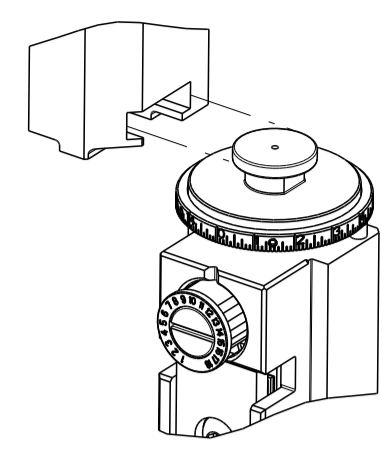


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150829-2	H	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150829-7	E	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR
 INTERFACE ADAPTER



APPLICATOR DATA

CRIMP	SIZE	TYPE
WIRE	3.30 mm [.130]	SP
INSUL	4.06 mm [.160]	OV

APPL INSTRUCTIONS
 408-35043

PART NUMBER	REVISION	DESCRIPTION	CONVERT FROM
7-2150829-8	H	APPLICATOR CONVERSION KIT	2150382-X

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION

TERMINAL NAME: .250 SERIES FASTON FLAG RECEPTACLE 2D

WIRE STRIP LENGTH	INSULATION DIAMETER RANGE
5.72-6.48 mm [.225-.255 IN]	Ø1.56-4.00 mm [.061-.157 IN]

TERMINAL APPLICATION SPECIFICATION 114-143089

TERMINALS APPLIED

TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
2238171-3			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
12 AWG	1.98+/-0.05 [.078+/-0.002]	2.7
14 AWG	1.65+/-0.05 [.065+/-0.002]	6.1
16 AWG	1.45+/-0.05 [.057+/-0.002]	7.8
18 AWG	1.30+/-0.05 [.051+/-0.002]	9.5
20 AWG	1.22+/-0.05 [.048+/-0.002]	10.5
22 AWG	1.17+/-0.05 [.046+/-0.002]	11.5

- 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 ITEMS 86 & 242. APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 180.
- 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.
- CUT TO LENGTH AT ASSEMBLY.
- TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- REPLACE ITEM # IN ORIGINAL APPLICATOR.

***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.

ACTION LIST

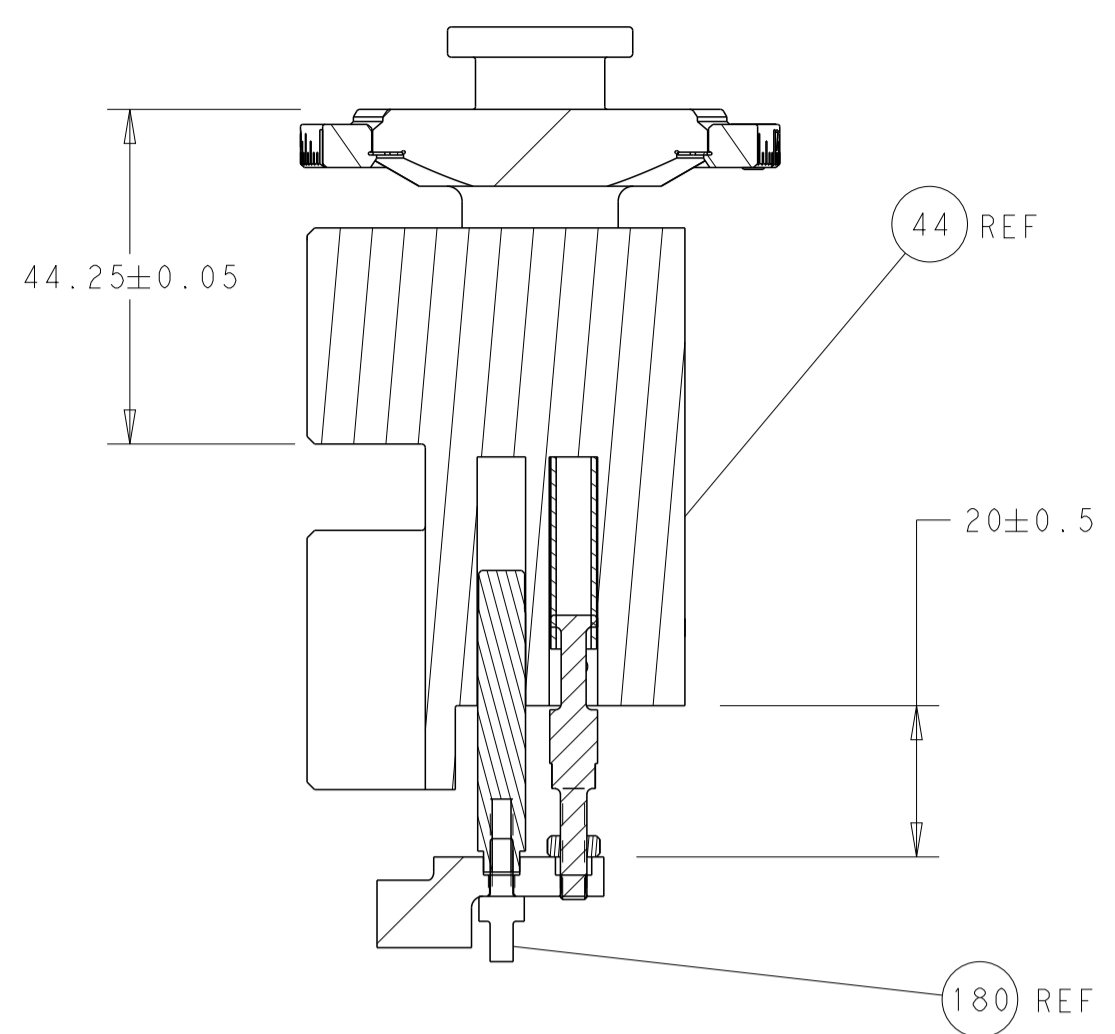
ADD	286
DELETE #192	-
ADD	180
DELETE #178	-
ADD	177
ADD	176
ADD	175
ADD	174
ADD	154
ADD	86
REPLACE #82	82
REPLACE #73	73
REPLACE #72	72
REPLACE #70	70
ADD	69
ADD	65
REPLACE #56	56
ADD	52
REPLACE #51	51
REPLACE #46	46
ADD	28
REPLACE #27	27
REPLACE #25	25
REPLACE #22	22
REPLACE #19	19
REPLACE #14	14
REPLACE #10	10
REPLACE #9	9
REPLACE #8	8
REPLACE #7	7
ADD	6
DELETE #5	-
REPLACE #4	4
REPLACE #3	3
REPLACE #2	2
REPLACE #1	1
-78 ACTION	ITEM NO

LOC	DIST	REV	DATE	BY	APPV
A	66	E	31MAR2020	TB	GB
		F	29JUN2021	TB	RK
		G	31AUG2023	FZ	JAH
		H	09MAY2024	ZZ	TE

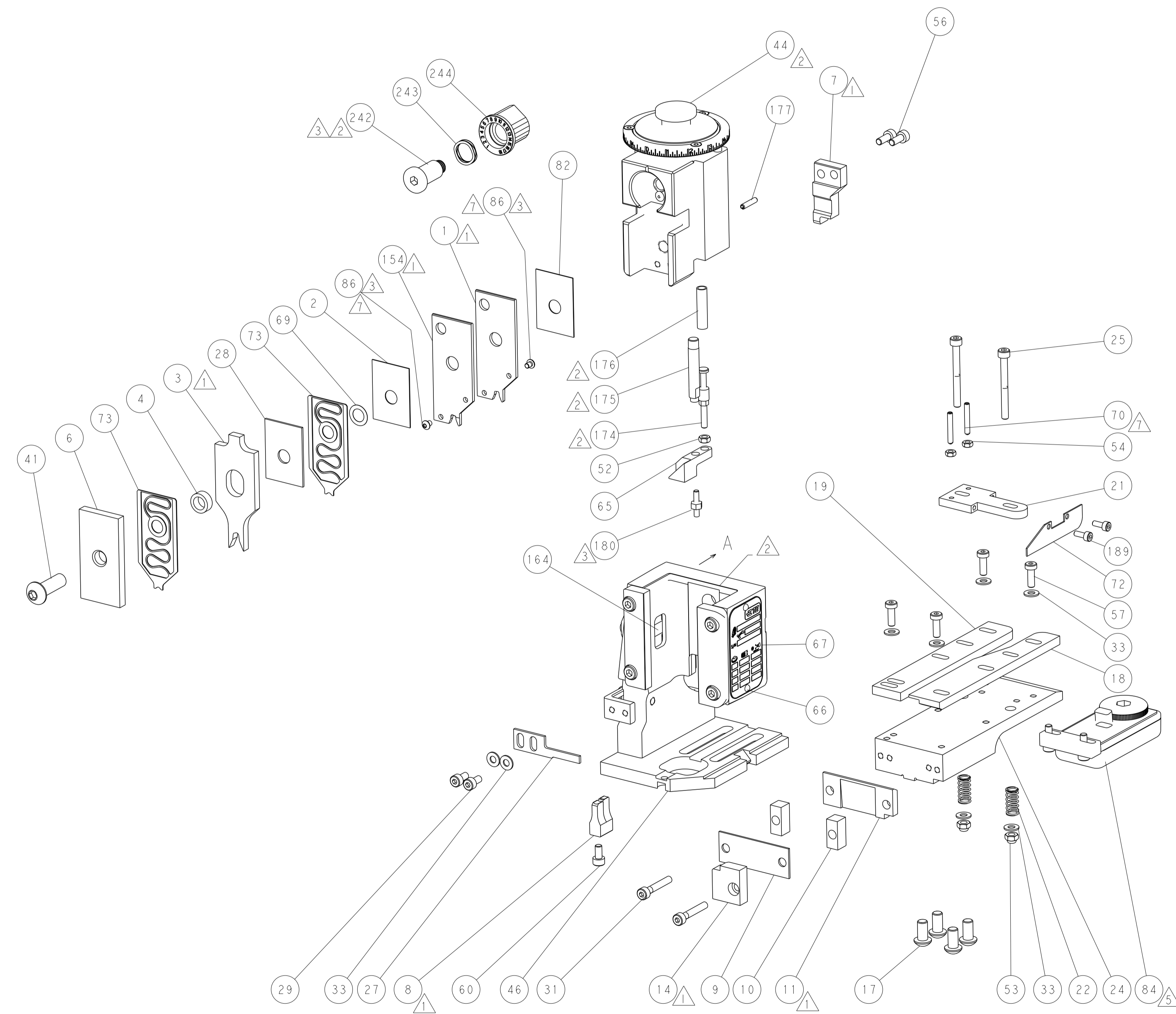
QTY	REV	DATE	DESCRIPTION	ITEM NO	
1	-	1	2119791-5	DEPRESSOR, WIRE	286
-	-	1	2119641-1	FEED CAM, AIR FEED	248
-	-	1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	-	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	-	1	2119083-1	RETAINER, INSULATION DIAL	242
-	-	1	2844940-3	AIR FEED MODULE	238
-	-	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	189
1	-	1	1-1976055-9	STANDOFF, HOLD-DOWN	180
1	-	1	6-993111-6	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	994970-2	COUNTER, MAGNETIC	164
1	1	1	1803619-3	CRIMPER, WIRE, OVERLAP, 2D	154
2	-	2	5-18024-3	SCR, BTN SKT HD CAP (M3 X 4.0)	86
-	-	1	2119955-2	ASSY, LUBRICATOR, END FEED	84
1	-	1	455888-4	SPACER, CRIMPER -	82
1	-	1	2119791-5	DEPRESSOR, WIRE	73
1	-	1	2-464452-5	DRAG, STOCK	72
-	-	1	1803607-4	DOCUMENTATION PACKAGE	71
2	-	2	3-18032-3	SCR, SET, FLT PNT, M3 X 20.0	70
-	-	1	2119943-1	WASHER, SPACER	69
-	-	1	2119740-1	TAG, IDENTIFICATION	67
-	-	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
1	-	1	1803176-1	HOLDDOWN, TERMINAL	65
-	-	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	60
-	-	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	-	4	2168400-1	SHCS, LOW HEAD, RoHS, M4 X 12	57
2	-	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	56
-	-	2	5018030-1	NUT, HEX, REG, RoHS, M3	54
-	-	2	986965-8	NUT, LOCK, HEX, TORQUE (M4)	53
1	-	1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52
1	-	1	1-2063961-4	FEED FINGER	51
-	-	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49
1	-	1	1-2119655-7	APPLICATOR BASIC ASSEMBLY, EF	46
-	-	1	1803517-1	RAM ASSEMBLY, EF ATLANTIC	44
-	-	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
-	-	8	1-18028-2	WASHER, FLAT, REG M4	33
-	-	2	1-2168083-2	SCR, SKT HD CAP, RoHS, M4 X 25	31
-	-	2	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	29
1	-	1	1-455888-0	SPACER, CRIMPER -	28
1	-	1	1-690455-3	STRIPPER, FRONT CASTING	27
2	-	2	1-2168083-7	SCR, SKT HD CAP, RoHS, M4 X 40	25
-	-	1	2161922-4	PLATE, STRIP GUIDE	24
2	-	2	2-22281-3	SPRING, COMPRESSION	22
-	-	1	1633168-2	ARM, STOCK DRAG	21
1	-	1	1-1901259-1	GUIDE, LOWER STRIP	19
-	-	1	3-1901695-2	STRIP GUIDE, FRONT	18
-	-	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17
1	-	1	1803175-4	SUPPORT, TERMINAL	14
1	-	1	461160-1	PLATE, REAR SHEAR	11
2	-	2	5-240645-4	SPACER, SHEAR PLATE	10
1	-	1	455961-5	PLATE, FRONT SHEAR	9
1	1	1	1803724-1	ANVIL, COMBINATION, END FEED	8
1	-	1	1803186-3	BLADE, SLUG	7
1	-	1	1-2119757-6	DEPRESSOR, SHEAR	6
1	-	1	3-238011-4	BLOCK, CRIMPER SPACER	4
1	1	1	1-1803208-7	CRIMPER, INSULATION OVERLAP PREMIUM	3
1	-	1	455888-4	SPACER, CRIMPER -	2
1	1	1	1803618-3	CRIMPER, WIRE, OVERLAP, 2D	1
-78-77-2	-	-	PART NO	DESCRIPTION	ITEM NO

DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH		DWG: M. ZHAO 14AUG2017 CHK: K. ZHANG 14AUG2017 APVD: K. ZHANG 14AUG2017 PRODUCT SPEC APPLICATION SPEC WEIGHT: - MATERIAL: -		NAME: Ocean End Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2150829 RESTRICTED TO: - SCALE: 1:1 SHEET: 1 of 4 REV: H	
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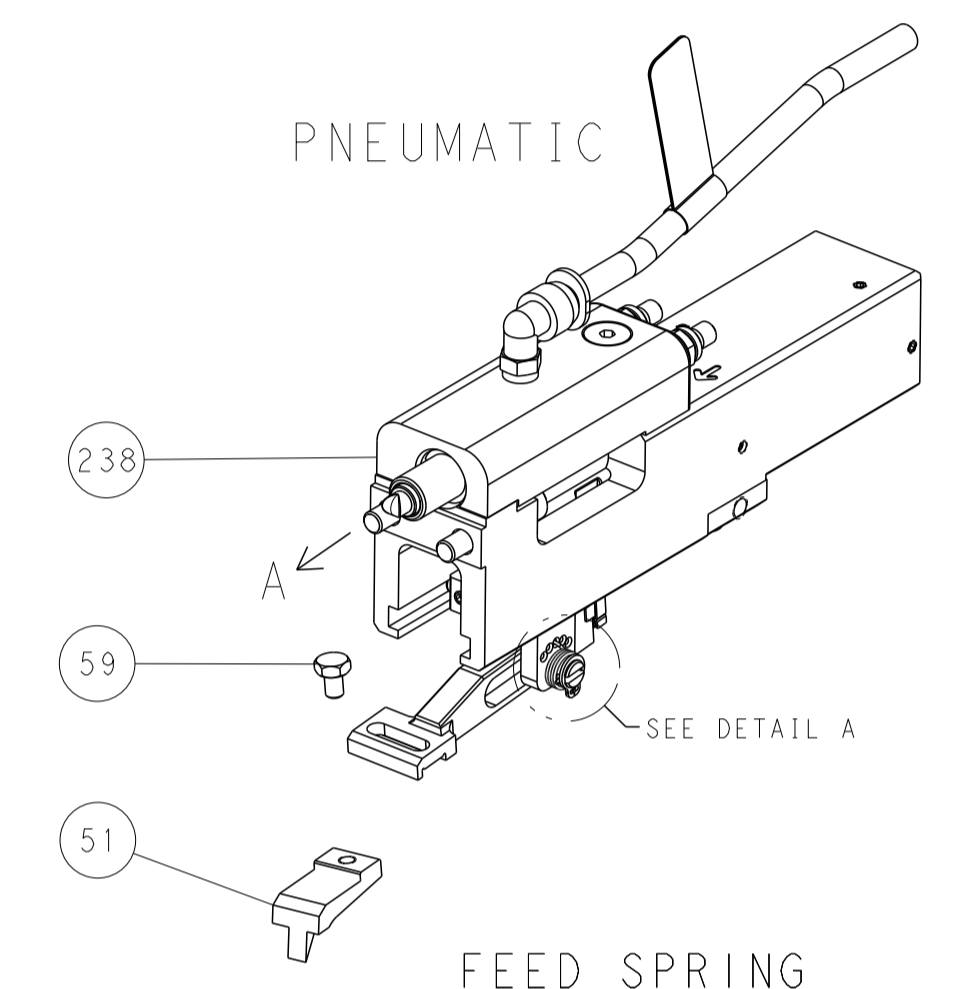
LOC	DIST	REVISIONS					
A	66	P	LTN	DESCRIPTION	DATE	DMN	APVD
		-		SEE SHEET 1			



RAM AND HOLDDOWN SET-UP

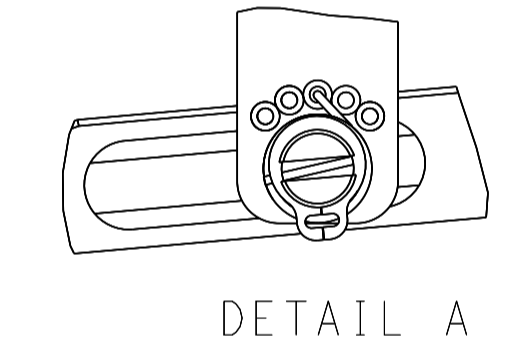


FEED TYPE

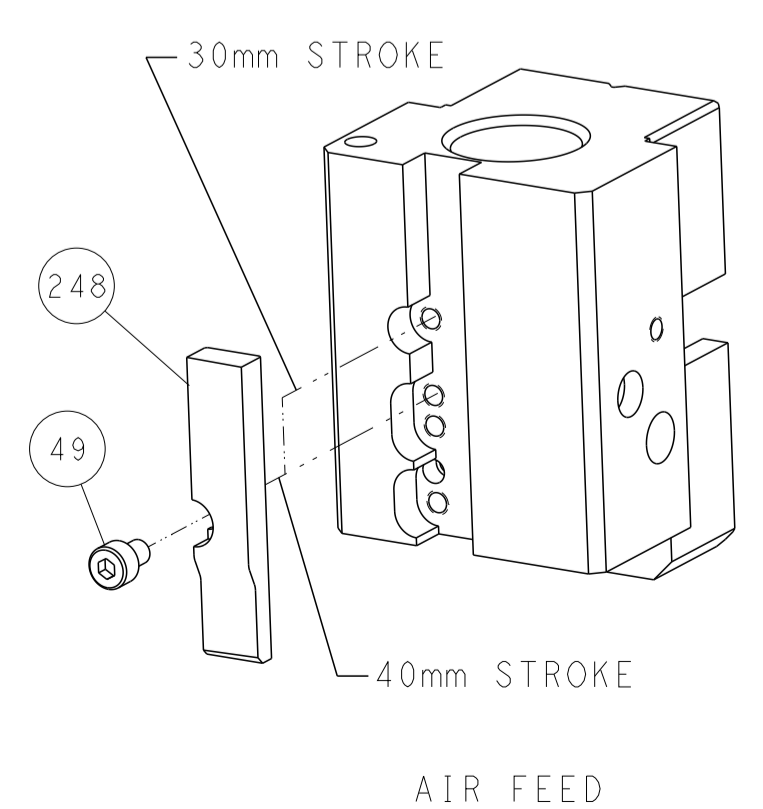


PNEUMATIC

FEED SPRING SETTING POSITION



CAM POSITION



AIR FEED

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DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± MATERIAL: - FINISH: -		NAME: Ocean End Feed Applicator PRODUCT SPEC: - APPLICATION SPEC: - SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2150829 WEIGHT: - SCALE: 1:1	RESTRICTED TO: - SHEET 2 OF 4 REV H