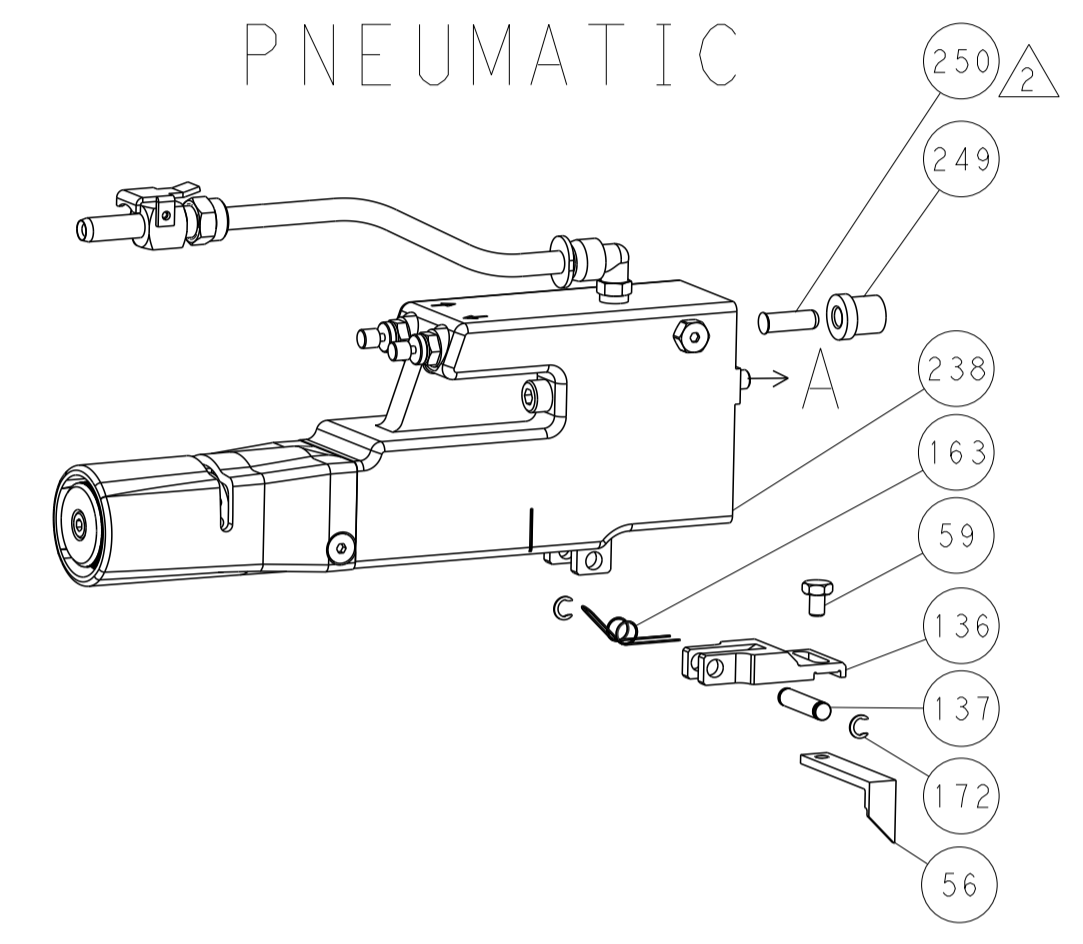


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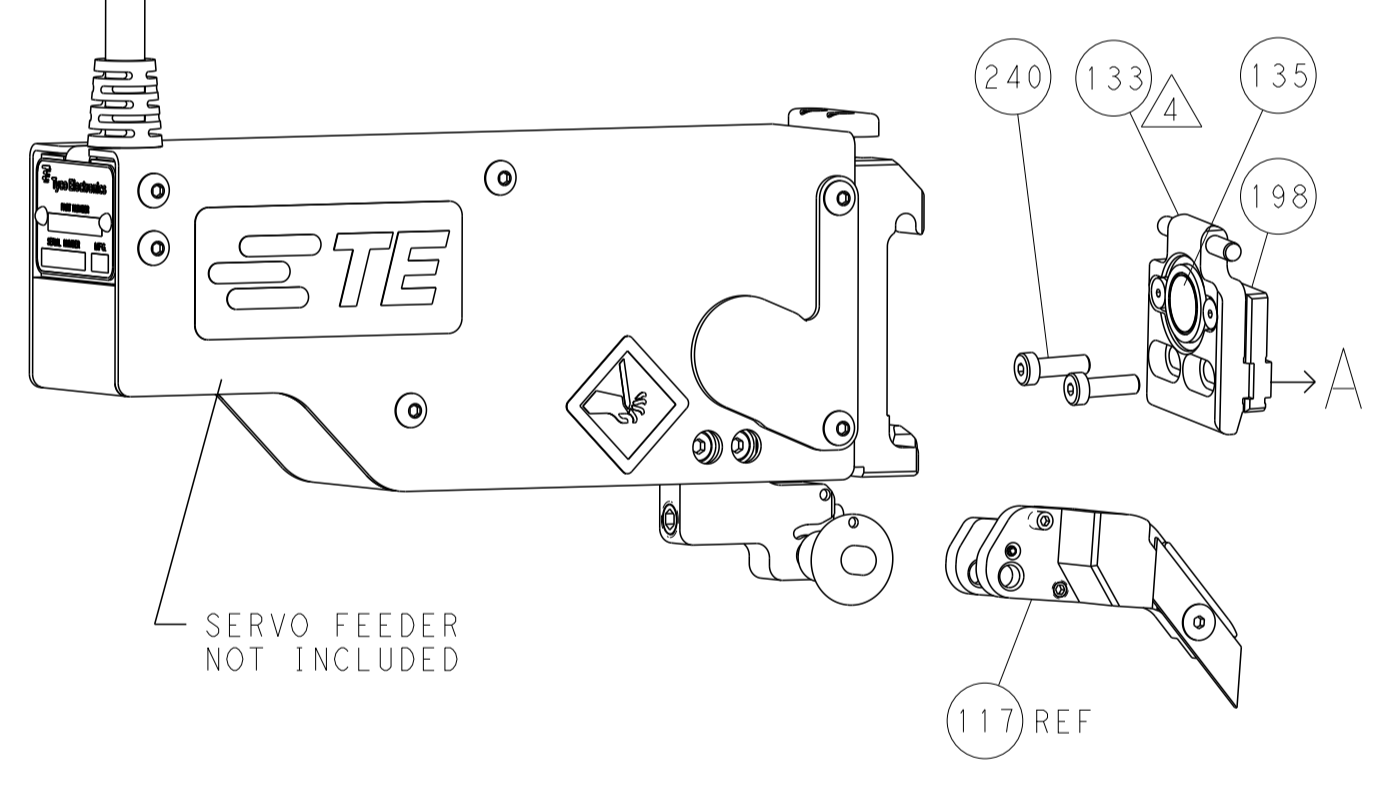
REVISIONS			
REV	DATE	BY	APPD
-	SEE SHEET 1	-	-

FEED TYPE

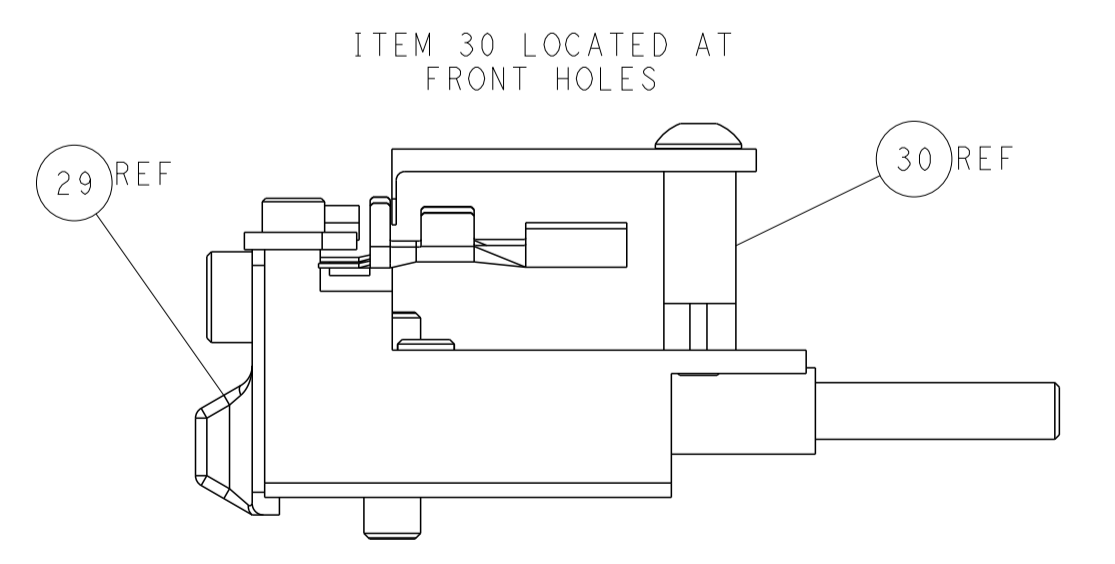
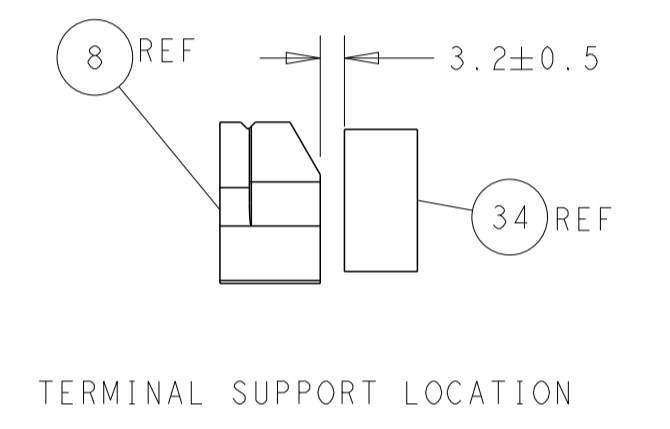
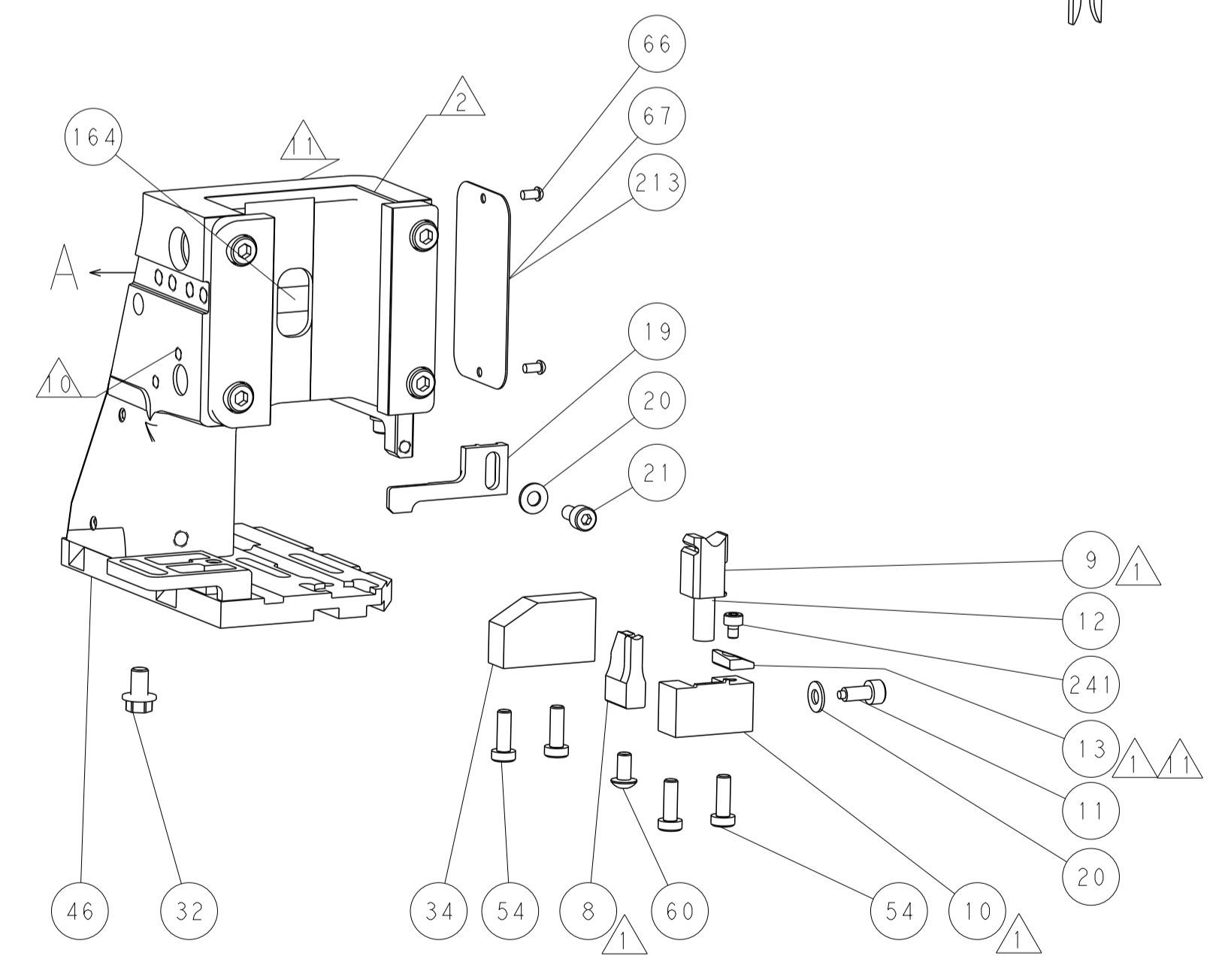
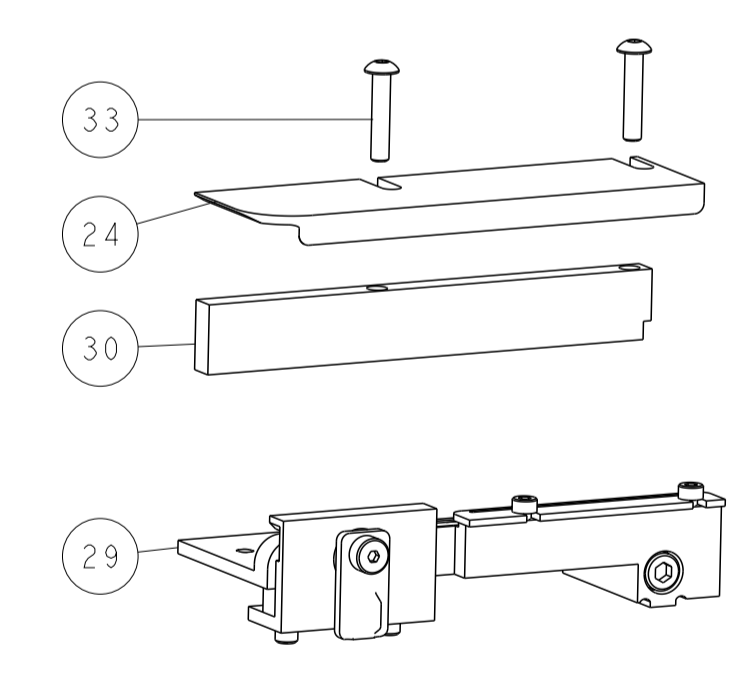
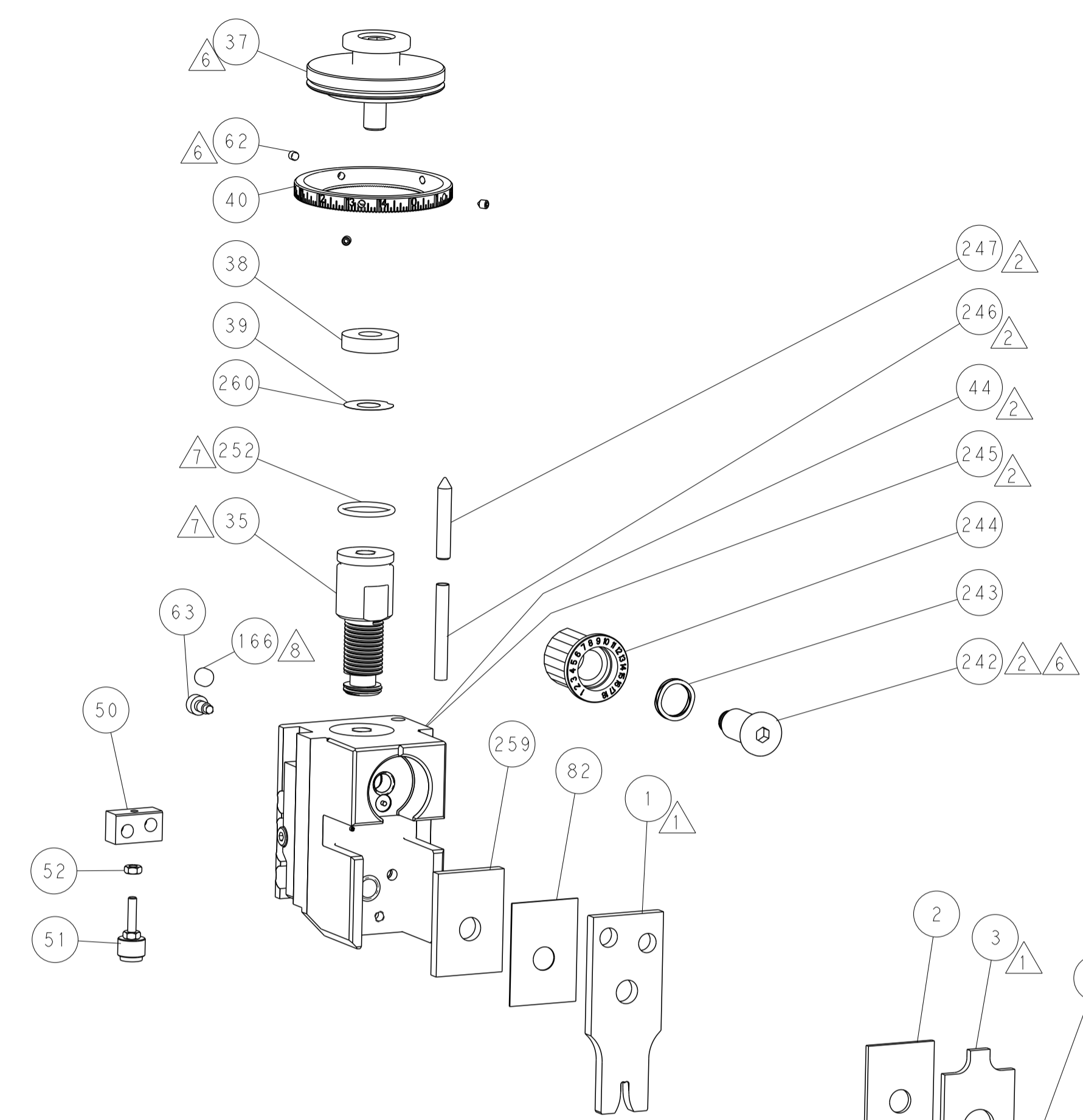
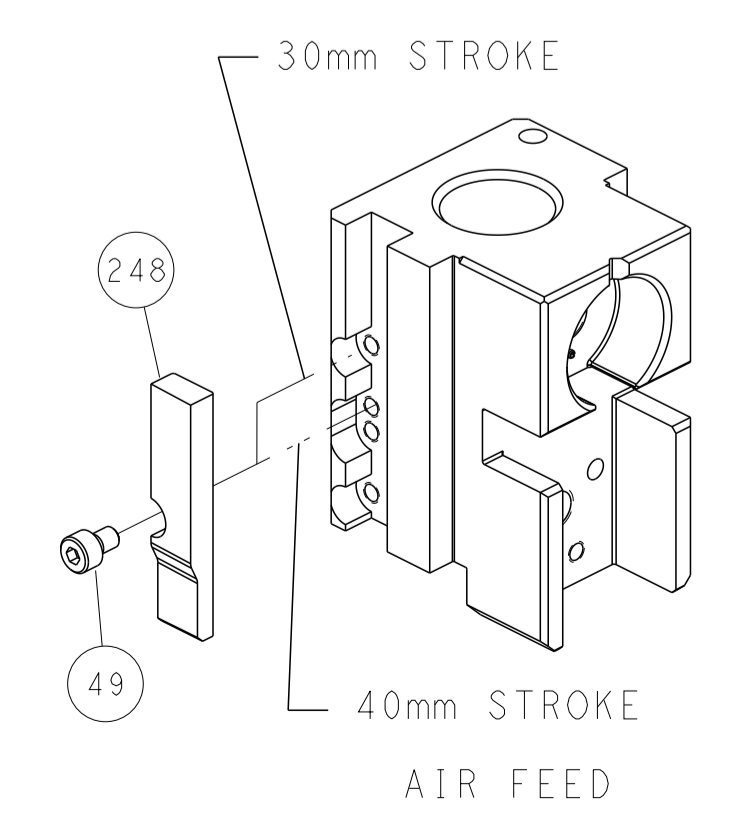
PNEUMATIC



SERVO LATCH PLATE



CAM POSITION



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)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG: M. ZHAO 10MAY2017		TE Connectivity	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	5 PLC ±	Harrisburg, PA 17105-3608
	ANGLES	FINISH		CHK: K. ZHANG 10MAY2017	NAME	Ocean Side Feed Applicator	
MATERIAL				APVD: K. ZHANG 10MAY2017	PRODUCT SPEC	RESTRICTED TO	
				APPLICATION SPEC	SIZE	CAGE CODE	DRAWING NO
				WEIGHT	A1	00779	©=2836747
				Customer Accessible Production Drawing	SCALE	1:2	SHEET 2 OF 4 REV A

PACIFIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	CONVERT TO	PART NUMBERS REQUIRED					
	2-2836747-2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	SERVO LATCH PLATE	2119951-1	-	8-2836747-5	1901094-3	-	2168400-6 (QUANTITY 2)
	2-2836747-5	A	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE ⁴	SMART APPLICATOR	2161326-1	-	8-2836747-4	-	-	-
	2-2836747-7	A	FINE CRIMP HEIGHT ADJUST	NONE	PNEUMATIC FEED	2119950-1	1338683-8	5-18022-5	2119641-2	2119799-1	2063440-2
	7-2836747-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	3.05 mm [1.20]	F
INSUL	4.00 mm [1.57]	F
APPLICATOR INSTRUCTIONS 408-10389		

TERMINAL DATA: ZBN TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: RECEPTACLE TERMINAL			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
6.04-6.80 mm [2.38-.268 IN]		∅2.40-3.20 mm [1.094-.126 IN]	
TERMINAL APPLICATION SPECIFICATION	NONE		
TERMINALS APPLIED ¹⁰			
TE TERMINAL	ZBN TERMINAL	TE TERMINAL	ZBN TERMINAL
2318279-1	DJ628-6.3B		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING ⁹
2.00mm2	1.93+/-0.05 [1.076+/-0.02]	7.1
1.50mm2	1.79+/-0.05 [1.070+/-0.02]	8.6
1.00mm2	1.65+/-0.05 [1.065+/-0.02]	10.2



- 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:
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2836747-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2836747-5
- 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 ITEMS 62.
APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242.
- ⁷ GREASE THREADS, GROOVE AND O-RING ON ITEMS 139 & 152.
- ⁸ MAGNET 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 TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- ¹¹ 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.

***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.

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

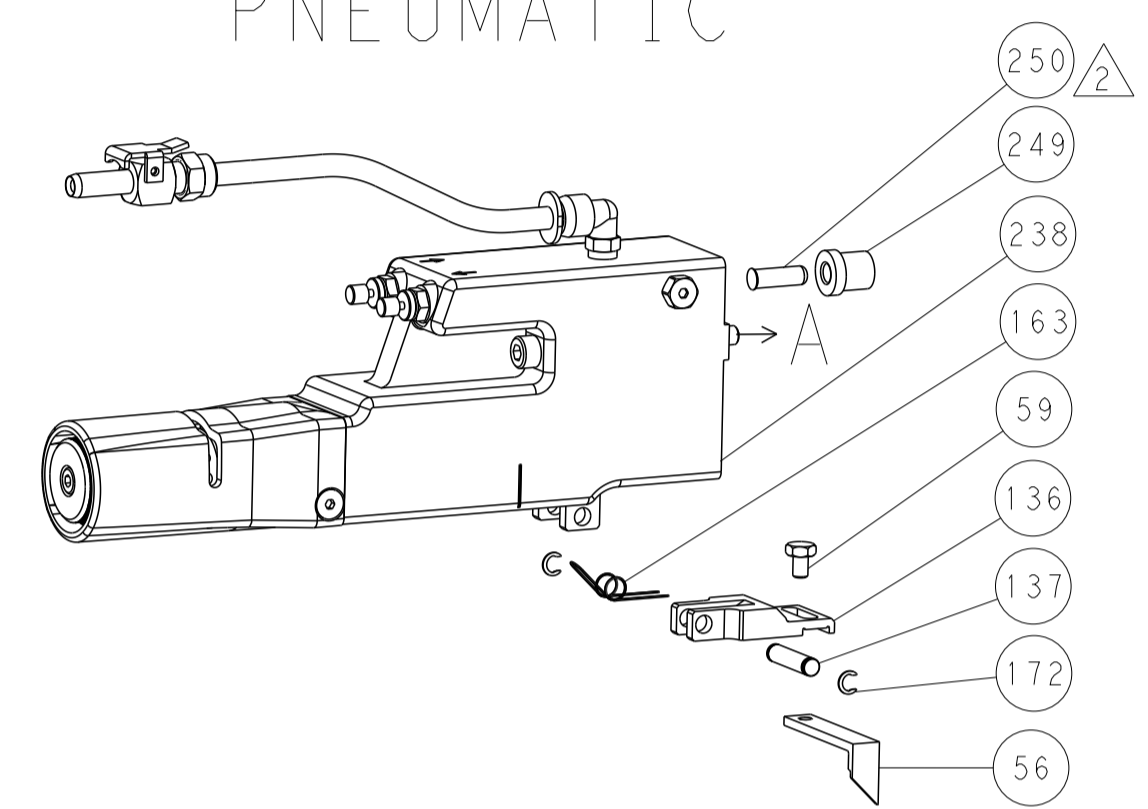
SET UP GAUGE	LOC	DIST	REVISIONS					
2119599-1	A	66	P	LTN	DESCRIPTION	DATE	OWN	APVD
			-	-	SEE SHEET 1	-	-	-

-	1	1	1	1803078-3	SPACER, PRECISION			259
-	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
-	1	1	1	2119082-7	CAM, SNAIL, INSULATION ADJUSTMENT			244
-	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST			243
-	1	1	1	2119083-1	RETAINER, INSULATION DIAL			242
-	1	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0			241
-	-	2	-	2168400-6	SHCS, LOW HEAD, RoHS, M5 X 16			240
-	-	-	1	2063440-2	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
-	4	4	4	2168400-5	SHCS, LOW HEAD, RoHS, M4 X 20			143
-	1	1	1	1-2119656-0	APPLICATOR BASIC ASSEMBLY, SF			141
-	1	1	1	2161312-1	RAM, STEPPED, ASIAN STYLE, SIDE FEED			140
-	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
-	-	1	-	1633743-1	SERVO FEED LATCH ASM			133
-	-	REF	-	2119944-1	FEED FINGER ASSEMBLY, SF			117
-	1	1	1	455888-4	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	1	2119793-1	LIMITER, ADJUSTMENT BOLT			63
-	3	3	3	992763-5	SCR, SET, SOC, CONE POINT, M3 x 4.0			62
-	-	-	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0			59
-	-	-	1	1338683-8	FEED PAWL			56
-	2	2	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10			53
-	1	1	1	5018030-1	NUT, HEX, REG, RoHS, M3			52
-	1	1	1	811242-5	BUMPER, HOLD DOWN			51
-	1	1	1	690753-2	SPACER, TONKER			50
-	-	-	1	18023-9	SCR, SKT HD CAP M4 X 6.0			49
-	1	1	1	1-2079383-5	SCR, BHSC, RoHS (M8 X 40)			41
-	1	1	1	2119645-1	DISC, NUMBERED FA WIRE ADJUSTMENT			40
-	1	1	1	2119957-1	APPLICATOR SHIM PACK			39
-	1	1	1	2119644-2	RAM WASHER, PRECISION			38
-	1	1	1	1-1752356-8	SUPPORT, TERMINAL			34
-	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)			33
-	1	1	1	2161328-1	HEX HEAD, FLANGED, M5 x 8mm LONG			32
-	1	1	1	1320908-7	SPACER, STRIP GUIDE			30
-	1	1	1	2119959-1	ASSEMBLY, STRIP GUIDE			29
-	1	1	1	455888-3	SPACER, CRIMPER			28
-	1	1	1	1320928-2	STRIP GUIDE			24
-	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0			21
-	2	2	2	1-18028-2	WASHER, FLAT, REG M4			20
-	1	1	1	2119533-1	STRIPPER, SIDE FEED			19
-	1	1	1	2119806-1	INSERT, SHEAR			13
-	1	1	1	3-22280-3	SPRING, COMPRESSION			12
-	1	1	1	1-356885-4	STOP, SHEAR			11
-	1	1	1	2119805-1	SHEAR HOLDER, FRONT			10
-	1	1	1	1803095-1	FLOATING SHEAR, FRONT			9
-	1	1	1	1-1633924-9	ANVIL, COMBINATION			8
-	-	-	-	-	-			7
-	-	-	-	-	-			6
-	1	1	1	1-2119757-0	DEPRESSOR, SHEAR			5
-	1	1	1	238011-9	BLOCK, CRIMPER SPACER			4
-	1	1	1	5-1803016-1	CRIMPER, INSULATION F			3
-	1	1	1	1-455888-6	SPACER, CRIMPER			2
-	1	1	1	3-456409-7	CRIMPER, WIRE .120 "F" PREMIUM			1

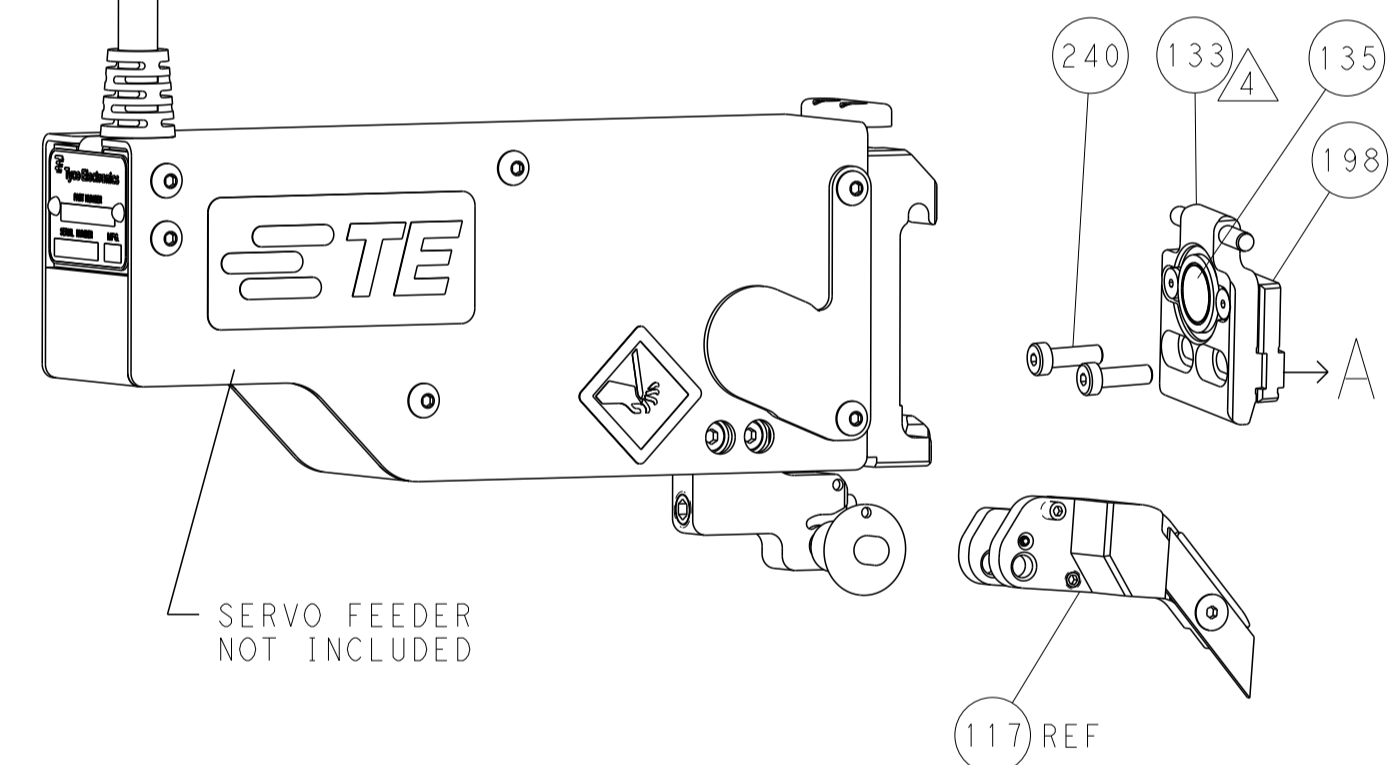
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	2 PLC	±									
	3 PLC	±									
	4 PLC	±									
	5 PLC	±									
	ANGLES	±									
	FINISH										

LOC	DIST	REV	DATE	BY	APPV
A	66				
REVISIONS			DATE	BY	APPV
DESCRIPTION					
SEE SHEET 1					

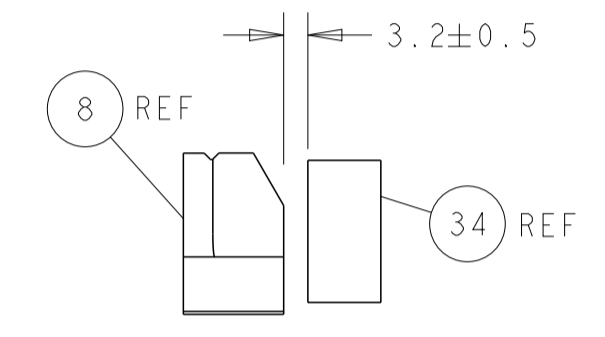
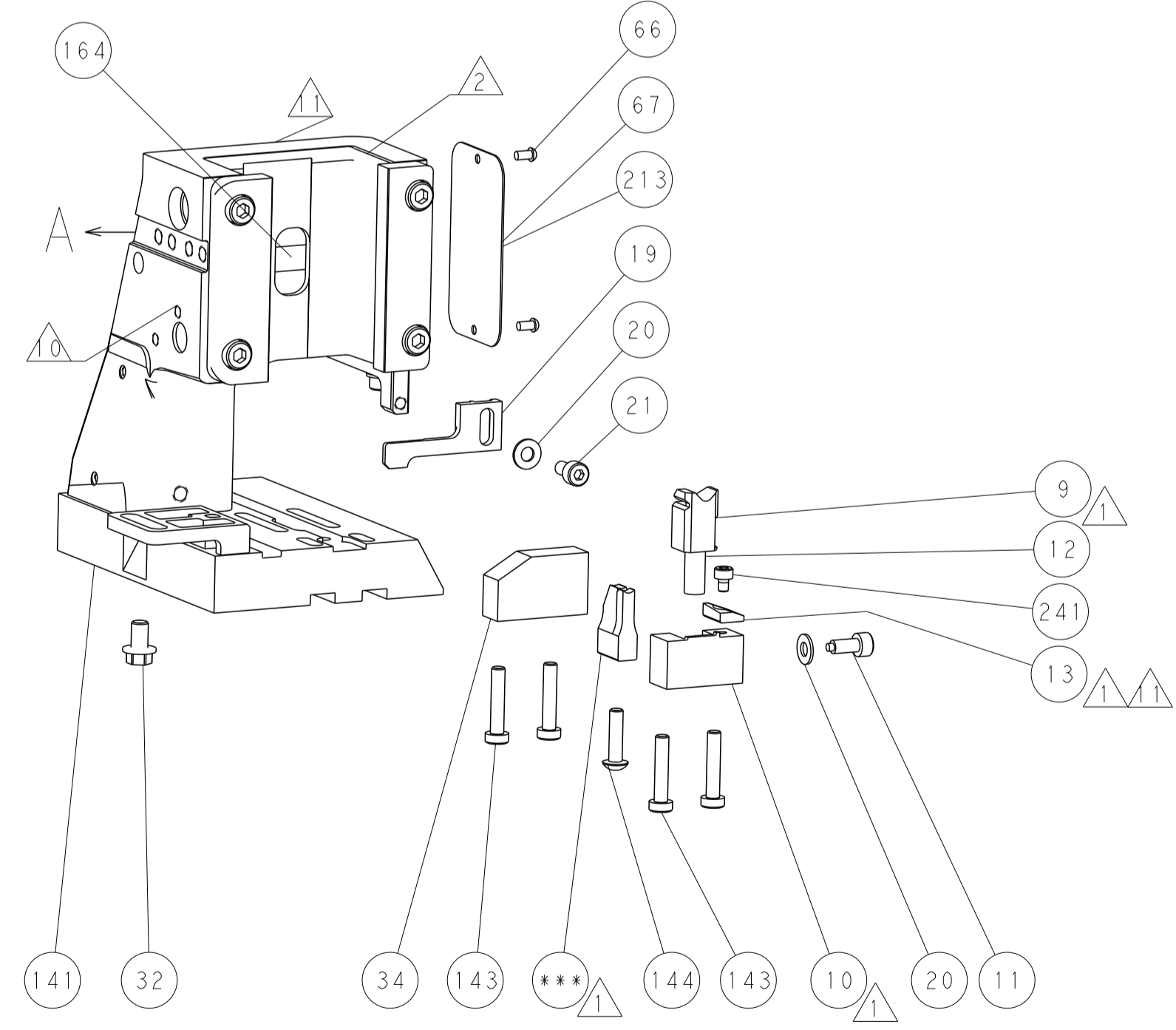
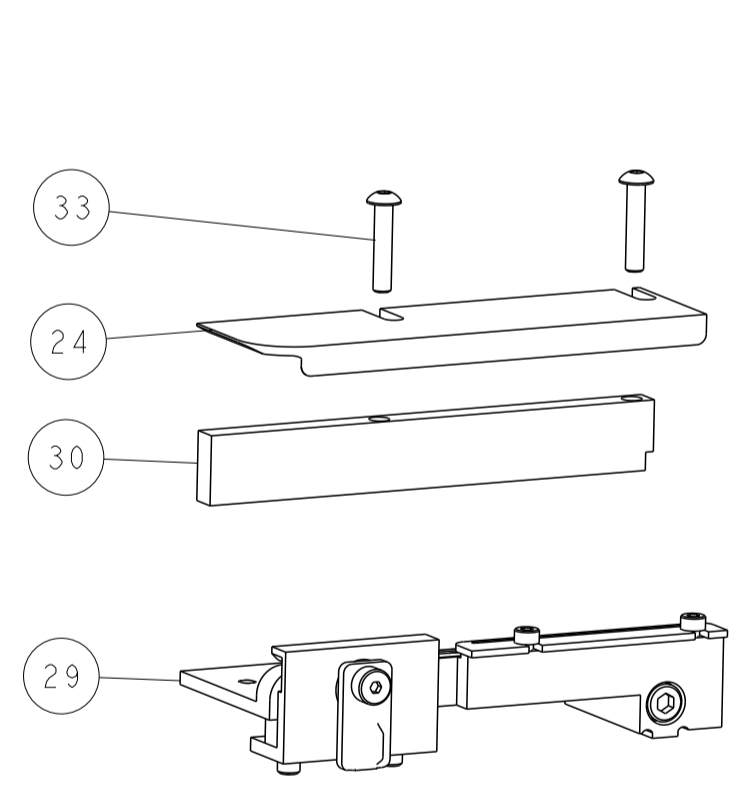
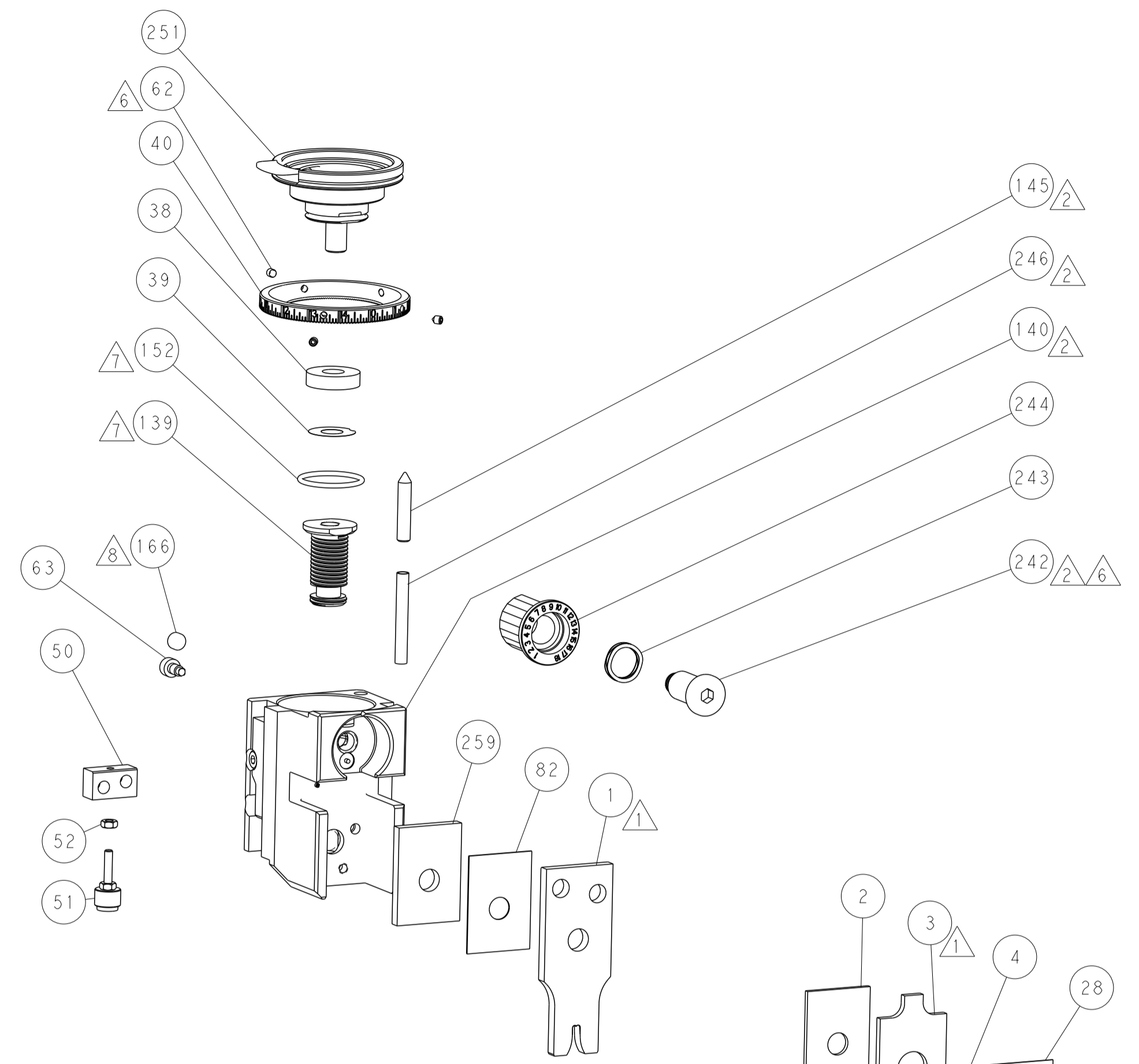
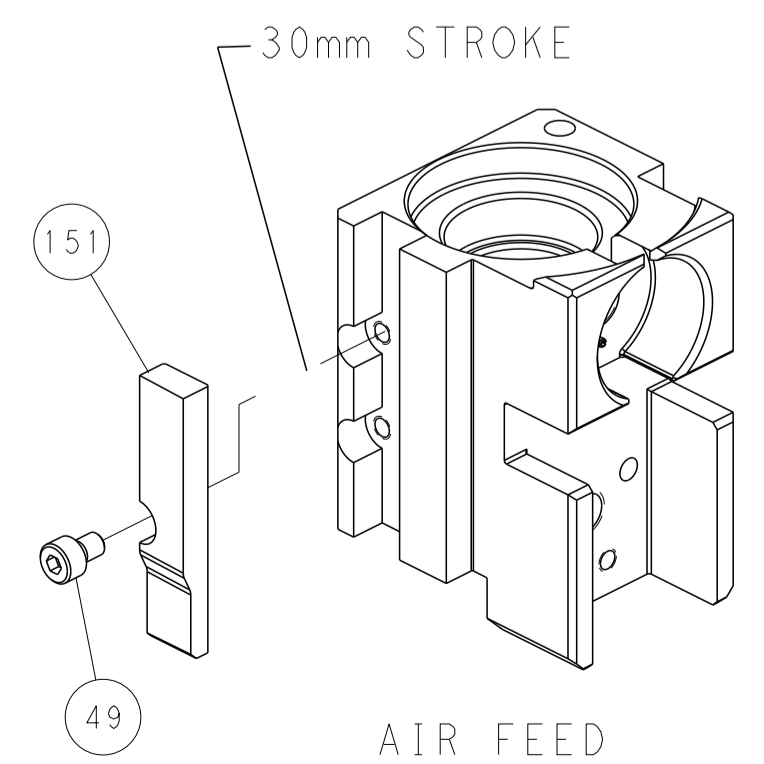
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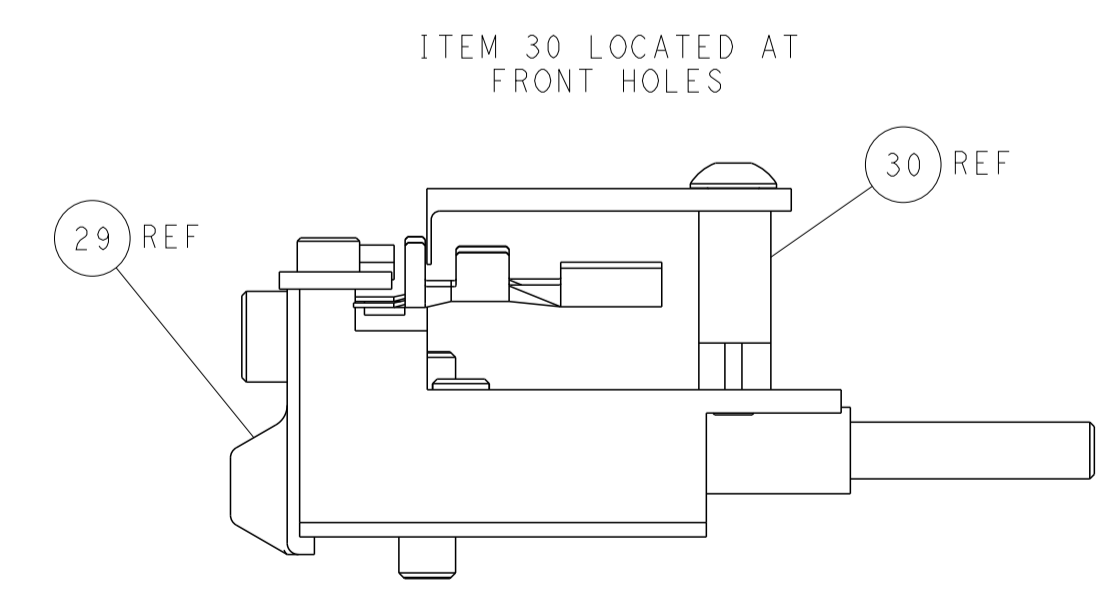
SERVO LATCH PLATE



CAM POSITION



TERMINAL SUPPORT LOCATION



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)

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