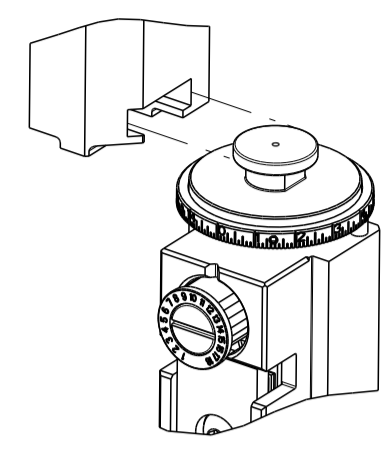
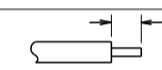
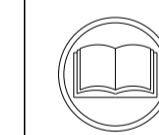


ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART						
					CONVERT TO	PART NUMBERS REQUIRED					
	2150339-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL	PNEUMATIC FEED	2119950-1	2119792-2	-	2119641-1	-	2063440-1
					SERVO LATCH PLATE	2119951-1	1901697-1	8-2150339-5	-	-	2168400-7 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2150339-4	-	-	-
	2150339-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	MECHANICAL FEED	2119949-1	2063961-1	5-18022-5	2119653-1	-	-
					SERVO LATCH PLATE	2119951-1	1901697-1	8-2150339-5	-	-	2168400-7 (QUANTITY 2)
	2150339-5	B	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
2150339-6	B	NON-CRIMP HEIGHT ADJUST	SERVO LATCH PLATE	-	-	-	-	-	-	-	
2150339-7	B	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	-	
7-2150339-7	B	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-	

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.54 mm [.100]	F
INSUL	4.40 mm [.173]	F
APPL INSTRUCTIONS 408-10390		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION
TERMINAL NAME: 6.3 SRS F-SPRING LIF RECEPTACLE		
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE
5.90-6.90 mm [.232-.272 IN]		Ø3.00-4.30 mm [.118-.169 IN]
TERMINAL APPLICATION SPECIFICATION	114-64027	
TERMINALS APPLIED		
TE TERMINAL	TE TERMINAL	TE TERMINAL
2178300-1		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
14 AWG	1.85+/-0.05 [.073+/- .002]	6.2
16 AWG	1.64+/-0.05 [.065+/- .002]	8.5
18 AWG	1.52+/-0.05 [.060+/- .002]	9.7



- 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: 8-2150339-4
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150339-4
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150339-5
 SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2150339-6
- 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 ITEM 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 & 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.

-77	-7	-6	-5	-2	-1	PART NO	DESCRIPTION	ITEM NO
-	-	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	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244

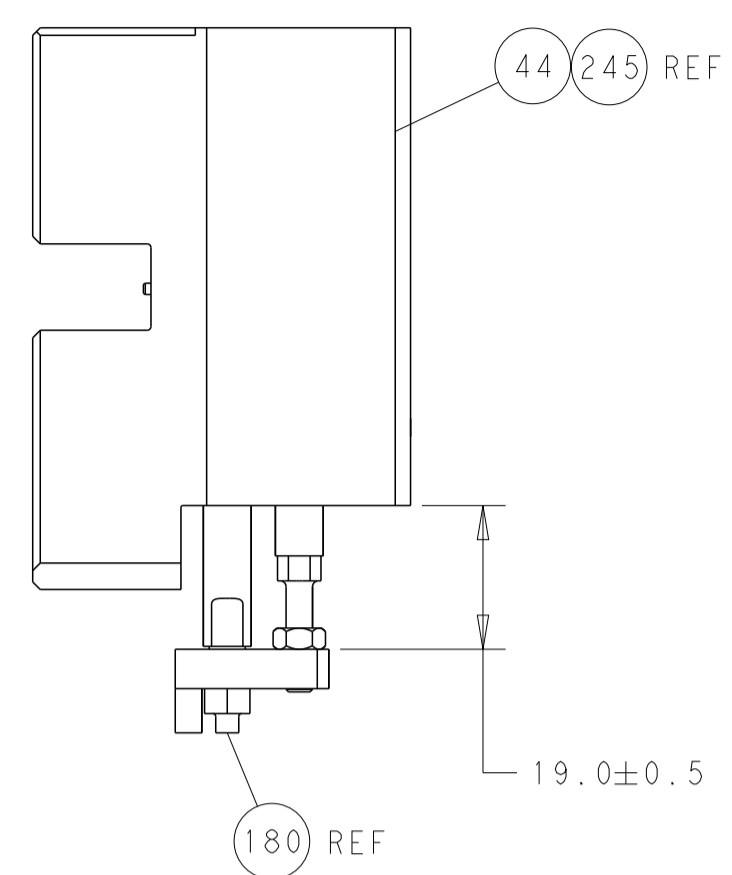
ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

SET UP GAUGE	LOC	DIST	REVISIONS					
2119599-2	A	66	P	LTN	DESCRIPTION	DATE	OWN	APVD
			B		ECR-15-012277	18AUG2015	MR	JDG

-	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
-	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	455888-6	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	1901681-5	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	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	-	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	690482-3	PLATE, FRONT SHEAR	9
-	1	1	1	1	1	1-1803001-8	ANVIL, COMBINATION, END FEED	8
-	1	1	1	1	1	1-2217206-3	BLADE, SLUG	7
-	-	-	-	-	-	-	-	6
-	1	1	1	1	1	2-240641-9	SPACER	5
-	1	1	1	1	1	2-238009-9	BLOCK, FL CRIMPER SPACER	4
-	1	1	1	1	1	1803223-3	CRIMPER, INSULATION F PREMIUM	3
-	1	1	1	1	1	455888-1	SPACER, CRIMPER	2
-	1	1	1	1	1	8-1633730-9	CRIMPER, WIRE	1

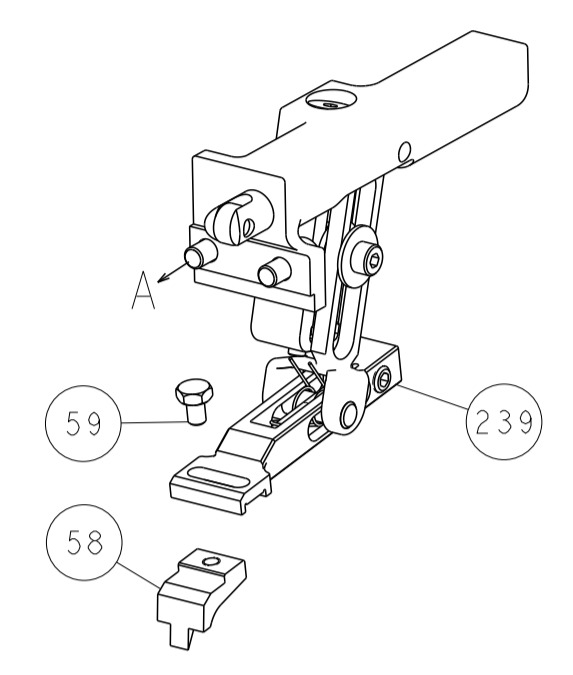
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG		NAME	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	5 PLC ±	6 PLC ±
	ANGLES	FINISH		DATE	CHK	APVD	PRODUCT SPEC
MATERIAL				06MAY2013	H. HUANG	U. GUO	06MAY2013
				06MAY2013	L. ZHANG		
							APPLICATION SPEC
							WEIGHT
							RESTRICTED TO
							Customer Accessible Production Drawing
							SCALE 1:1 SHEET 1 OF 4 REV B

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

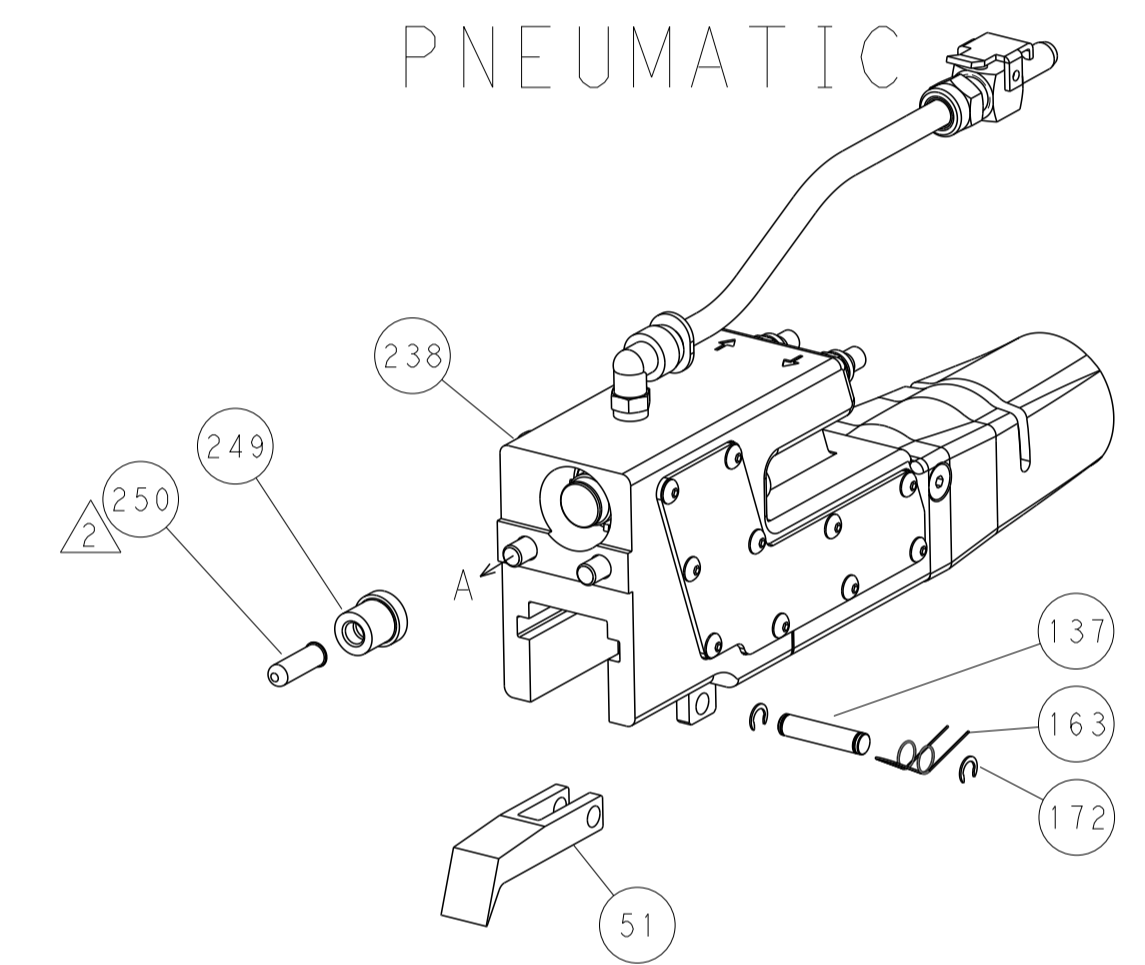


HOLDDOWN SET-UP

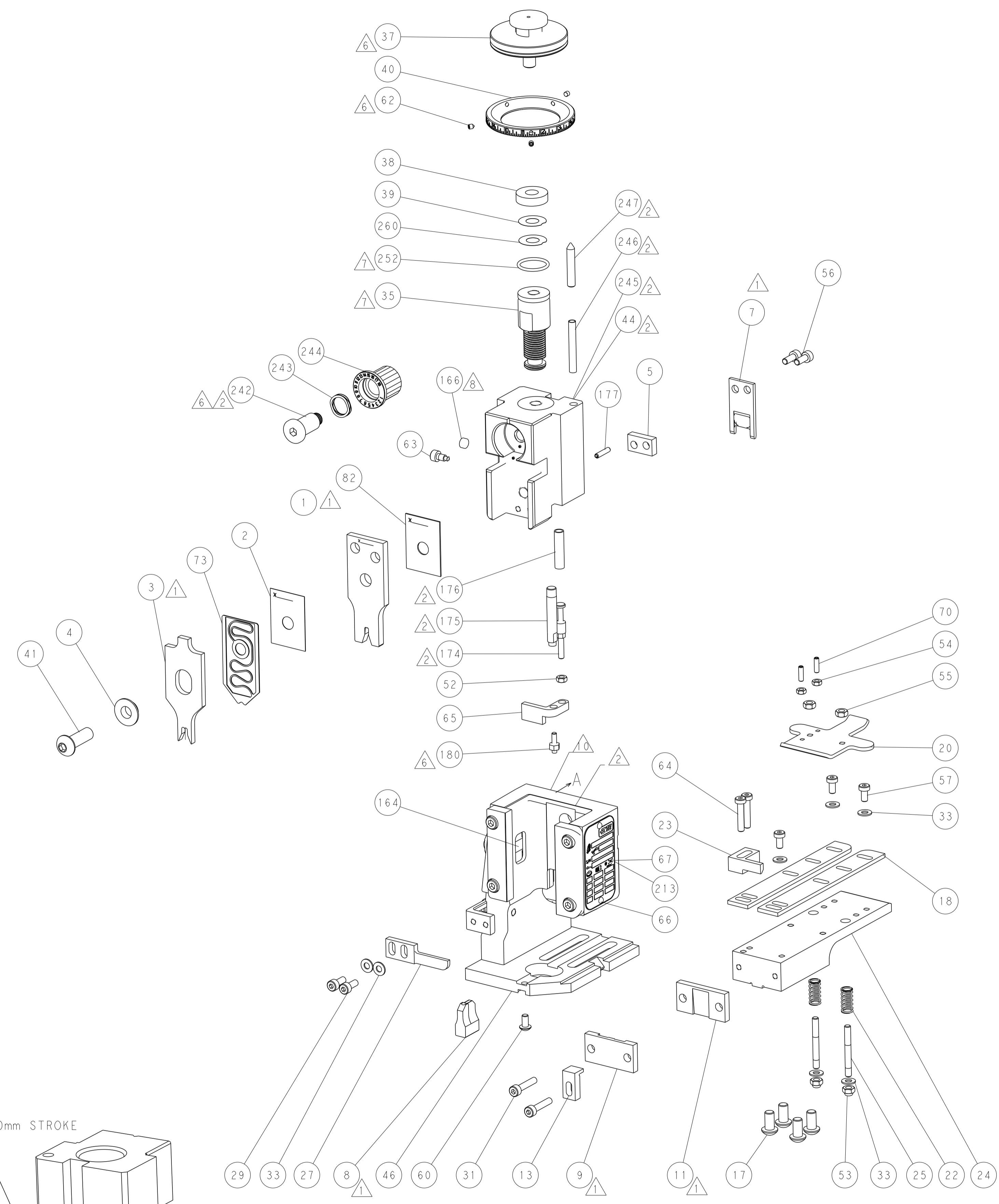
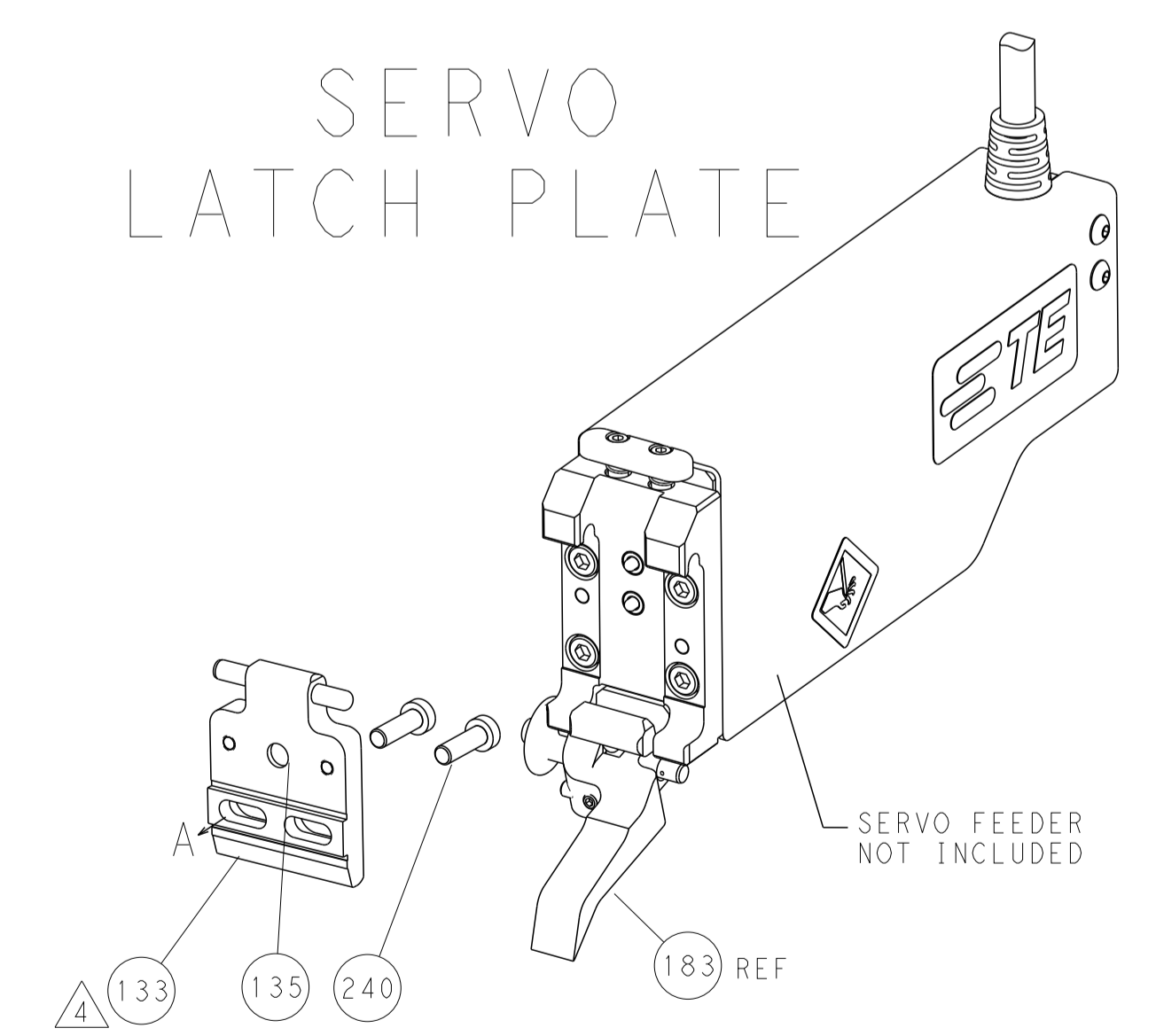
FEED TYPE
MECHANICAL



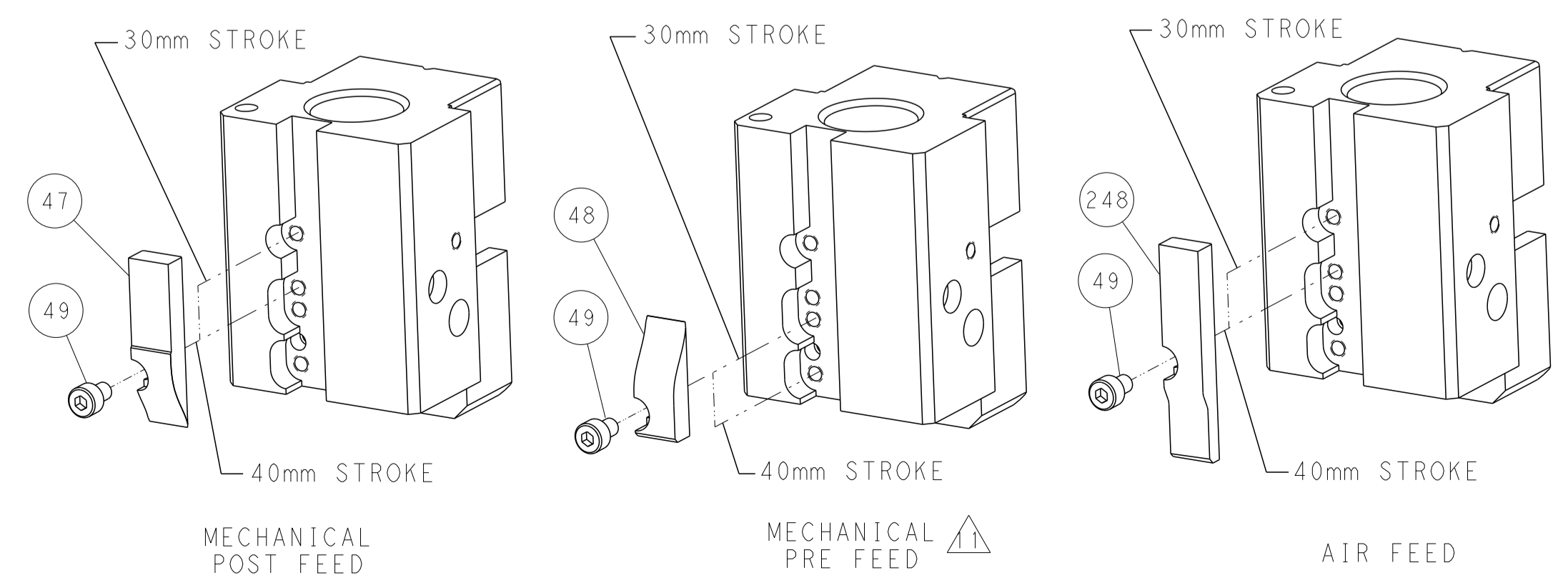
PNEUMATIC



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: K. HUANG 06MAY2013		TE Connectivity	
mm		0 PLC ±0.5		CHK: L. ZHANG 06MAY2013		Harrisburg, PA 17105-3608	
Ø		1 PLC ±0.13		APVD: J. GUO 06MAY2013		NAME: Ocean End Feed Applicator	
H		2 PLC ±0.013		PRODUCT SPEC		SIZE: CAGE CODE: DRAWING NO:	
D		3 PLC ±0.001		APPLICATION SPEC		RESTRICTED TO:	
R		4 PLC ±0.001		WEIGHT		A1 00779 ©=2150339	
ANGLES		FINISH		Customer Accessible Production Drawing		SCALE: 1:1 SHEET 2 OF 4 REV B	

PACIFIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART						
					CONVERT TO	PART NUMBERS REQUIRED					
	2-2150339-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL	PNEUMATIC FEED	2119950-1	2119792-2	-	2119641-2	-	2063440-1
					SERVO LATCH PLATE	2119951-1	1901697-1	8-2150339-5	-	-	2168400-7 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2150339-4	-	-	-
	2-2150339-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	MECHANICAL FEED	2119949-1	2063961-1	5-18022-5	2119653-2	-	-
					SERVO LATCH PLATE	2119951-1	1901697-1	8-2150339-5	-	-	2168400-7 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2150339-4	-	-	-
	2-2150339-5	B	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
	2-2150339-7	B	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	-
	7-2150339-7	B	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-

APPLICATOR DATA		
CRIMP SIZE	TYPE	
WIRE 2.54 mm (.100)	F	
INSUL 4.40 mm (.173)	F	
APPL INSTRUCTIONS 408-10390		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION
TERMINAL NAME: 6.3 SRS F-SPRING LIF RECEPTACLE		
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE
5.90-6.90 mm (.232-.272 IN)		3.00-4.30 mm (.118-.169 IN)
TERMINAL APPLICATION SPECIFICATION	114-64027	
TERMINALS APPLIED		
TE TERMINAL	TE TERMINAL	TE TERMINAL
2178300-1		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
14 AWG	1.85 +/- 0.05 [0.073 +/- .002]	6.2
16 AWG	1.64 +/- 0.05 [0.065 +/- .002]	8.5
18 AWG	1.52 +/- 0.05 [0.060 +/- .002]	9.7

- 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: 8-2150339-4
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150339-4
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150339-5
- 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 ITEM 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
- 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	2119082-9 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
-77-27-25-22-21	PART NO	DESCRIPTION

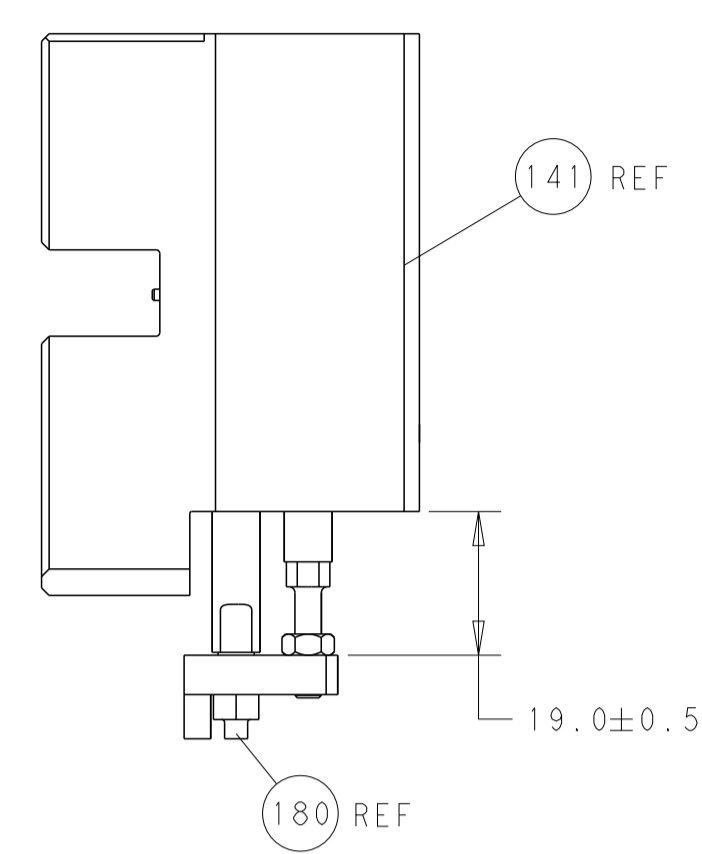
PACIFIC VERSION
 Shown on sheets 3 of 4 & 4 of 4
 (Atlantic version shown on sheets 1 of 4 & 2 of 4)

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

REV	DATE	BY	APPD	DESCRIPTION	DATE	BY	APPD
-	-	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	2079383-9	SCR, BHSC, RoHS (M6 X 20)		186
-	-	REF	-	1901697-1	FEED FINGER ASSEMBLY, EF		183
-	-	1	1	1976055-8	STANDOFF, HOLD-DOWN		180
-	-	1	1	6-993111-6	PIN, SLOTTED SPRING 3.0 X 14.0		177
-	-	1	1	8-22280-7	SPRING, COMPRESSION		176
-	-	1	1	1752353-2	GUIDE PIN, HOLDDOWN		175
-	-	1	1	1901680-2	GUIDE PIN, HOLDDOWN		174
-	-	-	2	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT		172
-	-	1	1	994969-1	MAGNET, RARE EARTH HIGH ENERGY		166
-	-	REF	REF	994970-2	COUNTER, MAGNETIC		164
-	-	-	1	240638-1	SPRING, FEED FINGER		163
-	-	1	1	8-21084-1	O-RING, .801 ID, .070 DIA. MAT.		153
-	-	-	1	2119641-2	FEED CAM, AIR FEED		152
-	-	1	1	2119798-2	DETENT PIN		145
-	-	1	1	2079383-8	SCR, BHSC, RoHS (M4 X 16)		144
-	-	-	1	2119653-2	FEED CAM, POST FEED		142
-	-	1	1	2119655-6	APPLICATOR BASIC ASSEMBLY, EF		141
-	-	1	1	2119651-1	RAM, ASIAN STYLE, END FEED		140
-	-	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	455888-6	SPACER, CRIMPER		82
-	-	1	1	2119791-9	DEPRESSOR, WIRE		73
-	-	1	1	2119956-2	DOCUMENTATION PACKAGE		71
-	-	2	2	2-18032-2	SCR, SET, FLT POINT M3 X 10.0		70
-	-	1	-	2119740-1	TAG, IDENTIFICATION		67
-	-	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188		66
-	-	1	1	1901681-5	HOLDDOWN, TERMINAL		65
-	-	2	2	2168400-5	SHCS, LOW HEAD, RoHS, M4 X 20		64
-	-	1	1	2119793-1	LIMITER, ADJUSTMENT BOLT		63
-	-	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	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8		57
-	-	2	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10		56
-	-	2	2	5018030-2	NUT, HEX, REG, RoHS, M4		55
-	-	2	2	5018030-1	NUT, HEX, REG, RoHS, M3		54
-	-	2	2	986965-8	NUT, LOCK, HEX, TORQUE (M4)		53
-	-	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	1	2079383-7	SCR, BHSC, RoHS (M8 X 25)		41
-	-	1	1	2119645-1	DISC, NUMBERED FA WIRE ADJUSTMENT		40
-	-	1	1	2119957-1	APPLICATOR SHIM PACK		39
-	-	1	1	1-2119644-2	RAM WASHER, PRECISION		38
-	-	7	7	1-18028-2	WASHER, FLAT, REG M4		33
-	-	2	2	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20		31
-	-	2	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10		29
-	-	1	1	240639-1	STRIPPER (MACHINING)		27
-	-	2	2	1320906-1	STUD, THREADED		25
-	-	1	1	1752371-5	PLATE, STRIP GUIDE		24
-	-	1	1	240825-1	PLATE, STRIP HOLD DOWN		23
-	-	2	2	2-22281-3	SPRING, COMPRESSION		22
-	-	1	1	1752373-4	DRAG		20
-	-	2	2	1901259-5	GUIDE, LOWER STRIP		18
-	-	1	1	1752360-1	SPACER, HOLD-DOWN		13
-	-	1	1	240644-9	PLATE, REAR SHEAR		11
-	-	-	-	-	-		10
-	-	1	1	690482-3	PLATE, FRONT SHEAR		9
-	-	1	1	1-1803001-8	ANVIL, COMBINATION, END FEED		8
-	-	1	1	1-2217206-3	BLADE, SLUG		7
-	-	-	-	-	-		6
-	-	1	1	2-240641-9	SPACER		5
-	-	1	1	2-238009-9	BLOCK, FL CRIMPER SPACER		4
-	-	1	1	1803223-3	CRIMPER, INSULATION F PREMIUM		3
-	-	1	1	455888-1	SPACER, CRIMPER		2
-	-	1	1	8-1633730-9	CRIMPER, WIRE		1
-77-27-25-22-21	PART NO	DESCRIPTION	ITEM NO				

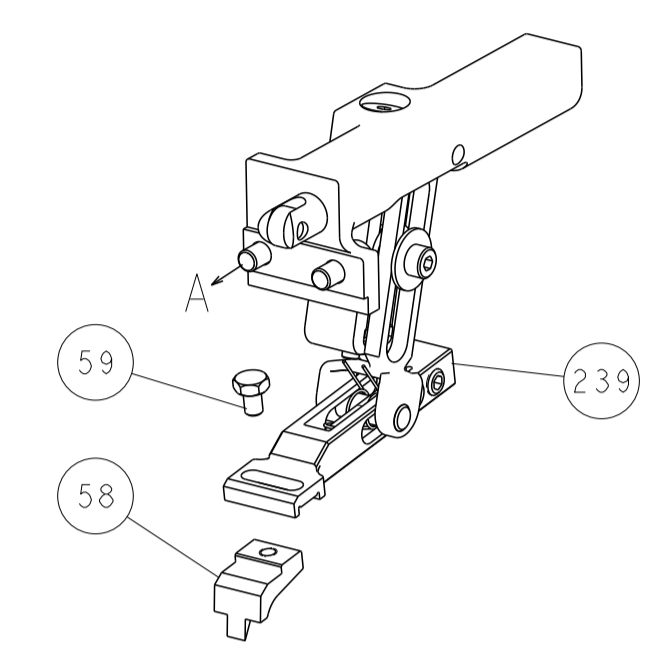
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG		CHK		APPD		NAME	
mm	0 PLC ±.5	1 PLC ±.3	2 PLC ±.2	3 PLC ±.15	4 PLC ±.1	5 PLC ±.08	6 PLC ±.05	7 PLC ±.03	8 PLC ±.02	9 ANGLE ±.0001	FINISH
MATERIAL		FINISH		SCALE		SHEET		OF		REV	
				1:1		3		4		B	

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

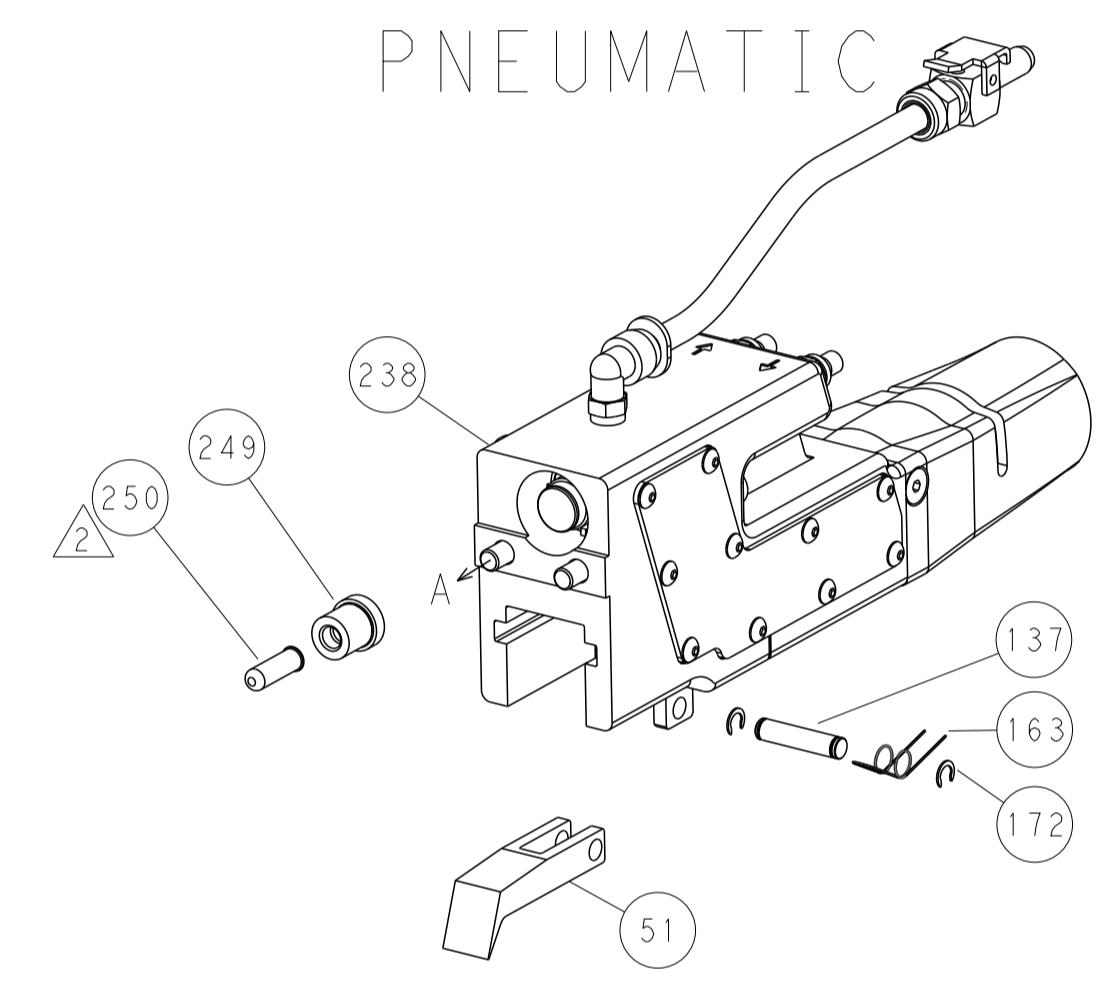


HOLDDOWN SET-UP

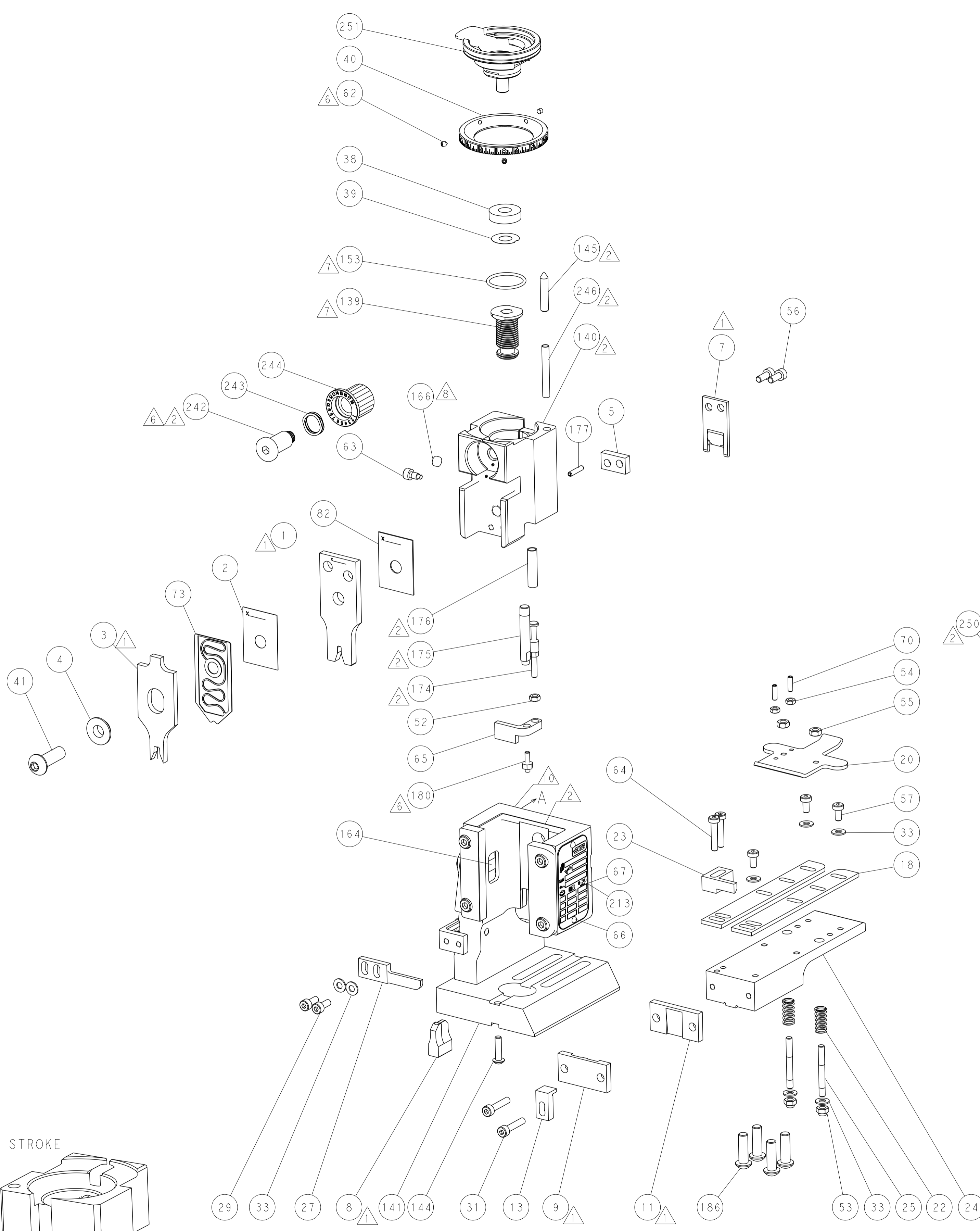
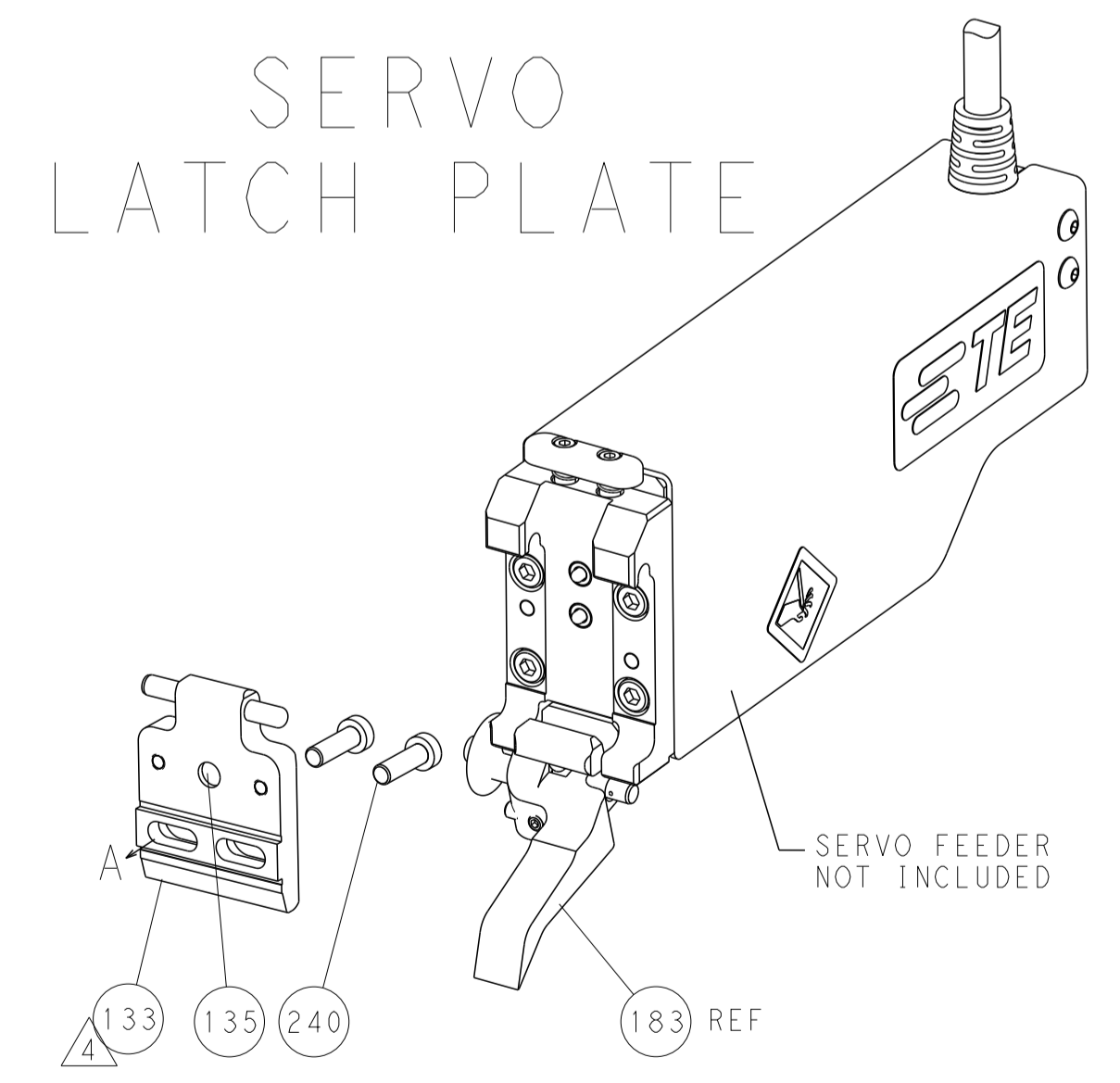
FEED TYPE
MECHANICAL



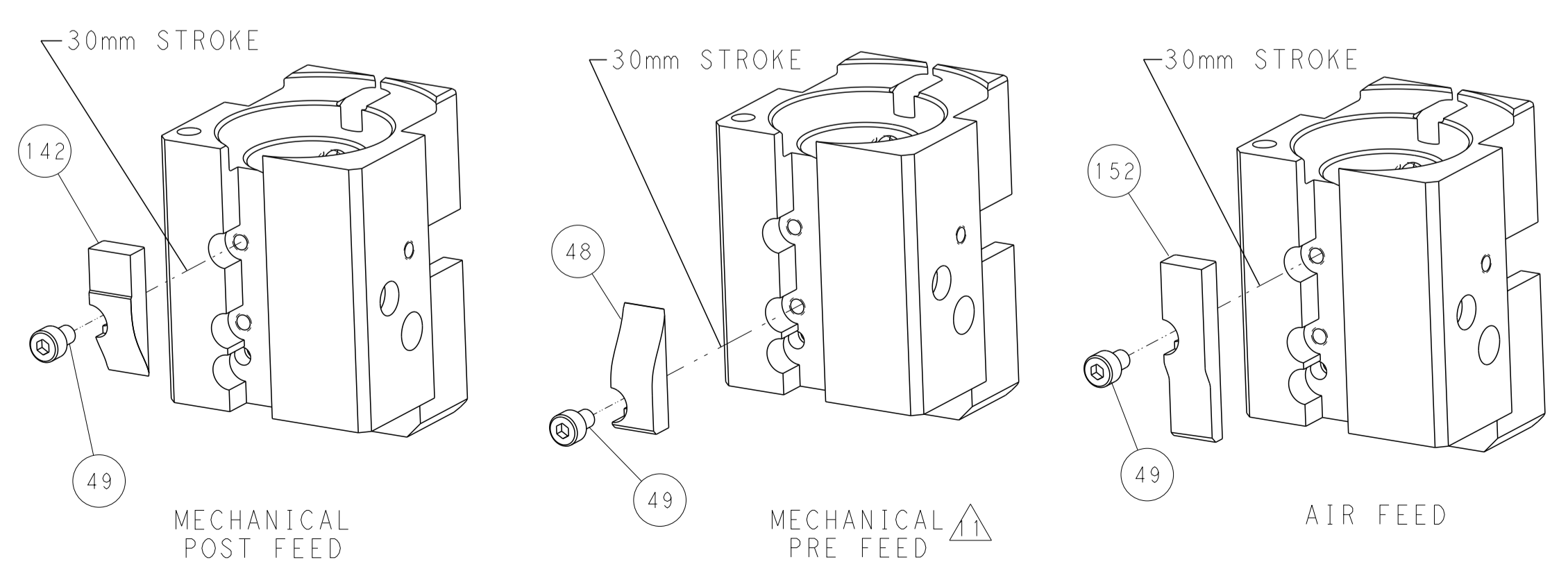
PNEUMATIC



SERVO
LATCH PLATE



CAM POSITIONS



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:		OWN: H. HUANG 06MAY2013		STE 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 06MAY2013	Harrisburg, PA 17105-3608
MATERIAL:	FINISH:	WEIGHT:	SCALE:	SIZE:	CAGE CODE:	DRAWING NO:	RESTRICTED TO:
			1:1	A1	00779	2150339	
Customer Accessible Production Drawing				SHEET 4 OF 4 REV B			