

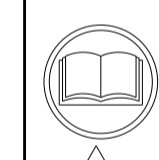
ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART						
					CONVERT TO	PART NUMBERS REQUIRED					
	2151850-1	A	FINE CRIMP HEIGHT ADJUST	MECHANICAL	PNEUMATIC FEED	2119950-1	1338685-1	5-18022-5	2119641-1	2119799-1	2063440-1
					SERVO LATCH PLATE	2119951-1	-	8-2151850-5	1901094-3	2-1752354-6	2168400-6 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2151850-4	-	-	-
	2151850-2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-1	-	-
					SERVO LATCH PLATE	2119951-1	-	8-2151850-5	1901094-3	2-1752354-6	2168400-6 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2151850-4	-	-	-
	2151850-5	A	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE <sup>4</sup>	MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-1	-	-
PNEUMATIC FEED					2119950-1	1338685-1	5-18022-5	2119641-1	2119799-1	2063440-1	
2151850-6	A	NON-CRIMP HEIGHT ADJUST	SERVO LATCH PLATE <sup>4</sup>	-	-	-	-	-	-	-	
				-	-	-	-	-	-	-	
2151850-7	A	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	-	
				-	-	-	-	-	-	-	
7-2151850-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-	

APPLICATOR DATA		
CRIMP WIRE	SIZE	TYPE
	3.68 mm [.145]	F
INSUL	4.37 mm [.172]	F

APPLICATOR INSTRUCTIONS 408-10389

TERMINAL DATA: DELPHI TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: TERM F M/P 630 P2S			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
4.60-4.60 mm [.181-.181 IN]		Ø3.40-3.70 mm [.134-.146 IN]	
TERMINAL APPLICATION SPECIFICATION	DELPHI		
TERMINALS APPLIED			
TE TERMINAL	DELPHI TERMINAL	TE TERMINAL	DELPHI TERMINAL
1572843-1	12176854-1		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
4.00mm2	2.55+/-0.05 [1.00+/-0.002]	6.6
3.00mm2	2.30+/-0.05 [0.91+/-0.002]	8.9



- 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: 8-2151850-4  
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151850-4  
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151850-5  
 SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2151850-6
- 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 & 242. FOR -6 ONLY APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 37, 180 & 242.
- 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 TO CONVERT THE APPLICATOR TO A NON-CARRIER CUTTING STYLE, REMOVE ITEM 13 AND ATTACH TO THE LOCATION ON THE BACK SIDE OF THE HOUSING. REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.
- 12 WHEN ASSEMBLING A NON CRIMP HEIGHT ADJUST APPLICATOR (-6) USE SHIMS FROM ITEM 260 TO ACHIEVE A NOMINAL SHIM HEIGHT OF 3.25.

**\*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	1	1803078-3	SPACER, PRECISION	259
-	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	-	-	-	2161314-1	RAM, STEPPED, ATLANTIC, SF, NON-ADJ	245

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

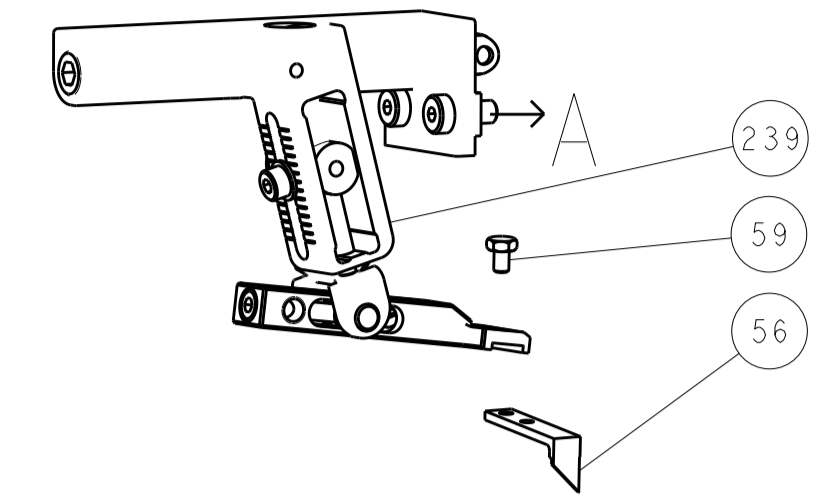
SET UP GAUGE	LOC	DIST	REVISIONS			
2119599-1	A	66	REV	DATE	BY	APPV
			1	ORIGINAL	19DEC2012	GH TE
			A	RELEASED	13FEB2013	GH TE

-	1	1	1	1	1	2119082-8	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	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
-	1	1	1	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
-	-	2	2	-	-	2168400-6	SHCS, LOW HEAD, RoHS, M5 X 16	240
-	-	-	-	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	-	-	-	-	1	2063440-1	AIR FEED MODULE	238
-	-	1	1	-	-	2119740-2	TAG, IDENTIFICATION	213
-	-	1	1	-	-	1901094-3	SPACER, FEEDER	198
-	1	1	1	1	1	2-1752354-6	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
-	-	-	-	1	-	2119799-1	HOLDER, FEED FINGER, AF	136
-	-	REF	REF	-	-	SEE NOTE 4	MEMORY CHIP, PROGRAMMED	135
-	-	1	1	-	-	1633743-1	SERVO FEED LATCH ASM	133
-	-	REF	REF	-	-	2119944-1	FEED FINGER ASSEMBLY, SF	117
-	1	1	1	1	1	318563-1	GUARD, FRONT CHIP	89
-	1	1	1	1	1	455888-6	SPACER, CRIMPER	82
-	1	1	1	1	1	455888-3	SPACER, CRIMPER	81
-	1	1	1	1	1	2119956-1	DOCUMENTATION PACKAGE	71
-	1	1	1	1	1	2119791-5	DEPRESSOR, WIRE	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	66
-	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	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	-	-	-	1	1	1338685-1	PAWL, FEED	56
-	4	4	4	4	4	2168400-1	SHCS, LOW HEAD, RoHS, M4 X 12	54
-	1	1	1	1	1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52
-	1	1	1	1	1	1901681-1	HOLDDOWN, TERMINAL	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	2119656-9	APPLICATOR BASIC ASSEMBLY, SF	46
-	1	-	1	1	1	2161311-1	RAM, STEPPED, AMP STYLE, SIDE FEED	44
-	1	1	1	1	1	1-2079383-5	SCR, BHSC, RoHS (M8 X 40)	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	2119644-3	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
-	1	1	1	1	1	1752356-1	SUPPORT, TERMINAL	34
-	2	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	1	1	1	1	1	2161328-1	HEX HEAD, FLANGED, M5 X 8mm LONG	32
-	1	1	1	1	1	1320908-7	SPACER, STRIP GUIDE	30
-	1	1	1	1	1	2119959-1	ASSEMBLY, STRIP GUIDE	29
-	1	1	1	1	1	1-455888-0	SPACER, CRIMPER	28
-	1	1	1	1	1	1320928-2	STRIP GUIDE	24
-	1	1	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
-	1	1	1	1	1	1-18028-2	WASHER, FLAT, REG M4	20
-	1	1	1	1	1	2119533-3	STRIPPER, SIDE FEED	19
-	1	1	1	1	1	2119806-1	INSERT, SHEAR	13
-	1	1	1	1	1	3-22280-3	SPRING, COMPRESSION	12
-	1	1	1	1	1	1-356885-4	STOP, SHEAR	11
-	1	1	1	1	1	2119805-1	SHEAR HOLDER, FRONT	10
-	1	1	1	1	1	318707-1	FLOATING SHEAR, FRONT	9
-	1	1	1	1	1	3-1633927-0	ANVIL, COMBINATION	8
-	-	-	-	-	-	-	-	7
-	-	-	-	-	-	-	-	6
-	1	1	1	1	1	2119757-9	DEPRESSOR, SHEAR	5
-	1	1	1	1	1	238011-4	BLOCK, CRIMPER SPACER	4
-	1	1	1	1	1	6-2119582-5	CRIMPER, INSULATION F PREMIUM	3
-	1	1	1	1	1	1-455888-1	SPACER, CRIMPER	2
-	1	1	1	1	1	2-1633609-4	CRIMPER, WIRE	1
-77	-7	-6	-5	-2	-1	PART NO	DESCRIPTION	ITEM NO

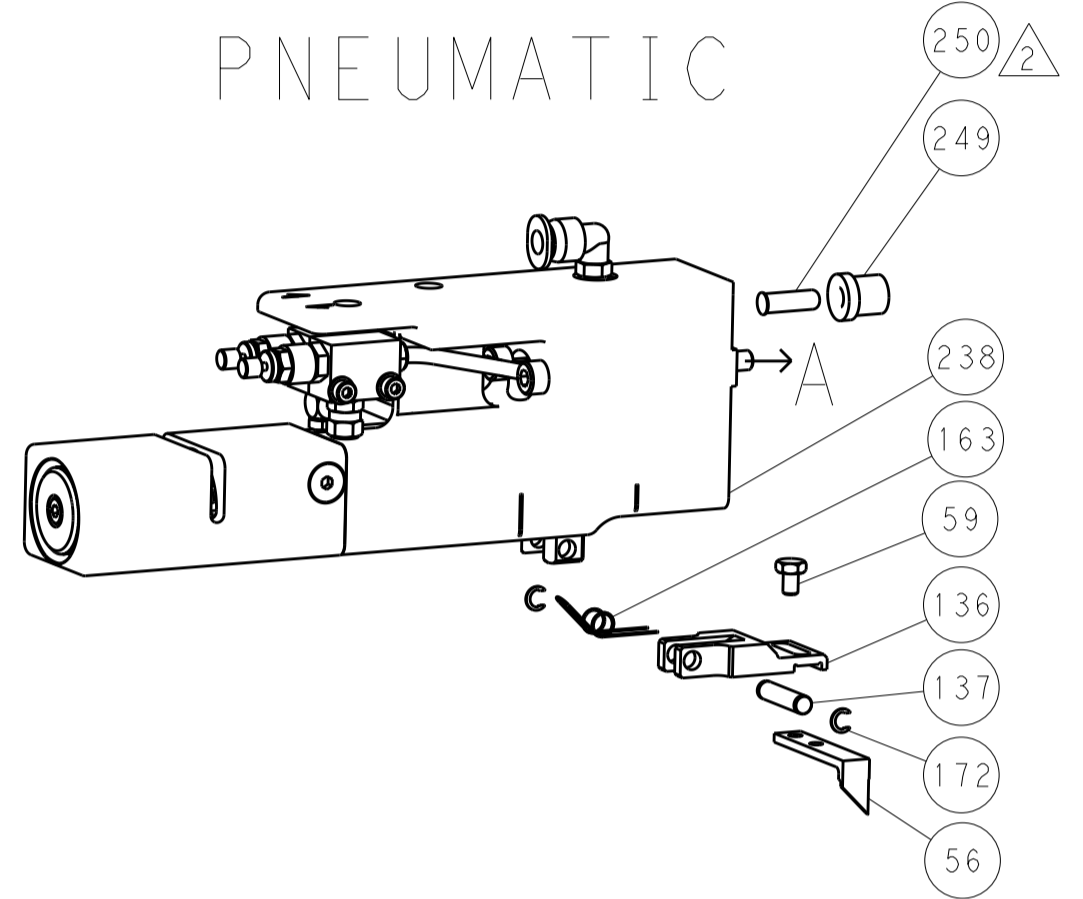
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		OWN	CHK	DATE	TE Connectivity	
mm	0 PLC ±0.1	1 PLC ±0.1	2 PLC ±0.02	G. HOFFNER	T. ELBIN	18DEC2012	Harrisburg, PA 17105-3608	
	3 PLC ±0.005	4 PLC ±0.0005	ANGLES ±0.0005	T. ELBIN	T. ELBIN	19DEC2012	Ocean Side Feed Applicator	
MATERIAL	FINISH	WEIGHT	SCALE	Customer Accessible Production Drawing		SIZE	CAGE CODE	DRAWING NO
			1:1			A1	00779	©=2151850

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

### FEED TYPE MECHANICAL



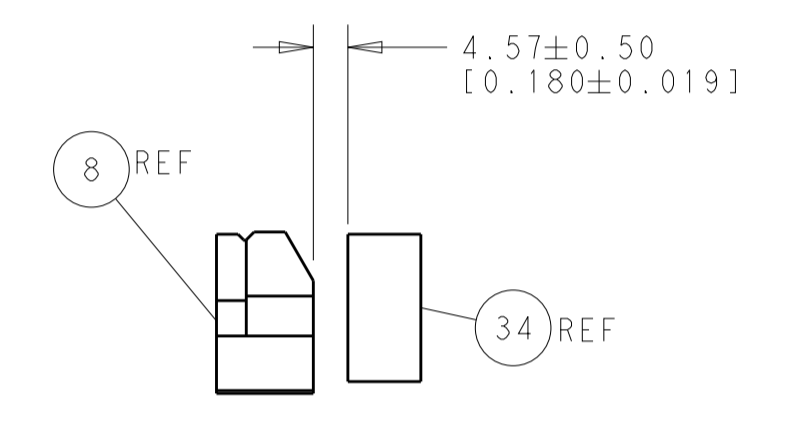
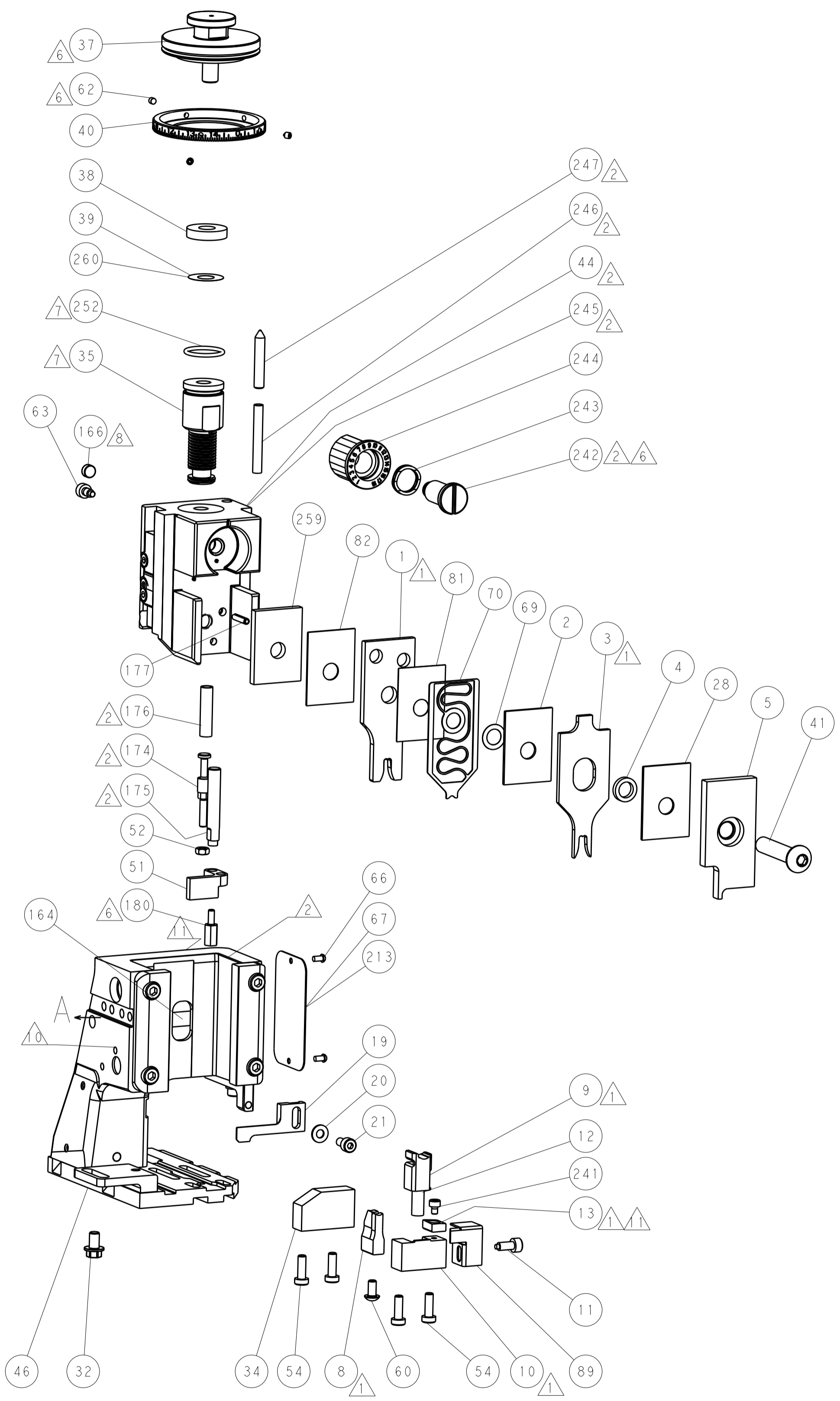
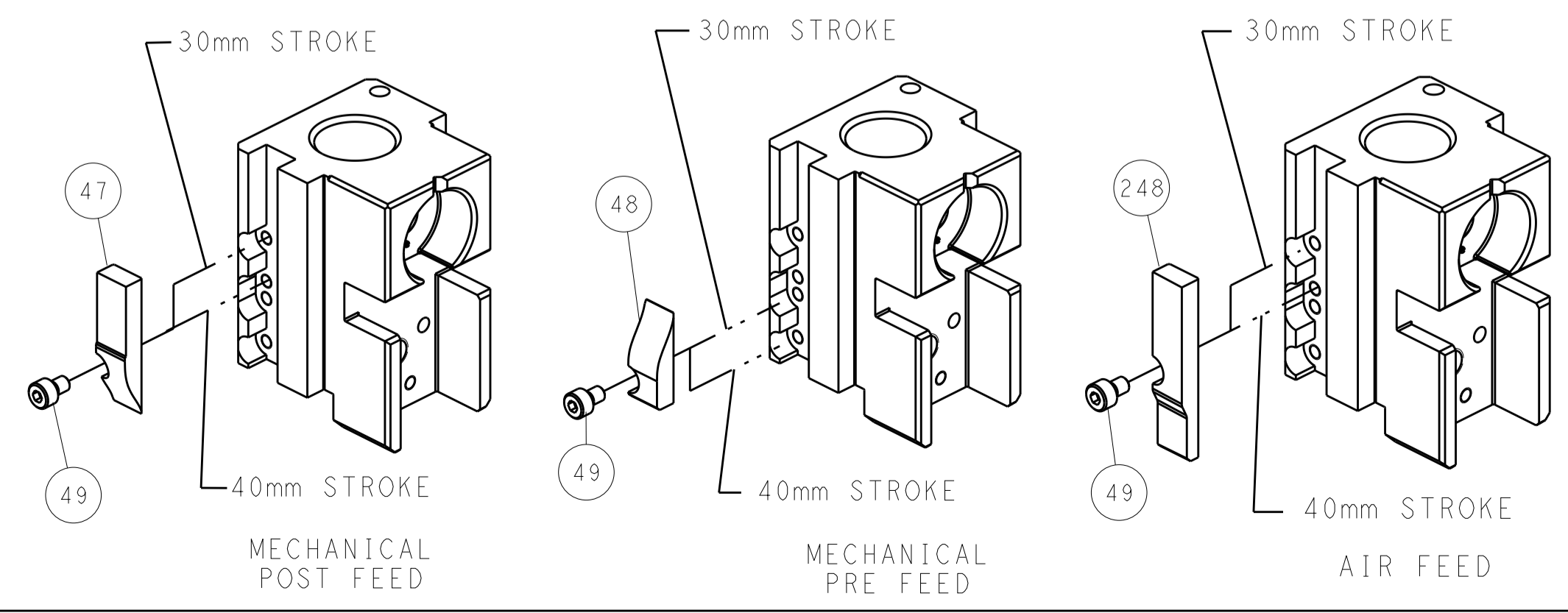
### PNEUMATIC



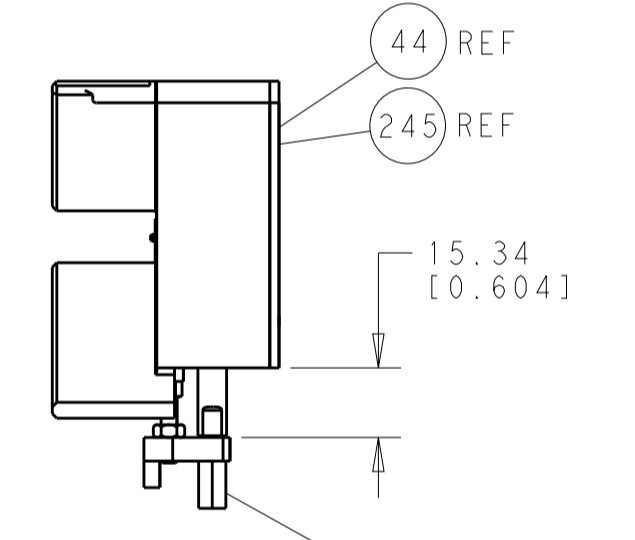
### SERVO LATCH PLATE



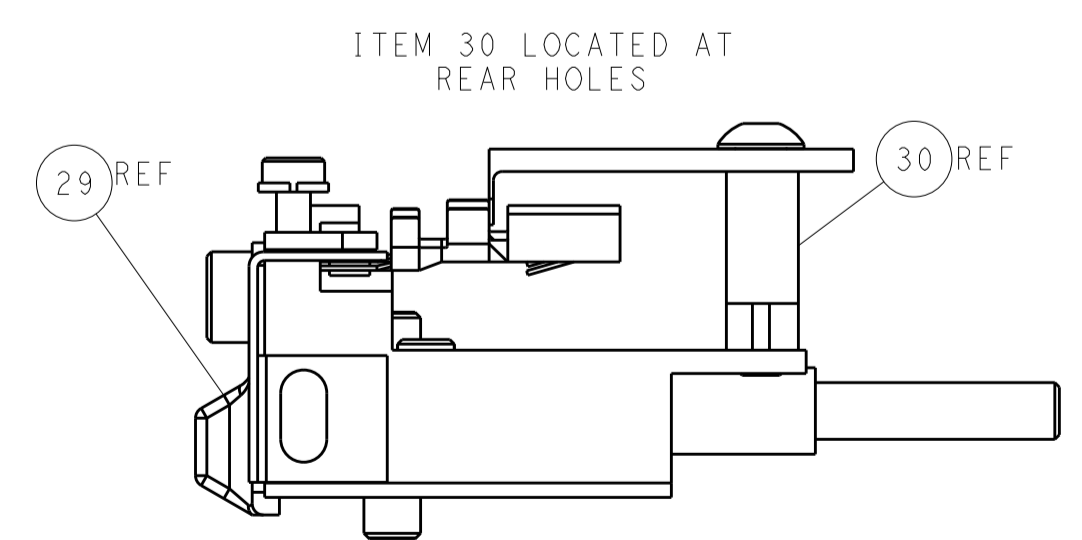
### CAM POSITIONS



TERMINAL SUPPORT LOCATION



HOLDDOWN SET-UP



FEED TRACK POSITION GUIDE BY WIRE BARREL

**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 G. HOFFNER 18DEC2012		TE Connectivity	
mm	0 PLC ±0.1	1 PLC ±0.1	2 PLC ±0.02	3 PLC ±0.005	4 PLC ±0.0005	APVD T. ELBIN 19DEC2012	Harrisburg, PA 17105-3608
MATERIAL:		FINISH:		NAME Ocean Side Feed Applicator		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					
	2-2151850-1	A	FINE CRIMP HEIGHT ADJUST	MECHANICAL	PNEUMATIC FEED	2119950-1	1338685-1	5-18022-5	2119641-2	2119799-1	2063440-1
					SERVO LATCH PLATE	2119951-1	-	8-2151850-5	1901094-3	2-1752354-6	2168400-6 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2151850-4	-	-	-
	2-2151850-2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-2	-	-
					SERVO LATCH PLATE	2119951-1	-	8-2151850-5	1901094-3	2-1752354-6	2168400-6 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2151850-4	-	-	-
	2-2151850-5	A	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE	MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-2	-	-
					PNEUMATIC FEED	2119950-1	1338685-1	5-18022-5	2119641-2	2119799-1	2063440-1
	2-2151850-7	A	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	-
	7-2151850-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-

APPLICATOR DATA		
CRIMP WIRE	SIZE	TYPE
	3.68 mm [1.45]	F
INSUL	4.37 mm [1.72]	F
APPLICATOR INSTRUCTIONS 408-10389		

TERMINAL DATA: DELPHI TERMINAL TE CRIMP SPECIFICATION			
TERMINAL NAME: TERM F M/P 630 P2S			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
4.60-4.60 mm [1.81-.181 IN]		Ø3.40-3.70 mm [1.34-.146 IN]	
TERMINAL APPLICATION SPECIFICATION	DELPHI	-	-
TERMINALS APPLIED			
TE TERMINAL	DELPHI TERMINAL	TE TERMINAL	DELPHI TERMINAL
1572843-1	12176854-1		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
4.00mm2	2.55+/-0.05 [1.00+/-0.02]	6.6
3.00mm2	2.30+/-0.05 [0.91+/-0.02]	8.9

- △ 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:  
 MECHANICAL FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151850-4  
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151850-4  
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151850-5
- 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, 180 & 242.
- △ GREASE THREADS, GROOVE AND O-RING ON ITEMS 139 & 152.
- △ MAGNET 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.
- △ TO CONVERT THE APPLICATOR TO A NON-CARRIER CUTTING STYLE, REMOVE ITEM 13 AND ATTACH TO THE LOCATION ON BACK SIDE OF THE HOUSING. REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.

\*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	1803078-3	SPACER, PRECISION	259
-	1	1	1	1	2119782-1	FINE ADJUST HEAD ASM, PACIFIC STYLE	251
-	-	-	-	-	2119640-1	PUSH ROD, AIR FEED	250
-	-	-	-	-	2079988-1	BUSHING, LCH5-12, MISUMI	249
-	1	1	1	1	1-22279-3	SPRING, COMPRESSION	246
-	1	1	1	1	2119082-8	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			
2119599-1	A	66	P	L	M	A
			DESCRIPTION	DATE	OWN	APVD
			SEE SHEET 1			

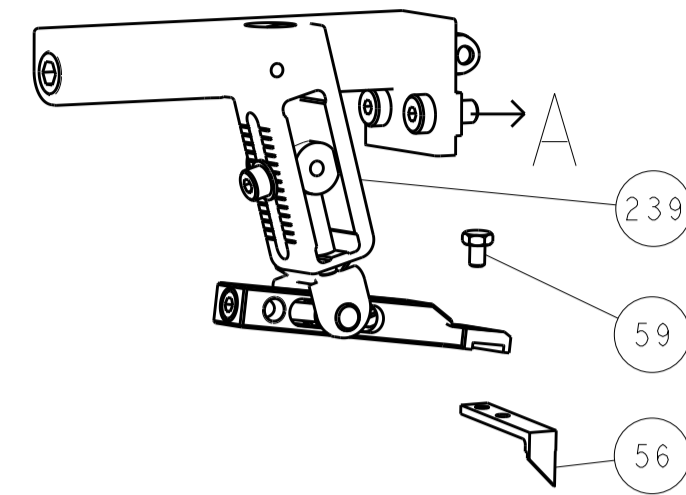
△	-	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242	
-	1	1	1	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241	
-	-	-	-	-	-	2168400-6	SHCS, LOW HEAD, RoHS, M5 X 16	240	
-	-	-	-	-	-	2119580-1	MECHANICAL FEED ASSEMBLY	239	
-	-	-	-	-	-	2063440-1	AIR FEED MODULE	238	
-	-	-	-	-	-	2119740-2	TAG, IDENTIFICATION	213	
-	-	-	-	-	-	1901094-3	SPACER, FEEDER	198	
-	1	1	1	1	1	2-1752354-6	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	
-	-	-	-	-	-	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	
-	-	-	-	-	-	240638-1	SPRING, FEED FINGER	163	
-	1	1	1	1	1	8-21084-1	O-RING, .801 ID, .070 DIA. MAT.	152	
-	-	-	-	-	-	2119641-2	FEED CAM, AIR FEED	151	
-	1	1	1	1	1	2119798-2	DETENT PIN	145	
-	1	1	1	1	1	2079383-8	SCR, BHSC, RoHS (M4 X 16)	144	
-	4	4	4	4	4	2168400-5	SHCS, LOW HEAD, RoHS, M4 X 20	143	
-	-	-	-	-	-	2119653-2	FEED CAM, POST FEED	142	
-	1	1	1	1	1	1-2119656-0	APPLICATOR BASIC ASSEMBLY, SF	141	
-	1	1	1	1	1	2161312-1	RAM, STEPPED, ASIAN STYLE, SIDE FEED	140	
-	1	1	1	1	1	2119092-2	BOLT, ADJUSTMENT	139	
-	-	-	-	-	-	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854	137	
-	-	-	-	-	-	2119799-1	HOLDER, FEED FINGER, AF	136	
-	-	REF	-	-	-	-	SEE NOTE 4	MEMORY CHIP, PROGRAMMED	135
-	-	-	-	-	-	1633743-1	SERVO FEED LATCH ASM	133	
-	-	REF	-	-	-	2119944-1	FEED FINGER ASSEMBLY, SF	117	
-	1	1	1	1	1	318563-1	GUARD, FRONT CHIP	89	
-	1	1	1	1	1	455888-6	SPACER, CRIMPER	82	
-	1	1	1	1	1	455888-3	SPACER, CRIMPER	81	
-	1	1	1	1	1	2119956-1	DOCUMENTATION PACKAGE	71	
-	1	1	1	1	1	2119791-5	DEPRESSOR, WIRE	70	
-	1	1	1	1	1	2119943-1	WASHER, SPACER	69	
-	1	-	-	-	-	2119740-1	TAG, IDENTIFICATION	67	
-	2	2	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS	66	
-	1	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	
-	-	-	-	-	-	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59	
-	-	-	-	-	-	1338685-1	PAWL, FEED	56	
-	1	1	1	1	1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52	
-	1	1	1	1	1	1901681-1	HOLDDOWN, TERMINAL	51	
-	-	-	-	-	-	18023-9	SCR, SKT HD CAP M4 X 6.0	49	
-	-	-	-	-	-	2119652-1	FEED CAM, PRE FEED	48	
-	1	1	1	1	1	1-2079383-5	SCR, BHSC, RoHS (M8 X 40)	41	
-	1	1	1	1	1	2119645-1	DISC, NUMBERED FA WIRE ADJUSTMENT	40	
-	1	1	1	1	1	2119957-1	APPLICATOR SHIM PACK	39	
-	1	1	1	1	1	2119644-3	RAM WASHER, PRECISION	38	
-	1	1	1	1	1	1752356-1	SUPPORT, TERMINAL	34	
-	2	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33	
-	1	1	1	1	1	2161328-1	HEX HEAD, FLANGED, M5 X 8mm LONG	32	
-	1	1	1	1	1	1320908-7	SPACER, STRIP GUIDE	30	
-	1	1	1	1	1	2119959-1	ASSEMBLY, STRIP GUIDE	29	
-	1	1	1	1	1	1-455888-0	SPACER, CRIMPER	28	
-	1	1	1	1	1	1320928-2	STRIP GUIDE	24	
-	1	1	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21	
-	1	1	1	1	1	1-18028-2	WASHER, FLAT, REG M4	20	
-	1	1	1	1	1	2119533-3	STRIPPER, SIDE FEED	19	
△	-	1	1	1	1	2119806-1	INSERT, SHEAR	13	
-	1	1	1	1	1	3-22280-3	SPRING, COMPRESSION	12	
-	1	1	1	1	1	1-356885-4	STOP, SHEAR	11	
△	-	1	1	1	1	2119805-1	SHEAR HOLDER, FRONT	10	
△	-	1	1	1	1	318707-1	FLOATING SHEAR, FRONT	9	
△	1	1	1	1	1	3-1633927-0	ANVIL, COMBINATION	8	
-	-	-	-	-	-	-	-	7	
-	-	-	-	-	-	-	-	6	
-	1	1	1	1	1	2119757-9	DEPRESSOR, SHEAR	5	
-	1	1	1	1	1	238011-4	BLOCK, CRIMPER SPACER	4	
△	1	1	1	1	1	6-2119582-5	CRIMPER, INSULATION F PREMIUM	3	
△	-	1	1	1	1	1-455888-1	SPACER, CRIMPER	2	
△	1	1	1	1	1	2-1633609-4	CRIMPER, WIRE	1	
-77	-27	-25	-22	-21	PART NO	DESCRIPTION	ITEM NO		

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DRAWN		CHK		APVD		NAME	
mm	0 PLC ±0.1	1 PLC ±0.1	2 PLC ±0.2	3 PLC ±0.005	4 PLC ±0.0005	18DEC2012	19DEC2012	19DEC2012	19DEC2012	TE Connectivity Harrisburg, PA 17105-3608	
		FINISH		PRODUCT SPEC		APPLICATOR SPEC		SIZE		CAGE CODE DRAWING NO	
MATERIAL		FINISH		WEIGHT		SCALE		SHEET		REV	
						A1 00779 ©=2151850		3 of 4		A	

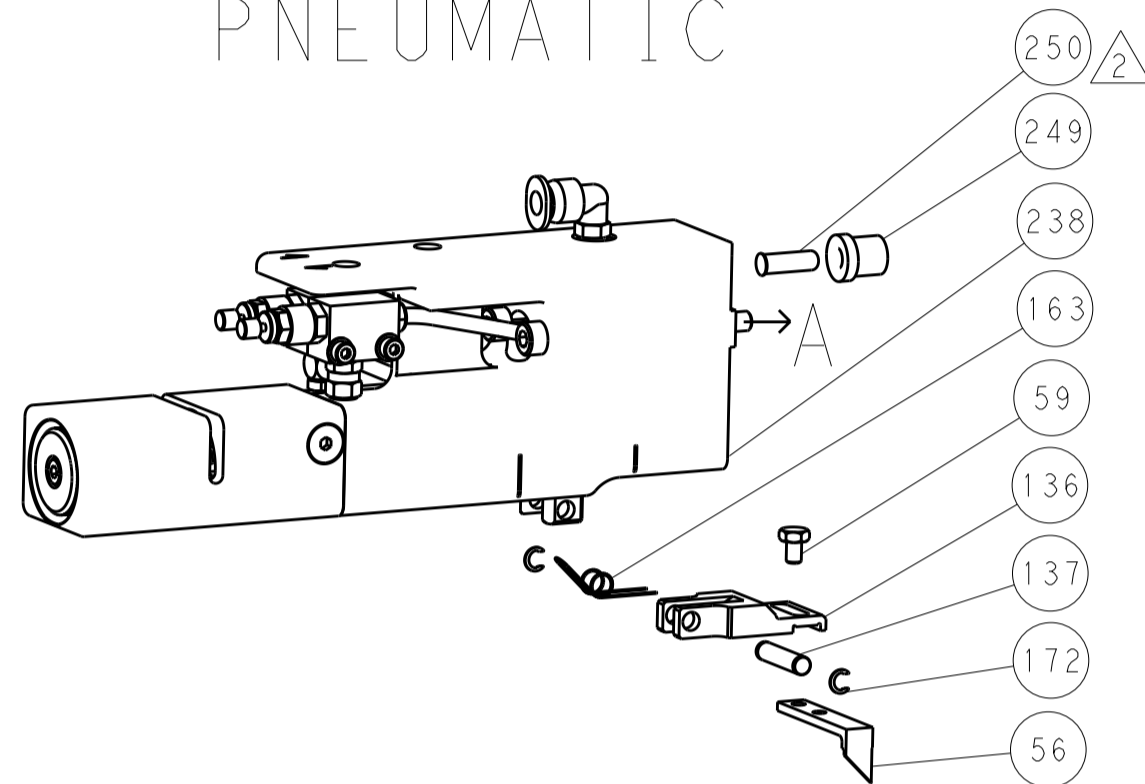
LOC		DIST		REVISIONS			
A	66	P	LTM	DESCRIPTION	DATE	OWN	APVD
		-		SEE SHEET 1			

DIMENSIONING AND TOLERANCING PER ASME Y14.5M-2003

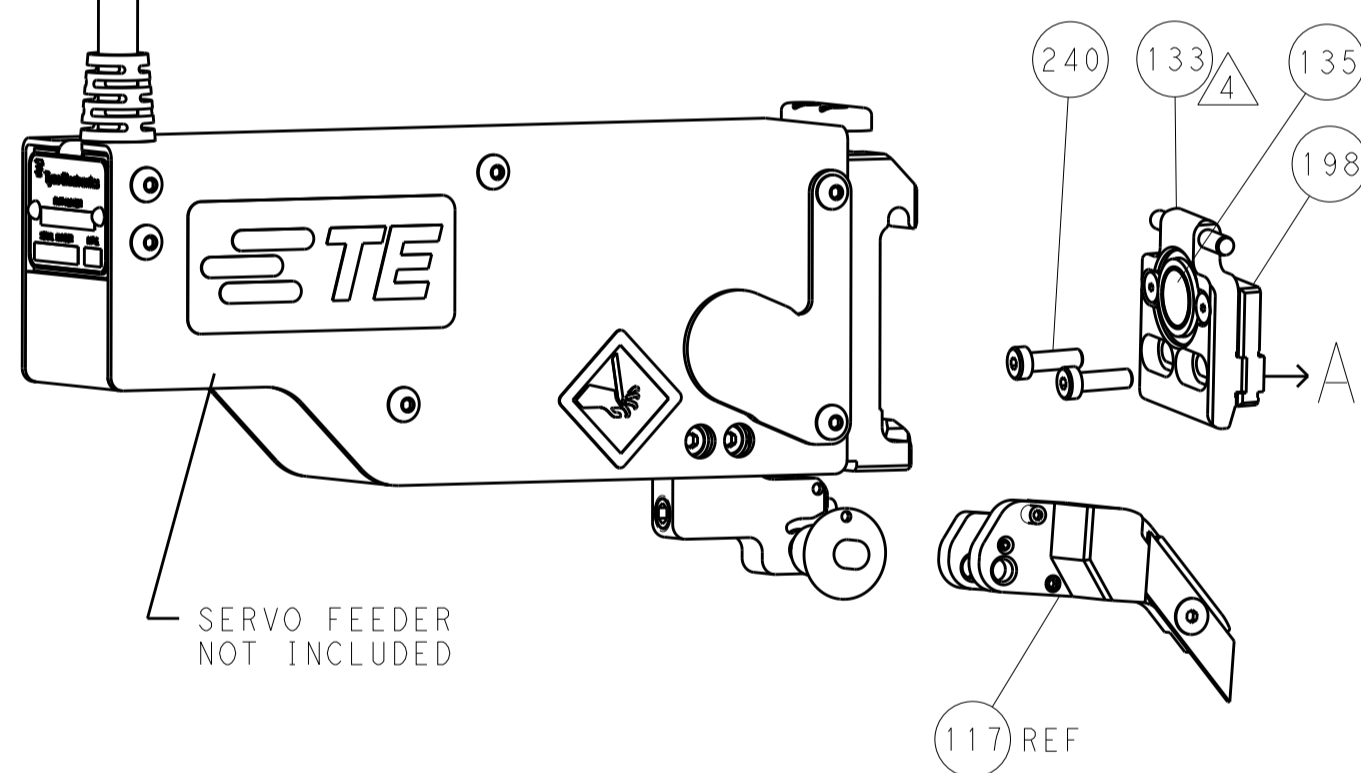
### FEED TYPE MECHANICAL



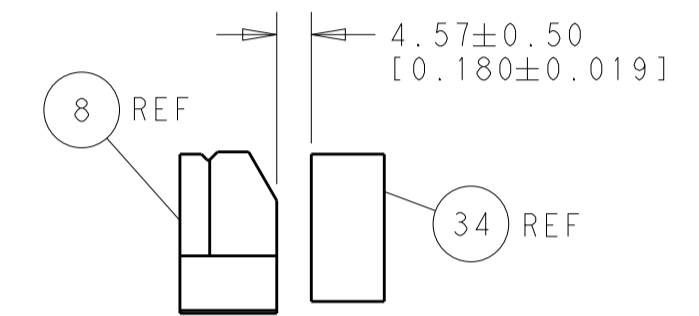
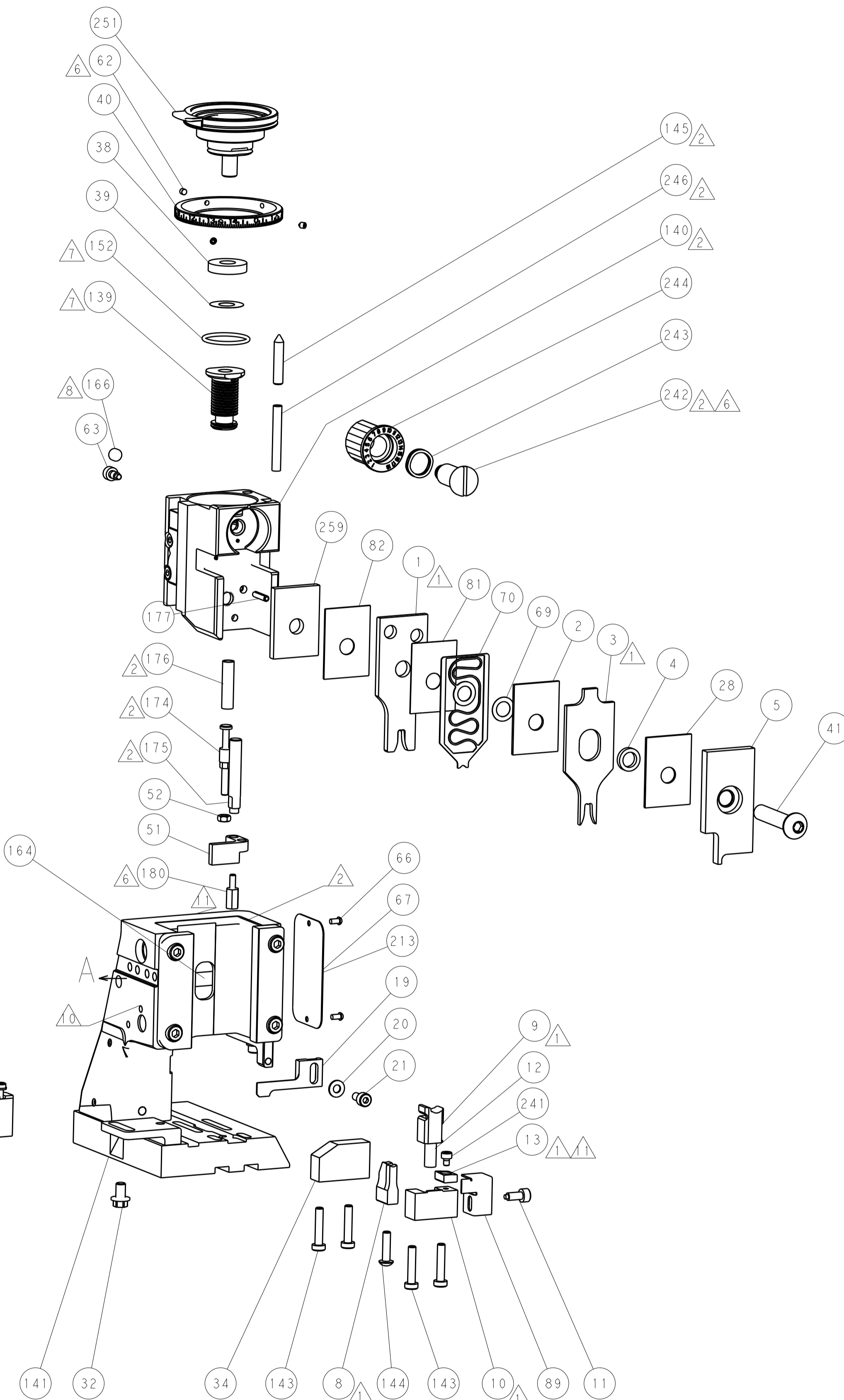
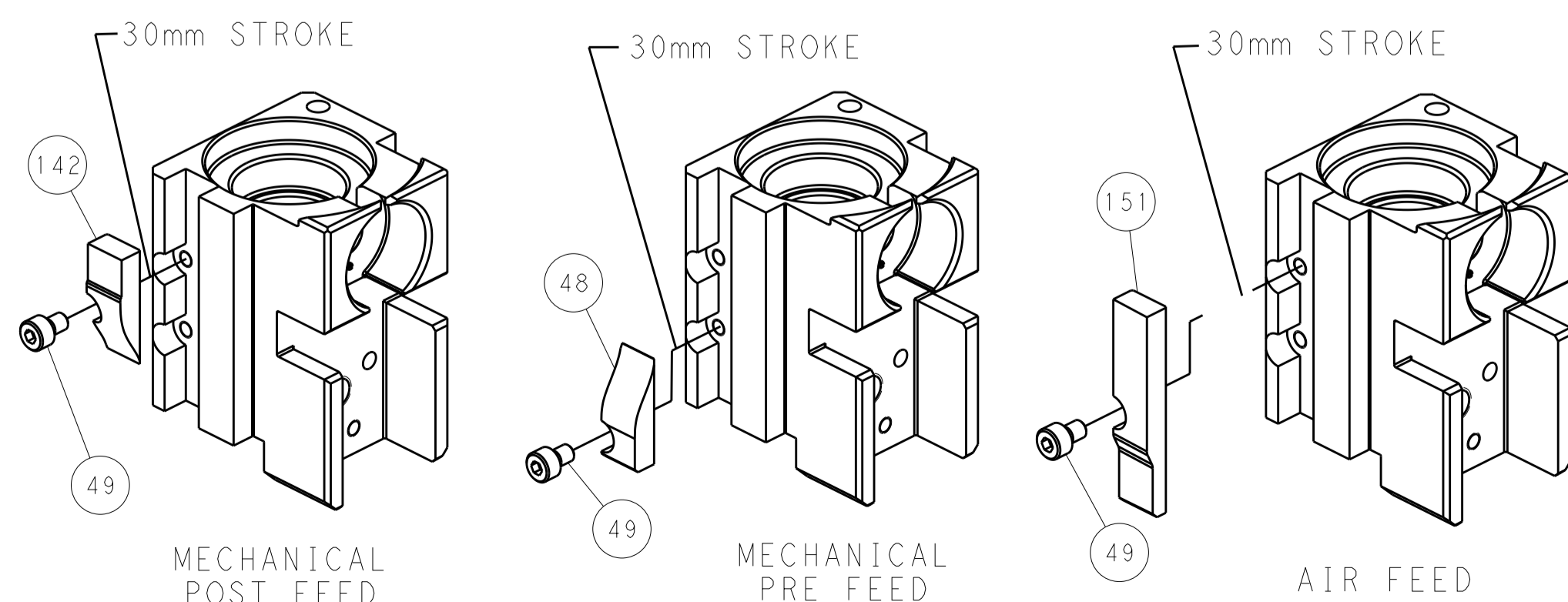
### PNEUMATIC



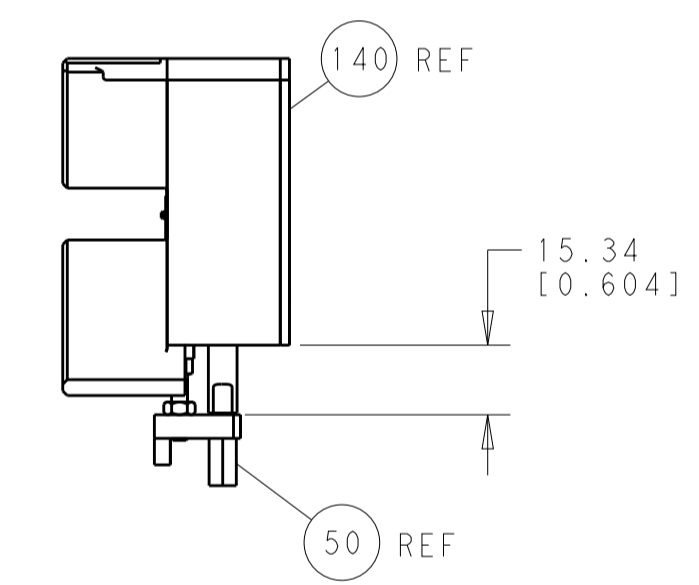
### SERVO LATCH PLATE



### CAM POSITIONS

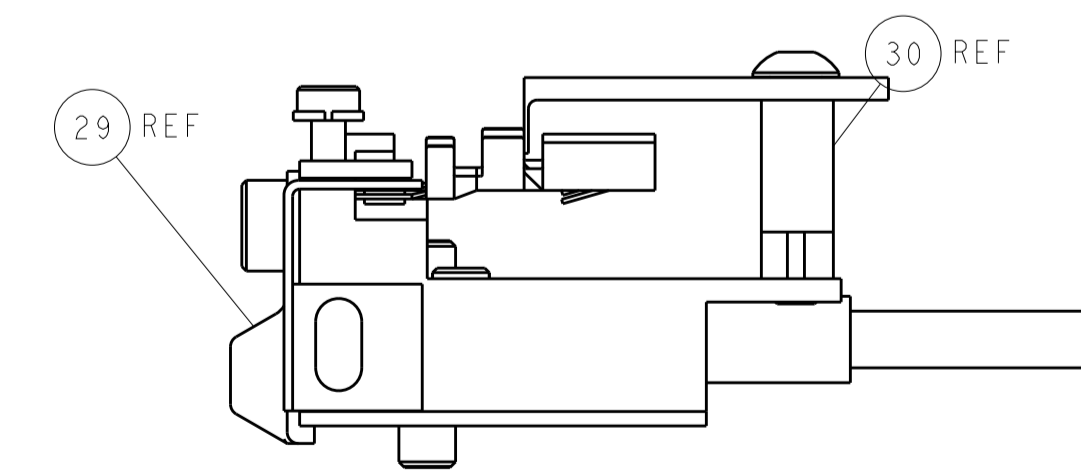


TERMINAL SUPPORT LOCATION



HOLDDOWN SET-UP

ITEM 30 LOCATED AT REAR HOLES



FEED TRACK POSITION GUIDE BY WIRE BARREL

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

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DIMENSIONS: mm 	TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.1 1 PLC ±0.1 2 PLC ±0.02 3 PLC ±0.005 4 PLC ±0.0005 ANGLES ±.1	PRODUCT SPEC: APPLICATION SPEC: WEIGHT:	SIZE: CAGE CODE: DRAWING NO: A1 00779 C=2151850
MATERIAL:	FINISH:	RESTRICTED TO:	SCALE: 1:1 SHEET 4 OF 4 REV A