

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	CONVERT TO	PART NUMBERS REQUIRED					
	2836085-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL	PNEUMATIC FEED	2119950-1	1338685-1	5-18022-5	2119641-1	2119799-1	2063440-1
	2836085-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	SERVO LATCH PLATE	2119951-1	-	8-2836085-5	1901094-3	-	2168400-6 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2836085-4	-	-	
					MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-1	-	-
	2836085-5	C	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE <sup>4</sup>	SERVO LATCH PLATE	2119951-1	-	8-2836085-5	1901094-3	-	2168400-6 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2836085-4	-	-	
	2836085-6	C	NON-CRIMP HEIGHT ADJUST	SERVO LATCH PLATE <sup>4</sup>	-	-	-	-	-	-	-
2836085-7	C	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	-	
7-2836085-7	C	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-	

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.55 mm [0.061]	F
INSUL	-	-

APPLICATOR INSTRUCTIONS  
408-10389

TERMINAL DATA: HI-STAT TERMINAL		Season Group CRIMP SPECIFICATION	
TERMINAL NAME: TERMINAL, FEMALE			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
4.34-5.11 mm [0.171-0.201 IN]		1.30-1.60 mm [0.051-0.063 IN]	
TERMINAL APPLICATION SPECIFICATION	Season Group	-	-
TERMINALS APPLIED <sup>3</sup>			
TE TERMINAL	HI-STAT TERMINAL	TE TERMINAL	HI-STAT TERMINAL
2113919-1	503-607-10		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
20 AWG	1.25 +/- 0.05 [0.049 +/- 0.002]	9.0

- 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: 8-2836085-4  
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2836085-4  
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2836085-5  
 SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2836085-6
- 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 ITEM 62. 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 4.55.
- 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.

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

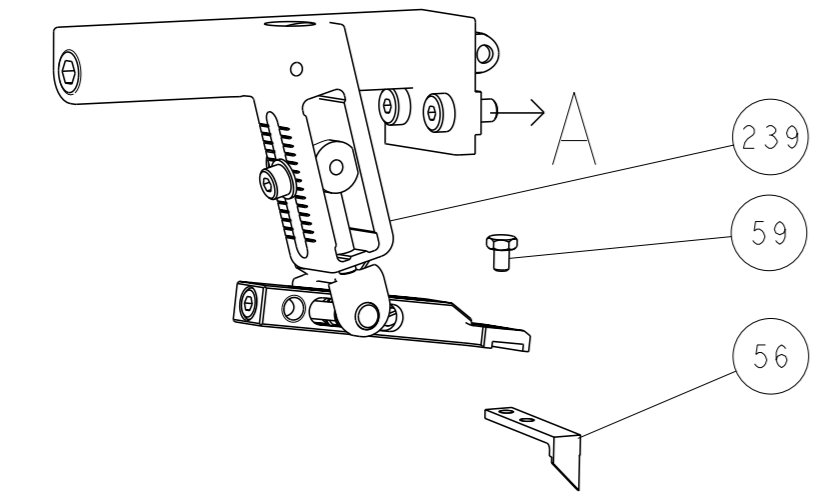
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			B	ECR-16-011879	18AUG2016	JH TE
			C	ECR-16-014690	17OCT2016	LG GB

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-	-	1	-	-	-
-	1	1	1	1	2119957-2
-	1	1	1	1	8-21084-0
-	-	-	1	-	2119640-1
-	-	-	1	-	2079988-1
-	-	-	1	-	2119641-1
-	1	1	1	1	2119798-1
-	1	1	1	1	1-22279-3
-	-	1	-	-	2119758-1
-	1	1	1	1	7-18023-7
-	-	2	2	-	2168400-6
-	-	-	-	1	2119580-1
-	-	-	-	1	2063440-1
-	-	1	1	-	2119740-2
-	-	1	1	-	1901094-3
-	-	-	2	-	21045-3
-	1	1	1	1	994969-1
-	REF	REF	REF	REF	994970-2
-	-	-	1	-	240638-1
-	-	-	1	-	3-23627-7
-	-	-	1	-	2119799-1
-	-	REF	REF	-	SEE NOTE 4
-	-	1	1	-	1633743-1
-	-	REF	REF	-	2119944-1
	1	1	1	1	2119955-1
-	1	1	1	1	455888-4
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-	1	1	1	1	2119791-9
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-	1	-	-	1	2119740-1
	2	2	2	2	2168078-1
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-	3	-	3	3	992763-5
-	1	1	1	1	2079383-4
-	-	-	-	1	5-18022-5
-	-	-	-	1	1338685-1
-	2	2	2	2	2168400-1
-	2	2	2	2	1-2168083-0
-	1	1	1	1	5018030-1
-	1	1	1	1	811242-5
-	1	1	1	1	690753-6
-	-	-	-	1	18023-9
-	-	-	-	1	2119652-1
-	-	-	-	1	2119653-1
-	1	1	1	1	2119656-9
-	1	-	1	1	2119370-1
-	1	1	1	1	2079383-7
-	1	-	1	1	2119645-1
-	1	-	1	1	2119957-1
-	1	1	1	1	2119644-1
	1	1	1	1	2119085-1
-	1	-	1	1	2119092-1
-	2	2	2	2	2079383-5
-	1	1	1	1	2161328-1
-	1	1	1	1	1320908-2
-	1	1	1	1	2119959-1
-	1	1	1	1	1320928-2
-	1	1	1	1	2168083-2
-	2	2	2	2	1-18028-2
-	1	1	1	1	2119533-9
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-	1	1	1	1	1-356885-4
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	1	1	1	1	318707-1
	1	1	1	1	6-1633933-6
-	-	-	-	-	-
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-77	-7	-6	-5	-2	-1

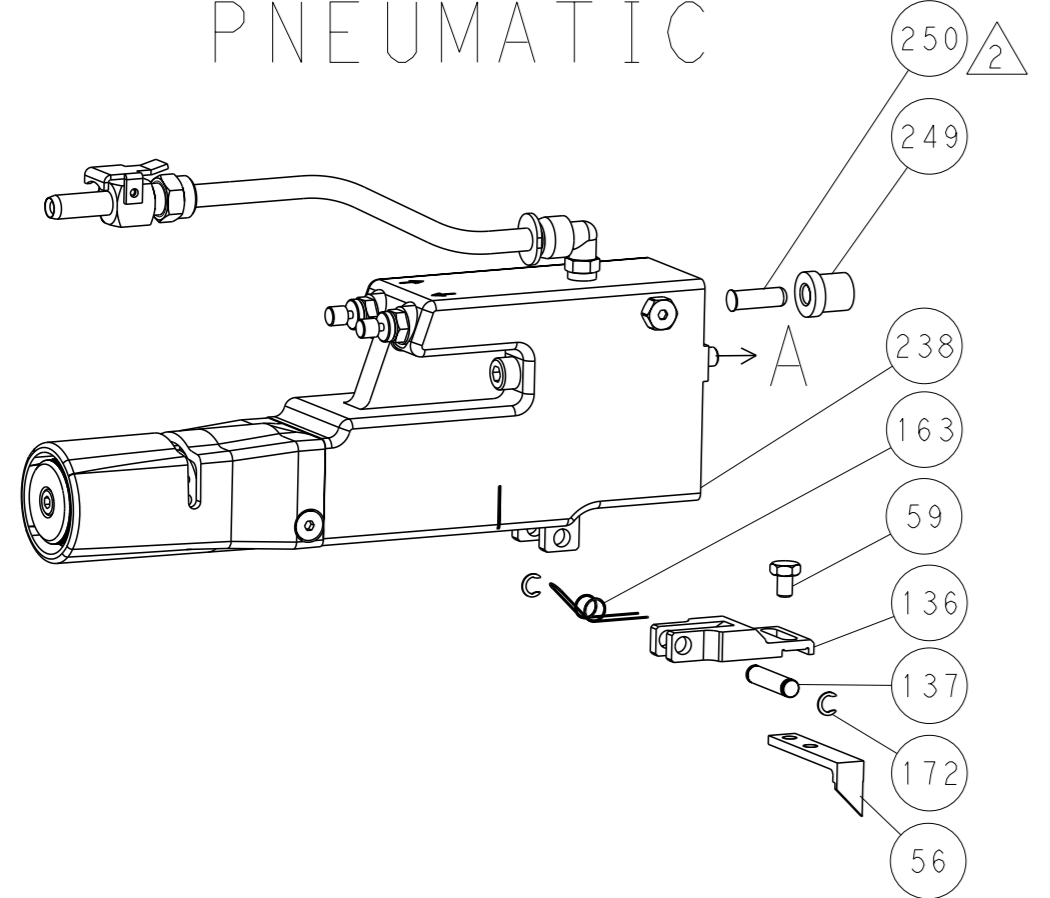
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MATERIAL:	FINISH:	DATE	DATE	DATE	DATE	DATE	SCALE	SHEET	OF	REV
-	-	22OCT2015	22OCT2015	22OCT2015	-	-	1:2	1	4	C

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

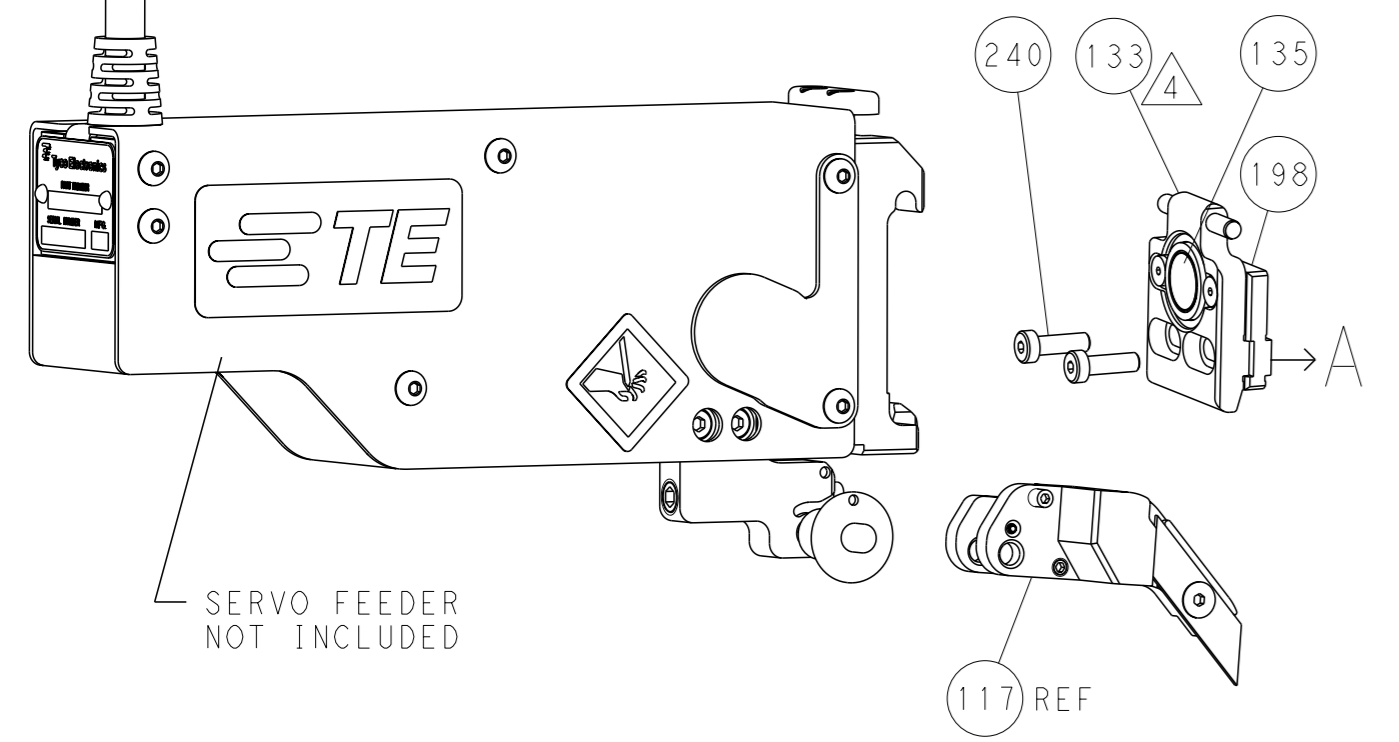
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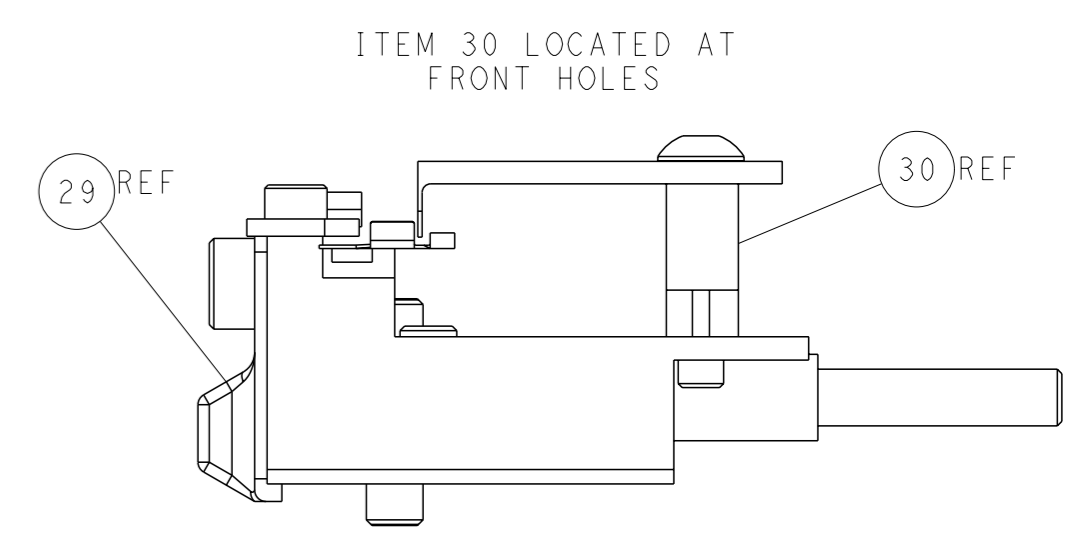
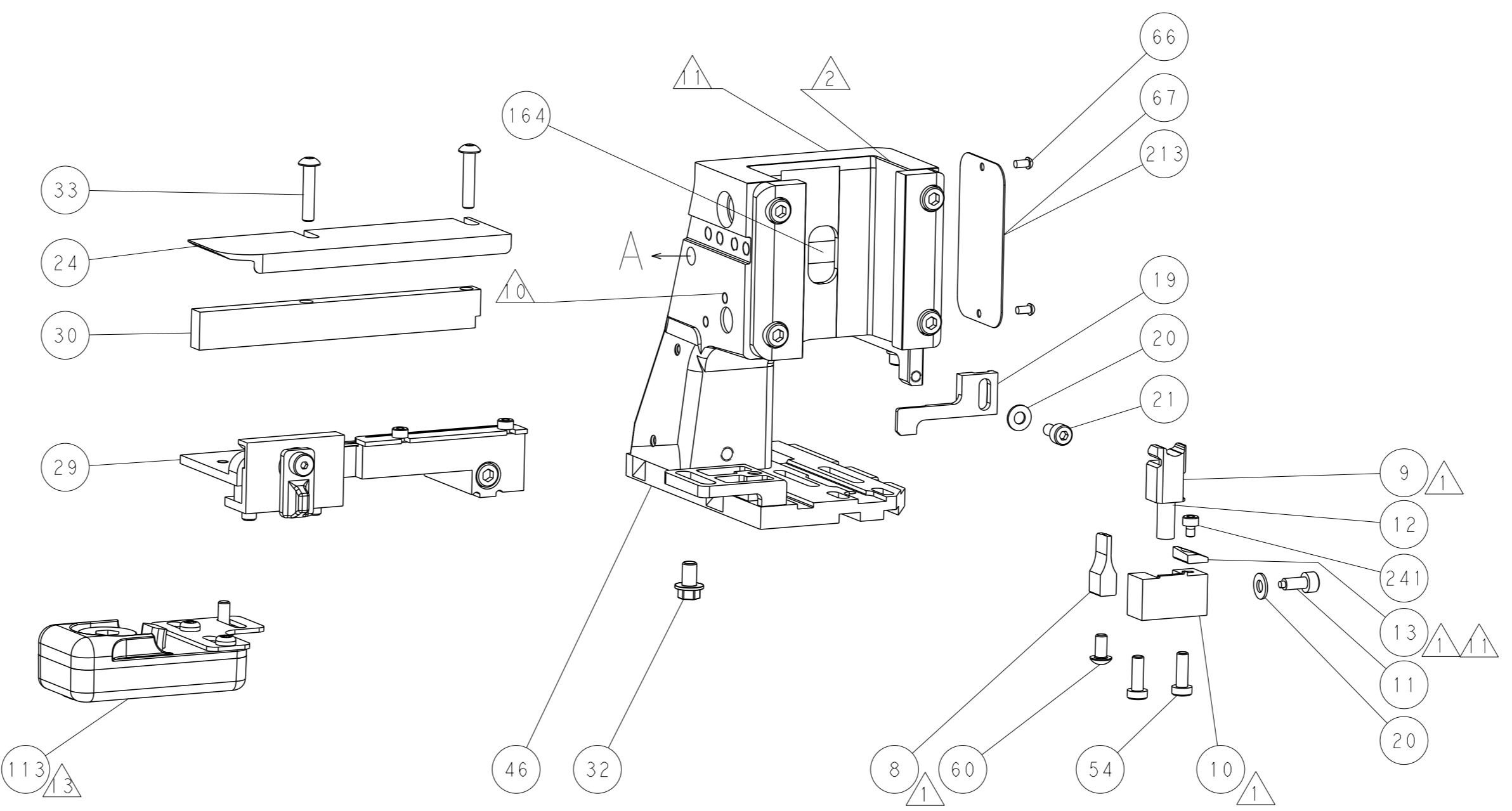
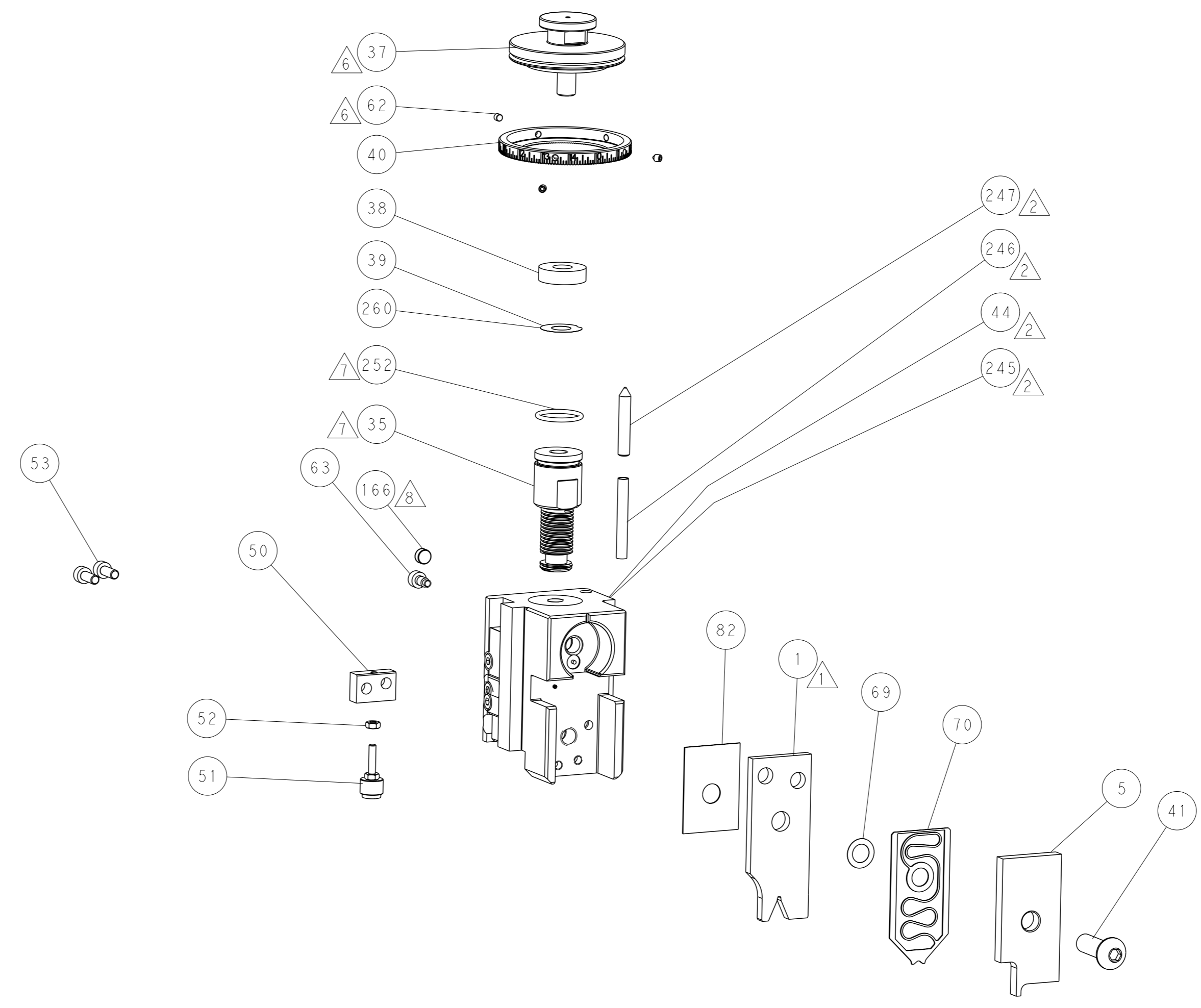
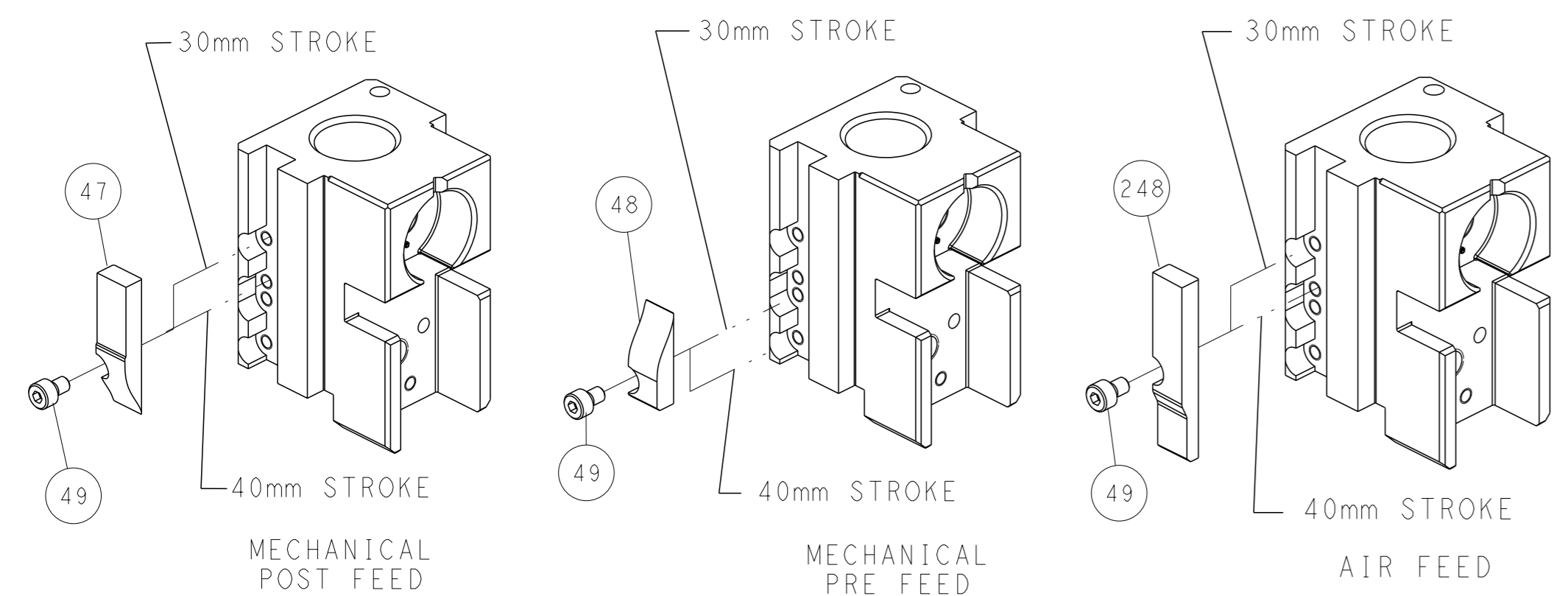
### PNEUMATIC



### 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 UNPUBLISHED. RELEASED FOR PUBLICATION BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.</small>		OWN: J. HOW CHK: L. ZHANG APVD: H. GUO	Z2OCT2015 Z2OCT2015 Z2OCT2015	TE Connectivity Harrisburg, PA 17105-3608
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=2836085	RESTRICTED TO: - SCALE: 1:2 SHEET: 2 of 4 REV: C	
MATERIAL: - FINISH: -		WEIGHT: - CUSTOMER 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					
	2-2836085-1	C	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	-	8-2836085-5	1901094-3	-	2168400-6 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2836085-4	-	-	-
	2-2836085-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-2	-	-
					SERVO LATCH PLATE	2119951-1	-	8-2836085-5	1901094-3	-	2168400-6 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2836085-4	-	-	-
	2-2836085-5	C	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
	2-2836085-7	C	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	-
	7-2836085-7	C	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.55 mm [.061]	F
INSUL	-	-
APPLICATOR INSTRUCTIONS 408-10389		

TERMINAL DATA: HI-STAT TERMINAL Season Group CRIMP SPECIFICATION	
TERMINAL NAME: TERMINAL, FEMALE	
WIRE STRIP LENGTH 4.34-5.11 mm [.171-.201 IN]	INSULATION DIAMETER RANGE 1.30-1.60 mm [.051-.063 IN]
TERMINAL APPLICATION SPECIFICATION Season Group	
TERMINALS APPLIED <sup>4</sup>	
TE TERMINAL 2113919-1	HI-STAT TERMINAL 503-607-10

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
20 AWG	1.25 +/- 0.05 [.049 +/- .002]	9.0

- <sup>1</sup> RECOMMENDED SPARE PARTS
- <sup>2</sup> GREASE BEARING SURFACES LIGHTLY
- 3. LUBRICATE DAILY PER THE APPLICATOR INSTRUCTION SHEET SUPPLIED WITH THE APPLICATOR.
- <sup>4</sup> APPLICATOR SPECIFIC DATA TO BE ENTERED INTO BLANK MEMORY CHIP AT ASSEMBLY. SEE BELOW FOR PART NUMBER:  
MECHANICAL FEED WITH "SMART APPLICATOR" CONVERSION: 8-2836085-4  
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2836085-4  
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2836085-5
- 5. ADJUSTMENT OF THE STRIPPER MAY BE REQUIRED WHEN MOVING THE APPLICATOR BETWEEN BENCH AND LEADMAKER APPLICATIONS.
- <sup>6</sup> APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 62.
- <sup>7</sup> GREASE THREADS, GROOVE AND O-RING ON ITEMS 139 & 152.
- <sup>8</sup> MAGNET MUST BE ORIENTED CORRECTLY IN ORDER TO PROPERLY ACTUATE THE COUNTER.
- <sup>9</sup> 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.
- <sup>10</sup> SPARE FEED CAM STORAGE LOCATION REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.
- <sup>11</sup> 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.
- <sup>12</sup> 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.

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

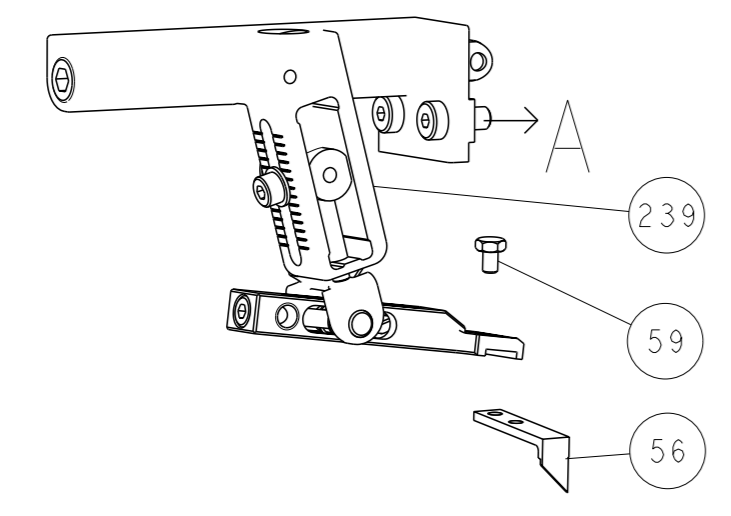
SET UP GAUGE	LOC	DIST	REVISIONS			
2119599-1	A	66	#	DATE	OWN	APVD
			-	SEE SHEET 1	-	-

-	1	1	1	1	2119782-1	FINE ADJUST HEAD ASM, PACIFIC STYLE	251
-	-	-	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	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	-	-	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
-	2	2	2	2	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
-	-	1	-	-	1633743-1	SERVO FEED LATCH ASM	133
-	-	REF	-	-	2119944-1	FEED FINGER ASSEMBLY, SF	117
<sup>12</sup>	-	1	1	1	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113
-	1	1	1	1	455888-4	SPACER, CRIMPER	82
-	1	1	1	1	2119956-1	DOCUMENTATION PACKAGE	71
-	1	1	1	1	2119791-9	DEPRESSOR, WIRE	70
-	1	1	1	1	2119943-1	WASHER, SPACER	69
-	1	-	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
<sup>6</sup>	-	3	3	3	992763-5	SCR, SET, SOC, CONE POINT, M3 X 4.0	62
-	-	-	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	-	-	1	1	1338685-1	PAWL, FEED	56
-	2	2	2	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	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	690753-6	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	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	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	2119533-9	STRIPPER, SIDE FEED	19
<sup>1</sup>	-	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
<sup>1</sup>	-	1	1	1	2119805-1	SHEAR HOLDER, FRONT	10
<sup>1</sup>	-	1	1	1	318707-1	FLOATING SHEAR, FRONT	9
<sup>1</sup>	1	1	1	1	6-1633933-6	ANVIL, COMBINATION	8
-	-	-	-	-	-	-	7
-	-	-	-	-	-	-	6
-	1	1	1	1	2119757-1	DEPRESSOR, SHEAR	5
-	-	-	-	-	-	-	4
-	-	-	-	-	-	-	3
-	-	-	-	-	-	-	2
<sup>1</sup>	1	1	1	1	7-1633713-0	CRIMPER, WIRE PREMIUM	1

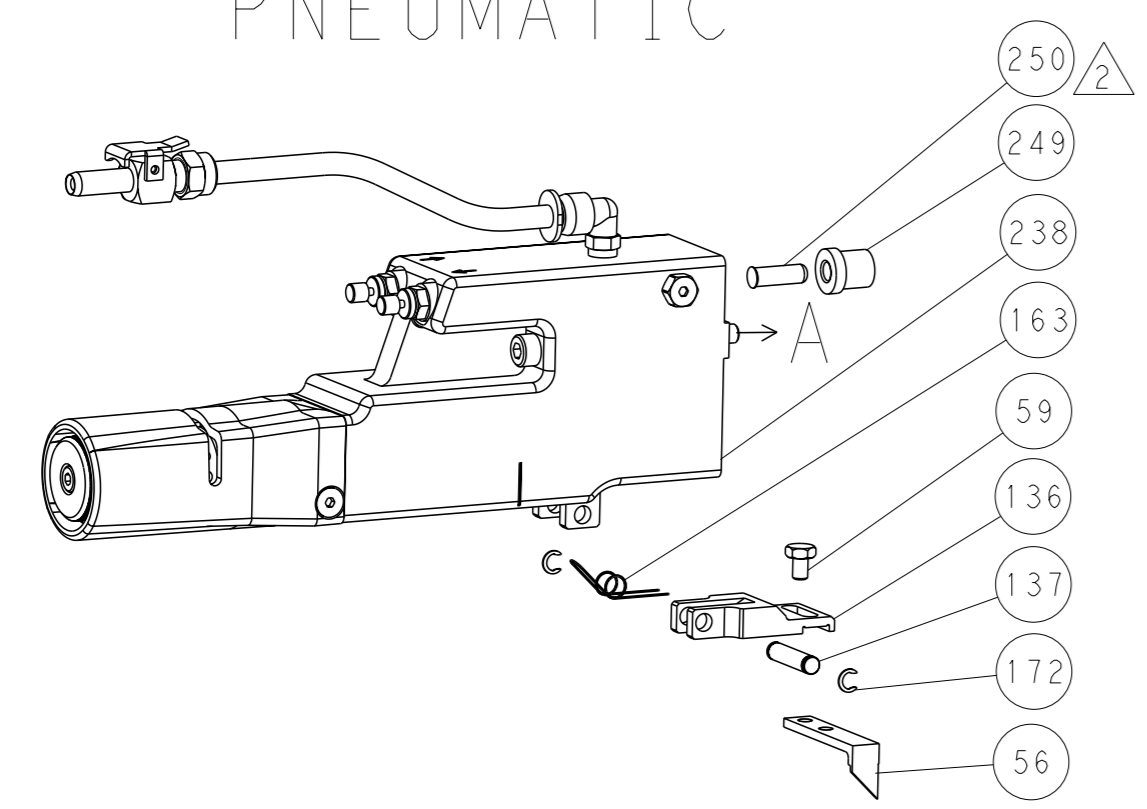
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		OWN	CHK	APVD	NAME
mm	0 PLC	±		J. HOU	L. ZHANG	U. GUO	Ocean Side Feed Applicator
	1 PLC	±					
	2 PLC	±					
	3 PLC	±					
	4 PLC	±					
	ANGLES	±					
MATERIAL	FINISH						
				WEIGHT	A1 00779		SCALE 1:2 SHEET 3 OF 4 REV C
				CUSTOMER DRAWING			

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

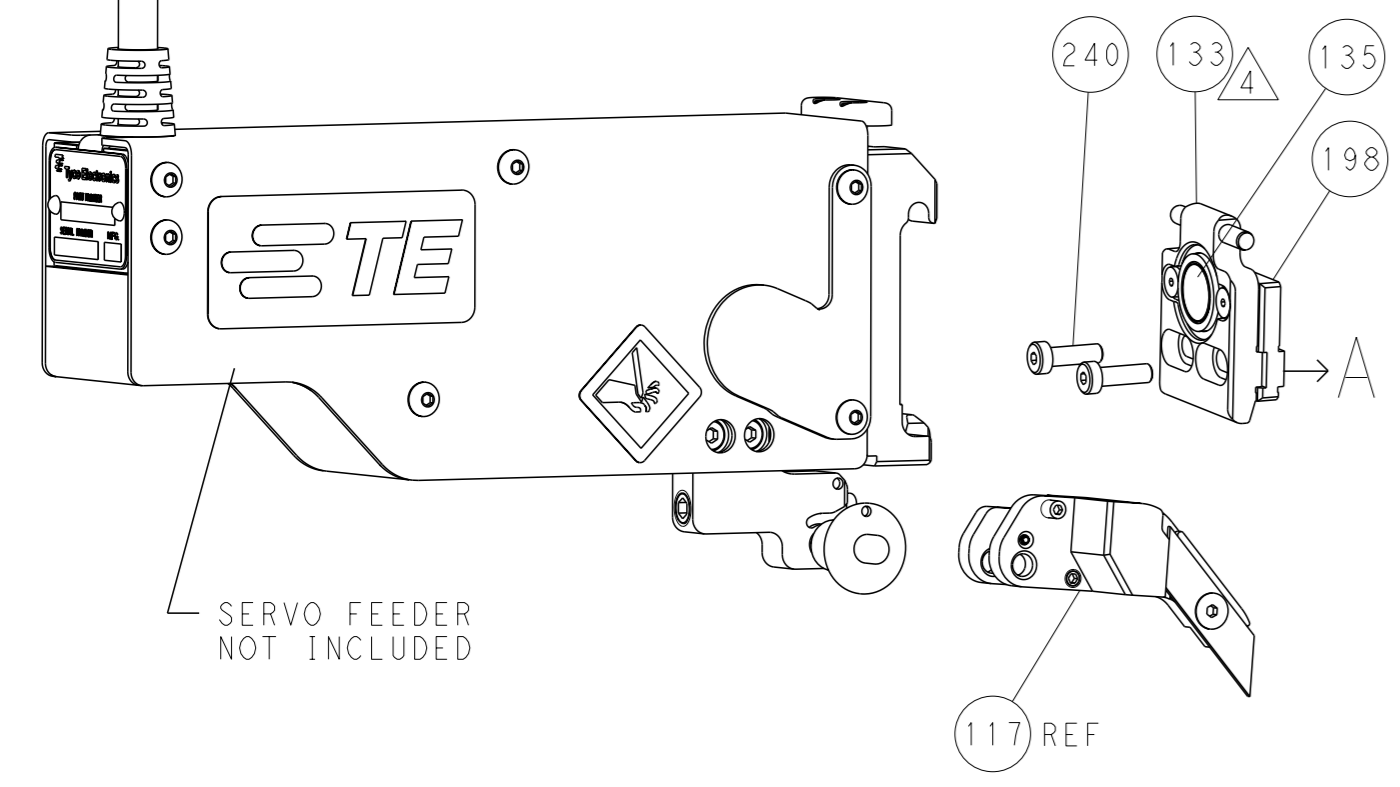
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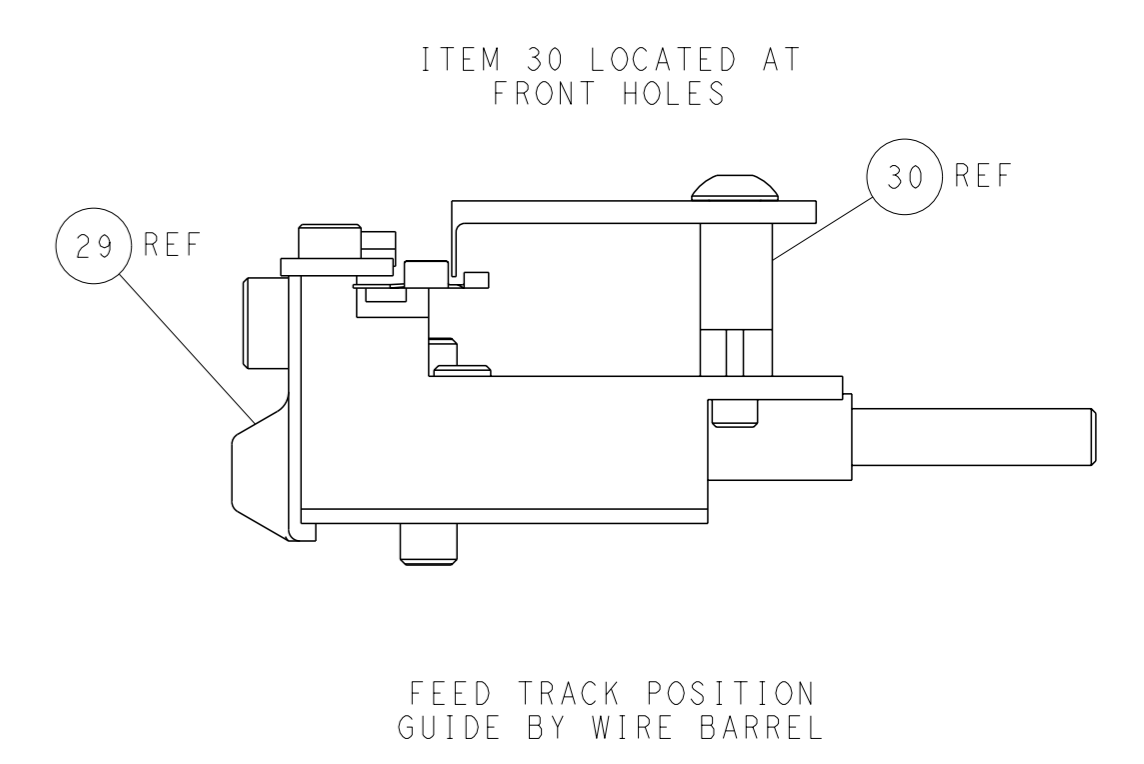
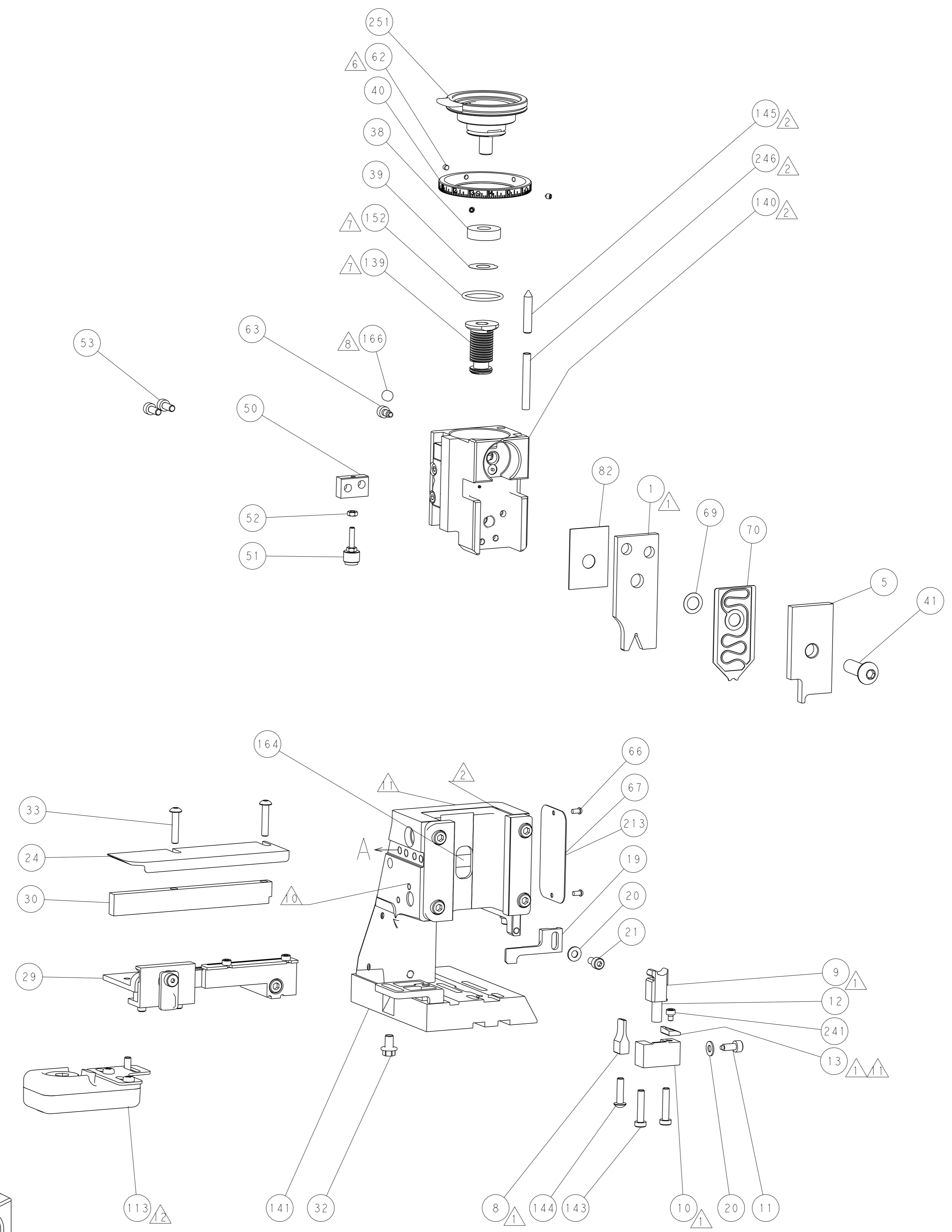
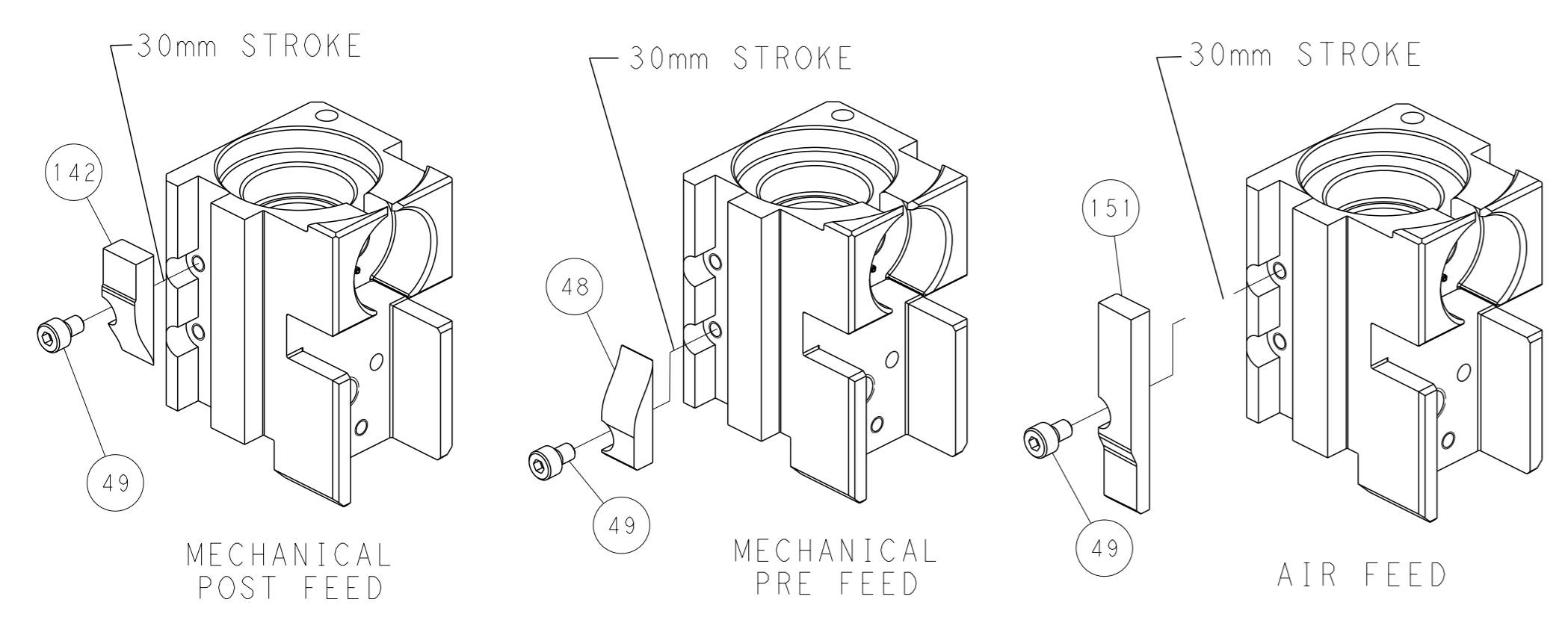
# PNEUMATIC



# 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. IT IS SUBJECT TO CHANGE AND THE CUSTOMER'S RESPONSIBILITY TO VERIFY DIMENSIONS SHOULD BE CONTACTED FOR THE LATEST REVISION.</small>		OWN: J. HOU CHK: L. ZHANG APVD: H. GUO	DATE: 22OCT2015 DATE: 22OCT2015 DATE: 22OCT2015	NAME: TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH ±	PRODUCT SPEC APPLICATION SPEC WEIGHT CUSTOMER DRAWING	SCALE: 1:2 SHEET: 4 of 4 REV: C	RESTRICTED TO: - SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2836085	NAME: Ocean Side Feed Applicator