

CRIMP SIZE	WIRE	INSUL	TYPE
	1.07 mm [.042]	1.45 mm [.057]	F
			F

APPLICATOR INSTRUCTIONS
408-10389

TERMINAL NAME: GRACE 2.0 EV SERIES REC CONTACT	
WIRE STRIP LENGTH 1.40-2.00 mm [.055-.079 IN]	INSULATION DIAMETER RANGE Ø0.98-1.58 mm [.039-.062 IN]
TERMINAL APPLICATION SPECIFICATION 114-5425	
TERMINALS APPLIED	
TE TERMINAL 1971031-1	TE TERMINAL 1971031-2

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
24 AWG	0.65 +/- 0.03 [.026 +/- .001]	10.7
26 AWG	0.59 +/- 0.03 [.023 +/- .001]	11.5
28 AWG	0.56 +/- 0.03 [.022 +/- .001]	11.8

- 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: 8-2151076-4
 - PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151076-4
 - SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151076-5
 - SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2151076-6
- 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 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 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 -6 NON-CRIMP HEIGHT ADJUST APPLICATOR USE SHIM PACK 2119957-2 TO ALIGN APPLICATOR'S MAXIMUM WIRE CRIMP HEIGHT AT NORMAL TERMINATOR SHUT HEIGHT

CONVERT TO	PART NUMBERS REQUIRED					
PNEUMATIC FEED	2119950-1	1338685-3	5-18022-5	2119641-1	2119799-1	2063440-1
SERVO LATCH PLATE	2119951-1	-	8-2151076-5	1901094-3	-	2168400-6 (QUANTITY 2)
SMART APPLICATOR	2161326-1	-	8-2151076-4	-	-	-
MECHANICAL FEED	2119949-1	1338685-3	5-18022-5	2119653-1	-	-
SERVO LATCH PLATE	2119951-1	-	8-2151076-5	1901094-3	-	2168400-6 (QUANTITY 2)
SMART APPLICATOR	2161326-1	-	8-2151076-4	-	-	-
MECHANICAL FEED	2119949-1	1338685-3	5-18022-5	2119653-1	-	-
PNEUMATIC FEED	2119950-1	1338685-3	5-18022-5	2119641-1	2119799-1	2063440-1
-	-	-	-	-	-	-
-	-	-	-	-	-	-
-	-	-	-	-	-	-
-	-	-	-	-	-	-

***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.

-77	-7	-6	-5	-2	-1	PART NO	DESCRIPTION	ITEM NO
-	-	1	-	-	-	2119957-2	APPLICATOR SHIM PACK	260
-	1	1	1	1	1	1-22281-8	SPRING, COMPRESSION	255
-	1	1	1	1	1	8-1655316-7	SCR, SKT HD CAP, M5 X 65	254
-	1	1	1	1	1	1901086-2	PLATE, STRIP GUIDE	253
-	1	1	1	1	1	8-21084-0	O-RING, .676 ID, .070 DIA. MAT.	252
-	-	-	-	-	-	2119640-1	PUSH ROD, AIR FEED	250
-	-	-	-	-	-	2079988-1	BUSHING, LCHS-12, MISUMI	249
-	-	-	-	-	-	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
-	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
-	1	1	1	1	1	18023-1	SCR, SKT HD CAP M3 X 5.0	241
-	-	2	2	-	-	2168400-6	SHCS, LOW HEAD, RoHS, M5 X 16	240
-	-	-	-	-	-	2119580-1	MECHANICAL FEED ASSEMBLY	239

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

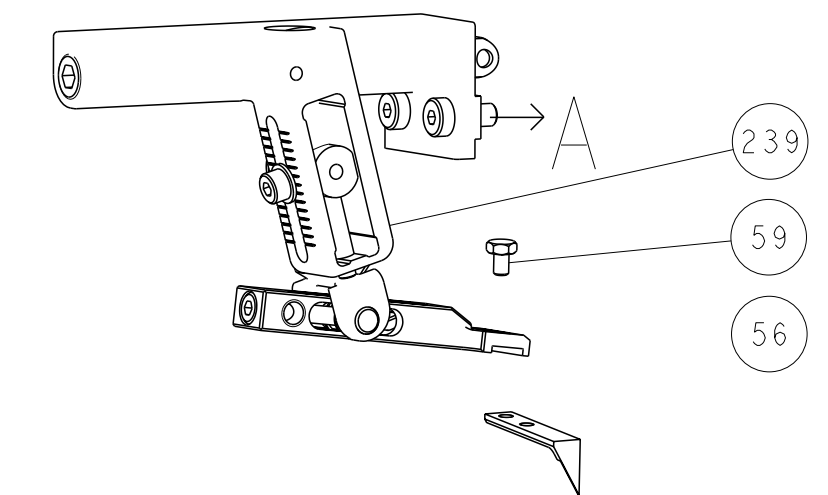
SET UP GAUGE 2119599-1	LOC A	DIST 66	REVISIONS	
			DESCRIPTION	DATE
			2 REDESIGN	26AUG2011 YY SX
			A RELEASED	13FEB2012 LG GB

P	LTB	DESCRIPTION		DATE	DWN	APVD
-	-	-	-	1	-	-
-	2	2	2	2	2	2063440-1 AIR FEED MODULE
-	2	2	2	2	2	1655785-9 SCR, BTN SKT HD CAP (M3 X 6)
-	1	1	1	1	1	2119740-2 TAG, IDENTIFICATION
-	1	1	1	1	1	1901094-3 SPACER, FEEDER
-	2	2	2	2	2	4-1655316-4 SCR, SKT HD CAP, M3 X 8.0
-	1	1	1	1	1	1-690438-0 FRONT STRIP GUIDE
-	1	1	1	1	1	1-1633764-7 HOLD DOWN, TERMINAL
-	1	1	1	1	1	993111-1 PIN, SLOTTED SPRING 3.0 X 20.0
-	1	1	1	1	1	8-22280-7 SPRING, COMPRESSION
-	1	1	1	1	1	1752353-2 GUIDE PIN, HOLDDOWN
-	1	1	1	1	1	1901680-2 GUIDE PIN, HOLDDOWN
-	-	-	-	2	-	21045-3 RING, RETAIN, EXTERN, 3/16 CRESCENT
-	1	1	1	1	1	994969-1 MAGNET, RARE EARTH HIGH ENERGY
-	REF	REF	REF	REF	REF	994970-2 COUNTER, MAGNETIC
-	-	-	-	1	-	240638-1 SPRING, FEED FINGER
-	-	-	-	1	-	3-23627-7 PIN, RETAIN, GRVD, 3/16 X .854
-	-	-	-	1	-	2119799-1 HOLDER, FEED FINGER, AF
-	REF	REF	-	-	-	SEE NOTE 4 MEMORY CHIP, PROGRAMMED
-	1	1	1	1	1	1633743-1 SERVO FEED LATCH ASM
-	1	1	1	1	1	1-18028-2 WASHER, FLAT, REG M4
-	REF	REF	-	-	-	2119944-1 FEED FINGER ASSEMBLY, SF
-	1	1	1	1	1	1-455888-8 SPACER, CRIMPER
-	1	1	1	1	1	547505-3 SPRING, COMPRESSION
-	1	1	1	1	1	854769-4 HOLDER, INS
-	1	1	1	1	1	2119956-1 DOCUMENTATION PACKAGE
-	1	-	-	1	1	2119740-1 TAG, IDENTIFICATION
-	2	2	2	2	2	2168078-1 SCREW, DRIVE, RH, RoHS
-	1	-	1	1	1	2119793-1 LIMITER, ADJUSTMENT BOLT
-	3	-	3	3	3	992763-5 SCR, SET, SOC, CONE POINT, M3 X 4.0
-	2	2	2	2	2	2-18032-5 SCR, SET, FLT POINT M5 X 20.0
-	1	1	1	1	1	2079383-4 SCR, BHSC, RoHS (M4 X 8)
-	-	-	-	1	1	5-18022-5 SCR, HEX HD CAP, M4 X 6.0
-	1	1	1	1	1	21028-2 PIN, SLOTTED SPRING .062 X .250
-	-	-	-	1	1	1338685-3 PAWL, FEED
-	4	4	4	4	4	2168400-1 SHCS, LOW HEAD, RoHS, M4 X 12
-	1	1	1	1	1	1-5018030-0 NUT, HEX, REG, RoHS, M3.5
-	1	1	1	1	1	1901681-8 HOLDDOWN, TERMINAL
-	1	1	1	1	1	1-1752354-6 STANDOFF, HOLD-DOWN
-	-	-	-	1	2	18023-9 SCR, SKT HD CAP M4 X 6.0
-	-	-	-	-	1	2119652-1 FEED CAM, PRE FEED
-	-	-	-	-	1	2119653-1 FEED CAM, POST FEED
-	1	1	1	1	1	2119656-9 APPLICATOR BASIC ASSEMBLY, SF
-	1	-	1	1	1	2119370-1 RAM, AMP STYLE, SIDE FEED
-	1	1	1	1	1	2079383-7 SCR, BHSC, RoHS (M8 X 25)
-	1	-	1	1	1	2119645-1 DISC, NUMBERED FA WIRE ADJUSTMENT
-	1	-	1	1	1	2119957-1 APPLICATOR SHIM PACK
-	1	1	1	1	1	2119644-1 RAM WASHER, PRECISION
-	1	1	1	1	1	2119085-1 FA HEAD, ATLANTIC STYLE
-	1	-	1	1	1	2119092-1 BOLT, ADJUSTMENT
-	1	1	1	1	1	3-1752356-9 SUPPORT, TERMINAL
-	2	2	2	2	2	2079383-5 SCR, BHSC, RoHS (M4 X 20)
-	1	1	1	1	1	2161328-1 HEX HEAD, FLANGED, M5 X 8mm LONG
-	1	1	1	1	1	1-1320908-7 SPACER, STRIP GUIDE
-	1	1	1	1	1	455888-3 SPACER, CRIMPER
-	2	2	2	2	2	22283-1 SPRING, COMPRESSION
-	1	1	1	1	1	356835-1 LEVER, DRAG RELEASE
-	1	1	1	1	1	240792-5 DRAG, TERMINAL
-	1	1	1	1	1	1-1320928-9 PLATE, STRIP GUIDE
-	1	1	1	1	1	980371-4 SCR, SKT HD SHLDR 5.0 DIA X 6.0
-	1	1	1	1	1	2168083-2 SCR, SKT HD CAP, RoHS, M4 X 8.0
-	1	1	1	1	1	1-18028-2 WASHER, FLAT, REG M4
-	1	1	1	1	1	2119533-3 STRIPPER, SIDE FEED
-	1	1	1	1	1	2119806-1 INSERT, SHEAR
-	1	1	1	1	1	3-22280-3 SPRING, COMPRESSION
-	1	1	1	1	1	1-356885-4 STOP, SHEAR
-	1	1	1	1	1	2119805-1 SHEAR HOLDER, FRONT
-	1	1	1	1	1	1633861-3 SHEAR, FLOATING
-	1	1	1	1	1	2-1633127-4 ANVIL, COMBINATION .042
-	1	1	1	1	1	2119780-1 DEPRESSOR, SHEAR
-	1	1	1	1	1	2-238011-0 BLOCK, CRIMPER SPACER
-	1	1	1	1	1	1-1633962-1 CRIMPER, INSULATION F PREMIUM
-	1	1	1	1	1	455888-1 SPACER, CRIMPER
-	1	1	1	1	1	3-1633730-4 CRIMPER, WIRE

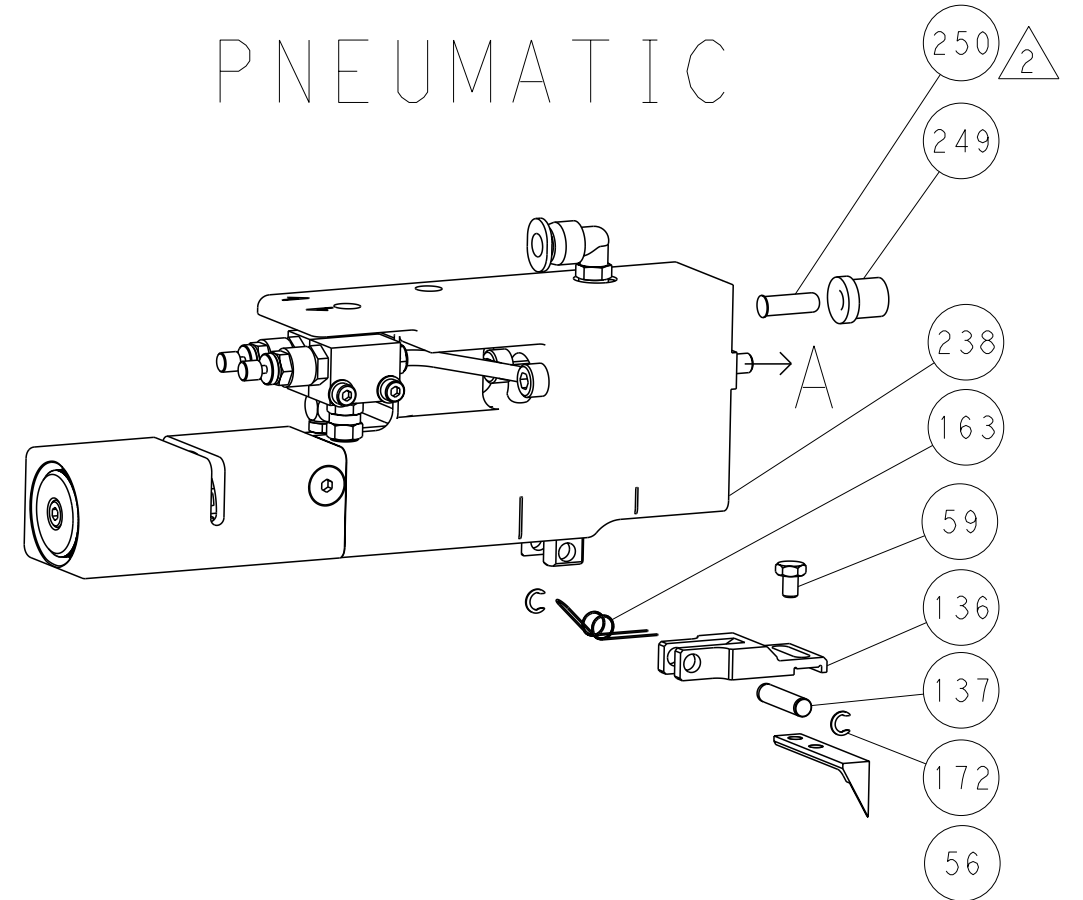
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		9 PLC ± .5	PLC ± 0.13	5 PLC ± 0.013	4 PLC ± 0.0001	NAME: Ocean Side Feed Applicator		SIZE: A1	CAGE CODE: 00779	DRAWING NO: C=2151076	RESTRICTED TO: -
MATERIAL: -		FINISH: -		WEIGHT: -		CUSTOMER ACCESSIBLE PRODUCTION DRAWING		SCALE: 1:2	SHEET: 1 OF 4	REV: A	-

LOC	DIST	REV	DESCRIPTION	DATE	DWN	APVD
A	66		SEE SHEET 1			

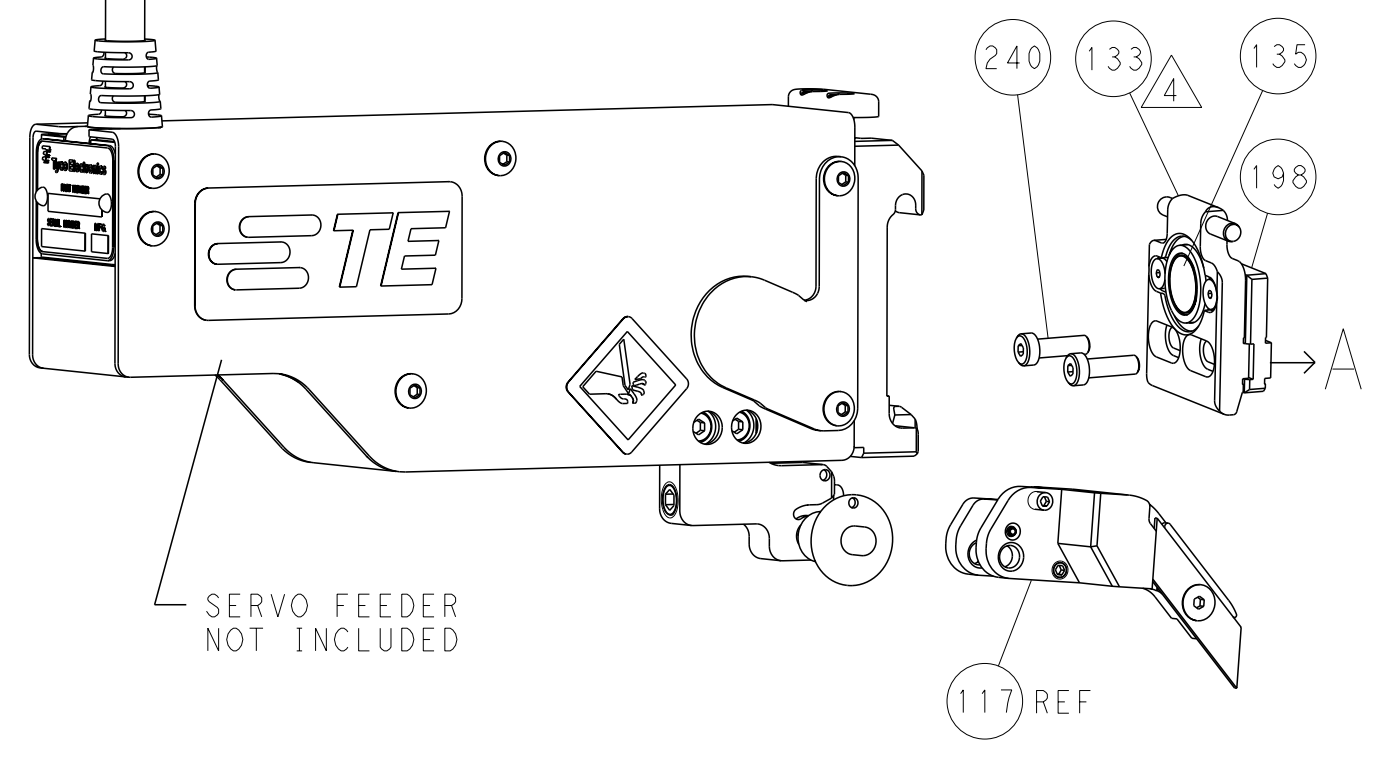
FEED TYPE MECHANICAL



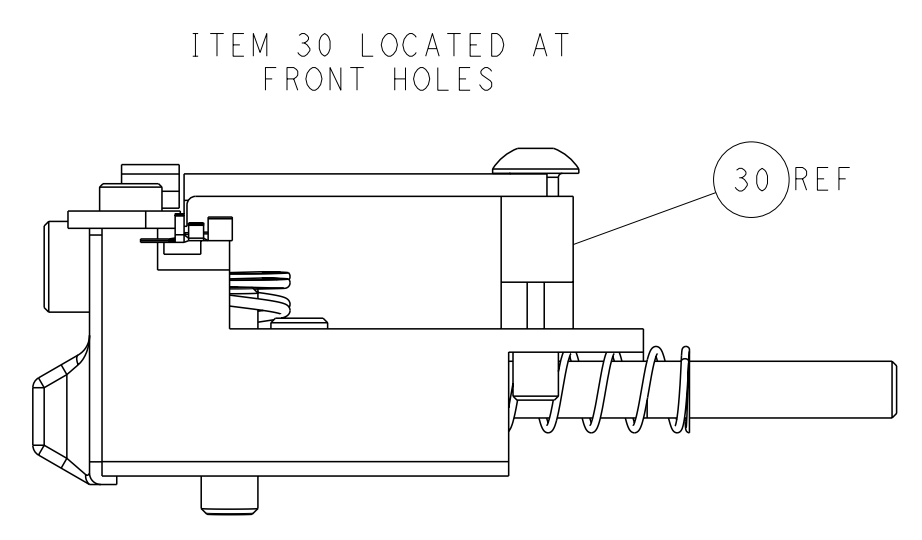
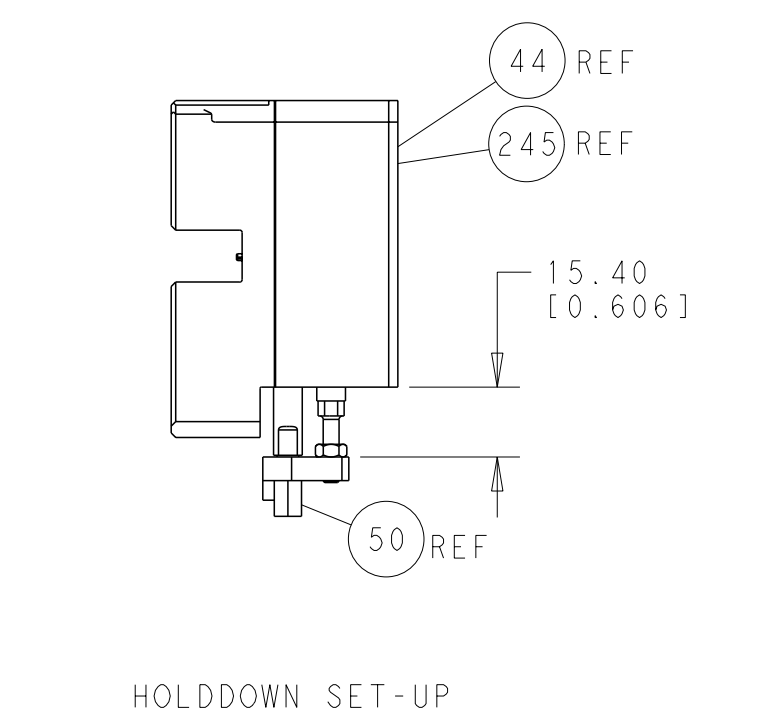
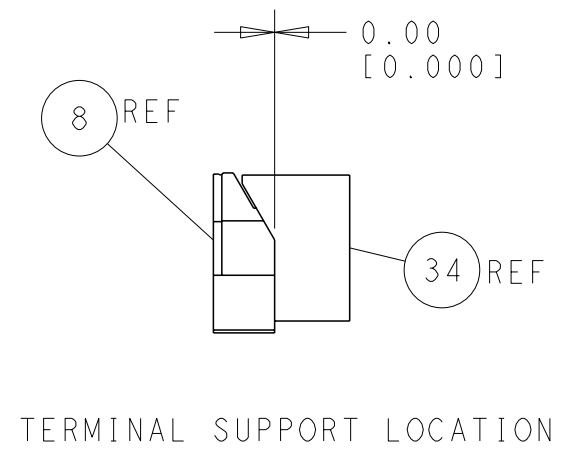
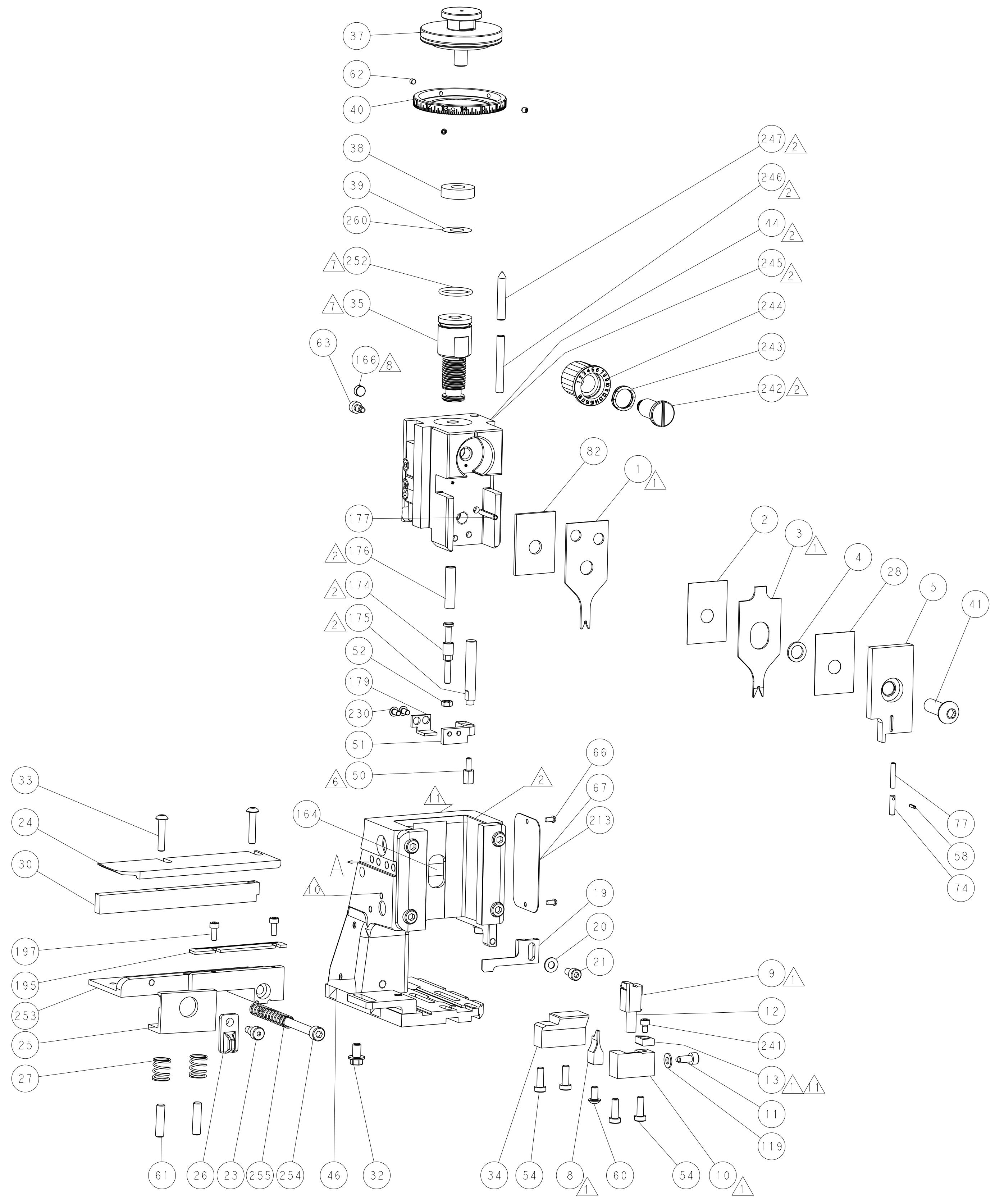
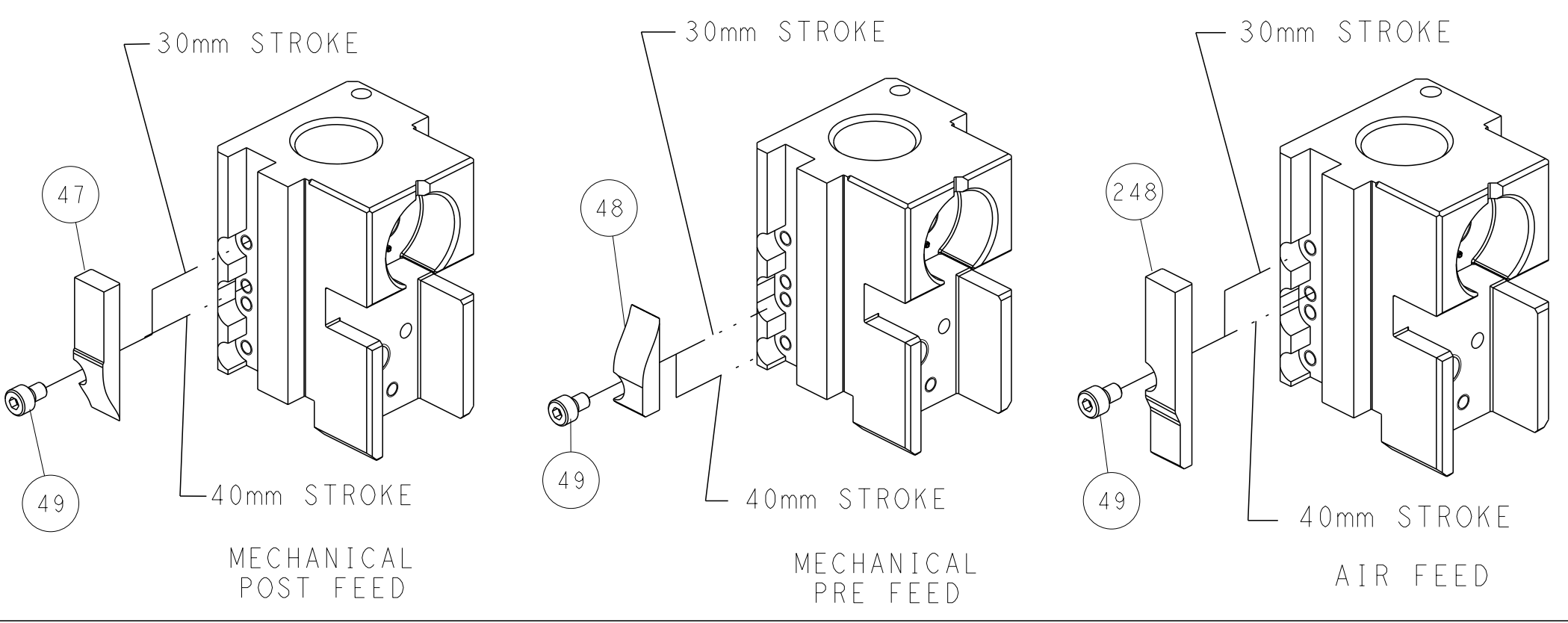
PNEUMATIC



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: Y. LIN 26AUG2011		TE Connectivity	
mm	9 PLC ±0.5	1 PLC ±0.5	2 PLC ±0.13	3 PLC ±0.13	4 PLC ±0.013	5 PLC ±0.001	Harrisburg, PA 17105-3608
	ANGLES ±0.0001			CHK: G. BAILEY 26AUG2011		NAME: Ocean Side Feed Applicator	
MATERIAL:	FINISH:			APVD: S. XI 26AUG2011		PRODUCT SPEC:	
				APPLICATION SPEC:		SIZE: CAGE CODE: DRAWING NO: RESTRICTED TO:	
				WEIGHT:		A11 00779 C-2151076	
CUSTOMER ACCESSIBLE PRODUCTION DRAWING				SCALE: 1:2		SHEET 2 OF 4 REV A	

PACIFIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART						
					CONVERT TO	PART NUMBERS REQUIRED					
	2-2151076-1	A	FINE CRIMP HEIGHT ADJUST	MECHANICAL	PNEUMATIC FEED	2119950-1	1338685-3	5-18022-5	2119641-2	2119799-1	2063440-1
					SERVO LATCH PLATE	2119951-1	-	8-2151076-5	1901094-3	-	2168400-6 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2151076-4	-	-	-
	2-2151076-2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	MECHANICAL FEED	2119949-1	1338685-3	5-18022-5	2119653-2	-	-
					SERVO LATCH PLATE	2119951-1	-	8-2151076-5	1901094-3	-	2168400-6 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2151076-4	-	-	-
	2-2151076-5	A	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE	MECHANICAL FEED	2119949-1	1338685-3	5-18022-5	2119653-2	-	-
					PNEUMATIC FEED	2119950-1	1338685-3	5-18022-5	2119641-2	2119799-1	2063440-1
	2-2151076-7	A	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	-
	7-2151076-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.07 mm [.042]	F
INSUL	1.45 mm [.057]	F
APPLICATOR INSTRUCTIONS 408-10389		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION
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TERMINAL APPLICATION SPECIFICATION 114-5425	-	-
TERMINALS APPLIED		
TE TERMINAL	TE TERMINAL	TE TERMINAL
1971031-1	1971031-2	

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
24 AWG	0.65 +/- 0.03 [.026 +/- .001]	10.7
26 AWG	0.59 +/- 0.03 [.023 +/- .001]	11.5
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- 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: 8-2151076-4
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151076-4
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151076-5
 SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2151076-6
- 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 50.
- 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.

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 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	1-22281-8	SPRING, COMPRESSION	255
-	1	1	1	1	8-1655316-7	SCR, SKT HD CAP, M5 X 65	254
-	1	1	1	1	1901086-2	PLATE, STRIP GUIDE	253
-	1	1	1	1	2119782-1	FINE ADJUST HEAD ASM, PACIFIC STYLE	251
-	-	-	-	-	2119640-1	PUSH ROD, AIR FEED	250
-	-	-	-	-	2079988-1	BUSHING, LCH5-12, MISUMI	249
-	1	1	1	1	1-22279-3	SPRING, COMPRESSION	246
-	1	1	1	1	2119082-9	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	18023-1	SCR, SKT HD CAP M3 X 5.0	241
-	-	-	-	-	2168400-6	SHCS, LOW HEAD, RoHS, M5 X 16	240
-	-	-	-	-	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	-	-	-	-	2063440-1	AIR FEED MODULE	238
-	2	2	2	2	1655785-9	SCR, BTN SKT HD CAP (M3 X 6)	230
-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	REV	DATE	BY	APPV
			1			
			2			

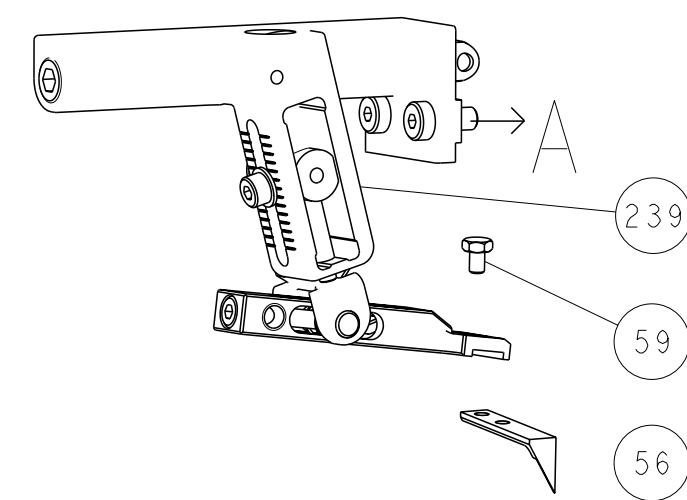
REV	DATE	BY	APPV	DESCRIPTION	DATE	BY	APPV
-	-	1	-	-	2119740-2	TAG, IDENTIFICATION	213
-	-	1	-	-	1901094-3	SPACER, FEEDER	198
-	2	2	2	-	4-1655316-4	SCR, SKT HD CAP, M3 X 8.0	197
-	1	1	1	1	1-690438-0	FRONT STRIP GUIDE	195
-	1	1	1	1	1-1633764-7	HOLD DOWN, TERMINAL	179
-	1	1	1	1	9931111-1	PIN, SLOTTED SPRING 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	1-455888-8	SPACER, CRIMPER	82
-	1	1	1	1	547505-3	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	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
-	2	2	2	2	2-18032-5	SCR, SET, FLT POINT M5 X 20.0	61
-	-	-	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	1338685-3	PAWL, FEED	56
-	1	1	1	1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52
-	1	1	1	1	1901681-8	HOLDDOWN, TERMINAL	51
-	1	1	1	1	1-1752354-6	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	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
-	1	1	1	1	3-1752356-9	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	1-1320908-7	SPACER, STRIP GUIDE	30
-	1	1	1	1	455888-3	SPACER, CRIMPER	28
-	2	2	2	2	22283-1	SPRING, COMPRESSION	27
-	1	1	1	1	356835-1	LEVER, DRAG RELEASE	26
-	1	1	1	1	240792-5	DRAG, TERMINAL	25
-	1	1	1	1	1-1320928-9	PLATE, STRIP GUIDE	24
-	1	1	1	1	980371-4	SCR, SKT HD SHLDR 5.0 DIA X 6.0	23
-	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	2119533-3	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	1633861-3	SHEAR, FLOATING	9
-	1	1	1	1	2-1633127-4	ANVIL, COMBINATION .042	8
-	1	1	1	1	2119780-1	DEPRESSOR, SHEAR	5
-	1	1	1	1	2-238011-0	BLOCK, CRIMPER SPACER	4
-	1	1	1	1	1-1633962-1	CRIMPER, INSULATION F PREMIUM	3
-	1	1	1	1	455888-1	SPACER, CRIMPER	2
-	1	1	1	1	3-1633730-4	CRIMPER, WIRE	1
-77	-27	-25	-22	-21	PART NO	DESCRIPTION	ITEM NO

DIMENSIONS:	TOLERANCES UNLESS OTHERWISE SPECIFIED:	DATE	BY	APPV	NAME	SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
mm	9 PLC ±.5 1 PLC ±0.5 3 PLC ±0.13 5 PLC ±0.013 4 PLC ±0.0001	26AUG2011	T.YIN	G.BALLEY	TE Connectivity Harrisburg, PA 17105-3608	A1	00779	2151076	
MATERIAL:	FINISH:	WEIGHT:	CUSTOMER ACCESSIBLE PRODUCTION DRAWING						
SCALE: 1:2 SHEET 3 OF 4 REV A									

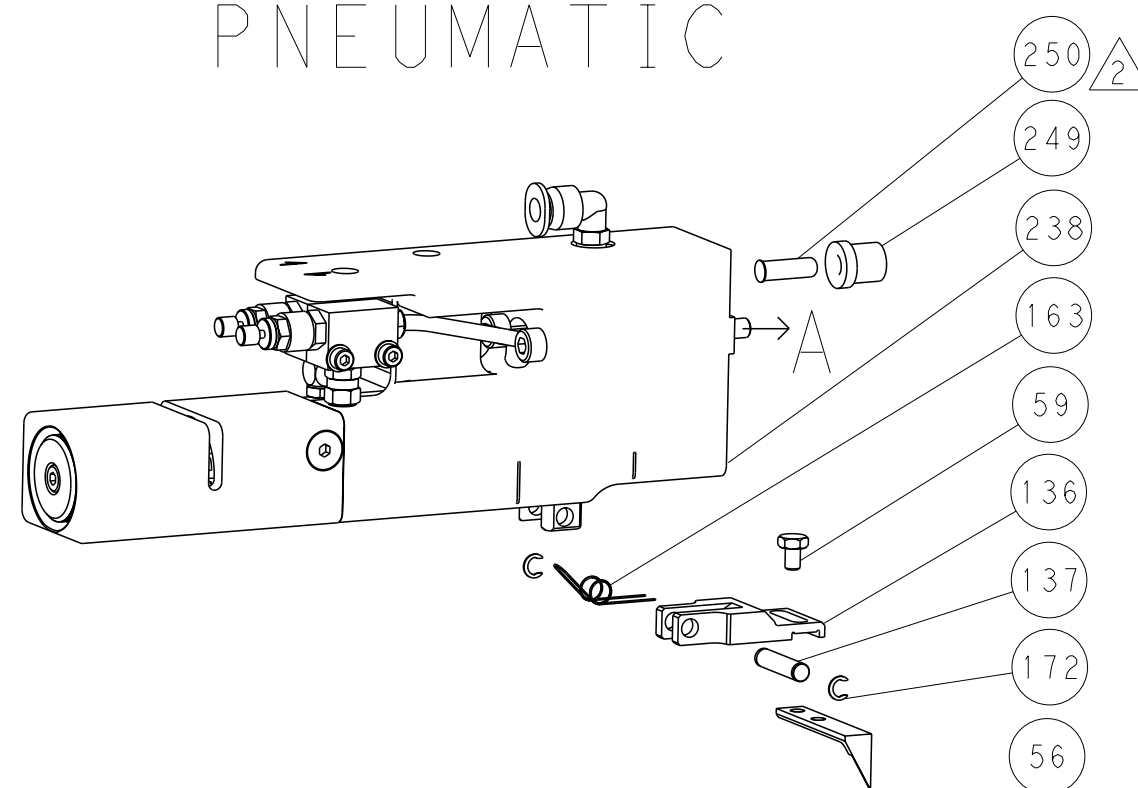
LOC	DIST	REV	DESCRIPTION	DATE	OWN	APVD
A	66		SEE SHEET 1			

DIMENSIONING AND TOLERANCING PER ASME Y14.5M-2009

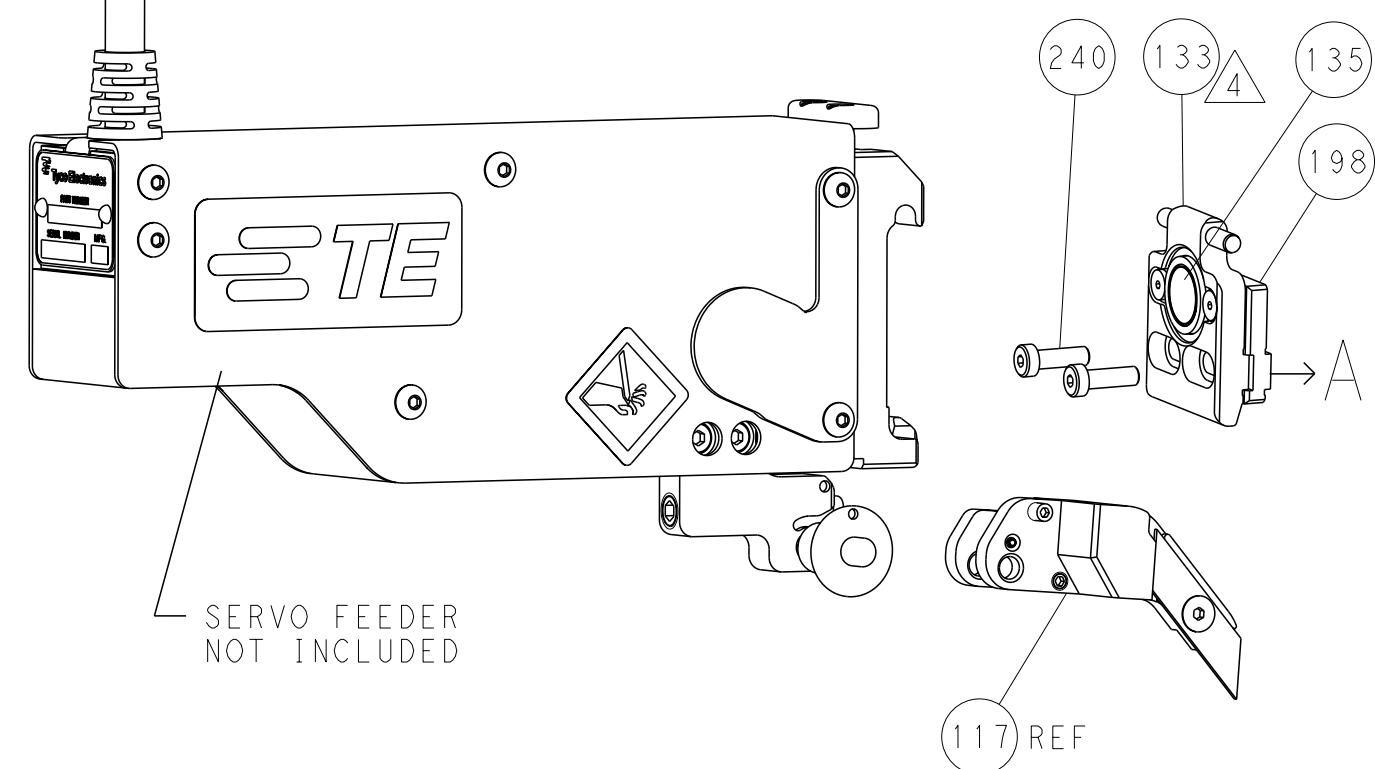
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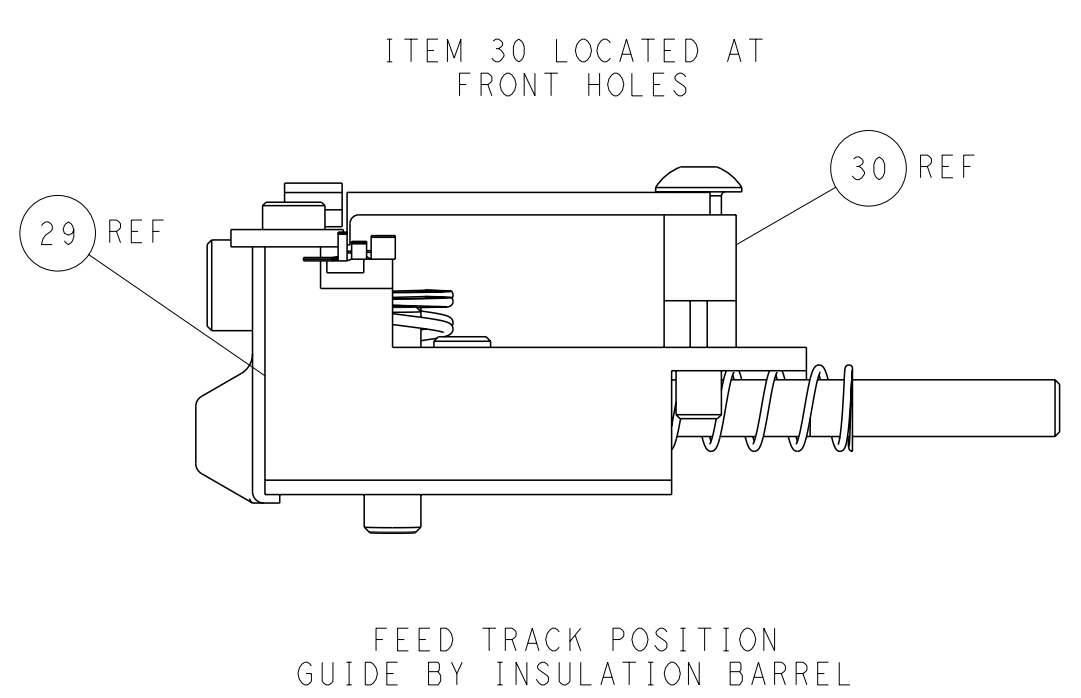
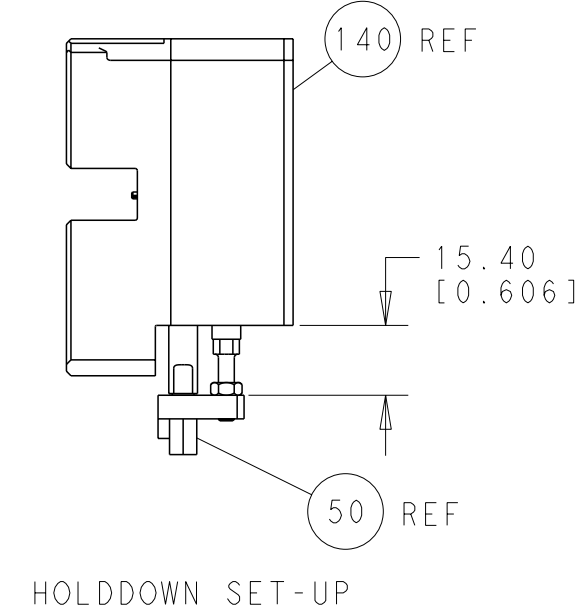
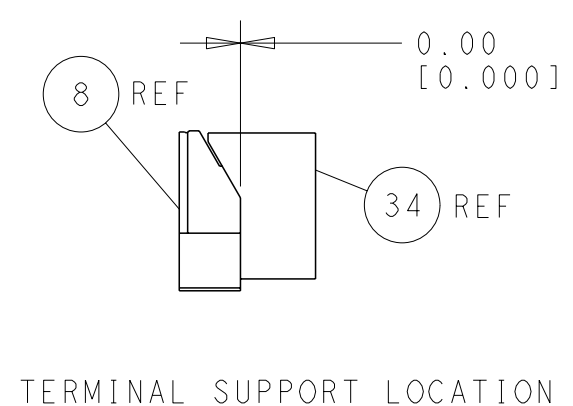
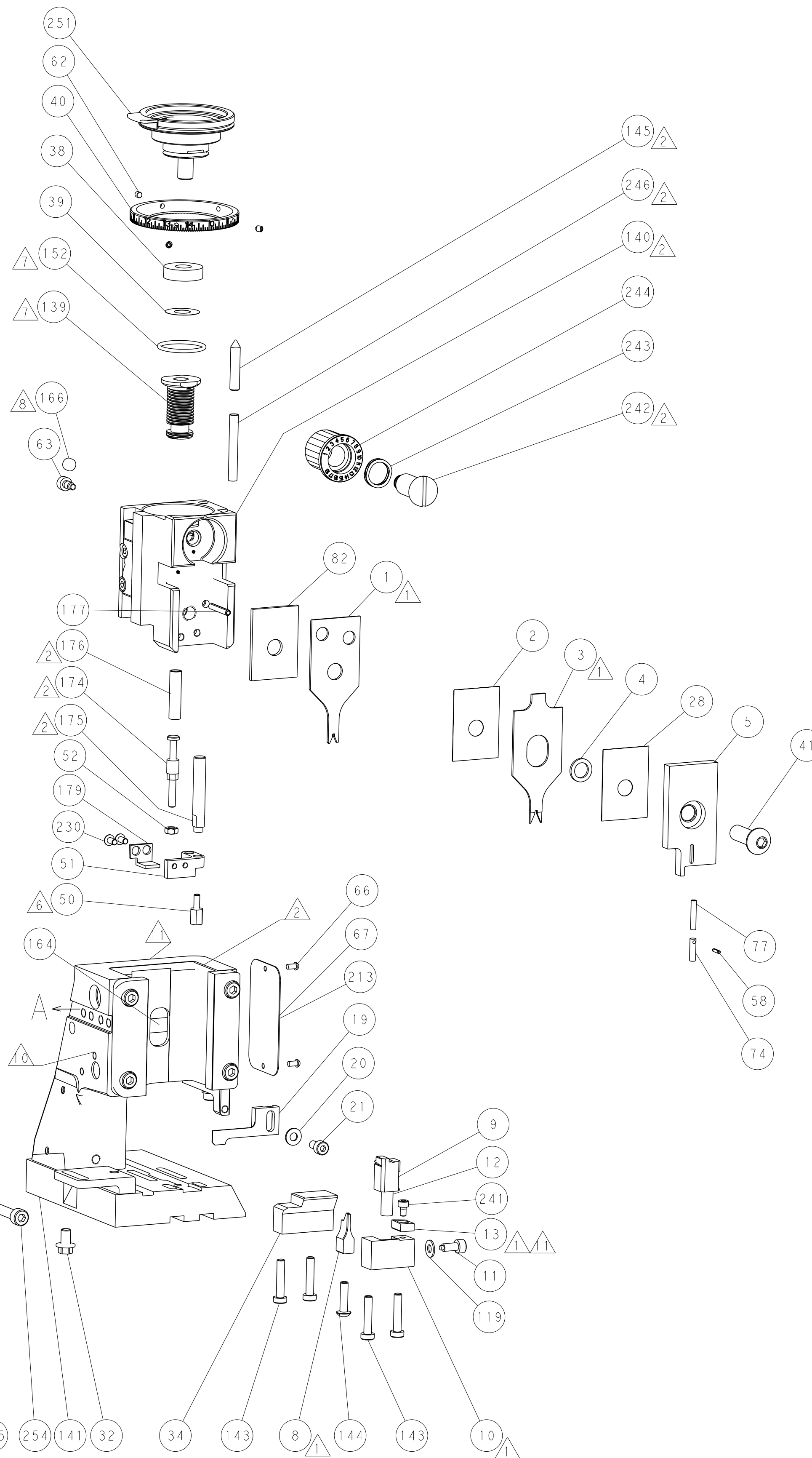
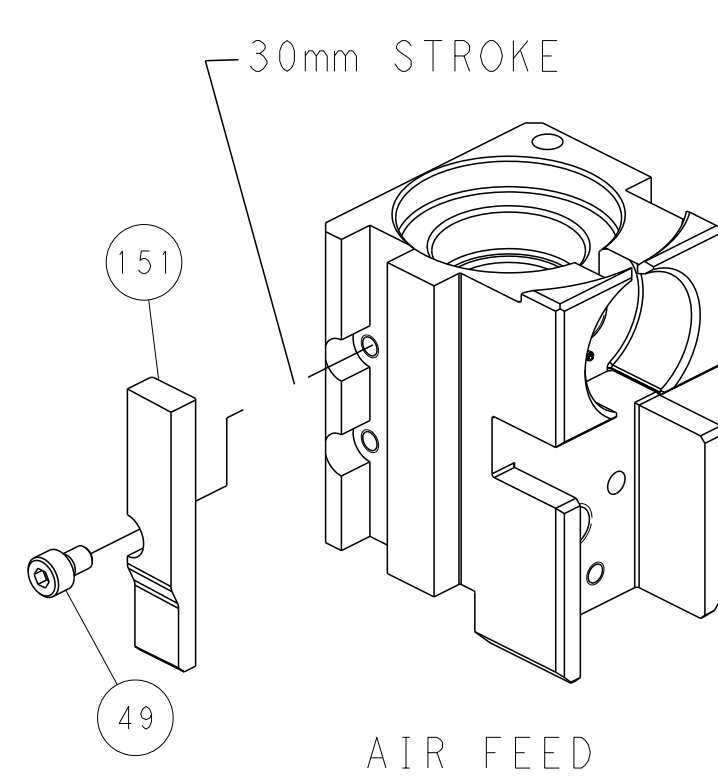
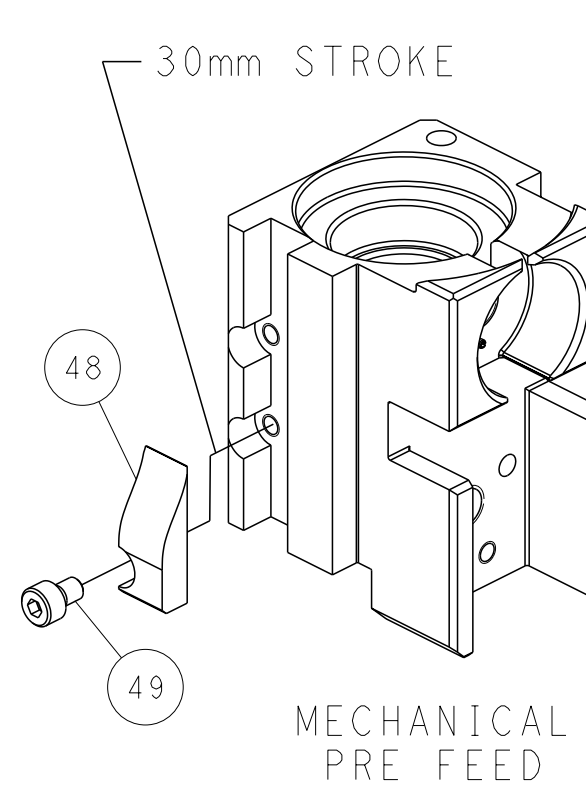
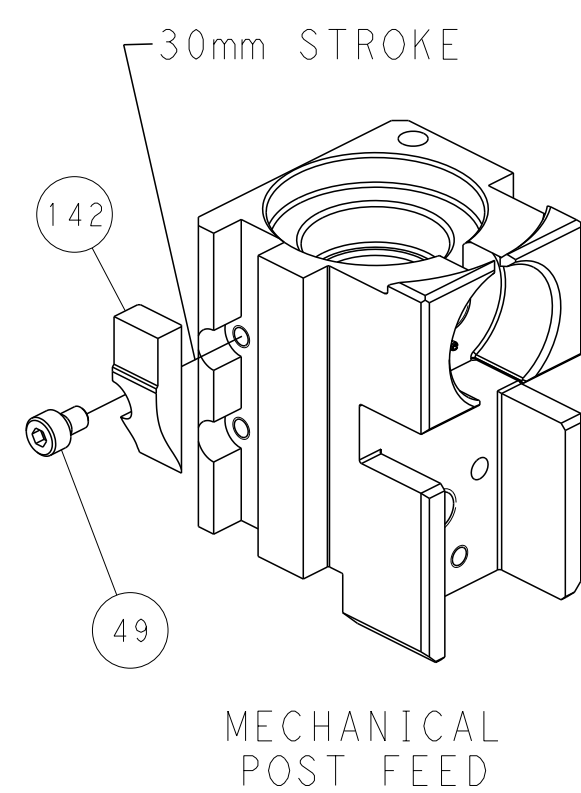
PNEUMATIC



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)

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DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 9 PLC ±0.5 1 PLC ±0.13 5 PLC ±0.013 4 PLC ±0.0001 ANGLES FINISH:	PRODUCT SPEC: APPLICATION SPEC: WEIGHT: CUSTOMER ACCESSIBLE PRODUCTION DRAWING	SIZE: A1 CAGE CODE: 00779 DRAWING NO: C-2151076 SCALE: 1:2 SHEET: 4 OF 4 REV: A	RESTRICTED TO: