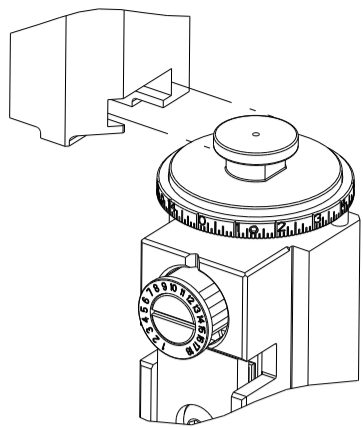









8		7	
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20		20	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150730-2	D	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150730-2	D	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150730-7	A	CRIMP TOOLING KIT	-



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	4.83 mm [ .190 ]	F
INSUL	6.35 mm [ .250 ]	F
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: TERMINAL			
WIRE STRIP LENGTH 5.43-6.19 mm [.214-.244 IN]		INSULATION DIAMETER RANGE Ø3.30-4.57 mm [.130-.180 IN]	
TERMINAL APPLICATION 		114-2084	
SPECIFICATION		-	
TERMINALS APPLIED 			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
40604-1	40973	40960	

WIRE SIZE			CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING 
12 AWG			3.07+/-0.05 [.121+/- .002]		5.8
14 AWG			2.85+/-0.05 [.112+/- .002]		8.7

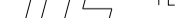



1. RECOMMENDED SPARE PARTS
2. REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
3. APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 180.  
APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242.
4. CRIMP HEIGHT REFERENCE SETTING WAS THE SETTING USED WHEN 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.
7. TERMINAL LUBRICANT IS RECOMMENDED.

```
*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.
```

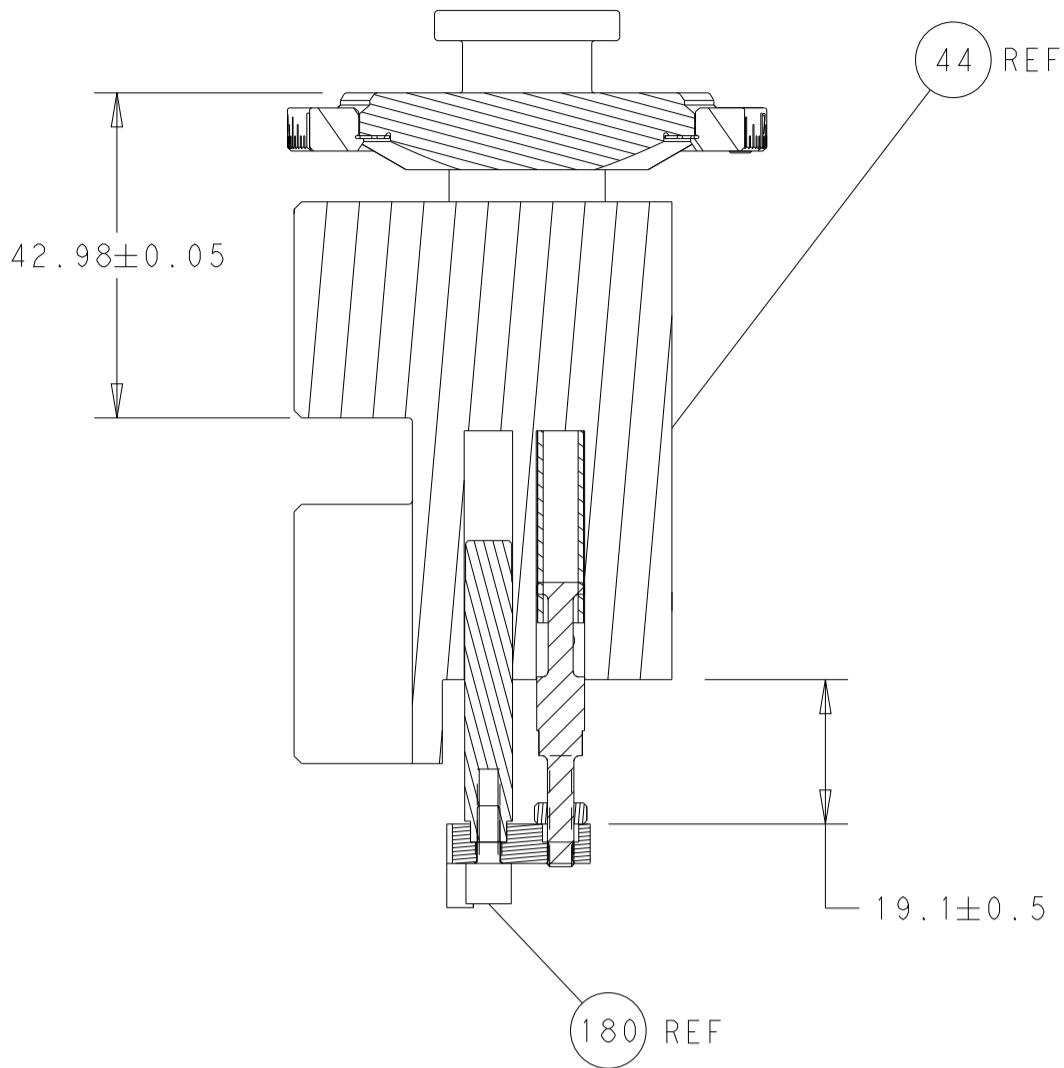
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			B	ECR-20-000495	13JAN2020	FZ	TE
			C	ECR-20-002439	19FEB2020	JAH	RK
			D	ECR-22-144711	04JUL2022	FZ	JAH

	-	1	1	2119641-1	FEED CAM, AIR FEED	248
	-	1	1	2119082-7	CAM, SNAIL, INSULATION ADJUSTMENT	244
	-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
3	-	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
3	-	1	1	1752354-6	STANDOFF, HOLD-DOWN	180
	-	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
7	-	1	1	2119955-2	ASSY, LUBRICATOR, END FEED	84
	-	1	1	455888-7	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	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	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52
	-	1	1	2063961-9	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	1803517-1	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	1752371-5	PLATE, STRIP GUIDE	24
	-	2	2	2-22281-3	SPRING, COMPRESSION	22
	-	1	1	1803292-4	DRAG	20
	-	1	1	1901696-6	STRIP GUIDE, REAR	19
	-	1	1	1901695-6	STRIP GUIDE, FRONT	18
	-	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17
	-	1	1	6-240641-9	SPACER	16
	-	1	1	1752360-1	SPACER, HOLD-DOWN	13
1	-	1	1	240644-1	PLATE, REAR SHEAR	11
	-	2	2	4-240645-7	SPACER, SHEAR PLATE	10
1	-	1	1	240642-1	PLATE, FRONT SHEAR	9
1	1	2	1	7-1803074-7	ANVIL, COMBINATION, END FEED	8
1	-	1	1	1-1803366-5	BLADE, SLUG -	7
	-	-	-	-	-	6
	-	1	1	1-240641-2	SPACER	5
	-	1	1	1-238011-4	BLOCK, CRIMPER SPACER	4
1	1	2	1	6-2119582-8	CRIMPER, INSULATION F PREMIUM	3
	-	1	1	455888-9	SPACER, CRIMPER	2
1	1	2	1	9-1803241-2	CRIMPER, WIRE F	1
-77-72-2				PART NO	DESCRIPTION	ITEM NO

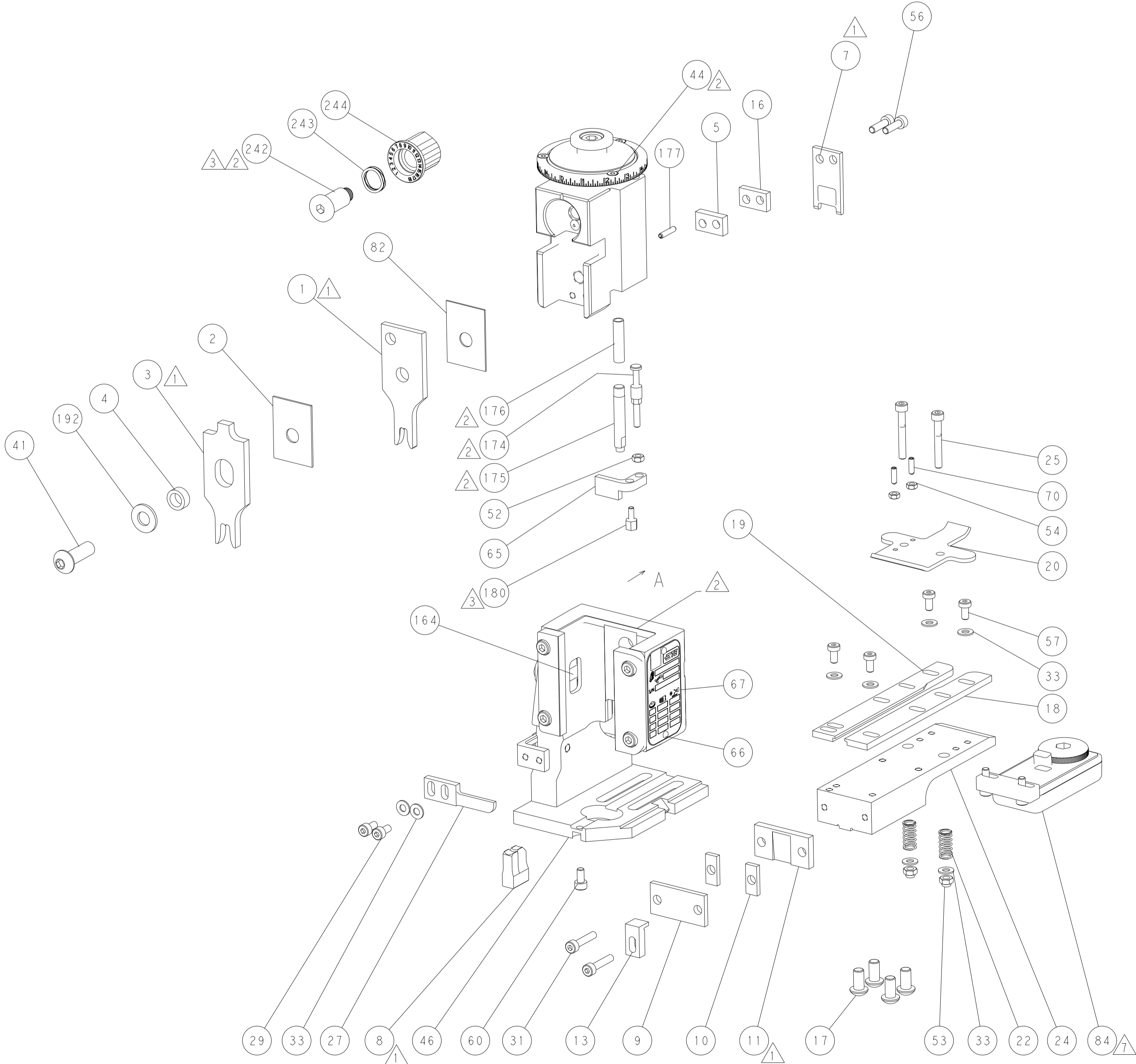
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DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH		NAME Ocean End Feed Applicator - APPLICATION SPEC	
		WEIGHT -		SIZE CAGE CODE DRAWING NO RESTRICTED TO A   00779 C=2150730 -	
MATERIAL -		Customer Accessible Production Drawing		SCALE 1:1 SHEET 1 OF 4 REV D	

SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

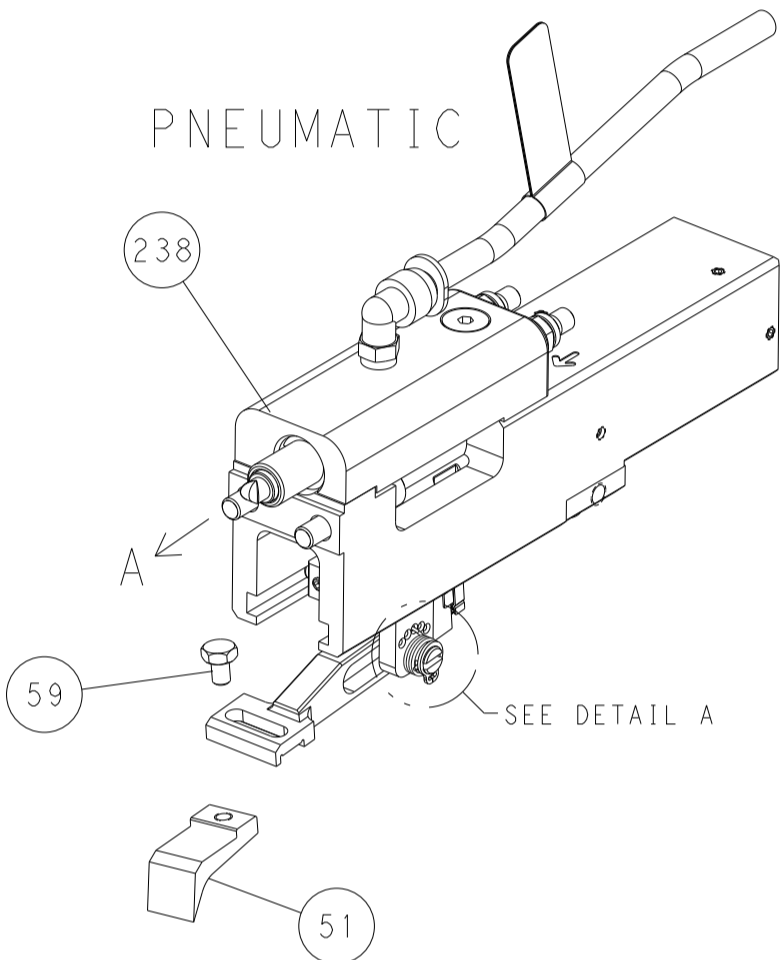
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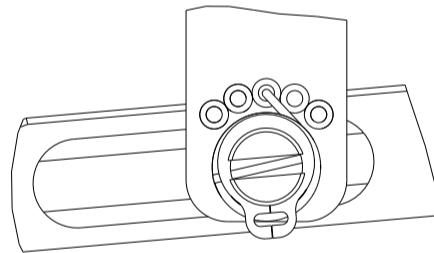
RAM AND HOLDDOWN SET-UP



FEED TYPE

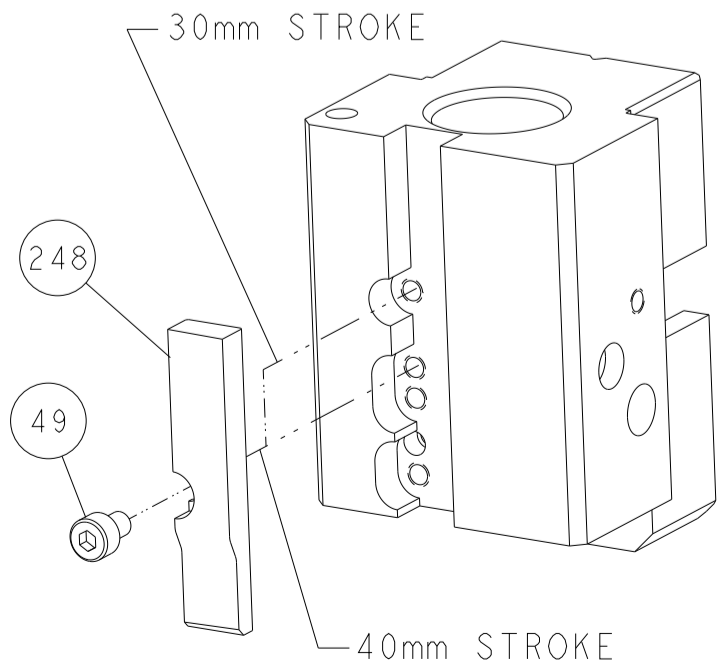


FEED SPRING SETTING POSITION



DETAIL A

CAM POSITION



AIR FEED

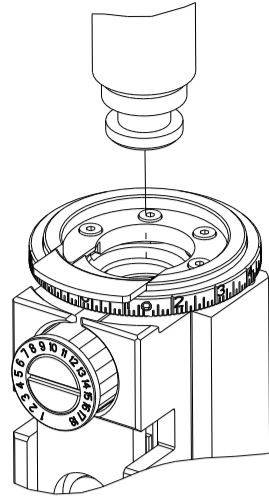
ATLANTIC VERSION  
Shown on sheets 1 of 4 & 2 of 4  
(Pacific version shown on sheets 3 of 4 & 4 of 4)

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				CHK K. ZHANG 04JUL2018		
				APVD K. ZHANG 04JUL2018	NAME Ocean End Feed Applicator	
				PRODUCT SPEC		
				APPLICATION SPEC		
				WEIGHT		
				Customer Accessible Production Drawing		
				SCALE	1:1	SHEET 2 of 4
				REV	D	





SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

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PART NUMBER	REVISION	DESCRIPTION
2-2150730-2	D	FINE CRIMP HEIGHT ADJUST
7-2150730-7	A	CRIMP TOOLING KIT
		FEED TYPE
		PNEUMATIC
		-

PACIFIC VERSION TERMINATOR  
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	4.83 mm [ .190 ]	F
INSUL	6.35 mm [ .250 ]	F
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: TERMINAL			
WIRE STRIP LENGTH 5.43-6.19 mm [.214-.244 IN]			INSULATION DIAMETER RANGE Ø3.30-4.57 mm [.130-.180 IN]
TERMINAL APPLICATION SPECIFICATION		114-2084	-
		-	-
TERMINALS APPLIED  			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
40604-1	40973	40960	

WIRE SIZE		CRIMP HEIGHT mm [ INCH ]		CRIMP HEIGHT REFERENCE SETTING	
12 AWG		3.07+/-0.05 [ .121+/- .002 ]		5.8	
14 AWG		2.85+/-0.05 [ .112+/- .002 ]		8.7	



RECOMMENDED SPARE PARTS

REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.

APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 180. 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.

5. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.

TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.

TERMINAL LUBRICANT IS RECOMMENDED.

\*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)

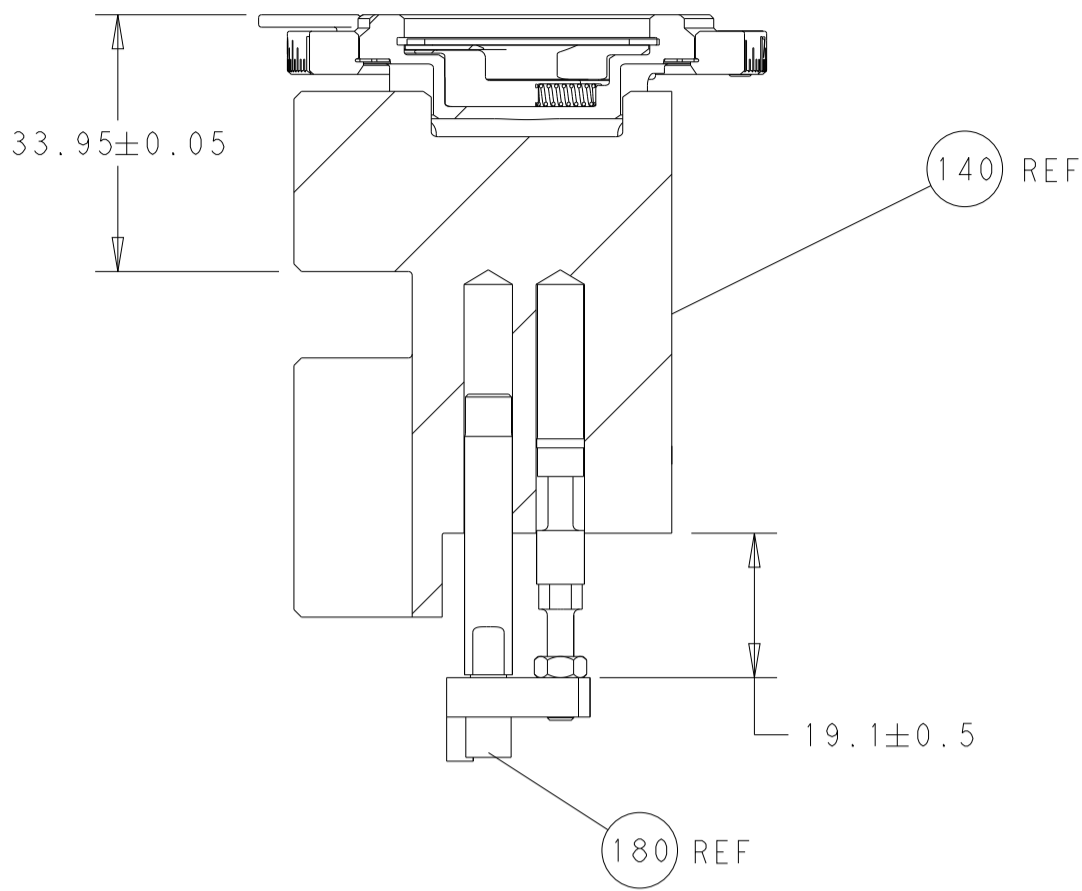
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	-	1	2119082-7	CAM, SNAIL, INSULATION ADJUSTMENT	244
	-	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
3	-	1	2119083-1	RETAINER, INSULATION DIAL	242
	-	1	2844940-4	AIR FEED MODULE	238
	-	1	1-18028-0	WASHER, FLAT, REG M8	192
	-	4	2079383-9	SCR, BHSC, RoHS (M6 X 20)	186
3	-	1	1752354-6	STANDOFF,HOLD-DOWN	180
	-	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
7	-	1	2119955-2	ASSY, LUBRICATOR, END FEED	84
	-	1	455888-7	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	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	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52
	-	1	2063961-9	FEED FINGER	51
	-	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	1752371-5	PLATE, STRIP GUIDE	24
	-	2	2-22281-3	SPRING, COMPRESSION	22
	-	1	1803292-4	DRAG	20
	-	1	1901696-6	STRIP GUIDE, REAR	19
	-	1	1901695-6	STRIP GUIDE, FRONT	18
	-	1	6-240641-9	SPACER	16
	-	1	1752360-1	SPACER,HOLD-DOWN	13
1	-	1	240644-1	PLATE, REAR SHEAR	11
	-	2	4-240645-7	SPACER, SHEAR PLATE	10
1	-	1	240642-1	PLATE, FRONT SHEAR	9
1	1	1	7-1803074-7	ANVIL, COMBINATION, END FEED	8
1	-	1	1-1803366-5	BLADE, SLUG -	7
	-	-	-	-	6
	-	1	1-240641-2	SPACER	5
	-	1	1-238011-4	BLOCK, CRIMPER SPACER	4
1	1	1	6-2119582-8	CRIMPER, INSULATION F PREMIUM	3
	-	1	455888-9	SPACER, CRIMPER	2
1	1	1	9-1803241-2	CRIMPER, WIRE F	1
	-77-22		PART NO	DESCRIPTION	ITEM NO

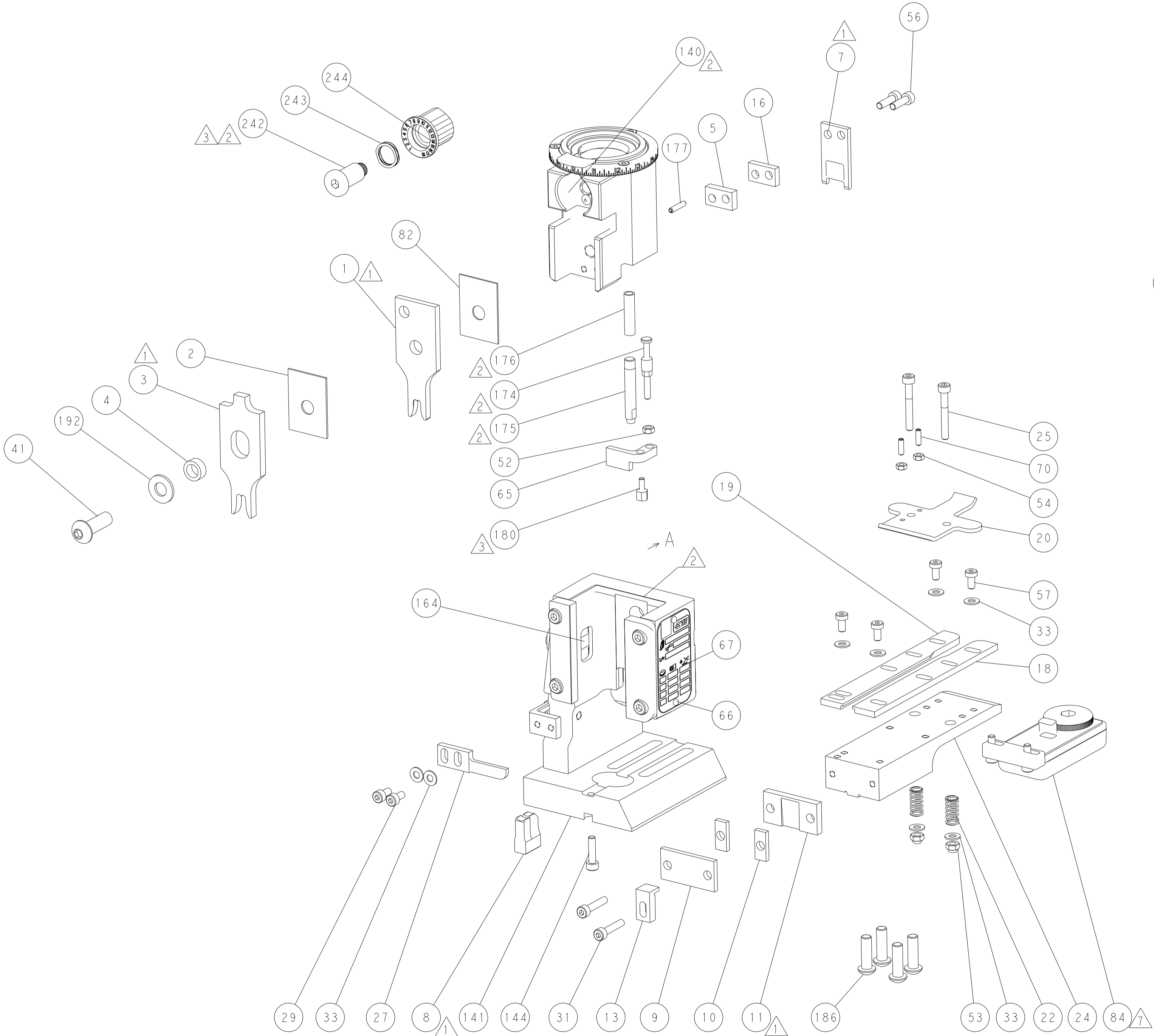
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CHK K. ZHANG 04JUL2018				NAME	Ocean End Feed Applicator			
APVD K. ZHANG 04JUL2018				PRODUCT SPEC				
				APPLICATION SPEC				
MATERIAL -				WEIGHT -	A   00779 ©=2150730			
					Customer Accessible Production Drawing			
					SCALE 1:1 SHEET 3 OF 4 REV D			

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

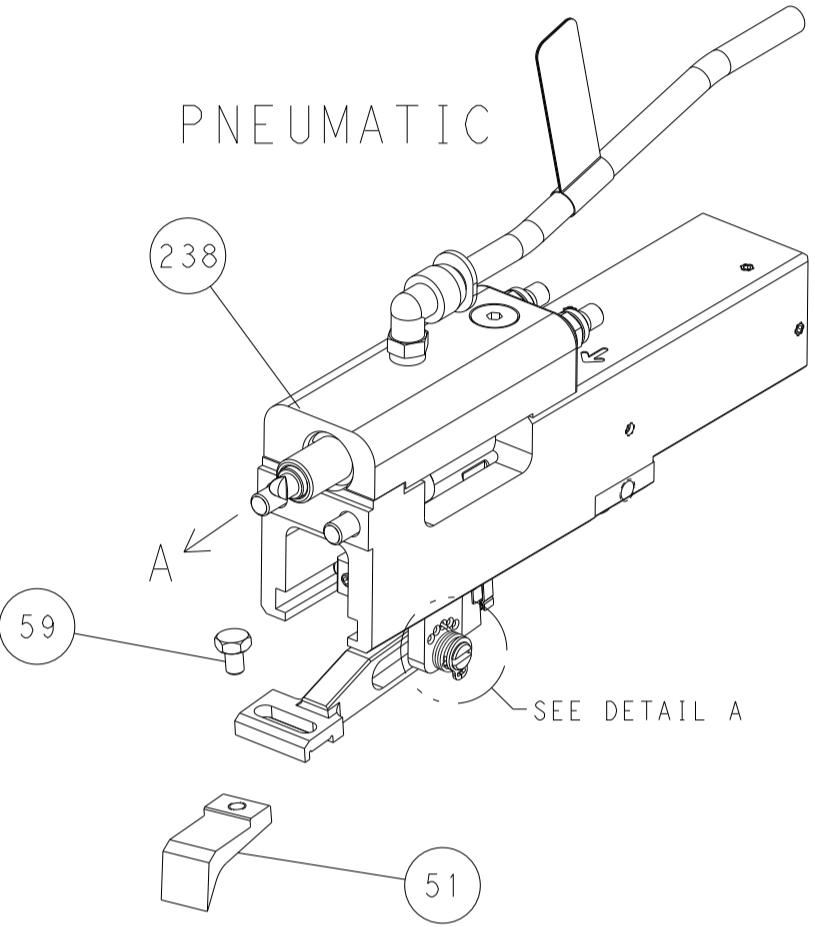
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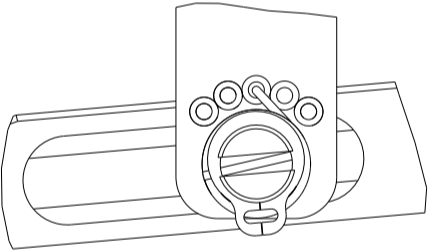
RAM AND HOLDDOWN SET-UP



FEED TYPE

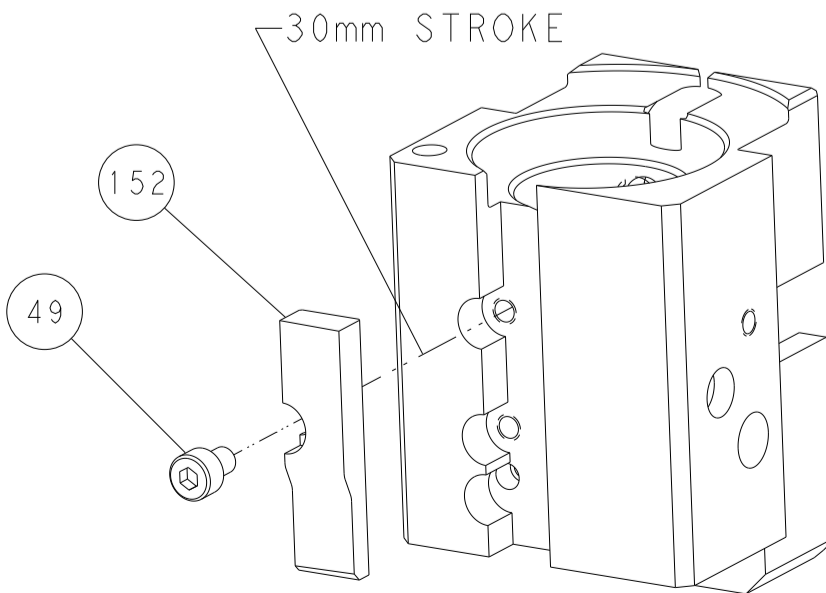


FEED SPRING SETTING POSITION





DETAIL A

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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TOLERANCES UNLESS OTHERWISE SPECIFIED:				CHK K. ZHANG 04JUL2018									
DIMENSIONS:				APVD K. ZHANG 04JUL2018	NAME Ocean End Feed Applicator								
mm				PRODUCT SPEC									
				APPLICATION SPEC									
0 PLOC ±.1				SIZE A   00779 C=2150730									
1 PLOC ±.1													
2 PLOC ±.1													
3 PLOC ±.1													
4 PLOC ±.1													
ANGLES ±.1				RESTRICTED TO									
FINISH													
MATERIAL									WEIGHT -				
-													
-													
Customer Accessible Production Drawing				SCALE 1:1 SHEET 4 OF 4 REV D									