

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART						
					CONVERT TO	PART NUMBERS REQUIRED					
	2150487-1	A	FINE CRIMP HEIGHT ADJUST	MECHANICAL	PNEUMATIC FEED	2119950-1	2119792-2	-	2119641-1	-	2063440-1
					SERVO LATCH PLATE	2119951-1	1901697-1	8-2150487-5	-	-	2168400-7 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2150487-4	-	-	-
	2150487-2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	MECHANICAL FEED	2119949-1	2063961-1	5-18022-5	2119653-1	-	-
					SERVO LATCH PLATE	2119951-1	1901697-1	8-2150487-5	-	-	2168400-7 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2150487-4	-	-	-
	2150487-5	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
					-	-	-	-	-	-	-
	2150487-6	A	NON-CRIMP HEIGHT ADJUST	SERVO LATCH PLATE	-	-	-	-	-	-	-
					-	-	-	-	-	-	-
	2150487-7	A	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	-
					-	-	-	-	-	-	-
		7-2150487-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	3.05 mm [1.20]	F
INSUL	6.35 mm [2.50]	F

APPLICATOR INSTRUCTIONS 408-10390

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: RECEPTACLE, FASTIN-FASTON, .250 SERIES			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
5.82-6.48 mm [1.229-.255 IN]		Ø4.06-5.33 mm [1.160-.210 IN]	
TERMINAL APPLICATION SPECIFICATION	114-2025	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
60253-1	60253-2	152313-1	

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
12 AWG	2.08+/-0.05 [1.082+/-0.002]	6.1
2X16AWG	1.91+/-0.05 [1.075+/-0.002]	7.9
14 AWG	1.75+/-0.05 [1.069+/-0.002]	9.7
16 AWG	1.55+/-0.05 [1.061+/-0.002]	11.9

- 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: 8-2150487-4  
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150487-4  
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150487-5  
SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2150487-6
- 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. FOR -6 ONLY APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 37 & 180.
- 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.

-	-	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	2119082-7	CAM, SNAIL, INSULATION ADJUSTMENT					244
-	1	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST					243
-77	-7	-6	-5	-2	-1	PART NO	DESCRIPTION					ITEM NO

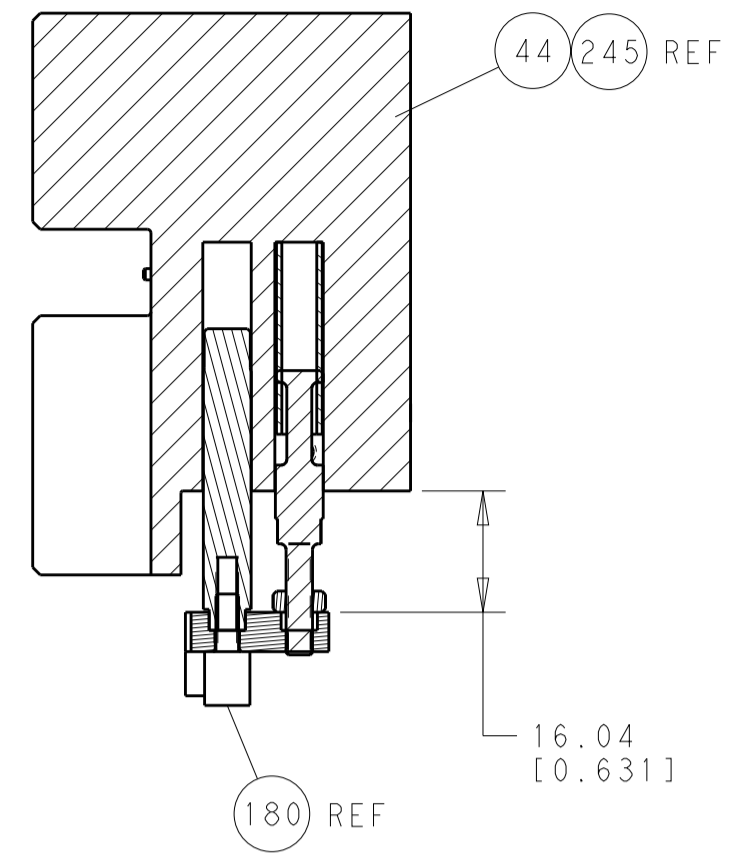
**ATLANTIC VERSION**  
Shown on sheets 1 of 4 & 2 of 4  
(Pacific version shown on sheets 3 of 4 & 4 of 4)

SET UP GAUGE	LOC	DIST	REVISIONS			
			DATE	OWN	APPV	DESCRIPTION
2119599-2	A	66	290CT2014	KH	UG	RELEASED

-	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	1-1752354-3	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	455888-5	SPACER, CRIMPER					82
-	1	1	1	1	1	2119791-9	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	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	1901681-1	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	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0					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	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	1752371-3	PLATE, STRIP GUIDE					24
-	1	1	1	1	1	240825-3	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	1901259-6	GUIDE, LOWER STRIP					18
-	4	4	4	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)					17
-	1	1	1	1	1	1-240641-1	SPACER					16
-	1	1	1	1	1	1752360-1	SPACER, HOLD-DOWN					13
-	1	1	1	1	1	240833-4	PLATE, REAR SHEAR					11
-	-	-	-	-	-	-	-					10
-	1	1	1	1	1	2-690495-6	PLATE, FRONT SHEAR					9
1	1	1	1	1	1	1-1803059-3	ANVIL, COMBINATION, END FEED					8
-	1	1	1	1	1	1-2217206-3	BLADE, SLUG					7
-	1	1	1	1	1	1803203-1	BLOCK, FRONT DEPRESSOR					6
-	1	1	1	1	1	240641-4	SPACER					5
-	1	1	1	1	1	1-238011-2	BLOCK, CRIMPER SPACER					4
1	1	1	1	1	1	2-1803016-6	CRIMPER, INSULATION F					3
-	-	-	-	-	-	-	-					2
1	1	1	1	1	1	2-456409-8	CRIMPER, WIRE .120 "F" PREMIUM					1
-77	-7	-6	-5	-2	-1	PART NO	DESCRIPTION					ITEM NO

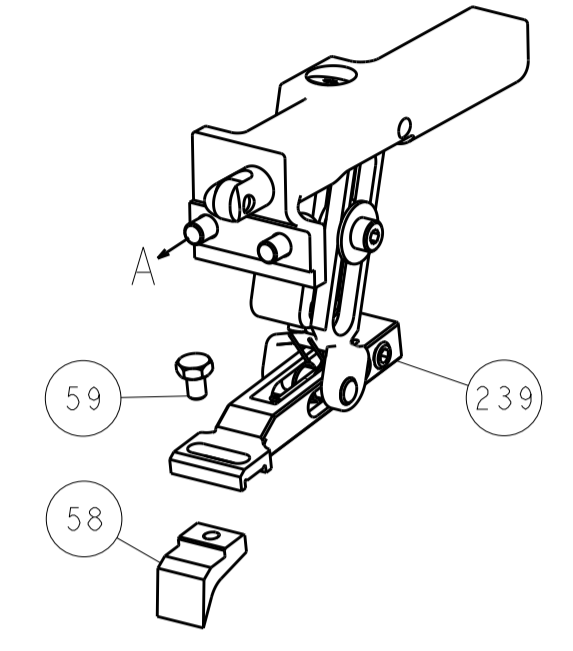
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LOC		DIST		REVISIONS			
A	66	P	LTM	DESCRIPTION	DATE	OWN	APVD
		-	-	SEE SHEET 1	-	-	-

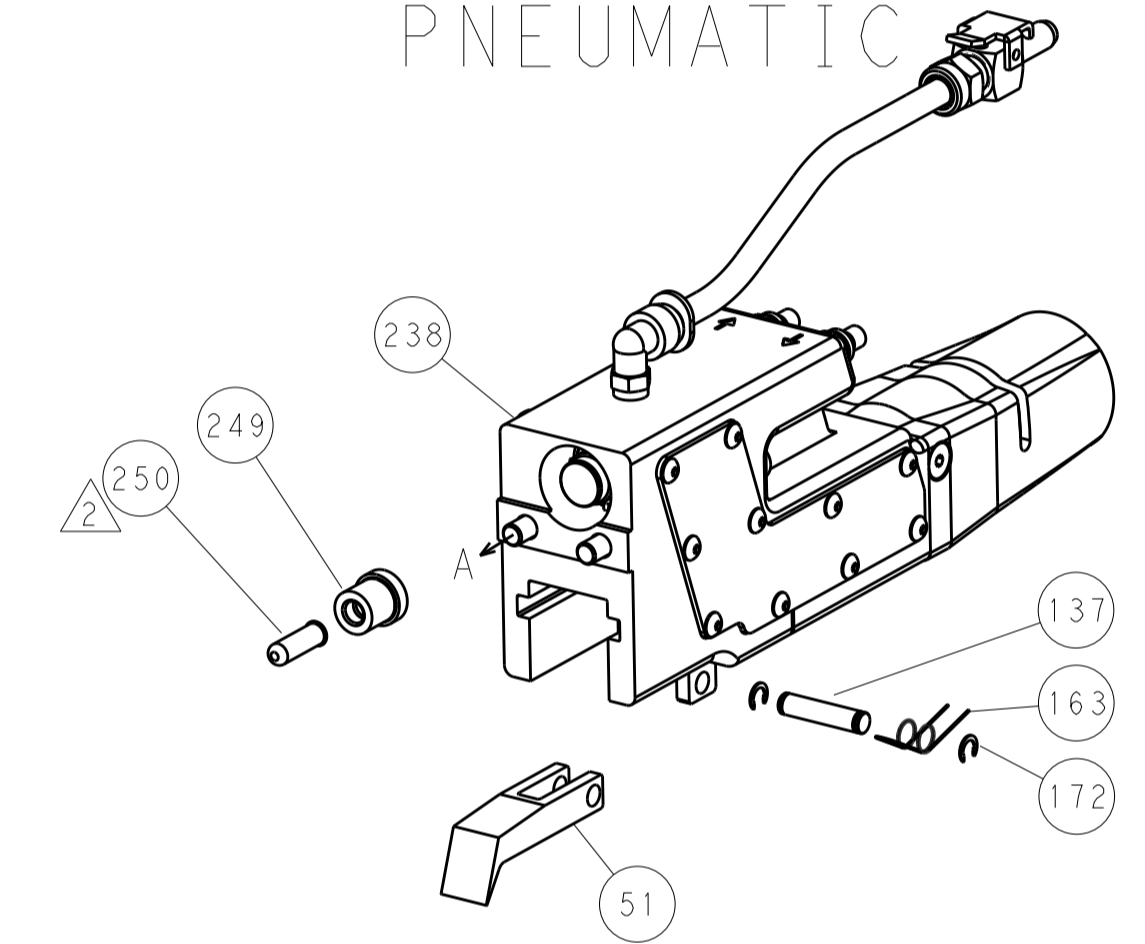


HOLDDOWN SET-UP

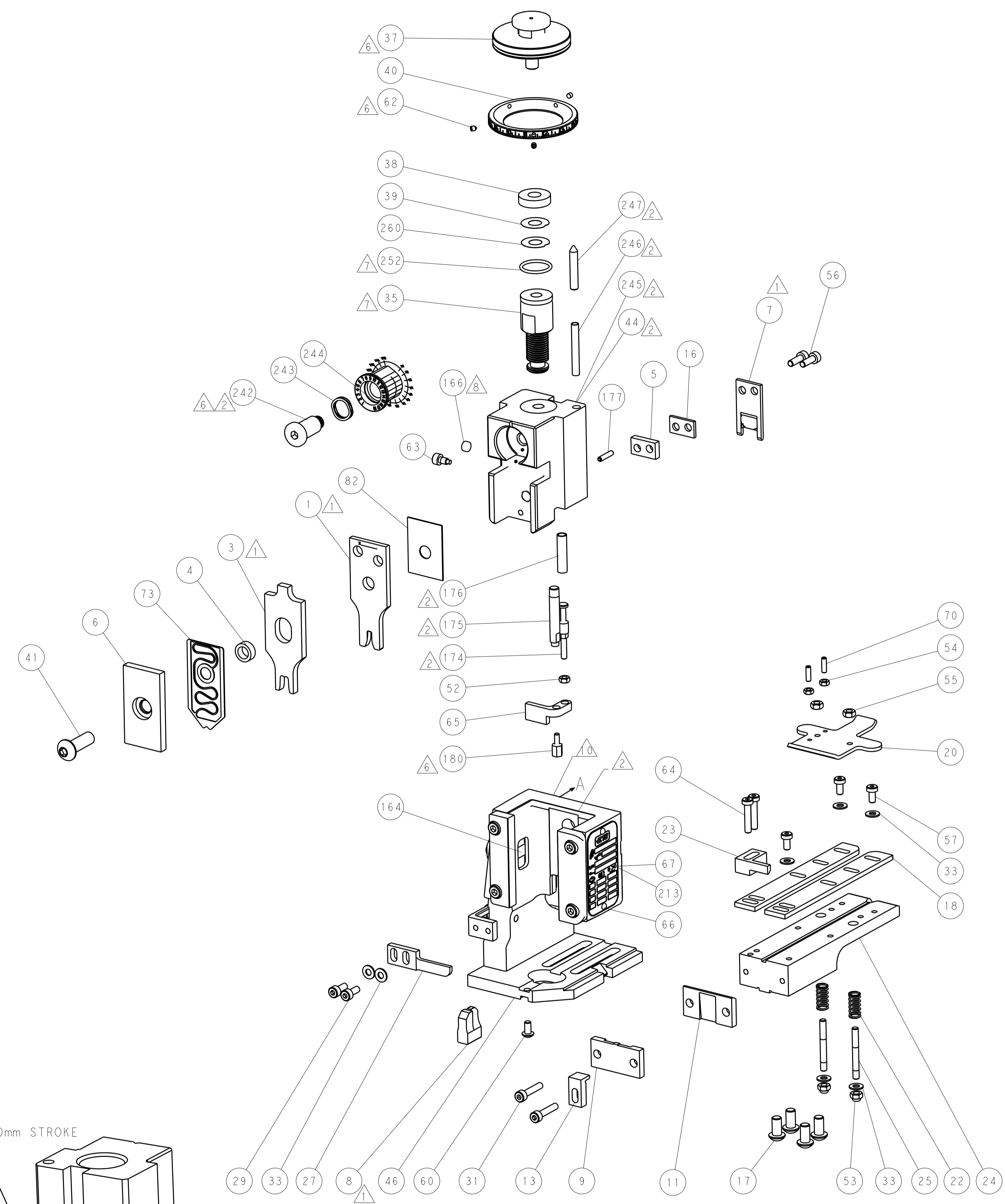
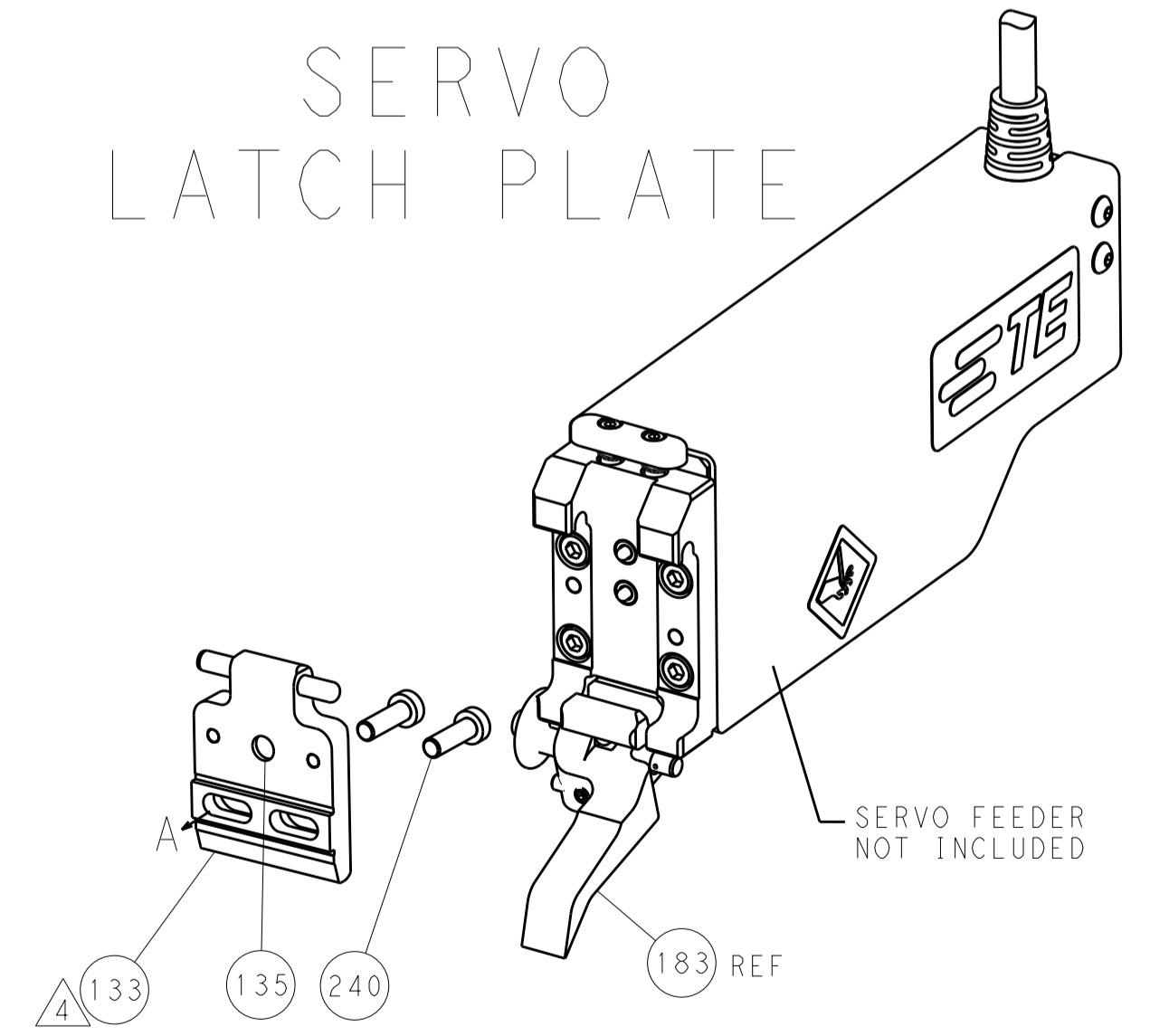
FEED TYPE  
MECHANICAL



PNEUMATIC



SERVO  
LATCH PLATE



CAM POSITIONS



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 10SEP2014		TE Connectivity	
mm	0 PLC ±0.5	1 PLC ±0.5	2 PLC ±0.13	3 PLC ±0.13	4 PLC ±0.001	5 PLC ±0.001	Harrisburg, PA 17105-3608
MATERIAL:		FINISH:		CHK: L. ZHANG 10SEP2014		NAME: Ocean End Feed Applicator	
APVD: H. GUO 10SEP2014		PRODUCT SPEC:		APVD: H. GUO 10SEP2014		SIZE: CAGE CODE: DRAWING NO: RESTRICTED TO	
APPLICATOR SPEC:		WEIGHT:		A11 00779 ©=2150487		SCALE: 1:1 SHEET 2 OF 4 REV A	
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					
	2-2150487-1	A	FINE CRIMP HEIGHT ADJUST	MECHANICAL	PNEUMATIC FEED	2119950-1	2119792-2	-	2119641-2	-	2063440-1
					SERVO LATCH PLATE	2119951-1	1901697-1	8-2150487-5	-	2168400-7 (QUANTITY 2)	
					SMART APPLICATOR	2161326-1	-	8-2150487-4	-	-	
	2-2150487-2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	MECHANICAL FEED	2119949-1	2063961-1	5-18022-5	2119653-2	-	-
					SERVO LATCH PLATE	2119951-1	1901697-1	8-2150487-5	-	2168400-7 (QUANTITY 2)	
					SMART APPLICATOR	2161326-1	-	8-2150487-4	-	-	
	2-2150487-5	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
	2-2150487-7	A	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	-
	7-2150487-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	3.05 mm [1.201]	F
INSUL	6.35 mm [1.250]	F
APPLICATOR INSTRUCTIONS 408-10390		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: RECEPTACLE, FASTIN- FASTON, .250 SERIES			
WIRE STRIP LENGTH 5.82-6.48 mm [1.229-.255 IN]		INSULATION DIAMETER RANGE 4.06-5.33 mm [1.160-.210 IN]	
TERMINAL APPLICATION SPECIFICATION	114-2025	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
60253-1	60253-2	152313-1	

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
12 AWG	2.08 +/- 0.05 [1.082 +/- .002]	6.1
2X16AWG	1.91 +/- 0.05 [1.075 +/- .002]	7.9
14 AWG	1.75 +/- 0.05 [1.069 +/- .002]	9.7
16 AWG	1.55 +/- 0.05 [1.061 +/- .002]	11.9

- 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: 8-2150487-4  
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150487-4  
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150487-5
- 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.

-	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	2119082-7	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	-	-	2168400-7	SHCS, LOW HEAD, RoHS, M5 X 10	240
-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)

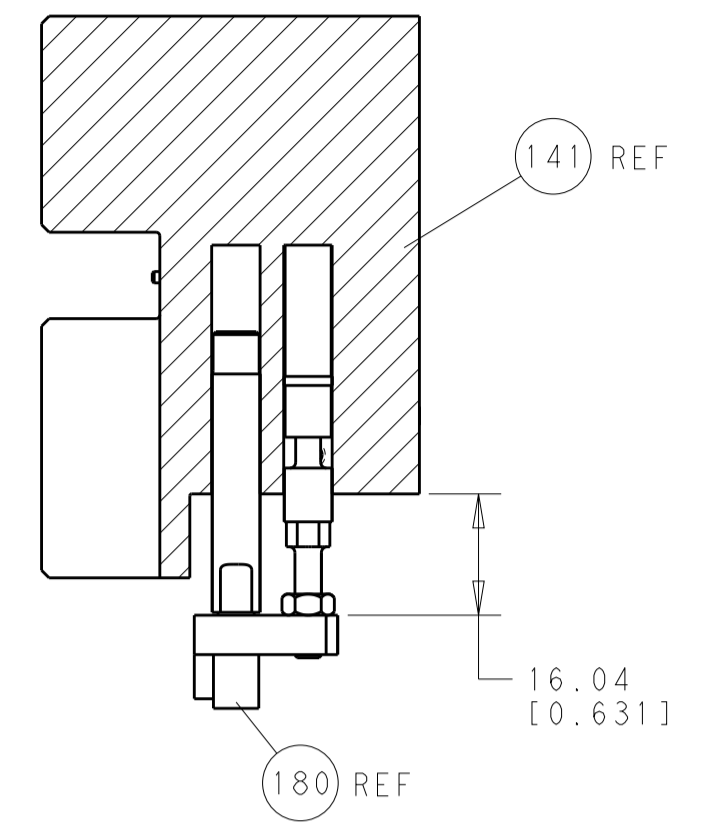
SET UP GAUGE	LOC	DIST	REVISIONS			
2119599-2	A	66	REV	DATE	BY	APPV
-	-	-	1	-	-	-
SEE SHEET 1			-	-	-	-

-	-	-	-	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	1-1752354-3	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	2119791-9	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	2119740-1	TAG, IDENTIFICATION	67
-	2	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	1	1	1	1	1901681-1	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	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	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
-	-	-	-	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	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	1752371-3	PLATE, STRIP GUIDE	24
-	1	1	1	1	240825-3	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	1901259-6	GUIDE, LOWER STRIP	18
-	1	1	1	1	1-240641-1	SPACER	16
-	1	1	1	1	1752360-1	SPACER, HOLD-DOWN	13
-	1	1	1	1	240833-4	PLATE, REAR SHEAR	11
-	-	-	-	-	-	-	10
-	1	1	1	1	2-690495-6	PLATE, FRONT SHEAR	9
-	1	1	1	1	1-1803059-3	ANVIL, COMBINATION, END FEED	8
-	1	1	1	1	1-2217206-3	BLADE, SLUG	7
-	1	1	1	1	1803203-1	BLOCK, FRONT DEPRESSOR	6
-	1	1	1	1	240641-4	SPACER	5
-	1	1	1	1	1-238011-2	BLOCK, CRIMPER SPACER	4
-	1	1	1	1	2-1803016-6	CRIMPER, INSULATION F	3
-	-	-	-	-	-	-	2
-	1	1	1	1	2-456409-8	CRIMPER, WIRE .120 "F" PREMIUM	1
-77-	27-	25-	22-	21	PART NO	DESCRIPTION	ITEM NO

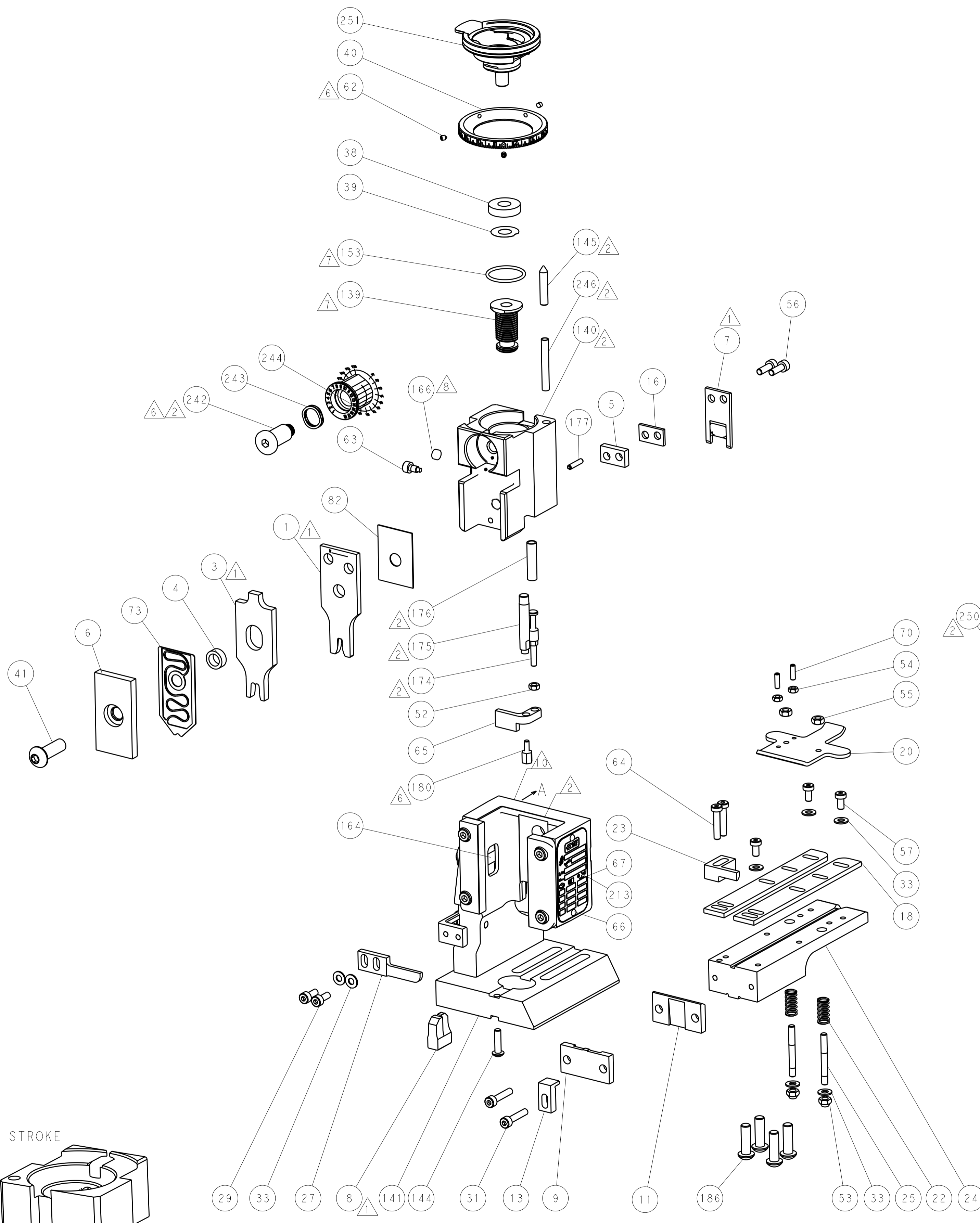
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG		CHK		APPV		NAME	
mm	0 PLC ±.5	1 PLC ±.13	2 PLC ±.013	3 PLC ±.001	10SEP2014	H. HUANG	L. ZHANG	U. GUO	10SEP2014	STE	TE Connectivity
MATERIAL:		FINISH:		WEIGHT:		SCALE:		SHEET:		REV:	
-		-		-		1:1		3 OF 4		A	



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



HOLDDOWN SET-UP

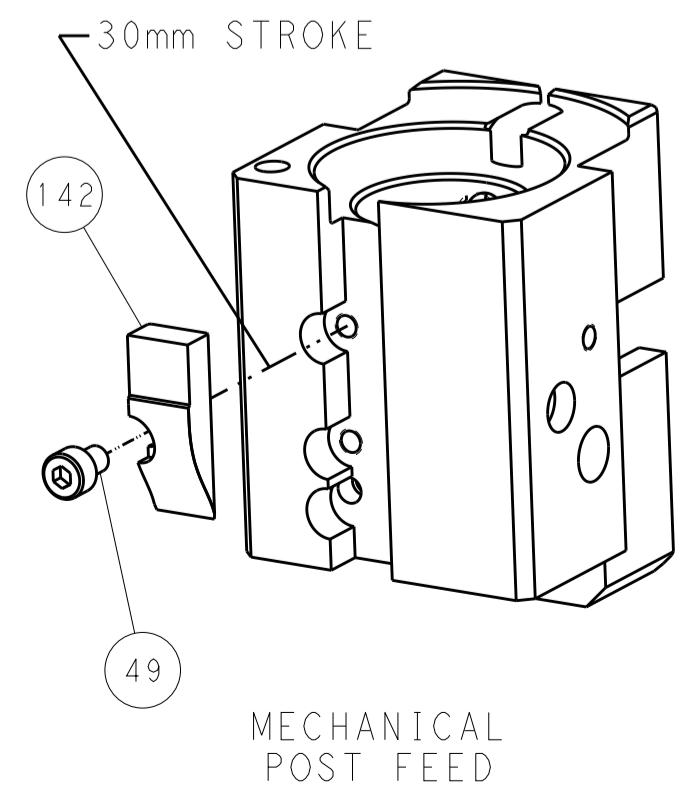


FEED TYPE  
MECHANICAL

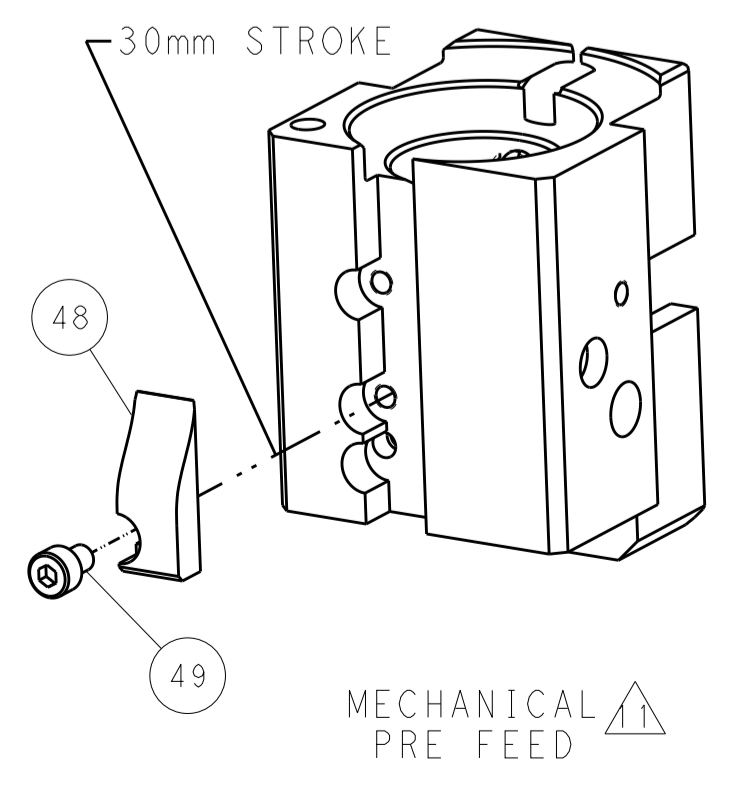
PNEUMATIC

SERVO  
LATCH PLATE

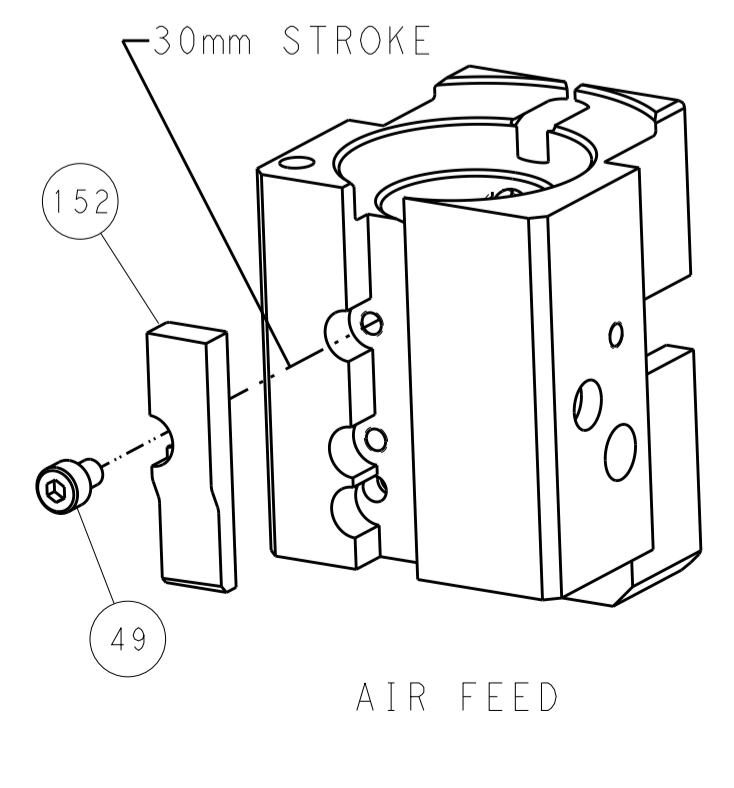
CAM POSITIONS



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: R. HUANG 10SEP2014		STE TE Connectivity	
mm	0 PLC ±0.5	1 PLC ±0.5	2 PLC ±0.13	3 PLC ±0.13	CHK: L. ZHANG 10SEP2014	Harrisburg, PA 17105-3608	
	4 PLC ±0.013	5 PLC ±0.001	6 ANGLE ±0.001	7 FINISH	APVD: H. GUO 10SEP2014	NAME: Ocean End Feed Applicator	
MATERIAL:		WEIGHT:		SIZE: A11	CAGE CODE: 00779	DRAWING NO: C-2150487	RESTRICTED TO:
				Customer Accessible Production Drawing		SCALE: 1:1	SHEET 4 OF 4 REV A