

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART						
					CONVERT TO	PART NUMBERS REQUIRED					
	2836941-1	A	FINE CRIMP HEIGHT ADJUST	MECHANICAL	PNEUMATIC FEED	2119950-1	1338685-1	5-18022-5	2119641-1	2119799-1	2063440-1
					SERVO LATCH PLATE	2119951-1	-	8-2836941-5	1901094-3	-	2168400-6 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2836941-4	-	-	-
	2836941-2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-1	-	-
					SERVO LATCH PLATE	2119951-1	-	8-2836941-5	1901094-3	-	2168400-6 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2836941-4	-	-	-
	2836941-5	A	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE ⁴	MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-1	-	-
					PNEUMATIC FEED	2119950-1	1338685-1	5-18022-5	2119641-1	2119799-1	2063440-1
	2836941-6	A	NON-CRIMP HEIGHT ADJUST	SERVO LATCH PLATE ⁴	-	-	-	-	-	-	-
	2836941-7	A	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	-
	7-2836941-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.40 mm [.055]	F
INSUL	1.65 mm [.065]	O

APPLICATOR INSTRUCTIONS
408-10389

TERMINAL DATA: HU LANE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: 0.64 SERIES TERMINAL			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
3.57-4.33 mm [.141-.171 IN]		Ø1.22-1.63 mm [.048-.064 IN]	
TERMINAL APPLICATION SPECIFICATION	NONE		
TERMINALS APPLIED			
TE TERMINAL	HU LANE TERMINAL	TE TERMINAL	HU LANE TERMINAL
2318392-1	6805803KSS		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.50mm2	1.03+/-0.05 [.041+/-0.002]	9.3
0.35mm2	0.91+/-0.05 [.036+/-0.002]	10.8

- 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: 8-2836941-4
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2836941-4
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2836941-5
 SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2836941-6
- 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 4.77.

***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.

-77	-7	-6	-5	-2	-1	PART NO	DESCRIPTION	ITEM NO
-	-	1	-	-	-	2119957-2	APPLICATOR SHIM PACK	260

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	REV	DATE	BY	APPV
			A	RELEASED	270CT2017	TE

	-	1	-	1	1	1	8-21084-0	O-RING, .676 ID, .070 DIA. MAT.	252	
	-	-	-	-	1	-	2119640-1	PUSH ROD, AIR FEED	250	
	-	-	-	-	1	-	1803259-1	BUSHING, FLANGED	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	2119082-5	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	
	-	-	-	-	-	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	
	-	-	REF	REF	-	-	2119944-1	FEED FINGER ASSEMBLY, SF	117	
	-	1	1	1	1	1	455888-7	SPACER, CRIMPER	82	
	-	1	1	1	1	1	2119956-1	DOCUMENTATION PACKAGE	71	
	-	1	-	-	-	1	2119740-1	TAG, IDENTIFICATION	67	
	-	2	2	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66	
	-	1	-	-	-	1	2119793-1	LIMITER, ADJUSTMENT BOLT	63	
	-	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	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59	
	-	-	-	-	-	1	1338685-1	PAWL, FEED	56	
	-	4	4	4	4	4	2168400-1	SHCS, LOW HEAD, RoHS, M4 X 12	54	
	-	2	2	2	2	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	53	
	-	1	1	1	1	1	5018030-1	NUT, HEX, REG, RoHS, M3	52	
	-	1	1	1	1	1	811242-5	BUMPER, HOLD DOWN	51	
	-	1	1	1	1	1	690753-2	SPACER, TONKER	50	
	-	-	-	-	-	1	2	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	1	2119656-9	APPLICATOR BASIC ASSEMBLY, SF	46	
	-	1	-	-	-	1	2119370-1	RAM, AMP STYLE, SIDE FEED	44	
	-	1	1	1	1	1	2079383-7	SCR, BHSC, RoHS (M8 X 25)	41	
	-	1	-	-	-	1	2119645-1	DISC, NUMBERED FA WIRE ADJUSTMENT	40	
	-	1	-	-	-	1	2119957-1	APPLICATOR SHIM PACK	39	
	-	1	1	1	1	1	1-2119644-2	RAM WASHER, PRECISION	38	
	-	1	1	1	1	1	2119085-1	FA HEAD, ATLANTIC STYLE	37	
	-	1	-	-	-	1	2119092-1	BOLT, ADJUSTMENT	35	
	-	1	1	1	1	1	3-1752356-4	SUPPORT, TERMINAL	34	
	-	2	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33	
	-	1	1	1	1	1	2161328-1	HEX HEAD, FLANGED, M5 X 8mm LONG	32	
	-	1	1	1	1	1	1320908-3	SPACER, STRIP GUIDE	30	
	-	1	1	1	1	1	2119959-1	ASSEMBLY, STRIP GUIDE	29	
	-	1	1	1	1	1	455888-3	SPACER, CRIMPER	28	
	-	1	1	1	1	1	1320928-2	STRIP GUIDE	24	
	-	1	1	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21	
	-	2	2	2	2	2	1-18028-2	WASHER, FLAT, REG M4	20	
	-	1	1	1	1	1	2119533-1	STRIPPER, SIDE FEED	19	
	-	1	1	1	1	1	2119806-1	INSERT, SHEAR	13	
	-	1	1	1	1	1	3-22280-3	SPRING, COMPRESSION	12	
	-	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	1803095-1	FLOATING SHEAR, FRONT	9	
	1	1	1	1	1	1	3-1803250-4	ANVIL, COMBINATION	8	
	-	-	-	-	-	-	-	-	7	
	-	-	-	-	-	-	-	-	6	
	-	1	1	1	1	1	2119757-4	DEPRESSOR, SHEAR	5	
	-	1	1	1	1	1	2-238011-8	BLOCK, CRIMPER SPACER	4	
	1	1	1	1	1	1	7-2119784-5	CRIMPER, INSULATION O PREMIUM	3	
	-	1	1	1	1	1	455888-3	SPACER, CRIMPER	2	
	1	1	1	1	1	1	1-456402-4	CRIMPER, WIRE PREMIUM	1	

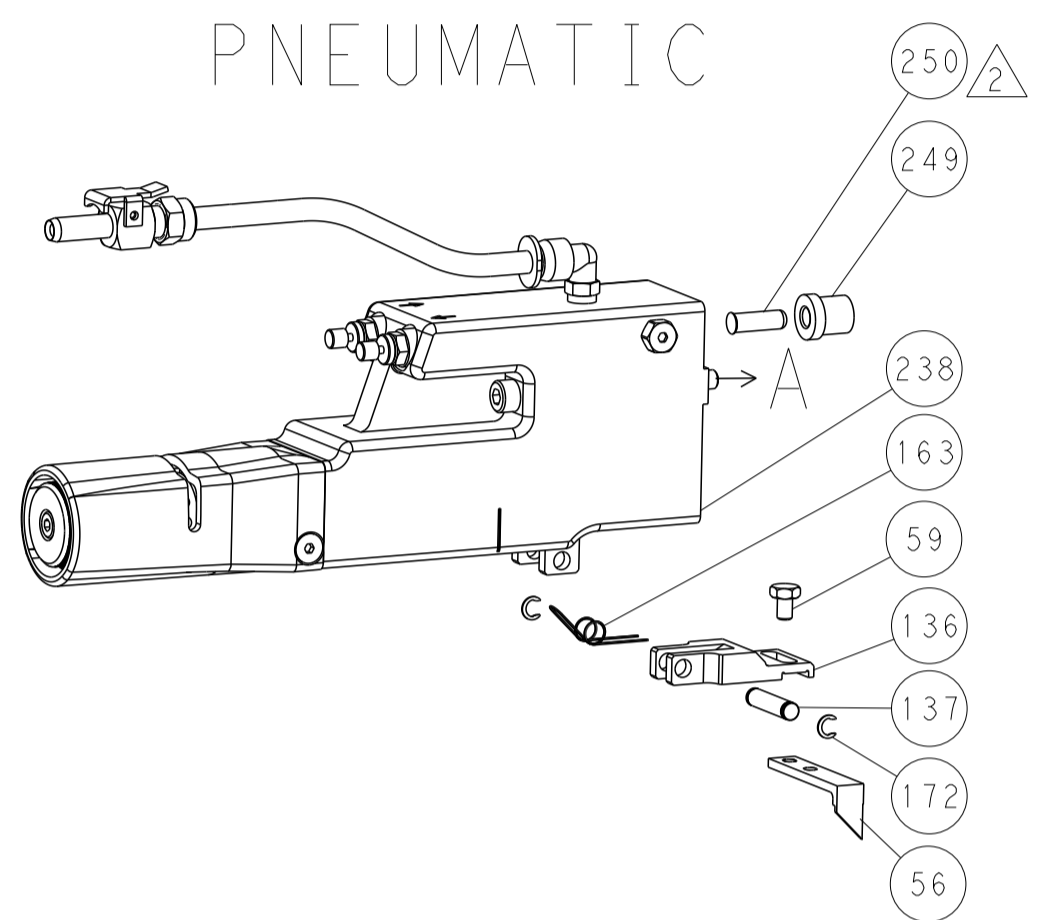
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mm	0 PLC	±									
	1 PLC	±									
	2 PLC	±									
	3 PLC	±									
	4 PLC	±									
	ANGLES	±									

LOC	DIST	REV	DATE	BY	APPV
A	66				

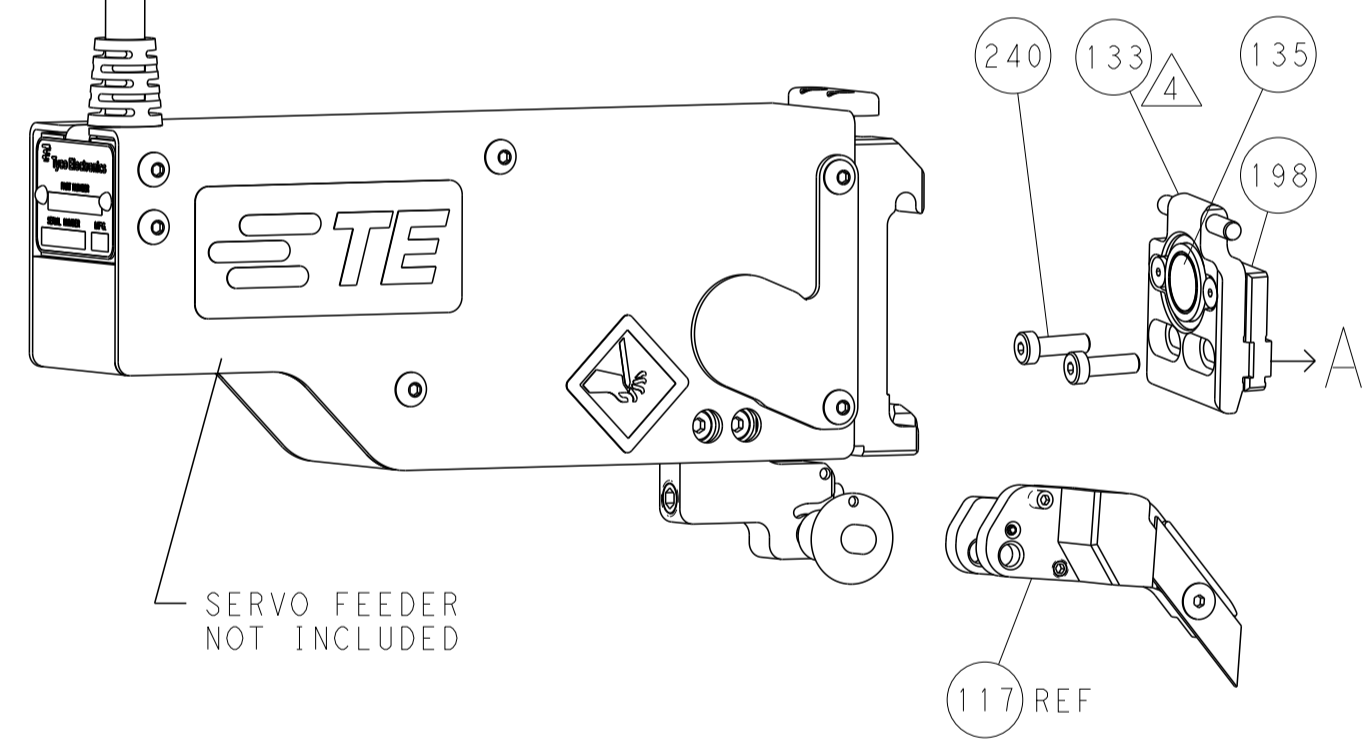
FEED TYPE MECHANICAL



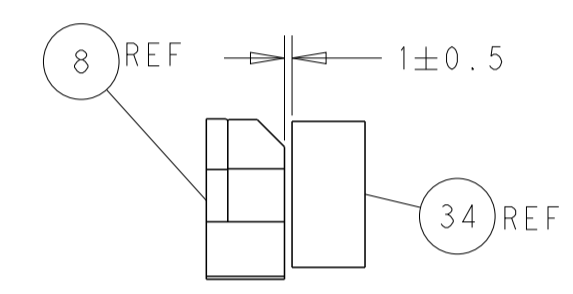
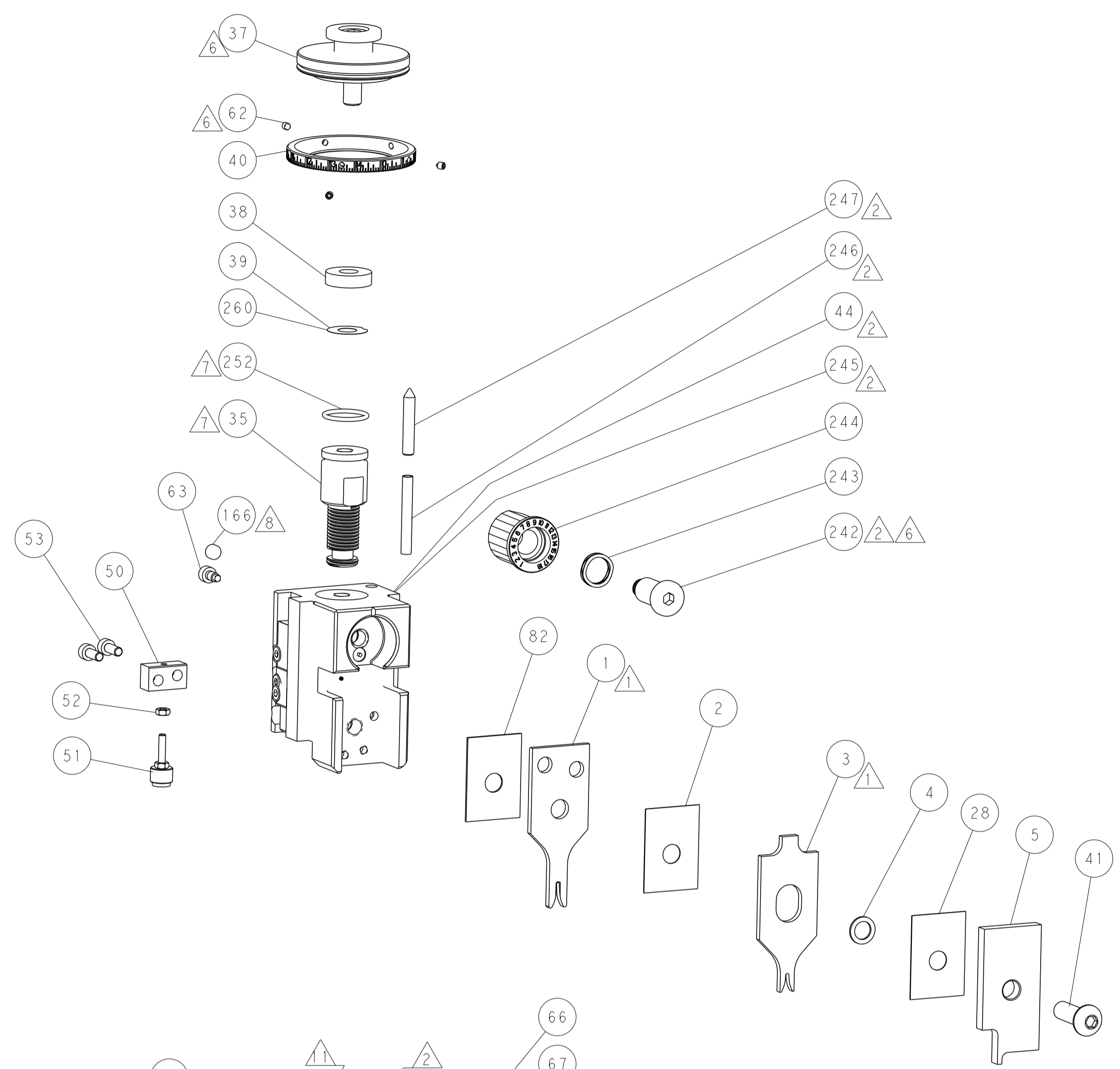
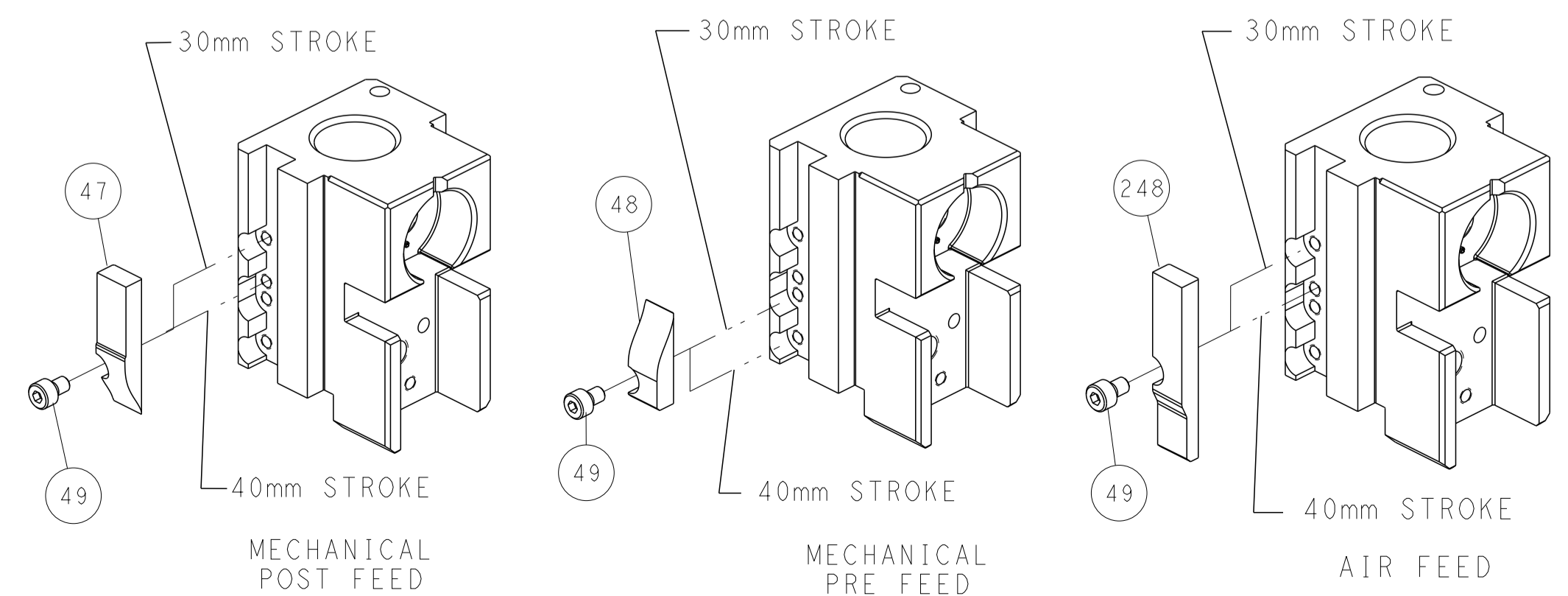
PNEUMATIC



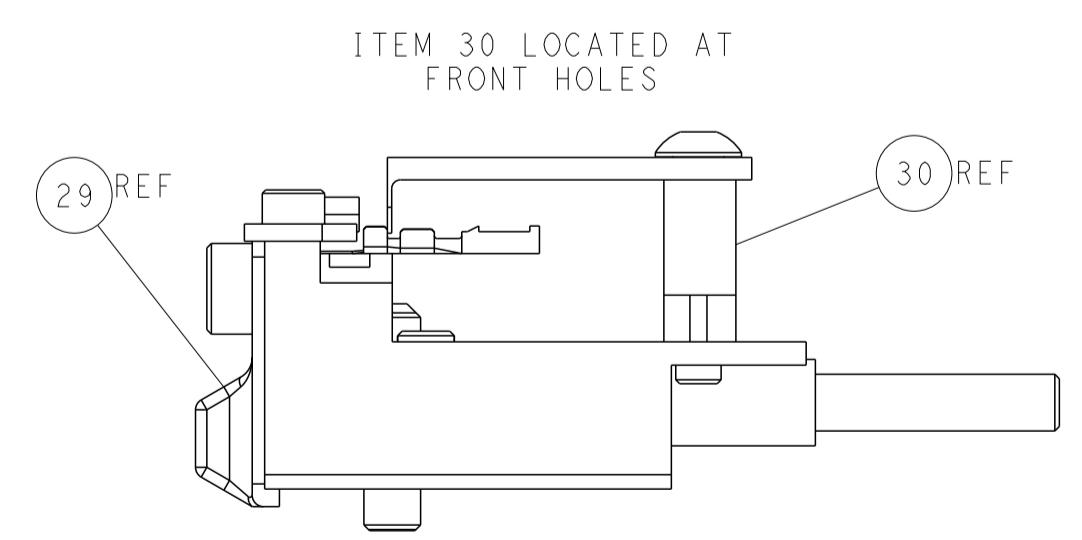
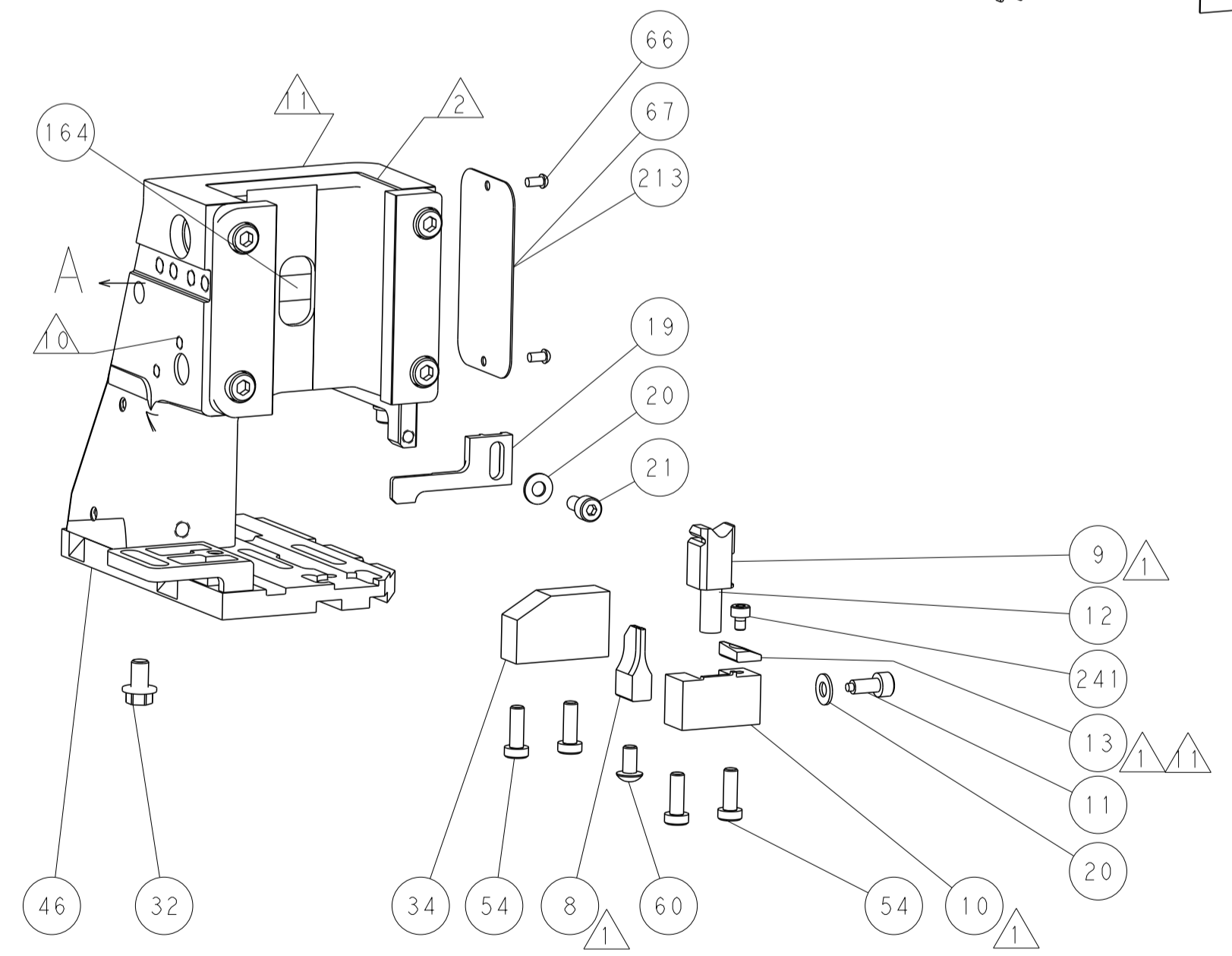
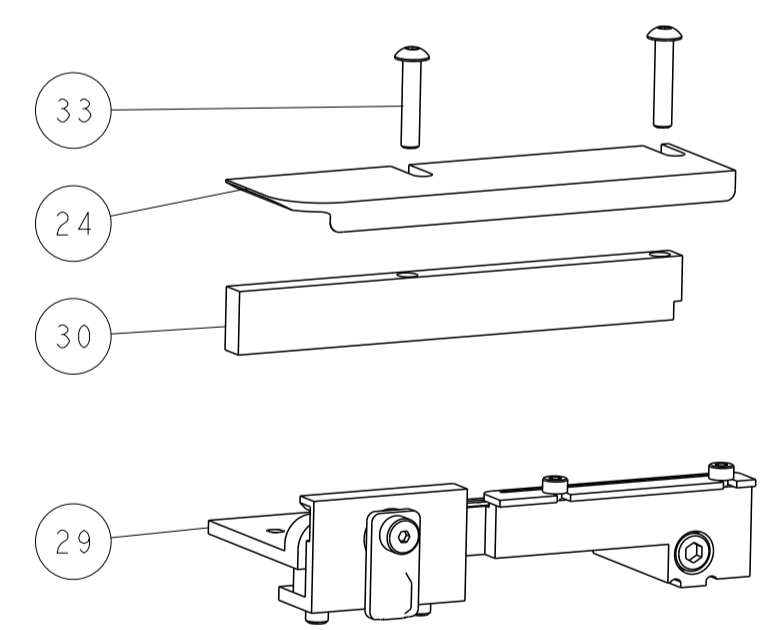
SERVO LATCH PLATE



CAM POSITIONS



TERMINAL SUPPORT LOCATION



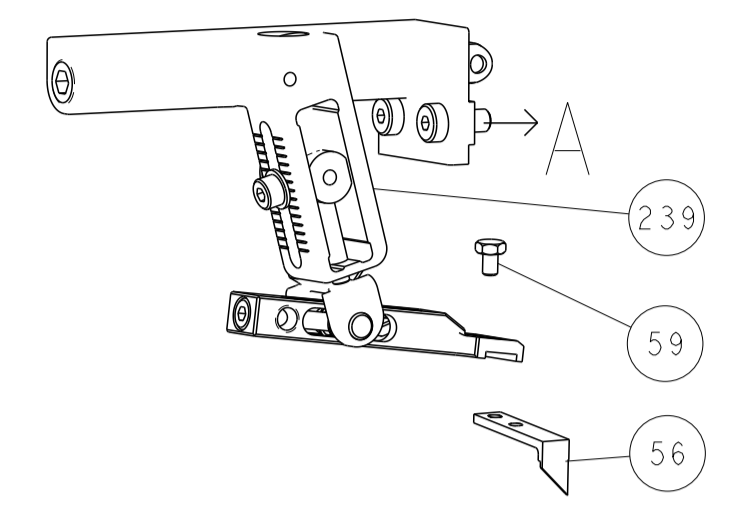
FEED TRACK POSITION GUIDE BY INSULATION BARREL

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

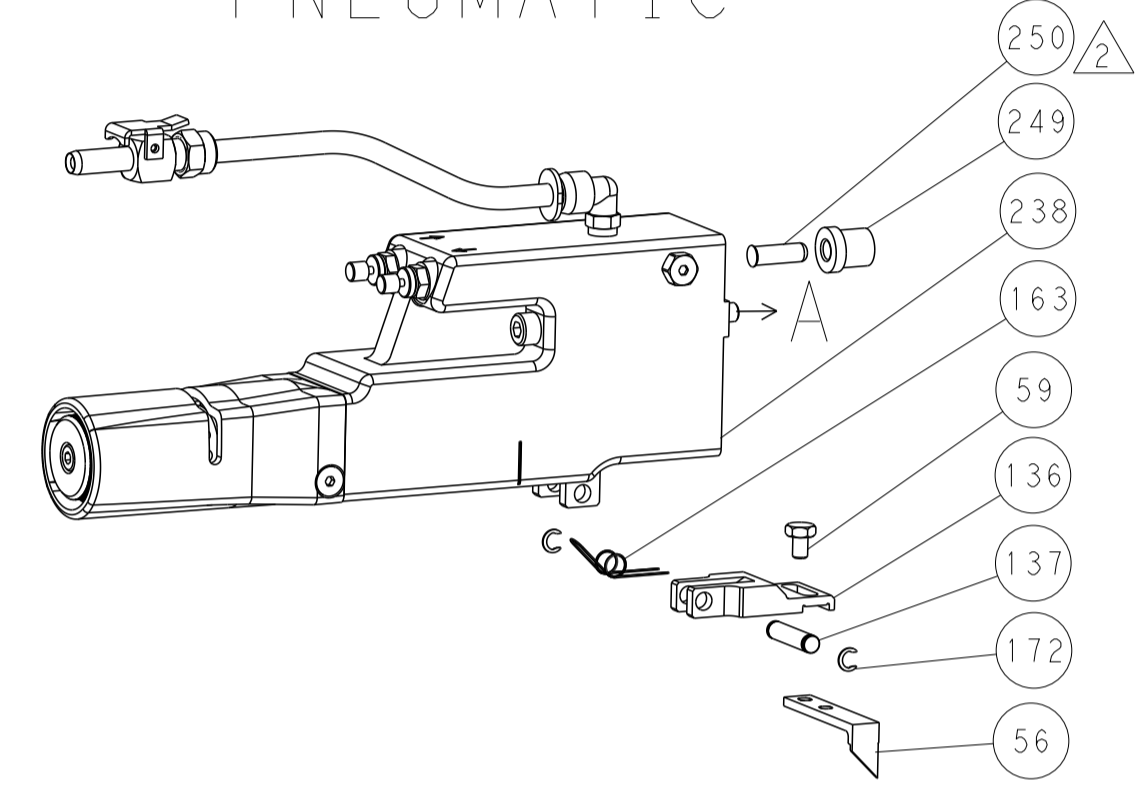
DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH		DWN H. HUANG 27SEP2017 CHK L. ZHANG 27SEP2017 APVD L. ZHANG 27SEP2017 PRODUCT SPEC APPLICATION SPEC WEIGHT Customer Accessible Production Drawing		NAME Ocean Side Feed Applicator SIZE CAGE CODE DRAWING NO A1 00779 C=2836941 SCALE 1:2 SHEET 2 OF 4 REV A		TE Connectivity Harrisburg, PA 17105-3608 RESTRICTED TO	
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LOC		DIST		REVISIONS			
A	66	P	LTM	DESCRIPTION	DATE	DWN	APVD
		-		SEE SHEET 1			

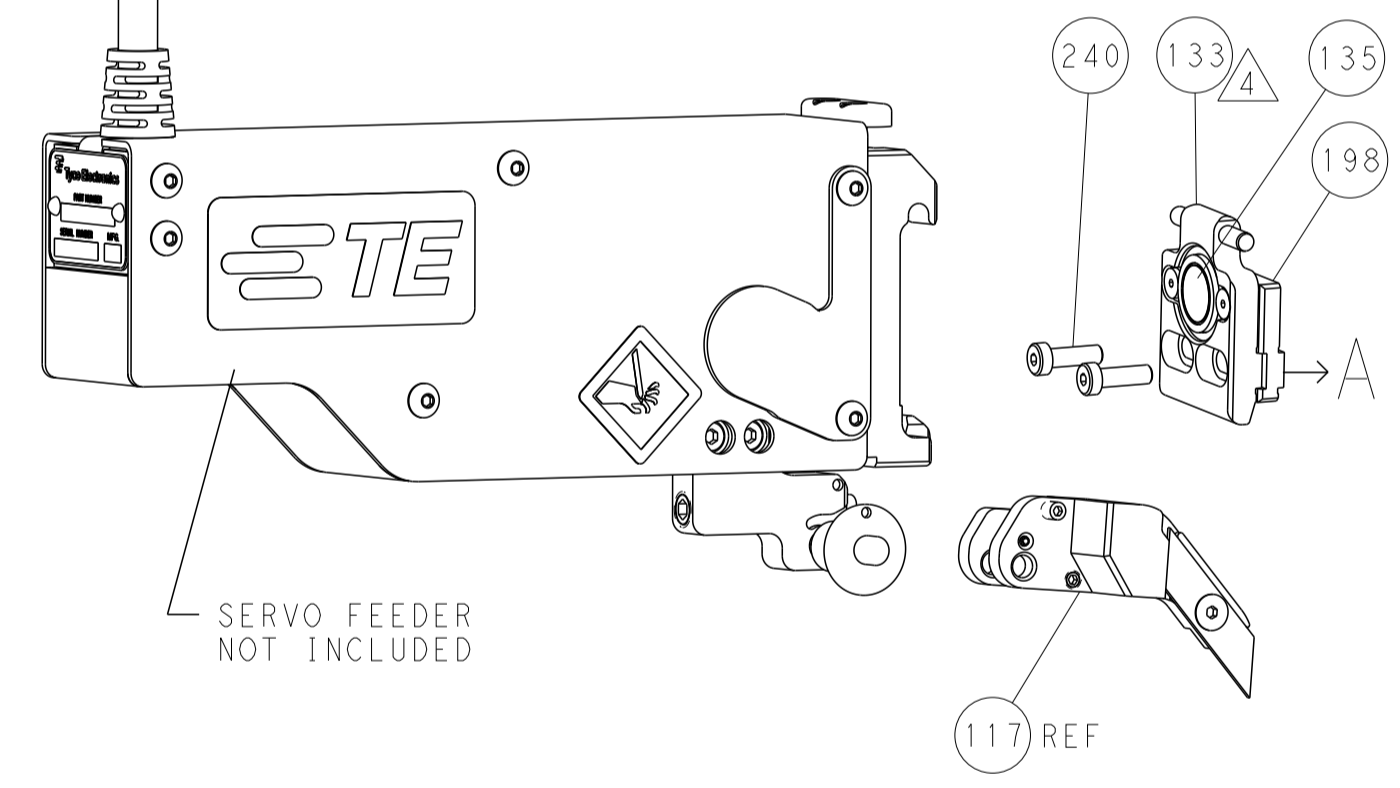
FEED TYPE MECHANICAL



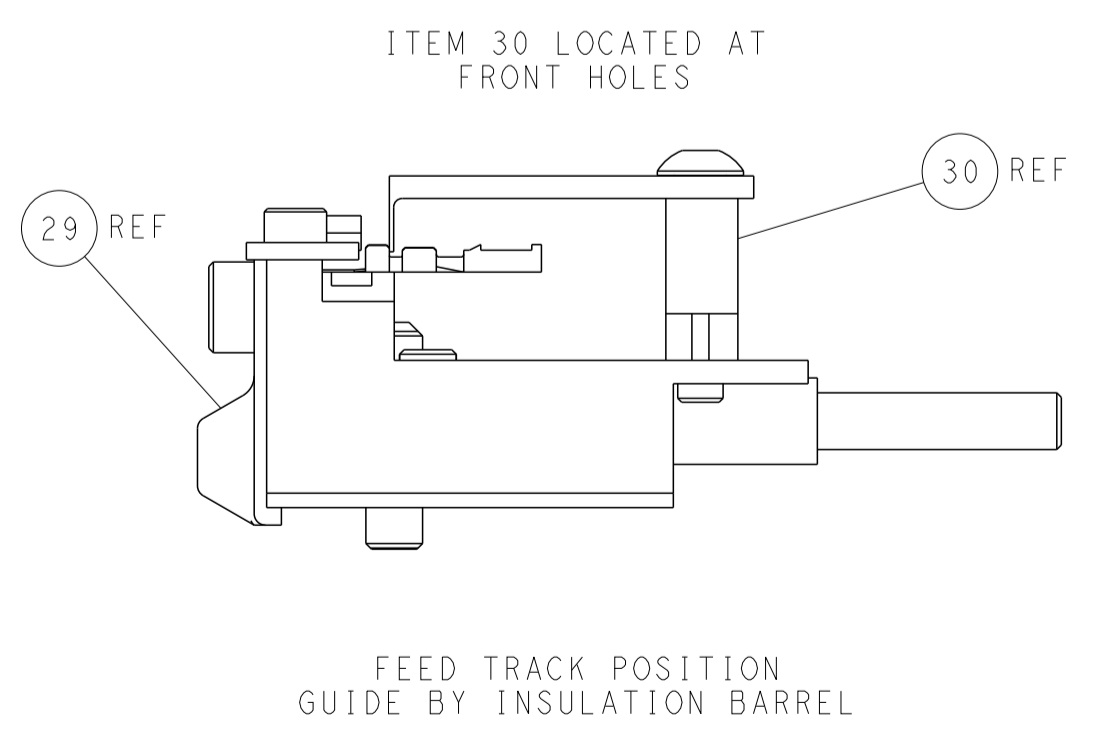
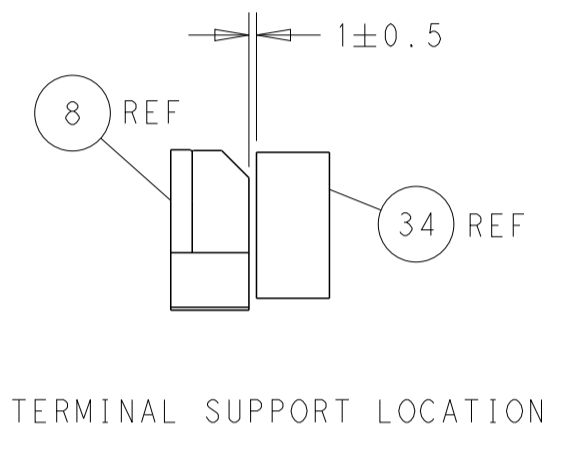
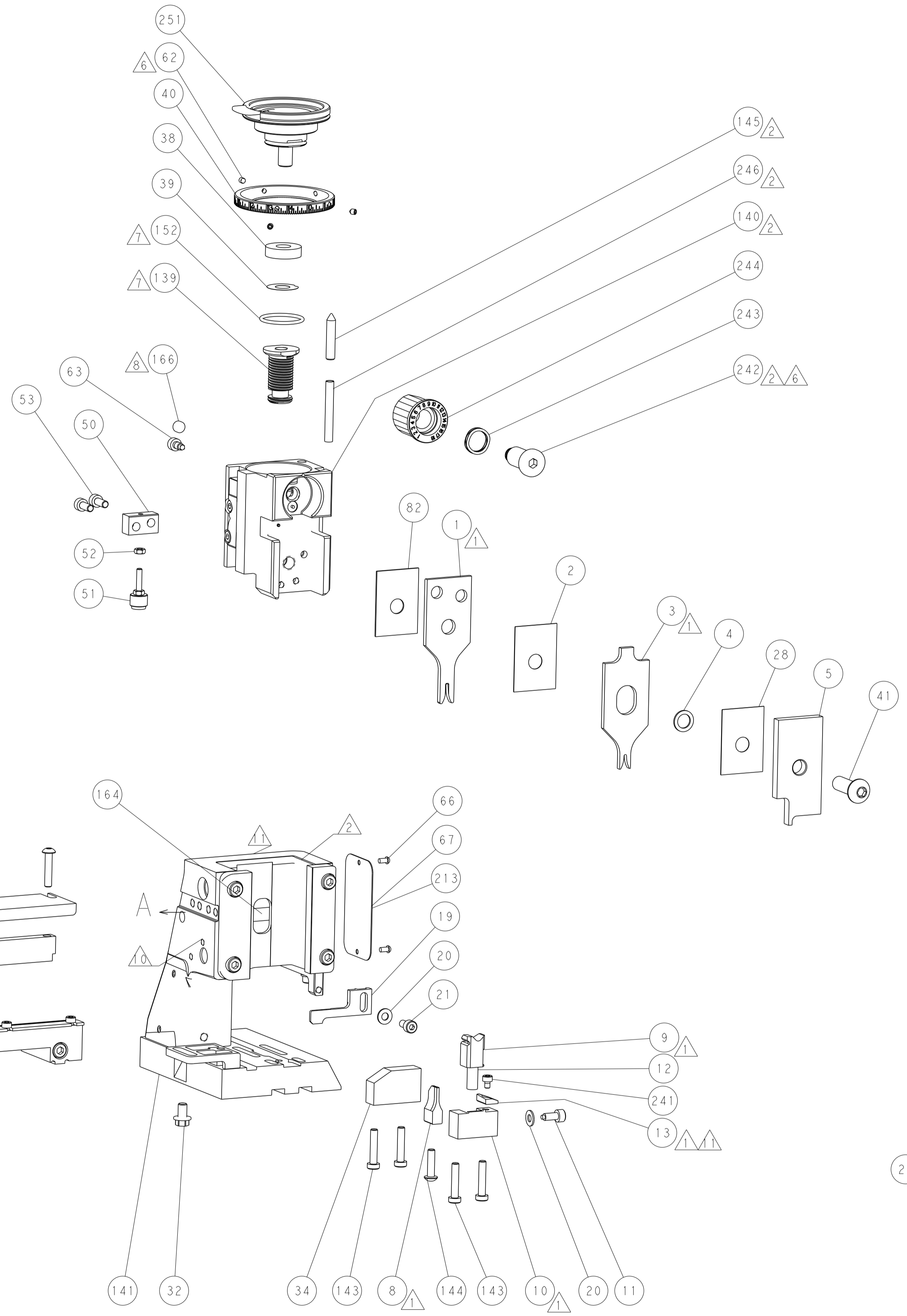
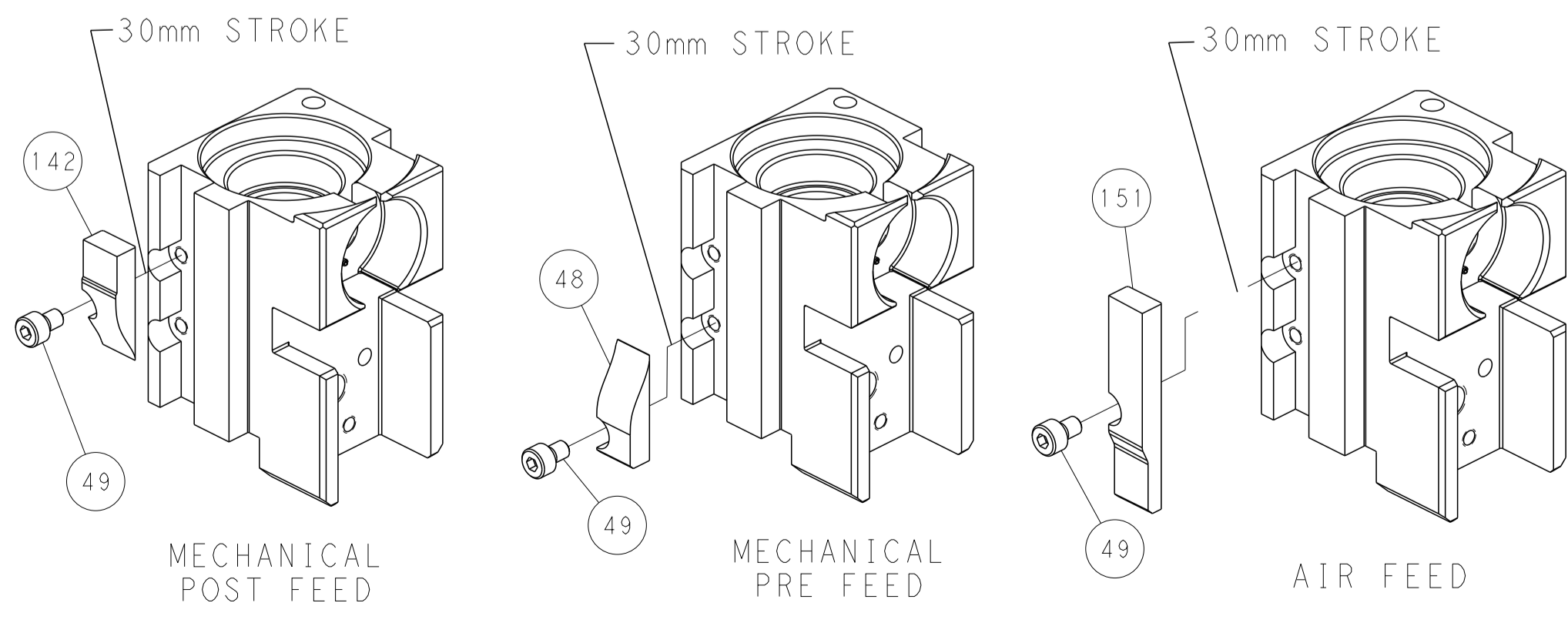
PNEUMATIC



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)

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DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH		NAME: Ocean Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2836941 SCALE: 1:2 SHEET: 4 OF 4 REV: A	RESTRICTED TO:
MATERIAL:		WEIGHT:	Customer Accessible Production Drawing

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