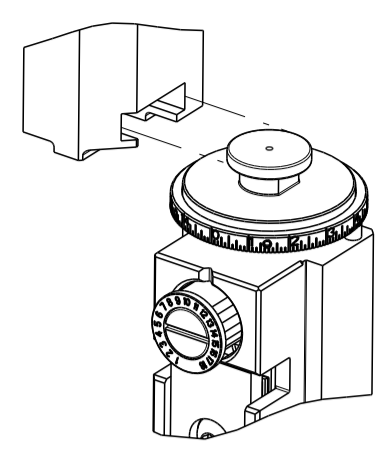


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150543-2	E	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150543-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR
 INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.79 mm [.110]	F
INSUL	3.94 mm [.155]	F
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: RECEPTACLE, CLUSTER PIN, AMPLIVAR			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
7.75-7.78 mm [.305-.306 IN]		Ø1.91-3.18 mm [.075-.125 IN]	
TERMINAL APPLICATION SPECIFICATION	114-2019		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
63454-1	1217174-1	1217174-3	

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
3500-4200 CMA	1.80 +/- 0.05 [.071 +/- .002]	7.5
1500-2300 CMA	1.55 +/- 0.05 [.061 +/- .002]	9.7

- RECOMMENDED SPARE PARTS
- REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242.
- 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 PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- 6. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- MINIMUM AND MAXIMUM CRIMP HEIGHTS ARE LISTED ON DRAWING. FOR SPECIFIC WIRE SIZES REFER TO SPECIFICATION 108-2008.
- TERMINAL LUBRICANT IS RECOMMENDED.

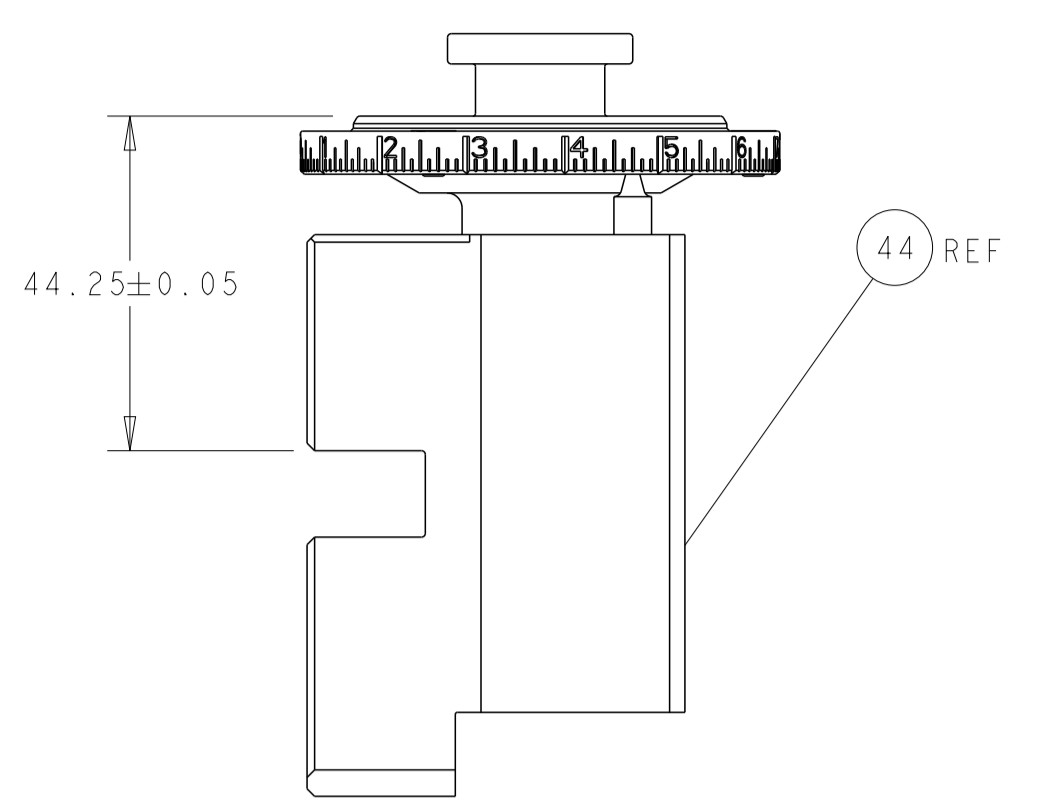
***WARNING**
 ON INSTALLATION, SET WIRE DISC TO CRIMP HEIGHT REFERENCE SETTING FOR LARGEST WIRE SIZE. CRIMP HEIGHT REFERENCE SETTINGS GREATER THAN THE VALUE SHOWN MAY CAUSE DAMAGE TO THE CRIMP TOOLING. REFER TO THE INSTRUCTION SHEET FOR PROPER SETUP AND ADJUSTMENTS.

LOC	DIST	REVISIONS					
A	66	P	LTN	DESCRIPTION	DATE	DWN	APVD
		B		ECR-18-017013	27OCT2018	TB	TE
		C		ECR-18-019470	27DEC2018	FZ	KZ
		D		ECR-19-009578	18JUN2019	LG	TE
		E		ECR-24-217576	13AUG2024	ROY	GEB

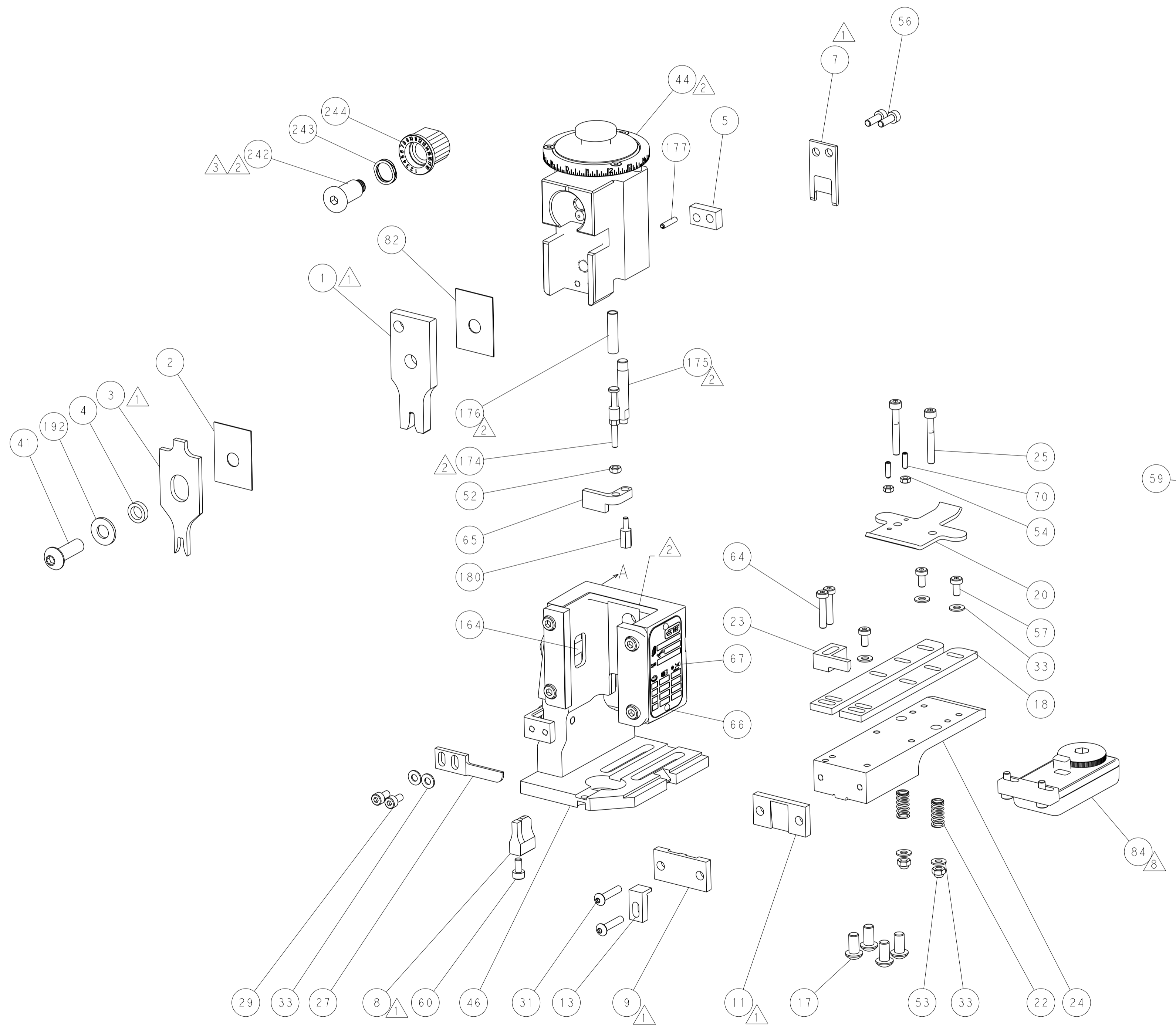
-	1	2119641-1	FEED CAM, AIR FEED	248	
-	1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244	
-	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243	
-	1	2119083-1	RETAINER, INSULATION DIAL	242	
-	1	2844940-4	AIR FEED MODULE	238	
-	1	1-18028-0	WASHER, FLAT, REG M8	192	
-	1	2-1752354-7	STANDOFF, HOLD-DOWN	180	
-	1	6-993111-6	PIN, SLOTTED SPRING 3.0 X 14.0	177	
-	1	8-22280-7	SPRING, COMPRESSION	176	
-	1	1752353-2	GUIDE PIN, HOLDDOWN	175	
-	1	1901680-2	GUIDE PIN, HOLDDOWN	174	
-	REF	994970-2	COUNTER, MAGNETIC	164	
-	1	2119955-2	ASSY, LUBRICATOR, END FEED	84	
-	1	455888-5	SPACER, CRIMPER -	82	
-	1	1803607-4	DOCUMENTATION PACKAGE	71	
-	2	2-18032-2	SCR, SET, FLT PNT, M3 X 10.0	70	
-	1	2119740-1	TAG, IDENTIFICATION	67	
-	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66	
-	1	1901681-1	HOLDDOWN, TERMINAL	65	
-	2	2168400-5	SHCS, LOW HEAD, RoHS, M4 X 20	64	
-	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	60	
-	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59	
-	3	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57	
-	2	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	56	
-	2	5018030-1	NUT, HEX, REG, RoHS, M3	54	
-	2	986965-8	NUT, LOCK, HEX, TORQUE (M4)	53	
-	1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52	
-	1	2063961-9	FEED FINGER	51	
-	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49	
-	1	2119655-5	APPLICATOR BASIC ASSEMBLY, EF	46	
-	1	1803517-1	RAM ASSEMBLY, EF ATLANTIC	44	
-	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41	
-	7	1-18028-2	WASHER, FLAT, REG M4	33	
-	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	31	
-	2	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	29	
-	1	240639-3	STRIPPER (MACHINING)	27	
-	2	1-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 30	25	
-	1	1752371-5	PLATE, STRIP GUIDE	24	
-	1	240825-1	PLATE, STRIP HOLD DOWN	23	
-	2	2-22281-3	SPRING, COMPRESSION	22	
-	1	1803292-4	DRAG	20	
-	2	1901259-7	GUIDE, LOWER STRIP	18	
-	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17	
-	1	1752360-1	SPACER, HOLD-DOWN	13	
-	1	240644-1	PLATE, REAR SHEAR	11	
-	-	-	-	10	
-	1	690482-5	PLATE, FRONT SHEAR	9	
-	1	819517-4	ANVIL, COMBINATION	8	
-	1	5-690474-8	BLADE, SLUG	7	
-	1	8-240641-8	SPACER	5	
-	1	238011-2	BLOCK, CRIMPER SPACER	4	
-	1	3-2119582-6	CRIMPER, INSULATION F PREMIUM	3	
-	1	455888-5	SPACER, CRIMPER -	2	
-	1	819516-2	CRIMPER, WIRE	1	
-	77	2	PART NO	DESCRIPTION	ITEM NO

DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH		DWN: A. STAKEM CHK: G. BAILEY APVD: T. ELBIN		DATE: 04APRIL2015 DATE: 04APRIL2015 DATE: 04APRIL2015		NAME: Ocean End Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2150543 RESTRICTED TO:	
MATERIAL: -		FINISH: -		WEIGHT: -		SCALE: 1:1		SHEET 1 OF 4	

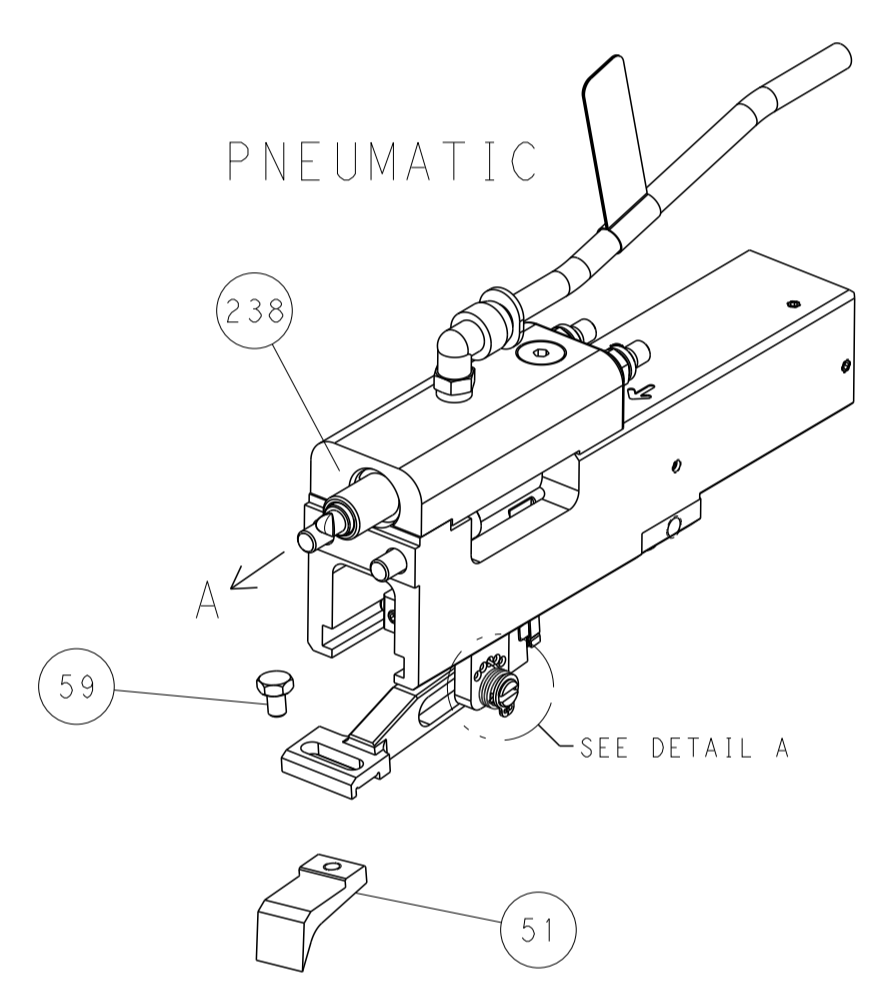
LOC		DIST		REVISIONS			
A	66	P	LTH	DESCRIPTION	DATE	OWN	APVD
		-		SEE SHEET 1			



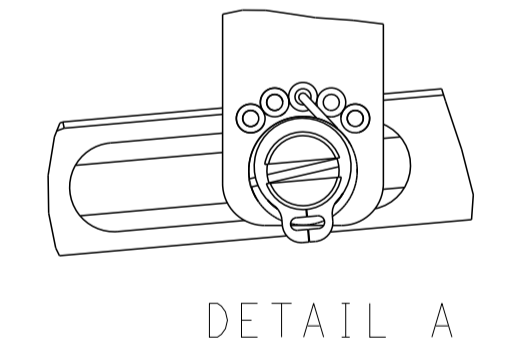
RAM SET-UP



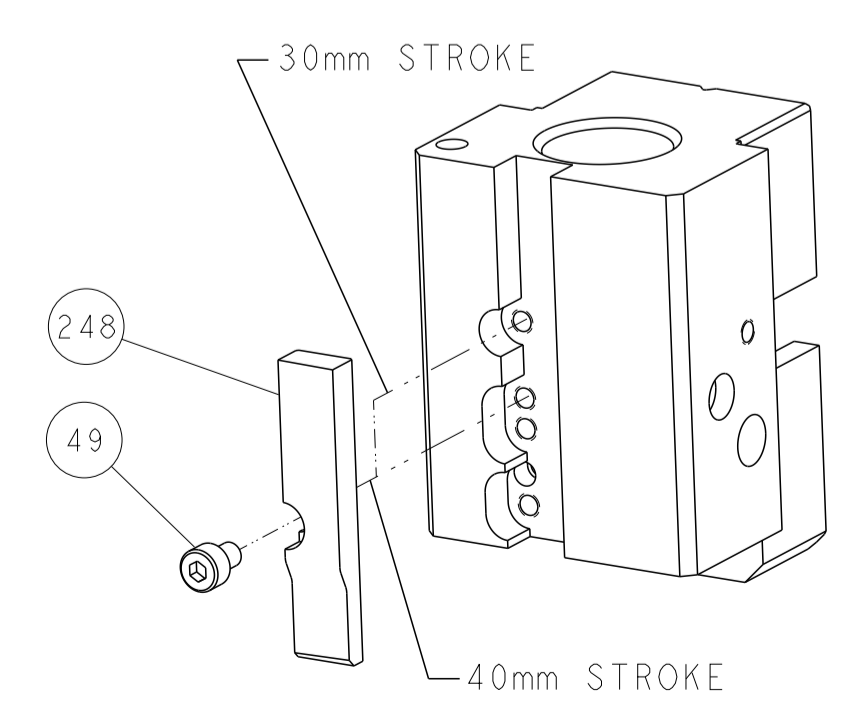
FEED TYPE



FEED SPRING SETTING POSITION



CAM POSITION



AIR FEED

DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH		DWN: K. STAKEM 10APRIL2015 CHK: G. BAILEY 10APRIL2015 APVD: T. ELBIN 10APRIL2015 PRODUCT SPEC: APPLICATION SPEC: WEIGHT:		NAME: Ocean End Feed Applier SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2150543 SCALE: 1:1 SHEET: 2 of 4 REV: E	
MATERIAL:				RESTRICTED TO:			