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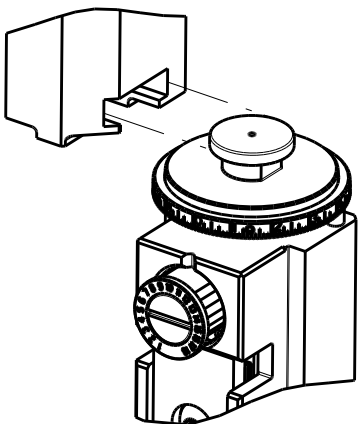
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ATLANTIC VERSION
TERMINATOR
INTERFACE ADAPTER

PART
NUMBER

REVISION

DESCRIPTION



2150398-2

A

FINE CRIMP HEIGHT ADJUST

2150398-5

A

FINE CRIMP HEIGHT ADJUST

2150398-6

A

NON-CRIMP HEIGHT ADJUST

2150398-7

A

FINE CRIMP HEIGHT ADJUST

7-2150398-7

A

CRIMP TOOLING KIT

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.54 mm [.100]	F
INSUL	4.57 mm [.180]	O
APPL INSTRUCTIONS 408-10390		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: RECEPTACLE, FASTON, FLAG, .250 SERIES			
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		REFERENCE 114-2079	
TERMINAL APPLICATION SPECIFICATION		TERMINAL APPLICATION SPECIFICATION	
TERMINALS APPLIED			
TE TERMINAL 1742999-1		TE TERMINAL 1742999-2	

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING 
14 AWG		1.78+/-0.05 [.070+/- .002]		6.1
16 AWG		1.55+/-0.05 [.061+/- .002]		8.5
18 AWG		1.40+/-0.05 [.055+/- .002]		10.5

-  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: 8-2150398-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150398-5
SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2150398-6
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 & 242. FOR -6 ONLY APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 37 & 242.
-  GREASE THREADS, GROOVE AND O-RING ON ITEMS 35 & 252.
-  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 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.
-  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
-  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.

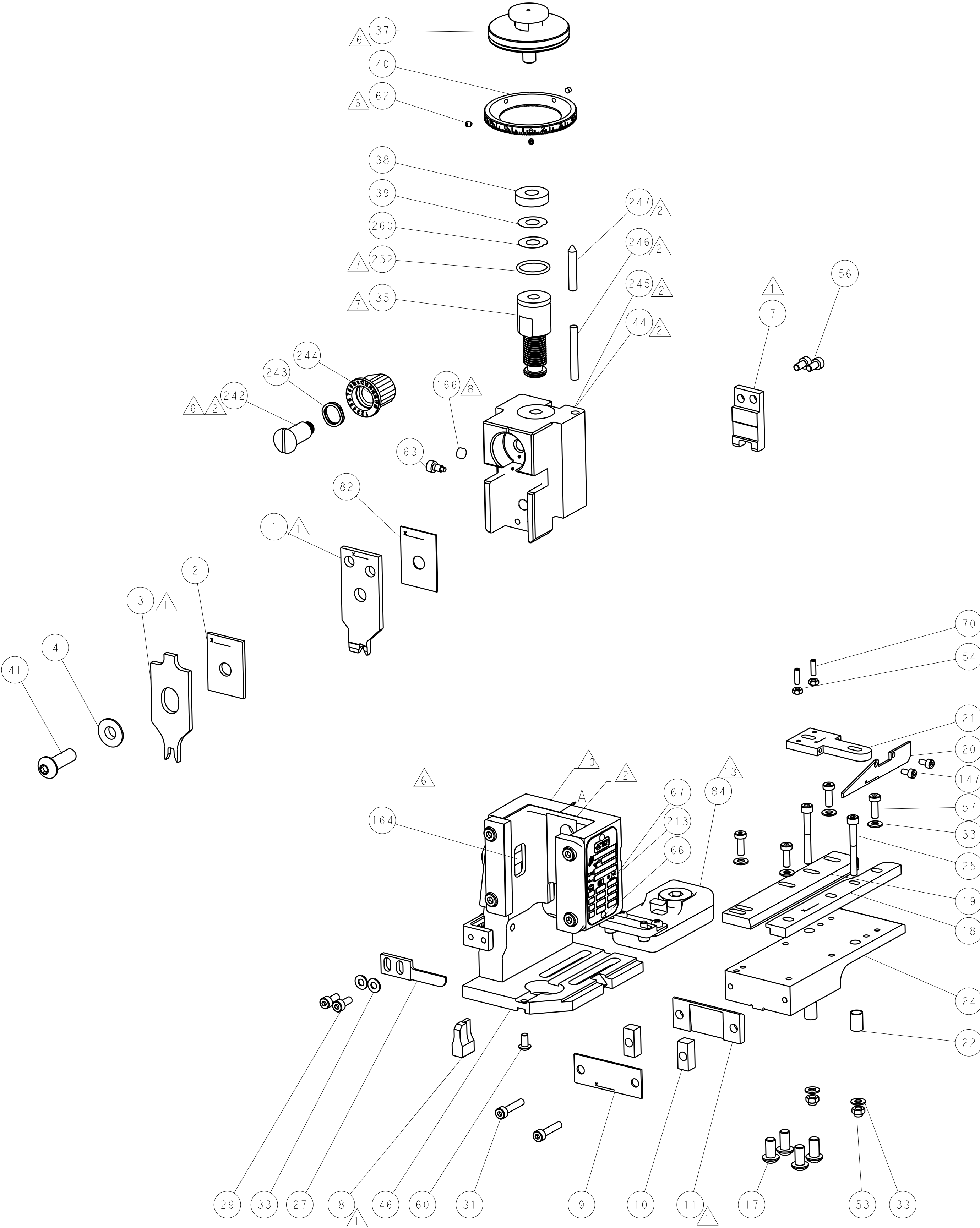
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

SET UP GAUGE 2119599-2	LOC A	DIST 66	REVISIONS			
			P	LTR	DESCRIPTION	DATE
				A	RELEASED	24FEB2014

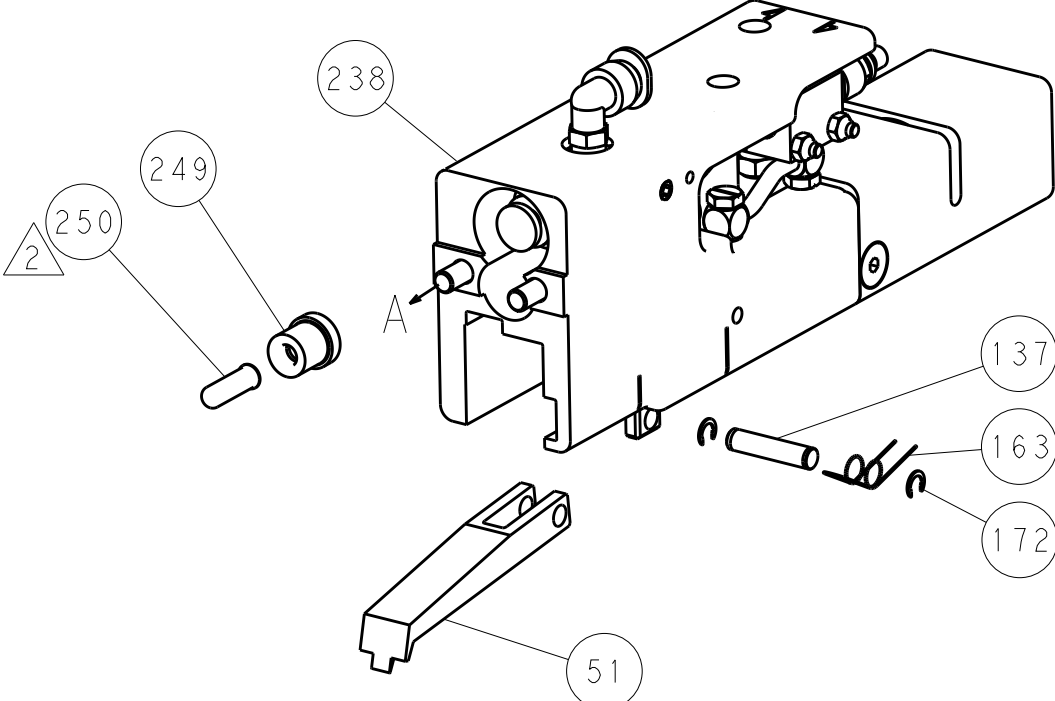
-	-	1	-	-	2119957-2	APPLICATOR SHIM PACK	260
-	-	1	-	1	8-21084-0	O-RING, .676 ID, .070 DIA. MAT.	252
-	-	-	-	1	2119640-1	PUSH ROD, AIR FEED	250
-	-	-	-	1	2079988-1	BUSHING, LCH5-12, MISUMI	249
-	-	-	-	1	2119641-1	FEED CAM, AIR FEED	248
-	1	-	1	1	2119798-1	DETENT PIN	247
-	1	-	1	1	1-22279-3	SPRING, COMPRESSION	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
-	-	-	-	1	2063440-1	AIR FEED MODULE	238
-	-	1	1	-	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	994969-1	MAGNET, RARE EARTH HIGH ENERGY	166
-	REFREFREFREF	-	-	-	994970-2	COUNTER, MAGNETIC	164
-	-	-	-	1	240638-1	SPRING, FEED FINGER	163
-	2	2	2	2	1-2168083-1	SCR, SKT HD CAP, RoHS, M3 X 6	147
-	-	-	-	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	2119955-2	ASSY, LUBRICATOR, END FEED	84
-	1	1	1	1	455888-6	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
-	1	-	-	1	2119740-1	TAG, IDENTIFICATION	67
-	2	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
-	1	1	1	1	2079383-4	SCR, BHSC, RoHS (M4 X 8)	60
-	4	4	4	4	2168400-1	SHCS, LOW HEAD, RoHS, M4 X 12	57
-	2	2	2	2	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	56
-	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	2161920-2	NARROW 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	240639-4	STRIPPER (MACHINING)	27
-	2	2	2	2	1-2168083-6	SCR, SKT HD CAP, RoHS, M4 X 35	25
-	1	1	1	1	2161922-1	PLATE, STRIP GUIDE	24
-	2	2	2	2	22281-6	SPRING, COMPRESSION	22
-	1	1	1	1	1633168-2	ARM, STOCK DRAG	21
-	1	1	1	1	464452-6	DRAG, STOCK	20
-	1	1	1	1	1803086-4	GUIDE, REAR STRIP	19
-	1	1	1	1	5-1901695-9	STRIP GUIDE, FRONT	18
-	4	4	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17
-	1	1	1	1	461160-3	PLATE, REAR SHEAR	11
-	2	2	2	2	8-240645-4	SPACER, SHEAR PLATE	10
-	1	1	1	1	455961-5	PLATE, FRONT SHEAR	9
-	1	1	1	1	1803074-6	ANVIL, COMBINATION, END FEED	8
-	1	1	1	1	1803109-3	BLADE, SLUG	7
-	-	-	-	-	-	-	6
-	-	-	-	-	-	-	5
-	1	1	1	1	238009-1	BLOCK, FL CRIMPER SPACER	4
-	1	1	1	1	1-1633989-3	CRIMPER, INSULATION, SPECIAL	3
-	1	1	1	1	2-455888-0	SPACER, CRIMPER	2
-	1	1	1	1	1803015-6	CRIMPER, WIRE	1

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DIMENSIONS: mm	TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.5 1 PLC ±0.13 3 PLC ±0.013 4 PLC ±0.0001 ANGLES ±.1	PRODUCT SPEC	NAME	Ocean End Feed Applicator	
MATERIAL	FINISH	APPLICATION SPEC	SIZE	CAGE CODE	DRAWING NO
-	-	-	A1	00779	©=2150398
Customer Accessible Production Drawing		SCALE	1:1	SHEET	1 OF 4
		REV	A		

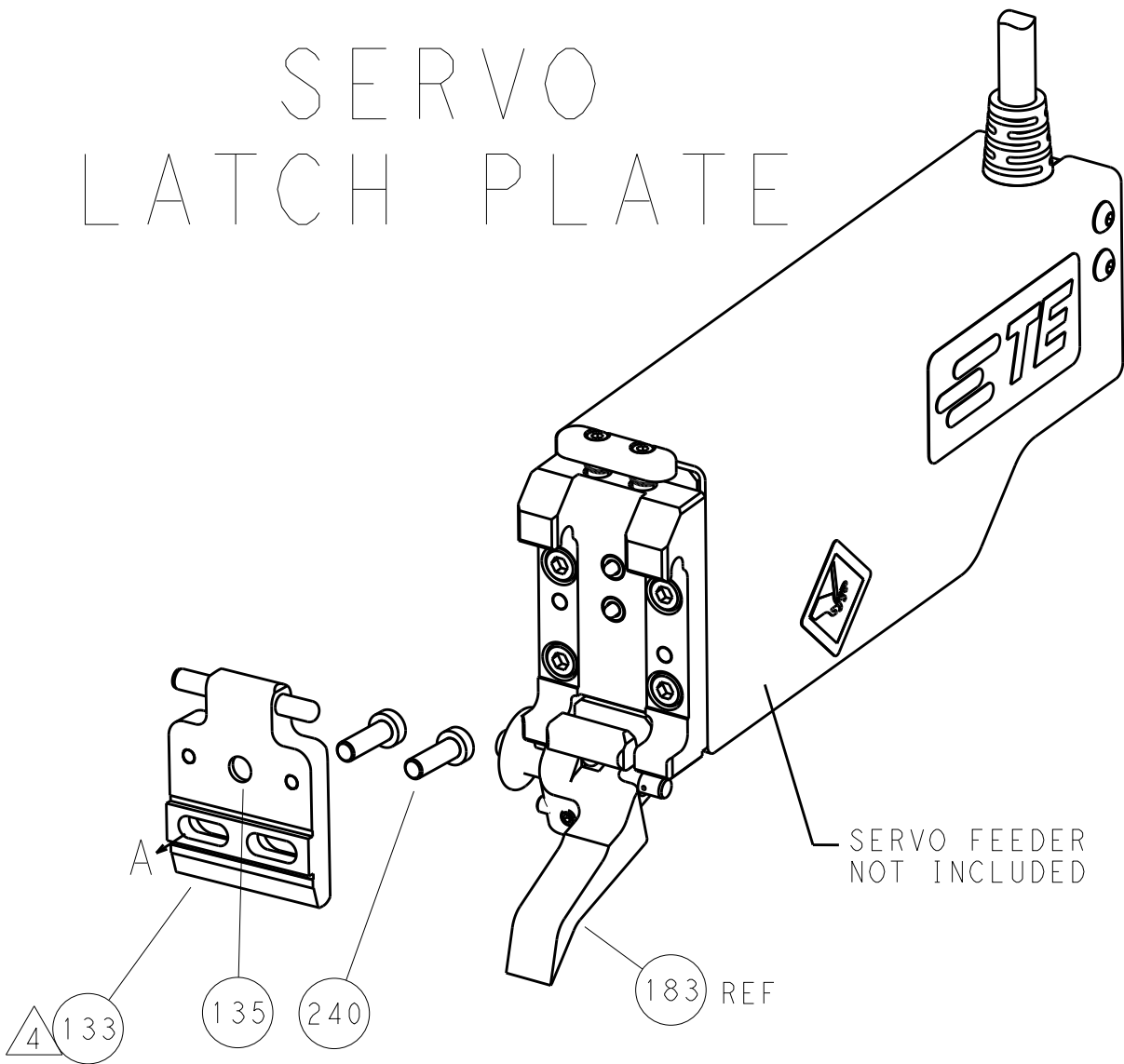
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		P	LTR	DESCRIPTION	DATE	DWN	APVD
A	66	-	-	SEE SHEET 1	-	-	-



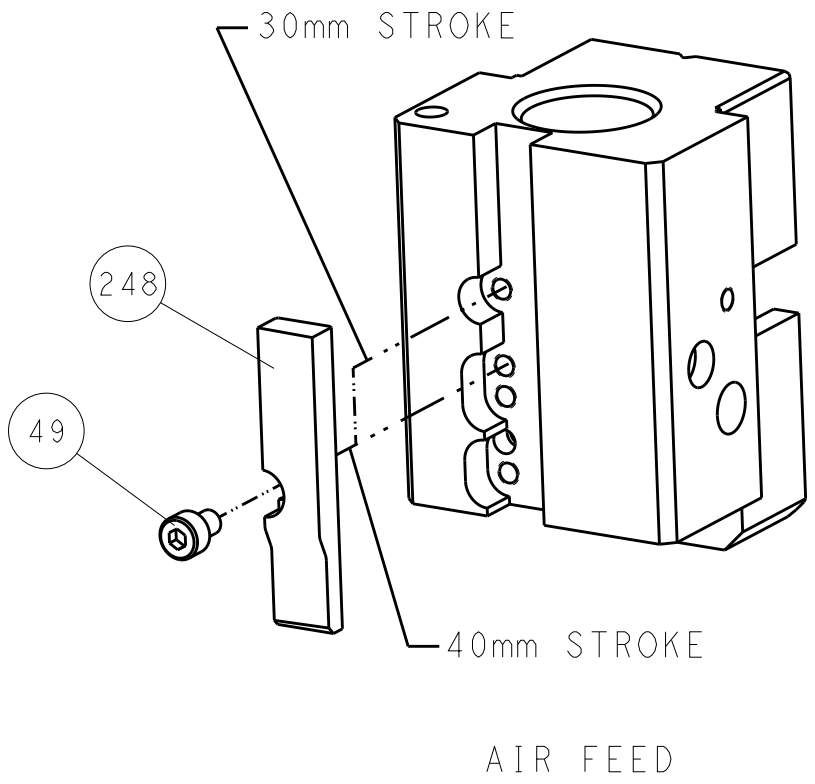
FEED TYPE
PNEUMATIC



SERVO
LATCH PLATE



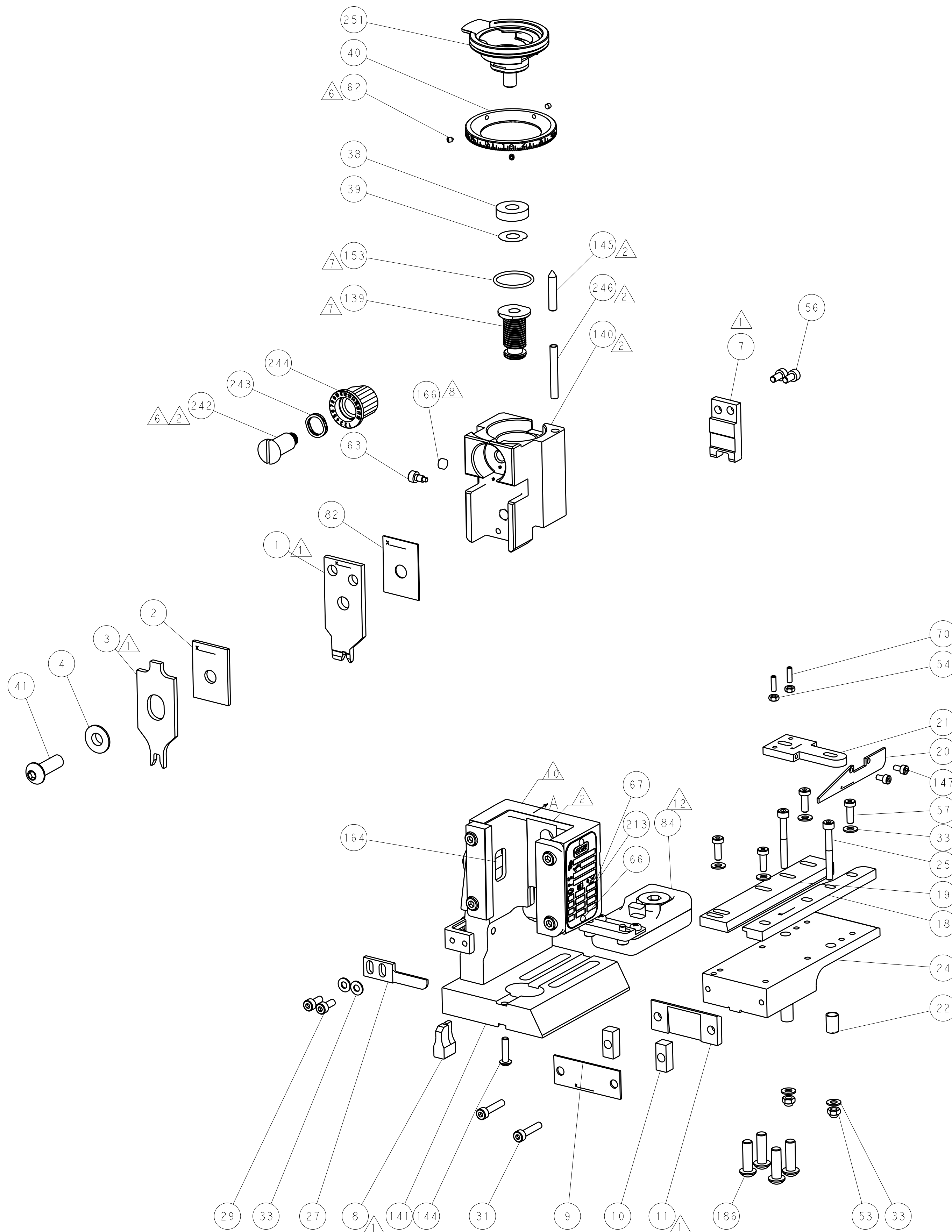
CAM POSITIONS



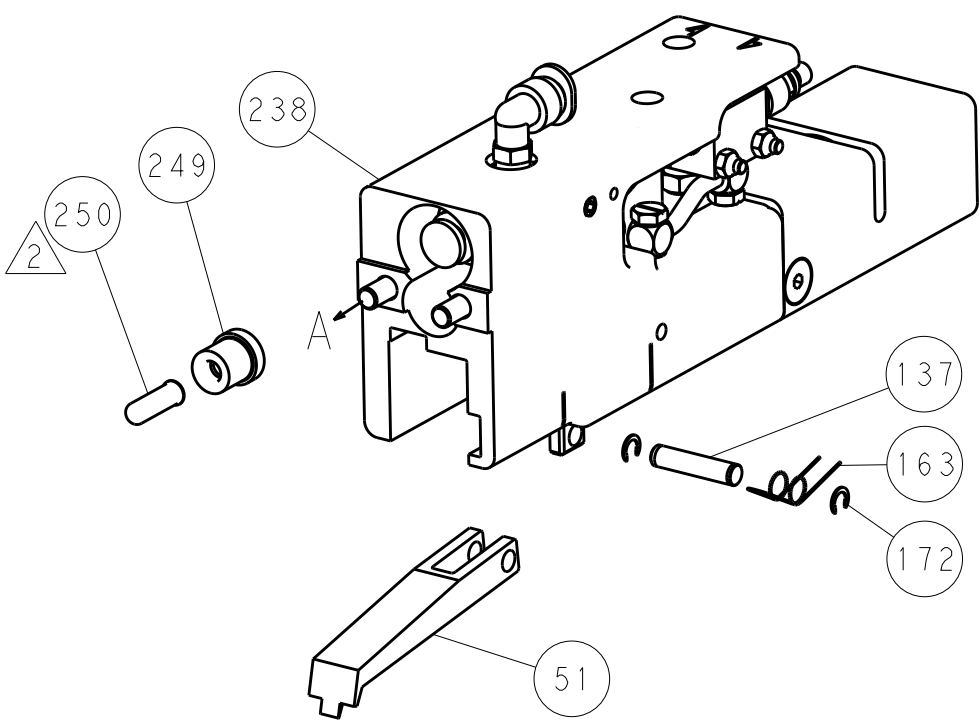
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DIMENSIONS: mm		CHK G. BAILEY 09-Jan-14	NAME Ocean End Feed Applicator	
TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.5 1 PLC ±0.5 2 PLC ±0.13 3 PLC ±0.013 4 PLC ±0.0001 ANGLES ±.1		APVD M. CLIFFORD 09-Jan-14	SIZE CAGE CODE DRAWING NO 00779 C=2150398	
MATERIAL -		PRODUCT SPEC -	RESTRICTED TO -	
FINISH -		APPLICATION SPEC -	SCALE 1:1	
Customer Accessible Production Drawing		WEIGHT -	SHEET 2 OF 4	
		REV A		

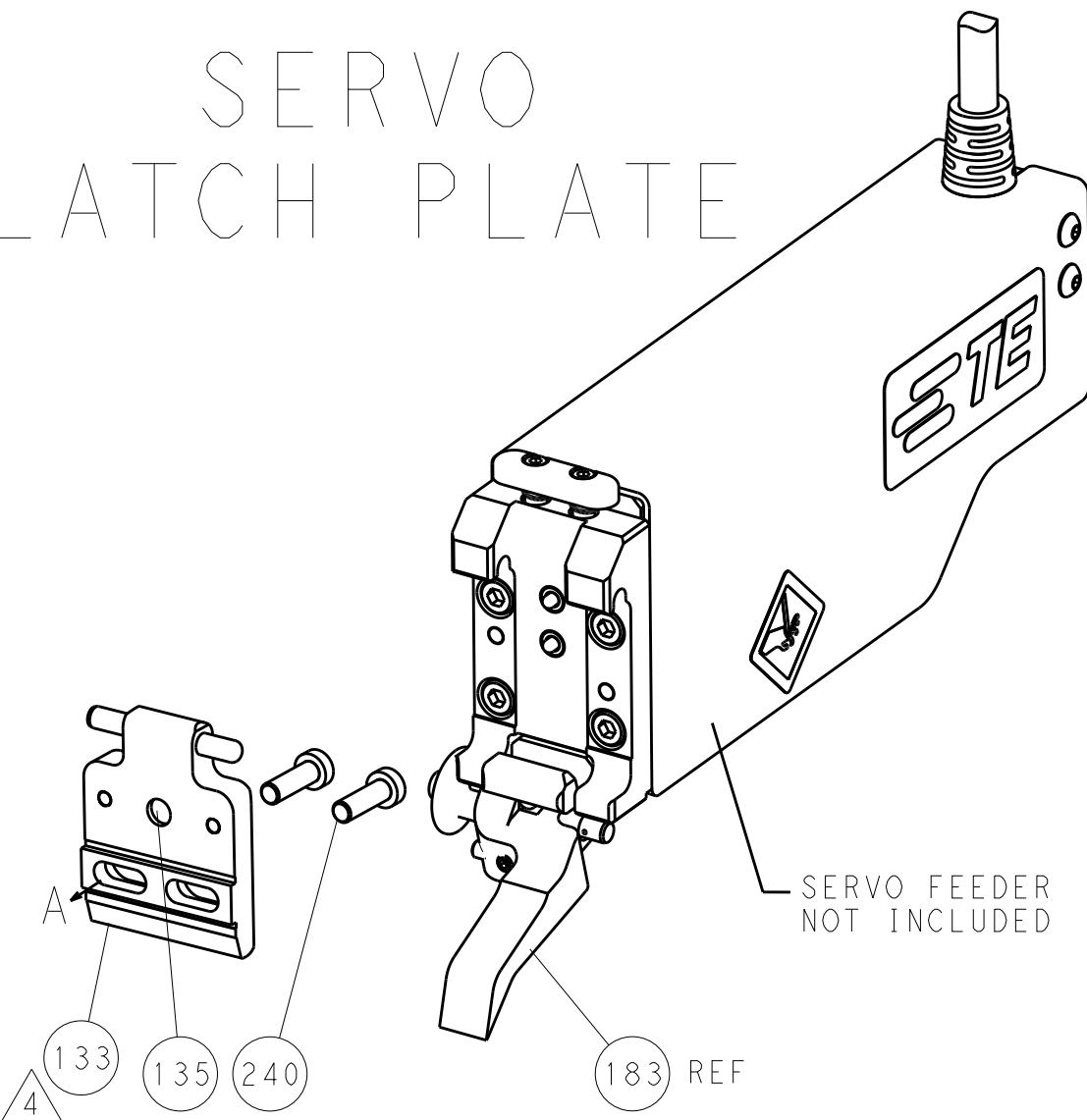
LOC	DIST	REVISIONS					
		P	LTR	DESCRIPTION	DATE	DWN	APVD
A	66	-	-	SEE SHEET 1	-	-	-



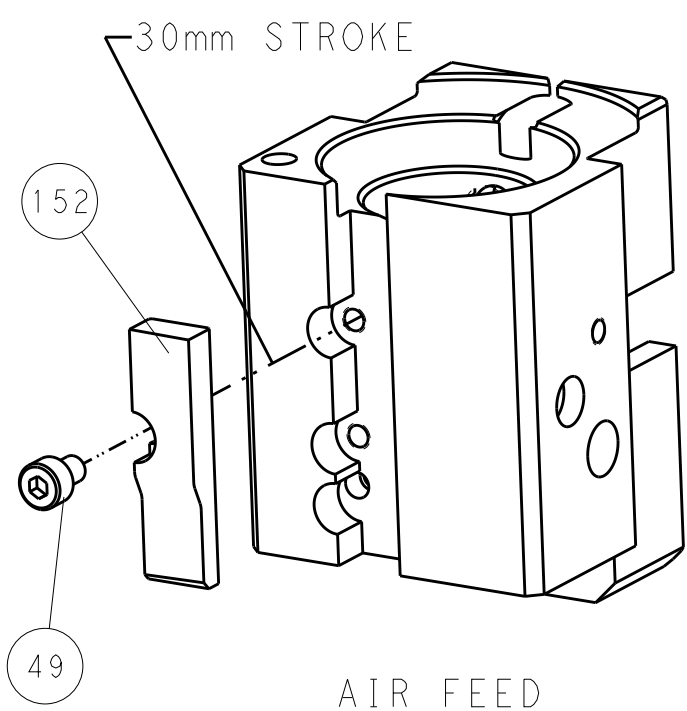
FEED TYPE
PNEUMATIC



SERVO
LATCH PLATE



CAM POSITIONS



AIR FEED

PACIFIC VERSION
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DIMENSIONS: mm		CHK G. BAILEY 09-Jan-14	NAME Ocean End Feed Applicator	
TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.5 1 PLC ±.5 2 PLC ±.13 3 PLC ±.13 4 PLC ±.0001 ANGLES ±.1		APVD M. CLIFFORD 09-Jan-14	SIZE A1	
MATERIAL -		PRODUCT SPEC -	CAGE CODE 00779	
		APPLICATION SPEC -	DRAWING NO C=2150398	
		WEIGHT -	RESTRICTED TO -	
		Customer Accessible Production Drawing	SCALE 1:1	
			SHEET 4	
			OF 4	
			REV A	