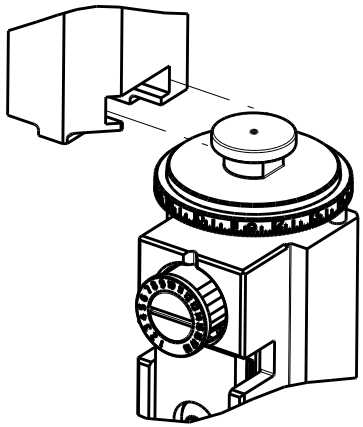
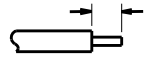
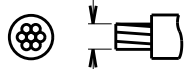



8		7	
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ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION
	2836717-1	C	FINE CRIMP HEIGHT ADJUST
	2836717-2	C	FINE CRIMP HEIGHT ADJUST
	2836717-5	C	FINE CRIMP HEIGHT ADJUST
	2836717-6	C	NON-CRIMP HEIGHT ADJUST
	2836717-7	C	FINE CRIMP HEIGHT ADJUST
	7-2836717-7	B	CRIMP TOOLING KIT

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.29 mm [.090]	F
INSUL	3.10 mm [1.22]	OV
APPLICATOR INSTRUCTIONS 408-10389		

TERMINAL DATA: G&H LEAR TERMINAL LEAR CRIMP SPECIFICATION			
TERMINAL NAME: CARLINE PIN RECEPTACLE TERMINAL			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
4.50-5.00 mm [1.77-.197 IN]		Ø1.40-2.10 mm [.055-.083 IN]	
TERMINAL APPLICATION SPECIFICATION	25004 Rev 2	-	-
TERMINALS APPLIED ³			
TE TERMINAL	G&H LEAR TERMINAL	TE TERMINAL	G&H LEAR TERMINAL
2303685-1	25004.223.111	2303685-2	25004.223.141

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING ⁹
1.00mm2		1.35+/-0.05 [.053+/- .002]		7.8
0.75mm2		1.25+/-0.05 [.049+/- .002]		8.8
0.50mm2		1.20+/-0.05 [.047+/- .002]		9.4



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: 8-2836717-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2836717-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2836717-5
SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2836717-6

5. ADJUSTMENT OF THE STRIPPER MAY BE REQUIRED WHEN MOVING THE APPLICATOR BETWEEN BENCH AND LEADMAKER APPLICATIONS.

6 APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 62. APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242. FOR -6 ONLY APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 37.

7 GREASE THREADS, GROOVE AND O-RING ON ITEMS 35 & 252.

8 MAGNET, ITEM 166 MUST BE ORIENTED CORRECTLY IN ORDER TO PROPERLY ACTUATE THE COUNTER.

9 CRIMP HEIGHT REFERENCE SETTING WAS THE SETTING USED WHEN THE APPLICATOR WAS QUALIFIED AT THE FACTORY. ADJUSTMENT MAY BE NECESSARY WHEN RUNNING APPLICATOR IN THE FIELD.

10 SPARE FEED CAM STORAGE LOCATION REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.

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 4.45.

13 TERMINAL LUBRICANT IS RECOMMENDED.

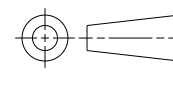
*WARNING
ON INSTALLATION, SET WIRE DISC, ITEM 40 TO LARGEST WIRE SIZE SETTING. USE OF SETTINGS BELOW MINIMUM REQUIRED CRIMP HEIGHT SETTING WILL CAUSE DAMAGE TO CRIMP TOOLING.

1	-	1	1	1	1	1	2280441-1	INSERT, SHEAR	282
2	-	-	1	-	-	-	2119957-2	APPLICATOR SHIM PACK	260
3	-	1	-	1	1	1	8-21084-0	O-RING, .676 ID, .070 DIA. MAT.	252
4	-	-	-	-	1	-	2119640-1	PUSH ROD, AIR FEED	250
5	-	-	-	-	1	-	1803259-1	BUSHING, FLANGED	249
6	-	-	-	-	1	-	2119641-1	FEED CAM, AIR FEED	248
7	-	1	-	1	1	1	2119798-1	DETENT PIN	247
8	-	1	-	1	1	1	1-22279-3	SPRING, COMPRESSION	246
9	-	-	1	-	-	-	2119758-1	RAM, AMP STYLE, SIDE FEED, NON-ADJ.	245
10	-	1	1	1	1	1	2119082-3	CAM, SNAIL, INSULATION ADJUSTMENT	244
11	-	1	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
12	-	1	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
13	-	2	2	2	2	2	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
14	-	2	2	2	-	-	2168400-6	SHCS, LOW HEAD, RoHS, M5 X 16	240
15	-	-	-	-	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
16	-77	-7	-6	-5	-2	-1	PART NO	DESCRIPTION	ITEM NO

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

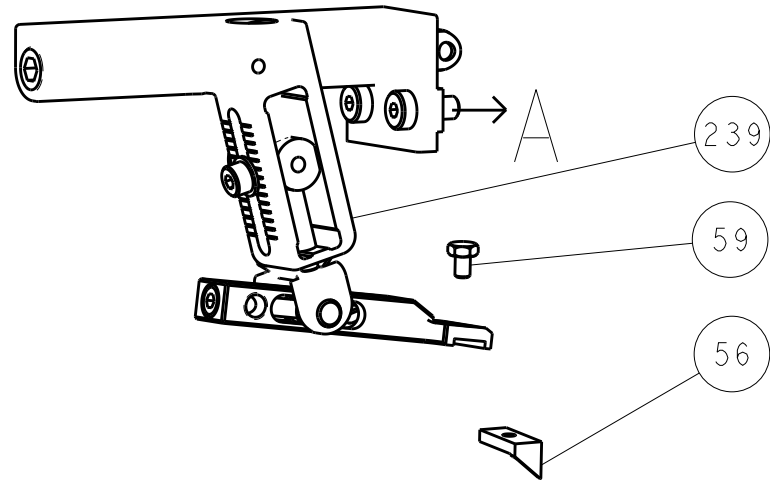
SET UP GAUGE 2119599-1	LOC A	DIST 66	REVISIONS				
	P	LTR	DESCRIPTION		DATE	OWN	APVD
		A	RELEASED		06JUNE2017	TB	CT
		B	ECR-18-001739		05FEB2018	KH	MNP
		C	ECR-18-003442		06MAR2018	MP	MC

-	-	-	-	1	-	2063440-1	AIR FEED MODULE	238
-	1	1	1	1	1	356885-4	STOP, SHEAR	237
-	-	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
3	-	1	1	1	1	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113
-	1	1	1	1	1	1-690438-0	FRONT STRIP GUIDE	96
-	4	4	4	4	4	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	455888-5	SPACER, CRIMPER	82
-	1	1	1	1	1	240641-2	SPACER	81
-	1	1	1	1	1	2119956-1	DOCUMENTATION PACKAGE	71
-	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	992763-5	SCR, SET, SOC, CONE PNT, M3 x 4.0	62
-	2	2	2	2	2	2-18032-5	SCR, SET, FLT PNT, 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	1338683-1	FEED PAWL	56
-	4	4	4	4	4	2168400-1	SHCS, LOW HEAD, RoHS, M4 X 12	54
-	2	2	2	2	2	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	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	690753-6	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	2119645-1	DISC, NUMBERED FA WIRE ADJUSTMENT	40
-	1	-	1	1	1	2119957-1	APPLICATOR SHIM PACK	39
-	1	1	1	1	1	1-2119644-2	RAM WASHER, PRECISION	38
6	-	1	1	1	1	2119085-1	FA HEAD, ATLANTIC STYLE	37
7	-	1	-	1	1	2119092-1	BOLT, ADJUSTMENT	35
-	1	1	1	1	1	2161328-1	HEX HEAD, FLANGED, M5 x 8mm LONG	32
-	1	1	1	1	1	3-1901091-2	PLATE, REAR STRIP GUIDE	29
-	1	1	1	1	1	455888-5	SPACER, CRIMPER	28
-	2	2	2	2	2	22283-1	SPRING, COMPRESSION	27
-	1	1	1	1	1	356835-1	LEVER, DRAG RELEASE	26
-	1	1	1	1	1	240792-1	DRAG, TERMINAL	25
-	1	1	1	1	1	4-189124-4	GUIDE, FRONT STRIP	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	2-690463-5	FLOATING SHEAR, REAR	17
-	2	2	2	2	2	1-2168083-1	SCR, SKT HD CAP, RoHS, M3 X 6	16
-	1	1	1	1	1	690464-1	SHEAR PLATE, REAR	15
-	1	1	1	1	1	2119862-1	SHEAR HOLDER, REAR	14
-	1	1	1	1	1	2119806-1	INSERT, SHEAR	13
-	2	2	2	2	2	3-22280-3	SPRING, COMPRESSION	12
-	1	1	1	1	1	1-356885-4	STOP, SHEAR	11
7	-	1	1	1	1	2119805-1	SHEAR HOLDER, FRONT	10
8	-	1	1	1	1	1803095-1	FLOATING SHEAR, FRONT -	9
9	1	1	1	1	1	7-1803058-7	ANVIL, COMBINATION	8
-	1	1	1	1	1	3-240641-3	SPACER	7
-	1	1	1	1	1	690468-1	DEPRESSOR SHEAR, REAR	6
-	1	1	1	1	1	2119757-4	DEPRESSOR, SHEAR	5
-	1	1	1	1	1	2-238011-1	BLOCK, CRIMPER SPACER	4
1	1	1	1	1	1	7-1633963-6	CRIMPER, INSULATION OVERLAP PREMIUM	3
-	1	1	1	1	1	1-455888-1	SPACER, CRIMPER	2
1	1	1	1	1	1	3-456406-3	CRIMPER, WIRE PREMIUM	1
-77	-7	-6	-5	-2	-1	PART NO	DESCRIPTION	ITEM NO

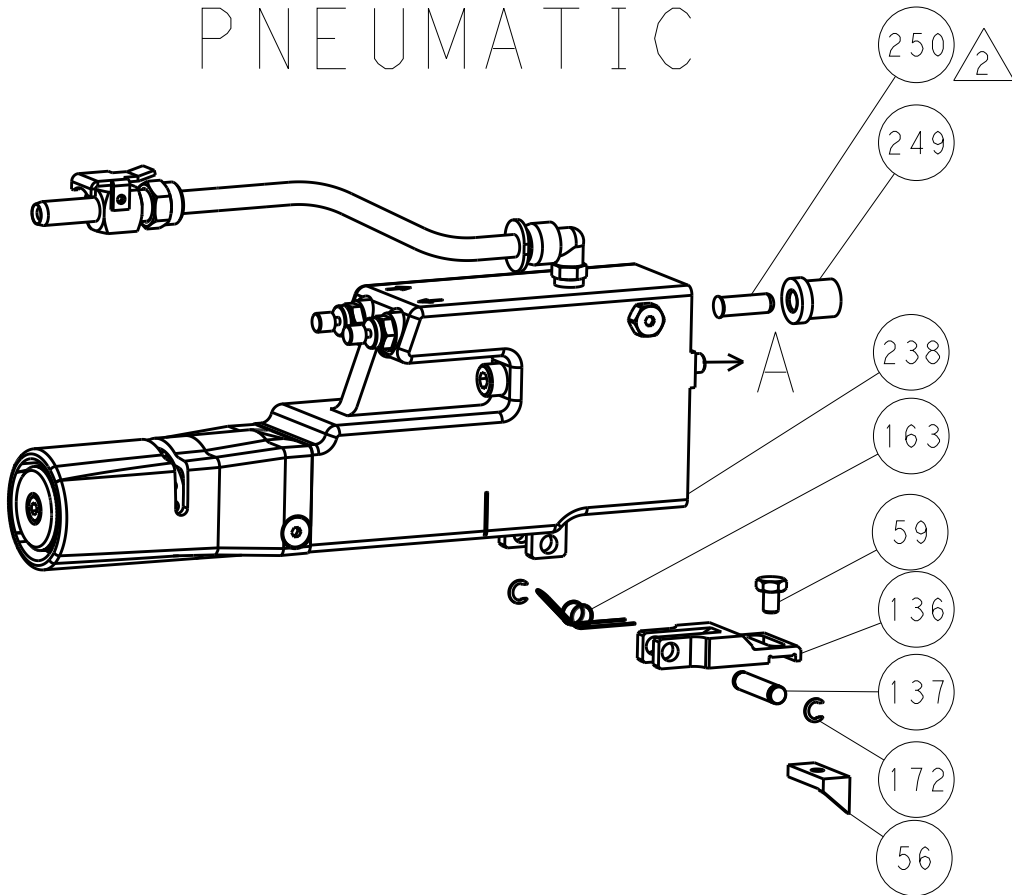
THIS IS SUBJECT TO CHANGE WITHOUT NOTICE. THE USER SHALL BE RESPONSIBLE FOR VERIFYING THE LATEST REVISIONS OF THIS DRAWING. THE USER SHALL BE CONTACTED FOR THE LATEST REVISIONS.				OWN D. WEAVER CHK T. ELBIN APVD T. ELBIN	08MAY2017 08MAY2017 08MAY2017	TE Connectivity Harrisburg, PA 17105-3608							
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.01 1 PLC ±.01 2 PLC ±.01 3 PLC ±.01 4 PLC ±.01 ANGLES ±.01		PRODUCT SPEC - APPLICATION SPEC -		NAME Ocean Side Feed Applicator -							
						SIZE A1		CAGE CODE 00779		DRAWING NO C2836717		RESTRICTED TO -	
MATERIAL -		FINISH -		WEIGHT -		Customer Accessible Production Drawing							
						SCALE 1:2		SHEET 1		OF 4		REV C	

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

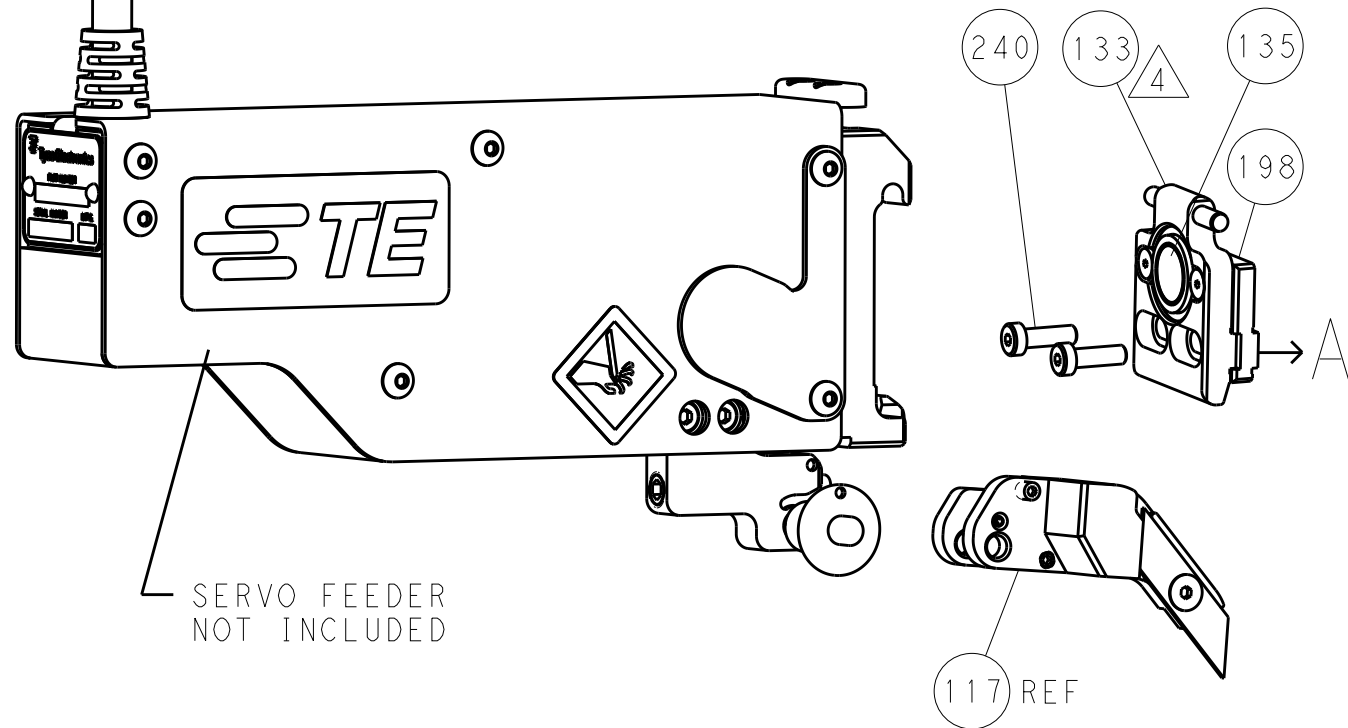
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MECHANICAL



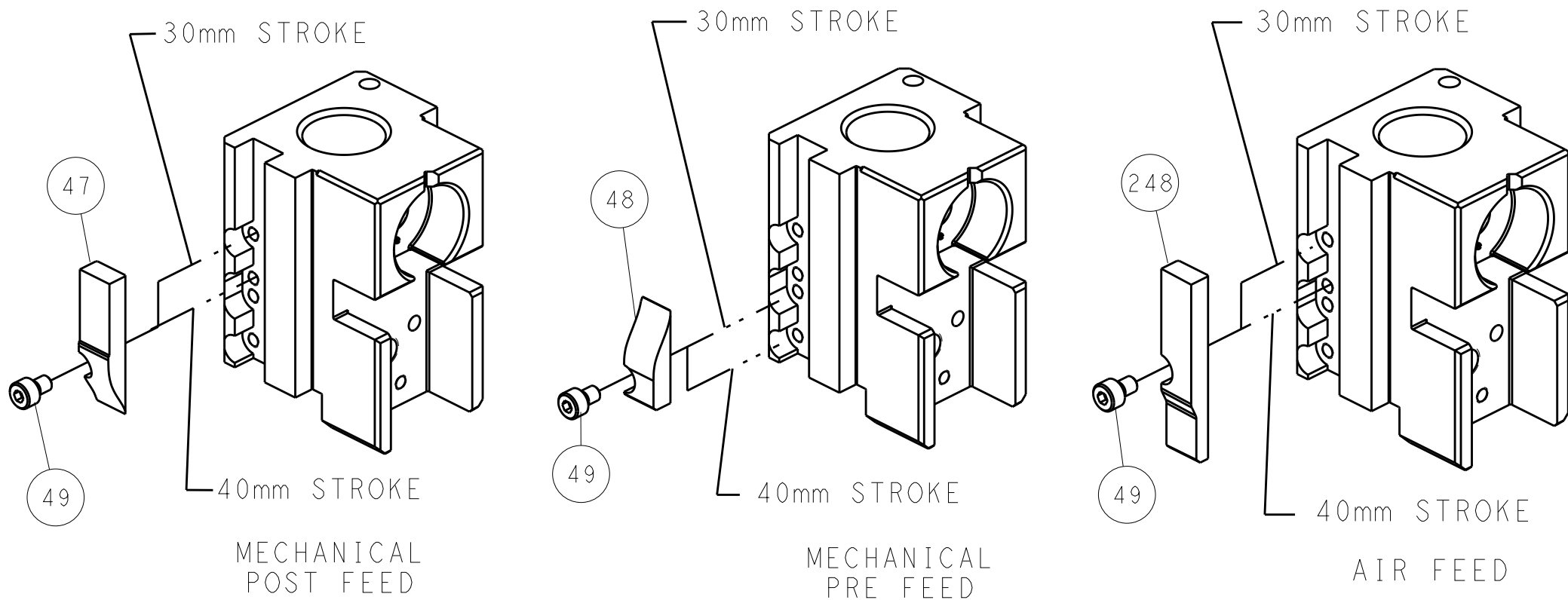
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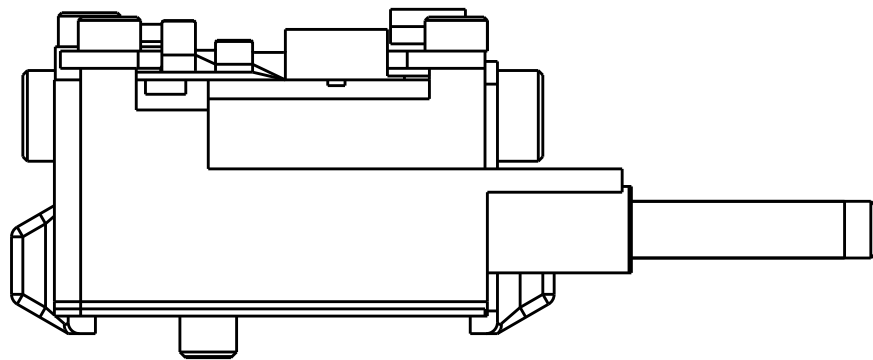
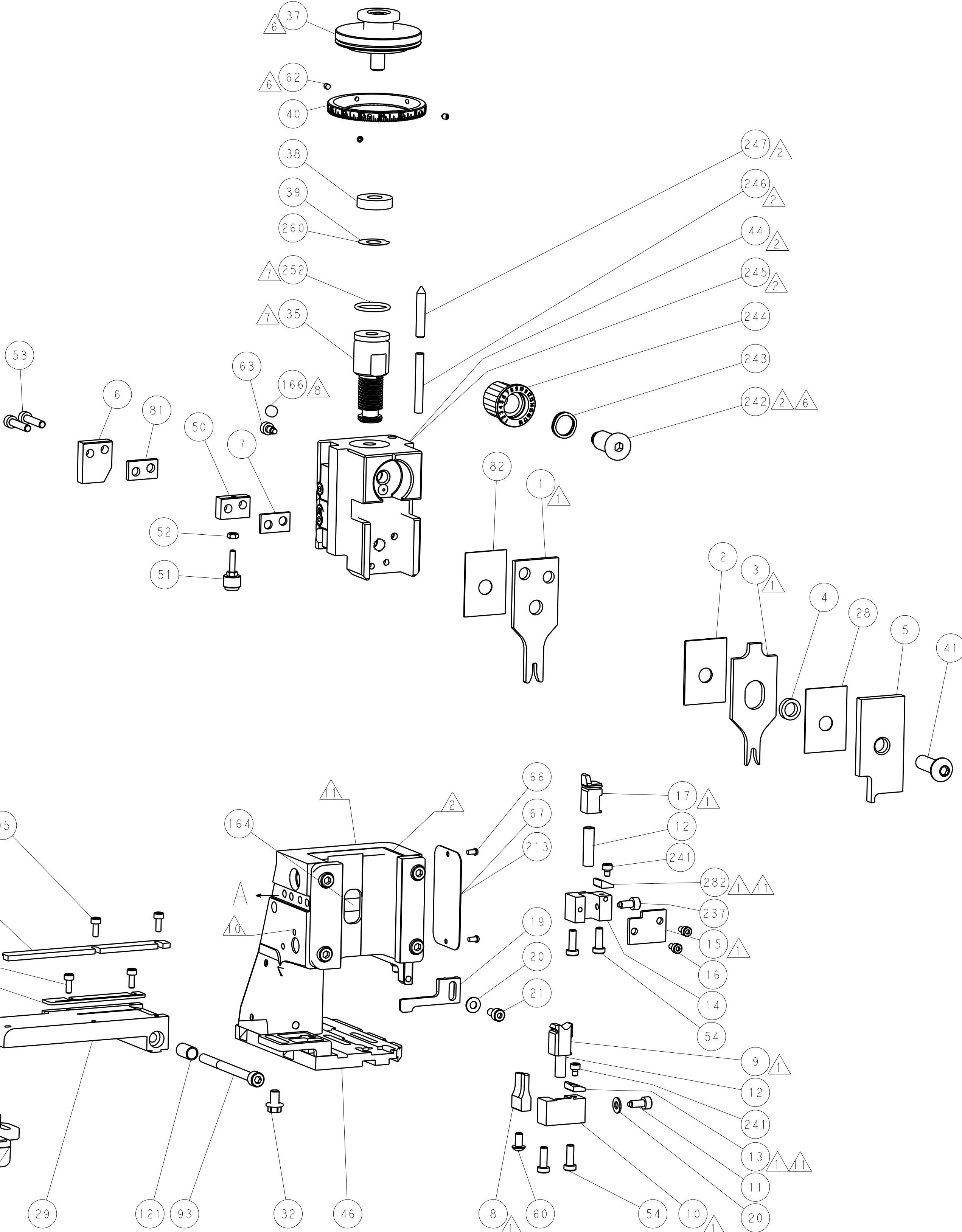
SERVO
LATCH PLATE



CAM POSITIONS



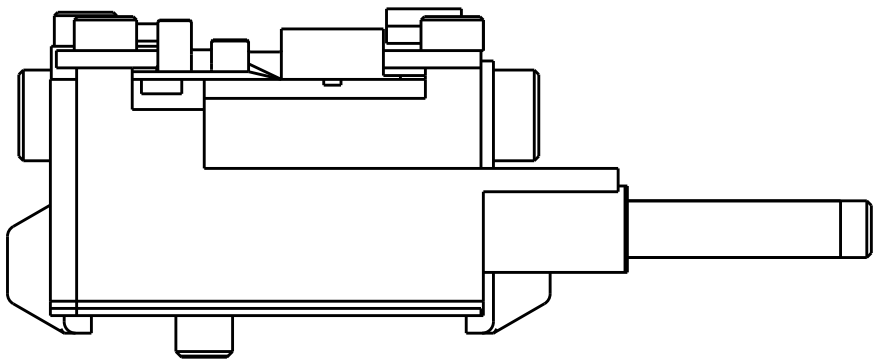
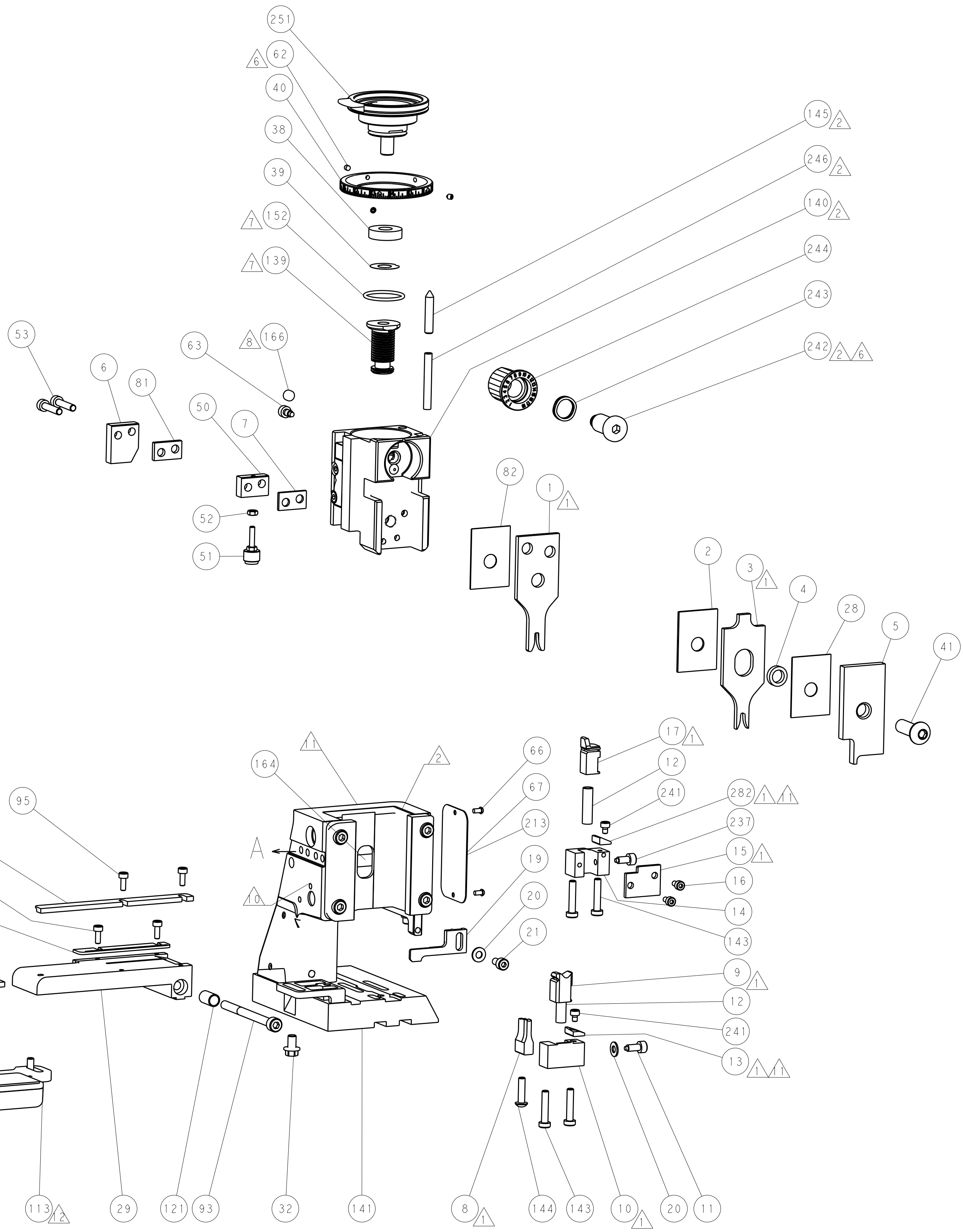
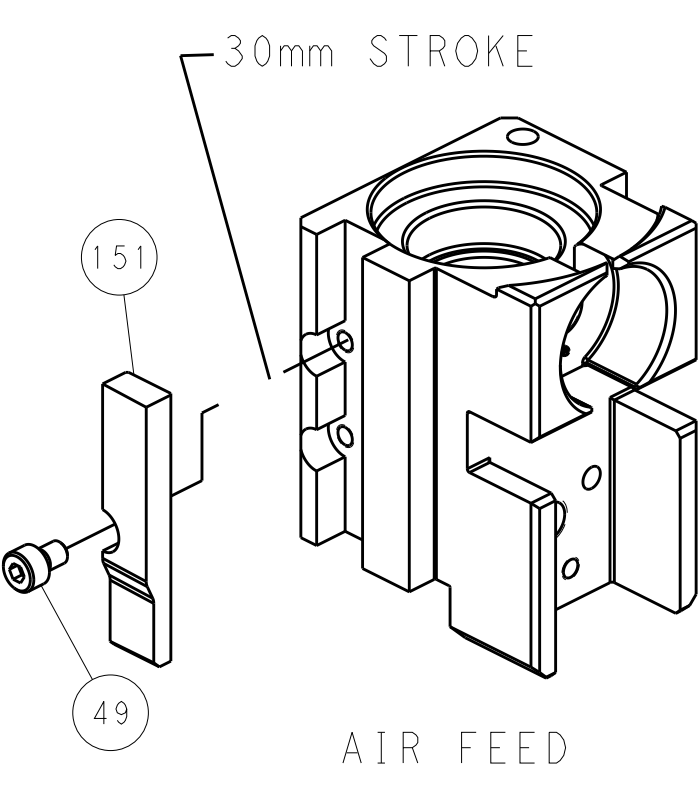
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)




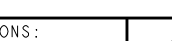
FEED TRACK POSITION
GUIDE BY INSULATION BARREL

1ST FORMERLY IT IS CONTROLLED TOUGHNESS FOR THE ELECTRONIC CORPORATION IT IS SUBJECT TO CHANGE WITHOUT NOTICE AND THE ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST POSITION.		DWN B. WEAVER 08MAY2017	TE Connectivity Harrisburg, PA 17105-3608	
CHG T. ELBIN 08MAY2017		NAME Ocean Side Feed Applicator	RESTRICTED TO	
APVD T. ELBIN 08MAY2017		PRODUCT SPEC	SIZE A1	
APPLICATION SPEC		WEIGHT	CAGE CODE 00779	
MATERIAL		FINISH	DRAWING NO C-2836717	
Customer Accessible Production Drawing		SCALE 1:2	SHEET 2 of 4	
			REV C	

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



FEED TRACK POSITION
GUIDE BY INSULATION BARREL

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DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		FINISH -		WEIGHT -		SCALE 1:2		SHEET 4		OF 4	
MATERIAL -		FINISH -		WEIGHT -		SCALE 1:2		SHEET 4		OF 4		REV C	
Customer Accessible Production Drawing													

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