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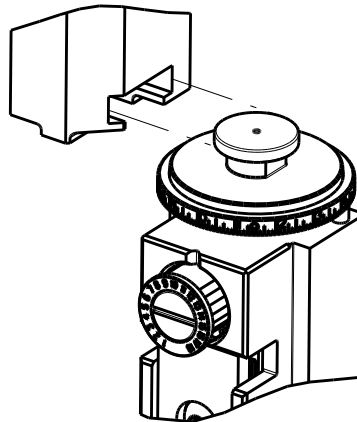
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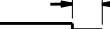
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ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION
	2150338-1	A	FINE CRIMP HEIGHT ADJUST
	2150338-2	A	FINE CRIMP HEIGHT ADJUST
	2150338-5	A	FINE CRIMP HEIGHT ADJUST
	2150338-6	A	NON-CRIMP HEIGHT ADJUST
	2150338-7	A	FINE CRIMP HEIGHT ADJUST
	7-2150338-7	A	CRIMP TOOLING KIT

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	3.56 mm [.140]	F
INSUL	5.59 mm [.220]	F
APPL INSTRUCTIONS 408-10390		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: 6.3 SRS F-SPRING LIF RECEPTACLE			
WIRE STRIP LENGTH			INSULATION DIAMETER RANGE
5.90-6.90 mm [.232-.272 IN]			Ø3.60-5.00 mm [.142-.197 IN]
TERMINAL APPLICATION	114-64027	-	-
SPECIFICATION		-	-
TERMINALS APPLIED ⁴			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
2178301-1			

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING ⁹
10 AWG		2.28+/-0.05 [.090+/- .002]		2.6
12 AWG		1.96+/-0.05 [.077+/- .002]		4.3
14 AWG		1.71+/-0.05 [.067+/- .002]		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: 8-2150338-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150338-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150338-5
SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2150338-6
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 50 & 242.
FOR -6 ONLY APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 37.
- ⁸ 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
- ¹³ TERMINAL LUBRICANT IS RECOMMENDED.

*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
-	-	-	-	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
-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)

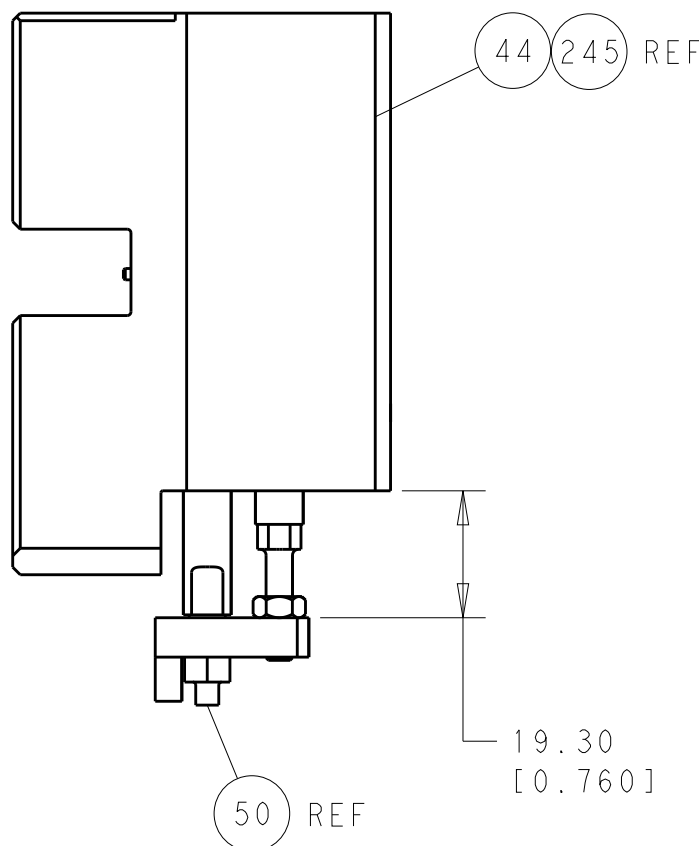
SET UP GAUGE 2119599-2	LOC A	DIST 66	REVISIONS			
P	LTR	DESCRIPTION		DATE	DWN	APVD
	A	RELEASE		15JUL2014	XZ	TE
	A1	ECR-15-006528		28APR2015	RS	LZ

	-	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	
6	-	-	2	2	-	-	2168400-7	SHCS, LOW HEAD, RoHS, M5 X 10	240	
	-	-	-	-	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239	
	-	-	-	-	-	1	2063440-1	AIR FEED MODULE	238	
	-	-	1	1	-	-	2119740-2	TAG,IDENTIFICATION	213	
	-	-	REFREF	-	-	-	1901697-1	FEED FINGER ASSEMBLY,EF	183	
	-	1	1	1	1	1	6-993111-6	PIN, SLOTTED SPRING 3.0 X 14.0	177	
	-	1	1	1	1	1	8-22280-7	SPRING, COMPRESSION	176	
	-	1	1	1	1	1	1752353-2	GUIDE PIN,HOLDDOWN	175	
	-	1	1	1	1	1	1901680-2	GUIDE PIN,HOLDDOWN	174	
	-	-	-	-	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	
	-	-	-	-	-	1	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854	137	
	-	-	REFREF	-	-	-	SEE NOTE 4	MEMORY CHIP, PROGRAMMED	135	
	-	-	1	1	-	-	1633743-1	SERVO FEED LATCH ASM	133	
	-	1	1	1	1	1	2119955-2	ASSY, LUBRICATOR, END FEED	84	
	-	1	1	1	1	1	455888-5	SPACER, CRIMPER	82	
	-	1	1	1	1	1	2119791-5	DEPRESSOR, WIRE	73	
	-	1	1	1	1	1	2119956-2	DOCUMENTATION PACKAGE	71	
	-	2	2	2	2	2	2-18032-2	SCR, SET, FLT POINT M3 X 10.0	70	
	-	1	1	1	1	1	2119943-1	WASHER, SPACER	69	
	-	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	1	1901681-5	HOLDDOWN, TERMINAL	65	
	-	1	-	1	1	1	2119793-1	LIMITER, ADJUSTMENT BOLT	63	
6	-	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	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59	
	-	-	-	-	-	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	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	56	
	-	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	1	1	1	1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52	
	-	-	-	-	-	1	2119792-2	PAWL, EF, AIR	51	
	-	1	1	1	1	1	1-1976055-0	STANDOFF, HOLD-DOWN	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	2119655-5	APPLICATOR BASIC ASSEMBLY, EF	46	
	-	1	-	1	1	1	2119369-1	RAM,AMP STYLE, END 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	
6	-	1	1	1	1	1	1-2119644-2	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	
	-	8	8	8	8	8	1-18028-2	WASHER, FLAT, REG M4	33	
	-	2	2	2	2	2	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	31	
	-	2	2	2	2	2	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	29	
	-	1	1	1	1	1	240639-1	STRIPPER (MACHINING)	27	
	-	2	2	2	2	2	1320906-1	STUD, THREADED	25	
	-	1	1	1	1	1	1-1752371-2	PLATE, STRIP GUIDE	24	
	-	2	2	2	2	2	2-22281-3	SPRING, COMPRESSION	22	
	-	1	1	1	1	1	1752373-4	DRAG	20	
	-	2	2	2	2	2	1901259-7	GUIDE, LOWER STRIP	18	
1	-	4	4	4	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17	
	-	1	1	1	1	1	1752360-1	SPACER,HOLD-DOWN	13	
	-	1	1	1	1	1	240644-5	PLATE, REAR SHEAR	11	
1	-	1	1	1	1	1	6-690482-7	PLATE, FRONT SHEAR	9	
1	1	1	1	1	1	1	1803059-4	ANVIL, COMBINATION, END FEED	8	
1	-	1	1	1	1	1	1-2217206-3	BLADE, SLUG	7	
	-	-	-	-	-	-	-	-	6	
	-	1	1	1	1	1	3-240641-5	SPACER	5	
	-	1	1	1	1	1	2-238009-9	BLOCK, FL CRIMPER SPACER	4	
1	1	1	1	1	1	1	8-2119582-3	CRIMPER, INSULATION F PREMIUM	3	
	-	1	1	1	1	1	455888-3	SPACER, CRIMPER	2	
1	1	1	1	1	1	1	6-1633730-7	CRIMPER, WIRE	1	
	-77	-7	-6	-5	-2	-1	PART NO	DESCRIPTION	ITEM NO	

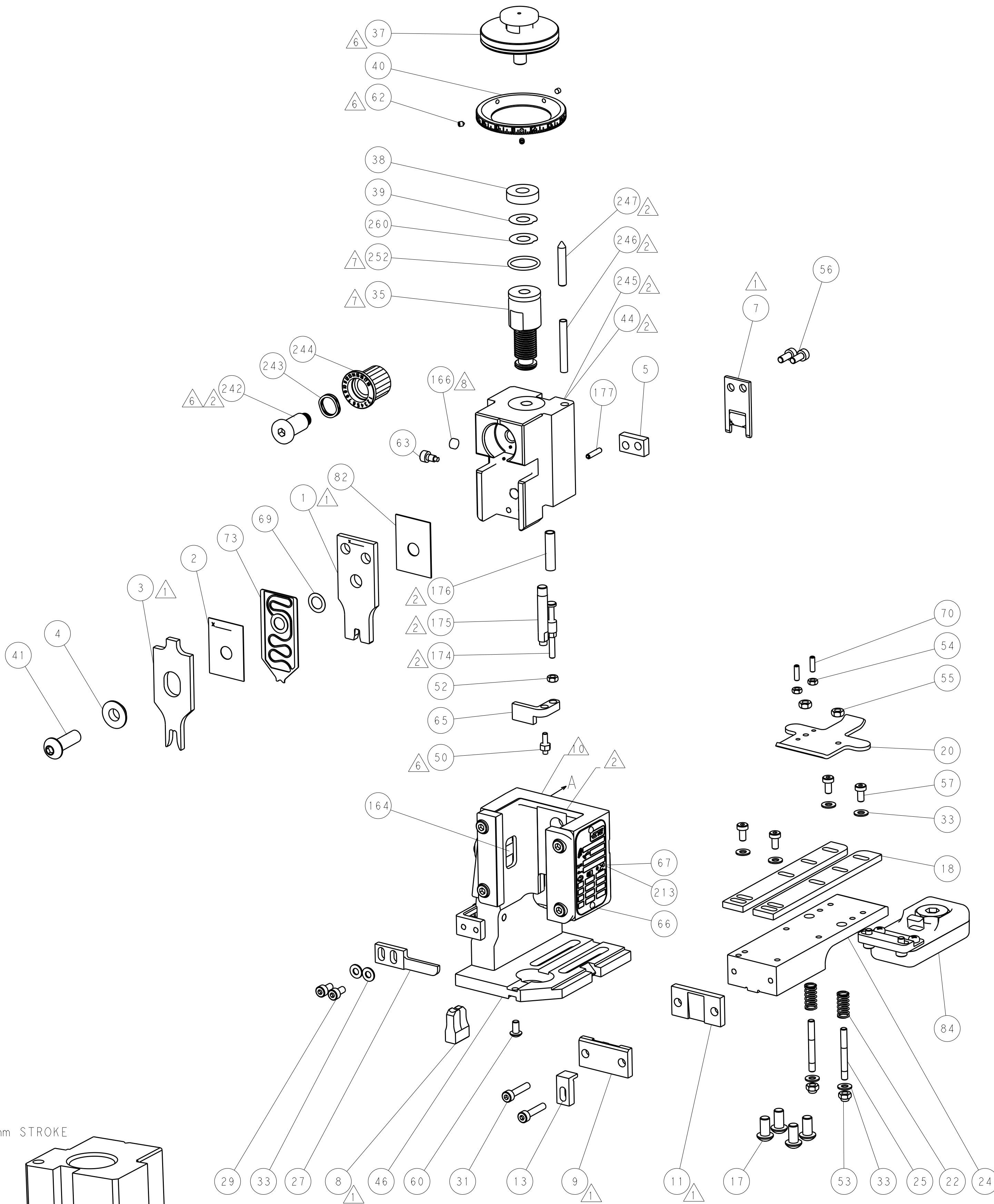
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DIMENSIONS: mm		CHK G. BAILEY 08MAY2013	NAME Ocean End Feed Applicator	
		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.5 1 PLC ±.5 2 PLC ±.5 3 PLC ±.5 4 PLC ±.5 ANGLES ±.0001 FINISH ±.	PRODUCT SPEC APPLICATION SPEC	
MATERIAL -		APVD J. GUO 08MAY2013	WEIGHT -	
CUSTOMER ACCESSIBLE PRODUCTION DRAWING		SIZE A	CAGE CODE 00779	DRAWING NO C=2150338
		SCALE 1:1	SHEET 1	OF 4
		REV A	RESTRICTED TO -	

SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

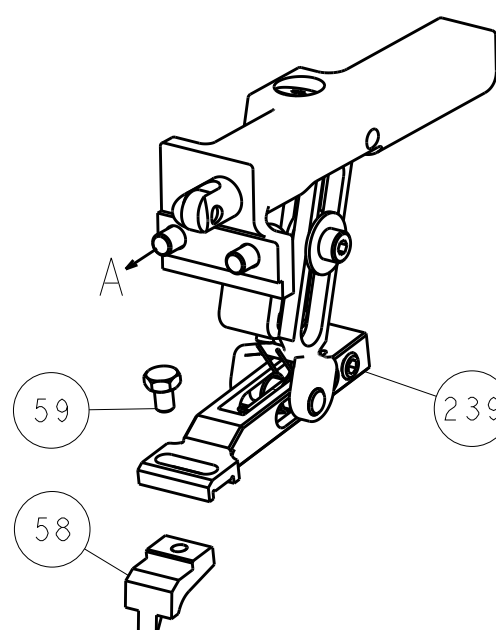
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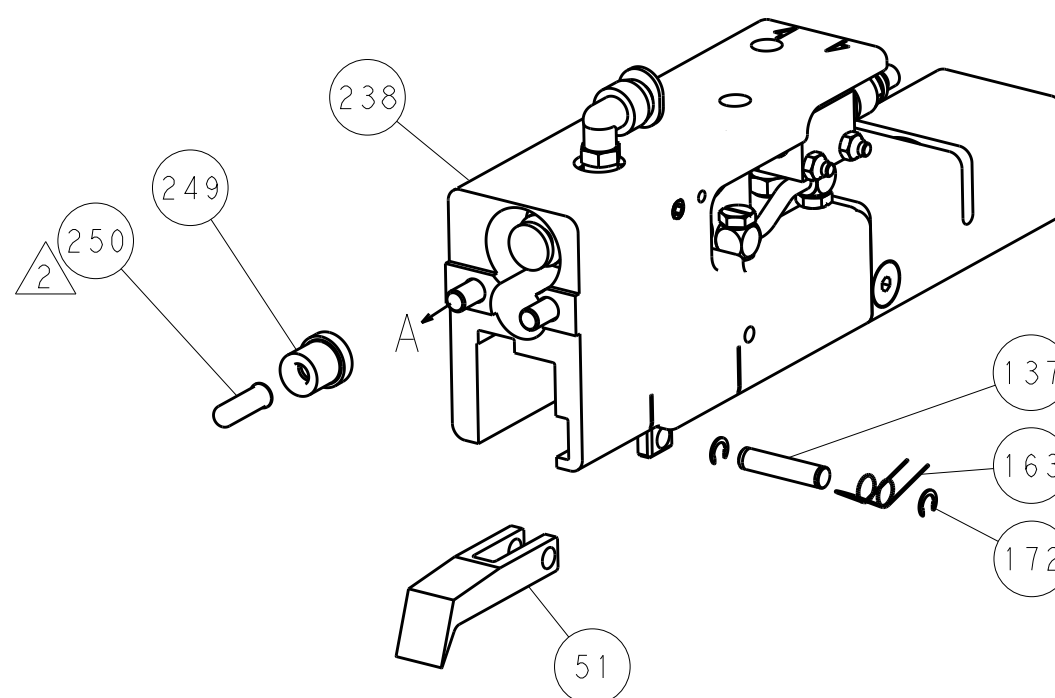
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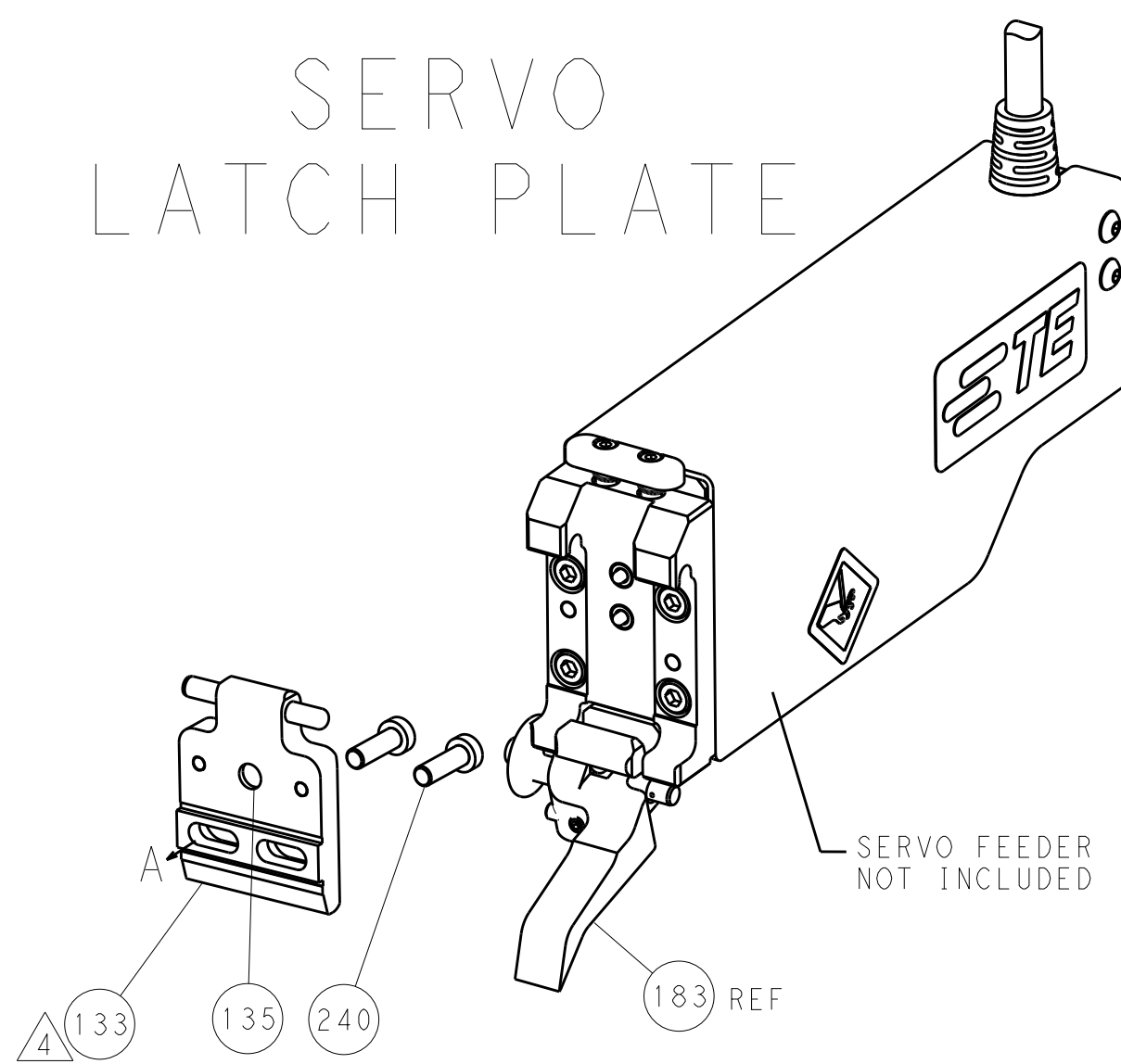
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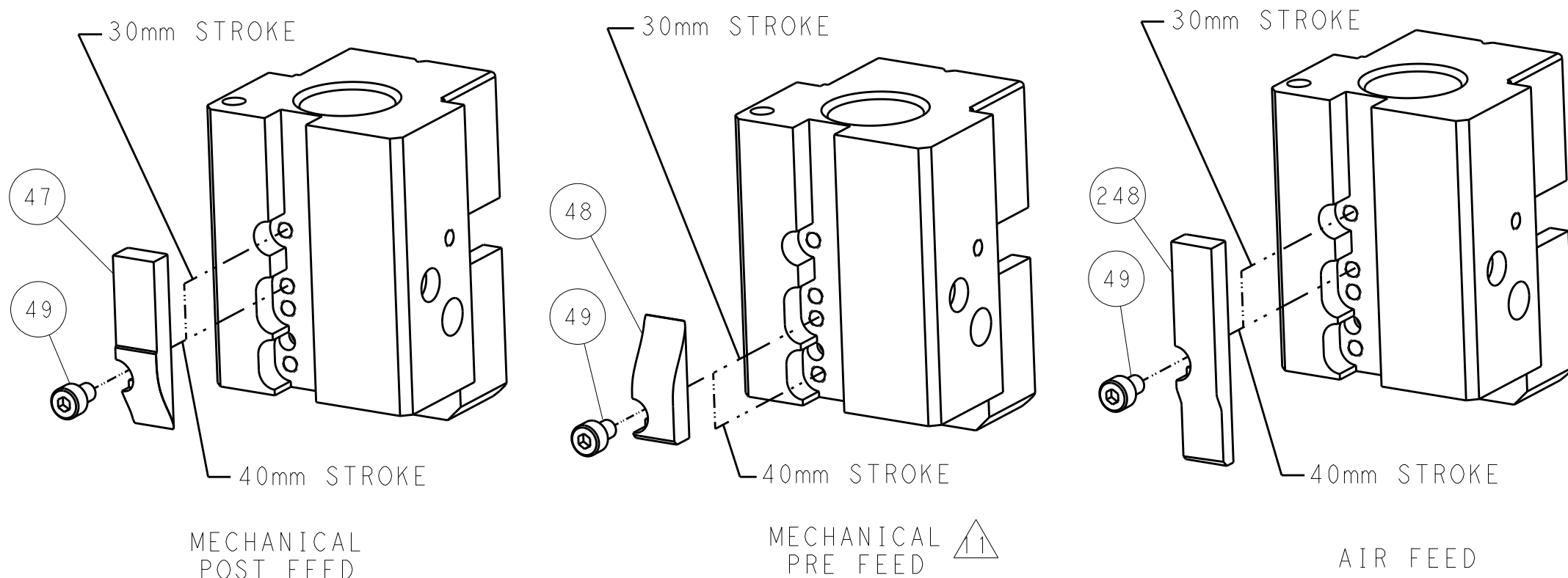
PNEUMATIC



SERVO
LATCH PLATE



CAM POSITIONS

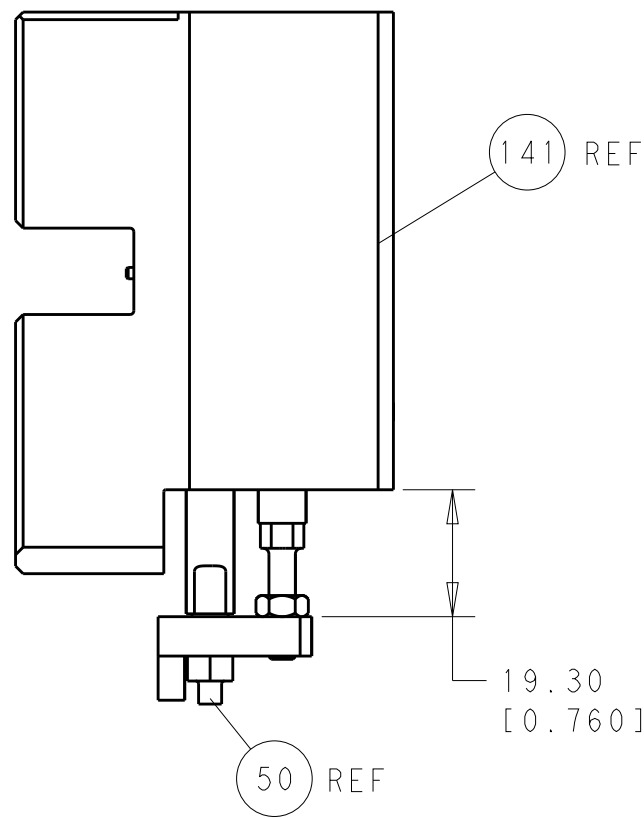


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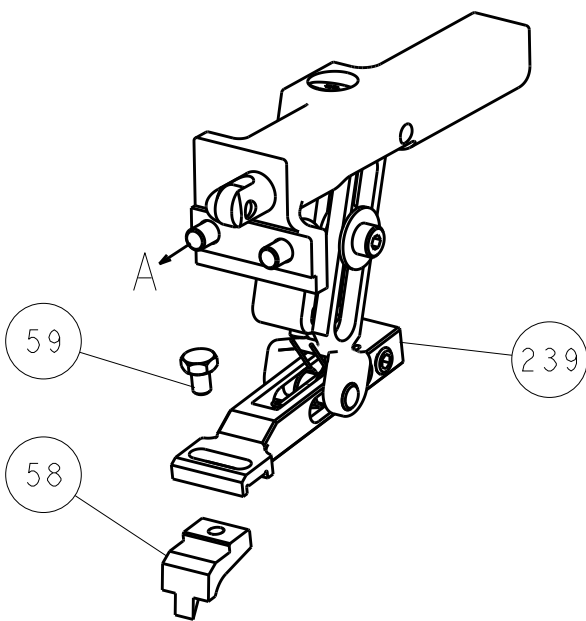
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		1 PLC ±0.13		APVD H. GUO 08MAY2013		NAME	
		2 PLC ±0.13		PRODUCT SPEC		Ocean End Feed	
		3 PLC ±0.013		APPLICATION SPEC		Applicator	
		4 PLC ±0.0001		WEIGHT		SIZE	
		FINISH		CAGE CODE		DRAWING NO	
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				SHEET		2 OF 4	
				REV		A1	

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

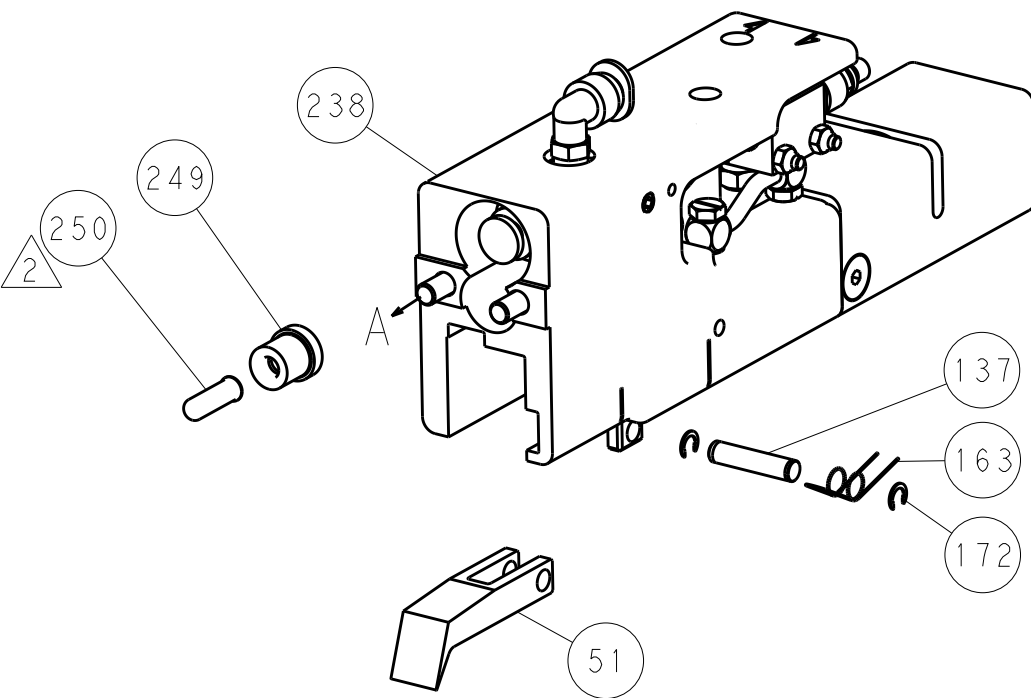
HOLDDOWN SET-UP



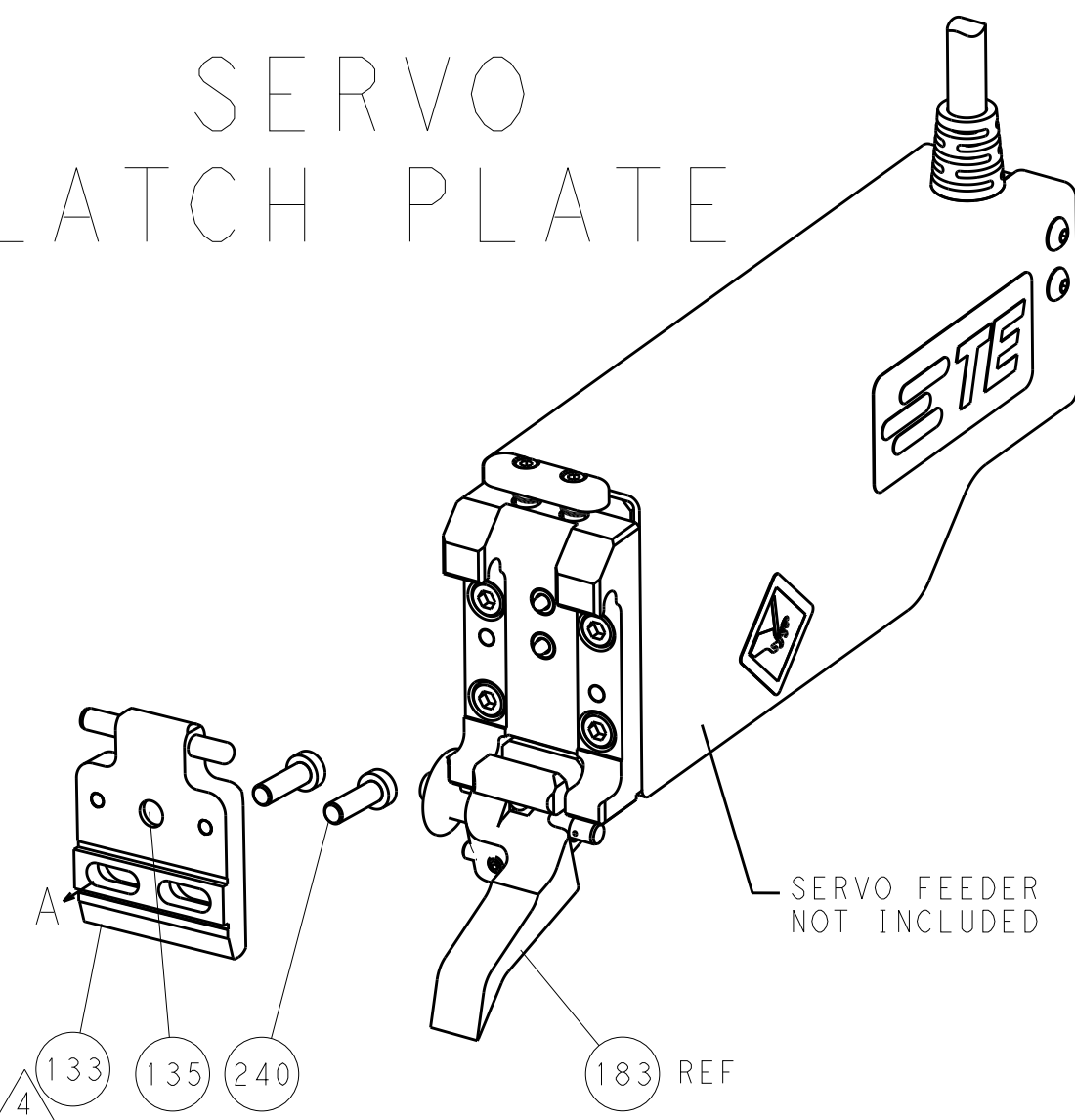
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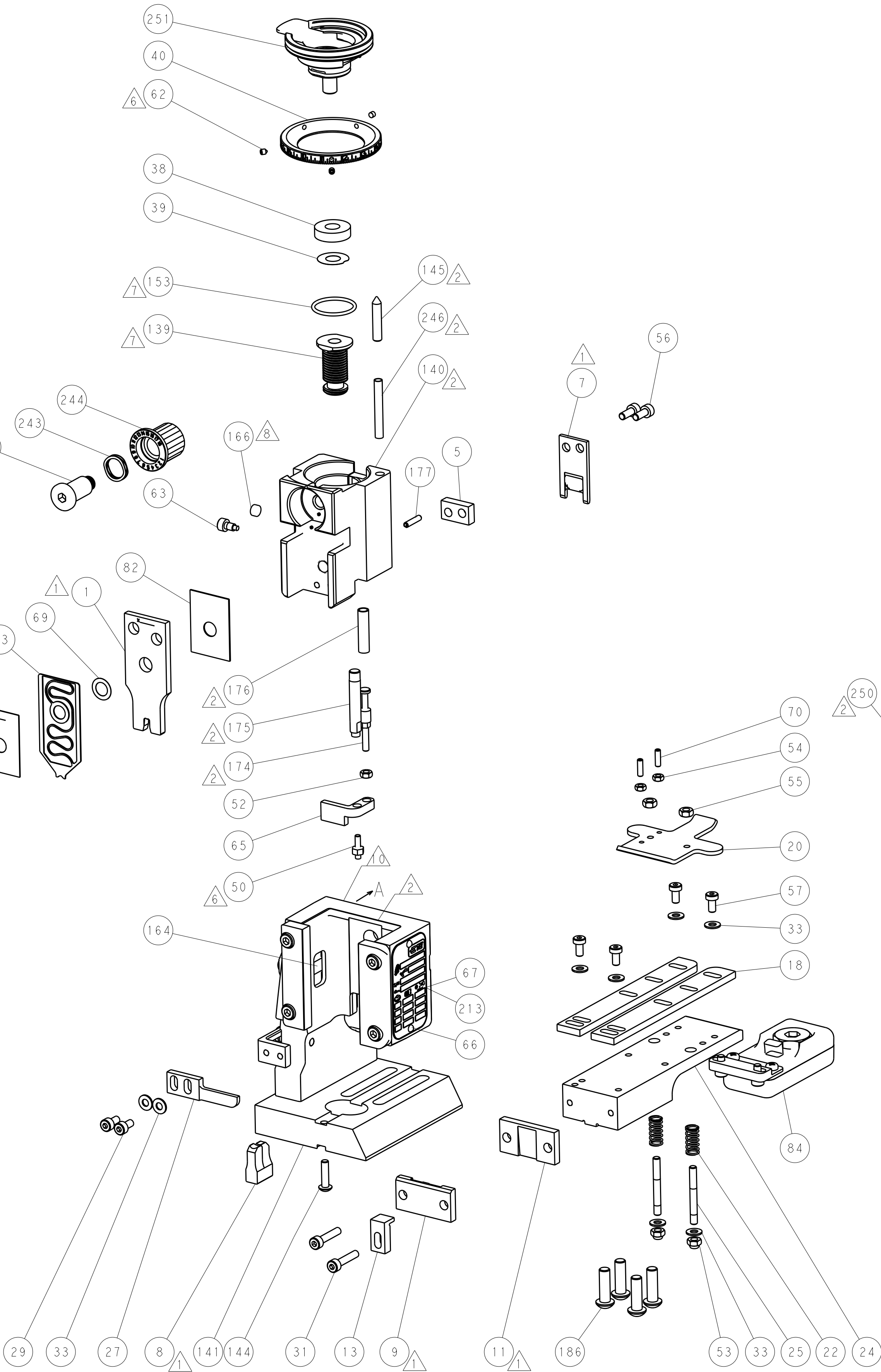
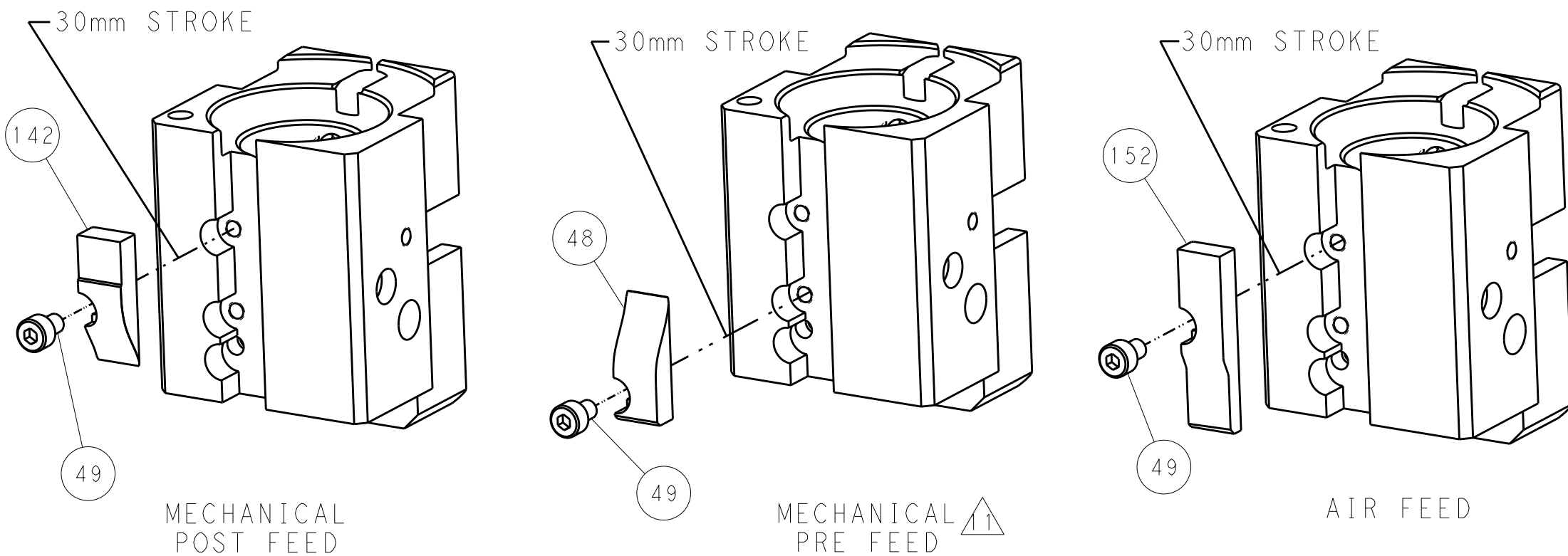
PNEUMATIC



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)

1ST PUBLISHED BY: CHANGHAI ELECTRONIC CORPORATION 1ST IS SUBJECT TO CHANGHAI ELECTRONIC CORPORATION'S ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST NOTATION.		DWN Y. YIN 08MAY2013	STE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm		CHK G. BAILEY 08MAY2013	NAME Ocean End Feed Applicator	
TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.5 1 PLC ±0.13 2 PLC ±0.13 3 PLC ±0.013 4 PLC ±0.001 ANGLES ±.1		APVD J. GUO 08MAY2013	SIZE A1	
MATERIAL -		PRODUCT SPEC -	CAGE CODE 00779	
FINISH -		APPLICATION SPEC -	DRAWING NO C-2150338	
-		WEIGHT -	CUSTOMER ACCESSIBLE PRODUCTION DRAWING	
-		SCALE 1:1	SHEET 4 OF 4	
-		REV A1	-	