





Д	APPLICATOR DATA	Д
CRIMP	SIZE	TYPE
WIRE	2.03 mm [.080]	F
INSUL	-	_
	INSTRUCTIONS	
	408-10390	

TERMINA	AL DATA:	LAT TE	ERMINAL		ΤE	CRIMP	SPECI	FICATIO) N
TERMINA	AL NAME:	CLIP	TERMINA	AL					
WIRE	STRIP L	ENGTH			INSULAT	ION DI	AMETER	RANGE	
5.34	-6.10 mm [. 210 24	0		\emptyset				
TERMINA APPLICA	LTION	I	NONE		-			-	
SPECIFI			-		-			-	
TERMI	NALS AF	PPLIED) 12						
TE TE	RMINAL	LAT	TERMINAL		TE TERMIN	IAL -	LAT	TERMINAL	
2318	304-1	21	000 110						

WIRE SIZE 🕸 T	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT 9 REFERENCE SETTING
1.00mm2	1.44+/-0.05 [.057+/002]	3.5
0.75mm2	1.33+/-0.05 [.052+/002]	4.8
0.50mm2	1.23+/-0.05 [.048+/002]	5.7



1 RECOMMENDED SPARE PARTS

2 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: 8-2150811-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150811-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150811-5

5. ADJUSTMENT OF THE STRIPPER MAY BE REQUIRED WHEN MOVING THE APPLICATIONS.

APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 62.

GREASE THREADS, GROOVE AND O-RING ON ITEMS 139 & 153.

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

ORIMP 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.

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 TERMINAL LUBRICANT IS RECOMMENDED.

*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.

_	1	1	1	1	2119782-1	FINE ADJUST HEAD ASM, PACIFIC STYLE	251
_	_	_	1	_	2119640-1	PUSH ROD, AIR FEED	250
_	-	-	1	_	1803259-1	BUSHING, FLANGED	249
-	1	1	1	1	1 - 22279 - 3	SPRING, COMPRESSION	246
- 77	- 27	- 25	- 22	- 21	PART NO	DESCRIPTION	I T E M N O

PACIFIC VERSION

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

_	-	2	-	_ 	2168400-7	SHCS, LOW HEAD, ROHS, M5 X 10 MECHANICAL FEED ASSEMBLY	240
_	_	_	1		2063440-1	AIR FEED MODULE	239
-	-	1	-	-	2119740-2	TAG, IDENTIFICATION	213
_	1 2	1 2	1 2	1 2	1803163-3	FLOATING SHEAR HOLDER SCR, SKT HD CAP, RoHS, M3 X 8.0	206
_	4	4	4	4	2079383-9	SCR, BHSC, RoHS (M6 X 20)	186
_		REF	-	-	1901697-1	FEED FINGER ASSEMBLY, EF	183
	2 2	2	2	2	<u>2 - 2 2 2 8 0 - 0</u> 2 1 6 8 0 8 3 - 1	SPRING, COMPRESSION SCR, SKT HD CAP, RoHS, M3 X 8.0	179
_	1	1	1	1	356885-1	STOP, SHEAR	177
_	_ 1	- 1	2	- 1	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172
_	REF	REF	REF	REF	994969-1	MAGNET, RARE EARTH HIGH ENERGY COUNTER, MAGNETIC	166
_	_	_	1	_	240638-1	SPRING, FEED FINGER	163
_	1	1	1	1	8-21084-1	O-RING, .801 ID, .070 DIA. MAT.	153
	1	1	1	1	2119641-2	FEED CAM, AIR FEED DETENT PIN	152
_	_	-	_	1	2119653-2	FEED CAM, POST FEED	1 4 2
	1	1	1	1	2119655-6	APPLICATOR BASIC ASSEMBLY, EF	1 4 1
	1 1	1	1	1	2119651-1	RAM, ASIAN STYLE, END FEED BOLT, ADJUSTMENT	1 4 0
_	_	_	1	_	3 - 23627 - 7	PIN, RETAIN, GRVD, 3/16 X .854	137
	<u> </u>	REF	-	-	SEE NOTE 4	MEMORY CHIP, PROGRAMMED	1 3 5
_	2	2	2	2	1633743-1	SERVO FEED LATCH ASM WASHER, FLAT, REG M4	133
	1	1	1	1	2119955-2	ASSY, LUBRICATOR, END FEED	8 4
-	1 1	1	1	1	3-455888-7	SPACER, CRIMPER	82
	1	1	1	1	1803203-2	BLOCK, FRONT DEPRESSOR DEPRESSOR, WIRE	7 3
_	1	1	1	1	2119956-2	DOCUMENTATION PACKAGE	7 1
-	2	2	2	2	3-18032-3	SCR, SET, FLT POINT M3 X 20.0	70
_	1	_	1	1	2119943-1	WASHER, SPACER TAG, IDENTIFICATION	6 9
_	2	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
_	1	1	3	1	2119793-1	LIMITER, ADJUSTMENT BOLT	63
	3	3	-	3	992763-5 5-18022-5	SCR, SET, SOC, CONE POINT, M3 x 4.0 SCR, HEX HD CAP, M4 X 6.0	6 2 5 9
_	-	-	-	1	2063961-1	FEED FINGER	58
_	4	4 2	4 2	4 2	2168400-4 1-2168083-0	SHCS, LOW HEAD, ROHS, M4 X 8	57
_	2	2	2	2	5018030-1	SCR, SKT HD CAP, RoHS, M4 X 10 NUT, HEX, REG, RoHS, M3	54
-	2	2	2	2	986965-8	NUT, LOCK, HEX, TORQUE (M4)	53
_	_	-	1	2	2119792-2 18023-9	PAWL, EF, AIR SCR, SKT HD CAP M4 X 6.0	51
_	_	-	-	1	2119652-1	FEED CAM, PRE FEED	4 9
_	1	1	1	1	2079383-7	SCR, BHSC, RoHS (M8 X 25)	4 1
_	1 1	1	1	1	2119645-1	DISC, NUMBERED FA WIRE ADJUSTMENT APPLICATOR SHIM PACK	40
_	1	1	1	1	2119644-1	RAM WASHER, PRECISION	38
_	8	8	8	8	1 - 18028 - 2	WASHER, FLAT, REG M4	3 3
_	2	2	2	2	2168083-3 2168083-2	SCR, SKT HD CAP, RoHS, M4 X 12.0 SCR, SKT HD CAP, RoHS, M4 X 8.0	31 29
_	1	1	1	1	468281-6	STRIPPER	27
-	2	2	2	2	1-2168083-6	SCR, SKT HD CAP, RoHS, M4 X 35	25
	2	2	7	2	1803162-1	PLATE, STRIP GUIDE SPRING, COMPRESSION	24
_	1	1	1	1	1633168-1	ARM, STOCK DRAG	21
-	1	1	1	1	464452-2	DRAG, STOCK	20
_	1	2	2	2	1901259-3	GUIDE, LOWER STRIP SCR, SKT HD CAP, RoHS, M3 X 16	18
_	1	1	1	1	5018030-1	NUT, HEX, REG, RoHS, M3	15
_	-	-	-	-	-		1 1
_	_	_	-	-	-	-	10
1	1	1	1	1	1213862-7	ANVIL, SPLICE TYPE	8
	1 1	1	1	1	1633722-6	SHEAR BLADE	7 6
_	1	1	1	1	690753-6	SPACER, TONKER	5
_		-	-	_	-	-	4
_	_	_	_	_	-	-	3 2
1	1	1	1	1	1803504-5	CRIMPER, WIRE	1
- 7 ī	7 - 27	- 25	- 22	- 21	PART NO	DESCRIPTION	ITEM
	CONTROLLED D CHANGE AND T LD BE CONTACT				I IV. HUANO	N2017 TE Connectivity	140
MENSIC	ONS:		TOLERAN	NCES UNL E SPECIF	CHK 02JUN		
mm		O PL	С	±-	TIED: APVD 02JUN L.ZHANG PRODUCT SPEC	Ocean End Feed	
		1 PL 2 PL	C	士- 士- 士- 士-	- APPLICATION SPEC	Applicator -	
	t	_ 3 PL			i i		
		3 PL 4 PL ANGL FINI	C ES	±- <u>=</u>	WEIGHT	SIZE CAGE CODE DRAWING NO RI	ESTRICTED TO

REVISIONS

DESCRIPTION

SEE SHEET 1

SET UP GAUGE 2119599-2

A 66

