

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART						
					CONVERT TO	PART NUMBERS REQUIRED					
	2836587-1	A	FINE CRIMP HEIGHT ADJUST	MECHANICAL	PNEUMATIC FEED	2119950-1	1338685-1	5-18022-5	2119641-1	2119799-1	2063440-1
					SERVO LATCH PLATE	2119951-1	-	8-2836587-5	1901094-3	-	2168400-6 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2836587-4	-	-	-
	2836587-2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-1	-	-
					SERVO LATCH PLATE	2119951-1	-	8-2836587-5	1901094-3	-	2168400-6 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2836587-4	-	-	-
	2836587-5	A	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE <sup>4</sup>	MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-1	-	-
PNEUMATIC FEED					2119950-1	1338685-1	5-18022-5	2119641-1	2119799-1	2063440-1	
2836587-6	A	NON-CRIMP HEIGHT ADJUST	SERVO LATCH PLATE <sup>4</sup>	-	-	-	-	-	-	-	
2836587-7	A	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	-	
7-2836587-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-	

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.40 mm (.055)	F
INSUL	-	-

APPLICATOR INSTRUCTIONS  
408-10389

TERMINAL DATA: BELDEN TERMINAL BELDEN CRIMP SPECIFICATION	
TERMINAL NAME: PIN AND SOCKET CONTACTS	
WIRE STRIP LENGTH 2.35-3.18 mm (.093-.125 IN)	INSULATION DIAMETER RANGE Ø1.18-1.58mm (.046-.062 IN)
TERMINAL APPLICATION SPECIFICATION PP 53 Rev 01	
TERMINALS APPLIED <sup>3</sup>	
TE TERMINAL 2303707-1	BELDEN TERMINAL 000-722-C06
TE TERMINAL 2303708-1	BELDEN TERMINAL 000-732-C01

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.50mm2	0.90+/-0.01 [.035+/- .000]	7.7
0.34mm2	0.84+/-0.01 [.033+/- .000]	8.3
0.25mm2	0.82+/-0.01 [.032+/- .000]	8.4

- <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:  
MECHANICAL FEED WITH "SMART APPLICATOR" CONVERSION: 8-2836587-4  
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2836587-4  
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2836587-5  
SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2836587-6
- 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 ITEM 62. FOR -6 ONLY APPLY PART NUMBER 2-23419-6 TO THREADS OF ITEM 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> SPARE FEED CAM STORAGE LOCATION REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.
- <sup>11</sup> 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.
- <sup>12</sup> WHEN ASSEMBLING A NON CRIMP HEIGHT ADJUST APPLICATOR (-6) USE SHIMS FROM ITEM 260 TO ACHIEVE A NOMINAL SHIM HEIGHT OF 4.9.
- <sup>13</sup> 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.

ITEM NO	DESCRIPTION	ITEM NO
-77	-7	-6
-6	-5	-2
-2	-1	PART NO
260	APPLICATOR SHIM PACK	260
252	O-RING, .676 ID, .070 DIA. MAT.	252
250	PUSH ROD, AIR FEED	250
249	BUSHING, FLANGED	249
248	FEED CAM, AIR FEED	248
247	DETENT PIN	247
246	SPRING, COMPRESSION	246
245	RAM, AMP STYLE, SIDE FEED, NON-ADJ.	245
241	SCR, SKT HD CAP M3 X 4.0	241
240	SHCS, LOW HEAD, RoHS, M5 X 16	240

**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		LOC	DIST	REVISIONS			
2119599-1	A	66		REV	DATE	BY	APPV
				1	PRELIMINARY	20JAN2017	MR GB
				A	RELEASED	01FEB2017	TB TE

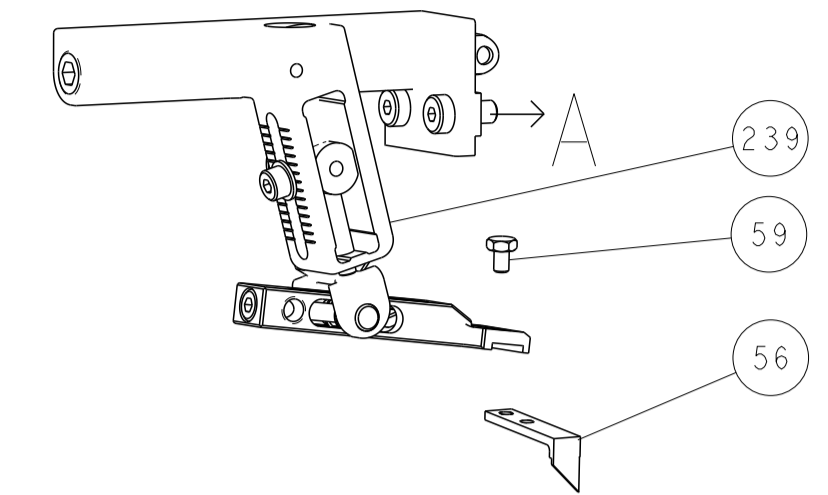
REV	DATE	BY	APPV	DESCRIPTION	ITEM NO
-	-	-	-	MECHANICAL FEED ASSEMBLY	239
-	-	-	-	AIR FEED MODULE	238
-	-	-	-	TAG, IDENTIFICATION	213
-	-	-	-	SPACER, FEEDER	198
-	-	-	-	RING, RETAIN, EXTERN, 3/16 CRESCENT	172
-	-	-	-	MAGNET, RARE EARTH HIGH ENERGY	166
-	-	-	-	COUNTER, MAGNETIC	164
-	-	-	-	SPRING, FEED FINGER	163
-	-	-	-	PIN, RETAIN, GRVD, 3/16 X .854	137
-	-	-	-	HOLDER, FEED FINGER, AF	136
-	-	-	-	MEMORY CHIP, PROGRAMMED	135
-	-	-	-	SERVO FEED LATCH ASM	133
-	-	-	-	SPRING, COMPRESSION	121
-	-	-	-	FEED FINGER ASSEMBLY, SF	117
-	-	-	-	ASSY, LUBRICATOR, SIDE FEED	113
-	-	-	-	FRONT STRIP GUIDE	96
-	-	-	-	SCR, SKT HD CAP, RoHS, M3 X 8.0	95
-	-	-	-	SCR, SKT HD CAP, RoHS, M5 X 65	93
-	-	-	-	SPACER, CRIMPER	82
-	-	-	-	DOCUMENTATION PACKAGE	71
-	-	-	-	DEPRESSOR, WIRE	70
-	-	-	-	WASHER, SPACER	69
-	-	-	-	TAG, IDENTIFICATION	67
-	-	-	-	SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	-	-	-	LIMITER, ADJUSTMENT BOLT	63
-	-	-	-	SCR, SET, SOC, CONE POINT, M3 X 4.0	62
-	-	-	-	SCR, SET, FLT POINT M5 X 20.0	61
-	-	-	-	SCR, BHSC, RoHS (M4 X 8)	60
-	-	-	-	SCR, HEX HD CAP, M4 X 6.0	59
-	-	-	-	PAWL, FEED	56
-	-	-	-	SHCS, LOW HEAD, RoHS, M4 X 12	54
-	-	-	-	SCR, SKT HD CAP, RoHS, M4 X 10	53
-	-	-	-	NUT, HEX, REG, RoHS, M3	52
-	-	-	-	BUMPER, HOLD DOWN	51
-	-	-	-	SPACER, TONKER	50
-	-	-	-	SCR, SKT HD CAP M4 X 6.0	49
-	-	-	-	FEED CAM, PRE FEED	48
-	-	-	-	FEED CAM, POST FEED	47
-	-	-	-	APPLICATOR BASIC ASSEMBLY, SF	46
-	-	-	-	RAM, AMP STYLE, SIDE FEED	44
-	-	-	-	SCR, BHSC, RoHS (M8 X 25)	41
-	-	-	-	DISC, NUMBERED FA WIRE ADJUSTMENT	40
-	-	-	-	APPLICATOR SHIM PACK	39
-	-	-	-	RAM WASHER, PRECISION	38
-	-	-	-	FA HEAD, ATLANTIC STYLE	37
-	-	-	-	BOLT, ADJUSTMENT	35
-	-	-	-	SUPPORT, TERMINAL	34
-	-	-	-	SCR, BHSC, RoHS (M4 X 20)	33
-	-	-	-	HEX HEAD, FLANGED, M5 X 8mm LONG	32
-	-	-	-	SPACER, STRIP GUIDE	30
-	-	-	-	PLATE, STRIP GUIDE	29
-	-	-	-	SPACER, CRIMPER	28
-	-	-	-	SPRING, COMPRESSION	27
-	-	-	-	LEVER, DRAG RELEASE	26
-	-	-	-	DRAG, TERMINAL	25
-	-	-	-	STRIP GUIDE	24
-	-	-	-	SCR, SKT HD SHLDR 5.0 DIA X 6.0	23
-	-	-	-	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
-	-	-	-	WASHER, FLAT, REG M4	20
-	-	-	-	STRIPPER, SIDE FEED	19
-	-	-	-	INSERT, SHEAR	13
-	-	-	-	SPRING, COMPRESSION	12
-	-	-	-	STOP, SHEAR	11
-	-	-	-	SHEAR HOLDER, FRONT	10
-	-	-	-	FLOATING SHEAR, FRONT	9
-	-	-	-	ANVIL, COMBINATION	8
-	-	-	-	-	7
-	-	-	-	-	6
-	-	-	-	DEPRESSOR, SHEAR	5
-	-	-	-	-	4
-	-	-	-	-	3
-	-	-	-	-	2
-	-	-	-	CRIMPER, WIRE SPECIAL	1

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		MATERIAL:	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±
ANGLES	FINISH	MATERIAL			

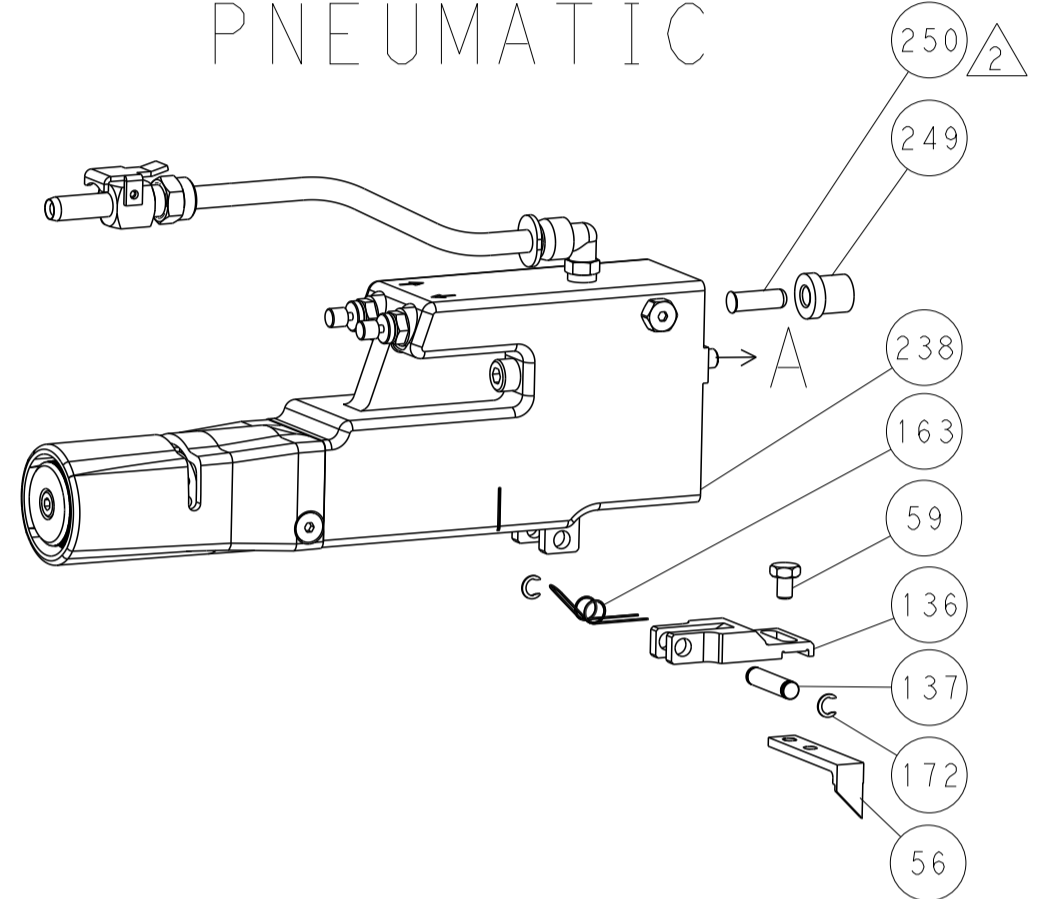
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APVD		20JAN2017		
PRODUCT SPEC	Ocean Side Feed Applicator			
APPLICATION SPEC	-			
SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO	
A1	00779	2836587	-	
Customer Accessible Production Drawing			SCALE	SHEET 1 OF 4
			1:2	REV A

LOC		DIST		REVISIONS			
A	66	P	LTM	DESCRIPTION	DATE	OWN	APVD
		-	-	SEE SHEET 1	-	-	-

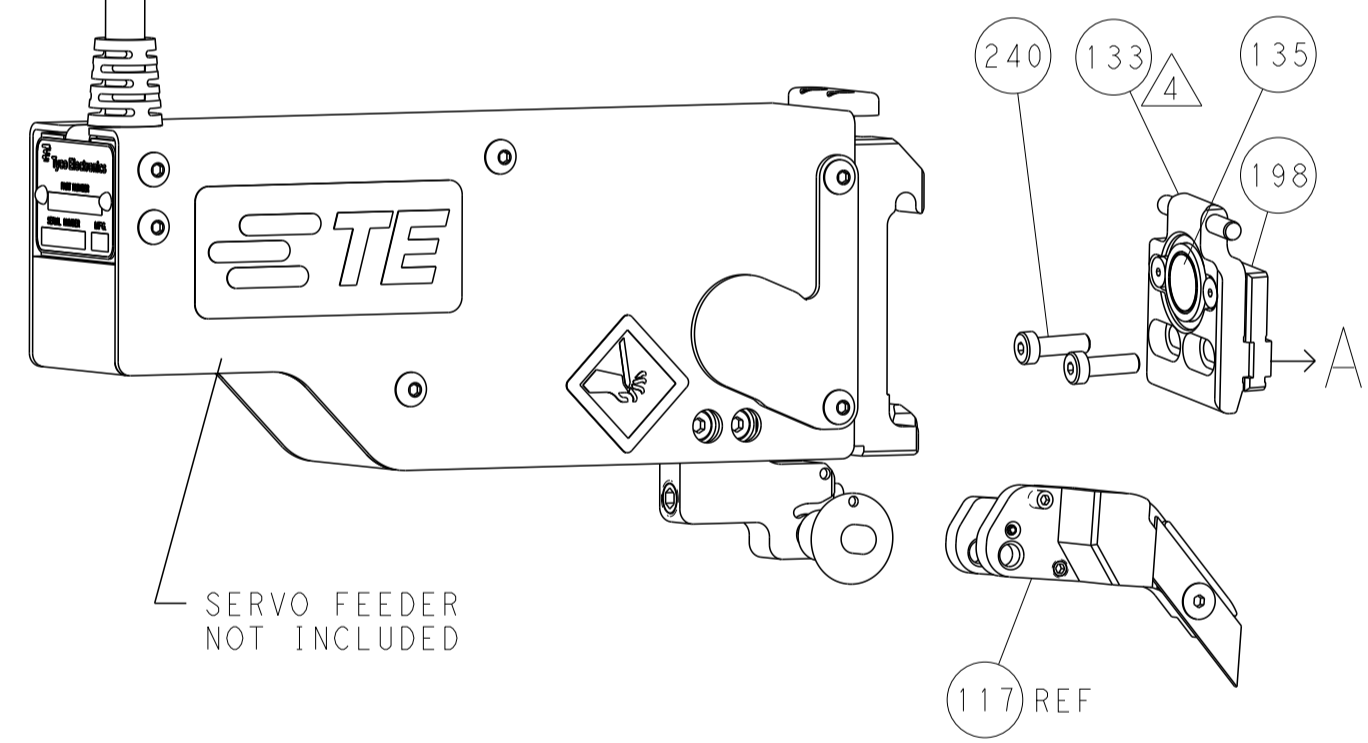
### FEED TYPE MECHANICAL



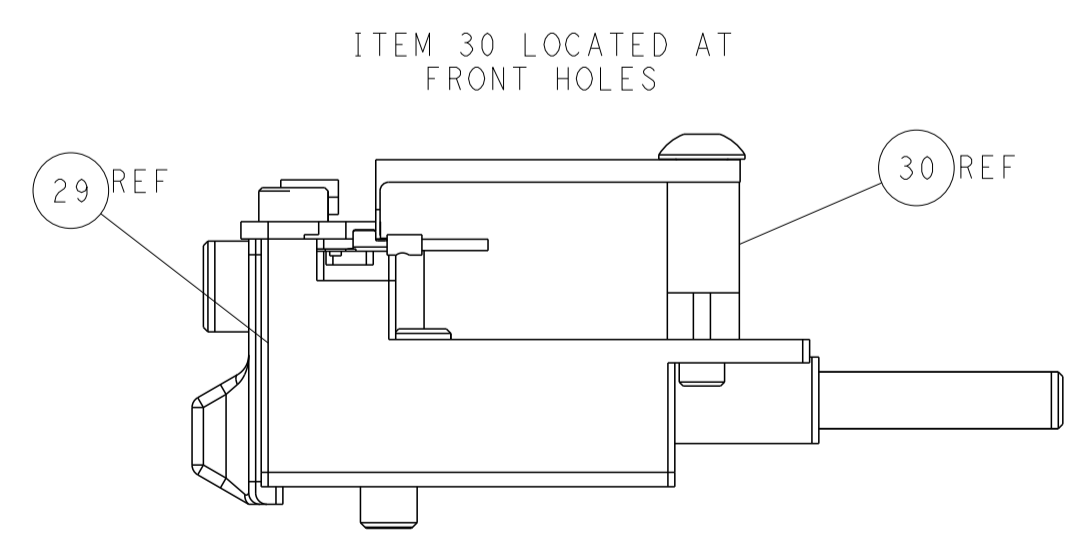
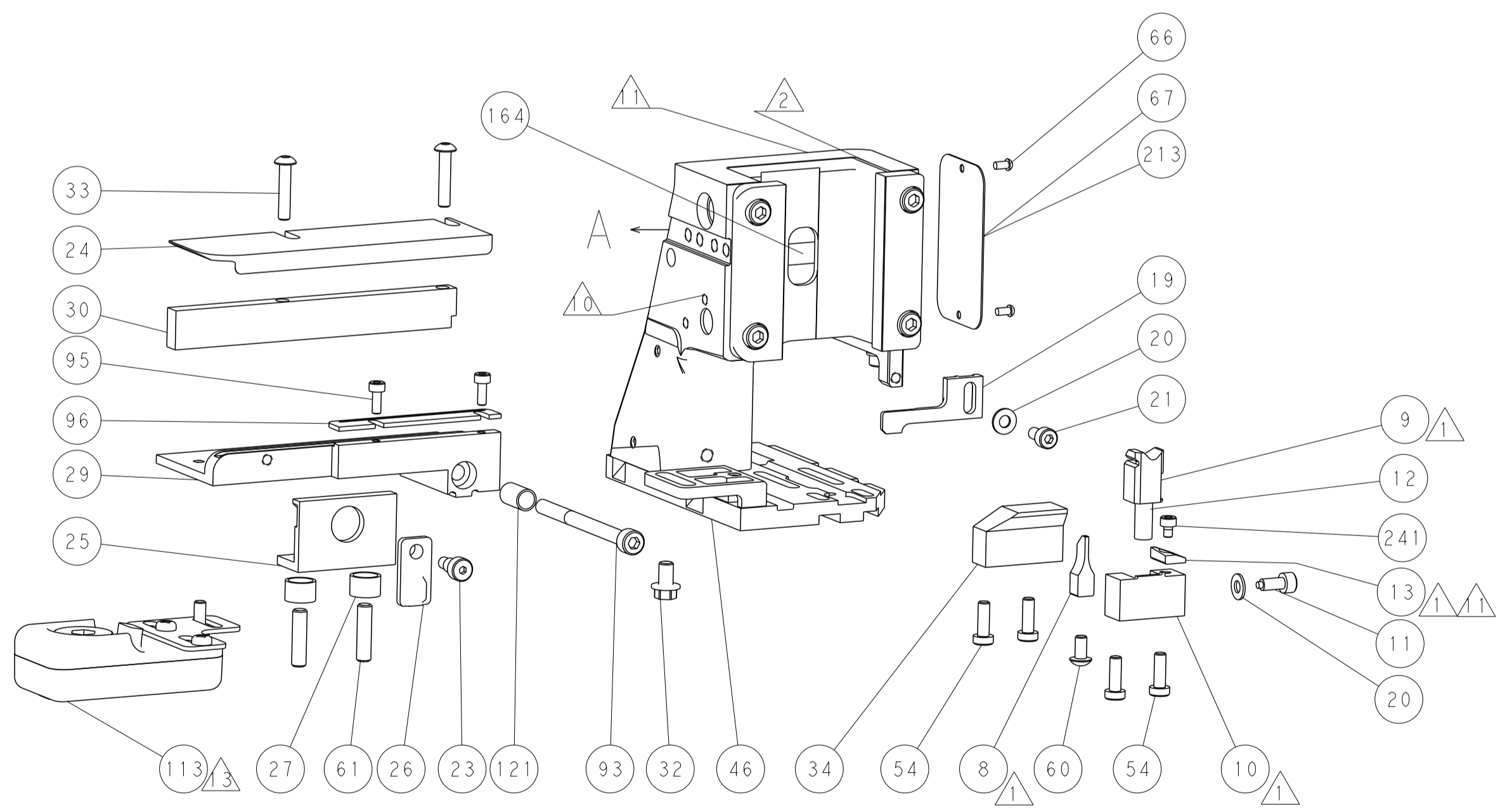
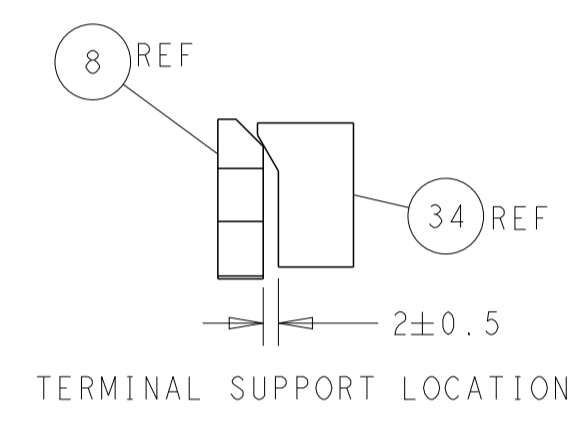
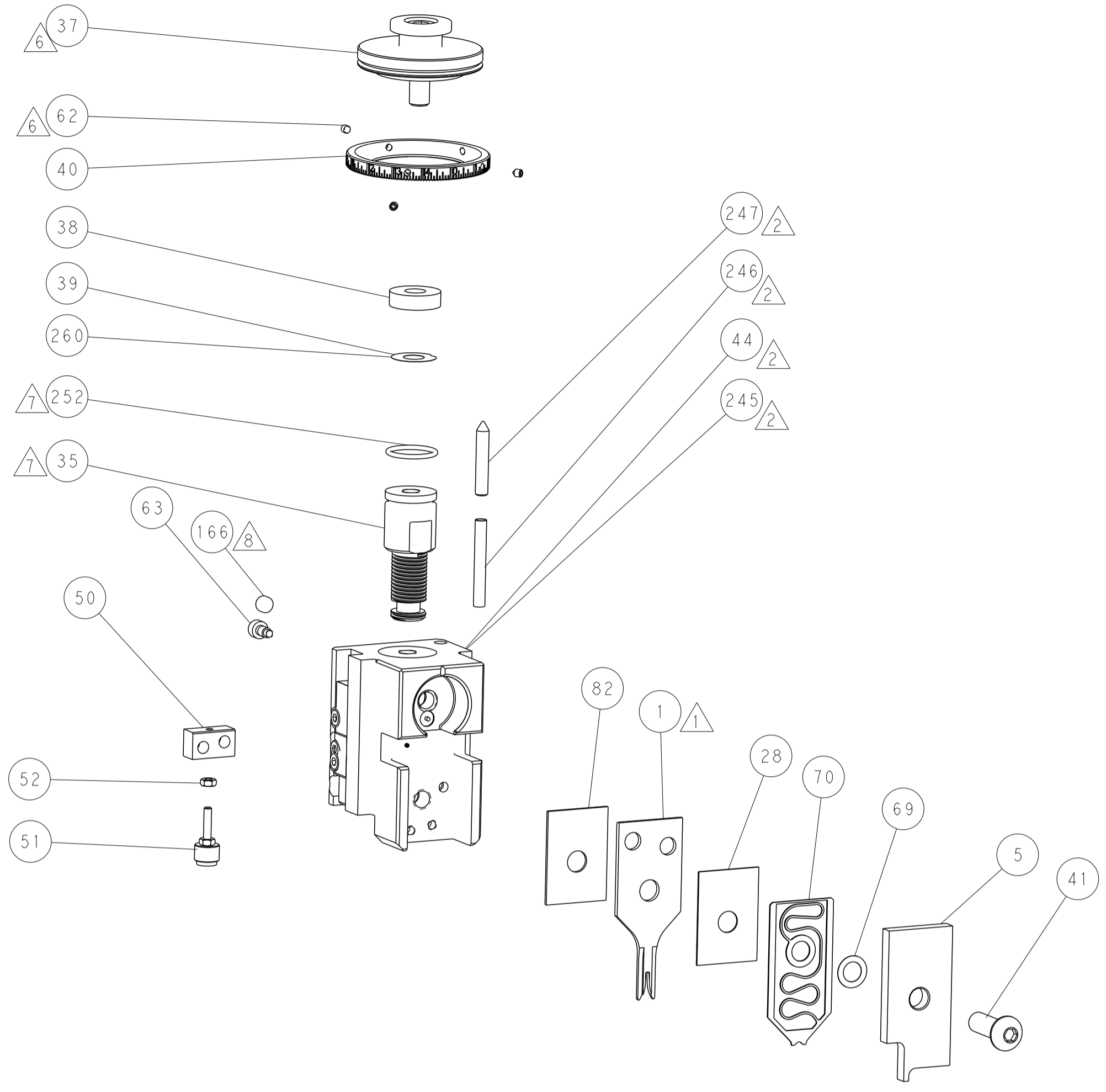
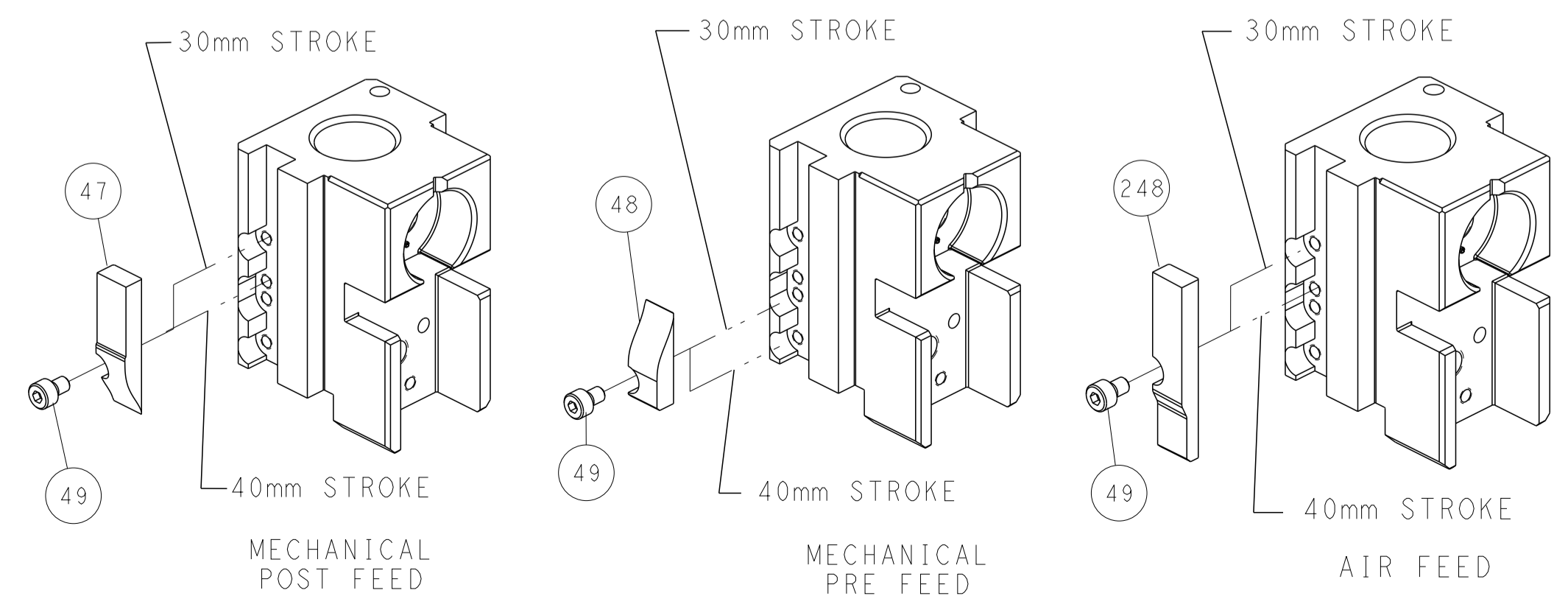
### PNEUMATIC



### SERVO LATCH PLATE



### CAM POSITIONS



FEED TRACK POSITION GUIDE BY WIRE BARREL

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

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		OWN: M. RILEY 20JAN2017		TE Connectivity	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	5 PLC ±	Harrisburg, PA 17105-3608
MATERIAL:		FINISH:		APVD: 20JAN2017		NAME: Ocean Side Feed Applicator	
				PRODUCT SPEC:		RESTRICTED TO:	
				APPLICATION SPEC:		SIZE: CAGE CODE: DRAWING NO:	
				WEIGHT:		A1 00779 ©=2836587	
				Customer Accessible Production Drawing		SCALE: 1:2 SHEET 2 OF 4 REV A	

Table with columns: PACIFIC VERSION TERMINATOR INTERFACE ADAPTER, PART NUMBER, REVISION, DESCRIPTION, FEED TYPE, CONVERT TO, PART NUMBERS REQUIRED. Includes a diagram of the Pacific Version Terminator Interface Adapter.

APPLICATOR DATA table with columns: CRIMP, SIZE, TYPE. Includes APPLICATOR INSTRUCTIONS 408-10389.

TERMINAL DATA: BELDEN TERMINAL BELDEN CRIMP SPECIFICATION. Includes WIRE STRIP LENGTH, INSULATION DIAMETER RANGE, and TERMINALS APPLIED table.

Table with columns: WIRE SIZE, CRIMP HEIGHT mm [INCH], CRIMP HEIGHT REFERENCE SETTING. Includes diagrams for crimping.

- RECOMMENDED SPARE PARTS
GREASE BEARING SURFACES LIGHTLY
LUBRICATE DAILY PER THE APPLICATOR INSTRUCTION SHEET SUPPLIED WITH THE APPLICATOR.
APPLICATOR SPECIFIC DATA TO BE ENTERED INTO BLANK MEMORY CHIP 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.

Table with columns: PART NO, DESCRIPTION, ITEM NO. Lists various spare parts like FINE ADJUST HEAD ASM, PUSH ROD, AIR FEED, etc.

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

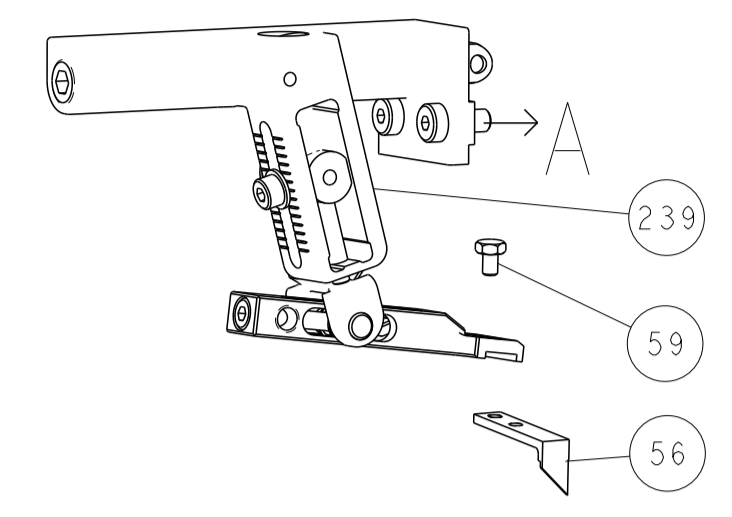
Table with columns: SET UP GAUGE, LOC, DIST, REVISIONS. Includes a small table for REVISIONS.

Large table with columns: P, LTM, DESCRIPTION, DATE, QTY, APVD. Lists various components like TAG, IDENTIFICATION, SPACER, FEEDER, RING, RETAIN, EXTERN, etc.

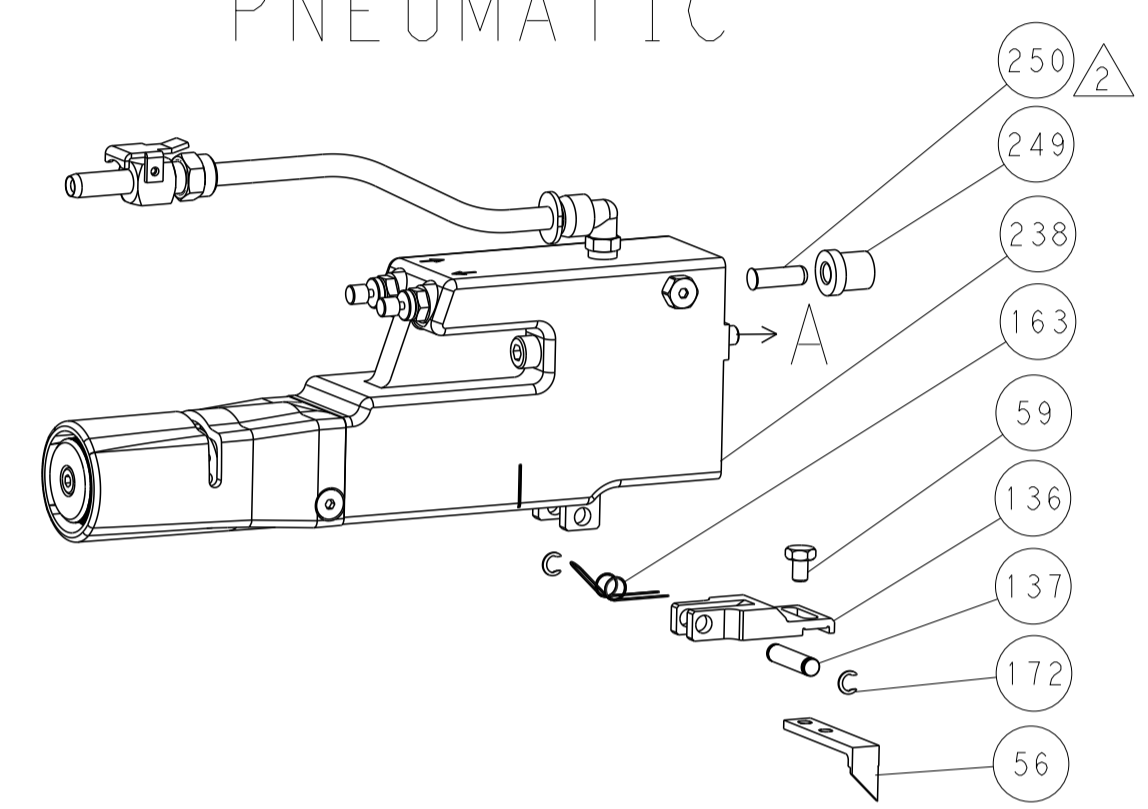
Technical drawing header/footer area including DIMENSIONS, TOLERANCES, MATERIAL, FINISH, and a title block with company name STE and product name Ocean Side Feed Applicator.

LOC		DIST		REVISIONS			
A	66	P	LTM	DESCRIPTION	DATE	DMN	APVD
		-	-	SEE SHEET 1	-	-	-

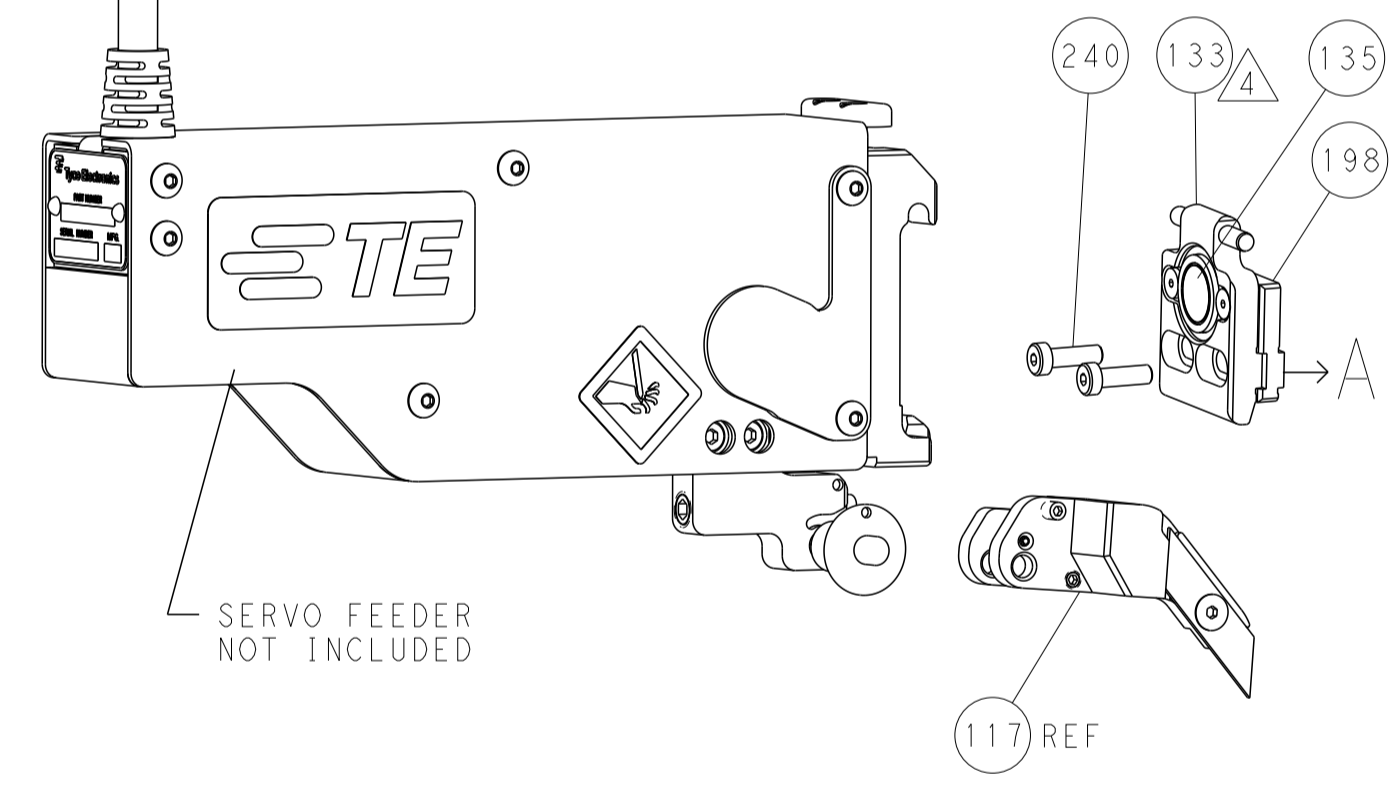
# FEED TYPE MECHANICAL



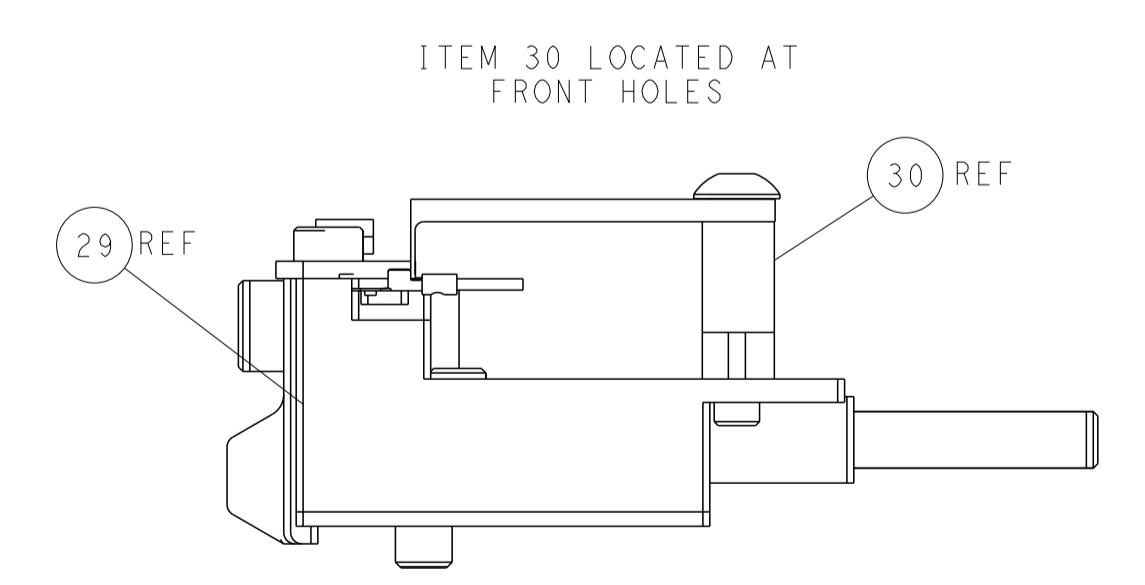
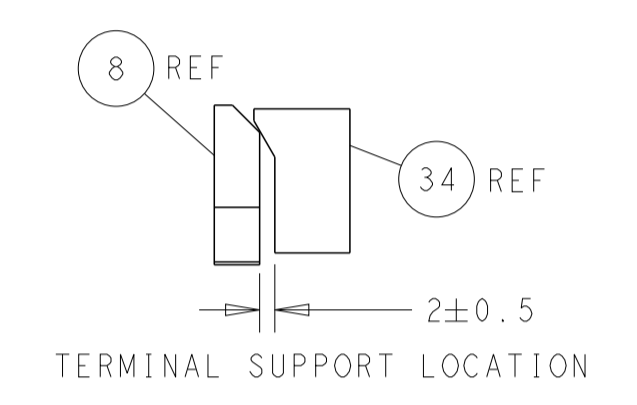
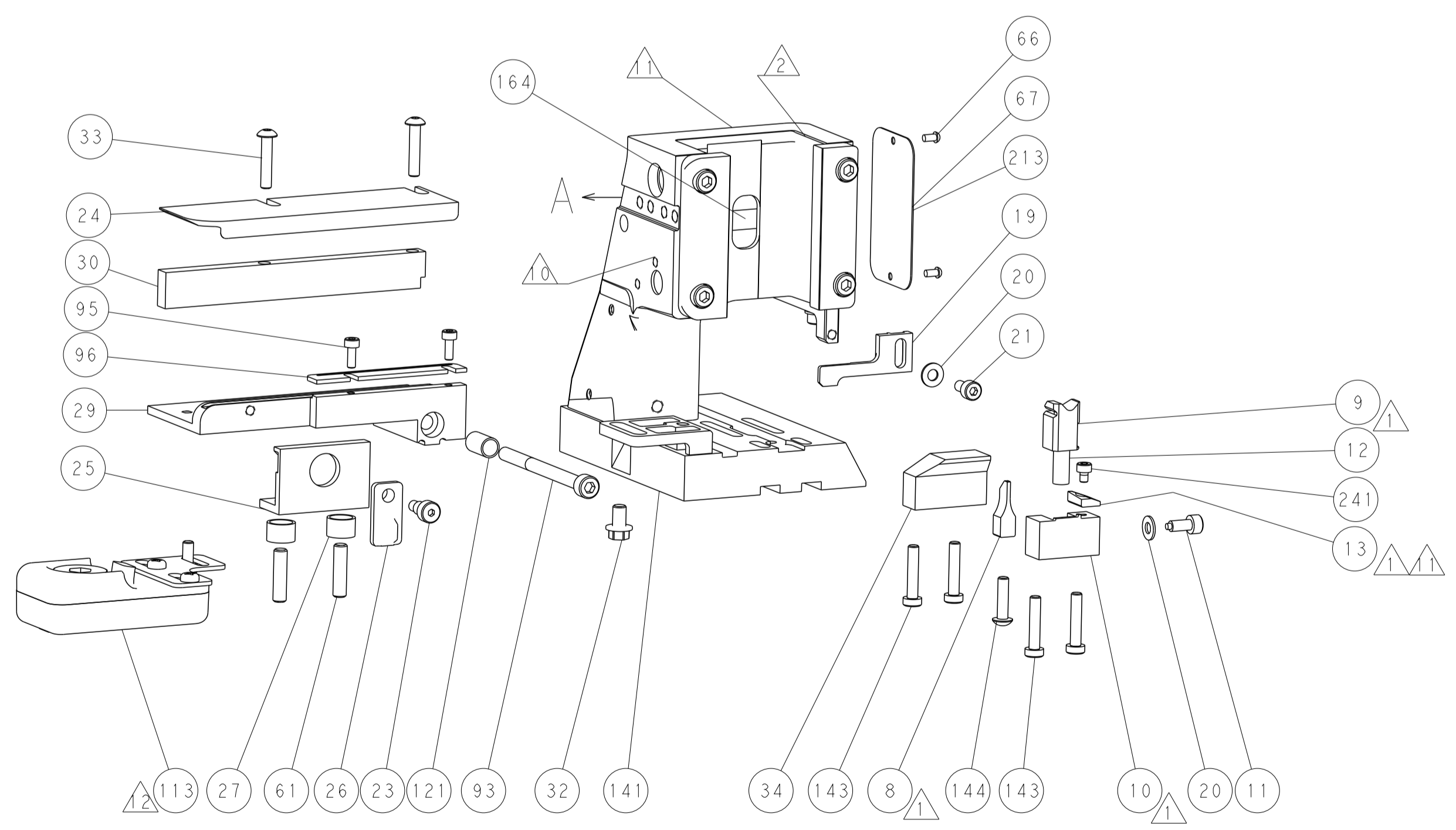
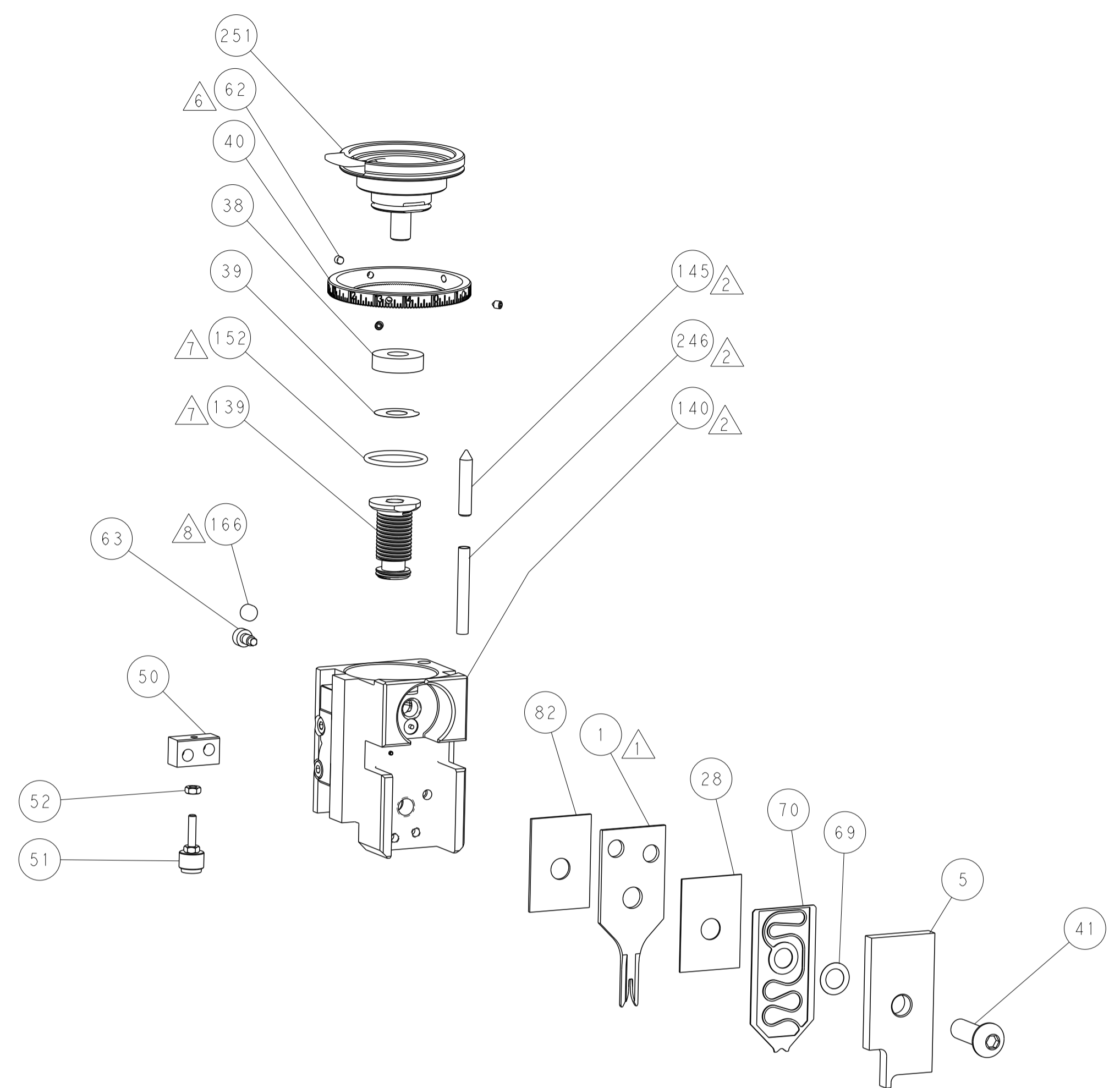
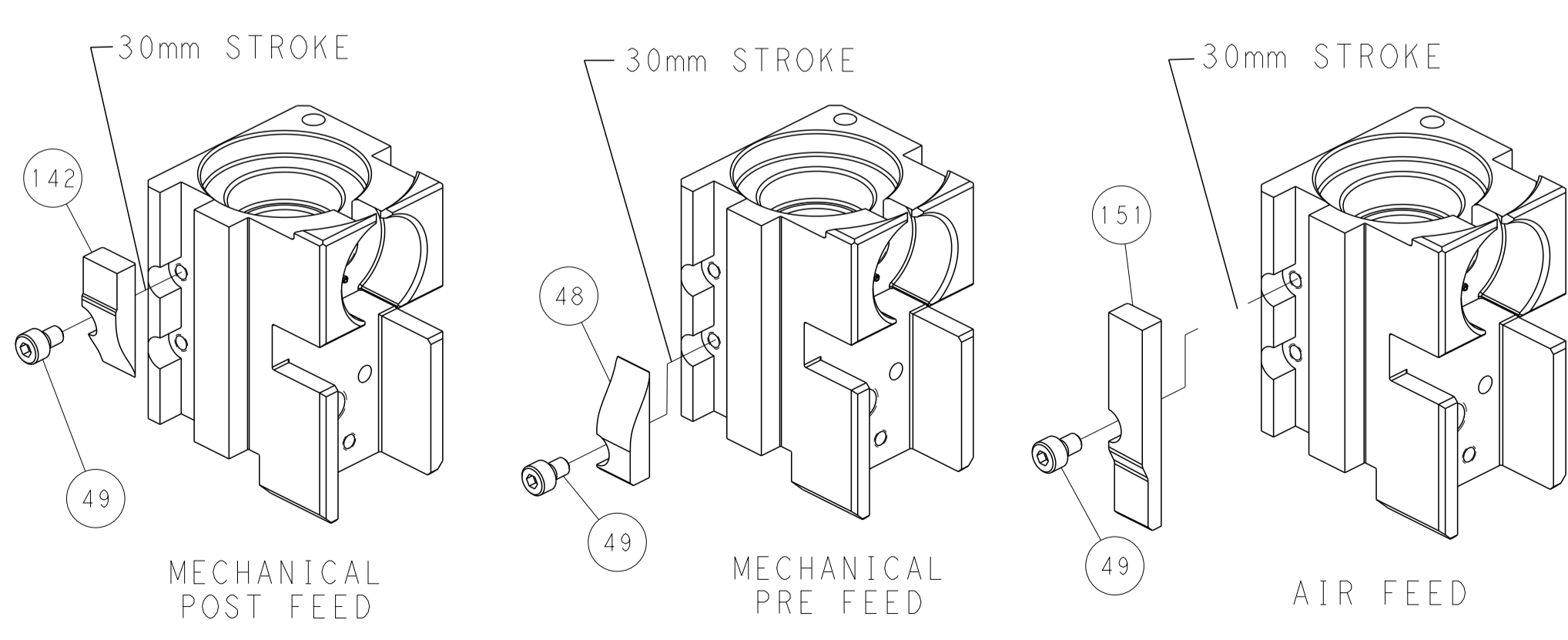
# PNEUMATIC



# SERVO LATCH PLATE



# CAM POSITIONS



**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 OTHERWISE SPECIFIED:		DMN	M. RILEY	20JAN2017	TE Connectivity Harrisburg, PA 17105-3608
mm	0 PLC ±	1 PLC ±	2 PLC ±	CHK	-	20JAN2017	
		3 PLC ±	4 PLC ±	APVD	-	20JAN2017	NAME
MATERIAL		ANGLES	FINISH	PRODUCT SPEC		Ocean Side Feed Applicator	
				APPLICATION SPEC			
				WEIGHT	-	SIZE	CAGE CODE
				Customer Accessible Production Drawing		SCALE	1:2
				A   00779		DRAWING NO	REV
				©=2836587		SHEET 4 OF 4	