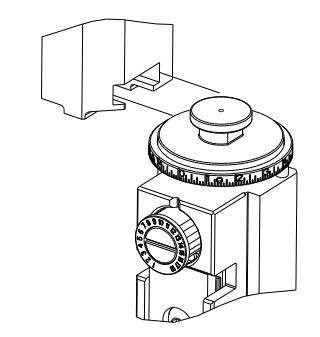


| PART NUMBER | REVISION | DESCRIPTION | FEED TYPE |
|-------------|----------|---------------------------------|-----------|
| 2836630-2 | C | FINE CRIMP HEIGHT ADJUST | PNEUMATIC |
| 7-2836630-2 | C | PNEUMATIC AND CRIMP TOOLING KIT | PNEUMATIC |
| 7-2836630-7 | A | CRIMP TOOLING KIT | - |

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER

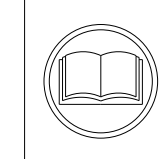


| APPLICATOR DATA | | |
|-----------------|----------------|------|
| CRIMP | SIZE | TYPE |
| WIRE | 1.17 mm [.046] | F |
| INSUL | 1.78 mm [.070] | F |

APPLICATOR INSTRUCTIONS 408-35042

| TERMINAL DATA: LANDWIN TERMINAL TE CRIMP SPECIFICATION | | | |
|--|------------------|---------------------------|------------------|
| TERMINAL NAME: 2.5mm PITCH BOARD-IN | | | |
| WIRE STRIP LENGTH | | INSULATION DIAMETER RANGE | |
| 1.95-2.71 mm [.077-.107 IN] | | ∅ 1.8mm MAX | |
| TERMINAL APPLICATION SPECIFICATION | NONE | - | - |
| TERMINALS APPLIED | | | |
| TE TERMINAL | LANDWIN TERMINAL | TE TERMINAL | LANDWIN TERMINAL |
| 2303722-1 | 2509T022R | | |

| WIRE SIZE | CRIMP HEIGHT mm [INCH] | CRIMP HEIGHT REFERENCE SETTING |
|-----------|-------------------------------|--------------------------------|
| 22 AWG | 0.89 +/- 0.05 [.035 +/- .002] | 7.0 |
| 24 AWG | 0.79 +/- 0.05 [.031 +/- .002] | 8.2 |
| 26 AWG | 0.73 +/- 0.05 [.029 +/- .002] | 8.8 |
| 28 AWG | 0.70 +/- 0.05 [.028 +/- .002] | 9.2 |



- 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 PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
 - TERMINAL LUBRICATION IS RECOMMENDED.
7. 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.

| LOC | DIST | REVISIONS | | | | | |
|-----|------|-----------|-----|---------------|-----------|-----|------|
| A | 66 | P | LTN | DESCRIPTION | DATE | OWN | APVD |
| | | A | | RELEASED | 23MAR2017 | MR | TE |
| | | B | | ECR-19-008468 | 29MAY2019 | FJ | CT |
| | | C | | ECR-21-002179 | 22FEB2021 | FZ | TE |

| | | | | | | |
|---|-----|-----|-------------|-------------------------------------|-------------------------------|---|
| - | 1 | 1 | 2119641-1 | FEED CAM, AIR FEED | 248 | |
| - | 1 | 1 | 2119082-8 | 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 | 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 | 2119791-5 | 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 | 1338685-1 | PAWL, FEED | 56 | |
| - | 4 | 4 | 2168083-3 | SCR, SKT HD CAP, RoHS, M4 X 12.0 | 54 | |
| - | 1 | 1 | 18023-9 | SCR, SKT HD CAP M4 X 6.0 | 49 | |
| - | 1 | 1 | 1803583-9 | 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 | 1752356-1 | SUPPORT, TERMINAL | 34 | |
| - | 2 | 2 | 2079383-5 | SCR, BHSC, RoHS (M4 X 20) | 33 | |
| - | 2 | 2 | 2-2844962-4 | SPACER, CYLINDRICAL, STRIP GUIDE | 30 | |
| - | 1 | 1 | 2844992-1 | ASSEMBLY, STRIP GUIDE | 29 | |
| - | 1 | 1 | 455888-5 | 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 | 1803095-3 | FLOATING SHEAR, FRONT | 9 | |
| - | 1 | 2 | 1 | 5-1803252-9 | ANVIL, COMBINATION | 8 |
| - | - | - | - | - | 7 | |
| - | - | - | - | - | 6 | |
| - | 1 | 1 | 2119757-6 | DEPRESSOR, SHEAR | 5 | |
| - | 1 | 1 | 2-238011-3 | BLOCK, CRIMPER SPACER | 4 | |
| - | 1 | 2 | 1 | 3-1633962-3 | CRIMPER, INSULATION F PREMIUM | 3 |
| - | 1 | 1 | 455888-6 | SPACER, CRIMPER | 2 | |
| - | 1 | 2 | 1 | 3-1803224-9 | CRIMPER, WIRE | 1 |

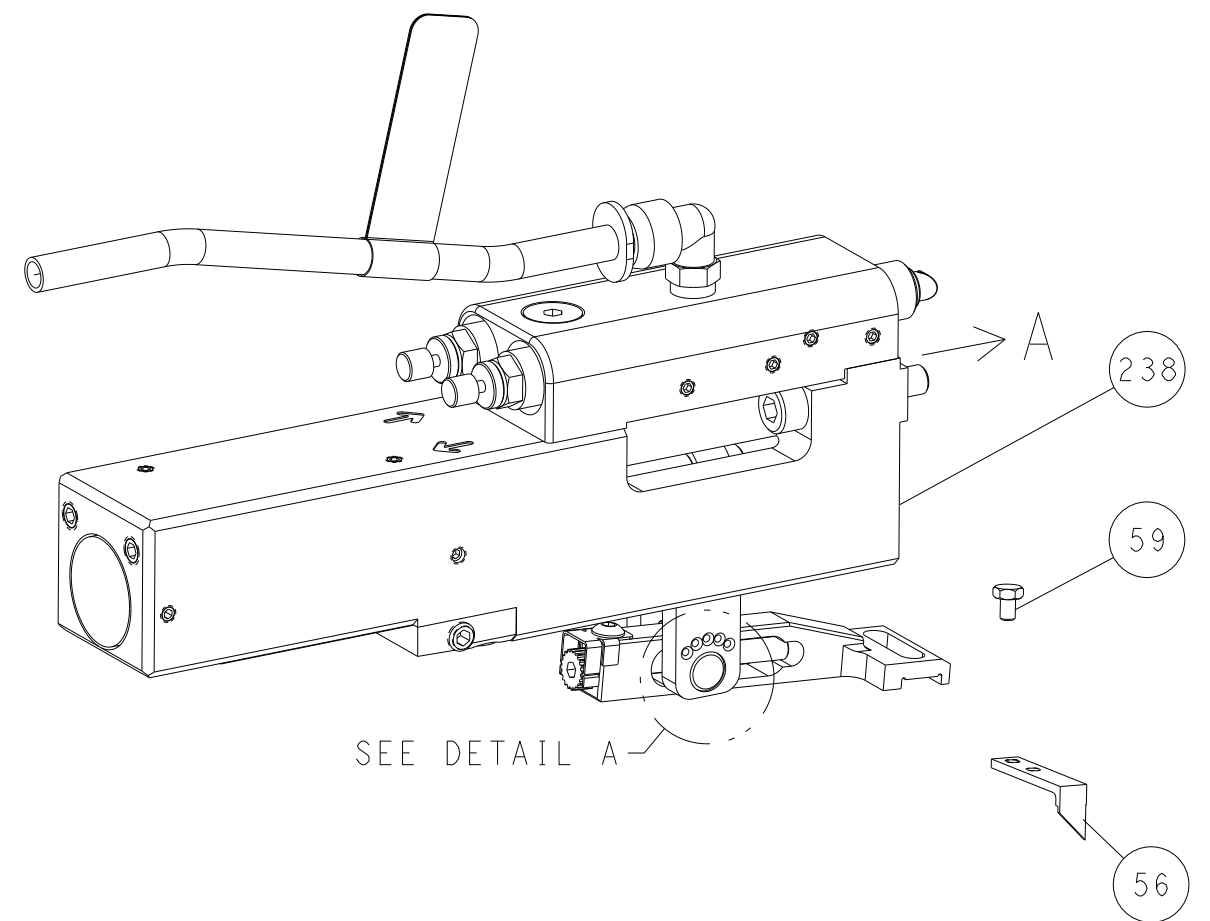
ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

| | | | | | | | |
|--|--|---|--|--|--------------|--|--|
| DIMENSIONS: mm | | TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ° FINISH | | OWN M. RILEY 14FEB2017 CHK T. ELBIN 14FEB2017 APVD J. DEGRANGE 14FEB2017 PRODUCT SPEC APPLICATION SPEC WEIGHT MATERIAL | | NAME Ocean Side Feed Applicator SIZE CAGE CODE DRAWING NO A1 00779 C=2836630 RESTRICTED TO | |
| Customer Accessible Production Drawing | | | | SCALE 1:2 | SHEET 1 OF 4 | REV C | |

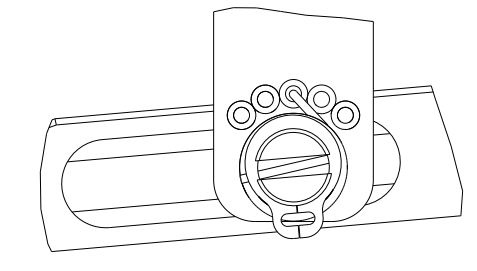
| LOC | DIST | REVISIONS | | | |
|-----|------|-------------|------|-----|------|
| P | LTN | DESCRIPTION | DATE | OWN | APVD |
| A | 66 | SEE SHEET 1 | - | - | - |
| | | | | | |
| | | | | | |

FEED TYPE

PNEUMATIC

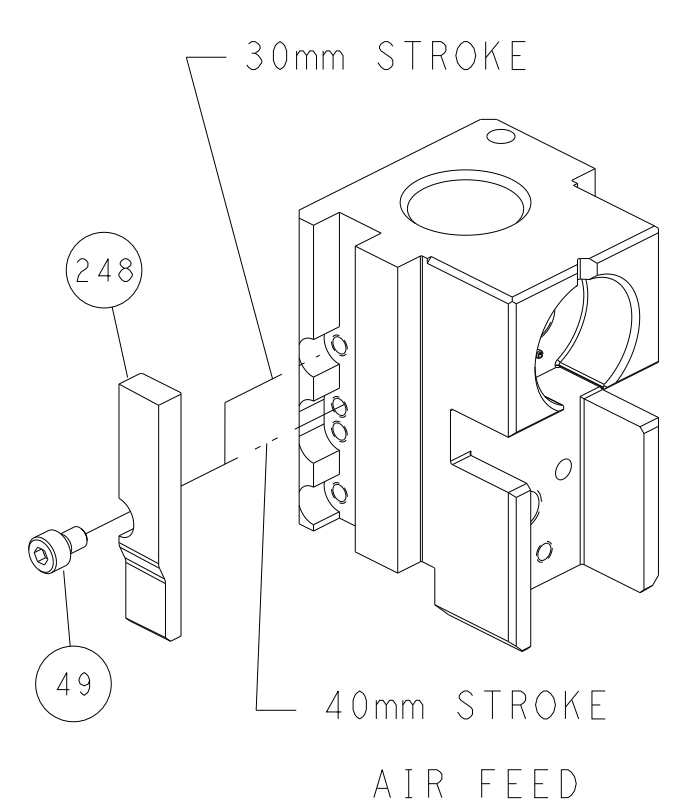


FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)

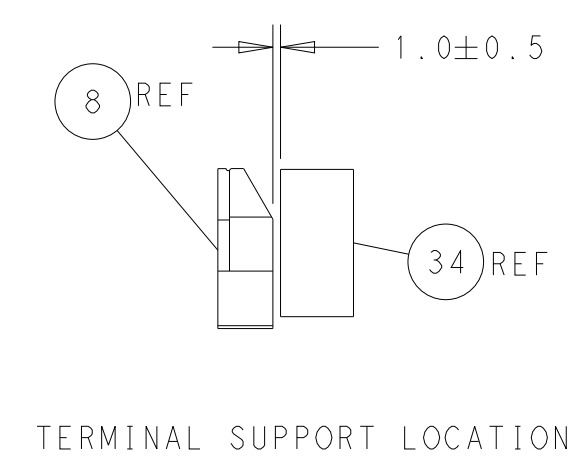
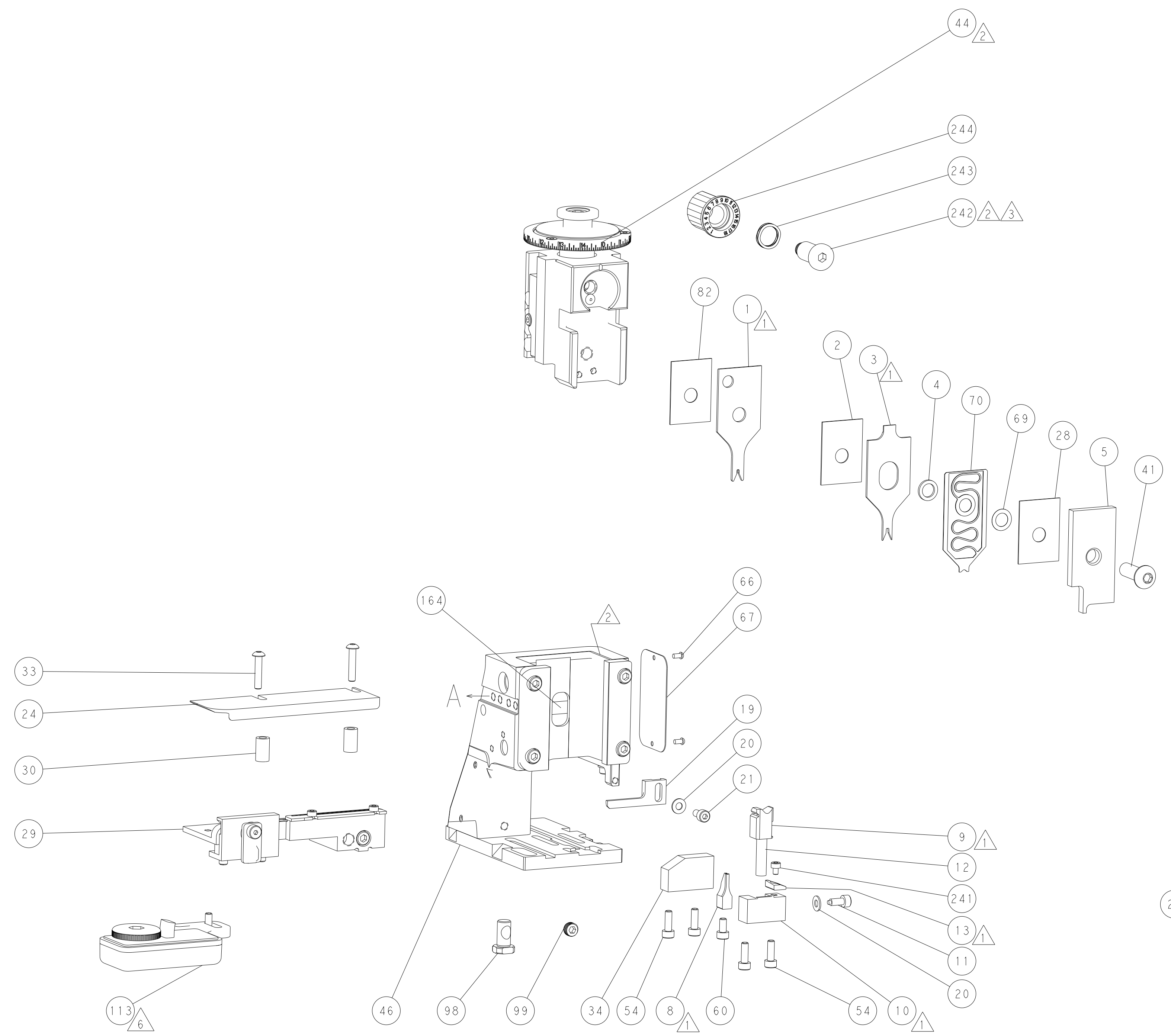


DETAIL A

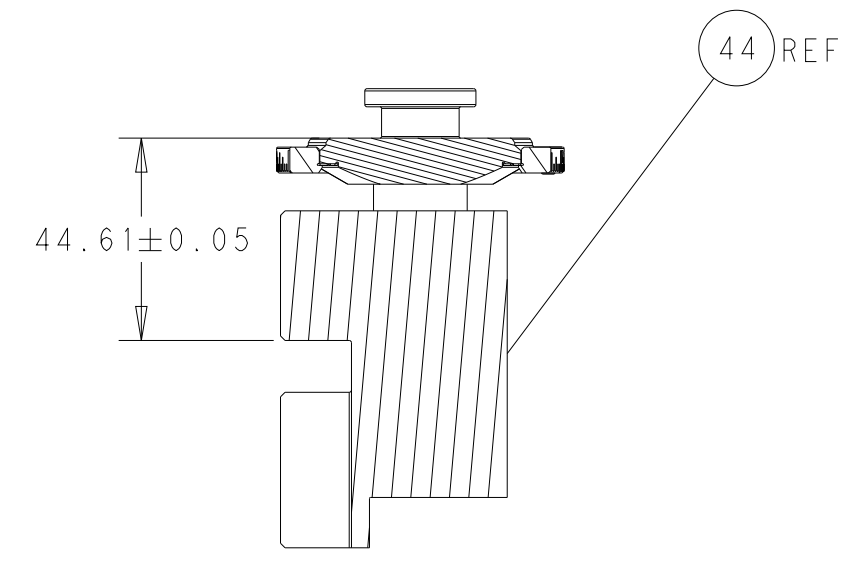
CAM POSITION



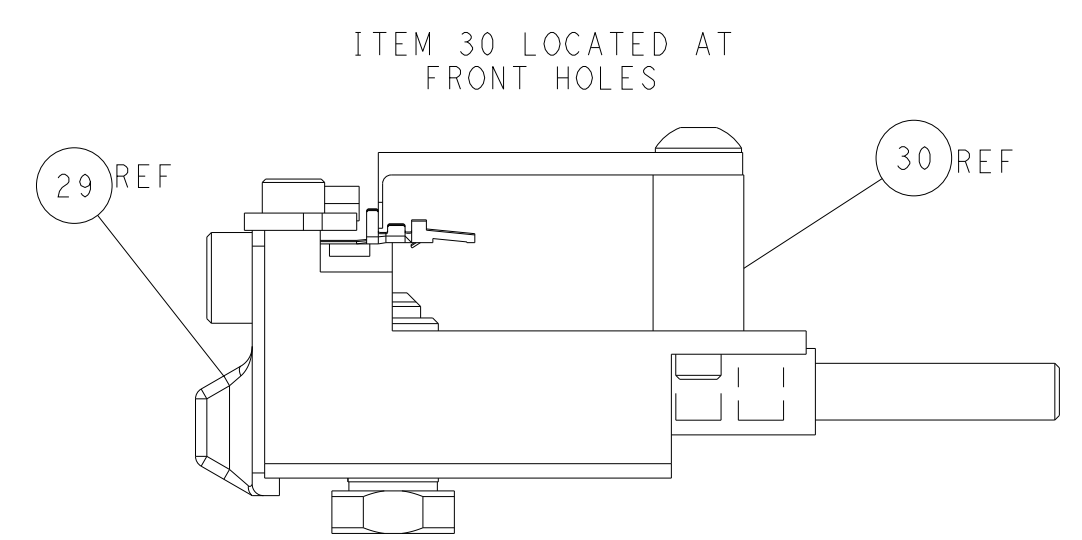
AIR FEED



TERMINAL SUPPORT LOCATION



RAM SET-UP



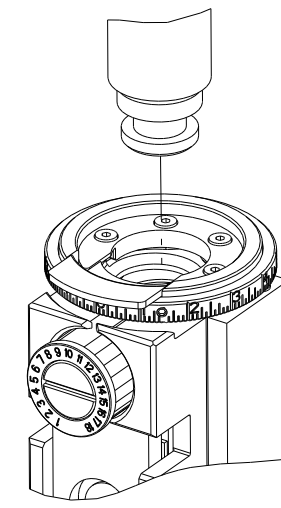
FEED TRACK POSITION GUIDE BY INSULATION BARREL

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

| | | | |
|--|---|--|--|
| <small>THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION. ALL RIGHTS RESERVED. THIS DRAWING IS CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION. IT IS THE PROPERTY OF TYCO ELECTRONICS CORPORATION AND IS NOT TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, INCLUDING PHOTOCOPYING, RECORDING, OR BY ANY INFORMATION STORAGE AND RETRIEVAL SYSTEM, WITHOUT THE WRITTEN PERMISSION OF TYCO ELECTRONICS CORPORATION.</small> | | DWN M. RILEY 14FEB2017 CHK T. ELBIN 14FEB2017 APVD J. DEGRANGE 14FEB2017 | 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 SIZE CAGE CODE DRAWING NO. RESTRICTED TO A1 00779 C=2836630 | WEIGHT SCALE 1:2 SHEET 2 OF 4 REV C | Customer Accessible Production Drawing |

| 8 | 7 | 6 | 5 | 4 | 3 | 2 | 1 |
|--|----------|--------------------------|-----------|----|---|---|---|
| THIS DRAWING IS UNPUBLISHED. | | RELEASED FOR PUBLICATION | | 20 | | | |
| COPYRIGHT 20 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED. | | | | | | | |
| PART NUMBER | REVISION | DESCRIPTION | FEED TYPE | | | | |
| 2-2836630-2 | C | FINE CRIMP HEIGHT ADJUST | PNEUMATIC | | | | |
| 7-2836630-7 | A | CRIMP TOOLING KIT | - | | | | |

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



| APPLICATOR DATA | | |
|--------------------------------------|----------------|------|
| CRIMP | SIZE | TYPE |
| WIRE | 1.17 mm [.046] | F |
| INSUL | 1.78 mm [.070] | F |
| APPLICATOR INSTRUCTIONS 408-35042 | | |

| | | | |
|-------------------------------------|------------------|---------------------------|------------------|
| TERMINAL DATA: LANDWIN TERMINAL | | TE CRIMP SPECIFICATION | |
| TERMINAL NAME: 2.5mm PITCH BOARD-IN | | | |
| WIRE STRIP LENGTH | | INSULATION DIAMETER RANGE | |
| 1.95-2.71 mm [.077-.107 IN] | | 1.8mm MAX | |
| TERMINAL APPLICATION SPECIFICATION | NONE | - | - |
| TERMINALS APPLIED | | | |
| TE TERMINAL | LANDWIN TERMINAL | TE TERMINAL | LANDWIN TERMINAL |
| 2303722-1 | 2509T022R | | |

| WIRE SIZE | CRIMP HEIGHT mm [INCH] | CRIMP HEIGHT REFERENCE SETTING |
|-----------|-------------------------------|--------------------------------|
| 22 AWG | 0.89 +/- 0.05 [.035 +/- .002] | 7.0 |
| 24 AWG | 0.79 +/- 0.05 [.031 +/- .002] | 8.2 |
| 26 AWG | 0.73 +/- 0.05 [.029 +/- .002] | 8.8 |
| 28 AWG | 0.70 +/- 0.05 [.028 +/- .002] | 9.2 |

- 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 PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
 - TERMINAL LUBRICATION IS RECOMMENDED.
7. 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.

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

| | | | | | |
|---|-----|-------------|-------------------------------------|-------------------------------|---------|
| - | 1 | 2119082-8 | 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 | 1-1803583-0 | APPLICATOR BASIC ASSEMBLY, SF | 141 | |
| - | 1 | 1803516-1 | RAM ASSEMBLY, SF PACIFIC | 140 | |
| - | 1 | 2119955-1 | ASSY, LUBRICATOR, SIDE FEED | 113 | |
| - | 1 | 2844908-1 | SCREW, LOCKING | 99 | |
| - | 1 | 2844907-1 | POST, LOCKING | 98 | |
| - | 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 | 1338685-1 | PAWL, FEED | 56 | |
| - | 1 | 18023-9 | SCR, SKT HD CAP M4 X 6.0 | 49 | |
| - | 1 | 1803602-1 | SCR, BHSC, RoHS (M8 X 25) | 41 | |
| - | 1 | 1752356-1 | SUPPORT, TERMINAL | 34 | |
| - | 2 | 2079383-5 | SCR, BHSC, RoHS (M4 X 20) | 33 | |
| - | 2 | 2-2844962-4 | SPACER, CYLINDRICAL, STRIP GUIDE | 30 | |
| - | 1 | 2844992-1 | ASSEMBLY, STRIP GUIDE | 29 | |
| - | 1 | 455888-5 | SPACER, CRIMPER | 28 | |
| - | 1 | 1320928-2 | STRIP GUIDE | 24 | |
| - | 1 | 2168083-2 | SCR, SKT HD CAP, RoHS, M4 X 8.0 | 21 | |
| - | 2 | 1-18028-2 | WASHER, FLAT, REG M4 | 20 | |
| - | 1 | 2119533-1 | STRIPPER, SIDE FEED | 19 | |
| - | 1 | 2119806-1 | INSERT, SHEAR | 13 | |
| - | 1 | 3-22280-3 | SPRING, COMPRESSION | 12 | |
| - | 1 | 1-356885-4 | STOP, SHEAR | 11 | |
| - | 1 | 2119805-1 | SHEAR HOLDER, FRONT | 10 | |
| - | 1 | 1803095-3 | FLOATING SHEAR, FRONT | 9 | |
| - | 1 | 1 | 5-1803252-9 | ANVIL, COMBINATION | 8 |
| - | - | - | - | 7 | |
| - | - | - | - | 6 | |
| - | 1 | 2119757-6 | DEPRESSOR, SHEAR | 5 | |
| - | 1 | 2-238011-3 | BLOCK, CRIMPER SPACER | 4 | |
| - | 1 | 1 | 3-1633962-3 | CRIMPER, INSULATION F PREMIUM | 3 |
| - | 1 | 1 | 455888-6 | SPACER, CRIMPER | 2 |
| - | 1 | 1 | 3-1803224-9 | CRIMPER, WIRE | 1 |
| - | 77 | -22 | PART NO | DESCRIPTION | ITEM NO |

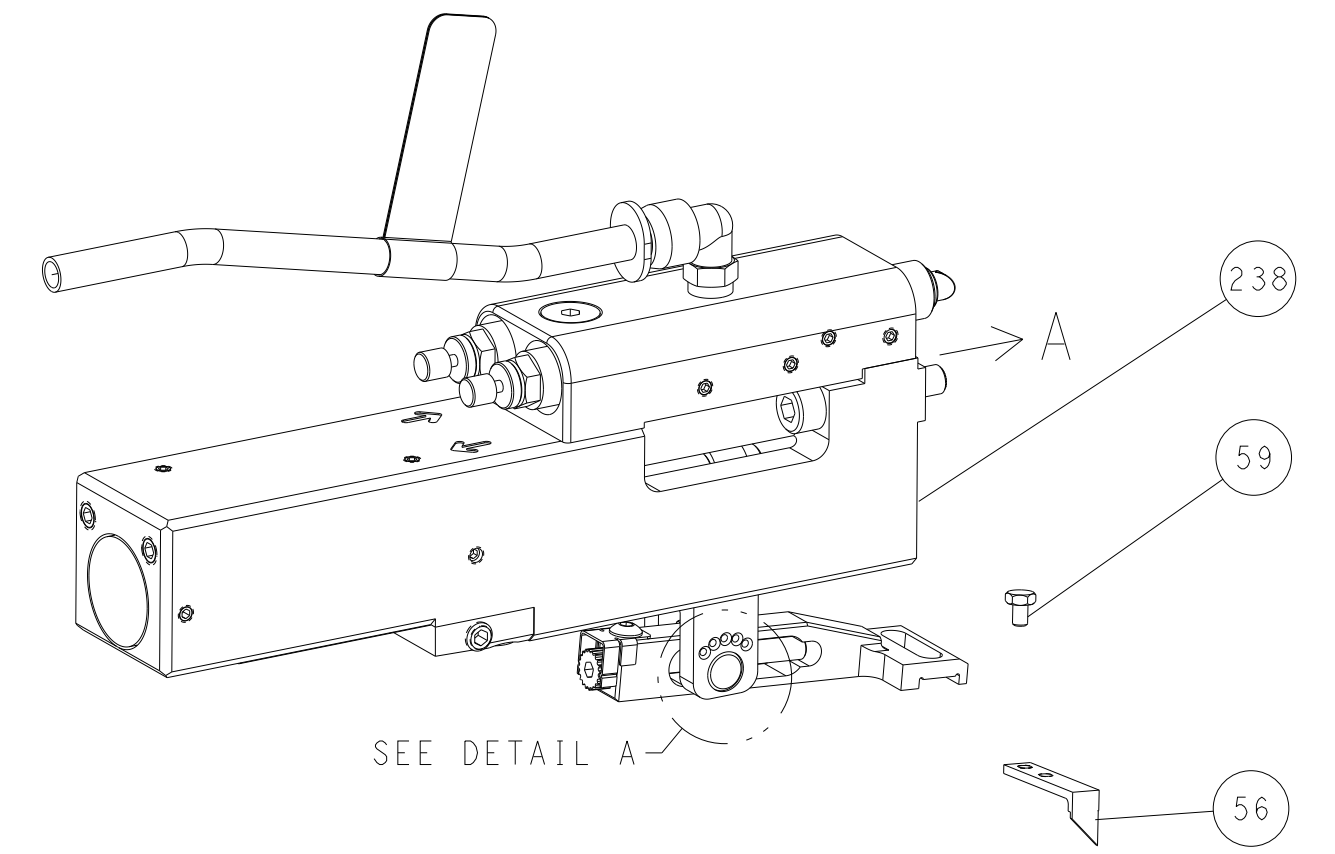
PACIFIC VERSION
Shown on sheets 3 of 4 & 4 of 4
(Atlantic version shown on sheets 1 of 4 & 2 of 4)

| | | | | | | | |
|-------------|---|--|---|--|----------|------------------------------|--|
| DIMENSIONS: | | TOLERANCES UNLESS OTHERWISE SPECIFIED: | | OWN | M. RILEY | 14FEB2017 | TE Connectivity Harrisburg, PA 17105-3608 |
| mm | 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH | ± | ± | CHK | T. ELBIN | 14FEB2017 | |
| MATERIAL | | APVD | | NAME | | Ocean Side Feed Applicator | |
| | | APPLICATION SPEC | | SIZE | | CAGE CODE DRAWING NO | |
| | | WEIGHT | | A1 | | 00779 C=2836630 | |
| | | RESTRICTED TO | | Customer Accessible Production Drawing | | SCALE 1:2 SHEET 3 OF 4 REV C | |

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

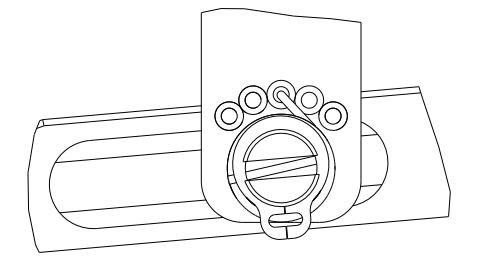
FEED TYPE

PNEUMATIC



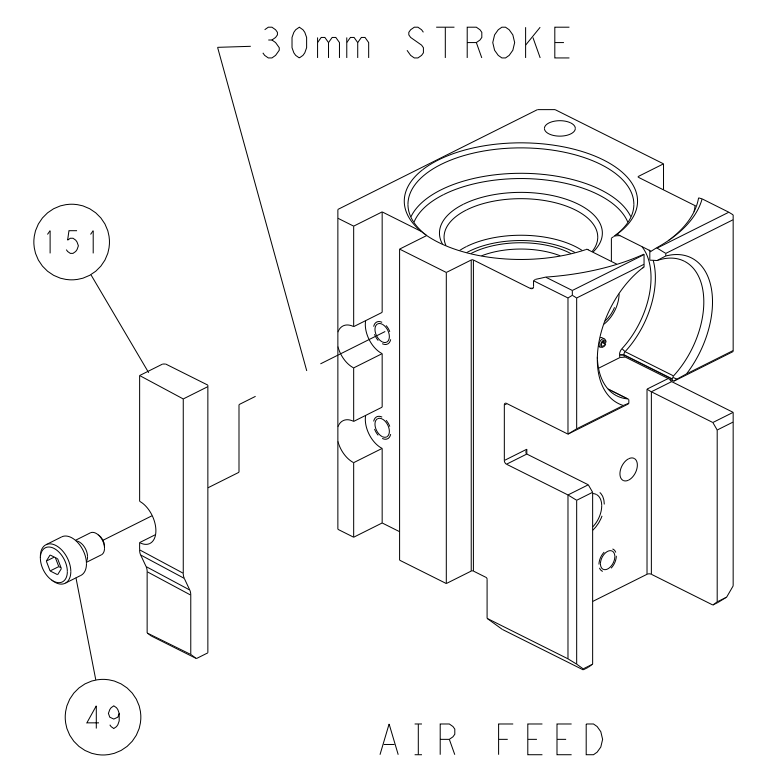
SEE DETAIL A

FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)

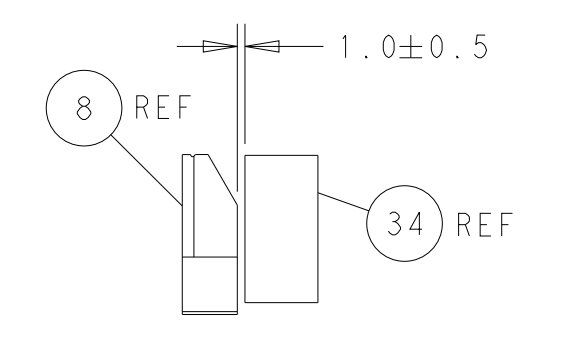
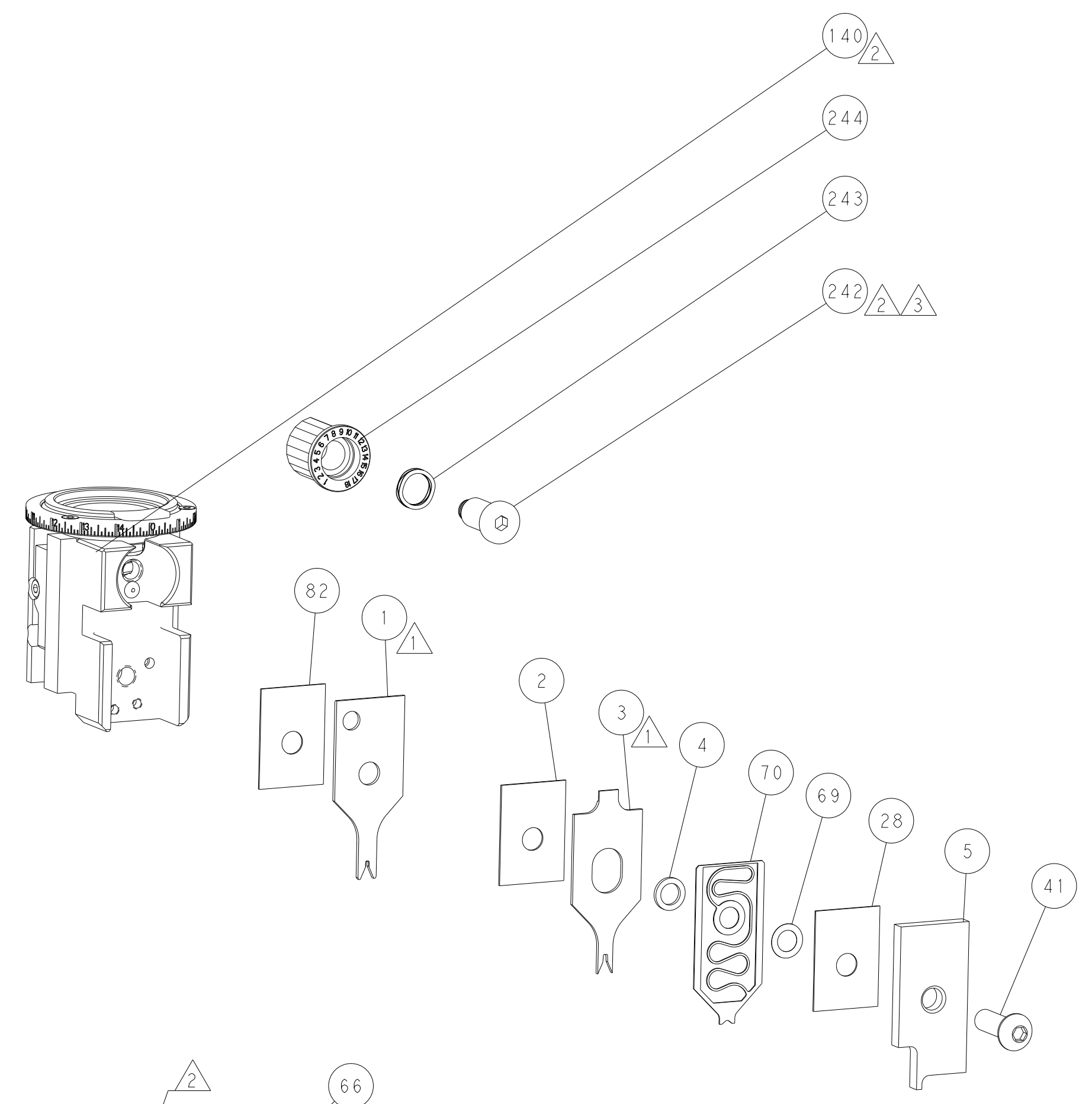


DETAIL A

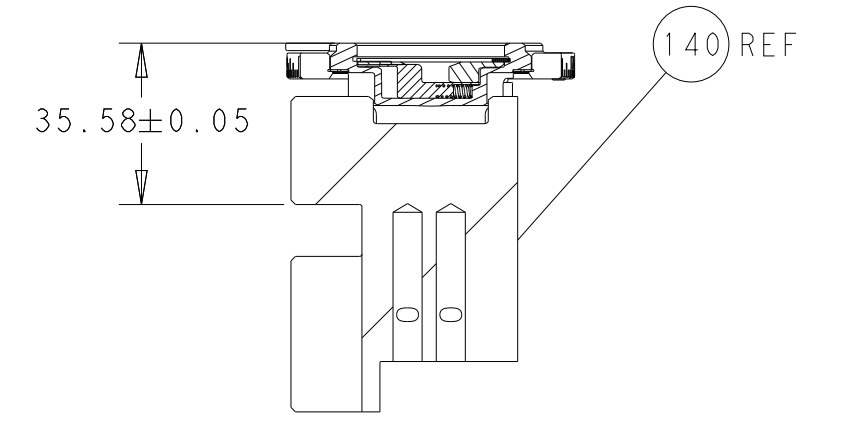
CAM POSITION



AIR FEED

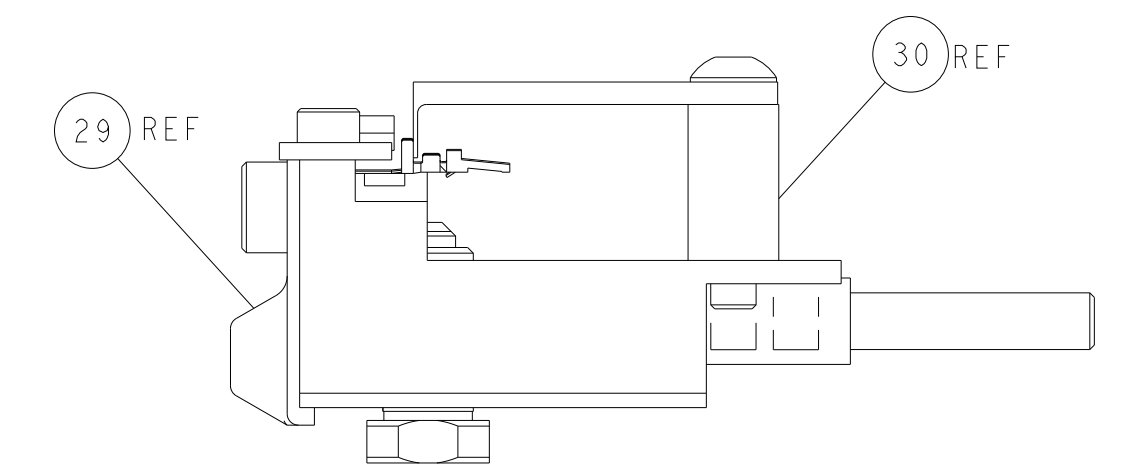


TERMINAL SUPPORT LOCATION

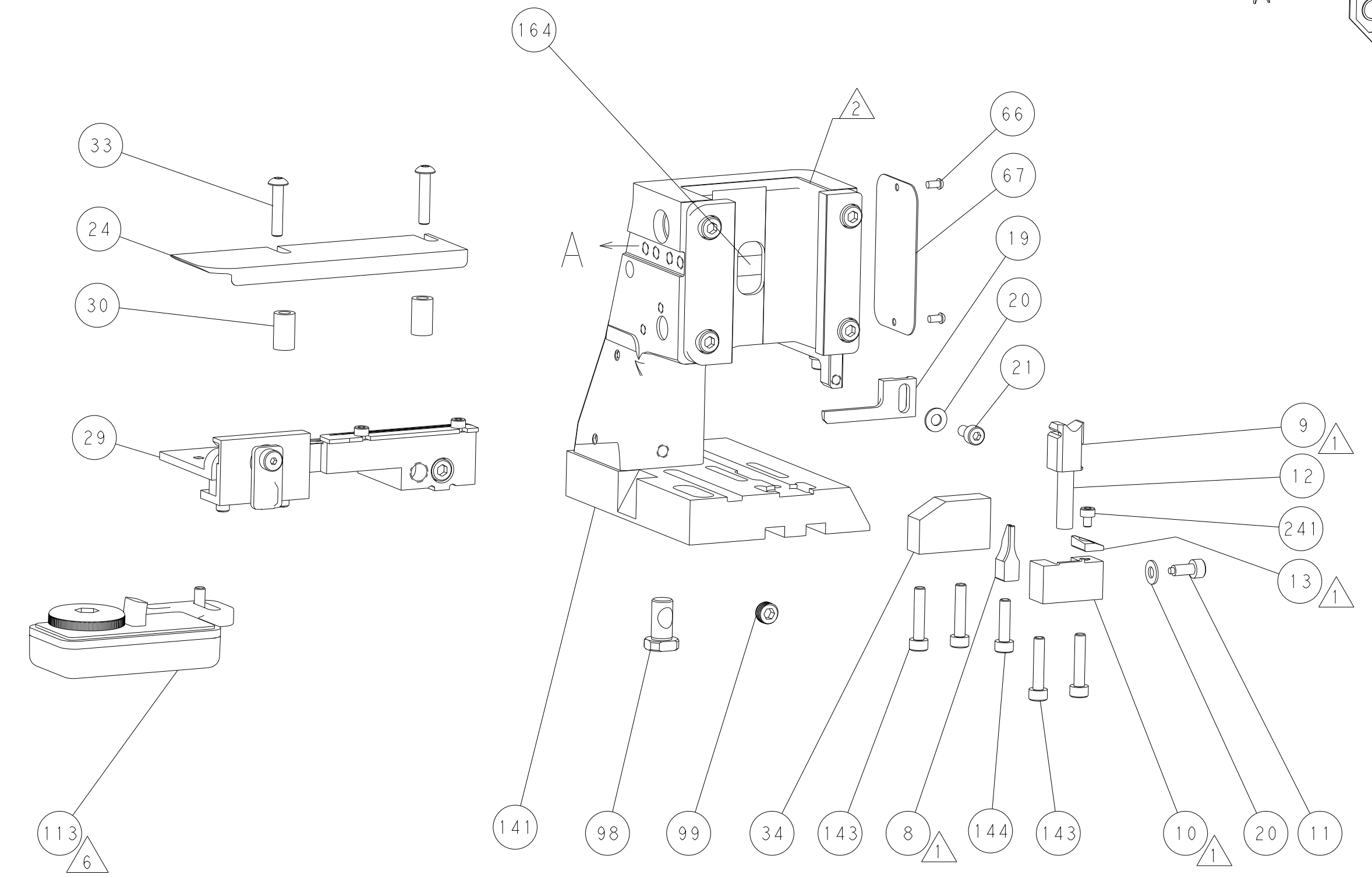


RAM SET-UP

ITEM 30 LOCATED AT FRONT HOLES



FEED TRACK POSITION GUIDE BY INSULATION 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 ± FINISH ± | | NAME Ocean Side Feed Applicator PRODUCT SPEC APPLICATION SPEC SIZE CAGE CODE DRAWING NO. A1 00779 C-2836630 WEIGHT SCALE 1:2 SHEET 4 OF 4 REV C | RESTRICTED TO |
| MATERIAL: | | CUSTOMER ACCESSIBLE PRODUCTION DRAWING | SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION |