

8

7

6

5

4

3

2

1

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ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER

PART NUMBER

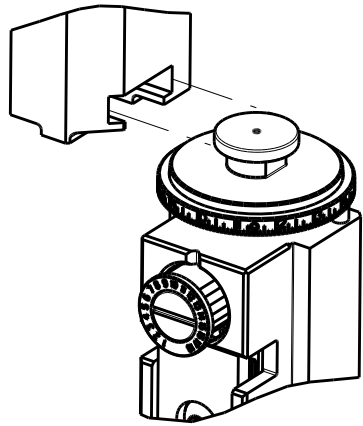
REVISION

DESCRIPTION

FEED TYPE

CONVERT TO

PART NUMBERS REQUIRED



2150311-2

A

FINE CRIMP HEIGHT ADJUST

PNEUMATIC

SERVO LATCH PLATE
SMART APPLICATOR

2119951-1
2161326-1

1901697-1
-

8-2150311-5
8-2150311-4

-
-

-
-

2168400-7 (QUANTITY 2)



2150311-5

A

FINE CRIMP HEIGHT ADJUST

SERVO LATCH PLATE

PNEUMATIC FEED

2119950-1

2119792-2

-

2119641-1

-

-

2063440-2



2150311-6

A

NON-CRIMP HEIGHT ADJUST

SERVO LATCH PLATE

-

-

-

-

-

-



2150311-7

A

FINE CRIMP HEIGHT ADJUST

NONE

-

-

-

-

-

-



7-2150311-7

A

CRIMP TOOLING KIT

-

-

-

-

-

-

APPLICATOR DATA

CRIMP

SIZE

TYPE

WIRE

2.03 mm [.080]

F

INSUL

3.56 mm [.140]

F

APPL INSTRUCTIONS

408-10390



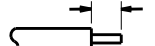
TERMINAL DATA: LEAR TERMINAL

TE CRIMP SPECIFICATION

TERMINAL NAME: TERMINAL

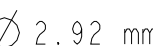
WIRE STRIP LENGTH

4.75-5.35 mm [.187-.211 IN]



INSULATION DIAMETER RANGE

Ø 2.92 mm MAX [0.115 IN MAX]



TERMINAL APPLICATION SPECIFICATION

TE SPEC

-

-

-

-

-

TERMINALS APPLIED



TE TERMINAL

LEAR TERMINAL

TE TERMINAL

LEAR TERMINAL

2114314-1

25697.126.009

2113314-4

25697.213.009

2114314-2

25697.126.142

2113314-5

25697.213.141

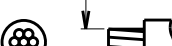
2114314-3

25697.126.178

2113314-6

25697.213.178

WIRE SIZE



CRIMP HEIGHT

mm [INCH]



CRIMP HEIGHT REFERENCE SETTING



1.00mm2

1.49+/-0.05 [1.059+/-0.002]

7.8

0.75mm2

1.39+/-0.05 [1.055+/-0.002]

8.8

0.50mm2

1.29+/-0.05 [1.051+/-0.002]

10.0



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:
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150311-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150311-5
SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2150311-6

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, 180 & 242.
FOR -6 ONLY APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 37, 180 & 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 TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED



11 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

-

-

1

-

-

2119957-2

APPLICATOR SHIM PACK

260

-

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

PART NO

DESCRIPTION

ITEM NO

ATLANTIC VERSION

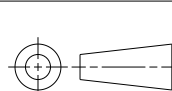
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(Pacific version shown on sheets 3 of 4 & 4 of 4)

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DIMENSIONS:

mm



0 PLC ±.5

1 PLC ±0.5

2 PLC ±0.13

3 PLC ±0.013

4 PLC ±0.0001

ANGLES ±.5

FINISH

MATERIAL

-

DRAWN

T. YIN

22JAN2013

CHK

G. BAILEY

22JAN2013

APVD

S. XI

22JAN2013

PRODUCT SPEC

-

APPLICATION SPEC

-

WEIGHT

-

CUSTOMER ACCESSIBLE PRODUCTION DRAWING

SCALE

1:1

SHEET

1

OF

4

REV

A

REVISIONS

DESCRIPTION

DATE

OWN

APVD

1

DEVELOPMENT

22JAN2013

YY

SX

2

RELEASED

22MAR2013

YY

UG

-

-

-

-

1

2079988-1

BUSHING, LCH5-12, MISUMI

249

-

-

-

-

1

2119641-1

FEED CAM, AIR FEED

248

-

1

-

-

1

2119798-1

DETENT PIN

247

-

1

-

1

1

1-22279-3

SPRING, COMPRESSION

246

-

-

1

-

-

2119759-1

RAM, AMP STYLE, END FEED, NON-ADJUST

245

-

1

1

1

1

2119082-9

CAM, SNAIL, INSULATION ADJUSTMENT

244

-

1

1

1

1

2079764-1

WASHER, WAVE SPRING, CREST-TO-CREST

243

-

1

1

1

1

2119083-1

RETAINER, INSULATION DIAL

242

-

-

2

2

-

2168400-7

SHCS, LOW HEAD, RoHS, M5 X 10

240

-

-

-

-

-

2119580-1

MECHANICAL FEED ASSEMBLY

239

-

-

-

-

1

2063440-2

AIR FEED MODULE

238

-

-

1

1

-

2119740-2

TAG, IDENTIFICATION

213

-

-

REFREF

-

-

1901697-1

FEED FINGER ASSEMBLY, EF

183

-

1

1

1

1

1976055-3

STANDOFF, HOLD-DOWN

180

-

1

1

1

1

6-993111-6

PIN, SLOTTED SPRING 3.0 X 14.0

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

-

1

1

1

1

994969-1

MAGNET, RARE EARTH HIGH ENERGY

166

-

REFREFREFREFREF

-

-

-

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

455888-4

SPACER, CRIMPER

82

-

1

1

1

1

2119956-2

DOCUMENTATION PACKAGE

71

-

2

2

2

2

2-18032-2

SCR, SET, FLT POINT M3 X 10.0

70

-

-

-

-

-

2119740-1

TAG, IDENTIFICATION

67

-

2

2

2

2

2168078-1

SCREW, DRIVE, RH, RoHS

66

-

1

1

1

1

1976052-1

HOLDDOWN, TERMINAL

65

-

1

-

1

1

2119793-1

LIMITER, ADJUSTMENT BOLT

63

-

3

-

3

3

992763-5

SCR, SET, SOC, CONE POINT, M3 x 4.0

62

-

1

1

1

1

2079383-4

SCR, BHSC, RoHS (M4 X 8)

60

-

-

-

-

-

2063961-1

FEED FINGER

58

-

4

4

4

4

2168400-4

SHCS, LOW HEAD, RoHS, M4 X 8

57

-

2

2

2

2

2168083-9

SCR, SKT HD CAP, RoHS, M4 X 20

56

-

2

2

2

2

5018030-2

NUT, HEX, REG, RoHS, M4

55

-

2

2

2

2

5018030-1

NUT, HEX, REG, RoHS, M3

54

-

2

2

2

2

986965-8

NUT, LOCK, HEX, TORQUE (M4)

53

-

1

1

1

1

1-5018030-0

NUT, HEX, REG, RoHS, M3.5

52

-

-

-

-

1

2119792-2

PAWL, EF, AIR

51

-

-

-

-

1

18023-9

SCR, SKT HD CAP M4 X 6.0

49

-

1

1

1

1

2119655-5

APPLICATOR BASIC ASSEMBLY, EF

46

-

1

-

1

1

2119369-1

RAM, AMP STYLE, END 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

-

1

1

1

1

1-2119644-2

RAM WASHER, PRECISION

38

-

1

1

1

1

2119085-1

FA HEAD, ATLANTIC STYLE

37

-

1

-

1

1

2119092-1

BOLT, ADJUSTMENT

35

-

8

8

8

8

1-18028-2

WASHER, FLAT, REG M4

33

-

2

2

2

2

2168083-9

SCR, SKT HD CAP, RoHS, M4 X 20

31

-

2

2

2

2

1-2168083-0

SCR, SKT HD CAP, RoHS, M4 X 10

29

-

1

1

1

1

240639-1

STRIPPER (MACHINING)

27

-

2

2

2

2

1320906-1

STUD, THREADED

25

-

1

1

1

1

1752371-5

PLATE, STRIP GUIDE

24

-

2

2

2

2

2-22281-3

SPRING, COMPRESSION

22

-

1

1

1

1

1752373-4

DRAG

20

-

1

1

1

1

1901696-3

STRIP GUIDE, REAR

19

-

1

1

1

1

1901695-3

STRIP GUIDE, FRONT

18

-

4

4

4

4

1-2079383-1

SCR, BHSC, RoHS (M6 X 12)

17

-

1

1

1

1

1752360-1

SPACER, HOLD-DOWN

13

-

1

1

1

1

240644-1

PLATE, REAR SHEAR

11

-

1

1

1

1

690482-3

PLATE, FRONT SHEAR

9

-

1

1

1

1

1-1803001-3

ANVIL, COMBINATION, END FEED

8

-

1

1

1

1

1-2217206-4

BLADE, SLUG

7

-

-

-

-

-

-

-

6

-

1

1

1

1

7-240641-6

SPACER

5

-

1

1

1

1

238009-1

BLOCK, FL CRIMPER SPACER

4

-

1

1

1

1

2-1633961-3

CRIMPER, INSULATION F PREMIUM

3

-

1

1

1

1

1-455888-1

SPACER, CRIMPER

2

-

1

1

1

1

2-456405-5

CRIMPER, WIRE PREMIUM

1

-77

-7

-6

-5

-2

PART NO

DESCRIPTION

ITEM NO

ATLANTIC VERSION

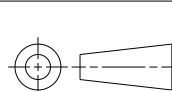
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DIMENSIONS:

mm



0 PLC ±.5

1 PLC ±0.5

2 PLC ±0.13

3 PLC ±0.013

4 PLC ±0.0001

ANGLES ±.5

FINISH

MATERIAL

-

DRAWN

T. YIN

22JAN2013

CHK

G. BAILEY

22JAN2013

APVD

S. XI

22JAN2013

PRODUCT SPEC

-

APPLICATION SPEC

-

WEIGHT

-

CUSTOMER ACCESSIBLE PRODUCTION DRAWING

SCALE

1:1

SHEET

1

OF

4

REV

A

REVISIONS

DESCRIPTION

DATE

OWN

APVD

1

DEVELOPMENT

22JAN2013

YY

SX

2

RELEASED

22MAR2013

YY

UG

AMP 4805 REV 31MAR2000

1

SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

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

FEED TYPE

PNEUMATIC

SERVO
LATCH PLATE

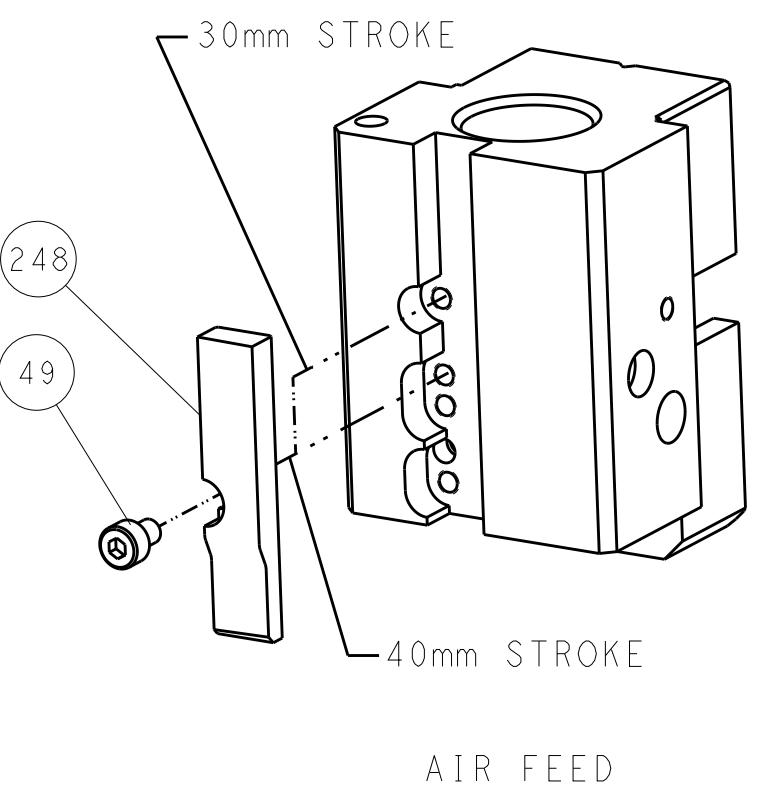
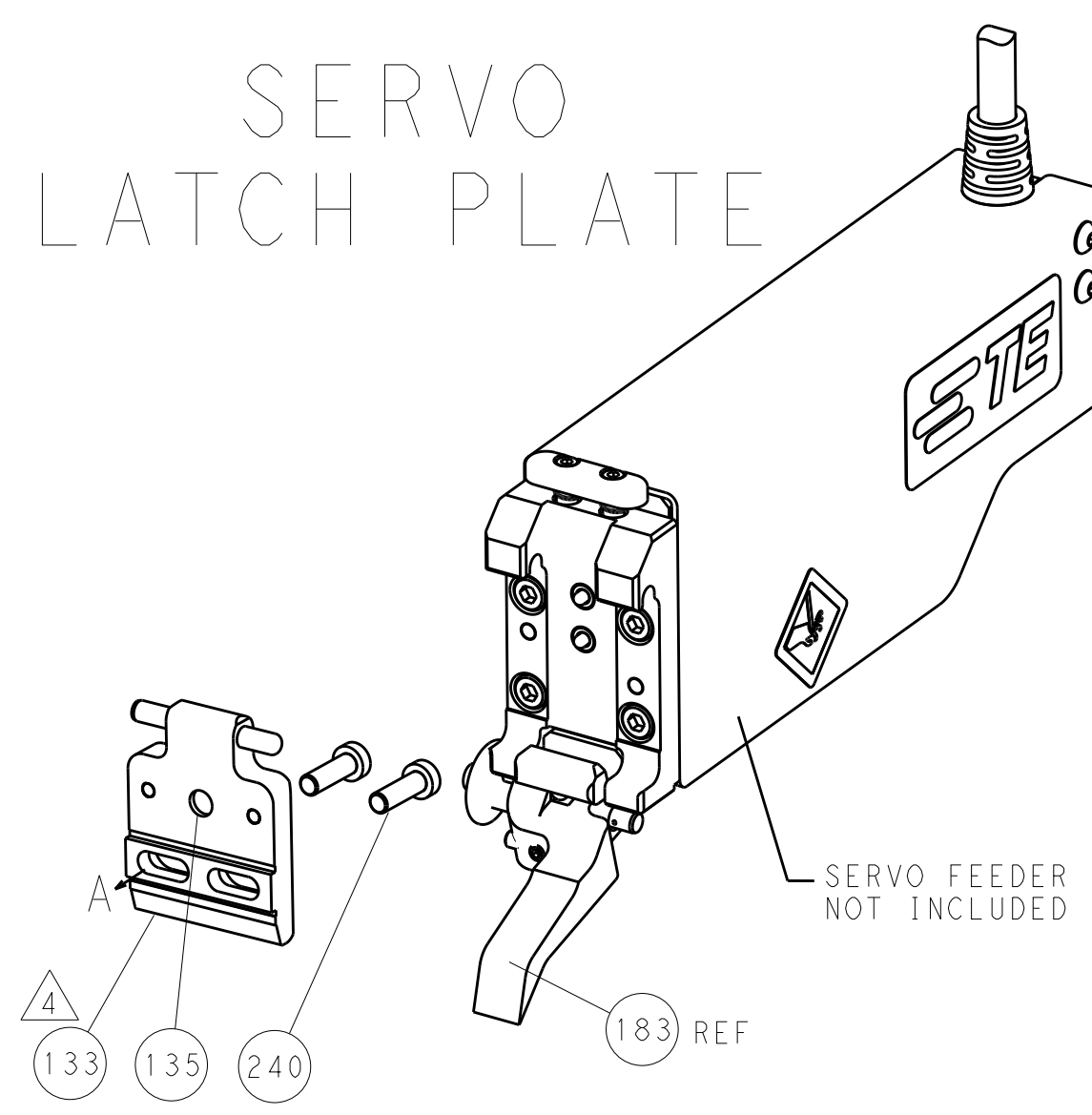
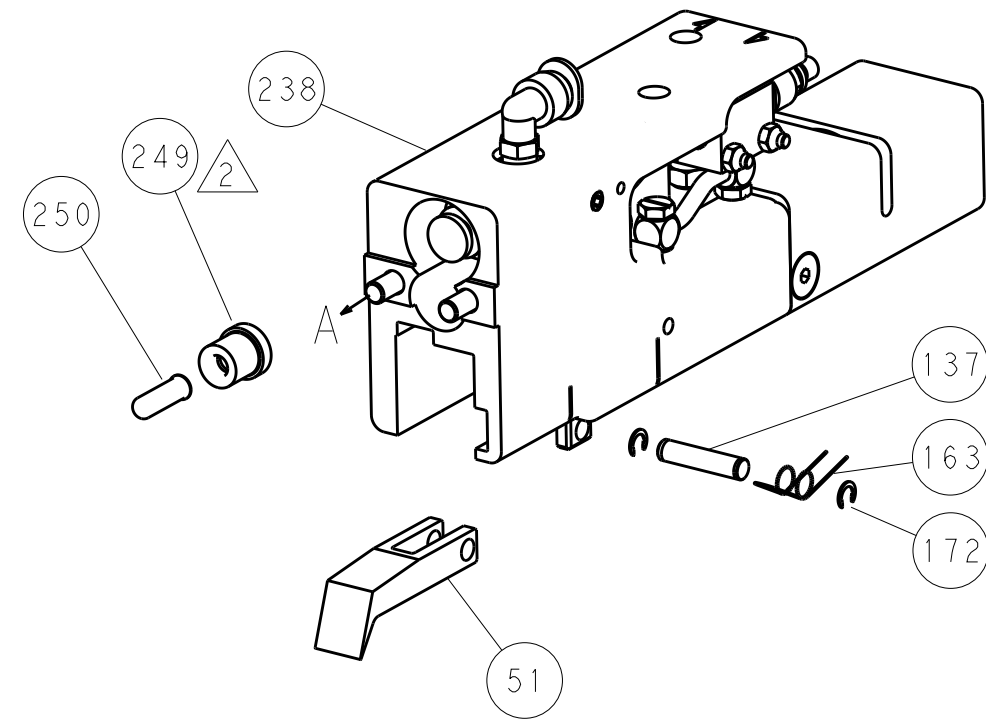
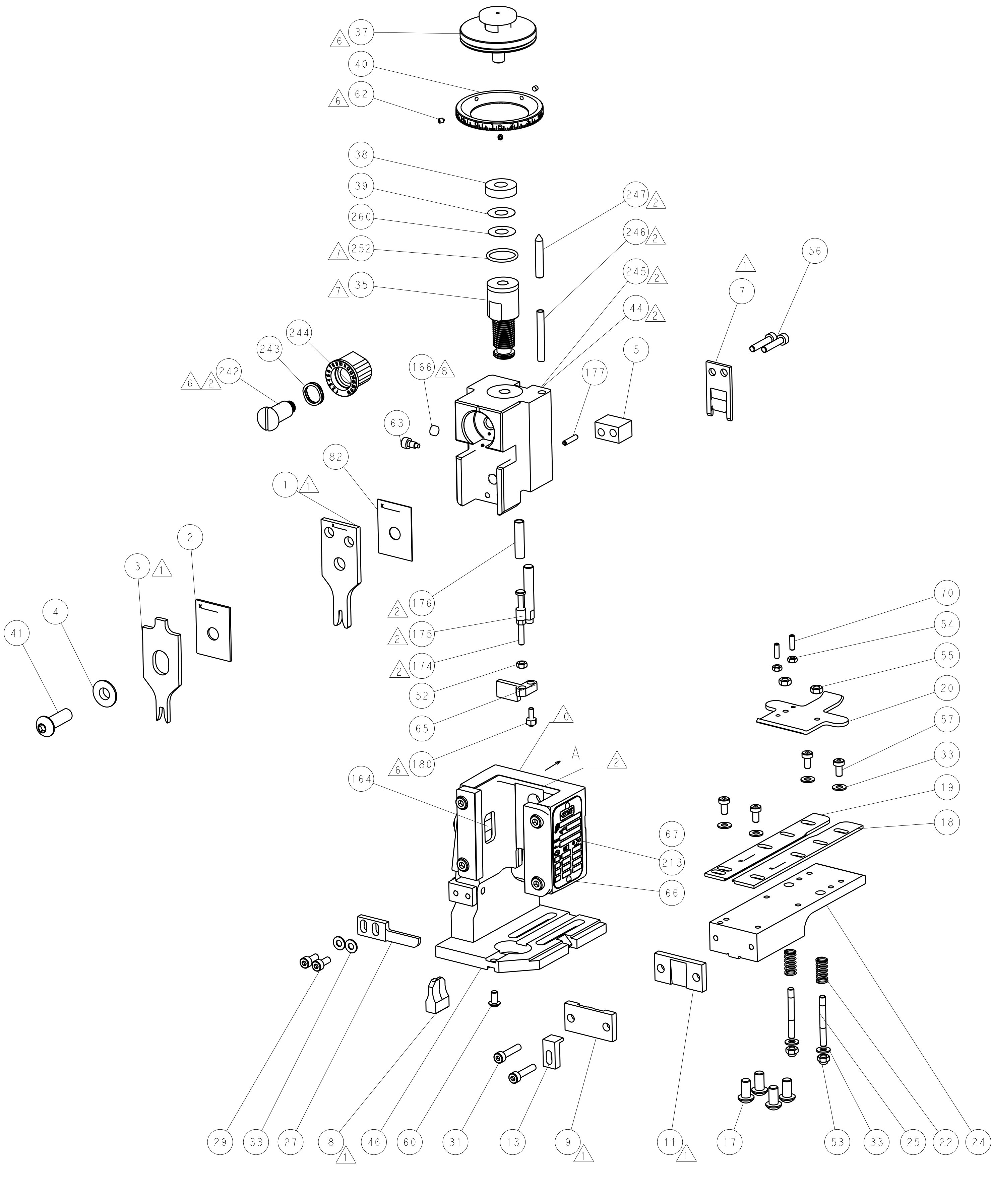
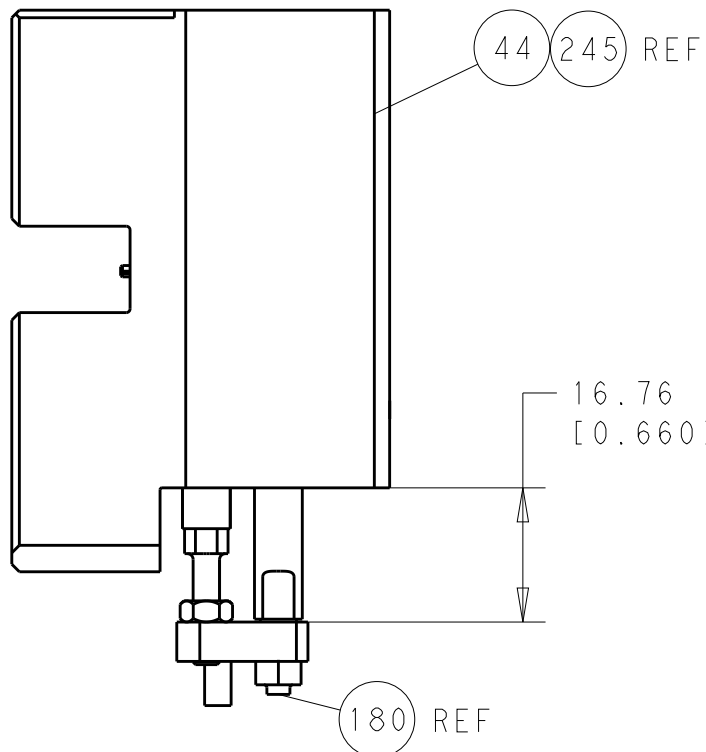
CAM POSITION

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 G. BAILEY	22JAN2013		
				APVD S. XI	22JAN2013	NAME Ocean End Feed Applicator	
				PRODUCT SPEC		SIZE A1	
				APPLICATION SPEC		CAGE CODE 00779	
				WEIGHT		DRAWING NO C=2150311	
				CUSTOMER ACCESSIBLE PRODUCTION DRAWING		SCALE 1:1	
						SHEET 2 OF 4	
						REV A	

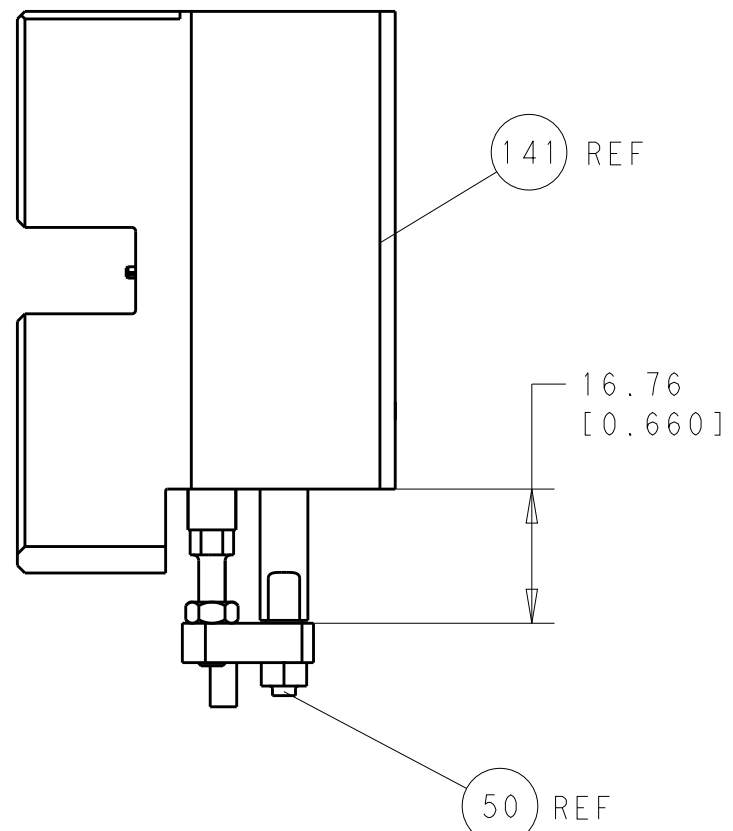
SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

DIMENSIONING AND TOLERANCING PER ASME Y14.5M-2003



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

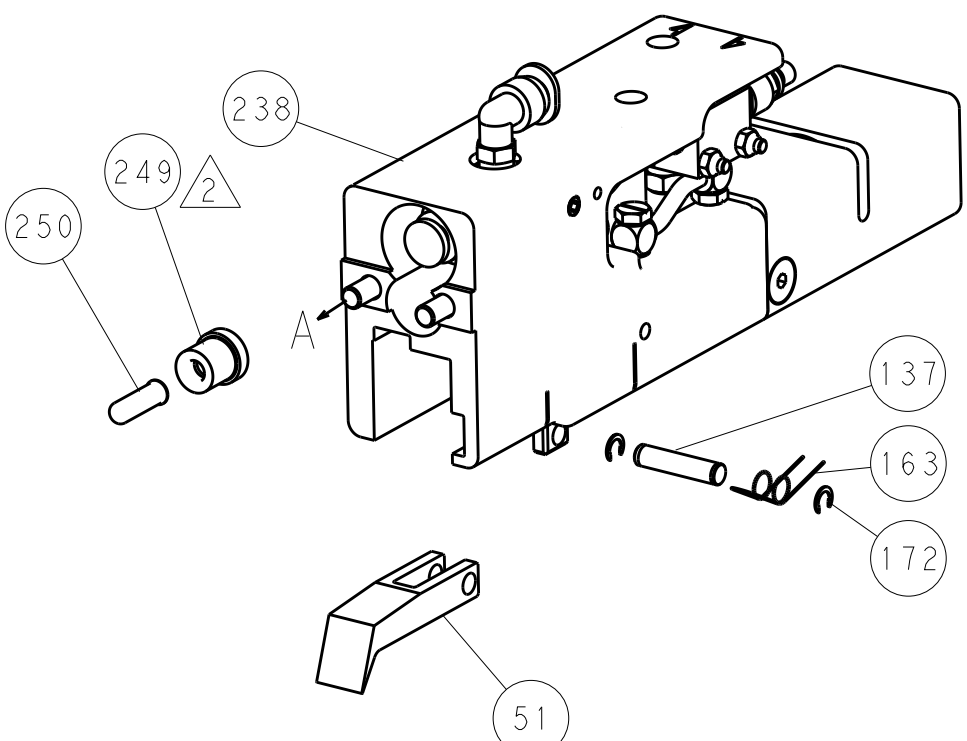
DIMENSIONING AND TOLERANCING PER ASME Y14.5M-2003



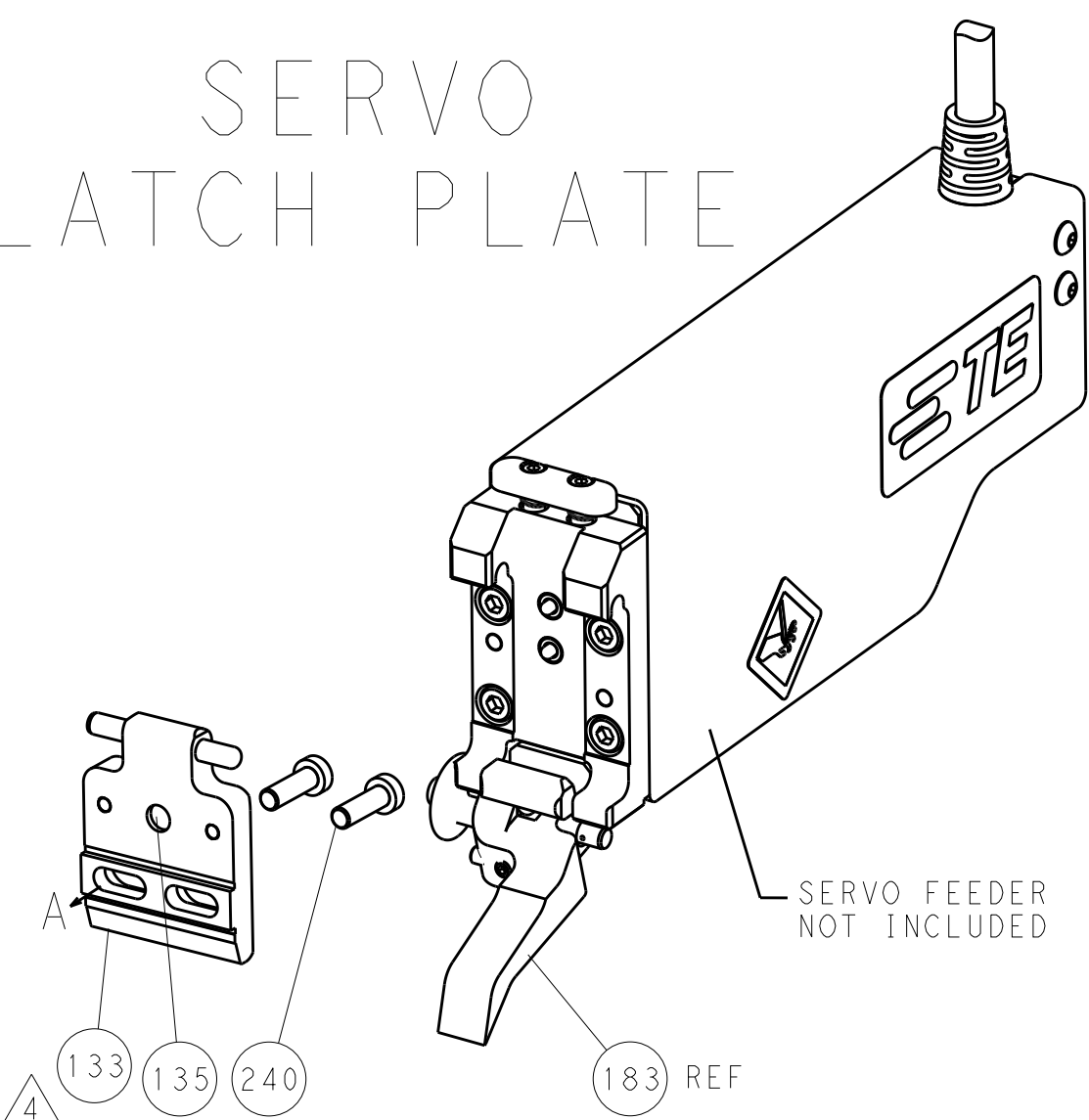
HOLDDOWN SET-UP

FEED TYPE

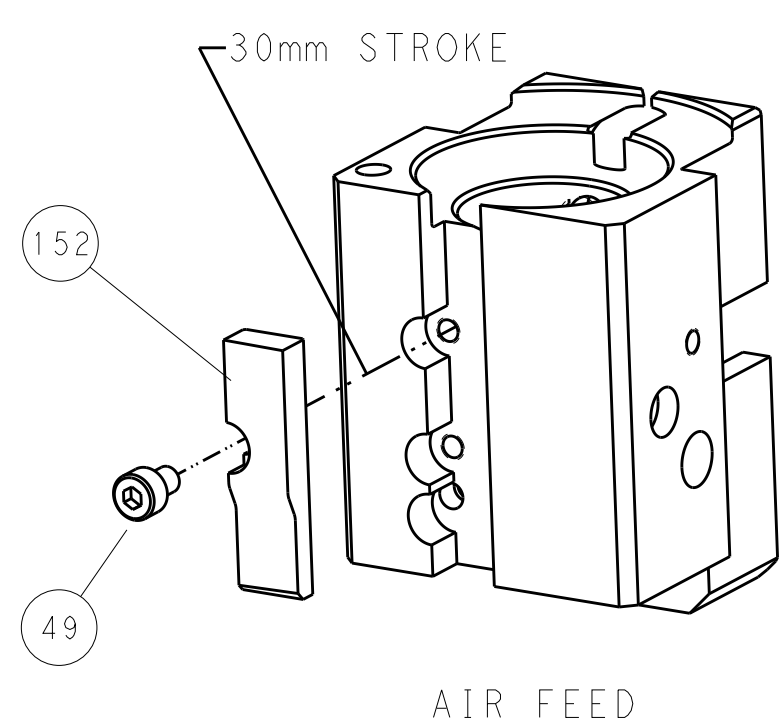
PNEUMATIC



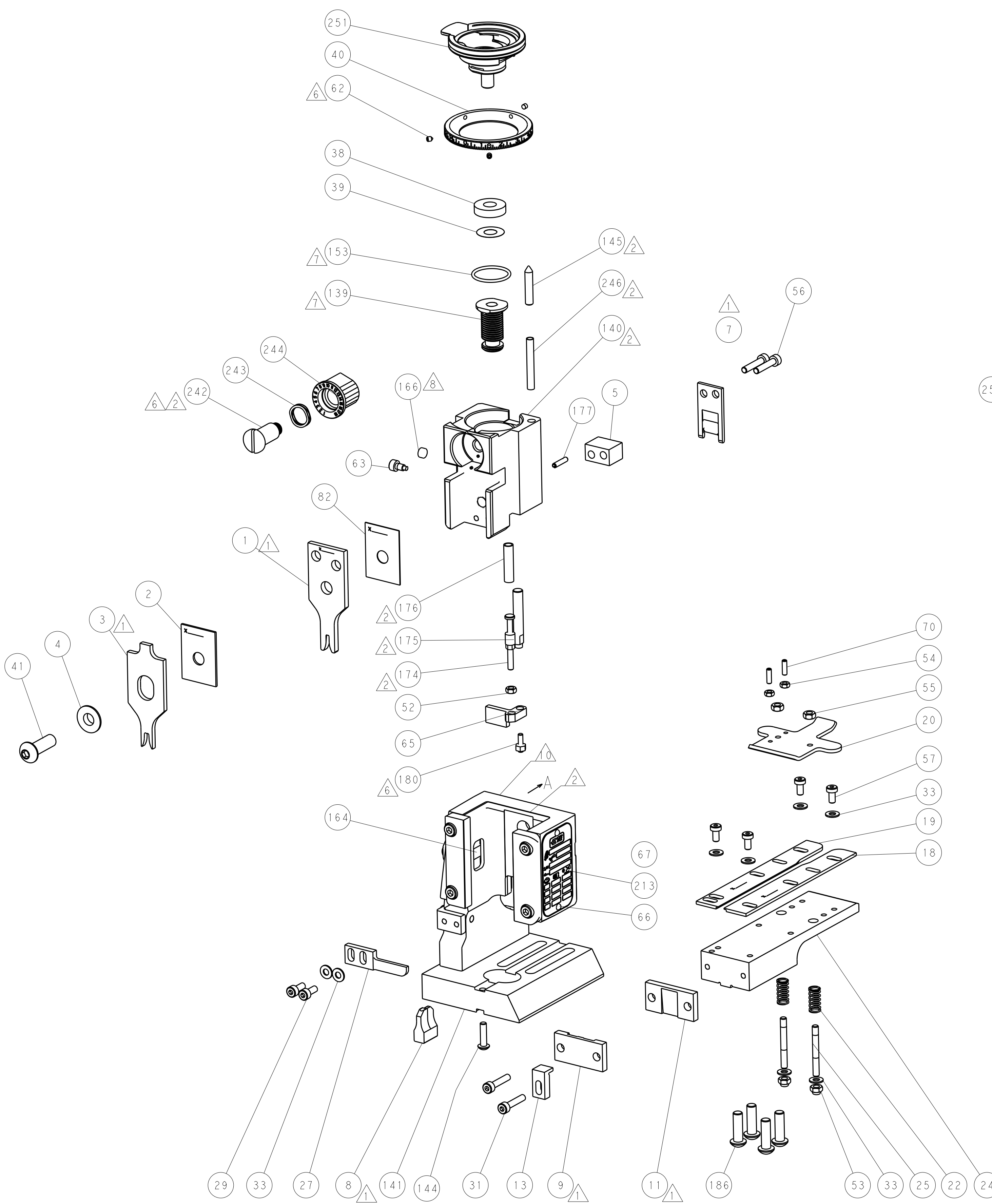
SERVO LATCH PLATE



CAM POSITION



AIR FEED



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

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DIMENSIONS:				CHK G BAILEY 22JAN2013		
mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		APVD S YI 22JAN2013		NAME
		0 PLC ±.5 1 PLC ±0.5 2 PLC ±0.13 3 PLC ±0.013 4 PLC ±0.0001		PRODUCT SPEC		Ocean End Feed Applicator
		FINISH		APPLICATION SPEC		
MATERIAL		WEIGHT		SIZE		
				CAGE CODE		
				DRAWING NO	RESTRICTED TO	
				A 00779	C=2150311	
CUSTOMER ACCESSIBLE PRODUCTION DRAWING				SCALE	1:1	
				SHEET	4 OF 4	
				REV	A	