

APPLICATOR STYLE CONVERSION CHART. TABLE with columns: PART NUMBER, REVISION, DESCRIPTION, FEED TYPE, CONVERT TO, PART NUMBERS REQUIRED.

APPLICATOR DATA. TABLE with columns: CRIMP SIZE, TYPE, WIRE, INSUL.

TERMINAL DATA: SUMITOMO TERMINAL, SUMITOMO CRIMP SPECIFICATION. TABLE with columns: WIRE STRIP LENGTH, INSULATION DIAMETER RANGE, TERMINAL APPLICATION SPECIFICATION.

TERMINALS APPLIED. TABLE with columns: TE TERMINAL, SUMITOMO TERMINAL, TE SEAL, SUMITOMO SEAL, CABLE DIAMETER.

WIRE SIZE, CRIMP HEIGHT mm [INCH], CRIMP HEIGHT REFERENCE SETTING. TABLE with columns: WIRE SIZE, CRIMP HEIGHT, REFERENCE SETTING.

- 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...
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...
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...
TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
TO CONVERT THE APPLICATOR TO A NON-CARRIER CUTTING STYLE...
WHEN ASSEMBLING A NON CRIMP HEIGHT ADJUST APPLICATOR (-6) USE SHIMS FROM ITEM 260...
THIS APPLICATOR APPLIES TERMINAL WITH A SEAL.
APPLY TORQ-SEAL IN ALLEN SOCKET TO FILL HOLE AFTER FLAT HD HAS BEEN ADJUSTED TO CORRECT HEIGHT...
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.

REVISIONS and parts list table. Columns: P, L, M, DESCRIPTION, DATE, OWN, APVD.

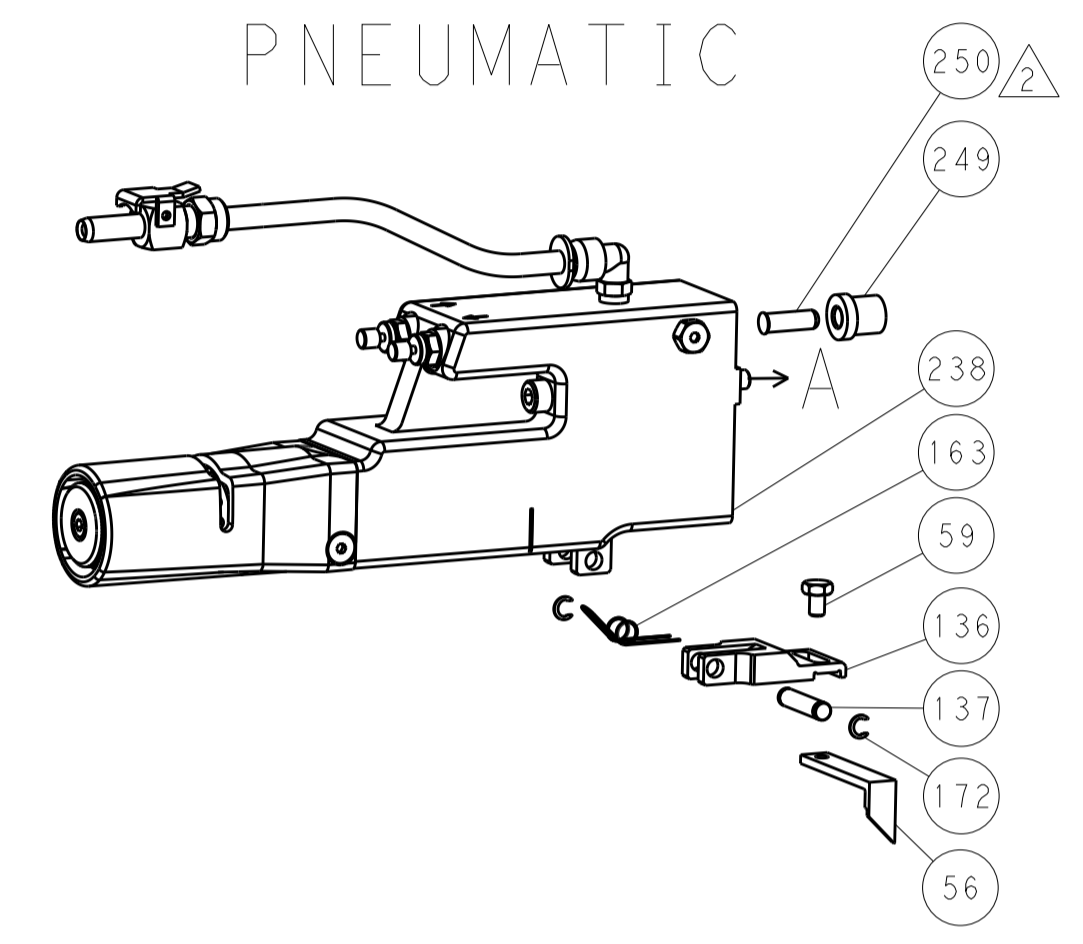
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

Customer Accessible Production Drawing form. Includes fields for dimensions, tolerances, material, weight, scale, and drawing number.

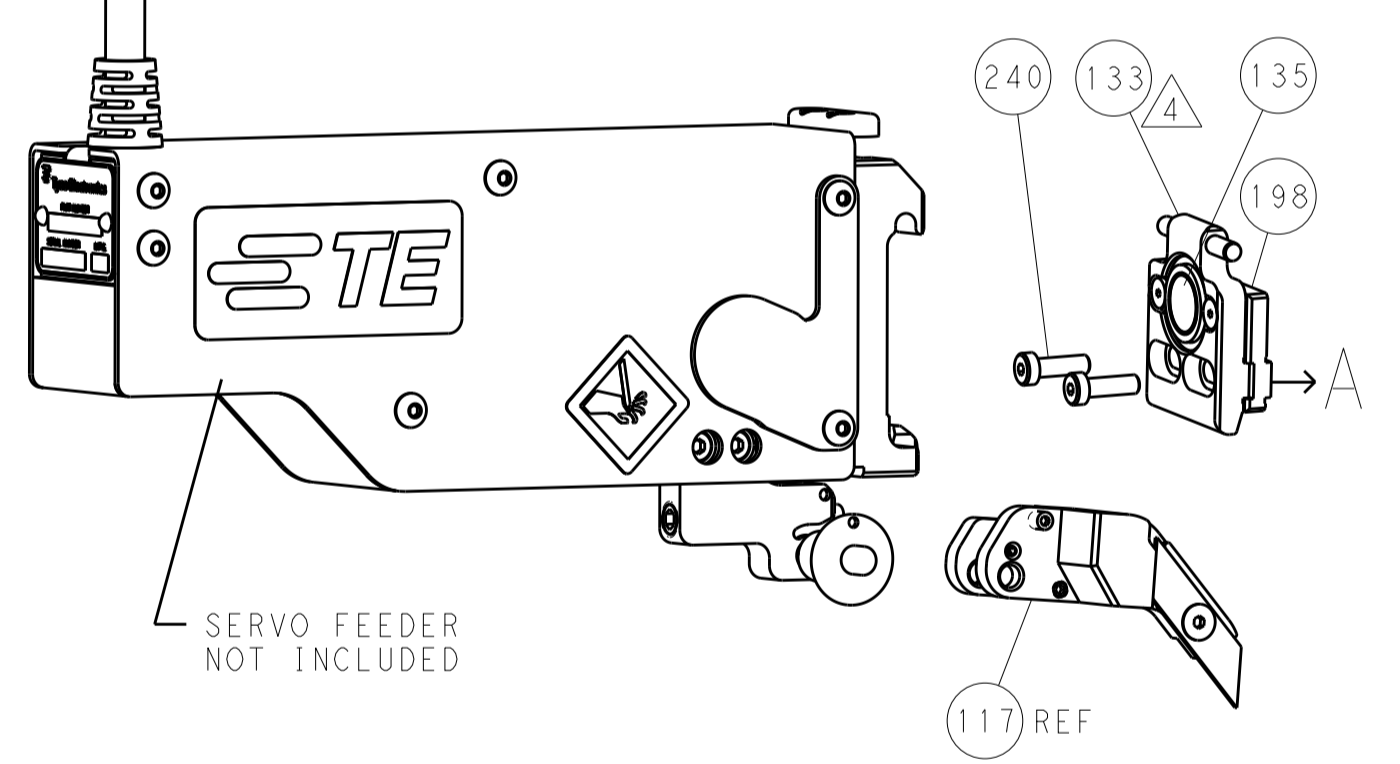
LOC	DIST	REV	DATE	BY	APPV
A	66				
REVISIONS			DESCRIPTION	DATE	BY
			SEE SHEET 1		

### FEED TYPE

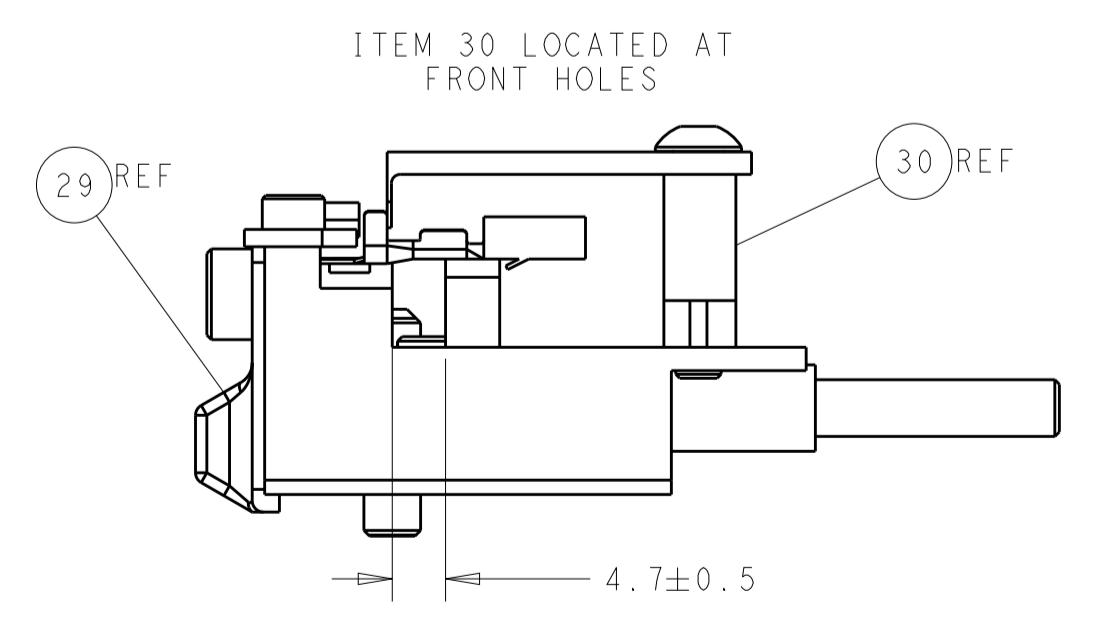
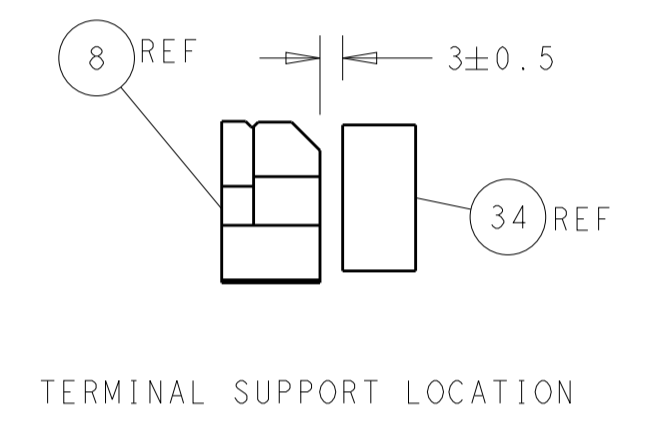
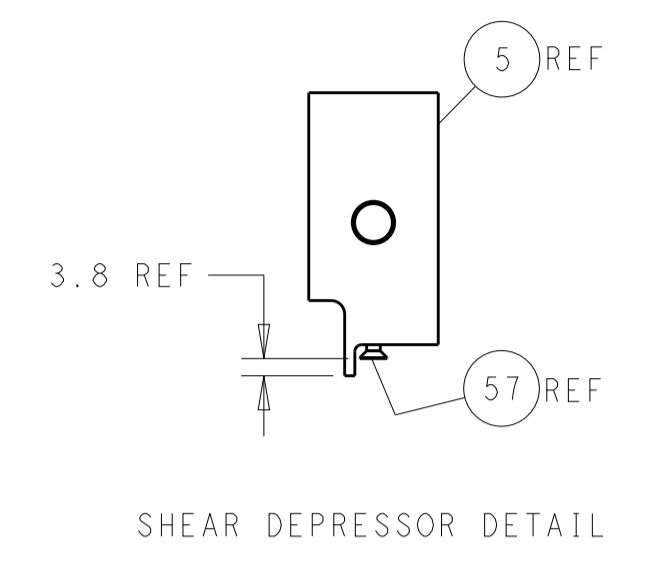
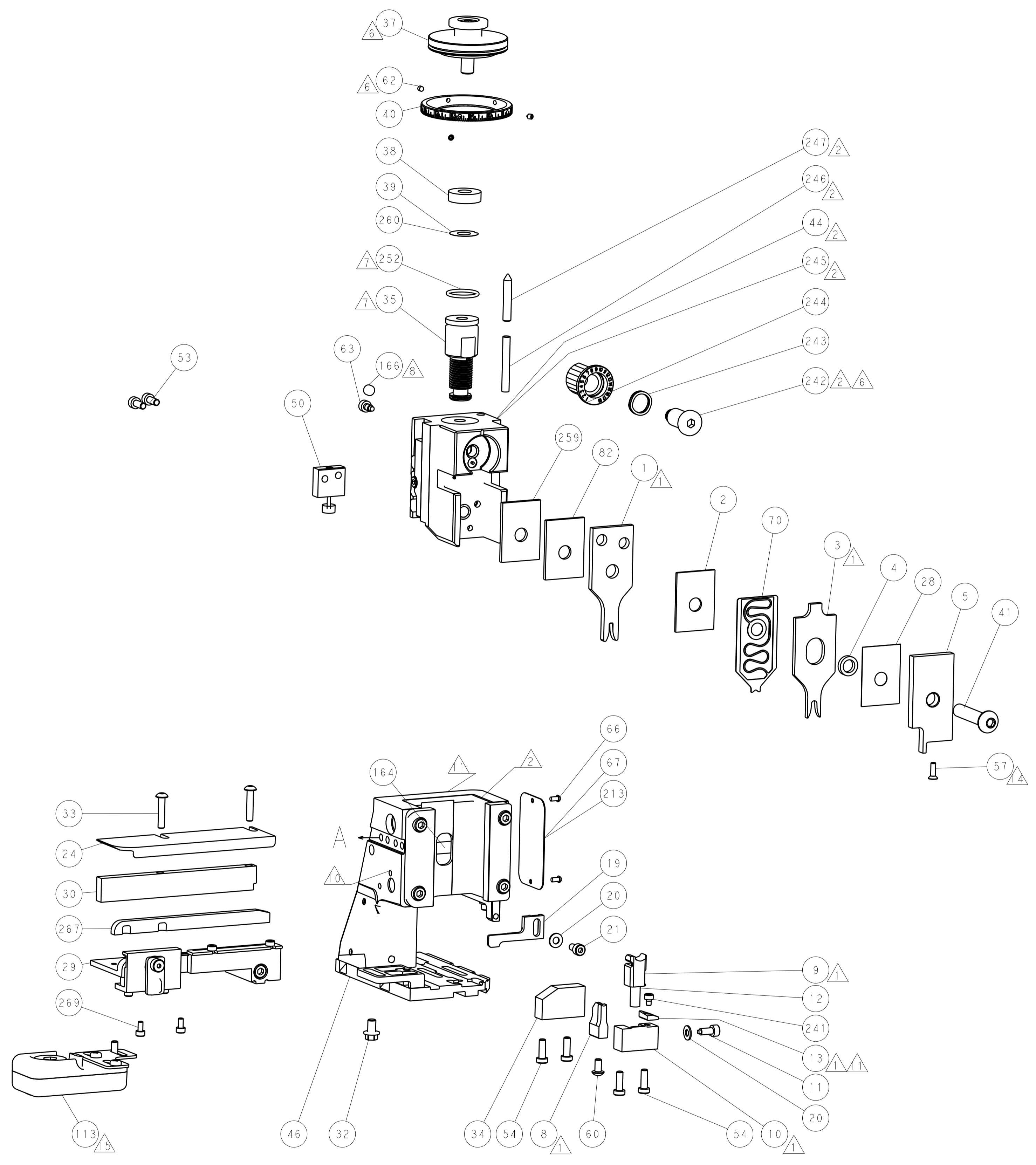
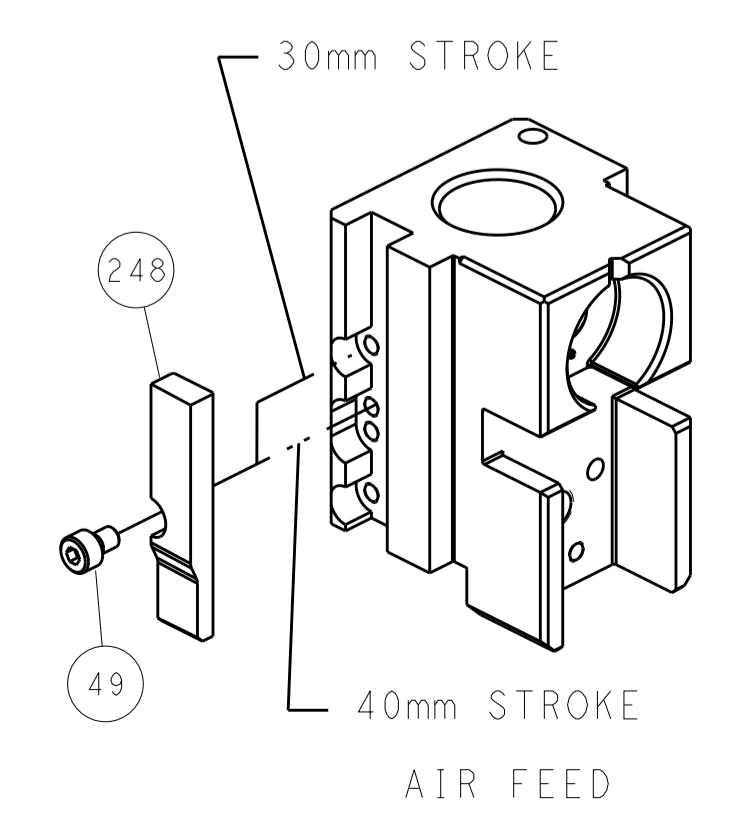
### PNEUMATIC



### 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: H. HUANG 21SEP2017		TE Connectivity	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	Harrisburg, PA 17105-3608	
MATERIAL:		FINISH:		CHK: L. ZHANG 21SEP2017		NAME: Ocean Side Feed Applicator	
				APVD: L. ZHANG 21SEP2017		PRODUCT SPEC:	
						APPLICATION SPEC:	
				WEIGHT:		SIZE: CAGE CODE: DRAWING NO: RESTRICTED TO:	
				Customer Accessible Production Drawing		A1 00779 ©=2836934	
				SCALE: 1:2		SHEET 2 OF 4 REV A	

PACIFIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
	2-2836934-2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
	2-2836934-5	A	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE <sup>4</sup>
	2-2836934-7	A	FINE CRIMP HEIGHT ADJUST	NONE
	7-2836934-7	A	CRIMP TOOLING KIT	-

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.24 mm [.088]	F
INSUL	3.90 mm [.154]	O
APPLICATOR INSTRUCTIONS 408-10389		

TERMINAL DATA: SUMITOMO TERMINAL SUMITOMO CRIMP SPECIFICATION				
TERMINAL NAME: 187 HX SERIES TERMINAL				
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE		
5.60-6.40 mm [.220-.252 IN]		$\phi$	$\Delta$	
TERMINAL APPLICATION SPECIFICATION	NONE Rev -	-	-	-
TERMINALS APPLIED <sup>1</sup> <sup>2</sup> <sup>3</sup> <sup>4</sup> <sup>5</sup>				
TE TERMINAL	SUMITOMO TERMINAL	TE SEAL	SUMITOMO SEAL	CABLE DIAMETER
2318382-1	8100-0661	2318383-1	7165-0347	2.0-2.9mm
		2318383-2	7165-0347S	2.0-2.9mm

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.50mm2	1.21+/-0.05 [.048+/-0.002]	7.1
0.30mm2	1.15+/-0.05 [.045+/-0.002]	7.7



- <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:  
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2836934-4  
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2836934-5
- 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 ITEMS 62.  
APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242.
- <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> TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- <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> THIS APPLICATOR APPLIES TERMINAL WITH A SEAL.
- <sup>13</sup> APPLY TORQ-SEAL IN ALLEN SOCKET TO FILL HOLE AFTER FLAT HD HAS BEEN ADJUSTED TO CORRECT HEIGHT AT QUALIFICATION.  
APPLY #1-23419-5 LOC-TITE TO THREADS.
- <sup>14</sup> TERMINAL LUBRICANT IS RECOMMENDED.

APPLICATOR STYLE CONVERSION CHART						
CONVERT TO	PART NUMBERS REQUIRED					
-	-	-	-	-	-	-
SERVO LATCH PLATE	2119951-1	-	8-2836934-5	1901094-3	-	2168400-6 (QUANTITY 2)
SMART APPLICATOR	2161326-1	-	8-2836934-4	-	-	-
PNEUMATIC FEED	2119950-1	1338683-8	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.

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

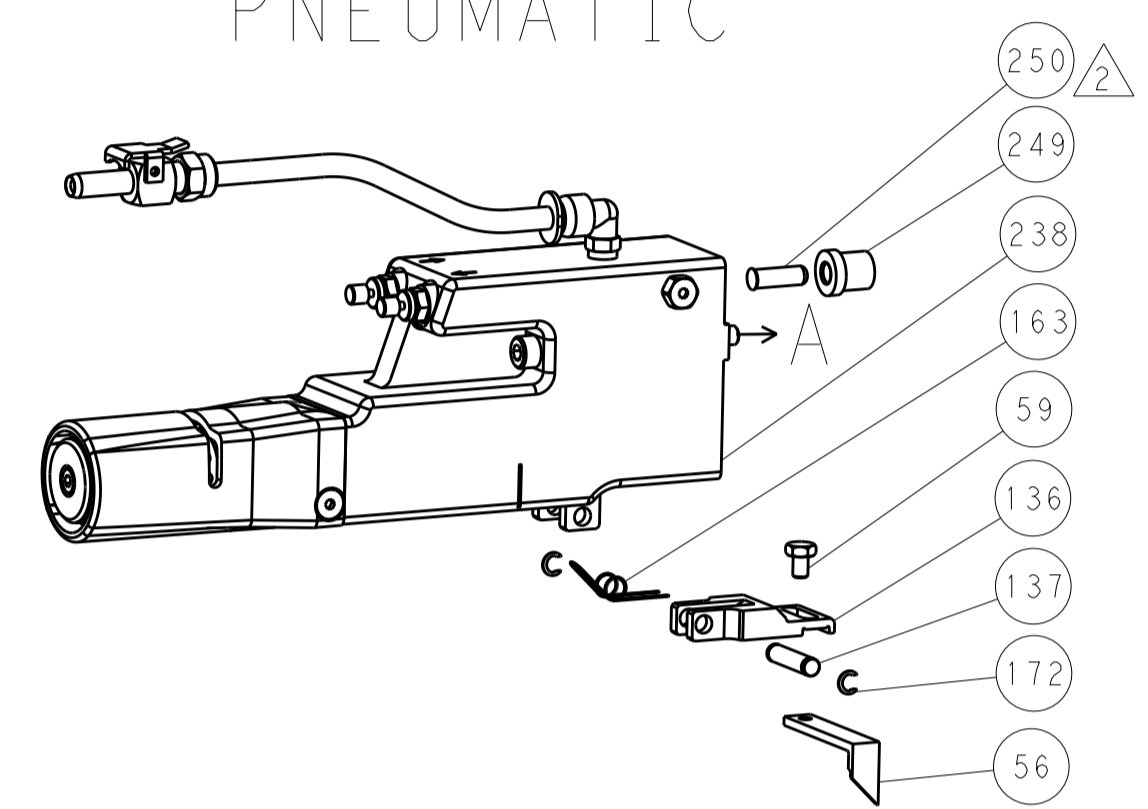
SET UP GAUGE	LOC	DIST	REVISIONS			
2119599-1	A	66	REV	DATE	BY	APPV
			-	SEE SHEET 1	-	-

-	2	2	2	1-21680083-1	SCR, SKT HD CAP, RoHS, M3 X 6	269
-	1	1	1	1633782-3	FENCE	267
-	1	1	1	1803078-2	SPACER, PRECISION	259
-	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	2119082-6	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
-	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	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
-	4	4	4	2168400-5	SHCS, LOW HEAD, RoHS, M4 X 20	143
-	1	1	1	1-2119656-0	APPLICATOR BASIC ASSEMBLY, SF	141
-	1	1	1	2161312-1	RAM, STEPPED, 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
-	-	REF	-	2119944-1	FEED FINGER ASSEMBLY, SF	117
-	1	1	1	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113
-	1	1	1	1-455888-9	SPACER, CRIMPER	82
-	1	1	1	2119956-1	DOCUMENTATION PACKAGE	71
-	1	1	1	2119791-5	DEPRESSOR, WIRE	70
-	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 PNT, M3 X 4.0	62
-	-	-	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	1	1	1	985575-3	SCR, FLT SKT HD CAP M3 X 10.0	57
-	-	-	1	1338683-8	FEED PAWL	56
-	2	2	2	1-21680083-0	SCR, SKT HD CAP, RoHS, M4 X 10	53
-	1	1	1	1803382-2	HOLD DOWN, SPRING LOADED	50
-	-	-	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	1	1	1	1-2079383-5	SCR, BHSC, RoHS (M8 X 40)	41
-	1	1	1	2119645-1	DISC, NUMBERED FA WIRE ADJUSTMENT	40
-	1	1	1	2119957-1	APPLICATOR SHIM PACK	39
-	1	1	1	2119644-1	RAM WASHER, PRECISION	38
-	1	1	1	3-1752356-4	SUPPORT, TERMINAL	34
-	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	1-1320908-2	SPACER, STRIP GUIDE	30
-	1	1	1	2119959-1	ASSEMBLY, STRIP GUIDE	29
-	1	1	1	455888-3	SPACER, CRIMPER	28
-	1	1	1	1320928-2	STRIP GUIDE	24
-	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
-	2	2	2	1-18028-2	WASHER, FLAT, REG M4	20
-	1	1	1	2119533-1	STRIPPER, SIDE FEED	19
-	1	1	1	2119806-1	INSERT, SHEAR	13
-	1	1	1	3-22280-3	SPRING, COMPRESSION	12
-	1	1	1	1-356885-4	STOP, SHEAR	11
-	1	1	1	2119805-1	SHEAR HOLDER, FRONT	10
-	1	1	1	318707-1	FLOATING SHEAR, FRONT	9
-	1	1	1	9-1803252-8	ANVIL, COMBINATION	8
-	-	-	-	-	-	7
-	1	1	1	2119781-1	DEPRESSOR, SHEAR	5
-	1	1	1	4-238011-0	BLOCK, CRIMPER SPACER	4
-	1	1	1	8-1633965-5	CRIMPER, INSULATION O PREMIUM	3
-	1	1	1	1-455888-2	SPACER, CRIMPER	2
-	1	1	1	9-1633609-6	CRIMPER, WIRE	1

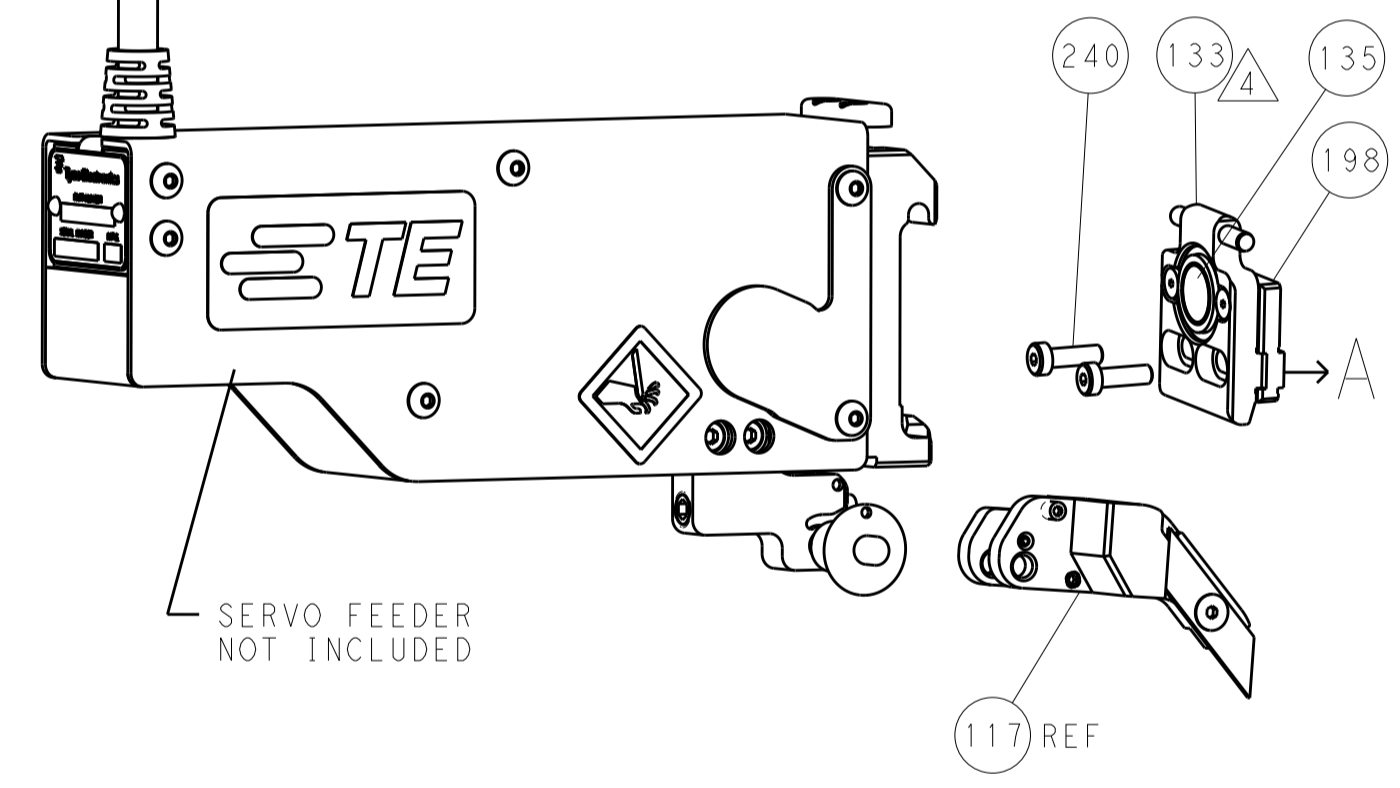
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DRAWN		CHK		APVD		DATE	
mm	0 PLC	±	1.0	H. HUANG	21SEP2017	L. ZHANG	21SEP2017	L. ZHANG	21SEP2017	TE Connectivity Harrisburg, PA 17105-3608	
MATERIAL:		FINISH:		NAME:		PRODUCT SPEC:		APPLICATION SPEC:		SIZE CAGE CODE DRAWING NO	
				Ocean Side Feed Applicator						A1 00779 ©=2836934	
				RESTRICTED TO:		WEIGHT:		SCALE:		SHEET 3 OF 4 REV A	
				Customer Accessible Production Drawing		SCALE 1:2		SHEET 3 OF 4		REV A	

LOC	DIST	REV	DATE	BY	APPV
A	66				

### FEED TYPE PNEUMATIC



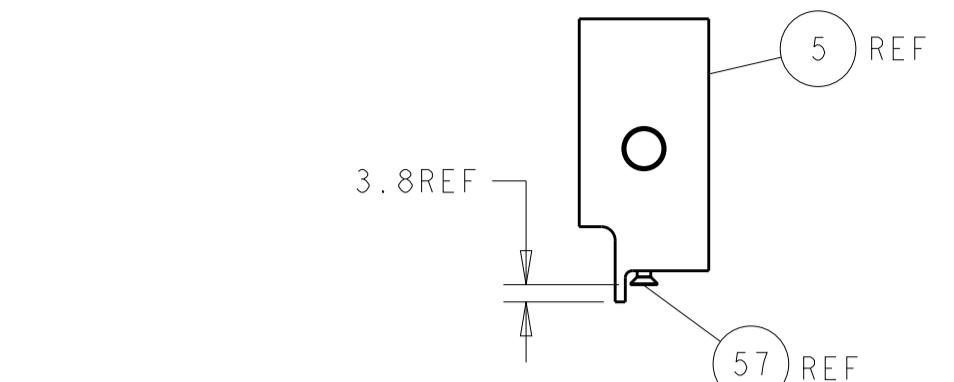
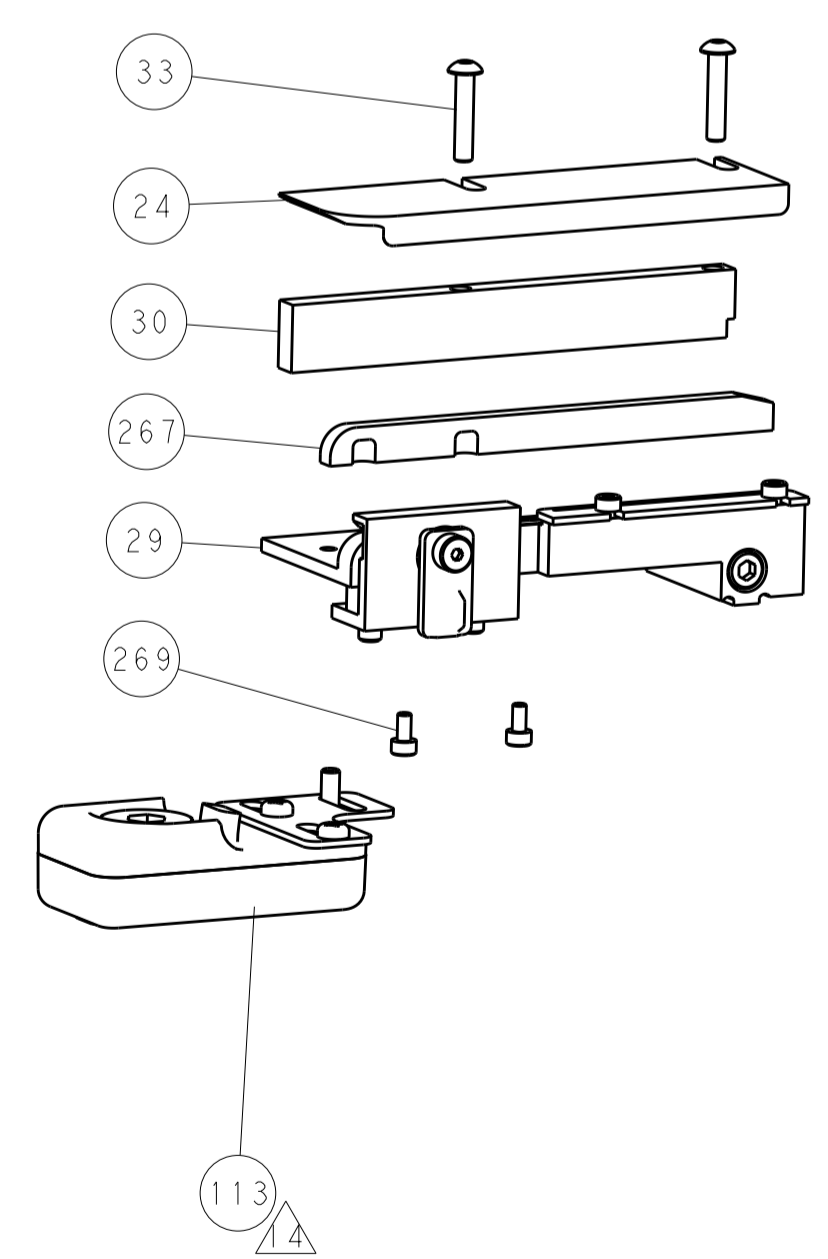
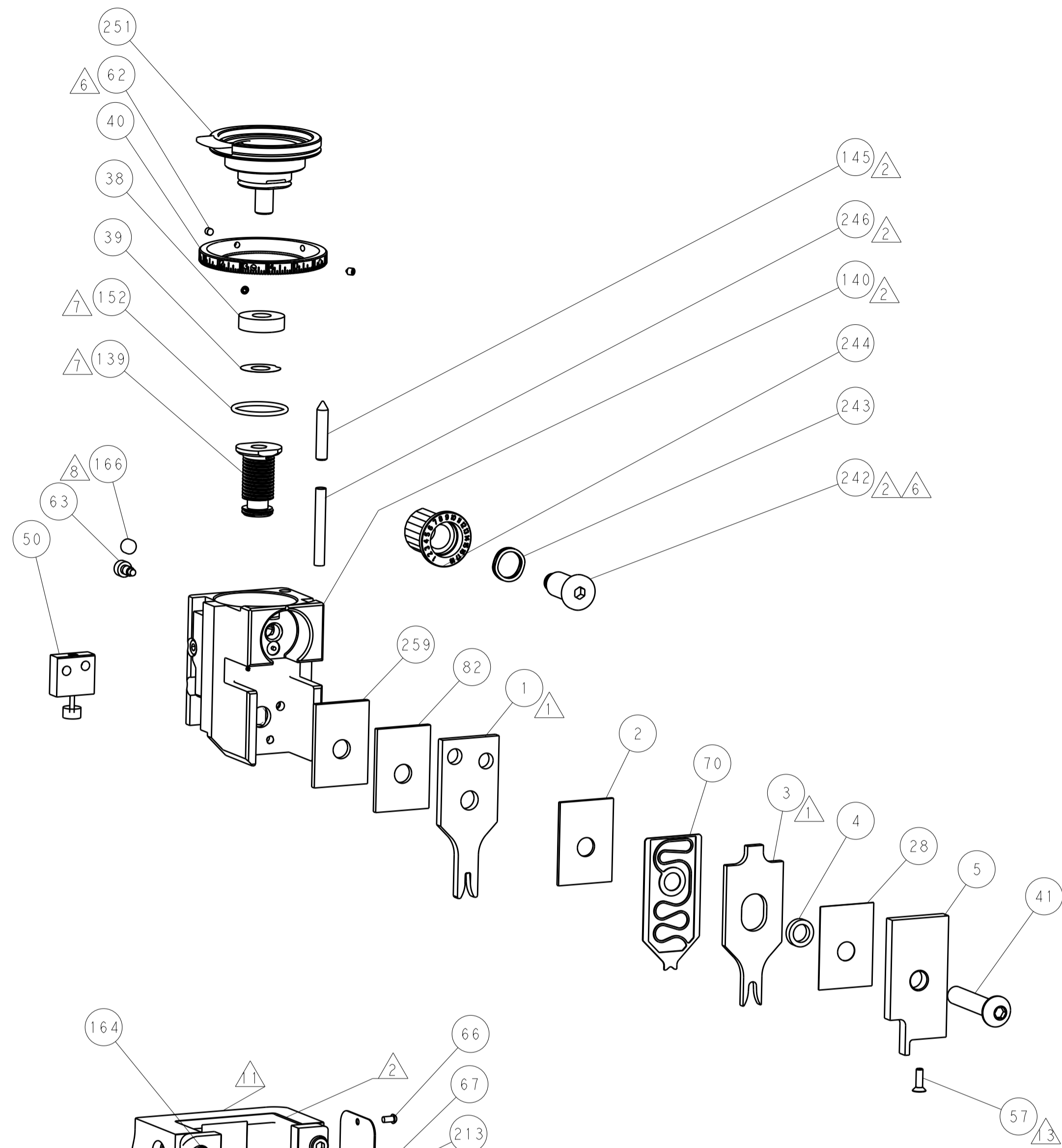
### SERVO LATCH PLATE



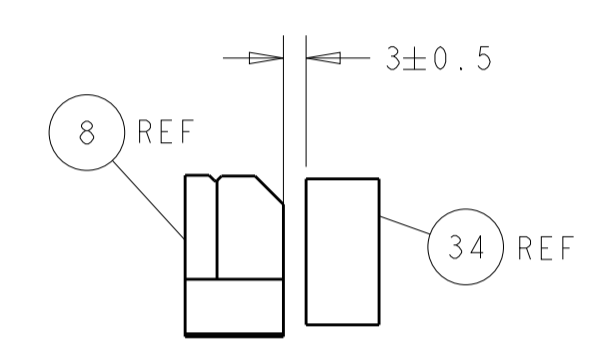
### CAM POSITION



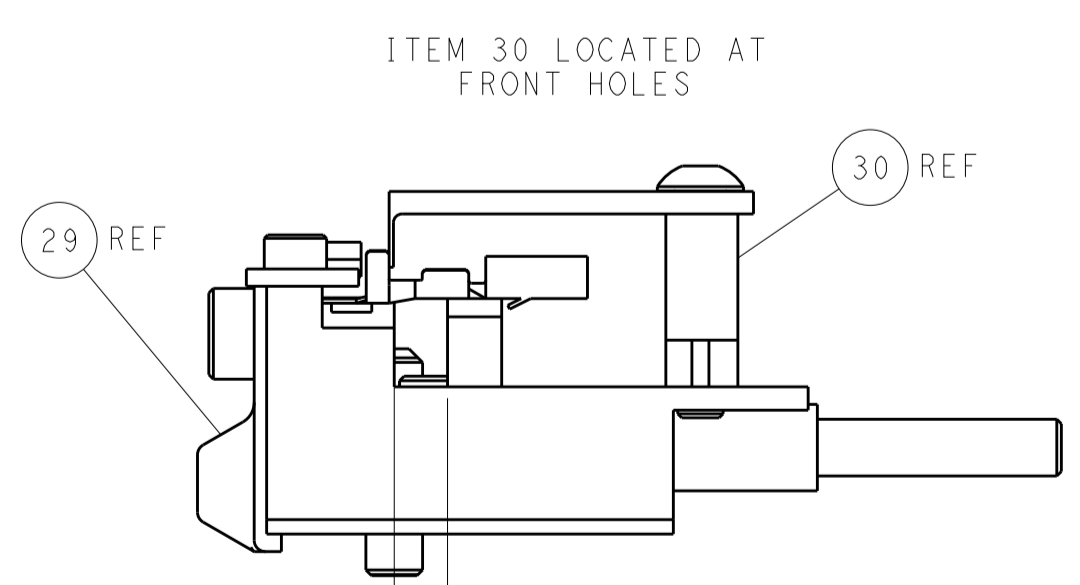
AIR FEED



SHEAR DEPRESSOR DETAIL



TERMINAL SUPPORT LOCATION



ITEM 30 LOCATED AT FRONT HOLES

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)

DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		DWN R. HUANG 21SEP2017 CHK L. ZHANG 21SEP2017 APVD L. ZHANG 21SEP2017 PRODUCT SPEC APPLICATION SPEC WEIGHT MATERIAL		NAME SIZE CAGE CODE DRAWING NO RESTRICTED TO	
				STE TE Connectivity Harrisburg, PA 17105-3608		Ocean Side Feed Applicator	
				A1 00779 ©=2836934 Customer Accessible Production Drawing		SCALE 1:2 SHEET 4 OF 4 REV A	