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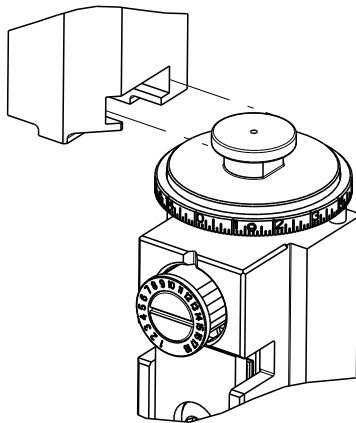
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ATLANTIC VERSION
TERMINATOR
INTERFACE ADAPTER

PART
NUMBER

REVISION

DESCRIPTION



2836474 1

A

FINE CRIMP HEIGHT ADJUST

2836474 2

A

FINE CRIMP HEIGHT ADJUST

2836474 5

A

FINE CRIMP HEIGHT ADJUST

2836474 6

A

NON CRIMP HEIGHT ADJUST

2836474 7

A

FINE CRIMP HEIGHT ADJUST



7-2836474-7

A

CRIMP TOOLING KIT

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.37 mm [.054]	F
INSUL	1.40 mm [.055]	F
APPLICATOR INSTRUCTIONS 408-10389		

TERMINAL DATA: JST TERMINAL		JST CRIMP SPECIFICATION
TERMINAL NAME: TERMINAL_INTERLOCK		
WIRE STRIP LENGTH 2.10-2.10 mm [.083-.083 IN]		INSULATION DIAMETER RANGE Ø1.00-1.50 mm [.039-.059 IN]
TERMINAL APPLICATION SPECIFICATION	HM-0003(CHM-1-070) Rev R6	-
TERMINALS APPLIED ³ ⁴		
TE TERMINAL	JST TERMINAL	TE TERMINAL
286828-1	SPHD-001T-P0.5	

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING ⁹
22 AWG		0.75+/-0.05 [.030+/- .002]		5.9
24 AWG		0.70+/-0.05 [.028+/- .002]		6.3
26 AWG		0.65+/-0.05 [.026+/- .002]		6.8



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: 8-2836474-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2836474-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2836474-5
SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2836474-6

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 5.05.

¹³ TERMINAL LUBRICANT IS RECOMMENDED.

¹⁴ THIS APPLICATOR IS SPECIFIC FOR USE IN A STRIPPER SEAL TERMINATING UNIT.



*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.

¹²	-	-	1	-	-	-	2119957-2	APPLICATOR SHIM PACK	260
¹⁷	-	1	-	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
	-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)

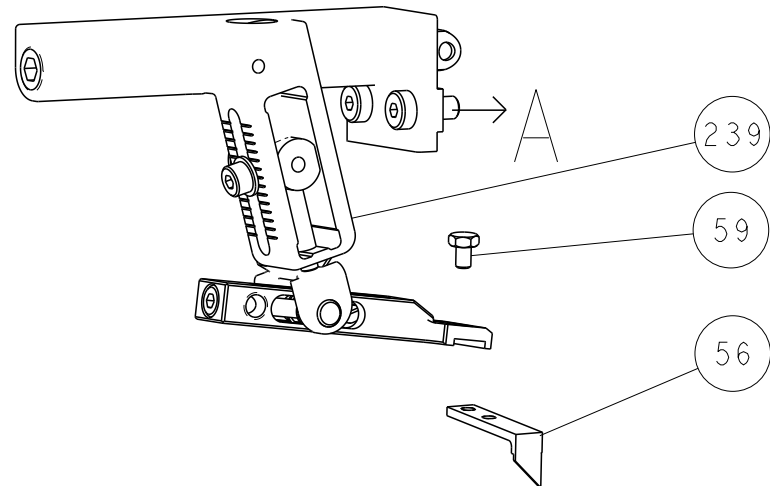
SET UP GAUGE 2119599-1	LOC A	DIS 66	REVISIONS							
			P	LTR	DESCRIPTION			DATE	DWN	APVD
				A	RELEASED			26OCT2016	MR	CT
				A1	ECR-16-016393			18NOV2016	RS	LZ
				A2	ECR-18-015499			02OCT2018	TB	TE

-	-	-	-	1	-	2119641-1	FEED CAM, AIR FEED	248
-	1	-	1	1	1	2119798-1	DETENT PIN	247
-	1	-	1	1	1	1-22279-3	SPRING, COMPRESSION	246
-	-	1	-	-	-	2119758-1	RAM, AMP STYLE, SIDE FEED, NON-ADJ.	245
-	1	1	1	1	1	2119082-5	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	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	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
⁶	-	1	1	-	-	1901094-3	SPACER, FEEDER	198
-	1	1	1	1	1	1-1752354-5	STANDOFF, HOLD-DOWN	180
-	1	1	1	1	1	993111-1	PIN, SLOTTED SPRING 3.0 X 20.0	177
-	1	1	1	1	1	8-22280-7	SPRING, COMPRESSION	176
-	1	1	1	1	1	1752353-2	GUIDE PIN,HOLDDOWN	175
-	1	1	1	1	1	1901680-2	GUIDE PIN,HOLDDOWN	174
-	-	-	-	2	-	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172
⁸	-	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
-	-	REF	REF	-	-	2119944-1	FEED FINGER ASSEMBLY,SF	117
-	1	1	1	1	1	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113
-	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	2119791-9	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	992763-5	SCR, SET, SOC, CONE PNT, M3 x 4.0	62
-	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
-	1	1	1	1	1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52
-	1	1	1	1	1	4-1722335-3	STRIPPER, SIDE FEED	51
-	-	-	-	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	2-2119656-1	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	2119085-1	FA HEAD, ATLANTIC STYLE	37
⁷	-	1	-	1	1	2119092-1	BOLT, ADJUSTMENT	35
-	1	1	1	1	1	2-1752356-6	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	1320908-6	SPACER, STRIP GUIDE	30
-	1	1	1	1	1	2119959-1	ASSEMBLY, STRIP GUIDE	29
-	1	1	1	1	1	455888-8	SPACER, CRIMPER	28
-	1	1	1	1	1	1320928-2	STRIP GUIDE	24
-	1	1	1	1	1	1-18028-2	WASHER, FLAT, REG M4	20
¹¹	-	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	1-356885-4	STOP, SHEAR	11
¹	-	1	1	1	1	2119805-1	SHEAR HOLDER, FRONT	10
¹	-	1	1	1	1	1803095-6	FLOATING SHEAR, FRONT -	9
¹	1	1	1	1	1	2-1633927-5	ANVIL, COMBINATION	8
-	-	-	-	-	-	-	-	7
-	-	-	-	-	-	-	-	6
-	1	1	1	1	1	1-2119757-0	DEPRESSOR, SHEAR	5
-	1	1	1	1	1	1-238011-0	BLOCK, CRIMPER SPACER	4
¹	1	1	1	1	1	2-1633962-8	CRIMPER, INSULATION F PREMIUM	3
-	-	-	-	-	-	-	-	2
¹	1	1	1	1	1	4-1633738-6	CRIMPER, WIRE	1
-77	-7	-6	-5	-2	-1	PART NO	DESCRIPTION	ITEM NO

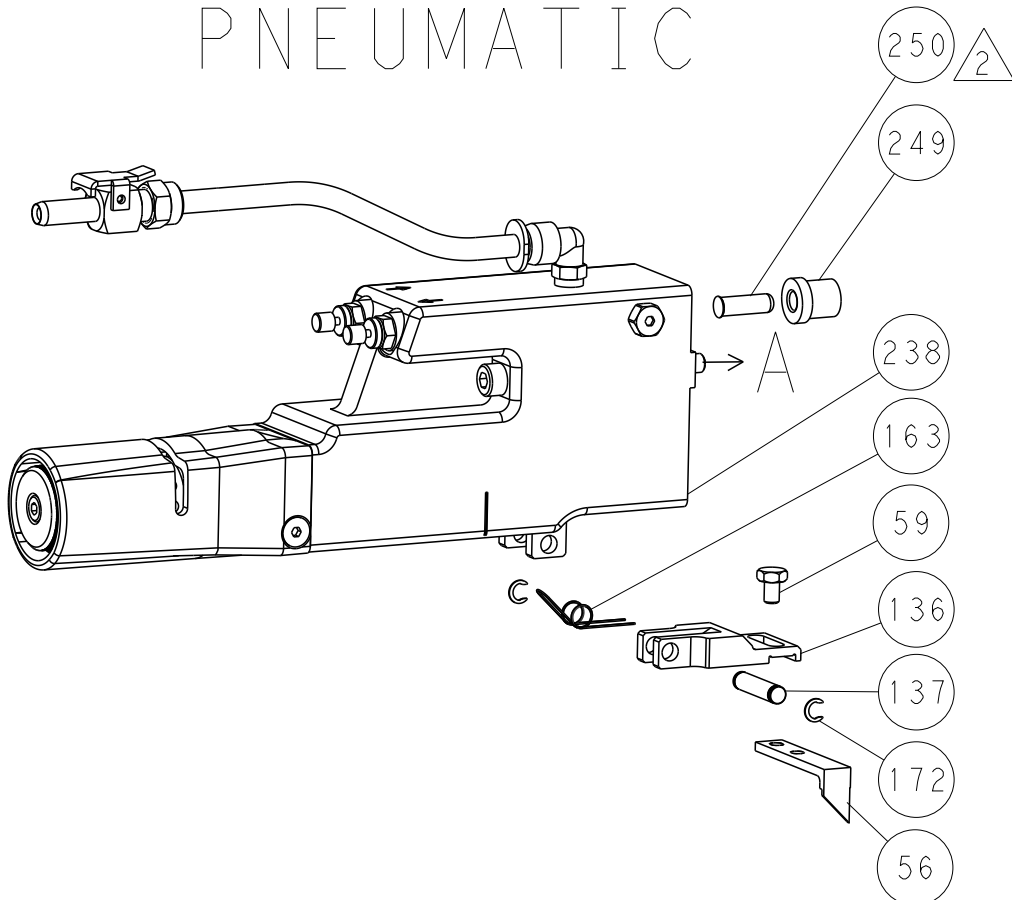
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DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.001 1 PLC ±.001 2 PLC ±.001 3 PLC ±.001 4 PLC ±.001 ANGLES ±.001 FINISH		NAME Ocean Side Feed Applicator	
		CHK C. TOPPER 07OCT2016		APVD J. DEGRANGE 07OCT2016	
MATERIAL -		PRODUCT SPEC		SIZE	
				CAGE CODE	
-		WEIGHT -		DRAWING NO	
				A1 00779 C-2836474	
Customer Accessible Production Drawing		RESTRICTED TO		SCALE	
				1:2	
-		-		SHEET	
				1 OF 4	
-		-		REV	
				A2	

LOC	DIST	REVISIONS					
		P	LTR	DESCRIPTION	DATE	DWN	APVD
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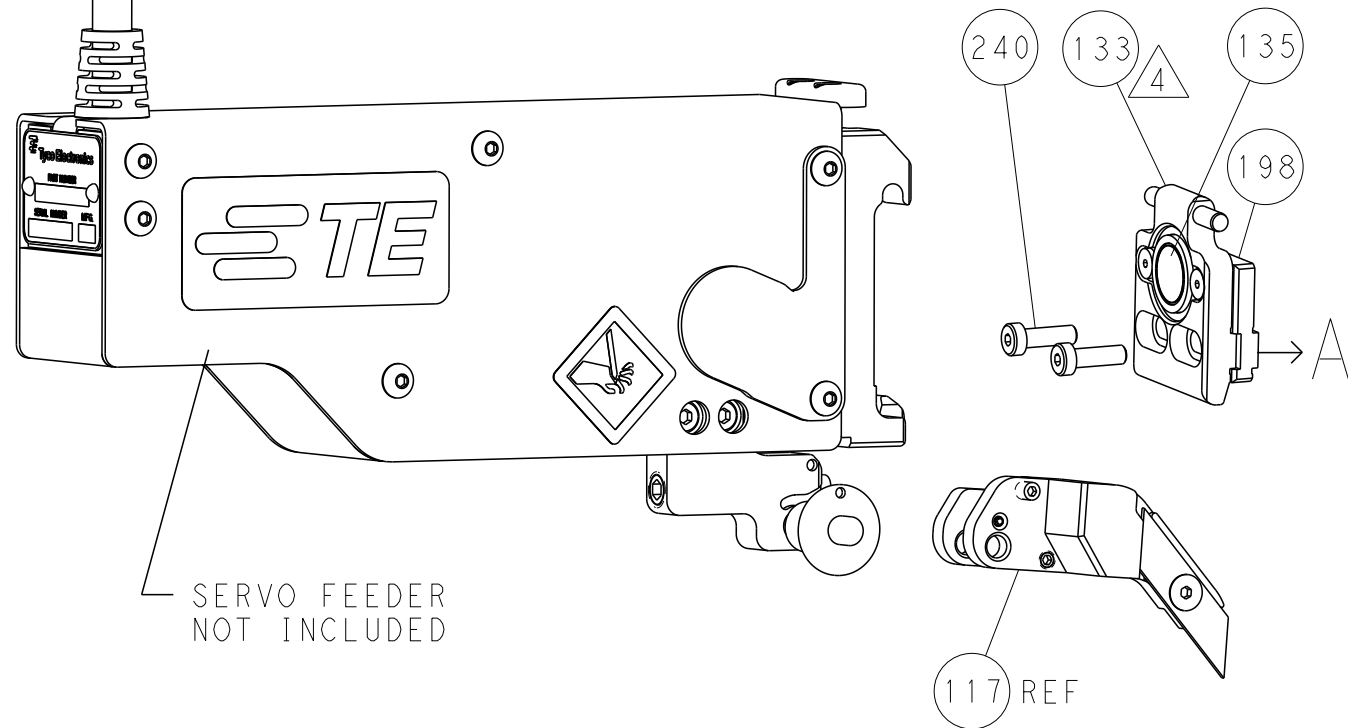
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MECHANICAL



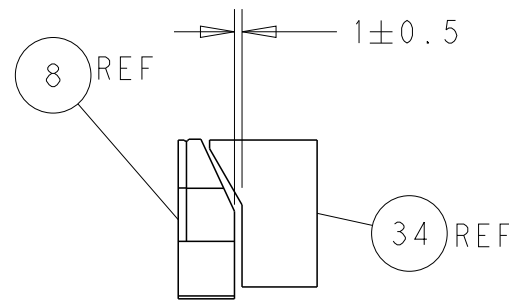
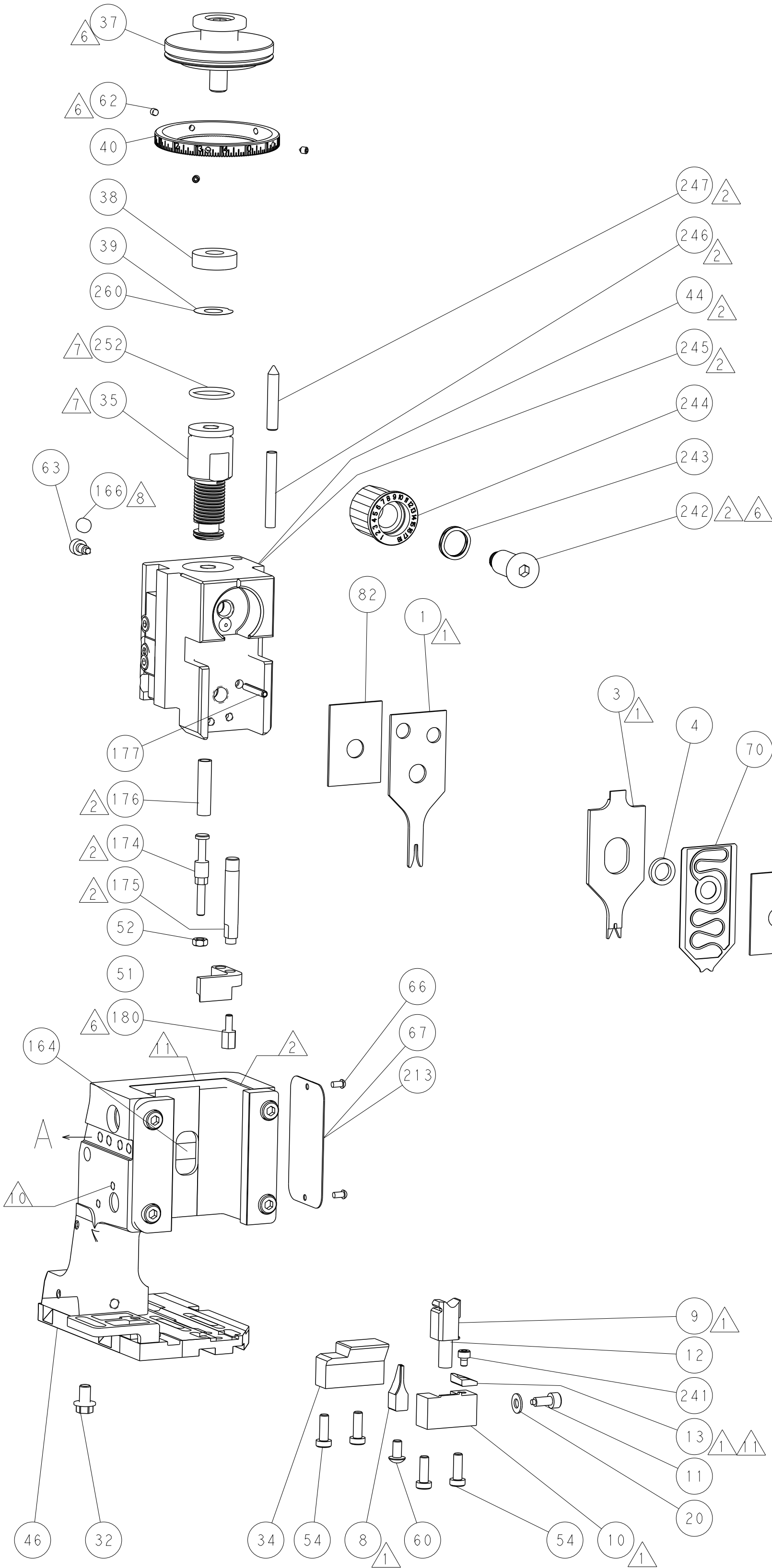
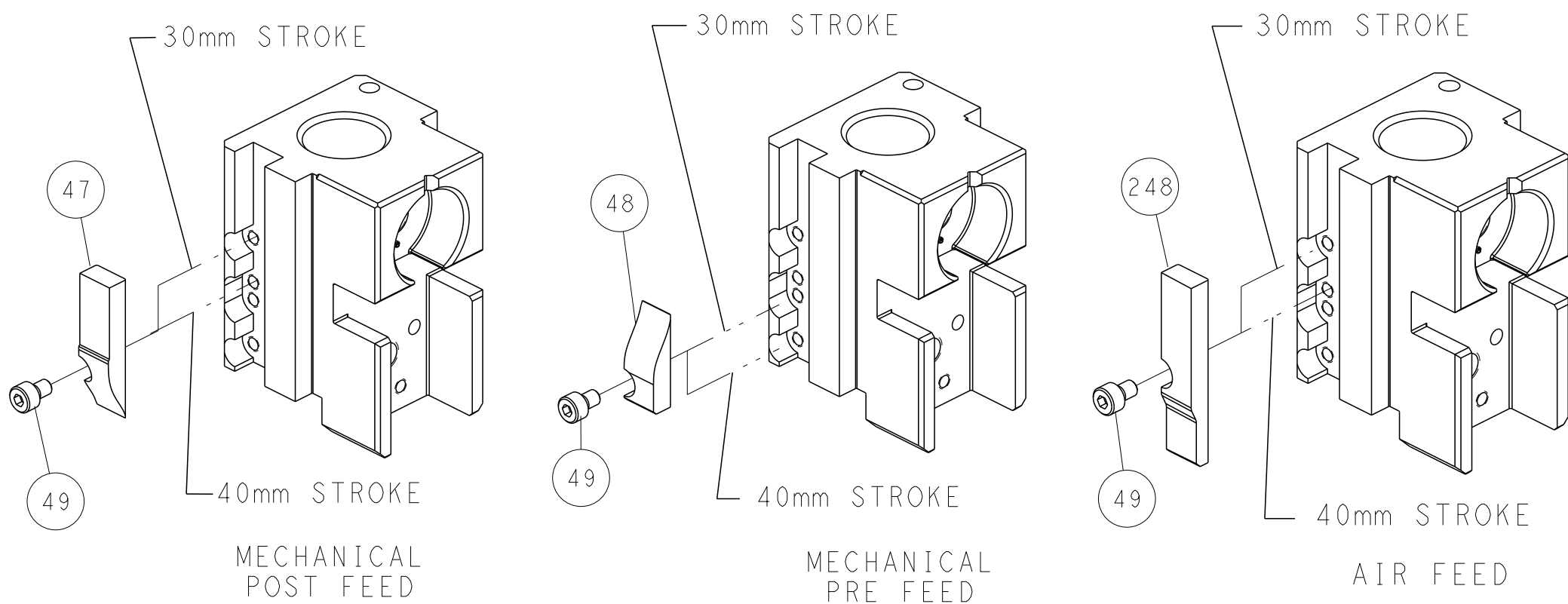
PNEUMATIC



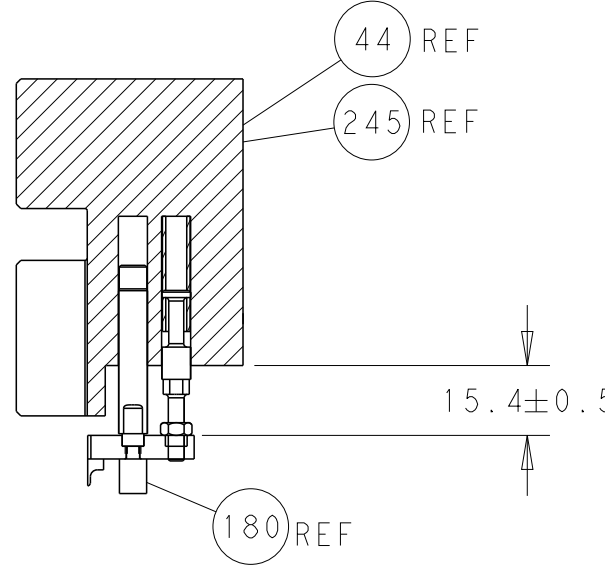
SERVO
LATCH PLATE



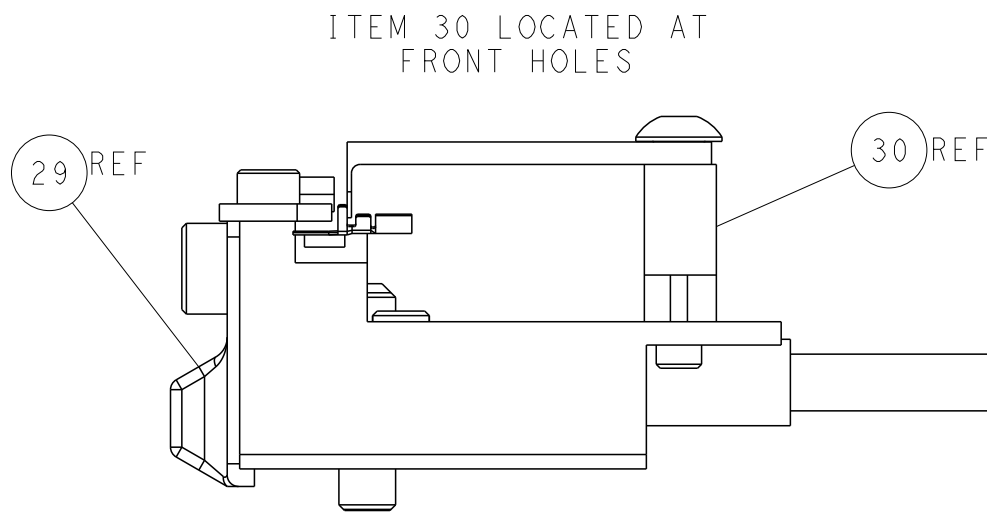
CAM POSITIONS



TERMINAL SUPPORT LOCATION



HOLDDOWN SET-UP



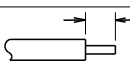



FEED TRACK POSITION
GUIDE BY INSULATION BARREL

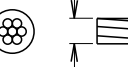

ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

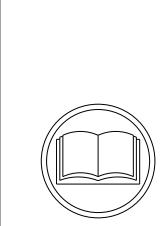
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CHK C. TOPPER 07OCT2016				NAME				Harrisburg, PA 17105-3608			
APVD J. DEGRANGE 07OCT2016				PRODUCT SPEC				Ocean Side Feed			
APPLICATION SPEC				SIZE				A1			
MATERIAL				WEIGHT				00779			
FINISH				SCALE				1:2			
Customer Accessible Production Drawing				SHEET 2 OF 4				REV A2			












PACIFIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	
	2-2836474-1	A	FINE CRIMP HEIGHT ADJUST	MECHANICAL	OBSOLETE
	2-2836474-2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	OBSOLETE
	2-2836474-5	A	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE ⁴	OBSOLETE
	2-2836474-7	A	FINE CRIMP HEIGHT ADJUST	NONE	OBSOLETE
	7-2836474-7	A	CRIMP TOOLING KIT	-	

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.37 mm [.054]	F
INSUL	1.40 mm [.055]	F
APPLICATOR INSTRUCTIONS 408-10389		

TERMINAL DATA: JST TERMINAL		JST CRIMP SPECIFICATION	
TERMINAL NAME: TERMINAL_INTERLOCK			
WIRE STRIP LENGTH 2.10-2.10 mm [.083-.083 IN]			INSULATION DIAMETER RANGE Ø1.00-1.50 mm [.039-.059 IN]
TERMINAL APPLICATION SPECIFICATION 		HM-0003(CHM-1-070) Rev R6	-
TERMINALS APPLIED  		-	-
TE TERMINAL	JST TERMINAL	TE TERMINAL	JST TERMINAL
286828-1	SPHD-001T-P0.5		

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING ⁹
22 AWG		0.75+/-0.05 [.030+/-0.002]		5.9
24 AWG		0.70+/-0.05 [.028+/-0.002]		6.3
26 AWG		0.65+/-0.05 [.026+/-0.002]		6.8



-  RECOMMENDED SPARE PARTS
-  GREASE BEARING SURFACES LIGHTLY
3. LUBRICATE DAILY PER THE APPLICATOR INSTRUCTION SHEET SUPPLIED WITH THE APPLICATOR.
-  APPLICATOR SPECIFIC DATA TO BE ENTERED INTO BLANK MEMORY CHIP AT ASSEMBLY. SEE BELOW FOR PART NUMBER:
MECHANICAL FEED WITH "SMART APPLICATOR" CONVERSION: 8-2836474-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2836474-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2836474-5
5. ADJUSTMENT OF THE STRIPPER MAY BE REQUIRED WHEN MOVING THE APPLICATOR BETWEEN BENCH AND LEADMAKER APPLICATIONS.
-  APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 62.
APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242.
-  GREASE THREADS, GROOVE AND O-RING ON ITEMS 139 & 152.
-  MAGNET MUST BE ORIENTED CORRECTLY IN ORDER TO PROPERLY ACTUATE THE COUNTER.
-  CRIMP HEIGHT REFERENCE SETTING WAS THE SETTING USED WHEN THE APPLICATOR WAS QUALIFIED AT THE FACTORY. ADJUSTMENT MAY BE NECESSARY WHEN RUNNING APPLICATOR IN THE FIELD.
-  SPARE FEED CAM STORAGE LOCATION REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.
-  TO CONVERT THE APPLICATOR TO A NON-CARRIER CUTTING STYLE, REMOVE ITEM 13 AND ATTACH TO THE LOCATION ON BACK SIDE OF THE HOUSING. REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.
-  TERMINAL LUBRICANT IS RECOMMENDED.
-  THIS APPLICATOR IS SPECIFIC FOR USE IN A STRIPPER SEAL TERMINATING UNIT.



*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	2119782-1	FINE ADJUST HEAD ASM, PACIFIC STYLE	251
-	-	-	1	-	2119640-1	PUSH ROD, AIR FEED	250
-77	-27	-25	-22	-21	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 2119599-1		LOC A	DIST 66	REVISIONS			
P	LTR	DESCRIPTION		DATE	OWN	APVD	
-	-	SEE SHEET 1		-	-	-	-

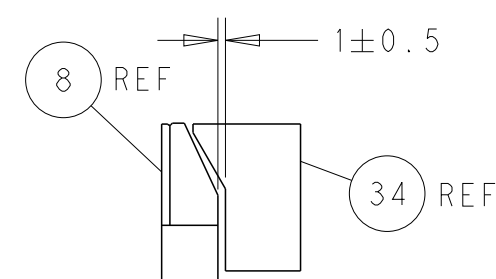
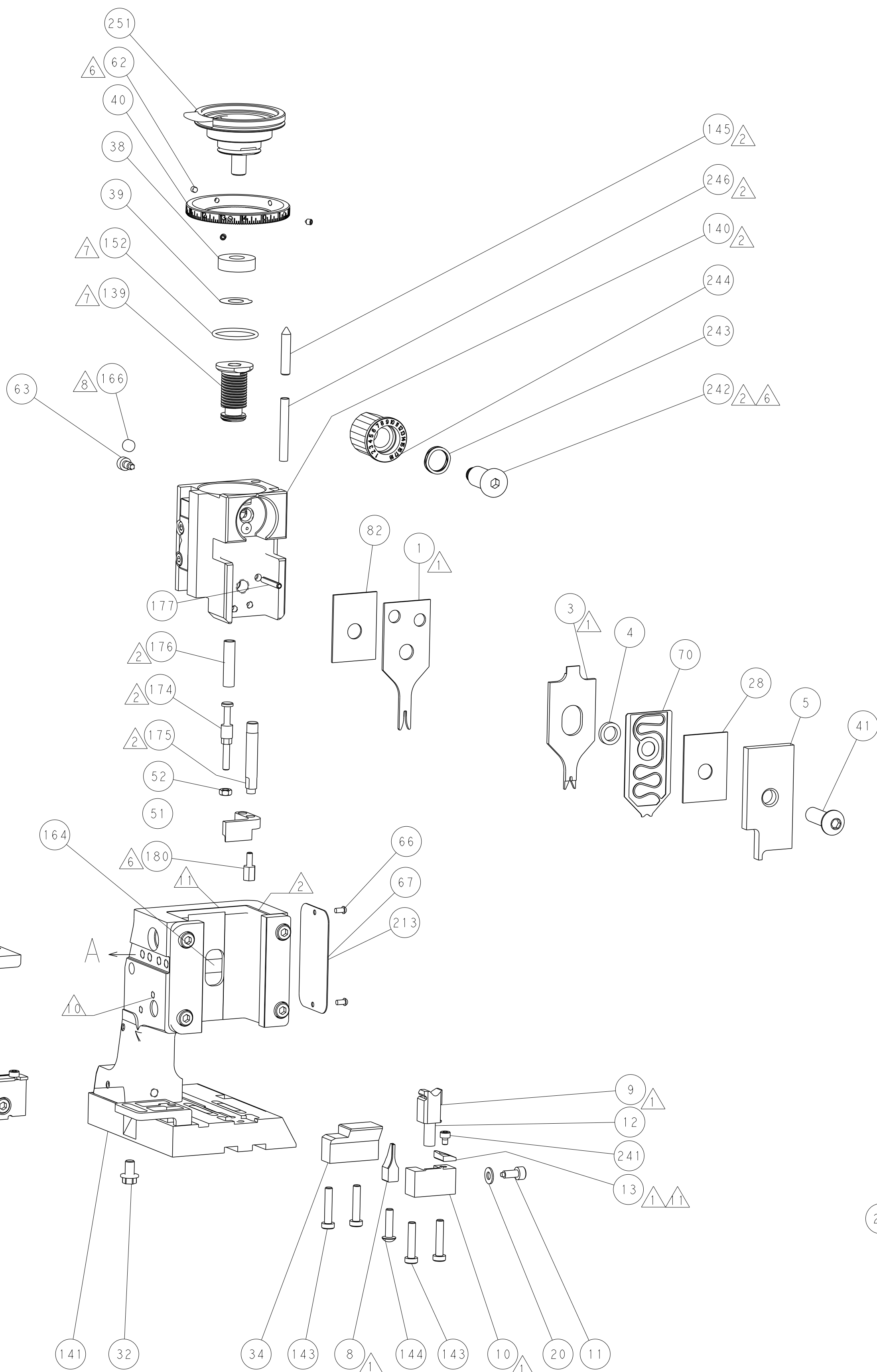
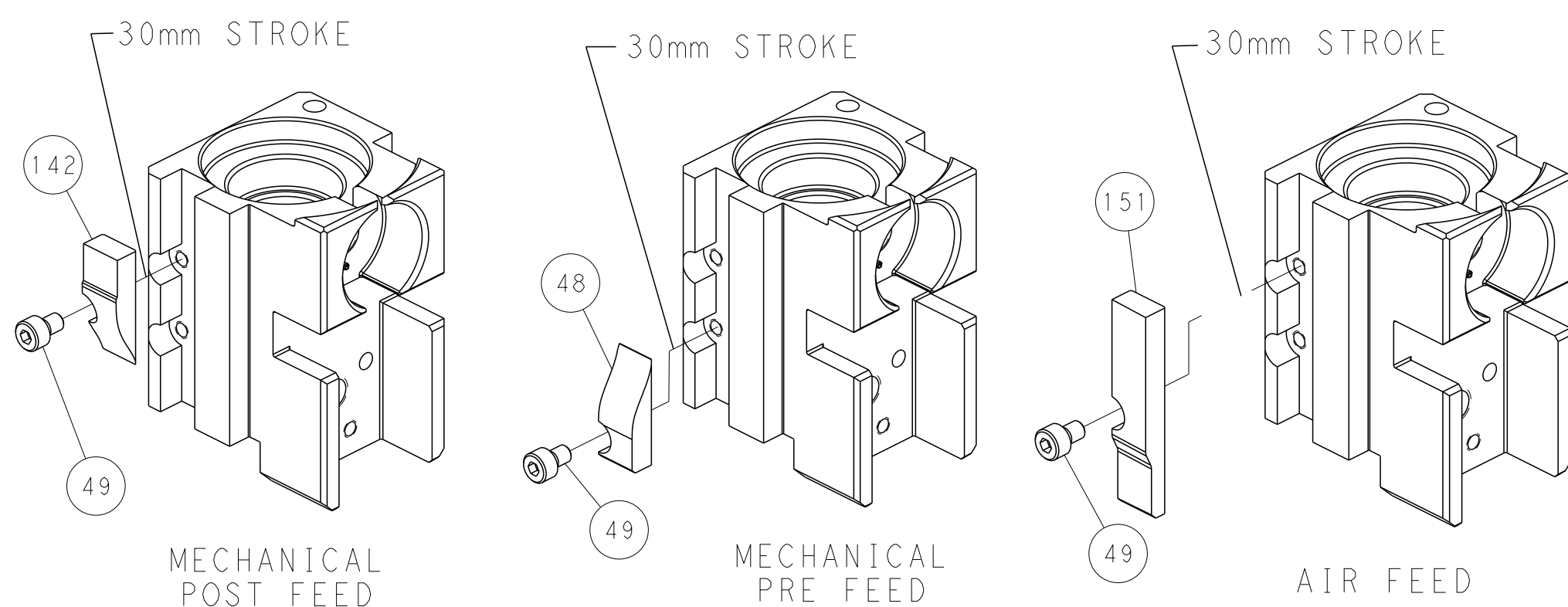
6	-	-	-	1	-	1803259-1	BUSHING, FLANGED	249
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-	-	1	-	-	1901094-3	SPACER, FEEDER	198	
6	-	1	1	1	1	1-1752354-5	STANDOFF,HOLD-DOWN	180
-	1	1	1	1	1	993111-1	PIN, SLOTTED SPRING 3.0 X 20.0	177
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-	-	-	2	-	-	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172
8	-	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	-	1	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	1	1	2119798-2	DETENT PIN	145
-	1	1	1	1	1	2079383-8	SCR, BHSC, RoHS (M4 X 16)	144
-	4	4	4	4	4	2168400-5	SHCS, LOW HEAD, RoHS, M4 X 20	143
-	-	-	-	-	1	2119653-2	FEED CAM, POST FEED	142
-	1	1	1	1	1	2-2119656-2	APPLICATOR BASIC ASSEMBLY, SF	141
-	1	1	1	1	1	2119650-1	RAM, ASIAN STYLE, SIDE FEED	140
7	-	1	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
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				CHK C. TOPPER	07OCT2016				
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		APVD J. DEGRANGE	07OCT2016	NAME			
mm		0 PLC ±.1 1 PLC ±.1 2 PLC ±.1 3 PLC ±.1 4 PLC ±.1 ANGLES ±.1 FINISH		PRODUCT SPEC		Ocean Side Feed Applicator			
				APPLICATION SPEC		SIZE			
MATERIAL				WEIGHT		A1 00779 C=2836474		RESTRICTED TO	
Customer Accessible Production Drawing				SCALE		1:2			
				SHEET		3 OF 4			
				REV		A2			

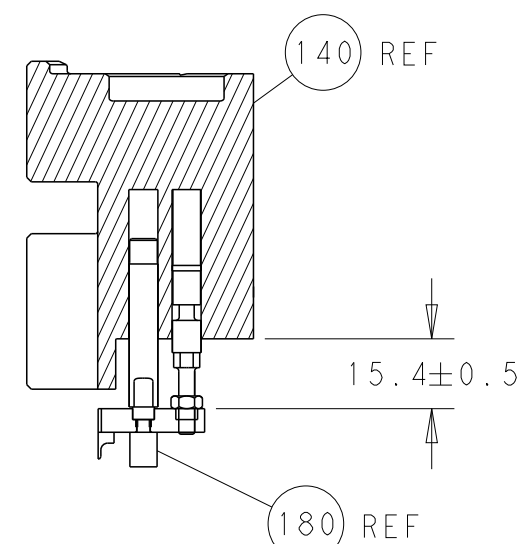
PNEUMATIC

SERVO
LATCH PLATE

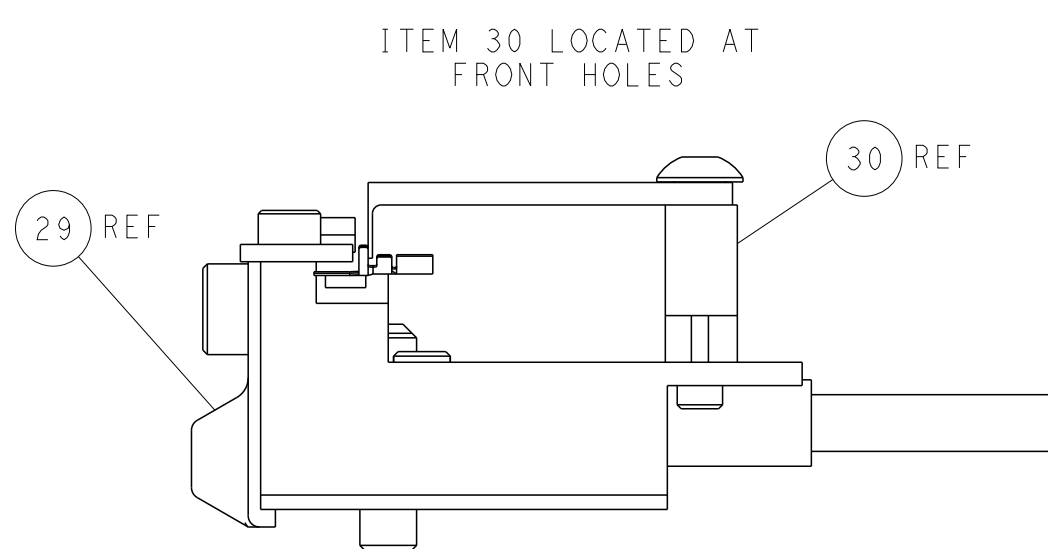
CAM POSITIONS



TERMINAL SUPPORT LOCATION

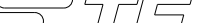
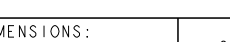


HOLDDOWN SET-UP



FEED TRACK POSITION
GUIDE BY INSULATION BARREL

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

<small>THIS DRAWING IS A CONTROLLED DOCUMENT FOR TWO ELECTRONICS CORPORATION IT IS SUBJECT TO THE COMPANY'S POLICY OF CONTROLLING AND MANAGING DOCUMENTATION SHOULD BE REVIEWED FOR THE LATEST REVISION.</small>		DWN: M. RILEY 070CT2016 CHR: J. TOPPER 070CT2016 APVD: J. DEGRANGE 070CT2016		 TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		NAME Ocean Side Fed Applicator -	
MATERIAL -		FINISH -		PRODUCT SPEC - APPLICATION SPEC -	
WEIGHT -		SIZE A		CAGE CODE 00779	
DRAWING NO. -		DRAWING NO. C=2836474		RESTRICTED TO -	
Customer Accessible Production Drawing				SCALE 1:2 SHEET 4 OF 4 REV A2	