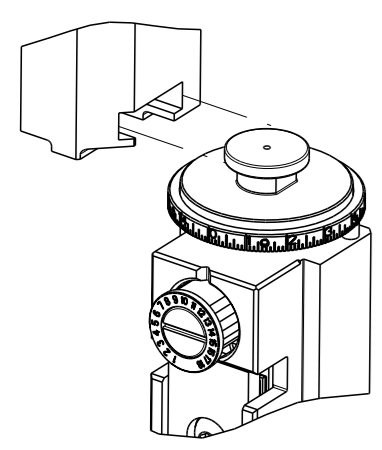
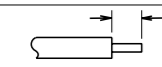


ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	
	2836859-1	A	FINE CRIMP HEIGHT ADJUST	MECHANICAL	SUPERSEDED BY 5-2151112-1
	2836859-2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	SUPERSEDED BY 5-2151112-2
	2836859-5	A	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE	OBSOLETE
	2836859-6	A	NON CRIMP HEIGHT ADJUST	SERVO LATCH PLATE	OBSOLETE
	2836859-7	A	FINE CRIMP HEIGHT ADJUST	NONE	OBSOLETE
	7-2836859-7	A	CRIMP TOOLING KIT	-	

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.78 mm [.070]	F
INSUL	3.56 mm [.140]	F

APPLICATOR INSTRUCTIONS
408-10389

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: MINI UNIVERSAL PIN AND SOCKET CONTACT TERMINAL			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
3.20-3.70 mm [.126-.146 IN]		Ø2.00-3.20 mm [.079-.126 IN]	
TERMINAL APPLICATION SPECIFICATION	114-5050		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
171636-1	171637-1	171637-2	171637-3
171637-4	5171637-3		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
16 AWG	1.30+/-0.05 [.051+/-0.002]	6.6
18 AWG	1.21+/-0.05 [.048+/-0.002]	7.3
20 AWG	1.06+/-0.05 [.042+/-0.002]	8.8

- 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: 8-2836859-4
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2836859-4
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2836859-5
 SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2836859-6
- 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 & 180. 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 & 180.
- 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 4.5.
- 13. THIS APPLICATOR IS SPECIFIC FOR USE IN A STRIPPER SEAL TERMINATING UNIT.
- 14. 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
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
-77	-7 -6 -5 -2 -1 PART NO	DESCRIPTION

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

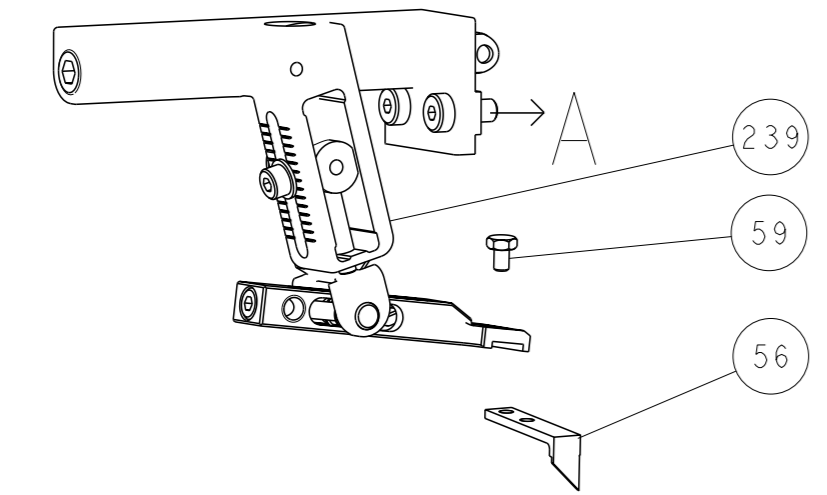
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2119599-1	A	66	#	DATE	BY	CHK
			A	RELEASED	27JUL2017	FZ KZ
			A1	ECR-18-011637	20JUL2018	JAH CT

ITEM NO	DESCRIPTION	ITEM NO
-	-	2119758-1
-	1	2119082-9
-	1	2079764-1
-	1	2119083-1
-	1	7-18023-7
-	2	2168400-6
-	-	2119580-1
-	-	2063440-1
-	1	2119740-2
-	1	1901094-3
-	1	4-1722335-3
-	1	1-5018030-0
-	1	1-1752354-7
-	1	9931111-1
-	1	5-22280-0
-	1	1752353-3
-	1	1901680-2
-	-	21045-3
-	1	994969-1
-	REF	994970-2
-	-	240638-1
-	-	3-23627-7
-	-	2119799-1
-	REF	SEE NOTE 4
-	1	1633743-1
-	1	1-18028-2
-	REF	2119944-1
-	1	2119955-1
-	1	455888-7
-	1	2119956-1
-	1	2119740-1
-	2	2168078-1
-	1	2119793-1
-	3	992763-5
-	1	2079383-4
-	-	5-18022-5
-	-	1338685-1
-	4	2168400-1
-	2	2-2168083-5
-	1	5018030-1
-	1	811242-5
-	1	690753-2
-	-	18023-9
-	-	2119652-1
-	-	2119653-1
-	1	2-2119656-1
-	1	2119370-1
-	1	2079383-7
-	1	2119645-1
-	1	2119957-1
-	1	1-2119644-2
-	1	2119085-1
-	1	2119092-1
-	1	1752356-3
-	2	2079383-5
-	1	2161328-1
-	1	1320908-6
-	1	2119959-1
-	1	455888-5
-	1	1320928-2
-	1	2119806-1
-	1	3-22280-3
-	1	1-356885-4
-	1	2119805-1
-	1	1803095-1
-	1	1338692-2
-	1	240641-5
-	1	2119757-8
-	1	238011-8
-	1	2-2119582-4
-	1	455888-2
-	1	2-456404-5
-77	-7 -6 -5 -2 -1 PART NO	DESCRIPTION

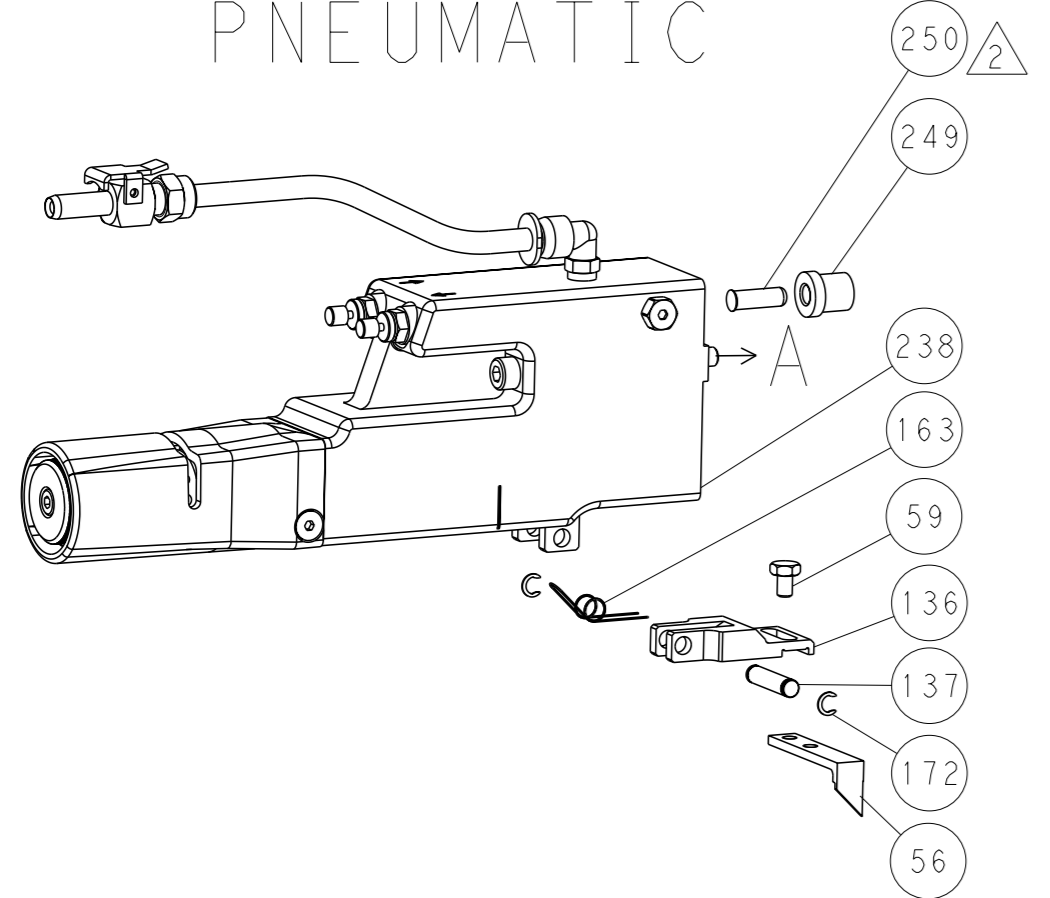
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mm	0 PLC	±		F. ZHANG	13JUL2017	TE Connectivity	
	1 PLC	±		C.K. ZHANG	13JUL2017	Harrisburg, PA 17105-3608	
	2 PLC	±		K. ZHANG	13JUL2017	Ocean Side Feed	
	3 PLC	±				Applicator	
	4 PLC	±				-	
	ANGLES	±				-	
MATERIAL	FINISH	±				SIZE	CAGE CODE
						A1	00779
						DRAWING NO	2836859
						RESTRICTED TO	
						Customer Accessible Production Drawing	SCALE 1:2 SHEET 1 of 4 REV A1

LOC	DIST	REV	DESCRIPTION	DATE	OWN	APVD
A	66		SEE SHEET 1			

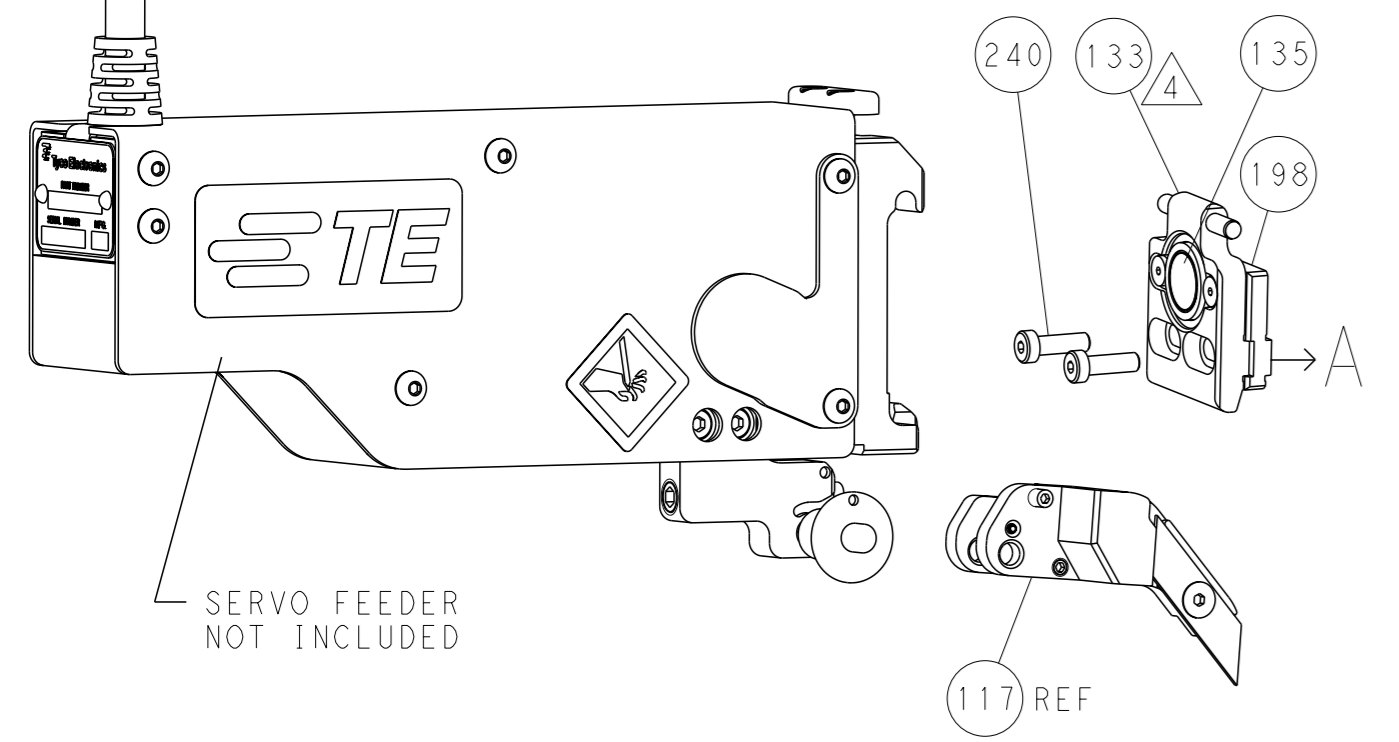
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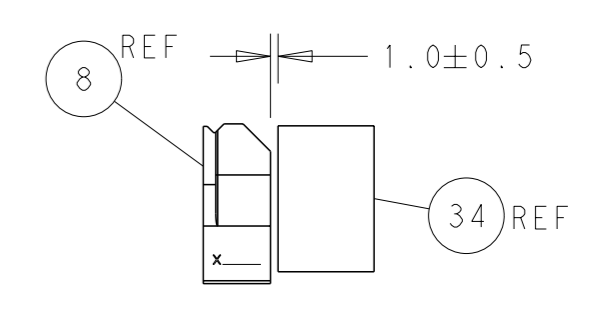
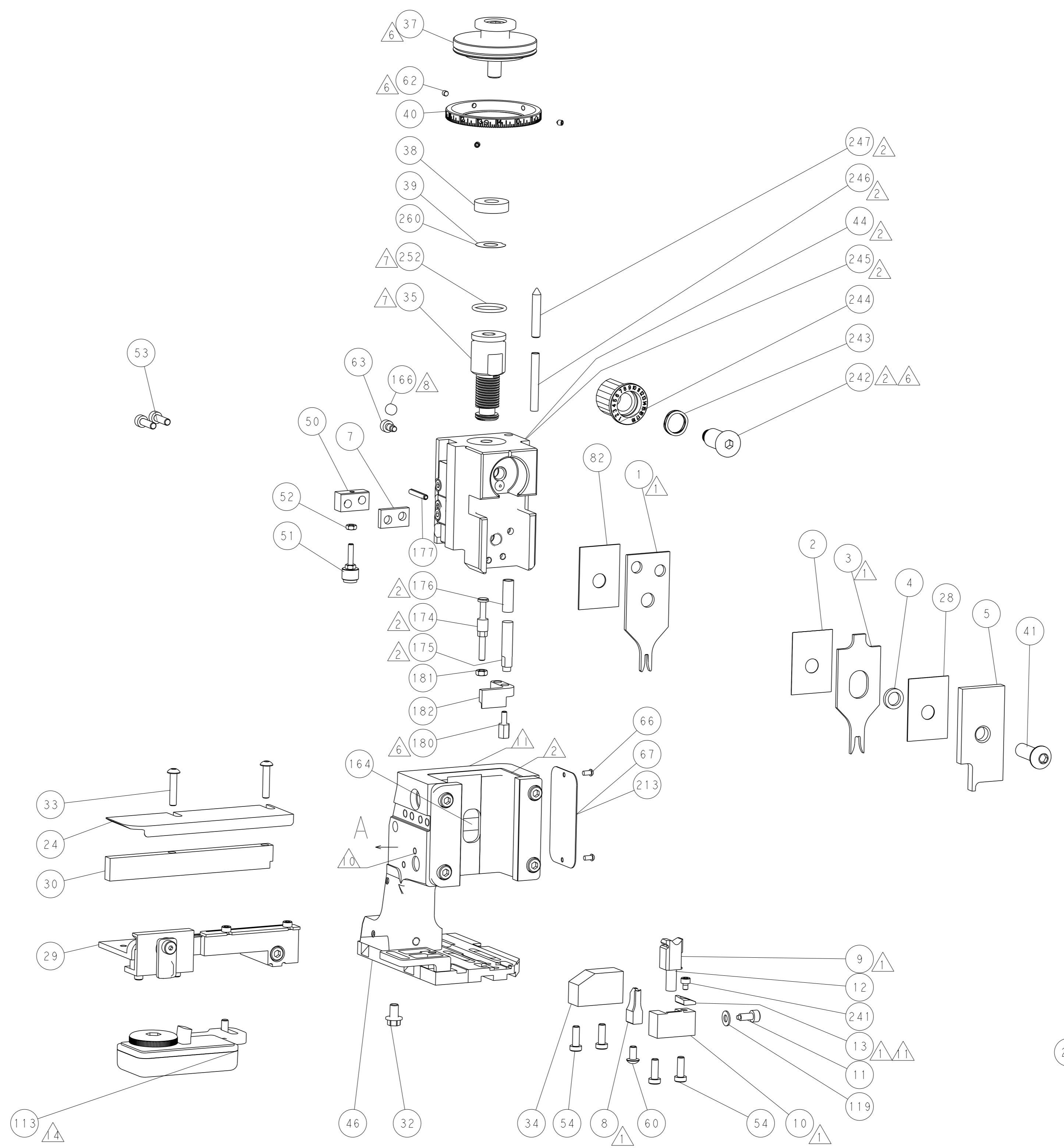
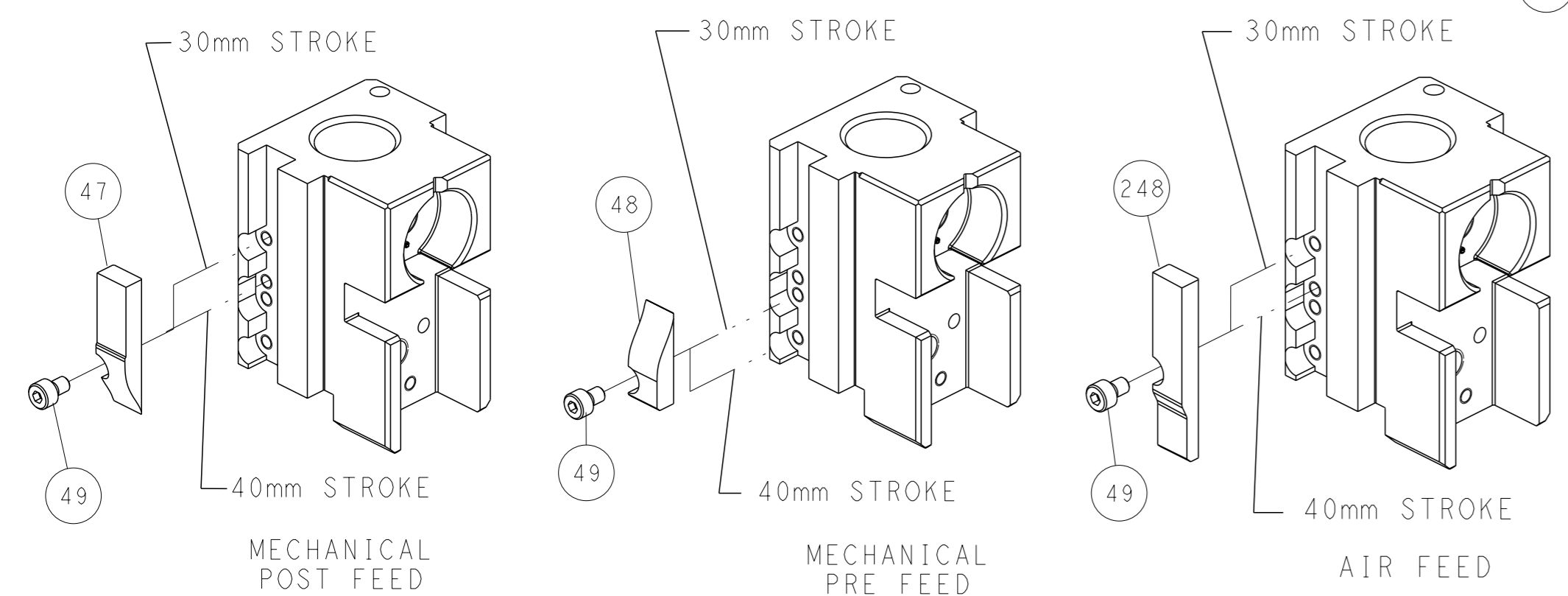
PNEUMATIC



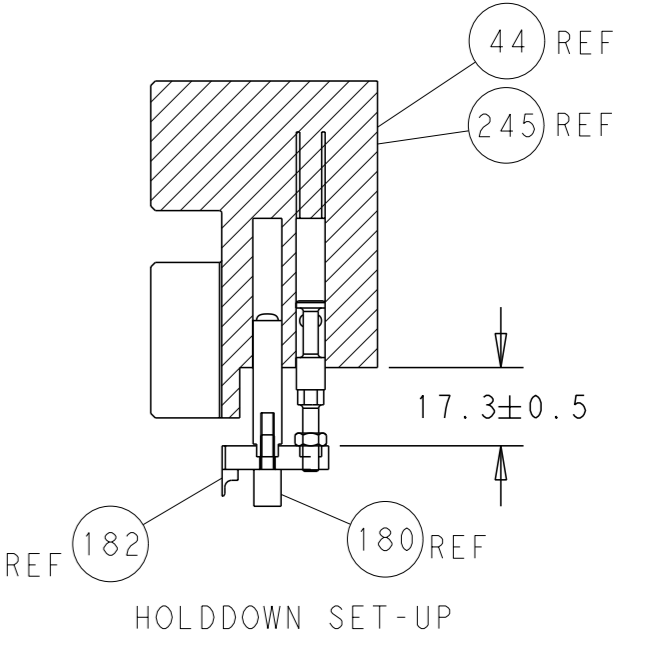
SERVO LATCH PLATE



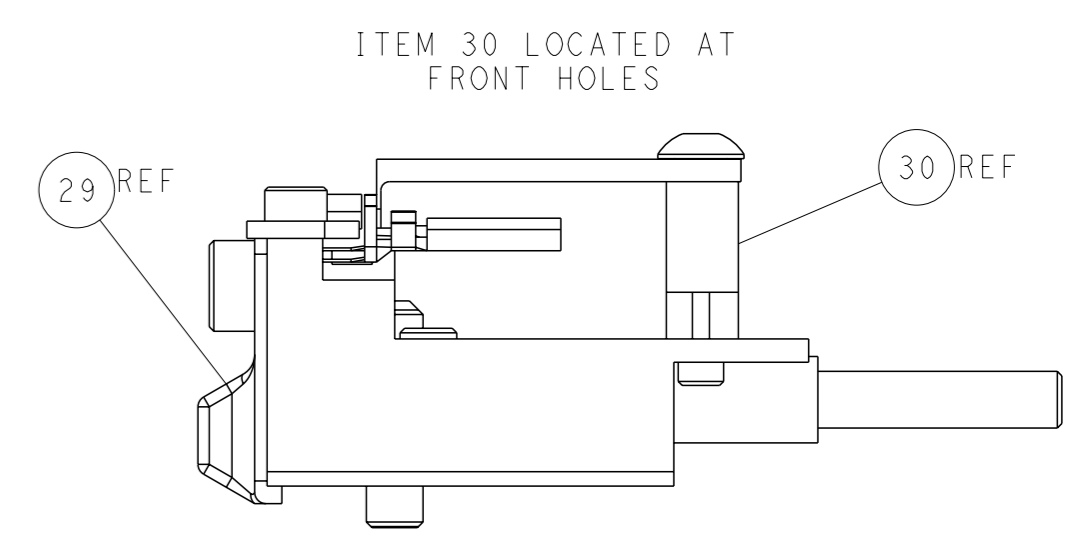
CAM POSITIONS



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)

DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		DWN F. ZHANG 13JUL2017 CHK K. ZHANG 13JUL2017 APVD K. ZHANG 13JUL2017 PRODUCT SPEC APPLICATION SPEC WEIGHT Customer Accessible Production Drawing		NAME Ocean Side Feed Applicator SIZE CAGE CODE DRAWING NO A1 00779 ©=2836859 SCALE 1:2 SHEET 2 of 4 REV A1		TE Connectivity Harrisburg, PA 17105-3608 RESTRICTED TO	
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PACIFIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	
	2-2836859-1	A	FINE CRIMP HEIGHT ADJUST	MECHANICAL	OBSOLETE
	2-2836859-2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	OBSOLETE
	2-2836859-5	A	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE	OBSOLETE
	2-2836859-7	A	FINE CRIMP HEIGHT ADJUST	NONE	OBSOLETE
	7-2836859-7	A	CRIMP TOOLING KIT	-	

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.78 mm [.070]	F
INSUL	3.56 mm [1.40]	F
APPLICATOR INSTRUCTIONS 408-10389		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: MINI UNIVERSAL PIN AND SOCKET CONTACT TERMINAL			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
3.20-3.70 mm [1.26-.146 IN]		Ø2.00-3.20 mm [0.79-.126 IN]	
TERMINAL APPLICATION SPECIFICATION	114-5050		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
171636-1	171637-1	171637-2	171637-3
171637-4	5171637-3		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
16 AWG	1.30 +/- 0.05 [0.051 +/- .002]	6.6
18 AWG	1.21 +/- 0.05 [0.048 +/- .002]	7.3
20 AWG	1.06 +/- 0.05 [0.042 +/- .002]	8.8

- 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. SEE BELOW FOR PART NUMBER:
 - MECHANICAL FEED WITH "SMART APPLICATOR" CONVERSION: 8-2836859-4
 - PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2836859-4
 - SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2836859-5
- 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 & 180. 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.
- THIS APPLICATOR IS SPECIFIC FOR USE IN A STRIPPER SEAL TERMINATING UNIT.
- 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	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	1-22279-3	SPRING, COMPRESSION	246
-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)

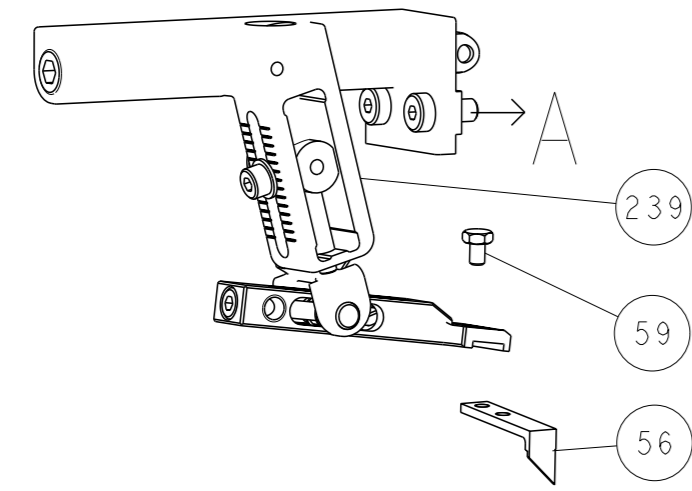
SET UP GAUGE	LOC	DIST	REVISIONS					
2119599-1	A	66	#	LYR	DESCRIPTION	DATE	OWN	APVD
			-		SEE SHEET 1			

-	1	1	1	1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	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	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	-	-	1	-	2063440-1	AIR FEED MODULE	238
-	-	1	-	-	2119740-2	TAG, IDENTIFICATION	213
-	-	1	-	-	1901094-3	SPACER, FEEDER	198
-	1	1	1	1	4-1722335-3	STRIPPER, SIDE FEED	182
-	1	1	1	1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	181
-	1	1	1	1	1-1752354-7	STANDOFF, HOLD-DOWN	180
-	1	1	1	1	993111-1	PIN, SLOTTED SPRING 3.0 X 20.0	177
-	1	1	1	1	5-22280-0	SPRING, COMPRESSION	176
-	1	1	1	1	1752353-3	GUIDE PIN, HOLDDOWN	175
-	1	1	1	1	1901680-2	GUIDE PIN, HOLDDOWN	174
-	-	-	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	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	2119798-2	DETENT PIN	145
-	1	1	1	1	2079383-8	SCR, BHSC, RoHS (M4 X 16)	144
-	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	2-2119656-2	APPLICATOR BASIC ASSEMBLY, SF	141
-	1	1	1	1	2119650-1	RAM, ASIAN STYLE, SIDE FEED	140
-	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
-	-	1	-	-	1633743-1	SERVO FEED LATCH ASM	133
-	1	1	1	1	1-18028-2	WASHER, FLAT, REG M4	119
-	-	REF	-	-	2119944-1	FEED FINGER ASSEMBLY, SF	117
-	1	1	1	1	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113
-	1	1	1	1	455888-7	SPACER, CRIMPER	82
-	1	1	1	1	2119956-1	DOCUMENTATION PACKAGE	71
-	1	-	1	1	2119740-1	TAG, IDENTIFICATION	67
-	2	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	1	1	1	1	2119793-1	LIMITER, ADJUSTMENT BOLT	63
-	3	3	3	3	992763-5	SCR, SET, SOC, CONE PNT, M3 X 4.0	62
-	-	-	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	-	-	1	1	1338685-1	PAWL, FEED	56
-	2	2	2	2	2-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 14	53
-	1	1	1	1	5018030-1	NUT, HEX, REG, RoHS, M3	52
-	1	1	1	1	811242-5	BUMPER, HOLD DOWN	51
-	1	1	1	1	690753-2	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	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	1-2119644-2	RAM WASHER, PRECISION	38
-	1	1	1	1	1752356-3	SUPPORT, TERMINAL	34
-	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	1	1	1	1	2161328-1	HEX HEAD, FLANGED, M5 X 8mm LONG	32
-	1	1	1	1	1320908-6	SPACER, STRIP GUIDE	30
-	1	1	1	1	2119959-1	ASSEMBLY, STRIP GUIDE	29
-	1	1	1	1	455888-5	SPACER, CRIMPER	28
-	1	1	1	1	1320928-2	STRIP GUIDE	24
-	1	1	1	1	2119806-1	INSERT, SHEAR	13
-	1	1	1	1	3-22280-3	SPRING, COMPRESSION	12
-	1	1	1	1	1-356885-4	STOP, SHEAR	11
-	1	1	1	1	2119805-1	SHEAR HOLDER, FRONT	10
-	1	1	1	1	1803095-1	FLOATING SHEAR, FRONT	9
-	1	1	1	1	1338692-2	ANVIL, COMBINATION .070	8
-	1	1	1	1	240641-5	SPACER	7
-	1	1	1	1	2119757-8	DEPRESSOR, SHEAR	5
-	1	1	1	1	238011-8	BLOCK, CRIMPER SPACER	4
-	1	1	1	1	2-2119582-4	CRIMPER, INSULATION F PREMIUM	3
-	1	1	1	1	455888-2	SPACER, CRIMPER	2
-	1	1	1	1	2-456404-5	CRIMPER, WIRE PREMIUM	1

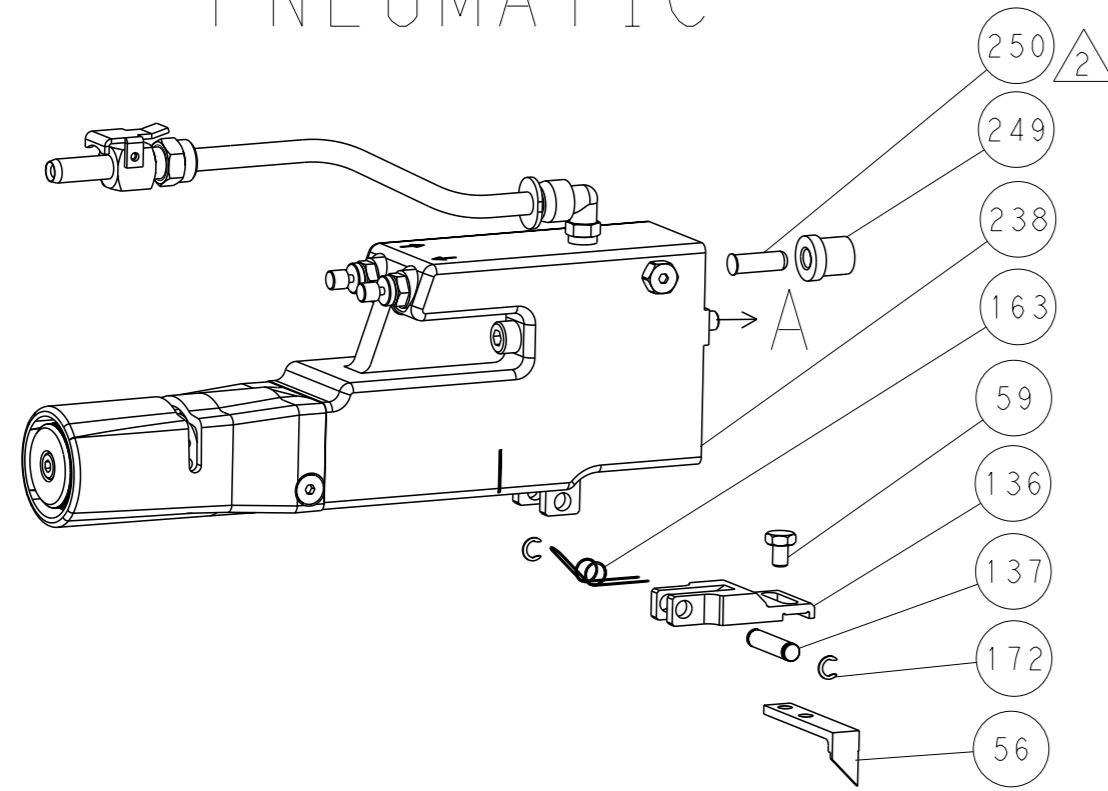
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	3 PLC ±	4 PLC ±	ANGLES FINISH	APPLICATOR SPEC		CUSTOMER ACCESSIBLE PRODUCTION DRAWING		SCALE 1:2		SHEET 3 OF 4		REV A1	

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

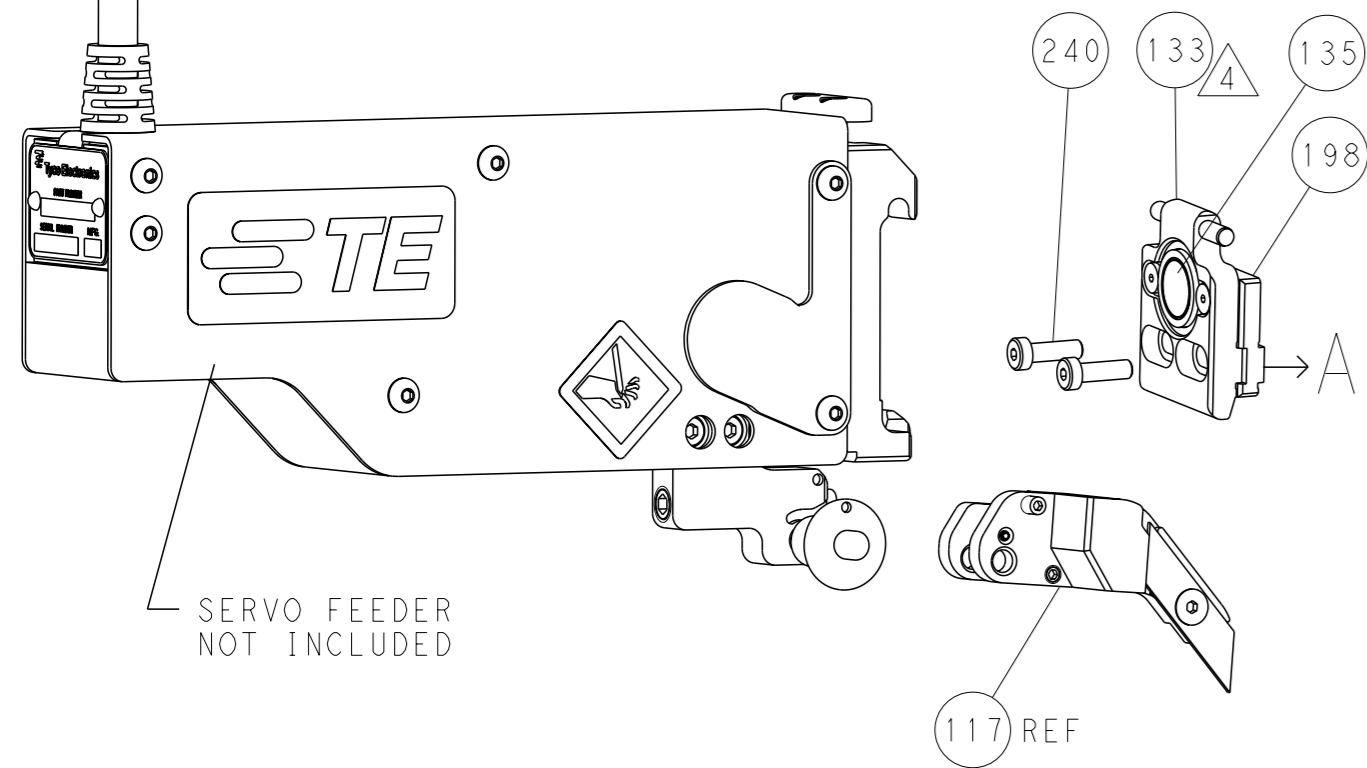
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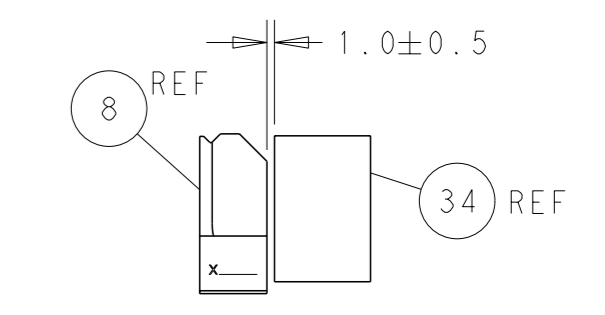
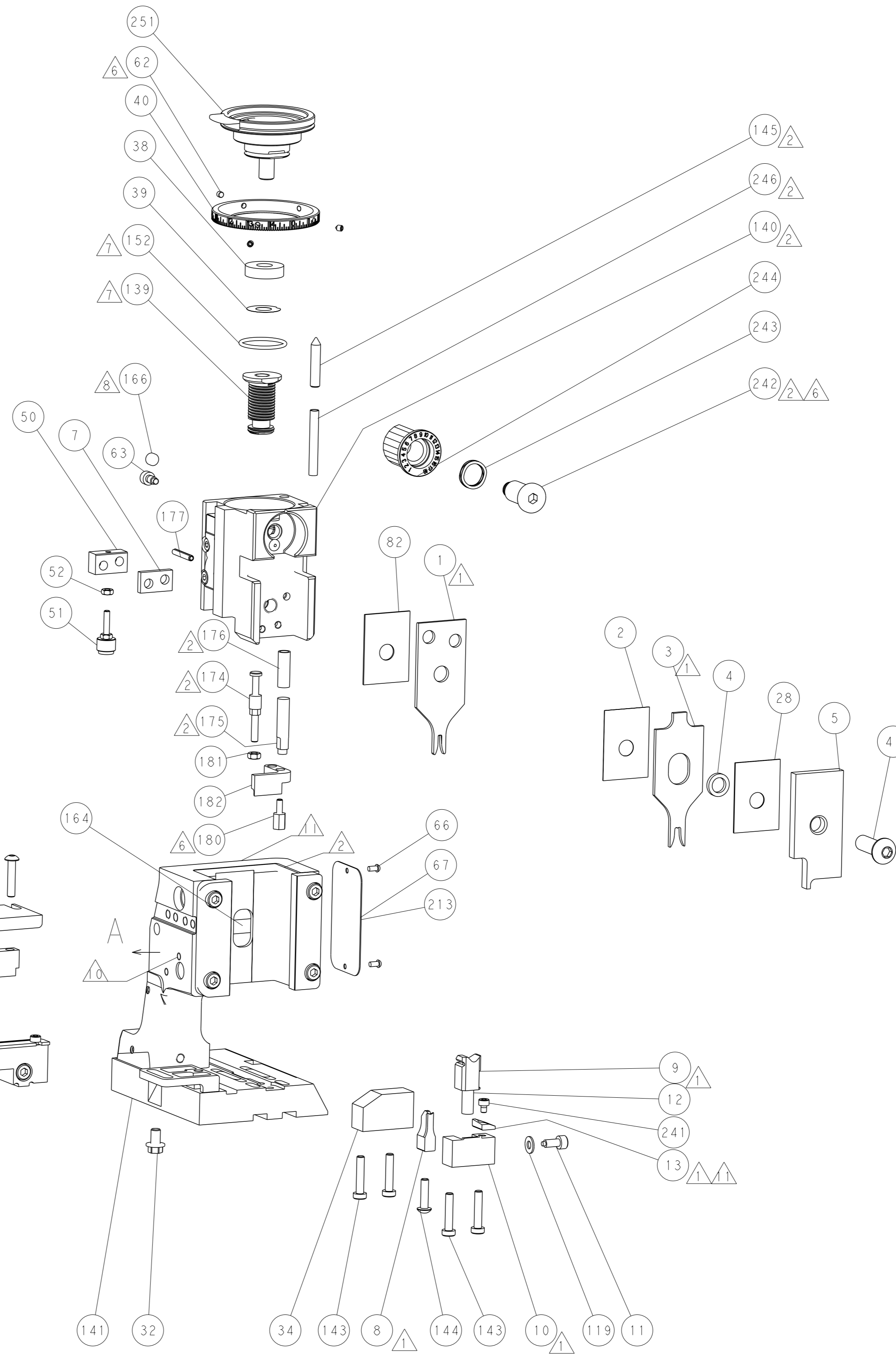
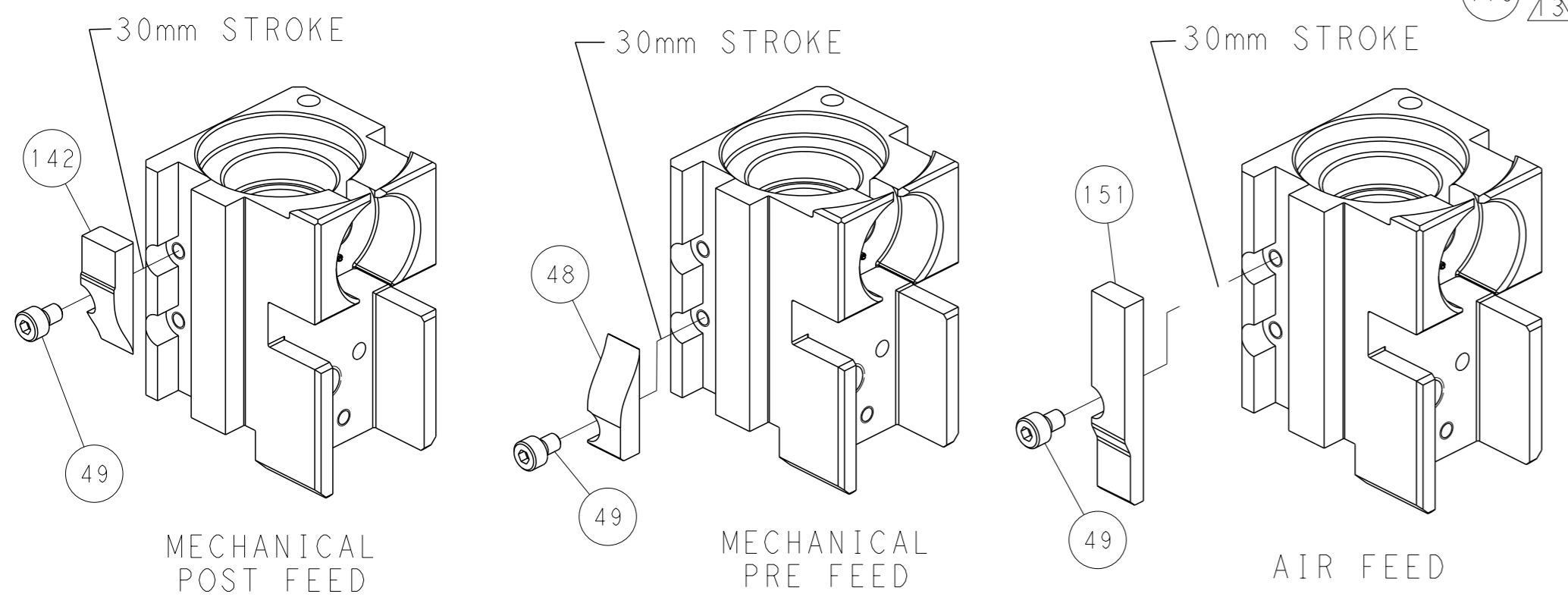
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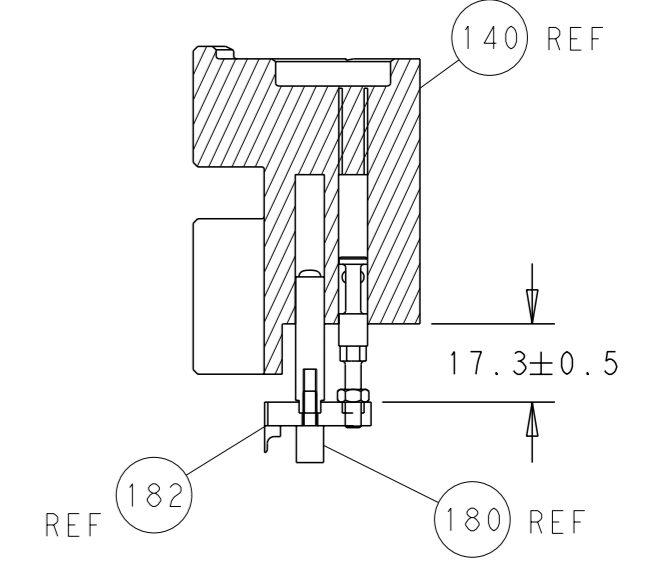
SERVO LATCH PLATE



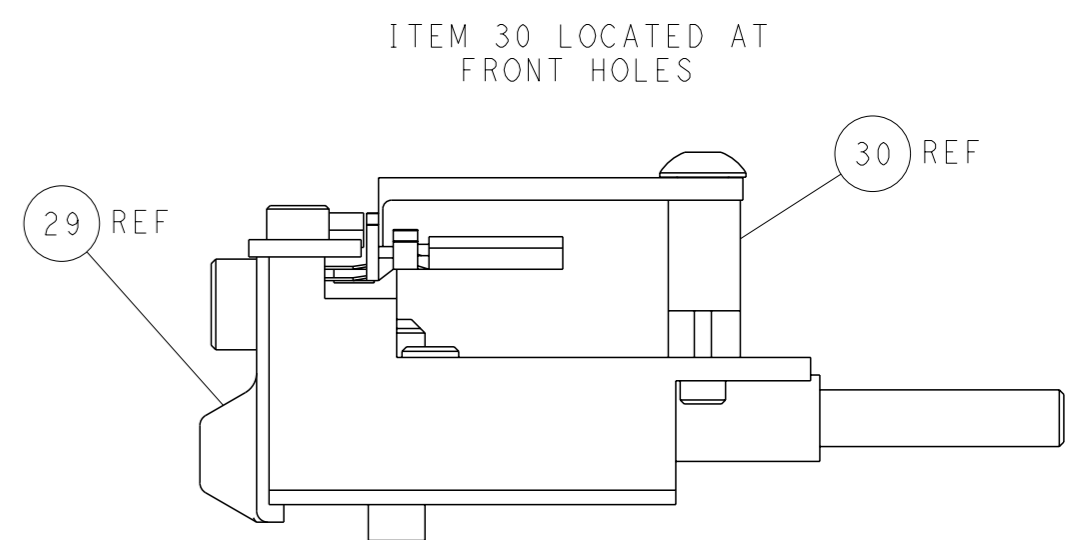
CAM POSITIONS



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)

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DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH ±	APPLICATION SPEC: - MATERIAL: -	PRODUCT SPEC: - APPLICATION SPEC: - WEIGHT: -	SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2836859 RESTRICTED TO: -
Customer Accessible Production Drawing		SCALE: 1:2	SHEET 4 OF 4 REV A1