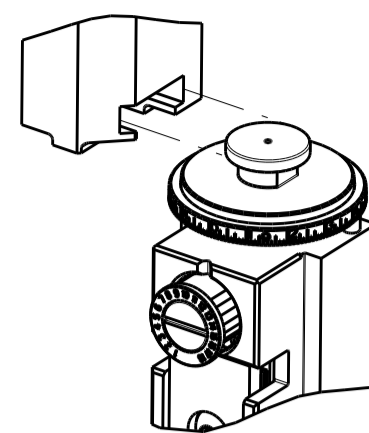


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151983-1	E	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2151983-2	E	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151983-1	E	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2151983-2	E	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2151983-7	C	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER

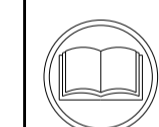


APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.10 mm [.043]	F
INSUL	1.40 mm [.055]	F

APPLICATOR INSTRUCTIONS 408-35042

TERMINAL DATA: HIROSE TERMINAL HIROSE CRIMP SPECIFICATION	
TERMINAL NAME: TERMINAL	
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE
2.00-2.50 mm [.079-.098 IN]	Ø0.80-1.50 mm [.031-.059 IN]
TERMINAL APPLICATION SPECIFICATION ATAD-PO514-283 Rev 1	
TERMINALS APPLIED	
TE TERMINAL	HIROSE TERMINAL
2113350-1	GT8-2428SCF

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
24 AWG	0.64 +/- 0.04 [.0252 +/- .0016]	7.2
26 AWG	0.60 +/- 0.04 [.0236 +/- .0016]	7.6
28 AWG	0.58 +/- 0.04 [.0228 +/- .0016]	7.8



- 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.

**\*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)

LOC	DIST	REV	LTN	DESCRIPTION	DATE	OWN	APVD
A	66	B		ECR-15-004965	30MAR2015	KH	TE
		C		ECR-15-017027	23NOV2015	TT	TE
		D		ECR-16-009416	29JUN2016	MEH	GB
		E		ECR-19-003815	11MAR2019	FZ	YY

-	1	-	1	-	2119640-1	PUSH ROD, AIR FEED	250
-	1	-	1	-	1803259-1	BUSHING, FLANGED	249
-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248
-	1	1	1	1	2119082-4	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	1	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
-	-	1	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	1	-	1	-	2063440-1	AIR FEED MODULE	238
-	2	-	2	-	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172
-	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	1	-	1	-	240638-1	SPRING, FEED FINGER	163
-	1	-	1	-	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854	137
-	1	-	1	-	2119799-1	HOLDER, FEED FINGER, AF	136
-	1	1	1	1	1-18028-2	WASHER, FLAT, REG M4	119
-	1	1	1	1	2844908-1	SCREW, LOCKING	99
-	1	1	1	1	2844907-1	POST, LOCKING	98
-	1	1	1	1	455888-5	SPACER, CRIMPER	82
-	1	1	1	1	1803607-1	DOCUMENTATION PACKAGE	71
-	1	1	1	1	2119791-9	DEPRESSOR, WIRE	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	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	1	1	1338685-1	PAWL, FEED	56
-	4	4	4	4	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	54
-	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	1803583-9	APPLICATOR BASIC ASSEMBLY, SF	46
-	1	1	1	1	1803515-1	RAM ASSEMBLY, SF ATLANTIC	44
-	1	1	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
-	1	1	1	1	2-1752356-6	SUPPORT, TERMINAL	34
-	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	2	2	2-2844962-4	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29
-	1	1	1	1	1320928-2	STRIP GUIDE	24
-	1	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
-	1	1	1	1	1-18028-2	WASHER, FLAT, REG M4	20
-	1	1	1	1	2119533-1	STRIPPER, SIDE FEED	19
-	1	1	1	1	2119806-1	INSERT, SHEAR	13
-	1	1	1	1	3-22280-3	SPRING, COMPRESSION	12
-	1	1	1	1	1-356885-3	STOP, SHEAR	11
-	1	1	1	1	2119805-1	SHEAR HOLDER, FRONT	10
-	1	1	1	1	1803095-6	FLOATING SHEAR, FRONT	9
-	1	2	2	1	1803335-4	ANVIL, COMBINATION	8
-	-	-	-	-	-	-	7
-	-	-	-	-	-	-	6
-	1	1	1	1	1-2119757-8	DEPRESSOR, SHEAR	5
-	1	1	1	1	238011-6	BLOCK, CRIMPER SPACER	4
-	1	2	2	1	1803326-4	CRIMPER, INSULATION F	3
-	1	1	1	1	455888-4	SPACER, CRIMPER	2
-	1	2	2	1	1803324-7	CRIMPER, WIRE	1
-	77	-72	-71	-2	-1	PART NO	ITEM NO

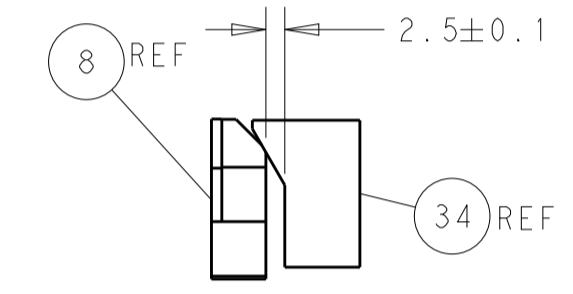
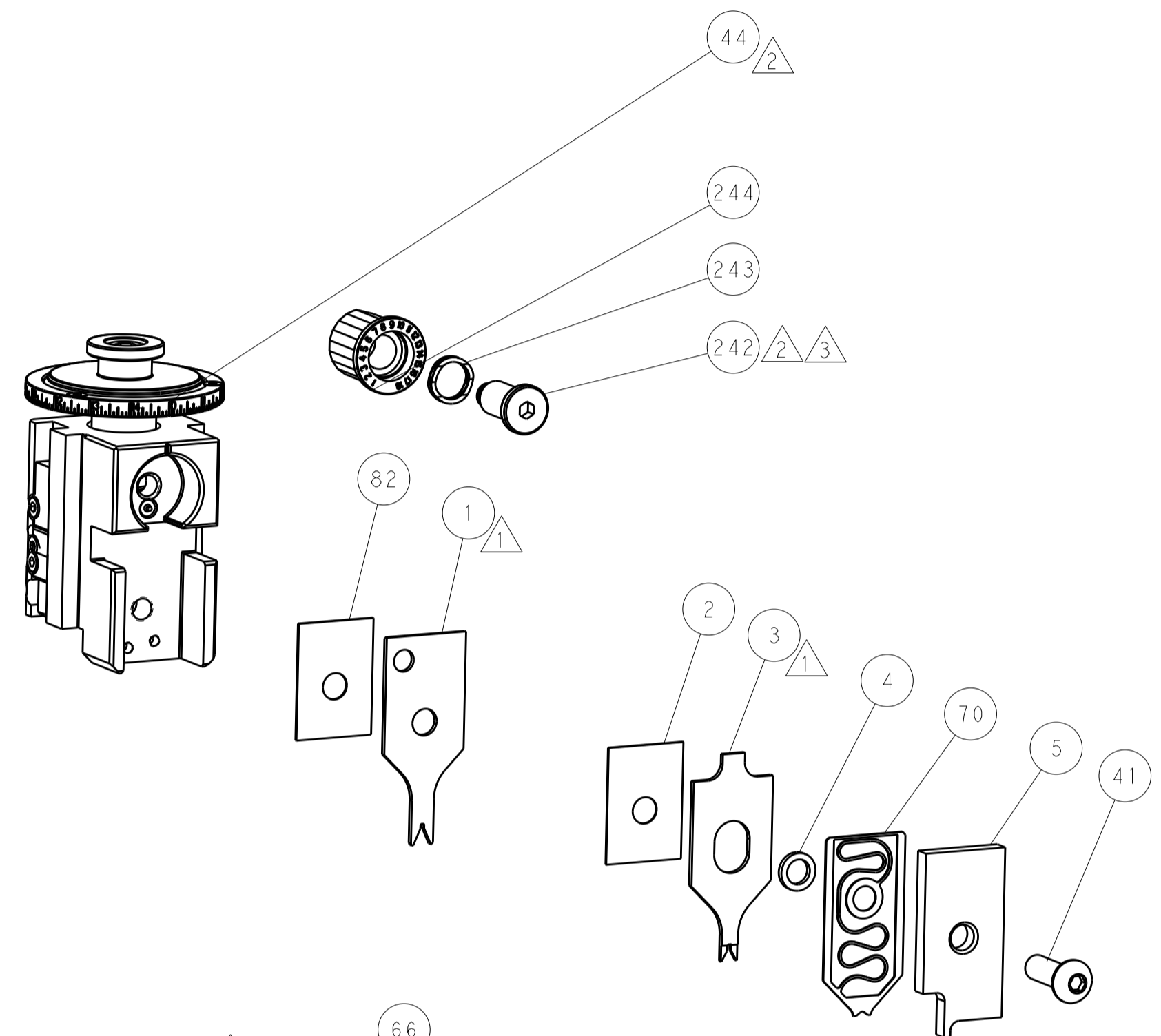
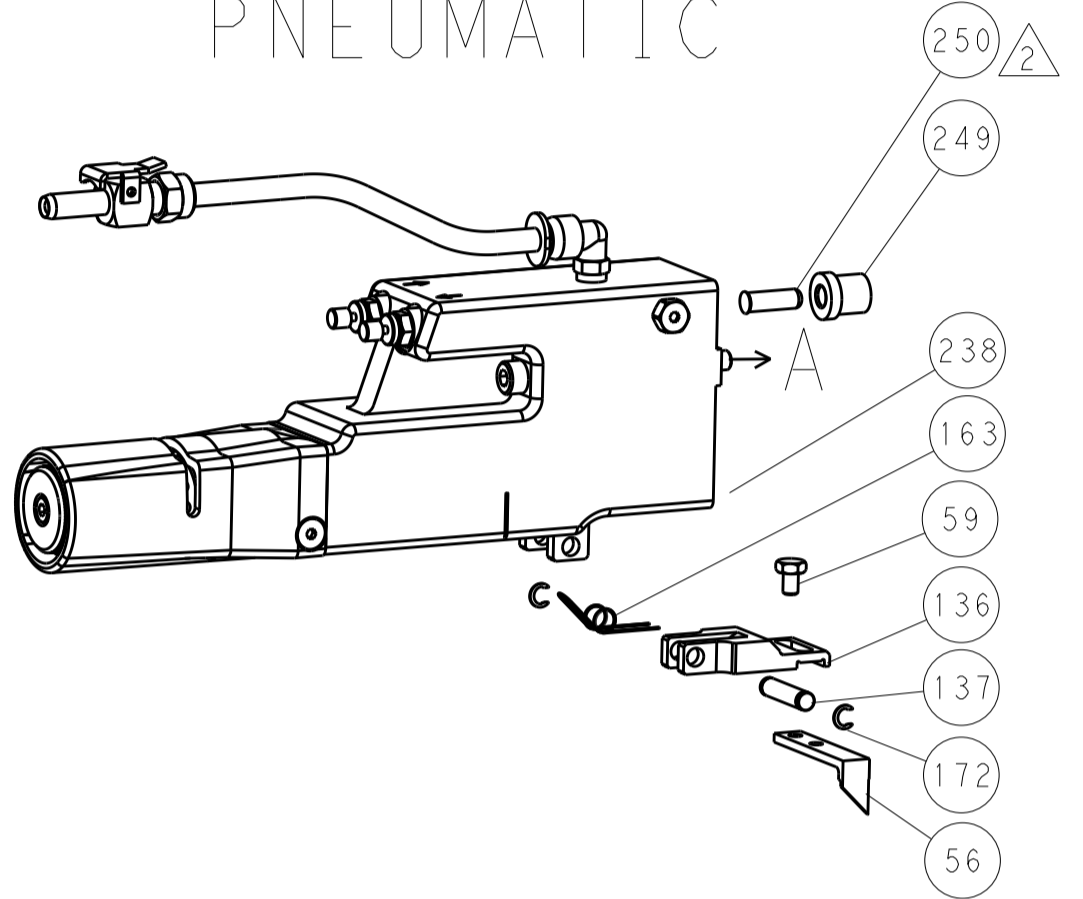
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		MATERIAL:		FINISH:		WEIGHT:		SCALE:		SHEET:		REV:				
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES	FINISH			Customer Accessible Production Drawing	SCALE	1:2	SHEET	1	OF	4	REV	E

LOC	DIST	REVISIONS			
P	LTN	DESCRIPTION	DATE	DMN	APVD
-	-	SEE SHEET 1	-	-	-

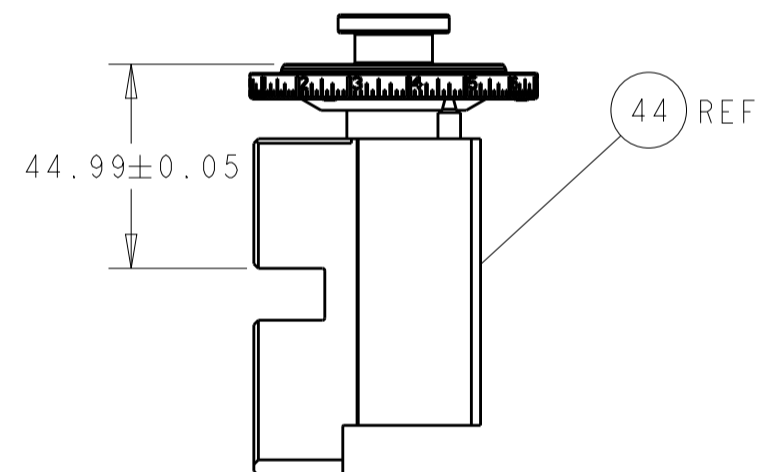
### FEED TYPE MECHANICAL



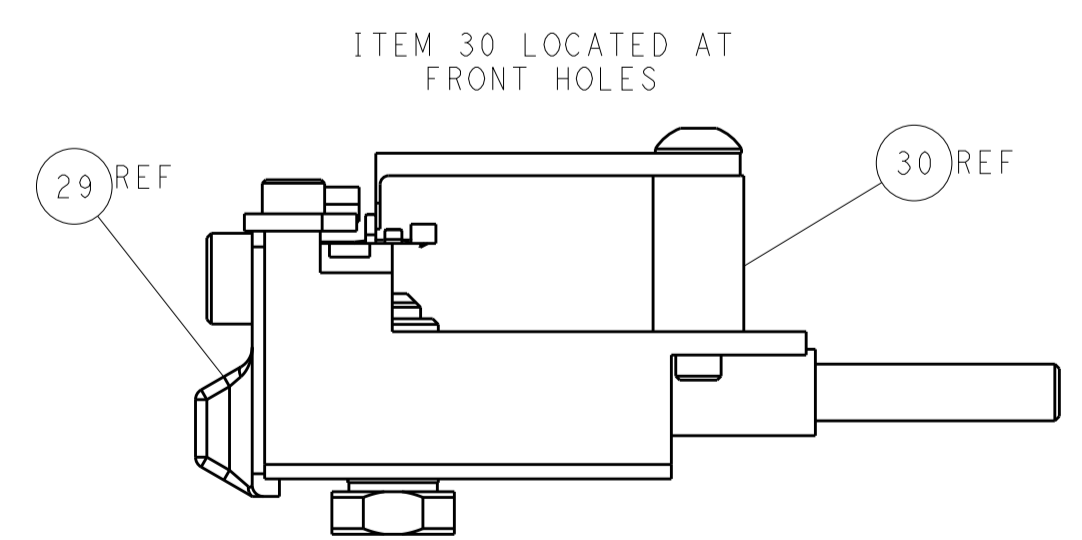
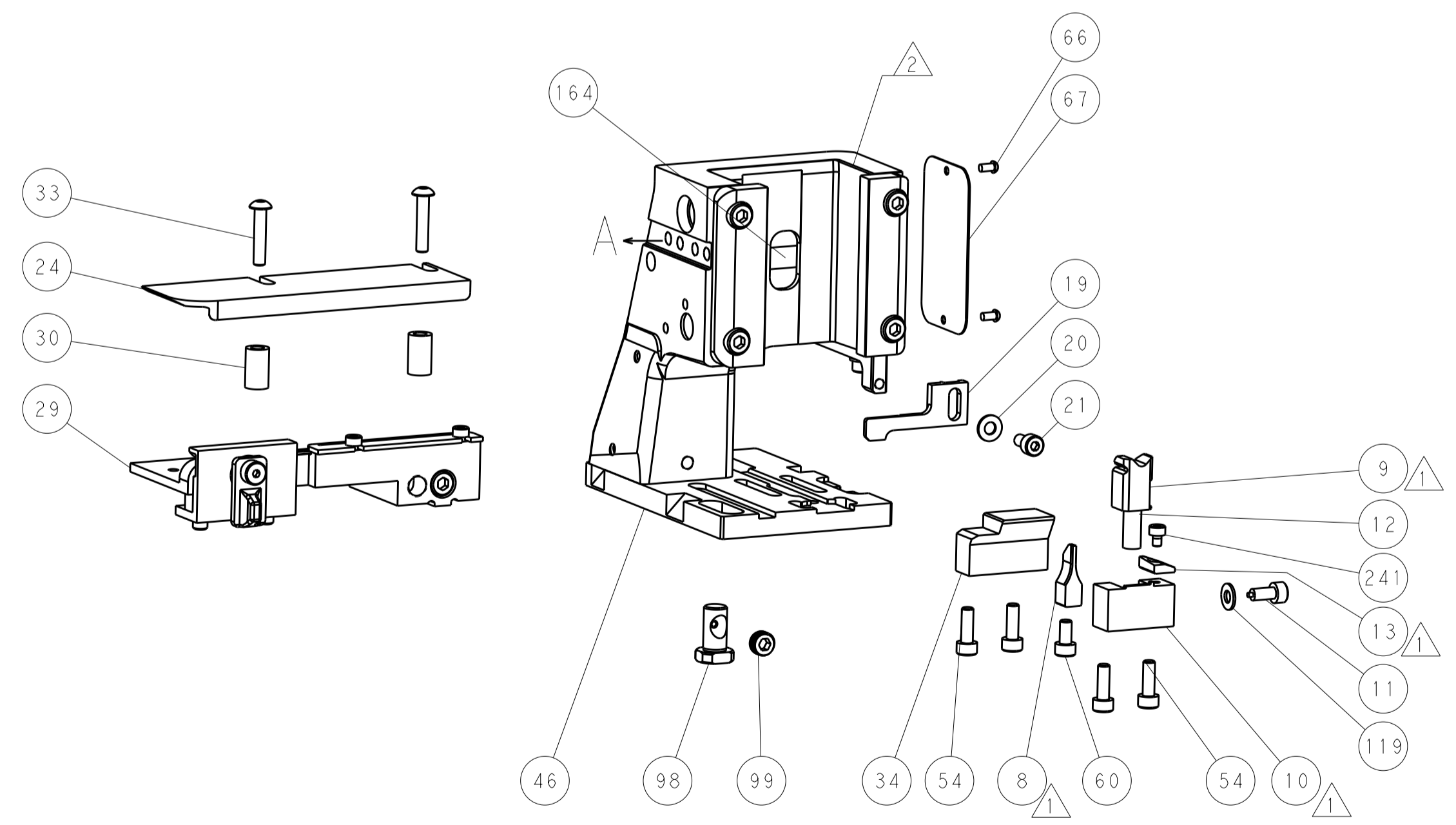
### PNEUMATIC



TERMINAL SUPPORT LOCATION



RAM SET-UP



FEED TRACK POSITION  
GUIDE BY INSULATION BARREL

### CAM POSITIONS



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

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG: BOB_HIGMAN 14AUG2013		
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	
MATERIAL:		FINISH:		APVD: T.ELBIN 14AUG2013		SIZE: A1
Customer Accessible Production Drawing		SCALE: 1:2		WEIGHT: -		RESTRICTED TO: -
SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION		SHEET 2 OF 4		CAGE CODE: 00779		REV: E

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2151983-1	E	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2151983-2	E	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151983-7	C	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR  
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.10 mm [.043]	F
INSUL	1.40 mm [.055]	F

APPLICATOR INSTRUCTIONS  
408-35042

TERMINAL DATA: HIROSE TERMINAL HIROSE CRIMP SPECIFICATION	
TERMINAL NAME: TERMINAL	
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE
2.00-2.50 mm [.079-.098 IN]	Ø0.80-1.50 mm [.031-.059 IN]
TERMINAL APPLICATION SPECIFICATION ATAD-P0514-283 Rev 1	
TERMINALS APPLIED	
TE TERMINAL	HIROSE TERMINAL
2113350-1	GT8-2428SCF

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
24 AWG	0.64+/-0.04 [.0252+/- .0016]	7.2
26 AWG	0.60+/-0.04 [.0232+/- .0016]	7.6
28 AWG	0.58+/-0.04 [.0228+/- .0016]	7.8



- 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.

**\*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)

LOC	DIST	REV	DATE	BY	APPV
-	-	1	-	-	-

REV	DATE	DESCRIPTION	ITEM NO	
-	1	2119640-1	PUSH ROD, AIR FEED	250
-	1	1803259-1	BUSHING, FLANGED	249
-	1	2119082-4	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
3	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
-	-	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	1	2063440-1	AIR FEED MODULE	238
-	2	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172
-	REF	994970-2	COUNTER, MAGNETIC	164
-	1	240638-1	SPRING, FEED FINGER	163
-	1	2119641-2	FEED CAM, AIR FEED	151
-	1	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	144
-	4	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	143
-	-	2119653-2	FEED CAM, POST FEED	142
-	1	1-1803583-0	APPLICATOR BASIC ASSEMBLY, SF	141
-	1	1803516-1	RAM ASSEMBLY, SF PACIFIC	140
-	1	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854	137
-	1	2119799-1	HOLDER, FEED FINGER, AF	136
-	1	1-18028-2	WASHER, FLAT, REG M4	119
-	1	2844908-1	SCREW, LOCKING	99
-	1	2844907-1	POST, LOCKING	98
-	1	455888-5	SPACER, CRIMPER	82
-	1	1803607-1	DOCUMENTATION PACKAGE	71
-	1	2119791-9	DEPRESSOR, WIRE	70
-	1	2119740-1	TAG, IDENTIFICATION	67
-	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	1	1338685-1	PAWL, FEED	56
-	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	-	2119652-1	FEED CAM, PRE FEED	48
-	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
-	1	2-1752356-6	SUPPORT, TERMINAL	34
-	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2-2844962-4	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	2844992-1	ASSEMBLY, STRIP GUIDE	29
-	1	1320928-2	STRIP GUIDE	24
-	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
-	1	1-18028-2	WASHER, FLAT, REG M4	20
-	1	2119533-1	STRIPPER, SIDE FEED	19
1	1	2119806-1	INSERT, SHEAR	13
-	1	3-22280-3	SPRING, COMPRESSION	12
-	1	1-356885-3	STOP, SHEAR	11
1	1	2119805-1	SHEAR HOLDER, FRONT	10
1	1	1803095-6	FLOATING SHEAR, FRONT	9
1	1	1803335-4	ANVIL, COMBINATION	8
-	-	-	-	7
-	-	-	-	6
-	1	1-2119757-8	DEPRESSOR, SHEAR	5
-	1	238011-6	BLOCK, CRIMPER SPACER	4
1	1	1803326-4	CRIMPER, INSULATION F	3
-	1	455888-4	SPACER, CRIMPER	2
1	1	1803324-7	CRIMPER, WIRE	1

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		MATERIAL:		FINISH:	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES ±	FINISH ±
APPLICATOR DATA		APPLICATOR DATA		APPLICATOR DATA		APPLICATOR DATA	
APPLICATOR DATA		APPLICATOR DATA		APPLICATOR DATA		APPLICATOR DATA	
APPLICATOR DATA		APPLICATOR DATA		APPLICATOR DATA		APPLICATOR DATA	

LOC	DIST	REVISIONS			
		P. LTM	DESCRIPTION	DATE	DWN APVD
-	-	-	SEE SHEET 1	-	-

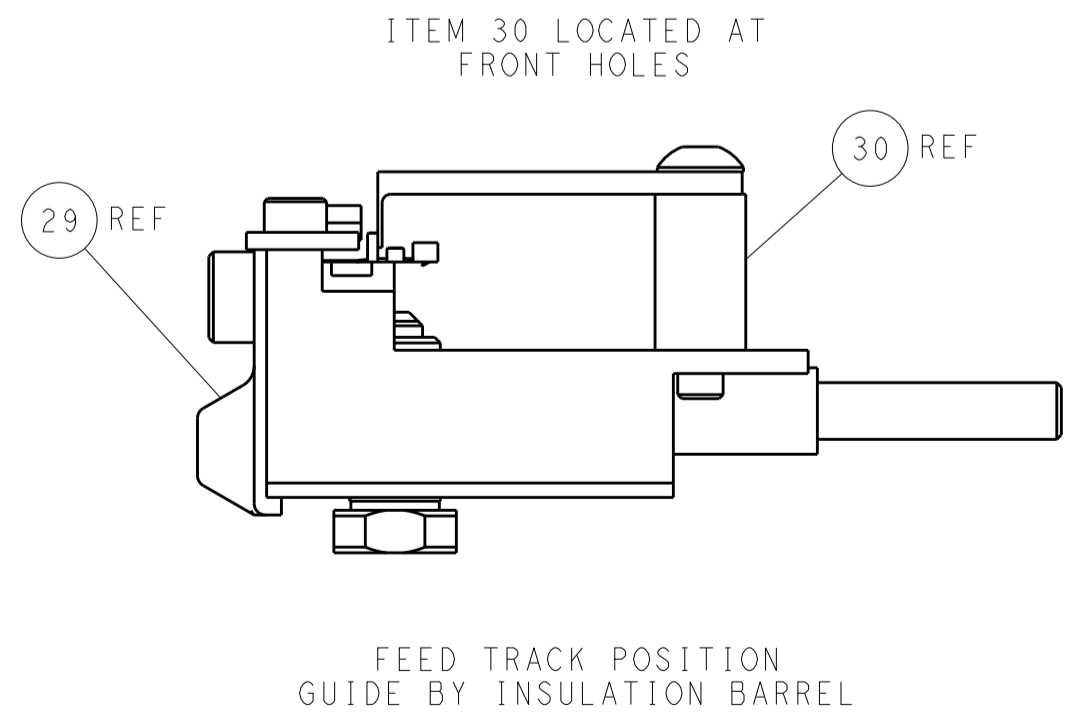
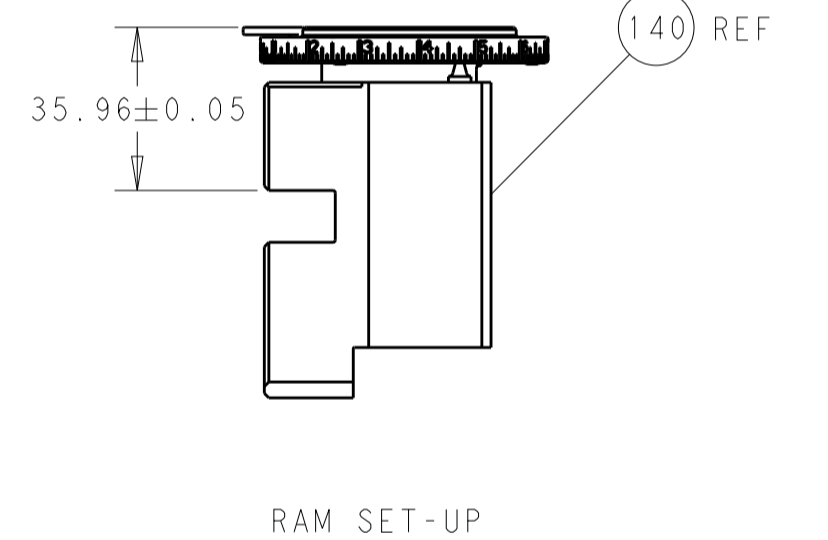
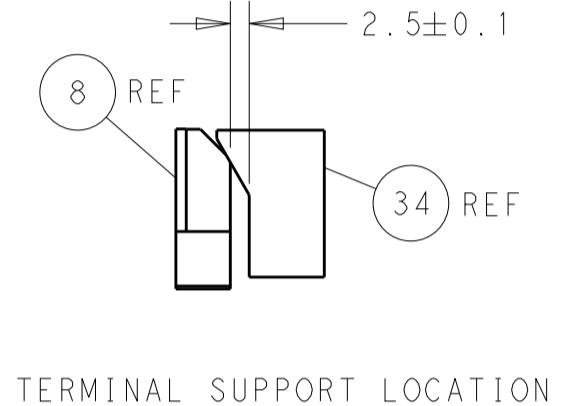
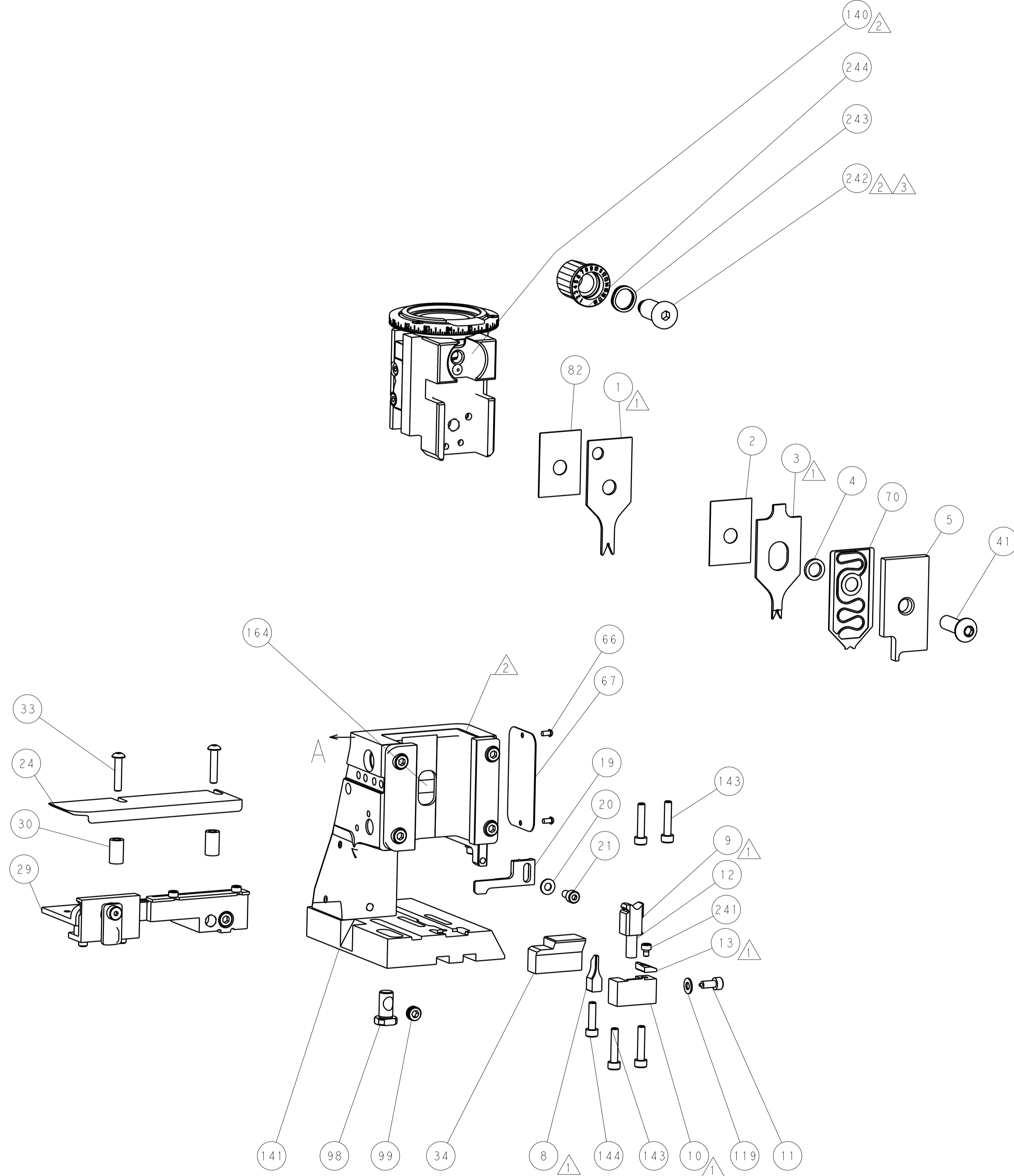
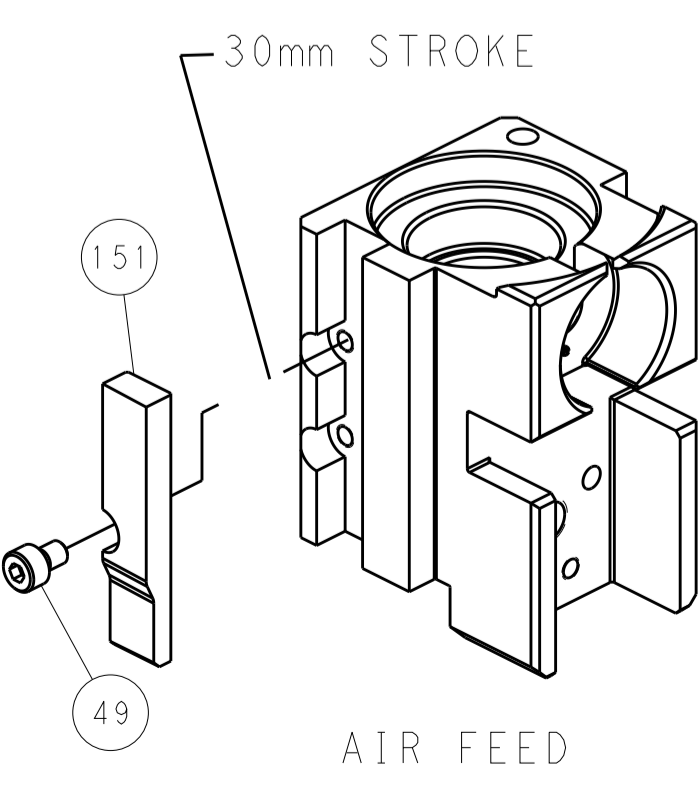
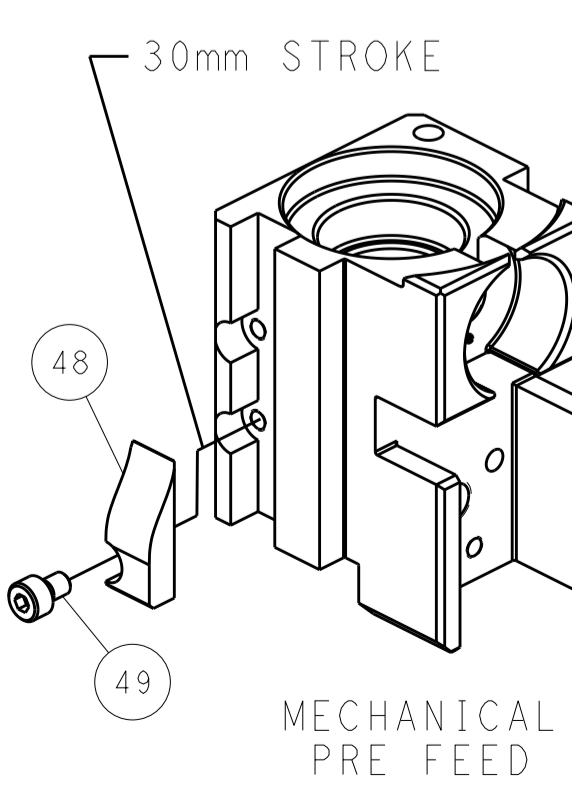
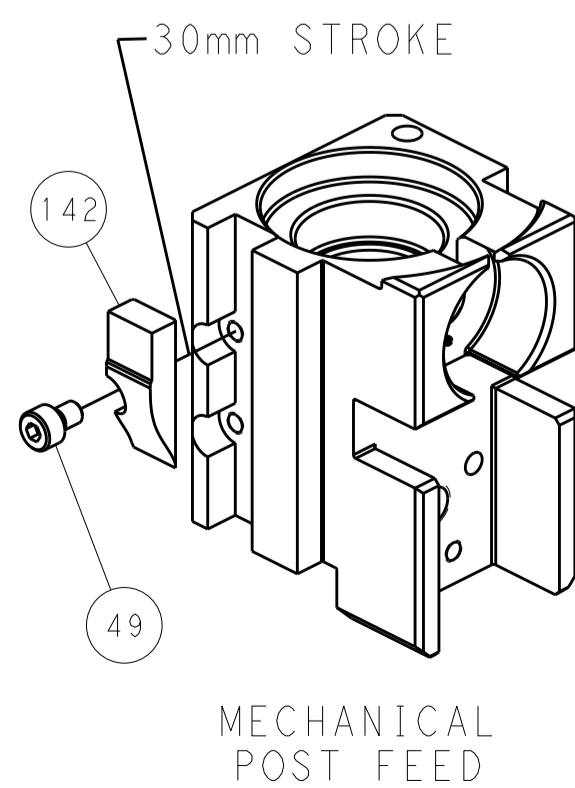
# FEED TYPE MECHANICAL



# PNEUMATIC



# CAM POSITIONS



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

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN BOB HIGMAN 14AUG2013		STE
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	
MATERIAL	FINISH	WEIGHT	SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
-	-	-	A1	00779	2151983	-
Customer Accessible Production Drawing			SCALE	SHEET	OF	REV
-			1:2	4	4	E