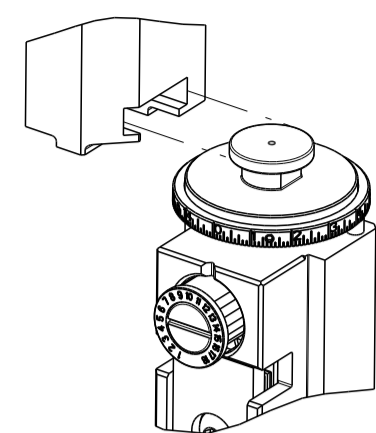


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150472-2	K	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150472-2	K	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150472-7	K	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



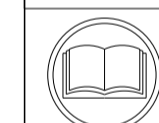
APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	6.35 mm [.250]	F
INSUL	9.53 mm [.375]	F
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION			
TERMINAL NAME: RING TONGUE			
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE		
5.18-5.94 mm [.204-.234 IN]	Ø5.59-8.00 mm [.220-.315 IN]		
TERMINAL APPLICATION SPECIFICATION	114-2084	-	-
TERMINALS APPLIED $\Delta$ 5 $\Delta$ 7			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
42899-1	42913-1	61352-1	
42899-2	42913-2	61352-2	
42899-3	42913-3		

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION			
TERMINAL NAME: RING TONGUE			
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE		
5.18-5.94 mm [.204-.234 IN]	Ø5.59-8.00 mm [.220-.315 IN]		
TERMINAL APPLICATION SPECIFICATION	114-2084	-	-
TERMINALS APPLIED $\Delta$ 5 $\Delta$ 7			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
41808	41808-1	41809	41809-1

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING $\Delta$ 4	RAM SET-UP DIM $\pm$ 0.05 $\Delta$ 6
6 AWG	4.85 +/- 0.05 [.191 +/- .002]	4.7	41.74
8 AWG	4.22 +/- 0.05 [.166 +/- .002]	11.7	41.74
10 AWG	3.81 +/- 0.05 [.150 +/- .002]	9.8	42.36

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING $\Delta$ 4	RAM SET-UP DIM $\pm$ 0.05 $\Delta$ 6
8 AWG	4.57 +/- 0.05 [.180 +/- .002]	5.7	41.74
10 AWG	4.24 +/- 0.05 [.167 +/- .002]	9.3	41.74



- $\Delta$ 1 RECOMMENDED SPARE PARTS
  - $\Delta$ 2 REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
  - $\Delta$ 3 APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242.
  - $\Delta$ 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.
  - $\Delta$ 5 TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
  - $\Delta$ 6 SEE CHART FOR RAM SET-UP DIMENSION.
  - $\Delta$ 7 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.

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

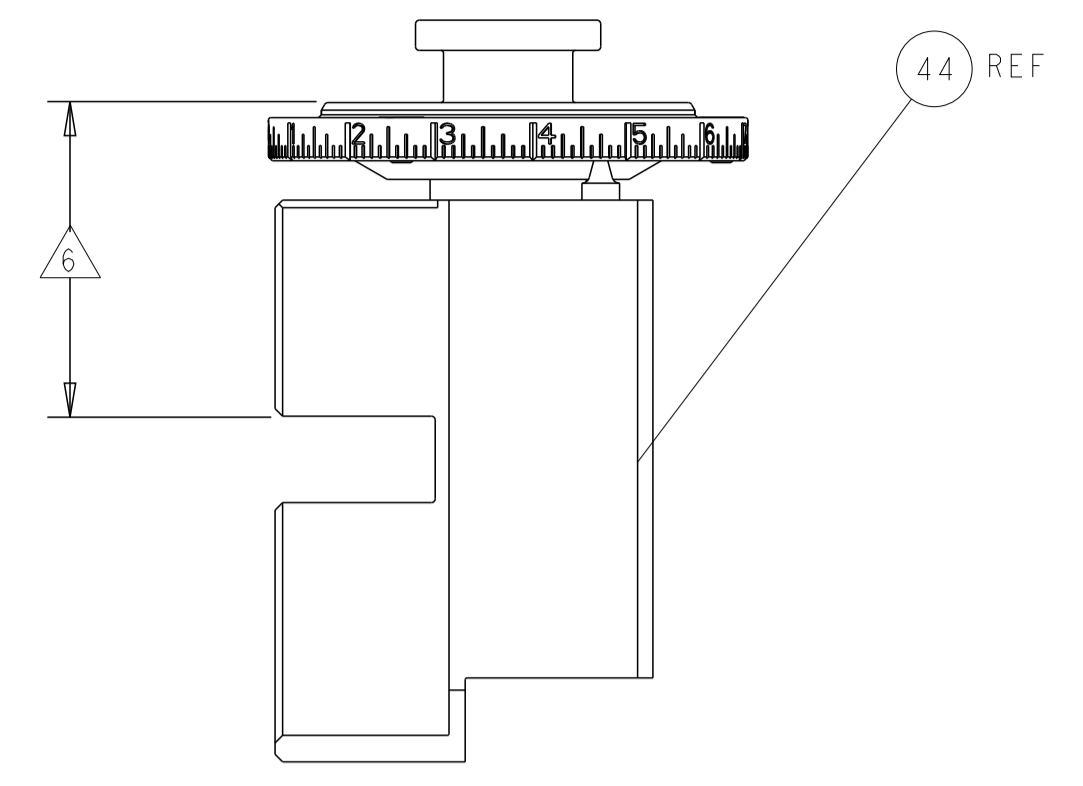
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		G		ECR-17-017682	04DEC2017	TB	TE
		H		ECR-18-015370	28SEP2018	JAH	CT
		J		ECR-19-009276	12JUN2019	LG	TE
		K		ECR-19-016825	29OCT2019	TB	TE

-	1	1	2119641-1	FEED CAM, AIR FEED	248
-	1	1	2119082-6	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	1803071-1	SPACER, REAR SHEAR STRIP GUIDE	196
-	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	2	2	1-2168083-1	SCR, SKT HD CAP, RoHS, M3 X 6	147
-	1	1	2119955-2	ASSY, LUBRICATOR, END FEED	84
-	1	1	1-455888-1	SPACER, CRIMPER	82
-	2	2	1-2119791-4	DEPRESSOR, WIRE	73
-	1	1	1803607-4	DOCUMENTATION PACKAGE	71
-	2	2	3-18032-3	SCR, SET, FLT PNT, M3 X 20.0	70
-	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
-	4	4	2168400-1	SHCS, LOW HEAD, RoHS, M4 X 12	57
-	2	2	2-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 14	56
-	2	2	5018030-1	NUT, HEX, REG, RoHS, M3	54
-	2	2	986965-8	NUT, LOCK, HEX, TORQUE (M4)	53
-	1	1	2063961-1	FEED FINGER	51
-	1	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	1	1	2119655-5	APPLICATOR BASIC ASSEMBLY, EF	46
-	1	1	1803517-2	RAM ASSEMBLY, EF ATLANTIC	44
-	1	1	1803602-2	SCR, BHSC, RoHS (M8 X 40)	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	2280534-1	STRIPPER, OFFSET	27
-	2	2	1-2168083-7	SCR, SKT HD CAP, RoHS, M4 X 40	25
-	1	1	2-1752371-9	PLATE, STRIP GUIDE	24
-	2	2	2-22281-1	SPRING, COMPRESSION	22
-	1	1	1-464452-7	DRAG, STOCK	21
-	1	1	1633168-2	ARM, STOCK DRAG	20
-	1	1	3-1901696-5	STRIP GUIDE, REAR	19
-	1	1	3-1901695-5	STRIP GUIDE, FRONT	18
-	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17
-	1	1	5-240641-4	SPACER	16
-	1	1	1803203-1	BLOCK, FRONT DEPRESSOR	12
-	1	1	240644-1	PLATE, REAR SHEAR	11
-	2	2	1-240645-0	SPACER, SHEAR PLATE	10
-	1	1	240642-1	PLATE, FRONT SHEAR	9
-	1	2	1803003-1	ANVIL, COMBINATION, END FEED	8
-	1	1	240651-4	BLADE, SLUG	7
-	-	-	-	-	6
-	1	1	6-240641-8	SPACER	5
-	1	1	5-238011-4	BLOCK, CRIMPER SPACER	4
-	1	2	1-1803016-3	CRIMPER, INSULATION F	3
-	1	1	1-455888-1	SPACER, CRIMPER	2
-	1	2	456432-3	CRIMPER, WIRE	1
-	77	72	-2	PART NO	ITEM NO

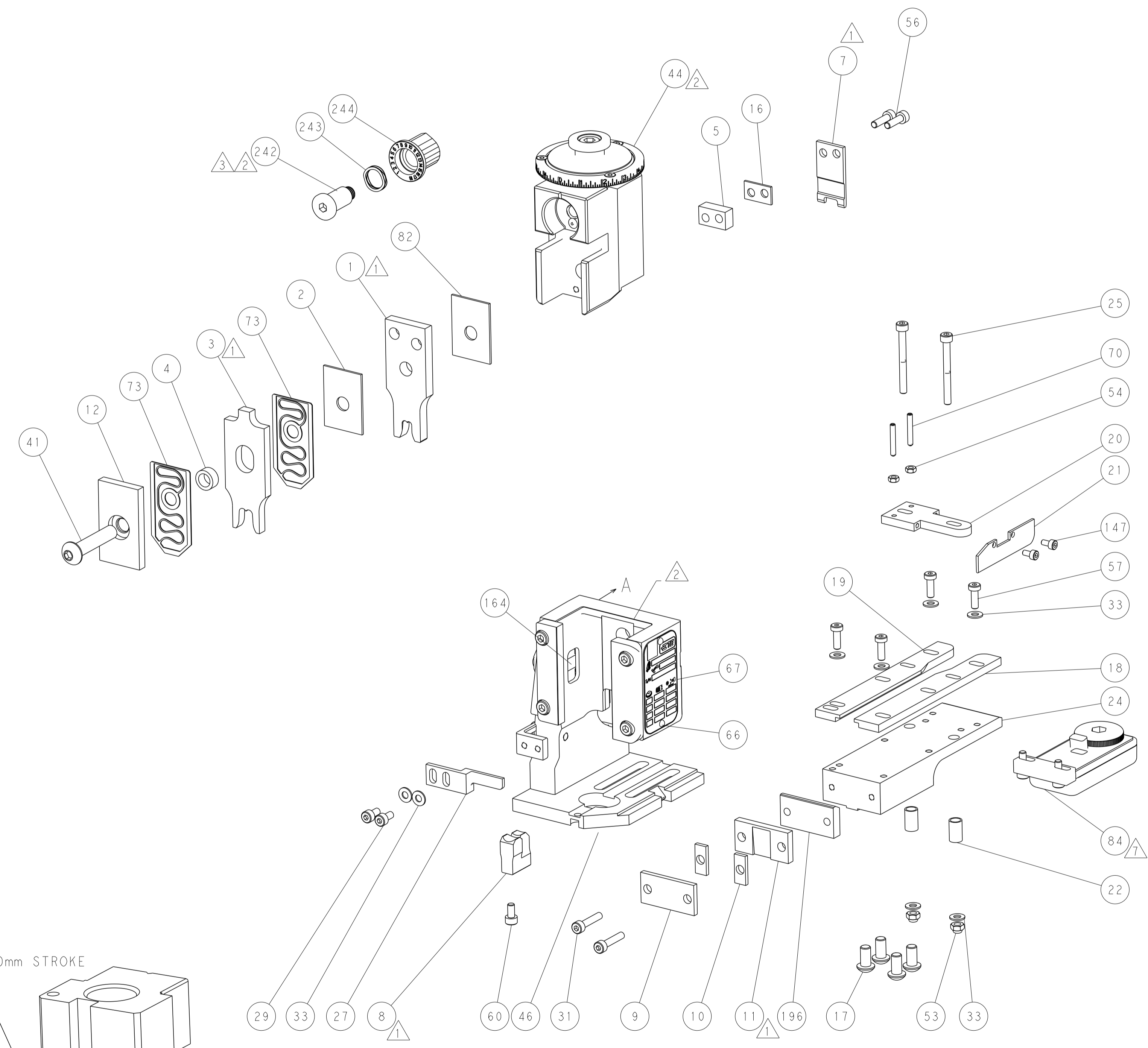
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mm	0 PLC	±		FINISH	
	1 PLC	±			
	2 PLC	±			
	3 PLC	±			
	4 PLC	±			
	ANGLES	±			
	FINISH				

DWN: L. STAKEM 20AUG2014	CHK: G. BAILEY 20AUG2014	APVD: J. ELBIN 20AUG2014	NAME: Ocean End Feed Applicator
SIZE: A1		CAGE CODE: 00779	DRAWING NO: C=2150472
Customer Accessible Production Drawing		SCALE: 1:1	SHEET 1 OF 4
		REV: K	

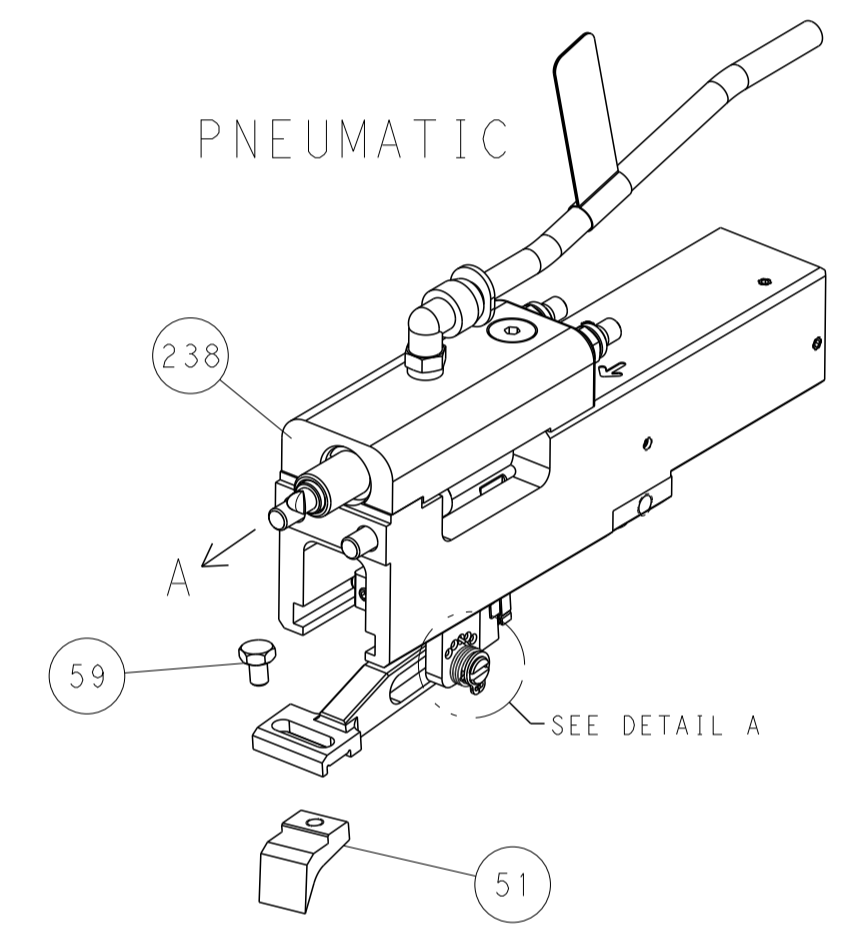
LOC	DIST	REVISIONS			
P	LTN	DESCRIPTION	DATE	OWN	APVD
A	66	SEE SHEET 1	-	-	-



RAM SET-UP

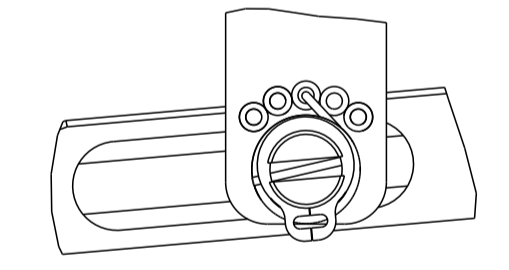


FEED TYPE



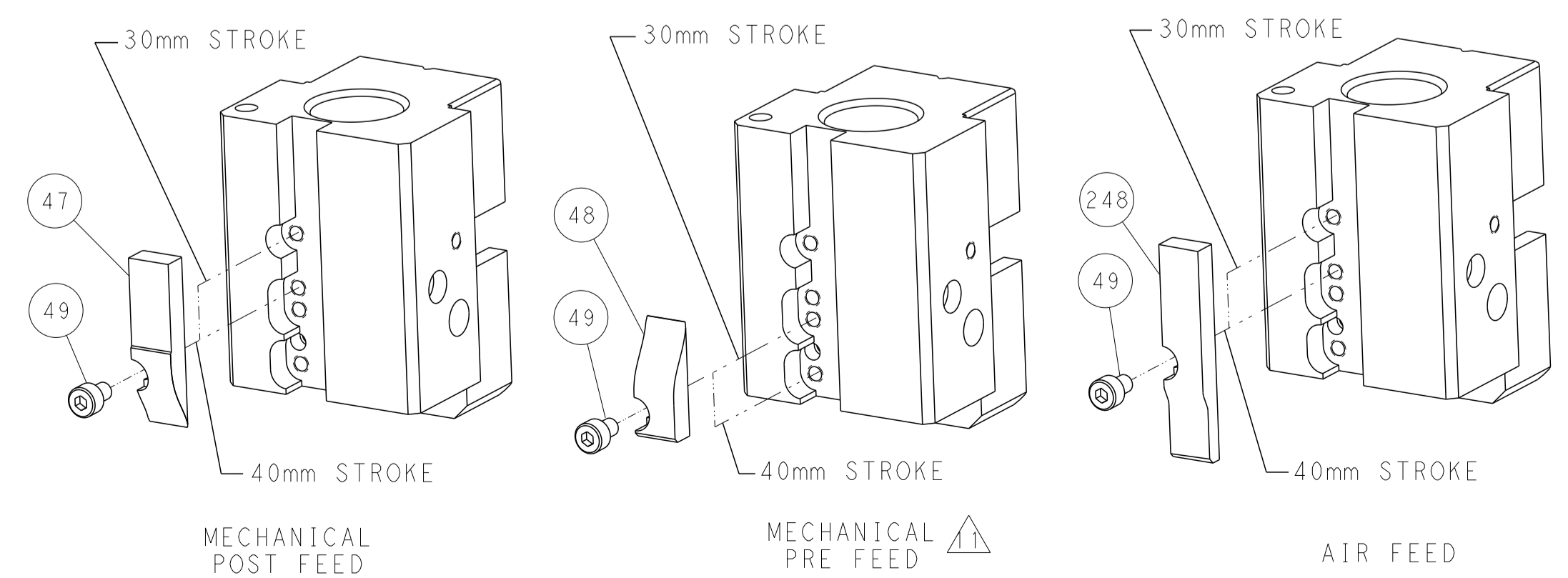
PNEUMATIC

FEED SPRING SETTING POSITION



DETAIL A

CAM POSITIONS

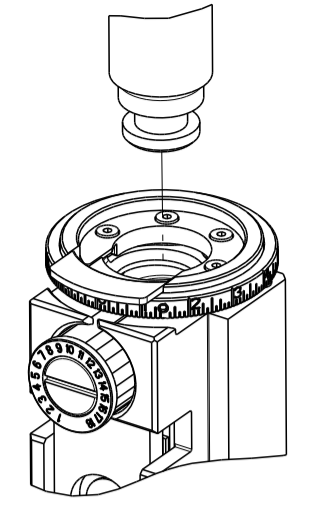


**ATLANTIC VERSION**  
 Shown on sheets 1 of 4 & 2 of 4  
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH		DWN: K. STAKEM 20AUG2014 CHK: G. BAILEY 20AUG2014 APVD: T. ELRLIN 20AUG2014 PRODUCT SPEC: APPLICATION SPEC: WEIGHT:		NAME: Ocean End Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2150472 SCALE: 1:1 SHEET: 2 of 4 REV: K	
MATERIAL:				RESTRICTED TO:			

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150472-2	K	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150472-7	K	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR  
 INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	6.35 mm [.250]	F
INSUL	9.53 mm [.375]	F
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: RING TONGUE			
WIRE STRIP LENGTH 5.18-5.94 mm [.204-.234 IN]		INSULATION DIAMETER RANGE Ø5.59-8.00 mm [.220-.315 IN]	
TERMINAL APPLICATION SPECIFICATION 114-2084		-	
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
42899-1	42913-1	61352-1	
42899-2	42913-2	61352-2	
42899-3	42913-3		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: RING TONGUE			
WIRE STRIP LENGTH 5.18-5.94 mm [.204-.234 IN]		INSULATION DIAMETER RANGE Ø5.59-8.00 mm [.220-.315 IN]	
TERMINAL APPLICATION SPECIFICATION 114-2084		-	
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
41808	41808-1	41809	41809-1

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING	RAM SET-UP DIM ± 0.05
6 AWG	4.85+/-0.05 [.191+/-0.002]	4.7	32.71
8 AWG	4.22+/-0.05 [.166+/-0.002]	11.7	32.71
10 AWG	3.81+/-0.05 [.150+/-0.002]	9.8	33.33

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING	RAM SET-UP DIM ± 0.05
8 AWG	4.57+/-0.05 [.180+/-0.002]	5.7	32.71
10 AWG	4.24+/-0.05 [.167+/-0.002]	9.3	32.71

- 1 RECOMMENDED SPARE PARTS
- 2 REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- 3 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 TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- 6 SEE CHART FOR RAM SET-UP DIMENSION.
- 7 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.

**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	LTN	DESCRIPTION	DATE	OWN	APVD
-	-	-	-	SEE SHEET 1	-	-	-

-	1	2119082-6	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	1803071-1	SPACER, REAR SHEAR STRIP GUIDE	196
-	4	2079383-9	SCR, BHSC, RoHS (M6 X 20)	186
-	REF	994970-2	COUNTER, MAGNETIC	164
-	1	2119641-2	FEED CAM, AIR FEED	152
-	2	1-2168083-1	SCR, SKT HD CAP, RoHS, M3 X 6	147
-	1	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	144
-	1	2119655-6	APPLICATOR BASIC ASSEMBLY, EF	141
-	1	1803518-2	RAM ASSEMBLY, EF PACIFIC	140
-	1	2119955-2	ASSY, LUBRICATOR, END FEED	84
-	1	1-455888-1	SPACER, CRIMPER	82
-	2	1-2119791-4	DEPRESSOR, WIRE	73
-	1	1803607-4	DOCUMENTATION PACKAGE	71
-	2	3-18032-3	SCR, SET, FLT PNT, M3 X 20.0	70
-	1	2119740-1	TAG, IDENTIFICATION	67
-	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	4	2168400-1	SHCS, LOW HEAD, RoHS, M4 X 12	57
-	2	2-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 14	56
-	2	5018030-1	NUT, HEX, REG, RoHS, M3	54
-	2	986965-8	NUT, LOCK, HEX, TORQUE (M4)	53
-	1	2063961-1	FEED FINGER	51
-	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	1	1803602-2	SCR, BHSC, RoHS (M8 X 40)	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	2280534-1	STRIPPER, OFFSET	27
-	2	1-2168083-7	SCR, SKT HD CAP, RoHS, M4 X 40	25
-	1	2-1752371-9	PLATE, STRIP GUIDE	24
-	2	2-22281-1	SPRING, COMPRESSION	22
-	1	1-464452-7	DRAG, STOCK	21
-	1	1633168-2	ARM, STOCK DRAG	20
-	1	3-1901696-5	STRIP GUIDE, REAR	19
-	1	3-1901695-5	STRIP GUIDE, FRONT	18
-	1	5-240641-4	SPACER	16
-	1	1803203-1	BLOCK, FRONT DEPRESSOR	12
-	1	240644-1	PLATE, REAR SHEAR	11
-	2	1-240645-0	SPACER, SHEAR PLATE	10
-	1	240642-1	PLATE, FRONT SHEAR	9
-	1	1803003-1	ANVIL, COMBINATION, END FEED	8
-	1	240651-4	BLADE, SLUG	7
-	-	-	-	6
-	1	6-240641-8	SPACER	5
-	1	5-238011-4	BLOCK, CRIMPER SPACER	4
-	1	9-1803016-3	CRIMPER, INSULATION F	3
-	1	1-455888-1	SPACER, CRIMPER	2
-	1	456432-3	CRIMPER, WIRE	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	

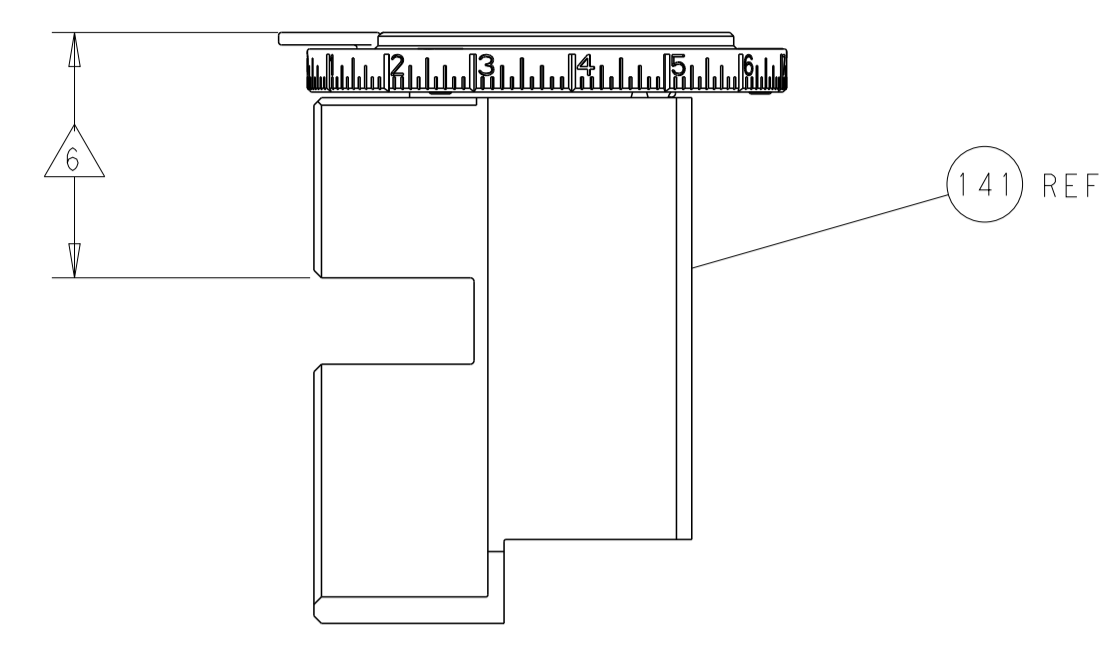
CHK	APVD	DATE	NAME
STAKEM	ELBLN	20AUG2014	20AUG2014
G. BAILEY			

DESCRIPTION	ITEM NO
Ocean End Feed Applicator	

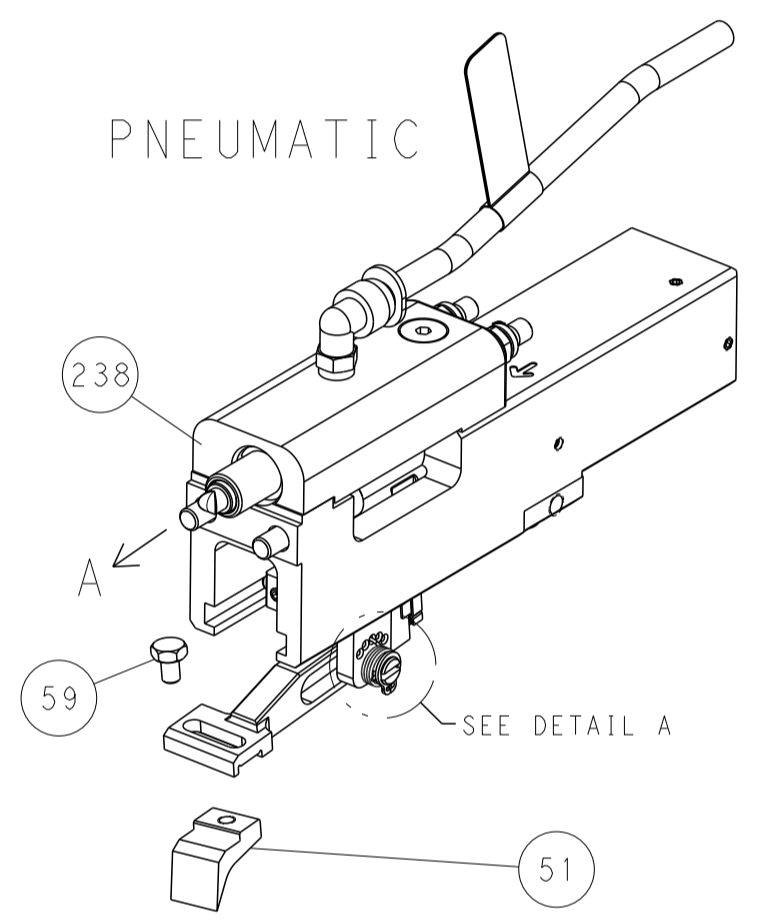
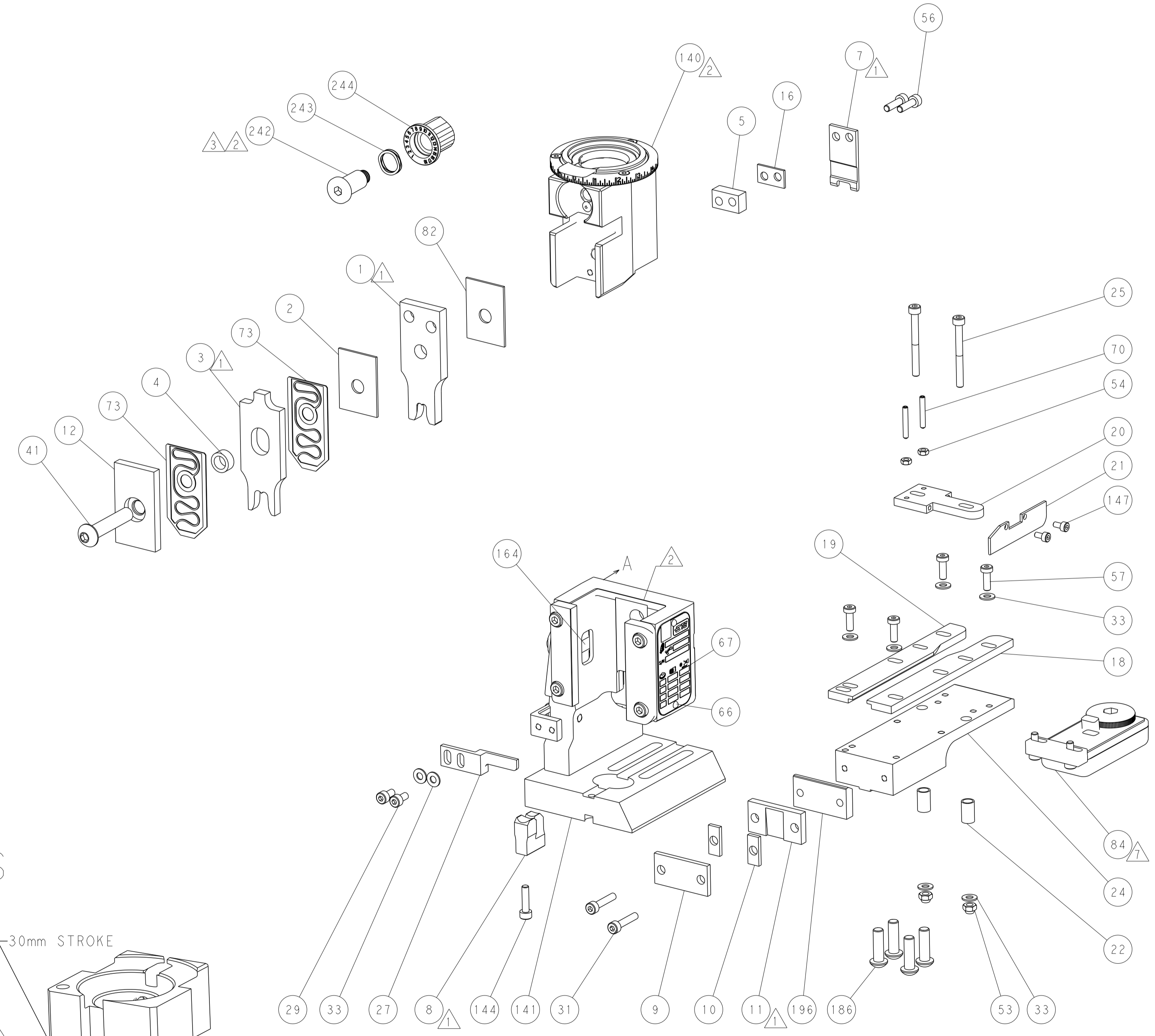
Customer Accessible Production Drawing	SCALE	SHEET	OF	REV
	1:1	3	4	K

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

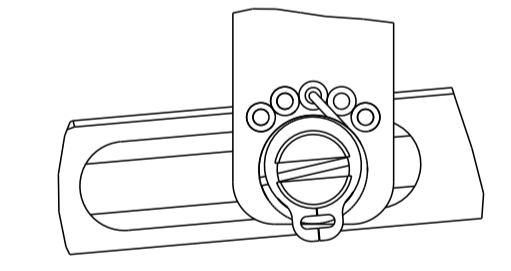
# FEED TYPE



## RAM SET-UP

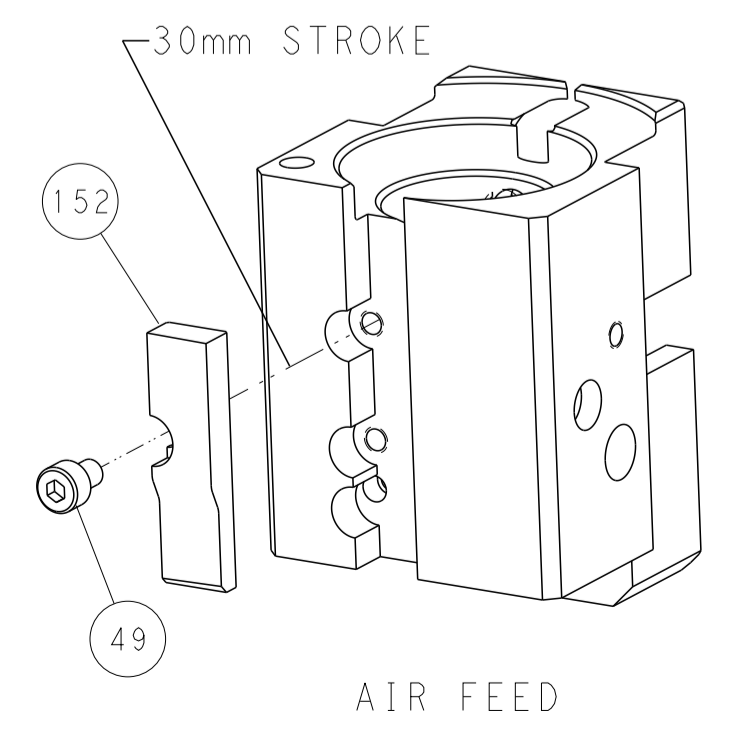
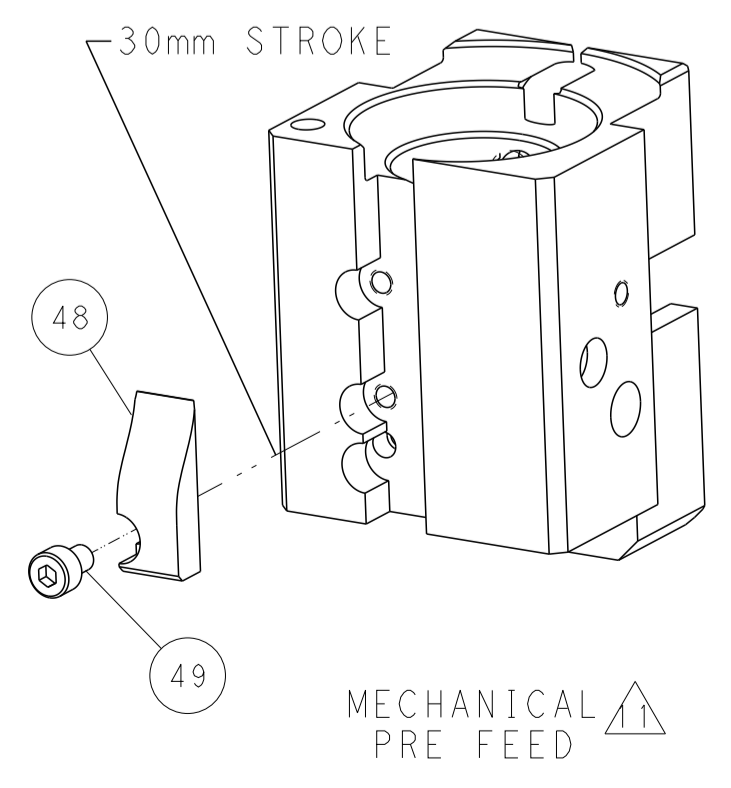
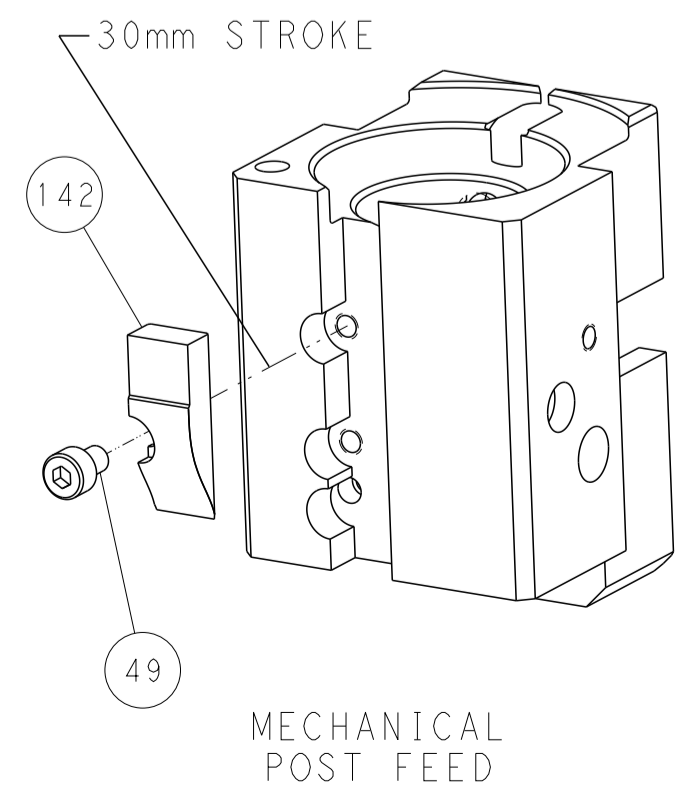


## FEED SPRING SETTING POSITION



DETAIL A

## 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: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH		DWN: K. STAKEM 20AUG2014 CHK: G. BAILEY 20AUG2014 APVD: T. ELRLIN 20AUG2014 NAME: Ocean End Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: C-2150472 SCALE: 1:1 SHEET: 4 of 4 REV: K	
MATERIAL:		WEIGHT:		RESTRICTED TO:	