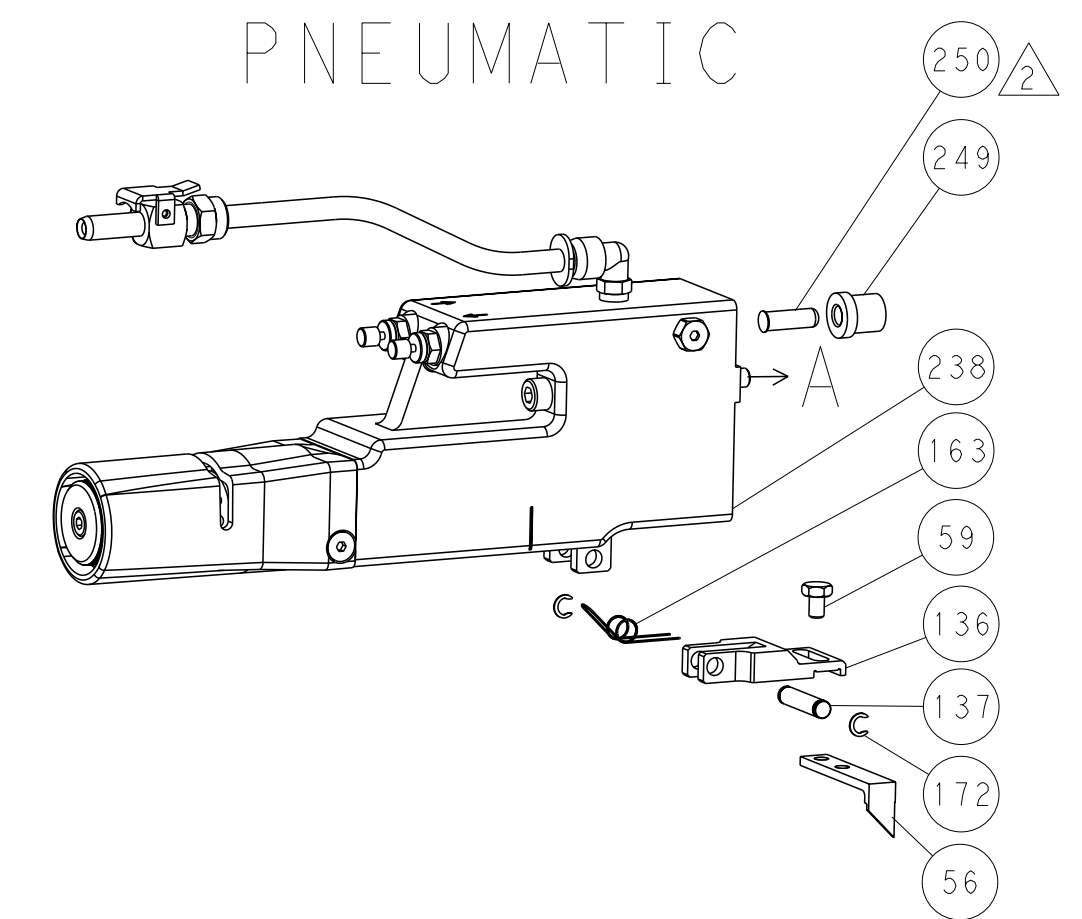


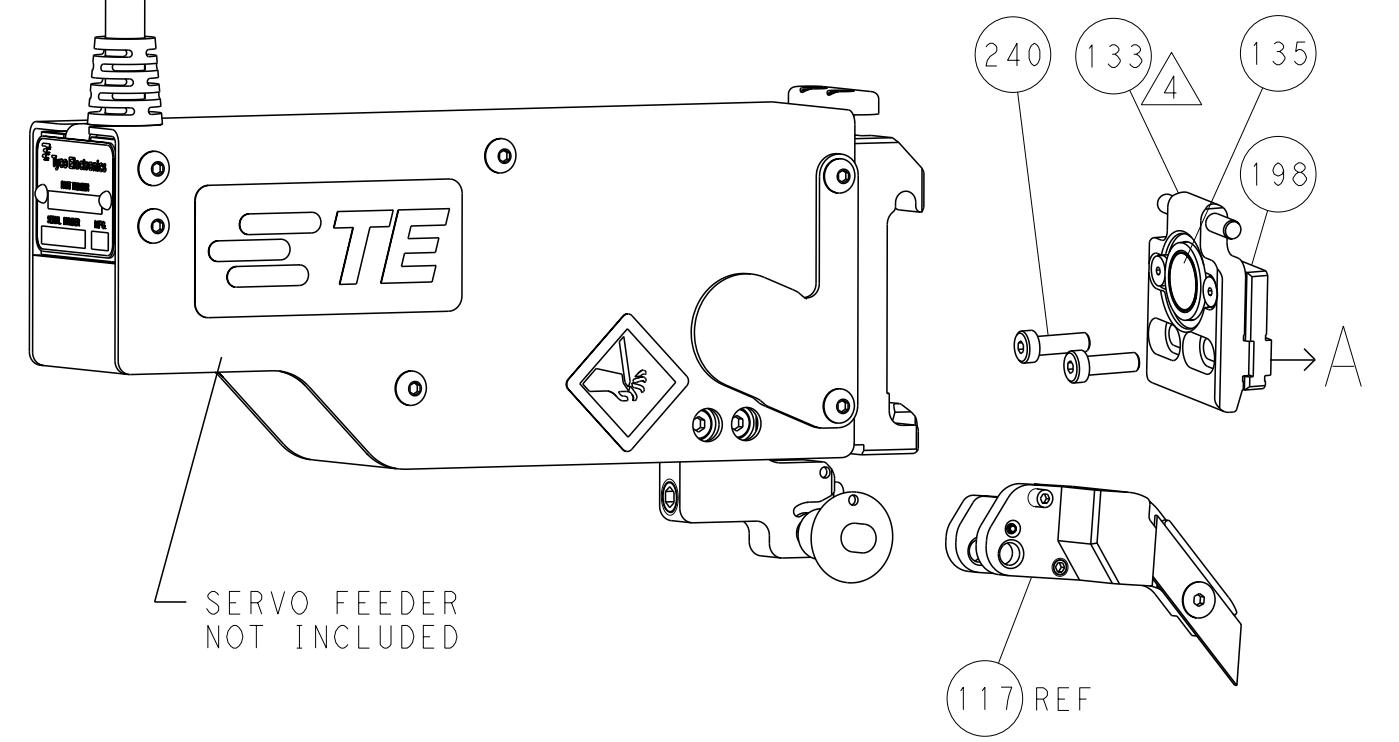
LOC		DIST		REVISIONS			
A	66	P	LYR	DESCRIPTION	DATE	OWN	APVD
		-		SEE SHEET 1	-	-	-

FEED TYPE

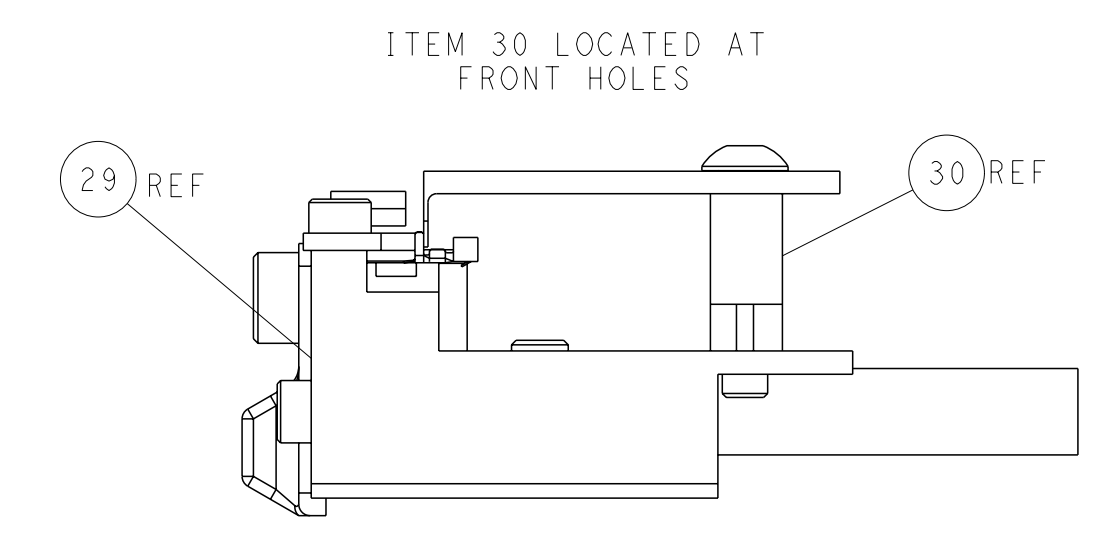
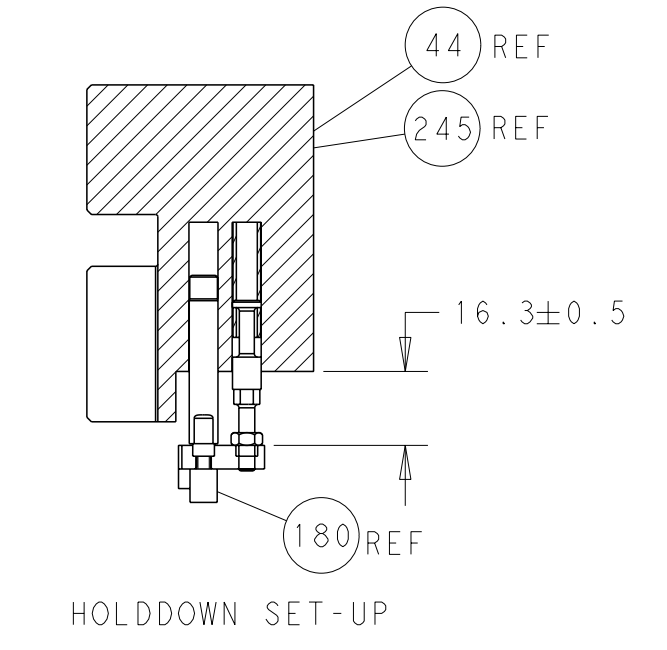
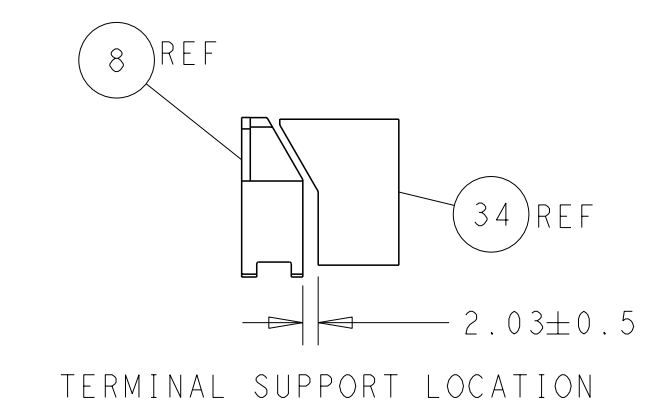
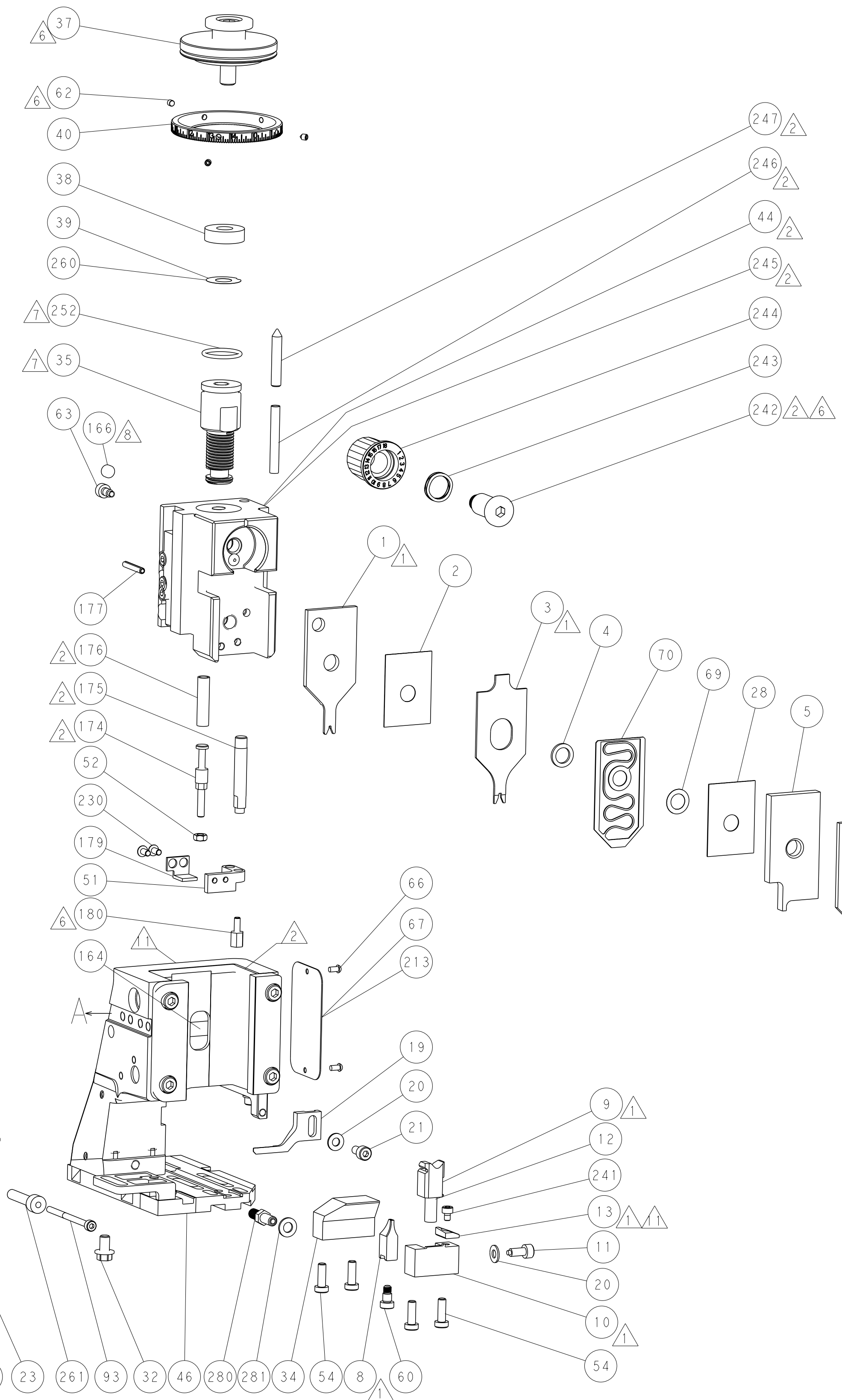
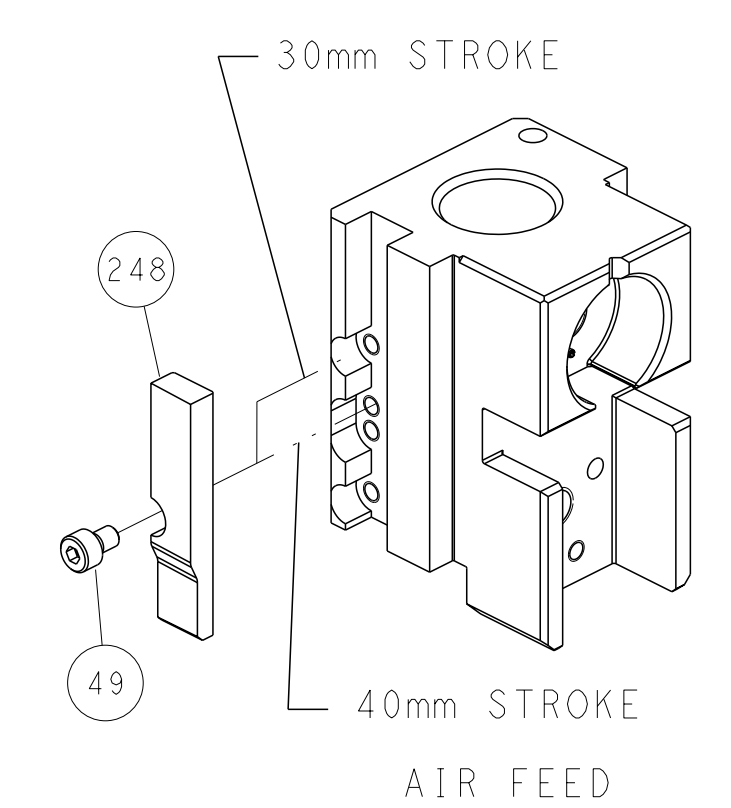
PNEUMATIC



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)

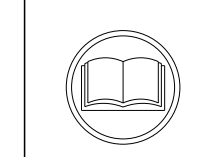
<small>THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE AND THE CONTROL AND REVISIONS DISPOSITION SHOULD BE CONTACTED FOR THE LATEST REVISION.</small>		DWN T. BROOKS 15JUN2018 CHK M. HERR 15JUN2018 APVD C. TOPPER 15JUN2018	TE Connectivity Harrisburg, PA 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 CAGE CODE DRAWING NO. A1 00779 C=2837304 WEIGHT Customer Accessible Production Drawing	RESTRICTED TO SCALE 1:2 SHEET 2 OF 4 REV A

PACIFIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
	2-2837304-2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
	2-2837304-5	A	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE ⁴
	2-2837304-7	A	FINE CRIMP HEIGHT ADJUST	NONE
	7-2837304-7	A	CRIMP TOOLING KIT	-

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.17 mm [.046]	F
INSUL	1.57 mm [.062]	F
APPLICATOR INSTRUCTIONS 408-10389		

TERMINAL DATA: WURTH TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: 2.00mm FEMALE			
WIRE STRIP LENGTH		TERMINAL INSULATION DIAMETER RANGE	
1.66-2.42 mm [.065-.095 IN]		Ø0.92-1.22 mm [.036-.048 IN]	
TERMINAL APPLICATION SPECIFICATION	NONE		
TERMINALS APPLIED ¹³			
TE TERMINAL	WURTH TERMINAL	TE TERMINAL	WURTH TERMINAL
2113722-1	62000113722		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
24 AWG	0.65 +/- 0.05 [.026 +/- .002]	5.3
0.14mm ²	0.63 +/- 0.05 [.025 +/- .002]	5.4
26 AWG	0.61 +/- 0.05 [.024 +/- .002]	5.7
28 AWG	0.58 +/- 0.05 [.023 +/- .002]	5.9



- 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: 8-2837304-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2837304-5
- 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 ITEMS 62 & 180.
APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242.
- ⁷ GREASE THREADS, GROOVE AND O-RING ON ITEMS 139 & 152.
- ⁸ MAGNET 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 TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- ¹¹ 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.
- 12. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT 101-35000.
- ¹³ TERMINAL LUBRICANT IS RECOMMENDED.
- ¹⁴ PART OPTIONAL FOR BETTER LEADMAKER PERFORMANCE.

***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	-27	-25	-22	PART NO	DESCRIPTION	ITEM NO
-	1	1	1	2079383-1	SCR, BHSC, RoHS (M3 X 8)	284
-	1	1	1	1633289-4	STABILIZER	283
-	1	1	1	1803461-1	HOLDER, STABILIZER	282
-	1	1	1	1-18028-3	WASHER, FLAT, REG M5	281
-	1	1	1	1803196-1	STUD, ADJUSTMENT SCREW	280
-	1	1	1	2330046-1	RESIN COLLAR, FLANGED	261
-	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	2119082-4	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	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	2063440-1	AIR FEED MODULE	238
-	2	2	2	1-2079383-0	SCR, BHSC, RoHS (M3 X 6)	230
-	-	1	-	2119740-2	TAG, IDENTIFICATION	213

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			
2161422-1	A	66	REV	DATE	BY	APPV
			-	SEE SHEET 1	-	-

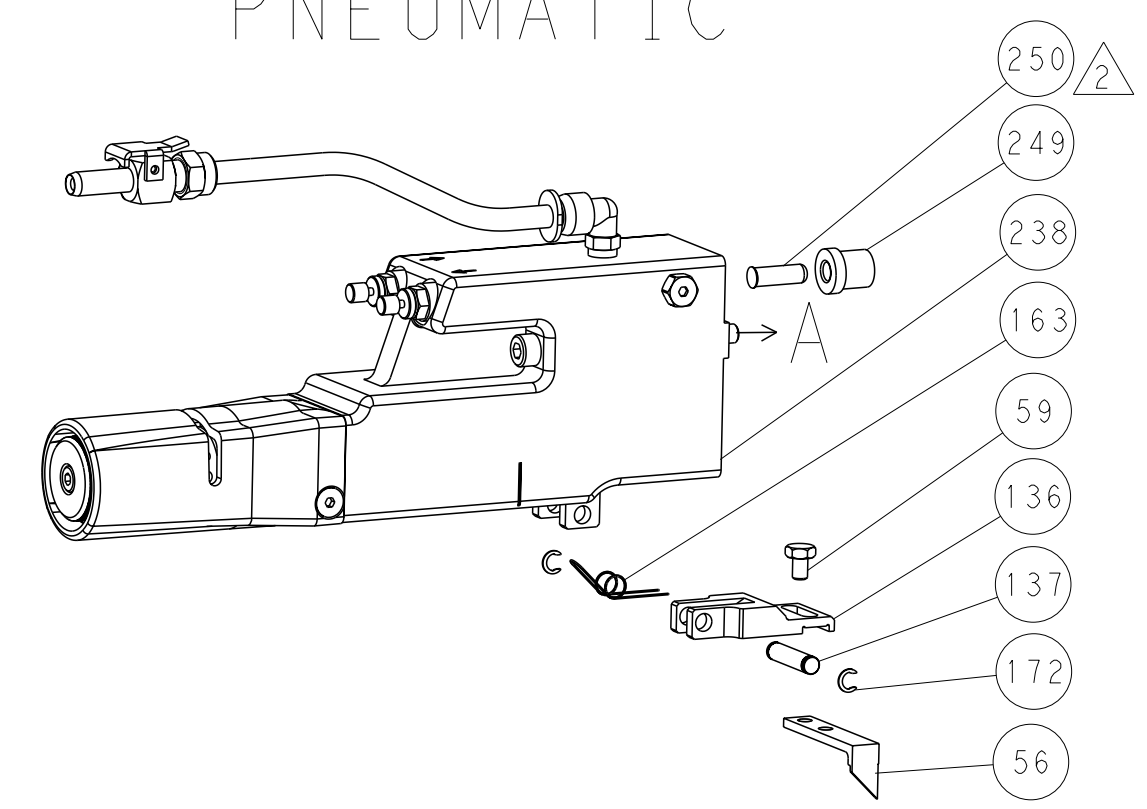
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-	-	1	-	1901094-3	SPACER, FEEDER		198
-	1	1	1	1-1752354-4	STANDOFF, HOLD-DOWN		180
-	1	1	1	2-1633764-2	HOLD DOWN, TERMINAL		179
-	1	1	1	993111-1	PIN, SLOTTED SPRING 3.0 X 20.0		177
-	1	1	1	8-22280-7	SPRING, COMPRESSION		176
-	1	1	1	1752353-2	GUIDE PIN, HOLDDOWN		175
-	1	1	1	1901680-2	GUIDE PIN, HOLDDOWN		174
-	-	-	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
-	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	2119798-2	DETENT PIN		145
-	1	1	1	2161425-1	SCREW, SHOULDER		144
-	4	4	4	2168400-5	SHCS, LOW HEAD, RoHS, M4 X 20		143
-	1	1	1	3-2119656-0	APPLICATOR BASIC ASSEMBLY, SF		141
-	1	1	1	2119650-1	RAM, ASIAN STYLE, SIDE FEED		140
-	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	1-22281-6	SPRING, COMPRESSION		121
-	-	REF	-	2119944-1	FEED FINGER ASSEMBLY, SF		117
-	1	1	1	2119955-1	ASSY, LUBRICATOR, SIDE FEED		113
-	1	1	1	1-690438-0	FRONT STRIP GUIDE		96
-	2	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0		95
-	1	1	1	1-994962-8	SCR, SKT HD CAP M3 X 45.0		93
-	1	1	1	2119956-1	DOCUMENTATION PACKAGE		71
-	1	1	1	2-2119791-2	DEPRESSOR, WIRE		70
-	1	1	1	2119943-1	WASHER, SPACER		69
-	1	-	1	2119740-1	TAG, IDENTIFICATION		67
-	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 PNT, M3 X 4.0		62
-	2	2	2	2-18032-5	SCR, SET, FLT PNT, M5 X 20.0		61
-	-	-	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0		59
-	-	-	1	1338685-1	PAWL, FEED		56
-	1	1	1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5		52
-	1	1	1	1901681-8	HOLDDOWN, TERMINAL		51
-	-	-	1	18023-9	SCR, SKT HD CAP M4 X 6.0		49
-	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	1-2119644-4	RAM WASHER, PRECISION		38
-	1	1	1	2-1752356-7	SUPPORT, TERMINAL		34
-	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)		33
-	1	1	1	2161328-1	HEX HEAD, FLANGED, M5 x 8mm LONG		32
-	1	1	1	1320908-6	SPACER, STRIP GUIDE		30
-	1	1	1	1901086-1	PLATE, STRIP GUIDE		29
-	1	1	1	455888-4	SPACER, CRIMPER		28
-	2	2	2	22283-1	SPRING, COMPRESSION		27
-	1	1	1	356835-1	LEVER, DRAG RELEASE		26
-	1	1	1	240792-1	DRAG, TERMINAL		25
-	1	1	1	1320928-6	STRIP GUIDE		24
-	1	1	1	980371-4	SCR, SKT HD SHLDR 5.0 DIA X 6.0		23
-	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0		21
-	2	2	2	1-18028-2	WASHER, FLAT, REG M4		20
-	1	1	1	1803213-1	STRIPPER		19
-	1	1	1	2119806-1	INSERT, SHEAR		13
-	1	1	1	3-22280-3	SPRING, COMPRESSION		12
-	1	1	1	1-356885-4	STOP, SHEAR		11
-	1	1	1	2119805-1	SHEAR HOLDER, FRONT		10
-	1	1	1	1803095-6	FLOATING SHEAR, FRONT		9
-	1	1	1	1803655-6	ANVIL, COMBINATION		8
-	-	-	-	-	-		7
-	-	-	-	-	-		6
-	1	1	1	2119757-1	DEPRESSOR, SHEAR		5
-	1	1	1	2-238011-0	BLOCK, CRIMPER SPACER		4
-	1	1	1	1-1803493-6	CRIMPER, INSULATION F PREMIUM		3
-	1	1	1	455888-3	SPACER, CRIMPER		2
-	1	1	1	3-1803407-2	CRIMPER, WIRE PREMIUM		1

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

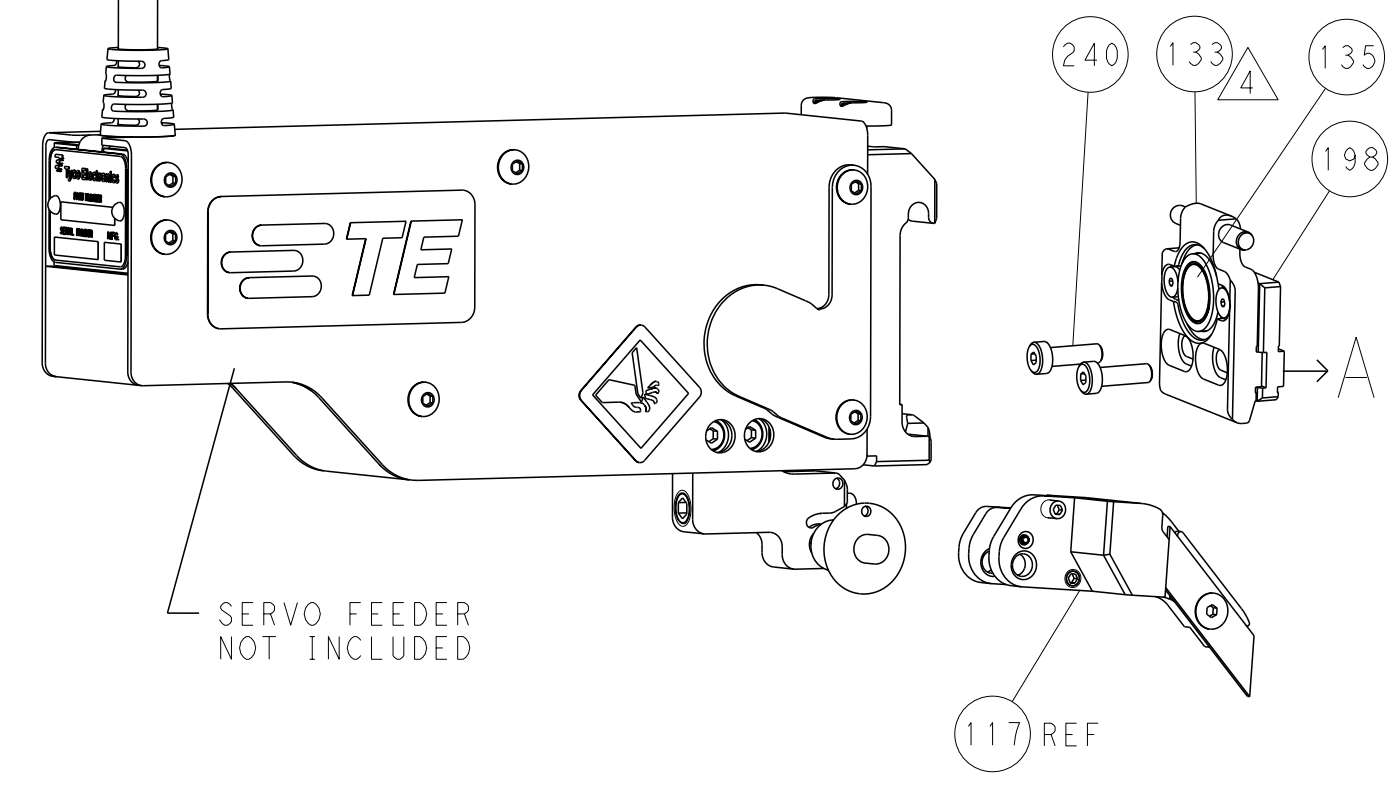
OWN	T. BROOKS	15JUN2018		TE Connectivity
CHK	M. HERR	15JUN2018		Harrisburg, PA 17105-3608
APPV	C. TOPPER	15JUN2018	Ocean Side Feed Applicator	
Customer Accessible Production Drawing			SCALE	1:2
SHEET			3	of 4
REV			A	

LOC	DIST	REVISIONS					
A	66	P	LYR	DESCRIPTION	DATE	OWN	APVD
		-		SEE SHEET 1	-	-	-

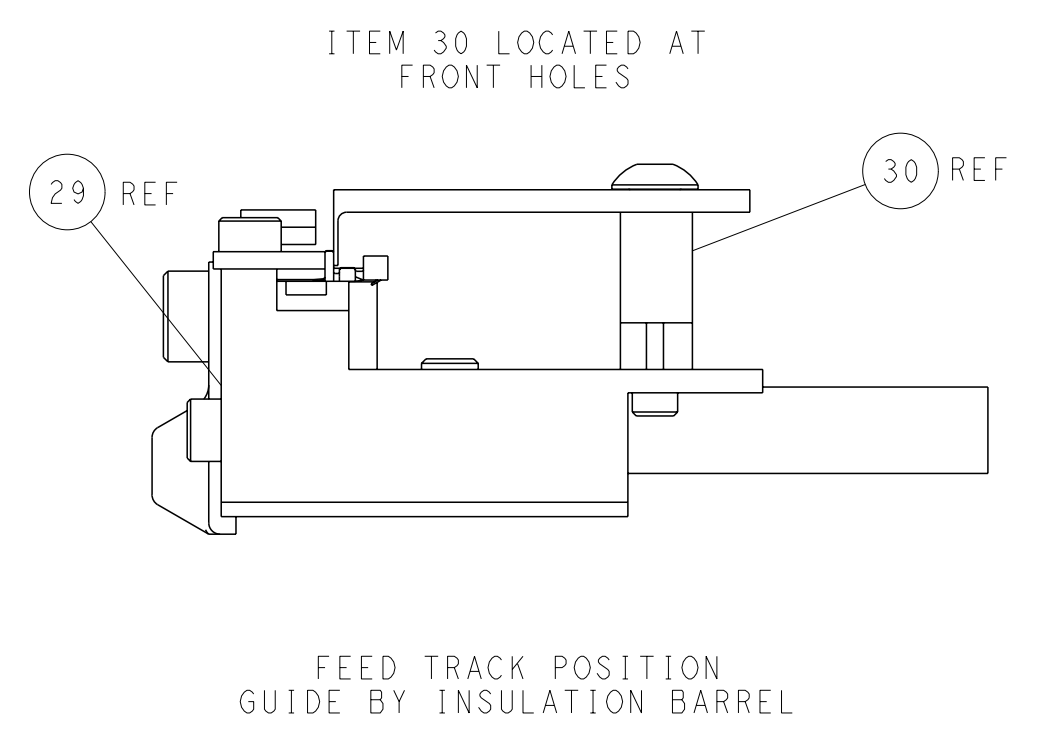
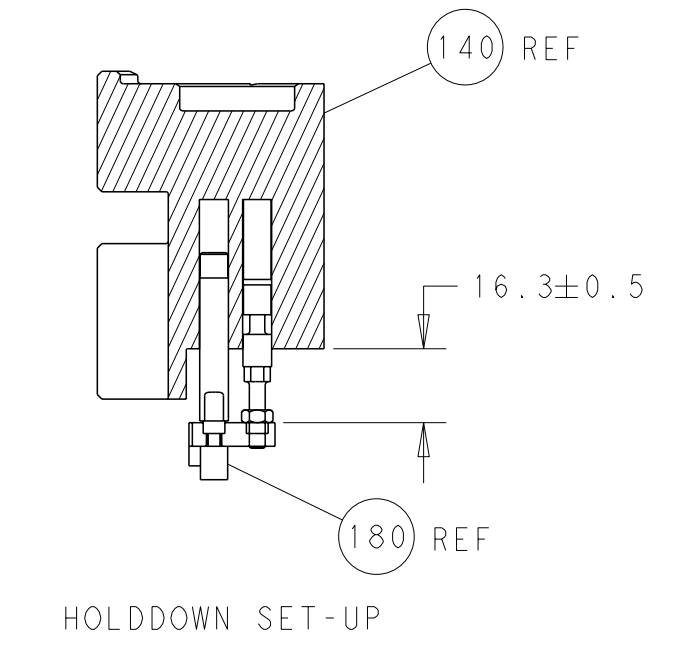
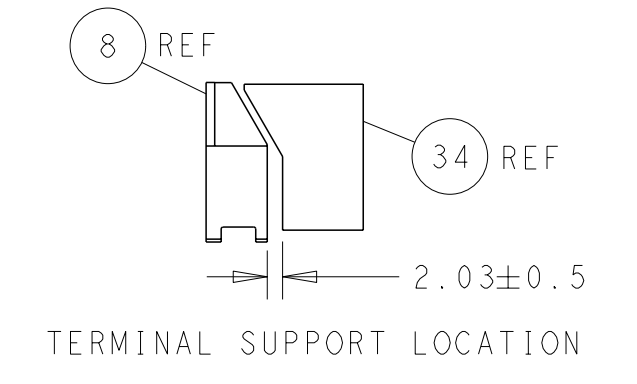
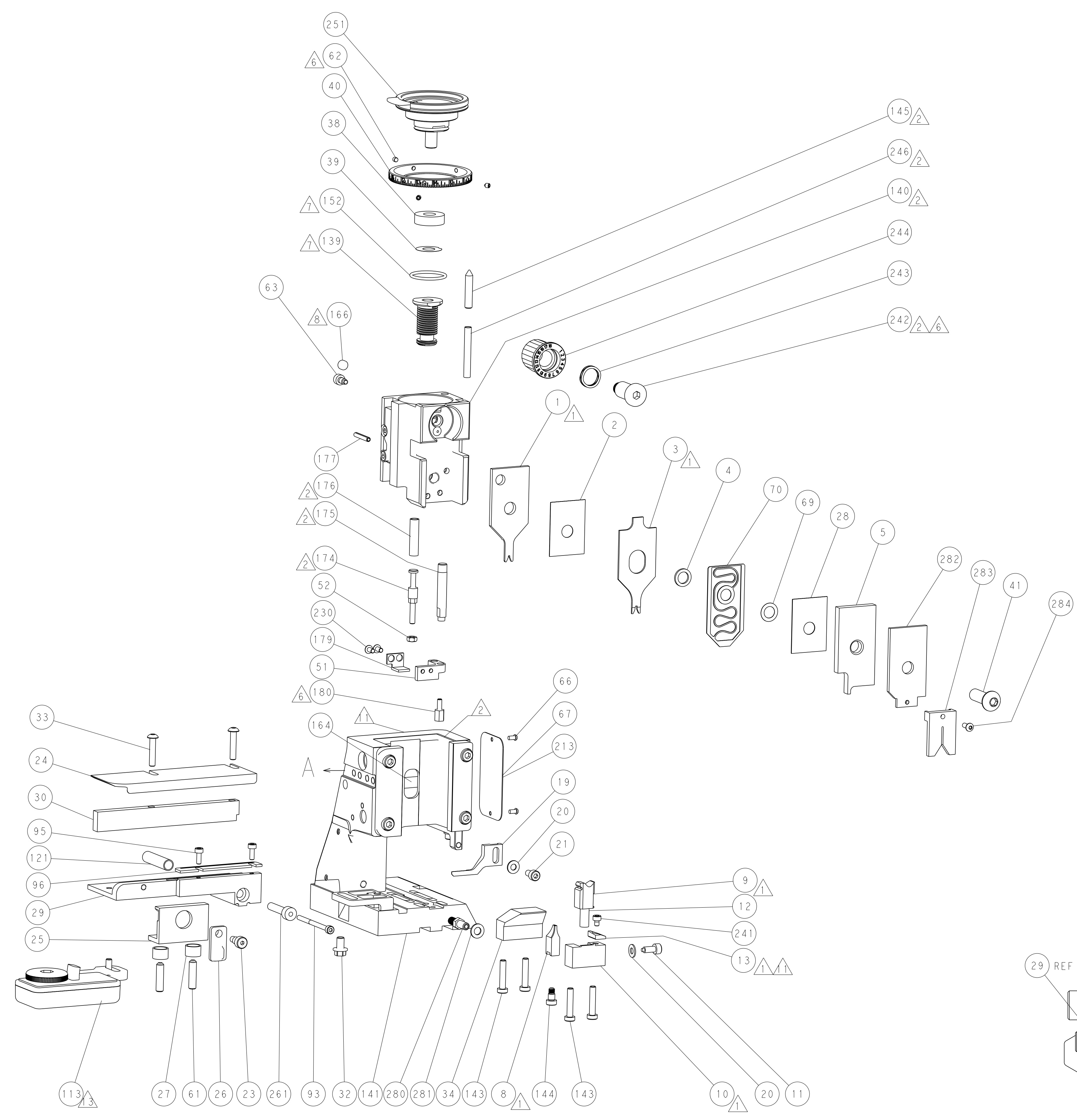
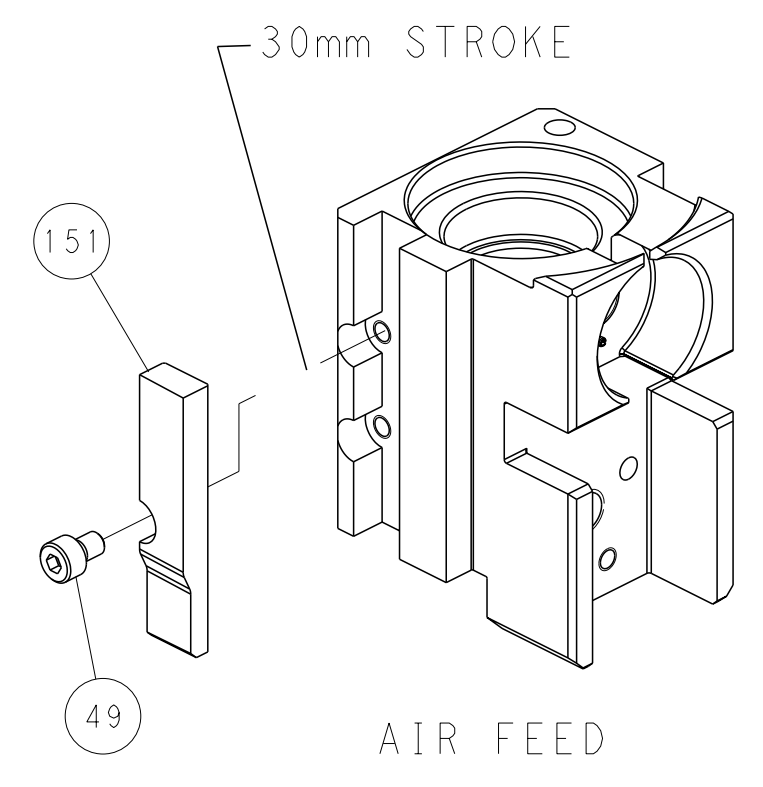
FEED TYPE PNEUMATIC



SERVO LATCH PLATE



CAM POSITION



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

<small>THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE AND THE CONTROLLER'S DISCRETION SHOULD BE CONTACTED FOR THE LATEST REVISION.</small>		DWN T. BROOKS 15JUN2018 CHK M. HERR 15JUN2018 APVD C. TOPPER 15JUN2018	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 APPLICATION SPEC SIZE A1 CAGE CODE 00779 DRAWING NO. C=2837304 WEIGHT SCALE 1:2 SHEET 4 of 4 REV A	RESTRICTED TO
MATERIAL:		Customer Accessible Production Drawing	SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION