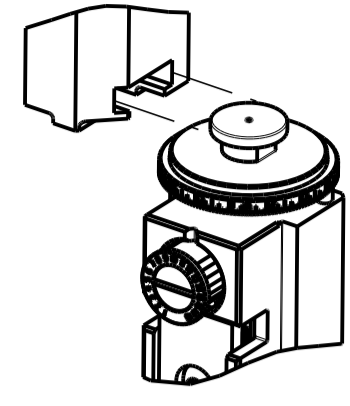


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2836364-2	D	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
3-2836364-2	D	FINE CRIMP HEIGHT ADJUST	DOUBLE ACTING PNEUMATIC WITH SENSORS ⁵
7-2836364-2	D	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2836364-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	3.81 mm [1.50]	O

APPLICATOR INSTRUCTIONS
408-35042

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: SHIELD, SHELL, BARREL			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
17.60-18.40 mm [.693-.724 IN]		∅3.10-3.50 mm [1.22-.138 IN]	
TERMINAL APPLICATION SPECIFICATION	114-94058		
TERMINALS APPLIED ⁴			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
1823899-1	1823899-2		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
Leoni Dacor 535	3.80+/-0.10 [1.50+/-0.04]	8.3

***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.

- ¹ RECOMMENDED SPARE PARTS
- ² REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- ³ 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.
- ⁴ TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- ⁵ THIS APPLICATOR IS EQUIPPED WITH THE DOUBLE ACTING FEED WITH SENSORS AND IS APPLICATION SPECIFIC. IT DOES NOT REQUIRE ITEMS 49 & 248.
- 6. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.

LOC	DIST	REV	LTN	DESCRIPTION	DATE	OWN	APVD
A	66	B		ECR-17-003302	07MAR2017	TB	CT
		C		ECR-18-016263	16OCT2018	TB	CT
		D		ECR-20-016924	30NOV2020	FZ	RK
		D1		ECR-20-017351	08DEC2020	FZ	RK

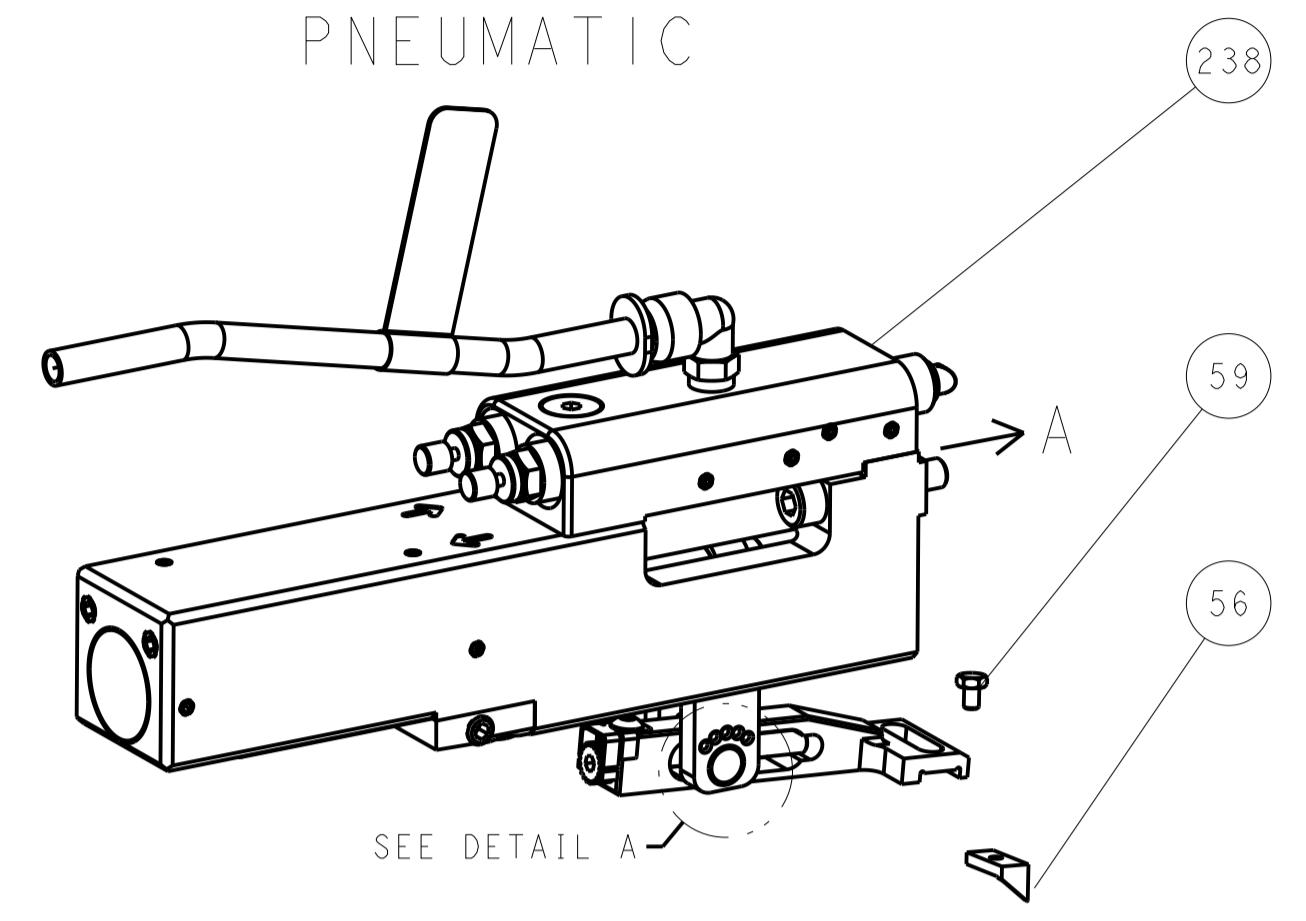
-	-	1	-	2844950-1	AIR FEED MODULE	290
-	1	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	283
-	1	1	1	2280441-1	INSERT, SHEAR	282
-	1	1	1	1803078-1	SPACER, PRECISION	259
-	1	-	1	2119641-1	FEED CAM, AIR FEED	248
-	1	-	1	2844940-1	AIR FEED MODULE	238
-	1	1	1	1-356885-0	STOP, SHEAR	237
-	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	1	1	1	1-22281-8	SPRING, COMPRESSION	121
-	1	1	1	1803415-1	WIRE DEPRESSOR	120
-	1	1	1	2844908-1	SCREW, LOCKING	99
-	1	1	1	2844907-1	POST, LOCKING	98
-	1	1	1	1-690438-0	FRONT STRIP GUIDE	96
-	2	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	95
-	1	1	1	2168083-6	SCR, SKT HD CAP, RoHS, M5 X 65	93
-	2	2	2	1803413-1	PLATE, WIRE DEPRESSOR	86
-	8	8	8	6-18023-9	SCR, SKT HD CAP M2 X 5.0	84
-	1	1	1	455888-7	SPACER, CRIMPER	82
-	1	1	1	1803607-3	DOCUMENTATION PACKAGE	71
-	1	1	1	1803415-1	WIRE DEPRESSOR	70
-	1	1	1	2119740-1	TAG IDENTIFICATION	67
-	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	2	2	2	2-18032-5	SCR, SET, FLT PNT, M5 X 20.0	61
-	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	60
-	1	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	1	1	1	1338683-1	FEED PAWL	56
-	4	4	4	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	54
-	2	2	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	53
-	1	-	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	1	1	1	1803583-9	APPLICATOR BASIC ASSEMBLY, SF	46
-	1	1	1	1803515-2	RAM ASSEMBLY, SF ATLANTIC	44
-	1	1	1	1803602-2	SCR, BHSC, RoHS (M8 X 40)	41
-	1	1	1	1803414-1	WIRE GUIDE	34
-	2	2	2	2079383-8	SCR, BHSC, RoHS (M4 X 16)	33
-	2	2	2	1-2844962-5	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	1	1803771-2	PLATE, REAR STRIP GUIDE	29
-	1	1	1	2-455888-2	SPACER, CRIMPER	28
-	2	2	2	22283-1	SPRING, COMPRESSION	27
-	1	1	1	356835-1	LEVER, DRAG RELEASE	26
-	1	1	1	240792-1	DRAG, TERMINAL	25
-	1	1	1	1633630-2	PLATE, STRIP GUIDE	24
-	1	1	1	980371-4	SCR, SKT HD SHLDR 5.0 DIA X 6.0	23
-	1	1	1	1-690463-6	FLOATING SHEAR, REAR	17
-	1	1	1	2119862-1	SHEAR HOLDER, REAR	14
-	1	1	1	3-22280-3	SPRING, COMPRESSION	12
-	-	-	-	-	-	10
-	-	-	-	-	-	9
-	1	2	1	1803416-1	ANVIL, COMBINATION	8
-	-	-	-	-	-	7
-	1	1	1	2-690468-9	DEPRESSOR SHEAR, REAR	6
-	-	-	-	-	-	5
-	-	-	-	-	-	4
-	-	-	-	-	-	3
-	-	-	-	-	-	2
-	1	2	1	1633723-6	CRIMPER, WIRE O	1

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

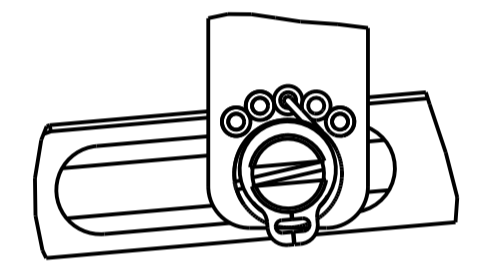
<small>THIS DRAWING IS UNPUBLISHED. IT IS THE PROPERTY OF STE CONNECTIVITY CORPORATION. IT IS TO BE USED ONLY FOR THE PURPOSES SPECIFIED IN THE ORDER. IT IS SUBJECT TO CHANGE AND WITHOUT WARRANTY. THE USER ASSUMES ALL LIABILITY FOR THE PROPER USE OF THIS DRAWING. CONTACT YOUR LOCAL SALES REPRESENTATIVE FOR MORE INFORMATION.</small>		OWN: R. KNEPPER 27-JUN-16 CHK: T. ELBIN 27-JUN-16 APVD: J. DEGRANGE 27-JUN-16	TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±	NAME: Ocean Side Feed Applicator PRODUCT SPEC: - APPLICATION SPEC: - SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2836364 RESTRICTED TO: -
MATERIAL: - FINISH: -		WEIGHT: - SCALE: 1:2 SHEET: 1 OF 4 REV: D1	Customer Accessible Production Drawing

LOC		DIST		REVISIONS			
A	66	P	LTM	DESCRIPTION	DATE	DWN	APVD
		-	-	SEE SHEET 1	-	-	-

FEED TYPE PNEUMATIC

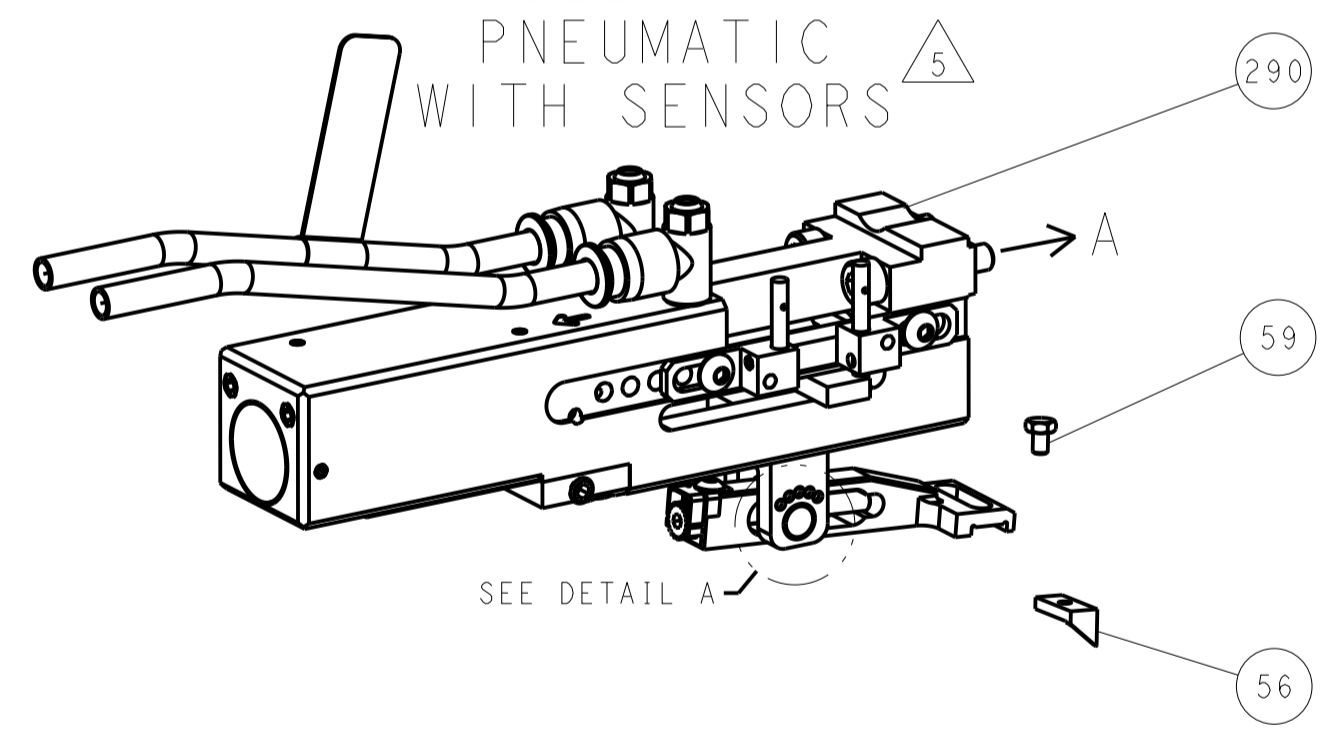


FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



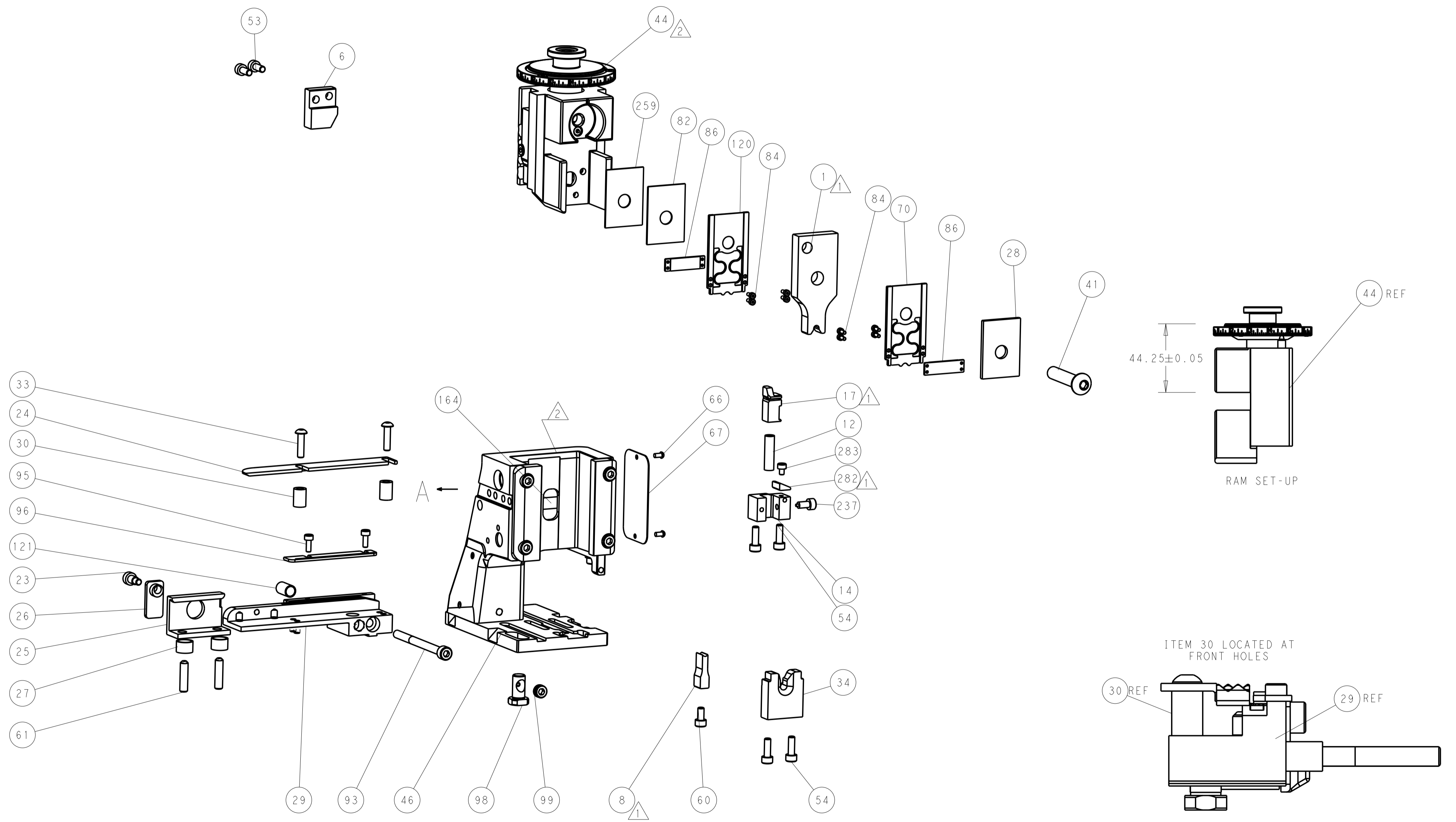
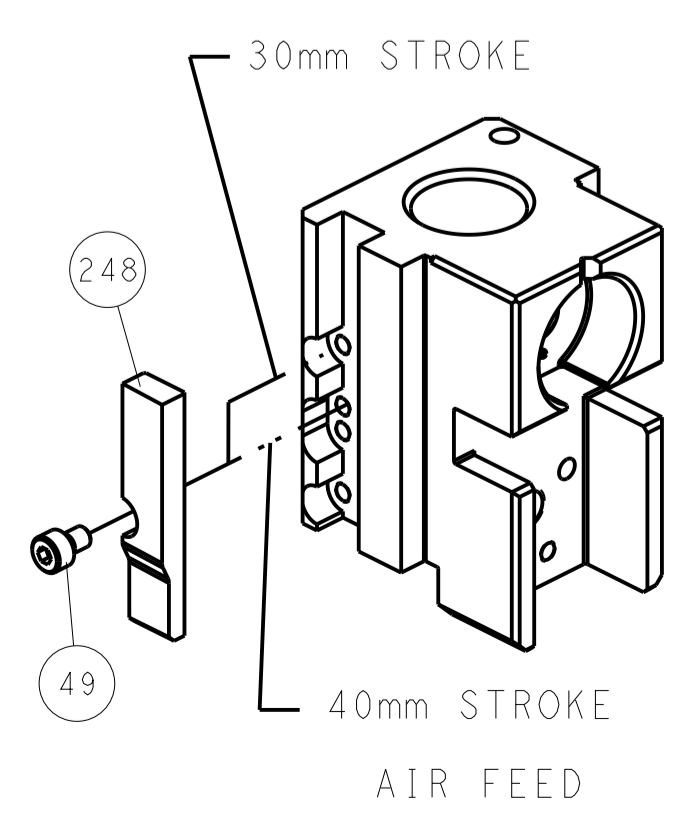
DETAIL A

DOUBLE ACTING PNEUMATIC WITH SENSORS



SEE DETAIL A

CAM POSITIONS

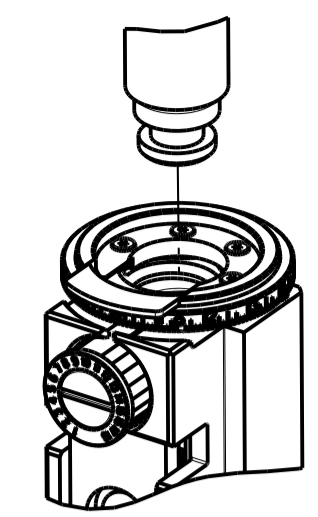


ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

<small>THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.</small>		DWN: R. KNEPPER 27-JUN-16 CHK: T. ELBIN 27-JUN-16 APVD: J. DEGRANGE 27-JUN-16	TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		NAME: Ocean Side Feed Applicator PRODUCT SPEC: APPLICATION SPEC: SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2836364	RESTRICTED TO:
MATERIAL:		WEIGHT:	SCALE: 1:2 SHEET: 2 OF 4 REV: D1

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2836364-2	D	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
4-2836364-2	D	FINE CRIMP HEIGHT ADJUST	DOUBLE ACTING PNEUMATIC WITH SENSORS
7-2836364-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	3.81 mm [.150]	Ø
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: SHIELD, SHELL, BARREL			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
17.60-18.40 mm [.693-.724 IN]		Ø3.10-3.50 mm [.122-.138 IN]	
TERMINAL APPLICATION SPECIFICATION	114-94058	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
1823899-1	1823899-2		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
Leoni Dacar 535	3.80 +/- 0.10 [.150 +/- .004]	8.3

- RECOMMENDED SPARE PARTS
- REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- 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 PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- THIS APPLICATOR IS EQUIPPED WITH THE DOUBLE ACTING FEED WITH SENSORS AND IS APPLICATION SPECIFIC. IT DOES NOT REQUIRE ITEMS 49 & 151.
- 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.

LOC	DIST	REV	DATE	BY	APPV
A	66				

REV	DATE	DESCRIPTION	DATE	BY	APPV
-	1	-	2844950-1	AIR FEED MODULE	290
-	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	283
-	1	1	2280441-1	INSERT, SHEAR	282
-	1	1	1803078-1	SPACER, PRECISION	259
-	-	1	2844940-1	AIR FEED MODULE	238
-	1	1	1-356885-0	STOP, SHEAR	237
-	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
-	2	2	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	143
-	2	2	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	143
-	-	-	2119653-2	FEED CAM, POST FEED	142
-	1	1	1-1803583-0	APPLICATOR BASIC ASSEMBLY, SF	141
-	1	1	1803516-2	RAM ASSEMBLY, SF PACIFIC	140
-	1	1	1-22281-8	SPRING, COMPRESSION	121
-	1	1	1803415-1	WIRE DEPRESSOR	120
-	1	1	2844908-1	SCREW, LOCKING	99
-	1	1	2844907-1	POST, LOCKING	98
-	1	1	1-690438-0	FRONT STRIP GUIDE	96
-	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	95
-	1	1	2168083-6	SCR, SKT HD CAP, RoHS, M5 X 65	93
-	2	2	1803413-1	PLATE, WIRE DEPRESSOR	86
-	8	8	6-18023-9	SCR, SKT HD CAP M2 X 5.0	84
-	1	1	455888-7	SPACER, CRIMPER	82
-	1	1	1803607-3	DOCUMENTATION PACKAGE	71
-	1	1	1803415-1	WIRE DEPRESSOR	70
-	1	1	2119740-1	TAG IDENTIFICATION	67
-	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	2	2	2-18032-5	SCR, SET, FLT PNT, M5 X 20.0	61
-	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	1	1	1338683-1	FEED PAWL	56
-	2	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	53
-	-	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	1	1	1803602-2	SCR, BHSC, RoHS (M8 X 40)	41
-	1	1	1803414-1	WIRE GUIDE	34
-	2	2	2079383-8	SCR, BHSC, RoHS (M4 X 16)	33
-	2	2	1-2844962-5	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	1803771-2	PLATE, REAR STRIP GUIDE	29
-	1	1	2-455888-2	SPACER, CRIMPER	28
-	2	2	22283-1	SPRING, COMPRESSION	27
-	1	1	356835-1	LEVER, DRAG RELEASE	26
-	1	1	240792-1	DRAG, TERMINAL	25
-	1	1	1633630-2	PLATE, STRIP GUIDE	24
-	1	1	980371-4	SCR, SKT HD SHLDR 5.0 DIA X 6.0	23
-	1	1	1-690463-6	FLOATING SHEAR, REAR	17
-	1	1	2119862-1	SHEAR HOLDER, REAR	14
-	1	1	3-22280-3	SPRING, COMPRESSION	12
-	-	-	-	-	10
-	-	-	-	-	9
-	1	1	1803416-1	ANVIL, COMBINATION	8
-	-	-	-	-	7
-	1	1	2-690468-9	DEPRESSOR SHEAR, REAR	6
-	-	-	-	-	5
-	-	-	-	-	4
-	-	-	-	-	3
-	-	-	-	-	2
-	1	1	1633723-6	CRIMPER, WIRE Ø	1

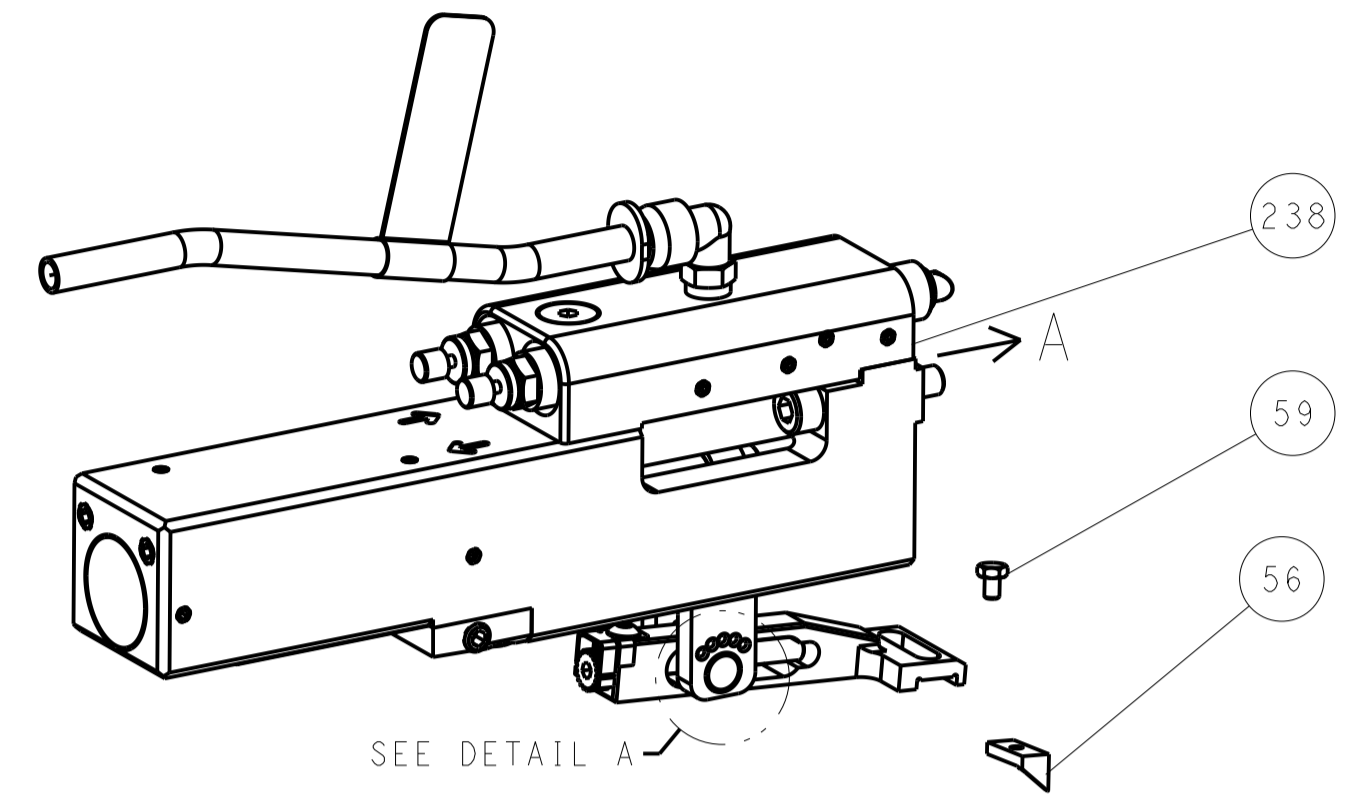
PACIFIC VERSION
Shown on sheets 3 of 4 & 4 of 4
(Atlantic version shown on sheets 1 of 4 & 2 of 4)

DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		OWN: R. KNEPPER 27-JUN-16		TE Connectivity Harrisburg, PA 17105-3608	
0 PLC ±		1 PLC ±		CHK: T. ELBIN 27-JUN-16		NAME: Ocean Side Feed Applicator	
2 PLC ±		3 PLC ±		APVD: J. DEGRANGE 27-JUN-16		PRODUCT SPEC: -	
4 PLC ±		ANGLES ±		APPLICATION SPEC: -		SIZE: -	
FINISH: -		MATERIAL: -		WEIGHT: -		SCALE: 1:2	
Customer Accessible Production Drawing		CAGE CODE: 00779		DRAWING NO: 2836364		SHEET 3 OF 4	

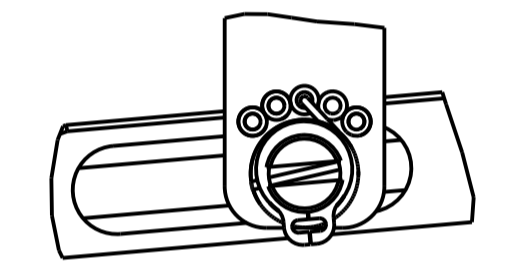
LOC		DIST		REVISIONS			
A	66	P	LTM	DESCRIPTION	DATE	DWN	APVD
				SEE SHEET 1			

FEED TYPE

PNEUMATIC

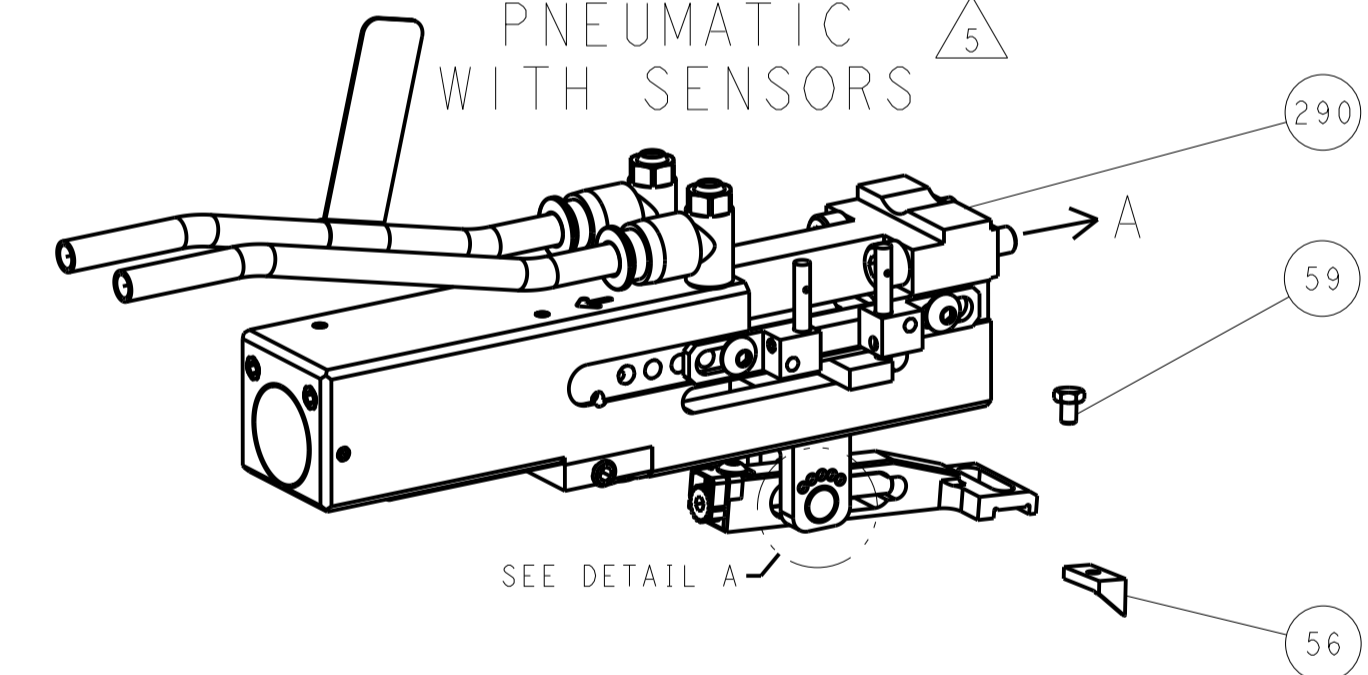


FEED SPRING SETTING POSITION
(SHOWN FROM REAR SIDE)



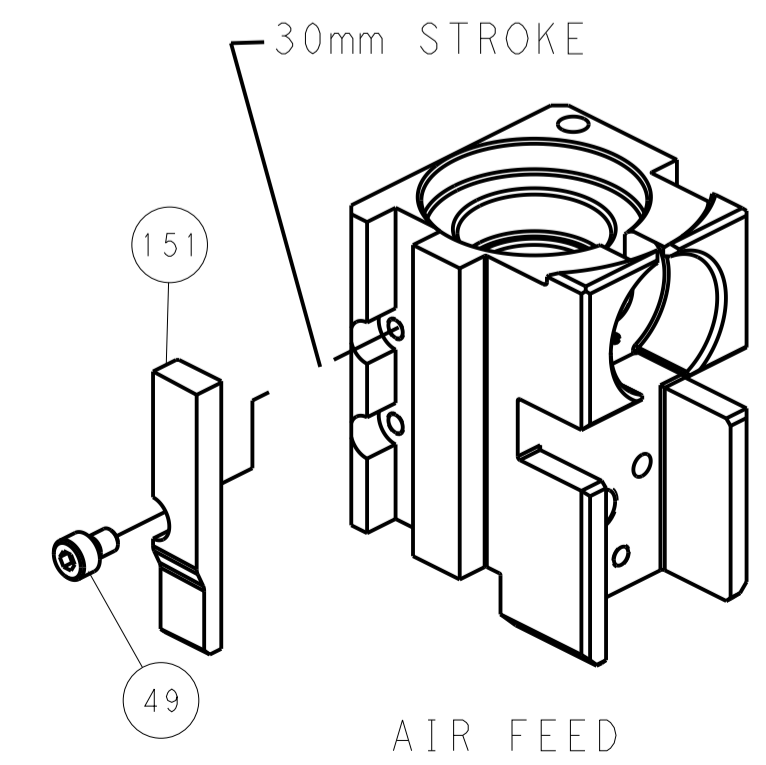
DETAIL A

DOUBLE ACTING PNEUMATIC WITH SENSORS

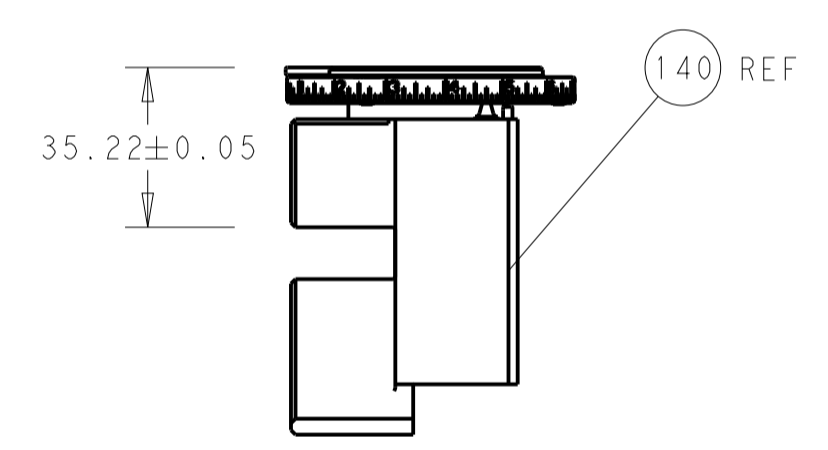
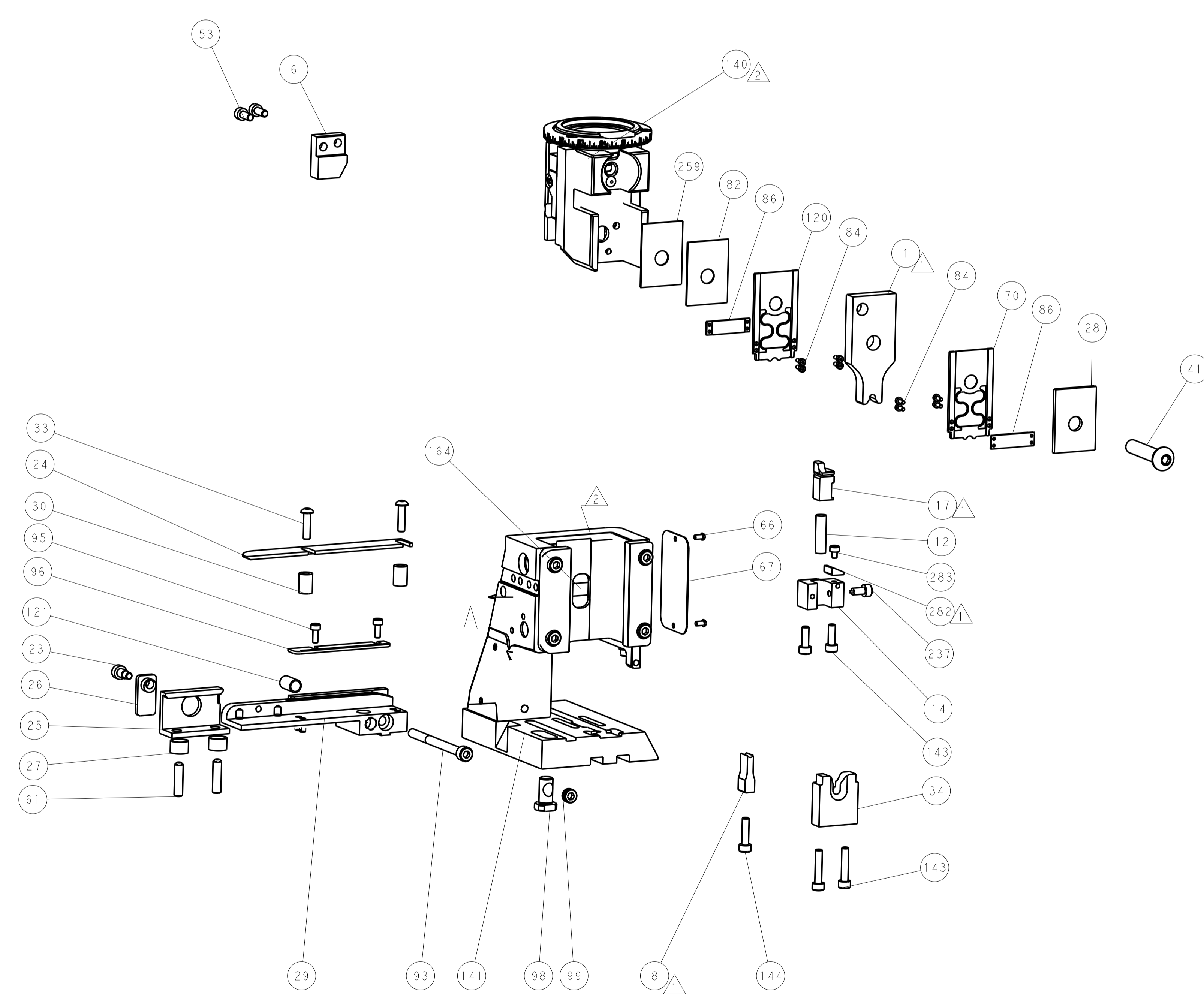


SEE DETAIL A

CAM POSITIONS

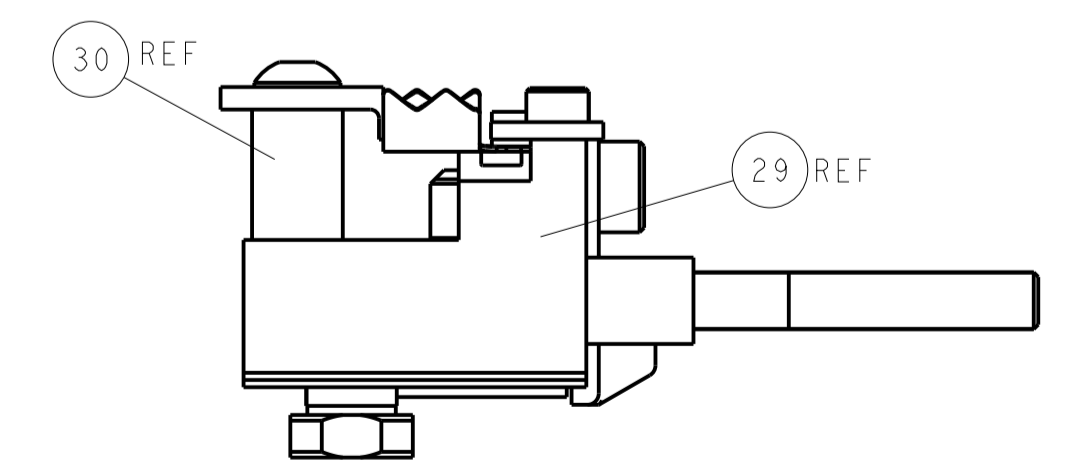


AIR FEED



RAM SET-UP

ITEM 30 LOCATED AT FRONT HOLES



FEED TRACK POSITION GUIDE BY WIRE BARREL

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:		DWN R. KNEPPER 27-JUN-16		TE Connectivity	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	Harrisburg, PA 17105-3608	
MATERIAL:		FINISH:		APVD J. DEGRANGE 27-JUN-16		NAME Ocean Side Feed Applicator	
				PRODUCT SPEC		SIZE CAGE CODE DRAWING NO	
				APPLICATION SPEC		A1 00779 C=2836364	
				WEIGHT		RESTRICTED TO	
				Customer Accessible Production Drawing		SCALE 1:2 SHEET 4 OF 4 REV D1	