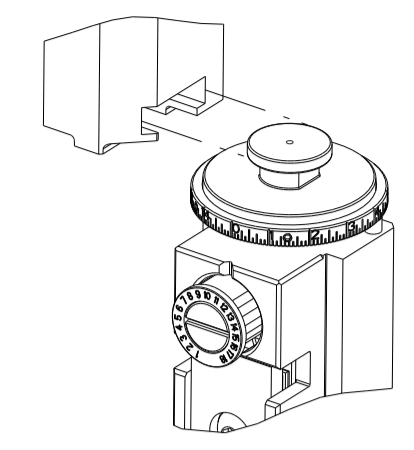


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2836913-1	D	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2836913-2	D	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2836913-1	D	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2836913-2	D	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2836913-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.55 mm [.061]	F
INSUL	2.16 mm [.085]	F

APPLICATOR INSTRUCTIONS 408-35042

TERMINAL DATA: NIPPON TANSHI CO. TERMINAL NIPPON TANSHI CO. CRIMP SPECIFICATION			
TERMINAL NAME: PIN AND SOCKET CONTACT			
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE		
3.50-4.00 mm [.138-.157 IN]	Ø1.40-2.00 mm [.055-.079 IN]		
TERMINAL APPLICATION SPECIFICATION (B)181404B-01 Rev 2016-8-31			
TERMINALS APPLIED 5 7			
TE TERMINAL	NIPPON TANSHI CO. TERMINAL	TE TERMINAL	NIPPON TANSHI CO. TERMINAL
(B) 2318369-1	(B) 181404-M2		

TERMINAL DATA: NIPPON TANSHI CO. TERMINAL NIPPON TANSHI CO. CRIMP SPECIFICATION			
TERMINAL NAME: PIN AND SOCKET CONTACT			
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE		
3.50-4.00 mm [.138-.157 IN]	Ø1.40-2.00 mm [.055-.079 IN]		
TERMINAL APPLICATION SPECIFICATION (A)172324B-01 Rev 2016-8-31			
TERMINALS APPLIED 5 7			
TE TERMINAL	NIPPON TANSHI CO. TERMINAL	TE TERMINAL	NIPPON TANSHI CO. TERMINAL
(A) 2318376-1	(A) 172324-M2		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.50mm2	1.00 +/- 0.05 [.039 +/- .002]	4.8
0.30mm2	0.91 +/- 0.03 [.036 +/- .001]	5.6

- 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 WHEN CHANGING TERMINALS, A FEED ADJUSTMENT MAY BE REQUIRED.
- 6 UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- 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.

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					
		P	LTN	DESCRIPTION	DATE	OWN	APVD
A	66			RELEASED	04OCT2017	TB	TE
				ECR-18-009424	6JUN2018	MEH	TE
				ECR-19-011464	22JUL2019	FJ	TE
				ECR-21-116821	11OCT2021	JAH	RK

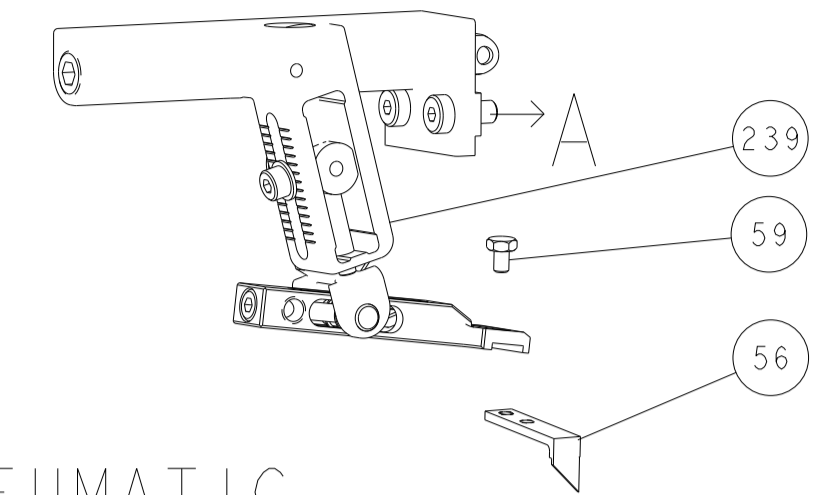
-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248
-	1	1	1	1	2119082-1	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	1	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
-	-	1	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	1	-	1	-	2844940-1	AIR FEED MODULE	238
-	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	1	1	1	1	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	455888-7	SPACER, CRIMPER	82
-	1	1	1	1	1803607-3	DOCUMENTATION PACKAGE	71
-	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	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	2-2844962-8	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29
-	1	1	1	1	455888-5	SPACER, CRIMPER	28
-	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	1803095-3	FLOATING SHEAR, FRONT	9
1	2	2	1	1	2-1803334-8	ANVIL, COMBINATION	8
-	-	-	-	-	-	-	7
-	-	-	-	-	-	-	6
-	1	1	1	1	2119757-5	DEPRESSOR, SHEAR	5
-	1	1	1	1	3-238011-5	BLOCK, CRIMPER SPACER	4
1	2	2	1	1	4-1803246-3	CRIMPER, INSULATION F PREMIUM	3
-	1	1	1	1	455888-6	SPACER, CRIMPER	2
1	2	2	1	1	2-1803325-4	CRIMPER, WIRE	1
-	77	-72	-71	-2	-1	PART NO	ITEM NO

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

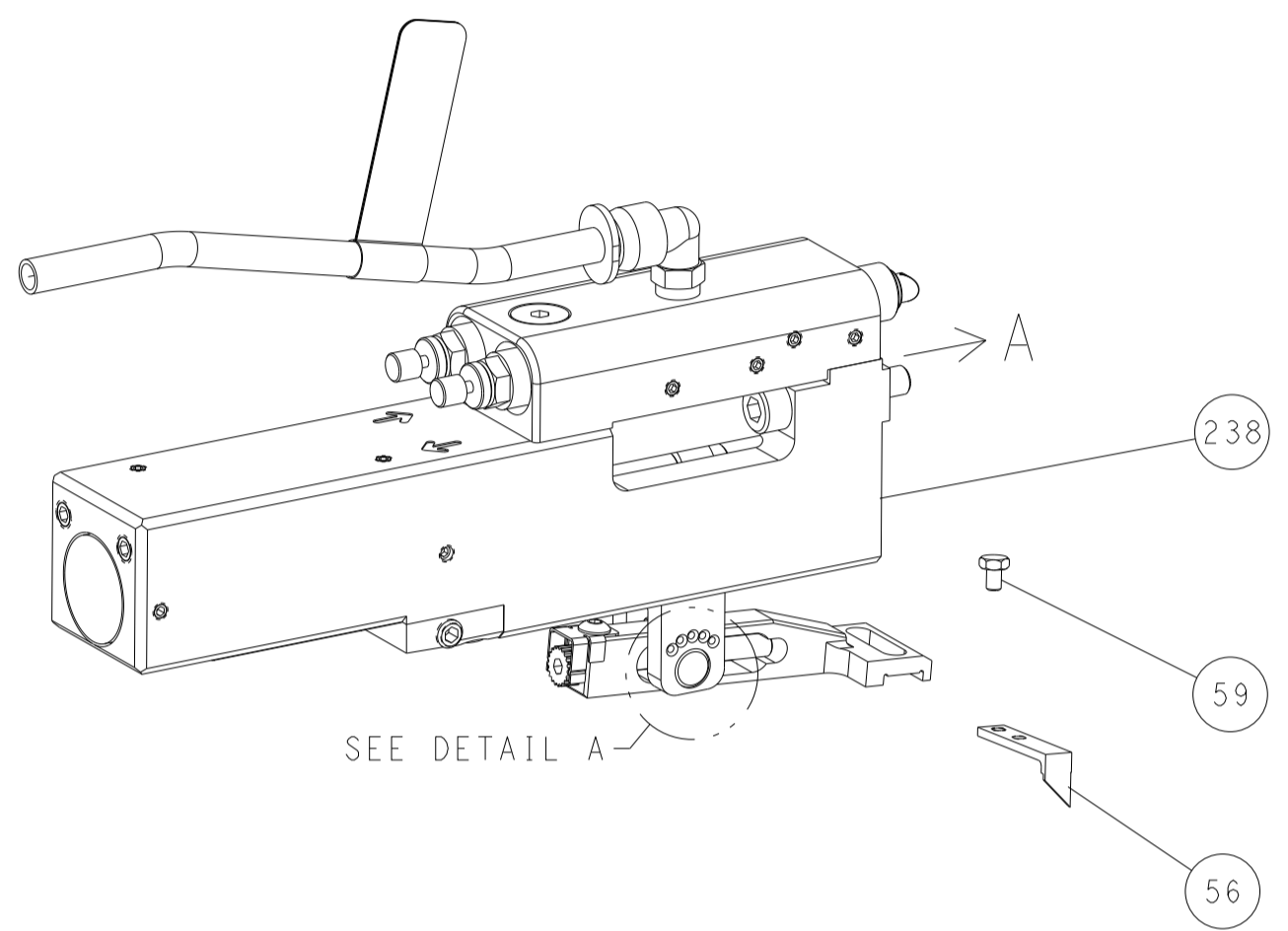
OWN	M. ZHAO	05SEP2017	
CHK	K. ZHANG	05SEP2017	
APVD	K. ZHANG	05SEP2017	
NAME	Ocean Side Feed Applicator		
SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
A1	00779	C=2836913	
Customer Accessible Production Drawing		SCALE	1:2 SHEET 1 OF 4 REV D

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

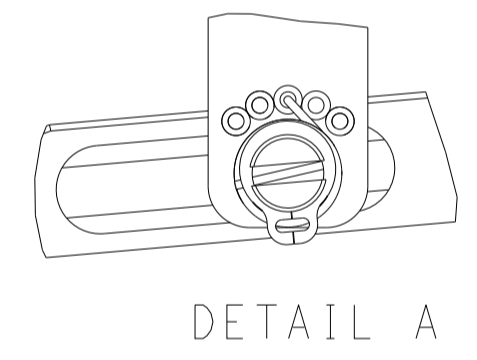
FEED TYPE MECHANICAL



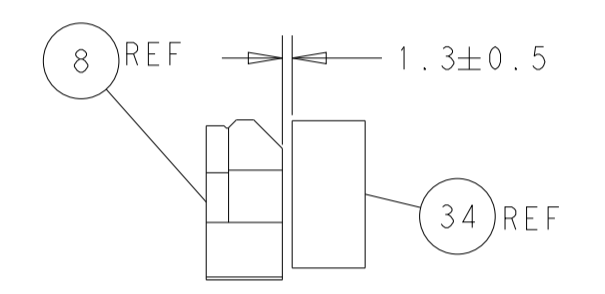
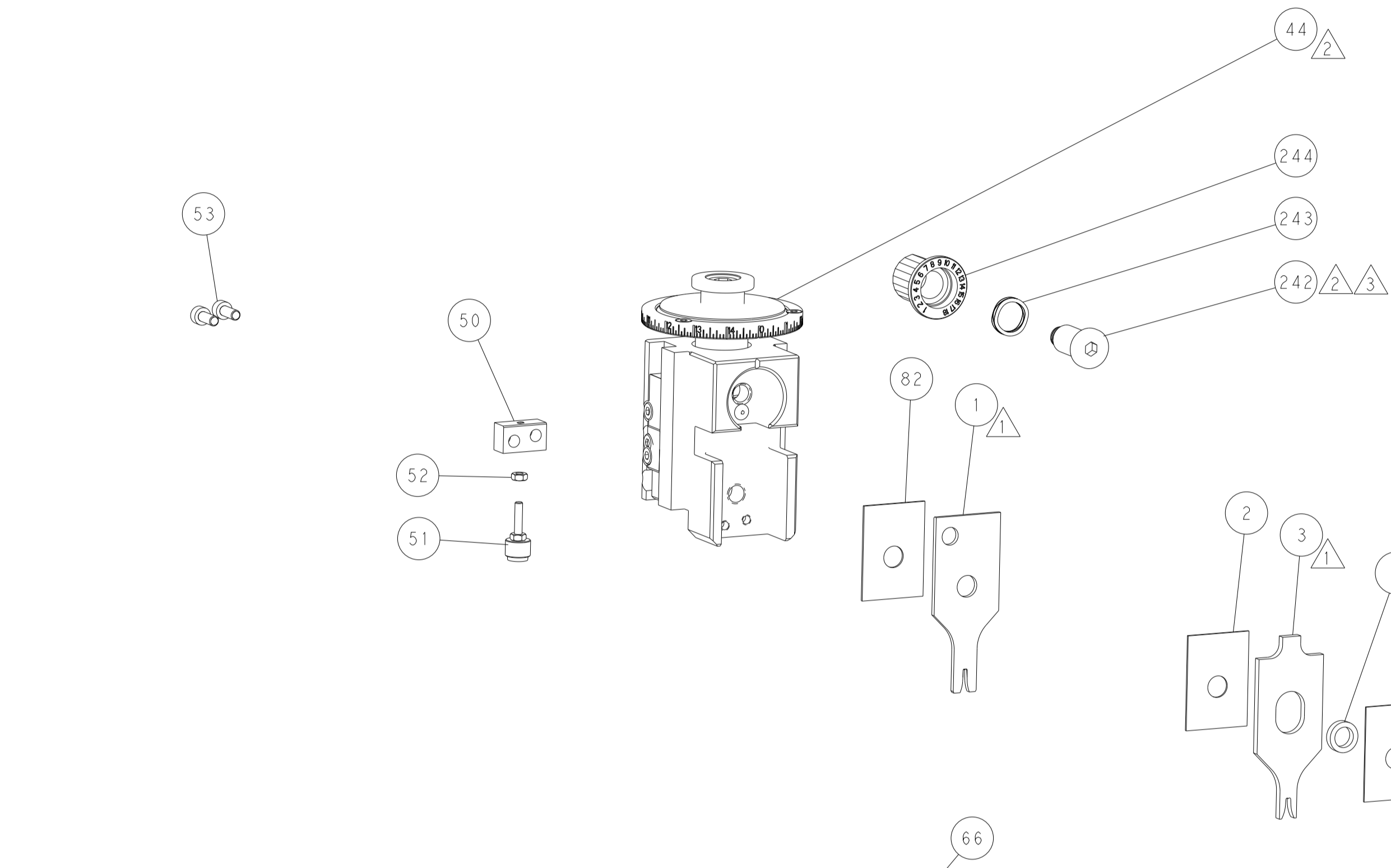
PNEUMATIC



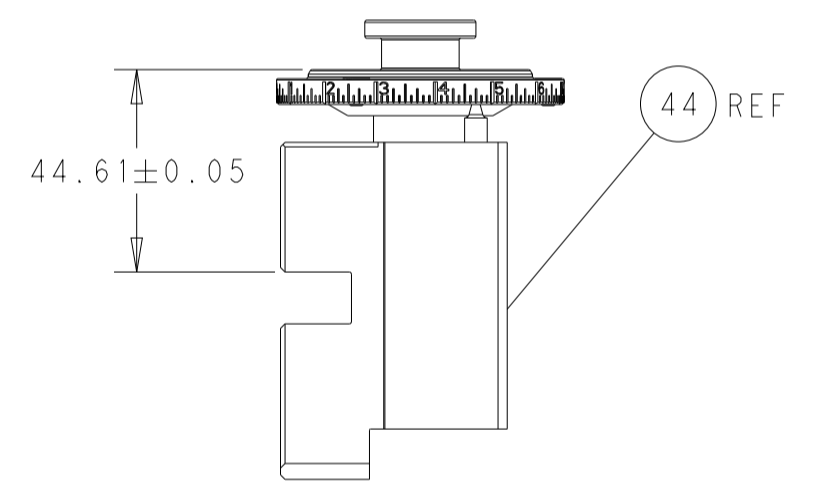
FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



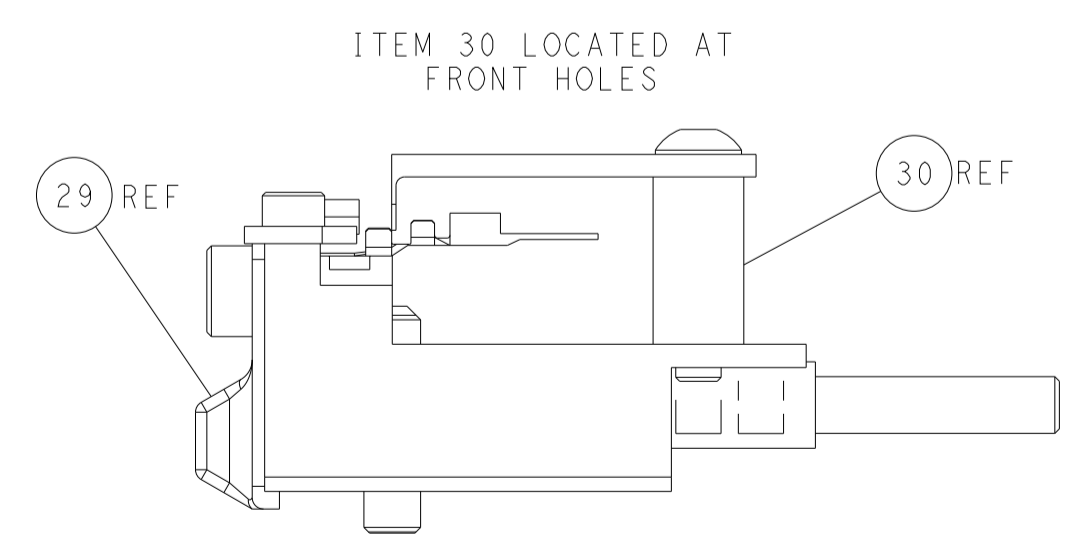
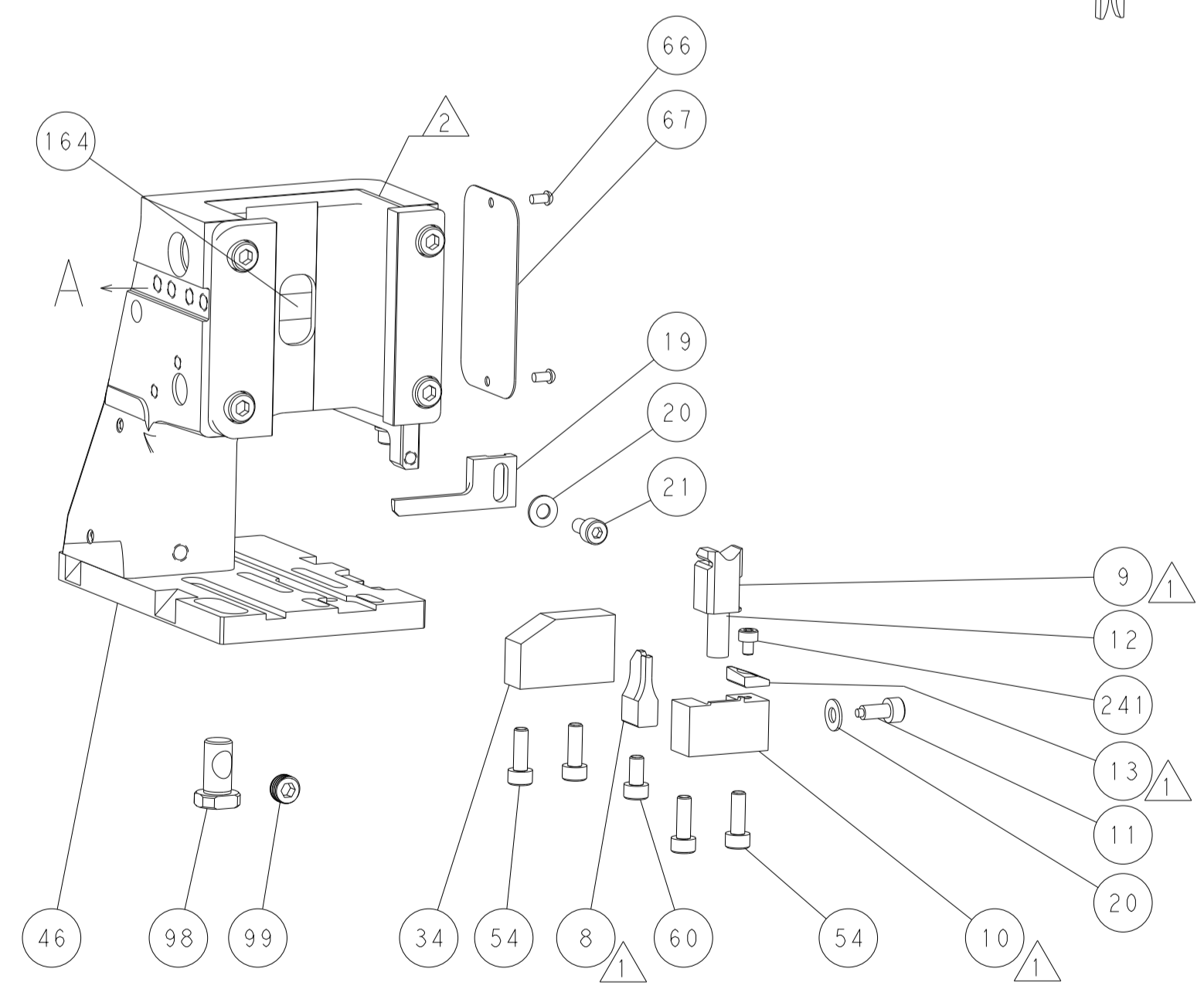
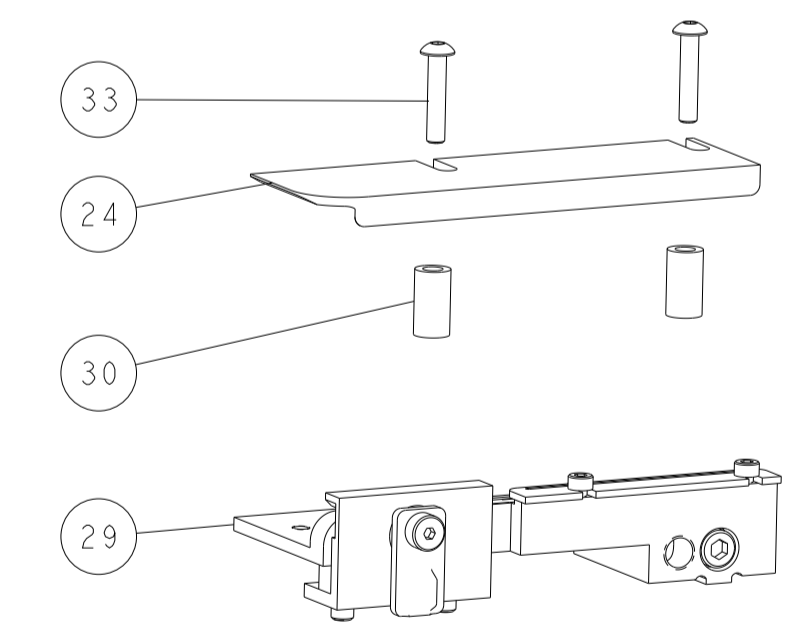
DETAIL A



TERMINAL SUPPORT LOCATION

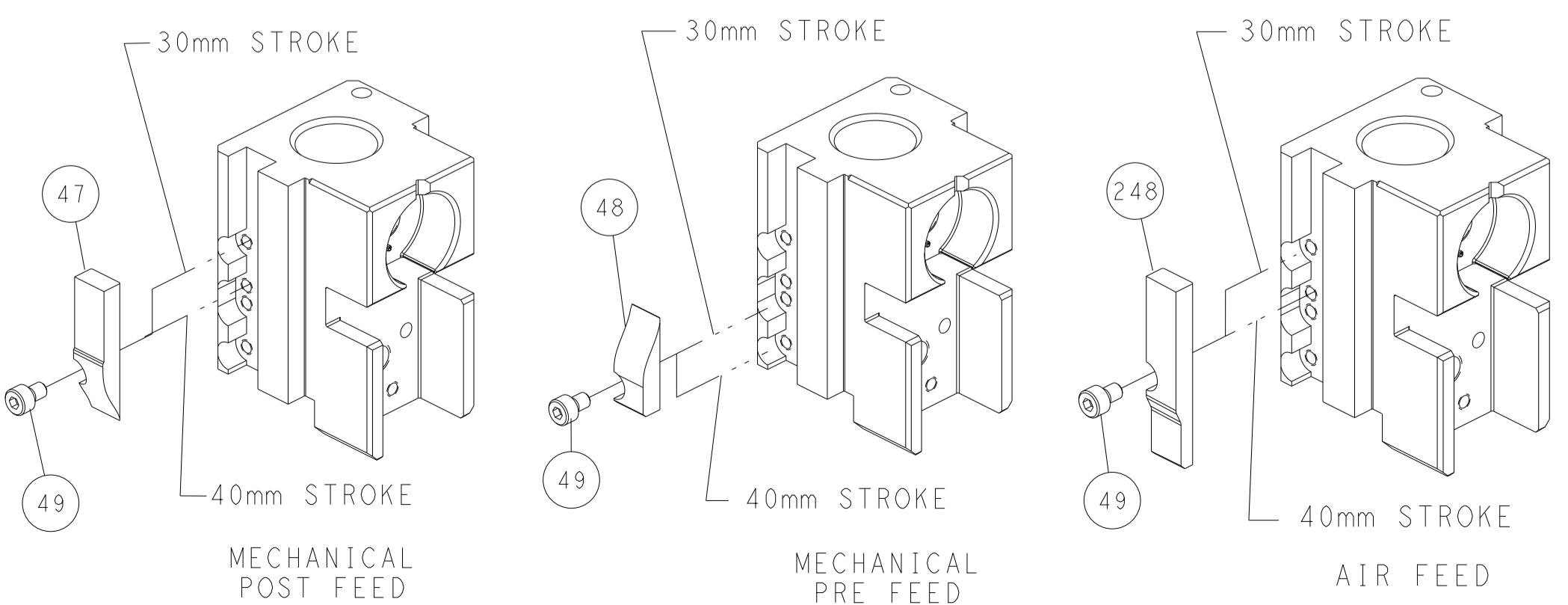


RAM SET-UP



ITEM 30 LOCATED AT FRONT HOLES

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 FINISH ±		DWG: M. ZHAO 05SEP2017 CHK: K. ZHANG 05SEP2017 APVD: K. ZHANG 05SEP2017 PRODUCT SPEC APPLICATION SPEC WEIGHT Customer Accessible Production Drawing		NAME: Ocean Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: C-2836913 SCALE: 1:2 SHEET: 2 of 4 REV: D	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2836913-1	D	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2836913-2	D	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2836913-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
 INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.55 mm [.061]	F
INSUL	2.16 mm [.085]	F
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: NIPPON TANSHI CO. TERMINAL NIPPON TANSHI CO. CRIMP SPECIFICATION			
TERMINAL NAME: PIN AND SOCKET CONTACT			
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE		
3.50-4.00 mm [.138-.157 IN]	Ø1.40-2.00 mm [.055-.079 IN]		
TERMINAL APPLICATION SPECIFICATION	(B)181404B-01 Rev 2016-8-31		
TERMINALS APPLIED			
TE TERMINAL	NIPPON TANSHI CO. TERMINAL	TE TERMINAL	NIPPON TANSHI CO. TERMINAL
(B) 2318369-1	(B) 181404-M2		

TERMINAL DATA: NIPPON TANSHI CO. TERMINAL NIPPON TANSHI CO. CRIMP SPECIFICATION			
TERMINAL NAME: PIN AND SOCKET CONTACT			
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE		
3.50-4.00 mm [.138-.157 IN]	Ø1.40-2.00 mm [.055-.079 IN]		
TERMINAL APPLICATION SPECIFICATION	(A)172324B-01 Rev 2016-8-31		
TERMINALS APPLIED			
TE TERMINAL	NIPPON TANSHI CO. TERMINAL	TE TERMINAL	NIPPON TANSHI CO. TERMINAL
(A) 2318376-1	(A) 172324-M2		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.50mm2	1.00+/-0.05 [.039+/-0.002]	4.8
0.30mm2	0.91+/-0.03 [.036+/-0.001]	5.6

- 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.
- WHEN CHANGING TERMINALS, A FEED ADJUSTMENT MAY BE REQUIRED.
- 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)

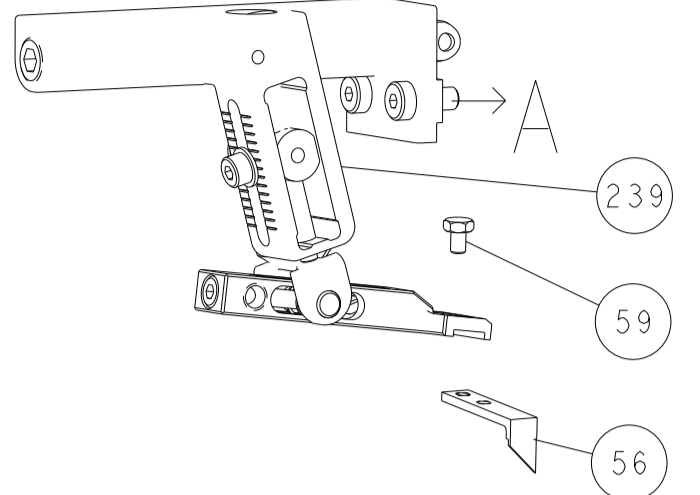
LOC	DIST	REVISIONS					
A	66	P	LTN	DESCRIPTION	DATE	OWN	APVD
		-	-	SEE SHEET 1	-	-	-

-	1	1	2119082-1	CAM, SNAIL, INSULATION ADJUSTMENT	244	
-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243	
3	-	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	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	1	994970-2	COUNTER, MAGNETIC	164
-	1	-	1	2119641-2	FEED CAM, AIR FEED	151
-	1	1	1	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	144
-	4	4	1	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	143
-	-	1	1	2119653-2	FEED CAM, POST FEED	142
-	1	1	1	1-1803583-0	APPLICATOR BASIC ASSEMBLY, SF	141
-	1	1	1	1803516-1	RAM ASSEMBLY, SF PACIFIC	140
3	-	1	1	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113
-	1	1	1	2844908-1	SCREW, LOCKING	99
-	1	1	1	2844907-1	POST, LOCKING	98
-	1	1	1	455888-7	SPACER, CRIMPER	82
-	1	1	1	1803607-3	DOCUMENTATION PACKAGE	71
-	1	1	1	2119740-1	TAG, IDENTIFICATION	67
-	2	2	1	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	1	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	1	1	1	1338685-1	PAWL, FEED	56
-	2	2	1	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	53
-	1	1	1	5018030-1	NUT, HEX, REG, RoHS, M3	52
-	1	1	1	811242-5	BUMPER, HOLD DOWN	51
-	1	1	1	690753-2	SPACER, TONKER	50
-	1	2	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	-	1	1	2119652-1	FEED CAM, PRE FEED	48
-	1	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
-	1	1	1	1752356-1	SUPPORT, TERMINAL	34
-	2	2	1	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	1	2-2844962-8	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29
-	1	1	1	455888-5	SPACER, CRIMPER	28
-	1	1	1	1320928-2	STRIP GUIDE	24
-	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
-	2	2	1	1-18028-2	WASHER, FLAT, REG M4	20
-	1	1	1	2119533-1	STRIPPER, SIDE FEED	19
3	-	1	1	2119806-1	INSERT, SHEAR	13
-	1	1	1	3-22280-3	SPRING, COMPRESSION	12
-	1	1	1	1-356885-4	STOP, SHEAR	11
3	-	1	1	2119805-1	SHEAR HOLDER, FRONT	10
3	-	1	1	1803095-3	FLOATING SHEAR, FRONT	9
3	1	1	1	2-1803334-8	ANVIL, COMBINATION	8
-	-	-	-	-	-	7
-	-	-	-	-	-	6
-	1	1	1	2119757-5	DEPRESSOR, SHEAR	5
-	1	1	1	3-238011-5	BLOCK, CRIMPER SPACER	4
3	1	1	1	4-1803246-3	CRIMPER, INSULATION F PREMIUM	3
-	1	1	1	455888-6	SPACER, CRIMPER	2
3	1	1	1	2-1803325-4	CRIMPER, WIRE	1

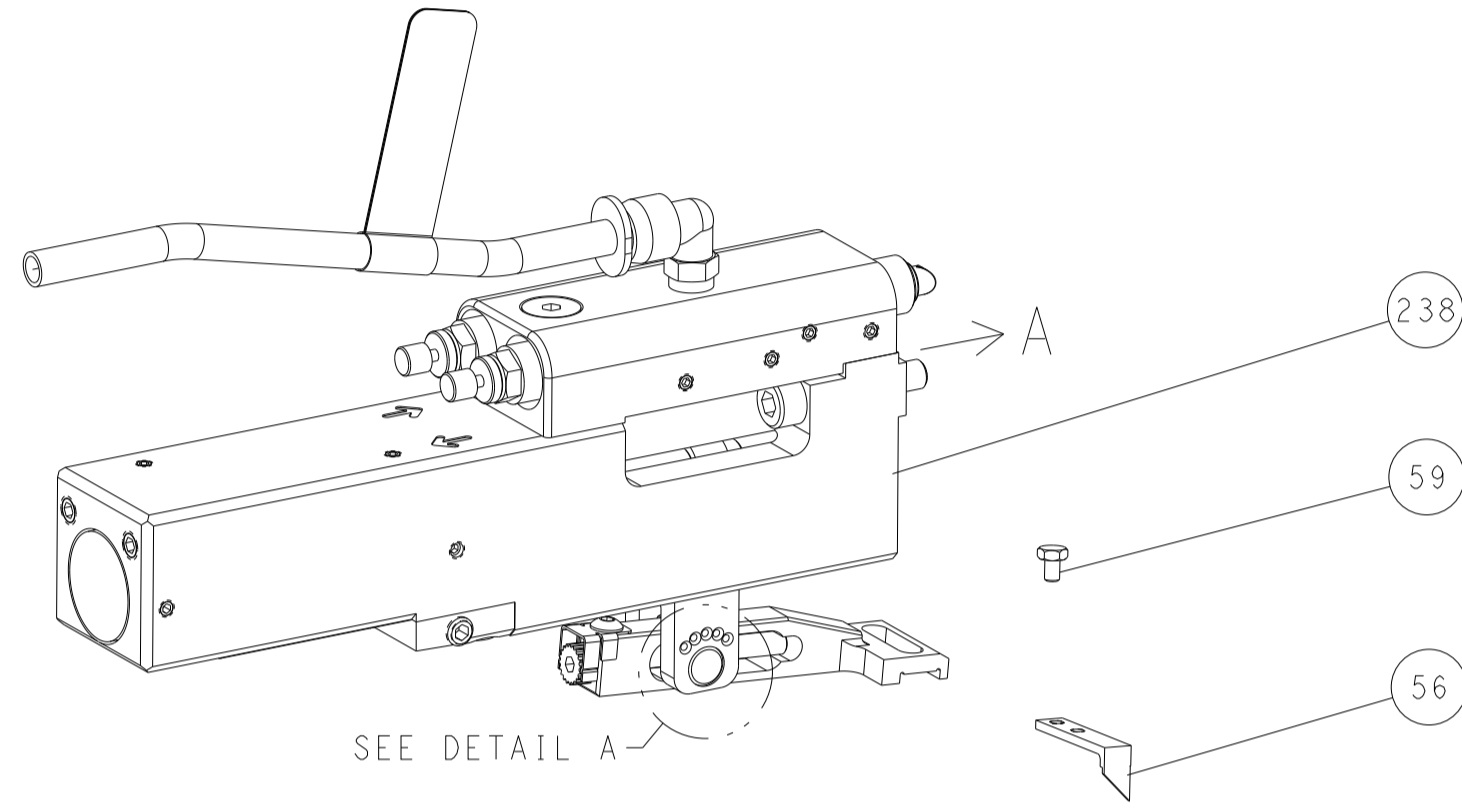
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		MATERIAL:		FINISH:		WEIGHT:		SCALE:	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES	FINISH				

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

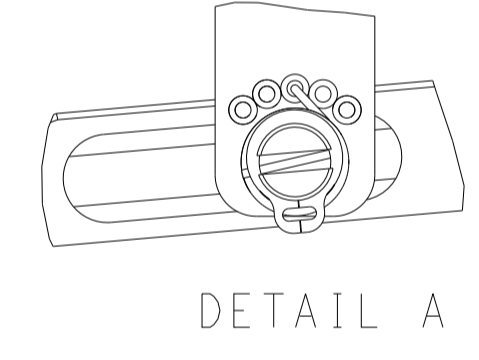
FEED TYPE MECHANICAL



PNEUMATIC

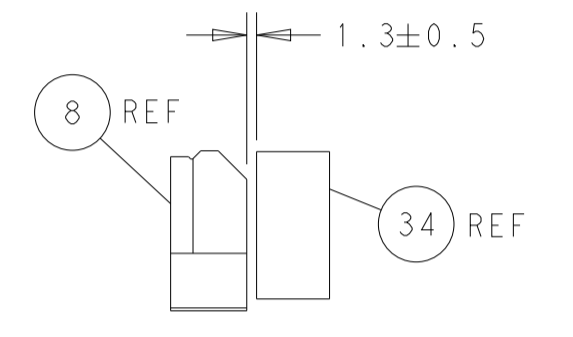
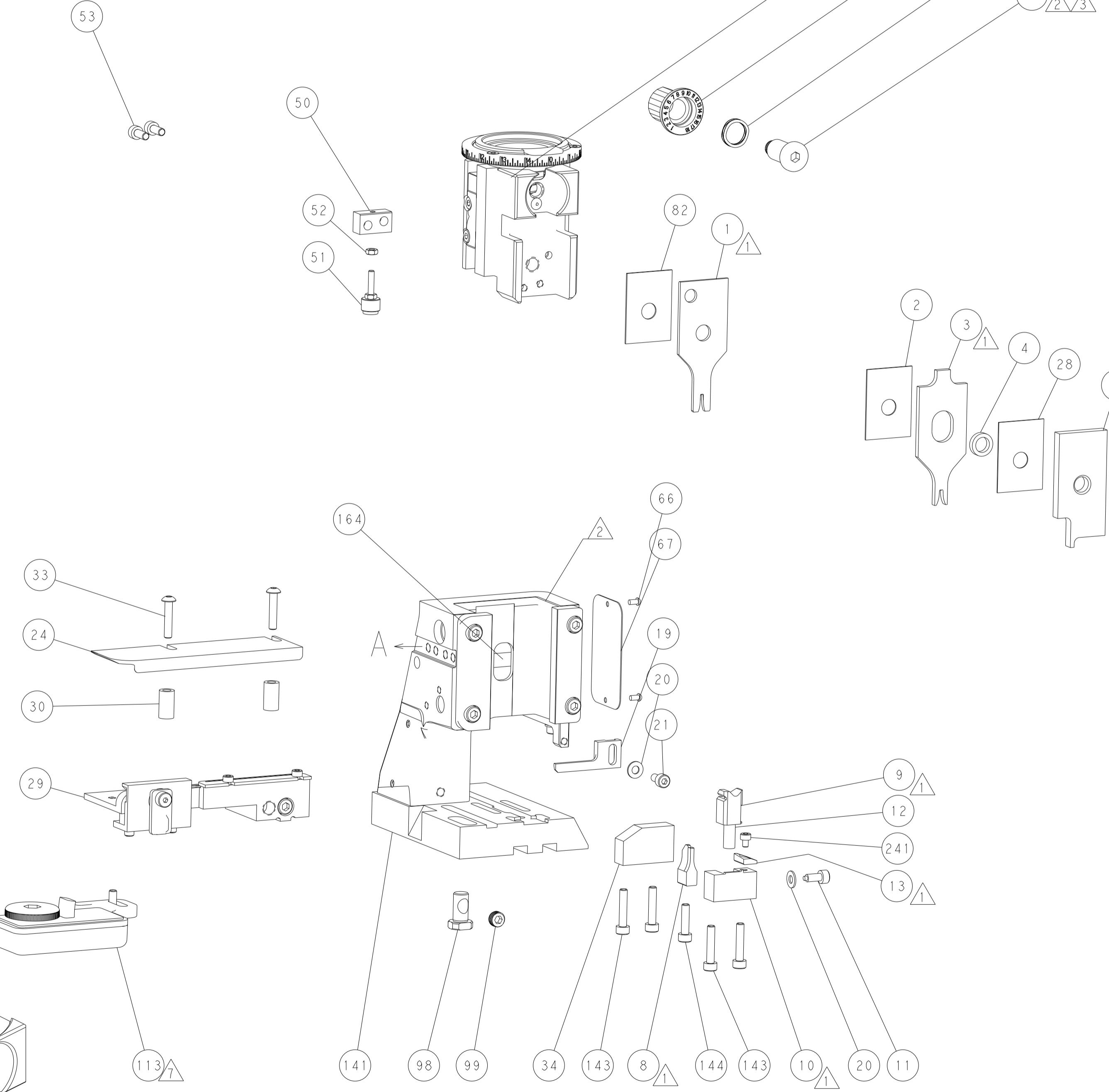
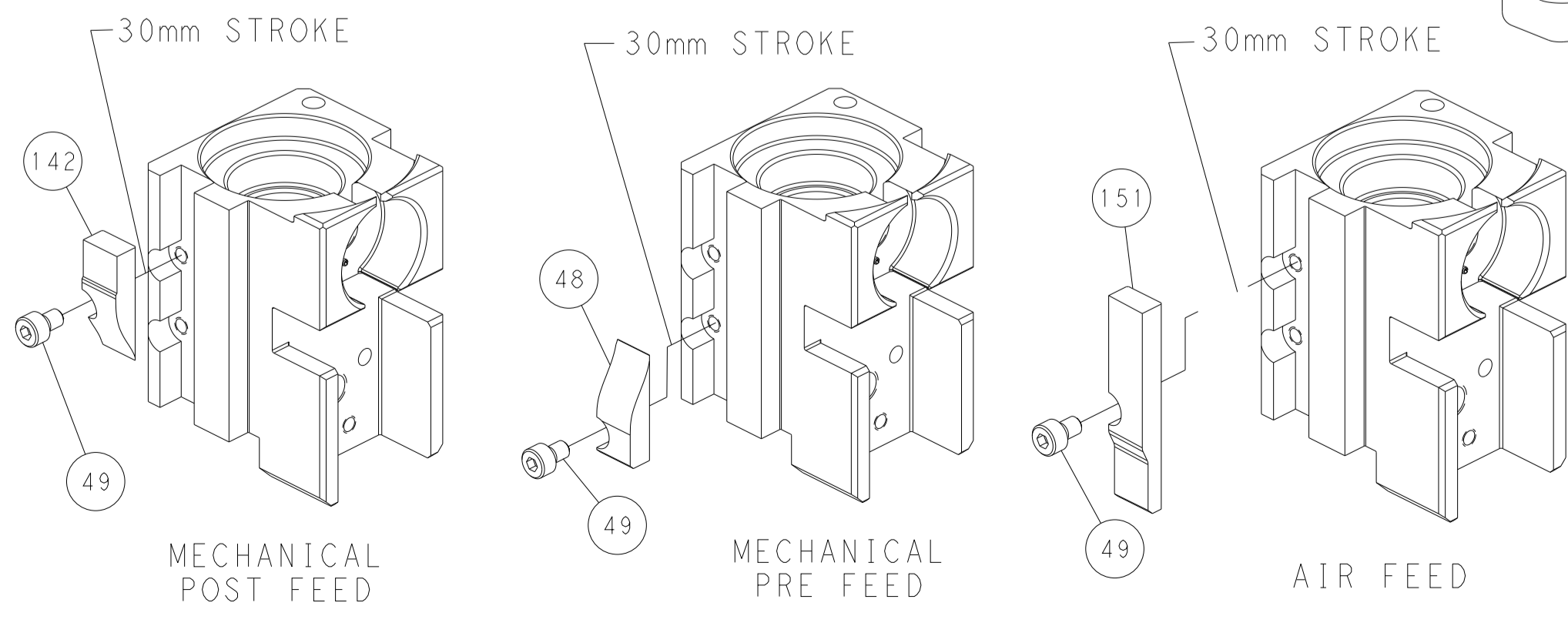


FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)

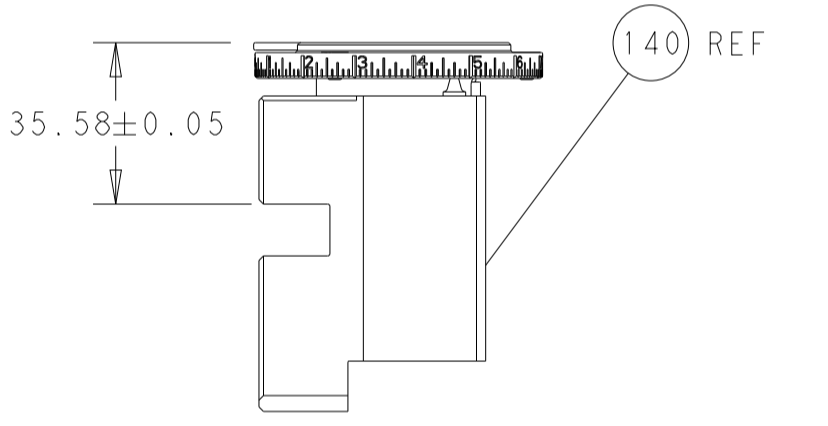


DETAIL A

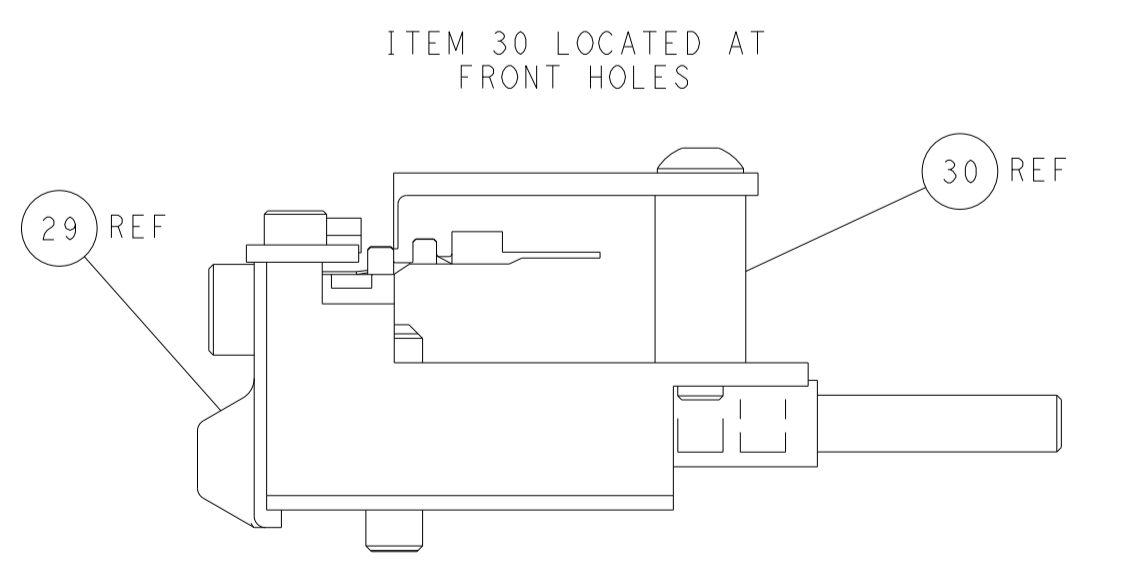
CAM POSITIONS



TERMINAL SUPPORT LOCATION



RAM SET-UP



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)

<small>THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION. ALL RIGHTS RESERVED. © 2017 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.</small>		DWN: M. ZHAO 05SEP2017 CHK: K. ZHANG 05SEP2017 APVD: K. ZHANG 05SEP2017	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 APPLICATION SPEC: - SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2836913	RESTRICTED TO: - SCALE: 1:2 SHEET: 4 OF 4 REV: D
MATERIAL: -		WEIGHT: - Customer Accessible Production Drawing	SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION