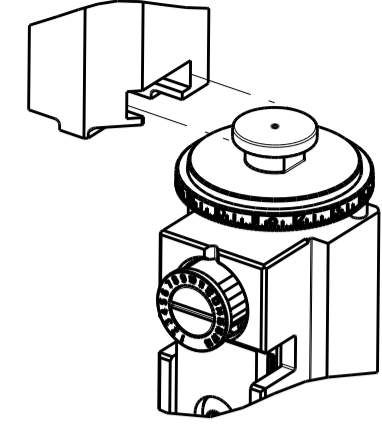


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2836042-1	E	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2836042-2	E	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2836042-1	E	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2836042-2	E	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2836042-7	D	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.55 mm [1.061]	F
INSUL	-	-

APPLICATOR INSTRUCTIONS
408-35042

TERMINAL DATA: HI-STAT TERMINAL Season Group CRIMP SPECIFICATION	
TERMINAL NAME: TERMINAL-WELD	
WIRE STRIP LENGTH 4.35-5.11 mm [1.71-.201 IN]	INSULATION DIAMETER RANGE Ø -
TERMINAL APPLICATION SPECIFICATION Season Group Rev 9-2-15	
TERMINALS APPLIED	
TE TERMINAL 1949704-1	HI-STAT TERMINAL 503-558-00

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
20 AWG	1.25 +/- 0.05 [1.049 +/- .002]	8.4

- 1 RECOMMENDED SPARE PARTS
- 2 REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- 3 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.
- 4. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- 5 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	REV	LTN	DESCRIPTION	DATE	OWN	APVD
A	66	B		ECR-17-003917	17MAR2017	MR	GB
		C		ECR-17-006937	12MAY2017	TB	GB
		D		ECR-18-005926	18APR2018	TB	GB
		E		ECR-19-010172	28JUN2019	FZ	TE

-	1	-	1	-	2119640-1	PUSH ROD, AIR FEED	250	
-	1	-	1	-	1803259-1	BUSHING, FLANGED	249	
-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248	
-	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	-	2063440-1	AIR FEED MODULE	238	
-	2	-	2	-	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172	
-	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164	
-	1	-	1	-	240638-1	SPRING, FEED FINGER	163	
-	1	-	1	-	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854	137	
-	1	-	1	-	2119799-1	HOLDER, FEED FINGER, AF	136	
-	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	455888-4	SPACER, CRIMPER	82	
-	1	1	1	1	1803607-1	DOCUMENTATION PACKAGE	71	
-	1	1	1	1	2119791-9	DEPRESSOR, WIRE	70	
-	1	1	1	1	2119943-1	WASHER, SPACER	69	
-	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	
-	2	2	2	2	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	690753-6	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	
-	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33	
-	2	2	2	2	2-2844962-3	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	2119533-9	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	318707-1	FLOATING SHEAR, FRONT	9	
-	1	2	2	1	1	5-1633933-5	ANVIL, COMBINATION	8
-	1	1	1	1	4-240641-3	SPACER	7	
-	-	-	-	-	-	-	6	
-	1	1	1	1	2119757-1	DEPRESSOR, SHEAR	5	
-	-	-	-	-	-	-	4	
-	-	-	-	-	-	-	3	
-	-	-	-	-	-	-	2	
-	1	2	2	1	1	8-1633713-1	CRIMPER, WIRE PREMIUM	1

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

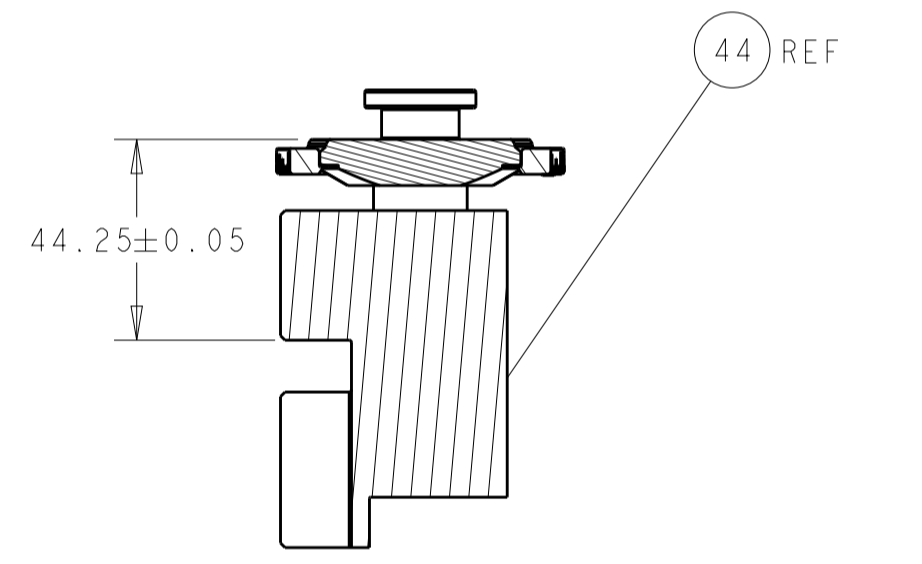
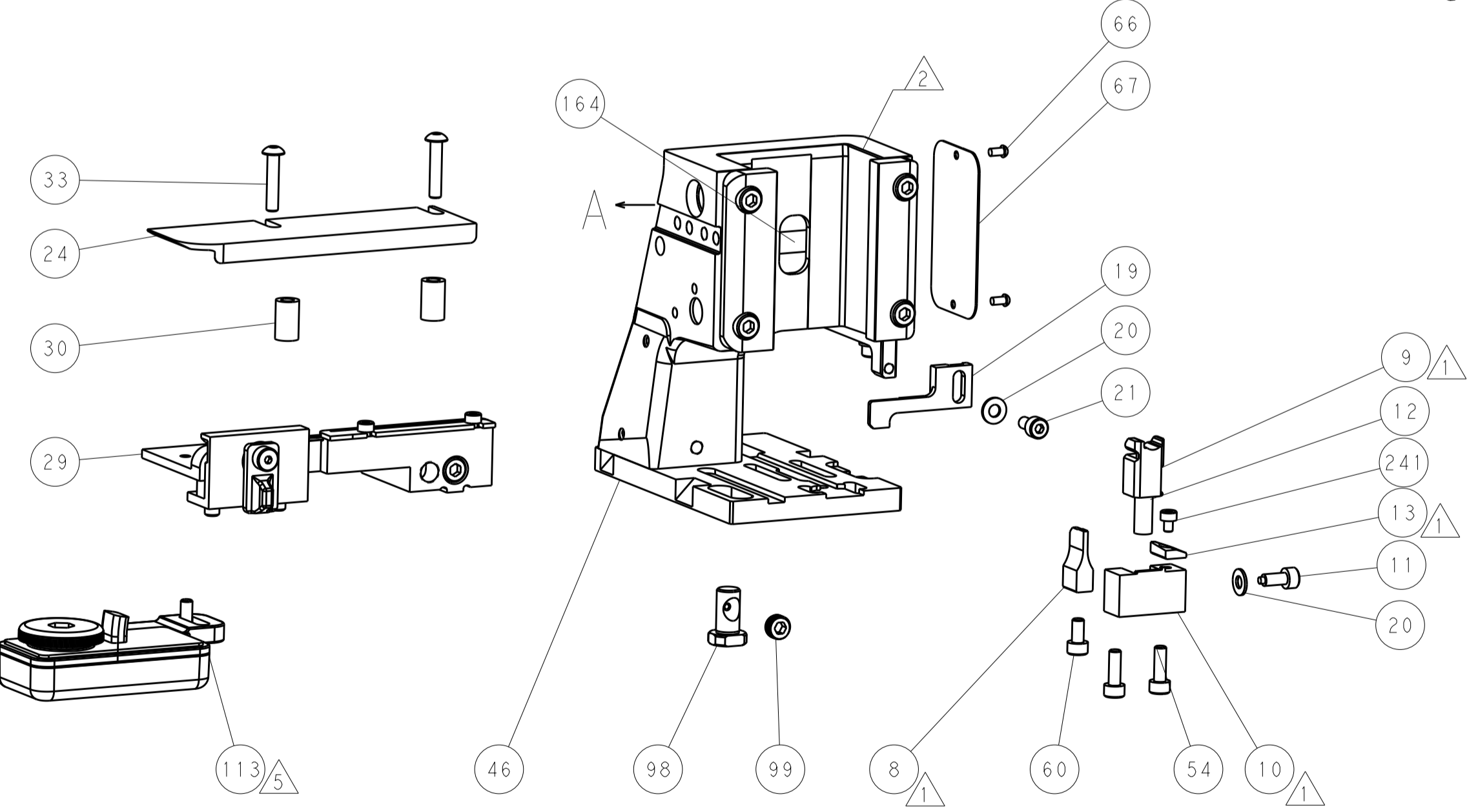
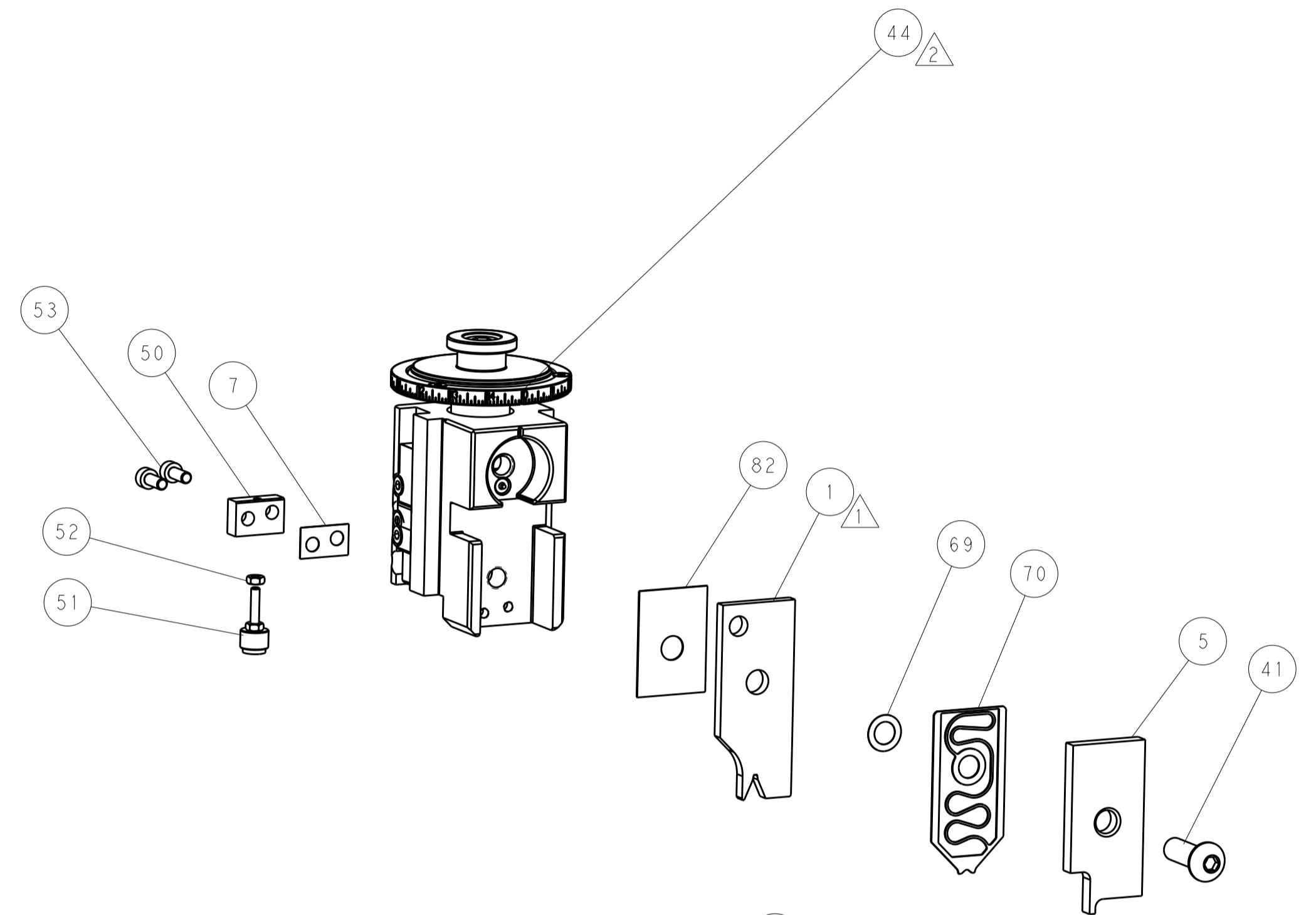
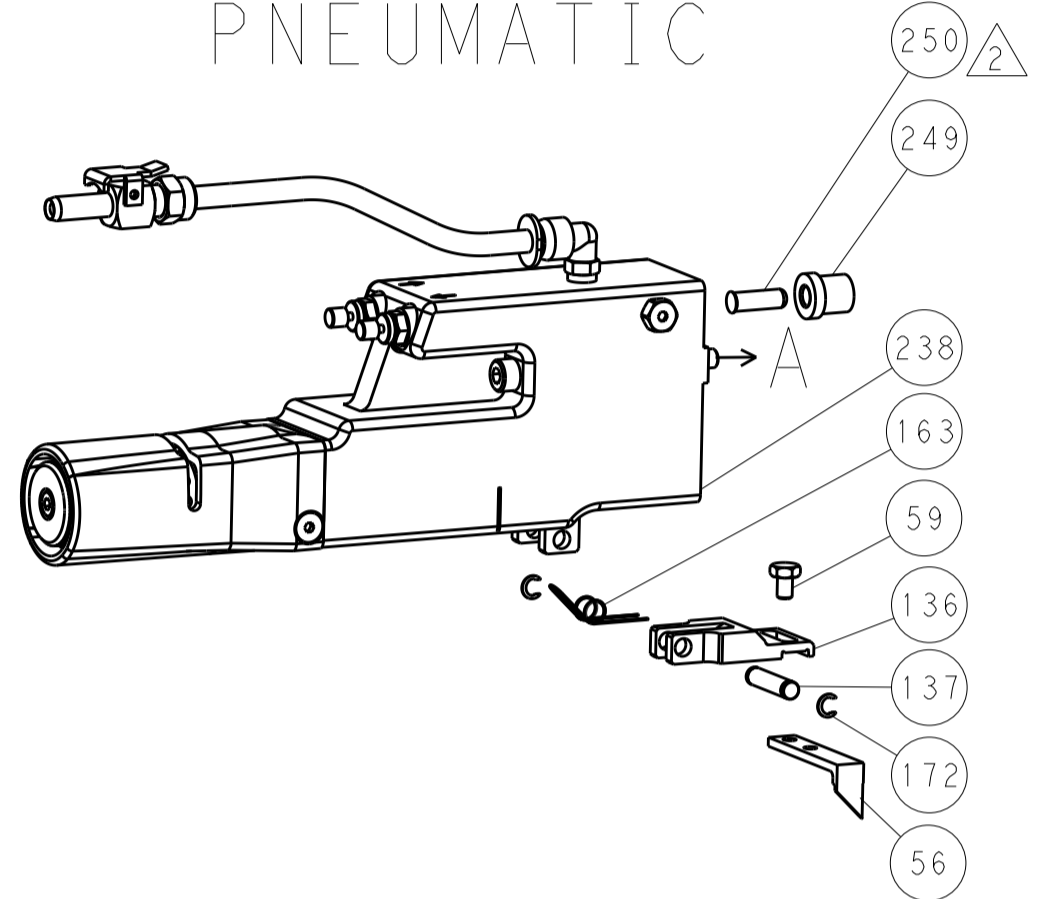
OWN	HOFFNER	08SEP2015	TE Connectivity
CHK	T. ELBIN	09SEP2015	Harrisburg, PA 17105-3608
APVD	T. ELBIN	09SEP2015	
PRODUCT SPEC	Ocean Side Feed Applicator		
APPLICATION SPEC			
SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
A1	00779	2836042	
Customer Accessible Production Drawing			SCALE 1:2 SHEET 1 OF 4 REV E

LOC	DIST	REV	DATE	BY	APP'D
A	66				

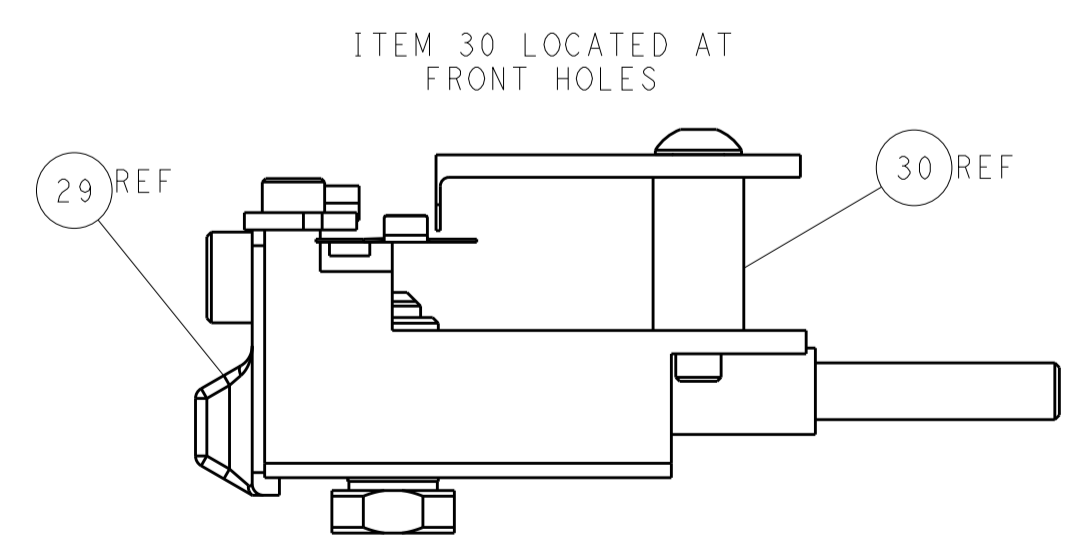
FEED TYPE MECHANICAL



PNEUMATIC

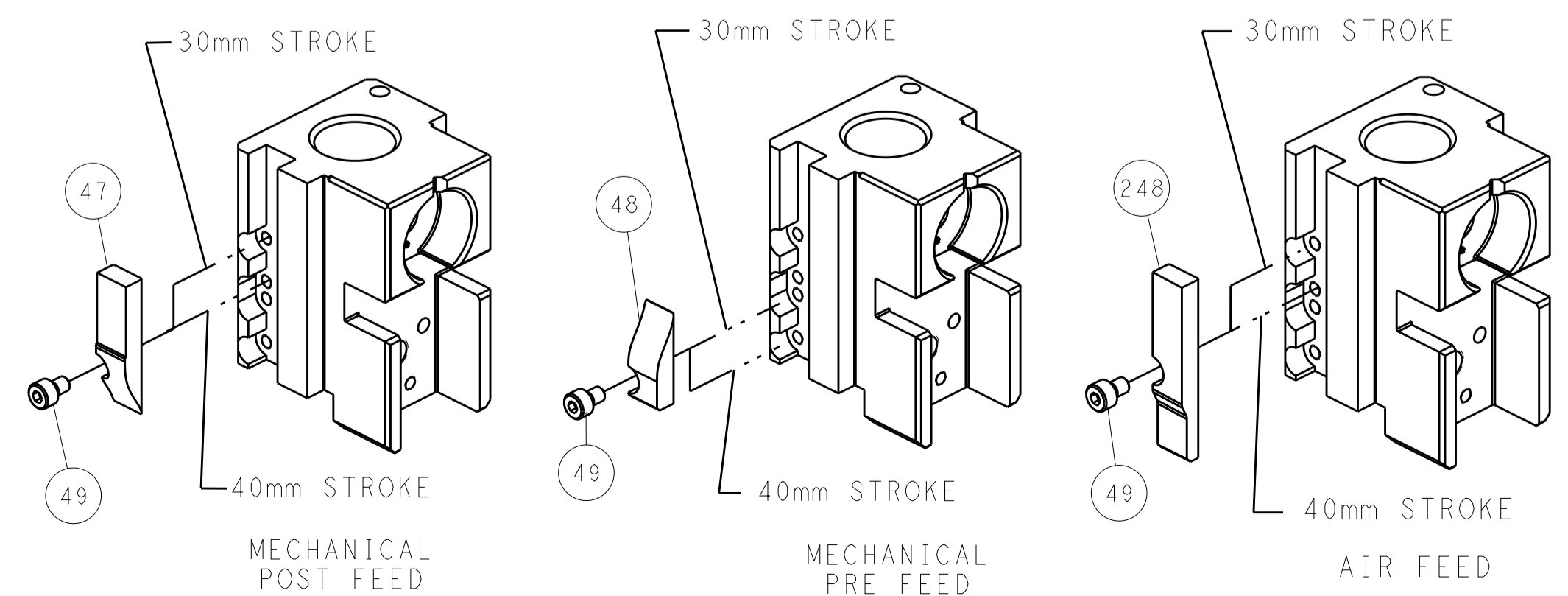


RAM SET-UP



FEED TRACK POSITION GUIDE BY WIRE BARREL

CAM POSITIONS

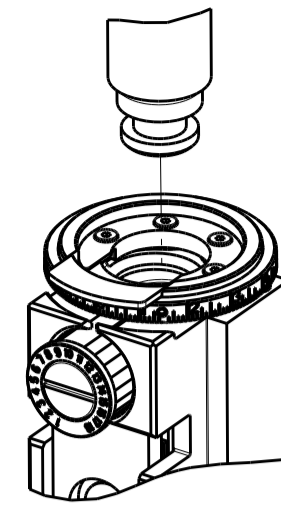


ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		DWN: HOFFNER 08SEP2015 CHK: T. ELBIN 09SEP2015 APVD: T. ELBIN 09SEP2015 PRODUCT SPEC APPLICATION SPEC WEIGHT Customer Accessible Production Drawing		NAME: Ocean Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2836042 SCALE: 1:2 SHEET: 2 of 4 REV: E	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2836042-1	E	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2836042-2	E	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2836042-7	D	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER

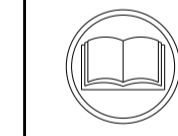


APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.55 mm [.0611]	F
INSUL	-	-

APPLICATOR INSTRUCTIONS
408-35042

TERMINAL DATA: HI-STAT TERMINAL Season Group CRIMP SPECIFICATION			
TERMINAL NAME: TERMINAL-WELD			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
4.35-5.11 mm [1.71-.201 IN]		\varnothing	
TERMINAL APPLICATION Season Group Rev 9-2-15			
TERMINALS APPLIED Δ			
TE TERMINAL	HI-STAT TERMINAL	TE TERMINAL	HI-STAT TERMINAL
1949704-1	503-558-00		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
20 AWG	1.25+/-0.05 [1.049+/-0.02]	8.4



- Δ RECOMMENDED SPARE PARTS
- Δ REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- Δ 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.
- 4. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- Δ 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)

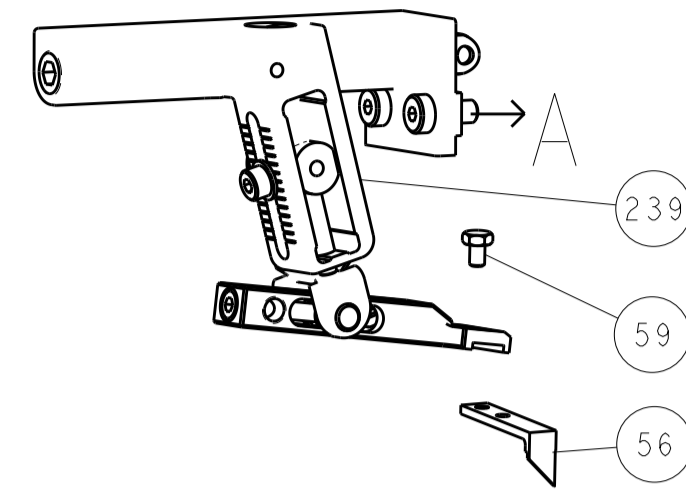
LOC	DIST	REV	DATE	BY	APPD
A	66	-	-	-	-

REV	DATE	BY	APPD	DESCRIPTION	DATE	BY	APPD
-	1	-	-	2119640-1	PUSH ROD, AIR FEED	-	250
-	1	-	-	1803259-1	BUSHING, FLANGED	-	249
-	1	1	-	7-18023-7	SCR, SKT HD CAP M3 X 4.0	-	241
-	-	1	-	2119580-1	MECHANICAL FEED ASSEMBLY	-	239
-	1	-	-	2063440-1	AIR FEED MODULE	-	238
-	2	-	-	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	-	172
-	REF	REF	-	994970-2	COUNTER, MAGNETIC	-	164
-	1	-	-	240638-1	SPRING, FEED FINGER	-	163
-	1	-	-	2119641-2	FEED CAM, AIR FEED	-	151
-	1	1	-	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	-	144
-	2	2	-	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	-	-	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854	-	137
-	1	-	-	2119799-1	HOLDER, FEED FINGER, AF	-	136
Δ	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	-	455888-4	SPACER, CRIMPER	-	82
-	1	1	-	1803607-1	DOCUMENTATION PACKAGE	-	71
-	1	1	-	2119791-9	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	-	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	-	5018030-1	NUT, HEX, REG, RoHS, M3	-	52
-	1	1	-	811242-5	BUMPER, HOLD DOWN	-	51
-	1	1	-	690753-6	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
-	2	2	-	2079383-5	SCR, BHSC, RoHS (M4 X 20)	-	33
-	2	2	-	2-2844962-3	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	-	2119533-9	STRIPPER, SIDE FEED	-	19
Δ	1	1	-	2119806-1	INSERT, SHEAR	-	13
-	1	1	-	3-22280-3	SPRING, COMPRESSION	-	12
-	1	1	-	1-356885-4	STOP, SHEAR	-	11
Δ	1	1	-	2119805-1	SHEAR HOLDER, FRONT	-	10
Δ	1	1	-	318707-1	FLOATING SHEAR, FRONT	-	9
Δ	1	1	1	5-1633933-5	ANVIL, COMBINATION	-	8
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Δ	1	1	1	8-1633713-1	CRIMPER, WIRE PREMIUM	-	1

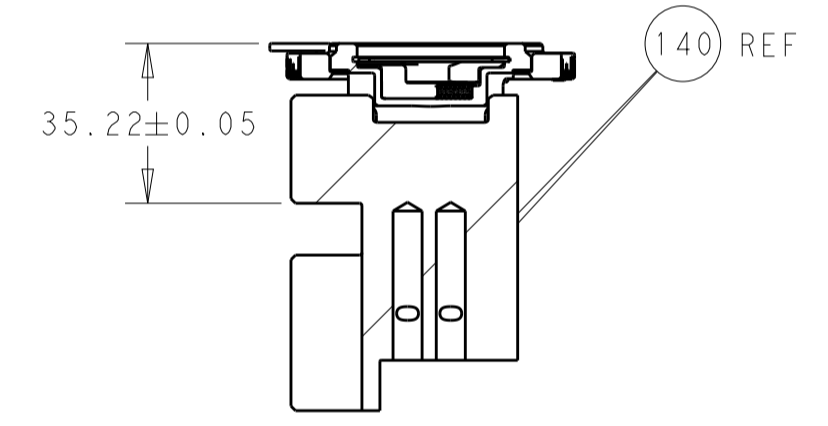
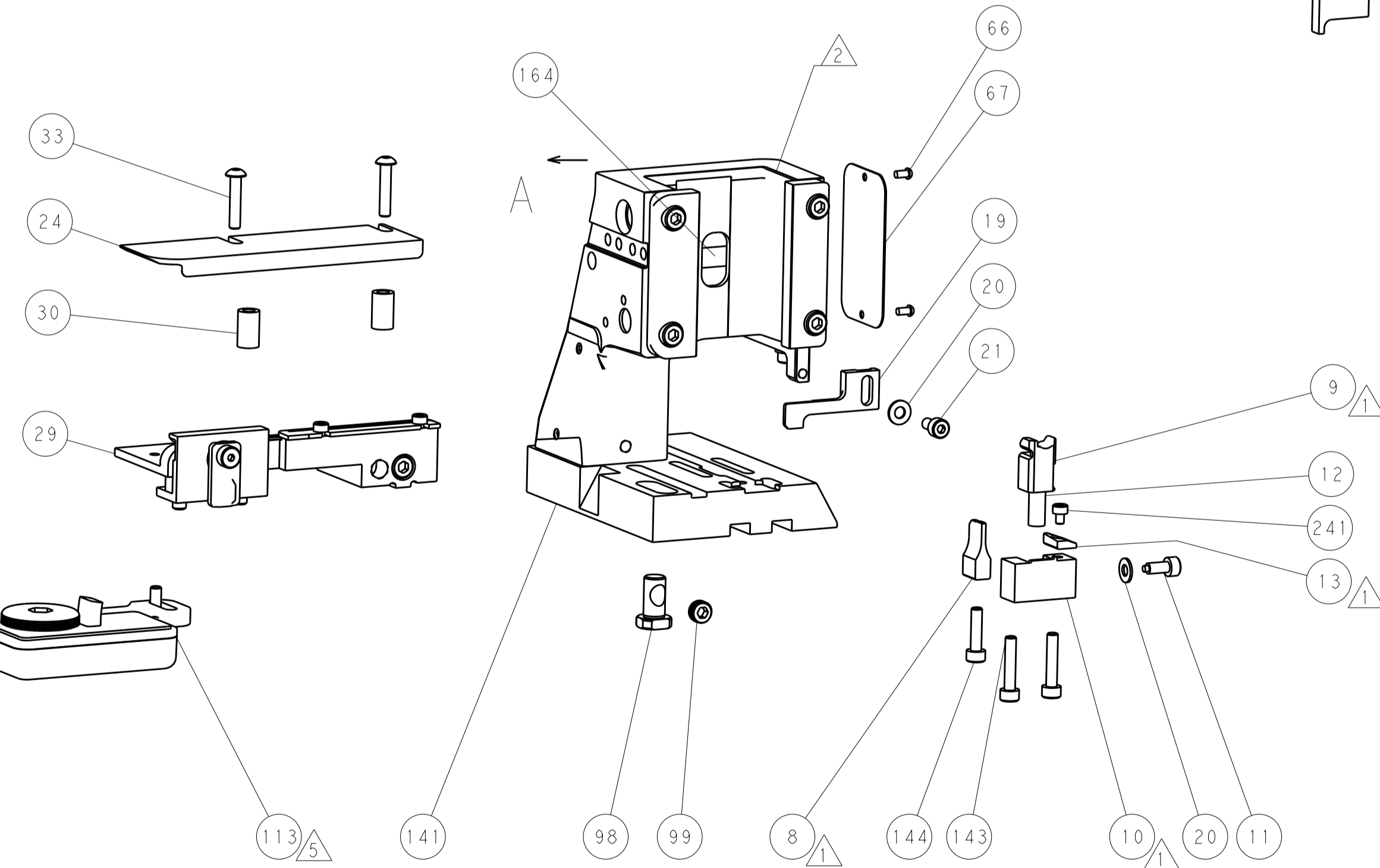
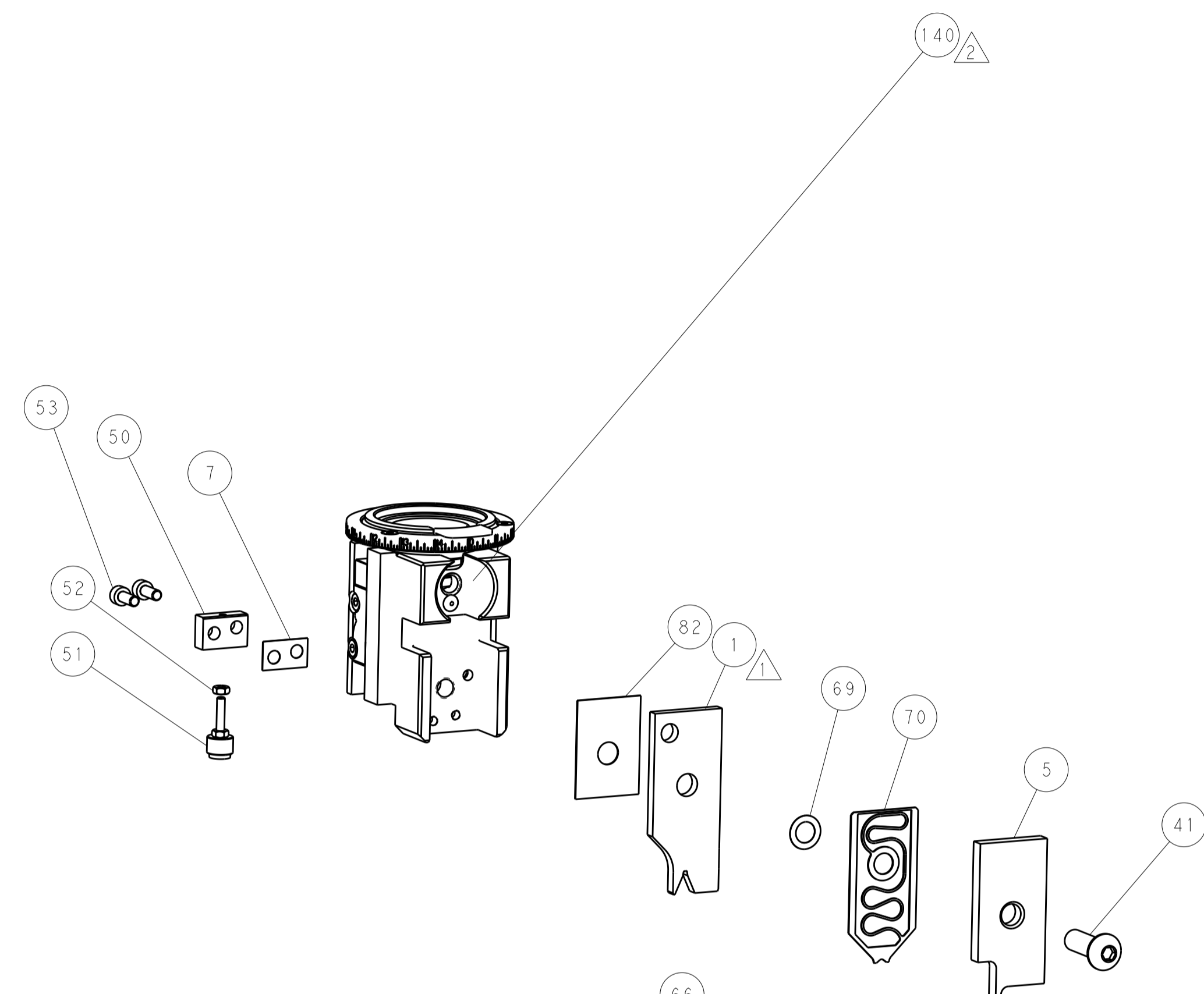
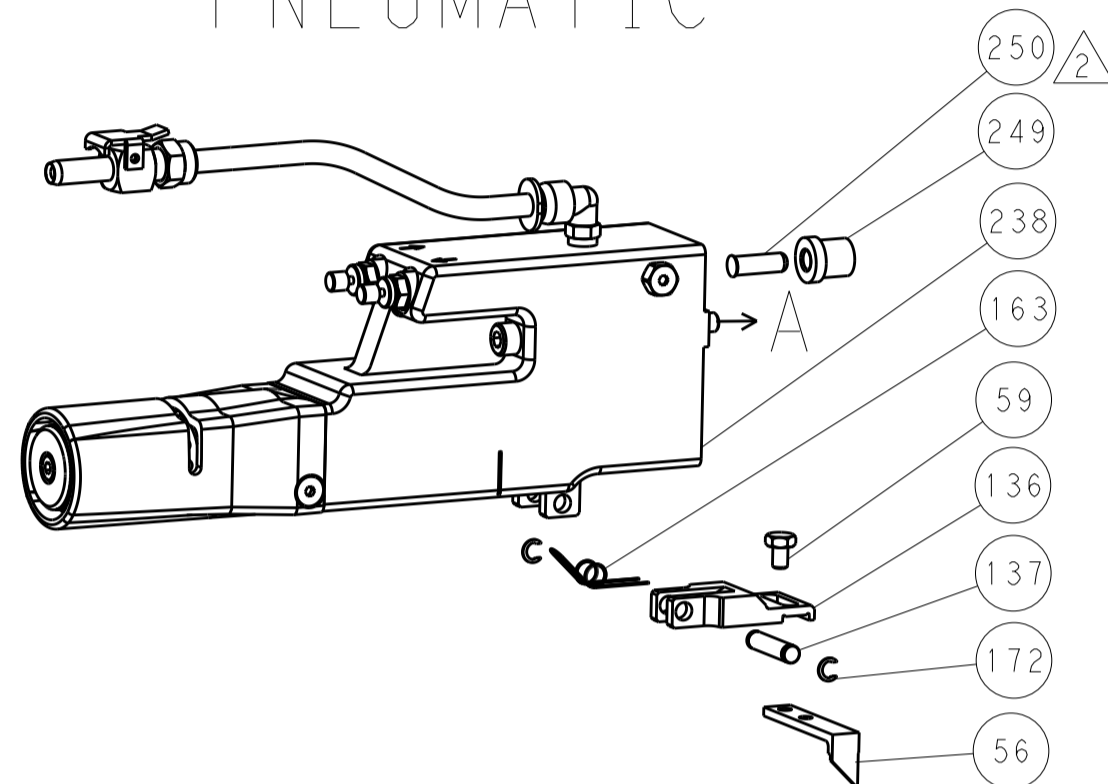
<small>THIS DRAWING IS UNPUBLISHED. IT IS THE PROPERTY OF TYCO ELECTRONICS CORPORATION. IT IS TO BE USED ONLY FOR THE PURPOSES AND IN THE MANNER SPECIFIED HEREIN. IT IS TO BE RETURNED TO TYCO ELECTRONICS CORPORATION UPON REQUEST. IT IS TO BE DESTROYED BY THE USER UPON THE EXPIRATION OF THE PATENT RIGHTS.</small>		DWN: HOFFNER 08SEP2015 CHK: T. ELBIN 09SEP2015 APVD: T. ELBIN 09SEP2015	NAME: TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm 	TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±	PRODUCT SPEC APPLICATION SPEC WEIGHT FINISH	SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2836042 SCALE: 1:2 SHEET: 3 OF 4 REV: E

LOC	DIST	REV	DATE	BY	APPV
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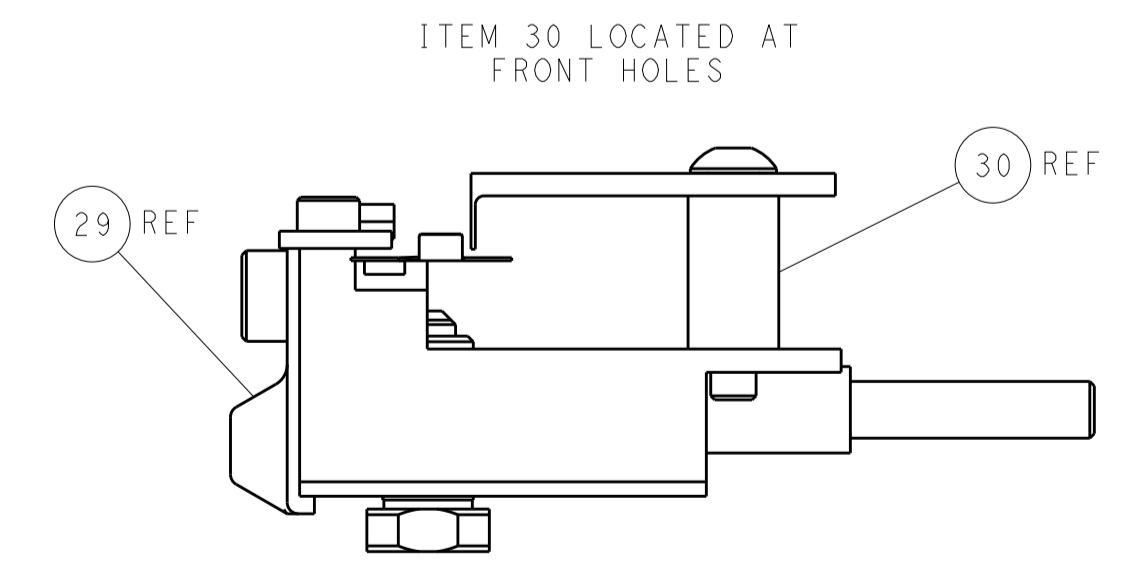
FEED TYPE MECHANICAL



PNEUMATIC

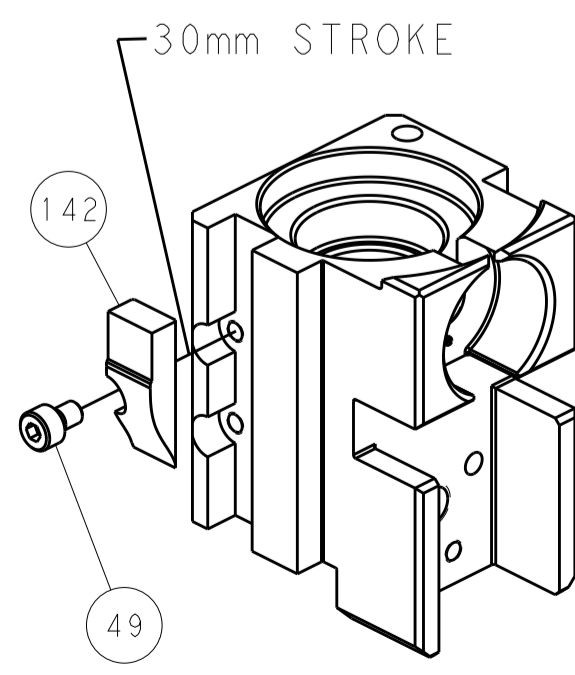


RAM SET-UP

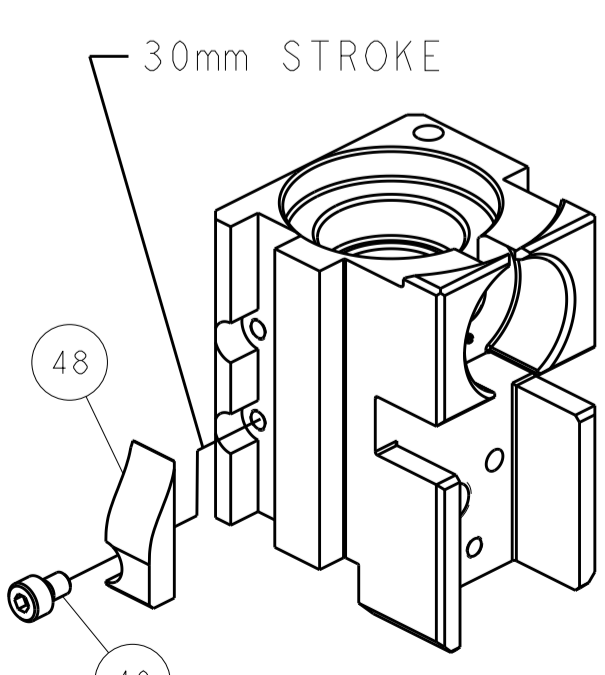


FEED TRACK POSITION GUIDE BY WIRE BARREL

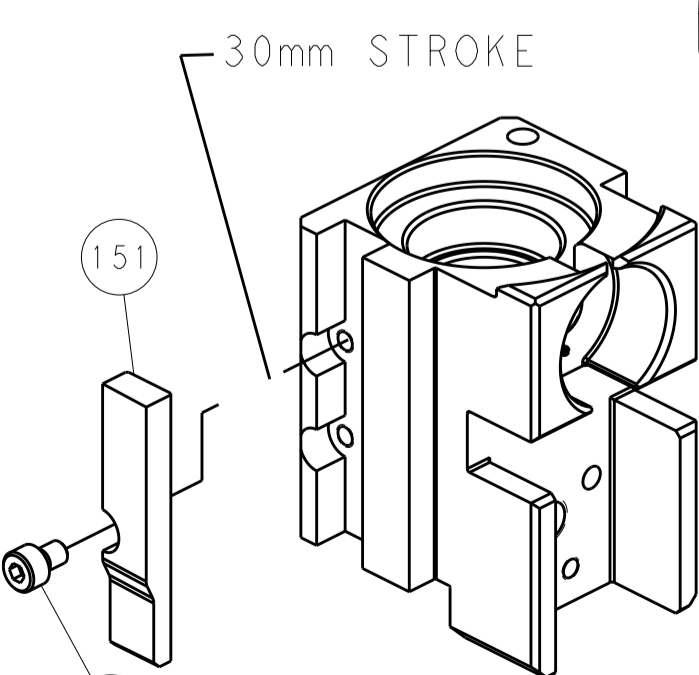
CAM POSITIONS



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:		DWG: HOFFNER 08SEP2015		TE Connectivity	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	5 PLC ±	Harrisburg, PA 17105-3608
MATERIAL:		FINISH:		CHK: TELBIN 09SEP2015		NAME: Ocean Side Feed Applicator	
				APVD: TELBIN 09SEP2015		SIZE: CAGE CODE: DRAWING NO: 00779 ©=2836042	
				PRODUCT SPEC:		RESTRICTED TO:	
				APPLICATION SPEC:		Customer Accessible Production Drawing	
				WEIGHT:		SCALE: 1:2 SHEET 4 OF 4 REV E	
				ANGLES:		SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION	