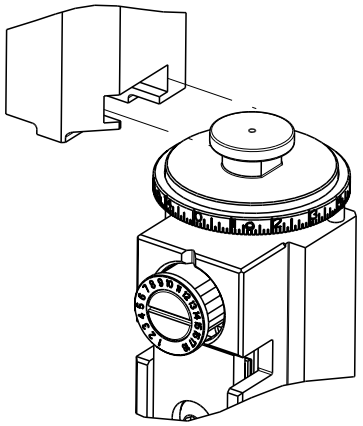


|                                                                                  |             |                                                       |                          |                                |                                   |                       |           |             |           |           |                        |
|----------------------------------------------------------------------------------|-------------|-------------------------------------------------------|--------------------------|--------------------------------|-----------------------------------|-----------------------|-----------|-------------|-----------|-----------|------------------------|
| 8                                                                                |             |                                                       |                          | 6                              |                                   | 5                     |           | 4           |           | 3         |                        |
| THIS DRAWING IS UNPUBLISHED.                                                     |             | RELEASED FOR PUBLICATION                              |                          | 2016                           |                                   |                       |           |             |           |           |                        |
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|  | PART NUMBER | REVISION                                              | DESCRIPTION              | FEED TYPE                      | APPLICATOR STYLE CONVERSION CHART |                       |           |             |           |           |                        |
|                                                                                  |             |                                                       |                          |                                | CONVERT TO                        | PART NUMBERS REQUIRED |           |             |           |           |                        |
|                                                                                  | 2836408-2   | A                                                     | FINE CRIMP HEIGHT ADJUST | PNEUMATIC                      | -                                 | -                     | -         | -           | -         | -         | -                      |
|                                                                                  |             |                                                       |                          |                                | SERVO LATCH PLATE                 | 2119951-1             | -         | 8-2836408-5 | 1901094-3 | -         | 2168400-6 (QUANTITY 2) |
|                                                                                  | 2836408-5   | A                                                     | FINE CRIMP HEIGHT ADJUST | SERVO LATCH PLATE <sup>4</sup> | SMART APPLICATOR                  | 2161326-1             | -         | 8-2836408-4 | -         | -         | -                      |
|                                                                                  |             |                                                       |                          |                                | PNEUMATIC FEED                    | 2119950-1             | 1338683-9 | 5-18022-5   | 2119641-1 | 2119799-1 | 2063440-1              |
|                                                                                  | 2836408-6   | A                                                     | NON-CRIMP HEIGHT ADJUST  | SERVO LATCH PLATE <sup>4</sup> | -                                 | -                     | -         | -           | -         | -         | -                      |
|                                                                                  |             |                                                       |                          |                                | -                                 | -                     | -         | -           | -         | -         | -                      |
|                                                                                  | 2836408-7   | A                                                     | FINE CRIMP HEIGHT ADJUST | NONE                           | -                                 | -                     | -         | -           | -         | -         | -                      |
|                                                                                  |             |                                                       |                          |                                | -                                 | -                     | -         | -           | -         | -         | -                      |
| 7-2836408-7                                                                      | A           | CRIMP TOOLING KIT                                     | -                        | -                              | -                                 | -                     | -         | -           | -         | -         |                        |
|                                                                                  |             |                                                       |                          | -                              | -                                 | -                     | -         | -           | -         | -         |                        |

|                                      |                |      |
|--------------------------------------|----------------|------|
| APPLICATOR DATA                      |                |      |
| CRIMP                                | SIZE           | TYPE |
| WIRE                                 | 2.59 mm [.102] | F    |
| INSUL                                | 3.81 mm [.150] | O    |
| APPLICATOR INSTRUCTIONS<br>408-10389 |                |      |

|                                                                |                 |                                                           |                 |
|----------------------------------------------------------------|-----------------|-----------------------------------------------------------|-----------------|
| TERMINAL DATA: UTILUX TERMINAL      UTILUX CRIMP SPECIFICATION |                 |                                                           |                 |
| TERMINAL NAME: RING TERMINAL                                   |                 |                                                           |                 |
| WIRE STRIP LENGTH<br>4.35-5.15 mm [.171-.203 IN]               |                 | INSULATION DIAMETER RANGE<br>Ø2.20-2.80 mm [.087-.110 IN] |                 |
| TERMINAL APPLICATION SPECIFICATION                             | H3930-2 Rev 3   | -                                                         | -               |
| TERMINALS APPLIED <sup>10</sup>                                |                 |                                                           |                 |
| TE TERMINAL                                                    | UTILUX TERMINAL | TE TERMINAL                                               | UTILUX TERMINAL |
| 2303645-1                                                      | ET-114CE        | 2303645-2                                                 | ET-114CD        |
| 2303645-3                                                      | ET-114CC        | 2303645-4                                                 | ET-114CB        |

|           |                                                                                     |                            |                                                                                     |                                             |
|-----------|-------------------------------------------------------------------------------------|----------------------------|-------------------------------------------------------------------------------------|---------------------------------------------|
| WIRE SIZE |  | CRIMP HEIGHT mm [INCH]     |  | CRIMP HEIGHT REFERENCE SETTING <sup>9</sup> |
| 1.00mm2   |                                                                                     | 1.65+/-0.05 [.065+/- .002] |                                                                                     | 6.2                                         |
| 0.75mm2   |                                                                                     | 1.55+/-0.05 [.061+/- .002] |                                                                                     | 7.3                                         |
| 0.50mm2   |                                                                                     | 1.45+/-0.05 [.057+/- .002] |                                                                                     | 8.3                                         |



- <sup>1</sup> RECOMMENDED SPARE PARTS
- <sup>2</sup> GREASE BEARING SURFACES LIGHTLY
3. LUBRICATE DAILY PER THE APPLICATOR INSTRUCTION SHEET SUPPLIED WITH THE APPLICATOR.
- <sup>4</sup> APPLICATOR SPECIFIC DATA TO BE ENTERED INTO BLANK MEMORY CHIP AT ASSEMBLY. SEE BELOW FOR PART NUMBER:  
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2836408-4  
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2836408-5  
SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2836408-6
5. ADJUSTMENT OF THE STRIPPER MAY BE REQUIRED WHEN MOVING THE APPLICATOR BETWEEN BENCH AND LEADMAKER APPLICATIONS.
- <sup>6</sup> APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 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 ITEMS 37.
- <sup>7</sup> GREASE THREADS, GROOVE AND O-RING ON ITEMS 35 & 252.
- <sup>8</sup> MAGNET, ITEM 166 MUST BE ORIENTED CORRECTLY IN ORDER TO PROPERLY ACTUATE THE COUNTER.
- <sup>9</sup> 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.
- <sup>10</sup> TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- <sup>11</sup> WHEN ASSEMBLING A NON CRIMP HEIGHT ADJUST APPLICATOR (-6)  
USE SHIMS FROM ITEM 260 TO ACHIEVE A NOMINAL SHIM HEIGHT OF 4.15.
- <sup>12</sup> CUT TO LENGTH AT ASSEMBLY.

\*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.

|     |    |    |    |    |           |                                 |         |
|-----|----|----|----|----|-----------|---------------------------------|---------|
| -   | -  | 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  | 1803259-1 | BUSHING, FLANGED                | 249     |
| -   | -  | -  | -  | 1  | 2119641-1 | FEED CAM, AIR FEED              | 248     |
| -   | 1  | -  | 1  | 1  | 2119798-1 | DETENT PIN                      | 247     |
| -77 | -7 | -6 | -5 | -2 | PART NO   | DESCRIPTION                     | ITEM NO |

<sup>7</sup>

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<br>2119599-1 | LOC<br>A | DIST<br>66 | REVISIONS |     |             |  |  |            |     |      |
|                           |          |            | P         | LYR | DESCRIPTION |  |  | DATE       | OWN | APVD |
|                           |          |            |           | 1   | PRELIMINARY |  |  | 21SEP12016 | MEH | TE   |
|                           |          |            |           | A   | RELEASED    |  |  | 06DEC2016  | MEH | TE   |
|                           |          |            |           |     |             |  |  |            |     |      |

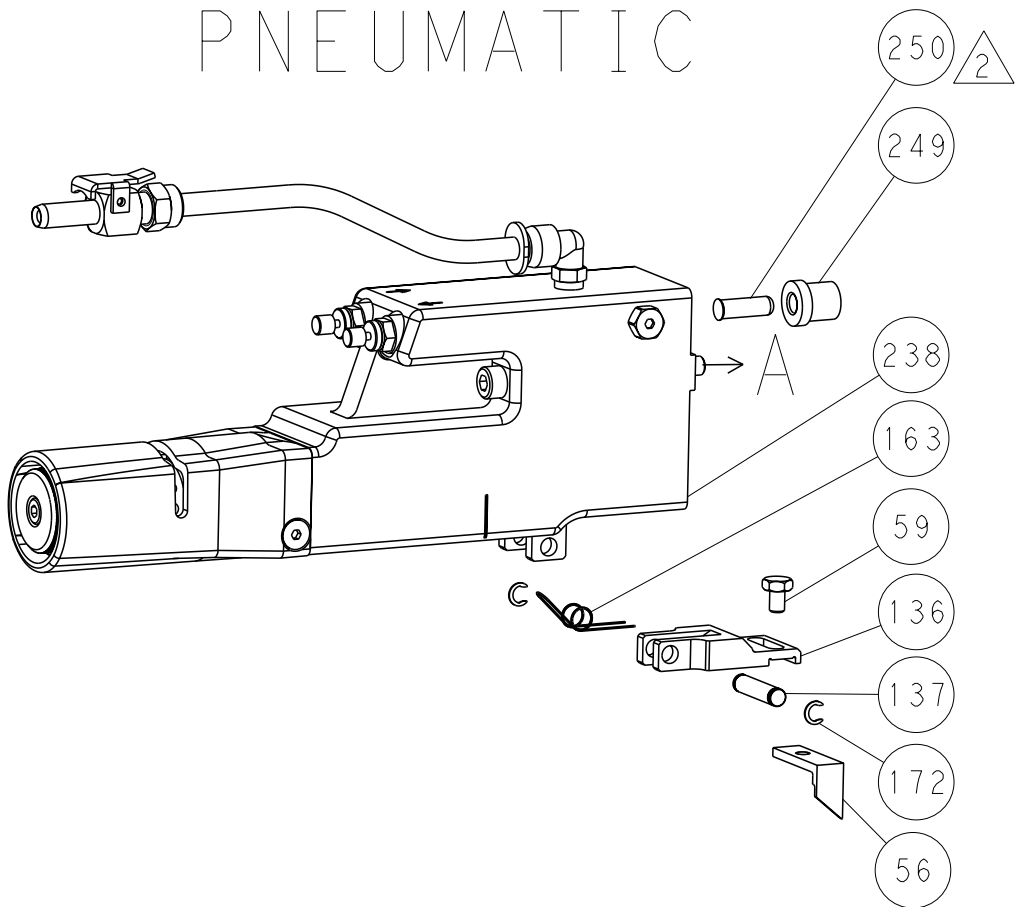
|                |     |     |     |     |             |                                     |         |
|----------------|-----|-----|-----|-----|-------------|-------------------------------------|---------|
| -              | 1   | -   | 1   | 1   | 1-22279-3   | SPRING, COMPRESSION                 | 246     |
| -              | -   | 1   | -   | -   | 2119758-1   | RAM, AMP STYLE, SIDE FEED, NON-ADJ. | 245     |
| -              | 1   | 1   | 1   | 1   | 2119082-3   | CAM, SNAIL, INSULATION ADJUSTMENT   | 244     |
| -              | 1   | 1   | 1   | 1   | 2079764-1   | WASHER, WAVE SPRING, CREST-TO-CREST | 243     |
| <sup>6</sup> - | 1   | 1   | 1   | 1   | 2119083-1   | RETAINER, INSULATION DIAL           | 242     |
| -              | -   | 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     |
| -              | -   | -   | -   | 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   | 2217068-1   | BRACKET, AIR BLAST                  | 130     |
| -              | 1   | 1   | 1   | 1   | 2030758-3   | TUBING, POLYURETHANE                | 129     |
| -              | 1   | 1   | 1   | 1   | 5018030-2   | NUT, HEX, REG, RoHS, M4             | 128     |
| -              | 2   | 2   | 2   | 2   | 2168083-3   | SCR, SKT HD CAP, RoHS, M4 X 12.0    | 127     |
| -              | 1   | 1   | 1   | 1   | 986220-3    | CLAMP, CABLE, BLACK                 | 126     |
| -              | 1   | 1   | 1   | 1   | 1-22281-8   | SPRING, COMPRESSION                 | 121     |
| -              | -   | REF | REF | -   | 2119944-1   | FEED FINGER ASSEMBLY, SF            | 117     |
| -              | 1   | 1   | 1   | 1   | 23238-1     | INSERT, COUPLING                    | 101     |
| <sup>2</sup> - | 2   | 2   | 2   | 2   | 2079383-4   | SCR, BHSC, RoHS (M4 X 8)            | 98      |
| -              | 1   | 1   | 1   | 1   | 1-690438-5  | FRONT STRIP GUIDE                   | 96      |
| -              | 2   | 2   | 2   | 2   | 2168083-1   | SCR, SKT HD CAP, RoHS, M3 X 8.0     | 95      |
| -              | 1   | 1   | 1   | 1   | 2168083-6   | SCR, SKT HD CAP, RoHS, M5 X 65      | 93      |
| -              | 1   | 1   | 1   | 1   | 455888-5    | SPACER, CRIMPER                     | 82      |
| -              | 1   | 1   | 1   | 1   | 2119956-1   | DOCUMENTATION PACKAGE               | 71      |
| -              | 1   | -   | -   | 1   | 2119740-1   | TAG, IDENTIFICATION                 | 67      |
| -              | 2   | 2   | 2   | 2   | 2168078-1   | SCREW, DRIVE, RH, RoHS, 2 x .188    | 66      |
| -              | 1   | -   | 1   | 1   | 2119793-1   | LIMITER, ADJUSTMENT BOLT            | 63      |
| <sup>6</sup> - | 3   | -   | 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   | 2079383-4   | SCR, BHSC, RoHS (M4 X 8)            | 60      |
| -              | -   | -   | -   | 1   | 5-18022-5   | SCR, HEX HD CAP, M4 X 6.0           | 59      |
| -              | -   | -   | -   | 1   | 1338683-9   | FEED PAWL                           | 56      |
| -              | 1   | 1   | 1   | 1   | 3-18031-6   | SCR, SET, CUP POINT M2.5 X 3.0      | 54      |
| <sup>2</sup> - | 2   | 2   | 2   | 2   | 2168083-9   | SCR, SKT HD CAP, RoHS, M4 X 20      | 53      |
| -              | 1   | 1   | 1   | 1   | 1-811242-0  | BUMPER, HOLD DOWN                   | 51      |
| -              | 1   | 1   | 1   | 1   | 1-1803011-2 | HOLDER, SLUG BLADE                  | 50      |
| -              | -   | -   | -   | 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   | 1-2119644-2 | RAM WASHER, PRECISION               | 38      |
| <sup>6</sup> - | 1   | 1   | 1   | 1   | 2119085-1   | FA HEAD, ATLANTIC STYLE             | 37      |
| <sup>7</sup> - | 1   | -   | 1   | 1   | 2119092-1   | BOLT, ADJUSTMENT                    | 35      |
| -              | 1   | 1   | 1   | 1   | 2161328-1   | HEX HEAD, FLANGED, M5 x 8mm LONG    | 32      |
| -              | 2   | 2   | 2   | 2   | 1-2168083-3 | SCR, SKT HD CAP, RoHS, M3 X 16      | 30      |
| -              | 1   | 1   | 1   | 1   | 2-1901091-2 | PLATE, REAR STRIP GUIDE             | 29      |
| -              | 2   | 2   | 2   | 2   | 22281-9     | SPRING, COMPRESSION                 | 27      |
| -              | 1   | 1   | 1   | 1   | 356835-1    | LEVER, DRAG RELEASE                 | 26      |
| -              | 1   | 1   | 1   | 1   | 240792-1    | DRAG, TERMINAL                      | 25      |
| -              | 1   | 1   | 1   | 1   | 980371-4    | SCR, SKT HD SHLDR 5.0 DIA X 6.0     | 23      |
| -              | 1   | 1   | 1   | 1   | 2168083-2   | SCR, SKT HD CAP, RoHS, M4 X 8.0     | 21      |
| -              | 6   | 6   | 6   | 6   | 1-18028-2   | WASHER, FLAT, REG M4                | 20      |
| -              | 1   | 1   | 1   | 1   | 1-2119533-0 | STRIPPER, SIDE FEED                 | 19      |
| -              | 1   | 1   | 1   | 1   | 1-189124-4  | GUIDE, FRONT STRIP                  | 12      |
| <sup>1</sup> - | 1   | 1   | 1   | 1   | 2161951-5   | BLADE, SLUG                         | 10      |
| <sup>1</sup> - | 1   | 1   | 1   | 1   | 2063687-8   | PLATE, REAR SHEAR                   | 9       |
| <sup>1</sup> - | 1   | 1   | 1   | 1   | 1803443-1   | ANVIL, SPECIAL, COMBINATION         | 8       |
| -              | -   | -   | -   | -   | -           | -                                   | 7       |
| -              | -   | -   | -   | -   | -           | -                                   | 6       |
| -              | -   | -   | -   | -   | -           | -                                   | 5       |
| -              | 1   | 1   | 1   | 1   | 238009-1    | BLOCK, FL CRIMPER SPACER            | 4       |
| <sup>1</sup> - | 1   | 1   | 1   | 1   | 3-1633965-1 | CRIMPER, INSULATION O PREMIUM       | 3       |
| -              | 1   | 1   | 1   | 1   | 455888-9    | SPACER, CRIMPER                     | 2       |
| <sup>1</sup> - | 1   | 1   | 1   | 1   | 1-1633664-0 | CRIMPER, WIRE                       | 1       |
| -77            | -7  | -6  | -5  | -2  | PART NO     | DESCRIPTION                         | ITEM NO |

|                                                                                                                                                            |  |  |  |                                                     |  |                                                                                                                                    |  |                                        |  |                               |  |                         |  |                    |  |
|------------------------------------------------------------------------------------------------------------------------------------------------------------|--|--|--|-----------------------------------------------------|--|------------------------------------------------------------------------------------------------------------------------------------|--|----------------------------------------|--|-------------------------------|--|-------------------------|--|--------------------|--|
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|                                                                                                                                                            |  |  |  | CHK<br>T. ELBIN<br>21SEP2016                        |  |                                                                                                                                    |  |                                        |  |                               |  |                         |  |                    |  |
| DIMENSIONS:                                                                                                                                                |  |  |  | APVD<br>T. ELBIN<br>21SEP2016                       |  |                                                                                                                                    |  |                                        |  | NAME                          |  |                         |  |                    |  |
| mm                                                                                                                                                         |  |  |  | PRODUCT SPEC                                        |  |                                                                                                                                    |  |                                        |  | Ocean Side Feed<br>Applicator |  |                         |  |                    |  |
|                                                                       |  |  |  | 0 PLC ±<br>1 PLC ±<br>2 PLC ±<br>3 PLC ±<br>4 PLC ± |  | APPLICATION SPEC                                                                                                                   |  | SIZE<br>A1                             |  | CAGE CODE<br>00779            |  | DRAWING NO<br>©=2836408 |  | RESTRICTED TO<br>- |  |
| FINISH                                                                                                                                                     |  |  |  | WEIGHT                                              |  | FINISH                                                                                                                             |  | Customer Accessible Production Drawing |  | SCALE<br>1:2                  |  | SHEET<br>1 of 4         |  | REV<br>A           |  |

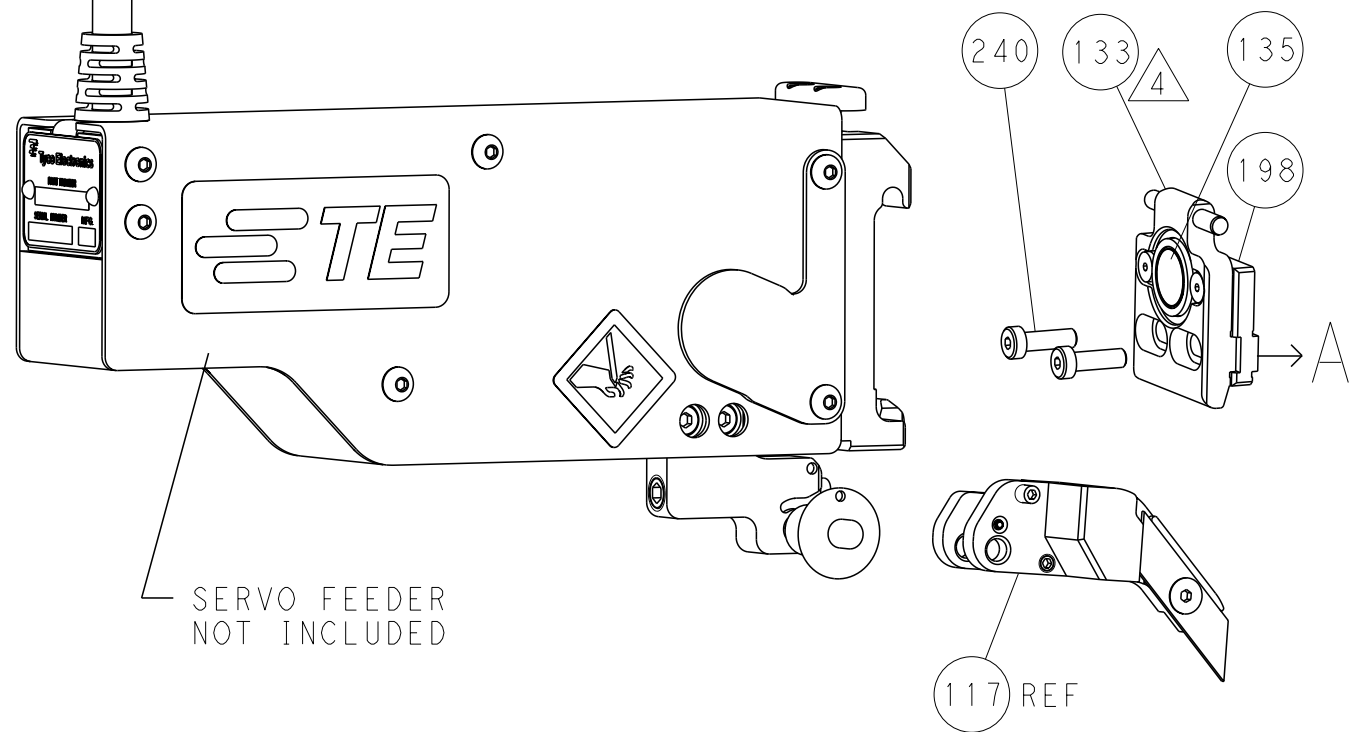
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|-----|--|------|--|-----------|-----|-------------|------|-----|------|
| A   |  | 66   |  | P         | LTR | DESCRIPTION | DATE | DWN | APVD |
|     |  |      |  | -         |     | SEE SHEET 1 | -    | -   | -    |
|     |  |      |  |           |     |             |      |     |      |
|     |  |      |  |           |     |             |      |     |      |
|     |  |      |  |           |     |             |      |     |      |
|     |  |      |  |           |     |             |      |     |      |

FEED TYPE

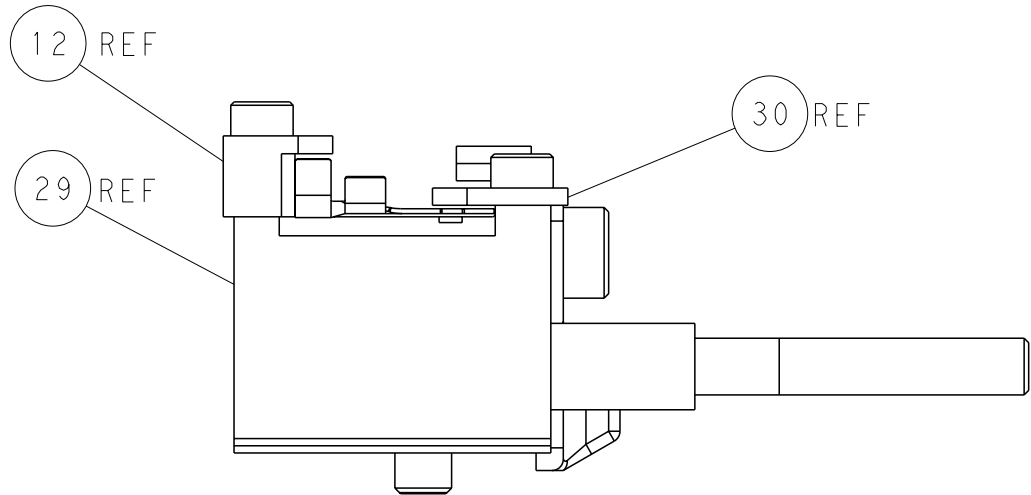
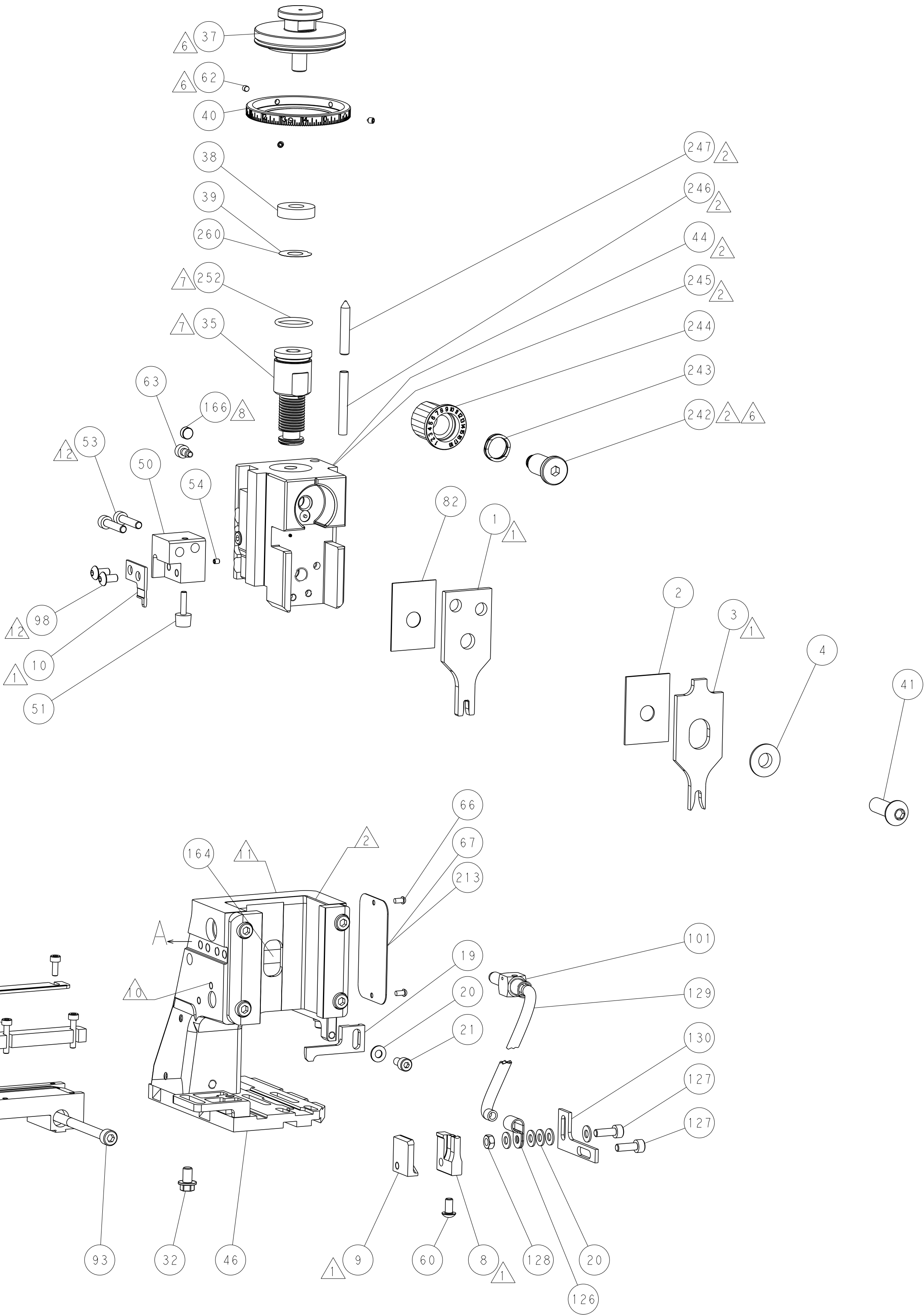
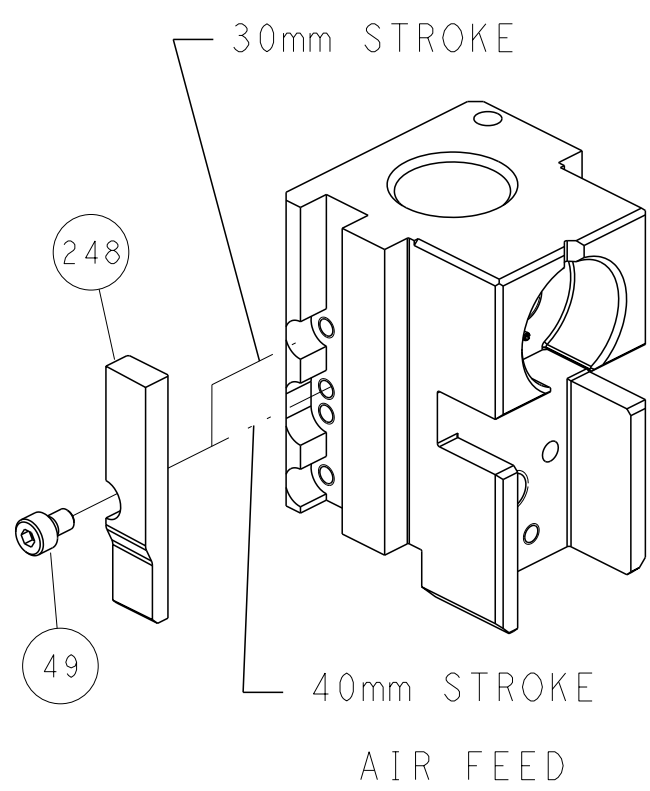
PNEUMATIC



SERVO LATCH PLATE

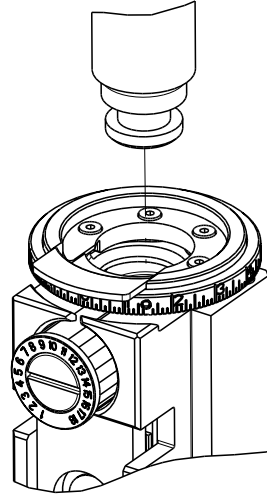


CAM POSITION

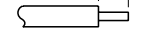


ATLANTIC VERSION  
Shown on sheets 1 of 4 & 2 of 4  
(Pacific version shown on sheets 3 of 4 & 4 of 4)

|                                                                                                                                                                                            |  |                                                                           |  |                                            |           |                                                                                                                                    |       |           |            |               |       |
|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--|---------------------------------------------------------------------------|--|--------------------------------------------|-----------|------------------------------------------------------------------------------------------------------------------------------------|-------|-----------|------------|---------------|-------|
| THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION<br>IT IS SUBJECT TO CHANGE AND TO CONTROL AND ENGINEERING DISCRETION<br>SHOULD BE CONTACTED FOR THE LATEST REVISION |  |                                                                           |  | DWN<br>M. HERR                             | 21SEP2016 |  TE Connectivity<br>Harrisburg, PA 17105-3608 |       |           |            |               |       |
|                                                                                                                                                                                            |  |                                                                           |  | CHK<br>T. ELBIN                            | 21SEP2016 |                                                                                                                                    |       |           |            |               |       |
|                                                                                                                                                                                            |  |                                                                           |  | APVD<br>T. ELBIN                           | 21SEP2016 |                                                                                                                                    |       |           |            |               |       |
|                                                                                                                                                                                            |  |                                                                           |  |                                            |           |                                                                                                                                    |       |           |            |               |       |
| DIMENSIONS:<br>mm                                                                                                                                                                          |  | TOLERANCES UNLESS<br>OTHERWISE SPECIFIED:                                 |  | NAME                                       |           | Ocean Side Feed<br>Applicator                                                                                                      |       |           |            |               |       |
|                                                                                                       |  | 0 PLC ±<br>1 PLC ±<br>2 PLC ±<br>3 PLC ±<br>4 PLC ±<br>ANGLES ±<br>FINISH |  | PRODUCT SPEC<br>-<br>APPLICATION SPEC<br>- |           | -<br>-                                                                                                                             |       |           |            |               |       |
| MATERIAL                                                                                                                                                                                   |  |                                                                           |  | WEIGHT                                     |           | SIZE                                                                                                                               |       | CAGE CODE | DRAWING NO | RESTRICTED TO |       |
| -                                                                                                                                                                                          |  | -                                                                         |  | -                                          |           | A                                                                                                                                  |       | 00779     | C=2836408  | -             |       |
| Customer Accessible Production Drawing                                                                                                                                                     |  |                                                                           |  |                                            |           |                                                                                                                                    | SCALE |           | 1:2        | SHEET 2 OF 4  | REV A |

|                                                                                  |                                                    |                                                       |                          |                                                                                                        |                   |                                   |                       |             |             |           |                        |
|----------------------------------------------------------------------------------|----------------------------------------------------|-------------------------------------------------------|--------------------------|--------------------------------------------------------------------------------------------------------|-------------------|-----------------------------------|-----------------------|-------------|-------------|-----------|------------------------|
| 8                                                                                |                                                    |                                                       |                          | 6                                                                                                      |                   | 5                                 |                       | 4           |             | 3         |                        |
| THIS DRAWING IS UNPUBLISHED.                                                     |                                                    | RELEASED FOR PUBLICATION                              |                          | 2016                                                                                                   |                   |                                   |                       |             |             |           |                        |
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|  | PACIFIC VERSION<br>TERMINATOR<br>INTERFACE ADAPTER | PART<br>NUMBER                                        | REVISION                 | DESCRIPTION                                                                                            | FEED TYPE         | APPLICATOR STYLE CONVERSION CHART |                       |             |             |           |                        |
|                                                                                  |                                                    |                                                       |                          |                                                                                                        |                   | CONVERT TO                        | PART NUMBERS REQUIRED |             |             |           |                        |
|                                                                                  |                                                    |                                                       |                          |                                                                                                        |                   | -                                 | -                     | -           | -           | -         | -                      |
|                                                                                  | 2-2836408-2                                        | A                                                     | FINE CRIMP HEIGHT ADJUST | PNEUMATIC                                                                                              | SERVO LATCH PLATE | 2119951-1                         | -                     | 8-2836408-5 | 1901094-3   | -         | 2168400-6 (QUANTITY 2) |
|                                                                                  |                                                    |                                                       |                          |                                                                                                        |                   | SMART APPLICATOR                  | 2161326-1             | -           | 8-2836408-4 | -         | -                      |
|                                                                                  | 2-2836408-5                                        | A                                                     | FINE CRIMP HEIGHT ADJUST | SERVO<br>LATCH PLATE  |                   | -                                 | -                     | -           | -           | -         | -                      |
|                                                                                  |                                                    |                                                       |                          |                                                                                                        |                   | PNEUMATIC FEED                    | 2119950-1             | 1338683-9   | 5-18022-5   | 2119641-2 | 2119799-1              |
| 2-2836408-7                                                                      | A                                                  | FINE CRIMP HEIGHT ADJUST                              | NONE                     |                                                                                                        | -                 | -                                 | -                     | -           | -           | -         | -                      |
| 7-2836408-7                                                                      | A                                                  | CRIMP TOOLING KIT                                     | -                        |                                                                                                        | -                 | -                                 | -                     | -           | -           | -         | -                      |

|                                                                                                                        |                  |      |
|------------------------------------------------------------------------------------------------------------------------|------------------|------|
| APPLICATOR DATA                                                                                                        |                  |      |
| CRIMP                                                                                                                  | SIZE             | TYPE |
| WIRE                                                                                                                   | 2.59 mm [ .102 ] | F    |
| INSUL                                                                                                                  | 3.81 mm [ .150 ] | O    |
| APPLICATOR INSTRUCTIONS<br>408-10389  |                  |      |

|                                                                                                                      |                 |                                                                                                                                              |                 |
|----------------------------------------------------------------------------------------------------------------------|-----------------|----------------------------------------------------------------------------------------------------------------------------------------------|-----------------|
| TERMINAL DATA: UTILUX TERMINAL                                                                                       |                 | UTILUX CRIMP SPECIFICATION                                                                                                                   |                 |
| TERMINAL NAME: RING TERMINAL                                                                                         |                 |                                                                                                                                              |                 |
| WIRE STRIP LENGTH<br>4.35-5.15 mm [ .171-.203 IN]                                                                    |                 |  INSULATION DIAMETER RANGE<br>Ø2.20-2.80 mm [ .087-.110 IN] |                 |
| TERMINAL APPLICATION SPECIFICATION  | H3930-2 Rev 3   | -                                                                                                                                            | -               |
| TERMINALS APPLIED                   |                 |                                                                                                                                              |                 |
| TE TERMINAL                                                                                                          | UTILUX TERMINAL | TE TERMINAL                                                                                                                                  | UTILUX TERMINAL |
| 2303645-1                                                                                                            | ET-114CE        | 2303645-2                                                                                                                                    | ET-114CD        |
| 2303645-3                                                                                                            | ET-114CC        | 2303645-4                                                                                                                                    | ET-114CB        |

|                                                                                               |                                                                                                              |                                                                                                                    |
|-----------------------------------------------------------------------------------------------|--------------------------------------------------------------------------------------------------------------|--------------------------------------------------------------------------------------------------------------------|
| WIRE SIZE  | CRIMP HEIGHT mm [ INCH ]  | CRIMP HEIGHT REFERENCE SETTING  |
| 1.00mm2                                                                                       | 1.65+/-0.05 [ .065+/- .002 ]                                                                                 | 6.2                                                                                                                |
| 0.75mm2                                                                                       | 1.55+/-0.05 [ .061+/- .002 ]                                                                                 | 7.3                                                                                                                |
| 0.50mm2                                                                                       | 1.45+/-0.05 [ .057+/- .002 ]                                                                                 | 8.3                                                                                                                |



-  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: 8-2836408-4  
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2836408-5
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.  
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.
-  CUT TO LENGTH AT ASSEMBLY.

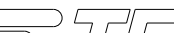
\*WARNING  
ON INSTALLATION, SET WIRE DISC, ITEM 40 TO LARGEST WIRE SIZE SETTING. USE OF SETTINGS BELOW MINIMUM REQUIRED CRIMP HEIGHT SETTING WILL CAUSE DAMAGE TO CRIMP TOOLING.

|     |     |     |     |           |                                     |         |
|-----|-----|-----|-----|-----------|-------------------------------------|---------|
| -   | 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     |
| -77 | -27 | -25 | -22 | PART NO   | DESCRIPTION                         | ITEM NO |

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

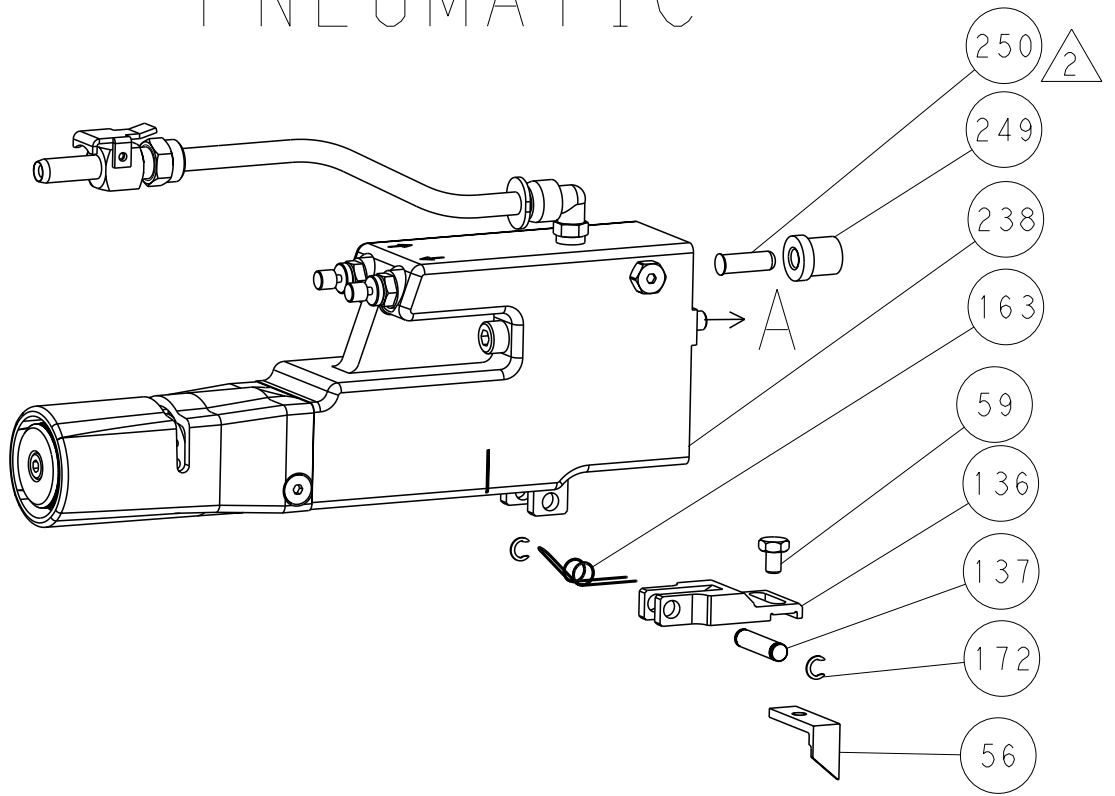
|                           |          |             |           |  |      |     |      |
|---------------------------|----------|-------------|-----------|--|------|-----|------|
| SET UP GAUGE<br>2119599-1 | LOC<br>A | DIST<br>66  | REVISIONS |  |      |     |      |
| P                         | LYR      | DESCRIPTION |           |  | DATE | OWN | APVD |
| -                         | -        | SEE SHEET 1 |           |  | -    | -   | -    |
|                           |          |             |           |  |      |     |      |
|                           |          |             |           |  |      |     |      |

|                                                                                       |     |     |     |             |                                     |         |
|---------------------------------------------------------------------------------------|-----|-----|-----|-------------|-------------------------------------|---------|
| -                                                                                     | 1   | 1   | 1   | 2119082-3   | 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     |
| -                                                                                     | -   | 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     |
| -                                                                                     | 1   | 1   | 1   | 1-2119656-0 | APPLICATOR BASIC ASSEMBLY, SF       | 141     |
| -                                                                                     | 1   | 1   | 1   | 2119650-1   | RAM, ASIAN STYLE, SIDE FEED         | 140     |
|    | -   | 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   | 2217068-1   | BRACKET, AIR BLAST                  | 130     |
| -                                                                                     | 1   | 1   | 1   | 2030758-3   | TUBING, POLYURETHANE                | 129     |
| -                                                                                     | 1   | 1   | 1   | 5018030-2   | NUT, HEX, REG, RoHS, M4             | 128     |
| -                                                                                     | 2   | 2   | 2   | 2168083-3   | SCR, SKT HD CAP, RoHS, M4 X 12.0    | 127     |
| -                                                                                     | 1   | 1   | 1   | 986220-3    | CLAMP, CABLE, BLACK                 | 126     |
| -                                                                                     | 1   | 1   | 1   | 1-22281-8   | SPRING, COMPRESSION                 | 121     |
| -                                                                                     | -   | REF | -   | 2119944-1   | FEED FINGER ASSEMBLY, SF            | 117     |
|    | -   | 1   | 1   | 23238-1     | INSERT, COUPLING                    | 101     |
| -                                                                                     | 2   | 2   | 2   | 2079383-4   | SCR, BHSC, RoHS (M4 X 8)            | 98      |
| -                                                                                     | 1   | 1   | 1   | 1-690438-5  | FRONT STRIP GUIDE                   | 96      |
| -                                                                                     | 2   | 2   | 2   | 2168083-1   | SCR, SKT HD CAP, RoHS, M3 X 8.0     | 95      |
| -                                                                                     | 1   | 1   | 1   | 2168083-6   | SCR, SKT HD CAP, RoHS, M5 X 65      | 93      |
| -                                                                                     | 1   | 1   | 1   | 455888-5    | SPACER, CRIMPER                     | 82      |
| -                                                                                     | 1   | 1   | 1   | 2119956-1   | DOCUMENTATION PACKAGE               | 71      |
| -                                                                                     | 1   | -   | 1   | 2119740-1   | TAG, IDENTIFICATION                 | 67      |
| -                                                                                     | 2   | 2   | 2   | 2168078-1   | SCREW, DRIVE, RH, RoHS, 2 x .188    | 66      |
|  | -   | 1   | 1   | 2119793-1   | LIMITER, ADJUSTMENT BOLT            | 63      |
| -                                                                                     | 3   | 3   | 3   | 992763-5    | SCR, SET, SOC, CONE POINT, M3 x 4.0 | 62      |
| -                                                                                     | 2   | 2   | 2   | 2-18032-5   | SCR, SET, FLT POINT M5 X 20.0       | 61      |
| -                                                                                     | -   | -   | 1   | 5-18022-5   | SCR, HEX HD CAP, M4 X 6.0           | 59      |
| -                                                                                     | -   | -   | 1   | 1338683-9   | FEED PAWL                           | 56      |
|  | -   | 1   | 1   | 3-18031-6   | SCR, SET, CUP POINT M2.5 X 3.0      | 54      |
| -                                                                                     | 2   | 2   | 2   | 2168083-9   | SCR, SKT HD CAP, RoHS, M4 X 20      | 53      |
| -                                                                                     | 1   | 1   | 1   | 1-811242-0  | BUMPER, HOLD DOWN                   | 51      |
| -                                                                                     | 1   | 1   | 1   | 1-1803011-2 | HOLDER, SLUG BLADE                  | 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   | 1-2119644-2 | RAM WASHER, PRECISION               | 38      |
| -                                                                                     | 1   | 1   | 1   | 2161328-1   | HEX HEAD, FLANGED, M5 x 8mm LONG    | 32      |
| -                                                                                     | 2   | 2   | 2   | 1-2168083-3 | SCR, SKT HD CAP, RoHS, M3 X 16      | 30      |
| -                                                                                     | 1   | 1   | 1   | 2-1901091-2 | PLATE, REAR STRIP GUIDE             | 29      |
| -                                                                                     | 2   | 2   | 2   | 22281-9     | SPRING, COMPRESSION                 | 27      |
| -                                                                                     | 1   | 1   | 1   | 356835-1    | LEVER, DRAG RELEASE                 | 26      |
| -                                                                                     | 1   | 1   | 1   | 240792-1    | DRAG, TERMINAL                      | 25      |
| -                                                                                     | 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      |
| -                                                                                     | 6   | 6   | 6   | 1-18028-2   | WASHER, FLAT, REG M4                | 20      |
| -                                                                                     | 1   | 1   | 1   | 1-2119533-0 | STRIPPER, SIDE FEED                 | 19      |
| -                                                                                     | 1   | 1   | 1   | 1-189124-4  | GUIDE, FRONT STRIP                  | 12      |
|  | -   | 1   | 1   | 2161951-5   | BLADE, SLUG                         | 10      |
|  | -   | 1   | 1   | 2063687-8   | PLATE, REAR SHEAR                   | 9       |
|  | 1   | 1   | 1   | 1803443-1   | ANVIL, SPECIAL, COMBINATION         | 8       |
| -                                                                                     | -   | -   | -   | -           | -                                   | 7       |
| -                                                                                     | -   | -   | -   | -           | -                                   | 6       |
| -                                                                                     | -   | -   | -   | -           | -                                   | 5       |
| -                                                                                     | 1   | 1   | 1   | 238009-1    | BLOCK, FL CRIMPER SPACER            | 4       |
|  | 1   | 1   | 1   | 3-1633965-1 | CRIMPER, INSULATION O PREMIUM       | 3       |
| -                                                                                     | 1   | 1   | 1   | 455888-9    | SPACER, CRIMPER                     | 2       |
|  | 1   | 1   | 1   | 1-1633664-0 | CRIMPER, WIRE                       | 1       |
| -77                                                                                   | -27 | -25 | -22 | PART NO     | DESCRIPTION                         | ITEM NO |

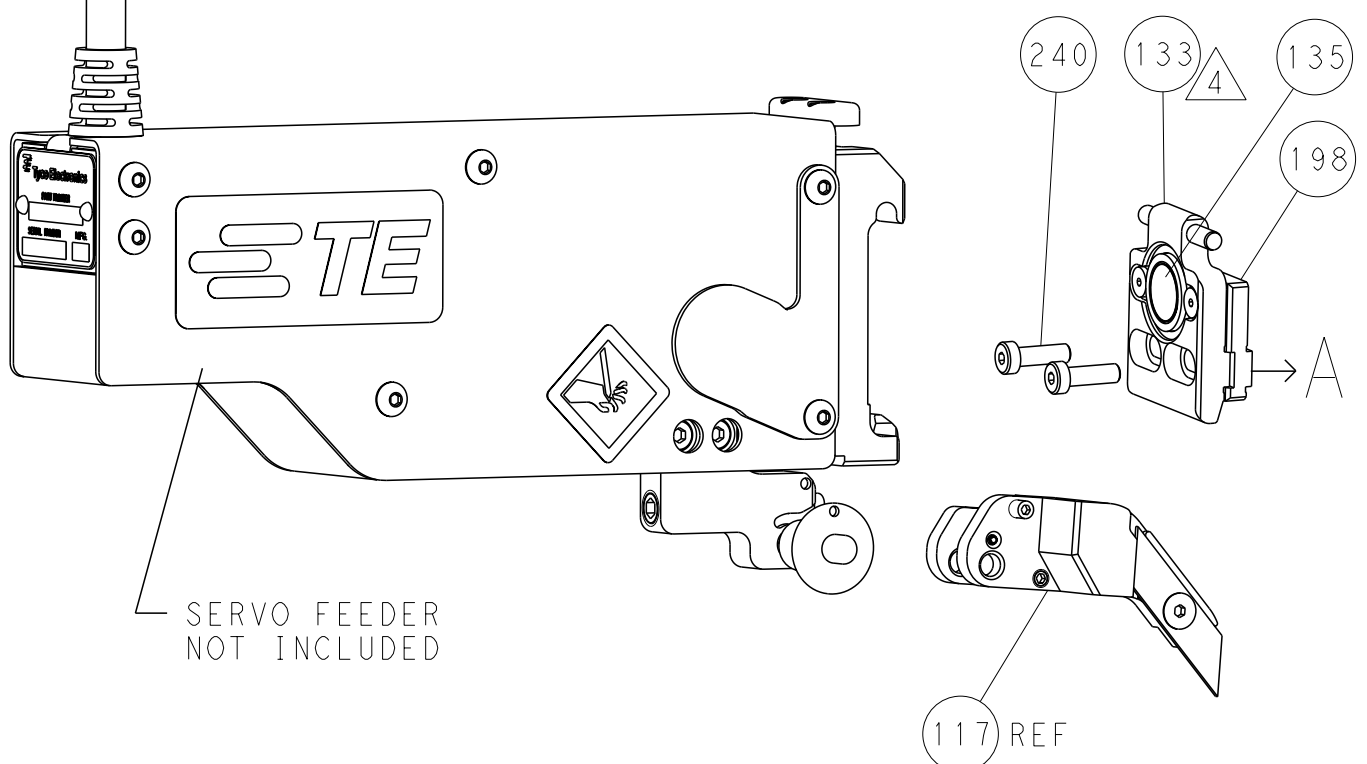
|                                                                                                                       |  |                                                                 |  |                  |           |                                                                                                                                    |  |                    |  |
|-----------------------------------------------------------------------------------------------------------------------|--|-----------------------------------------------------------------|--|------------------|-----------|------------------------------------------------------------------------------------------------------------------------------------|--|--------------------|--|
| THIS DRAWING IS CONTROLLED. FOR INFORMATION, THE ENGINEERING ORGANIZATION SHALL BE CONTACTED FOR THE LATEST REVISION. |  |                                                                 |  | OWN<br>M. HERR   | 21SEP2016 |  TE Connectivity<br>Harrisburg, PA 17105-3608 |  |                    |  |
|                                                                                                                       |  |                                                                 |  | CHK<br>T. ELBIN  | 21SEP2016 |                                                                                                                                    |  |                    |  |
| DIMENSIONS:<br>mm                                                                                                     |  | TOLERANCES UNLESS OTHERWISE SPECIFIED:                          |  | APVD<br>T. ELBIN | 21SEP2016 | NAME<br>Ocean Side Feed<br>Applicator                                                                                              |  |                    |  |
|                                  |  | 0 PLC ±<br>1 PLC ±<br>2 PLC ±<br>3 PLC ±<br>4 PLC ±<br>ANGLES ± |  | PRODUCT SPEC     |           | SIZE<br>A1                                                                                                                         |  | CASE CODE<br>00779 |  |
| MATERIAL<br>-                                                                                                         |  | FINISH<br>-                                                     |  | APPLICATION SPEC |           | DRAWING NO<br>©=2836408                                                                                                            |  | RESTRICTED TO<br>- |  |
|                                                                                                                       |  |                                                                 |  | WEIGHT<br>-      |           | SCALE<br>1:2                                                                                                                       |  | SHEET<br>3 OF 4    |  |
| Customer Accessible Production Drawing                                                                                |  |                                                                 |  |                  |           | REV<br>A                                                                                                                           |  |                    |  |

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

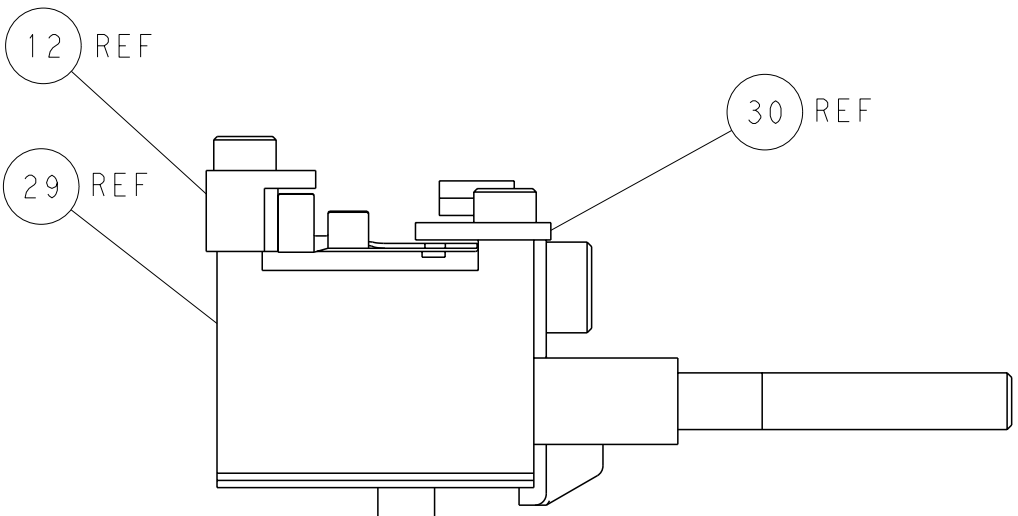
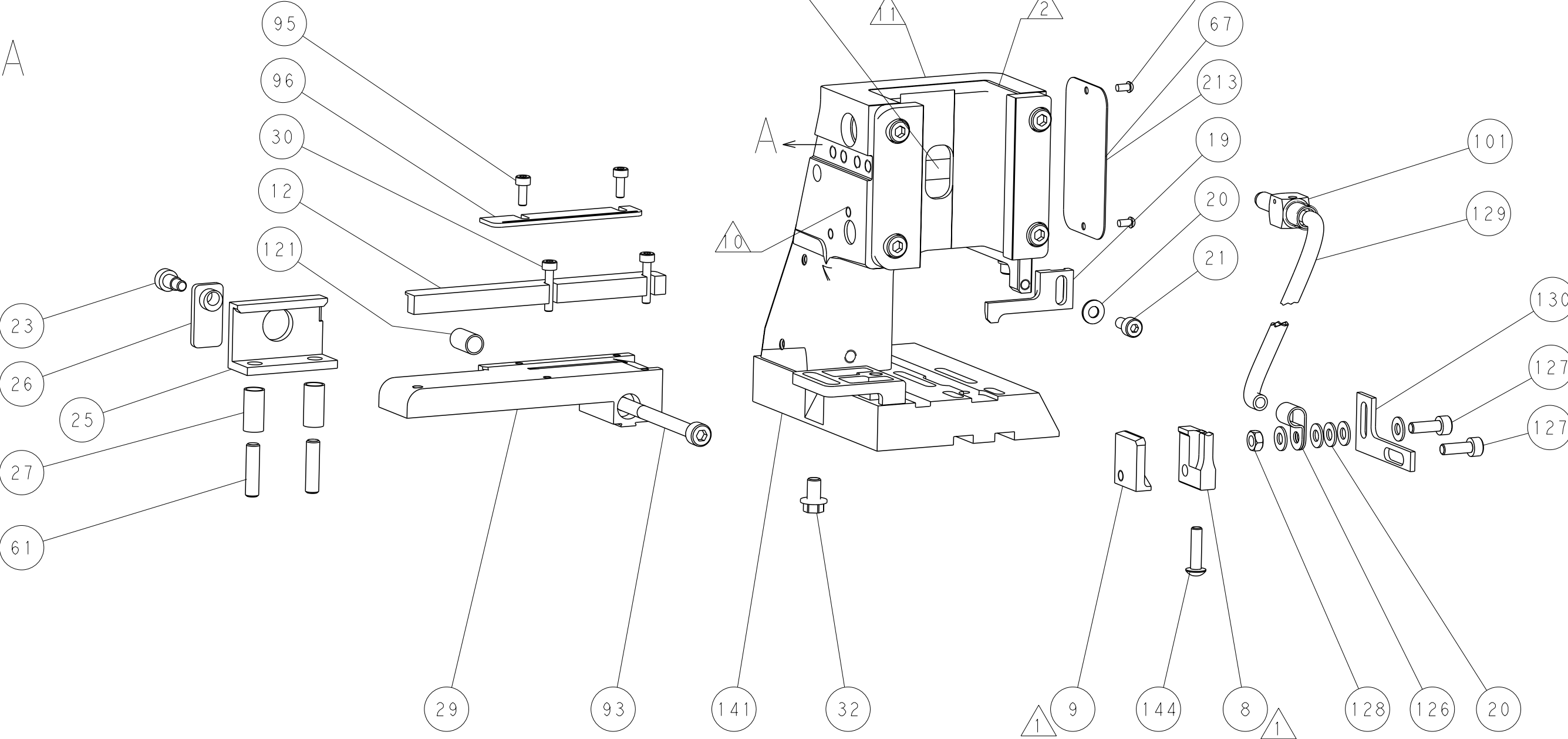
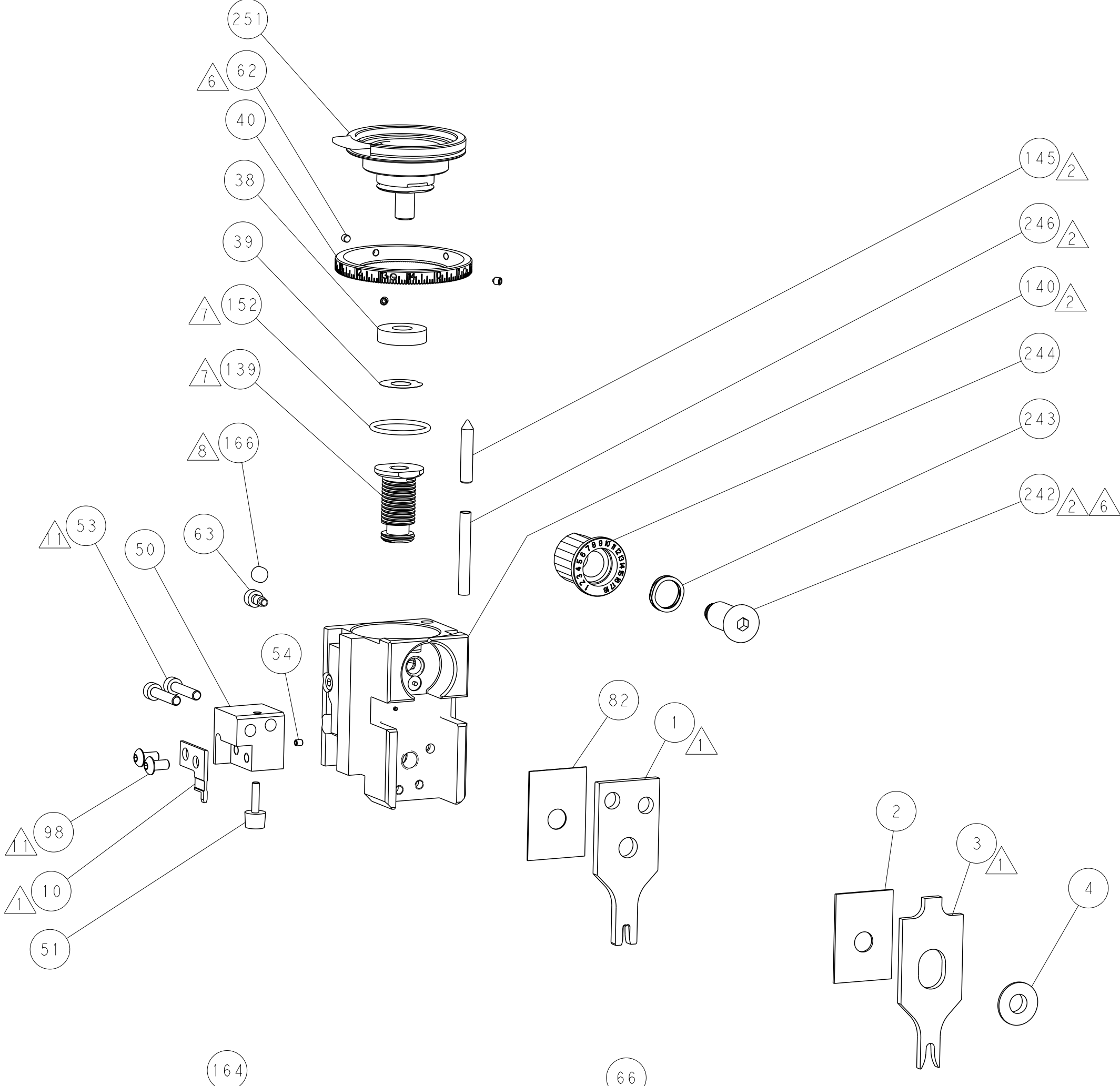
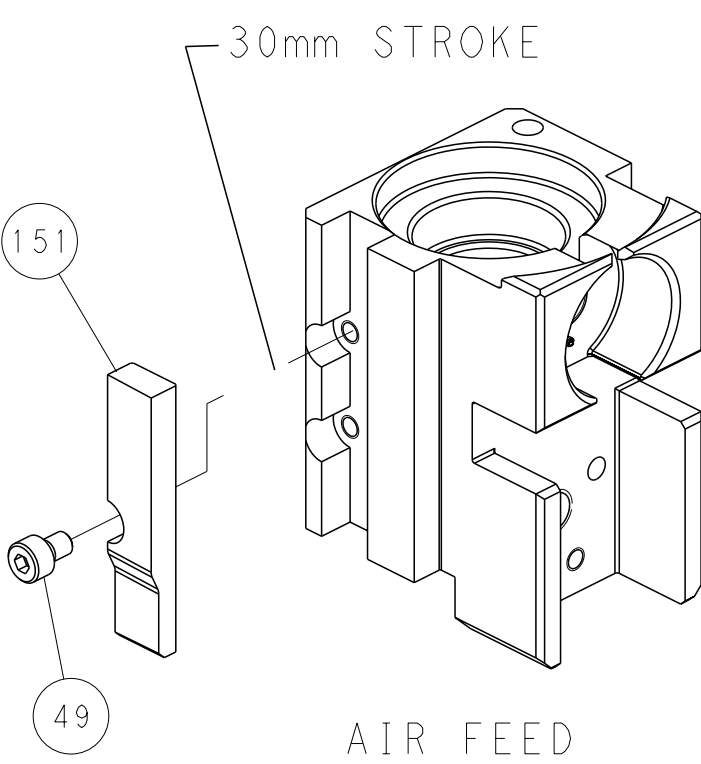
FEED TYPE  
PNEUMATIC



SERVO  
LATCH PLATE



CAM POSITION



FEED TRACK POSITION  
GUIDE AS SHOWN.

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<br>OTHERWISE SPECIFIED: |  | DWN<br>M. HERR                         |  | 21SEP2016 |  | STE TE Connectivity       |  |
| mm          |  | 0 PLC ±                                   |  | CMK<br>T. ELBIN                        |  | 21SEP2016 |  | Harrisburg, PA 17105-3608 |  |
| FINISH      |  | 1 PLC ±                                   |  | APVD<br>T. ELBIN                       |  | 21SEP2016 |  | NAME                      |  |
| MATERIAL    |  | 2 PLC ±                                   |  | PRODUCT SPEC                           |  |           |  | Ocean Side Feed           |  |
|             |  | 3 PLC ±                                   |  | APPLICATION SPEC                       |  |           |  | Applicator                |  |
|             |  | 4 PLC ±                                   |  | WEIGHT                                 |  | -         |  | SIZE                      |  |
|             |  | ANGLES                                    |  | Customer Accessible Production Drawing |  | SCALE     |  | 1:2                       |  |
|             |  |                                           |  |                                        |  |           |  | SHEET                     |  |
|             |  |                                           |  |                                        |  |           |  | 4                         |  |
|             |  |                                           |  |                                        |  |           |  | OF                        |  |
|             |  |                                           |  |                                        |  |           |  | 4                         |  |
|             |  |                                           |  |                                        |  |           |  | REV                       |  |
|             |  |                                           |  |                                        |  |           |  | A                         |  |

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