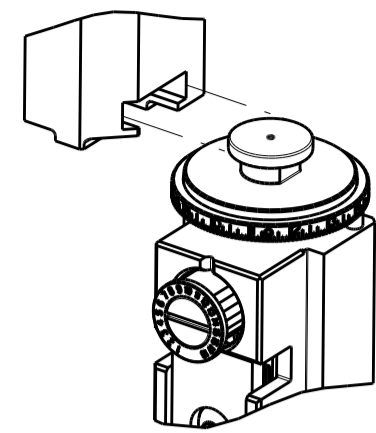


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2836031-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2836031-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2836031-1	B	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2836031-2	B	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2836031-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER

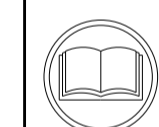


APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.98 mm [.078]	F
INSUL	2.50 mm [.098]	OV

APPLICATOR INSTRUCTIONS 408-35042

TERMINAL DATA: KET TERMINAL		KET CRIMP SPECIFICATION	
TERMINAL NAME: 280(110) MALE TERMINAL			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
4.30-4.70 mm [.169-.185 IN]		Ø1.40-1.70 mm [.055-.067 IN]	
TERMINAL APPLICATION SPECIFICATION 280 MALE TERMINAL S M L Rev 2010.10.29			
TERMINALS APPLIED 5			
TE TERMINAL	KET TERMINAL	TE TERMINAL	KET TERMINAL
2113893-1	ST741285-3		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
AVSS 0.5mm ²	1.25+/-0.05 [.049+/- .002]	6.8
AVSS 0.3mm ²	1.15+/-0.05 [.045+/- .002]	8.1



- 1 RECOMMENDED SPARE PARTS
- 2 REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- 3 APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242.
- 4 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.
- 5 TERMINAL LUBRICANT IS RECOMMENDED.
- 6. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.

***WARNING**
ON INSTALLATION, SET WIRE DISC TO CRIMP HEIGHT REFERENCE SETTING FOR LARGEST WIRE SIZE. CRIMP HEIGHT REFERENCE SETTINGS GREATER THAN THE VALUE SHOWN MAY CAUSE DAMAGE TO THE CRIMP TOOLING, REFER TO THE INSTRUCTION SHEET FOR PROPER SETUP AND ADJUSTMENTS.

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

LOC	DIST	REVISIONS			
A	66	REV	DATE	BY	APP'D
		A	RELEASED	09DEC2015	LG TE
		B	ECR-19-001027	22JAN2019	FZ KZ

-	1	-	1	-	2119640-1	PUSH ROD, AIR FEED	250	
-	1	-	1	-	1803259-1	BUSHING, FLANGED	249	
-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248	
-	1	1	1	1	2119082-4	CAM, SNAIL, INSULATION ADJUSTMENT	244	
-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243	
3	-	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	
-	-	1	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239	
-	1	-	1	-	2063440-1	AIR FEED MODULE	238	
-	2	-	2	-	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172	
-	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164	
-	1	-	1	-	240638-1	SPRING, FEED FINGER	163	
-	1	-	1	-	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854	137	
-	1	-	1	-	2119799-1	HOLDER, FEED FINGER, AF	136	
5	-	1	1	1	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113	
-	1	1	1	1	2844908-1	SCREW, LOCKING	99	
-	1	1	1	1	2844907-1	POST, LOCKING	98	
-	1	1	1	1	455888-5	SPACER, CRIMPER	82	
-	1	1	1	1	1803607-1	DOCUMENTATION PACKAGE	71	
-	1	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	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	60	
-	1	1	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59	
-	1	1	1	1	1338685-1	PAWL, FEED	56	
-	4	4	4	4	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	54	
-	2	2	2	2	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	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	690753-2	SPACER, TONKER	50	
-	1	2	1	2	18023-9	SCR, SKT HD CAP M4 X 6.0	49	
-	-	1	-	1	2119652-1	FEED CAM, PRE FEED	48	
-	-	1	-	1	2119653-1	FEED CAM, POST FEED	47	
-	1	1	1	1	1803583-9	APPLICATOR BASIC ASSEMBLY, SF	46	
-	1	1	1	1	1803515-1	RAM ASSEMBLY, SF ATLANTIC	44	
-	1	1	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41	
-	1	1	1	1	1752356-9	SUPPORT, TERMINAL	34	
-	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33	
-	2	2	2	2	3-2844962-0	SPACER, CYLINDRICAL, STRIP GUIDE	30	
-	1	1	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29	
-	1	1	1	1	455888-3	SPACER, CRIMPER	28	
-	1	1	1	1	1320928-6	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	2119533-1	STRIPPER, SIDE FEED	19	
1	-	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	
1	-	1	1	1	2119805-1	SHEAR HOLDER, FRONT	10	
1	-	1	1	1	1803095-1	FLOATING SHEAR, FRONT	9	
1	1	2	2	1	1	7-1633928-2	ANVIL, COMBINATION	8
-	1	1	1	1	4-240641-7	SPACER	7	
-	-	-	-	-	-	-	6	
-	1	1	1	1	2119757-4	DEPRESSOR, SHEAR	5	
-	1	1	1	1	1-238011-7	BLOCK, CRIMPER SPACER	4	
1	1	2	2	1	1	1803341-1	CRIMPER, INSULATION OVERLAP PREMIUM	3
-	1	1	1	1	455888-5	SPACER, CRIMPER	2	
1	1	2	2	1	1	4-1333281-5	CRIMPER, WIRE PREMIUM	1
-	77	-72	-71	-2	-1	PART NO	DESCRIPTION	ITEM NO

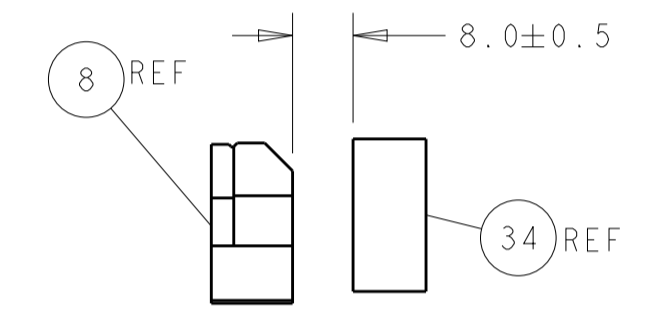
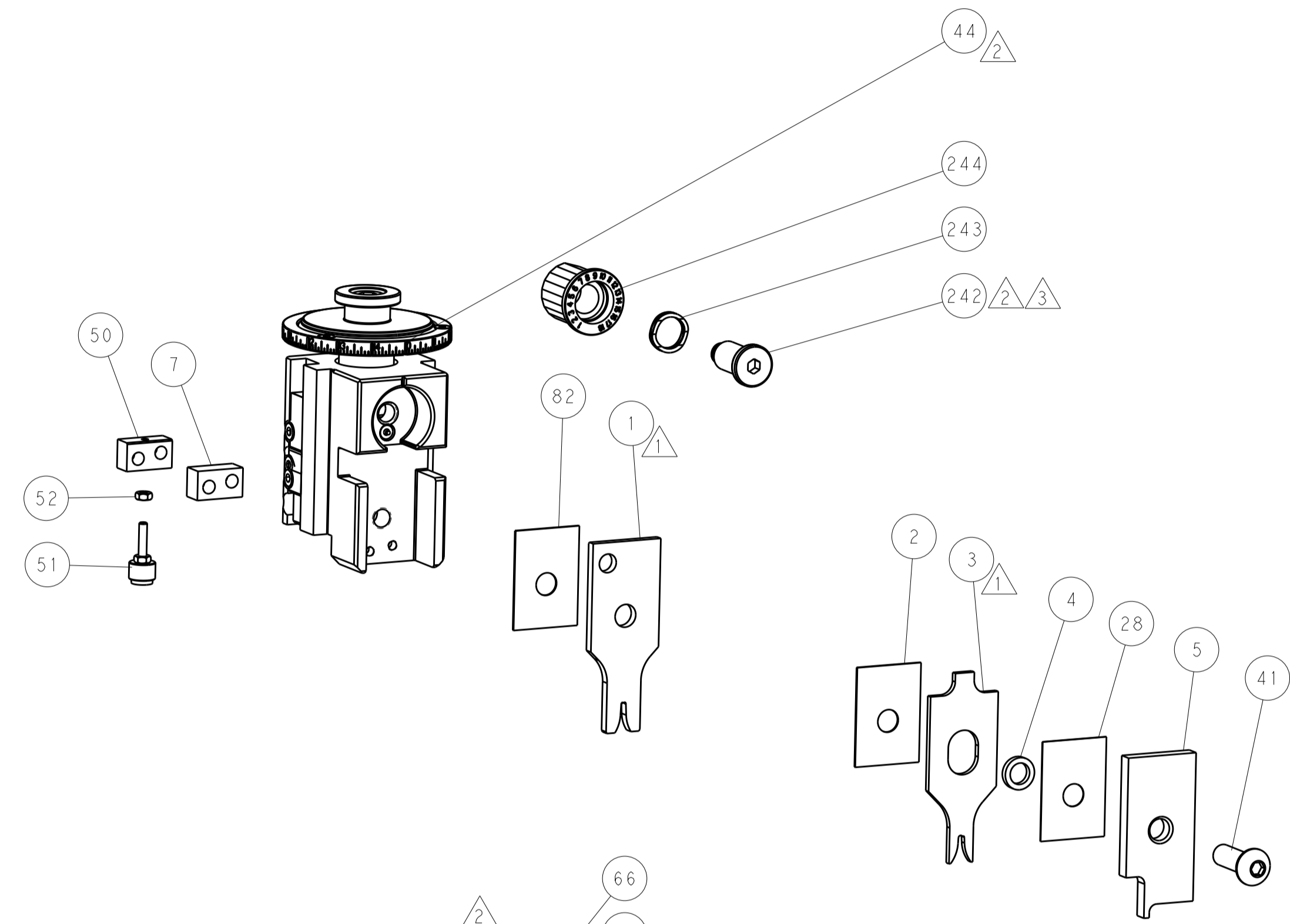
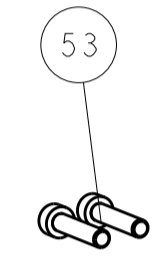
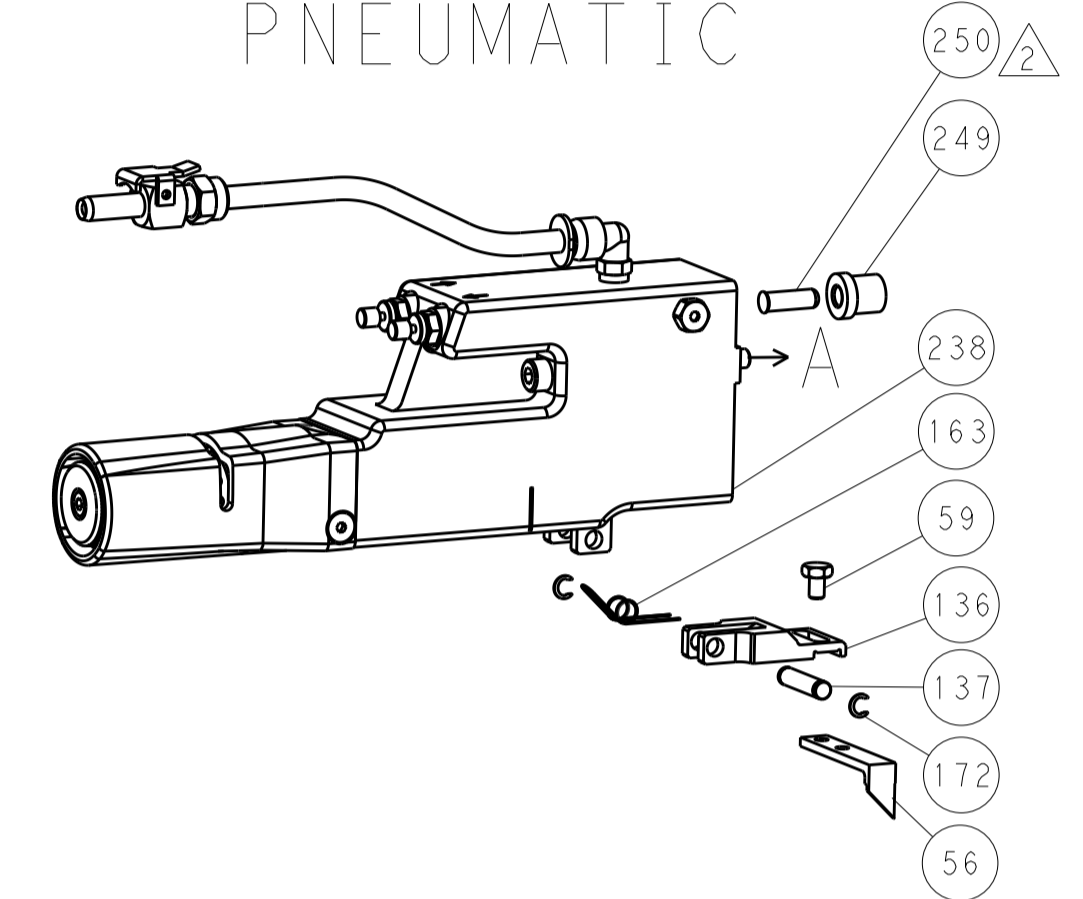
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		OWN	09OCT2015	TE Connectivity	
mm	0 PLC ±	1 PLC ±	2 PLC ±	M. RILEY	09OCT2015	Harrisburg, PA 17105-3608	
	3 PLC ±	4 PLC ±	ANGLES ±	T. ELBIN	09OCT2015	NAME	
	FINISH			D. STOUGH	09OCT2015	Ocean Side Feed Applicator	
MATERIAL				PRODUCT SPEC		SIZE	CAGE CODE
				APPLICATION SPEC		A1	00779
				WEIGHT		DRAWING NO	2836031
						Customer Accessible Production Drawing	SCALE 1:2
						SHEET 1	OF 4
						REV	B

LOC	DIST	REV	DATE	BY	APP'D
		1			

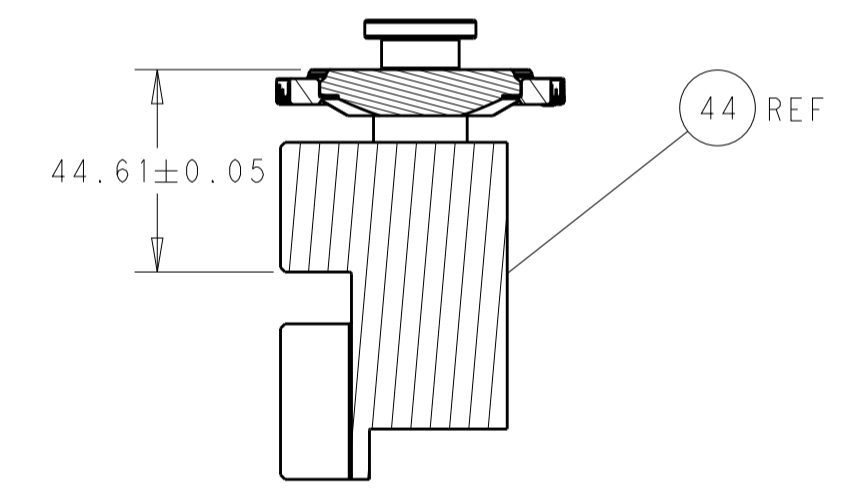
FEED TYPE MECHANICAL



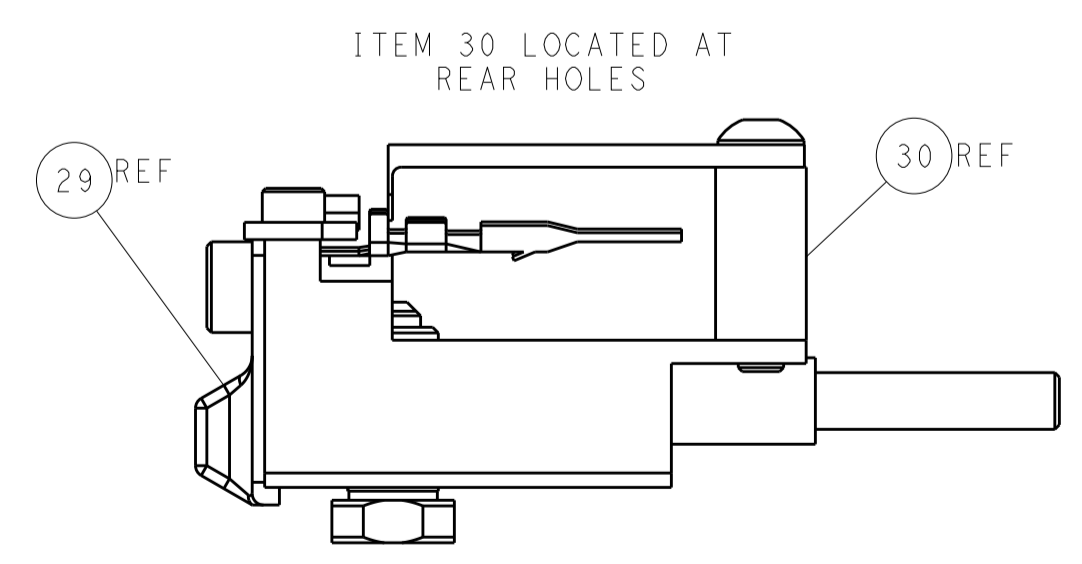
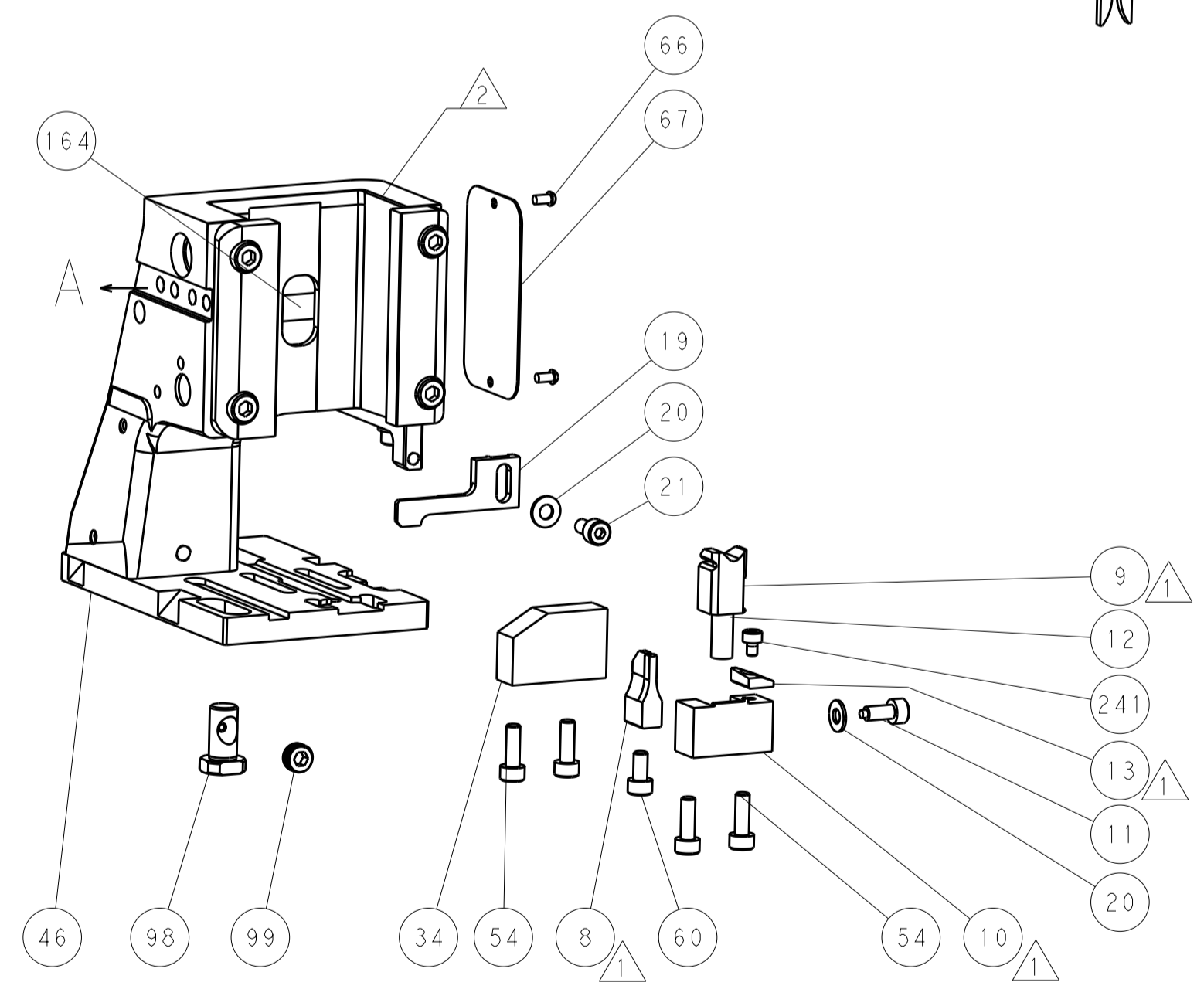
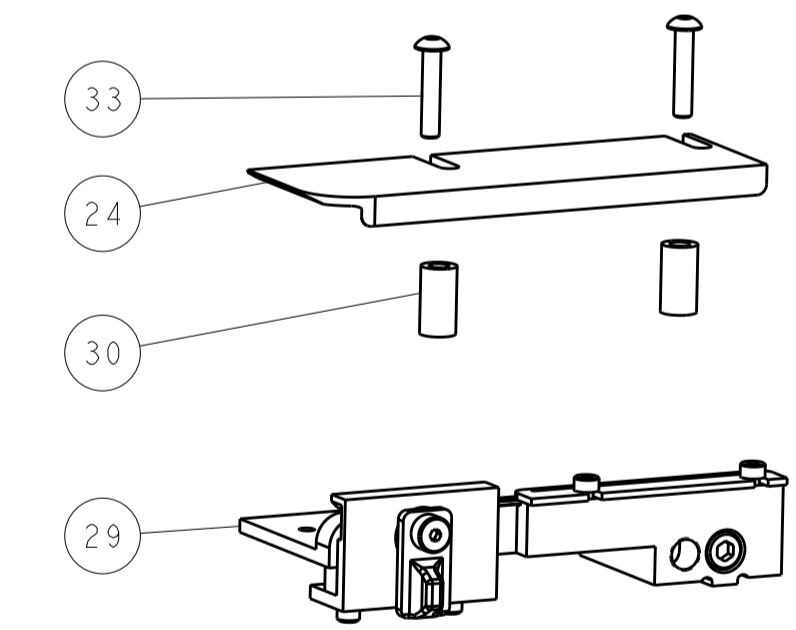
PNEUMATIC



TERMINAL SUPPORT LOCATION

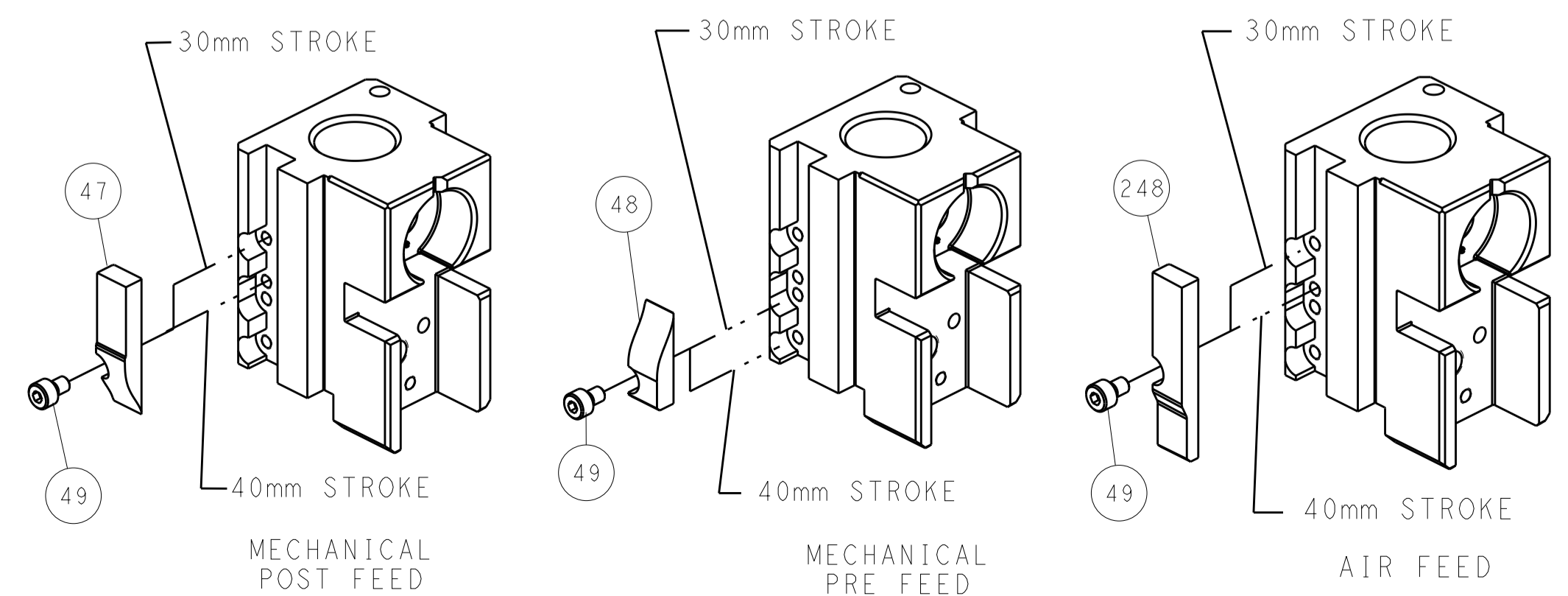


RAM SET-UP



FEED TRACK POSITION GUIDE BY INSULATION BARREL

CAM POSITIONS



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:		REVISIONS	
mm	0 PLC	±		REV	DATE
	1 PLC	±		1	09OCT2015
	2 PLC	±		2	09OCT2015
	3 PLC	±		3	09OCT2015
	4 PLC	±		4	09OCT2015
	ANGLES	±			
MATERIAL	FINISH	WEIGHT	SCALE	Customer Accessible Production Drawing	
			1:2	SHEET 1 OF 4 REV B	

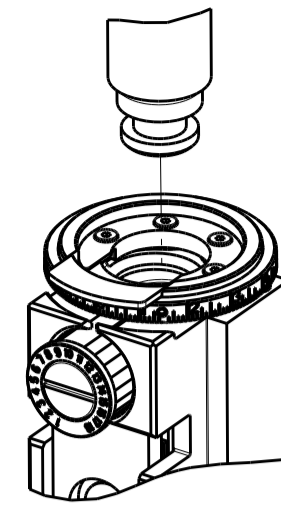


NAME: Ocean Side Feed Applicator

SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2836031

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2836031-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2836031-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2836031-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.98 mm [.078]	F
INSUL	2.50 mm [.098]	OV
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: KET TERMINAL		KET CRIMP SPECIFICATION	
TERMINAL NAME: 280(110) MALE TERMINAL			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
4.30-4.70 mm [1.69-.185 IN]		1.40-1.70 mm [.055-.067 IN]	
TERMINAL APPLICATION SPECIFICATION: 280 MALE TERMINAL S M L Rev 2010.10.29			
TERMINALS APPLIED ⁵			
TE TERMINAL	KET TERMINAL	TE TERMINAL	KET TERMINAL
2113893-1	ST741285-3		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
AVSS 0.5mm ²	1.25+/-0.05 [1.049+/-0.002]	6.8
AVSS 0.3mm ²	1.15+/-0.05 [1.045+/-0.002]	8.1



- ¹ RECOMMENDED SPARE PARTS
 - ² REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
 - ³ APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242.
 - ⁴ 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.
 - ⁵ TERMINAL LUBRICANT IS RECOMMENDED.
6. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.

***WARNING**
ON INSTALLATION, SET WIRE DISC TO CRIMP HEIGHT REFERENCE SETTING FOR LARGEST WIRE SIZE. CRIMP HEIGHT REFERENCE SETTINGS GREATER THAN THE VALUE SHOWN MAY CAUSE DAMAGE TO THE CRIMP TOOLING, REFER TO THE INSTRUCTION SHEET FOR PROPER SETUP AND ADJUSTMENTS.

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

LOC	DIST	REV	DATE	BY	APPV
-	-	SEE SHEET 1	-	-	-

REV	DATE	BY	APPV	DESCRIPTION	ITEM NO	
-	1	-	-	2119640-1	PUSH ROD, AIR FEED	250
-	1	-	-	1803259-1	BUSHING, FLANGED	249
-	1	1	-	2119082-4	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	-	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1	-	2119083-1	RETAINER, INSULATION DIAL	242
-	1	1	-	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
-	-	1	-	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	1	-	-	2063440-1	AIR FEED MODULE	238
-	2	-	-	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172
-	REF	REF	-	994970-2	COUNTER, MAGNETIC	164
-	1	-	-	240638-1	SPRING, FEED FINGER	163
-	1	-	-	2119641-2	FEED CAM, AIR FEED	151
-	1	1	-	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	144
-	4	4	-	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	143
-	-	1	-	2119653-2	FEED CAM, POST FEED	142
-	1	1	-	1-1803583-0	APPLICATOR BASIC ASSEMBLY, SF	141
-	1	1	-	1803516-1	RAM ASSEMBLY, SF PACIFIC	140
-	1	-	-	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854	137
-	1	-	-	2119799-1	HOLDER, FEED FINGER, AF	136
-	1	1	-	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113
-	1	1	-	2844908-1	SCREW, LOCKING	99
-	1	1	-	2844907-1	POST, LOCKING	98
-	1	1	-	455888-5	SPACER, CRIMPER	82
-	1	1	-	1803607-1	DOCUMENTATION PACKAGE	71
-	1	1	-	2119740-1	TAG, IDENTIFICATION	67
-	2	2	-	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	1	1	-	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	1	1	-	1338685-1	PAWL, FEED	56
-	2	2	-	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	53
-	1	1	-	5018030-1	NUT, HEX, REG, RoHS, M3	52
-	1	1	-	811242-5	BUMPER, HOLD DOWN	51
-	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	1	-	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
-	1	1	-	1752356-9	SUPPORT, TERMINAL	34
-	2	2	-	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	-	3-2844962-0	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	-	2844992-1	ASSEMBLY, STRIP GUIDE	29
-	1	1	-	455888-3	SPACER, CRIMPER	28
-	1	1	-	1320928-6	STRIP GUIDE	24
-	1	1	-	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
-	2	2	-	1-18028-2	WASHER, FLAT, REG M4	20
-	1	1	-	2119533-1	STRIPPER, SIDE FEED	19
-	1	1	-	2119806-1	INSERT, SHEAR	13
-	1	1	-	3-22280-3	SPRING, COMPRESSION	12
-	1	1	-	1-356885-4	STOP, SHEAR	11
-	1	1	-	2119805-1	SHEAR HOLDER, FRONT	10
-	1	1	-	1803095-1	FLOATING SHEAR, FRONT	9
-	1	1	1	7-1633928-2	ANVIL, COMBINATION	8
-	1	1	-	4-240641-7	SPACER	7
-	-	-	-	-	-	6
-	1	1	-	2119757-4	DEPRESSOR, SHEAR	5
-	1	1	-	1-238011-7	BLOCK, CRIMPER SPACER	4
-	1	1	1	1803341-1	CRIMPER, INSULATION OVERLAP PREMIUM	3
-	1	1	-	455888-5	SPACER, CRIMPER	2
-	1	1	1	4-1333281-5	CRIMPER, WIRE PREMIUM	1

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		MATERIAL:		FINISH:	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES	FINISH

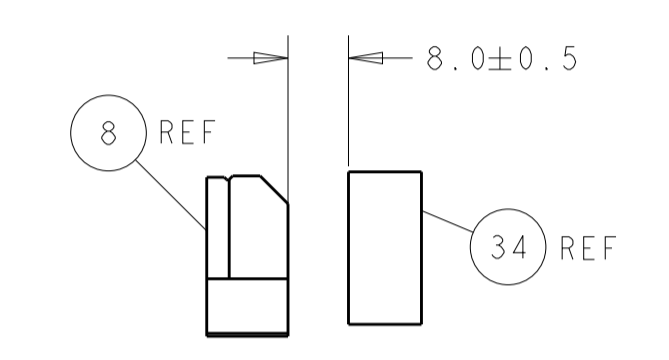
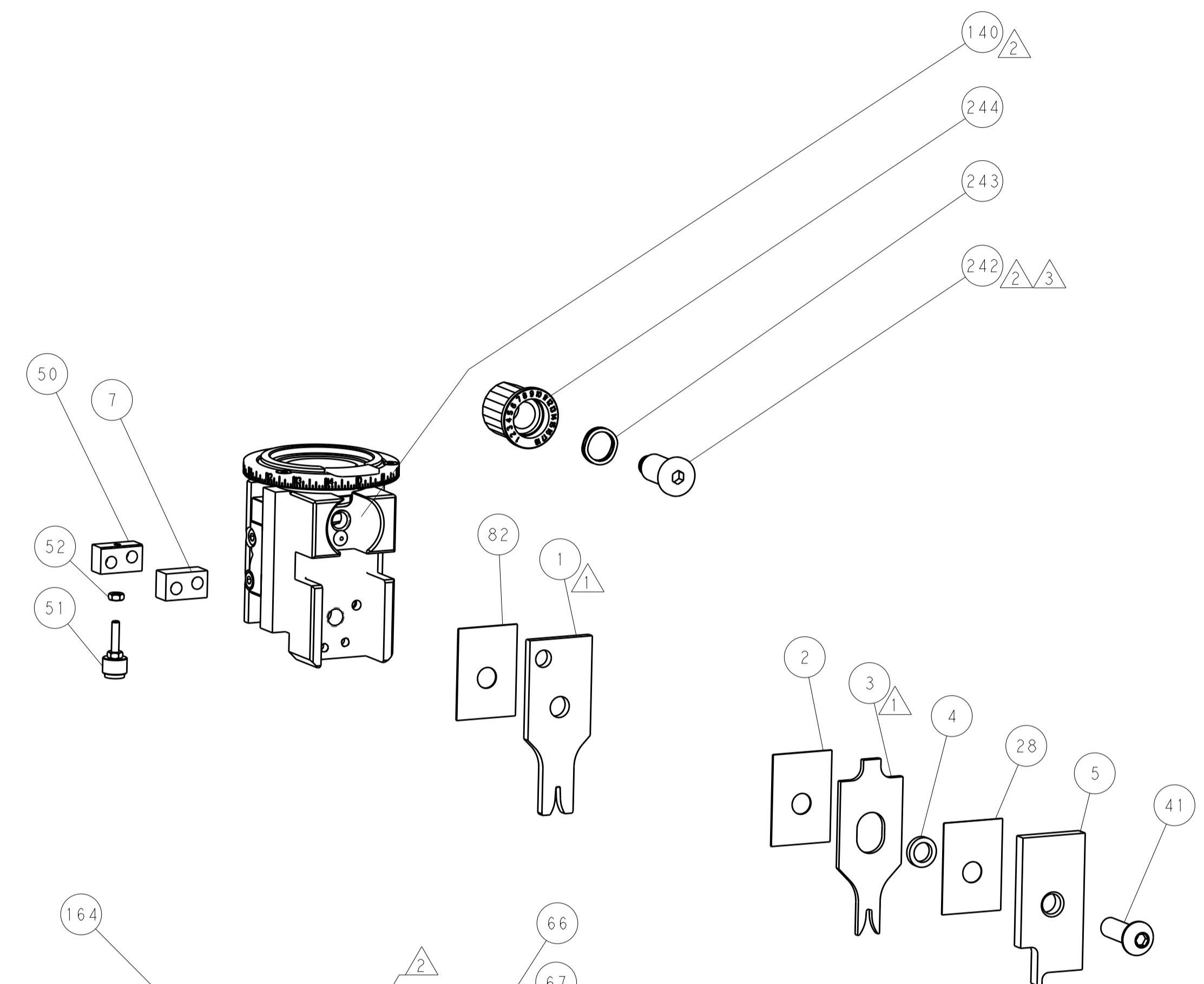
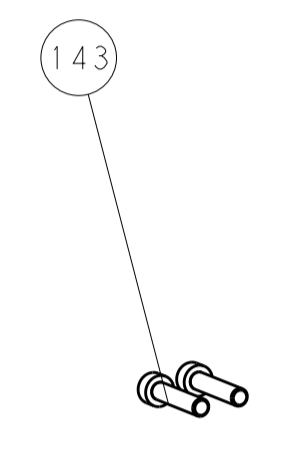
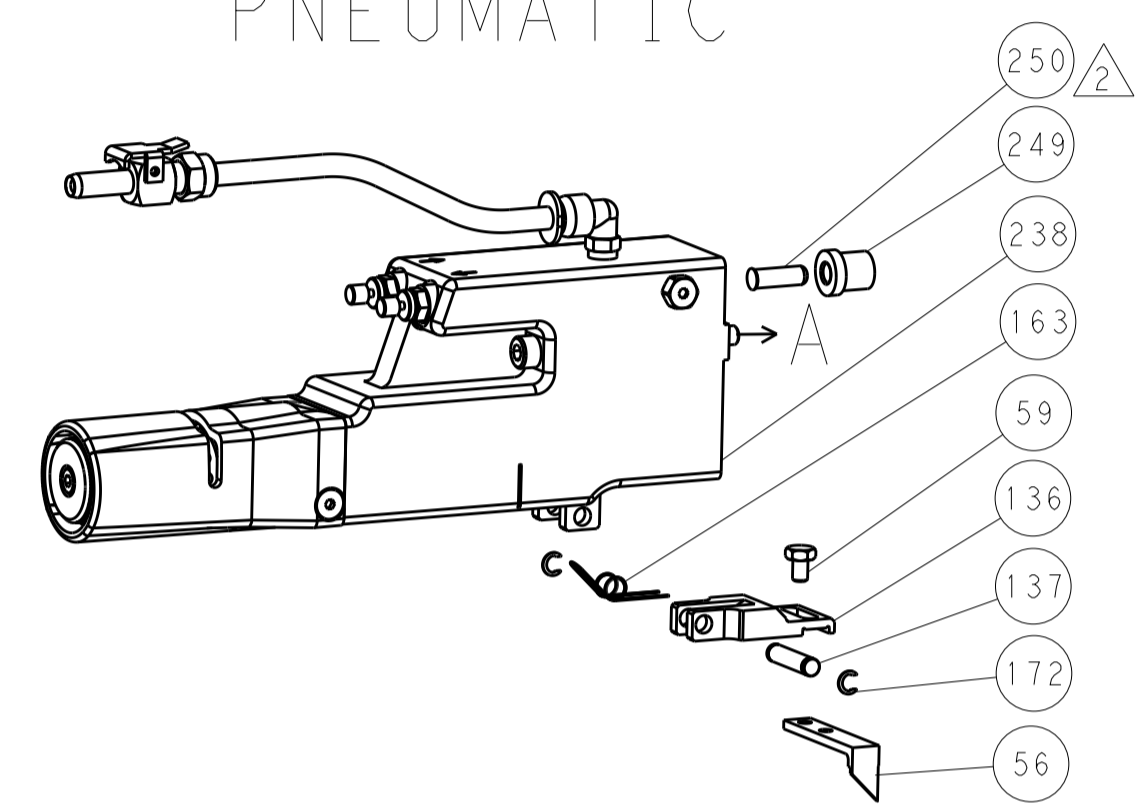
OWN	M. RILEY	09OCT2015
CHK	T. ELBIN	09OCT2015
APPV	D. STOUGH	09OCT2015
NAME	Ocean Side Feed Applicator	
PRODUCT SPEC		
APPLICATION SPEC		
SIZE	CAGE CODE	DRAWING NO
A1	00779	2836031
Customer Accessible Production Drawing		
SCALE	1:2	SHEET 1 OF 4
REV	B	

LOC	DIST	REVISIONS				
		P. LTM	DESCRIPTION	DATE	DMN	APVD
-	-	SEE SHEET 1				

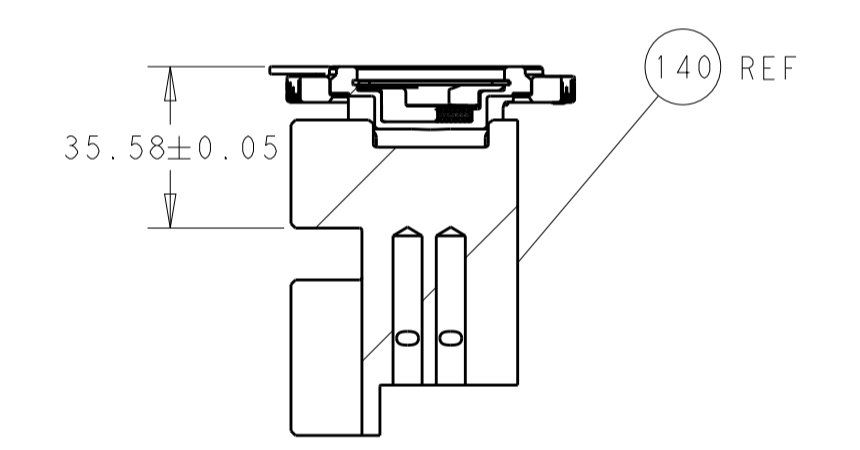
FEED TYPE MECHANICAL



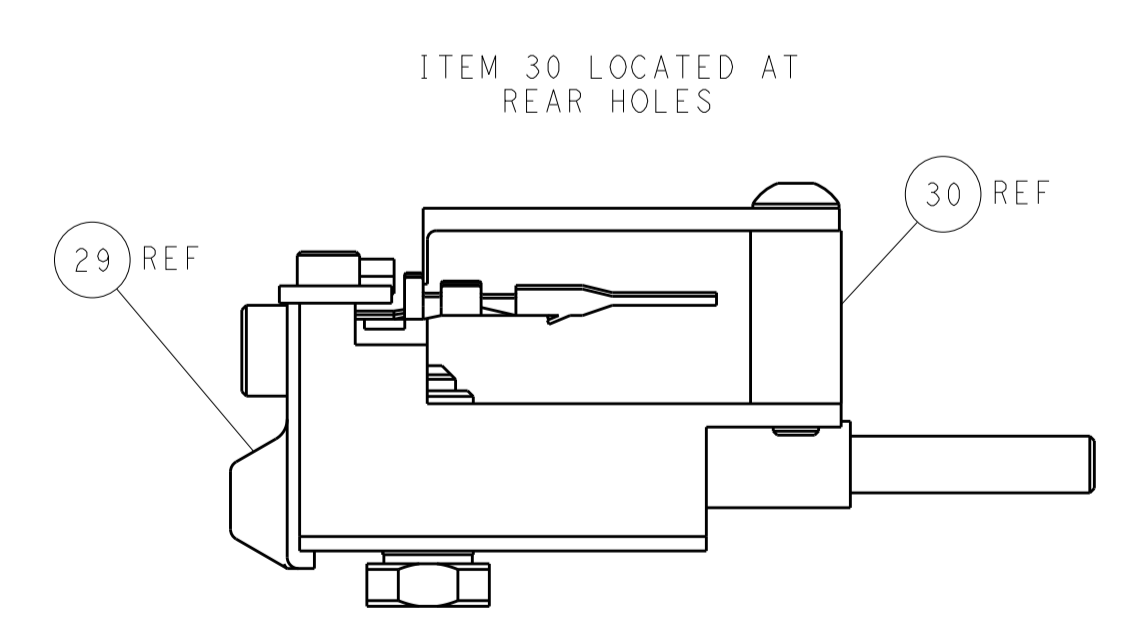
PNEUMATIC



TERMINAL SUPPORT LOCATION

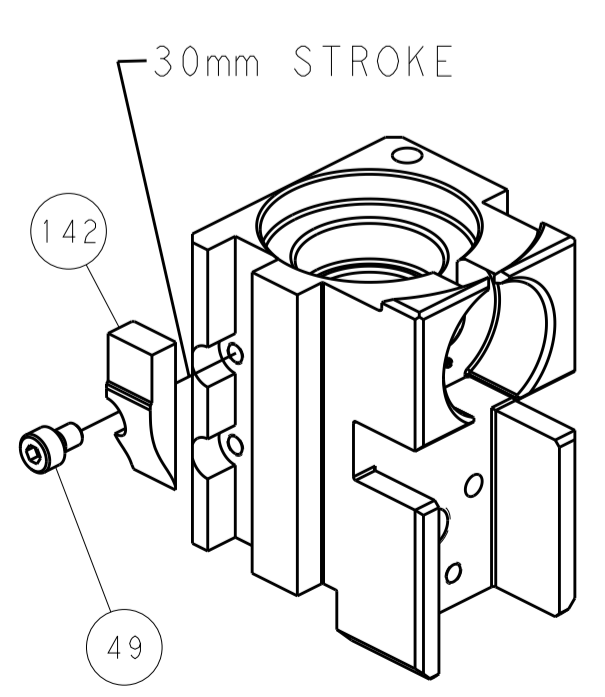


RAM SET-UP

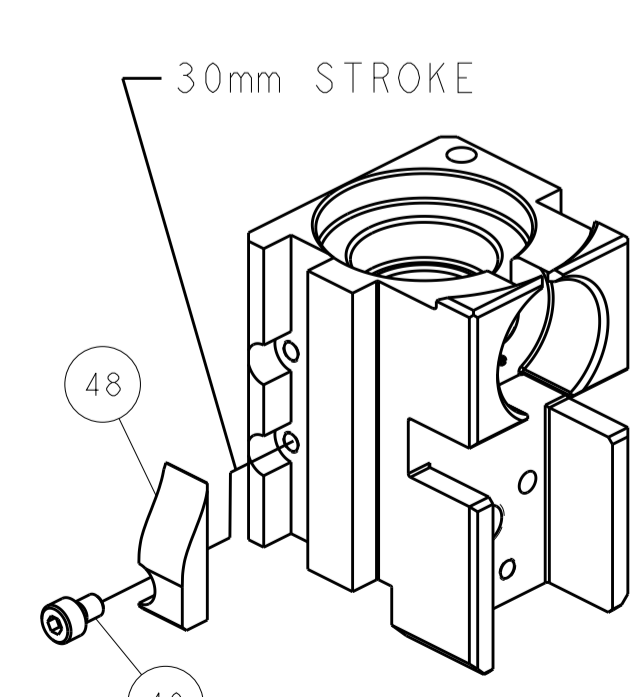


FEED TRACK POSITION
GUIDE BY INSULATION BARREL

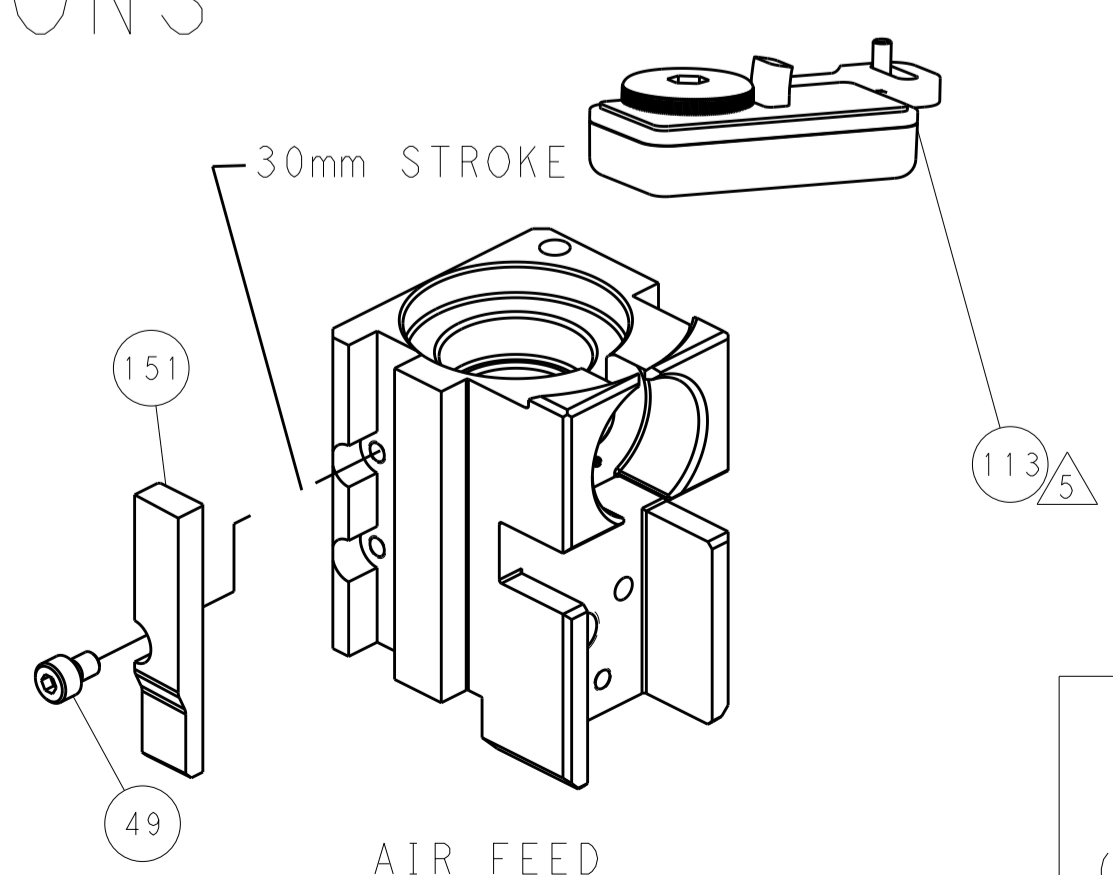
CAM POSITIONS



MECHANICAL
POST FEED



MECHANICAL
PRE FEED



AIR FEED

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:		DMN: M. RILEY 09OCT2015	STE
mm	0 PLC ±	1 PLC ±	2 PLC ±	CHK: T. ELBIN 09OCT2015	
MATERIAL:		FINISH:		APVD: D. STOUGH 09OCT2015	NAME: Ocean Side Feed Applicator
-		-		PRODUCT SPEC:	
-		-		APPLICATION SPEC:	SIZE: CAGE CODE: DRAWING NO:
-		-		WEIGHT:	A1 00779 C=2836031
-		-		Customer Accessible Production Drawing	SCALE: 1:2 SHEET 1 OF 4 REV B