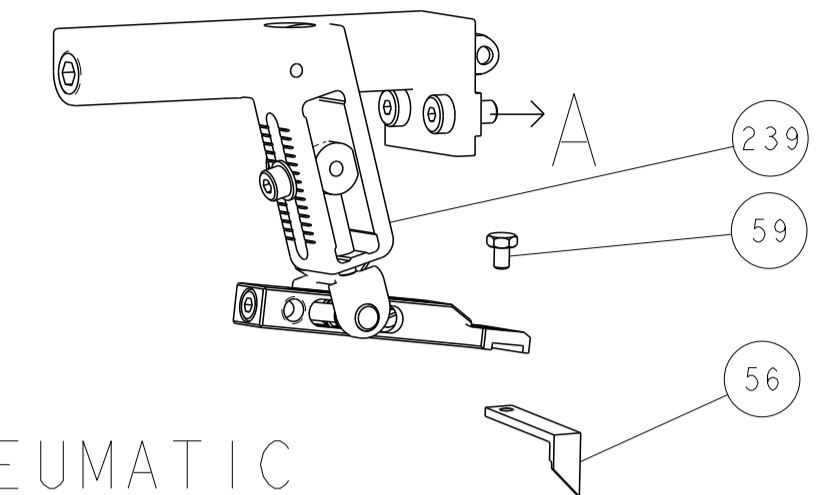
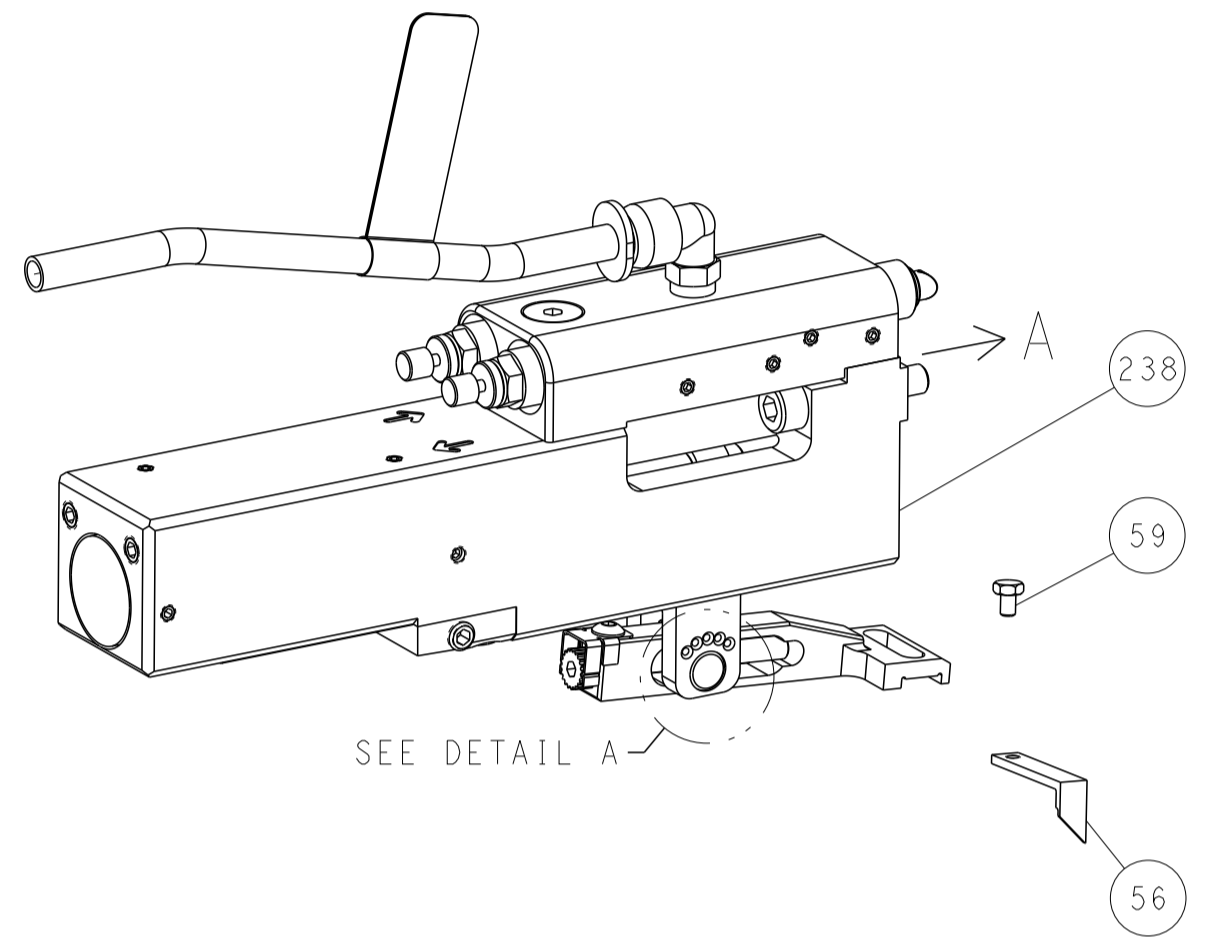


LOC	DIST	REV	DATE	BY	APPV
A	66				

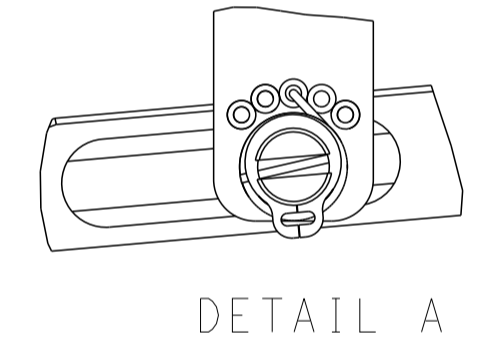
FEED TYPE MECHANICAL



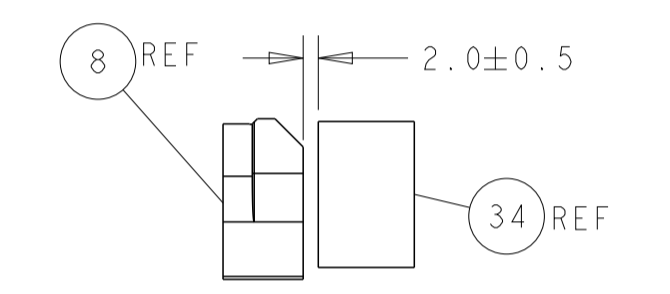
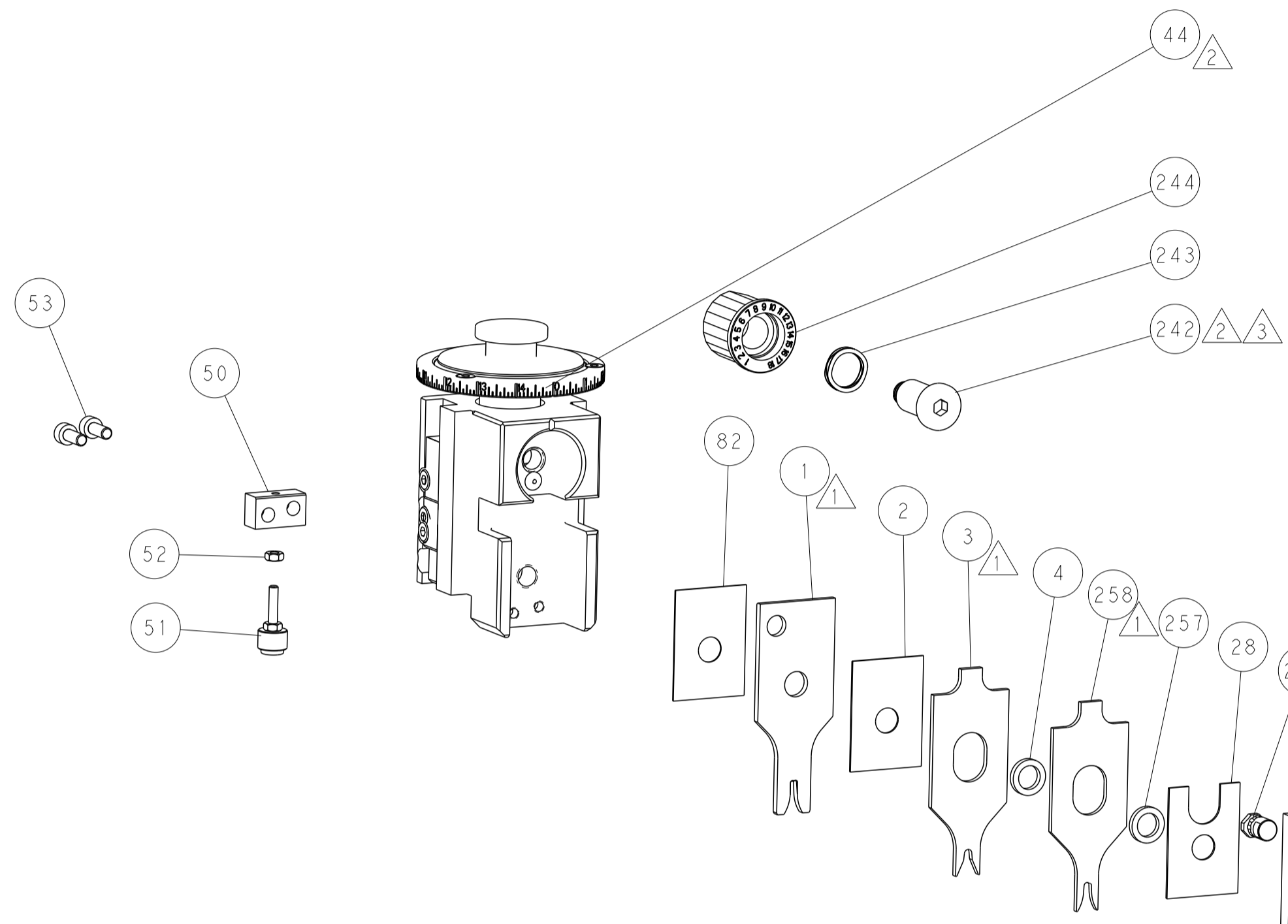
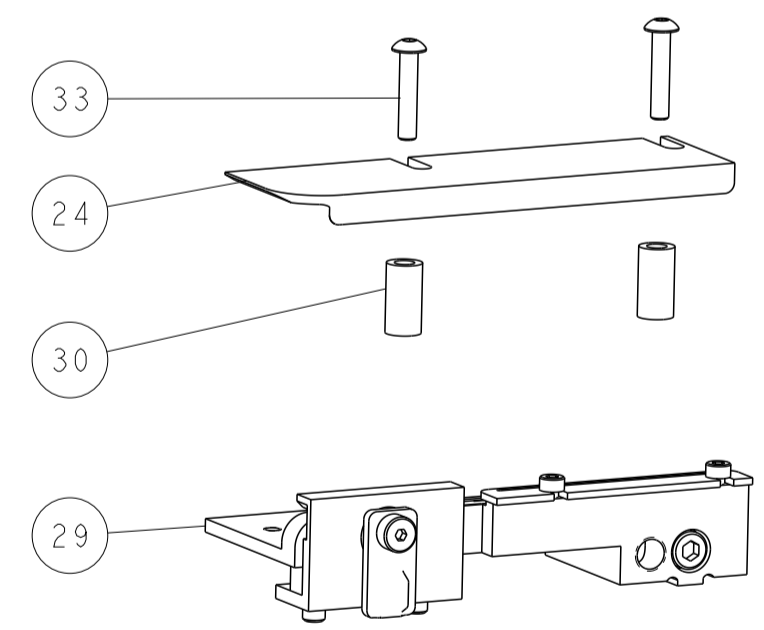
PNEUMATIC



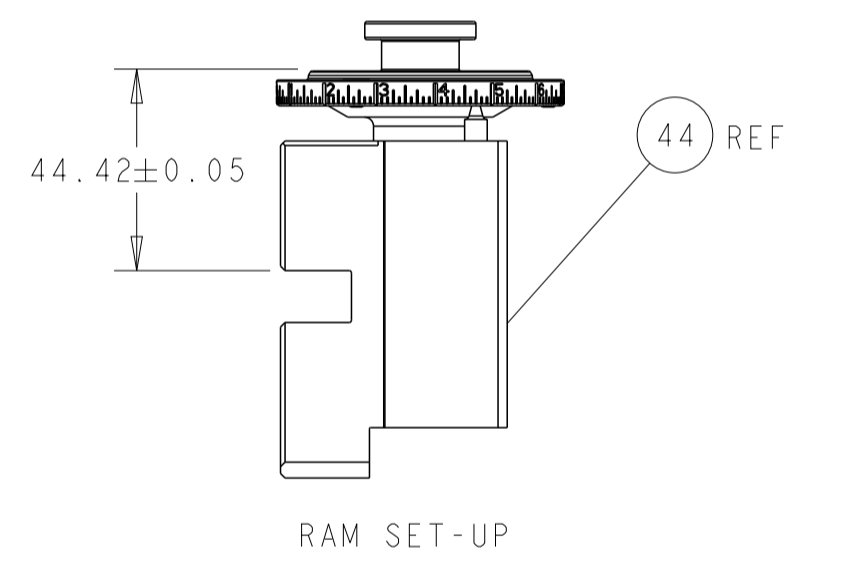
FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



DETAIL A

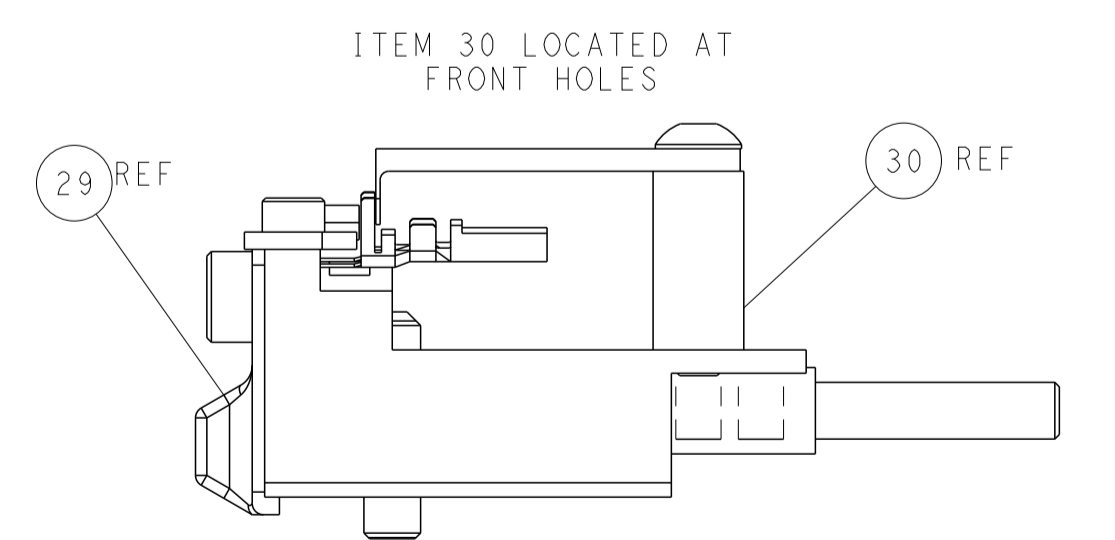
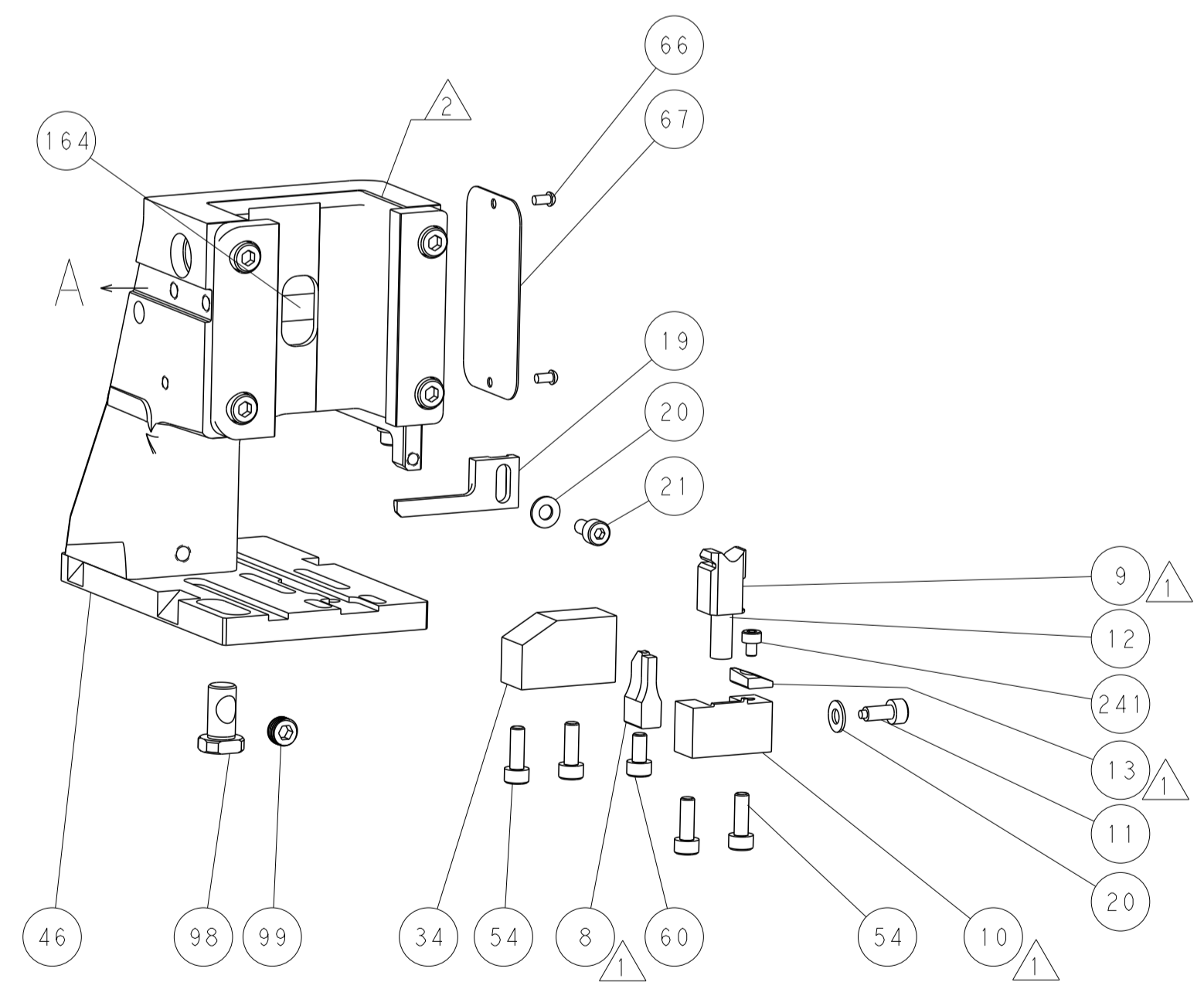
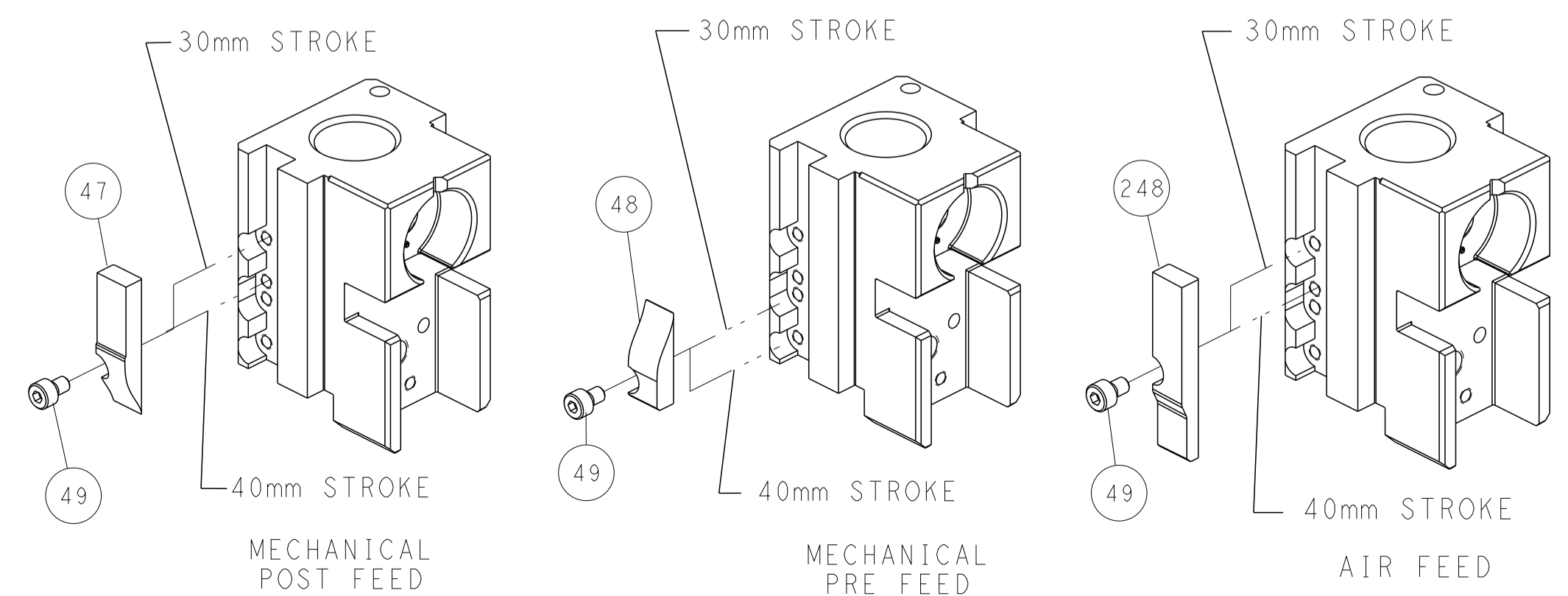


TERMINAL SUPPORT LOCATION



RAM SET-UP

CAM POSITIONS



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:		DWG: M. ZHAO 19OCT2017		TE Connectivity	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	Harrisburg, PA 17105-3608	
MATERIAL:		FINISH:		CHK: K. ZHANG 19OCT2017		NAME: Ocean Side Feed Applicator	
				APVD: K. ZHANG 19OCT2017		SIZE: CAGE CODE: DRAWING NO: RESTRICTED TO	
				PRODUCT SPEC:		A1 00779 ©=2836970	
				APPLICATION SPEC:		Customer Accessible Production Drawing	
				WEIGHT:		SCALE: 1:2 SHEET 2 OF 4 REV E	

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2836970-1	E	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2836970-2	E	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2836970-7	E	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
 INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.29 mm [.090]	F
INSUL	2.79 mm [.110]	O
STAB	2.79 mm [.110]	F

APPLICATOR INSTRUCTIONS
 408-35042

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: .070 SERIES RECEPTACLE CONTACT			
WIRE STRIP LENGTH 3.30-3.80 mm [.130-.150 IN]		INSULATION DIAMETER RANGE Ø1.20-2.20 mm [.047-.087 IN]	
TERMINAL APPLICATION SPECIFICATION 114-5156			
TERMINALS APPLIED 5			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
175221-1	175221-2		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING 4	STABILIZER CRIMP HEIGHT mm [INCH] 5	STABILIZER SETTINGS
1.25mm2	1.52+/-0.05 [.060+/-0.002]	8.1	4.40+/-0.10 [.172+/-0.004]	7
0.85mm2	1.37+/-0.05 [.054+/-0.002]	9.8	4.40+/-0.10 [.172+/-0.004]	5
0.50mm2	1.25+/-0.05 [.049+/-0.002]	10.8	4.40+/-0.10 [.172+/-0.004]	4



- 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.
- APPLICATOR WAS QUALIFIED TO STABILIZER CRIMP HEIGHT LISTED FOR ALL TERMINALS.
- 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.

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	1	2119785-5	CRIMPER, INSULATION OVERLAP PREMIUM	258
-	1	1	238011-7	BLOCK, CRIMPER SPACER	257
-	1	1	2119348-3	SNAIL CAM, STABILIZER CRIMP ADJUSTMENT	256
-	2	2	2079844-1	PLUNGER, BALL	255
-	1	1	2119347-1	KNOB, STABILIZER CRIMP ADJUSTMENT	254
-	1	1	18032-1	SCR, SET, FLT PNT, M3 X 5.0	253
-	1	1	2119082-5	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	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	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	1752356-3	SUPPORT, TERMINAL	34
-	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	3-2844962-2	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29
-	1	1	2119797-2	SPACER, CRIMPER, SPECIAL	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	1	2119806-1	INSERT, SHEAR	13
-	1	1	3-22280-3	SPRING, COMPRESSION	12
-	1	1	1-356885-4	STOP, SHEAR	11
1	1	1	2119805-1	SHEAR HOLDER, FRONT	10
1	1	1	1803095-6	FLOATING SHEAR, FRONT	9
1	1	1	4-1633921-0	ANVIL, COMBINATION	8
-	-	-	-	-	7
-	-	-	-	-	6
-	1	1	2119349-2	SHEAR DEPRESSOR, STAB. CRIMP ADJ.	5
-	1	1	238011-5	BLOCK, CRIMPER SPACER	4
1	1	1	1-1803019-0	CRIMPER, INSULATION O	3
-	1	1	455888-5	SPACER, CRIMPER	2
1	1	1	1-456406-8	CRIMPER, WIRE PREMIUM	1

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

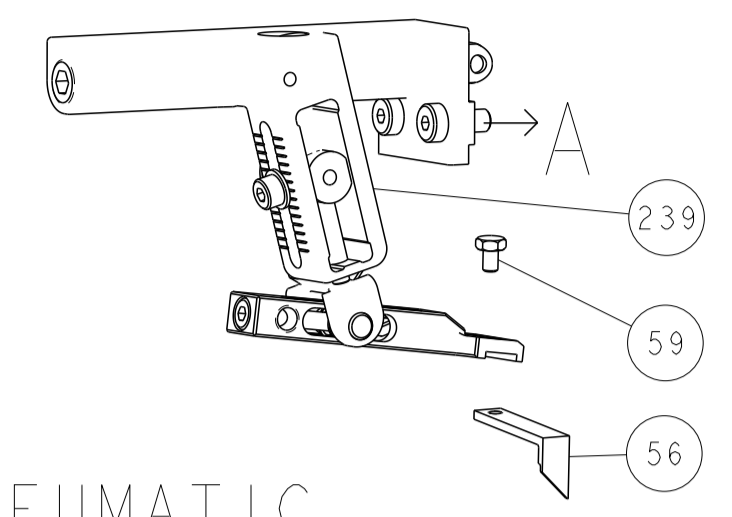
ITEM NO	PART NO	DESCRIPTION
-77	-22	-21

OWN	M. ZHAO	19OCT2017
CHK	K. ZHANG	19OCT2017
APVD	K. ZHANG	19OCT2017

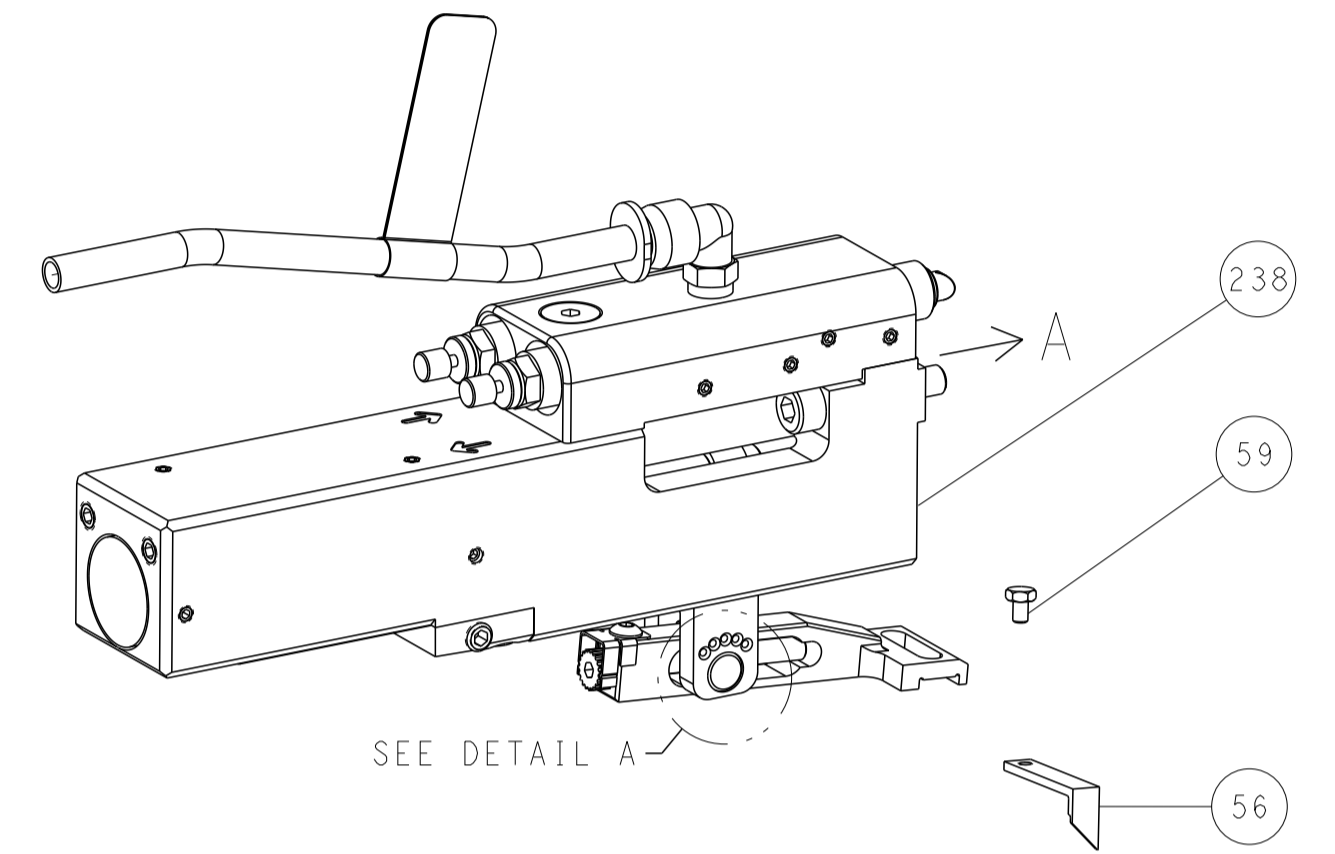
Customer Accessible Production Drawing

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

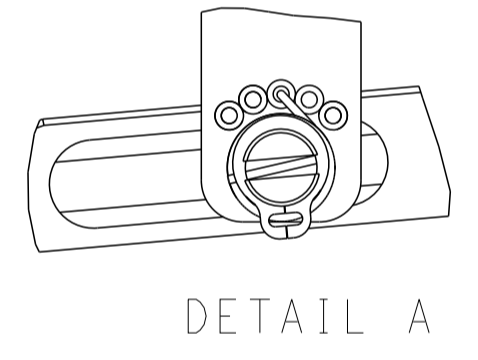
FEED TYPE MECHANICAL



PNEUMATIC

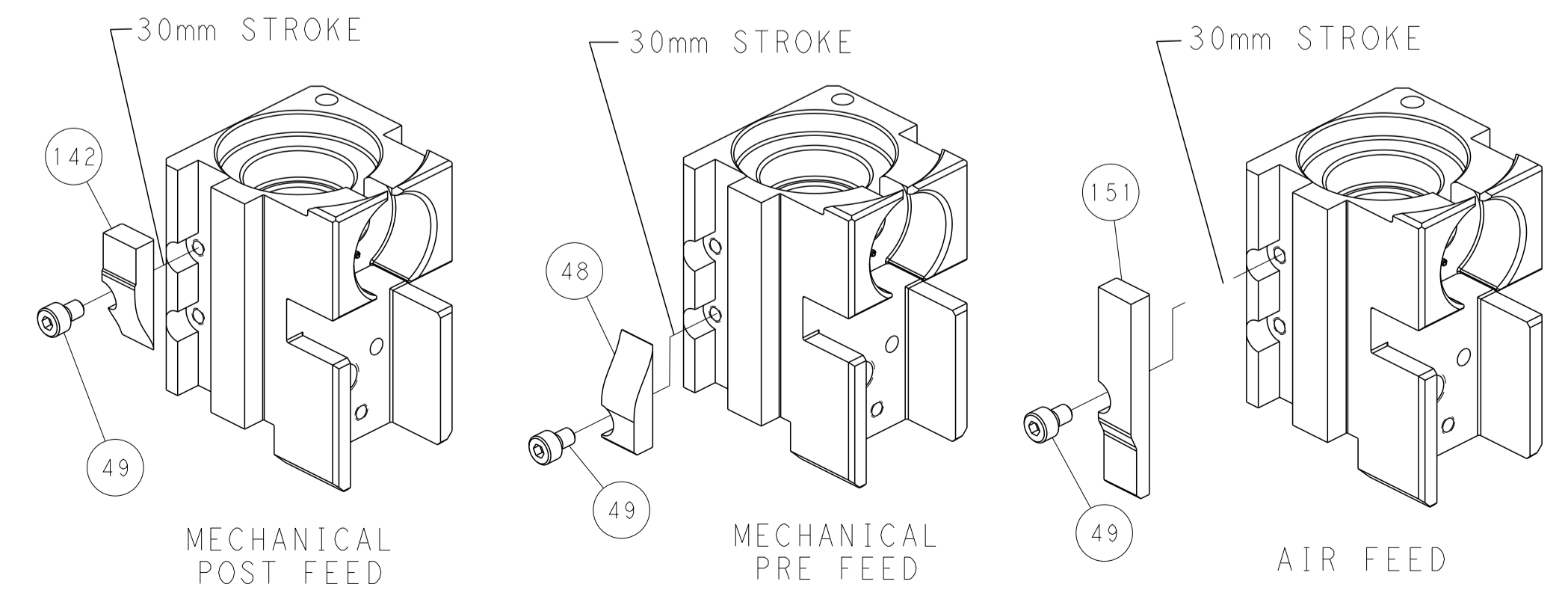


FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



DETAIL A

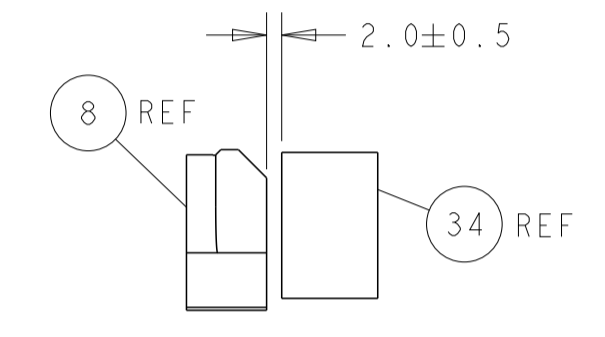
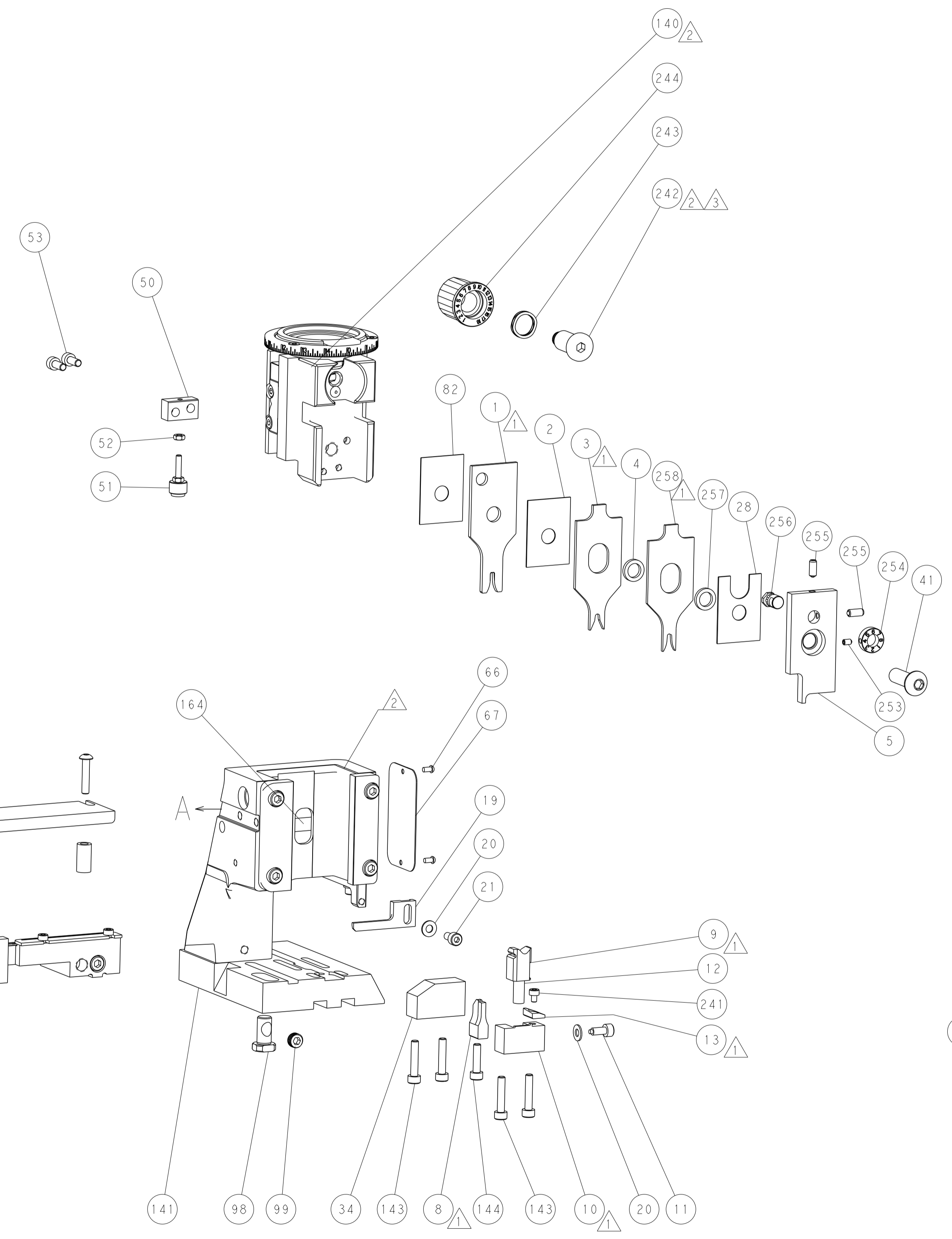
CAM POSITIONS



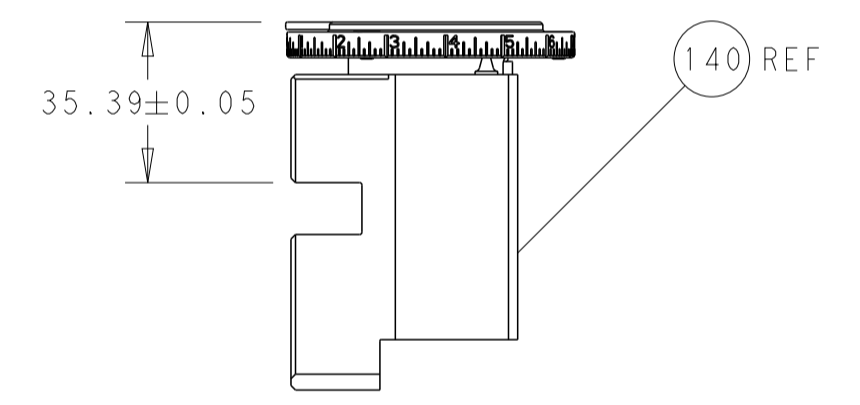
MECHANICAL
POST FEED

MECHANICAL
PRE FEED

AIR FEED

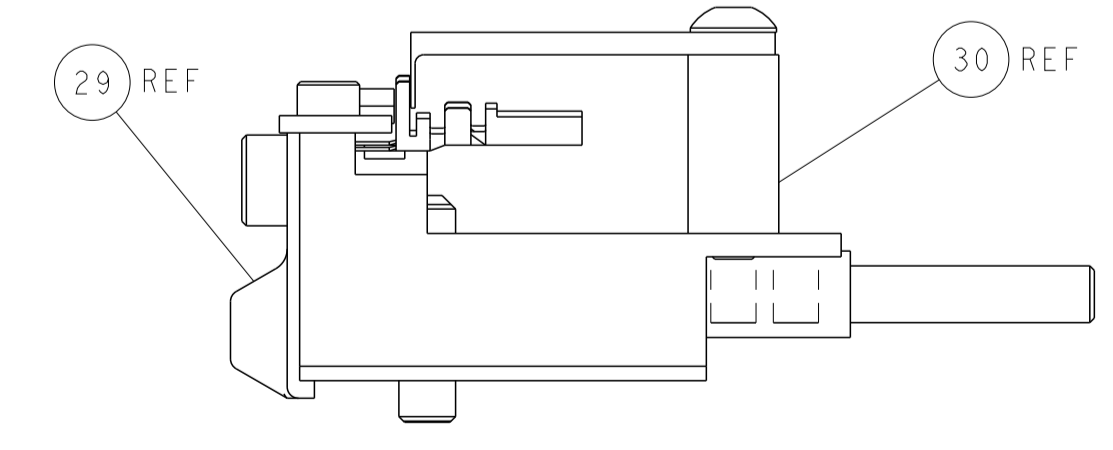


TERMINAL SUPPORT LOCATION



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 APPLICATION SPEC: - SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2836970	RESTRICTED TO: - SCALE: 1:2 SHEET: 4 OF 4 REV: E
MATERIAL: - FINISH: -		WEIGHT: - Customer Accessible Production Drawing	SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION