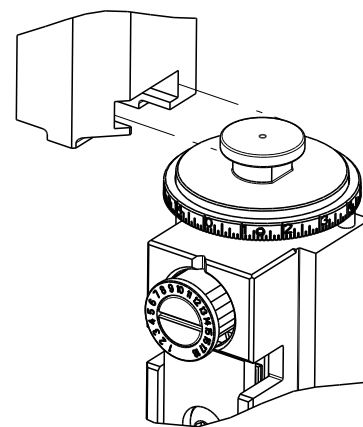
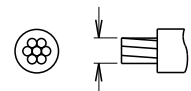
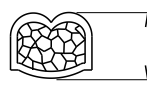


8		7	
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ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION
	2150485-1	A	FINE CRIMP HEIGHT ADJUST
	2150485-2	A	FINE CRIMP HEIGHT ADJUST
	2150485-5	A	FINE CRIMP HEIGHT ADJUST
	2150485-6	A	NON-CRIMP HEIGHT ADJUST
	2150485-7	A	FINE CRIMP HEIGHT ADJUST
	7-2150485-7	A	CRIMP TOOLING KIT

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.78 mm [.070]	F
INSUL	2.50 mm [.098]	F
APPL INSTRUCTIONS 408-10390		

TERMINAL DATA: STEWART WARNER TERMINATOR CRIMP SPECIFICATION			
TERMINAL NAME: 6.3 TERMINAL SELF LOCKING RECEPTACLE			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
4.65-5.42 mm [.183-.213 IN]		Ø 1.70mm MAX [.067 IN MAX]	
TERMINAL APPLICATION SPECIFICATION	NONE	-	-
TERMINALS APPLIED			
TE TERMINAL	STEWART WARNER TERMINAL	TE TERMINAL	STEWART WARNER TERMINAL
2113585-1	SO.481.622	2113585-2	172773

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING
18 AWG		1.44+/-0.05 [.057+/- .002]		6.8



- 1 RECOMMENDED SPARE PARTS
- 2 GREASE BEARING SURFACES LIGHTLY
3. LUBRICATE DAILY PER THE APPLICATOR INSTRUCTION SHEET SUPPLIED WITH THE APPLICATOR.
- 4 APPLICATOR SPECIFIC DATA TO BE ENTERED INTO BLANK MEMORY CHIP AT ASSEMBLY. SEE BELOW FOR PART NUMBER:
MECHANICAL FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150485-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150485-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150485-5
SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2150485-6
5. ADJUSTMENT OF THE STRIPPER MAY BE REQUIRED WHEN MOVING THE APPLICATOR BETWEEN BENCH AND LEADMAKER APPLICATIONS.
- 6 APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 62 & 180.
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 & 180.
- 7 GREASE THREADS, GROOVE AND O-RING ON ITEMS 35 & 252.
- 8 MAGNET, ITEM 166 MUST BE ORIENTED CORRECTLY IN ORDER TO PROPERLY ACTUATE THE COUNTER.
- 9 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.
- 10 SPARE FEED CAM STORAGE LOCATION REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.
- 11 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.
- 12 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

*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.

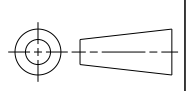
-	-	1	-	-	-	2119957-2	APPLICATOR SHIM PACK	260
-	1	-	1	1	1	8-21084-0	O-RING, .676 ID, .070 DIA. MAT.	252
-	-	-	-	1	-	2119640-1	PUSH ROD, AIR FEED	250
-	-	-	-	1	-	2079988-1	BUSHING, LCH5-12, MISUMI	249
-	-	-	-	1	-	2119641-1	FEED CAM, AIR FEED	248
-	1	-	1	1	1	2119798-1	DETENT PIN	247
-	1	-	1	1	1	1-22279-3	SPRING, COMPRESSION	246
-	-	1	-	-	-	2119759-1	RAM, AMP STYLE, END FEED, NON-ADJUST	245
-	1	1	1	1	1	2119082-1	CAM, SNAIL, INSULATION ADJUSTMENT	244
-77	-7	-6	-5	-2	-1	PART NO	DESCRIPTION	ITEM NO

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

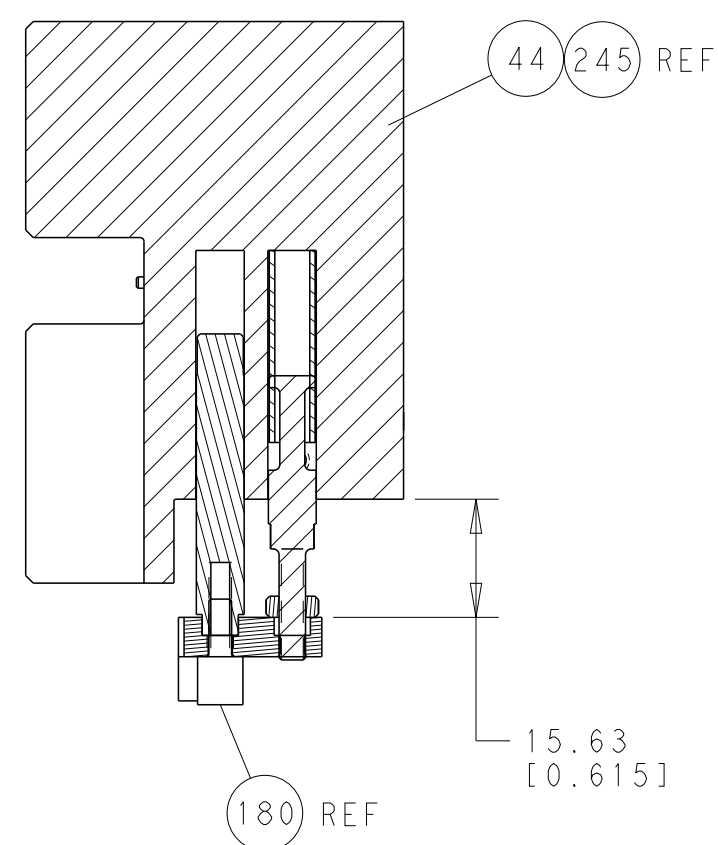
SET UP GAUGE 2119599-2	LOC A	DIST 66	REVISIONS					
			P	LTR	DESCRIPTION	DATE	DWN	APVD
				A	RELEASED	04NOV2014	RK	GB

-	1	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	-	2	2	-	-	2168400-7	SHCS, LOW HEAD, RoHS, M5 X 10	240
-	-	-	-	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	-	-	-	1	-	2063440-1	AIR FEED MODULE	238
-	-	1	1	-	-	2119740-2	TAG, IDENTIFICATION	213
-	-	REF	REF	-	-	1901697-1	FEED FINGER ASSEMBLY, EF	183
-	1	1	1	1	1	1-1752354-0	STANDOFF, HOLD-DOWN	180
-	1	1	1	1	1	6-993111-6	PIN, SLOTTED SPRING 3.0 X 14.0	177
-	1	1	1	1	1	8-22280-7	SPRING, COMPRESSION	176
-	1	1	1	1	1	1752353-2	GUIDE PIN, HOLDDOWN	175
-	1	1	1	1	1	1901680-2	GUIDE PIN, HOLDDOWN	174
-	-	-	-	2	-	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172
-	1	1	1	1	1	994969-1	MAGNET, RARE EARTH HIGH ENERGY	166
-	REF	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	-	-	-	1	-	240638-1	SPRING, FEED FINGER	163
-	-	-	-	1	-	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854	137
-	-	REF	REF	-	-	SEE NOTE 4	MEMORY CHIP, PROGRAMMED	135
-	-	1	1	-	-	1633743-1	SERVO FEED LATCH ASM	133
-	1	1	1	1	1	455888-5	SPACER, CRIMPER	82
-	1	1	1	1	1	2119956-2	DOCUMENTATION PACKAGE	71
-	2	2	2	2	2	2-18032-2	SCR, SET, FLT POINT M3 X 10.0	70
-	1	-	-	1	1	2119740-1	TAG, IDENTIFICATION	67
-	2	2	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	1	1	1	1	1	1901681-1	HOLDDOWN, TERMINAL	65
-	2	2	2	2	2	2168400-8	SHCS, LOW HEAD, RoHS, M4 X 16	64
-	1	-	-	1	1	2119793-1	LIMITER, ADJUSTMENT BOLT	63
-	3	-	3	3	3	992763-5	SCR, SET, SOC, CONE POINT, M3 x 4.0	62
-	1	1	1	1	1	2079383-4	SCR, BHSC, RoHS (M4 X 8)	60
-	-	-	-	-	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	-	-	-	-	1	2063961-1	FEED FINGER	58
-	3	3	3	3	3	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57
-	2	2	2	2	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	56
-	2	2	2	2	2	5018030-2	NUT, HEX, REG, RoHS, M4	55
-	2	2	2	2	2	5018030-1	NUT, HEX, REG, RoHS, M3	54
-	2	2	2	2	2	986965-8	NUT, LOCK, HEX, TORQUE (M4)	53
-	1	1	1	1	1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52
-	-	-	-	1	-	2119792-2	PAWL, EF, AIR	51
-	-	-	-	1	2	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	-	-	-	-	1	2119652-1	FEED CAM, PRE FEED	48
-	-	-	-	-	1	2119653-1	FEED CAM, POST FEED	47
-	1	1	1	1	1	2119655-5	APPLICATOR BASIC ASSEMBLY, EF	46
-	1	-	1	1	1	2119369-1	RAM, AMP STYLE, END FEED	44
-	1	1	1	1	1	2079383-7	SCR, BHSC, RoHS (M8 X 25)	41
-	1	-	1	1	1	2119645-1	DISC, NUMBERED FA WIRE ADJUSTMENT	40
-	1	-	1	1	1	2119957-1	APPLICATOR SHIM PACK	39
-	1	1	1	1	1	1-2119644-2	RAM WASHER, PRECISION	38
-	1	1	1	1	1	2119085-1	FA HEAD, ATLANTIC STYLE	37
-	1	-	1	1	1	2119092-1	BOLT, ADJUSTMENT	35
-	7	7	7	7	7	1-18028-2	WASHER, FLAT, REG M4	33
-	2	2	2	2	2	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	31
-	2	2	2	2	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	29
-	1	1	1	1	1	240639-1	STRIPPER (MACHINING)	27
-	2	2	2	2	2	1320906-1	STUD, THREADED	25
-	1	1	1	1	1	1752371-5	PLATE, STRIP GUIDE	24
-	1	1	1	1	1	240825-1	PLATE, STRIP HOLD DOWN	23
-	2	2	2	2	2	2-22281-3	SPRING, COMPRESSION	22
-	1	1	1	1	1	1752373-4	DRAG	20
-	2	2	2	2	2	1901259-4	GUIDE, LOWER STRIP	18
-	4	4	4	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17
-	1	1	1	1	1	5-240641-2	SPACER	16
-	1	1	1	1	1	1752360-1	SPACER, HOLD-DOWN	13
-	1	1	1	1	1	240644-1	PLATE, REAR SHEAR	11

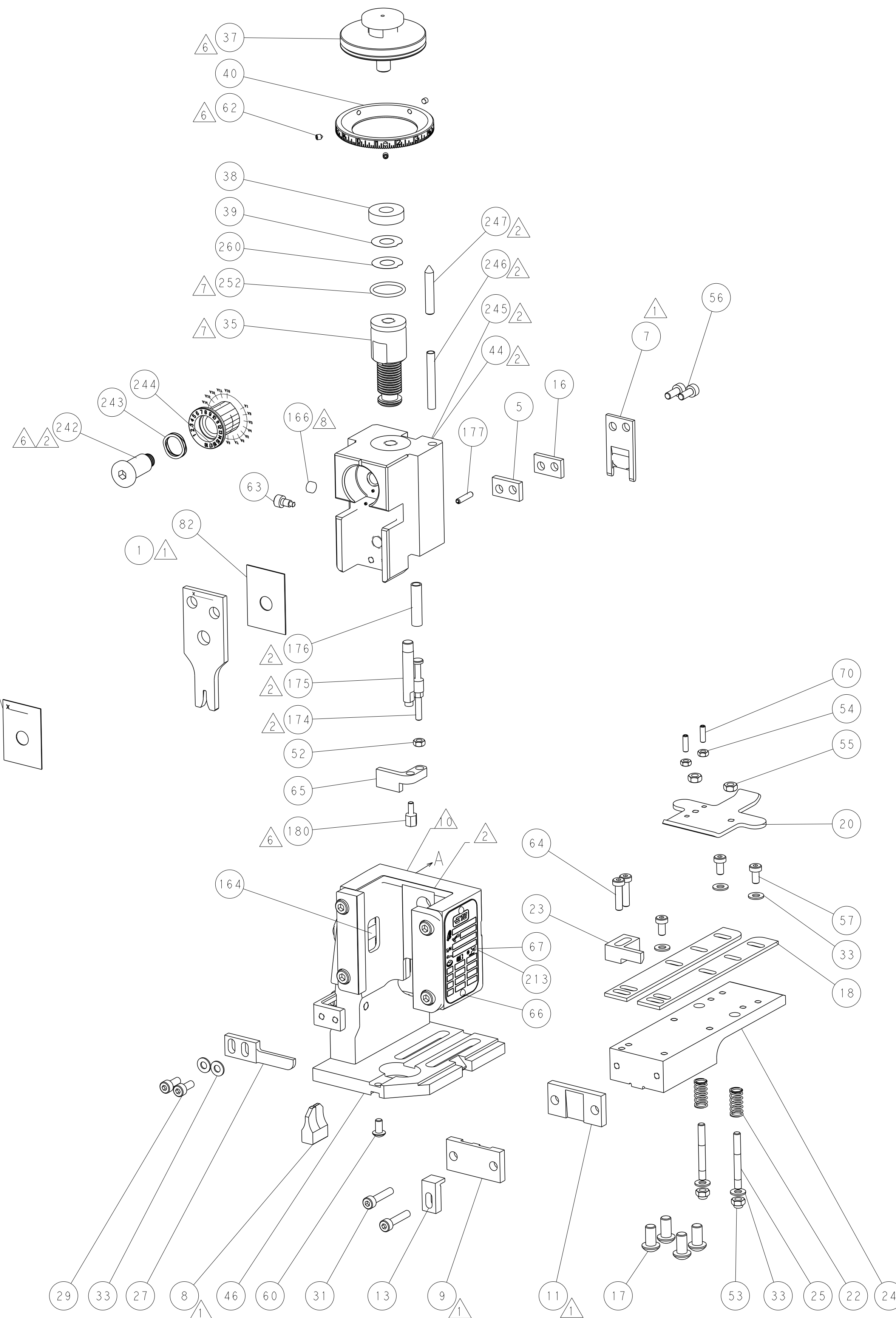
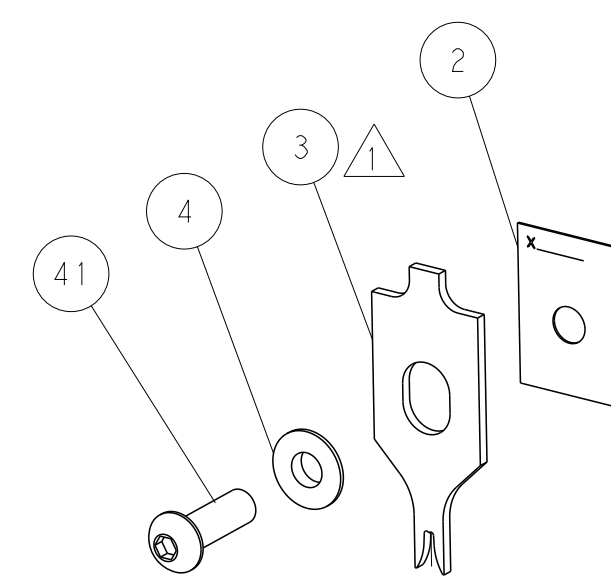
-	-	-	-	-	-	-	-	10
-	1	1	1	1	1	1	690482-6	PLATE, FRONT SHEAR
1	1	1	1	1	1	1	1-1803059-4	ANVIL, COMBINATION, END FEED
-	1	1	1	1	1	1	2217206-4	BLADE, SLUG
-	-	-	-	-	-	-	-	6
-	1	1	1	1	1	1	240641-1	SPACER
-	1	1	1	1	1	1	238009-4	BLOCK, FL CRIMPER SPACER
1	1	1	1	1	1	1	4-1633961-5	CRIMPER, INSULATION F PREMIUM
-	1	1	1	1	1	1	455888-4	SPACER, CRIMPER
1	1	1	1	1	1	1	3-456404-9	CRIMPER, WIRE PREMIUM

1. THIS IS SUBJECT TO CHANGE. USER REQUIREMENTS AND THE APPLICATOR'S ORGANIZATION SHALL BE CONTACTED FOR THE LATEST NOTATION.		DWN T. YIN	10SEP2014	STE TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm		CHK G. BAILEY	10SEP2014	NAME Ocean End Feed Applicator	
		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.5 1 PLC ±.0.5 2 PLC ±.0.13 3 PLC ±.0.13 4 PLC ±.0.0001 ANGLES ±.5		PRODUCT SPEC - APPLICATION SPEC -	
MATERIAL -		FINISH -		SIZE A1	
		WEIGHT -		CAGE CODE 00779	
				DRAWING NO C=2150485	
				RESTRICTED TO -	
				Customer Accessible Production Drawing	
				SCALE 1:1	
				SHEET 1	
				OF 4	
				REV A	

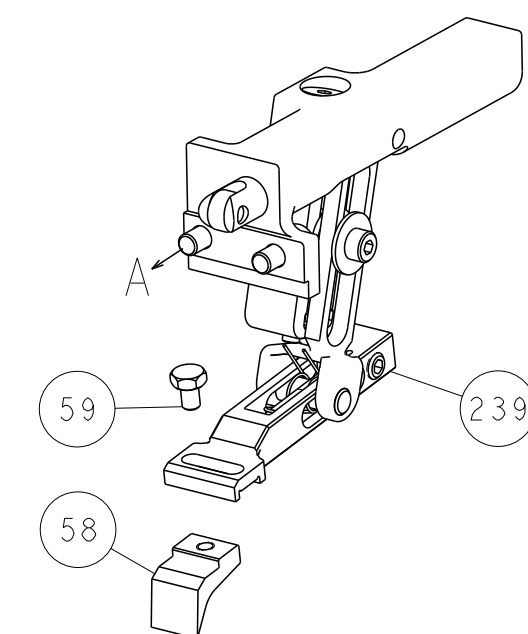
SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION



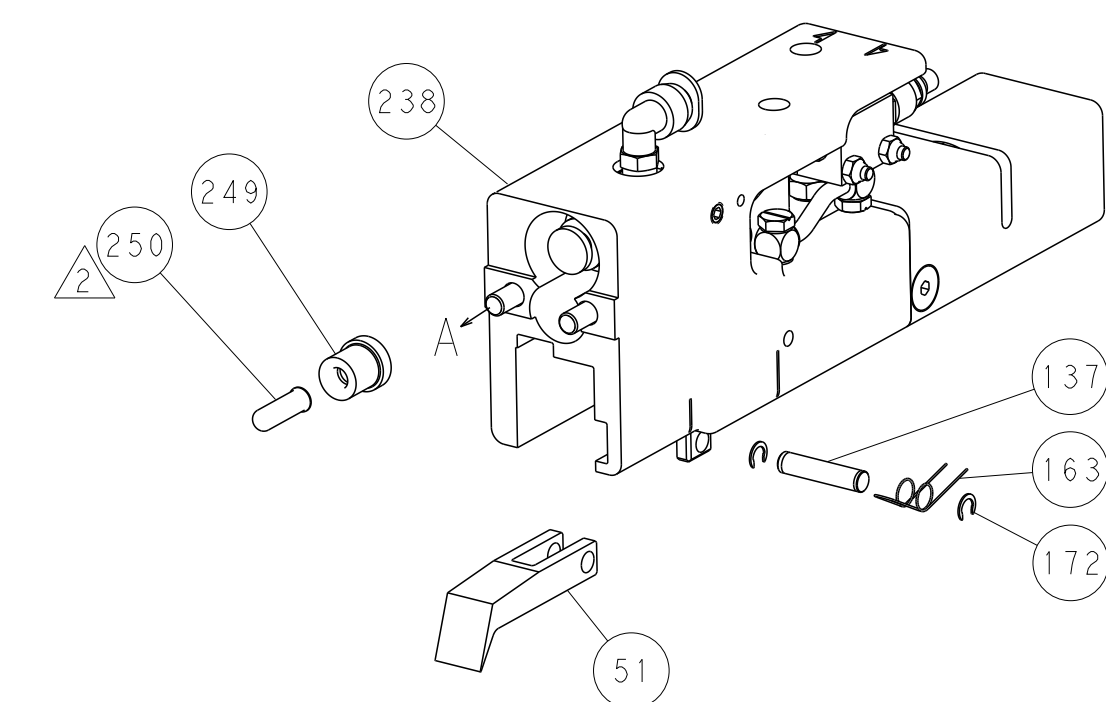
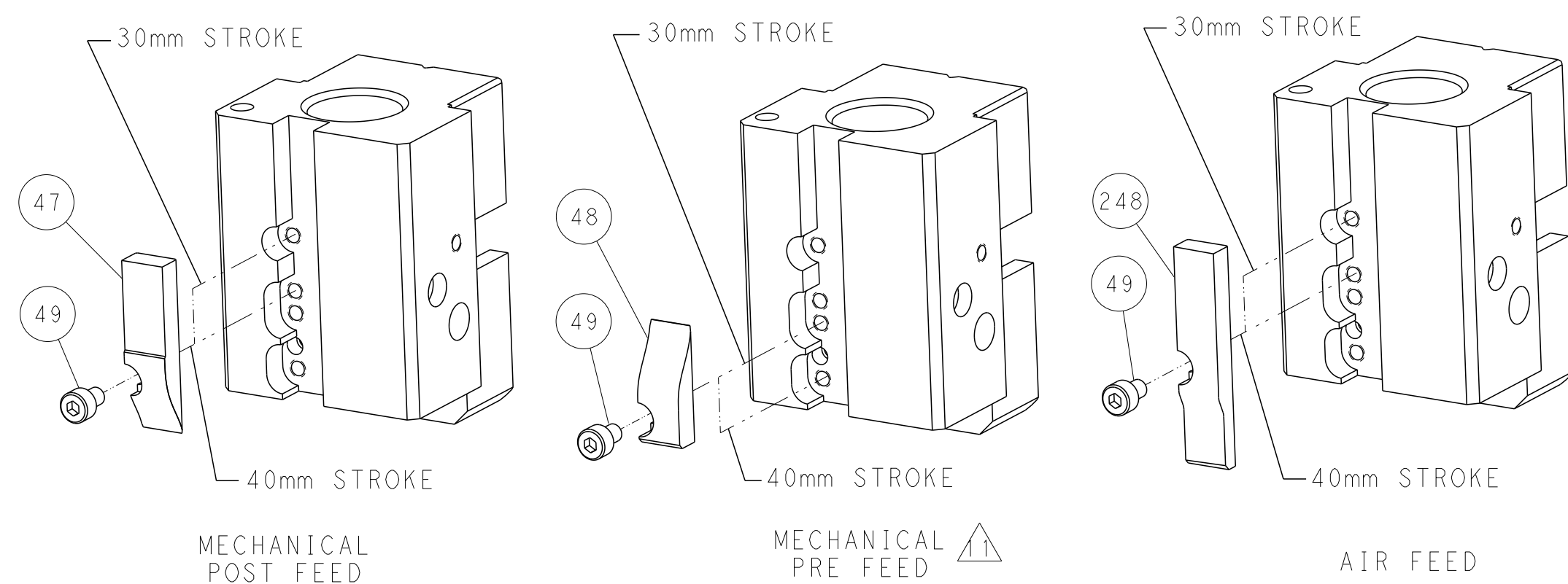
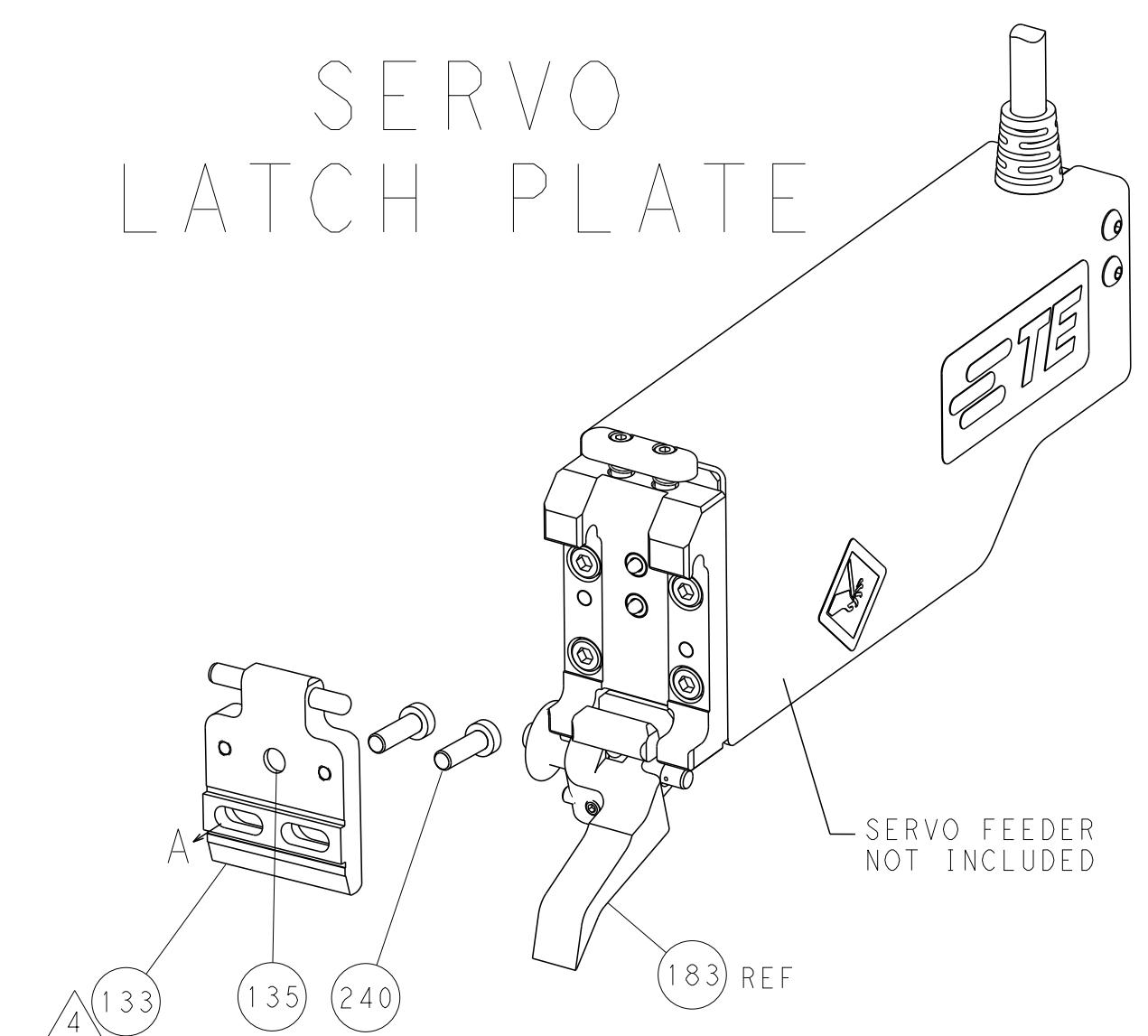
HOLDDOWN SET-UP



FEED TYPE
MECHANICAL



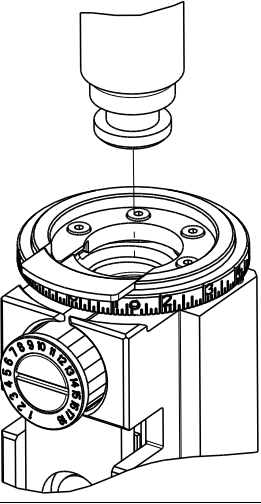
PNEUMATIC

SERVO
LATCH PLATE

ATLANTIC VERSION

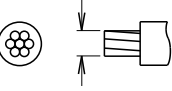
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

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DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		NAME	
mm		0 PLC ±.0 1 PLC ±.5 2 PLC ±0.13 3 PLC ±0.013 4 PLC ±0.0001 ANGLES ±.		Ocean End Feed Applicator	
		APPLICATION SPEC		SIZE	
MATERIAL		FINISH		CAGE CODE	
-		-		DRAWING NO	
		WEIGHT		C=2150485	
		-		RESTRICTED TO	
				-	
Customer Accessible Production Drawing				SCALE 1:1 SHEET 2 of 4 REV A	

PACIFIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART						
					CONVERT TO	PART NUMBERS REQUIRED					
	2-2150485-1	A	FINE CRIMP HEIGHT ADJUST	MECHANICAL	PNEUMATIC FEED	2119950-1	2119792-2	-	2119641-2	-	2063440-1
					SERVO LATCH PLATE	2119951-1	1901697-1	8-2150485-5	-	-	2168400-7 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2150485-4	-	-	-
	2-2150485-2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	MECHANICAL FEED	2119949-1	2063961-1	5-18022-5	2119653-2	-	-
					SERVO LATCH PLATE	2119951-1	1901697-1	8-2150485-5	-	-	2168400-7 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2150485-4	-	-	-
	2-2150485-5	A	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE ⁴	MECHANICAL FEED	2119949-1	2063961-1	5-18022-5	2119653-2	-	-
					PNEUMATIC FEED	2119950-1	2119792-2	-	2119641-2	-	2063440-1
	2-2150485-7	A	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	-
	7-2150485-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.78 mm [.070]	F
INSUL	2.50 mm [.098]	F
APPL INSTRUCTIONS 408-10390		

TERMINAL DATA: STEWART WARNER TERMINATOR CRIMP SPECIFICATION			
TERMINAL NAME: 6.3 TERMINAL SELF LOCKING RECEPTACLE			
WIRE STRIP LENGTH 4.65-5.42 mm [.183-.213 IN]		INSULATION DIAMETER RANGE Ø 1.70mm MAX [.067 IN MAX]	
TERMINAL APPLICATION SPECIFICATION	NONE	-	-
TERMINALS APPLIED	-	-	-
TE TERMINAL	STEWART WARNER TERMINAL	TE TERMINAL	STEWART WARNER TERMINAL
2113585-1	SO.481.622	2113585-2	172773

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING ⁹
18 AWG		1.44+/-0.05 [.057+/-0.002]		6.8



- RECOMMENDED SPARE PARTS

GREASE BEARING SURFACES LIGHTLY

3. LUBRICATE DAILY PER THE APPLICATOR INSTRUCTION SHEET SUPPLIED WITH THE APPLICATOR.

4. APPLICATOR SPECIFIC DATA TO BE ENTERED INTO BLANK MEMORY CHIP AT ASSEMBLY. SEE BELOW FOR PART NUMBER:
MECHANICAL FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150485-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150485-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150485-5

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

6. APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 62 & 180.
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.

10. SPARE FEED CAM STORAGE LOCATION REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.

11. 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.

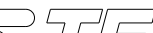
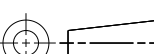
*WARNING
ON INSTALLATION, SET WIRE DISC, ITEM 40 TO LARGEST WIRE SIZE SETTING. USE OF SETTINGS BELOW MINIMUM REQUIRED CRIMP HEIGHT SETTING WILL CAUSE DAMAGE TO CRIMP TOOLING.

-	1	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	1-22279-3	SPRING, COMPRESSION	246
-	1	1	1	1	2119082-1	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
-77-27-25-22-21					PART NO	DESCRIPTION	ITEM NO

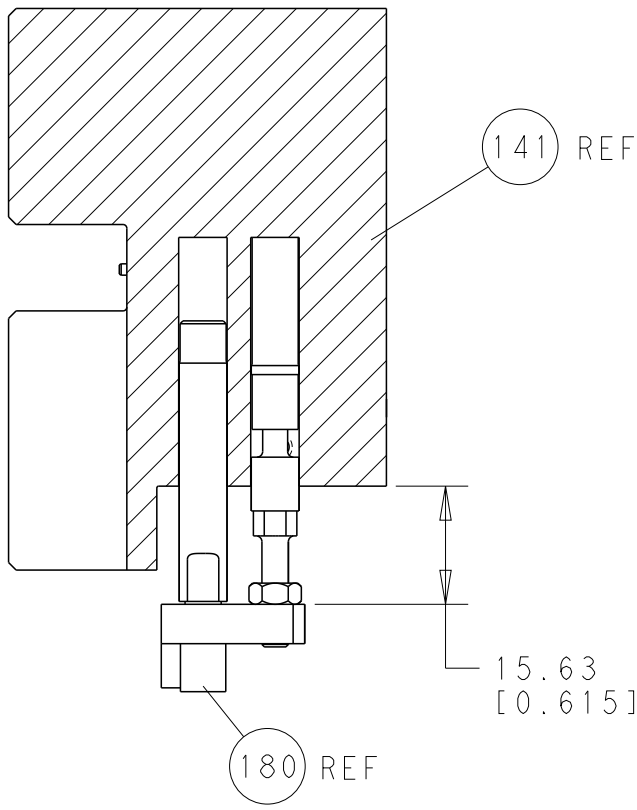
PACIFIC VERSION
Shown on sheets 3 of 4 & 4 of 4
(Atlantic version shown on sheets 1 of 4 & 2 of 4)

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

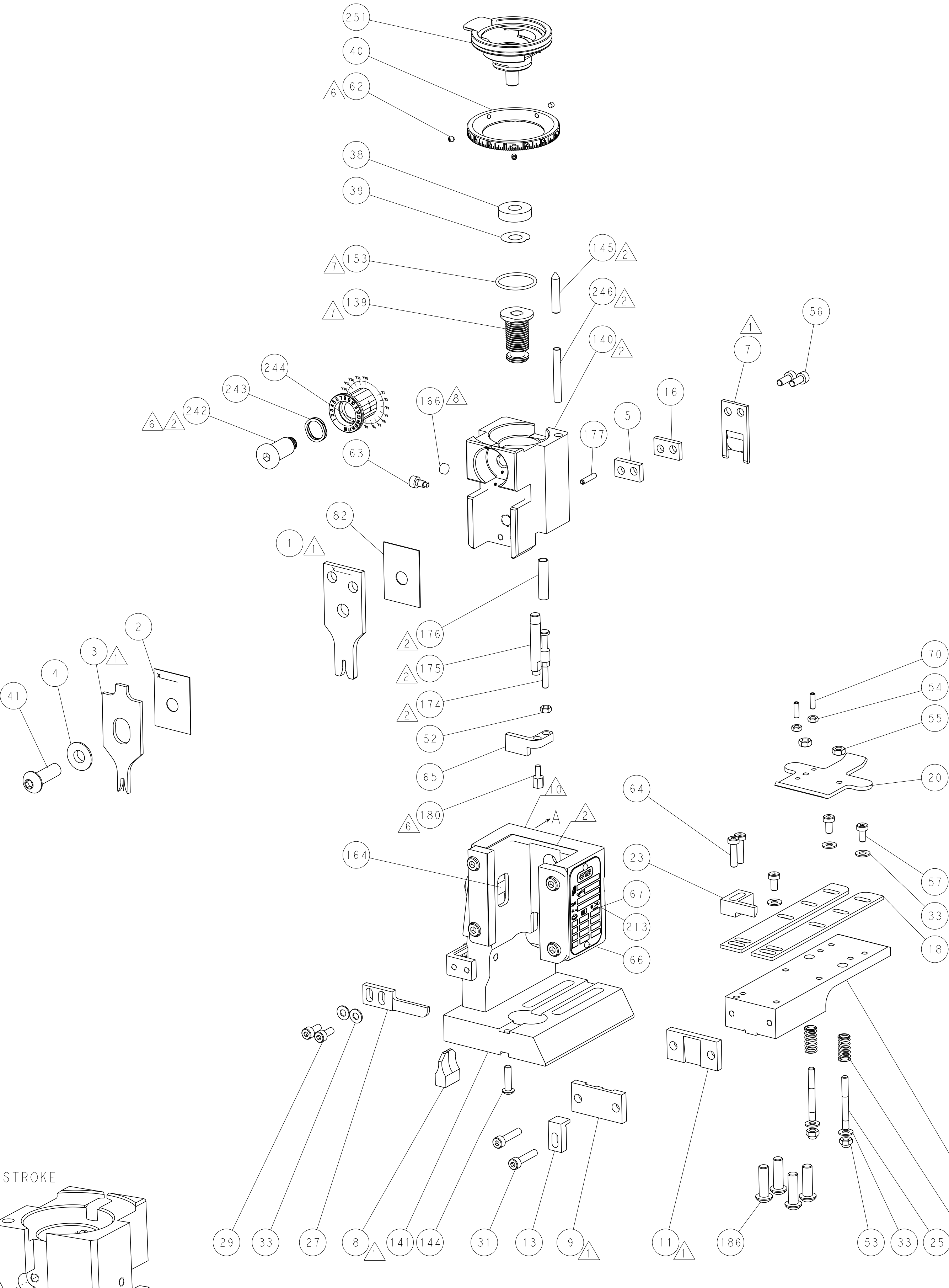
-	-	2	-	-	2168400-7	SHCS, LOW HEAD, RoHS, M5 X 10	240
-	-	-	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	-	-	1	-	2063440-1	AIR FEED MODULE	238
-	-	1	-	-	2119740-2	TAG, IDENTIFICATION	213
-	4	4	4	4	2079383-9	SCR, BHSC, RoHS (M6 X 20)	186
-	-	REF	-	-	1901697-1	FEED FINGER ASSEMBLY, EF	183
-	1	1	1	1	1-1752354-0	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
-	-	-	2	-	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172
-	1	1	1	1	994969-1	MAGNET, RARE EARTH HIGH ENERGY	166
-	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
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-77-27-25-22-21					PART NO	DESCRIPTION	ITEM NO

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				CHK G. BAILEY	10SEP2014				
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		APVD J. GUO	10SEP2014	NAME			
mm		0 PLC ±.5 1 PLC ±0.13 3 PLC ±0.013 4 PLC ±0.0001 ANGLES ±.1		PRODUCT SPEC		Ocean End Feed Applicator			
				APPLICATION SPEC					
MATERIAL				WEIGHT		SIZE A1	CAGE CODE 00779	DRAWING NO C=2150485	RESTRICTED TO
						Customer Accessible Production Drawing		SCALE 1:1	SHEET 3 OF 4 REV A

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

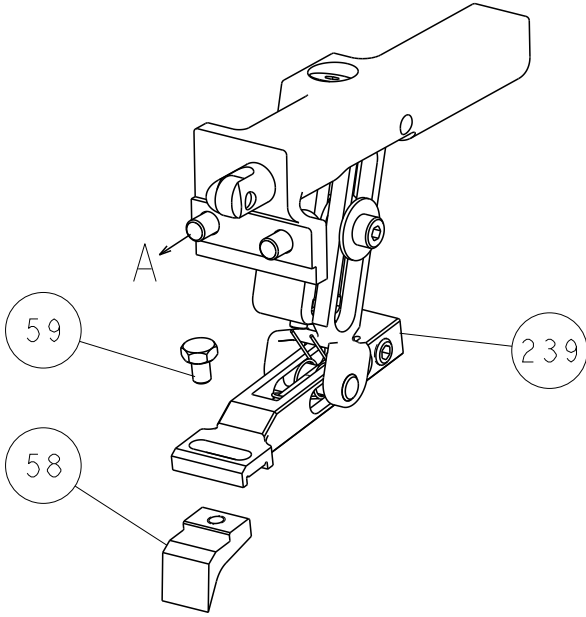


HOLDDOWN SET-UP

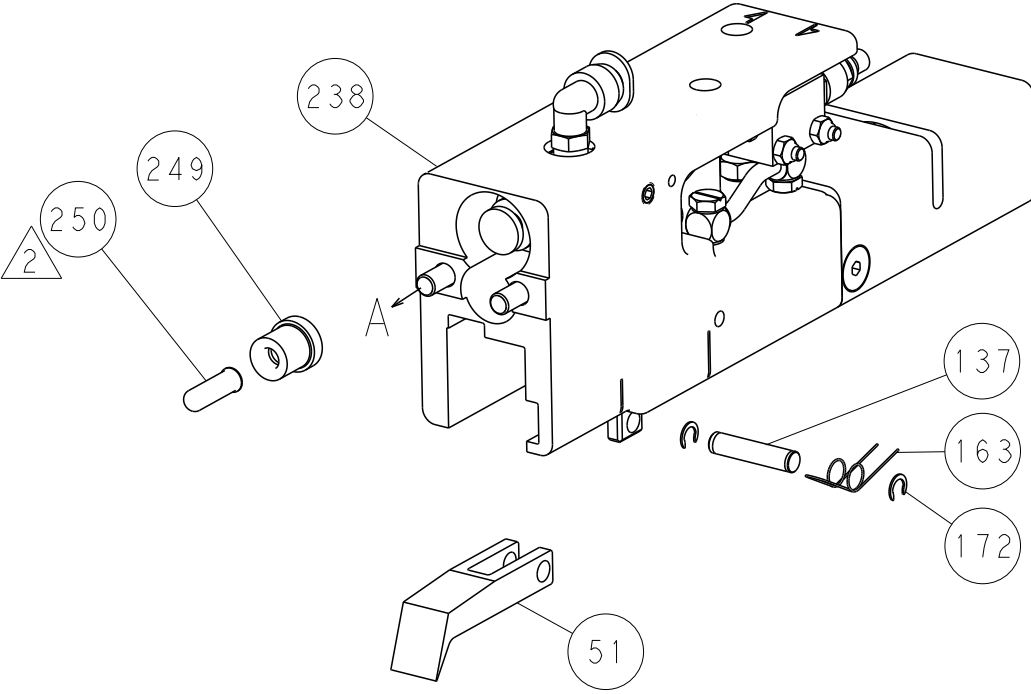


PACIFIC VERSION
Shown on sheets 3 of 4 & 4 of 4
(Atlantic version shown on sheets 1 of 4 & 2 of 4)

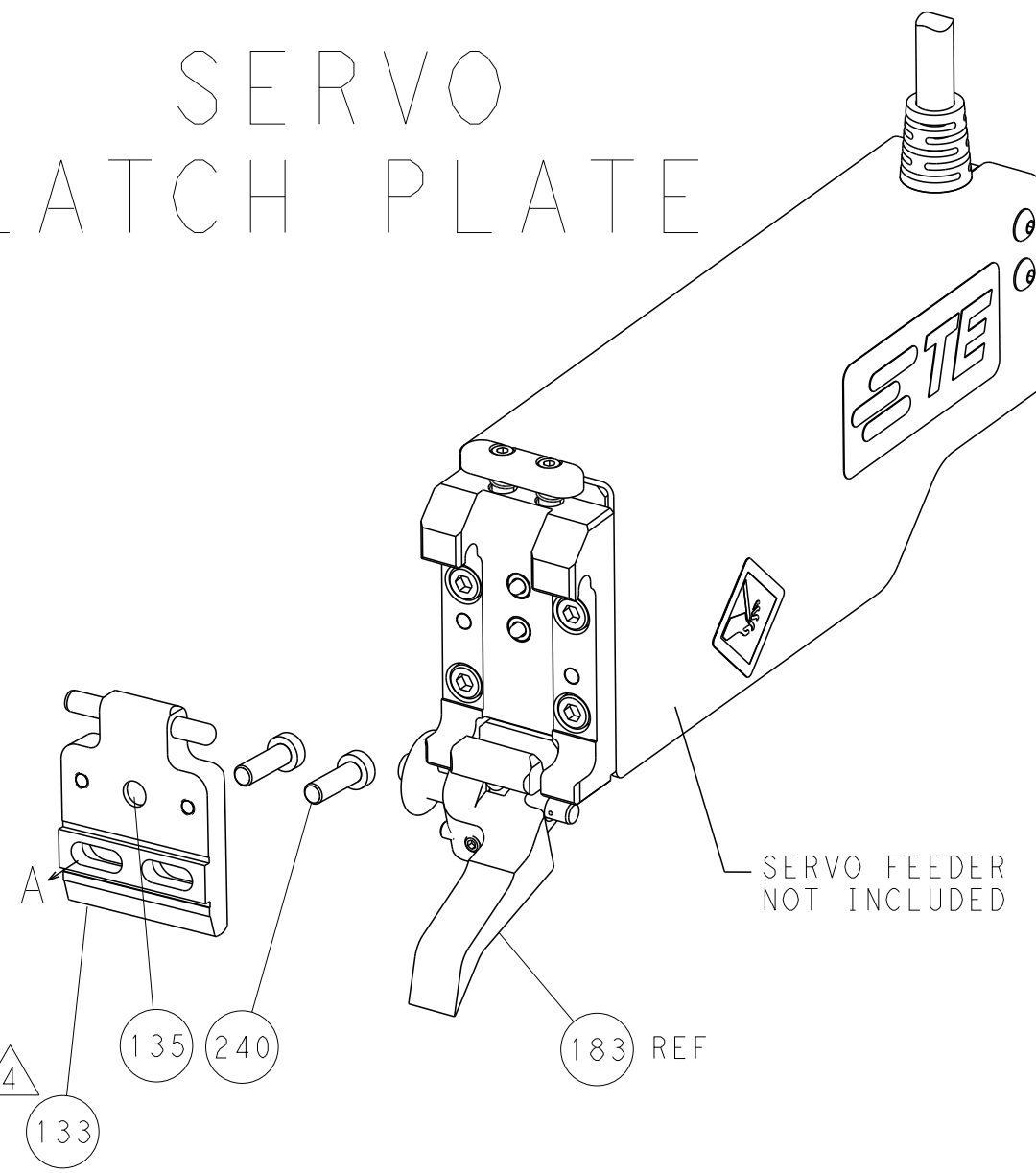
FEED TYPE
MECHANICAL



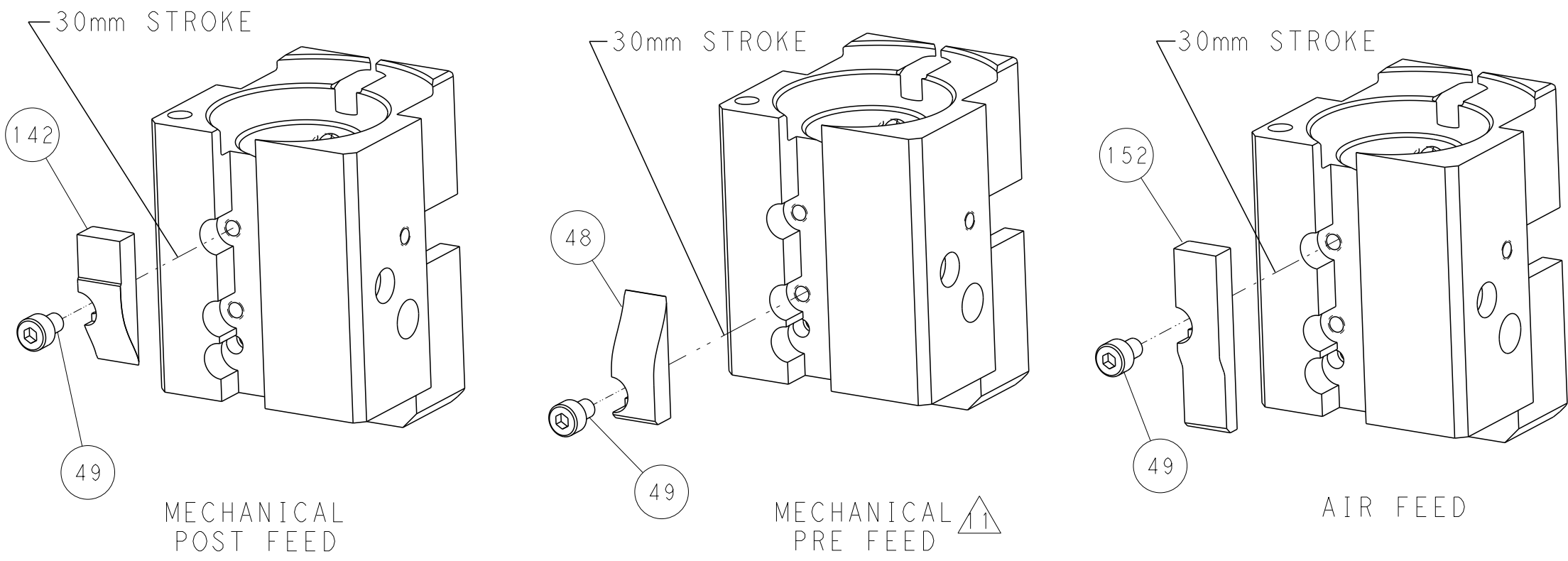
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SERVO
LATCH PLATE



CAM POSITIONS



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DIMENSIONS: mm		CHK G. BAILEY 10SEP2014	NAME Ocean End Feed Applicator	
TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.5 1 PLC ±0.13 2 PLC ±0.13 3 PLC ±0.013 4 PLC ±0.001 ANGLES ±.1		APVD J. GUO 10SEP2014	PRODUCT SPEC	
MATERIAL			APPLICATION SPEC	
			WEIGHT	
			Customer Accessible Production Drawing	
			SCALE 1:1	
			SHEET 4 OF 4	
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