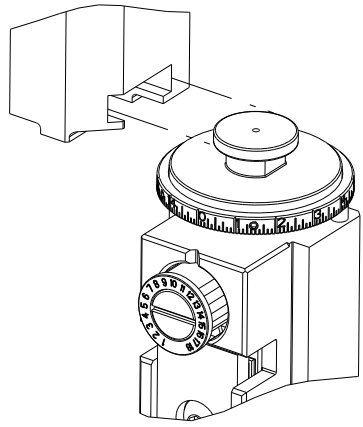


8	7
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RELEASED FOR PUBLICATION 20	
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PART NUMBER	REVISION
2150214-2	D
7-2150214-2	D
7-2150214-7	A
DESCRIPTION	
FINE CRIMP HEIGHT ADJUST	
PNEUMATIC AND CRIMP TOOLING KIT	
CRIMP TOOLING KIT	
FEED TYPE	
PNEUMATIC	
PNEUMATIC	
-	

ATLANTIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.78 mm [.070]	F
INSUL	2.79 mm [.110]	F
APPLICATOR INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: RECEPTACLE M.I.C. IV			
WIRE STRIP LENGTH 4.58-4.59 mm [.180-.181 IN]		INSULATION DIAMETER RANGE Ø1.30-2.00 mm [.051-.079 IN]	
TERMINAL APPLICATION SPECIFICATION		(A)114-15036 - -	
		(B)114-15003 - -	
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
(A) 144180-1	(B) 142183-2	(B) 142183-5	(B) 3-142183-1
(A) 142647-1	(B) 142183-3	(B) 1-142183-1	
(B) 142183-1	(B) 142183-4	(B) 2-142183-1	

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.00mm2	1.48+/-0.050 [.058+/- .002]	6.9
0.35+0.6	1.48+/-0.050 [.058+/- .002]	6.9
0.75mm2	1.41+/-0.050 [.056+/- .002]	7.5
0.35+0.35	1.36+/-0.050 [.054+/- .002]	8.1
0.60mm2	1.32+/-0.050 [.052+/- .002]	8.5
0.50mm2	1.27+/-0.050 [.050+/- .002]	9.1
0.35mm2	1.21+/-0.050 [.048+/- .002]	9.7



1. RECOMMENDED SPARE PARTS
2. REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
3. APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 50. APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242.
4. 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.
5. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
6. TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.

*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.

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

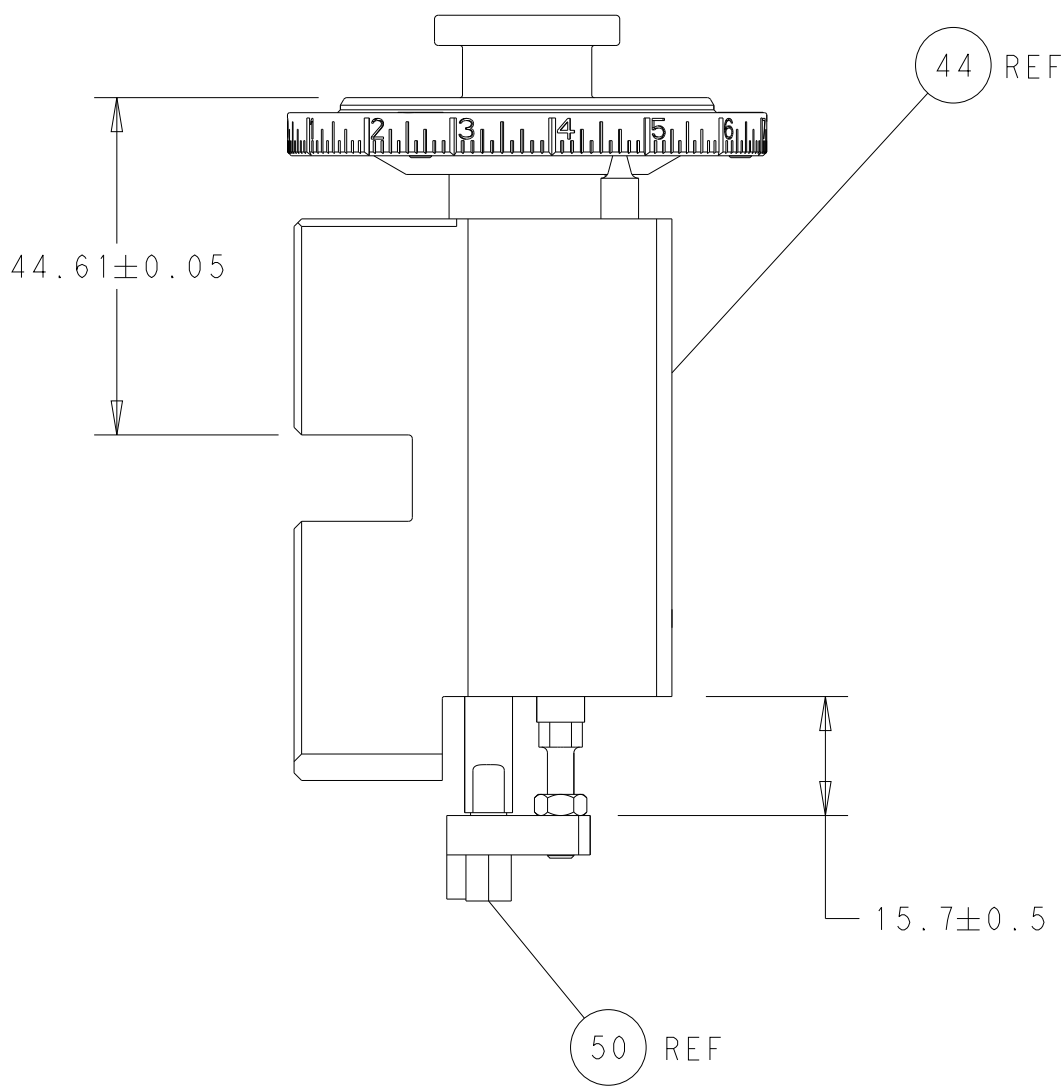
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		B		REVISED ECR-12-010723	13JUN2012	CC
		C		ECR-15-000050	05JAN2015	JH
		D		ECR-22-160252	05DEC2022	FZ

-	1	1	2119641-1	FEED CAM, AIR FEED	248
-	1	1	2119082-9	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	2844940-4	AIR FEED MODULE	238
-	1	1	1-18028-0	WASHER, FLAT, REG M8	192
-	1	1	6-9931111-6	PIN, SLOTTED SPRING 3.0 X 14.0	177
-	1	1	8-22280-7	SPRING, COMPRESSION	176
-	1	1	1752353-2	GUIDE PIN,HOLDDOWN	175
-	1	1	1901680-2	GUIDE PIN,HOLDDOWN	174
-	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	1	1	455888-5	SPACER, CRIMPER	82
-	1	1	1803607-4	DOCUMENTATION PACKAGE	71
-	2	2	2-18032-2	SCR, SET, FLT PNT, M3 X 10.0	70
-	1	1	2119740-1	TAG,IDENTIFICATION	67
-	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	1	1	1901681-1	HOLDDOWN, TERMINAL	65
-	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
-	4	4	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57
-	2	2	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	56
-	2	2	5018030-1	NUT, HEX, REG, RoHS, M3	54
-	2	2	986965-8	NUT, LOCK, HEX, TORQUE (M4)	53
-	1	1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52
-	1	1	2063961-9	FEED FINGER	51
-	1	1	1752354-9	STANDOFF,HOLD-DOWN	50
-	1	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	1	1	2119655-5	APPLICATOR BASIC ASSEMBLY, EF	46
-	1	1	1803517-1	RAM ASSEMBLY, EF ATLANTIC	44
-	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
-	8	8	1-18028-2	WASHER, FLAT, REG M4	33
-	2	2	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	31
-	2	2	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	29
-	1	1	240639-1	STRIPPER (MACHINING)	27
-	2	2	1-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 30	25
-	1	1	2-1752371-0	PLATE, STRIP GUIDE	24
-	2	2	2-22281-3	SPRING, COMPRESSION	22
-	1	1	1803292-1	DRAG	20
-	2	2	1901259-4	GUIDE, LOWER STRIP	18
-	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17
-	1	1	1752360-1	SPACER,HOLD-DOWN	13
-	1	1	240644-1	PLATE, REAR SHEAR	11
-	1	1	690482-5	PLATE, FRONT SHEAR	9
-	1	2	1338686-1	ANVIL, COMBINATION	8
-	1	1	690474-5	BLADE, SLUG	7
-	1	1	5-240641-5	SPACER	5
-	1	1	238011-4	BLOCK, CRIMPER SPACER	4
-	1	2	4-2119582-5	CRIMPER, INSULATION F PREMIUM	3
-	1	1	455888-5	SPACER, CRIMPER	2
-	1	2	456418-2	CRIMPER, WIRE, .070 "F"	1
-	77	72	-2	PART NO	ITEM NO

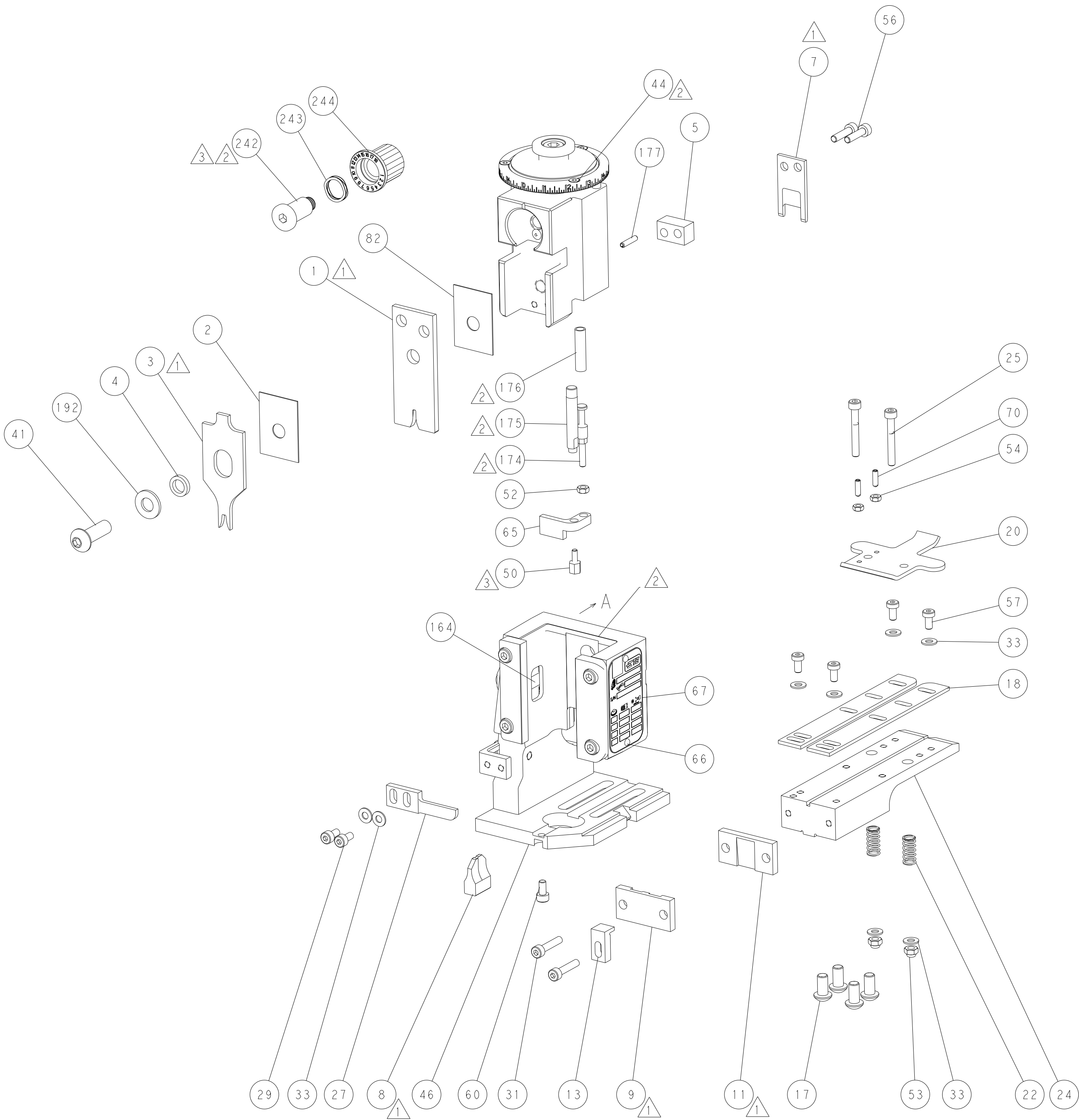
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DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		NAME Ocean End Feed Applicator	
0 PLC 1 PLC 2 PLC 3 PLC 4 PLC ANGLES FINISH		± ± ± ± ± ± ±		PRODUCT SPEC APPLICATION SPEC	
MATERIAL -		WEIGHT -		SIZE A1	
		Customer Accessible Production Drawing		SCALE 1:1	
		SHEET 1		REV D	

SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

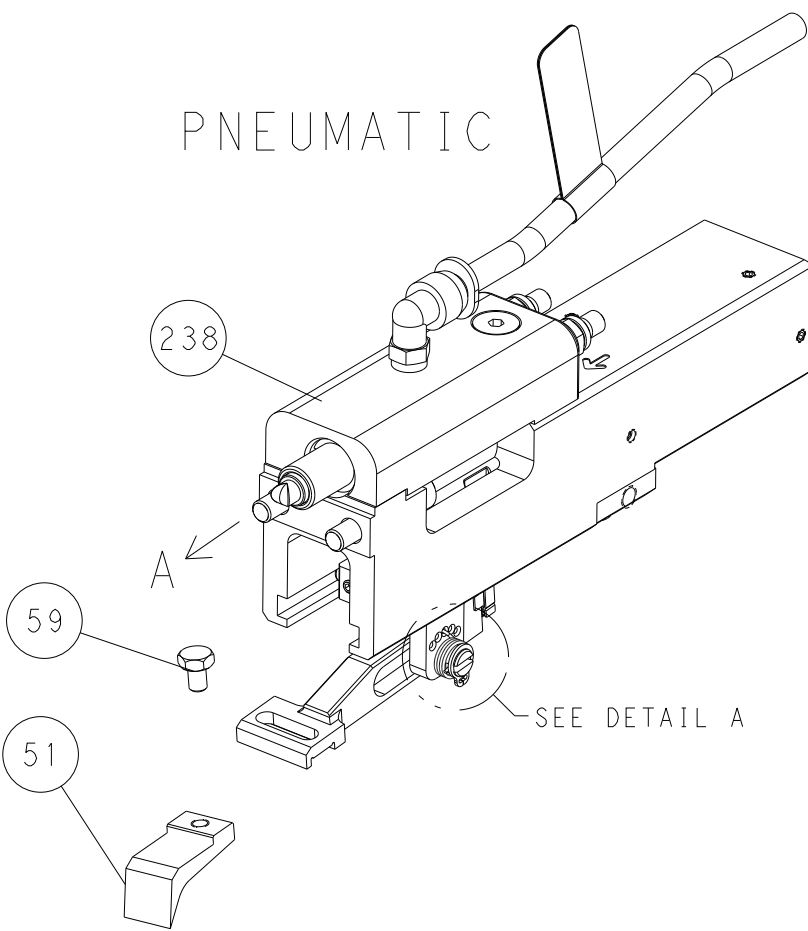
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		P	LTR	DESCRIPTION	DATE	DWN
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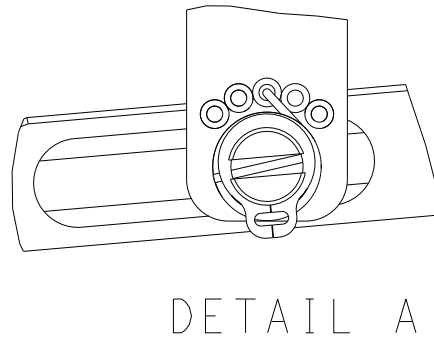
RAM AND HOLDDOWN SET-UP



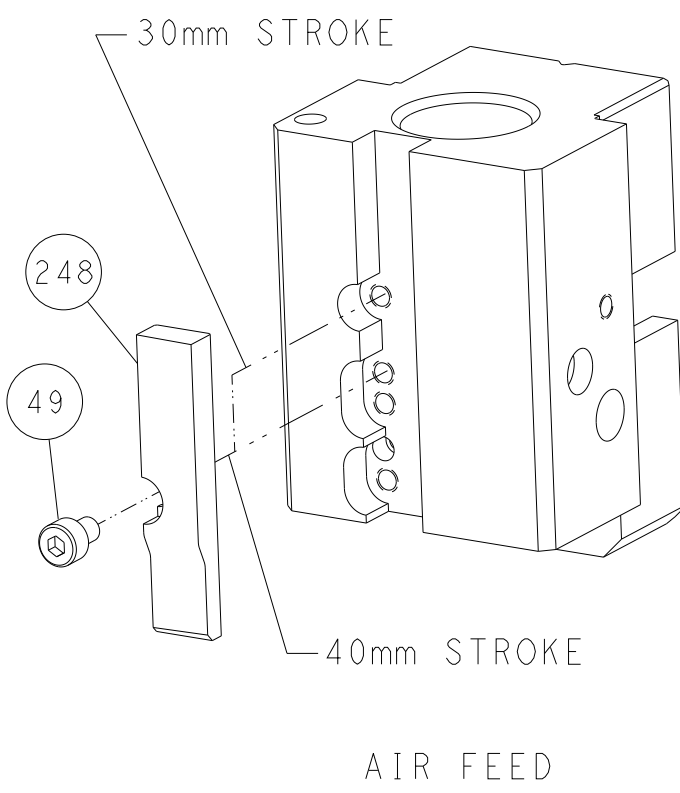
FEED TYPE



FEED SPRING SETTING POSITION



CAM POSITION

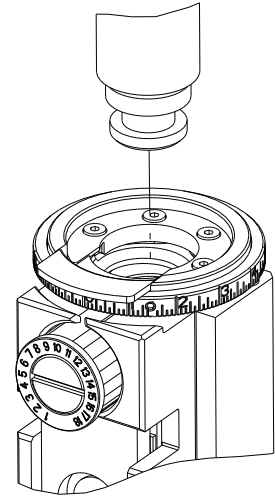


ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

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CHK G. BAILEY 23MAR2012				NAME	Ocean End Feed Applicator	
APVD S. XI 23MAR2012				PRODUCT SPEC	-	
				APPLICATION SPEC	-	
				WEIGHT	-	
				SCALE	1:1	
				SHEET	2 of 4	
				REV	D	

8	7	6	5	4	3	2	1
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE				
2-2150214-2	D	FINE CRIMP HEIGHT ADJUST	PNEUMATIC				
7-2150214-7	A	CRIMP TOOLING KIT	-				

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.78 mm [.070]	F
INSUL	2.79 mm [.110]	F
APPLICATOR INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: RECEPTACLE M.I.C. IV			
WIRE STRIP LENGTH 4.58-4.59 mm [.180-.181 IN]		INSULATION DIAMETER RANGE Ø1.30-2.00 mm [.051-.079 IN]	
TERMINAL APPLICATION SPECIFICATION	(A)114-15036	-	-
	(B)114-15003	-	-
TERMINALS APPLIED 			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
(A) 144180-1	(B) 142183-2	(B) 142183-5	(B) 3-142183-1
(A) 142647-1	(B) 142183-3	(B) 1-142183-1	
(B) 142183-1	(B) 142183-4	(B) 2-142183-1	

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.00mm2	1.48+/-0.050 [.058+/- .002]	6.9
0.35+0.6	1.48+/-0.050 [.058+/- .002]	6.9
0.75mm2	1.41+/-0.050 [.056+/- .002]	7.5
0.35+0.35	1.36+/-0.050 [.054+/- .002]	8.1
0.60mm2	1.32+/-0.050 [.052+/- .002]	8.5
0.50mm2	1.27+/-0.050 [.050+/- .002]	9.1
0.35mm2	1.21+/-0.050 [.048+/- .002]	9.7



- 1 RECOMMENDED SPARE PARTS
- 2 REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- 3 APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 50. APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242.
- 4 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.
5. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- 6 TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.

*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.

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

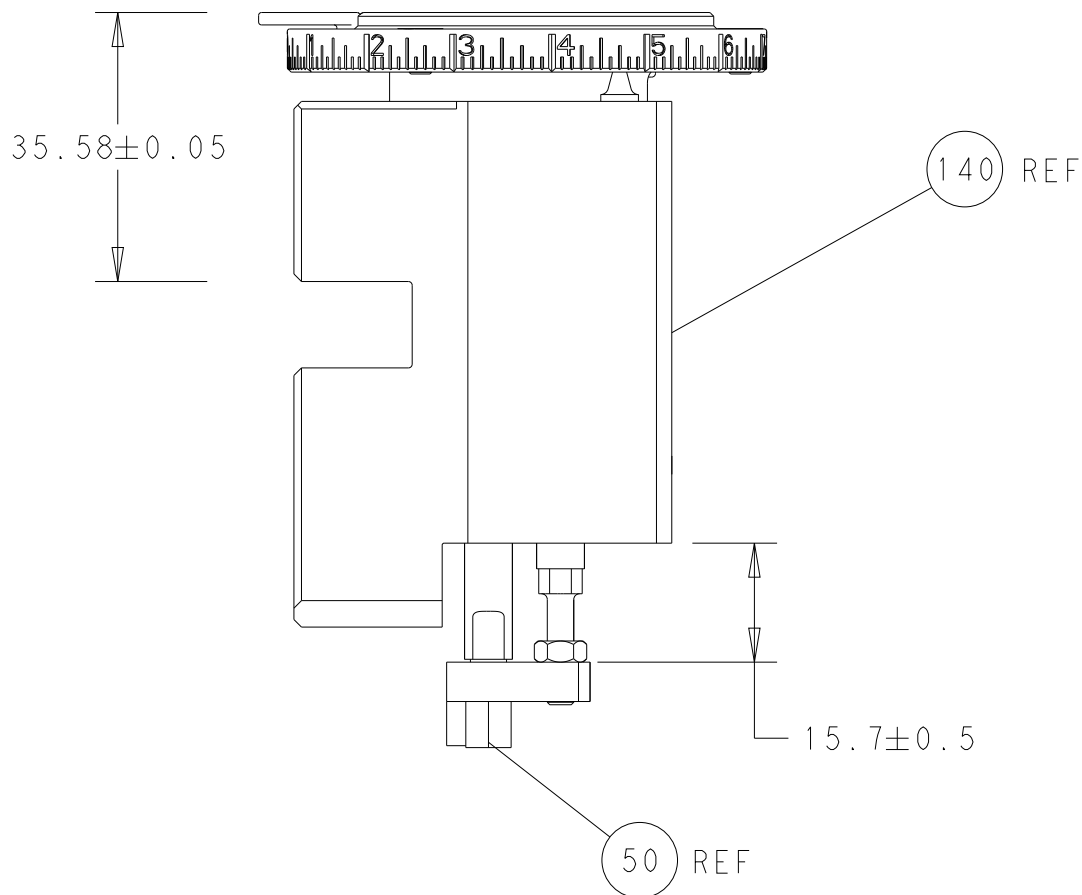
LOC	DIST	REVISIONS				
A	66	P	LTR	DESCRIPTION	DATE	OWN
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-	1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	2844940-4	AIR FEED MODULE	238
-	1	1-18028-0	WASHER, FLAT, REG M8	192
-	4	2079383-9	SCR, BHSC, RoHS (M6 X 20)	186
-	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	2119641-2	FEED CAM, AIR FEED	152
-	1	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	144
-	1	2119655-6	APPLICATOR BASIC ASSEMBLY, EF	141
-	1	1803518-1	RAM ASSEMBLY, EF PACIFIC	140
-	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
-	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	4	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57
-	2	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	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	1752354-9	STANDOFF,HOLD-DOWN	50
-	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
-	8	1-18028-2	WASHER, FLAT, REG M4	33
-	2	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	31
-	2	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	29
-	1	240639-1	STRIPPER (MACHINING)	27
-	2	1-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 30	25
-	1	2-1752371-0	PLATE, STRIP GUIDE	24
-	2	2-22281-3	SPRING, COMPRESSION	22
-	1	1803292-1	DRAG	20
-	2	1901259-4	GUIDE, LOWER STRIP	18
-	1	1752360-1	SPACER,HOLD-DOWN	13
-	1	240644-1	PLATE, REAR SHEAR	11
-	1	690482-5	PLATE, FRONT SHEAR	9
1	1	1338686-1	ANVIL, COMBINATION	8
-	1	690474-5	BLADE, SLUG	7
-	1	5-240641-5	SPACER	5
-	1	238011-4	BLOCK, CRIMPER SPACER	4
1	1	4-2119582-5	CRIMPER, INSULATION F PREMIUM	3
-	1	455888-5	SPACER, CRIMPER	2
1	1	456418-2	CRIMPER, WIRE, .070 "F"	1
-	77-22	PART NO	DESCRIPTION	ITEM NO

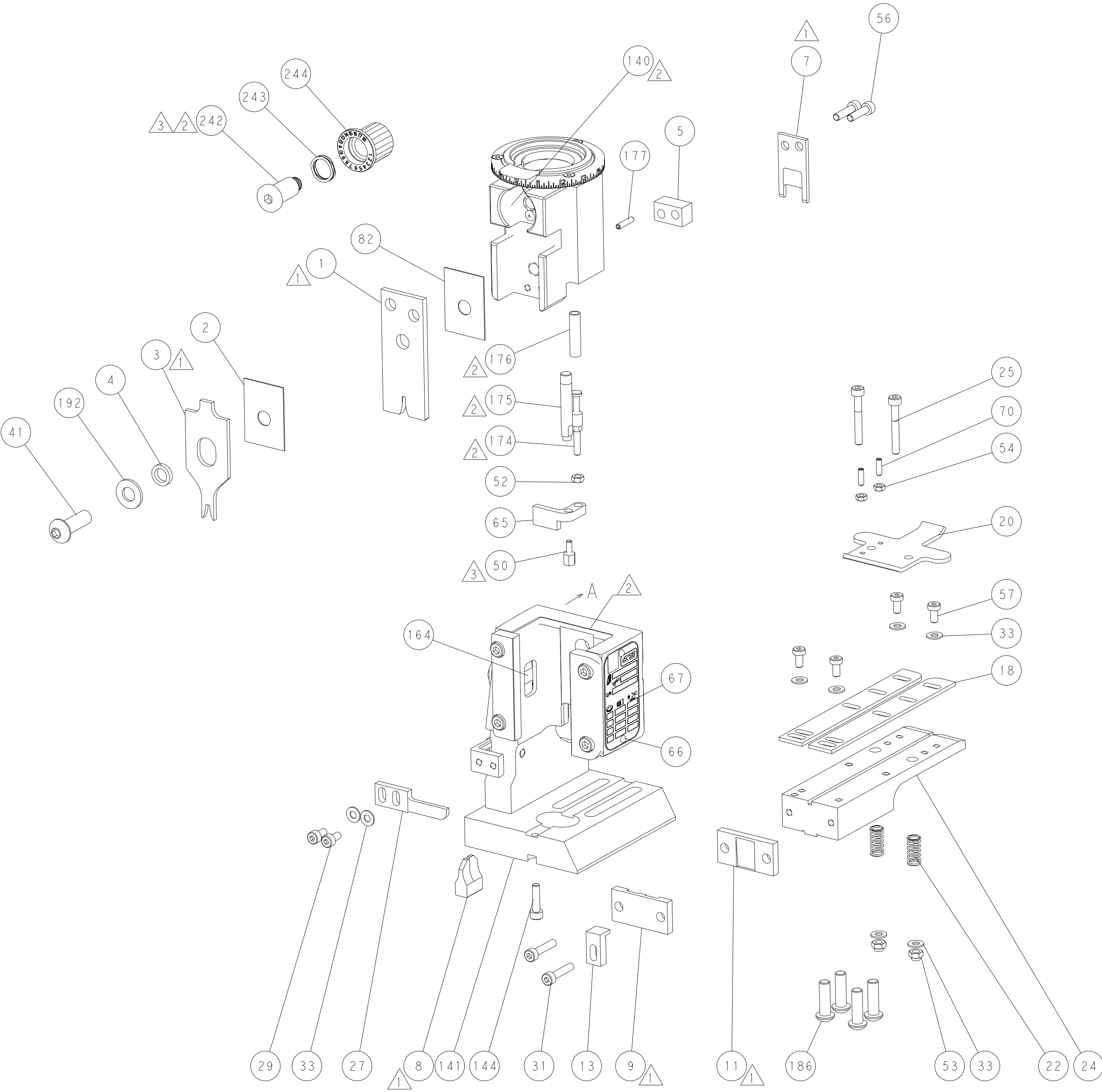
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CHK G.BAILEY 23MAR2012		NAME	Ocean End Feed Applicator	
DIMENSIONS: mm		APVD S. XI 23MAR2012	SIZE CAGE CODE DRAWING NO	
TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH		PRODUCT SPEC APPLICATION SPEC WEIGHT	RESTRICTED TO	
MATERIAL		00779	Customer Accessible Production Drawing	
		SCALE	1:1	
		SHEET	3 of 4	
		REV	D	

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

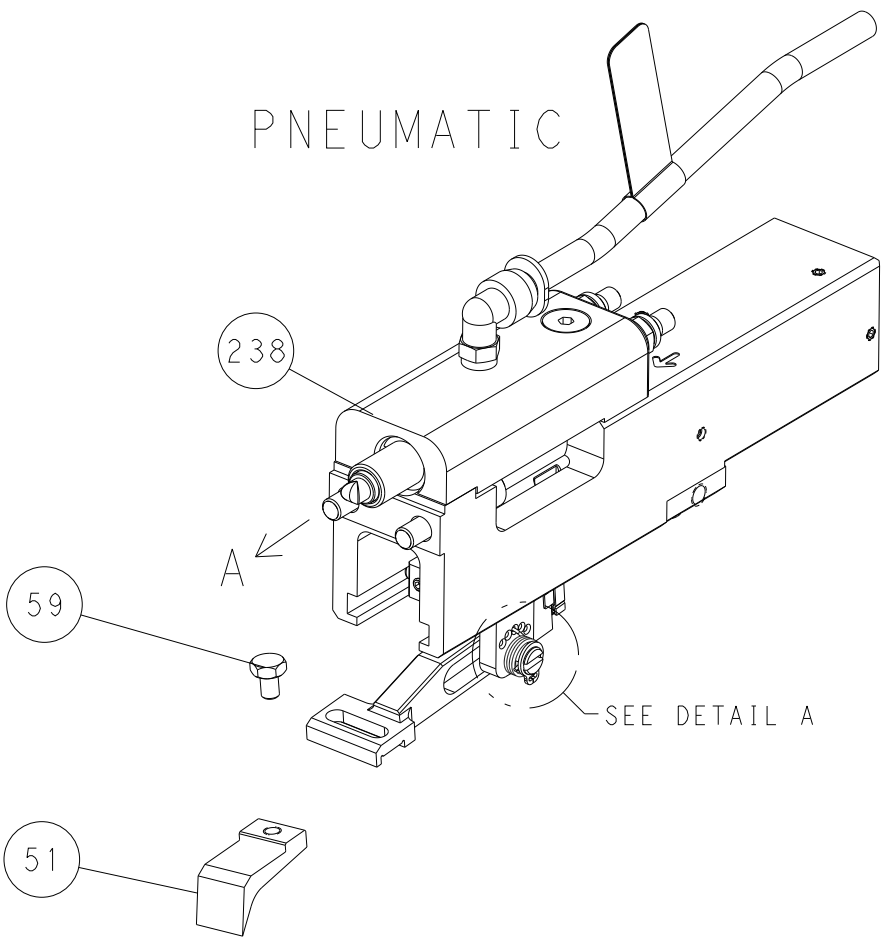
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A	66	P	LTR	DESCRIPTION		DATE	DWN	APVD
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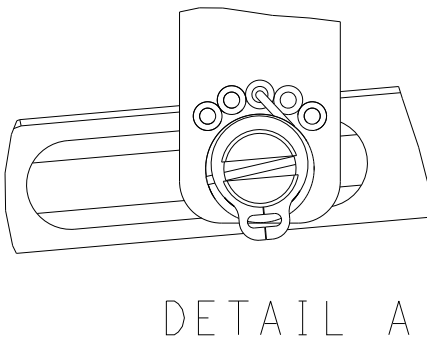
RAM AND HOLDDOWN SET-UP



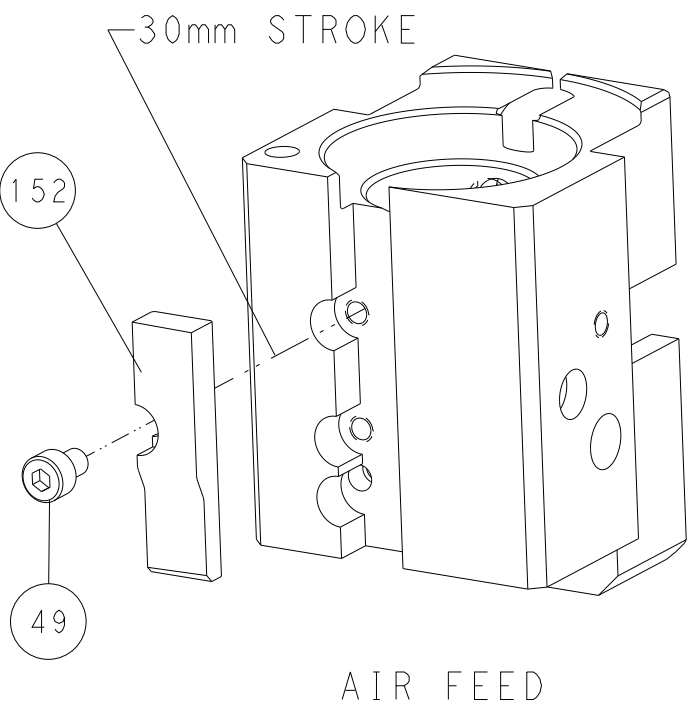
FEED TYPE



FEED SPRING SETTING POSITION



CAM POSITION



AIR FEED

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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										CHK		G. BAILEY		23MAR2012																									
										APVD		S. XI		23MAR2012		NAME																							
DIMENSIONS: mm										TOLERANCES, UNLESS OTHERWISE SPECIFIED: 0 PLC ±.1 1 PLC ±.1 2 PLC ±.1 3 PLC ±.1 4 PLC ±.1 ANGLES ±.1 FINISH										PRODUCT SPEC				Ocean End Feed Applicator -															
																				APPLICATION SPEC																			
										WEIGHT										SIZE		CAGE CODE		DRAWING NO		RESTRICTED TO													
																				A		00779		C=2150214															
MATERIAL										-										Customer Accessible Production Drawing				SCALE		1:1		SHEET		4		OF		4		REV		D	