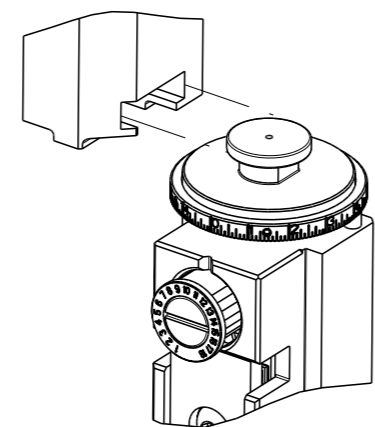


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2836628-2	F	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2836628-2	F	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2836628-7	B	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER

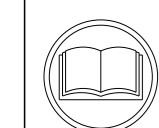


APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	0.80 mm [.031]	F
INSUL	0.95 mm [.037]	F

APPLICATOR INSTRUCTIONS 408-35042

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: WIRE TO BOARD SOCKET, TERMINAL.			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
0.90-1.30 mm [.035-.051 IN]		Ø0.90-1.00 mm [.035-.039 IN]	
TERMINAL APPLICATION SPECIFICATION	114-57016		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
1734193-1	440147-2		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
28 AWG OR 0.08mm2	0.535+/-0.025 [.021+/- .001]	7.2
30 AWG OR 0.05mm2	0.505+/-0.025 [.020+/- .001]	7.4
32 AWG OR 0.03mm2	0.485+/-0.025 [.019+/- .001]	7.7



- RECOMMENDED SPARE PARTS
- REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 180. 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 PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- THIS APPLICATOR DOES NOT CUT CARRIER STRIP.
- 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.

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	CHK
		C	ECR-17-017574	30NOV2017	TB CT
		D	ECR-18-019192	10DEC2018	MZ KZ
		E	ECR-20-013428	22SEP2020	FJ TE
		F	ECR-21-003564	23MAR2021	JWC RK

-	1	1	2-2119791-2	DEPRESSOR, WIRE	286
-	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	2844940-1	AIR FEED MODULE	238
-	2	2	1-2079383-0	SCR, BHSC, RoHS (M3 X 6)	230
-	1	1	1-1752354-3	STANDOFF, HOLD-DOWN	180
-	1	1	2-1633764-2	HOLD DOWN, TERMINAL	179
-	1	1	6-993111-6	PIN, SLOTTED SPRING 3.0 X 14.0	177
-	1	1	8-22280-7	SPRING, COMPRESSION	176
-	1	1	1752353-2	GUIDE PIN, HOLDDOWN	175
-	1	1	1901680-2	GUIDE PIN, HOLDDOWN	174
-	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	1	1	1-22281-8	SPRING, COMPRESSION	121
-	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	1-690438-0	FRONT STRIP GUIDE	96
-	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	95
-	1	1	2168083-6	SCR, SKT HD CAP, RoHS, M5 X 65	93
-	1	1	1803607-3	DOCUMENTATION PACKAGE	71
-	1	1	2-2119791-2	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
-	2	2	2-18032-5	SCR, SET, FLT PNT, M5 X 20.0	61
-	1	1	2161425-1	SCREW, SHOULDER	60
-	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	1	1	1338685-1	PAWL, FEED	56
-	2	2	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	54
-	1	1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52
-	1	1	1901681-8	HOLDDOWN, TERMINAL	51
-	1	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	1	1	2-1803583-5	APPLICATOR BASIC ASSEMBLY, SF	46
-	1	1	1803515-3	RAM ASSEMBLY, SF ATLANTIC	44
-	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
-	1	1	2-1752356-5	SUPPORT, TERMINAL	34
-	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	2-2844962-3	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	2-2844938-0	PLATE, STRIP GUIDE	29
-	1	1	455888-3	SPACER, CRIMPER	28
-	2	2	22283-1	SPRING, COMPRESSION	27
-	1	1	356835-1	LEVER, DRAG RELEASE	26
-	1	1	240792-1	DRAG, TERMINAL	25
-	1	1	1320928-2	STRIP GUIDE	24
-	1	1	980371-4	SCR, SKT HD SHLDR 5.0 DIA X 6.0	23
-	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	2119533-4	STRIPPER, SIDE FEED	19
-	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	2	1803437-2	ANVIL, COMBINATION	8
-	-	-	-	-	7
-	-	-	-	-	6
-	1	1	2-2119757-7	DEPRESSOR, SHEAR	5
-	1	1	2-238011-0	BLOCK, CRIMPER SPACER	4
-	1	2	1803559-1	CRIMPER, INSULATION F PREMIUM	3
-	-	-	-	-	2
-	1	2	1803558-1	CRIMPER, WIRE PREMIUM	1
-	77	72	-2	PART NO	ITEM NO

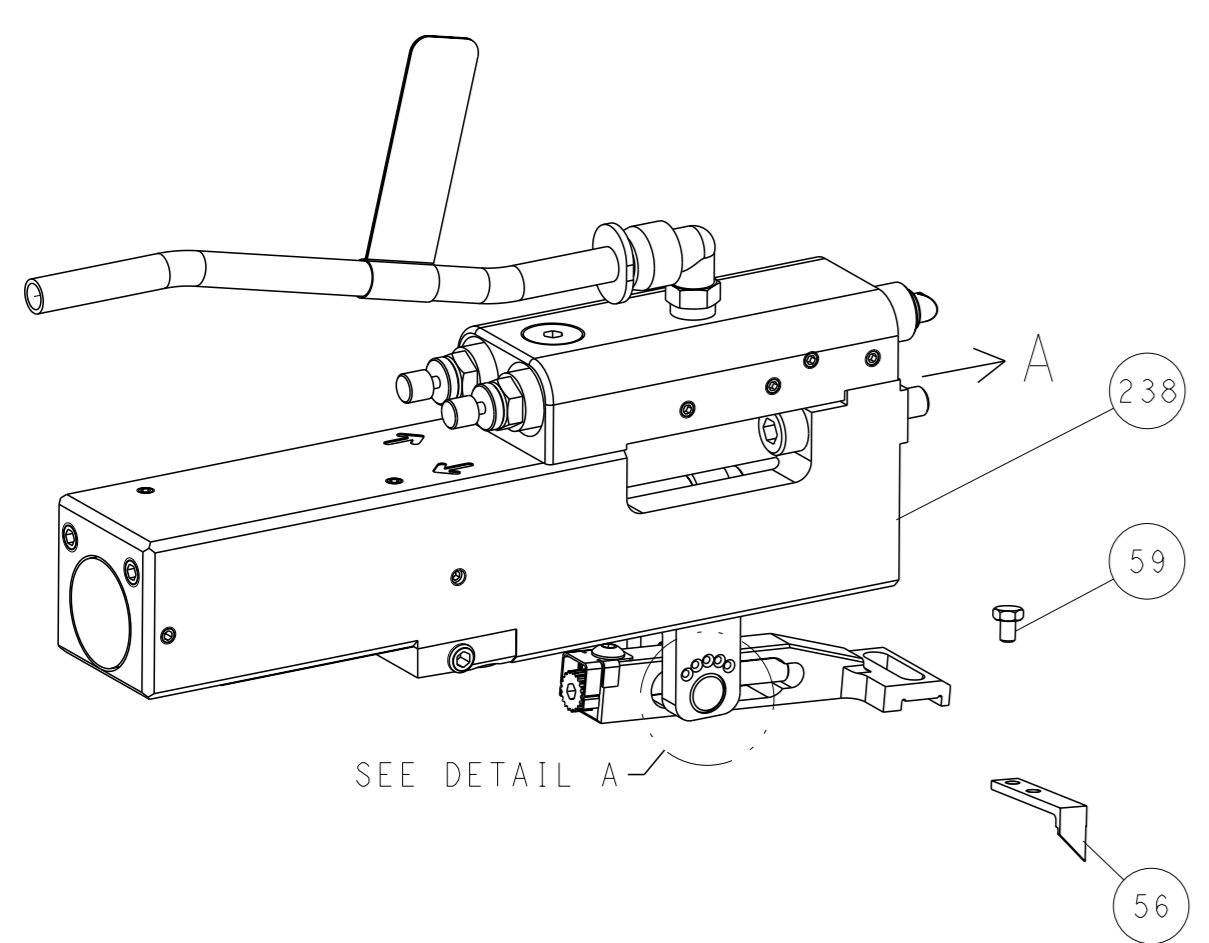
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		APPLICATOR DATA	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±
	ANGLES	FINISH			
MATERIAL					

OWN	H. HUANG	22FEB2017	TE Connectivity Harrisburg, PA 17105-3608
CHK	L. ZHANG	22FEB2017	
APVD	L. ZHANG	22FEB2017	
NAME	Ocean Side Feed Applicator		
SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
A1	00779	2836628	
Customer Accessible Production Drawing			SCALE 1:2 SHEET 1 OF 4 REV F

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

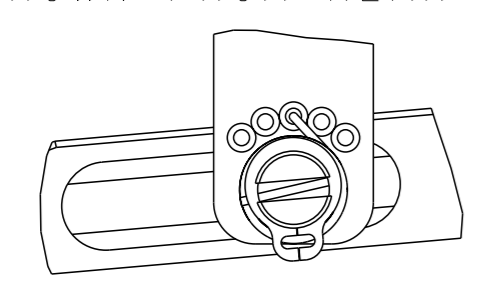
FEED TYPE

PNEUMATIC



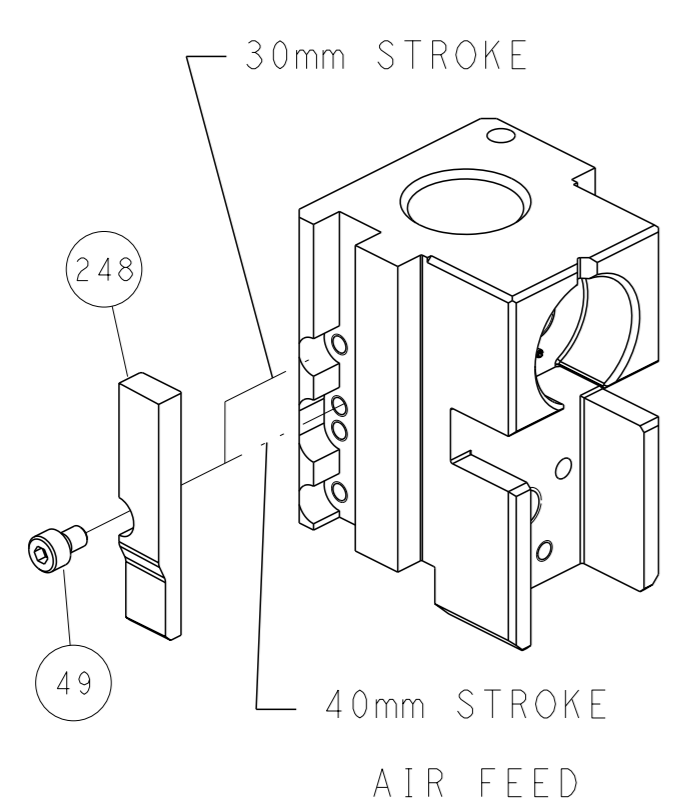
SEE DETAIL A

FEED SPRING SETTING POSITION
(SHOWN FROM REAR SIDE)

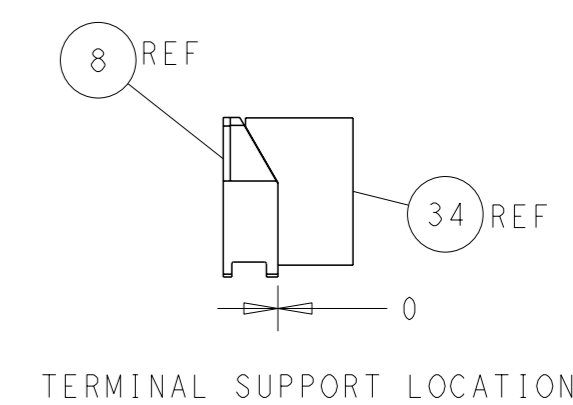
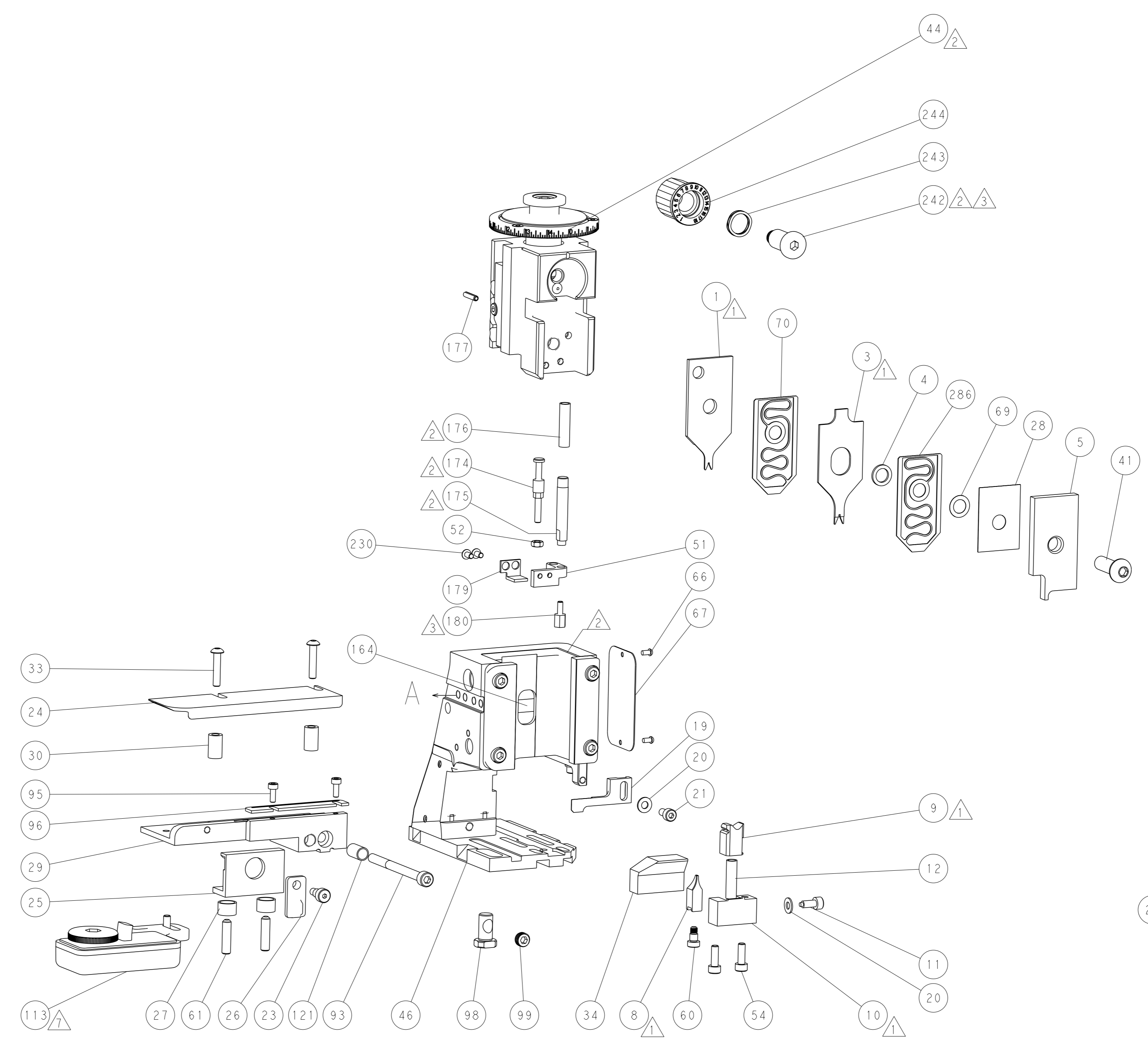


DETAIL A

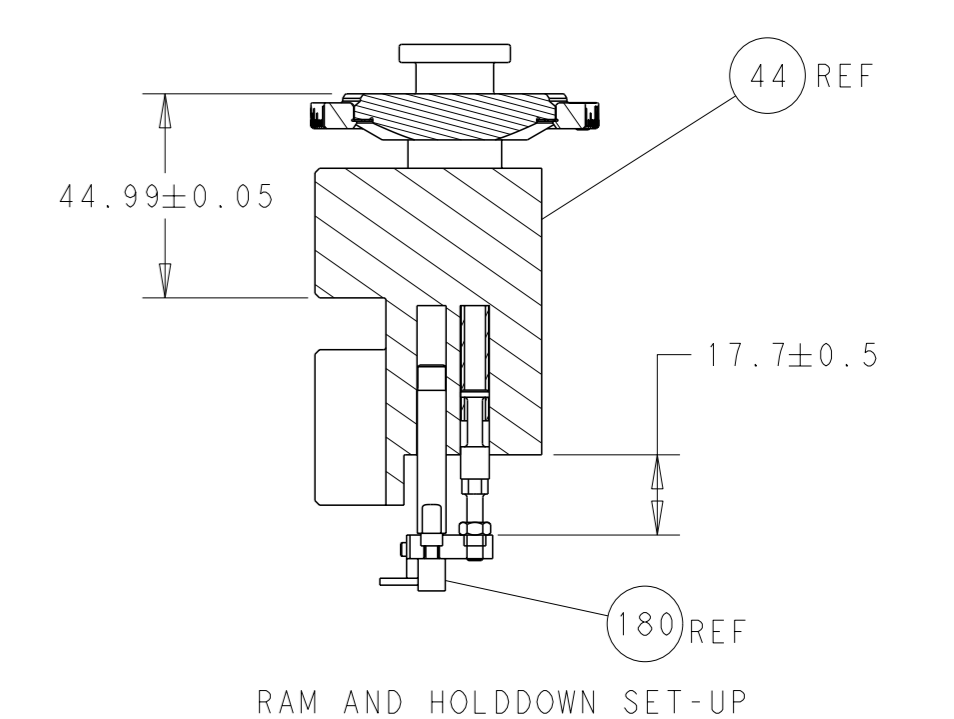
CAM POSITION



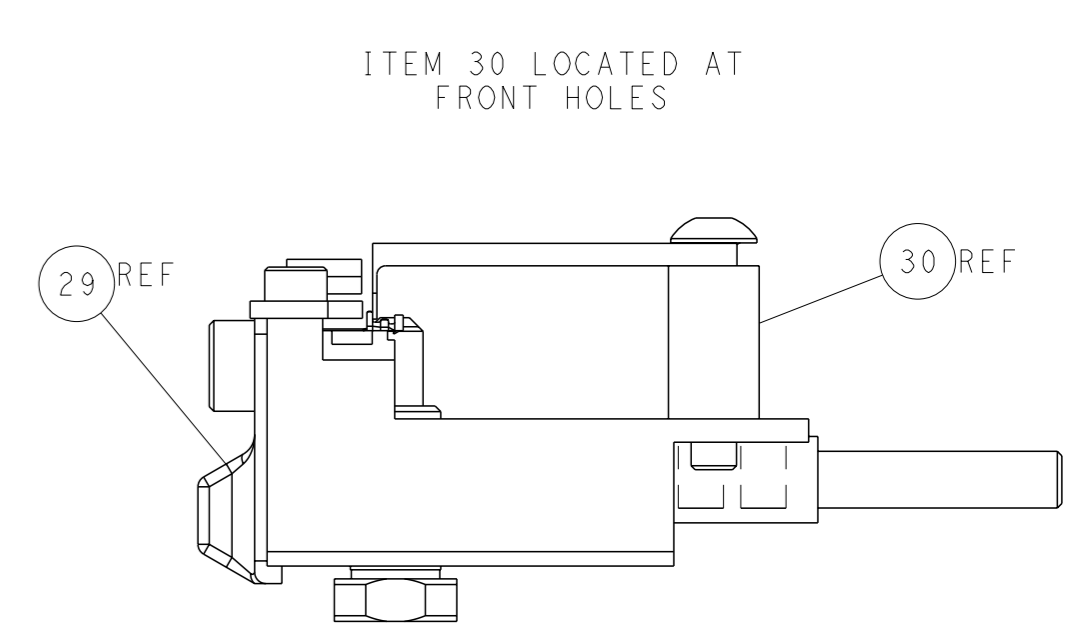
AIR FEED



TERMINAL SUPPORT LOCATION



RAM AND HOLDDOWN SET-UP



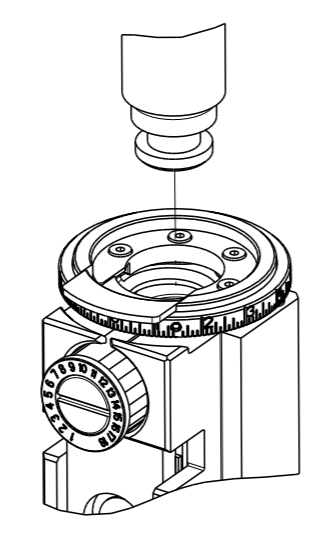
FEED TRACK POSITION
GUIDE BY INSULATION BARREL

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:		OWN		NAME	
mm	0 PLC	±		R. HUANG	22FEB2017	STE TE Connectivity	
	1 PLC	±		CHEK	22FEB2017	Harrisburg, PA 17105-3608	
	2 PLC	±		L. ZHANG			
	3 PLC	±		APVD			
	4 PLC	±		L. ZHANG	22FEB2017		
	ANGLES	±	*				
MATERIAL				Customer Accessible Production Drawing	SCALE	SHEET	REV
					1:2	2 of 4	F

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2836628-2	F	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2836628-7	B	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	0.80 mm [.031]	F
INSUL	0.95 mm [.037]	F
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION
TERMINAL NAME: WIRE TO BOARD SOCKET, TERMINAL.		
WIRE STRIP LENGTH 0.90-1.30 mm [.035-.051 IN]		INSULATION DIAMETER RANGE ∅0.90-1.00 mm [.035-.039 IN]
TERMINAL APPLICATION SPECIFICATION 114-57016	-	-
TERMINALS APPLIED $\triangle 5 \nabla 6 \nabla 7$		
TE TERMINAL 1734193-1	TE TERMINAL 440147-2	TE TERMINAL TE TERMINAL

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
28 AWG OR 0.08mm2	0.535+/-0.025 [.021+/-0.001]	7.2
30 AWG OR 0.05mm2	0.505+/-0.025 [.020+/-0.001]	7.4
32 AWG OR 0.03mm2	0.485+/-0.025 [.019+/-0.001]	7.7

- $\triangle 1$ RECOMMENDED SPARE PARTS
- $\triangle 2$ REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- $\triangle 3$ APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 180. APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242.
- $\triangle 4$ 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.
- $\triangle 5$ TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- $\triangle 6$ THIS APPLICATOR DOES NOT CUT CARRIER STRIP.
- $\triangle 7$ 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.

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

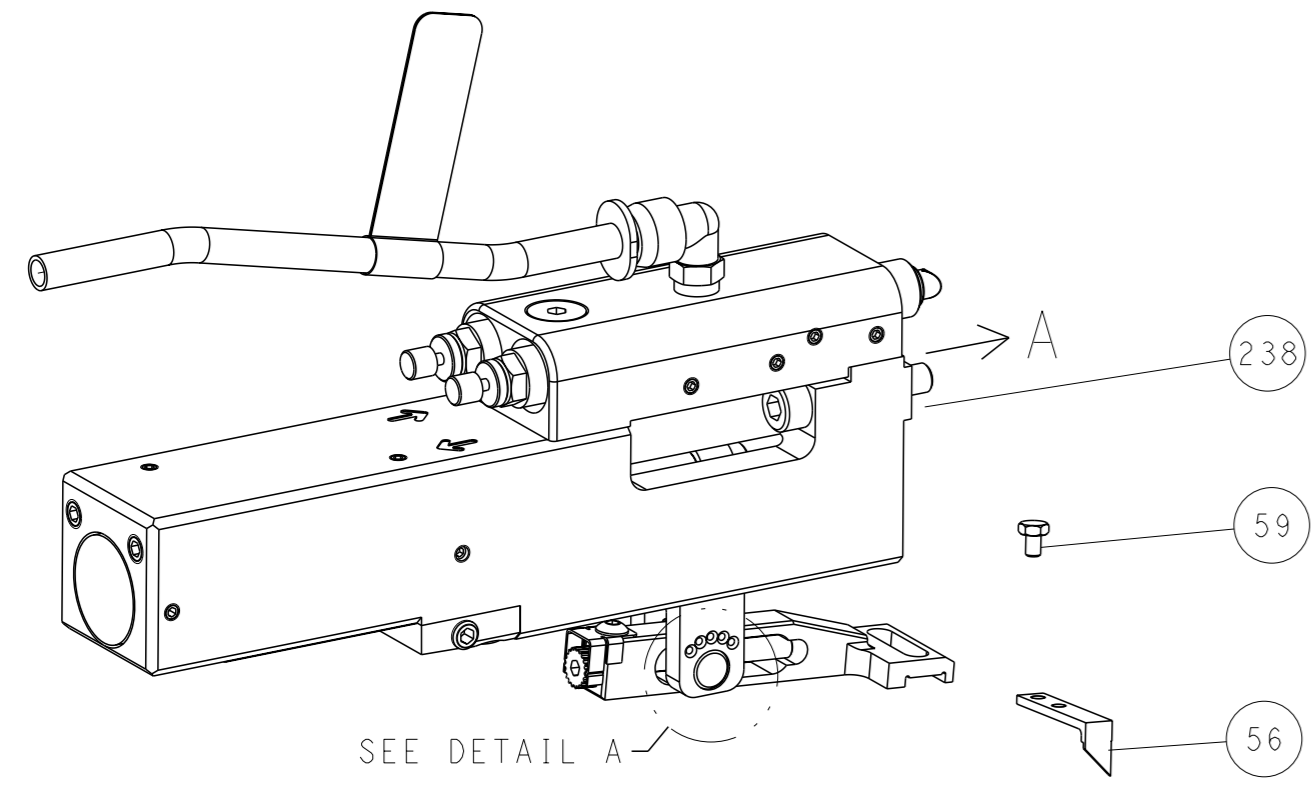
-	1	2-2119791-2	DEPRESSOR, WIRE	286
-	1	2119082-5	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	2119083-1	RETAINER, INSULATION DIAL	242
$\triangle 3$	1	2844940-1	AIR FEED MODULE	238
-	2	1-2079383-0	SCR, BHSC, RoHS (M3 X 6)	230
$\triangle 3$	1	1-1752354-3	STANDOFF, HOLD-DOWN	180
-	1	2-1633764-2	HOLD DOWN, TERMINAL	179
-	1	6-993111-6	PIN, SLOTTED SPRING 3.0 X 14.0	177
-	1	8-22280-7	SPRING, COMPRESSION	176
-	1	1752353-2	GUIDE PIN, HOLDDOWN	175
-	1	1901680-2	GUIDE PIN, HOLDDOWN	174
-	REF	994970-2	COUNTER, MAGNETIC	164
-	1	2119641-2	FEED CAM, AIR FEED	151
-	1	2161425-2	SCREW, SHOULDER	144
-	2	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	143
-	1	3-1803583-0	APPLICATOR BASIC ASSEMBLY, SF	141
-	1	1803516-1	RAM ASSEMBLY, SF PACIFIC	140
-	1	1-22281-8	SPRING, COMPRESSION	121
$\triangle 7$	1	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113
-	1	2844908-1	SCREW, LOCKING	99
-	1	2844907-1	POST, LOCKING	98
-	1	1-690438-0	FRONT STRIP GUIDE	96
-	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	95
-	1	2168083-6	SCR, SKT HD CAP, RoHS, M5 X 6.5	93
-	1	1803607-3	DOCUMENTATION PACKAGE	71
-	1	2-2119791-2	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
-	2	2-18032-5	SCR, SET, FLT PNT, M5 X 20.0	61
-	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	1	1338685-1	PAWL, FEED	56
-	1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52
-	1	1901681-8	HOLDDOWN, TERMINAL	51
-	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
-	1	2-1752356-5	SUPPORT, TERMINAL	34
-	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2-2844962-3	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	2-2844938-0	PLATE, STRIP GUIDE	29
-	1	455888-3	SPACER, CRIMPER	28
-	2	22283-1	SPRING, COMPRESSION	27
-	1	356835-1	LEVER, DRAG RELEASE	26
-	1	240792-1	DRAG, TERMINAL	25
-	1	1320928-2	STRIP GUIDE	24
-	1	980371-4	SCR, SKT HD SHLDR 5.0 DIA X 6.0	23
-	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
-	2	1-18028-2	WASHER, FLAT, REG M4	20
-	1	2119533-4	STRIPPER, SIDE FEED	19
-	1	3-22280-3	SPRING, COMPRESSION	12
-	1	1-356885-4	STOP, SHEAR	11
$\triangle 1$	1	2119805-1	SHEAR HOLDER, FRONT	10
$\triangle 1$	1	1803095-6	FLOATING SHEAR, FRONT	9
$\triangle 1$	1	1803437-2	ANVIL, COMBINATION	8
-	-	-	-	7
-	-	-	-	6
-	1	2-2119757-7	DEPRESSOR, SHEAR	5
-	1	2-238011-0	BLOCK, CRIMPER SPACER	4
$\triangle 1$	1	1803559-1	CRIMPER, INSULATION F PREMIUM	3
-	-	-	-	2
$\triangle 1$	1	1803558-1	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)

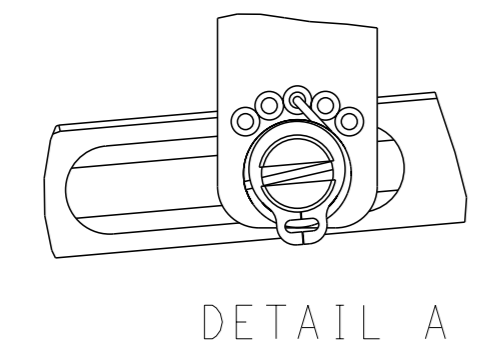
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		OWN L. HUANG 22FEB2017	CHK L. ZHANG 22FEB2017	APVD L. ZHANG 22FEB2017		NAME Ocean Side Feed Applicator	
		0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH ±		APPLICATION SPEC PRODUCT SPEC RESTRICTED TO		SIZE A1 00779 ©=2836628		SCALE 1:2	
MATERIAL				WEIGHT		CUSTOMER ACCESSIBLE PRODUCTION DRAWING		SCALE 1:2 SHEET 3 OF 4 REV F	

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

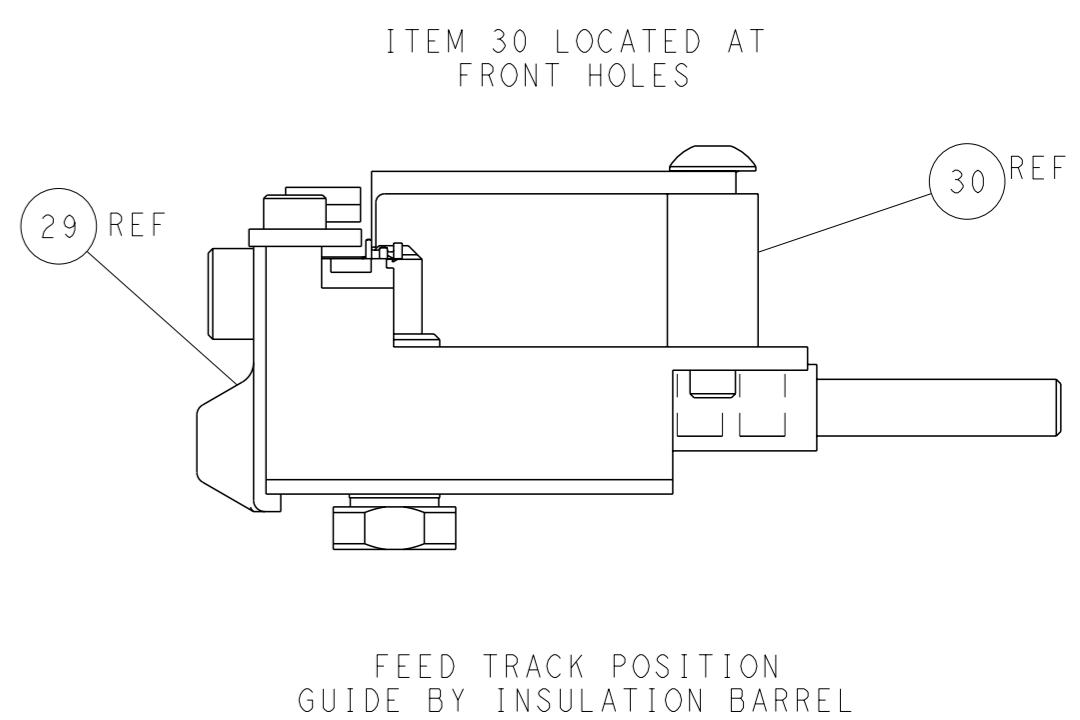
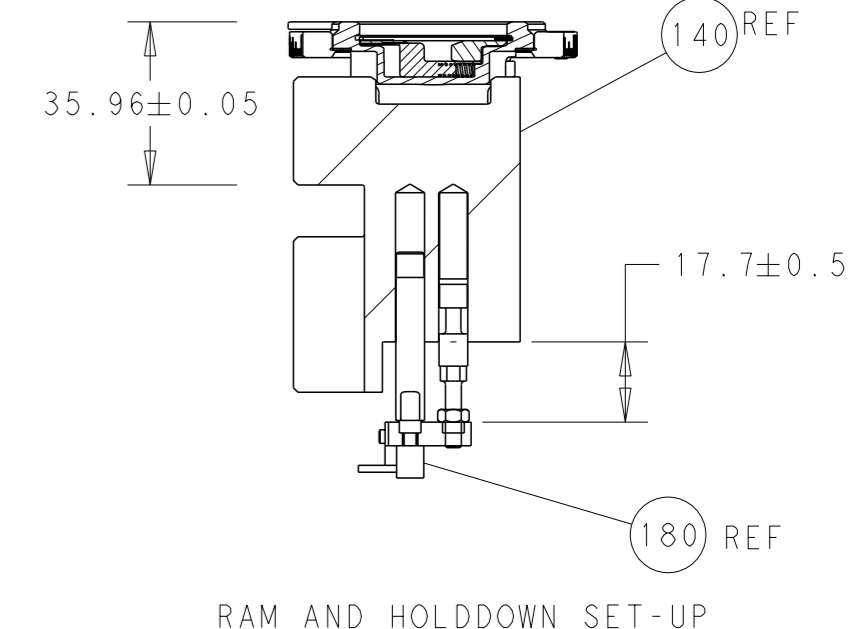
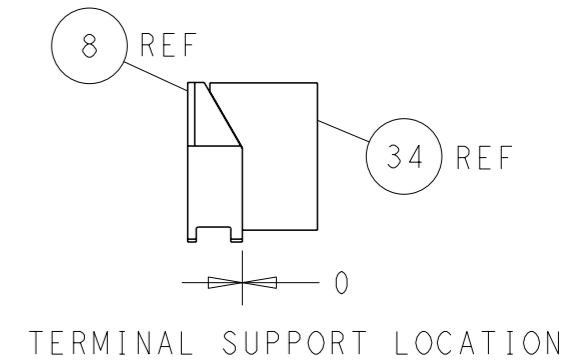
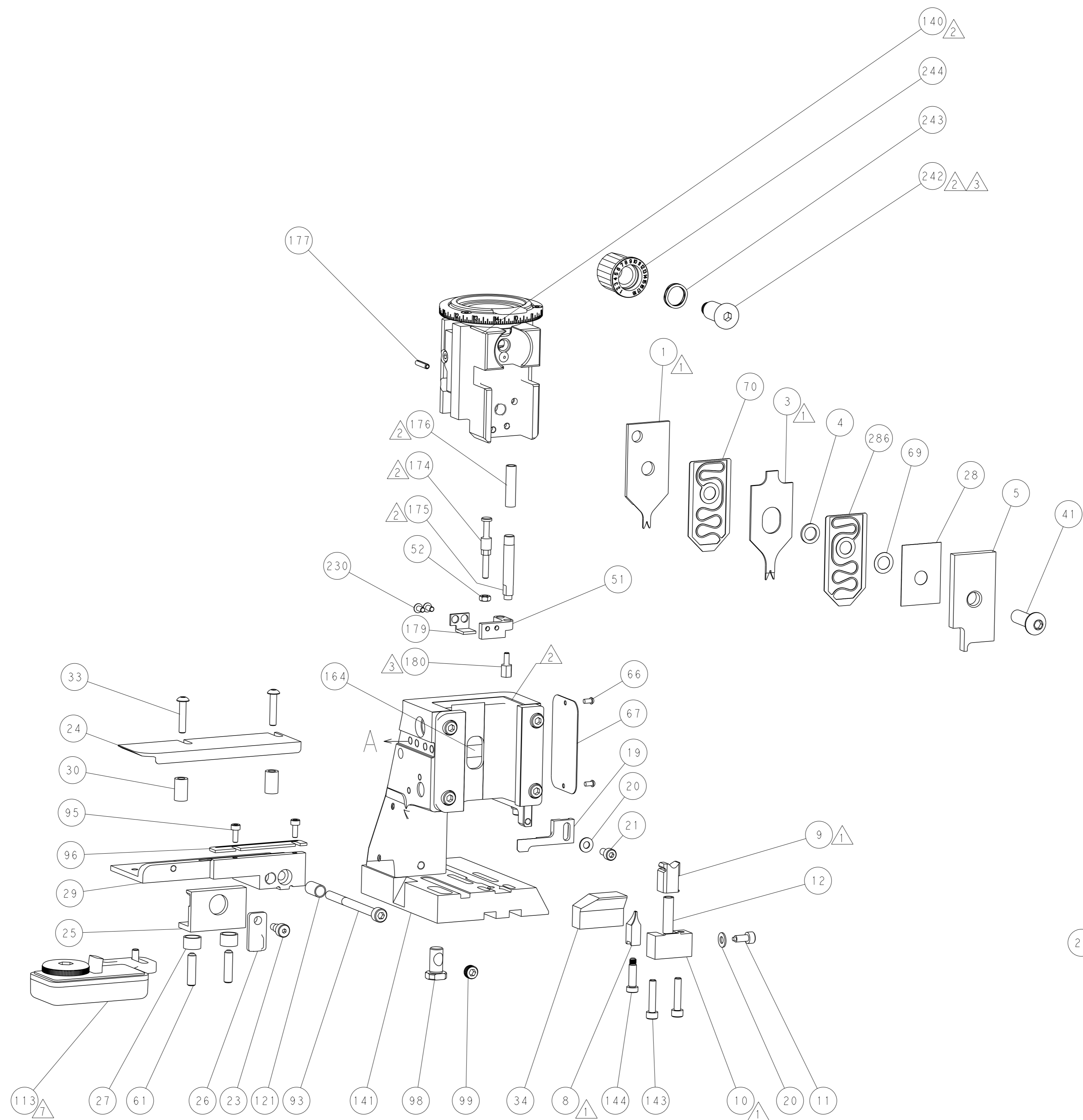
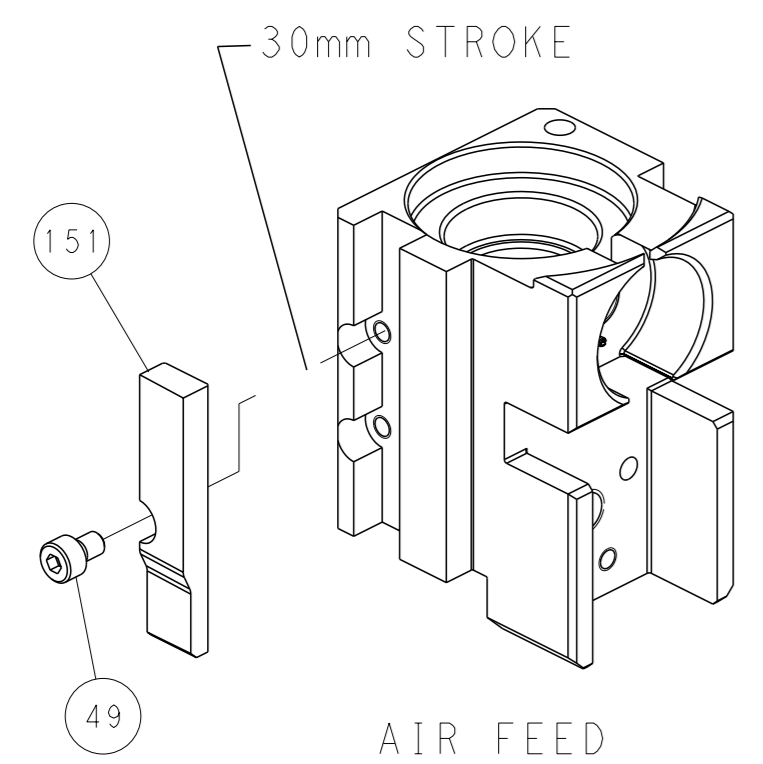
FEED TYPE PNEUMATIC



FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



CAM POSITION



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>		DWN: K. HUANG 22FEB2017 CHK: L. ZHANG 22FEB2017 APVD: L. ZHANG 22FEB2017	TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH ±		NAME: Ocean Side Feed Applicator PRODUCT SPEC: - APPLICATION SPEC: - WEIGHT: - SCALE: 1:2	SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2836628 SHEET 4 OF 4 REV F
MATERIAL: - FINISH: -		Customer Accessible Production Drawing	