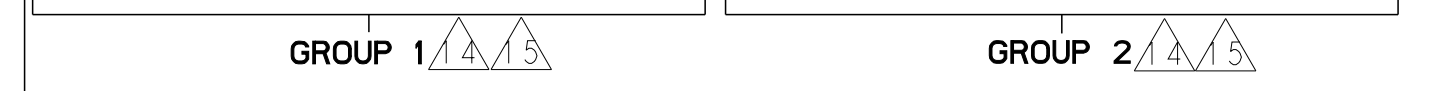


ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART						
					CONVERT TO	PART NUMBERS REQUIRED					
	2151034-2	E	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	-	1338685-1	5-18022-5	-	-	-	
	2151034-5	E	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE ⁴	SERVO LATCH PLATE	2119951-1	2161540-1	8-2151034-5	1901094-3	1976043-1	2168400-6 (QUANTITY 2)
	2151034-6	E	NON-CRIMP HEIGHT ADJUST	SERVO LATCH PLATE ¹⁰	PNEUMATIC FEED	2119950-1	1338685-1	5-18022-5	2119641-1	2119799-1	2063440-2
	2151034-7	E	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	-
	7-2151034-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-

APPLICATOR DATA		
CRIMP WIRE	SIZE	TYPE
	.176 [4.47 mm]	0
INSUL	-	-
APPLICATOR INSTRUCTIONS 408-10389		

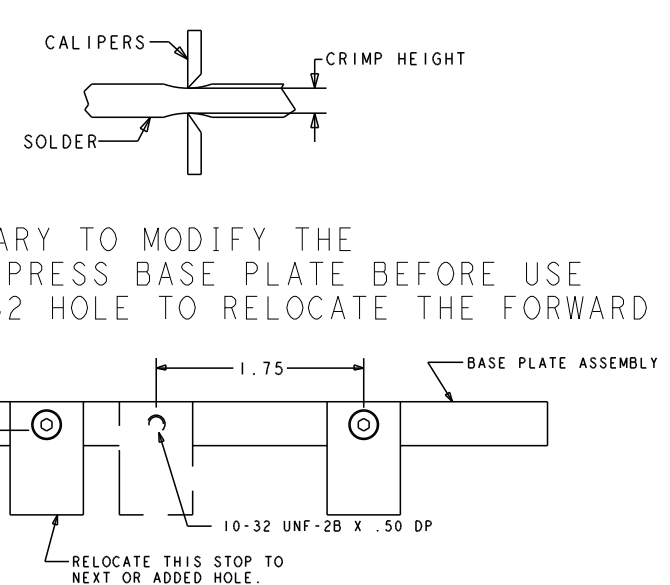
TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: FULLY INSULATED FASTON			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
.265-.297 IN [6.73-7.54 mm]		∅	¹⁴
TERMINAL APPLICATION SPECIFICATION	114-2123	-	-
TERMINALS APPLIED ¹⁰			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
2-520102-1	5-520183-2	2-520274-2	
2-520102-2	9-520183-2	2-521144-2	
2-520181-2	2-520193-2	2-520261-2	
2-520181-4	9-520193-2	9-520261-2	
5-520181-2	2-521102-2	2-520263-2	
9-520181-2	2-521104-2	2-520263-4	
2-520183-2	2-521308-2	5-520263-2	
2-520183-4	2-521406-2		



WIRE SIZE	CRIMP HEIGHT INCH [mm]	CRIMP HEIGHT REFERENCE SETTING	∅ SOLDER
18, (2)22, or (1)20+(1)22	0.070+/-0.002 [1.78+/-0.05]	6.4	.125 IN [3.175mm]
20 or 22	0.065+/-0.002 [1.65+/-0.05]	8.3	.125 IN [3.175mm]

- 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: 8-2151034-4
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151034-5
 SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2151034-6
- 5. ADJUSTMENT OF THE STRIPPER MAY BE REQUIRED WHEN MOVING THE APPLICATOR BETWEEN BENCH AND LEADMAKER APPLICATIONS.
- ⁶ GREASE THREADS, GROOVE AND O-RING ON ITEMS 35 & 252.
- ⁷ MAGNET, ITEM 166 MUST BE ORIENTED CORRECTLY IN ORDER TO PROPERLY ACTUATE THE COUNTER.
- ⁸ 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.
- ⁹ 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.
- ¹⁰ 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
- ¹¹ ITEM 7 MUST BE REMOVED IF APPLICATOR IS USED ON BENCH MACHINE.
- ¹² ITEMS 5 AND 9 OR ITEMS 10 AND 22 ARE REQUIRED WHEN RUNNING ON A LEADMAKER. ITEM 42 OR 43 REQUIRED WHEN RUNNING ON A BENCH MACHINE.
- ¹³ FEED ADJUSTMENT MAY BE REQUIRED WHEN SWITCHING TERMINALS.
- ¹⁴ GROUP 1 TERMINALS: ∅.135 IN [3.43mm] MAX INSULATION
 GROUP 2 TERMINALS: ∅.200 IN [5.08mm] MAX INSULATION

- ¹⁵ USE ITEMS 5, 9, OR 42 WITH GROUP 1 TERMINALS USE ITEMS 10, 22, OR 43 WITH GROUP 2 TERMINALS
- ¹⁶ TO CHECK CRIMP HEIGHT, CRIMP SOLDER (∅.12 IN [3.05mm] 60/40 SOLID CORE) AND MEASURE AT CENTER OF SLUG.
- ¹⁷ IT MAY BE NECESSARY TO MODIFY THE T-TERMINATING/K-PRESS BASE PLATE BEFORE USE BY ADDING A 10-32 HOLE TO RELOCATE THE FORWARD STOP AS SHOWN.
- ¹⁸ ITEMS 253 AND 255 MUST BE INSTALLED IN THE G-TERMINATING UNIT CHIP RELIEF HOLE BEFORE INSTALLING THE APPLICATOR.
- ¹⁹ ITEM 257, REQUIRED IF APPLICATOR IS RUN ON T-TERMINATING UNIT/K-PRESS. GUARD, ITEM 256, REQUIRED IF APPLICATOR IS BEING USED ON G-TERMINATOR.
- ²⁰ TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.



***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	-	-	2119957-2	APPLICATOR SHIM PACK	260
²	-	REF	REF	REF	REF	462992-5	GUARD ASSY	257
³	-	REF	REF	REF	REF	679532-1	INSERT, GUARD	256
⁴	-	1	1	1	1	189728-1	BRACKET, SPACER	255
⁵	-	1	1	1	1	568681-1	SPACER, BASE PLATE	253
⁶	-	1	-	1	1	8-21084-0	O-RING, .676 ID, .070 DIA. MAT.	252
	-	-	-	-	1	2119640-1	PUSH ROD, AIR FEED	250
	-	-	-	-	1	1803259-1	BUSHING, FLANGED	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	-	1	2119758-1	RAM, AMP STYLE, SIDE FEED, NON-ADJ.	245
	-	1	1	1	1	18023-1	SCR, SKT HD CAP M3 X 5.0	241
	-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					
2119599-1	A	66	P	LTN	DESCRIPTION	DATE	OWN	APVD
			C		ECR-15-001464	29JAN2015	LG	TE
			D		ECR-15-011872	10AUG2015	JH	UG
			D1		ECR-15-016137	04NOV2015	JH	JDG
			E		ECR-16-016256	16NOV2016	TB	CT

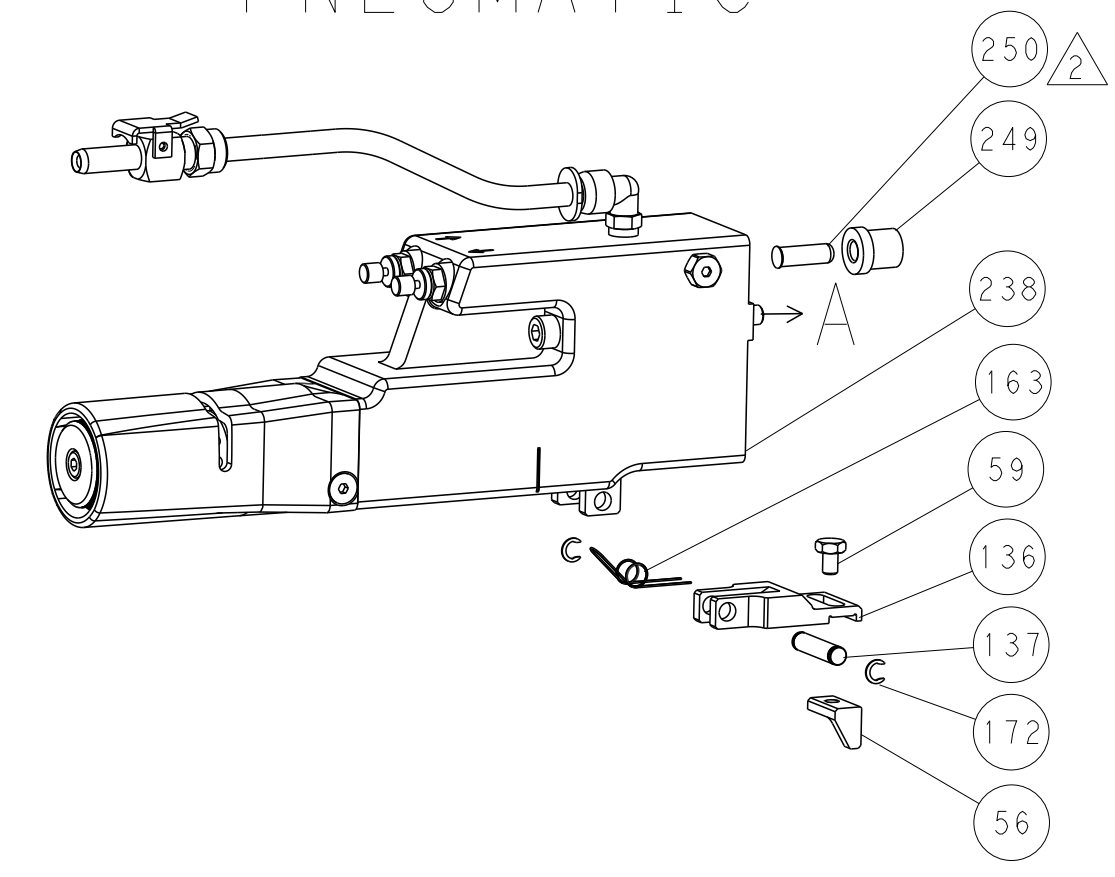
-	-	2	2	-	2168400-6	SHCS, LOW HEAD, RoHS, M5 X 16	240
-	-	-	-	-	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	-	-	-	1	2063440-2	AIR FEED MODULE	238
-	-	1	1	-	2119740-2	TAG, IDENTIFICATION	213
-	-	1	1	-	1901094-3	SPACER, FEEDER	198
-	-	-	-	2	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172
-	1	1	1	1	994969-1	MAGNET, RARE EARTH HIGH ENERGY	166
-	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	-	-	-	1	240638-1	SPRING, FEED FINGER	163
-	-	-	-	1	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854	137
-	-	-	-	1	2119799-1	HOLDER, FEED FINGER, AF	136
⁴	-	REF	REF	-	SEE NOTE 4	MEMORY CHIP, PROGRAMMED	135
-	-	1	1	-	1633743-1	SERVO FEED LATCH ASM	133
-	1	1	1	1	1-22281-8	SPRING, COMPRESSION	121
-	1	1	1	1	1-690438-0	FRONT STRIP GUIDE	96
-	4	4	4	4	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	95
-	1	1	1	1	2168083-6	SCR, SKT HD CAP, RoHS, M5 X 65	93
-	1	1	1	1	455888-4	SPACER, CRIMPER	82
-	1	1	1	1	240641-6	SPACER	81
-	1	1	1	1	2119956-1	DOCUMENTATION PACKAGE	71
-	1	1	1	1	2161332-2	DEPRESSOR, WIRE FUNNEL	70
-	1	1	1	1	2161331-1	SPACER, WIRE FUNNEL DEPRESSOR	69
-	2	2	2	2	1-18028-4	WASHER, FLAT, REG M3	68
-	1	-	-	1	2119740-1	TAG, IDENTIFICATION	67
-	2	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	1	-	1	1	2119793-1	LIMITER, ADJUSTMENT BOLT	63
¹	-	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	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	462427-2	FINGER, FEED	56
-	4	4	4	4	2168400-1	SHCS, LOW HEAD, RoHS, M4 X 12	54
-	2	2	2	2	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	53
-	-	-	-	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	1	1	1	1	1-2119656-9	APPLICATOR BASIC ASSEMBLY, SF	46
-	1	-	1	1	2119370-1	RAM, AMP STYLE, SIDE FEED	44
¹⁵	-	1	1	1	462433-7	SUPPORT, INSULATION	43
¹⁵	-	1	1	1	462433-6	SUPPORT, INSULATION	42
-	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
²¹	-	1	1	1	2119085-1	FA HEAD, ATLANTIC STYLE	37
²¹	-	1	-	1	2119092-1	BOLT, ADJUSTMENT	35
²¹	-	2	2	2	5-22278-1	SPRING, COMPRESSION	33
-	1	1	1	1	2161328-1	HEX HEAD, FLANGED, M5 x 8mm LONG	32
-	2	2	2	2	1-2168083-4	SCR, SKT HD CAP, RoHS, M4 X 5	30
-	1	1	1	1	2161336-1	PLATE, REAR STRIP GUIDE	29
-	2	2	2	2	22281-9	SPRING, COMPRESSION	27
-	1	1	1	1	356835-1	LEVER, DRAG RELEASE	26
-	1	1	1	1	240792-1	DRAG, TERMINAL	25
-	1	1	1	1	684042-4	GUIDE, STRIP, FRONT	24
-	1	1	1	1	980371-4	SCR, SKT HD SHLDR 5.0 DIA X 6.0	23
⁵ / ¹²	-	1	1	1	462431-6	WIRE FUNNEL	22
-	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	463460-3	HOLD DOWN, TERMINAL	18
¹	-	1	1	1	469542-3	REAR FLOATING SHEAR	17
-	4	4	4	4	1-2168083-1	SCR, SKT HD CAP, RoHS, M3 X 6	16
¹	-	1	1	1	2161335-2	SHEAR PLATE, REAR	15
-	1	1	1	1	2119862-2	SHEAR HOLDER, REAR	14
¹	-	1	1	1	2280441-1	INSERT, SHEAR	13
-	1	1	1	1	3-22280-3	SPRING, COMPRESSION	12
-	1	1	1	1	356885-4	STOP, SHEAR	11
⁵ / ¹²	-	1	1	1	462843-6	TERMINAL SUPPORT	10
⁵ / ¹²	-	1	1	1	462843-5	TERMINAL SUPPORT	9
¹	1	1	1	1	464291-4	ANVIL, SAND-BLASTED 22-18	8
¹	-	1	1	1	803925-2	GUIDE, CARRIER SCRAP	7
⁵ / ¹²	-	1	1	1	2-690468-5	DEPRESSOR SHEAR, REAR	6
⁵ / ¹²	-	1	1	1	462431-1	WIRE FUNNEL	5
-	1	1	1	1	238009-3	BLOCK, FL CRIMPER SPACER	4
¹	1	1	1	1	464290-1	CRIMPER, SEMI-FLAT 22-18	1

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

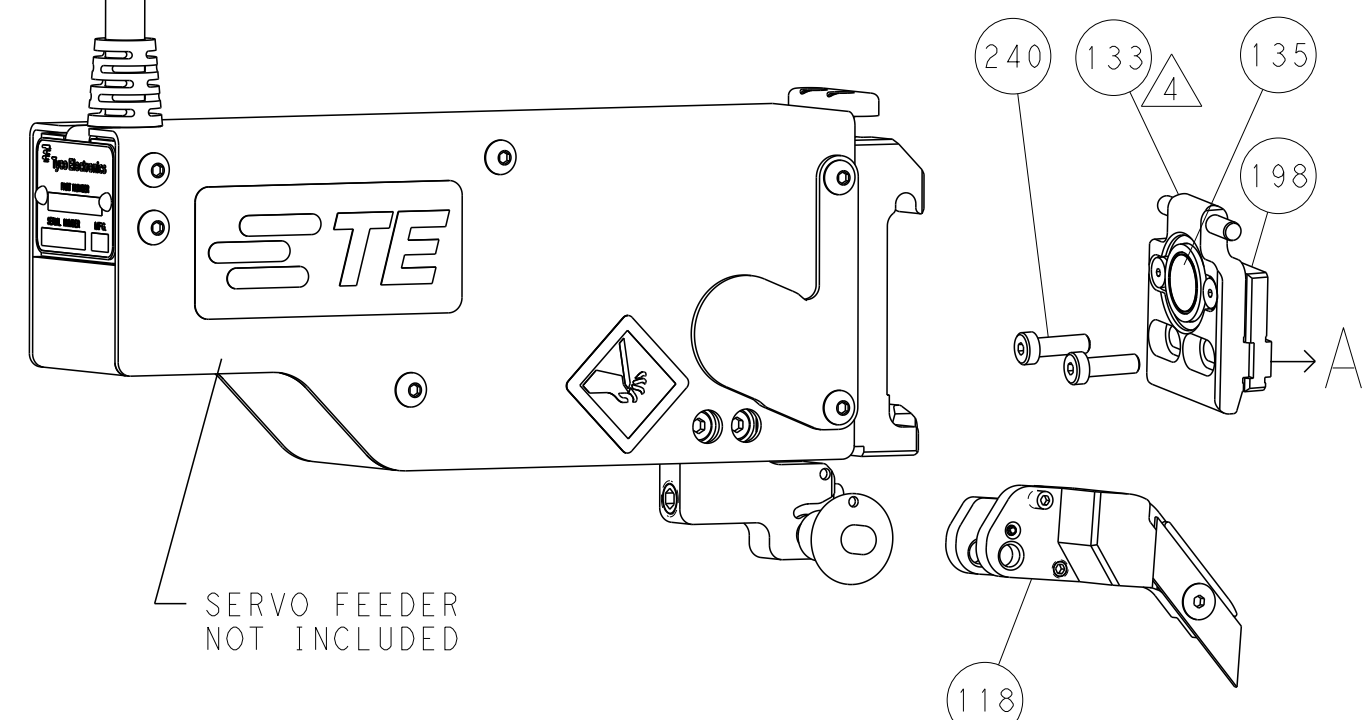
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WEAVER	21OCT2011		TE Connectivity				
G. HOFFNER	21OCT2011		Harrisburg, PA 17105-3608				
ELBIN	21OCT2011		OCEAN SIDE FEED APPLICATOR				
				A1	00779	2151034	
Customer Accessible Production Drawing				SCALE	1:1	SHEET 1 OF 4	REV E

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

FEED TYPE PNEUMATIC

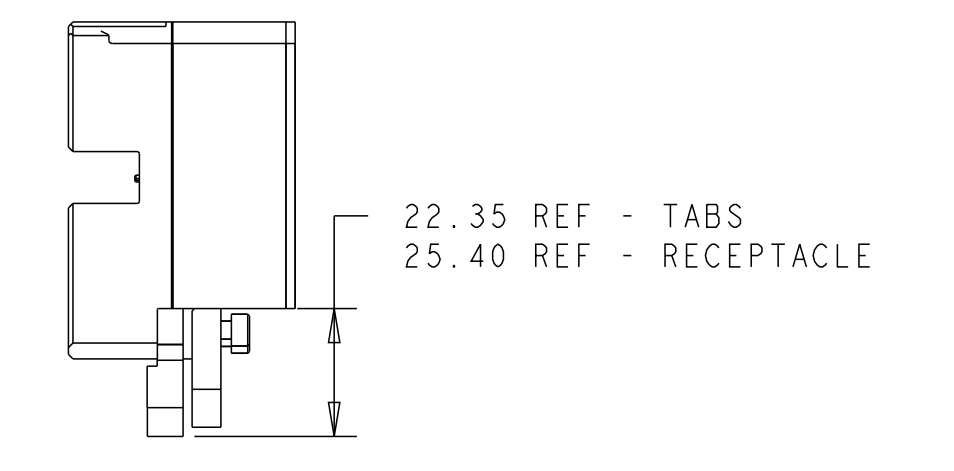
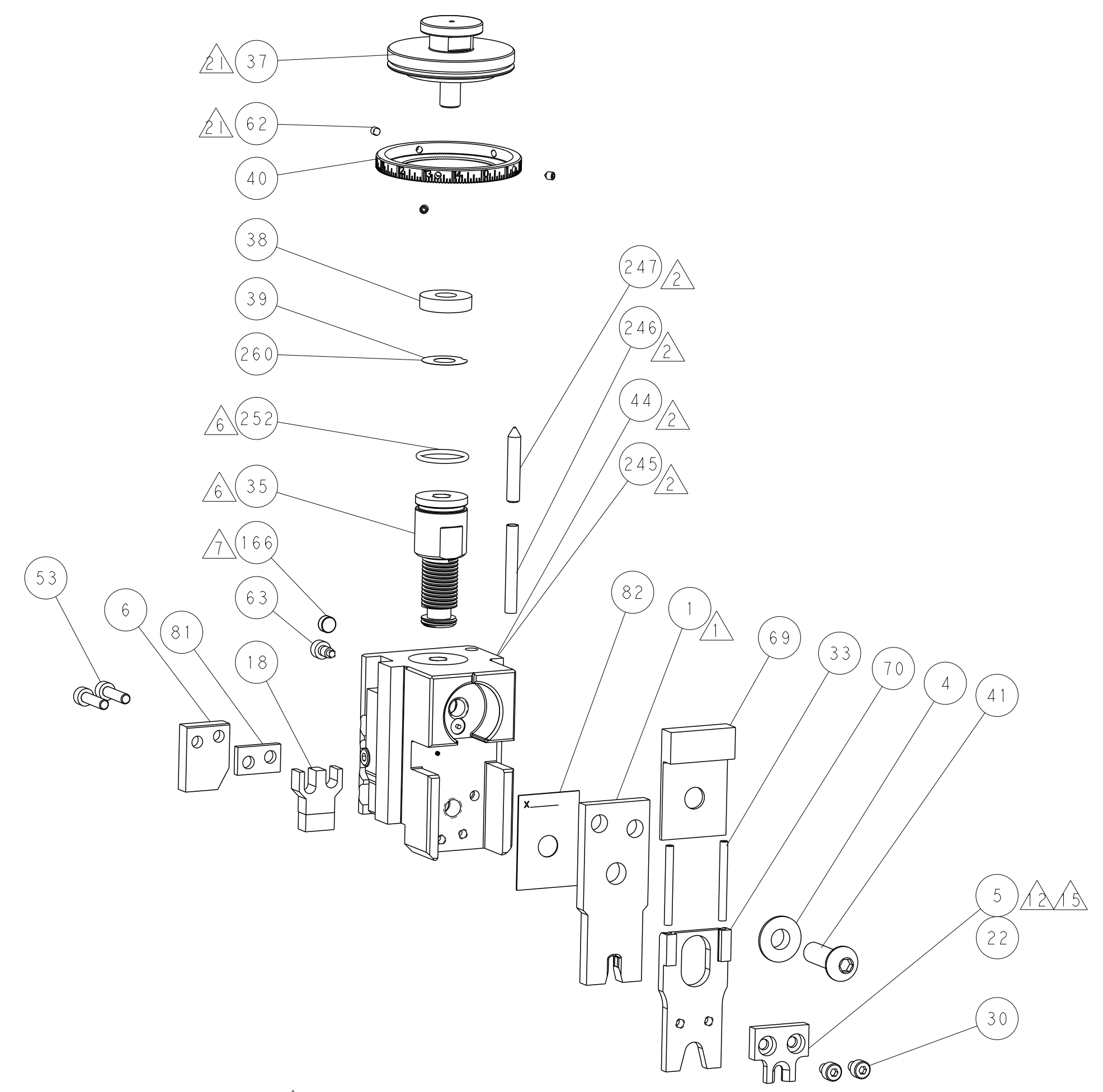
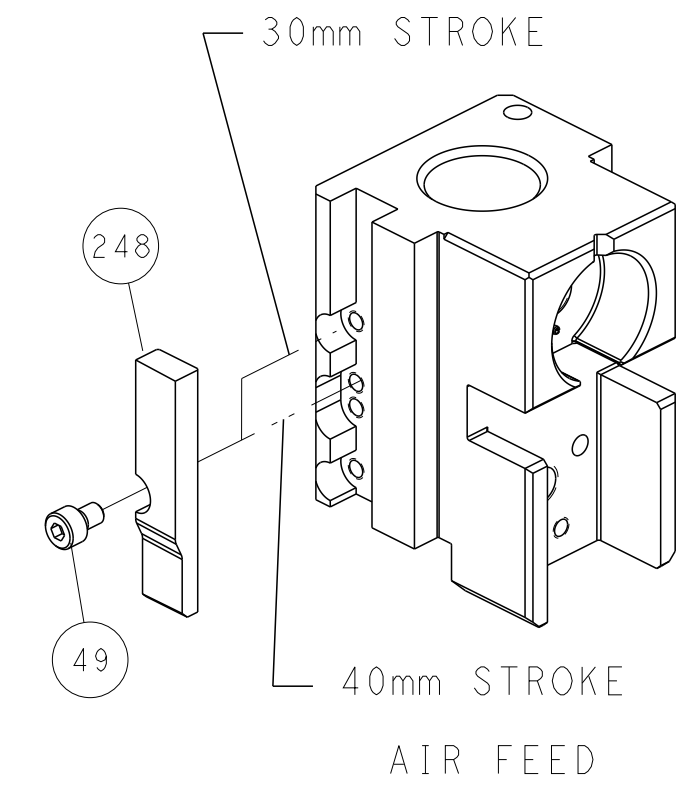


SERVO LATCH PLATE

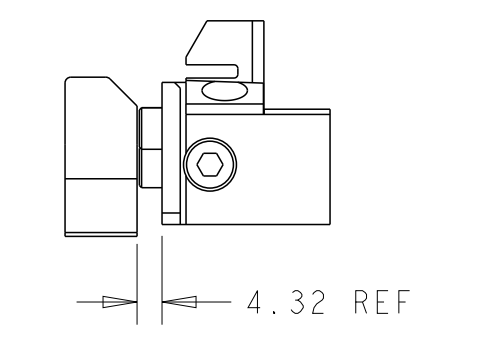


***FEED FINGER REPRESENTATION ABOVE MAY DIFFER FROM ACTUAL FEED FINGER THAT IS REQUIRED BY THIS APPLICATOR

CAM POSITIONS



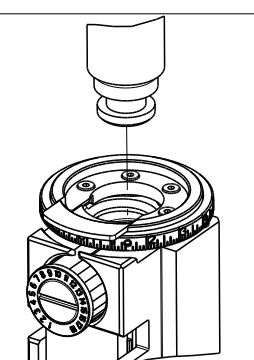
HOLDDOWN SET-UP




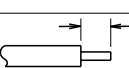

LOWER TOOLING SET-UP

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

<small>THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION 2011 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.</small>		DWN: B. WEAVER 21OCT2011 CHK: G. HOFENER 21OCT2011 APVD: T. ELBIN 21OCT2011	TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH		NAME: OCEAN SIDE FEED APPLICATOR PRODUCT SPEC: APPLICATION SPEC: SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2151034 WEIGHT:	RESTRICTED TO: SCALE: 1:1 SHEET: 2 OF 4 REV: E
MATERIAL:		Customer Accessible Production Drawing	

PACIFIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART						
					CONVERT TO	PART NUMBERS REQUIRED					
	2-2151034-2	E	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	-	1338685-1	5-18022-5	-	-	-	
					SERVO LATCH PLATE	2119951-1	2161540-1	8-2151034-5	1901094-3	1976043-1	2168400-6 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2151034-4	-	-	-
	2-2151034-5	E	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE $\Delta 4$	-	1338685-1	5-18022-5	-	-	-	-
2-2151034-7	E	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	-	
7-2151034-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-	

APPLICATOR DATA		
CRIMP WIRE	SIZE	TYPE
	.176 [4.47 mm]	Ø
INSUL	-	-
APPLICATOR INSTRUCTIONS 408-10389 		

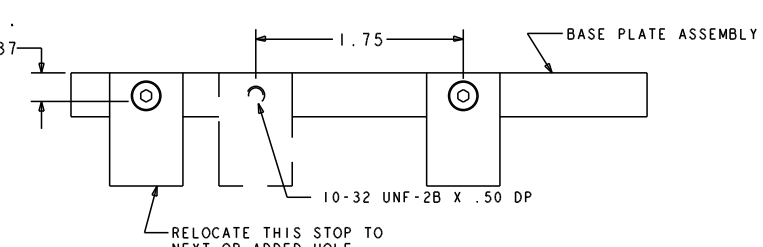
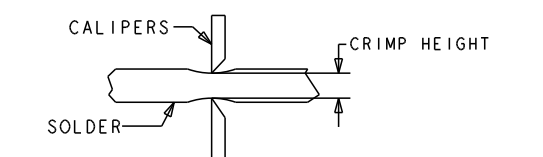
TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: FULLY INSULATED FASTON			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
.265-.297 IN [6.73-7.54 mm]		Ø	$\Delta 3$
TERMINAL APPLICATION SPECIFICATION	114-2123	-	-
TERMINALS APPLIED $\Delta 9$			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
2-520102-1	5-520183-2	2-520274-2	
2-520102-2	9-520183-2	2-521144-2	
2-520181-2	2-520193-2	2-520261-2	
2-520181-4	9-520193-2	9-520261-2	
5-520181-2	2-521102-2	2-520263-2	
9-520181-2	2-521104-2	2-520263-4	
2-520183-2	2-521308-2	5-520263-2	
2-520183-4	2-521406-2		



WIRE SIZE	CRIMP HEIGHT INCH [mm]	CRIMP HEIGHT REFERENCE SETTING	Ø SOLDER
18, (2)22, or (1)20+(1)22	0.070+/-0.002 [1.78+/-0.05]	6.4	.125 IN [3.175mm]
20 or 22	0.065+/-0.002 [1.65+/-0.05]	8.3	.125 IN [3.175mm]

- $\Delta 1$ RECOMMENDED SPARE PARTS
- $\Delta 2$ GREASE BEARING SURFACES LIGHTLY
- 3. LUBRICATE DAILY PER THE APPLICATOR INSTRUCTION SHEET SUPPLIED WITH THE APPLICATOR.
- $\Delta 4$ APPLICATOR SPECIFIC DATA TO BE ENTERED INTO BLANK MEMORY CHIP AT ASSEMBLY. SEE BELOW FOR PART NUMBER:
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151034-4
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151034-5
- 5. ADJUSTMENT OF THE STRIPPER MAY BE REQUIRED WHEN MOVING THE APPLICATOR BETWEEN BENCH AND LEADMAKER APPLICATIONS.
- $\Delta 6$ GREASE THREADS, GROOVE AND O-RING ON ITEMS 139 & 152.
- $\Delta 7$ MAGNET MUST BE ORIENTED CORRECTLY IN ORDER TO PROPERLY ACTUATE THE COUNTER.
- $\Delta 8$ 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.
- $\Delta 9$ 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.
- $\Delta 10$ ITEM 7 MUST BE REMOVED IF APPLICATOR IS USED ON BENCH MACHINE.
- $\Delta 11$ ITEMS 5 AND 9 OR ITEMS 10 AND 20 ARE REQUIRED WHEN RUNNING ON A LEADMAKER.
 ITEM 42 OR 43 REQUIRED WHEN RUNNING ON A BENCH MACHINE.
- $\Delta 12$ FEED ADJUSTMENT MAY BE REQUIRED WHEN SWITCHING TERMINALS.
- $\Delta 13$ GROUP 1 TERMINALS: Ø.135 IN [3.43mm] MAX INSULATION
 GROUP 2 TERMINALS: Ø.200 IN [5.08mm] MAX INSULATION

- $\Delta 4$ USE ITEMS 5, 9, & 42 WITH GROUP 1 TERMINALS
 USE ITEMS 10, 22, & 43 WITH GROUP 2 TERMINALS
- $\Delta 5$ TO CHECK CRIMP HEIGHT, CRIMP SOLDER (Ø.12 IN [3.05mm] 60/40 SOLID CORE) AND MEASURE AT CENTER OF SLUG.
- $\Delta 6$ IT MAY BE NECESSARY TO MODIFY THE T-TERMINATING/K-PRESS BASE PLATE BEFORE USE BY ADDING A 10-32 HOLE TO RELOCATE THE FORWARD STOP AS SHOWN.
- $\Delta 7$ ITEMS 253 AND 255 MUST BE INSTALLED IN THE G-TERMINATING UNIT CHIP RELIEF HOLE BEFORE INSTALLING THE APPLICATOR.
- $\Delta 8$ ITEM 257, REQUIRED IF APPLICATOR IS RUN ON T-TERMINATING UNIT/K-PRESS. GUARD, ITEM 256, REQUIRED IF APPLICATOR IS BEING USED ON G-TERMINATOR.
- $\Delta 9$ TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.



***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.

$\Delta 10$ APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 62.

REF	REF	REF	REF	PART NO	DESCRIPTION	ITEM NO
-	REF	REF	REF	462992-5	GUARD ASSY	257
-	REF	REF	REF	679532-1	INSERT, GUARD	256
-	1	1	1	189728-1	BRACKET, SPACER	255
-	1	1	1	568681-1	SPACER, BASE PLATE	253
-	1	1	1	2119782-1	FINE ADJUST HEAD ASM, PACIFIC STYLE	251
-	-	-	1	2119640-1	PUSH ROD, AIR FEED	250
-	-	-	1	1803259-1	BUSHING, FLANGED	249
-	1	1	1	1-22279-3	SPRING, COMPRESSION	246
-	1	1	1	18023-1	SCR, SKT HD CAP M3 X 5.0	241
-	-	2	-	2168400-6	SHCS, LOW HEAD, RoHS, M5 X 16	240
-	-	-	-	2119580-1	MECHANICAL FEED ASSEMBLY	239
-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)

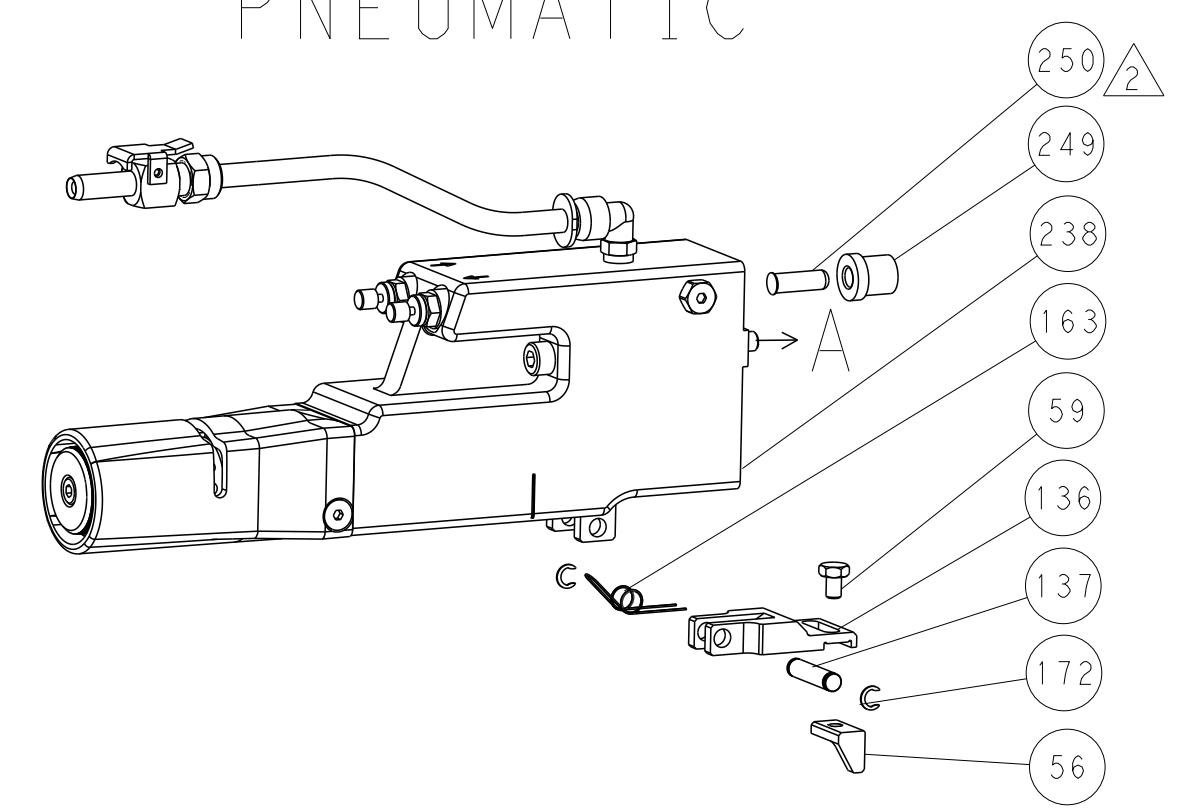
SET UP GAUGE	LOC	DIST	REVISIONS				
2119599-1	A	66	P LTR	DESCRIPTION	DATE	OWN	APVD
			-	SEE SHEET 1	-	-	-

-	-	-	1	2063440-2	AIR FEED MODULE	238	
-	-	1	-	2119740-2	TAG IDENTIFICATION	213	
-	-	1	-	1901094-3	SPACER, FEEDER	198	
-	-	-	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	
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-	-	-	1	2119641-2	FEED CAM, AIR FEED	151	
-	1	1	1	2119798-2	DETENT PIN	145	
-	1	1	1	2079383-8	SCR, BHSC, RoHS (M4 X 16)	144	
-	4	4	4	2168400-5	SHCS, LOW HEAD, RoHS, M4 X 20	143	
-	1	1	1	2-2119656-0	APPLICATOR BASIC ASSEMBLY, SF	141	
-	1	1	1	2119650-1	RAM, ASIAN STYLE, SIDE FEED	140	
$\Delta 6$	-	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	
$\Delta 4$	-	-	REF	-	SEE NOTE 4	MEMORY CHIP, PROGRAMMED	135
-	-	1	-	1633743-1	SERVO FEED LATCH ASM	133	
-	1	1	1	1-22281-8	SPRING, COMPRESSION	121	
-	1	1	1	1-690438-0	FRONT STRIP GUIDE	96	
-	4	4	4	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	95	
-	1	1	1	2168083-6	SCR, SKT HD CAP, RoHS, M5 X 65	93	
-	1	1	1	455888-4	SPACER, CRIMPER	82	
-	1	1	1	240641-6	SPACER	81	
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-	1	1	1	2161332-2	DEPRESSOR, WIRE FUNNEL	70	
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-	2	2	2	2-18032-5	SCR, SET, FLT POINT M5 X 20.0	61	
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-	1	1	1	2119957-1	APPLICATOR SHIM PACK	39	
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-	2	2	2	22281-9	SPRING, COMPRESSION	27	
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$\Delta 14$	-	1	1	462431-1	WIRE FUNNEL	5	
-	1	1	1	238009-3	BLOCK, FL CRIMPER SPACER	4	
$\Delta 1$	1	1	1	464290-1	CRIMPER, SEMI-FLAT 22-18	1	
-77	-27	-25	-22	PART NO	DESCRIPTION	ITEM NO	

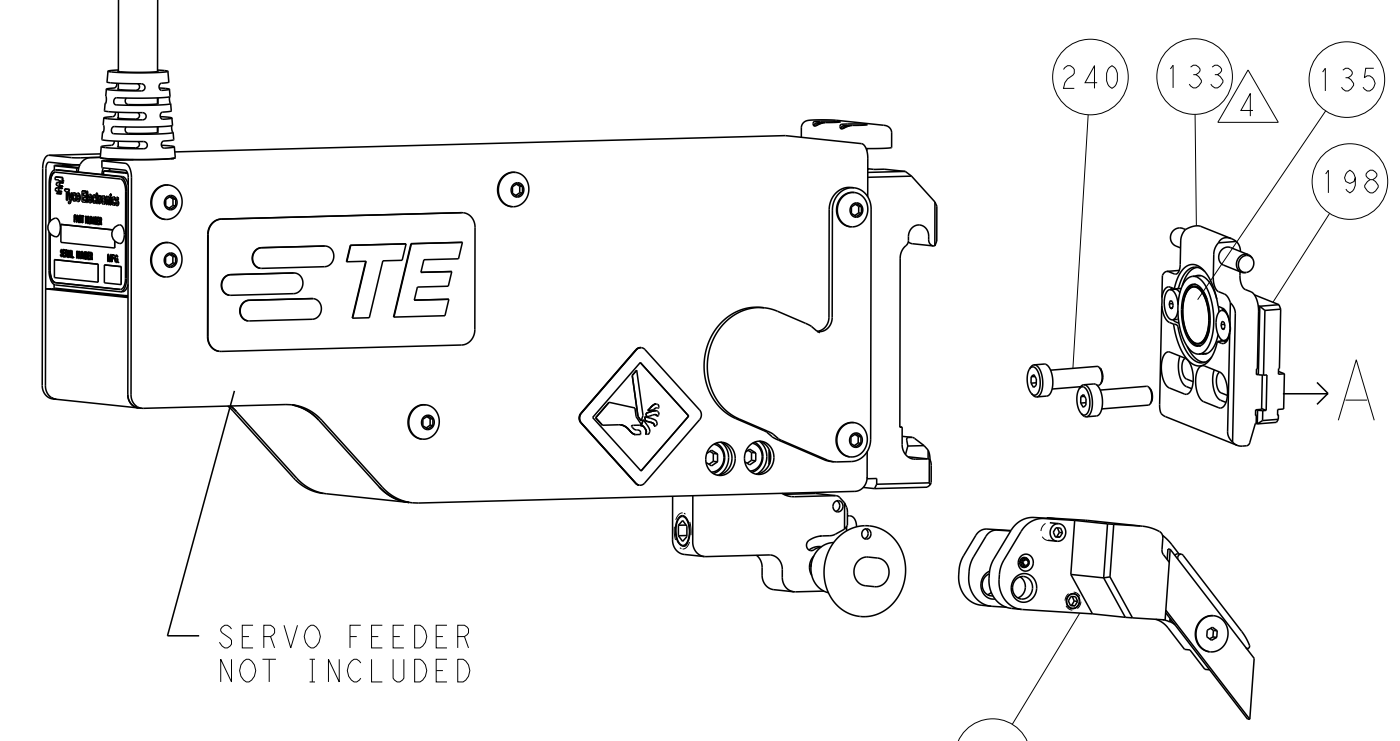
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG		NAME	
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	2 PLC	±		2		G. HOFENER	
	3 PLC	±		3			
	4 PLC	±		4			
	ANGLES	±		APVD	DATE	T. ELBIN	21OCT2011
	FINISH	±		PRODUCT SPEC			
MATERIAL				APPLICATION SPEC			
				WEIGHT			
				SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
				A1	00779	©=2151034	
				Customer Accessible Production Drawing	SCALE	SHEET	3 OF 4
					1:1		REV E

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

FEED TYPE PNEUMATIC

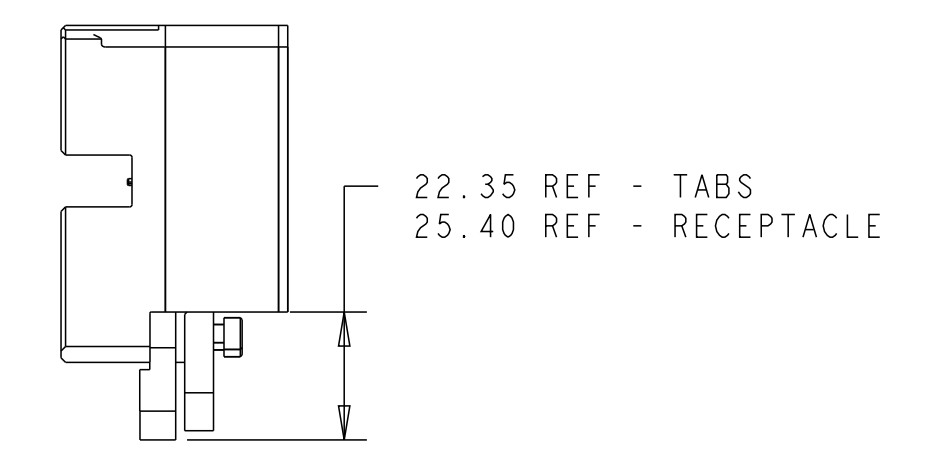
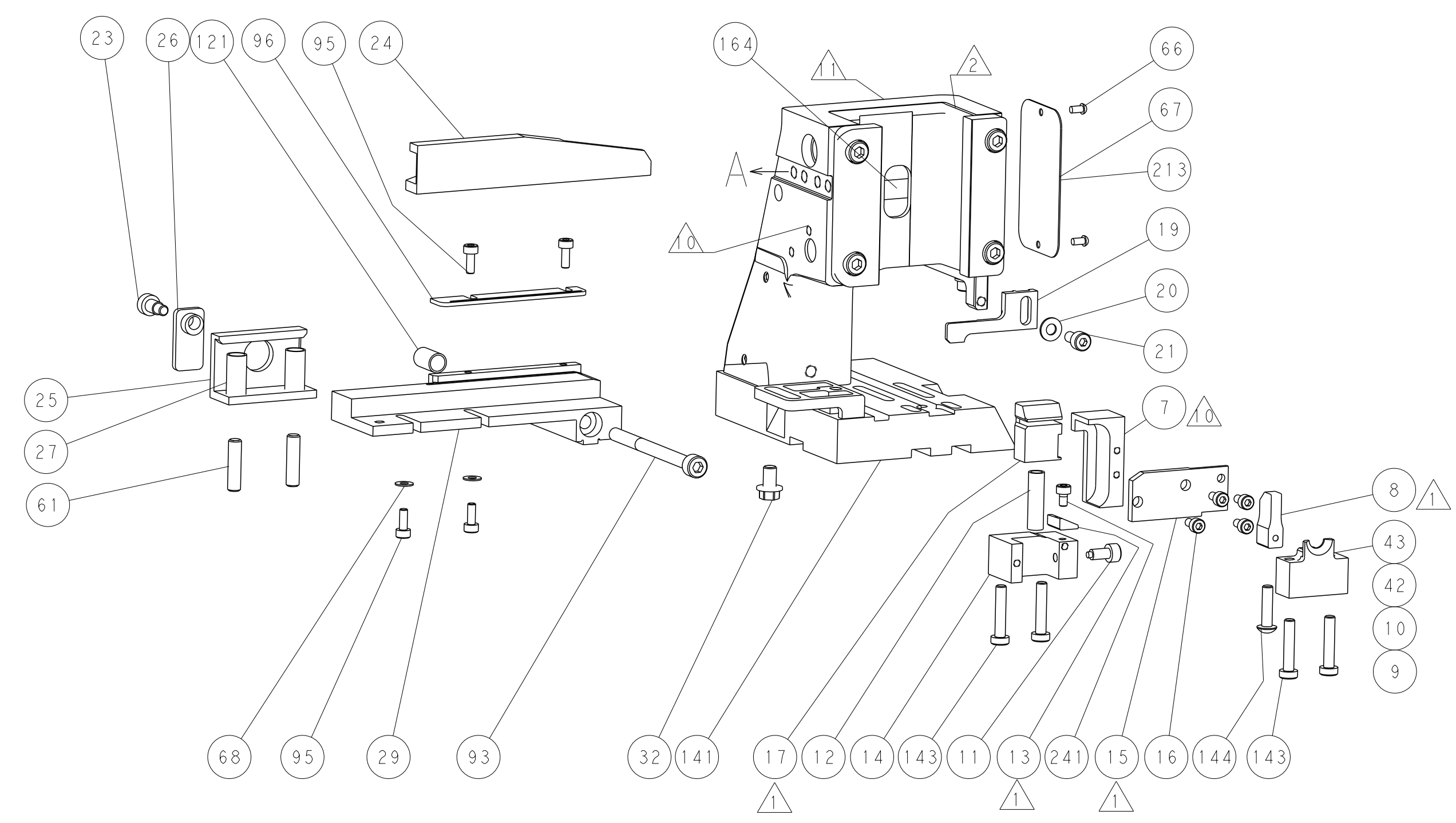
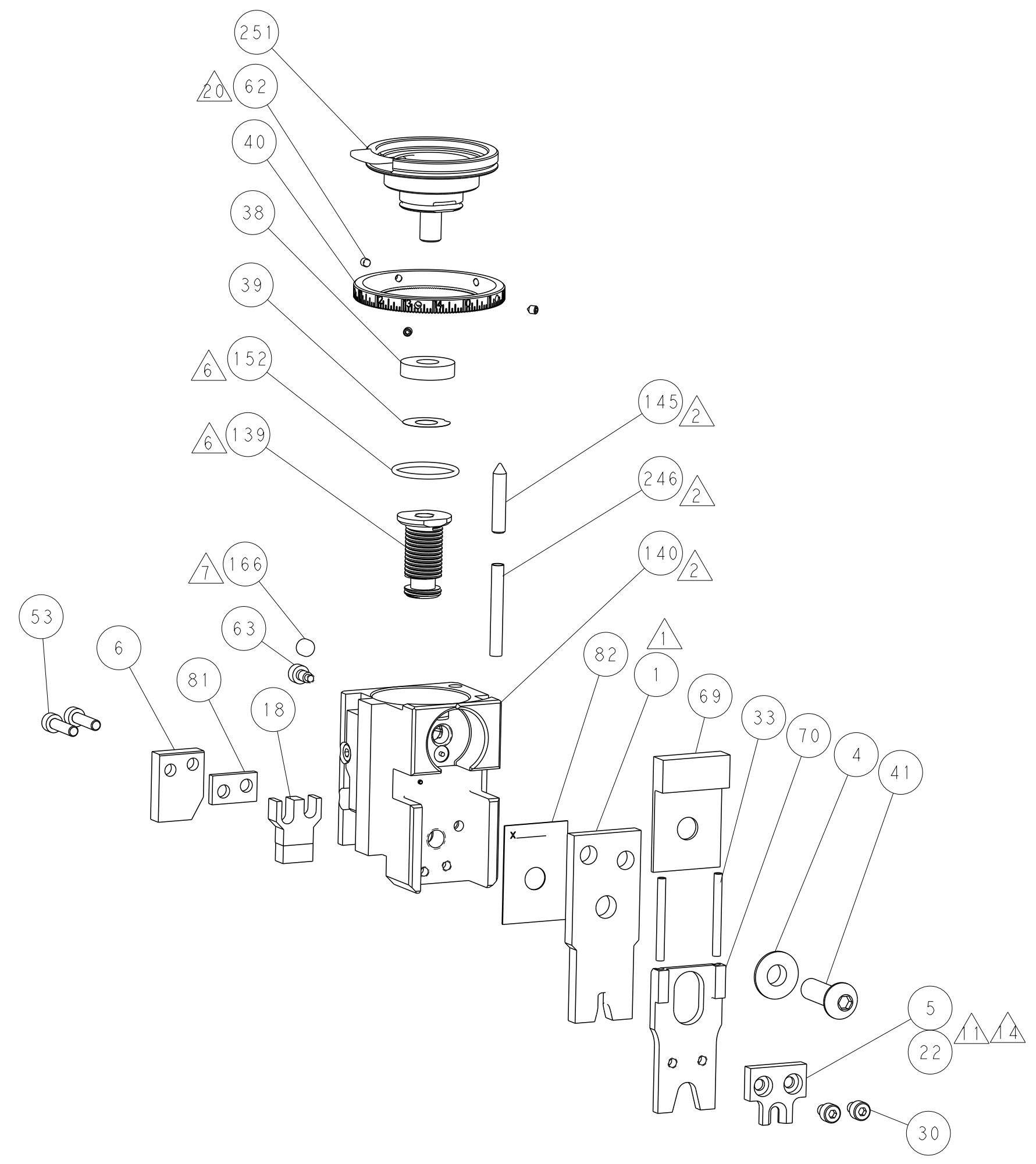
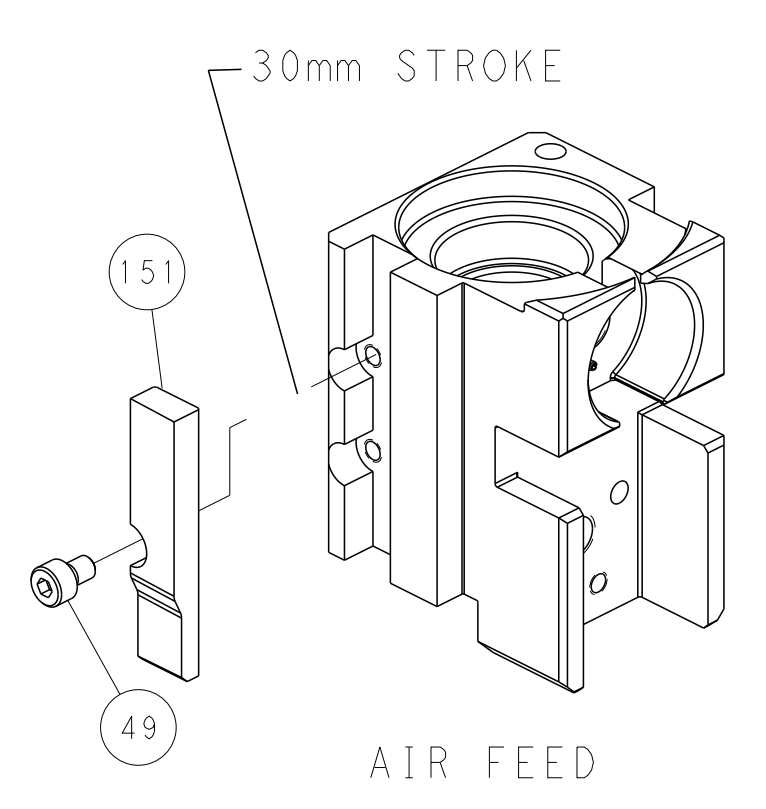


SERVO LATCH PLATE

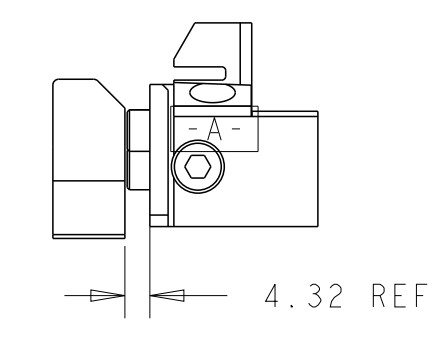


***FEED FINGER REPRESENTATION ABOVE MAY DIFFER FROM ACTUAL FEED FINGER THAT IS REQUIRED BY THIS APPLICATOR

CAM POSITION



HOLDDOWN SET-UP



LOWER TOOLING SET-UP

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: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH	PRODUCT SPEC APPLICATION SPEC SIZE CAGE CODE DRAWING NO A1 00779 C=2151034	RESTRICTED TO Customer Accessible Production Drawing SCALE 1:1 SHEET 4 OF 4 REV E