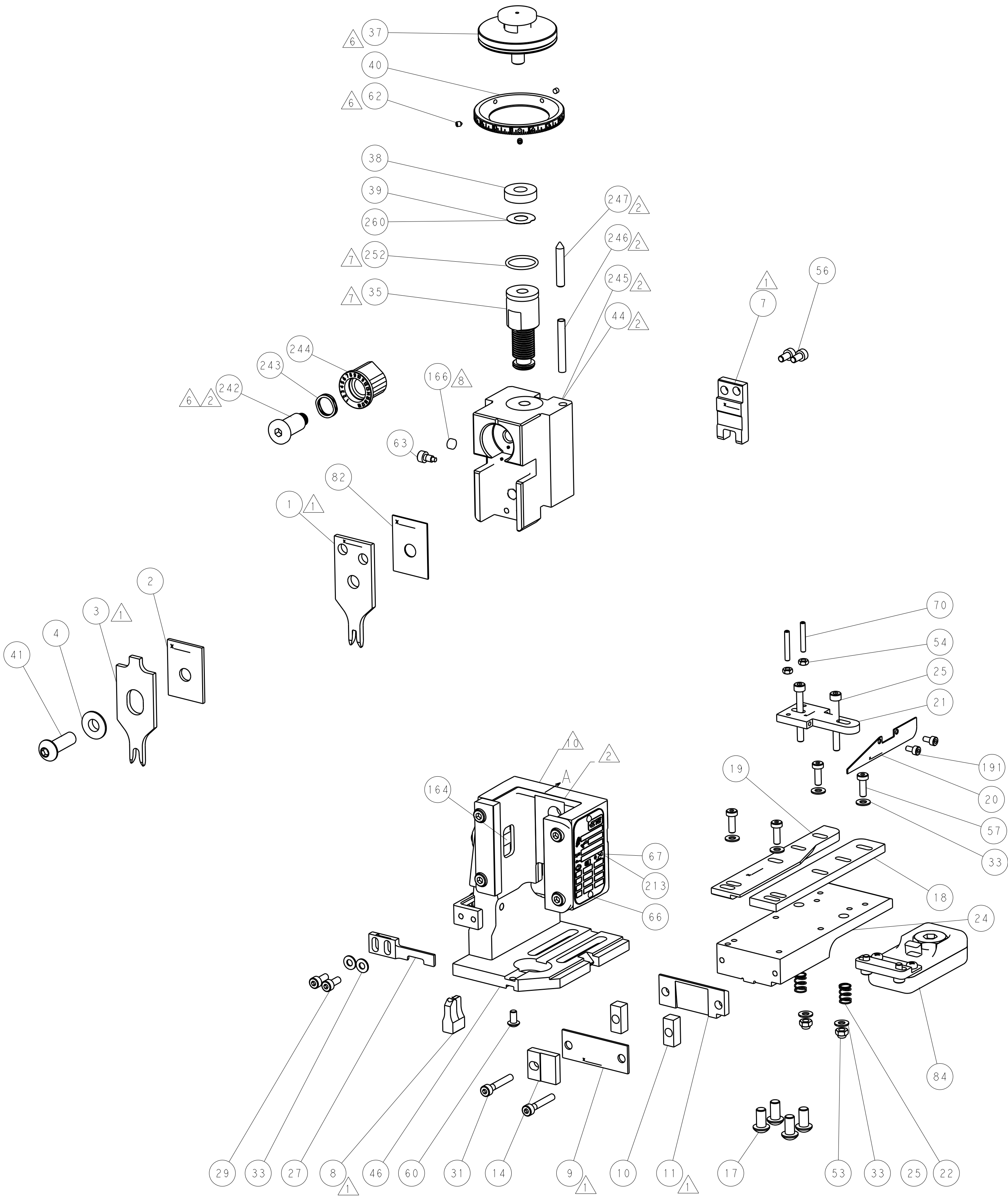
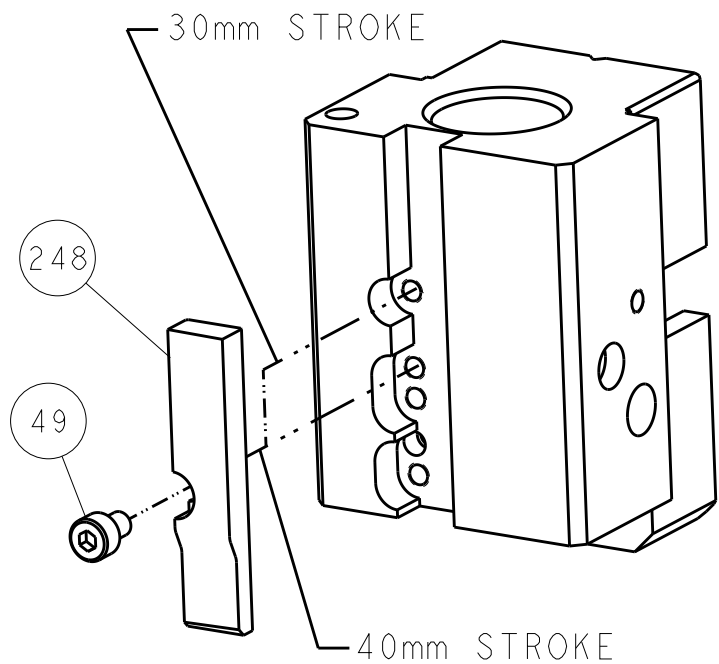


LOC	DIST	REVISIONS					
		P	LTR	DESCRIPTION	DATE	DWN	APVD
A	66	-	-	SEE SHEET 1	-	-	-



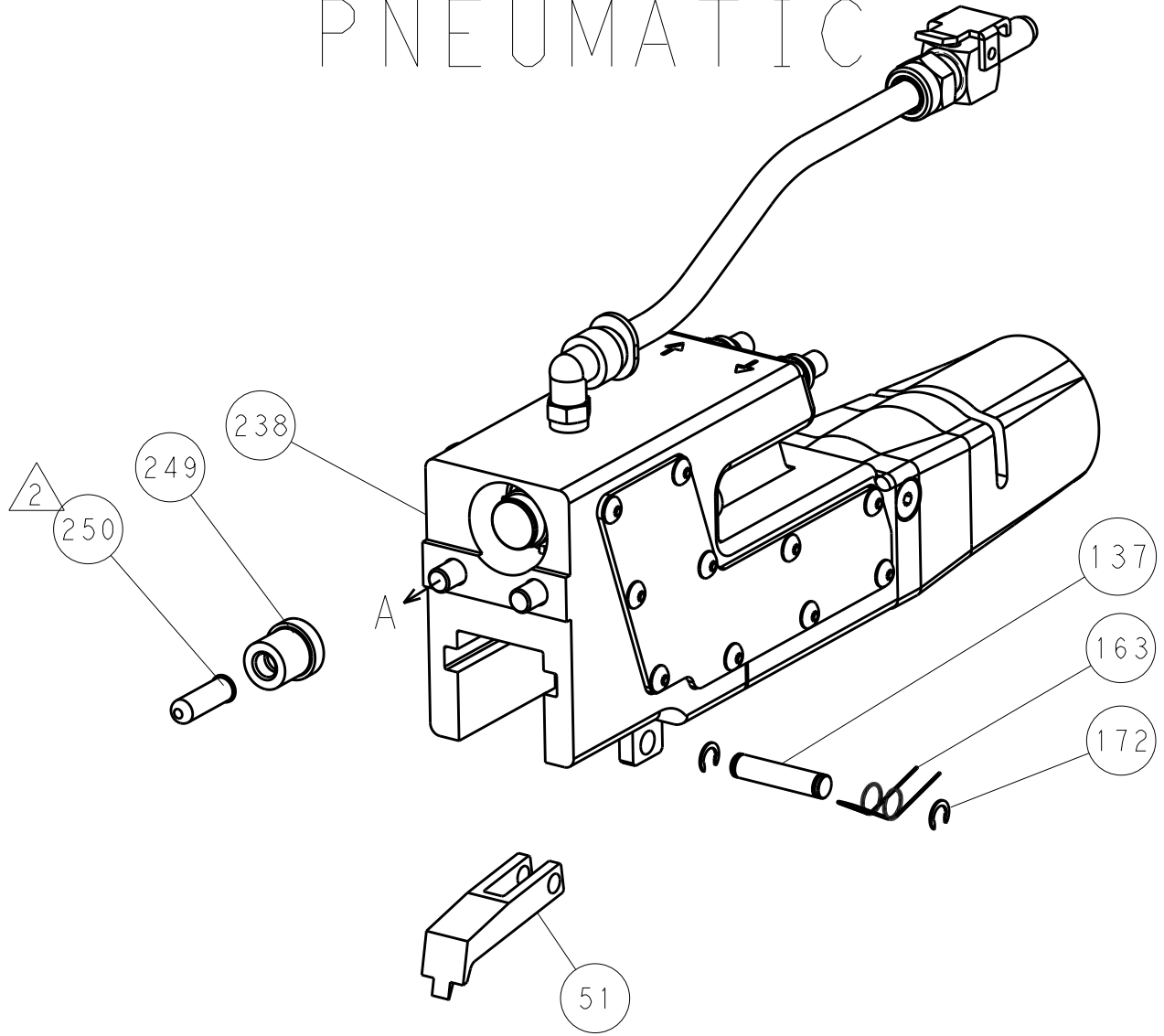
CAM POSITION



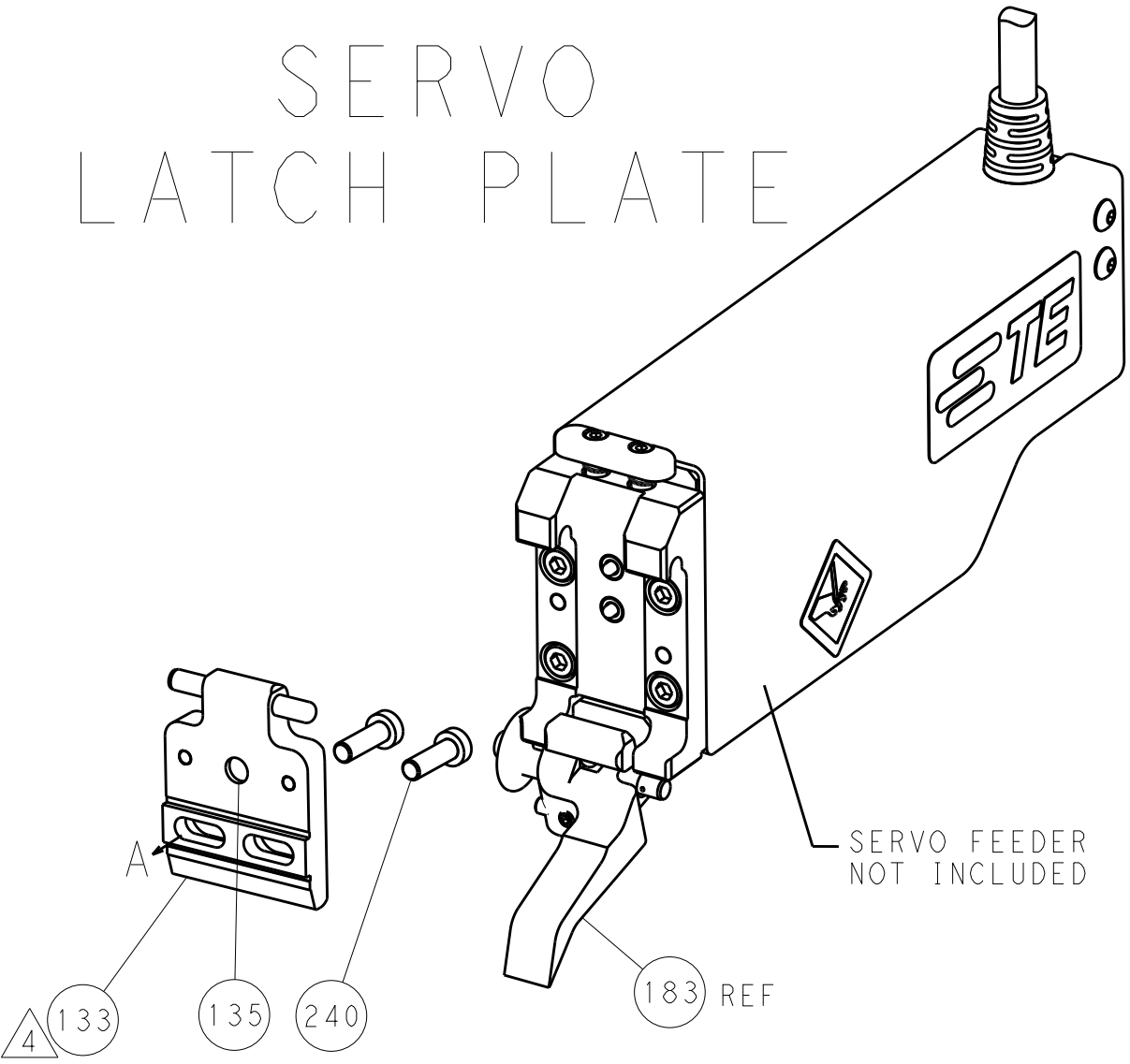
AIR FEED

FEED TYPE

PNEUMATIC

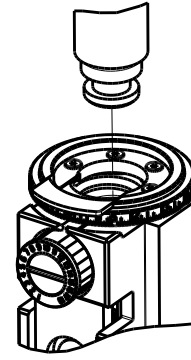


SERVO LATCH PLATE



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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CHG: T. ELBIN 03MAR2015				NAME: Ocean End Feed Applicator				Harrisburg, PA 17105-3608			
APVD: T. ELBIN 03MAR2015				SIZE: CAGE CODE: DRAWING NO: 00779 ©=2150129				RESTRICTED TO: -			
PRODUCT SPEC: -				SCALE: 1:1				SHEET 2 OF 4			
APPLICATION SPEC: -				REV: A							
WEIGHT: -				Customer Accessible Production Drawing							
MATERIAL: -											
FINISH: -											

8		7	
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PACIFIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION
	2-2150129-2	A	FINE CRIMP HEIGHT ADJUST
	2-2150129-5	A	FINE CRIMP HEIGHT ADJUST
	2-2150129-7	A	FINE CRIMP HEIGHT ADJUST
	7-2150129-7	A	CRIMP TOOLING KIT

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.79 mm [.110]	F
INSUL	4.57 mm [.180]	O
APPL INSTRUCTIONS 408-10390		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: .250 SERIES FASTON FLAG			
WIRE STRIP LENGTH 4.39-5.15 mm [.173-.203 IN]		INSULATION DIAMETER RANGE Ø2.79-5.08 mm [.110-.200 IN]	
TERMINAL APPLICATION SPECIFICATION	114-2079	-	-
	-	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
63538-1	63538-3	63963-1	

WIRE SIZE 	CRIMP HEIGHT mm [INCH] 	CRIMP HEIGHT REFERENCE SETTING 
14 AWG	1.96+/-0.05 [.077+/- .002]	3.7
(2) 18 AWG	1.80+/-0.05 [.071+/- .002]	5.6
16 AWG	1.73+/-0.05 [.068+/- .002]	6.0
18 AWG	1.57+/-0.05 [.062+/- .002]	7.8



-  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:
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150129-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150129-5
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 ITEMS 62 & 180.
APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242.
-  GREASE THREADS, GROOVE AND O-RING ON ITEMS 139 & 153.
-  MAGNET, ITEM 166 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.
-  TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
-  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.
-  TERMINAL LUBRICANT IS RECOMMENDED.

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: .250 SERIES FASTON FLAG			
WIRE STRIP LENGTH 4.39-5.15 mm [.173-.203 IN]		INSULATION DIAMETER RANGE Ø2.79-4.06 mm [.110-.160 IN]	
TERMINAL APPLICATION SPECIFICATION	114-2079	-	-
	-	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
62811-1	62811-2		

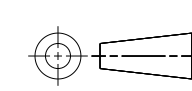
WIRE SIZE 	CRIMP HEIGHT mm [INCH] 	CRIMP HEIGHT REFERENCE SETTING 
14 AWG	1.96+/-0.05 [.077+/- .002]	3.7
(2) 18 AWG	1.80+/-0.05 [.071+/- .002]	5.6
16 AWG	1.73+/-0.05 [.068+/- .002]	6.0
18 AWG	1.57+/-0.05 [.062+/- .002]	7.8

*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.

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

SET UP GAUGE 2119599-2	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
-	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	-	2	-	2168400-7	SHCS, LOW HEAD, RoHS, M5 X 10	240
-	-	-	1	2063440-1	AIR FEED MODULE	238
-	-	1	-	2119740-2	TAG,IDENTIFICATION	213
-	2	2	2	1-2168083-1	SCR, SKT HD CAP, RoHS, M3 X 6	191
-	4	4	4	2079383-9	SCR, BHSC, RoHS (M6 X 20)	186
-	-	REF	-	1901697-1	FEED FINGER ASSEMBLY,EF	183
-	-	-	2	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172
-	1	1	1	994969-1	MAGNET, RARE EARTH HIGH ENERGY	166
-	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	-	-	1	240638-1	SPRING, FEED FINGER	163
-	1	1	1	8-21084-1	O-RING, .801 ID, .070 DIA. MAT.	153
-	-	-	1	2119641-2	FEED CAM, AIR FEED	152
-	1	1	1	2119798-2	DETENT PIN	145
-	1	1	1	2079383-8	SCR, BHSC, RoHS (M4 X 16)	144
-	-	-	-	2119653-2	FEED CAM, POST FEED	142
-	1	1	1	2119655-6	APPLICATOR BASIC ASSEMBLY, EF	141
-	1	1	1	2119651-1	RAM, ASIAN STYLE, END FEED	140
-	1	1	1	2119092-2	BOLT, ADJUSTMENT	139
-	-	-	1	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854	137
-	-	REF	-	SEE NOTE 4	MEMORY CHIP, PROGRAMMED	135
-	-	1	-	1633743-1	SERVO FEED LATCH ASM	133
-	1	1	1	2119955-2	ASSY, LUBRICATOR, END FEED	84
-	1	1	1	455888-6	SPACER, CRIMPER	82
-	1	1	1	2119956-2	DOCUMENTATION PACKAGE	71
-	2	2	2	3-18032-3	SCR, SET, FLT POINT M3 X 20.0	70
-	1	-	1	2119740-1	TAG,IDENTIFICATION	67
-	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	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
-	4	4	4	2168400-1	SHCS, LOW HEAD, RoHS, M4 X 12	57
-	2	2	2	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	56
-	2	2	2	5018030-1	NUT, HEX, REG, RoHS, M3	54
-	2	2	2	986965-8	NUT, LOCK, HEX, TORQUE (M4)	53
-	-	-	1	2119792-9	PAWL, EF, AIR	51
-	-	-	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	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	1-2119644-2	RAM WASHER, PRECISION	38
-	8	8	8	1-18028-2	WASHER, FLAT, REG M4	33
-	2	2	2	1-2168083-2	SCR, SKT HD CAP, RoHS, M4 X 25	31
-	2	2	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	29
-	1	1	1	468281-1	STRIPPER	27
-	2	2	2	1-2168083-6	SCR, SKT HD CAP, RoHS, M4 X 35	25
-	1	1	1	2161922-4	PLATE, STRIP GUIDE	24
-	2	2	2	22281-6	SPRING, COMPRESSION	22
-	1	1	1	1633168-2	ARM, STOCK DRAG	21
-	1	1	1	464452-4	DRAG, STOCK	20
-	1	1	1	3-1901696-2	STRIP GUIDE, REAR	19
-	1	1	1	1-1901259-1	GUIDE, LOWER STRIP	18
-	1	1	1	469633-1	BLOCK, SUPPORT	14
-	1	1	1	461160-1	PLATE, REAR SHEAR	11
-	2	2	2	5-240645-2	SPACER, SHEAR PLATE	10
-	1	1	1	455961-3	PLATE, FRONT SHEAR	9
-	1	1	1	1-1803000-0	ANVIL, COMBINATION, END FEED	8
-	1	1	1	1-469634-9	BLADE, SLUG	7
-	-	-	-	-	-	6
-	1	1	1	238009-1	BLOCK, FL CRIMPER SPACER	4
-	1	1	1	1803229-1	CRIMPER, INSULATION O PREMIUM	3
-	1	1	1	1-455888-8	SPACER, CRIMPER	2
-	1	1	1	2-464112-4	CRIMPER, WIRE	1
-	77	27	25	22	PART NO	DESCRIPTION
-	-	-	-	-	-	ITEM NO

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DIMENSIONS:				CHK T. ELBIN	03MAR2015	NAME	
mm				APVD T. ELBIN	03MAR2015	PRODUCT SPEC	
				APPLICATION SPEC		SIZE	
MATERIAL				FINISH		WEIGHT	
-				-		A1 00779 ©=2150129	
Customer Accessible Production Drawing				SCALE		1:1 SHEET 3 OF 4	
						REV A	

