

LOC	DIST	REV	DATE	BY	CHK	APPV
A	66					

REV	DESCRIPTION	DATE	BY	CHK	APPV
A	RELEASE	24APR2012	L.Z		S.X
B	ECR-15-010374	10JUL2015	JH		CT

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART						
					CONVERT TO	PART NUMBERS REQUIRED					
	2150013-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL	PNEUMATIC FEED	2119950-1	2119792-1	-	2119641-1	-	2063440-1
					SERVO LATCH PLATE	2119951-1	1901697-1	8-2150013-5	-	-	2168400-7 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2150013-4	-	-	-
	2150013-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	MECHANICAL FEED	2119949-1	2063961-1	5-18022-5	2119653-1	-	-
					SERVO LATCH PLATE	2119951-1	1901697-1	8-2150013-5	-	-	2168400-7 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2150013-4	-	-	-
	2150013-5	B	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE	MECHANICAL FEED	2119949-1	2063961-1	5-18022-5	2119653-1	-	-
					PNEUMATIC FEED	2119950-1	2119792-1	-	2119641-1	-	2063440-1
					-	-	-	-	-	-	-
	2150013-6	B	NON-CRIMP HEIGHT ADJUST	SERVO LATCH PLATE	-	-	-	-	-	-	-
					-	-	-	-	-	-	-
					-	-	-	-	-	-	-
2150013-7	B	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	-	
				-	-	-	-	-	-	-	
7-2150013-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-	

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.03 mm [.080]	F
INSUL	3.30 mm [.130]	F
APPL INSTRUCTIONS 408-10390		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION
TERMINAL NAME: .250 SERIES FASTON REC		
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE
3.80-4.60 mm [.150-.181 IN]		Ø2.00-3.30 mm [.079-.130 IN]
TERMINAL APPLICATION SPECIFICATION	NONE	
TERMINALS APPLIED		
TE TERMINAL	TE TERMINAL	TE TERMINAL
880683-1	880683-2	880683-3
		880683-6

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.00mm2	1.62 +/- 0.05 [.064 +/- .002]	8.6
0.75mm2	1.52 +/- 0.05 [.060 +/- .002]	9.6
0.50mm2	1.45 +/- 0.05 [.057 +/- .002]	10.3

- 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: 8-2150013-4
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150013-4
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150013-5
 SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2150013-6
- 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 50, 62. APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEMS 242. FOR -6 ONLY APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 37, 50.
- 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
- 13 CUT TO LENGTH AT ASSEMBLY

***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.

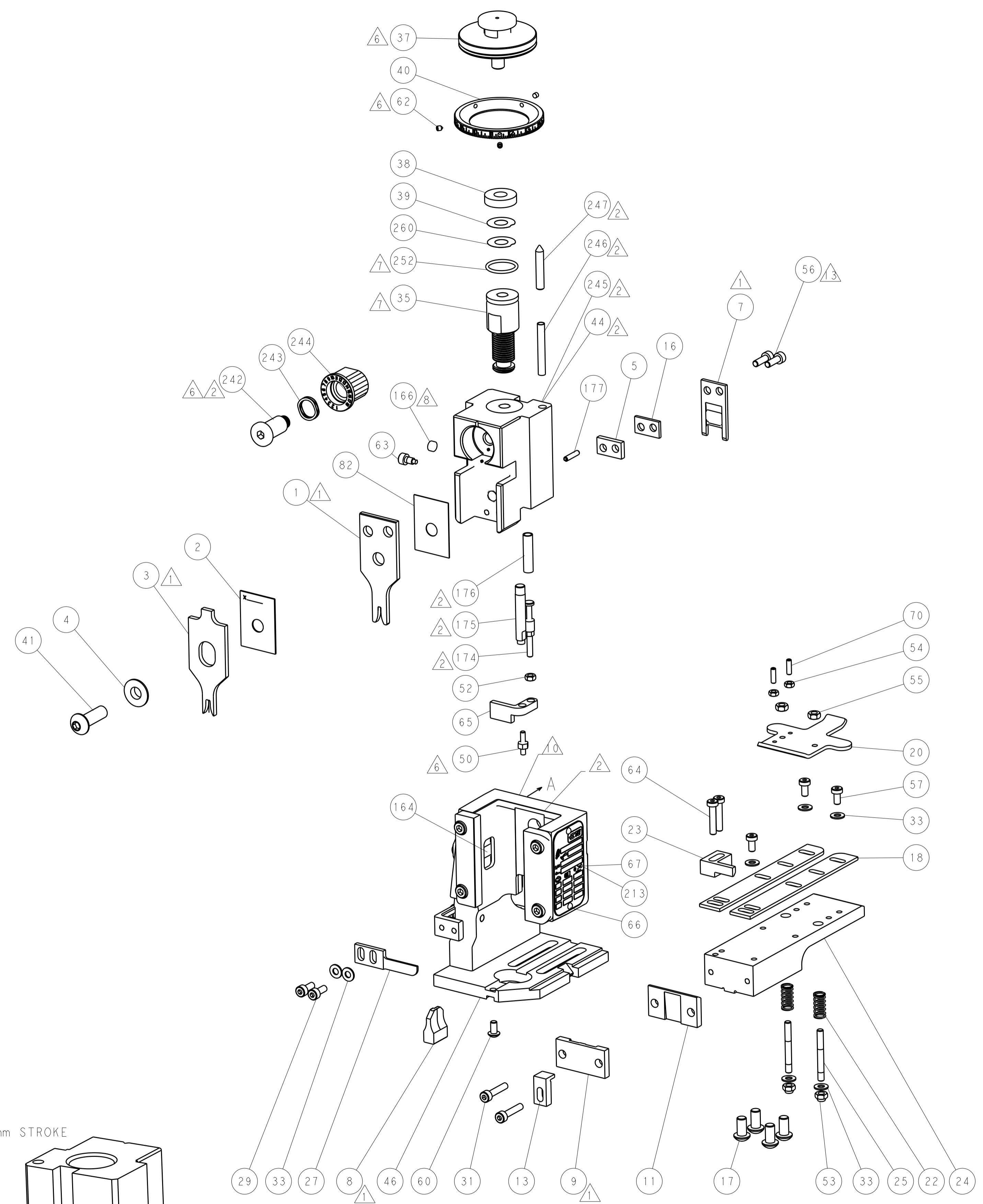
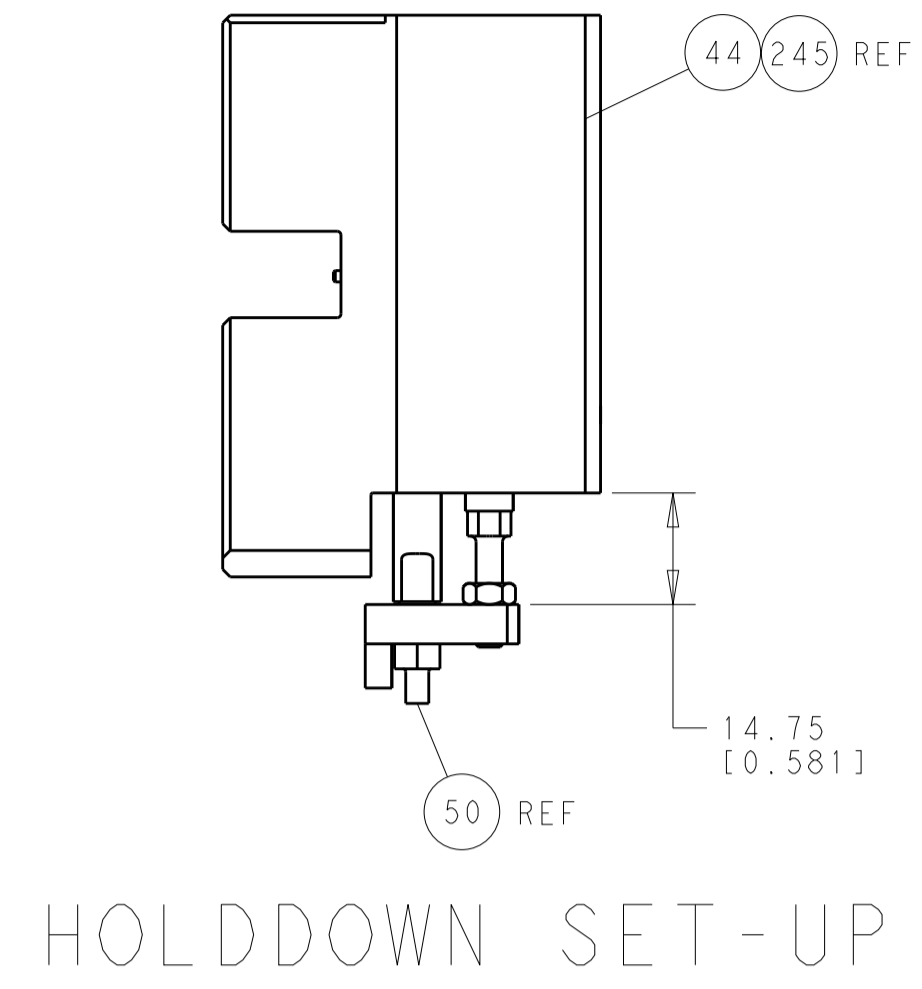
-	-	1	-	-	-	2119957-2	APPLICATOR SHIM PACK	260
-	1	-	1	1	1	8-21084-0	O-RING, .676 ID, .070 DIA. MAT.	252
-	-	-	-	1	-	2119640-1	PUSH ROD, AIR FEED	250
-	-	-	-	1	-	2079988-1	BUSHING, LCH5-12, MISUMI	249
-	-	-	-	1	-	2119641-1	FEED CAM, AIR FEED	248
-	1	-	1	1	1	2119798-1	DETENT PIN	247
-	1	-	1	1	1	1-22279-3	SPRING, COMPRESSION	246
-	-	1	-	-	-	2119759-1	RAM, AMP STYLE, END FEED, NON-ADJUST	245
-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)

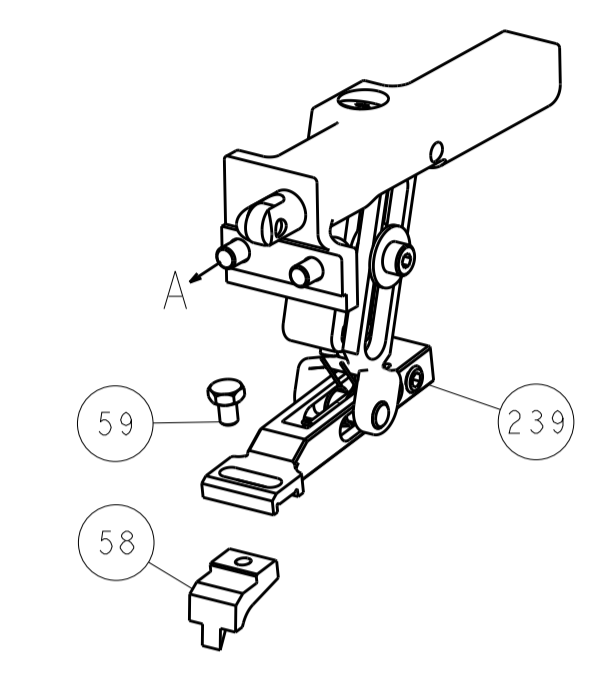
-	1	1	1	1	1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244	
-	1	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243	
-	1	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242	
-	-	2	2	-	-	2168400-7	SHCS, LOW HEAD, RoHS, M5 X 10	240	
-	-	-	-	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239	
-	-	-	-	-	1	2063440-1	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	455888-3	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	1901681-5	HOLDDOWN, TERMINAL	65	
-	2	2	2	2	2	2168400-5	SHCS, LOW HEAD, RoHS, M4 X 20	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	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	2119792-1	PAWL, EF, AIR	51	
-	1	1	1	1	1	1-1976055-6	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	2119653-1	FEED CAM, POST FEED	47	
-	1	1	1	1	1	2119655-5	APPLICATOR BASIC ASSEMBLY, EF	46	
-	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	2119645-1	DISC, NUMBERED FA WIRE ADJUSTMENT	40	
-	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	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	240639-4	STRIPPER (MACHINING)	27	
-	2	2	2	2	2	1320906-1	STUD, THREADED	25	
-	1	1	1	1	1	1752371-2	PLATE, STRIP GUIDE	24	
-	1	1	1	1	1	240825-2	PLATE, STRIP HOLD DOWN	23	
-	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	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	1-240641-1	SPACER	16	
-	1	1	1	1	1	1752360-1	SPACER, HOLD-DOWN	13	
-	1	1	1	1	1	240833-2	PLATE, REAR SHEAR	11	
-	-	-	-	-	-	-	-	10	
-	1	1	1	1	1	690482-3	PLATE, FRONT SHEAR	9	
-	1	1	1	1	1	1803001-1	ANVIL, COMBINATION, END FEED	8	
-	1	1	1	1	1	690474-3	BLADE, SLUG	7	
-	1	1	1	1	1	240641-8	SPACER	5	
-	1	1	1	1	1	238009-1	BLOCK, FL CRIMPER SPACER	4	
-	1	1	1	1	1	2-1633961-6	CRIMPER, INSULATION F PREMIUM	3	
-	1	1	1	1	1	455888-6	SPACER, CRIMPER	2	
-	1	1	1	1	1	1-456405-6	CRIMPER, WIRE PREMIUM	1	
-77	-7	-6	-5	-2	-1	PART NO	DESCRIPTION	ITEM NO	

DIMENSIONS:	TOLERANCES UNLESS OTHERWISE SPECIFIED:	DRAWN	CHK	APPV	DATE	NAME
mm	0 PLC ±.1 1 PLC ±.13 2 PLC ±.13 3 PLC ±.013 4 PLC ±.0001 ANGLES ±.1	L. ZHANG	L. ZHANG	S. XI	19DEC2011	TE Connectivity Harrisburg, PA 17105-3608
MATERIAL:		FINISH:	WEIGHT:	SCALE: 1:1		RESTRICTED TO:
Customer Accessible Production Drawing		Customer Accessible Production Drawing	Customer Accessible Production Drawing	SCALE: 1:1 SHEET 1 OF 4		REV B

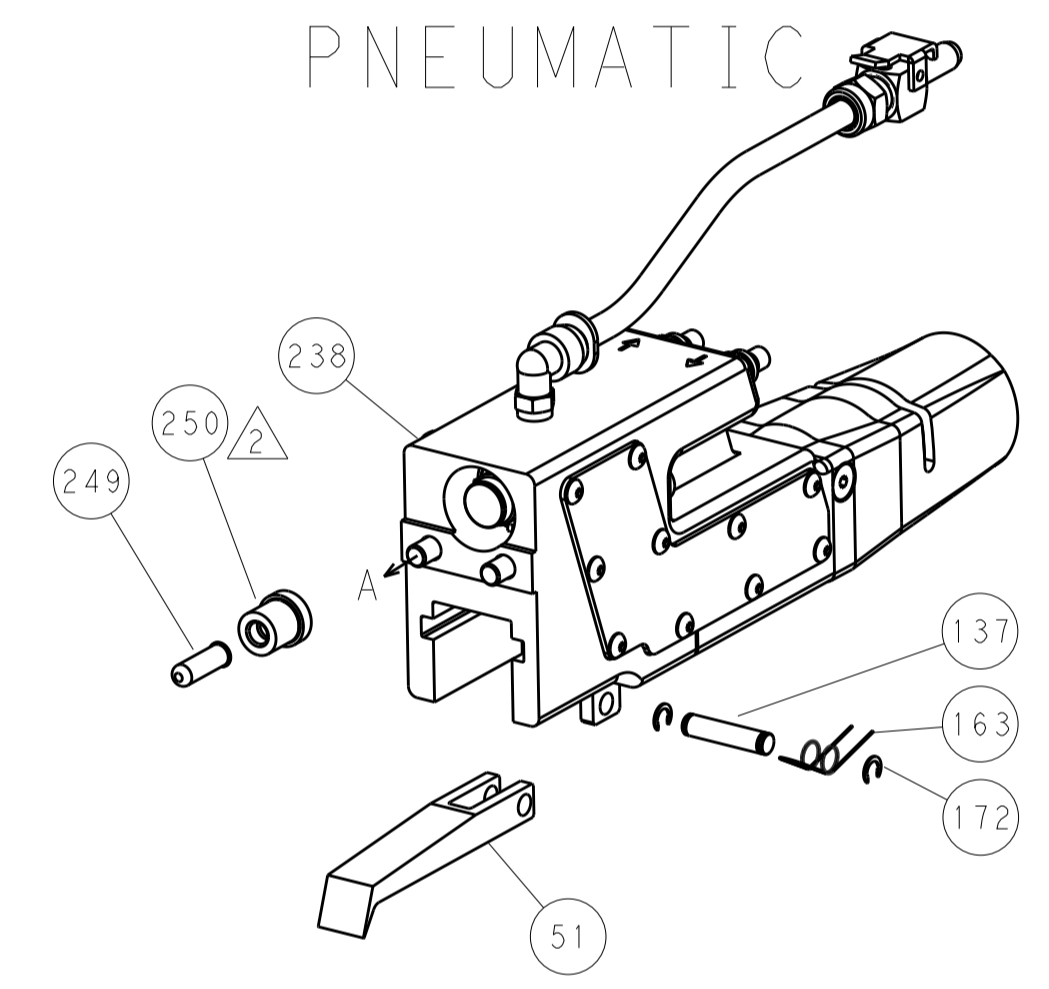
LOC	DIST	REV	DATE	BY	APPV
A	66				
REVISIONS			DESCRIPTION	DATE	BY
			SEE SHEET 1		



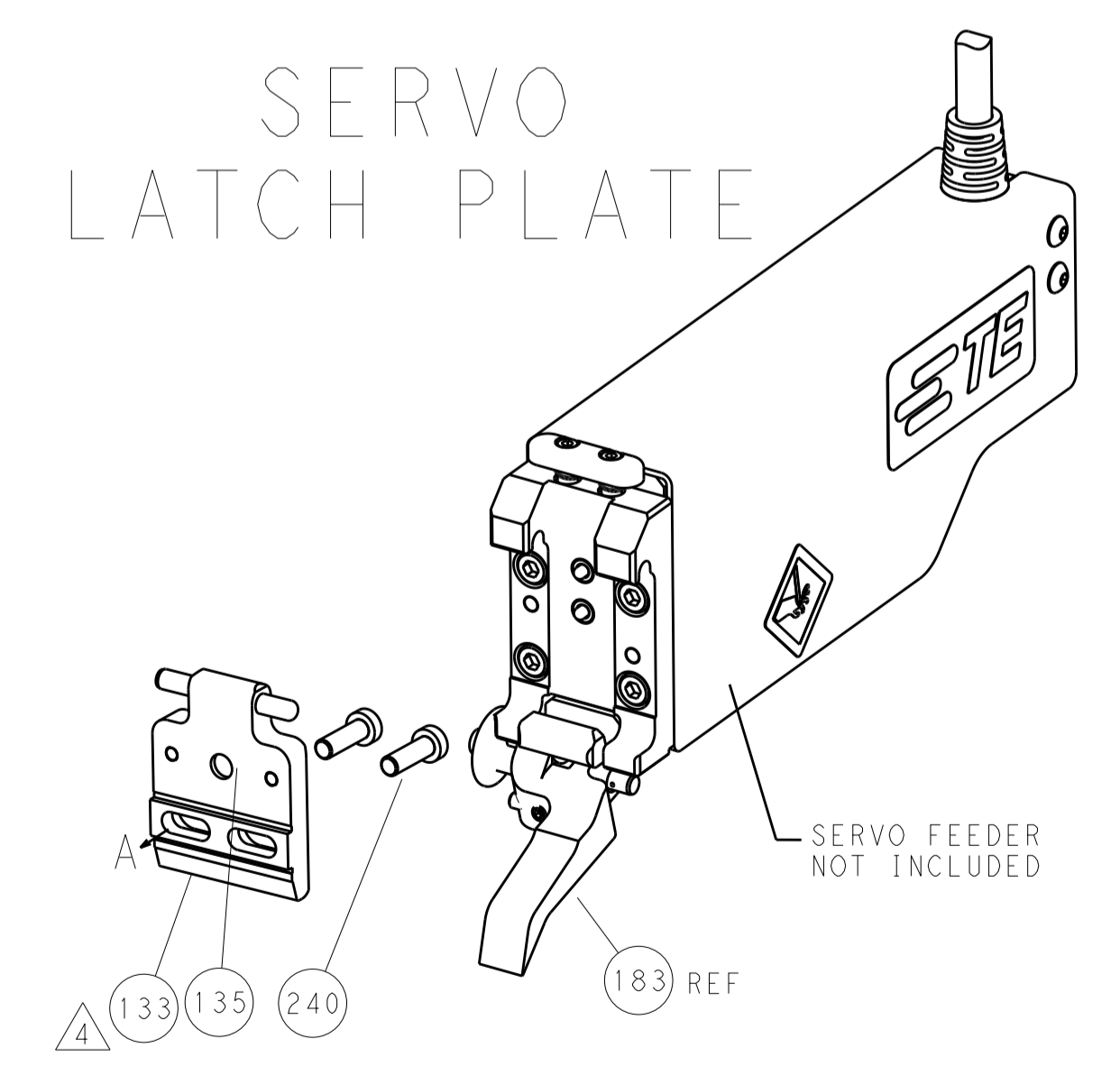
FEED TYPE
MECHANICAL



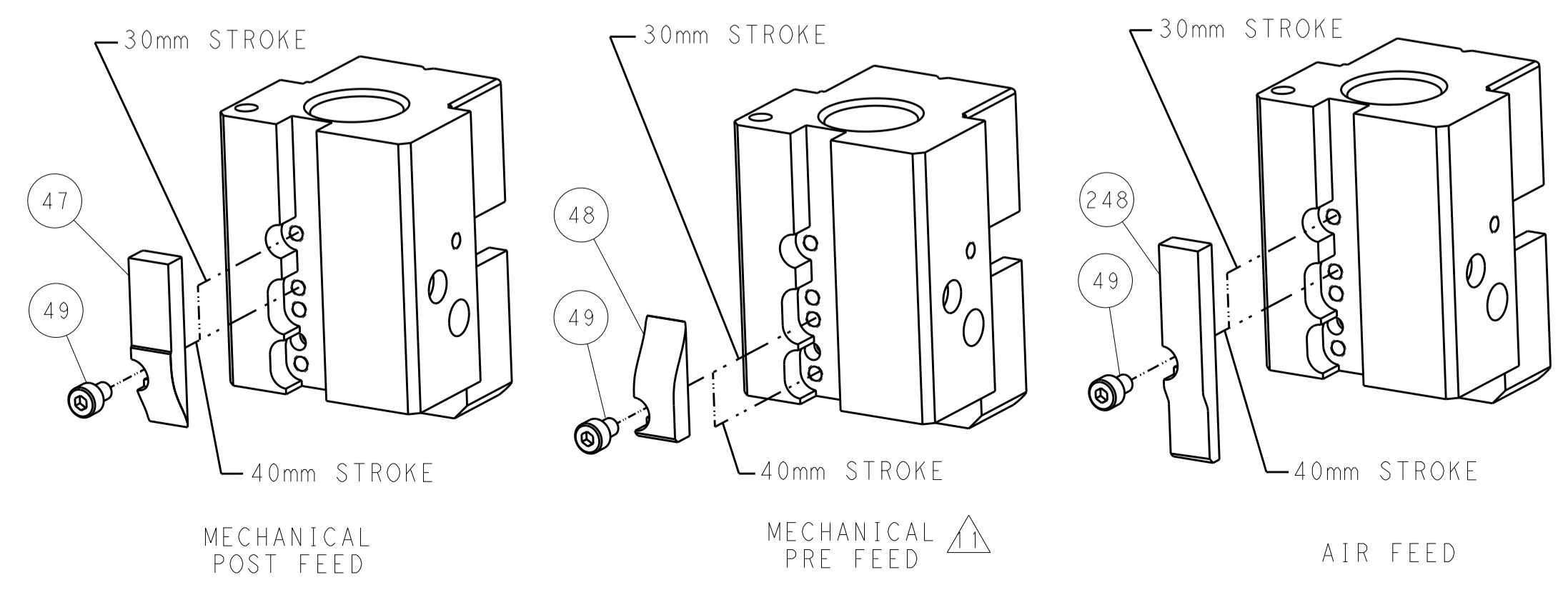
PNEUMATIC



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:		OWN	19DEC2011	TE Connectivity Harrisburg, PA 17105-3608
mm	0 PLC ±0.5	1 PLC ±0.5	2 PLC ±0.13	CHK	19DEC2011	
	3 PLC ±0.013	4 PLC ±0.001	ANGLES ±0.001	APPV	19DEC2011	NAME
MATERIAL	FINISH	WEIGHT	Customer Accessible Production Drawing	S-XI	PRODUCT SPEC	Ocean End Feed Applicator
			SCALE 1:1	SIZE	APPLICATION SPEC	RESTRICTED TO
			SHEET 2 OF 4	Customer Accessible Production Drawing	WEIGHT	REV B
			REV	Customer Accessible Production Drawing	Customer Accessible Production Drawing	

THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION

8 7 6 5 4 3 2 1

BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	CONVERT TO						
				PART NUMBERS REQUIRED						
2-2150013-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL	PNEUMATIC FEED	2119950-1	2119792-1	-	2119641-2	-	2063440-1
				SERVO LATCH PLATE	2119951-1	1901697-1	8-2150013-5	-	2168400-7 (QUANTITY 2)	
				SMART APPLICATOR	2161326-1	-	8-2150013-4	-	-	
2-2150013-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	MECHANICAL FEED	2119949-1	2063961-1	5-18022-5	2119653-2	-	-
				SERVO LATCH PLATE	2119951-1	1901697-1	8-2150013-5	-	2168400-7 (QUANTITY 2)	
				SMART APPLICATOR	2161326-1	-	8-2150013-4	-	-	
2-2150013-5	B	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE	2119949-1	2063961-1	5-18022-5	2119653-2	-	-	
2-2150013-7	B	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	
7-2150013-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-	

APPLICATOR DATA

CRIMP SIZE	TYPE
WIRE 2.03 mm [.080]	F
INSUL 3.30 mm [.130]	F

APPL INSTRUCTIONS 408-10390

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION

TERMINAL NAME: .250 SERIES FASTON REC

WIRE STRIP LENGTH 3.80-4.60 mm [.150-.181 IN] INSULATION DIAMETER RANGE 2.00-3.30 mm [.079-.130 IN]

TERMINAL APPLICATION SPECIFICATION NONE

TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
880683-1	880683-2	880683-3	880683-6

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.00mm2	1.62 +/- 0.05 [.064 +/- .002]	8.6
0.75mm2	1.52 +/- 0.05 [.060 +/- .002]	9.6
0.50mm2	1.45 +/- 0.05 [.057 +/- .002]	10.3



- 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: 8-2150013-4
 - PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150013-4
 - SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150013-5
- 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 50, 62. APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEMS 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.
- CUT TO LENGTH AT ASSEMBLY

***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
-77-27-25-22-21	PART NO	
1	FINE ADJUST HEAD ASM, PACIFIC STYLE	251
2	PUSH ROD, AIR FEED	250
3	BUSHING, LCH5-12, MISUMI	249
4	SPRING, COMPRESSION	246
5	CAM, SNAIL, INSULATION ADJUSTMENT	244
6	WASHER, WAVE SPRING, CREST-TO-CREST	243

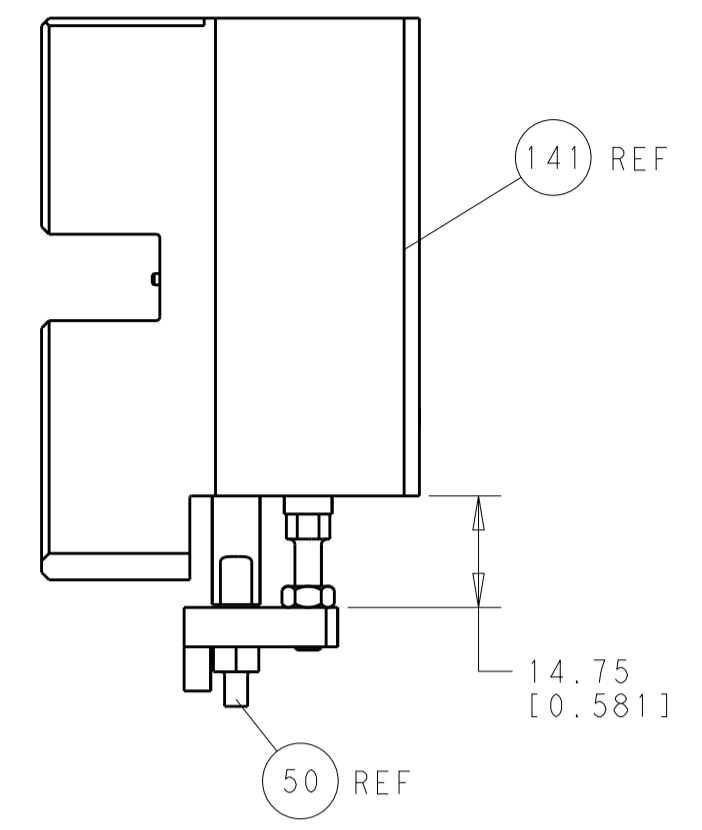
PACIFIC VERSION
Shown on sheets 3 of 4 & 4 of 4
(Atlantic version shown on sheets 1 of 4 & 2 of 4)

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

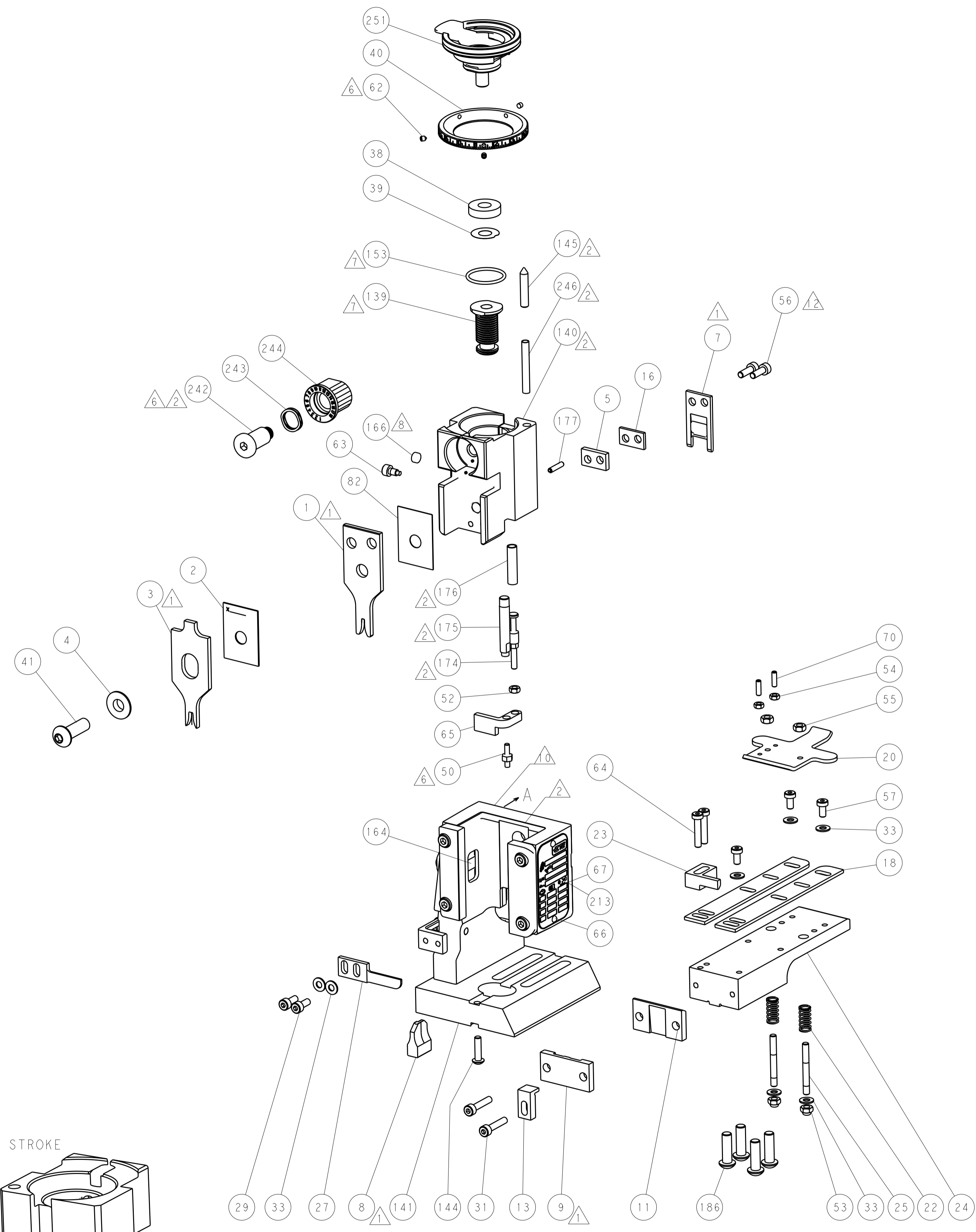
ITEM NO	DESCRIPTION	ITEM NO
-1	RETAINER, INSULATION DIAL	242
-2	SHCS, LOW HEAD, RoHS, M5 X 10	240
-1	MECHANICAL FEED ASSEMBLY	239
-1	AIR FEED MODULE	238
-1	TAG, IDENTIFICATION	213
-4	SCR, BHSC, RoHS (M6 X 20)	186
-REF	FEED FINGER ASSEMBLY, EF	183
-1	PIN, SLOTTED SPRING 3.0 X 14.0	177
-1	SPRING, COMPRESSION	176
-1	GUIDE PIN, HOLDDOWN	175
-1	GUIDE PIN, HOLDDOWN	174
-2	RING, RETAIN, EXTERN, 3/16 CRESCENT	172
-1	MAGNET, RARE EARTH HIGH ENERGY	166
-REF	COUNTER, MAGNETIC	164
-1	SPRING, FEED FINGER	163
-1	O-RING, .801 ID, .070 DIA. MAT.	153
-1	FEED CAM, AIR FEED	152
-1	DETENT PIN	145
-1	SCR, BHSC, RoHS (M4 X 16)	144
-1	FEED CAM, POST FEED	142
-1	APPLICATOR BASIC ASSEMBLY, EF	141
-1	RAM, ASIAN STYLE, END FEED	140
-1	BOLT, ADJUSTMENT	139
-1	PIN, RETAIN, GRVD, 3/16 X .854	137
-REF	MEMORY CHIP, PROGRAMMED	135
-1	SERVO FEED LATCH ASM	133
-1	SPACER, CRIMPER	82
-1	DOCUMENTATION PACKAGE	71
-2	SCR, SET, FLT POINT M3 X 10.0	70
-1	TAG, IDENTIFICATION	67
-2	SCREW, DRIVE, RH, RoHS, 2 X .188	66
-1	HOLDDOWN, TERMINAL	65
-2	SHCS, LOW HEAD, RoHS, M4 X 20	64
-1	LIMITER, ADJUSTMENT BOLT	63
-3	SCR, SET, SOC, CONE POINT, M3 X 4.0	62
-1	SCR, HEX HD CAP, M4 X 6.0	59
-1	FEED FINGER	58
-3	SHCS, LOW HEAD, RoHS, M4 X 8	57
-2	SCR, SKT HD CAP, RoHS, M4 X 12.0	56
-2	NUT, HEX, REG, RoHS, M4	55
-2	NUT, HEX, REG, RoHS, M3	54
-2	NUT, LOCK, HEX, TORQUE (M4)	53
-1	NUT, HEX, REG, RoHS, M3.5	52
-1	PAWL, EF, AIR	51
-1	STANDOFF, HOLD-DOWN	50
-1	SCR, SKT HD CAP M4 X 6.0	49
-1	FEED CAM, PRE FEED	48
-1	SCR, BHSC, RoHS (M8 X 25)	41
-1	DISC, NUMBERED FA WIRE ADJUSTMENT	40
-1	APPLICATOR SHIM PACK	39
-1	RAM WASHER, PRECISION	38
-7	WASHER, FLAT, REG M4	33
-2	SCR, SKT HD CAP, RoHS, M4 X 20	31
-2	SCR, SKT HD CAP, RoHS, M4 X 10	29
-1	STRIPPER (MACHINING)	27
-2	STUD, THREADED	25
-1	PLATE, STRIP GUIDE	24
-1	PLATE, STRIP HOLD DOWN	23
-2	SPRING, COMPRESSION	22
-1	DRAG	20
-2	GUIDE, LOWER STRIP	18
-1	SPACER	16
-1	SPACER, HOLD-DOWN	13
-1	PLATE, REAR SHEAR	11
-1	-	10
-1	PLATE, FRONT SHEAR	9
1	ANVIL, COMBINATION, END FEED	8
-1	BLADE, SLUG	7
-1	SPACER	5
-1	BLOCK, FL CRIMPER SPACER	4
1	CRIMPER, INSULATION F PREMIUM	3
-1	SPACER, CRIMPER	2
1	CRIMPER, WIRE PREMIUM	1

DIMENSIONS:	TOLERANCES UNLESS OTHERWISE SPECIFIED:	DRAWN	DATE	CHK	DATE	APPD	DATE
mm	0 PLC ±.5 1 PLC ±.5 2 PLC ±.5 3 PLC ±.5 4 PLC ±.5 ANGLES ±.0001	L. ZHANG	19DEC2011	L. ZHANG	19DEC2011	S. XI	19DEC2011
MATERIAL:		PRODUCT SPEC		NAME		SIZE	
FINISH:		APPLICATION SPEC		Ocean End Feed Applicator		SCALE	
		WEIGHT		A1 00779 ©=2150013		RESTRICTED TO	
		Customer Accessible Production Drawing		SCALE 1:1		SHEET 3 OF 4 REV B	

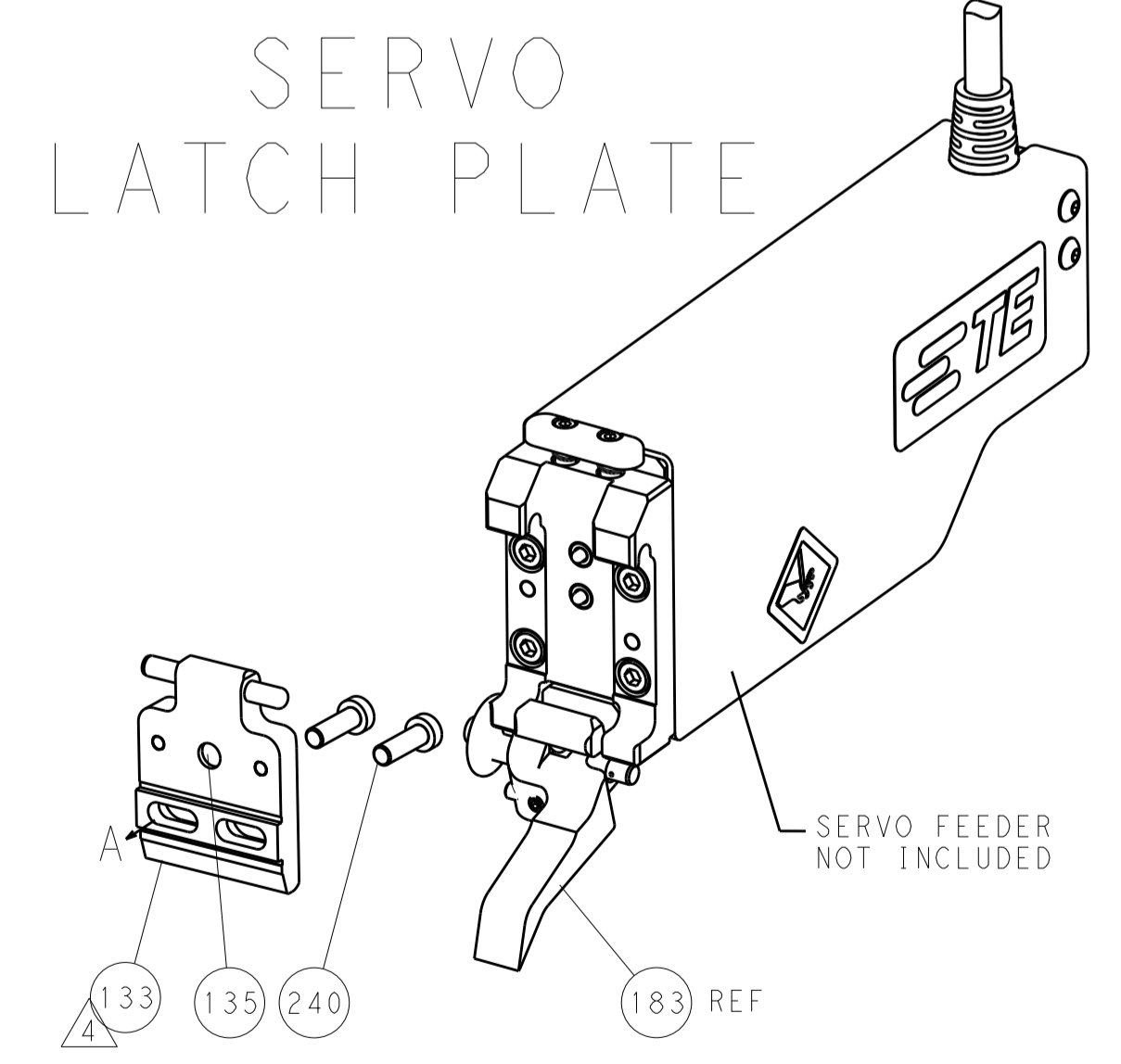
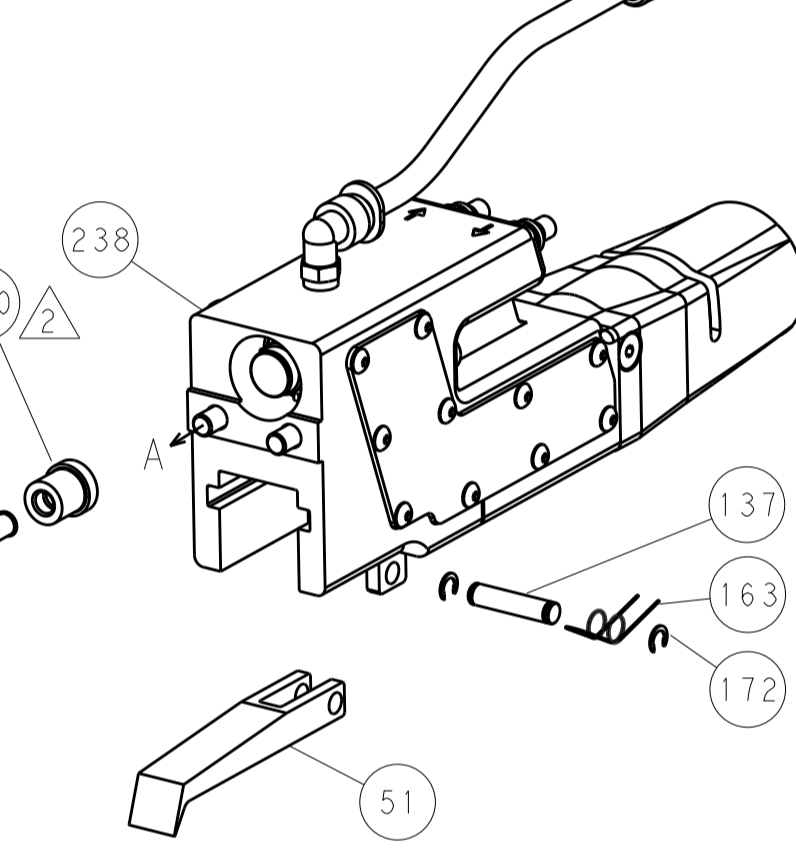
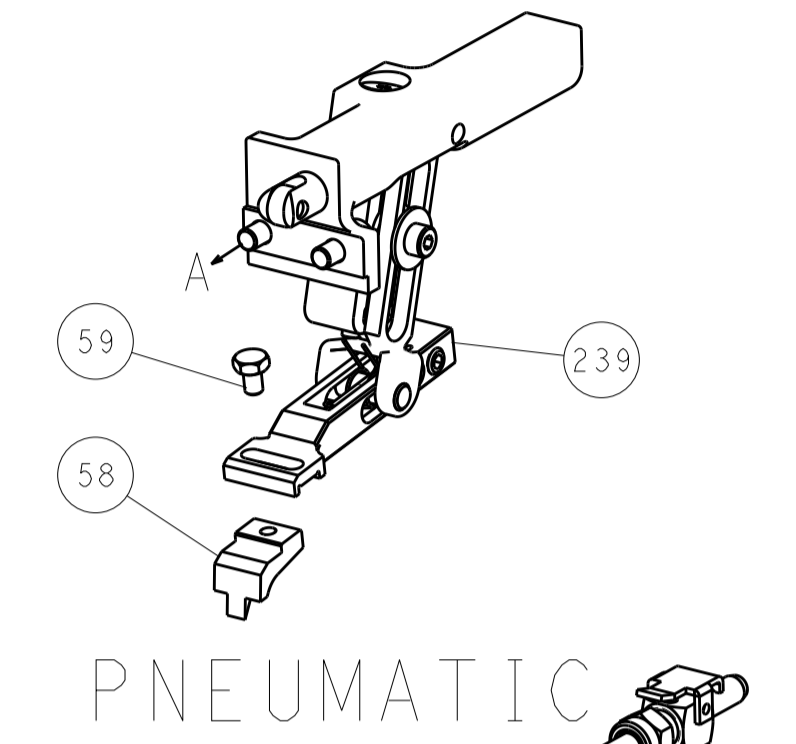
LOC		DIST		REVISIONS			
A	66	P	LTM	DESCRIPTION	DATE	OWN	APVD
		-	-	SEE SHEET 1	-	-	-



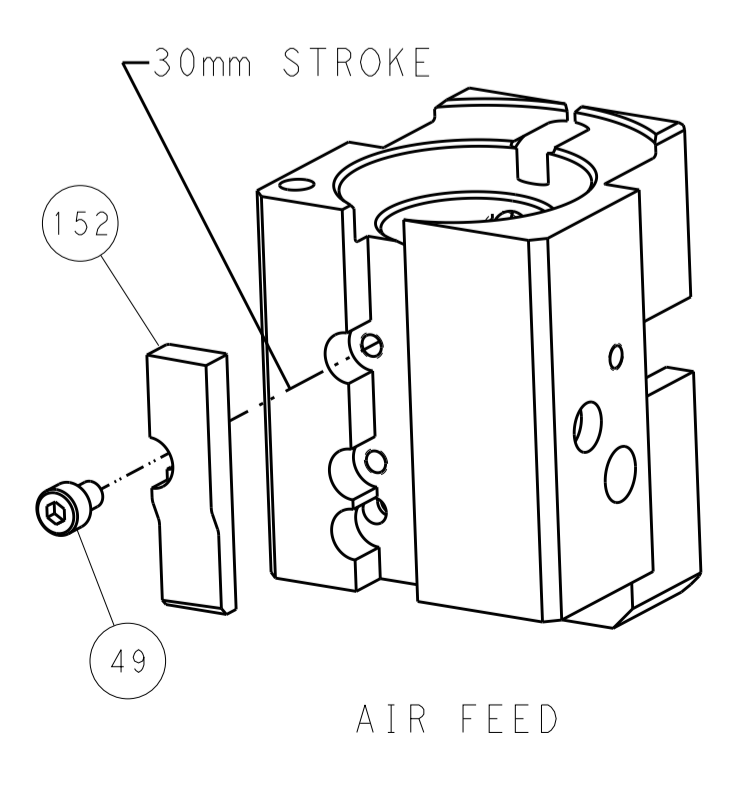
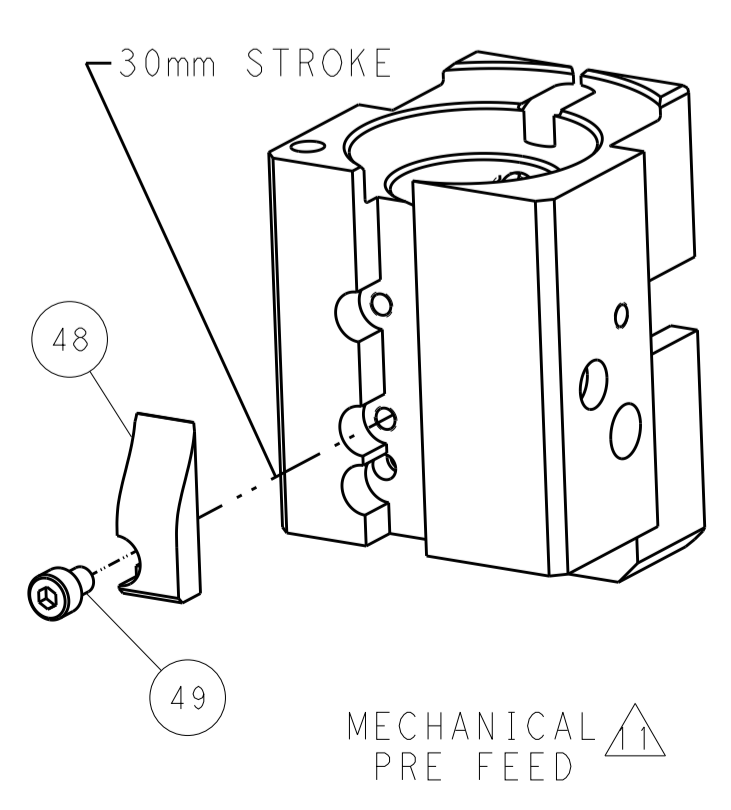
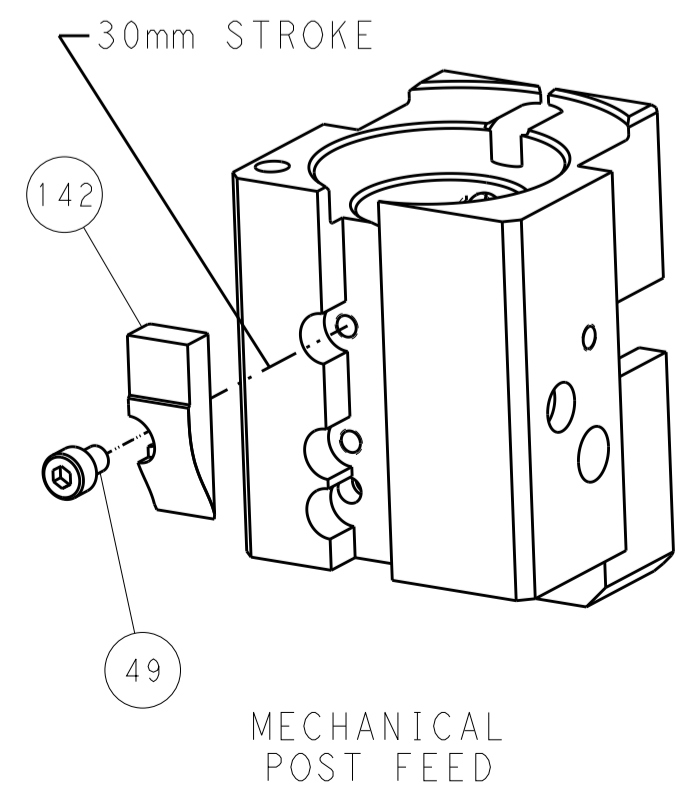
HOLDDOWN SET-UP



FEED TYPE
MECHANICAL



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 19DEC2011		STE TE Connectivity Harrisburg, PA 17105-3608	
mm	0 PLC ±0.5	1 PLC ±0.5	2 PLC ±0.13	3 PLC ±0.013	4 PLC ±0.001	APVD S. XI 19DEC2011	NAME Ocean End Feed Applier
MATERIAL:	FINISH:	WEIGHT:	ANGLES:	SIZE: A1	CAGE CODE: 00779	DRAWING NO: C-2150013	RESTRICTED TO:
Customer Accessible Production Drawing				SCALE: 1:1	SHEET: 4	OF: 4	REV: B