

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART					
					CONVERT TO	PART NUMBERS REQUIRED				
	2836427-2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	-	-	-	-	-	-
	2836427-5	A	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE	2119951-1	-	8-2836427-5	1901094-3	-	2168400-6 (QUANTITY 2)
	2836427-6	A	NON-CRIMP HEIGHT ADJUST	SERVO LATCH PLATE	2161326-1	-	8-2836427-4	-	-	-
	2836427-7	A	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-
	7-2836427-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.41 mm [.095]	F
INSUL	3.00 mm [.118]	F

APPLICATOR INSTRUCTIONS 408-10389

TERMINAL DATA: JENN FENG ELEC TERMINAL LITTELFUSE INC CRIMP SPECIFICATION	
TERMINAL NAME: CRIMP TERMINAL WITH INSULATION GRIP	
WIRE STRIP LENGTH 4.75-5.51 mm [.187-.217 IN]	INSULATION DIAMETER RANGE Ø2.00-2.66 mm [.079-.105 IN]
TERMINAL APPLICATION SPECIFICATION	LITTELFUSE Rev 8/10/2016
TERMINALS APPLIED	
TE TERMINAL	JENN FENG ELEC TERMINAL
2303657-1	913-009-R

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
18 AWG	1.55+/-0.05 [.061+/-0.002]	3.1



- 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:
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2836427-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2836427-5
SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2836427-6
- 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 ITEMS 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 ITEMS 37.
- GREASE THREADS, GROOVE AND O-RING ON ITEMS 35 & 252.
- MAGNET, ITEM 166 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.
- TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- 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.
- WHEN ASSEMBLING A NON CRIMP HEIGHT ADJUST APPLICATOR (-6) USE SHIMS FROM ITEM 260 TO ACHIEVE A NOMINAL SHIM HEIGHT OF 4.25.
- 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.

-	1	1	1	1	5-18024-8	SCR, BTN SKT HD CAP (M4 X 5.0)	283
-	1	1	1	1	2280441-1	INSERT, SHEAR	282
-	2	2	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	269
-	1	1	1	1	1633782-5	FENCE	267
-	-	-	-	-	2119957-2	APPLICATOR SHIM PACK	260
-	1	-	1	1	8-21084-0	O-RING, .676 ID, .070 DIA. MAT.	252
-	-	-	-	-	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	-	-	2119758-1	RAM, AMP STYLE, SIDE FEED, NON-ADJ.	245
-	1	1	1	1	2119082-4	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
-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
			1		DEVELOPMENT	01SEP2016	KH	LZ
			A		RELEASED	07OCT2016	MEH	GB

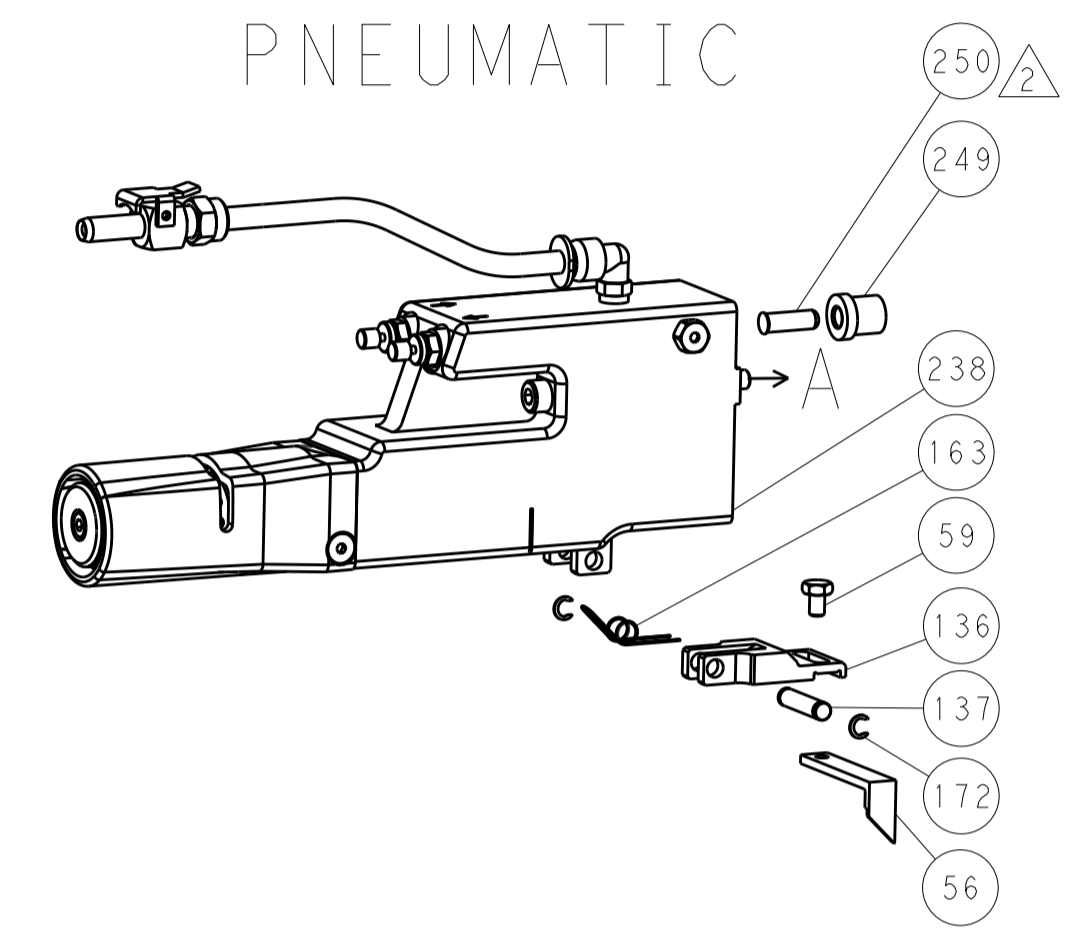
-	-	2	2	-	2168400-6	SHCS, LOW HEAD, RoHS, M5 X 16	240
-	-	-	-	1	2063440-1	AIR FEED MODULE	238
-	1	1	1	1	356885-6	STOP, SHEAR	237
-	-	1	1	-	2119740-2	TAG, IDENTIFICATION	213
-	-	1	1	-	1901094-3	SPACER, FEEDER	198
-	-	-	-	2	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172
-	1	1	1	1	994969-1	MAGNET, RARE 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
-	-	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
-	-	REF	REF	-	2119944-1	FEED FINGER ASSEMBLY, SF	117
-	1	1	1	1	693855-1	FRONT STRIP GUIDE	96
-	2	2	2	2	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 6.5	93
-	1	1	1	1	455888-9	SPACER, CRIMPER	82
-	1	1	1	1	3-240641-0	SPACER	81
-	1	1	1	1	2119956-1	DOCUMENTATION PACKAGE	71
-	1	1	1	1	2119791-5	DEPRESSOR, WIRE	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	2119793-1	LIMITER, ADJUSTMENT BOLT	63
-	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	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	1338683-8	FEED PAWL	56
-	4	4	4	4	2168400-1	SHCS, LOW HEAD, RoHS, M4 X 12	54
-	2	2	2	2	1-2168083-2	SCR, SKT HD CAP, RoHS, M4 X 25	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	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	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	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	2119644-1	RAM WASHER, PRECISION	38
-	1	1	1	1	2119085-1	FA HEAD, ATLANTIC STYLE	37
-	1	-	1	1	2119092-1	BOLT, ADJUSTMENT	35
-	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	2119959-3	ASSEMBLY, STRIP GUIDE	29
-	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	1320928-6	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
-	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	690463-1	FLOATING SHEAR, REAR	17
-	2	2	2	2	1-2168083-1	SCR, SKT HD CAP, RoHS, M3 X 6	16
-	1	1	1	1	2-690464-6	SHEAR PLATE, REAR	15
-	1	1	1	1	1803217-1	SHEAR HOLDER, REAR	14
-	1	1	1	1	2119806-1	INSERT, SHEAR	13
-	2	2	2	2	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	9-1803056-1	ANVIL, COMBINATION	8
-	1	1	1	1	6-240641-5	SPACER	7
-	1	1	1	1	1-690468-7	DEPRESSOR SHEAR, REAR	6
-	1	1	1	1	2119757-4	DEPRESSOR, SHEAR	5
-	1	1	1	1	6-238011-9	BLOCK, CRIMPER SPACER	4
1	1	1	1	1	9-1803017-0	CRIMPER, INSULATION F	3
-	1	1	1	1	455888-6	SPACER, CRIMPER	2
1	1	1	1	1	9-1803188-9	CRIMPER, WIRE	1
-77	-7	-6	-5	-2	PART NO	DESCRIPTION	ITEM NO

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DRAWING NO	
mm	0 PLC	±	25AUG2016	CHK	25AUG2016
	1 PLC	±		CHK	
	2 PLC	±		CHK	
	3 PLC	±		CHK	
	4 PLC	±		CHK	
	ANGLES	±		CHK	
MATERIAL	FINISH			APVD	25AUG2016
				NAME	
				PRODUCT SPEC	
				APPLICATION SPEC	
				SIZE	CAGE CODE
				A1	00779
				WEIGHT	©=2836427
				Customer Accessible Production Drawing	SCALE 1:2 SHEET 1 OF 4 REV A

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

FEED TYPE

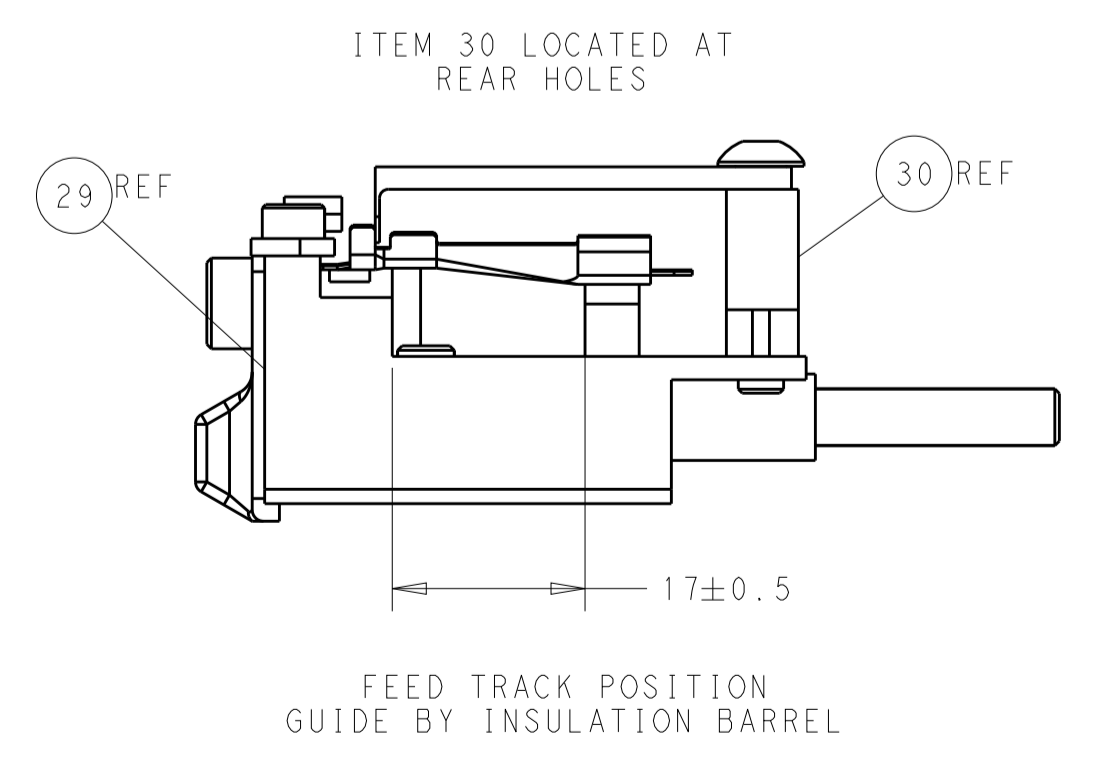
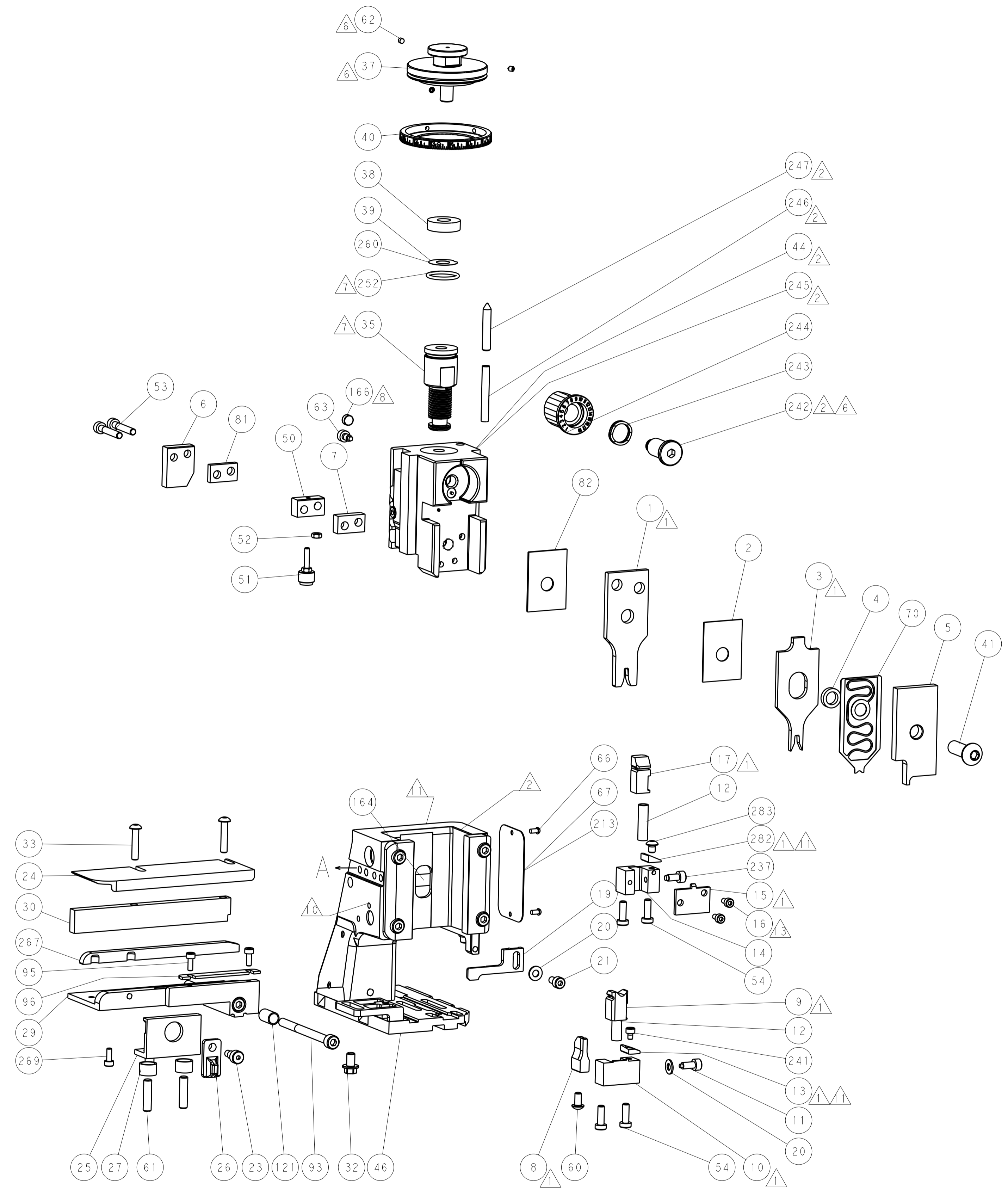
PNEUMATIC



SERVO LATCH PLATE



CAM POSITION

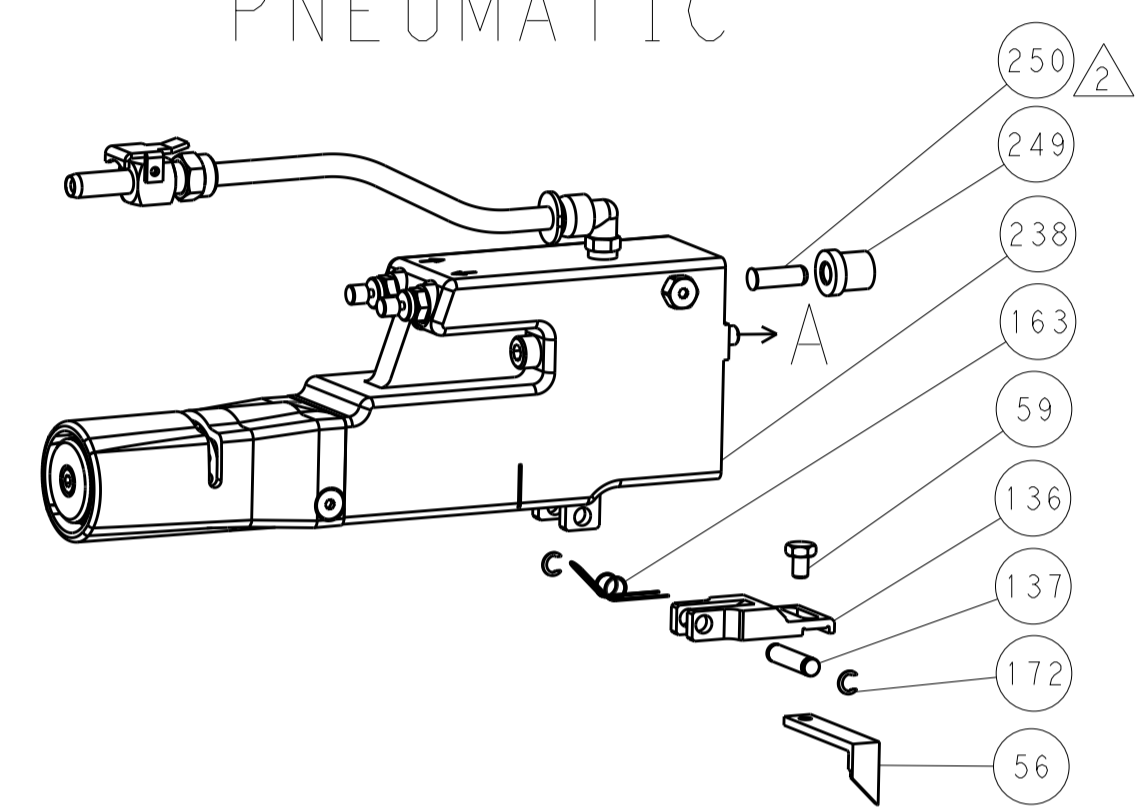


ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN: A. HUANG 25AUG2016		TE Connectivity	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	5 PLC ±	Harrisburg, PA 17105-3608
	ANGLES	FINISH		CHK: L. ZHANG 25AUG2016		NAME: Ocean Side Feed Applicator	
MATERIAL				APVD: L. ZHANG 25AUG2016		PRODUCT SPEC	
				APPLICATION SPEC		SIZE: CAGE CODE DRAWING NO	
				WEIGHT		RESTRICTED TO	
				A1 00779 ©=2836427		SCALE: 1:2 SHEET 2 OF 4 REV A	
Customer Accessible Production Drawing				Customer Accessible Production Drawing			

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

FEED TYPE PNEUMATIC



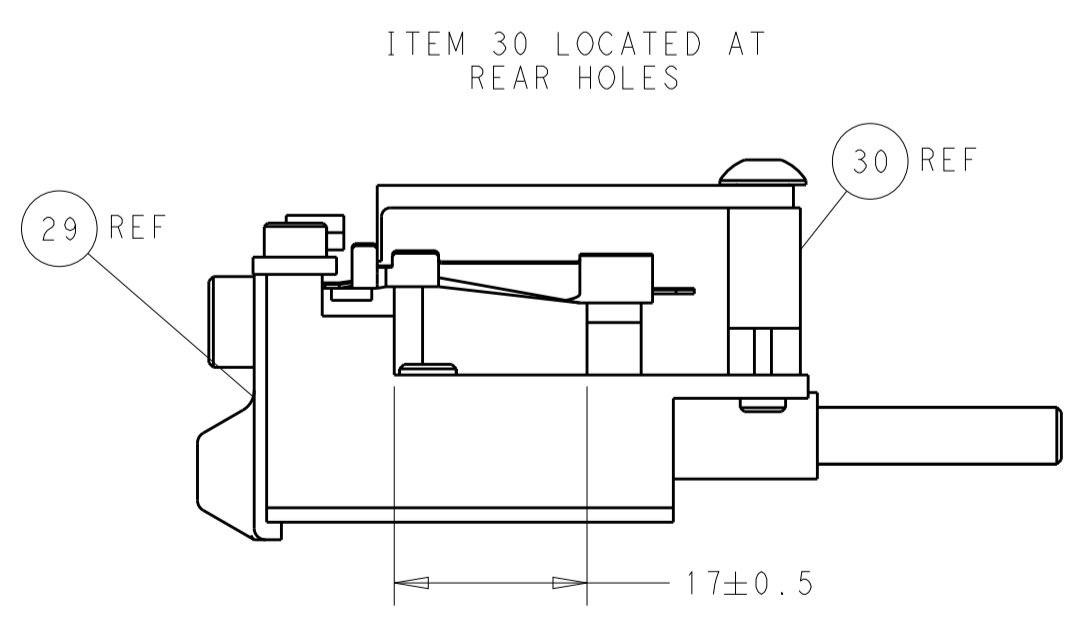
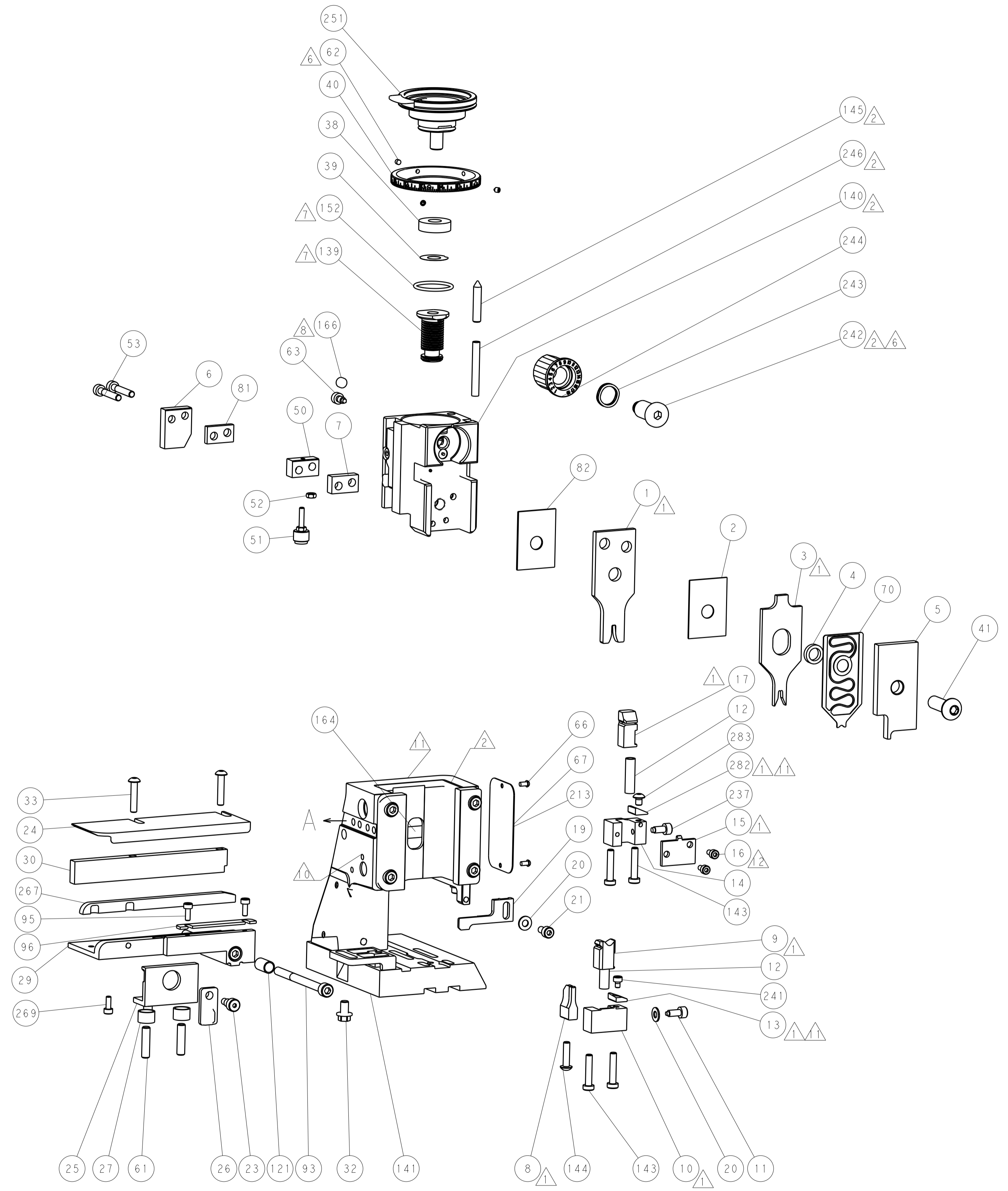
SERVO LATCH PLATE



CAM POSITION



AIR FEED



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)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN: H. HUANG 25AUG2016		STE Connectivity Harrisburg, PA 17105-3608	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	NAME: Ocean Side Feed Applicator	
MATERIAL:		FINISH:		CHK: L. ZHANG 25AUG2016		RESTRICTED TO:	
				APVD: L. ZHANG 25AUG2016		SIZE: A1	
				PRODUCT SPEC:		CAGE CODE: 00779	
				APPLICATION SPEC:		DRAWING NO: 2836427	
				WEIGHT:		SCALE: 1:2	
				Customer Accessible Production Drawing		SHEET 4 OF 4 REV A	