

| ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER | PART NUMBER | REVISION | DESCRIPTION | FEED TYPE | CONVERT TO | PART NUMBERS REQUIRED | | | | | |
|---|-------------|--------------------------|--------------------------|-------------------|-------------------|-----------------------|-----------|-------------|-----------|-----------|------------------------|
| | 2837314-1 | A | FINE CRIMP HEIGHT ADJUST | MECHANICAL | PNEUMATIC FEED | 2119950-1 | 1338683-8 | 5-18022-5 | 2119641-1 | 2119799-1 | 2063440-1 |
| | 2837314-2 | A | FINE CRIMP HEIGHT ADJUST | PNEUMATIC | SERVO LATCH PLATE | 2119951-1 | - | 8-2837314-5 | 1901094-3 | - | 2168400-6 (QUANTITY 2) |
| | | | | | SMART APPLICATOR | 2161326-1 | - | 8-2837314-4 | - | - | |
| | | | | | MECHANICAL FEED | 2119949-1 | 1338683-8 | 5-18022-5 | 2119653-1 | - | - |
| | 2837314-5 | A | FINE CRIMP HEIGHT ADJUST | SERVO LATCH PLATE | SERVO LATCH PLATE | 2119951-1 | - | 8-2837314-5 | 1901094-3 | - | 2168400-6 (QUANTITY 2) |
| | | | | | SMART APPLICATOR | 2161326-1 | - | 8-2837314-4 | - | - | |
| | 2837314-6 | A | NON-CRIMP HEIGHT ADJUST | SERVO LATCH PLATE | MECHANICAL FEED | 2119949-1 | 1338683-8 | 5-18022-5 | 2119653-1 | - | - |
| PNEUMATIC FEED | | | | | 2119950-1 | 1338683-8 | 5-18022-5 | 2119641-1 | 2119799-1 | 2063440-1 | |
| 2837314-7 | A | FINE CRIMP HEIGHT ADJUST | NONE | - | - | - | - | - | - | - | |
| 7-2837314-7 | A | CRIMP TOOLING KIT | - | - | - | - | - | - | - | - | |

| APPLICATOR DATA | | |
|-----------------|----------------|------|
| CRIMP | SIZE | TYPE |
| WIRE | 2.03 mm [.080] | F |
| INSUL | 3.30 mm [.130] | F |

APPLICATOR INSTRUCTIONS
408-10389

| TERMINAL DATA: THB TERMINAL | TE CRIMP SPECIFICATION |
|--|---|
| TERMINAL NAME: TERMINAL | |
| WIRE STRIP LENGTH 3.43-4.19 mm [.135-.165 IN] | TERMINAL INSULATION DIAMETER RANGE 1.60-2.54 mm [.063-.100 IN] |
| TERMINAL APPLICATION SPECIFICATION NONE | |
| TERMINALS APPLIED | |
| TE TERMINAL | THB TERMINAL |
| 3311237-1 | PP0137001 |

| WIRE SIZE | CRIMP HEIGHT mm [INCH] | CRIMP HEIGHT REFERENCE SETTING |
|---------------------|-------------------------------|--------------------------------|
| 0.50mm ² | 1.36 +/- 0.05 [.054 +/- .002] | 3.6 |

- 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: 8-2837314-4
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2837314-4
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2837314-5
 SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2837314-6
- 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. FOR -6 ONLY APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 37.
- GREASE THREADS, GROOVE AND O-RING ON ITEMS 35 & 252.
- MAGNET, ITEM 166 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 THE BACK SIDE OF THE HOUSING. REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.
- WHEN ASSEMBLING A NON CRIMP HEIGHT ADJUST APPLICATOR (-6) USE SHIMS FROM ITEM 260 TO ACHIEVE A NOMINAL SHIM HEIGHT OF 4.53.
- 13. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT 101-35000.
- 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.

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 | DIST 66 | REVISIONS | | | | | |
| | | | R | LTN | DESCRIPTION | DATE | DWN | APVD |
| | | | 1 | | DEVELOPMENT | 22JUN2018 | TB | TE |
| | | | A | | RELEASE | 19JUL2018 | AW | GB |

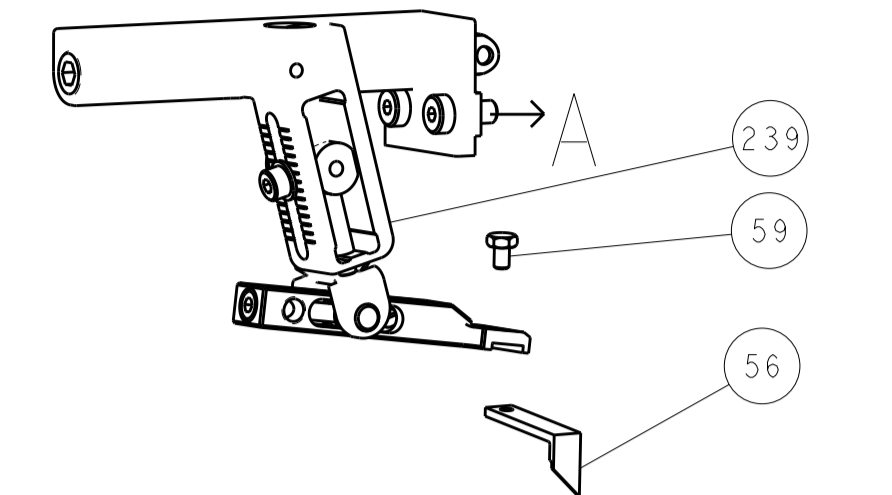
| P | LTN | DESCRIPTION | DATE | DWN | APVD |
|---|-----|-----------------|-------------|-----|------|
| - | - | 1 - - - - | 2119957-2 | | 260 |
| - | 1 | - 1 1 1 | 8-21084-0 | | 252 |
| - | - | - - - 1 | 2119640-1 | | 250 |
| - | - | - - - 1 | 1803259-1 | | 249 |
| - | - | - - - 1 | 2119641-1 | | 248 |
| - | 1 | - 1 1 1 | 2119798-1 | | 247 |
| - | 1 | - 1 1 1 | 1-22279-3 | | 246 |
| - | - | 1 - - - | 2119758-1 | | 245 |
| - | 1 | 1 1 1 1 | 2119082-3 | | 244 |
| - | 1 | 1 1 1 1 | 2079764-1 | | 243 |
| - | 1 | 1 1 1 1 | 2119083-1 | | 242 |
| - | 1 | 1 1 1 1 | 7-18023-7 | | 241 |
| - | - | 2 2 - - | 2168400-6 | | 240 |
| - | - | - - - 1 | 2119580-1 | | 239 |
| - | - | - - - 1 | 2063440-1 | | 238 |
| - | - | 1 1 - - | 2119740-2 | | 213 |
| - | - | - 1 1 - | 1901094-3 | | 198 |
| - | - | - - - 2 | 21045-3 | | 172 |
| - | 1 | 1 1 1 1 | 994969-1 | | 166 |
| - | REF | REF REF REF REF | 994970-2 | | 164 |
| - | - | - - - 1 | 240638-1 | | 163 |
| - | - | - - - 1 | 3-23627-7 | | 137 |
| - | - | - - - 1 | 2119799-1 | | 136 |
| - | - | REF REF - - | SEE NOTE 4 | | 135 |
| - | - | 1 1 - - | 1633743-1 | | 133 |
| - | - | REF REF - - | 2119944-1 | | 117 |
| - | 1 | 1 1 1 1 | 2119955-1 | | 113 |
| - | 1 | 1 1 1 1 | 455888-4 | | 82 |
| - | 1 | 1 1 1 1 | 2119956-1 | | 71 |
| - | 1 | - - - 1 | 2119740-1 | | 67 |
| - | 2 | 2 2 2 2 | 2168078-1 | | 66 |
| - | 1 | - - - 1 | 2119793-1 | | 63 |
| - | 3 | - - - 3 | 992763-5 | | 62 |
| - | 1 | 1 1 1 1 | 2079383-4 | | 60 |
| - | - | - - - 1 | 5-18022-5 | | 59 |
| - | - | - - - 1 | 1338683-8 | | 56 |
| - | 4 | 4 4 4 4 | 2168400-1 | | 54 |
| - | 2 | 2 2 2 2 | 1-2168083-0 | | 53 |
| - | 1 | 1 1 1 1 | 1803382-6 | | 50 |
| - | - | - - - 1 | 18023-9 | | 49 |
| - | - | - - - - | 2119652-1 | | 48 |
| - | - | - - - - | 2119653-1 | | 47 |
| - | 1 | 1 1 1 1 | 2119656-9 | | 46 |
| - | 1 | - - - 1 | 2119370-1 | | 44 |
| - | 1 | 1 1 1 1 | 2079383-7 | | 41 |
| - | 1 | - - - 1 | 2119645-1 | | 40 |
| - | 1 | - - - 1 | 2119957-1 | | 39 |
| - | 1 | 1 1 1 1 | 2119644-1 | | 38 |
| - | 1 | 1 1 1 1 | 2119085-1 | | 37 |
| - | 1 | - - - 1 | 2119092-1 | | 35 |
| - | 1 | 1 1 1 1 | 1752356-1 | | 34 |
| - | 2 | 2 2 2 2 | 2079383-5 | | 33 |
| - | 1 | 1 1 1 1 | 2161328-1 | | 32 |
| - | 1 | 1 1 1 1 | 1-1320908-0 | | 30 |
| - | 1 | 1 1 1 1 | 2119959-1 | | 29 |
| - | 1 | 1 1 1 1 | 1-455888-0 | | 28 |
| - | 1 | 1 1 1 1 | 1320928-2 | | 24 |
| - | 1 | 1 1 1 1 | 2168083-2 | | 21 |
| - | 2 | 2 2 2 2 | 1-18028-2 | | 20 |
| - | 1 | 1 1 1 1 | 2119533-1 | | 19 |
| - | 1 | 1 1 1 1 | 2119806-1 | | 13 |
| - | 1 | 1 1 1 1 | 3-22280-3 | | 12 |
| - | 1 | 1 1 1 1 | 1-356885-3 | | 11 |
| - | 1 | 1 1 1 1 | 2119805-1 | | 10 |
| - | 1 | 1 1 1 1 | 1803095-1 | | 9 |
| 1 | 1 | 1 1 1 1 | 1-1803608-8 | | 8 |
| - | - | - - - - | - | | 7 |
| - | - | - - - - | - | | 6 |
| - | 1 | 1 1 1 1 | 2119757-4 | | 5 |
| - | 1 | 1 1 1 1 | 2-238011-1 | | 4 |
| 1 | 1 | 1 1 1 1 | 1-1803017-6 | | 3 |
| - | 1 | 1 1 1 1 | 455888-6 | | 2 |
| 1 | 1 | 1 1 1 1 | 1-456405-8 | | 1 |

| | | | | |
|---|--|---|---|------------------------------------|
| THIS DRAWING IS UNPUBLISHED. RELEASING OR PUBLISHING THIS INFORMATION WITHOUT THE WRITTEN PERMISSION OF TYCO ELECTRONICS CORPORATION IS PROHIBITED. | | DWN T. BROOKENS CHK M. HERR APVD T. ELBIN 22JUN2018 22JUN2018 | DATE 22JUN2018 22JUN2018 22JUN2018 | NAME Ocean Side Feed Applicator |
| DIMENSIONS: mm | | TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±, 1 PLC ±, 2 PLC ±, 3 PLC ±, 4 PLC ±, ANGLES ±. | | RESTRICTED TO |
| MATERIAL: | | FINISH: | | WEIGHT: |
| CUSTOMER ACCESSIBLE PRODUCTION DRAWING | | SCALE: 1:2 | SHEET: 1 OF 4 | REV: A |

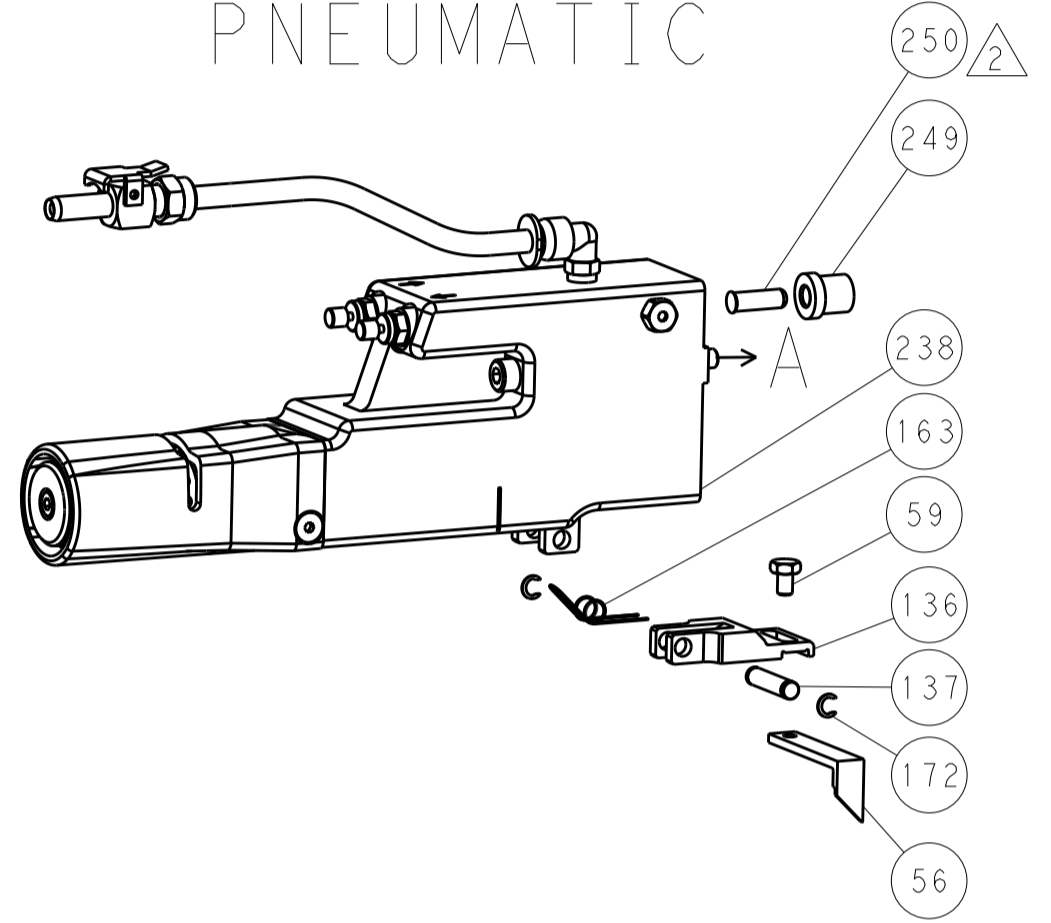
SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

| LOC | DIST | REV | DATE | BY | APP'D |
|-----|------|-----|------|----|-------|
| A | 66 | | | | |
| | | | | | |
| | | | | | |

FEED TYPE MECHANICAL



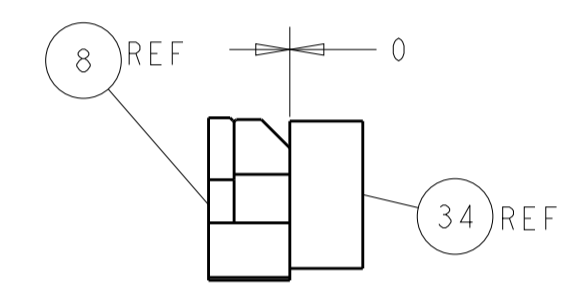
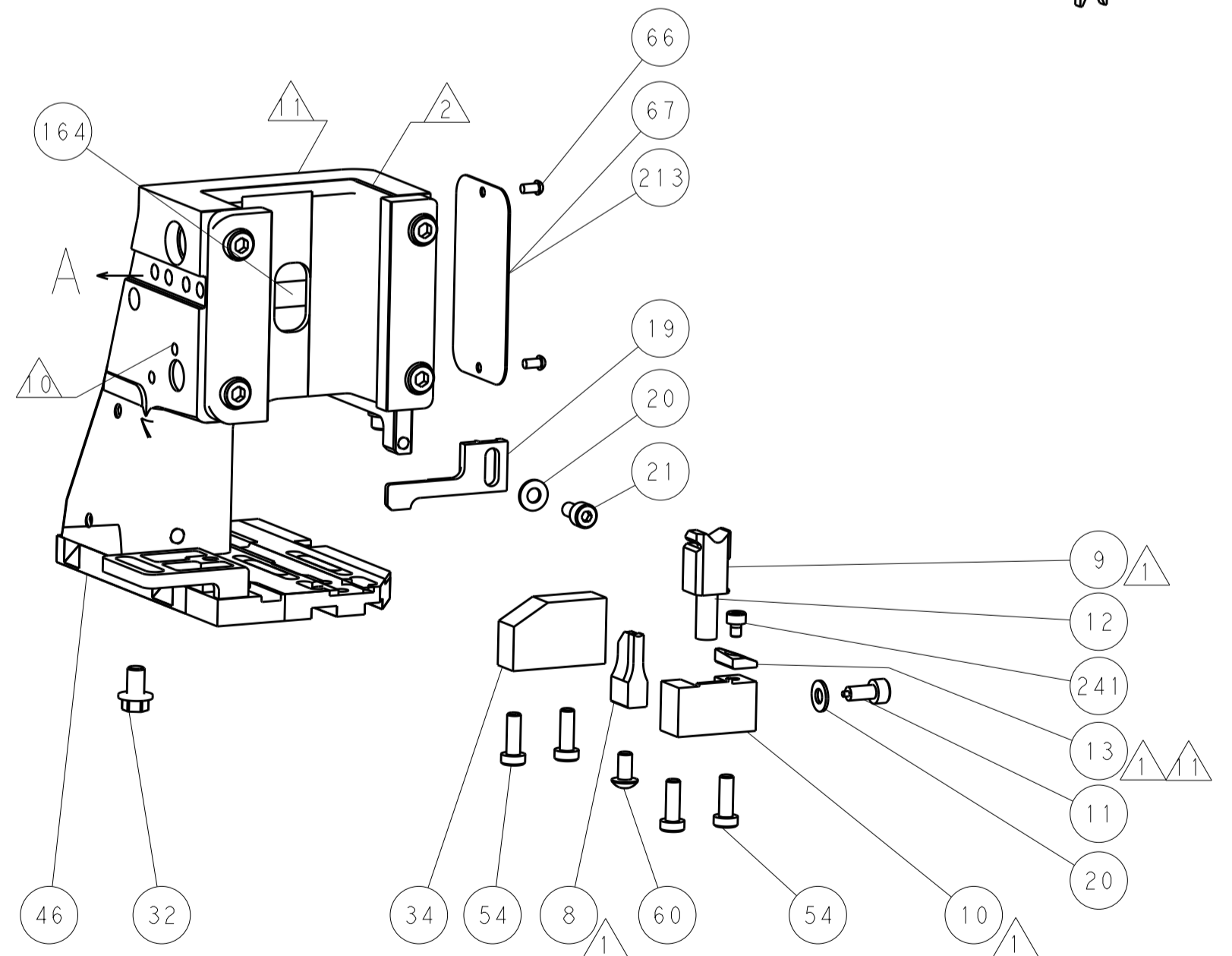
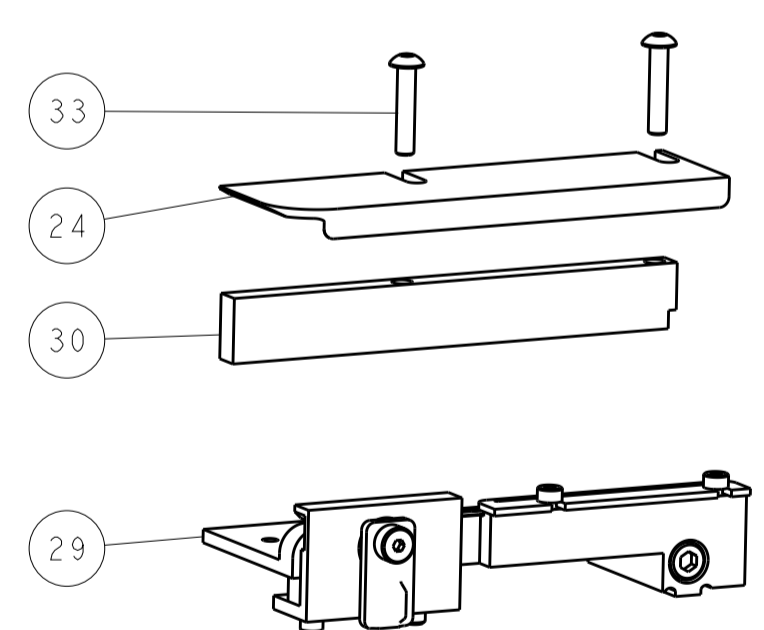
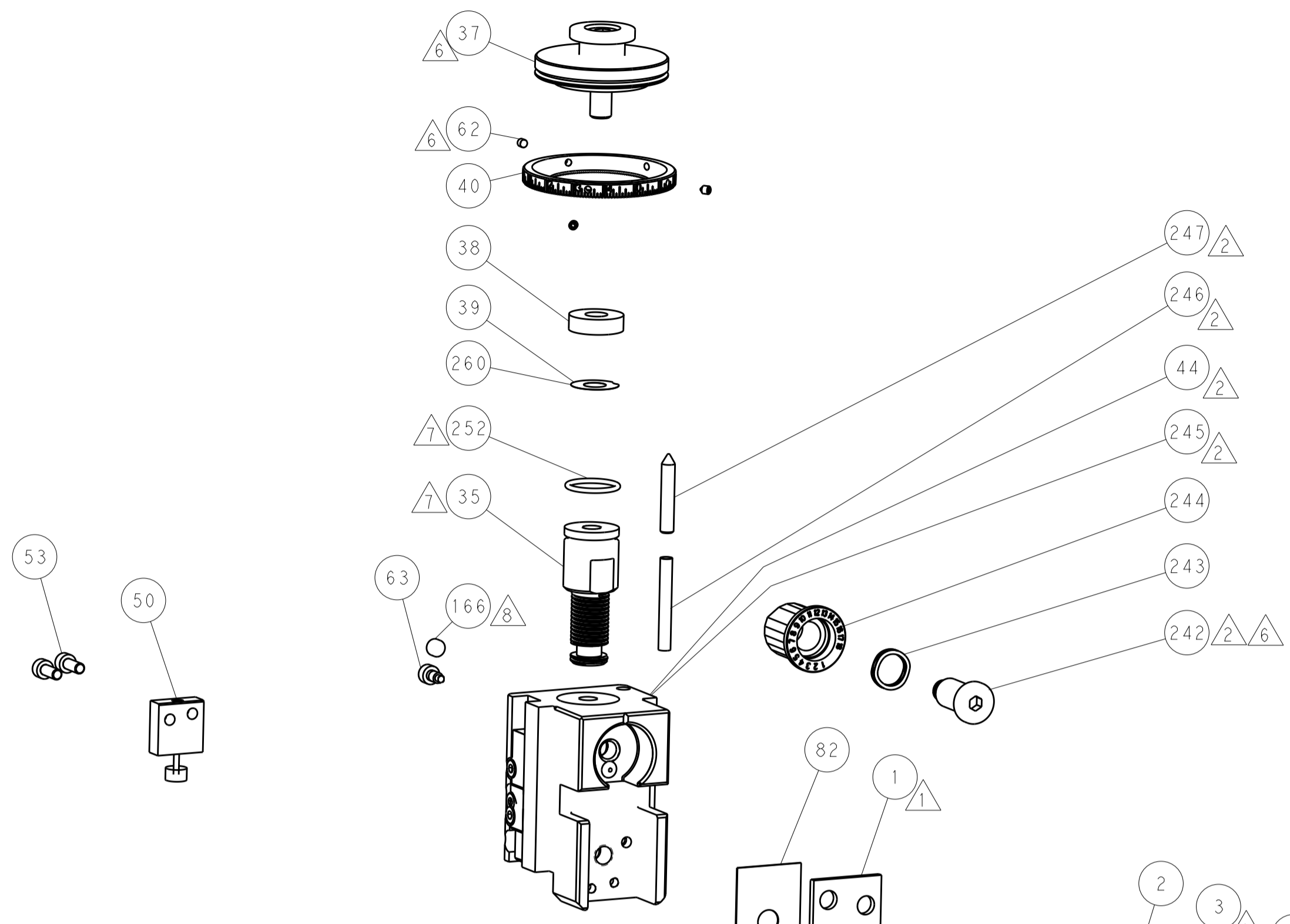
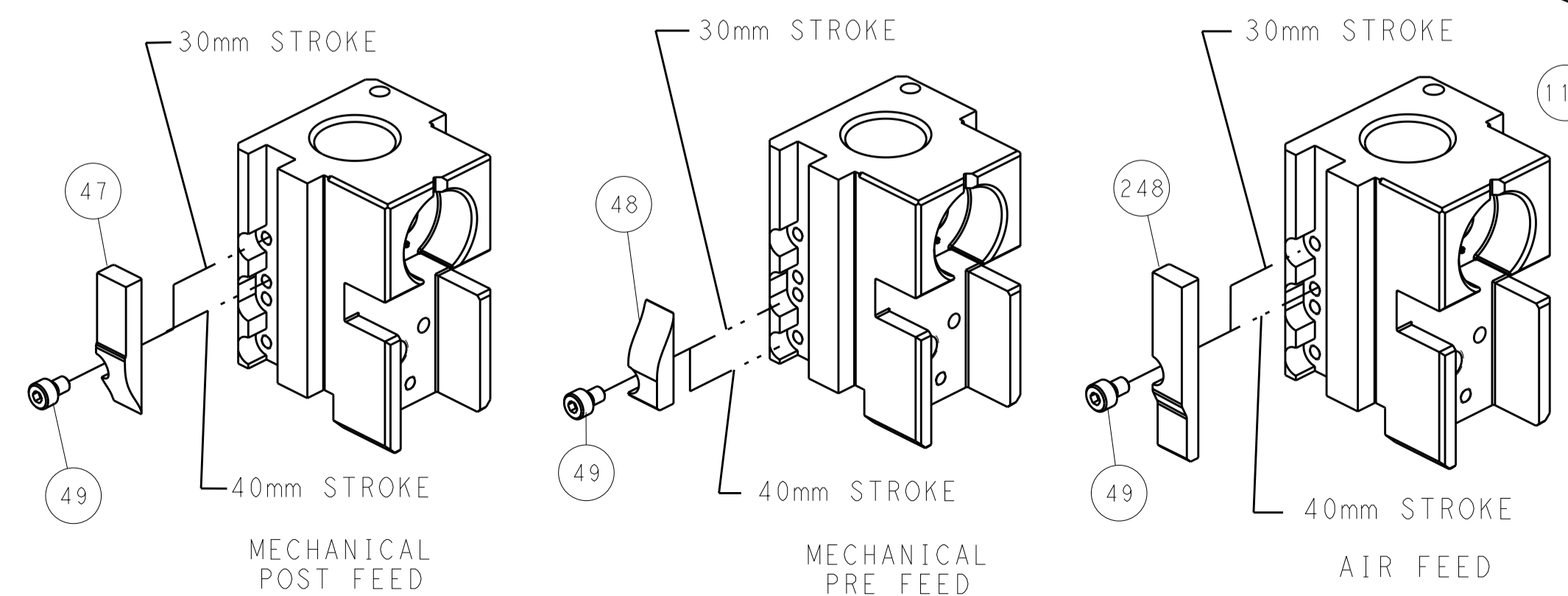
PNEUMATIC



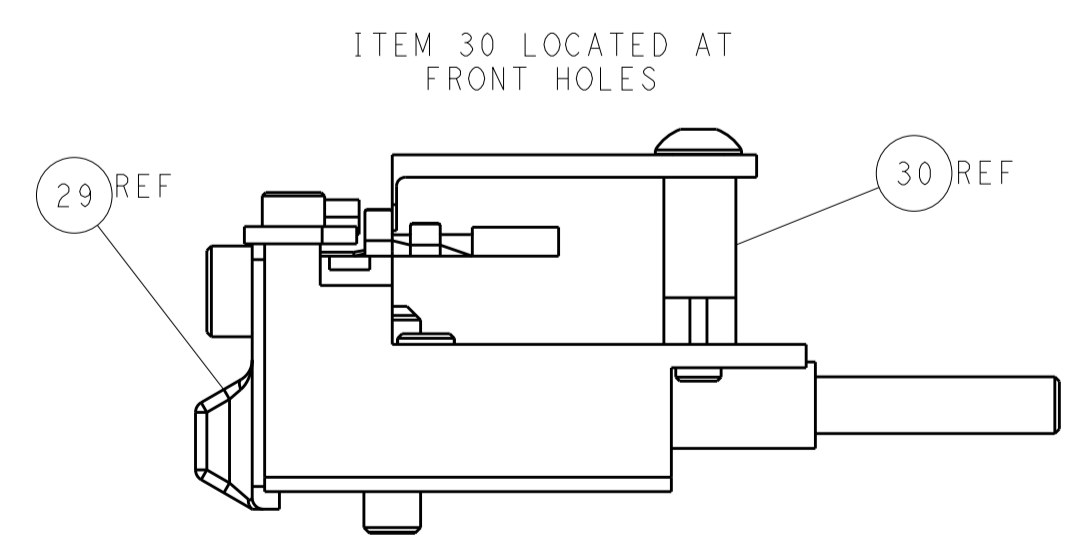
SERVO LATCH PLATE



CAM POSITIONS



TERMINAL SUPPORT LOCATION



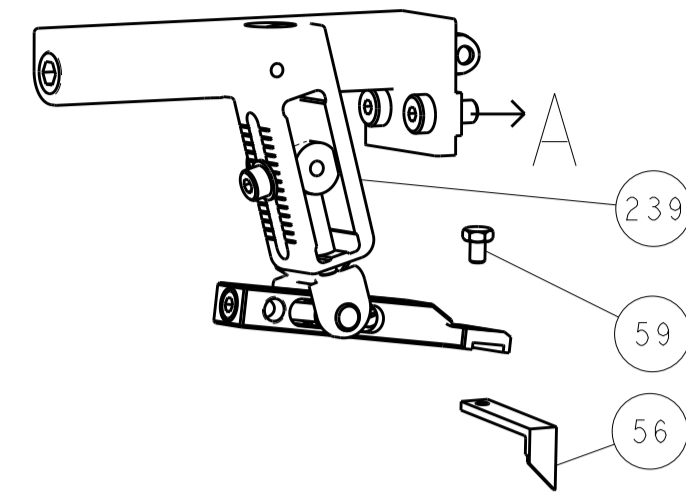
ITEM 30 LOCATED AT FRONT HOLES

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

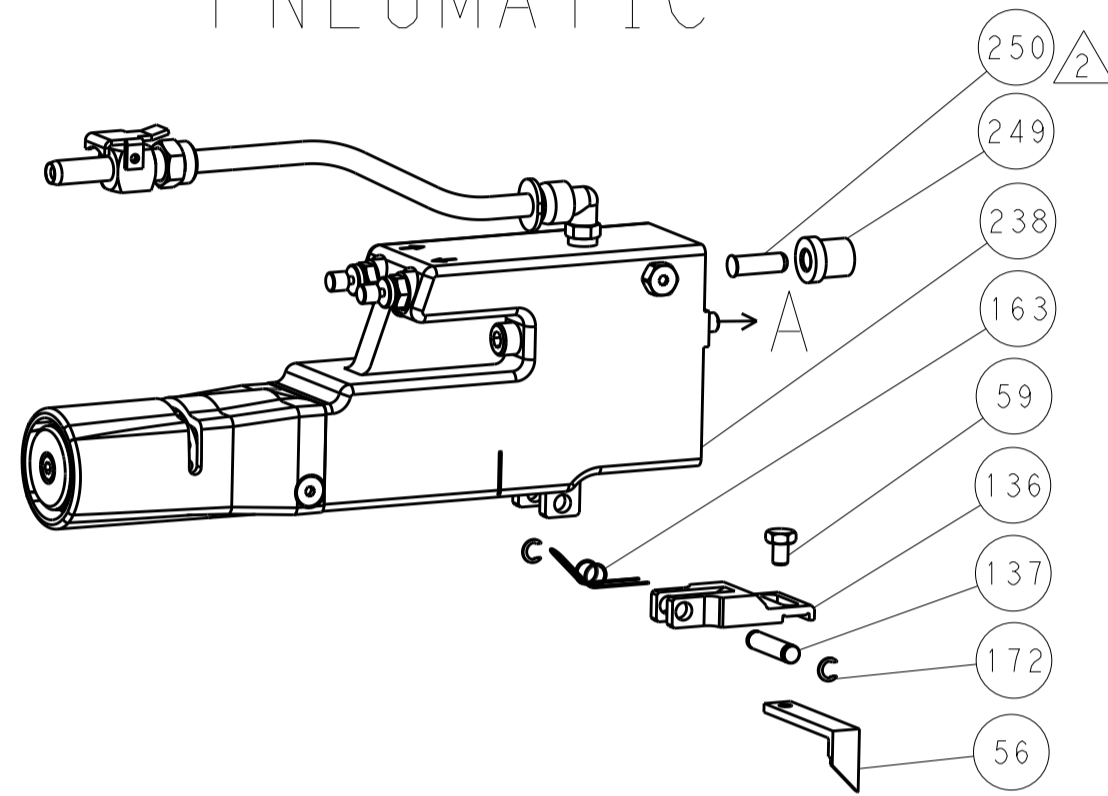
| | | | | | | | |
|--|--|--|--|---|--|---|--|
| DIMENSIONS: mm | | TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 3 PLC ± 4 PLC ± ANGLES ± | | DWN T. BROOKS 22JUN2018 CHK M. HERR 22JUN2018 APVD T. ELBIN 22JUN2018 | | NAME Ocean Side Feed Applicator | |
| MATERIAL: | | FINISH: | | WEIGHT: | | SIZE CAGE CODE DRAWING NO A1 00779 C=2837314 | |
| Customer Accessible Production Drawing | | | | SCALE 1:2 | | SHEET 2 OF 4 REV A | |

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

FEED TYPE MECHANICAL



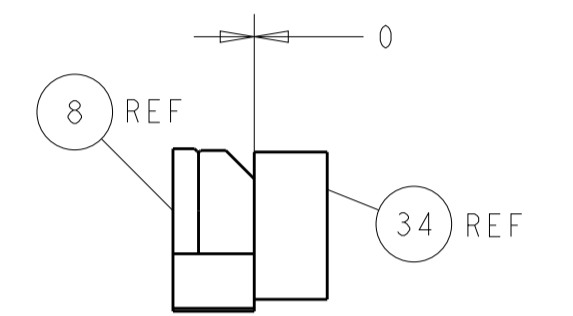
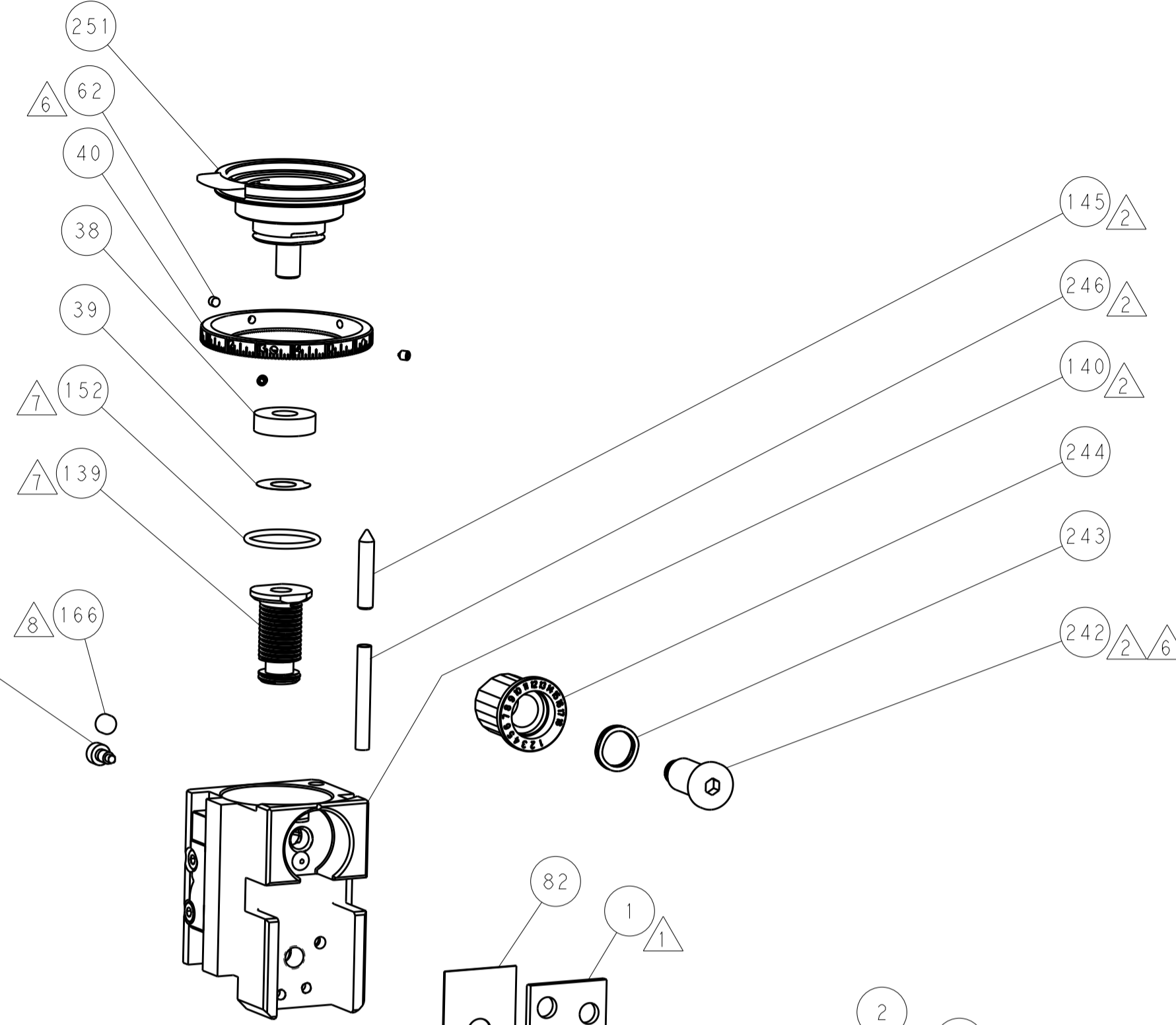
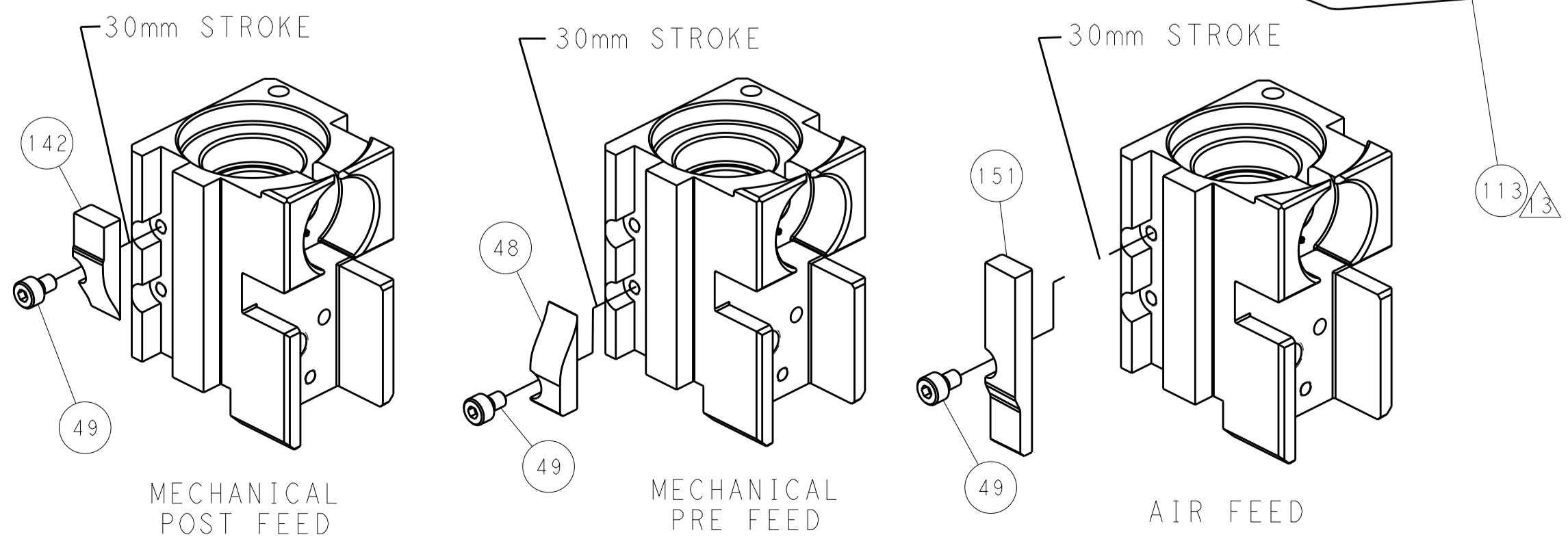
PNEUMATIC



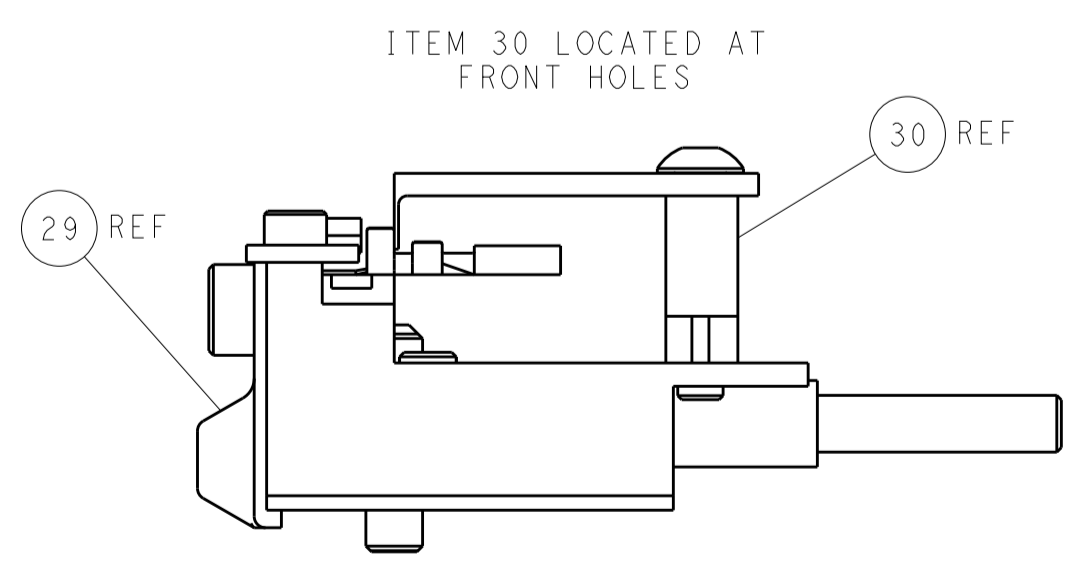
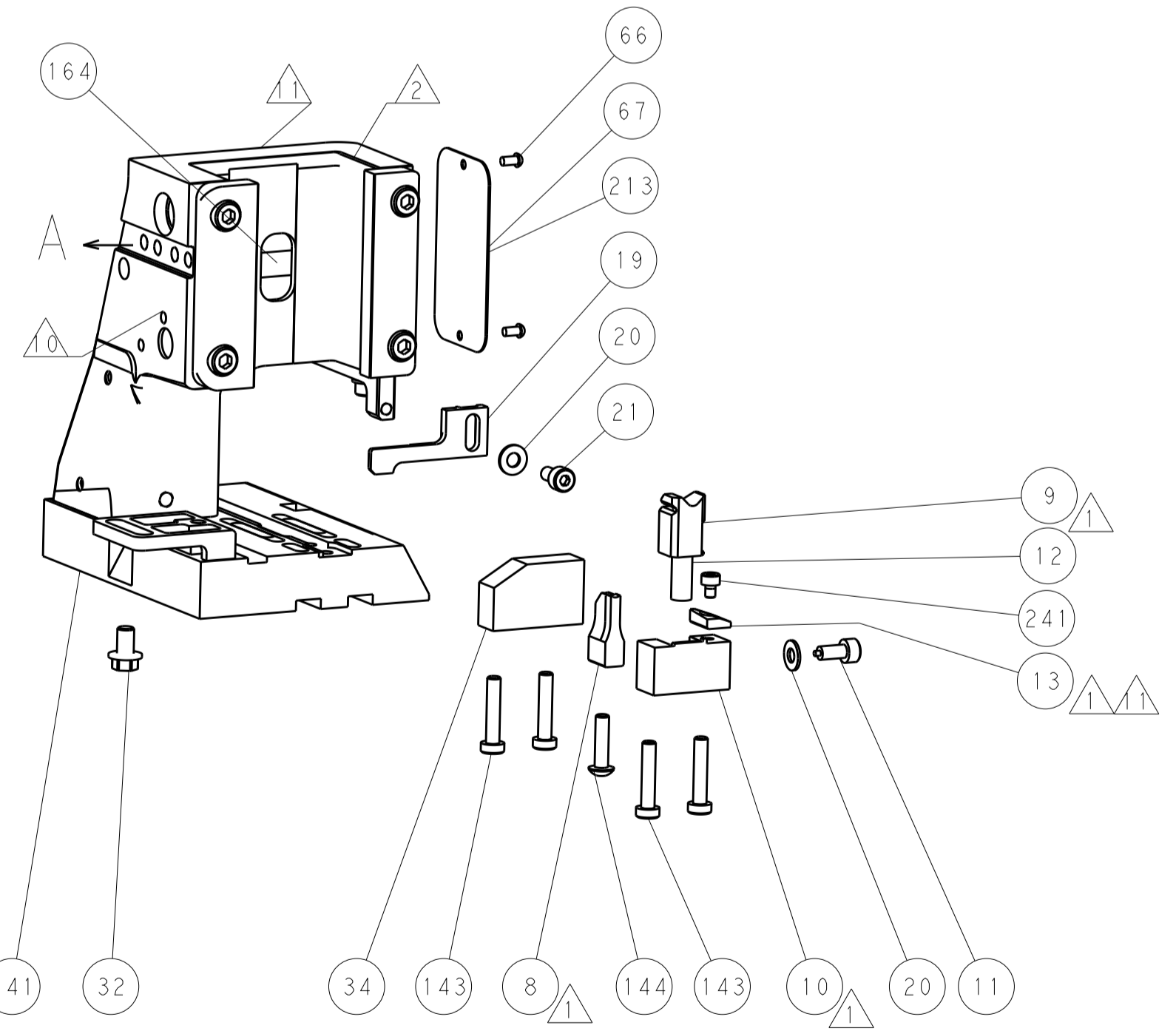
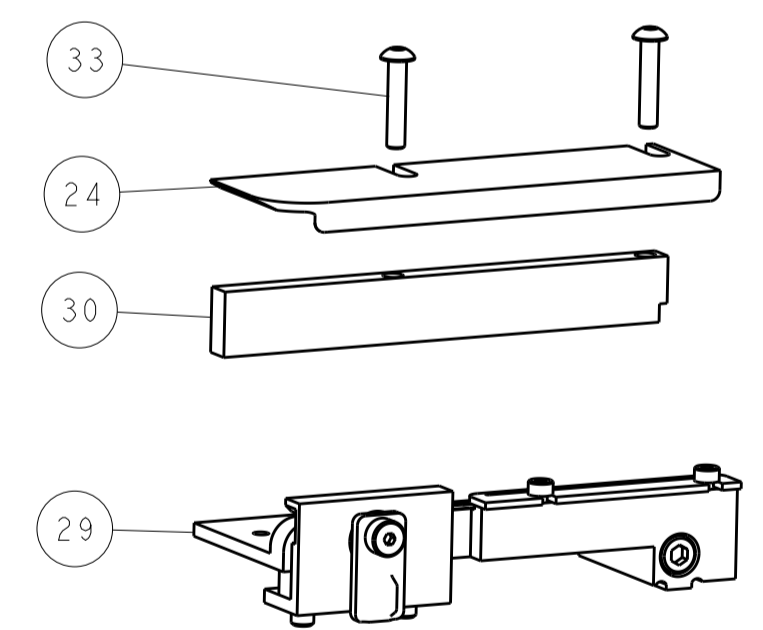
SERVO LATCH PLATE



CAM POSITIONS



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)

| | | | | | | | |
|-------------|---------|--|---------|---------------------------|---------|--|---------------------------|
| DIMENSIONS: | | TOLERANCES UNLESS OTHERWISE SPECIFIED: | | DWN T. BROOKENS 22JUN2018 | | STE TE Connectivity | |
| mm | 0 PLC ± | 1 PLC ± | 2 PLC ± | 3 PLC ± | 4 PLC ± | NAME | Harrisburg, PA 17105-3608 |
| | ANGLES | FINISH | | APVD M. HERR 22JUN2018 | | PRODUCT SPEC | |
| MATERIAL | | | | APVD T. ELBIN 22JUN2018 | | APPLICATION SPEC | |
| | | | | WEIGHT | | SIZE | RESTRICTED TO |
| | | | | | | CAGE CODE DRAWING NO | |
| | | | | | | 00779 | |
| | | | | | | ©=2837314 | |
| | | | | | | Customer Accessible Production Drawing | |
| | | | | | | SCALE | |
| | | | | | | 1:2 | |
| | | | | | | SHEET | |
| | | | | | | 4 | |
| | | | | | | OF 4 | |
| | | | | | | REV | |
| | | | | | | A | |