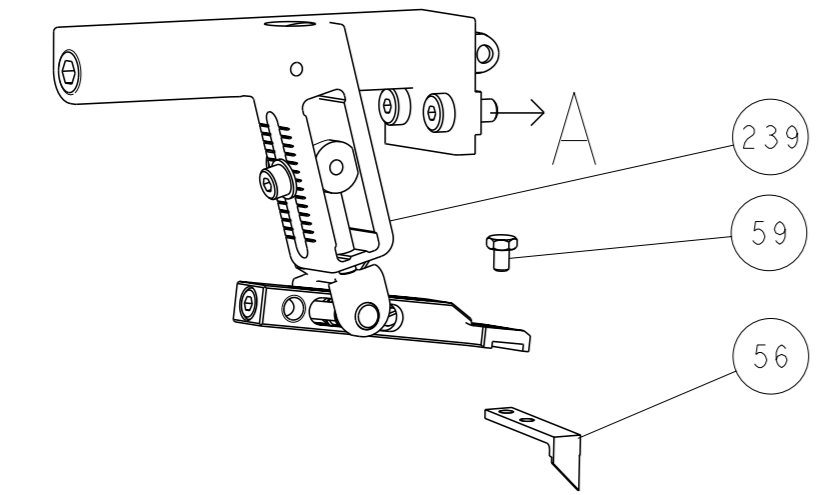


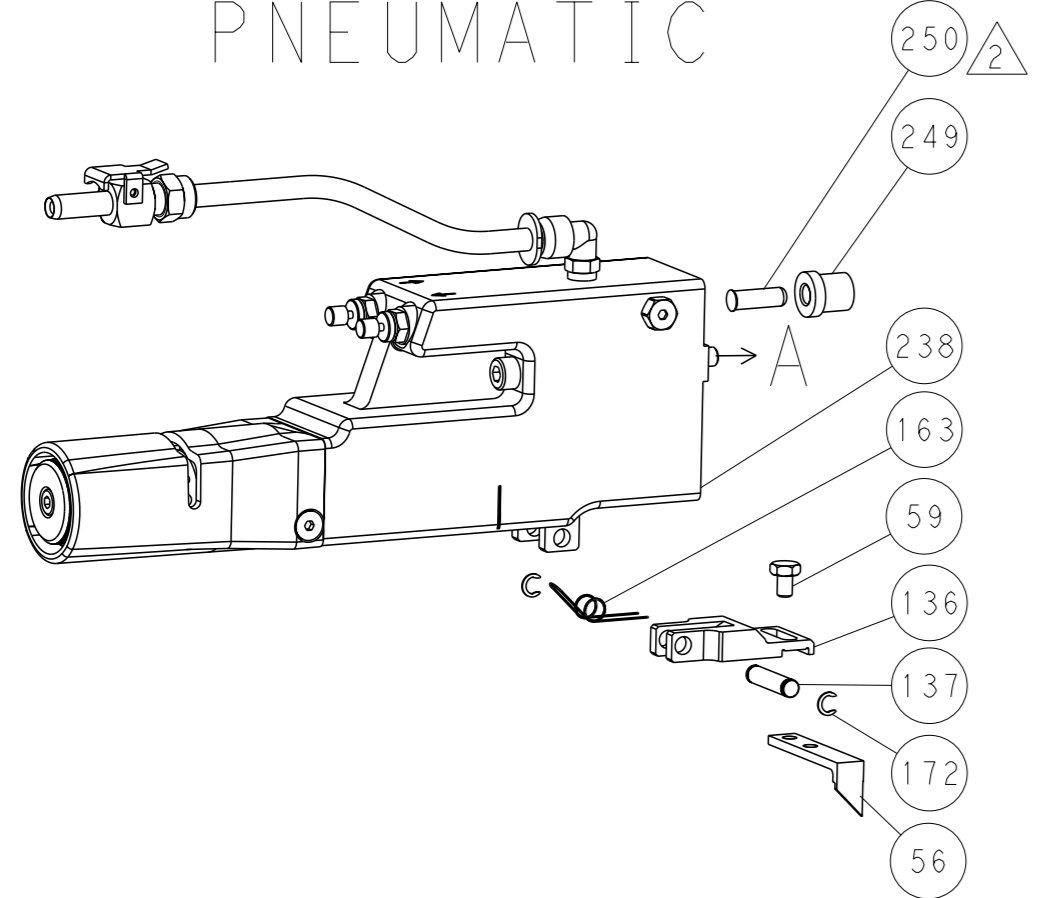


| LOC | DIST | REVISIONS   |      |     |      |
|-----|------|-------------|------|-----|------|
| A   | 66   | REV         | DATE | OWN | APVD |
| -   | -    | SEE SHEET 1 | -    | -   | -    |

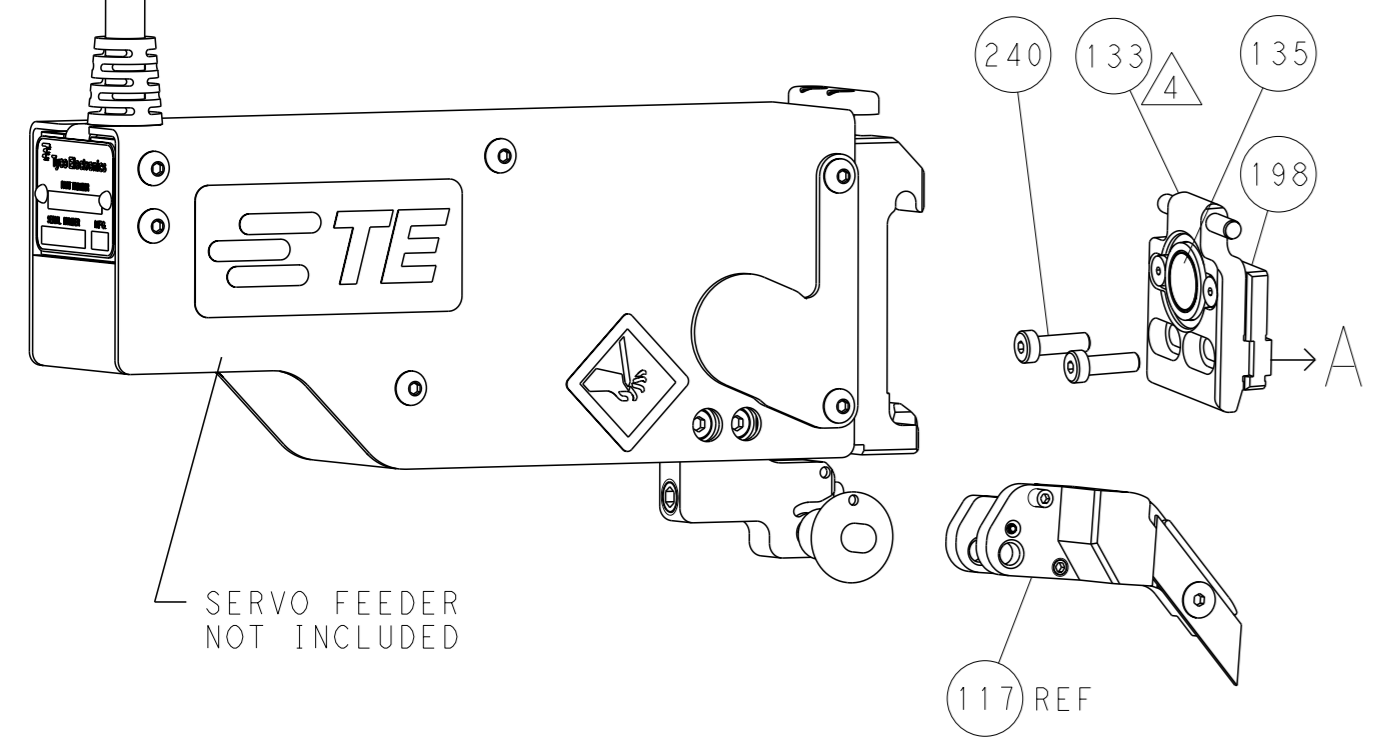
### FEED TYPE MECHANICAL



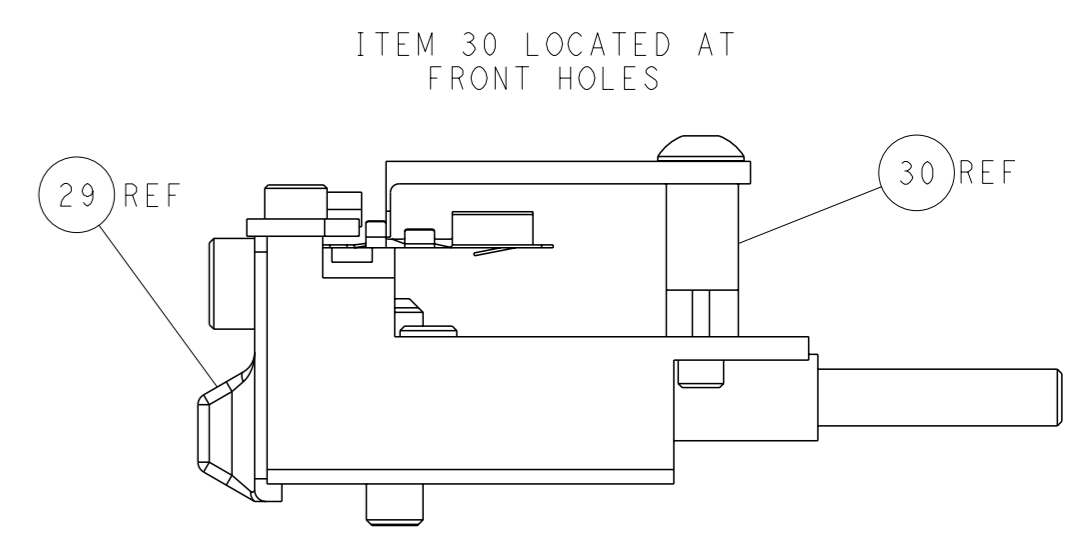
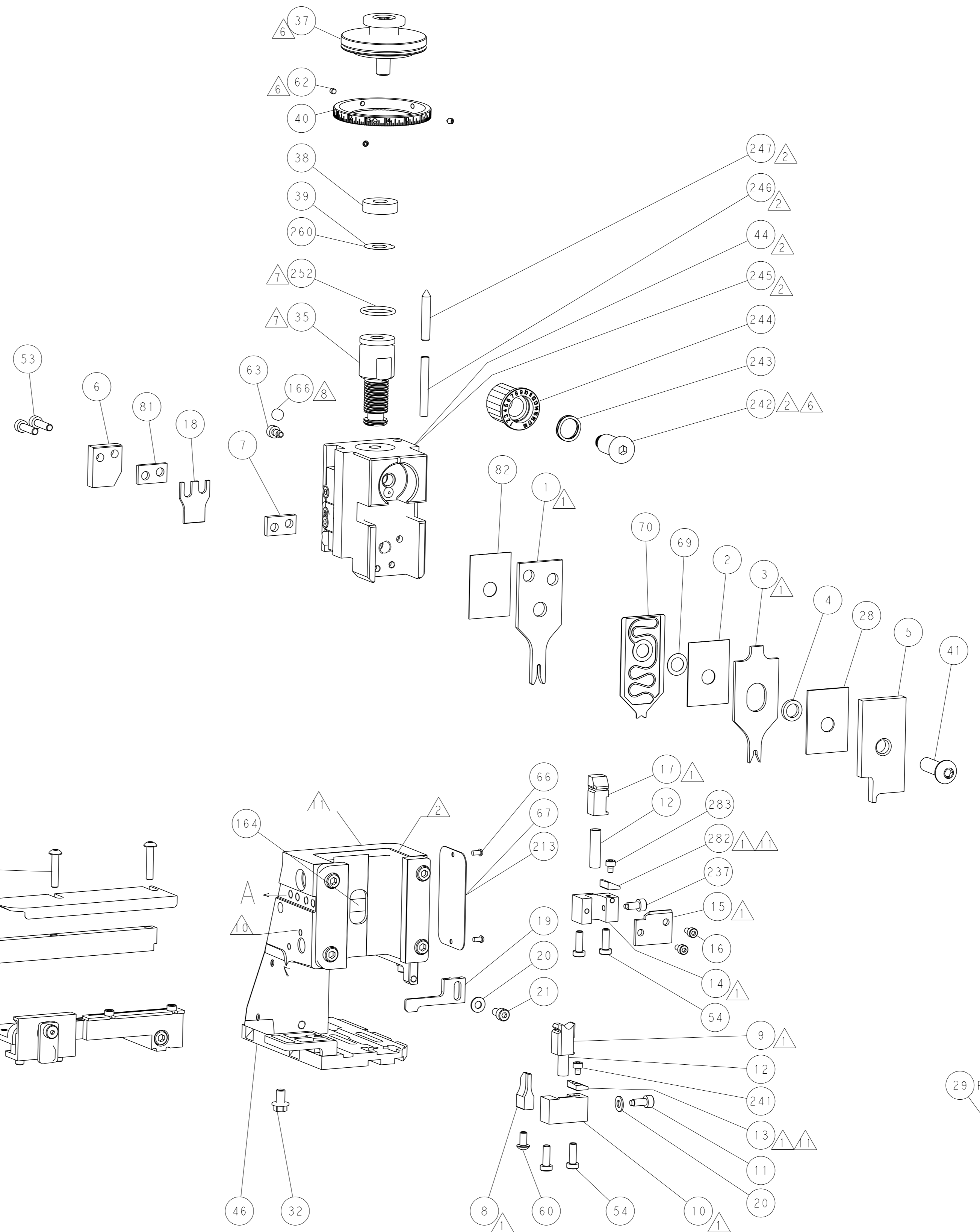
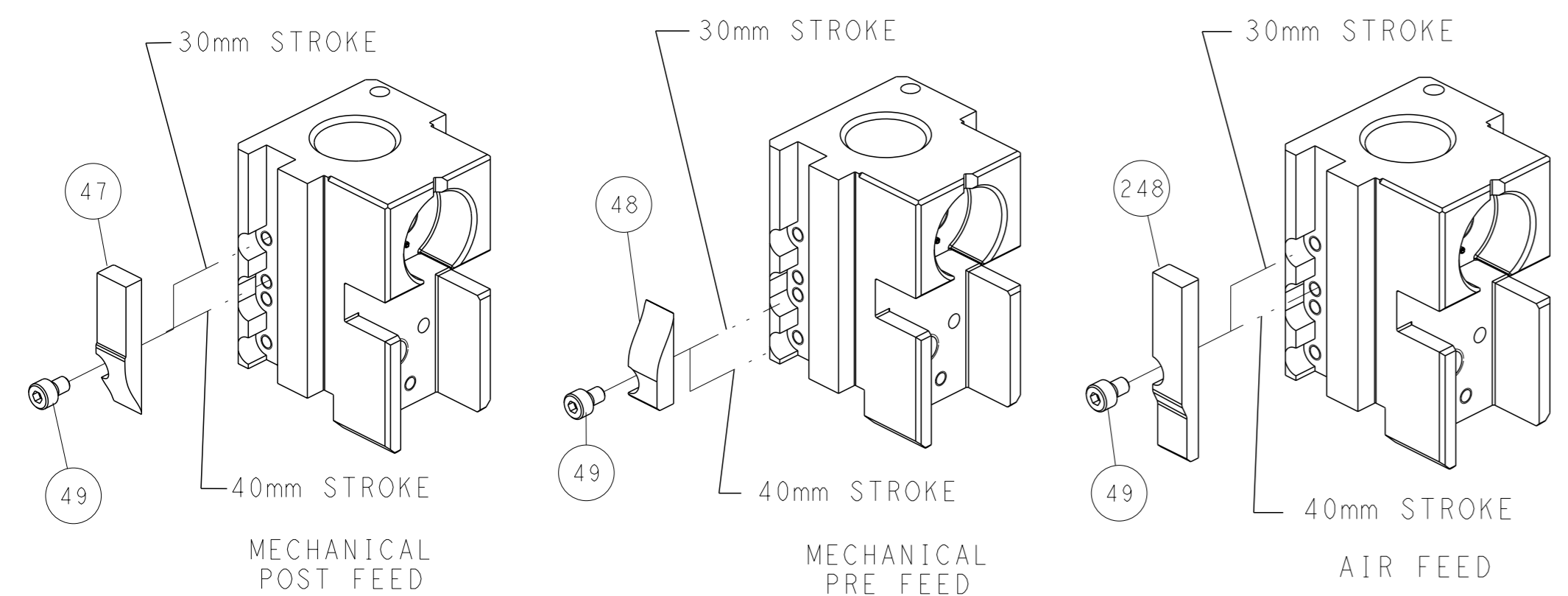
### PNEUMATIC



### SERVO LATCH PLATE



### CAM POSITIONS



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

|  |  |   |   |
|--|--|---|---|
| <small>THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE AND THE USER MUST CONSULT THE LATEST REVISION. SHOULD BE CONTACTED FOR THE LATEST REVISION.</small> |  | OWN: M. HERR 17SEPT2018<br>CHK: T. ELBIN 17SEPT2018<br>APVD: B. BAIR 17SEPT2018           | TE Connectivity<br>Harrisburg, PA 17105-3608              |
| DIMENSIONS: mm<br>TOLERANCES UNLESS OTHERWISE SPECIFIED:<br>0 PLC ±<br>1 PLC ±<br>2 PLC ±<br>3 PLC ±<br>4 PLC ±<br>ANGLES FINISH ±   |  | NAME: Ocean Side Feed Applicator<br>SIZE: A1<br>CAGE CODE: 00779<br>DRAWING NO: C=2837440 | RESTRICTED TO: -<br>SCALE: 1:2<br>SHEET: 2 of 4<br>REV: A |
| MATERIAL: -<br>FINISH: -   |  | WEIGHT: -<br>Customer Accessible Production Drawing                                       | SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION        |

| PACIFIC VERSION TERMINATOR INTERFACE ADAPTER | PART NUMBER | REVISION | DESCRIPTION              | FEED TYPE                      | APPLICATOR STYLE CONVERSION CHART |                       |           |             |           |           |                        |
|--|-------------|----------|--------------------------|--------------------------------|-----------------------------------|-----------------------|-----------|-------------|-----------|-----------|------------------------|
|  |             |          |                          |                                | CONVERT TO                        | PART NUMBERS REQUIRED |           |             |           |           |                        |
|  | 2-2837440-1 | A        | FINE CRIMP HEIGHT ADJUST | MECHANICAL                     | PNEUMATIC FEED                    | 2119950-1             | 1338685-1 | 5-18022-5   | 2119641-2 | 2119799-1 | 2063440-1              |
|  |             |          |                          |                                | SERVO LATCH PLATE                 | 2119951-1             | -         | 8-2837440-5 | 1901094-3 | -         | 2168400-6 (QUANTITY 2) |
|  |             |          |                          |                                | SMART APPLICATOR                  | 2161326-1             | -         | 8-2837440-4 | -         | -         | -                      |
|  | 2-2837440-2 | A        | FINE CRIMP HEIGHT ADJUST | PNEUMATIC                      | MECHANICAL FEED                   | 2119949-1             | 1338685-1 | 5-18022-5   | 2119653-2 | -         | -                      |
|  |             |          |                          |                                | SERVO LATCH PLATE                 | 2119951-1             | -         | 8-2837440-5 | 1901094-3 | -         | 2168400-6 (QUANTITY 2) |
|  |             |          |                          |                                | SMART APPLICATOR                  | 2161326-1             | -         | 8-2837440-4 | -         | -         | -                      |
|  | 2-2837440-5 | A        | FINE CRIMP HEIGHT ADJUST | SERVO LATCH PLATE <sup>4</sup> | MECHANICAL FEED                   | 2119949-1             | 1338685-1 | 5-18022-5   | 2119653-2 | -         | -                      |
|  |             |          |                          |                                | PNEUMATIC FEED                    | 2119950-1             | 1338685-1 | 5-18022-5   | 2119641-2 | 2119799-1 | 2063440-1              |
|  | 2-2837440-7 | A        | FINE CRIMP HEIGHT ADJUST | NONE                           | -                                 | -                     | -         | -           | -         | -         | -                      |
|  | 7-2837440-7 | A        | CRIMP TOOLING KIT        | -                              | -                                 | -                     | -         | -           | -         | -         | -                      |

| APPLICATOR DATA                   |                |      |
|-----------------------------------|----------------|------|
| CRIMP                             | SIZE           | TYPE |
| WIRE                              | 1.40 mm (.055) | F    |
| INSUL                             | 2.29 mm (.090) | F    |
| APPLICATOR INSTRUCTIONS 408-10389 |                |      |

| TERMINAL DATA: TE TERMINAL                   |             | TE CRIMP SPECIFICATION             |             |
|--|-------------|------------------------------------|-------------|
| TERMINAL NAME: CONTACT, MOD I, HIGH PRESSURE |             |                                    |             |
| WIRE STRIP LENGTH                            |             | TERMINAL INSULATION DIAMETER RANGE |             |
| 3.35-4.17 mm (.132-.164 IN)                  |             | Ø1.07-1.85 mm (.042-.073 IN)       |             |
| TERMINAL APPLICATION SPECIFICATION           | 114-25000   | -                                  | -           |
| TERMINALS APPLIED                            |             |                                    |             |
| TE TERMINAL                                  | TE TERMINAL | TE TERMINAL                        | TE TERMINAL |
| 102102-2                                     | 102102-5    |                                    |             |

| WIRE SIZE | CRIMP HEIGHT mm [INCH]     | CRIMP HEIGHT REFERENCE SETTING |
|-----------|----------------------------|--------------------------------|
| 22 AWG    | 0.97+/-0.05 [.038+/-0.002] | 7.7                            |
| 24 AWG    | 0.84+/-0.05 [.033+/-0.002] | 9.2                            |
| 26 AWG    | 0.84+/-0.05 [.033+/-0.002] | 8.8                            |

- RECOMMENDED SPARE PARTS
- 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: 8-2837440-4  
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2837440-4  
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2837440-5
- 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 ITEM 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. 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 BACK SIDE OF THE HOUSING. REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.
- 12. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT 101-35000.

**\*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   | 7-18023-7 | SCR, SKT HD CAP M3 X 4.0            | 283     |
| -   | 1   | 1   | 1   | 1   | 2280441-1 | INSERT, SHEAR                       | 282     |
| -   | 1   | 1   | 1   | 1   | 2119782-1 | FINE ADJUST HEAD ASM, PACIFIC STYLE | 251     |
| -   | -   | -   | -   | -   | 2119640-1 | PUSH ROD, AIR FEED                  | 250     |
| -   | -   | -   | -   | -   | 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   | #         | DATE | DESCRIPTION | DATE | OWN | APVD |
|              |     |      | -         |      | SEE SHEET 1 |      |     |      |

|     |     |     |     |     |             |                                     |         |
|-----|-----|-----|-----|-----|-------------|-------------------------------------|---------|
| -   | 1   | 1   | 1   | 1   | 2119082-8   | 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   | 1   | 1   | 1   | 356885-4    | STOP, SHEAR                         | 237     |
| -   | -   | 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   | 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   | 1-2119656-0 | 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     |
| -   | -   | -   | -   | -   | 1633743-1   | SERVO FEED LATCH ASM                | 133     |
| -   | -   | REF | -   | -   | 2119944-1   | FEED FINGER ASSEMBLY, SF            | 117     |
| -   | 1   | 1   | 1   | 1   | 455888-4    | SPACER, CRIMPER                     | 82      |
| -   | 1   | 1   | 1   | 1   | 240641-9    | SPACER                              | 81      |
| -   | 1   | 1   | 1   | 1   | 2119956-1   | DOCUMENTATION PACKAGE               | 71      |
| -   | 1   | 1   | 1   | 1   | 2119791-5   | DEPRESSOR, WIRE                     | 70      |
| -   | 1   | 1   | 1   | 1   | 2119943-1   | WASHER, SPACER                      | 69      |
| -   | 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   | 5-18022-5   | SCR, HEX HD CAP, M4 X 6.0           | 59      |
| -   | -   | -   | -   | 1   | 1338685-1   | PAWL, FEED                          | 56      |
| -   | 2   | 2   | 2   | 2   | 2168083-8   | SCR, SKT HD CAP, RoHS, M4 X 16      | 53      |
| -   | -   | -   | -   | 1   | 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   | 2119644-1   | RAM WASHER, PRECISION               | 38      |
| -   | 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   | 1320908-2   | SPACER, STRIP GUIDE                 | 30      |
| -   | 1   | 1   | 1   | 1   | 2119959-1   | ASSEMBLY, STRIP GUIDE               | 29      |
| -   | 1   | 1   | 1   | 1   | 1-455888-0  | SPACER, CRIMPER                     | 28      |
| -   | 1   | 1   | 1   | 1   | 1320928-2   | STRIP GUIDE                         | 24      |
| -   | 1   | 1   | 1   | 1   | 2168083-2   | SCR, SKT HD CAP, RoHS, M4 X 8.0     | 21      |
| -   | 2   | 2   | 2   | 2   | 1-18028-2   | WASHER, FLAT, REG M4                | 20      |
| -   | 1   | 1   | 1   | 1   | 2119533-1   | STRIPPER, SIDE FEED                 | 19      |
| -   | 1   | 1   | 1   | 1   | 690518-4    | HOLD DOWN, TERMINAL                 | 18      |
| -   | 1   | 1   | 1   | 1   | 690463-1    | FLOATING SHEAR, REAR                | 17      |
| -   | 2   | 2   | 2   | 2   | 1-2168083-1 | SCR, SKT HD CAP, RoHS, M3 X 6       | 16      |
| -   | 1   | 1   | 1   | 1   | 1-690464-3  | SHEAR PLATE, REAR                   | 15      |
| -   | 1   | 1   | 1   | 1   | 2119862-1   | SHEAR HOLDER, REAR                  | 14      |
| -   | 1   | 1   | 1   | 1   | 2119806-1   | INSERT, SHEAR                       | 13      |
| -   | 2   | 2   | 2   | 2   | 3-22280-3   | SPRING, COMPRESSION                 | 12      |
| -   | 1   | 1   | 1   | 1   | 1-356885-5  | 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   | 3-1803537-3 | ANVIL, COMBINATION                  | 8       |
| -   | 1   | 1   | 1   | 1   | 240641-5    | SPACER                              | 7       |
| -   | 1   | 1   | 1   | 1   | 690468-1    | DEPRESSOR SHEAR, REAR               | 6       |
| -   | 1   | 1   | 1   | 1   | 2119757-2   | DEPRESSOR, SHEAR                    | 5       |
| -   | 1   | 1   | 1   | 1   | 1-238011-0  | BLOCK, CRIMPER SPACER               | 4       |
| -   | 1   | 1   | 1   | 1   | 1-1803614-7 | CRIMPER, INSULATION F               | 3       |
| -   | 1   | 1   | 1   | 1   | 455888-5    | SPACER, CRIMPER                     | 2       |
| -   | 1   | 1   | 1   | 1   | 1-456402-4  | CRIMPER, WIRE PREMIUM               | 1       |
| -77 | -27 | -25 | -22 | -21 | PART NO     | DESCRIPTION                         | ITEM NO |

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

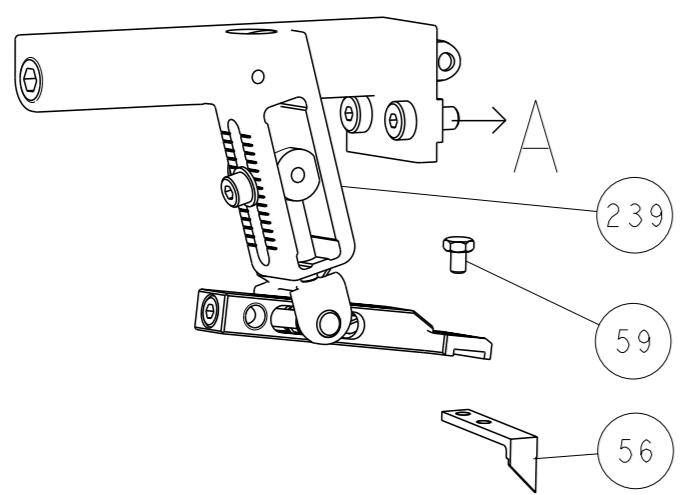
| DATE       | BY      | CHK      | APPV    | NAME                       |
|------------|---------|----------|---------|----------------------------|
| 17SEPT2018 | M. HERR | T. ELBIN | B. BAIR | Ocean Side Feed Applicator |

| SIZE | CAGE CODE | DRAWING NO | RESTRICTED TO |
|------|-----------|------------|---------------|
| A1   | 00779     | 2837440    | -             |

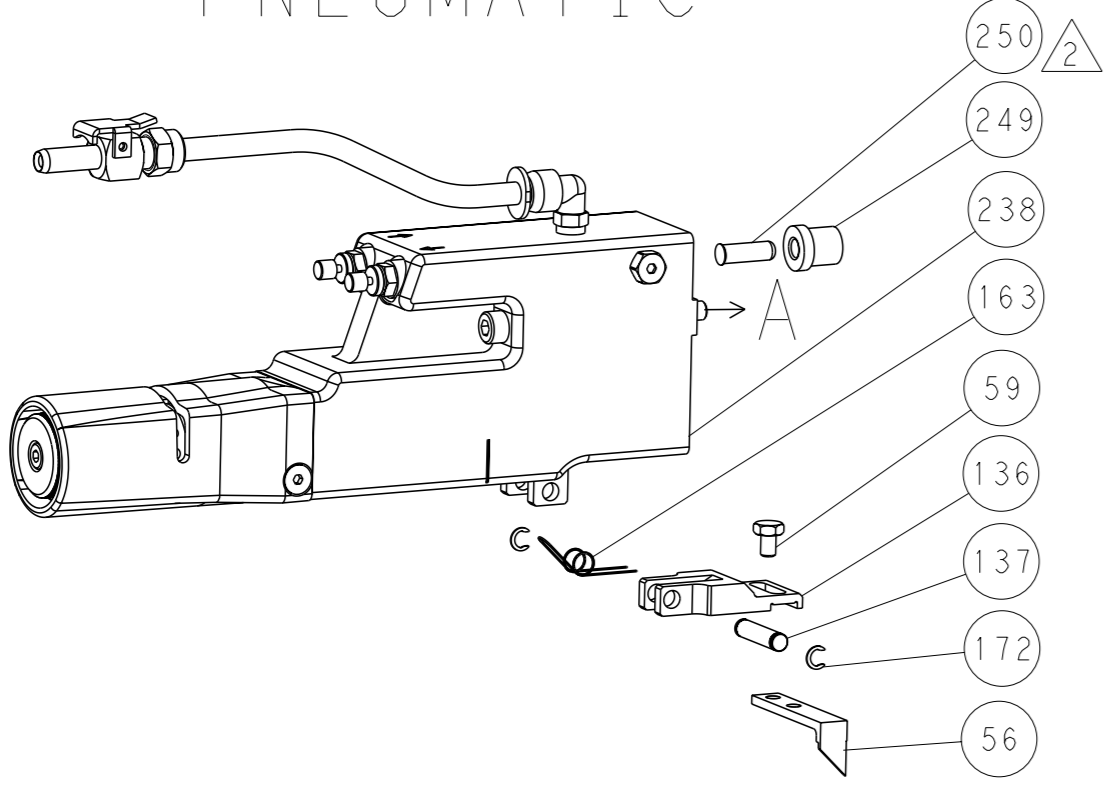
Customer Accessible Production Drawing SCALE 1:2 SHEET 3 of 4 REV A

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

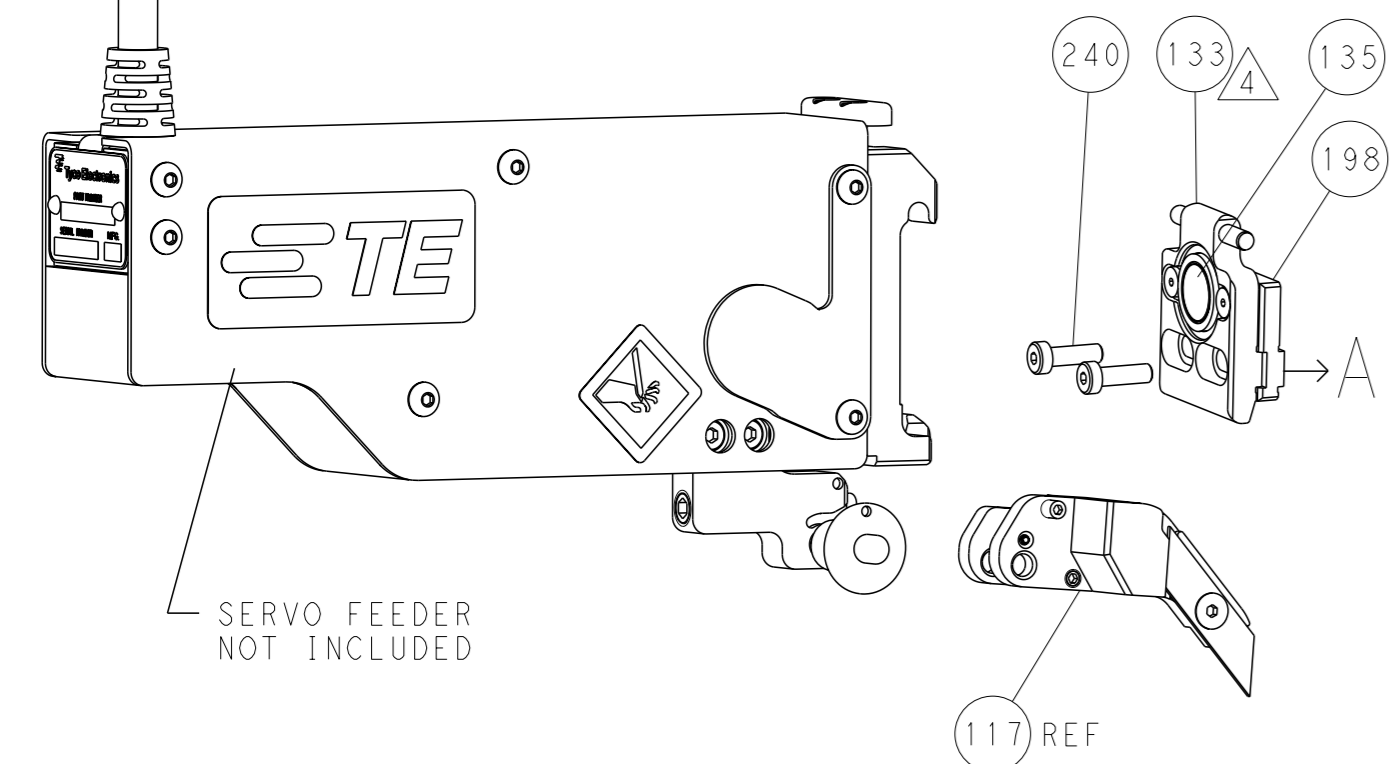
# FEED TYPE MECHANICAL



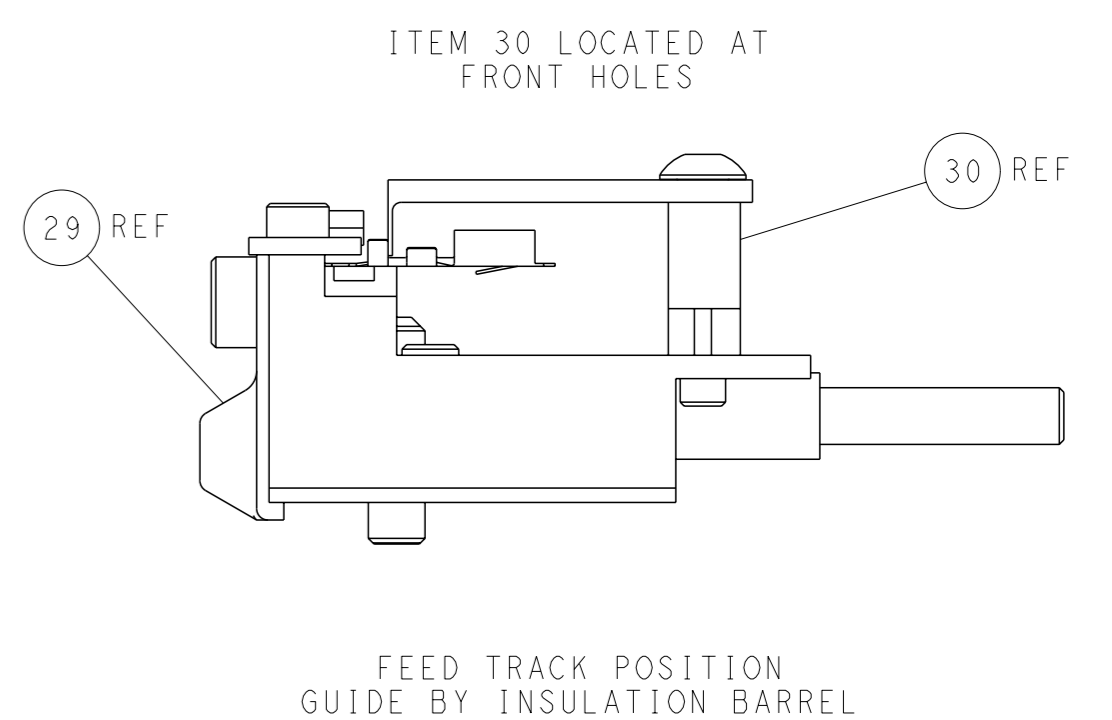
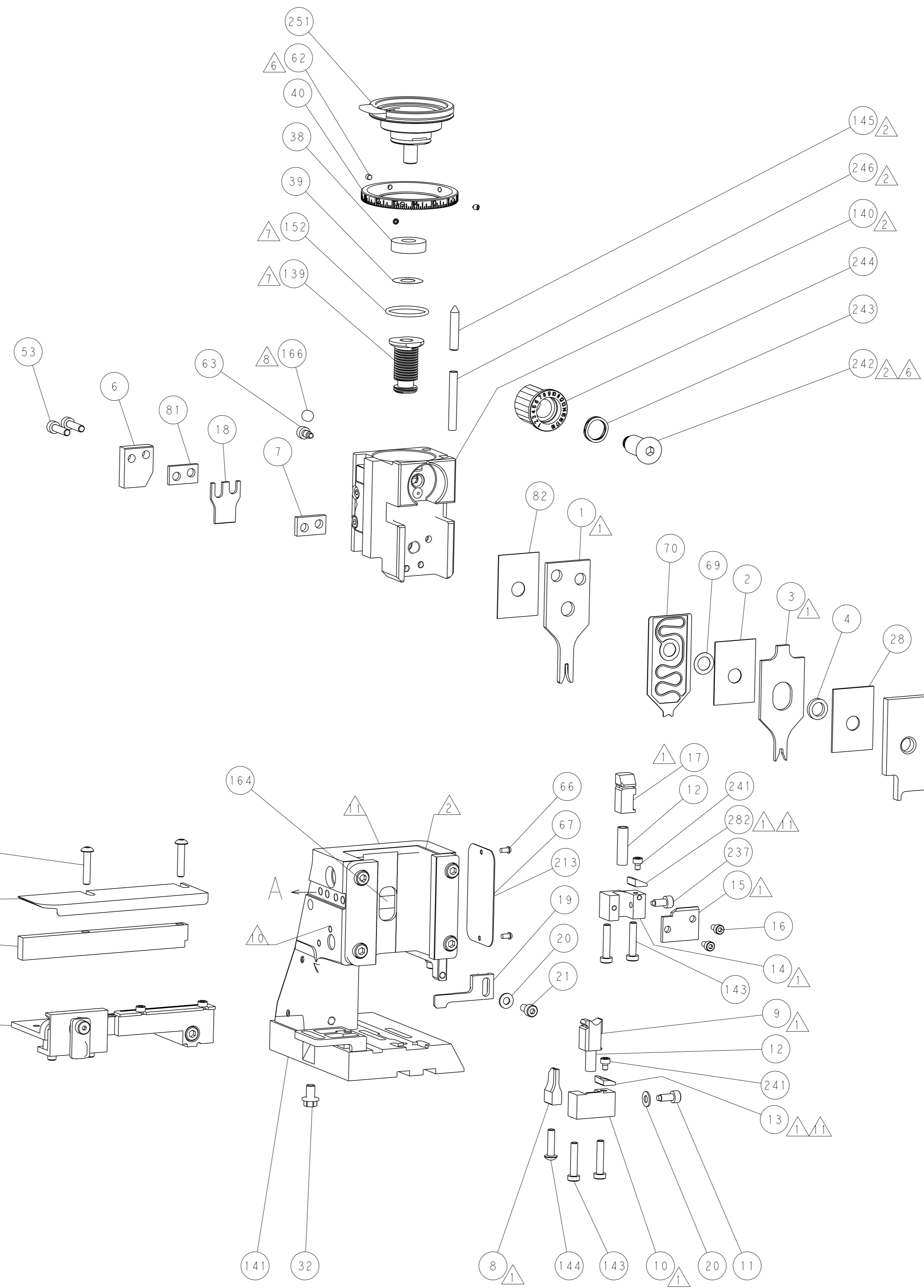
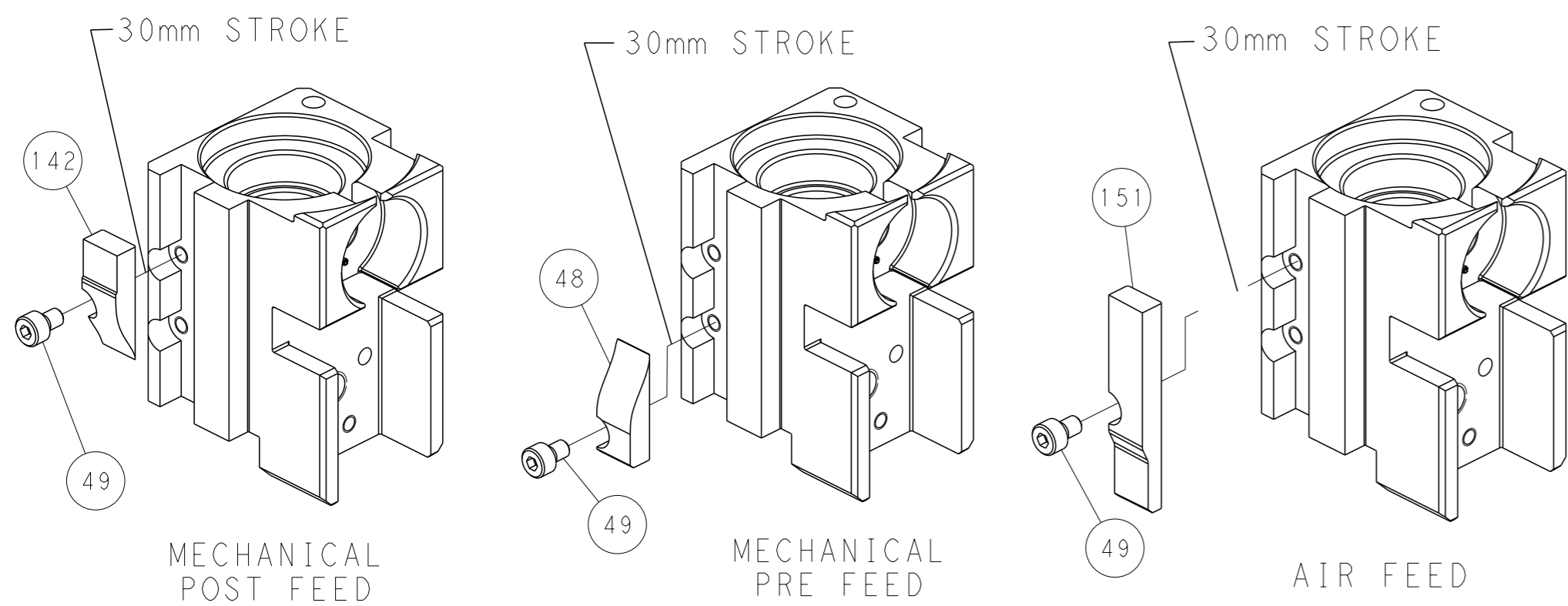
# PNEUMATIC



# 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: |          | OWN: M. HERR 17SEPT2018                | TE Connectivity<br>Harrisburg, PA 17105-3608 |
| mm          | 0 PLC ±   | 1 PLC ±                                | 2 PLC ±  | CHE: T. ELBIN 17SEPT2018               |  |
|             | 3 PLC ±   | 4 PLC ±                                | ANGLES ± | APVD: B. BAIR 17SEPT2018               | NAME: Ocean Side Feed Applicator             |
|             | MATERIAL: | FINISH:                                | WEIGHT:  | Customer Accessible Production Drawing | SCALE: 1:2                                   |
|             |           |  |          | SIZE: A1                               | CAGE CODE: 00779                             |
|             |           |  |          | DRAWING NO: C=2837440                  | RESTRICTED TO:                               |
|             |           |  |          | SHEET: 4 of 4                          | REV: A                                       |