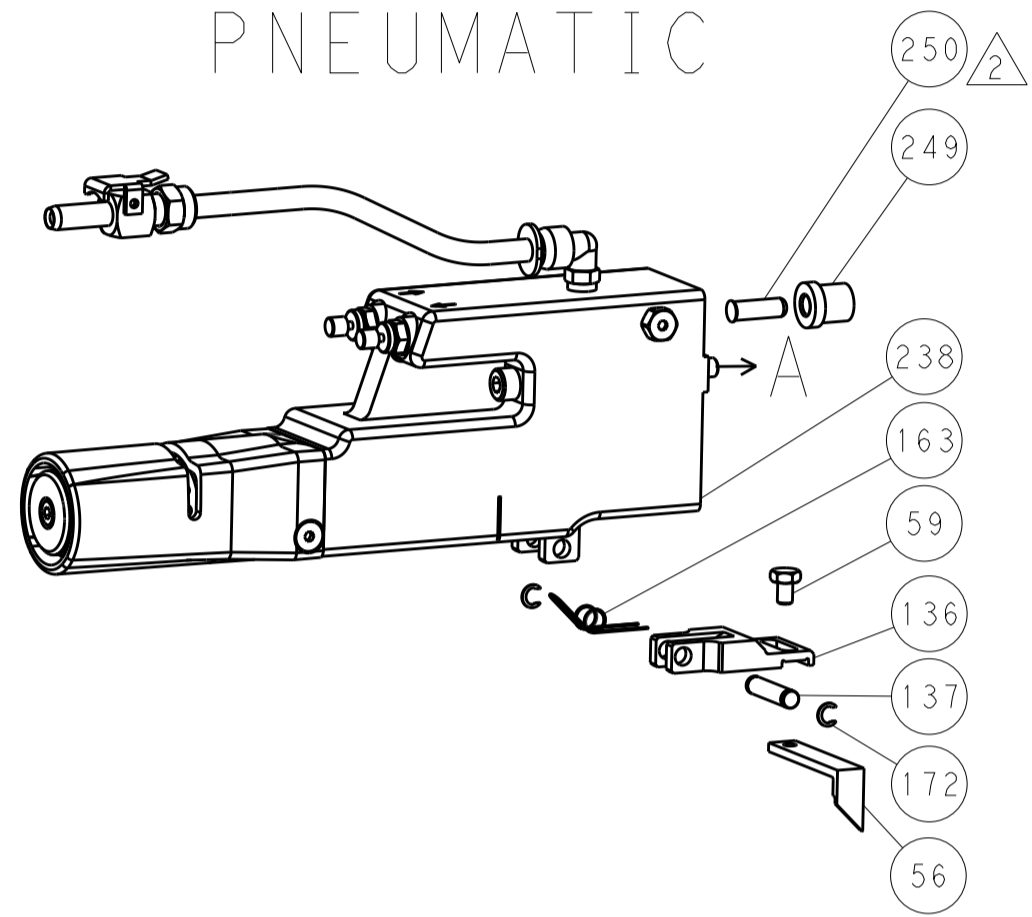


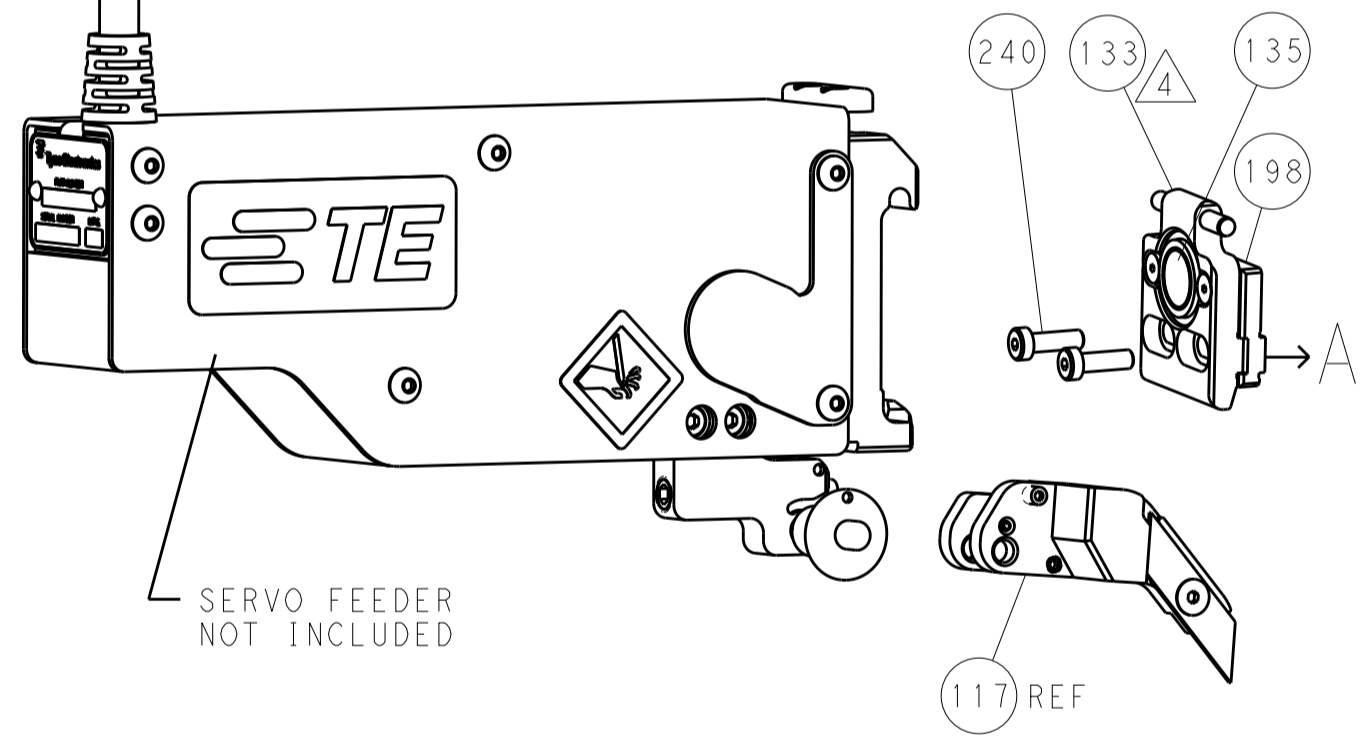
LOC	DIST	REVISIONS			
P	LTN	DESCRIPTION	DATE	DWN	APVD
A	66	SEE SHEET 1	-	-	-

FEED TYPE

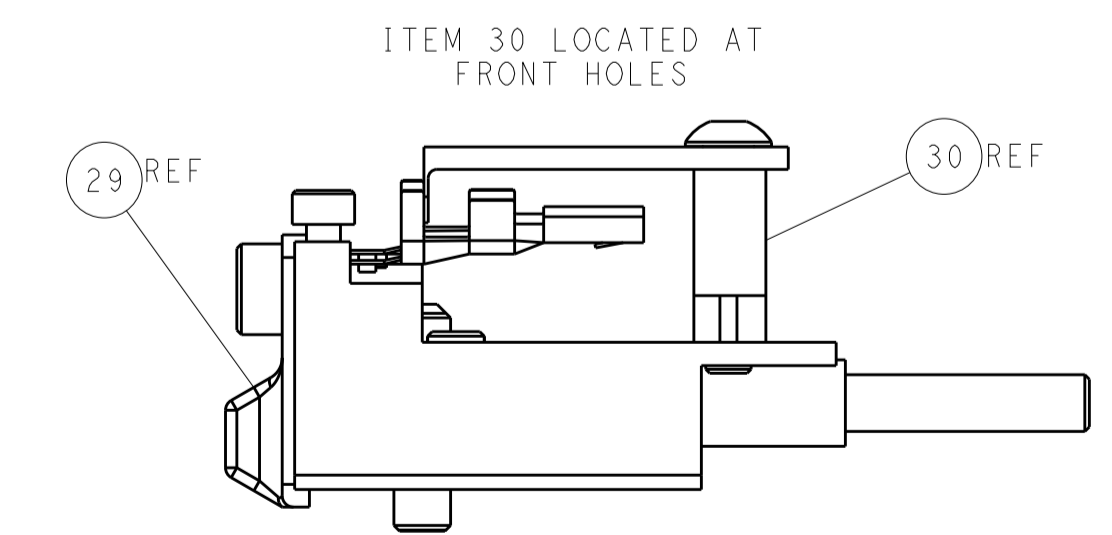
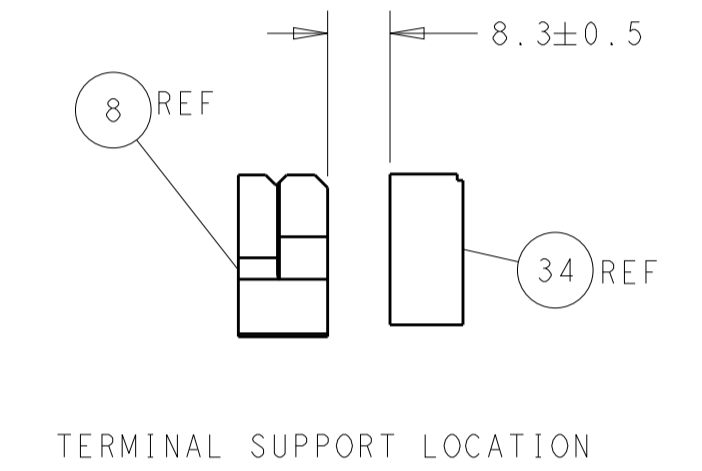
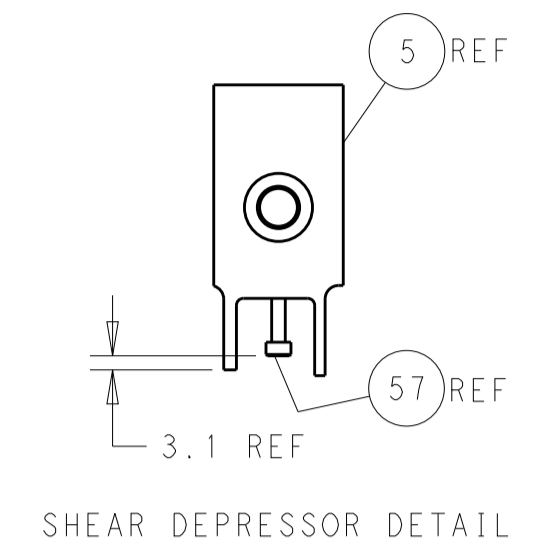
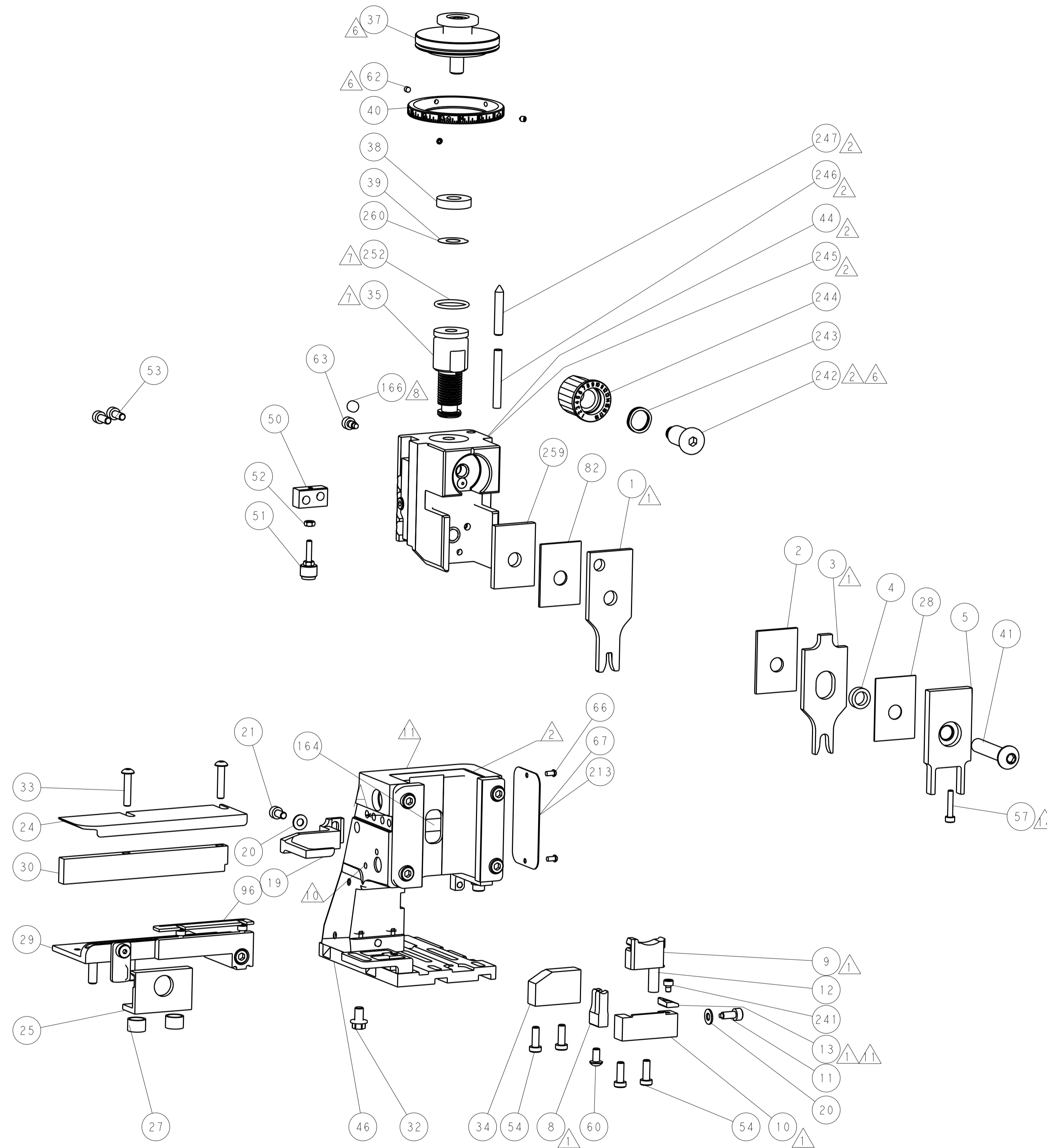
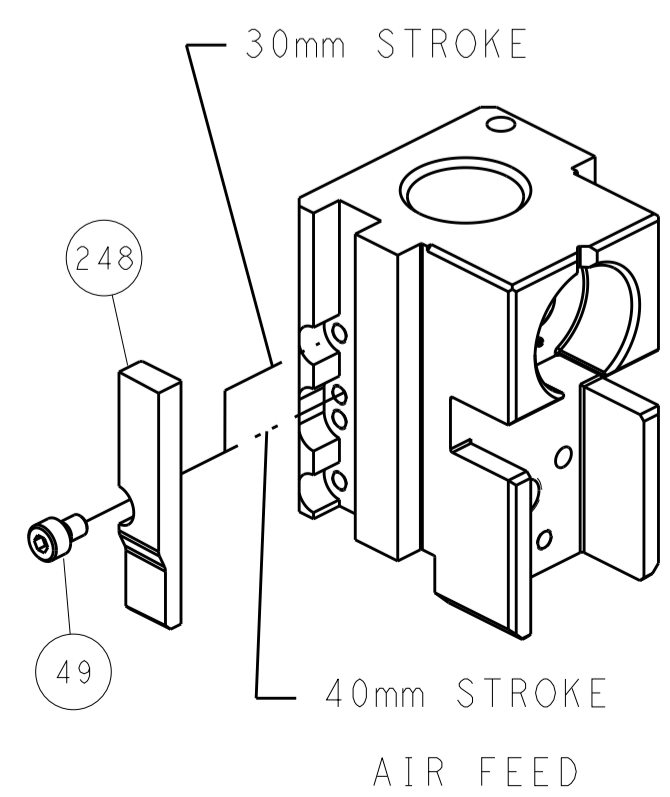
PNEUMATIC



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)

<small>THE DRAWING IS CONTROLLED THROUGHOUT THE PRODUCT LIFECYCLE. ANY CHANGES TO THIS DRAWING MUST BE APPROVED BY THE ORIGINAL DESIGNER AND THE QUALITY CONTROL AND ENGINEERING DEPARTMENTS. REVISED DRAWINGS MUST BE CONTROLLED FOR THE LATEST POSITION.</small>		DWN: B. WEAVER 07OCT2017 CHK: C. TOPPER 07OCT2017 APVD: C. TOPPER 07OCT2017	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 Feed Applicator PRODUCT SPEC: APPLICATION SPEC: WEIGHT:	SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2836952 RESTRICTED TO:
MATERIAL:		FINISH:	SCALE: 1:2 SHEET: 2 of 4 REV: B

PACIFIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART						
					CONVERT TO	PART NUMBERS REQUIRED					
	2-2836952-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	-	-	-	-	-	-	-
					SERVO LATCH PLATE	2119951-1	-	8-2836952-5	1901094-3	-	2168400-6 (QUANTITY 2)
	2-2836952-5	B	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE ⁴	-	-	-	-	-	-	-
2-2836952-7	B	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	-	
7-2836952-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-	

APPLICATOR DATA

CRIMP	SIZE	TYPE
WIRE	3.30 mm [1.30]	F
INSUL	5.59 mm [2.20]	O

APPLICATOR INSTRUCTIONS
408-10389

TERMINAL DATA: KOSTAL/LEAR TERMINAL KOSTAL CRIMP SPECIFICATION

TERMINAL NAME: SLK 2.8 TERMINAL

WIRE STRIP LENGTH	INSULATION DIAMETER RANGE
5.00-5.60 mm [1.97-.220 IN]	3.40-3.70 mm [1.34-.146 IN]

TERMINAL APPLICATION SPECIFICATION DOC00074173 Rev 08/12

TERMINALS APPLIED ¹⁰

TE TERMINAL	KOSTAL/LEAR TERMINAL	TE SEAL	KOSTAL/LEAR SEAL	SEAL INSULATION DIAMETER RANGE
1572921-1	22140583120	1572957-1	10800583400	5.70mm MAX [1.224 IN MAX]
1572921-2	22124583120	1572957-2	10800583130	5.70mm MAX [1.224 IN MAX]
1572921-3	22125583120	1572957-3	32045B24	5.70mm MAX [1.224 IN MAX]
1572921-4	3202574P0	-	-	-

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
4.00mm ²	1.95+/-0.05 [1.077+/-0.02]	9.2



- 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: 8-2836952-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2836952-5
- 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.
- ¹² APPLY TORO-SEAL IN ALLEN SOCKET TO FILL HOLE AFTER FLAT HD HAS BEEN ADJUSTED TO CORRECT HEIGHT AT QUALIFICATION. APPLY #1-23419-5 LOC-TITE TO THREADS.

***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	1803078-3	SPACER, PRECISION	259
-77	-27	-25	-22	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	P	LTN	DESCRIPTION	DATE	OWN	APVD
-	-	-	-	-	SEE SHEET 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	1-22279-3	SPRING, COMPRESSION	246
-	1	1	1	2119082-5	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	2063440-1	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	1-2119656-8	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	1-690438-0	FRONT STRIP GUIDE	96
-	1	1	1	1-455888-3	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 PNT, M3 X 4.0	62
-	-	-	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	1	1	1	1-2168083-3	SCR, SKT HD CAP, RoHS, M3 X 16	57
-	-	-	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	1-2119644-3	RAM WASHER, PRECISION	38
-	1	1	1	5-1752356-1	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	1-1320908-2	SPACER, STRIP GUIDE	30
-	1	1	1	2119959-6	ASSEMBLY, STRIP GUIDE	29
-	1	1	1	455888-5	SPACER, CRIMPER	28
-	2	2	2	22283-1	SPRING, COMPRESSION	27
-	1	1	1	240792-1	DRAG, TERMINAL	25
-	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	1803013-1	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	2119805-7	SHEAR HOLDER, FRONT	10
-	1	1	1	318059-9	FLOATING SHEAR, FRONT	9
-	1	1	1	1-1633925-6	ANVIL, COMBINATION	8
-	-	-	-	-	-	7
-	-	-	-	-	-	6
-	1	1	1	1803080-1	DEPRESSOR, SHEAR	5
-	1	1	1	238011-1	BLOCK, CRIMPER SPACER	4
-	1	1	1	1-1803464-5	CRIMPER, INSULATION O	3
-	1	1	1	1-455888-7	SPACER, CRIMPER	2
-	1	1	1	456410-1	CRIMPER, WIRE PREMIUM	1

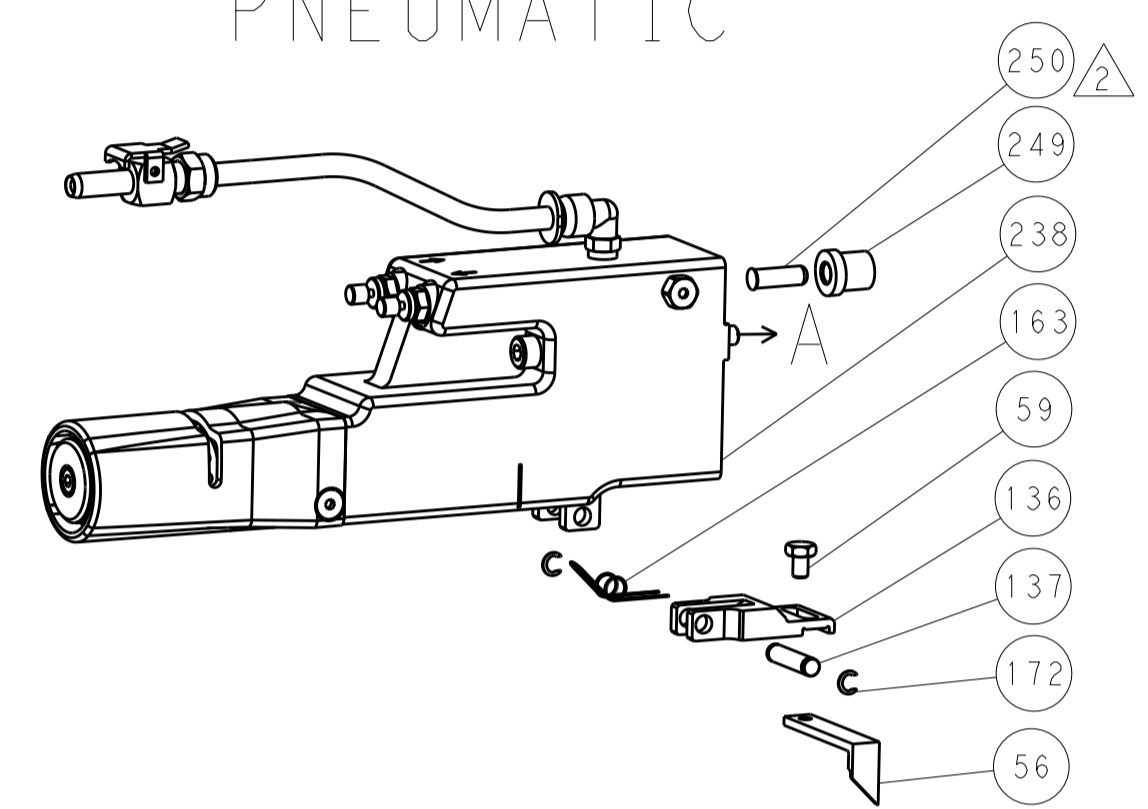
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:	
mm	0 PLC ±	1 PLC ±	2 PLC ±
	3 PLC ±	4 PLC ±	ANGLES ±
MATERIAL:	FINISH:	WEIGHT:	

DRAWING NO	00779	SCALE	1:2	SHEET	3	OF	4
DATE	07OCT2017	BY	WEAVER	CHK	TOPPER	APVD	TOPPER

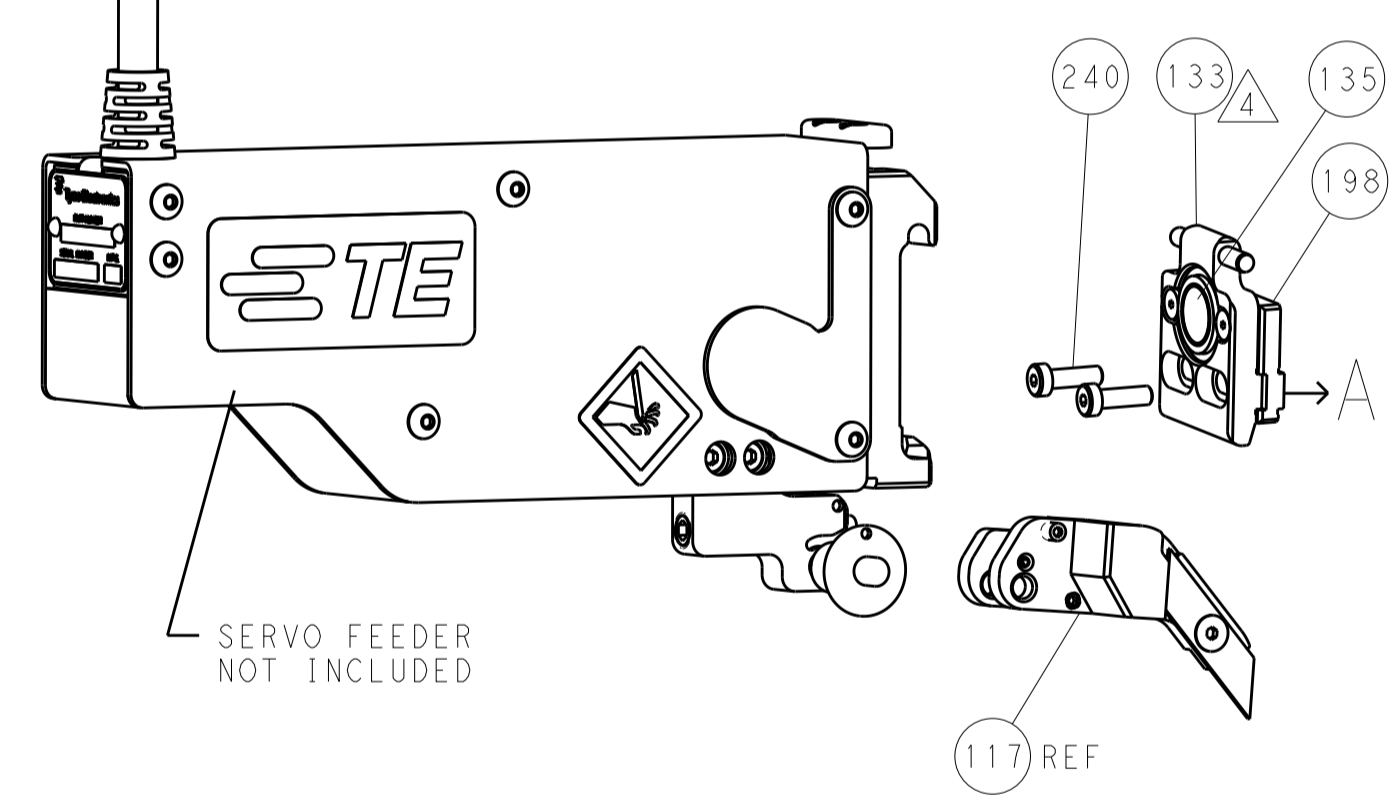
Customer Accessible Production Drawing

LOC	DIST	REV	DATE	BY	APPV
A	66				

FEED TYPE PNEUMATIC



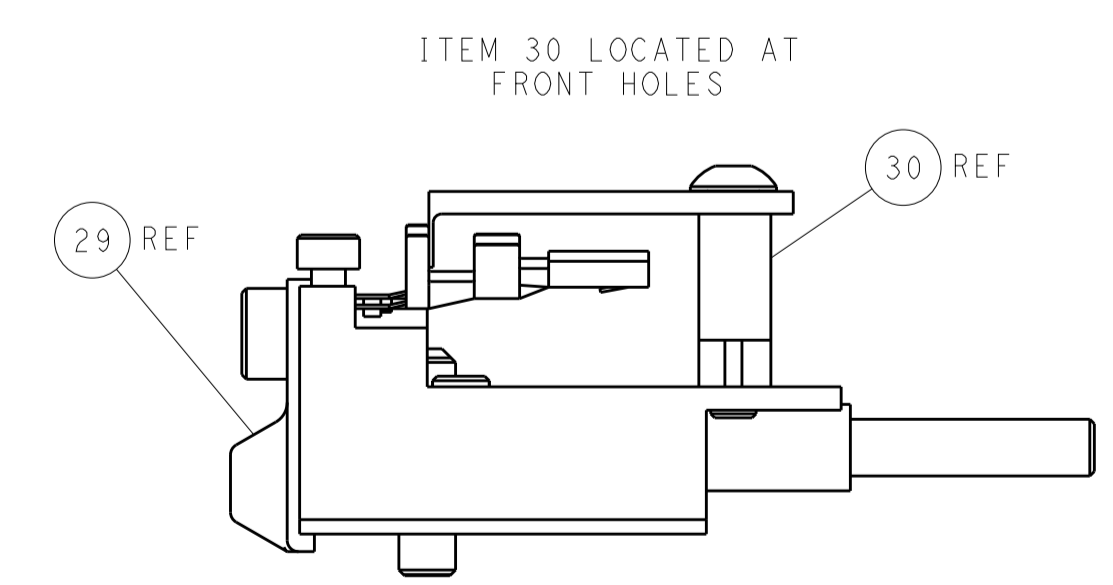
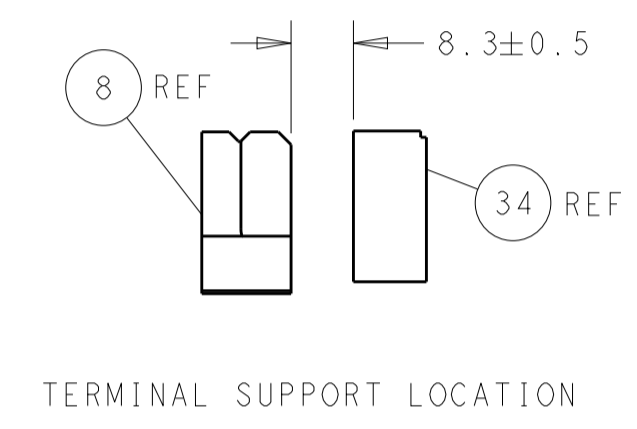
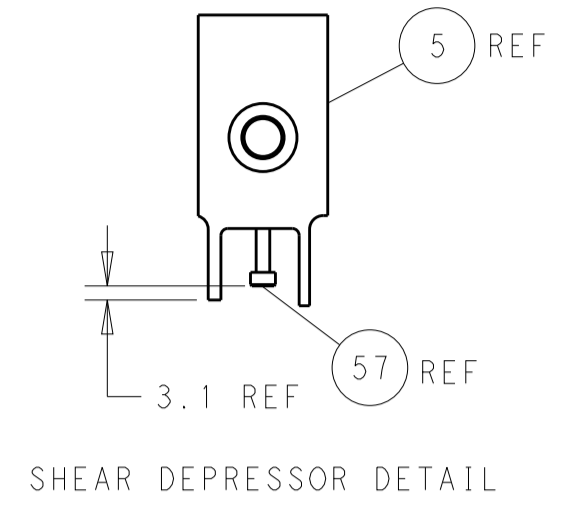
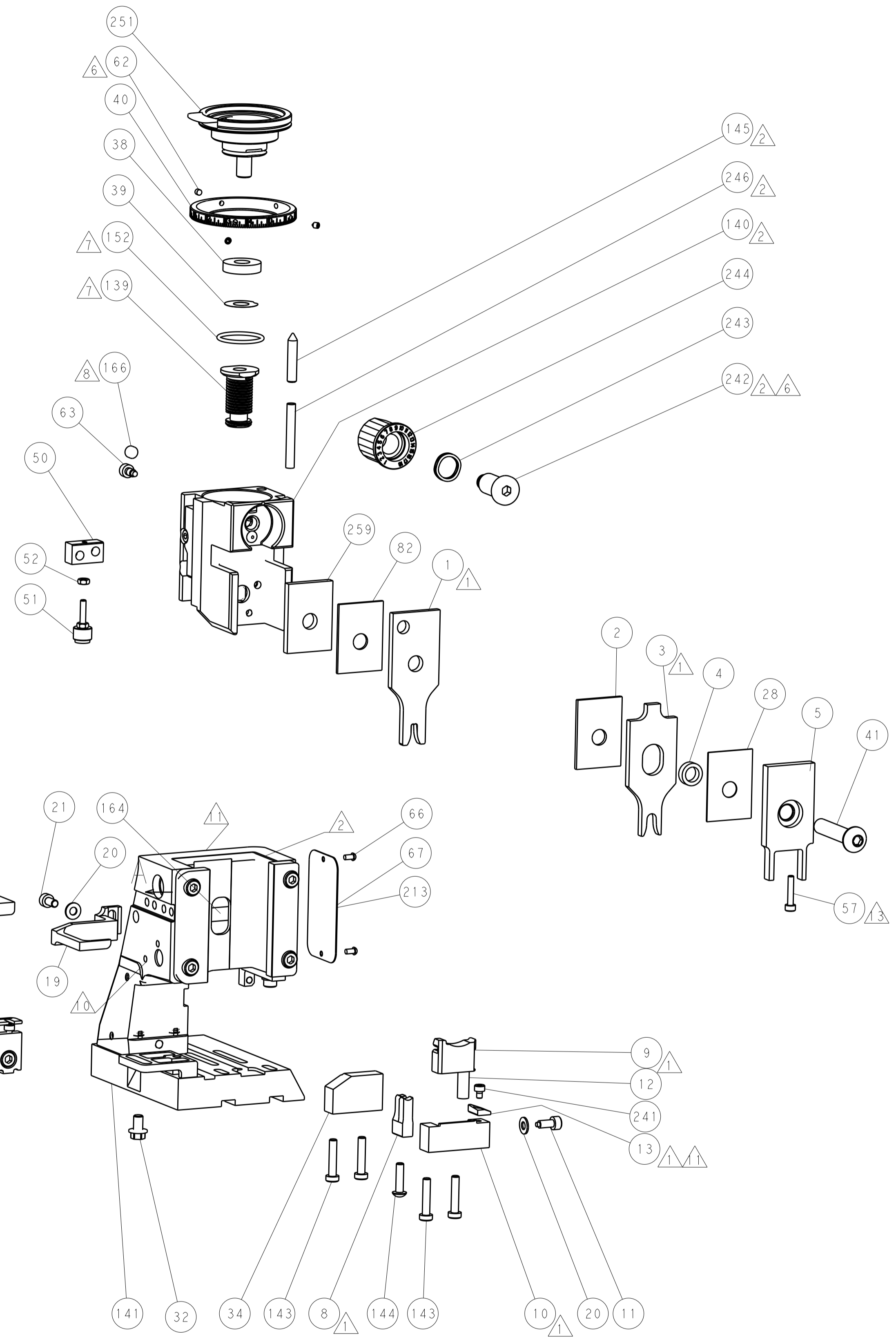
SERVO LATCH PLATE



CAM POSITION



AIR FEED



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

DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		DWN B. WEAVER 07OCT2017 CHK C. TOPPER 07OCT2017 APVD C. TOPPER 07OCT2017 PRODUCT SPEC APPLICATION SPEC WEIGHT CUSTOMER ACCESSIBLE PRODUCTION DRAWING		NAME Ocean Side Feed Applicator SIZE CAGE CODE DRAWING NO A1 00779 C=2836952 SCALE 1:2 SHEET 4 OF 4 REV B		RESTRICTED TO	
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