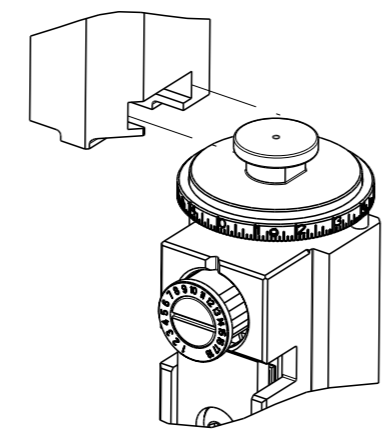


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2836341-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2836341-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2836341-1	B	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2836341-2	B	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2836341-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.03 mm [.080]	F
INSUL	2.35 mm [.093]	OV

APPLICATOR INSTRUCTIONS
408-35042

TERMINAL DATA: MOLEX TERMINAL MOLEX CRIMP SPECIFICATION			
TERMINAL NAME: NSCC 1.5 RECEPTACLE TERMINAL			
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE		
4.20-4.80 mm [1.65-.189 IN]	1.40-2.15 mm [.055-.085 IN]		
TERMINAL APPLICATION SPECIFICATION	AS-98897-001-C Rev C		
TERMINALS APPLIED			
TE TERMINAL	MOLEX TERMINAL	TE TERMINAL	MOLEX TERMINAL
2303589-1	98897-1119		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.00mm ²	1.18 +/- 0.05 [1.046 +/- .002]	4.1
0.75mm ²	1.10 +/- 0.05 [1.043 +/- .002]	4.9
0.50mm ²	1.07 +/- 0.05 [1.042 +/- .002]	5.3

- 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	DESCRIPTION	DATE	OWN	APVD
1				DEVELOPMENT	16 JUN 2016	JH	LZ	
A				RELEASED	05 AUG 2016	JH	TE	
B				ECR-19-019362	12 DEC 2019	FJ	TE	

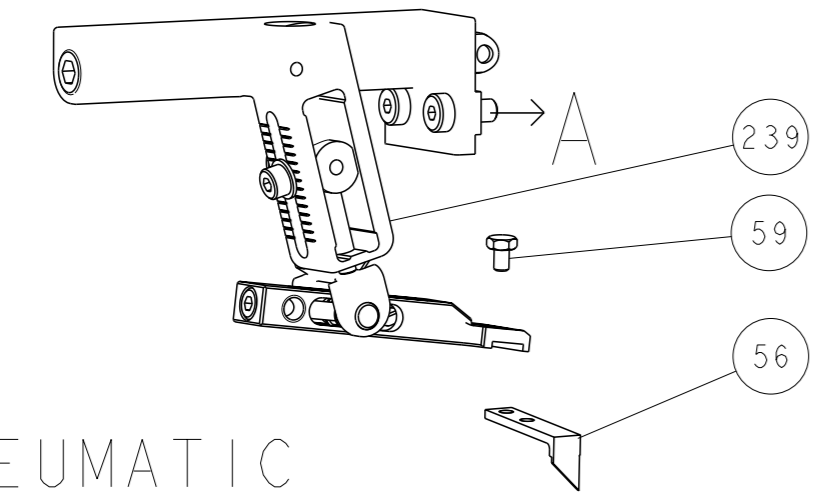
-	1	-	1	-	2119641-1	FEED CAM, AIR FEED		248
-	1	1	1	1	2119082-4	CAM, SNAIL, INSULATION ADJUSTMENT		244
-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST		243
3	-	1	1	1	2119083-1	RETAINER, INSULATION DIAL		242
-	1	1	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0		241
-	-	1	-	1	2119580-1	MECHANICAL FEED ASSEMBLY		239
-	1	-	1	-	2844940-1	AIR FEED MODULE		238
-	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC		164
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	455888-6	SPACER, CRIMPER		82
-	1	1	1	1	1803607-3	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	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	3-1752356-3	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	2844992-4	ASSEMBLY, STRIP GUIDE		29
-	1	1	1	1	455888-5	SPACER, CRIMPER		28
-	1	1	1	1	240792-1	DRAG, TERMINAL		25
-	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	1803095-3	FLOATING SHEAR, FRONT		9
1	1	2	2	1	1	6-1633920-3	ANVIL, COMBINATION	8
-	-	-	-	-	-	-	-	7
-	-	-	-	-	-	-	-	6
-	1	1	1	1	2119757-8	DEPRESSOR, SHEAR		5
-	1	1	1	1	3-238011-5	BLOCK, CRIMPER SPACER		4
1	1	2	2	1	1	2-1633964-9	CRIMPER, INSULATION OVERLAP PREMIUM	3
-	1	1	1	1	455888-5	SPACER, CRIMPER		2
1	1	2	2	1	1	3-456405-7	CRIMPER, WIRE PREMIUM	1
-	-	-	-	-	-	-	-	-
-	-	-	-	-	-	-	-	-

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		OWN		CHK		APVD	
mm	PLC	±	°	DATE	NAME	DATE	NAME	DATE	NAME
0 PLC	±			16 JUN 2016	J. HOU	16 JUN 2016	L. ZHANG	16 JUN 2016	L. ZHANG
1 PLC	±								
2 PLC	±								
3 PLC	±								
4 PLC	±								
ANGLES	±								
FINISH	±								

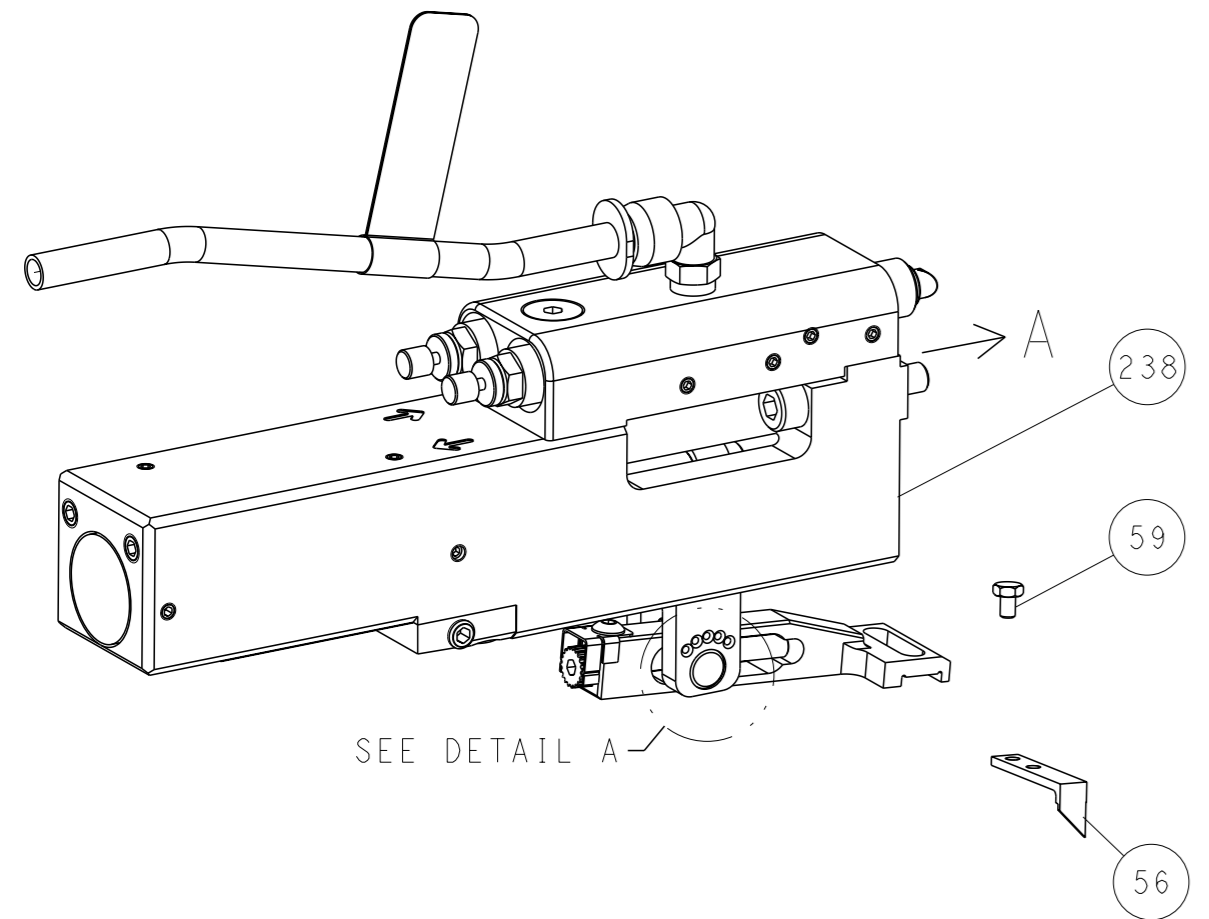
Customer Accessible Production Drawing SCALE 1:2 SHEET 1 OF 4 REV B

LOC	DIST	REVISIONS			
A	66	REV	DATE	OWN	APVD
-	-	SEE SHEET 1	-	-	-

FEED TYPE MECHANICAL



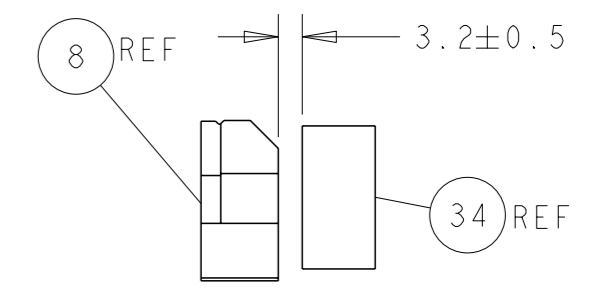
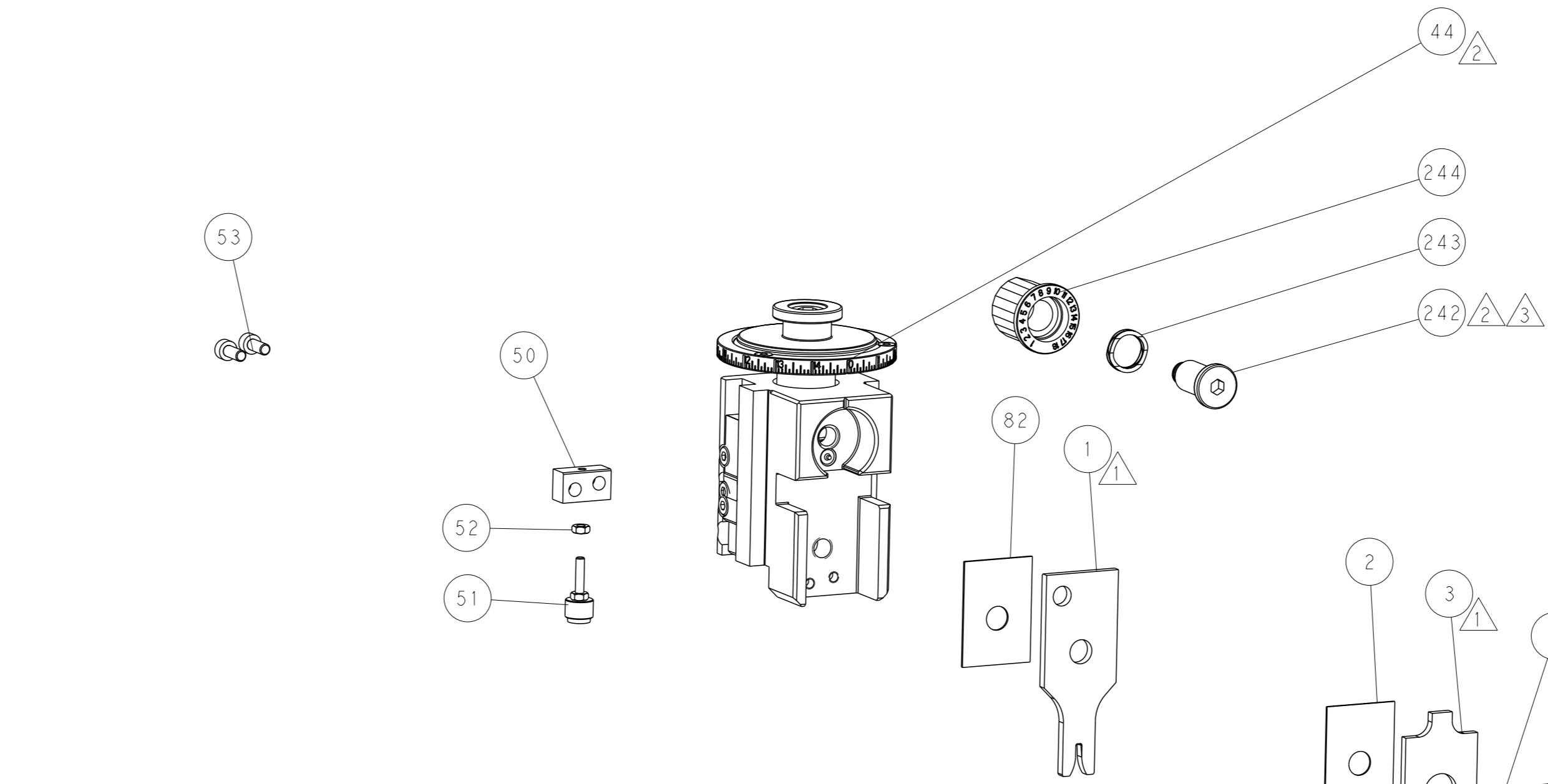
PNEUMATIC



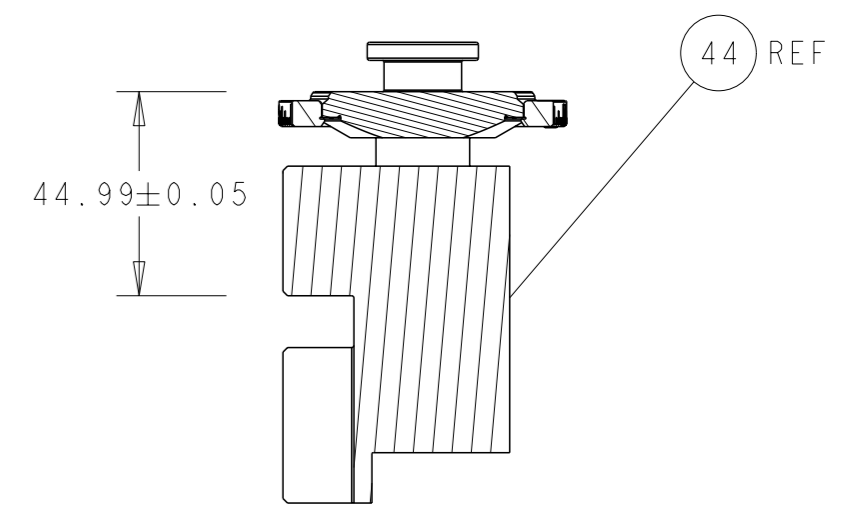
FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



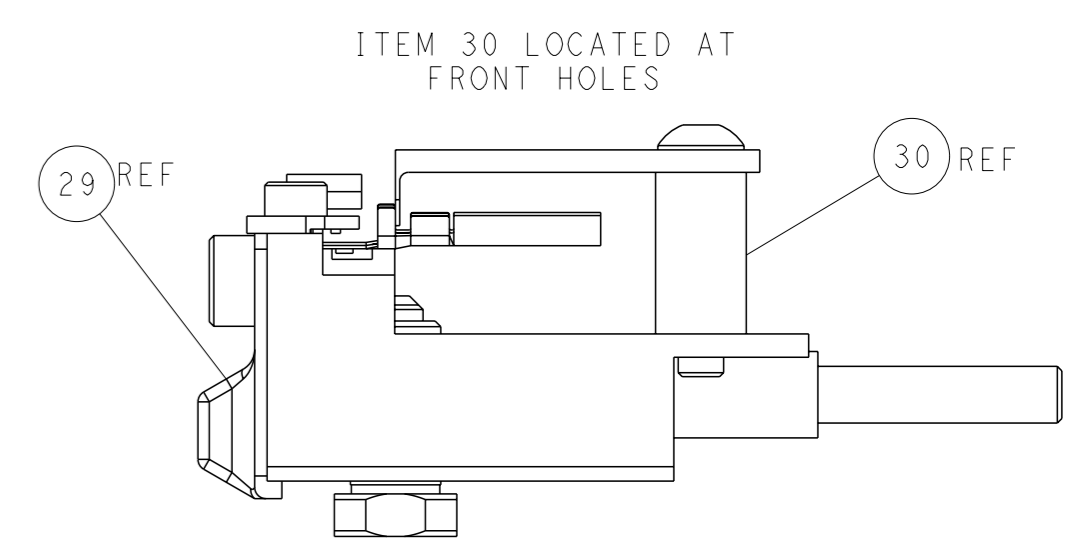
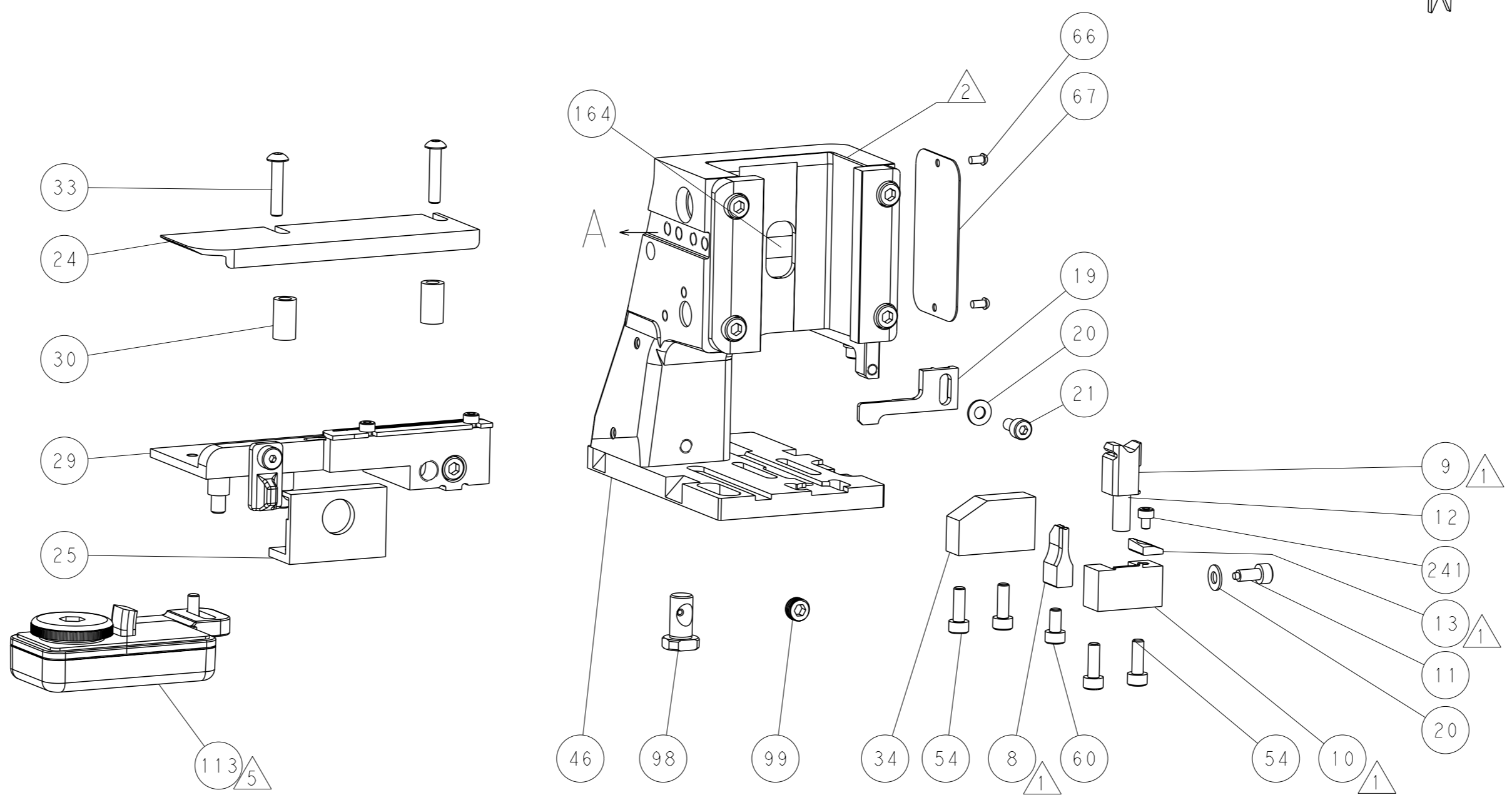
DETAIL A



TERMINAL SUPPORT LOCATION

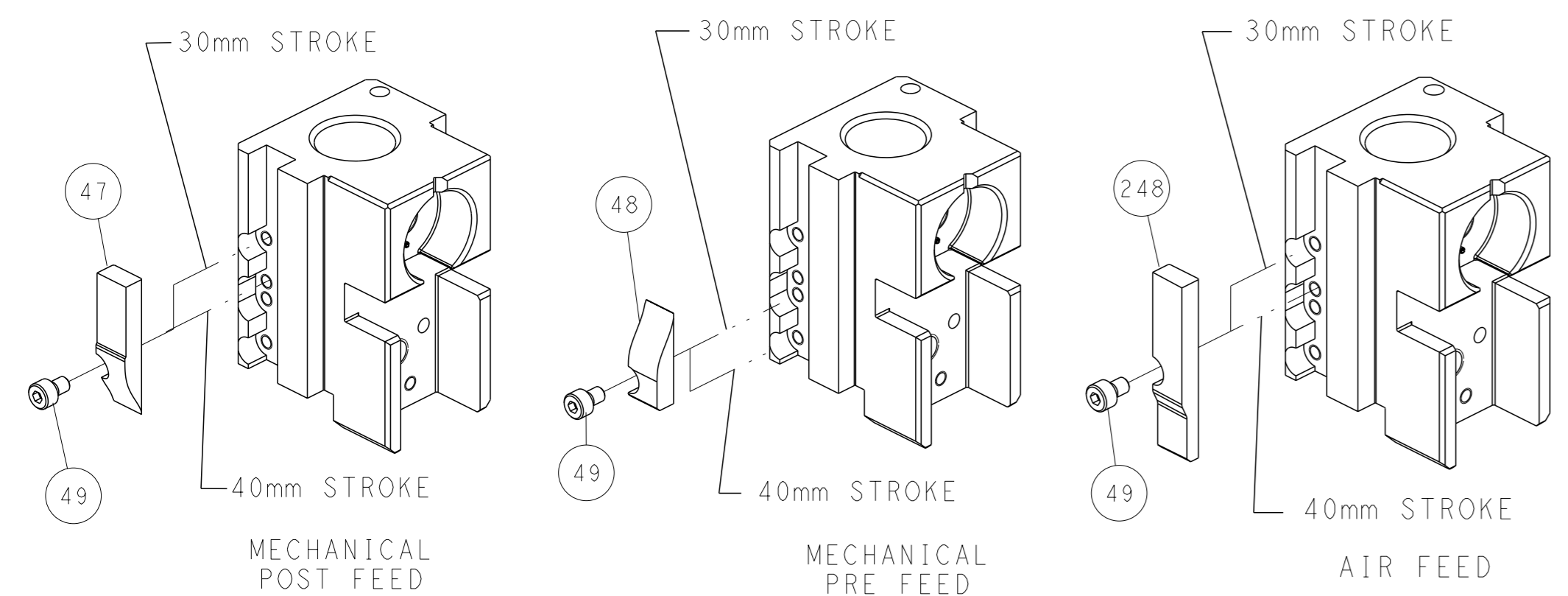


RAM SET-UP



ITEM 30 LOCATED AT FRONT HOLES

CAM POSITIONS

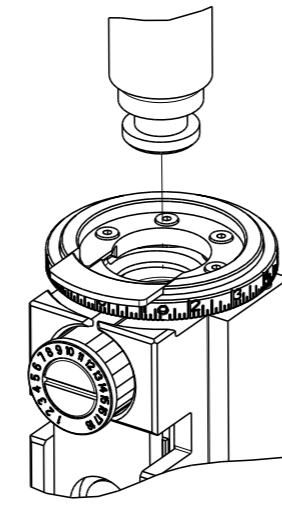


ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		OWN: J. HOU 16 JUN 2016 CHK: L. ZHANG 16 JUN 2016 APVD: L. ZHANG 16 JUN 2016 PRODUCT SPEC APPLICATION SPEC WEIGHT: - MATERIAL: -	NAME: Ocean Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2836341 SCALE: 1:2 SHEET: 2 of 4 REV: B	TE Connectivity Harrisburg, PA 17105-3608 RESTRICTED TO Customer Accessible Production Drawing
-----------------------------------------------------------------------------------------------------------------------------	--	----------------------------------------------------------------------------------------------------------------------------------------------------	------------------------------------------------------------------------------------------------------------------------------------	---------------------------------------------------------------------------------------------------------

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2836341-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2836341-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2836341-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.03 mm [.080]	F
INSUL	2.35 mm [.093]	OV

APPLICATOR INSTRUCTIONS
408-35042

TERMINAL DATA: MOLEX TERMINAL		MOLEX CRIMP SPECIFICATION	
TERMINAL NAME: NSCC 1.5 RECEPTACLE TERMINAL			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
4.20-4.80 mm [.165-.189 IN]		Ø1.40-2.15 mm [.055-.085 IN]	
TERMINAL APPLICATION SPECIFICATION	AS-98897-001-C Rev C		
TERMINALS APPLIED			
TE TERMINAL	MOLEX TERMINAL	TE TERMINAL	MOLEX TERMINAL
2303589-1	98897-1119		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.00mm2	1.18+/-0.05 [.046+/-0.002]	4.1
0.75mm2	1.10+/-0.05 [.043+/-0.002]	4.9
0.50mm2	1.07+/-0.05 [.042+/-0.002]	5.3



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

-	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	-	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
-	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	455888-6	SPACER, CRIMPER	82
-	1	1	1803607-3	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	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	3-1752356-3	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	2844992-4	ASSEMBLY, STRIP GUIDE	29
-	1	1	455888-5	SPACER, CRIMPER	28
-	1	1	240792-1	DRAG, TERMINAL	25
-	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
-	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	1803095-3	FLOATING SHEAR, FRONT	9
-	1	1	6-1633920-3	ANVIL, COMBINATION	8
-	-	-	-	-	7
-	-	-	-	-	6
-	1	1	2119757-8	DEPRESSOR, SHEAR	5
-	1	1	3-238011-5	BLOCK, CRIMPER SPACER	4
-	1	1	2-1633964-9	CRIMPER, INSULATION OVERLAP PREMIUM	3
-	1	1	455888-5	SPACER, CRIMPER	2
-	1	1	3-456405-7	CRIMPER, WIRE PREMIUM	1

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

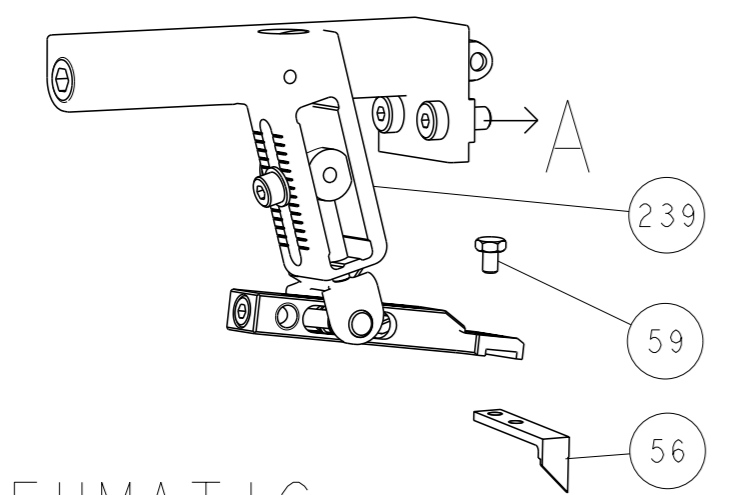
OWN	CHK	APVD	DATE
J. HOU	L. ZHANG	L. ZHANG	16 JUN 2016

NAME	SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
Ocean Side Feed Applicator	A1	00779	2836341	

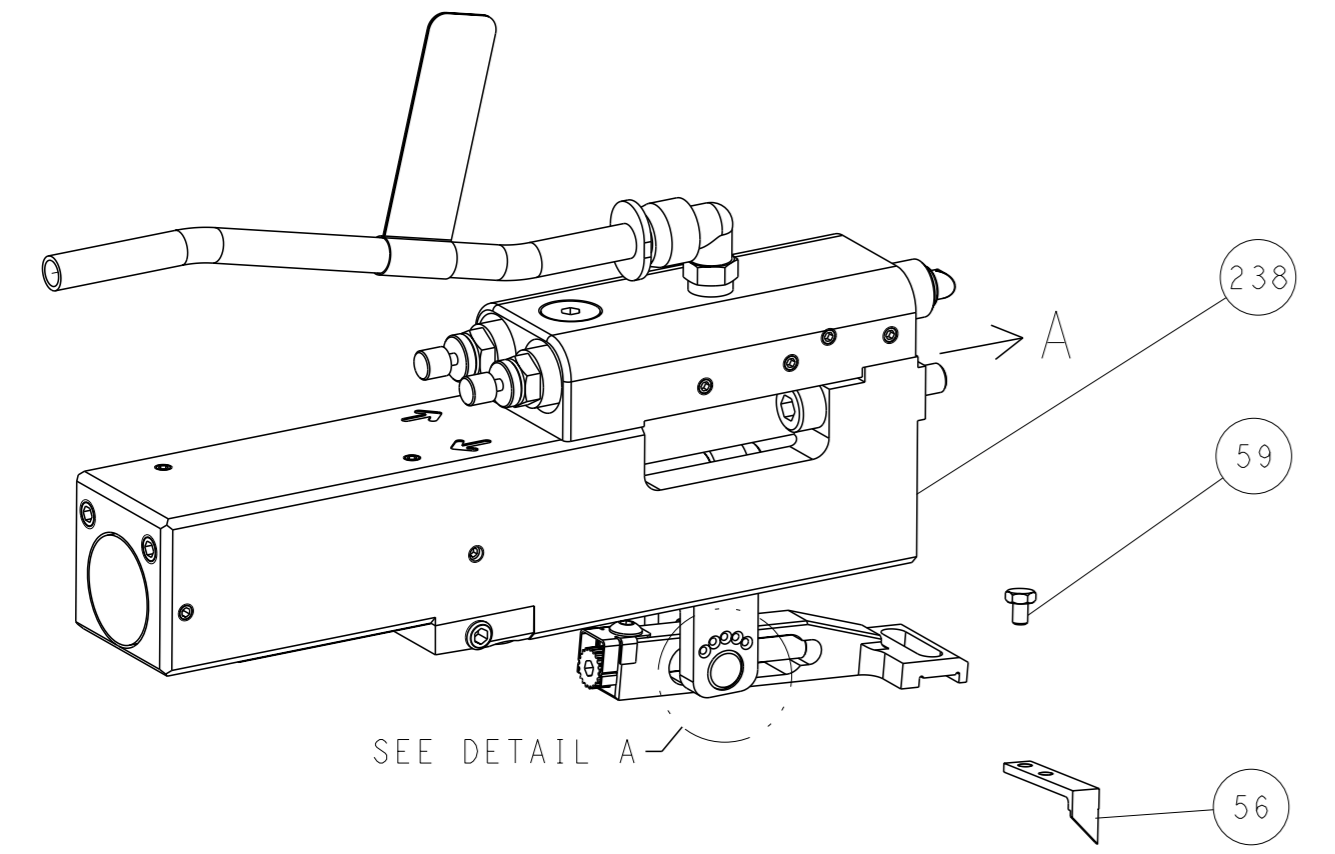
Customer Accessible Production Drawing SCALE 1:2 SHEET 3 OF 4 REV B

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

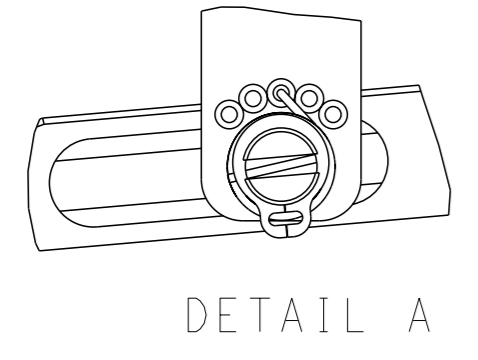
FEED TYPE MECHANICAL



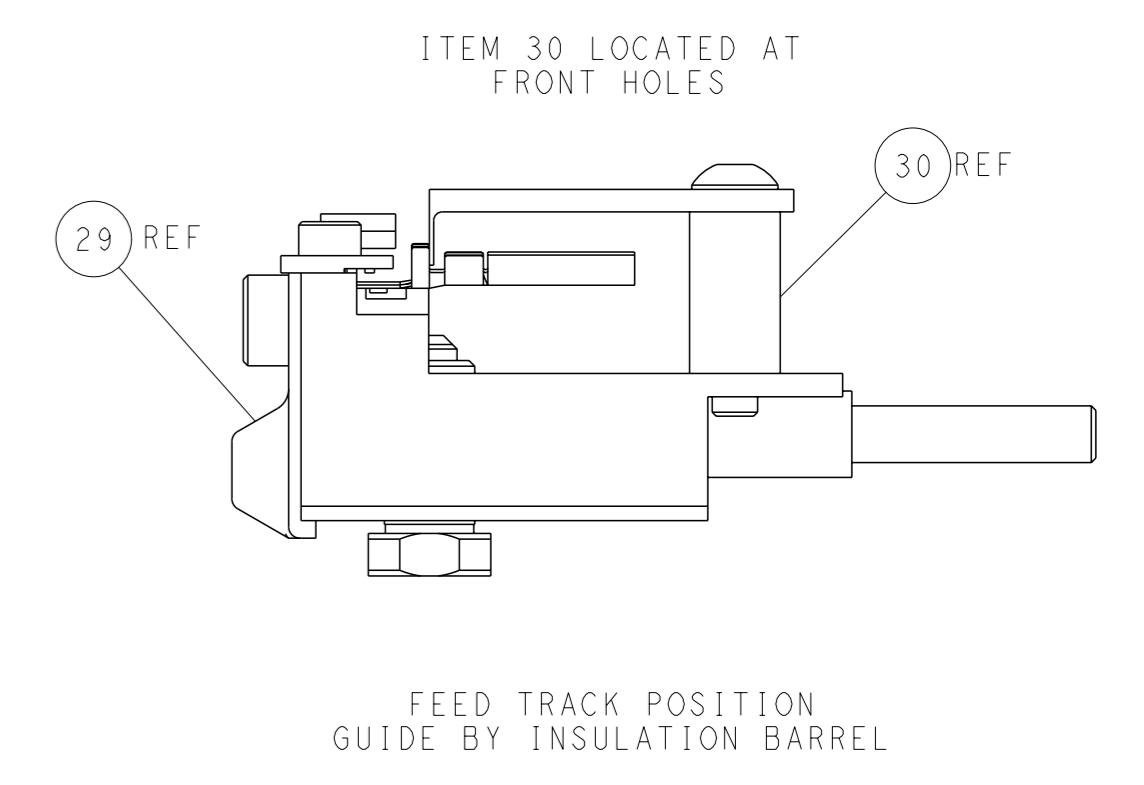
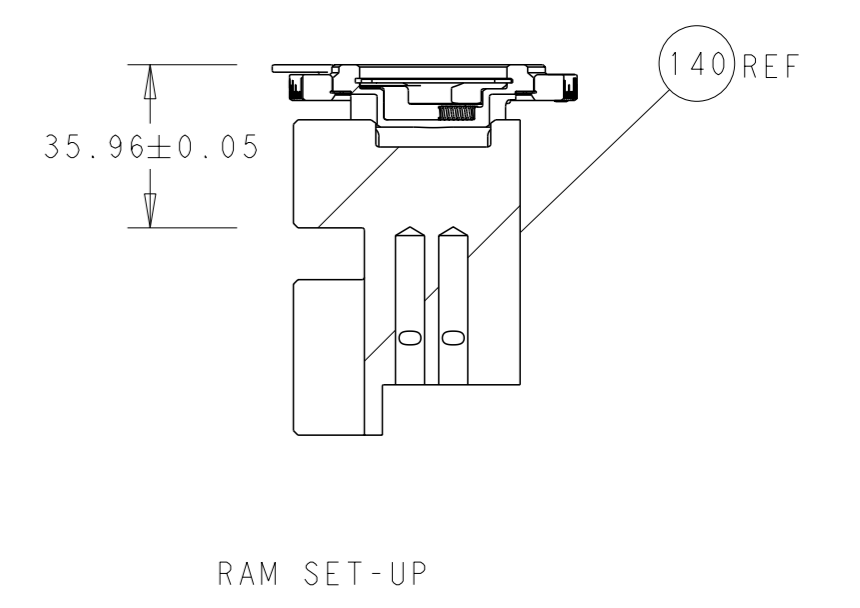
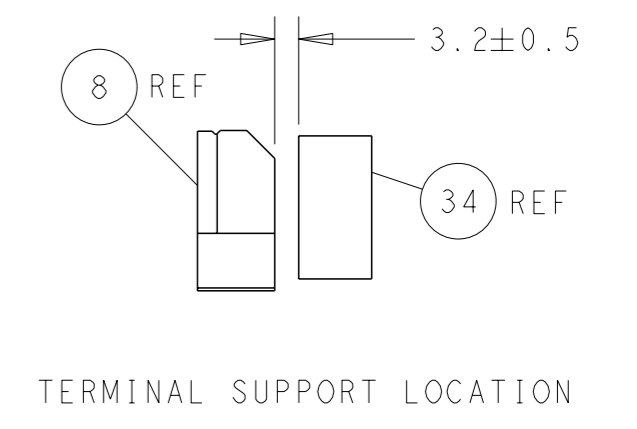
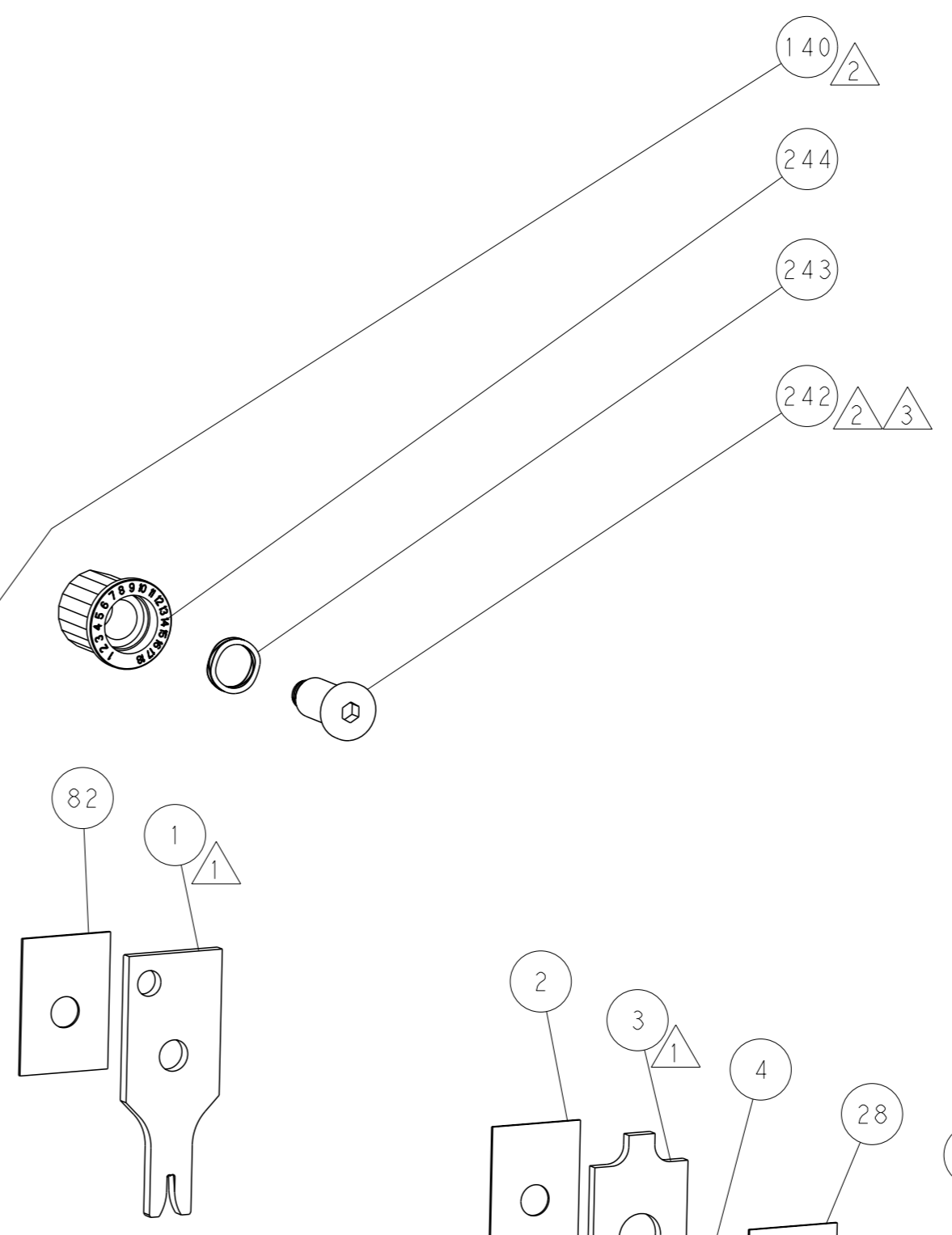
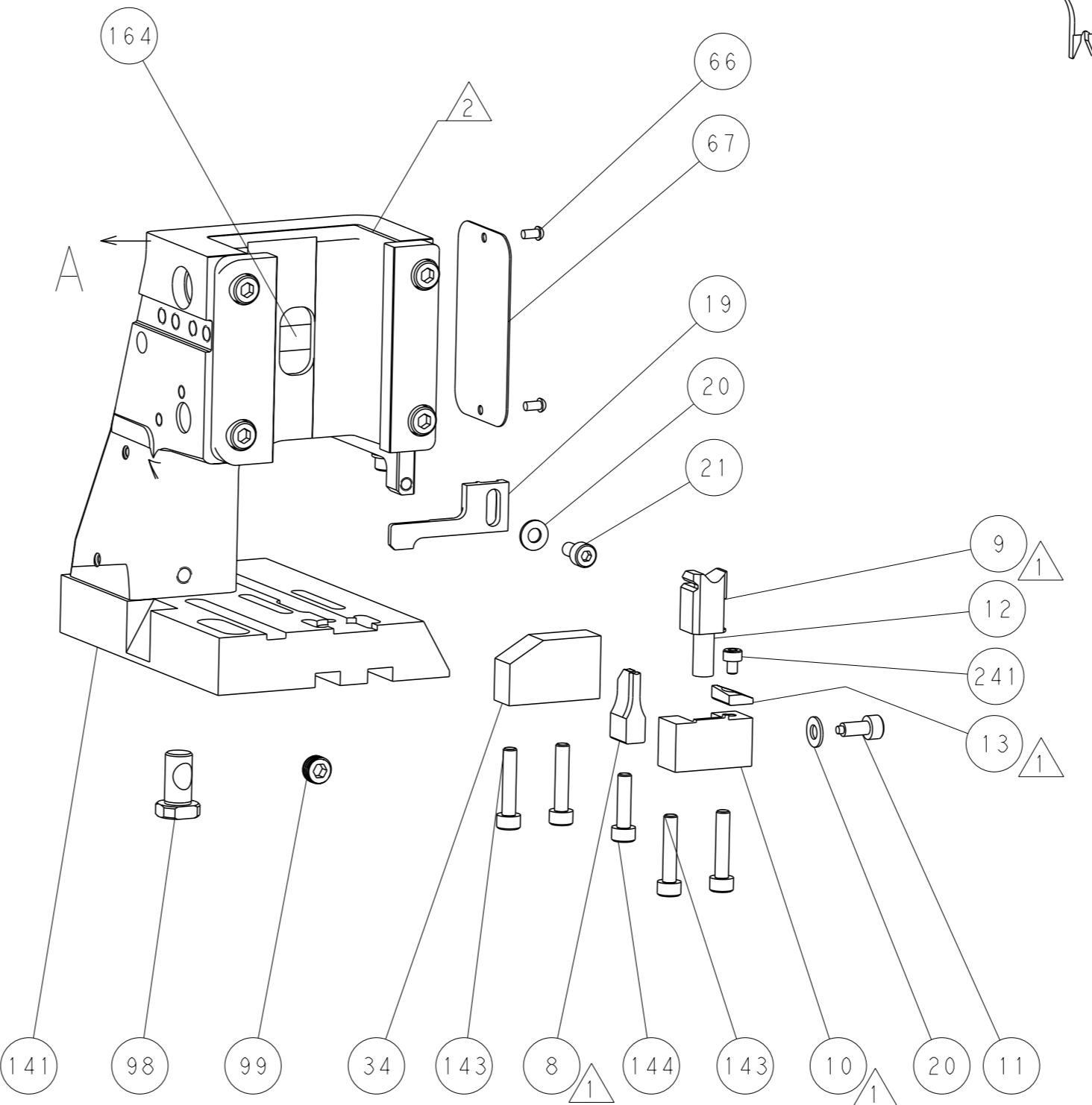
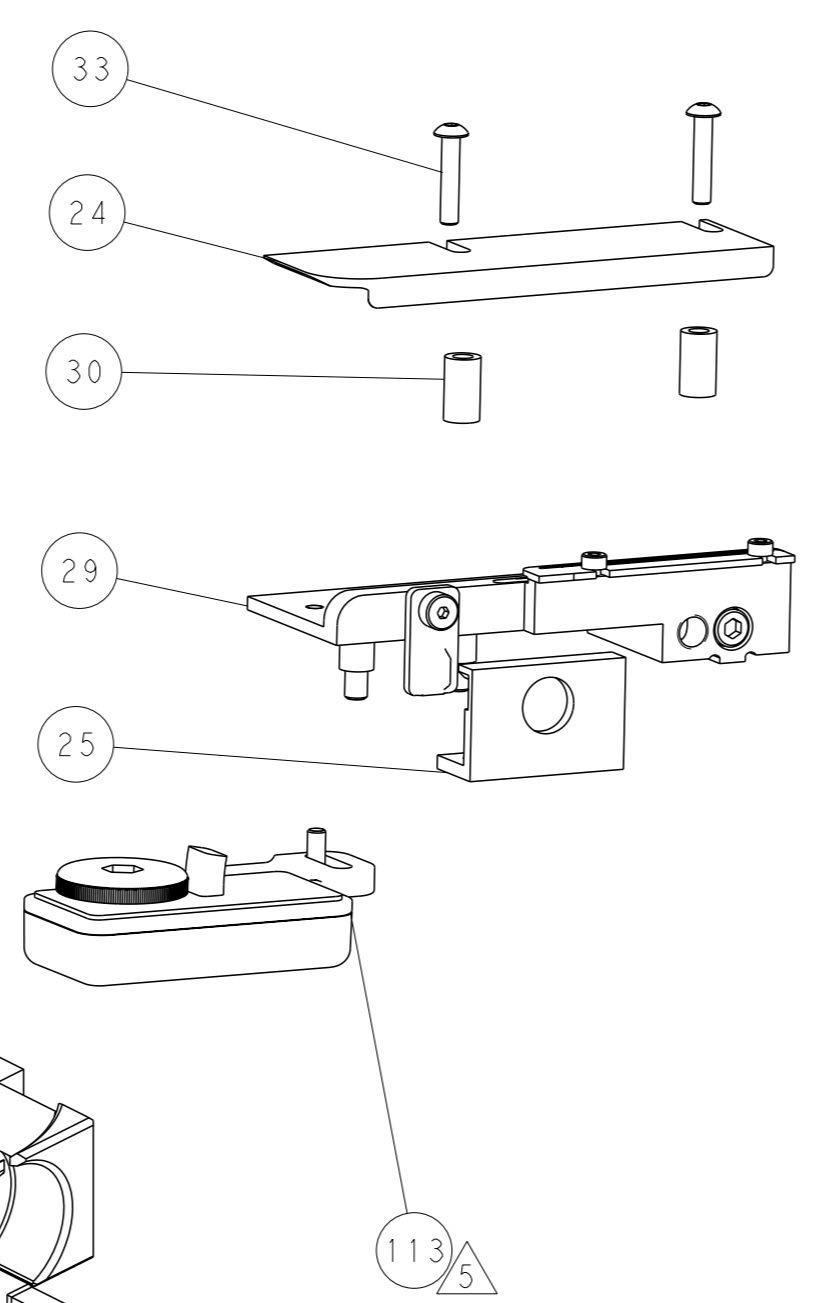
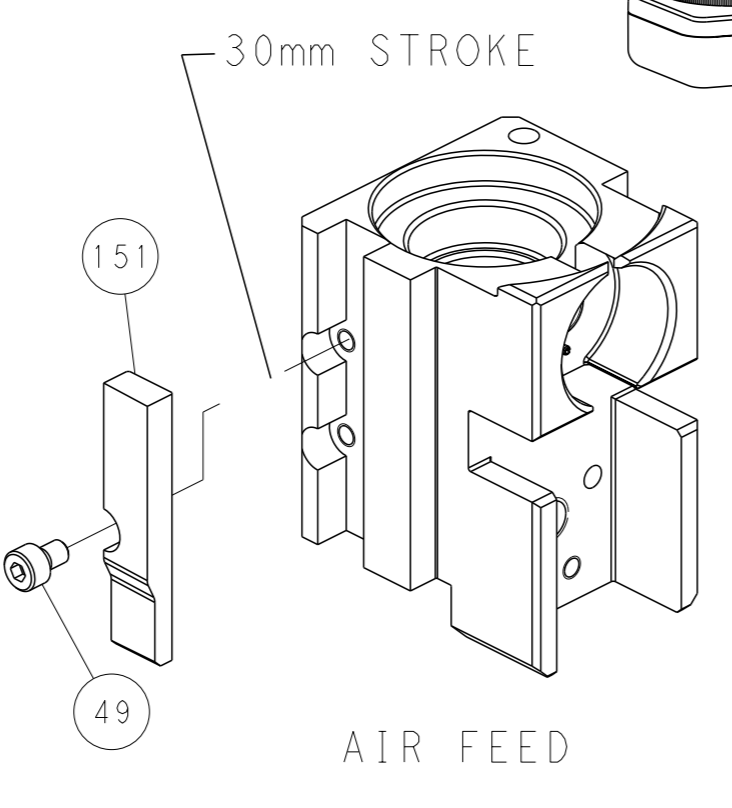
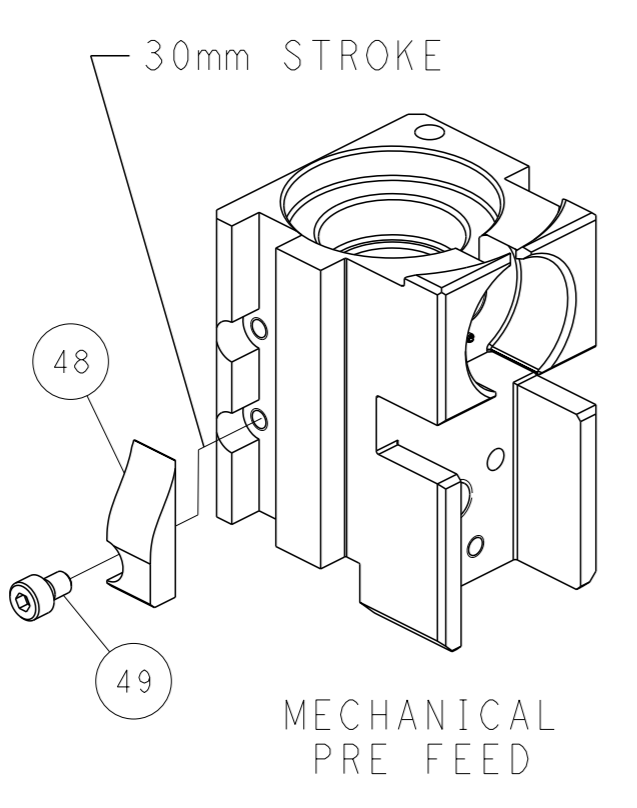
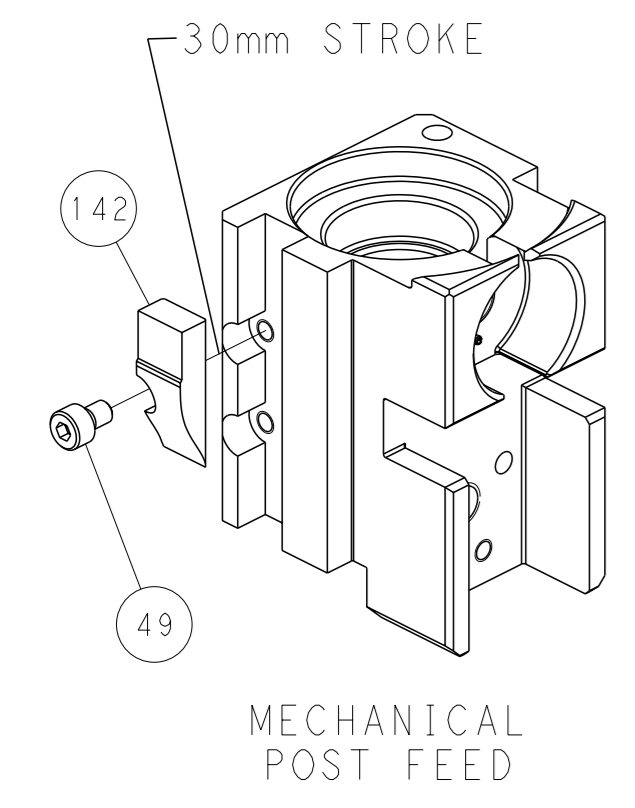
PNEUMATIC



FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



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 A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE AND THE CONTROL AND ENGINEERING ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST REVISION.</small>		OWN: J. HOU 16 JUN 2016 CHK: L. ZHANG 16 JUN 2016 APVD: L. ZHANG 16 JUN 2016	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 APPLICATION SPEC: - SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2836341	RESTRICTED TO: - SCALE: 1:2 SHEET: 4 of 4 REV: B
MATERIAL: - FINISH: -		WEIGHT: - Customer Accessible Production Drawing	SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION