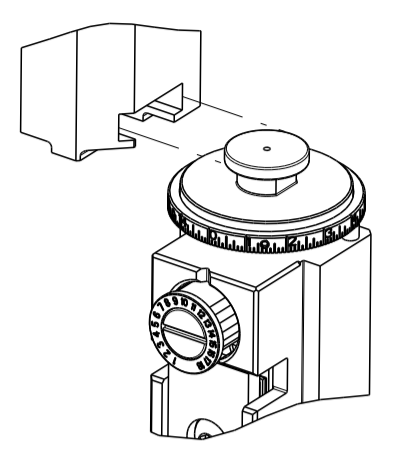


ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
	2836451-1	A	FINE CRIMP HEIGHT ADJUST	MECHANICAL
	2836451-2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
	2836451-5	A	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE
	2836451-6	A	NON CRIMP HEIGHT ADJUST	SERVO LATCH PLATE
	2836451-7	A	FINE CRIMP HEIGHT ADJUST	NONE
	7-2836451-7	A	CRIMP TOOLING KIT	-
	7-2836451-8	A	APPLICATOR CONVERSION KIT	-

CRIMP	SIZE	TYPE
WIRE	1.75 mm [.069]	F
INSUL	1.32 mm [.052]	O

APPLICATOR INSTRUCTIONS 408-10389

PART NUMBER	INSULATION DIAMETER RANGE
7-2836506-8	Ø2.67-3.18mm [.105-.125]
7-2836507-8	Ø2.16-2.82mm [.085-.111]
7-2836508-8	Ø1.91-2.67mm [.075-.105]
7-2836509-8	Ø1.62-2.16mm [.063-.085]
7-2836451-8	Ø1.27-1.57mm [.050-.062]

TERMINAL NAME: STAMPED CONTACT PIN SIZE 20	WIRE STRIP LENGTH: 3.81-5.09 mm [.150-.200 IN]	INSULATION DIAMETER RANGE: Ø1.27-1.57 mm [.050-.062 IN]
TERMINAL APPLICATION SPECIFICATION: 0425-059-0000 Rev L	TE TERMINAL: 1572032-3	DEUTSCH TERMINAL: 1060-20-0222
TE TERMINAL	DEUTSCH TERMINAL	TE TERMINAL
1572032-3	1060-20-0222	1572032-4
1572032-8	1060-20-0277	1060-20-0244

TERMINAL NAME: STAMPED CONTACT SOCKET SIZE 20	WIRE STRIP LENGTH: 3.81-5.09 mm [.150-.200 IN]	INSULATION DIAMETER RANGE: Ø1.27-1.57 mm [.050-.062 IN]
TERMINAL APPLICATION SPECIFICATION: 0425-059-0000 Rev L	TE TERMINAL: 286680-3	DEUTSCH TERMINAL: 1062-20-0222
TE TERMINAL	DEUTSCH TERMINAL	TE TERMINAL
286680-3	1062-20-0222	286680-4
1-286680-1	1062-20-0277	1062-20-0244

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.75mm ²	1.22±0.03/-0.05 [.048±.001/-0.002]	5.9
0.60mm ²	1.07±0.03/-0.05 [.042±.001/-0.002]	7.4
20 AWG	0.99±0.03/-0.05 [.039±.001/-0.002]	8.2
0.50mm ²	0.97±0.03/-0.05 [.038±.001/-0.002]	8.4
22 AWG	0.94±0.03/-0.05 [.037±.001/-0.002]	8.7
0.35mm ²	0.94±0.03/-0.05 [.037±.001/-0.002]	8.7

- 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: 8-2836451-4
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2836451-4
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2836451-5
 SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2836451-6
- 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 ITEMS 62. APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEMS 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 4.58.
- SEE APPROPRIATE APPLICATOR LOG SHEETS FOR APPLIED TERMINALS, WIRE RANGE AND MEMORY CHIP.
- TERMINAL LUBRICANTOR 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.

-78	-77	-7	-6	-5	-2	-1	PART NO	DESCRIPTION	ITEM NO
-	-	-	1	-	-	-	2119957-2	APPLICATOR SHIM PACK	260
-	-	1	-	1	1	1	8-21084-0	O-RING, .676 ID, .070 DIA. MAT.	252
-	-	-	-	-	1	-	2119640-1	PUSH ROD, AIR FEED	250
-	-	-	-	-	1	-	2079988-1	BUSHING, LCH5-12, MISUMI	249
-	-	-	-	-	1	-	2119641-1	FEED CAM, AIR FEED	248
-	-	1	-	1	1	1	2119798-1	DETENT PIN	247
-	-	1	-	1	1	1	1-22279-3	SPRING, COMPRESSION	246
-	-	-	1	-	-	-	2119758-1	RAM, AMP STYLE, SIDE FEED, NON-ADJ.	245

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	LOC	DIST	REVISIONS					
2119599-1	A	66	P	LTN	DESCRIPTION	DATE	OWN	APVD
			1		DEVELOPMENT	23SEP2016	YY	KZ
			A		RELEASED	13OCT2016	YY	KZ
			A1		ECR-18-013072	17AUG2018	TB	TE

P	LTN	DESCRIPTION	DATE	OWN	APVD			
-	-	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	2	-	-	2168400-6	SHCS, LOW HEAD, RoHS, M5 X 16	240
-	-	-	-	-	-	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	-	-	-	1	-	2063440-1	AIR FEED MODULE	238
-	-	1	1	-	-	2119740-2	TAG, IDENTIFICATION	213
-	-	1	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	1-1752354-8	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
-	-	-	-	-	-	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	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854	137
-	-	-	-	-	1	2119799-1	HOLDER, FEED FINGER, AF	136
-	-	-	-	-	-	SEE NOTE 4	MEMORY CHIP, PROGRAMMED	135
-	-	1	1	-	-	1633743-1	SERVO FEED LATCH ASM	133
-	-	1	1	1	1	1-18028-2	WASHER, FLAT, REG M4	119
-	-	-	-	-	-	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	-	-	-	-	-	2836451	PRINT, APPLICATOR LOG SHEET	72
-	-	1	1	1	1	2119956-1	DOCUMENTATION PACKAGE	71
-	-	2	2	2	2	2119791-9	DEPRESSOR, WIRE	70
-	-	1	-	-	1	2119740-1	TAG, IDENTIFICATION	67
-	-	2	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	1	1	1	2079383-4	SCR, BHSC, RoHS (M4 X 8)	60
-	-	-	-	-	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	-	-	-	-	1	1338685-1	PAWL, FEED	56
-	-	4	4	4	4	2168400-1	SHCS, LOW HEAD, RoHS, M4 X 12	54
-	-	2	2	2	2	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	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	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	-	-	-	-	1	2119652-1	FEED CAM, PRE FEED	48
-	-	-	-	-	1	2119653-1	FEED CAM, POST FEED	47
-	-	1	1	1	1	2-2119656-1	APPLICATOR BASIC ASSEMBLY, SF	46
-	-	1	-	1	1	2119370-1	RAM, AMP STYLE, SIDE FEED	44
-	-	1	1	1	1	2079383-7	SCR, BHSC, RoHS (M8 X 25)	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	2119644-1	RAM WASHER, PRECISION	38
-	-	1	1	1	1	2119085-1	FA HEAD, ATLANTIC STYLE	37
-	-	1	-	1	1	2119092-1	BOLT, ADJUSTMENT	35
-	-	1	1	1	1	2-1752356-0	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	1-1320908-0	SPACER, STRIP GUIDE	30
-	-	1	1	1	1	2119959-1	ASSEMBLY, STRIP GUIDE	29
-	-	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	1	1	1-1803293-6	ANVIL, COMBINATION DEUTSCH STYLE	8
-	-	1	1	1	1	3-240641-7	SPACER	7
-	-	-	-	-	-	-	-	6
-	-	1	1	1	1	1-2119757-2	DEPRESSOR, SHEAR	5
-	-	1	1	1	1	238011-9	BLOCK, CRIMPER SPACER	4
1	1	1	1	1	1	6-1803019-3	CRIMPER, INSULATION O	3
-	-	1	1	1	1	455888-4	SPACER, CRIMPER	2
-	-	1	1	1	1	4-1633713-4	CRIMPER, WIRE PREMIUM	1

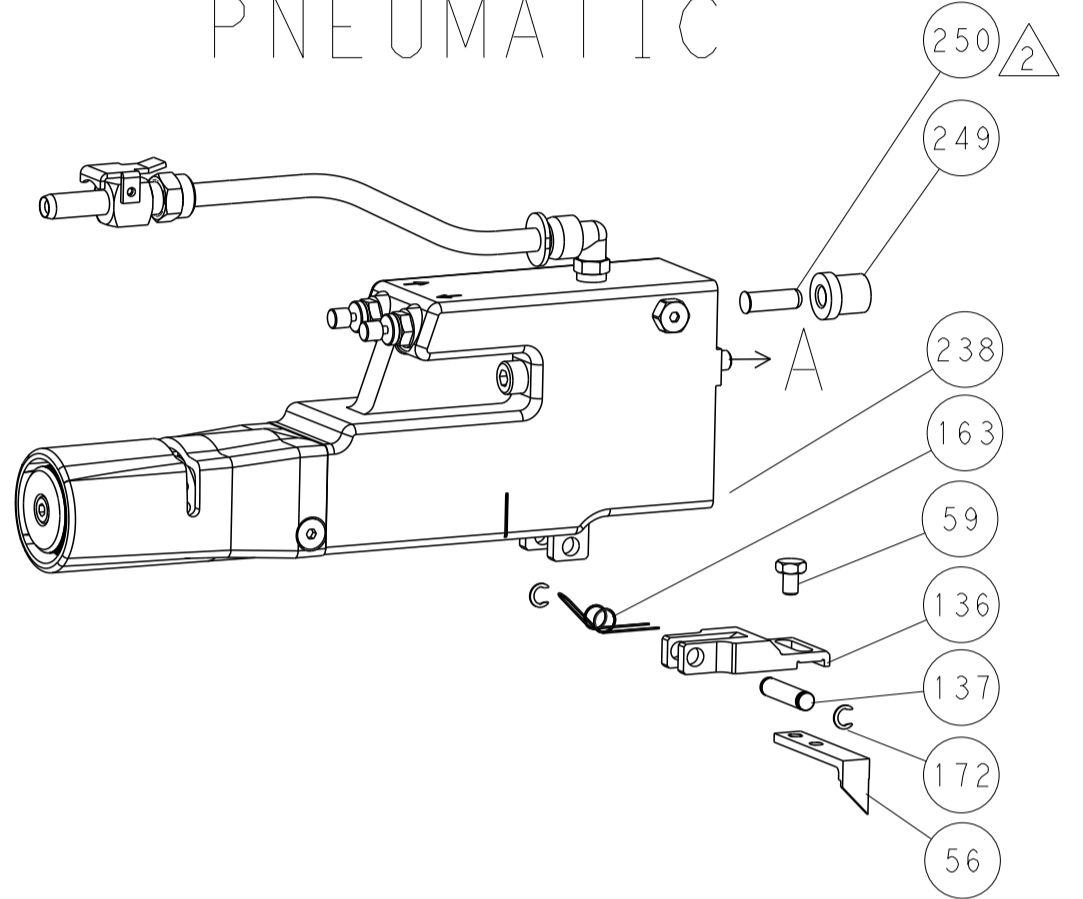
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		OWN	DATE	 TE Connectivity Harrisburg, PA 17105-3608
mm	0	PLC	±	Y. YIN	23SEP2016	
		1	PLC	G. BALLEY	23SEP2016	
		2	PLC	K. ZHANG	23SEP2016	
		3	PLC			
		4	PLC			
		ANGLES	±			
		FINISH				
MATERIAL		WEIGHT				NAME: Ocean Side Feed Applicator
						SIZE: A1 CASE CODE: 00779 DRAWING NO: ©=2836451 RESTRICTED TO
				Customer Accessible Production Drawing		SCALE: 1:2 SHEET: 1 OF 4 REV: A1

LOC	DIST	REV	DATE	BY	APPV
A	66				

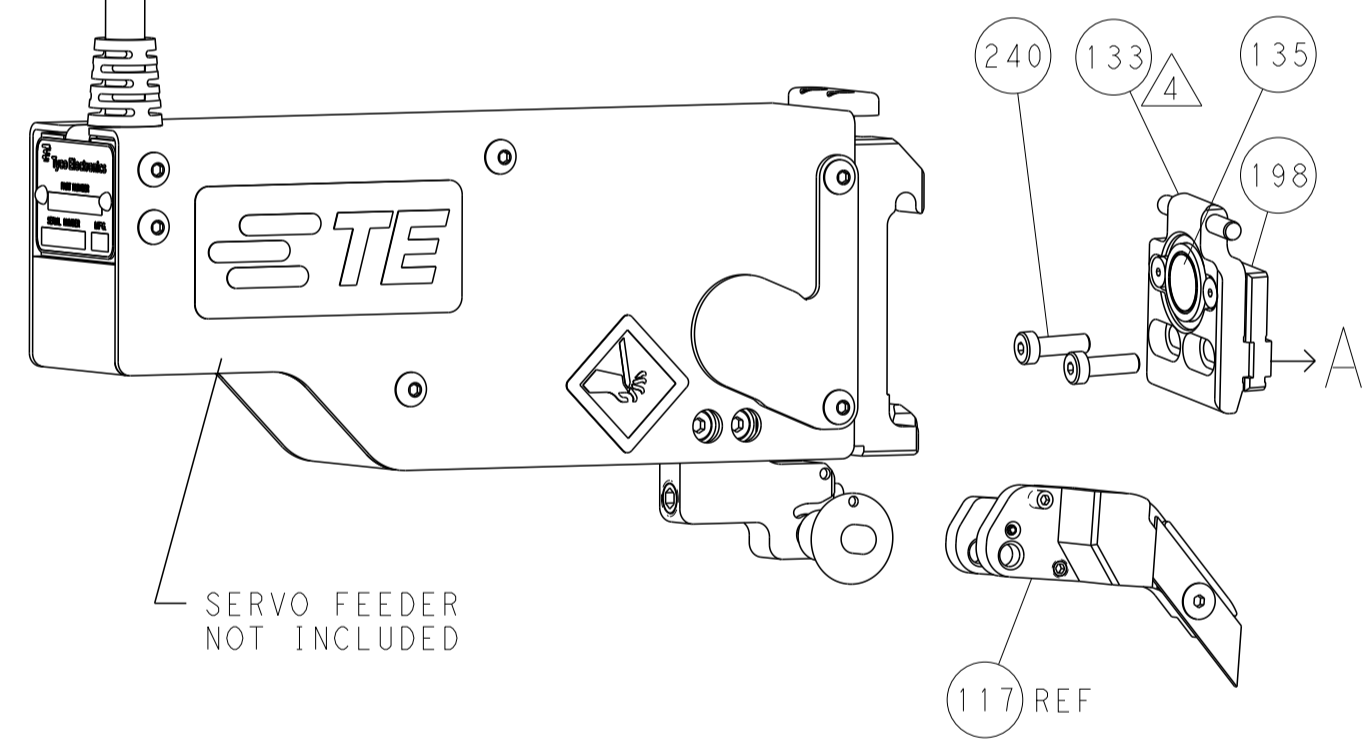
FEED TYPE MECHANICAL



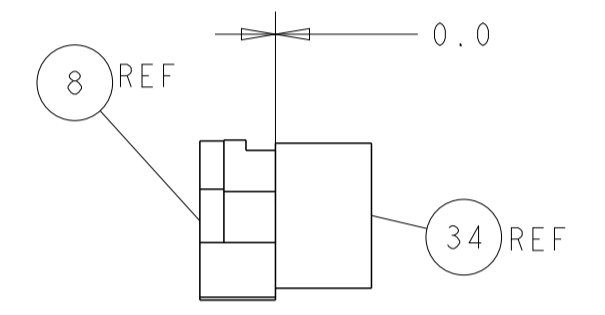
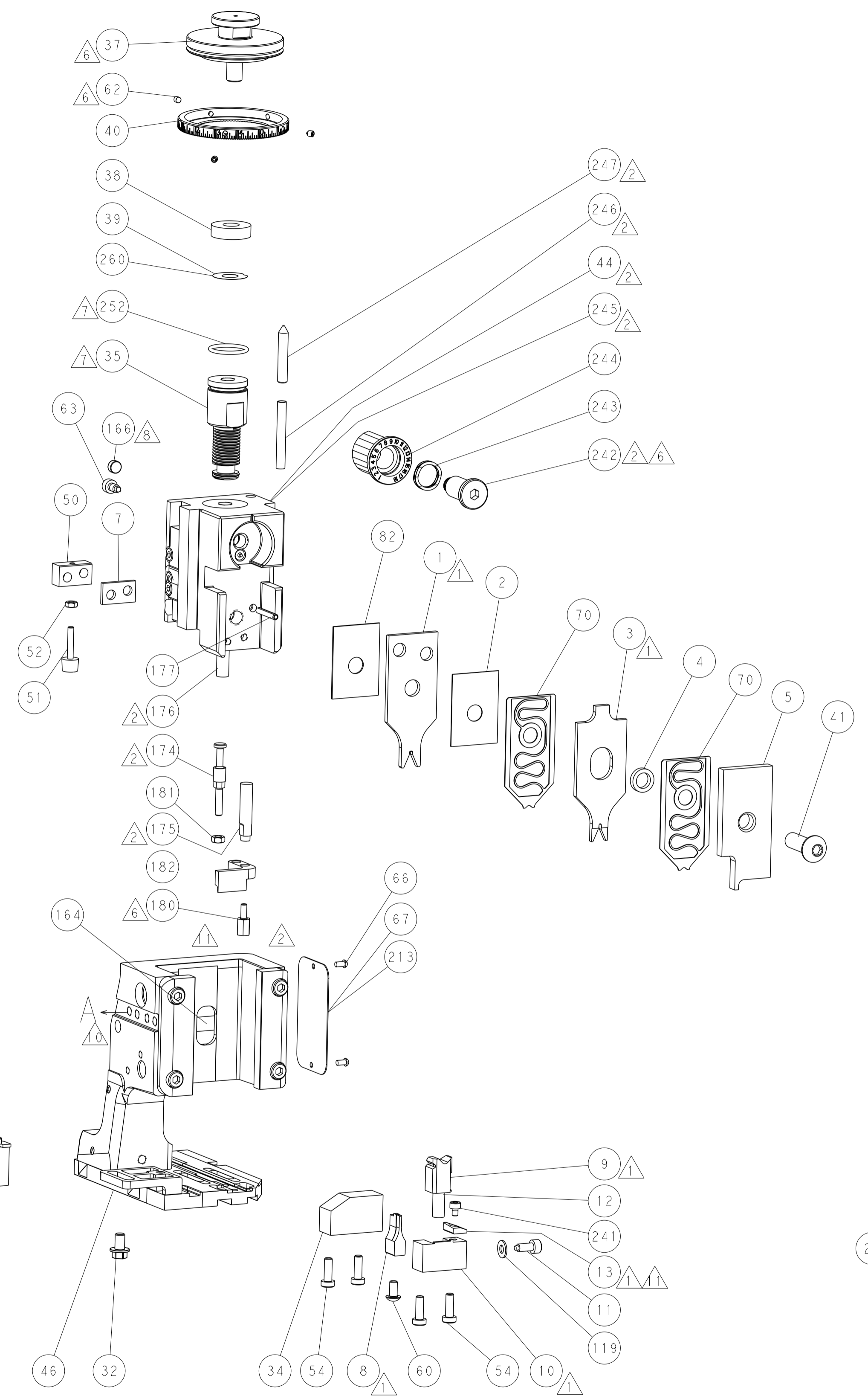
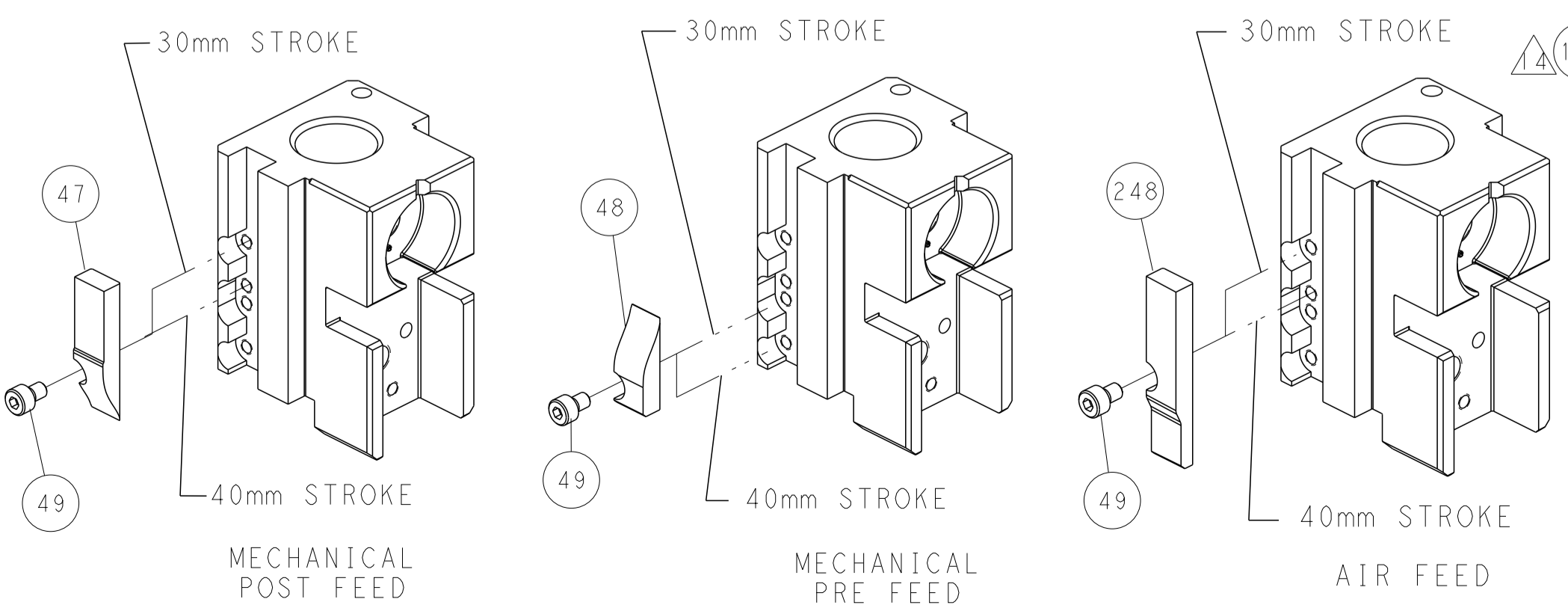
PNEUMATIC



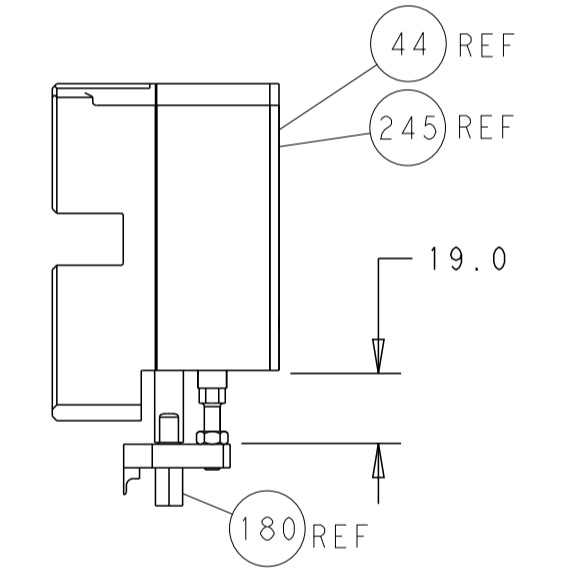
SERVO LATCH PLATE



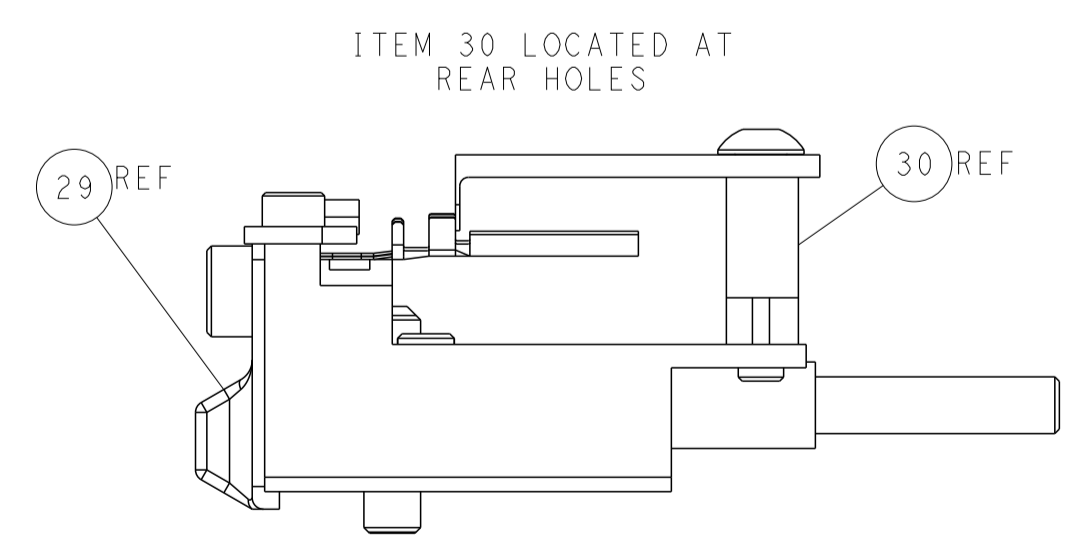
CAM POSITIONS



TERMINAL SUPPORT LOCATION



HOLDDOWN SET-UP



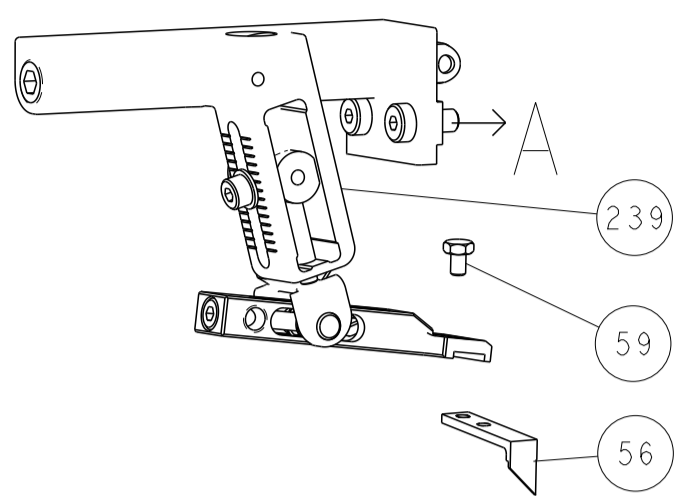
FEED TRACK POSITION GUIDE BY WIRE BARREL

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

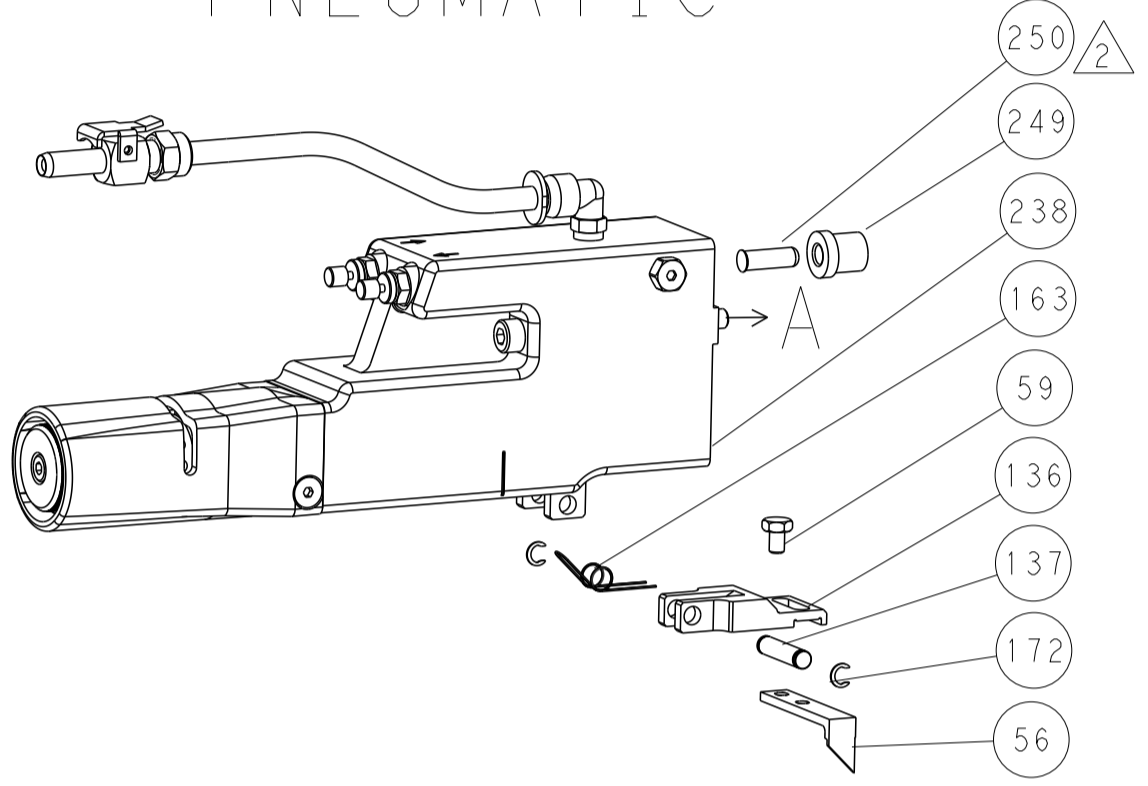
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG		REV	
mm	0 PLC	±		Y. YIN	23SEP2016	TE Connectivity	
	1 PLC	±		CHK G. BAILEY	23SEP2016	Harrisburg, PA 17105-3608	
	2 PLC	±		APPV K. ZHANG	23SEP2016	NAME	
	3 PLC	±				Ocean Side Feed	
	4 PLC	±				Applicator	
	ANGLES	±				SIZE	CAGE CODE
	FINISH	±				A1	00779
MATERIAL						DRAWING NO	©=2836451
						RESTRICTED TO	
						Customer Accessible Production Drawing	SCALE 1:2
						SHEET 2 of 4	REV A1

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

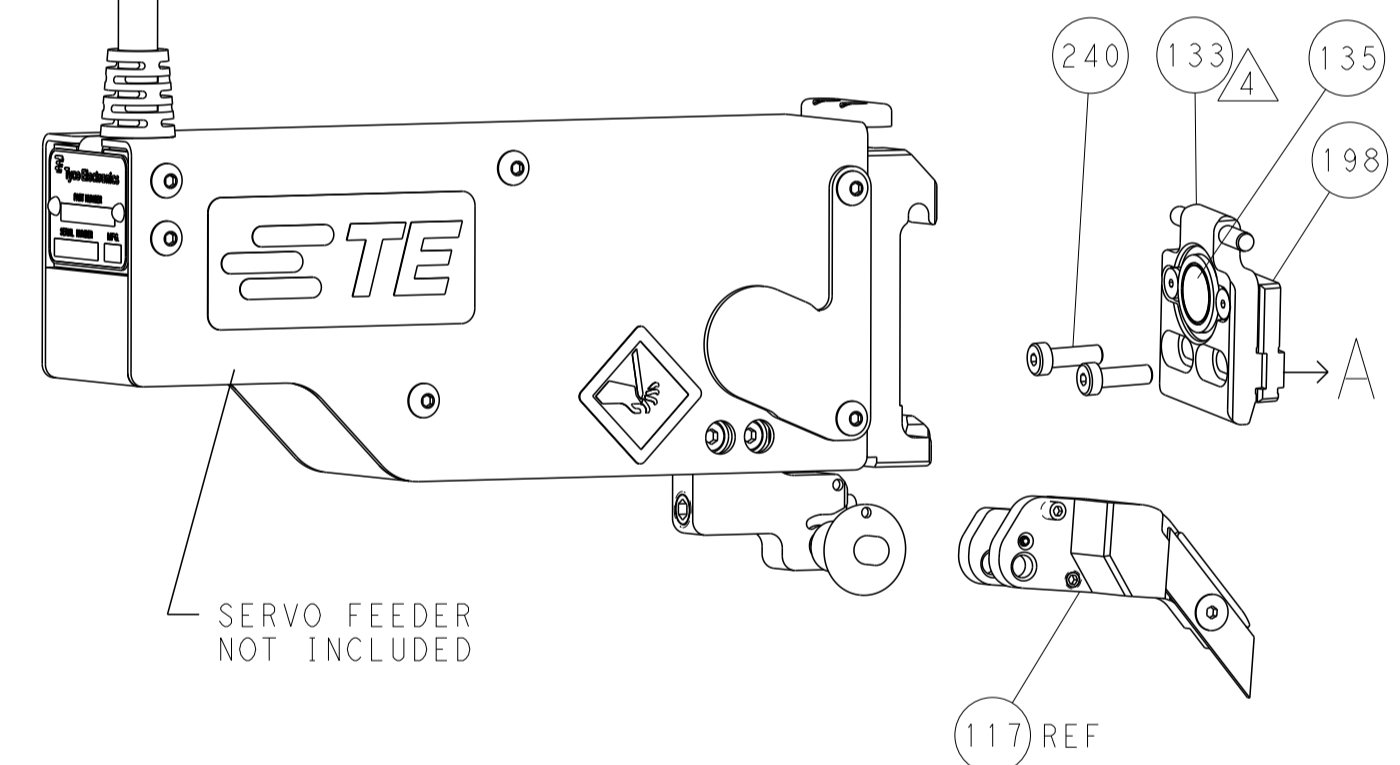
FEED TYPE MECHANICAL



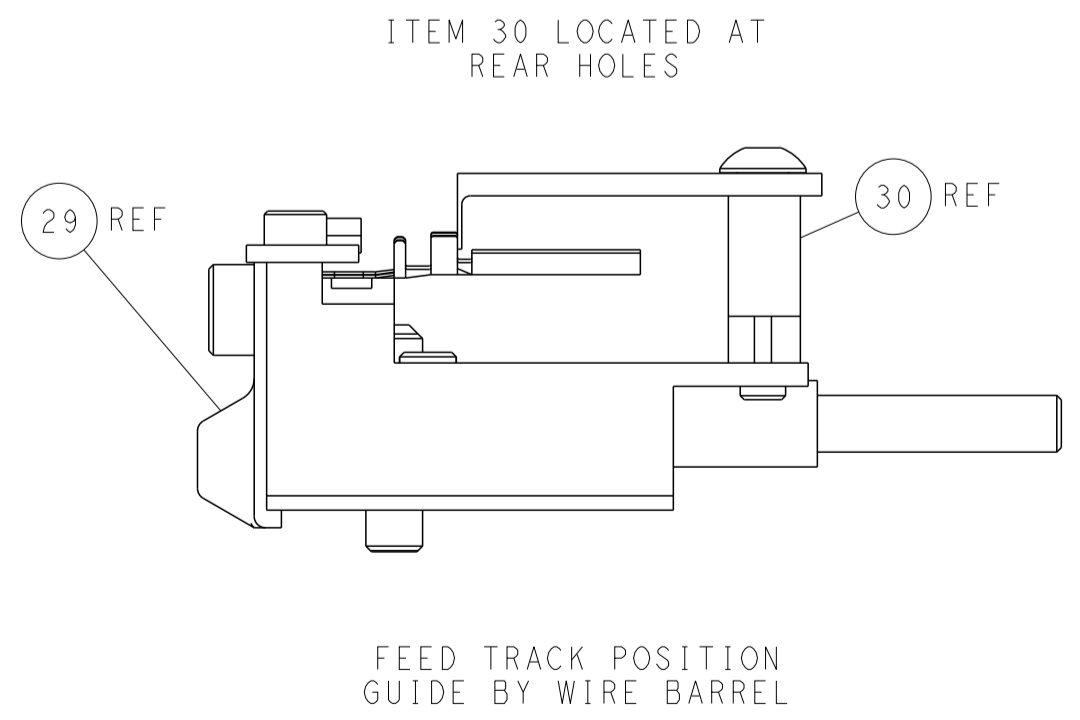
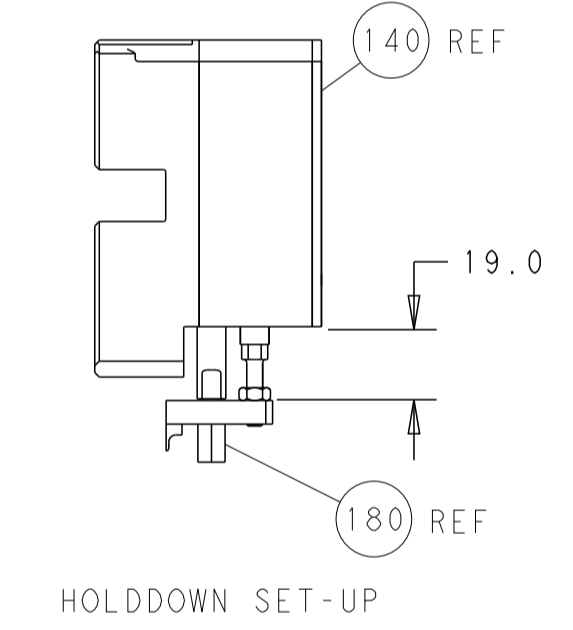
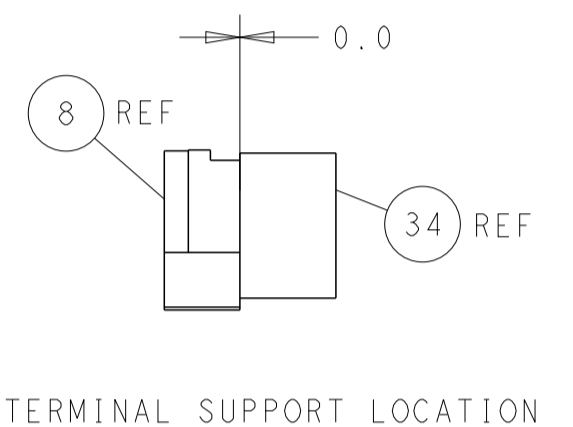
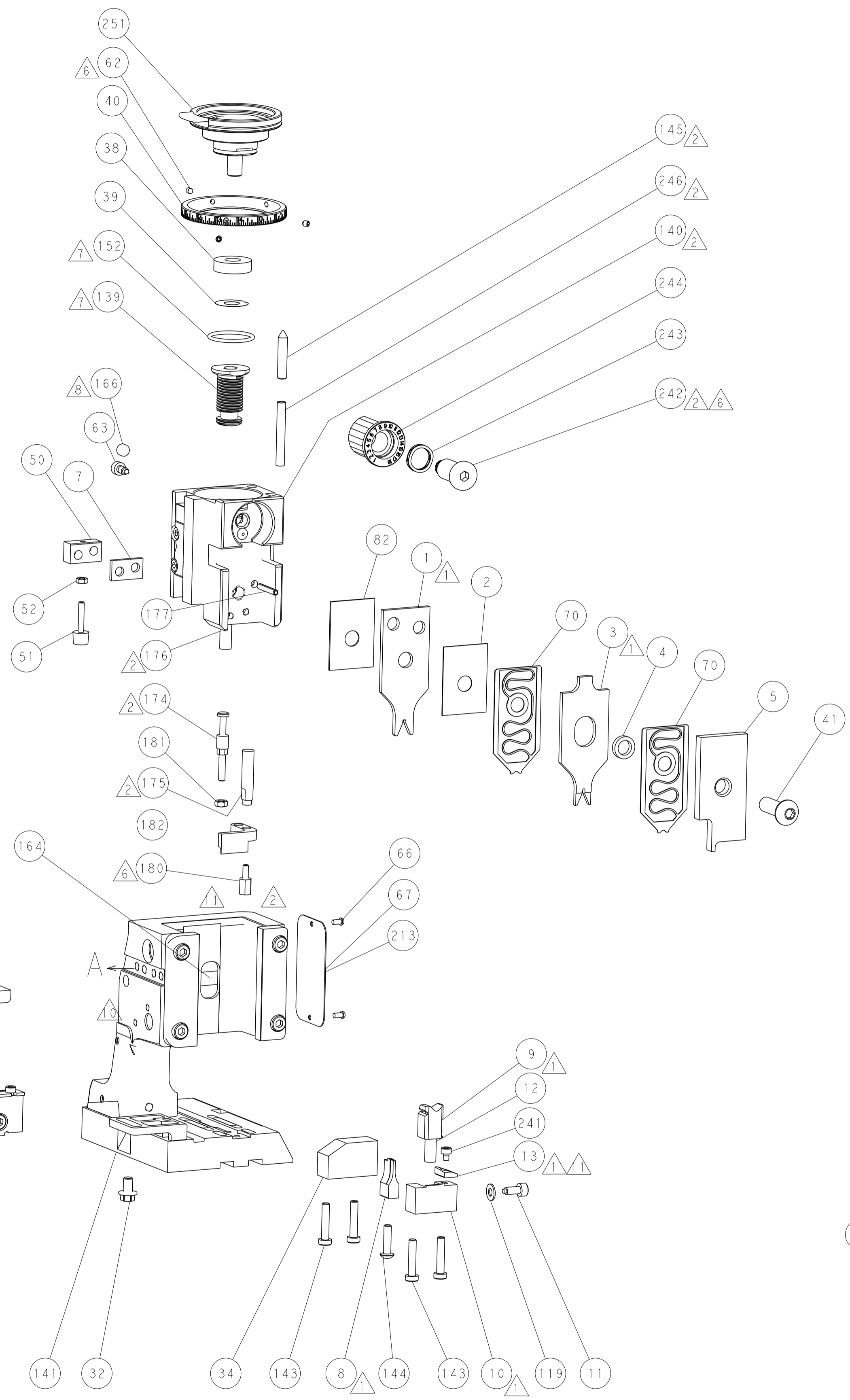
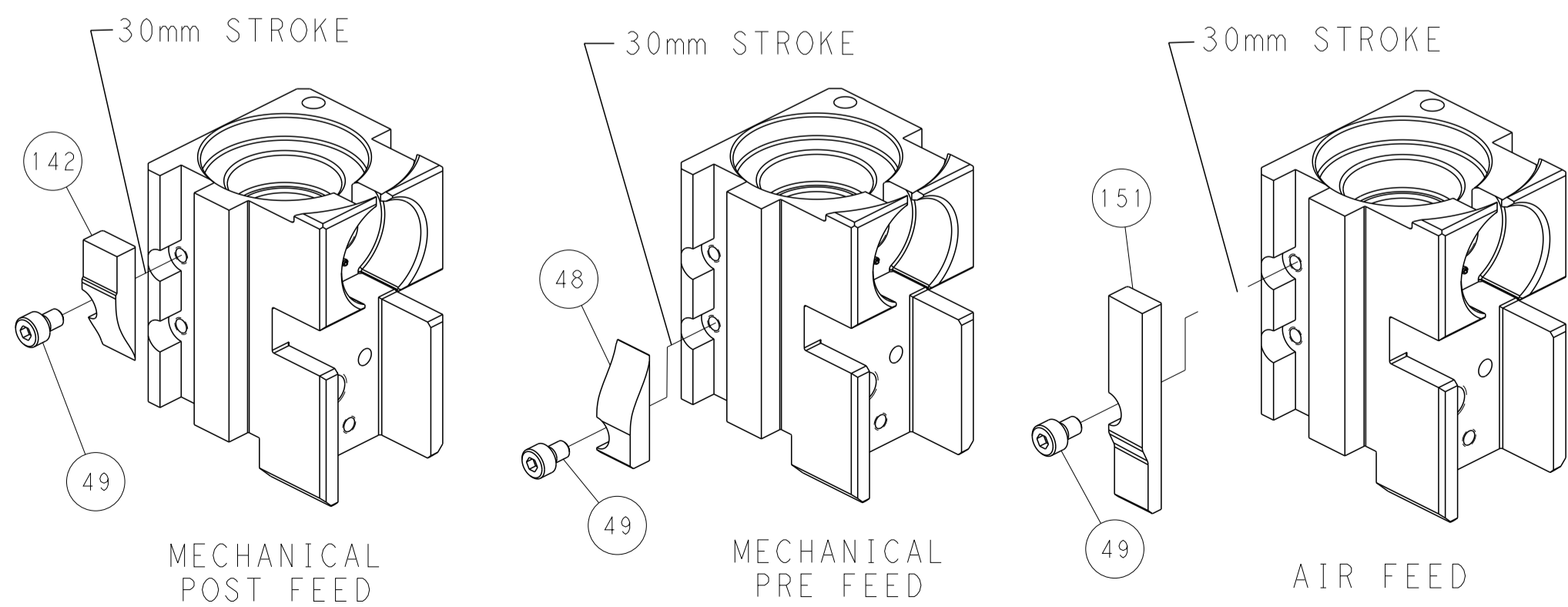
PNEUMATIC



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)

<small>THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION. ALL RIGHTS RESERVED. THIS IS THE PROPERTY OF CONNECTED TECHNOLOGY AND ITS CONTENTS ARE UNCLASSIFIED UNLESS OTHERWISE SPECIFIED. SHOULD BE CONTACTED FOR THE LATEST REVISION.</small>		DWN Y. YIN 23SEP2016 CHK G. BAILEY 23SEP2016 APVD K. ZHANG 23SEP2016	NAME Ocean Side Feed Applicator
DIMENSIONS: mm 	TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH	PRODUCT SPEC APPLICATION SPEC WEIGHT SCALE 1:2	SIZE CAGE CODE DRAWING NO A1 00779 C=2836451 SHEET 4 OF 4 REV A1