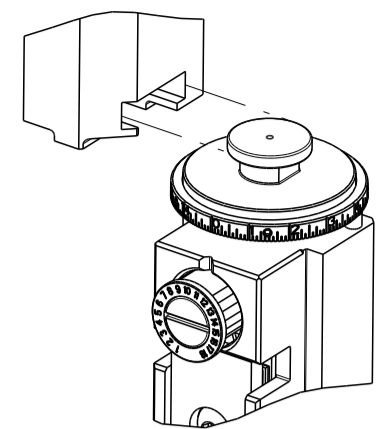


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2836539-2	D	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2836539-2	D	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2836539-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.54 mm [.100]	F
INSUL	6.35 mm [.250]	O

APPLICATOR INSTRUCTIONS
408-35042

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: 4mm SOCKET CONTACT, SWS			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
4.70-5.30 mm [.185-.209 1N]		∅	
TERMINAL APPLICATION SPECIFICATION	114-18118	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE SEAL	TE SEAL
962954-1	962954-2		963244-1
962954-5			
			SEAL INSULATION DIAMETER RANGE
			2.2-3.0

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
2.50mm2	1.94+/-0.05 [.076+/- .002]	6.3
2.00mm2	1.79+/-0.05 [.070+/- .002]	8.0
1.50mm2	1.64+/-0.05 [.065+/- .002]	9.3
1.25mm2	1.56+/-0.05 [.061+/- .002]	10.3

- 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.
- APPLY TORO-SEAL IN ALLEN SOCKET TO FILL HOLE AFTER FLAT HD HAS BEEN ADJUSTED TO CORRECT HEIGHT AT QUALIFICATION.
- 6. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.

***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)

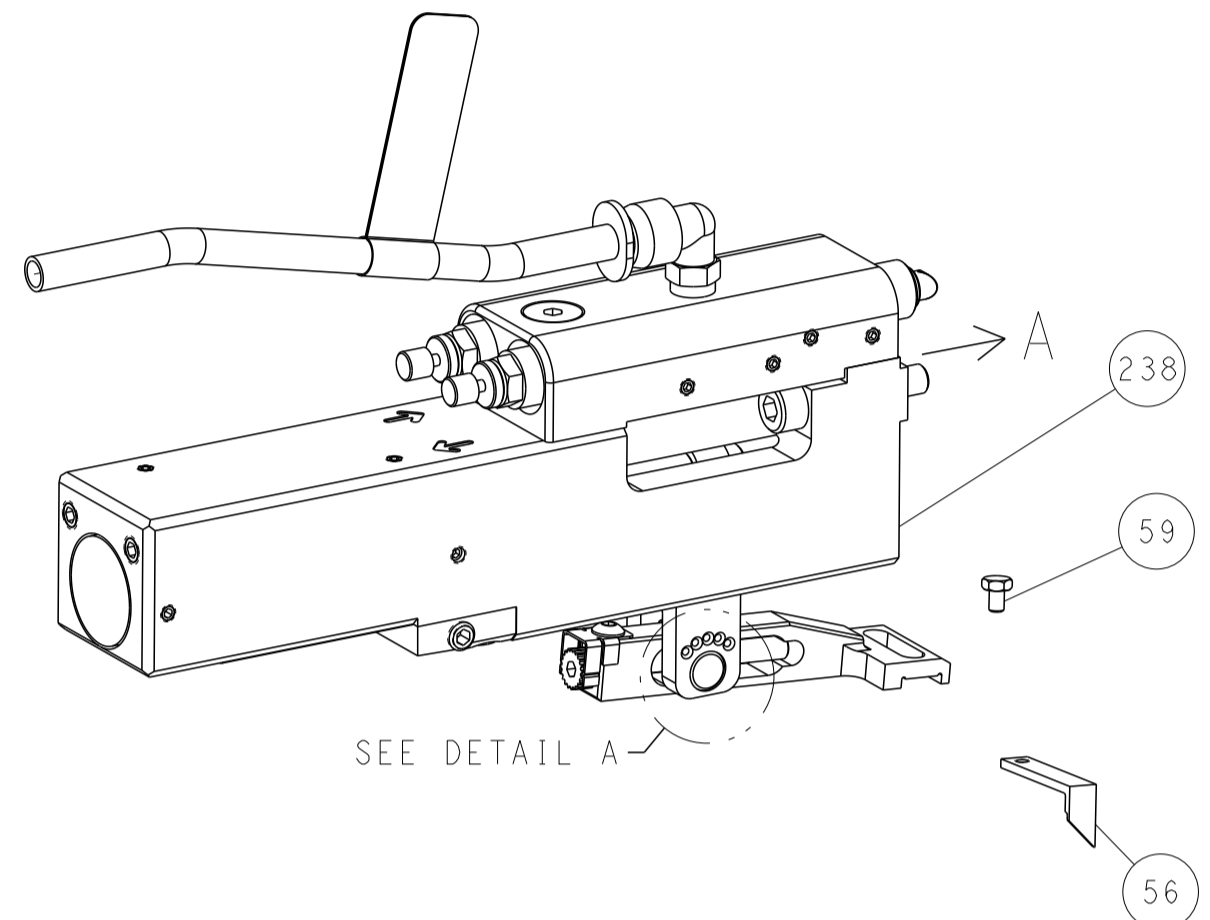
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		B		ECR-17-008638	15JUN2017	TB	CT
		C		ECR-19-001088	22JAN2019	TB	CT
		D		ECR-19-009777	23JUN2019	TB	TE

-	1	1	2119641-1	FEED CAM, AIR FEED	248	
-	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	1	2844940-1	AIR FEED MODULE	238	
-	REF	REF	994970-2	COUNTER, MAGNETIC	164	
-	1	1	2844908-1	SCREW, LOCKING	99	
-	1	1	2844907-1	POST, LOCKING	98	
-	1	1	1-690438-0	FRONT STRIP GUIDE	96	
-	1	1	318563-1	GUARD, FRONT CHIP	89	
-	1	1	455888-5	SPACER, CRIMPER	82	
-	1	1	1803607-3	DOCUMENTATION PACKAGE	71	
-	1	1	2119791-5	DEPRESSOR, WIRE	70	
-	1	1	2119943-1	WASHER, SPACER	69	
-	1	1	2119740-1	TAG IDENTIFICATION	67	
-	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66	
-	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	60	
-	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59	
-	1	1	5018030-1	NUT, HEX, REG, RoHS, M3	58	
-	1	1	1-2168083-3	SCR, SKT HD CAP, RoHS, M3 X 16	57	
-	1	1	1338683-8	FEED PAWL	56	
-	4	4	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	54	
-	2	2	2-2168083-6	SCR, SKT HD CAP, RoHS, M4 X 18	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	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49	
-	1	1	1-1803583-7	APPLICATOR BASIC ASSEMBLY, SF	46	
-	1	1	1803515-1	RAM ASSEMBLY, SF ATLANTIC	44	
-	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41	
-	1	1	1-1752356-3	SUPPORT, TERMINAL	34	
-	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33	
-	2	2	3-2844962-2	SPACER, CYLINDRICAL, STRIP GUIDE	30	
-	1	1	2844992-6	ASSEMBLY, STRIP GUIDE	29	
-	1	1	1-455888-0	SPACER, CRIMPER	28	
-	2	2	22283-1	SPRING, COMPRESSION	27	
-	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	
-	1	1	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	4-22280-7	SPRING, COMPRESSION	12	
-	1	1	1-356885-4	STOP, SHEAR	11	
-	1	1	2119805-7	SHEAR HOLDER, FRONT	10	
-	1	1	318059-9	FLOATING SHEAR, FRONT	9	
-	1	2	1	4-1333206-8	ANVIL, COMBINATION .100	8
-	1	1	2-240641-2	SPACER	7	
-	-	-	-	-	6	
-	1	1	1803080-1	DEPRESSOR, SHEAR	5	
-	1	1	6-238011-9	BLOCK, CRIMPER SPACER	4	
-	1	2	1	3-1633965-8	CRIMPER, INSULATION O PREMIUM	3
-	1	1	1-455888-2	SPACER, CRIMPER	2	
-	1	2	1	456407-5	CRIMPER, WIRE PREMIUM	1

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		MATERIAL:		FINISH:		WEIGHT:		SCALE:		SHEET:		REV:	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES	FINISH			Customer Accessible Production Drawing	1:2	1	of 4	D	

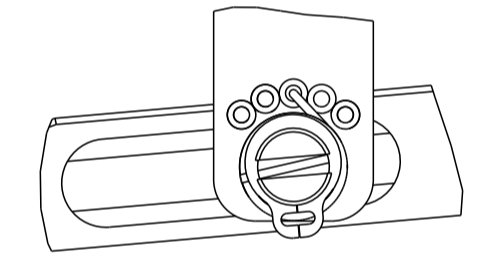
LOC	DIST	REVISIONS					
		P	LTN	DESCRIPTION	DATE	DMN	APVD
A	66	-	-	SEE SHEET 1	-	-	-

FEED TYPE PNEUMATIC



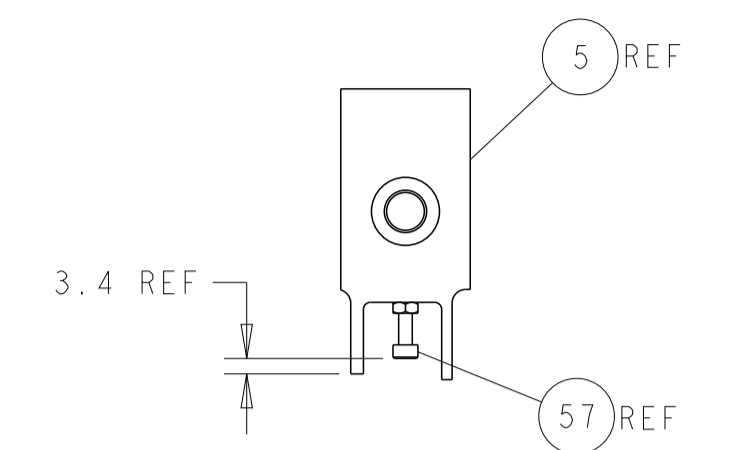
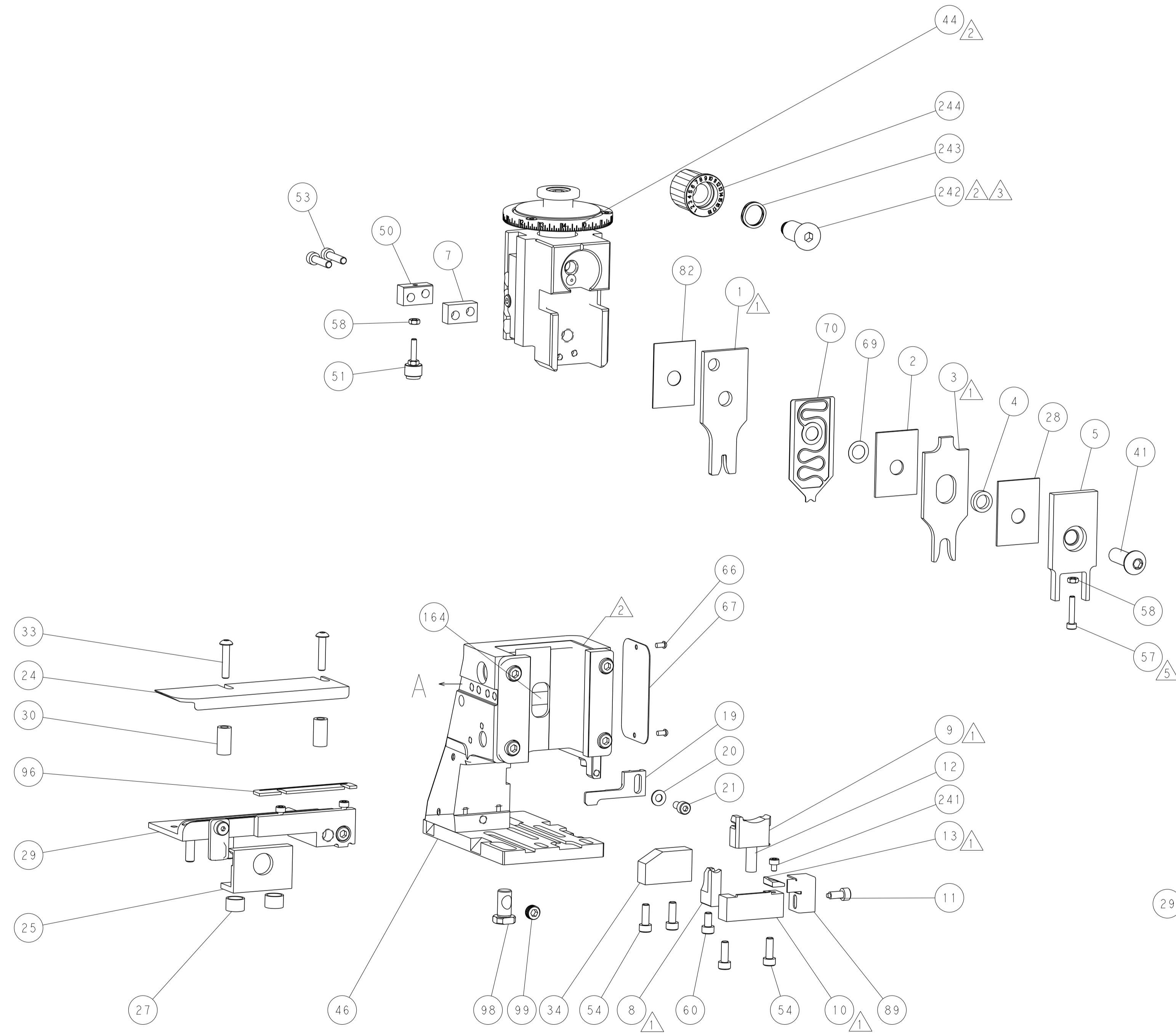
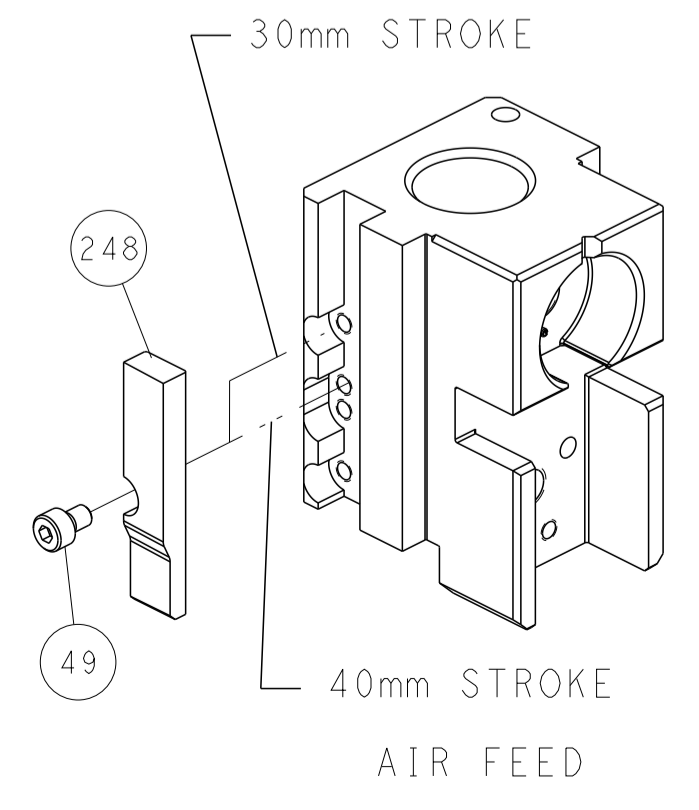
SEE DETAIL A

FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)

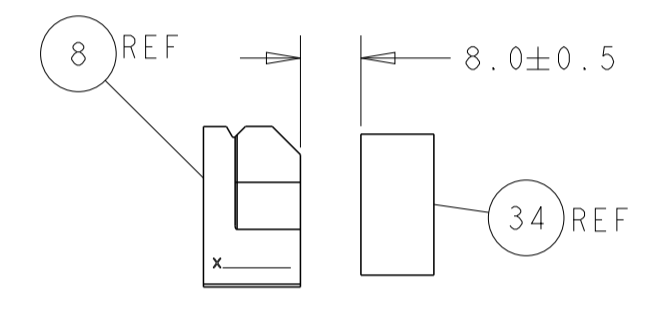


DETAIL A

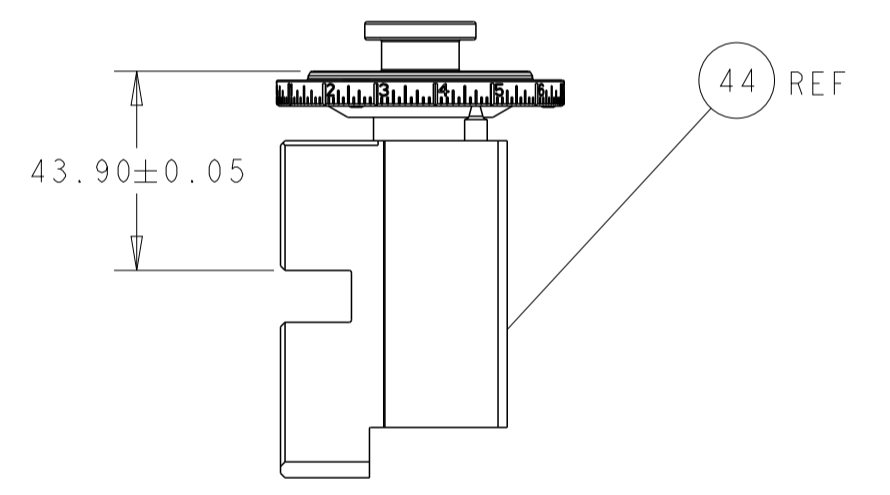
CAM POSITION



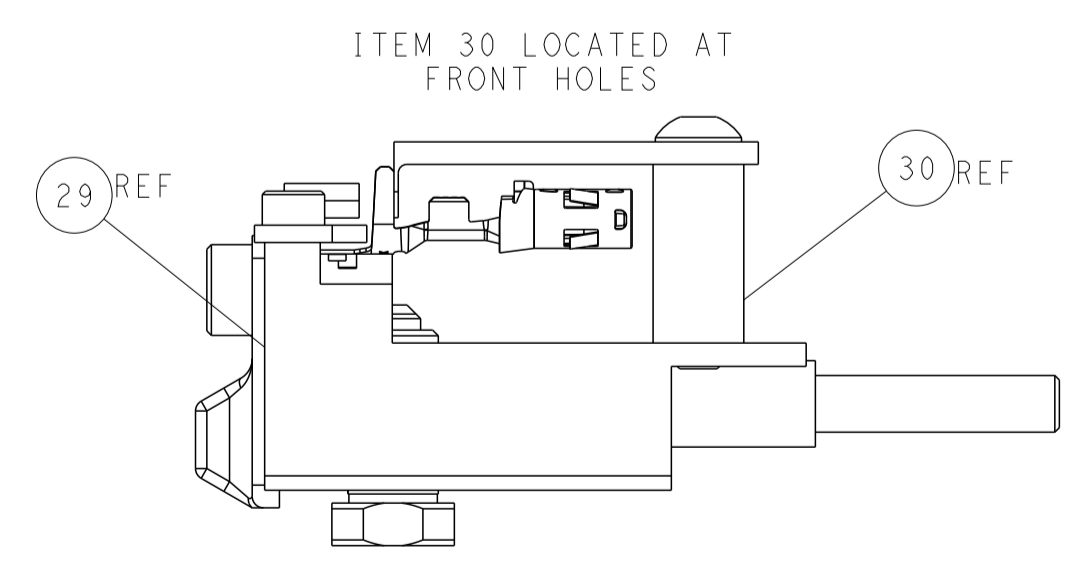
SHEAR DEPRESSOR DETAIL



TERMINAL SUPPORT LOCATION



RAM SET-UP



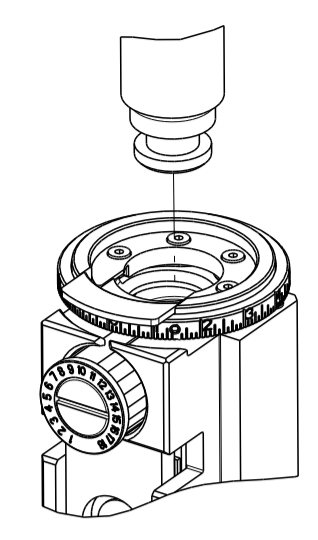
FEED TRACK POSITION
GUIDE BY INSULATION BARREL

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:		DMN	M. HERR	10NOV2016	TE Connectivity Harrisburg, PA 17105-3608
mm	0 PLC ±	1 PLC ±	2 PLC ±	CHK	T. ELBIN	10NOV2016	
	3 PLC ±	4 PLC ±	ANGLES ±	APVD	T. ELBIN	10NOV2016	NAME
MATERIAL	FINISH	WEIGHT	SCALE	Customer Accessible Production Drawing		SIZE	CAGE CODE
			1:2			A1	00779
		SHEET 2 OF 4		DRAWING NO		REV D	
		SCALE		C=2836539		RESTRICTED TO	

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2836539-2	D	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2836539-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
 INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.54 mm [.100]	F
INSUL	6.35 mm [.250]	O

APPLICATOR INSTRUCTIONS
 408-35042

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: 4mm SOCKET CONTACT, SWS			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
4.70-5.30 mm [1.85-.209 IN]		Ø	
TERMINAL APPLICATION SPECIFICATION		114-18118	
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE SEAL	TE SEAL
962954-1	962954-2		963244-1
962954-5			
			SEAL INSULATION DIAMETER RANGE
			2.2-3.0

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
2.50mm2	1.94 +/- 0.05 [0.076 +/- .002]	6.3
2.00mm2	1.79 +/- 0.05 [0.070 +/- .002]	8.0
1.50mm2	1.64 +/- 0.05 [0.065 +/- .002]	9.3
1.25mm2	1.56 +/- 0.05 [0.061 +/- .002]	10.3

- 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.
- APPLY TORQ-SEAL IN ALLEN SOCKET TO FILL HOLE AFTER FLAT HD HAS BEEN ADJUSTED TO CORRECT HEIGHT AT QUALIFICATION.
- UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.

***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	
		-		SEE SHEET 1				

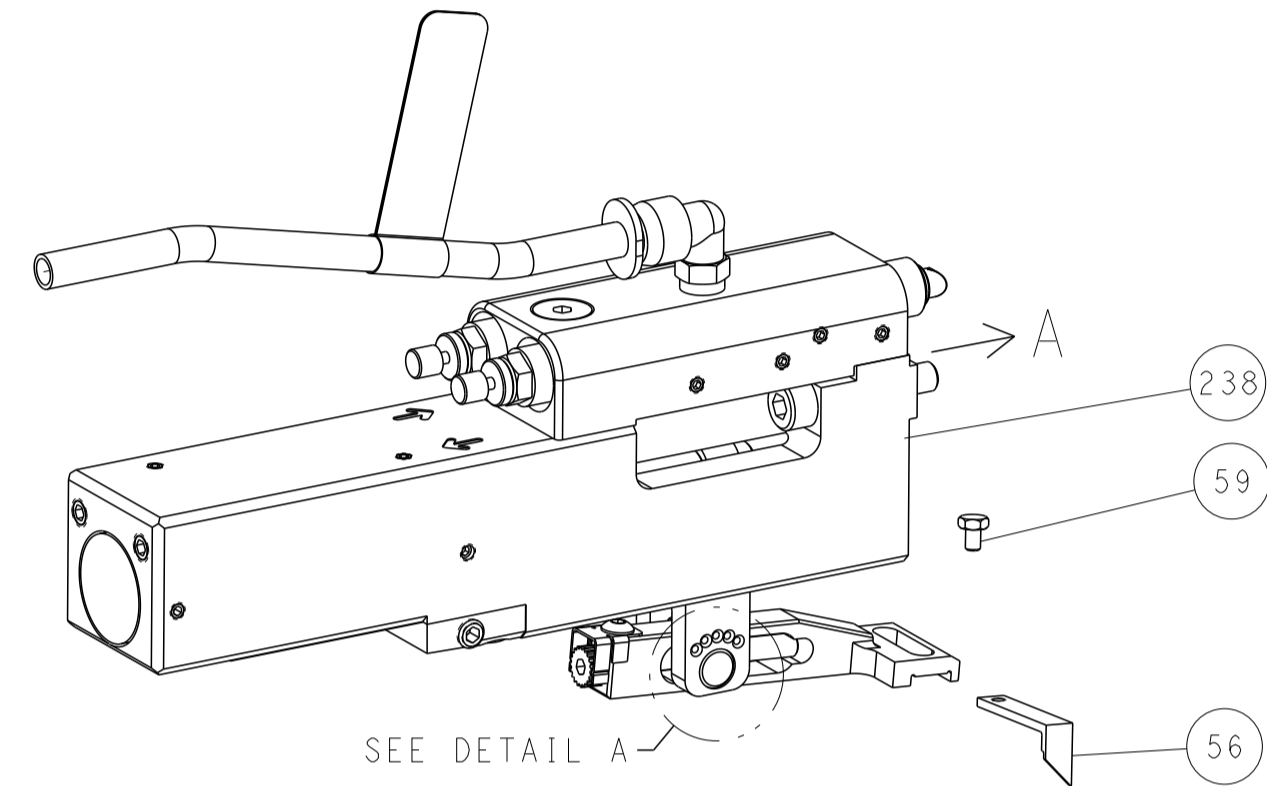
-	1	2119082-5	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
-	1	2844940-1	AIR FEED MODULE	238
-	REF	994970-2	COUNTER, MAGNETIC	164
-	1	2119641-2	FEED CAM, AIR FEED	151
-	1	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	144
-	4	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	143
-	1	1-1803583-8	APPLICATOR BASIC ASSEMBLY, SF	141
-	1	1803516-1	RAM ASSEMBLY, SF PACIFIC	140
-	1	2844908-1	SCREW, LOCKING	99
-	1	2844907-1	POST, LOCKING	98
-	1	1-690438-0	FRONT STRIP GUIDE	96
-	1	318563-1	GUARD, FRONT CHIP	89
-	1	455888-5	SPACER, CRIMPER	82
-	1	1803607-3	DOCUMENTATION PACKAGE	71
-	1	2119791-5	DEPRESSOR, WIRE	70
-	1	2119943-1	WASHER, SPACER	69
-	1	2119740-1	TAG, IDENTIFICATION	67
-	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	1	5018030-1	NUT, HEX, REG, RoHS, M3	58
-	1	1-2168083-3	SCR, SKT HD CAP, RoHS, M3 X 16	57
-	1	1338683-8	FEED PAWL	56
-	2	2-2168083-6	SCR, SKT HD CAP, RoHS, M4 X 18	53
-	1	5018030-1	NUT, HEX, REG, RoHS, M3	52
-	1	811242-5	BUMPER, HOLD DOWN	51
-	1	690753-2	SPACER, TONKER	50
-	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
-	1	1-1752356-3	SUPPORT, TERMINAL	34
-	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	3-2844962-2	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	2844992-6	ASSEMBLY, STRIP GUIDE	29
-	1	1-455888-0	SPACER, CRIMPER	28
-	2	22283-1	SPRING, COMPRESSION	27
-	1	240792-1	DRAG, TERMINAL	25
-	1	1320928-2	STRIP GUIDE	24
-	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
-	1	1-18028-2	WASHER, FLAT, REG M4	20
-	1	2119533-1	STRIPPER, SIDE FEED	19
-	1	2119806-1	INSERT, SHEAR	13
-	1	4-22280-7	SPRING, COMPRESSION	12
-	1	1-356885-4	STOP, SHEAR	11
-	1	2119805-7	SHEAR HOLDER, FRONT	10
-	1	318059-9	FLOATING SHEAR, FRONT	9
-	1	4-1333206-8	ANVIL, COMBINATION .100	8
-	1	2-240641-2	SPACER	7
-	-	-	-	6
-	1	1803080-1	DEPRESSOR, SHEAR	5
-	1	6-238011-9	BLOCK, CRIMPER SPACER	4
-	1	3-1633965-8	CRIMPER, INSULATION O PREMIUM	3
-	1	1-455888-2	SPACER, CRIMPER	2
-	1	456407-5	CRIMPER, WIRE PREMIUM	1
-	77	-22	PART NO	
-			DESCRIPTION	ITEM NO

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

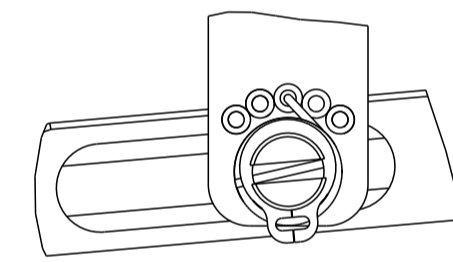
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mm		0 PLC ±		CHK		10NOV2016		Harrisburg, PA 17105-3608	
Ø		1 PLC ±		T. ELBIN		10NOV2016		NAME	
±		2 PLC ±		APVD		10NOV2016		Ocean Side Feed	
±		3 PLC ±		PRODUCT SPEC				Applicator	
±		4 PLC ±		APPLICATION SPEC				SIZE	
±		5 PLC ±		MATERIAL				CAGE CODE	
±		ANGLES		FINISH				DRAWING NO	
±								RESTRICTED TO	
±								WEIGHT	
±								SCALE	
±								SHEET	
±								OF	
±								REV	
±								D	
±								Customer Accessible Production Drawing	
±								SCALE	
±								1:2	
±								3	
±								4	
±								REV	
±								D	

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

FEED TYPE PNEUMATIC

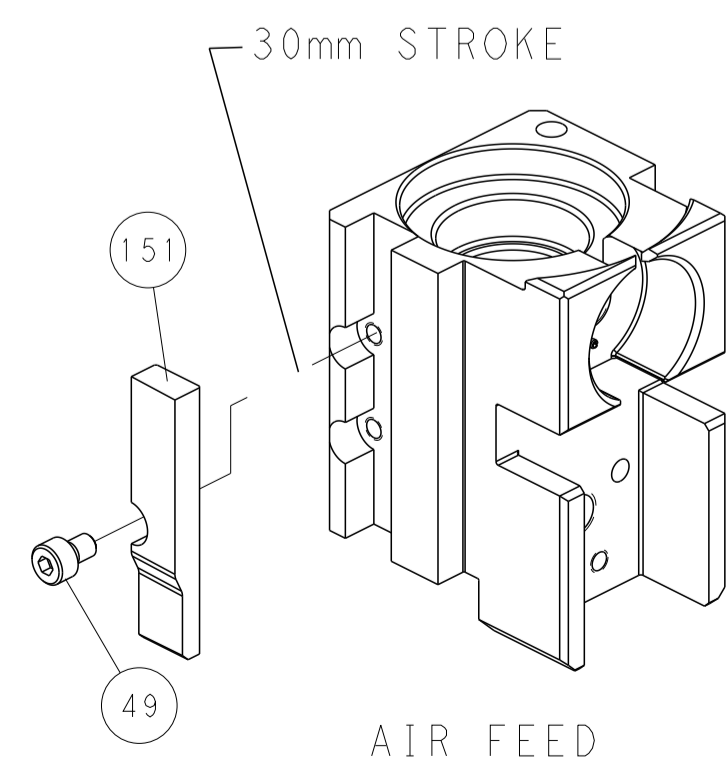


FEED SPRING SETTING POSITION
(SHOWN FROM REAR SIDE)

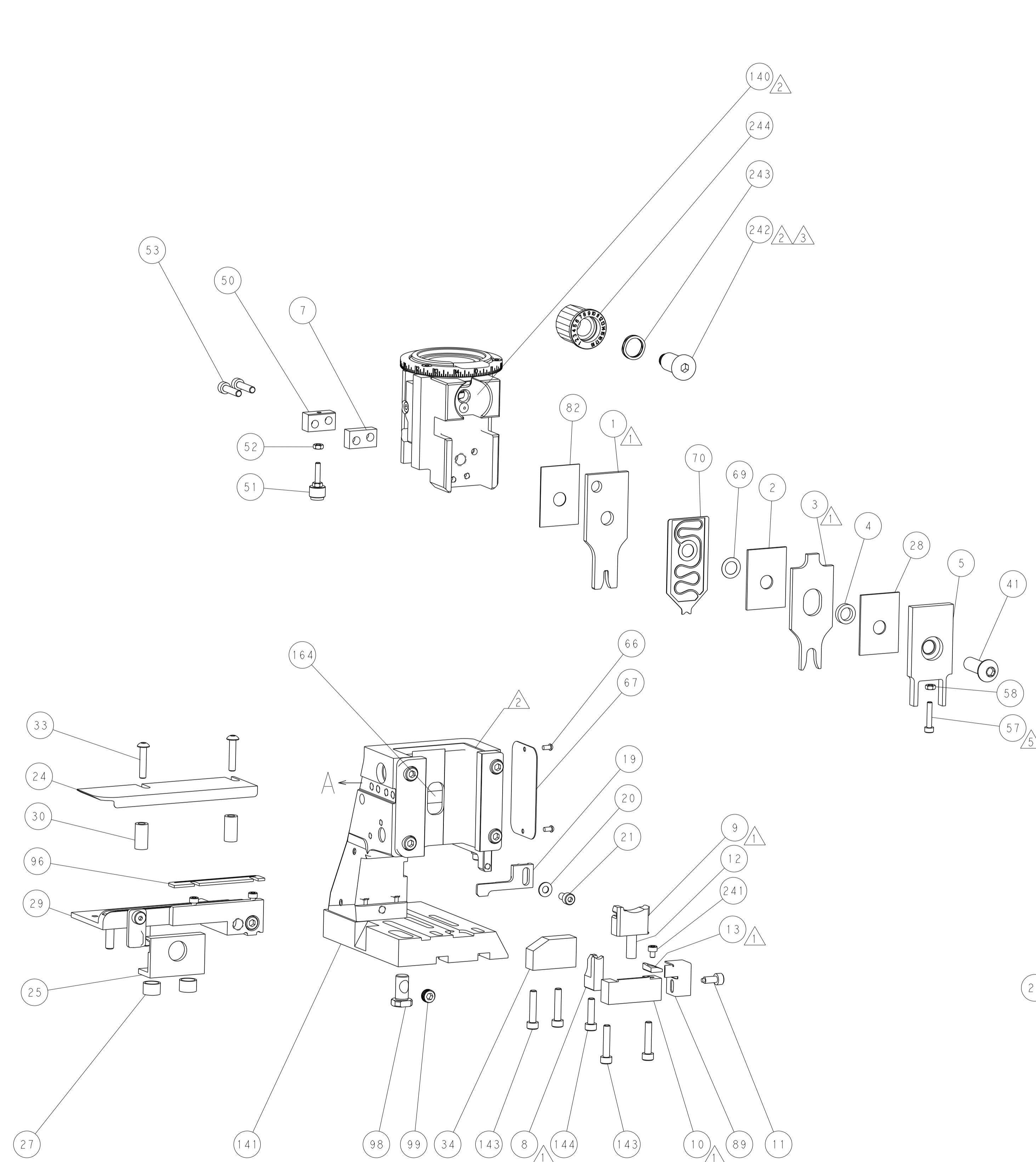


DETAIL A

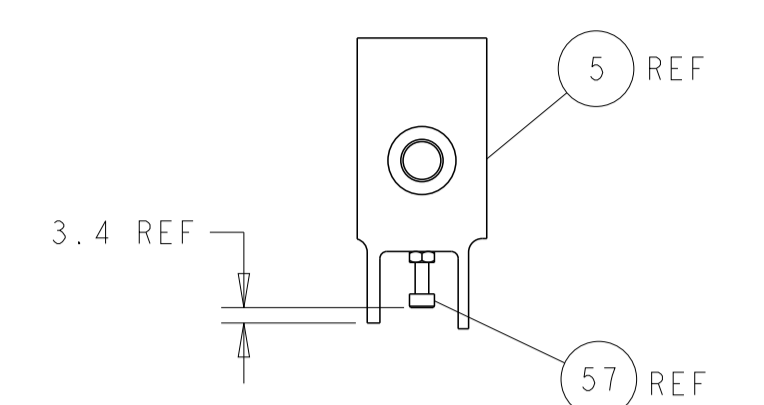
CAM POSITION



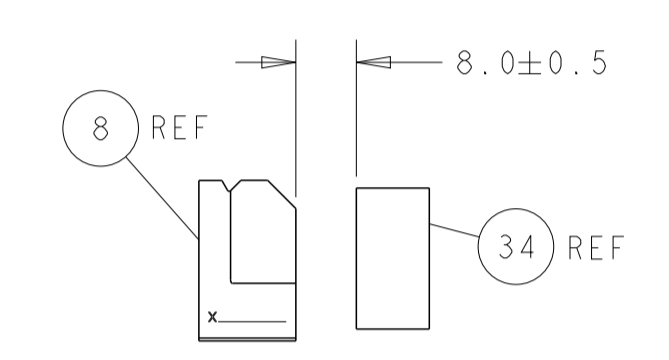
AIR FEED



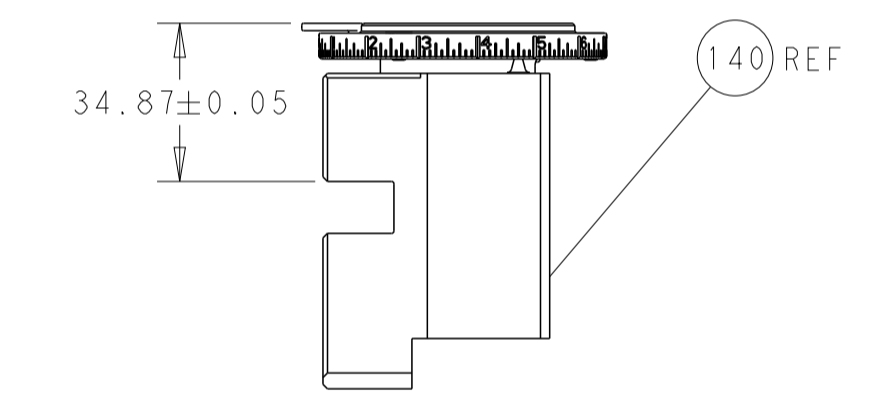
PACIFIC VERSION
 Shown on sheets 3 of 4 & 4 of 4
 (Atlantic version shown on sheets 1 of 4 & 2 of 4)



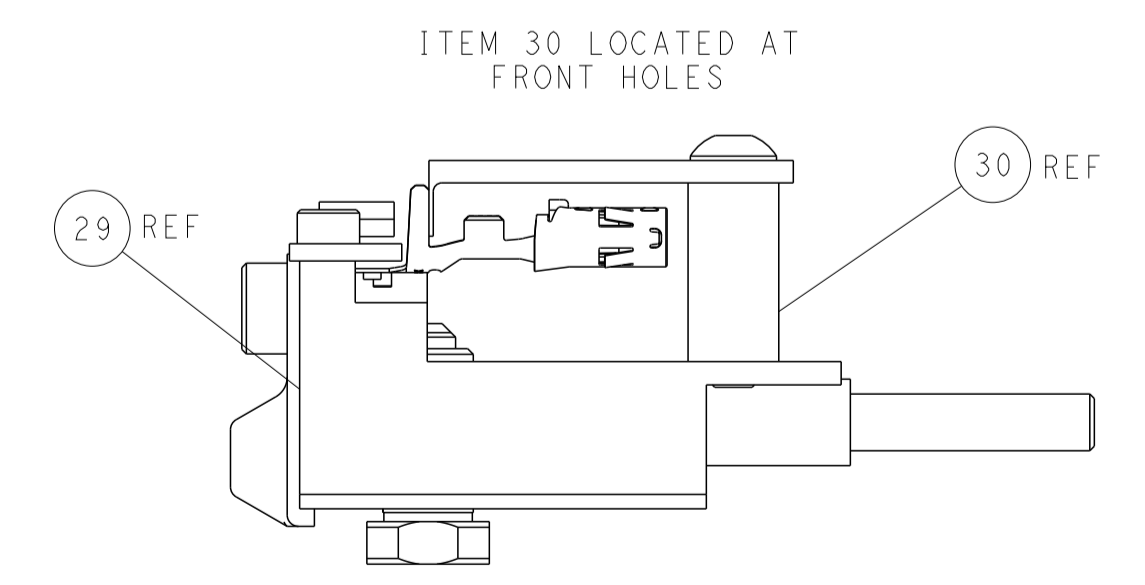
SHEAR DEPRESSOR DETAIL



TERMINAL SUPPORT LOCATION



RAM SET-UP



FEED TRACK POSITION
GUIDE BY INSULATION BARREL

<small>THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION 2016. COPYRIGHT 2016 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.</small>		OWN: M. HERR 10NOV2016 CHK: T. ELBIN 10NOV2016 APVD: T. ELBIN 10NOV2016	TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± MATERIAL: - FINISH: -		NAME: Ocean Side Feed Applicator APPLICATION SPEC: - SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2836539 SCALE: 1:2 SHEET: 4 OF 4 REV: D	RESTRICTED TO: -