

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART						
					CONVERT TO	PART NUMBERS REQUIRED					
	2150535-1	A	FINE CRIMP HEIGHT ADJUST	MECHANICAL	PNEUMATIC FEED	2119950-1	2119792-2	-	2119641-1	-	2063440-1
					SERVO LATCH PLATE	2119951-1	1901697-1	8-2150535-5	-	-	2168400-7 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2150535-4	-	-	-
	2150535-2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	MECHANICAL FEED	2119949-1	2063961-1	5-18022-5	2119653-1	-	-
					SERVO LATCH PLATE	2119951-1	1901697-1	8-2150535-5	-	-	2168400-7 (QUANTITY 2)
	2150535-5	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
2150535-6	A	NON-CRIMP HEIGHT ADJUST	SERVO LATCH PLATE	-	-	-	-	-	-	-	
2150535-7	A	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	-	
7-2150535-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-	

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.78 mm [.070]	F
INSUL	3.94 mm [.155]	O
APPL INSTRUCTIONS 408-10390		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: PIN RECEPTACLE, .093 DIA			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
3.56-4.32 mm [.140-.170 IN]		Ø2.29-3.30 mm [.090-.130 IN]	
TERMINAL APPLICATION SPECIFICATION	114-2080	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
1742350-1	41854	41854-1	41870

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
18 AWG	1.37+/-0.05 [.054+/- .002]	7.8
20 AWG	1.24+/-0.05 [.049+/- .002]	9.2
22 AWG	1.17+/-0.05 [.046+/- .002]	10.0

- 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: 8-2150535-4
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150535-4
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150535-5
 SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2150535-6
- 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	2119082-6	CAM, SNAIL, INSULATION ADJUSTMENT	244
-77	-7	-6	-5	-2	-1	PART NO	DESCRIPTION	ITEM NO

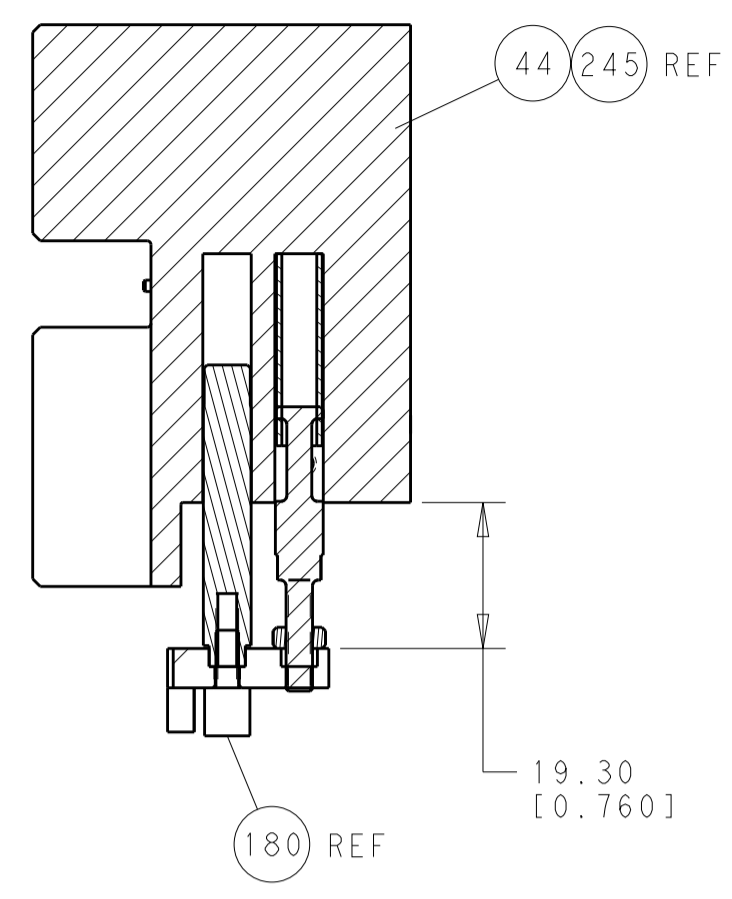
ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

SET UP GAUGE	LOC	DIST	REVISIONS			
2119599-2	A	66	REV	DATE	BY	APPD
			A	RELEASED	23MAR2015	KH

-	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	2119955-2	ASSY, LUBRICATOR, END FEED	84
-	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	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	1-1901681-8	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	2063961-1	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	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	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	29
-	1	1	1	1	1	240639-3	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	240825-2	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	7-1803001-3	ANVIL, COMBINATION, END FEED	8
-	1	1	1	1	1	2217206-4	BLADE, SLUG	7
-	-	-	-	-	-	-	-	6
-	1	1	1	1	1	240641-9	SPACER	5
-	1	1	1	1	1	238009-1	BLOCK, FL CRIMPER SPACER	4
-	1	1	1	1	1	3-1633965-7	CRIMPER, INSULATION O PREMIUM	3
-	1	1	1	1	1	455888-2	SPACER, CRIMPER	2
-	1	1	1	1	1	1-456404-1	CRIMPER, WIRE PREMIUM	1
-77	-7	-6	-5	-2	-1	PART NO	DESCRIPTION	ITEM NO

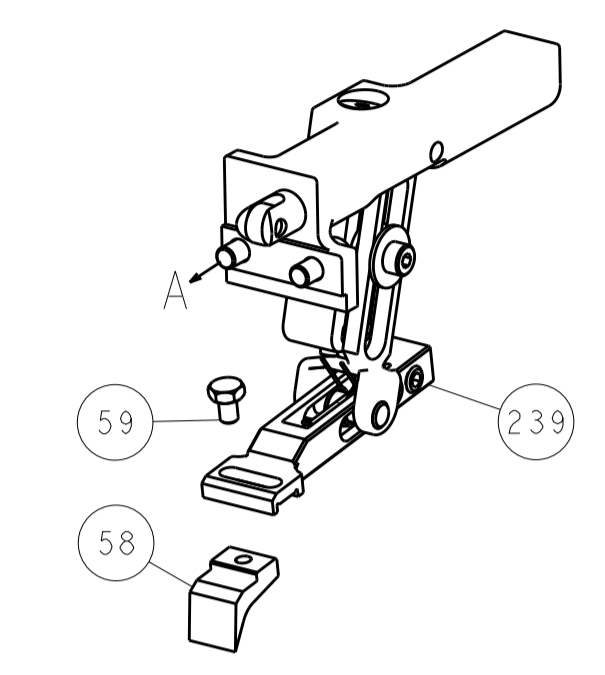
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG		REV	
mm	0 PLC ±.5	1 PLC ±.3	2 PLC ±.2	3 PLC ±.15	4 PLC ±.1	5 PLC ±.05	6 PLC ±.02
	ANGLES ±.0001						
MATERIAL:	FINISH:	WEIGHT:	SCALE:	DATE:	BY:	APPD:	REV:
			1:1	05MAR2015	H. HUANG	L. ZHANG	
Customer Accessible Production Drawing				SHEET 1 OF 4			

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

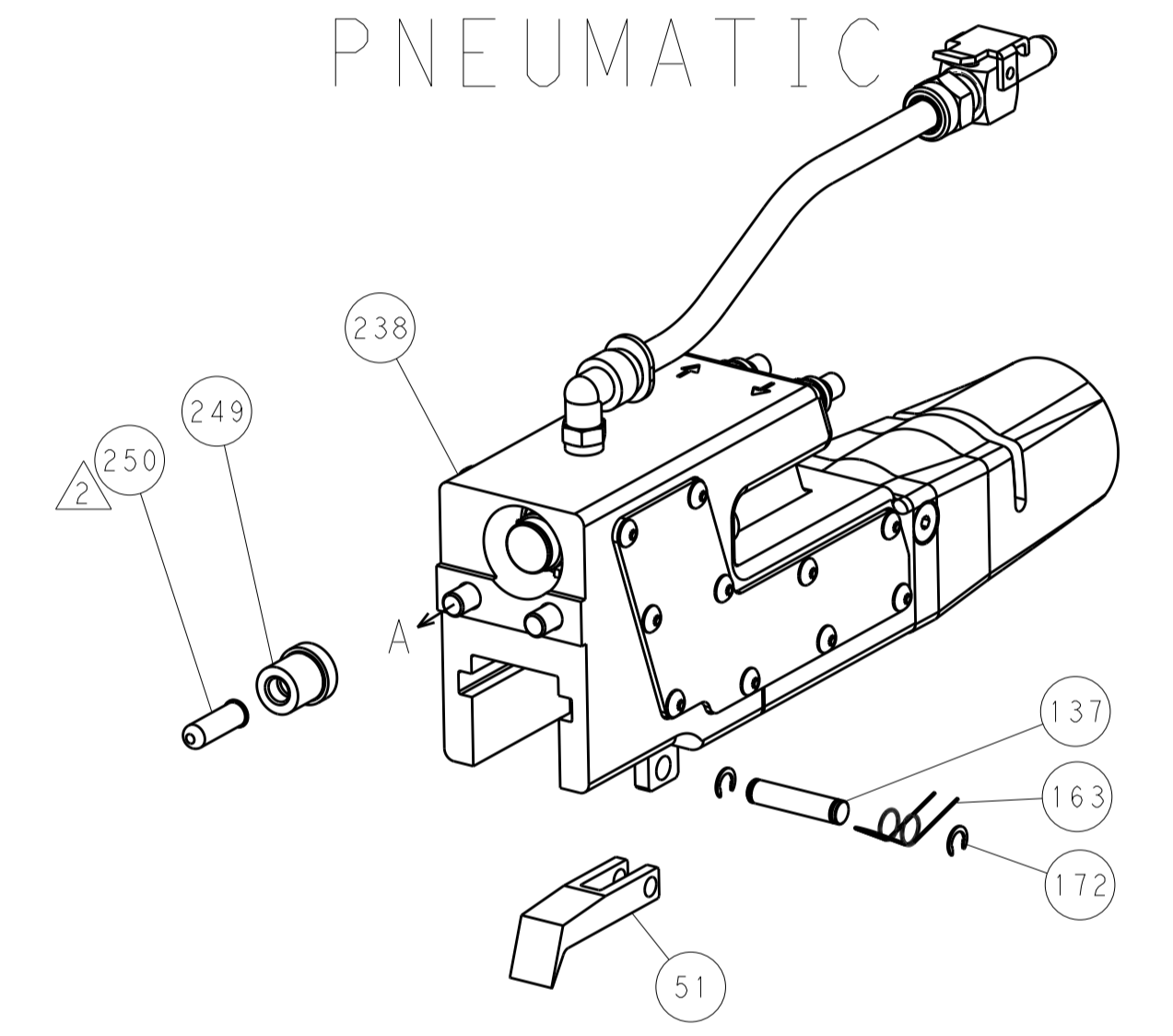


HOLDDOWN SET-UP

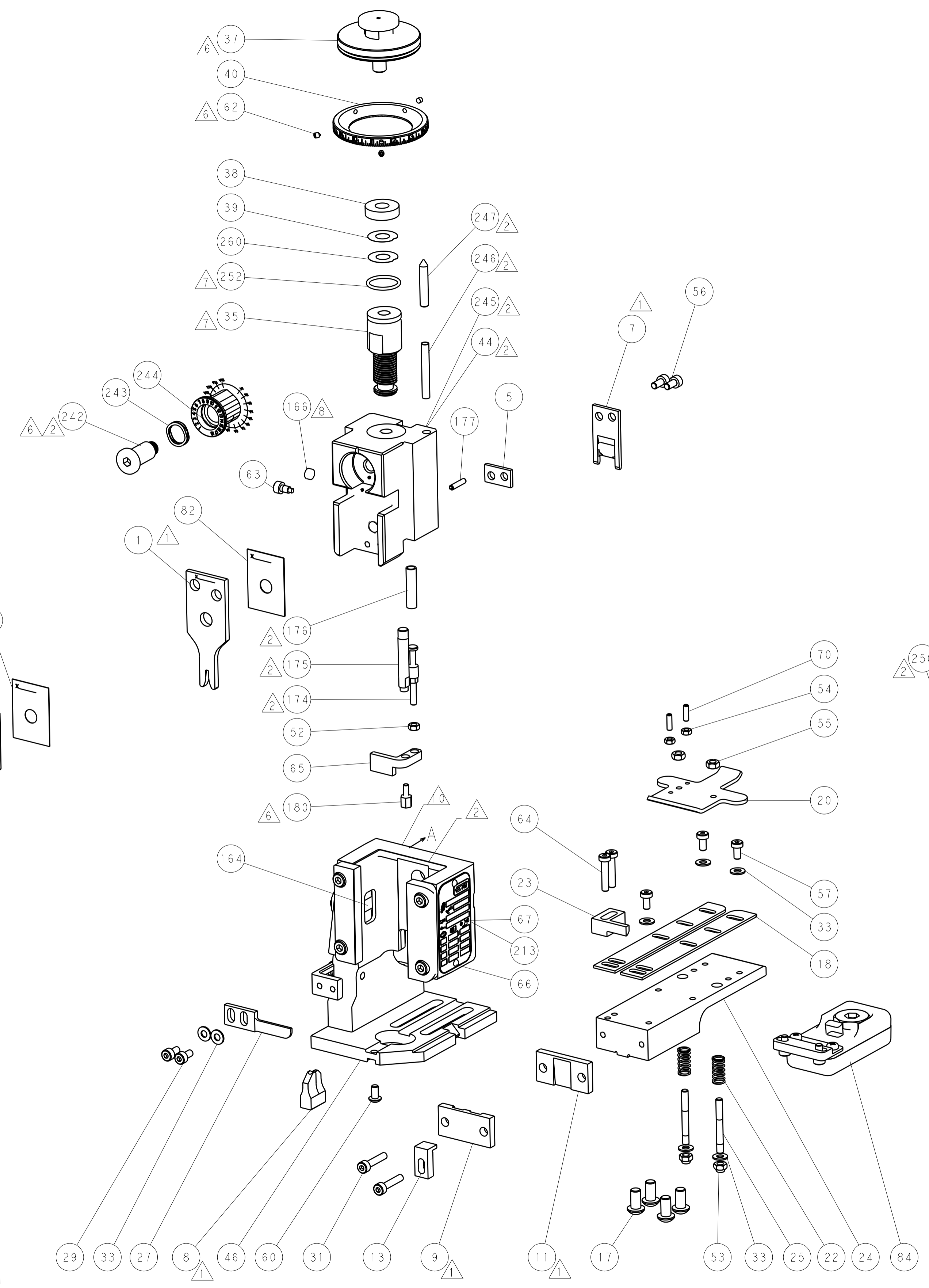
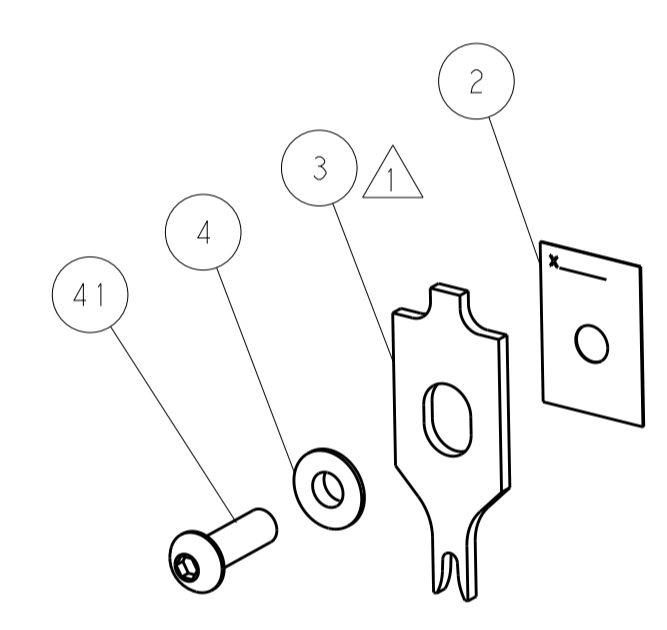
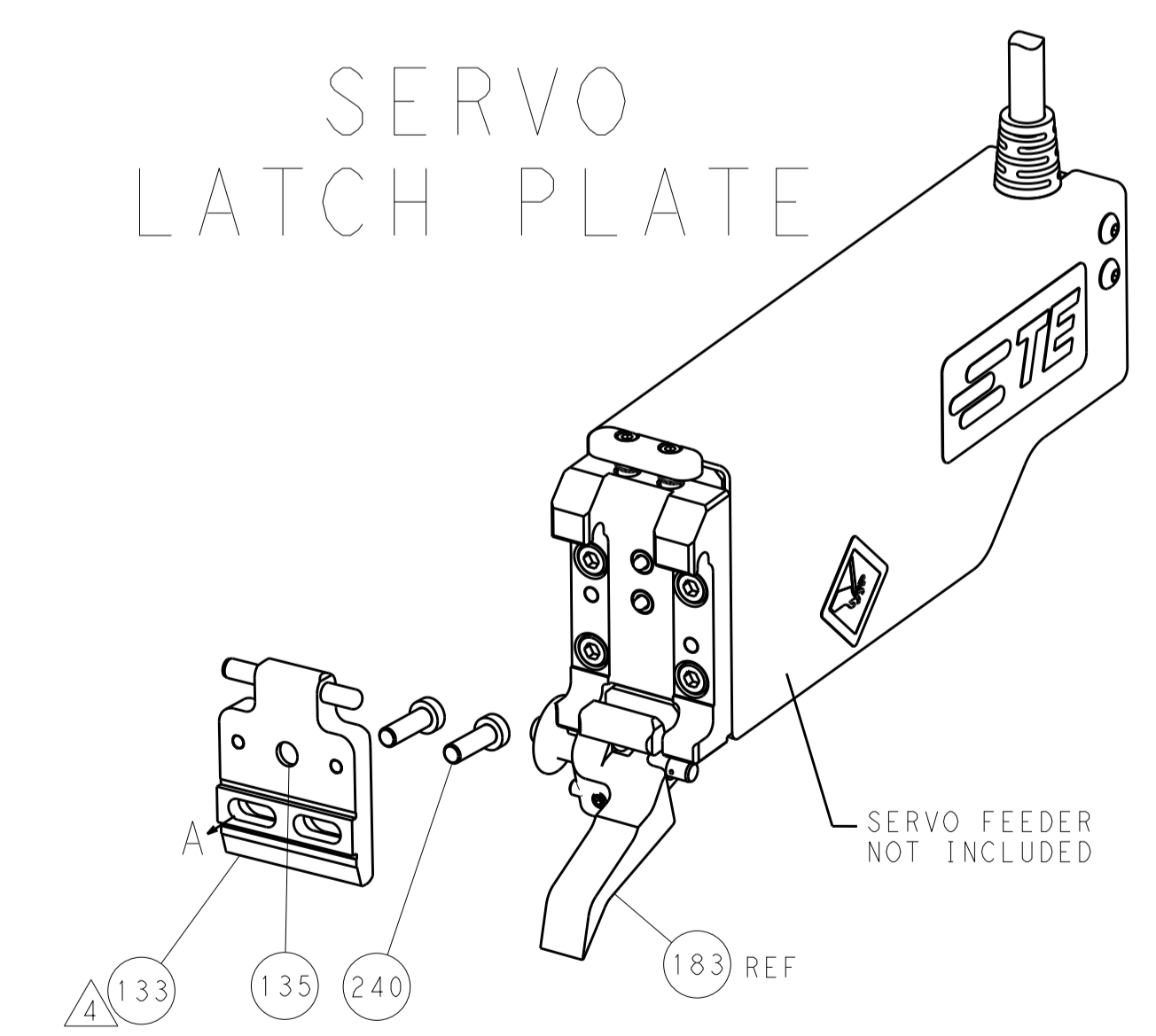
FEED TYPE
MECHANICAL



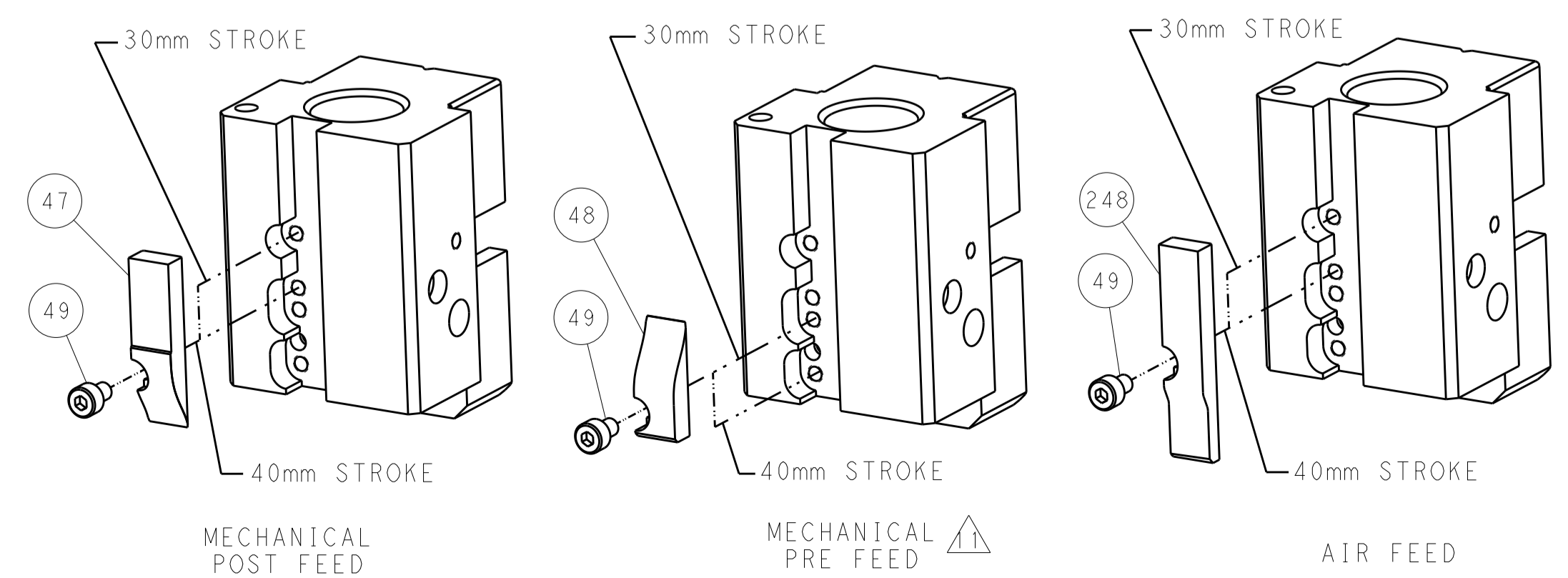
PNEUMATIC



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:		OWN: H. HUANG 05MAR2015		TE Connectivity	
mm	0 PLC ±0.5	1 PLC ±0.5	2 PLC ±0.13	3 PLC ±0.013	4 PLC ±0.001	APVD: L. ZHANG 05MAR2015	Harrisburg, PA 17105-3608
MATERIAL:		FINISH:		NAME: Ocean End Feed Applicator		RESTRICTED TO:	
				SIZE: A1 00779 C=2150535		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					
	2-2150535-1	A	FINE CRIMP HEIGHT ADJUST	MECHANICAL	PNEUMATIC FEED	2119950-1	2119792-2	-	2119641-2	-	2063440-1
					SERVO LATCH PLATE	2119951-1	1901697-1	8-2150535-5	-	-	2168400-7 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2150535-4	-	-	-
	2-2150535-2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	MECHANICAL FEED	2119949-1	2063961-1	5-18022-5	2119653-2	-	-
					SERVO LATCH PLATE	2119951-1	1901697-1	8-2150535-5	-	-	2168400-7 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2150535-4	-	-	-
	2-2150535-5	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
	2-2150535-7	A	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	-
	7-2150535-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-

APPLICATOR DATA		
CRIMP SIZE	TYPE	
WIRE 1.78 mm (.070)	F	
INSUL 3.94 mm (.155)	Ø	
APPL INSTRUCTIONS 408-10390		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: PIN RECEPTACLE, .093 DIA			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
3.56-4.32 mm (.140-.170 IN)		Ø2.29-3.30 mm (.090-.130 IN)	
TERMINAL APPLICATION SPECIFICATION	114-2080		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
1742350-1	41854	41854-1	41870

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
18 AWG	1.37+/-0.05 [.054+/-0.002]	7.8
20 AWG	1.24+/-0.05 [.049+/-0.002]	9.2
22 AWG	1.17+/-0.05 [.046+/-0.002]	10.0

- 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: 8-2150535-4
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150535-4
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150535-5
- 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. 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.

QTY	ITEM NO	DESCRIPTION
-	1	2119782-1 FINE ADJUST HEAD ASM, PACIFIC STYLE
-	-	2119640-1 PUSH ROD, AIR FEED
-	-	2079988-1 BUSHING, LCH5-12, MISUMI
-	1	1-22279-3 SPRING, COMPRESSION
-	1	2119082-6 CAM, SNAIL, INSULATION ADJUSTMENT
-	1	2079764-1 WASHER, WAVE SPRING, CREST-TO-CREST
-	1	2119083-1 RETAINER, INSULATION DIAL
-	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)

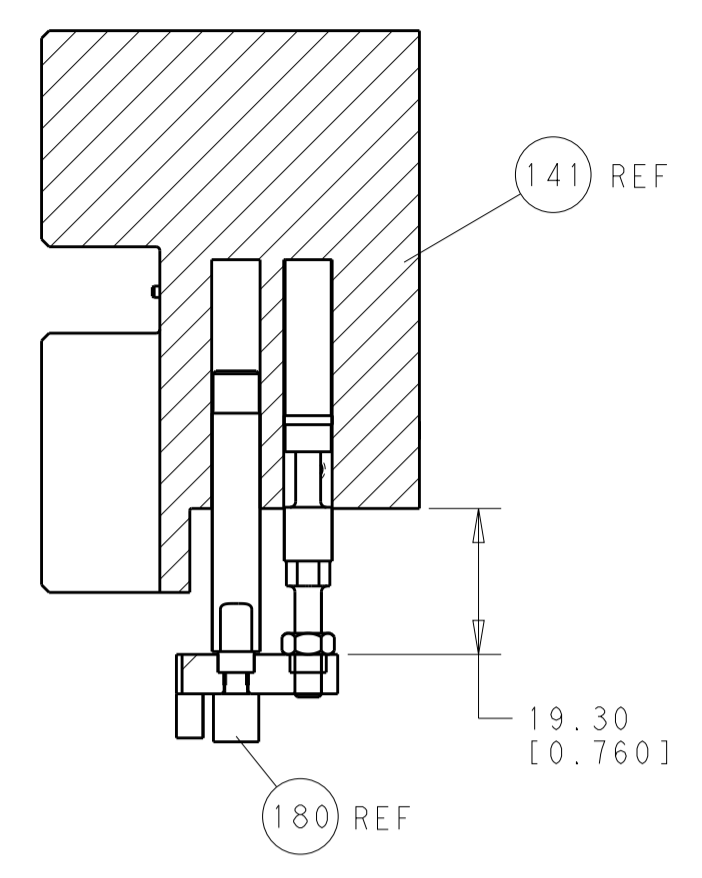
SET UP GAUGE	LOC	DIST	REVISIONS			
2119599-2	A	66	REV	DATE	BY	APPV
			-	SEE SHEET 1	-	-

QTY	ITEM NO	DESCRIPTION	DATE	BY	APPV
-	2	2168400-7 SHCS, LOW HEAD, RoHS, M5 X 10			240
-	-	2119580-1 MECHANICAL FEED ASSEMBLY			239
-	-	2063440-1 AIR FEED MODULE			238
-	1	2119740-2 TAG, IDENTIFICATION			213
-	4	2079383-9 SCR, BHSC, RoHS (M6 X 20)			186
-	4	1901697-1 FEED FINGER ASSEMBLY, EF			183
-	1	1-1752354-0 STANDOFF, HOLD-DOWN			180
-	1	6-993111-6 PIN, SLOTTED SPRING 3.0 X 14.0			177
-	1	8-22280-7 SPRING, COMPRESSION			176
-	1	1752353-2 GUIDE PIN, HOLDDOWN			175
-	1	1901680-2 GUIDE PIN, HOLDDOWN			174
-	-	21045-3 RING, RETAIN, EXTERN, 3/16 CRESCENT			172
-	1	994969-1 MAGNET, RARE EARTH HIGH ENERGY			166
-	REF	994970-2 COUNTER, MAGNETIC			164
-	-	240638-1 SPRING, FEED FINGER			163
-	1	8-21084-1 O-RING, .801 ID, .070 DIA. MAT.			153
-	-	2119641-2 FEED CAM, AIR FEED			152
-	1	2119798-2 DETENT PIN			145
-	1	2079383-8 SCR, BHSC, RoHS (M4 X 16)			144
-	-	2119653-2 FEED CAM, POST FEED			142
-	1	2119655-6 APPLICATOR BASIC ASSEMBLY, EF			141
-	1	2119651-1 RAM, ASIAN STYLE, END FEED			140
-	1	2119092-2 BOLT, ADJUSTMENT			139
-	-	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	2119955-2 ASSY, LUBRICATOR, END FEED			84
-	1	455888-4 SPACER, CRIMPER			82
-	1	2119956-2 DOCUMENTATION PACKAGE			71
-	2	2-18032-2 SCR, SET, FLT POINT M3 X 10.0			70
-	1	2119740-1 TAG, IDENTIFICATION			67
-	2	2168078-1 SCREW, DRIVE, RH, RoHS, 2 x .188			66
-	1	1-1901681-8 HOLDDOWN, TERMINAL			65
-	2	2168400-5 SHCS, LOW HEAD, RoHS, M4 X 20			64
-	1	2119793-1 LIMITER, ADJUSTMENT BOLT			63
-	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
-	-	2063961-1 FEED FINGER			58
-	3	2168400-4 SHCS, LOW HEAD, RoHS, M4 X 8			57
-	2	2168083-2 SCR, SKT HD CAP, RoHS, M4 X 8.0			56
-	2	5018030-2 NUT, HEX, REG, RoHS, M4			55
-	2	5018030-1 NUT, HEX, REG, RoHS, M3			54
-	2	986965-8 NUT, LOCK, HEX, TORQUE (M4)			53
-	1	1-5018030-0 NUT, HEX, REG, RoHS, M3.5			52
-	-	2119792-2 PAWL, EF, AIR			51
-	-	18023-9 SCR, SKT HD CAP M4 X 6.0			49
-	-	2119652-1 FEED CAM, PRE FEED			48
-	1	2079383-7 SCR, BHSC, RoHS (M8 X 25)			41
-	1	2119645-1 DISC, NUMBERED FA WIRE ADJUSTMENT			40
-	1	2119957-1 APPLICATOR SHIM PACK			39
-	1	1-2119644-2 RAM WASHER, PRECISION			38
-	7	1-18028-2 WASHER, FLAT, REG M4			33
-	2	2168083-9 SCR, SKT HD CAP, RoHS, M4 X 20			31
-	2	2168083-2 SCR, SKT HD CAP, RoHS, M4 X 8.0			29
-	1	240639-3 STRIPPER (MACHINING)			27
-	2	1320906-1 STUD, THREADED			25
-	1	1752371-5 PLATE, STRIP GUIDE			24
-	1	240825-2 PLATE, STRIP HOLD DOWN			23
-	2	2-22281-3 SPRING, COMPRESSION			22
-	1	1752373-4 DRAG			20
-	2	1901259-3 GUIDE, LOWER STRIP			18
-	1	1752360-1 SPACER, HOLD-DOWN			13
-	1	240644-1 PLATE, REAR SHEAR			11
-	-	-			10
-	1	690482-6 PLATE, FRONT SHEAR			9
-	1	7-1803001-3 ANVIL, COMBINATION, END FEED			8
-	1	2217206-4 BLADE, SLUG			7
-	-	-			6
-	1	240641-9 SPACER			5
-	1	238009-1 BLOCK, FL CRIMPER SPACER			4
-	1	3-1633965-7 CRIMPER, INSULATION O PREMIUM			3
-	1	455888-2 SPACER, CRIMPER			2
-	1	1-456404-1 CRIMPER, WIRE PREMIUM			1
-	77-27-25-22-21	PART NO DESCRIPTION ITEM NO			

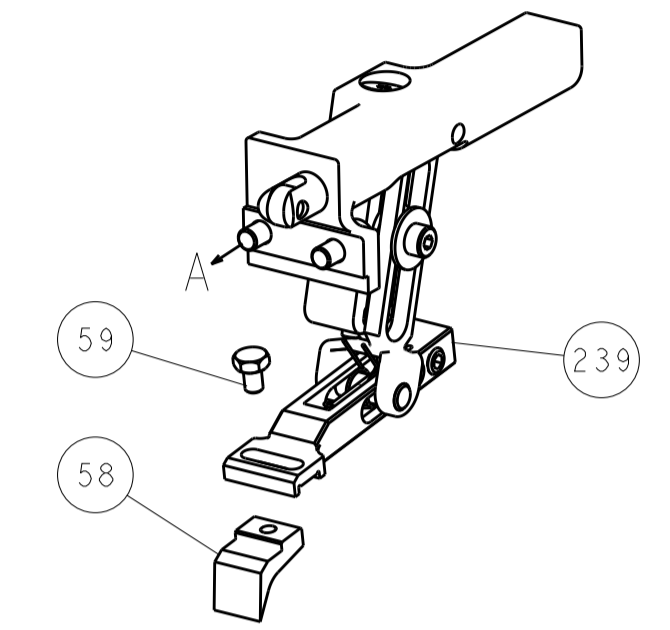
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG		CHK		APVD		NAME	
mm	0 PLC ±.5	1 PLC ±.3	2 PLC ±.13	3 PLC ±.013	4 PLC ±.0001	ANGLES ±.0001	FINISH	H. HUANG	OSMAR2015	L. ZHANG	OSMAR2015
MATERIAL		FINISH		PRODUCT SPEC		APPLICATION SPEC		WEIGHT		SCALE	
								A1		00779 ©=2150535	
Customer Accessible Production Drawing				SCALE 1:1		SHEET 3 OF 4		REV A			

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

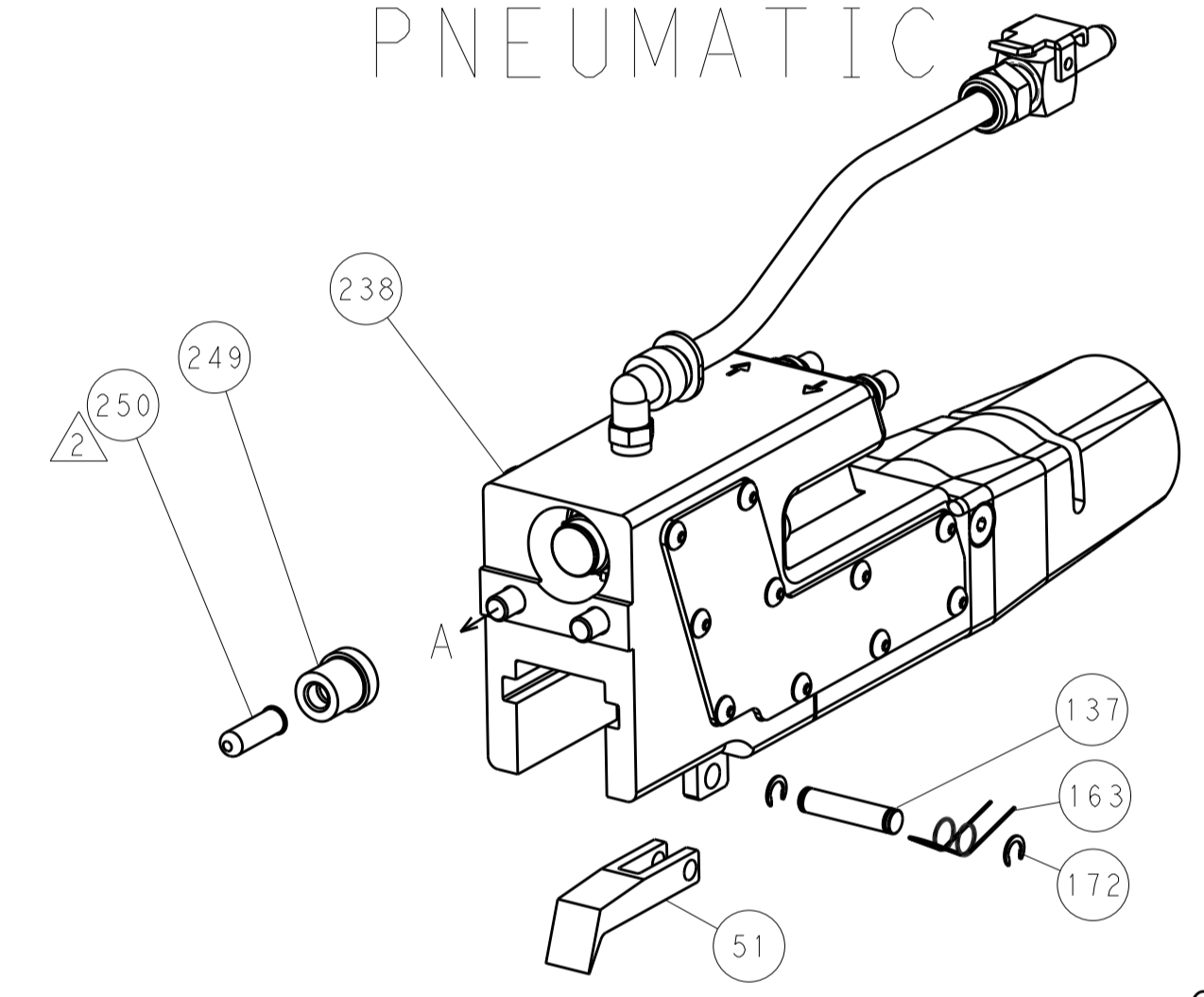
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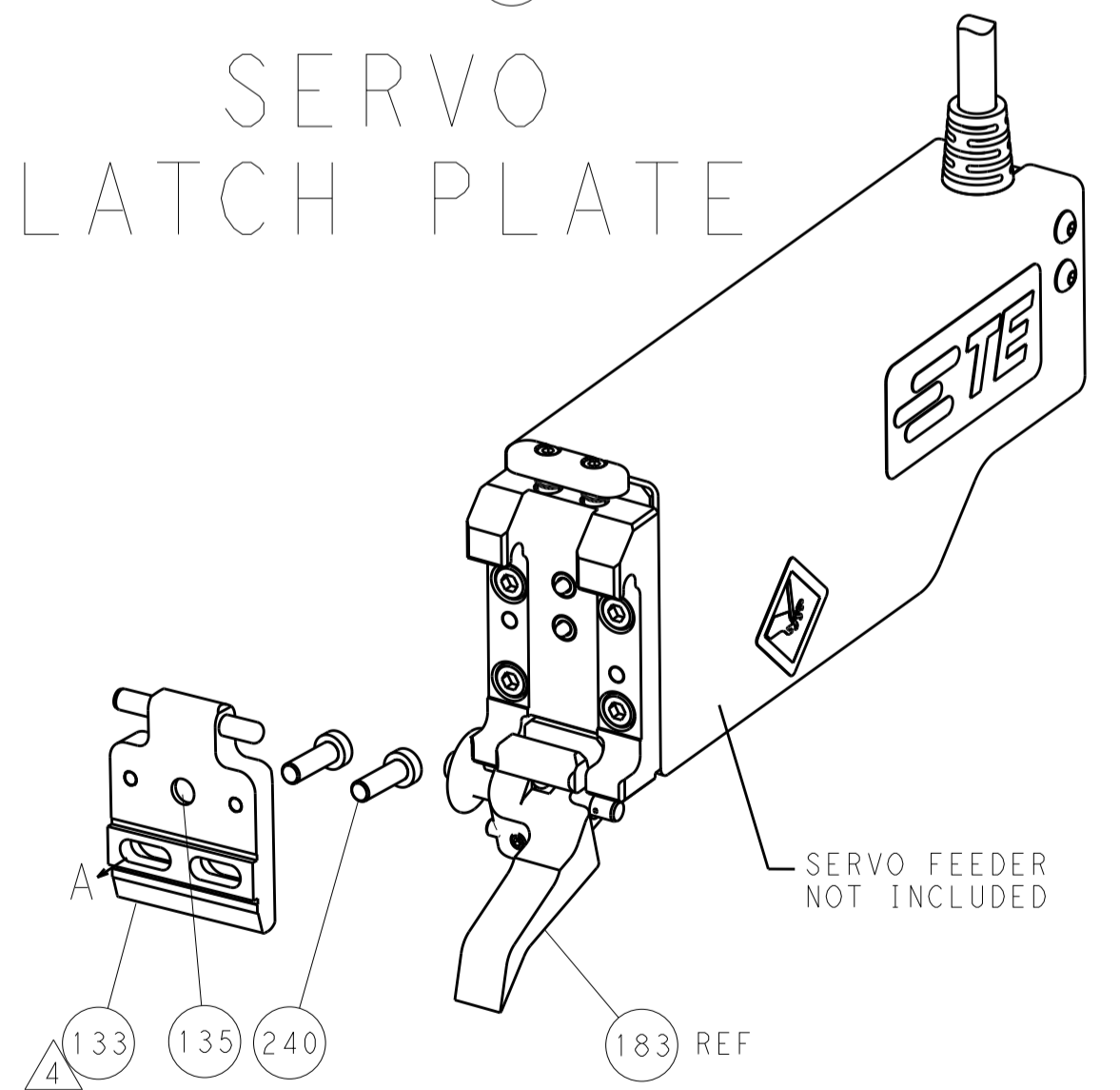
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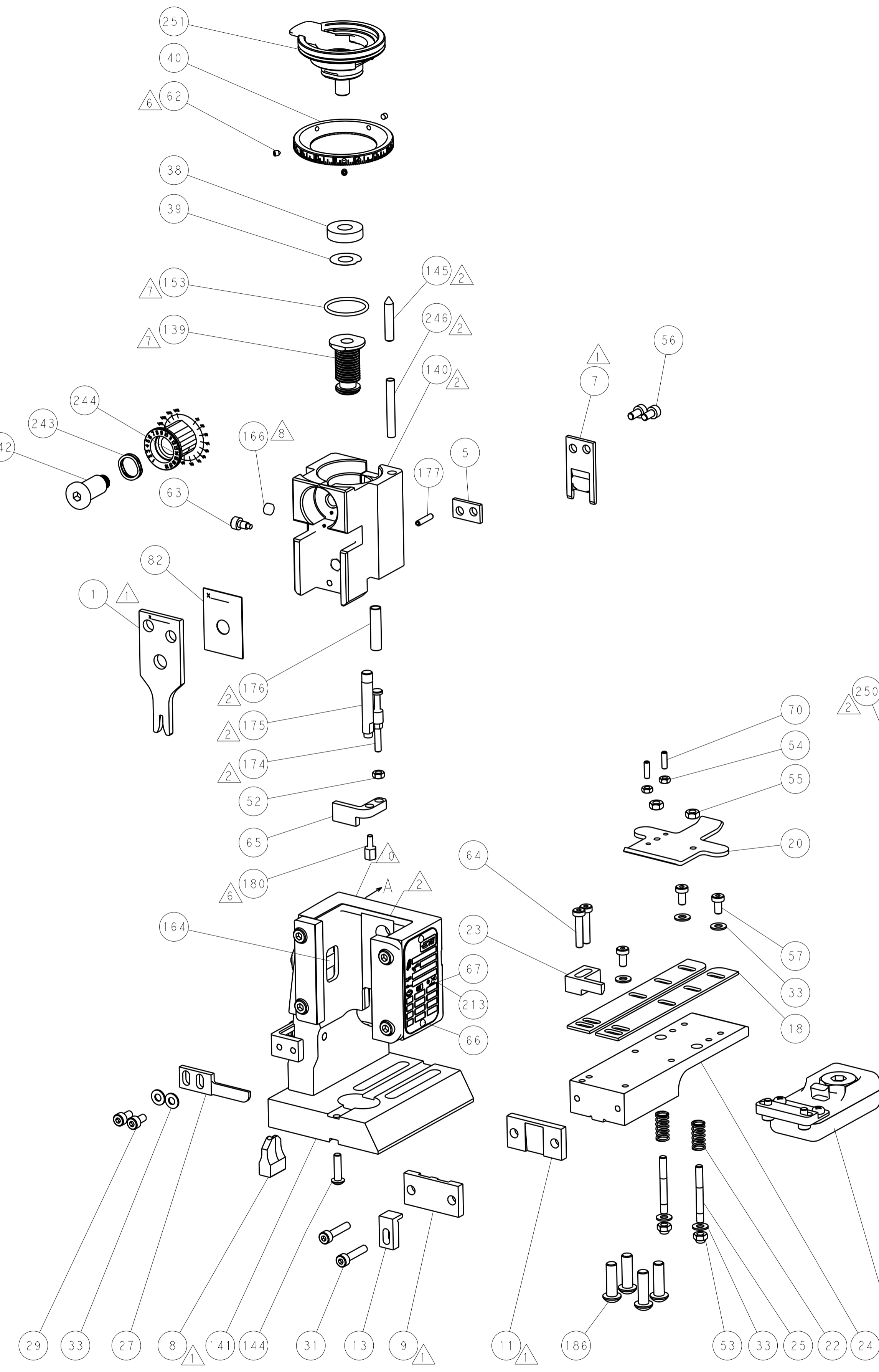
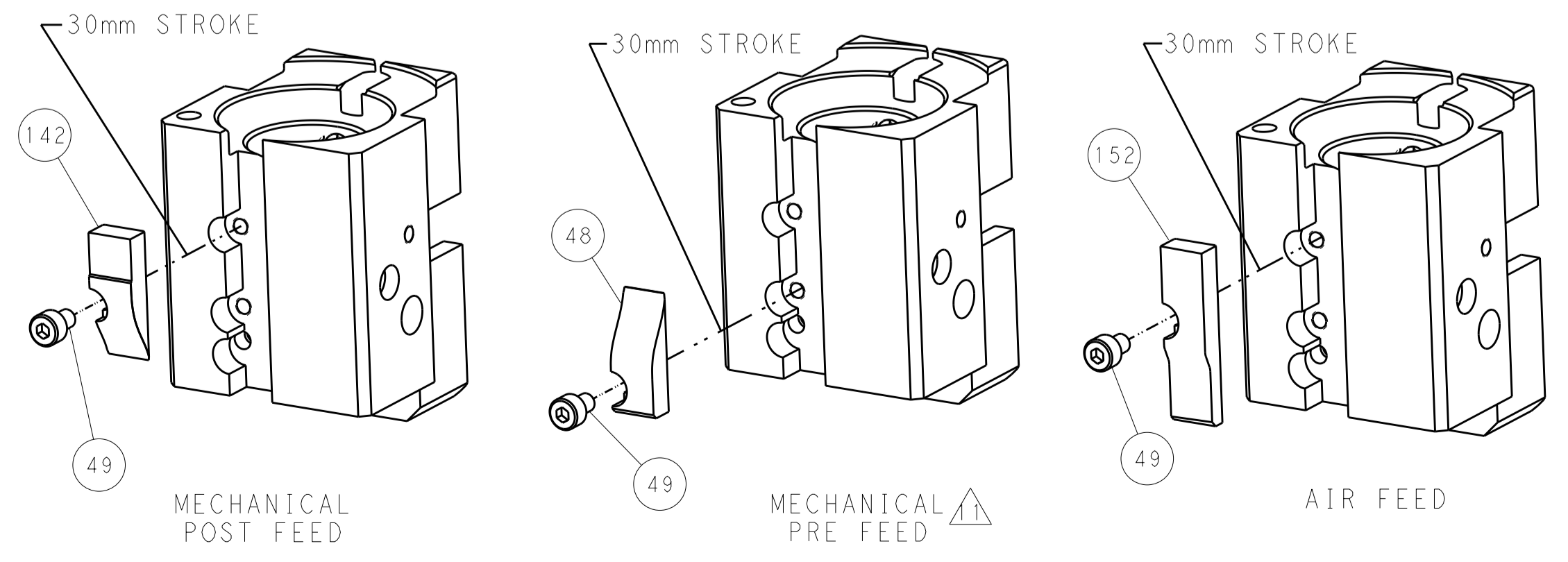
PNEUMATIC



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)

<small>THE INFORMATION CONTAINED HEREON IS UNCLASSIFIED EXCEPT WHERE SHOWN OTHERWISE. IT IS SUBJECT TO CHANGE AND WITHOUT WARRANTY OR RESTRICTION OR LIMITATION OF ANY KIND BY THE USER.</small>		DWN: H. HUANG 05MAR2015 CHK: L. ZHANG 05MAR2015 APVD: H. GUO 05MAR2015	NAME: TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±0.5 1 PLC ±0.13 2 PLC ±0.13 3 PLC ±0.013 4 PLC ±0.001 ANGLES ±0.001	PRODUCT SPEC APPLICATION SPEC WEIGHT MATERIAL FINISH	SIZE: CAGE CODE DRAWING NO: 00779 ©=2150535 SCALE: 1:1 SHEET 4 OF 4 REV A	RESTRICTED TO: Customer Accessible Production Drawing