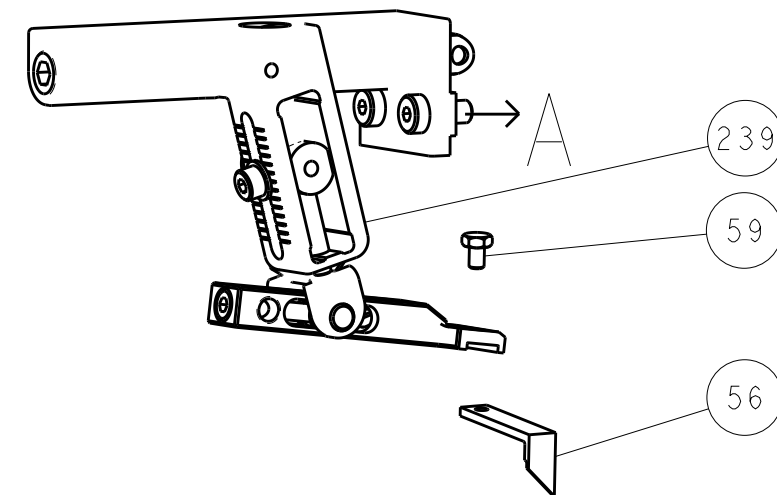
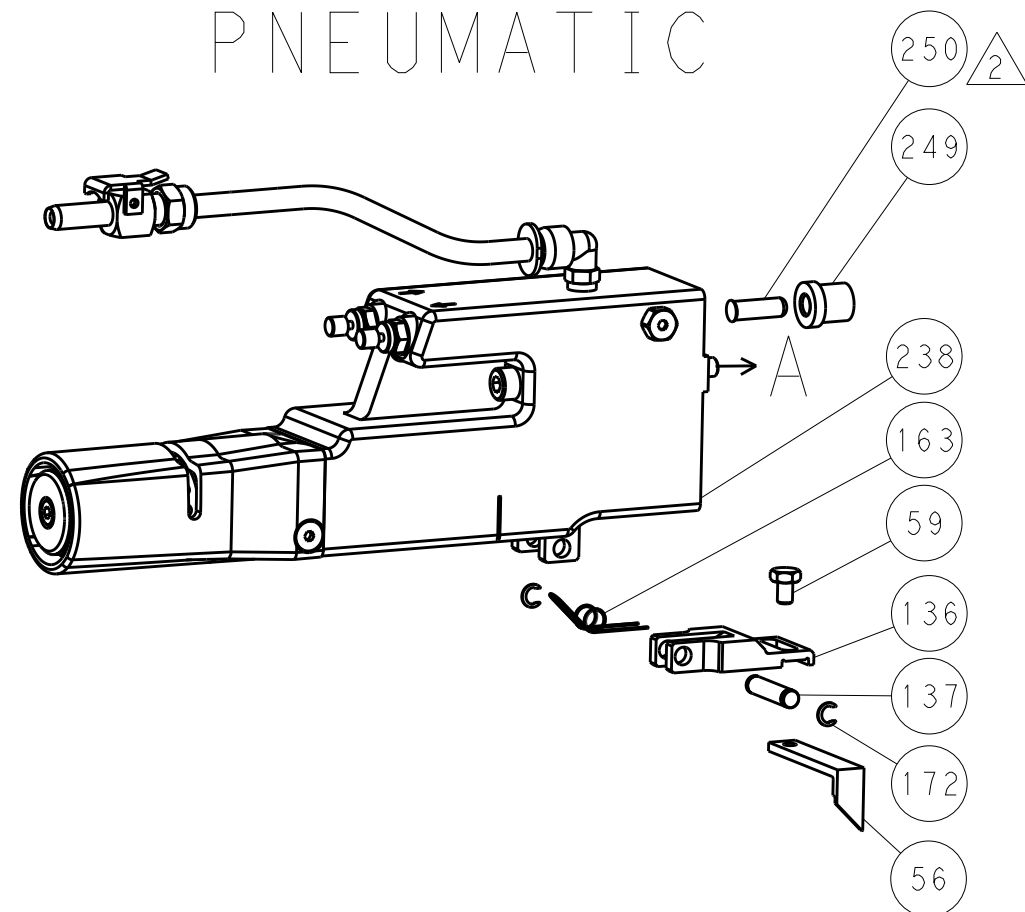


LOC	DIST	REVISIONS					
		P	LTR	DESCRIPTION	DATE	DWN	APVD
A	66	-	-	SEE SHEET 1	-	-	-

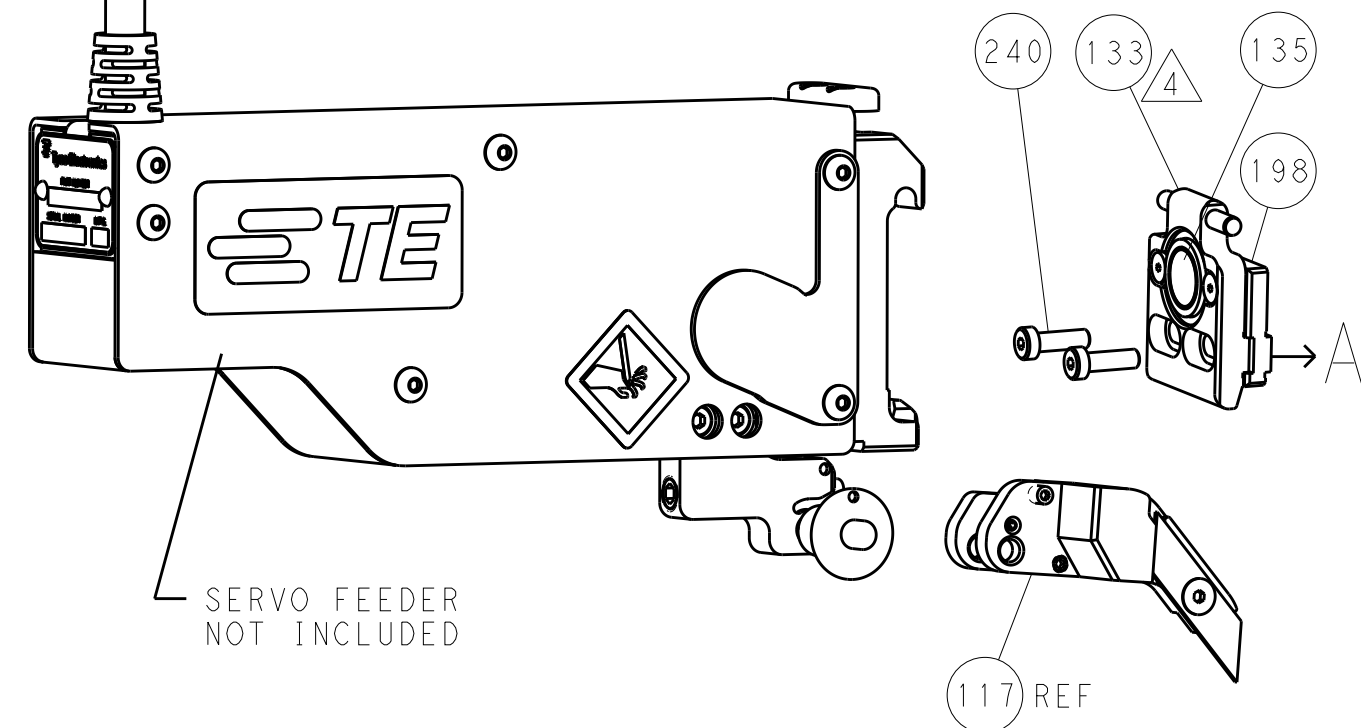
FEED TYPE
MECHANICAL



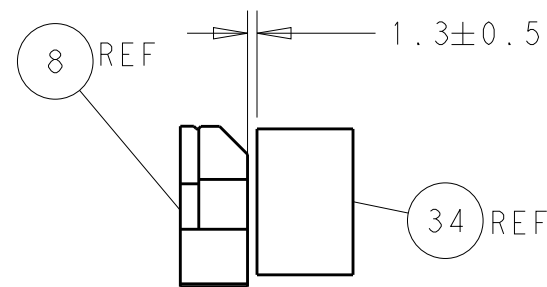
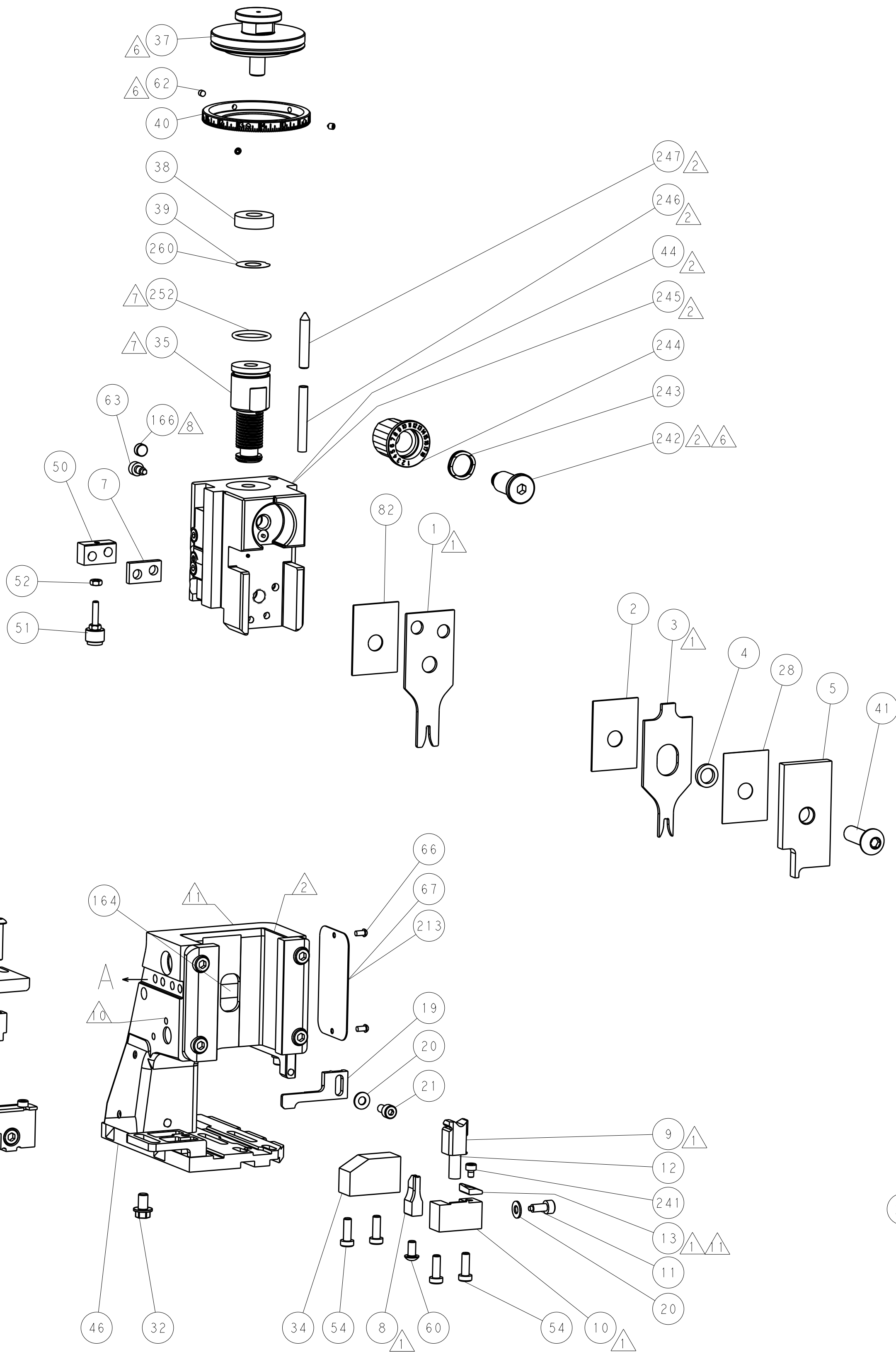
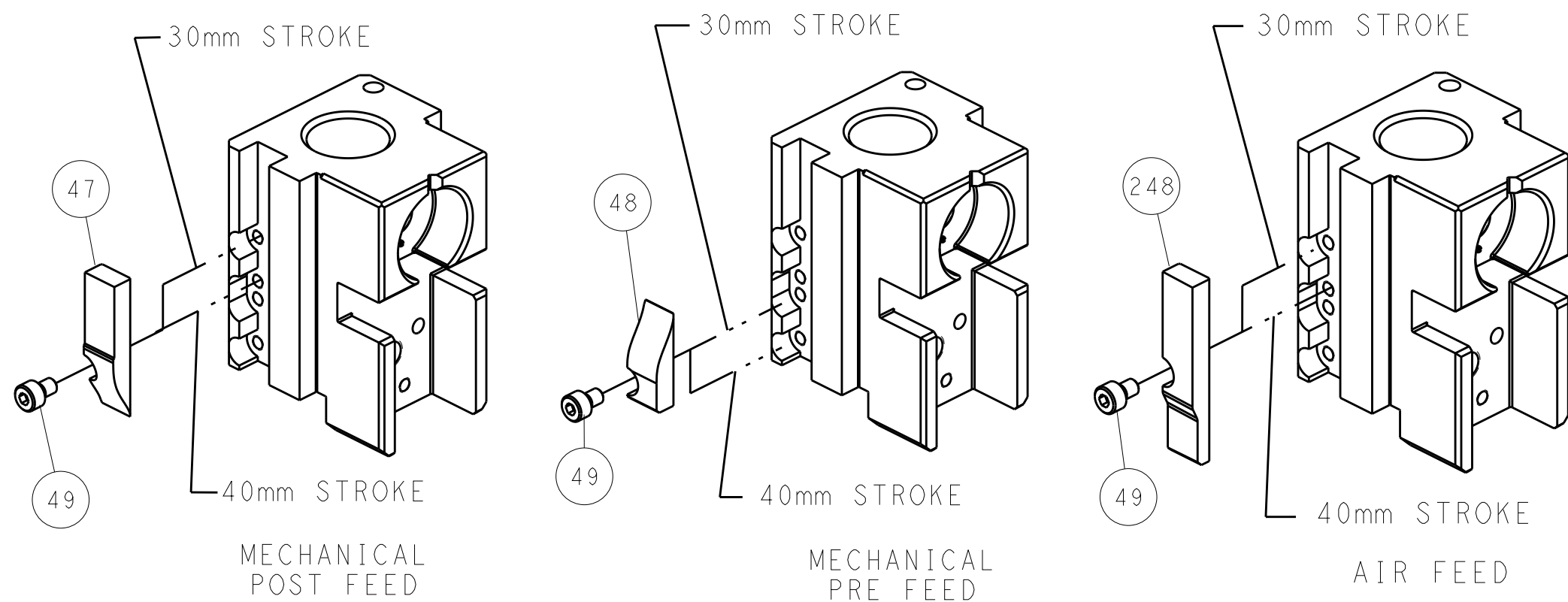
PNEUMATIC



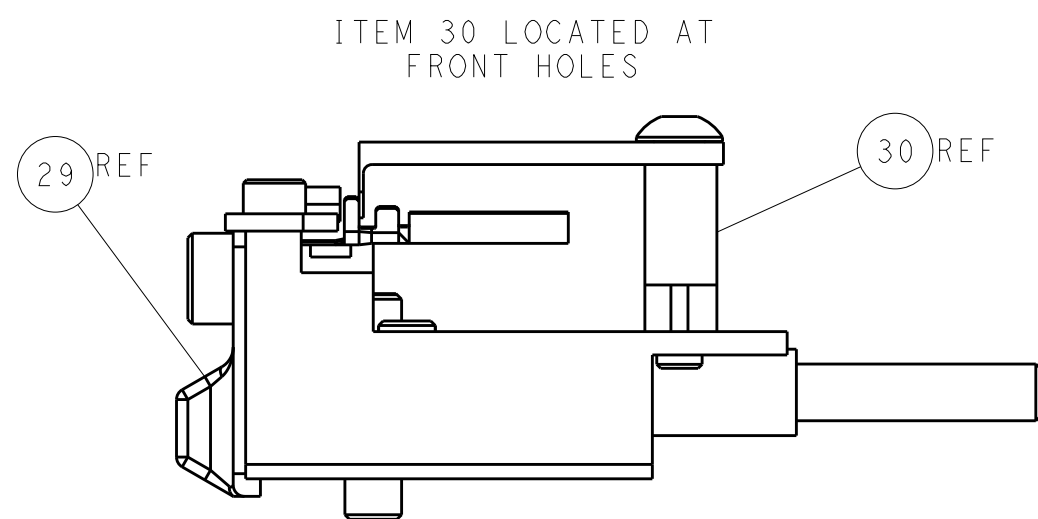
SERVO
LATCH PLATE



CAM POSITIONS



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)

THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. ANY CHANGES TO THIS DRAWING SHOULD BE CONTACTED FOR THE LATEST VERSION.				DWN: M. ZHAO 28JUN2016 CHK: K. ZHANG 28JUN2016 APVD: K. ZHANG 28JUN2016				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			
MATERIAL: -				WEIGHT: -				SIZE: A1 00779 C=2836367			
Customer Accessible Production Drawing				SCALE: 1:2				SHEET 2 OF 4 REV A			

8

7

6

5

4

3

2

1

THIS DRAWING IS UNPUBLISHED.

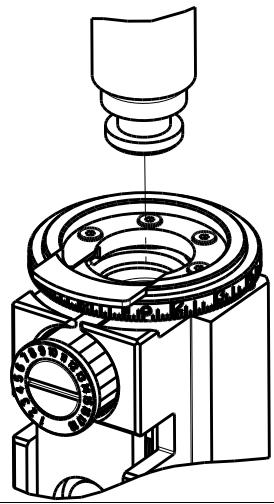
RELEASED FOR PUBLICATION

20

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PACIFIC VERSION
TERMINATOR
INTERFACE ADAPTER



PART
NUMBER

2-2836367-1

REVISION

A

DESCRIPTION

FINE CRIMP HEIGHT ADJUST

FEED TYPE

MECHANICAL

CONVERT TO

PNEUMATIC FEED

PART NUMBERS REQUIRED

2119950-1

1338683-8

5-18022-5

2119641-2

2119799-1

2063440-1

CONVERT TO

SERVO LATCH PLATE

PART NUMBERS REQUIRED

2119951-1

-

8-2836367-5

1901094-3

-

2168400-6 (QUANTITY 2)

CONVERT TO

SMART APPLICATOR

PART NUMBERS REQUIRED

2161326-1

-

8-2836367-4

-

-

CONVERT TO

MECHANICAL FEED

PART NUMBERS REQUIRED

2119949-1

1338683-8

5-18022-5

2119653-2

-

-

CONVERT TO

SERVO LATCH PLATE

PART NUMBERS REQUIRED

2119951-1

-

8-2836367-5

1901094-3

-

2168400-6 (QUANTITY 2)

CONVERT TO

SMART APPLICATOR

PART NUMBERS REQUIRED

2161326-1

-

8-2836367-4

-

-

CONVERT TO

MECHANICAL FEED

PART NUMBERS REQUIRED

2119949-1

1338683-8

5-18022-5

2119653-2

-

-

CONVERT TO

PNEUMATIC FEED

PART NUMBERS REQUIRED

2119950-1

1338683-8

5-18022-5

2119641-2

2119799-1

2063440-1

CONVERT TO

-

PART NUMBERS REQUIRED

-

-

-

-

-

CONVERT TO

-

PART NUMBERS REQUIRED

-

-

-

-

-

CRIMP

SIZE

TYPE

WIRE

2.03 mm [.080]

F

INSUL

2.92 mm [.115]

F

APPLICATOR INSTRUCTIONS

408-10389



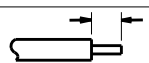
TERMINAL DATA: HONGXING TERMINAL

TE CRIMP SPECIFICATION

TERMINAL NAME: RECEPTACLE HOUSING

WIRE STRIP LENGTH

2.75-3.52 mm [.108-.138 IN]



INSULATION DIAMETER RANGE

Ø1.70-3.00 mm [.067-.118 IN]

TERMINAL APPLICATION SPECIFICATION

NONE

-

-

-

-

-

-

TERMINALS APPLIED



TE TERMINAL

HONGXING TERMINAL

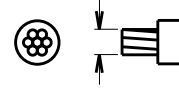
TE TERMINAL

HONGXING TERMINAL

2303613-1

HX45005-21RT

WIRE SIZE



CRIMP HEIGHT mm [INCH]



CRIMP HEIGHT REFERENCE SETTING



18 AWG OR 0.80mm2

1.28+/-0.05 [.050+/- .002]

4.8

20 AWG OR 0.50mm2

1.14+/-0.05 [.045+/- .002]

6.3

22 AWG OR 0.30mm2

1.06+/-0.05 [.042+/- .002]

7.2



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: 8-2836367-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2836367-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2836367-5

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.
APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242.

 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.

APPLICATOR STYLE CONVERSION CHART

APPLICATOR DATA

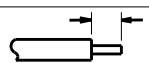
TERMINAL DATA: HONGXING TERMINAL

TE CRIMP SPECIFICATION

TERMINAL NAME: RECEPTACLE HOUSING

WIRE STRIP LENGTH

2.75-3.52 mm [.108-.138 IN]



INSULATION DIAMETER RANGE

Ø1.70-3.00 mm [.067-.118 IN]

TERMINAL APPLICATION SPECIFICATION

NONE

-

-

-

-

-

-

TERMINALS APPLIED



TE TERMINAL

HONGXING TERMINAL

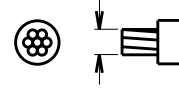
TE TERMINAL

HONGXING TERMINAL

2303613-1

HX45005-21RT

WIRE SIZE



CRIMP HEIGHT mm [INCH]



CRIMP HEIGHT REFERENCE SETTING



18 AWG OR 0.80mm2

1.28+/-0.05 [.050+/- .002]

4.8

20 AWG OR 0.50mm2

1.14+/-0.05 [.045+/- .002]

6.3

22 AWG OR 0.30mm2

1.06+/-0.05 [.042+/- .002]

7.2

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

2119599-1

LOC

A

DIST

66

REVISIONS

P

LTR

DESCRIPTION

DATE

OWN

APVD

-

-

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

-

1

1

1

1

2119082-3

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

7-18023-7

SCR, SKT HD CAP M3 X 4.0

241

-

-

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

-

-

2119740-2

TAG,IDENTIFICATION

213

-

-

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

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

-

-

REF

-

-

2119944-1

FEED FINGER ASSEMBLY,SF

117

-

1

1

1

1

455888-7

SPACER, CRIMPER

82

-

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, 2 x .188

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

-

-

-

1

1

5-18022-5

SCR, HEX HD CAP, M4 X 6.0

59

-

-

-

1

1

1338683-8

FEED PAWL

56

-

2

2

2

2

2168083-8

SCR, SKT HD CAP, RoHS, M4 X 16

53

-

1

1

1

1

5018030-1

NUT, HEX, REG, RoHS, M3

52

-

1

1

1

1

811242-5

BUMPER, HOLD DOWN

51

-

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

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

1752356-3

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

1-1320908-0

SPACER, STRIP GUIDE

30

-

1

1

1

1

2119959-1

ASSEMBLY, STRIP GUIDE

29

-

1

1

1

1

455888-3

SPACER, CRIMPER

28

-

1

1

1

1

1320928-2

STRIP GUIDE

24

-

1

1

1

1

2168083-2

SCR, SKT HD CAP, RoHS, M4 X 8.0

21

-

2

2

2

2

1-18028-2

WASHER, FLAT, REG M4

20

-

1

1

1

1

2119533-1

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

1803095-1

FLOATING SHEAR, FRONT

9

-

1

1

1

1

1

6-1633920-5

ANVIL, COMBINATION

8

-

1

1

1

1

1

240641-5

SPACER

7

-

-

-

-

-

-

-

6

-

1

1

1

1

2119757-4

DEPRESSOR, SHEAR

5

-

1

1

1

1

2-238011-2

BLOCK, CRIMPER SPACER

4

-

1

1

1

1

1

8-1803187-3

CRIMPER, INSULATION F

3

-

1

1

1

1

1

455888-7

SPACER, CRIMPER

2

-

1

1

1

1

1

6-456405-1

CRIMPER, WIRE PREMIUM

1

-77

-27

-25

-22

-21

PART NO

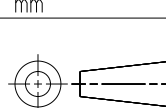
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ITEM NO

THE FOLLOWING TOLERANCES APPLY TO DIMENSIONS UNLESS OTHERWISE SPECIFIED:
IT IS SUBJECT TO CHANGE BASED ON THE LATEST REVISIONS OF THE DRAWING
AND SHALL BE CONTACTED FOR THE LATEST NOTATION

DIMENSIONS:

mm



TOLERANCES UNLESS OTHERWISE SPECIFIED:

0 PLC ±

1 PLC ±

2 PLC ±

3 PLC ±

4 PLC ±

ANGLES ±

FINISH ±

MATERIAL

-

-

OWN

28JUN2016

CHK

K. ZHAO

28JUN2016

CHK

K. ZHANG

28JUN2016

APVD

K. ZHANG

28JUN2016

NAME

Ocean Side Feed Applicator

SIZE

CAGE CODE

DRAWING NO

RESTRICTED TO

00779

©=2836367

-

Customer Accessible Production Drawing

SCALE

1:2

SHEET

3

OF

4

REV

A

AMP 4805 REV 31MAR2000

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

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

D

C

B

A

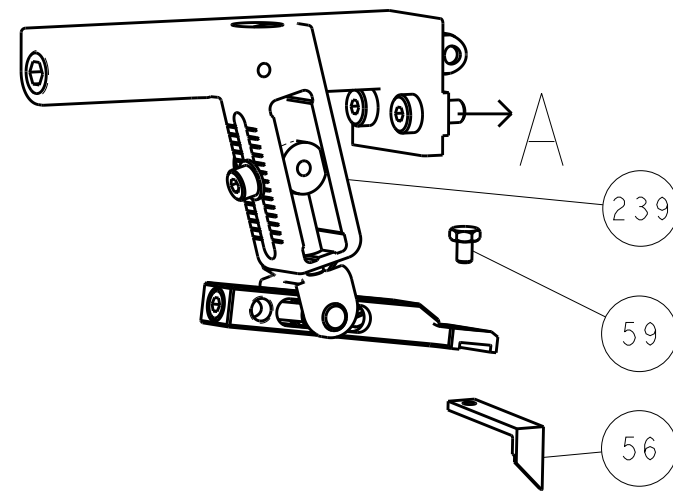
D

C

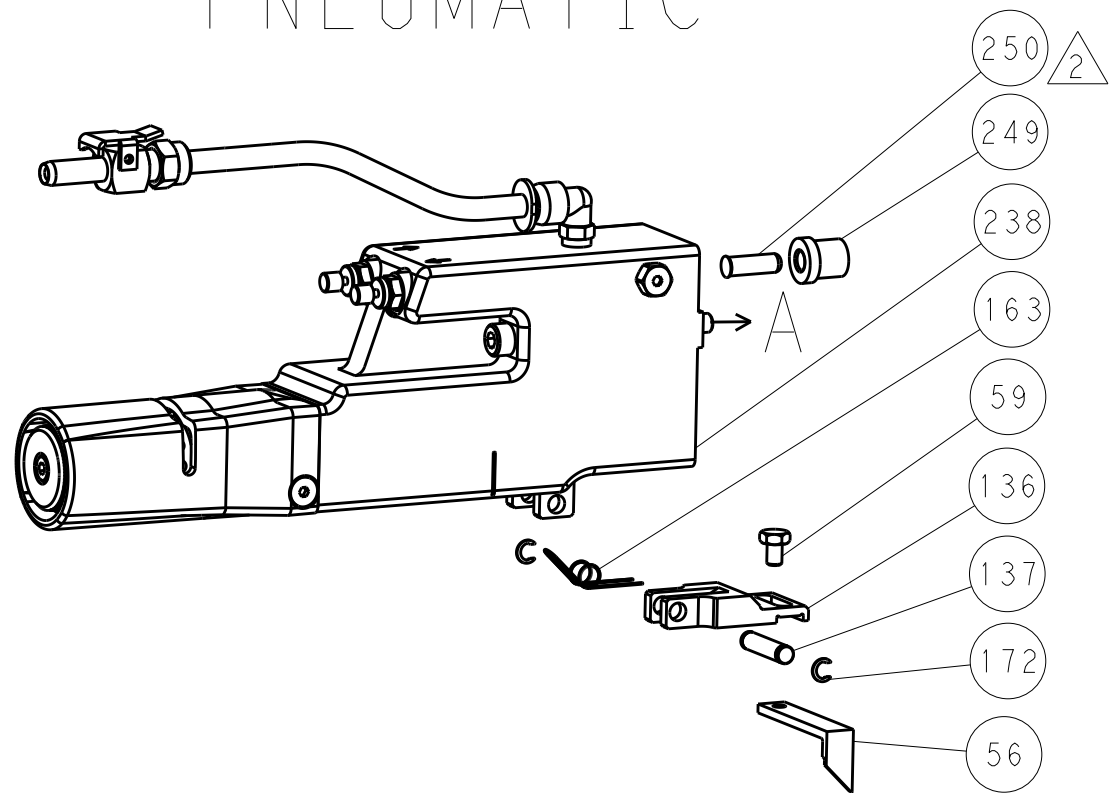
B

A

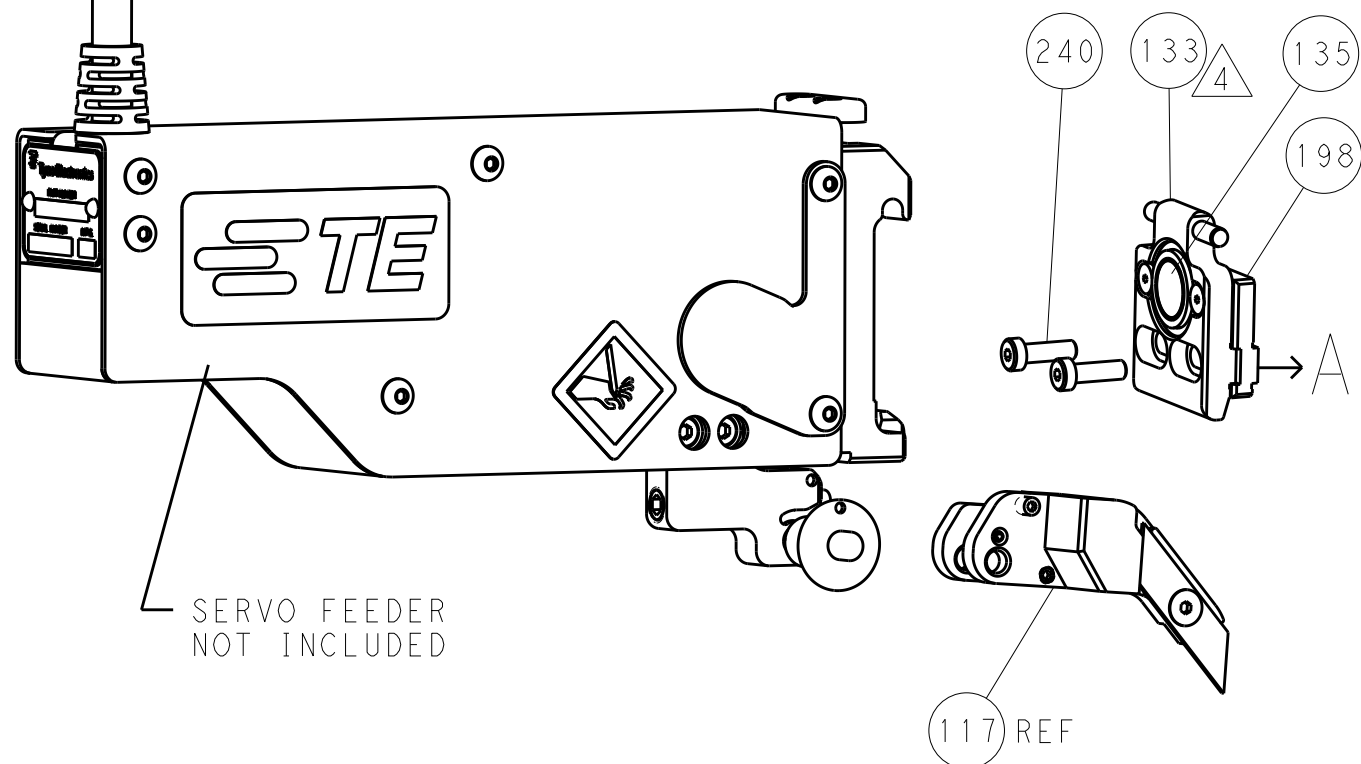
FEED TYPE MECHANICAL



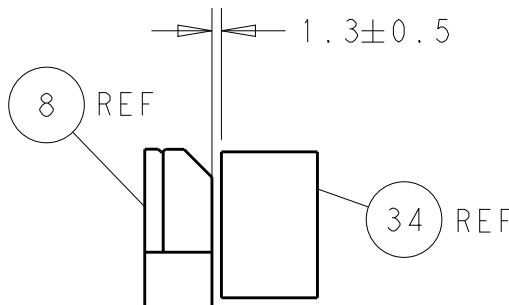
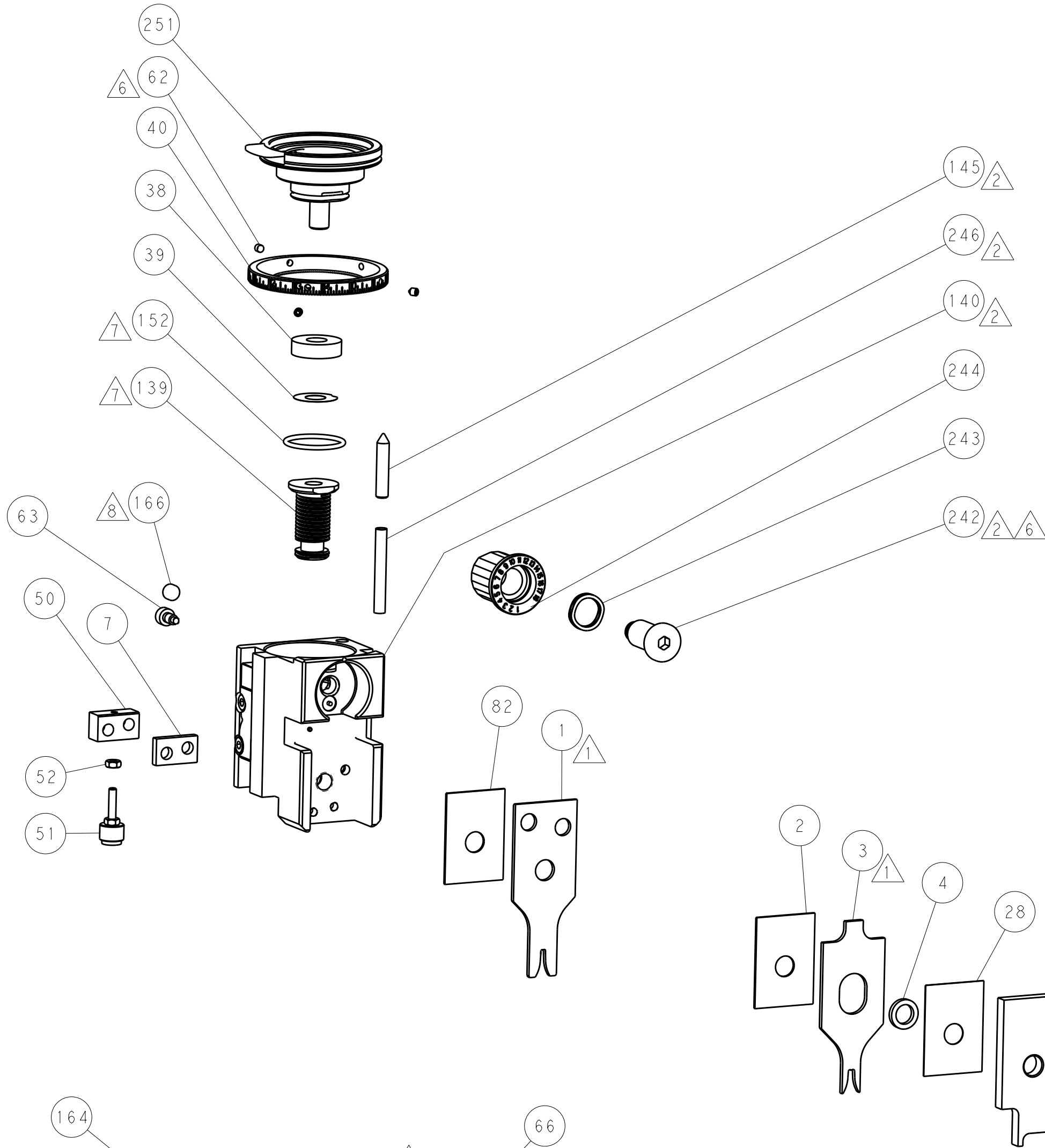
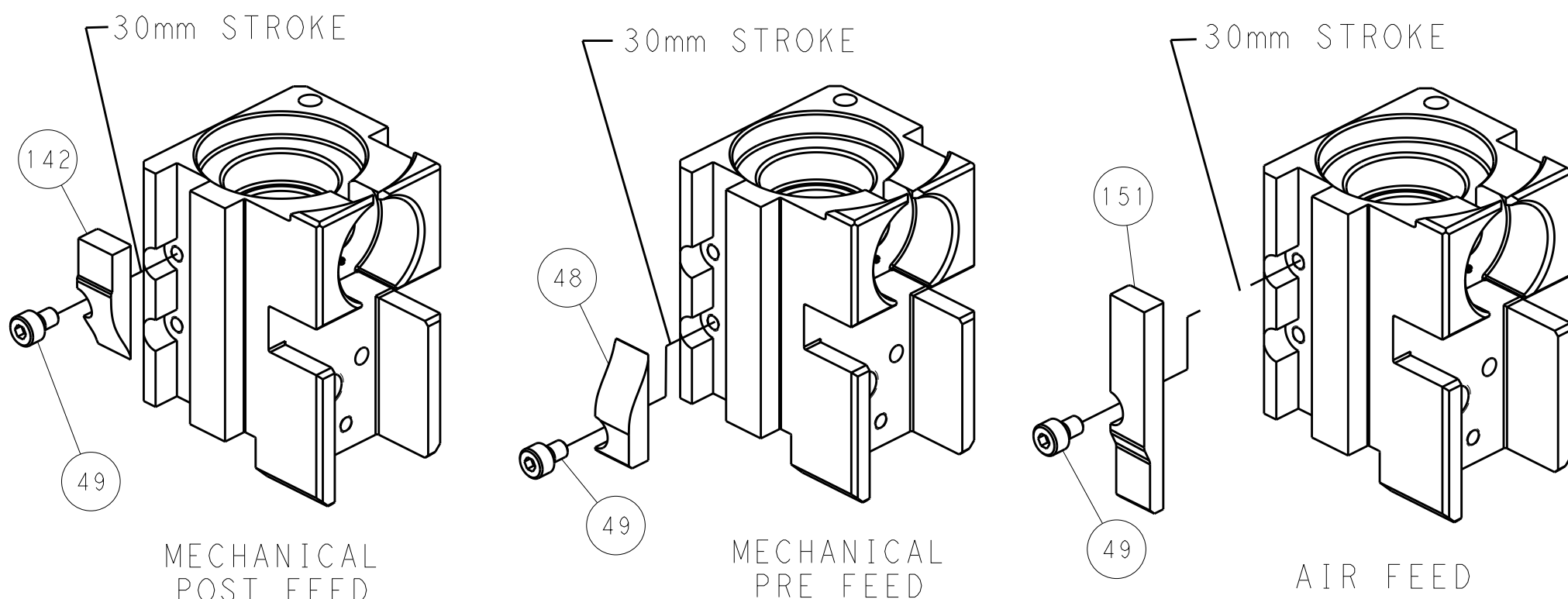
PNEUMATIC



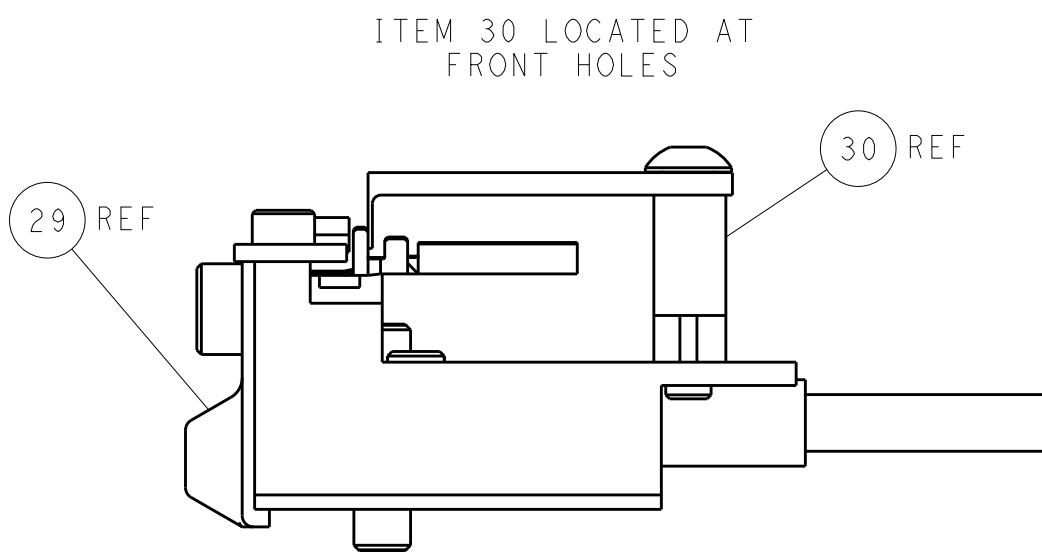
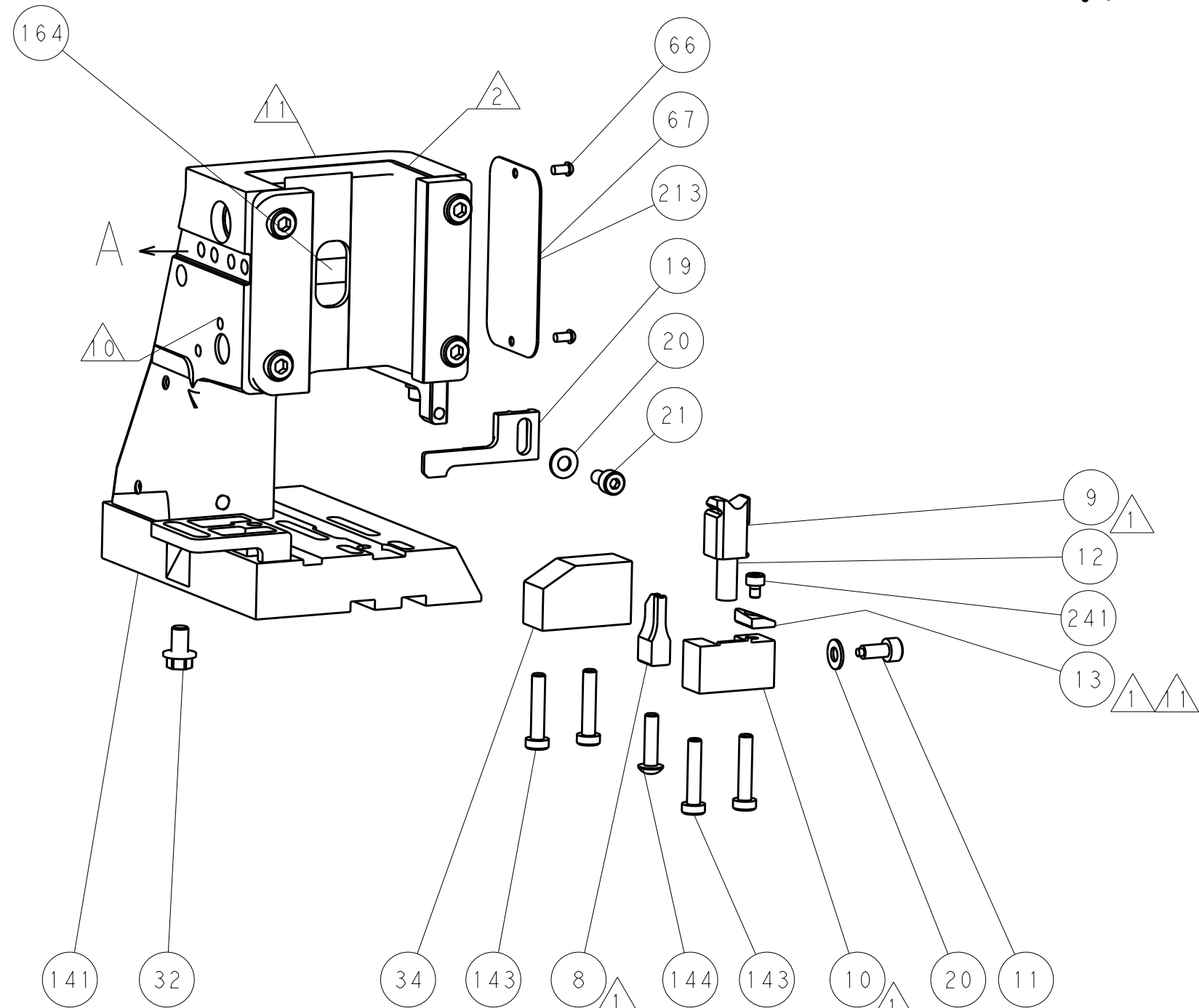
SERVO LATCH PLATE



CAM POSITIONS



TERMINAL SUPPORT LOCATION



FEED TRACK POSITION
GUIDE BY INSULATION BARREL

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

1ST PUBLISHED BY: CHANGHAI ELECTRONIC CORPORATION IT IS SUBJECT TO CHANGHAI ELECTRONIC CORPORATION'S POLICY ON CHANGHAI ELECTRONIC CORPORATION'S POLICY ON CHANGHAI ELECTRONIC CORPORATION'S		DWN M. ZHAO 28JUN2016	TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm		CHK K. ZHANG 28JUN2016	NAME Ocean Side Feed Applicator	
TOLERANCES UNLESS OTHERWISE SPECIFIED:		APVD K. ZHANG 28JUN2016	SIZE CAGE CODE DRAWING NO	
0 PLC ±.0005		PRODUCT SPEC	RESTRICTED TO	
1 PLC ±.0005		APPLICATION SPEC	A1 00779 ©=2836367	
2 PLC ±.0005		WEIGHT	Customer Accessible Production Drawing	
3 PLC ±.0005		SCALE	1:2	
4 PLC ±.0005		REVISIONS	SHEET 4 OF 4	
ANGLES		REV	A	
FINISH				