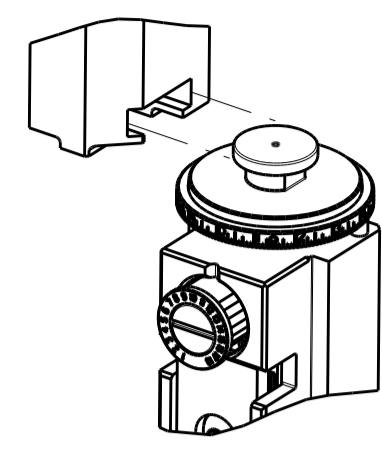


ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART						
					CONVERT TO	PART NUMBERS REQUIRED					
	2150338-1	A	FINE CRIMP HEIGHT ADJUST	MECHANICAL	PNEUMATIC FEED	2119950-1	2119792-2	-	2119641-1	-	2063440-1
					SERVO LATCH PLATE	2119951-1	1901697-1	8-2150338-5	-	2168400-7 (QUANTITY 2)	
					SMART APPLICATOR	2161326-1	-	8-2150338-4	-	-	
	2150338-2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	MECHANICAL FEED	2119949-1	2063961-1	5-18022-5	2119653-1	-	-
					SERVO LATCH PLATE	2119951-1	1901697-1	8-2150338-5	-	2168400-7 (QUANTITY 2)	
					SMART APPLICATOR	2161326-1	-	8-2150338-4	-	-	
	2150338-5	A	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE	MECHANICAL FEED	2119949-1	2063961-1	5-18022-5	2119653-1	-	-
					PNEUMATIC FEED	2119950-1	2119792-2	-	2119641-1	-	2063440-1
	2150338-6	A	NON-CRIMP HEIGHT ADJUST	SERVO LATCH PLATE	-	-	-	-	-	-	-
					-	-	-	-	-	-	-
	2150338-7	A	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	-
					-	-	-	-	-	-	-
7-2150338-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-	

APPLICATOR DATA		
CRIMP SIZE	TYPE	
WIRE 3.56 mm [1.40]	F	
INSUL 5.59 mm [2.20]	F	
APPL INSTRUCTIONS 408-10390		

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION	
TERMINAL NAME: 6.3 SRS F-SPRING LIF RECEPTACLE	
WIRE STRIP LENGTH 5.90-6.90 mm [2.32-.272 IN]	INSULATION DIAMETER RANGE Ø3.60-5.00 mm [1.42-.197 IN]
TERMINAL APPLICATION SPECIFICATION 114-64027	
TERMINALS APPLIED	
TE TERMINAL 2178301-1	

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
10 AWG	2.28 +/- 0.05 [1.090 +/- .002]	2.6
12 AWG	1.96 +/- 0.05 [0.777 +/- .002]	4.3
14 AWG	1.71 +/- 0.05 [0.677 +/- .002]	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: 8-2150338-4
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150338-4
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150338-5
 SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2150338-6
- 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 ITEM 50 & 62. APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 50 & 242. FOR *-6 ONLY APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 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.
- 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.
- 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
- TERMINAL LUBRICANT IS RECOMMENDED.

***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	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	2119798-1	DETENT PIN	247
-	1	-	1	1	1-22279-3	SPRING, COMPRESSION	246
-	-	1	-	-	2119759-1	RAM, AMP STYLE, END FEED, NON-ADJUST	245

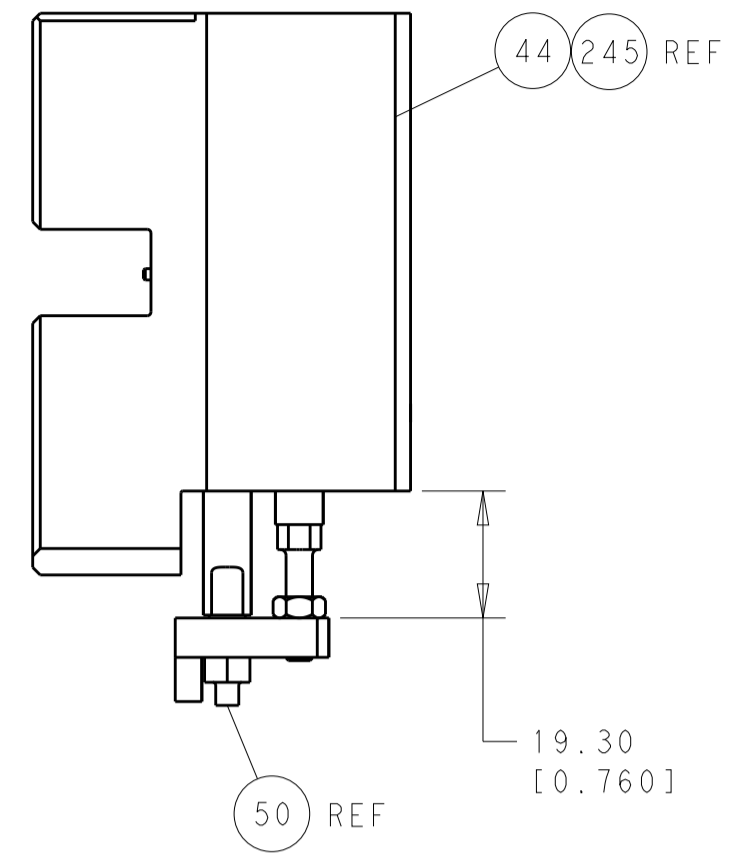
ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

SET UP GAUGE	LOC	DIST	REVISIONS			
2119599-2	A	66	REV	DATE	BY	APPV
	A		RELEASE	15JUL2014	XZ	TE
	A1		ECR-15-006528	28APR2015	RS	LZ

REV	DATE	BY	APPV	DESCRIPTION	DATE	BY	APPV	
-	1	1	1	1	2119082-9	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	
-	-	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	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	
-	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	2119955-2	ASSY, LUBRICATOR, END FEED	84	
-	1	1	1	1	455888-5	SPACER, CRIMPER	82	
-	1	1	1	1	2119791-5	DEPRESSOR, WIRE	73	
-	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	1	1	1	2119943-1	WASHER, SPACER	69	
-	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	2119793-1	LIMITER, ADJUSTMENT BOLT	63	
-	3	-	3	3	992763-5	SCR, SET, SOC, CONE POINT, M3 X 4.0	62	
-	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	
-	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	5018030-2	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	2119792-2	PAWL, EF, AIR	51	
-	1	1	1	1	1-1976055-0	STANDOFF, HOLD-DOWN	50	
-	-	-	-	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	2119655-5	APPLICATOR BASIC ASSEMBLY, EF	46	
-	1	-	1	1	2119369-1	RAM, AMP STYLE, END FEED	44	
-	1	1	1	1	2079383-7	SCR, BHSC, RoHS (M8 X 25)	41	
-	1	-	1	1	2119645-1	DISC, NUMBERED FA WIRE ADJUSTMENT	40	
-	1	-	1	1	2119957-1	APPLICATOR SHIM PACK	39	
-	1	1	1	1	1-2119644-2	RAM WASHER, PRECISION	38	
-	1	1	1	1	2119085-1	FA HEAD, ATLANTIC STYLE	37	
-	1	-	1	1	2119092-1	BOLT, ADJUSTMENT	35	
-	8	8	8	8	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	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	1320906-1	STUD, THREADED	25	
-	1	1	1	1	1-1752371-2	PLATE, STRIP GUIDE	24	
-	2	2	2	2	2-22281-3	SPRING, COMPRESSION	22	
-	1	1	1	1	1752373-4	DRAG	20	
-	2	2	2	2	1901259-7	GUIDE, LOWER STRIP	18	
-	4	4	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17	
-	1	1	1	1	1752360-1	SPACER, HOLD-DOWN	13	
-	1	1	1	1	240644-5	PLATE, REAR SHEAR	11	
-	1	1	1	1	6-690482-7	PLATE, FRONT SHEAR	9	
-	1	1	1	1	1803059-4	ANVIL, COMBINATION, END FEED	8	
-	1	1	1	1	1-2217206-3	BLADE, SLUG	7	
-	-	-	-	-	-	-	6	
-	1	1	1	1	3-240641-5	SPACER	5	
-	1	1	1	1	2-238009-9	BLOCK, FL CRIMPER SPACER	4	
-	1	1	1	1	8-2119582-3	CRIMPER, INSULATION F PREMIUM	3	
-	1	1	1	1	455888-3	SPACER, CRIMPER	2	
-	1	1	1	1	6-1633730-7	CRIMPER, WIRE	1	

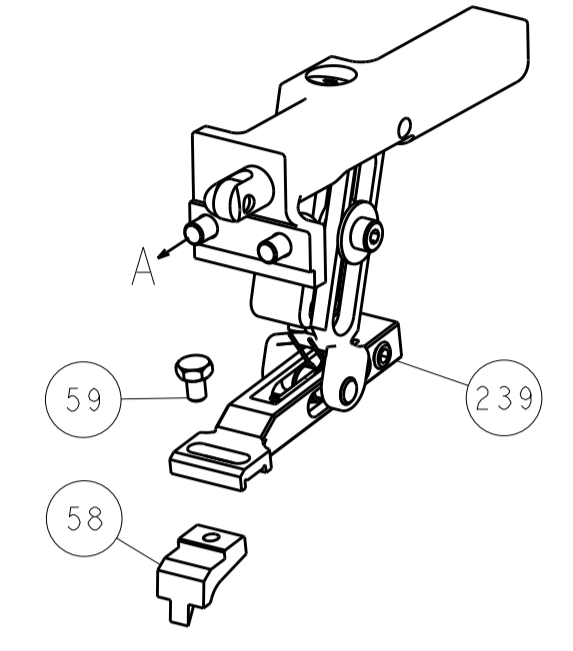
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG		CHK		APPV		NAME	
mm	0 PLC ±.5	1 PLC ±.3	2 PLC ±.2	3 PLC ±.15	4 PLC ±.1	08MAY2013	08MAY2013	08MAY2013	08MAY2013	Ocean End Feed Applicator	
	ANGLES ±.0001	FINISH								SIZE	CAGE CODE
										A1	00779
										SCALE	SHEET
										1:1	1 of 4

LOC	DIST	REV	DATE	BY	APPV
A	66				
REVISIONS			DESCRIPTION	DATE	BY
			SEE SHEET 1		

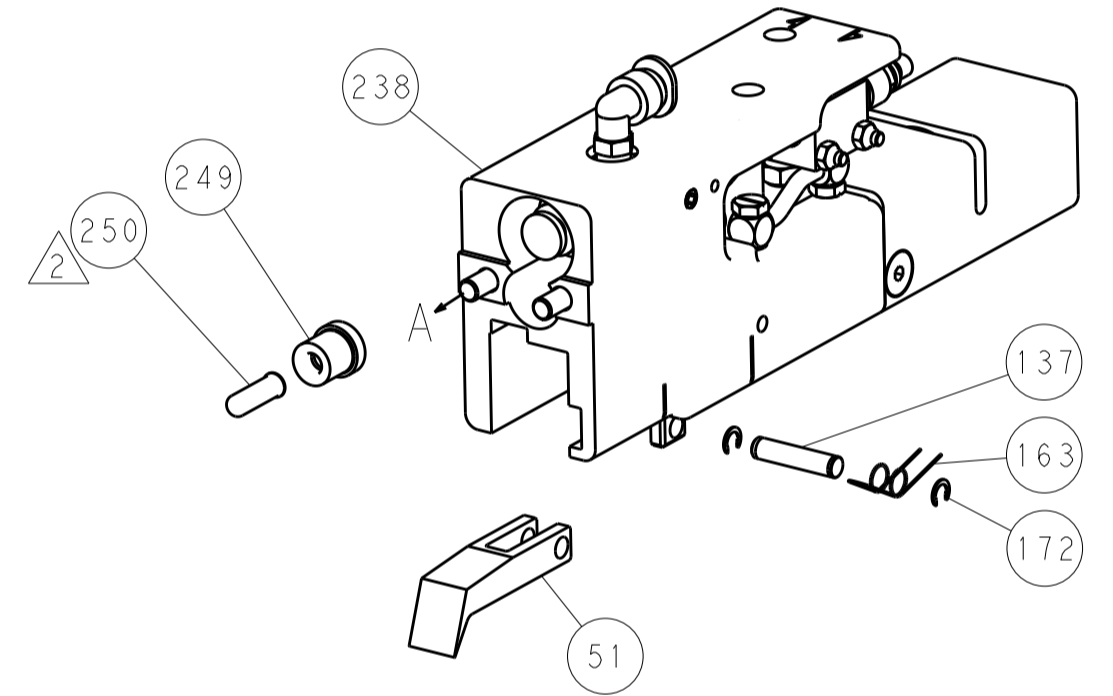


HOLDDOWN SET-UP

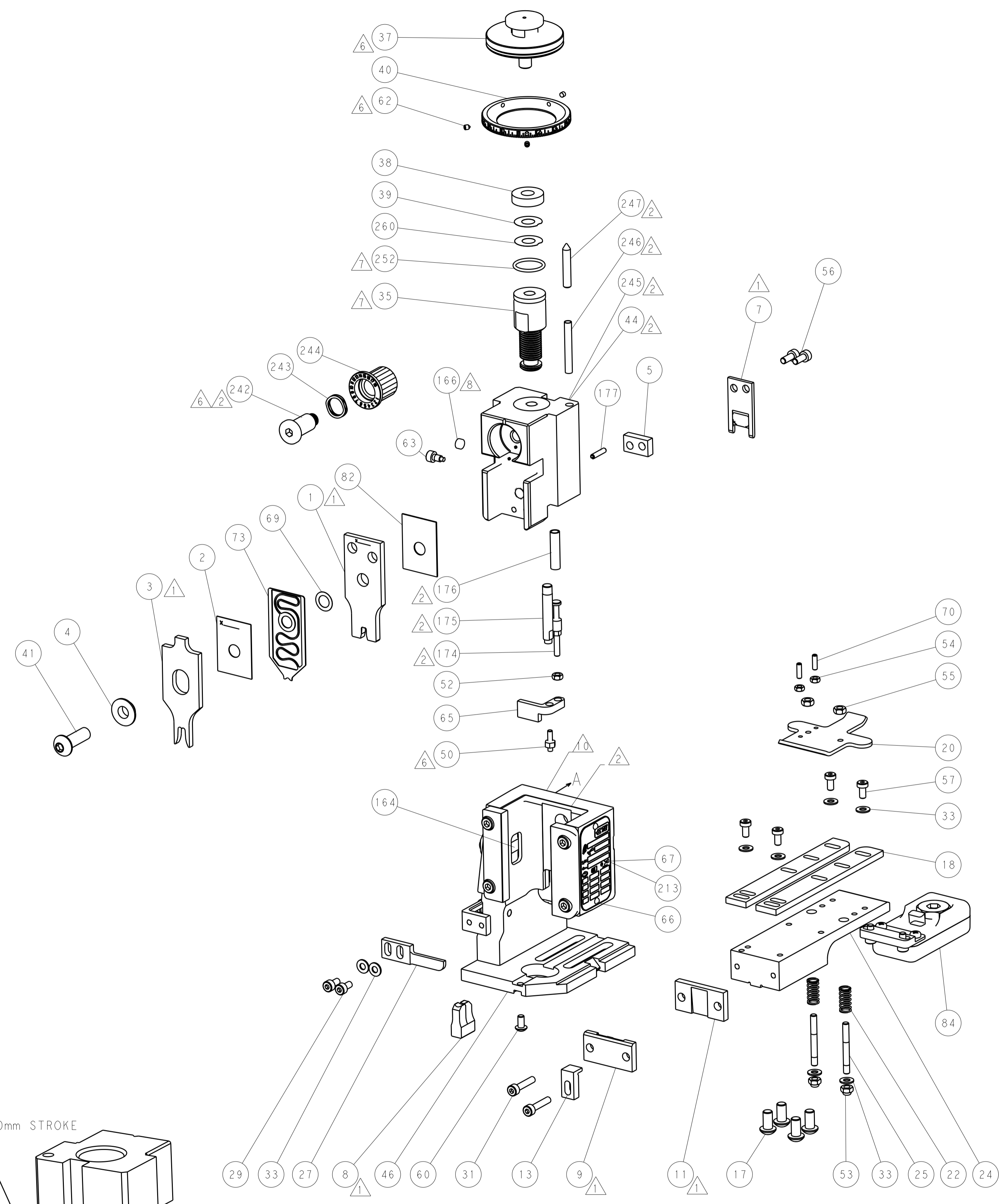
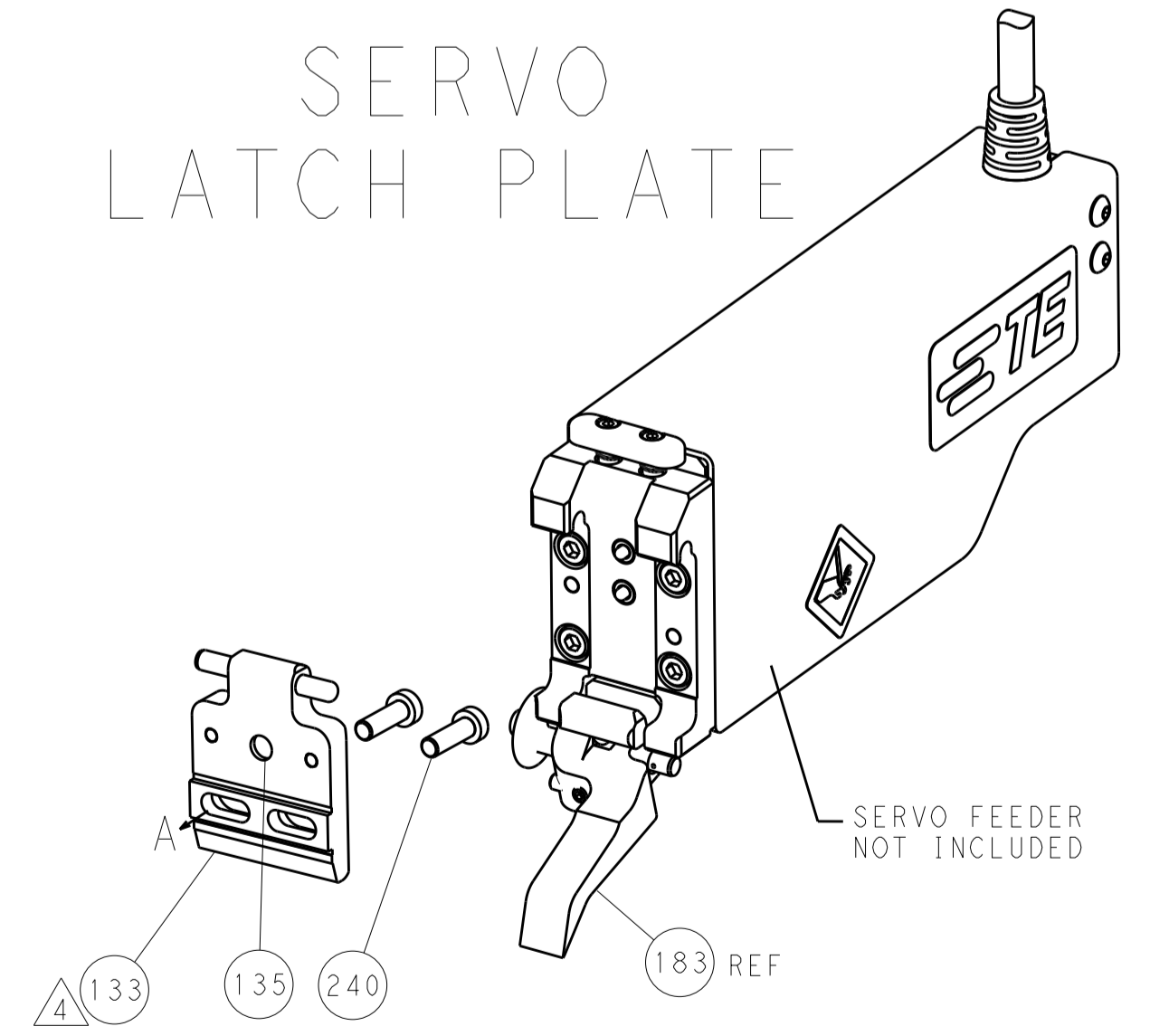
FEED TYPE
MECHANICAL



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:		DWG: Y. YIN 08MAY2013		TE Connectivity	
mm		0 PLC ±0.5		CHK: G. BAILEY 08MAY2013		Harrisburg, PA 17105-3608	
Ø		1 PLC ±0.13		APPV: H. GUO 08MAY2013		NAME: Ocean End Feed Applicator	
H		2 PLC ±0.013		PRODUCT SPEC		SIZE: CAGE CODE DRAWING NO	
A		3 PLC ±0.001		APPLICATION SPEC		RESTRICTED TO	
R		4 PLC ±0.001		WEIGHT		A1 00779 ©=2150338	
FINISH		ANGLES		CUSTOMER ACCESSIBLE PRODUCTION DRAWING		SCALE: 1:1 SHEET 2 OF 4 REV A1	

PACIFIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART						
					CONVERT TO	PART NUMBERS REQUIRED					
	2-2150338-1	A	FINE CRIMP HEIGHT ADJUST	MECHANICAL	PNEUMATIC FEED	2119950-1	2119792-2	-	2119641-2	-	2063440-1
					SERVO LATCH PLATE	2119951-1	1901697-1	8-2150338-5	-	-	2168400-7 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2150338-4	-	-	-
	2-2150338-2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	MECHANICAL FEED	2119949-1	2063961-1	5-18022-5	2119653-2	-	-
					SERVO LATCH PLATE	2119951-1	1901697-1	8-2150338-5	-	-	2168400-7 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2150338-4	-	-	-
	2-2150338-5	A	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE	MECHANICAL FEED	2119949-1	2063961-1	5-18022-5	2119653-2	-	-
					PNEUMATIC FEED	2119950-1	2119792-2	-	2119641-2	-	2063440-1
	2-2150338-7	A	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	-
	7-2150338-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-

APPLICATOR DATA		
CRIMP SIZE	TYPE	
WIRE 3.56 mm [1.40]	F	
INSUL 5.59 mm [2.20]	F	
APPL INSTRUCTIONS 408-10390		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: 6.3 SRS F-SPRING LIF RECEPTACLE			
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE		
5.90-6.90 mm [1.232-.272 IN]	3.60-5.00 mm [1.142-.197 IN]		
TERMINAL APPLICATION SPECIFICATION	114-64027		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
2178301-1			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
10 AWG	2.28 +/- 0.05 [1.090 +/- .002]	2.6
12 AWG	1.96 +/- 0.05 [1.077 +/- .002]	4.3
14 AWG	1.71 +/- 0.05 [1.067 +/- .002]	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: 8-2150338-4
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150338-4
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150338-5
- 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 ITEM 50 & 62. APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 50 & 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.
- TERMINAL LUBRICANT IS RECOMMENDED.

***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	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244				
-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243				
-77-	27-	25-	22-	21	PART NO	DESCRIPTION	ITEM NO				

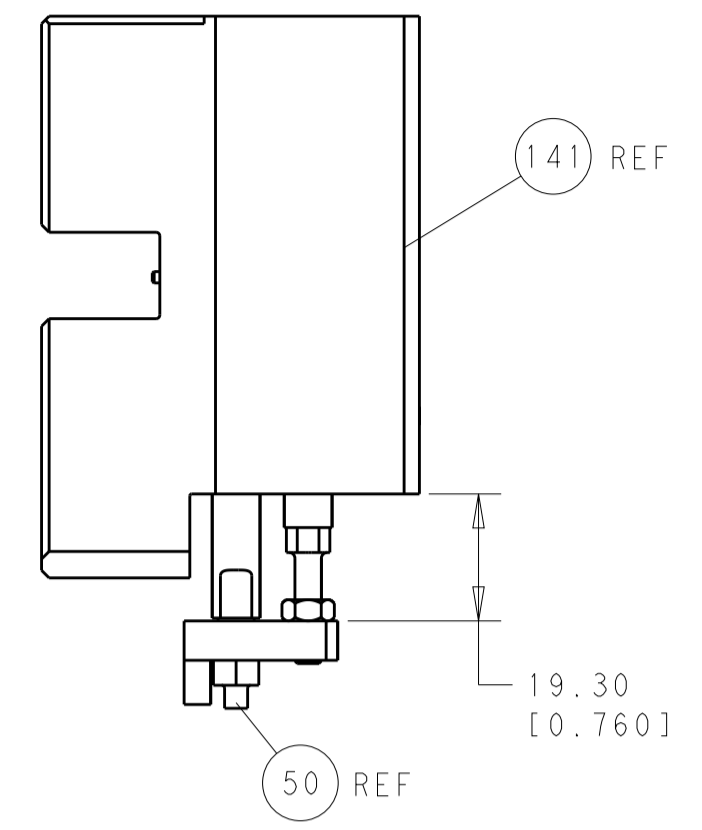
PACIFIC VERSION
 Shown on sheets 3 of 4 & 4 of 4
 (Atlantic version shown on sheets 1 of 4 & 2 of 4)

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

-	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242				
-	-	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	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	2119955-2	ASSY, LUBRICATOR, END FEED	84				
-	1	1	1	1	455888-5	SPACER, CRIMPER	82				
-	1	1	1	1	2119791-5	DEPRESSOR, WIRE	73				
-	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	1	1	1	2119943-1	WASHER, SPACER	69				
-	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	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	2063961-1	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	5018030-2	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	-	2119792-2	PAWL, EF, AIR	51				
-	1	1	1	1	1-1976055-0	STANDOFF, HOLD-DOWN	50				
-	-	-	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				
-	8	8	8	8	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	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	1320906-1	STUD, THREADED	25				
-	1	1	1	1	1-1752371-2	PLATE, STRIP GUIDE	24				
-	2	2	2	2	2-22281-3	SPRING, COMPRESSION	22				
-	1	1	1	1	1752373-4	DRAG	20				
-	2	2	2	2	1901259-7	GUIDE, LOWER STRIP	18				
-	1	1	1	1	1752360-1	SPACER, HOLD-DOWN	13				
-	1	1	1	1	240644-5	PLATE, REAR SHEAR	11				
-	1	1	1	1	6-690482-7	PLATE, FRONT SHEAR	9				
-	1	1	1	1	1803059-4	ANVIL, COMBINATION, END FEED	8				
-	1	1	1	1	1-2217206-3	BLADE, SLUG	7				
-	-	-	-	-	-	-	6				
-	1	1	1	1	3-240641-5	SPACER	5				
-	1	1	1	1	2-238009-9	BLOCK, FL CRIMPER SPACER	4				
-	1	1	1	1	8-2119582-3	CRIMPER, INSULATION F PREMIUM	3				
-	1	1	1	1	455888-3	SPACER, CRIMPER	2				
-	1	1	1	1	6-1633730-7	CRIMPER, WIRE	1				
-77-	27-	25-	22-	21	PART NO	DESCRIPTION	ITEM NO				

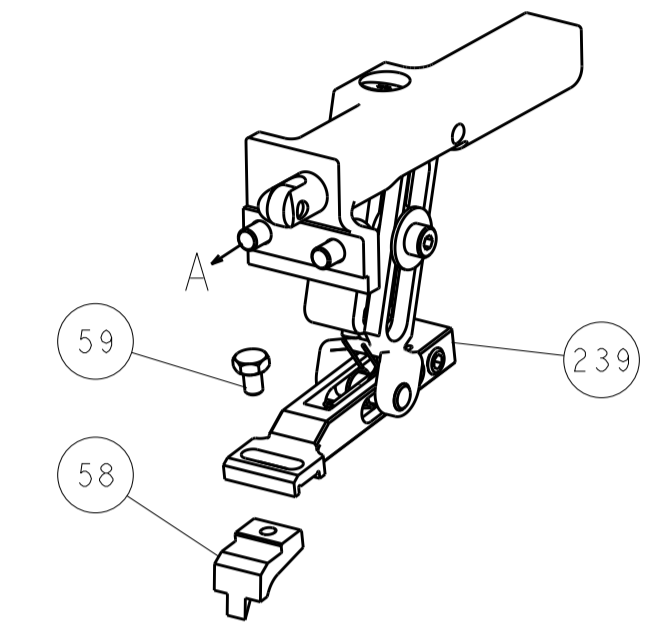
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DRAWN		CHK		APPV		NAME	
mm	0 PLC ±.5	1 PLC ±.13	2 PLC ±.013	3 PLC ±.001	Y. YIN	08MAY2013	G. BAILEY	08MAY2013	U. GUO	08MAY2013	TE Connectivity Harrisburg, PA 17105-3608
MATERIAL:		FINISH:		WEIGHT:		SCALE:		SHEET:		REV:	
						A1		3 OF 4		A1	

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

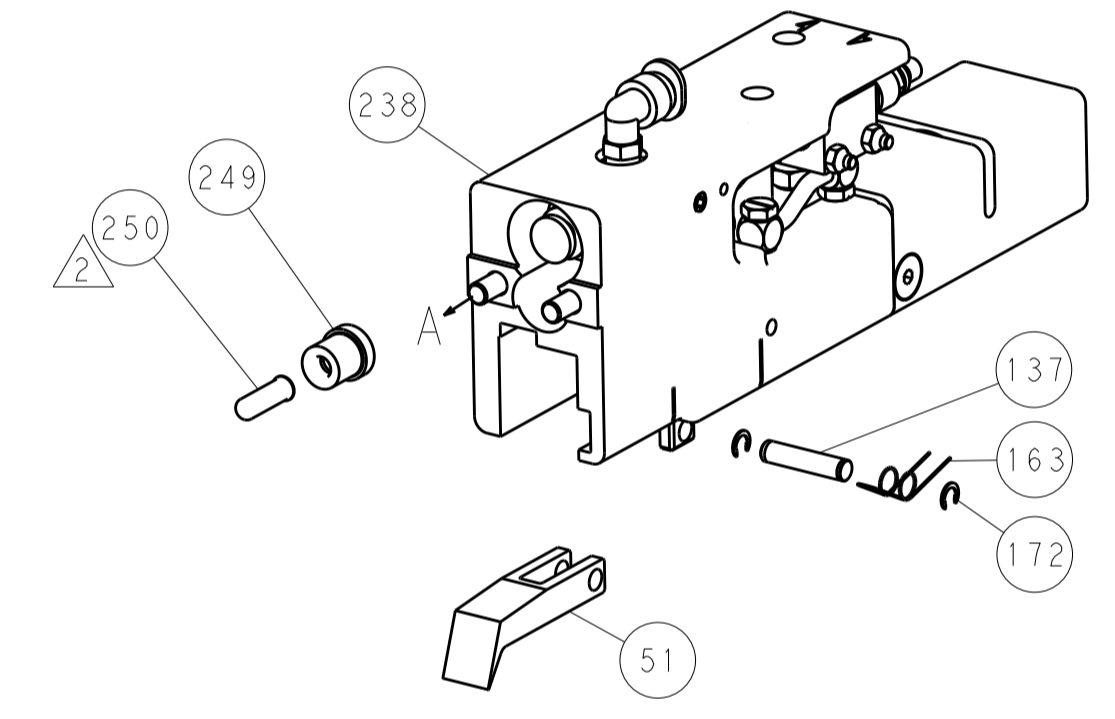


HOLDDOWN SET-UP

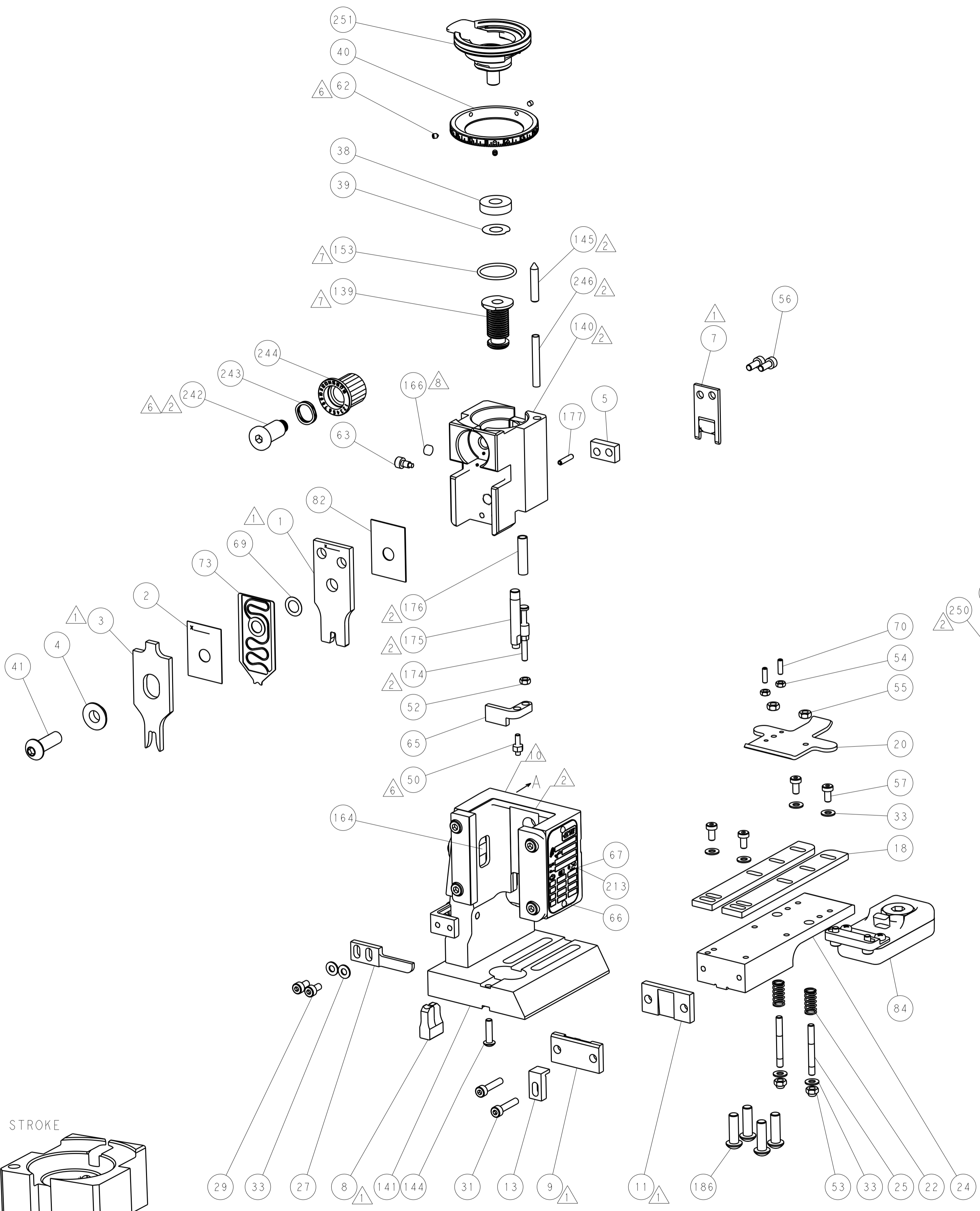
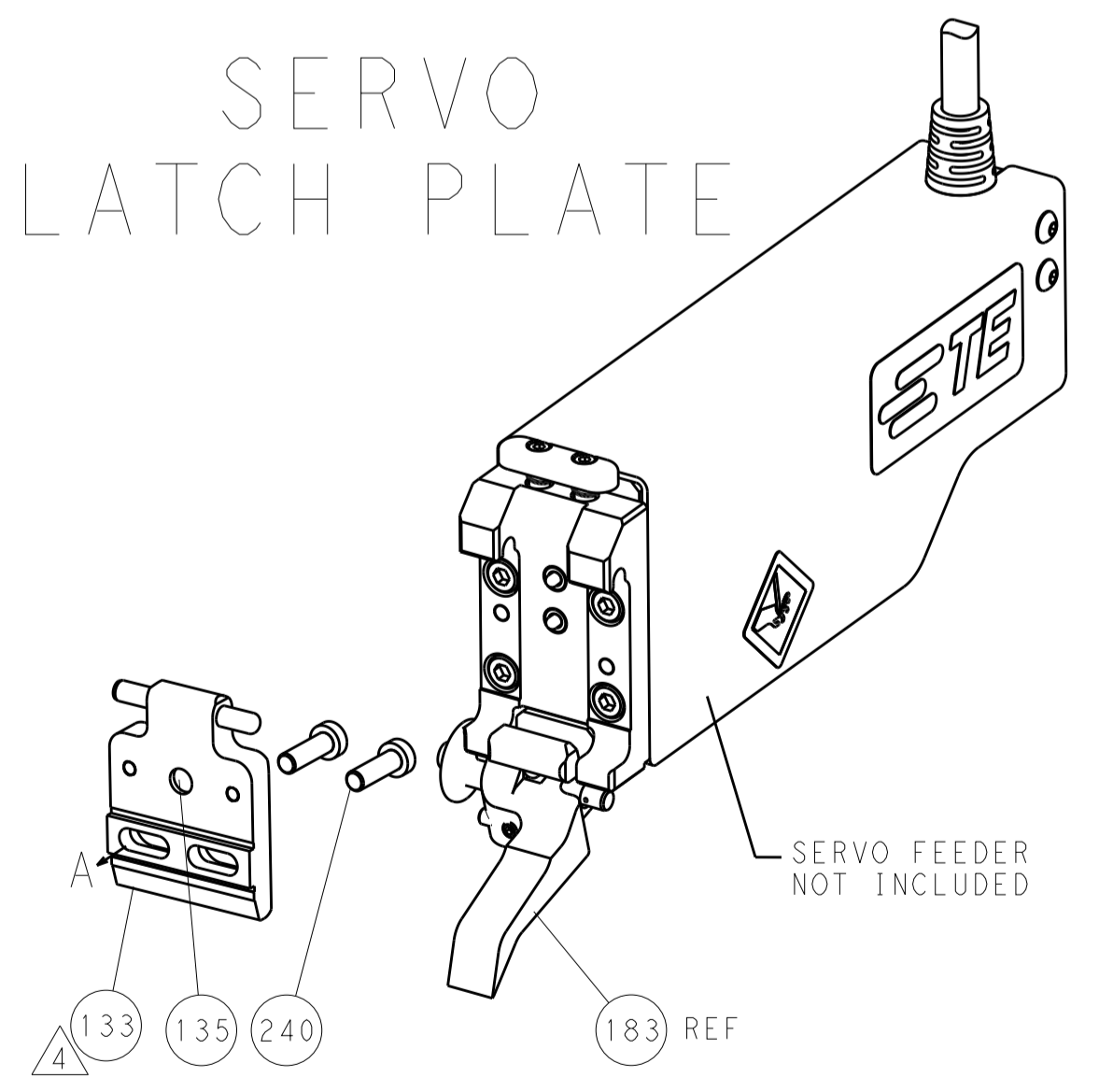
FEED TYPE
MECHANICAL



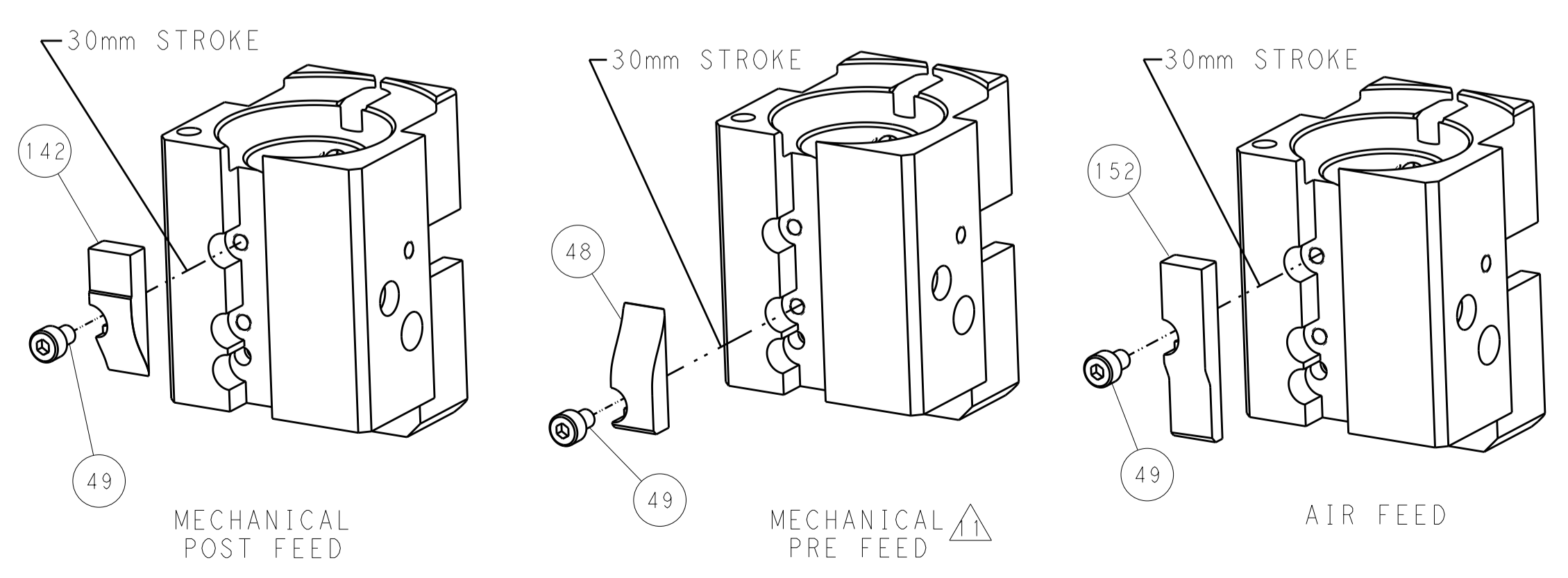
PNEUMATIC



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: Y. YIN 08MAY2013		TE Connectivity	
mm	0 PLC ±0.5	1 PLC ±0.5	2 PLC ±0.13	3 PLC ±0.13	CHK: G. BAILEY 08MAY2013	Harrisburg, PA 17105-3608	
	4 PLC ±0.013	5 PLC ±0.013	6 PLC ±0.001	APVD: H. GUO 08MAY2013	NAME: Ocean End Feed Applier		
MATERIAL:	FINISH:	WEIGHT:	ANGLES:	PRODUCT SPEC:		SIZE: A1	CAGE CODE: 00779
CUSTOMER ACCESSIBLE PRODUCTION DRAWING				SCALE: 1:1	SHEET: 4	OF: 4	REV: A1