

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART						
					CONVERT TO	PART NUMBERS REQUIRED					
	2836647-2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	-	-	-	-	-	-	
	2836647-5	A	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE ⁴	SERVO LATCH PLATE	2119951-1	-	8-2836647-5	1901094-3	-	2168400-6 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2836647-4	-	-	-
	2836647-6	A	NON-CRIMP HEIGHT ADJUST	SERVO LATCH PLATE ⁴	-	-	-	-	-	-	
	2836647-7	A	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	
	7-2836647-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-	

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	3.48 mm [.137]	F
INSUL	4.95 mm [.195]	F

APPLICATOR INSTRUCTIONS
408-10389

TERMINAL DATA: SUMITOMO TERMINAL		SUMITOMO CRIMP SPECIFICATION	
TERMINAL NAME: SUMITOMO TERMINAL			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
5.38-6.14 mm [.212-.242 IN]		Ø2.20-4.30 mm [.087-.169 IN]	
TERMINAL APPLICATION SPECIFICATION		EARTH M6Z-L-SN Rev 3/23/2017	
TERMINALS APPLIED ^{10,13}			
TE TERMINAL	SUMITOMO TERMINAL	TE TERMINAL	SUMITOMO TERMINAL
1-1203679-1	8100-2991		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
3.00mm ²	2.50 +/- 0.05 [.098 +/- .002]	4.9
2.50mm ²	2.40 +/- 0.05 [.094 +/- .002]	5.7
2.00mm ²	2.30 +/- 0.05 [.091 +/- .002]	6.8
1.50mm ²	2.20 +/- 0.05 [.087 +/- .002]	7.5
2 X 0.75mm ²	2.20 +/- 0.05 [.087 +/- .002]	8.0
0.5 + 0.75mm ²	2.15 +/- 0.05 [.085 +/- .002]	8.6

- 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: 8-2836647-4
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2836647-5
 SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2836647-6
- 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 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 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 3.3.
- ¹³ TERMINAL LUBRICANT IS RECOMMENDED.

*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.

- 2	2	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	269	
- 1	1	1	1	1-1633782-4	FENCE	267	
- -	-	-	-	2119957-2	APPLICATOR SHIM PACK	260	
- 1	1	1	1	1803078-3	SPACER, PRECISION	259	
- 1	-	-	-	8-21084-0	O-RING, .676 ID, .070 DIA. MAT.	252	
- -	-	-	-	2119640-1	PUSH ROD, AIR FEED	250	
- -	-	-	-	1803259-1	BUSHING, FLANGED	249	
- -	-	-	-	2119641-1	FEED CAM, AIR FEED	248	
- 1	-	-	-	2119798-1	DETENT PIN	247	
- 1	-	-	-	1-22279-3	SPRING, COMPRESSION	246	
- -	-	-	-	2161314-1	RAM, STEPPED, ATLANTIC, SF, NON-ADJ	245	
- 1	1	1	1	2119082-7	CAM, SNAIL, INSULATION ADJUSTMENT	244	
- 1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243	
-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
			A		RELEASED	15MAY2017	TB	TE

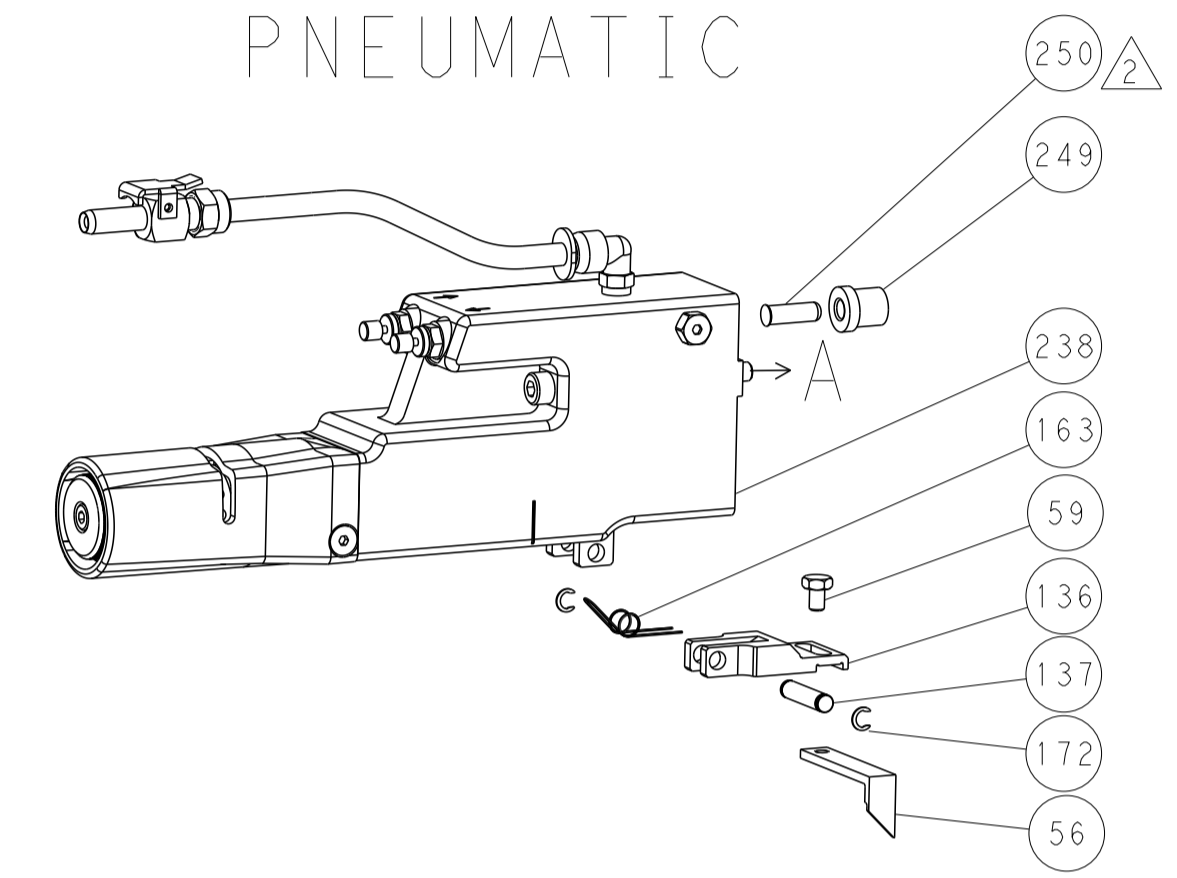
⁶	-	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	-	1	1	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
-	-	-	2	2	-	2168400-6	SHCS, LOW HEAD, RoHS, M5 X 16	240
-	-	-	-	-	1	2063440-1	AIR FEED MODULE	238
-	-	-	1	1	-	2119740-2	TAG, IDENTIFICATION	213
-	-	-	1	1	-	1901094-3	SPACER, FEEDER	198
-	-	-	-	-	2	21045-3	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
-	1	1	1	1	1	1-22281-8	SPRING, COMPRESSION	121
-	-	REF	REF	-	-	2119944-1	FEED FINGER ASSEMBLY, SF	117
¹³	-	1	1	1	1	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113
-	1	1	1	1	1	1-690438-0	FRONT STRIP GUIDE	96
-	2	2	2	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	95
-	1	1	1	1	1	2168083-6	SCR, SKT HD CAP, RoHS, M5 X 65	93
-	1	1	1	1	1	1-455888-1	SPACER, CRIMPER	82
-	2	2	2	2	2	2079383-4	SCR, BHSC, RoHS (M4 X 8)	79
-	1	1	1	1	1	1803096-1	EXTENSION PLATE	78
-	1	1	1	1	1	2119956-1	DOCUMENTATION PACKAGE	71
-	1	1	1	1	1	2119791-7	DEPRESSOR, WIRE	70
-	1	1	1	1	1	2119943-1	WASHER, SPACER	69
-	1	-	-	-	1	2119740-1	TAG, IDENTIFICATION	67
-	2	2	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	1	-	-	-	1	2119793-1	LIMITER, ADJUSTMENT BOLT	63
⁶	-	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	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	4	2168400-1	SHCS, LOW HEAD, RoHS, M4 X 12	54
-	2	2	2	2	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	53
-	1	1	1	1	1	1803382-1	HOLD DOWN, SPRING LOADED	50
-	-	-	-	-	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	2161311-1	RAM, STEPPED, AMP STYLE, SIDE FEED	44
-	1	1	1	1	1	1-2079383-5	SCR, BHSC, RoHS (M8 X 40)	41
-	1	-	-	-	1	2119645-1	DISC, NUMBERED FA WIRE ADJUSTMENT	40
-	1	-	-	-	1	2119957-1	APPLICATOR SHIM PACK	39
-	1	1	1	1	1	1-2119644-3	RAM WASHER, PRECISION	38
⁶	-	1	1	1	1	2119085-1	FA HEAD, ATLANTIC STYLE	37
⁷	-	1	-	-	1	2119092-1	BOLT, ADJUSTMENT	35
-	1	1	1	1	1	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	1320908-2	SPACER, STRIP GUIDE	30
-	1	1	1	1	1	2-1901086-7	PLATE, STRIP GUIDE	29
-	1	1	1	1	1	455888-5	SPACER, CRIMPER	28
-	2	2	2	2	2	22283-1	SPRING, COMPRESSION	27
-	1	1	1	1	1	356835-1	LEVER, DRAG RELEASE	26
-	1	1	1	1	1	240792-1	DRAG, TERMINAL	25
-	1	1	1	1	1	1320928-4	STRIP GUIDE	24
-	1	1	1	1	1	980371-4	SCR, SKT HD SHLDR 5.0 DIA X 6.0	23
-	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
¹¹	-	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	454276-5	FLOATING SHEAR, FRONT	9
¹¹	1	1	1	1	1	2-1803250-4	ANVIL, COMBINATION	8
-	-	-	-	-	-	-	-	7
-	-	-	-	-	-	-	-	6
-	1	1	1	1	1	2119757-8	DEPRESSOR, SHEAR	5
-	1	1	1	1	1	2-238011-7	BLOCK, CRIMPER SPACER	4
¹¹	1	1	1	1	1	1803246-1	CRIMPER, INSULATION F PREMIUM	3
-	1	1	1	1	1	455888-1	SPACER, CRIMPER	2
¹¹	1	1	1	1	1	1803482-6	CRIMPER, WIRE	1
-77	-7	-6	-5	-2	-2	PART NO	DESCRIPTION	ITEM NO

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		OWN		CHK		APVD		NAME	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	M. RILEY	04APR2017	T. BROOKENS	04APR2017	T. BROOKENS	04APR2017
MATERIAL		FINISH		WEIGHT		SCALE		SHEET		REV	
-		-		-		A1 00779		C=2836647		A	

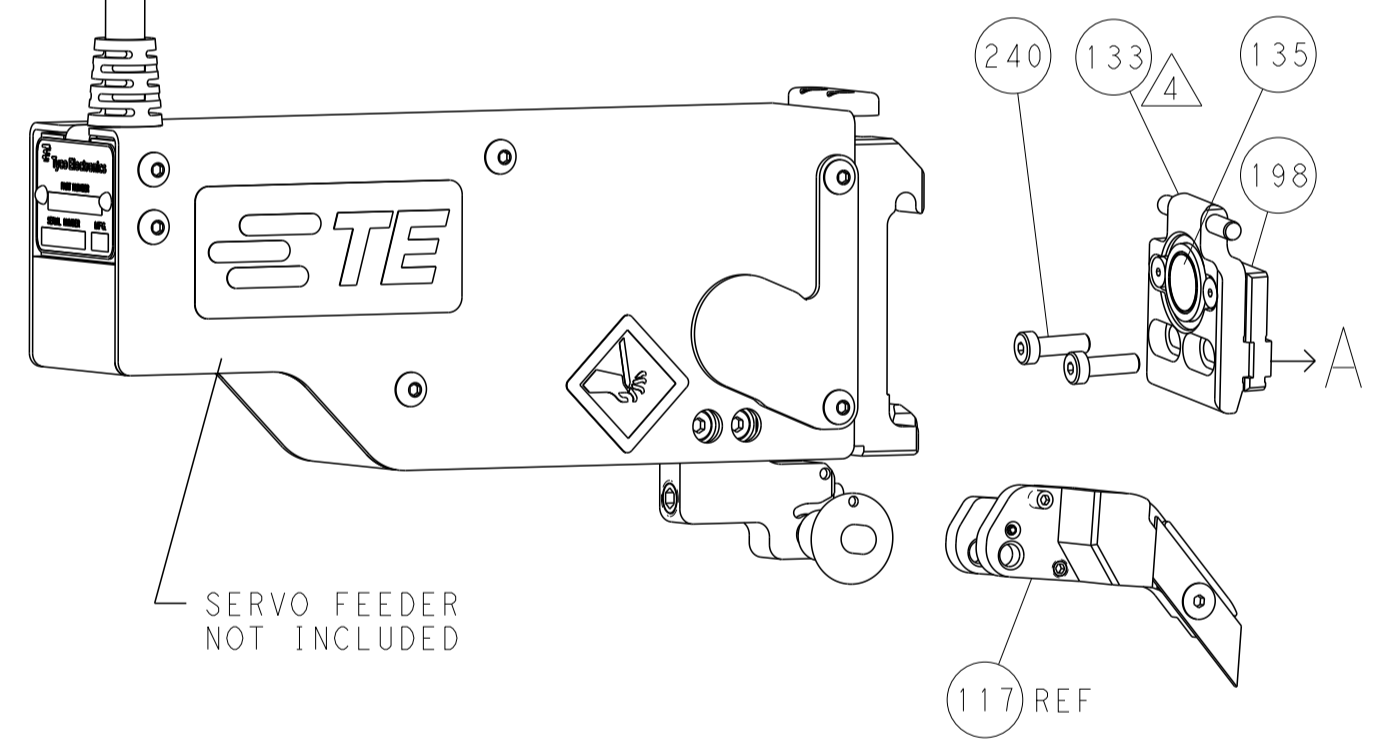
LOC	DIST	REVISIONS			
P	LTN	DESCRIPTION	DATE	OWN	APVD
-	-	SEE SHEET 1	-	-	-

FEED TYPE

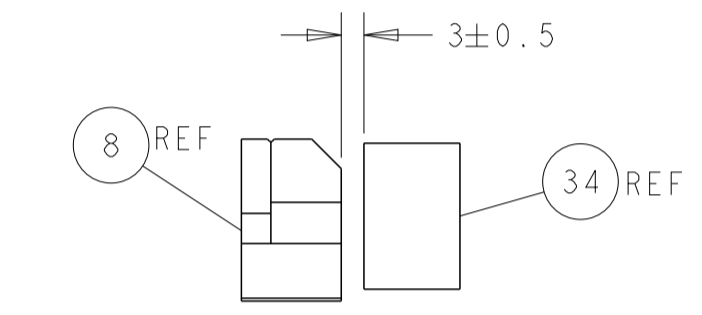
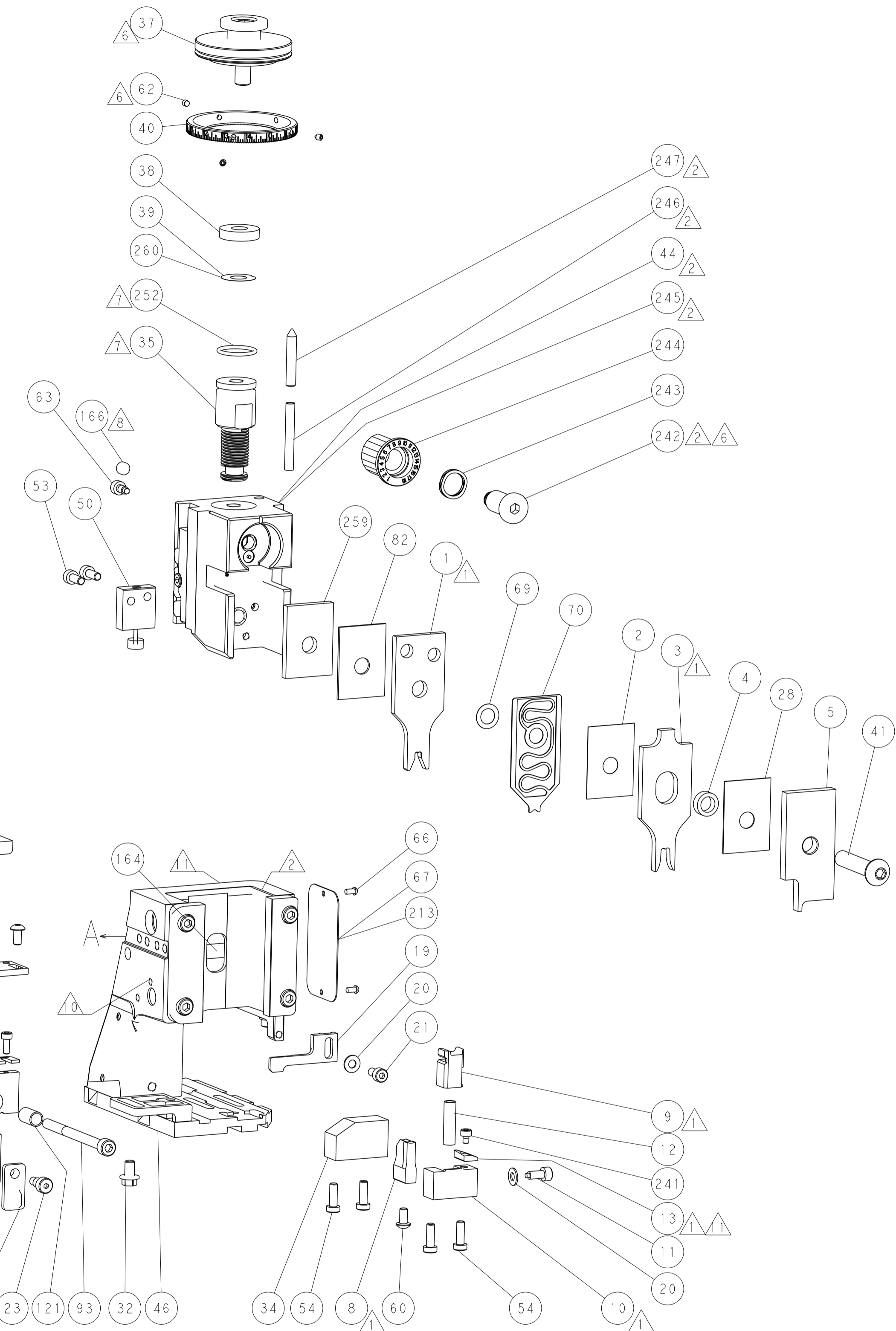
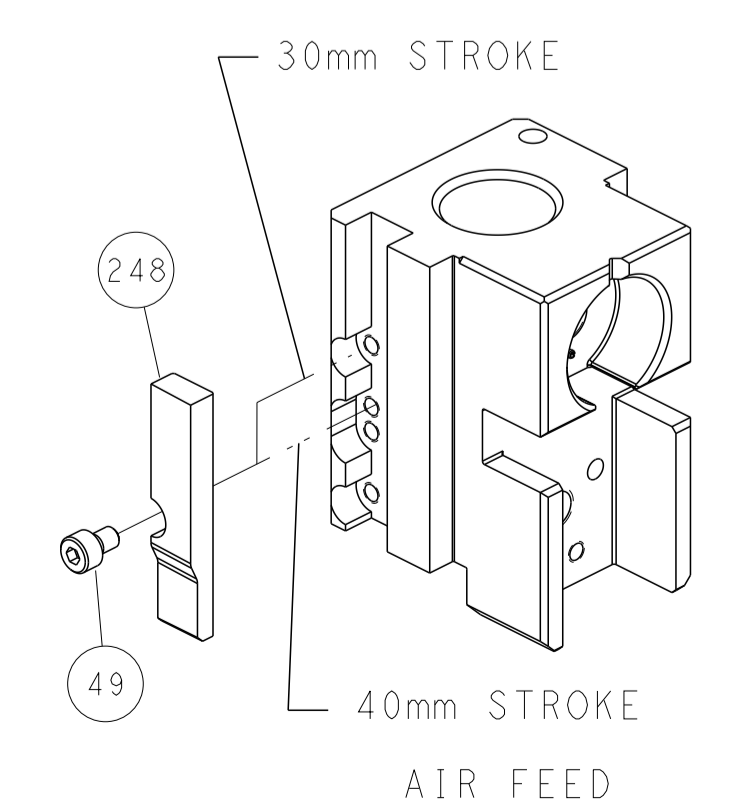
PNEUMATIC



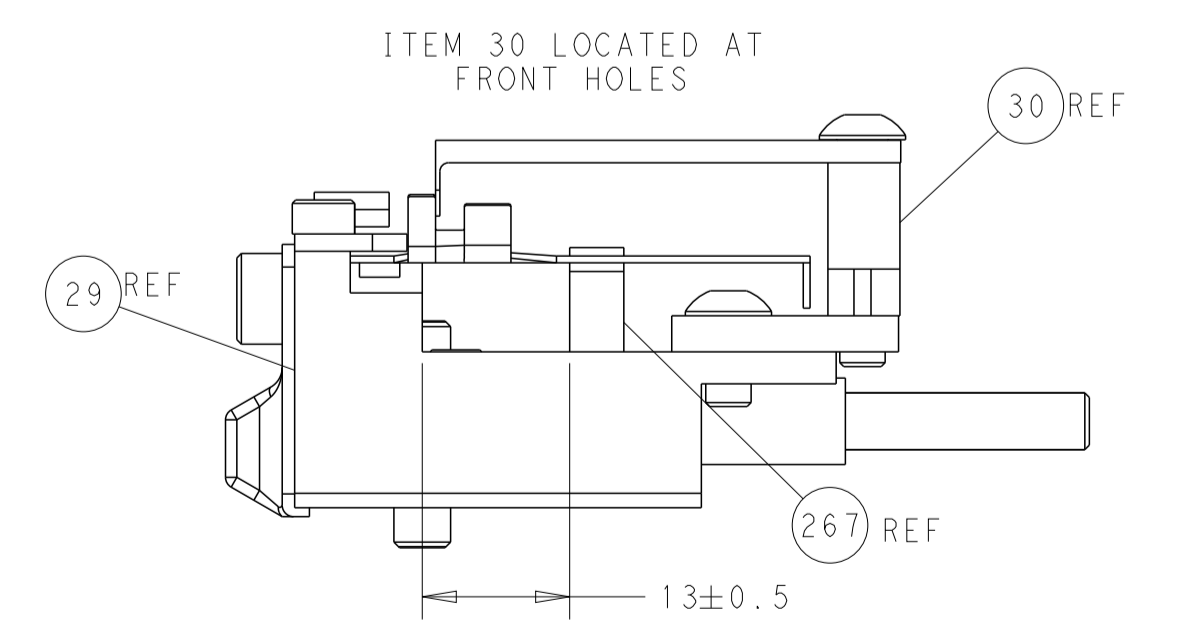
SERVO LATCH PLATE



CAM POSITION



TERMINAL SUPPORT LOCATION



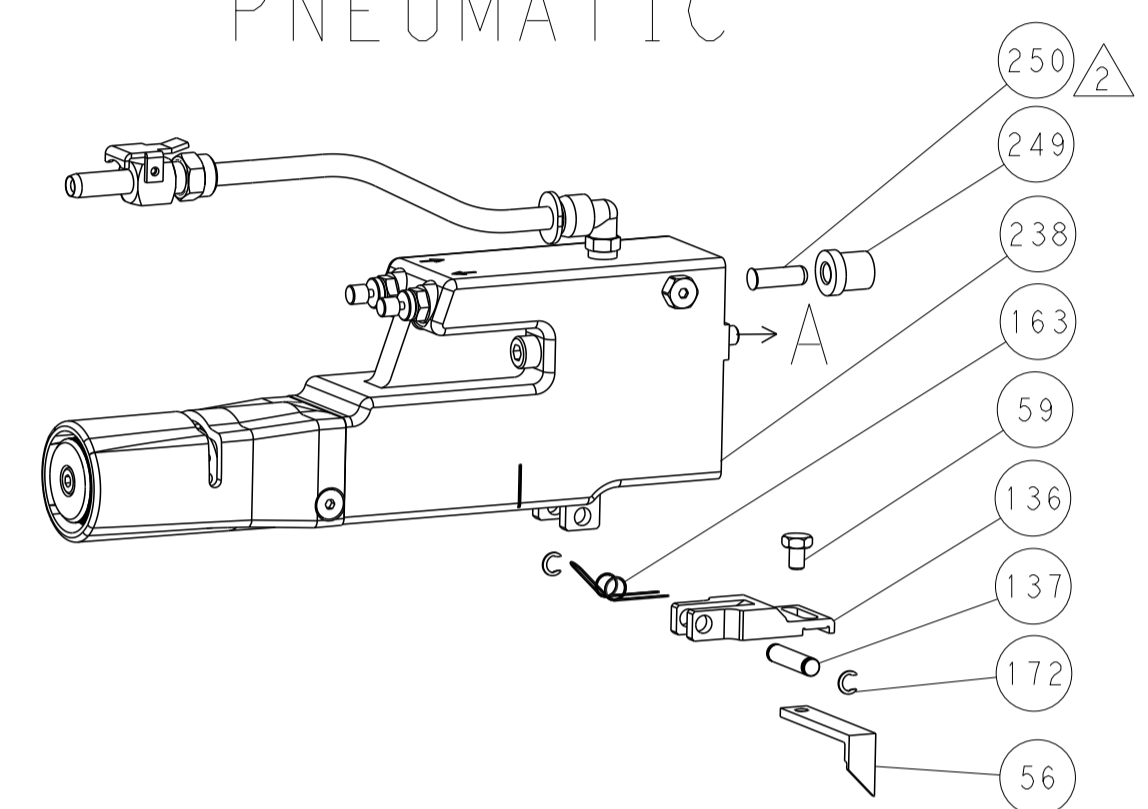
FEED TRACK POSITION GUIDE BY INSULATION BARREL

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

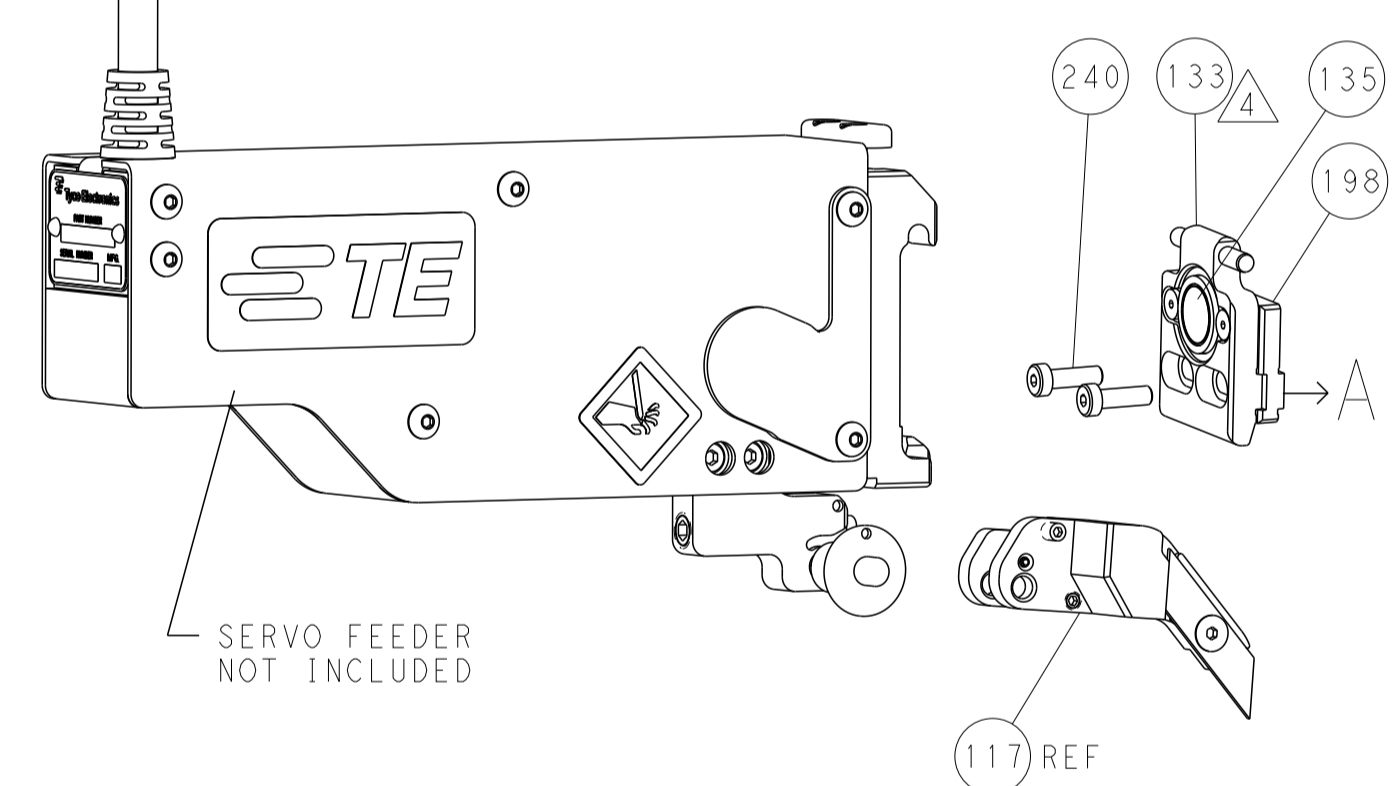
DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH ±		DWN M. RILEY 04APR2017 CHK T. BROOKENS 04APR2017 APVD J. ELBIN 04APR2017 PRODUCT SPEC APPLICATION SPEC WEIGHT SCALE 1:2		NAME Ocean Side Feed Applicator SIZE CAGE CODE DRAWING NO A1 00779 ©=2836647 RESTRICTED TO REV A	
Customer Accessible Production Drawing				SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION			

LOC	DIST	REVISIONS			
P	LTN	DESCRIPTION	DATE	DMN	APVD
-	-	SEE SHEET 1	-	-	-

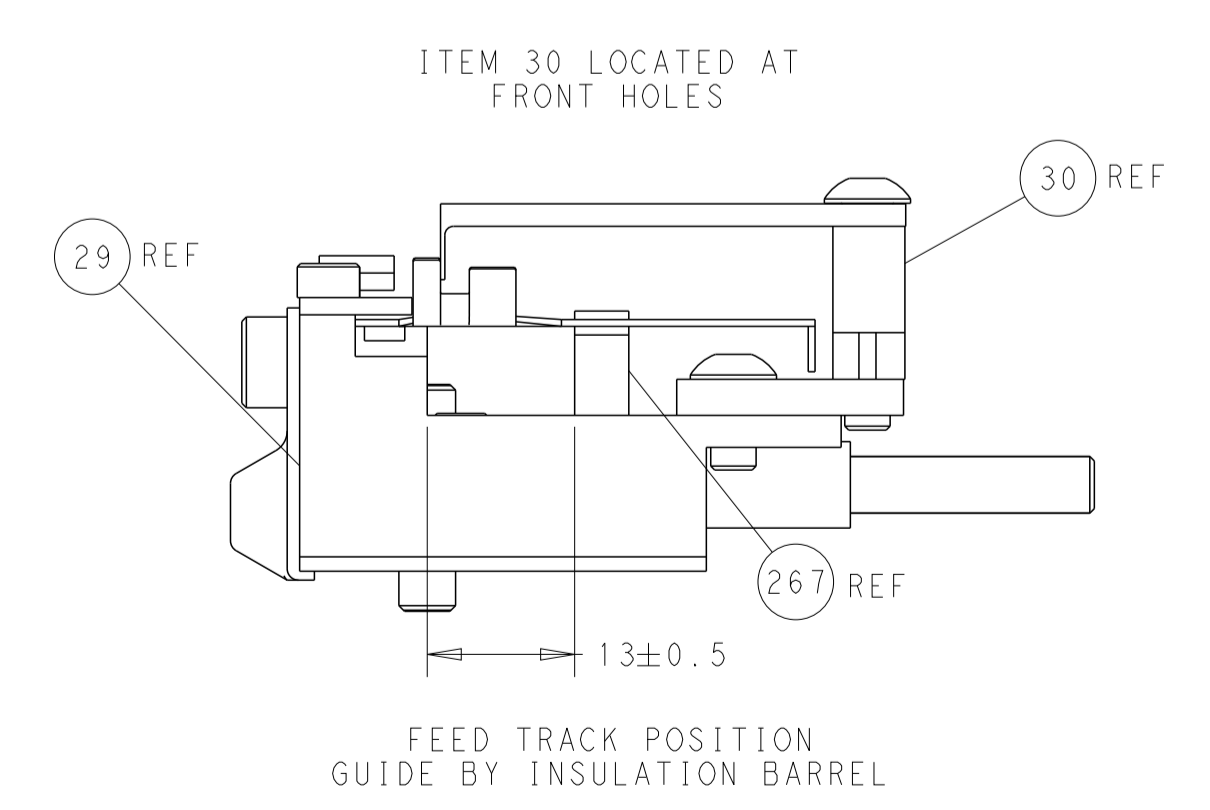
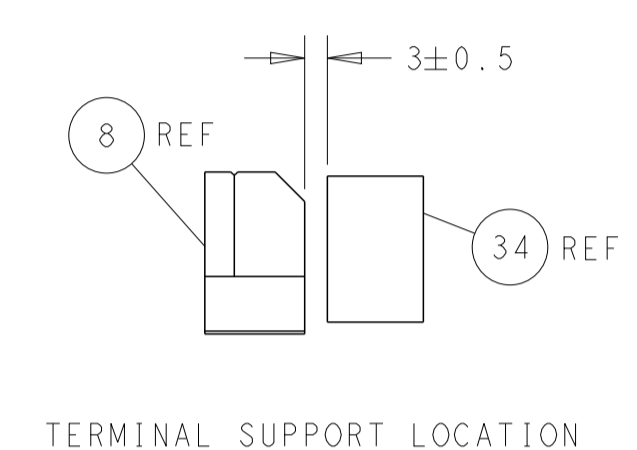
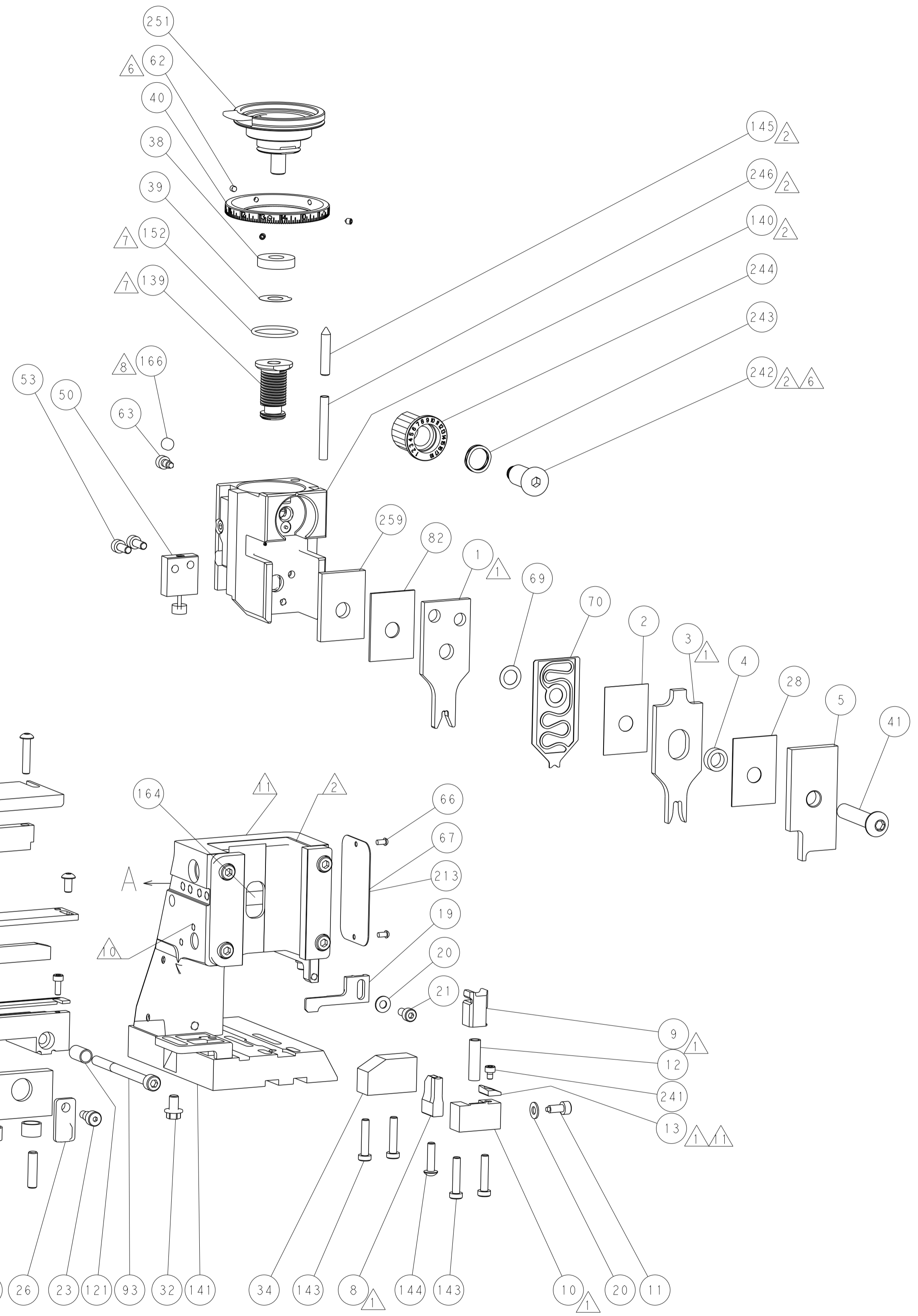
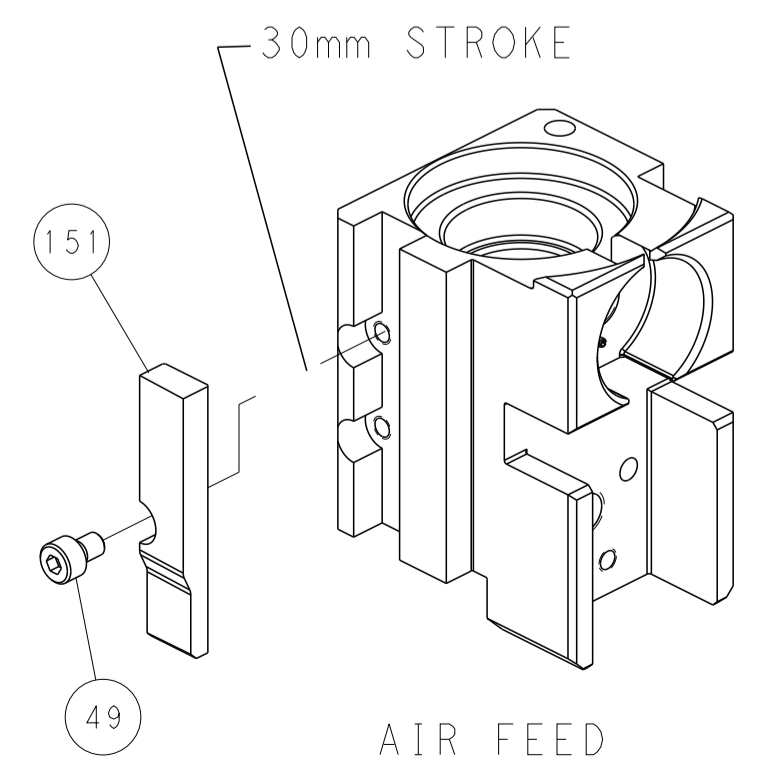
FEED TYPE PNEUMATIC



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)

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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: A CAGE CODE: 00779 DRAWING NO: 2836647	RESTRICTED TO:
MATERIAL:		WEIGHT:	SCALE: 1:2 SHEET: 4 OF 4 REV: A