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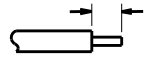
RELEASED FOR PUBLICATION

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ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION
	2151956-1	B	FINE CRIMP HEIGHT ADJUST
	2151956-2	B	FINE CRIMP HEIGHT ADJUST
	2151956-5	B	FINE CRIMP HEIGHT ADJUST
	2151956-6	B	NON-CRIMP HEIGHT ADJUST
	2151956-7	B	FINE CRIMP HEIGHT ADJUST
	7-2151956-7	A	CRIMP TOOLING KIT

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.98 mm [.078]	F
INSUL	3.70 mm [1.46]	O
APPLICATOR INSTRUCTIONS 408-10389		

TERMINAL DATA: SUMITOMO TERMINAL SUMITOMO CRIMP SPECIFICATION			
TERMINAL NAME: TERMINAL			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
4.40-5.20 mm [1.73-.205 IN]		Ø1.80-2.90 mm [1.071-.114 IN]	
TERMINAL APPLICATION SPECIFICATION	SUMITOMO SPEC Rev -	-	-
TERMINALS APPLIED			
TE TERMINAL	SUMITOMO TERMINAL	TE SEAL	SUMITOMO SEAL
1642775-1	1500-0105	1949371-1	7160-8234
		1949634-1	7165-0119

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING
1.25mm2		1.50+/-0.05 [1.059+/-0.002]		4.0
0.85mm2		1.40+/-0.05 [1.055+/-0.002]		4.9
0.50mm2		1.25+/-0.05 [1.049+/-0.002]		6.7
0.30mm2		1.10+/-0.05 [1.043+/-0.002]		8.6



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: 8-2151956-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151956-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151956-5
SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2151956-6

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

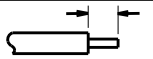
10 SPARE FEED CAM STORAGE LOCATION REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.

11 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 A NON CRIMP HEIGHT ADJUST APPLICATOR (-6) USE SHIMS FROM ITEM 260 TO ACHIEVE A NOMINAL SHIM HEIGHT OF 4.30.

13 THIS APPLICATOR APPLIES TERMINAL WITH A SEAL.

14 APPLY TORO-SEAL IN ALLEN SOCKET TO FILL HOLE AFTER FLAT HD HAS BEEN ADJUSTED TO CORRECT HEIGHT AT QUALIFICATION. APPLY #1-23419-5 LOC-TITE TO THREADS.

TERMINAL DATA: SUMITOMO TERMINAL SUMITOMO CRIMP SPECIFICATION			
TERMINAL NAME: TERMINAL			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
4.40-5.20 mm [1.73-.205 IN]		Ø1.80-2.90 mm [1.071-.114 IN]	
TERMINAL APPLICATION SPECIFICATION	SUMITOMO SPEC Rev -	-	-
TERMINALS APPLIED			
TE TERMINAL	SUMITOMO TERMINAL	TE SEAL	SUMITOMO SEAL
1832684-1	1500-0106	1949371-1	7160-8234
		1949634-1	7165-0119

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING
1.25mm2		1.30+/-0.05 [1.051+/-0.002]		5.2
0.85mm2		1.20+/-0.05 [1.047+/-0.002]		6.3
0.50mm2		1.10+/-0.05 [1.043+/-0.002]		7.6
0.30mm2		0.95+/-0.05 [1.037+/-0.002]		9.4

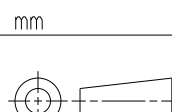
*WARNING
ON INSTALLATION, SET WIRE DISC, ITEM 40 TO LARGEST WIRE SIZE SETTING. USE OF SETTINGS BELOW MINIMUM REQUIRED CRIMP HEIGHT SETTING WILL CAUSE DAMAGE TO CRIMP TOOLING.

-	-	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
-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 2119599-1	LOC	DIST	REVISIONS					
	A	66	P	LTR	DESCRIPTION	DATE	DWN	APVD
				A	RELEASED	09JUL2013	CC	TE
				B	ECR-14-004337	24MAR2014	XZ	TE
				B1	ECR-15-007575	19MAY2015	RS	LZ

-	-	-	-	1	-	2079988-1	BUSHING, LCH5-12, MISUMI	249
-	-	-	-	1	-	2119641-1	FEED CAM, AIR FEED	248
-	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	2119082-8	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
-	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
-	-	-	-	1	-	2063440-1	AIR FEED MODULE	238
-	-	1	1	-	-	2119740-2	TAG,IDENTIFICATION	213
-	-	1	1	-	-	1901094-3	SPACER, FEEDER	198
-	-	-	-	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
-	-	-	-	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	1	1-18028-2	WASHER, FLAT, REG M4	119
-	-	REF	REF	-	-	2119944-1	FEED FINGER ASSEMBLY,SF	117
-	1	1	1	1	1	455888-4	SPACER, CRIMPER	82
-	1	1	1	1	1	2119956-1	DOCUMENTATION PACKAGE	71
-	1	-	-	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	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	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	1	1	1	1	1	985575-3	SCR, FLT SKT HD CAP M3 X 10.0	57
-	-	-	-	1	1	1338685-1	PAWL, FEED	56
-	4	4	4	4	4	2168400-1	SHCS, LOW HEAD, RoHS, M4 X 12	54
-	2	2	2	2	2	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	53
-	1	1	1	1	1	5018030-1	NUT, HEX, REG, RoHS, M3	52
-	1	1	1	1	1	811242-5	BUMPER, HOLD DOWN	51
-	1	1	1	1	1	690753-2	SPACER, TONKER	50
-	-	-	-	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	2119656-9	APPLICATOR BASIC ASSEMBLY, SF	46
-	1	-	1	1	1	2119370-1	RAM, AMP STYLE, SIDE 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	2119644-1	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
-	1	1	1	1	1	2-1752356-0	SUPPORT, TERMINAL	34
-	2	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	1	1	1	1	1	2161328-1	HEX HEAD, FLANGED, M5 x 8mm LONG	32
-	1	1	1	1	1	1-1320908-2	SPACER, STRIP GUIDE	30
-	1	1	1	1	1	2119959-1	ASSEMBLY, STRIP GUIDE	29
-	1	1	1	1	1	455888-3	SPACER, CRIMPER	28
-	1	1	1	1	1	1320928-2	STRIP GUIDE	24
-	1	1	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
-	1	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	1	2119806-1	INSERT, SHEAR	13
-	1	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	4-1633711-9	ANVIL, COMBINATION	8
-	1	1	1	1	1	2-240641-8	SPACER	7
-	-	-	-	-	-	-	-	6
-	1	1	1	1	1	2119781-1	DEPRESSOR, SHEAR	5
-	1	1	1	1	1	238011-4	BLOCK, CRIMPER SPACER	4
1	1	1	1	1	1	2-1803018-9	CRIMPER, INSULATION O	3
-	1	1	1	1	1	1-455888-2	SPACER, CRIMPER	2
1	1	1	1	1	1	3-1633305-0	CRIMPER, WIRE PREMIUM	1
-77	-7	-6	-5	-2	-1	PART NO	DESCRIPTION	ITEM NO

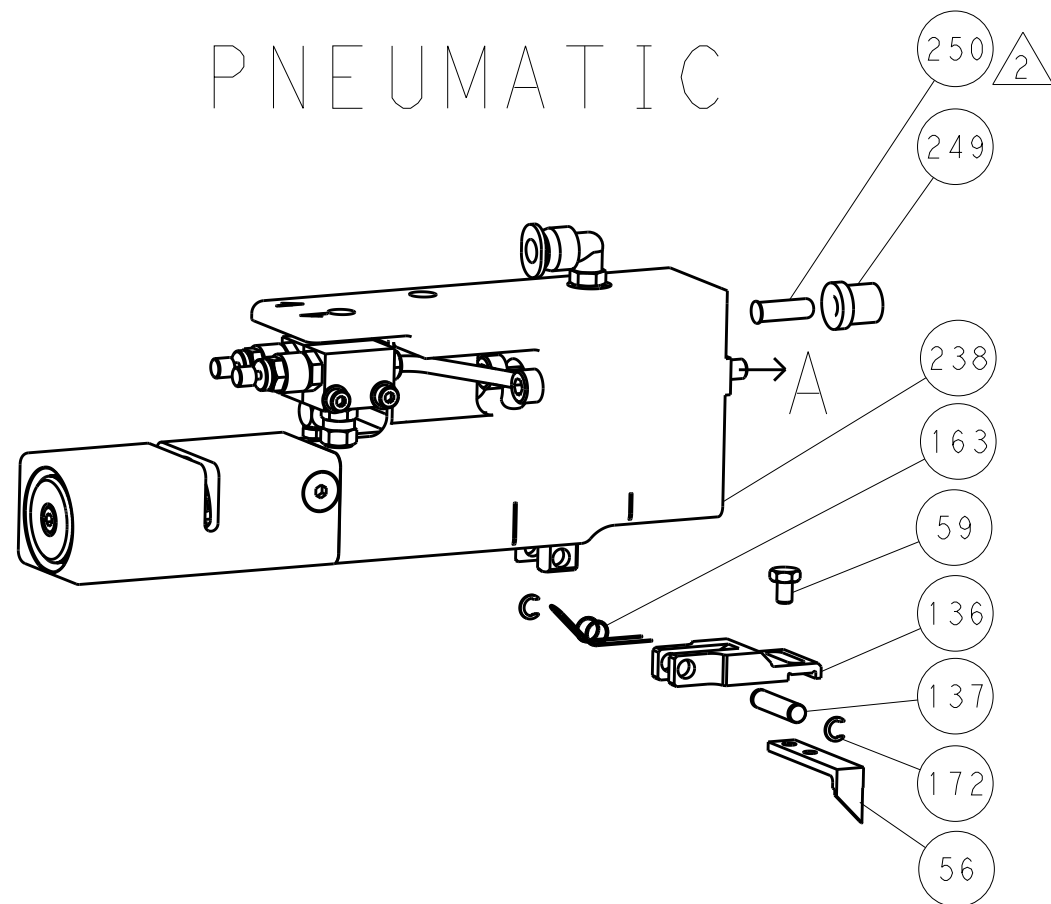
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DIMENSIONS: mm		CHK U. GUO 09JUN2013	NAME Ocean Side Feed Applicator	
		APVD J. CRUZ 09JUN2013	SIZE CASE CODE DRAWING NO	
		PRODUCT SPEC	RESTRICTED TO	
MATERIAL		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.5 1 PLC ±.03 2 PLC ±.013 3 PLC ±.013 4 PLC ±.0001 ANGLES ±.0001	APPLICATION SPEC	
		FINISH	WEIGHT	
-		-	A1 00779 ©=2151956	
Customer Accessible Production Drawing		SCALE 1:2	SHEET 1 OF 4 REV B1	

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

FEED TYPE
MECHANICAL



PNEUMATIC



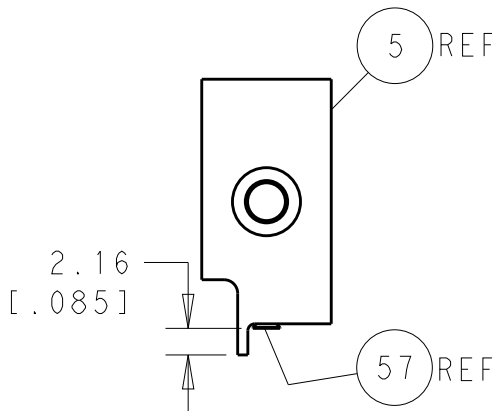
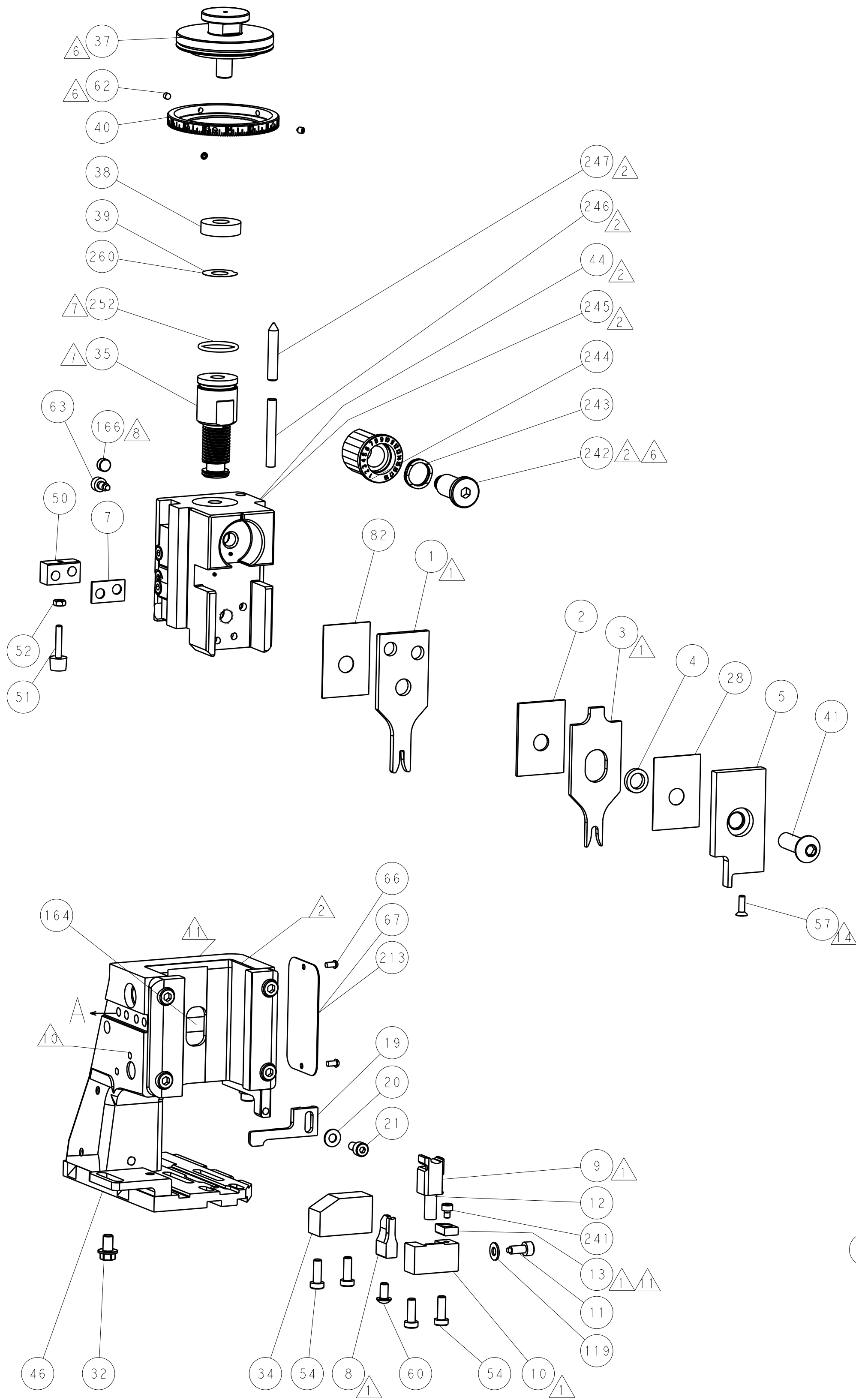
SERVO
LATCH PLATE



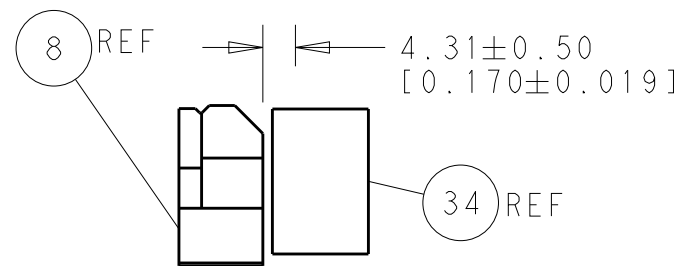
CAM POSITIONS



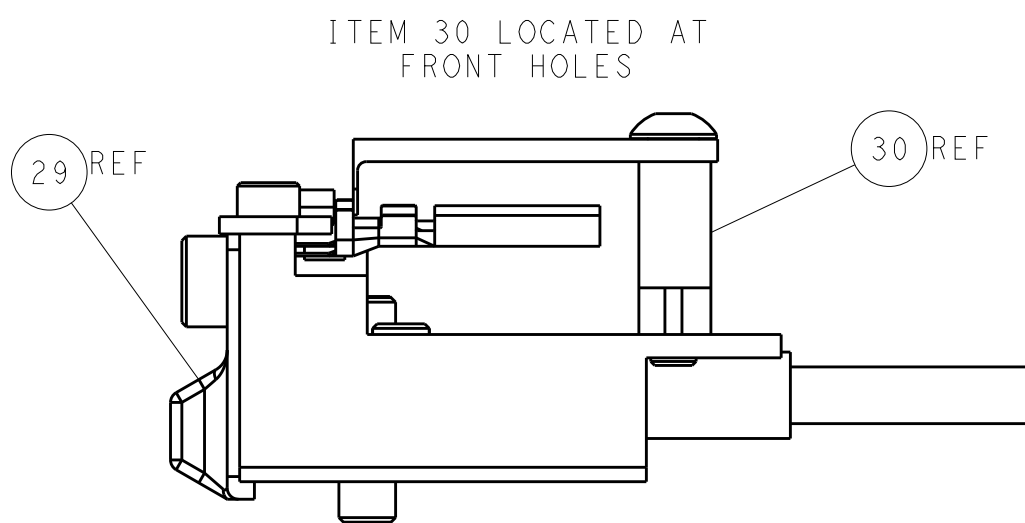
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)



SHEAR DEPRESSOR DETAIL



TERMINAL SUPPORT LOCATION



FEED TRACK POSITION
GUIDE BY INSULATION BARREL

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DIMENSIONS: mm				TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.5 1 PLC ±0.13 2 PLC ±0.13 3 PLC ±0.013 4 PLC ±0.0001 ANGLES FINISH				NAME: Ocean Side Feed Applicator			
MATERIAL: -				WEIGHT: -				SIZE: A11 00779 C=2151956			
Customer Accessible Production Drawing				SCALE: 1:2				SHEET 2 OF 4			
								REV B1			

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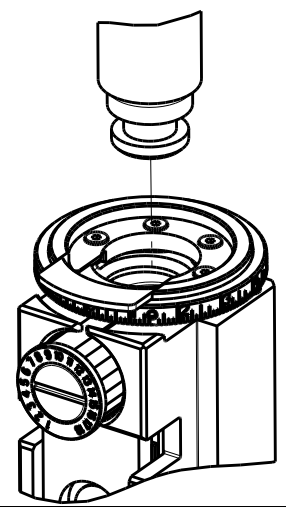
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PACIFIC VERSION
TERMINATOR
INTERFACE ADAPTER



PART
NUMBER

2-2151956-1

REVISION

B

DESCRIPTION

FINE CRIMP HEIGHT ADJUST

FEED TYPE

MECHANICAL

CONVERT TO

PNEUMATIC FEED

PART NUMBERS REQUIRED

2119950-1

2119951-1

1338685-1

5-18022-5

2119641-2

2119799-1

2063440-1

2161326-1

8-2151956-4

8-2151956-5

1901094-3

1-1752354-6

2168400-6 (QUANTITY 2)

2119949-1

1338685-1

5-18022-5

2119653-2

-

-

2119951-1

-

8-2151956-5

1901094-3

1-1752354-6

2168400-6 (QUANTITY 2)

2161326-1

-

8-2151956-4

-

-

-

2119949-1

1338685-1

5-18022-5

2119653-2

-

-

2119950-1

1338685-1

5-18022-5

2119641-2

2119799-1

2063440-1

-

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-

APPLICATOR DATA

CRIMP

SIZE

TYPE

WIRE

1.98 mm [.078]

F

INSUL

3.70 mm [.146]

O

APPLICATOR INSTRUCTIONS

408-10389

TERMINAL DATA: SUMITOMO TERMINAL

SUMITOMO CRIMP SPECIFICATION

TERMINAL NAME: TERMINAL

WIRE STRIP LENGTH

4.40-5.20 mm [.173-.205 IN]

INSULATION DIAMETER RANGE

Ø1.80-2.90 mm [.071-.114 IN]

TERMINAL APPLICATION SPECIFICATION

SUMITOMO SPEC Rev -

-

-

-

TERMINALS APPLIED

TE TERMINAL

SUMITOMO TERMINAL

TE SEAL

SUMITOMO SEAL

1642775-1

1500-0105

1949371-1

7160-8234

1949634-1

7165-0119

TERMINAL DATA: SUMITOMO TERMINAL

SUMITOMO CRIMP SPECIFICATION

TERMINAL NAME: TERMINAL

WIRE STRIP LENGTH

4.40-5.20 mm [.173-.205 IN]

INSULATION DIAMETER RANGE

Ø1.80-2.90 mm [.071-.114 IN]

TERMINAL APPLICATION SPECIFICATION

SUMITOMO SPEC Rev -

-

-

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TERMINALS APPLIED

TE TERMINAL

SUMITOMO TERMINAL

TE SEAL

SUMITOMO SEAL

1832684-1

1500-0106

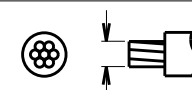
1949371-1

7160-8234

1949634-1

7165-0119

WIRE SIZE



CRIMP HEIGHT mm [INCH]

1.25mm2

1.50+/-0.05 [.059+/- .002]

0.85mm2

1.40+/-0.05 [.055+/- .002]

0.50mm2

1.25+/-0.05 [.049+/- .002]

0.30mm2

1.10+/-0.05 [.043+/- .002]

CRIMP HEIGHT REFERENCE SETTING

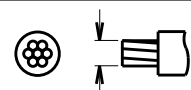
4.0

4.9

6.7

8.6

WIRE SIZE



CRIMP HEIGHT mm [INCH]

1.25mm2

1.30+/-0.05 [.051+/- .002]

0.85mm2

1.20+/-0.05 [.047+/- .002]

0.50mm2

1.10+/-0.05 [.043+/- .002]

0.30mm2

0.95+/-0.05 [.037+/- .002]

CRIMP HEIGHT REFERENCE SETTING

5.2

6.3

7.6

9.4

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RECOMMENDED SPARE PARTS

GREASE BEARING SURFACES LIGHTLY

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: 8-2151956-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151956-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151956-5

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 ITEMS 62 & 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.

THIS APPLICATOR APPLIES TERMINAL WITH A SEAL.

APPLY TORQ-SEAL IN ALLEN SOCKET TO FILL HOLE AFTER FLAT HD HAS BEEN ADJUSTED TO CORRECT HEIGHT AT QUALIFICATION. APPLY #1-23419-5 LOC-TITE TO THREADS.

APPLICATOR STYLE CONVERSION CHART

CONVERT TO

PART NUMBERS REQUIRED

PNEUMATIC FEED

2119950-1

1338685-1

5-18022-5

2119641-2

2119799-1

2063440-1

SERVO LATCH PLATE

2119951-1

-

8-2151956-5

1901094-3

1-1752354-6

2168400-6 (QUANTITY 2)

SMART APPLICATOR

2161326-1

-

8-2151956-4

-

-

-

MECHANICAL FEED

2119949-1

1338685-1

5-18022-5

2119653-2

-

-

SERVO LATCH PLATE

2119951-1

-

8-2151956-5

1901094-3

1-1752354-6

2168400-6 (QUANTITY 2)

SMART APPLICATOR

2161326-1

-

8-2151956-4

-

-

-

MECHANICAL FEED

2119949-1

1338685-1

5-18022-5

2119653-2

-

-

PNEUMATIC FEED

2119950-1

1338685-1

5-18022-5

2119641-2

2119799-1

2063440-1

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APPLICATOR DATA

CRIMP

SIZE

TYPE

WIRE

1.98 mm [.078]

F

INSUL

3.70 mm [.146]

O

APPLICATOR INSTRUCTIONS

408-10389

TERMINAL DATA: SUMITOMO TERMINAL

SUMITOMO CRIMP SPECIFICATION

TERMINAL NAME: TERMINAL

WIRE STRIP LENGTH

4.40-5.20 mm [.173-.205 IN]

INSULATION DIAMETER RANGE

Ø1.80-2.90 mm [.071-.114 IN]

TERMINAL APPLICATION SPECIFICATION

SUMITOMO SPEC Rev -

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TERMINALS APPLIED

TE TERMINAL

SUMITOMO TERMINAL

TE SEAL

SUMITOMO SEAL

1642775-1

1500-0105

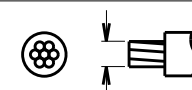
1949371-1

7160-8234

1949634-1

7165-0119

WIRE SIZE



CRIMP HEIGHT mm [INCH]

1.25mm2

1.50+/-0.05 [.059+/- .002]

0.85mm2

1.40+/-0.05 [.055+/- .002]

0.50mm2

1.25+/-0.05 [.049+/- .002]

0.30mm2

1.10+/-0.05 [.043+/- .002]

CRIMP HEIGHT REFERENCE SETTING

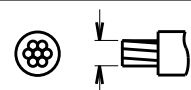
4.0

4.9

6.7

8.6

WIRE SIZE



CRIMP HEIGHT mm [INCH]

1.25mm2

1.30+/-0.05 [.051+/- .002]

0.85mm2

1.20+/-0.05 [.047+/- .002]

0.50mm2

1.10+/-0.05 [.043+/- .002]

0.30mm2

0.95+/-0.05 [.037+/- .002]

CRIMP HEIGHT REFERENCE SETTING

5.2

6.3

7.6

9.4

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RECOMMENDED SPARE PARTS

GREASE BEARING SURFACES LIGHTLY

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: 8-2151956-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151956-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151956-5

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 ITEMS 62 & 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.

THIS APPLICATOR APPLIES TERMINAL WITH A SEAL.

APPLY TORQ-SEAL IN ALLEN SOCKET TO FILL HOLE AFTER FLAT HD HAS BEEN ADJUSTED TO CORRECT HEIGHT AT QUALIFICATION. APPLY #1-23419-5 LOC-TITE TO THREADS.

APPLICATOR STYLE CONVERSION CHART

CONVERT TO

PART NUMBERS REQUIRED

PNEUMATIC FEED

2119950-1

1338685-1

5-18022-5

2119641-2

2119799-1

2063440-1

SERVO LATCH PLATE

2119951-1

-

8-2151956-5

1901094-3

1-1752354-6

2168400-6 (QUANTITY 2)

SMART APPLICATOR

2161326-1

-

8-2151956-4

-

-

-

MECHANICAL FEED

2119949-1

1338685-1

5-18022-5

2119653-2

-

-

SERVO LATCH PLATE

2119951-1

-

8-2151956-5

1901094-3

1-1752354-6

2168400-6 (QUANTITY 2)

SMART APPLICATOR

2161326-1

-

8-2151956-4

-

-

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MECHANICAL FEED

2119949-1

1338685-1

5-18022-5

2119653-2

-

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PNEUMATIC FEED

2119950-1

1338685-1

5-18022-5

2119641-2

2119799-1

2063440-1

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APPLICATOR DATA

CRIMP

SIZE

TYPE

WIRE

1.98 mm [.078]

F

INSUL

3.70 mm [.146]

O

APPLICATOR INSTRUCTIONS

408-10389

TERMINAL DATA: SUMITOMO TERMINAL

SUMITOMO CRIMP SPECIFICATION

TERMINAL NAME: TERMINAL

WIRE STRIP LENGTH

4.40-5.20 mm [.173-.205 IN]

INSULATION DIAMETER RANGE

Ø1.80-2.90 mm [.071-.114 IN]

TERMINAL APPLICATION SPECIFICATION

SUMITOMO SPEC Rev -

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TERMINALS APPLIED

TE TERMINAL

SUMITOMO TERMINAL

TE SEAL

SUMITOMO SEAL

1642775-1

1500-0105

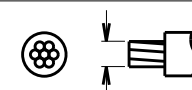
1949371-1

7160-8234

1949634-1

7165-0119

WIRE SIZE



CRIMP HEIGHT mm [INCH]

1.25mm2

1.50+/-0.05 [.059+/- .002]

0.85mm2

1.40+/-0.05 [.055+/- .002]

0.50mm2

1.25+/-0.05 [.049+/- .002]

0.30mm2

1.10+/-0.05 [.043+/- .002]

CRIMP HEIGHT REFERENCE SETTING

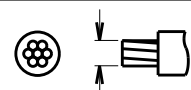
4.0

4.9

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WIRE SIZE



CRIMP HEIGHT mm [INCH]

1.25mm2

1.30+/-0.05 [.051+/- .002]

0.85mm2

1.20+/-0.05 [.047+/- .002]

0.50mm2

1.10+/-0.05 [.043+/- .002]

0.30mm2

0.95+/-0.05 [.037+/- .002]

CRIMP HEIGHT REFERENCE SETTING

5.2

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RECOMMENDED SPARE PARTS

GREASE BEARING SURFACES LIGHTLY

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:
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PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151956-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151956-5

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 ITEMS 62 & 242.

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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.

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APPLY TORQ-SEAL IN ALLEN SOCKET TO FILL HOLE AFTER FLAT HD HAS BEEN ADJUSTED TO CORRECT HEIGHT AT QUALIFICATION. APPLY #1-23419-5 LOC-TITE TO THREADS.

APPLICATOR STYLE CONVERSION CHART

CONVERT TO

PART NUMBERS REQUIRED

PNEUMATIC FEED

2119950-1

1338685-1

5-18022-5

2119641-2

2119799-1

2063440-1

SERVO LATCH PLATE

2119951-1

-

8-2151956-5

1901094-3

1-1752354-6

2168400-6 (QUANTITY 2)

SMART APPLICATOR

2161326-1

-

8-2151956-4

-

-

-

MECHANICAL FEED

2119949-1

1338685-1

5-18022-5

2119653-2

-

-

SERVO LATCH PLATE

2119951-1

-

8-2151956-5

1901094-3

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SMART APPLICATOR

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8-2151956-4

-

-

-

MECHANICAL FEED

2119949-1

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5-18022-5

2119653-2

-

-

PNEUMATIC FEED

2119950-1

1338685-1

5-18022-5

2119641-2

2119799-1

2063440-1

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APPLICATOR DATA

CRIMP

SIZE

TYPE

WIRE

1.98 mm [.078]

F

INSUL

3.70 mm [.146]

O

APPLICATOR INSTRUCTIONS

408-10389

TERMINAL DATA: SUMITOMO TERMINAL

SUMITOMO CRIMP SPECIFICATION

TERMINAL NAME: TERMINAL

WIRE STRIP LENGTH

4.40-5.20 mm [.173-.205 IN]

INSULATION DIAMETER RANGE

Ø1.80-2.90 mm [.071-.114 IN]

TERMINAL APPLICATION SPECIFICATION

SUMITOMO SPEC Rev -

-

-

-

TERMINALS APPLIED

TE TERMINAL

SUMITOMO TERMINAL

TE SEAL

SUMITOMO SEAL

1642775-1

1500-0105

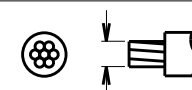
1949371-1

7160-8234

1949634-1

7165-0119

WIRE SIZE



CRIMP HEIGHT mm [INCH]

1.25mm2

1.50+/-0.05 [.059+/- .002]

0.85mm2

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0.50mm2

1.25+/-0.05 [.049+/- .002]

0.30mm2

1.10+/-0.05 [.043+/- .002]

CRIMP HEIGHT REFERENCE SETTING

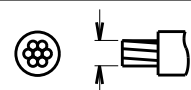
4.0

4.9

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WIRE SIZE



CRIMP HEIGHT mm [INCH]

1.25mm2

1.30+/-0.05 [.051+/- .002]

0.85mm2

1.20+/-0.05 [.047+/- .002]

0.50mm2

1.10+/-0.05 [.043+/- .002]

0.30mm2

0.95+/-0.05 [.037+/- .002]

CRIMP HEIGHT REFERENCE SETTING

5.2

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RECOMMENDED SPARE PARTS

GREASE BEARING SURFACES LIGHTLY

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: 8-2151956-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151956-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151956-5

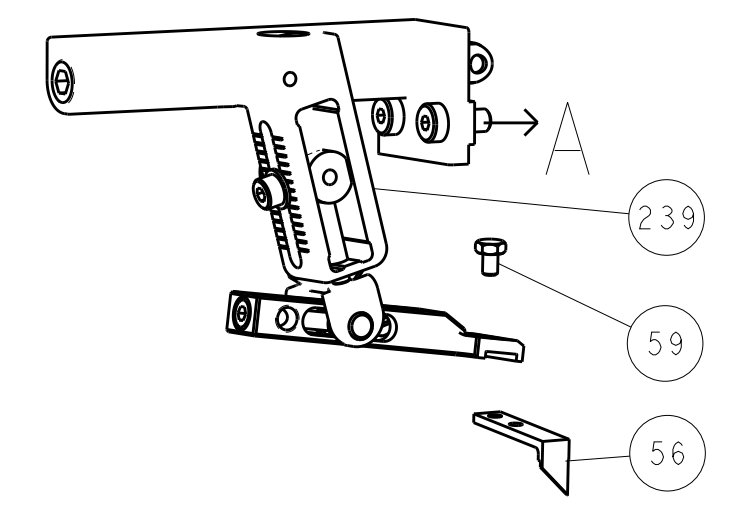
ADJUSTMENT OF THE STRIPPER MAY BE REQUIRED WHEN MOVING THE APPLICATOR BETWEEN BENCH AND LEADMAKER APPLICATIONS.

APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 62 & 242.

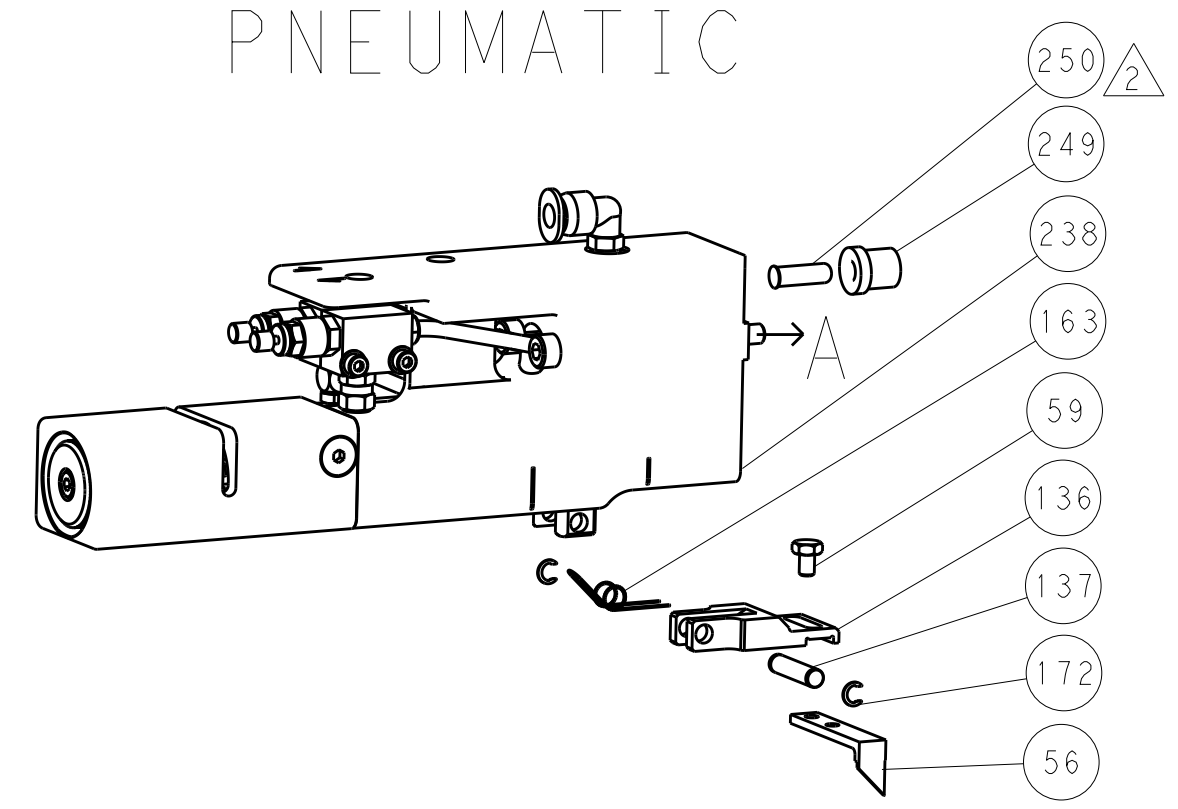
GREASE THREADS, GRO

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

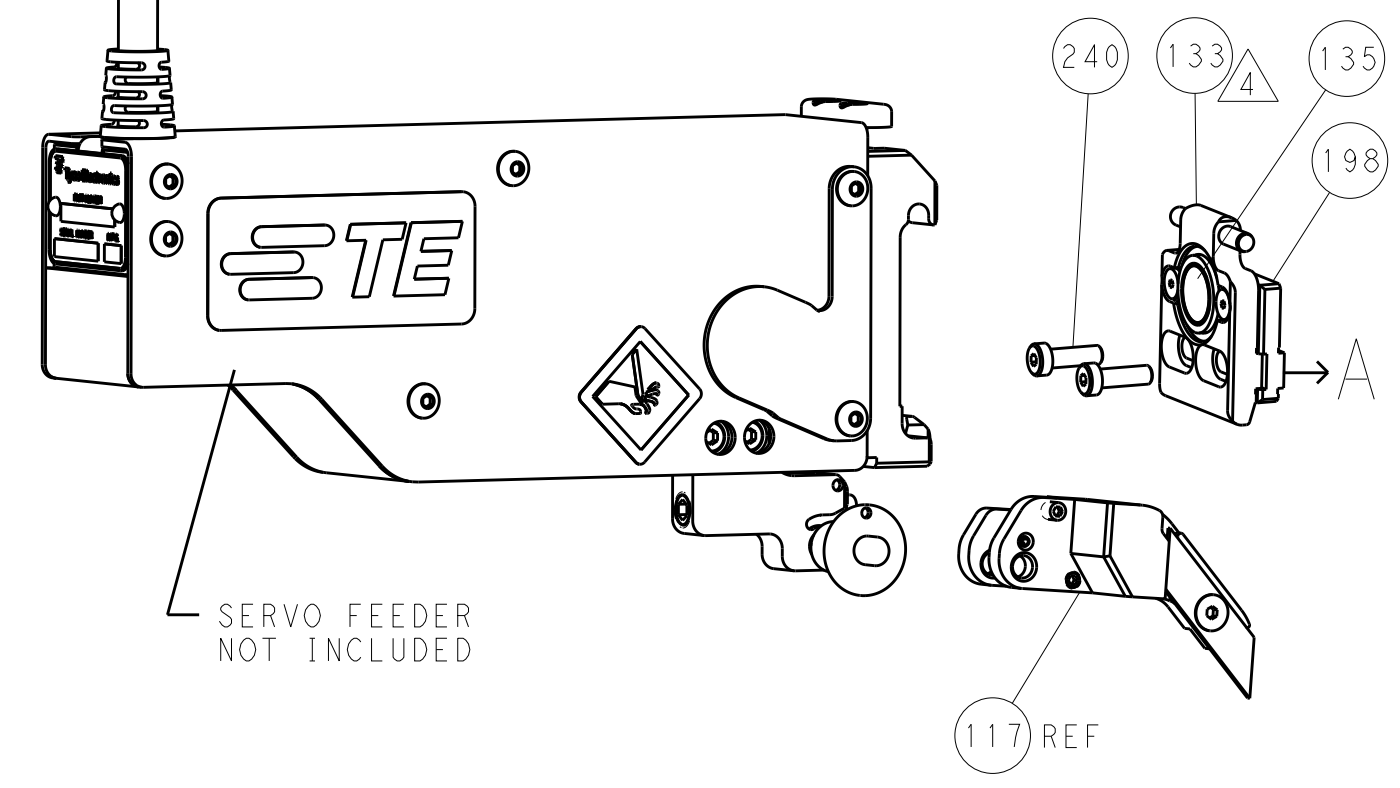
FEED TYPE
MECHANICAL



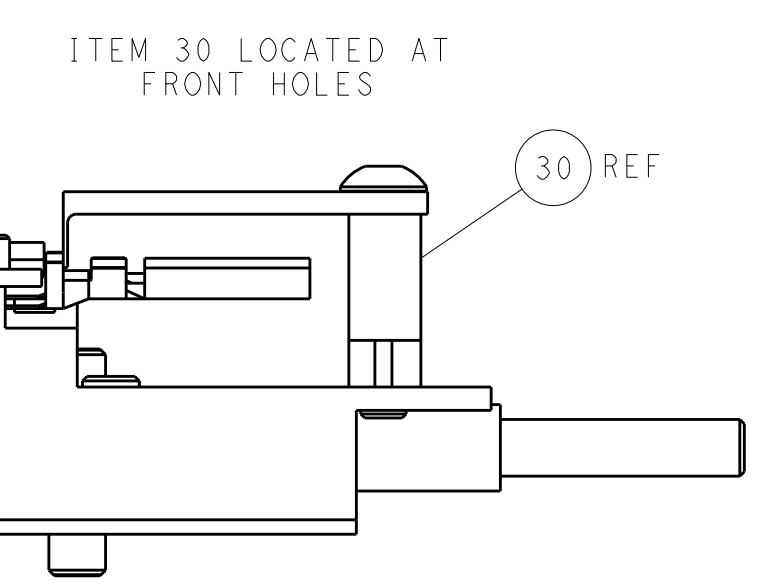
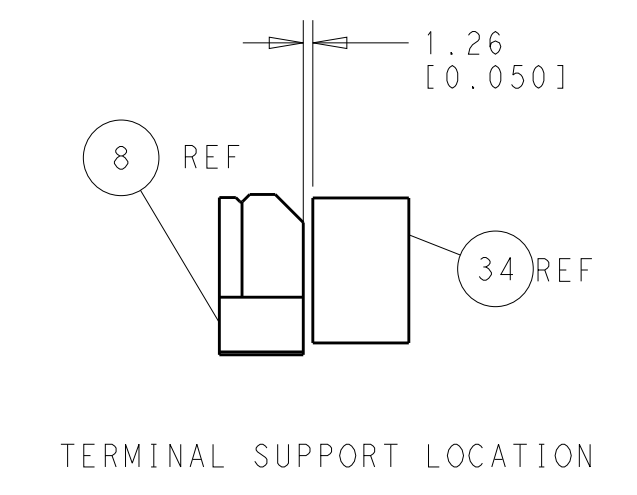
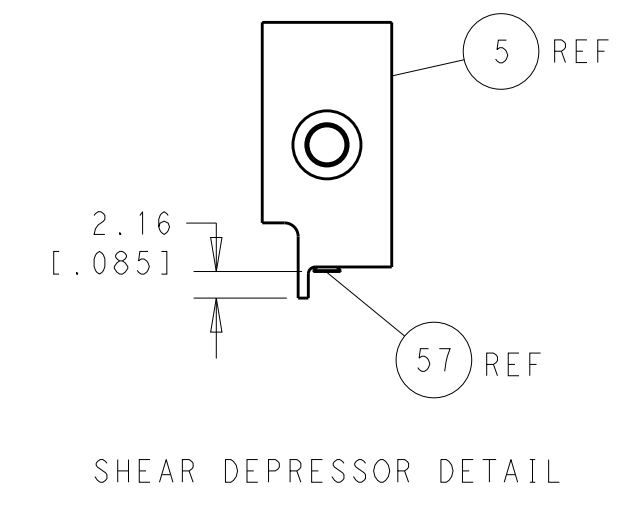
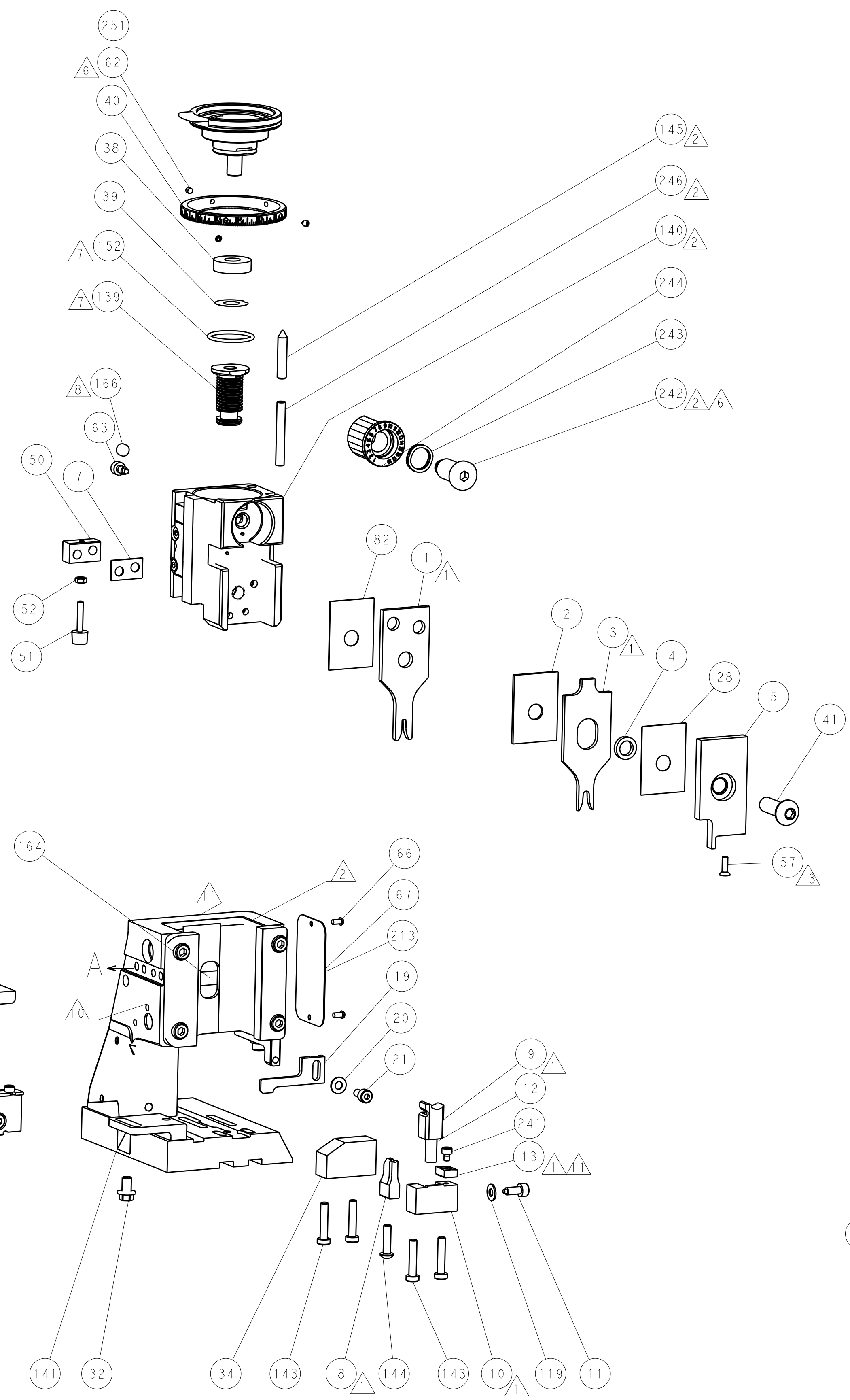
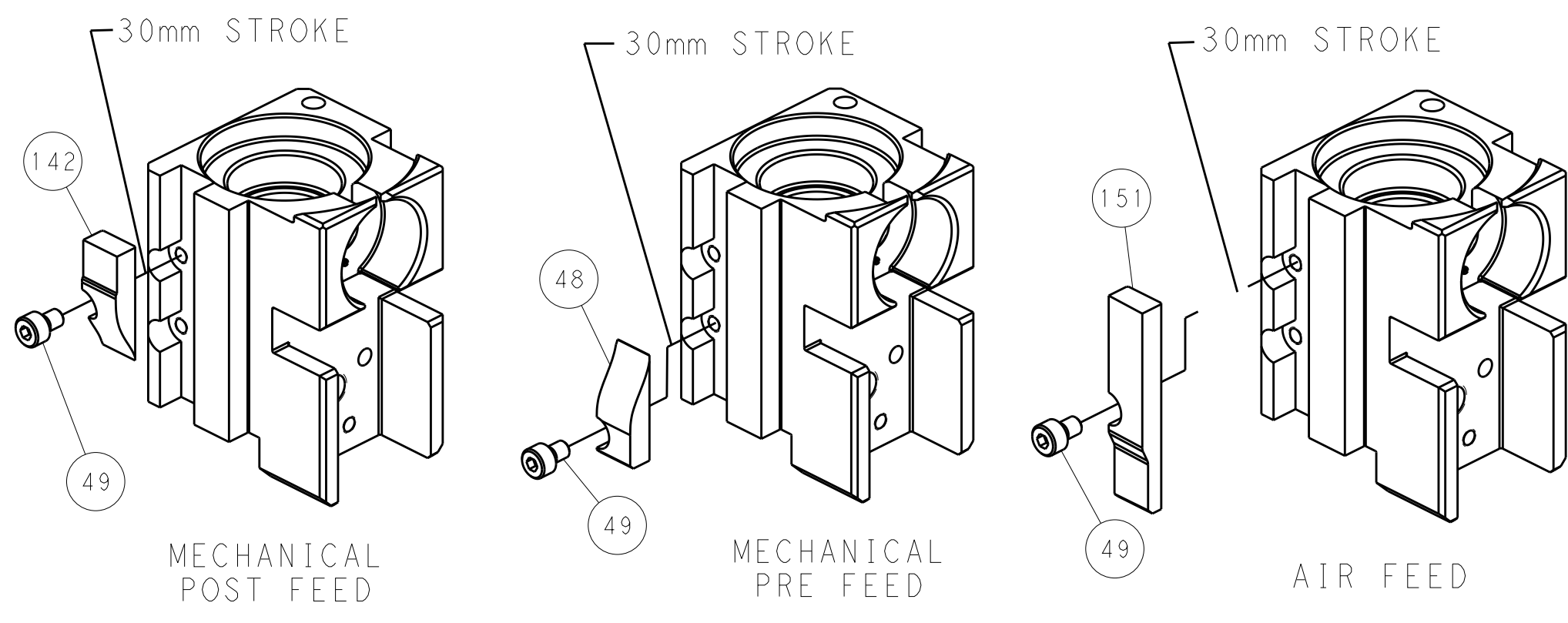
PNEUMATIC



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 C. CHEN 09JUN2013		CHK U. GUO 09JUN2013		APVD J. CRUZ 09JUN2013		NAME Ocean Side Feed Applicator	
mm		0 PLC ±0.5		PRODUCT SPEC		APPLICATION SPEC		SIZE CAGE CODE DRAWING NO		RESTRICTED TO	
MATERIAL		FINISH		WEIGHT		Customer Accessible Production Drawing		SCALE 1:2		SHEET 4 OF 4	
										REV B1	