

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	CONVERT TO	PART NUMBERS REQUIRED					
	2150177-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL	PNEUMATIC FEED	2119950-1	2119792-2	-	2119641-1	-	2063440-1
	2150177-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	SERVO LATCH PLATE	2119951-1	1901697-1	8-2150177-5	-	-	2168400-7 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2150177-4	-	-	-
					MECHANICAL FEED	2119949-1	2063961-1	5-18022-5	2119653-1	-	-
	2150177-5	C	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE ⁴	SERVO LATCH PLATE	2119951-1	1901697-1	8-2150177-5	-	-	2168400-7 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2150177-4	-	-	-
					MECHANICAL FEED	2119949-1	2063961-1	5-18022-5	2119653-1	-	-
2150177-6	C	NON-CRIMP HEIGHT ADJUST	SERVO LATCH PLATE ⁴	PNEUMATIC FEED	2119950-1	2119792-2	-	2119641-1	-	2063440-1	
				-	-	-	-	-	-	-	
2150177-7	C	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	-	
7-2150177-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-	

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.79 mm [.110]	F
INSUL	4.57 mm [.180]	F
APPLICATOR INSTRUCTIONS 408-10390		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: RECEPTACLE, POSITIVE-LOCK, .250 SERIES			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
4.30-5.10 mm [.169-.201 IN]		Ø2.29-3.94 mm [.090-.155 IN]	
TERMINAL APPLICATION SPECIFICATION	114-2074	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
1217094-1	1217094-2		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
14 AWG	1.57+/-0.05 [.062+/-0.002]	4.5
16 AWG	1.37+/-0.05 [.054+/-0.002]	7.0
18 AWG	1.24+/-0.05 [.049+/-0.002]	8.5

- 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: 8-2150177-4
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150177-4
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150177-5
 SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2150177-6
- 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 50 & 62. 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 50 & 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.

-77	-7	-6	-5	-2	-1	PART NO	DESCRIPTION	ITEM NO
-	-	1	-	-	-	2119957-2	APPLICATOR SHIM PACK	260
-	-	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

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	APPV
			A	RELEASE	04JUN2012	L.Z S.X
			B	ECR-13-009877	19JUN2013	BH TE
			C	ECR-14-011567	05AUG2014	YY TE

REV	DATE	BY	APPV	DESCRIPTION	DATE	OWN	APPV	
-	-	-	-	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
-	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	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
-	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
-	4	4	4	4	4	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57
-	2	2	2	2	2	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	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	1	1	1	1	1-1752354-2	STANDOFF, HOLD-DOWN	50
-	-	-	-	-	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	2119644-1	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
-	8	8	8	8	8	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	1752371-1	PLATE, STRIP GUIDE	24
-	2	2	2	2	2	2-22281-3	SPRING, COMPRESSION	22
-	1	1	1	1	1	1752373-1	DRAG	20
-	2	2	2	2	2	1-1901259-0	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
-	1	1	1	1	1	690482-4	PLATE, FRONT SHEAR	9
-	1	1	1	1	1	1633386-2	ANVIL, COMBINATION	8
-	1	1	1	1	1	1-690474-7	BLADE, SLUG	7
-	1	1	1	1	1	1-240641-5	SPACER	5
-	1	1	1	1	1	238009-1	BLOCK, FL CRIMPER SPACER	4
-	1	1	1	1	1	2119582-3	CRIMPER, INSULATION F PREMIUM	3
-	1	1	1	1	1	455888-4	SPACER, CRIMPER	2
-	1	1	1	1	1	456408-3	CRIMPER, WIRE PREMIUM	1

DIMENSIONS:	TOLERANCES UNLESS OTHERWISE SPECIFIED:	OWN	DATE	REV	DESCRIPTION
mm	0 PLC ±.05 1 PLC ±.05 2 PLC ±.05 3 PLC ±.05 4 PLC ±.05 ANGLES ±.0001	L. ZHANG	24FEB2012		TE Connectivity Harrisburg, PA 17105-3608
		L. ZHANG	24FEB2012		NAME: Ocean End Feed Applicator
MATERIAL:		APV	DATE	REV	PRODUCT SPEC
FINISH:		S. XI	24FEB2012		APPLICATION SPEC
WEIGHT:		SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
SCALE		A1	00779	©=2150177	
Customer Accessible Production Drawing		SCALE	1:1	SHEET 1 of 4	REV C

PACIFIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART						
					CONVERT TO	PART NUMBERS REQUIRED					
	2-2150177-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL	PNEUMATIC FEED	2119950-1	2119792-2	-	2119641-2	-	2063440-1
					SERVO LATCH PLATE	2119951-1	1901697-1	8-2150177-5	-	2168400-7 (QUANTITY 2)	
					SMART APPLICATOR	2161326-1	-	8-2150177-4	-	-	
	2-2150177-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	MECHANICAL FEED	2119949-1	2063961-1	5-18022-5	2119653-2	-	-
					SERVO LATCH PLATE	2119951-1	1901697-1	8-2150177-5	-	2168400-7 (QUANTITY 2)	
					SMART APPLICATOR	2161326-1	-	8-2150177-4	-	-	
	2-2150177-5	C	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
	2-2150177-7	C	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	-
	7-2150177-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-

APPLICATOR DATA		
CRIMP SIZE	TYPE	
WIRE 2.79 mm (.110)	F	
INSUL 4.57 mm (.180)	F	
APPLICATOR INSTRUCTIONS 408-10390		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION
TERMINAL NAME: RECEPTACLE, POSITIVE-LOCK, .250 SERIES		
WIRE STRIP LENGTH 4.30-5.10 mm (.169-.201 IN)		INSULATION DIAMETER RANGE Ø2.29-3.94 mm (.090-.155 IN)
TERMINAL APPLICATION SPECIFICATION 114-2074		
TERMINALS APPLIED		
TE TERMINAL	TE TERMINAL	TE TERMINAL
1217094-1	1217094-2	

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
14 AWG	1.57+/-0.05 [.062+/-0.002]	4.5
16 AWG	1.37+/-0.05 [.054+/-0.002]	7.0
18 AWG	1.24+/-0.05 [.049+/-0.002]	8.5

- 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: 8-2150177-4
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150177-4
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150177-5
- 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 50 & 62. 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

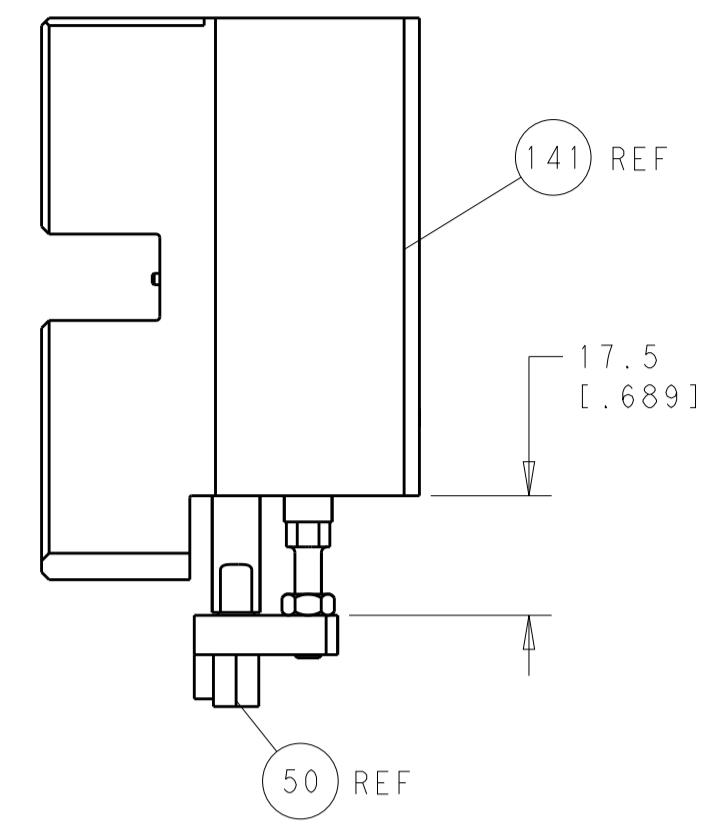
PACIFIC VERSION
 Shown on sheets 3 of 4 & 4 of 4
 (Atlantic version shown on sheets 1 of 4 & 2 of 4)

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

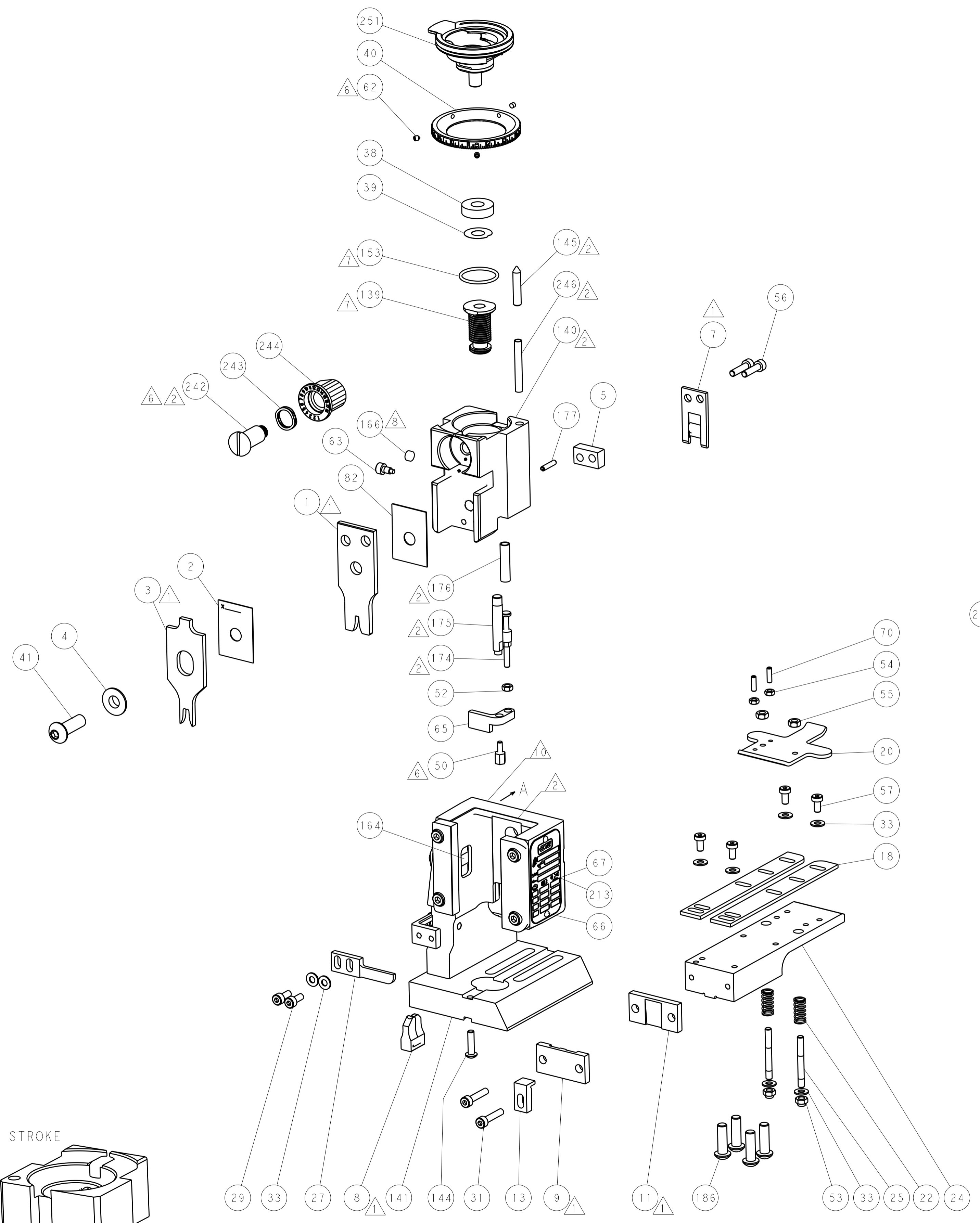
REV	DATE	BY	APPV	DESCRIPTION	ITEM NO
- - - 1 -	2079988-1			BUSHING, LCH5-12, MISUMI	249
- 1 1 1 1	1-22279-3			SPRING, COMPRESSION	246
- 1 1 1 1	2119082-9			CAM, SNAIL, INSULATION ADJUSTMENT	244
- 1 1 1 1	2079764-1			WASHER, WAVE SPRING, CREST-TO-CREST	243
- 1 1 1 1	2119083-1			RETAINER, INSULATION DIAL	242
- - 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	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	1901681-1			HOLDDOWN, TERMINAL	65
- 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
- 4 4 4 4	2168400-4			SHCS, LOW HEAD, RoHS, M4 X 8	57
- 2 2 2 2	2168083-8			SCR, SKT HD CAP, RoHS, M4 X 16	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 1 1 1	1-1752354-2			STANDOFF, HOLD-DOWN	50
- - - 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	2119644-1			RAM WASHER, PRECISION	38
- 8 8 8 8	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	1752371-1			PLATE, STRIP GUIDE	24
- 2 2 2 2	2-22281-3			SPRING, COMPRESSION	22
- 1 1 1 1	1752373-1			DRAG	20
- 2 2 2 2	1-1901259-0			GUIDE, LOWER STRIP	18
- 1 1 1 1	1752360-1			SPACER, HOLD-DOWN	13
- 1 1 1 1	240644-1			PLATE, REAR SHEAR	11
- 1 1 1 1	690482-4			PLATE, FRONT SHEAR	9
	1633386-2			ANVIL, COMBINATION	8
	1-690474-7			BLADE, SLUG	7
- 1 1 1 1	1-240641-5			SPACER	5
- 1 1 1 1	238009-1			BLOCK, FL CRIMPER SPACER	4
	2119582-3			CRIMPER, INSULATION F PREMIUM	3
- 1 1 1 1	455888-4			SPACER, CRIMPER	2
	456408-3			CRIMPER, WIRE PREMIUM	1

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG		CHK		APPV		NAME	
mm	0 PLC ±.5	1 PLC ±.5	2 PLC ±.5	3 PLC ±.5	4 PLC ±.5	5 PLC ±.5	6 PLC ±.5	7 PLC ±.5	8 PLC ±.5	9 PLC ±.5	10 PLC ±.5
	ANGLES ±.0001										
MATERIAL	FINISH	WEIGHT	SCALE	DATE	REV	DESCRIPTION	ITEM NO	DATE	BY	DATE	BY
			1:1	24FEB2012	1	Ocean End Feed Applicator	251	24FEB2012	L.ZHANG	24FEB2012	L.ZHANG
Customer Accessible Production Drawing				SCALE	SHEET	OF	REV				

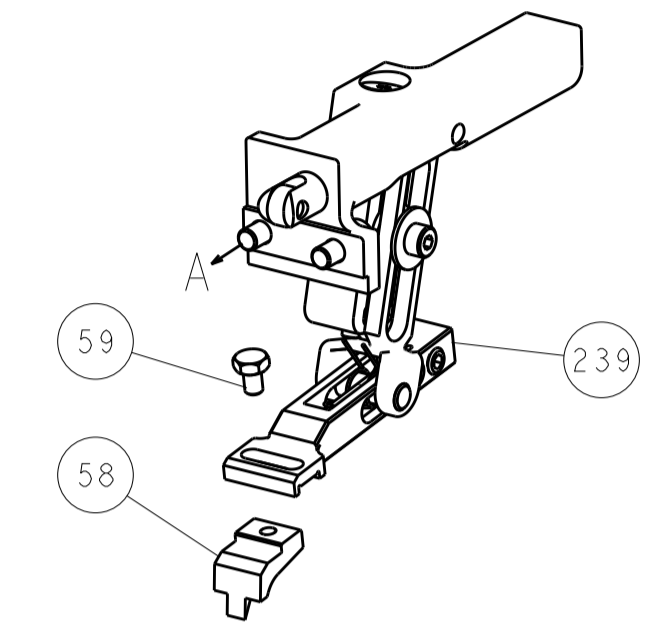
LOC		DIST		REVISIONS			
A	66	P	LTM	DESCRIPTION	DATE	OWN	APVD
		-	-	SEE SHEET 1	-	-	-



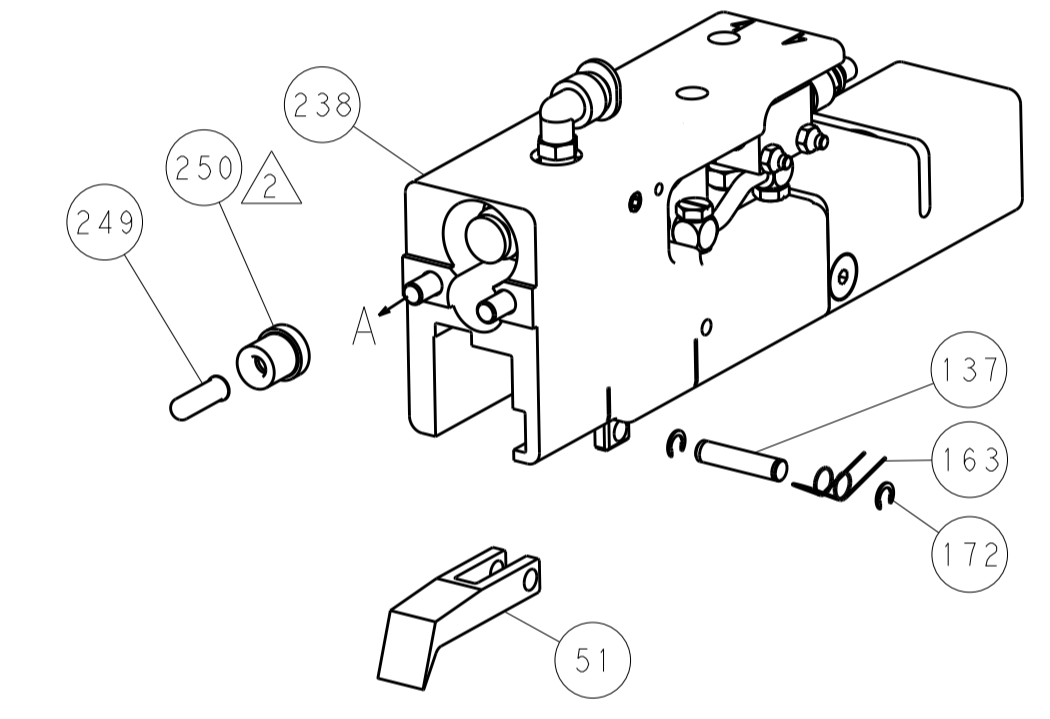
HOLDDOWN SET-UP



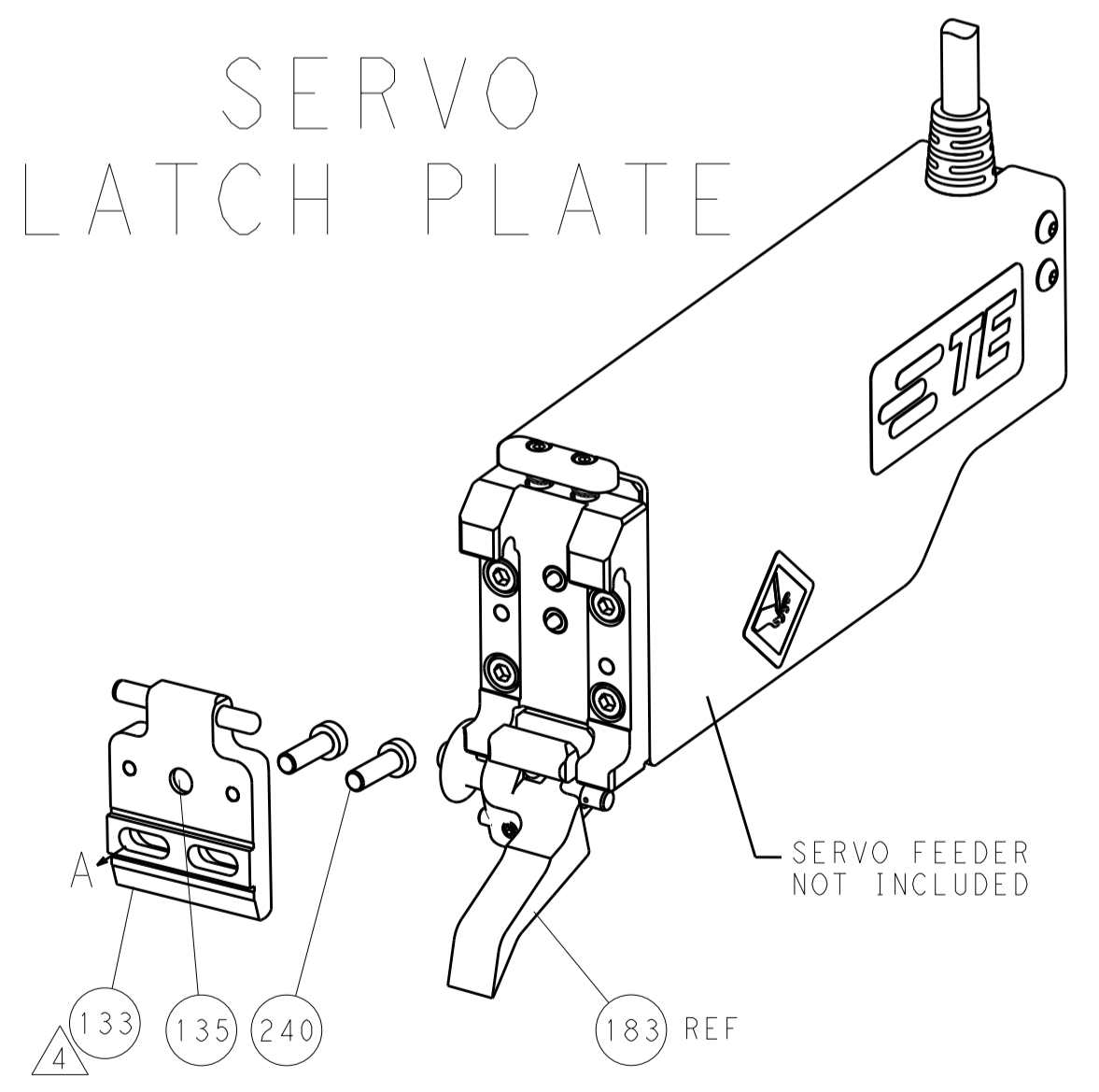
FEED TYPE
MECHANICAL



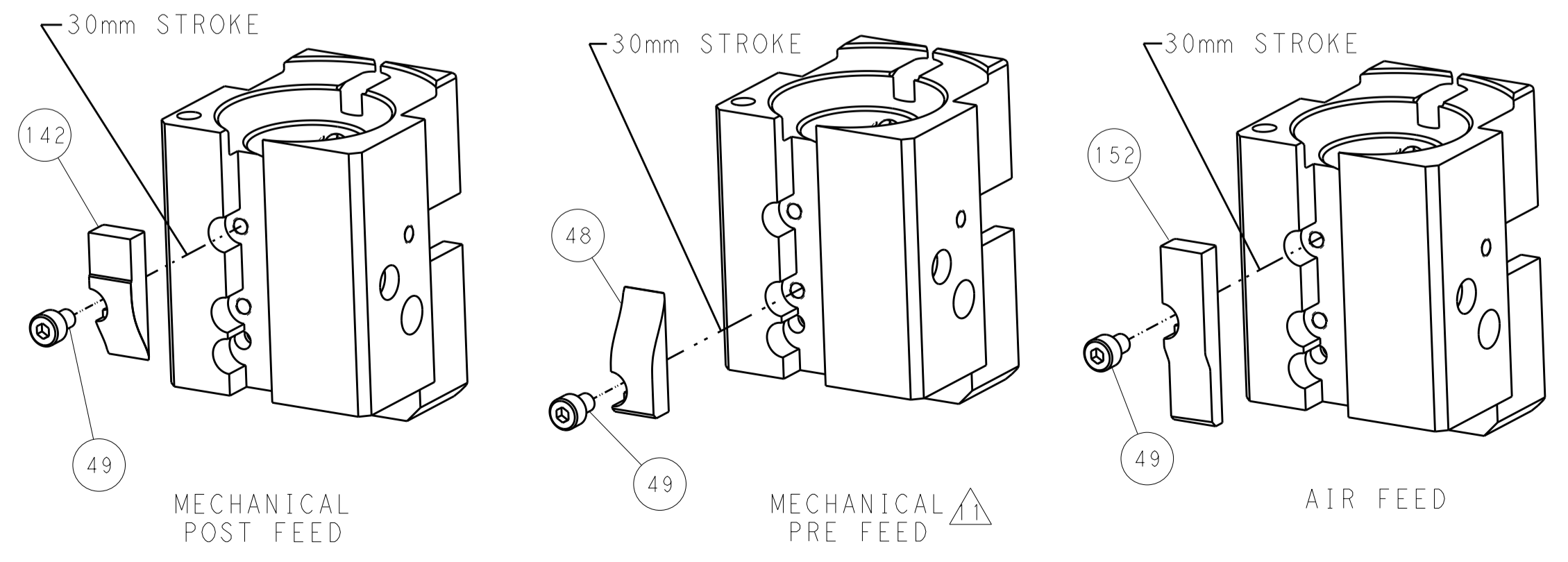
PNEUMATIC



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 L. ZHANG 24FEB2012		CHK L. ZHANG 24FEB2012		S. XI 24FEB2012		NAME	
mm	0 PLC ±.5	1 PLC ±0.5	2 PLC ±0.13	3 PLC ±0.013	4 PLC ±0.001	ANGLES ±.1	PRODUCT SPEC		STE TE Connectivity Harrisburg, PA 17105-3608		
MATERIAL		FINISH		WEIGHT		SCALE		SHEET		REV	
						1:1		4 OF 4		C	