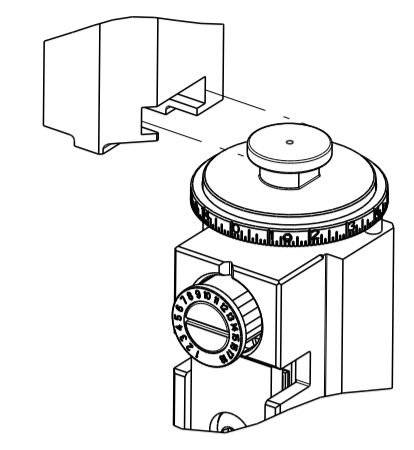


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2836399-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2836399-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2836399-1	B	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2836399-2	C	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2836399-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.07 mm [.042]	F
INSUL	1.78 mm [.070]	F

APPLICATOR INSTRUCTIONS 408-35042

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: MINI AMP-IN CONTACT			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
1.72-2.48 mm [.068-.098 IN]		Ø1.02-1.52 mm [.040-.060 IN]	
TERMINAL APPLICATION SPECIFICATION	114-1016		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
925819-2	925819-3		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.35mm2	0.99+/-0.05 [.039+/-0.002]	8.3
22 AWG OR 0.32mm2	0.96+/-0.05 [.038+/-0.002]	8.8
0.25mm2	0.90+/-0.05 [.035+/-0.002]	9.4
24 AWG OR 0.20mm2	0.86+/-0.05 [.034+/-0.002]	9.8
26 AWG OR 0.14mm2	0.81+/-0.05 [.032+/-0.002]	10.4
0.12mm2	0.79+/-0.05 [.031+/-0.002]	10.0

- 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.

**\*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	REVISIONS					
A	66	P	LTN	DESCRIPTION	DATE	OWN	APVD
		A		RELEASED	09SEP2016	MR	TE
		B		ECR-19-001789	02FEB2019	TB	CT
		C		ECR-22-139818	19MAY2022	TB	RK

-	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	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	1-2168083-4	SCR, SKT HD CAP, RoHS, M4 X 5	53	
-	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	2-1752356-7	SUPPORT, TERMINAL	34	
-	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33	
-	2	2	2	2	2-2844962-4	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	1320928-2	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	2119533-3	STRIPPER, SIDE FEED	19	
-	1	1	1	1	2-690518-6	HOLD DOWN, TERMINAL	18	
-	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	2	2	1	1-1633916-5	ANVIL, COMBINATION	8	
-	-	-	-	-	-	-	7	
-	-	-	-	-	-	-	6	
-	1	1	1	1	2119757-8	DEPRESSOR, SHEAR	5	
-	1	1	1	1	238011-7	BLOCK, CRIMPER SPACER	4	
-	1	2	2	1	1-1633961-8	CRIMPER, INSULATION F PREMIUM	3	
-	1	1	1	1	455888-2	SPACER, CRIMPER	2	
-	1	2	2	1	1-456401-7	CRIMPER, WIRE .042 F PREMIUM	1	
-	77	-72	-71	-2	-1	PART NO	DESCRIPTION	ITEM NO

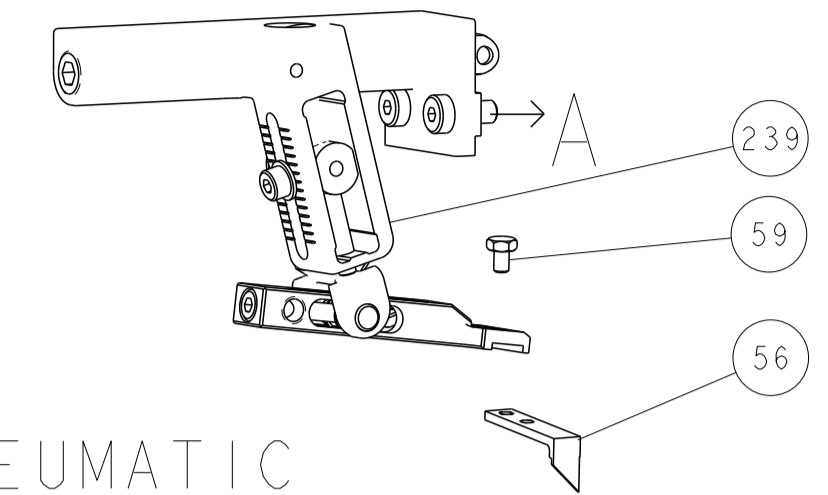
ATLANTIC VERSION  
 Shown on sheets 1 of 4 & 2 of 4  
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

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

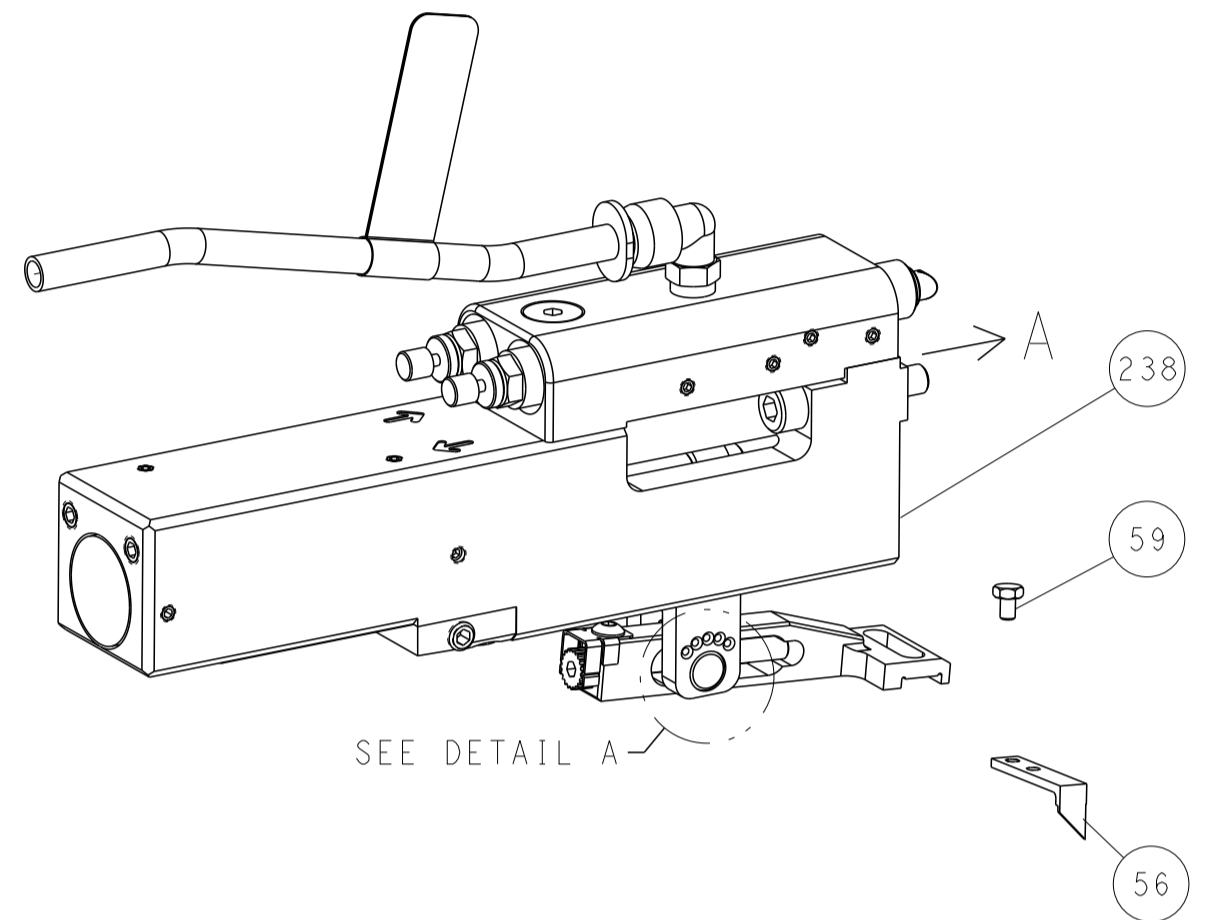
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CHK	L. ZHANG	14JUL2016
APVD	L. ZHANG	14JUL2016
PRODUCT SPEC		
APPLICATION SPEC		
SIZE	CAGE CODE	DRAWING NO
A1	00779	2836399
Customer Accessible Production Drawing		
SCALE	1:2	SHEET 1 OF 4
REV	C	

LOC	DIST	REV	DATE	BY	APPV
A	66				
REVISIONS			DATE	BY	APPV

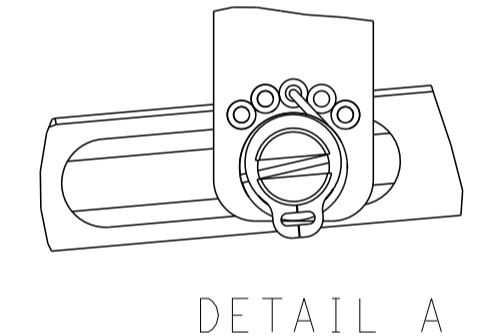
# FEED TYPE MECHANICAL



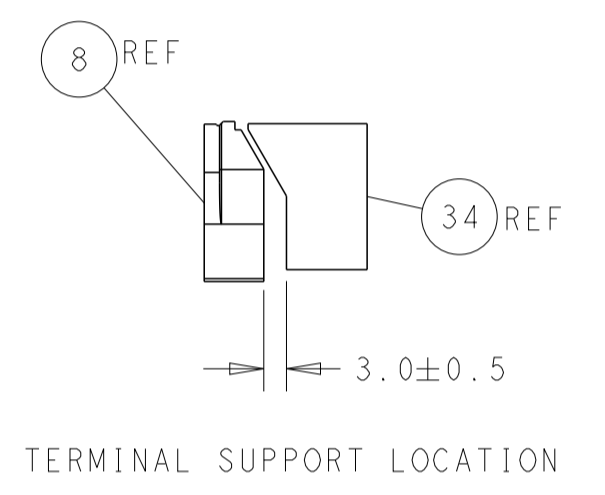
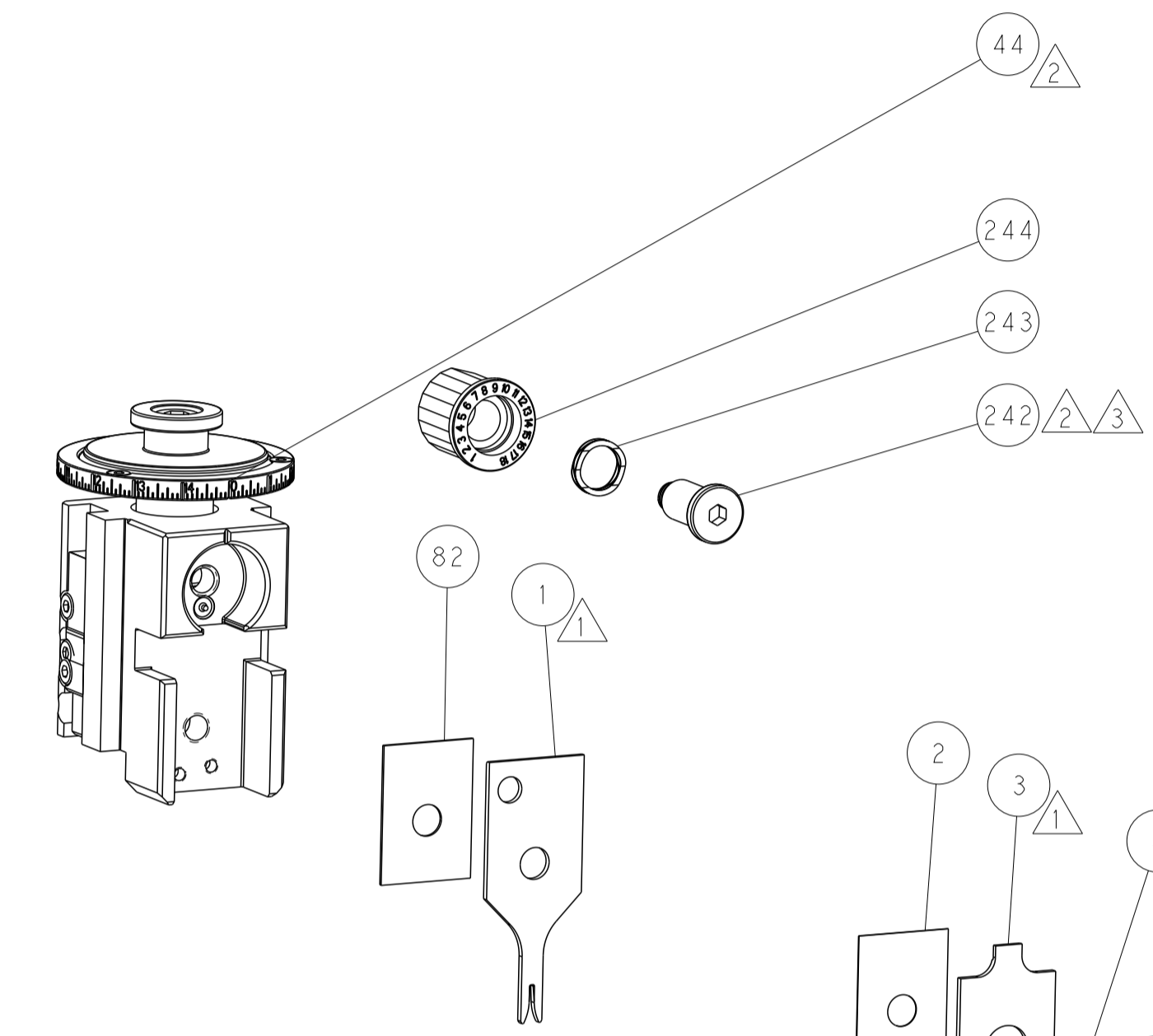
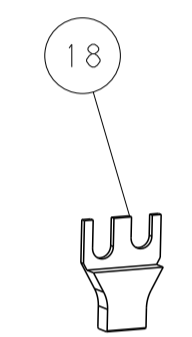
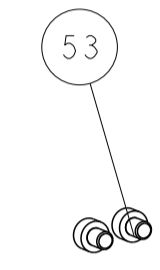
## PNEUMATIC



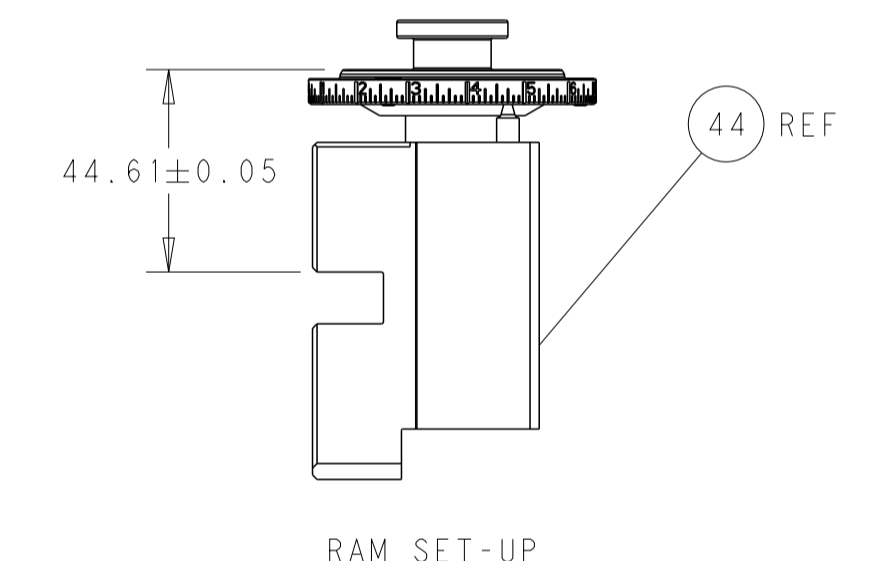
## FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



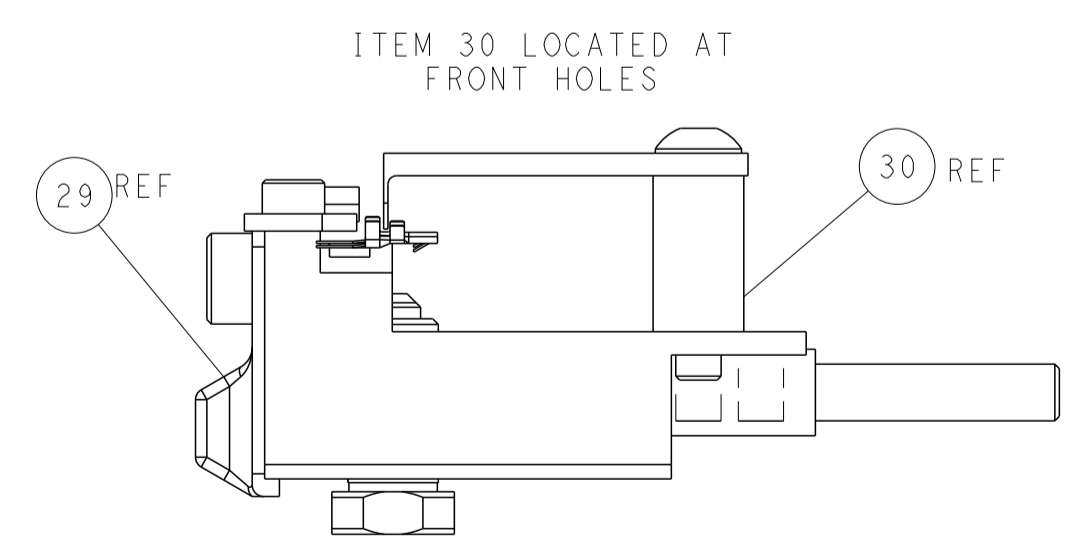
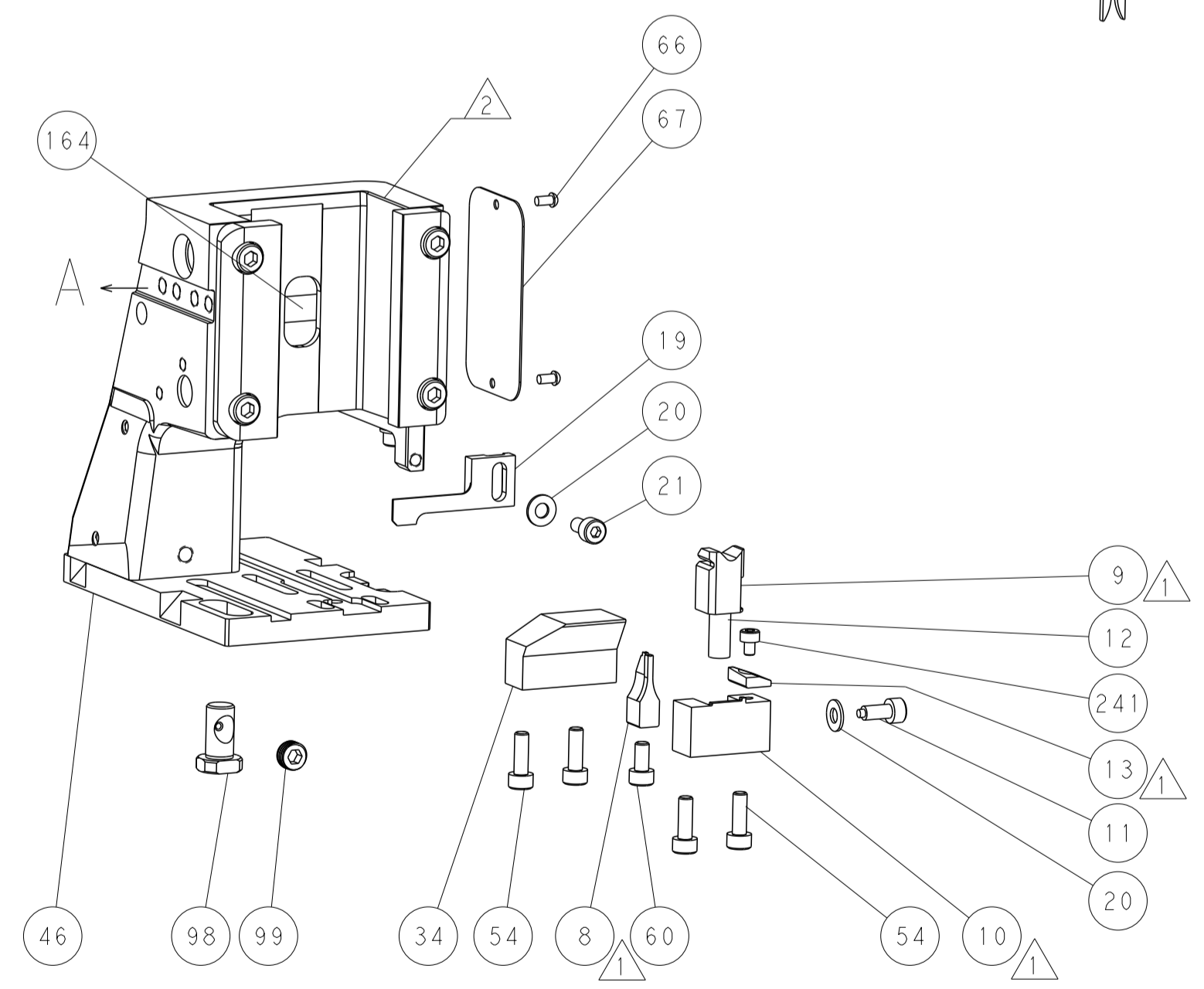
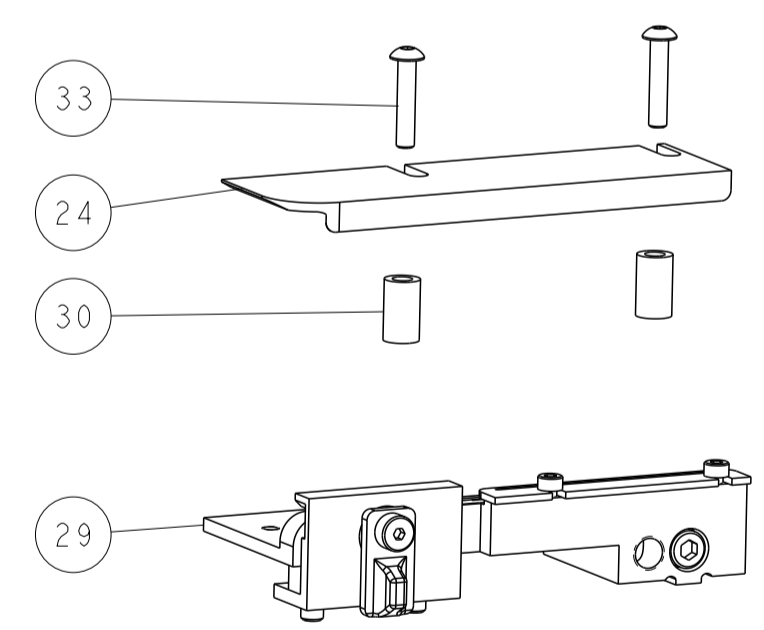
DETAIL A



TERMINAL SUPPORT LOCATION

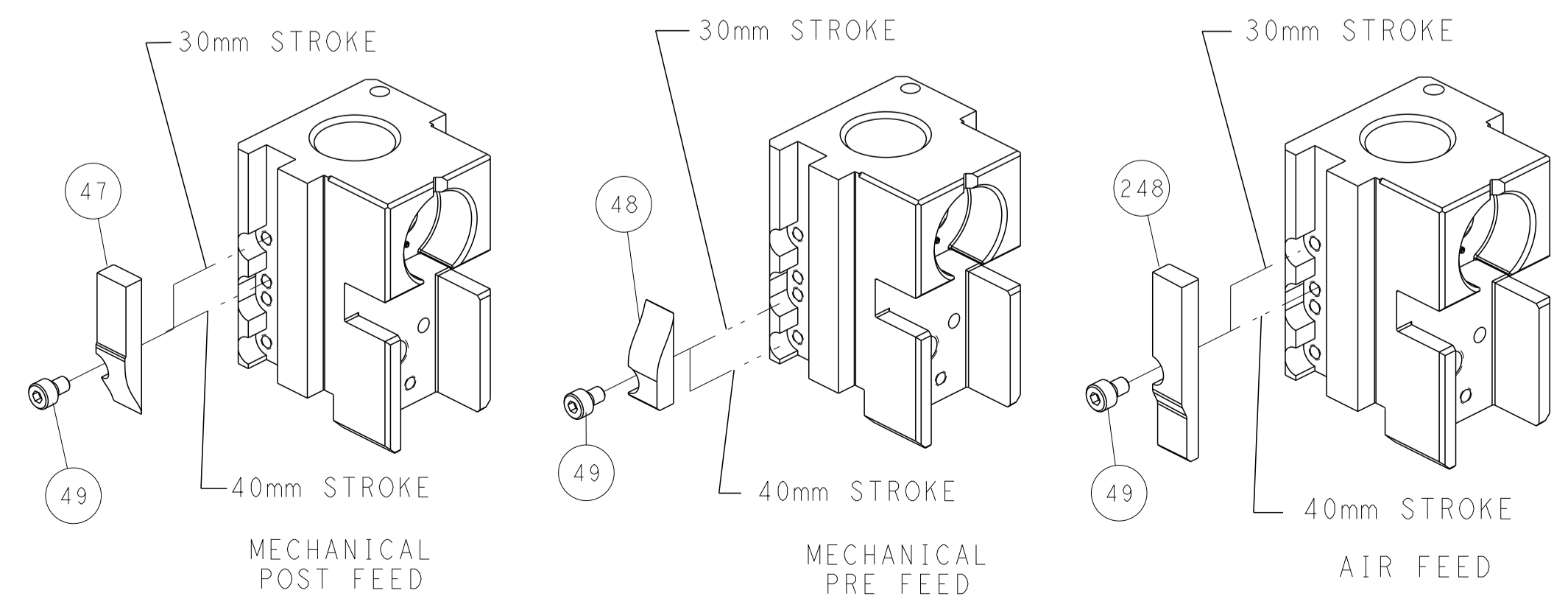


RAM SET-UP



FEED TRACK POSITION GUIDE BY INSULATION BARREL

# CAM POSITIONS



**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:		DWG: H. HUANG 14JUL2016		TE Connectivity	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	Harrisburg, PA 17105-3608	
MATERIAL:		FINISH:		CHK: L. ZHANG 14JUL2016		NAME: Ocean Side Feed Applicator	
				APVD: L. ZHANG 14JUL2016		SIZE: A1	
				PRODUCT SPEC:		CAGE CODE: 00779	
				APPLICATION SPEC:		DRAWING NO: 2836399	
				WEIGHT:		SCALE: 1:2	
				Customer Accessible Production Drawing		SHEET 2 OF 4	

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2836399-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2836399-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2836399-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR  
 INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.07 mm [.042]	F
INSUL	1.78 mm [.070]	F

APPLICATOR INSTRUCTIONS  
 408-35042

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: MINI AMP-IN CONTACT			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
1.72-2.48 mm [.068-.098 IN]		∅1.02-1.52 mm [.040-.060 IN]	
TERMINAL APPLICATION SPECIFICATION	114-1016		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
925819-2	925819-3		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.35mm2	0.99+/-0.05 [.039+/-0.002]	8.3
22 AWG OR 0.32mm2	0.96+/-0.05 [.038+/-0.002]	8.8
0.25mm2	0.90+/-0.05 [.035+/-0.002]	9.4
24 AWG OR 0.20mm2	0.86+/-0.05 [.034+/-0.002]	9.8
26 AWG OR 0.14mm2	0.81+/-0.05 [.032+/-0.002]	10.4
0.12mm2	0.79+/-0.05 [.031+/-0.002]	10.0

- 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.

**\*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	REVISIONS					
		P	LTN	DESCRIPTION	DATE	OWN	APVD
A	66	-	-	SEE SHEET 1	-	-	-

-	1	1	2119082-5	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	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	1-2168083-4	SCR, SKT HD CAP, RoHS, M4 X 5	53
-	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	2-1752356-7	SUPPORT, TERMINAL	34
-	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	2-2844962-4	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29
-	1	1	455888-3	SPACER, CRIMPER	28
-	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	2119533-3	STRIPPER, SIDE FEED	19
-	1	1	2-690518-6	HOLD DOWN, TERMINAL	18
-	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	1-1633916-5	ANVIL, COMBINATION	8
-	-	-	-	-	7
-	-	-	-	-	6
-	1	1	2119757-8	DEPRESSOR, SHEAR	5
-	1	1	238011-7	BLOCK, CRIMPER SPACER	4
-	1	1	4-1633961-8	CRIMPER, INSULATION F PREMIUM	3
-	1	1	455888-2	SPACER, CRIMPER	2
-	1	1	1-456401-7	CRIMPER, WIRE .042 F PREMIUM	1

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

ITEM NO	DESCRIPTION	DATE	BY	CHK	APVD
77	22	21	PART NO		
			DESCRIPTION		

OWN	H. HUANG	14JUL2016
CHK	L. ZHANG	14JUL2016
APVD	L. ZHANG	14JUL2016

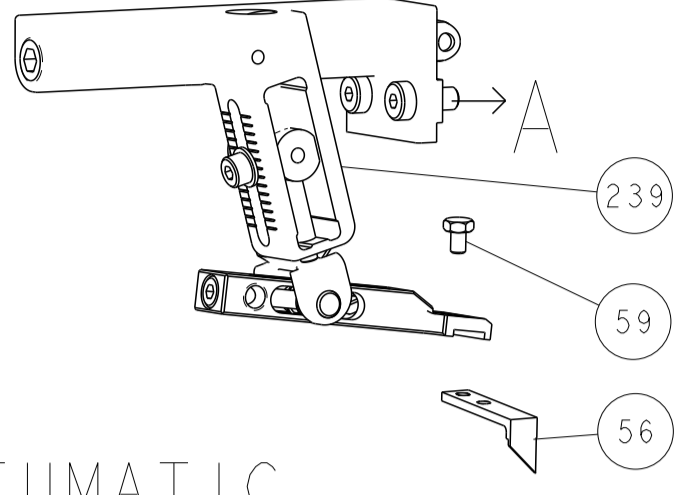
NAME	Ocean Side Feed Applicator	
SIZE	CAGE CODE	DRAWING NO
A1	00779	C=2836399

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

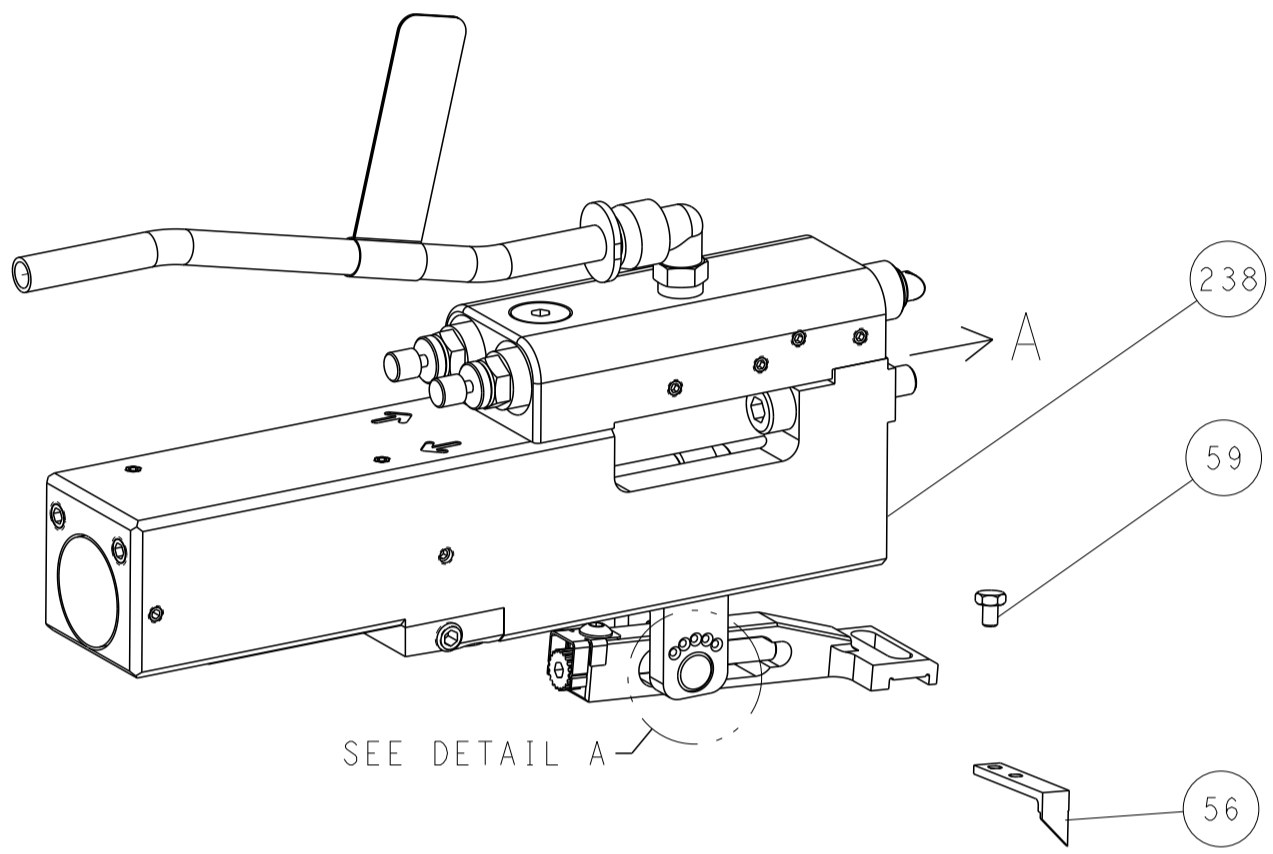
PACIFIC VERSION  
 Shown on sheets 3 of 4 & 4 of 4  
 (Atlantic version shown on sheets 1 of 4 & 2 of 4)

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

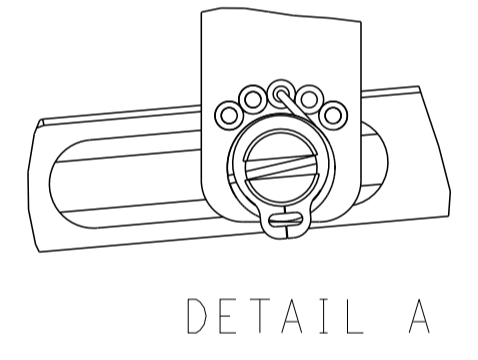
# FEED TYPE MECHANICAL



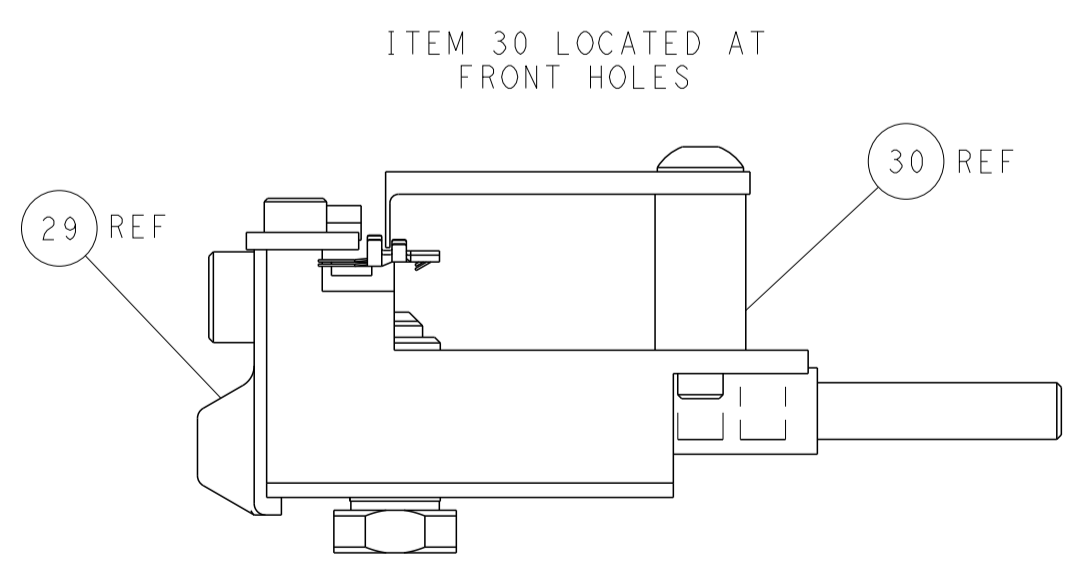
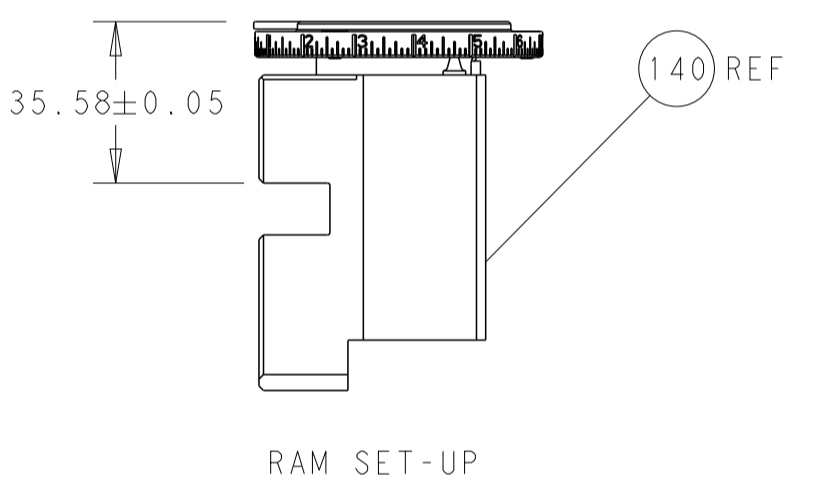
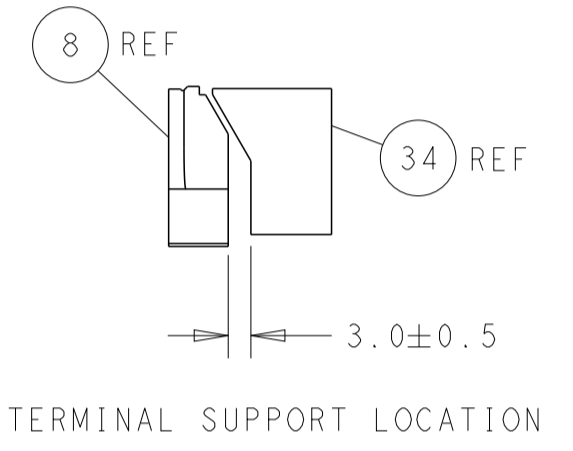
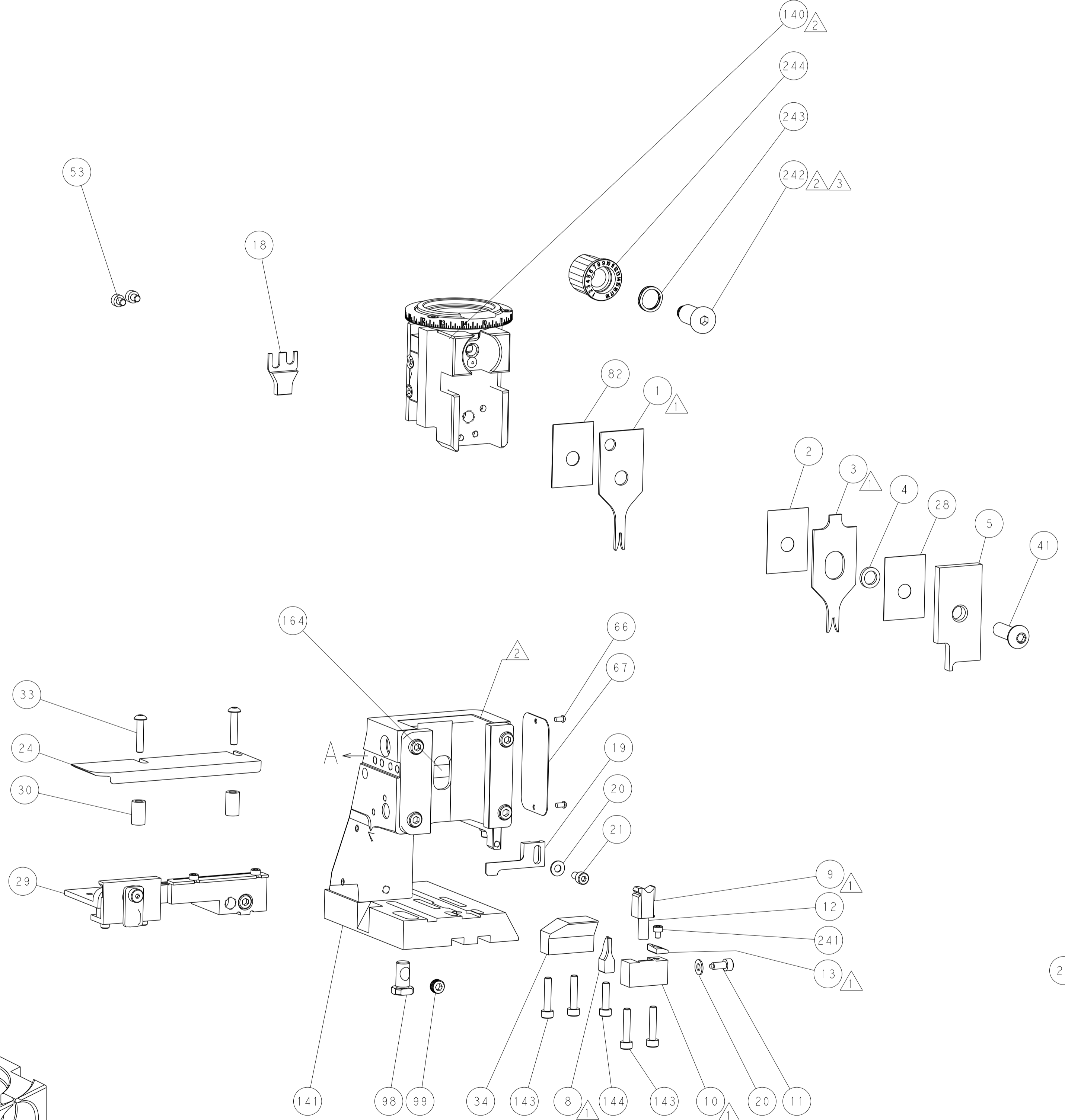
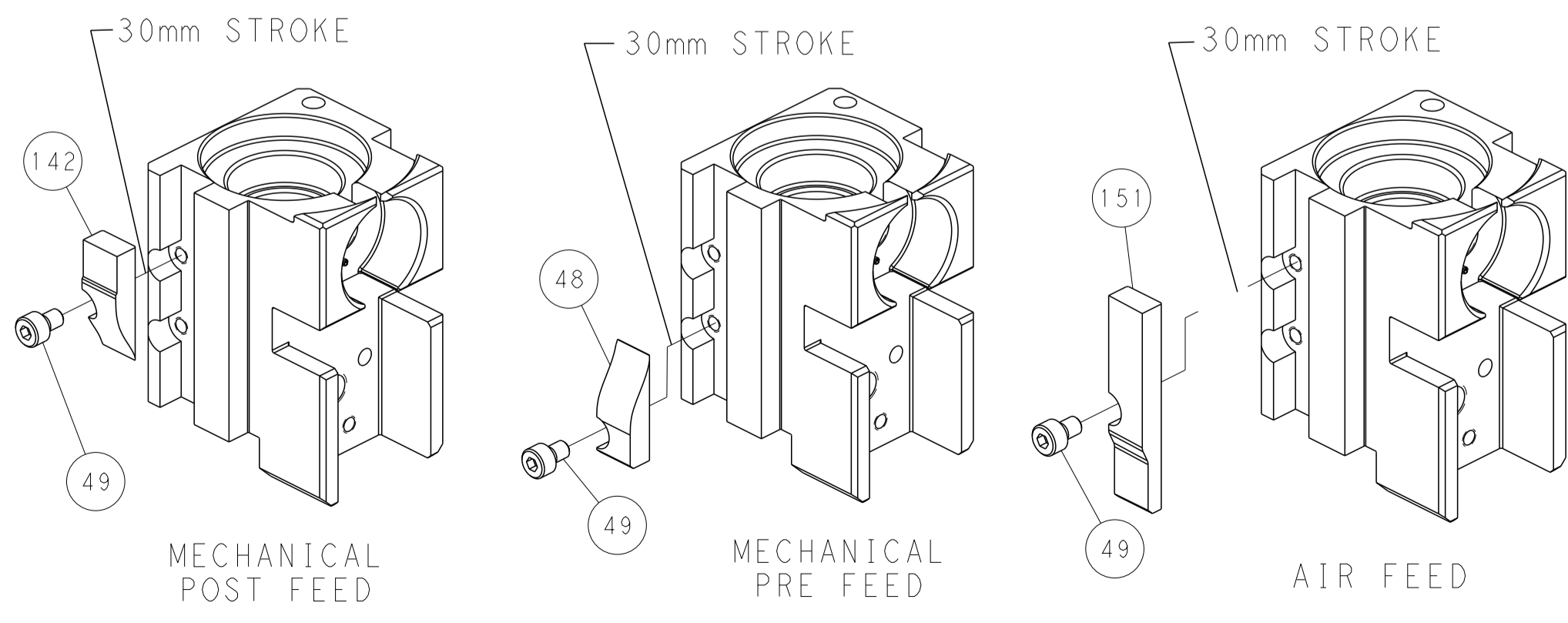
# PNEUMATIC



# 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 UNPUBLISHED. RELEASED FOR PUBLICATION. ALL RIGHTS RESERVED. © 2016 BY TYCO ELECTRONICS CORPORATION. THIS IS THE PROPERTY OF COMPANY AND IS NOT TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, WITHOUT PERMISSION IN WRITING FROM TYCO ELECTRONICS CORPORATION. SHOULD BE CONTACTED FOR THE LATEST POSITION.</small>		DWN: H. HUANG 14JUL2016 CHK: L. ZHANG 14JUL2016 APVD: L. ZHANG 14JUL2016	NAME: TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH ±	PRODUCT SPEC APPLICATION SPEC WEIGHT SCALE: 1:2	SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2836399	RESTRICTED TO: - SHEET: 4 OF 4 REV: C