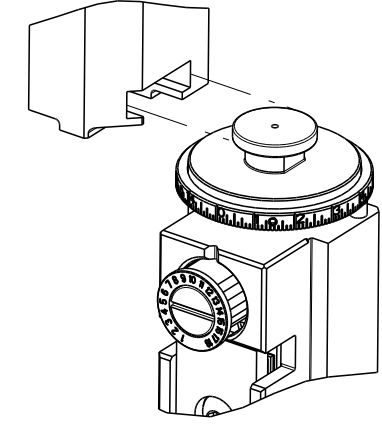


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2836333-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2836333-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2836333-1	B	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2836333-2	B	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2836333-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.78 mm [.070]	F
INSUL	2.03 mm [.080]	O

APPLICATOR INSTRUCTIONS 408-35042

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: AMP TAB CONTACT			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
2.92-3.68 mm [.115-.145 IN]		Ø1.40-1.80 mm [.055-.071 IN]	
TERMINAL APPLICATION SPECIFICATION	108-9208		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
583278-2			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
18 AWG	1.35+/-0.05 [.053+/-0.002]	8.4
20 AWG	1.24+/-0.05 [.049+/-0.002]	9.4
22 AWG	1.24+/-0.05 [.049+/-0.002]	9.4

- RECOMMENDED SPARE PARTS
- REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242.
- 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.
- TERMINAL LUBRICANT IS RECOMMENDED.
- 6. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- EXCEEDING MAXIMUM CMA OF 1630 WILL CAUSE WIRE BARREL SEAM TO NOT CLOSE.

**\*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)

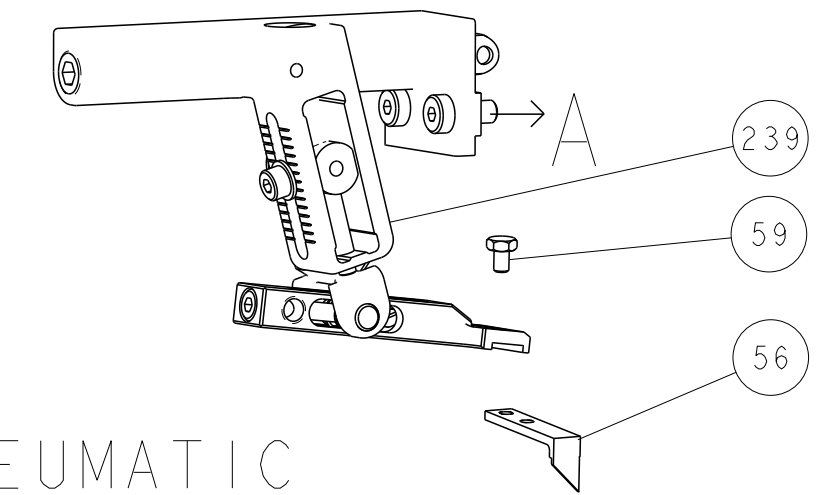
REVISIONS				
P	LTN	DESCRIPTION	DATE	APVD
A		RELEASED	10MAY2017	TB TE
B		ECR-23-172696	20APR2023	JWC TE

-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248
-	1	1	1	1	2119082-5	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	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	-	2844940-1	AIR FEED MODULE	238
-	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	1	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	455888-4	SPACER, CRIMPER	82
-	1	1	1	1	1803607-3	DOCUMENTATION PACKAGE	71
-	1	1	1	1	2119791-9	DEPRESSOR, WIRE	70
-	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	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	690753-2	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	1752356-2	SUPPORT, TERMINAL	34
-	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	2	2	2-2844962-6	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	1	1	2844992-1	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	2119533-1	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	1803095-6	FLOATING SHEAR, FRONT	9
-	1	2	2	1	1-1803318-3	ANVIL, COMBINATION	8
-	-	-	-	-	-	-	7
-	-	-	-	-	-	-	6
-	1	1	1	1	2119757-8	DEPRESSOR, SHEAR	5
-	1	1	1	1	2-238011-5	BLOCK, CRIMPER SPACER	4
-	1	2	2	1	1803365-3	CRIMPER, INSULATION O	3
-	1	1	1	1	455888-5	SPACER, CRIMPER	2
-	1	2	2	1	4-456404-4	CRIMPER, WIRE PREMIUM	1
-	77	-72	-71	-2	-1	PART NO	ITEM NO

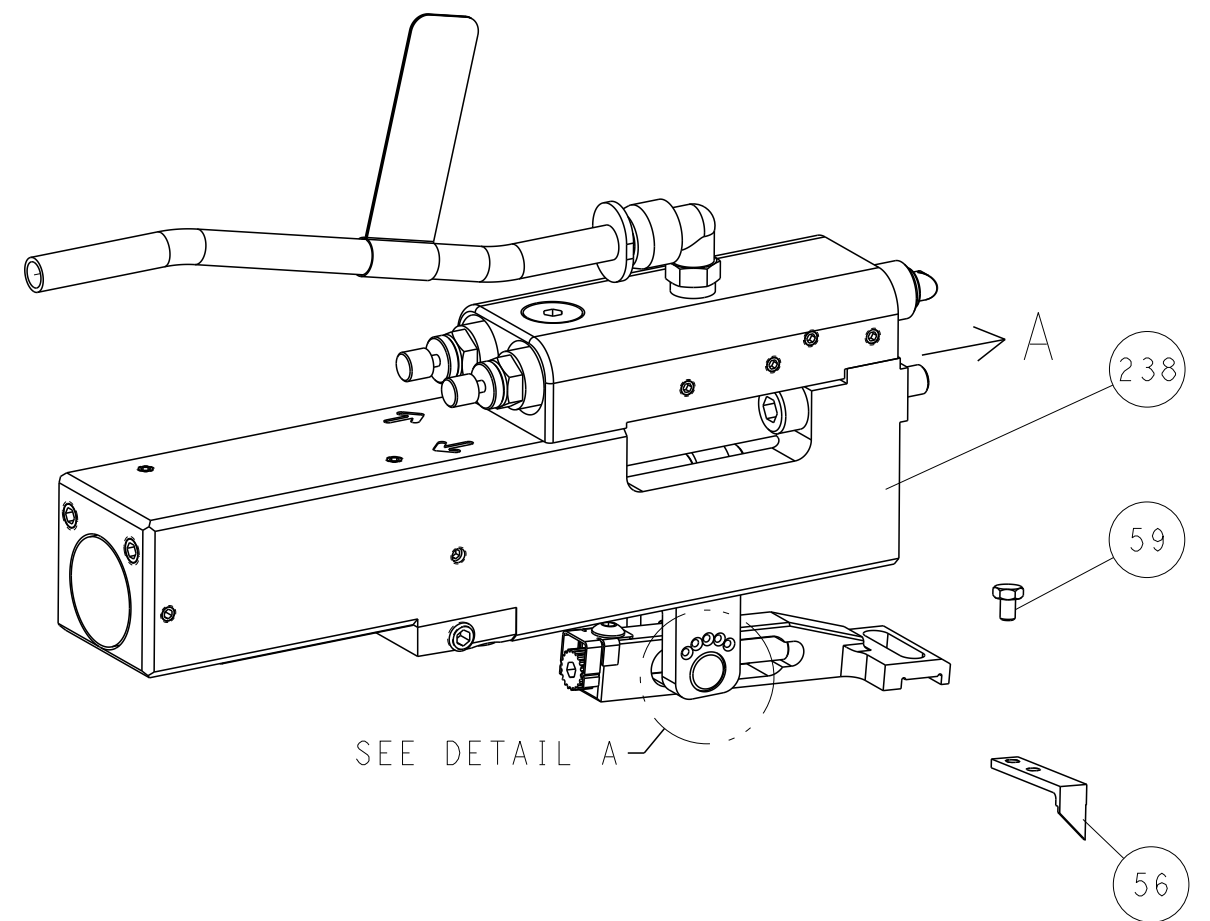
THIS DRAWING IS A CONTROLLED DOCUMENT.		OWN: M. RILEY 01JUN2016	TE Connectivity	
DIMENSIONS: mm		CHK: T. ELBIN 01JUN2016		
TOLERANCES UNLESS OTHERWISE SPECIFIED:		APVD: J. DEGRANGE 01JUN2016	Name: Ocean Side Feed Applicator	
0 PLC ±		PRODUCT SPEC	SIZE: A1	
1 PLC ±		APPLICATION SPEC	CAGE CODE: C=2836333	
2 PLC ±			RESTRICTED TO	
3 PLC ±			CUSTOMER ACCESSIBLE PRODUCTION DRAWING	
4 PLC ±			SCALE: 1:2	
ANGLES ±		WEIGHT	SHEET 1 OF 4	
FINISH			REV B	

REVISIONS				
P	LTN	DESCRIPTION	DATE	APVD
-	-	SEE SHEET 1	-	-

# FEED TYPE MECHANICAL



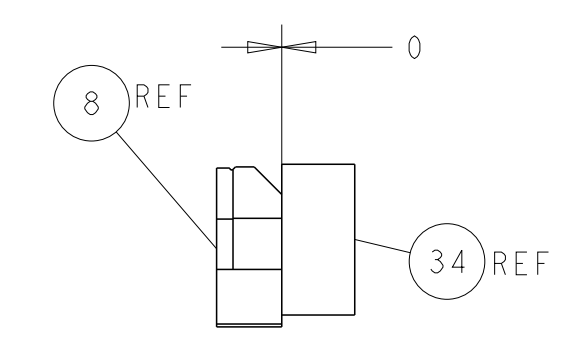
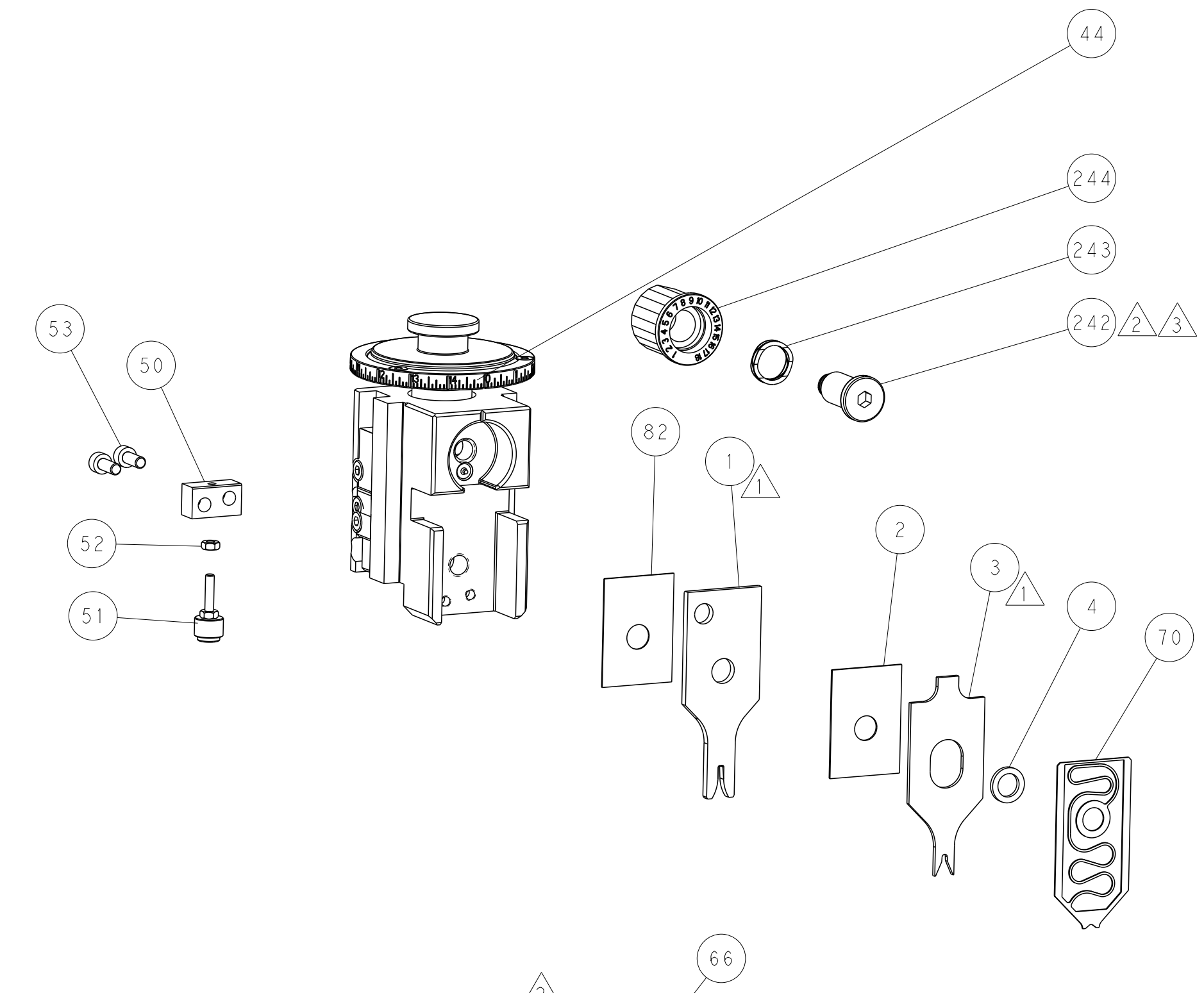
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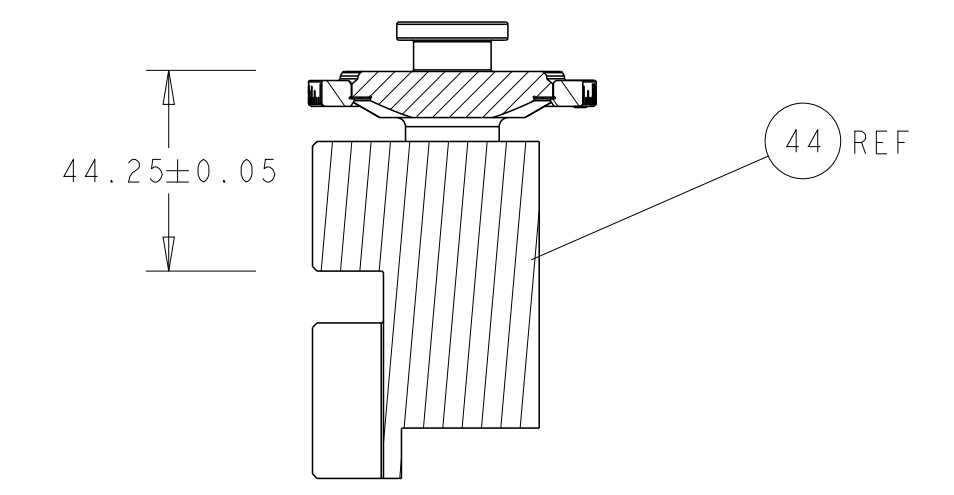
## FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



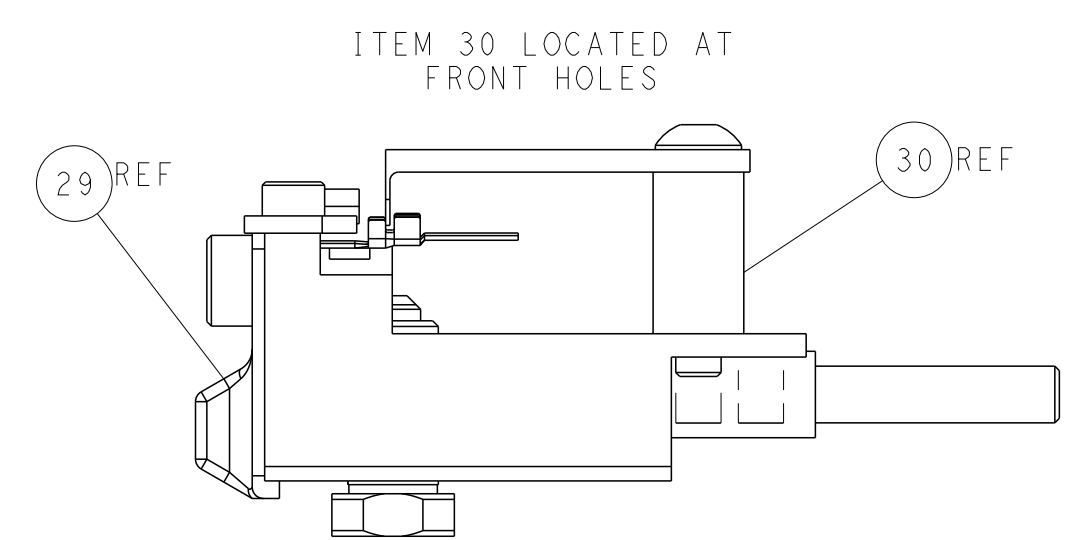
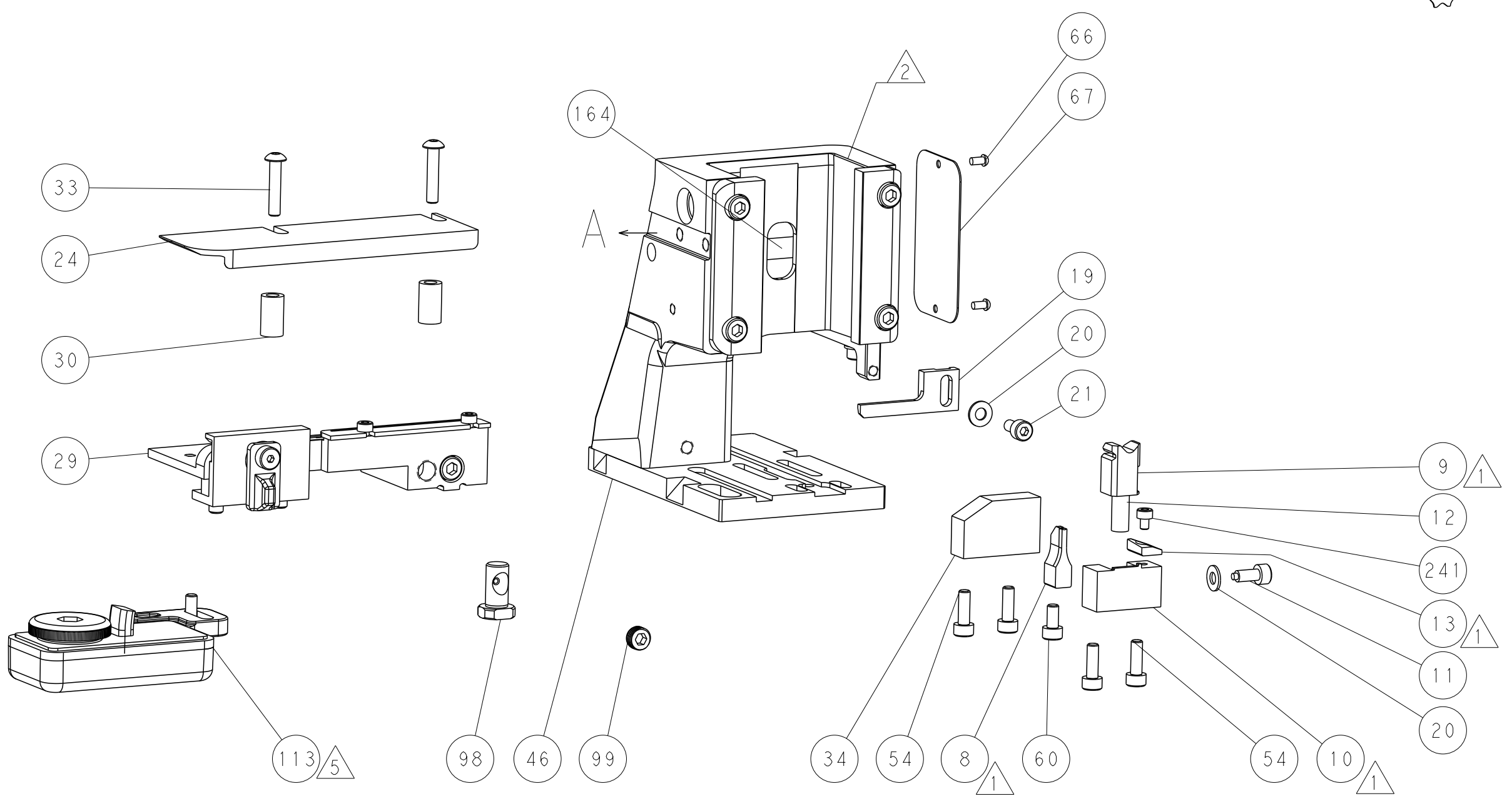
DETAIL A



TERMINAL SUPPORT LOCATION

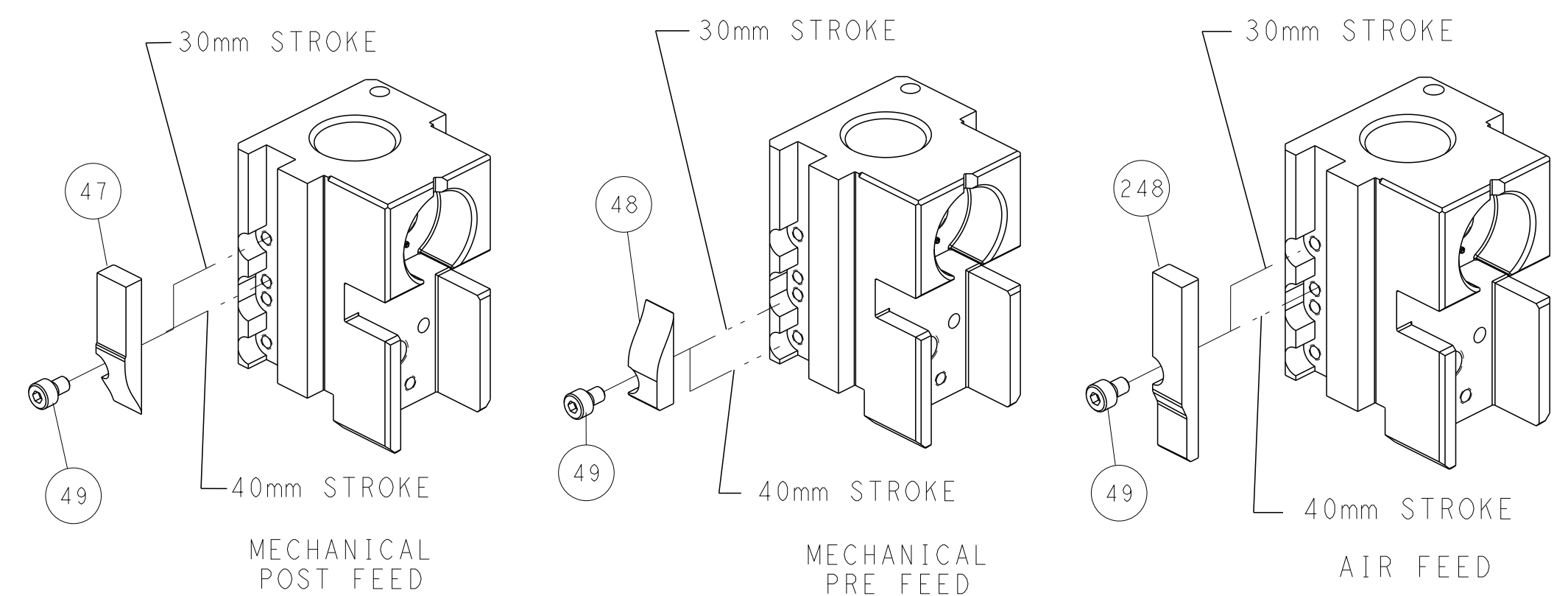


RAM SET-UP



FEED TRACK POSITION GUIDE BY INSULATION BARREL

# CAM POSITIONS

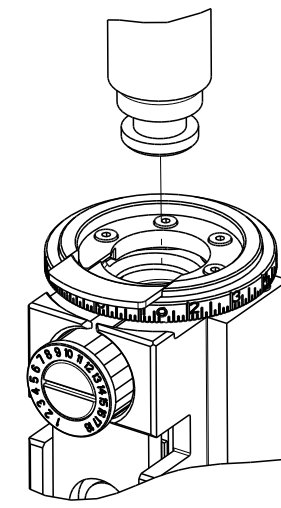


**ATLANTIC VERSION**  
 Shown on sheets 1 of 4 & 2 of 4  
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

THIS DRAWING IS A CONTROLLED DOCUMENT.		OWN: M. RILEY 01JUN2016	TE Connectivity
DIMENSIONS: mm		CHK: T. ELBIN 01JUN2016	
TOLERANCES UNLESS OTHERWISE SPECIFIED:		APVD: J. DEGRANGE 01JUN2016	NAME: Ocean Side Feed Applicator
0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH ±		PRODUCT SPEC	APPLICATION SPEC
MATERIAL		WEIGHT	SIZE: A1
		CUSTOMER ACCESSIBLE PRODUCTION DRAWING	SCALE: 1:2 SHEET 2 OF 4 REV B

THIS DRAWING IS UNPUBLISHED.	RELEASED FOR PUBLICATION	20	
COPYRIGHT 20 BY - ALL RIGHTS RESERVED.			
PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2836333-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2836333-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2836333-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR  
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.78 mm [.070]	F
INSUL	2.03 mm [.080]	O
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION
TERMINAL NAME: AMP TAB CONTACT		
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE
2.92-3.68 mm [1.15-.145 IN]		∅1.40-1.80 mm [.055-.071 IN]
TERMINAL APPLICATION SPECIFICATION	108-9208	
TERMINALS APPLIED <sup>5</sup>		
TE TERMINAL	TE TERMINAL	TE TERMINAL
583278-2		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
18 AWG	1.35+/-0.05 [.053+/-0.002]	8.4
20 AWG	1.24+/-0.05 [.049+/-0.002]	9.4
22 AWG	1.24+/-0.05 [.049+/-0.002]	9.4



- <sup>1</sup> RECOMMENDED SPARE PARTS
- <sup>2</sup> REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- <sup>3</sup> APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242.
- <sup>4</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>5</sup> TERMINAL LUBRICANT IS RECOMMENDED.
- 6. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- <sup>7</sup> EXCEEDING MAXIMUM CMA OF 1630 WILL CAUSE WIRE BARREL SEAM TO NOT CLOSE.

REVISIONS				
P	LTN	DESCRIPTION	DATE	OWN
-	-	SEE SHEET 1	-	-

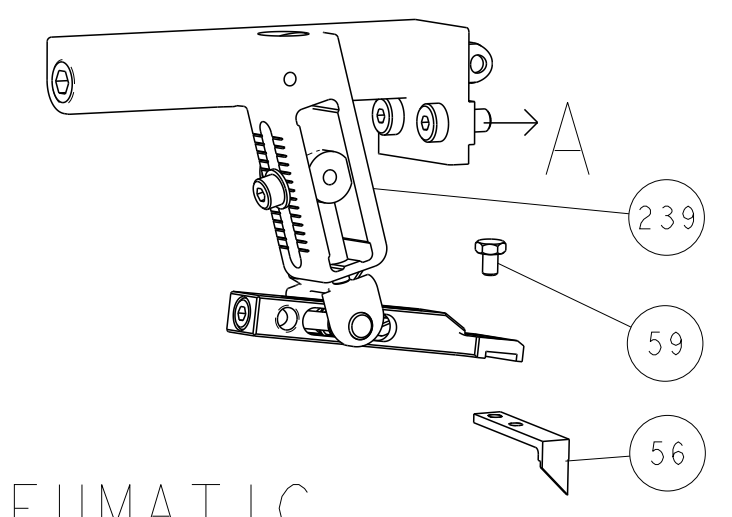
-	1	1	2119082-5	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
<sup>3</sup>	-	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
-	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	1	-	2844940-1	AIR FEED MODULE	238
-	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	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
<sup>5</sup>	-	1	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113
-	1	1	2844908-1	SCREW, LOCKING	99
-	1	1	2844907-1	POST, LOCKING	98
-	1	1	455888-4	SPACER, CRIMPER	82
-	1	1	1803607-3	DOCUMENTATION PACKAGE	71
-	1	1	2119791-9	DEPRESSOR, WIRE	70
-	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	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	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	1752356-2	SUPPORT, TERMINAL	34
-	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	2-2844962-6	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29
-	1	1	1320928-2	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
<sup>7</sup>	-	1	2119806-1	INSERT, SHEAR	13
-	1	1	3-22280-3	SPRING, COMPRESSION	12
-	1	1	1-356885-4	STOP, SHEAR	11
<sup>7</sup>	-	1	2119805-1	SHEAR HOLDER, FRONT	10
<sup>7</sup>	-	1	1803095-6	FLOATING SHEAR, FRONT	9
<sup>7</sup>	1	1	1-1803318-3	ANVIL, COMBINATION	8
-	-	-	-	-	7
-	-	-	-	-	6
-	1	1	2119757-8	DEPRESSOR, SHEAR	5
-	1	1	2-238011-5	BLOCK, CRIMPER SPACER	4
<sup>7</sup>	1	1	1803365-3	CRIMPER, INSULATION O	3
-	1	1	455888-5	SPACER, CRIMPER	2
<sup>7</sup>	1	1	4-456404-4	CRIMPER, WIRE PREMIUM	1

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

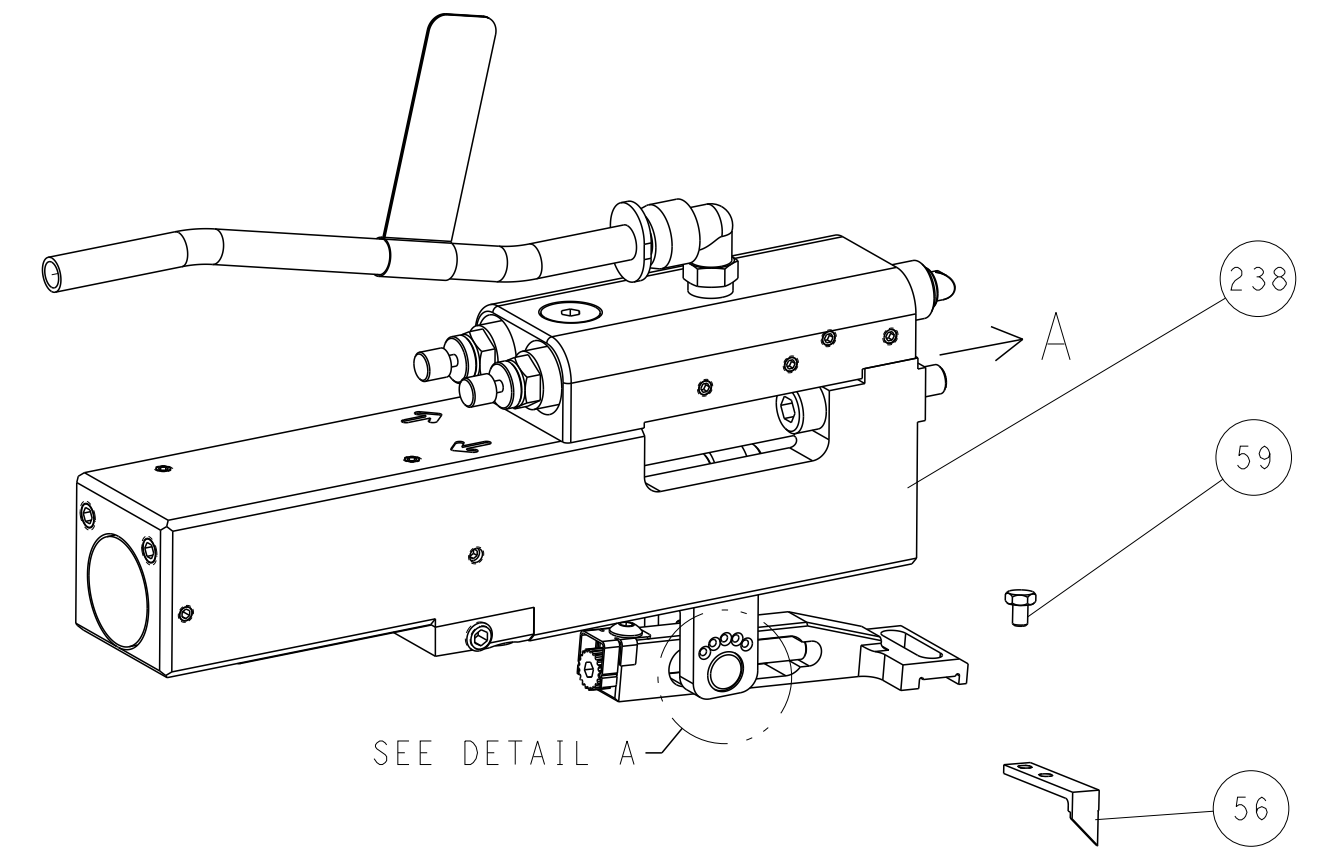
THIS DRAWING IS A CONTROLLED DOCUMENT.		OWN	M. RILEY	01JUN2016	 TE Connectivity
DIMENSIONS:		CHK	T. ELBIN	01JUN2016	
mm	TOLERANCES UNLESS OTHERWISE SPECIFIED:	APVD	J. DEGRANGE	01JUN2016	Name
0 PLC ±	1 PLC ±	PRODUCT SPEC			Ocean Side Feed
2 PLC ±	3 PLC ±	APPLICATION SPEC			Applicator
4 PLC ±	ANGLES ±	SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
MATERIAL	FINISH	WEIGHT	A1	C=2836333	
CUSTOMER ACCESSIBLE PRODUCTION DRAWING		SCALE	1:2	SHEET 3 OF 4	REV B

REVISIONS				
P.	LTN.	DESCRIPTION	DATE	APVD.
-	-	SEE SHEET 1	-	-

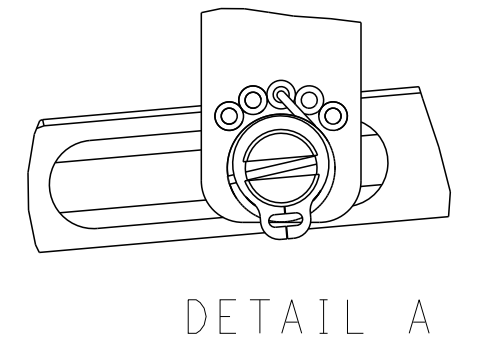
# FEED TYPE MECHANICAL



## PNEUMATIC

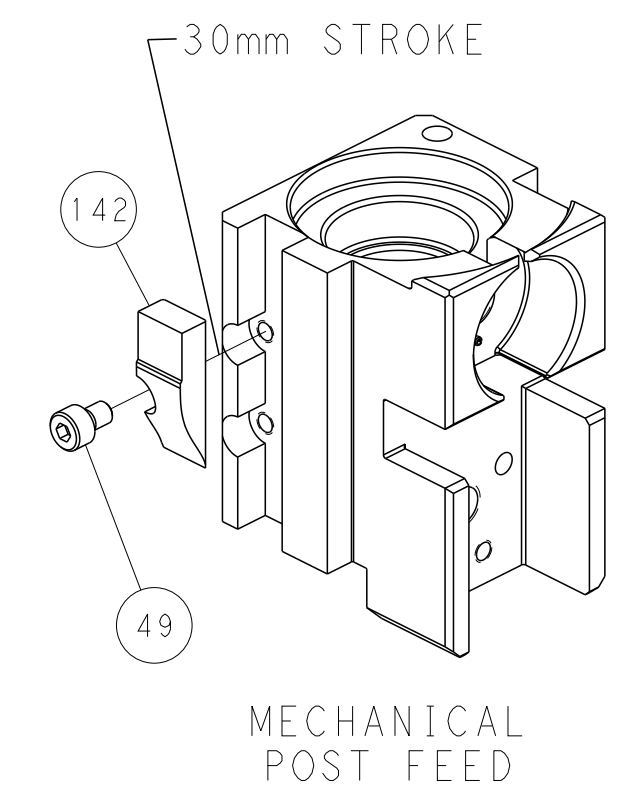


### FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)

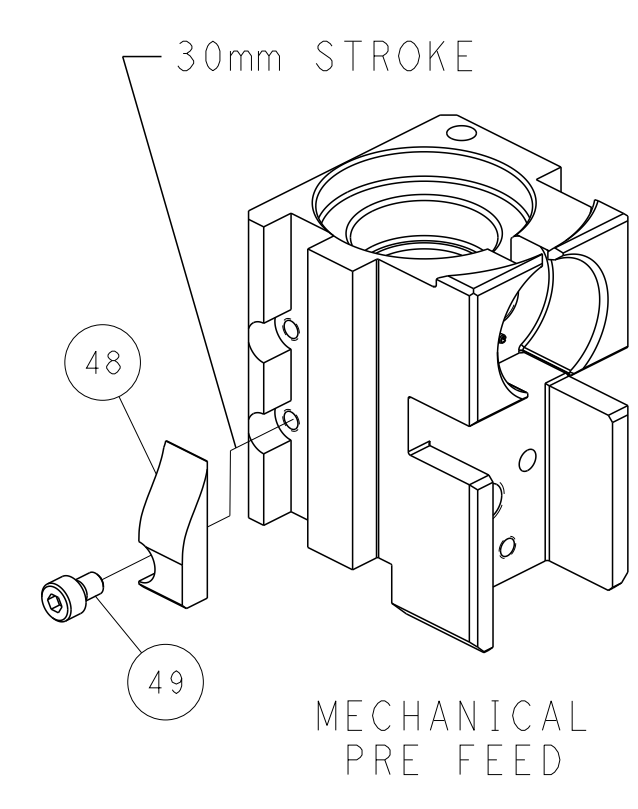


DETAIL A

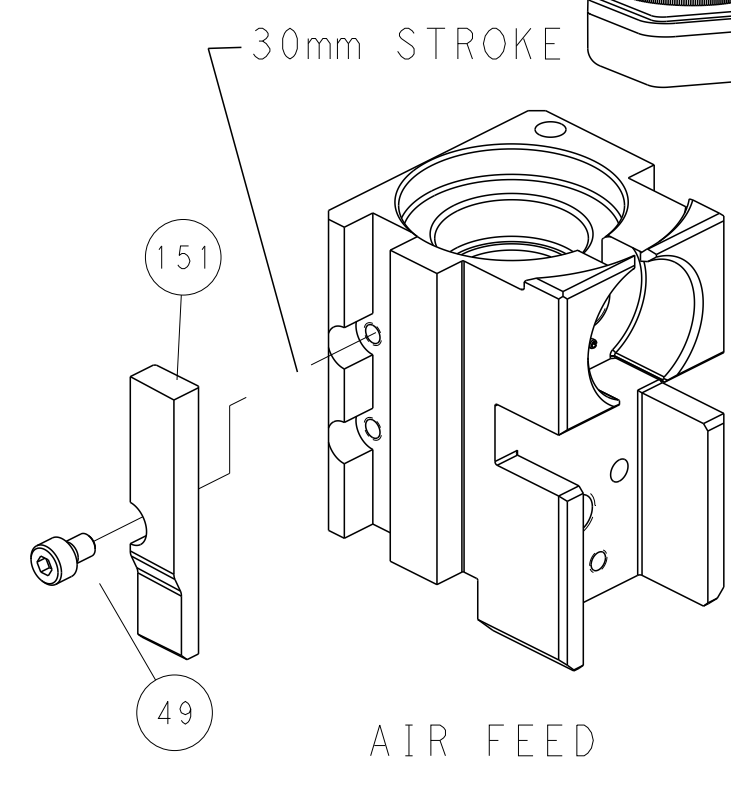
## CAM POSITIONS



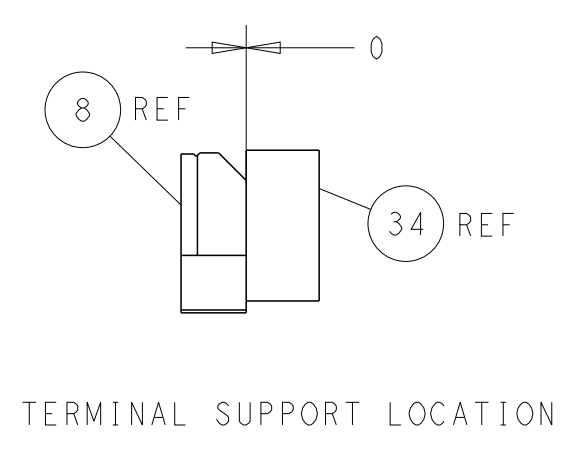
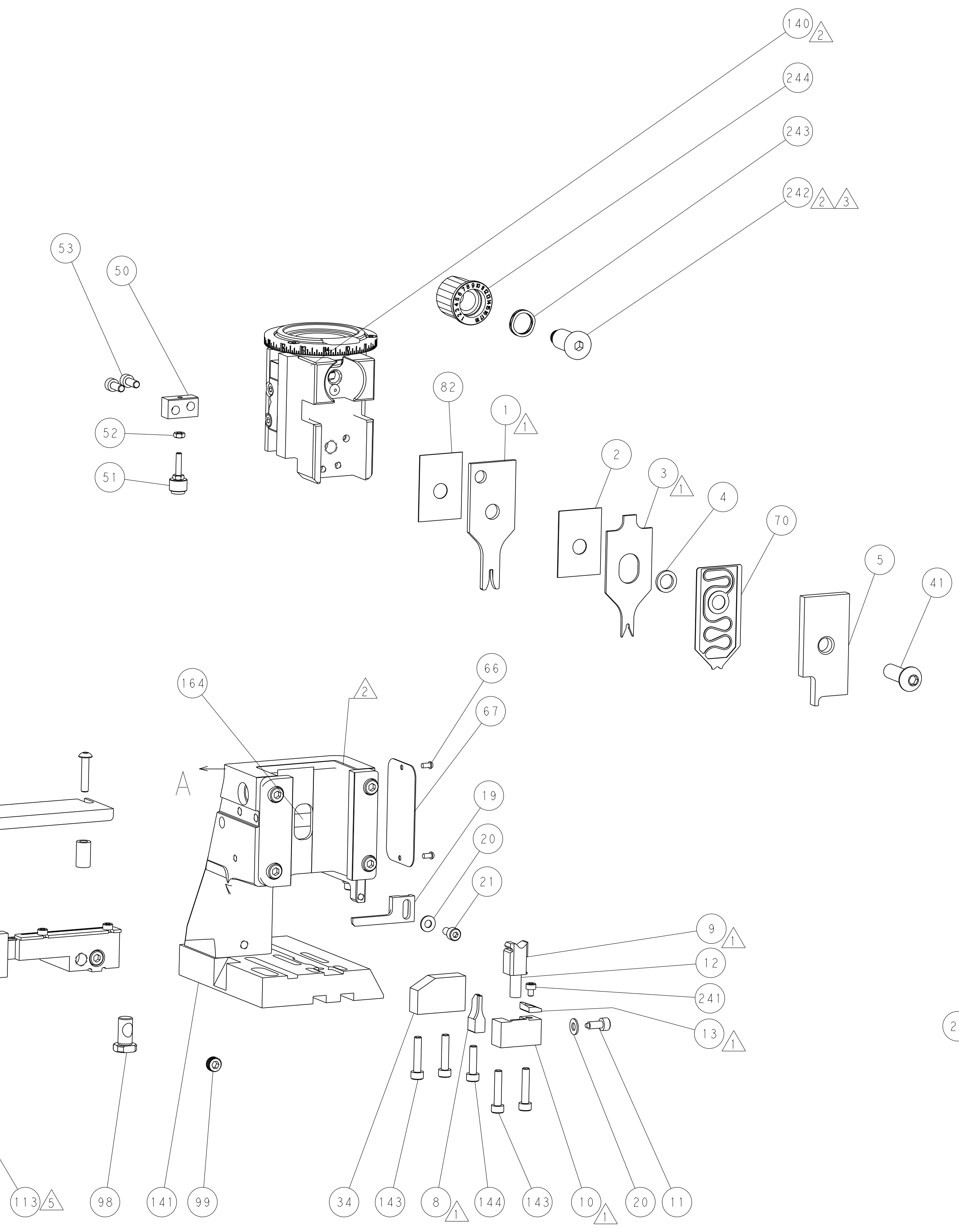
MECHANICAL  
POST FEED



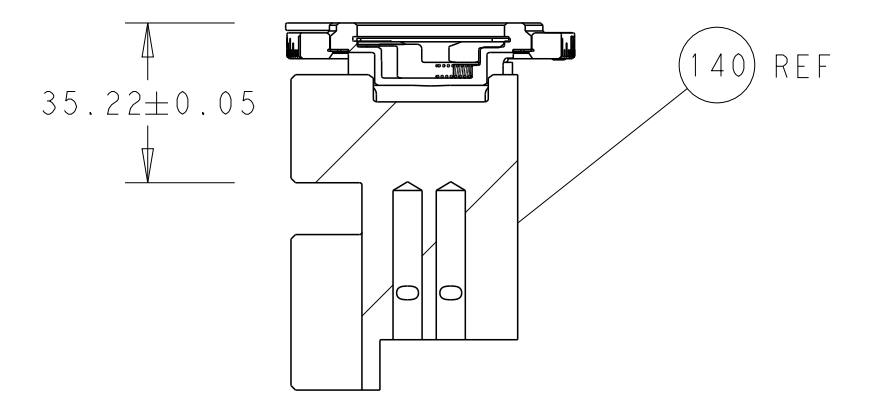
MECHANICAL  
PRE FEED



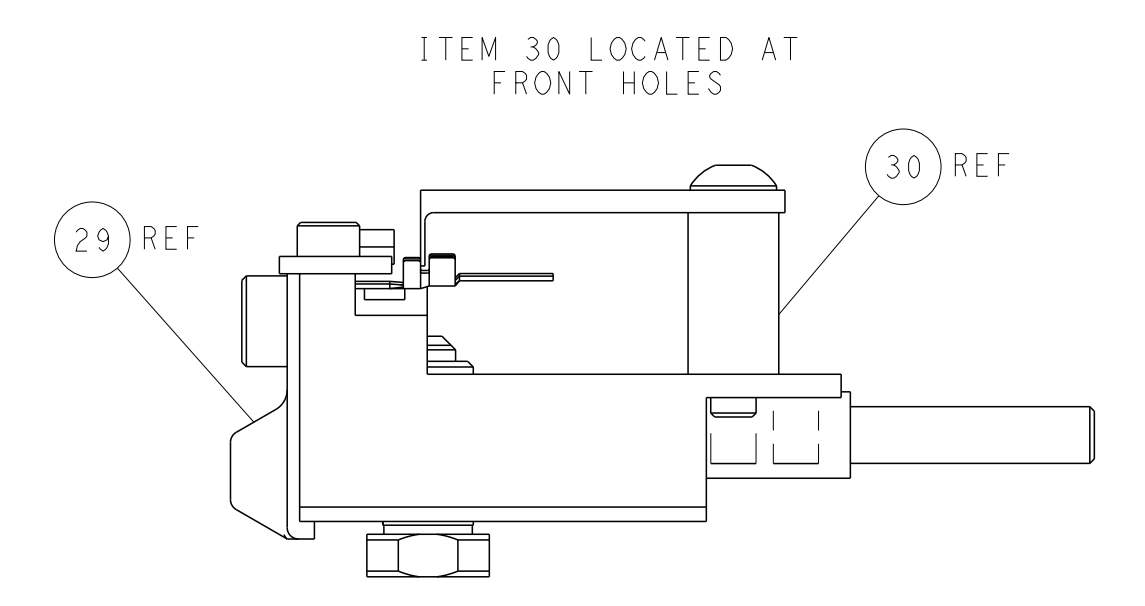
AIR FEED



TERMINAL SUPPORT LOCATION



RAM SET-UP



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)

THIS DRAWING IS A CONTROLLED DOCUMENT.		OWN: M. RILEY 01JUN2016	TE Connectivity
DIMENSIONS: mm		CHK: T. ELBIN 01JUN2016	
TOLERANCES UNLESS OTHERWISE SPECIFIED:		APVD: J. DEGRANGE 01JUN2016	NAME: Ocean Side Feed Applicator
0 PLC ±		PRODUCT SPEC	APPLICATION SPEC
1 PLC ±		SIZE: A1	CAGE CODE: C=2836333
2 PLC ±		WEIGHT	SCALE: 1:2
3 PLC ±		CUSTOMER ACCESSIBLE PRODUCTION DRAWING	SHEET 4 OF 4
4 PLC ±		RESTRICTED TO	REV B
ANGLES FINISH		SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION	