

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
	2150485-1	A	FINE CRIMP HEIGHT ADJUST	MECHANICAL
	2150485-2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
	2150485-5	A	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE
	2150485-6	A	NON-CRIMP HEIGHT ADJUST	SERVO LATCH PLATE
	2150485-7	A	FINE CRIMP HEIGHT ADJUST	NONE
	7-2150485-7	A	CRIMP TOOLING KIT	-

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.78 mm [.070]	F
INSUL	2.50 mm [.098]	F
APPL INSTRUCTIONS 408-10390		

TERMINAL DATA: STEWART WARNER TERMINATOR CRIMP SPECIFICATION			
TERMINAL NAME: 6.3 TERMINAL SELF LOCKING RECEPTACLE			
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE		
4.65-5.42 mm [.183-.213 IN]	Ø 1.70mm MAX [.067 IN MAX]		
TERMINAL APPLICATION SPECIFICATION	NONE		
TERMINALS APPLIED			
TE TERMINAL	STEWART WARNER TERMINAL	TE TERMINAL	STEWART WARNER TERMINAL
2113585-1	SO.481.622	2113585-2	172773

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
18 AWG	1.44 +/- 0.05 [.057 +/- .002]	6.8

- 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: 8-2150485-4
 - PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150485-4
 - SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150485-5
 - SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2150485-6
- 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

CONVERT TO	PART NUMBERS REQUIRED						
PNEUMATIC FEED	2119950-1	2119792-2	-	2119641-1	-	2063440-1	
SERVO LATCH PLATE	2119951-1	1901697-1	8-2150485-5	-	-	2168400-7 (QUANTITY 2)	
SMART APPLICATOR	2161326-1	-	8-2150485-4	-	-		
MECHANICAL FEED	2119949-1	2063961-1	5-18022-5	2119653-1	-		
SERVO LATCH PLATE	2119951-1	1901697-1	8-2150485-5	-	-	2168400-7 (QUANTITY 2)	
SMART APPLICATOR	2161326-1	-	8-2150485-4	-	-		
MECHANICAL FEED	2119949-1	2063961-1	5-18022-5	2119653-1	-		
PNEUMATIC FEED	2119950-1	2119792-2	-	2119641-1	-	2063440-1	

SET UP GAUGE	LOC	DIST	REVISIONS				
2119599-2	A	66	P	LTN	DATE	DWN	APVD
			A	RELEASED	04NOV2014	RK	GB

-	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	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	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	2168400-8	SHCS, LOW HEAD, RoHS, M4 X 16	64	
-	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	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	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	-	-	-	-	2119369-1	RAM,AMP STYLE, END FEED	44	
-	1	1	1	1	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	1	1	1	1-2119644-2	RAM WASHER, PRECISION	38	
-	1	1	1	1	1	2119085-1	FA HEAD, ATLANTIC STYLE	37	
-	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	1901259-4	GUIDE, LOWER STRIP	18	
-	4	4	4	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17	
-	1	1	1	1	1	5-240641-2	SPACER	16	
-	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	1-1803059-4	ANVIL, COMBINATION, END FEED	8	
-	1	1	1	1	1	2217206-4	BLADE, SLUG	7	
-	-	-	-	-	-	-	-	6	
-	1	1	1	1	1	240641-1	SPACER	5	
-	1	1	1	1	1	238009-4	BLOCK, FL CRIMPER SPACER	4	
-	1	1	1	1	1	4-1633961-5	CRIMPER, INSULATION F PREMIUM	3	
-	1	1	1	1	1	455888-4	SPACER, CRIMPER	2	
-	1	1	1	1	1	3-456404-9	CRIMPER, WIRE PREMIUM	1	

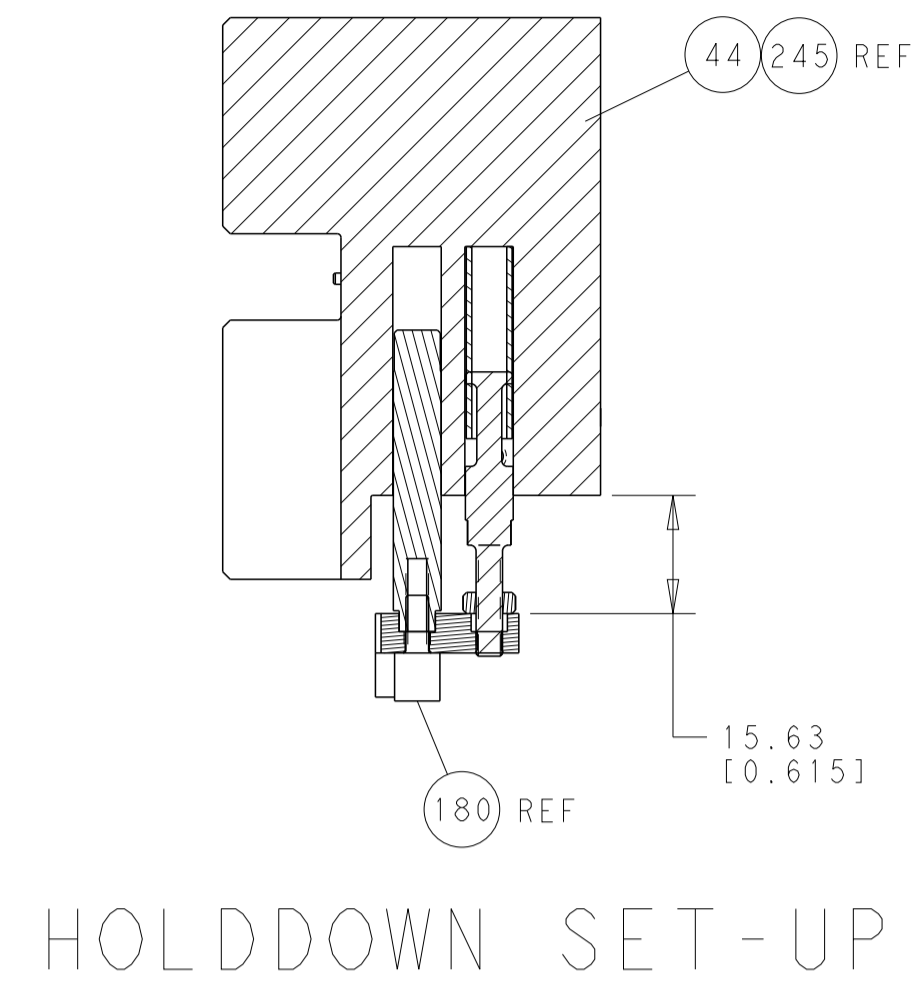
***WARNING**
ON INSTALLATION, SET WIRE DISC, ITEM 40 TO LARGEST WIRE SIZE SETTING. USE OF SETTINGS BELOW MINIMUM REQUIRED CRIMP HEIGHT SETTING WILL CAUSE DAMAGE TO CRIMP TOOLING.

-	-	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	2119082-1	CAM, SNAIL, INSULATION ADJUSTMENT	244
-77	-7	-6	-5	-2	-1	PART NO	DESCRIPTION	ITEM NO

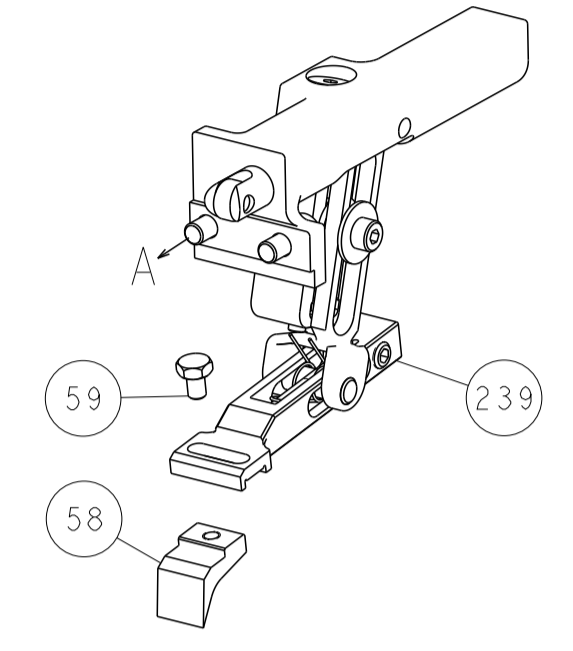
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

DIMENSIONS: mm 	TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.5 1 PLC ±.13 5 PLC ±.013 4 PLC ±.0001 ANGLES ±.1	DWN Y. YIN 10SEP2014 CHK G. BAILEY 10SEP2014 APVD H. GUO 10SEP2014 PRODUCT SPEC APPLICATION SPEC MATERIAL FINISH	NAME Ocean End Feed Applicator SIZE A1 CAGE CODE 00779 DRAWING NO C=2150485 RESTRICTED TO SCALE 1:1 SHEET 1 OF 4 REV A
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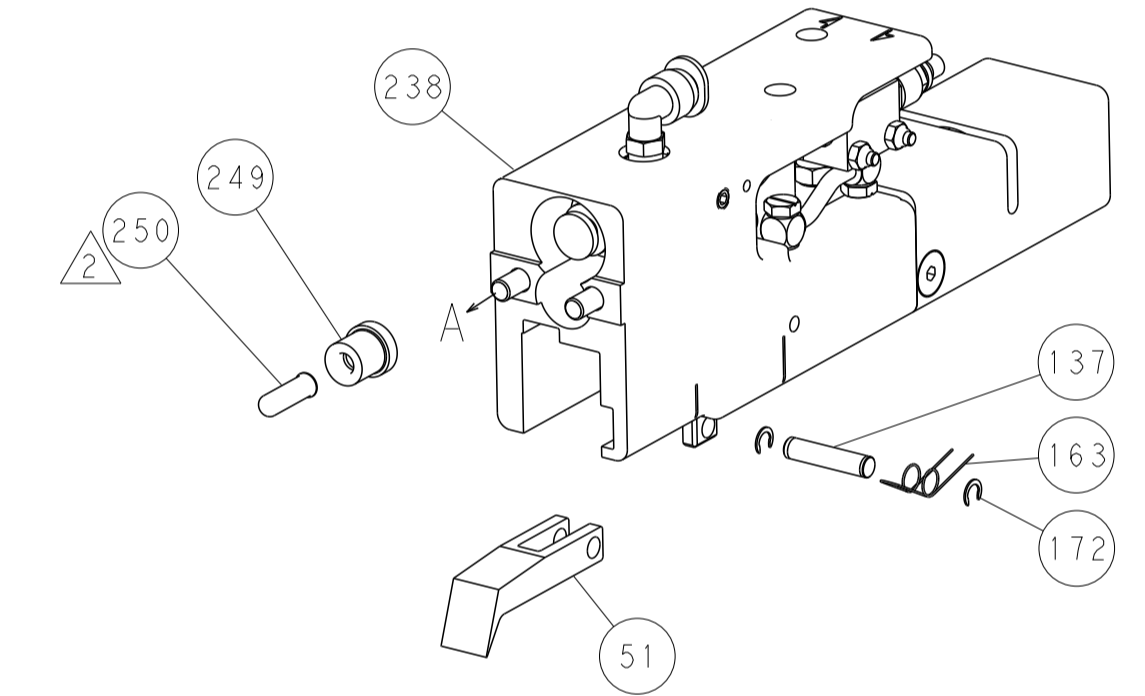
LOC		DIST		REVISIONS			
A	66	P	LTH	DESCRIPTION	DATE	OWN	APVD
				SEE SHEET 1			



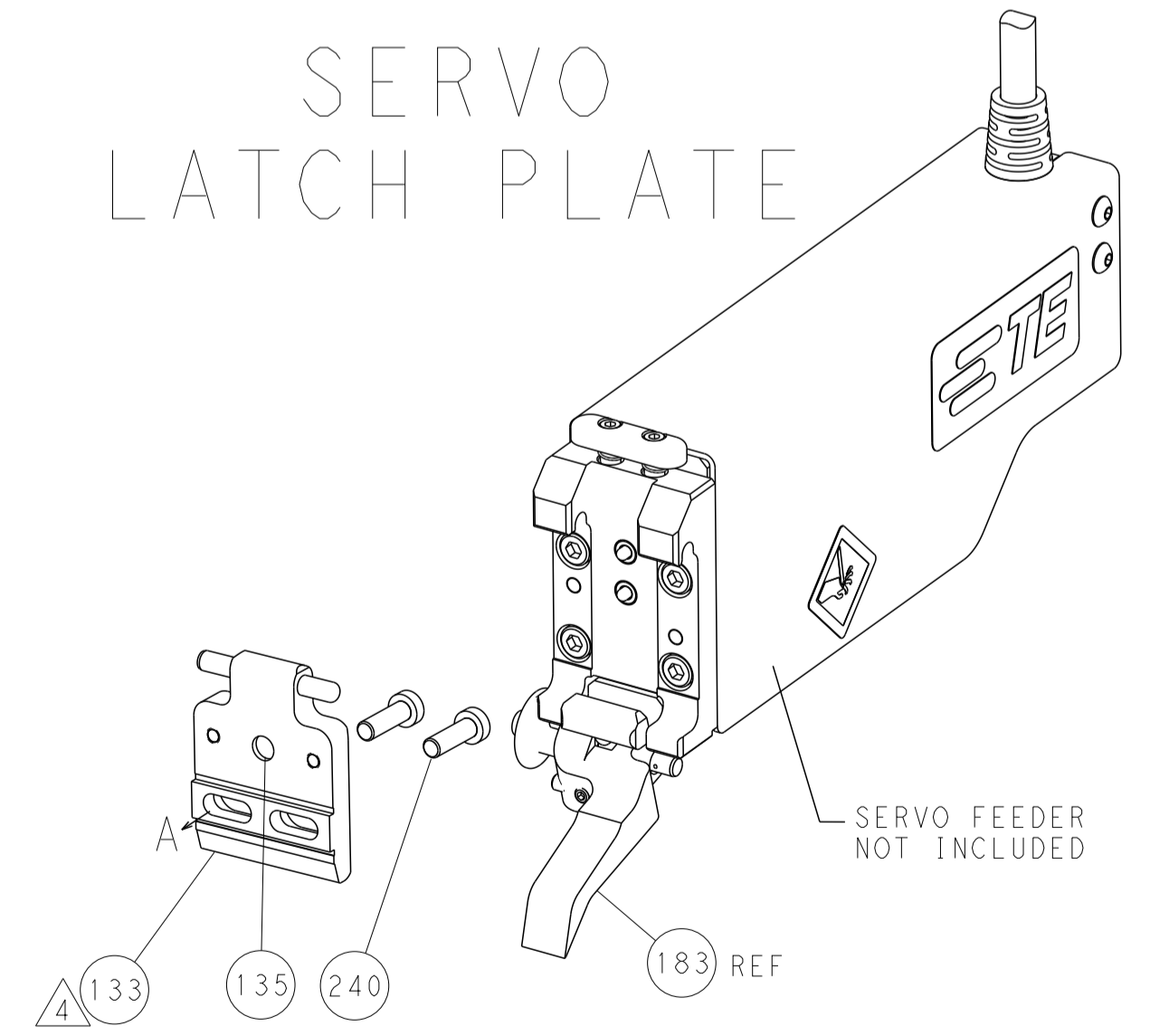
FEED TYPE
MECHANICAL



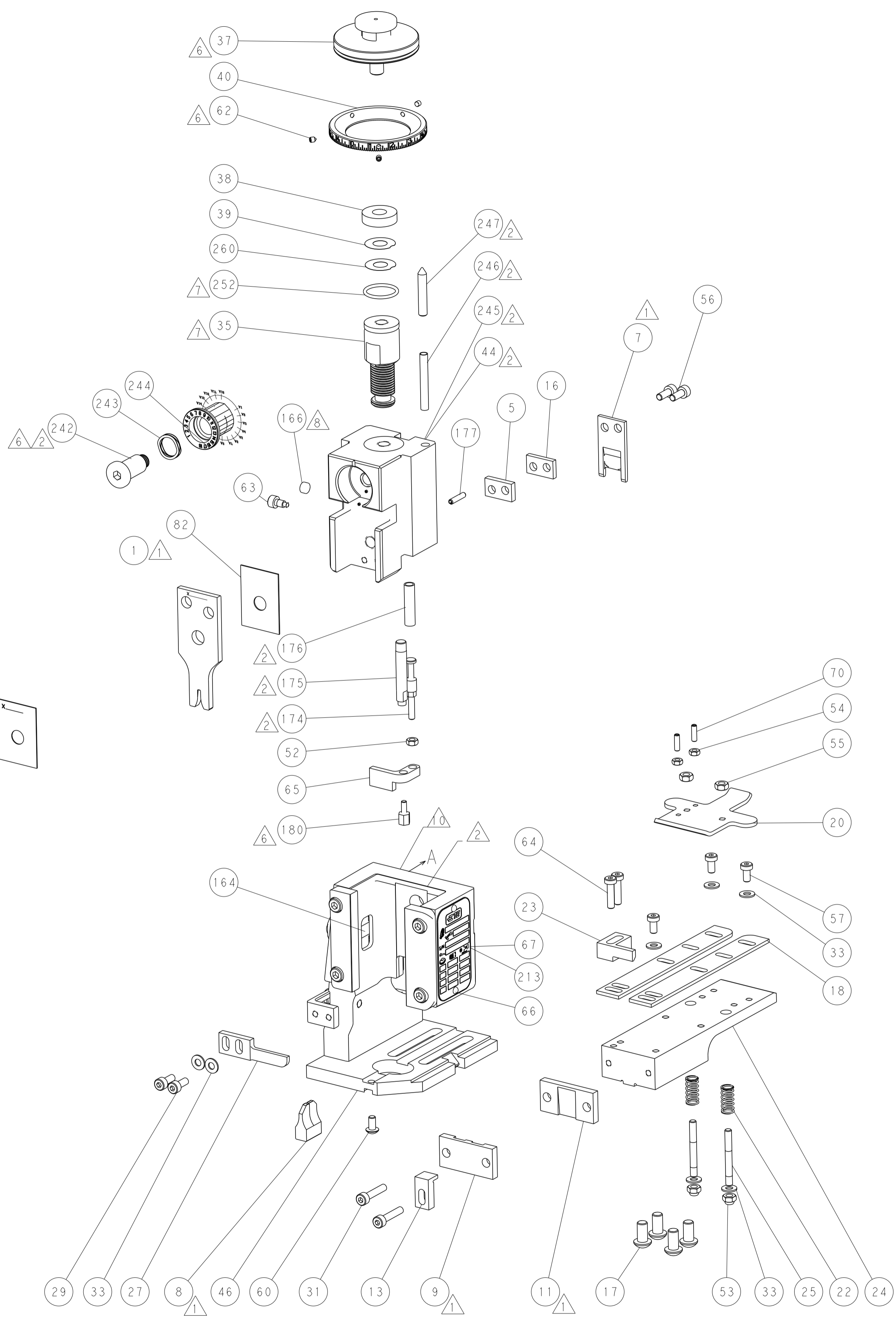
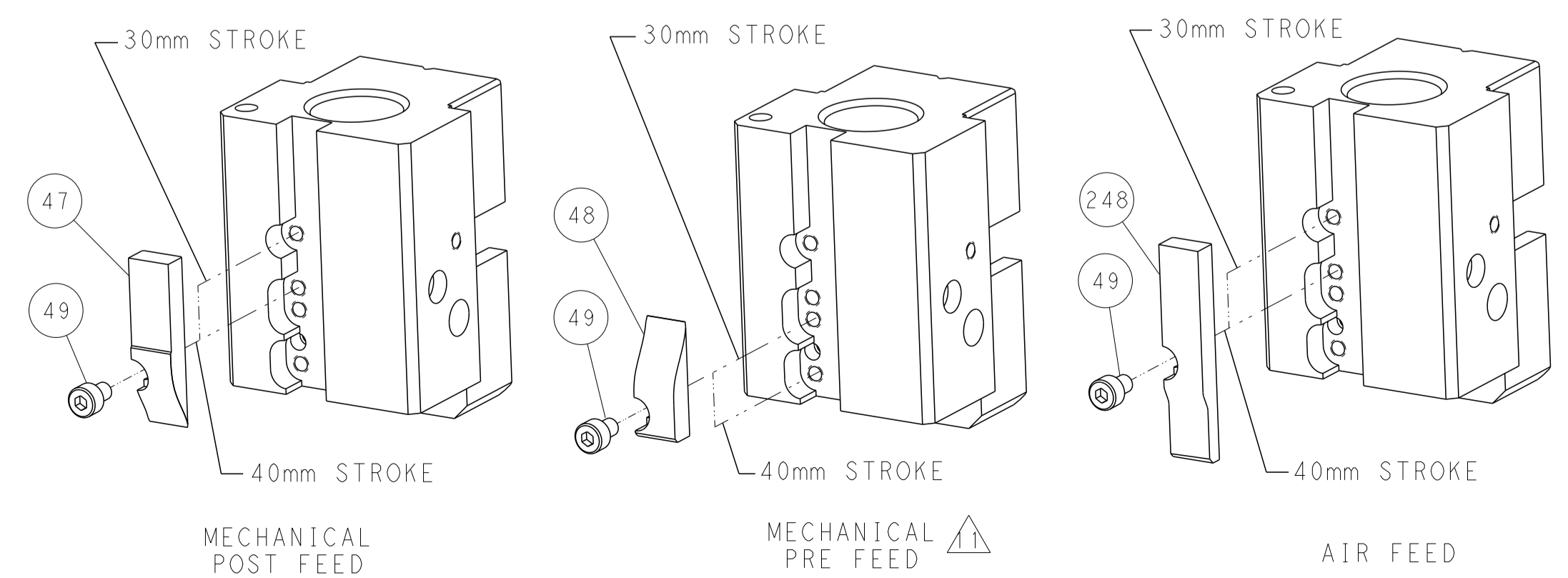
PNEUMATIC



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: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.5 1 PLC ±0.5 2 PLC ±0.13 3 PLC ±0.013 4 PLC ±0.001 ANGLES ±.0001 FINISH		DWN T. YIN 10SEP2014 CHK G. BAILEY 10SEP2014 APVD JJ. GUO 10SEP2014 PRODUCT SPEC APPLICATION SPEC WEIGHT Customer Accessible Production Drawing		NAME Ocean End Feed Applicator SIZE CAGE CODE DRAWING NO A1 00779 C=2150485 SCALE 1:1 SHEET 2 OF 4 REV A		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	-
	2-2150485-1	A	FINE CRIMP HEIGHT ADJUST	MECHANICAL	SERVO LATCH PLATE	2119951-1	1901697-1	8-2150485-5	-	-	2168400-7 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2150485-4	-	-	-
					MECHANICAL FEED	2119949-1	2063961-1	5-18022-5	2119653-2	-	-
	2-2150485-2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	SERVO LATCH PLATE	2119951-1	1901697-1	8-2150485-5	-	-	2168400-7 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2150485-4	-	-	-
					MECHANICAL FEED	2119949-1	2063961-1	5-18022-5	2119653-2	-	-
	2-2150485-5	A	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE	2119950-1	2119792-2	-	-	2119641-2	-	2063440-1
	2-2150485-7	A	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	-
	7-2150485-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-

APPLICATOR DATA		
CRIMP SIZE	TYPE	
WIRE 1.78 mm [.070]	F	
INSUL 2.50 mm [.098]	F	
APPL INSTRUCTIONS 408-10390		

TERMINAL DATA: STEWART WARNER TERMINATOR CRIMP SPECIFICATION			
TERMINAL NAME: 6.3 TERMINAL SELF LOCKING RECEPTACLE			
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE		
4.65-5.42 mm [.183-.213 IN]	1.70mm MAX [.067 IN MAX]		
TERMINAL APPLICATION SPECIFICATION	NONE	-	-
TERMINALS APPLIED			
TE TERMINAL	STEWART WARNER TERMINAL	TE TERMINAL	STEWART WARNER TERMINAL
2113585-1	SO.481.622	2113585-2	172773

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
18 AWG	1.44 +/- 0.05 [.057 +/- .002]	6.8



- 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: 8-2150485-4
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150485-4
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150485-5
- 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.

ITEM NO	DESCRIPTION	ITEM NO
251	FINE ADJUST HEAD ASM, PACIFIC STYLE	2119782-1
250	PUSH ROD, AIR FEED	2119640-1
249	BUSHING, LCH5-12, MISUMI	2079988-1
246	SPRING, COMPRESSION	1-22279-3
244	CAM, SNAIL, INSULATION ADJUSTMENT	2119082-1
243	WASHER, WAVE SPRING, CREST-TO-CREST	2079764-1
242	RETAINER, INSULATION DIAL	2119083-1
	PART NO	DESCRIPTION

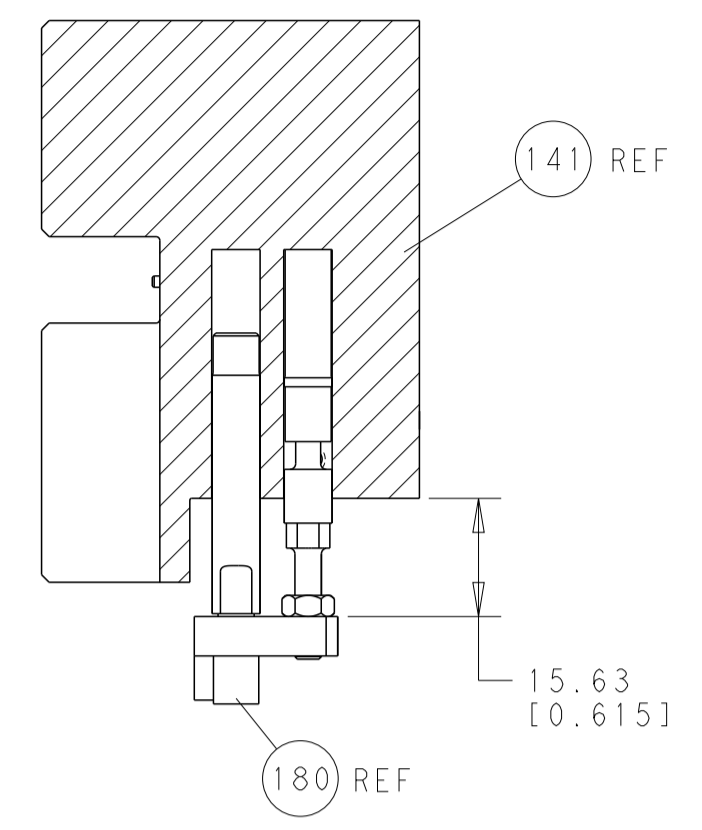
PACIFIC VERSION
 Shown on sheets 3 of 4 & 4 of 4
 (Atlantic version shown on sheets 1 of 4 & 2 of 4)

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

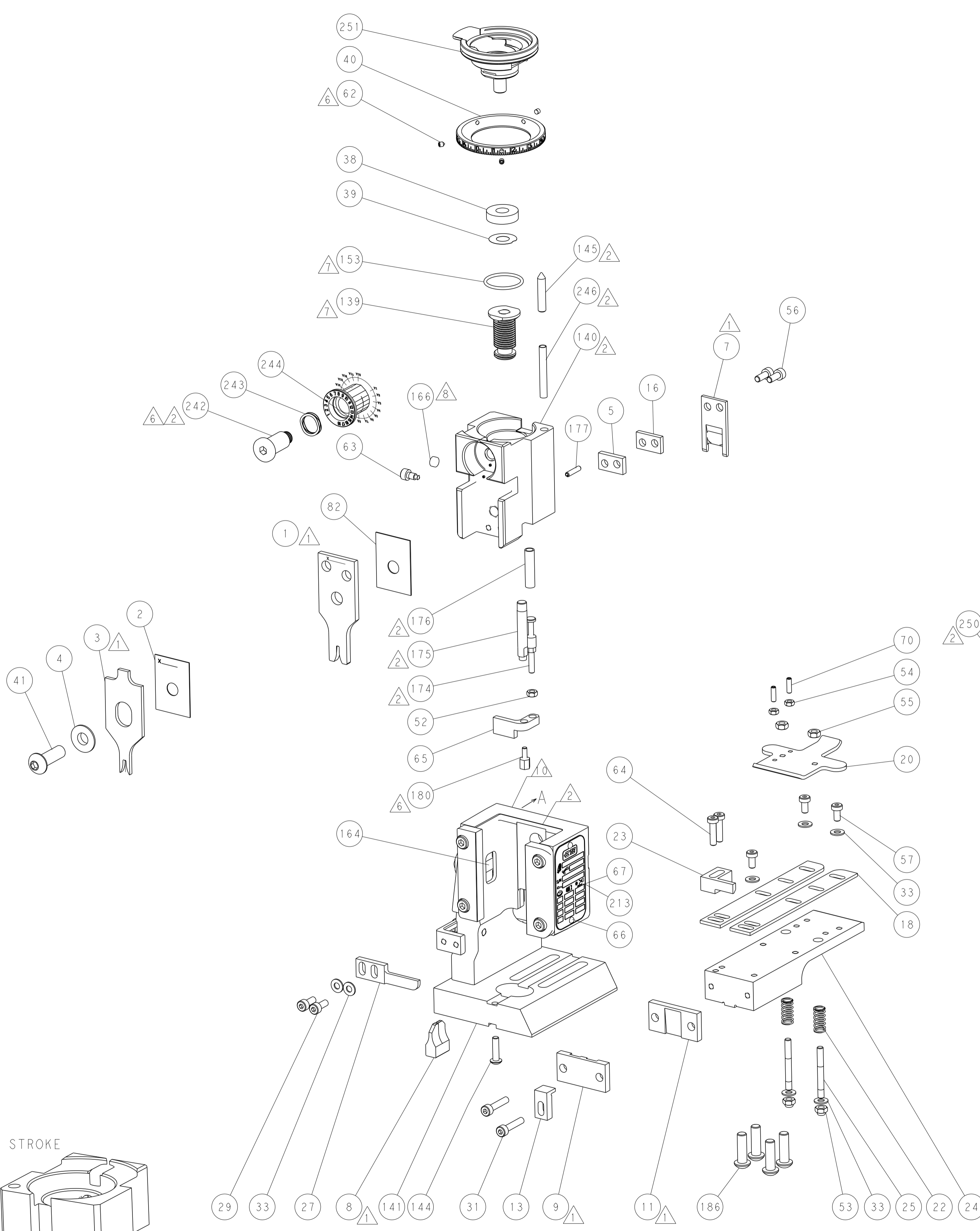
REV	DATE	BY	APPV	DESCRIPTION	DATE	BY	APPV
-	-	2	-	-	2168400-7	SHCS, LOW HEAD, RoHS, M5 X 10	240
-	-	-	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	-	-	-	1	2063440-1	AIR FEED MODULE	238
-	-	1	-	-	2119740-2	TAG, IDENTIFICATION	213
-	4	4	4	4	2079383-9	SCR, BHSC, RoHS (M6 X 20)	186
-	-	REF	-	-	1901697-1	FEED FINGER ASSEMBLY, EF	183
-	1	1	1	1	1-1752354-0	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	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	2168400-8	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	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	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	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	1901259-4	GUIDE, LOWER STRIP	18
-	1	1	1	1	5-240641-2	SPACER	16
-	1	1	1	1	1752360-1	SPACER, HOLD-DOWN	13
-	1	1	1	1	240644-1	PLATE, REAR SHEAR	11
-	-	-	-	-	-	-	10
-	1	1	1	1	690482-6	PLATE, FRONT SHEAR	9
-	1	1	1	1	1-1803059-4	ANVIL, COMBINATION, END FEED	8
-	1	1	1	1	2217206-4	BLADE, SLUG	7
-	-	-	-	-	-	-	6
-	1	1	1	1	240641-1	SPACER	5
-	1	1	1	1	238009-4	BLOCK, FL CRIMPER SPACER	4
-	1	1	1	1	4-1633961-5	CRIMPER, INSULATION F PREMIUM	3
-	1	1	1	1	455888-4	SPACER, CRIMPER	2
-	1	1	1	1	3-456404-9	CRIMPER, WIRE PREMIUM	1
-77-27-25-22-21	PART NO	DESCRIPTION	ITEM NO				

DIMENSIONS:	TOLERANCES UNLESS OTHERWISE SPECIFIED:	DRAWN:	CHK:	DATE:	NAME:	SIZE:	CAGE CODE:	DRAWING NO:	RESTRICTED TO:
mm	0 PLC ±.05 1 PLC ±.05 3 PLC ±.013 4 PLC ±.013 ANGLES ±.0001 FINISH	Y. LIN	G. BAILEY	10SEP2014	TE Connectivity Harrisburg, PA 17105-3608	A1	00779	2150485	-
MATERIAL:					Customer Accessible Production Drawing				

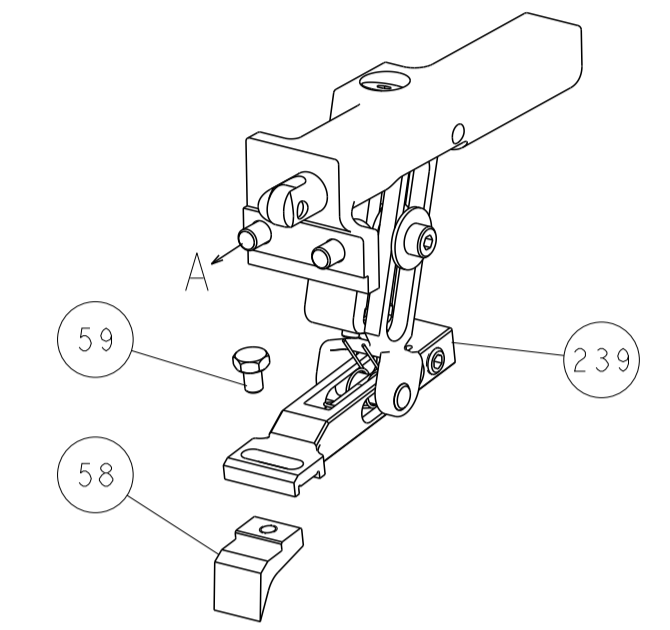
LOC		DIST		REVISIONS			
A	66	P	LTM	DESCRIPTION	DATE	OWN	APVD
		-		SEE SHEET 1			



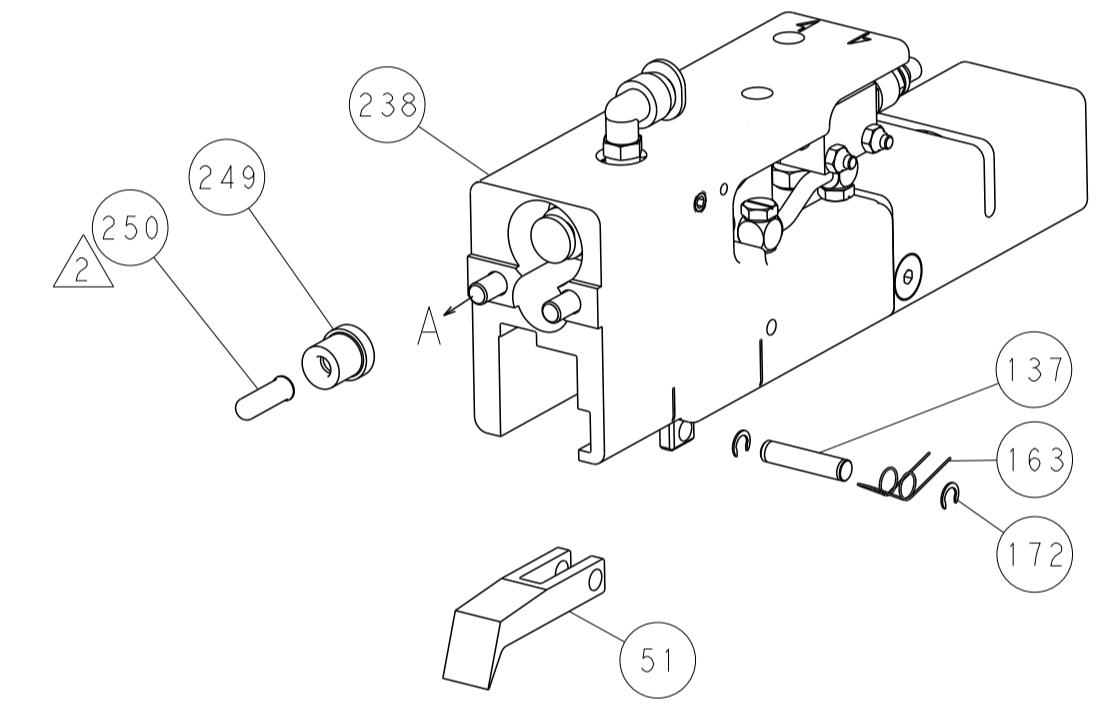
HOLDDOWN SET-UP



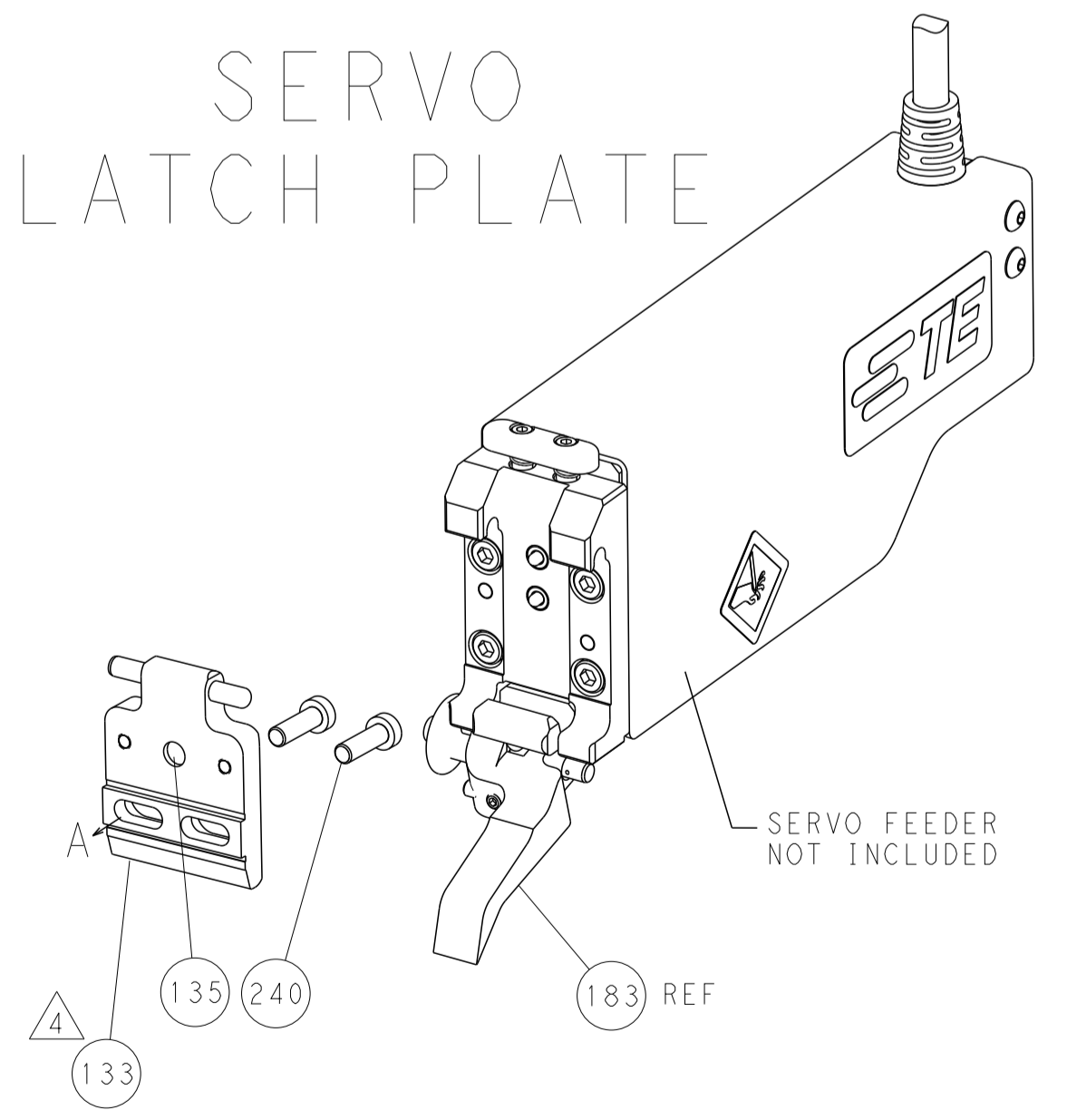
FEED TYPE
MECHANICAL



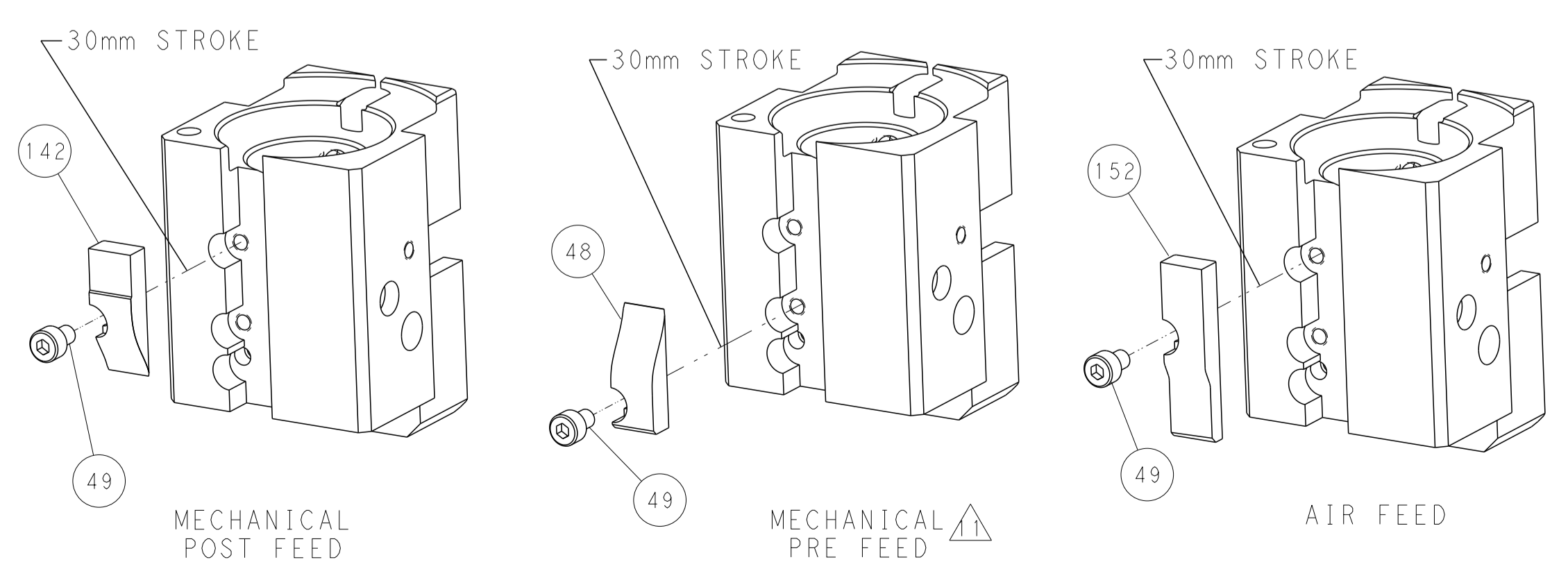
PNEUMATIC



SERVO LATCH PLATE



CAM POSITIONS



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 Y. YIN 10SEP2014		STE TE Connectivity	
mm	0 PLC ±0.5	1 PLC ±0.5	2 PLC ±0.13	3 PLC ±0.013	4 PLC ±0.001	ANGLES ±0.001	FINISH
MATERIAL:		APVD U. GUO 10SEP2014	NAME G. BAILEY	PRODUCT SPEC	APPLICATION SPEC	SIZE	CAGE CODE
		WEIGHT	A1 00779	SCALE 1:1	SHEET 4 OF 4	REV A	RESTRICTED TO