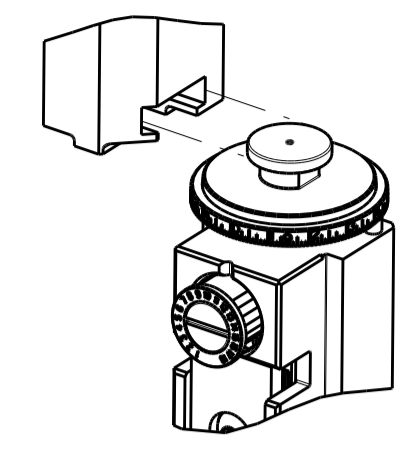


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2836551-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2836551-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2836551-1	B	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2836551-2	C	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2836551-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.63 mm [.064]	F
INSUL	3.65 mm [.144]	O

APPLICATOR INSTRUCTIONS
408-35042

TERMINAL DATA: KOSTAL TERMINAL KOSTAL CRIMP SPECIFICATION	
TERMINAL NAME: SLK 2.8 STECKER	
WIRE STRIP LENGTH 4.00-4.60 mm [.157-.181 IN]	INSULATION DIAMETER RANGE Ø1.10-1.60 mm [.043-.063 IN]
TERMINAL APPLICATION SPECIFICATION (A) Attachment 1 DOC 00074173 Rev 06	

TERMINALS APPLIED				
TE TERMINAL	KOSTAL TERMINAL	TE SEAL	KOSTAL SEAL	CABLE DIAMETER
(A) 1572280-1	(A) 1 01 24 49913 0	(A) 2209984-1	(A) 1 08 00 44452 2	1.1 - 2.1mm
(A) 1572280-2	(A) 1 01 40 49913 0	(A) 957402-1	(A) 1 08 00 44452 2	1.1 - 2.1mm
(A) 1572280-3	(A) 1 01 25 49913 0	(A) 2113422-1	(A) 10030680	
(A) 1572791-1	(A) 2 21 24 49205 0			
(A) 1572791-2	(A) 2 21 40 49205 0			
(A) 1572791-3	(A) 2 21 25 49205 0			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.50mm2	1.00 +/- 0.03 [.039 +/- .001]	8.2
0.35mm2	0.99 +/- 0.03 [.039 +/- .001]	8.4
0.22mm2	0.97 +/- 0.03 [.038 +/- .001]	8.6

- 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 TERMINAL LUBRICANT IS RECOMMENDED.
- 6. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- 7 APPLY TORO-SEAL IN ALLEN SOCKET TO FILL HOLE AFTER FLAT HD HAS BEEN ADJUSTED TO CORRECT HEIGHT AT QUALIFICATION. APPLY #1-23419-5 LOC-TITE TO THREADS.

TERMINAL DATA: KOSTAL TERMINAL KOSTAL CRIMP SPECIFICATION	
TERMINAL NAME: SLK 2.8 STECKER	
WIRE STRIP LENGTH 4.00-4.60 mm [.157-.181 IN]	INSULATION DIAMETER RANGE Ø1.10-1.60 mm [.043-.063 IN]
TERMINAL APPLICATION SPECIFICATION (B) Attachment 3 DOC 00074173 Rev 06	

TERMINALS APPLIED				
TE TERMINAL	KOSTAL TERMINAL	TE SEAL	KOSTAL SEAL	CABLE DIAMETER
(B) 1572280-1	(B) 1 01 24 49913 0	(B) 2209984-1	(B) 1 08 00 44452 2	1.1 - 2.1mm
(B) 1572280-2	(B) 1 01 40 49913 0	(B) 957402-1	(B) 1 08 00 44452 2	1.1 - 2.1mm
(B) 1572280-3	(B) 1 01 25 49913 0	(B) 2113422-1	(B) 10030680	
(B) 1572791-1	(B) 2 21 24 49205 0			
(B) 1572791-2	(B) 2 21 40 49205 0			
(B) 1572791-3	(B) 2 21 25 49205 0			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
22 AWG	1.03 +/- 0.03 [.041 +/- .001]	7.8
24 AWG	1.01 +/- 0.03 [.040 +/- .001]	8.1

***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	APPV
		1	05JAN2017	KH	LZ
		A	07FEB2017	TB	TE
		B	05SEP2018	TB	TE
		C	25NOV2020	FZ	TE

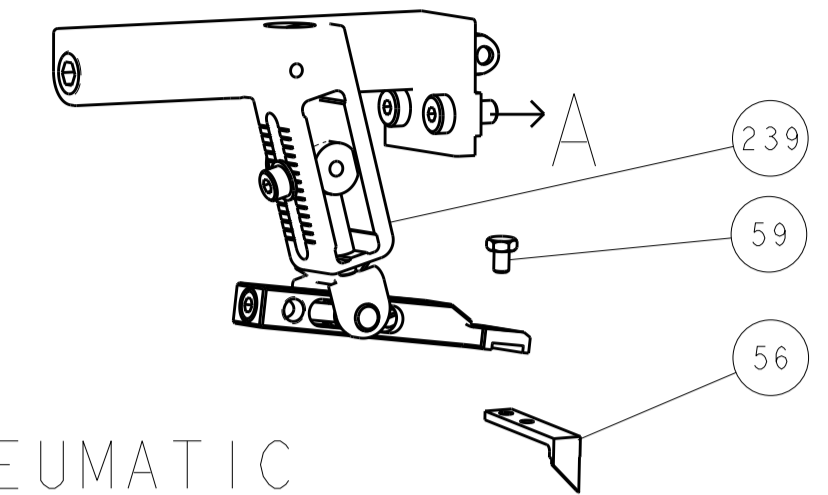
-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248	
-	1	1	1	1	2119082-2	CAM, SNAIL, INSULATION ADJUSTMENT	244	
-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243	
3	-	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242	
-	1	1	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241	
-	-	1	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239	
-	1	-	1	-	2844940-1	AIR FEED MODULE	238	
-	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164	
5	-	1	1	1	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	2119791-9	DEPRESSOR, WIRE	70	
-	1	1	1	1	2119943-1	WASHER, SPACER	69	
-	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	
7	-	1	1	1	985575-3	SCR, FLT SKT HD CAP M3 X 10.0	57	
-	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	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	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	1752356-1	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	2844992-4	ASSEMBLY, STRIP GUIDE	29	
-	1	1	1	1	455888-5	SPACER, CRIMPER	28	
-	1	1	1	1	240792-1	DRAG, TERMINAL	25	
-	1	1	1	1	1320928-6	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	318707-1	FLOATING SHEAR, FRONT	9	
1	1	2	2	1	1	7-1803249-0	ANVIL, COMBINATION	8
-	1	1	1	1	2-240641-0	SPACER	7	
-	-	-	-	-	-	-	6	
-	1	1	1	1	2119781-2	DEPRESSOR, SHEAR	5	
-	1	1	1	1	238011-4	BLOCK, CRIMPER SPACER	4	
1	1	2	2	1	1	2-1803317-7	CRIMPER, INSULATION O	3
-	1	1	1	1	455888-8	SPACER, CRIMPER	2	
1	1	2	2	1	1	3-1803224-3	CRIMPER, WIRE	1

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DATE	BY	APPV
mm	0 PLC ±	1 PLC ±	2 PLC ±	05JAN2017	H. HUANG	
	3 PLC ±	4 PLC ±	ANGLES ±	05JAN2017	L. ZHANG	
					L. ZHANG	
MATERIAL	FINISH	WEIGHT				

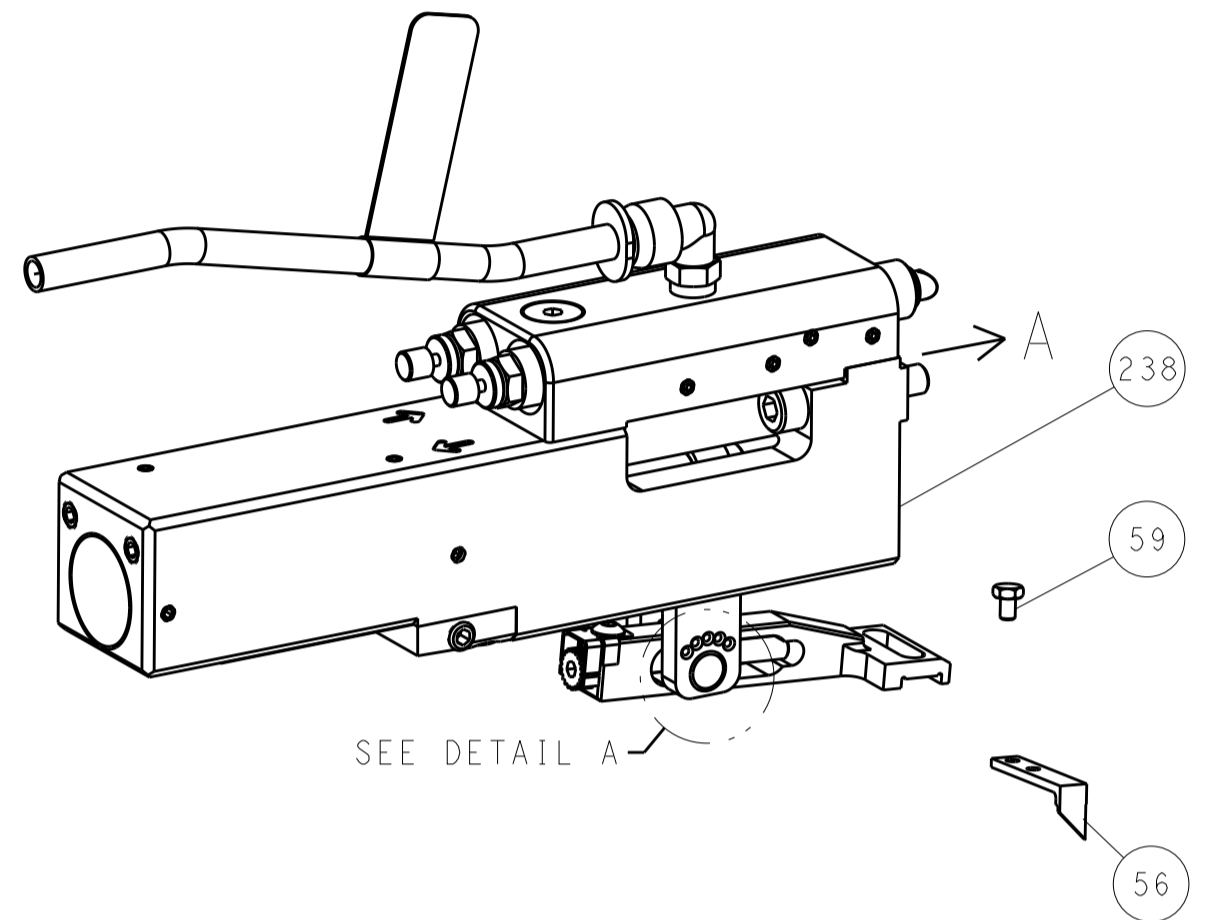
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ADDRESS	Harrisburg, PA 17105-3608
PRODUCT SPEC	
APPLICATION SPEC	
SIZE	A1
CAGE CODE	00779
DRAWING NO	2836551
RESTRICTED TO	
Customer Accessible Production Drawing	SCALE 1:2 SHEET 1 OF 4 REV C

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

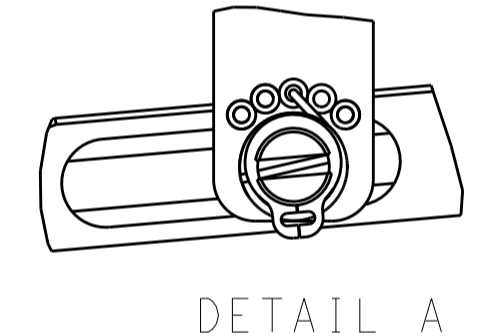
FEED TYPE MECHANICAL



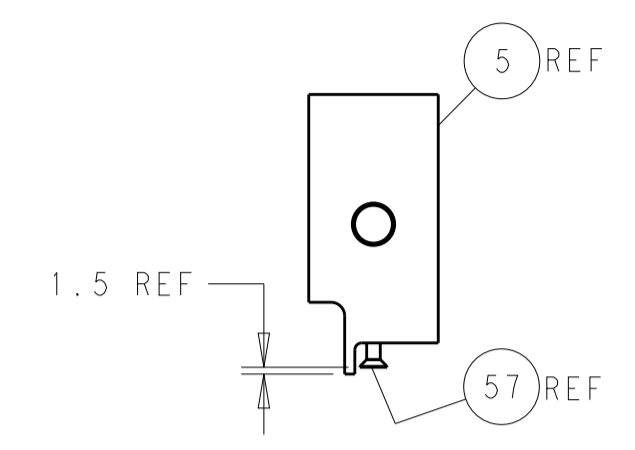
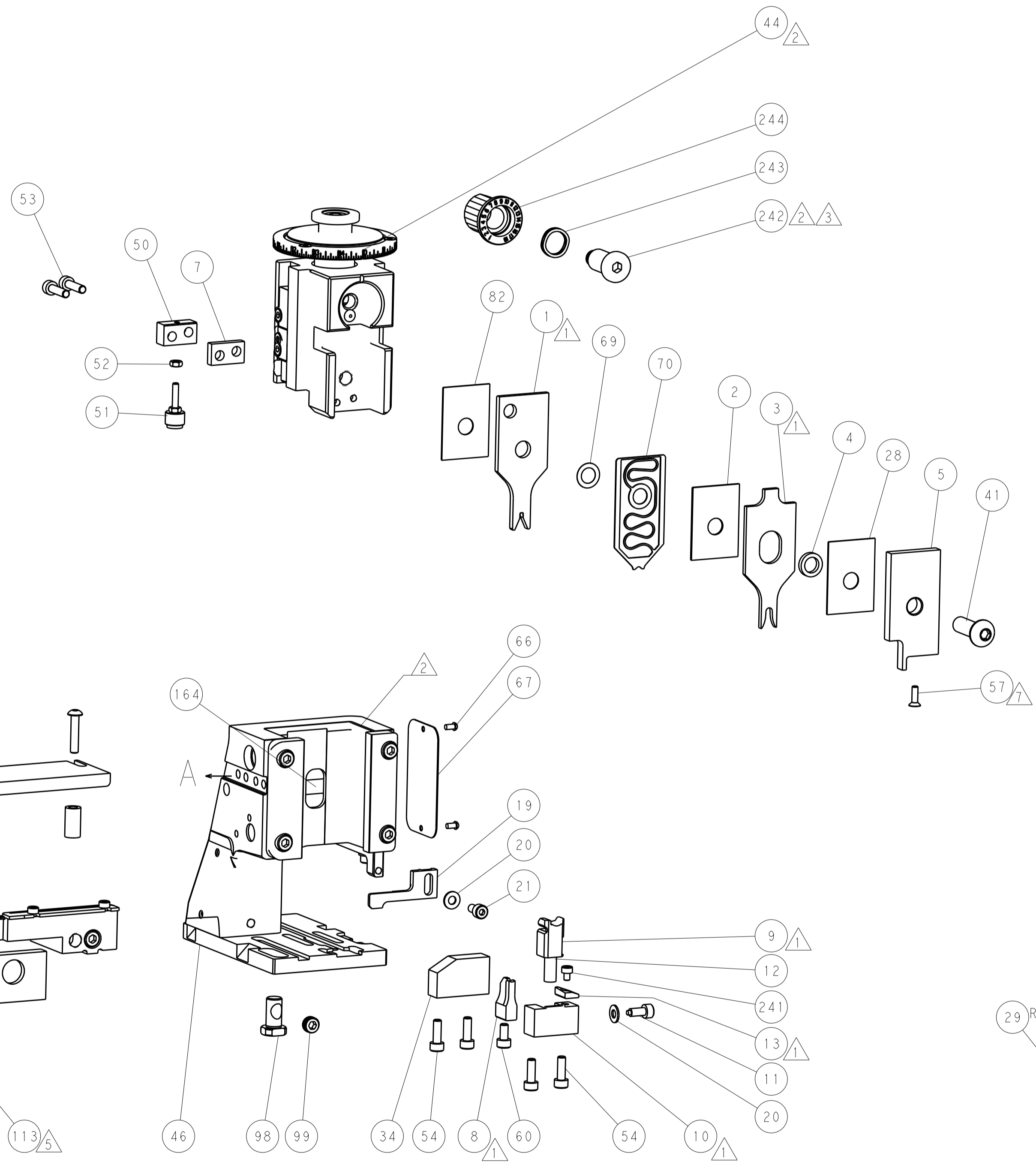
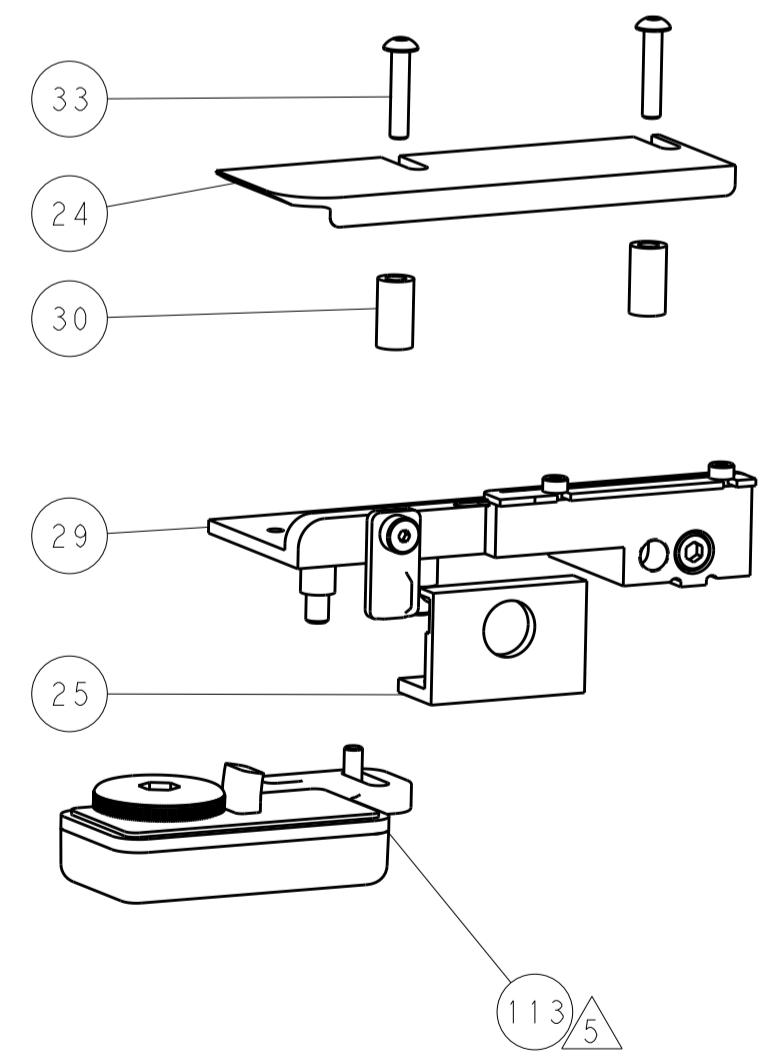
PNEUMATIC



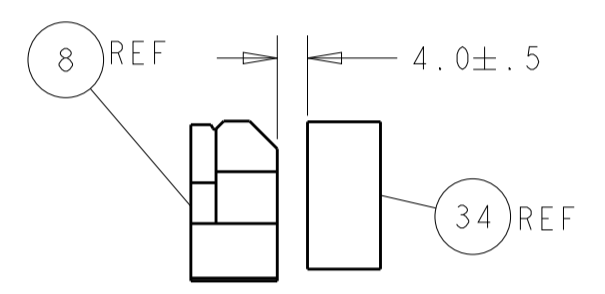
FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



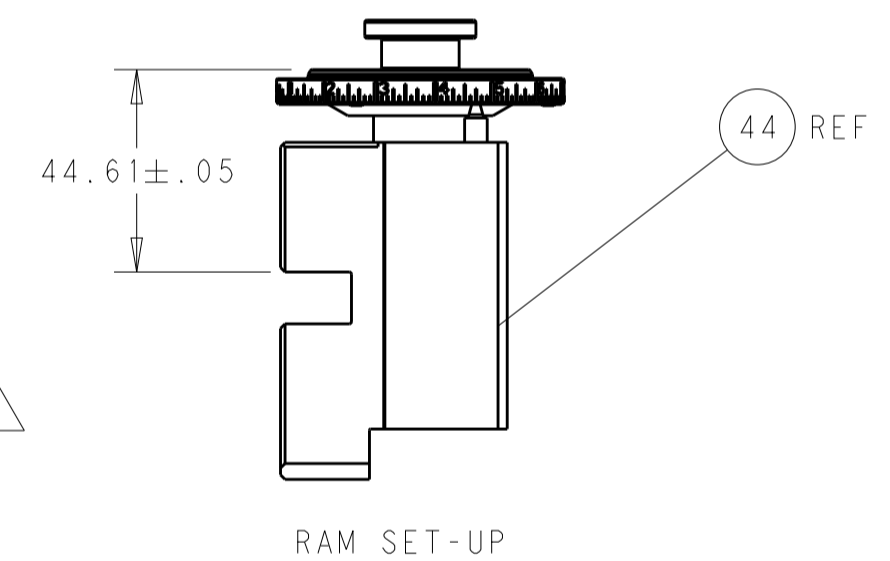
DETAIL A



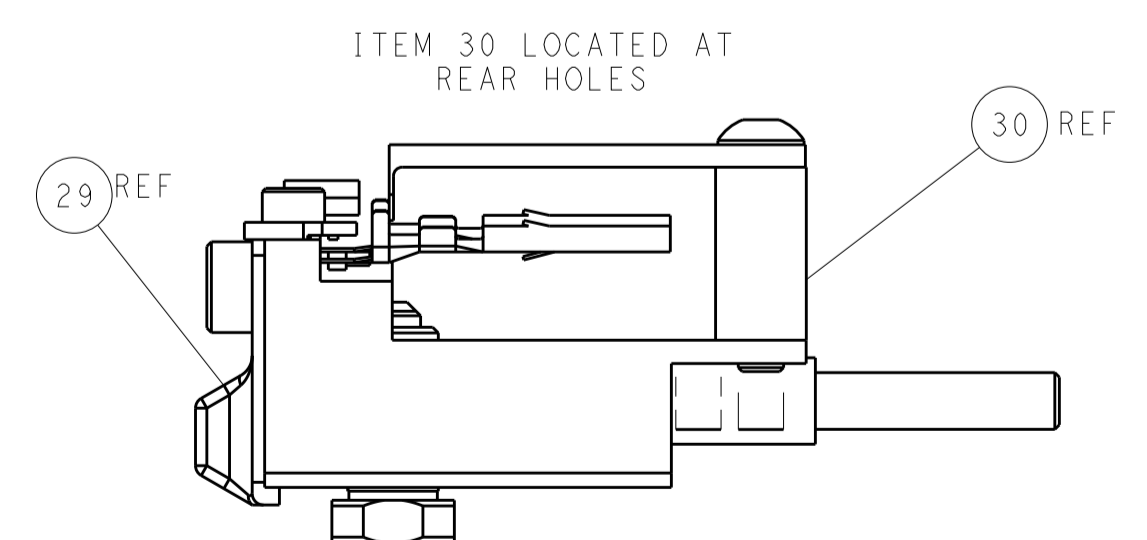
SHEAR DEPRESSOR DETAIL



TERMINAL SUPPORT LOCATION

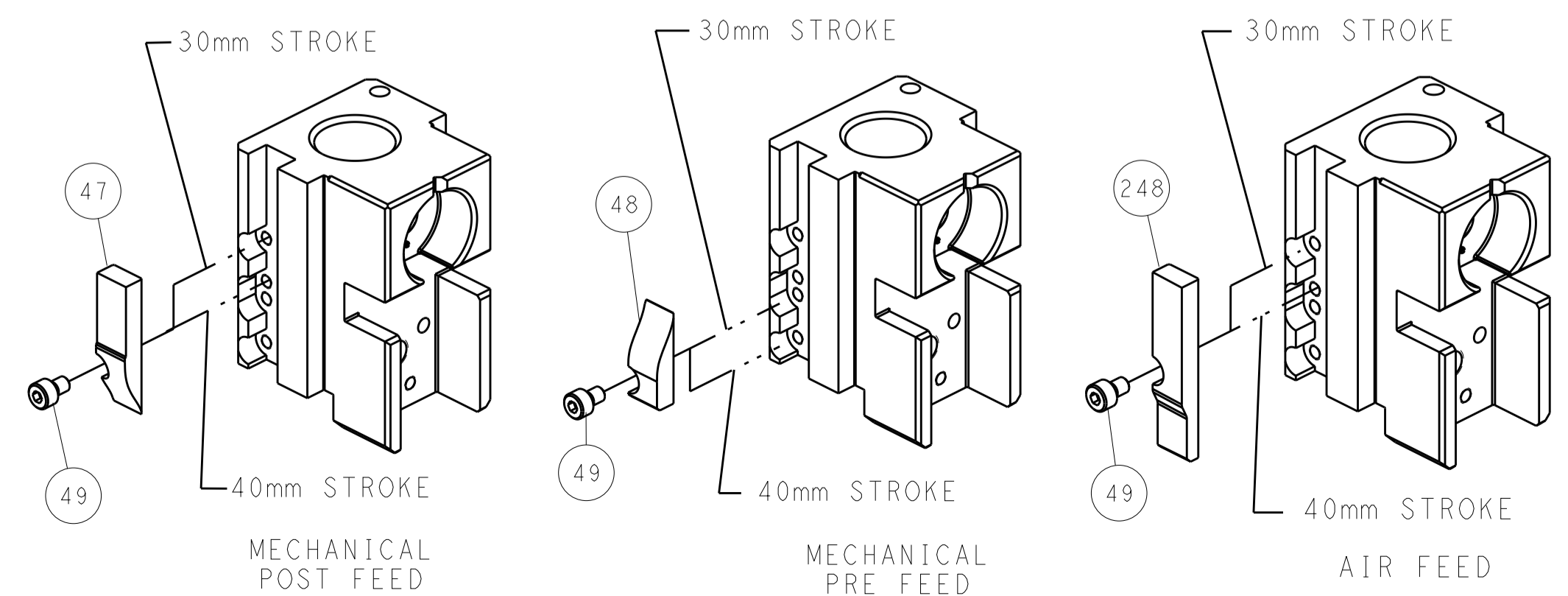


RAM SET-UP



FEED TRACK POSITION GUIDE BY INSULATION BARREL

CAM POSITIONS

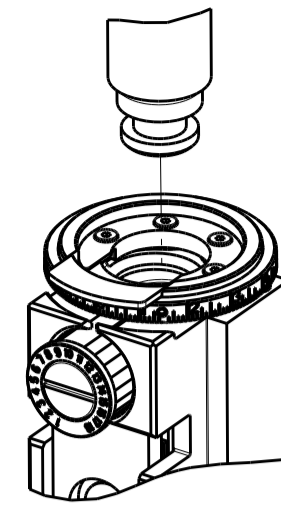


ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		DWN R. HUANG 05JAN2017 CHK L. ZHANG 05JAN2017 APVD L. ZHANG 05JAN2017 PRODUCT SPEC APPLICATION SPEC WEIGHT Customer Accessible Production Drawing		NAME Ocean Side Feed Applicator SIZE CAGE CODE DRAWING NO. A11 00779 C=2836551 SCALE 1:2 SHEET 2 OF 4 REV C	
MATERIAL:				FINISH:		RESTRICTED TO:	

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2836551-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2836551-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2836551-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.63 mm [.064]	F
INSUL	3.65 mm [.144]	O

APPLICATOR INSTRUCTIONS
408-35042

TERMINAL DATA: KOSTAL TERMINAL		KOSTAL CRIMP SPECIFICATION	
TERMINAL NAME: SLK 2.8 STECKER			
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE		
4.00-4.60 mm [.157-.181 IN]	Ø1.10-1.60 mm [.043-.063 IN]		
TERMINAL APPLICATION SPECIFICATION	(A) Attachment 1 DOC 00074173 Rev 06		

TERMINALS APPLIED				
TE TERMINAL	KOSTAL TERMINAL	TE SEAL	KOSTAL SEAL	CABLE DIAMETER
(A) 1572280-1	(A) 1 01 24 49913 0	(A) 2209984-1	(A) 1 08 00 44452 2	1.1 - 2.1mm
(A) 1572280-2	(A) 1 01 40 49913 0	(A) 957402-1	(A) 1 08 00 44452 2	1.1 - 2.1mm
(A) 1572280-3	(A) 1 01 25 49913 0	(A) 2113422-1	(A) 10030680	
(A) 1572791-1	(A) 2 21 24 49205 0			
(A) 1572791-2	(A) 2 21 40 49205 0			
(A) 1572791-3	(A) 2 21 25 49205 0			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.50mm2	1.00 +/- 0.03 [.039 +/- .001]	8.2
0.35mm2	0.99 +/- 0.03 [.039 +/- .001]	8.4
0.22mm2	0.97 +/- 0.03 [.038 +/- .001]	8.6

TERMINAL DATA: KOSTAL TERMINAL		KOSTAL CRIMP SPECIFICATION	
TERMINAL NAME: SLK 2.8 STECKER			
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE		
4.00-4.60 mm [.157-.181 IN]	Ø1.10-1.60 mm [.043-.063 IN]		
TERMINAL APPLICATION SPECIFICATION	(B) Attachment 3 DOC 00074173 Rev 06		

TERMINALS APPLIED				
TE TERMINAL	KOSTAL TERMINAL	TE SEAL	KOSTAL SEAL	CABLE DIAMETER
(B) 1572280-1	(B) 1 01 24 49913 0	(B) 2209984-1	(B) 1 08 00 44452 2	1.1 - 2.1mm
(B) 1572280-2	(B) 1 01 40 49913 0	(B) 957402-1	(B) 1 08 00 44452 2	1.1 - 2.1mm
(B) 1572280-3	(B) 1 01 25 49913 0	(B) 2113422-1	(B) 10030680	
(B) 1572791-1	(B) 2 21 24 49205 0			
(B) 1572791-2	(B) 2 21 40 49205 0			
(B) 1572791-3	(B) 2 21 25 49205 0			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
22 AWG	1.03 +/- 0.03 [.041 +/- .001]	7.8
24 AWG	1.01 +/- 0.03 [.040 +/- .001]	8.1

***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	ITEM NO		
-	1	1	2119082-2	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	2119791-9	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	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	1	1	985575-3	SCR, FLT SKT HD CAP M3 X 10.0	57
-	1	1	1338685-1	PAWL, FEED	56
-	2	2	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	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	1752356-1	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	2844992-4	ASSEMBLY, STRIP GUIDE	29
-	1	1	455888-5	SPACER, CRIMPER	28
-	1	1	240792-1	DRAG, TERMINAL	25
-	1	1	1320928-6	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	318707-1	FLOATING SHEAR, FRONT	9
-	1	1	7-1803249-0	ANVIL, COMBINATION	8
-	1	1	2-240641-0	SPACER	7
-	-	-	-	-	6
-	1	1	2119781-2	DEPRESSOR, SHEAR	5
-	1	1	238011-4	BLOCK, CRIMPER SPACER	4
-	1	1	2-1803317-7	CRIMPER, INSULATION O	3
-	1	1	455888-8	SPACER, CRIMPER	2
-	1	1	3-1803224-3	CRIMPER, WIRE	1

- 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.
- TERMINAL LUBRICANT IS RECOMMENDED.
- UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- APPLY TORQ-SEAL IN ALLEN SOCKET TO FILL HOLE AFTER FLAT HD HAS BEEN ADJUSTED TO CORRECT HEIGHT AT QUALIFICATION. APPLY #1-23419-5 LOC-TITE TO THREADS.

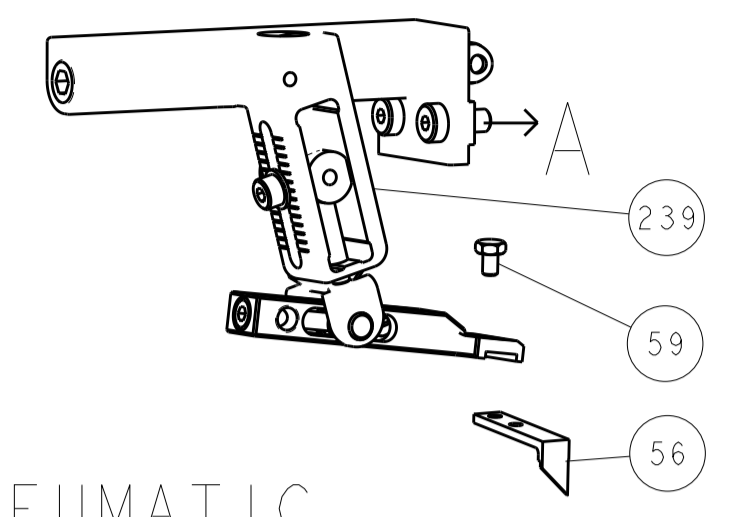
PACIFIC VERSION
Shown on sheets 3 of 4 & 4 of 4
(Atlantic version shown on sheets 1 of 4 & 2 of 4)

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

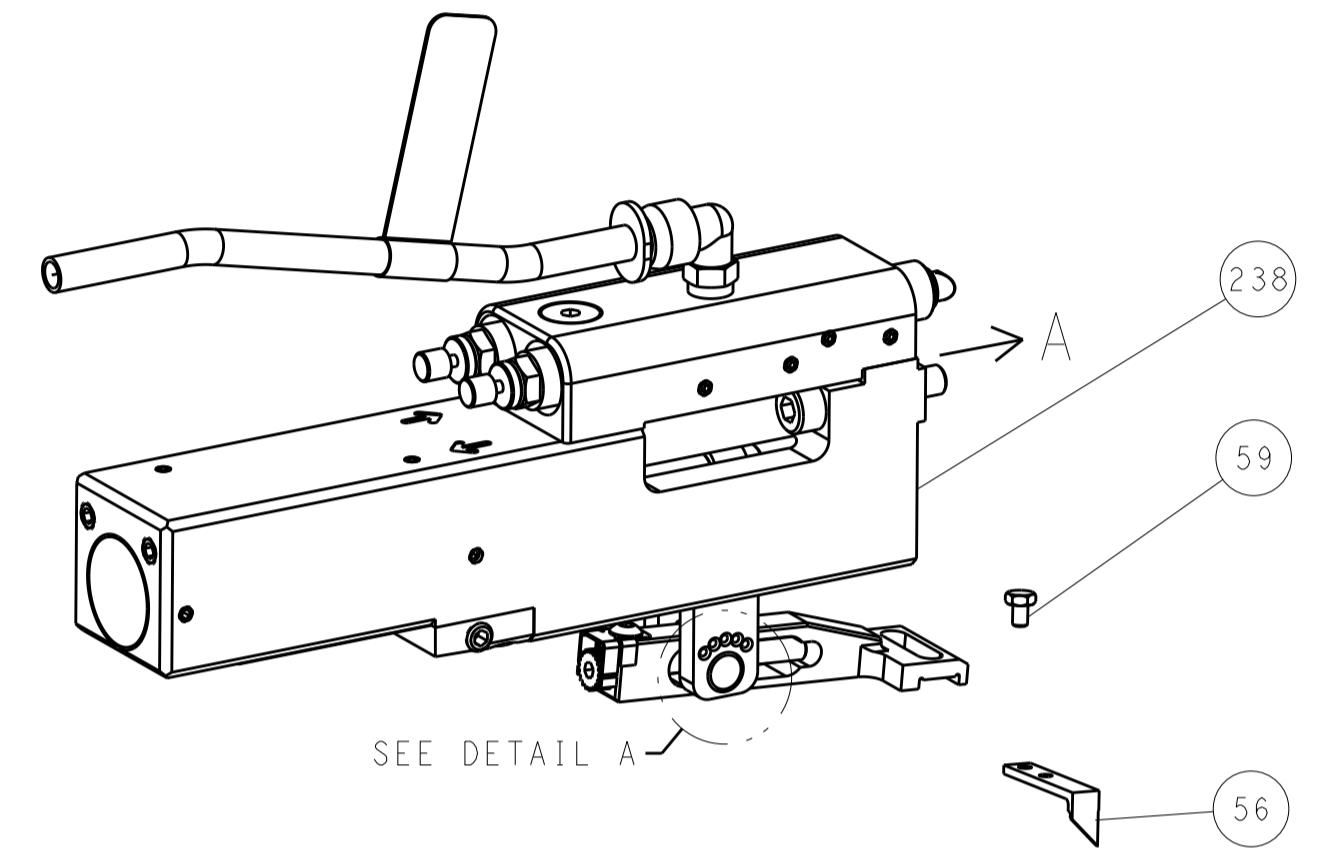
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DATE	05JAN2017	CHK	L. ZHANG	DATE	05JAN2017	CHK	L. ZHANG
PRODUCT SPEC	-						
APPLICATION SPEC	-						
SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO				
A1	00779	C=2836551	-				
Customer Accessible Production Drawing			SCALE	1:2	SHEET	3	OF 4
			REV	C			

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

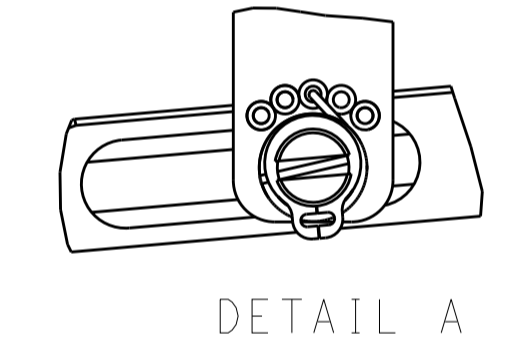
FEED TYPE MECHANICAL



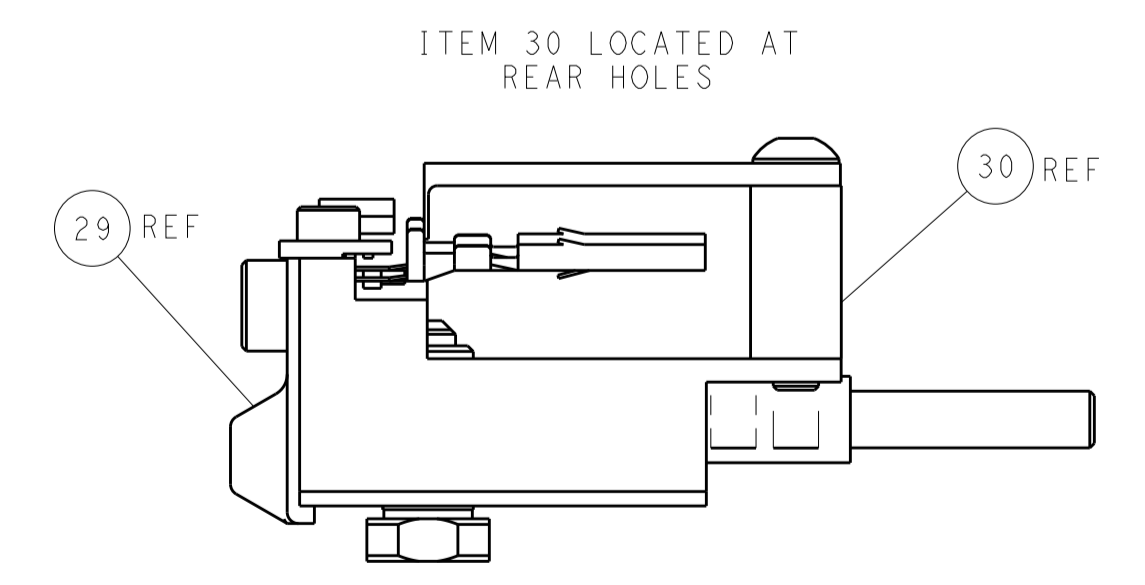
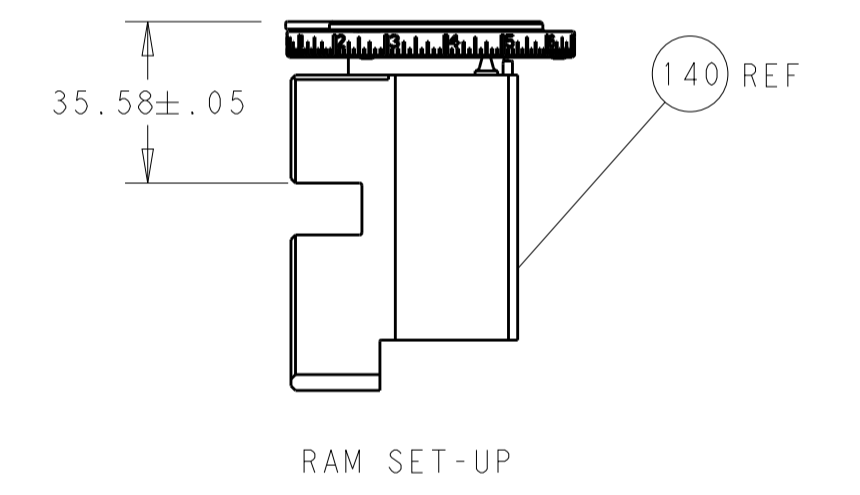
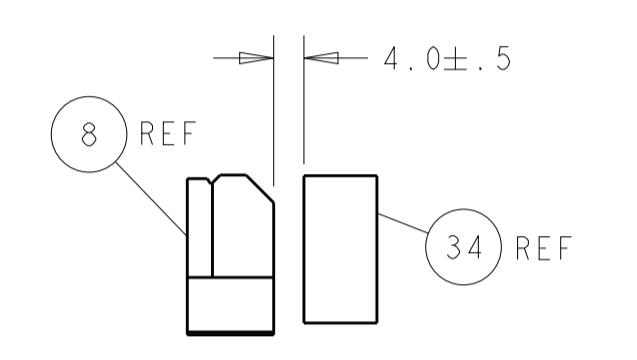
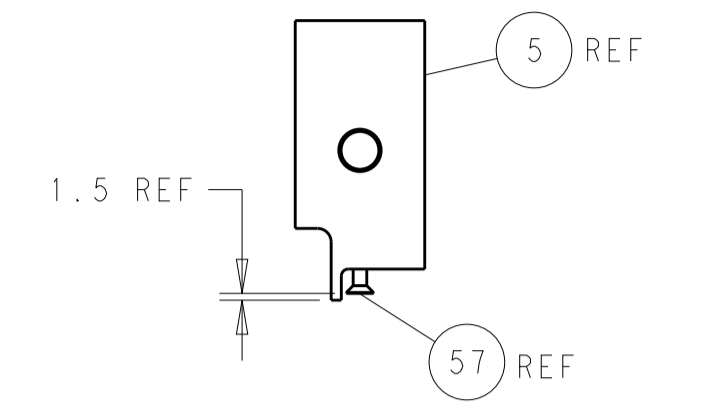
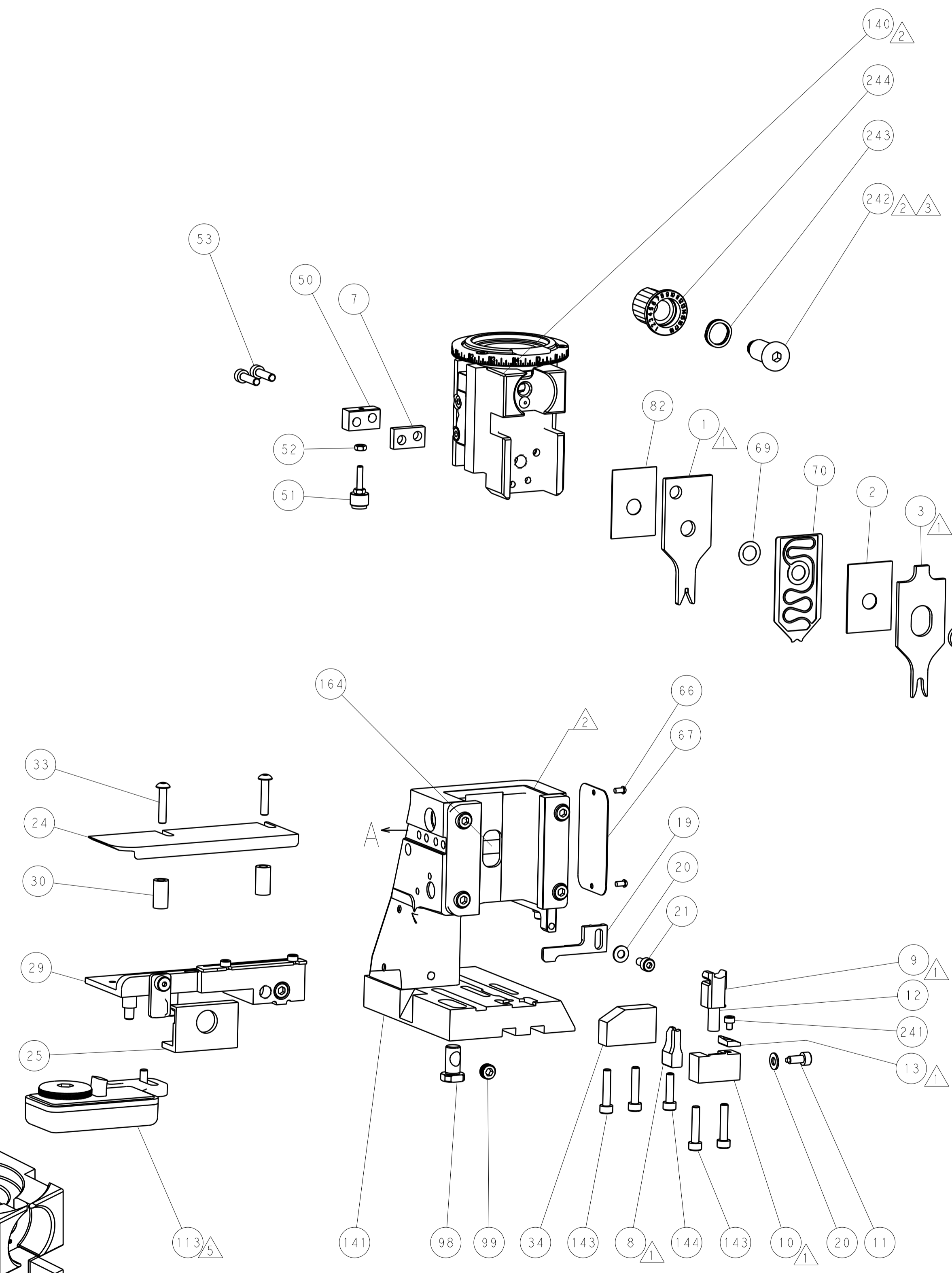
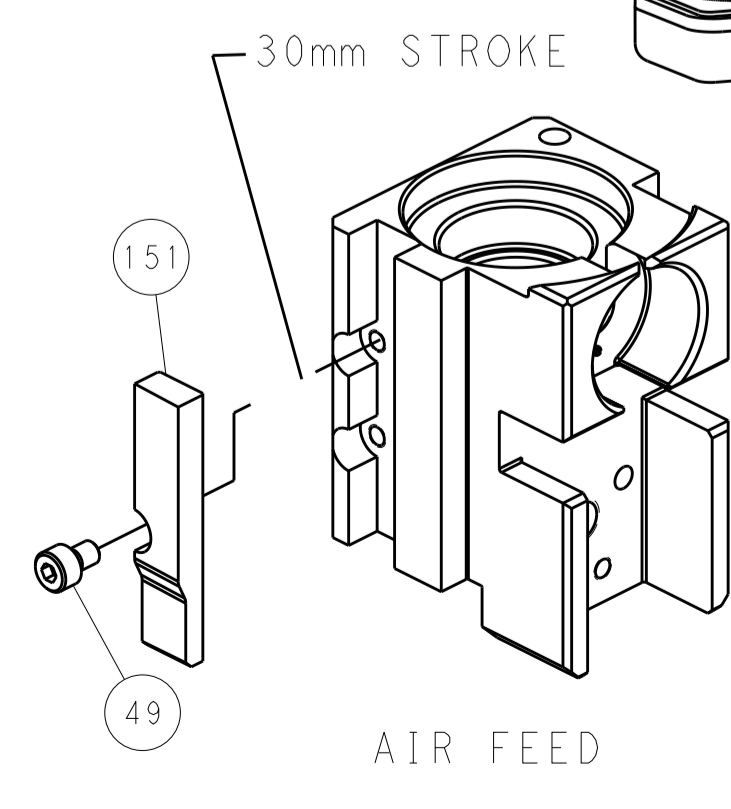
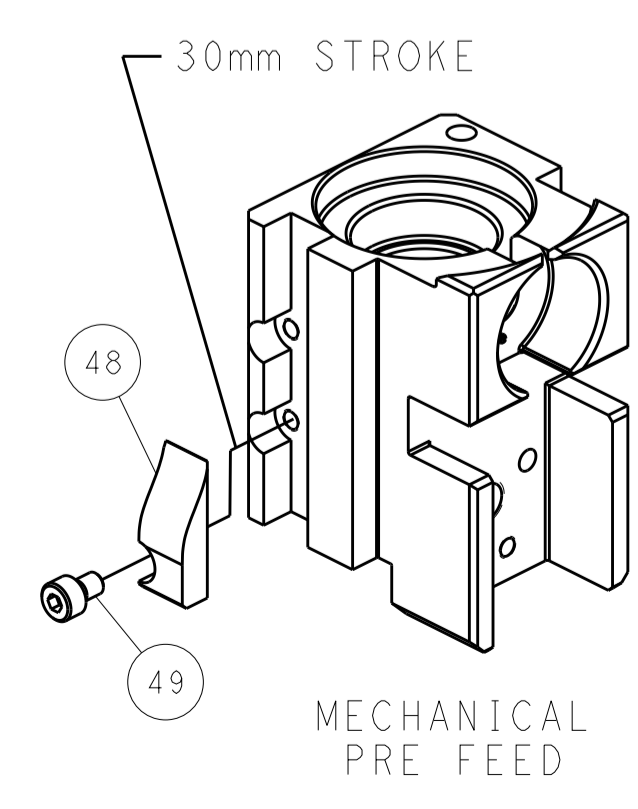
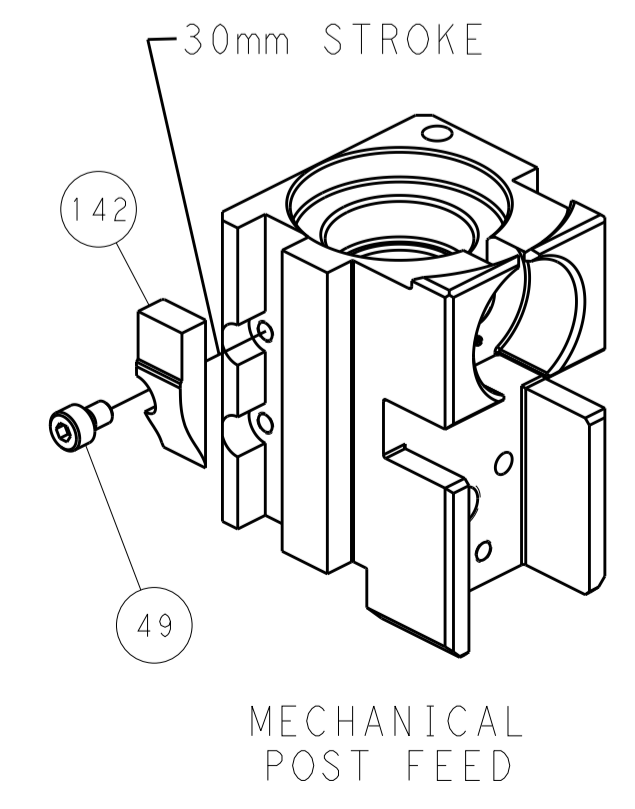
PNEUMATIC



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)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN R. HUANG 05JAN2017		STE TE Connectivity Harrisburg, PA 17105-3608	
mm	0 PLC	±		CHK L. ZHANG 05JAN2017	NAME	Ocean Side Feed Applicator	
	1 PLC	±		APVD L. ZHANG 05JAN2017	PRODUCT SPEC	SIZE	CAGE CODE DRAWING NO
	2 PLC	±			APPLICATION SPEC	A1	00779 C=2836551
	3 PLC	±			WEIGHT	SCALE	1:2
	4 PLC	±			Customer Accessible Production Drawing	SHEET	4 OF 4
	ANGLES	±				REV	C