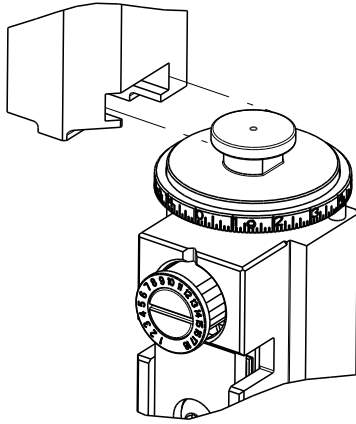
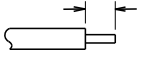


8	7
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RELEASED FOR PUBLICATION	
20	
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PART NUMBER	REVISION
DESCRIPTION	FEED TYPE
2150388-1	C
2150388-2	C
7-2150388-1	C
7-2150388-2	C
7-2150388-7	A

ATLANTIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.64 mm [.104]	F
INSUL	3.68 mm [.145]	OV
APPLICATOR INSTRUCTIONS 408-35043		

TERMINAL DATA: G & H TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: FLACHSTECKHULSE 4.80 x 0.8 FASTON			
WIRE STRIP LENGTH			INSULATION DIAMETER RANGE
5.00-5.00 mm [.197-.197 IN]			Ø2.10-3.10 mm [.083-.122 IN]
TERMINAL APPLICATION SPECIFICATION		25312	-
		-	-
TERMINALS APPLIED			-

TE TERMINAL	G & H TERMINAL	TE TERMINAL	G & H TERMINAL
1572180-1	25312.213.011	1572180-8	25312.123.327
1572180-2	25312.417.328	1572180-9	25312.123.324
1572180-3	25312.417.031	1-1572180-0	25312.123.210
1572180-4	25312.213.178	1-1572180-1	25312.123.211
1572180-5	25312.213.042	1-1572180-2	25312.123.204
1572180-6	25312.213.004	1-1572180-3	25312.123.178
1572180-7	25312.123.330		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
2 X 1.00mm2	1.75+/-0.05 [.069+/- .002]	4.4
2.50mm2	1.70+/-0.05 [.067+/- .002]	5.0
1.50mm2	1.50+/-0.05 [.059+/- .002]	7.0



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 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.

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

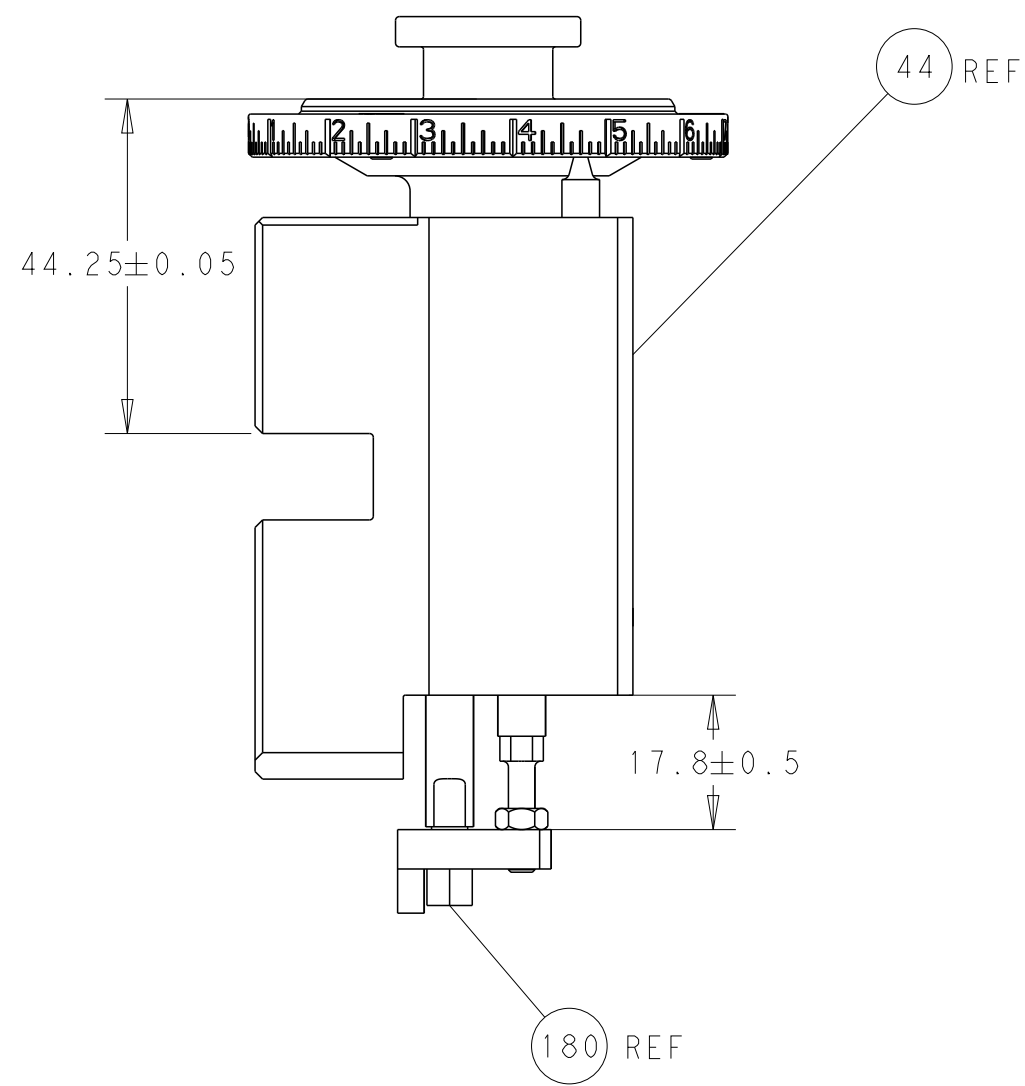
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		B		ECR-17-005523	17APR2017
		C		ECR-23-179893	30JUN2023

	-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248
	-	1	1	1	1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244
	-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
3	-	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
	-	-	1	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
	-	1	-	1	-	2844940-3	AIR FEED MODULE	238
	-	1	1	1	1	1-18028-0	WASHER, FLAT, REG M8	192
3	-	1	1	1	1	1752354-4	STANDOFF,HOLD-DOWN	180
	-	1	1	1	1	6-993111-6	PIN, SLOTTED SPRING 3.0 X 14.0	177
	-	1	1	1	1	8-22280-7	SPRING, COMPRESSION	176
	-	1	1	1	1	1752353-2	GUIDE PIN,HOLDDOWN	175
	-	1	1	1	1	1901680-2	GUIDE PIN,HOLDDOWN	174
	-	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
6	-	1	1	1	1	2119955-2	ASSY, LUBRICATOR, END FEED	84
	-	1	1	1	1	455888-6	SPACER, CRIMPER	82
	-	1	1	1	1	1803607-4	DOCUMENTATION PACKAGE	71
	-	2	2	2	2	2-18032-2	SCR, SET, FLT PNT, M3 X 10.0	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	1901681-5	HOLDDOWN, TERMINAL	65
	-	1	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	60
	-	1	1	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
	-	-	1	-	1	2063961-1	FEED FINGER	58
	-	4	4	4	4	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57
	-	2	2	2	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	56
	-	2	2	2	2	5018030-1	NUT, HEX, REG, RoHS, M3	54
	-	2	2	2	2	986965-8	NUT, LOCK, HEX, TORQUE (M4)	53
	-	1	1	1	1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52
	-	1	-	1	-	2063961-9	FEED FINGER	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	2079383-8	SCR, BHSC, RoHS (M4 X 16)	31
	-	2	2	2	2	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	29
	-	1	1	1	1	240639-1	STRIPPER (MACHINING)	27
	-	2	2	2	2	1-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 30	25
	-	1	1	1	1	1752371-5	PLATE, STRIP GUIDE	24
	-	2	2	2	2	2-22281-3	SPRING, COMPRESSION	22
	-	1	1	1	1	1803292-4	DRAG	20
	-	2	2	2	2	1901259-5	GUIDE, LOWER STRIP	18
	-	4	4	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17
1	-	1	1	1	1	240644-1	PLATE, REAR SHEAR	11
	-	-	-	-	-	-	-	10
1	-	1	1	1	1	1-690482-2	PLATE, FRONT SHEAR	9
1	1	2	2	1	1	3-1803001-3	ANVIL, COMBINATION, END FEED	8
1	-	1	1	1	1	2217206-7	BLADE, SLUG	7
	-	-	-	-	-	-	-	6
	-	1	1	1	1	4-240641-1	SPACER	5
	-	1	1	1	1	238011-2	BLOCK, CRIMPER SPACER	4
1	1	2	2	1	1	1633963-5	CRIMPER, INSULATION OVERLAP PREMIUM	3
	-	1	1	1	1	455888-5	SPACER, CRIMPER	2
1	1	2	2	1	1	9-1633305-1	CRIMPER, WIRE PREMIUM	1
	-77-	72-	71-	2-	1-	PART NO	DESCRIPTION	ITEM NO

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										CHK L. ZHANG 18OCT2013						
										APVD J. GUO 18OCT2013						
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:								NAME		Ocean End Feed Applifier -				
mm																
		0	PLC	±						PRODUCT SPEC						
		1	PLC	±						-						
		2	PLC	±						APPLICATION SPEC						
		3	PLC	±												
		4	PLC	±												
ANGLES		°														
MATERIAL		FINISH								SIZE		CAGE CODE	DRAWING NO	RESTRICTED TO		
-		-								A1		00779	C=2150388	-		
Customer Accessible Production Drawing										SCALE		1:1		SHEET 1 OF 4		REV C

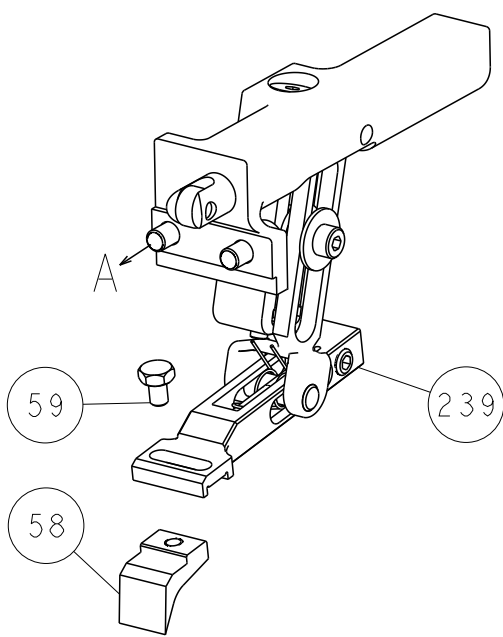
SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

LOC		DIST		REVISIONS			
A	66	P	LTR	DESCRIPTION	DATE	DWN	APVD
		-		SEE SHEET 1	-	-	-

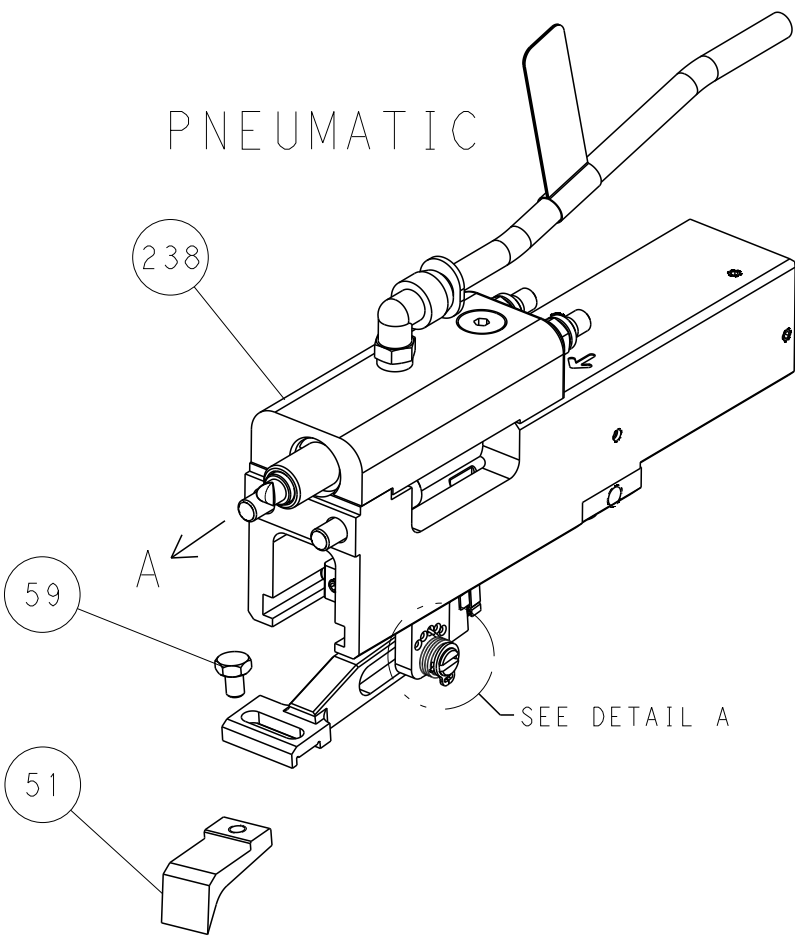


RAM & HOLDDOWN SET-UP

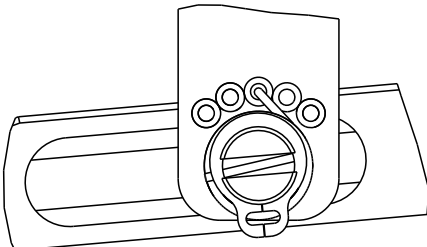
FEED TYPE
MECHANICAL



PNEUMATIC

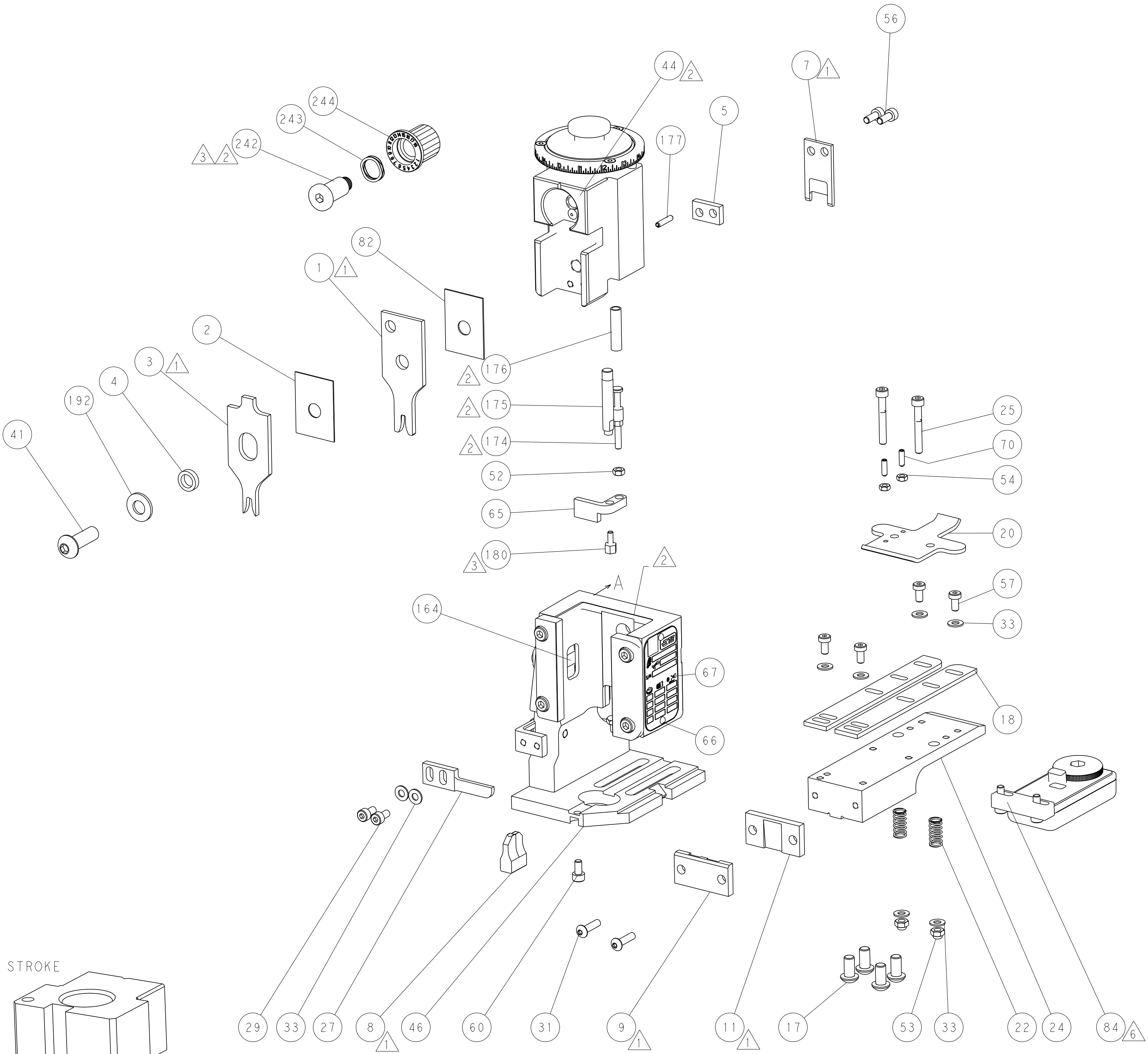
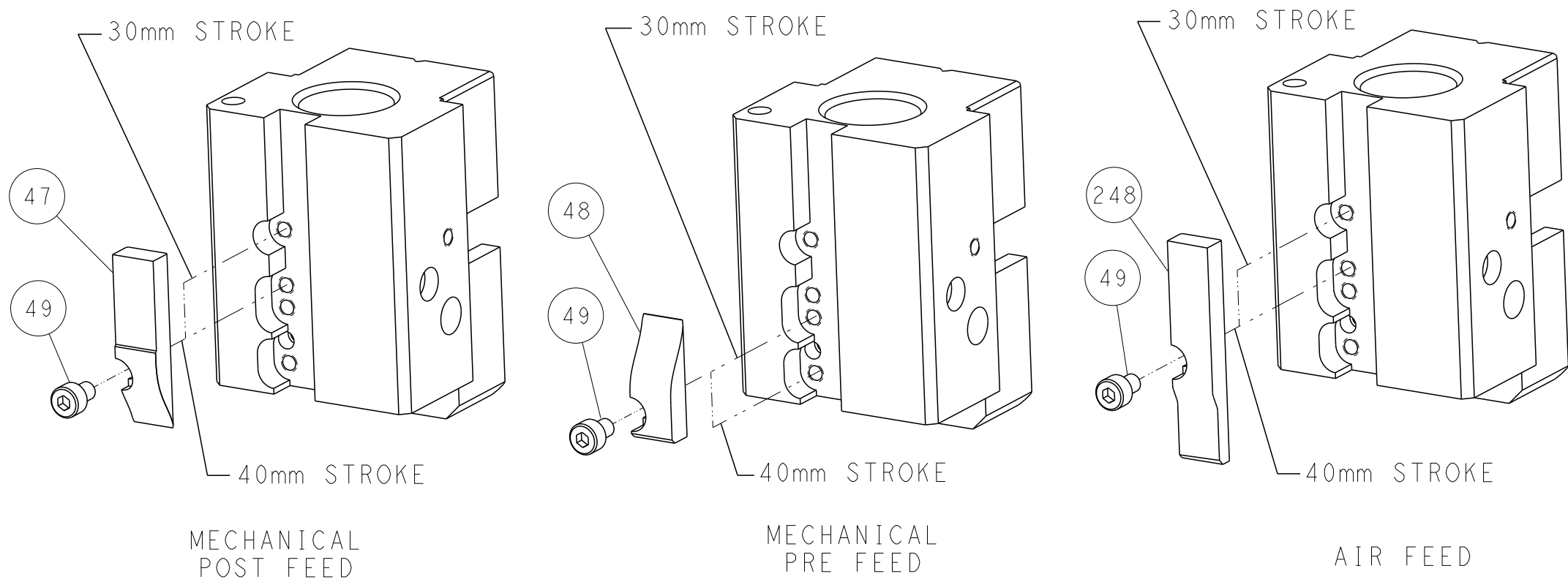


FEED SPRING
SETTING POSITION

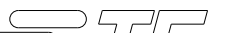


DETAIL A

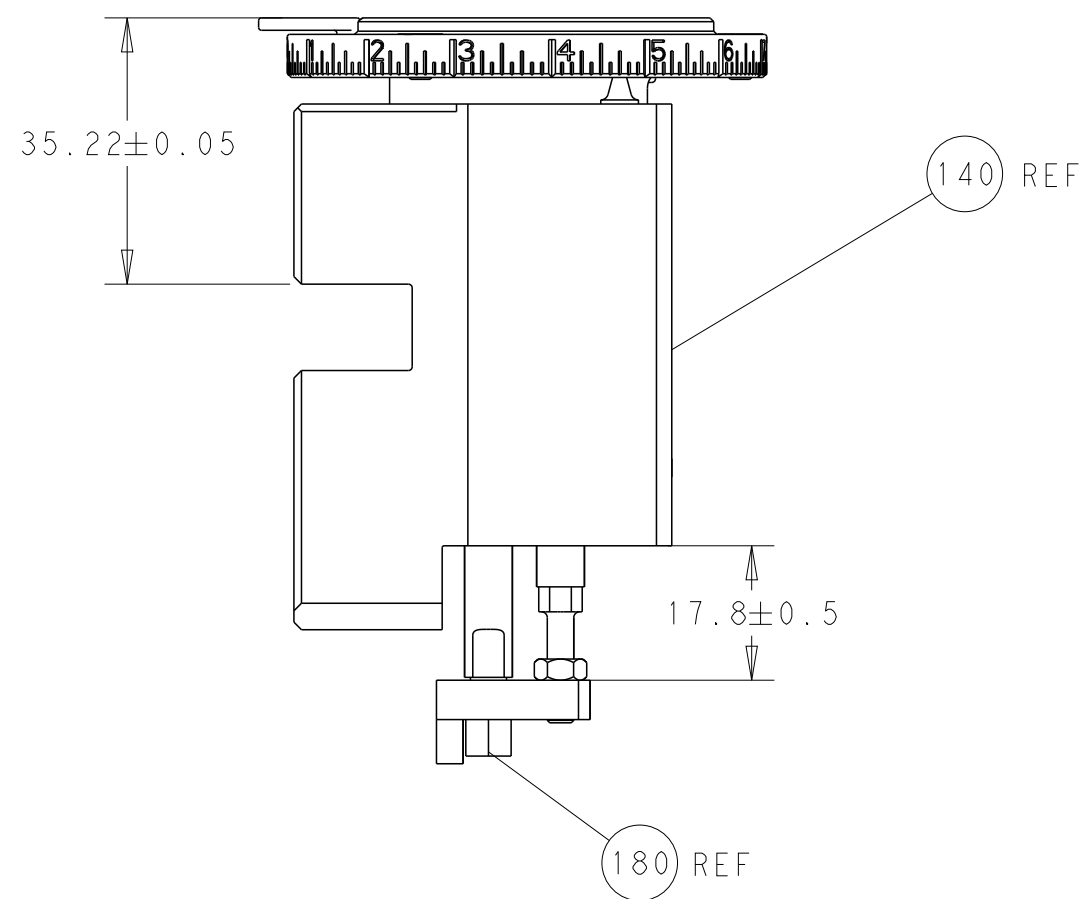
CAM POSITIONS



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

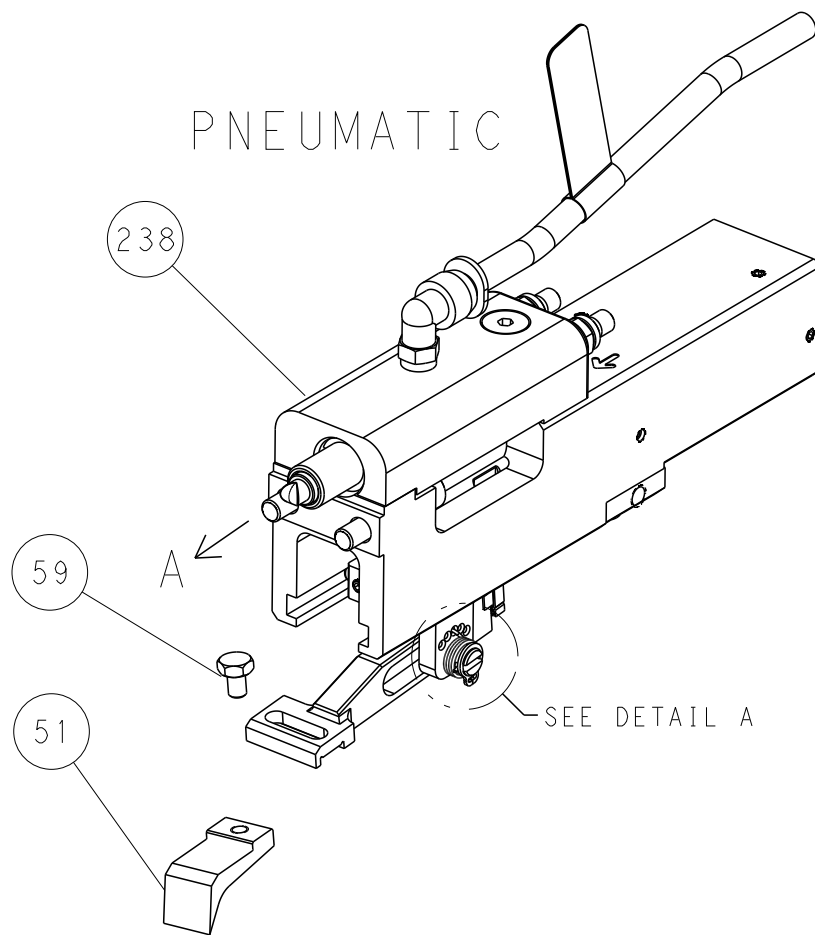
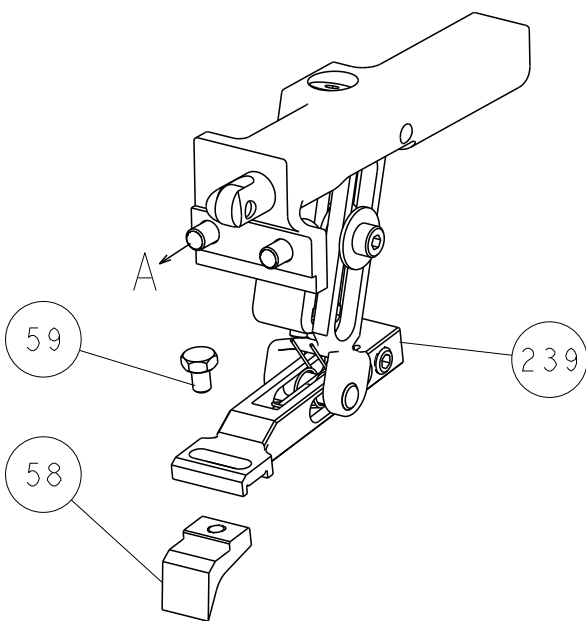
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				CHK	L. ZHANG	18OCT2013										
				APVD	J. GUO	18OCT2013										
DIMENSIONS:				TOLERANCES UNLESS OTHERWISE SPECIFIED:			NAME		Ocean End Feed Appliator -							
mm																
																
MATERIAL																
0 PLC ±				PRODUCT SPEC			SIZE		CAGE CODE		DRAWING NO	RESTRICTED TO				
1 PLC ±				APPLICATION SPEC			A		00779		C=2150388	-				
2 PLC ±				WEIGHT			-									
3 PLC ±				Customer Accessible Production Drawing			SCALE		1:1		SHEET	2	OF	4	REV	C
4 PLC ±																
ANGLES ±																
FINISH																

LOC		DIST		REVISIONS			
A	66	P	LTR	DESCRIPTION	DATE	DWN	APVD
		-		SEE SHEET 1	-	-	-

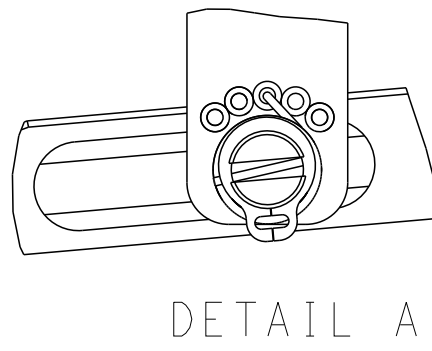


RAM & HOLDDOWN SET-UP

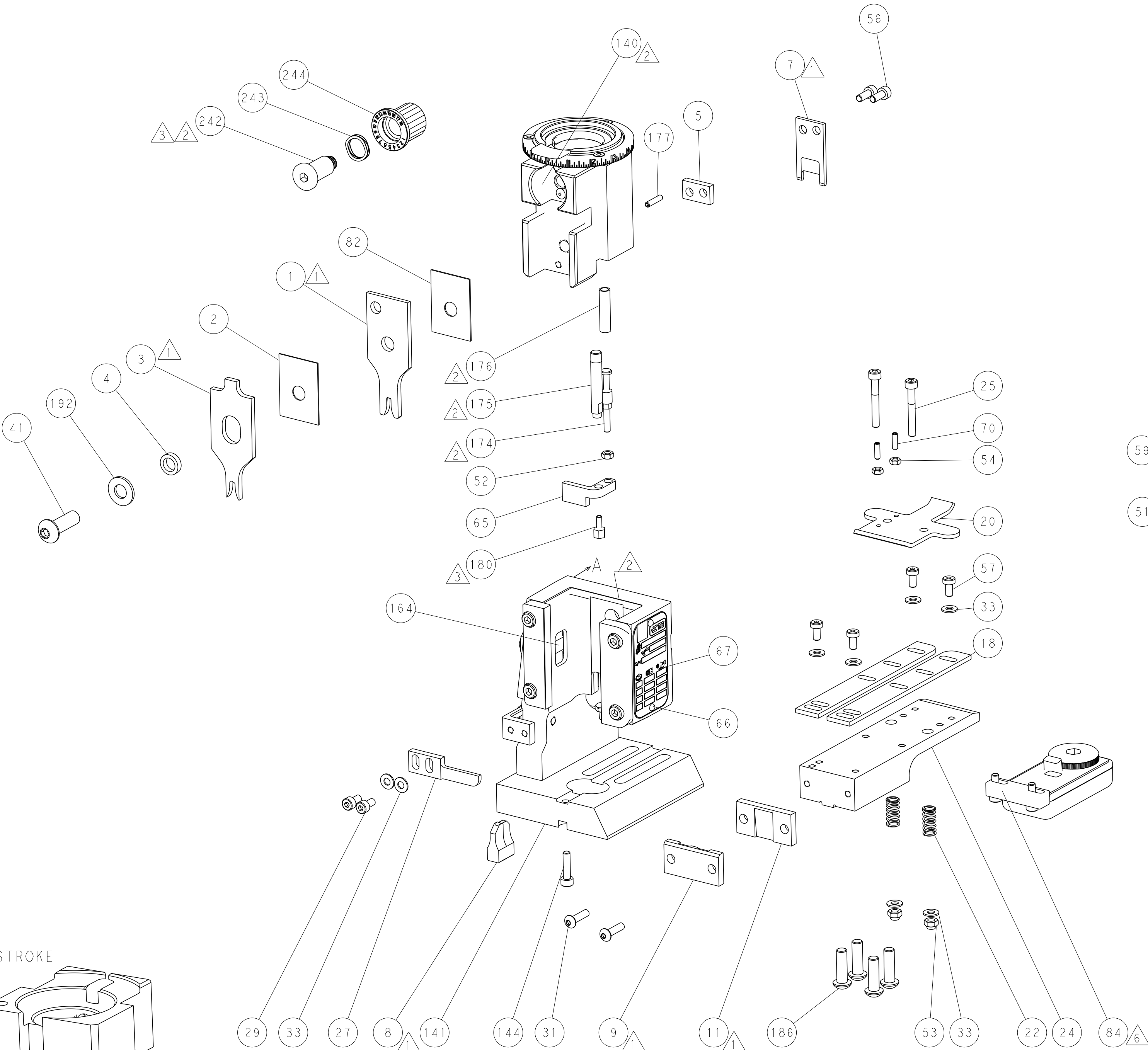
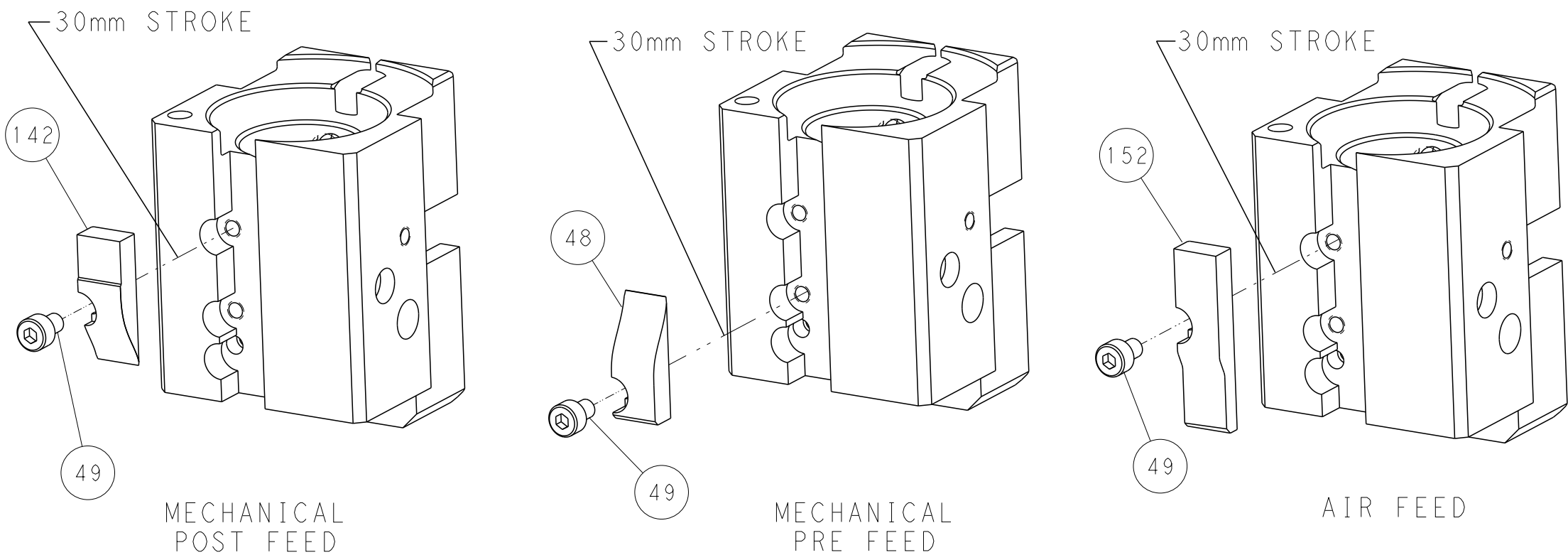
FEED TYPE
MECHANICAL



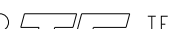
FEED SPRING
SETTING POSITION



CAM POSITIONS



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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				CHK	L. ZHANG	18OCT2013					
				APVD	J. GUO	18OCT2013	NAME Ocean End Feed Applicator -				
				PRODUCT SPEC							
				APPLICATION SPEC							
				WEIGHT							
				Customer Accessible Production Drawing							
				SCALE							
				SHEET							
				REV							

DIMENSIONS:		TOLERANCES, UNLESS OTHERWISE SPECIFIED:	
mm		0	PLC ±
		2	PLC ±
		2	PLC ±
		3	PLC ±
		4	PLC ±
		6	PLC ±
		ANGLES	±°
		FINISH	-
MATERIAL	-	WEIGHT	-
		Customer Accessible Production Drawing	
		SCALE	1:1
		SHEET	4 of 4
		REV	C