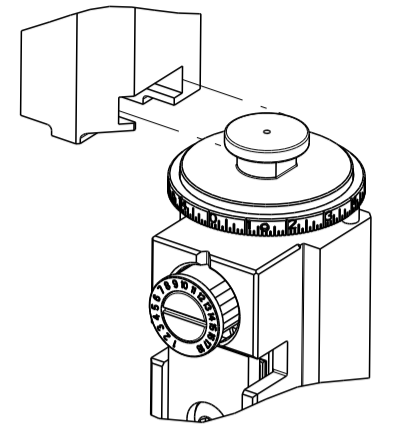


ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART						
					CONVERT TO	PART NUMBERS REQUIRED					
						PNEUMATIC FEED	SERVO LATCH PLATE	SMART APPLICATOR	MECHANICAL FEED	SERVO LATCH PLATE	SMART APPLICATOR
	2836086-1	A	FINE CRIMP HEIGHT ADJUST	MECHANICAL	2119950-1	1338685-1	5-18022-5	2119641-1	2119799-1	2063440-1	
					2119951-1	-	8-2836086-5	1901094-3	-	2168400-6 (QUANTITY 2)	
					2161326-1	-	8-2836086-4	-	-	-	
	2836086-2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	2119949-1	1338685-1	5-18022-5	2119653-1	-	-	
					2119951-1	-	8-2836086-5	1901094-3	-	2168400-6 (QUANTITY 2)	
					2161326-1	-	8-2836086-4	-	-	-	
	2836086-5	A	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE ⁴	2119949-1	1338685-1	5-18022-5	2119653-1	-	-	
					2119950-1	1338685-1	5-18022-5	2119641-1	2119799-1	2063440-1	
	2836086-6	A	NON-CRIMP HEIGHT ADJUST	SERVO LATCH PLATE ⁴ LATCH PLATE ¹²	-	-	-	-	-	-	
	2836086-7	A	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	
	7-2836086-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-	



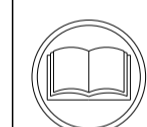
APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.57 mm [.062]	F
INSUL	2.54 mm [.100]	O

APPLICATOR INSTRUCTIONS
408-10389

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: 1.6 CIRCULAR CONTACT			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
3.90-4.70 mm [.154-.185 1N]			
TERMINAL APPLICATION SPECIFICATION	114-20121 Rev A		

TERMINALS APPLIED				
TE TERMINAL	TE TERMINAL	TE SEAL	TE SEAL	CABLE DIAMETER
1437709-3	1-1437709-1	1-1437713-1		∅ 1.15-1.40
1437709-6	1-1437709-4			
1437709-9				

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
FLR 0.35 mm ²	1.03+/-0.03 [.041+/-0.001]	8.2
FLR 0.3 mm ²	1.00+/-0.03 [.039+/-0.001]	8.7
FLR 0.22 mm ²	0.95+/-0.03 [.037+/-0.001]	9.1



- 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: 8-2836086-4
 - PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2836086-4
 - SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2836086-5
 - SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2836086-6
- 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. APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 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 4.77.
- 13 THIS APPLICATOR APPLIES TERMINAL WITH A SEAL.
- 14 APPLY TORO-SEAL IN ALLEN SOCKET TO FILL HOLE AFTER FLAT HD HAS BEEN ADJUSTED TO CORRECT HEIGHT AT QUALIFICATION. APPLY #1-23419-5 LOC-TITE TO THREADS.

15 CUT TO LENGTH AT ASSEMBLY

***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.

ITEM NO	DESCRIPTION	ITEM NO
-77	-7 -6 -5 -2 -1 PART NO	286
12	DEPRESSOR, WIRE	260
12	APPLICATOR SHIM PACK	252
12	O-RING, .676 ID, .070 DIA. MAT.	250
12	PUSH ROD, AIR FEED	

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	10FEB2016	MR	GB

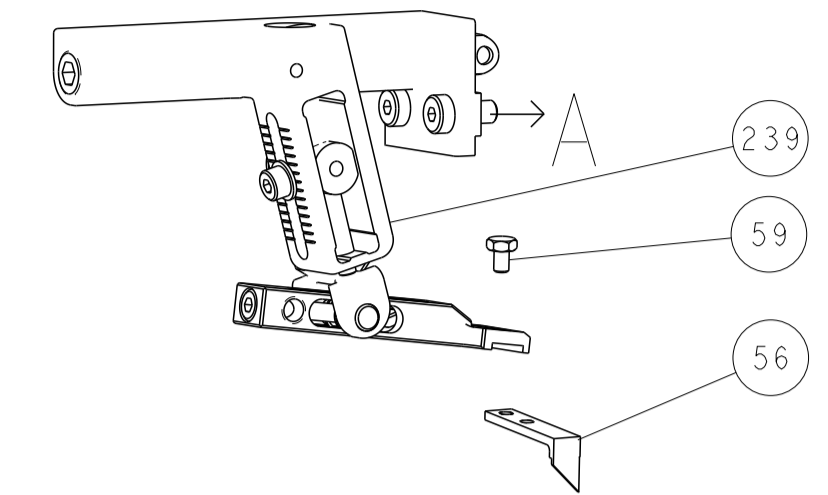
-	-	-	-	1	-	2079988-1	BUSHING, LCH5-12, MISUMI	249
-	-	-	-	1	-	2119641-1	FEED CAM, AIR FEED	248
-	1	-	-	1	1	2119798-1	DETENT PIN	247
-	1	-	-	1	1	1-22279-3	SPRING, COMPRESSION	246
-	-	1	-	-	-	2119758-1	RAM, AMP STYLE, SIDE FEED, NON-ADJ.	245
-	1	1	1	1	1	2119082-3	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
6	-	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
-	-	-	-	2	-	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172
8	-	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
-	-	REF	REF	-	-	2119944-1	FEED FINGER ASSEMBLY, SF	117
-	1	1	1	1	1	455888-7	SPACER, CRIMPER	82
-	1	1	1	1	1	2119956-1	DOCUMENTATION PACKAGE	71
-	1	1	1	1	1	1-2119791-7	DEPRESSOR, WIRE	70
-	1	-	-	1	1	2119740-1	TAG, IDENTIFICATION	67
-	2	2	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
6	-	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
4	-	1	1	1	1	985575-3	SCR, FLT SKT HD CAP M3 X 10.0	57
-	-	-	-	1	1	1338685-1	PAWL, FEED	56
3	-	4	4	4	4	2168400-1	SHCS, LOW HEAD, RoHS, M4 X 12	54
-	2	2	2	2	2	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	53
-	1	1	1	1	1	5018030-1	NUT, HEX, REG, RoHS, M3	52
-	1	1	1	1	1	811242-5	BUMPER, HOLD DOWN	51
-	1	1	1	1	1	690753-2	SPACER, TONKER	50
-	-	-	-	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	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	2119645-1	DISC, NUMBERED FA WIRE ADJUSTMENT	40
-	1	-	-	1	1	2119957-1	APPLICATOR SHIM PACK	39
-	1	1	1	1	1	2119644-1	RAM WASHER, PRECISION	38
6	-	1	1	1	1	2119085-1	FA HEAD, ATLANTIC STYLE	37
7	-	1	-	1	1	2119092-1	BOLT, ADJUSTMENT	35
-	1	1	1	1	1	3-1752356-3	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	1-1320908-5	SPACER, STRIP GUIDE	30
-	1	1	1	1	1	2119959-2	ASSEMBLY, STRIP GUIDE	29
-	1	1	1	1	1	455888-3	SPACER, CRIMPER	28
-	1	1	1	1	1	1320928-1	STRIP GUIDE	24
-	1	1	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
-	2	2	2	2	2	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	318707-1	FLOATING SHEAR, FRONT	9
1	1	1	1	1	1	4-1633918-1	ANVIL, COMBINATION	8
-	-	-	-	-	-	-	-	7
-	-	-	-	-	-	-	-	6
-	1	1	1	1	1	2119781-1	DEPRESSOR, SHEAR	5
-	1	1	1	1	1	2-238011-2	BLOCK, CRIMPER SPACER	4
1	1	1	1	1	1	7-1633966-0	CRIMPER, INSULATION O	3
-	1	1	1	1	1	455888-5	SPACER, CRIMPER	2
1	1	1	1	1	1	2-456403-6	CRIMPER, WIRE PREMIUM	1
-77	-7	-6	-5	-2	-1	PART NO	DESCRIPTION	ITEM NO

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		OWN: J. HOU 26OCT2015	TE Connectivity Harrisburg, PA 17105-3608
mm	0 PLC ±	1 PLC ±	2 PLC ±	CHK: L. ZHANG 26OCT2015	
	3 PLC ±	4 PLC ±	5 PLC ±	APVD: J. GUO 26OCT2015	
MATERIAL:	ANGLES ±	FINISH ±	NAME: Ocean Side Feed Applicator	SIZE: A1	
WEIGHT:	SCALE: 1:2	SHEET: 1 OF 4	REV: A	RESTRICTED TO:	

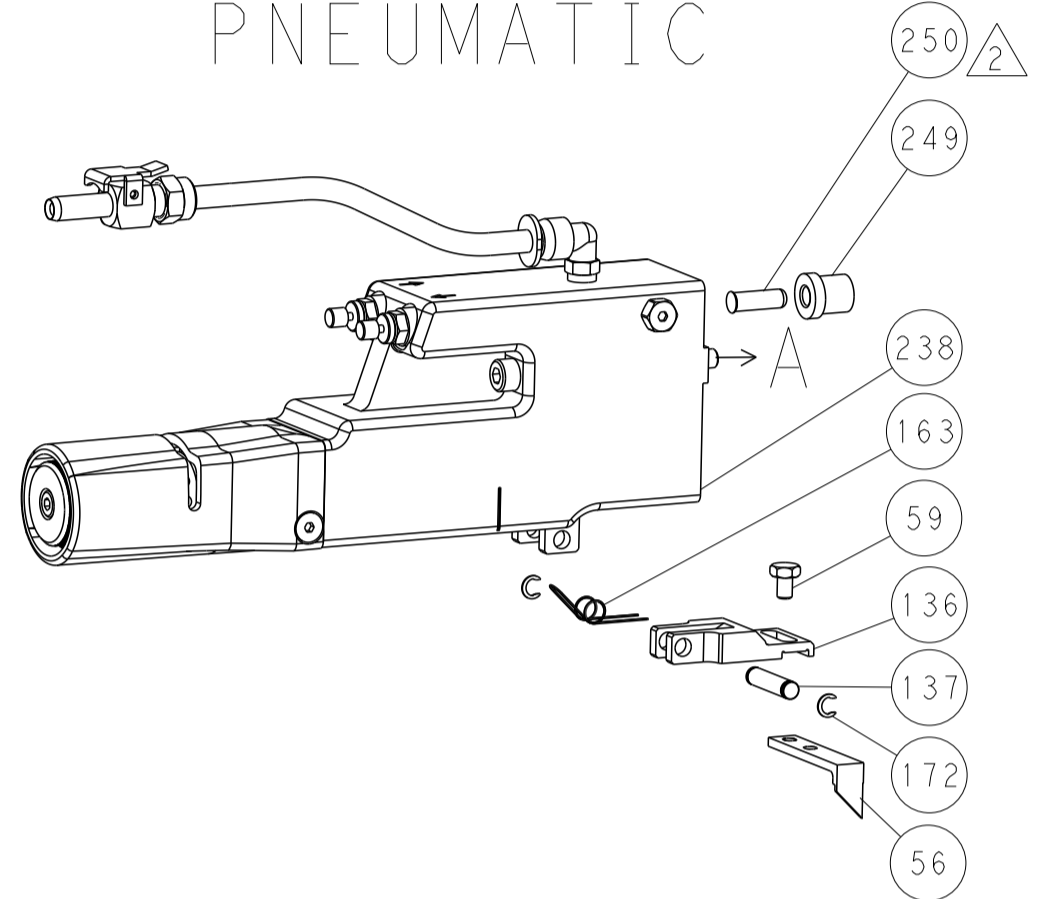
Customer Accessible Production Drawing

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

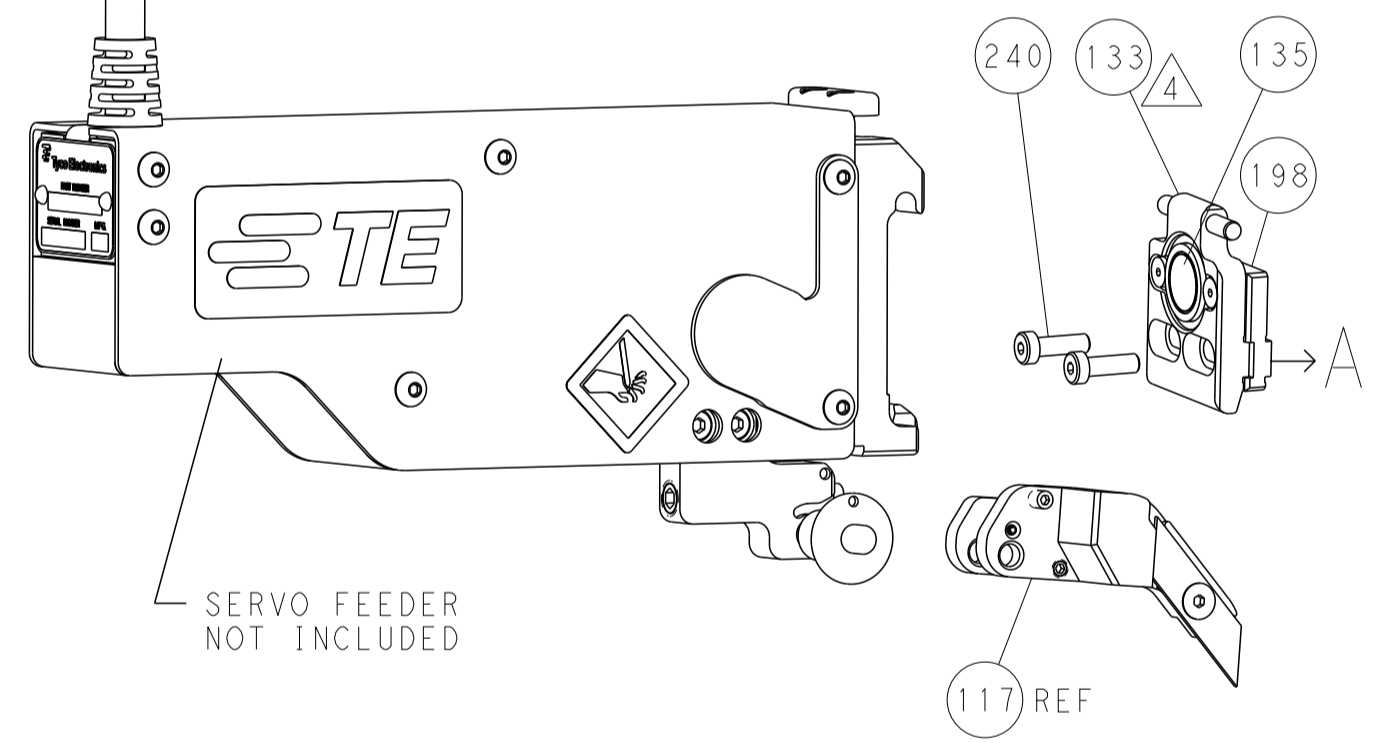
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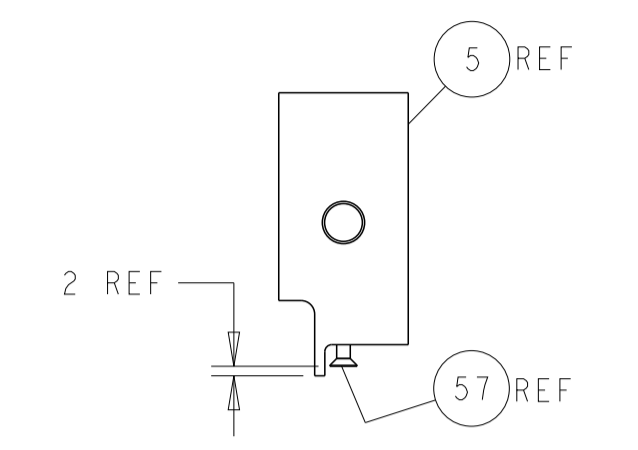
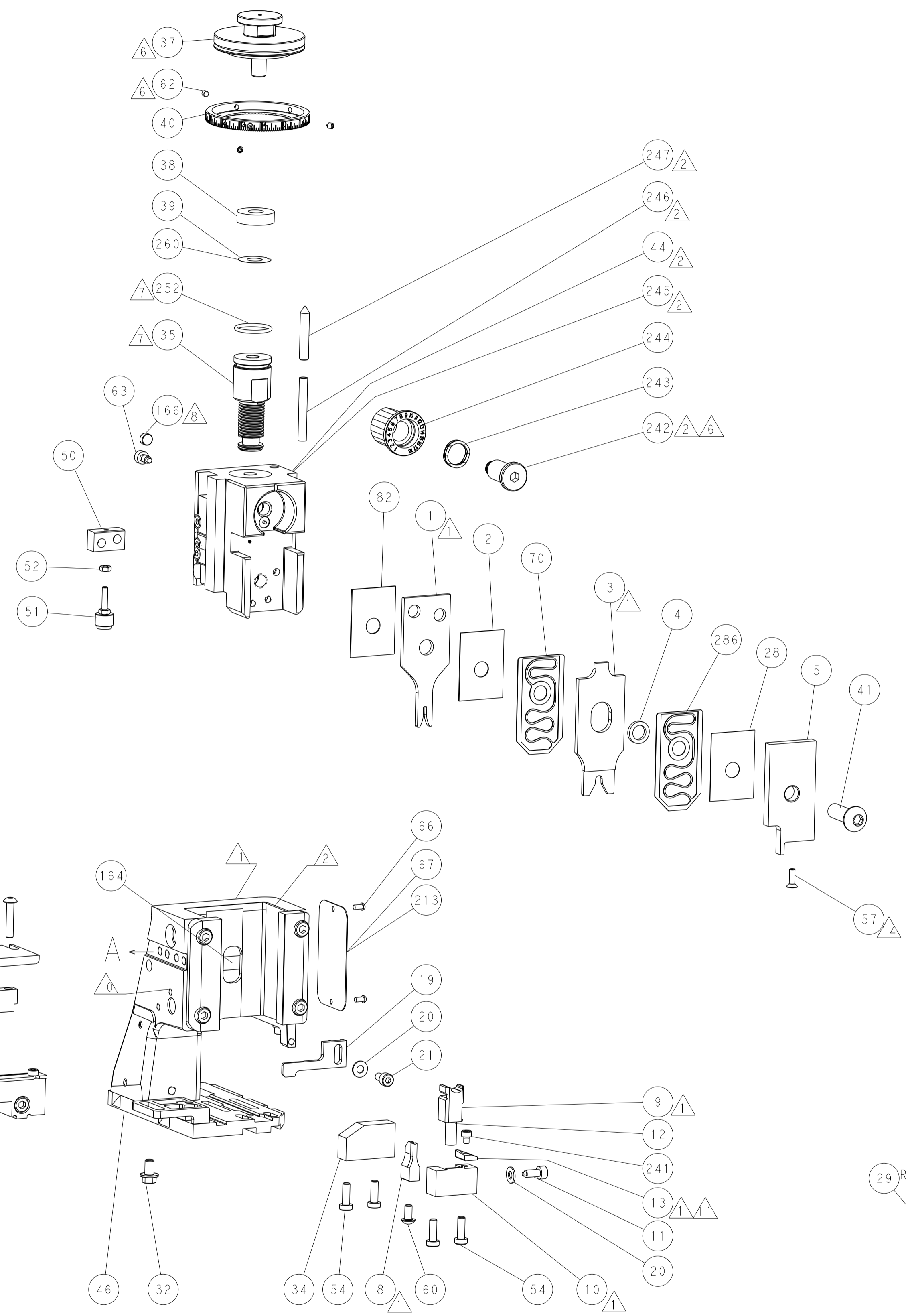
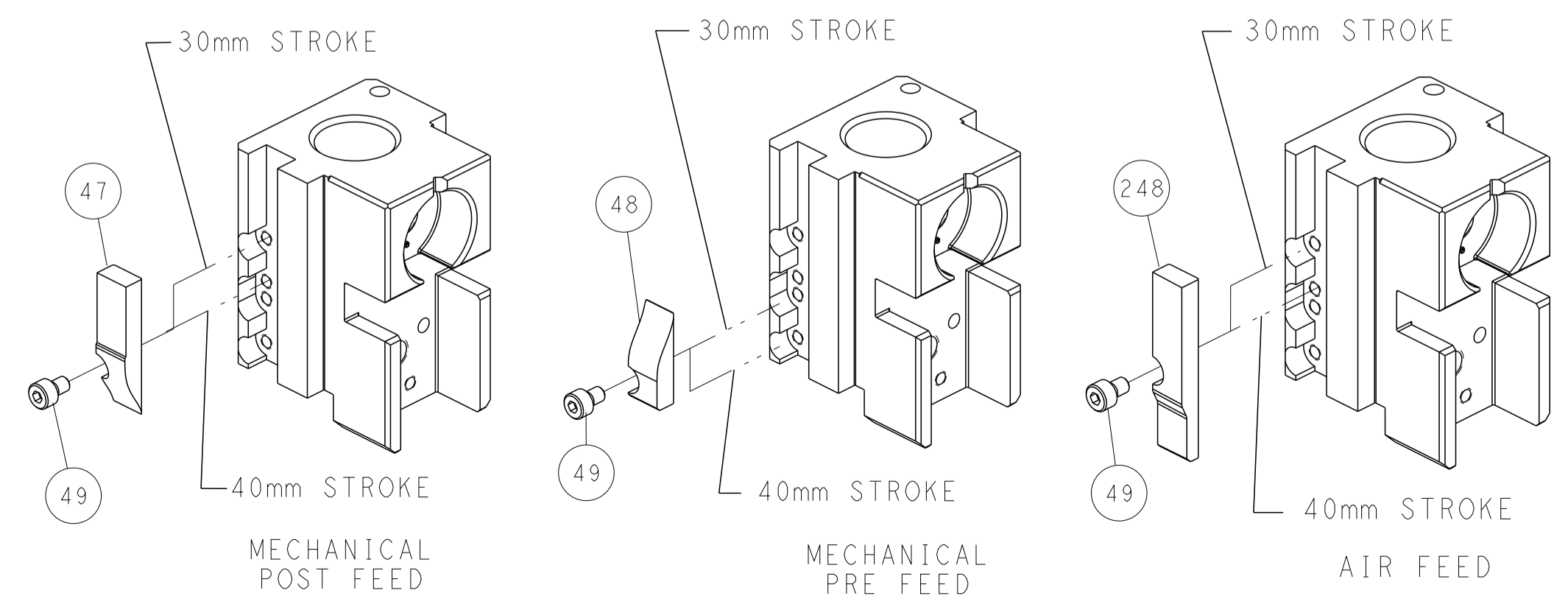
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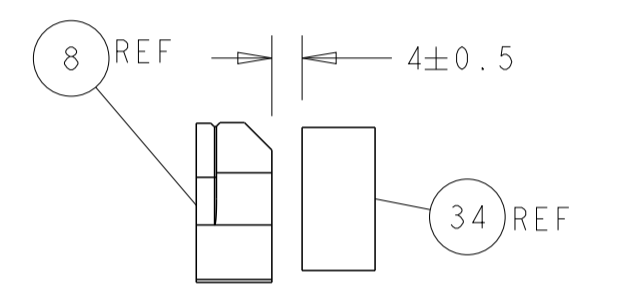
SERVO LATCH PLATE



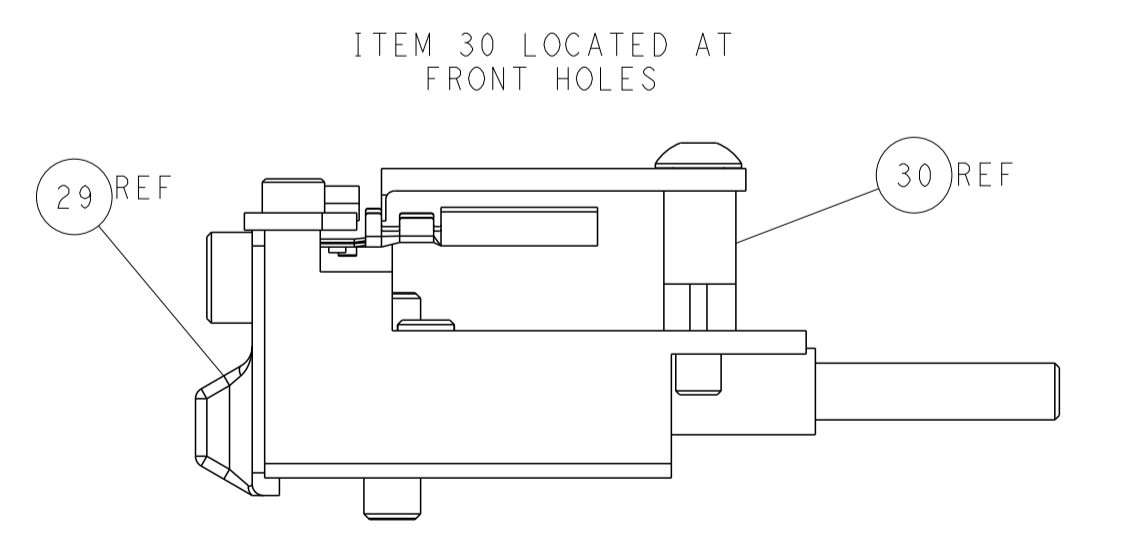
CAM POSITIONS



SHEAR DEPRESSOR DETAIL



TERMINAL SUPPORT LOCATION



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: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH		DWN J. HOU 26OCT2015 CHK L. ZHANG 26OCT2015 APVD H. GUO 26OCT2015 PRODUCT SPEC APPLICATION SPEC WEIGHT Customer Accessible Production Drawing		NAME Ocean Side Feed Applicator SIZE CAGE CODE DRAWING NO. A1 00779 C=2836086 SCALE 1:2 SHEET 2 OF 4 REV A		TE Connectivity Harrisburg, PA 17105-3608 RESTRICTED TO	
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Table with columns: PART NUMBER, REVISION, DESCRIPTION, FEED TYPE, CONVERT TO, PART NUMBERS REQUIRED. Includes a diagram of the Pacific Version Terminator Interface Adapter.

APPLICATOR DATA table with columns: CRIMP SIZE, WIRE, INSUL, APPLICATOR INSTRUCTIONS.

Terminal Data and Terminals Applied tables. Includes 'TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION' and 'TERMINALS APPLIED'.

Table with columns: WIRE SIZE, CRIMP HEIGHT mm [INCH], CRIMP HEIGHT REFERENCE SETTING.

- 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...

*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.

Table with columns: PART NO, DESCRIPTION, ITEM NO. Includes items 286 and 251.

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

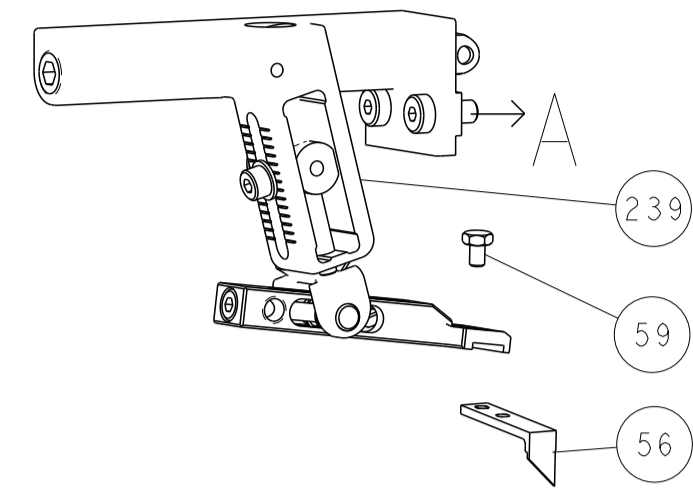
Table with columns: SET UP GAUGE, LOC, DIST, REVISIONS. Includes 'SEE SHEET 1'.

Large table with columns: P, LTM, DESCRIPTION, DATE, QTY, APVD. Lists various parts and their quantities.

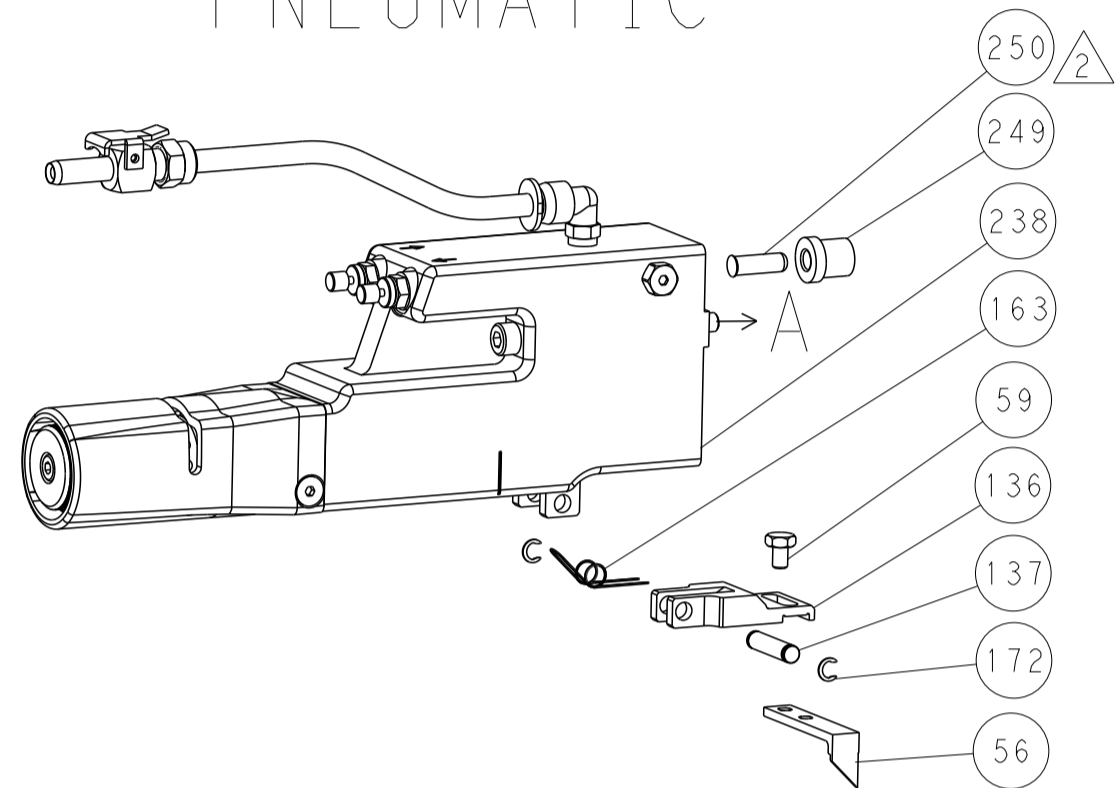
STE logo and technical drawing information including dimensions, tolerances, material, and drawing number.

LOC	DIST	REV	DATE	BY	APPV
A	66				
		DESCRIPTION	DATE	BY	APPV
		SEE SHEET 1			

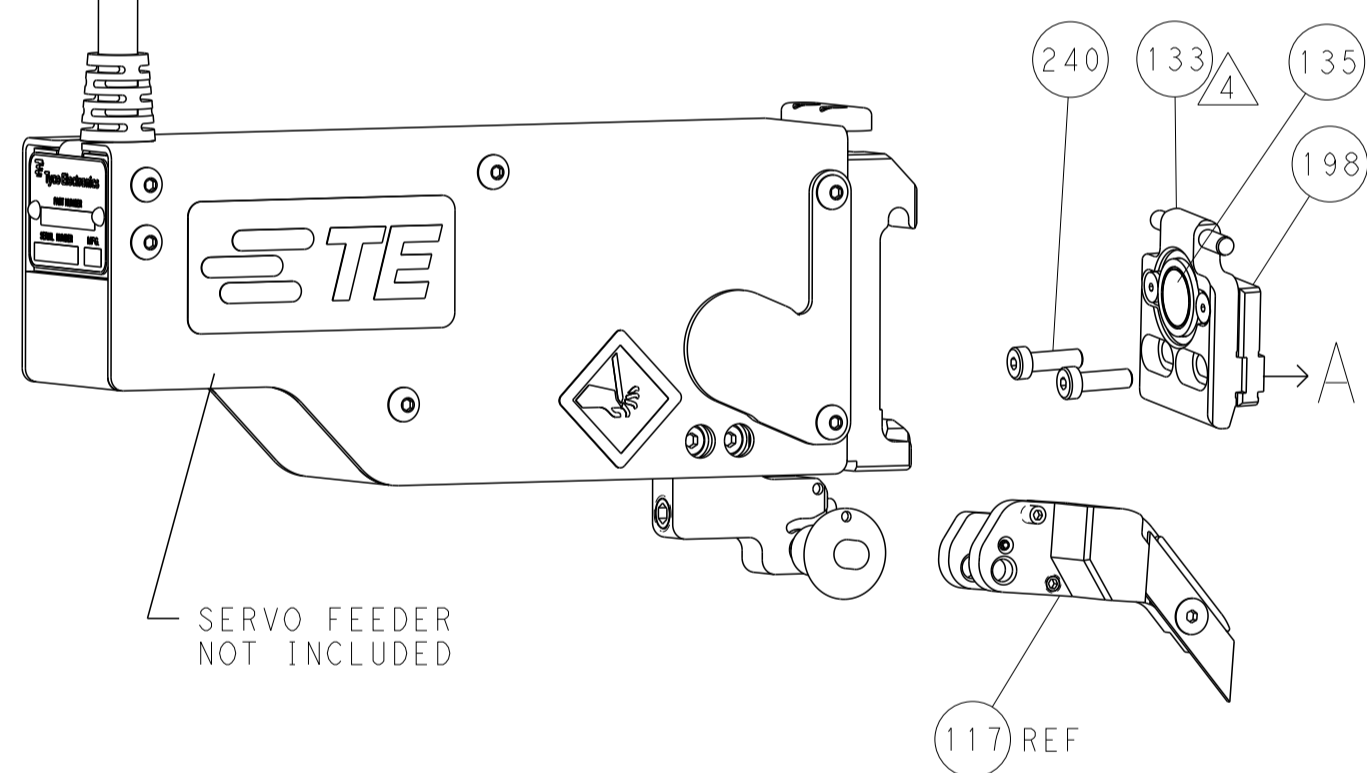
FEED TYPE MECHANICAL



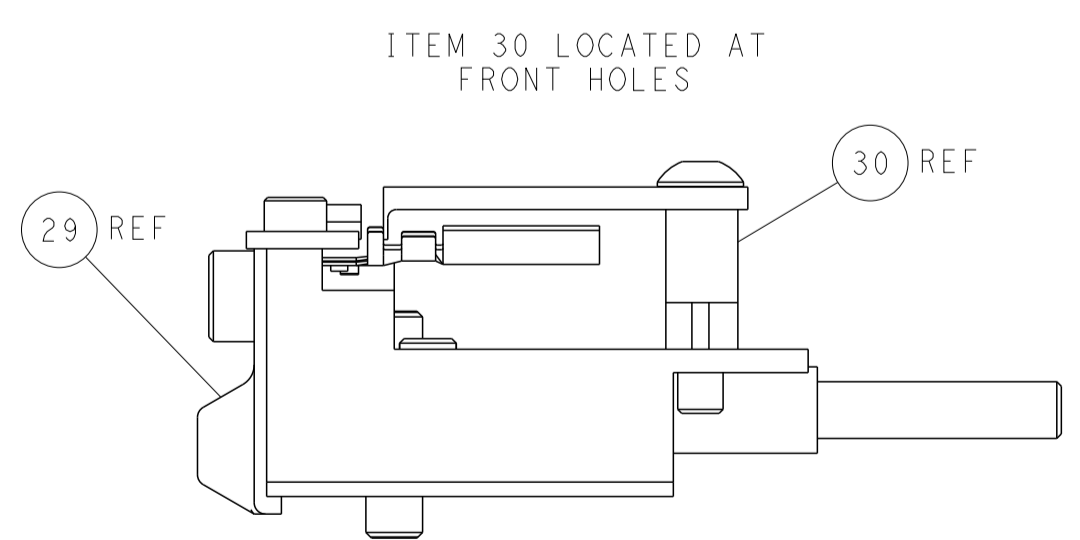
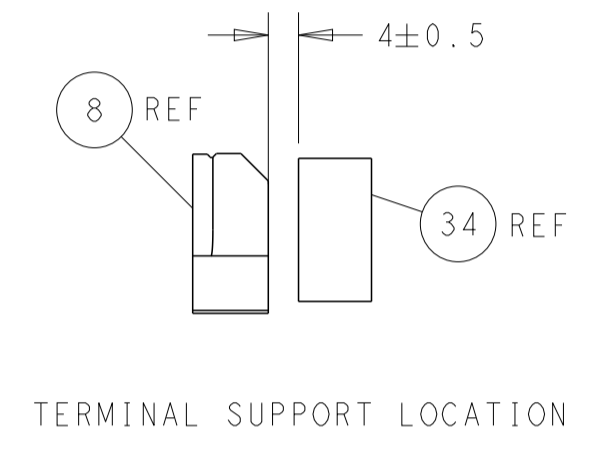
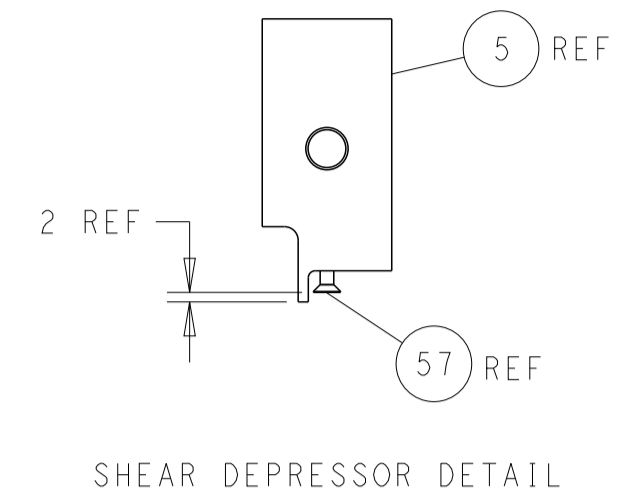
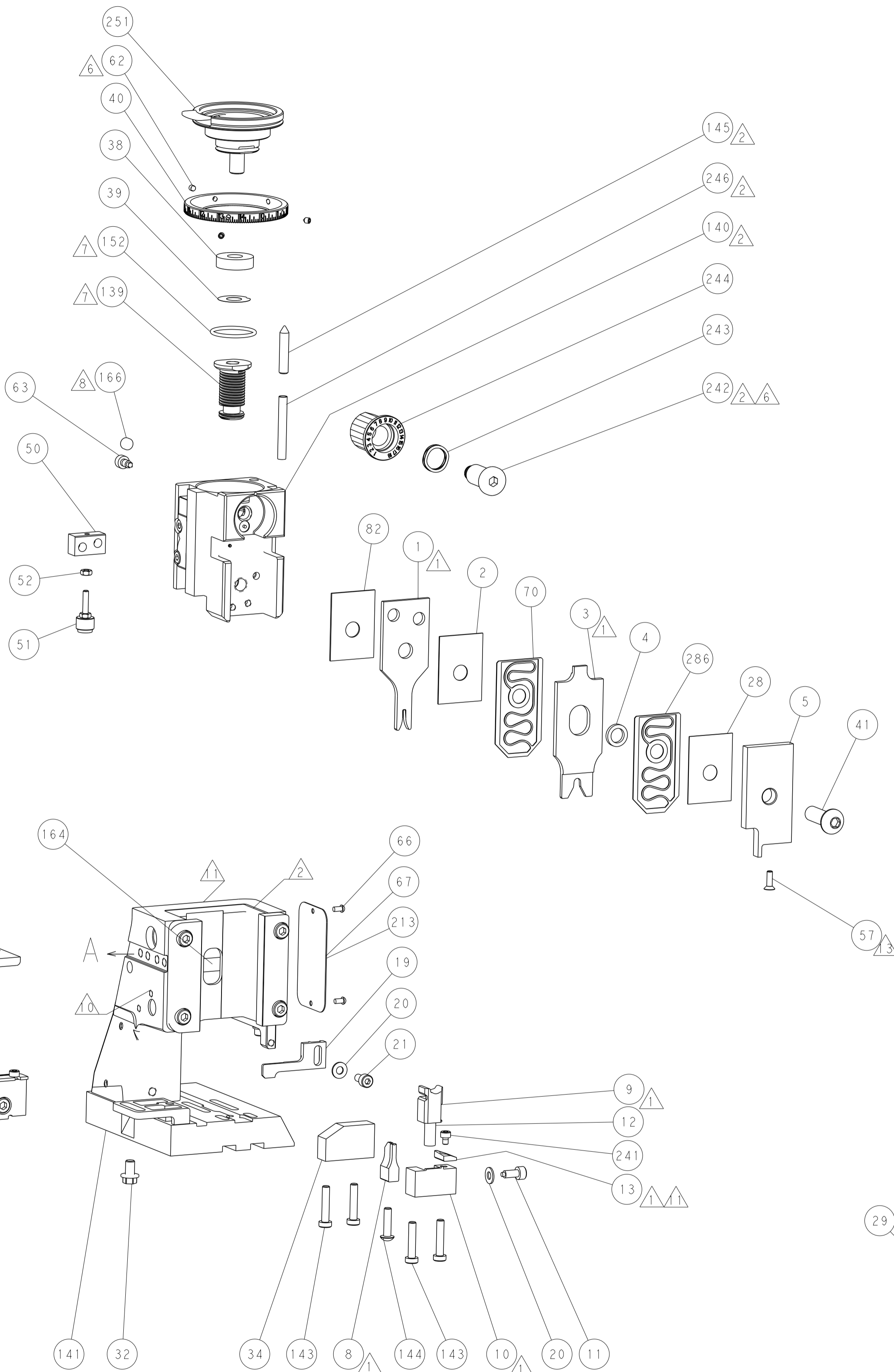
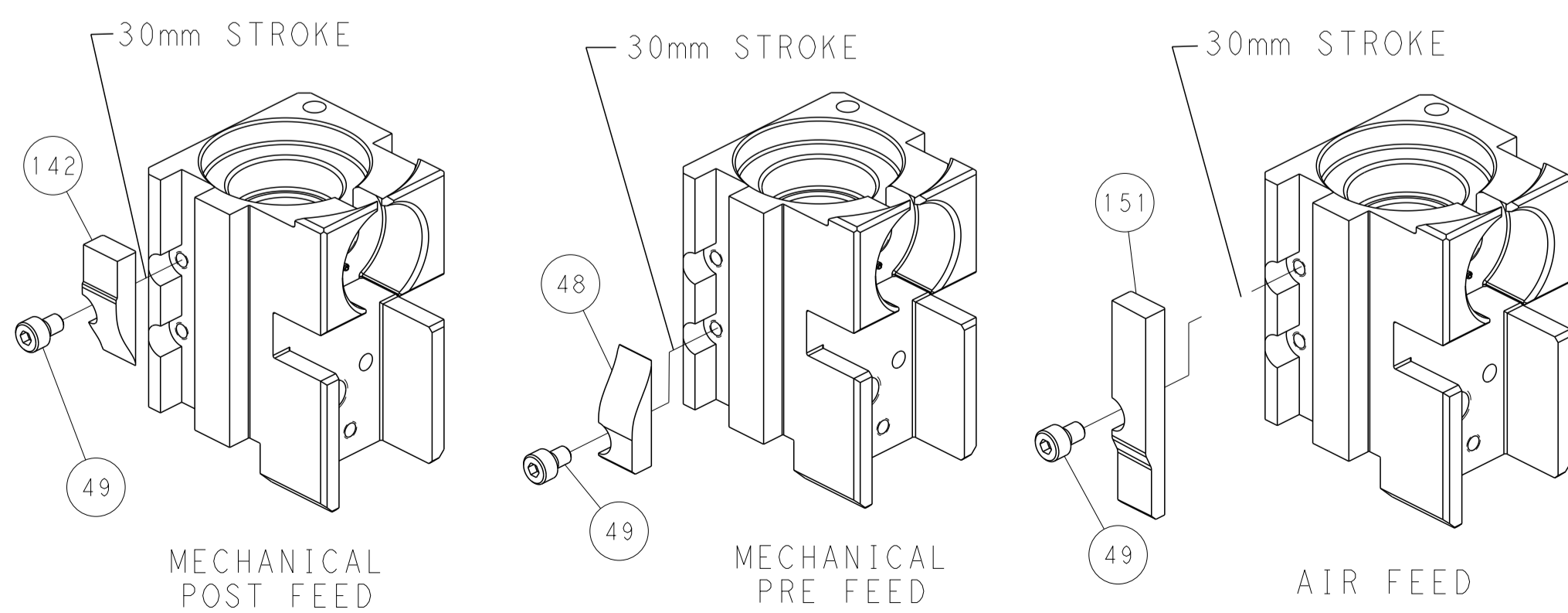
PNEUMATIC



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:		DWG: J. HOU 26OCT2015		REV: L. ZHANG 26OCT2015		NAME: Ocean Side Feed Applicator	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	5 PLC ±	6 PLC ±	SIZE: A1	CAGE CODE: 00779
MATERIAL:	FINISH:	WEIGHT:	SCALE: 1:2	SHEET: 4	OF: 4	REV: A	RESTRICTED TO		