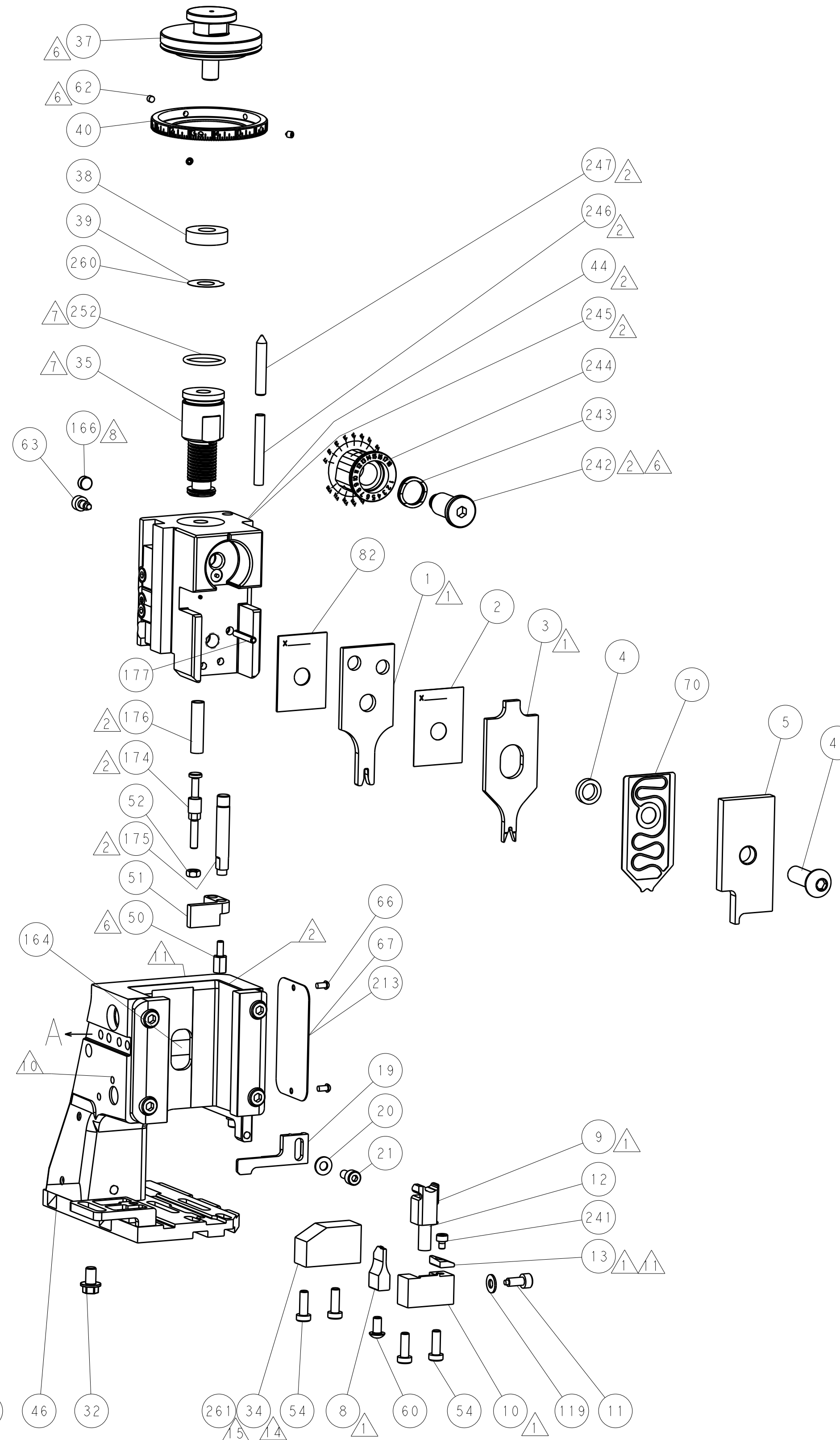
30mm STROKE

248

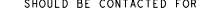
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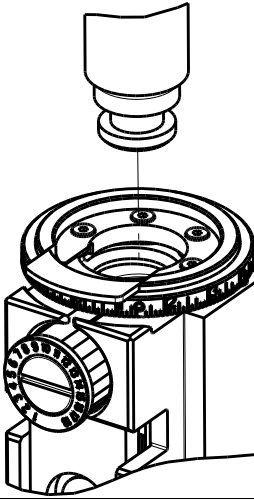
40mm STROKE

AIR FEED



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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		CHK T ELBIN	20DEC2012				
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:	NAME	Ocean Side Feed Applicator			
mm			APVD T ELBIN				
	0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±	PRODUCT SPEC -	APPLICATION SPEC -				
MATERIAL	FINISH	WEIGHT	SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO	
-	-	-	A	00779	C=2151539	-	
Customer Accessible Production Drawing				SCALE	1:2	SHEET	2 of 4
				REV N			

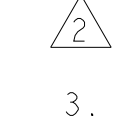
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PACIFIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION
	2-2151539-1	N	FINE CRIMP HEIGHT ADJUST
	2-2151539-2	N	FINE CRIMP HEIGHT ADJUST
	2-2151539-5	N	FINE CRIMP HEIGHT ADJUST
	2-2151539-7	N	FINE CRIMP HEIGHT ADJUST
	7-2151539-7	L	CRIMP TOOLING KIT

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.78 mm [.070]	F
INSUL	1.73 mm [.068]	SP
APPLICATOR INSTRUCTIONS 408-10389		

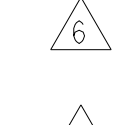
TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: GET 0.64mm PIN AND SOCKET CONTACTS			
WIRE STRIP LENGTH 4.40 mm [.173 IN]			INSULATION DIAMETER RANGE Ø1.40-2.06 mm [.055-.081 IN]
TERMINAL APPLICATION SPECIFICATION 	114-13060	-	-
TERMINALS APPLIED 			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
1393366-1	1393365-1	1438299-3	1438299-4
1393366-2	1393365-2	1438299-6	1-1438299-1

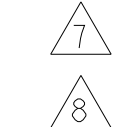
WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
18 AWG	1.12+/-0.04 [.044+/- .0016]	7.0
0.75mm2	1.10+/-0.04 [.043+/- .0016]	7.1
0.50mm2	1.02+/-0.04 [.040+/- .0016]	8.1
20 AWG	1.02+/-0.04 [.040+/- .0016]	8.1

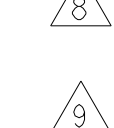
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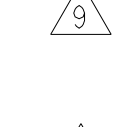
RECOMMENDED SPARE PARTS
- 

GREASE BEARING SURFACES LIGHTLY
3. LUBRICATE DAILY PER THE APPLICATOR INSTRUCTION SHEET SUPPLIED WITH THE APPLICATOR.
- 

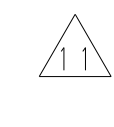
APPLICATOR SPECIFIC DATA TO BE ENTERED INTO BLANK MEMORY CHIP AT ASSEMBLY. SEE BELOW FOR PART NUMBER:
MECHANICAL FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151539-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151539-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151539-5
5. ADJUSTMENT OF THE STRIPPER MAY BE REQUIRED WHEN MOVING THE APPLICATOR BETWEEN BENCH AND LEADMAKER APPLICATIONS.
- 

APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 50 & 62.
APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242.
- 

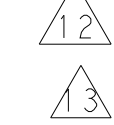
GREASE THREADS, GROOVE AND O-RING ON ITEMS 139 & 152.
- 

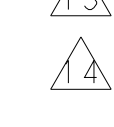
MAGNET MUST BE ORIENTED CORRECTLY IN ORDER TO PROPERLY ACTUATE THE COUNTER.
- 

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.
- 

SPARE FEED CAM STORAGE LOCATION REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.
- 

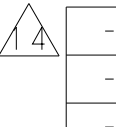
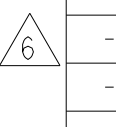
TO CONVERT THE APPLICATOR TO A NON-CARRIER CUTTING STYLE, REMOVE ITEM 13 AND ATTACH TO THE LOCATION ON BACK SIDE OF THE HOUSING. REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.
- 

REAR STRIP GUIDE MUST BE ADJUSTED WHEN SWITCHING TERMINALS.
- 

USE ITEM 34, WHEN CRIMPING MALE TERMINALS.
- 

USE ITEM 261, WHEN CRIMPING FEMALE TERMINALS.

*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	1	1-1752356-8	SUPPORT, TERMINAL	261
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SET UP GAUGE 2119599-1	LOC A	DIST 66	REVISIONS			
			P	LTR	DESCRIPTION	DATE
				-	SEE SHEET 1	-

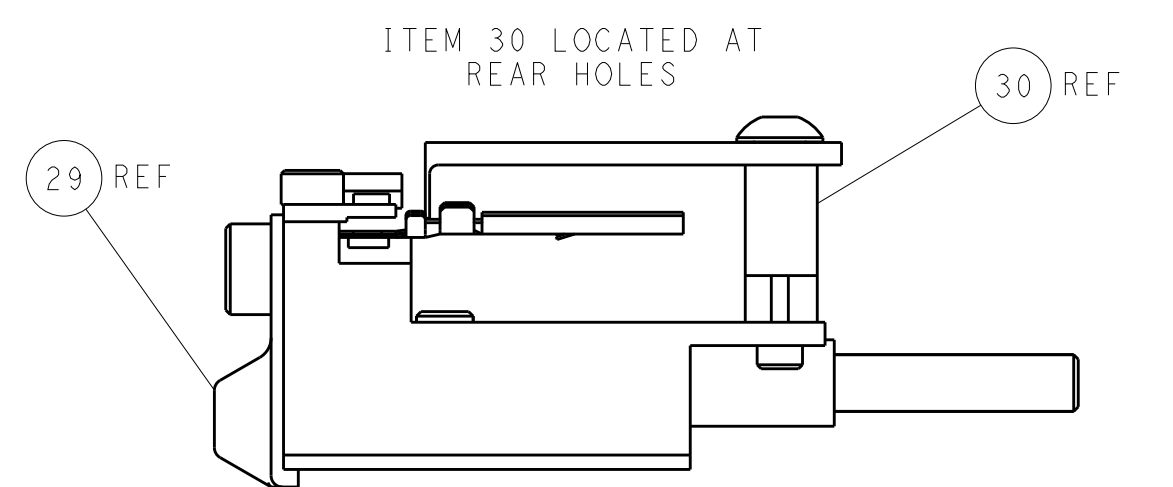
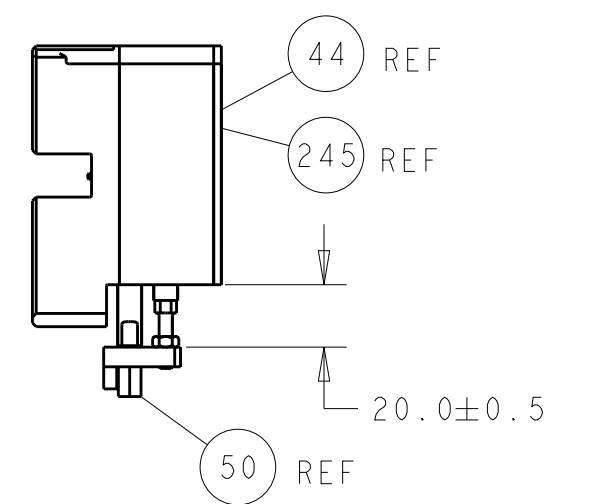
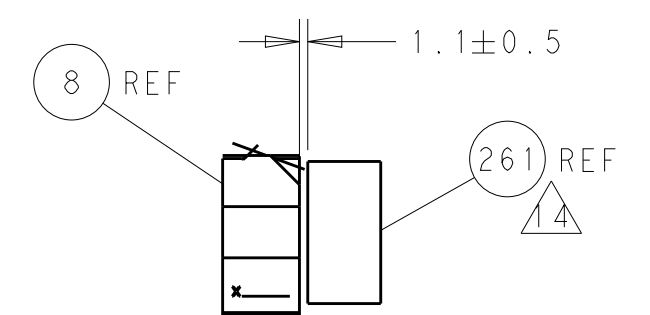
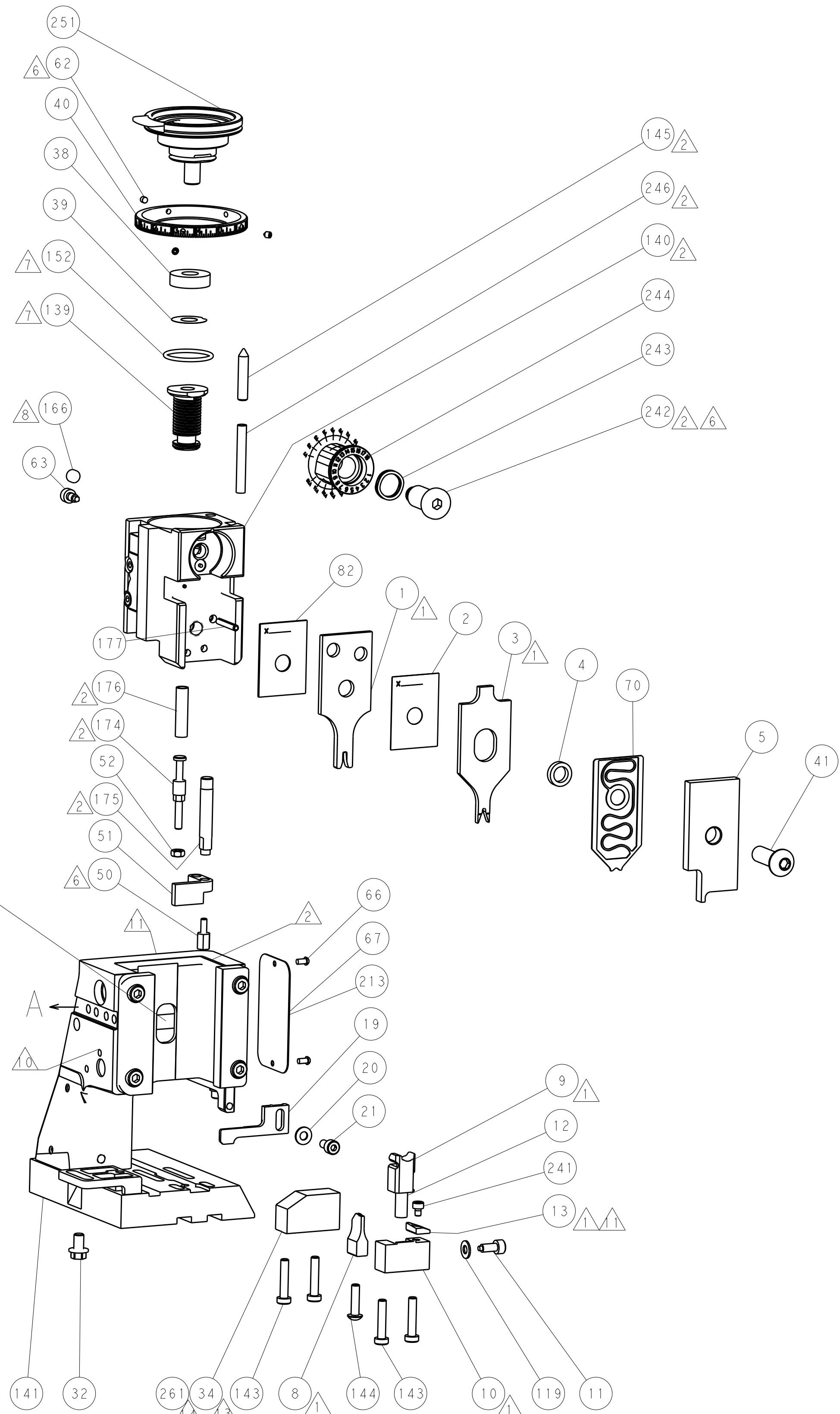
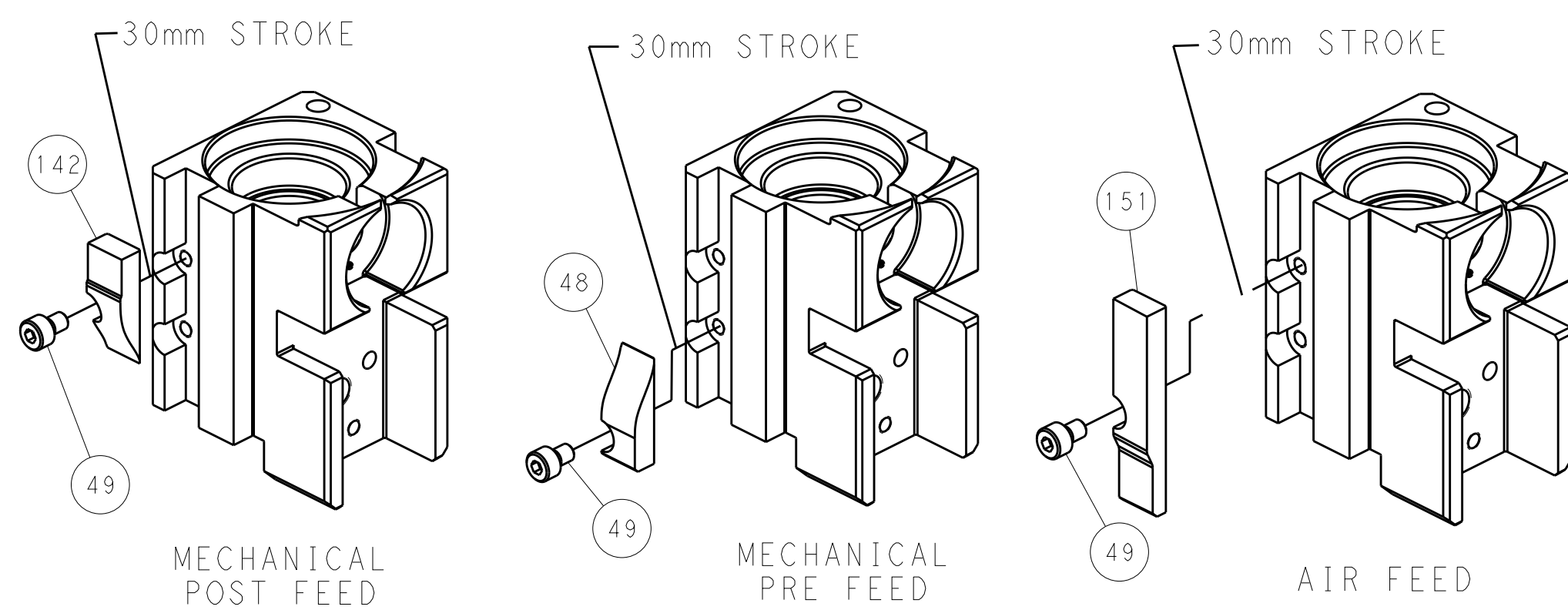
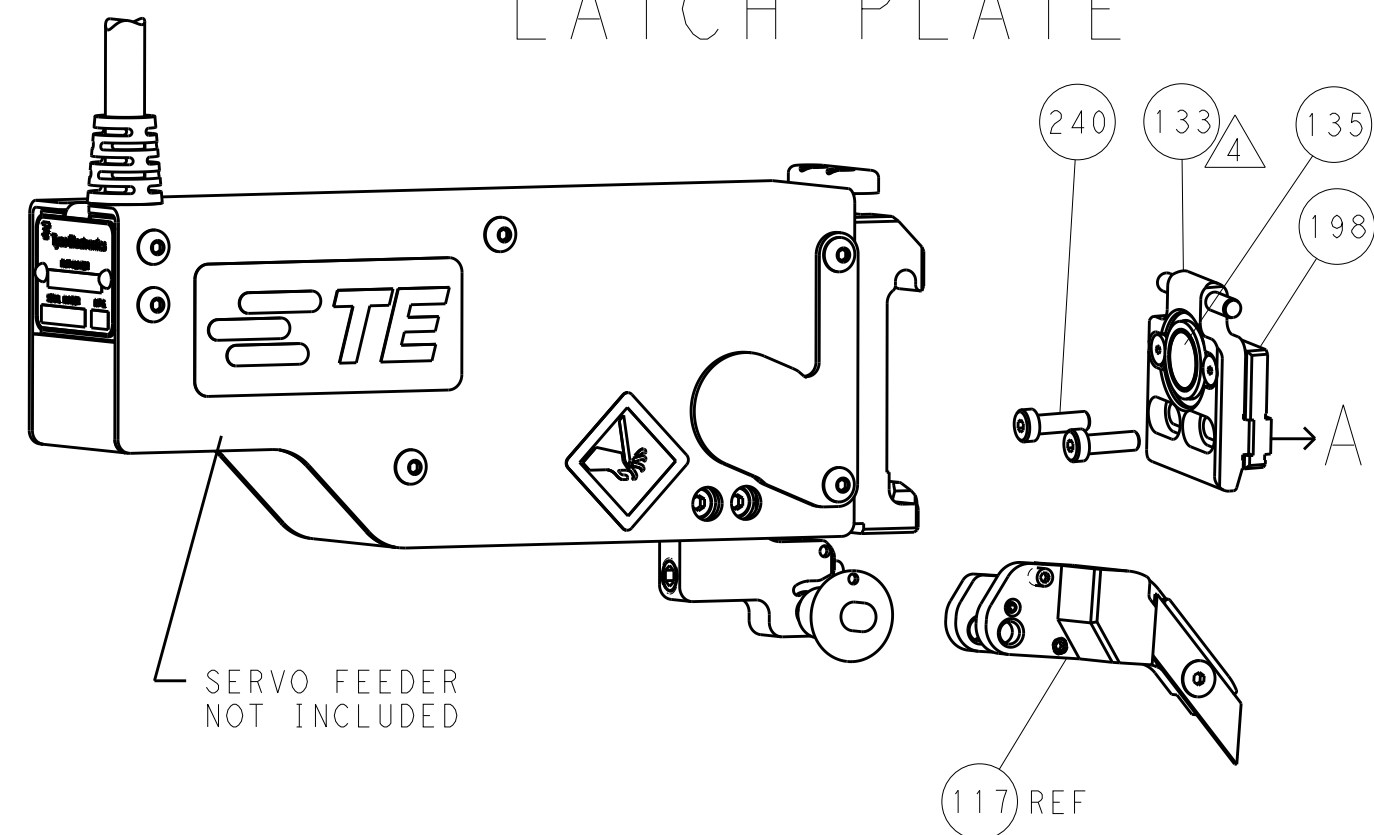
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DIMENSIONS: mm		CHK T. ELBIN	ZODEC2012	NAME Ocean Side Feed Applicator	
TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH		APVD T. ELBIN	ZODEC2012	SIZE CAGE CODE DRAWING NO 00779 ©=2151539	
MATERIAL		WEIGHT		RESTRICTED TO	
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Customer Accessible Production Drawing		SCALE		REV	
		1:2		3 of 4	

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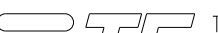
SERVO
LATCH PLATE

CAM POSITIONS



FEED TRACK POSITION GUIDE BY INSULATION BARREL

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

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DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		NAME Ocean Side Feed Applicator -	
		PRODUCT SPEC - APPLICATION SPEC -		SIZE A	
MATERIAL - FINISH -		WEIGHT -		CAGE CODE 00779	
				DRAWING NO C=2151539	
		Customer Accessible Production Drawing		SCALE 1:2 SHEET 4 OF 4 REV N	