

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART						
					CONVERT TO	PART NUMBERS REQUIRED					
	2150275-2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	-	-	-	-	-	-	
	2150275-5	A	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE <sup>4</sup>	SERVO LATCH PLATE	2119951-1	1901697-1	8-2150275-5	-	-	2168400-7 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2150275-4	-	-	-
	2150275-6	A	NON-CRIMP HEIGHT ADJUST	SERVO LATCH PLATE <sup>11</sup>	-	-	-	-	-	-	
	2150275-7	A	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	
7-2150275-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-		

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	3.30 mm [.130]	F
INSUL	4.32 mm [.170]	OV
APPL INSTRUCTIONS 408-10390		

TERMINAL DATA: G&H LEAR TERMINAL G&H LEAR CRIMP SPECIFICATION			
TERMINAL NAME: CLAW TERMINAL RING TYPE			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
3.00-6.00 mm [.118-.236 IN]		Ø2.20-3.00 mm [.087-.118 IN]	
TERMINAL APPLICATION SPECIFICATION	LEAR DATA SHT 25217		
TERMINALS APPLIED			
TE TERMINAL	G&H LEAR TERMINAL	TE TERMINAL	G&H LEAR TERMINAL
1572907-1	25215.123.011	1949279-1	25217.212.179
1572907-2	25215.213.011	1949279-2	25217.213.011
1572907-3	25215.212.179	1949279-3	25217.213.004
1572907-4	25215.213.004	1949279-4	25217.213.320
1572907-5	25215.122.323	1949279-5	25217.123.041
1572907-6	25215.123.014	1949279-6	25217.123.014
1572907-7	25215.123.322	1949279-7	25217.123.011
1572907-8	25215.122.321	1949279-8	25217.123.322
1572907-9	25215.123.009	1949279-9	25217.123.178
1-1572907-0	25215.411.131	1-1949279-0	25217.123.009
		1-1949279-1	25217.123.321
		1-1949279-2	25217.411.131

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.00mm <sup>2</sup> +1.50mm <sup>2</sup>	2.40+/-0.05 [.094+/-0.002]	12.4
2.50mm <sup>2</sup>	2.40+/-0.05 [.094+/-0.002]	12.4
0.75mm <sup>2</sup> +0.75mm <sup>2</sup>	2.25+/-0.05 [.089+/-0.002]	13.9
1.50mm <sup>2</sup>	2.20+/-0.05 [.087+/-0.002]	14.4

- 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:  
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150275-4  
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150275-5  
 SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2150275-6
- 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 & 242. FOR -6 ONLY APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 37, 180 & 242.
- 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 TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- 11 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
- 12 APPLICATOR APPLIES FLRY TYPE INSULATIONG. FOR DOUBLE WIRE APPS. INSULATION RANGE IS 2 X 2.20mm MAX

**\*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	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
-77	-7	-6	-5	-2	PART NO	DESCRIPTION	ITEM NO

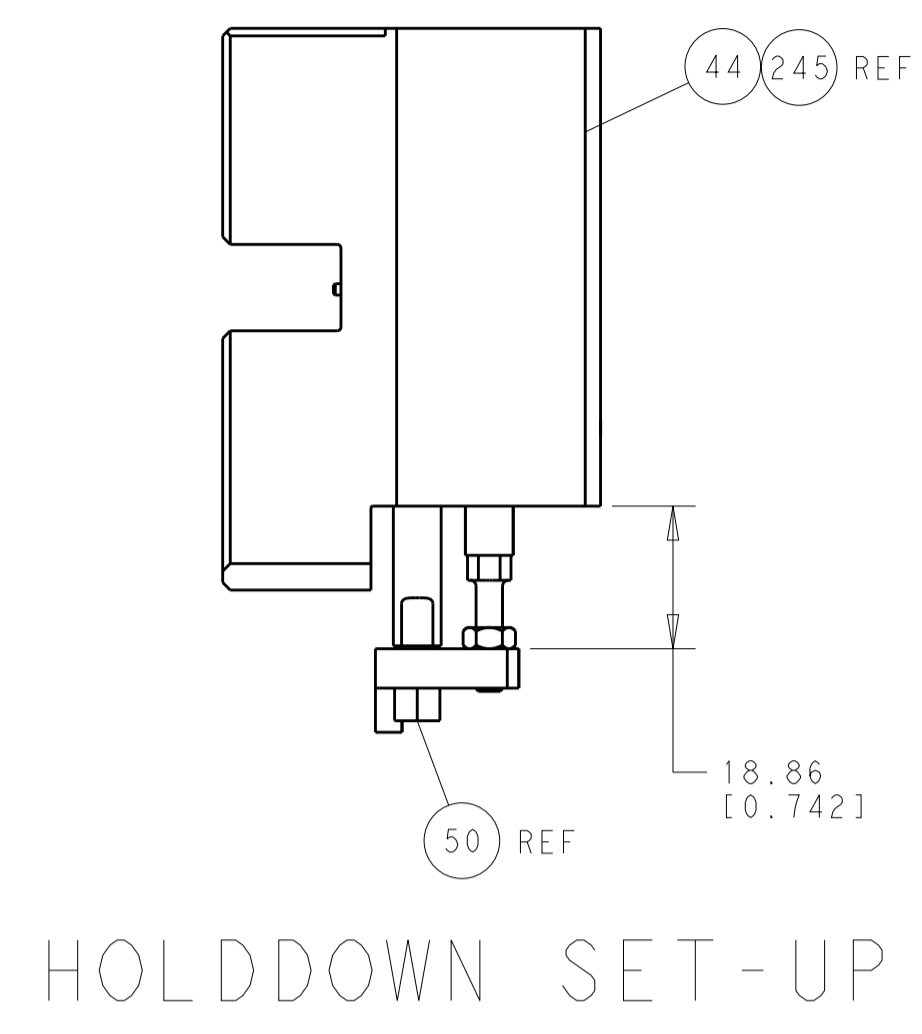
**ATLANTIC VERSION**  
 Shown on sheets 1 of 4 & 2 of 4  
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

SET UP GAUGE	LOC	DIST	REVISIONS			
2119599-2	A	66	REV	DATE	BY	APPV
			A	RELEASE	12FEB2014	XZ TE

-	-	-	-	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	-	-	2119759-1	RAM, AMP STYLE, END FEED, NON-ADJUST	245
-	1	1	1	1	2119082-8	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
6	-	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	-	2	2	-	2168400-7	SHCS, LOW HEAD, RoHS, M5 X 10	240
-	-	-	-	1	2063440-2	AIR FEED MODULE	238
-	-	1	1	-	2119740-2	TAG, IDENTIFICATION	213
-	-	REFREF	-	-	1901697-1	FEED FINGER ASSEMBLY, EF	183
6	-	1	1	1	1752354-2	STANDOFF, HOLD-DOWN	180
-	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
-	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	455888-4	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
-	1	1	1	1	1901681-1	HOLDDOWN, TERMINAL	65
-	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	992763-5	SCR, SET, SOC, CONE POINT, M3 x 4.0	62
-	1	1	1	1	2079383-4	SCR, BHSC, RoHS (M4 X 8)	60
-	3	3	3	3	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57
-	2	2	2	2	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	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	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	1	1	1	1	2119655-5	APPLICATOR BASIC ASSEMBLY, EF	46
-	1	-	1	1	2119369-1	RAM, 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	2119644-2	RAM WASHER, PRECISION	38
6	-	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	240639-1	STRIPPER (MACHINING)	27
-	2	2	2	2	1320906-1	STUD, THREADED	25
-	1	1	1	1	1752371-1	PLATE, STRIP GUIDE	24
-	1	1	1	1	240825-4	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	1901259-7	GUIDE, LOWER STRIP	18
-	4	4	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17
-	1	1	1	1	5-240641-2	SPACER	16
-	1	1	1	1	1752360-1	SPACER, HOLD-DOWN	13
1	-	1	1	1	240644-1	PLATE, REAR SHEAR	11
-	-	-	-	-	-	-	10
1	-	1	1	1	690482-4	PLATE, FRONT SHEAR	9
1	1	1	1	1	4-1803000-2	ANVIL, COMBINATION, END FEED	8
1	1	1	1	1	690474-4	BLADE, SLUG	7
-	-	-	-	-	-	-	6
-	1	1	1	1	240641-3	SPACER	5
-	1	1	1	1	238009-1	BLOCK, FL CRIMPER SPACER	4
1	1	1	1	1	5-2119785-1	CRIMPER, INSULATION OVERLAP PREMIUM	3
-	1	1	1	1	1-455888-2	SPACER, CRIMPER	2
1	1	1	1	1	1-456410-2	CRIMPER, WIRE PREMIUM	1
-77	-7	-6	-5	-2	PART NO	DESCRIPTION	ITEM NO

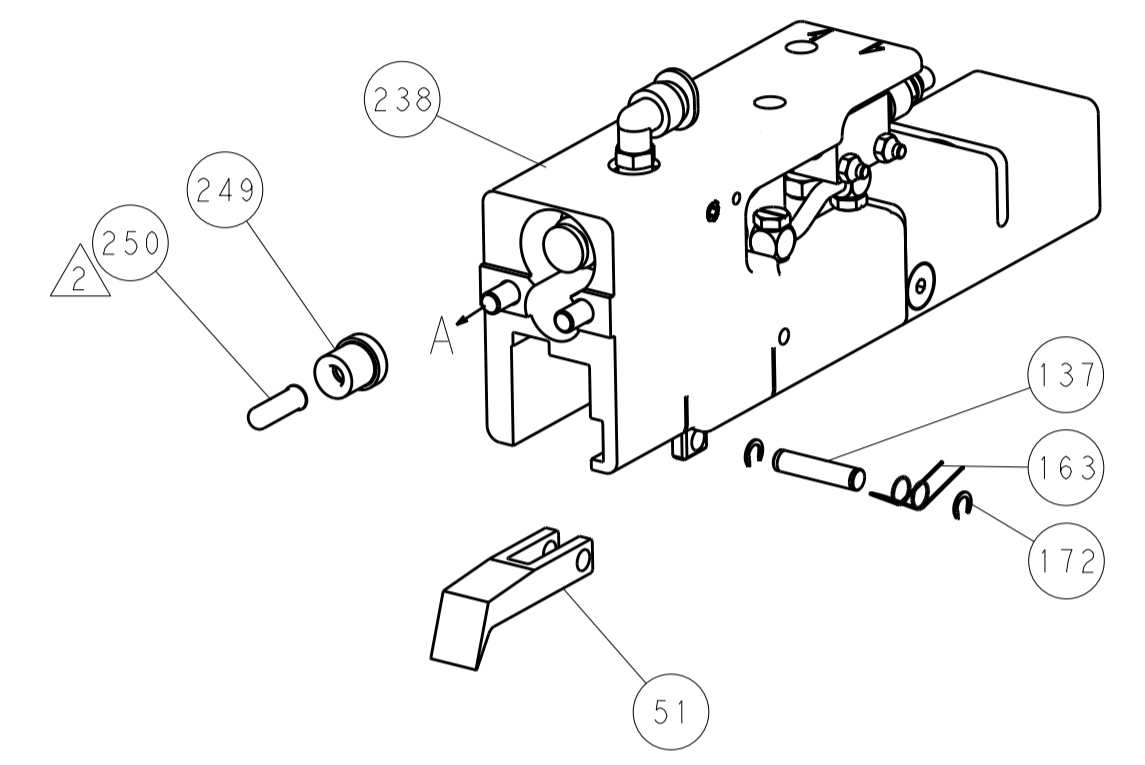
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG		CHK		APVD		NAME	
mm	0 PLC ±.5	1 PLC ±.5	2 PLC ±.5	3 PLC ±.5	4 PLC ±.5	5 PLC ±.5	6 PLC ±.5	7 PLC ±.5	8 PLC ±.5	9 PLC ±.5	10 PLC ±.5
	ANGLES ±.0001										
MATERIAL	FINISH	WEIGHT	SCALE	SHEET	OF	REV					
			1:1	1	OF 4	A					

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

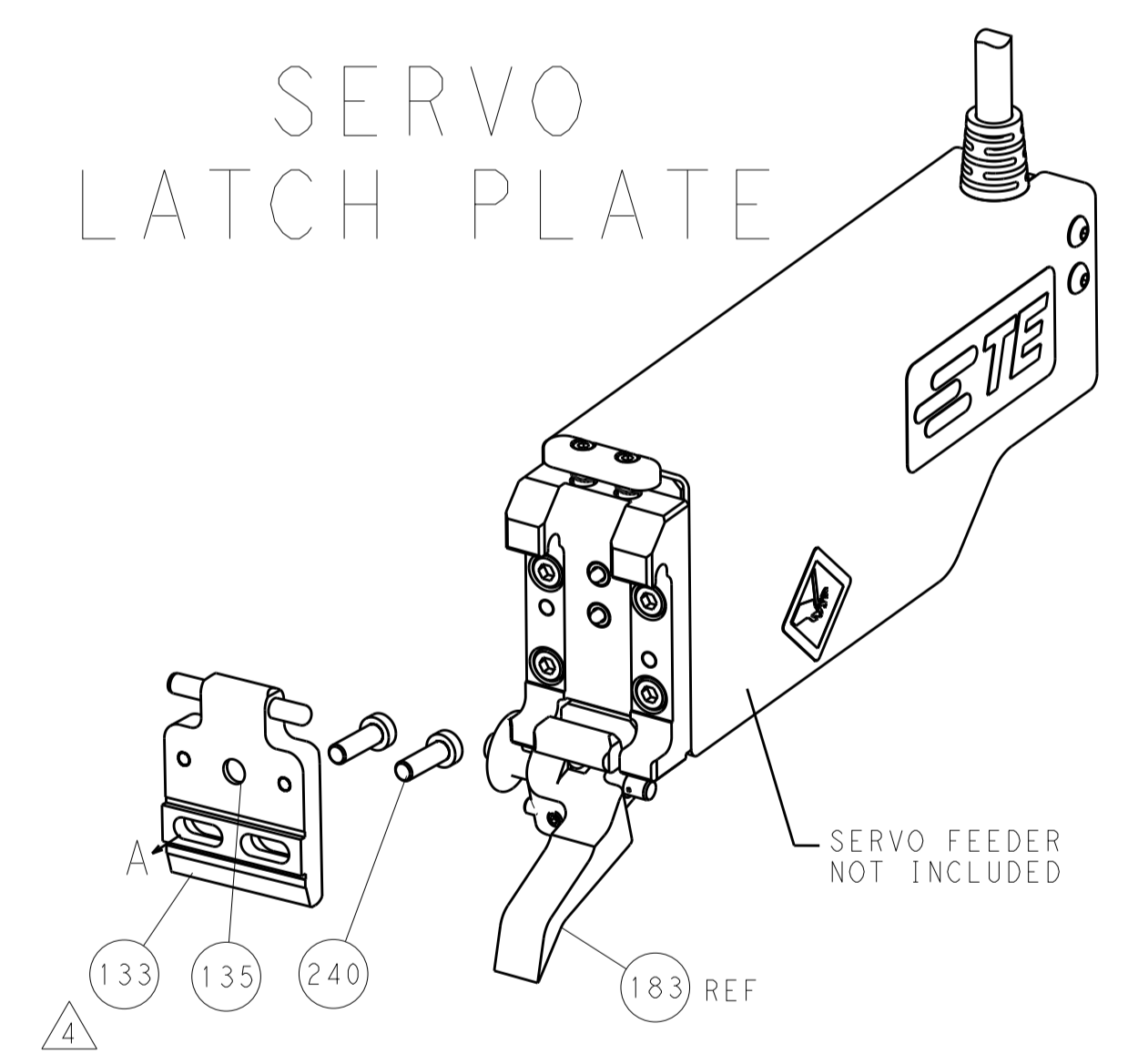


FEED TYPE

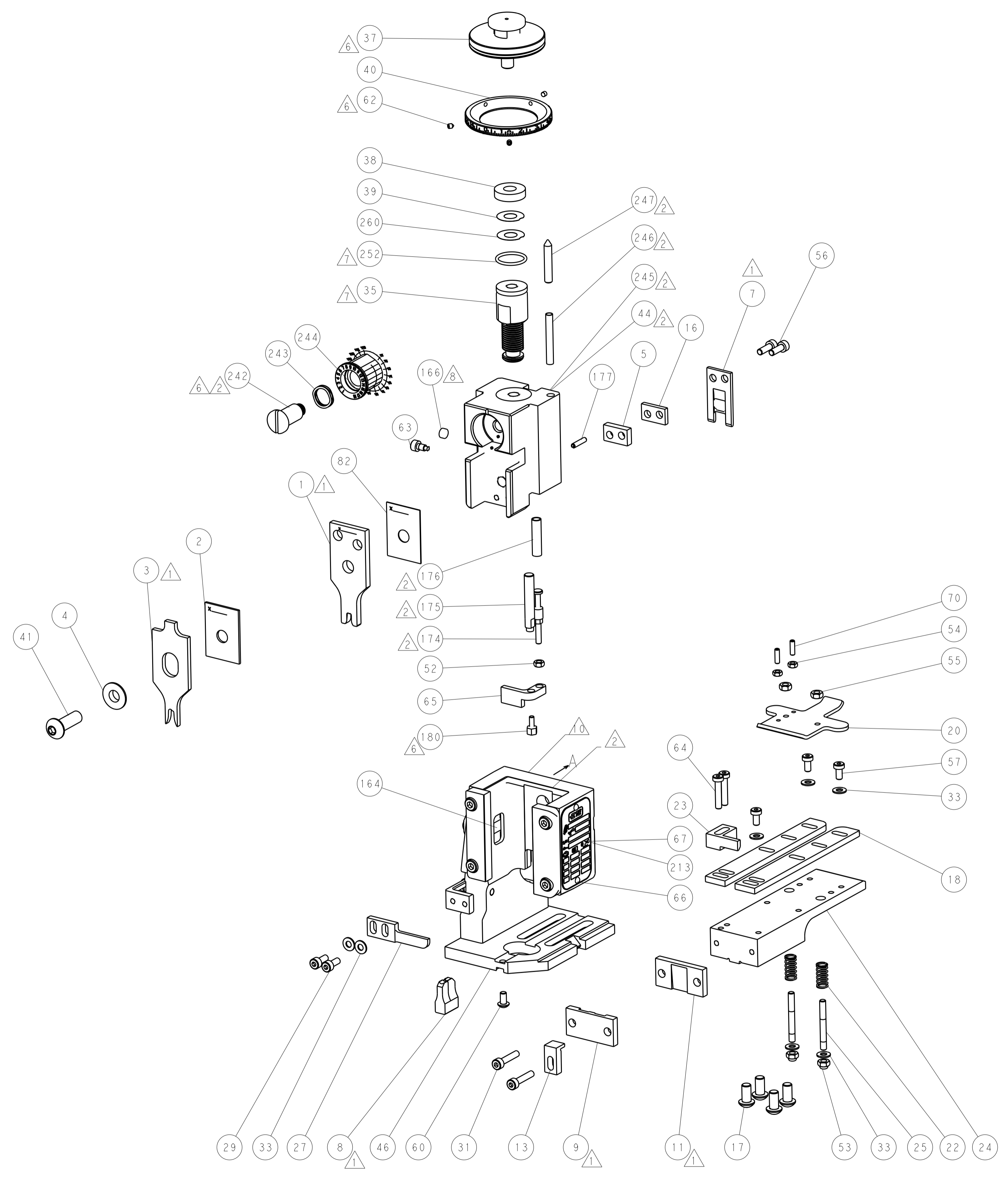
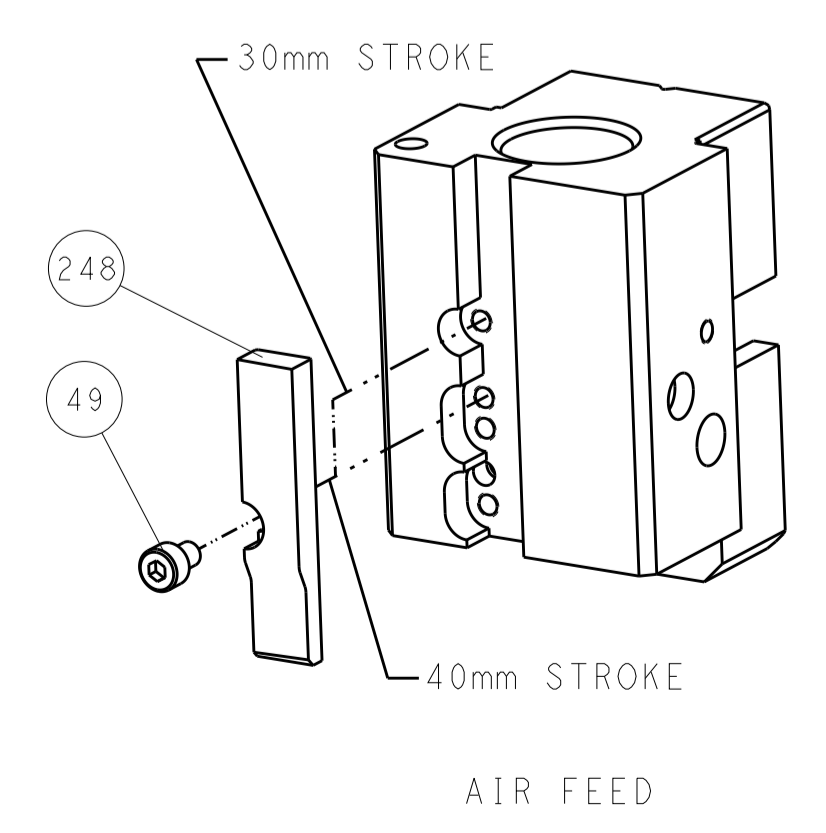
PNEUMATIC



SERVO LATCH PLATE



CAM POSITION



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 X.ZHAO 17JAN2014		TE Connectivity	
mm	0 PLC ±0.5	1 PLC ±0.5	2 PLC ±0.13	3 PLC ±0.013	4 PLC ±0.001	APVD T.ELBIN 17JAN2014	Harrisburg, PA 17105-3608
MATERIAL:		FINISH:		NAME Ocean End Feed Applicator		RESTRICTED TO	
				SIZE CAGE CODE DRAWING NO. A11 00779 C=2150275		SCALE 1:1 SHEET 2 OF 4 REV A	
Customer Accessible Production Drawing				Customer Accessible Production Drawing			

PACIFIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART					
					CONVERT TO	PART NUMBERS REQUIRED				
	2-2150275-2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	-	-	-	-	-	-
					SERVO LATCH PLATE SMART APPLICATOR	2119951-1	1901697-1	8-2150275-5	-	-
	2-2150275-5	A	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE	-	-	-	-	-	-
					PNEUMATIC FEED	2119950-1	2119792-1	-	2119641-2	-
2-2150275-7	A	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	
7-2150275-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-	

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	3.30 mm [ .130 ]	F
INSUL	4.32 mm [ .170 ]	OV
APPL INSTRUCTIONS 408-10390		

TERMINAL DATA: G&H LEAR TERMINAG&H LEAR CRIMP SPECIFICATION
TERMINAL NAME: CLAW TERMINAL RING TYPE
WIRE STRIP LENGTH  INSULATION DIAMETER RANGE
3.00-6.00 mm [ .118-.236 IN ] $\varnothing$ 2.20-3.00 mm [ .087-.118 IN ]

TERMINAL APPLICATION SPECIFICATION	LEAR DATA SHT 25217	-	-
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TE TERMINAL	G&H LEAR TERMINAL	TE TERMINAL	G&H LEAR TERMINAL
1572907-1	25215.123.011	1949279-1	25217.212.179
1572907-2	25215.213.011	1949279-2	25217.213.011
1572907-3	25215.212.179	1949279-3	25217.213.004
1572907-4	25215.213.004	1949279-4	25217.213.320
1572907-5	25215.122.323	1949279-5	25217.123.041
1572907-6	25215.123.014	1949279-6	25217.123.014
1572907-7	25215.123.322	1949279-7	25217.123.011
1572907-8	25215.122.321	1949279-8	25217.123.322
1572907-9	25215.123.009	1949279-9	25217.123.178
1-1572907-0	25215.411.131	1-1949279-0	25217.123.009
		1-1949279-1	25217.123.321
		1-1949279-2	25217.411.131

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.00mm <sup>2</sup> +1.50mm <sup>2</sup>	2.40+/-0.05 [ .094+/- .002 ]	12.4
2.50mm <sup>2</sup>	2.40+/-0.05 [ .094+/- .002 ]	12.4
0.75mm <sup>2</sup> +0.75mm <sup>2</sup>	2.25+/-0.05 [ .089+/- .002 ]	13.9
1.50mm <sup>2</sup>	2.20+/-0.05 [ .087+/- .002 ]	14.4

- 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:  
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150275-4  
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150275-5
- 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 & 242.
- 7 GREASE THREADS, GROOVE AND O-RING ON ITEMS 139 & 153.
- 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 TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- 11 APPLICATOR APPLIES FLY TYPE INSULATIONG. FOR DOUBLE WIRE APPS. INSULATION RANGE IS 2 X 2.20mm MAX

**\*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	2119782-1	FINE ADJUST HEAD ASM, PACIFIC STYLE	251
- - - 1	2119640-1	PUSH ROD, AIR FEED	250
-77-27-25-22	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 2119599-2	LOC A	DIST 66	REVISIONS			
			REV	DATE	BY	APPV
			-	-	-	-
			-	SEE SHEET 1	-	-

- - - 1	2079988-1	BUSHING, LCH5-12, MISUMI	249
- 1 1 1	1-22279-3	SPRING, COMPRESSION	246
- 1 1 1	2119082-8	CAM, SNAIL, INSULATION ADJUSTMENT	244
- 1 1 1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
- 1 1 1	2119083-1	RETAINER, INSULATION DIAL	242
- - 2 -	2168400-7	SHCS, LOW HEAD, RoHS, M5 X 10	240
- - - 1	2063440-2	AIR FEED MODULE	238
- - 1 -	2119740-2	TAG, IDENTIFICATION	213
- 4 4 4	2079383-9	SCR, BHSC, RoHS (M6 X 20)	186
- - REF -	1901697-1	FEED FINGER ASSEMBLY, EF	183
- 1 1 1	1752354-2	STANDOFF, HOLD-DOWN	180
- 1 1 1	6-993111-6	PIN, SLOTTED SPRING 3.0 X 14.0	177
- 1 1 1	8-22280-7	SPRING, COMPRESSION	176
- 1 1 1	1752353-2	GUIDE PIN, HOLDDOWN	175
- 1 1 1	1901680-2	GUIDE PIN, HOLDDOWN	174
- - - 2	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172
- 1 1 1	994969-1	MAGNET, RARE EARTH HIGH ENERGY	166
- REF REF REF	994970-2	COUNTER, MAGNETIC	164
- - - 1	240638-1	SPRING, FEED FINGER	163
- 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	2119798-2	DETENT PIN	145
- 1 1 1	2079383-8	SCR, BHSC, RoHS (M4 X 16)	144
- 1 1 1	2119655-6	APPLICATOR BASIC ASSEMBLY, EF	141
- 1 1 1	2119651-1	RAM, ASIAN STYLE, END FEED	140
- 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	455888-4	SPACER, CRIMPER	82
- 1 1 1	2119956-2	DOCUMENTATION PACKAGE	71
- 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	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
- 1 1 1	1901681-1	HOLDDOWN, TERMINAL	65
- 2 2 2	2168400-5	SHCS, LOW HEAD, RoHS, M4 X 20	64
- 1 1 1	2119793-1	LIMITER, ADJUSTMENT BOLT	63
- 3 3 3	992763-5	SCR, SET, SOC, CONE POINT, M3 X 4.0	62
- 3 3 3	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57
- 2 2 2	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	56
- 2 2 2	5018030-2	NUT, HEX, REG, RoHS, M4	55
- 2 2 2	5018030-1	NUT, HEX, REG, RoHS, M3	54
- 2 2 2	986965-8	NUT, LOCK, HEX, TORQUE (M4)	53
- 1 1 1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52
- - - 1	2119792-2	PAWL, EF, AIR	51
- - - 1	18023-9	SCR, SKT HD CAP M4 X 6.0	49
- 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	2119644-2	RAM WASHER, PRECISION	38
- 7 7 7	1-18028-2	WASHER, FLAT, REG M4	33
- 2 2 2	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	31
- 2 2 2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	29
- 1 1 1	240639-1	STRIPPER (MACHINING)	27
- 2 2 2	1320906-1	STUD, THREADED	25
- 1 1 1	1752371-1	PLATE, STRIP GUIDE	24
- 1 1 1	240825-4	PLATE, STRIP HOLD DOWN	23
- 2 2 2	2-22281-3	SPRING, COMPRESSION	22
- 1 1 1	1752373-4	DRAG	20
- 2 2 2	1901259-7	GUIDE, LOWER STRIP	18
- 1 1 1	5-240641-2	SPACER	16
- 1 1 1	1752360-1	SPACER, HOLD-DOWN	13
- 1 1 1	240644-1	PLATE, REAR SHEAR	11
- - - -	-	-	10
- 1 1 1	690482-4	PLATE, FRONT SHEAR	9
1 1 1 1	4-1803000-2	ANVIL, COMBINATION, END FEED	8
- 1 1 1	690474-4	BLADE, SLUG	7
- - - -	-	-	6
- 1 1 1	240641-3	SPACER	5
- 1 1 1	238009-1	BLOCK, FL CRIMPER SPACER	4
1 1 1 1	5-2119785-1	CRIMPER, INSULATION OVERLAP PREMIUM	3
- 1 1 1	1-455888-2	SPACER, CRIMPER	2
1 1 1 1	1-456410-2	CRIMPER, WIRE PREMIUM	1
-77-27-25-22	PART NO	DESCRIPTION	ITEM NO

DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG: X.ZHAO 17JAN2014		CHK: L.ZHANG 17JAN2014		NAME: I. ELBIN 17JAN2014		TE Connectivity Harrisburg, PA 17105-3608	
0 PLC ±.5		1 PLC ±.13		2 PLC ±.08		3 PLC ±.05		4 PLC ±.03		RESTRICTED TO	
5 PLC ±.013		6 PLC ±.01		7 PLC ±.008		8 PLC ±.006		9 PLC ±.004		Customer Accessible Production Drawing	
ANGLES ±.0001		FINISH		WEIGHT		SCALE		SHEET 3 OF 4		REV A	
MATERIAL		FINISH		WEIGHT		SCALE		SHEET 3 OF 4		REV A	

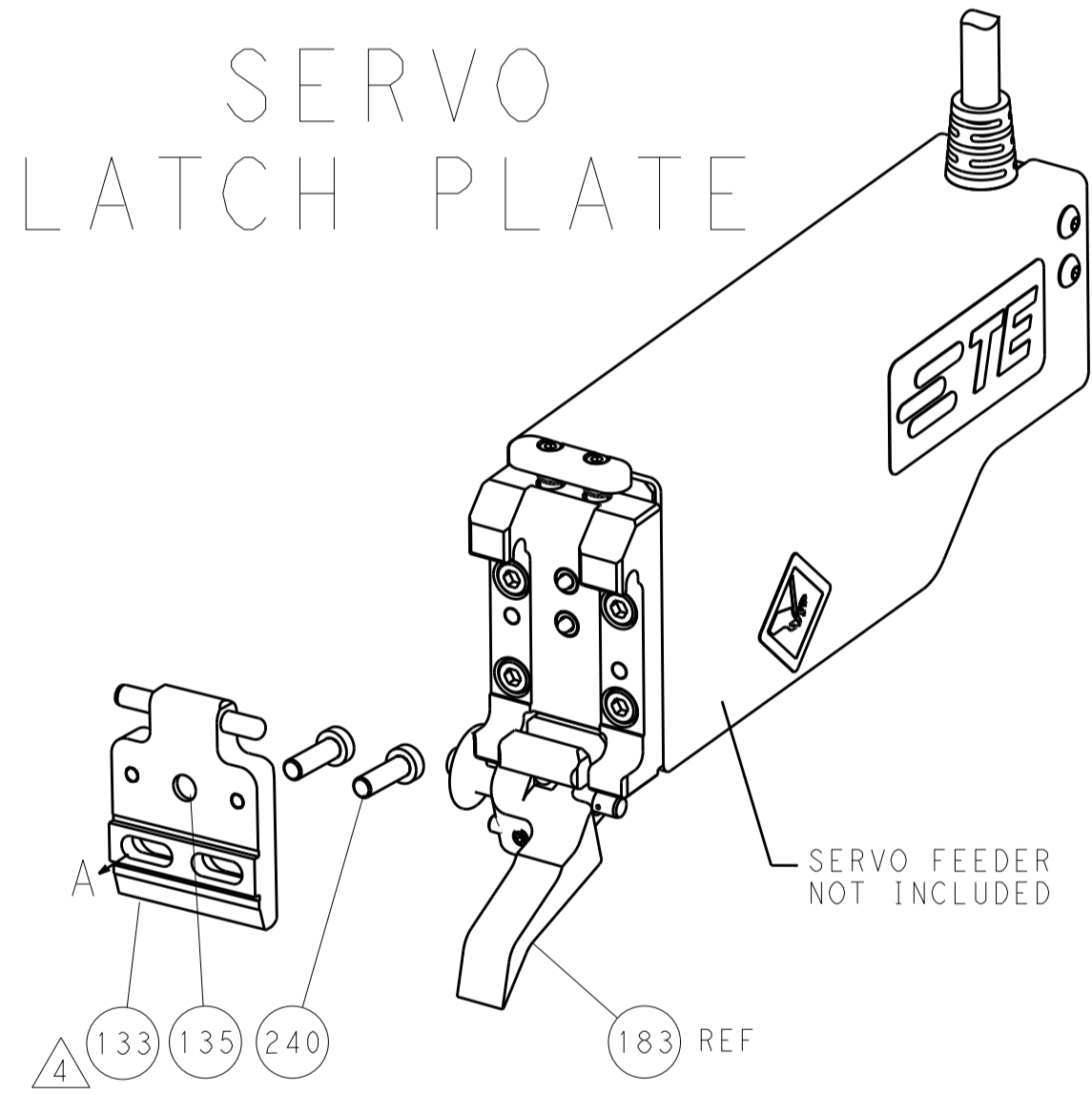
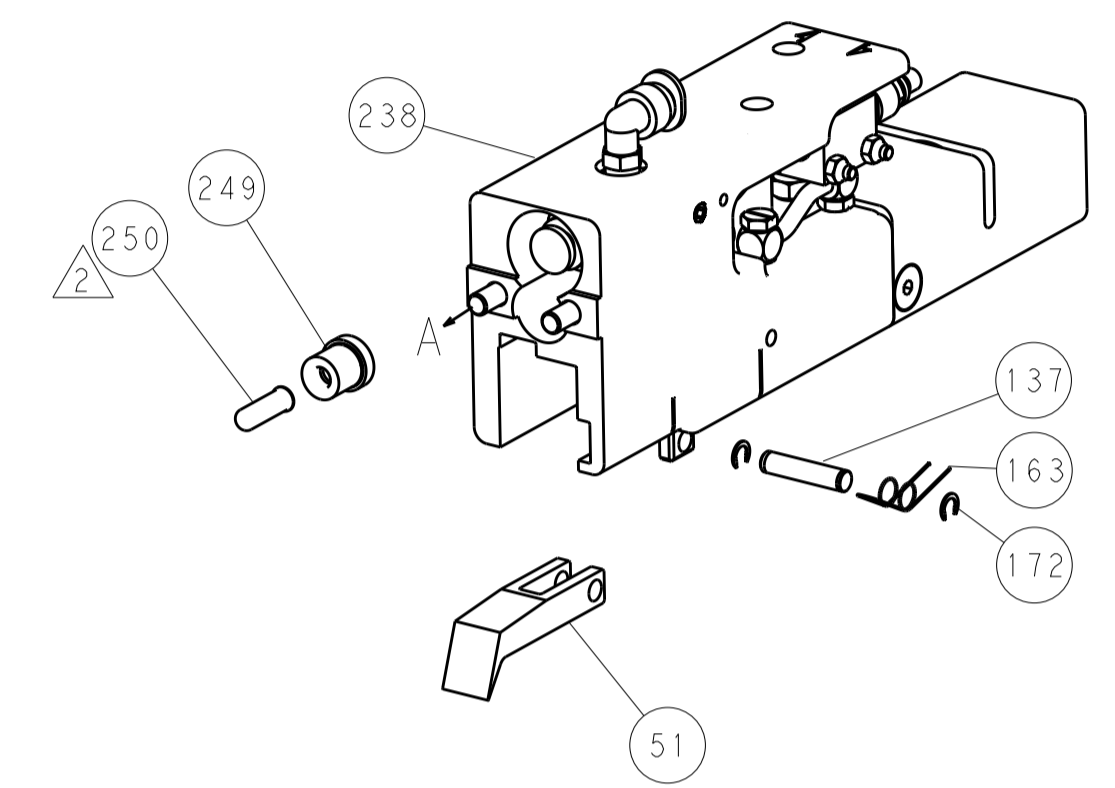
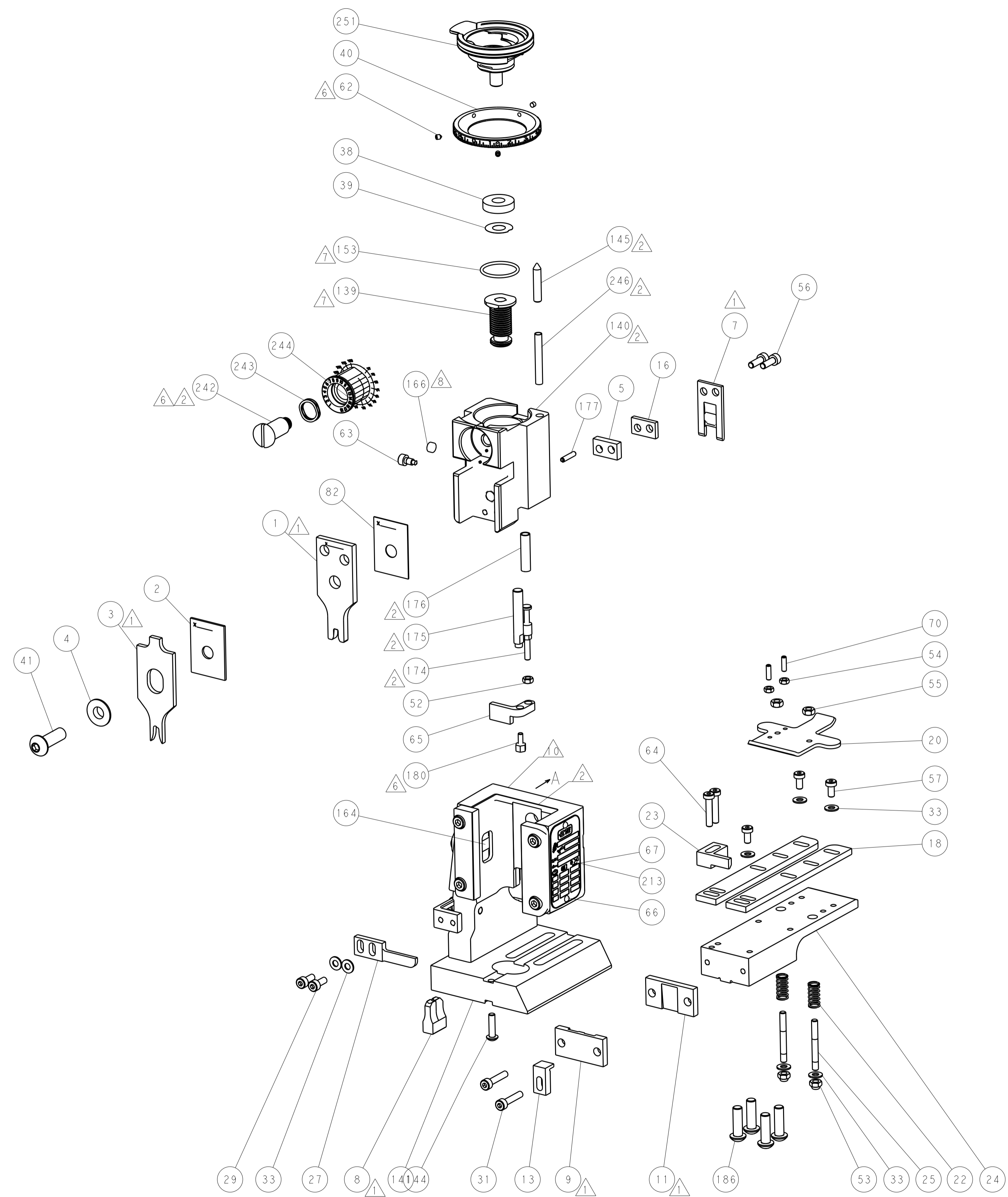
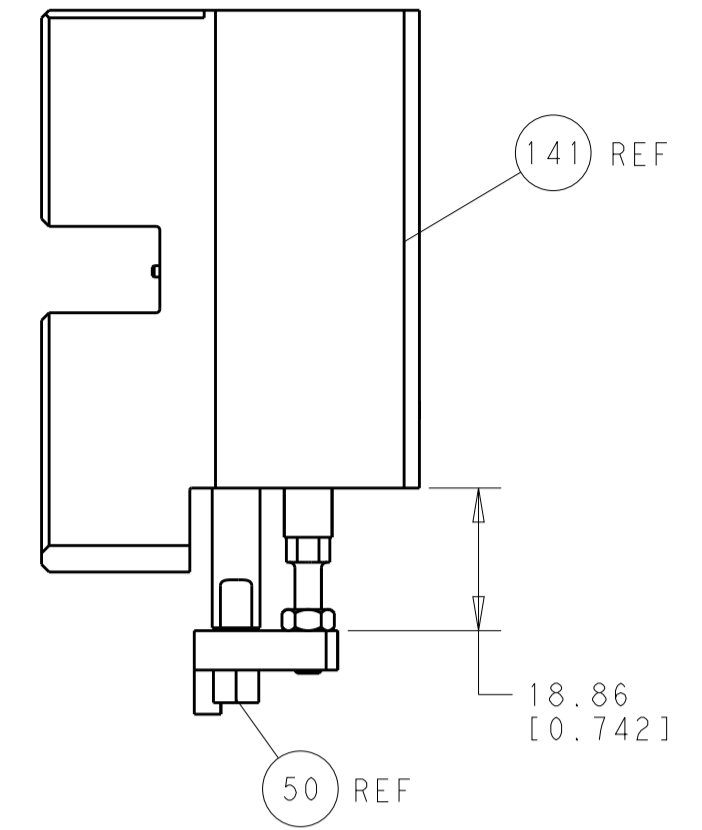
LOC	DIST	REV	DATE	BY	APPV
A	66				

### FEED TYPE

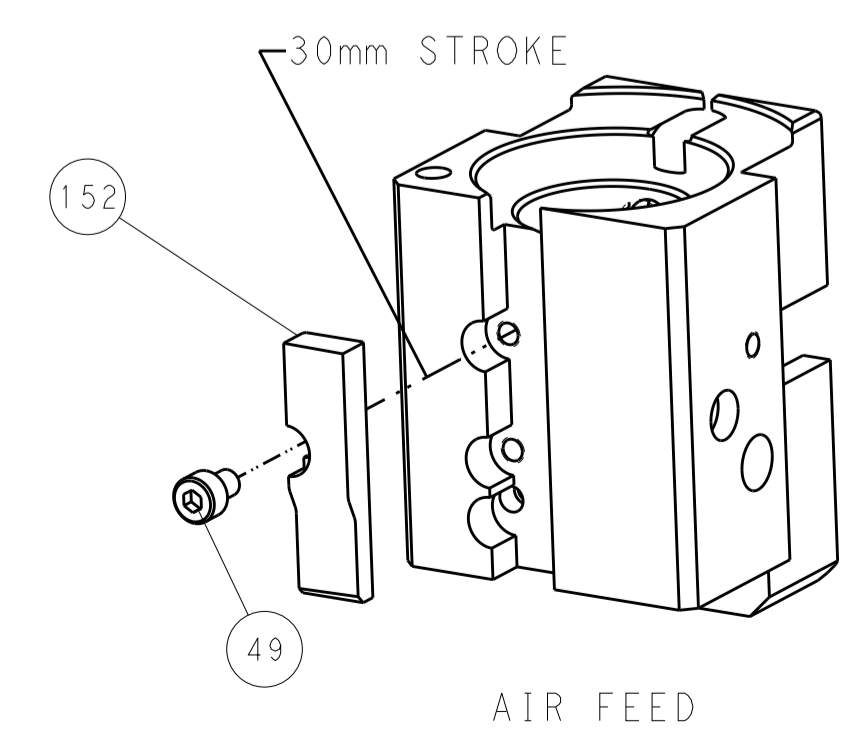
### PNEUMATIC

### SERVO LATCH PLATE

### HOLDDOWN SET-UP



### CAM POSITION



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

<small>THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION. ALL RIGHTS RESERVED. © 2014 BY TYCO ELECTRONICS CORPORATION. THIS DRAWING IS THE PROPERTY OF TYCO ELECTRONICS CORPORATION AND IS NOT TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, INCLUDING PHOTOCOPYING, RECORDING, OR BY ANY INFORMATION STORAGE AND RETRIEVAL SYSTEM, WITHOUT THE WRITTEN PERMISSION OF TYCO ELECTRONICS CORPORATION.</small>		DWN: X.ZHAO 17JAN2014 CHK: L.ZHANG 17JAN2014 APVD: T.FELBIN 17JAN2014	NAME: Ocean End Feed Applicator PRODUCT SPEC: - APPLICATION SPEC: - WEIGHT: - SCALE: 1:1
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±0.5 1 PLC ±0.13 3 PLC ±0.013 4 PLC ±0.0001 ANGLES ±0.0001	FINISH: - MATERIAL: -	SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2150275 SHEET 4 OF 4 REV A	RESTRICTED TO: - SCALE: 1:1 SHEET 4 OF 4 REV A