

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART						
					CONVERT TO	PART NUMBERS REQUIRED					
	2266309-1	A	FINE CRIMP HEIGHT ADJUST	MECHANICAL	PNEUMATIC FEED	2119950-1	1338685-1	5-18022-5	2119641-1	2119799-1	2063440-1
	2266309-2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	SERVO LATCH PLATE	2119951-1	-	8-2266309-5	1901094-3	1-1752354-5	2168400-6 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2266309-4	-	-	
					MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-1	-	
	2266309-5	A	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE	SERVO LATCH PLATE	2119951-1	-	8-2266309-5	1901094-3	1-1752354-5	2168400-6 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2266309-4	-	-	
	2266309-6	A	NON-CRIMP HEIGHT ADJUST	SERVO LATCH PLATE	MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-1	-	-
2266309-7	A	FINE CRIMP HEIGHT ADJUST	NONE	PNEUMATIC FEED	2119950-1	1338685-1	5-18022-5	2119641-1	2119799-1	2063440-1	
7-2266309-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-	

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.29 mm [.090]	F
INSUL	2.45 mm [.096]	F

APPLICATOR INSTRUCTIONS
408-10389

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: .070 SERIES RECEPTACLE CONTACT			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
3.50-4.50 mm [1.38-.177 IN]		2.00-2.60 mm [.079-.102 IN]	1.70-2.40 mm [.067-.094 IN]
TERMINAL APPLICATION SPECIFICATION	(A)114-5092		
	(B)114-5092-3		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
(A) 173645-1	(A) 173645-2	(A) 173645-3	(A) 173645-4
(A) 173645-5	(B) 175189-1		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.25mm2	1.52+/-0.05 [.060+/- .002]	6.3
0.85mm2	1.37+/-0.05 [.054+/- .002]	7.8
0.50mm2	1.25+/-0.05 [.049+/- .002]	9.2

- 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: 8-2266309-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2266309-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2266309-5
SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2266309-6
- 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 ITEMS 242.
FOR -6 ONLY APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 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 4.28.
- 13

***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	-	-	-	2119758-1	RAM, AMP STYLE, SIDE FEED, NON-ADJ.	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)

SET UP GAUGE	LOC	DIST	REVISIONS					
2119599-1	A	66	P	LTN	DESCRIPTION	DATE	OWN	APVD
			A		RELEASED	16MAY2014	LG	TE
			A1		ECR-14-017986	02DEC2014	KH	TE

-	1	1	1	1	1	2119082-7	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
-	1	1	1	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
-	-	2	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	1	-	-	2119740-2	TAG, IDENTIFICATION	213
-	-	1	1	-	-	1901094-3	SPACER, FEEDER	198
-	1	1	1	1	1	1-1752354-5	STANDOFF, HOLD-DOWN	180
-	1	1	1	1	1	993111-1	PIN, SLOTTED SPRING 3.0 X 20.0	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
-	REF	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	-	-	-	1	-	240638-1	SPRING, FEED FINGER	163
-	-	-	-	1	-	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854	137
-	-	-	-	1	-	2119799-1	HOLDER, FEED FINGER, AF	136
-	-	REF	REF	-	-	SEE NOTE 4	MEMORY CHIP, PROGRAMMED	135
-	-	1	1	-	-	1633743-1	SERVO FEED LATCH ASM	133
-	1	1	1	1	1	1-18028-2	WASHER, FLAT, REG M4	119
-	-	REF	REF	-	-	2119944-1	FEED FINGER ASSEMBLY, SF	117
-	1	1	1	1	1	455888-4	SPACER, CRIMPER	82
-	1	1	1	1	1	22278-8	SPRING, COMPRESSION	77
-	1	1	1	1	1	854769-4	HOLDER, INS	74
-	1	1	1	1	1	2119956-1	DOCUMENTATION PACKAGE	71
-	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	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	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	1	1	1	1	1	21028-2	PIN, SLOTTED SPRING .062 X .250	58
-	-	-	-	1	1	1338685-1	PAWL, FEED	56
-	4	4	4	4	4	2168400-1	SHCS, LOW HEAD, RoHS, M4 X 12	54
-	1	1	1	1	1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52
-	1	1	1	1	1	1901681-1	HOLDDOWN, TERMINAL	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	2119656-9	APPLICATOR BASIC ASSEMBLY, SF	46
-	1	-	1	1	1	2119370-1	RAM, AMP STYLE, SIDE 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
-	1	1	1	1	1	1752356-3	SUPPORT, TERMINAL	34
-	2	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	1	1	1	1	1	2161328-1	HEX HEAD, FLANGED, M5 x 8mm LONG	32
-	1	1	1	1	1	1-1320908-0	SPACER, STRIP GUIDE	30
-	1	1	1	1	1	2119959-1	ASSEMBLY, STRIP GUIDE	29
-	1	1	1	1	1	455888-3	SPACER, CRIMPER	28
-	1	1	1	1	1	1320928-2	STRIP GUIDE	24
-	1	1	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
-	1	1	1	1	1	1-18028-2	WASHER, FLAT, REG M4	20
-	1	1	1	1	1	2119533-1	STRIPPER, SIDE FEED	19
-	1	1	1	1	1	2119806-1	INSERT, SHEAR	13
-	1	1	1	1	1	3-22280-3	SPRING, COMPRESSION	12
-	1	1	1	1	1	1-356885-4	STOP, SHEAR	11
-	1	1	1	1	1	2119805-1	SHEAR HOLDER, FRONT	10
-	1	1	1	1	1	462006-6	FLOATING SHEAR, FRONT	9
-	1	1	1	1	1	1-1633922-8	ANVIL, COMBINATION	8
-	-	-	-	-	-	-	-	7
-	-	-	-	-	-	-	-	6
-	1	1	1	1	1	1-2119780-2	DEPRESSOR, SHEAR	5
-	1	1	1	1	1	238011-9	BLOCK, CRIMPER SPACER	4
-	1	1	1	1	1	8-1633961-0	CRIMPER, INSULATION F PREMIUM	3
-	1	1	1	1	1	455888-4	SPACER, CRIMPER	2
-	1	1	1	1	1	4-456406-3	CRIMPER, WIRE PREMIUM	1
-77	-7	-6	-5	-2	-1	PART NO	DESCRIPTION	ITEM NO

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		MATERIAL:		FINISH:		WEIGHT:	
mm	0 PLC ±.05	1 PLC ±.05	2 PLC ±.05	3 PLC ±.05	4 PLC ±.05	ANGLES ±.0001			

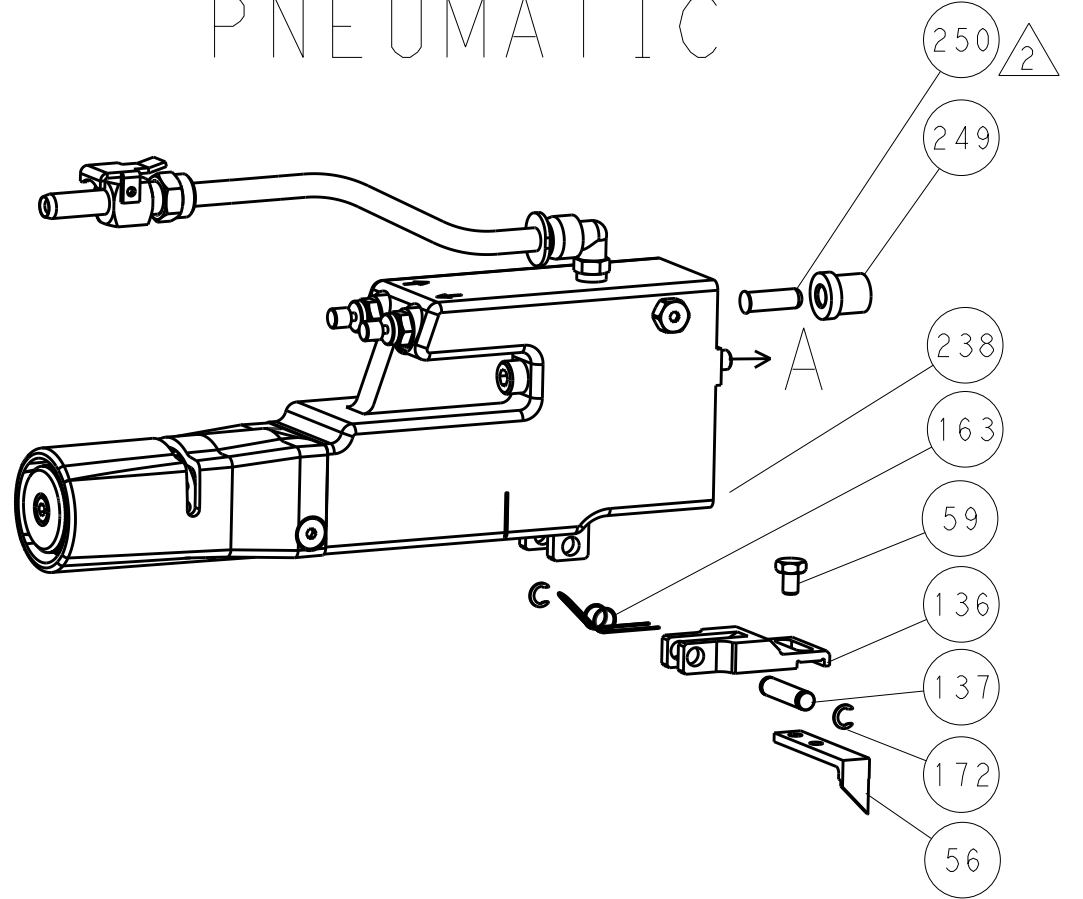
DLN	15MAY2014	TE Connectivity
CHK	15MAY2014	Harrisburg, PA 17105-3608
APVD	15MAY2014	
NAME	Ocean Side Feed Applicator	
SIZE	CAGE CODE	DRAWING NO
A1	00779	2266309
Customer Accessible Production Drawing		
SCALE	1:2	SHEET 1 OF 4
REV	A1	

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

FEED TYPE MECHANICAL



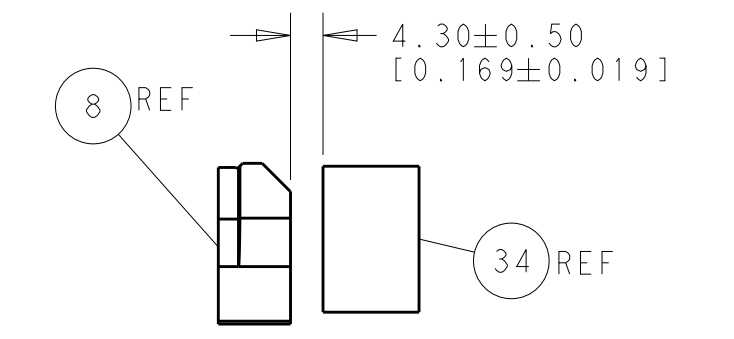
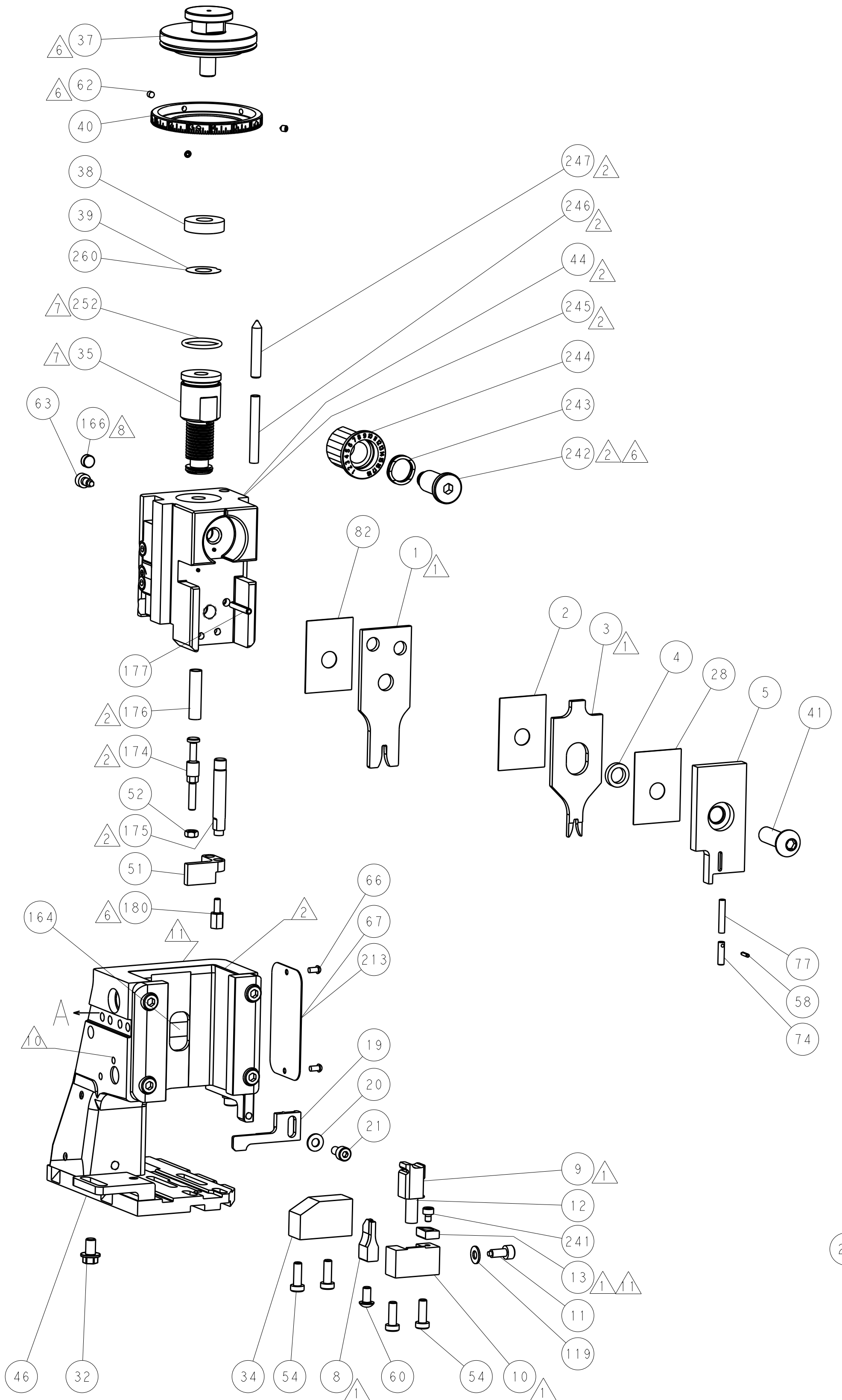
PNEUMATIC



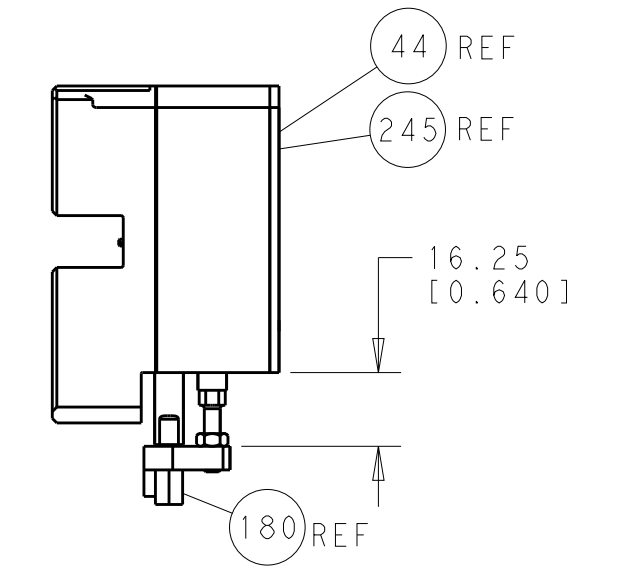
SERVO LATCH PLATE



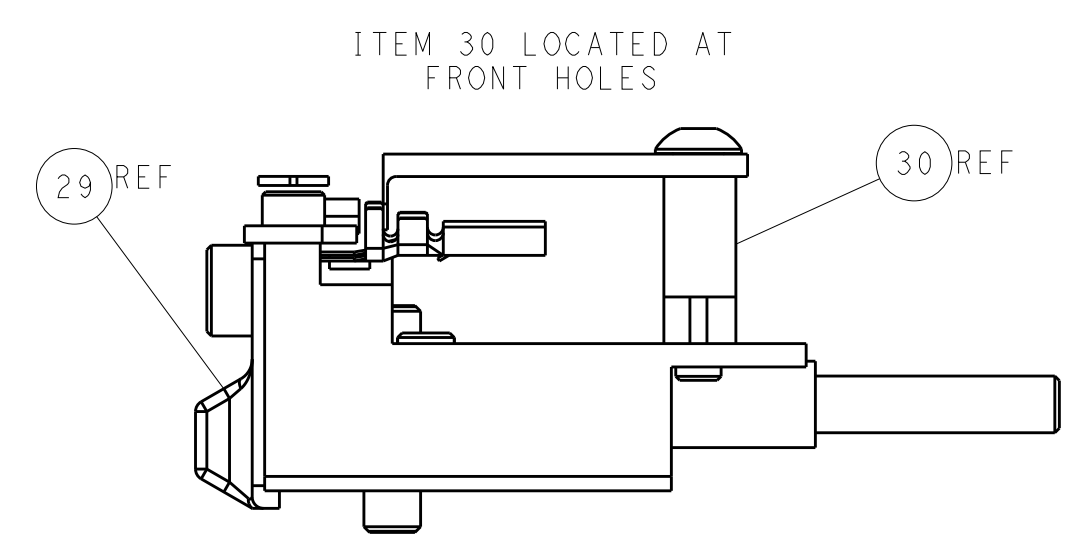
CAM POSITIONS



TERMINAL SUPPORT LOCATION



HOLDDOWN SET-UP



FEED TRACK POSITION GUIDE BY INSULATION BARREL

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 03OCT2013		TE Connectivity	
mm	0 PLC ±0.5	1 PLC ±0.5	2 PLC ±0.13	3 PLC ±0.013	4 PLC ±0.001	ANGLES ±0.0001	FINISH
MATERIAL		WEIGHT		APVD M. CLIFFORD	NAME Ocean Side Feed Applicator	SIZE A1	CAGE CODE 00779
Customer Accessible Production Drawing				SCALE 1:2	SHEET 2 of 4	REV A1	RESTRICTED TO

PACIFIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART						
					CONVERT TO	PART NUMBERS REQUIRED					
	2-2266309-1	A	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	-	8-2266309-5	1901094-3	1-1752354-5	2168400-6 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2266309-4	-	-	-
	2-2266309-2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-2	-	-
					SERVO LATCH PLATE	2119951-1	-	8-2266309-5	1901094-3	1-1752354-5	2168400-6 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2266309-4	-	-	-
	2-2266309-5	A	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
	2-2266309-7	A	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	-
	7-2266309-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.29 mm [.090]	F
INSUL	2.45 mm [.096]	F
APPLICATOR INSTRUCTIONS 408-10389		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: .070 SERIES RECEPTACLE CONTACT			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
3.50-4.50 mm [.138-.177 IN]		∅2.00-2.60 mm [.079-.102 IN]	∅1.70-2.40 mm [.067-.094 IN]
TERMINAL APPLICATION SPECIFICATION	(A)114-5092		
	(B)114-5092-3		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
(A) 173645-1	(A) 173645-2	(A) 173645-3	(A) 173645-4
(A) 173645-5	(B) 175189-1		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.25mm2	1.52+/-0.05 [1.060+/-0.002]	6.3
0.85mm2	1.37+/-0.05 [1.054+/-0.002]	7.8
0.50mm2	1.25+/-0.05 [1.049+/-0.002]	9.2

- 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: 8-2266309-4
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2266309-4
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2266309-5
- 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 62,180
 APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEMS 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.

TERMINAL PART NUMBER	INSULATION DIAMETER RANGE
173645	∅2.0-2.6 mm [.079-.102 IN]
345212	∅1.7-2.4 mm [.067-.094 IN]
175189	∅2.0-2.6 mm [.079-.102 IN]

***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	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	2119082-7	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-77	-27	-25	-22	-21	PART NO	DESCRIPTION	ITEM NO

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	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	
	-	1	1	1	1	1-1752354-5	STANDOFF, HOLD-DOWN	180	
	-	1	1	1	1	993111-1	PIN, SLOTTED SPRING 3.0 X 20.0	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.	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	
	-	1	1	1	1	1-2119656-0	APPLICATOR BASIC ASSEMBLY, SF	141	
	-	1	1	1	1	2119650-1	RAM, ASIAN STYLE, SIDE FEED	140	
	-	1	1	1	1	2119092-2	BOLT, ADJUSTMENT	139	
	-	-	-	1	-	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854	137	
	-	-	-	1	-	2119799-1	HOLDER, FEED FINGER, AF	136	
	-	-	REF	-	-	-	SEE NOTE 4	MEMORY CHIP, PROGRAMMED	135
	-	-	1	-	-	1633743-1	SERVO FEED LATCH ASM	133	
	-	1	1	1	1	1-18028-2	WASHER, FLAT, REG M4	119	
	-	-	REF	-	-	2119944-1	FEED FINGER ASSEMBLY, SF	117	
	-	1	1	1	1	455888-4	SPACER, CRIMPER	82	
	-	1	1	1	1	22278-8	SPRING, COMPRESSION	77	
	-	1	1	1	1	854769-4	HOLDER, INS	74	
	-	1	1	1	1	2119956-1	DOCUMENTATION PACKAGE	71	
	-	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	2119793-1	LIMITER, ADJUSTMENT BOLT	63	
	-	3	3	3	3	992763-5	SCR, SET, SOC, CONE POINT, M3 x 4.0	62	
	-	-	-	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59	
	-	1	1	1	1	21028-2	PIN, SLOTTED SPRING .062 X .250	58	
	-	-	-	1	1	1338685-1	PAWL, FEED	56	
	-	1	1	1	1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52	
	-	1	1	1	1	1901681-1	HOLDDOWN, TERMINAL	51	
	-	-	-	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	1-2119644-2	RAM WASHER, PRECISION	38	
	-	1	1	1	1	1752356-3	SUPPORT, TERMINAL	34	
	-	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33	
	-	1	1	1	1	2161328-1	HEX HEAD, FLANGED, M5 x 8mm LONG	32	
	-	1	1	1	1	1-1320908-0	SPACER, STRIP GUIDE	30	
	-	1	1	1	1	2119959-1	ASSEMBLY, STRIP GUIDE	29	
	-	1	1	1	1	455888-3	SPACER, CRIMPER	28	
	-	1	1	1	1	1320928-2	STRIP GUIDE	24	
	-	1	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21	
	-	1	1	1	1	1-18028-2	WASHER, FLAT, REG M4	20	
	-	1	1	1	1	2119533-1	STRIPPER, SIDE FEED	19	
	-	1	1	1	1	2119806-1	INSERT, SHEAR	13	
	-	1	1	1	1	3-22280-3	SPRING, COMPRESSION	12	
	-	1	1	1	1	1-356885-4	STOP, SHEAR	11	
	-	1	1	1	1	2119805-1	SHEAR HOLDER, FRONT	10	
	-	1	1	1	1	462006-6	FLOATING SHEAR, FRONT	9	
	1	1	1	1	1	1-1633922-8	ANVIL, COMBINATION	8	
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	-	-	-	-	-	-	-	6	
	-	1	1	1	1	1-2119780-2	DEPRESSOR, SHEAR	5	
	-	1	1	1	1	238011-9	BLOCK, CRIMPER SPACER	4	
	1	1	1	1	1	8-1633961-0	CRIMPER, INSULATION F PREMIUM	3	
	-	1	1	1	1	455888-4	SPACER, CRIMPER	2	
	1	1	1	1	1	4-456406-3	CRIMPER, WIRE PREMIUM	1	
	-77	-27	-25	-22	-21	PART NO	DESCRIPTION	ITEM NO	

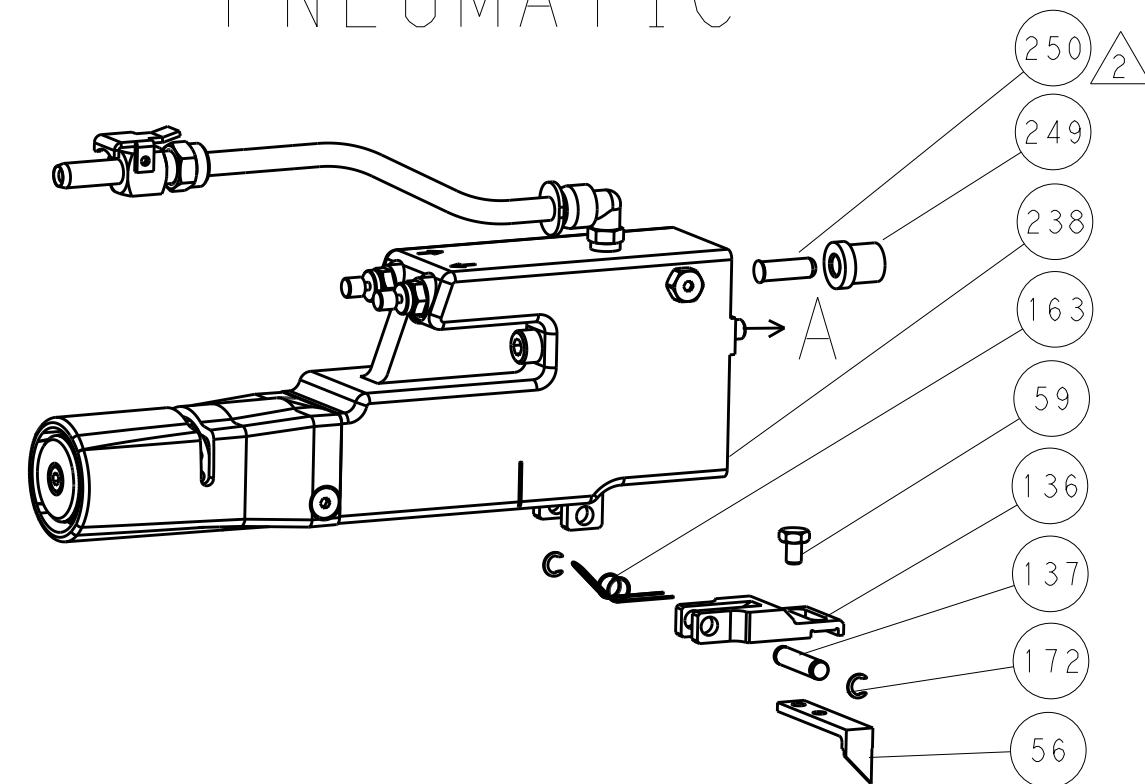
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mm	0 PLC ±.5	1 PLC ±0.5	2 PLC ±0.13	3 PLC ±0.013	4 PLC ±0.001	03OCT2013	TE Connectivity
	ANGLES	±.0001				03OCT2013	Harrisburg, PA 17105-3608
MATERIAL	FINISH					03OCT2013	Ocean Side Feed Applicator
						00779	Customer Accessible Production Drawing
						2266309	SCALE 1:2 SHEET 3 OF 4 REV A1

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

FEED TYPE MECHANICAL



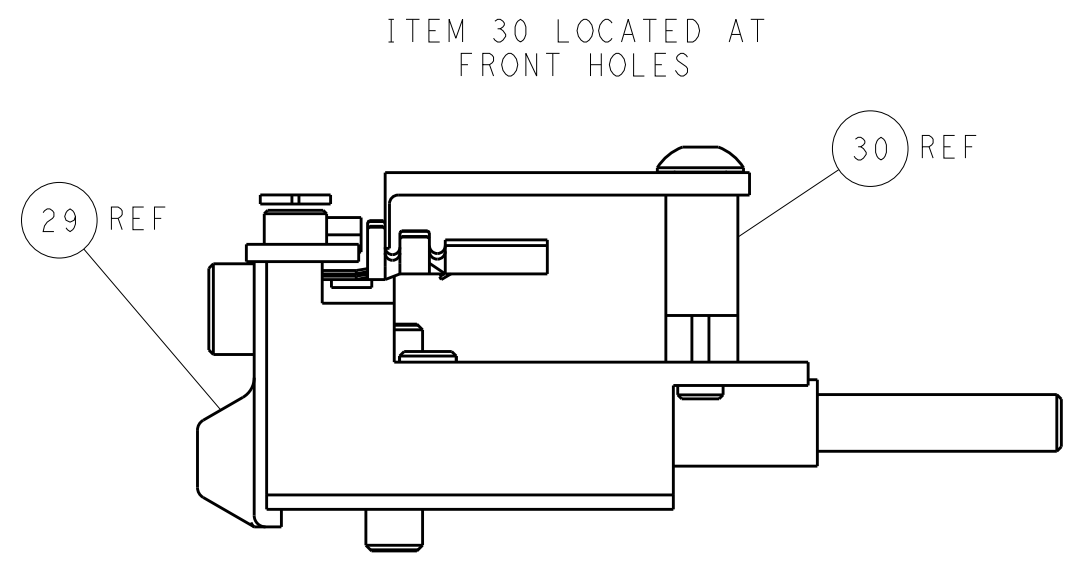
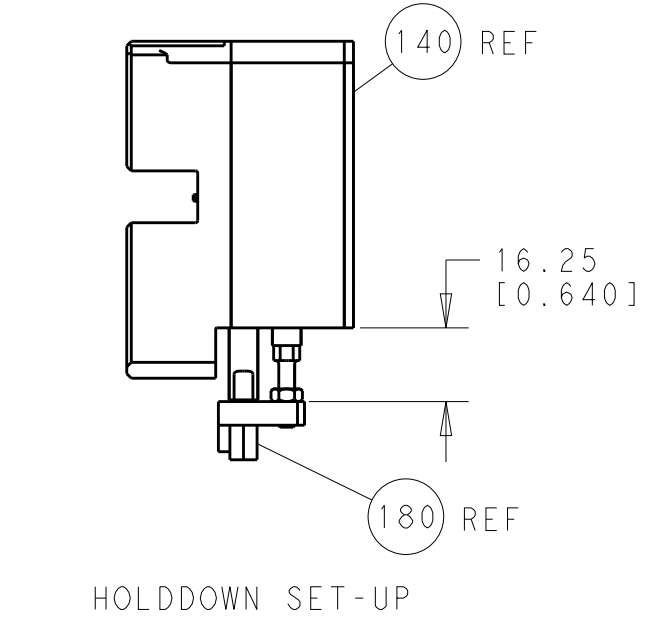
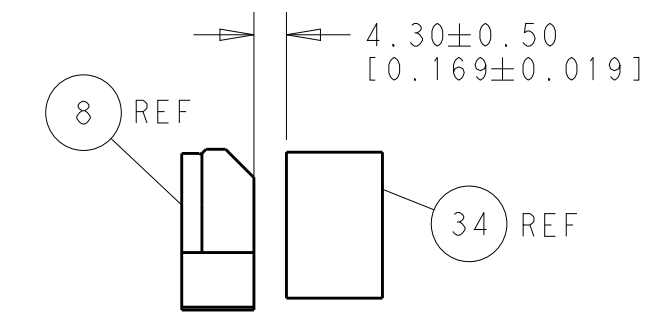
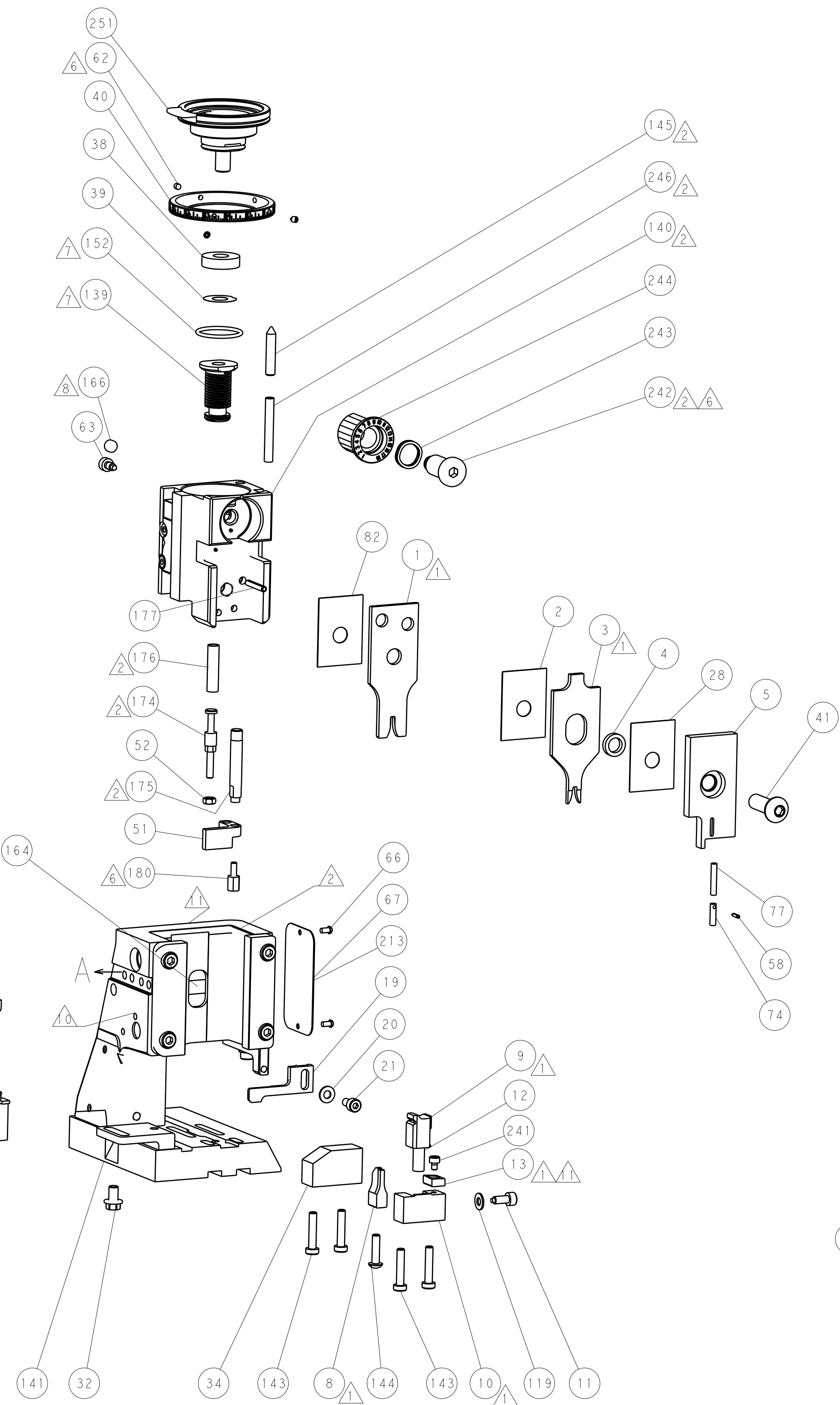
PNEUMATIC



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 03OCT2013		TEL GROSS 03OCT2013		CHG T. ELBIN 03OCT2013		APV M. CLIFFORD 03OCT2013		NAME		TE Connectivity	
mm	0 PLC ±0.5	1 PLC ±0.5	2 PLC ±0.13	3 PLC ±0.013	4 PLC ±0.001	ANGLES ±	FINISH	PRODUCT SPEC	APPLICATION SPEC	SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO	Harrisburg, PA 17105-3608	
MATERIAL										A1	00779	2266309		Ocean Side Feed Applicator	
Customer Accessible Production Drawing										SCALE	1:2	SHEET	4	OF	4
										REV	A1				