

LOC	DIST	REV	DATE	BY	APP'D
A	66				

FEED TYPE MECHANICAL



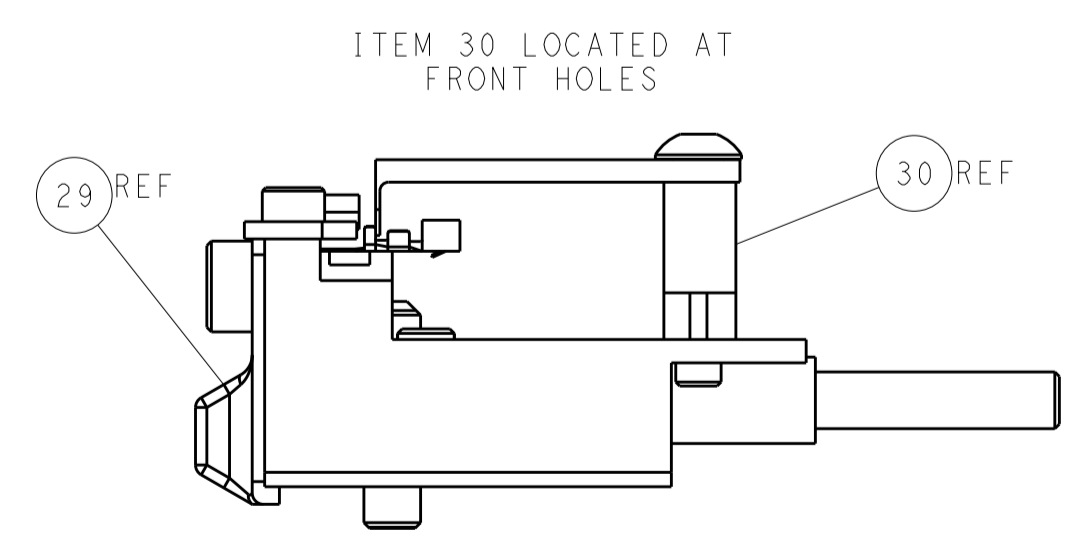
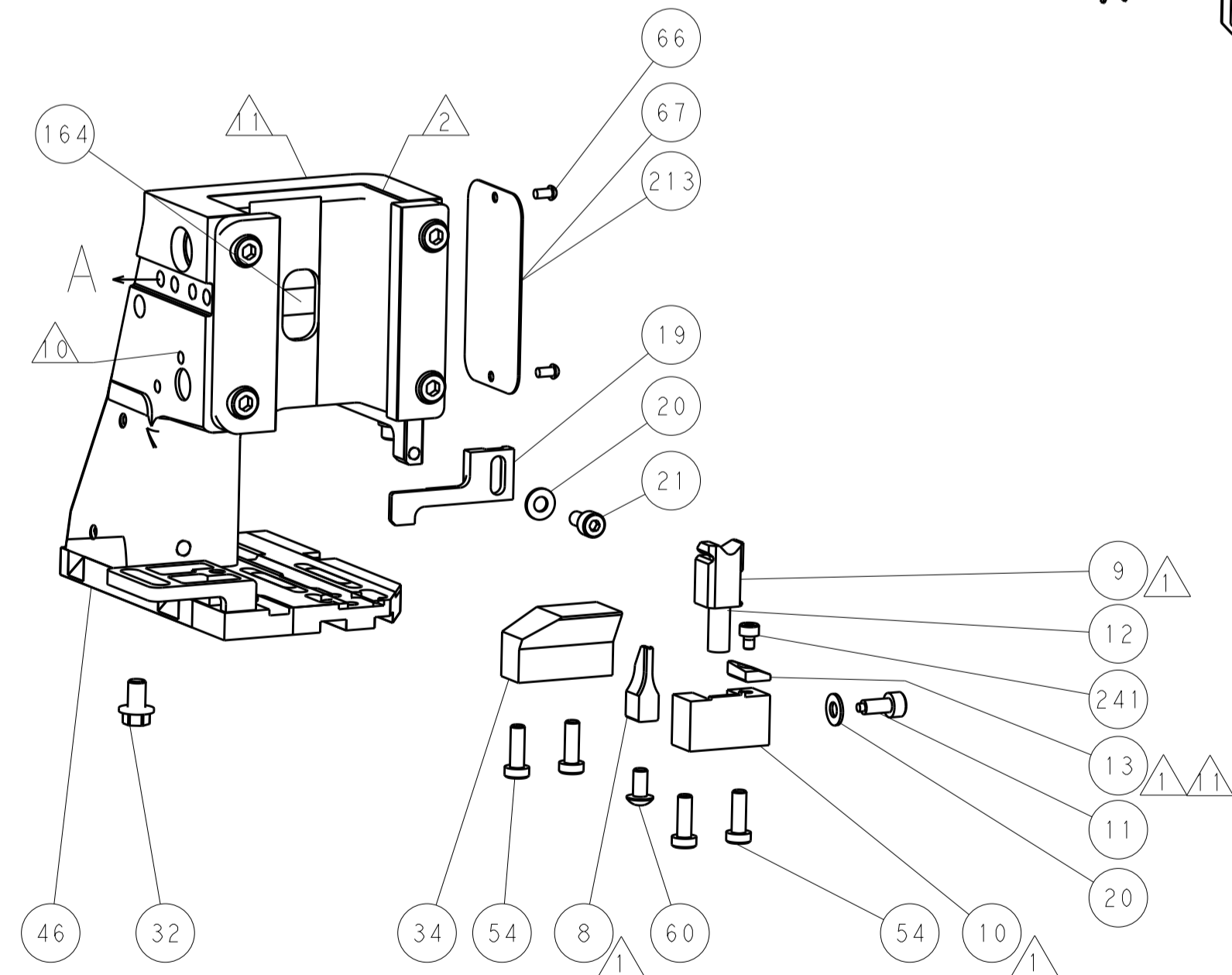
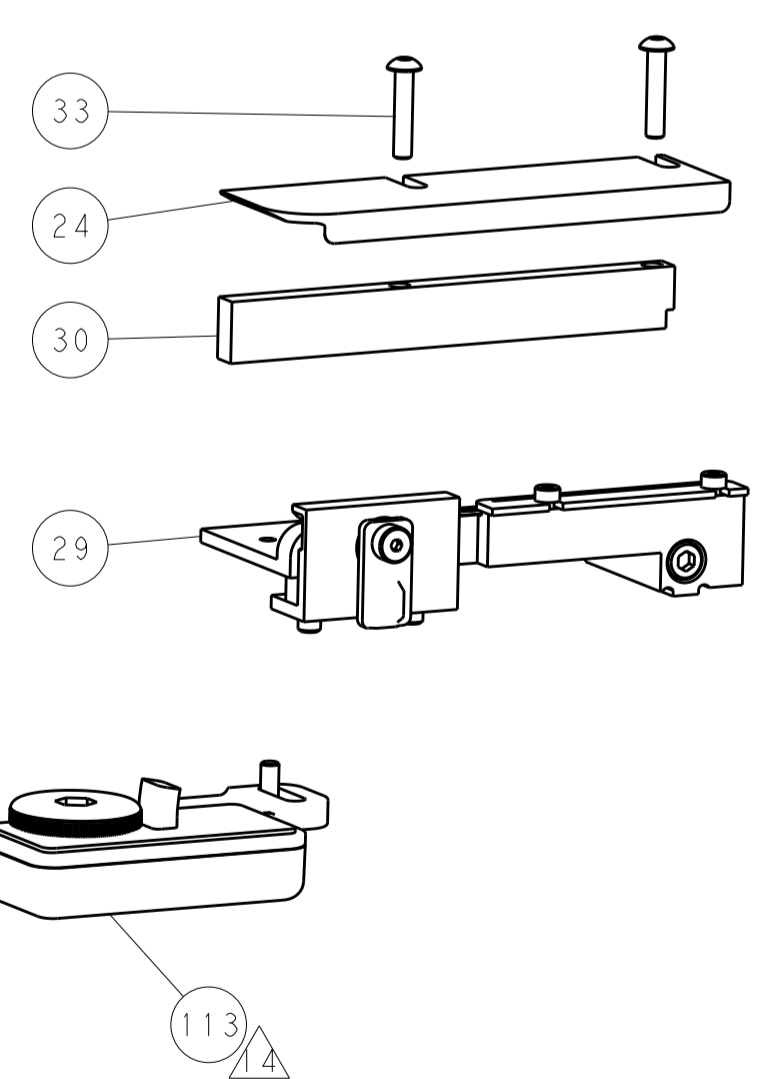
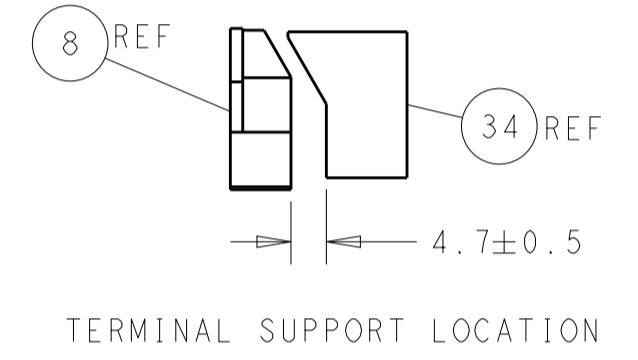
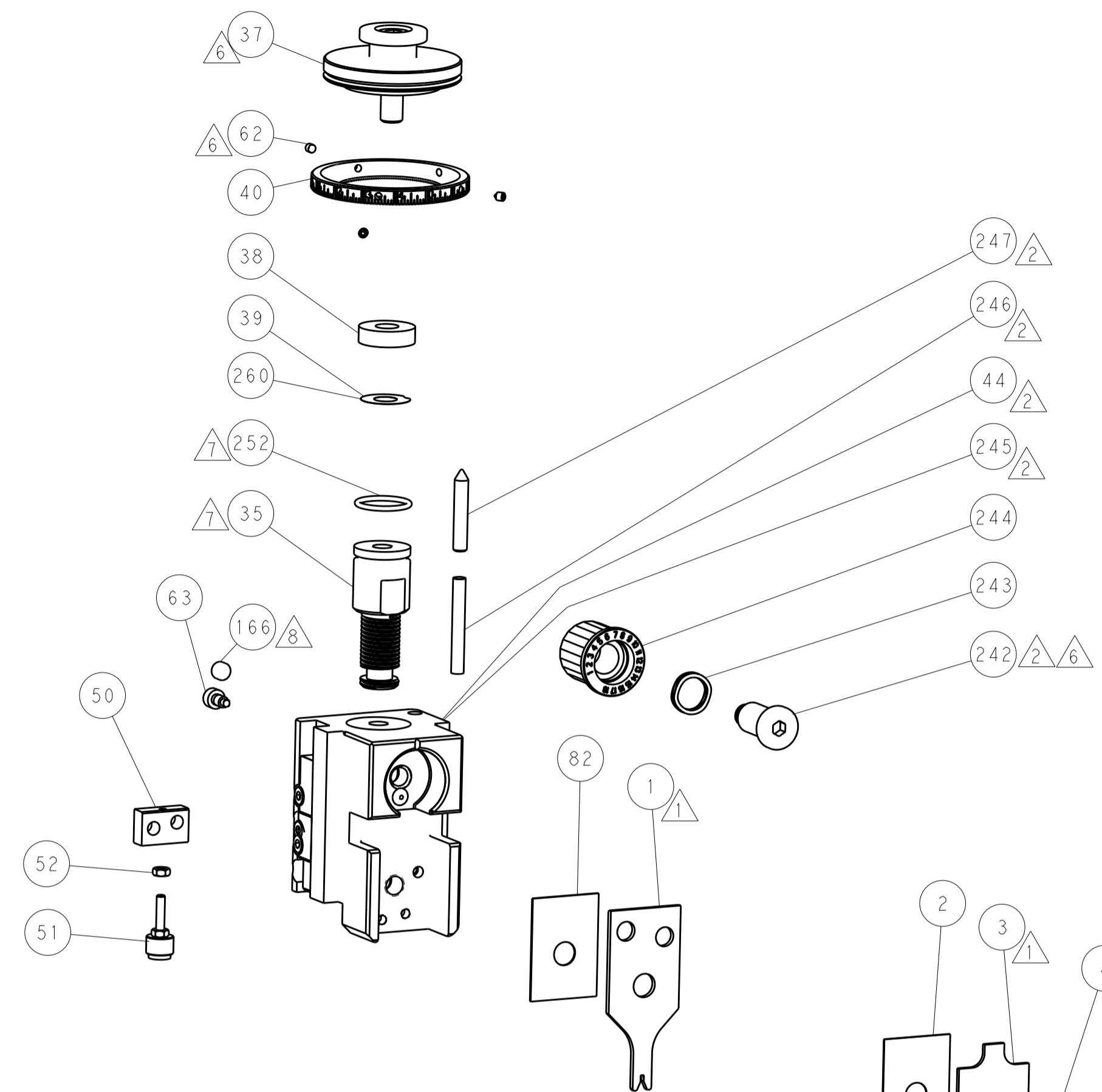
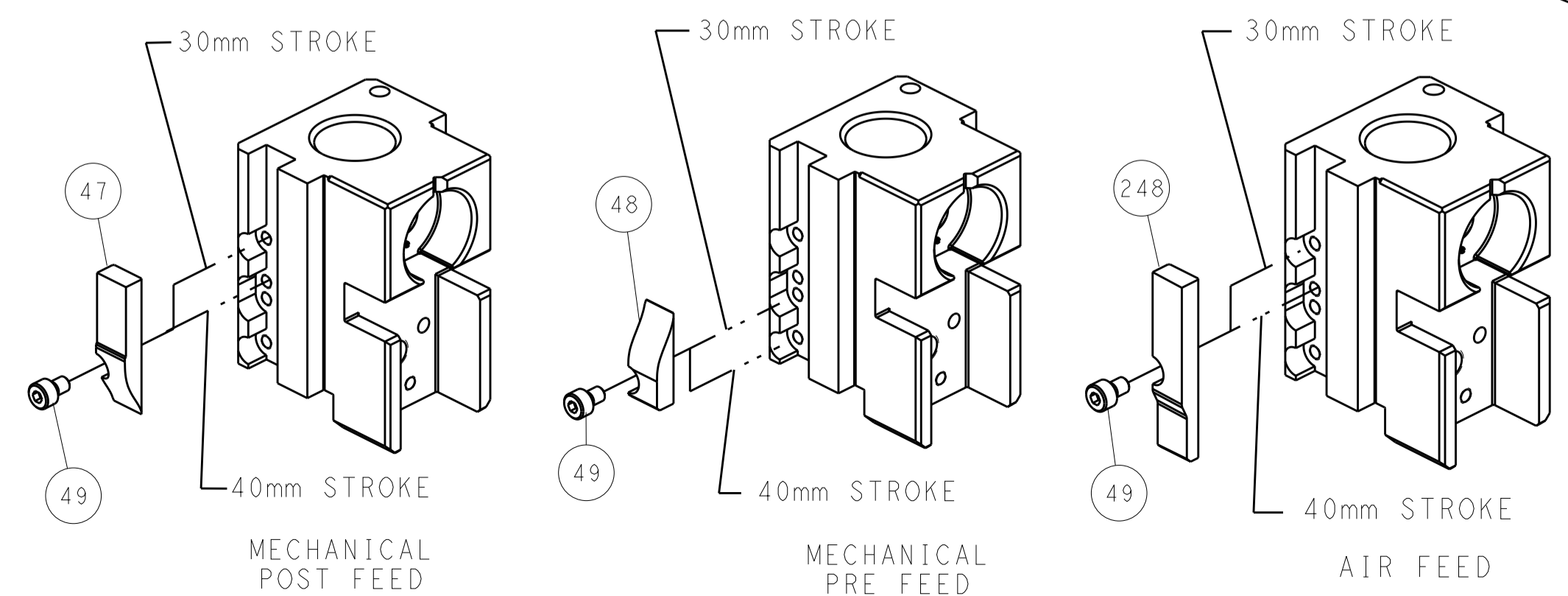
PNEUMATIC



SERVO LATCH PLATE



CAM POSITIONS



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 ±		DWN F. LIANG 11JUL2018 CHK K. ZHANG 11JUL2018 APVD K. ZHANG 11JUL2018 PRODUCT SPEC APPLICATION SPEC WEIGHT Customer Accessible Production Drawing		NAME Ocean Side Feed Applicator SIZE CAGE CODE DRAWING NO A1 00779 C=2837334 SCALE 1:2 SHEET 2 OF 4 REV A		TE Connectivity Harrisburg, PA 17105-3608 RESTRICTED TO	
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PACIFIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART						
					CONVERT TO	PART NUMBERS REQUIRED					
	2-2837334-1	A	FINE CRIMP HEIGHT ADJUST	MECHANICAL	PNEUMATIC FEED	2119950-1	1338685-1	5-18022-5	2119641-2	2119799-1	2063440-1
					SERVO LATCH PLATE	2119951-1	-	8-2837334-5	1901094-3	-	2168400-6 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2837334-4	-	-	
	2-2837334-2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-2	-	-
					SERVO LATCH PLATE	2119951-1	-	8-2837334-5	1901094-3	-	2168400-6 (QUANTITY 2)
2-2837334-5	A	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE	MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-2	-	-	
2-2837334-7	A	FINE CRIMP HEIGHT ADJUST	NONE	PNEUMATIC FEED	2119950-1	1338685-1	5-18022-5	2119641-2	2119799-1	2063440-1	
7-2837334-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-	

CRIMP	SIZE	TYPE
WIRE	1.07 mm [.042]	F
INSUL	2.03 mm [.080]	F
APPLICATOR INSTRUCTIONS 408-10389		

TERMINAL DATA: CONEXCON TERMINAL		TE CRIMP SPECIFICATION
TERMINAL NAME: LATERAL CARRIER CRIMPING TERMINAL		
WIRE STRIP LENGTH	TERMINAL INSULATION DIAMETER RANGE	
2.44-3.20 mm [.096-.126 IN]	Ø 1.90 mm MAX [.075 IN MAX]	
TERMINAL APPLICATION SPECIFICATION	NONE	
TERMINALS APPLIED		
TE TERMINAL	CONEXCON TERMINAL	TE TERMINAL
3311258-1	2572-2000	

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
22 AWG	0.91 +/- 0.025 [.036 +/- .001]	7.4
24 AWG	0.84 +/- 0.025 [.033 +/- .001]	8.0
26 AWG	0.79 +/- 0.025 [.031 +/- .001]	8.5
28 AWG	0.76 +/- 0.025 [.030 +/- .001]	8.8

- 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: 8-2837334-4
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2837334-4
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2837334-5
- 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.
- 12. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT 101-35000.
- 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.

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			
2119599-1	A	66	REV	DATE	BY	APPV
			-	SEE SHEET 1		

REV	DATE	BY	APPV	DESCRIPTION	DATE	OWN	APPV
-	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	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	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	2079383-8	SCR, BHSC, RoHS (M4 X 16)		144
-	4	4	4	2168400-5	SHCS, LOW HEAD, RoHS, M4 X 20		143
-	-	-	1	2119653-2	FEED CAM, POST FEED		142
-	1	1	1	1-2119656-0	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
-	-	REF	-	2119944-1	FEED FINGER ASSEMBLY, SF		117
	1	1	1	2119955-1	ASSY, LUBRICATOR, SIDE FEED		113
-	1	1	1	455888-5	SPACER, CRIMPER		82
-	1	1	1	2119956-1	DOCUMENTATION PACKAGE		71
-	1	1	1	2119791-5	DEPRESSOR, WIRE		70
-	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
-	-	-	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0		59
-	-	-	1	1338685-1	PAWL, FEED		56
-	2	2	2	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0		53
-	1	1	1	5018030-1	NUT, HEX, REG, RoHS, M3		52
-	1	1	1	811242-5	BUMPER, HOLD DOWN		51
-	1	1	1	690753-6	SPACER, TONKER		50
-	-	-	1	18023-9	SCR, SKT HD CAP M4 X 6.0		49
-	-	-	1	2119652-1	FEED CAM, PRE FEED		48
-	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	2119644-1	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	2119959-1	ASSEMBLY, STRIP GUIDE		29
-	1	1	1	1320928-2	STRIP GUIDE		24
-	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	2119533-9	STRIPPER, SIDE FEED		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	1803095-1	FLOATING SHEAR, FRONT		9
	1	1	1	2-1803537-8	ANVIL, COMBINATION		8
-	-	-	-	-	-		7
-	-	-	-	-	-		6
-	1	1	1	2119757-4	DEPRESSOR, SHEAR		5
-	1	1	1	1-238011-3	BLOCK, CRIMPER SPACER		4
	1	1	1	1803709-2	CRIMPER, INSULATION F PREMIUM		3
	1	1	1	455888-4	SPACER, CRIMPER		2
	1	1	1	1803224-9	CRIMPER, WIRE		1

DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		OWN: F. LIANG 11JUL2018	NAME: Ocean Side Feed Applicator
		0 PLC ±	1 PLC ±	CHK: K. ZHANG 11JUL2018	
		2 PLC ±	3 PLC ±	APPV: K. ZHANG 11JUL2018	SIZE: A1
		4 PLC ±	ANGLES ±	PRODUCT SPEC	CAGE CODE: 00779
		FINISH	FINISH	APPLICATION SPEC	DRAWING NO: C-2837334
MATERIAL:				WEIGHT:	RESTRICTED TO:
				SCALE: 1:2	SHEET 3 OF 4
				Customer Accessible Production Drawing	REV A

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

FEED TYPE MECHANICAL



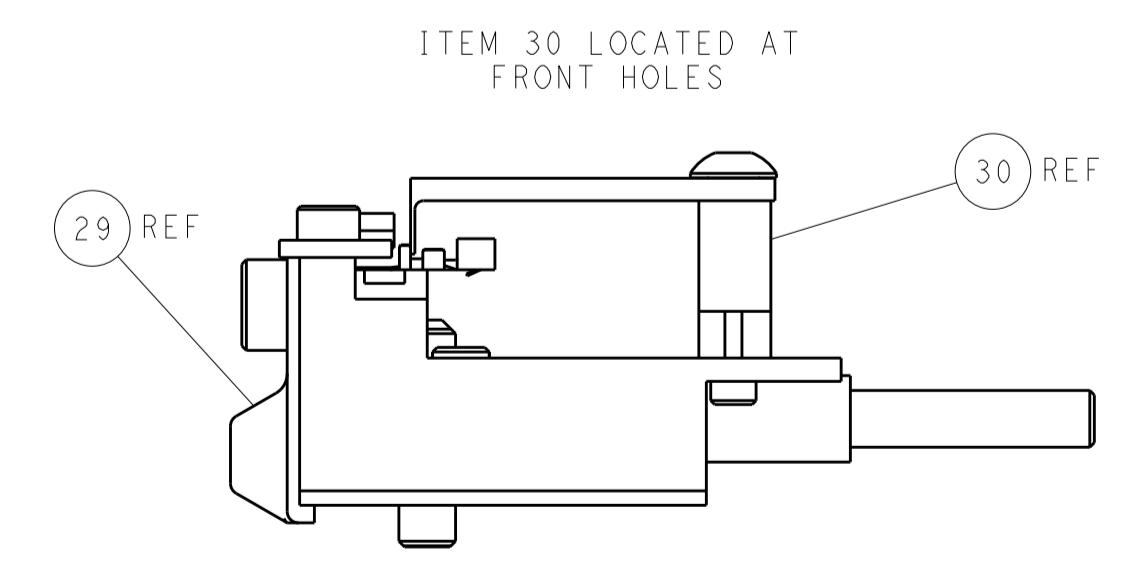
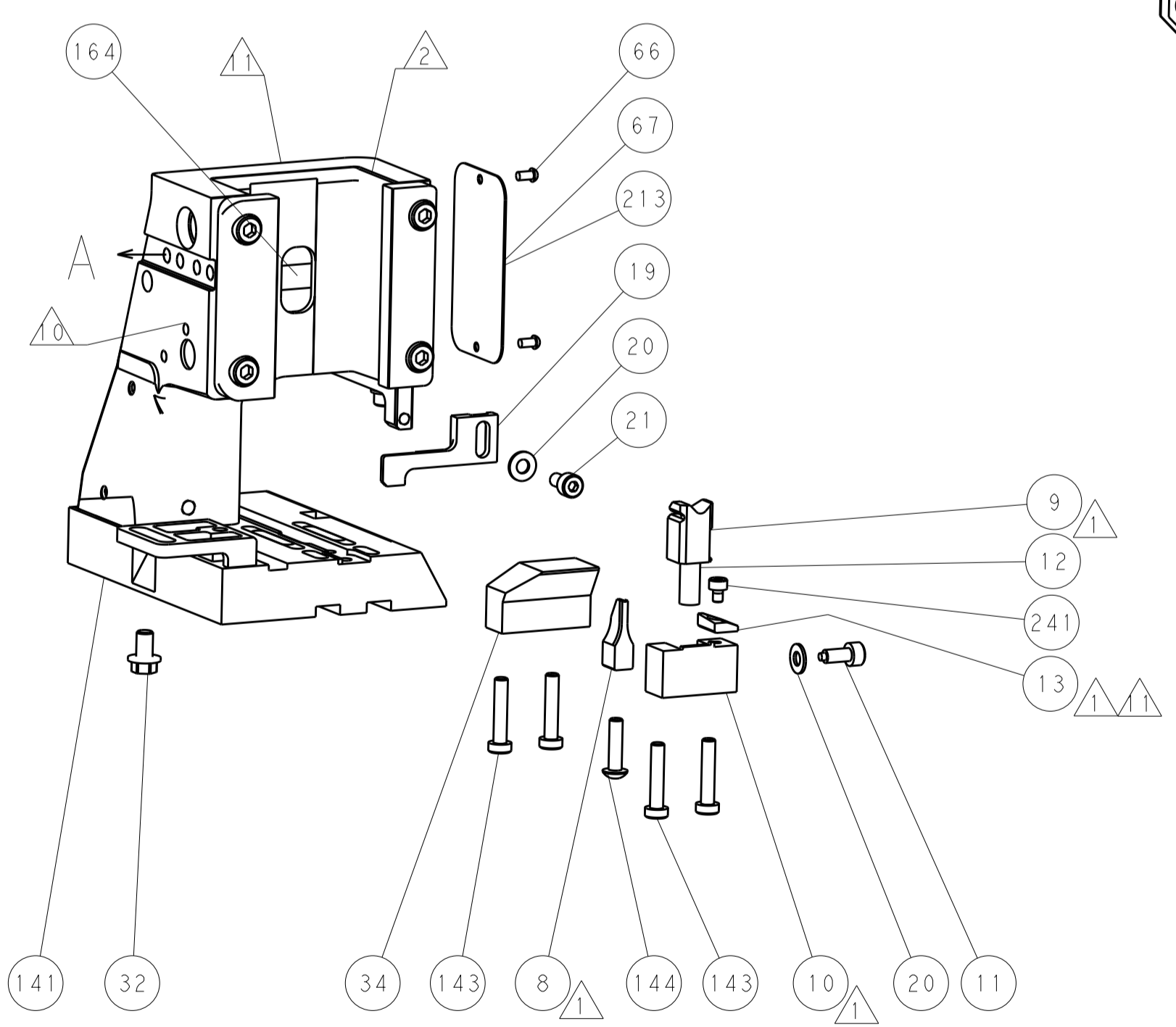
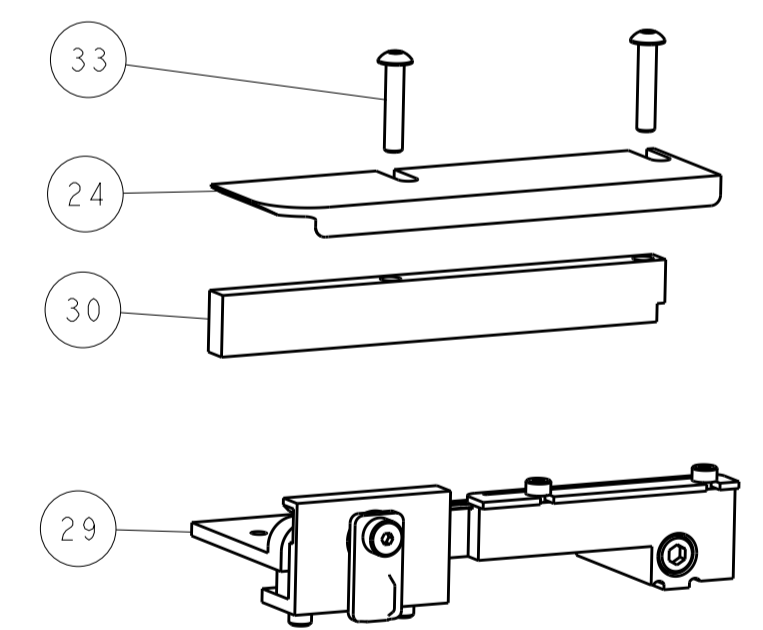
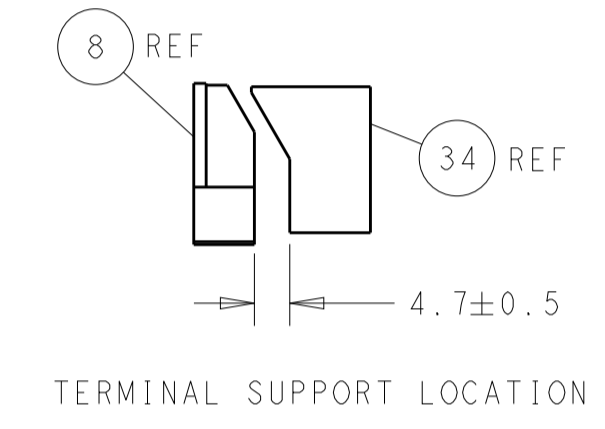
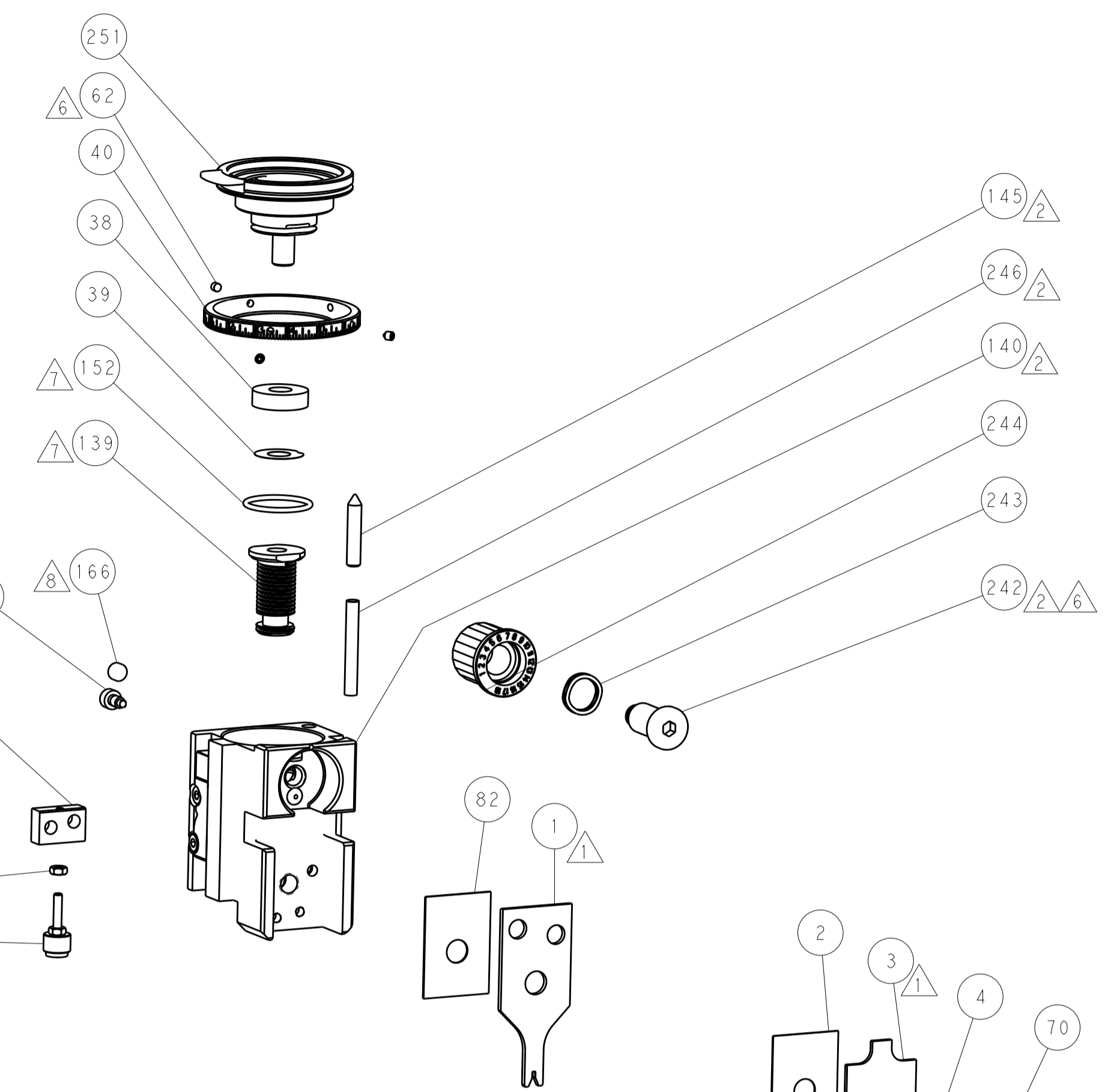
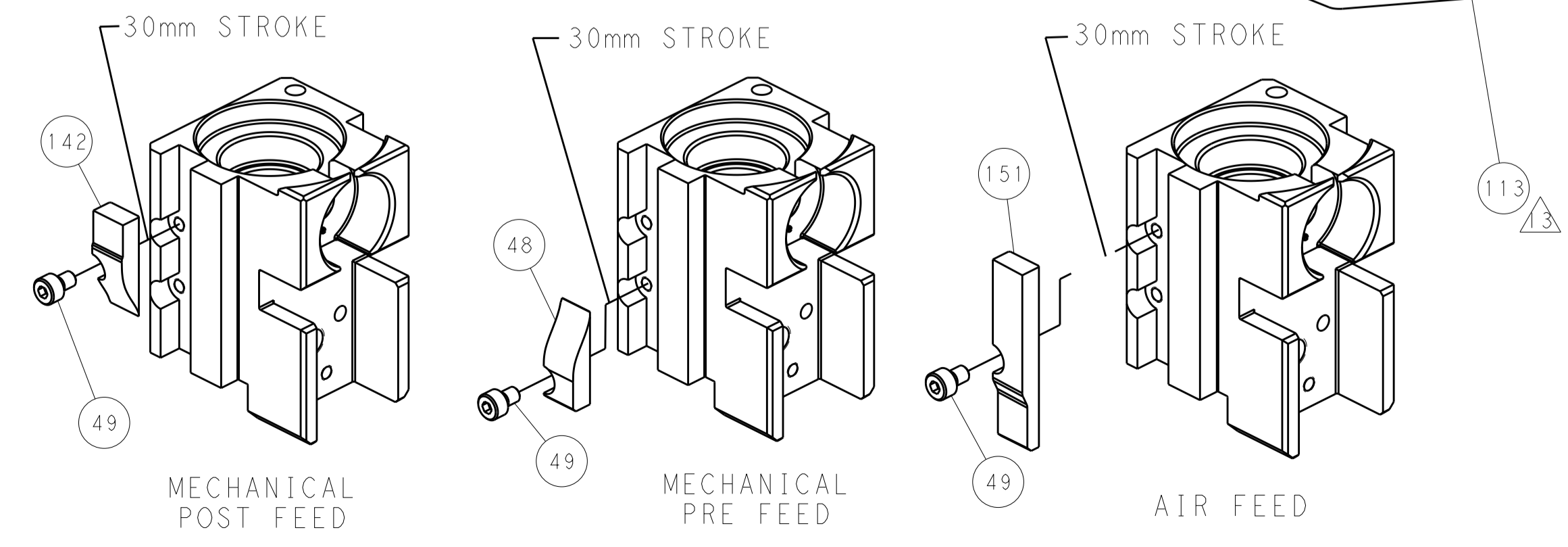
PNEUMATIC



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:		DWN F. LIANG 11 JUL 2018		TE Connectivity Harrisburg, PA 17105-3608	
mm	0 PLC	±		CHK K. ZHANG 11 JUL 2018	NAME	Ocean Side Feed Applicator	
	1 PLC	±		APVD K. ZHANG 11 JUL 2018	PRODUCT SPEC	RESTRICTED TO	
	2 PLC	±			APPLICATION SPEC	SIZE CAGE CODE DRAWING NO	
	3 PLC	±				A1 00779 ©=2837334	
	4 PLC	±			WEIGHT	SCALE 1:2 SHEET 4 OF 4 REV A	
	ANGLES	±				Customer Accessible Production Drawing	