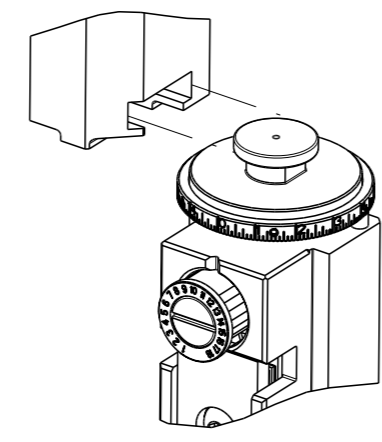


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2836453-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2836453-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2836453-1	C	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2836453-2	C	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2836453-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER

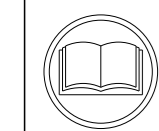


APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.50 mm [.059]	F
INSUL	1.80 mm [.071]	O

APPLICATOR INSTRUCTIONS  
408-35043

TERMINAL DATA: LEAR TERMINAL		LEAR CRIMP SPECIFICATION	
TERMINAL NAME: AFK FEMALE TERMINAL			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
3.76-4.52 mm [.148-.178 IN]		Ø1.20-1.30 mm [.047-.051 IN]	
TERMINAL APPLICATION SPECIFICATION	N 103 357 Rev 49		
TERMINALS APPLIED			
TE TERMINAL	LEAR TERMINAL	TE TERMINAL	LEAR TERMINAL
1949189-1	26591.331.185	1949189-2	26591.201.702

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.35mm2	1.02 +/- 0.03 [1.040 +/- .001]	10.7



- △ 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.

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					
		#	LY#	DESCRIPTION	DATE	OWN	APVD
A	66	A		RELEASED	14DEC2016	RK	CT
		B		ECR-20-015414	29OCT2020	FJ	TE
		C		ECR-21-006774	08JUL2021	FZ	RK

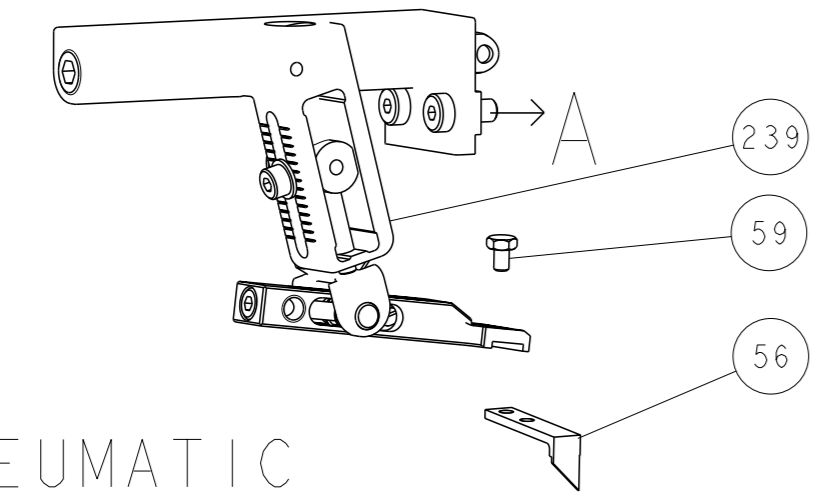
-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248	
-	1	1	1	1	2119082-1	CAM, SNAIL, INSULATION ADJUSTMENT	244	
-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243	
-	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242	
-	1	1	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241	
-	-	1	-	1	2119580-1	MECHANICAL FEED 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	1-2168083-0	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	1-1752356-8	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	2844992-2	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	2119533-1	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	6-1803249-1	ANVIL, COMBINATION	8
-	-	-	-	-	-	-	7	
-	-	-	-	-	-	-	6	
-	1	1	1	1	1-2119757-2	DEPRESSOR, SHEAR	5	
-	1	1	1	1	6-238011-0	BLOCK, CRIMPER SPACER	4	
-	1	2	2	1	1	8-1803019-2	CRIMPER, INSULATION O	3
-	1	1	1	1	455888-9	SPACER, CRIMPER	2	
-	1	2	2	1	1	8-1490019-0	CRIMPER, WIRE PREMIUM	1
-	77	72	71	-2	-1	PART NO	ITEM NO	

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

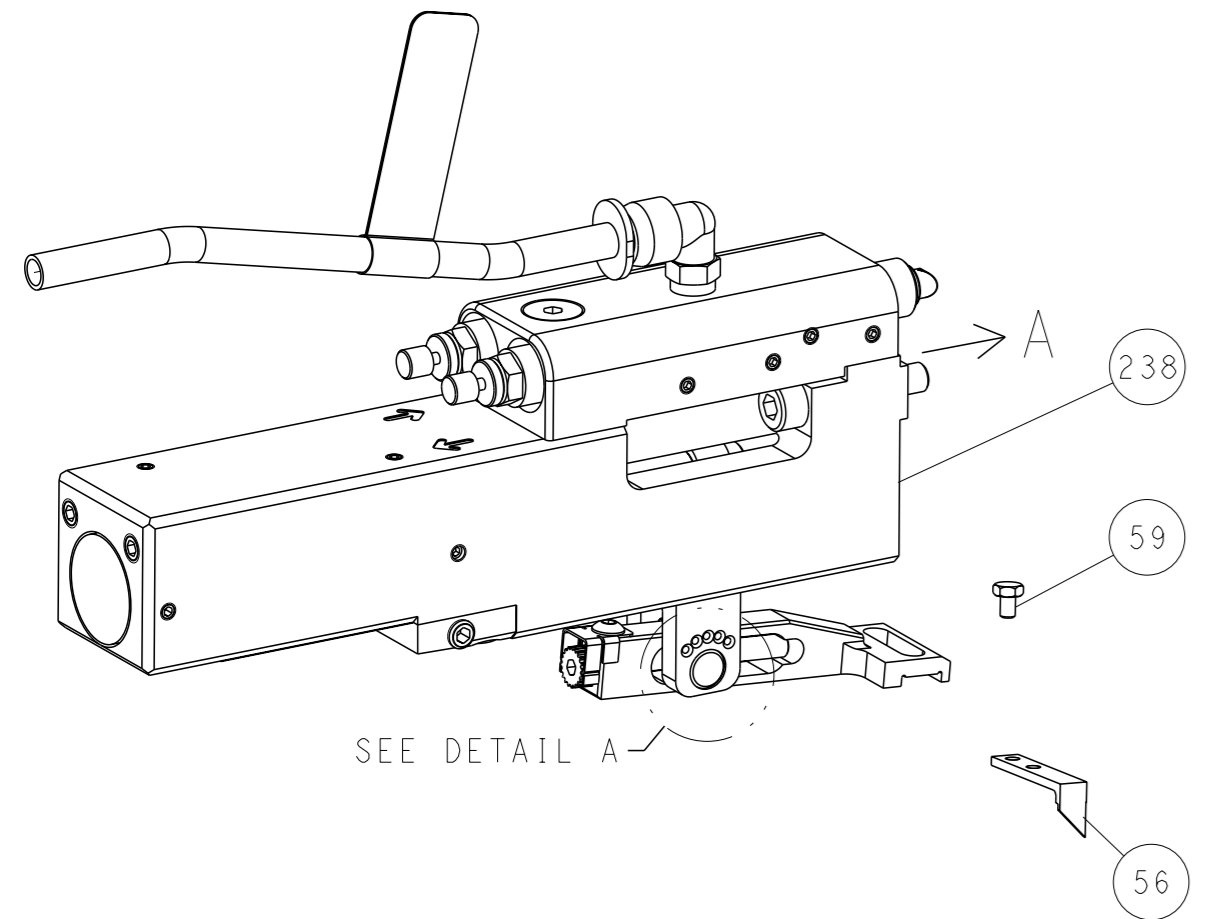
OWN	Y. YIN	26OCT2016	TE Connectivity Harrisburg, PA 17105-3608
CHK	G. BAILEY	26OCT2016	
APVD	H. ZHANG	26OCT2016	NAME
PRODUCT SPEC			Ocean Side Feed Applicator
APPLICATION SPEC			
SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
A1	00779	2836453	
Customer Accessible Production Drawing			SCALE 1:2 SHEET 1 OF 4 REV C

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

# FEED TYPE MECHANICAL



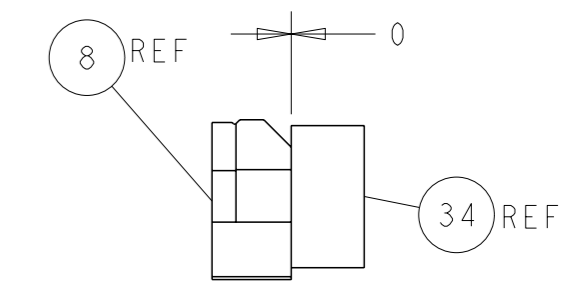
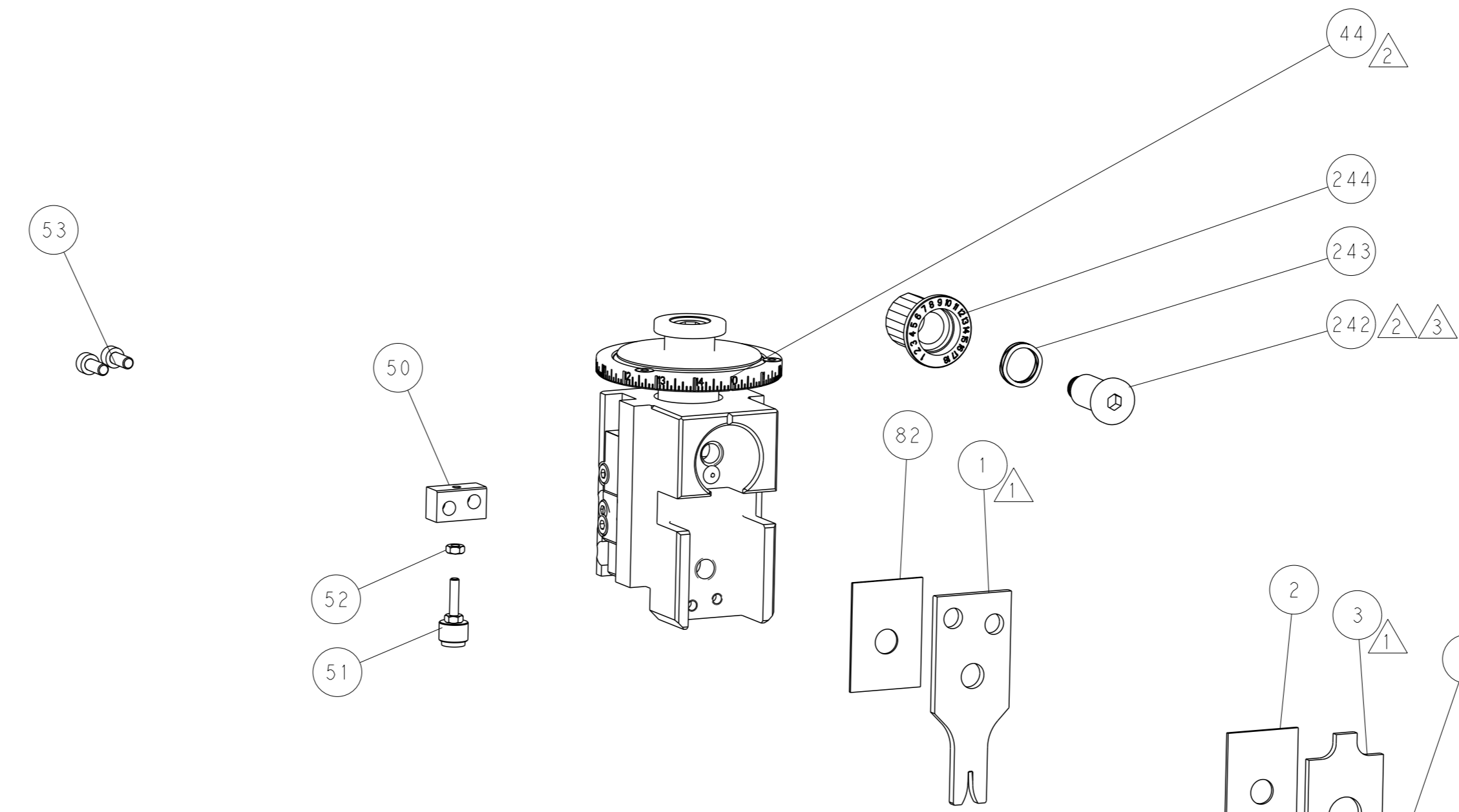
## PNEUMATIC



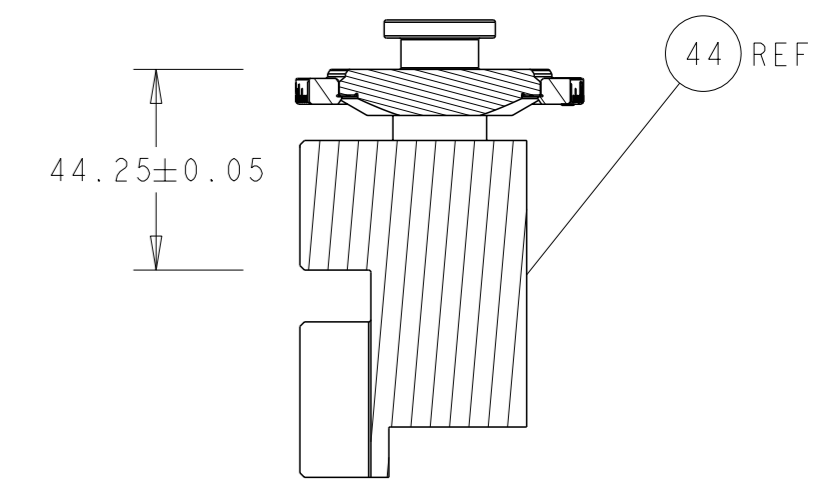
## FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



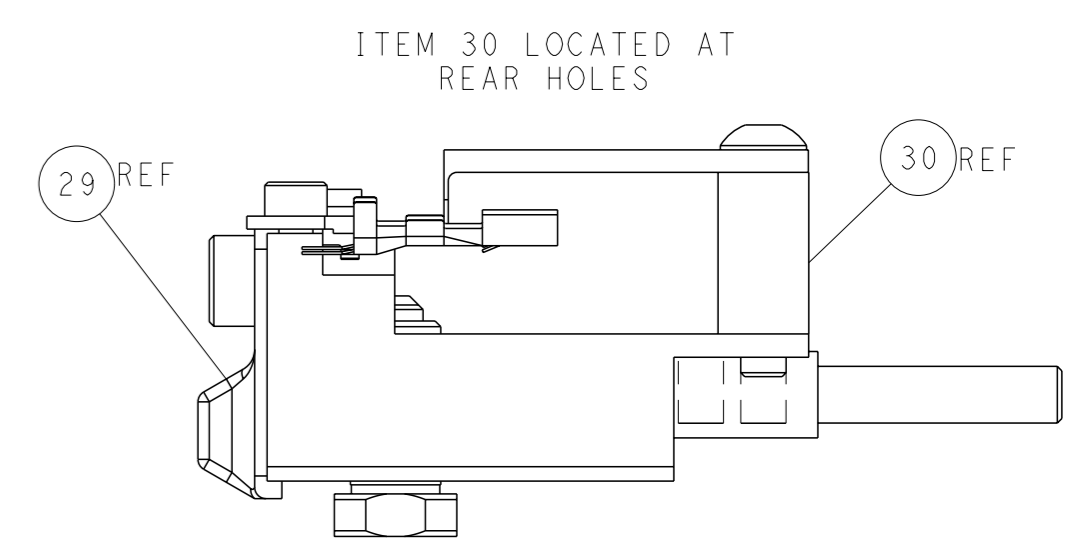
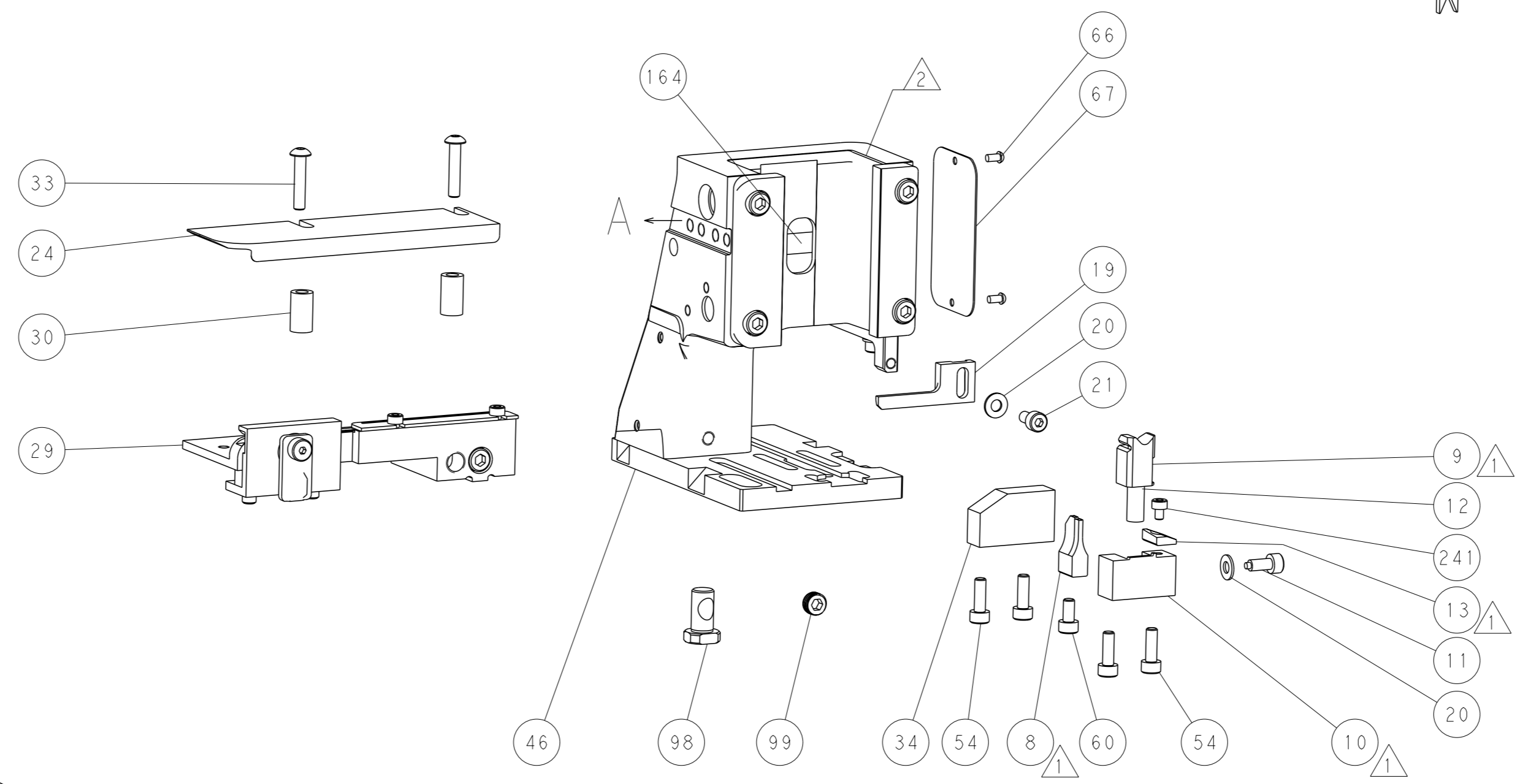
DETAIL A



TERMINAL SUPPORT LOCATION

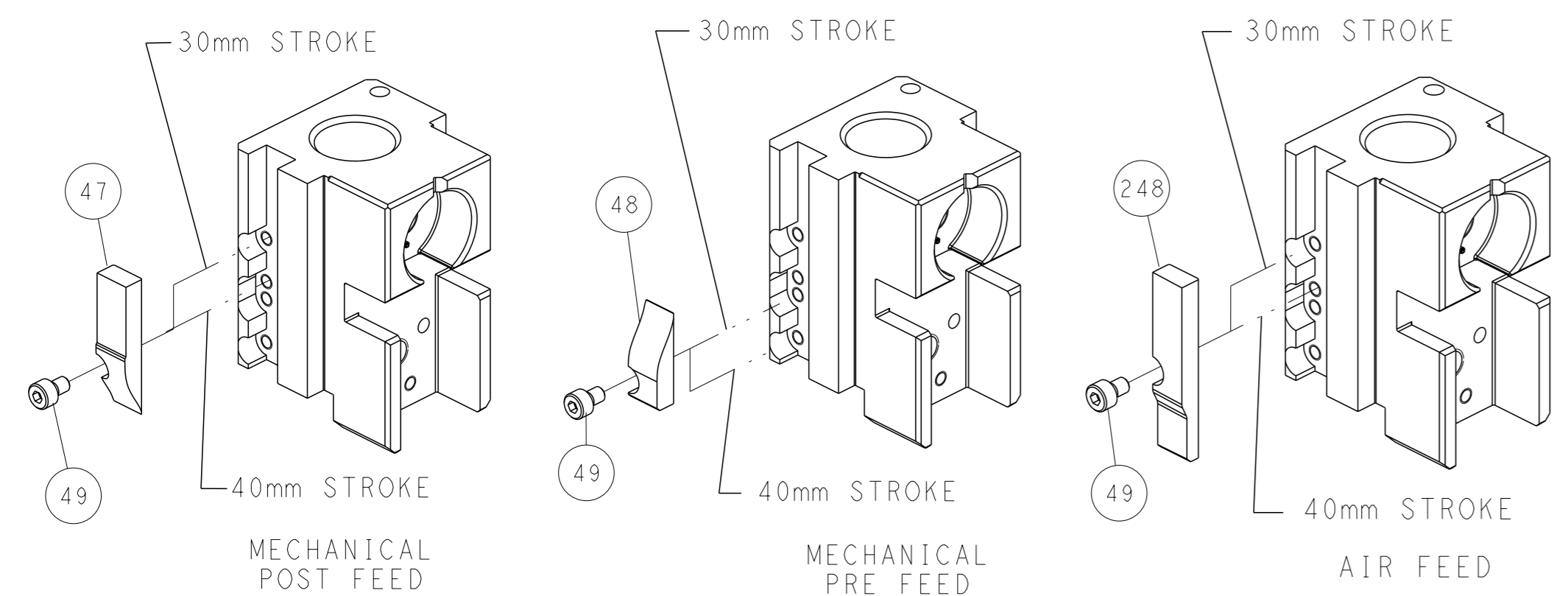


RAM SET-UP



ITEM 30 LOCATED AT REAR HOLES

# CAM POSITIONS

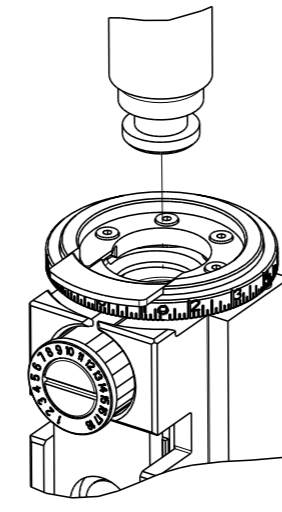


**ATLANTIC VERSION**  
 Shown on sheets 1 of 4 & 2 of 4  
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		OWN: Y. YIN 26OCT2016		TE Connectivity	
mm		0 PLC ±		CHK: G. BAILEY 26OCT2016		Harrisburg, PA 17105-3608	
MATERIAL:		1 PLC ±		APVD: H. ZHANG 26OCT2016		NAME: Ocean Side Feed Applicator	
		2 PLC ±		PRODUCT SPEC		SIZE: CAGE CODE DRAWING NO. RESTRICTED TO	
		3 PLC ±		APPLICATION SPEC		A1 00779 ©=2836453	
		4 PLC ±		WEIGHT		SCALE: 1:2 SHEET 2 OF 4 REV C	
		FINISH		Customer Accessible Production Drawing		SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION	

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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2836453-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2836453-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2836453-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR  
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.50 mm (.059)	F
INSUL	1.80 mm (.071)	O
APPLICATOR INSTRUCTIONS 408-35043		

TERMINAL DATA: LEAR TERMINAL		LEAR CRIMP SPECIFICATION	
TERMINAL NAME: AFK FEMALE TERMINAL			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
3.76-4.52 mm (.148-.178 IN)		Ø1.20-1.30 mm (.047-.051 IN)	
TERMINAL APPLICATION SPECIFICATION	N 103 357 Rev 49		
TERMINALS APPLIED			
TE TERMINAL	LEAR TERMINAL	TE TERMINAL	LEAR TERMINAL
1949189-1	26591.331.185	1949189-2	26591.201.702

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.35mm2	1.02 +/- 0.03 [.040 +/- .001]	10.7



- 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. 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)

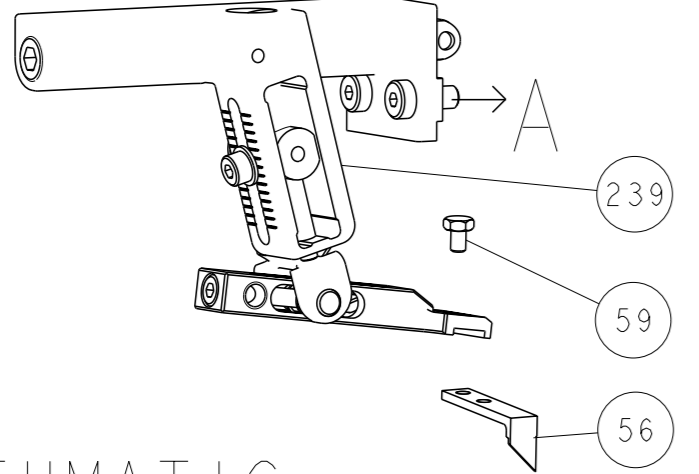
LOC	DIST	REVISIONS			
A	66	REV	DATE	BY	APPV
		-	SEE SHEET 1	-	-

3	-	1	1	2119082-1	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	1-2168083-0	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	1-1752356-8	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	2844992-2	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	2119533-1	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	1803095-6	FLOATING SHEAR, FRONT	9
	1	1	1	6-1803249-1	ANVIL, COMBINATION	8
	-	-	-	-	-	7
	-	-	-	-	-	6
	-	1	1	1-2119757-2	DEPRESSOR, SHEAR	5
	-	1	1	6-238011-0	BLOCK, CRIMPER SPACER	4
	1	1	1	8-1803019-2	CRIMPER, INSULATION O	3
	-	1	1	455888-9	SPACER, CRIMPER	2
	1	1	1	8-1490019-0	CRIMPER, WIRE PREMIUM	1
	-	77	-22	-21	PART NO	ITEM NO

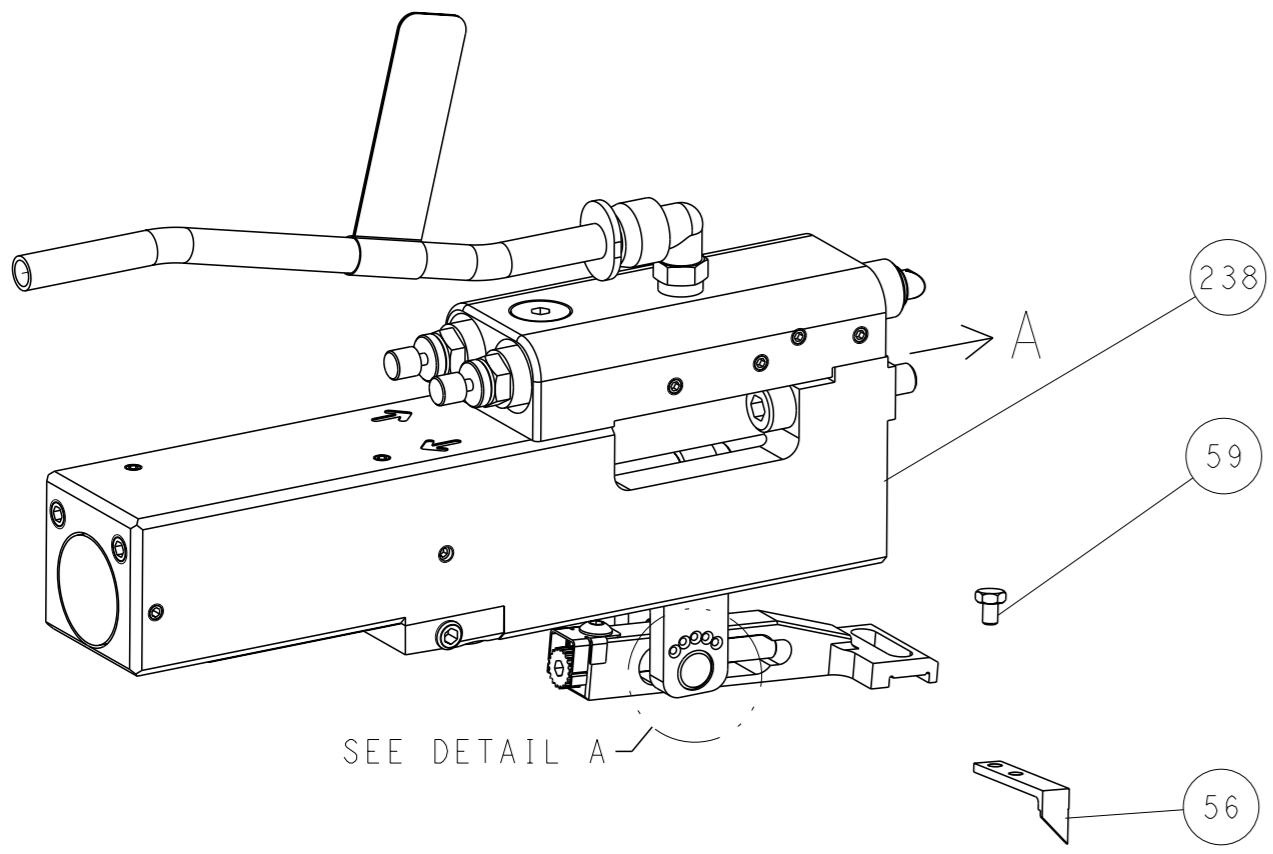
<small>THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE AND THE USER SHALL BE RESPONSIBLE FOR VERIFYING THE DIMENSIONS SHOWN BY CONTACTING THE SUPPLIER FOR THE LATEST REVISION.</small>		DWG Y. YIN 26OCT2016 CHK G. BAILEY 26OCT2016 APVD K. ZHANG 26OCT2016	NAME <b>STE</b> TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm 	TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH ±	APPLICATION SPEC WEIGHT SCALE 1:2 SHEET 3 OF 4 REV C	SIZE CASE CODE DRAWING NO A1 00779 C=2836453 Customer Accessible Production Drawing

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

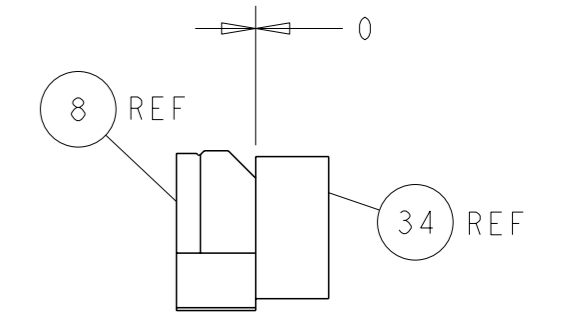
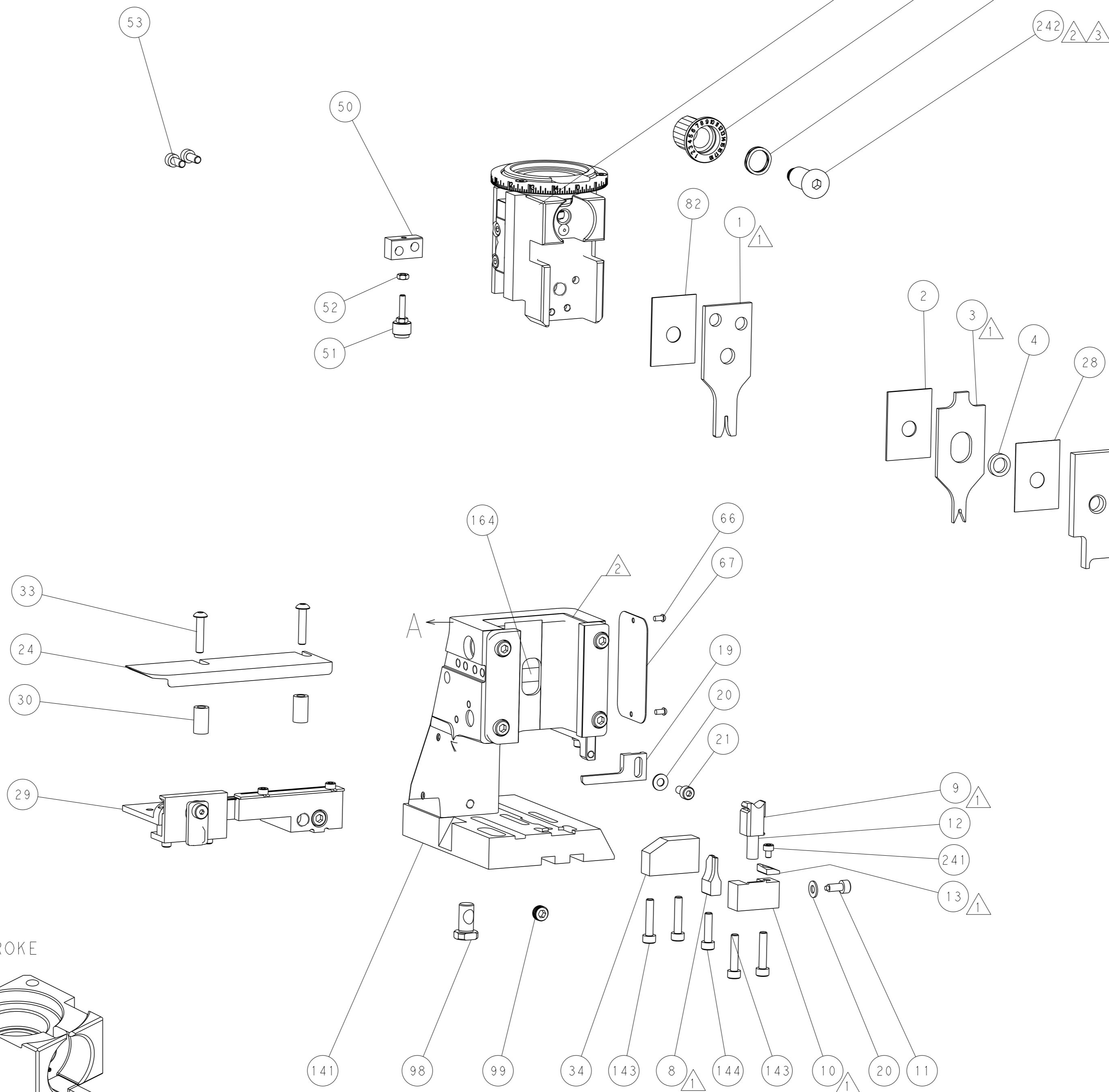
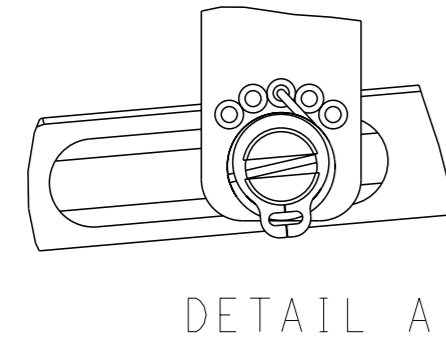
# FEED TYPE MECHANICAL



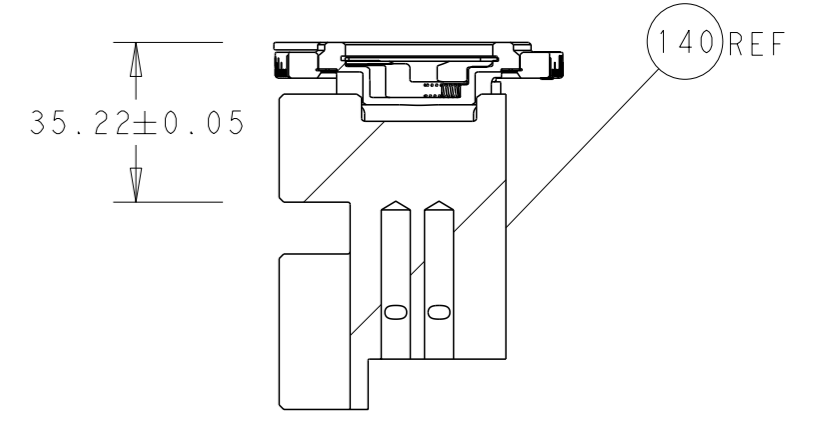
## PNEUMATIC



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

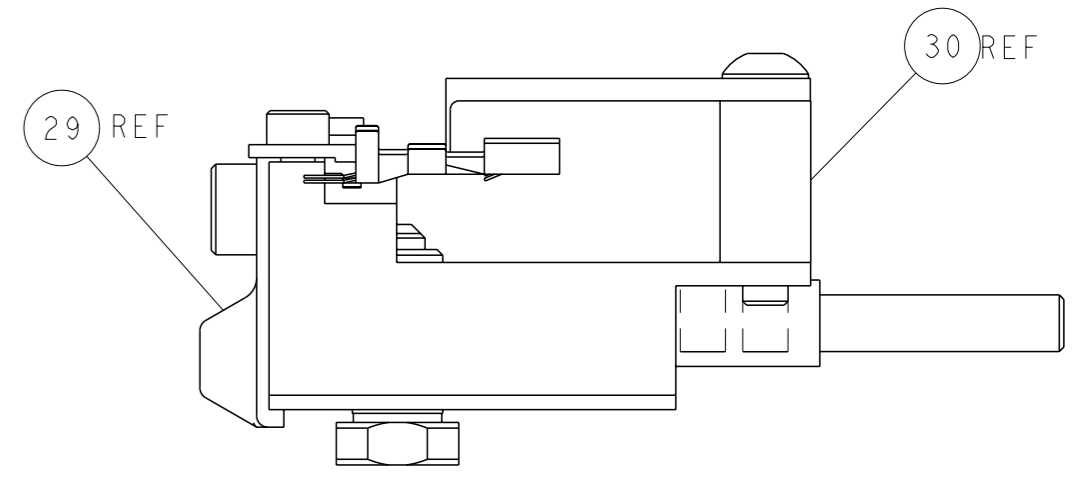


TERMINAL SUPPORT LOCATION



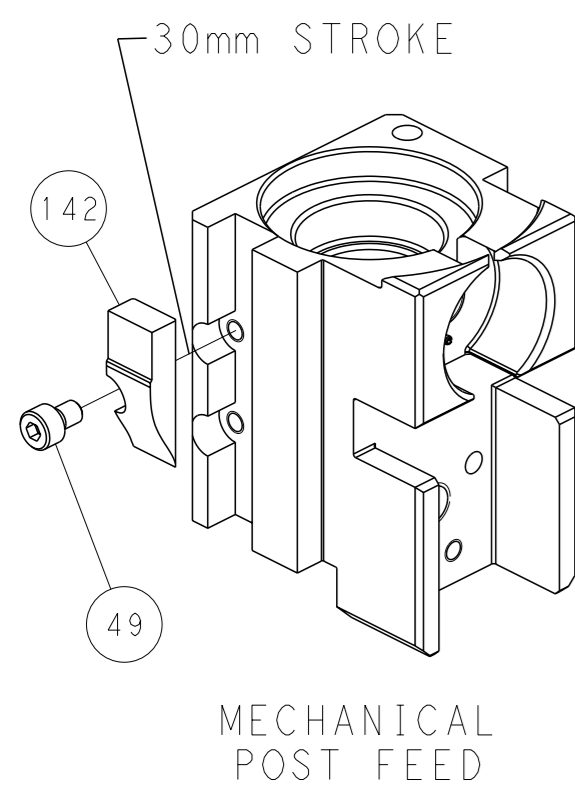
RAM SET-UP

ITEM 30 LOCATED AT REAR HOLES

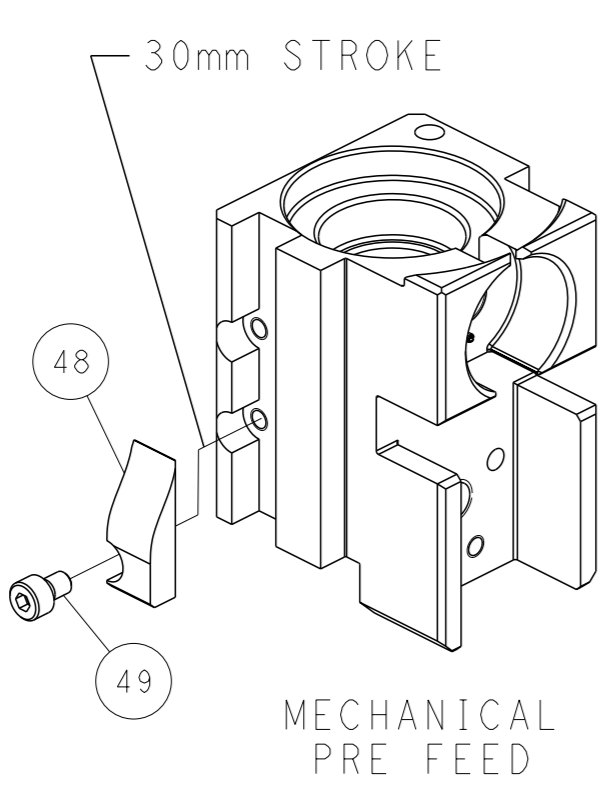


FEED TRACK POSITION GUIDE BY WIRE BARREL

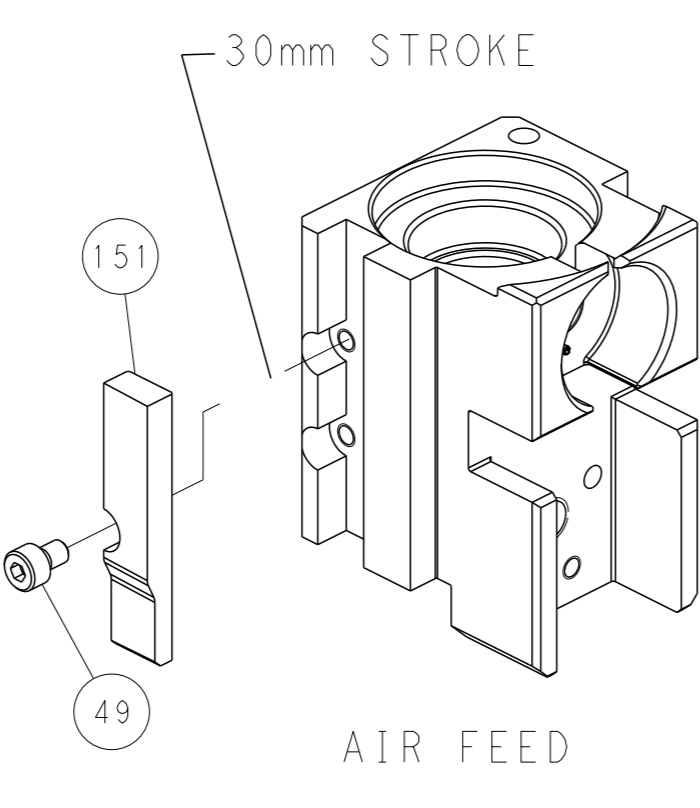
## CAM POSITIONS



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: Y. YIN CHK: G. BAILEY APVD: K. ZHANG	26OCT2016 26OCT2016 26OCT2016	NAME: Ocean Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2836453	RESTRICTED TO: - SCALE: 1:2 SHEET: 4 of 4 REV: C
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH ±	WEIGHT: - MATERIAL: -	CUSTOMER ACCESSIBLE PRODUCTION DRAWING			