

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART							
					CONVERT TO	PART NUMBERS REQUIRED						
						2119950-1	2119792-2	-	2119641-1	-	2063440-1	
	2150438-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL	PNEUMATIC FEED	2119950-1	2119792-2	-	2119641-1	-	2063440-1	
					SERVO LATCH PLATE	2119951-1	1901697-1	8-2150438-5	-	2168400-7 (QUANTITY 2)		
	2150438-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	MECHANICAL FEED	2119949-1	2063961-1	5-18022-5	2119653-1	-	-	
					SERVO LATCH PLATE	2119951-1	1901697-1	8-2150438-5	-	2168400-7 (QUANTITY 2)		
	2150438-5	B	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE ⁴	MECHANICAL FEED	2119949-1	2063961-1	5-18022-5	2119653-1	-	-	
					PNEUMATIC FEED	2119950-1	2119792-2	-	2119641-1	-	2063440-1	
	2150438-6	B	NON-CRIMP HEIGHT ADJUST	SERVO LATCH PLATE ⁴	-	-	-	-	-	-	-	
					-	-	-	-	-	-	-	
	2150438-7	B	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	-	
	7-2150438-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-	

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.54 mm [.100]	F
INSUL	4.32 mm [.170]	F
APPL INSTRUCTIONS 408-10390		

TERMINAL DATA: INARCA TERMINAL INARCA CRIMP SPECIFICATION			
TERMINAL NAME: INARCA TERMINAL			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
3.75-4.35 mm [.148-.171 IN]		∅1.90-3.70 mm [.075-.146 IN]	
TERMINAL APPLICATION SPECIFICATION	NONE	-	-
TERMINALS APPLIED			
TE TERMINAL	INARCA TERMINAL	TE TERMINAL	INARCA TERMINAL
2113457-1	0010587201	2113457-5	0110587201
2113457-2	0010587001	2113457-6	0110587301
2113457-3	0010587301	2113457-7	0210587401
2113457-4	0110587001	2113457-8	0910587001

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
14 AWG OR 2.00mm ²	1.74+/-0.05 [.069+/- .002]	5.4
16 AWG OR 1.30mm ²	1.52+/-0.05 [.060+/- .002]	7.3
18 AWG OR 0.85mm ²	1.37+/-0.05 [.054+/- .002]	8.8
20 AWG OR 0.50mm ²	1.26+/-0.05 [.050+/- .002]	10.2

- 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: 8-2150438-4
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150438-4
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150438-5
 SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2150438-6
- 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 ITEM 37.
- 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	-	1803259-1	BUSHING, FLANGED	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
-77	-7	-6	-5	-2	-1	PART NO	DESCRIPTION	ITEM NO

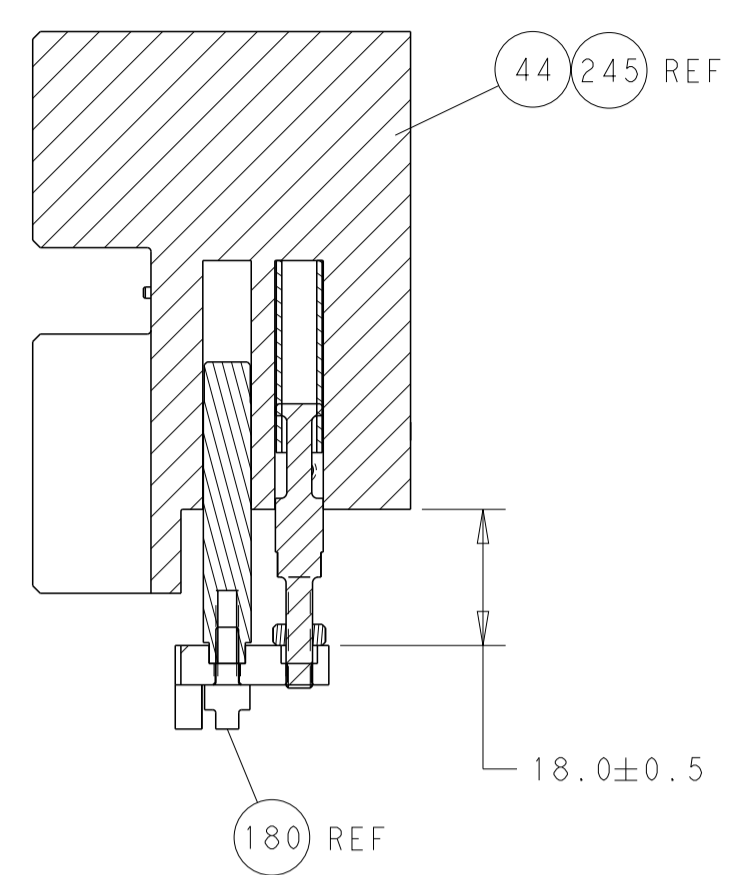
ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

SET UP GAUGE 2119599-2	LOC A	DIST 66	REVISIONS			
	A	RELEASED		DATE	OWN	APVD
	B	ECR-17-009908		17JUN2014	KH	TE
				07JUL2011	TB	GB

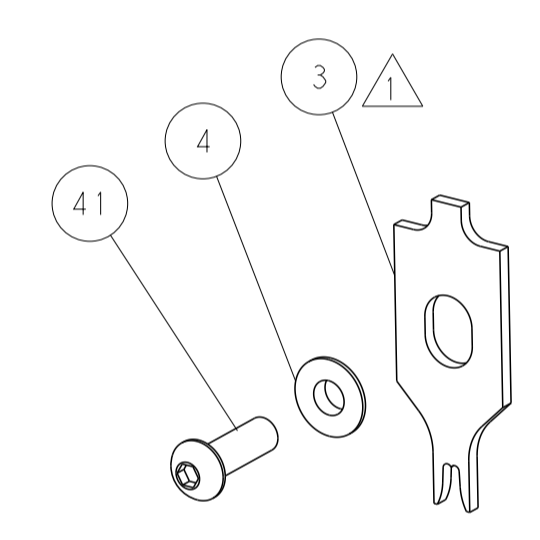
-	1	1	1	1	1	2119082-3	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	-	2	2	-	-	2168400-7	SHCS, LOW HEAD, RoHS, M5 X 10	240
-	-	-	-	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	-	-	-	-	1	2063440-1	AIR FEED MODULE	238
-	-	1	1	-	-	2119740-2	TAG, IDENTIFICATION	213
-	-	REFREF	-	-	-	1901697-1	FEED FINGER ASSEMBLY, EF	183
-	1	1	1	1	1	1976055-8	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
-	REFREFREFREFREFREF	-	-	-	-	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	455888-5	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	1901681-5	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	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	240825-1	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	1752360-1	SPACER, HOLD-DOWN	13
-	1	1	1	1	1	240644-9	PLATE, REAR SHEAR	11
-	-	-	-	-	-	-	-	10
-	1	1	1	1	1	690482-5	PLATE, FRONT SHEAR	9
-	1	1	1	1	1	4-1803001-7	ANVIL, COMBINATION, END FEED	8
-	1	1	1	1	1	2217206-7	BLADE, SLUG	7
-	-	-	-	-	-	-	-	6
-	1	1	1	1	1	4-240641-6	SPACER	5
-	1	1	1	1	1	238009-1	BLOCK, FL CRIMPER SPACER	4
-	1	1	1	1	1	7-1633961-5	CRIMPER, INSULATION F PREMIUM	3
-	-	-	-	-	-	-	-	2
-	1	1	1	1	1	456407-5	CRIMPER, WIRE PREMIUM	1
-77	-7	-6	-5	-2	-1	PART NO	DESCRIPTION	ITEM NO

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG X. ZHAO 05MAY2014		CHK L. ZHANG 05MAY2014		NAME Ocean End Feed Applicator		DATE 17JUN2014		OWN KH		APVD TE	
mm		0 PLC ±		APVD T. ELBIN 05MAY2014		NAME Ocean End Feed Applicator		DATE 17JUN2014		OWN KH		APVD TE		REV B	
MATERIAL		FINISH		WEIGHT		SCALE		SHEET		OF		REV		B	
						1:1		1		4		1		B	

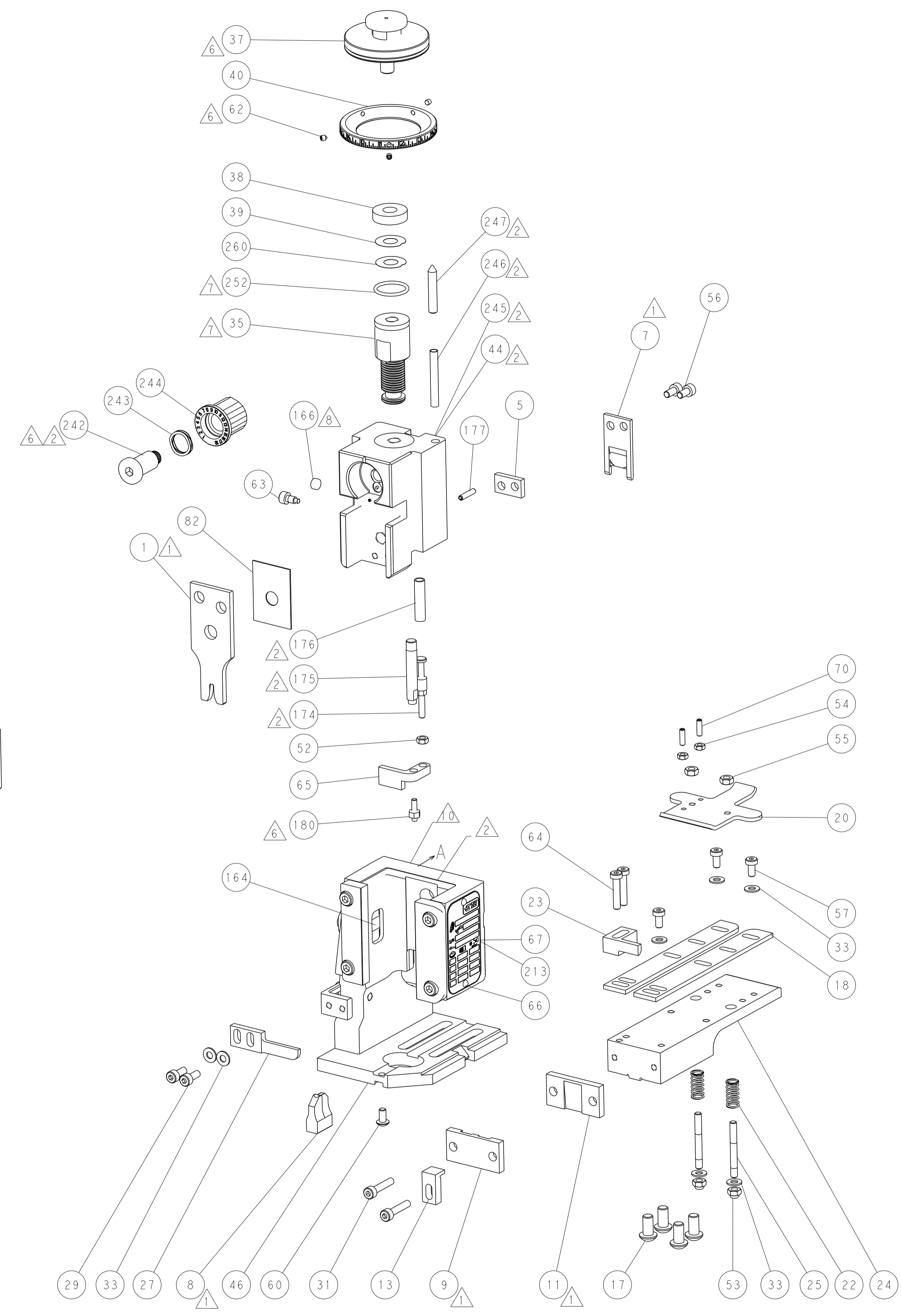
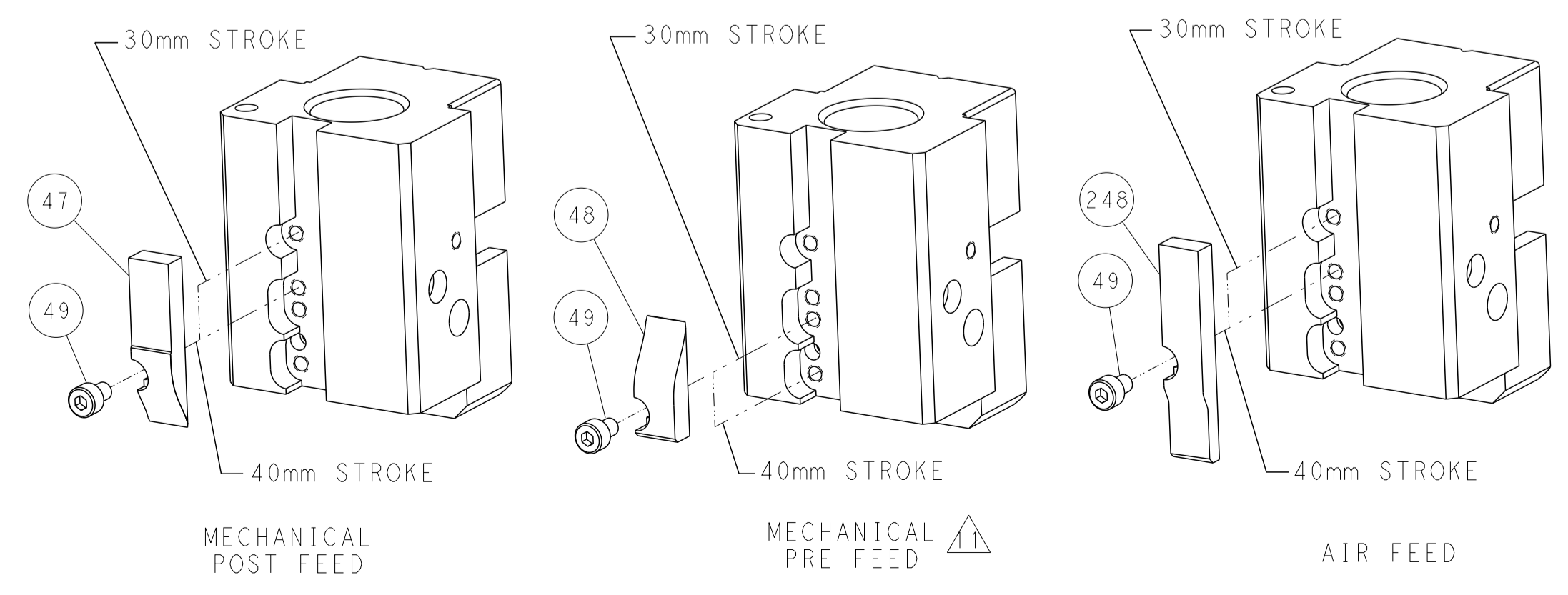
LOC		DIST		REVISIONS			
A	66	P	LTM	DESCRIPTION	DATE	DWN	APVD
		-		SEE SHEET 1			



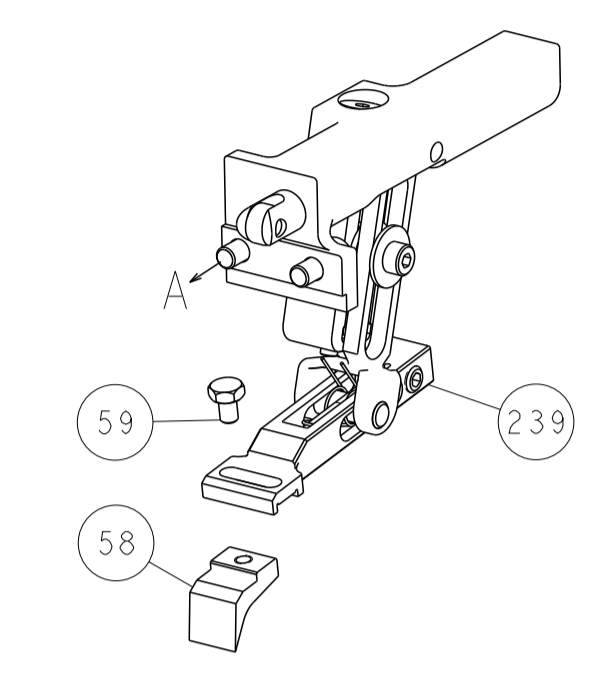
HOLDDOWN SET-UP



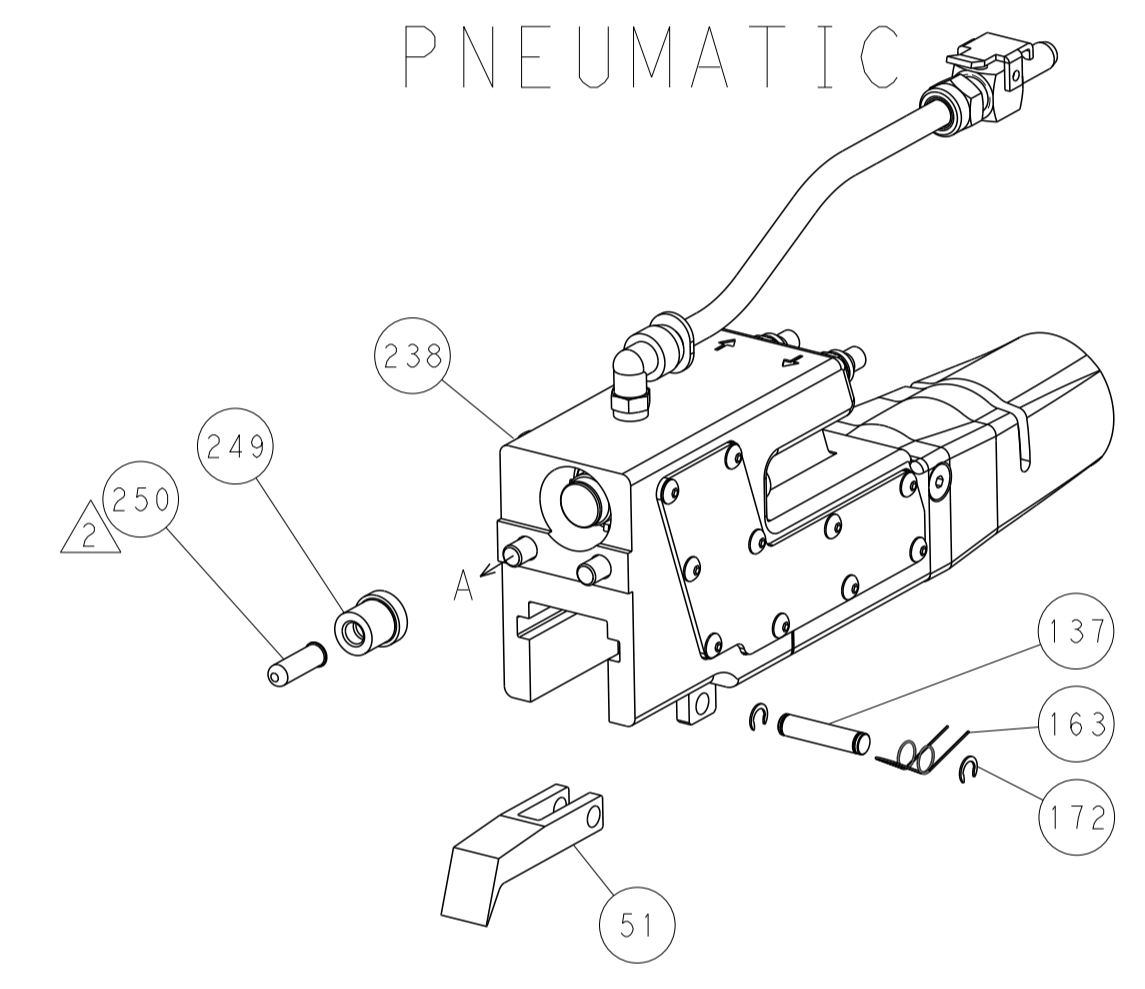
CAM POSITIONS



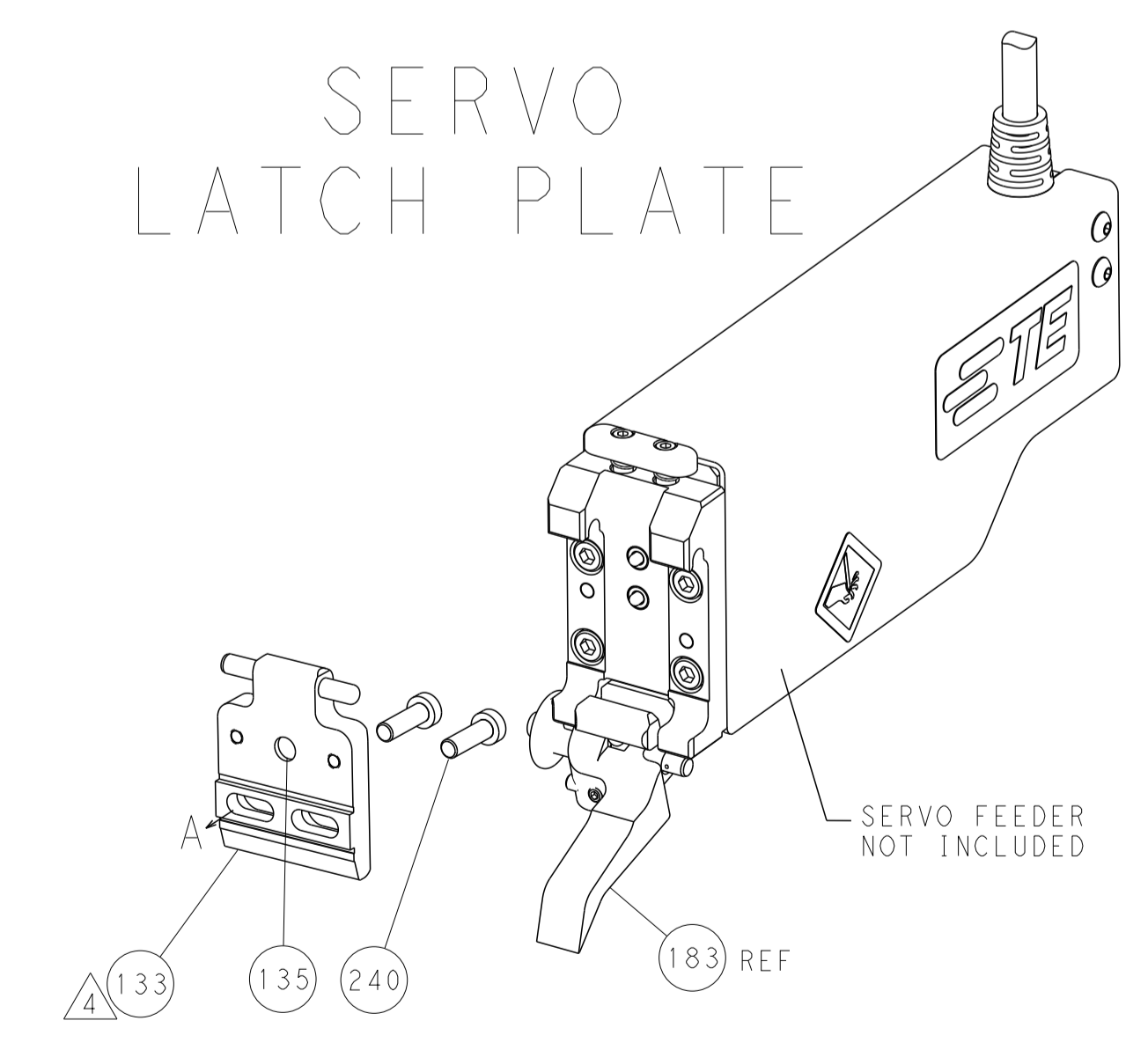
FEED TYPE
MECHANICAL



PNEUMATIC



SERVO
LATCH PLATE



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

DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH		DWN X.ZHAO 05MAY2014 CHK L.ZHANG 05MAY2014 APVD J.ELBIN 05MAY2014 PRODUCT SPEC APPLICATION SPEC WEIGHT Customer Accessible Production Drawing		NAME Ocean End Feed Applicator SIZE CAGE CODE DRAWING NO A1 00779 C=2150438 SCALE 1:1 SHEET 2 OF 4 REV B		RESTRICTED TO -	
SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION									

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PACIFIC 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	-	2119641-2	-	2063440-1
	2-2150438-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL	SERVO LATCH PLATE	2119951-1	1901697-1	8-2150438-5	-	-	2168400-7 (QUANTITY 2)	
					SMART APPLICATOR	2161326-1	-	8-2150438-4	-	-	-	
					MECHANICAL FEED	2119949-1	2063961-1	5-18022-5	2119653-2	-	-	
	2-2150438-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	SERVO LATCH PLATE	2119951-1	1901697-1	8-2150438-5	-	-	2168400-7 (QUANTITY 2)	
					SMART APPLICATOR	2161326-1	-	8-2150438-4	-	-	-	
					MECHANICAL FEED	2119949-1	2063961-1	5-18022-5	2119653-2	-	-	
	2-2150438-5	B	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE	PNEUMATIC FEED	2119950-1	2119792-2	-	2119641-2	-	2063440-1	
					-	-	-	-	-	-	-	
	2-2150438-7	B	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	-	
	7-2150438-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-	

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.54 mm [.100]	F
INSUL	4.32 mm [.170]	F
APPL INSTRUCTIONS 408-10390		

TERMINAL DATA: INARCA TERMINAL INARCA CRIMP SPECIFICATION	
TERMINAL NAME: INARCA TERMINAL	
WIRE STRIP LENGTH 3.75-4.35 mm [.148-.171 IN]	INSULATION DIAMETER RANGE Ø1.90-3.70 mm [.075-.146 IN]
TERMINAL APPLICATION SPECIFICATION	NONE
TERMINALS APPLIED	
TE TERMINAL	INARCA TERMINAL
2113457-1	0010587201
2113457-2	0010587001
2113457-3	0010587301
2113457-4	0110587001

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
14 AWG OR 2.00mm2	1.74 +/- 0.05 [.069 +/- .002]	5.4
16 AWG OR 1.30mm2	1.52 +/- 0.05 [.060 +/- .002]	7.3
18 AWG OR 0.85mm2	1.37 +/- 0.05 [.054 +/- .002]	8.8
20 AWG OR 0.50mm2	1.26 +/- 0.05 [.050 +/- .002]	10.2



- 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: 8-2150438-4
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150438-4
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150438-5
- 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.

-77-27-25-22-21	PART NO	DESCRIPTION	ITEM NO
- 1 1 1 1 1	2119782-1	FINE ADJUST HEAD ASM, PACIFIC STYLE	251
- - - 1 -	2119640-1	PUSH ROD, AIR FEED	250
- - - 1 -	1803259-1	BUSHING, FLANGED	249
- 1 1 1 1 1	1-22279-3	SPRING, COMPRESSION	246
- 1 1 1 1 1	2119082-3	CAM, SNAIL, INSULATION ADJUSTMENT	244
- 1 1 1 1 1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243

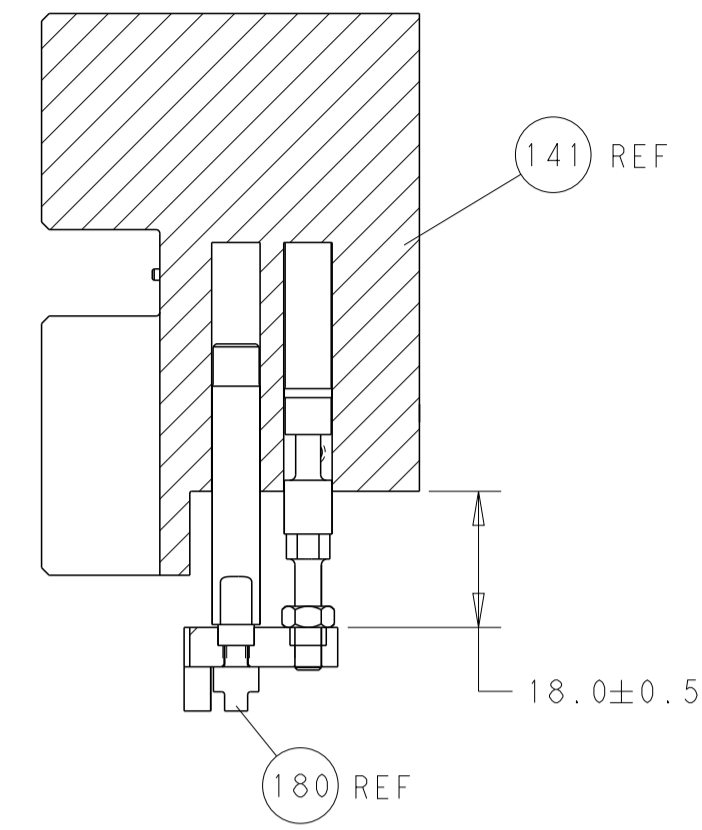
PACIFIC VERSION
 Shown on sheets 3 of 4 & 4 of 4
 (Atlantic version shown on sheets 1 of 4 & 2 of 4)

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

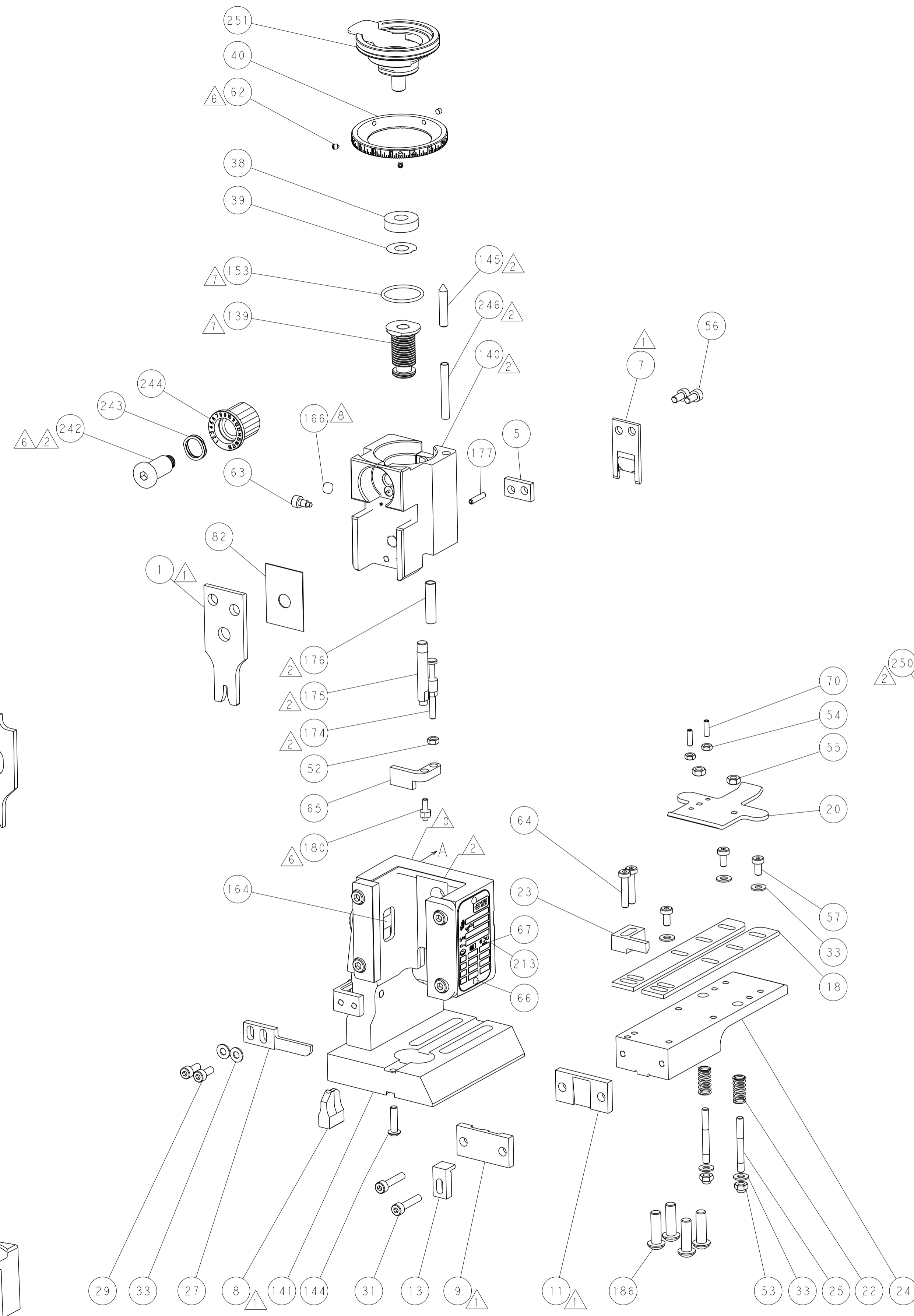
QTY	REV	QTY	REV	QTY	REV	QTY	REV	DESCRIPTION	DATE	BY	APPD
-	1	1	1	1	1	2119083-1		RETAINER, INSULATION DIAL			242
-	-	2	-	-	-	2168400-7		SHCS, LOW HEAD, RoHS, M5 X 10			240
-	-	-	-	1	-	2119580-1		MECHANICAL FEED ASSEMBLY			239
-	-	-	1	-	-	2063440-1		AIR FEED MODULE			238
-	-	1	-	-	-	2119740-2		TAG, IDENTIFICATION			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		1976055-8		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	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		455888-5		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	-	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		2168400-5		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	-	2063961-1		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	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		240825-1		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		1752360-1		SPACER, HOLD-DOWN			13
-	1	1	1	1		240644-9		PLATE, REAR SHEAR			11
-	-	-	-	-		-		-			10
-	1	1	1	1		690482-5		PLATE, FRONT SHEAR			9
-	1	1	1	1		4-1803001-7		ANVIL, COMBINATION, END FEED			8
-	1	1	1	1		2217206-7		BLADE, SLUG			7
-	-	-	-	-		-		-			6
-	1	1	1	1		4-240641-6		SPACER			5
-	1	1	1	1		238009-1		BLOCK, FL CRIMPER SPACER			4
-	1	1	1	1		7-1633961-5		CRIMPER, INSULATION F PREMIUM			3
-	-	-	-	-		-		-			2
-	1	1	1	1		456407-5		CRIMPER, WIRE PREMIUM			1

DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG: X.ZHAO 05MAY2014		CHK: L.ZHANG 05MAY2014		APVD: T.ELBIN 05MAY2014		NAME: Ocean End Feed Applicator	
0 PLC ±		1 PLC ±		2 PLC ±		3 PLC ±		4 PLC ±		SIZE: A1	
ANGLES ±		FINISH ±		WEIGHT		SCALE: 1:1		SHEET: 3 of 4		REV: B	

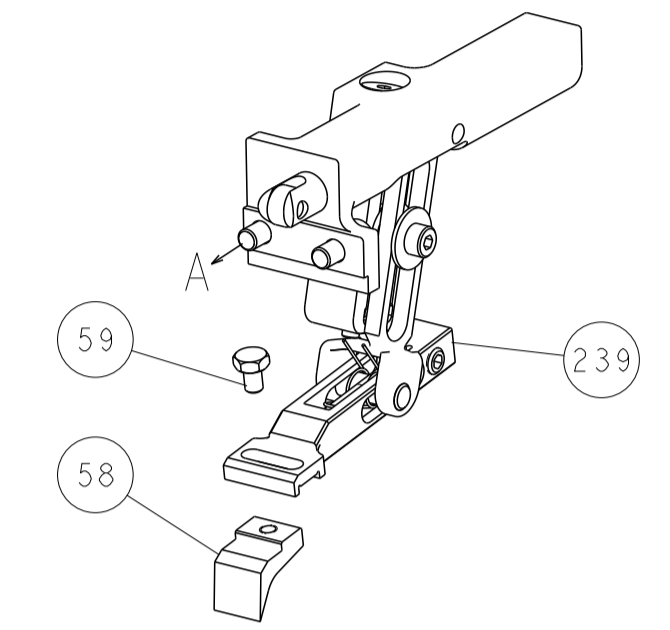
LOC		DIST		REVISIONS			
A	66	P	LTM	DESCRIPTION	DATE	OWN	APVD
		-		SEE SHEET 1			



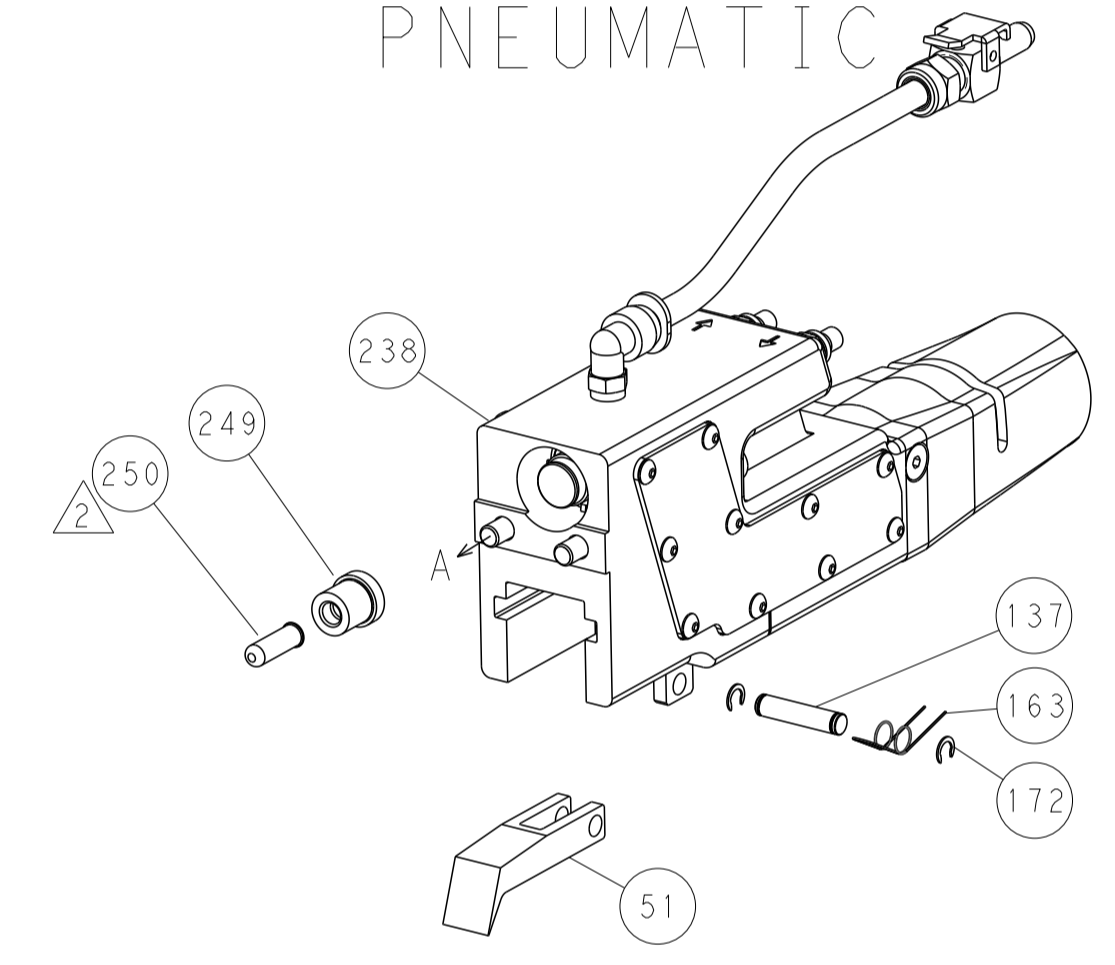
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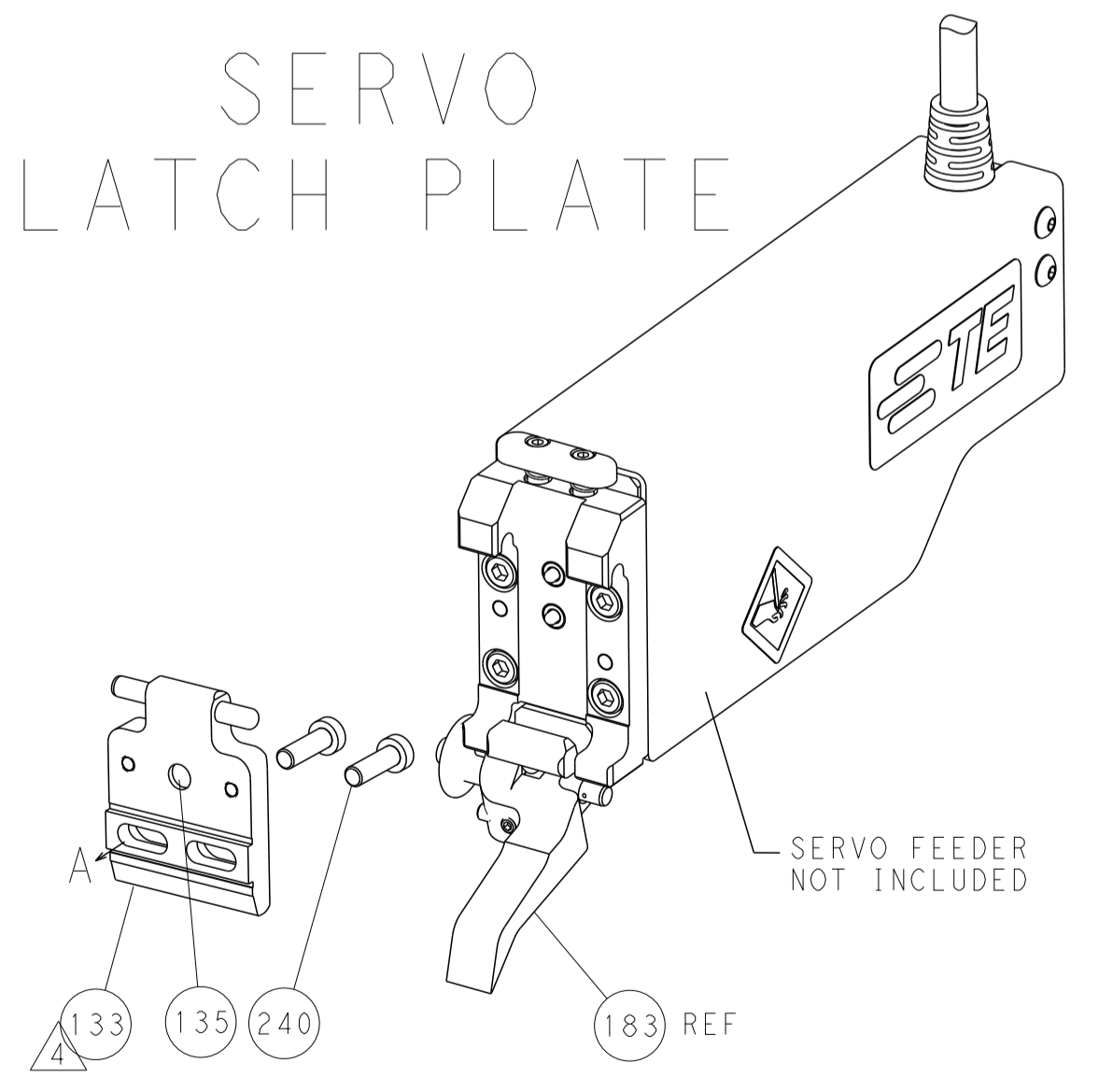
FEED TYPE
MECHANICAL



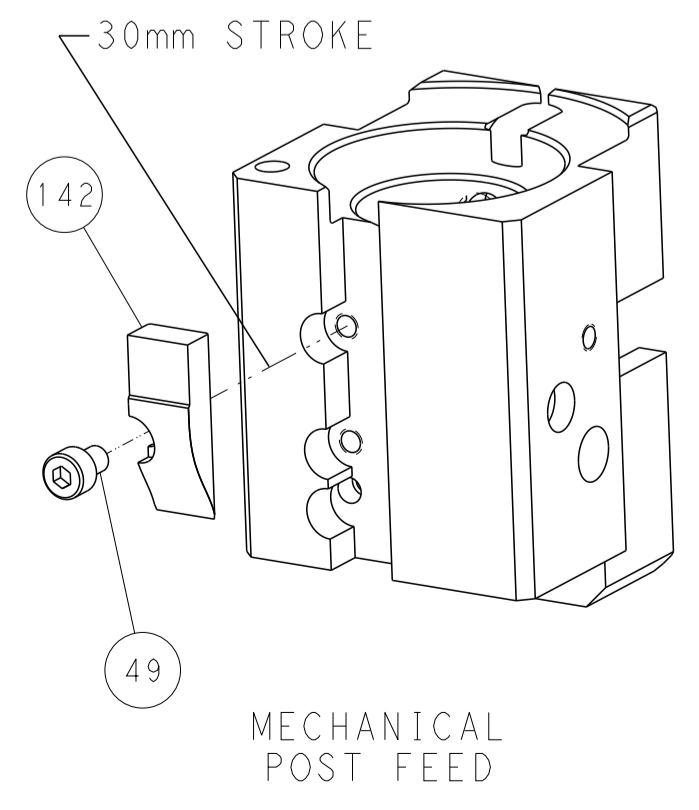
PNEUMATIC



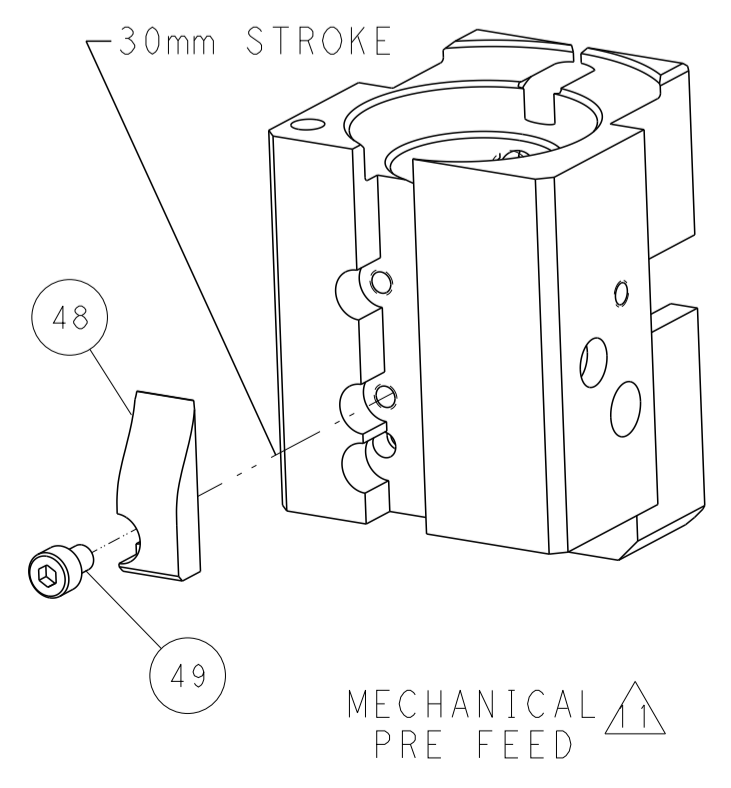
SERVO
LATCH PLATE



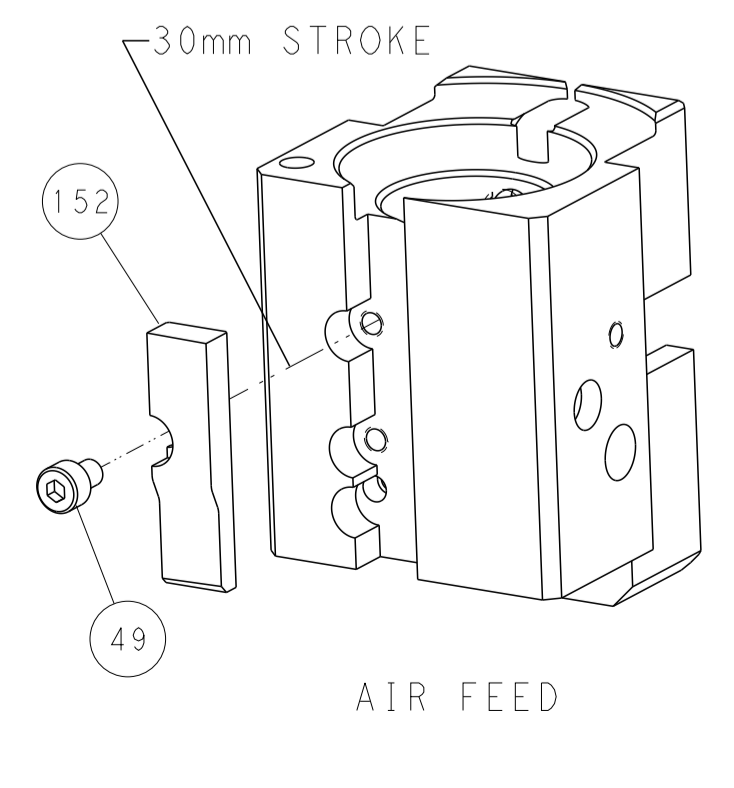
CAM POSITIONS



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 05MAY2014		STE TE Connectivity Harrisburg, PA 17105-3608	
mm	0 PLC ±	1 PLC ±	2 PLC ±	CHK L_ZHANG 05MAY2014	NAME	SIZE	CAGE CODE
	3 PLC ±	4 PLC ±	5 PLC ±	APVD T_ELBIN 05MAY2014	PRODUCT SPEC	00779	2150438
	6 PLC ±	ANGLES ±	FINISH	APPLICATION SPEC	RESTRICTED TO	Customer Accessible Production Drawing	
MATERIAL		WEIGHT		SCALE	SHEET	OF	REV
				1:1	4	4	B