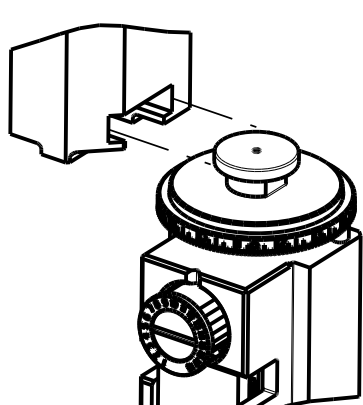


8		7		6		5		4		3	
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ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART						
					CONVERT TO	PART NUMBERS REQUIRED					
	2150404-2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	-	-	-	-	-	-	-
					SERVO LATCH PLATE	2119951-1	1901697-1	8-2150404-5	-	-	2168400-7 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2150404-4	-	-	-
	2150404-5	A	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE 4	-	-	-	-	-	-	-
					PNEUMATIC FEED	2119950-1	2119792-2	-	2119641-1	-	2063440-1
					-	-	-	-	-	-	-
2150404-6	A	NON-CRIMP HEIGHT ADJUST	4 SERVO LATCH PLATE 11	-	-	-	-	-	-	-	-
2150404-7	A	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	-	-
7-2150404-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-	-

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.79 mm [.110]	F
INSUL	3.94 mm [.155]	F
APPL INSTRUCTIONS 408-10390		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: RING, AMPLIVAR			
WIRE STRIP LENGTH 5.46-5.84mm [.215-.230 IN]		INSULATION DIAMETER RANGE Ø 2.54-3.56mm [.100-.140 IN]	
TERMINAL APPLICATION 		-	
SPECIFICATION		-	
TERMINALS APPLIED 			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
60320-1	60320-2	60318-1	1217730-1

WIRE SIZE			CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING
14 OR 14.5 MAG			1.93+/-0.05 [0.076+/- .002]		7.6
15 MAG			1.85+/-0.05 [0.073+/- .002]		8.4
16 MAG			1.75+/-0.05 [0.069+/- .002]		9.4
17 OR 18 MAG			1.65+/-0.05 [0.065+/- .002]		10.5



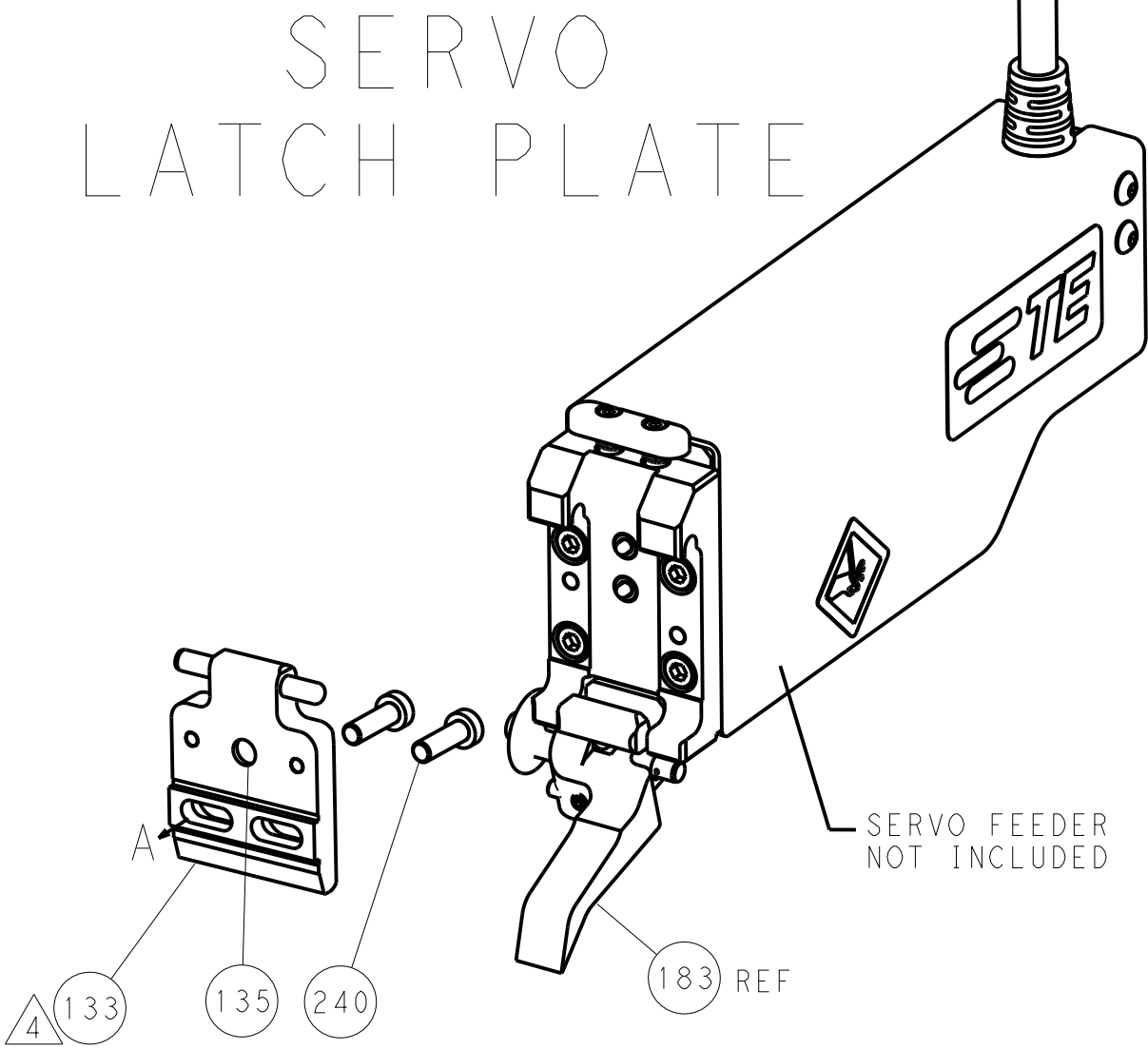
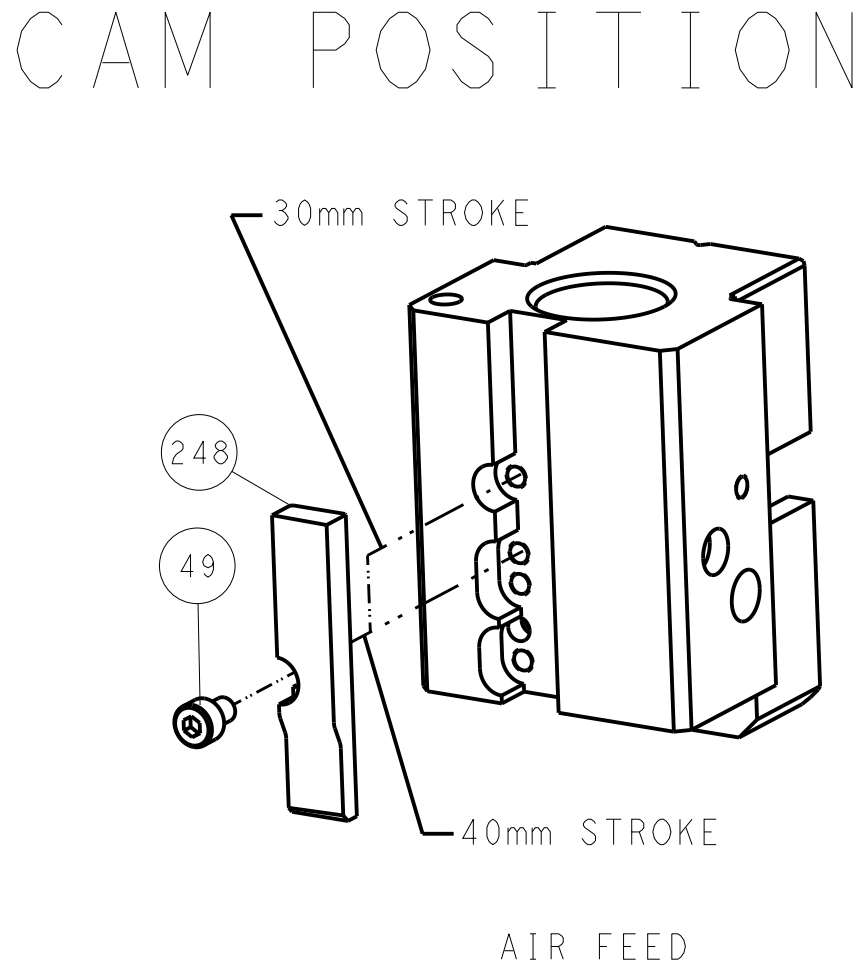
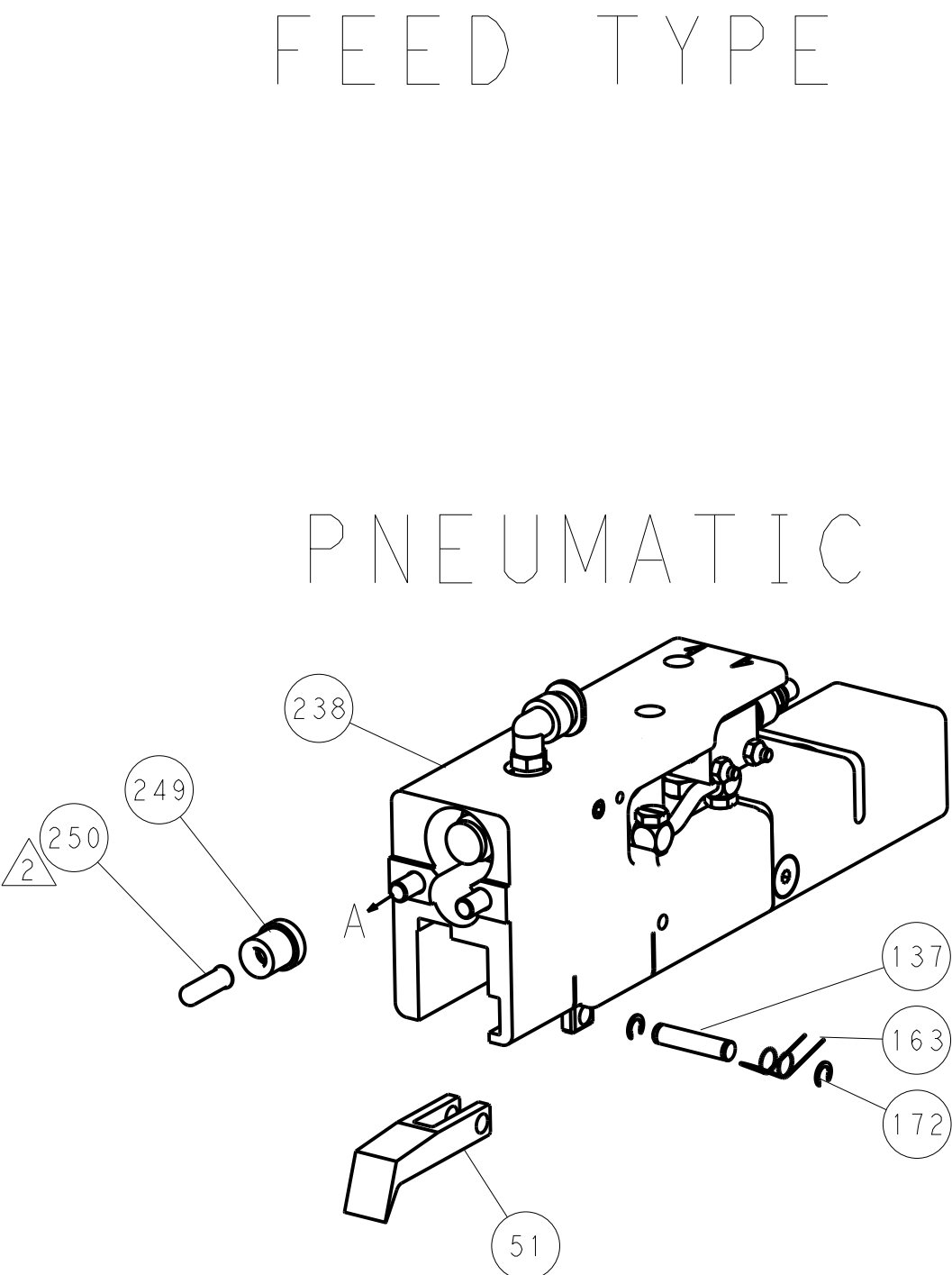
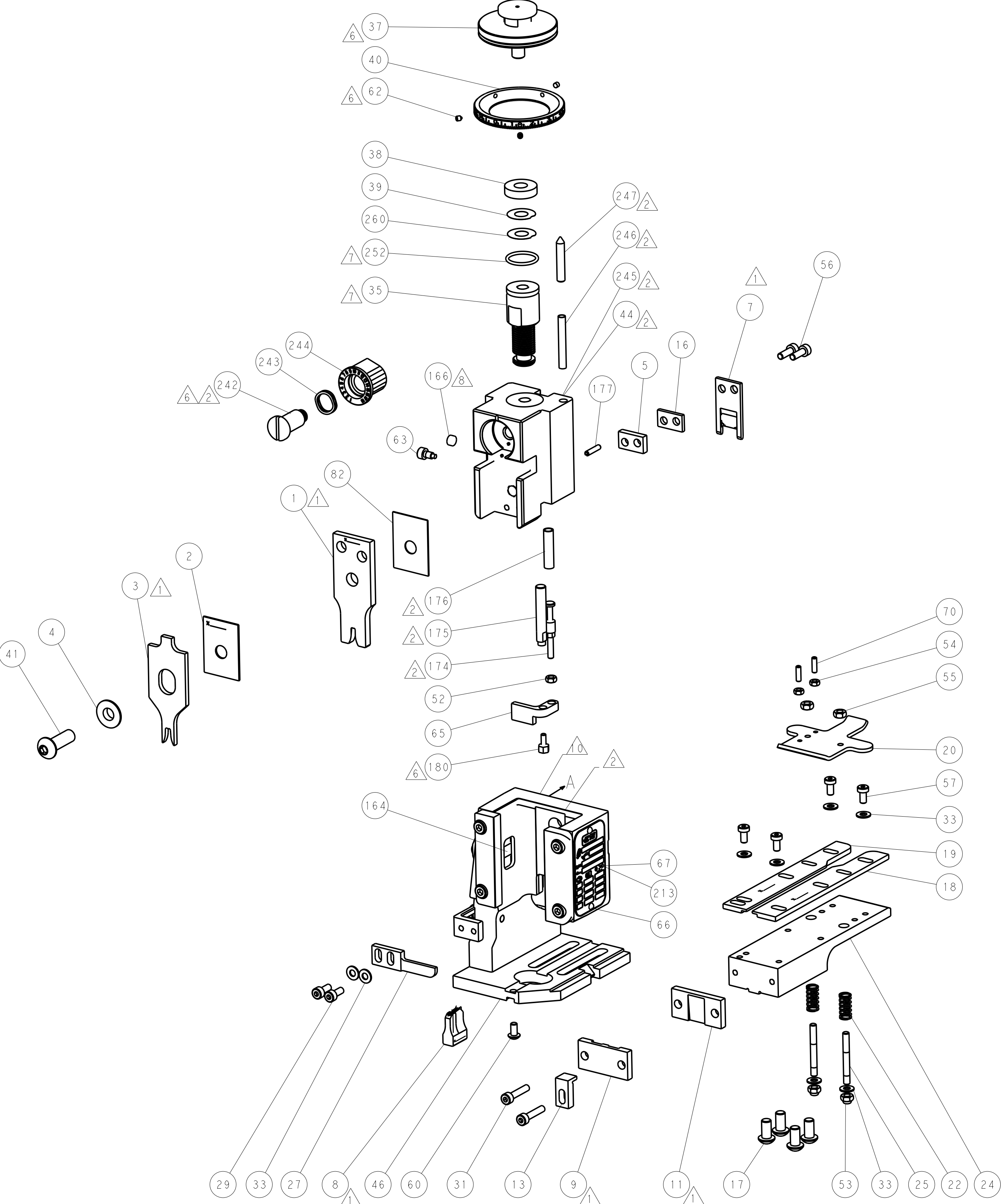
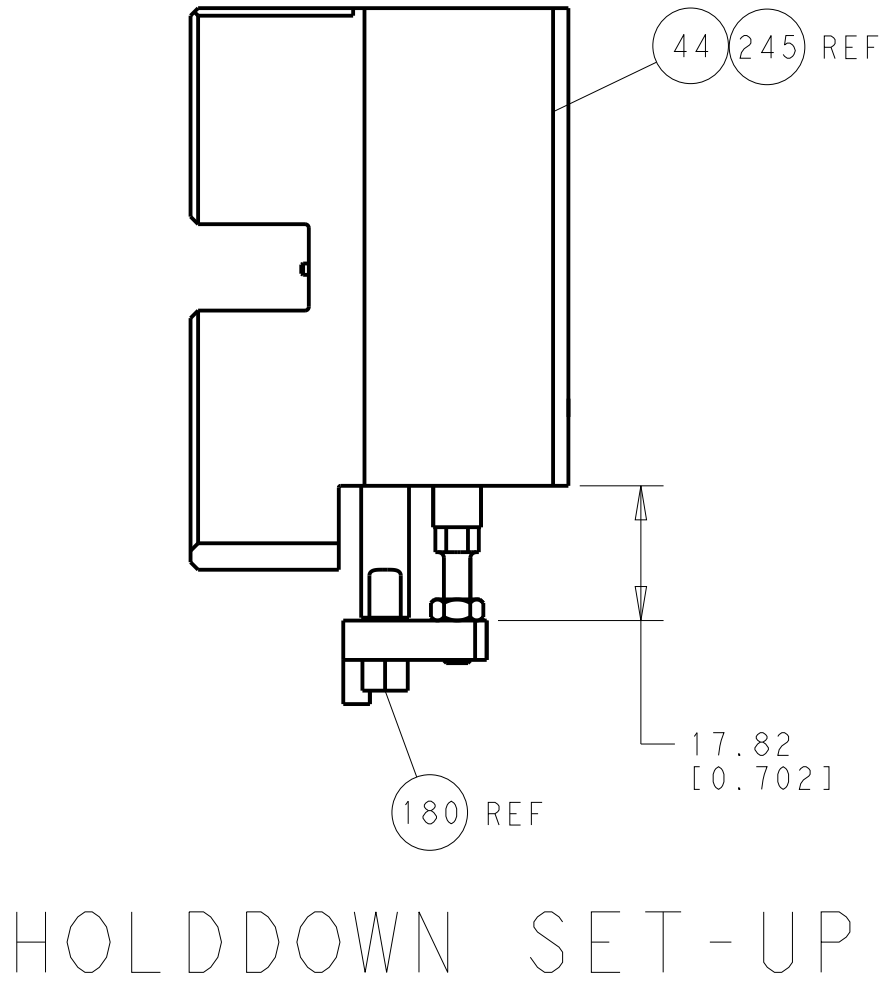
- 1 RECOMMENDED SPARE PARTS
- 2 GREASE BEARING SURFACES LIGHTLY
3. LUBRICATE DAILY PER THE APPLICATOR INSTRUCTION SHEET SUPPLIED WITH THE APPLICATOR.
- 4 APPLICATOR SPECIFIC DATA TO BE ENTERED INTO BLANK MEMORY CHIP AT ASSEMBLY. SEE BELOW FOR PART NUMBER:
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150404-4
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150404-5
 SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2150404-6
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
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

				2				1	
SET UP GAUGE 2119599-2				LOC A	DIST 66	REVISIONS			
		P	LTR	DESCRIPTION			DATE	DWN	APVD
			A	RELEASED			19MAR2014	LG	TE

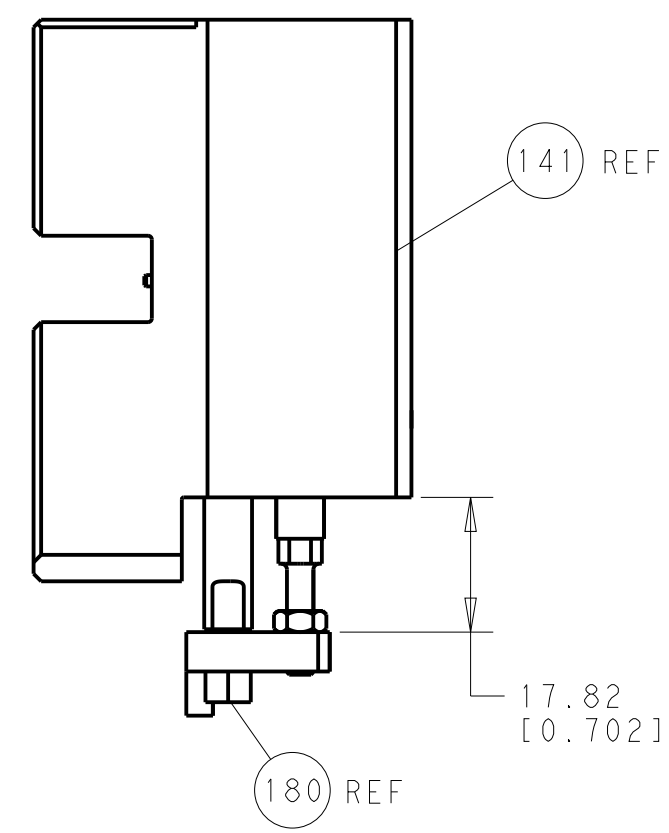
LOC		DIST		REVISIONS			
A	66	P	LTR	DESCRIPTION	DATE	DWN	APVD
		-		SEE SHEET 1	-	-	-



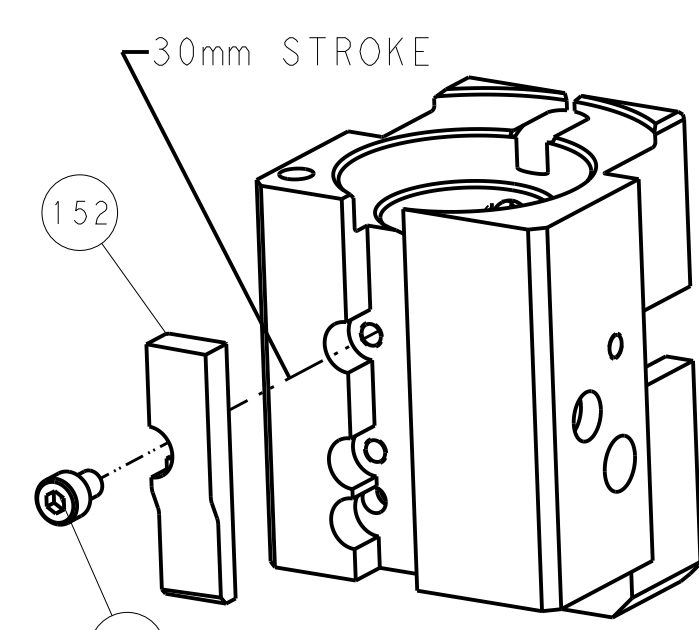
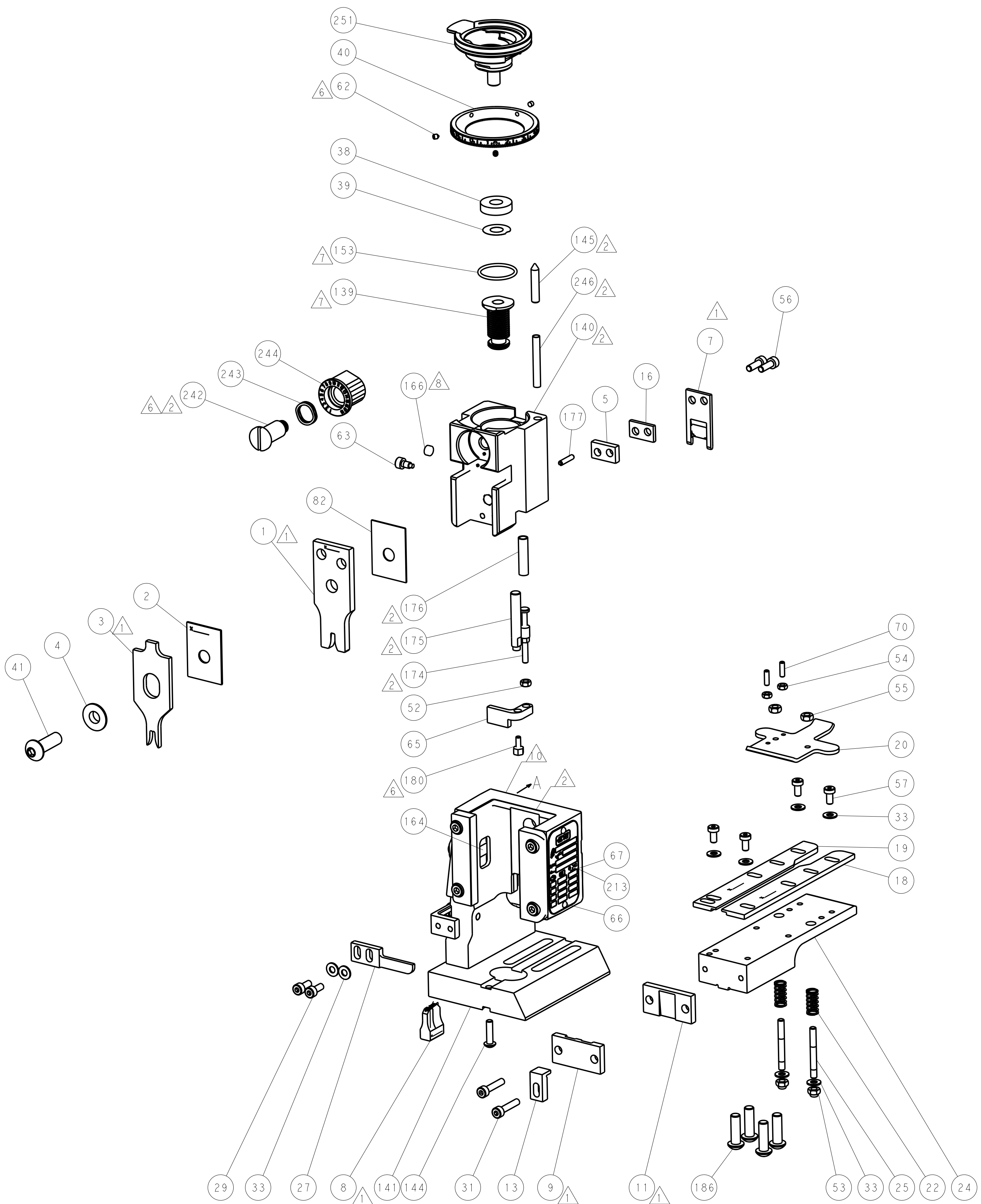
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

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DIMENSIONS: mm				TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.5 1 PLC ±0.13 2 PLC ±0.13 3 PLC ±0.13 4 PLC ±0.0001 ANGLES ±.1				NAME: Ocean End Feed Applicator			
MATERIAL: -				FINISH: -				SIZE: CAGE CODE: DRAWING NO: 00779 ©=2150404			
Customer Accessible Production Drawing				SCALE: 1:1				SHEET 2 OF 4 REV A			

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



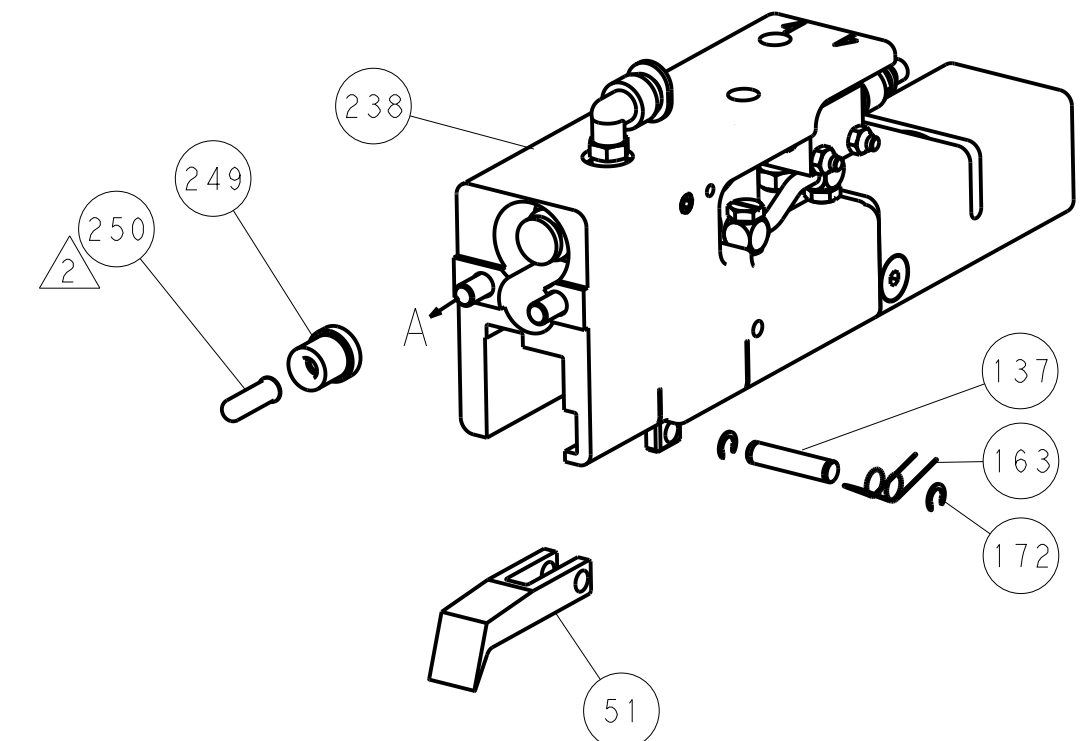
HOLDDOWN SET-UP



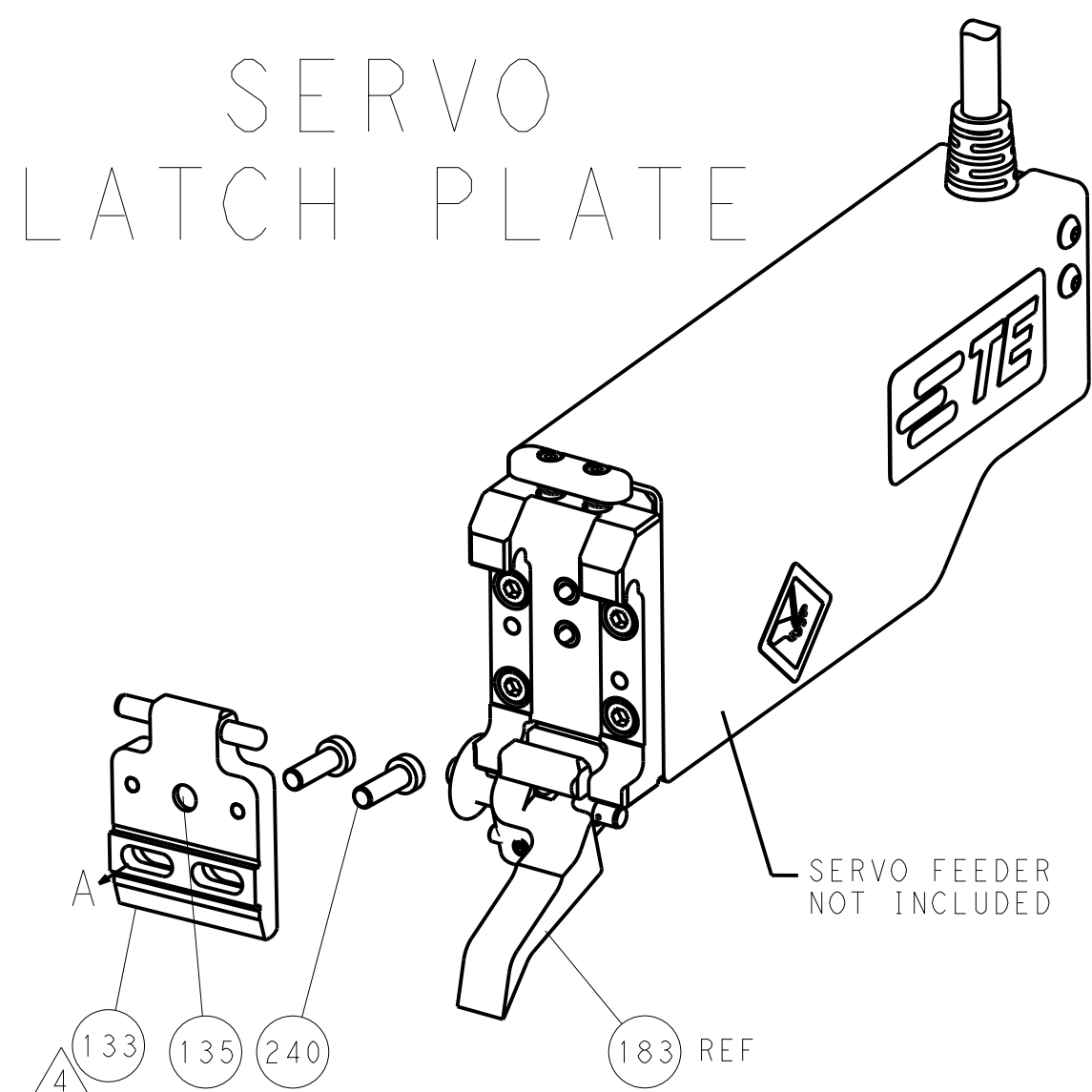
AIR FEED

FEED TYPE

PNEUMATIC



SERVO LATCH PLATE



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 - 01 JUN 2011			
		APVD - 01 JUN 2011			
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		NAME	
		0 PLC ±.5		PRODUCT SPEC	
		1 PLC ±0.5		APPLICATION SPEC	
		2 PLC ±0.13			
		3 PLC ±0.013			
		4 PLC ±0.0001			
ANGLES ±.1		SIZE CAGE CODE DRAWING NO		RESTRICTED TO	
MATERIAL	FINISH	WEIGHT	A1 00779 C=2150404		-
Customer Accessible Production Drawing			SCALE 1:1	SHEET 4 OF 4	REV A

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