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ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER

PART NUMBER

REVISION

DESCRIPTION

FEED TYPE

CONVERT TO

PART NUMBERS REQUIRED

2150281-1

C

FINE CRIMP HEIGHT ADJUST

MECHANICAL

PNEUMATIC FEED

SERVO LATCH PLATE

SMART APPLICATOR

2119950-1

2119951-1

2161326-1

2119792-1

1901697-1

-

-

-

-

2119641-1

-

-

-

-

2063440-1

2150281-2

C

FINE CRIMP HEIGHT ADJUST

PNEUMATIC

MECHANICAL FEED

SERVO LATCH PLATE

SMART APPLICATOR

2119949-1

2119951-1

2161326-1

2063961-1

1901697-1

-

5-18022-5

8-2150281-5

8-2150281-4

2119653-1

-

-

-

-

2168400-7 (QUANTITY 2)

2150281-5

C

FINE CRIMP HEIGHT ADJUST

SERVO LATCH PLATE

MECHANICAL FEED

PNEUMATIC FEED

2119949-1

2119950-1

2063961-1

2119792-1

5-18022-5

-

2119653-1

-

-

-

2063440-1

2150281-6

C

NON-CRIMP HEIGHT ADJUST

SERVO LATCH PLATE

-

-

-

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-

-

-

-

2150281-7

C

FINE CRIMP HEIGHT ADJUST

NONE

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-

7-2150281-7

A

CRIMP TOOLING KIT

-

-

-

-

-

-

-

APPLICATOR DATA

CRIMP

SIZE

TYPE

WIRE

2.79 mm [.110]

F

INSUL

4.57 mm [.180]

F

APPL INSTRUCTIONS

408-10390

TERMINAL DATA: TE TERMINAL

TE CRIMP SPECIFICATION

TERMINAL NAME: TONGUE, RING, OPEN BARREL

WIRE STRIP LENGTH

INSULATION DIAMETER RANGE

.178-.193 IN [4.52-4.90 mm]

Ø.120-.170 IN [3.05-4.32 mm]

TERMINAL APPLICATION SPECIFICATION

114-2084

-

-

TERMINALS APPLIED

TE TERMINAL

TE TERMINAL

TE TERMINAL

TE TERMINAL

155406-3

155406-5

155406-6

WIRE SIZE

CRIMP HEIGHT

mm [INCH]

CRIMP HEIGHT REFERENCE SETTING

14 AWG

2.11+/-0.05 [.083+/- .002]

6.2

16 AWG

1.88+/-0.05 [.074+/- .002]

8.5

18 AWG

1.75+/-0.05 [.069+/- .002]

10.2

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: 8-2150281-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150281-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150281-5
SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2150281-6

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

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

*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.

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2119957-2

APPLICATOR SHIM PACK

260

-

1

-

1

1

1

8-21084-0

O-RING, .676 ID, .070 DIA. MAT.

252

-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

2119599-2

LOC

A

DIST

66

P

LTR

C

DESCRIPTION

DATE

DWN

APVD

ECR-15-006663

28APR2015

MR

TE

-

-

-

-

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

1

2119798-1

DETENT PIN

247

-

1

-

1

1

1

1-22279-3

SPRING, COMPRESSION

246

-

-

1

-

-

-

2119759-1

RAM, AMP STYLE, END FEED, NON-ADJUST

245

-

1

1

1

1

1

2119082-9

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

-

-

2

2

-

-

2168400-7

SHCS, LOW HEAD, RoHS, M5 X 10

240

-

-

-

-

-

1

2119580-1

MECHANICAL FEED ASSEMBLY

239

-

-

-

-

1

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2063440-1

AIR FEED MODULE

238

-

-

1

1

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-

2119740-2

TAG, IDENTIFICATION

213

-

-

REFREF

-

-

-

1901697-1

FEED FINGER ASSEMBLY, EF

183

-

-

-

-

2

-

21045-3

RING, RETAIN, EXTERN, 3/16 CRESCENT

172

-

1

1

1

1

1

994969-1

MAGNET, RARE EARTH HIGH ENERGY

166

-

REFREFREFREFREFREF

994970-2

COUNTER, MAGNETIC

164

-

-

-

-

1

-

240638-1

SPRING, FEED FINGER

163

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-

-

-

1

-

3-23627-7

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

137

-

-

REFREF

-

-

-

SEE NOTE 4

MEMORY CHIP, PROGRAMMED

135

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-

1

1

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-

1633743-1

SERVO FEED LATCH ASM

133

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1

1

1

1

1

455888-4

SPACER, CRIMPER

82

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1

1

1

1

1

2119791-9

DEPRESSOR, WIRE

73

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1

1

1

1

1

2119956-2

DOCUMENTATION PACKAGE

71

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2

2

2

2

2

2-18032-2

SCR, SET, FLT POINT M3 X 10.0

70

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1

1

1

1

1

2119943-1

WASHER, SPACER

69

-

1

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1

1

2119740-1

TAG, IDENTIFICATION

67

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2

2

2

2

2

2168078-1

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

66

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1

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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

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1

1

1

1

1

2079383-4

SCR, BHSC, RoHS (M4 X 8)

60

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1

5-18022-5

SCR, HEX HD CAP, M4 X 6.0

59

-

-

-

-

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1

2063961-1

FEED FINGER

58

-

4

4

4

4

4

2168400-4

SHCS, LOW HEAD, RoHS, M4 X 8

57

-

2

2

2

2

2

2168083-3

SCR, SKT HD CAP, RoHS, M4 X 12.0

56

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2

2

2

2

2

5018030-2

NUT, HEX, REG, RoHS, M4

55

-

2

2

2

2

2

5018030-1

NUT, HEX, REG, RoHS, M3

54

-

2

2

2

2

2

986965-8

NUT, LOCK, HEX, TORQUE (M4)

53

-

-

-

-

1

-

2119792-1

PAWL, EF, AIR

51

-

-

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1

2

18023-9

SCR, SKT HD CAP M4 X 6.0

49

-

-

-

-

-

1

2119652-1

FEED CAM, PRE FEED

48

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1

2119653-1

FEED CAM, POST FEED

47

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1

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2119655-5

APPLICATOR BASIC ASSEMBLY, EF

46

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1

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1

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2119369-1

RAM, AMP STYLE, END FEED

44

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1

1

1

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1

2079383-7

SCR, BHSC, RoHS (M8 X 25)

41

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1

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1

1

1

2119645-1

DISC, NUMBERED FA WIRE ADJUSTMENT

40

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1

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1

1

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2119957-1

APPLICATOR SHIM PACK

39

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2119644-2

RAM WASHER, PRECISION

38

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1

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2119085-1

FA HEAD, ATLANTIC STYLE

37

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1

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1

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2119092-1

BOLT, ADJUSTMENT

35

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8

8

8

8

8

1-18028-2

WASHER, FLAT, REG M4

33

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1

1

1

1

1

2168083-9

SCR, SKT HD CAP, RoHS, M4 X 20

31

-

1

1

1

1

1

2168083-8

SCR, SKT HD CAP, RoHS, M4 X 16

31

-

2

2

2

2

2

1-2168083-0

SCR, SKT HD CAP, RoHS, M4 X 10

29

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1

1

1

1

1

240639-1

STRIPPER (MACHINING)

27

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2

2

2

2

2

1320906-1

STUD, THREADED

25

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1

1

1

1

1

1752371-5

PLATE, STRIP GUIDE

24

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2

2

2

2

2

2-22281-3

SPRING, COMPRESSION

22

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1

1

1

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1

1752373-4

DRAG

20

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1901696-5

STRIP GUIDE, REAR

19

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1

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1

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1

1901695-5

STRIP GUIDE, FRONT

18

-

4

4

4

4

4

1-2079383-1

SCR, BHSC, RoHS (M6 X 12)

17

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1

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240641-2

SPACER

16

1

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240644-9

PLATE, REAR SHEAR

11

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10

1

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6-690482-3

PLATE, FRONT SHEAR

9

1

1

1

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1803001-9

ANVIL, COMBINATION, END FEED

8

1

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1-690474-7

BLADE, SLUG

7

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1

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240641-1

SPACER

5

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1

238009-1

BLOCK, FL CRIMPER SPACER

4

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2119582-3

CRIMPER, INSULATION F PREMIUM

3

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1

1-456408-9

CRIMPER, WIRE PREMIUM

1

-77

-7

-6

-5

-2

-1

PART NO

DESCRIPTION

ITEM NO

11 THIS IS SUBJECT TO CHANGE AND THE USER SHALL BE RESPONSIBLE FOR VERIFYING THE CURRENT EDITION OF THIS DRAWING. ANY DISCREPANCY TO CHANGES TO THE DRAWING SHALL BE CONTACTED FOR THE LATEST EDITION.

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 ±.5

FINISH

MATERIAL

-

DWN

R. HUANG

02AUG2012

CHK

S. XI

02AUG2012

APVD

S. XI

02AUG2012

NAME

Ocean End Feed Applicator

SIZE

A1

CAGE CODE

00779

DRAWING NO

©=2150281

RESTRICTED TO

-

PRODUCT SPEC

-

APPLICATION SPEC

-

WEIGHT

-

Customer Accessible Production Drawing

SCALE

1:1

SHEET

1

OF

4

REV

C

805 REV 31MAR2000

SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

DIMENSIONING AND TOLERANCING PER ASME Y14.5M-2009

C

B

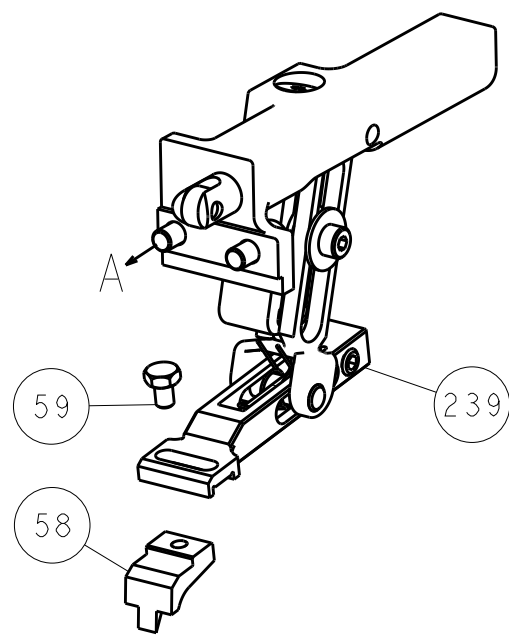
A

AMP 4805 REV 31MAR2000

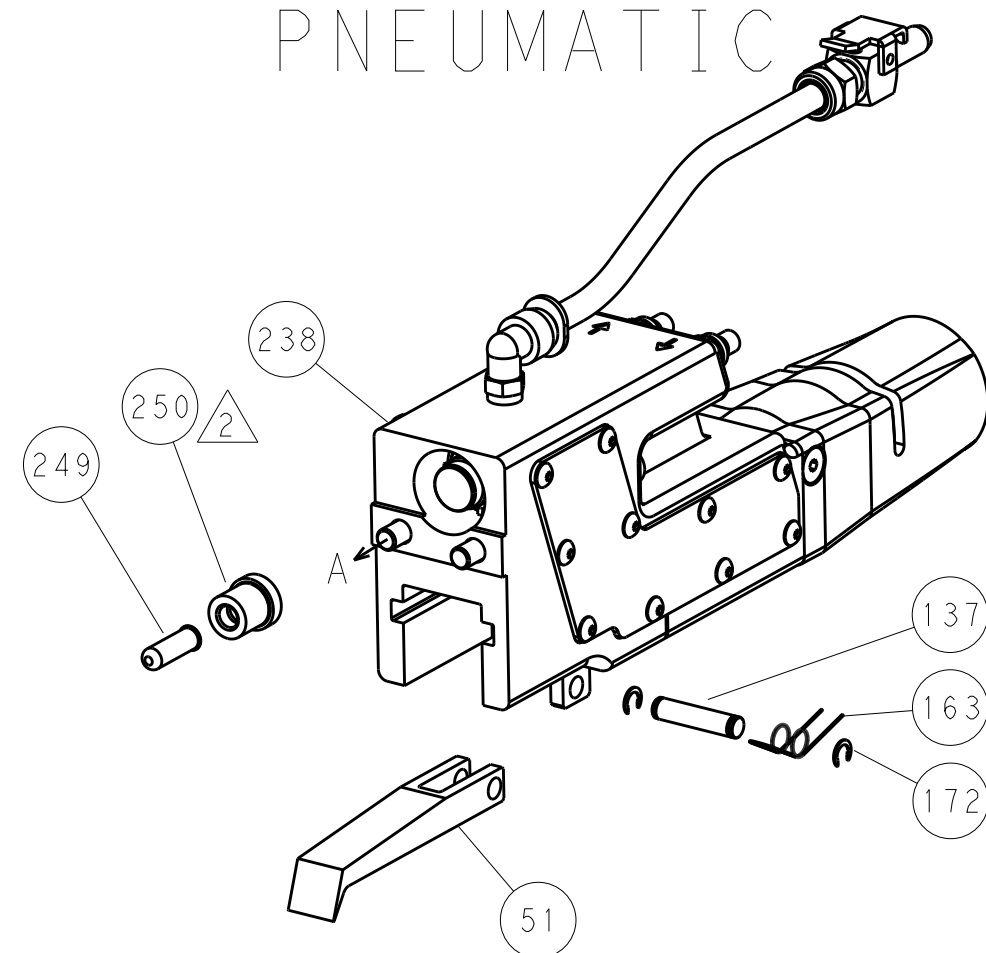
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LOC		DIST		REVISIONS				
A	66	P	LTR	DESCRIPTION	DATE	DWN	APVD	
		-		SEE SHEET 1	-	-	-	

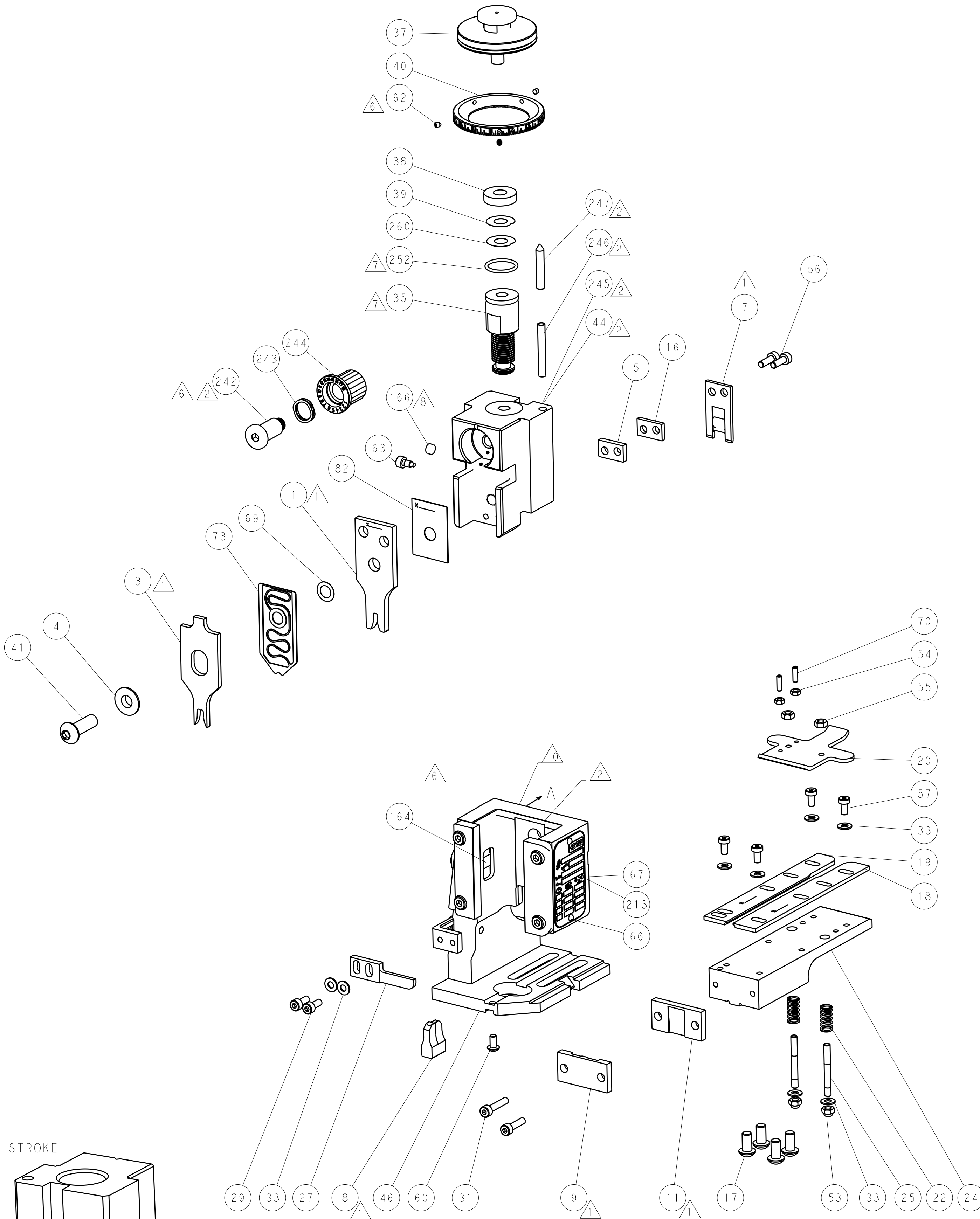
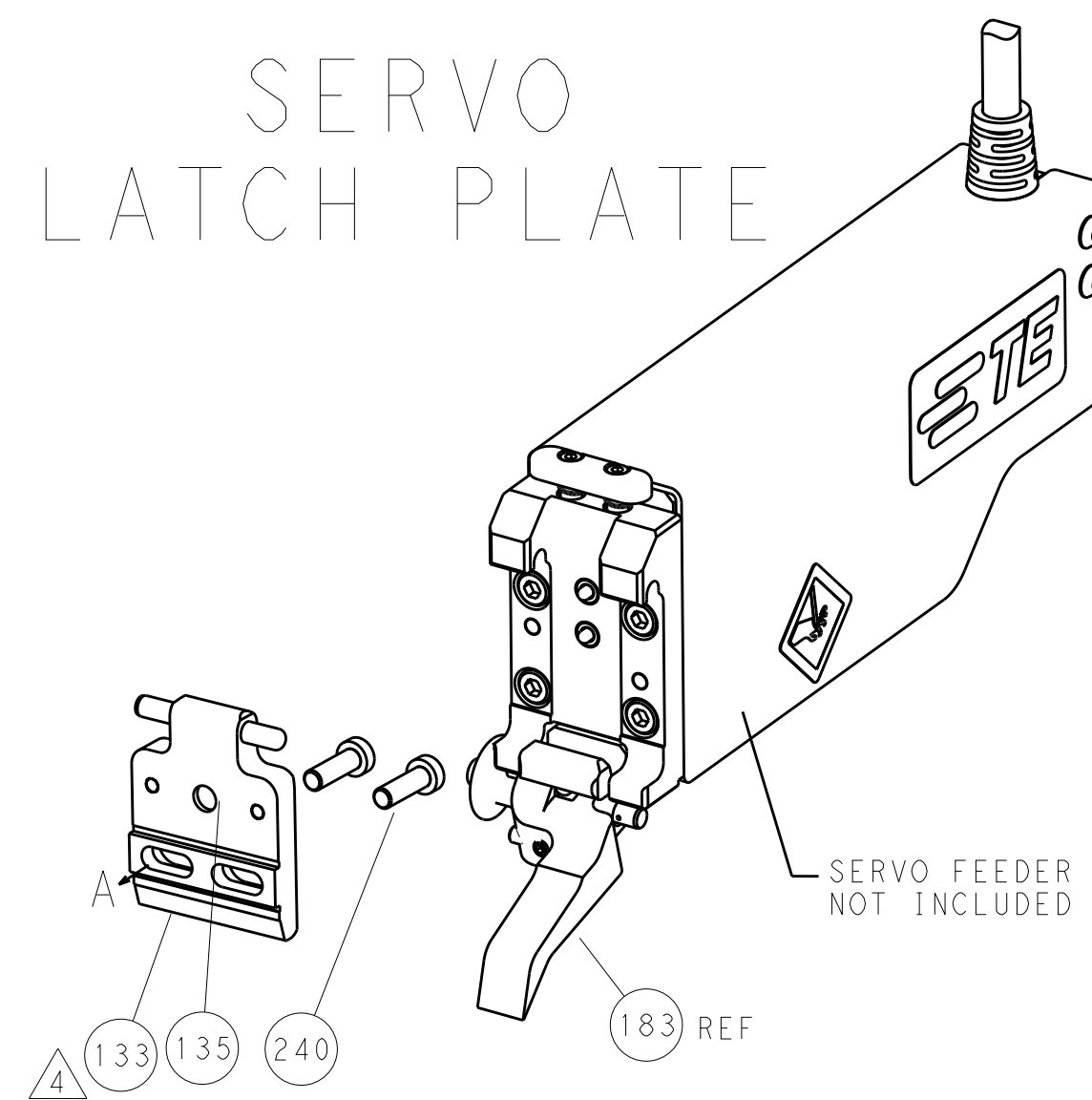
FEED TYPE
MECHANICAL



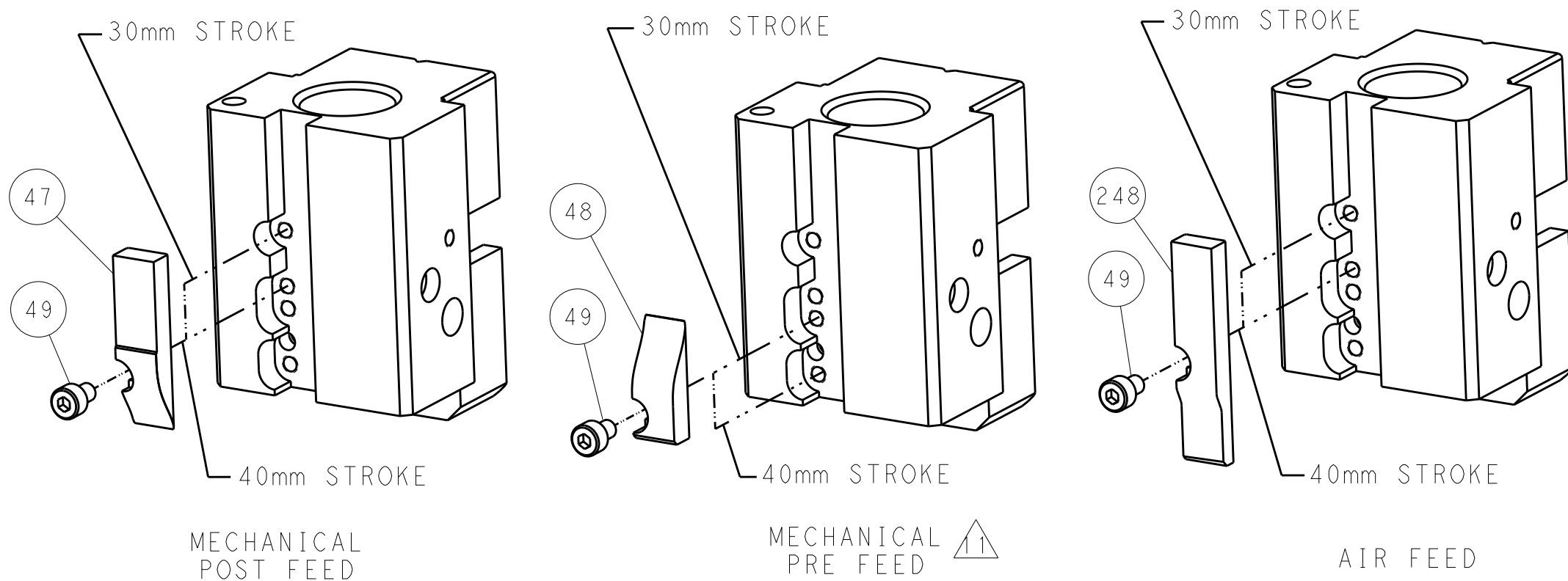
PNEUMATIC



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)

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CHK S. XI 02AUG2012		NAME Ocean End Feed Applicator	SIZE A1	
APVD S. XI 02AUG2012		PRODUCT SPEC -	CAGE CODE 00779	
APPLICATION SPEC -		WEIGHT -	DRAWING NO C-2150281	
MATERIAL -		Customer Accessible Production Drawing	SCALE 1:1	
		SHEET 2	REV C	

SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

