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ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER

PART NUMBER

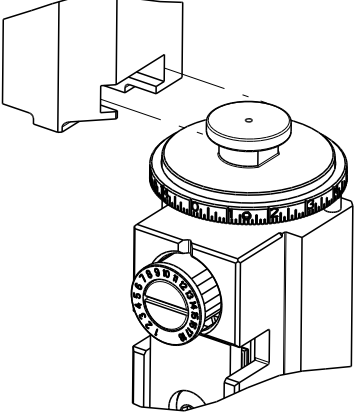
REVISION

DESCRIPTION

FEED TYPE

CONVERT TO

PART NUMBERS REQUIRED



2150630-2

A

FINE CRIMP HEIGHT ADJUST

PNEUMATIC

SERVO LATCH PLATE
SMART APPLICATOR

2119951-1
2161326-1

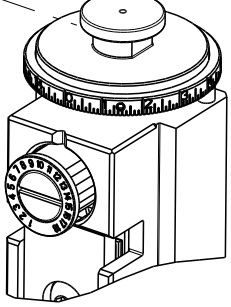
1901697-1
-

8-2150630-5
8-2150630-4

-
-

-
-

2168400-7 (QUANTITY 2)



2150630-5

A

FINE CRIMP HEIGHT ADJUST

SERVO LATCH PLATE

PNEUMATIC FEED

2119950-1
2119792-2

-
-

-
-

-
-

2063440-2

2150630-6

A

NON-CRIMP HEIGHT ADJUST

SERVO LATCH PLATE

-

-

-

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2150630-7

A

FINE CRIMP HEIGHT ADJUST

NONE

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-

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-

7-2150630-7

A

CRIMP TOOLING KIT

-

-

-

-

-

-

APPLICATOR DATA

CRIMP

SIZE

TYPE

WIRE

4.50 mm [.177]

F

INSUL

6.45 mm [.254]

F

APPL INSTRUCTIONS

408-10390

TERMINAL DATA: LEAR TERMINAL

LEAR CRIMP SPECIFICATION

TERMINAL NAME: RING TERMINAL

WIRE STRIP LENGTH

6.10-6.90 mm [.240-.272 IN]

INSULATION DIAMETER RANGE

Ø3.70-5.00 mm [.146-.197 IN]

TERMINAL APPLICATION SPECIFICATION

25806 Rev 13

-

-

TERMINALS APPLIED

TE TERMINAL

LEAR TERMINAL

TE TERMINAL

LEAR TERMINAL

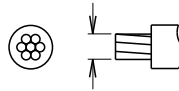
2113917-1

25806.214.012

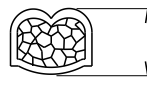
2113917-2

25806.417.011

WIRE SIZE



CRIMP HEIGHT mm [INCH]



CRIMP HEIGHT REFERENCE SETTING

FLY 6mm²

3.15+/-0.10 [.124+/- .004]

7.1

FLY 4mm²

2.95+/-0.10 [.116+/- .004]

8.7

RECOMMENDED SPARE PARTS

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:
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150630-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150630-5
SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2150630-6

5. ADJUSTMENT OF THE STRIPPER MAY BE REQUIRED WHEN MOVING THE APPLICATOR BETWEEN BENCH AND LEADMAKER APPLICATIONS.

APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 62.
APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242.
FOR -6 ONLY APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 37.

GREASE THREADS, GROOVE AND O-RING ON ITEMS 35 & 252.

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

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 PITCH NOT COMPATIBLE WITH MECHANICAL FEED.

WHEN ASSEMBLING -6 NON-CRIMP HEIGHT ADJUST APPLICATOR USE SHIM PACK 2119957-2 TO ALIGN APPLICATOR'S MAXIMUM WIRE CRIMP HEIGHT AT NORMAL TERMINATOR SHUT HEIGHT

CUT TO LENGTH AT ASSEMBLY.

ATLANTIC VERSION

Shown on sheets 1 of 4 & 2 of 4

(Pacific version shown on sheets 3 of 4 & 4 of 4)

REVISIONS

SET UP GAUGE 2119599-2

LOC A

DIST 66

REV

DATE

OWN

APVD

DESCRIPTION

RELEASED

14DEC2015

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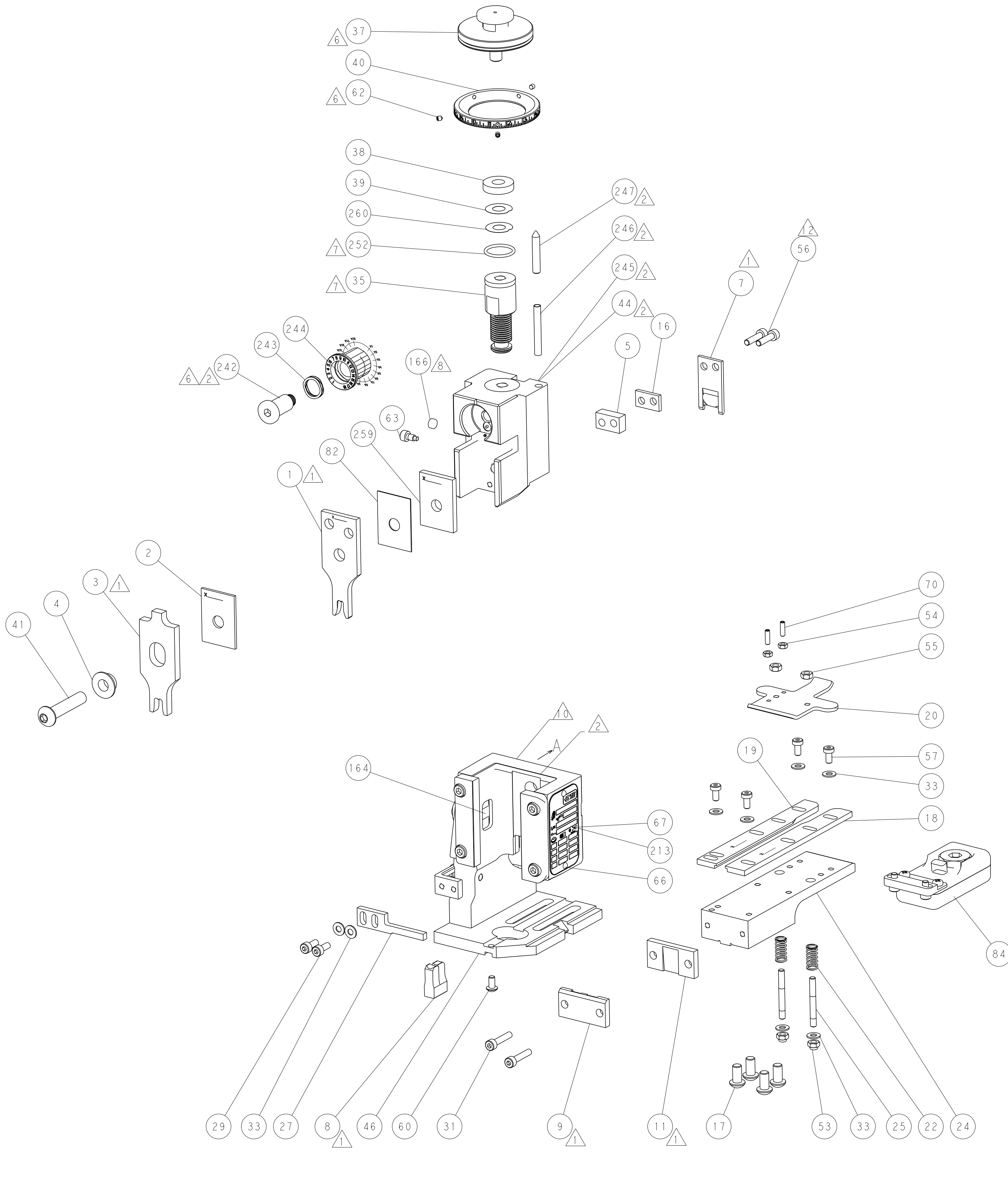
164

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

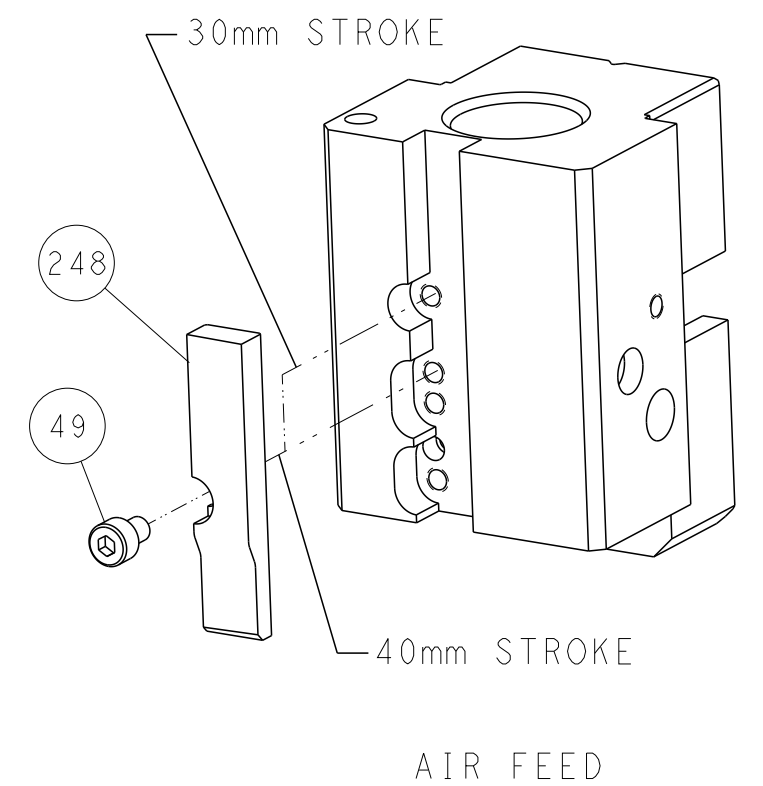


FEED TYPE

PNEUMATIC

SERVO
LATCH PLATE

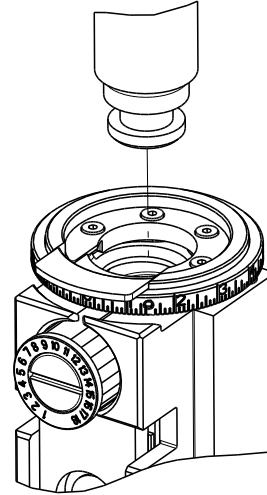
CAM POSITION



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 06NOV2015		NAME U. GUO 06NOV2015	Ocean End Feed Applicator	
DIMENSIONS: mm		PRODUCT SPEC	SIZE A1	
TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH		APPLICATION SPEC	CAGE CODE 00779	
MATERIAL		WEIGHT	DRAWING NO 2150630	
		Customer Accessible Production Drawing	SCALE 1:1	
			SHEET 2 OF 4	
			REV A	

SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

8		7	
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PACIFIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION
	2-2150630-2	A	FINE CRIMP HEIGHT ADJUST
	2-2150630-5	A	FINE CRIMP HEIGHT ADJUST
	2-2150630-7	A	FINE CRIMP HEIGHT ADJUST
	7-2150630-7	A	CRIMP TOOLING KIT

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	4.50 mm [.177]	F
INSUL	6.45 mm [.254]	F
APPL INSTRUCTIONS 408-10390		

TERMINAL DATA: LEAR TERMINAL		LEAR CRIMP SPECIFICATION	
TERMINAL NAME: RING TERMINAL			
WIRE STRIP LENGTH 6.10-6.90 mm [.240-.272 IN]		INSULATION DIAMETER RANGE Ø3.70-5.00 mm [.146-.197 IN]	
TERMINAL APPLICATION SPECIFICATION	25806 Rev 13	-	-
TERMINALS APPLIED			
TE TERMINAL	LEAR TERMINAL	TE TERMINAL	LEAR TERMINAL
2113917-1	25806.214.012	2113917-2	25806.417.011

WIRE SIZE 		CRIMP HEIGHT mm [INCH] 	CRIMP HEIGHT REFERENCE SETTING 
FLY 6mm ²		3.15+/-0.10 [.124+/- .004]	7.1
FLY 4mm ²		2.95+/-0.10 [.116+/- .004]	8.7



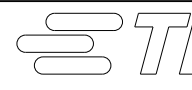
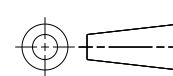
-  RECOMMENDED SPARE PARTS
-  GREASE BEARING SURFACES LIGHTLY
3. LUBRICATE DAILY PER THE APPLICATOR INSTRUCTION SHEET SUPPLIED WITH THE APPLICATOR.
-  APPLICATOR SPECIFIC DATA TO BE ENTERED INTO BLANK MEMORY CHIP AT ASSEMBLY. SEE BELOW FOR PART NUMBER:
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150630-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150630-5
5. ADJUSTMENT OF THE STRIPPER MAY BE REQUIRED WHEN MOVING THE APPLICATOR BETWEEN BENCH AND LEADMAKER APPLICATIONS.
-  APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 62.
APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242.
-  GREASE THREADS, GROOVE AND O-RING ON ITEMS 139 & 153.
-  MAGNET, ITEM 166 MUST BE ORIENTED CORRECTLY IN ORDER TO PROPERLY ACTUATE THE COUNTER.
-  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 PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
-  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.
-  CUT TO LENGTH AT ASSEMBLY.

*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.

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

SET UP GAUGE 2119599-2	LOC A	DIST 66	REVISIONS			
			P	LTR	DESCRIPTION	DATE
				-	SEE SHEET 1	-

	-	1	1	1	1803078-3	SPACER, PRECISION	259			
	-	1	1	1	2119782-1	FINE ADJUST HEAD ASM, PACIFIC STYLE	251			
	-	-	-	1	2119640-1	PUSH ROD, AIR FEED	250			
	-	-	-	1	2079988-1	BUSHING, LCH5-12, MISUMI	249			
	-	1	1	1	1-22279-3	SPRING, COMPRESSION	246			
	-	1	1	1	2119082-2	CAM, SNAIL, INSULATION ADJUSTMENT	244			
	-	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243			
6	-	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242			
	-	-	2	-	2168400-7	SHCS, LOW HEAD, RoHS, M5 X 10	240			
	-	-	-	1	2063440-2	AIR FEED MODULE	238			
	-	-	1	-	2119740-2	TAG, IDENTIFICATION	213			
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				CHK L. ZHANG	06NOV2015										
				APVD J. GUO	06NOV2015										
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		NAME		Ocean End Feed Applicator -									
mm				PRODUCT SPEC											
				APPLICATION SPEC											
MATERIAL		FINISH		WEIGHT		SIZE		CAGE CODE		DRAWING NO		RESTRICTED TO			
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Customer Accessible Production Drawing						SCALE		1:1		SHEET		3 OF 4		REV A	

