

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART						
					CONVERT TO	PART NUMBERS REQUIRED					
	2150511-1	A	FINE CRIMP HEIGHT ADJUST	MECHANICAL	PNEUMATIC FEED	2119950-1	2119792-8	-	2119641-1	-	2063440-1
					SERVO LATCH PLATE	2119951-1	1901697-1	8-2150511-5	-	2168400-7 (QUANTITY 2)	
					SMART APPLICATOR	2161326-1	-	8-2150511-4	-	-	
	2150511-2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	MECHANICAL FEED	2119949-1	2063961-3	5-18022-5	2119653-1	-	-
					SERVO LATCH PLATE	2119951-1	1901697-1	8-2150511-5	-	2168400-7 (QUANTITY 2)	
					SMART APPLICATOR	2161326-1	-	8-2150511-4	-	-	
	2150511-5	A	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE	MECHANICAL FEED	2119949-1	2063961-3	5-18022-5	2119653-1	-	-
					PNEUMATIC FEED	2119950-1	2119792-8	-	2119641-1	-	2063440-1
	2150511-6	A	NON-CRIMP HEIGHT ADJUST	SERVO LATCH PLATE	-	-	-	-	-	-	-
					-	-	-	-	-	-	-
	2150511-7	A	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	-
	7-2150511-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-

APPLICATOR DATA		
CRIMP SIZE	TYPE	
WIRE 1.52 mm [.060]	F	
INSUL 2.79 mm [.110]	O	
APPL INSTRUCTIONS 408-10390		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: .250 SERIES RECEPTACLE WITHOUT LATCH			
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE		
4.00-4.75 mm [.157-.187 IN]	Ø1.50-2.20 mm [.059-.087 IN]		
TERMINAL APPLICATION SPECIFICATION	114-5052		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
170384-1	170384-7	6-170384-1	7-170384-7
170384-2	170384-9	7-170384-1	

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.50mm2	1.20 +/- 0.05 [.047 +/- .002]	8.7
0.30mm2	1.10 +/- 0.05 [.043 +/- .002]	9.6

- 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: 8-2150511-4
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150511-4
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150511-5
 SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2150511-6
- 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.

-77	-7	-6	-5	-2	-1	PART NO	DESCRIPTION	ITEM NO
-	-	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	2119082-3	CAM, SNAIL, INSULATION ADJUSTMENT	244

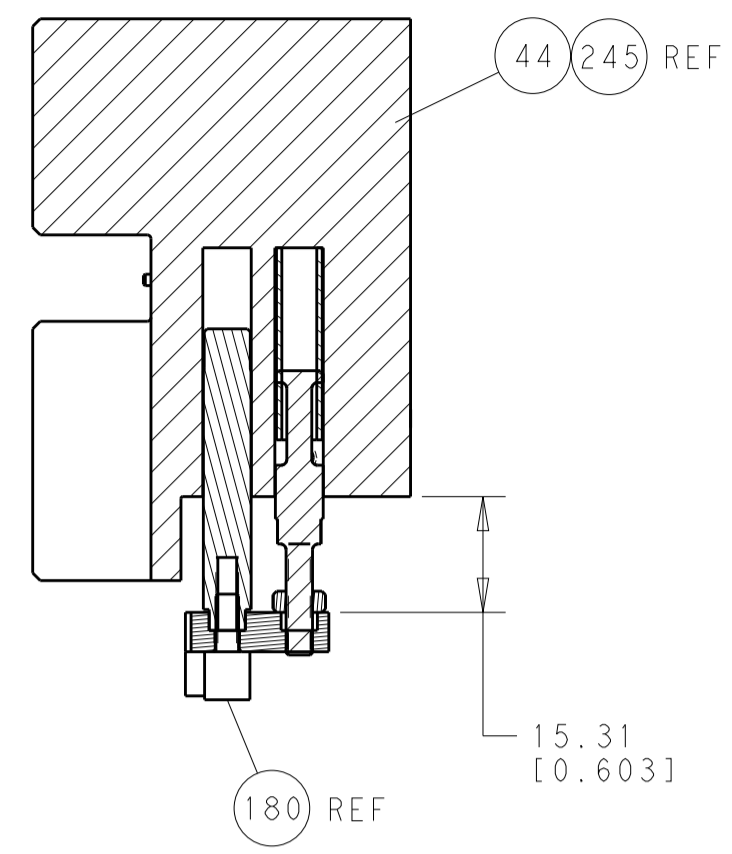
ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

SET UP GAUGE	LOC	DIST	REVISIONS			
2119599-2	A	66	REV	DATE	BY	APPD
			1	DEVELOPMENT	07JAN2015	JH UG
			A	RELEASED	03FEB2015	JH GB

REV	DATE	BY	APPD	DESCRIPTION	DATE	BY	APPD	
-	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
-	-	REFREF	-	-	-	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
-	REFREF	REFREF	REFREF	REFREF	REFREF	994970-2	COUNTER, MAGNETIC	164
-	-	-	-	1	-	240638-1	SPRING, FEED FINGER	163
-	-	-	-	1	-	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854	137
-	-	REFREF	-	-	-	SEE NOTE 4	MEMORY CHIP, PROGRAMMED	135
-	-	1	1	-	-	1633743-1	SERVO FEED LATCH ASM	133
-	1	1	1	1	1	455888-4	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	2168400-5	SHCS, LOW HEAD, RoHS, M4 X 20	64
-	1	-	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	2063961-3	FEED FINGER	58
-	3	3	3	3	3	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57
-	2	2	2	2	2	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	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	-	2119792-8	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	240825-7	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	1901259-5	GUIDE, LOWER STRIP	18
-	4	4	4	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17
-	1	1	1	1	1	3-240641-0	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	690482-4	PLATE, FRONT SHEAR	9
-	1	1	1	1	1	7-1803001-0	ANVIL, COMBINATION, END FEED	8
-	1	1	1	1	1	1-2217206-0	BLADE, SLUG	7
-	-	-	-	-	-	-	-	6
-	1	1	1	1	1	240641-5	SPACER	5
-	1	1	1	1	1	2-238009-9	BLOCK, FL CRIMPER SPACER	4
-	1	1	1	1	1	8-1633965-3	CRIMPER, INSULATION O PREMIUM	3
-	1	1	1	1	1	455888-8	SPACER, CRIMPER	2
-	1	1	1	1	1	9-1633609-3	CRIMPER, WIRE	1

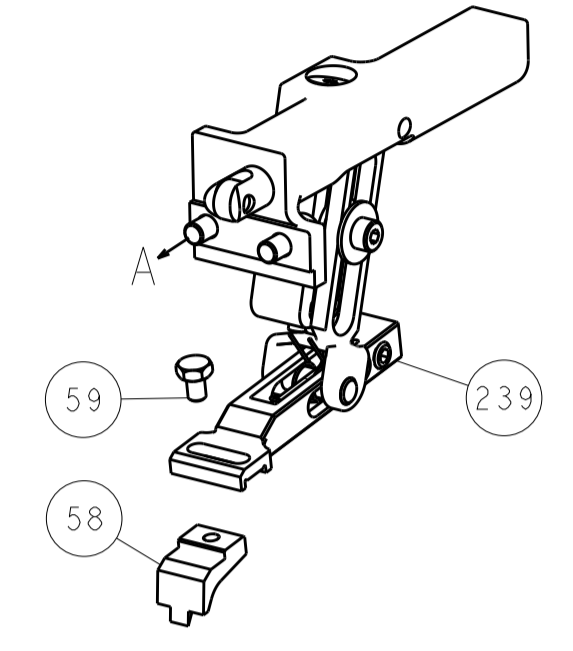
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DATE		NAME	
mm	0 PLC ±.5	1 PLC ±.5	2 PLC ±.13	3 PLC ±.013	4 PLC ±.0001	ANGLES ±.0001	FINISH
MATERIAL		FINISH		WEIGHT		SCALE	
-		-		-		-	

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

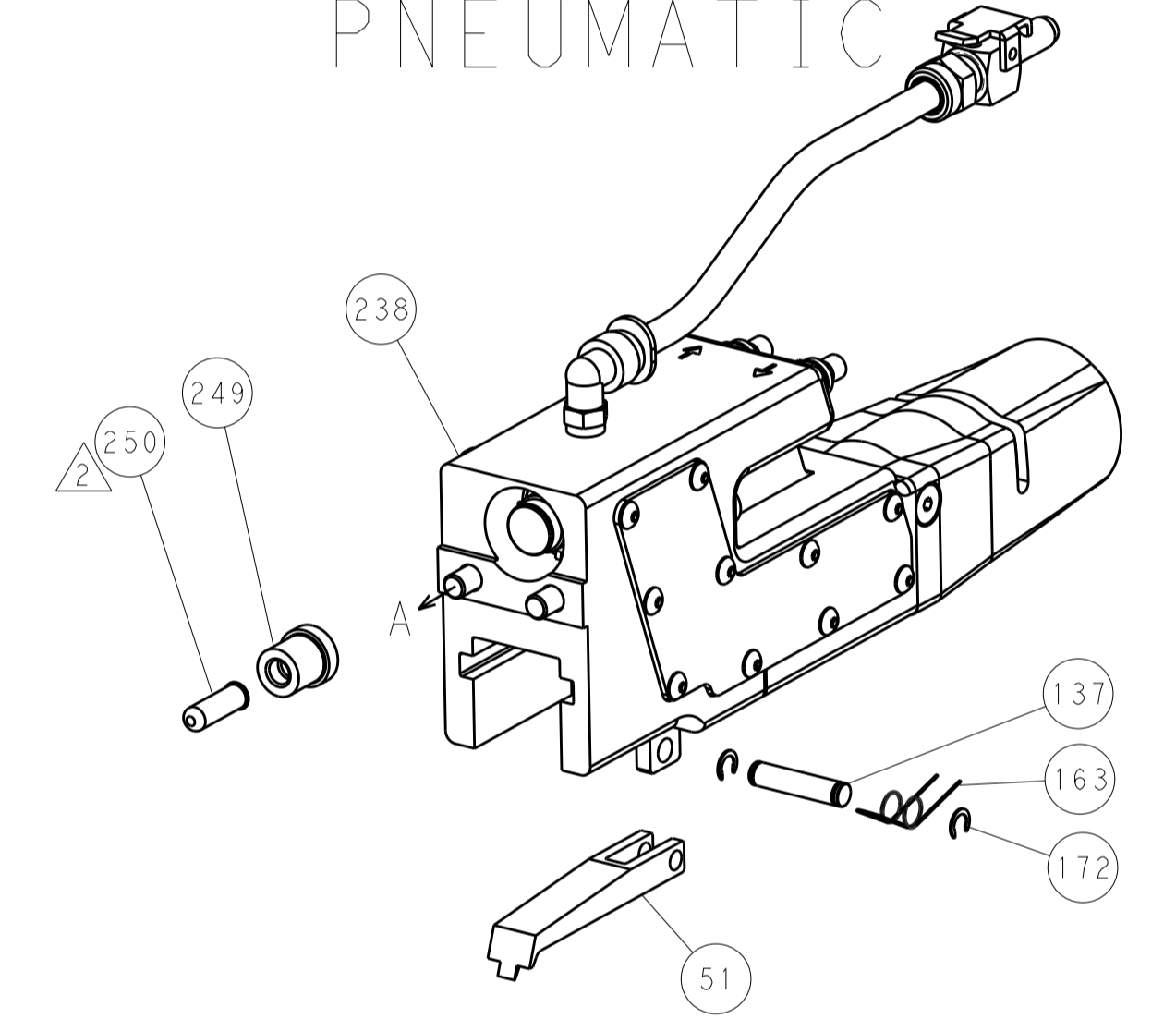


HOLDDOWN SET-UP

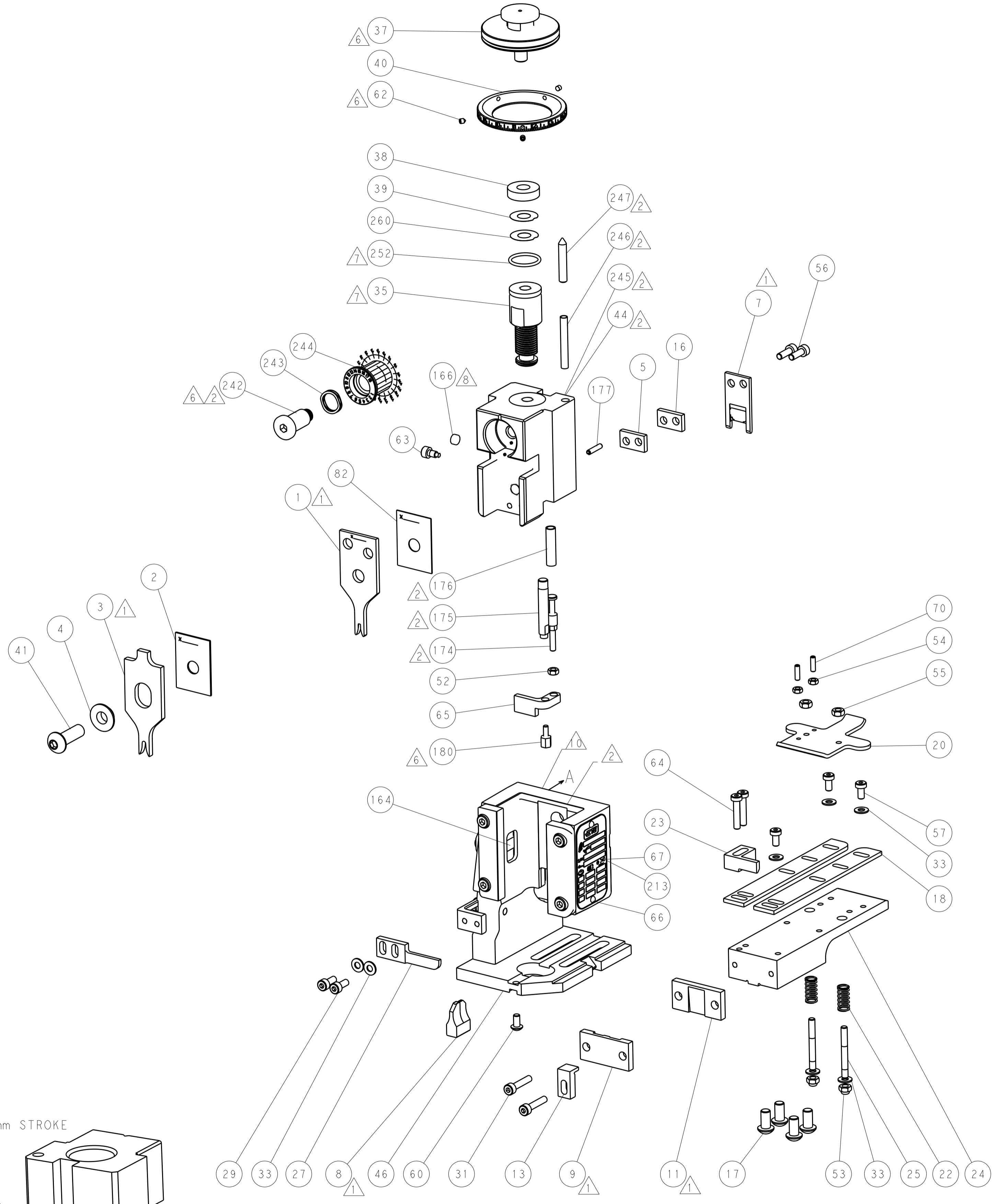
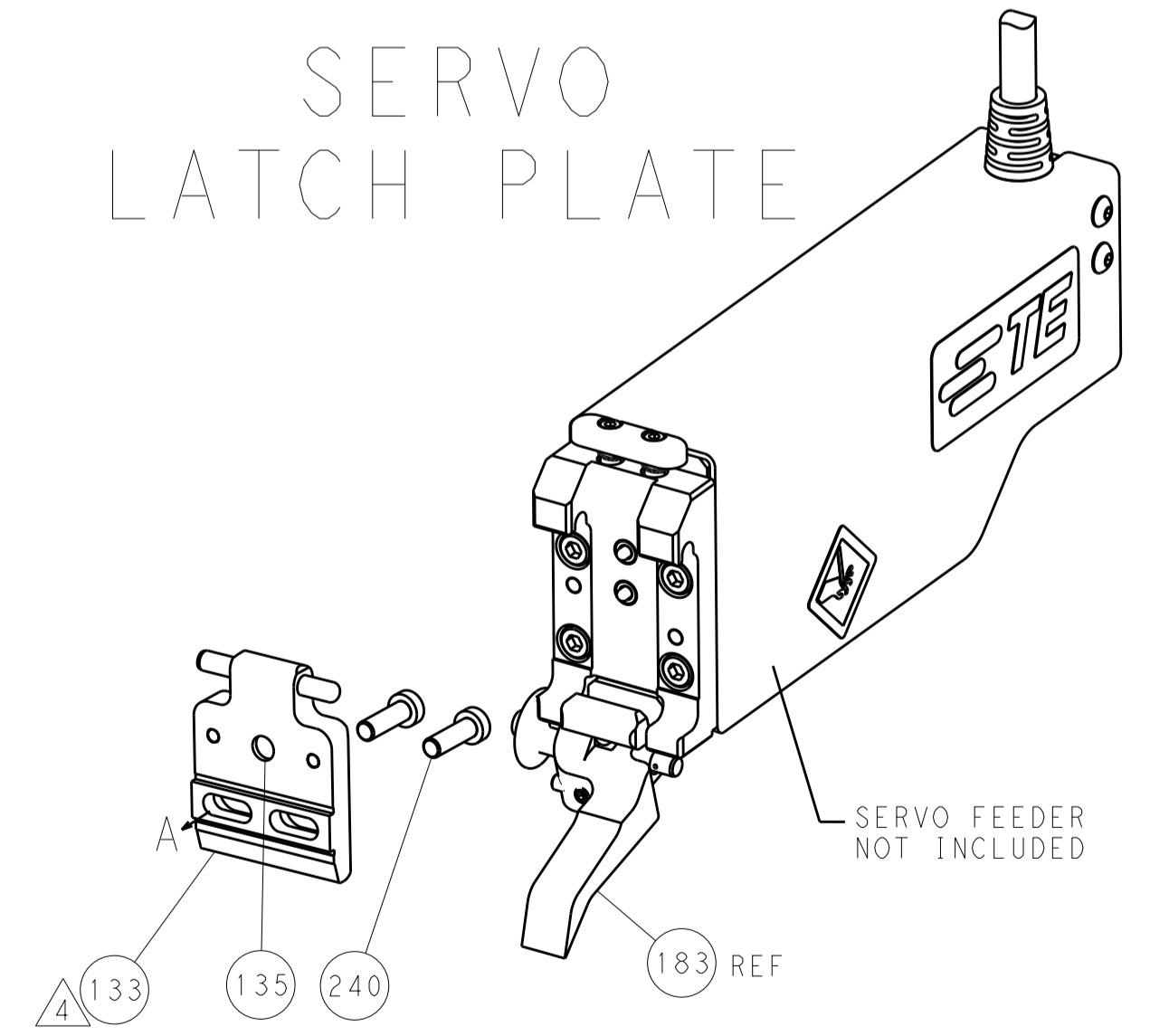
FEED TYPE
MECHANICAL



PNEUMATIC



SERVO
LATCH PLATE



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:		DWN: J. HOU 01JAN2015		TE Connectivity	
mm		0 PLC ±0.5		CHK: L. ZHANG 01JAN2015		Harrisburg, PA 17105-3608	
Ø		1 PLC ±0.13		APVD: H. GUO 01JAN2015		NAME: Ocean End Feed Applicator	
H		3 PLC ±0.013		PRODUCT SPEC		SIZE: CAGE CODE: DRAWING NO:	
A		4 PLC ±0.001		APPLICATION SPEC		RESTRICTED TO:	
ANGLES		FINISH		WEIGHT		A1 00779 ©=2150511	
MATERIAL		SCALE: 1:1		SHEET 2 OF 4		REV A	
Customer Accessible Production Drawing				Customer Accessible Production Drawing			

PACIFIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART						
					CONVERT TO	PART NUMBERS REQUIRED					
	2-2150511-1	A	FINE CRIMP HEIGHT ADJUST	MECHANICAL	PNEUMATIC FEED	2119950-1	2119792-8	-	2119641-2	-	2063440-1
					SERVO LATCH PLATE	2119951-1	1901697-1	8-2150511-5	-	2168400-7 (QUANTITY 2)	
					SMART APPLICATOR	2161326-1	-	8-2150511-4	-	-	
	2-2150511-2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	MECHANICAL FEED	2119949-1	2063961-3	5-18022-5	2119653-2	-	-
					SERVO LATCH PLATE	2119951-1	1901697-1	8-2150511-5	-	2168400-7 (QUANTITY 2)	
					SMART APPLICATOR	2161326-1	-	8-2150511-4	-	-	
	2-2150511-5	A	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE	MECHANICAL FEED	2119949-1	2063961-3	5-18022-5	2119653-2	-	-
					PNEUMATIC FEED	2119950-1	2119792-8	-	2119641-2	-	2063440-1
	2-2150511-7	A	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	-
	7-2150511-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-

APPLICATOR DATA		
CRIMP SIZE	TYPE	
WIRE 1.52 mm (.060)	F	
INSUL 2.79 mm (.110)	Ø	
APPL INSTRUCTIONS 408-10390		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: .250 SERIES RECEPTACLE WITHOUT LATCH			
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE		
4.00-4.75 mm (.157-.187 IN)	Ø1.50-2.20 mm (.059-.087 IN)		
TERMINAL APPLICATION SPECIFICATION	114-5052		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
170384-1	170384-7	6-170384-1	7-170384-7
170384-2	170384-9	7-170384-1	

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.50mm2	1.20 +/- 0.05 [.047 +/- .002]	8.7
0.30mm2	1.10 +/- 0.05 [.043 +/- .002]	9.6

- RECOMMENDED SPARE PARTS
- GREASE BEARING SURFACES LIGHTLY
- 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:
 MECHANICAL FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150511-4
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150511-4
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150511-5
- 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 & 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.
- SPARE FEED CAM STORAGE LOCATION REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.
- 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	2119082-3	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

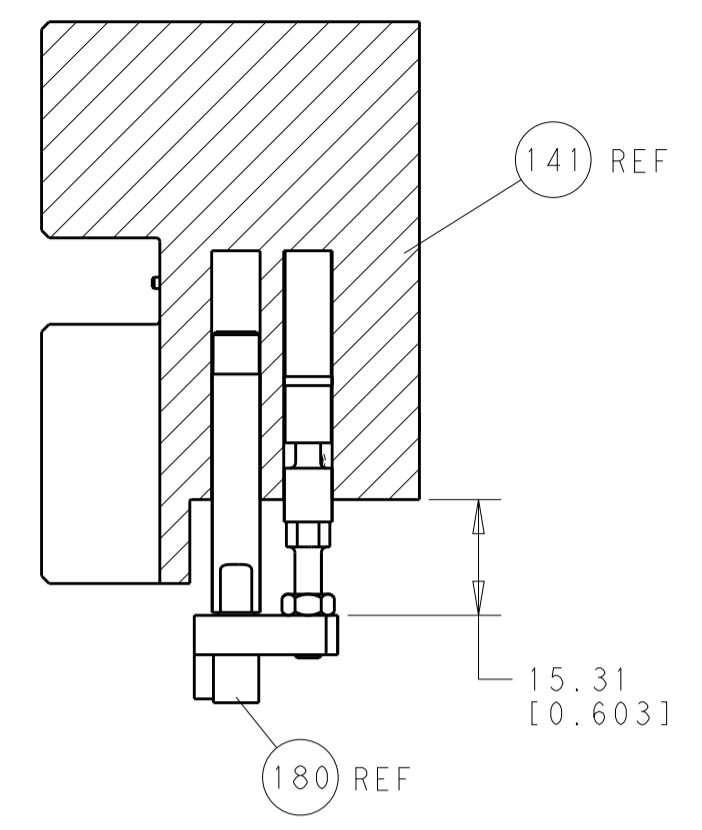
PACIFIC VERSION
 Shown on sheets 3 of 4 & 4 of 4
 (Atlantic version shown on sheets 1 of 4 & 2 of 4)

SET UP GAUGE	LOC	DIST	REVISIONS			
2119599-2	A	66	REV	DATE	BY	APPV
			-	SEE SHEET 1	-	-

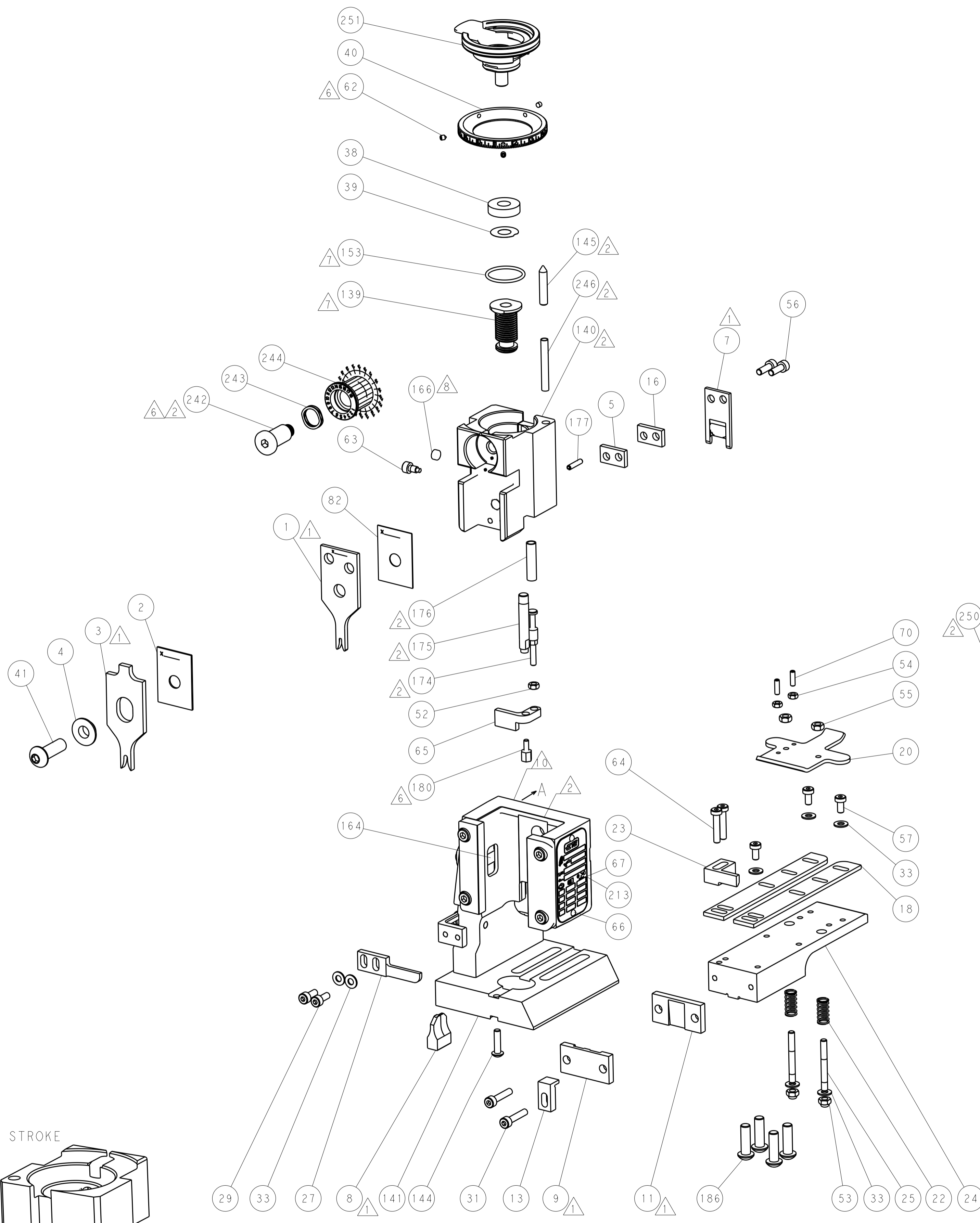
-	-	2	-	-	2168400-7	SHCS, LOW HEAD, RoHS, M5 X 10	240					
-	-	-	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239					
-	-	-	-	1	2063440-1	AIR FEED MODULE	238					
-	-	1	-	-	2119740-2	TAG, IDENTIFICATION	213					
-	4	4	4	4	2079383-9	SCR, BHSC, RoHS (M6 X 20)	186					
-	-	REF	-	-	1901697-1	FEED FINGER ASSEMBLY, 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					
-	-	-	1	-	240638-1	SPRING, FEED FINGER	163					
-	1	1	1	1	8-21084-1	O-RING, .801 ID, .070 DIA. MAT.	153					
-	-	-	1	-	2119641-2	FEED CAM, AIR FEED	152					
-	1	1	1	1	2119798-2	DETENT PIN	145					
-	1	1	1	1	2079383-8	SCR, BHSC, RoHS (M4 X 16)	144					
-	-	-	-	1	2119653-2	FEED CAM, POST FEED	142					
-	1	1	1	1	2119655-6	APPLICATOR BASIC ASSEMBLY, EF	141					
-	1	1	1	1	2119651-1	RAM, ASIAN STYLE, END FEED	140					
-	1	1	1	1	2119092-2	BOLT, ADJUSTMENT	139					
-	-	-	1	-	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854	137					
-	-	REF	-	-	SEE NOTE 4	MEMORY CHIP, PROGRAMMED	135					
-	-	1	-	-	1633743-1	SERVO FEED LATCH ASM	133					
-	1	1	1	1	455888-4	SPACER, CRIMPER	82					
-	1	1	1	1	2119956-2	DOCUMENTATION PACKAGE	71					
-	2	2	2	2	2-18032-2	SCR, SET, FLT POINT M3 X 10.0	70					
-	1	2	-	1	2119740-1	TAG, IDENTIFICATION	67					
-	2	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66					
-	1	1	1	1	1901681-1	HOLDDOWN, TERMINAL	65					
-	2	2	2	2	2168400-5	SHCS, LOW HEAD, RoHS, M4 X 20	64					
-	1	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	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59					
-	-	-	-	1	2063961-3	FEED FINGER	58					
-	3	3	3	3	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57					
-	2	2	2	2	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	56					
-	2	2	2	2	5018030-2	NUT, HEX, REG, RoHS, M4	55					
-	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	-	2119792-8	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	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	1-2119644-2	RAM WASHER, PRECISION	38					
-	7	7	7	7	1-18028-2	WASHER, FLAT, REG M4	33					
-	2	2	2	2	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	31					
-	2	2	2	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	29					
-	1	1	1	1	240639-1	STRIPPER (MACHINING)	27					
-	2	2	2	2	1320906-1	STUD, THREADED	25					
-	1	1	1	1	1752371-5	PLATE, STRIP GUIDE	24					
-	1	1	1	1	240825-7	PLATE, STRIP HOLD DOWN	23					
-	2	2	2	2	2-22281-3	SPRING, COMPRESSION	22					
-	1	1	1	1	1752373-4	DRAG	20					
-	2	2	2	2	1901259-5	GUIDE, LOWER STRIP	18					
-	1	1	1	1	3-240641-0	SPACER	16					
-	1	1	1	1	1752360-1	SPACER, HOLD-DOWN	13					
-	1	1	1	1	240644-1	PLATE, REAR SHEAR	11					
-	-	-	-	-	-	-	10					
-	1	1	1	1	690482-4	PLATE, FRONT SHEAR	9					
-	1	1	1	1	7-1803001-0	ANVIL, COMBINATION, END FEED	8					
-	1	1	1	1	1-2217206-0	BLADE, SLUG	7					
-	-	-	-	-	-	-	6					
-	1	1	1	1	240641-5	SPACER	5					
-	1	1	1	1	2-238009-9	BLOCK, FL CRIMPER SPACER	4					
-	1	1	1	1	8-1633965-3	CRIMPER, INSULATION O PREMIUM	3					
-	1	1	1	1	455888-8	SPACER, CRIMPER	2					
-	1	1	1	1	9-1633609-3	CRIMPER, WIRE	1					
-	77	-	27	-	25	-	22	-	21	PART NO	DESCRIPTION	ITEM NO

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DATE		NAME	
mm	0 PLC ±.5	1 PLC ±.13	2 PLC ±.013	3 PLC ±.0001	01JAN2015	01JAN2015	TE Connectivity
	ANGLES ±.0001	FINISH					Harrisburg, PA 17105-3608
MATERIAL							Ocean End Feed Applicator
							SIZE: A1 CAGE CODE: 00779 DRAWING NO: ©=2150511
							Customer Accessible Production Drawing SCALE: 1:1 SHEET 3 OF 4 REV: A

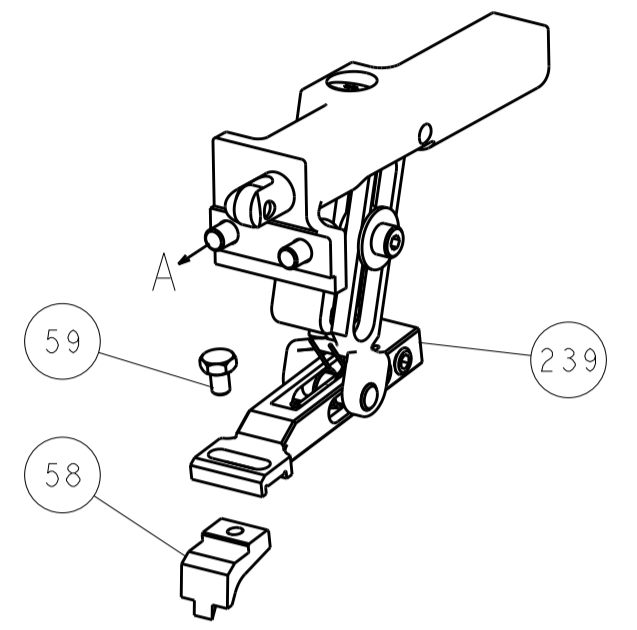
LOC		DIST		REVISIONS			
A	66	P	LTM	DESCRIPTION	DATE	DMN	APVD
				SEE SHEET 1			



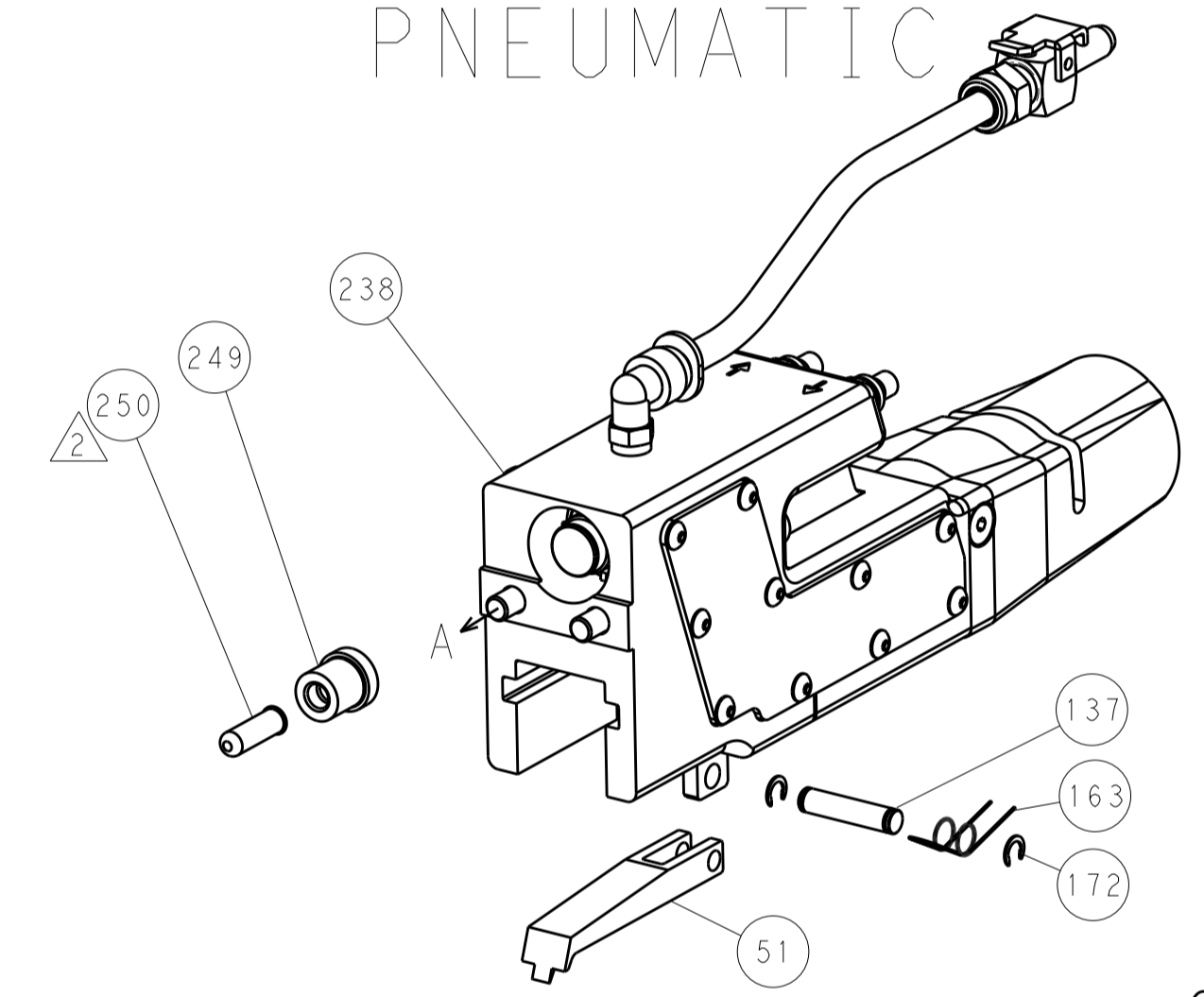
HOLDDOWN SET-UP



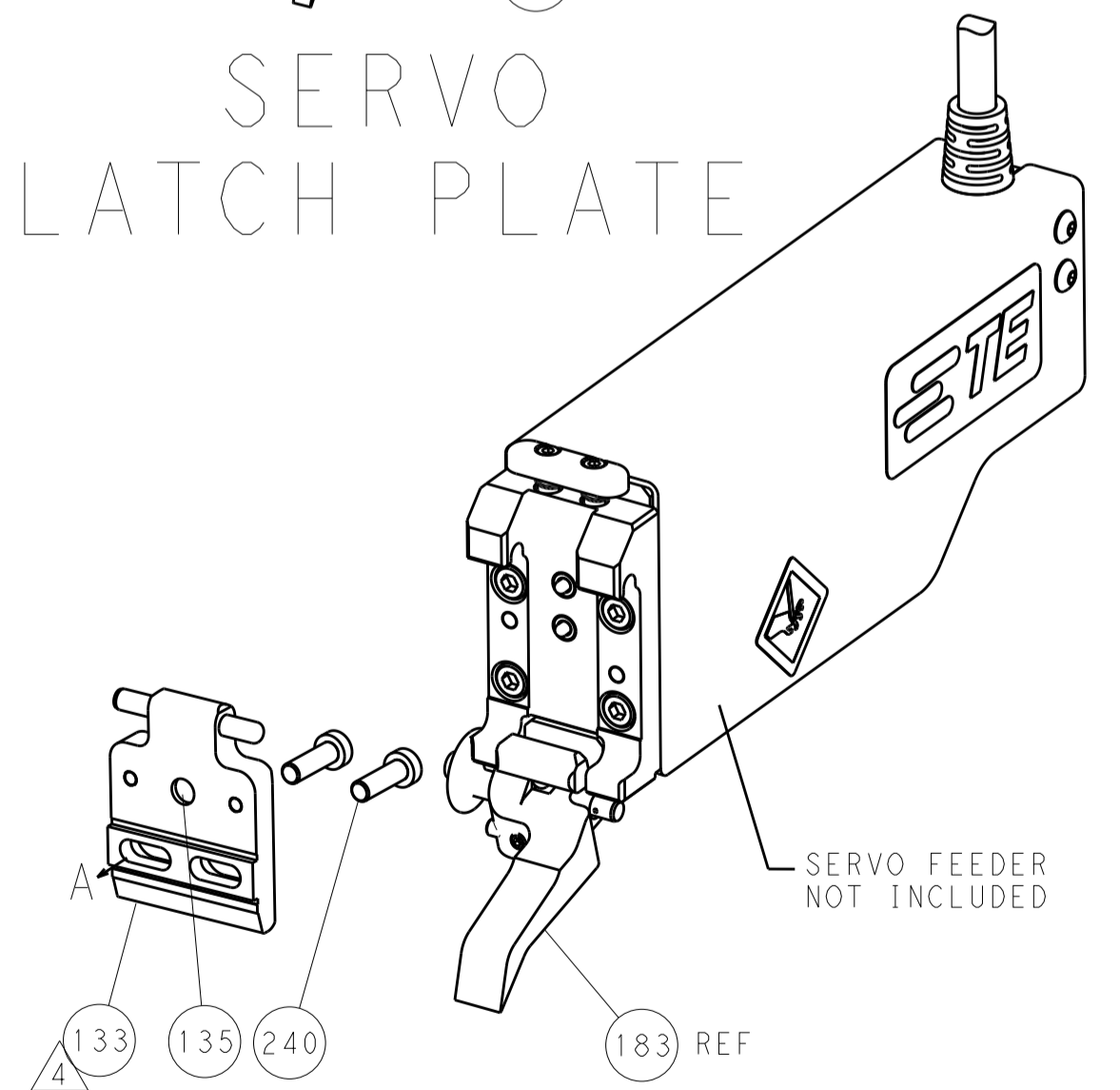
FEED TYPE
MECHANICAL



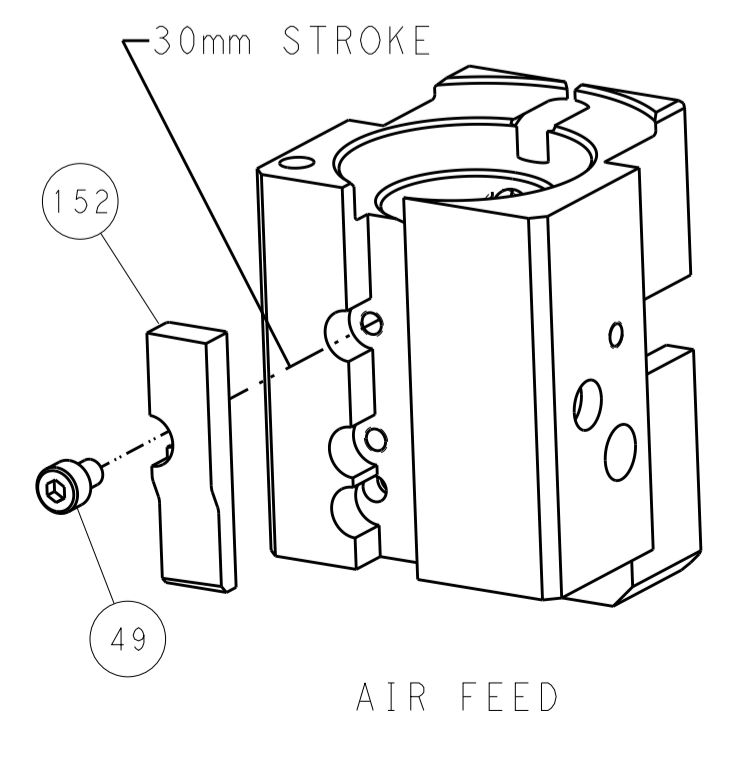
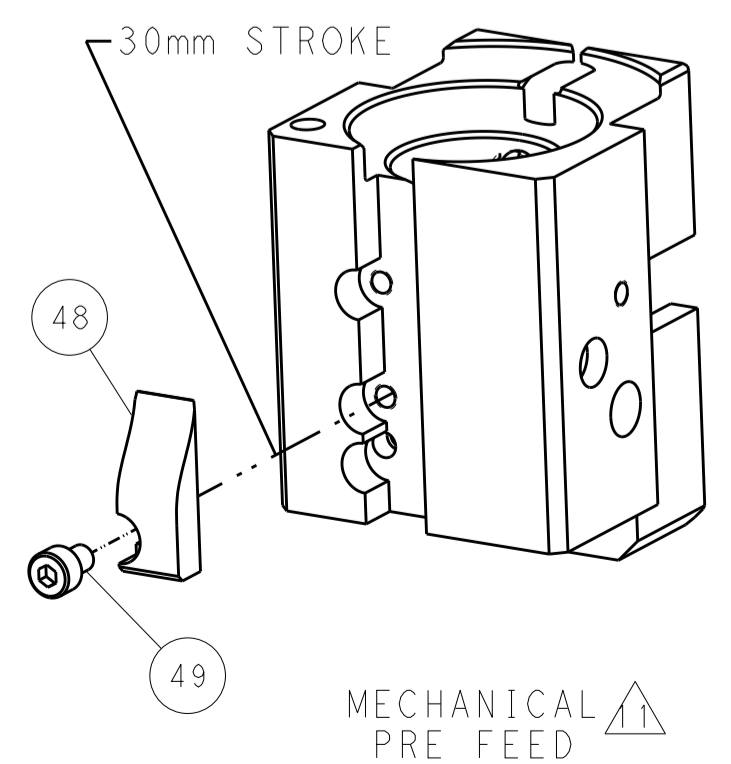
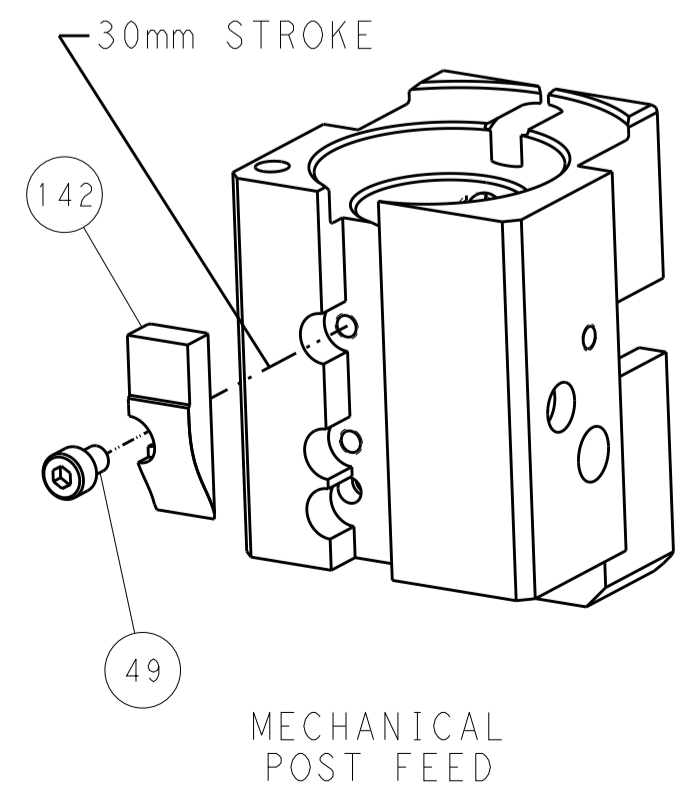
PNEUMATIC



SERVO
LATCH PLATE



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:		DWG: J. HOU 01JAN2015		CHK: L. ZHANG 01JAN2015		APVD: H. GUO 01JAN2015		NAME: Ocean End Feed Applicator	
mm	0 PLC ±0.5	1 PLC ±0.13	2 PLC ±0.013	3 PLC ±0.001	4 PLC ±0.0001	ANGLES	FINISH	WEIGHT	SCALE	SHEET 4 OF 4	REV A
MATERIAL:		FINISH:		CUSTOMER ACCESSIBLE PRODUCTION DRAWING		SCALE: 1:1		SHEET 4 OF 4		REV A	