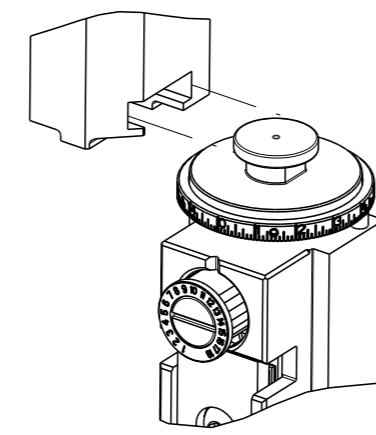


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2836342-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2836342-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2836342-1	C	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2836342-2	C	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2836342-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	3.10 mm [.122]	F
INSUL	4.06 mm [.160]	OV

APPLICATOR INSTRUCTIONS 408-35042

TERMINAL DATA: MOLEX TERMINAL MOLEX CRIMP SPECIFICATION			
TERMINAL NAME: RECEPTACLE TERMINAL			
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE		
4.40-4.60 mm [.173-.181 IN]	$\varnothing$ 3.25-5.60 mm [.128-.220 IN]		
TERMINAL APPLICATION SPECIFICATION	AS-988998-001 Rev A		
TERMINALS APPLIED			
TE TERMINAL	MOLEX TERMINAL	TE TERMINAL	MOLEX TERMINAL
2303590-1	98898-1049		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
5.00mm2	2.40 +/- 0.05 [0.094 +/- .002]	3.4
4.00mm2	2.10 +/- 0.05 [0.083 +/- .002]	6.2
2.00mm2+2.00mm2	2.00 +/- 0.05 [0.079 +/- .002]	7.2
3.00mm2	1.95 +/- 0.05 [0.077 +/- .002]	7.8
1.00mm2+2.00mm2	1.70 +/- 0.05 [0.067 +/- .002]	10.2

- 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.
- 5. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- TERMINAL LUBRICANT IS RECOMMENDED.

**\*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)

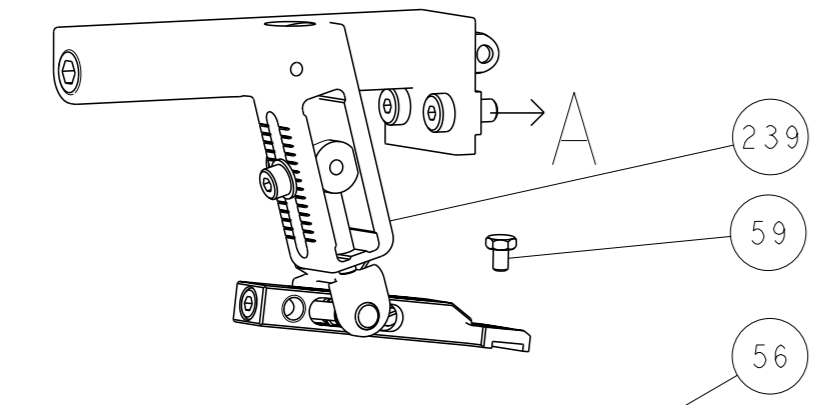
LOC		DIST		REVISIONS			
A		66		REV	DATE	BY	CHK
A				RELEASED	28 JUL 2016	BW	GB
B				ECR-20-014686 ECR-20-014686	19 OCT 2020	JAH	RK
C				ECR-20-016074	11 NOV 2020	JWC	RK

-	1	1	1	1	2119791-9	DEPRESSOR, WIRE	286	
-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248	
-	1	1	1	1	2119082-7	CAM, SNAIL, INSULATION ADJUSTMENT	244	
-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243	
	3	-	-	-	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	
	6	-	-	-	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	1803607-3	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	1-1338683-8	FEED PAWL	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	1752356-3	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	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	-	-	-	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	-	-	-	2119805-1	SHEAR HOLDER, FRONT	10	
	1	-	-	-	1803095-3	FLOATING SHEAR, FRONT	9	
	1	2	2	1	1	2-1803252-4	ANVIL, COMBINATION	8
-	-	-	-	-	-	-	7	
-	-	-	-	-	-	-	6	
-	1	1	1	1	1-2119757-2	DEPRESSOR, SHEAR	5	
-	1	1	1	1	238011-9	BLOCK, CRIMPER SPACER	4	
	1	2	2	1	1	6-1633963-0	CRIMPER, INSULATION OVERLAP PREMIUM	3
-	-	-	-	-	-	-	2	
	1	2	2	1	1	1-1803325-6	CRIMPER, WIRE	1
-	-	-	-	-	-	-	0	

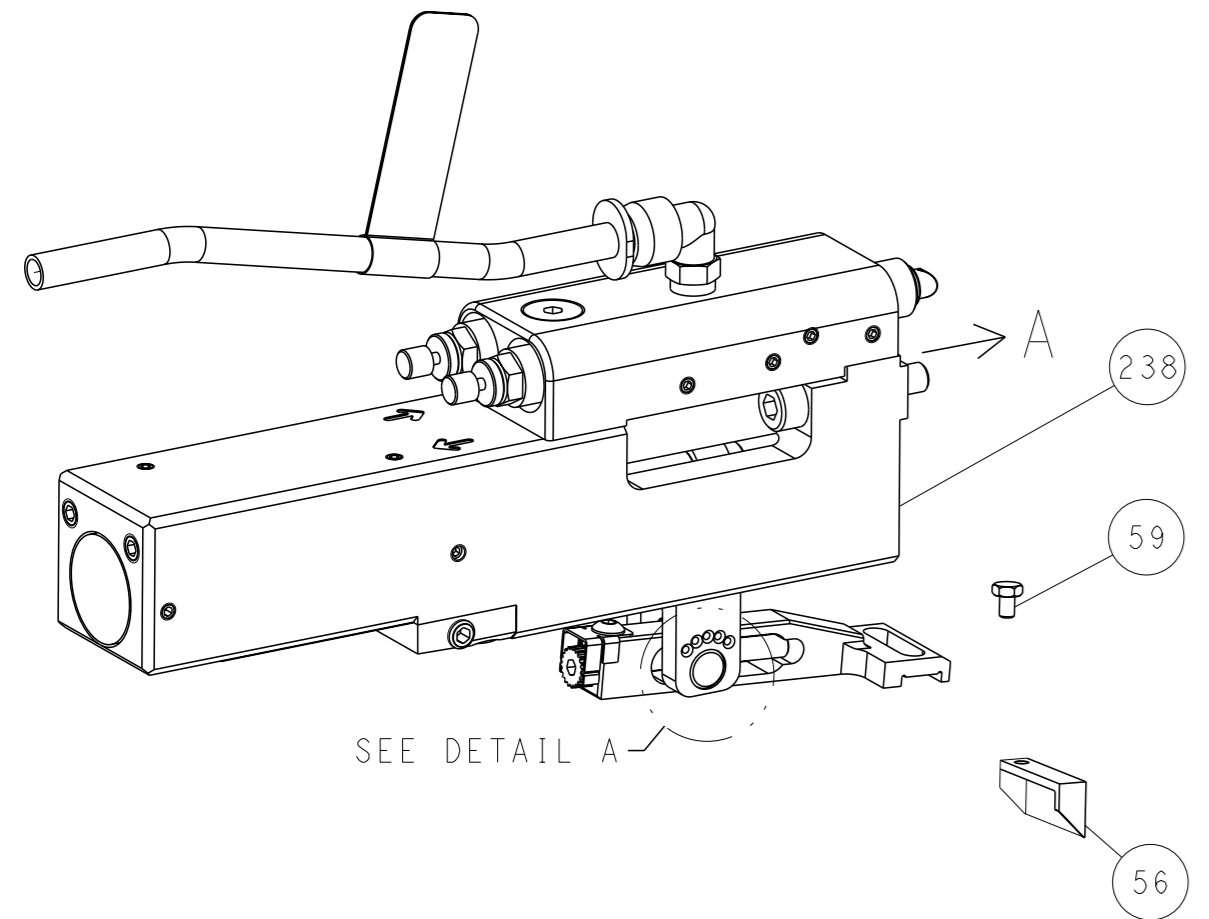
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		OWN	CHK	DATE	STE		TE Connectivity
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES ±	FINISH ±	HOU	3 JUNE 2016
								ZHANG	3 JUNE 2016
				APVD		NAME		Ocean Side Feed Applicator	
				SIZE		CAGE CODE		DRAWING NO	
				A1		00779		C=2836342	
				WEIGHT		SCALE		SHEET 1 OF 4	
				Customer Accessible Production Drawing		SCALE 1:2		REV C	

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

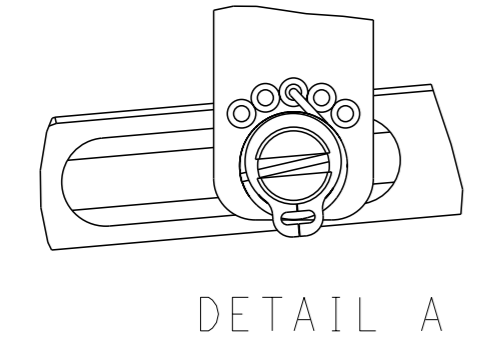
# FEED TYPE MECHANICAL



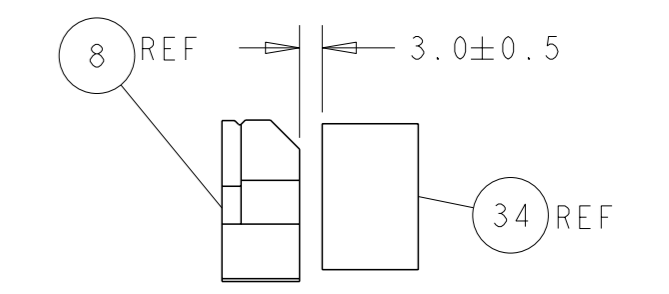
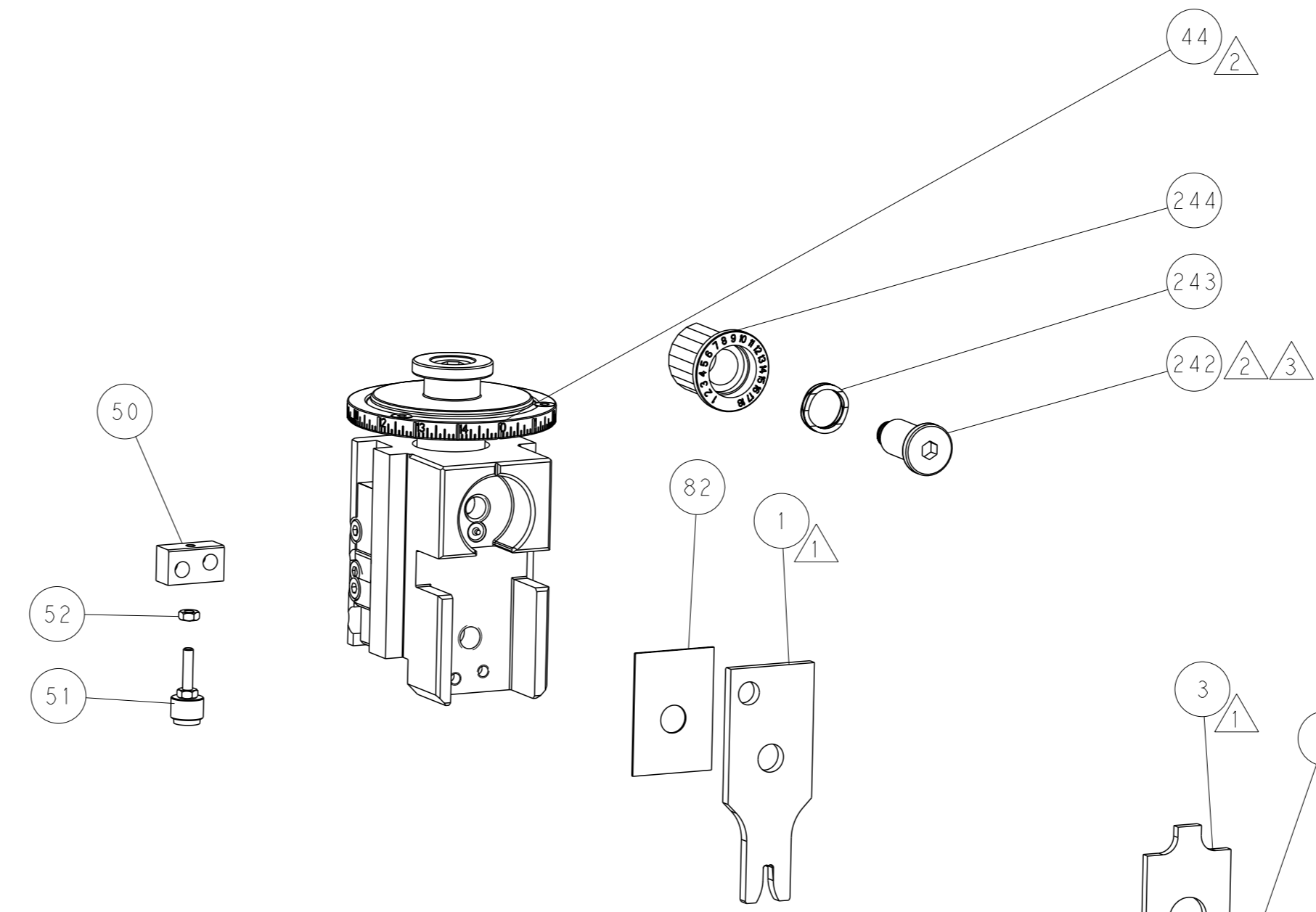
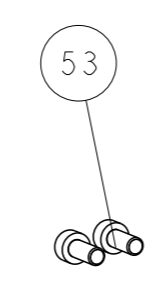
## PNEUMATIC



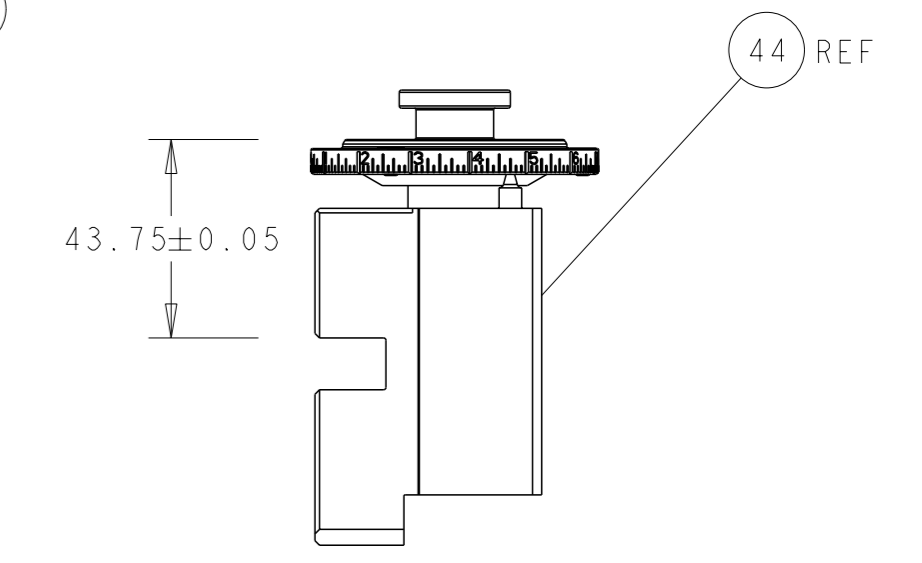
## FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



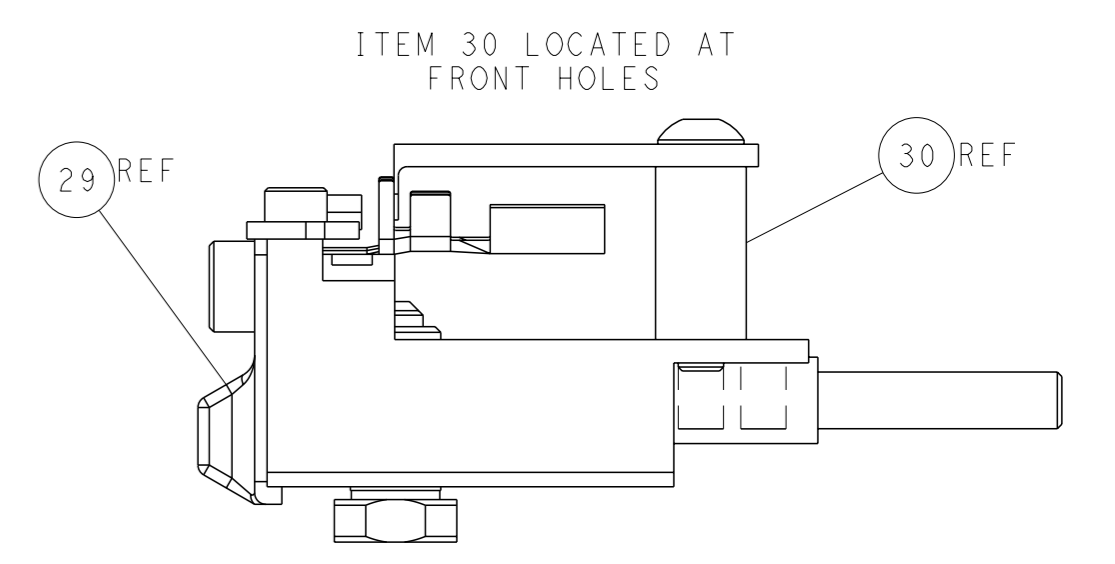
DETAIL A



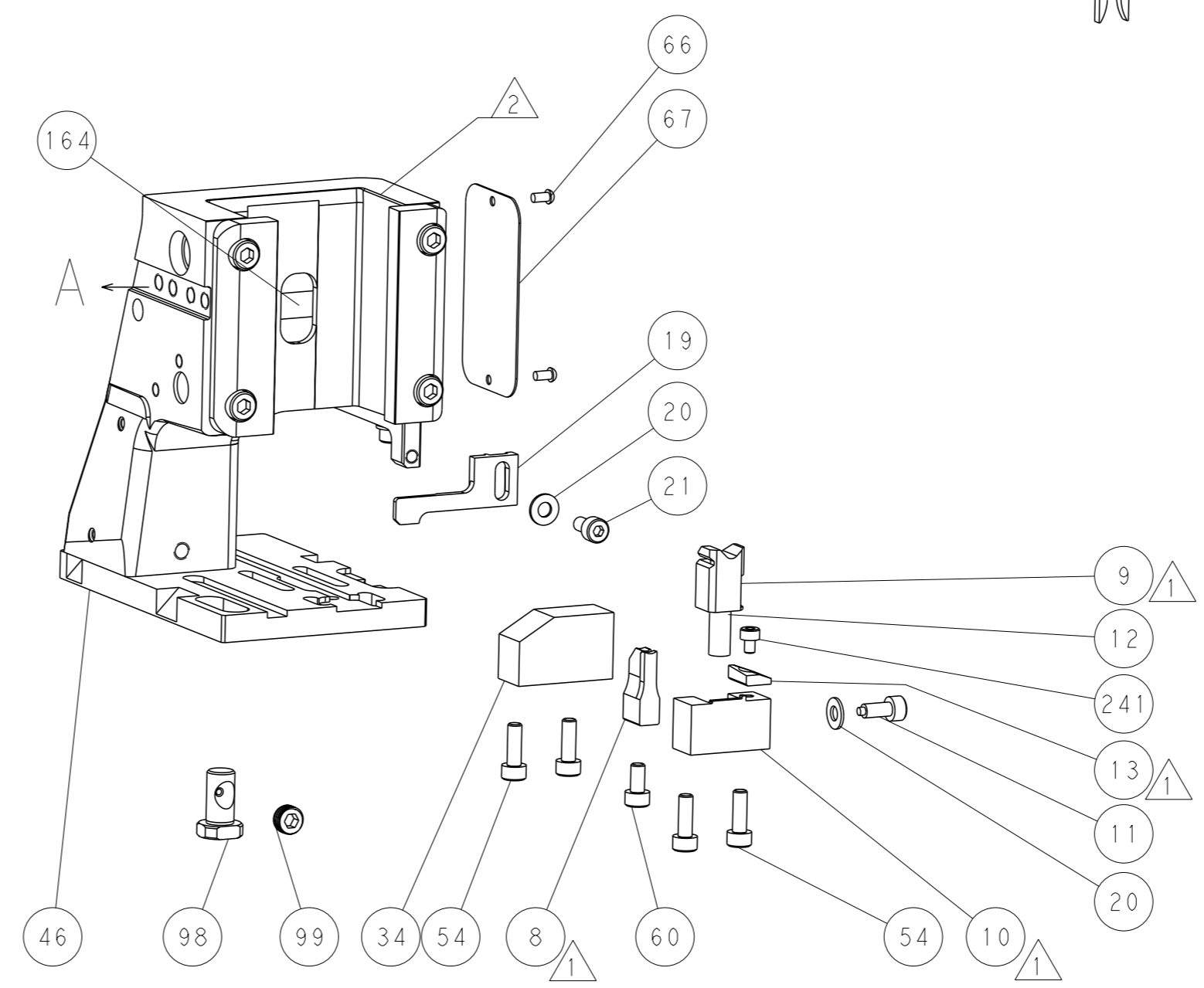
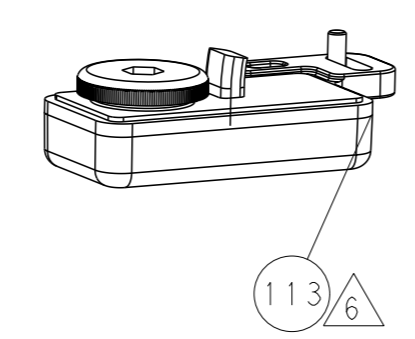
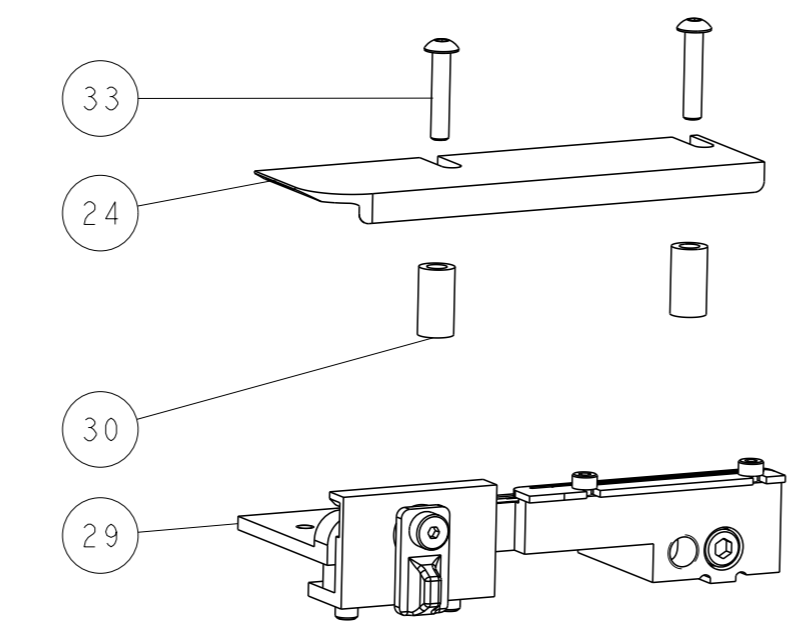
TERMINAL SUPPORT LOCATION



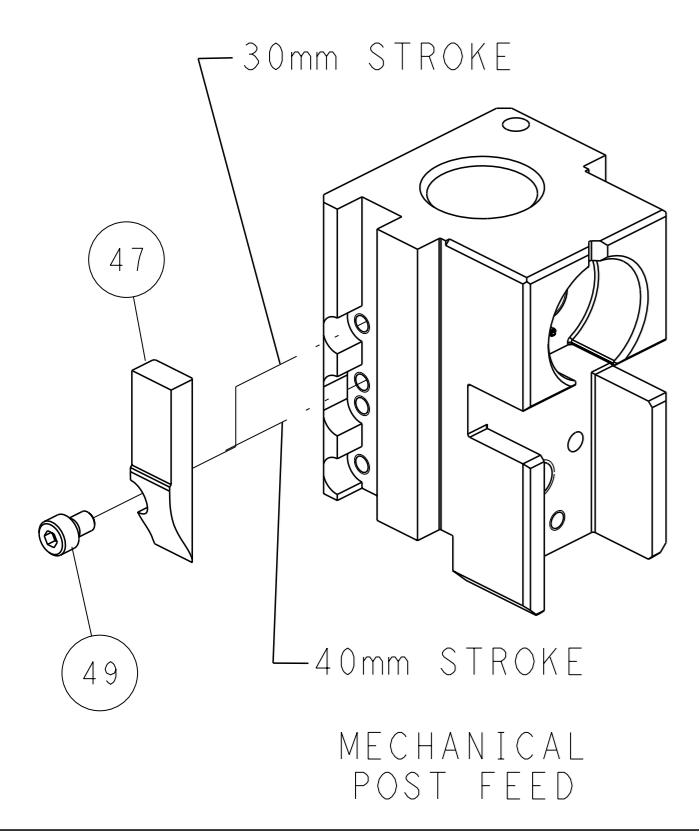
RAM SET-UP



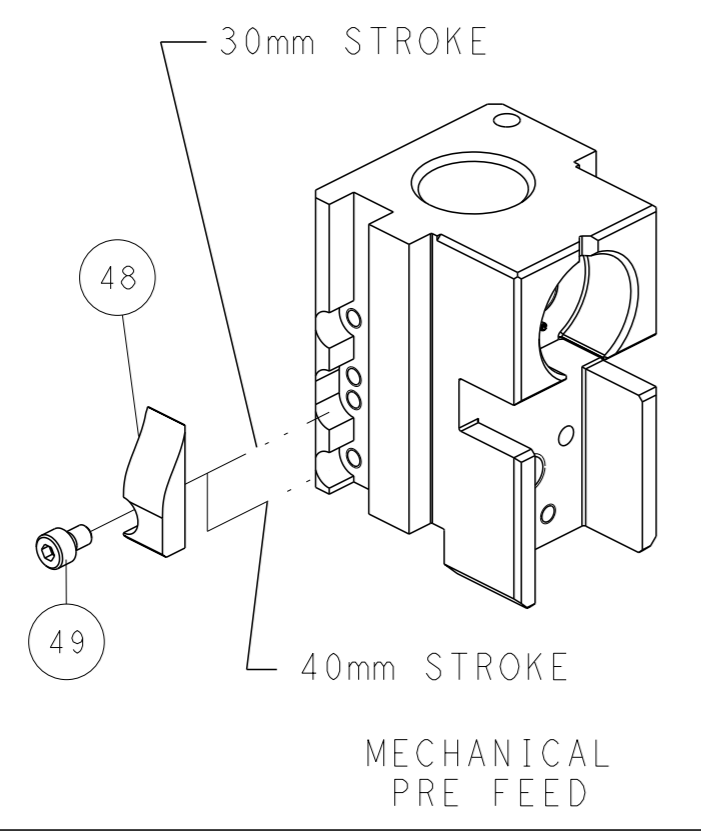
FEED TRACK POSITION GUIDE BY INSULATION BARREL



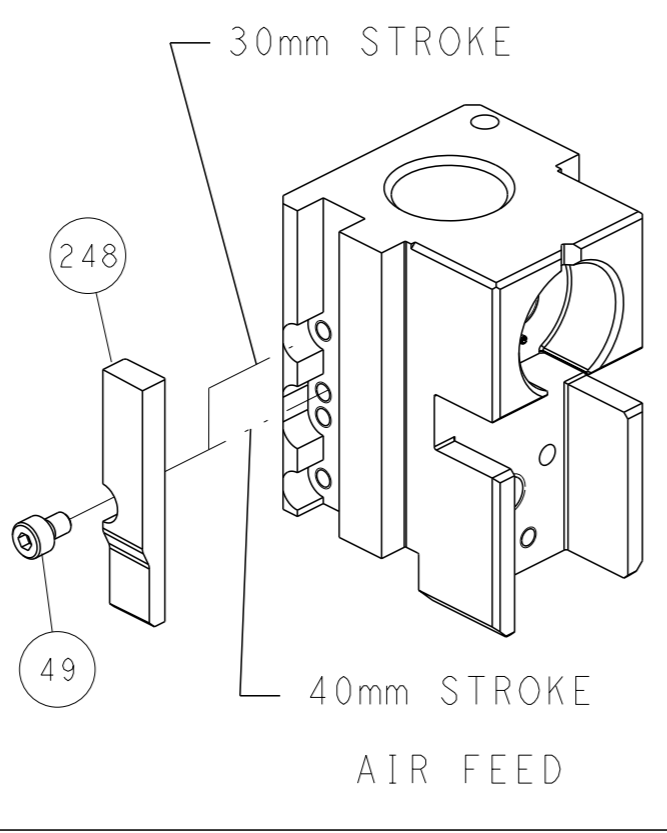
# CAM POSITIONS



MECHANICAL POST FEED



MECHANICAL PRE FEED



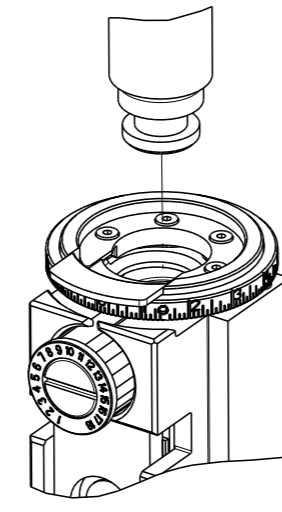
AIR FEED

**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. HOU CHK: L. ZHANG APVD: L. ZHANG	DATE: 3JUNE2016 DATE: 3JUNE2016 DATE: 3JUNE2016	NAME: Ocean Side Feed Applicator	SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2836342	RESTRICTED TO: -
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH ±	TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH ±	WEIGHT: - MATERIAL: -	SCALE: 1:2 SHEET: 2 of 4 REV: C	Customer Accessible Production Drawing		

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2836342-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2836342-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2836342-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR  
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	3.10 mm [.122]	F
INSUL	4.06 mm [.160]	OV
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: MOLEX TERMINAL		MOLEX CRIMP SPECIFICATION	
TERMINAL NAME: RECEPTACLE TERMINAL			
WIRE STRIP LENGTH 4.40-4.60 mm [.173-.181 IN]		INSULATION DIAMETER RANGE Ø3.25-5.60 mm [.128-.220 IN]	
TERMINAL APPLICATION SPECIFICATION AS-988998-001 Rev A			
TERMINALS APPLIED			
TE TERMINAL	MOLEX TERMINAL	TE TERMINAL	MOLEX TERMINAL
2303590-1	98898-1049		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
5.00mm2	2.40+/-0.05 [.094+/-0.002]	3.4
4.00mm2	2.10+/-0.05 [.083+/-0.002]	6.2
2.00mm2+2.00mm2	2.00+/-0.05 [.079+/-0.002]	7.2
3.00mm2	1.95+/-0.05 [.077+/-0.002]	7.8
1.00mm2+2.00mm2	1.70+/-0.05 [.067+/-0.002]	10.2

- 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.
- UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- TERMINAL LUBRICANT IS RECOMMENDED.

**\*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.

LOC	DIST	REV	DATE	BY	APPV
A	66				

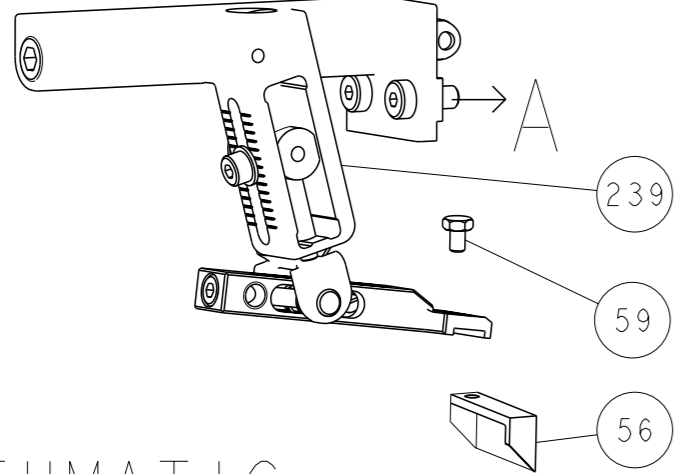
REV	DATE	BY	APPV	DESCRIPTION	ITEM NO	
-	1	1		2119791-9	DEPRESSOR, WIRE	286
-	1	1		2119082-7	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1		2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1		2119083-1	RETAINER, INSULATION DIAL	242
-	1	1		7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
-	-	1		2119580-1	MECHANICAL 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		455888-5	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		1-1338683-8	FEED PAWL	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		1752356-3	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		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		2-1803252-4	ANVIL, COMBINATION	8
-	-	-		-	-	7
-	-	-		-	-	6
-	1	1		1-2119757-2	DEPRESSOR, SHEAR	5
-	1	1		238011-9	BLOCK, CRIMPER SPACER	4
-	1	1		6-1633963-0	CRIMPER, INSULATION OVERLAP PREMIUM	3
-	-	-		-	-	2
-	1	1		1-1803325-6	CRIMPER, WIRE	1

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

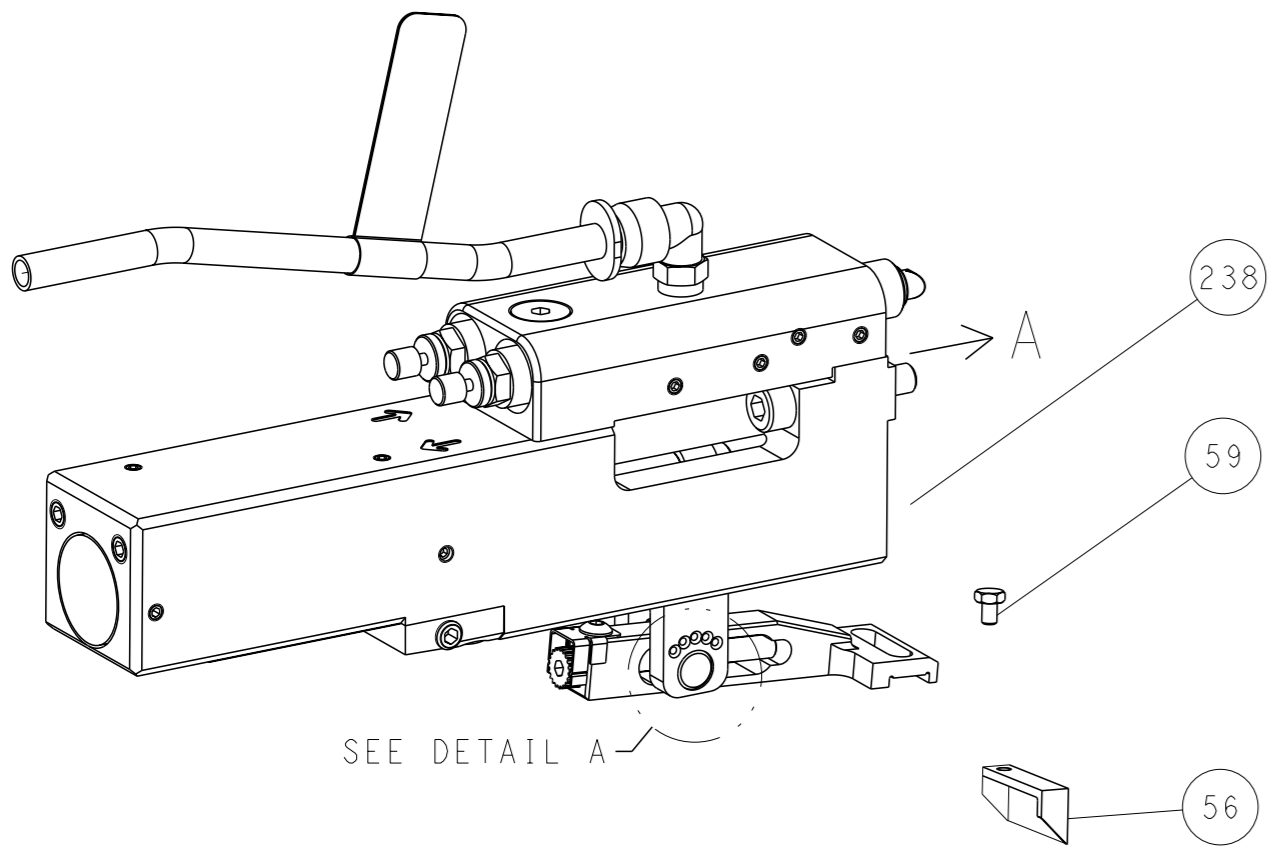
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		OWN J. HOU 3 JUNE 2016	STE TE Connectivity Harrisburg, PA 17105-3608
0 PLC ±		1 PLC ±		CHK L. ZHANG 3 JUNE 2016	
2 PLC ±		3 PLC ±		APVD L. ZHANG 3 JUNE 2016	NAME Ocean Side Feed Applicator
4 PLC ±		5 PLC ±		PRODUCT SPEC	SIZE CAGE CODE DRAWING NO
MATERIAL		FINISH		APPLICATION SPEC	RESTRICTED TO
				WEIGHT	SCALE 1:2 SHEET 3 OF 4 REV C
				Customer Accessible Production Drawing	SCALE 1:2 SHEET 3 OF 4 REV C

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

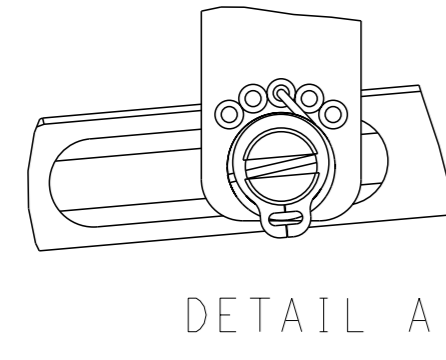
# FEED TYPE MECHANICAL



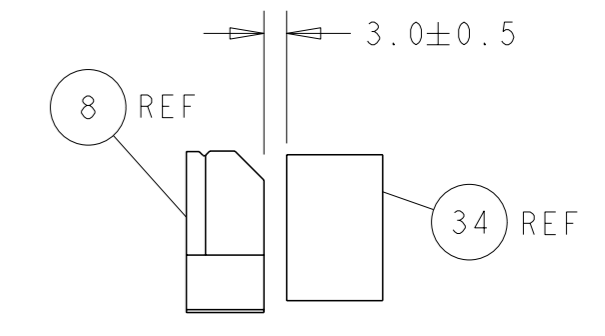
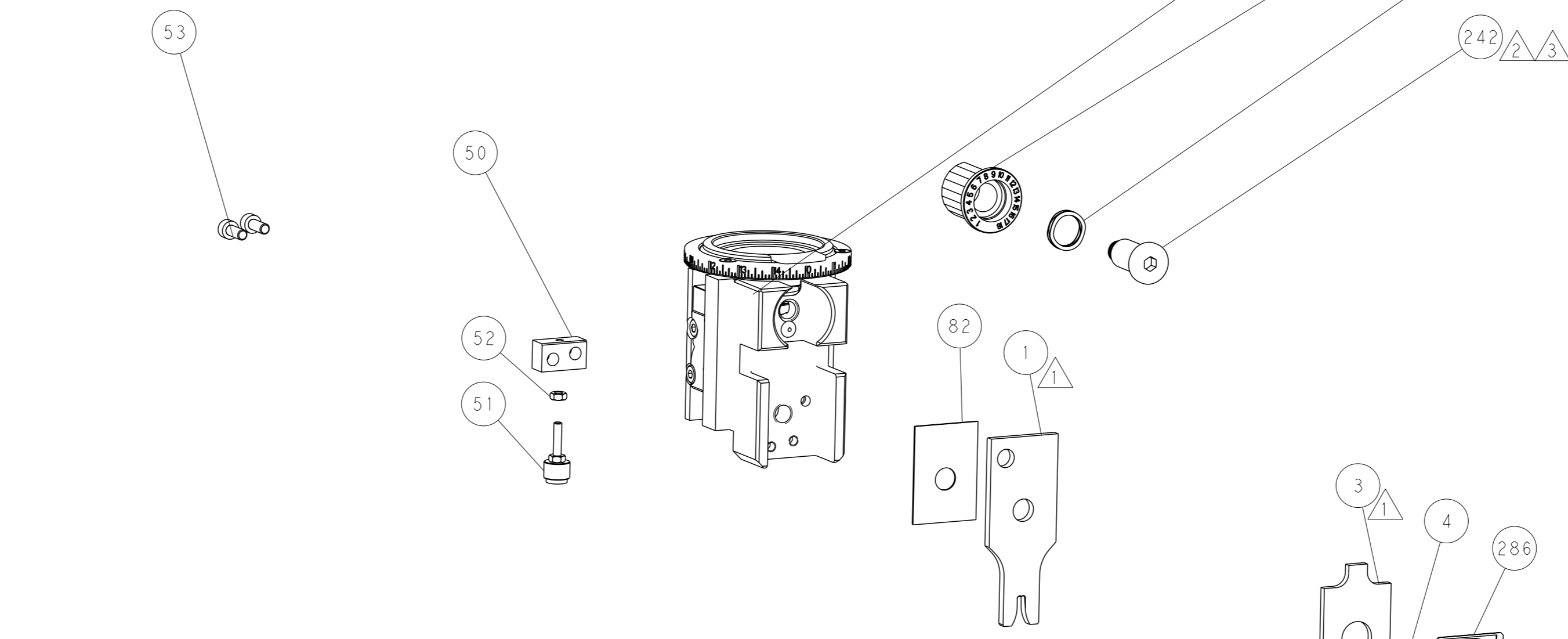
## PNEUMATIC



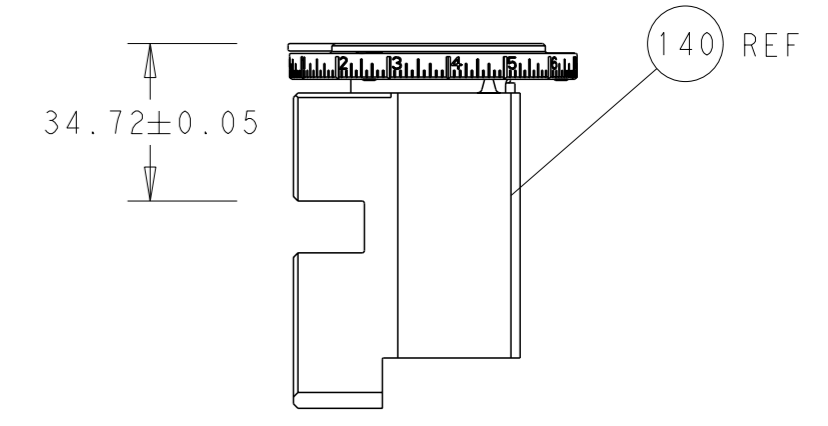
## FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



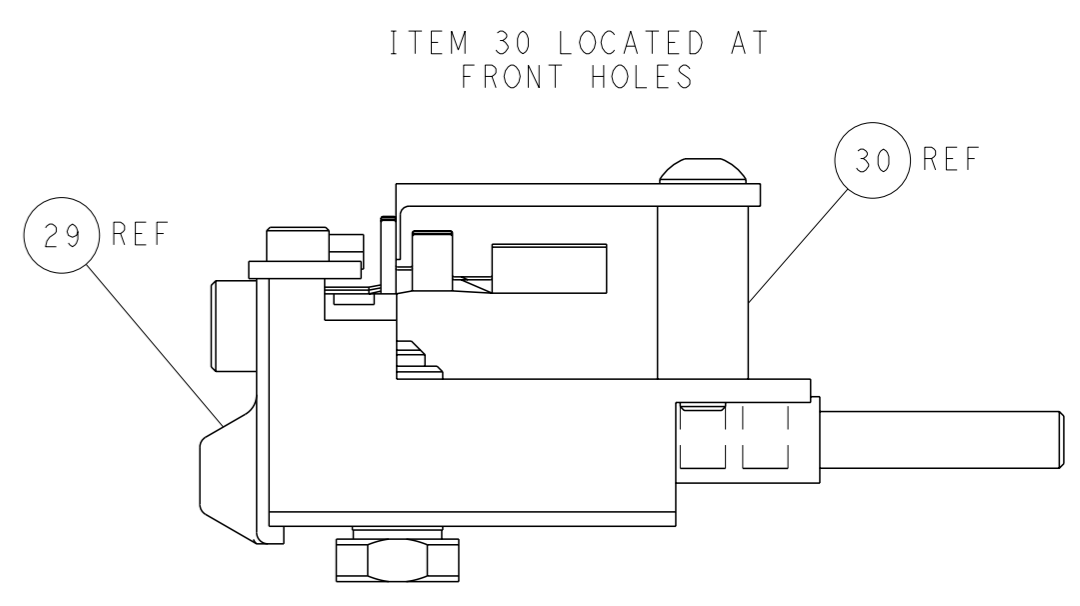
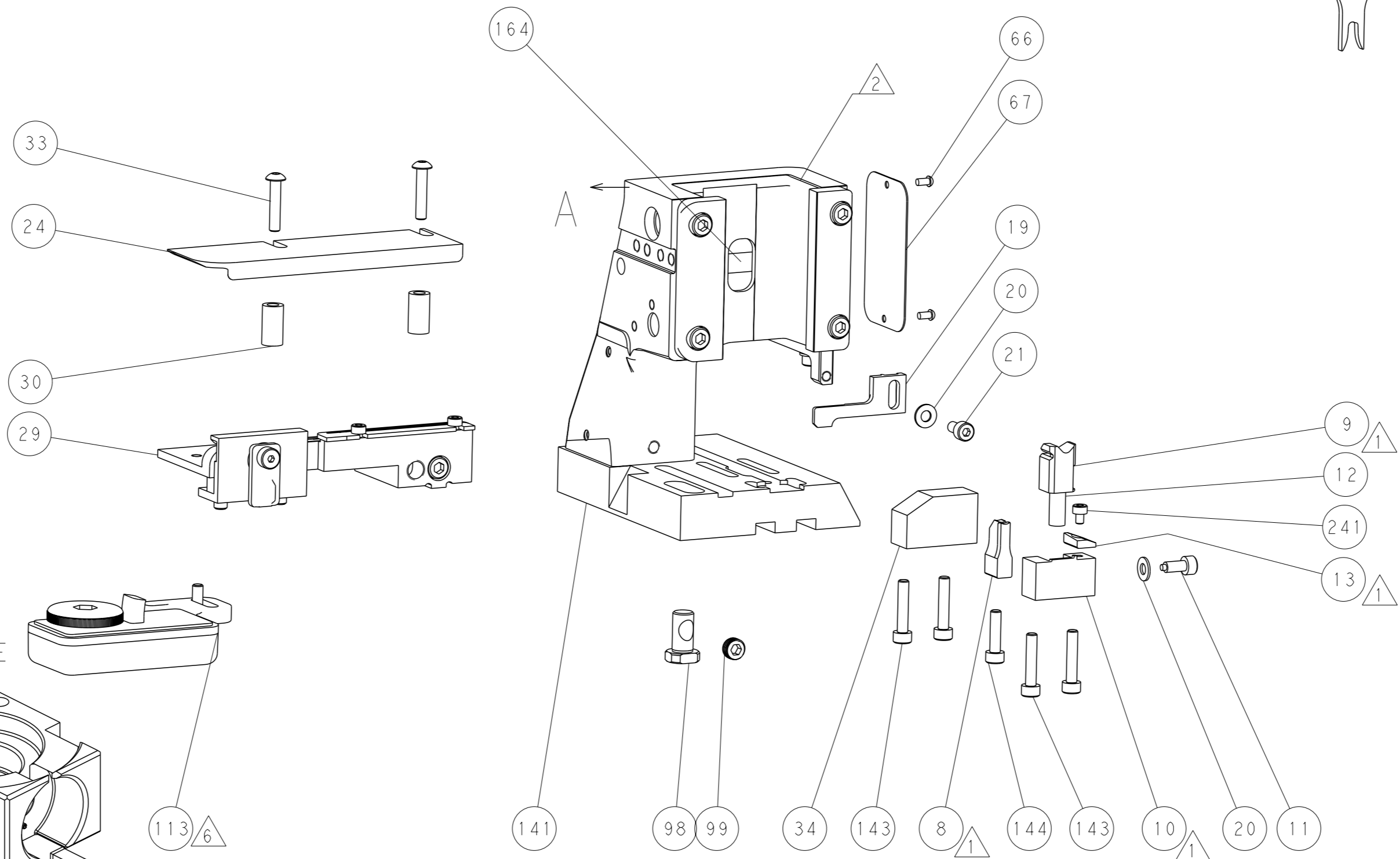
DETAIL A



TERMINAL SUPPORT LOCATION

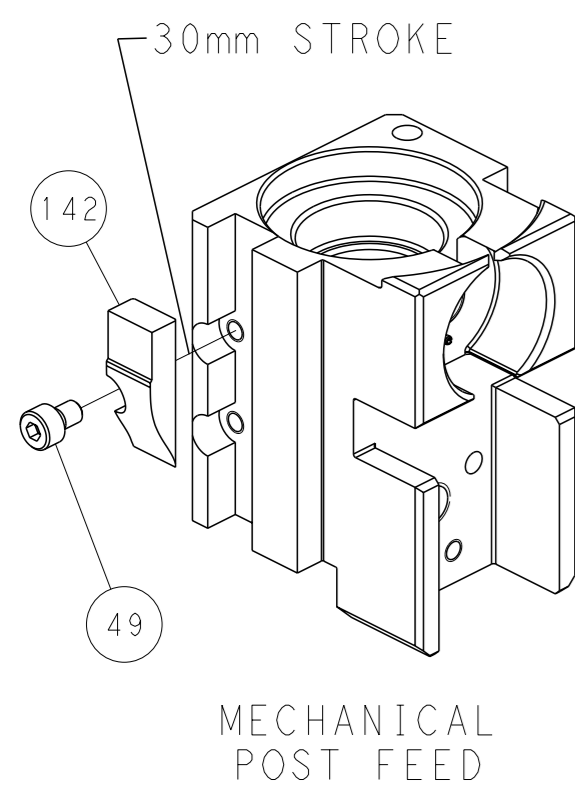


RAM SET-UP

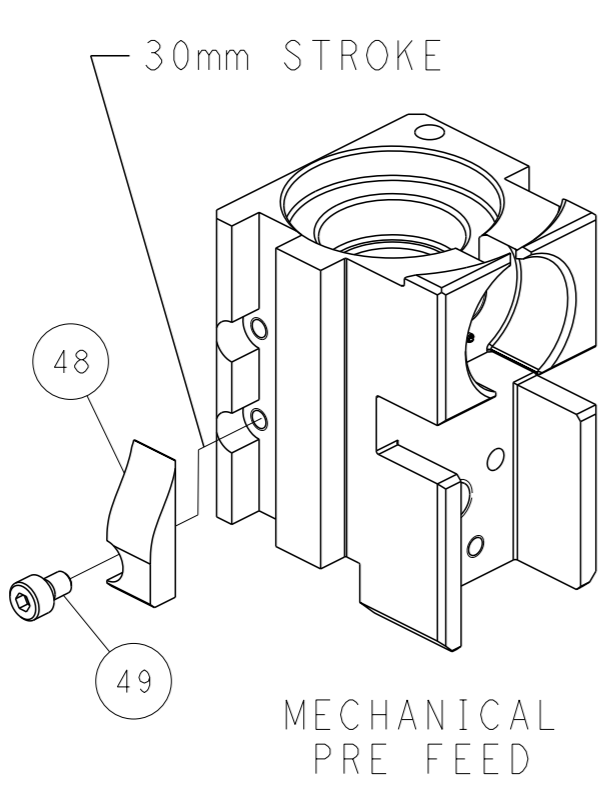


FEED TRACK POSITION GUIDE BY INSULATION BARREL

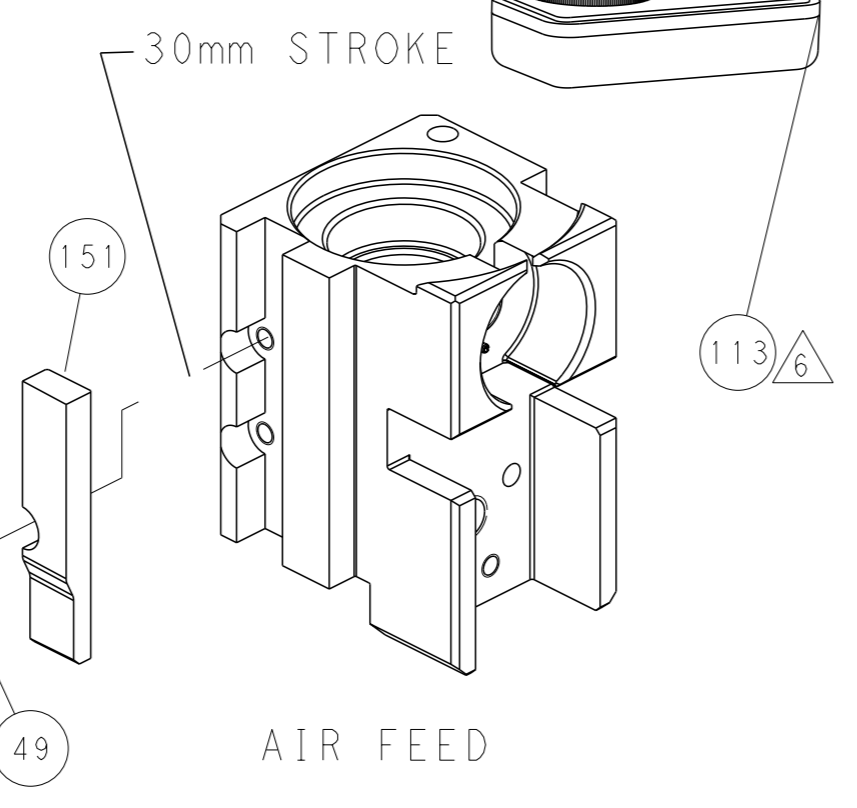
## CAM POSITIONS



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)

<small>THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE AND THE CONTROLLER'S ENGINEERING DEPARTMENT SHOULD BE CONTACTED FOR THE LATEST REVISION.</small>		OWN: J. HOU CHK: L. ZHANG APVD: L. ZHANG DATE: 3JUNE2016	NAME: Ocean Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2836342	TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH ±	MATERIAL:	WEIGHT:	RESTRICTED TO:	SCALE: 1:2 SHEET: 4 of 4 REV: C