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RELEASED FOR PUBLICATION

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ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER

PART NUMBER

REVISION

DESCRIPTION

FEED TYPE

CONVERT TO

PART NUMBERS REQUIRED

2150278-2

A

FINE CRIMP HEIGHT ADJUST

PNEUMATIC

SERVO LATCH PLATE

2119951-1

1901697-2

8-2150278-5

-

-

2168400-7 (QUANTITY 2)

2150278-5

A

FINE CRIMP HEIGHT ADJUST

SERVO LATCH PLATE

2161326-1

-

8-2150278-4

-

-

-

2150278-6

A

NON-CRIMP HEIGHT ADJUST

SERVO LATCH PLATE

2119950-1

2119792-1

-

2119641-1

-

2063440-1

2150278-7

A

FINE CRIMP HEIGHT ADJUST

NONE

-

-

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7-2150278-7

A

CRIMP TOOLING KIT

-

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APPLICATOR DATA

CRIMP

SIZE

TYPE

WIRE

5.11 mm [.201]

D

INSUL

-

-

APPL INSTRUCTIONS

408-10390

TERMINAL DATA: TE TERMINAL

TE CRIMP SPECIFICATION

TERMINAL NAME: RECPT, ULTRA-FAST FLAG, .187 SERIES

WIRE STRIP LENGTH

7.51-8.33 mm [.296-.328 IN]

INSULATION DIAMETER RANGE

Ø0.00-4.19 mm [.000-.165 IN]

TERMINAL APPLICATION SPECIFICATION

114-2123

-

-

TERMINALS APPLIED

9

TE TERMINAL

TE TERMINAL

TE TERMINAL

TE TERMINAL

2-520334-2

9-520334-2

5-520336-2

5-520334-2

2-520336-2

9-520336-2

WIRE SIZE

CRIMP HEIGHT mm [INCH]

CRIMP HEIGHT REFERENCE SETTING

Ø SOLDER

18 OR (2) 22

1.79+/-0.05 [.070+/- .002]

5.0

.19 in [4.83mm]

22 OR 20

1.65+/-0.05 [.065+/- .002]

6.5

.19 in [4.83mm]

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: 8-2150278-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150278-5
SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2150278-6

5.

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

6

GREASE THREADS, GROOVE AND O-RING ON ITEMS 35 & 252.

7

MAGNET, ITEM 166 MUST BE ORIENTED CORRECTLY IN ORDER TO PROPERLY ACTUATE THE COUNTER.

8

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.

9

TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.

10

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

11

TO CHECK CRIMP HEIGHT. CRIMP SOLDER (Ø.19 IN [4.83mm] 60/40 SOLID CORE) AND MEASURE AT CENTER OF SLUG.

12

APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 62

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SET UP GAUGE 2119599-2

LOC A

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REVISONS

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DESCRIPTION

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DIMENSIONING AND TOLERANCING PER ASME Y14.5M-2003

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AMP 4805 REV 31MAR2000

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

FEED TYPE

PNEUMATIC

SERVO
LATCH PLATE

CAM POSITION

PACIFIC VERSION

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

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				CHK: T.ELBIN 12APRIL2012		NAME: Ocean End Feed Applicator	
				APVD: T.ELBIN 12APRIL2012		SIZE: A1	
				PRODUCT SPEC		CAGE CODE: 00779	
				APPLICATION SPEC		DRAWING NO: C-2150278	
				WEIGHT		SHEET 4 OF 4	
				Customer Accessible Production Drawing		REV A2	

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