

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART						
					CONVERT TO	PART NUMBERS REQUIRED					
	2266015-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL	PNEUMATIC FEED	2119950-1	1338685-1	5-18022-5	2119641-1	2119799-1	2063440-1
					SERVO LATCH PLATE	2119951-1	-	8-2266015-5	1901094-3	2-1752354-6	2168400-6 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2266015-4	-	-	-
	2266015-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-1	-	-
					SERVO LATCH PLATE	2119951-1	-	8-2266015-5	1901094-3	2-1752354-6	2168400-6 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2266015-4	-	-	-
	2266015-5	B	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE	MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-1	-	-
PNEUMATIC FEED					2119950-1	1338685-1	5-18022-5	2119641-1	2119799-1	2063440-1	
2266015-6	B	NON-CRIMP HEIGHT ADJUST	SERVO LATCH PLATE	-	-	-	-	-	-	-	
2266015-7	B	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	-	
7-2266015-7	B	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-	

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.18 mm [.086]	F
INSUL	2.71 mm [.107]	F

APPLICATOR INSTRUCTIONS
408-10389

TERMINAL DATA: TRW TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: CRIMP CONTACT			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
3.81-4.57 mm [.150-.180 IN]		Ø1.70-2.00 mm [.067-.079 IN]	
TERMINAL APPLICATION SPECIFICATION	NONE		
TERMINALS APPLIED			
TE TERMINAL	TRW TERMINAL	TE TERMINAL	TRW TERMINAL
2113362-1	Y090093798		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.75mm ²	1.28 +/- 0.03 [.050 +/- .001]	6.5

- 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: 8-2266015-4
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2266015-4
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2266015-5
 SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2266015-6
- 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. APPLY PART NUMBER 2-23416-6 LOCTITE TO THE THREADS OF ITEM 242. FOR -6 ONLY APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 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 TO CONVERT THE APPLICATOR TO A NON-CARRIER CUTTING STYLE, REMOVE ITEM 13 AND ATTACH TO THE LOCATION ON THE BACK SIDE OF THE HOUSING. REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.
- 12 WHEN ASSEMBLING A NON CRIMP HEIGHT ADJUST APPLICATOR (-6) USE SHIMS FROM ITEM 260 TO ACHIEVE A NOMINAL SHIM HEIGHT OF 4.52.

***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.

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

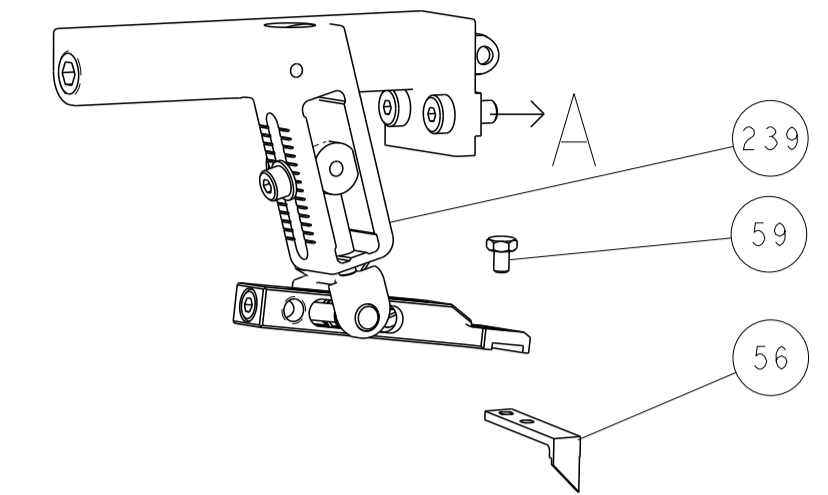
SET UP GAUGE	LOC	DIST	REVISIONS					
2119599-1	A	66	P	LTN	DESCRIPTION	DATE	OWN	APVD
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			B		ECR-17-000503	12JAN2017	TB	GB

1	-	-	1	-	-	-	2119957-2	APPLICATOR SHIM PACK	260
2	-	1	-	1	1	1	8-21084-0	O-RING, .676 ID, .070 DIA. MAT.	252
3	-	-	-	-	1	-	2119640-1	PUSH ROD, AIR FEED	250
4	-	-	-	-	1	-	1803259-1	BUSHING, FLANGED	249
5	-	-	-	-	1	-	2119641-1	FEED CAM, AIR FEED	248
6	-	1	-	1	1	1	2119798-1	DETENT PIN	247
7	-	1	-	1	1	1	1-22279-3	SPRING, COMPRESSION	246
8	-	-	1	-	-	-	2119758-1	RAM, AMP STYLE, SIDE FEED, NON-ADJ.	245
9	-	1	1	1	1	1	2119082-6	CAM, SNAIL, INSULATION ADJUSTMENT	244
10	-	1	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
11	-	1	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
12	-	1	1	1	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
13	-	-	2	2	-	-	2168400-6	SHCS, LOW HEAD, RoHS, M5 X 16	240
14	-	-	-	-	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
15	-	-	-	-	1	-	2063440-1	AIR FEED MODULE	238
16	-	-	1	1	-	-	2119740-2	TAG IDENTIFICATION	213
17	-	-	1	1	-	-	1901094-3	SPACER, FEEDER	198
18	-	-	-	-	2	-	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172
19	-	1	1	1	1	1	994969-1	MAGNET, RARE EARTH HIGH ENERGY	166
20	-	REF	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
21	-	-	-	-	1	-	240638-1	SPRING, FEED FINGER	163
22	-	-	-	-	1	-	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854	137
23	-	-	-	-	1	-	2119799-1	HOLDER, FEED FINGER, AF	136
24	-	-	REF	REF	-	-	SEE NOTE 4	MEMORY CHIP, PROGRAMMED	135
25	-	-	1	1	-	-	1633743-1	SERVO FEED LATCH ASM	133
26	-	1	1	1	1	1	1-18028-2	WASHER, FLAT, REG M4	119
27	-	-	REF	REF	-	-	2119944-1	FEED FINGER ASSEMBLY, SF	117
28	-	1	1	1	1	1	455888-4	SPACER, CRIMPER	82
29	-	1	1	1	1	1	1962431-2	SPRING, COMPRESSION	77
30	-	1	1	1	1	1	854769-4	HOLDER, INS	74
31	-	1	1	1	1	1	2119956-1	DOCUMENTATION PACKAGE	71
32	-	1	-	-	1	1	2119740-1	TAG IDENTIFICATION	67
33	-	2	2	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
34	-	1	-	1	1	1	2119793-1	LIMITER, ADJUSTMENT BOLT	63
35	-	3	-	3	3	3	992763-5	SCR, SET, SOC, CONE POINT, M3 X 4.0	62
36	-	1	1	1	1	1	2079383-4	SCR, BHSC, RoHS (M4 X 8)	60
37	-	-	-	-	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
38	-	1	1	1	1	1	21028-2	PIN, SLOTTED SPRING .062 X .250	58
39	-	-	-	-	1	1	1338685-1	PAWL, FEED	56
40	-	4	4	4	4	4	2168400-1	SHCS, LOW HEAD, RoHS, M4 X 12	54
41	-	-	-	-	1	2	18023-9	SCR, SKT HD CAP M4 X 6.0	49
42	-	-	-	-	1	-	2119652-1	FEED CAM, PRE FEED	48
43	-	-	-	-	1	-	2119653-1	FEED CAM, POST FEED	47
44	-	1	1	1	1	1	2119656-9	APPLICATOR BASIC ASSEMBLY, SF	46
45	-	1	-	1	1	1	2119370-1	RAM, AMP STYLE, SIDE FEED	44
46	-	1	1	1	1	1	2079383-7	SCR, BHSC, RoHS (M8 X 25)	41
47	-	1	-	1	1	1	2119645-1	DISC, NUMBERED FA WIRE ADJUSTMENT	40
48	-	1	-	1	1	1	2119957-1	APPLICATOR SHIM PACK	39
49	-	1	1	1	1	1	2119644-1	RAM WASHER, PRECISION	38
50	-	1	1	1	1	1	2119085-1	FA HEAD, ATLANTIC STYLE	37
51	-	1	-	1	1	1	2119092-1	BOLT, ADJUSTMENT	35
52	-	1	1	1	1	1	4-1752356-7	SUPPORT, TERMINAL	34
53	-	2	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
54	-	1	1	1	1	1	2161328-1	HEX HEAD, FLANGED, M5 X 8mm LONG	32
55	-	1	1	1	1	1	1320908-3	SPACER, STRIP GUIDE	30
56	-	1	1	1	1	1	2119959-1	ASSEMBLY, STRIP GUIDE	29
57	-	1	1	1	1	1	2-455888-2	SPACER, CRIMPER	28
58	-	1	1	1	1	1	1320928-2	STRIP GUIDE	24
59	-	1	1	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
60	-	1	1	1	1	1	1-18028-2	WASHER, FLAT, REG M4	20
61	-	1	1	1	1	1	2119533-1	STRIPPER, SIDE FEED	19
62	-	1	1	1	1	1	2119806-1	INSERT, SHEAR	13
63	-	1	1	1	1	1	3-22280-3	SPRING, COMPRESSION	12
64	-	1	1	1	1	1	1-356885-4	STOP, SHEAR	11
65	-	1	1	1	1	1	2119805-1	SHEAR HOLDER, FRONT	10
66	-	1	1	1	1	1	1803095-1	FLOATING SHEAR, FRONT	9
67	1	1	1	1	1	1	6-1803055-4	ANVIL, COMBINATION	8
68	-	1	1	1	1	1	2119780-9	DEPRESSOR, SHEAR	5
69	-	1	1	1	1	1	238011-7	BLOCK, CRIMPER SPACER	4
70	1	1	1	1	1	1	8-1803017-7	CRIMPER, INSULATION F	3
71	-	1	1	1	1	1	455888-3	SPACER, CRIMPER	2
72	1	1	1	1	1	1	9-1803188-4	CRIMPER, WIRE	1

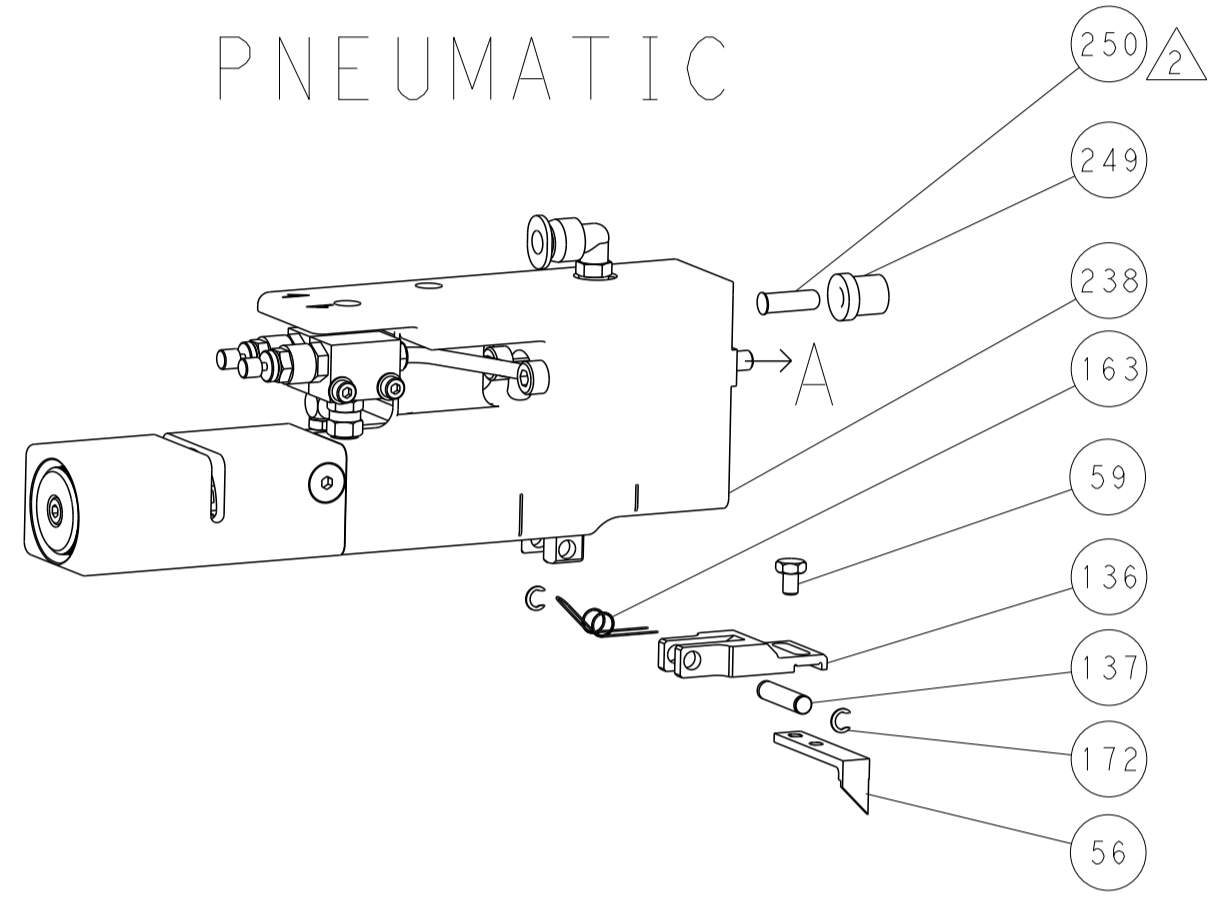
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-75	-5	-4	-3
-74	-4	-3	-2
-73	-3	-2	-1
-72	-2	-1	0
-71	-1	0	1
-70	0	1	2
-69	1	2	3
-68	2	3	4
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22	92		

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

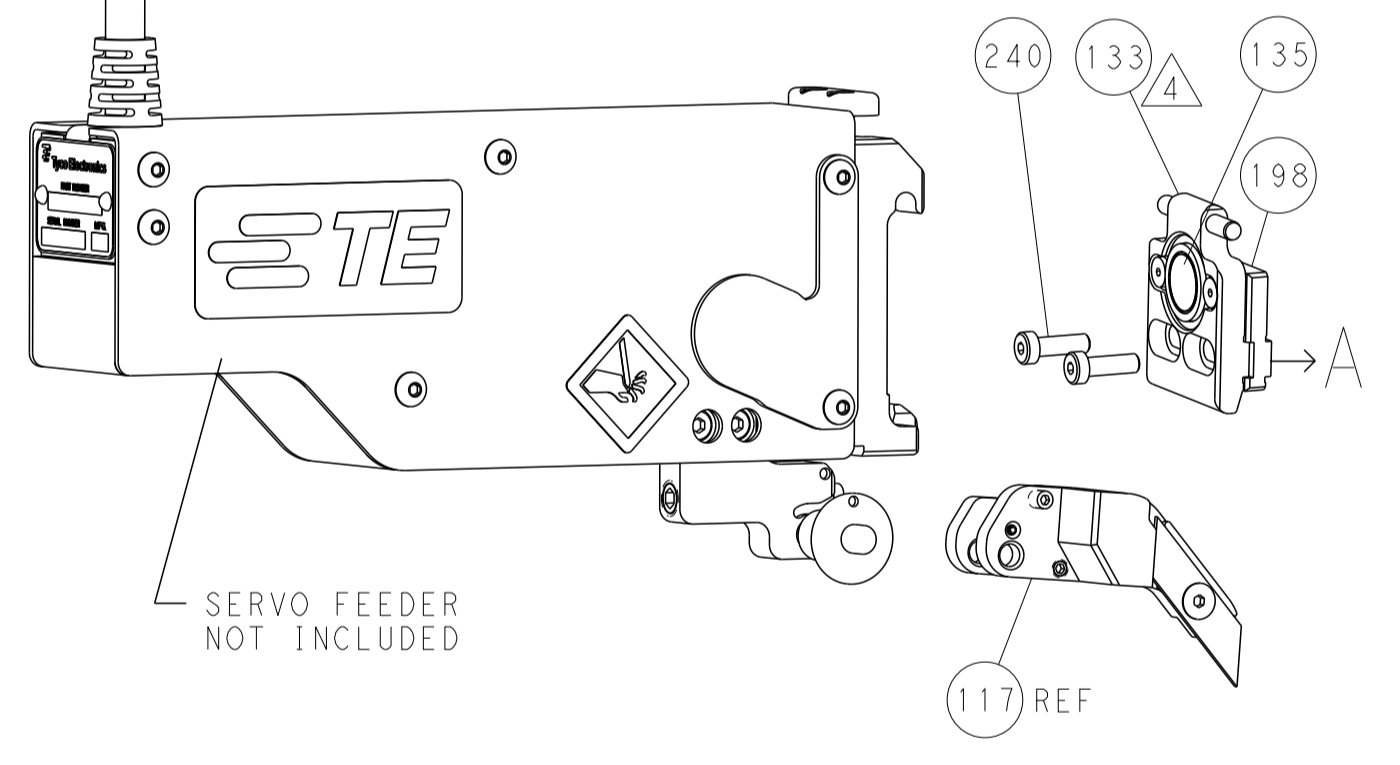
FEED TYPE MECHANICAL



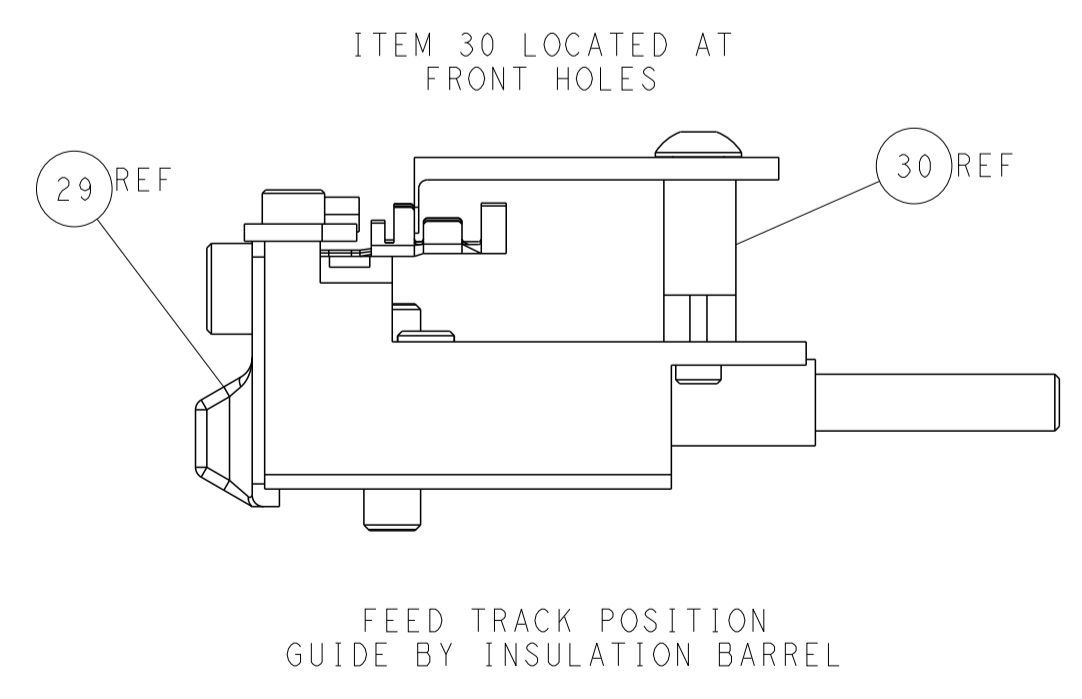
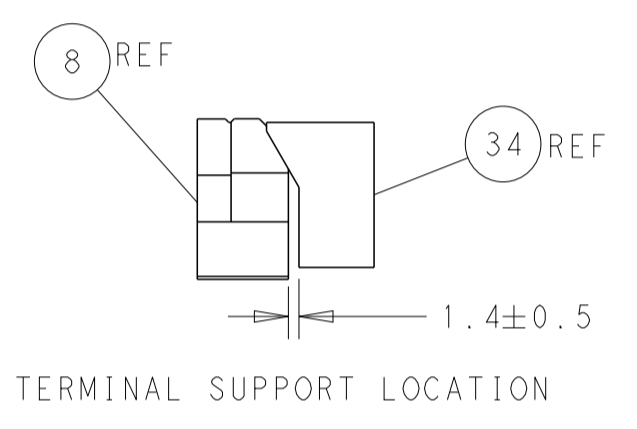
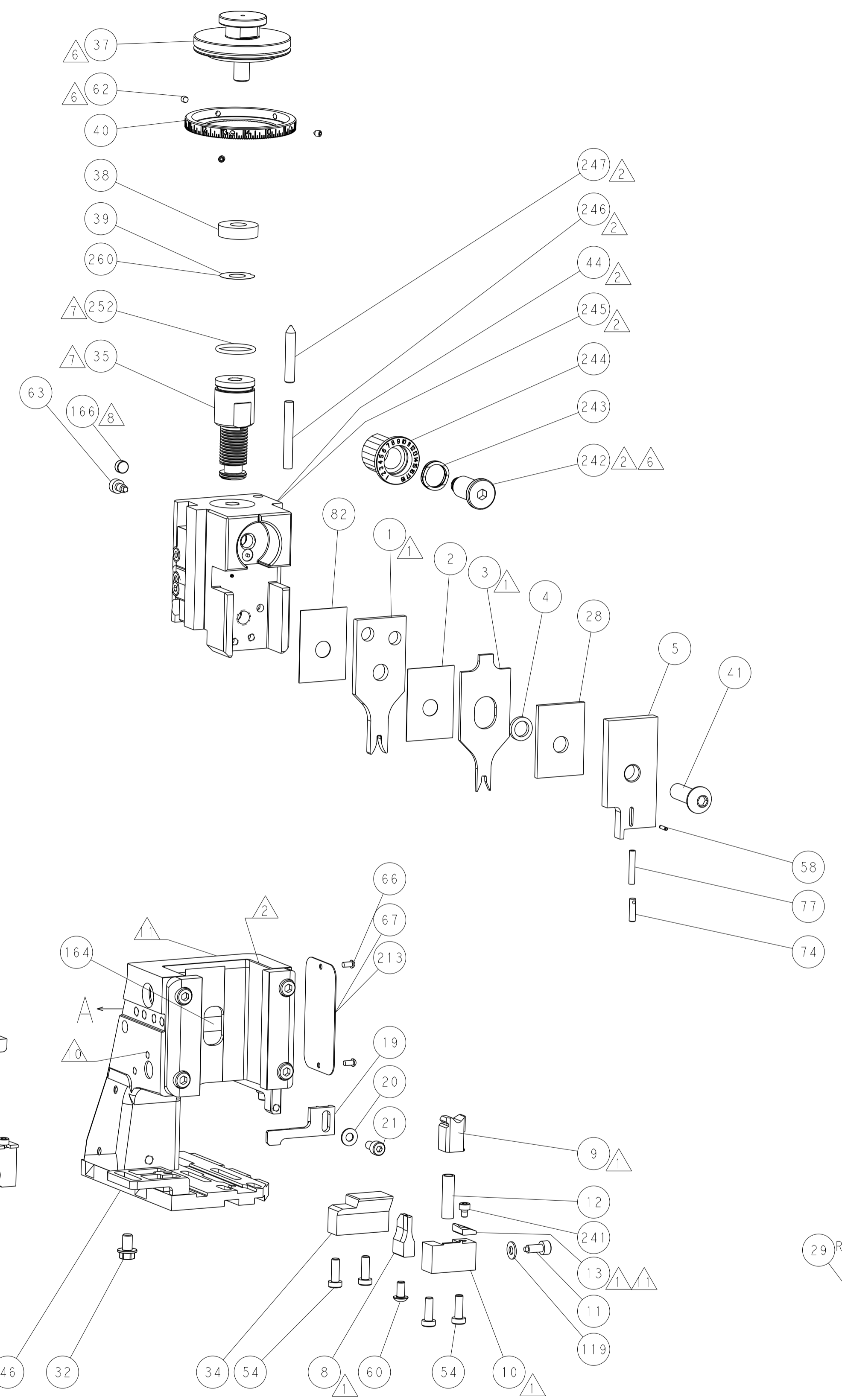
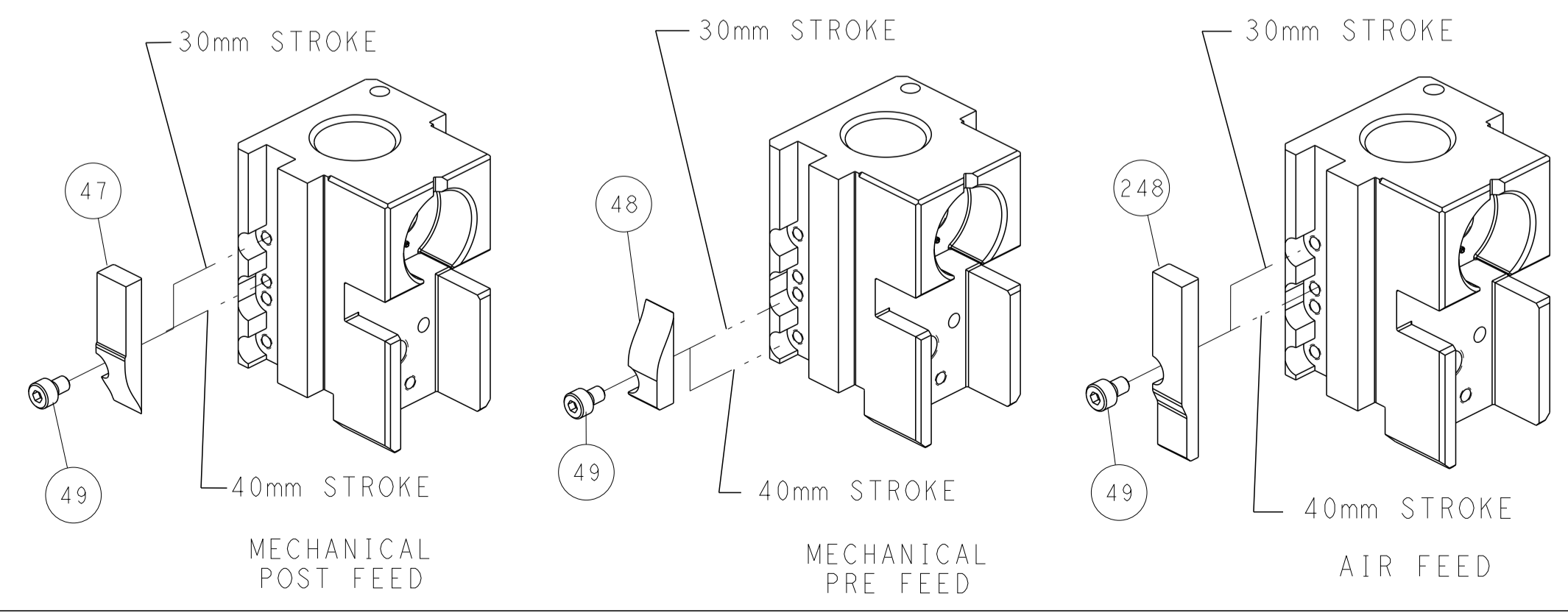
PNEUMATIC



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:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN: R. STAKEM 13AUG2013		TE Connectivity	
mm	0 PLC	±		CHK: G. BAILEY 13AUG2013	NAME: Ocean Side Feed Applicator		TE Connectivity Harrisburg, PA 17105-3608
	1 PLC	±		APVD: T. ELBIN 13AUG2013	RESTRICTED TO:		
	2 PLC	±		MATERIAL:		SIZE: A1	CAGE CODE: 00779
	3 PLC	±		FINISH:		SCALE: 1:2	DRAWING NO: C=2266015
	4 PLC	±		WEIGHT:		SHEET: 2 of 4	REV: B
	ANGLES	±		Customer Accessible Production Drawing		SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION	

PACIFIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART						
					CONVERT TO	PART NUMBERS REQUIRED					
	2-2266015-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL	PNEUMATIC FEED	2119950-1	1338685-1	5-18022-5	2119641-2	2119799-1	2063440-1
					SERVO LATCH PLATE	2119951-1	-	8-2266015-5	1901094-3	2-1752354-6	2168400-6 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2266015-4	-	-	-
	2-2266015-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-2	-	-
					SERVO LATCH PLATE	2119951-1	-	8-2266015-5	1901094-3	2-1752354-6	2168400-6 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2266015-4	-	-	-
	2-2266015-5	B	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE	MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-2	-	-
					PNEUMATIC FEED	2119950-1	1338685-1	5-18022-5	2119641-2	2119799-1	2063440-1
	2-2266015-7	B	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	-
	7-2266015-7	B	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.18 mm [.086]	F
INSUL	2.71 mm [.107]	F
APPLICATOR INSTRUCTIONS 408-10389		

TERMINAL DATA: TRW TERMINAL TE CRIMP SPECIFICATION	
TERMINAL NAME: CRIMP CONTACT	
WIRE STRIP LENGTH 3.81-4.57 mm [.150-.180 IN]	INSULATION DIAMETER RANGE Ø1.70-2.00 mm [.067-.079 IN]
TERMINAL APPLICATION SPECIFICATION NONE	-
TERMINALS APPLIED	
TE TERMINAL 2113362-1	TRW TERMINAL Y090093798

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.75mm2	1.28 +/- 0.03 [.050 +/- .001]	6.5

- 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: 8-2266015-4
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2266015-4
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2266015-5
- 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 ITEMS 62. APPLY PART NUMBER 2-23416-6 LOCTITE TO THE THREADS OF ITEM 242.
- GREASE THREADS, GROOVE AND O-RING ON ITEMS 139 & 152.
- MAGNET 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.
- TO CONVERT THE APPLICATOR TO A NON-CARRIER CUTTING STYLE, REMOVE ITEM 13 AND ATTACH TO THE LOCATION ON BACK SIDE OF THE HOUSING. REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.

***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.

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

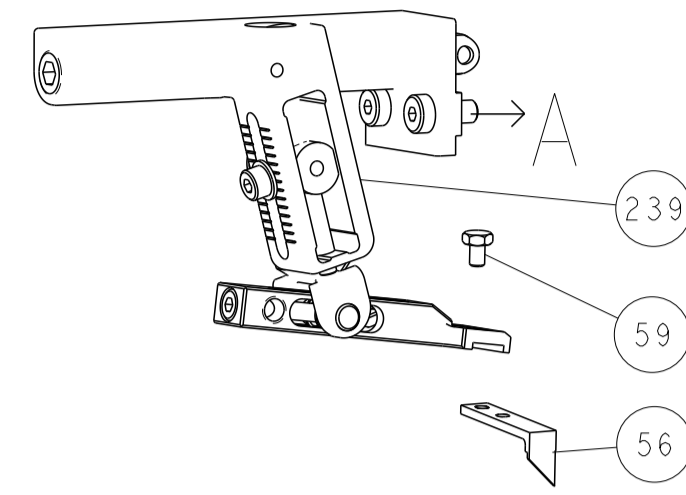
SET UP GAUGE	LOC	DIST	REVISIONS					
2119599-1	A	66	P	LTN	DESCRIPTION	DATE	OWN	APVD
-	-	-	-	-	SEE SHEET 1	-	-	-

-	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	1-22279-3	SPRING, COMPRESSION	246
-	1	1	1	1	2119082-6	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
-	1	1	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
-	-	2	-	-	2168400-6	SHCS, LOW HEAD, RoHS, M5 X 16	240
-	-	-	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	-	-	-	1	2063440-1	AIR FEED MODULE	238
-	-	1	-	-	2119740-2	TAG, IDENTIFICATION	213
-	-	1	-	-	1901094-3	SPACER, FEEDER	198
-	-	-	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.	152
-	-	-	1	-	2119641-2	FEED CAM, AIR FEED	151
-	1	1	1	1	2119798-2	DETENT PIN	145
-	1	1	1	1	2079383-8	SCR, BHSC, RoHS (M4 X 16)	144
-	4	4	4	4	2168400-5	SHCS, LOW HEAD, RoHS, M4 X 20	143
-	-	-	-	1	2119653-2	FEED CAM, POST FEED	142
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-	-	-	1	-	2119799-1	HOLDER, FEED FINGER, AF	136
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-	-	REF	-	-	2119944-1	FEED FINGER ASSEMBLY, SF	117
-	1	1	1	1	455888-4	SPACER, CRIMPER	82
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-	1	1	1	1	2119780-9	DEPRESSOR, SHEAR	5
-	1	1	1	1	238011-7	BLOCK, CRIMPER SPACER	4
-	1	1	1	1	8-1803017-7	CRIMPER, INSULATION F	3
-	1	1	1	1	455888-3	SPACER, CRIMPER	2
-	1	1	1	1	9-1803188-4	CRIMPER, WIRE	1

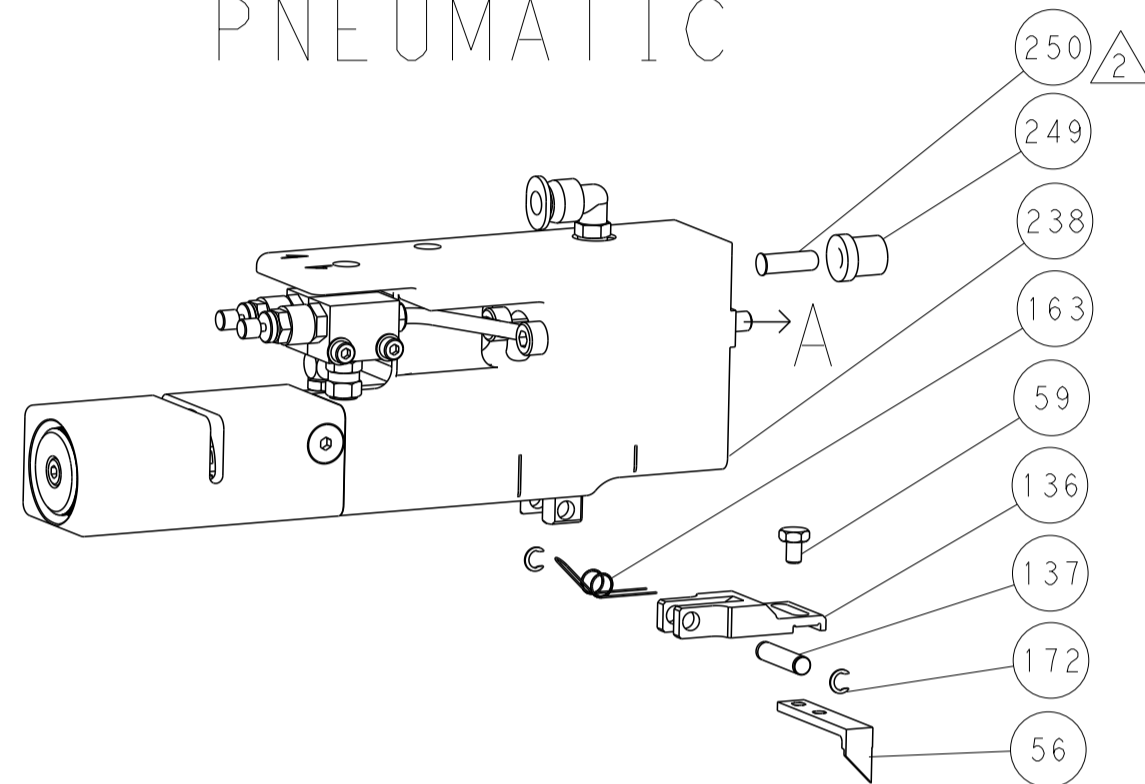
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mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES	FINISH				
MATERIAL:		FINISH:		WEIGHT:		SCALE:		CUSTOMER ACCESSIBLE PRODUCTION DRAWING		SCALE: 1:2 SHEET 3 OF 4 REV B	

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

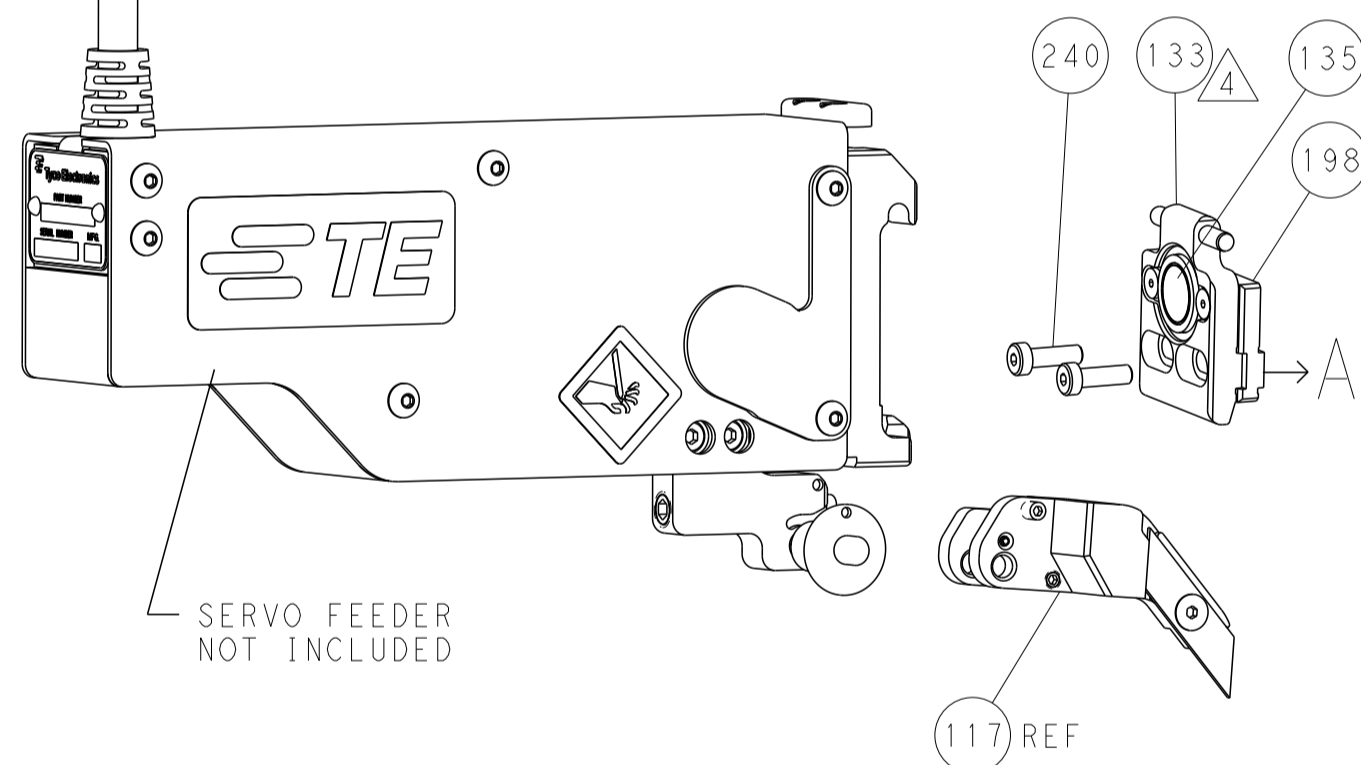
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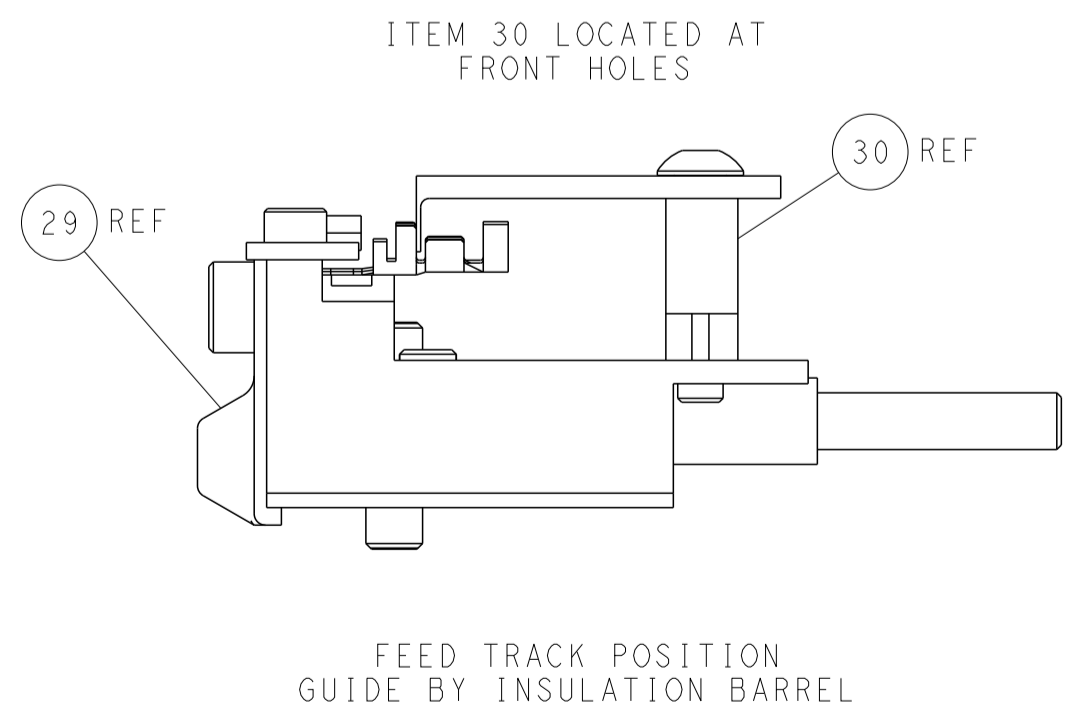
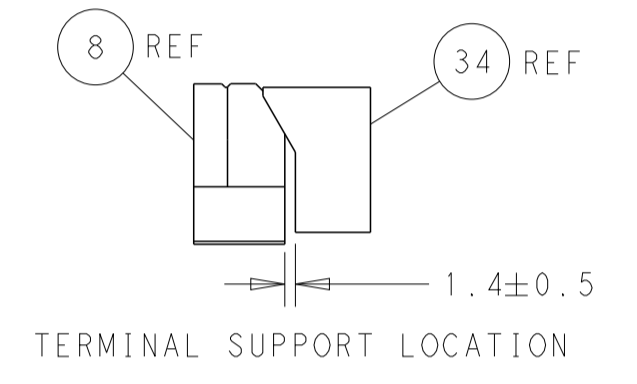
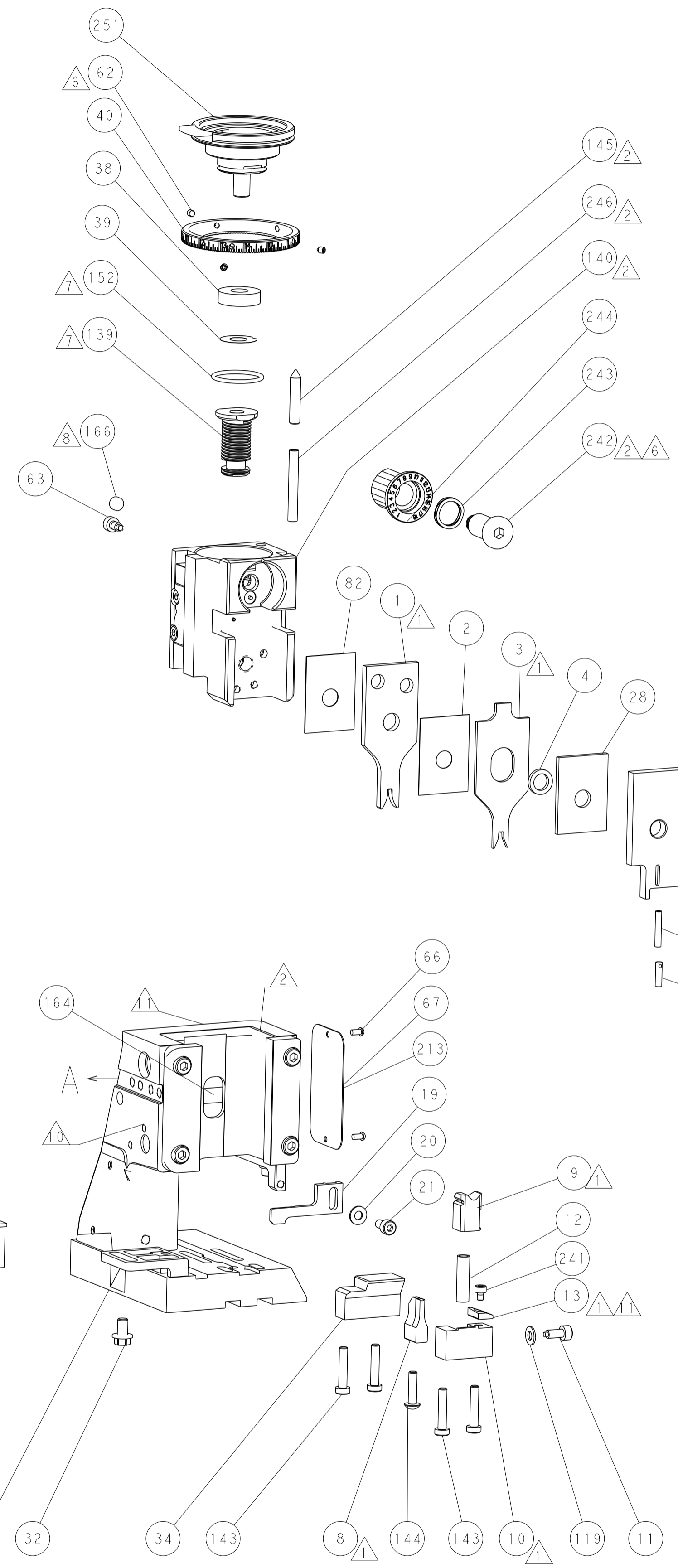
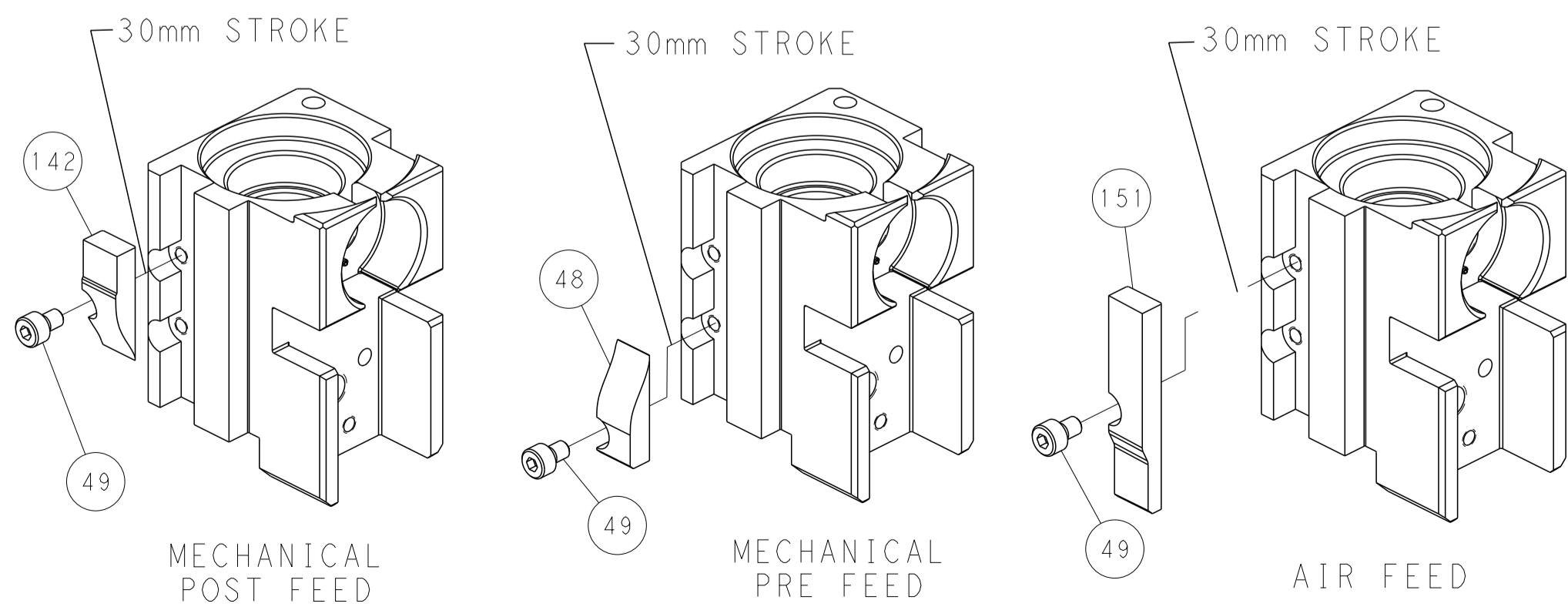
PNEUMATIC



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:		DWG: R. STAKEM 13AUG2013		NAME: TE Connectivity	
mm	0 PLC	±		CHK: G. BAILEY 13AUG2013	Harrisburg, PA 17105-3608		
	1 PLC	±		APVD: T. ELBIN 13AUG2013	Customer Accessible Production Drawing		
	2 PLC	±			SCALE: 1:2	SHEET: 4 OF 4	REV: B
	3 PLC	±					
	4 PLC	±					
	ANGLES	±					
MATERIAL:	FINISH:	WEIGHT:					