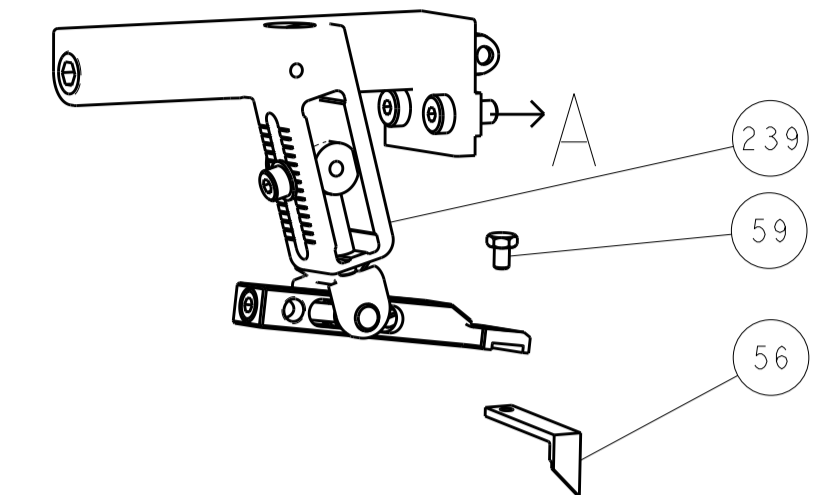
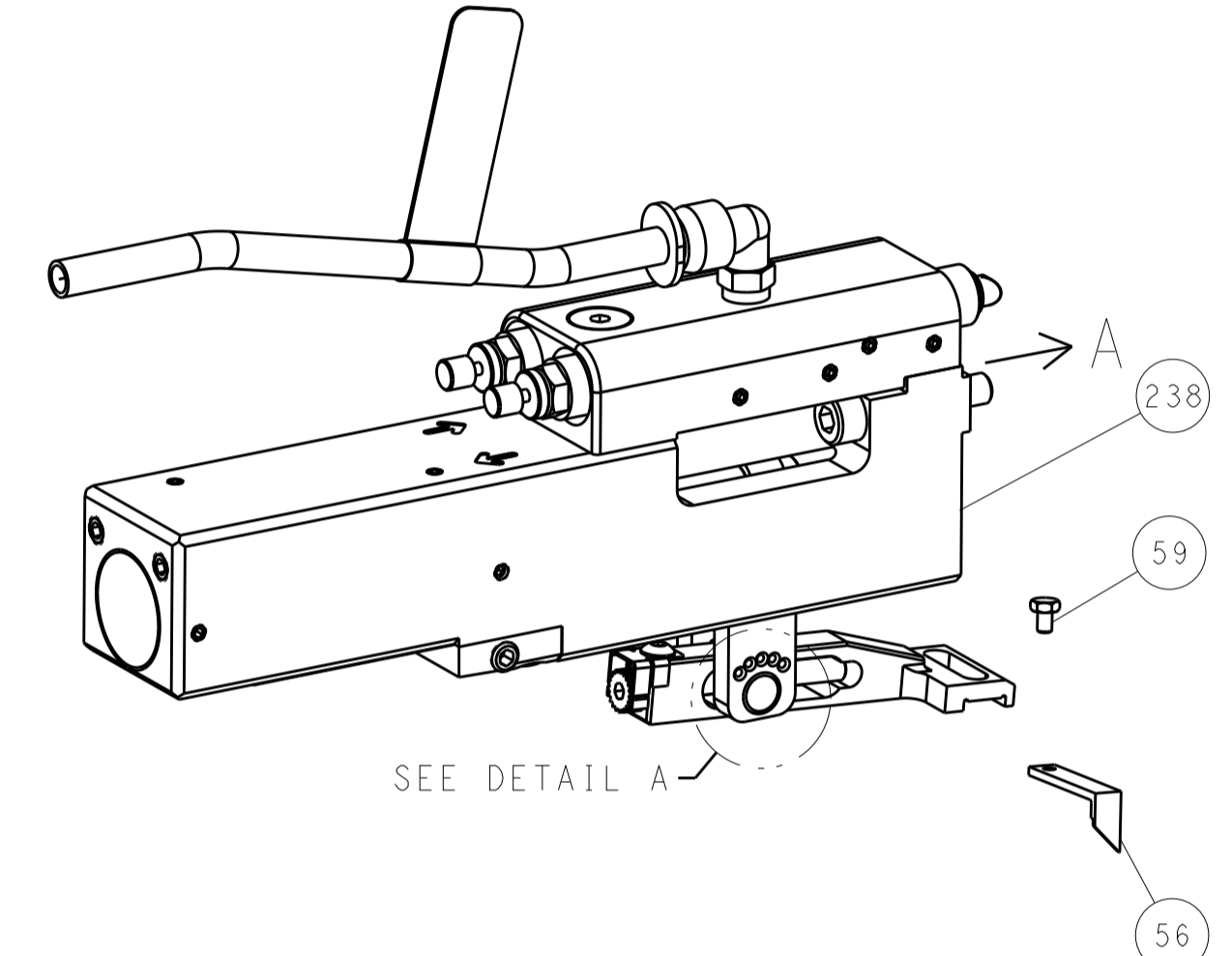


LOC	DIST	REV	DATE	BY	APPD
		1			
		2			
		3			
		4			

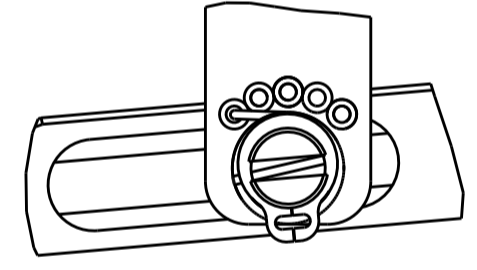
FEED TYPE MECHANICAL



PNEUMATIC

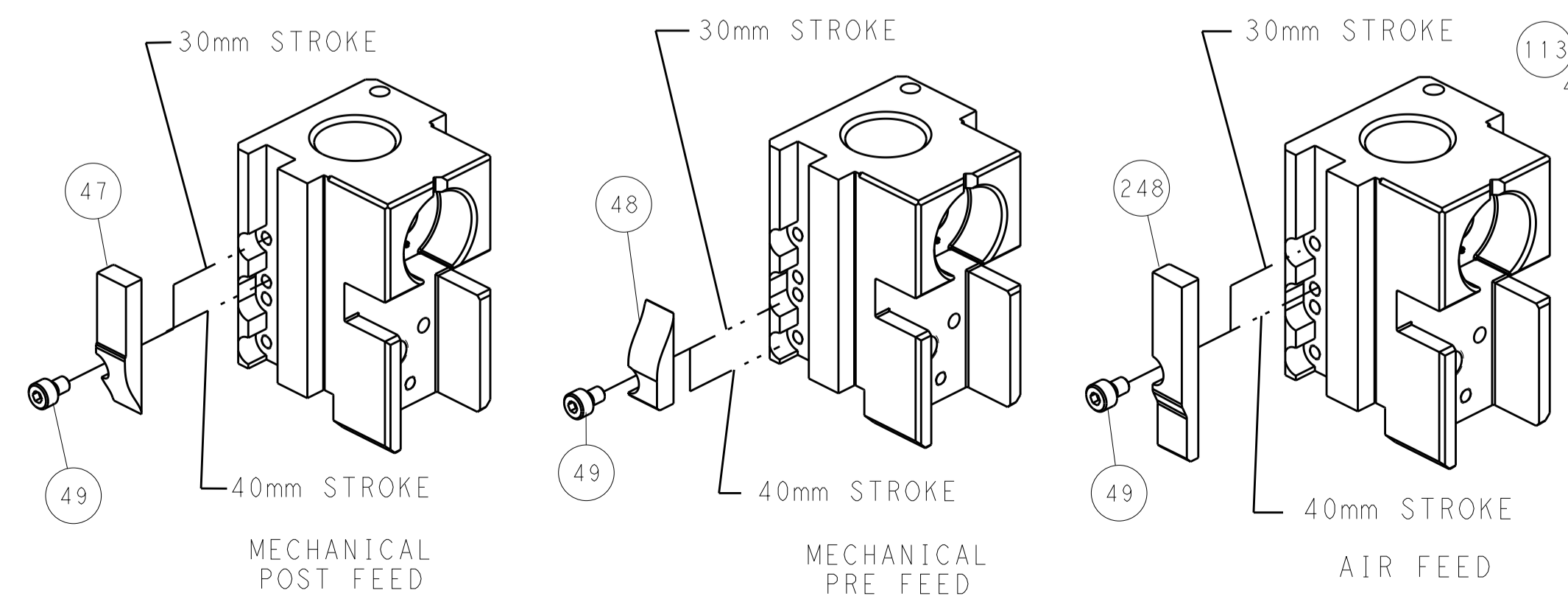


FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



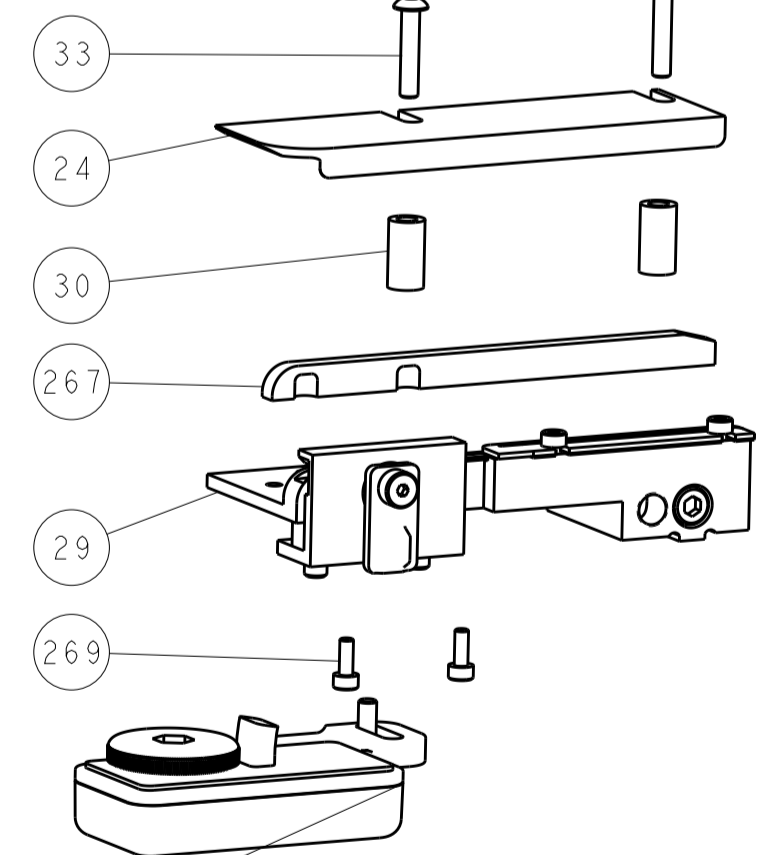
DETAIL A

CAM POSITIONS

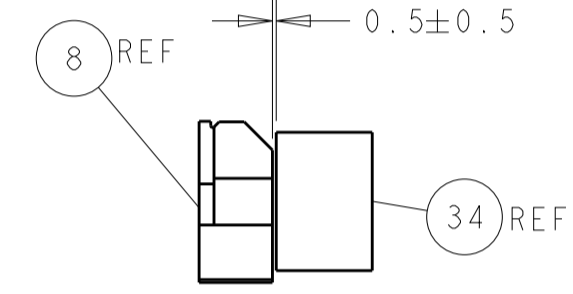
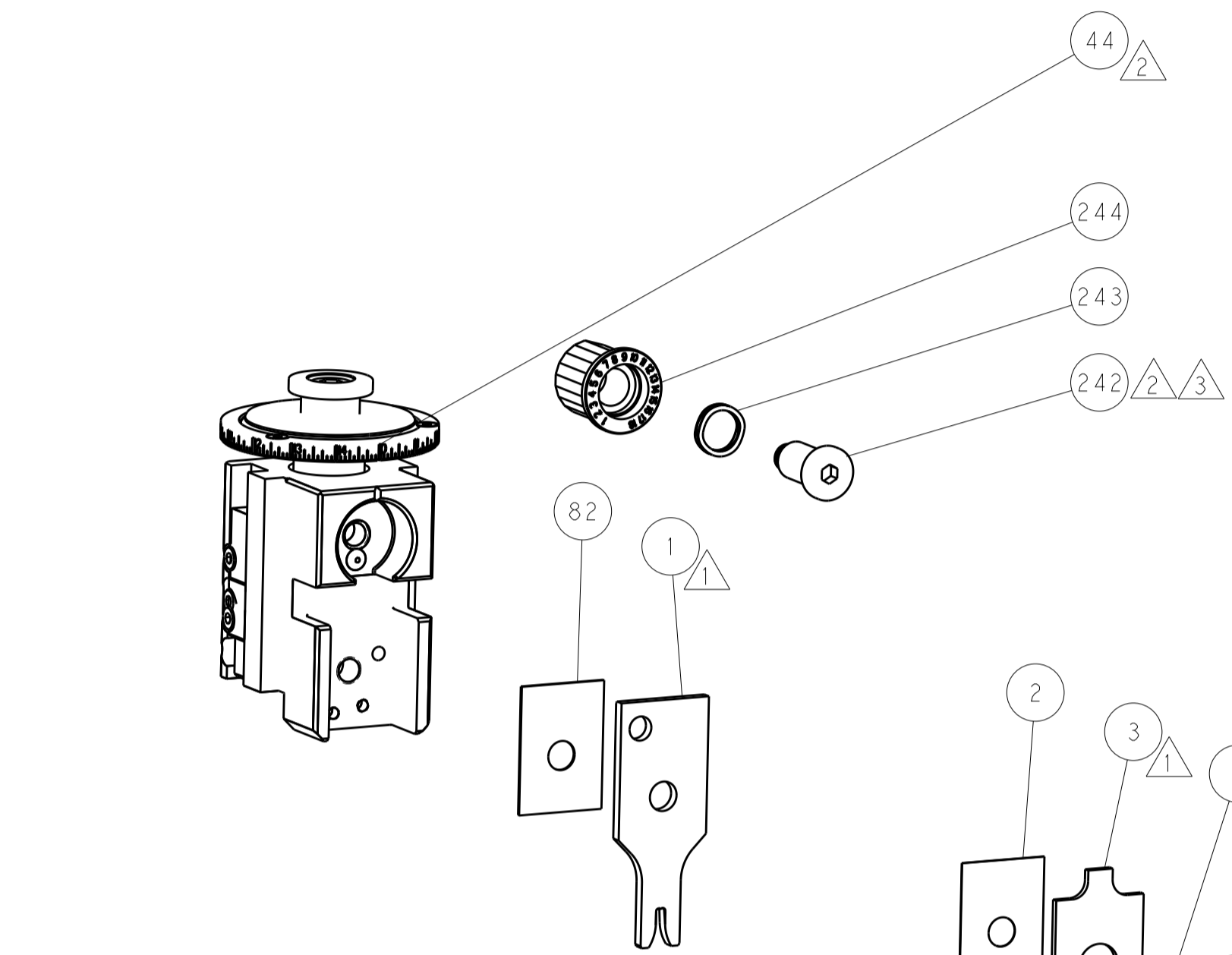


53

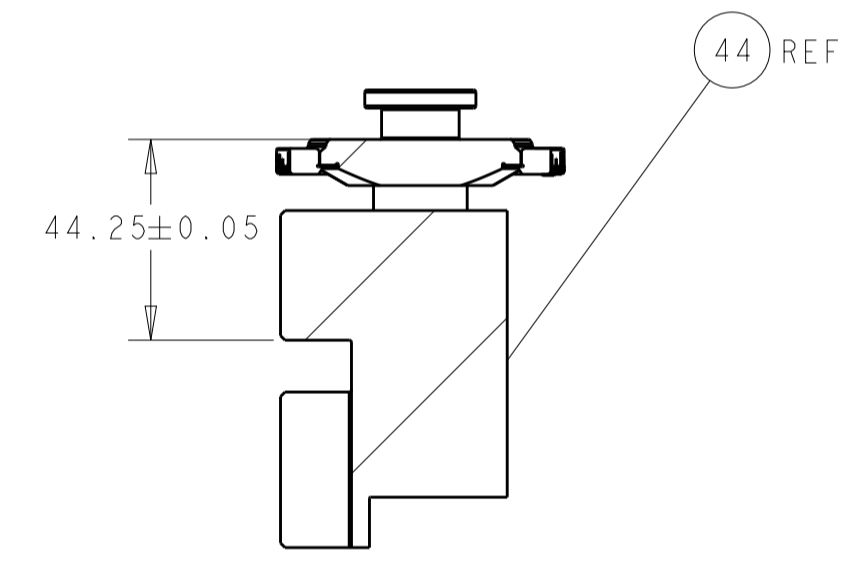
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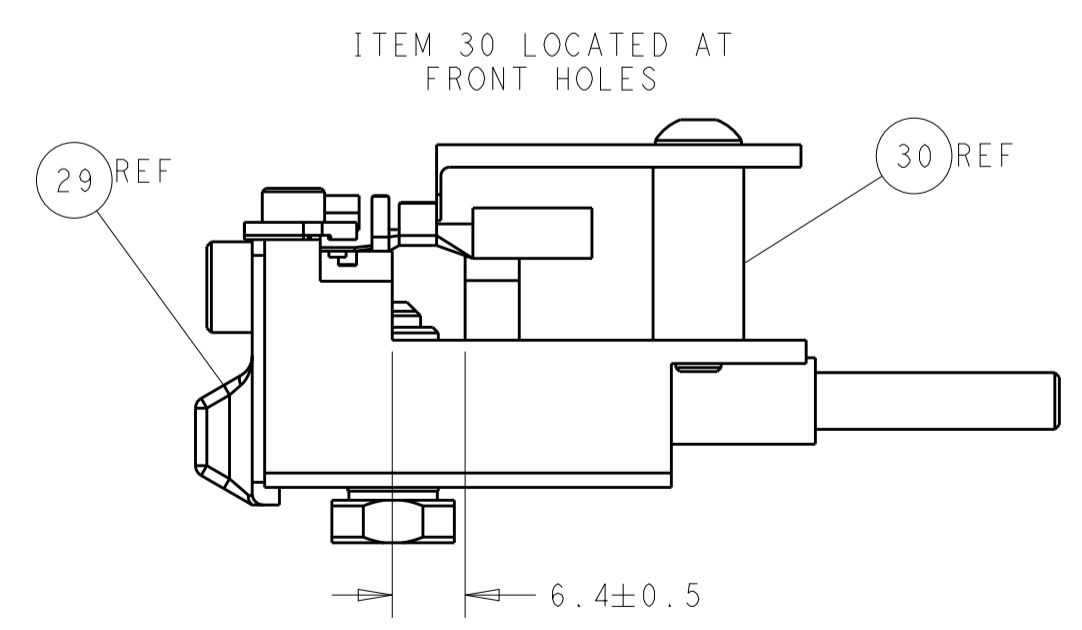
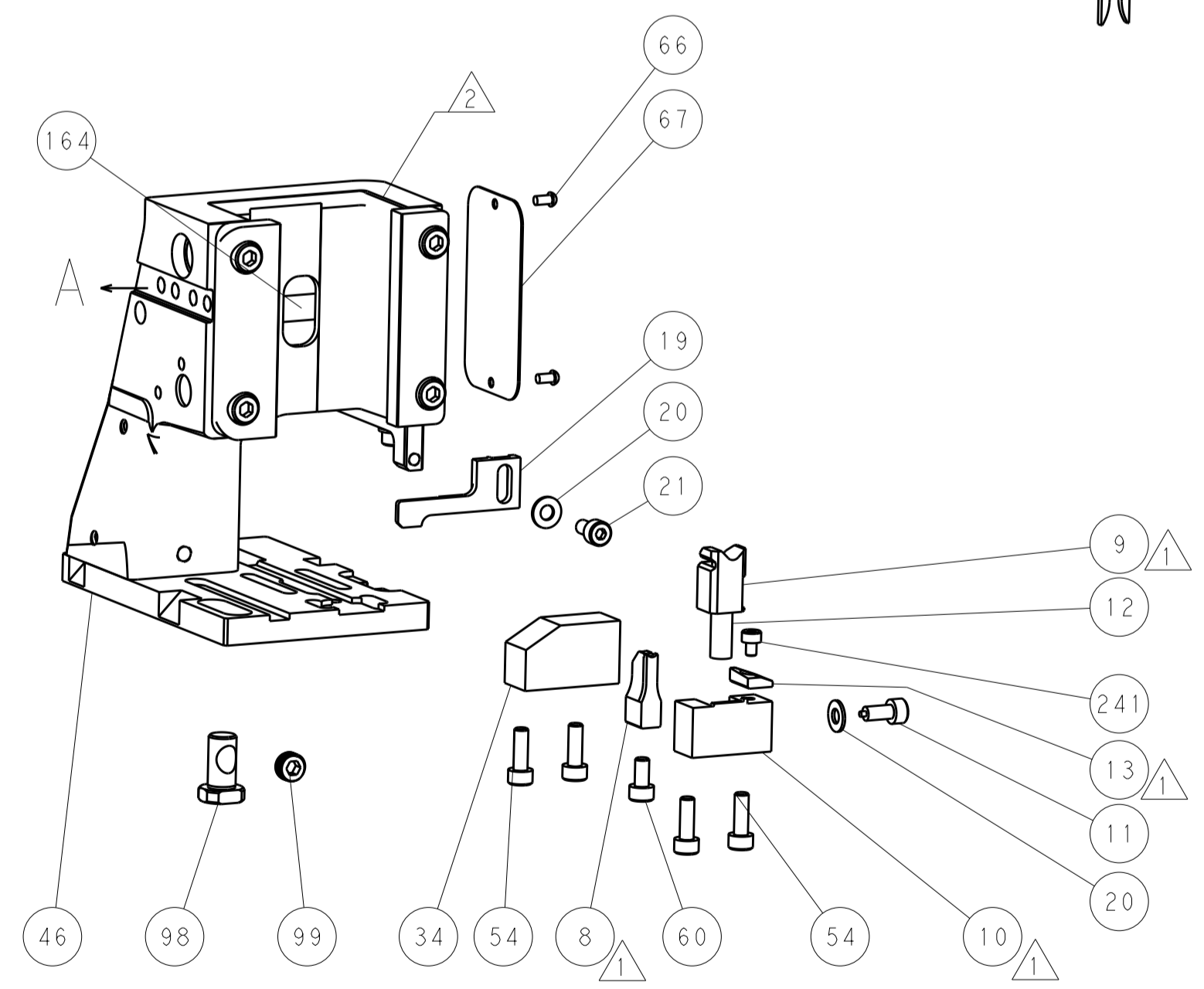
113



TERMINAL SUPPORT LOCATION



RAM SET-UP



FEED TRACK POSITION GUIDE BY WIRE 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:		DWG		REV	
mm	0 PLC	±		CHS	T. HERR	10JAN2017	
	1 PLC	±		APVD	T. ELBIN	10JAN2017	
	2 PLC	±		NAME	Ocean Side Feed		
	3 PLC	±		PRODUCT SPEC	Applicator		
	4 PLC	±		APPLICATION SPEC			
	ANGLES	±		SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
MATERIAL	FINISH			A1	00779	2836567	
				Customer Accessible Production Drawing	SCALE	1:2	SHEET 2 OF 4 REV B

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2836567-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2836567-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2836567-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.62 mm [.103]	F
INSUL	3.60 mm [.142]	F

APPLICATOR INSTRUCTIONS
408-35042

TERMINAL DATA: G&H (LEAR) TERMINAL LEAR CRIMP SPECIFICATION			
TERMINAL NAME: 2.8 MAK FLAT CONTACT			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
4.60-5.40 mm [.181-.213 IN]		∅2.20-3.00 mm [.087-.118 IN]	
TERMINAL APPLICATION SPECIFICATION	28273 Rev 3	-	-
TERMINALS APPLIED			
TE TERMINAL	G&H (LEAR) TERMINAL	TE TERMINAL	G&H (LEAR) TERMINAL
1949213-1	28273.306.185		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
2.50mm ²	1.60 +/- 0.05 [1.063 +/- .002]	6.0
(2)1mm ²	1.50 +/- 0.05 [1.059 +/- .002]	7.0
1.50mm ²	1.40 +/- 0.05 [1.055 +/- .002]	8.0

- 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.
- TERMINAL LUBRICANT IS RECOMMENDED.

***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)

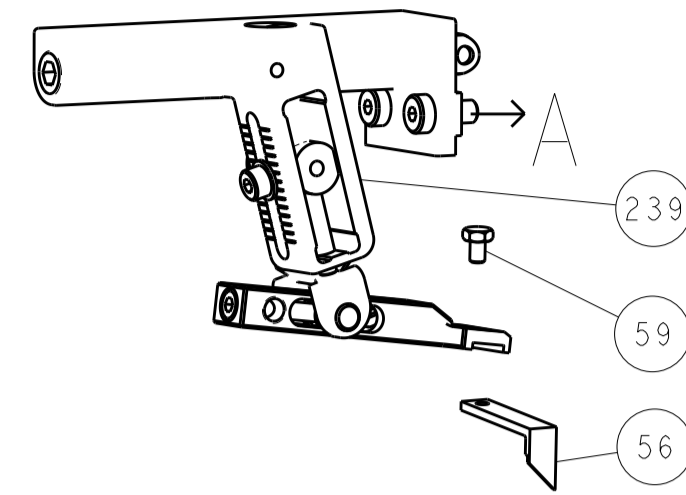
LOC	DIST	REV	DATE	BY	APPV
-	-	1	-	-	-

REV	DATE	BY	APPV	DESCRIPTION	DATE	BY	APPV
-	-	-	-	SEE SHEET 1	-	-	-
-	2	2		2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0		269
-	1	1		1-1633782-1	FENCE		267
-	1	1		2119082-4	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		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		1338683-8	FEED PAWL		56
-	2	2		1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10		53
-	1	1		1803382-2	HOLD DOWN, SPRING LOADED		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		1752356-4	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		2844992-2	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		1-356885-3	STOP, SHEAR		11
	-	1	1	2119805-1	SHEAR HOLDER, FRONT		10
	-	1	1	1803095-5	FLOATING SHEAR, FRONT		9
	1	1	1	5-1803252-0	ANVIL, COMBINATION		8
-	-	-		-	-		7
-	-	-		-	-		6
-	1	1		2119757-4	DEPRESSOR, SHEAR		5
-	1	1		2-238011-2	BLOCK, CRIMPER SPACER		4
	1	1	1	1803384-9	CRIMPER, INSULATION F		3
-	1	1		455888-1	SPACER, CRIMPER		2
	1	1	1	1803470-1	CRIMPER, WIRE F		1

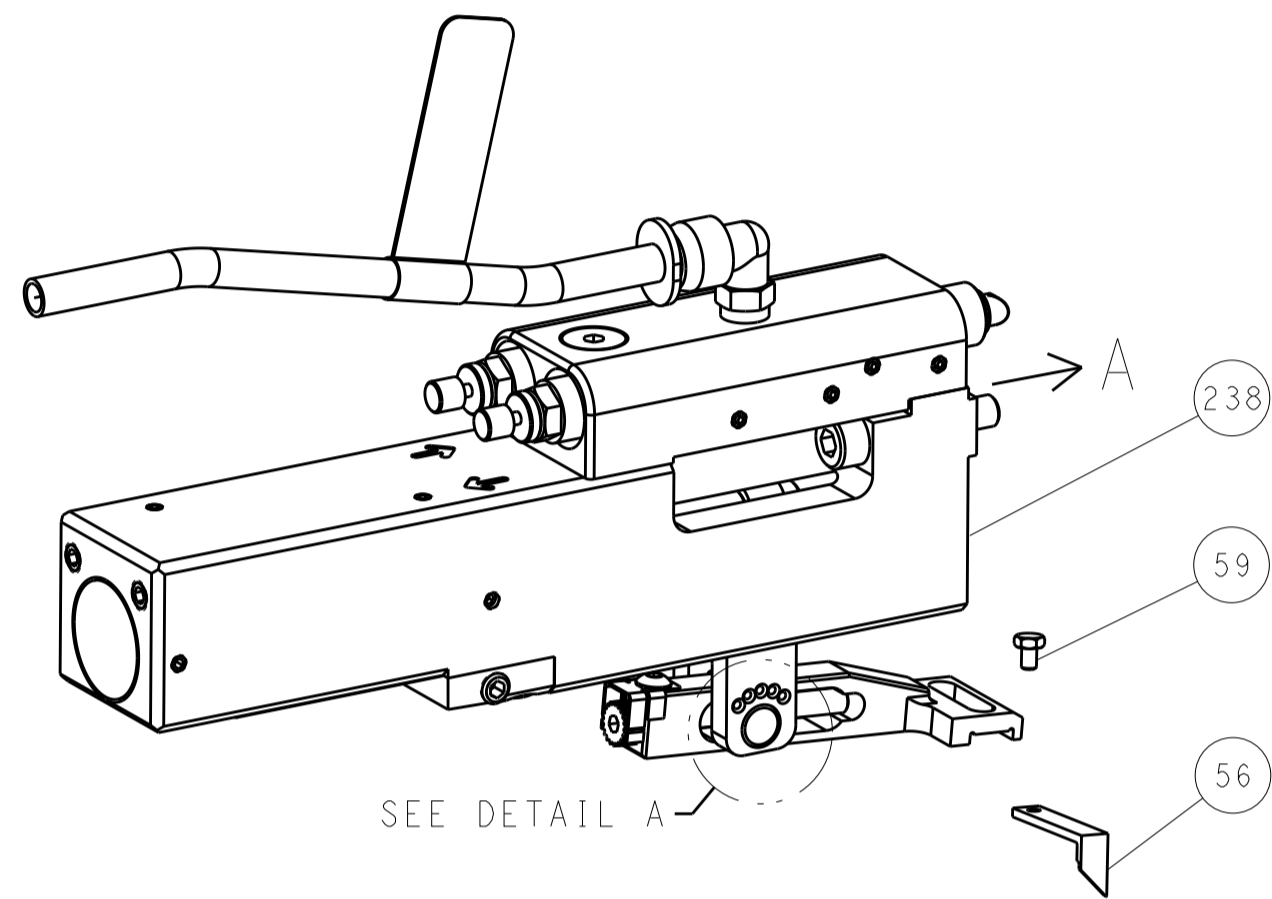
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		OWN	DATE	
mm	0 PLC ±	1 PLC ±	2 PLC ±	JM_HERR	10JAN2017	
	3 PLC ±	4 PLC ±	ANGLES ±	T. ELBIN	10JAN2017	Ocean Side Feed Applicator
MATERIAL	FINISH	WEIGHT	SCALE	APVD	DATE	
-	-	-	1:2	T. ELBIN	10JAN2017	Customer Accessible Production Drawing
Customer Accessible Production Drawing			SCALE	SHEET	OF	REV
Customer Accessible Production Drawing			1:2	3	4	B

LOC	DIST	REV	DESCRIPTION	DATE	OWN	APVD
			SEE SHEET 1			

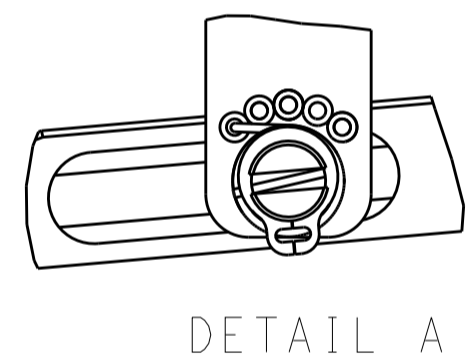
FEED TYPE MECHANICAL



PNEUMATIC

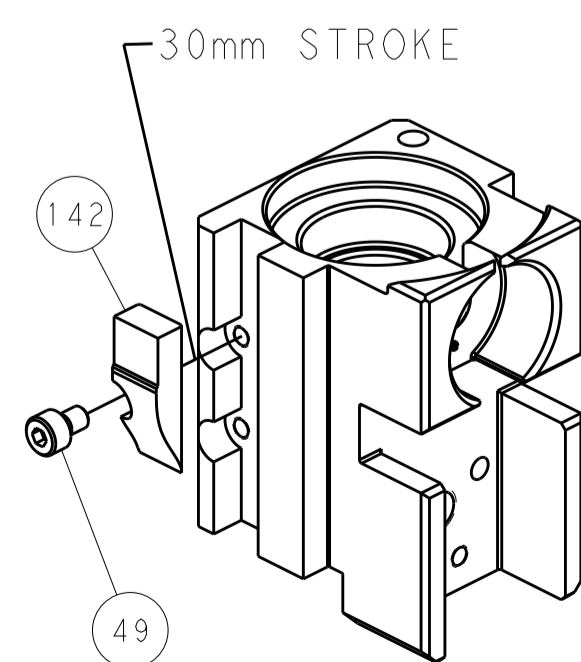


FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)

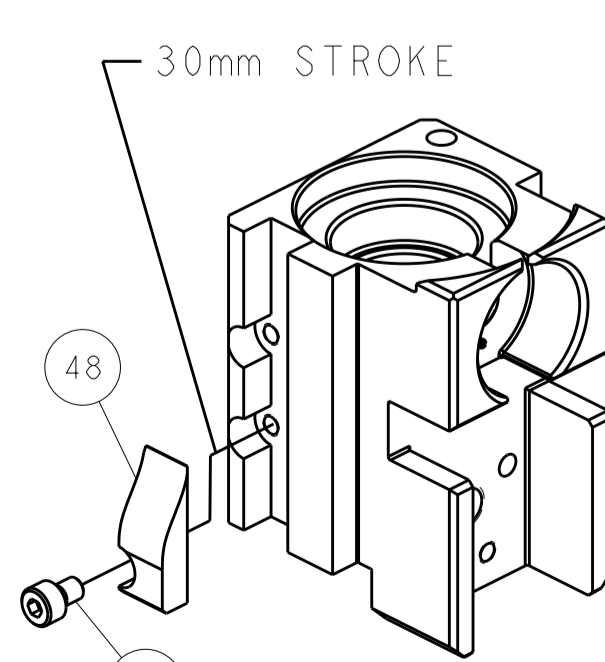


DETAIL A

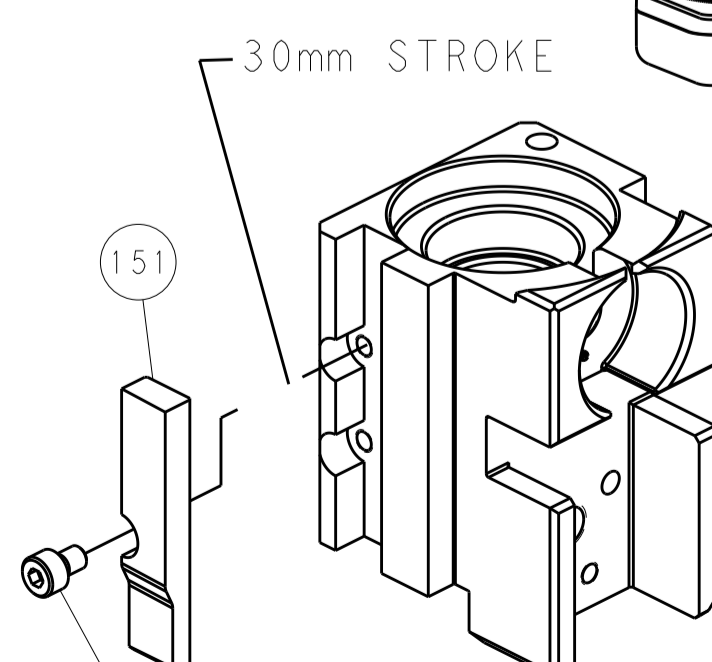
CAM POSITIONS



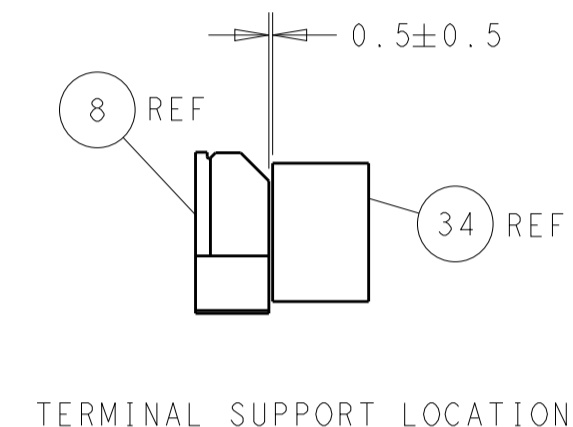
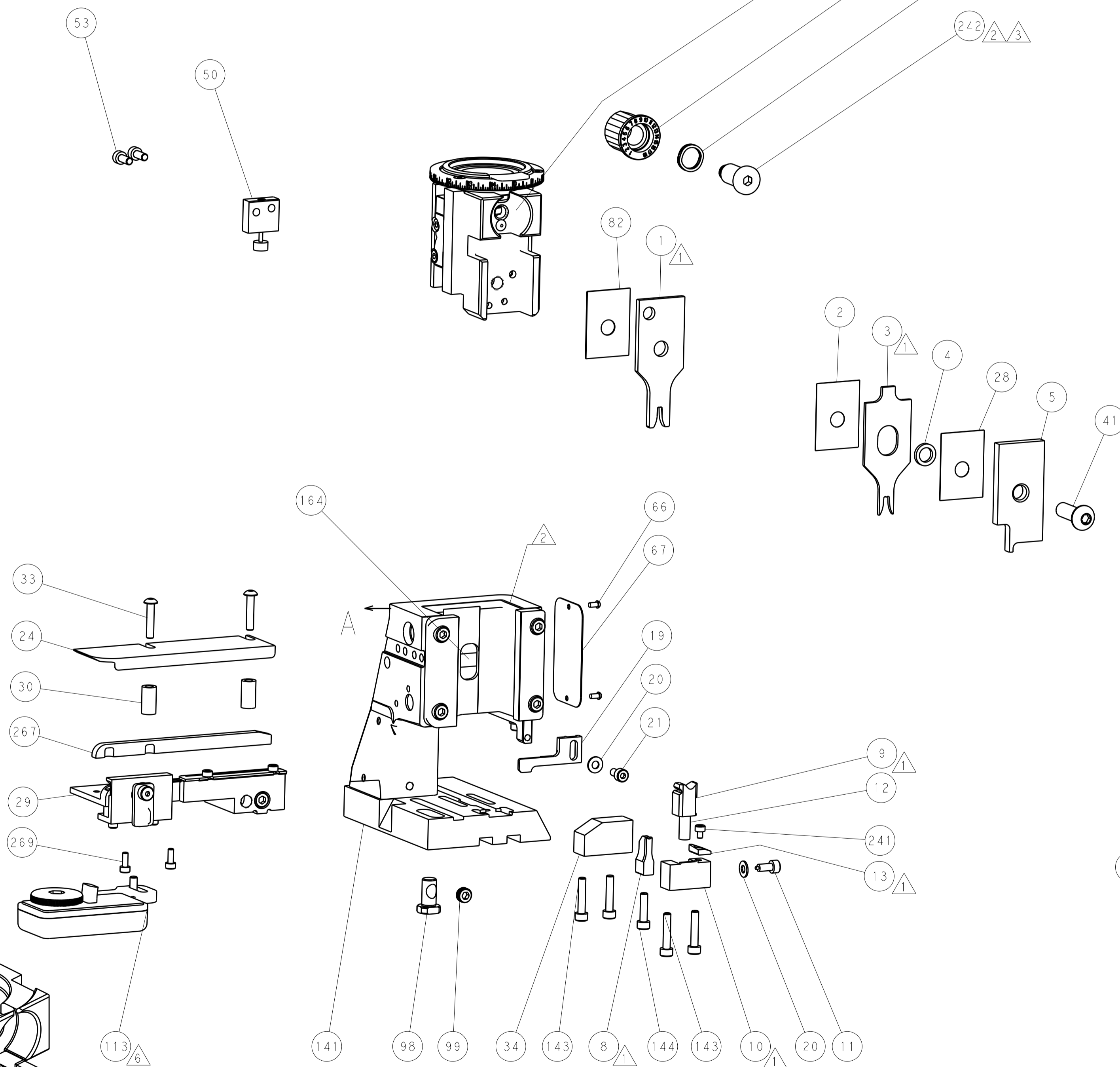
MECHANICAL
POST FEED



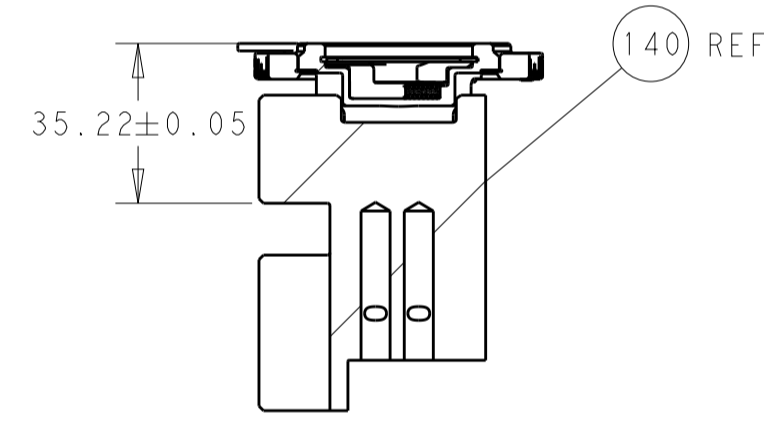
MECHANICAL
PRE FEED



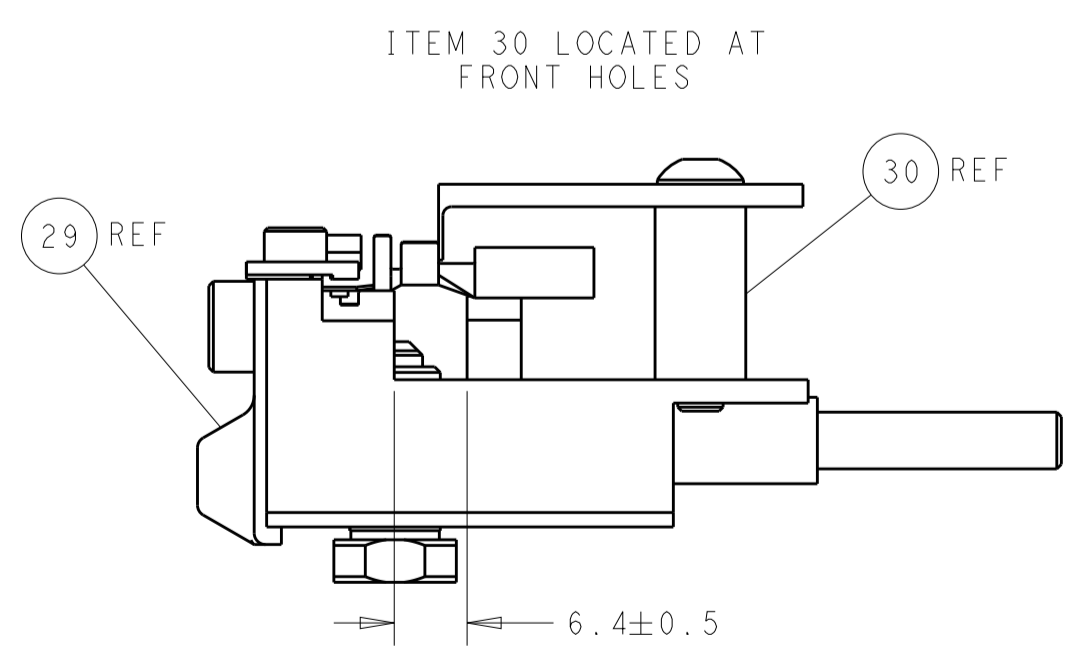
AIR FEED



TERMINAL SUPPORT LOCATION



RAM SET-UP



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)

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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: CAGE CODE DRAWING NO: WEIGHT: A 00779 C=2836567
MATERIAL:		RESTRICTED TO:	SCALE: 1:2 SHEET 4 OF 4 REV B