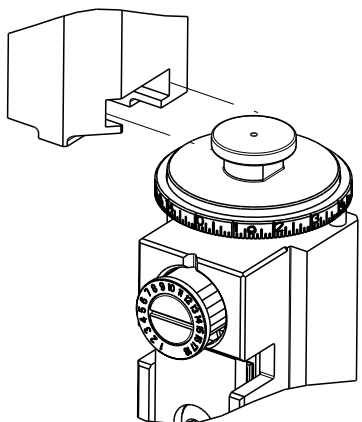


8		7		6		5		4		3		
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ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER		PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART						
						CONVERT TO	PART NUMBERS REQUIRED					
		2836344-1	A	FINE CRIMP HEIGHT ADJUST	MECHANICAL	PNEUMATIC FEED	2119950-1	1338685-1	5-18022-5	2119641-1	2119799-1	2063440-1
						SERVO LATCH PLATE	2119951-1	-	8-2836344-5	1901094-3	-	2168400-6 (QUANTITY 2)
						SMART APPLICATOR	2161326-1	-	8-2836344-4	-	-	-
		2836344-2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-1	-	-
						SERVO LATCH PLATE	2119951-1	-	8-2836344-5	1901094-3	-	2168400-6 (QUANTITY 2)
						SMART APPLICATOR	2161326-1	-	8-2836344-4	-	-	-
		2836344-5	A	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE ⁴	MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-1	-	-
						PNEUMATIC FEED	2119950-1	1338685-1	5-18022-5	2119641-1	2119799-1	2063440-1
		2836344-6	A	NON-CRIMP HEIGHT ADJUST	⁴ LATCH PLATE ¹²	-	-	-	-	-	-	-
						-	-	-	-	-	-	-
2836344-7	A	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	-		
7-2836344-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-		

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.40 mm [.055]	F
INSUL	1.57 mm [.062]	O
APPLICATOR INSTRUCTIONS 408-10389		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: .040 SERIES FEMALE RECEPTACLE			
WIRE STRIP LENGTH 4.80-5.60 mm [.189-.220 IN]		INSULATION DIAMETER RANGE Ø1.20-1.65 mm [.047-.065 IN]	
TERMINAL APPLICATION SPECIFICATION		114-6063	
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
638187-4	638009-6	638098-8	638099-8

WIRE SIZE			CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING	
22 AWG			0.95 +/- 0.05 [0.037 +/- .002]		5.4	
0.35mm2			0.94 +/- 0.05 [0.037 +/- .002]		5.6	



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:	
	MECHANICAL FEED WITH "SMART APPLICATOR" CONVERSION:	8-2836344-4
	PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION:	8-2836344-4
	SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST":	8-2836344-5
	SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST":	8-2836344-6

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.

 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 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 4.85.

		2				I	
SET UP GAUGE 2119599-1		LOC A	DIST 66	REVISIONS			
P	LTR	DESCRIPTION			DATE	DWN	APVD
	I	ORIGINAL			10JUN2016	BW	TE
	A	RELEASED			01AUG2016	MEH	GB

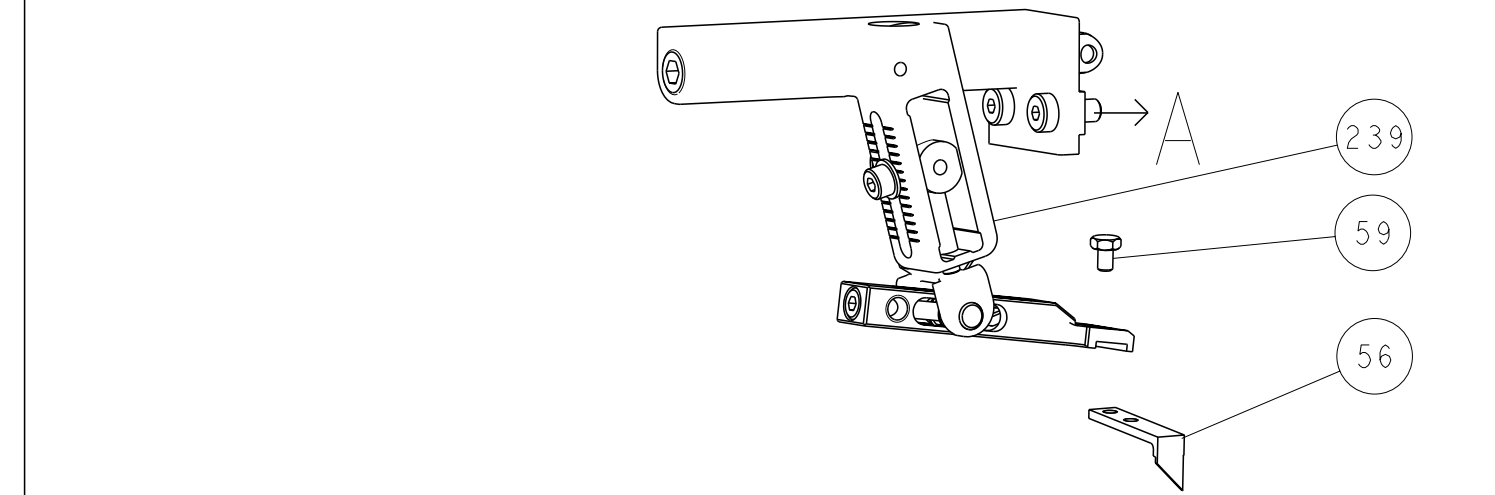
6	-	1	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
	-	1	1	1	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
-	-	2	2	-	-	-	2168400-6	SHCS, LOW HEAD, RoHS, M5 X 16	240
-	-	-	-	-	1	-	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	-	-	-	1	-	-	2063440-1	AIR FEED MODULE	238
-	-	1	1	-	-	-	2119740-2	TAG, IDENTIFICATION	213
-	-	1	1	-	-	-	1901094-3	SPACER, FEEDER	198
-	-	-	-	2	-	-	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172
-	1	1	1	1	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
-	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	-	455888-9	SPACER, CRIMPER	82
-	1	1	1	1	1	-	2119956-1	DOCUMENTATION PACKAGE	71
-	1	1	1	1	1	-	2119791-5	DEPRESSOR, WIRE	70
-	1	-	-	1	1	-	2119740-1	TAG, IDENTIFICATION	67
-	2	2	2	2	2	-	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	1	-	1	1	1	-	2119793-1	LIMITER, ADJUSTMENT BOLT	63
6	-	3	-	3	3	3	992763-5	SCR, SET, SOC, CONE POINT, M3 x 4.0	62
-	2	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	1	-	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	-	-	-	1	1	-	1338685-1	PAWL, FEED	56
-	4	4	4	4	4	-	2168400-1	SHCS, LOW HEAD, RoHS, M4 X 12	54
-	2	2	2	2	2	-	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	53
-	1	1	1	1	1	-	5018030-1	NUT, HEX, REG, RoHS, M3	52
-	1	1	1	1	1	-	811242-5	BUMPER, HOLD DOWN	51
-	1	1	1	1	1	-	690753-2	SPACER, TONKER	50
-	-	-	-	1	2	-	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	-	-	-	-	1	-	2119652-1	FEED CAM, PRE FEED	48
-	-	-	-	-	1	-	2119653-1	FEED CAM, POST FEED	47
-	1	1	1	1	1	-	2119656-9	APPLICATOR BASIC ASSEMBLY, SF	46
-	1	-	1	1	1	-	2119370-1	RAM, AMP STYLE, SIDE FEED	44
-	1	1	1	1	1	-	2079383-7	SCR, BHSC, RoHS (M8 X 25)	41
-	1	-	1	1	1	-	2119645-1	DISC, NUMBERED FA WIRE ADJUSTMENT	40
-	1	-	1	1	1	-	2119957-1	APPLICATOR SHIM PACK	39
-	1	1	1	1	1	-	1-2119644-4	RAM WASHER, PRECISION	38
6	1	1	1	1	1	-	2119085-1	FA HEAD, ATLANTIC STYLE	37
7	-	1	-	1	1	1	2119092-1	BOLT, ADJUSTMENT	35
-	1	1	1	1	1	-	2-1752356-0	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	-	1901086-5	PLATE, STRIP GUIDE	29
-	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	-	1320928-2	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
1	-	1	1	1	1	1	2119806-1	INSERT, SHEAR	13
-	1	1	1	1	1	1	3-22280-3	SPRING, COMPRESSION	12
-	1	1	1	1	1	1	1-356885-5	STOP, SHEAR	11
1	-	1	1	1	1	1	2119805-1	SHEAR HOLDER, FRONT	10
1	-	1	1	1	1	1	1-318707-4	FLOATING SHEAR, FRONT	9
1	1	1	1	1	1	1	1-1338690-5	ANVIL, COMBINATION .055	8
-	1	1	1	1	1	1	2-240641-8	SPACER	7
-	-	-	-	-	-	-	-	-	6
-	1	1	1	1	1	1	2119757-8	DEPRESSOR, SHEAR	5
-	1	1	1	1	1	1	7-238011-0	BLOCK, CRIMPER SPACER	4
1	1	1	1	1	1	1	7-1803019-4	CRIMPER, INSULATION O	3
-	1	1	1	1	1	1	455888-4	SPACER, CRIMPER	2
1	1	1	1	1	1	1	5-456402-8	CRIMPER, WIRE PREMIUM	1
-77	-7	-6	-5	-2	-1		PART NO	DESCRIPTION	ITEM NO

DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.1 1 PLC ±.1 2 PLC ±.1 3 PLC ±.1 4 PLC ±.1 ANGLES ±.1 FINISH -				DWG B. WEAVER 10JUN2016 CHK T. ELBIN 10JUN2016 APP'D T. ELBIN 10JUN2016		 TE Connectivity Harrisburg, PA 17105-3608	
NAME Ocean Side Feed Applicator		SIZE A1		CAGE CODE 00779		DRAWING NO C-2836344		RESTRICTED TO -	
MATERIAL -		WEIGHT -		Customer Accessible Production Drawing		SCALE 1:2		SHEET 1 OF 4 REV A	

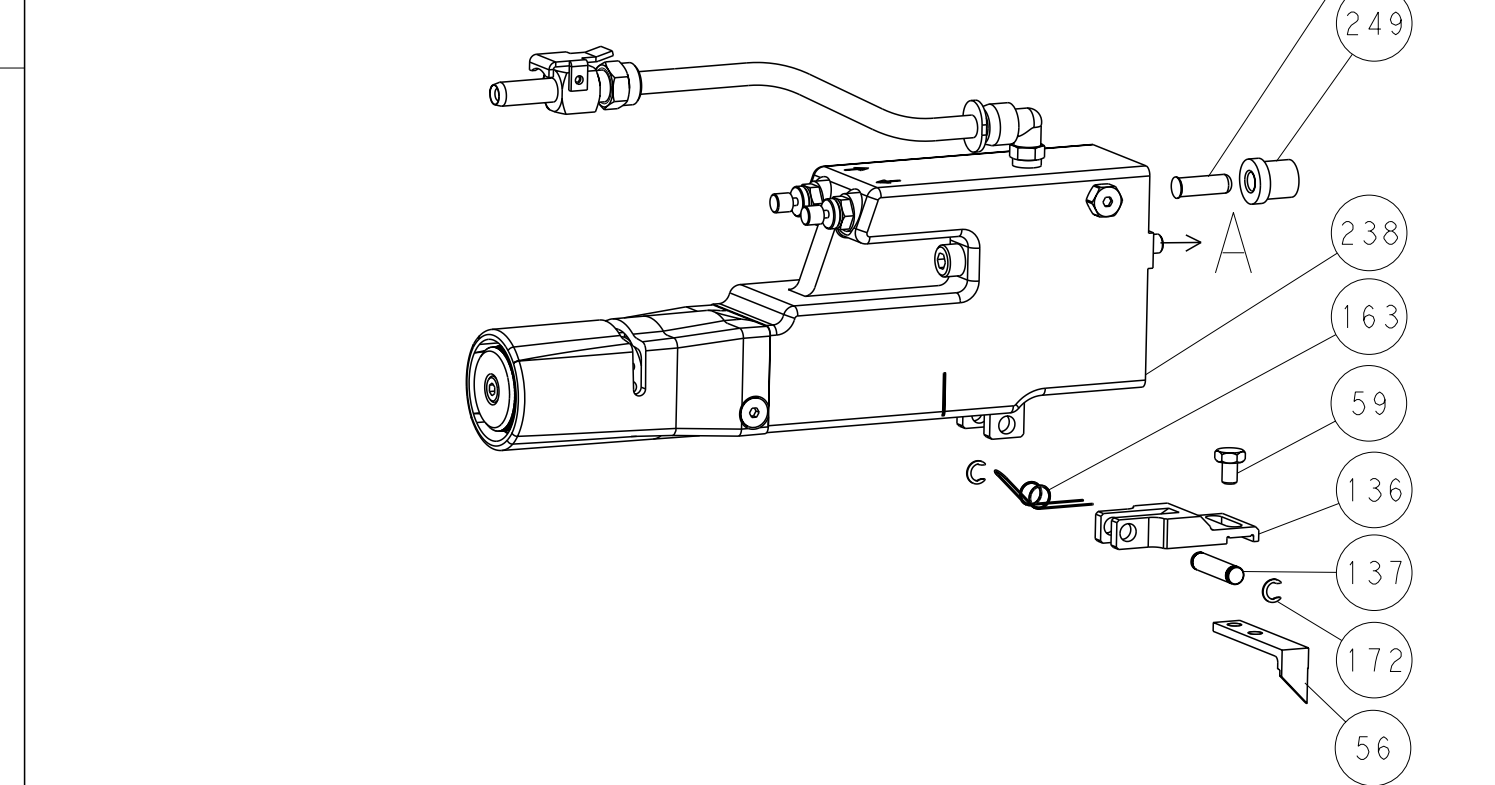
AMP 4805 REV 31MAR2000

SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

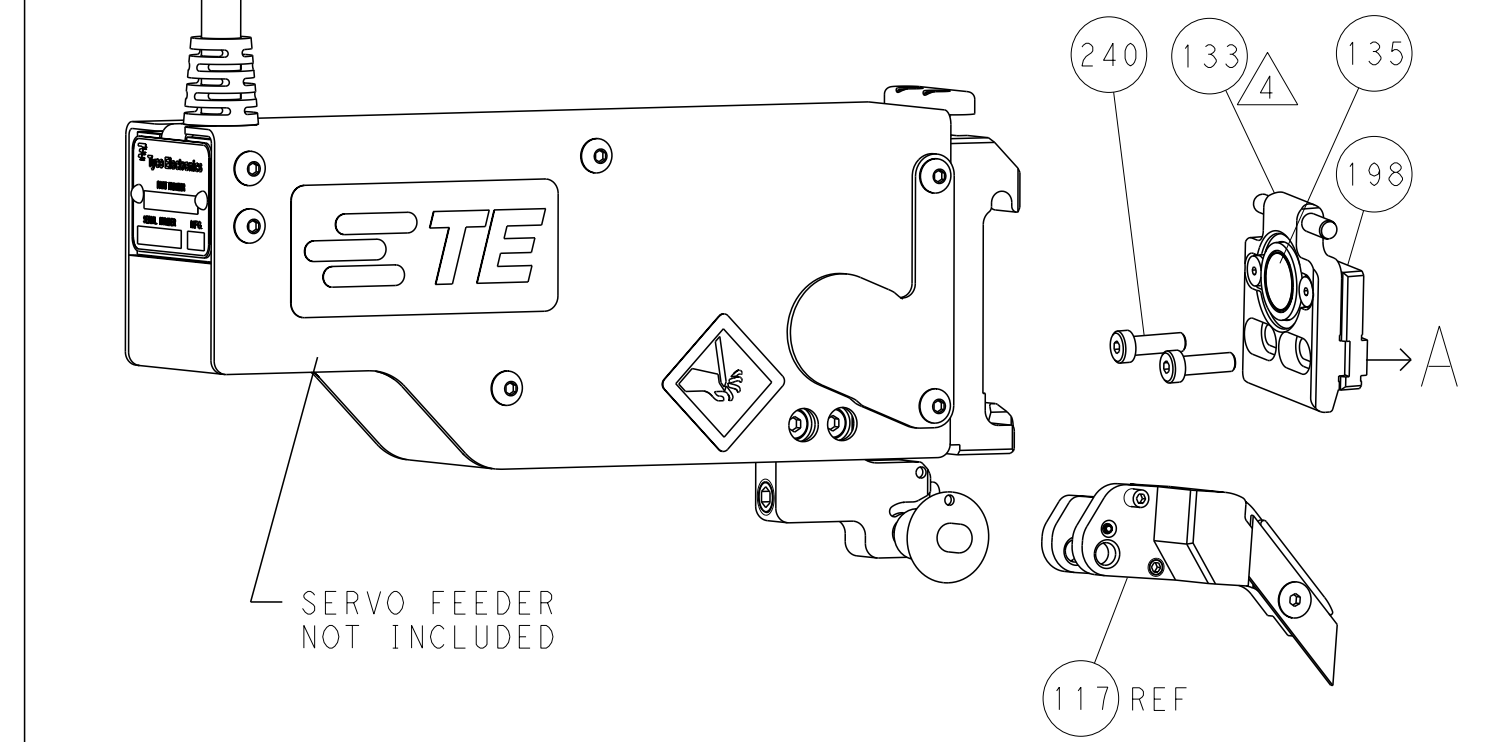
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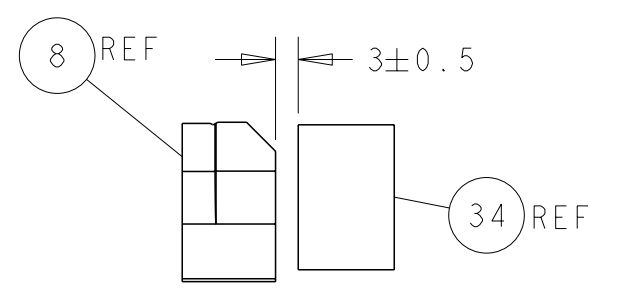
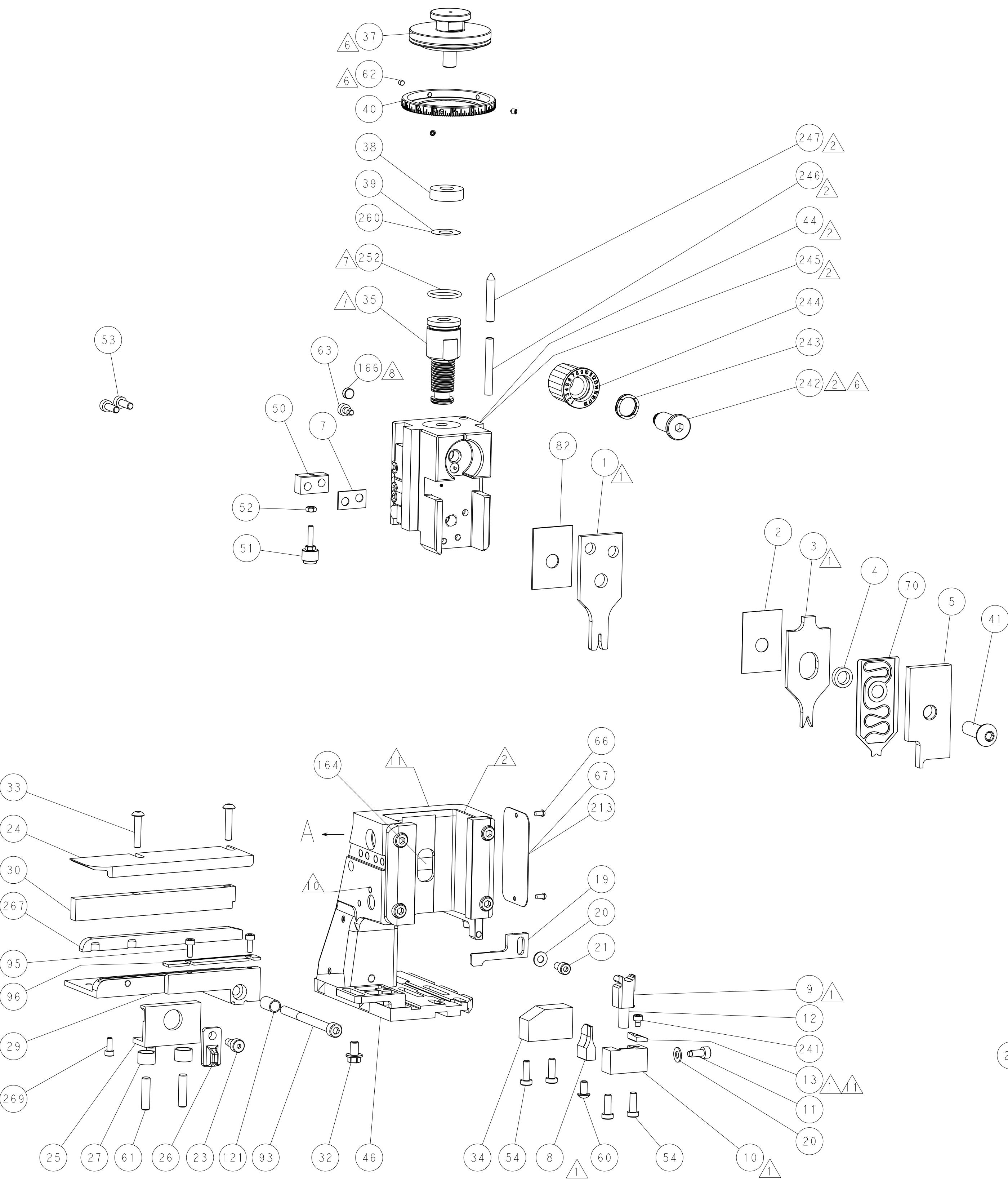
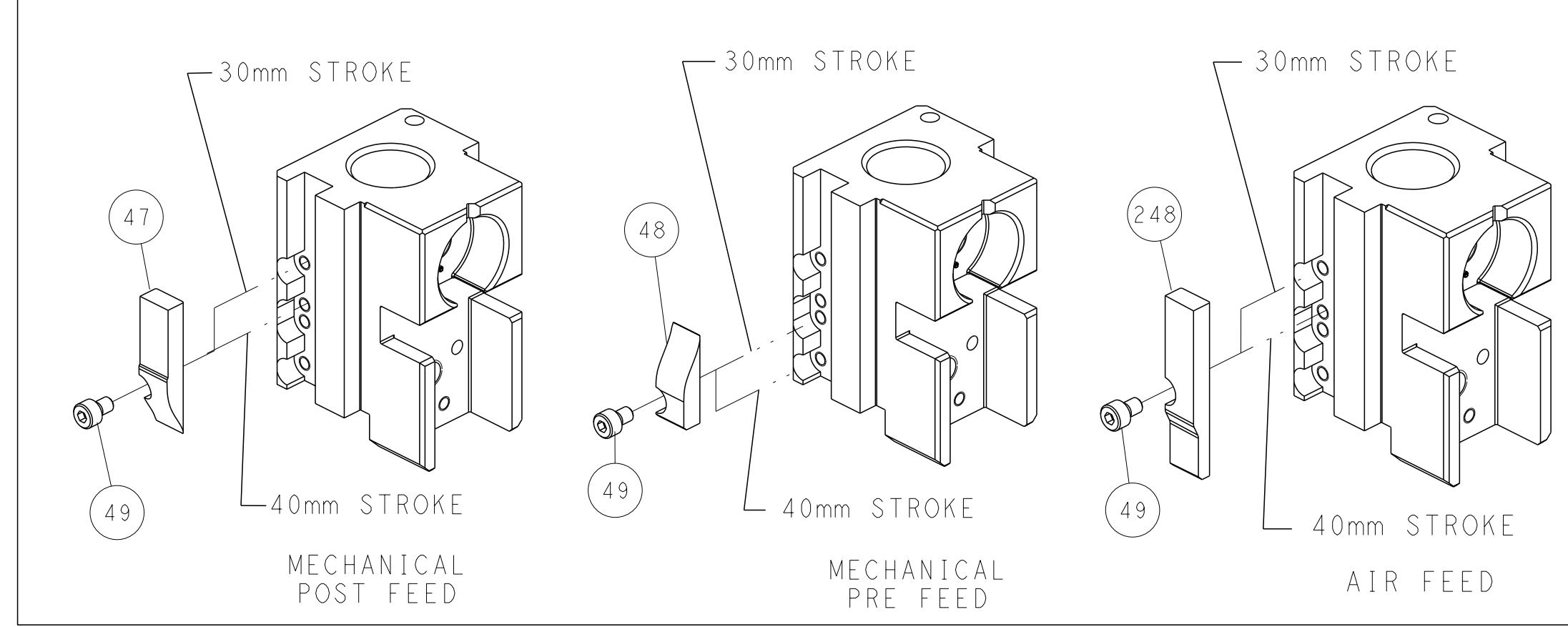
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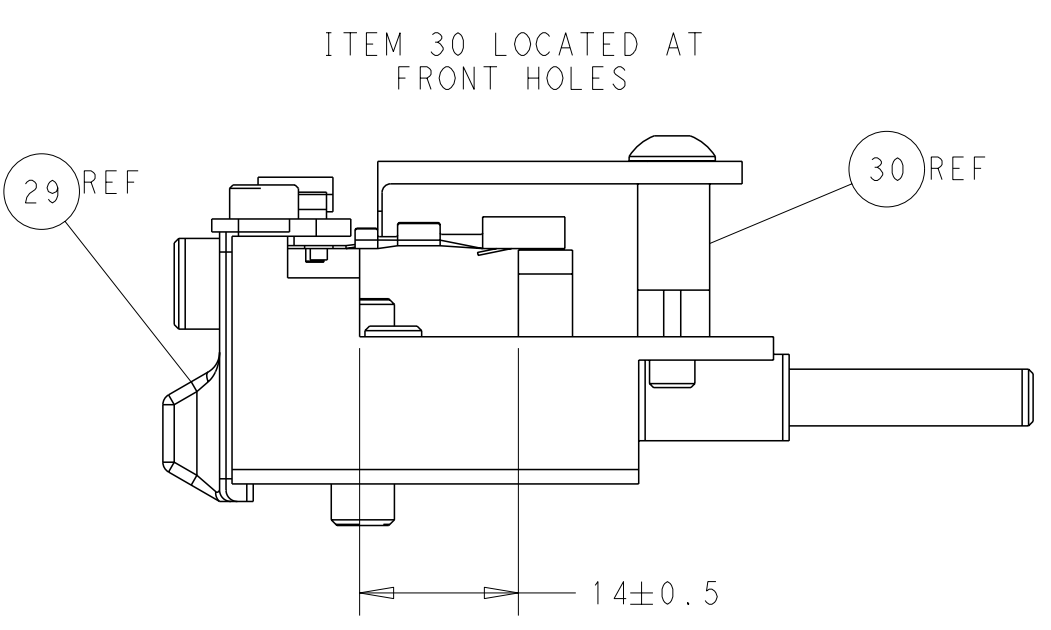
SERVO LATCH PLATE



CAM POSITIONS



TERMINAL SUPPORT LOCATION



FEED TRACK POSITION
GUIDE BY INSULATION BARREL

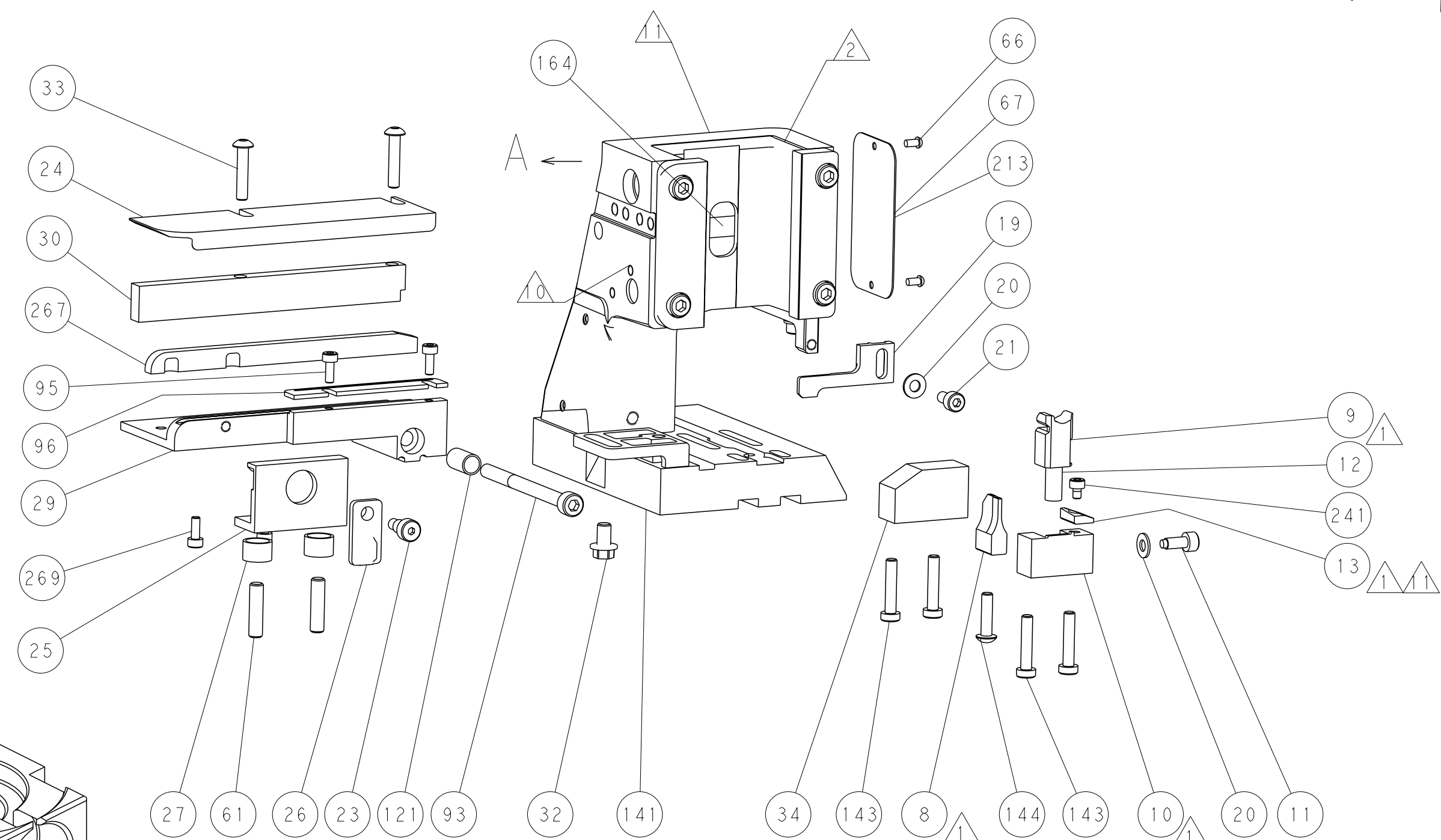
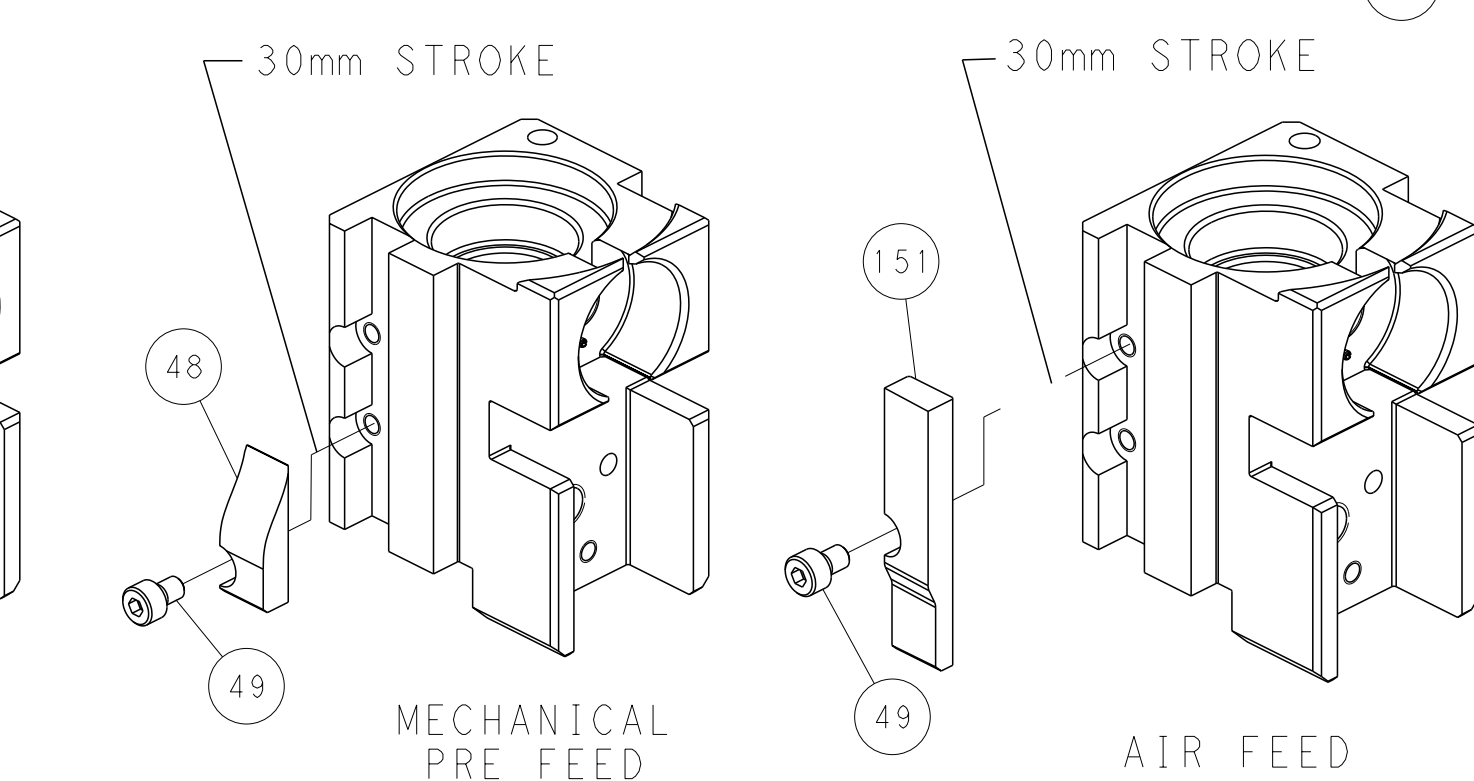
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

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DIMENSIONS: mm		CHK T. ELBIN 10JUN2016	NAME Ocean Side Feed Applicator
TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		APVD T. ELBIN 10JUN2016	SIZE A1
MATERIAL -		PRODUCT SPEC -	CAGE CODE 00779
FINISH -		APPLICATION SPEC -	DRAWING NO C=2836344
WEIGHT -		RESTRICTED TO -	SCALE 1:2
Customer Accessible Production Drawing		SHEET 2	OF 4
		REV A	

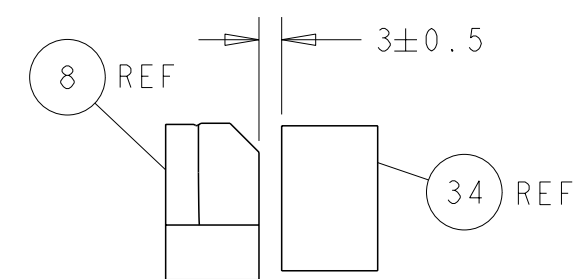
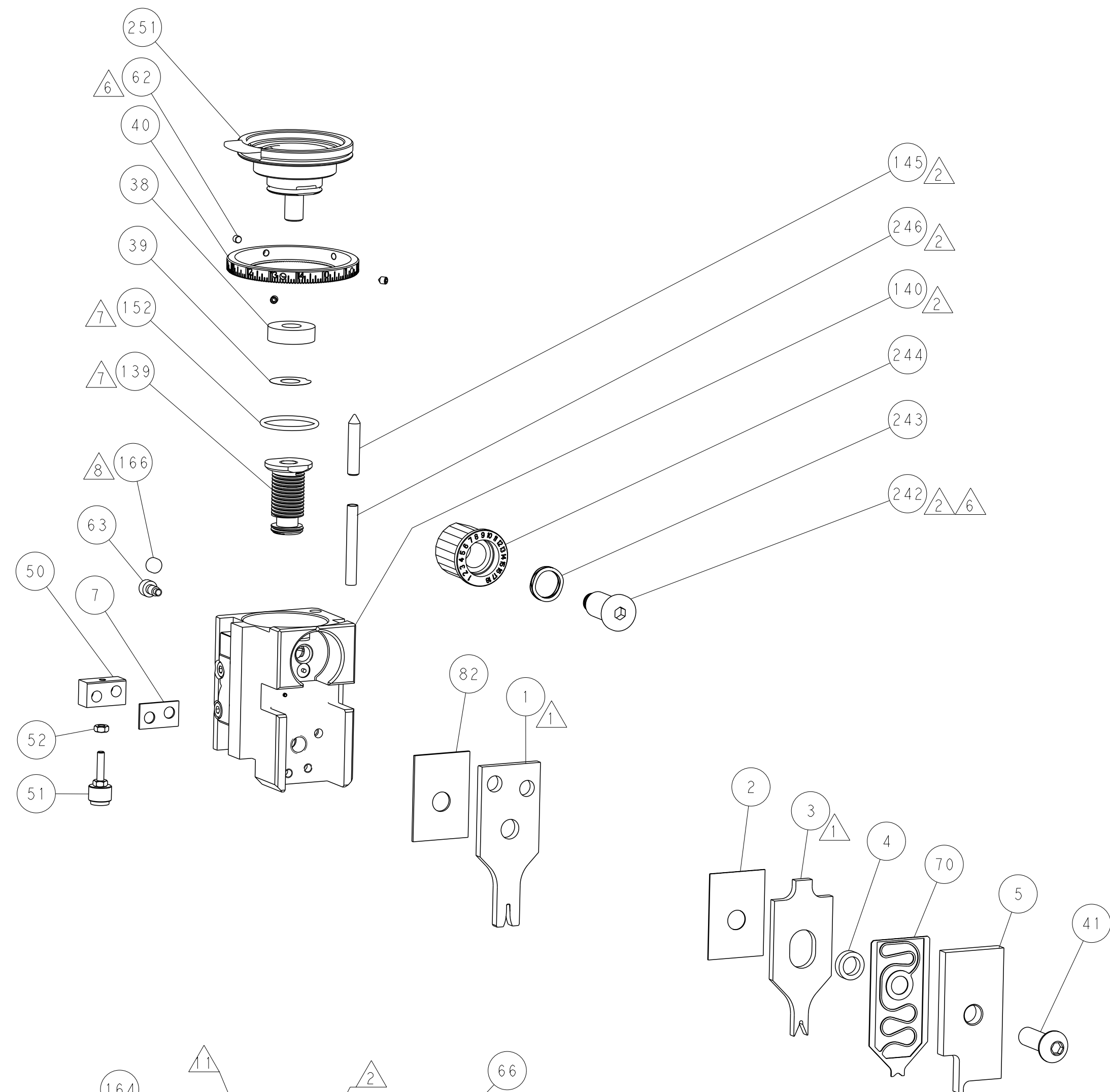
PNEUMATIC

SERVO
LATCH PLATE

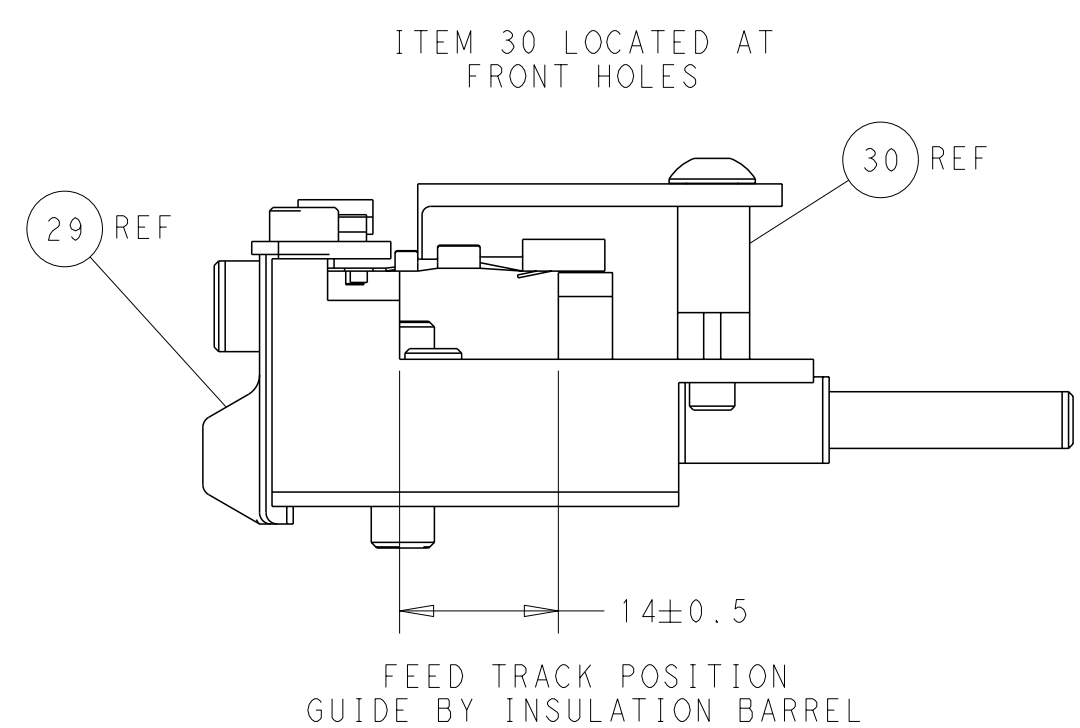
CAM POSITIONS



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



TERMINAL SUPPORT LOCATION



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DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		NAME		Ocean Side Feed Applicator			
mm				APPROVED T ELBIN 10JUN2016					
		0 PLC ± 2 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		PRODUCT SPEC					
				APPLICATION SPEC					
				SIZE		CAGE CODE	DRAWING NO	RESTRICTED TO	
MATERIAL		FINISH		WEIGHT		A 00779	G=2836344	-	
-		-		-		Customer Accessible Production Drawing		SCALE 1:2 SHEET 4 OF 4 REV A	

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