

SET UP GAUGE			LOC		DIST		REVISIONS					
2119599-1			A		66		P	LTN	DESCRIPTION	DATE	OWN	APVD
							A	RELEASED		120CT2017	TB	CT

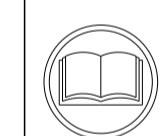
ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART								
					CONVERT TO	PART NUMBERS REQUIRED							
	2836939-1	A	FINE CRIMP HEIGHT ADJUST	MECHANICAL	PNEUMATIC FEED	2119950-1	1338683-8	5-18022-5	2119641-1	2119799-1	2063440-1		
					SERVO LATCH PLATE	2119951-1	-	8-2836939-5	1901094-3	2-1752354-3	2168400-6 (QUANTITY 2)		
					SMART APPLICATOR	2161326-1	-	8-2836939-4	-	-			
	2836939-2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	MECHANICAL FEED	2119949-1	1338683-8	5-18022-5	2119653-1	-			
					SERVO LATCH PLATE	2119951-1	-	8-2836939-5	1901094-3	2-1752354-3	2168400-6 (QUANTITY 2)		
					SMART APPLICATOR	2161326-1	-	8-2836939-4	-	-			
	2836939-5	A	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE	MECHANICAL FEED	2119949-1	1338683-8	5-18022-5	2119653-1	-			
					PNEUMATIC FEED	2119950-1	1338683-8	5-18022-5	2119641-1	2119799-1	2063440-1		
	2836939-6	A	NON-CRIMP HEIGHT ADJUST	SERVO LATCH PLATE	-	-	-	-	-	-			
					-	-	-	-	-	-			
	2836939-7	A	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-			
	7-2836939-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-			

APPLICATOR DATA		
CRIMP WIRE	SIZE	TYPE
INSUL	4.32 mm [.170]	F
APPLICATOR INSTRUCTIONS 408-10389		

TERMINAL DATA: HU LANE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: 110 SERIES TERMINAL FEMALE, SEALED			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
4.25-5.02 mm [.168-.198 IN]		ϕ	$\Delta 3$
TERMINAL APPLICATION SPECIFICATION	NONE	-	-

TERMINALS APPLIED				
TE TERMINAL	HU LANE TERMINAL	TE SEAL	HU LANE SEAL	CABLE DIAMETER
2318390-1	892006PSS	2113509-1	DJ90112	2.34mm-2.90mm

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
2.50mm2	1.78+/-0.05 [.070+/-0.002]	6.5
2.00mm2	1.63+/-0.05 [.064+/-0.002]	8.1



- $\Delta 1$ RECOMMENDED SPARE PARTS
- $\Delta 2$ GREASE BEARING SURFACES LIGHTLY
- 3. LUBRICATE DAILY PER THE APPLICATOR INSTRUCTION SHEET SUPPLIED WITH THE APPLICATOR.
- $\Delta 4$ APPLICATOR SPECIFIC DATA TO BE ENTERED INTO BLANK MEMORY CHIP AT ASSEMBLY. SEE BELOW FOR PART NUMBER:
 MECHANICAL FEED WITH "SMART APPLICATOR" CONVERSION: 8-2836939-4
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2836939-4
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2836939-5
 SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2836939-6
- 5. ADJUSTMENT OF THE STRIPPER MAY BE REQUIRED WHEN MOVING THE APPLICATOR BETWEEN BENCH AND LEADMAKER APPLICATIONS.
- $\Delta 6$ 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. FOR -6 ONLY APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 37.
- $\Delta 7$ GREASE THREADS, GROOVE AND O-RING ON ITEMS 35 & 252.
- $\Delta 8$ MAGNET, ITEM 166 MUST BE ORIENTED CORRECTLY IN ORDER TO PROPERLY ACTUATE THE COUNTER.
- $\Delta 9$ 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.
- $\Delta 10$ SPARE FEED CAM STORAGE LOCATION REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.
- $\Delta 11$ 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.
- $\Delta 12$ WHEN ASSEMBLING A NON CRIMP HEIGHT ADJUST APPLICATOR (-6) USE SHIMS FROM ITEM 260 TO ACHIEVE A NOMINAL SHIM HEIGHT OF 4.02.
- $\Delta 13$ THIS APPLICATOR APPLIES TERMINAL WITH A SEAL.
- $\Delta 14$ 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.

***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.

ITEM NO	DESCRIPTION	ITEM NO
$\Delta 12$	- - 1 - - - 2119957-2 APPLICATOR SHIM PACK	260
$\Delta 13$	- 1 - 1 1 1 8-21084-0 O-RING, .676 ID, .070 DIA. MAT.	252
	- - - - 1 - 2119640-1 PUSH ROD, AIR FEED	250
	- - - - 1 - 1803259-1 BUSHING, FLANGED	249
	- - - - 1 - 2119641-1 FEED CAM, AIR FEED	248

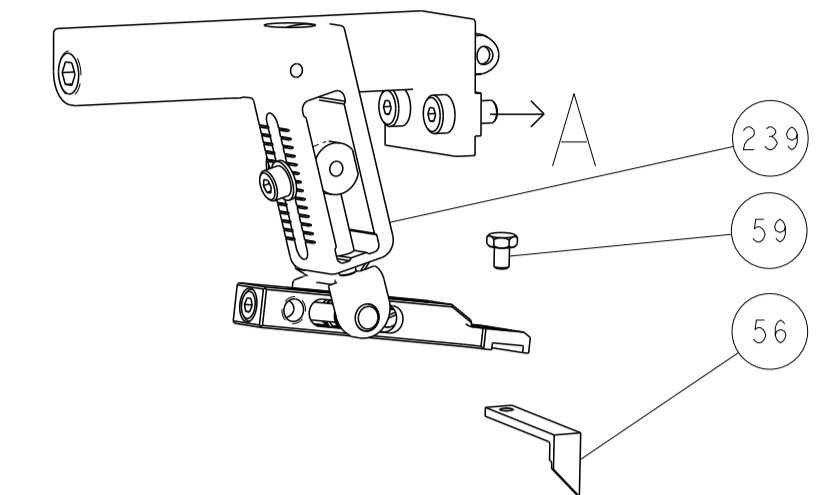
ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

- 1 - 1 1 1 1	2119798-1	DETENT PIN	247
- 1 - 1 1 1 1	1-22279-3	SPRING, COMPRESSION	246
- - 1 - - -	2119758-1	RAM, AMP STYLE, SIDE FEED, NON-ADJ.	245
- 1 1 1 1 1	2119082-2	CAM, SNAIL, INSULATION ADJUSTMENT	244
- 1 1 1 1 1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
$\Delta 6$ - 1 1 1 1 1	2119083-1	RETAINER, INSULATION DIAL	242
- 1 1 1 1 1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	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
$\Delta 6$ - 1 1 1 1 1	2-1752354-3	STANDOFF, HOLD-DOWN	180
- 1 1 1 1 1	993111-1	PIN, SLOTTED SPRING 3.0 X 20.0	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 -	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
- - REF REF - -	2119944-1	FEED FINGER ASSEMBLY, SF	117
- 1 1 1 1 1	455888-4	SPACER, CRIMPER	82
- 1 1 1 1 1	2119956-1	DOCUMENTATION PACKAGE	71
- 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	2119793-1	LIMITER, ADJUSTMENT BOLT	63
$\Delta 6$ - 3 - 3 3 3	992763-5	SCR, SET, SOC, CONE PNT, M3 X 4.0	62
- 1 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
$\Delta 4$ - 1 1 1 1 1	985575-3	SCR, FLT SKT HD CAP M3 X 10.0	57
- - - - 1 1	1338683-8	FEED PAWL	56
- 4 4 4 4 4	2168400-1	SHCS, LOW HEAD, RoHS, M4 X 12	54
- 1 1 1 1 1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52
- 1 1 1 1 1	1901681-9	HOLDDOWN, TERMINAL	51
- - - - 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 1	2119656-9	APPLICATOR BASIC ASSEMBLY, SF	46
- 1 - 1 1 1 1	2119370-1	RAM, AMP STYLE, SIDE FEED	44
- 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	2119644-2	RAM WASHER, PRECISION	38
$\Delta 6$ - 1 1 1 1 1	2119085-1	FA HEAD, ATLANTIC STYLE	37
$\Delta 7$ - 1 - 1 1 1 1	2119092-1	BOLT, ADJUSTMENT	35
- 1 1 1 1 1	1-1752356-3	SUPPORT, TERMINAL	34
- 2 2 2 2 2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
- 1 1 1 1 1	2161328-1	HEX HEAD, FLANGED, M5 X 8mm LONG	32
- 1 1 1 1 1	1320908-7	SPACER, STRIP GUIDE	30
- 1 1 1 1 1	2119959-2	ASSEMBLY, STRIP GUIDE	29
- 1 1 1 1 1	455888-3	SPACER, CRIMPER	28
- 1 1 1 1 1	1320928-2	STRIP GUIDE	24
- 1 1 1 1 1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
- 2 2 2 2 2	1-18028-2	WASHER, FLAT, REG M4	20
- 1 1 1 1 1	2119533-1	STRIPPER, SIDE FEED	19
$\Delta 11$ - 1 1 1 1 1	2119806-1	INSERT, SHEAR	13
- 1 1 1 1 1	3-22280-3	SPRING, COMPRESSION	12
- 1 1 1 1 1	1-356885-3	STOP, SHEAR	11
$\Delta 1$ - 1 1 1 1 1	2119805-1	SHEAR HOLDER, FRONT	10
$\Delta 1$ - 1 1 1 1 1	318707-1	FLOATING SHEAR, FRONT	9
$\Delta 1$ 1 1 1 1 1	6-1803318-2	ANVIL, COMBINATION	8
- - - - -	-	-	7
- - - - -	-	-	6
- 1 1 1 1 1	2119781-2	DEPRESSOR, SHEAR	5
- 1 1 1 1 1	2-238011-6	BLOCK, CRIMPER SPACER	4
$\Delta 1$ 1 1 1 1 1	1803365-9	CRIMPER, INSULATION O	3
- 1 1 1 1 1	455888-3	SPACER, CRIMPER	2
$\Delta 1$ 1 1 1 1 1	1803504-6	CRIMPER, WIRE	1
-77 -7 -6 -5 -2 -1	PART NO	DESCRIPTION	ITEM NO

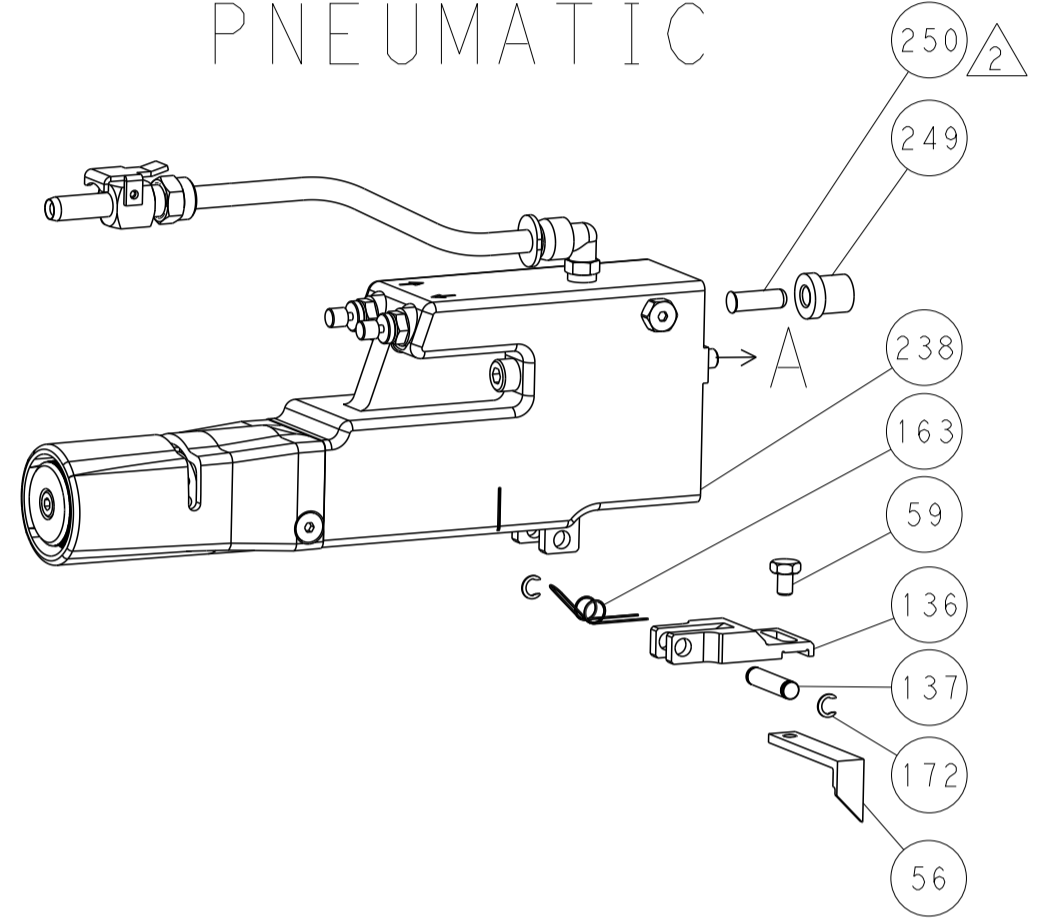
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		OWN T. BROOKENS 21SEP2017	NAME Ocean Side Feed Applicator
mm	0 PLC ±	1 PLC ±	2 PLC ±	CHK M. HERR 21SEP2017	
	3 PLC ±	4 PLC ±	ANGLES ±	APVD T. ELBIN 21SEP2017	SIZE CAGE CODE DRAWING NO RESTRICTED TO
MATERIAL	FINISH	WEIGHT		Customer Accessible Production Drawing	SCALE 1:2 SHEET 1 OF 4 REV A

LOC	DIST	REV	DATE	BY	APPV
A	66				

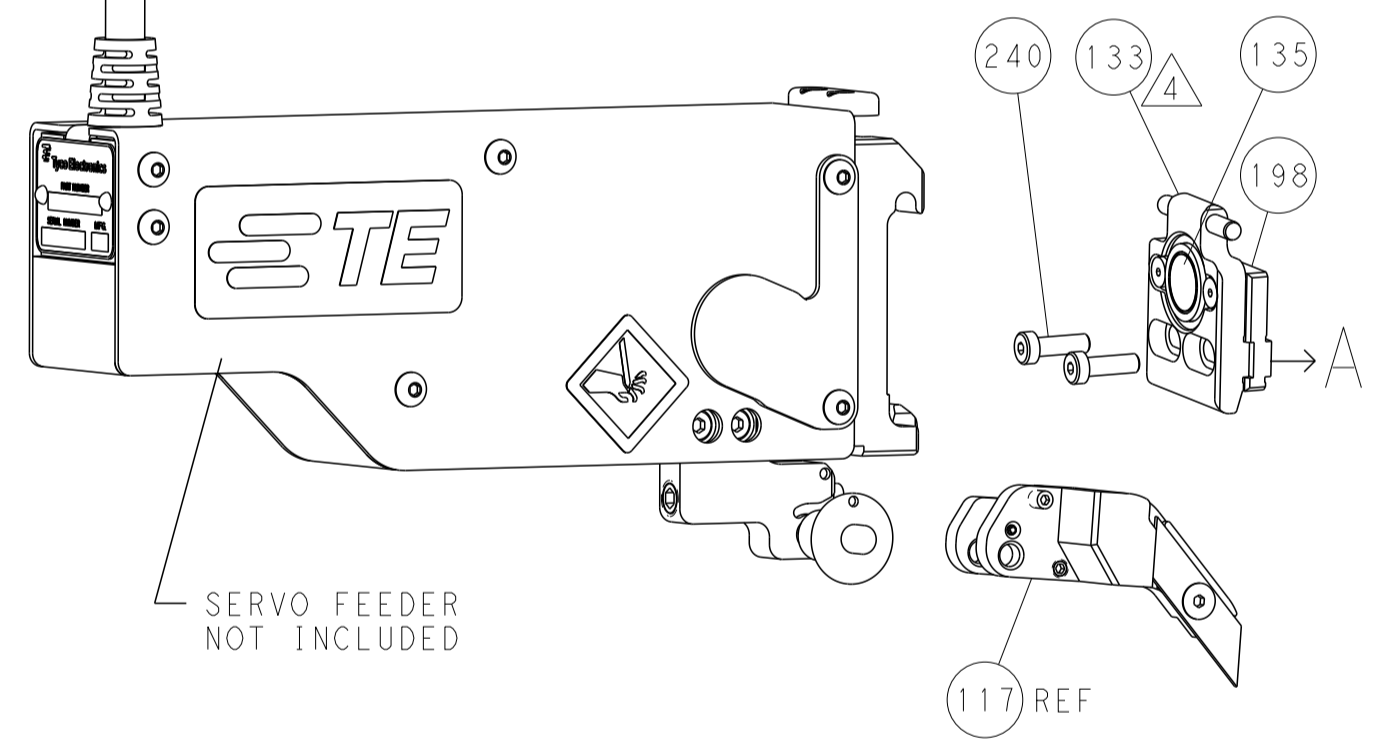
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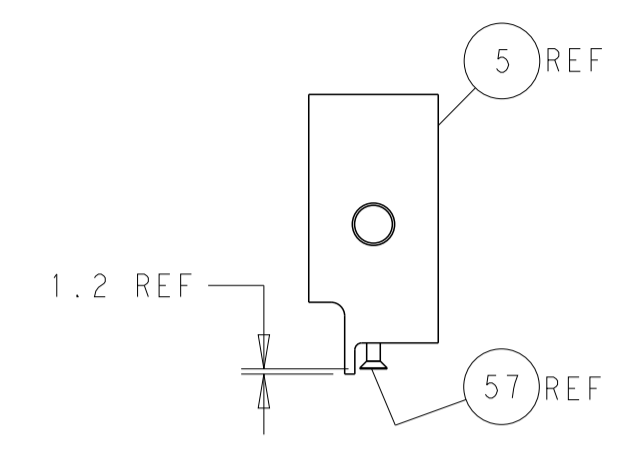
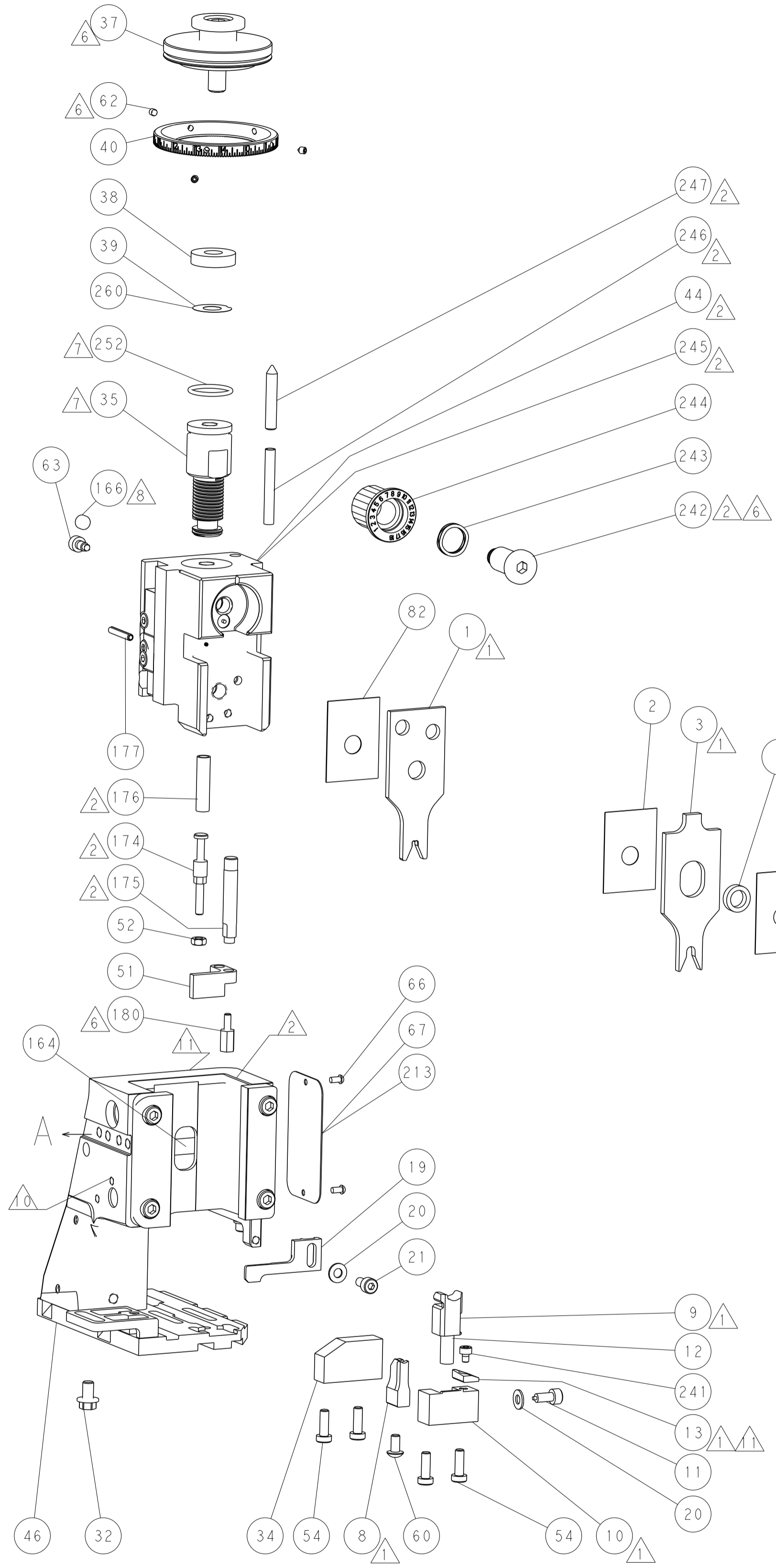
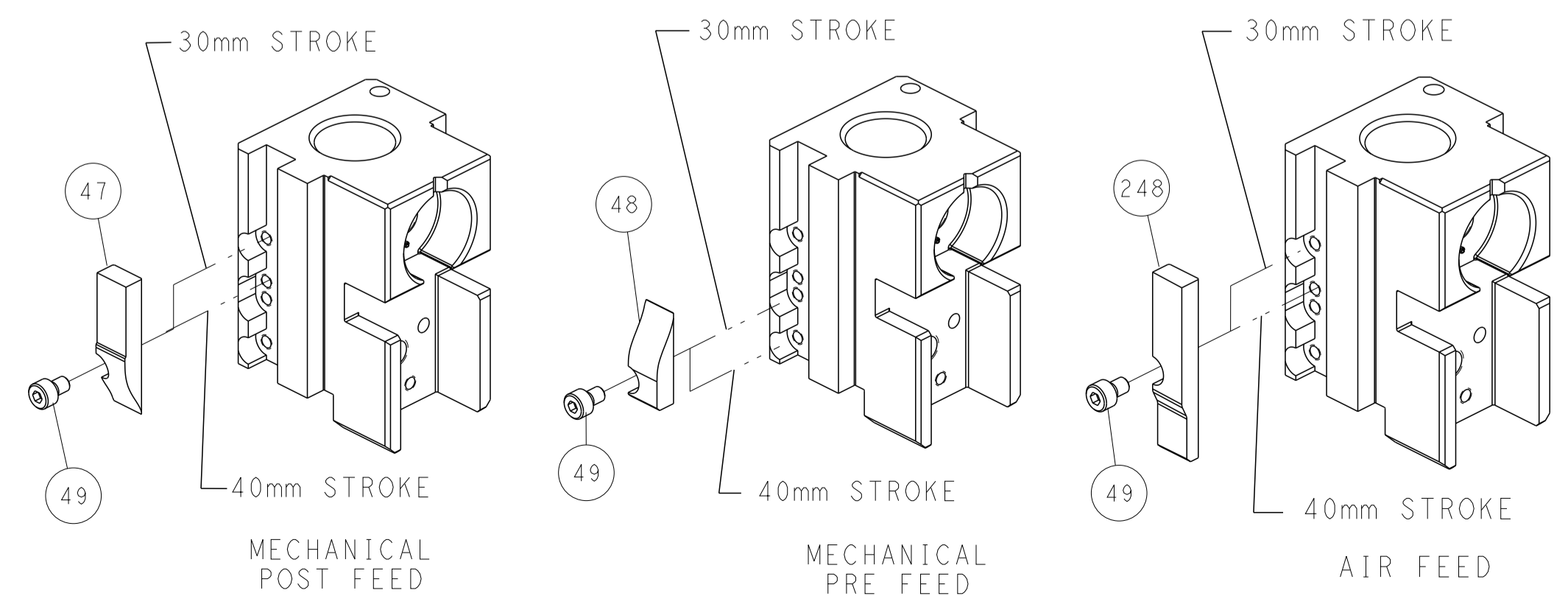
PNEUMATIC



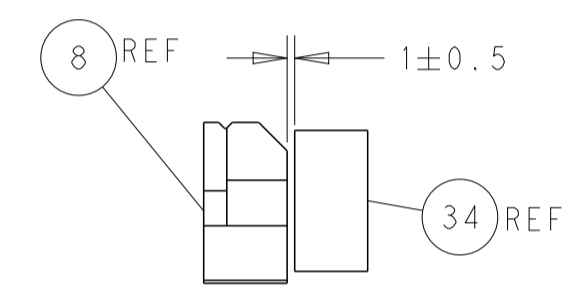
SERVO LATCH PLATE



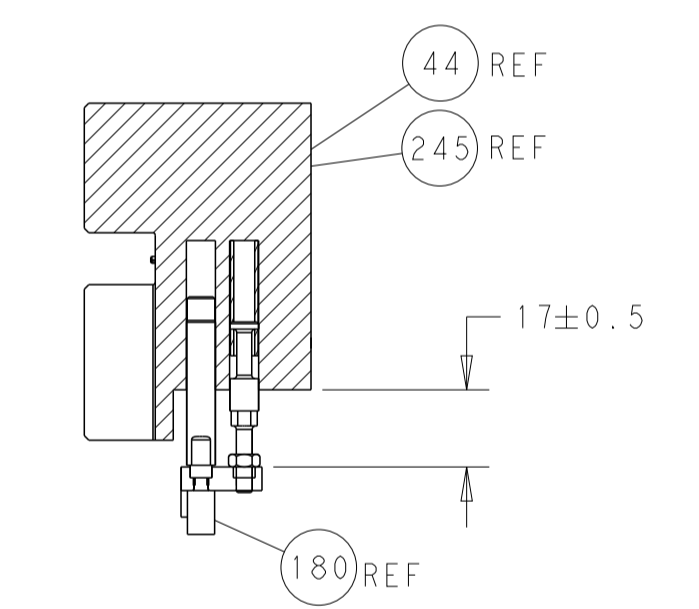
CAM POSITIONS



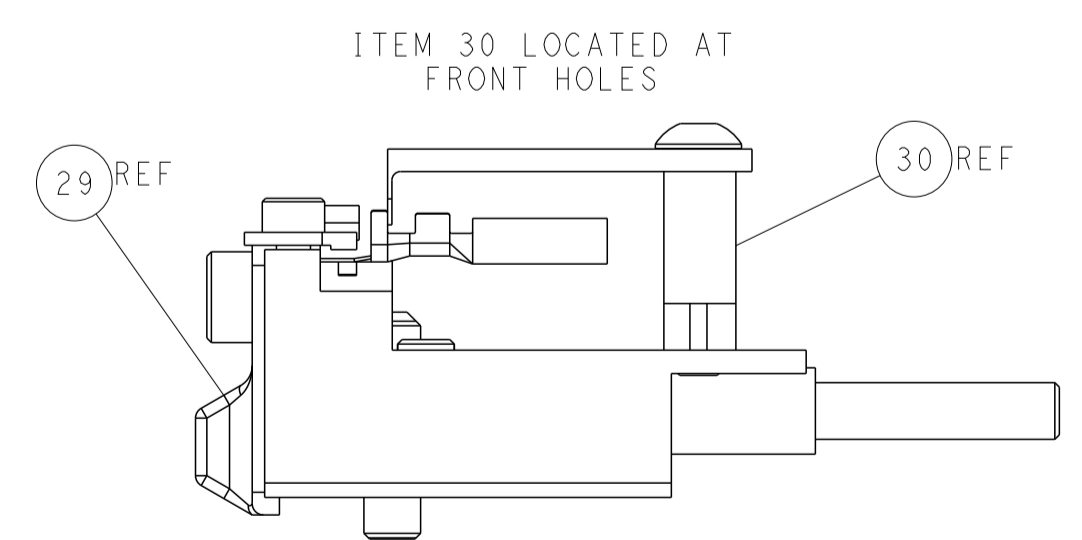
SHEAR DEPRESSOR DETAIL



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)

DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±. 1 PLC ±. 2 PLC ±. 3 PLC ±. 4 PLC ±. ANGLES ° ±. FINISH		DWN T. BROOKS 21SEP2017 CHK M. HERR 21SEP2017 APVD T. ELBIN 21SEP2017 NAME PRODUCT SPEC APPLICATION SPEC WEIGHT SCALE 1:2 SHEET 2 OF 4 REV A	
MATERIAL:		FINISH:		SIZE CAGE CODE DRAWING NO A1 00779 C=2836939 RESTRICTED TO	

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

Table titled 'APPLICATOR DATA' containing CRIMP SIZE TYPE, WIRE INSUL dimensions, and APPLICATOR INSTRUCTIONS.

Terminal data and specifications including WIRE STRIP LENGTH, INSULATION DIAMETER RANGE, and TERMINALS APPLIED table.

Table for CRIMP HEIGHT mm [INCH] and CRIMP HEIGHT REFERENCE SETTING (mm).



- RECOMMENDED SPARE PARTS
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...

*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: -77 -27 -25 -22 -21 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)

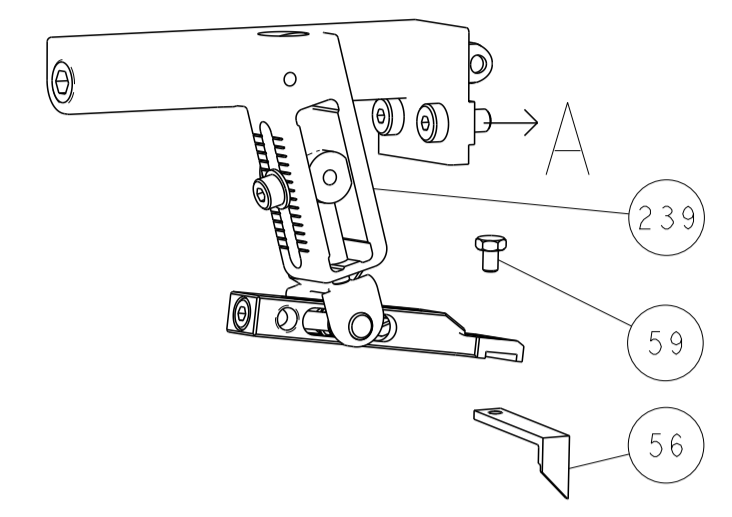
REVISIONS table with columns: P, LTR, DESCRIPTION, DATE, DWN, APVD.

Main parts list table with columns: Item No, Description, Quantity, Part No.

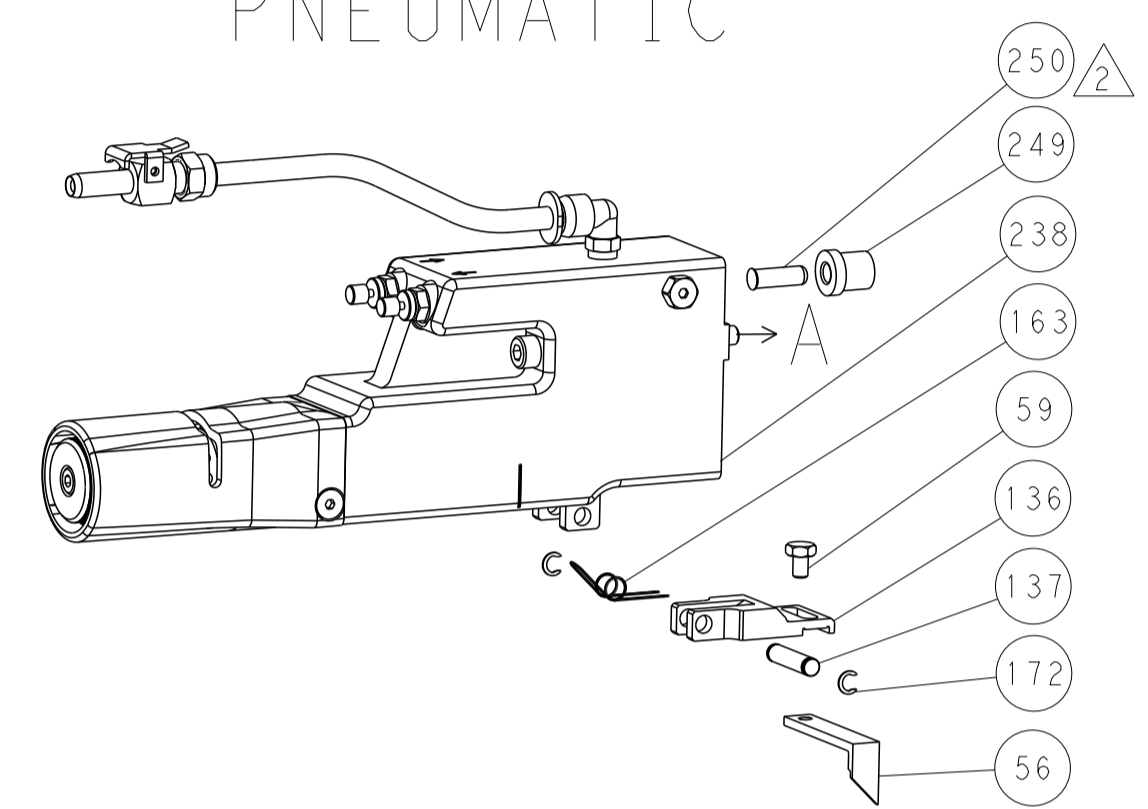
Technical drawing header form including dimensions, tolerances, and material specifications.

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

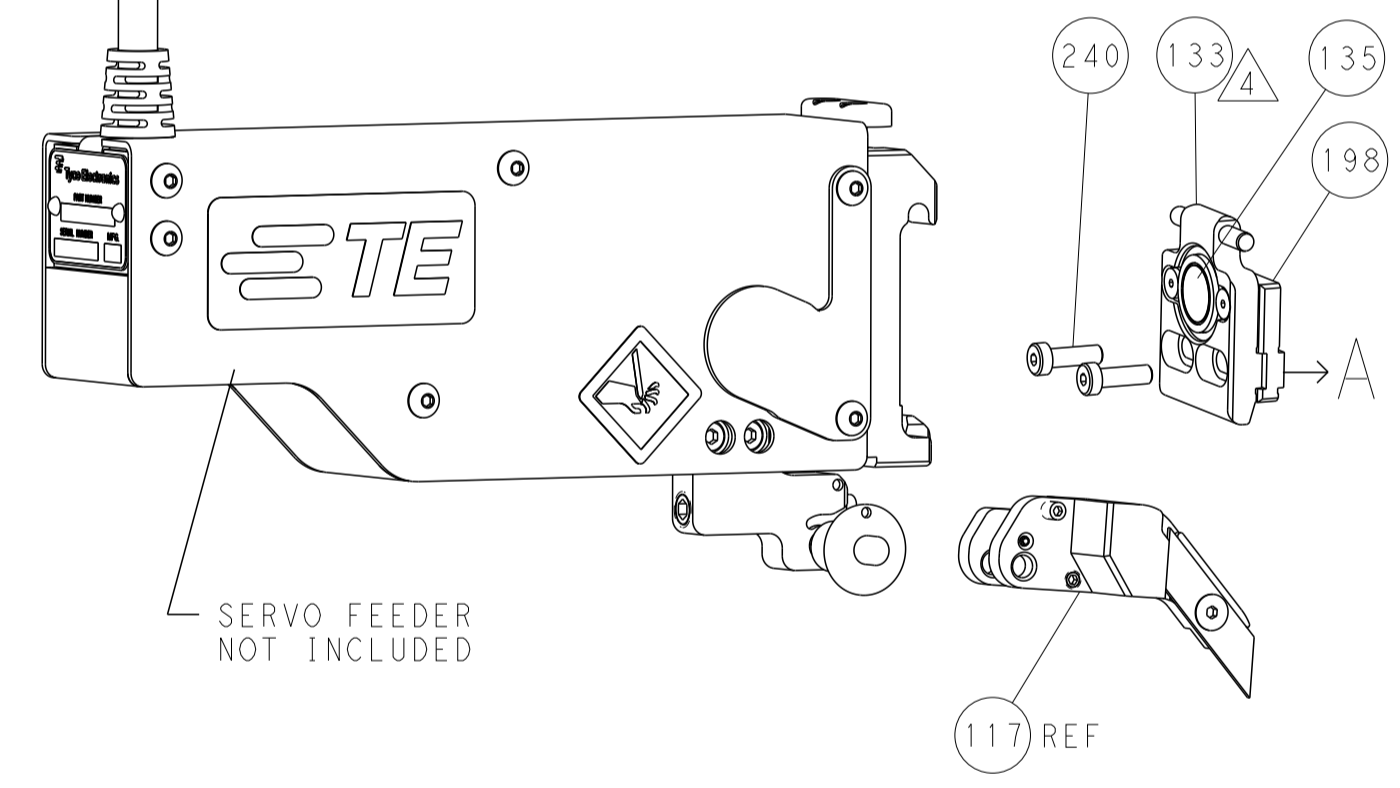
FEED TYPE MECHANICAL



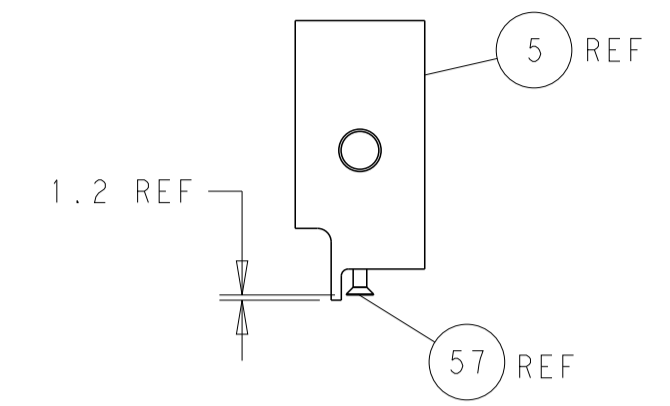
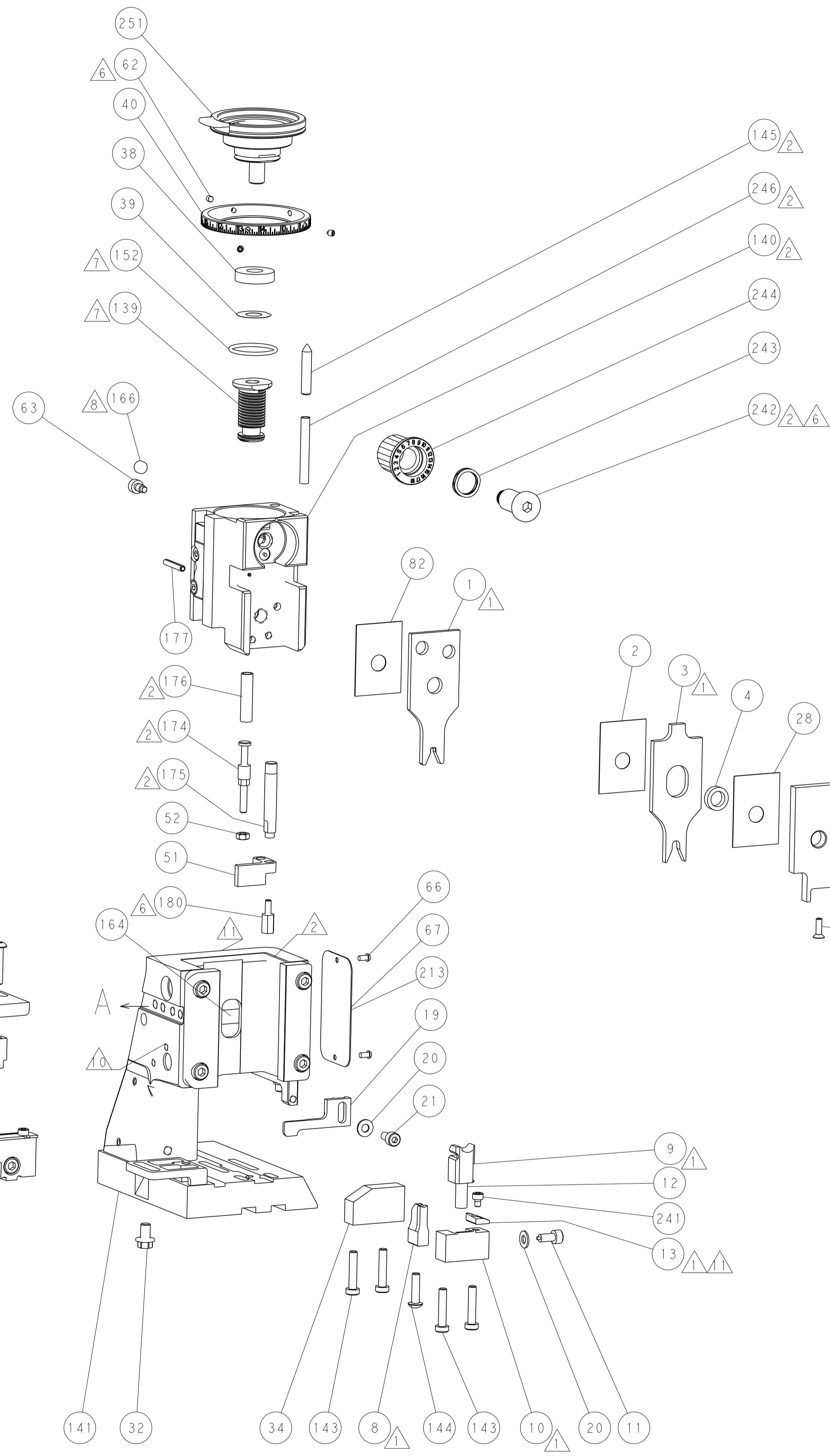
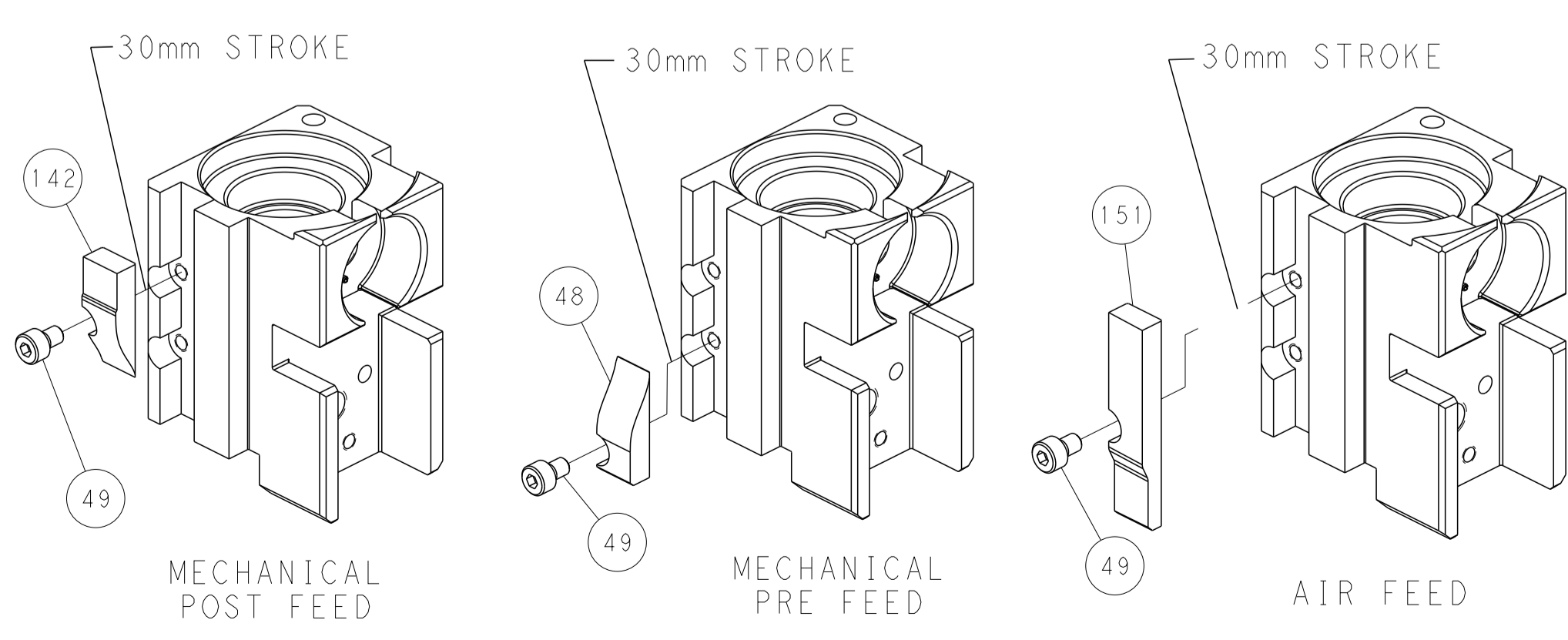
PNEUMATIC



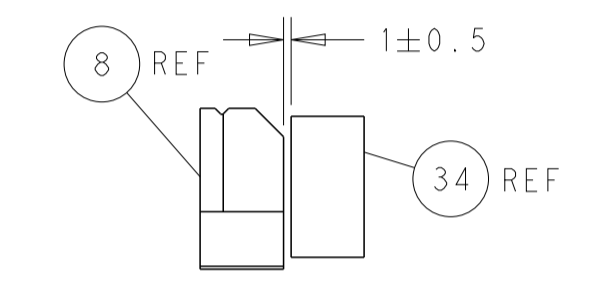
SERVO LATCH PLATE



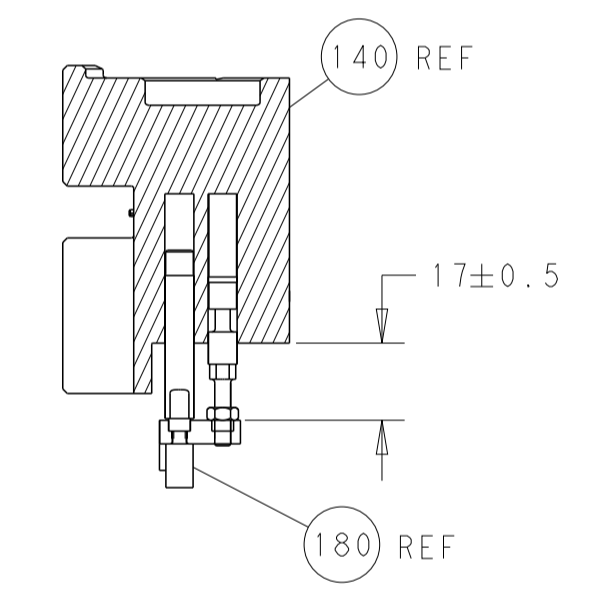
CAM POSITIONS



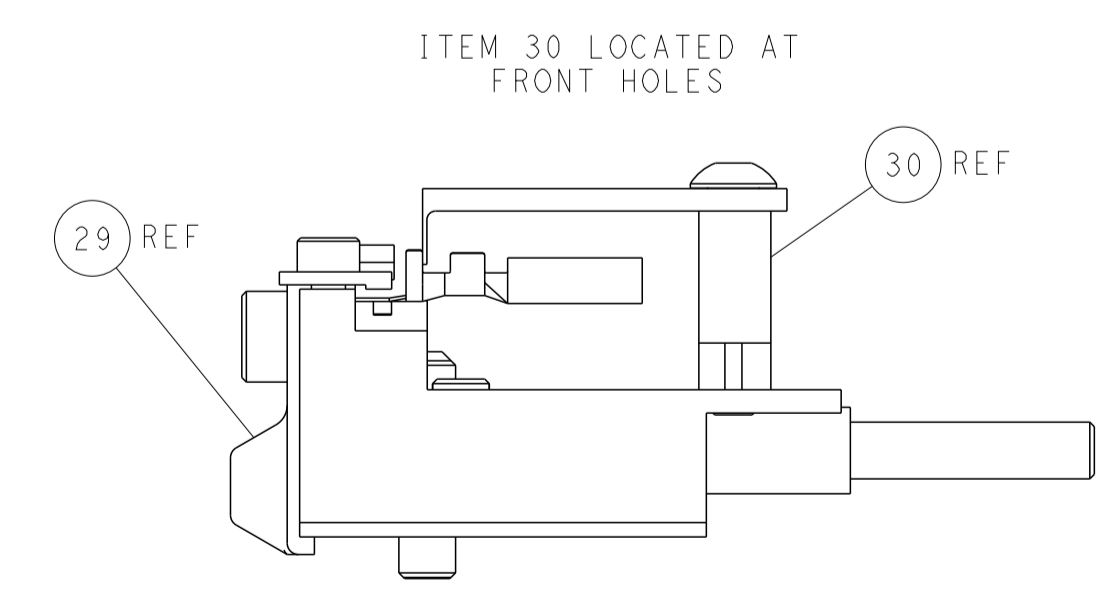
SHEAR DEPRESSOR DETAIL



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)

DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH		DWN T. BROOKS 21SEP2017 CHK M. HERR 21SEP2017 APVD T. ELBIN 21SEP2017 PRODUCT SPEC APPLICATION SPEC WEIGHT SCALE 1:2		NAME Ocean Side Feed Applicator SIZE CAGE CODE DRAWING NO A1 00779 C=2836939 SHEET 4 OF 4 REV A	
MATERIAL FINISH				RESTRICTED TO Customer Accessible Production Drawing		SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION	