

| ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER | PART NUMBER | REVISION | DESCRIPTION | FEED TYPE | APPLICATOR STYLE CONVERSION CHART | | | | | | |
|---|-------------|----------|--------------------------|--|-----------------------------------|-----------------------|-----------|-------------|-----------|---|------------------------|
| | | | | | CONVERT TO | PART NUMBERS REQUIRED | | | | | |
| | 2150122-1 | A | FINE CRIMP HEIGHT ADJUST | MECHANICAL | PNEUMATIC FEED | 2119950-1 | 2119792-2 | - | 2119641-1 | - | 2063440-1 |
| | | | | | SERVO LATCH PLATE | 2119951-1 | 1901697-1 | 8-2150122-5 | - | - | 2168400-7 (QUANTITY 2) |
| | | | | | SMART APPLICATOR | 2161326-1 | - | 8-2150122-4 | - | - | - |
| | 2150122-2 | A | FINE CRIMP HEIGHT ADJUST | PNEUMATIC | MECHANICAL FEED | 2119949-1 | 2063961-1 | 5-18022-5 | 2119653-1 | - | - |
| | | | | | SERVO LATCH PLATE | 2119951-1 | 1901697-1 | 8-2150122-5 | - | - | 2168400-7 (QUANTITY 2) |
| | | | | | SMART APPLICATOR | 2161326-1 | - | 8-2150122-4 | - | - | - |
| | 2150122-5 | A | FINE CRIMP HEIGHT ADJUST | SERVO LATCH PLATE ⁴ | MECHANICAL FEED | 2119949-1 | 2063961-1 | 5-18022-5 | 2119653-1 | - | - |
| | | | | | PNEUMATIC FEED | 2119950-1 | 2119792-2 | - | 2119641-1 | - | 2063440-1 |
| | | | | | - | - | - | - | - | - | - |
| | 2150122-6 | A | NON-CRIMP HEIGHT ADJUST | SERVO LATCH PLATE ⁴ ¹² | - | - | - | - | - | - | - |
| | | | | | - | - | - | - | - | - | - |
| | 7-2150122-7 | A | FINE CRIMP HEIGHT ADJUST | NONE | - | - | - | - | - | - | - |
| | | | | | CRIMP TOOLING KIT | - | - | - | - | - | - |

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

| TERMINAL DATA: TE TERMINAL | | TE CRIMP SPECIFICATION |
|------------------------------------|-------------|---------------------------|
| TERMINAL NAME: SPLICE | | |
| WIRE STRIP LENGTH | | INSULATION DIAMETER RANGE |
| 4.82-5.84 mm [.190-.230 IN] | | |
| TERMINAL APPLICATION SPECIFICATION | 114-2088 | |
| TERMINALS APPLIED ³ | | |
| TE TERMINAL | TE TERMINAL | TE TERMINAL |
| 41974 | 41975 | |

| WIRE SIZE | CRIMP HEIGHT mm [INCH] | CRIMP HEIGHT REFERENCE SETTING |
|-----------|----------------------------|--------------------------------|
| 3200 CMA | 1.73+/-0.05 [.068+/- .002] | - |
| 1000 CMA | 1.42+/-0.05 [.056+/- .002] | - |

- 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: 8-2150122-4
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150122-4
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150122-5
 SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2150122-6
- 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. 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 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 TERMINAL LUBRICANT IS RECOMMENDED.
- ¹⁴ REFER TO TERMINAL CUSTOMER DRAWING FOR CRIMP HEIGHT FORMULA TO CALCULATE SPECIFIC CRIMP HEIGHTS.

***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)

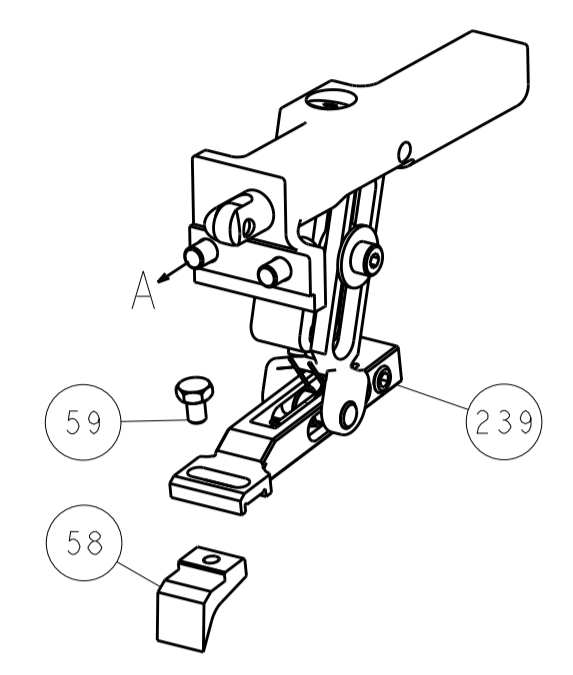
| SET UP GAUGE | LOC | DIST | REVISIONS | | | |
|--------------|-----|------|-----------|---------------|----|-----------------|
| 2119599-2 | A | 66 | REV | DATE | BY | APPV |
| | | | A | RELEASED | | 03JUL2014 LG TE |
| | | | A1 | ECR-14-014956 | | 08OCT2014 JH TE |

| | | | | | | | | |
|--------------|---|--------------------|---|---|---|-------------|--|-----|
| - | - | 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 |
| - | - | - | - | 1 | - | 2119641-1 | FEED CAM, AIR FEED | 248 |
| - | - | 1 | - | 1 | 1 | 2119798-1 | DETENT PIN | 247 |
| - | - | 1 | - | 1 | 1 | 1-22279-3 | SPRING, COMPRESSION | 246 |
| - | - | 1 | - | - | - | 2161315-1 | RAM, STEPPED, AMP STYL, EF, NON-ADJUST | 245 |
| - | - | 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 |
| - | - | - | - | 2 | - | 21045-3 | RING, RETAIN, EXTERN, 3/16 CRESCENT | 172 |
| - | - | 1 | 1 | 1 | 1 | 994969-1 | MAGNET, RARE EARTH HIGH ENERGY | 166 |
| - | - | REFREFREFREFREFREF | - | - | - | 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 | 2119955-2 | ASSY, LUBRICATOR, END FEED | 84 |
| - | - | 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 | 2119740-1 | TAG, IDENTIFICATION | 67 |
| - | - | 2 | 2 | 2 | 2 | 2168078-1 | SCREW, DRIVE, RH, RoHS, 2 x .188 | 66 |
| - | - | 2 | 2 | 2 | 2 | 2168400-5 | SHCS, LOW HEAD, RoHS, M4 X 20 | 64 |
| - | - | 1 | - | 1 | 1 | 2119793-1 | LIMITER, ADJUSTMENT BOLT | 63 |
| ⁶ | - | 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 |
| - | - | 3 | 3 | 3 | 3 | 2168400-4 | SHCS, LOW HEAD, RoHS, M4 X 8 | 57 |
| - | - | 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 | 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 | 2119653-1 | FEED CAM, POST FEED | 47 |
| - | - | 1 | 1 | 1 | 1 | 2119655-5 | APPLICATOR BASIC ASSEMBLY, EF | 46 |
| - | - | 1 | - | 1 | 1 | 2161310-1 | RAM, STEPPED, AMP STYLE, END FEED | 44 |
| - | - | 1 | 1 | 1 | 1 | 2079383-7 | SCR, BHSC, RoHS (M8 X 25) | 41 |
| - | - | 1 | - | 1 | 1 | 2119645-1 | DISC, NUMBERED FA WIRE ADJUSTMENT | 40 |
| - | - | 1 | - | 1 | 1 | 2119957-1 | APPLICATOR SHIM PACK | 39 |
| - | - | 1 | 1 | 1 | 1 | 2119644-1 | RAM WASHER, PRECISION | 38 |
| ⁶ | - | 1 | 1 | 1 | 1 | 2119085-1 | FA HEAD, ATLANTIC STYLE | 37 |
| - | - | 1 | - | 1 | 1 | 2119092-1 | BOLT, ADJUSTMENT | 35 |
| - | - | 7 | 7 | 7 | 7 | 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 | 690455-3 | STRIPPER, FRONT CASTING | 27 |
| - | - | 2 | 2 | 2 | 2 | 1320906-1 | STUD, THREADED | 25 |
| - | - | 1 | 1 | 1 | 1 | 1752371-1 | PLATE, STRIP GUIDE | 24 |
| - | - | 1 | 1 | 1 | 1 | 240825-9 | PLATE, STRIP HOLD DOWN | 23 |
| - | - | 2 | 2 | 2 | 2 | 2-22281-3 | SPRING, COMPRESSION | 22 |
| - | - | 1 | 1 | 1 | 1 | 1752373-4 | DRAG | 20 |
| - | - | 2 | 2 | 2 | 2 | 1901259-4 | GUIDE, LOWER STRIP | 18 |
| - | - | 4 | 4 | 4 | 4 | 1-2079383-1 | SCR, BHSC, RoHS (M6 X 12) | 17 |
| ¹ | - | 1 | 1 | 1 | 1 | 240644-1 | PLATE, REAR SHEAR | 11 |
| - | - | 2 | 2 | 2 | 2 | 240645-1 | SPACER, SHEAR PLATE | 10 |
| - | - | 1 | 1 | 1 | 1 | 690619-5 | PLATE, RETAINING | 9 |
| ¹ | 1 | 1 | 1 | 1 | 1 | 4-690618-8 | ANVIL, SPLICE TYPE | 8 |
| ¹ | - | 1 | 1 | 1 | 1 | 2-459722-7 | BLADE, SHEAR | 7 |
| - | - | - | - | - | - | - | - | 6 |
| - | - | - | - | - | - | - | - | 5 |
| - | - | - | - | - | - | - | - | 4 |
| - | - | - | - | - | - | - | - | 3 |
| - | - | - | - | - | - | - | - | 2 |
| ¹ | 1 | 1 | 1 | 1 | 1 | 4-459736-0 | CRIMPER, WIRE | 1 |

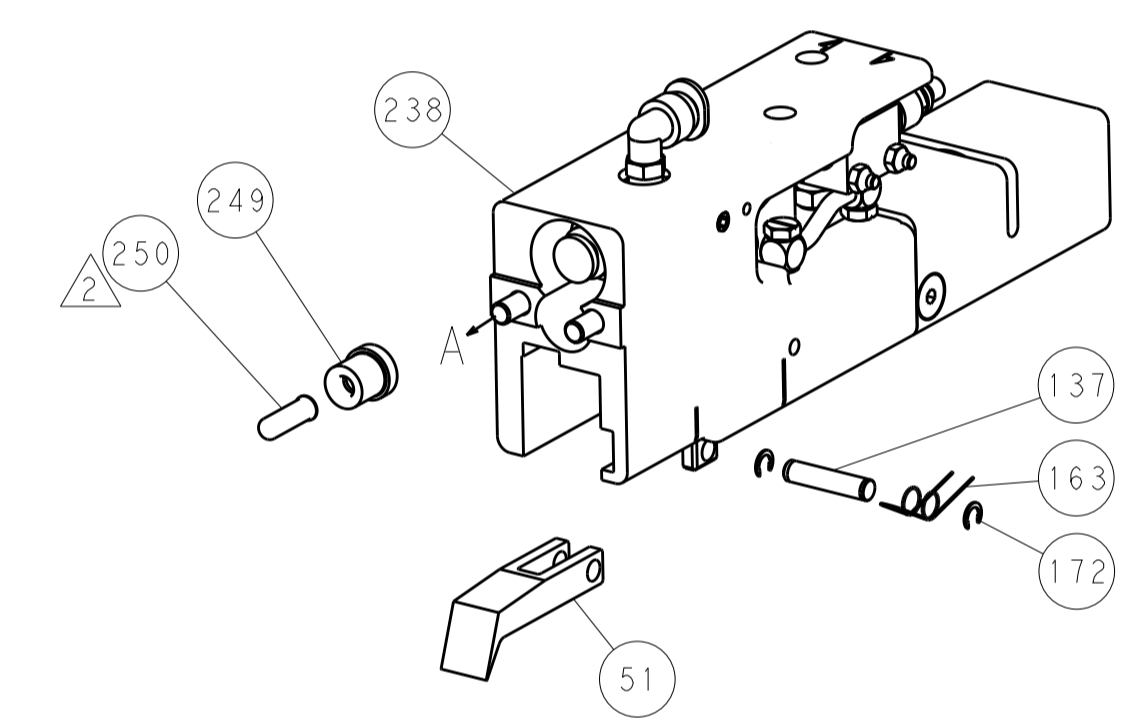
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|-------------|--|--|--------|---|--|
| DIMENSIONS: | | TOLERANCES UNLESS OTHERWISE SPECIFIED: | | DWN: STAKEM 13MAY2014 CHK: G. BAILEY 13MAY2014 APVD: T. ERLIN 13MAY2014 | TE Connectivity Harrisburg, PA 17105-3608 |
| mm | 0 PLC ±.5 1 PLC ±.13 2 PLC ±.013 3 PLC ±.008 4 PLC ±.004 | ANGLES ±.0001 | FINISH | PRODUCT SPEC APPLICATION SPEC | NAME: Ocean End Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2150122 |
| MATERIAL: | | | | WEIGHT: | RESTRICTED TO: |
| | | | | Customer Accessible Production Drawing | SCALE: 1:1 SHEET 1 OF 4 REV: A1 |

| LOC | DIST | REV | DATE | BY | APPV |
|-----------|------|-----|------|----|------|
| A | 66 | | | | |
| REVISIONS | | | | | |
| | | | | | |
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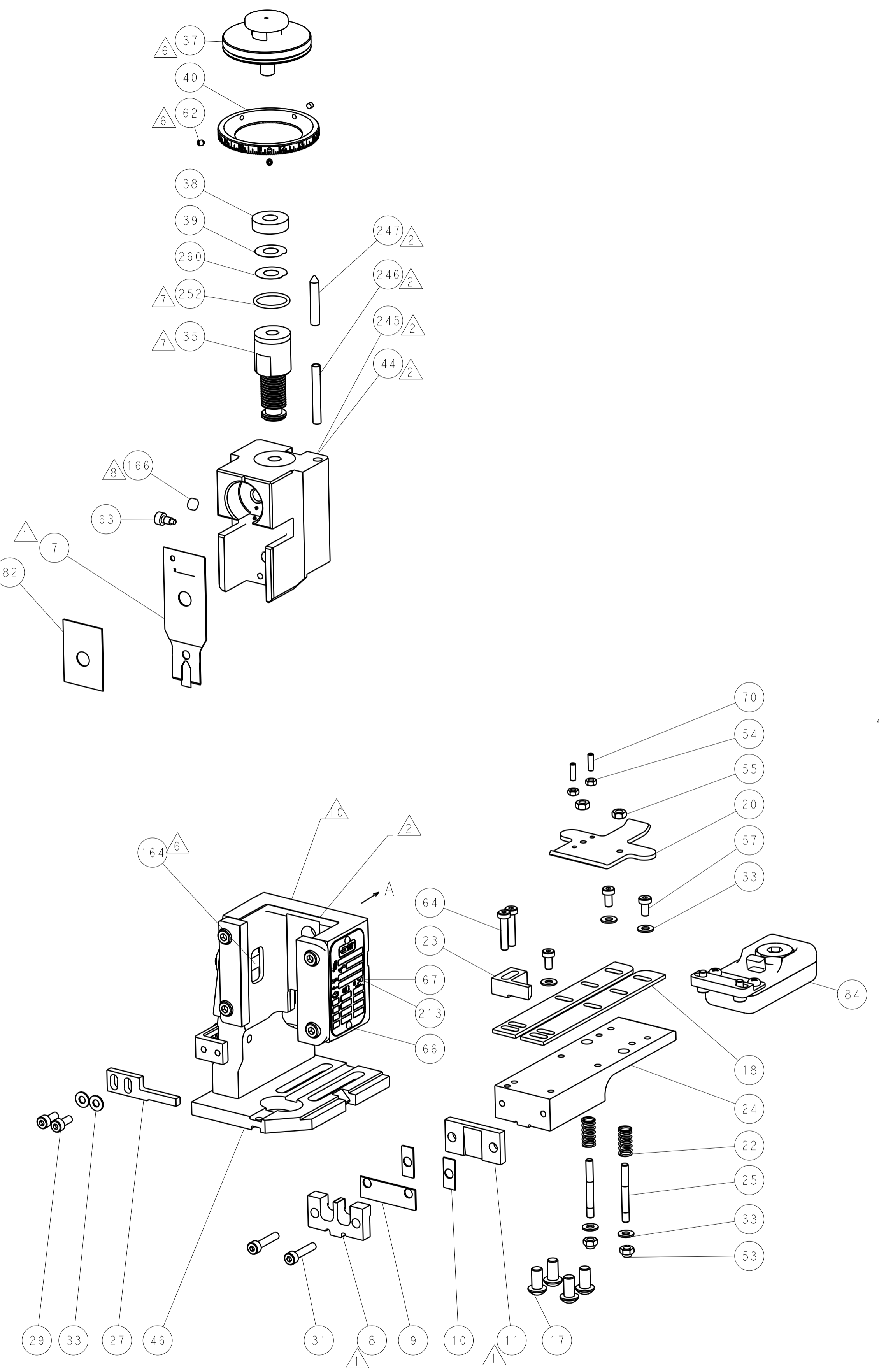
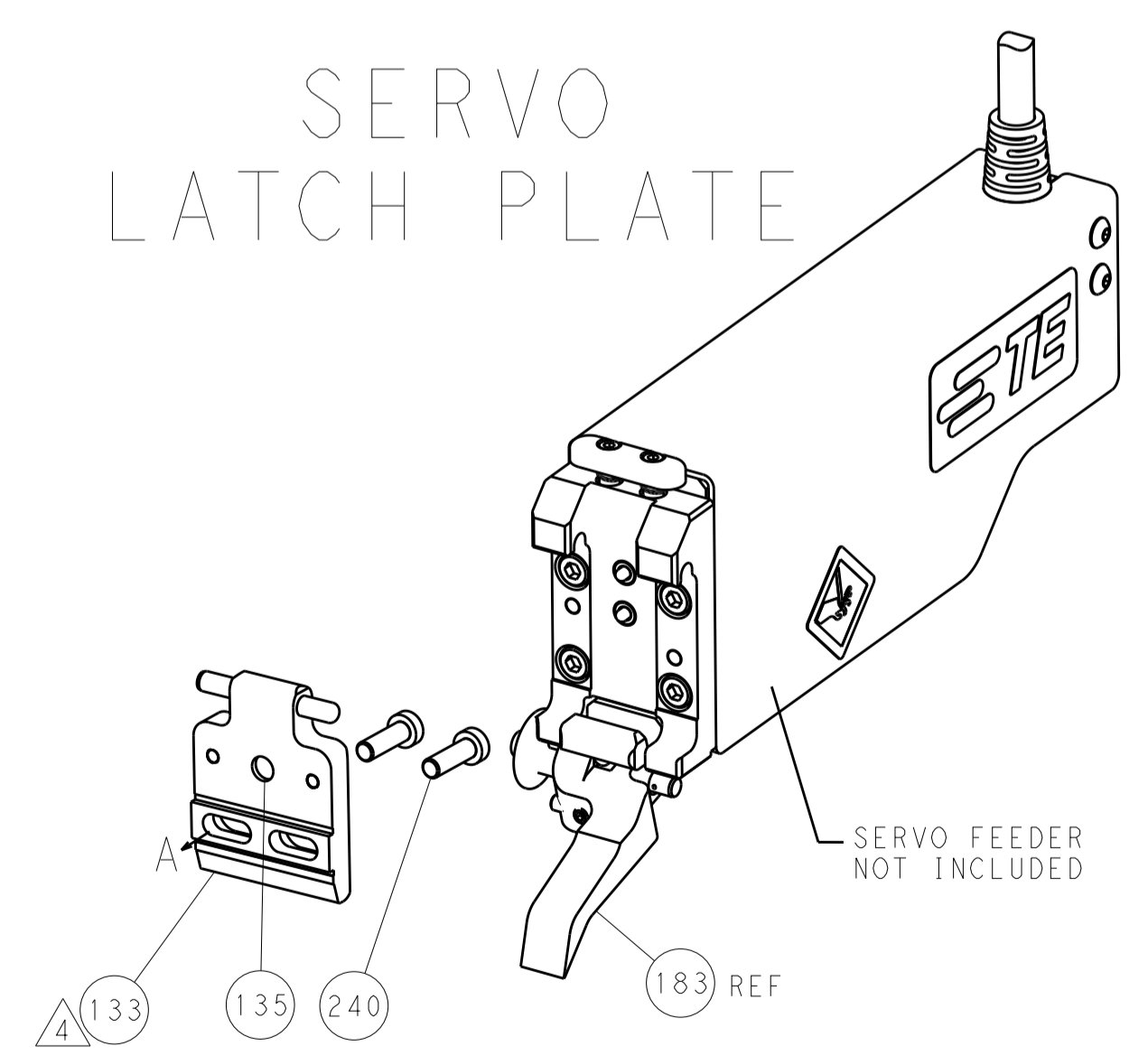
FEED TYPE MECHANICAL



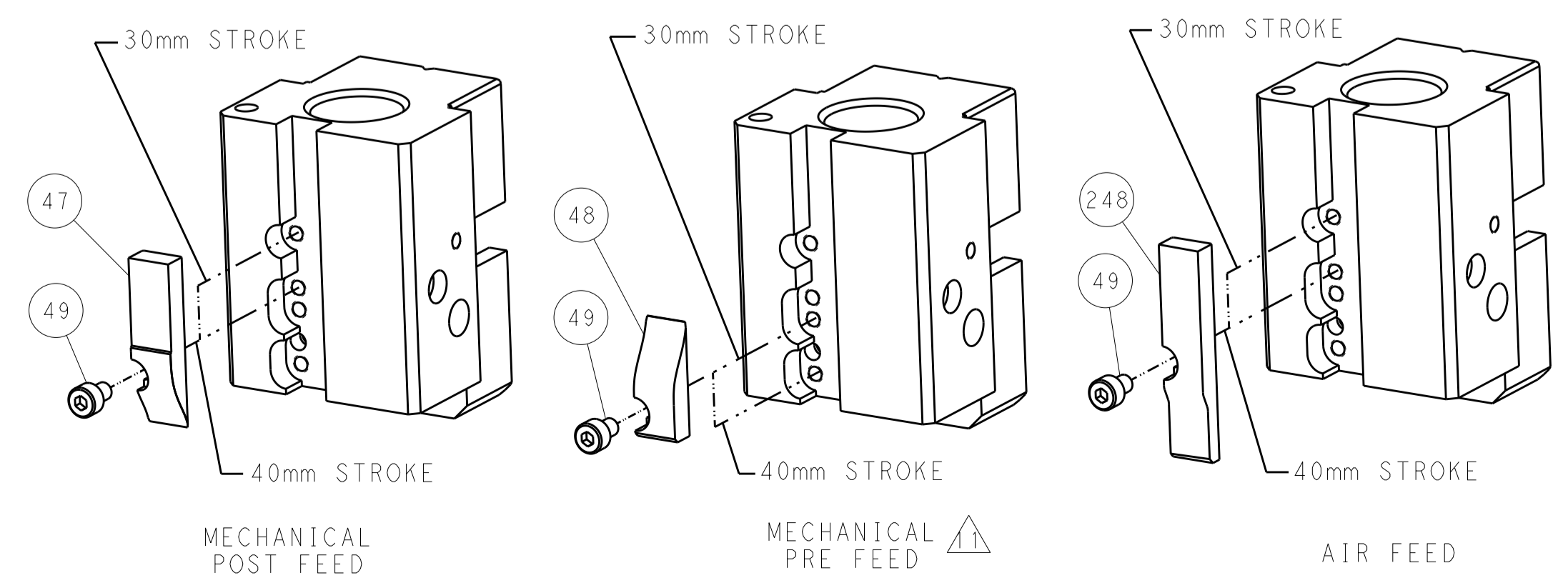
PNEUMATIC



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)

| | | | |
|---|--|--|--|
| <small>THE INFORMATION CONTAINED HEREON IS UNCLASSIFIED EXCEPT WHERE SHOWN OTHERWISE. IT IS SUBJECT TO CHANGE AND WITHOUT WARRANTY OF ACCURACY OR COMPLETION. IT IS THE USER'S RESPONSIBILITY TO CONTACT THE ORIGINAL SOURCE FOR THE LATEST REVISION.</small> | | DWN: K. STAKEM 13MAY2014 CHK: G. BAILEY 13MAY2014 APVD: T. ERLIN 13MAY2014 | TE Connectivity Harrisburg, PA 17105-3608 |
| DIMENSIONS: mm | | TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±0.5 1 PLC ±0.13 3 PLC ±0.013 4 PLC ±0.001 ANGLES ±0.001 | NAME: Ocean End Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: C-2150122 |
| MATERIAL: | | WEIGHT: | RESTRICTED TO: |
| CUSTOMER ACCESSIBLE PRODUCTION DRAWING | | SCALE: 1:1 | SHEET 2 OF 4 REV A1 |

| PACIFIC VERSION TERMINATOR INTERFACE ADAPTER | PART NUMBER | REVISION | DESCRIPTION | FEED TYPE | APPLICATOR STYLE CONVERSION CHART | | | | | | |
|--|-------------|----------|--------------------------|-------------------|-----------------------------------|-----------------------|-----------|-------------|-----------|---|------------------------|
| | | | | | CONVERT TO | PART NUMBERS REQUIRED | | | | | |
| | 2-2150122-1 | A | FINE CRIMP HEIGHT ADJUST | MECHANICAL | PNEUMATIC FEED | 2119950-1 | 2119792-2 | - | 2119641-2 | - | 2063440-1 |
| | | | | | SERVO LATCH PLATE | 2119951-1 | 1901697-1 | 8-2150122-5 | - | - | 2168400-7 (QUANTITY 2) |
| | | | | | SMART APPLICATOR | 2161326-1 | - | 8-2150122-4 | - | - | - |
| | 2-2150122-2 | A | FINE CRIMP HEIGHT ADJUST | PNEUMATIC | MECHANICAL FEED | 2119949-1 | 2063961-1 | 5-18022-5 | 2119653-2 | - | - |
| | | | | | SERVO LATCH PLATE | 2119951-1 | 1901697-1 | 8-2150122-5 | - | - | 2168400-7 (QUANTITY 2) |
| | | | | | SMART APPLICATOR | 2161326-1 | - | 8-2150122-4 | - | - | - |
| | 2-2150122-5 | A | 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 |
| | 2-2150122-7 | A | FINE CRIMP HEIGHT ADJUST | NONE | - | - | - | - | - | - | - |
| | 7-2150122-7 | A | CRIMP TOOLING KIT | - | - | - | - | - | - | - | - |

| APPLICATOR DATA | | |
|--------------------------------|----------------|------|
| CRIMP | SIZE | TYPE |
| WIRE | 2.79 mm [1.10] | F |
| INSUL | - | - |
| APPL INSTRUCTIONS 408-10390 | | |

| TERMINAL DATA: TE TERMINAL | | TE CRIMP SPECIFICATION |
|--|----------------------|----------------------------------|
| TERMINAL NAME: SPLICE | | |
| WIRE STRIP LENGTH 4.82-5.84 mm [1.90-.230 IN] | | INSULATION DIAMETER RANGE Ø - |
| TERMINAL APPLICATION SPECIFICATION 114-2088 | - | - |
| TERMINALS APPLIED | | |
| TE TERMINAL 41974 | TE TERMINAL 41975 | TE TERMINAL TE TERMINAL |

| WIRE SIZE | CRIMP HEIGHT mm [INCH] | CRIMP HEIGHT REFERENCE SETTING |
|-----------|-----------------------------|--------------------------------|
| 3200 CMA | 1.73+/-0.05 [1.068+/-0.002] | - |
| 1000 CMA | 1.42+/-0.05 [1.056+/-0.002] | - |

- 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: 8-2150122-4
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150122-4
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150122-5
- 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.
- 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.
- TERMINAL LUBRICANT IS RECOMMENDED.
- REFER TO TERMINAL CUSTOMER DRAWING FOR CRIMP HEIGHT FORMULA TO CALCULATE SPECIFIC CRIMP HEIGHTS.

***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)

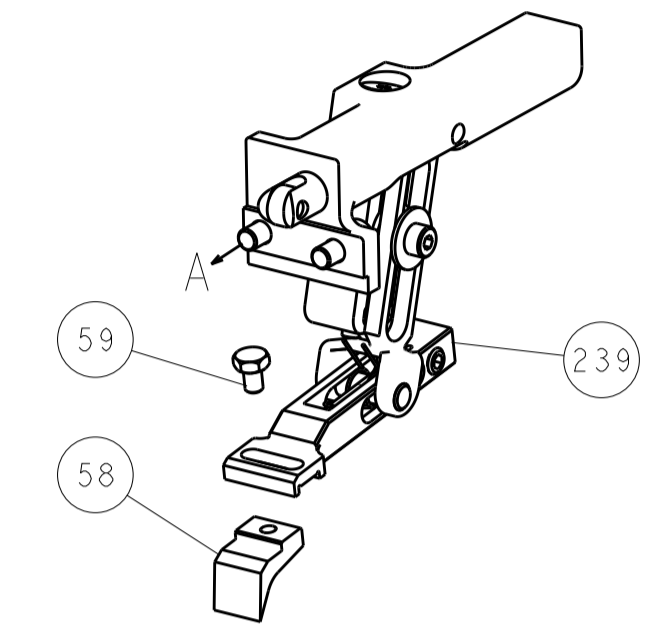
| SET UP GAUGE | LOC | DIST | REVISIONS | | | |
|--------------|-----|------|-----------|-------------|----|------|
| 2119599-2 | A | 66 | REV | DATE | BY | APPV |
| - | - | - | 1 | SEE SHEET 1 | - | - |

| | | | | | | | |
|---|-----|-----|-----|-----|-------------|-------------------------------------|-----|
| - | 1 | 1 | 1 | 1 | 2119782-1 | FINE ADJUST HEAD ASM, PACIFIC STYLE | 251 |
| - | - | - | 1 | - | 2119640-1 | PUSH ROD, AIR FEED | 250 |
| - | - | - | 1 | - | 2079988-1 | BUSHING, LCH5-12, MISUMI | 249 |
| - | 1 | 1 | 1 | 1 | 1-22279-3 | SPRING, COMPRESSION | 246 |
| - | - | 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 |
| - | - | - | 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 | 2119653-2 | FEED CAM, POST FEED | 142 |
| - | 1 | 1 | 1 | 1 | 2119655-6 | APPLICATOR BASIC ASSEMBLY, EF | 141 |
| - | 1 | 1 | 1 | 1 | 2161313-1 | RAM, STEPPED, 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 | 2119955-2 | ASSY, LUBRICATOR, END FEED | 84 |
| - | 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 |
| - | 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 | 5-18022-5 | SCR, HEX HD CAP, M4 X 6.0 | 59 |
| - | - | - | - | 1 | 2063961-1 | FEED FINGER | 58 |
| - | 3 | 3 | 3 | 3 | 2168400-4 | SHCS, LOW HEAD, RoHS, M4 X 8 | 57 |
| - | 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 | - | 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 | 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 |
| - | 7 | 7 | 7 | 7 | 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 | 690455-3 | STRIPPER, FRONT CASTING | 27 |
| - | 2 | 2 | 2 | 2 | 1320906-1 | STUD, THREADED | 25 |
| - | 1 | 1 | 1 | 1 | 1752371-1 | PLATE, STRIP GUIDE | 24 |
| - | 1 | 1 | 1 | 1 | 240825-9 | PLATE, STRIP HOLD DOWN | 23 |
| - | 2 | 2 | 2 | 2 | 2-22281-3 | SPRING, COMPRESSION | 22 |
| - | 1 | 1 | 1 | 1 | 1752373-4 | DRAG | 20 |
| - | 2 | 2 | 2 | 2 | 1901259-4 | GUIDE, LOWER STRIP | 18 |
| - | 1 | 1 | 1 | 1 | 240644-1 | PLATE, REAR SHEAR | 11 |
| - | 2 | 2 | 2 | 2 | 240645-1 | SPACER, SHEAR PLATE | 10 |
| - | 1 | 1 | 1 | 1 | 690619-5 | PLATE, RETAINING | 9 |
| - | 1 | 1 | 1 | 1 | 4-690618-8 | ANVIL, SPLICE TYPE | 8 |
| - | 1 | 1 | 1 | 1 | 2-459722-7 | BLADE, SHEAR | 7 |
| - | - | - | - | - | - | - | 6 |
| - | - | - | - | - | - | - | 5 |
| - | - | - | - | - | - | - | 4 |
| - | - | - | - | - | - | - | 3 |
| - | - | - | - | - | - | - | 2 |
| - | 1 | 1 | 1 | 1 | 4-459736-0 | CRIMPER, WIRE | 1 |

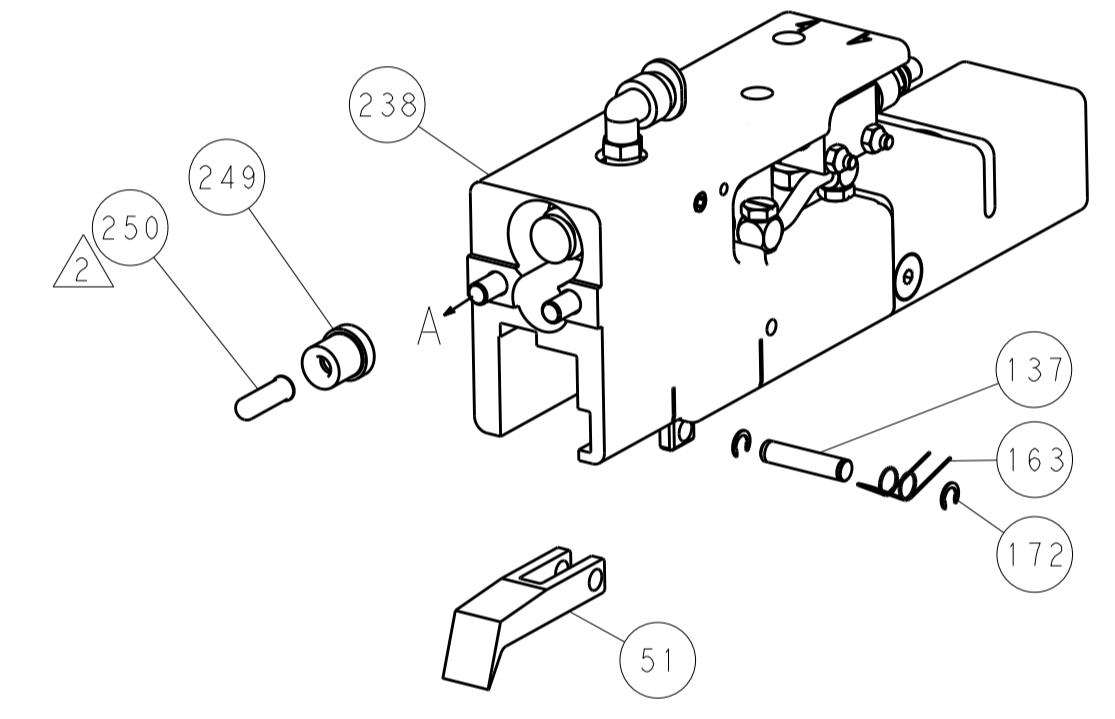
| DIMENSIONS: | | TOLERANCES UNLESS OTHERWISE SPECIFIED: | | MATERIAL: | | FINISH: | | WEIGHT: | | SCALE: | |
|--|-----------|--|-----------|--------------|-----------|---------------|--------|----------------|--|-----------------|--|
| mm | 0 PLC ±.5 | 1 PLC ±.5 | 2 PLC ±.5 | 3 PLC ±.5 | 4 PLC ±.5 | ANGLES ±.0001 | FINISH | | | | |
| Customer Accessible Production Drawing | | SCALE 1:1 | | SHEET 3 OF 4 | | REV A1 | | DATE 13MAY2014 | | DRAWN BY STAKEM | |
| Customer Accessible Production Drawing | | SCALE 1:1 | | SHEET 3 OF 4 | | REV A1 | | DATE 13MAY2014 | | DRAWN BY STAKEM | |

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

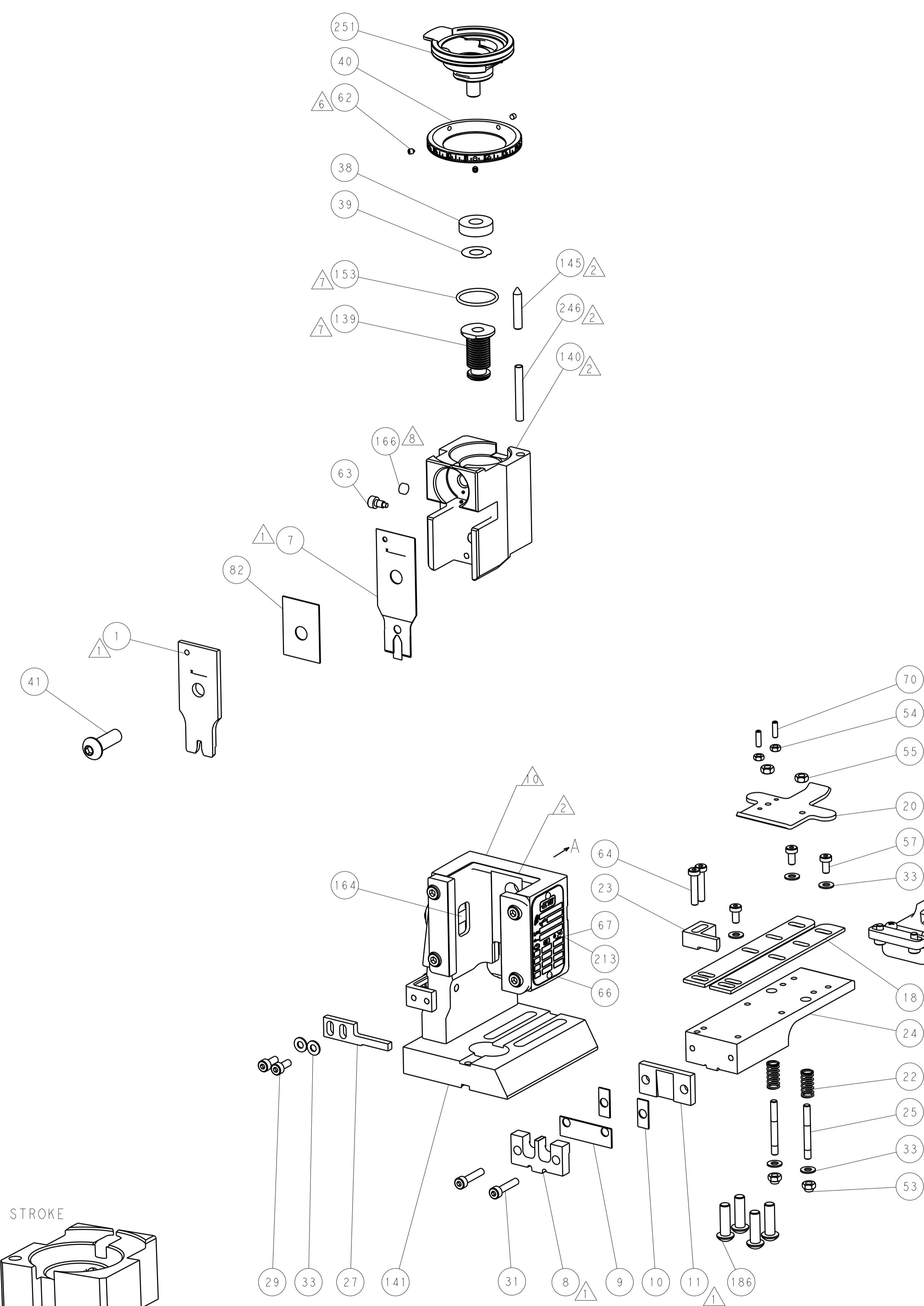
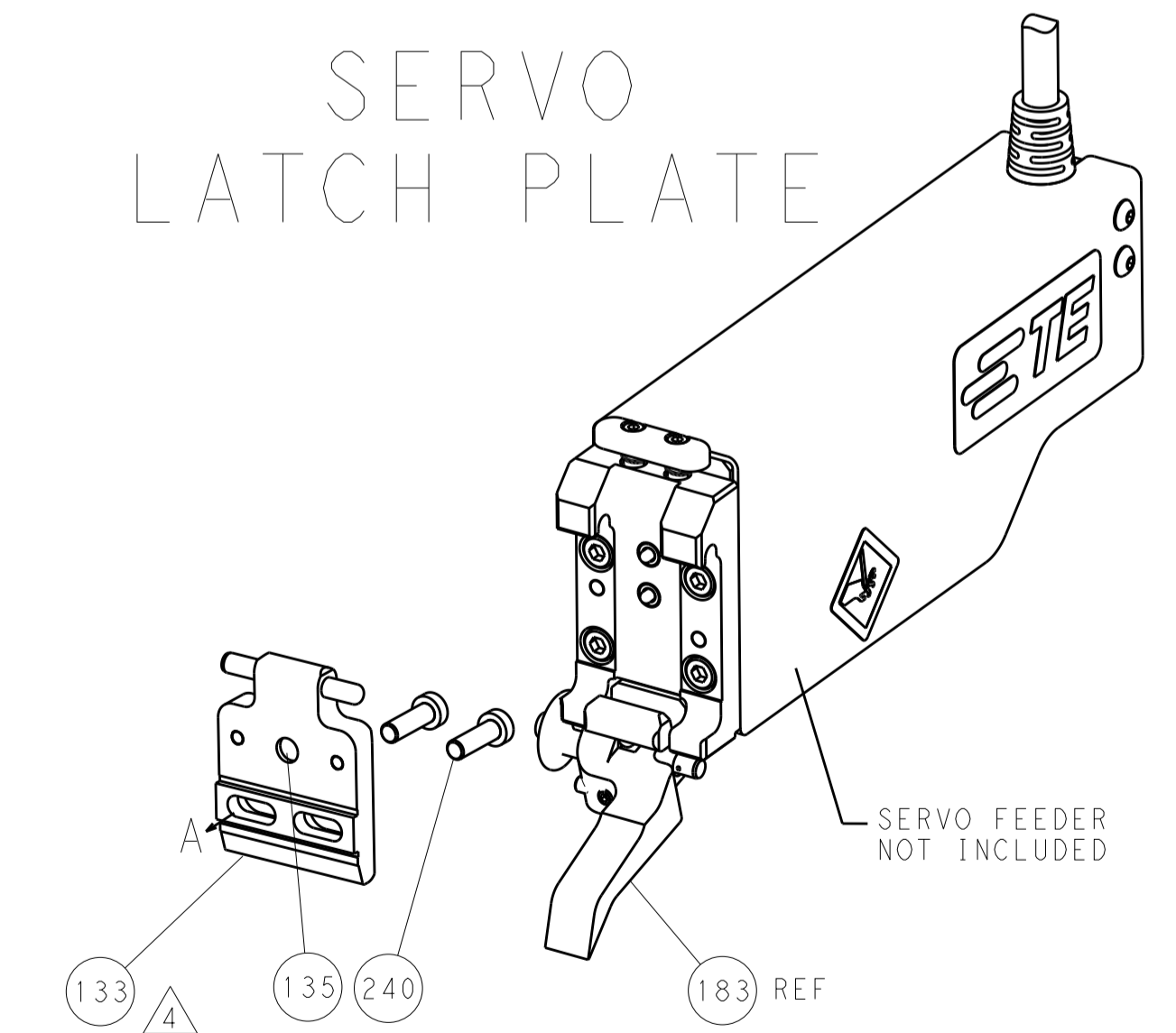
FEED TYPE MECHANICAL



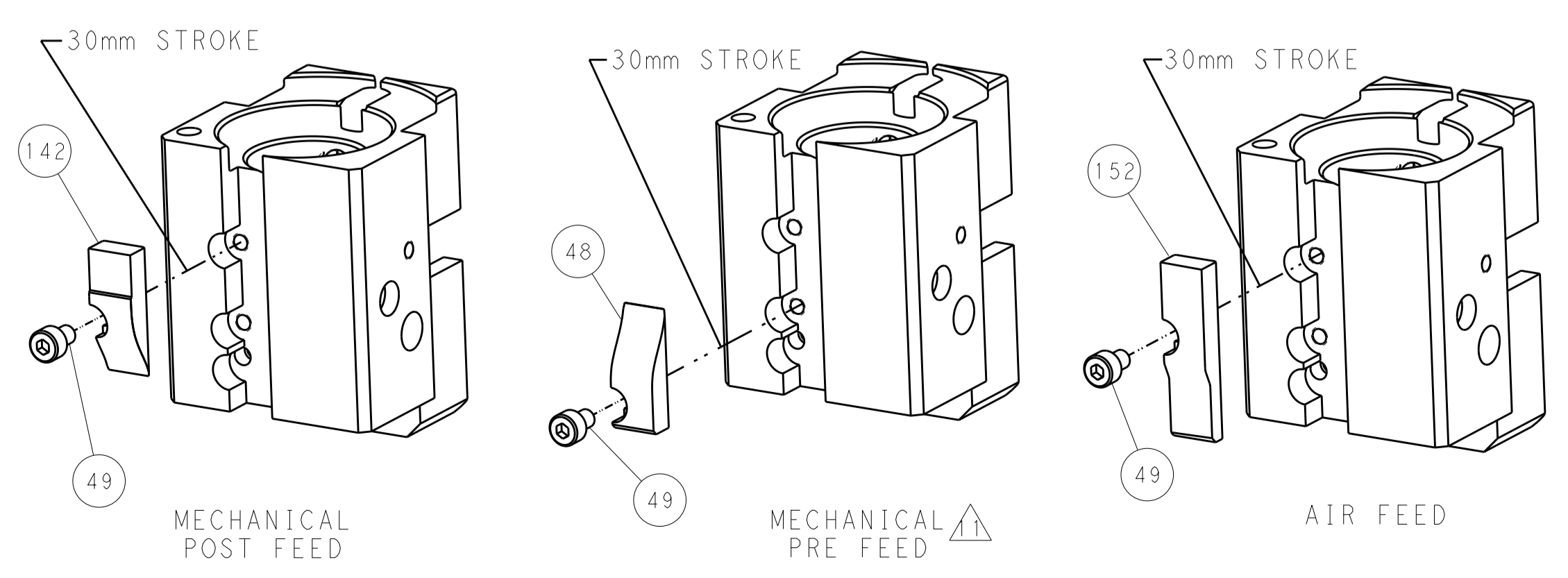
PNEUMATIC



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: | | DWG. CHK. 13MAY2014 | | STE TE Connectivity | |
| mm | 0 PLC ±0.5 | 1 PLC ±0.5 | 2 PLC ±0.13 | 3 PLC ±0.13 | 13MAY2014 | Harrisburg, PA 17105-3608 | |
| | 4 PLC ±0.013 | 5 PLC ±0.001 | ANGLES ±0.0001 | APVD T. ERLIN 13MAY2014 | NAME | | |
| MATERIAL: | FINISH: | WEIGHT: | | A1 00779 C=2150122 | | RESTRICTED TO | |
| Customer Accessible Production Drawing | | | | SCALE 1:1 | SHEET 4 OF 4 | REV A1 | |