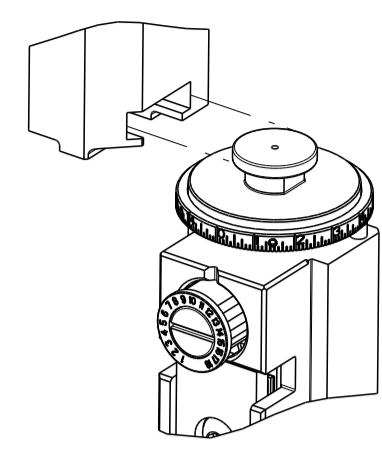


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2836740-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2836740-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2836740-1	B	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2836740-2	B	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2836740-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER

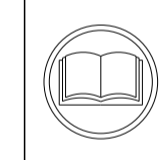


APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.57 mm [.062]	F
INSUL	1.60 mm [.063]	F

APPLICATOR INSTRUCTIONS  
408-35042

TERMINAL DATA: HL TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: TERMINAL			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
3.31-4.07 mm [.130-.160 IN]		Ø1.18-1.57 mm [.046-.062 IN]	
TERMINAL APPLICATION SPECIFICATION	NONE		
TERMINALS APPLIED			
TE TERMINAL	HL TERMINAL	TE TERMINAL	HL TERMINAL
2318272-1	619403		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.50mm2	0.90 +/- 0.05 [.035 +/- .002]	3.0
0.30mm2	0.79 +/- 0.05 [.031 +/- .002]	4.0



- 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. 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.

SET UP GAUGE		LOC	DIST	REVISIONS			
2119599-1		A	66	REV	DATE	BY	CHK
				A	RELEASED	08JUN2017	TB GB
				B	ECR-21-123970	13DEC2021	TB TE

-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248	
-	1	1	1	1	2119082-4	CAM, SNAIL, INSULATION ADJUSTMENT	244	
-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243	
-	1	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	
-	1	1	1	1	2844908-1	SCREW, LOCKING	99	
-	1	1	1	1	2844907-1	POST, LOCKING	98	
-	1	1	1	1	455888-4	SPACER, CRIMPER	82	
-	1	1	1	1	1803607-3	DOCUMENTATION PACKAGE	71	
-	1	1	1	1	2119791-5	DEPRESSOR, WIRE	70	
-	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	
-	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	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	53	
-	1	1	1	1	1803382-1	HOLD DOWN, SPRING LOADED	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	1752356-3	SUPPORT, TERMINAL	34	
-	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33	
-	2	2	2	2	2-2844962-8	SPACER, CYLINDRICAL, STRIP GUIDE	30	
-	1	1	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29	
-	1	1	1	1	1320928-2	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	1803095-6	FLOATING SHEAR, FRONT	9	
-	1	2	2	1	1	2-1803250-9	ANVIL, COMBINATION	8
-	-	-	-	-	-	-	7	
-	-	-	-	-	-	-	6	
-	1	1	1	1	2119757-3	DEPRESSOR, SHEAR	5	
-	1	1	1	1	4-238011-5	BLOCK, CRIMPER SPACER	4	
-	1	2	2	1	1	1-1803260-8	CRIMPER, INSULATION F PREMIUM	3
-	-	-	-	-	-	-	2	
-	1	2	2	1	1	1-456403-3	CRIMPER, WIRE PREMIUM	1
-	77	-72	-71	-2	-1	PART NO	DESCRIPTION	ITEM NO

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:		MATERIAL:		FINISH:	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES ±	FINISH ±

OWN	Y. YIN	26APR2017	TE Connectivity
CHK	G. BAILEY	26APR2017	Harrisburg, PA 17105-3608
APVD	K. ZHANG	26APR2017	
PRODUCT SPEC	Ocean Side Feed Applicator		
APPLICATION SPEC	-		
SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
A1	00779	2836740	-
Customer Accessible Production Drawing			SCALE 1:2 SHEET 1 OF 4 REV B



PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2836740-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2836740-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2836740-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR  
 INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.57 mm [.062]	F
INSUL	1.60 mm [.063]	F

APPLICATOR INSTRUCTIONS  
 408-35042

TERMINAL DATA: HL TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: TERMINAL			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
3.31-4.07 mm [1.30-.160 IN]		Ø1.18-1.57 mm [1.046-.062 IN]	
TERMINAL APPLICATION SPECIFICATION	NONE		
TERMINALS APPLIED			
TE TERMINAL	HL TERMINAL	TE TERMINAL	HL TERMINAL
2318272-1	619403		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.50mm2	0.90 +/- 0.05 [1.035 +/- .002]	3.0
0.30mm2	0.79 +/- 0.05 [1.031 +/- .002]	4.0

- 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.

**\*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.

SET UP GAUGE	LOC	DIST	REVISIONS			
2119599-1	A	66	REV	DATE	BY	APPV
			-	SEE SHEET 1		

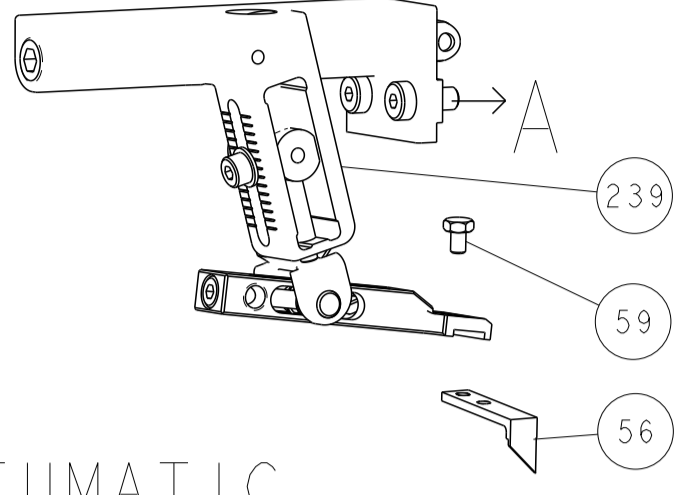
-	1	1	2119082-4	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
-	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	1	-	2844940-1	AIR FEED MODULE	238
-	REF	REF	994970-2	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	2844908-1	SCREW, LOCKING	99
-	1	1	2844907-1	POST, LOCKING	98
-	1	1	455888-4	SPACER, CRIMPER	82
-	1	1	1803607-3	DOCUMENTATION PACKAGE	71
-	1	1	2119791-5	DEPRESSOR, WIRE	70
-	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	1338685-1	PAWL, FEED	56
-	2	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	53
-	1	1	1803382-1	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	1752356-3	SUPPORT, TERMINAL	34
-	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	2-2844962-8	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29
-	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	1803095-6	FLOATING SHEAR, FRONT	9
-	1	1	1-1803250-9	ANVIL, COMBINATION	8
-	-	-	-	-	7
-	-	-	-	-	6
-	1	1	2119757-3	DEPRESSOR, SHEAR	5
-	1	1	4-238011-5	BLOCK, CRIMPER SPACER	4
-	1	1	1-1803260-8	CRIMPER, INSULATION F PREMIUM	3
-	-	-	-	-	2
-	1	1	1-456403-3	CRIMPER, WIRE PREMIUM	1

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

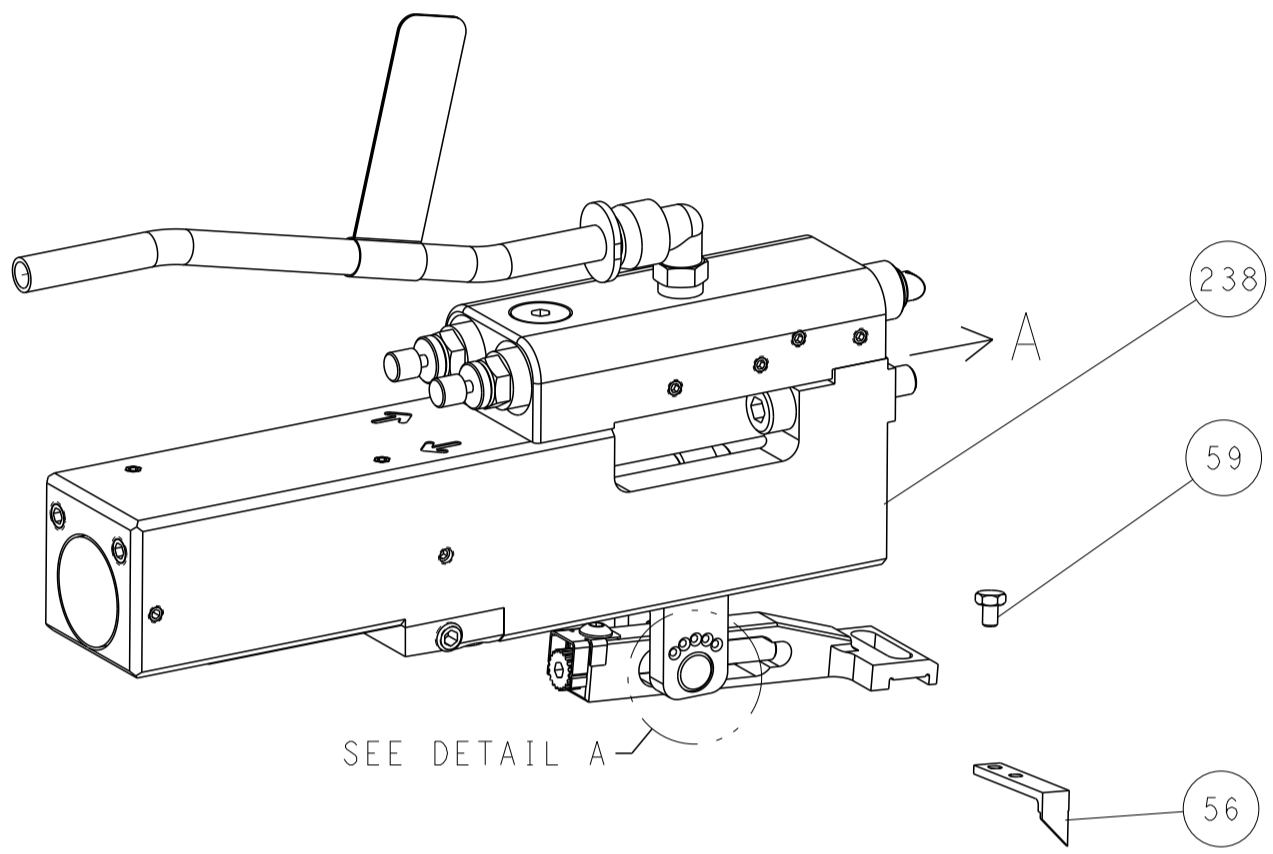
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LOC	DIST	REVISIONS					
A	66	P	LTN	DESCRIPTION	DATE	DMN	APVD
		-		SEE SHEET 1	-	-	-

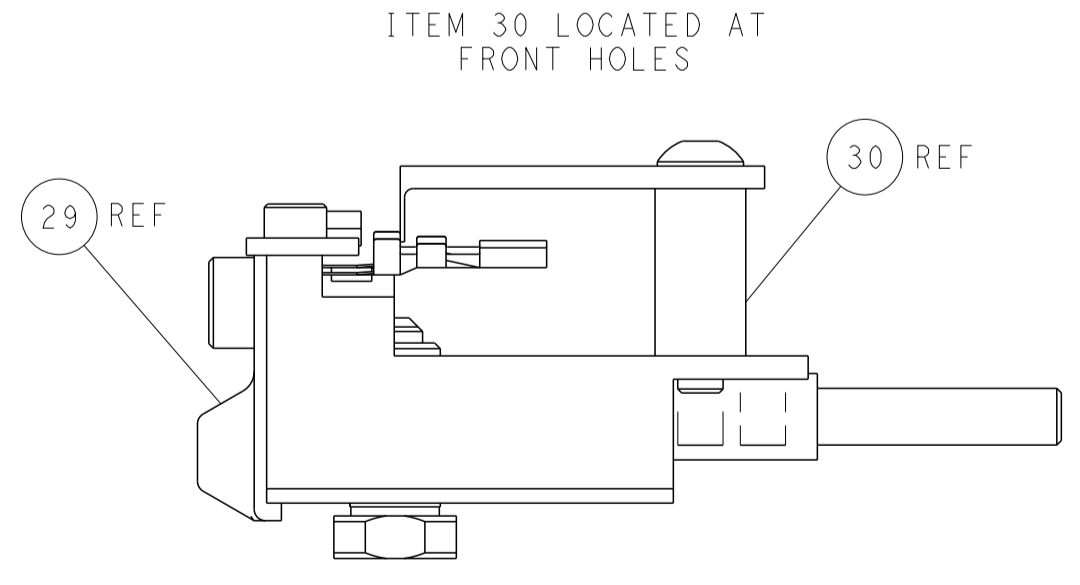
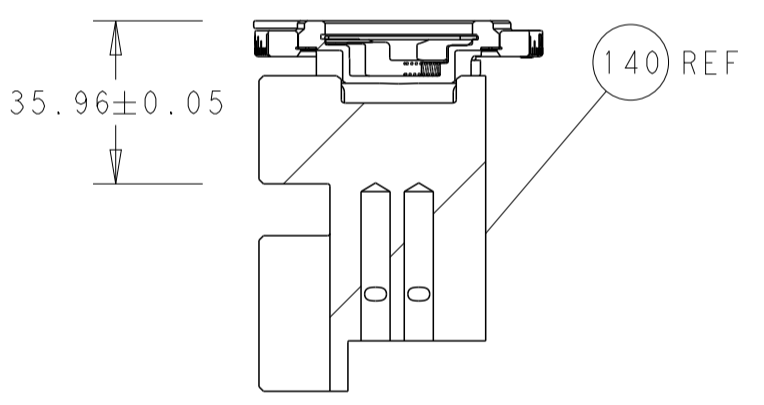
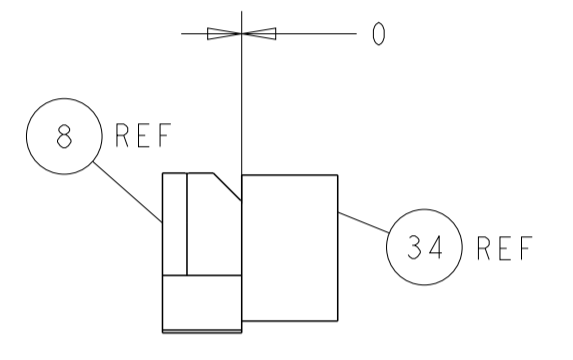
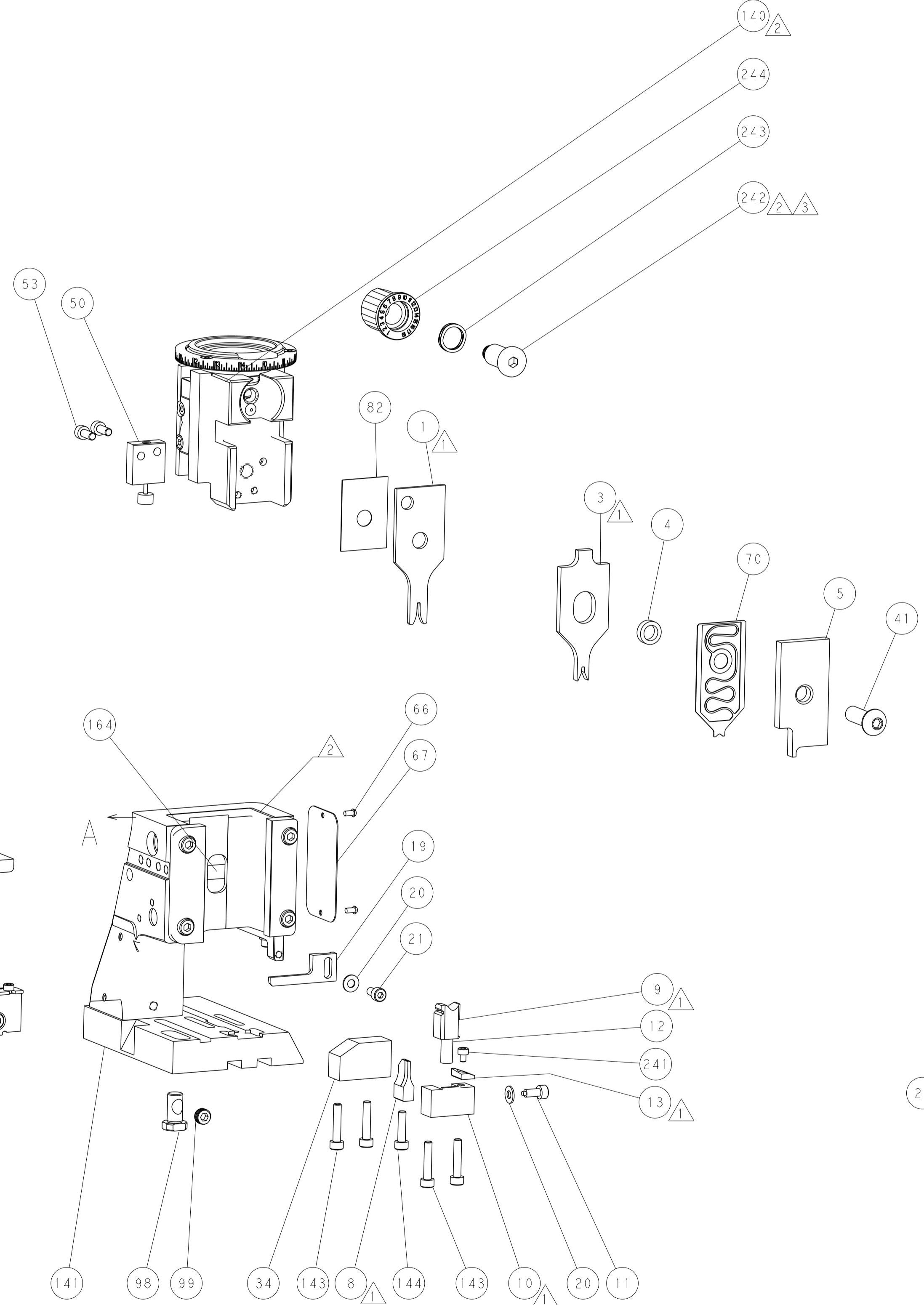
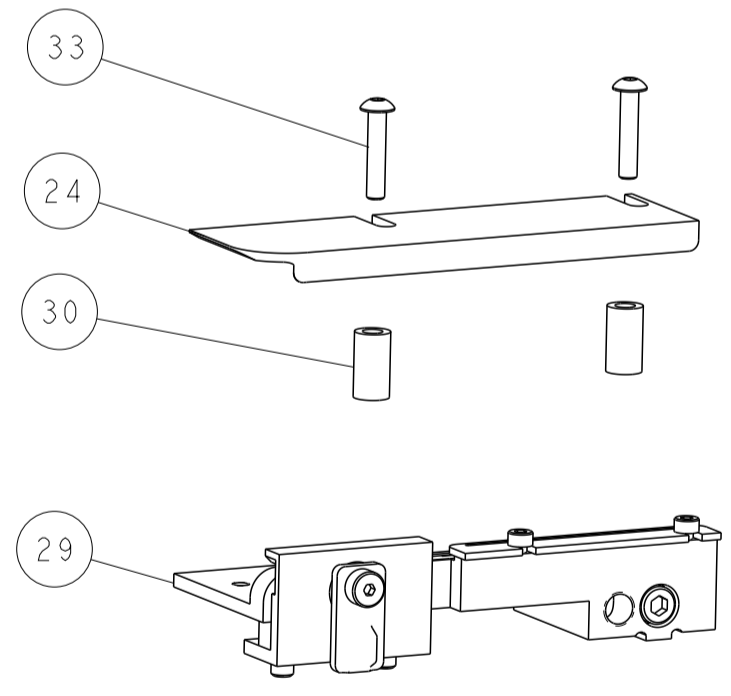
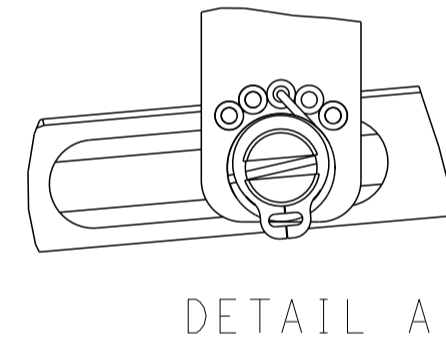
# FEED TYPE MECHANICAL



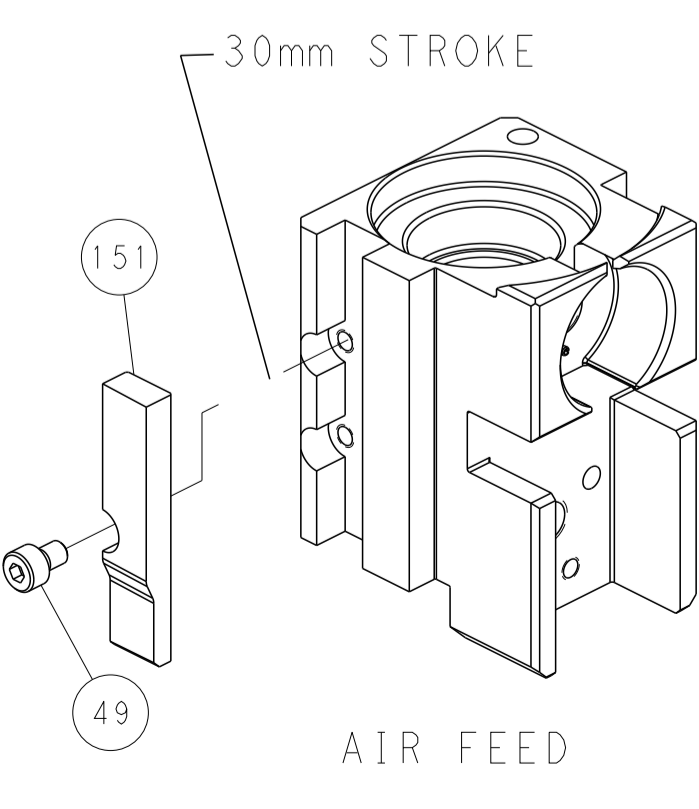
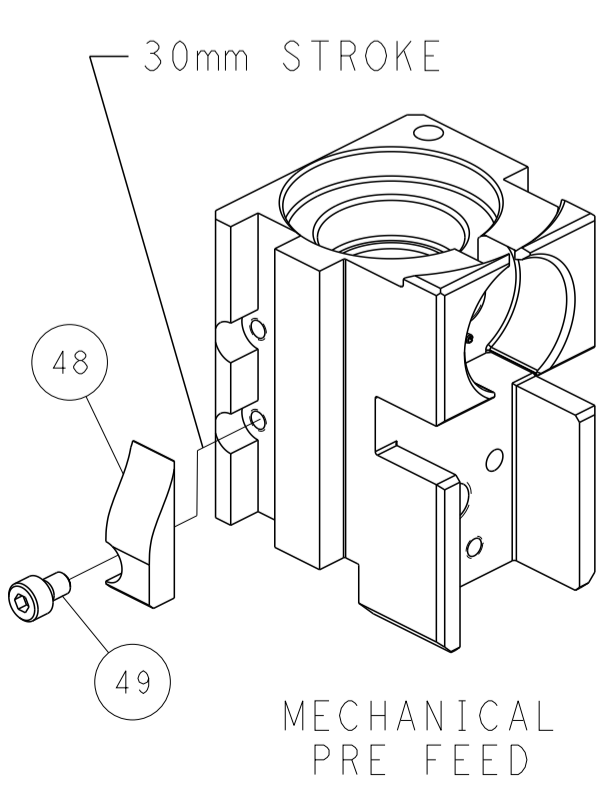
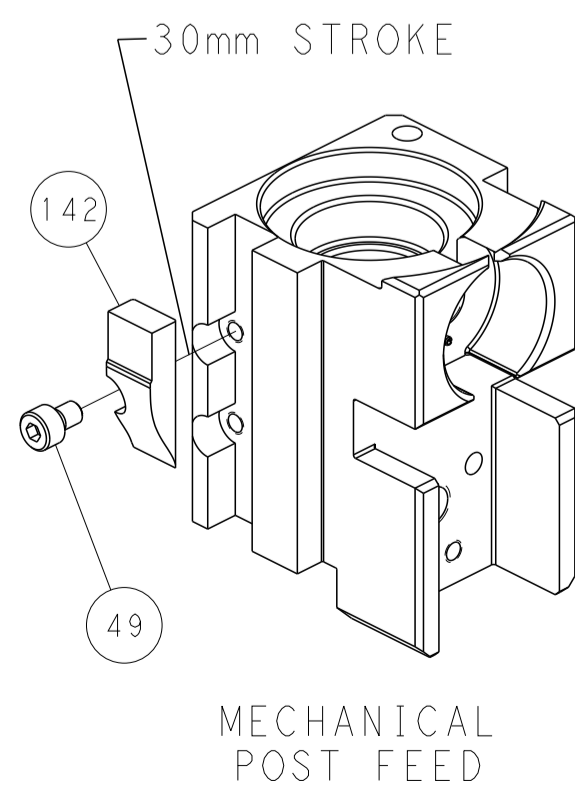
## PNEUMATIC



### 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)

<small>THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION. ALL RIGHTS RESERVED. © 2017 BY TYCO ELECTRONICS CORPORATION. THIS DRAWING 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, WITHOUT THE WRITTEN PERMISSION OF TYCO ELECTRONICS CORPORATION.</small>		DMN: Y. YIN 26APR2017 CHK: G. BAILEY 26APR2017 APVD: K. ZHANG 26APR2017	NAME: TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH	PRODUCT SPEC APPLICATION SPEC WEIGHT SCALE: 1:2	SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2836740	RESTRICTED TO: B SHEET 4 OF 4 REV B