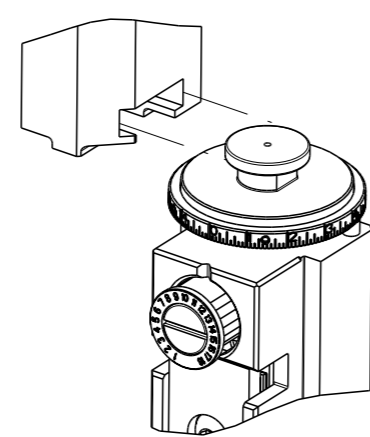


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150623-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2150623-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150623-1	C	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2150623-2	C	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150623-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	3.10 mm [.122]	F
INSUL	4.50 mm [.177]	F
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION			
TERMINAL NAME: FLAG CLIP 6.35			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
5.60-6.40 mm [.220-.252 IN]		∅2.40-3.50 mm [.094-.138 IN]	
TERMINAL APPLICATION SPECIFICATION	1544114		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
1544114-1	1544114-2	1544114-3	1544114-4

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
3.00mm2	2.25 +/- 0.03 [.089 +/- .001]	6.0
12 AWG	2.21 +/- 0.05 [.087 +/- .002]	6.5
2.50mm2	2.10 +/- 0.03 [.083 +/- .001]	7.3
14 AWG	1.93 +/- 0.05 [.076 +/- .002]	9.2
1.50mm2	1.80 +/- 0.03 [.071 +/- .001]	10.3
1.40mm2	1.75 +/- 0.03 [.069 +/- .001]	10.9
16 AWG	1.70 +/- 0.05 [.067 +/- .002]	11.7



- RECOMMENDED SPARE PARTS
- REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242.
- 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.
- TERMINAL LUBRICANT IS RECOMMENDED.
- 6. 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.

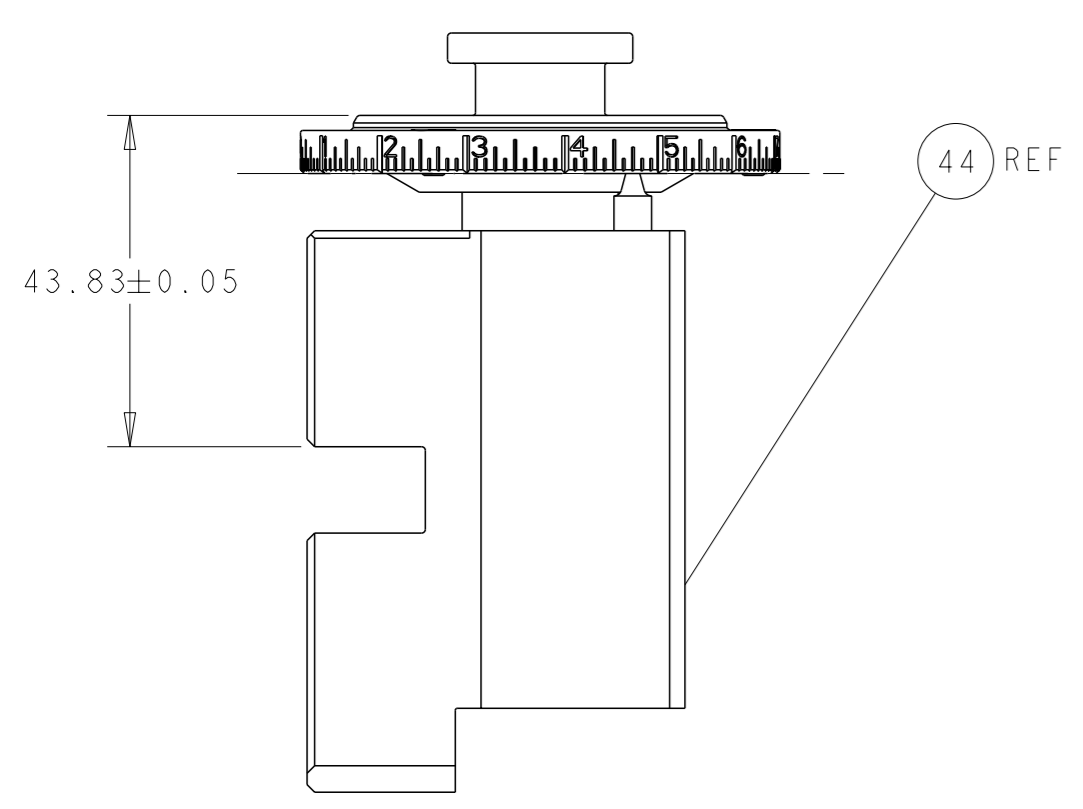
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		A		RELEASED	25JAN2018	RK	CT
		B		ECR-19-003381	02MAR2019	TB	CT
		C		ECR-19-006679	26APR2019	JAH	TE

-	1	-	1	-	2119640-1	PUSH ROD, AIR FEED	250	
-	1	-	1	-	1803259-1	BUSHING, FLANGED	249	
-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248	
-	1	1	1	1	2119082-3	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	2119580-1	MECHANICAL FEED ASSEMBLY	239	
-	1	-	1	-	2063440-1	AIR FEED MODULE	238	
-	1	1	1	1	1-18028-0	WASHER, FLAT, REG M8	192	
-	2	2	2	2	1-2168083-1	SCR, SKT HD CAP, RoHS, M3 X 6	191	
-	2	-	2	-	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172	
-	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164	
-	1	-	1	-	240638-1	SPRING, FEED FINGER	163	
-	1	-	1	-	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854	137	
-	1	1	1	1	2119955-2	ASSY, LUBRICATOR, END FEED	84	
-	1	1	1	1	455888-7	SPACER, CRIMPER	82	
-	1	1	1	1	1803607-2	DOCUMENTATION PACKAGE	71	
-	2	2	2	2	5018030-1	NUT, HEX, REG, RoHS, M3	70	
-	1	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	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	
-	-	1	-	1	2161924-1	FEED FINGER	58	
-	4	4	4	4	2168400-1	SHCS, LOW HEAD, RoHS, M4 X 12	57	
-	2	2	2	2	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	56	
-	2	2	2	2	3-18032-3	SCR, SET, FLT PNT, M3 X 20.0	55	
-	2	2	2	2	986965-8	NUT, LOCK, HEX, TORQUE (M4)	53	
-	1	-	1	-	2161920-1	NARROW PAWL, EF, AIR	51	
-	1	2	1	2	18023-9	SCR, SKT HD CAP M4 X 6.0	49	
-	-	1	-	1	2119652-1	FEED CAM, PRE FEED	48	
-	-	1	-	1	2119653-1	FEED CAM, POST FEED	47	
-	1	1	1	1	2119655-5	APPLICATOR BASIC ASSEMBLY, EF	46	
-	1	1	1	1	1803517-1	RAM ASSEMBLY, EF ATLANTIC	44	
-	1	1	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41	
-	8	8	8	8	1-18028-2	WASHER, FLAT, REG M4	33	
-	2	2	2	2	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	31	
-	2	2	2	2	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	29	
-	1	1	1	1	690455-2	STRIPPER, FRONT CASTING	27	
-	2	2	2	2	1-2168083-6	SCR, SKT HD CAP, RoHS, M4 X 35	25	
-	1	1	1	1	2161922-4	PLATE, STRIP GUIDE	24	
-	2	2	2	2	22281-8	SPRING, COMPRESSION	22	
-	1	1	1	1	1633168-2	ARM, STOCK DRAG	21	
-	1	1	1	1	464452-6	DRAG, STOCK	20	
-	1	1	1	1	2-1901259-0	GUIDE, LOWER STRIP	19	
-	1	1	1	1	7-1901695-5	STRIP GUIDE, FRONT	18	
-	4	4	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17	
-	1	1	1	1	240644-5	PLATE, REAR SHEAR	11	
-	2	2	2	2	6-240645-0	SPACER, SHEAR PLATE	10	
-	1	1	1	1	1-240642-8	PLATE, FRONT SHEAR	9	
-	1	2	2	1	1	5-1803060-9	ANVIL, COMBINATION, END FEED	8
-	1	1	1	1	1-469634-8	BLADE, SLUG	7	
-	-	-	-	-	-	-	6	
-	1	1	1	1	4-240641-3	SPACER	5	
-	1	1	1	1	1-238011-0	BLOCK, CRIMPER SPACER	4	
-	1	2	2	1	1	4-1803223-3	CRIMPER, INSULATION F PREMIUM	3
-	1	1	1	1	2-455888-7	SPACER, CRIMPER	2	
-	1	2	2	1	1	1803688-1	CRIMPER, WIRE	1
-	77	72	71	2	1	PART NO	DESCRIPTION	ITEM NO

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

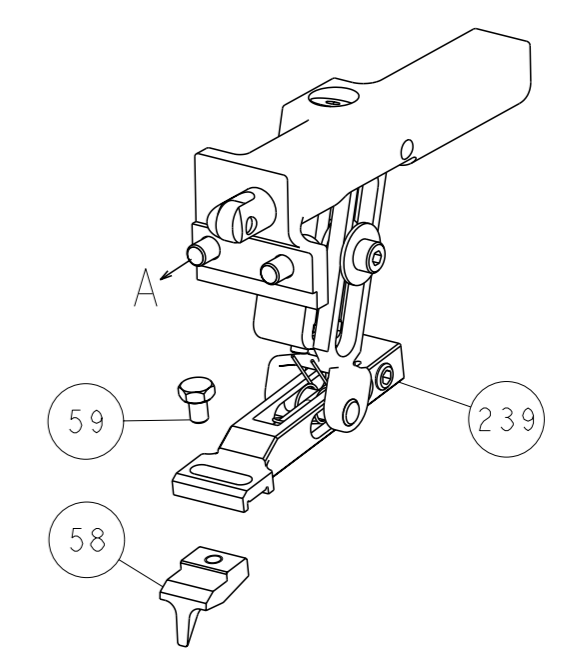
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mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	SIZE: A1		CAGE CODE: 00779		DRAWING NO: 2150623		
MATERIAL:	FINISH:		WEIGHT:		SCALE: 1:1		SHEET: 1 of 4		REV: C		RESTRICTED TO:	
Customer Accessible Production Drawing												

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

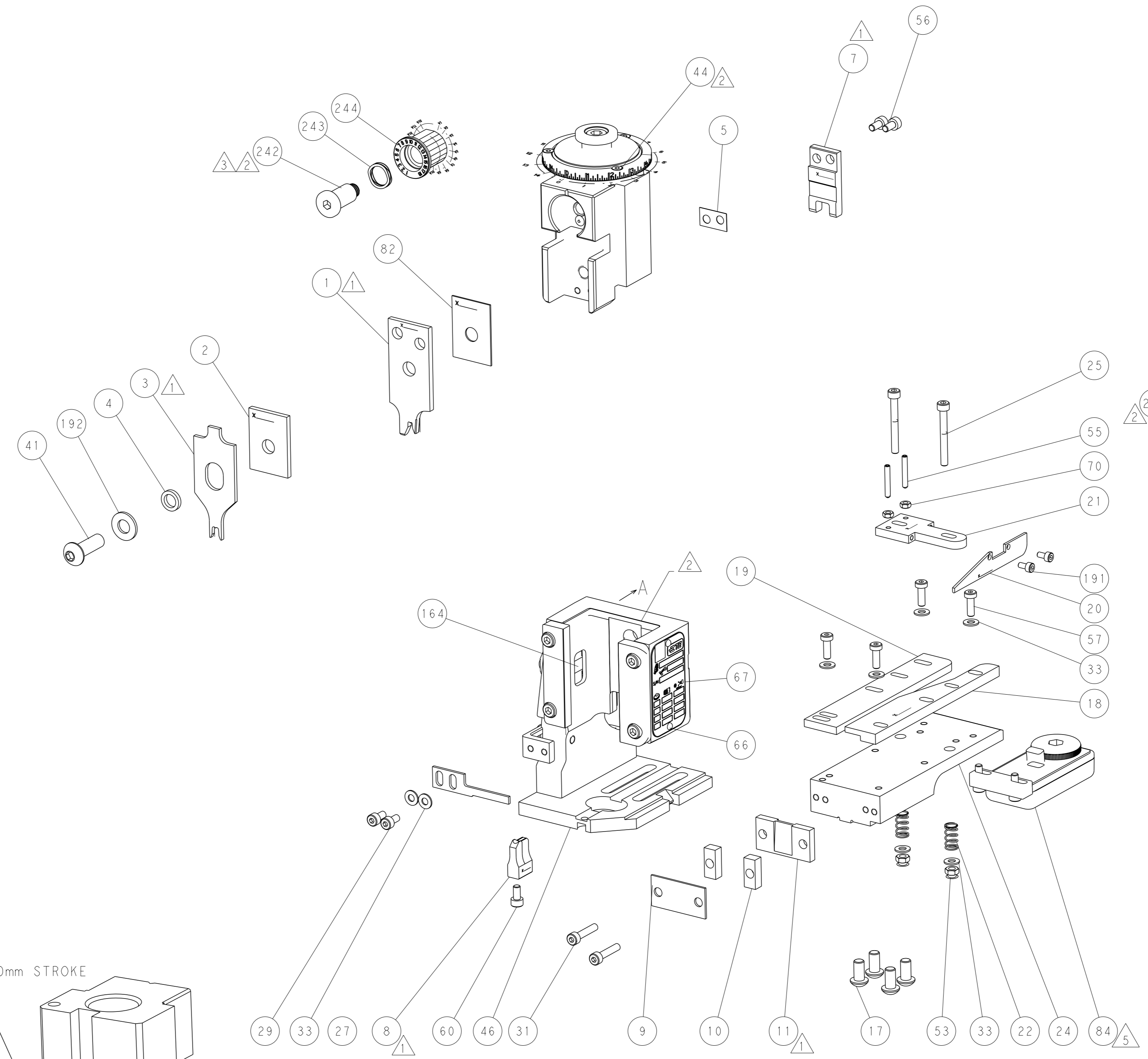
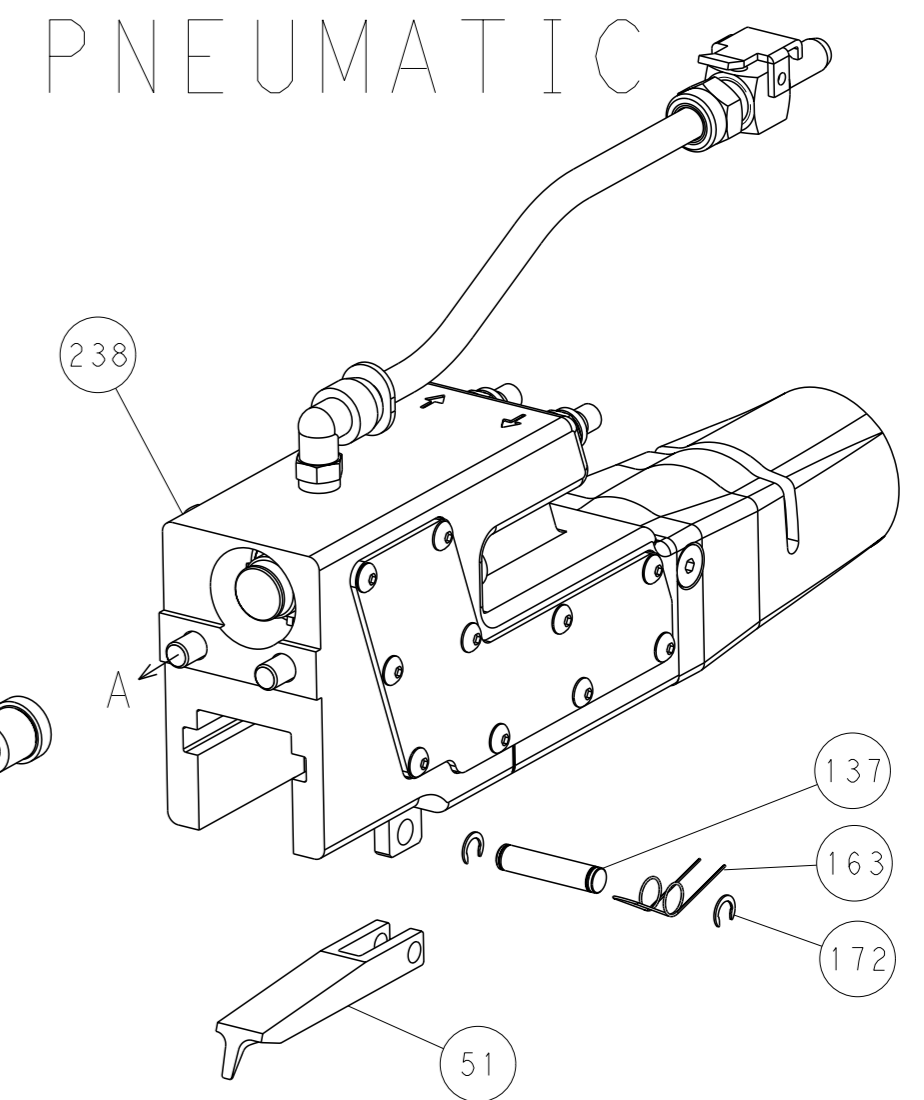


RAM SET-UP

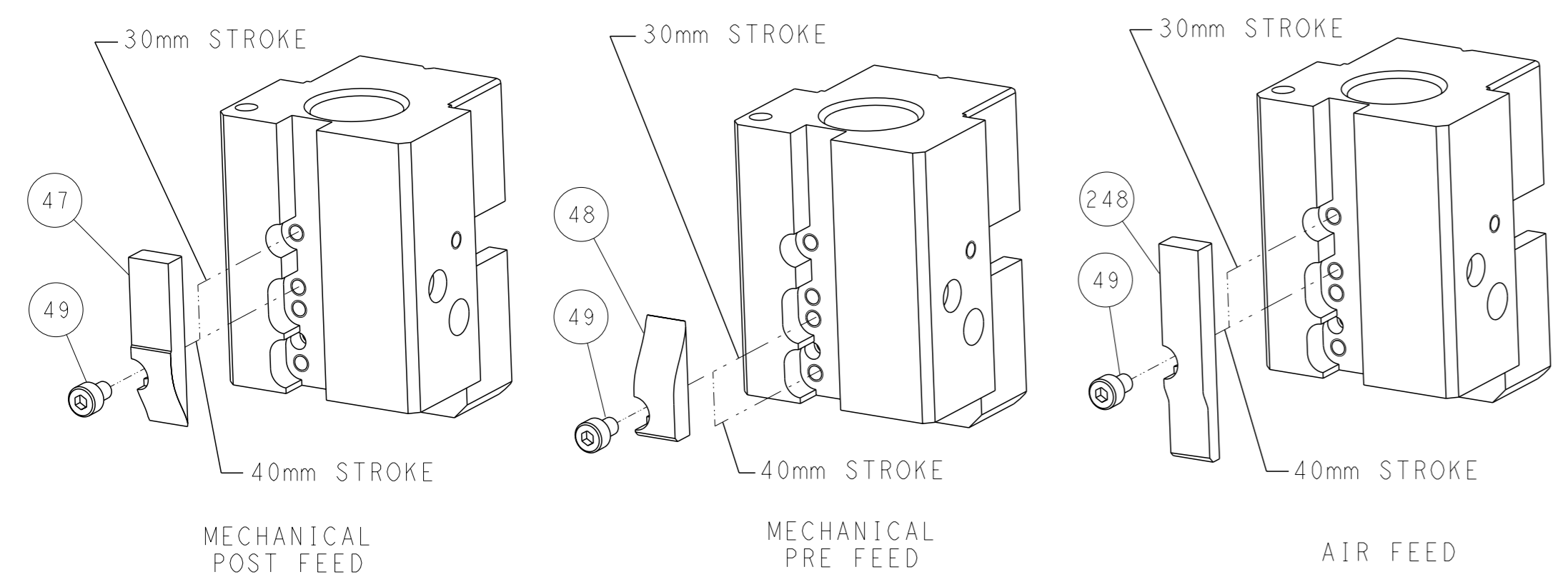
FEED TYPE
MECHANICAL



PNEUMATIC



CAM POSITIONS

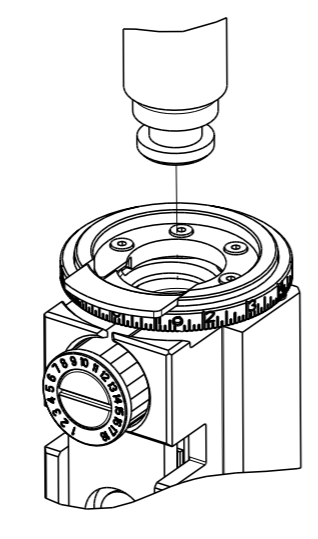


ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH ±		OWN R. KNEPPER 14-NOV-17 CHK C. TOPPER 14-NOV-17 APVD J. DEGRANGE 14-NOV-17 PRODUCT SPEC APPLICATION SPEC WEIGHT MATERIAL		NAME Ocean End Feed Applicator SIZE CAGE CODE DRAWING NO. A1 00779 ©=2150623 RESTRICTED TO	
Customer Accessible Production Drawing				SCALE 1:1	SHEET 2 of 4	REV C	

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150623-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2150623-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150623-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
 INTERFACE ADAPTER



APPLICATOR DATA

CRIMP	SIZE	TYPE
WIRE	3.10 mm [1.221]	F
INSUL	4.50 mm [1.771]	F

APPL INSTRUCTIONS
 408-35043

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION

TERMINAL NAME: FLAG CLIP 6.35

WIRE STRIP LENGTH	INSULATION DIAMETER RANGE
5.60-6.40 mm [1.220-.252 IN]	Ø2.40-3.50 mm [1.094-.138 IN]

TERMINAL APPLICATION SPECIFICATION

TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
1544114-1	1544114-2	1544114-3	1544114-4

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
3.00mm2	2.25 +/- 0.03 [1.089 +/- .001]	6.0
12 AWG	2.21 +/- 0.05 [1.087 +/- .002]	6.5
2.50mm2	2.10 +/- 0.03 [1.083 +/- .001]	7.3
14 AWG	1.93 +/- 0.05 [1.076 +/- .002]	9.2
1.50mm2	1.80 +/- 0.03 [1.071 +/- .001]	10.3
1.40mm2	1.75 +/- 0.03 [1.069 +/- .001]	10.9
16 AWG	1.70 +/- 0.05 [1.067 +/- .002]	11.7

- RECOMMENDED SPARE PARTS
- REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242.
- 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.
- TERMINAL LUBRICANT IS RECOMMENDED.
- 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.

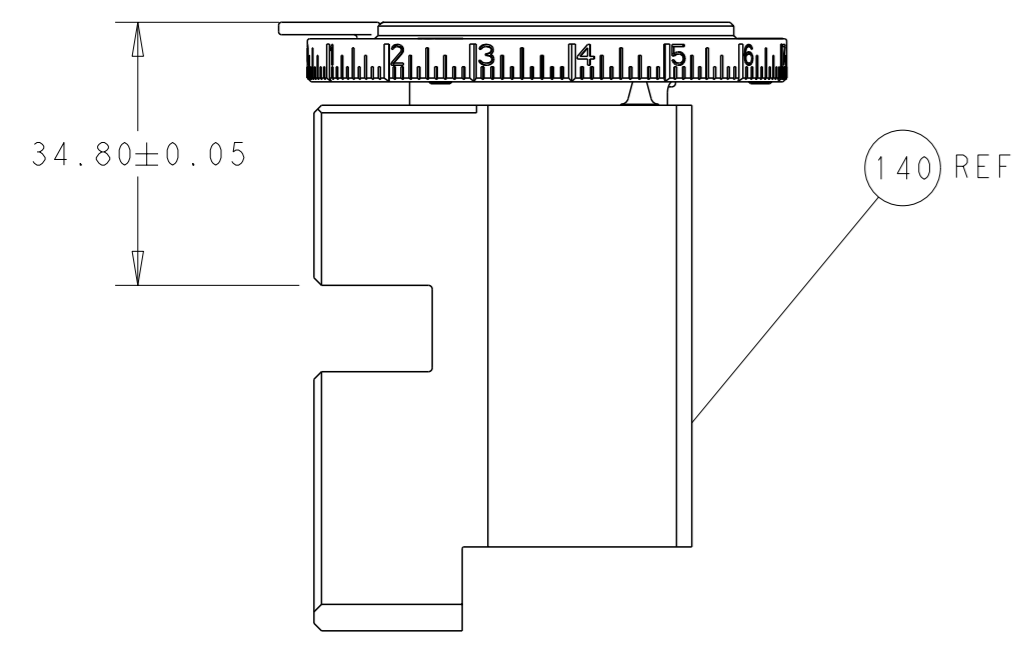
LOC	DIST	REV	DATE	BY	APPV
A	66				

REV	DATE	DESCRIPTION	ITEM NO		
-	1	-	2119640-1	PUSH ROD, AIR FEED	250
-	1	-	1803259-1	BUSHING, FLANGED	249
-	1	1	2119082-3	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
3	-	1	2119083-1	RETAINER, INSULATION DIAL	242
-	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	1	-	2063440-1	AIR FEED MODULE	238
-	1	1	1-18028-0	WASHER, FLAT, REG M8	192
-	2	2	1-2168083-1	SCR, SKT HD CAP, RoHS, M3 X 6	191
-	4	4	2079383-9	SCR, BHSC, RoHS (M6 X 20)	186
-	2	-	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172
-	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	1	-	240638-1	SPRING, FEED FINGER	163
-	1	-	2119641-2	FEED CAM, AIR FEED	152
-	1	1	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	144
-	-	1	2119653-2	FEED CAM, POST FEED	142
-	1	1	2119655-6	APPLICATOR BASIC ASSEMBLY, EF	141
-	1	1	1803518-1	RAM ASSEMBLY, EF PACIFIC	140
-	1	-	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854	137
5	-	1	2119955-2	ASSY, LUBRICATOR, END FEED	84
-	1	1	455888-7	SPACER, CRIMPER	82
-	1	1	1803607-2	DOCUMENTATION PACKAGE	71
-	2	2	5018030-1	NUT, HEX, REG, RoHS, M3	70
-	1	1	2119740-1	TAG, IDENTIFICATION	67
-	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	-	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	-	1	2161924-1	FEED FINGER	58
-	4	4	2168400-1	SHCS, LOW HEAD, RoHS, M4 X 12	57
-	2	2	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	56
-	2	2	3-18032-3	SCR, SET, FLT PNT, M3 X 20.0	55
-	2	2	986965-8	NUT, LOCK, HEX, TORQUE (M4)	53
-	1	-	2161920-1	NARROW 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
-	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	690455-2	STRIPPER, FRONT CASTING	27
-	2	2	1-2168083-6	SCR, SKT HD CAP, RoHS, M4 X 35	25
-	1	1	2161922-4	PLATE, STRIP GUIDE	24
-	2	2	22281-8	SPRING, COMPRESSION	22
-	1	1	1633168-2	ARM, STOCK DRAG	21
-	1	1	464452-6	DRAG, STOCK	20
-	1	1	2-1901259-0	GUIDE, LOWER STRIP	19
-	1	1	7-1901695-5	STRIP GUIDE, FRONT	18
1	-	1	240644-5	PLATE, REAR SHEAR	11
1	-	2	6-240645-0	SPACER, SHEAR PLATE	10
1	-	1	1-240642-8	PLATE, FRONT SHEAR	9
1	-	1	5-1803060-9	ANVIL, COMBINATION, END FEED	8
1	-	1	1-469634-8	BLADE, SLUG	7
-	-	-	-	-	6
-	1	1	4-240641-3	SPACER	5
-	1	1	1-238011-0	BLOCK, CRIMPER SPACER	4
1	-	1	4-1803223-3	CRIMPER, INSULATION F PREMIUM	3
-	1	1	2-455888-7	SPACER, CRIMPER	2
1	-	1	1803688-1	CRIMPER, WIRE	1
-	-	-	-	-	0

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

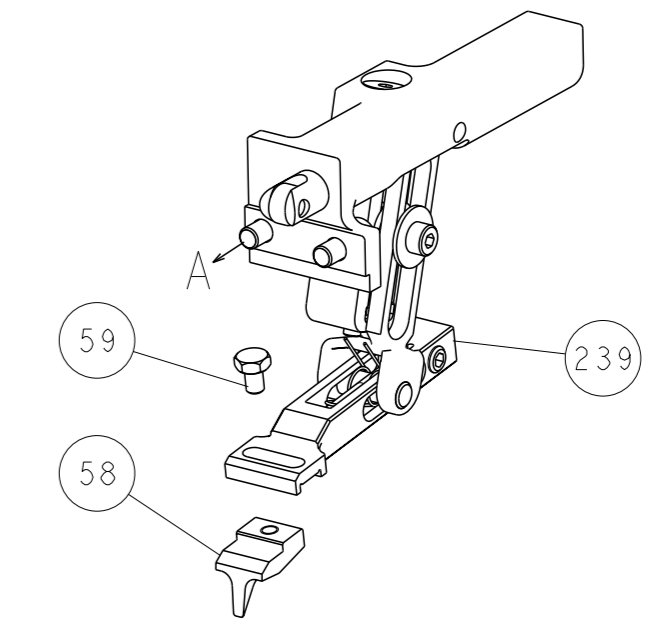
DIMENSIONS:	TOLERANCES UNLESS OTHERWISE SPECIFIED:	APPROVED:	DATE:
mm	0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±	R. KNEPPER C. TOPPER J. DEGRANGE	14-NOV-17 14-NOV-17 14-NOV-17
MATERIAL:	FINISH:	WEIGHT:	SCALE: 1:1

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

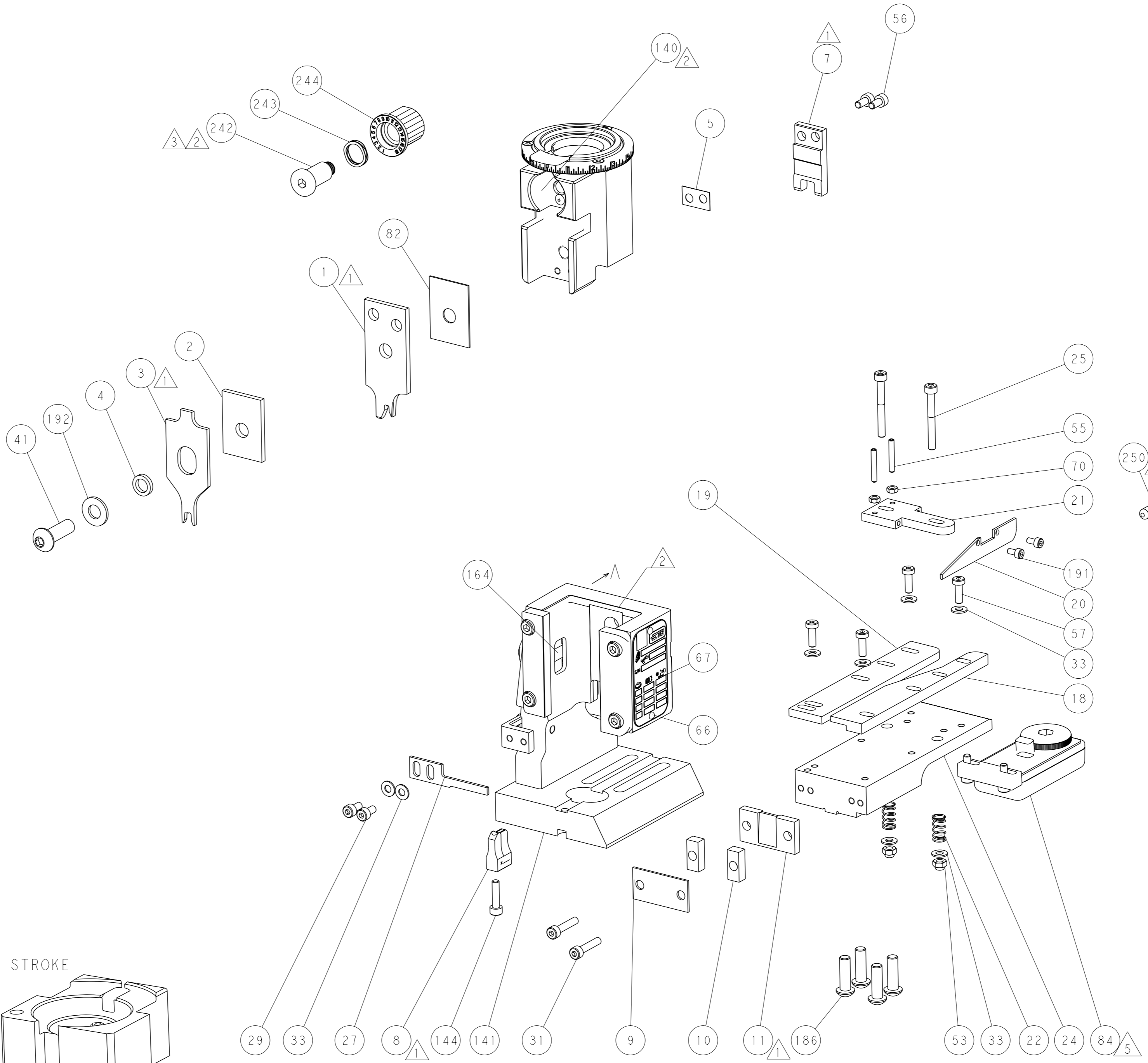
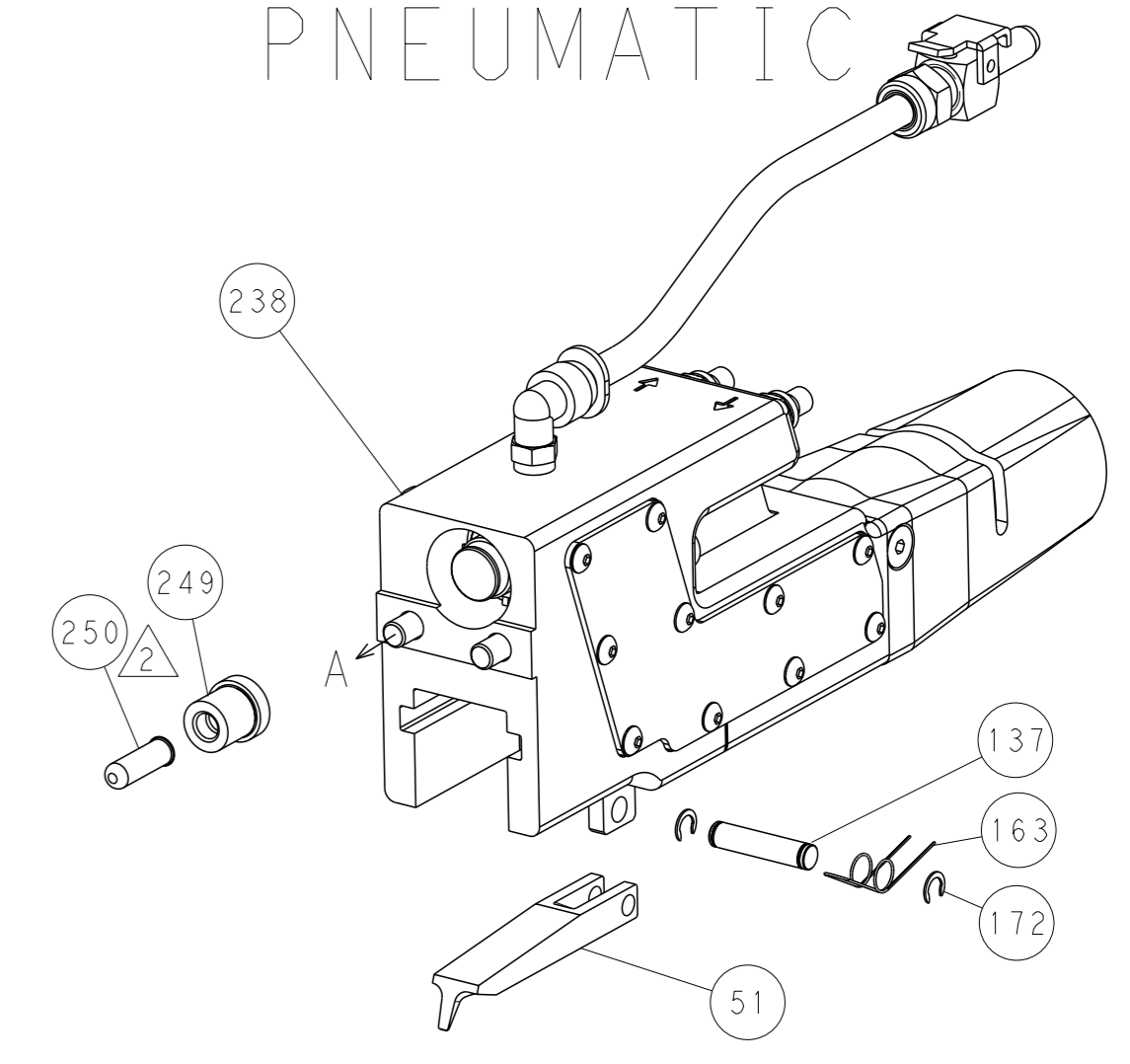


RAM SET-UP

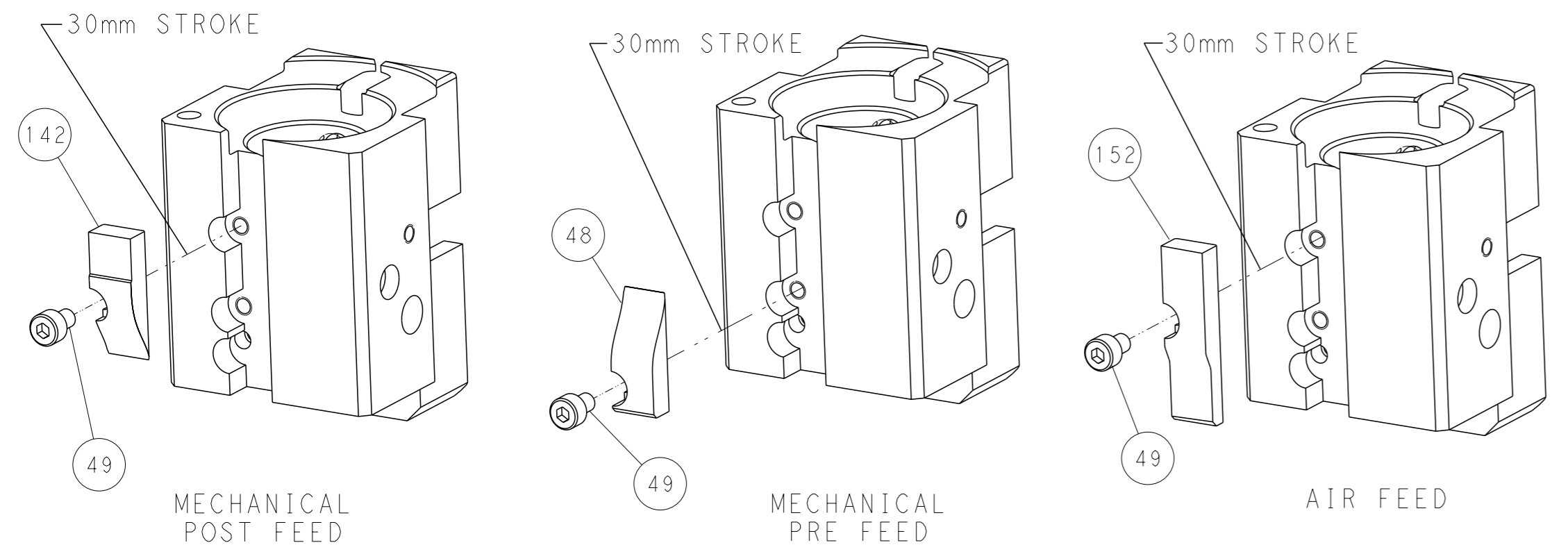
FEED TYPE
MECHANICAL



PNEUMATIC



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 ±		OWN R. KNEPPER 14-NOV-17 CHK C. TOPPER 14-NOV-17 APVD J. DEGRANGE 14-NOV-17 PRODUCT SPEC APPLICATION SPEC WEIGHT Customer Accessible Production Drawing		NAME Ocean End Feed Applicator SIZE CAGE CODE DRAWING NO. A1 00779 C-2150623 SCALE 1:1 SHEET 4 OF 4 REV C		RESTRICTED TO	
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