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ATLANTIC VERSION
TERMINATOR
INTERFACE ADAPTER

PART
NUMBER

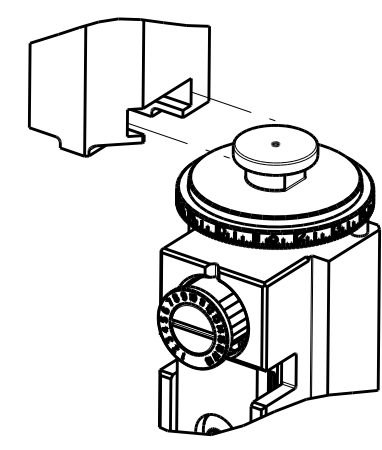
REVISION

DESCRIPTION

FEED TYPE

CONVERT TO

PART NUMBERS REQUIRED



2150461-1

B

FINE CRIMP HEIGHT ADJUST

MECHANICAL

PNEUMATIC FEED

2119950-1

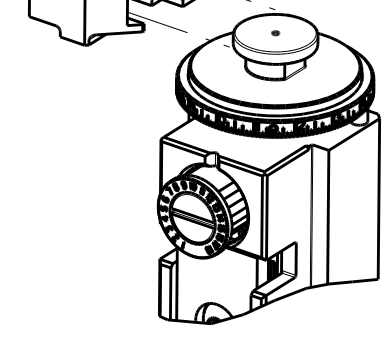
2119792-2

-

2119641-1

-

2063440-1



2150461-2

B

FINE CRIMP HEIGHT ADJUST

PNEUMATIC

SERVO LATCH PLATE

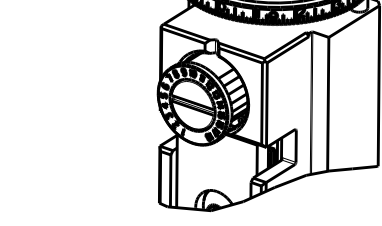
2119951-1

1901697-1

8-2150461-5

-

2168400-7 (QUANTITY 2)



2150461-5

B

FINE CRIMP HEIGHT ADJUST

SERVO LATCH PLATE

2119949-1

2063961-1

5-18022-5

2119653-1

-

-



2150461-6

B

NON-CRIMP HEIGHT ADJUST

SERVO LATCH PLATE

2161326-1

-

8-2150461-4

-

-

2150461-7

B

FINE CRIMP HEIGHT ADJUST

NONE

2119950-1

2119792-2

-

2119641-1

-

2063440-1

7-2150461-7

A

CRIMP TOOLING KIT

-

-

-

-

-

-

APPLICATOR DATA

CRIMP

SIZE

TYPE

WIRE

3.05 mm [.120]

F

INSUL

3.94 mm [.155]

F

APPLICATOR INSTRUCTIONS

408-10390

TERMINAL DATA: TE TERMINAL

TE CRIMP SPECIFICATION

TERMINAL NAME: TERMINAL,RING

WIRE STRIP LENGTH

INSULATION DIAMETER RANGE

TERMINAL APPLICATION SPECIFICATION

TERMINALS APPLIED

TE TERMINAL

TE TERMINAL

TE TERMINAL

TE TERMINAL

TERMINAL DATA: TE TERMINAL

TE CRIMP SPECIFICATION

TERMINAL NAME: TERMINAL,RING

WIRE STRIP LENGTH

INSULATION DIAMETER RANGE

TERMINAL APPLICATION SPECIFICATION

TERMINALS APPLIED

TE TERMINAL

TE TERMINAL

TE TERMINAL

TE TERMINAL

WIRE SIZE

CRIMP HEIGHT

CRIMP HEIGHT REFERENCE SETTING

1.00mm2

1.65+/-0.05 [.065+/- .002]

6.5

0.75mm2

1.58+/-0.05 [.062+/- .002]

7.3

0.50mm2

1.50+/-0.05 [.059+/- .002]

8.1

WIRE SIZE

CRIMP HEIGHT

CRIMP HEIGHT REFERENCE SETTING

18 AWG

1.52+/-0.05 [.060+/- .002]

7.9

20 AWG

1.45+/-0.05 [.057+/- .002]

8.7

1 RECOMMENDED SPARE PARTS

2 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. SEE BELOW FOR PART NUMBER:
MECHANICAL FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150461-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150461-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150461-5
SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2150461-6

5. ADJUSTMENT OF THE STRIPPER MAY BE REQUIRED WHEN MOVING THE APPLICATOR BETWEEN BENCH AND LEADMAKER APPLICATIONS.

6 APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 62.
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 ITEMS 37.

7 GREASE THREADS, GROOVE AND O-RING ON ITEMS 35 & 252.

8 MAGNET, ITEM 166 MUST BE ORIENTED CORRECTLY IN ORDER TO PROPERLY ACTUATE THE COUNTER.

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.

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

11 THE RECOMMENDED SET-UP FOR END FEED APPLICATORS IS POST-FEED WITH ITEM 2119653-1. THE APPLICATOR CAN BE CONFIGURED FOR PRE-FEED WITH ITEM 2119652-1 BUT MAY ENCOUNTER PROBLEMS WITH SOME APPLICATIONS. FEED ISSUES OR TERMINAL JAMMING MAY OCCUR IN THE PRE-FEED CONFIGURATION.

12 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

13 TERMINAL LUBRICANT IS RECOMMENDED.

SET UP GAUGE

2119599-2

LOC

A

DIST

66

REVISIONS

REV

DATE

BY

APP'D

-

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8-21084-0

O-RING, .676 ID, .070 DIA. MAT.

252

-

-

-

-

1

-

2119640-1

PUSH ROD, AIR FEED

250

-

-

-

-

1

-

2079988-1

BUSHING, LCH5-12, MISUMI

249

-

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1

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2119641-1

FEED CAM, AIR FEED

248

-

1

-

1

1

1

2119798-1

DETENT PIN

247

-

1

-

1

1

1

1-22279-3

SPRING, COMPRESSION

246

-

-

1

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-

-

2119759-1

RAM, AMP STYLE, END FEED, NON-ADJUST

245

-

1

1

1

1

1

2119082-7

CAM, SNAIL, INSULATION ADJUSTMENT

244

-

1

1

1

1

1

2079764-1

WASHER, WAVE SPRING, CREST-TO-CREST

243

-

1

1

1

1

1

2119083-1

RETAINER, INSULATION DIAL

242

-

-

2

2

-

-

2168400-7

SHCS, LOW HEAD, RoHS, M5 X 10

240

-

-

-

-

-

1

2119580-1

MECHANICAL FEED ASSEMBLY

239

-

-

-

-

1

-

2063440-1

AIR FEED MODULE

238

-

-

1

1

-

-

2119740-2

TAG,IDENTIFICATION

213

-

-

REF

REF

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-

1901697-1

FEED FINGER ASSEMBLY,EF

183

-

-

-

-

2

-

21045-3

RING, RETAIN, EXTERN, 3/16 CRESCENT

172

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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

-

-

REF

REF

-

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SEE NOTE 4

MEMORY CHIP, PROGRAMMED

135

-

-

1

1

-

-

1633743-1

SERVO FEED LATCH ASM

133

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1

1

1

1

1

2119955-2

ASSY, LUBRICATOR, END FEED

84

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1

1

1

1

1

455888-5

SPACER, CRIMPER

82

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1

1

1

1

1

2119791-5

DEPRESSOR, WIRE

73

-

1

1

1

1

1

2119956-2

DOCUMENTATION PACKAGE

71

-

2

2

2

2

2

2-18032-2

SCR, SET, FLT POINT M3 X 10.0

70

-

1

-

-

1

1

2119740-1

TAG,IDENTIFICATION

67

-

2

2

2

2

2

2168078-1

SCREW, DRIVE, RH, RoHS, 2 x .188

66

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1

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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

1

2079383-4

SCR, BHSC, RoHS (M4 X 8)

60

-

-

-

-

-

1

5-18022-5

SCR, HEX HD CAP, M4 X 6.0

59

-

-

-

-

-

1

2063961-1

FEED FINGER

58

-

4

4

4

4

4

2168400-4

SHCS, LOW HEAD, RoHS, M4 X 8

57

-

2

2

2

2

2

1-2168083-4

SCR, SKT HD CAP, RoHS, M4 X 5

56

-

2

2

2

2

2

5018030-2

NUT, HEX, REG, RoHS, M4

55

-

2

2

2

2

2

5018030-1

NUT, HEX, REG, RoHS, M3

54

-

2

2

2

2

2

986965-8

NUT, LOCK, HEX, TORQUE (M4)

53

-

-

-

-

1

-

2119792-2

PAWL, EF, AIR

51

-

-

-

-

1

2

18023-9

SCR, SKT HD CAP M4 X 6.0

49

-

-

-

-

-

1

2119652-1

FEED CAM, PRE FEED

48

-

-

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-

1

2119653-1

FEED CAM, POST FEED

47

-

1

1

1

1

1

2119655-5

APPLICATOR BASIC ASSEMBLY, EF

46

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1

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1

1

1

2119369-1

RAM, AMP STYLE, END FEED

44

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1

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

1

1-2119644-2

RAM WASHER, PRECISION

38

-

1

1

1

1

1

2119085-1

FA HEAD, ATLANTIC STYLE

37

-

1

-

1

1

1

2119092-1

BOLT, ADJUSTMENT

35

-

8

8

8

8

8

1-18028-2

WASHER, FLAT, REG M4

33

-

2

2

2

2

2

2168083-8

SCR, SKT HD CAP, RoHS, M4 X 16

31

-

2

2

2

2

2

2168083-2

SCR, SKT HD CAP, RoHS, M4 X 8.0

29

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1

1

1

1

1

240639-1

STRIPPER (MACHINING)

27

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2

2

2

2

2

1320906-1

STUD, THREADED

25

-

1

1

1

1

1

1752371-2

PLATE, STRIP GUIDE

24

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2

2

2

2

2

2-22281-3

SPRING, COMPRESSION

22

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1

1

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1752373-4

DRAG

20

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1-1901696-2

STRIP GUIDE, REAR

19

-

1

1

1

1

1

1-1901695-2

STRIP GUIDE, FRONT

18

-

4

4

4

4

4

1-2079383-1

SCR, BHSC, RoHS (M6 X 12)

17

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1

1

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1

691901-2

REAR SHEAR PLATE, REVERSIBLE

11

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2

2

2

2

2

1-240645-6

SPACER, SHEAR PLATE

10

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1

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240642-1

PLATE, FRONT SHEAR

9

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1

1

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1803060-9

ANVIL, COMBINATION, END FEED

8

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2-691157-6

BLADE, SLUG

7

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6

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1

1

1

1

1

5-240641-8

SPACER

5

-

1

1

1

1

1

238009-8

BLOCK, FL CRIMPER SPACER

4

-

1

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1

1

1

2-2119582-6

CRIMPER, INSULATION F PREMIUM

3

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2

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456409-2

CRIMPER, WIRE .120 "F" PREMIUM

1

-

7

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6

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2

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1

PART NO

DESCRIPTION

ITEM NO

APPLICATOR STYLE CONVERSION CHART

PART NUMBERS REQUIRED

APPLICATOR DATA

CRIMP

SIZE

TYPE

WIRE

3.05 mm [.120]

F

INSUL

3.94 mm [.155]

F

APPLICATOR INSTRUCTIONS

408-10390

TERMINAL DATA: TE TERMINAL

TE CRIMP SPECIFICATION

TERMINAL NAME: TERMINAL,RING

WIRE STRIP LENGTH

INSULATION DIAMETER RANGE

TERMINAL APPLICATION SPECIFICATION

TERMINALS APPLIED

TE TERMINAL

TE TERMINAL

TE TERMINAL

TE TERMINAL

TERMINAL DATA: TE TERMINAL

TE CRIMP SPECIFICATION

TERMINAL NAME: TERMINAL,RING

WIRE STRIP LENGTH

INSULATION DIAMETER RANGE

TERMINAL APPLICATION SPECIFICATION

TERMINALS APPLIED

TE TERMINAL

TE TERMINAL

TE TERMINAL

TE TERMINAL

WIRE SIZE

CRIMP HEIGHT

CRIMP HEIGHT REFERENCE SETTING

1.00mm2

1.65+/-0.05 [.065+/- .002]

6.5

0.75mm2

1.58+/-0.05 [.062+/- .002]

7.3

0.50mm2

1.50+/-0.05 [.059+/- .002]

8.1

WIRE SIZE

CRIMP HEIGHT

CRIMP HEIGHT REFERENCE SETTING

18 AWG

1.52+/-0.05 [.060+/- .002]

7.9

20 AWG

1.45+/-0.05 [.057+/- .002]

8.7

1 RECOMMENDED SPARE PARTS

2 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. SEE BELOW FOR PART NUMBER:
MECHANICAL FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150461-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150461-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150461-5
SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2150461-6

5. ADJUSTMENT OF THE STRIPPER MAY BE REQUIRED WHEN MOVING THE APPLICATOR BETWEEN BENCH AND LEADMAKER APPLICATIONS.

6 APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 62.
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 ITEMS 37.

7 GREASE THREADS, GROOVE AND O-RING ON ITEMS 35 & 252.

8 MAGNET, ITEM 166 MUST BE ORIENTED CORRECTLY IN ORDER TO PROPERLY ACTUATE THE COUNTER.

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.

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

11 THE RECOMMENDED SET-UP FOR END FEED APPLICATORS IS POST-FEED WITH ITEM 2119653-1. THE APPLICATOR CAN BE CONFIGURED FOR PRE-FEED WITH ITEM 2119652-1 BUT MAY ENCOUNTER PROBLEMS WITH SOME APPLICATIONS. FEED ISSUES OR TERMINAL JAMMING MAY OCCUR IN THE PRE-FEED CONFIGURATION.

12 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

13 TERMINAL LUBRICANT IS RECOMMENDED.

SET UP GAUGE

2119599-2

LOC

A

DIST

66

REVISIONS

REV

DATE

BY

APP'D

-

1

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8-21084-0

O-RING, .676 ID, .070 DIA. MAT.

252

-

-

-

-

1

-

2119640-1

PUSH ROD, AIR FEED

250

-

-

-

-

1

-

2079988-1

BUSHING, LCH5-12, MISUMI

249

-

-

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1

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2119641-1

FEED CAM, AIR FEED

248

-

1

-

1

1

1

2119798-1

DETENT PIN

247

-

1

-

1

1

1

1-22279-3

SPRING, COMPRESSION

246

-

-

1

-

-

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2119759-1

RAM, AMP STYLE, END FEED, NON-ADJUST

245

-

1

1

1

1

1

2119082-7

CAM, SNAIL, INSULATION ADJUSTMENT

244

-

1

1

1

1

1

2079764-1

WASHER, WAVE SPRING, CREST-TO-CREST

243

-

1

1

1

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1

2119083-1

RETAINER, INSULATION DIAL

242

-

-

2

2

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-

2168400-7

SHCS, LOW HEAD, RoHS, M5 X 10

240

-

-

-

-

-

1

2119580-1

MECHANICAL FEED ASSEMBLY

239

-

-

-

-

1

-

2063440-1

AIR FEED MODULE

238

-

-

1

1

-

-

2119740-2

TAG,IDENTIFICATION

213

-

-

REF

REF

-

-

1901697-1

FEED FINGER ASSEMBLY,EF

183

-

-

-

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2

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21045-3

RING, RETAIN, EXTERN, 3/16 CRESCENT

172

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1

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1

994969-1

MAGNET, RARE EARTH HIGH ENERGY

166

-

REF

REF

REF

REF

REF

994970-2

COUNTER, MAGNETIC

164

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240638-1

SPRING, FEED FINGER

163

-

-

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1

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3-23627-7

PIN, RETAIN, GRVD, 3/16 X .854

137

-

-

REF

REF

-

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SEE NOTE 4

MEMORY CHIP, PROGRAMMED

135

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1633743-1

SERVO FEED LATCH ASM

133

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2119955-2

ASSY, LUBRICATOR, END FEED

84

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455888-5

SPACER, CRIMPER

82

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2119791-5

DEPRESSOR, WIRE

73

-

1

1

1

1

1

2119956-2

DOCUMENTATION PACKAGE

71

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2

2

2

2

2

2-18032-2

SCR, SET, FLT POINT M3 X 10.0

70

-

1

-

-

1

1

2119740-1

TAG,IDENTIFICATION

67

-

2

2

2

2

2

2168078-1

SCREW, DRIVE, RH, RoHS, 2 x .188

66

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1

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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

1

2079383-4

SCR, BHSC, RoHS (M4 X 8)

60

-

-

-

-

-

1

5-18022-5

SCR, HEX HD CAP, M4 X 6.0

59

-

-

-

-

-

1

2063961-1

FEED FINGER

58

-

4

4

4

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4

2168400-4

SHCS, LOW HEAD, RoHS, M4 X 8

57

-

2

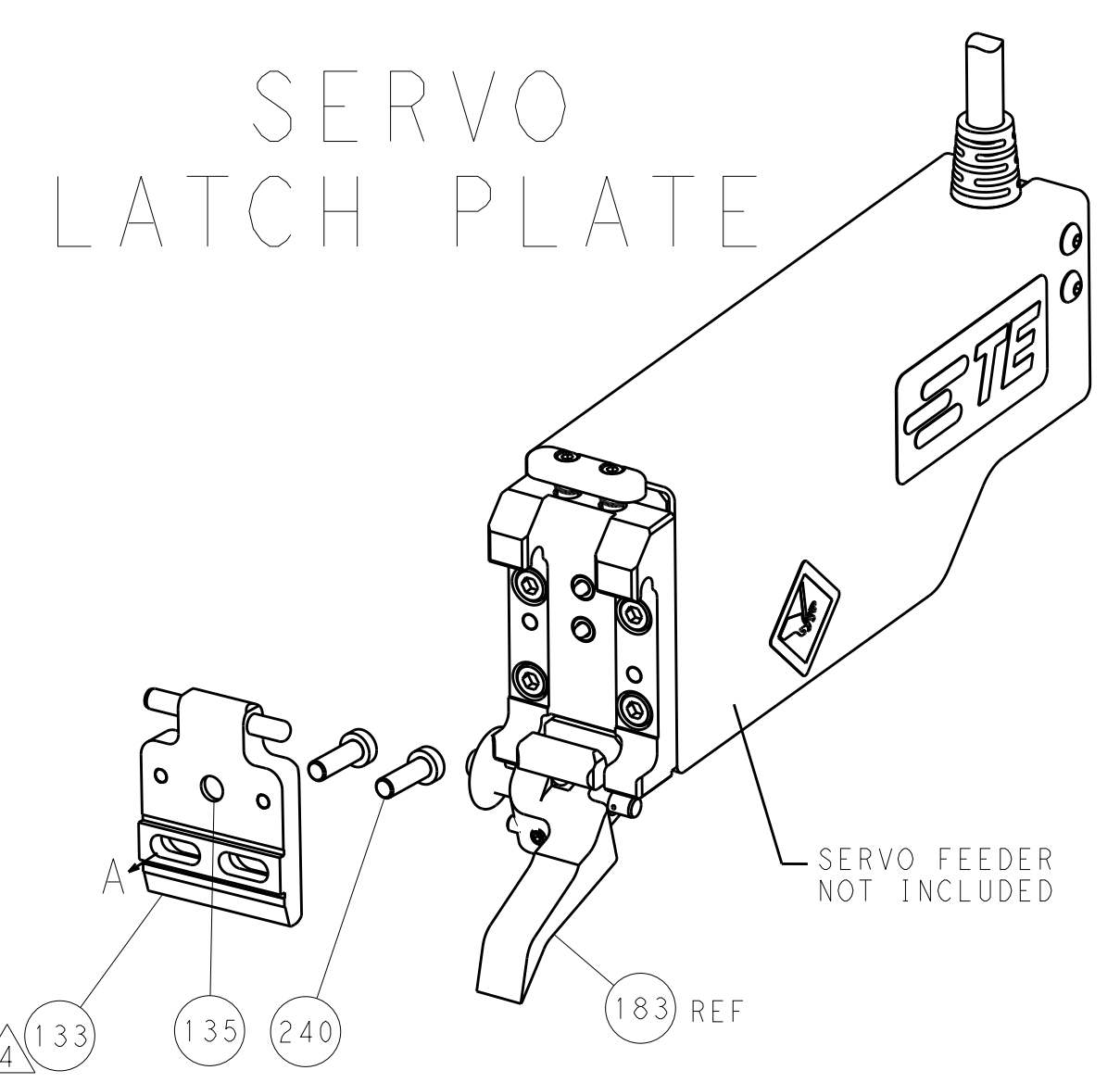
2

2

2

2

1-2168083



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

