

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2836931-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2836931-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2836931-1	B	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2836931-2	C	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2836931-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.20 mm [.087]	F
INSUL	2.80 mm [.110]	O

APPLICATOR INSTRUCTIONS 408-35042

TERMINAL DATA: MOLEX TERMINAL MOLEX CRIMP SPECIFICATION			
TERMINAL NAME: TERMINAL, CP 1.5 RECEPTACLE			
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE		
4.10-4.90 mm [.161-.193 IN]	Ø2.10-2.70 mm [.083-.106 IN]		
TERMINAL APPLICATION SPECIFICATION			
ATS-638688100 Rev D			
TERMINALS APPLIED			
TE TERMINAL	MOLEX TERMINAL	TE TERMINAL	MOLEX TERMINAL
1949147-1	98915-1039	1949147-3	64323-1039
1949147-2	98915-1219	1949147-4	64323-1219

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
2.00mm2	1.75+/-0.05 [.069+/- .002]	5.5
1.50mm2	1.55+/-0.05 [.061+/- .002]	7.5
1.40mm2	1.50+/-0.05 [.059+/- .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.
- TERMINAL LUBRICANT IS RECOMMENDED.
- 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	14NOV2017	TB	CT
		B		ECR-19-005585	07APR2019	TB	CT
		C		ECR-21-000566	17JAN2021	TB	RK

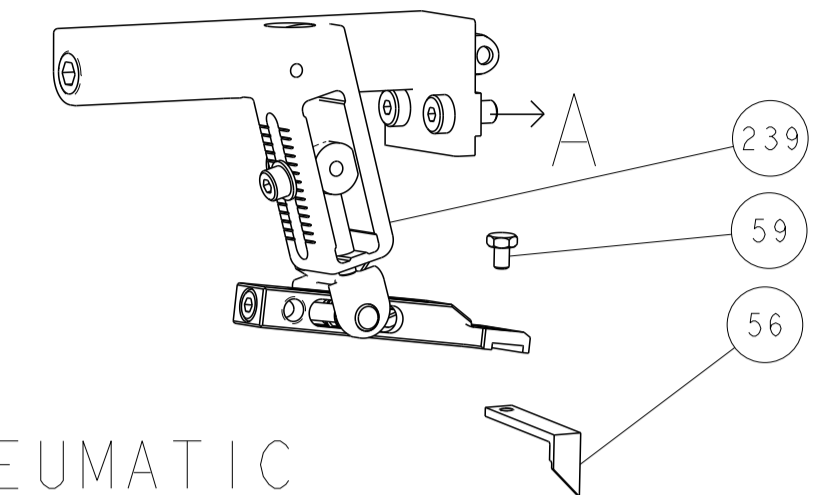
-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248	
-	1	1	1	1	2119082-8	CAM, SNAIL, INSULATION ADJUSTMENT	244	
-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243	
-	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242	
-	1	1	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241	
-	-	1	-	1	2119580-1	MECHANICAL FEED 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	455888-5	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	1338683-8	FEED PAWL	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	7-1752356-7	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	455888-3	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	1803095-6	FLOATING SHEAR, FRONT	9	
-	1	2	2	1	1	2-1633138-0	ANVIL, COMBINATION	8
-	-	-	-	-	-	-	7	
-	-	-	-	-	-	-	6	
-	1	1	1	1	2119757-5	DEPRESSOR, SHEAR	5	
-	1	1	1	1	7-238011-0	BLOCK, CRIMPER SPACER	4	
-	1	2	2	1	1	2-1803453-0	CRIMPER, INSULATION O	3
-	1	1	1	1	455888-4	SPACER, CRIMPER	2	
-	1	2	2	1	1	3-1490019-7	CRIMPER, WIRE PREMIUM	1
-	77	-72	-71	-2	-1	PART NO	ITEM NO	

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

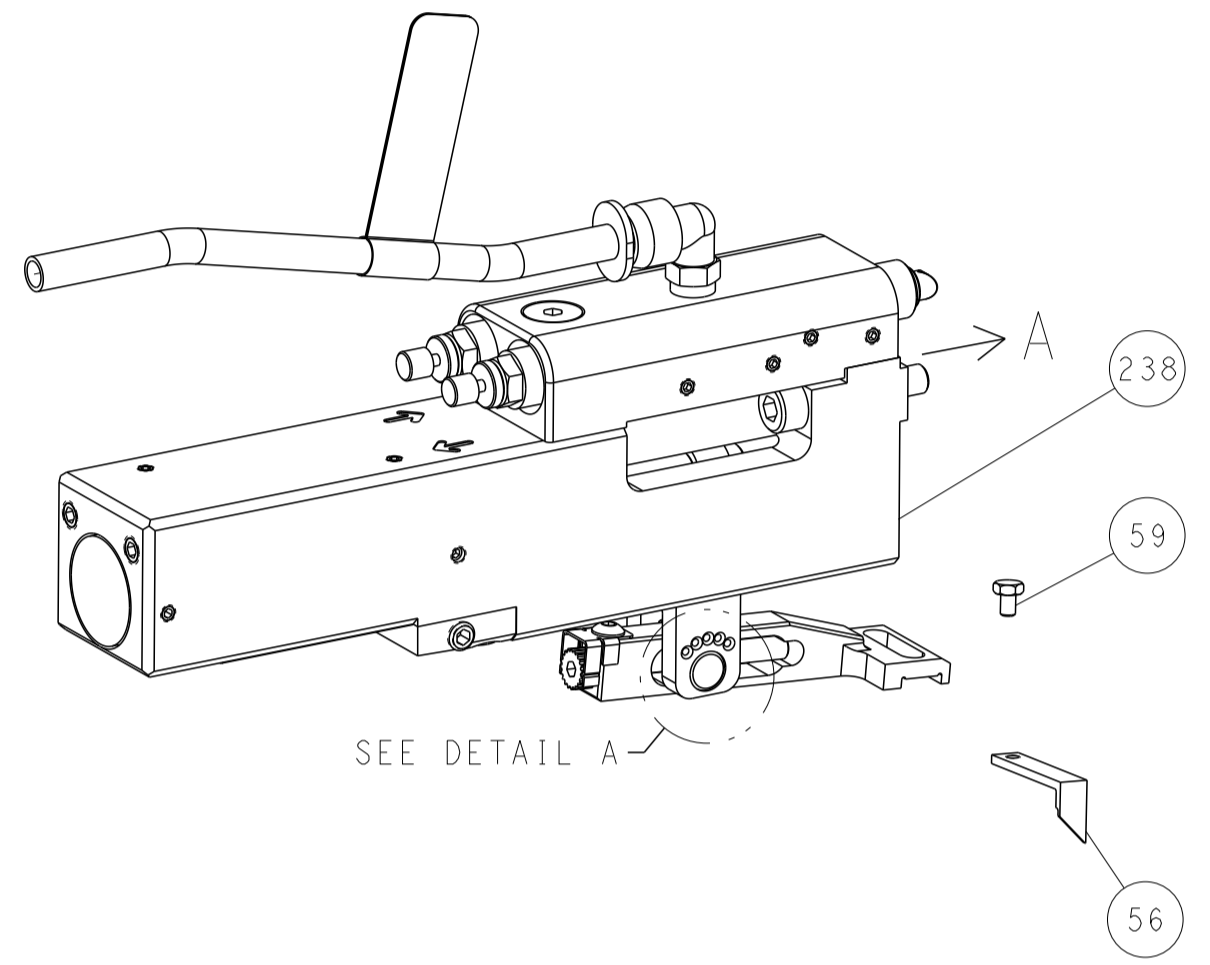
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mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES ±	FINISH ±
				WEIGHT: - SCALE: 1:2 SHEET: 1 of 4 REV: C			

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

# FEED TYPE MECHANICAL



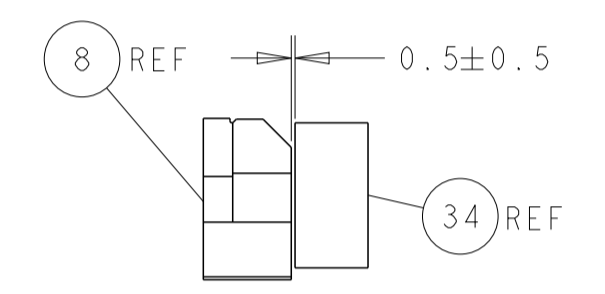
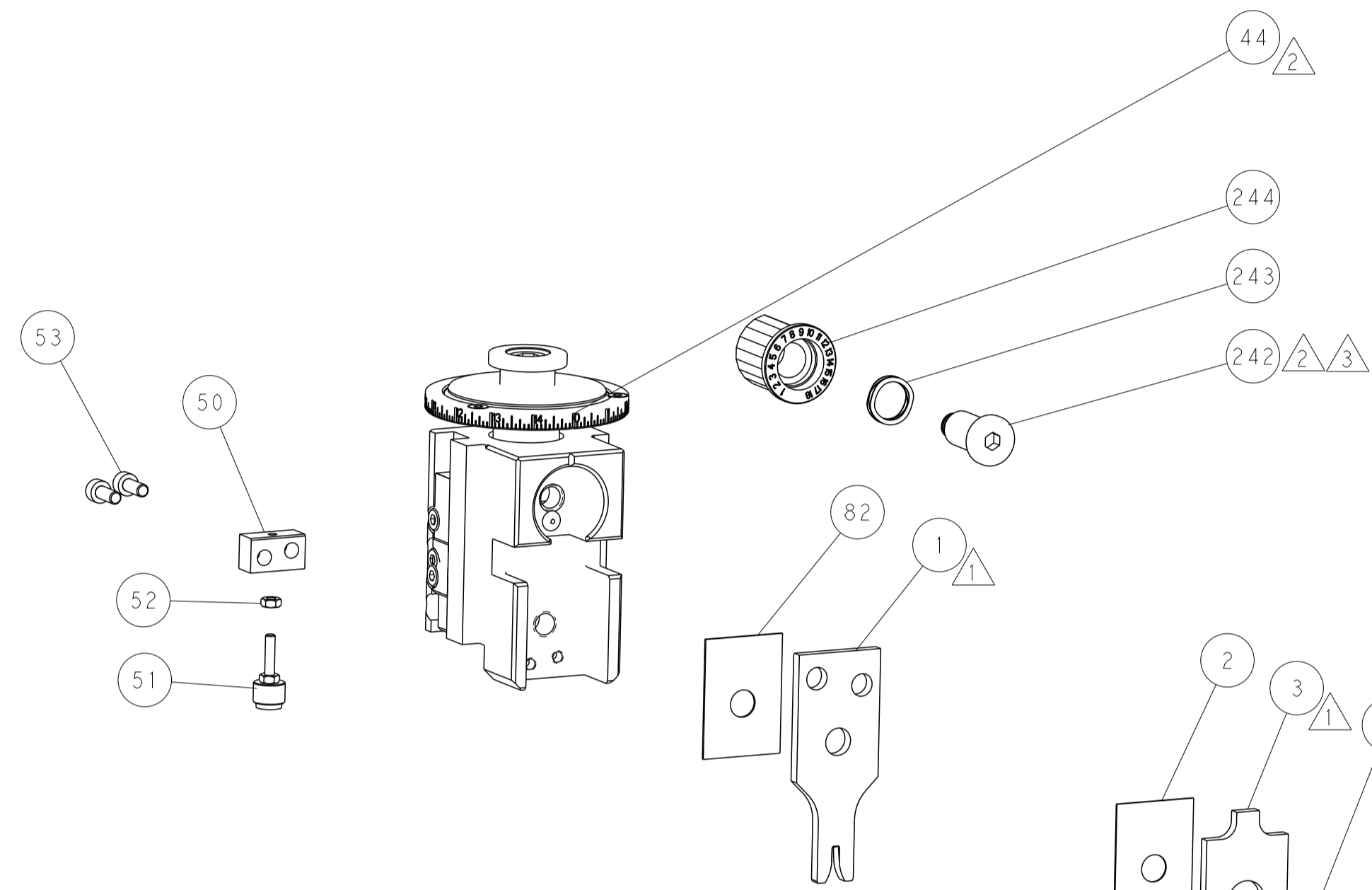
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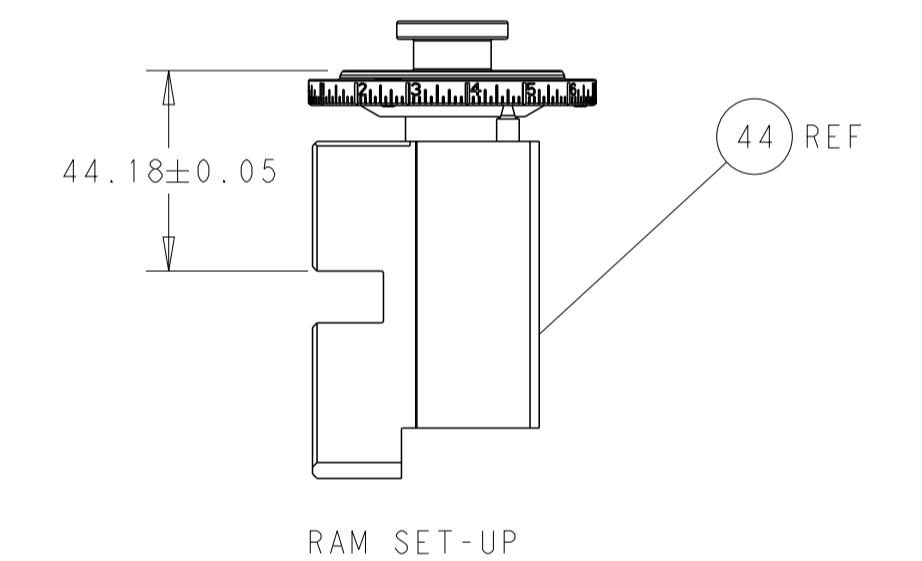
## FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



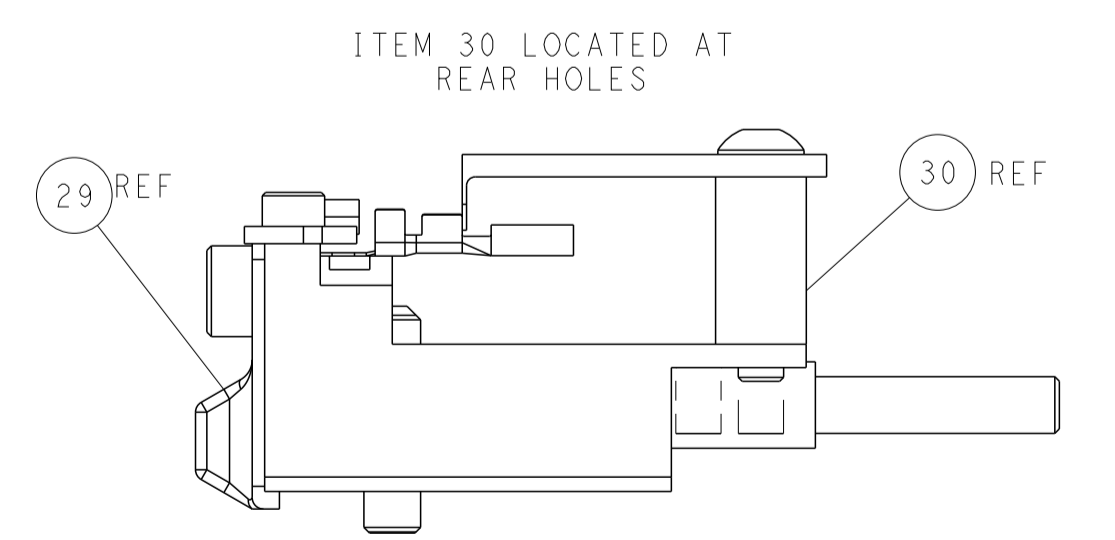
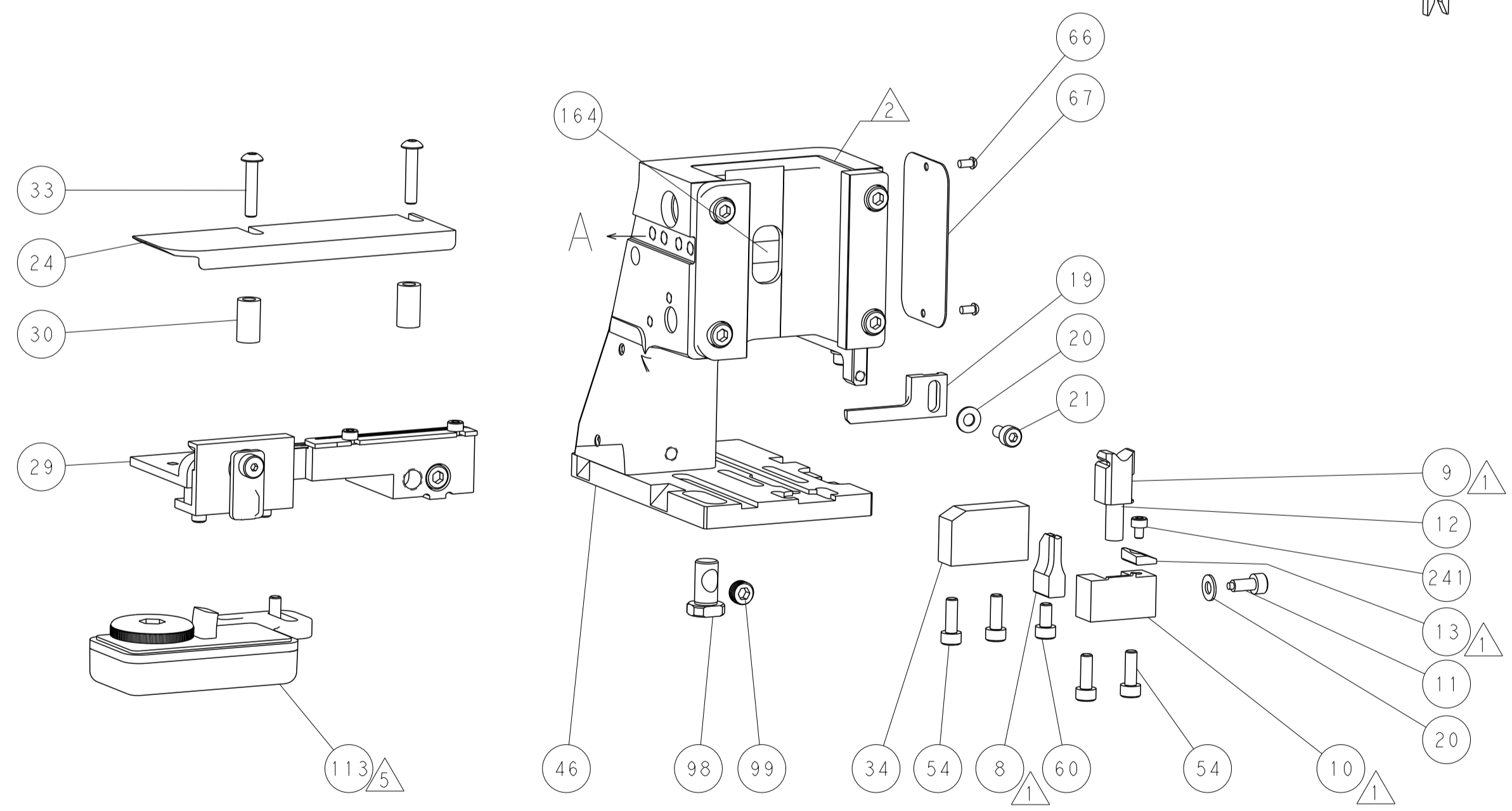
DETAIL A



TERMINAL SUPPORT LOCATION

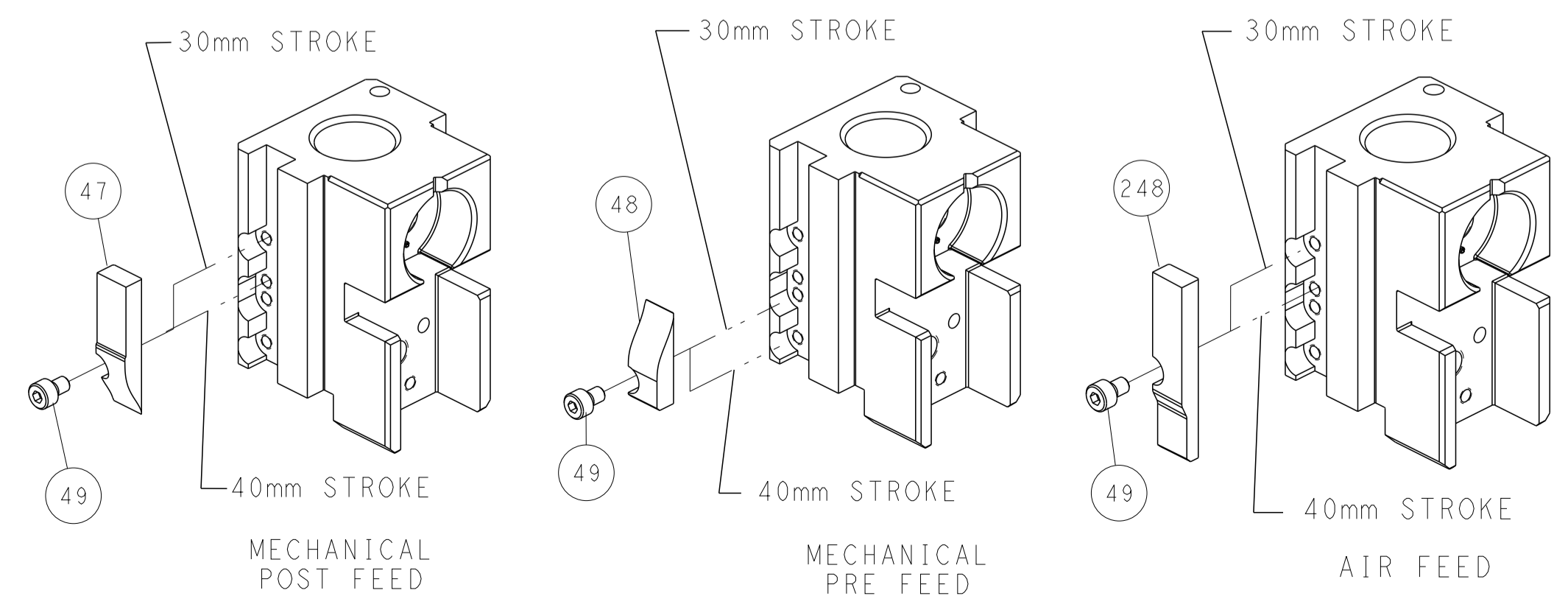


RAM SET-UP



ITEM 30 LOCATED AT REAR 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		DWN T. BROOKENS 20OCT2017 CHK M. HERR 20OCT2017 APVD J. ELBIN 20OCT2017 PRODUCT SPEC APPLICATION SPEC WEIGHT Customer Accessible Production Drawing		NAME Ocean Side Feed Applicator SIZE CAGE CODE DRAWING NO. A1 00779 C=2836931 SCALE 1:2 SHEET 2 OF 4 REV C		RESTRICTED TO TE Connectivity Harrisburg, PA 17105-3608	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2836931-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2836931-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2836931-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR  
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.20 mm [.087]	F
INSUL	2.80 mm [.110]	O

APPLICATOR INSTRUCTIONS  
408-35042

TERMINAL DATA: MOLEX TERMINAL		MOLEX CRIMP SPECIFICATION	
TERMINAL NAME: TERMINAL, CP 1.5 RECEPTACLE			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
4.10-4.90 mm [1.61-.193 IN]		Ø2.10-2.70 mm [.083-.106 IN]	
TERMINAL APPLICATION SPECIFICATION			
TERMINALS APPLIED			
TE TERMINAL	MOLEX TERMINAL	TE TERMINAL	MOLEX TERMINAL
1949147-1	98915-1039	1949147-3	64323-1039
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WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
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1.50mm2	1.55+/-0.05 [1.061+/-0.002]	7.5
1.40mm2	1.50+/-0.05 [1.059+/-0.002]	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.
  - TERMINAL LUBRICANT IS RECOMMENDED.
6. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.

**\*WARNING**  
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LOC	DIST	REVISIONS					
A	66	P	LTN	DESCRIPTION	DATE	DWN	APVD
-	-	-	-	SEE SHEET 1	-	-	-

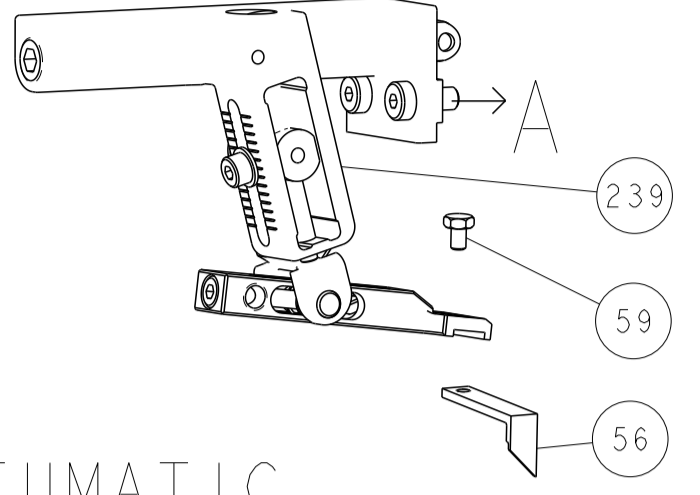
-	1	1	2119082-8	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
3	-	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
-	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	1	-	2844940-1	AIR FEED MODULE	238
-	REF	REF	994970-2	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
5	-	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	5018030-1	NUT, HEX, REG, RoHS, M3	52
-	1	1	811242-5	BUMPER, HOLD DOWN	51
-	1	1	690753-2	SPACER, TONKER	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	7-1752356-7	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	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	1-356885-4	STOP, SHEAR	11
1	-	1	2119805-1	SHEAR HOLDER, FRONT	10
1	-	1	1803095-6	FLOATING SHEAR, FRONT	9
1	1	1	2-1633138-0	ANVIL, COMBINATION	8
-	-	-	-	-	7
-	-	-	-	-	6
-	1	1	2119757-5	DEPRESSOR, SHEAR	5
-	1	1	7-238011-0	BLOCK, CRIMPER SPACER	4
1	1	1	2-1803453-0	CRIMPER, INSULATION O	3
-	1	1	455888-4	SPACER, CRIMPER	2
1	1	1	3-1490019-7	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)

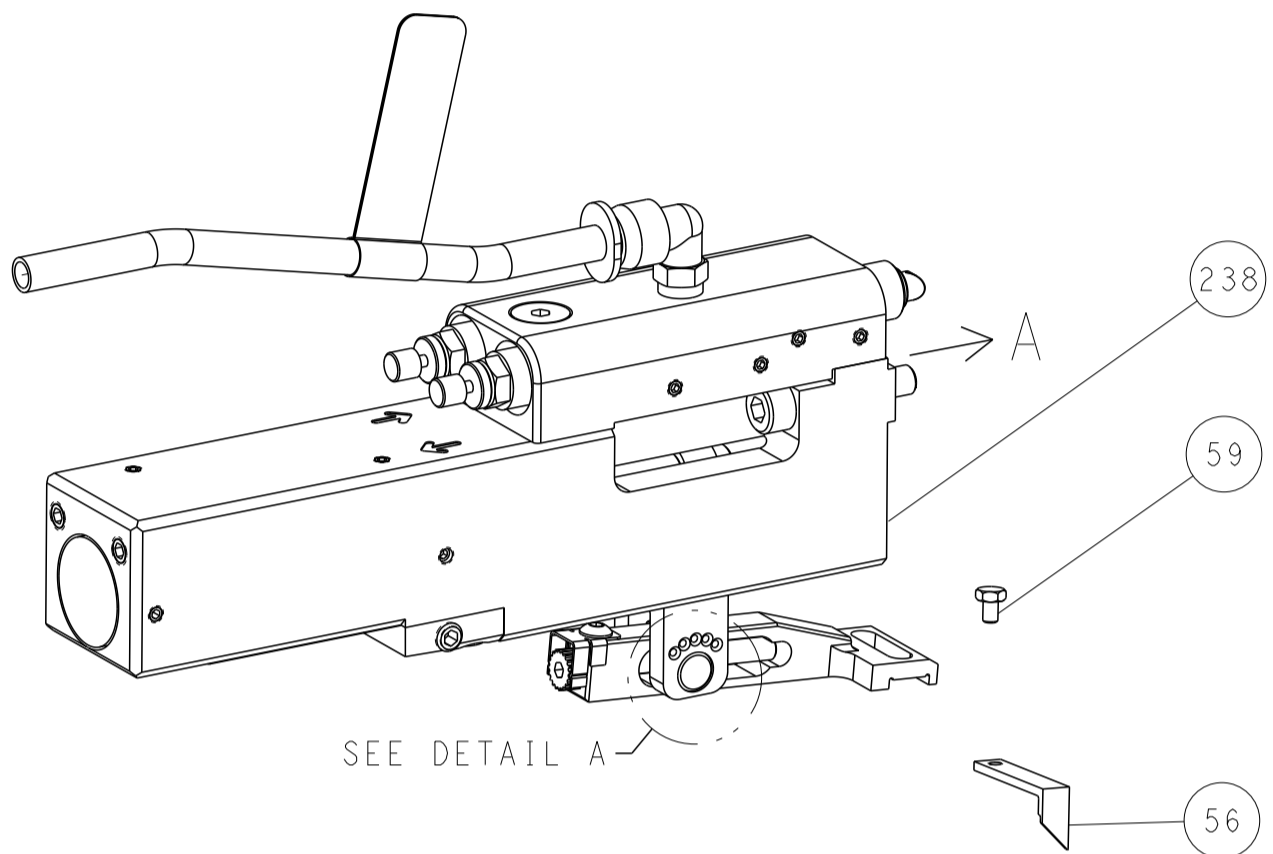
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN T. BROOKENS 20OCT2017		TE Connectivity	
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Ø		1 PLC ±		APVD T. ELBIN 20OCT2017		NAME	
H		2 PLC ±		PRODUCT SPEC		Ocean Side Feed	
L		3 PLC ±		APPLICATION SPEC		Applicator	
R		4 PLC ±		SIZE		CAGE CODE DRAWING NO	
ANGLES		FINISH		WEIGHT		RESTRICTED TO	
MATERIAL		SCALE		A1 00779 C=2836931		SHEET 3 OF 4	
FINISH		SCALE		Customer Accessible Production Drawing		REV C	

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

# FEED TYPE MECHANICAL



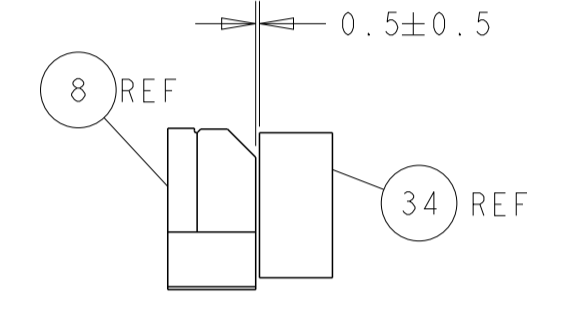
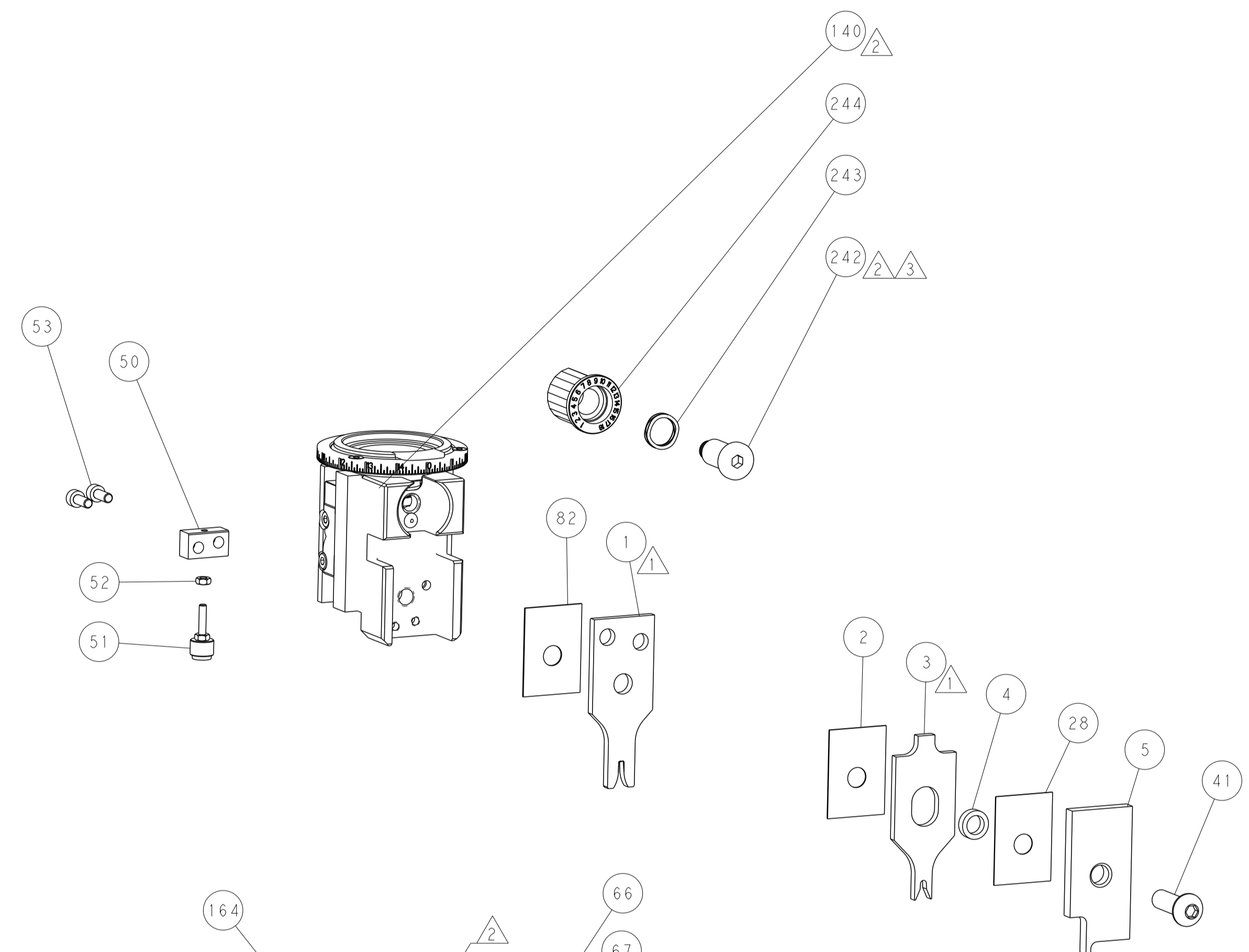
## PNEUMATIC



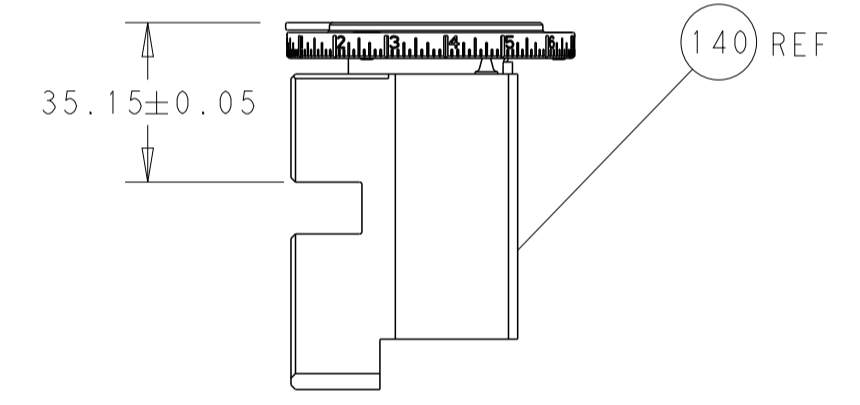
### FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



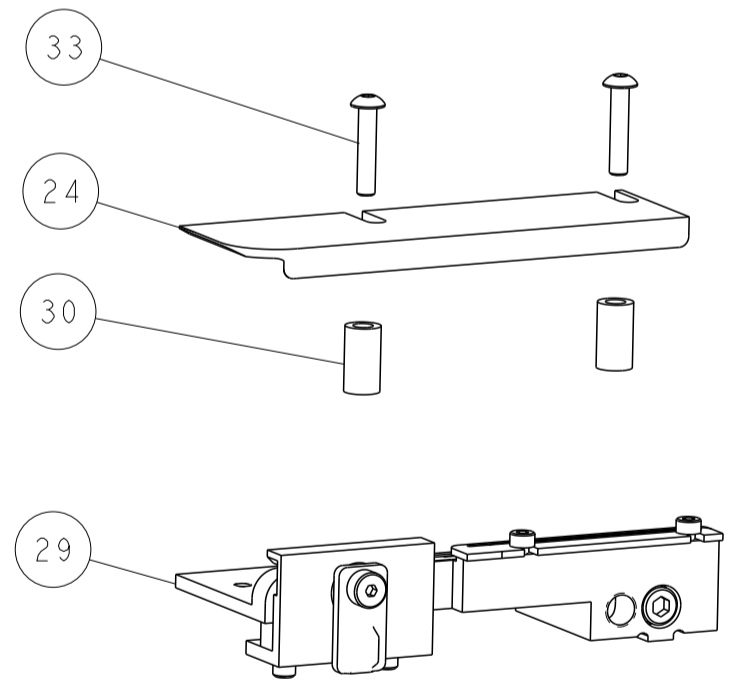
DETAIL A



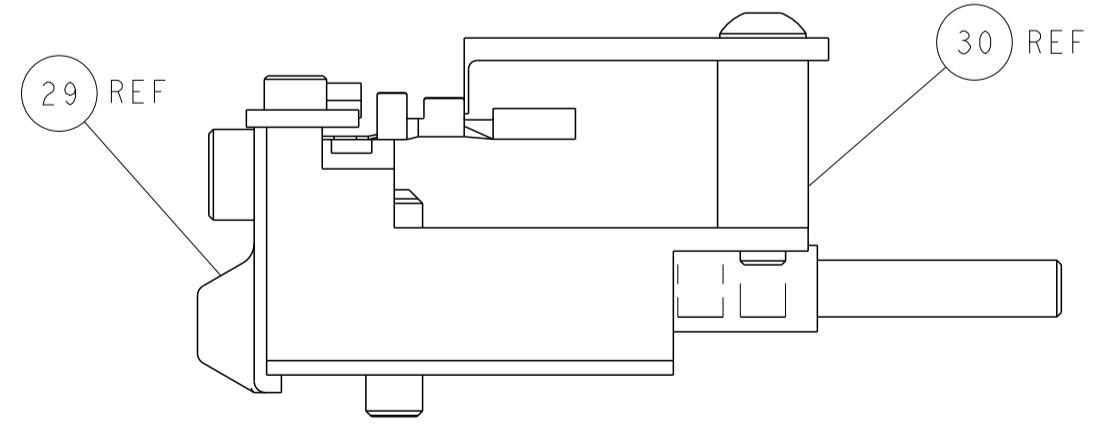
TERMINAL SUPPORT LOCATION



RAM SET-UP

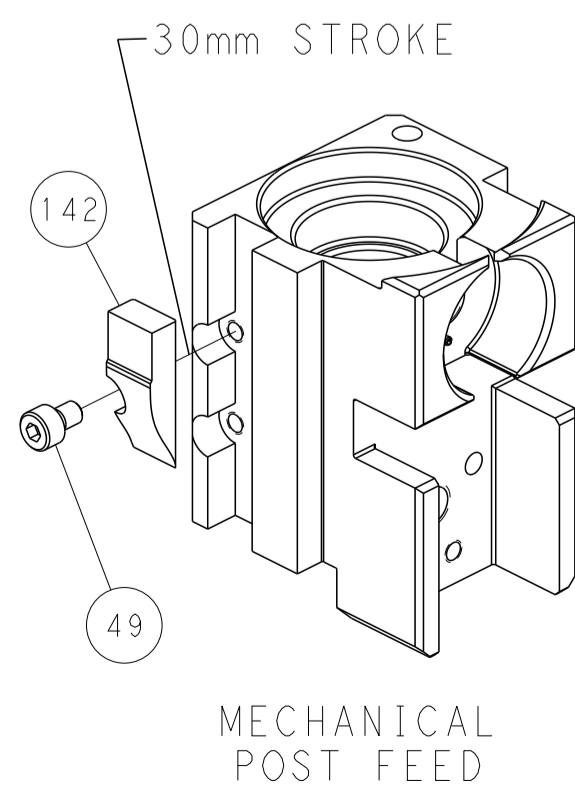


ITEM 30 LOCATED AT REAR HOLES

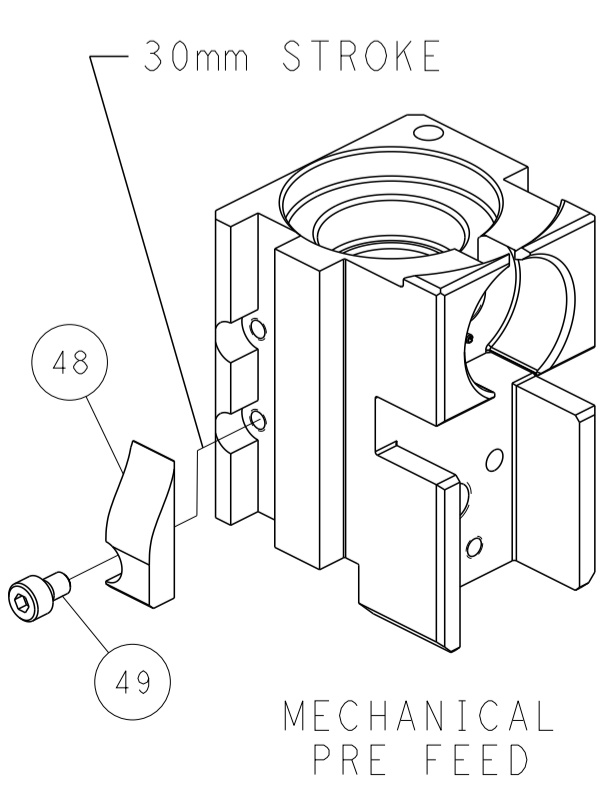


FEED TRACK POSITION GUIDE BY WIRE BARREL

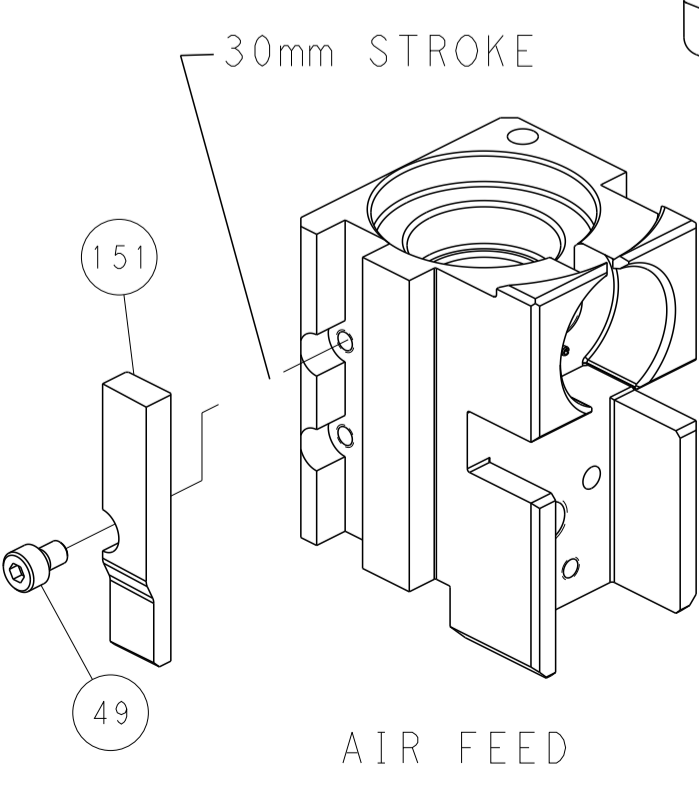
## CAM POSITIONS



MECHANICAL POST FEED



MECHANICAL PRE FEED



AIR FEED

**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:		DWN T. BROOKENS 20OCT2017		TE Connectivity	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES ±	FINISH ±
MATERIAL		WEIGHT		SCALE	1:2	SHEET	4 OF 4
Customer Accessible Production Drawing				RESTRICTED TO			