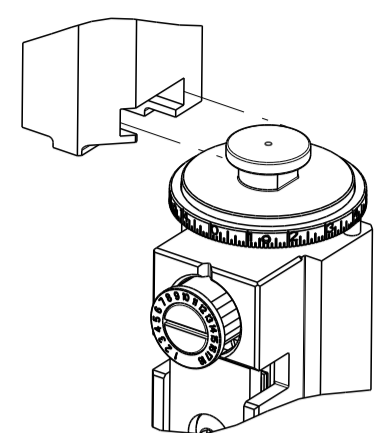


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151234-2	G	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
5-2151234-2	G	SEAL STRIPPER CRIMPER TERMINATING UNIT	PNEUMATIC
7-2151234-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.03 mm [.080]	F
INSUL	6.35 mm [.250]	O

APPLICATOR INSTRUCTIONS 408-35042

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: STANDARD POWER TIMER CONTACT TYPE A			
WIRE STRIP LENGTH		TERMINAL INSULATION DIAMETER RANGE	
4.40-5.00 mm [.173-.197 IN]		∅ 1.4-2.7mm	
TERMINAL APPLICATION SPECIFICATION	114-18037	-	-

TERMINALS APPLIED				
TE TERMINAL	TE TERMINAL	TE SEAL	TE SEAL	SEAL INSULATION DIAMETER RANGE
969040-1			963243-1	∅1.4-2.1mm

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: STANDARD POWER TIMER CONTACT TYPE A			
WIRE STRIP LENGTH		TERMINAL INSULATION DIAMETER RANGE	
3.90-4.50 mm [.153-.177 IN]		∅ 1.4-2.7mm	
TERMINAL APPLICATION SPECIFICATION	114-18388	-	-

TERMINALS APPLIED				
TE TERMINAL	TE TERMINAL	TE SEAL	TE SEAL	SEAL INSULATION DIAMETER RANGE
1241412-1	1241412-3		963243-1	∅1.4-2.1mm

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.00mm2	1.52+/-0.05 [1.060+/-0.002]	7.6
0.75mm2	1.43+/-0.05 [1.056+/-0.002]	8.5
0.50mm2	1.34+/-0.05 [1.053+/-0.002]	9.6

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.00mm2	1.54+/-0.05 [1.061+/-0.002]	7.6
0.75mm2	1.47+/-0.05 [1.058+/-0.002]	8.5
0.50mm2	1.43+/-0.05 [1.056+/-0.002]	9.6

- RECOMMENDED SPARE PARTS
 - REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION & STORAGE OF APPLICATOR.
 - APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 180. 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.
 - 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.
 - TERMINAL LUBRICANT IS RECOMMENDED.
8. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.

***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
		F		ECR-19-005517	05APR2019	LG	TE
		F1		ECR-20-014998	21OCT2020	JWC	GB
		G		ECR-22-145388	07JUL2022	TB	JH
		G1		ECR-24-209583	23MAY2024	ZZ	GB

-	1	-	1803515-3	RAM ASSEMBLY, SF ATLANTIC	293
-	1	-	2-1803583-1	APPLICATOR BASIC ASSEMBLY, SF	292
-	1	1	2119641-1	FEED CAM, AIR FEED	248
-	1	1	2119082-8	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
-	1	1	2844940-1	AIR FEED MODULE	238
-	1	-	4-1722335-3	STRIPPER, SIDE FEED	182
-	1	-	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	181
-	1	-	2-1752354-2	STANDOFF, HOLD-DOWN	180
-	1	-	993111-1	PIN, SLOTTED SPRING 3.0 X 20.0	177
-	1	-	5-22280-0	SPRING, COMPRESSION	176
-	1	-	1752353-3	GUIDE PIN, HOLDDOWN	175
-	1	-	1901680-2	GUIDE PIN, HOLDDOWN	174
-	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	1	1	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113
-	1	1	2844908-1	SCREW, LOCKING	99
-	1	1	2844907-1	POST, LOCKING	98
-	1	1	455888-5	SPACER, CRIMPER -	82
-	1	1	1803607-3	DOCUMENTATION PACKAGE	71
-	1	1	2119740-1	TAG, IDENTIFICATION	67
-	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	60
-	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	1	1	985575-3	SCR, FLT SKT HD CAP M3 X 10.0	57
-	1	1	1338685-1	PAWL, FEED	56
-	4	4	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	54
-	2	2	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	53
-	1	1	1803382-2	HOLD DOWN, SPRING LOADED	50
-	1	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	-	1	1803583-9	APPLICATOR BASIC ASSEMBLY, SF	46
-	-	1	1803515-1	RAM ASSEMBLY, SF ATLANTIC	44
-	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
-	1	1	1-1752356-1	SUPPORT, TERMINAL	34
-	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	3-2844962-2	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	2844992-2	ASSEMBLY, STRIP GUIDE -	29
-	1	1	455888-3	SPACER, CRIMPER -	28
-	1	1	1320928-6	STRIP GUIDE -	24
-	-	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
-	1	2	1-18028-2	WASHER, FLAT, REG M4	20
-	-	1	2119533-1	STRIPPER, SIDE FEED	19
-	1	1	2119806-1	INSERT, SHEAR	13
-	1	1	3-22280-3	SPRING, COMPRESSION	12
-	1	1	1-356885-4	STOP, SHEAR	11
-	1	1	2119805-1	SHEAR HOLDER, FRONT -	10
-	1	1	318707-1	FLOATING SHEAR, FRONT	9
1	1	1	4-1333204-2	ANVIL, COMBINATION	8
-	1	1	8-240641-6	SPACER	7
-	1	1	2119781-1	DEPRESSOR, SHEAR	5
-	1	1	238011-2	BLOCK, CRIMPER SPACER	4
1	1	1	1633996-6	CRIMPER, INSULATION SPECIAL	3
-	1	1	455888-9	SPACER, CRIMPER -	2
1	1	1	1-456405-6	CRIMPER, WIRE PREMIUM	1

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		MATERIAL:		FINISH:	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES ±	FINISH
MATERIAL		FINISH		WEIGHT		SCALE	
-		-		-		1:2	

ITEM NO	PART NO	DESCRIPTION	ITEM NO
-77	-52	-2	

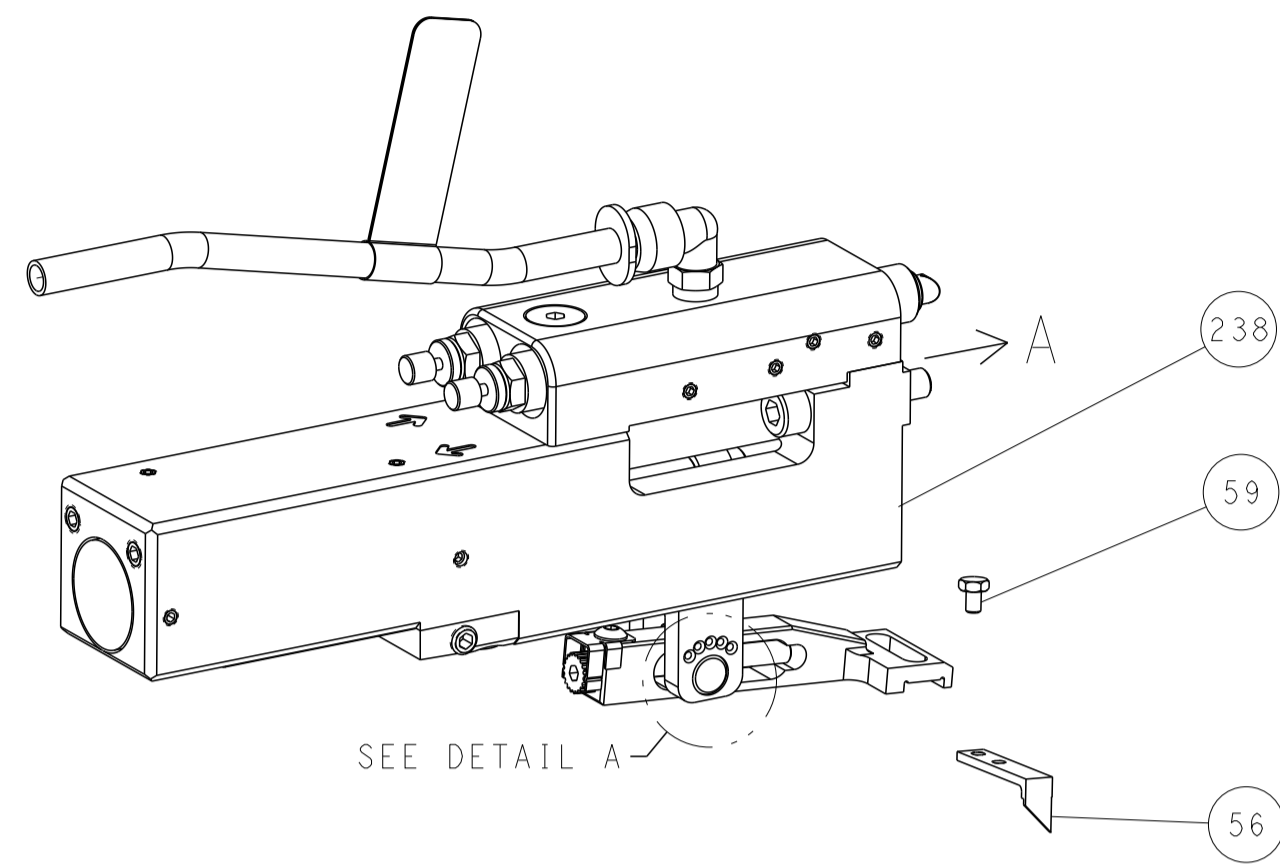
DATE	BY	APPROVED	NAME
22SEP2011	L. ZHANG		L. ZHANG
22SEP2011	L. ZHANG		L. ZHANG
22SEP2011	S. XI		S. XI

Customer Accessible Production Drawing

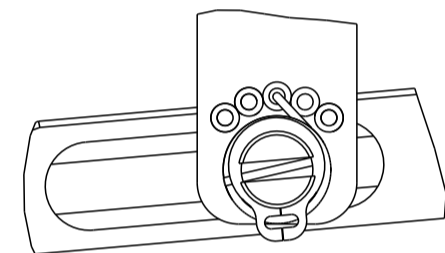
LOC	DIST	REVISIONS					
		P	LTN	DESCRIPTION	DATE	OWN	APVD
A	66	-	-	SEE SHEET 1	-	-	-

FEED TYPE

PNEUMATIC

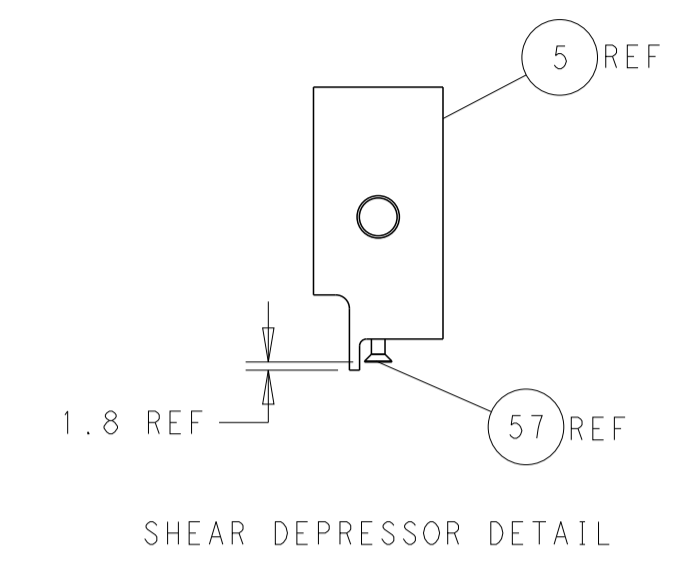
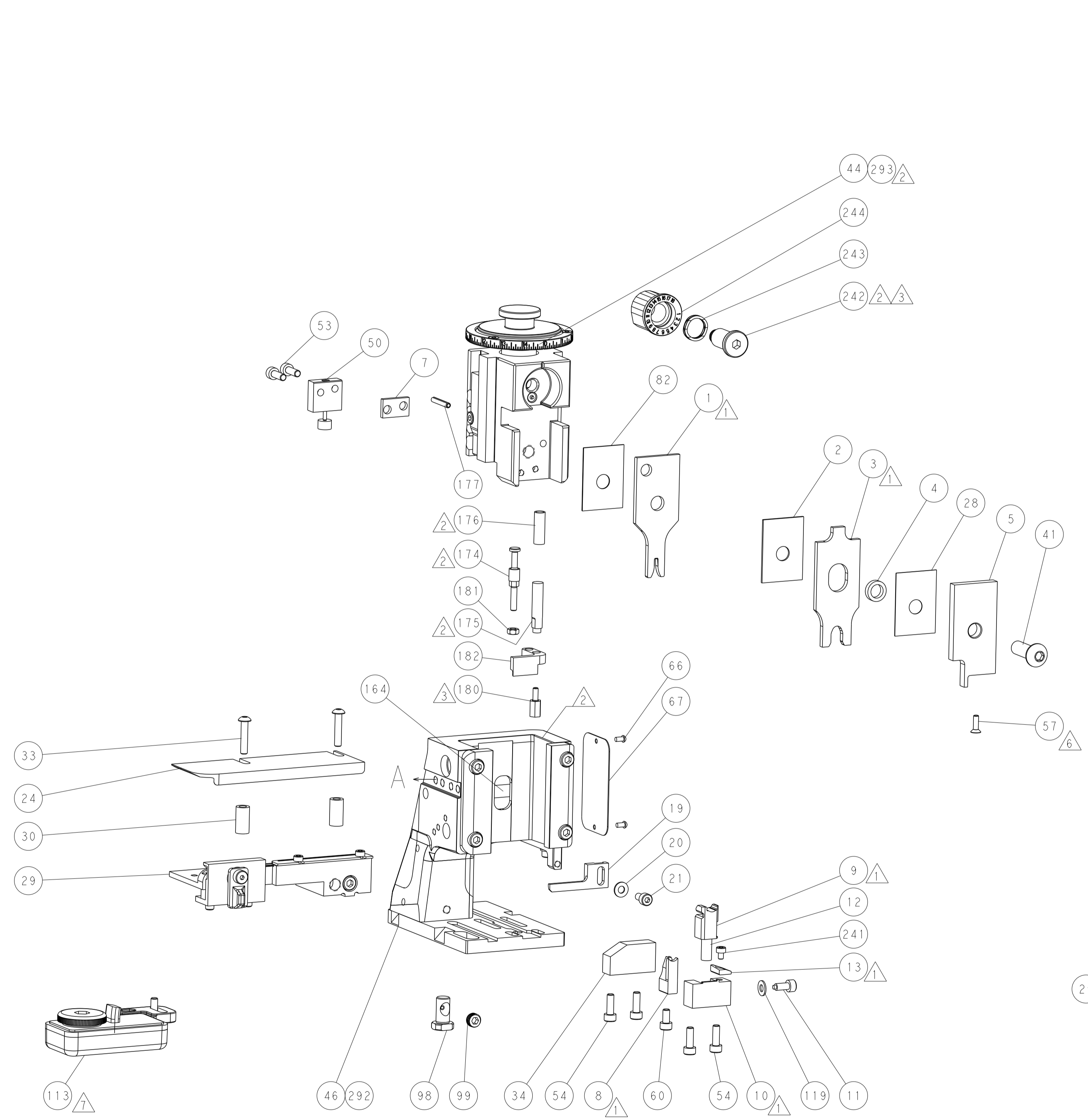
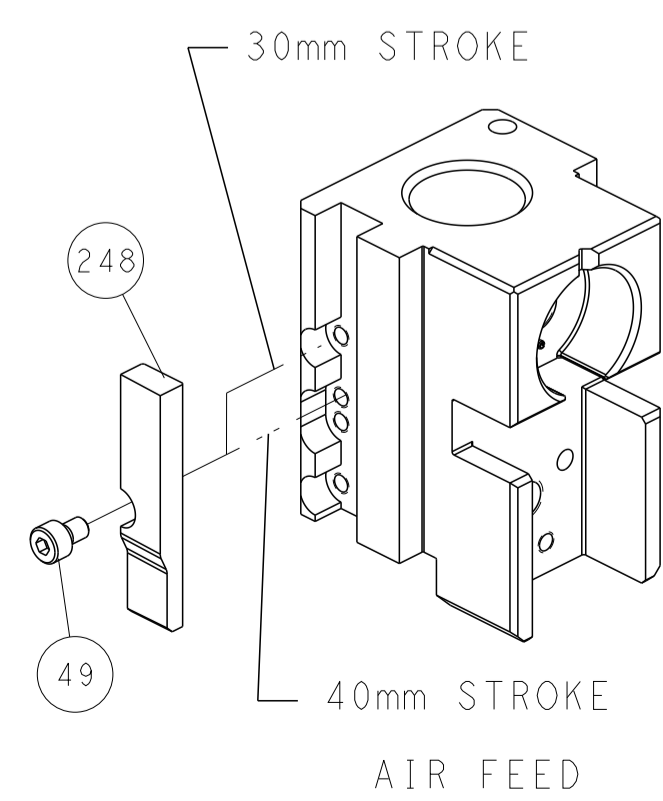


FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)

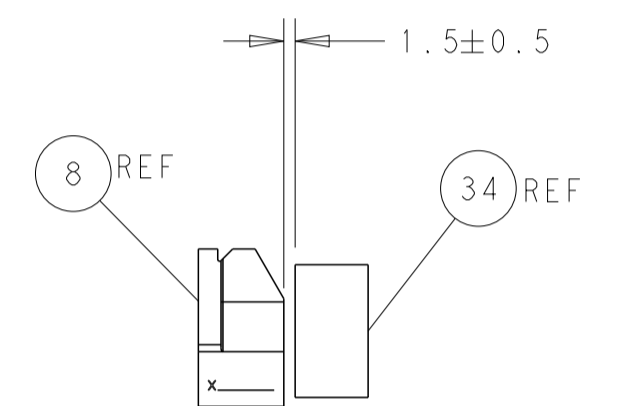


DETAIL A

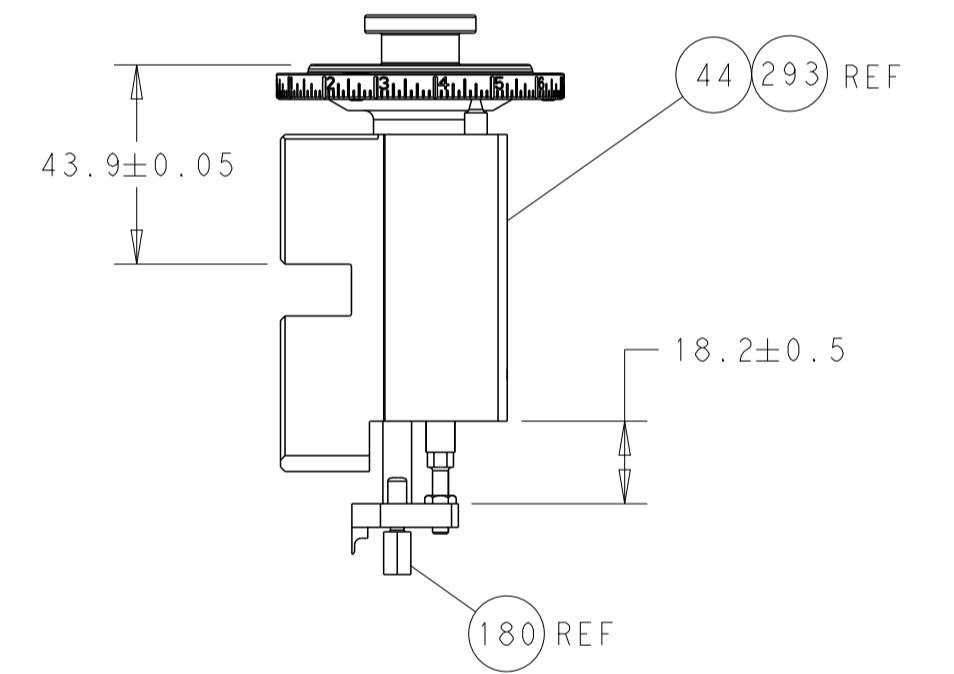
CAM POSITION



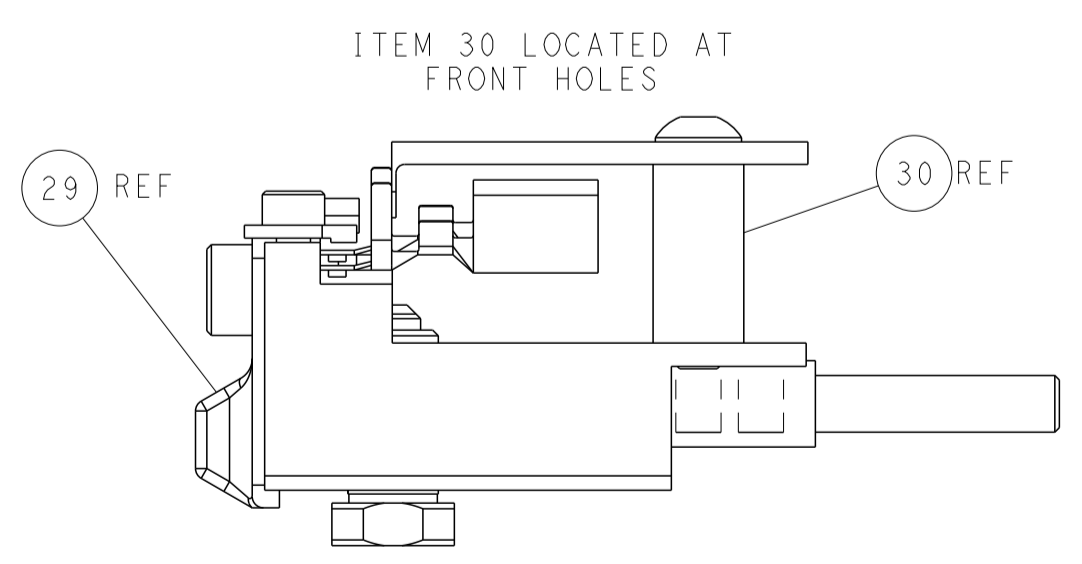
SHEAR DEPRESSOR DETAIL



TERMINAL SUPPORT LOCATION



RAM & HOLD DOWN SET-UP



FEED TRACK POSITION
GUIDE BY INSULATION BARREL

DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH		DWG L. ZHANG 22SEP2011 CHK L. ZHANG 22SEP2011 APVD S. XI 22SEP2011 NAME Ocean Side Feed Applicator SIZE CAGE CODE DRAWING NO RESTRICTED TO A1 00779 C=2151234 Customer Accessible Production Drawing SCALE 1:2 SHEET 2 OF 4 REV G1	
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