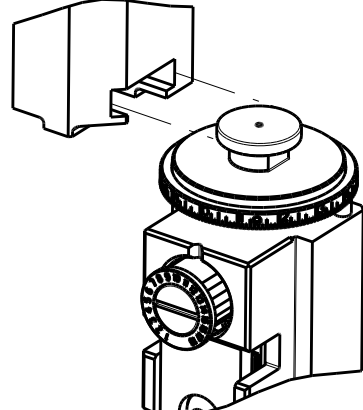


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ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER		PART NUMBER	REVISION	DESCRIPTION
	2836115-2	A	FINE CRIMP HEIGHT ADJUST	
	2836115-5	A	FINE CRIMP HEIGHT ADJUST	
	2836115-6	A	NON-CRIMP HEIGHT ADJUST	
	2836115-7	A	FINE CRIMP HEIGHT ADJUST	
	7-2836115-7	A	CRIMP TOOLING KIT	

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	3.56 mm [1.140]	F
INSUL	5.08 mm [1.200]	F
APPLICATOR INSTRUCTIONS 408-10389		

TERMINAL DATA: ETCO TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: TERMINAL			
WIRE STRIP LENGTH			INSULATION DIAMETER RANGE
4.90-5.66 mm [1.93-.223 IN]			Ø3.18-5.08 mm [1.25-.200 IN]
TERMINAL APPLICATION SPECIFICATION		NONE	-
		-	-
TERMINALS APPLIED 			
TE TERMINAL	ETCO TERMINAL	TE TERMINAL	ETCO TERMINAL
2113924-1	07956[D263N-HB]	2113924-2	07957[D263N-THB]

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
10 AWG	2.78+/-0.05 [1.109+/-0.002]	5.7
12 AWG	2.39+/-0.05 [1.094+/-0.002]	9.5
2 x 16 AWG	2.15+/-0.05 [1.085+/-0.002]	12.1
14 AWG	2.11+/-0.05 [1.083+/-0.002]	12.7



- 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: 8-2836115-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2836115-5
SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2836115-6
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 ITEMS 62 & 180.
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 & 180.
- 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 3.02.

*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.

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 2119599-1	LOC A	DIST 66	REVISIONS			
			P	LTR	DESCRIPTION	DATE
				A	RELEASED	17DEC2015

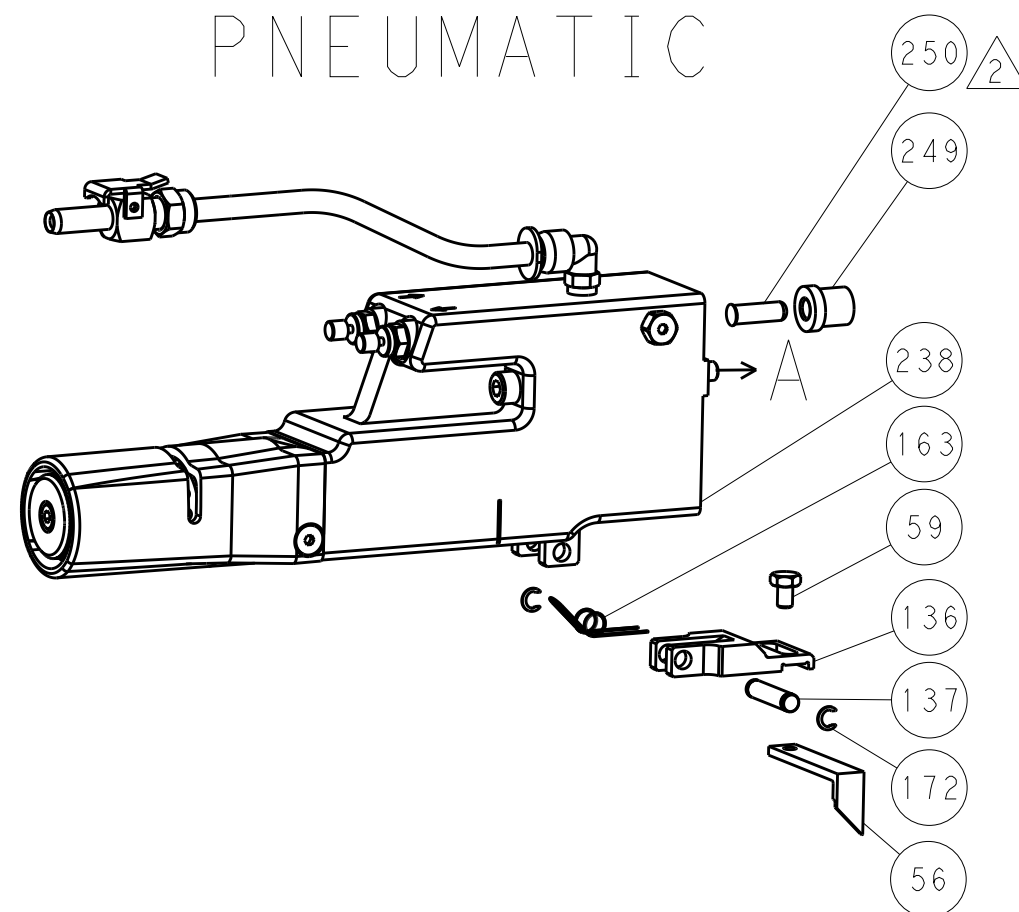
6	-	-	1	-	-	2119957-2	APPLICATOR SHIM PACK	260
	-	1	-	1	1	8-21084-0	O-RING, .676 ID, .070 DIA MAT.	252
	-	-	-	-	1	2119640-1	PUSH ROD, AIR FEED	250
	-	-	-	-	1	2079988-1	BUSHING, LCH5-12, MISUMI	249
	-	-	-	-	1	2119641-1	FEED CAM, AIR FEED	248
	-	1	-	1	1	2119798-1	DETENT PIN	247
	-	1	-	1	1	1-22279-3	SPRING, COMPRESSION	246
	-	-	1	-	-	2119758-1	RAM, AMP STYLE, SIDE FEED, NON-ADJ.	245
	-	1	1	1	1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244
	-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
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
	-	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
6	-	-	-	-	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
	-	-	REF	REF	-	2119944-1	FEED FINGER ASSEMBLY,SF	117
	-	1	1	1	1	455888-4	SPACER, CRIMPER	82
	-	1	1	1	1	2119956-1	DOCUMENTATION PACKAGE	71
	-	1	1	1	1	2119791-9	DEPRESSOR, WIRE	70
	-	1	-	-	1	2119740-1	TAG,IDENTIFICATION	67
	-	2	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
6	-	1	-	1	1	2119793-1	LIMITER, ADJUSTMENT BOLT	63
	-	3	-	3	3	992763-5	SCR, SET, SOC, CONE POINT, M3 x 4.0	62
	-	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	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	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
6	-	-	-	-	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	2119644-3	RAM WASHER, PRECISION	38
	-	1	1	1	1	2119085-1	FA HEAD, ATLANTIC STYLE	37
	-	1	-	1	1	2119092-1	BOLT, ADJUSTMENT	35
	-	1	1	1	1	1752356-3	SUPPORT, TERMINAL	34
1	-	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	2119959-2	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	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	1803250-2	ANVIL, COMBINATION	8
	-	-	-	-	-	-	-	7
	-	-	-	-	-	-	-	6
	-	1	1	1	1	2119757-8	DEPRESSOR, SHEAR	5
	-	1	1	1	1	238011-2	BLOCK, CRIMPER SPACER	4
	1	1	1	1	1	5-1633961-1	CRIMPER, INSULATION F PREMIUM	3
1	-	1	1	1	1	455888-1	SPACER, CRIMPER	2
	1	1	1	1	1	456411-9	CRIMPER, WIRE PREMIUM	1

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DIMENSIONS:				CHK L. ZHANG 18NOV2015	NAME		
mm				APVD J. GUO 18NOV2015	Ocean Side Feed Applicator		
				PRODUCT SPEC	SIZE		
				APPLICATION SPEC	CAGE CODE		
MATERIAL				FINISH	DRAWING NO		
					00779		
					©=2836115		
					Customer Accessible Production Drawing		
					SCALE		
					1:2		
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					1 OF 4		
					REV		
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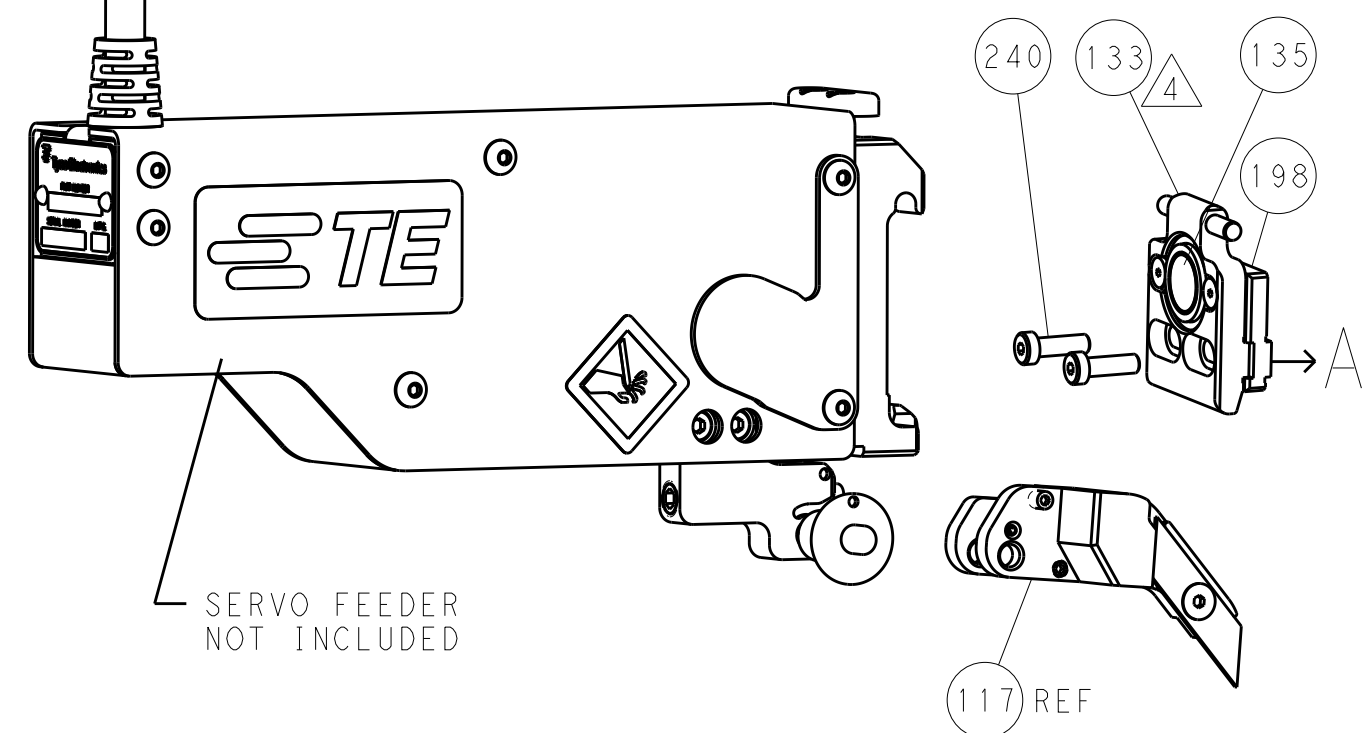
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		P	LTR	DESCRIPTION	DATE	DWN	APVD
A	66	-	-	SEE SHEET 1	-	-	-

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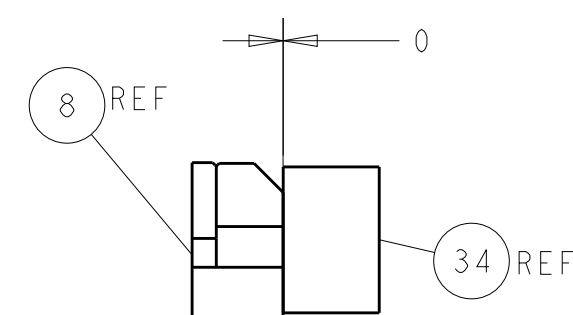
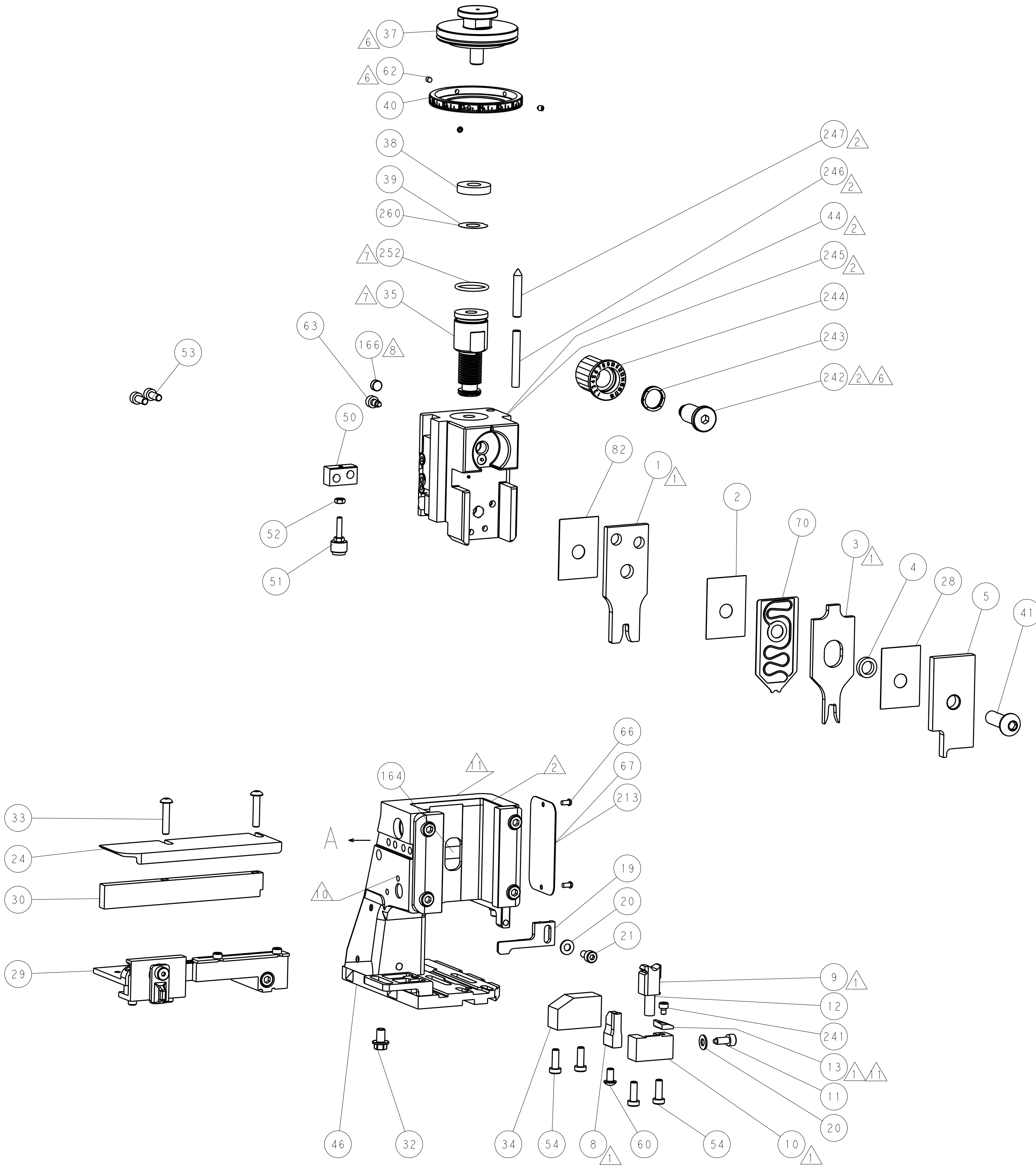
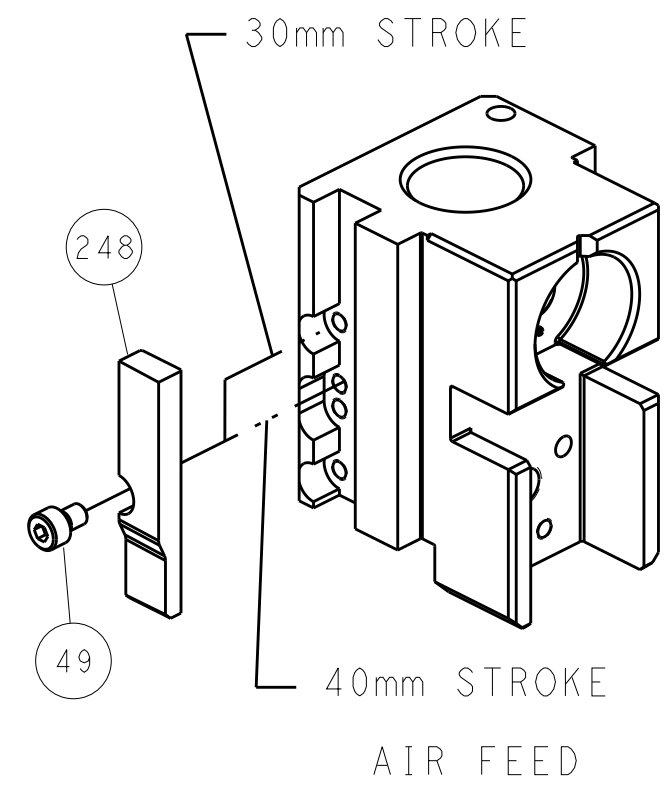
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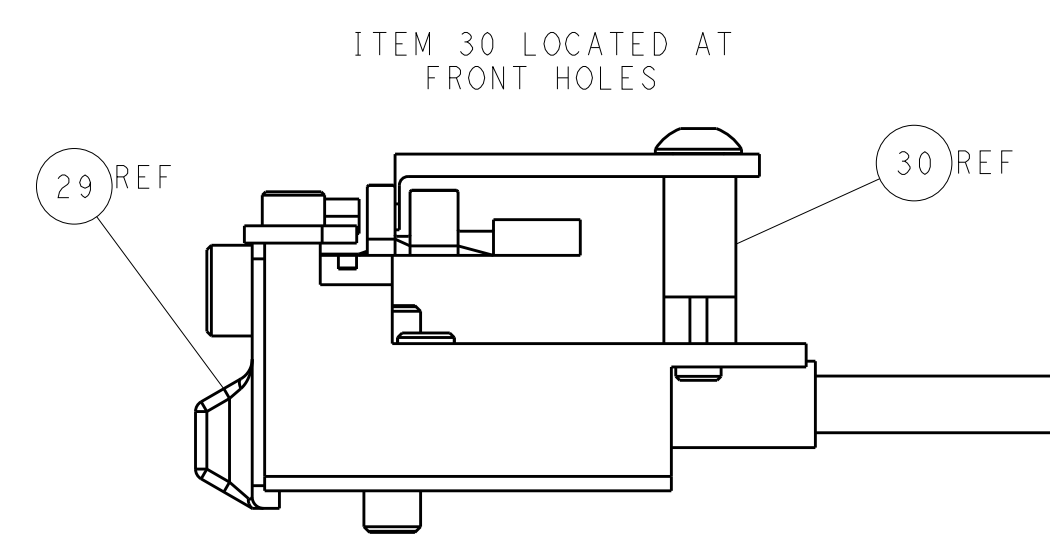
SERVO LATCH PLATE



CAM POSITION



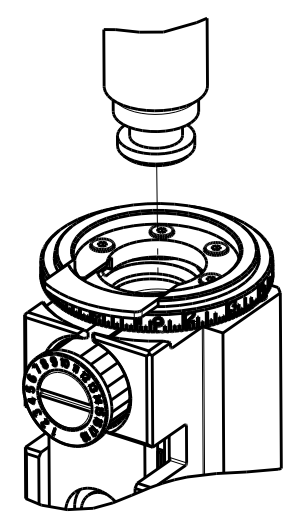
TERMINAL SUPPORT LOCATION



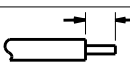
FEED TRACK POSITION GUIDE BY INSULATION BARREL

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

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DIMENSIONS:				CHK	L. ZHANG	18NOV2015					
mm				APVD	H. GUO	18NOV2015					
TOLERANCES UNLESS OTHERWISE SPECIFIED:				PRODUCT SPEC							
				APPLICATION SPEC			NAME	Ocean Side Feed Applicator			
				FINISH							
				MATERIAL							
				WEIGHT							
ANGLES				FINISH			SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO	
-				-			A	00779	C=2836115	-	
Customer Accessible Production Drawing											
								SCALE	1:2	SHEET	2 of 4
								REV A			

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PACIFIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION
	2-2836115-2	A	FINE CRIMP HEIGHT ADJUST
	2-2836115-5	A	FINE CRIMP HEIGHT ADJUST
	2-2836115-7	A	FINE CRIMP HEIGHT ADJUST
	7-2836115-7	A	CRIMP TOOLING KIT

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	3.56 mm [1.40]	F
INSUL	5.08 mm [2.00]	F
APPLICATOR INSTRUCTIONS  408-10389		

TERMINAL DATA: ETCO TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: TERMINAL			
WIRE STRIP LENGTH			INSULATION DIAMETER RANGE
4.90-5.66 mm [1.93-.223 IN]			Ø3.18-5.08 mm [1.25-.200 IN]
TERMINAL APPLICATION SPECIFICATION		NONE	-
		-	-
TERMINALS APPLIED 			
TE TERMINAL	ETCO TERMINAL	TE TERMINAL	ETCO TERMINAL
2113924-1	07956[D263N-HB]	2113924-2	07957[D263N-THB]

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING 
10 AWG		2.78+/-0.05 [1.109+/-0.002]		5.7
12 AWG		2.39+/-0.05 [1.094+/-0.002]		9.5
2 x 16 AWG		2.15+/-0.05 [1.085+/-0.002]		12.1
14 AWG		2.11+/-0.05 [1.083+/-0.002]		12.7

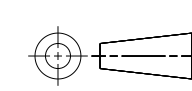


-  RECOMMENDED SPARE PARTS
-  GREASE BEARING SURFACES LIGHTLY
3. LUBRICATE DAILY PER THE APPLICATOR INSTRUCTION SHEET SUPPLIED WITH THE APPLICATOR.
-  APPLICATOR SPECIFIC DATA TO BE ENTERED INTO BLANK MEMORY CHIP AT ASSEMBLY. SEE BELOW FOR PART NUMBER:
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2836115-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2836115-5
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 ITEMS 62 & 180.
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.
-  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 BACK SIDE OF THE HOUSING. REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.

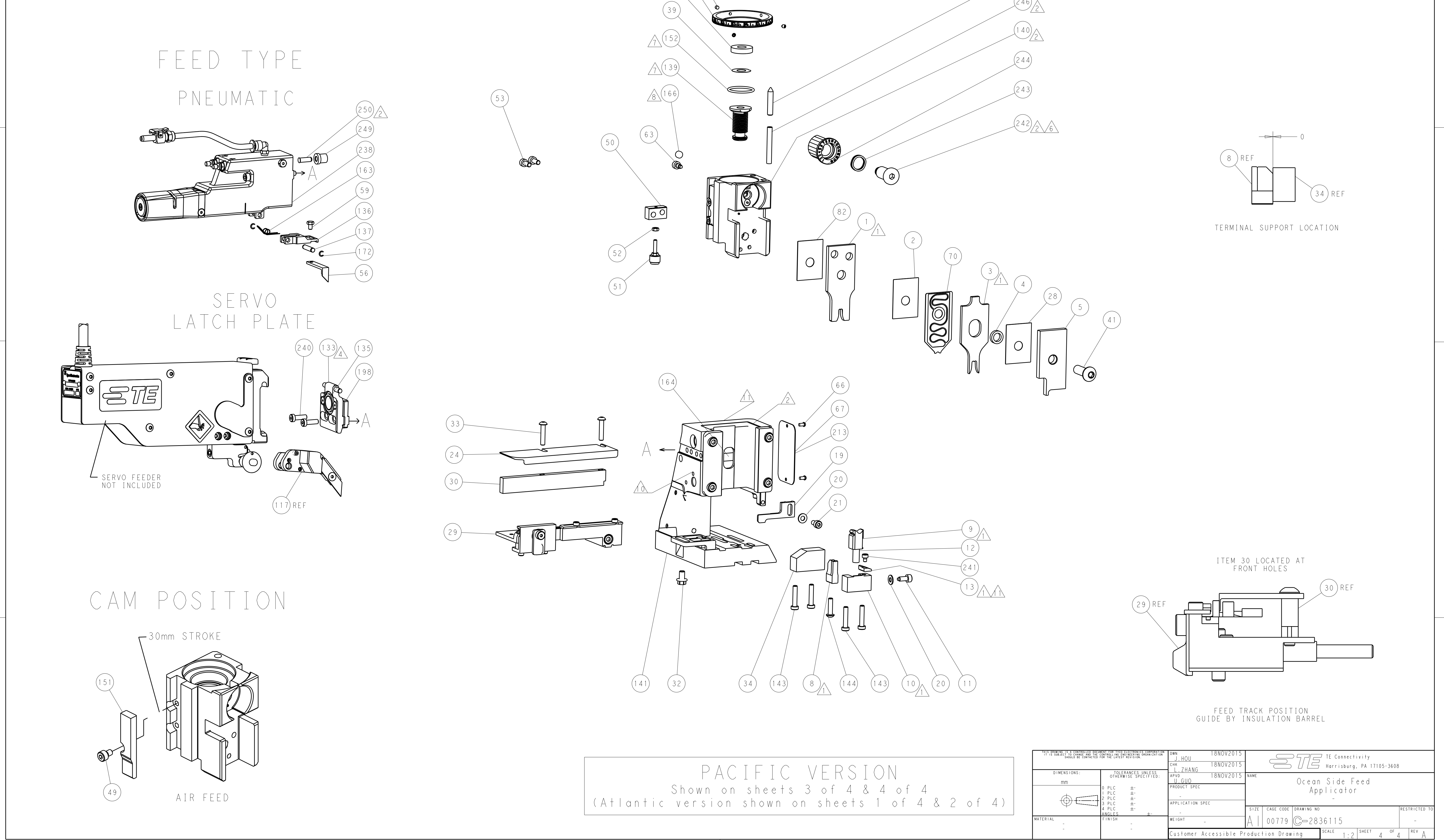
PACIFIC VERSION
Shown on sheets 3 of 4 & 4 of 4
(Atlantic version shown on sheets 1 of 4 & 2 of 4)

SET UP GAUGE 2119599-1	LOC A	DIST 66	REVISIONS			
			P	LTR	DESCRIPTION	DATE
				-	SEE SHEET 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	1-22279-3	SPRING, COMPRESSION	246
-	1	1	1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
	-	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
-	-	-	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	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	455888-4	SPACER, CRIMPER	82
-	1	1	1	2119956-1	DOCUMENTATION PACKAGE	71
-	1	1	1	2119791-9	DEPRESSOR, WIRE	70
-	1	-	1	2119740-1	TAG, IDENTIFICATION	67
	-	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
-	-	-	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	-	-	1	1338683-8	FEED PAWL	56
-	2	2	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	53
-	1	1	1	5018030-1	NUT, HEX, REG, RoHS, M3	52
-	1	1	1	811242-5	BUMPER, HOLD DOWN	51
-	1	1	1	690753-2	SPACER, TONKER	50
-	-	-	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	2119644-3	RAM WASHER, PRECISION	38
-	1	1	1	1752356-3	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	1-1320908-0	SPACER, STRIP GUIDE	30
-	1	1	1	2119959-2	ASSEMBLY, STRIP GUIDE	29
-	1	1	1	455888-3	SPACER, CRIMPER	28
-	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	2119533-1	STRIPPER, SIDE FEED	19
	-	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	2119805-1	SHEAR HOLDER, FRONT	10
	-	1	1	1803095-1	FLOATING SHEAR, FRONT	9
	1	1	1	1803250-2	ANVIL, COMBINATION	8
-	-	-	-	-	-	7
-	-	-	-	-	-	6
-	1	1	1	2119757-8	DEPRESSOR, SHEAR	5
-	1	1	1	238011-2	BLOCK, CRIMPER SPACER	4
	1	1	1	5-1633961-1	CRIMPER, INSULATION F PREMIUM	3
-	1	1	1	455888-1	SPACER, CRIMPER	2
	1	1	1	456411-9	CRIMPER, WIRE PREMIUM	1
-77	-27	-25	-22	PART NO	DESCRIPTION	ITEM NO

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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 CAGE CODE DRAWING NO 00779 ©=2836115	
MATERIAL -		WEIGHT -		RESTRICTED TO -	
Customer Accessible Production Drawing		SCALE 1:2		SHEET 3 OF 4	

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



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DIMENSIONS:				CHK	18NOV2015																					
mm				TOLERANCES UNLESS OTHERWISE SPECIFIED:		NAME	Ocean Side Feed Applicator																			
				APVD	18NOV2015																					
0 PLC ±				PRODUCT SPEC		SIZE			CAGE CODE			DRAWING NO			RESTRICTED TO											
1 PLC ±				APPLICATION SPEC																						
2 PLC ±				WEIGHT		A			00779			C			2836115											
3 PLC ±																										
4 PLC ±				Customer Accessible Production Drawing		SCALE			1:2			SHEET			4			OF			REV			A		
ANGLES ±																										
FINISH																										
MATERIAL																										

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