

Table with columns: ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER, PART NUMBER, REVISION, DESCRIPTION, FEED TYPE, CONVERT TO, PART NUMBERS REQUIRED.

APPLICATOR DATA table with columns: CRIMP SIZE, WIRE, INSUL, TYPE.

TERMINAL DATA: TAKBRO TERMINAL TE CRIMP SPECIFICATION table including terminal name, wire strip length, insulation diameter range, and terminals applied.

WIRE SIZE table with columns: WIRE SIZE, CRIMP HEIGHT mm [INCH], CRIMP HEIGHT REFERENCE SETTING.

- List of recommendations and warnings: 1. RECOMMENDED SPARE PARTS, 2. GREASE BEARING SURFACES LIGHTLY, 3. LUBRICATE DAILY PER THE APPLICATOR INSTRUCTION SHEET SUPPLIED WITH THE APPLICATOR, etc.

*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.

Table with columns: PART NO, DESCRIPTION, ITEM NO. listing various components and their quantities.

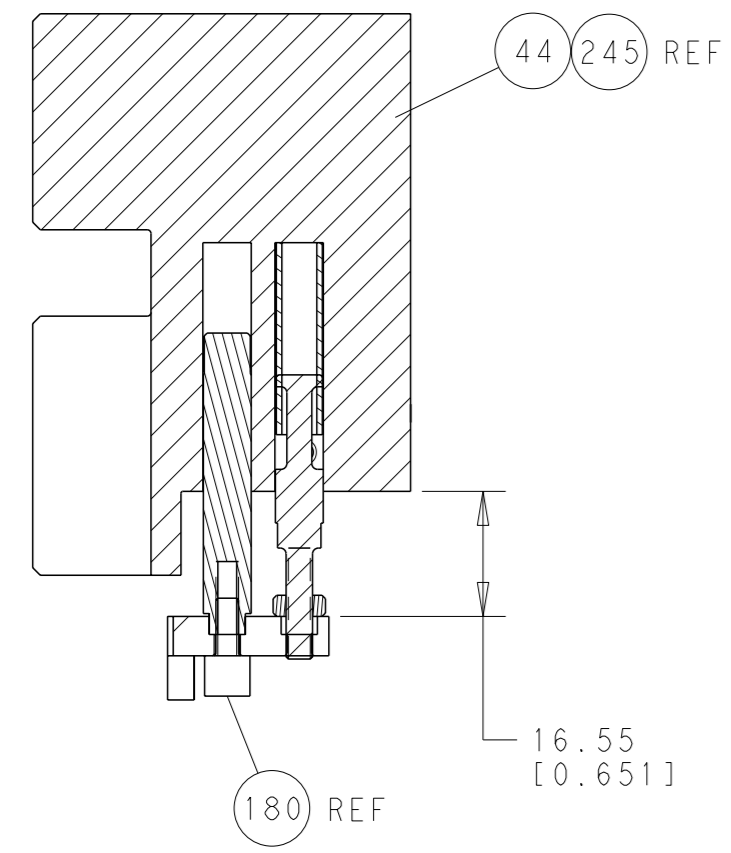
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

SET UP GAUGE 2119599-2 table with columns: F, L, H, DESCRIPTION, DATE, QTY, APPV.

Main assembly table with columns: QTY, PART NO, DESCRIPTION, ITEM NO. listing various parts like CAM, SNAIL, INSULATION ADJUSTMENT, WASHER, WAVE SPRING, etc.

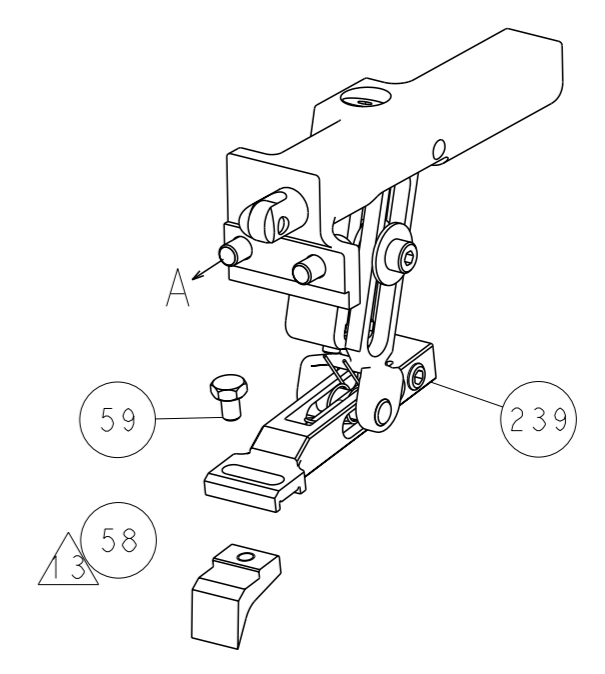
Technical drawing footer including dimensions, tolerances, material, and drawing information.

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

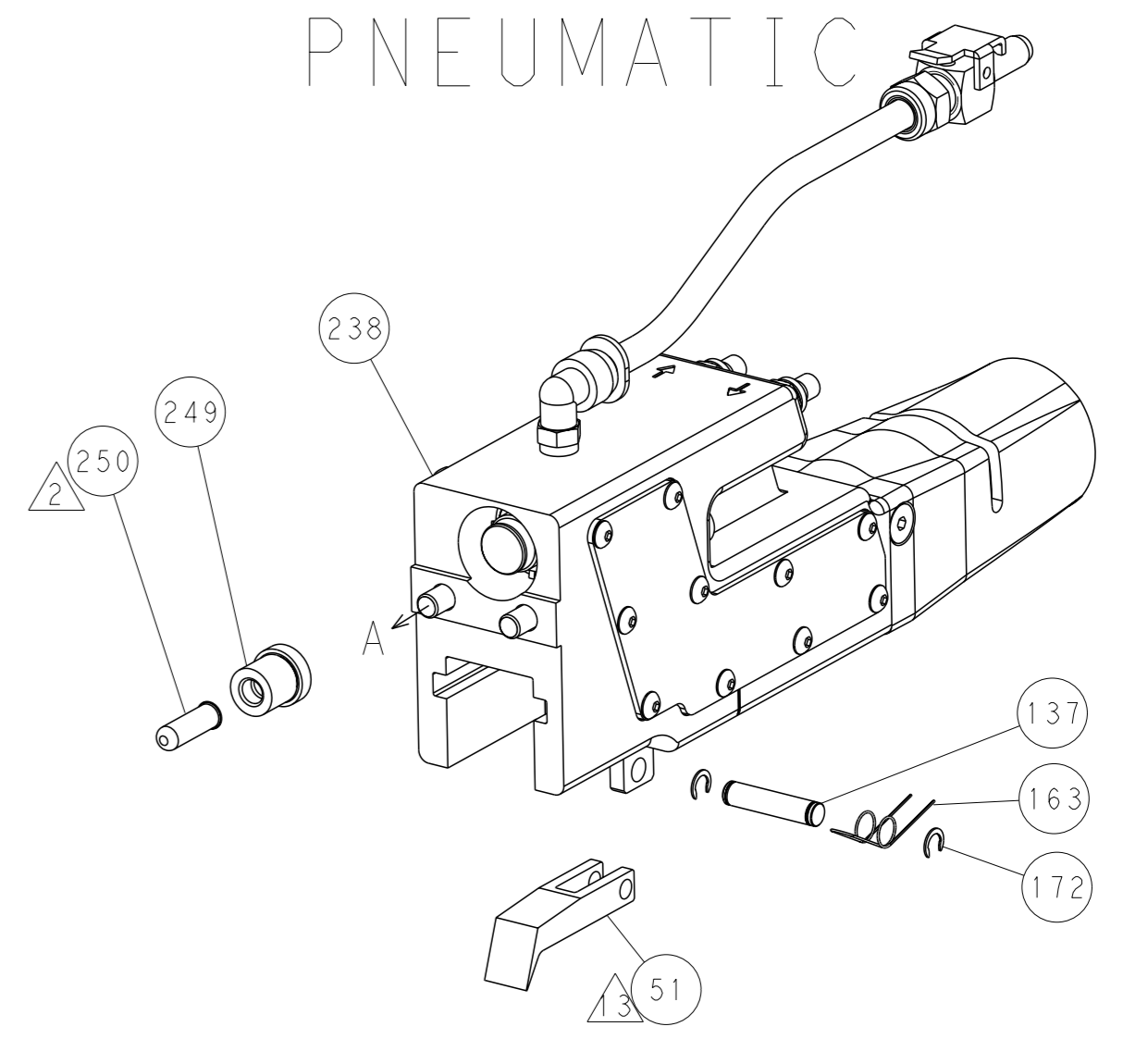


HOLDDOWN SET-UP

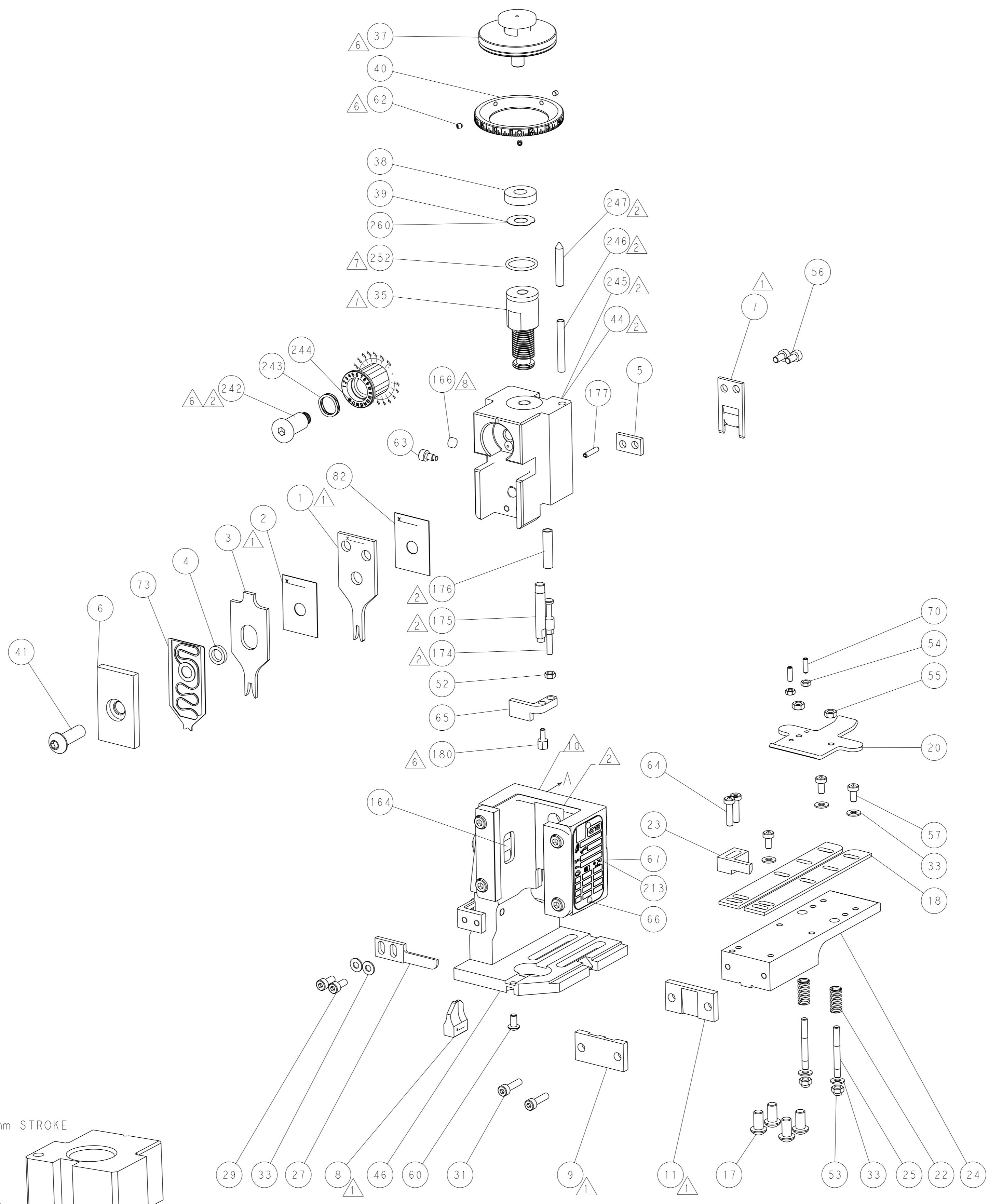
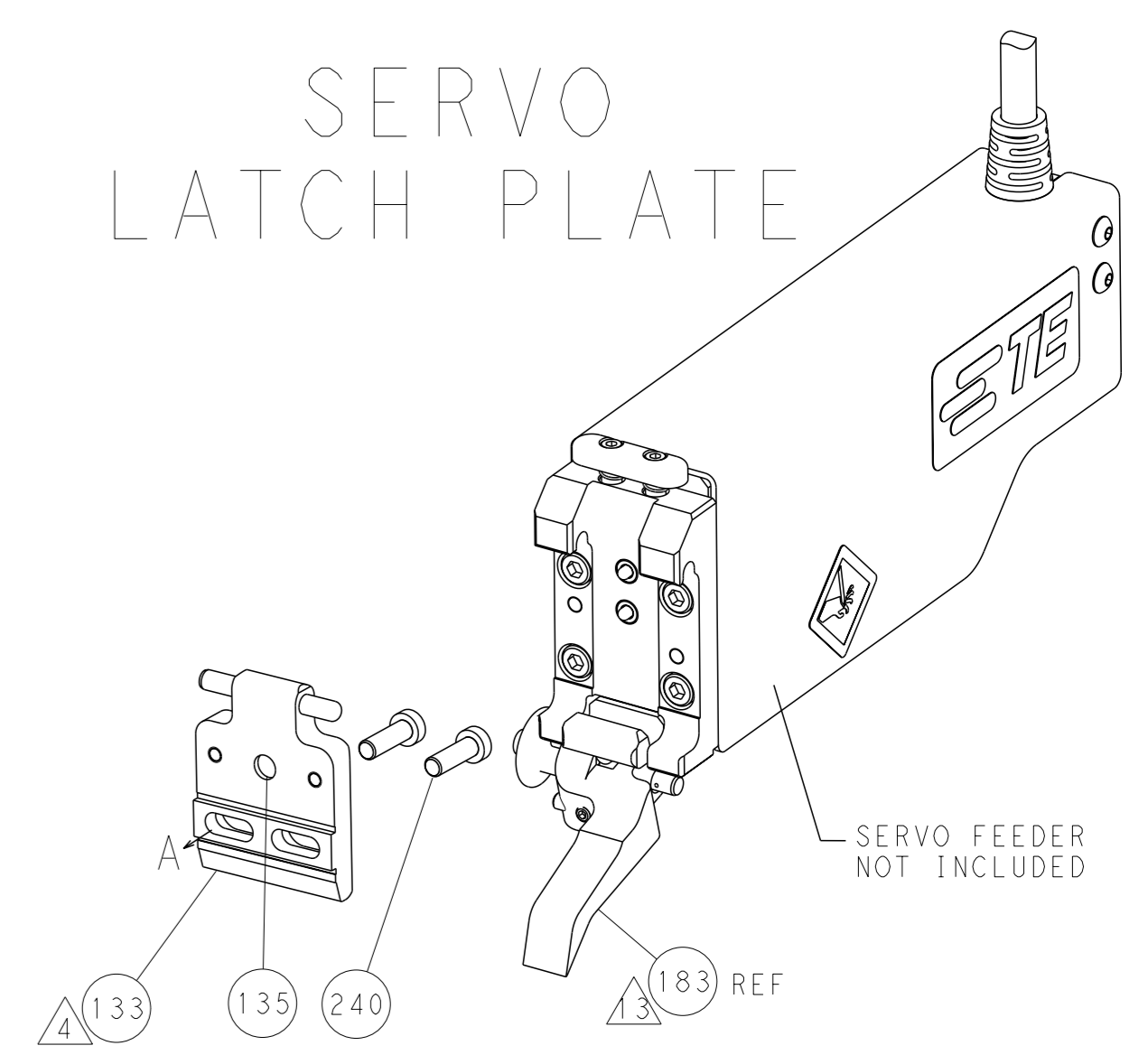
FEED TYPE
MECHANICAL



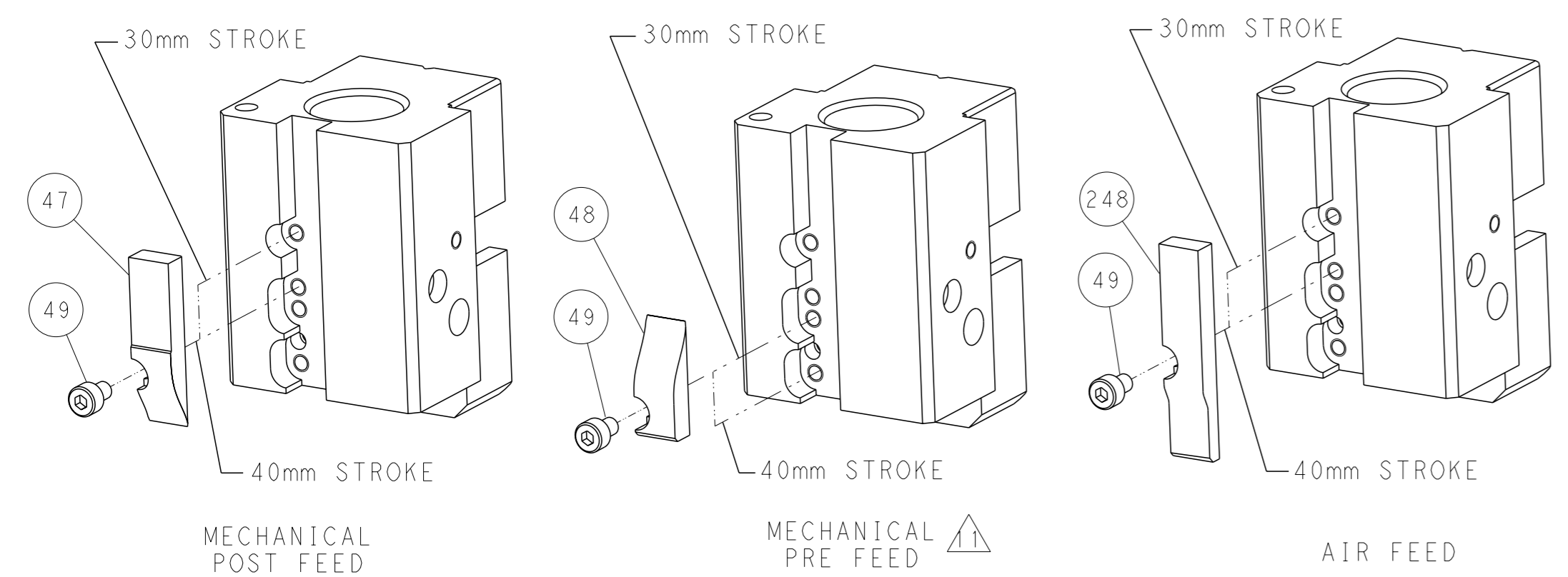
PNEUMATIC



SERVO
LATCH PLATE



CAM POSITIONS



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

DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ° ± FINISH		OWN: K. STAKEM 12MAY2015 CHK: G. BAILEY 12MAY2015 APVD: T. ELBIN 12MAY2015 PRODUCT SPEC APPLICATION SPEC WEIGHT Customer Accessible Production Drawing		NAME: Ocean End Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: ©=2150545 SCALE: 1:1 SHEET: 2 of 4 REV: A		RESTRICTED TO:	
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PACIFIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART						
					CONVERT TO	PART NUMBERS REQUIRED					
	2-2150545-1	A	FINE CRIMP HEIGHT ADJUST	MECHANICAL	PNEUMATIC FEED	2119950-1	2119792-1	-	2119641-2	-	2063440-1
					SERVO LATCH PLATE	2119951-1	1901697-1	8-2150545-5	-	-	2168400-7 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2150545-4	-	-	-
	2-2150545-2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	MECHANICAL FEED	2119949-1	2063961-1	5-18022-5	2119653-2	-	-
					SERVO LATCH PLATE	2119951-1	1901697-1	8-2150545-5	-	-	2168400-7 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2150545-4	-	-	-
	2-2150545-5	A	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE	MECHANICAL FEED	2119949-1	2063961-1	5-18022-5	2119653-2	-	-
					PNEUMATIC FEED	2119950-1	2119792-1	-	2119641-2	-	2063440-1
	2-2150545-7	A	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	-
	7-2150545-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.78 mm (.070)	F
INSUL	2.92 mm (.115)	F
APPL INSTRUCTIONS 408-10390		

TERMINAL DATA: TAKBRO TERMINAL	TE CRIMP SPECIFICATION
TERMINAL NAME: TERMINAL	
WIRE STRIP LENGTH 3.17-3.93 mm (.125-.155 IN)	INSULATION DIAMETER RANGE Ø2.20-3.00 mm (.087-.118 IN)
TERMINAL APPLICATION SPECIFICATION	NONE
TERMINALS APPLIED	
TE TERMINAL 2113686-1	TAKBRO TERMINAL SF1-110-5B(B)

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.00mm	1.54 +/- 0.05 [1.061 +/- .002]	OUT OF RANGE
0.80mm	1.45 +/- 0.05 [1.057 +/- .002]	0.5
0.50mm	1.31 +/- 0.05 [1.052 +/- .002]	1.9

- RECOMMENDED SPARE PARTS**
- GREASE BEARING SURFACES LIGHTLY
- 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:
 MECHANICAL FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150545-4
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150545-4
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150545-5
- 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 & 180. APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242.
- GREASE THREADS, GROOVE AND O-RING ON ITEMS 139 & 153.
- 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.
- SPARE FEED CAM STORAGE LOCATION REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.
- 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.
- POSITION FEED FINGER OFF OF INSULATION BARREL TO FEED TERMINAL.

***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.

-	1	1	1	1	2119782-1	FINE ADJUST HEAD ASM, PACIFIC STYLE	251
-	-	-	1	-	2119640-1	PUSH ROD, AIR FEED	250
-	-	-	1	-	2079988-1	BUSHING, LCH5-12, MISUMI	249
-	1	1	1	1	1-22279-3	SPRING, COMPRESSION	246
-	1	1	1	1	2119082-3	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	77	-	27	-	25	-	-
-	77	-	27	-	25	PART NO	DESCRIPTION
-	-	-	-	-	-	ITEM NO	

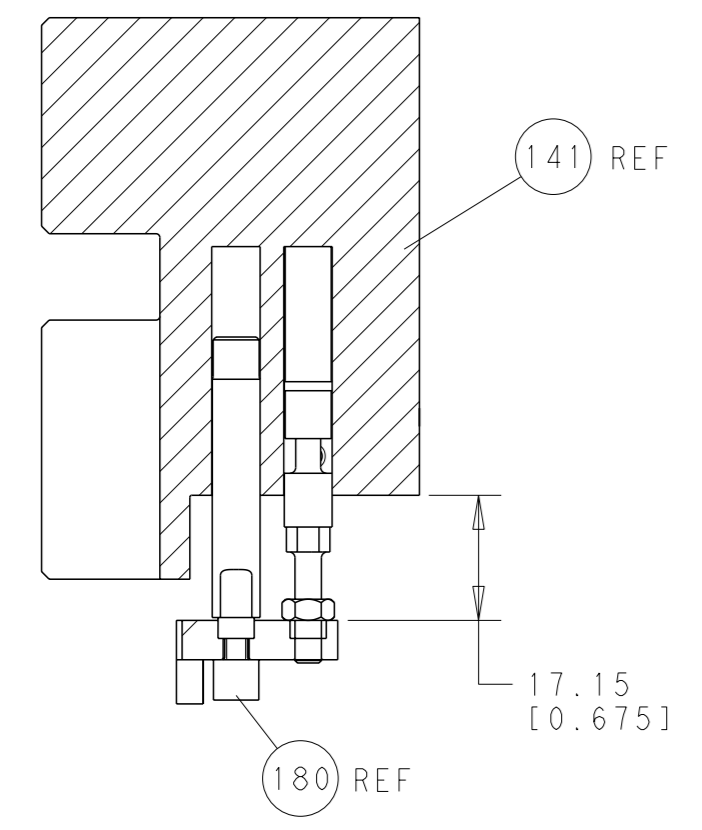
PACIFIC VERSION
 Shown on sheets 3 of 4 & 4 of 4
 (Atlantic version shown on sheets 1 of 4 & 2 of 4)

SET UP GAUGE		LOC	DIST	REVISIONS			
2119599-2	A	66	P	LYR	DESCRIPTION	DATE	OWN
			-		SEE SHEET 1	-	-

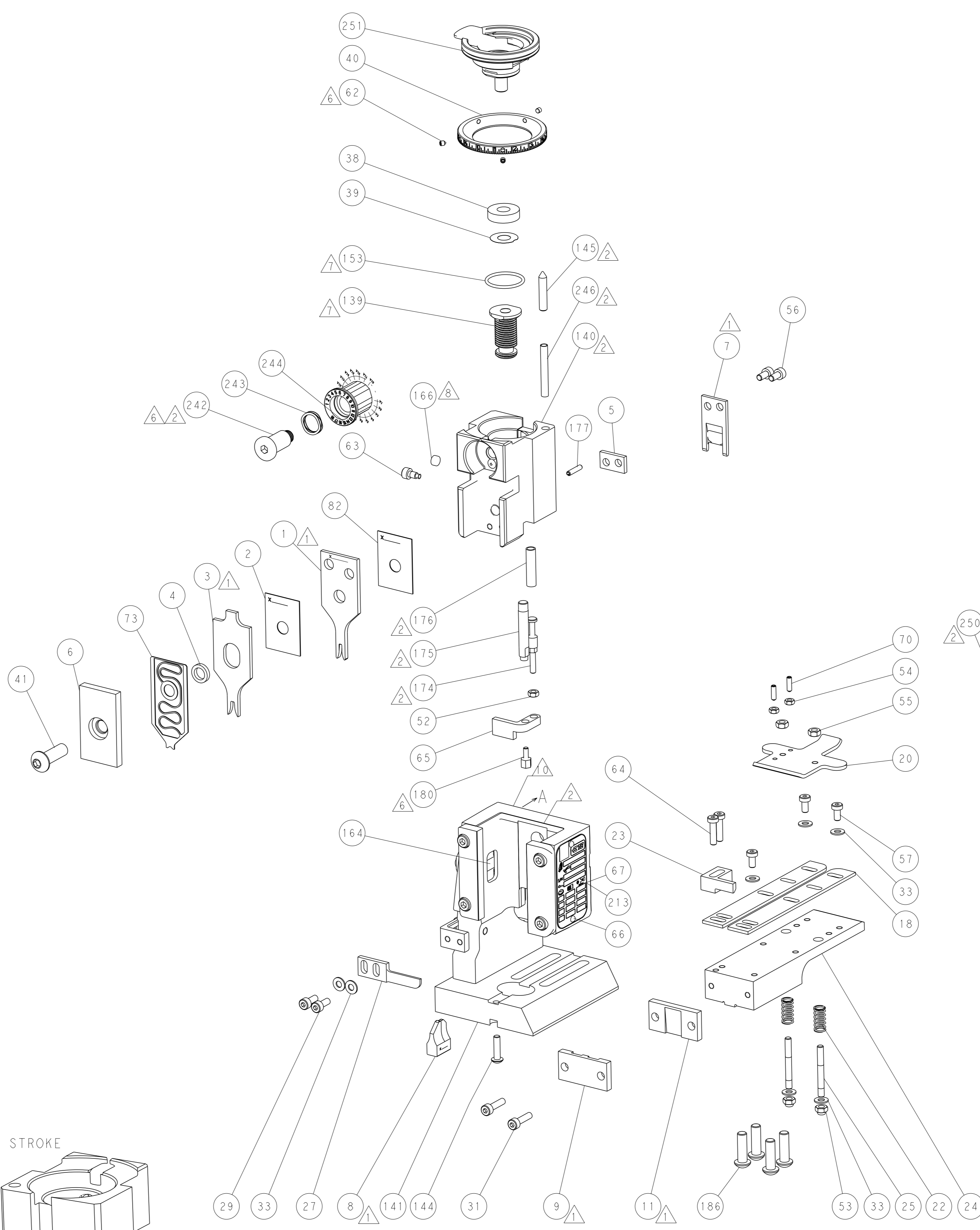
△	-	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	-	2	-	-	-	2168400-7	SHCS, LOW HEAD, RoHS, M5 X 10	240
-	-	-	-	1	-	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	-	-	1	-	-	2063440-1	AIR FEED MODULE	238
-	-	1	-	-	-	2119740-2	TAG, IDENTIFICATION	213
-	4	4	4	4	4	2079383-9	SCR, BHSC, RoHS (M6 X 20)	186
△	-	REF	-	-	-	1901697-1	FEED FINGER ASSEMBLY, EF	183
-	1	1	1	1	1	1752354-6	STANDOFF, HOLD-DOWN	180
-	1	1	1	1	1	6-993111-6	PIN, SLOTTED SPRING 3.0 X 14.0	177
-	1	1	1	1	1	8-22280-7	SPRING, COMPRESSION	176
-	1	1	1	1	1	1752353-2	GUIDE PIN, HOLDDOWN	175
-	1	1	1	1	1	1901680-2	GUIDE PIN, HOLDDOWN	174
-	-	-	2	-	-	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172
-	1	1	1	1	1	994969-1	MAGNET, RARE EARTH HIGH ENERGY	166
-	REF	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	-	-	1	-	-	240638-1	SPRING, FEED FINGER	163
-	1	1	1	1	1	8-21084-1	O-RING, .801 ID, .070 DIA. MAT.	153
-	-	-	1	-	-	2119641-2	FEED CAM, AIR FEED	152
-	1	1	1	1	1	2119798-2	DETENT PIN	145
-	1	1	1	1	1	2079383-8	SCR, BHSC, RoHS (M4 X 16)	144
-	-	-	-	1	-	2119653-2	FEED CAM, POST FEED	142
-	1	1	1	1	1	2119655-6	APPLICATOR BASIC ASSEMBLY, EF	141
-	1	1	1	1	1	2119651-1	RAM, ASIAN STYLE, END FEED	140
-	1	1	1	1	1	2119092-2	BOLT, ADJUSTMENT	139
-	-	-	1	-	-	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854	137
-	-	REF	-	-	-	SEE NOTE 4	MEMORY CHIP, PROGRAMMED	135
-	-	1	-	-	-	1633743-1	SERVO FEED LATCH ASM	133
-	1	1	1	1	1	455888-4	SPACER, CRIMPER	82
-	1	1	1	1	1	2119791-5	DEPRESSOR, WIRE	73
-	1	1	1	1	1	2119956-2	DOCUMENTATION PACKAGE	71
-	2	2	2	2	2	2-18032-2	SCR, SET, FLT PNT, M3 X 10.0	70
-	1	-	1	1	1	2119740-1	TAG, IDENTIFICATION	67
-	2	2	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	1	1	1	1	1	1-1901681-8	HOLDDOWN, TERMINAL	65
-	2	2	2	2	2	2168400-8	SHCS, LOW HEAD, RoHS, M4 X 16	64
△	-	1	1	1	1	2119793-1	LIMITER, ADJUSTMENT BOLT	63
-	-	3	3	3	3	992763-5	SCR, SET, SOC, CONE PNT, M3 x 4.0	62
-	-	-	-	1	-	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
△	-	-	-	1	-	2063961-1	FEED FINGER	58
-	-	3	3	3	3	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57
-	-	2	2	2	2	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	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	2	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	-	-	-	1	-	2119652-1	FEED CAM, PRE FEED	48
-	1	1	1	1	1	2079383-7	SCR, BHSC, RoHS (M8 X 25)	41
-	1	1	1	1	1	2119645-1	DISC, NUMBERED FA WIRE ADJUSTMENT	40
-	1	1	1	1	1	2119957-1	APPLICATOR SHIM PACK	39
-	1	1	1	1	1	1-2119644-2	RAM WASHER, PRECISION	38
-	7	7	7	7	7	1-18028-2	WASHER, FLAT, REG M4	33
-	2	2	2	2	2	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	31
-	2	2	2	2	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	29
-	1	1	1	1	1	240639-3	STRIPPER (MACHINING)	27
-	2	2	2	2	2	1320906-1	STUD, THREADED	25
-	1	1	1	1	1	1752371-5	PLATE, STRIP GUIDE	24
-	1	1	1	1	1	240825-1	PLATE, STRIP HOLD DOWN	23
-	2	2	2	2	2	2-22281-3	SPRING, COMPRESSION	22
-	1	1	1	1	1	1752373-4	DRAG	20
-	2	2	2	2	2	1901259-4	GUIDE, LOWER STRIP	18
△	-	1	1	1	1	240644-9	PLATE, REAR SHEAR	11
-	-	-	-	-	-	-	-	10
△	-	1	1	1	1	5-690482-6	PLATE, FRONT SHEAR	9
△	1	1	1	1	1	2-1803060-1	ANVIL, COMBINATION, END FEED	8
△	-	1	1	1	1	2217206-1	BLADE, SLUG	7
-	-	1	1	1	1	1803203-1	BLOCK, FRONT DEPRESSOR	6
-	-	1	1	1	1	240641-7	SPACER	5
-	-	1	1	1	1	238011-4	BLOCK, CRIMPER SPACER	4
△	1	1	1	1	1	2-1803187-0	CRIMPER, INSULATION F	3
-	-	1	1	1	1	455888-4	SPACER, CRIMPER	2
△	1	1	1	1	1	3-456404-5	CRIMPER, WIRE PREMIUM	1

DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.1, 1 PLC ±.125, 2-4 PLC ±.15, 5-8 PLC ±.2, 9-10 PLC ±.25, ANGLES FINISH		OWN: H. STAKEM 12MAY2015 CHK: G. BAILEY 12MAY2015 APVD: T. ELBIN 12MAY2015	NAME: Ocean End Feed Applicator	
MATERIAL: .	WEIGHT: .	SCALE: 1:1	CAGE CODE: 00779	DRAWING NO: 2150545	SHEET 3 of 4	REV A

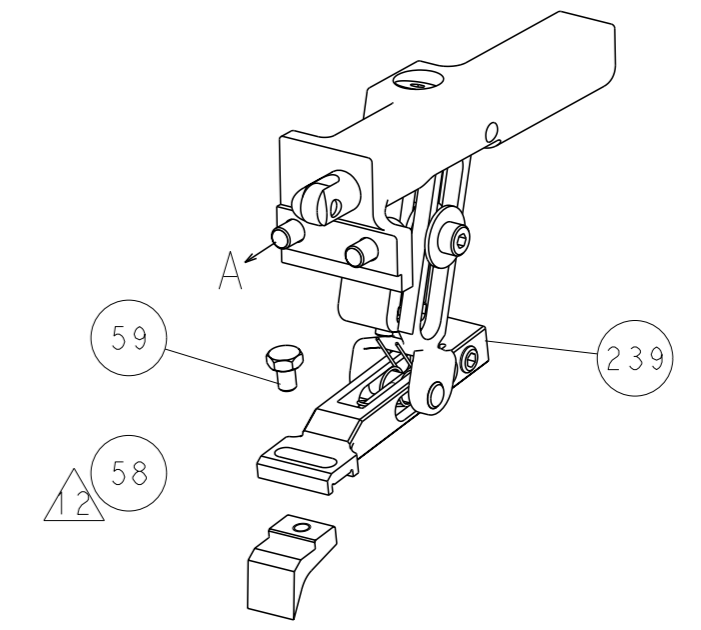
LOC		DIST		REVISIONS			
A	66	P	LYR	DESCRIPTION	DATE	OWN	APVD
		-		SEE SHEET 1			



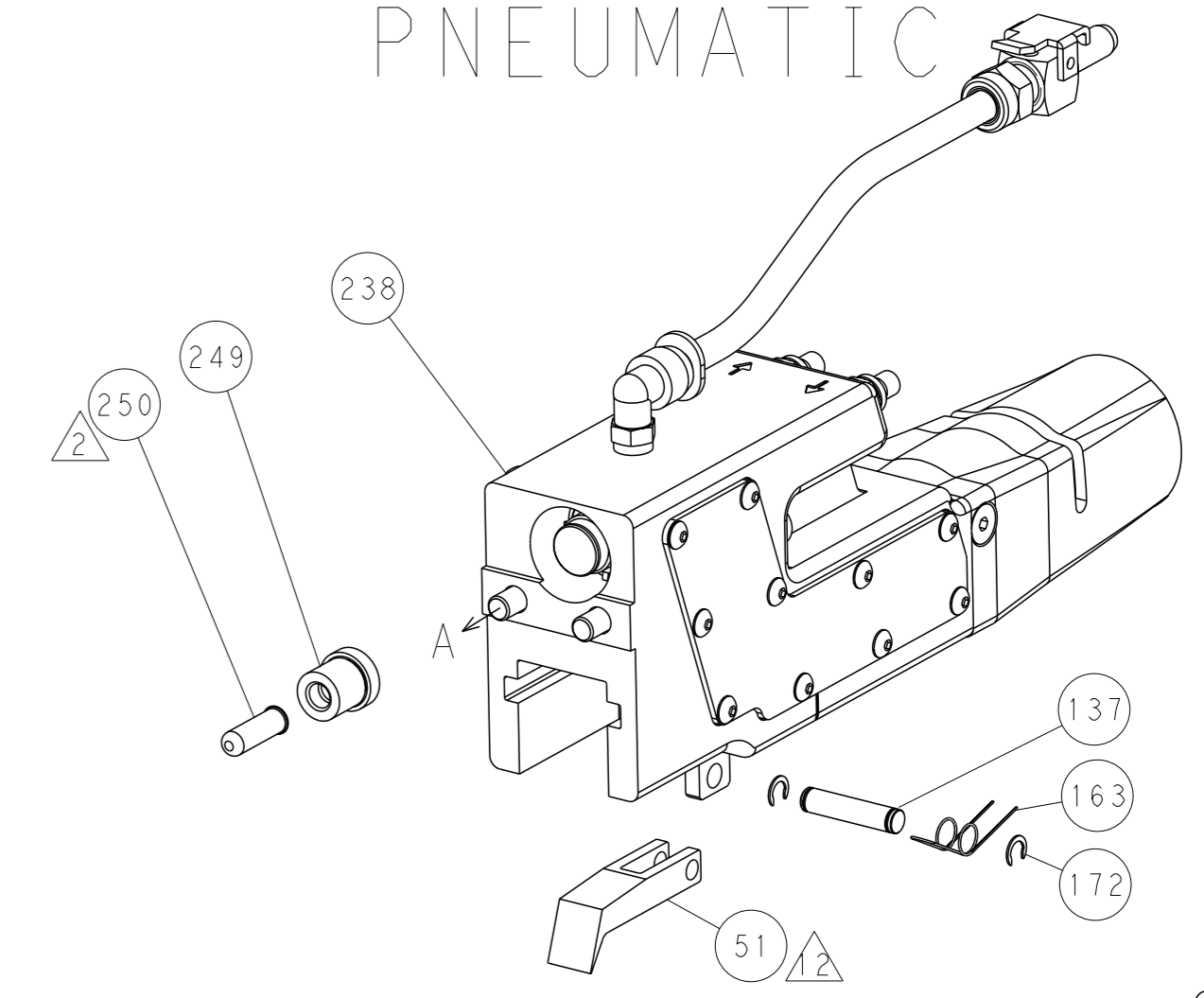
HOLDDOWN SET-UP



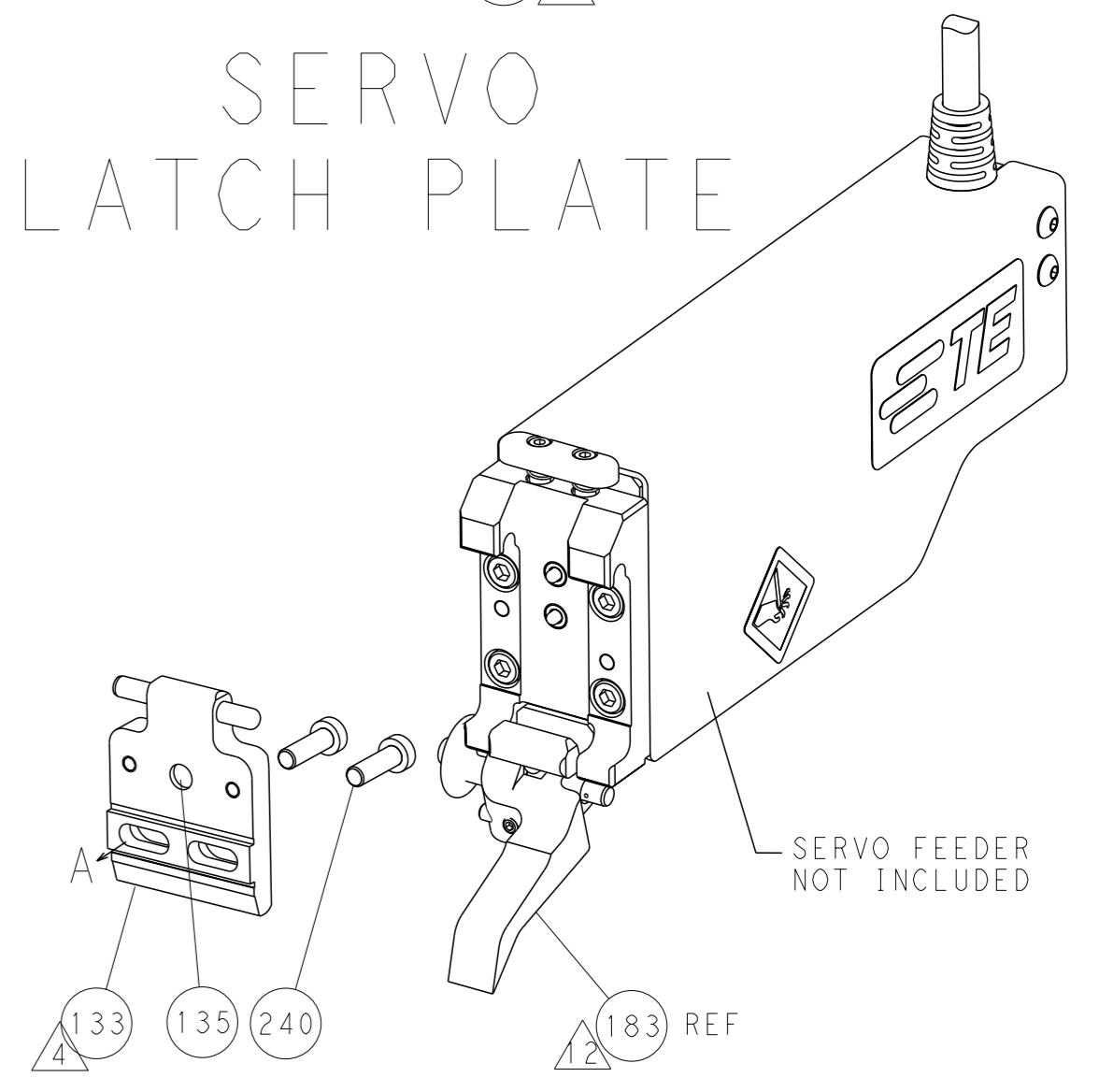
FEED TYPE
MECHANICAL



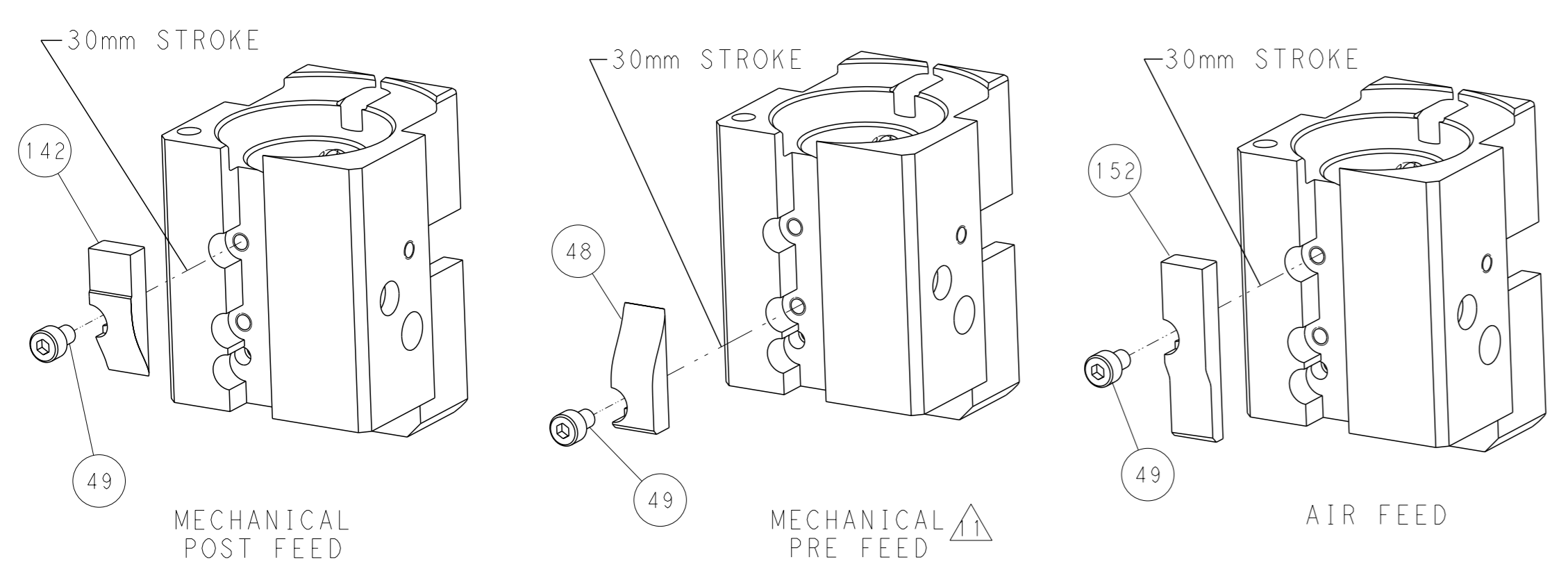
PNEUMATIC



SERVO
LATCH PLATE



CAM POSITIONS



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

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		OWN: K. STAKEM 12MAY2015		STE Connectivity	
mm	0 PLC ±	1 PLC ±	2 PLC ±	CHK: G. BAILEY 12MAY2015	NAME: Ocean End Feed Applicator		RESTRICTED TO:
	3 PLC ±	4 PLC ±	ANGLES FINISH *	APVD: J. ERLIN 12MAY2015	SIZE: A1		CAGE CODE: 00779
MATERIAL:				PRODUCT SPEC:	DRAWING NO: C-2150545		SCALE: 1:1
				APPLICATION SPEC:	SHEET 4 OF 4		REV A
				WEIGHT:	Customer Accessible Production Drawing		