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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

2151322-1

A

FINE CRIMP HEIGHT ADJUST

MECHANICAL

PNEUMATIC FEED

2119950-1

1338685-1

5-18022-5

2119641-1

2119799-1

2063440-1

2151322-2

A

FINE CRIMP HEIGHT ADJUST

PNEUMATIC

SERVO LATCH PLATE

2119951-1

-

8-2151322-5

1901094-3

-

2168400-6 (QUANTITY 2)

2151322-5

A

FINE CRIMP HEIGHT ADJUST

SERVO LATCH PLATE

2161326-1

-

8-2151322-4

-

-

-

2151322-6

A

NON-CRIMP HEIGHT ADJUST

SERVO LATCH PLATE

2119949-1

1338685-1

5-18022-5

2119653-1

-

-

2151322-7

A

FINE CRIMP HEIGHT ADJUST

NONE

2119950-1

1338685-1

5-18022-5

2119641-1

2119799-1

2063440-1

7-2151322-7

A

CRIMP TOOLING KIT

-

-

-

-

-

-

-

APPLICATOR DATA

CRIMP SIZE TYPE

WIRE 1.78 mm [.070] F

INSUL 5.84 mm [.230] O

APPLICATOR INSTRUCTIONS 408-10389

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION

TERMINAL NAME: DIA 4MM SOCKET CONTACT

WIRE STRIP LENGTH INSULATION DIAMETER RANGE

4.70-5.30 mm [.185-.209 IN] Ø1.00-4.00 mm [.039-.157 IN]

TERMINAL APPLICATION SPECIFICATION

TERMINALS APPLIED

TE TERMINAL TE TERMINAL TE SEAL TE SEAL

962952-1 962952-2 963243-1

WIRE SIZE

CRIMP HEIGHT mm [INCH]

CRIMP HEIGHT REFERENCE SETTING

1.00mm2 1.60+/-0.05 [.063+/- .002] 8.3

0.75mm2 1.52+/-0.05 [.060+/- .002] 9.3

0.50mm2 1.40+/-0.05 [.055+/- .002] 10.5

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: 8-2151322-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151322-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151322-5
SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2151322-6

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 ITEM 50.

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.

SPARE FEED CAM STORAGE LOCATION REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.

TO CONVERT THE APPLICATOR TO A NON-CARRIER CUTTING STYLE, REMOVE ITEM 13 AND ATTACH TO THE LOCATION ON THE BACK SIDE OF THE HOUSING. REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.

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

THIS APPLICATOR APPLIES TERMINAL WITH A SEAL.

APPLY TORO-SEAL IN ALLEN SOCKET TO FILL HOLE AFTER FLAT HD HAS BEEN ADJUSTED TO CORRECT HEIGHT AT QUALIFICATION. APPLY #1-23419-5 LOC-TITE TO THREADS.

APPLICATOR STYLE CONVERSION CHART

PART NUMBERS REQUIRED

2119950-1 1338685-1 5-18022-5 2119641-1 2119799-1 2063440-1

2119951-1 - 8-2151322-5 1901094-3 - 2168400-6 (QUANTITY 2)

2161326-1 - 8-2151322-4 - - -

2119949-1 1338685-1 5-18022-5 2119653-1 - -

2119951-1 - 8-2151322-5 1901094-3 - 2168400-6 (QUANTITY 2)

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SET UP GAUGE 2119599-1

LOC A

DIST 66

REVISIONS

DESCRIPTION

DATE

OWN

APVD

RELEASED

31JAN2012

LG

GB

1 1 1 2119798-1 DETENT PIN 247

1 1 1 1-22279-3 SPRING, COMPRESSION 246

1 1 1 2119758-1 RAM, AMP STYLE, SIDE FEED, NON-ADJ. 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

1 1 1 1 18023-1 SCR, SKT HD CAP M3 X 5.0 241

- 2 2 - 2168400-6 SHCS, LOW HEAD, RoHS, M5 X 16 240

- - - 1 2119580-1 MECHANICAL FEED ASSEMBLY 239

- - - 1 2063440-1 AIR FEED MODULE 238

- 1 1 - 2119740-2 TAG,IDENTIFICATION 213

- 1 1 - 1901094-3 SPACER, FEEDER 198

1 1 1 1 993111-1 PIN, SLOTTED SPRING 3.0 X 20.0 177

1 1 1 1 8-22280-7 SPRING, COMPRESSION 176

1 1 1 1 1752353-2 GUIDE PIN,HOLDDOWN 175

1 1 1 1 1901680-2 GUIDE PIN,HOLDDOWN 174

- - - 2 21045-3 RING, RETAIN, EXTERN, 3/16 CRESCENT 172

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 - 3-23627-7 PIN, RETAIN, GRVD, 3/16 X .854 137

- - - 1 - 2119799-1 HOLDER,FEED FINGER, AF 136

- - REF REF - - SEE NOTE 4 MEMORY CHIP, PROGRAMMED 135

- 1 1 - - 1633743-1 SERVO FEED LATCH ASM 133

1 1 1 1 1-18028-2 WASHER, FLAT, REG M4 119

- REF REF - - 2119944-1 FEED FINGER ASSEMBLY,SF 117

1 1 1 1 455888-5 SPACER, CRIMPER 82

1 1 1 1 2119956-1 DOCUMENTATION PACKAGE 71

1 1 1 1 2119791-9 DEPRESSOR, WIRE 70

1 - - 1 1 2119740-1 TAG,IDENTIFICATION 67

2 2 2 2 2168078-1 SCREW, DRIVE, RH, RoHS 66

1 - 1 1 1 2119793-1 LIMITER, ADJUSTMENT BOLT 63

3 - 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

- - - 1 1 5-18022-5 SCR, HEX HD CAP, M4 X 6.0 59

1 1 1 1 985575-3 SCR, FLT SKT HD CAP M3 X 10.0 57

- - - 1 1 1338685-1 PAWL, FEED 56

4 4 4 4 2168400-1 SHCS, LOW HEAD, RoHS, M4 X 12 54

1 1 1 1 1-5018030-0 NUT, HEX, REG, RoHS, M3.5 52

1 1 1 1 1901681-1 HOLDDOWN, TERMINAL 51

1 1 1 1 2-1752354-9 STANDOFF,HOLD-DOWN 50

- - - 1 2 18023-9 SCR, SKT HD CAP M4 X 6.0 49

- - - - 1 2119652-1 FEED CAM, PRE FEED 48

- - - - 1 2119653-1 FEED CAM, POST FEED 47

1 1 1 1 2119656-9 APPLICATOR BASIC ASSEMBLY, SF 46

1 - 1 1 1 2119370-1 RAM, AMP STYLE, SIDE FEED 44

1 1 1 1 2079383-7 SCR, BHSC, RoHS (M8 X 25) 41

1 - 1 1 1 2119645-1 DISC, NUMBERED FA WIRE ADJUSTMENT 40

1 - 1 1 1 2119957-1 APPLICATOR SHIM PACK 39

1 1 1 1 2119644-2 RAM WASHER, PRECISION 38

1 1 1 1 2119085-1 FA HEAD, ATLANTIC STYLE 37

1 - 1 1 1 2119092-1 BOLT, ADJUSTMENT 35

1 1 1 1 1-1752356-7 SUPPORT, TERMINAL 34

2 2 2 2 2 2079383-5 SCR, BHSC, RoHS (M4 X 20) 33

1 1 1 1 2161328-1 HEX HEAD, FLANGED, M5 x 8mm LONG 32

1 1 1 1 1320908-7 SPACER, STRIP GUIDE 30

1 1 1 1 2119959-2 ASSEMBLY, STRIP GUIDE 29

1 1 1 1 455888-5 SPACER, CRIMPER 28

1 1 1 1 1320928-2 PLATE, STRIP GUIDE 24

1 1 1 1 2168083-2 SCR, SKT HD CAP, RoHS, M4 X 8.0 21

1 1 1 1 1-18028-2 WASHER, FLAT, REG M4 20

1 1 1 1 2119533-1 STRIPPER, SIDE FEED 19

1 1 1 1 2119806-1 INSERT, SHEAR 13

1 1 1 1 3-22280-3 SPRING, COMPRESSION 12

1 1 1 1 1-356885-4 STOP, SHEAR 11

1 1 1 1 2119805-1 SHEAR HOLDER, FRONT 10

1 1 1 1 318707-1 FLOATING SHEAR, FRONT 9

1 1 1 1 3-1633711-9 ANVIL, COMBINATION 8

1 1 1 1 2119781-1 DEPRESSOR, SHEAR 5

1 1 1 1 4-238011-5 BLOCK, CRIMPER SPACER 4

1 1 1 1 1803018-2 CRIMPER, INSULATION O 3

1 1 1 1 455888-5 SPACER, CRIMPER 2

1 1 1 1 1-456404-8 CRIMPER, WIRE PREMIUM 1

APPLICATOR DATA

CRIMP SIZE TYPE

WIRE 1.78 mm [.070] F

INSUL 5.84 mm [.230] O

APPLICATOR INSTRUCTIONS 408-10389

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION

TERMINAL NAME: DIA 4MM SOCKET CONTACT

WIRE STRIP LENGTH INSULATION DIAMETER RANGE

4.70-5.30 mm [.185-.209 IN] Ø1.00-4.00 mm [.039-.157 IN]

TERMINAL APPLICATION SPECIFICATION

TERMINALS APPLIED

TE TERMINAL TE TERMINAL TE SEAL TE SEAL

962952-1 962952-2 963243-1

WIRE SIZE

CRIMP HEIGHT mm [INCH]

CRIMP HEIGHT REFERENCE SETTING

1.00mm2 1.60+/-0.05 [.063+/- .002] 8.3

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RECOMMENDED SPARE PARTS

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APPLICATOR SPECIFIC DATA TO BE ENTERED INTO BLANK MEMORY CHIP AT ASSEMBLY. SEE BELOW FOR PART NUMBER:
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SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151322-5
SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2151322-6

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 ITEM 50.

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.

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APPLICATOR STYLE CONVERSION CHART

PART NUMBERS REQUIRED

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SET UP GAUGE 2119599-1

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- 1 1 - 2119740-2 TAG,IDENTIFICATION 213

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1 1 1 1 993111-1 PIN, SLOTTED SPRING 3.0 X 20.0 177

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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 - 3-23627-7 PIN, RETAIN, GRVD, 3/16 X .854 137

- - - 1 - 2119799-1 HOLDER,FEED FINGER, AF 136

- - REF REF - - SEE NOTE 4 MEMORY CHIP, PROGRAMMED 135

- 1 1 - - 1633743-1 SERVO FEED LATCH ASM 133

1 1 1 1 1-18028-2 WASHER, FLAT, REG M4 119

- REF REF - - 2119944-1 FEED FINGER ASSEMBLY,SF 117

1 1 1 1 455888-5 SPACER, CRIMPER 82

1 1 1 1 2119956-1 DOCUMENTATION PACKAGE 71

1 1 1 1 2119791-9 DEPRESSOR, WIRE 70

1 - - 1 1 2119740-1 TAG,IDENTIFICATION 67

2 2 2 2 2168078-1 SCREW, DRIVE, RH, RoHS 66

1 - 1 1 1 2119793-1 LIMITER, ADJUSTMENT BOLT 63

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1 1 1 1 3-1633711-9 ANVIL, COMBINATION 8

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- REF REF REF REF REF 994970-2 COUNTER, MAGNETIC 164

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- - - 1 1 1338685-1 PAWL, FEED 56

4 4 4 4 2168400-1 SHCS, LOW HEAD, RoHS, M4 X 12 54

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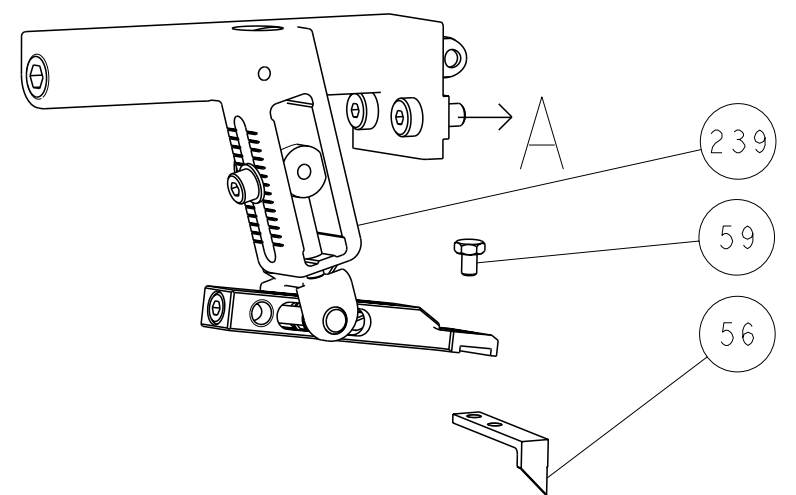
DIMENSIONING AND TOLERANCING PER ASME Y14.5M-2009

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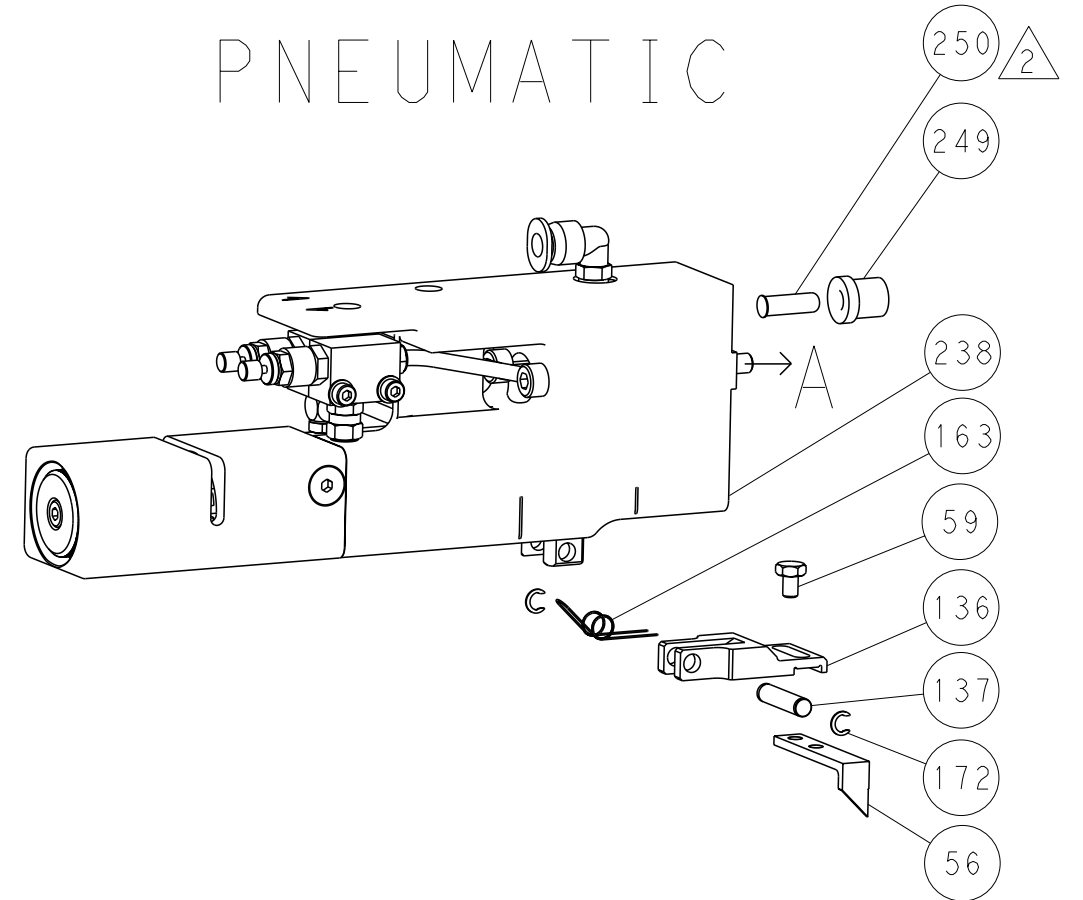
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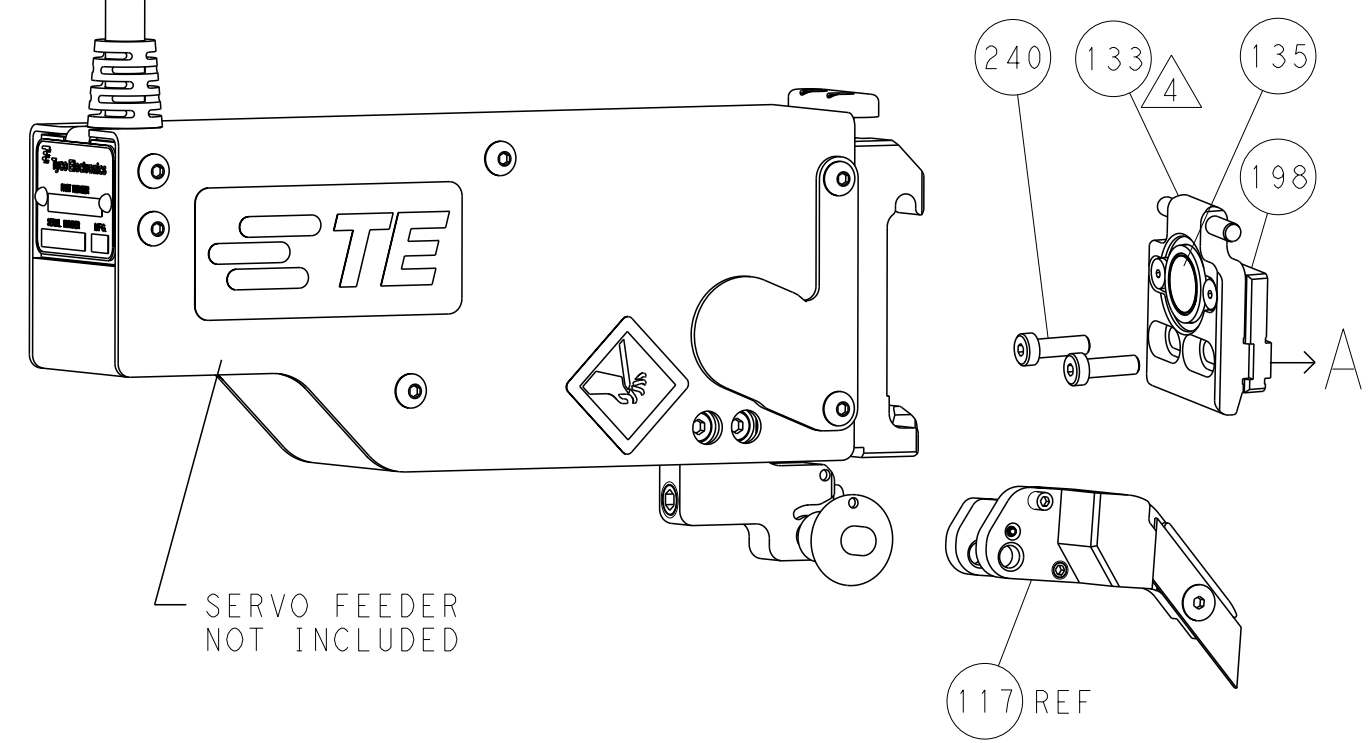
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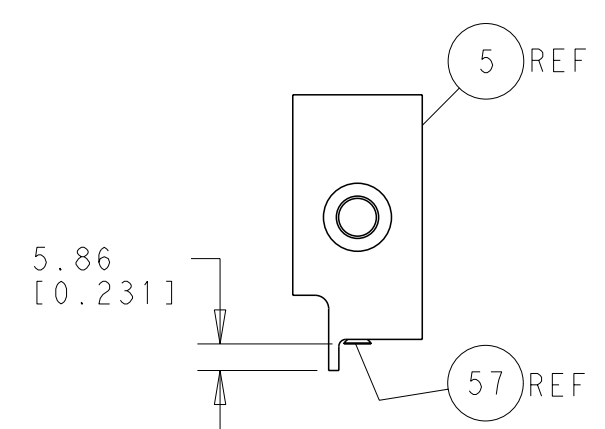
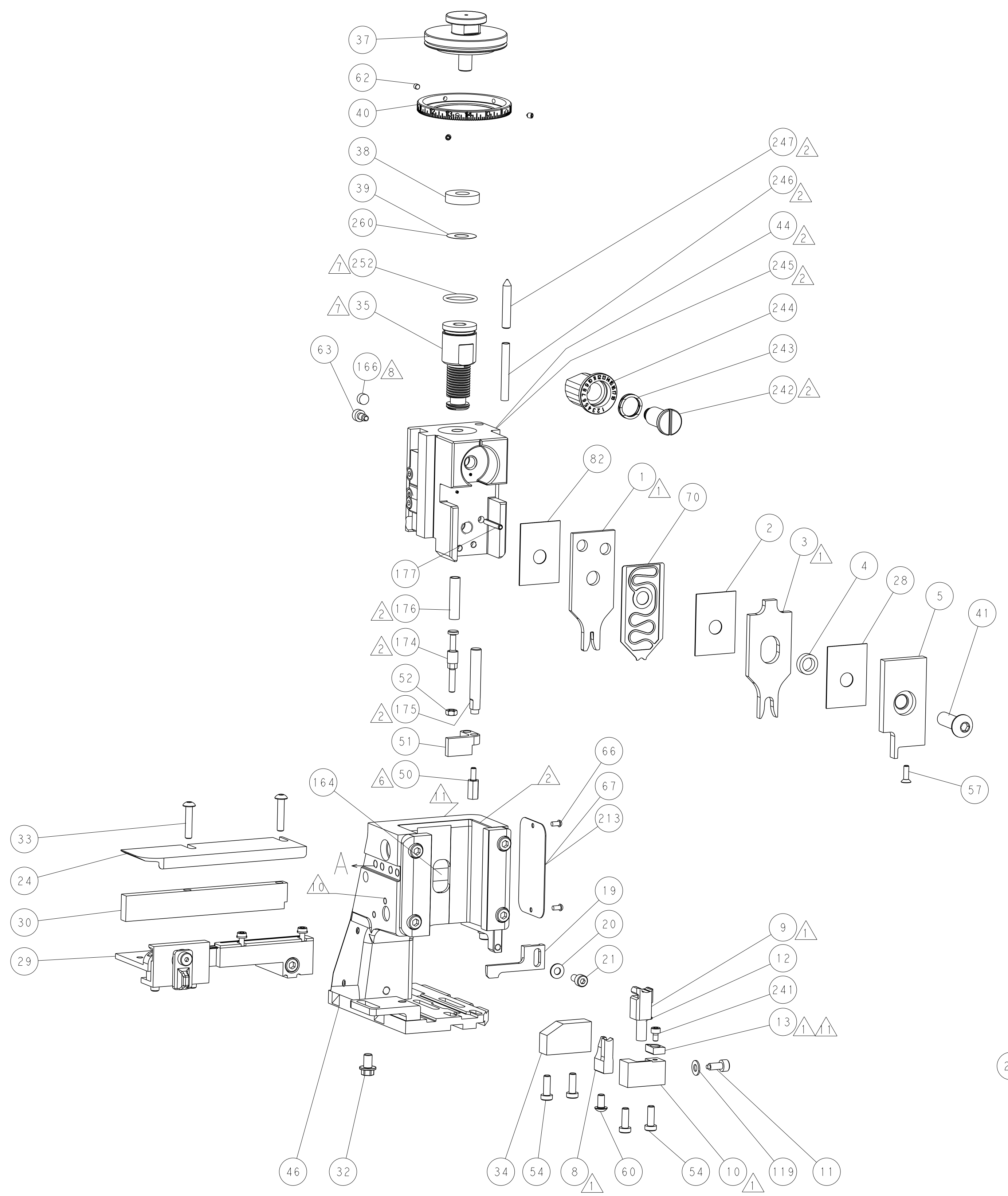
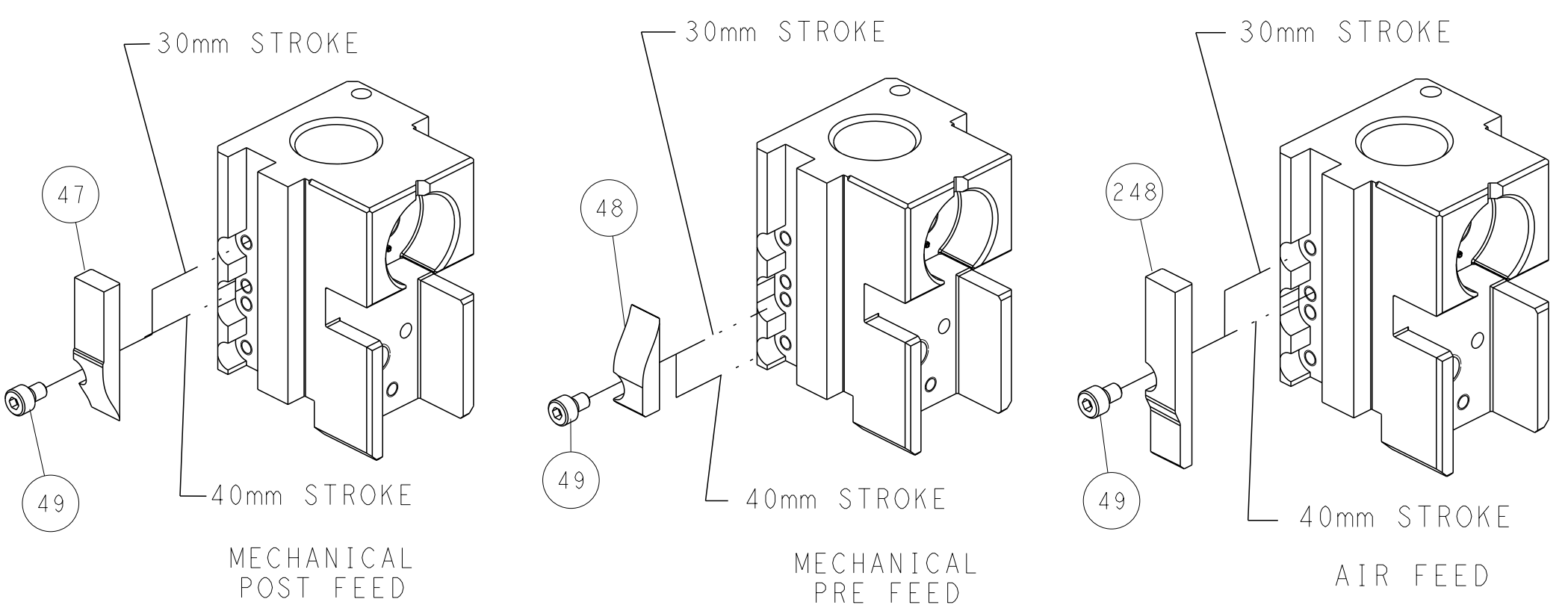
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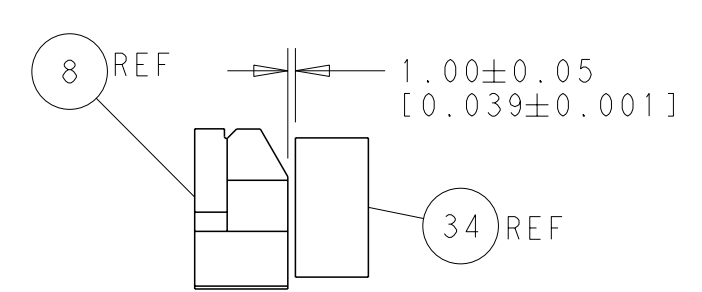
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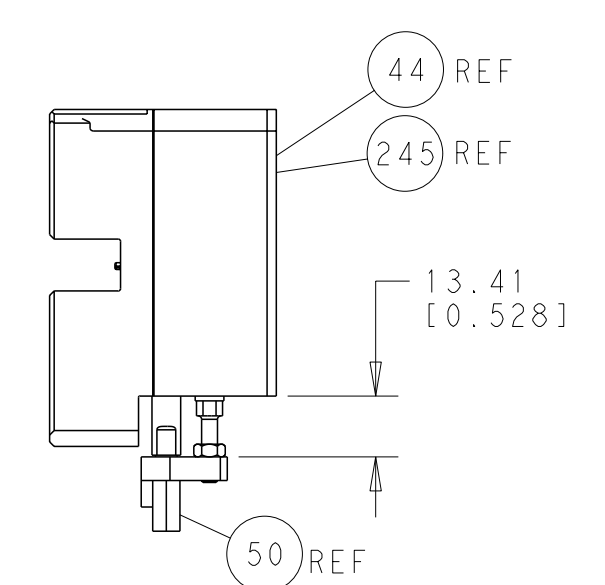
CAM POSITIONS



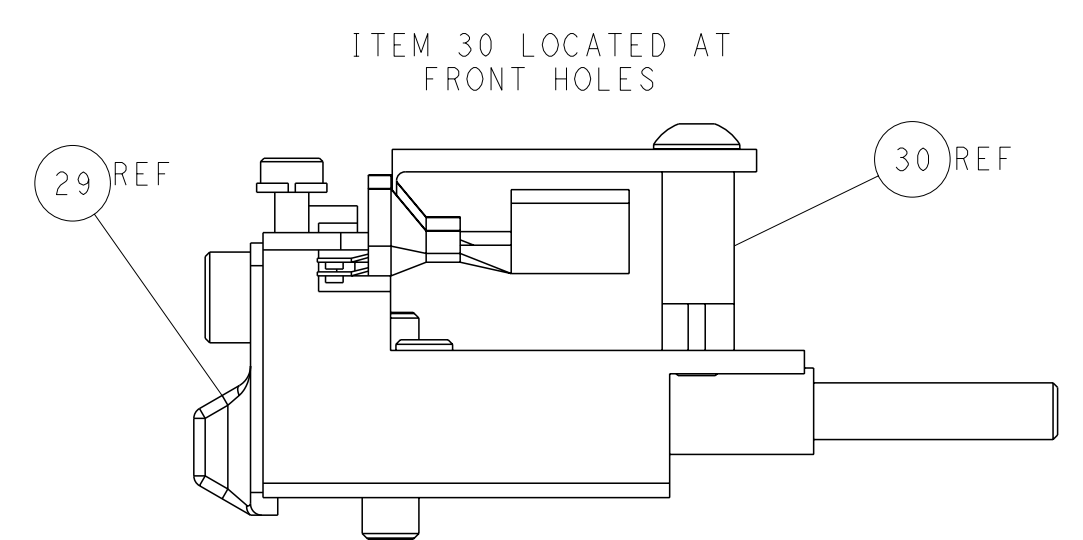
SHEAR DEPRESSOR DETAIL



TERMINAL SUPPORT LOCATION



HOLDDOWN SET-UP



FEED TRACK POSITION
GUIDE BY INSULATION BARREL

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: 9 PLC ±.5 1 PLC ±0.13 2 PLC ±0.13 3 PLC ±0.013 4 PLC ±0.0001 ANGLES FINISH		RESTRICTED TO
MATERIAL -		WEIGHT -		SIZE A1
CUSTOMER ACCESSIBLE PRODUCTION DRAWING		SCALE 1:2		SHEET 2 OF 4
				REV A

SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

DIMENSIONING AND TOLERANCING PER ASME Y14.5M-2009

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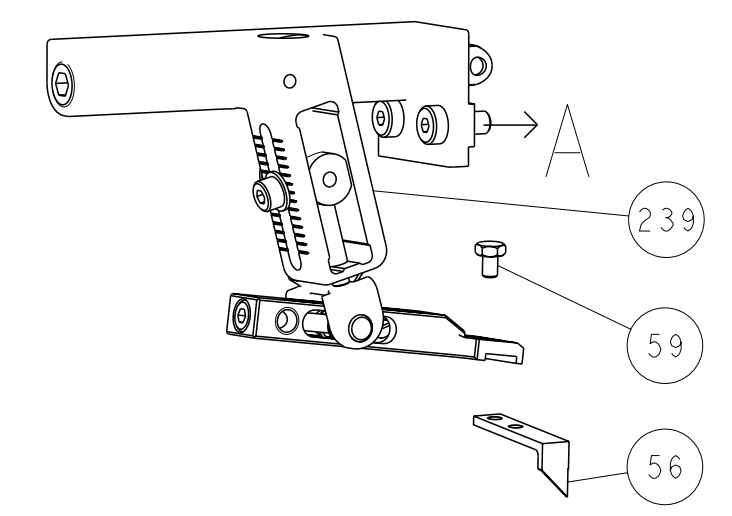
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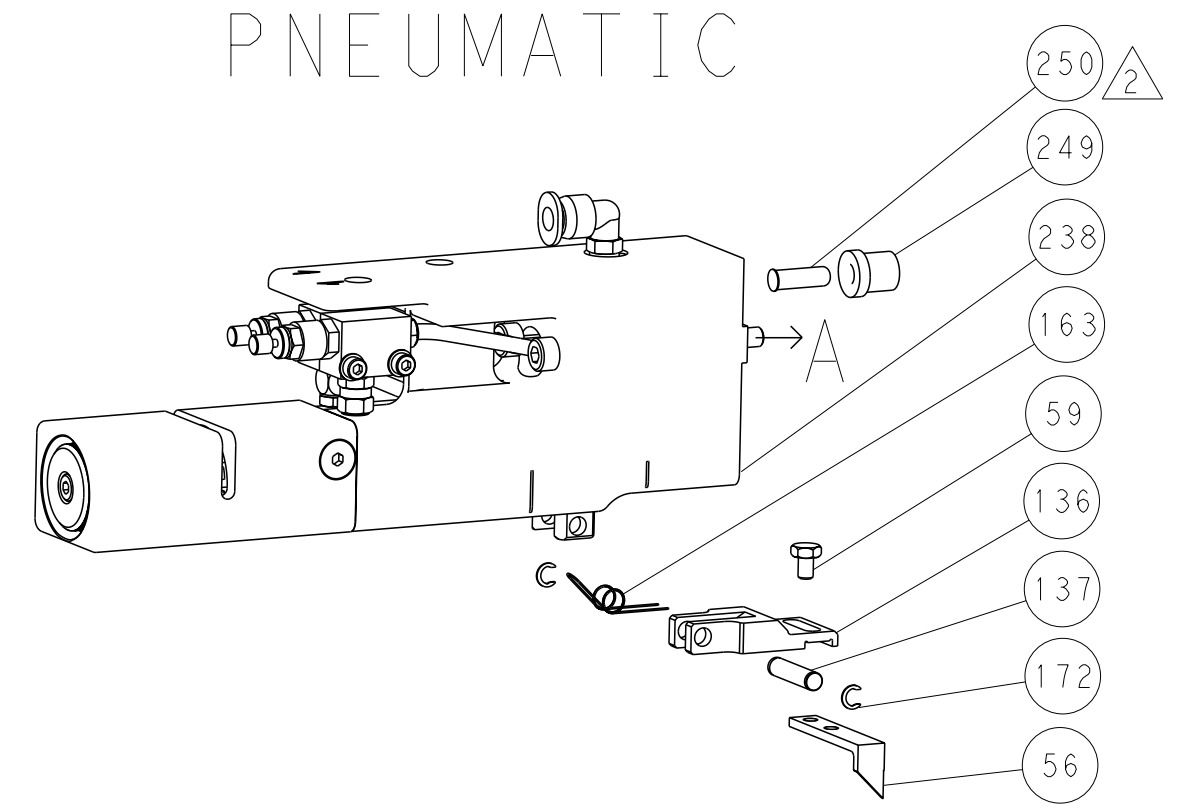
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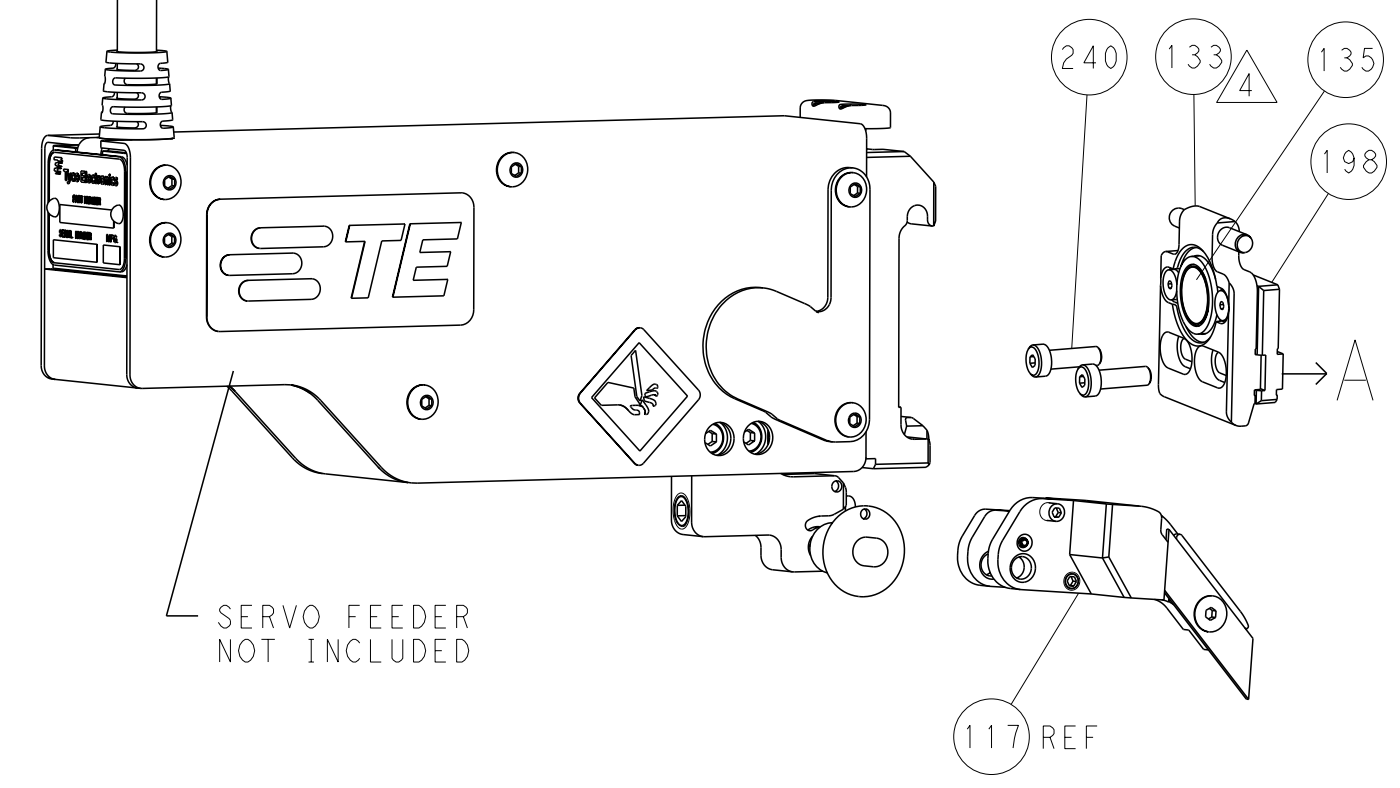
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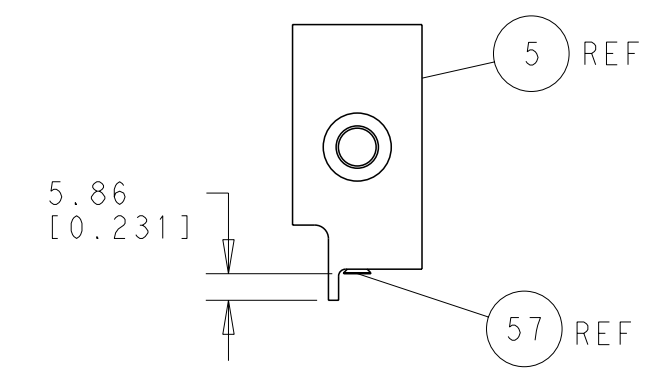
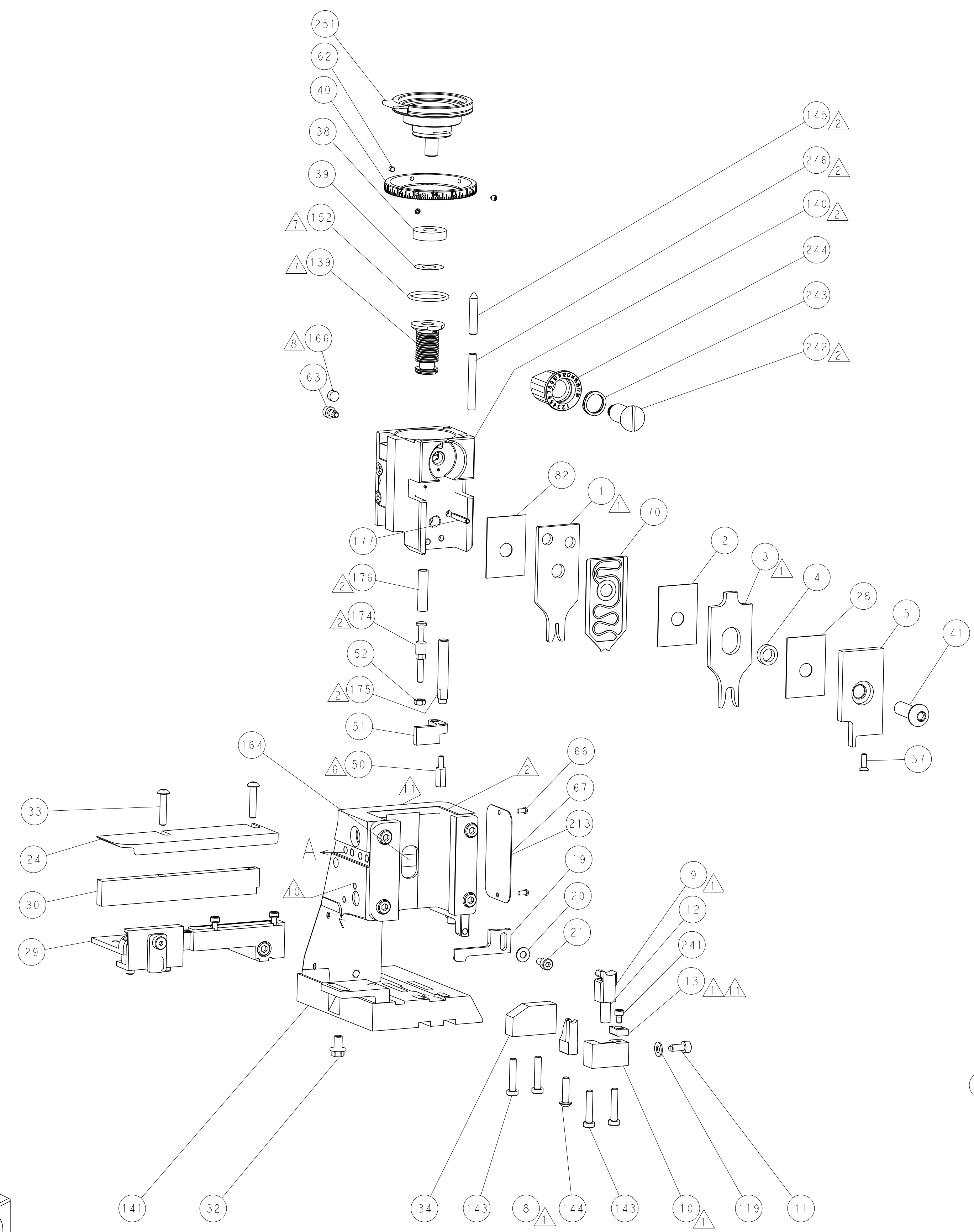
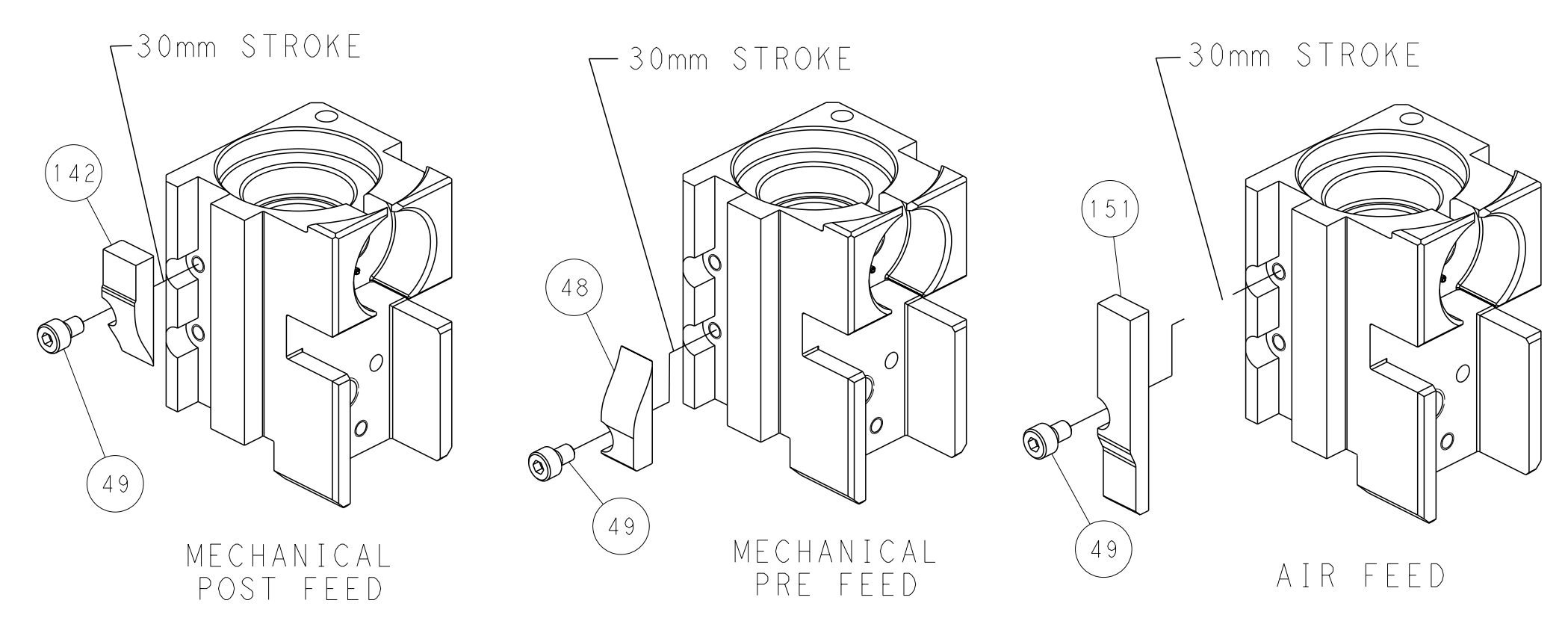
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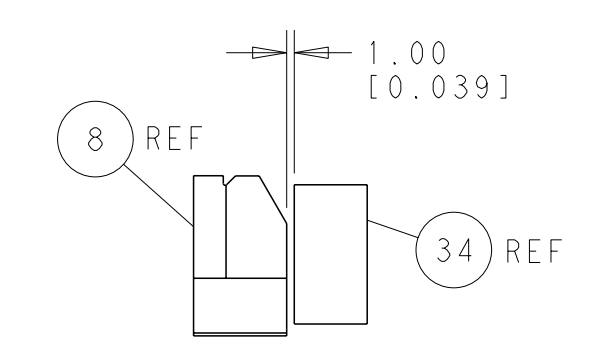
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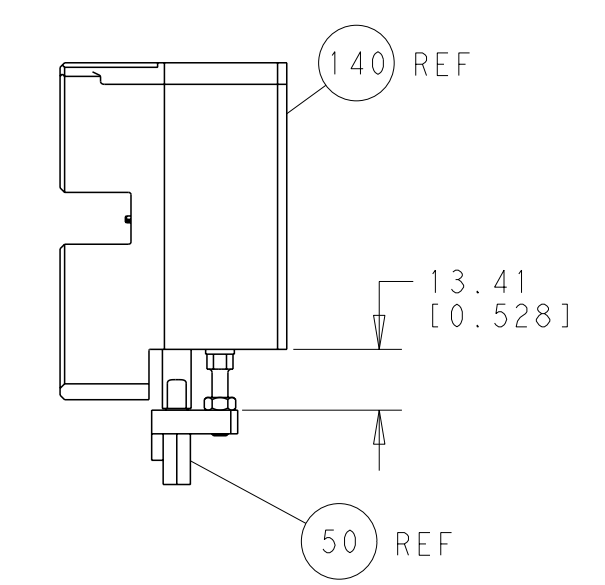
CAM POSITIONS



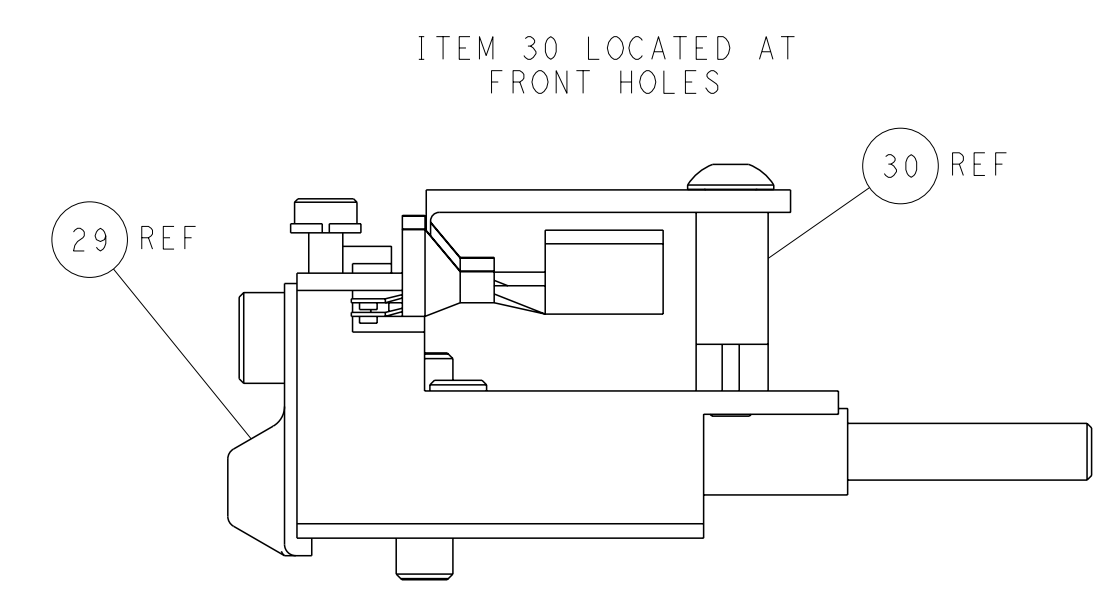
SHEAR DEPRESSOR DETAIL



TERMINAL SUPPORT LOCATION



HOLDDOWN SET-UP



FEED TRACK POSITION
GUIDE BY INSULATION BARREL

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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