

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART						
					CONVERT TO	PART NUMBERS REQUIRED					
	2151491-1	L	FINE CRIMP HEIGHT ADJUST	MECHANICAL	PNEUMATIC FEED	2119950-1	1338685-1	5-18022-5	2119641-1	2119799-1	2063440-1
					SERVO LATCH PLATE	2119951-1	-	8-2151491-5	1901094-3	-	2168400-6 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2151491-4	-	-	-
	2151491-2	L	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-1	-	-
					SERVO LATCH PLATE	2119951-1	-	8-2151491-5	1901094-3	-	2168400-6 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2151491-4	-	-	-
	2151491-5	L	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE ⁴	MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-1	-	-
PNEUMATIC FEED					2119950-1	1338685-1	5-18022-5	2119641-1	2119799-1	2063440-1	
2151491-6	L	NON-CRIMP HEIGHT ADJUST	SERVO LATCH PLATE ⁴	SERVO LATCH PLATE ¹²	-	-	-	-	-	-	
2151491-7	L	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	-	
7-2151491-7	K	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-	

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.40 mm [.055]	F
INSUL	2.03 mm [.080]	O
APPLICATOR INSTRUCTIONS 408-10389		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: MICRO QUADLOK SYSTEM SOCKET CONTACT			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
3.35-3.65 mm [.132-.144 IN]		Ø1.30-1.90mm [.051-.075 IN]	
TERMINAL APPLICATION SPECIFICATION	(A) 114-18021		
	(B) 114-61024		

TERMINALS APPLIED			
GROUP 1 ⁴		GROUP 2 ³	
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
(A) 963715-1	(A) 963716-1	(A) 1452013-1	(A) 968221-1
(A) 963715-5	(A) 963716-2	(A) 1-1452013-1	(A) 968221-5
(A) 963715-6	(A) 1-963716-2	(A) 5-1452013-1	(A) 968221-6
(A) 1-963715-5	(A) 5-963716-1	(A) 6-1452013-1	(A) 5-968221-1
(A) 5-963715-1	(A) 5-963716-2		(A) 5-968221-5
(A) 5-963715-5	(A) 5-963716-3		(A) 5-968221-6
(A) 5-963715-6	(A) 6-963716-1		(A) 1241920-1
(A) 6-963715-5	(A) 6-963716-2		(A) 5-1241920-1

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.75mm2	1.07+/-0.05 [.042+/-0.002]	6.3
0.50mm2	0.93+/-0.05 [.037+/-0.002]	7.7

- 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: 8-2151491-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151491-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151491-5
SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2151491-6
- 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 ITEM 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 ITEM 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 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.
- 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 CUT TO LENGTH AT ASSEMBLY.

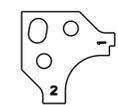
TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: MICRO QUADLOK SYSTEM SOCKET CONTACT			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
3.35-3.65 mm [.132-.144 IN]		Ø1.40-1.90 mm [.055-.075 IN]	
TERMINAL APPLICATION SPECIFICATION	(A) 114-18021		
	(B) 114-61024		

TERMINALS APPLIED			
GROUP 1 ⁴		GROUP 2 ³	
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
(A) 1801529-1	(A) 1801529-2	(A) 1703282-1	(A) 5-1703282-1
		(A) 1703282-2	(A) 5-1703282-2

⁴ POSITION THE HOLD DOWN, ITEM 18, IN ORIENTATION 1 FOR GROUP 1 TERMINALS. REFER TO SHEET 2.



³ POSITION THE HOLD DOWN, ITEM 18, IN ORIENTATION 2 FOR GROUP 2 TERMINALS. REFER TO SHEET 2.



***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.

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

SET UP GAUGE	LOC	DIST	REVISIONS					
2119599-1	A	66	P	LTN	DESCRIPTION	DATE	OWN	APVD
			L		ECR-16-004202	21MAR2016	YY	JT

-	-	1	-	-	-	2119957-2	APPLICATOR SHIM PACK	260
-	-	1	-	1	1	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
-	-	-	-	1	-	2119641-1	FEED CAM, AIR FEED	248
-	-	1	-	1	1	2119798-1	DETENT PIN	247
-	-	1	-	1	1	1-22279-3	SPRING, COMPRESSION	246
-	-	1	-	-	-	2119758-1	RAM, AMP STYLE, SIDE FEED, NON-ADJ.	245
-	-	1	1	1	1	2119082-5	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	-	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	-	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
-	-	-	-	2	-	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172
-	-	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
-	-	1	1	1	1	1-18028-2	WASHER, FLAT, REG M4	119
-	-	REF	REF	-	-	2119944-1	FEED FINGER ASSEMBLY, SF	117
-	-	1	1	1	1	455888-6	SPACER, CRIMPER	82
-	-	1	1	1	1	240641-9	SPACER	81
-	-	1	1	1	1	2119956-1	DOCUMENTATION PACKAGE	71
-	-	1	1	1	1	2119791-9	DEPRESSOR, WIRE	70
-	-	1	-	-	1	2119740-1	TAG, IDENTIFICATION	67
-	-	2	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	-	1	-	1	1	2119793-1	LIMITER, ADJUSTMENT BOLT	63
-	-	3	-	3	3	992763-5	SCR, SET, SOC, CONE POINT, M3 X 4.0	62
-	-	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	1338685-1	PAWL, FEED	56
-	-	4	4	4	4	2168400-1	SHCS, LOW HEAD, RoHS, M4 X 12	54
-	-	2	2	2	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	53
-	-	-	-	-	1	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	2119656-9	APPLICATOR BASIC ASSEMBLY, SF	46
-	-	1	-	1	1	2119370-1	RAM, AMP STYLE, SIDE FEED	44
-	-	1	1	1	1	2079383-7	SCR, BHSC, RoHS (M8 X 25)	41
-	-	1	-	1	1	2119645-1	DISC, NUMBERED FA WIRE ADJUSTMENT	40
-	-	1	-	1	1	2119957-1	APPLICATOR SHIM PACK	39
-	-	1	1	1	1	2119644-1	RAM WASHER, PRECISION	38
-	-	1	1	1	1	2119085-1	FA HEAD, ATLANTIC STYLE	37
-	-	1	-	1	1	2119092-1	BOLT, ADJUSTMENT	35
-	-	1	1	1	1	1752356-3	SUPPORT, TERMINAL	34
-	-	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	-	1	1	1	1	2161328-1	HEX HEAD, FLANGED, M5 X 8mm LONG	32
-	-	1	1	1	1	1320908-6	SPACER, STRIP GUIDE	30
-	-	1	1	1	1	2119959-1	ASSEMBLY, STRIP GUIDE	29
-	-	1	1	1	1	1320928-2	STRIP GUIDE	24
-	-	1	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
-	-	1	1	1	1	1-18028-2	WASHER, FLAT, REG M4	20
-	-	1	1	1	1	2119533-1	STRIPPER, SIDE FEED	19
-	-	1	1	1	1	2217529-1	TERMINAL HOLD DOWN	18
-	-	1	1	1	1	2119806-1	INSERT, SHEAR	13
-	-	1	1	1	1	3-22280-3	SPRING, COMPRESSION	12
-	-	1	1	1	1	1-356885-4	STOP, SHEAR	11
-	-	1	1	1	1	2119805-1	SHEAR HOLDER, FRONT	10
-	-	1	1	1	1	1803095-3	FLOATING SHEAR, FRONT	9
-	-	1	1	1	1	1-1338690-1	ANVIL, COMBINATION .055	8
-	-	1	1	1	1	1-240641-1	SPACER	7
-	-	1	1	1	1	2119757-4	DEPRESSOR, SHEAR	5
-	-	1	1	1	1	238011-9	BLOCK, CRIMPER SPACER	4
-	-	1	1	1	1	2-1633966-9	CRIMPER, INSULATION O	3
-	-	1	1	1	1	3-1633860-8	CRIMPER, WIRE	1

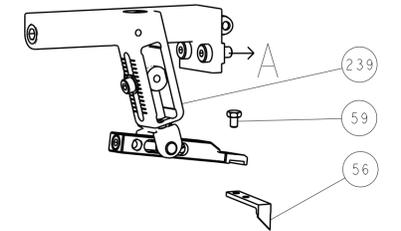
ITEM NO	PART NO	DESCRIPTION	ITEM NO
-77	-7	-6	-5
-2	-1		

DATE	BY	CHK	APPV	PRODUCT SPEC	APPLICATION SPEC	WEIGHT	SCALE	SHEET	OF	REV
31AUG2011	WEAVER						1:2	1	4	L
31AUG2011	HOFENER									
31AUG2011	ELBIN									

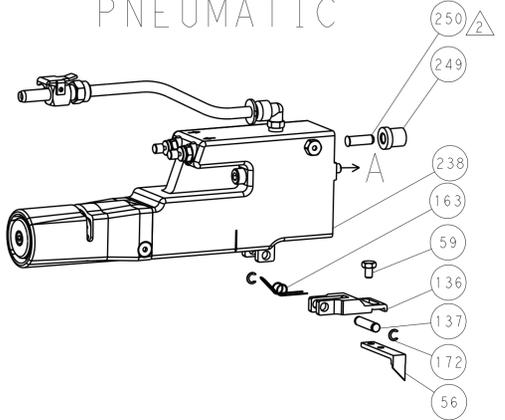
Customer Accessible Production Drawing

LOC	DIST	REV	DESCRIPTION	DATE	OWN	APVD
A	66		SEE SHEET 1			

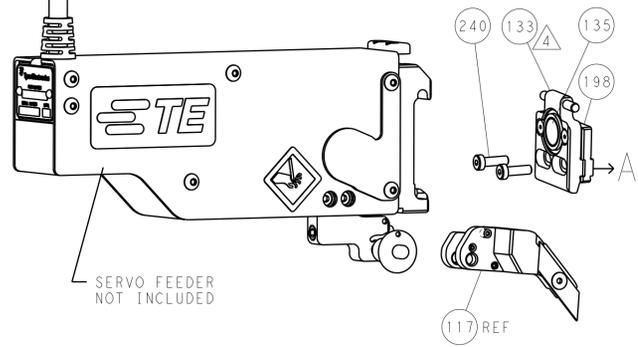
FEED TYPE MECHANICAL



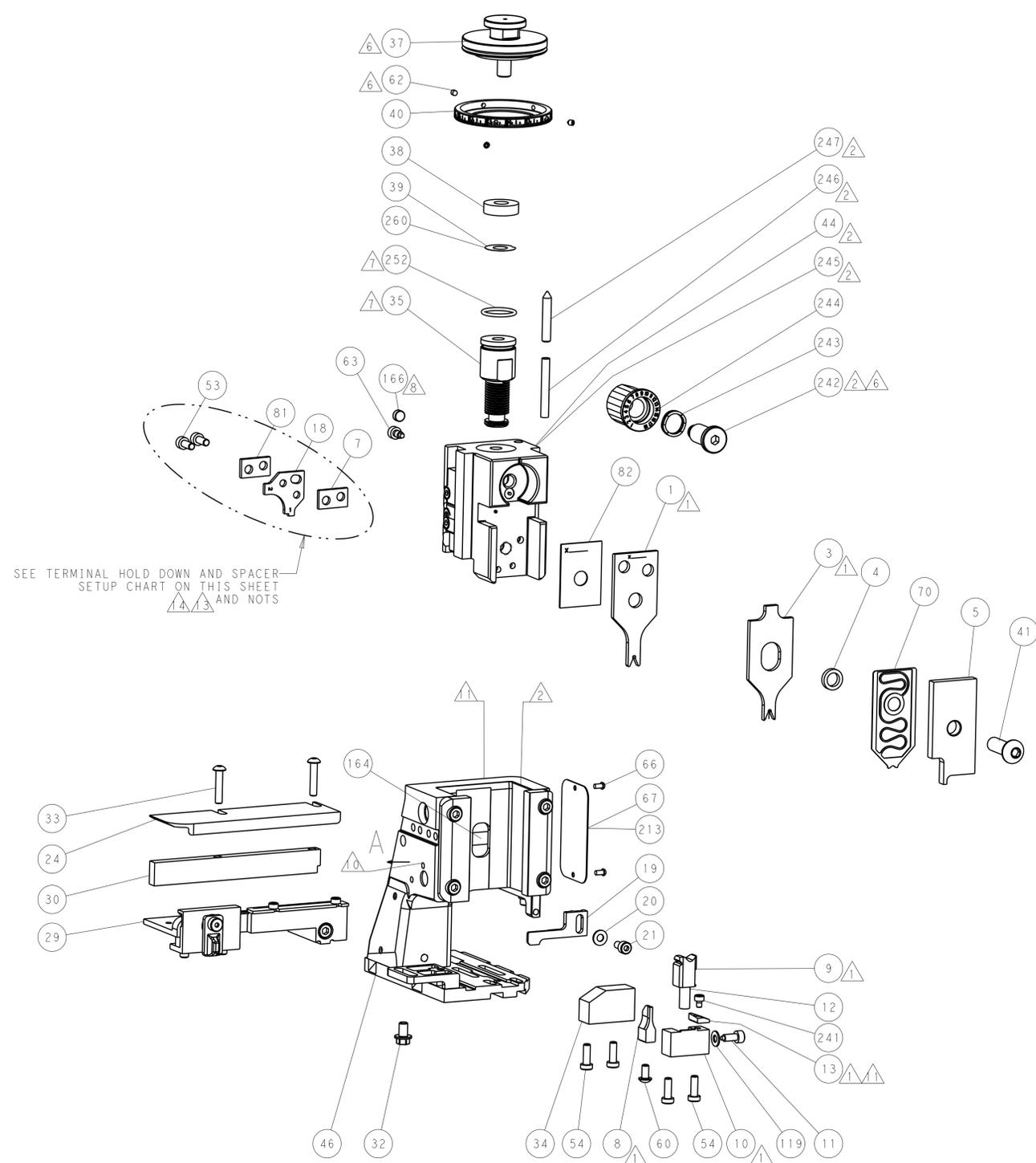
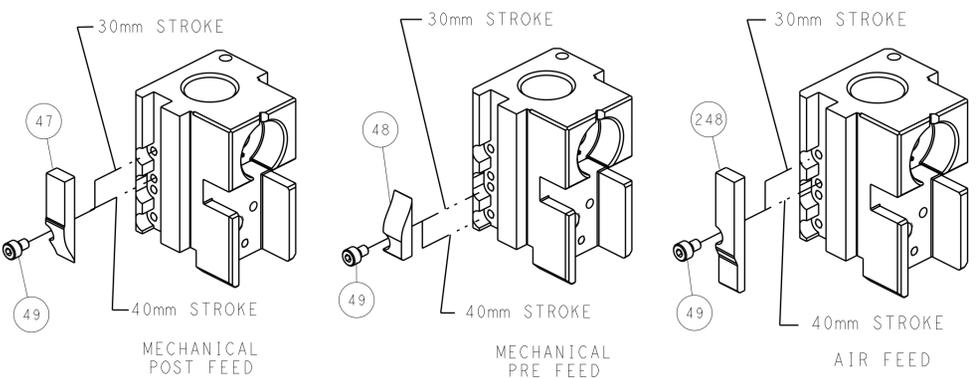
PNEUMATIC



SERVO LATCH PLATE

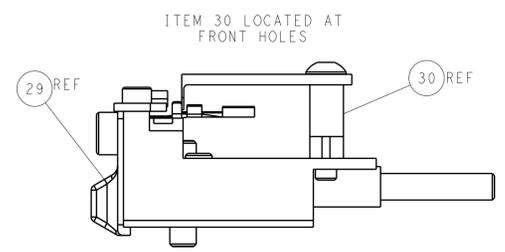
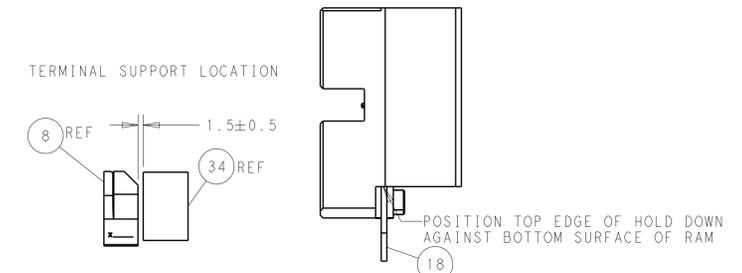


CAM POSITIONS



SEE TERMINAL HOLD DOWN AND SPACER SETUP CHART ON THIS SHEET AND NOTS

TERMINAL HOLD DOWN & SPACER SETUP CHART	
HOLD DOWN & SPACER TOOLING SETUP FOR TERMINALS: 963715-1 963716-1 963715-5 963716-2 963715-6 1-963716-2 1-963715-5 5-963716-1 5-963715-1 5-963716-2 5-963715-5 5-963716-3 5-963715-6 6-963716-1 6-963715-5 6-963716-2 1801529-1 1703298-1 1801529-2 1703298-5 2141399-6 2005120-1	 POSITION 1
HOLD DOWN & SPACER TOOLING SETUP FOR TERMINALS: 1452013-1 1-1452013-1 5-1452013-1 6-1452013-1	 POSITION 1
HOLD DOWN & SPACER TOOLING SETUP FOR TERMINALS: 968221-1 1703282-1 968221-5 1703282-2 968221-6 5-1703282-1 5-968221-1 5-1703282-2 5-968221-5 1379418-1 5-968221-6 1379418-2	 POSITION 2
HOLD DOWN & SPACER TOOLING SETUP FOR TERMINALS: 1241920-1 5-1241920-1	 POSITION 2



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 ±		OWN: B. WEAVER 31AUG2011 CHK: G. HOFFNER 31AUG2011 APVD: T. ELBIN 31AUG2011		NAME: Ocean Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2151491	
MATERIAL:		FINISH:		WEIGHT:		SCALE: 1:2	
				Customer Accessible Production Drawing		SHEET 2 OF 4 REV L	

PACIFIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART						
					CONVERT TO	PART NUMBERS REQUIRED					
	2-2151491-1	L	FINE CRIMP HEIGHT ADJUST	MECHANICAL	PNEUMATIC FEED	2119950-1	1338685-1	5-18022-5	2119641-2	2119799-1	2063440-1
					SERVO LATCH PLATE	2119951-1	-	8-2151491-5	1901094-3	-	2168400-6 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2151491-4	-	-	
	2-2151491-2	L	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-2	-	-
					SERVO LATCH PLATE	2119951-1	-	8-2151491-5	1901094-3	-	2168400-6 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2151491-4	-	-	
	2-2151491-5	L	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE ⁴	MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-2	-	-
					PNEUMATIC FEED	2119950-1	1338685-1	5-18022-5	2119641-2	2119799-1	2063440-1
	2-2151491-7	L	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	-
	7-2151491-7	K	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.40 mm [.055]	F
INSUL	2.03 mm [.080]	O
APPLICATOR INSTRUCTIONS 408-10389		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: MICRO QUADLOK SYSTEM SOCKET CONTACT			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
3.35-3.65 mm [.132-.144 IN]		Ø1.30-1.90mm [.051-.075 IN]	
TERMINAL APPLICATION SPECIFICATION	(A) 114-18021 (B) 114-61024		
TERMINALS APPLIED			
GROUP 1 ³		GROUP 2 ⁴	
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
(A) 963715-1	(A) 963716-1	(A) 1452013-1	(A) 968221-1
(A) 963715-5	(A) 963716-2	(A) 1-1452013-1	(A) 968221-5
(A) 963715-6	(A) 1-963716-2	(A) 5-1452013-1	(A) 968221-6
(A) 1-963715-5	(A) 5-963716-1	(A) 6-1452013-1	(A) 5-968221-1
(A) 5-963715-1	(A) 5-963716-2		(A) 5-968221-5
(A) 5-963715-5	(A) 5-963716-3		(A) 5-968221-6
(A) 5-963715-6	(A) 6-963716-1		(A) 1241920-1
(A) 6-963715-5	(A) 6-963716-2		(A) 5-1241920-1

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: MICRO QUADLOK SYSTEM SOCKET CONTACT			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
3.35-3.65 mm [.132-.144 IN]		Ø1.40-1.90 mm [.055-.075 IN]	
TERMINAL APPLICATION SPECIFICATION	(A) 114-18021 (B) 114-61024		
TERMINALS APPLIED			
GROUP 1 ³		GROUP 2 ⁴	
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
(A) 1801529-1	(A) 1801529-2	(A) 1703282-1	(A) 5-1703282-1
		(A) 1703282-2	(A) 5-1703282-2

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: MICRO QUADLOK SYSTEM SOCKET CONTACT			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
3.35-3.65 mm [.132-.144 IN]		Ø1.70-1.90mm [.067-.075 IN]	
TERMINAL APPLICATION SPECIFICATION	(A) 114-18021 (B) 114-61024		
TERMINALS APPLIED			
GROUP 1 ³		GROUP 2 ⁴	
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
(A) 1379418-1		(A) 1703298-1	(B) 2005120-1
(A) 1379418-2		(A) 1703298-5	(A) 2141399-6

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.75mm2	1.07+/-0.05 [.042+/-0.002]	6.3
0.50mm2	0.93+/-0.05 [.037+/-0.002]	7.7

- RECOMMENDED SPARE PARTS
- GREASE BEARING SURFACES LIGHTLY
- 3. LUBRICATE DAILY PER THE APPLICATOR INSTRUCTION SHEET SUPPLIED WITH THE APPLICATOR.
- APPLICATOR SPECIFIC DATA TO BE ENTERED INTO BLANK MEMORY CHIP AT ASSEMBLY. SEE BELOW FOR PART NUMBER:
MECHANICAL FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151491-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151491-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151491-5
- 5. ADJUSTMENT OF THE STRIPPER MAY BE REQUIRED WHEN MOVING THE APPLICATOR BETWEEN BENCH AND LEADMAKER APPLICATIONS.
- APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 62.
APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242.
- GREASE THREADS, GROOVE AND O-RING ON ITEMS 139 & 152.
- MAGNET MUST BE ORIENTED CORRECTLY IN ORDER TO PROPERLY ACTUATE THE COUNTER.
- 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.
- SPARE FEED CAM STORAGE LOCATION REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.
- TO CONVERT THE APPLICATOR TO A NON-CARRIER CUTTING STYLE, REMOVE ITEM 13 AND ATTACH TO THE LOCATION ON BACK SIDE OF THE HOUSING. REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.
- CUT TO LENGTH AT ASSEMBLY.

POSITION THE HOLD DOWN, ITEM 18, IN ORIENTATION 1 FOR GROUP 1 TERMINALS. REFER TO SHEET 2.



POSITION THE HOLD DOWN, ITEM 18, IN ORIENTATION 2 FOR GROUP 2 TERMINALS. REFER TO SHEET 2.



***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.

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

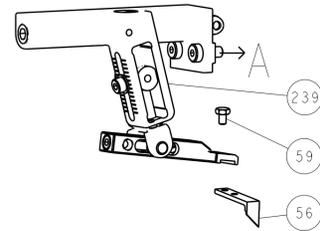
SET UP GAUGE	LOC	DIST	REVISIONS					
2119599-1	A	66	P	LTN	DESCRIPTION	DATE	OWN	APVD
			-	-	SEE SHEET 1	-	-	-

-	1	1	1	1	2119782-1	FINE ADJUST HEAD ASM, PACIFIC STYLE	251
-	-	-	1	-	2119640-1	PUSH ROD, AIR FEED	250
-	-	-	1	-	2079988-1	BUSHING, LCH5-12, MISUMI	249
-	1	1	1	1	1-22279-3	SPRING, COMPRESSION	246
-	1	1	1	1	2119082-5	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	1	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
-	-	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	-	-	2119740-2	TAG IDENTIFICATION	213
-	-	1	-	-	1901094-3	SPACER, FEEDER	198
-	-	-	2	-	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172
-	1	1	1	1	994969-1	MAGNET, RARE EARTH HIGH ENERGY	166
-	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	-	-	1	-	240638-1	SPRING, FEED FINGER	163
-	1	1	1	1	8-21084-1	O-RING, .801 ID, .070 DIA. MAT.	152
-	-	-	1	-	2119641-2	FEED CAM, AIR FEED	151
-	1	1	1	1	2119798-2	DETENT PIN	145
-	1	1	1	1	2079383-8	SCR, BHSC, RoHS (M4 X 16)	144
-	4	4	4	4	2168400-5	SHCS, LOW HEAD, RoHS, M4 X 20	143
-	-	-	-	1	2119653-2	FEED CAM, POST FEED	142
-	1	1	1	1	1-2119656-0	APPLICATOR BASIC ASSEMBLY, SF	141
-	1	1	1	1	2119650-1	RAM, ASIAN STYLE, SIDE FEED	140
-	1	1	1	1	2119092-2	BOLT, ADJUSTMENT	139
-	-	-	1	-	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854	137
-	-	-	1	-	2119799-1	HOLDER, FEED FINGER, AF	136
-	-	REF	-	-	SEE NOTE 4	MEMORY CHIP, PROGRAMMED	135
-	-	1	-	-	1633743-1	SERVO FEED LATCH ASM	133
-	1	1	1	1	1-18028-2	WASHER, FLAT, REG M4	119
-	-	REF	-	-	2119944-1	FEED FINGER ASSEMBLY, SF	117
-	1	1	1	1	455888-6	SPACER, CRIMPER	82
-	1	1	1	1	240641-9	SPACER	81
-	1	1	1	1	2119956-1	DOCUMENTATION PACKAGE	71
-	1	1	1	1	2119791-9	DEPRESSOR, WIRE	70
-	1	-	1	1	2119740-1	TAG IDENTIFICATION	67
-	2	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	1	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	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	-	-	1	1	1338685-1	PAWL, FEED	56
-	2	2	2	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	53
-	-	-	1	2	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	-	-	-	1	2119652-1	FEED CAM, PRE FEED	48
-	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	2119644-1	RAM WASHER, PRECISION	38
-	1	1	1	1	1752356-3	SUPPORT, TERMINAL	34
-	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	1	1	1	1	2161328-1	HEX HEAD, FLANGED, M5 x 8mm LONG	32
-	1	1	1	1	1320908-6	SPACER, STRIP GUIDE	30
-	1	1	1	1	2119959-1	ASSEMBLY, STRIP GUIDE	29
-	1	1	1	1	1320928-2	STRIP GUIDE	24
-	1	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
-	1	1	1	1	1-18028-2	WASHER, FLAT, REG M4	20
-	1	1	1	1	2119533-1	STRIPPER, SIDE FEED	19
-	1	1	1	1	2217529-1	TERMINAL HOLD DOWN	18
-	1	1	1	1	2119806-1	INSERT, SHEAR	13
-	1	1	1	1	3-22280-3	SPRING, COMPRESSION	12
-	1	1	1	1	1-356885-4	STOP, SHEAR	11
-	1	1	1	1	2119805-1	SHEAR HOLDER, FRONT	10
-	1	1	1	1	1803095-3	FLOATING SHEAR, FRONT	9
-	1	1	1	1	1-1338690-1	ANVIL, COMBINATION .055	8
-	1	1	1	1	1-240641-1	SPACER	7
-	1	1	1	1	2119757-4	DEPRESSOR, SHEAR	5
-	1	1	1	1	238011-9	BLOCK, CRIMPER SPACER	4
-	1	1	1	1	2-1633966-9	CRIMPER, INSULATION O	3
-	1	1	1	1	3-1633860-8	CRIMPER, WIRE	1

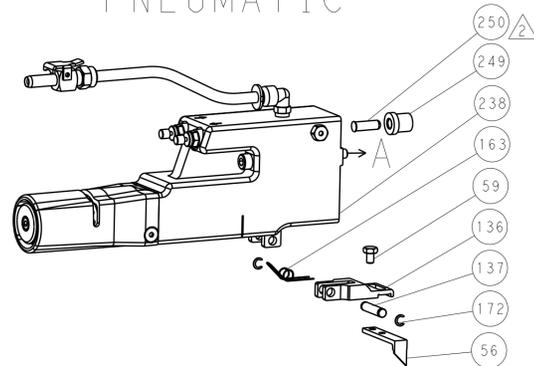
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		MATERIAL:		FINISH:		WEIGHT:		SCALE:	
mm	0 PLC	±									
	1 PLC	±									
	5 PLC	±									
	4 PLC	±									
	ANGLES	±									

REVISONS		DATE	OWN	APVD
A	66			
DESCRIPTION				
SEE SHEET 1				

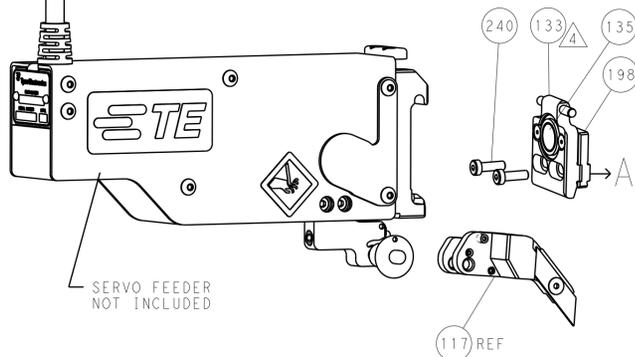
FEED TYPE MECHANICAL



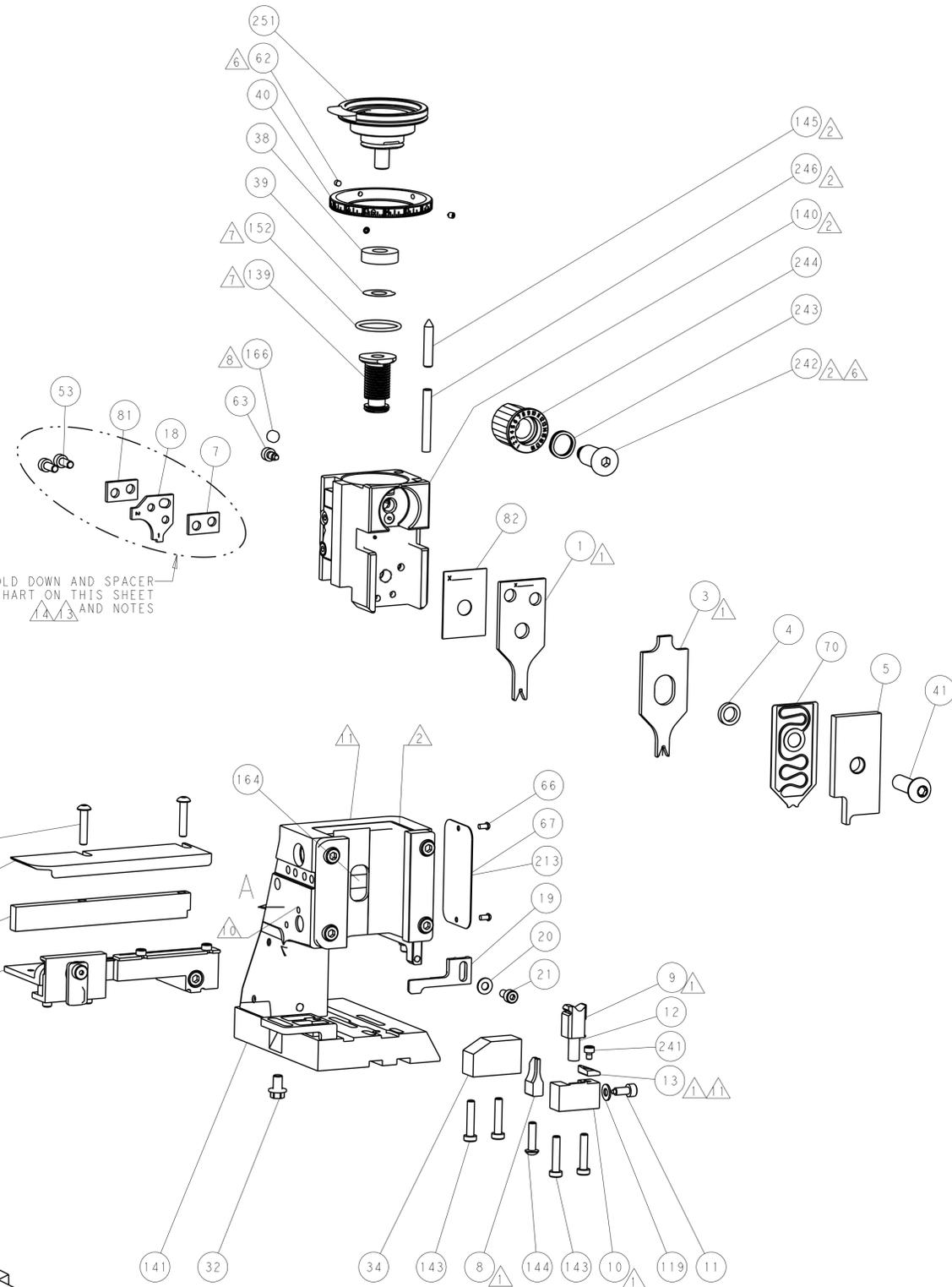
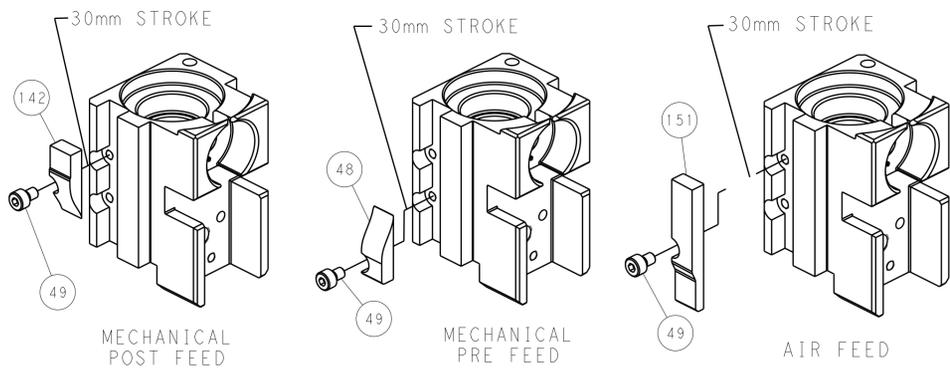
PNEUMATIC



SERVO LATCH PLATE

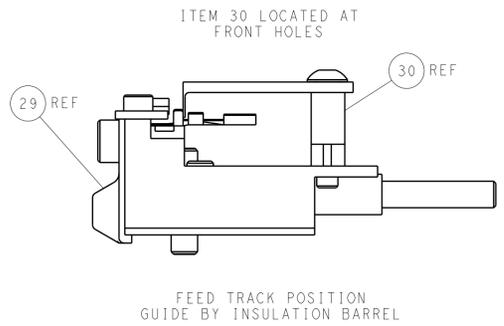
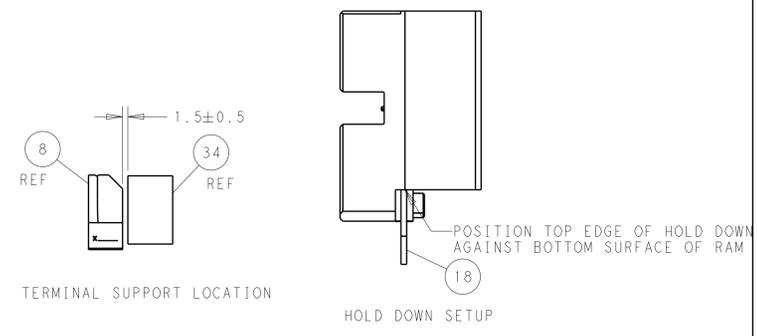


CAM POSITIONS



SEE TERMINAL HOLD DOWN AND SPACER SETUP CHART AND NOTES

TERMINAL HOLD DOWN & SPACER SETUP CHART		
GROUP 1	HOLD DOWN & SPACER TOOLING SETUP FOR TERMINALS:	<p>POSITION 1</p>
	963715-1 963716-1	
	963715-5 963716-2	
	963715-6 1-963716-2	
	1-963715-5 5-963716-1	
GROUP 2	HOLD DOWN & SPACER TOOLING SETUP FOR TERMINALS:	<p>POSITION 1</p>
	1452013-1	
	1-1452013-1	
	5-1452013-1	
	6-1452013-1	
GROUP 2	HOLD DOWN & SPACER TOOLING SETUP FOR TERMINALS:	<p>POSITION 2</p>
	968221-1 1703282-1	
	968221-5 1703282-2	
	968221-6 5-1703282-1	
	5-968221-1 5-1703282-2	
GROUP 2	HOLD DOWN & SPACER TOOLING SETUP FOR TERMINALS:	<p>POSITION 2</p>
	1241920-1	
	5-1241920-1	



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

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN B. WEAVER 31AUG2011 CHK G. HOFNER 31AUG2011 APVD T. ELBIN 31AUG2011	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±
	ANGLES	FINISH			
MATERIAL		WEIGHT		SIZE	CAGE CODE DRAWING NO
				A1	00779 C=2151491
Customer Accessible Production Drawing			SCALE	SHEET	REV
			1:2	4	4