

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART							
					CONVERT TO	PART NUMBERS REQUIRED						
					PNEUMATIC FEED	2119950-1	2119792-2	-	2119641-1	-	2063440-1	
	2150024-1	D	FINE CRIMP HEIGHT ADJUST	MECHANICAL	SERVO LATCH PLATE	2119951-1	1901697-1	8-2150024-5	-	-	2168400-7 (QUANTITY 2)	
	2150024-2	D	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	SMART APPLICATOR	2161326-1	-	8-2150024-4	-	-	-	
	2150024-5	D	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE	MECHANICAL FEED	2119949-1	2063961-1	5-18022-5	2119653-1	-	-	
	2150024-6	D	NON-CRIMP HEIGHT ADJUST	SERVO LATCH PLATE	SERVO LATCH PLATE	2119951-1	1901697-1	8-2150024-5	-	-	2168400-7 (QUANTITY 2)	
	2150024-7	D	FINE CRIMP HEIGHT ADJUST	NONE	SMART APPLICATOR	2161326-1	-	8-2150024-4	-	-	-	
	7-2150024-7	A	CRIMP TOOLING KIT	-	MECHANICAL FEED	2119949-1	2063961-1	5-18022-5	2119653-1	-	2063440-1	
						PNEUMATIC FEED	2119950-1	2119792-2	-	2119641-1	-	-
						-	-	-	-	-	-	-
						-	-	-	-	-	-	-
						-	-	-	-	-	-	-

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.57 mm [0.062]	F
INSUL	2.79 mm [0.110]	F
APPLICATOR INSTRUCTIONS 408-10390		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: 110 SERIES FASTON RECEPTACLE			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
3.96-4.75 mm [0.156-0.187 IN]		Ø2.00-3.00 mm [0.079-0.118 IN]	
TERMINAL APPLICATION SPECIFICATION	114-5084		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
170043-1	170043-2	170043-3	170043-4
170043-5	170043-6	170043-7	1-170043-2
2-170043-4	170056-1	170056-2	170056-3
170056-4			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.50mm2	1.02 +/- 0.05 [0.040 +/- .002]	7.4
0.30mm2	0.91 +/- 0.05 [0.036 +/- .002]	8.9
0.20mm2	0.84 +/- 0.05 [0.033 +/- .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: 8-2150024-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150024-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150024-5
SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2150024-6
- 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 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 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

***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	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244

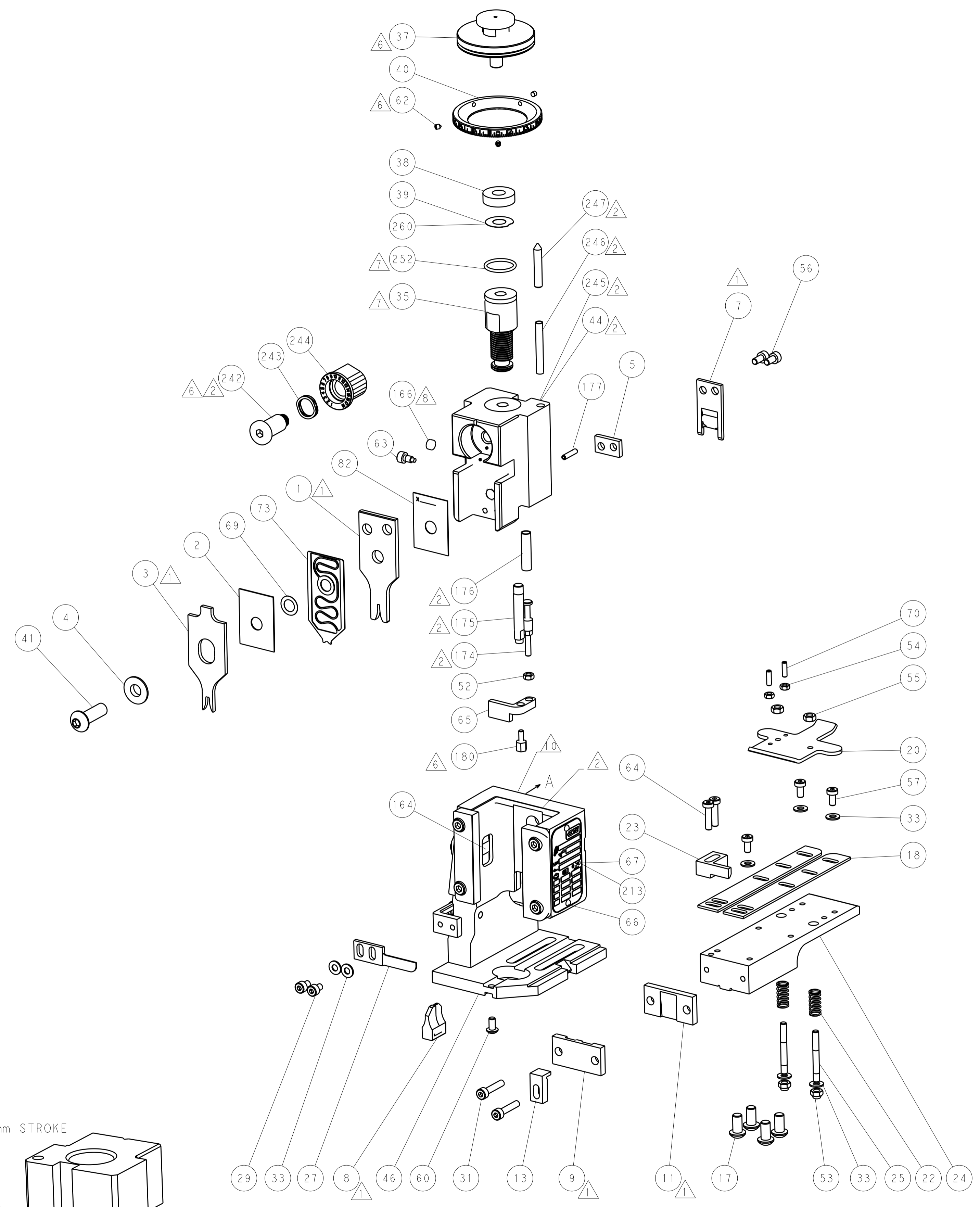
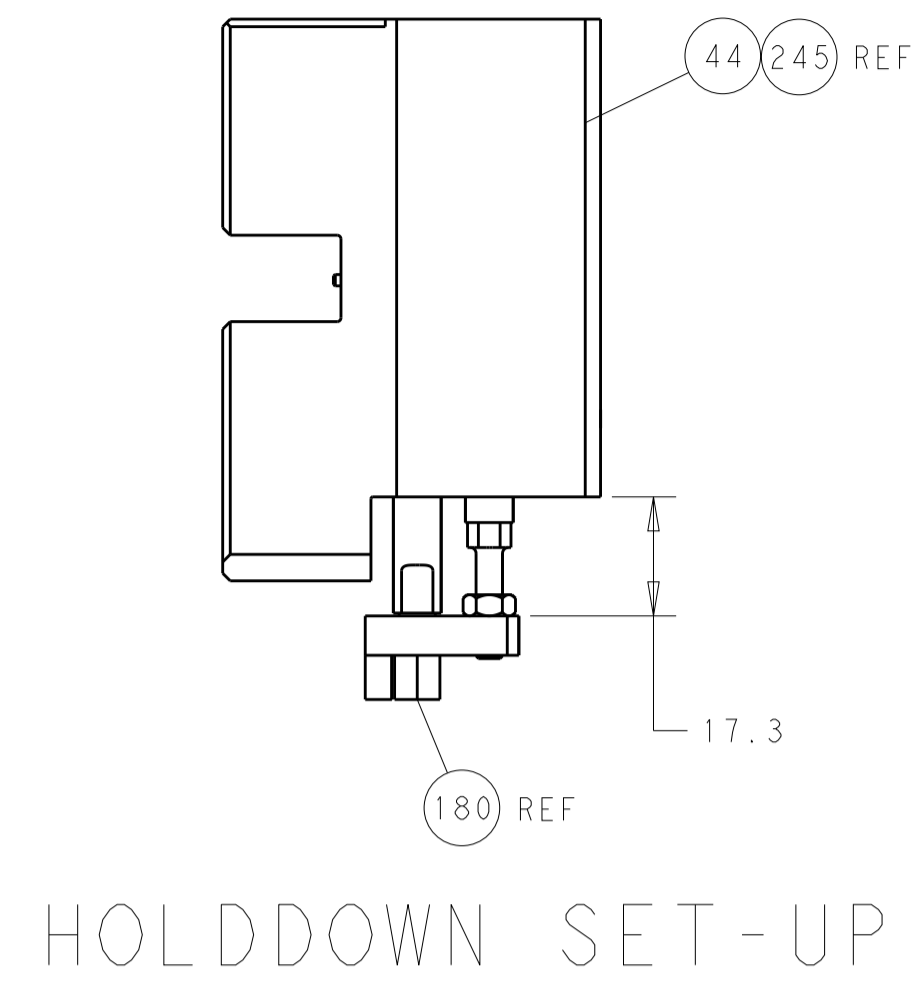
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

SET UP GAUGE	LOC	DIST	REVISIONS				
2119599-2	A	66	R	L	DATE	BY	APPV
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			C		23SEP2013	XZ	GB
			D		14JUL2015	YY	GB

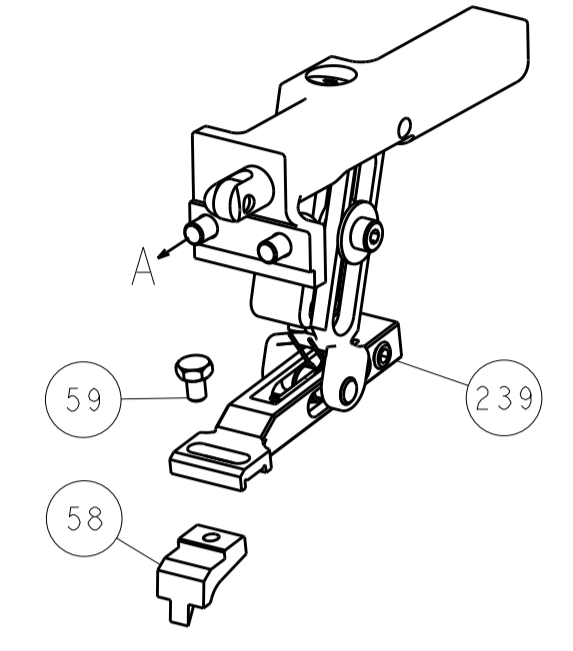
QTY	QTY	QTY	QTY	QTY	QTY	PART NO	DESCRIPTION	ITEM NO
-	1	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	-	2	2	-	-	2168400-7	SHCS, LOW HEAD, RoHS, M5 X 10	240
-	-	-	-	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	-	-	-	-	1	2063440-1	AIR FEED MODULE	238
-	-	1	1	-	-	2119740-2	TAG, IDENTIFICATION	213
-	-	REFREF	-	-	-	1901697-1	FEED FINGER ASSEMBLY,EF	183
-	1	1	1	1	1	1752354-8	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	2119791-5	DEPRESSOR, WIRE	73
-	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	1	1	2119943-1	WASHER, SPACER	69
-	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	1901681-5	HOLDDOWN, TERMINAL	65
-	2	2	2	2	2	2168400-8	SHCS, LOW HEAD, RoHS, M4 X 16	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	2063961-1	FEED FINGER	58
-	3	3	3	3	3	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57
-	2	2	2	2	2	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	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	2119792-2	PAWL, EF, AIR	51
-	-	-	-	-	1	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	2119644-1	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	2168083-5	SCR, SKT HD CAP, RoHS, M4 X 6.0	29
-	1	1	1	1	1	240639-2	STRIPPER (MACHINING)	27
-	2	2	2	2	2	1320906-1	STUD, THREADED	25
-	1	1	1	1	1	1752371-1	PLATE, STRIP GUIDE	24
-	1	1	1	1	1	240825-4	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	1901259-3	GUIDE, LOWER STRIP	18
-	4	4	4	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17
-	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	690482-6	PLATE, FRONT SHEAR	9
-	1	1	1	1	1	1633386-7	ANVIL, COMBINATION	8
-	1	1	1	1	1	2217206-4	BLADE, SLUG	7
-	1	1	1	1	1	240641-5	SPACER	5
-	1	1	1	1	1	238009-4	BLOCK, FL CRIMPER SPACER	4
-	1	1	1	1	1	2119582-2	CRIMPER, INSULATION F PREMIUM	3
-	1	1	1	1	1	455888-5	SPACER, CRIMPER	2
-	1	1	1	1	1	1-456403-5	CRIMPER, WIRE PREMIUM	1

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DATE		NAME	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	DATE	
	ANGLES	FINISH	SCALE	1:1	SHEET 1 OF 4	REV D	
MATERIAL	Customer Accessible Production Drawing	WEIGHT	00779	C=2150024	RESTRICTED TO		
Customer Accessible Production Drawing				SCALE	SHEET	REV	

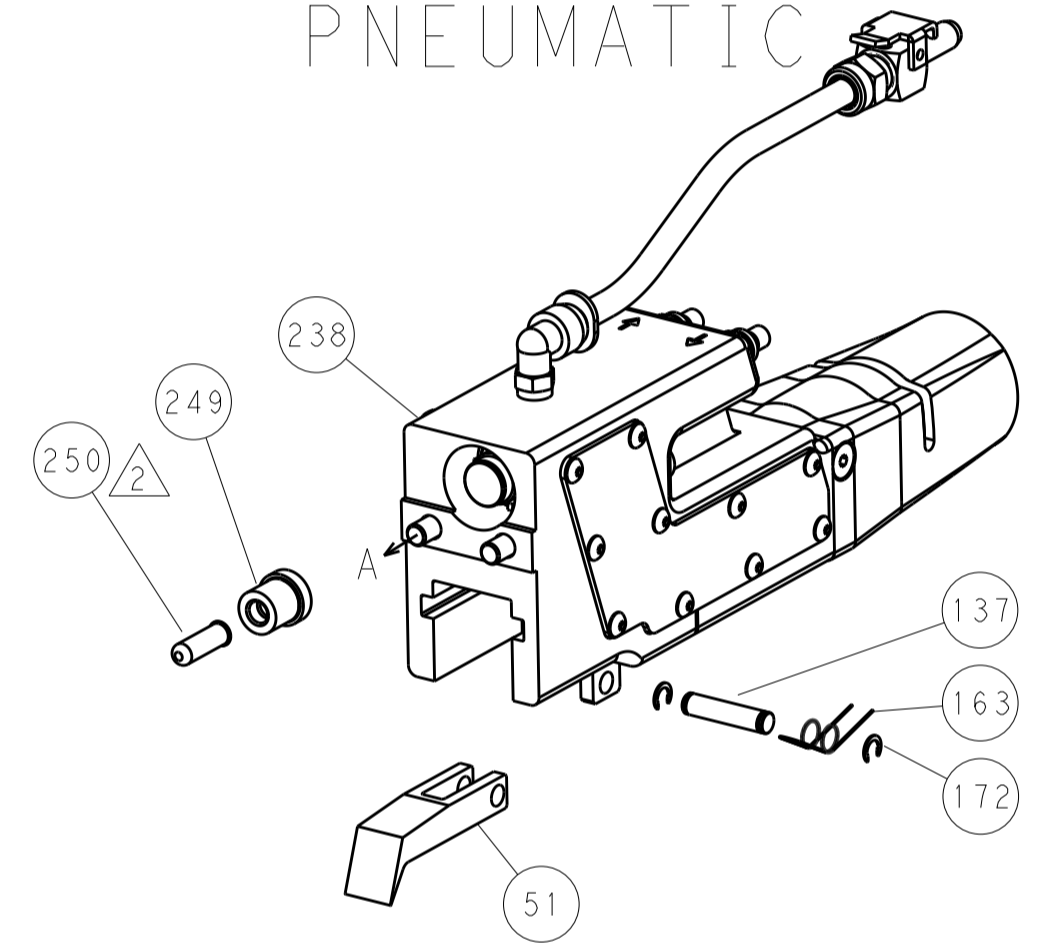
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A	66	P	LTM	DESCRIPTION	DATE	OWN	APVD
		-	-	SEE SHEET 1	-	-	-



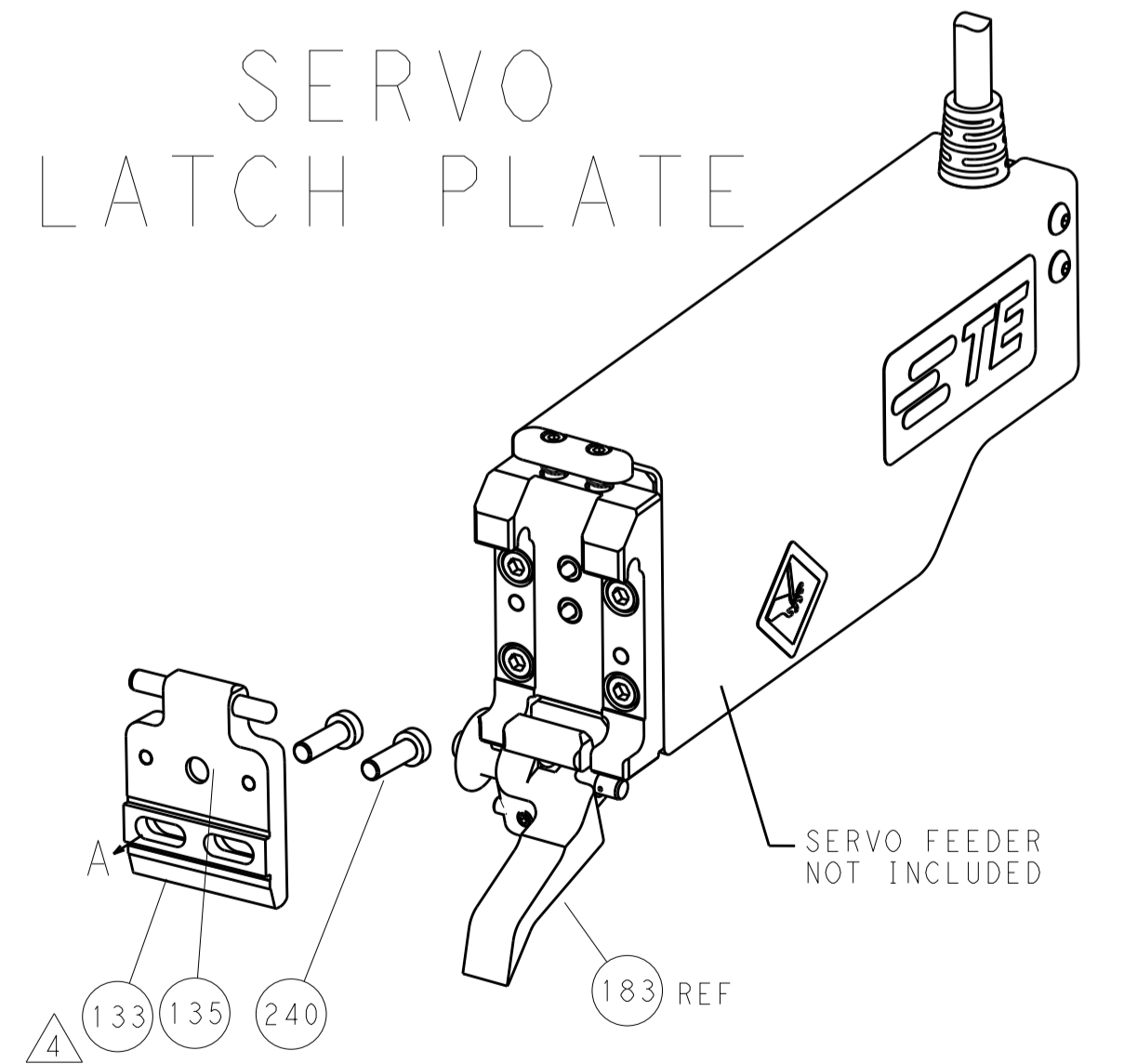
FEED TYPE
MECHANICAL



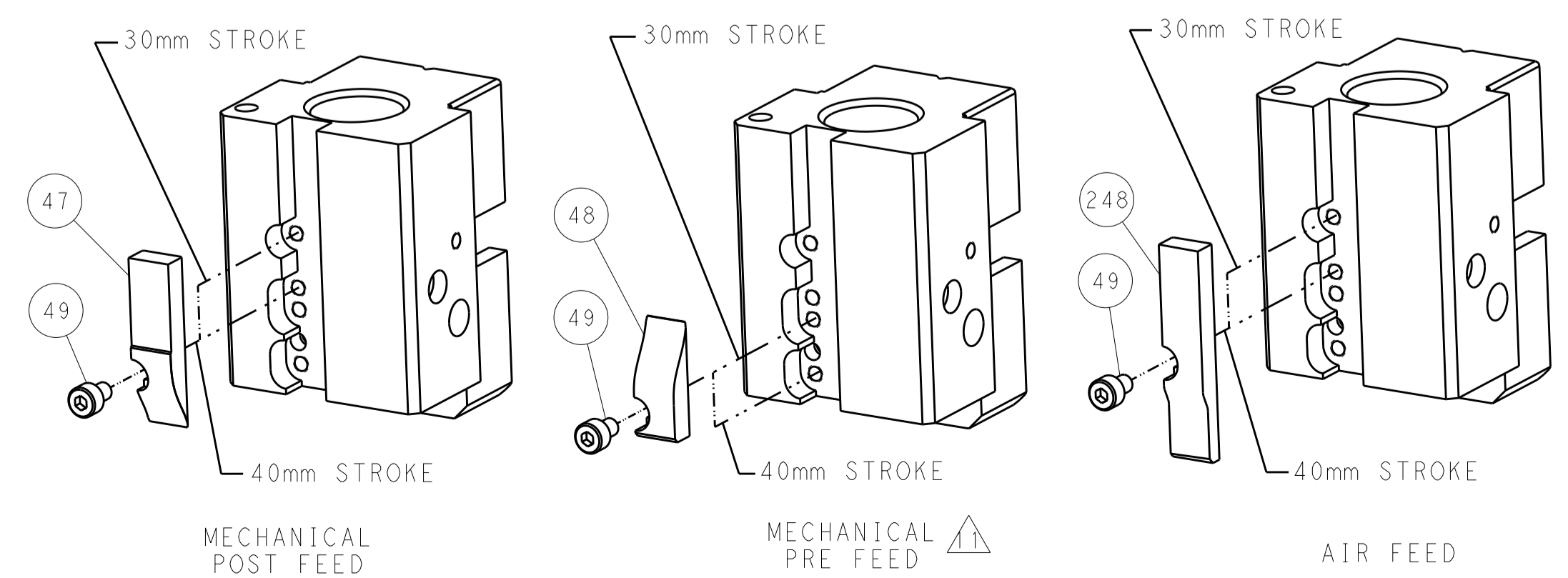
PNEUMATIC



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: X_ZHAO 06JUN2012		TE Connectivity	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	5 PLC ±	Harrisburg, PA 17105-3608
MATERIAL:		FINISH:		CHK: T_ELBIN 06JUN2012		NAME: Ocean End Feed Applicator	
				APVD: S_XI 06JUN2012		SIZE: CAGE CODE DRAWING NO. RESTRICTED TO	
				PRODUCT SPEC:		A1 00779 ©=2150024	
				APPLICATION SPEC:		Customer Accessible Production Drawing	
				WEIGHT:		SCALE: 1:1 SHEET 2 OF 4 REV D	
				ANGLES:		SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION	

PACIFIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART						
					CONVERT TO	PART NUMBERS REQUIRED					
	2-2150024-1	D	FINE CRIMP HEIGHT ADJUST	MECHANICAL	PNEUMATIC FEED	2119950-1	2119792-2	-	2119641-2	-	2063440-1
					SERVO LATCH PLATE	2119951-1	1901697-1	8-2150024-5	-	-	2168400-7 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2150024-4	-	-	-
	2-2150024-2	D	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	MECHANICAL FEED	2119949-1	2063961-1	5-18022-5	2119653-2	-	-
					SERVO LATCH PLATE	2119951-1	1901697-1	8-2150024-5	-	-	2168400-7 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2150024-4	-	-	-
	2-2150024-5	D	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
	2-2150024-7	D	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	-
	7-2150024-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-

APPLICATOR DATA		
CRIMP SIZE	TYPE	
WIRE 1.57 mm (.062)	F	
INSUL 2.79 mm (.110)	F	
APPLICATOR INSTRUCTIONS 408-10390		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: 110 SERIES FASTON RECEPTACLE			
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE		
3.96-4.75 mm (.156-.187 IN)	2.00-3.00 mm (.079-.118 IN)		
TERMINAL APPLICATION SPECIFICATION	114-5084		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
170043-1	170043-2	170043-3	170043-4
170043-5	170043-6	170043-7	1-170043-2
2-170043-4	170056-1	170056-2	170056-3
170056-4			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.50mm2	1.02 +/- 0.05 [.040 +/- .002]	7.4
0.30mm2	0.91 +/- 0.05 [.036 +/- .002]	8.9
0.20mm2	0.84 +/- 0.05 [.033 +/- .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: 8-2150024-4
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150024-4
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150024-5
- 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 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	2119082-9	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

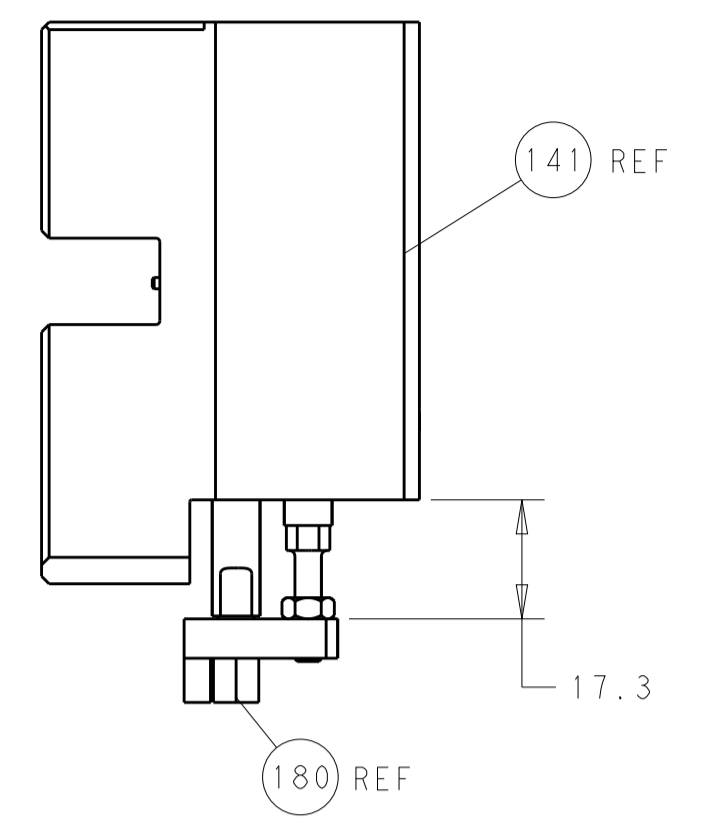
PACIFIC VERSION
 Shown on sheets 3 of 4 & 4 of 4
 (Atlantic version shown on sheets 1 of 4 & 2 of 4)

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

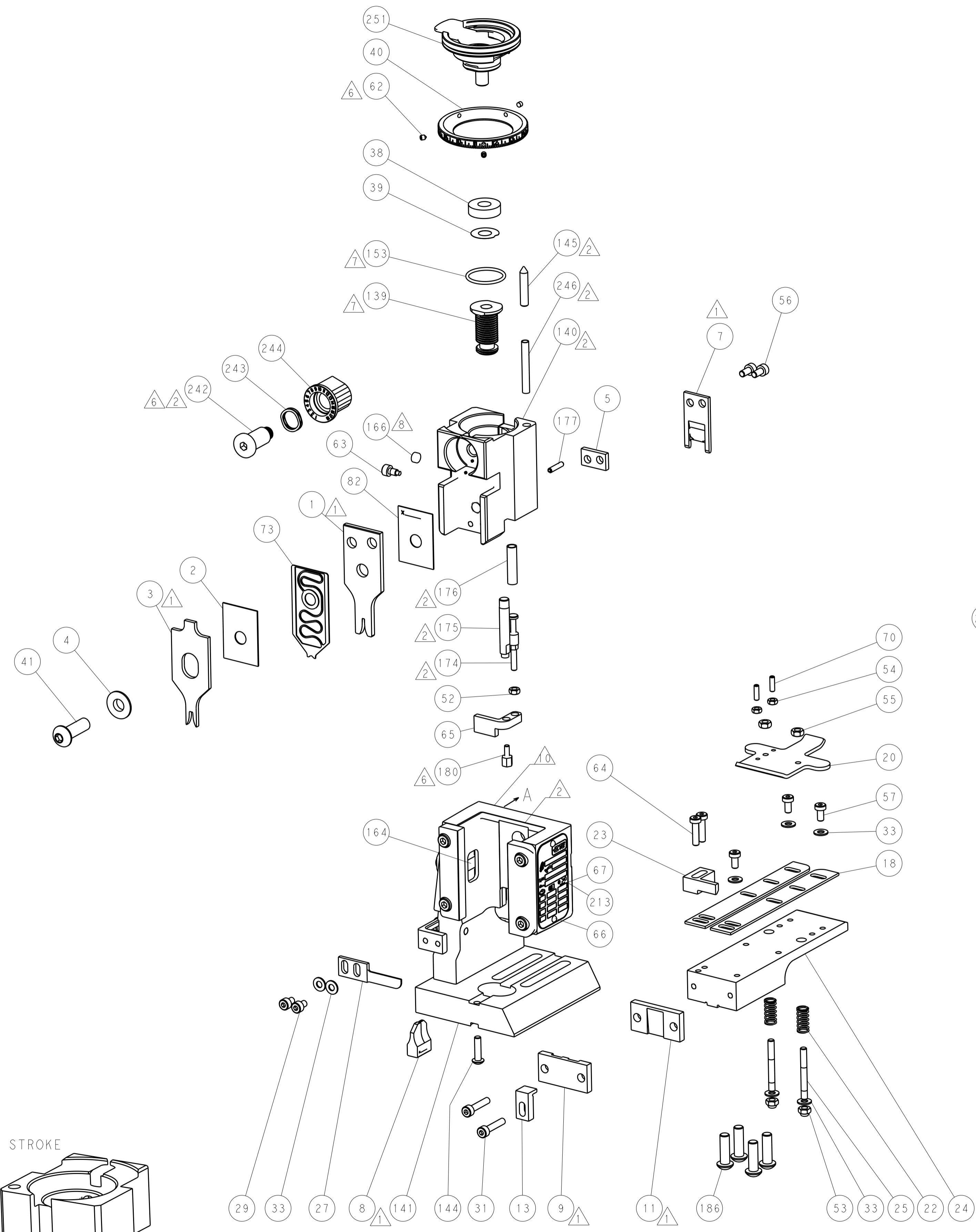
1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242	
-	-	2	-	2168400-7	SHCS, LOW HEAD, RoHS, M5 X 10	240	
-	-	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239	
-	-	-	1	2063440-1	AIR FEED MODULE	238	
-	-	1	-	2119740-2	TAG, IDENTIFICATION	213	
-	4	4	4	2079383-9	SCR, BHSC, RoHS (M6 X 20)	186	
-	-	REF	-	1901697-1	FEED FINGER ASSEMBLY, EF	183	
1	1	1	1	1752354-8	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	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	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	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	
2	2	2	2	2168400-8	SHCS, LOW HEAD, RoHS, M4 X 16	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	2063961-1	FEED FINGER	58	
3	3	3	3	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57	
2	2	2	2	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	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	2119792-2	PAWL, EF, AIR	51	
-	-	-	1	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	2119644-1	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	2168083-5	SCR, SKT HD CAP, RoHS, M4 X 6.0	29	
1	1	1	1	240639-2	STRIPPER (MACHINING)	27	
2	2	2	2	1320906-1	STUD, THREADED	25	
1	1	1	1	1752371-1	PLATE, STRIP GUIDE	24	
1	1	1	1	240825-4	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	1901259-3	GUIDE, LOWER STRIP	18	
1	1	1	1	1752360-1	SPACER, HOLD-DOWN	13	
1	1	1	1	240644-1	PLATE, REAR SHEAR	11	
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1	1	1	1	690482-6	PLATE, FRONT SHEAR	9	
1	1	1	1	1633386-7	ANVIL, COMBINATION	8	
1	1	1	1	2217206-4	BLADE, SLUG	7	
1	1	1	1	240641-5	SPACER	5	
1	1	1	1	238009-4	BLOCK, FL CRIMPER SPACER	4	
1	1	1	1	2119582-2	CRIMPER, INSULATION F PREMIUM	3	
1	1	1	1	455888-5	SPACER, CRIMPER	2	
1	1	1	1	1-456403-5	CRIMPER, WIRE PREMIUM	1	
-77-	27-	25-	22-	21	PART NO	DESCRIPTION	ITEM NO

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DATE		DRAWING NO	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	5 PLC ±	ANGLES ±
MATERIAL:	FINISH:	WEIGHT:	SCALE:	Customer Accessible Production Drawing	SCALE	SHEET 3 OF 4	REV D

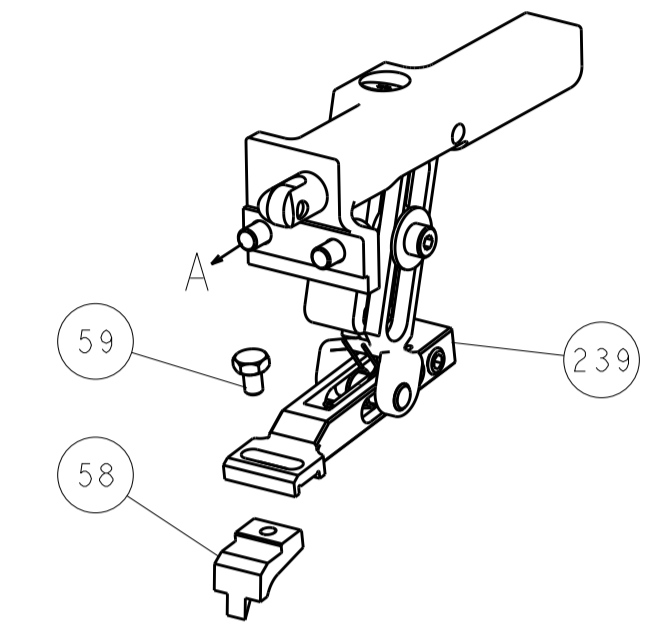
LOC		DIST		REVISIONS			
A	66	P	LTM	DESCRIPTION	DATE	OWN	APVD
		-	-	SEE SHEET 1	-	-	-



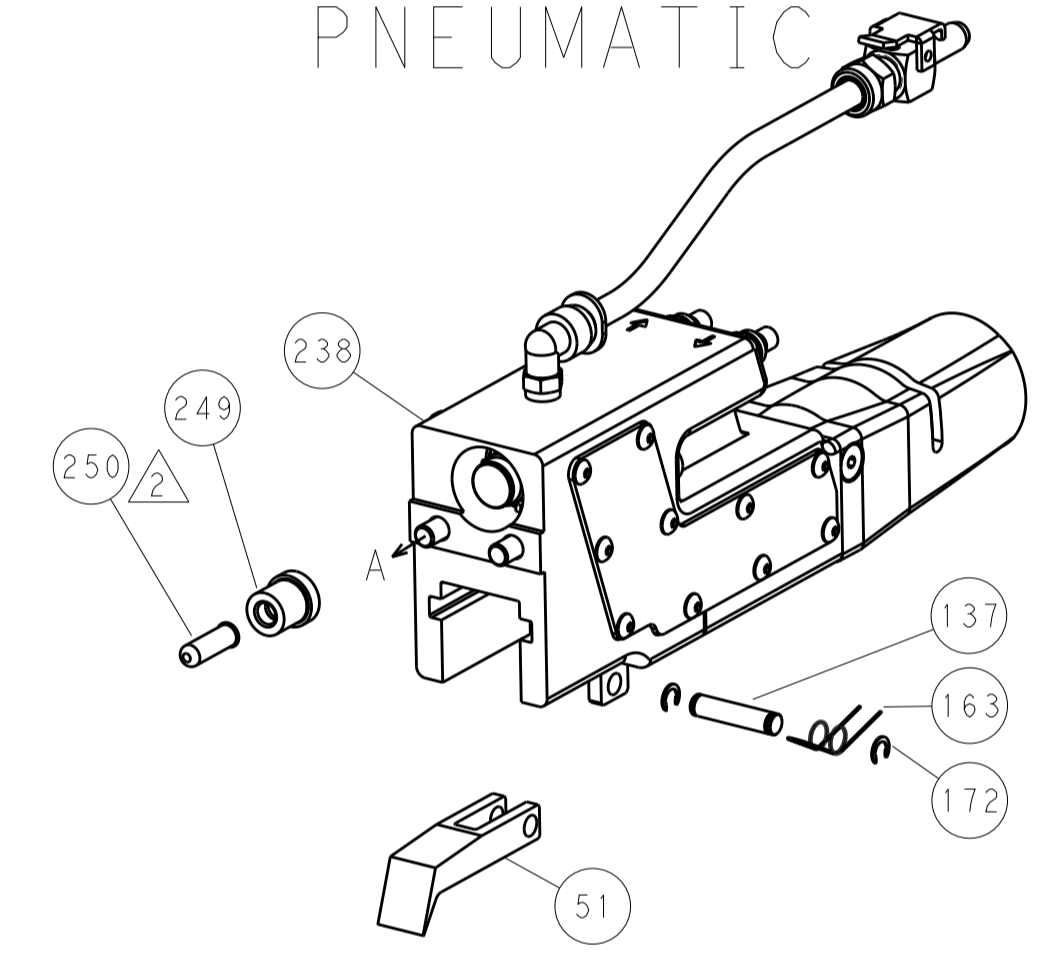
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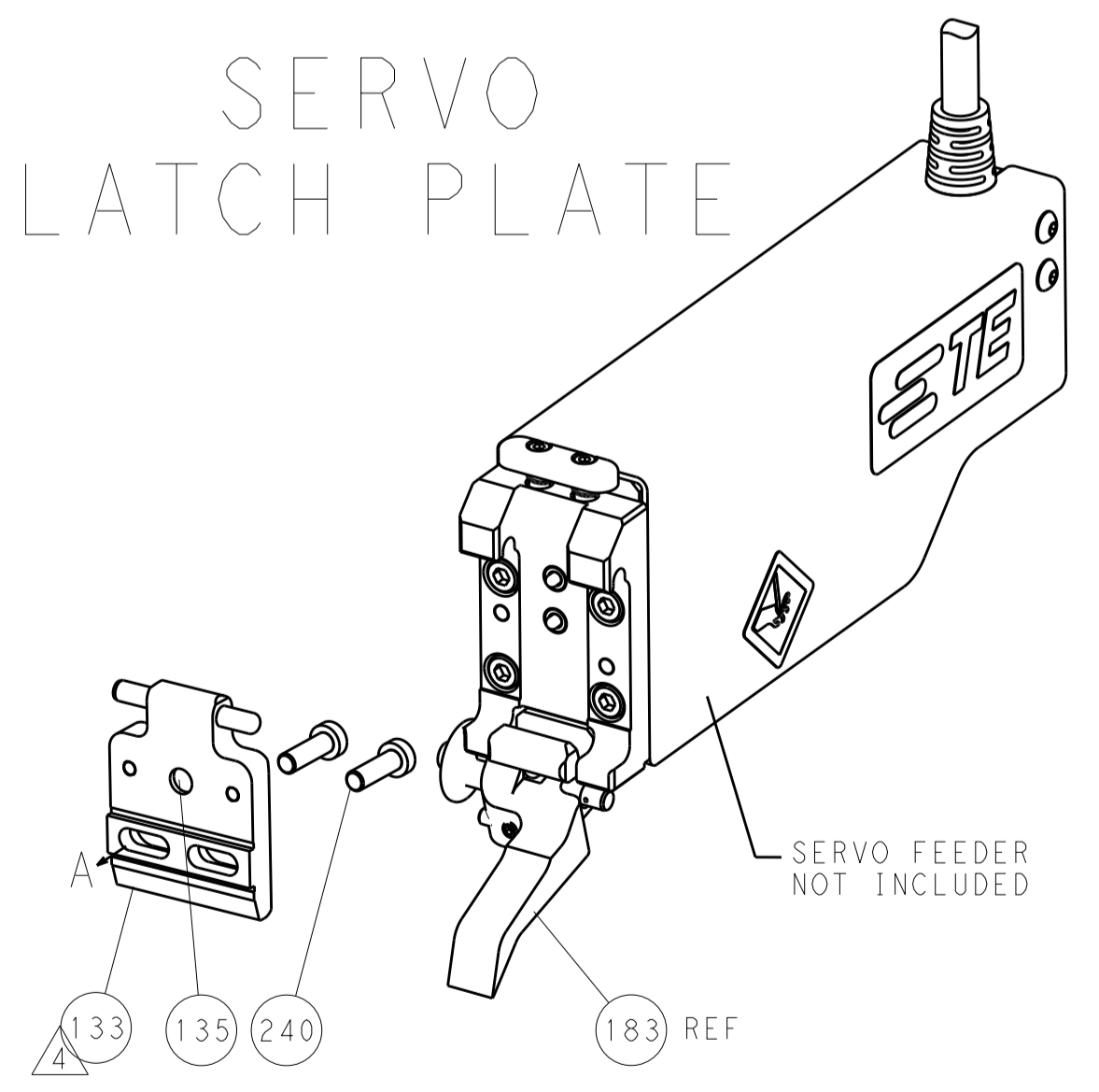
FEED TYPE
MECHANICAL



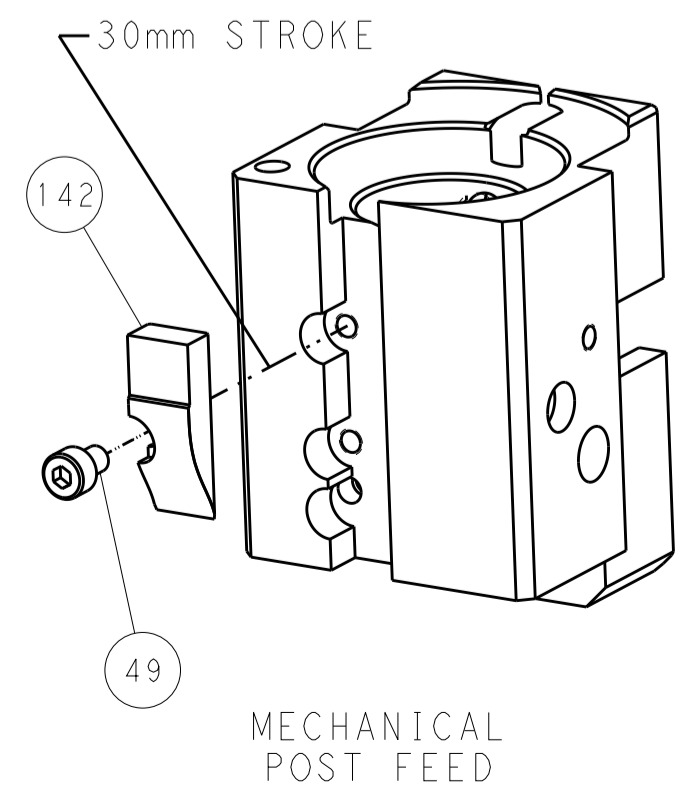
PNEUMATIC



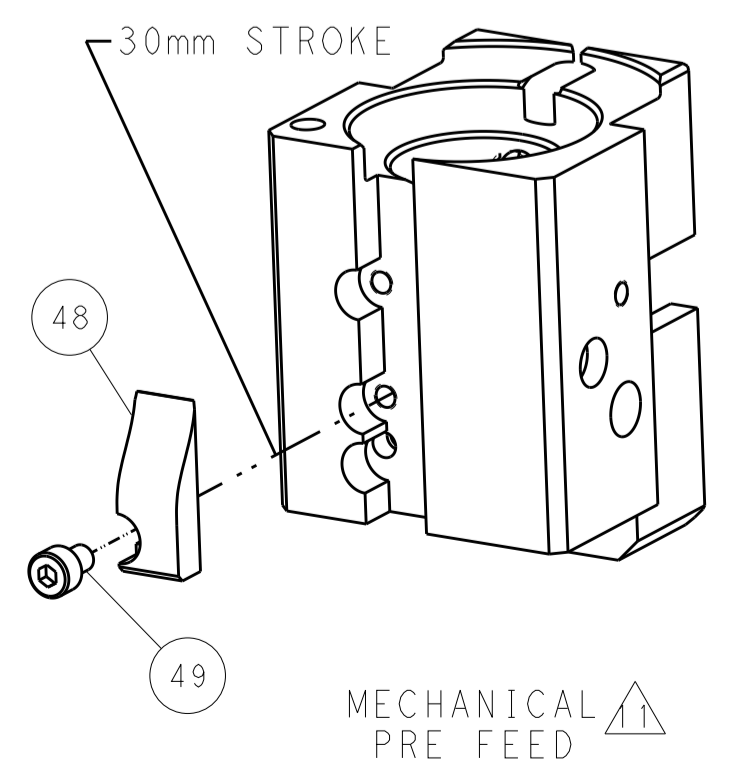
SERVO
LATCH PLATE



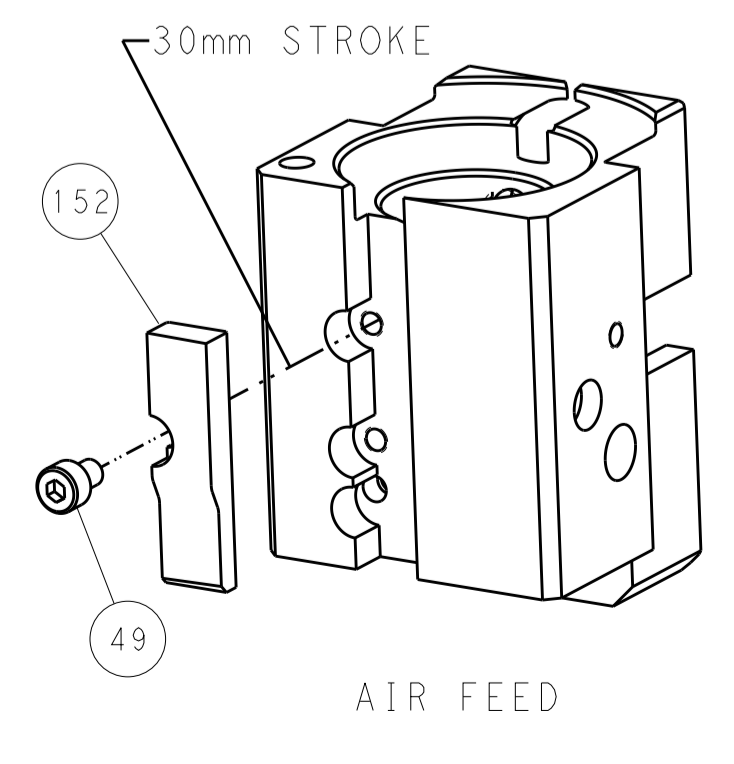
CAM POSITIONS



MECHANICAL POST FEED



MECHANICAL PRE FEED



AIR FEED

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 X_ZHAO 06JUN2012		STE TE Connectivity Harrisburg, PA 17105-3608	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	5 PLC ±	NAME
	ANGLES	FINISH		APVD S_XI 06JUN2012			Product Spec
MATERIAL							Application Spec
				WEIGHT		SIZE	CAGE CODE DRAWING NO
						A11	00779 C=2150024
							RESTRICTED TO
							Customer Accessible Production Drawing
						SCALE	SHEET 4 OF 4 REV D
						1:1	