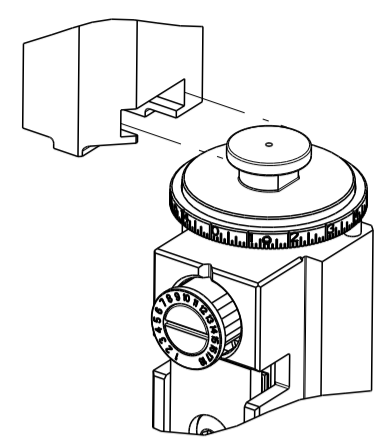


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2836041-2	E	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2836041-2	E	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2836041-7	C	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER

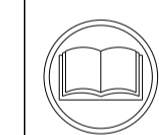


APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	0.80 mm [.031]	F
INSUL	0.80 mm [.031]	F

APPLICATOR INSTRUCTIONS 408-35042

TERMINAL DATA: MOLEX TERMINAL MOLEX CRIMP SPECIFICATION			
TERMINAL NAME: 1.25mm PITCH WIRE-TO BOARD TERMINALS			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
1.50-1.70 mm [.059-.067 IN]		∅0.80-1.00 mm [.031-.039 IN]	
TERMINAL APPLICATION SPECIFICATION	ATS-639006600 Rev C		
TERMINALS APPLIED			
TE TERMINAL	MOLEX TERMINAL	TE TERMINAL	MOLEX TERMINAL
2113902-1	502381-0000	2113902-2	502381-0010

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
26 AWG OR 0.14mm2	0.58+/-0.025 [.023+/- .001]	6.4
28 AWG OR 0.08mm2	0.56+/-0.025 [.022+/- .001]	6.7



- 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.
- TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- 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					
A	66	P	LTN	DESCRIPTION	DATE	OWN	APVD
		C		ECR-16-013542	22SEP2016	KH	CT
		C1		ECR-18-006162	23APR2018	KH	JDG
		D		ECR-20-004649	30MAR2020	FZ	TE
		E		ECR-23-184158	14AUG2023	JWC	GB

-	1	1	2119641-1	FEED CAM, AIR FEED	248
-	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	1	2844940-1	AIR FEED MODULE	238
-	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	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	1803607-3	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	2161425-1	SCREW, SHOULDER	60
-	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	1	1	1338685-1	PAWL, FEED	56
-	4	4	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	54
-	2	2	1-2168083-4	SCR, SKT HD CAP, RoHS, M4 X 5	53
-	1	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	1	1	2-1803583-5	APPLICATOR BASIC ASSEMBLY, SF	46
-	1	1	1803515-1	RAM ASSEMBLY, SF ATLANTIC	44
-	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
-	1	1	2-1752356-6	SUPPORT, TERMINAL	34
-	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	1803338-1	STRIPPER, SIDE FEED	19
-	1	1	2-690518-8	HOLD DOWN, TERMINAL	18
-	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	1803095-3	FLOATING SHEAR, FRONT	9
-	1	2	1803437-1	ANVIL, COMBINATION	8
-	-	-	-	-	7
-	-	-	-	-	6
-	1	1	1-2119757-8	DEPRESSOR, SHEAR	5
-	1	1	6-238011-3	BLOCK, CRIMPER SPACER	4
-	1	2	1803438-1	CRIMPER, INSULATION F	3
-	1	1	455888-3	SPACER, CRIMPER	2
-	1	2	1803433-1	CRIMPER, WIRE PREMIUM	1

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

STE TE Connectivity
Harrisburg, PA 17105-3608

NAME: Ocean Side Feed Applicator

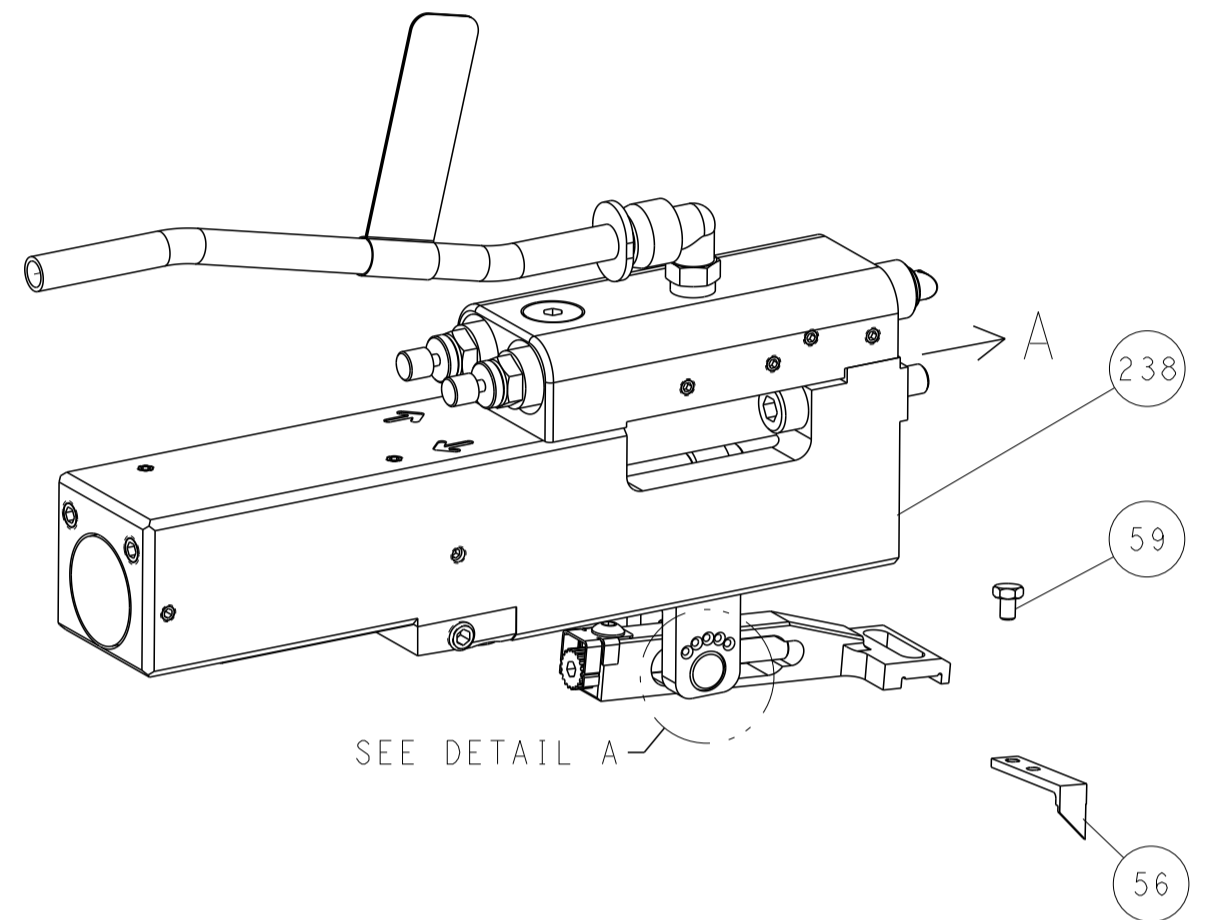
SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2836041

Customer Accessible Production Drawing

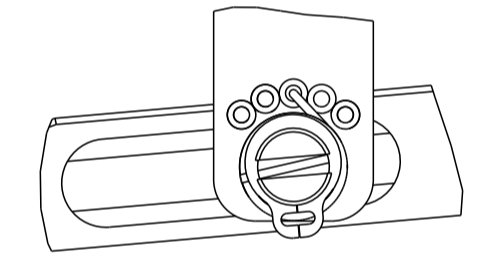
LOC	DIST	REVISIONS					
		P	LTN	DESCRIPTION	DATE	OWN	APVD
A	66	-	-	SEE SHEET 1	-	-	-

FEED TYPE

PNEUMATIC

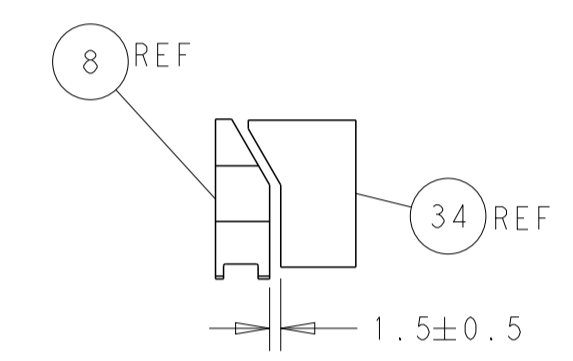
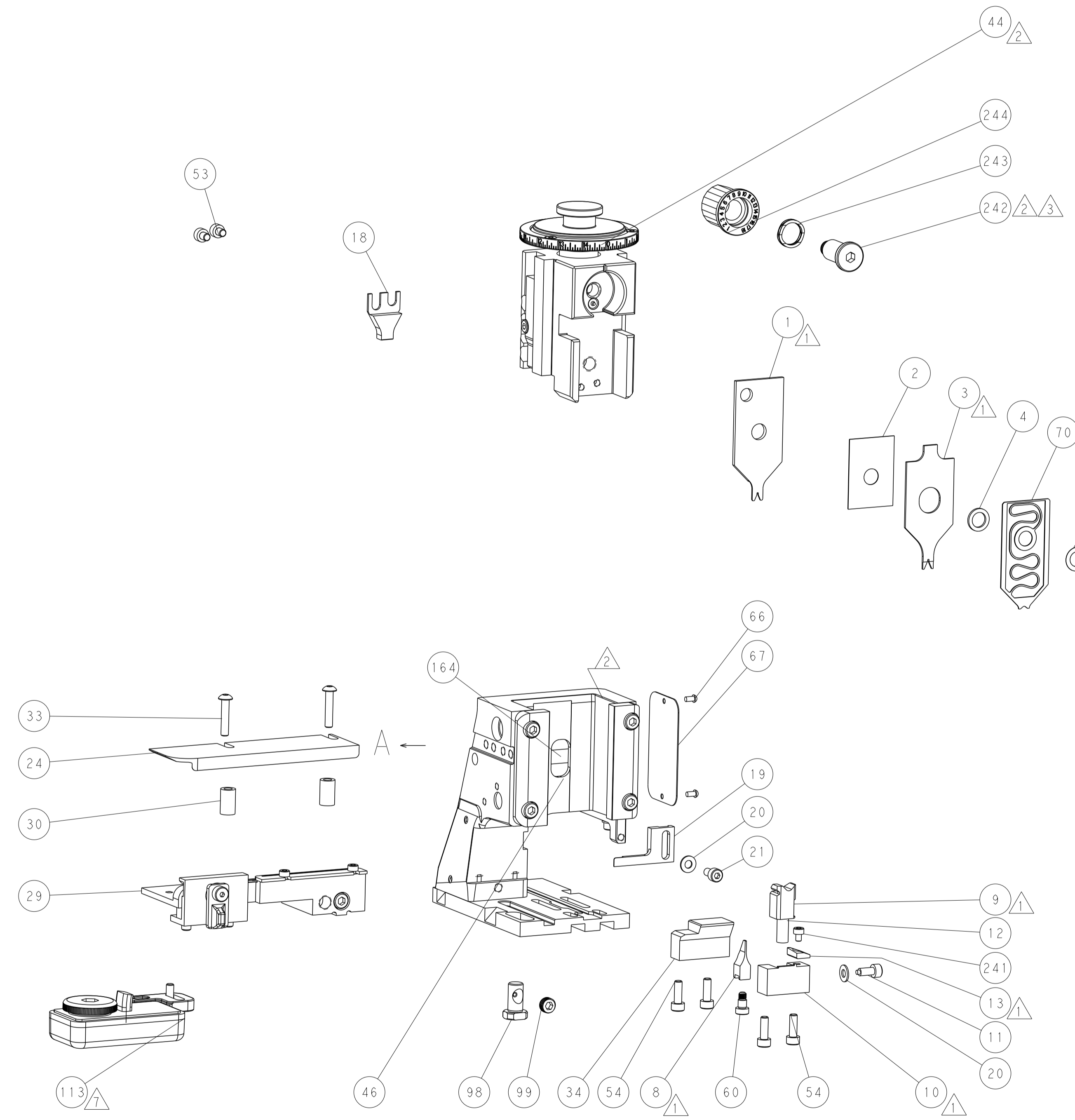
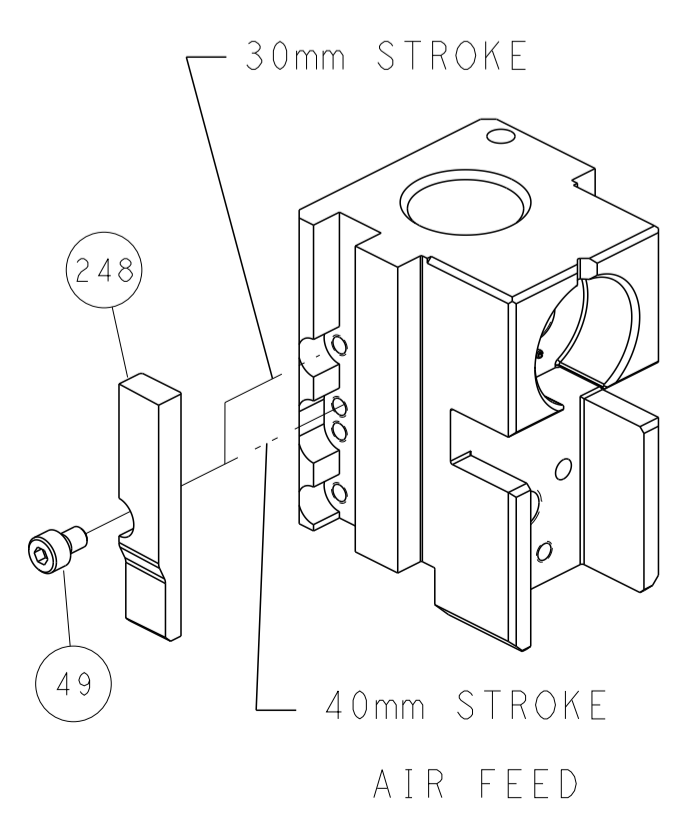


FEED SPRING SETTING POSITION
(SHOWN FROM REAR SIDE)

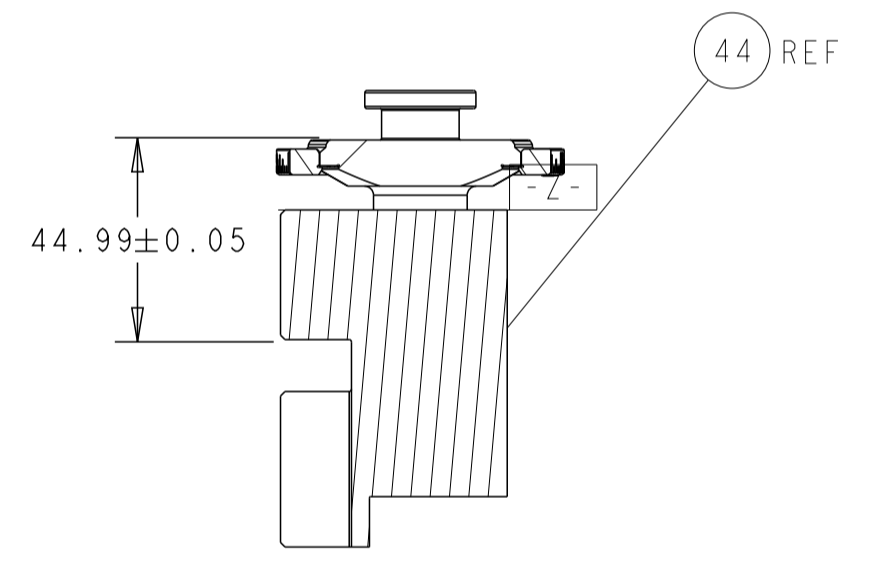


DETAIL A

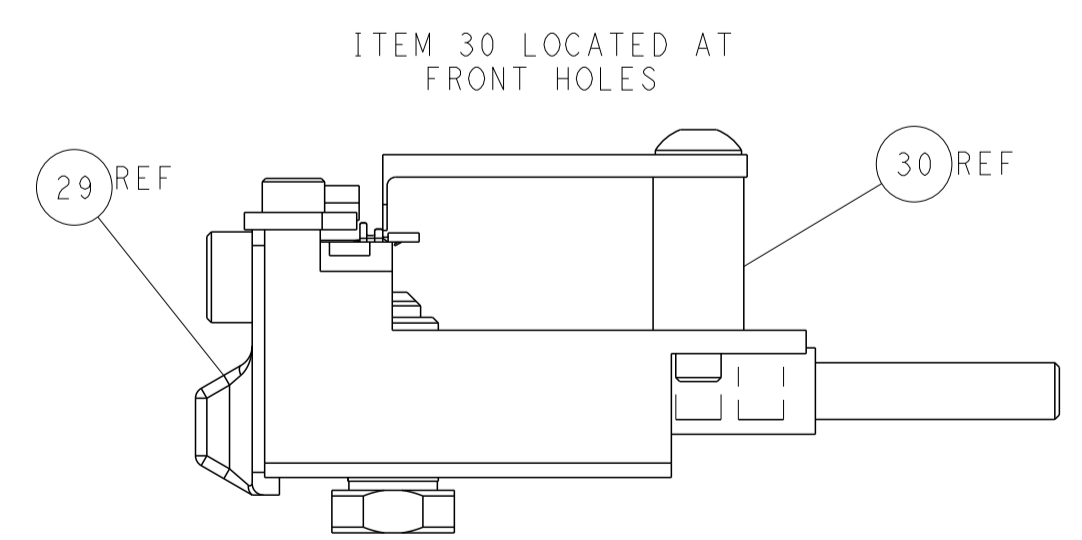
CAM POSITION



TERMINAL SUPPORT LOCATION



RAM SET-UP



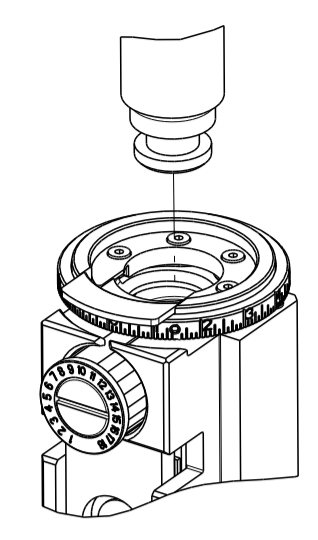
FEED TRACK POSITION
GUIDE BY WIRE BARREL

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

<small>THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.</small>		DWN: R. HUANG 22OCT2015 CHK: L. ZHANG 22OCT2015 APVD: J. GUO 22OCT2015	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 PRODUCT SPEC: - APPLICATION SPEC: - SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2836041	RESTRICTED TO: - SCALE: 1:2 SHEET: 2 OF 4 REV: E
MATERIAL: - FINISH: -		WEIGHT: - Customer Accessible Production Drawing	SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2836041-2	E	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2836041-7	C	CRIMP TOOLING KIT	-

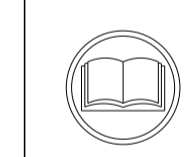
PACIFIC VERSION TERMINATOR
 INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	0.80 mm [.031]	F
INSUL	0.80 mm [.031]	F
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: MOLEX TERMINAL MOLEX CRIMP SPECIFICATION			
TERMINAL NAME: 1.25mm PITCH WIRE-TO BOARD TERMINALS			
WIRE STRIP LENGTH 1.50-1.70 mm [.059-.067 IN]	INSULATION DIAMETER RANGE Ø0.80-1.00 mm [.031-.039 IN]		
TERMINAL APPLICATION SPECIFICATION ATS-639006600 Rev C			
TERMINALS APPLIED			
TE TERMINAL 2113902-1	MOLEX TERMINAL 502381-0000	TE TERMINAL 2113902-2	MOLEX TERMINAL 502381-0010

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
26 AWG OR 0.14mm ²	0.58 +/- 0.025 [.023 +/- .001]	6.4
28 AWG OR 0.08mm ²	0.56 +/- 0.025 [.022 +/- .001]	6.7



- 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.
- 6 TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- 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.

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				

REVISIONS					
REV	DATE	DESCRIPTION	DATE	BY	APPD
-	-	SEE SHEET 1	-	-	-
-	1	2119082-4			244
-	1	2079764-1			243
-	1	2119083-1			242
-	1	7-18023-7			241
-	1	2844940-1			238
-	REF	994970-2			164
-	1	2119641-2			151
-	1	2168083-8			144
-	4	2168083-9			143
-	1	3-1803583-0			141
-	1	1803516-1			140
-	1	2119955-1			113
-	1	2844908-1			99
-	1	2844907-1			98
-	1	1803607-3			71
-	1	2119791-9			70
-	1	2119943-1			69
-	1	2119740-1			67
-	2	2168078-1			66
-	1	5-18022-5			59
-	1	1338685-1			56
-	2	1-2168083-4			53
-	1	18023-9			49
-	1	1803602-1			41
-	1	2-1752356-6			34
-	2	2079383-5			33
-	2	2-2844962-3			30
-	1	2844992-1			29
-	1	1320928-2			24
-	1	2168083-2			21
-	2	1-18028-2			20
-	1	1803338-1			19
-	1	2-690518-8			18
-	1	2119806-1			13
-	1	3-22280-3			12
-	1	1-356885-4			11
-	1	2119805-1			10
-	1	1803095-3			9
-	1	1803437-1			8
-	-	-			7
-	-	-			6
-	1	1-2119757-8			5
-	1	6-238011-3			4
-	1	1803438-1			3
-	1	458888-3			2
-	1	1803433-1			1
-	77	-22	PART NO	DESCRIPTION	ITEM NO

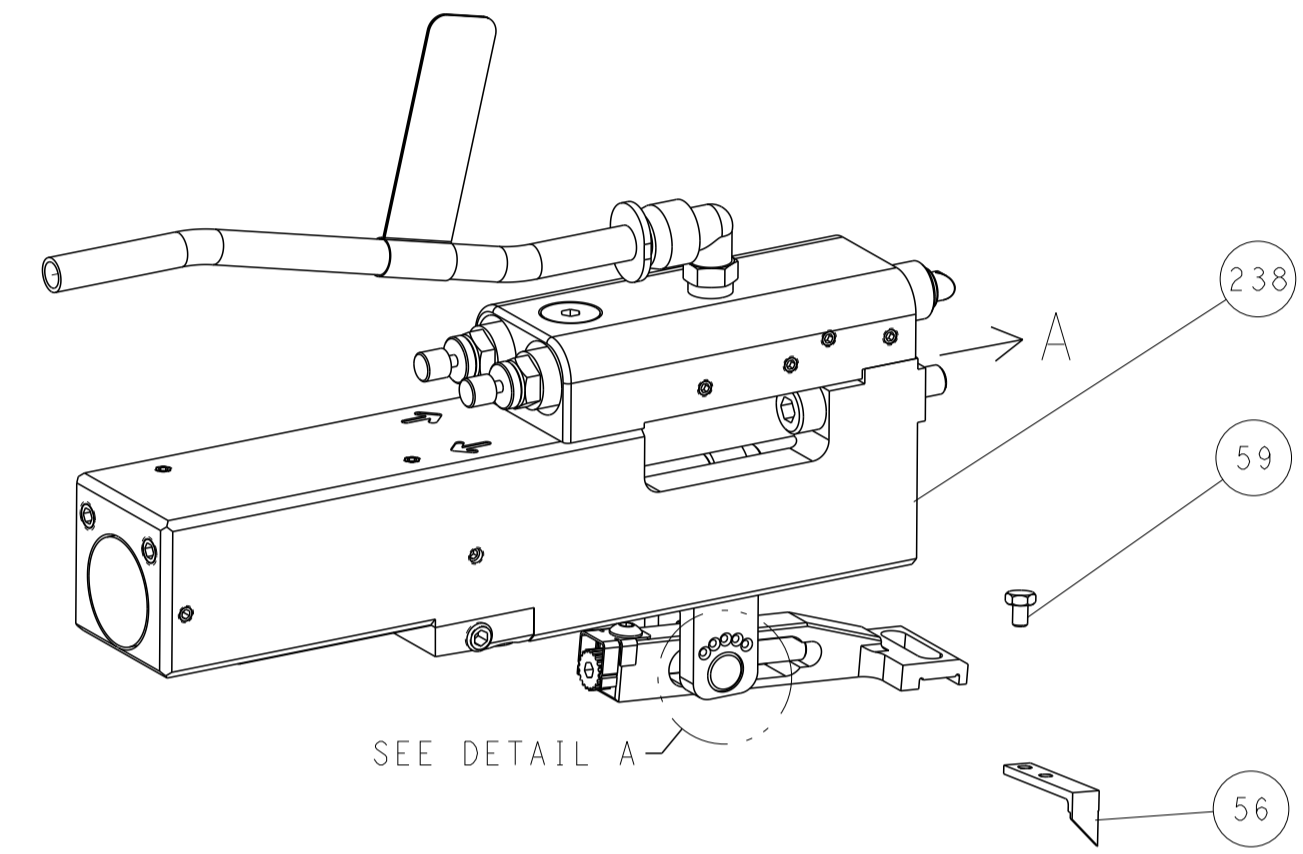
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		MATERIAL:	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±
	ANGLES	FINISH			

OWN	H. HUANG	22OCT2015
CHK	L. ZHANG	22OCT2015
APPD	J. GUO	22OCT2015
PRODUCT SPEC		
APPLICATION SPEC		
SIZE	CAGE CODE	DRAWING NO
A1	00779	2836041
Customer Accessible Production Drawing		
SCALE	1:2	SHEET 3 OF 4
REV	E	

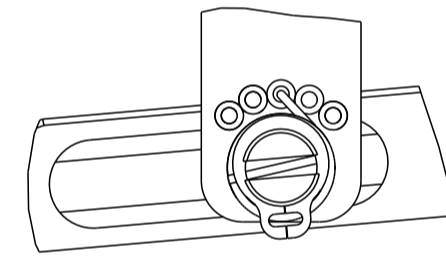
LOC	DIST	REV	DATE	BY	APPD
A	66				

FEED TYPE

PNEUMATIC

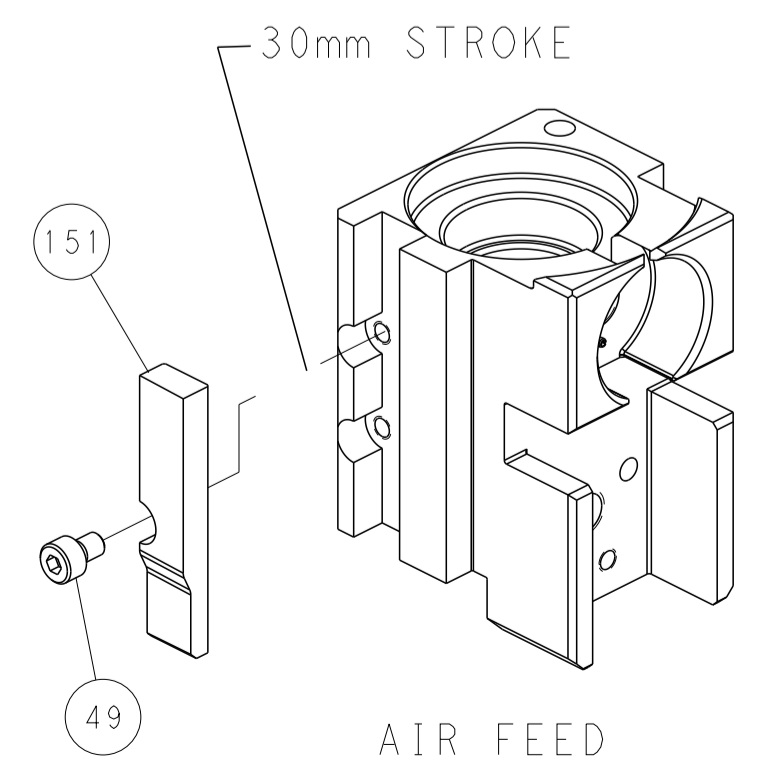


FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)

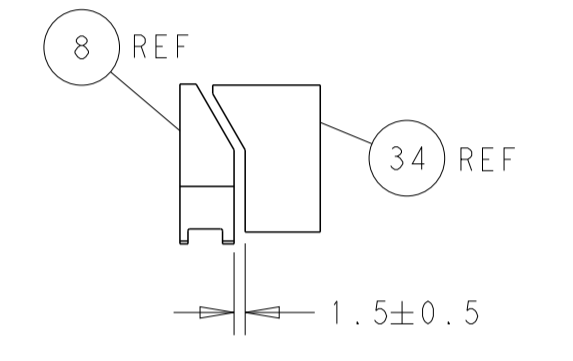
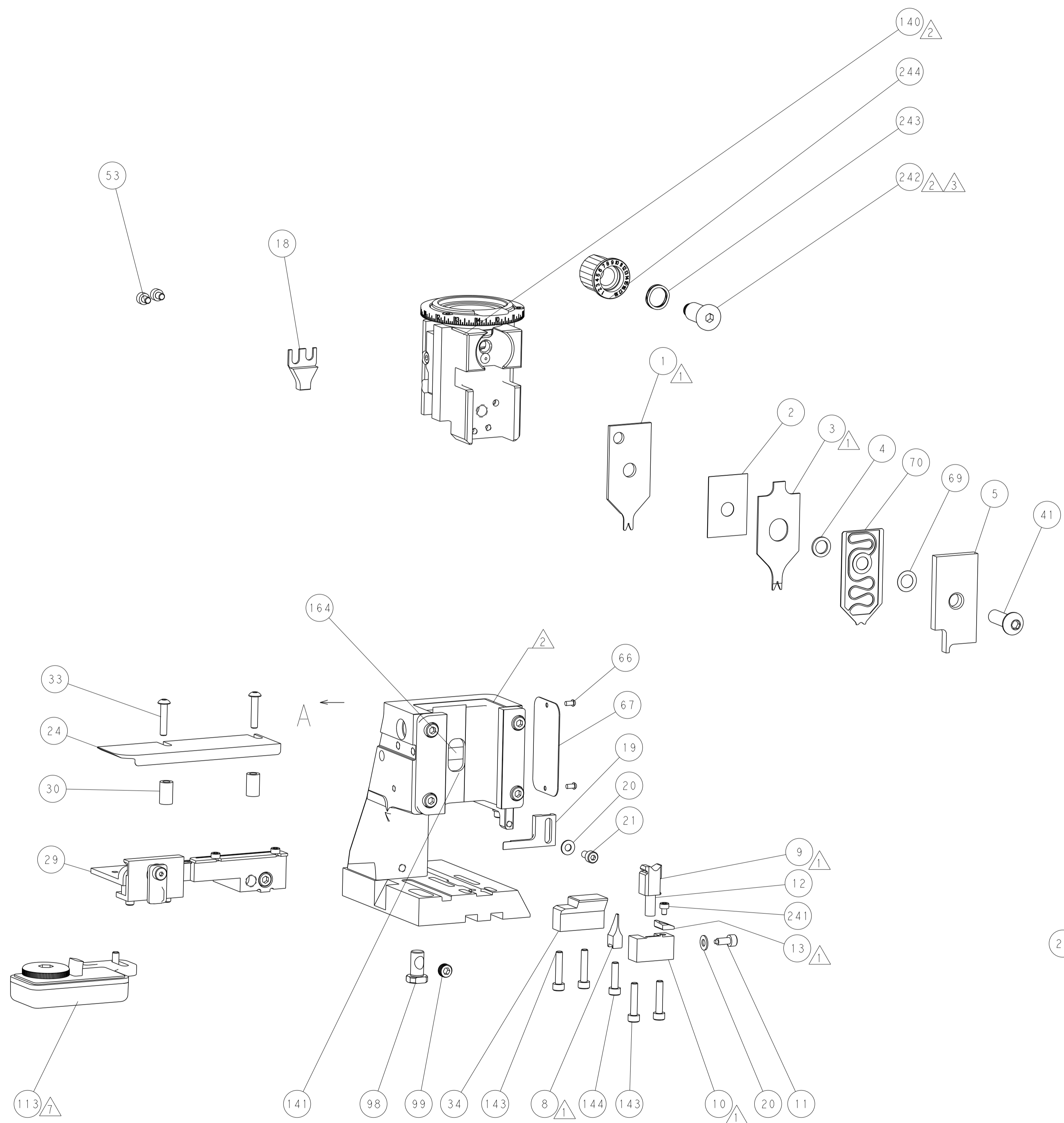


DETAIL A

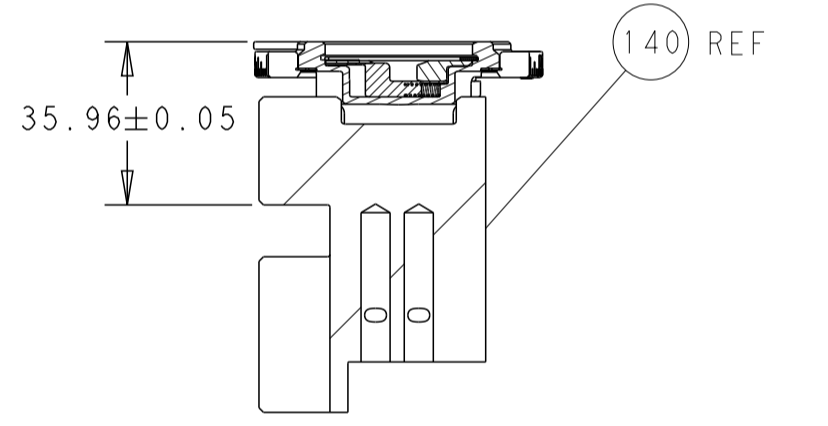
CAM POSITION



AIR FEED

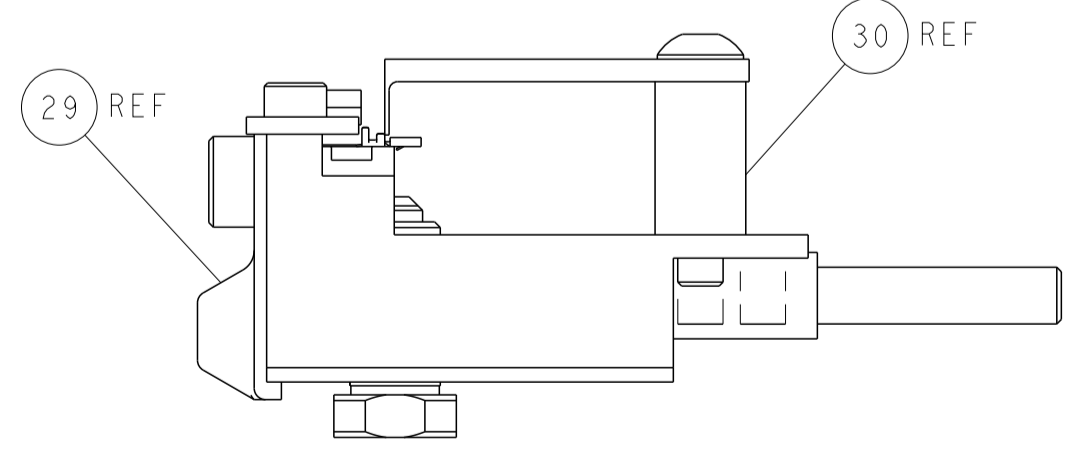


TERMINAL SUPPORT LOCATION



RAM SET-UP

ITEM 30 LOCATED AT FRONT HOLES



FEED TRACK POSITION GUIDE BY WIRE 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 20. COPYRIGHT 20 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.</small>		DWN: H. HUANG 22OCT2015 CHK: L. ZHANG 22OCT2015 APVD: J. GUO 22OCT2015	NAME: Ocean Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2836041	RESTRICTED TO: - SCALE: 1:2 SHEET: 4 OF 4 REV: E
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± MATERIAL: - FINISH: -	TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± MATERIAL: - FINISH: -	PRODUCT SPEC: - APPLICATION SPEC: - WEIGHT: -	CUSTOMER ACCESSIBLE PRODUCTION DRAWING	SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION