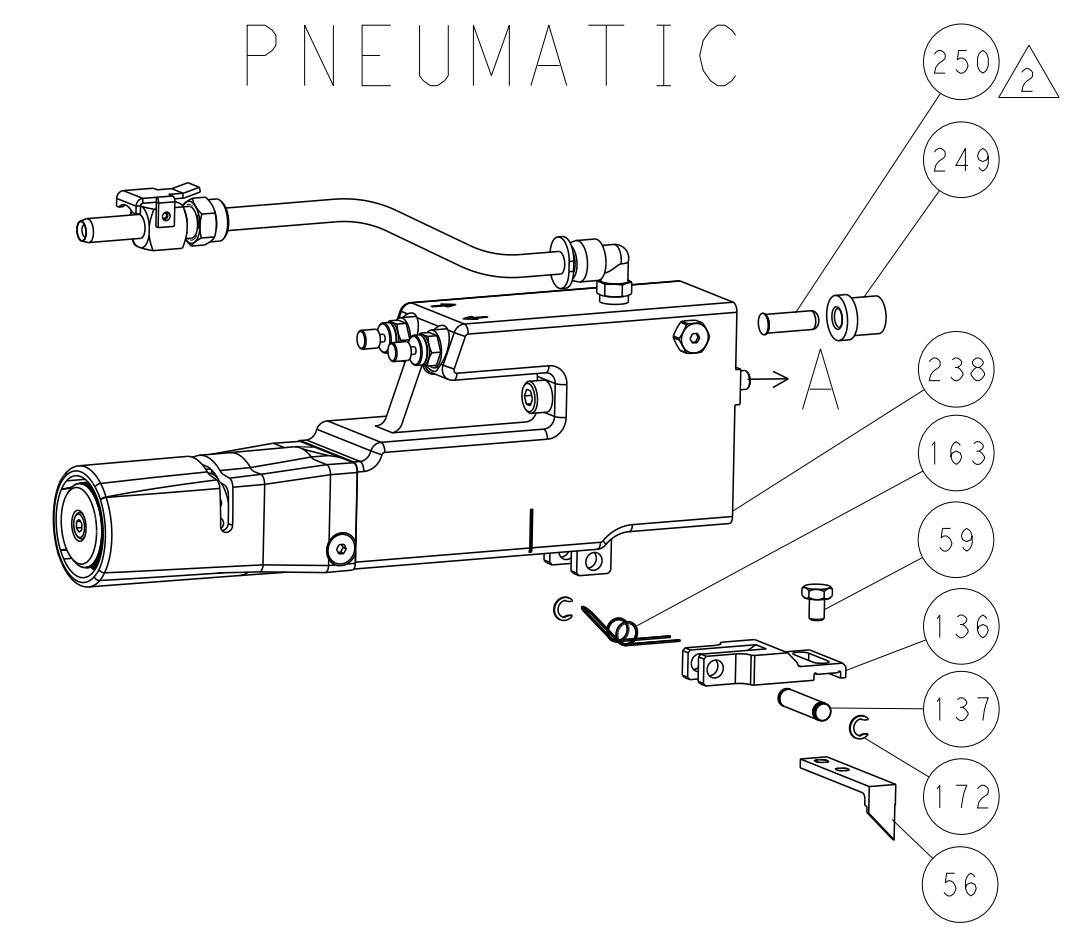


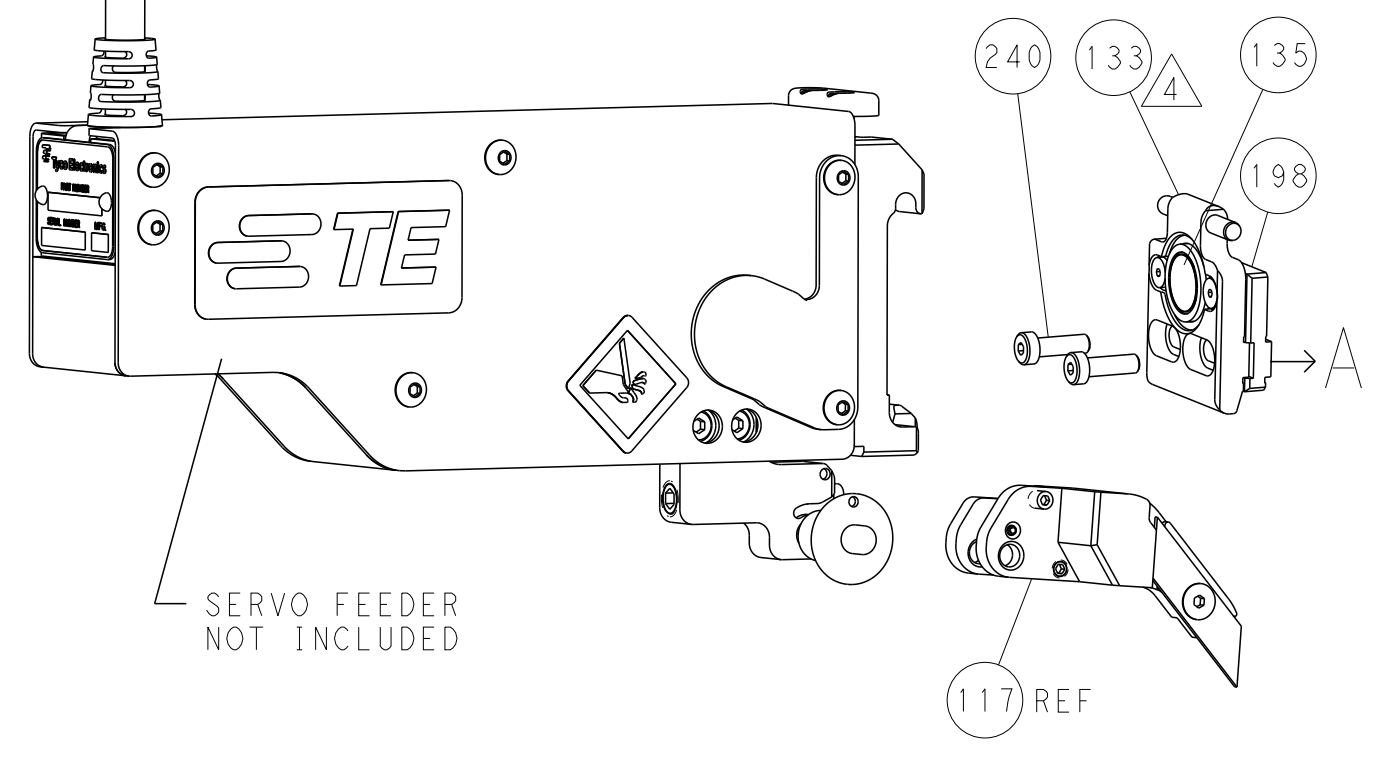
LOC		DIST		REVISIONS			
A	66	P	LYN	DESCRIPTION	DATE	DWN	APVD
		-		SEE SHEET 1			

FEED TYPE

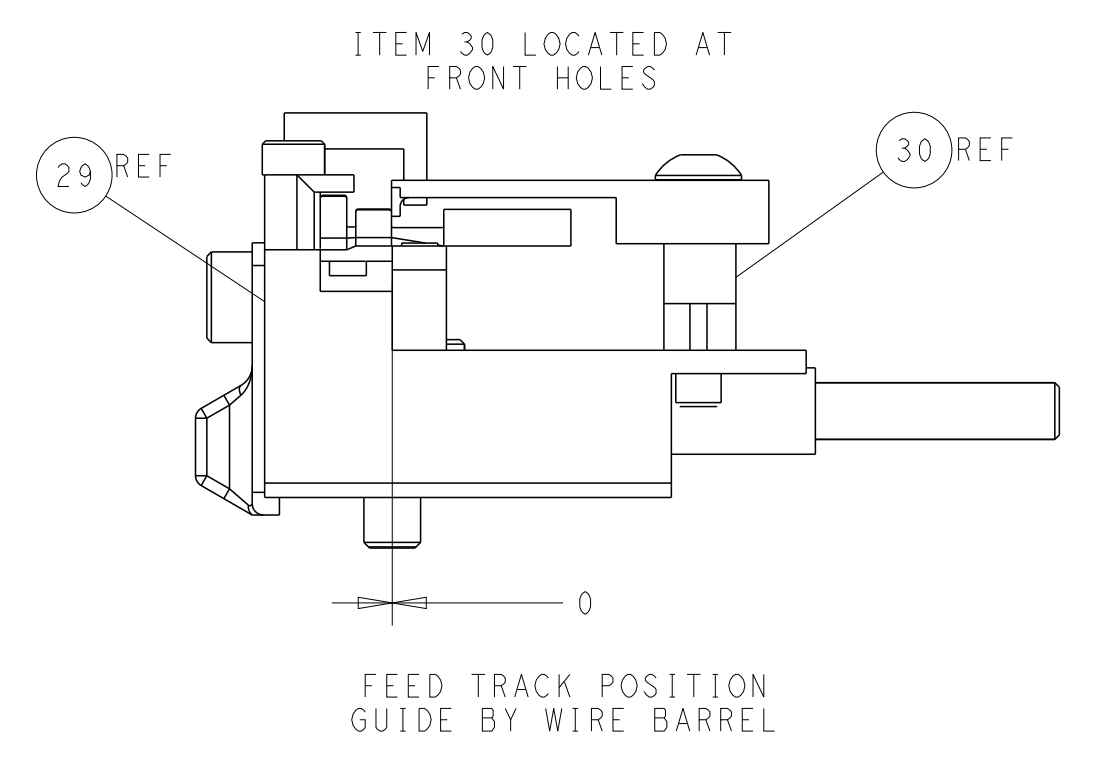
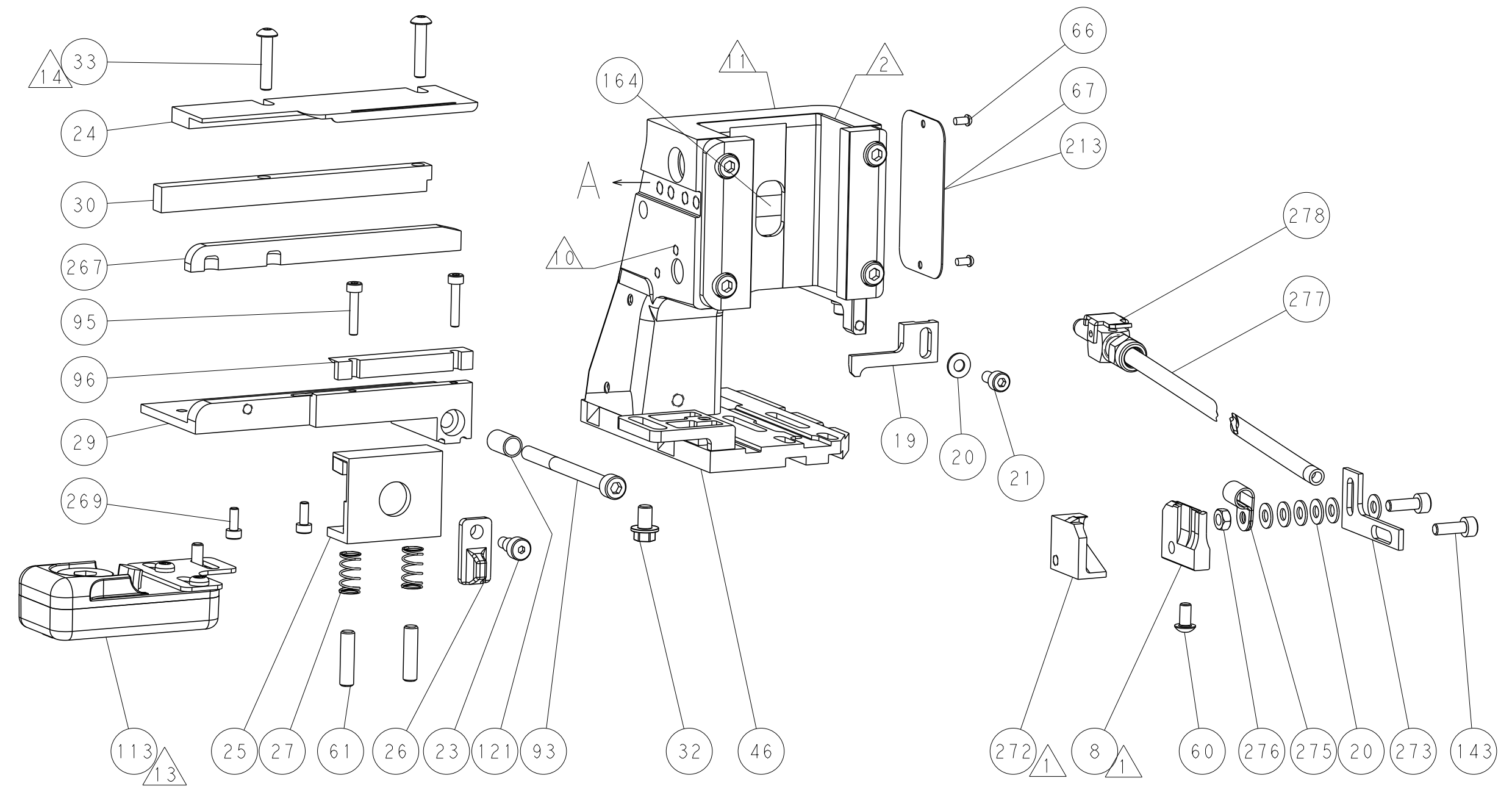
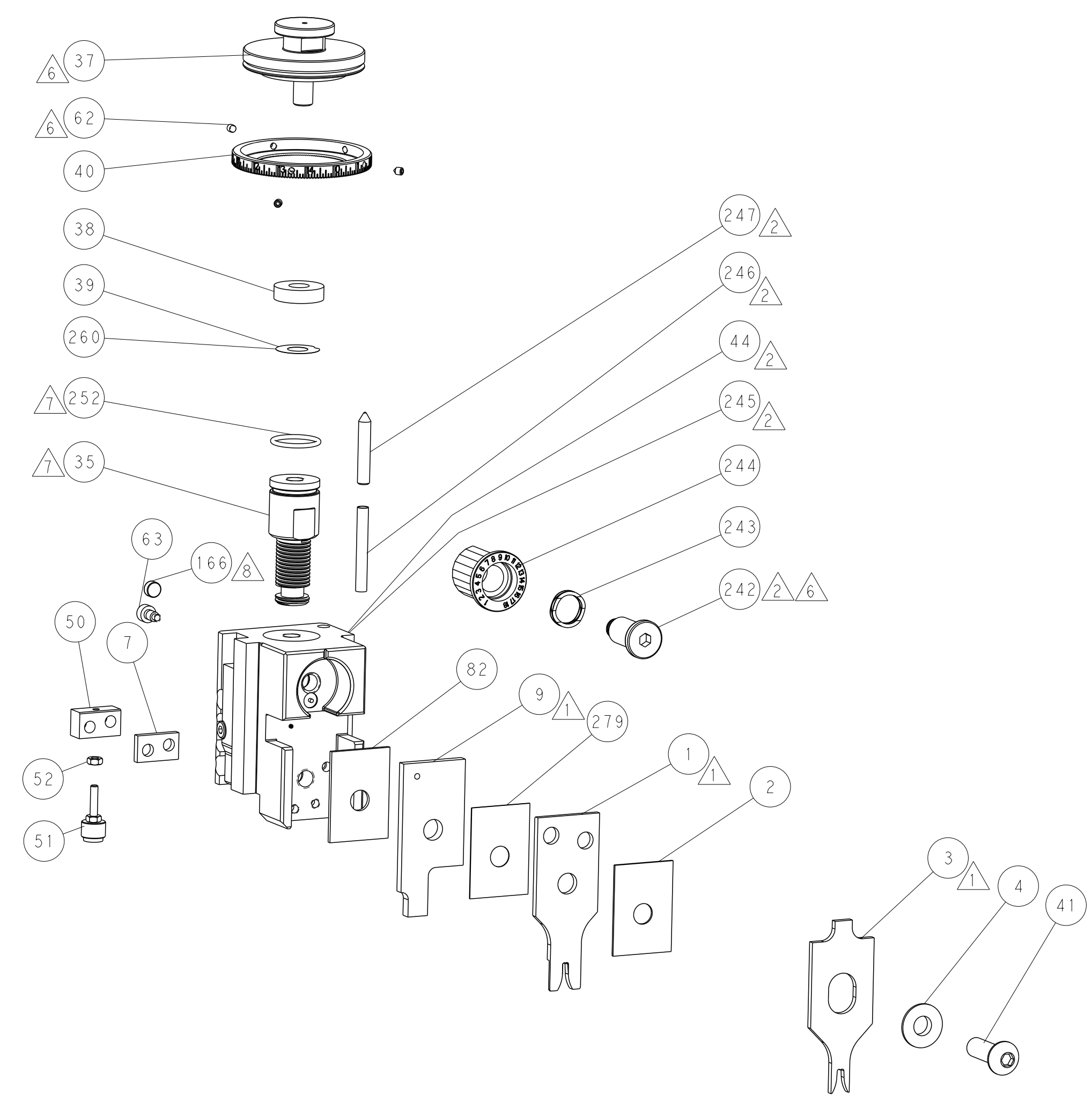
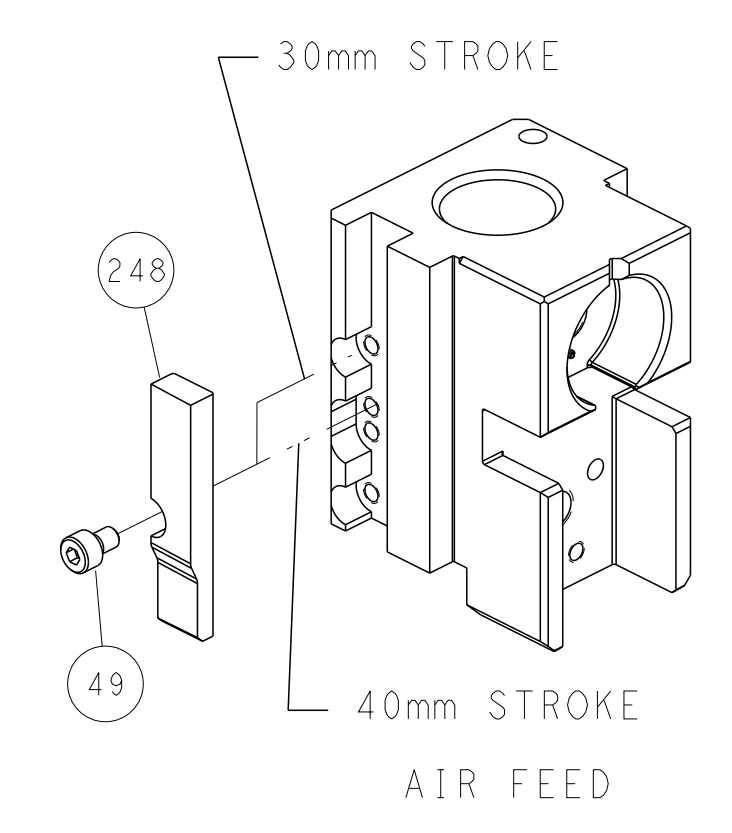
PNEUMATIC



SERVO LATCH PLATE



CAM POSITION



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: B. WEAVER 21OCT2015		TE Connectivity	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES ±	FINISH
MATERIAL:		WEIGHT:		SIZE:	CAGE CODE:	DRAWING NO:	RESTRICTED TO:
				A1	00779	©=2836084	
Customer Accessible Production Drawing				SCALE:	1:2	SHEET:	2 OF 4
SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION							

PACIFIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
	2-2836084-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
	2-2836084-5	B	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE ⁴
	2-2836084-7	B	FINE CRIMP HEIGHT ADJUST	NONE
	7-2836084-7	A	CRIMP TOOLING KIT	-

APPLICATOR DATA		
CRIMP SIZE	WIRE	TYPE
2.30 mm [0.91]	2.30 mm [0.91]	F
INSUL	3.10 mm [1.22]	F
APPLICATOR INSTRUCTIONS 408-10389		

TERMINAL DATA: MOLEX TERMINAL MOLEX CRIMP SPECIFICATION	
TERMINAL NAME: .093 DIA. PIN AND SOCKET	
WIRE STRIP LENGTH 3.96-5.54 mm [1.56-.218 IN]	INSULATION DIAMETER RANGE Ø1.65-2.79 mm [0.65-.110 IN]
TERMINAL APPLICATION SPECIFICATION ATS-638927100 Rev B	
TERMINALS APPLIED ¹⁰ ¹¹ ¹²	
TE TERMINAL	MOLEX TERMINAL
1572331-1	02-09-2101
1572331-2	02-09-6100
1572331-3	02-09-6101
1572332-1	02-09-1102
1572332-2	02-09-5100
1572332-3	02-09-5102
1572332-4	02-09-1205

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING ⁹
14 AWG OR 2.00mm ²	1.50+/-0.05 [0.059+/-0.002]	7.5
16 AWG OR 1.30mm ²	1.40+/-0.05 [0.055+/-0.002]	8.3
18 AWG OR 0.80mm ²	1.31+/-0.04 [0.052+/-0.002]	9.3
20 AWG OR 0.50mm ²	1.27+/-0.05 [0.050+/-0.002]	9.3



- 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:
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2836084-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2836084-5
- 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 TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- 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 TERMINAL LUBRICATION RECOMMENDED.
- ¹³ CUT AT ASSEMBLY.

APPLICATOR STYLE CONVERSION CHART						
CONVERT TO	PART NUMBERS REQUIRED					
SERVO LATCH PLATE	2119951-1	-	8-2836084-5	1901094-3	-	2168400-6 (QUANTITY 2)
SMART APPLICATOR	2161326-1	-	8-2836084-4	-	-	-
PNEUMATIC FEED	2119950-1	1338685-1	5-18022-5	2119641-2	2119799-1	2063440-1

***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	-27	-25	-22	PART NO	DESCRIPTION	ITEM NO
-	1	1	1	455888-3	SPACER, CRIMPER	279
-	1	1	1	23238-1	INSERT, COUPLING	278
-	1	1	1	2030758-3	TUBING, POLYURETHANE	277
-	1	1	1	5018030-2	NUT, HEX, REG, RoHS, M4	276
-	1	1	1	986220-3	CLAMP, CABLE, BLACK	275
-	1	1	1	2217068-1	BRACKET, AIR BLAST	273
-	1	1	1	2844234-1	PLATE, REAR SHEAR	272
-	2	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	269
-	1	1	1	1-1633782-4	FENCE	267

PACIFIC VERSION
Shown on sheets 3 of 4 & 4 of 4
(Atlantic version shown on sheets 1 of 4 & 2 of 4)

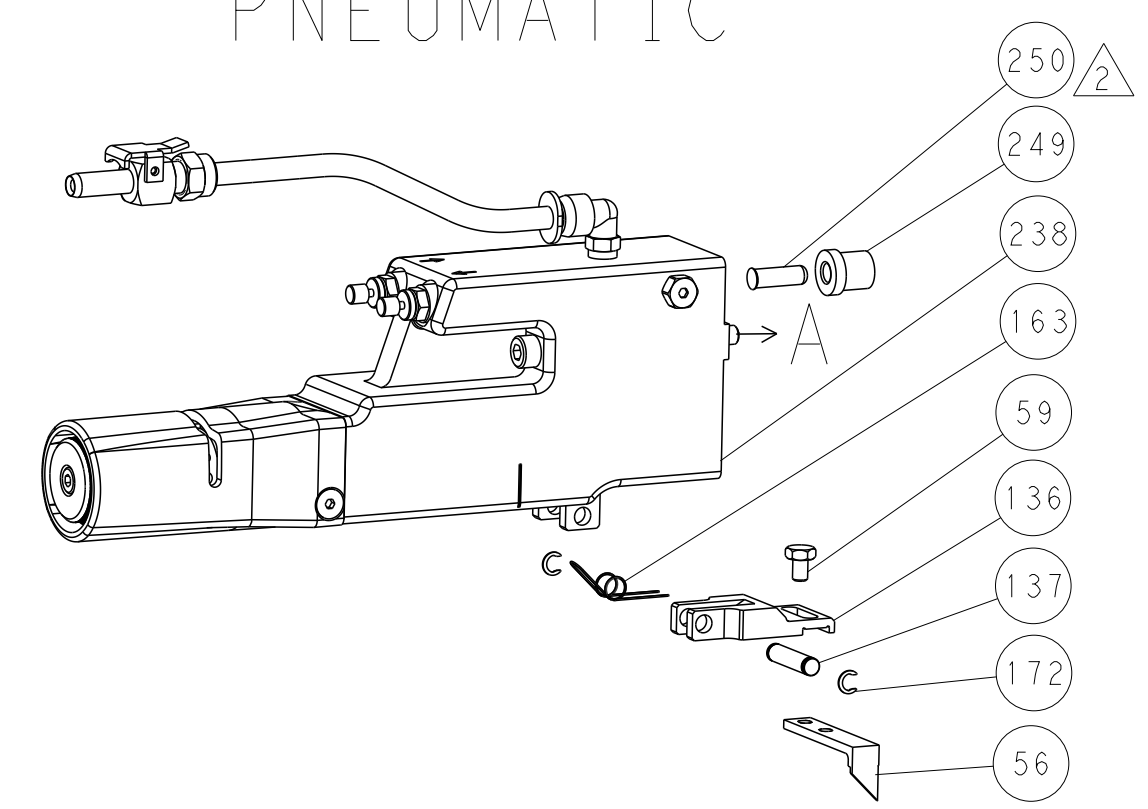
SET UP GAUGE	LOC	DIST	REVISIONS					
2119599-1	A	66	P	LTN	DESCRIPTION	DATE	OWN	APVD
-	-	-	-	-	SEE SHEET 1	-	-	-

-	1	1	1	2119782-1	FINE ADJUST HEAD ASM, PACIFIC STYLE	251
-	-	-	1	2119640-1	PUSH ROD, AIR FEED	250
-	-	-	1	1803259-1	BUSHING, FLANGED	249
-	1	1	1	1-22279-3	SPRING, COMPRESSION	246
-	1	1	1	2119082-7	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	-	2	-	2168400-6	SHCS, LOW HEAD, RoHS, M5 X 16	240
-	-	-	1	2063440-1	AIR FEED MODULE	238
-	-	-	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	994969-1	MAGNET, RARE EARTH HIGH ENERGY	166
-	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	-	-	1	240638-1	SPRING, FEED FINGER	163
-	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	2119798-2	DETENT PIN	145
-	1	1	1	2079383-8	SCR, BHSC, RoHS (M4 X 16)	144
-	2	2	2	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	143
-	1	1	1	1-2119656-0	APPLICATOR BASIC ASSEMBLY, SF	141
-	1	1	1	2119650-1	RAM, ASIAN STYLE, SIDE FEED	140
-	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
-	-	-	1	1633743-1	SERVO FEED LATCH ASM	133
-	1	1	1	1-22281-8	SPRING, COMPRESSION	121
-	-	REF	-	2119944-1	FEED FINGER ASSEMBLY, SF	117
-	1	1	1	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113
-	1	1	1	3-690712-7	FRONT STRIP GUIDE	96
-	2	2	2	1-2168083-3	SCR, SKT HD CAP, RoHS, M3 X 16	95
-	1	1	1	2168083-6	SCR, SKT HD CAP, RoHS, M5 X 65	93
-	1	1	1	1-455888-4	SPACER, CRIMPER	82
-	1	1	1	2119956-1	DOCUMENTATION PACKAGE	71
-	1	-	1	2119740-1	TAG IDENTIFICATION	67
-	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 POINT, M3 x 4.0	62
-	2	2	2	2-18032-5	SCR, SET, FLT POINT M5 X 20.0	61
-	-	-	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	-	-	1	1338685-1	PAWL, FEED	56
-	2	2	2	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	53
-	1	1	1	5018030-1	NUT, HEX, REG, RoHS, M3	52
-	1	1	1	811242-5	BUMPER, HOLD DOWN	51
-	1	1	1	690753-2	SPACER, TONKER	50
-	-	-	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	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	1-2119644-2	RAM WASHER, PRECISION	38
-	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	1	1	1	2161328-1	HEX HEAD, FLANGED, M5 x 8mm LONG	32
-	1	1	1	3-1320908-2	SPACER, STRIP GUIDE	30
-	1	1	1	2-1901086-2	PLATE, STRIP GUIDE	29
-	2	2	2	22281-8	SPRING, COMPRESSION	27
-	1	1	1	356835-1	LEVER, DRAG RELEASE	26
-	1	1	1	2-690754-1	DRAG, SPECIAL	25
-	1	1	1	1320860-2	STRIP GUIDE, REAR	24
-	1	1	1	980371-4	SCR, SKT HD SHLDR 5.0 DIA X 6.0	23
-	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
-	7	7	7	1-18028-2	WASHER, FLAT, REG M4	20
-	1	1	1	2119533-6	STRIPPER, SIDE FEED	19
-	-	-	-	-	-	10
-	1	1	1	4-853720-3	BLADE, SLUG	9
-	1	1	1	1633054-5	ANVIL, SPECIAL	8
-	1	1	1	240641-7	SPACER	7
-	-	-	-	-	-	6
-	-	-	-	-	-	5
-	1	1	1	238009-4	BLOCK, FL CRIMPER SPACER	4
-	1	1	1	8-1803016-8	CRIMPER, INSULATION F	3
-	1	1	1	455888-7	SPACER, CRIMPER	2
-	1	1	1	5-1803188-5	CRIMPER, WIRE	1

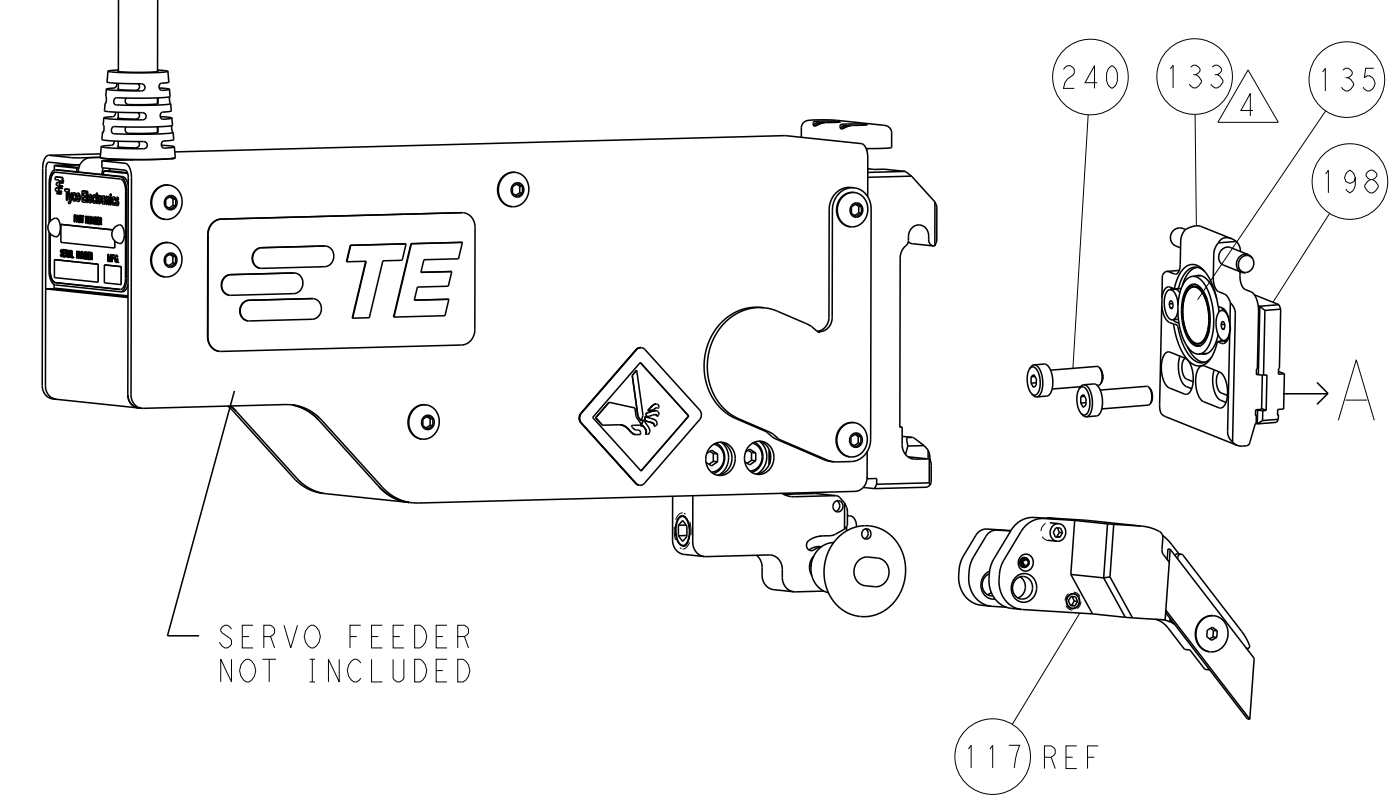
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG		NAME	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES ±	FINISH
MATERIAL	WEIGHT			SCALE	SHEET	OF	REV
	A1 00779			©=2836084	3	4	B

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

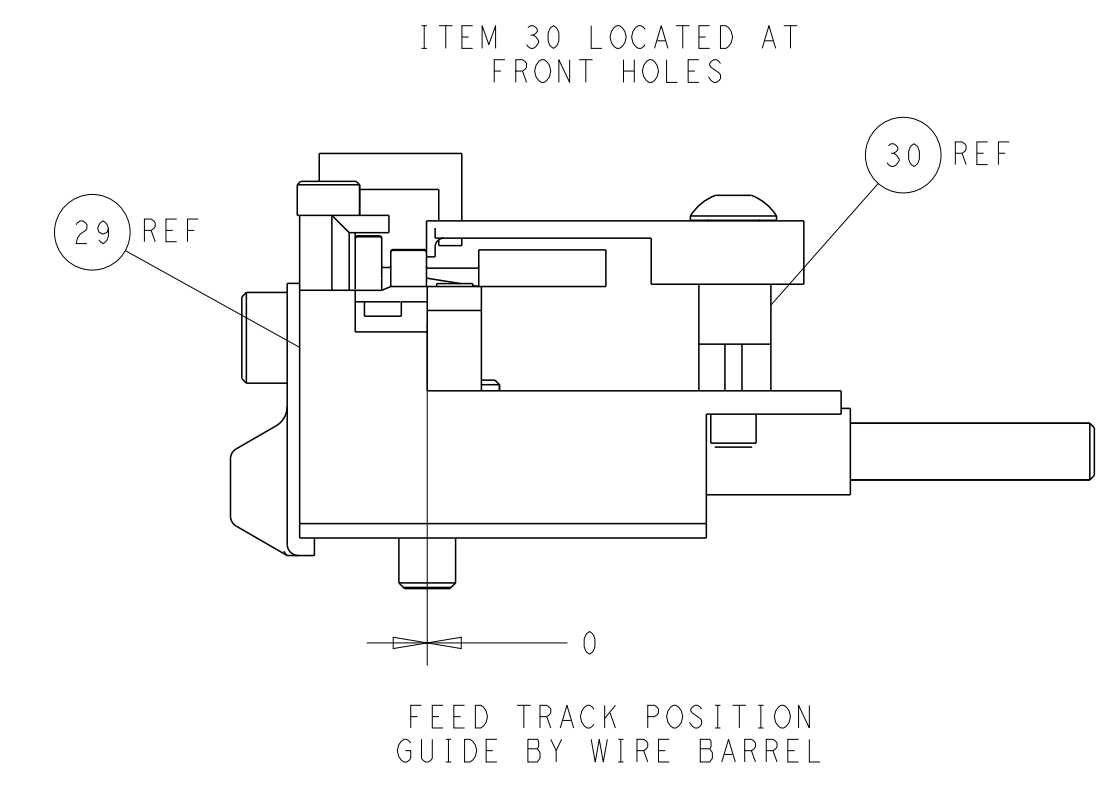
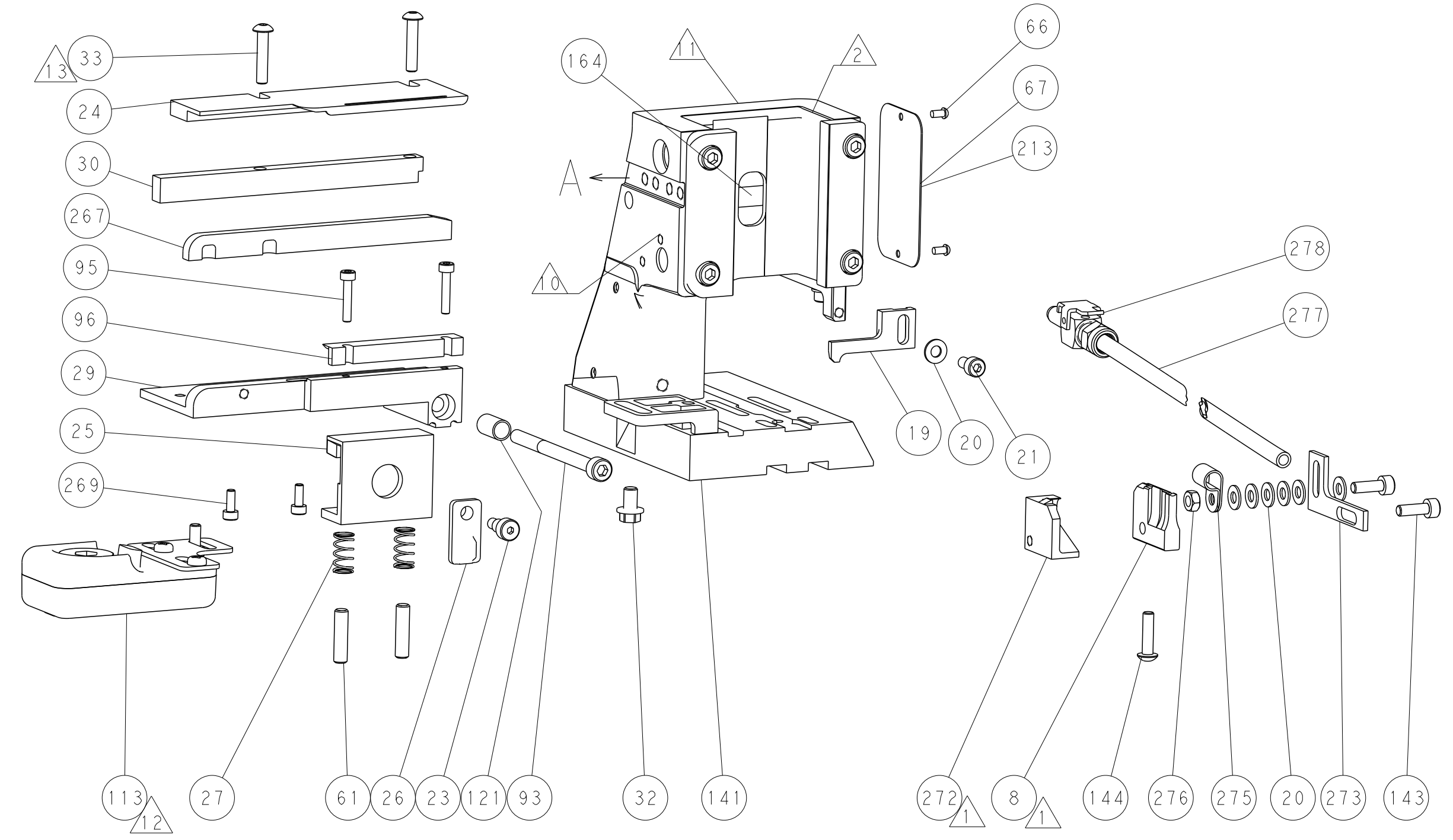
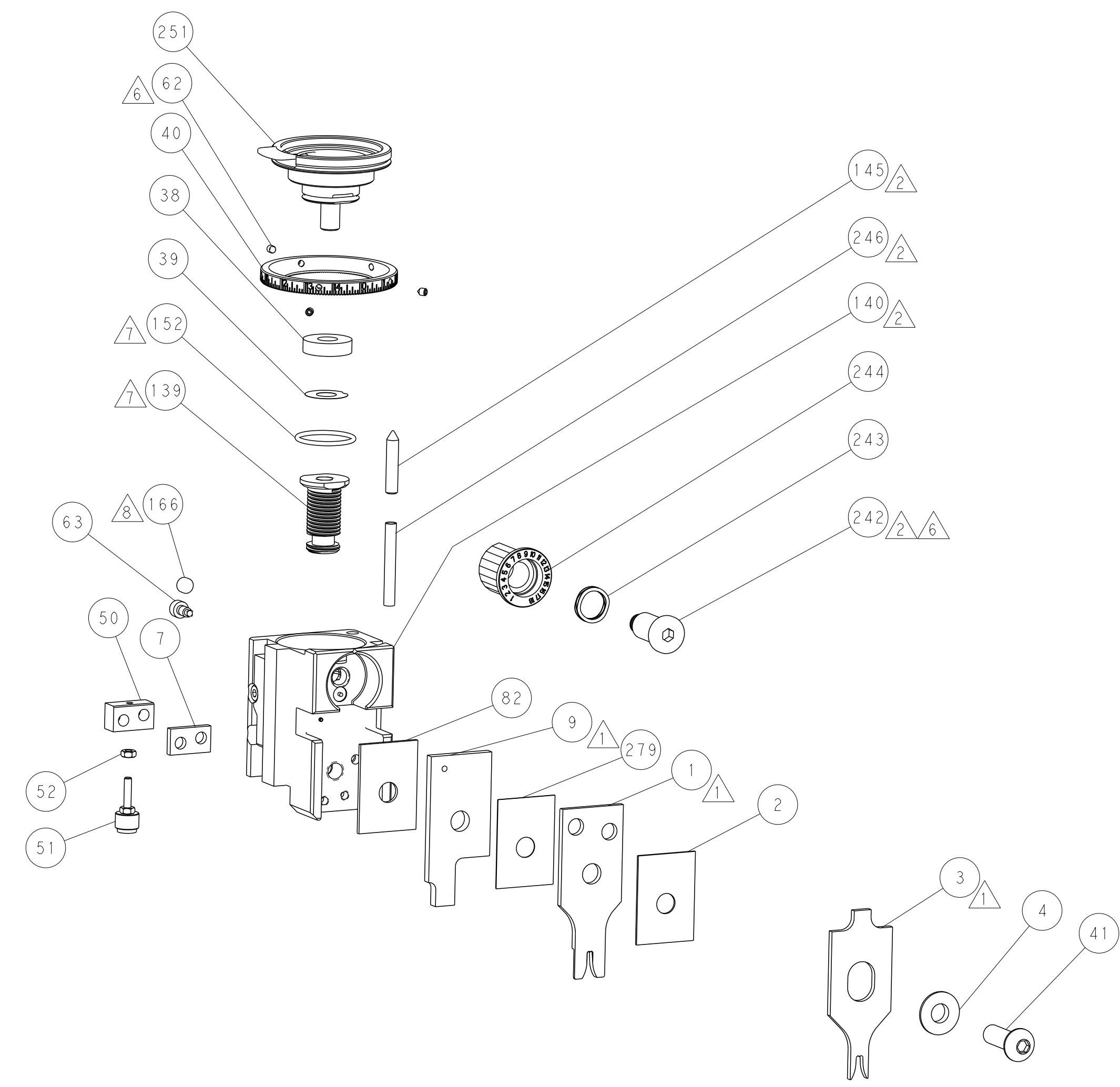
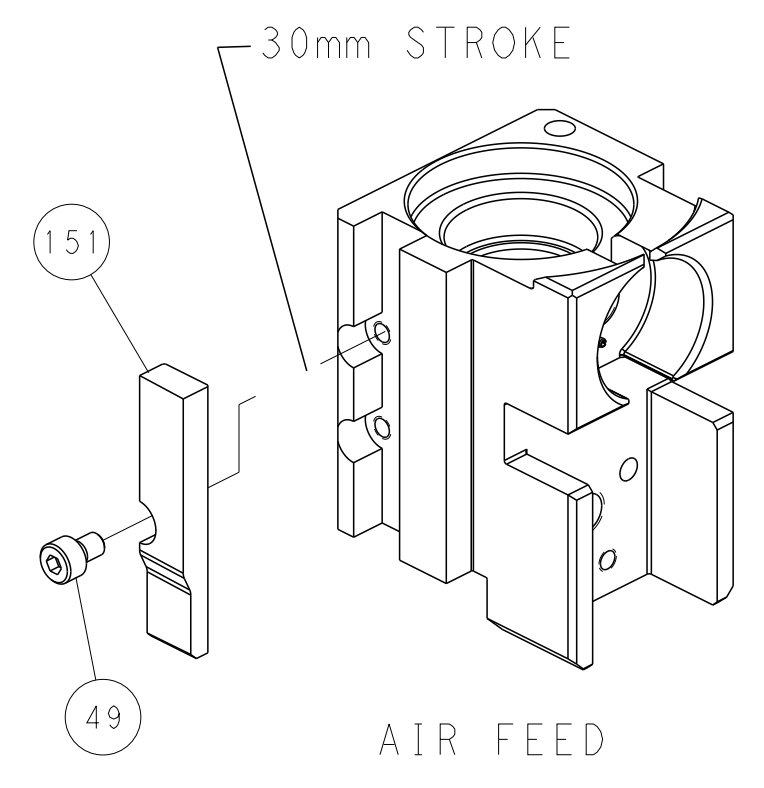
FEED TYPE PNEUMATIC



SERVO LATCH PLATE



CAM POSITION



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:		DWG: B. WEAVER 21OCT2015		TE Connectivity	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	5 PLC ±	Harrisburg, PA 17105-3608
MATERIAL:		FINISH:		CHK: G. BAILEY 21OCT2015		NAME: Ocean Side Feed Applicator	
				APVD: G. BAILEY 21OCT2015		RESTRICTED TO:	
				PRODUCT SPEC:		SIZE: A1	
				APPLICATION SPEC:		CAGE CODE: 00779	
				WEIGHT:		DRAWING NO: 2836084	
				Customer Accessible Production Drawing		SCALE: 1:2	
						SHEET 4 OF 4	
						REV B	