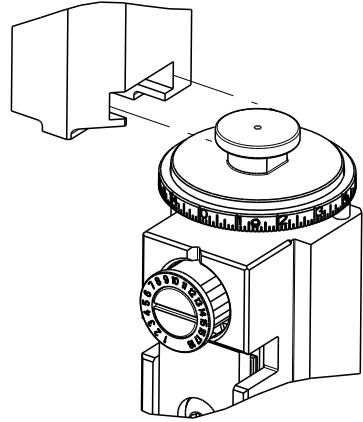


|                                                                      |          |                                    |           |
|----------------------------------------------------------------------|----------|------------------------------------|-----------|
| 8                                                                    |          | 7                                  |           |
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| 20                                                                   |          | 20                                 |           |
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| PART<br>NUMBER                                                       | REVISION | DESCRIPTION                        | FEED TYPE |
| 2151501-2                                                            | K        | FINE CRIMP HEIGHT ADJUST           | PNEUMATIC |
| 7-2151501-2                                                          | K        | PNEUMATIC AND CRIMP<br>TOOLING KIT | PNEUMATIC |
| 7-2151501-7                                                          | G        | CRIMP TOOLING KIT                  | -         |

ATLANTIC VERSION TERMINATOR  
INTERFACE ADAPTER



| APPLICATOR DATA                      |                 |      |
|--------------------------------------|-----------------|------|
| CRIMP                                | SIZE            | TYPE |
| WIRE                                 | 3.30 mm [1.130] | F    |
| INSUL                                | 6.60 mm [1.260] | O    |
| APPLICATOR INSTRUCTIONS<br>408-35042 |                 |      |

|                                       |                                                                                   |                                                                                   |                                    |
|---------------------------------------|-----------------------------------------------------------------------------------|-----------------------------------------------------------------------------------|------------------------------------|
| TERMINAL DATA: TE TERMINAL            |                                                                                   | TE CRIMP SPECIFICATION                                                            |                                    |
| TERMINAL NAME: TAB 5.8 X 0.8 ASSEMBLY |                                                                                   |                                                                                   |                                    |
| WIRE STRIP LENGTH                     |                                                                                   |  | TERMINAL INSULATION DIAMETER RANGE |
| 5.05-6.05 mm [1.99-.238 IN]           |                                                                                   |                                                                                   | Ø                                  |
| TERMINAL APPLICATION SPECIFICATION    |  | 114-18052                                                                         | -                                  |
|                                       |                                                                                   | -                                                                                 | -                                  |

|                   |             |         |          |                                |
|-------------------|-------------|---------|----------|--------------------------------|
| TERMINALS APPLIED |             |         |          | SEAL INSULATION DIAMETER RANGE |
| TE TERMINAL       | TE TERMINAL | TE SEAL | TE SEAL  |                                |
| 964314-1          | 2-964314-2  |         | 963245-1 | Ø 3.40-3.70mm                  |

|           |                             |                                |
|-----------|-----------------------------|--------------------------------|
| WIRE SIZE | CRIMP HEIGHT mm [INCH]      | CRIMP HEIGHT REFERENCE SETTING |
| 4.00mm2   | 2.34+/-0.05 [1.092+/-0.002] | 8.2                            |
| 4.00mm2   | 2.17+/-0.05 [1.085+/-0.002] | 8.4                            |



- 1 RECOMMENDED SPARE PARTS
- 2 REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- 3 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 APPLY TORQ-SEAL IN ALLEN SOCKET TO FILL HOLE AFTER FLAT HD HAS BEEN ADJUSTED TO CORRECT HEIGHT AT QUALIFICATION. APPLY #1-23419-5 LOC-TITE TO THREADS.
- 8 PREFERRED CRIMP DATA FOR UPDATED AUTOMOTIVE REQUIREMENTS ACOURDING 114-18052, TABLE 4".

\*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.

|     |      |           |     |               |  |   |  |           |     |      |
|-----|------|-----------|-----|---------------|--|---|--|-----------|-----|------|
| 2   |      |           |     |               |  | 1 |  |           |     |      |
| LOC | DIST | REVISIONS |     |               |  |   |  |           |     |      |
| A   | 66   | P         | LTR | DESCRIPTION   |  |   |  | DATE      | DWN | APVD |
|     |      |           | H1  | ECR-18-012024 |  |   |  | 27JUL2018 | FL  | CT   |
|     |      |           | J   | ECR-18-017039 |  |   |  | 29OCT2018 | FL  | TE   |
|     |      |           | K   | ECR-19-009212 |  |   |  | 12JUN2019 | FJ  | TE   |
|     |      |           | K1  | ECR-23-195515 |  |   |  | 18DEC2023 | JWC | TE   |

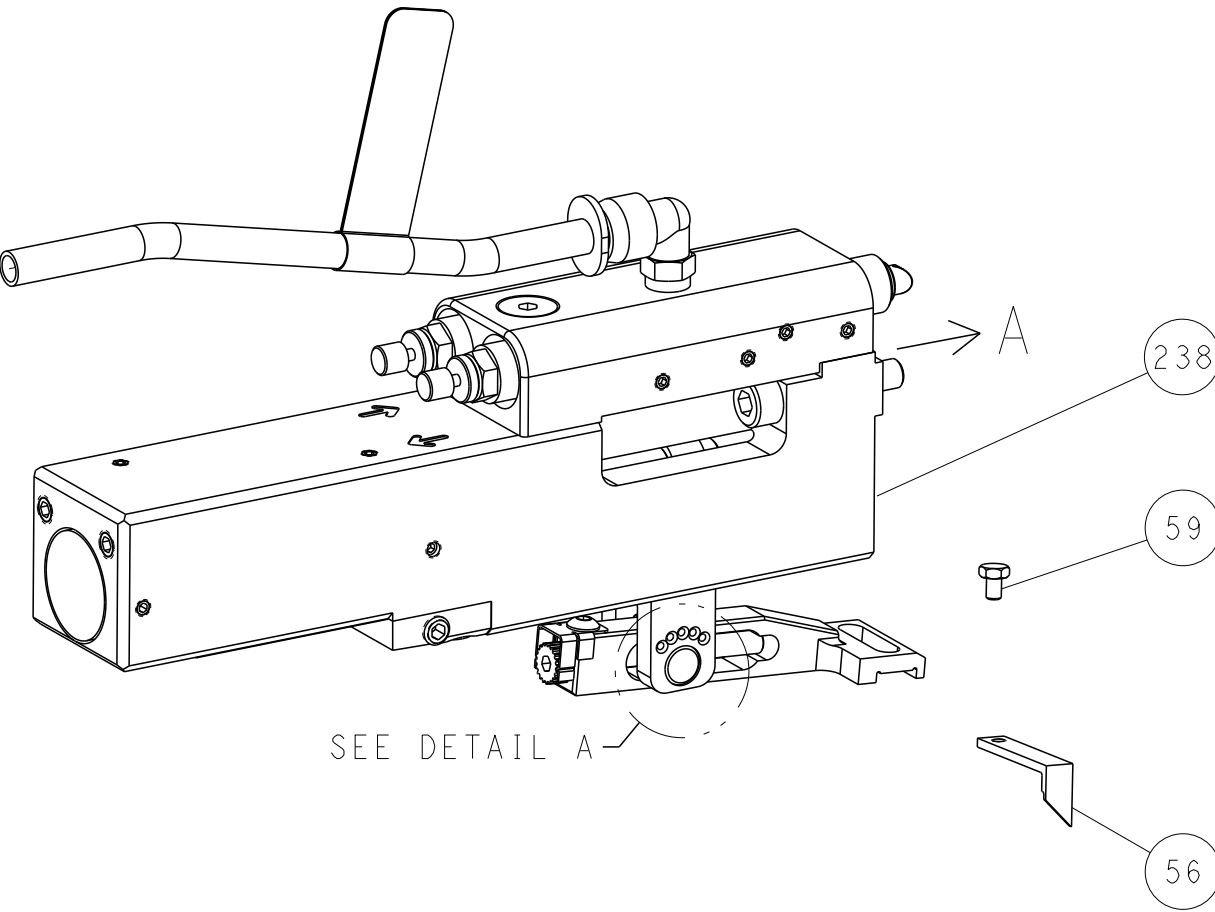
|        |     |     |             |                                     |         |
|--------|-----|-----|-------------|-------------------------------------|---------|
| -      | 1   | 1   | 2119641-1   | FEED CAM, AIR FEED                  | 248     |
| -      | 1   | 1   | 2119082-6   | CAM, SNAIL, INSULATION ADJUSTMENT   | 244     |
| -      | 1   | 1   | 2079764-1   | WASHER, WAVE SPRING, CREST-TO-CREST | 243     |
| 3      | -   | 1   | 2119083-1   | RETAINER, INSULATION DIAL           | 242     |
| -      | 1   | 1   | 7-18023-7   | SCR, SKT HD CAP M3 X 4.0            | 241     |
| -      | 1   | 1   | 2844940-2   | AIR FEED MODULE                     | 238     |
| -      | REF | REF | 994970-2    | COUNTER, MAGNETIC                   | 164     |
| -      | 1   | 1   | 2844908-1   | SCREW, LOCKING                      | 99      |
| -      | 1   | 1   | 2844907-1   | POST, LOCKING                       | 98      |
| -      | 1   | 1   | 1-690438-0  | FRONT STRIP GUIDE                   | 96      |
| -      | 1   | 1   | 455888-8    | SPACER, CRIMPER -                   | 82      |
| -      | 1   | 1   | 1803607-3   | DOCUMENTATION PACKAGE               | 71      |
| -      | 1   | 1   | 2119791-5   | DEPRESSOR, WIRE                     | 70      |
| -      | 1   | 1   | 2119943-1   | WASHER, SPACER                      | 69      |
| -      | 1   | 1   | 2119740-1   | TAG,IDENTIFICATION                  | 67      |
| -      | 2   | 2   | 2168078-1   | SCREW, DRIVE, RH, RoHS, 2 x .188    | 66      |
| -      | 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      |
| 7      | -   | 1   | 985575-5    | SCR, FLT SKT HD CAP M3 X 16.0       | 57      |
| -      | 1   | 1   | 1338683-8   | FEED PAWL                           | 56      |
| -      | 4   | 4   | 2168083-3   | SCR, SKT HD CAP, RoHS, M4 X 12.0    | 54      |
| -      | 2   | 2   | 1-2168083-0 | SCR, SKT HD CAP, RoHS, M4 X 10      | 53      |
| -      | 1   | 1   | 1803382-2   | HOLD DOWN, SPRING LOADED            | 50      |
| -      | 1   | 1   | 18023-9     | SCR, SKT HD CAP M4 X 6.0            | 49      |
| -      | 1   | 1   | 1803583-3   | APPLICATOR BASIC ASSEMBLY, SF       | 46      |
| -      | 1   | 1   | 1803515-1   | RAM ASSEMBLY, SF ATLANTIC           | 44      |
| -      | 1   | 1   | 1803602-1   | SCR, BHSC, RoHS (M8 X 25)           | 41      |
| -      | 1   | 1   | 1-1752356-1 | SUPPORT, TERMINAL                   | 34      |
| -      | 2   | 2   | 2079383-5   | SCR, BHSC, RoHS (M4 X 20)           | 33      |
| -      | 2   | 2   | 3-2844962-5 | SPACER, CYLINDRICAL, STRIP GUIDE    | 30      |
| -      | 1   | 1   | 2844992-6   | ASSEMBLY, STRIP GUIDE -             | 29      |
| -      | 1   | 1   | 455888-4    | SPACER, CRIMPER -                   | 28      |
| -      | 2   | 2   | 22283-1     | SPRING, COMPRESSION                 | 27      |
| -      | 1   | 1   | 240792-1    | DRAG, TERMINAL                      | 25      |
| -      | 1   | 1   | 1320928-6   | STRIP GUIDE                         | 24      |
| -      | 1   | 1   | 2168083-2   | SCR, SKT HD CAP, RoHS, M4 X 8.0     | 21      |
| -      | 2   | 2   | 1-18028-2   | WASHER, FLAT, REG M4                | 20      |
| -      | 1   | 1   | 2119533-1   | STRIPPER, SIDE FEED                 | 19      |
| 1      | -   | 1   | 2119806-1   | INSERT, SHEAR                       | 13      |
| -      | 1   | 1   | 3-22280-3   | SPRING, COMPRESSION                 | 12      |
| -      | 1   | 1   | 1-356885-3  | STOP, SHEAR                         | 11      |
| 1      | -   | 1   | 2119805-2   | SHEAR HOLDER, FRONT -               | 10      |
| 1      | -   | 1   | 318059-4    | FLOATING SHEAR, FRONT               | 9       |
| 1      | 2   | 1   | 2-1333229-7 | ANVIL, COMBINATION                  | 8       |
| -      | -   | -   | -           | -                                   | 7       |
| -      | -   | -   | -           | -                                   | 6       |
| -      | 1   | 1   | 2-2119781-6 | DEPRESSOR, SHEAR                    | 5       |
| -      | 1   | 1   | 238011-2    | BLOCK, CRIMPER SPACER               | 4       |
| 1      | 2   | 1   | 5-1803018-6 | CRIMPER, INSULATION O               | 3       |
| -      | -   | -   | -           | -                                   | 2       |
| 1      | 2   | 1   | 1-456410-7  | CRIMPER, WIRE PREMIUM               | 1       |
| -77-72 | -2  |     | PART NO     | DESCRIPTION                         | ITEM NO |

|                                                                                                                                                                                                                                               |  |                              |                                                  |  |
|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--|------------------------------|--------------------------------------------------|--|
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| DIMENSIONS:                                                                                                                                                                                                                                   |  | CHK<br>S. XI<br>29AUG2012    | NAME                                             |  |
| mm                                                                                                                                                                                                                                            |  | APVD<br>I. CRUZ<br>29AUG2012 | Ocean Side Feed<br>Applicator                    |  |
| TOLERANCES UNLESS OTHERWISE SPECIFIED:                                                                                                                                                                                                        |  | PRODUCT SPEC                 | SIZE                                             |  |
| 0 PLC ±                                                                                                                                                                                                                                       |  | APPLICATION SPEC             | CAGE CODE                                        |  |
| 1 PLC ±                                                                                                                                                                                                                                       |  |                              | DRAWING NO                                       |  |
| 2 PLC ±                                                                                                                                                                                                                                       |  |                              | RESTRICTED TO                                    |  |
| 3 PLC ±                                                                                                                                                                                                                                       |  |                              | 00779                                            |  |
| 4 PLC ±                                                                                                                                                                                                                                       |  |                              | C=2151501                                        |  |
| ANGLES                                                                                                                                                                                                                                        |  |                              | SCALE                                            |  |
| FINISH                                                                                                                                                                                                                                        |  |                              | 1:2                                              |  |
| MATERIAL                                                                                                                                                                                                                                      |  | WEIGHT                       | SHEET                                            |  |
| -                                                                                                                                                                                                                                             |  | -                            | 1 OF 4                                           |  |
| CUSTOMER DRAWING                                                                                                                                                                                                                              |  |                              | REV                                              |  |
|                                                                                                                                                                                                                                               |  |                              | K1                                               |  |

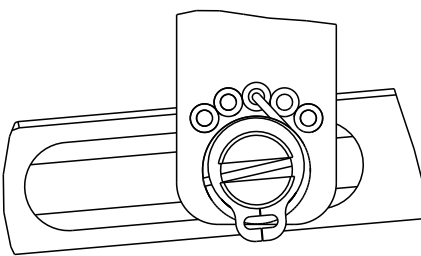
| LOC |     | DIST        |  | REVISIONS |     |      |  |
|-----|-----|-------------|--|-----------|-----|------|--|
| P   | LYR | DESCRIPTION |  | DATE      | DWN | APVD |  |
|     | -   | SEE SHEET 1 |  | -         | -   | -    |  |
|     |     |             |  |           |     |      |  |
|     |     |             |  |           |     |      |  |
|     |     |             |  |           |     |      |  |

FEED TYPE

PNEUMATIC

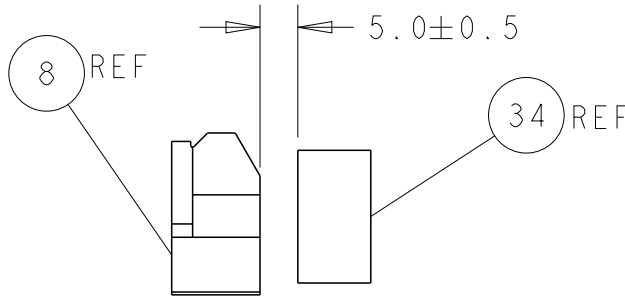
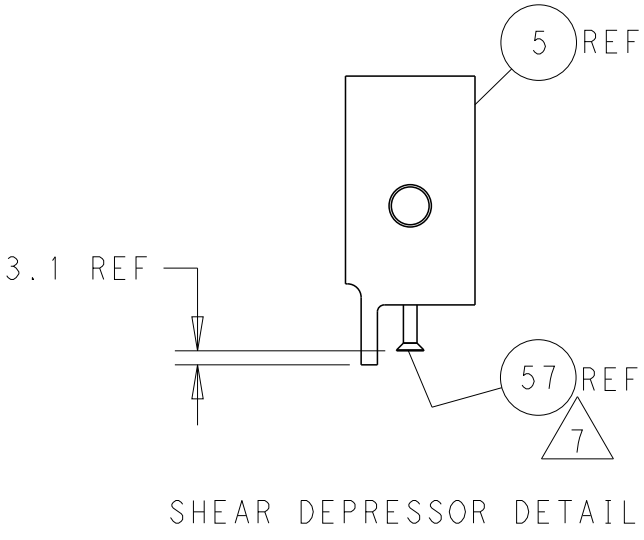
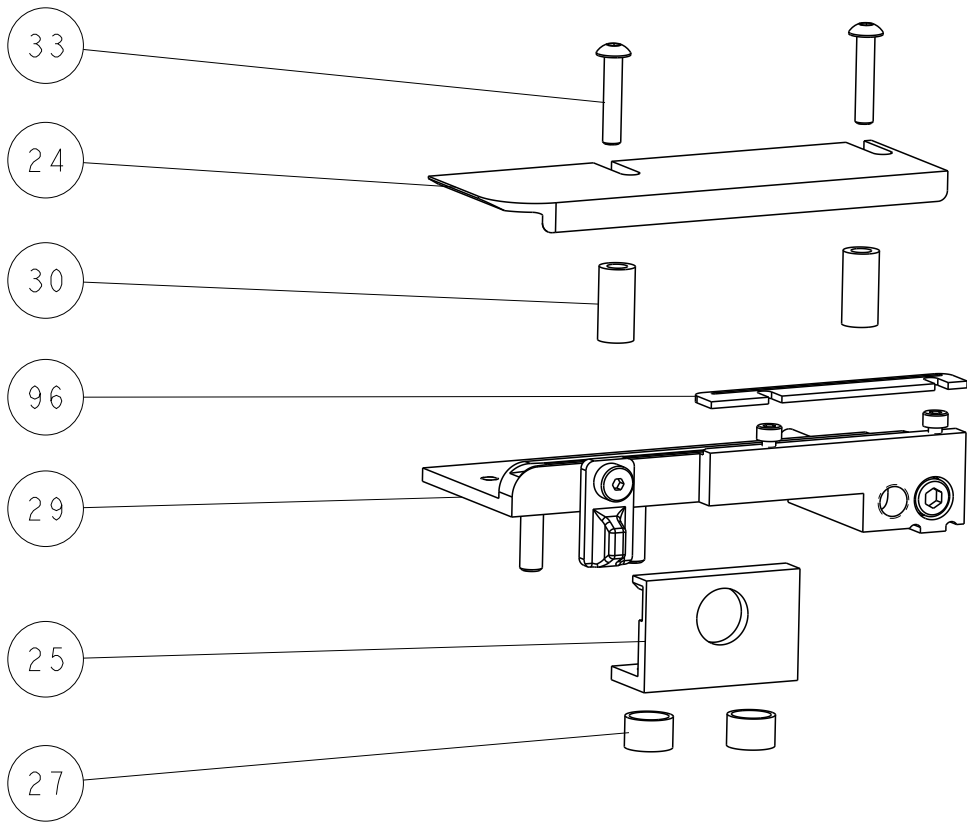
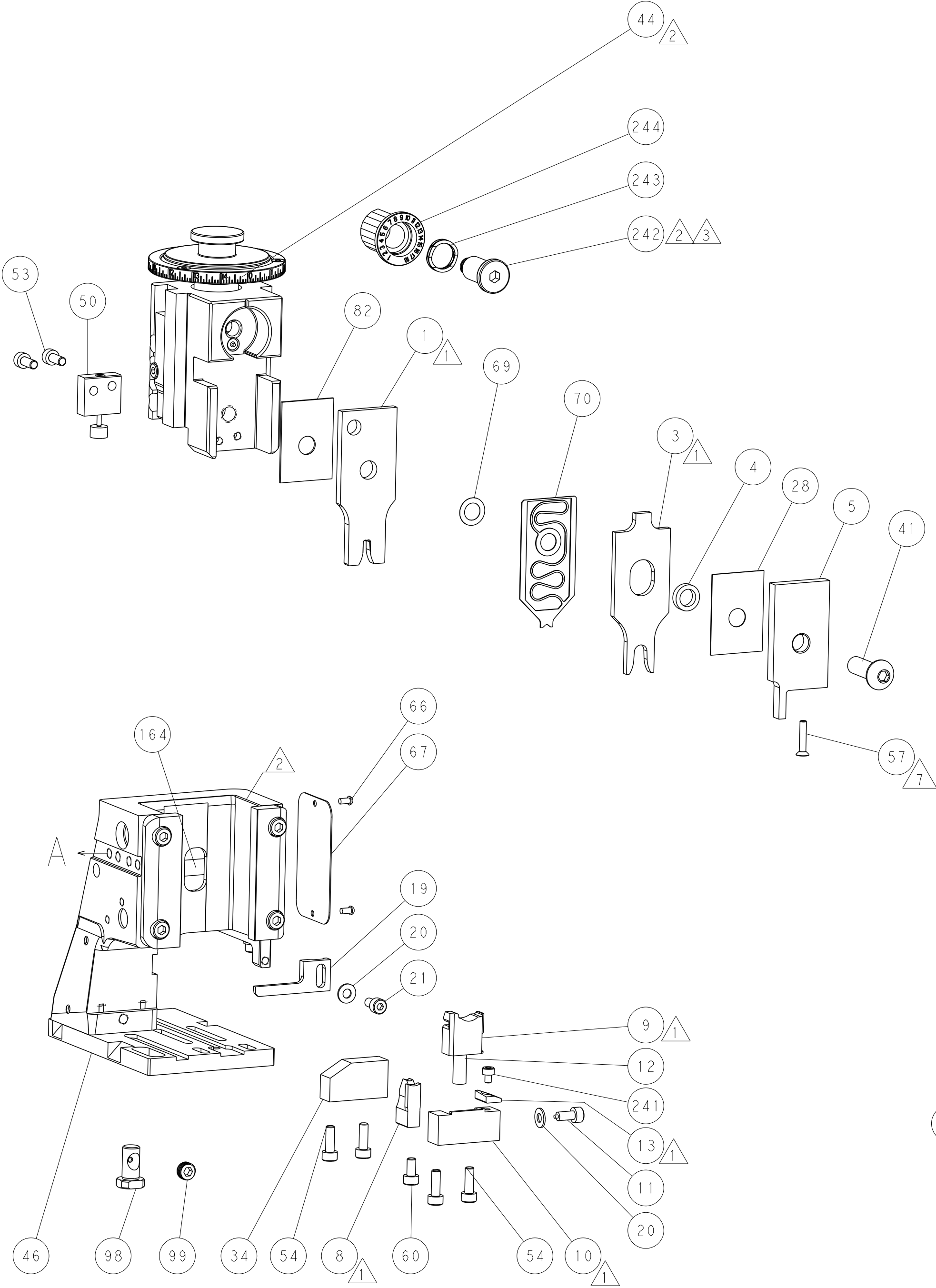
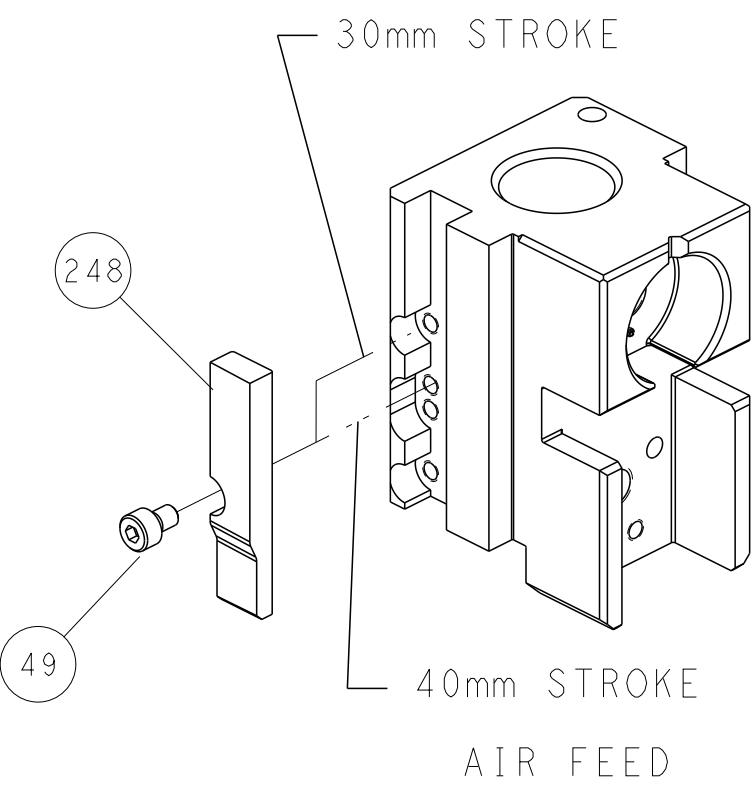


FEED SPRING SETTING POSITION  
(SHOWN FROM REAR SIDE)

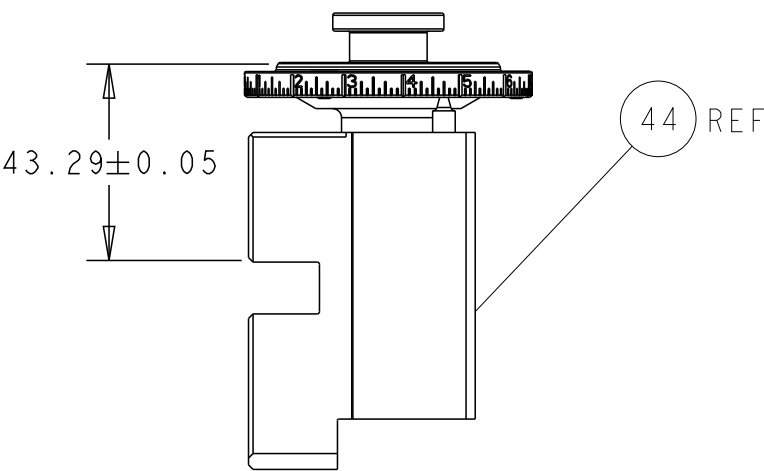


DETAIL A

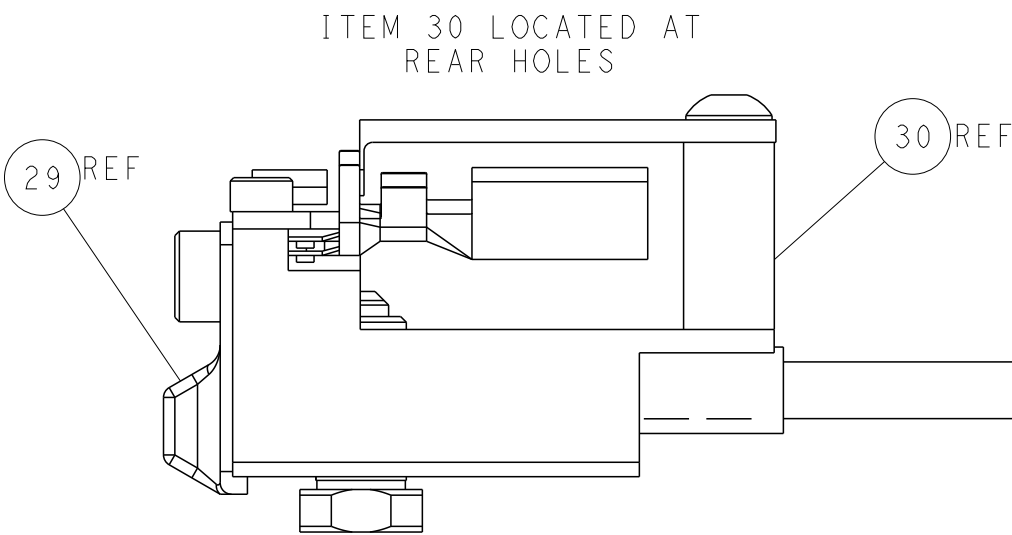
CAM POSITION



TERMINAL SUPPORT LOCATION



RAM SET-UP



FEED TRACK POSITION  
GUIDE BY INSULATION BARREL

|                                                                                                                                                                                         |  |                              |                                              |  |
|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--|------------------------------|----------------------------------------------|--|
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| CHK<br>S. XI<br>29AUG2012                                                                                                                                                               |  | NAME<br>I. CRUZ<br>29AUG2012 | Ocean Side Feed<br>Applicator                |  |
| DIMENSIONS:<br>mm                                                                                                                                                                       |  | PRODUCT SPEC                 | SIZE<br>A1                                   |  |
| TOLERANCES UNLESS OTHERWISE SPECIFIED:<br>0 PLC ±<br>1 PLC ±<br>2 PLC ±<br>3 PLC ±<br>4 PLC ±<br>ANGLES ±<br>FINISH ±                                                                   |  | APPLICATION SPEC             | CAGE CODE<br>00779                           |  |
| MATERIAL<br>-                                                                                                                                                                           |  | WEIGHT<br>-                  | DRAWING NO.<br>C=2151501                     |  |
|                                                                                                                                                                                         |  | CUSTOMER DRAWING             | SCALE<br>1:2                                 |  |
|                                                                                                                                                                                         |  |                              | SHEET<br>2 OF 4                              |  |
|                                                                                                                                                                                         |  |                              | REV<br>K1                                    |  |