

8

7

6

5

4

3

2

1

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ATLANTIC VERSION
TERMINATOR
INTERFACE ADAPTER

PART
NUMBER

REVISION

DESCRIPTION

FEED TYPE

2836702-1

A

FINE CRIMP HEIGHT ADJUST

MECHANICAL

SUPERSEDED BY 5-2151948-1

2836702-2

A

FINE CRIMP HEIGHT ADJUST

PNEUMATIC

SUPERSEDED BY 5-2151948-2

2836702-5

A

FINE CRIMP HEIGHT ADJUST

SERVO
LATCH PLATE⁴

OBSOLETE

2836702-6

A

NON CRIMP HEIGHT ADJUST

SERVO
LATCH PLATE⁴¹²

OBSOLETE

2836702-7

A

FINE CRIMP HEIGHT ADJUST

NONE

OBSOLETE

7-2836702-7

A

CRIMP TOOLING KIT

-

APPLICATOR DATA

CRIMP

SIZE

TYPE

WIRE

1.16 mm [.046]

F

INSUL

1.45 mm [.057]

F

APPLICATOR INSTRUCTIONS

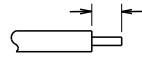
408-10389

TERMINAL DATA: TE TERMINAL

TE CRIMP SPECIFICATION

TERMINAL NAME: 2.5 PITCH NEXT GENERATION GI RECEPTACLE

WIRE STRIP LENGTH



INSULATION DIAMETER RANGE

1.70-2.30 mm [.067- .091 IN]

Ø1.08-1.50 mm [.043- .059 IN]

TERMINAL APPLICATION SPECIFICATION

114-106077

-

-

TERMINALS APPLIED⁴

TE TERMINAL

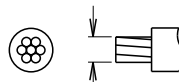
TE TERMINAL

TE TERMINAL

TE TERMINAL

1971795-1

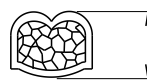
WIRE SIZE





CRIMP HEIGHT

mm [INCH]



CRIMP HEIGHT

REFERENCE SETTING



0.31-0.38mm² OR 22 AWG

0.80+/-0.03 [.031+/- .001]

4.3

0.21-0.23mm² OR 24 AWG

0.73+/-0.03 [.029+/- .001]

5.0

0.12-0.15mm² OR 26 AWG

0.67+/-0.03 [.026+/- .001]

5.6

28 AWG OR 0.08mm²

0.64+/-0.03 [.025+/- .001]

6.0

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: 8-2836702-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2836702-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2836702-5
SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2836702-6

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 ITEMS 62 & 180. 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 & 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 5.00.

13

THIS APPLICATOR IS SPECIFIC FOR USE IN A STRIPPER SEAL TERMINATING UNIT.

14

TERMINAL LUBRICANT IS RECOMMENDED.

SET UP GAUGE

2119599-1

LOC

A

DIST

66

P

LTR

DESCRIPTION

DATE

OWN

APVD

A

RELEASED

18MAT2017

LG

GB

A1

ECR-18-017697

09NOV2018

TB

CT

-

-

-

-

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

-

1

1

1

1

1

2119082-4

CAM, SNAIL, INSULATION ADJUSTMENT

244

-

1

1

1

1

1

2079764-1

WASHER, WAVE SPRING, CREST-TO-CREST

243

-

1

1

1

1

1

2119083-1

RETAINER, INSULATION DIAL

242

-

1

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

-

-

-

-

-

1

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

1

4-1722335-3

STRIPPER, SIDE FEED

182

-

1

1

1

1

1

1-5018030-0

NUT, HEX, REG, RoHS, M3.5

181

-

1

1

1

1

1

1-1752354-9

STANDOFF,HOLD-DOWN

180

-

1

1

1

1

1

9931111-1

PIN, SLOTTED SPRING 3.0 X 20.0

177

-

1

1

1

1

1

5-22280-0

SPRING, COMPRESSION

176

-

1

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1

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1752353-3

GUIDE PIN,HOLDDOWN

175

-

1

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1

1

1901680-2

GUIDE PIN,HOLDDOWN

174

-

-

-

-

2

-

21045-3

RING, RETAIN, EXTERN, 3/16 CRESCENT

172

-

1

1

1

1

1

994969-1

MAGNET, RARE EARTH HIGH ENERGY

166

-

REF

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

-

-

REF

REF

-

-

SEE NOTE 4

MEMORY CHIP, PROGRAMMED

135

-

-

1

1

-

-

1633743-1

SERVO FEED LATCH ASM

133

-

1

1

1

1

1

1-18028-2

WASHER, FLAT, REG M4

119

-

-

REF

REF

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-

2119944-1

FEED FINGER ASSEMBLY,SF

117

-

1

1

1

1

1

2119955-1

ASSY, LUBRICATOR, SIDE FEED

113

-

1

1

1

1

1

455888-5

SPACER, CRIMPER

82

-

1

1

1

1

1

2119956-1

DOCUMENTATION PACKAGE

71

-

1

1

1

1

1

2119791-9

DEPRESSOR, WIRE

70

-

1

-

-

1

1

2119740-1

TAG,IDENTIFICATION

67

-

2

2

2

2

2

2168078-1

SCREW, DRIVE, RH, RoHS, 2 x .188

66

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1

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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

1

1

1

2079383-4

SCR, BHSC, RoHS (M4 X 8)

60

-

-

-

-

1

1

5-18022-5

SCR, HEX HD CAP, M4 X 6.0

59

-

-

-

-

1

1

1338685-1

PAWL, FEED

56

-

4

4

4

4

4

2168400-1

SHCS, LOW HEAD, RoHS, M4 X 12

54

-

-

-

-

1

2

18023-9

SCR, SKT HD CAP M4 X 6.0

49

-

-

-

-

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1

2119652-1

FEED CAM, PRE FEED

48

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-

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-

-

1

2119653-1

FEED CAM, POST FEED

47

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1

1

1

1

1

2-2119656-1

APPLICATOR BASIC ASSEMBLY, SF

46

-

1

-

1

1

1

2119370-1

RAM, AMP STYLE, SIDE FEED

44

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1

1

1

1

1

2079383-7

SCR, BHSC, RoHS (M8 X 25)

41

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1

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1

2119645-1

DISC, NUMBERED FA WIRE ADJUSTMENT

40

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1

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1

1

1

2119957-1

APPLICATOR SHIM PACK

39

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1

1

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1

1-2119644-4

RAM WASHER, PRECISION

38

-

1

1

1

1

1

2119085-1

FA HEAD, ATLANTIC STYLE

37

-

1

-

1

1

1

2119092-1

BOLT, ADJUSTMENT

35

-

1

1

1

1

1

1752356-1

SUPPORT, TERMINAL

34

-

2

2

2

2

2

2079383-5

SCR, BHSC, RoHS (M4 X 20)

33

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1

1

1

1

1

2161328-1

HEX HEAD, FLANGED, M5 x 8mm LONG

32

-

1

1

1

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1

1320908-6

SPACER, STRIP GUIDE

30

-

1

1

1

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1

2119959-1

ASSEMBLY, STRIP GUIDE

29

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1

1

1

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1

1320928-2

STRIP GUIDE

24

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1

1

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2119806-1

INSERT, SHEAR

13

-

1

1

1

1

1

3-22280-3

SPRING, COMPRESSION

12

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1

1

1

1

1

1-356885-4

STOP, SHEAR

11

-

1

1

1

1

1

2119805-1

SHEAR HOLDER, FRONT

10

-

1

1

1

1

1

1803095-6

FLOATING SHEAR, FRONT -

9

-

1

1

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1-1803054-0

ANVIL, COMBINATION

8

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7

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6

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1

2119757-3

DEPRESSOR, SHEAR

5

-

1

1

1

1

1

238011-6

BLOCK, CRIMPER SPACER

4

-

1

1

1

1

1

3-1633962-2

CRIMPER, INSULATION F PREMIUM

3

-

1

1

1

1

1

455888-2

SPACER, CRIMPER

2

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1

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1

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1

3-1633730-7

CRIMPER, WIRE

1

-77

-7

-6

-5

-2

-1

PART NO

DESCRIPTION

ITEM NO

-

-

1

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-

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

ATLANTIC VERSION

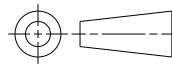
Shown on sheets 1 of 4 & 2 of 4

(Pacific version shown on sheets 3 of 4 & 4 of 4)

THIS IS SUBJECT TO COMPANY POLICY AND THE CUSTOMER'S ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST EDITION.

DIMENSIONS:

mm



TOLERANCES UNLESS OTHERWISE SPECIFIED:

0 PLC ±
1 PLC ±
2 PLC ±
3 PLC ±
4 PLC ±
ANGLES ±
FINISH

MATERIAL

-

FINISH

-

WEIGHT

-

Customer Accessible Production Drawing

SCALE

1:2

SHEET

1

OF

4

REV

A1

OWN

M. ZHAO

29MAR2017

CHK

L. ZHANG

29MAR2017

APVD

L. ZHANG

29MAR2017

NAME

Ocean Side Feed Applicator

SIZE

CAGE CODE

DRAWING NO

RESTRICTED TO

TE Connectivity

Harrisburg, PA 17105-3608

Customer Accessible Production Drawing

SCALE

1:2

SHEET

1

OF

4

REV

A1

8

7

6

5

4

3

2

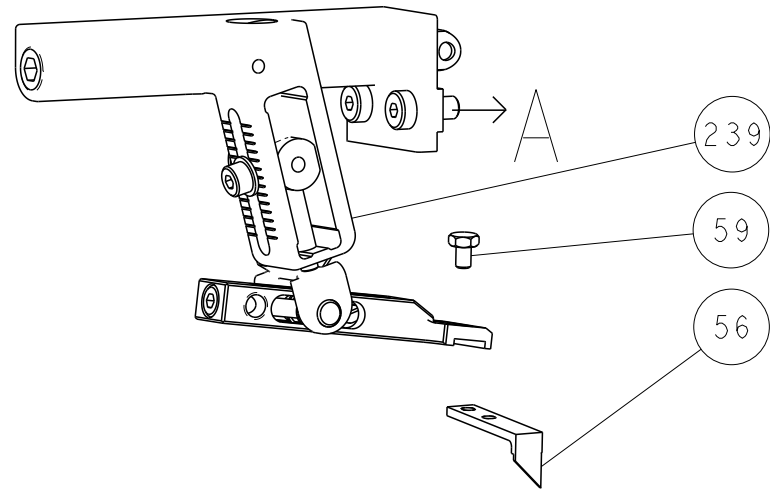
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AMP 4805 REV 31MAR2000

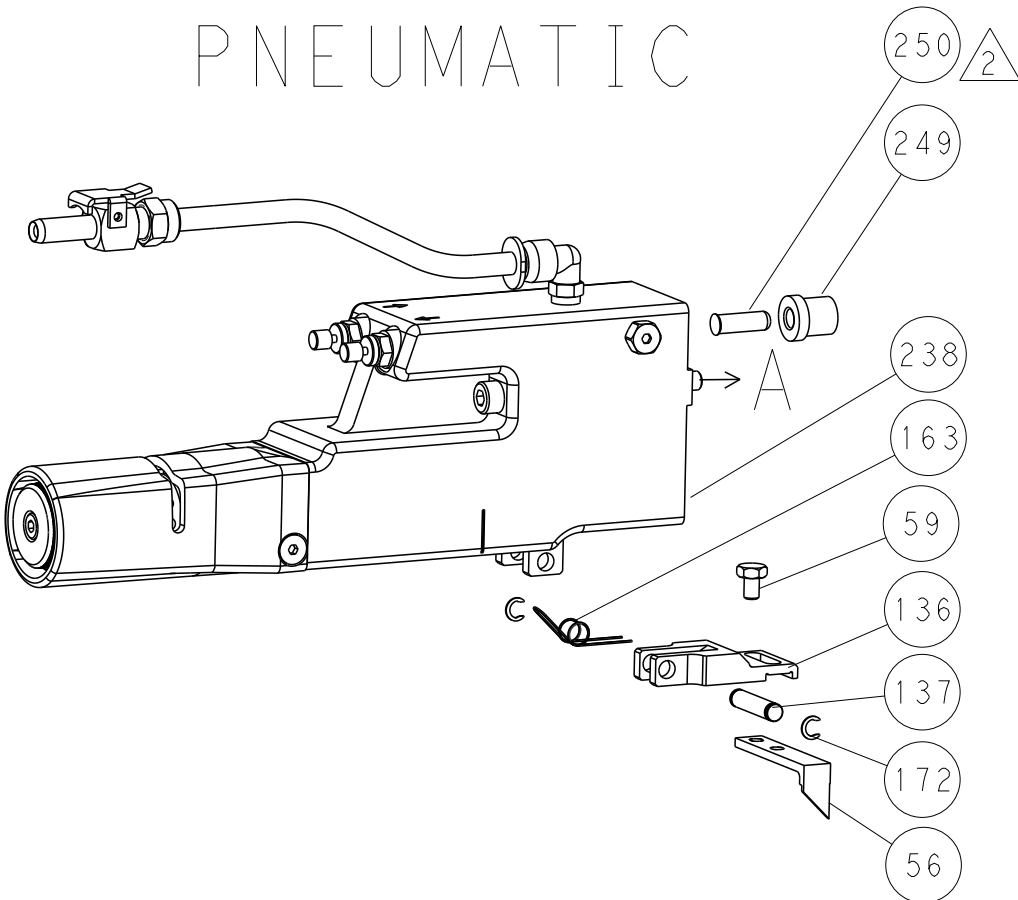
SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

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

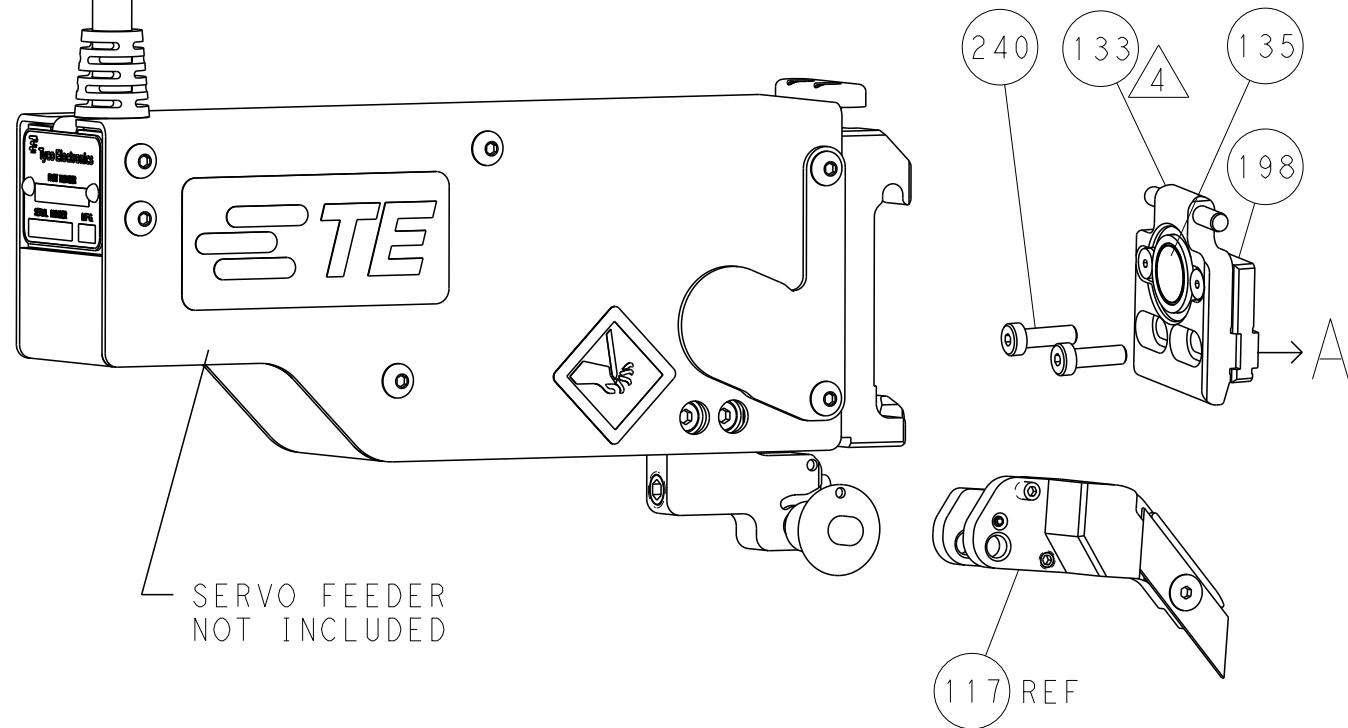
FEED TYPE MECHANICAL



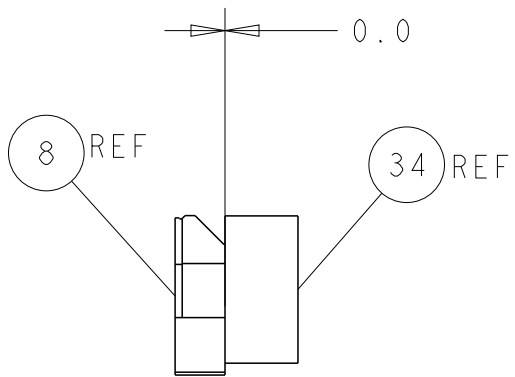
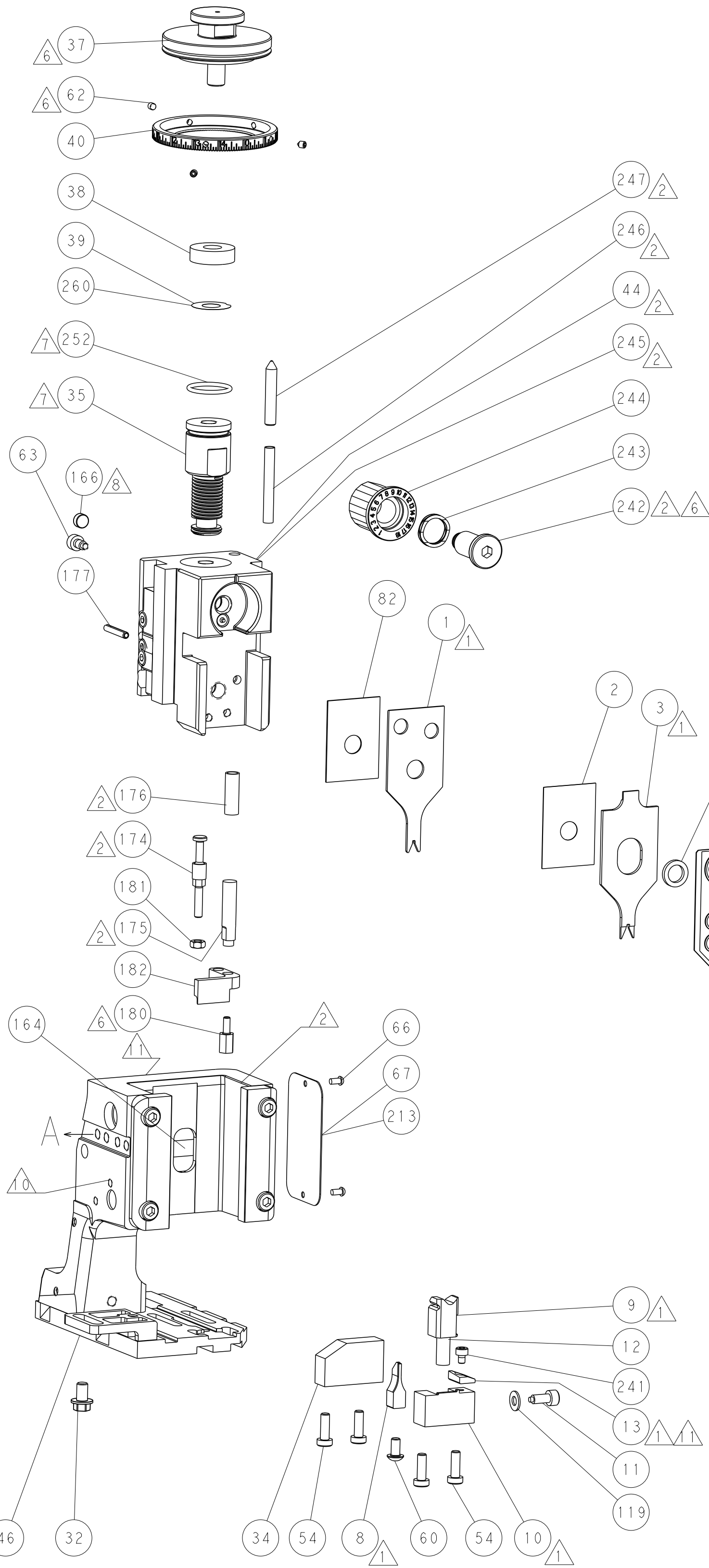
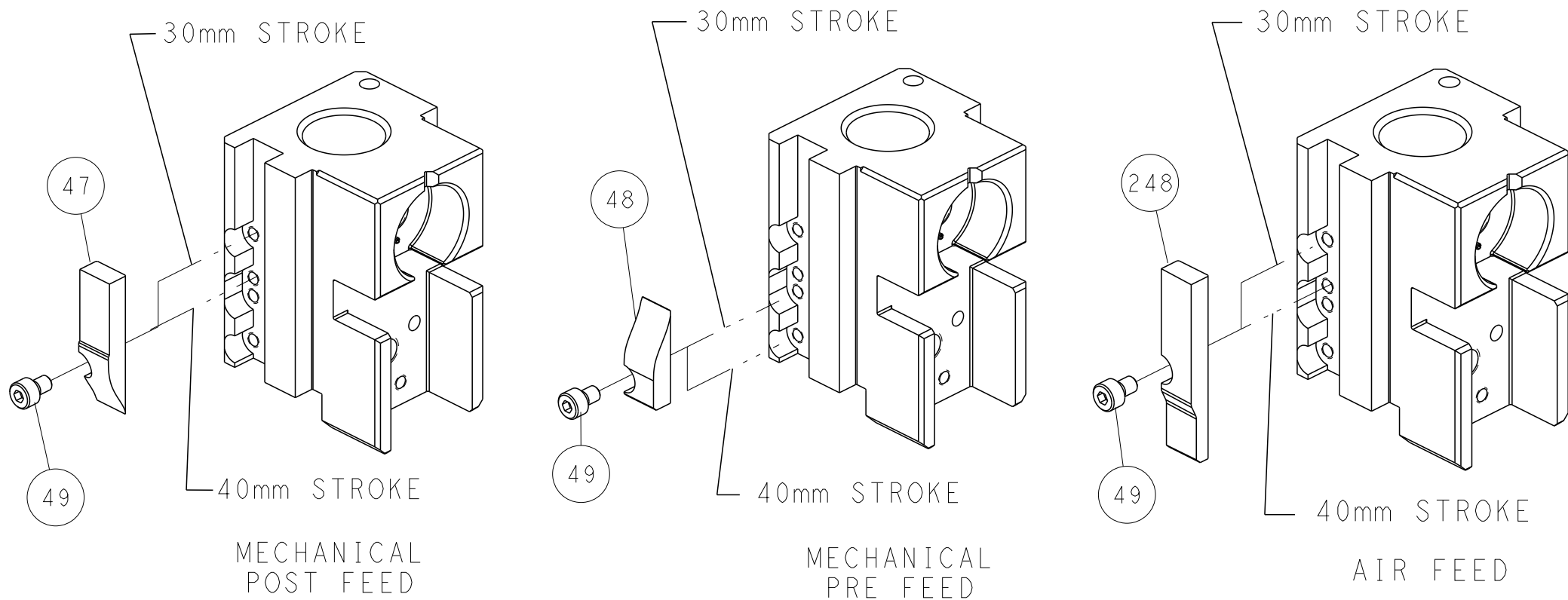
PNEUMATIC



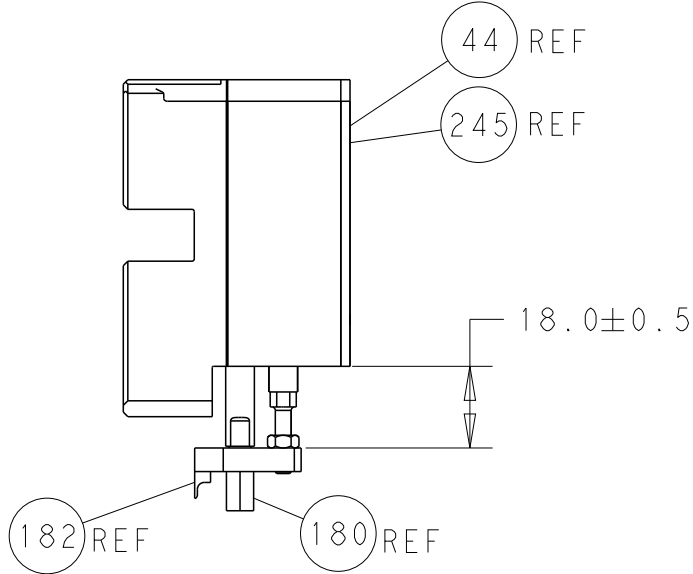
SERVO LATCH PLATE



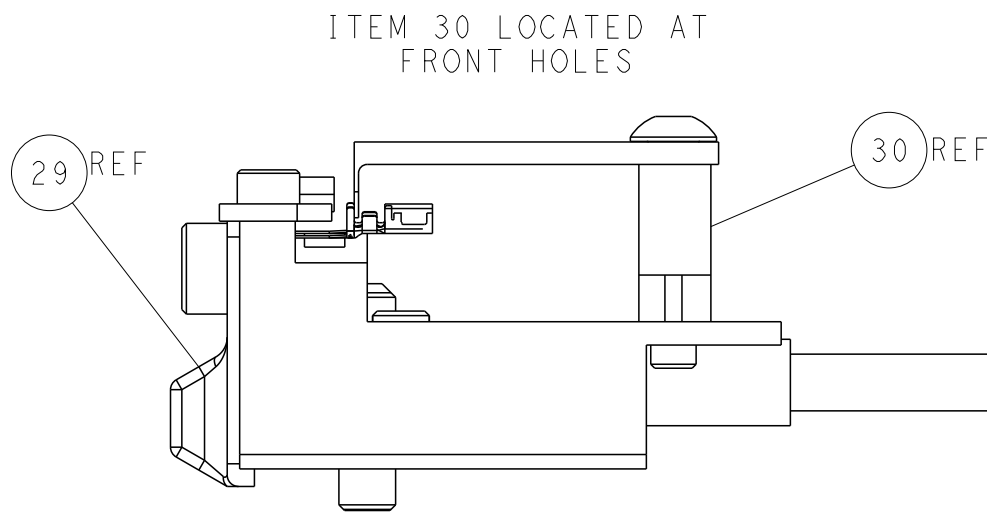
CAM POSITIONS



TERMINAL SUPPORT LOCATION



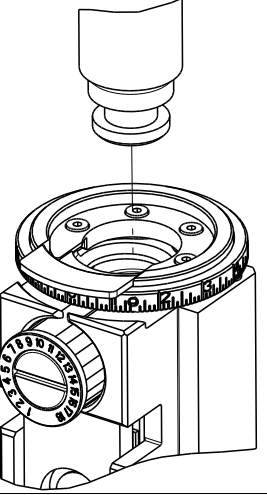
HOLDDOWN SET-UP



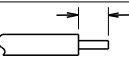
FEED TRACK POSITION
GUIDE BY INSULATION BARREL

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

THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. IT IS SUBJECT TO CHANGE WITHOUT NOTICE.		OWN	M. ZHAO	29MAR2017	TE Connectivity		
		CHK	L. ZHANG	29MAR2017	Harrisburg, PA 17105-3608		
		APVD	L. ZHANG	29MAR2017	NAME		
		PRODUCT SPEC		Ocean Side Feed			
		APPLICATION SPEC		Applicator			
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		SIZE		RESTRICTED TO	
mm		0 PLC ±		CAGE CODE		DRAWING NO	
		1 PLC ±		00779			
		2 PLC ±		C=2836702		SHEET	
		3 PLC ±		Customer Accessible Production Drawing			
		4 PLC ±		SCALE		2 OF 4	
		ANGLES		1:2			
		FINISH		REV		A1	

PACIFIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	
	2-2836702-1	A	FINE CRIMP HEIGHT ADJUST	MECHANICAL	OBSOLETE
	2-2836702-2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	OBSOLETE
	2-2836702-5	A	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE ⁴	OBSOLETE
	2-2836702-7	A	FINE CRIMP HEIGHT ADJUST	NONE	OBSOLETE
	7-2836702-7	A	CRIMP TOOLING KIT	-	

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.16 mm [.046]	F
INSUL	1.45 mm [.057]	F
APPLICATOR INSTRUCTIONS 408-10389 		

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION			
TERMINAL NAME: 2.5 PITCH NEXT GENERATION GI RECEPTACLE			
WIRE STRIP LENGTH 1.70-2.30 mm [.067-.091 IN]		 INSULATION DIAMETER RANGE Ø1.08-1.50 mm [.043-.059 IN]	
TERMINAL APPLICATION SPECIFICATION 	114-106077	-	-
TERMINALS APPLIED ¹³			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
1971795-1			

WIRE SIZE 	CRIMP HEIGHT mm [INCH] 	CRIMP HEIGHT REFERENCE SETTING ⁹ 
0.31-0.38mm ² OR 22 AWG	0.80+/-0.03 [.031+/-0.001]	4.3
0.21-0.23mm ² OR 24 AWG	0.73+/-0.03 [.029+/-0.001]	5.0
0.12-0.15mm ² OR 26 AWG	0.67+/-0.03 [.026+/-0.001]	5.6
28 AWG OR 0.08mm2	0.64+/-0.03 [.025+/-0.001]	6.0



- 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: 8-2836702-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2836702-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2836702-5
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 & 180.
APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEMS 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 THIS APPLICATOR IS SPECIFIC FOR USE IN A STRIPPER SEAL TERMINATING UNIT.
- ¹³ 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
-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)

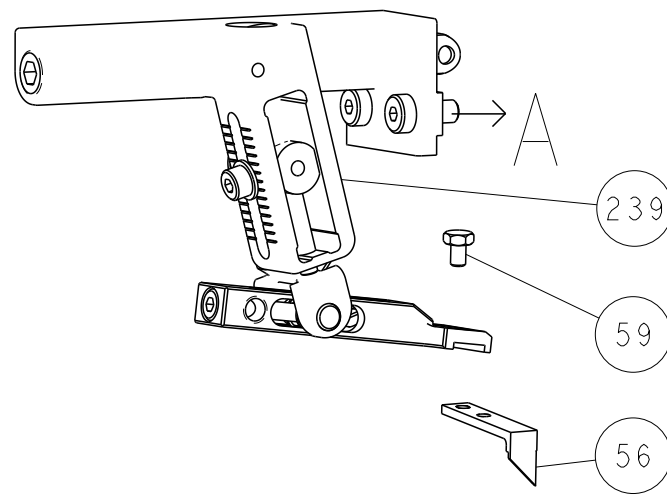
SET UP GAUGE 2119599-1		LOC A	DIST 66	REVISIONS			
P	LTR	DESCRIPTION		DATE	OWN	APVD	
	-	SEE SHEET 1		-	-	-	

-	-	-	1	-	2119640-1	PUSH ROD, AIR FEED	250
-	-	-	1	-	2079988-1	BUSHING, LCH5-12, MISUMI	249
-	1	1	1	1	1-22279-3	SPRING, COMPRESSION	246
-	1	1	1	1	2119082-4	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
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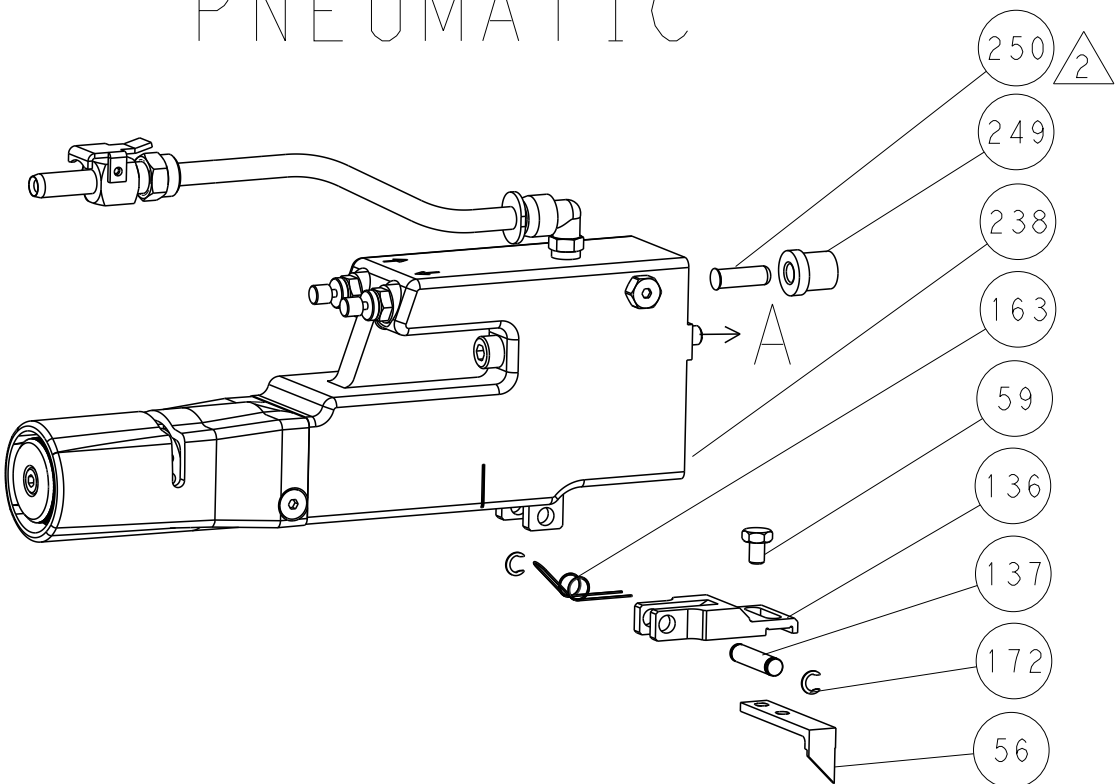
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DIMENSIONS: mm				TOLERANCES UNLESS OTHERWISE SPECIFIED:		CHECKED L. ZHANG 29MAR2017		NAME	
				0 PLC ±.01 1 PLC ±.01 2 PLC ±.01 3 PLC ±.01 4 PLC ±.01 ANGLES ±.01		PRODUCT SPEC		Ocean Side Feed Applicator	
MATERIAL				FINISH		APPLICATION SPEC		SIZE CAGE CODE DRAWING NO	
-				-		-		A1 00779 C=2836702	
						WEIGHT		RESTRICTED TO	
						-		-	
Customer Accessible Production Drawing						SCALE		SHEET	
						1:2		3 of 4	
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LOC		DIST		REVISIONS			
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		-		SEE SHEET 1	-	-	-

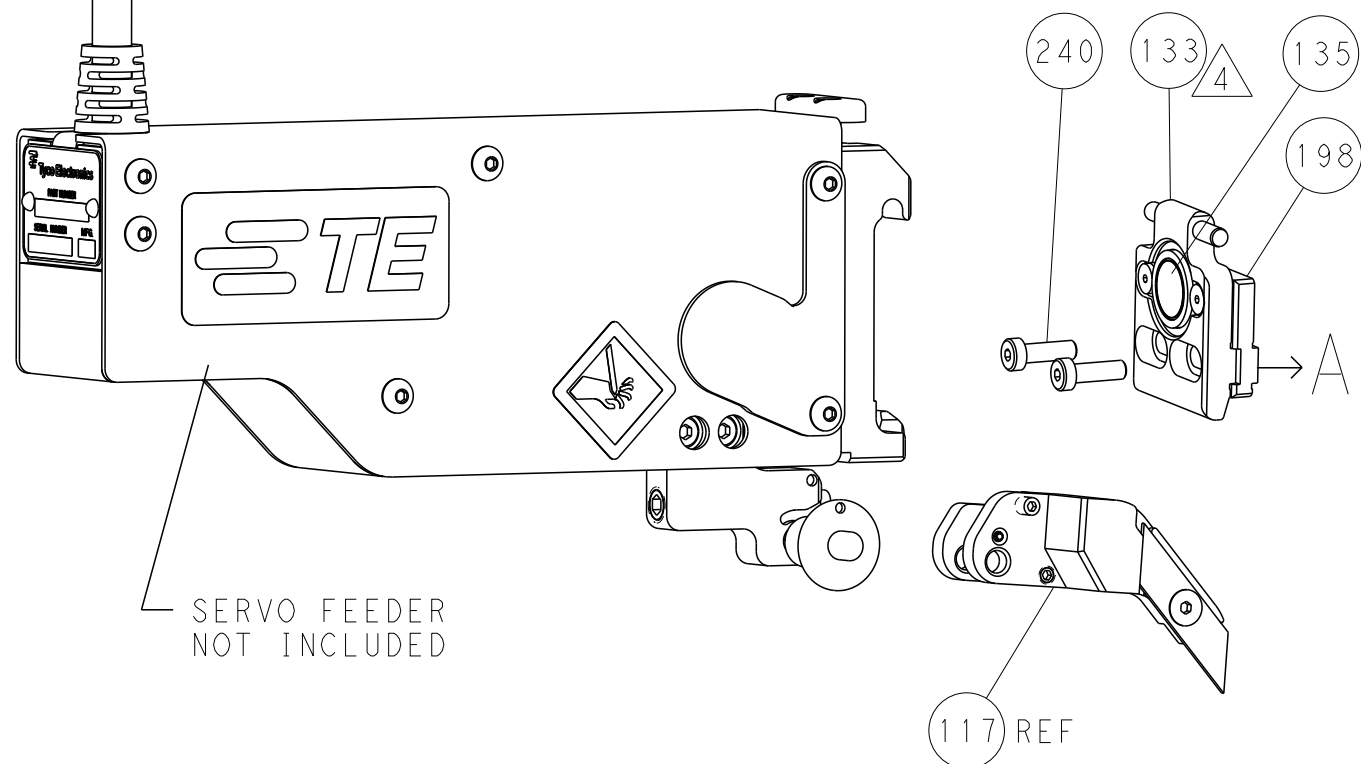
FEED TYPE
MECHANICAL



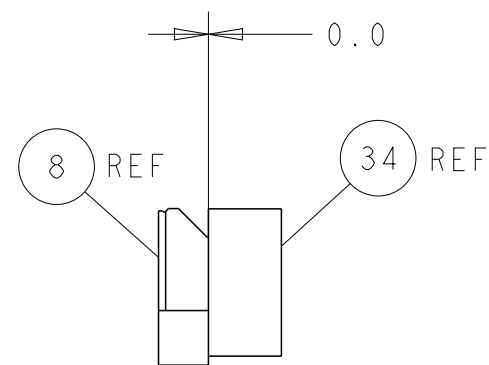
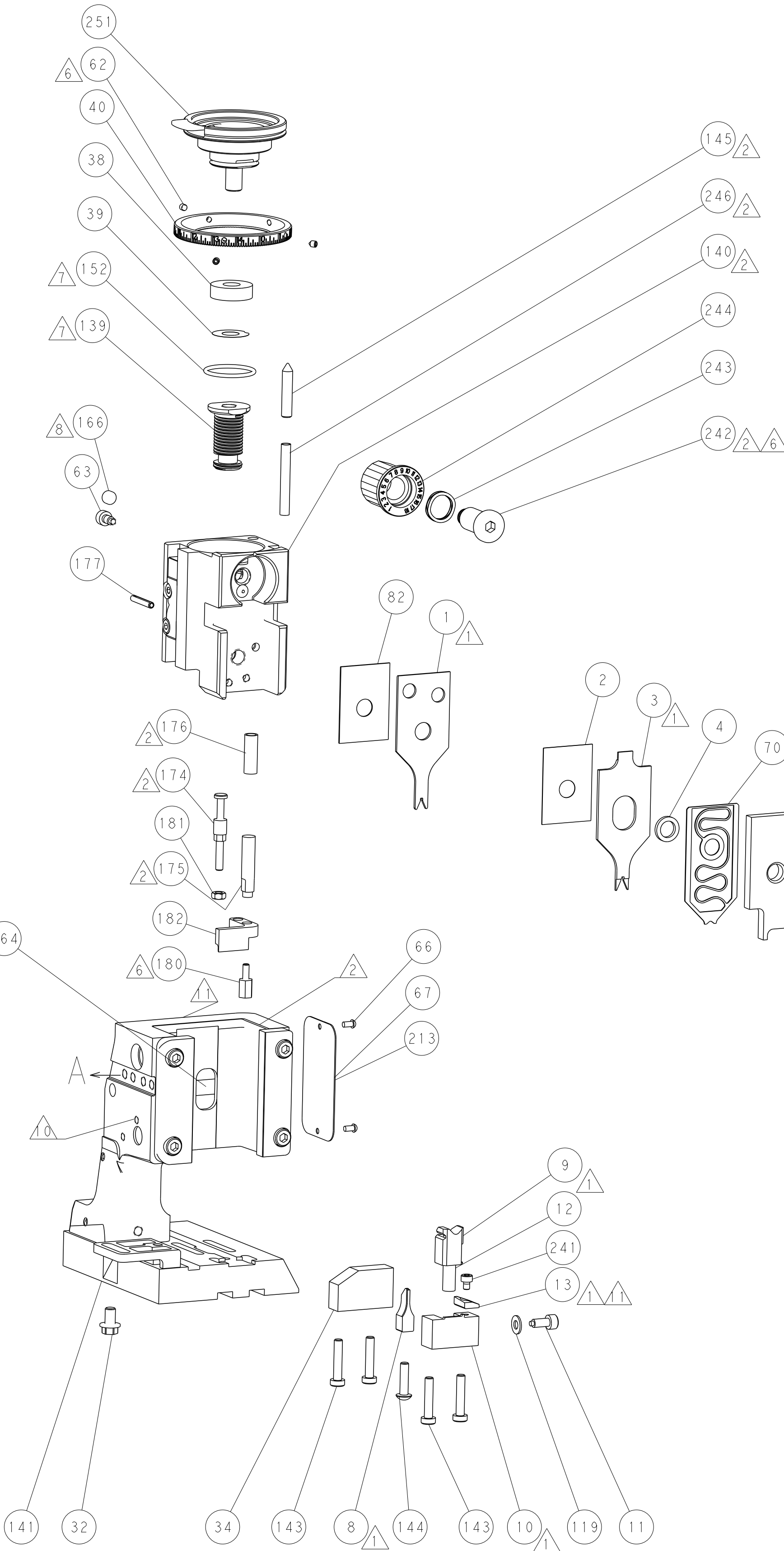
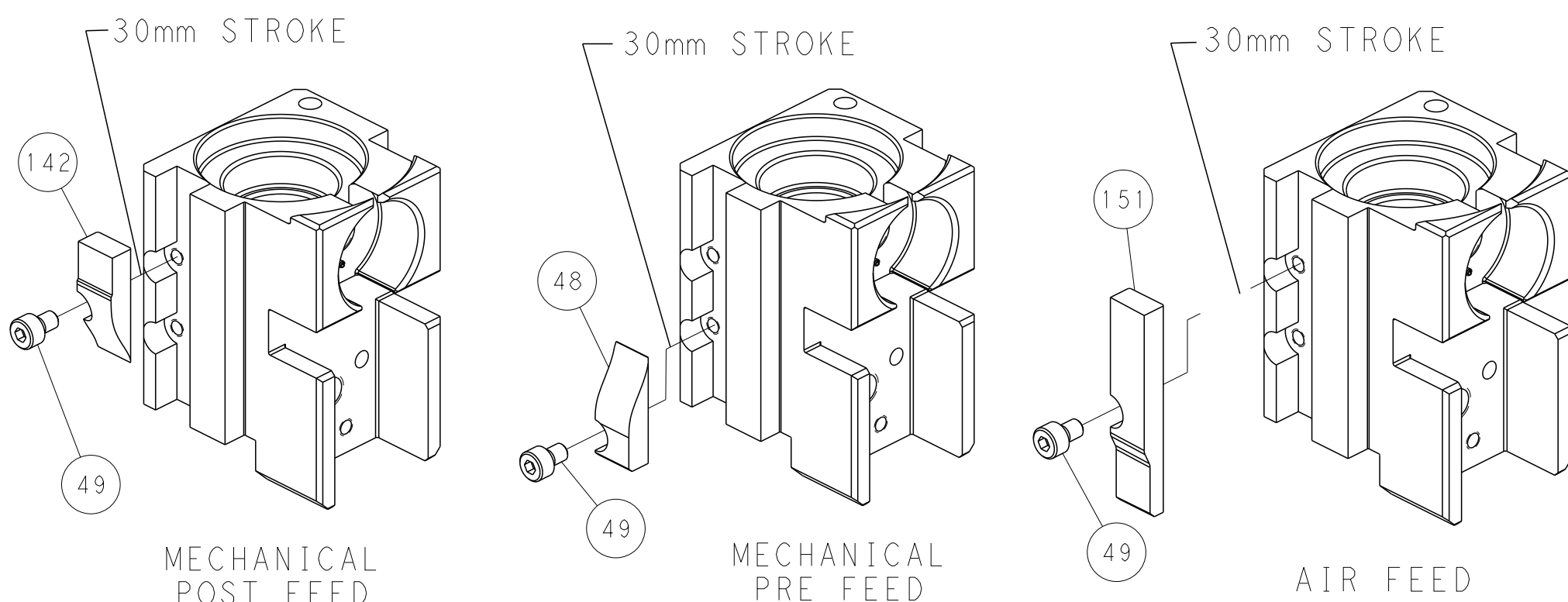
PNEUMATIC



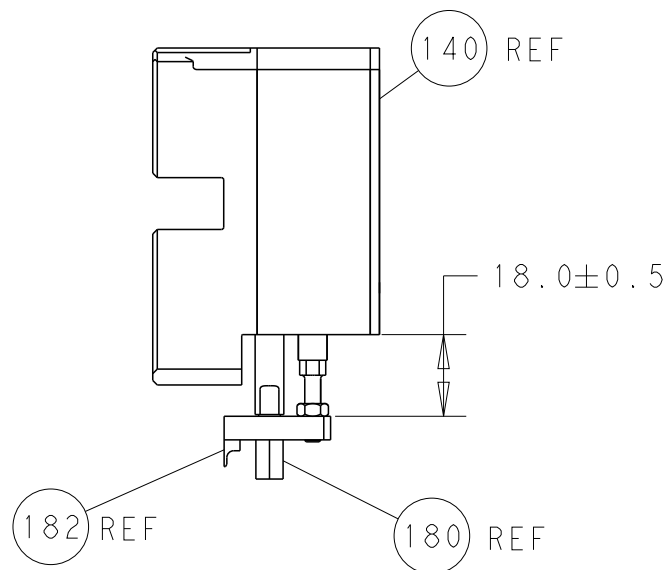
SERVO
LATCH PLATE



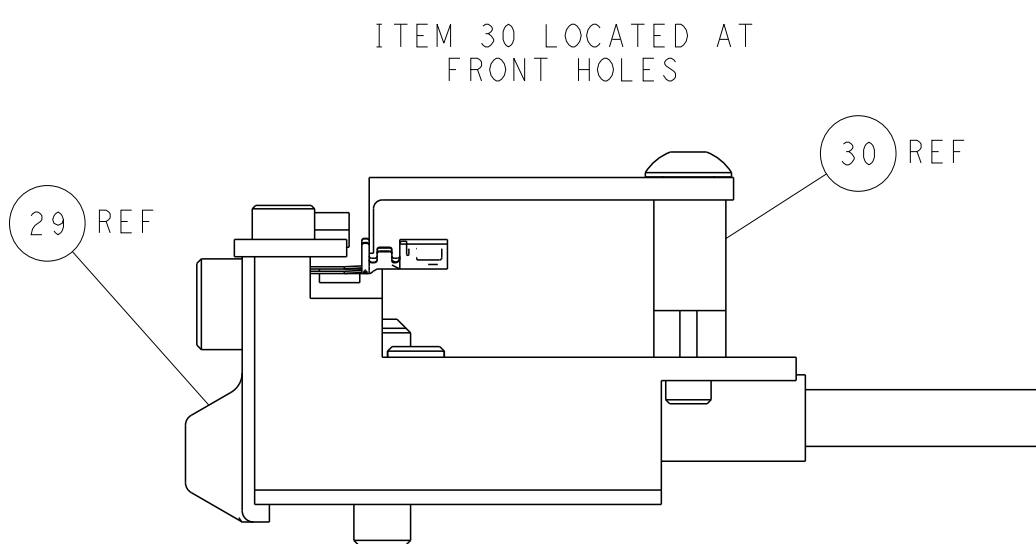
CAM POSITIONS



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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		CHK	L. ZHANG	29MAR2017	Harrisburg, PA 17105-3608	
		APVD	L. ZHANG	29MAR2017	NAME	
		PRODUCT SPEC			Ocean Side Feed	
		APPLICATION SPEC			Applicator	
		WEIGHT			RESTRICTED TO	
		Customer Accessible Production Drawing			REV A1	