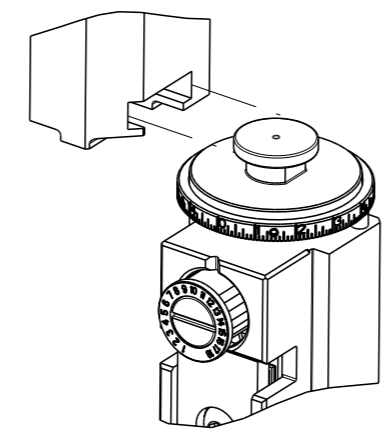


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2836081-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2836081-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2836081-1	B	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2836081-2	B	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2836081-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	4.06 mm [.160]	F
INSUL	4.57 mm [.180]	O

APPLICATOR INSTRUCTIONS  
408-35042

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: AMP MCP 2.8mm LANCELESS-BUSBAR			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
10.20-10.96 mm [.402-.432 IN]		Ø4.10-5.20 mm [.161-.205 IN]	
TERMINAL APPLICATION SPECIFICATION	(A)1114-18022		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
(A) 1-1355844-1			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
6.00mm2	2.45 +/- 0.05 [.096 +/- .002]	4.0
5.00mm2	2.25 +/- 0.05 [.089 +/- .002]	6.2
4.00mm2	2.10 +/- 0.05 [.083 +/- .002]	7.9



- 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.
  - GRIND TO LENGTH AT ASSEMBLY.
  - TERMINAL LUBRICANT IS RECOMMENDED.
7. 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.

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

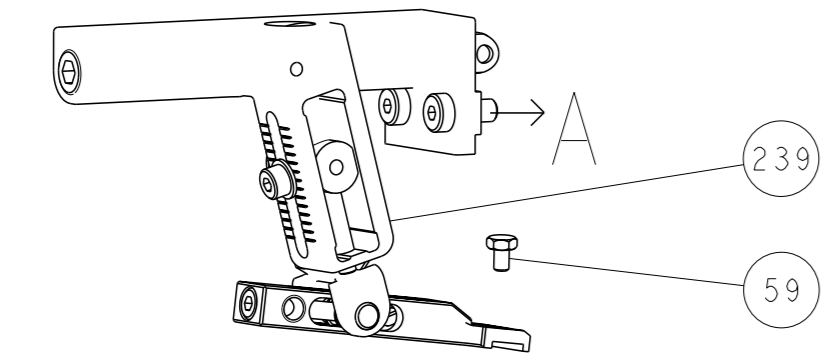
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		B		ECR-20-012827	10SEP2020	FJ	GB

-	1	1	1	1	1803203-1	BLOCK, FRONT DEPRESSOR	279
-	1	1	1	1	23238-1	INSERT, COUPLING	278
-	1	1	1	1	2030758-3	TUBING, POLYURETHANE	277
-	1	1	1	1	18030-2	NUT, HEX, REG M4	276
-	1	1	1	1	986220-3	CLAMP, CABLE, BLACK	275
-	1	1	1	1	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	274
-	1	1	1	1	2217068-1	BRACKET, AIR BLAST	273
-	1	1	1	1	1752737-7	PLATE, REAR SHEAR	272
-	2	2	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	269
-	1	1	1	1	1633782-3	FENCE	267
-	1	1	1	1	1803078-1	SPACER, PRECISION	259
-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248
-	1	1	1	1	2119082-9	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	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	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	143
-	1	1	1	1	1-22281-8	SPRING, COMPRESSION	121
-	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	3-690712-6	FRONT STRIP GUIDE	96
-	2	2	2	2	1-2168083-3	SCR, SKT HD CAP, RoHS, M3 X 16	95
-	1	1	1	1	2168083-6	SCR, SKT HD CAP, RoHS, M5 X 65	93
-	1	1	1	1	455888-3	SPACER, CRIMPER	82
-	1	1	1	1	1803607-3	DOCUMENTATION PACKAGE	71
-	1	1	1	1	1-2119791-0	DEPRESSOR, WIRE	70
-	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	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	1803515-2	RAM ASSEMBLY, SF ATLANTIC	44
-	1	1	1	1	1803602-2	SCR, BHSC, RoHS (M8 X 40)	41
-	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	2	2	2-2844962-6	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	1	1	2-2844938-2	PLATE, STRIP GUIDE	29
-	2	2	2	2	22281-9	SPRING, COMPRESSION	27
-	1	1	1	1	356835-1	LEVER, DRAG RELEASE	26
-	1	1	1	1	7-690754-0	DRAG, SPECIAL	25
-	1	1	1	1	1-1320928-6	STRIP GUIDE	24
-	1	1	1	1	980371-4	SCR, SKT HD SHLDR 5.0 DIA X 6.0	23
-	1	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
-	8	8	8	8	1-18028-2	WASHER, FLAT, REG M4	20
-	1	1	1	1	2119533-1	STRIPPER, SIDE FEED	19
-	-	-	-	-	-	-	10
-	1	1	1	1	4-853720-2	BLADE, SLUG	9
-	1	2	2	1	1803321-1	ANVIL, COMBINATION	8
-	-	-	-	-	-	-	7
-	-	-	-	-	-	-	6
-	-	-	-	-	-	-	5
-	1	1	1	1	238011-1	BLOCK, CRIMPER SPACER	4
-	1	2	2	1	4-1633966-2	CRIMPER, INSULATION O	3
-	1	1	1	1	455888-4	SPACER, CRIMPER	2
-	1	2	2	1	456414-3	CRIMPER, WIRE	1

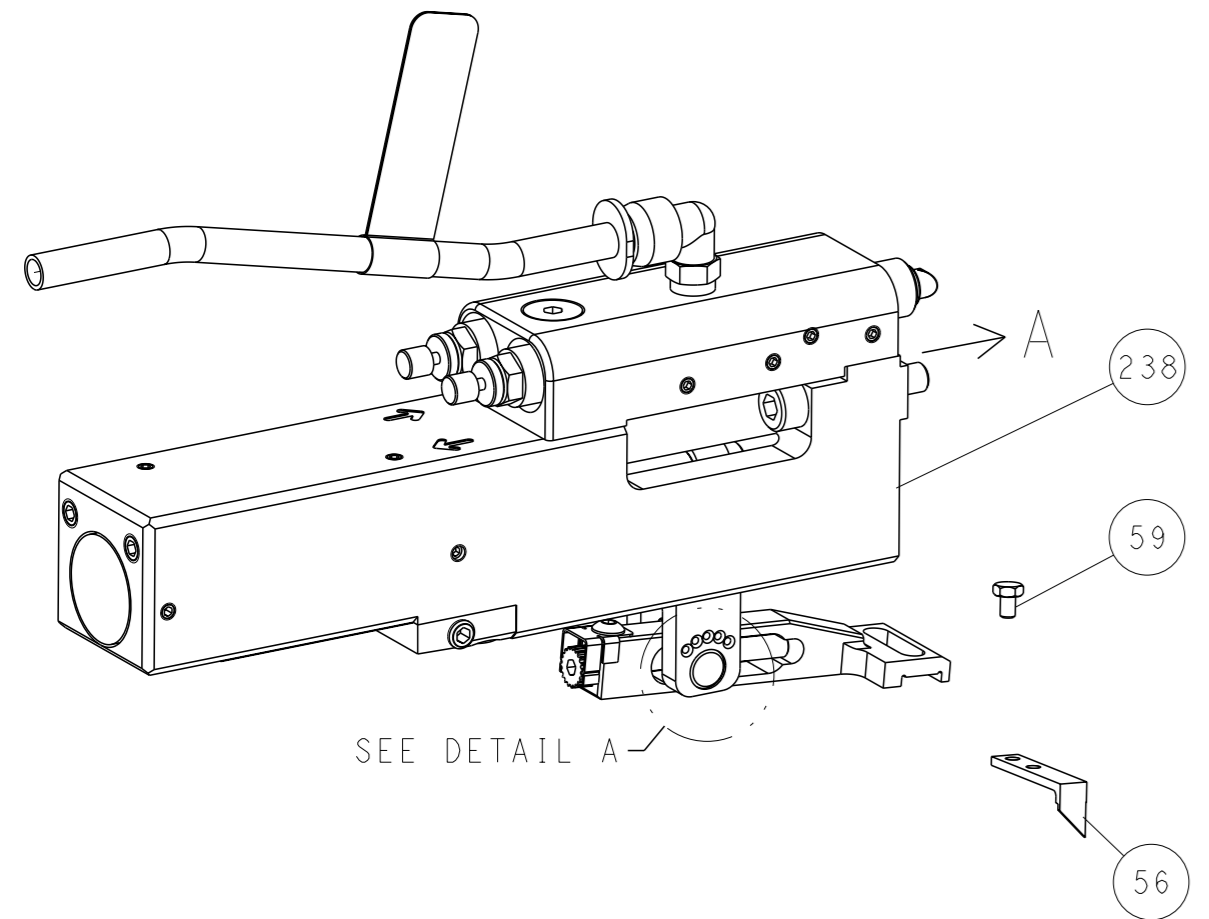
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	3 PLC ±	4 PLC ±	ANGLES ±	C. TOPPER	200CT2015	200CT2015	200CT2015	Harrisburg, PA 17105-3608				
				C. TOPPER	200CT2015	200CT2015	200CT2015	Ocean Side Feed Applicator				
MATERIAL												

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

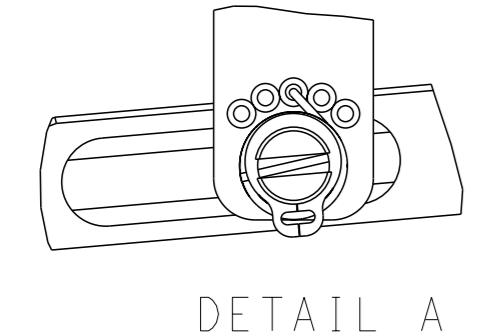
# FEED TYPE MECHANICAL



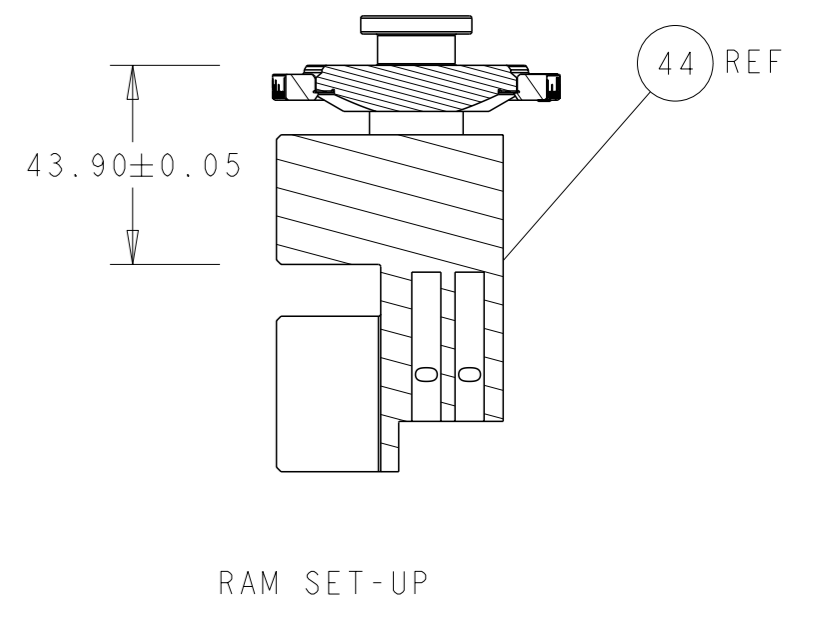
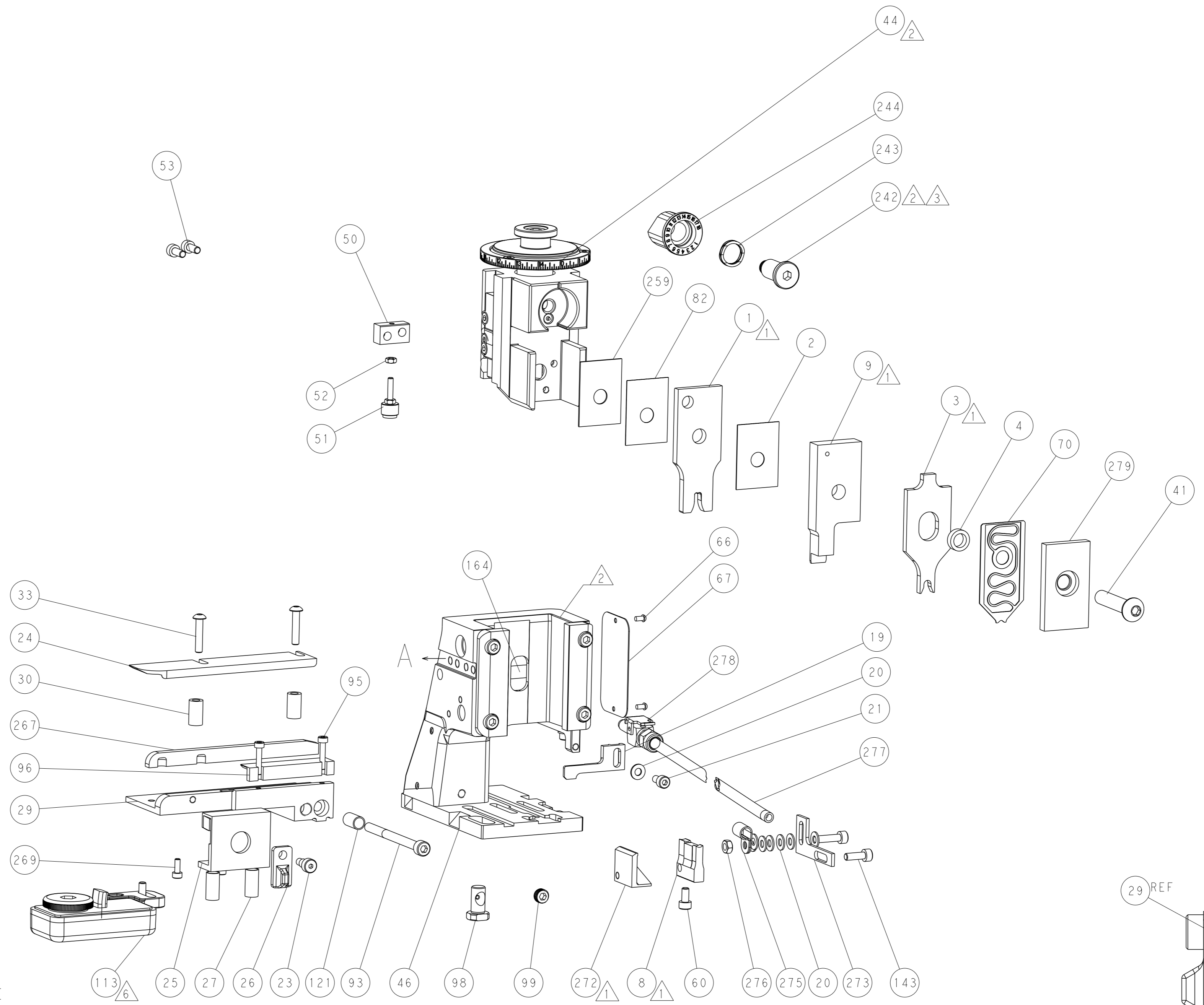
## PNEUMATIC



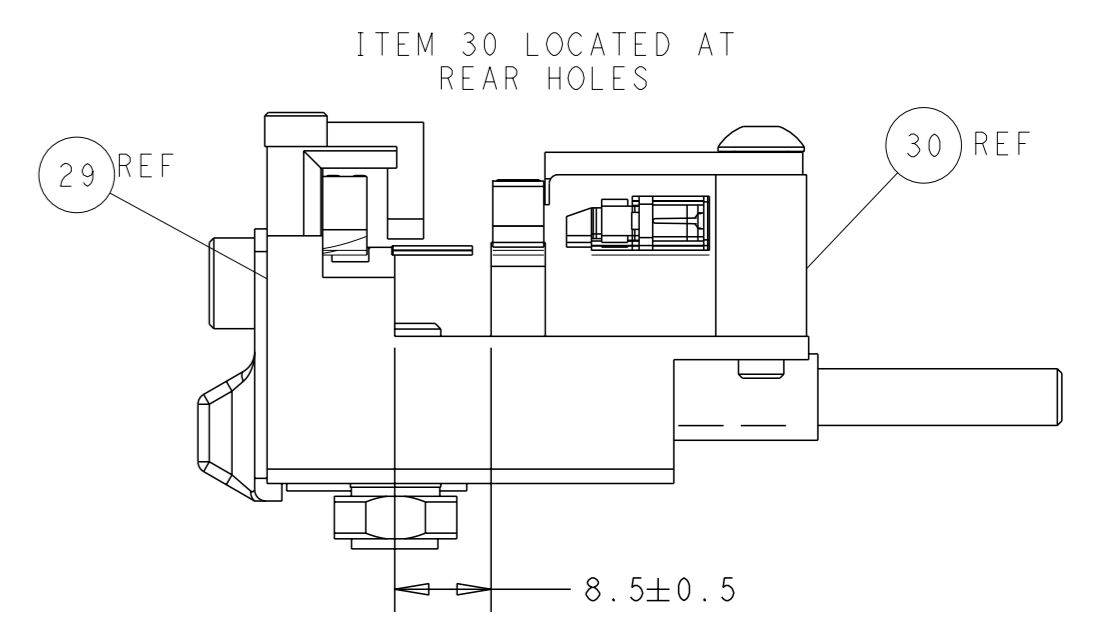
## FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



DETAIL A

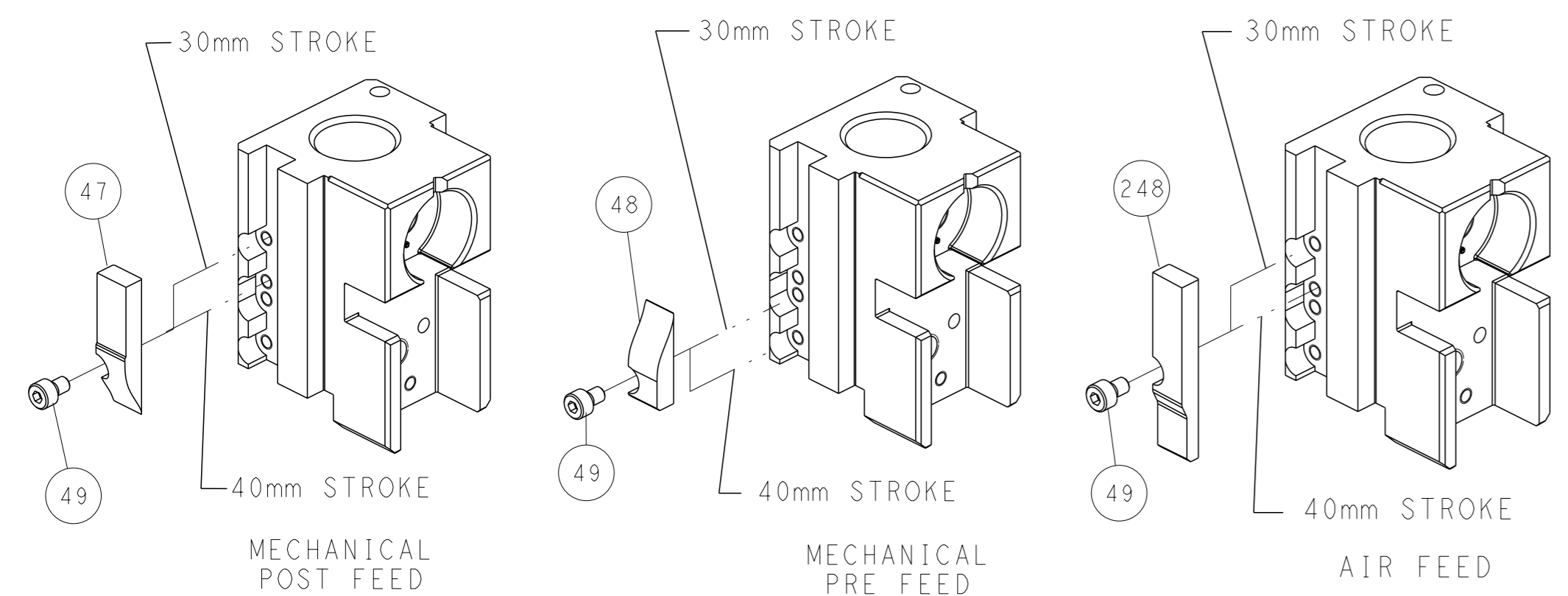


RAM SET-UP



FEED TRACK POSITION GUIDE BY WIRE BARREL

# CAM POSITIONS

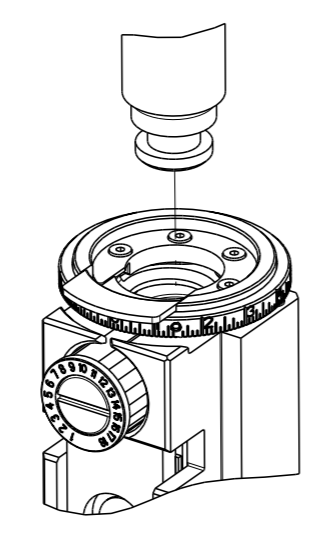


**ATLANTIC VERSION**  
 Shown on sheets 1 of 4 & 2 of 4  
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

<small>THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE AND THE USER MUST CONTACT THE DESIGNATION SHOULD BE CONTACTED FOR THE LATEST REVISION.</small>		OWN: B. WEAVER CHK: C. TOPPER APVD: C. TOPPER PRODUCT SPEC: - APPLICATION SPEC: - WEIGHT: - MATERIAL: -	200CT2015 200CT2015 200CT2015 - - - A1 00779 ©=2836081 Customer Accessible Production Drawing	TE Connectivity Harrisburg, PA 17105-3608 NAME: Ocean Side Feed Applicator SIZE: - CAGE CODE: - DRAWING NO: 00779 ©=2836081 SCALE: 1:2 SHEET: 2 of 4 REV: B
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2836081-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2836081-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2836081-7	A	CRIMP TOOLING KIT	-

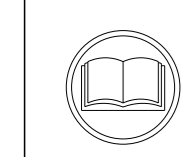
PACIFIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	4.06 mm [.160]	F
INSUL	4.57 mm [.180]	O
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: AMP MCP 2.8mm LANCELESS-BUSBAR			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
10.20-10.96 mm [.402-.432 IN]		Ø4.10-5.20 mm [.161-.205 IN]	
TERMINAL APPLICATION SPECIFICATION	(A)1114-18022		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
(A) 1-1355844-1			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
6.00mm2	2.45+/-0.05 [.096+/- .002]	4.0
5.00mm2	2.25+/-0.05 [.089+/- .002]	6.2
4.00mm2	2.10+/-0.05 [.083+/- .002]	7.9



- 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 GRIND TO LENGTH AT ASSEMBLY.
  - 6 TERMINAL LUBRICANT IS RECOMMENDED.
7. 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)

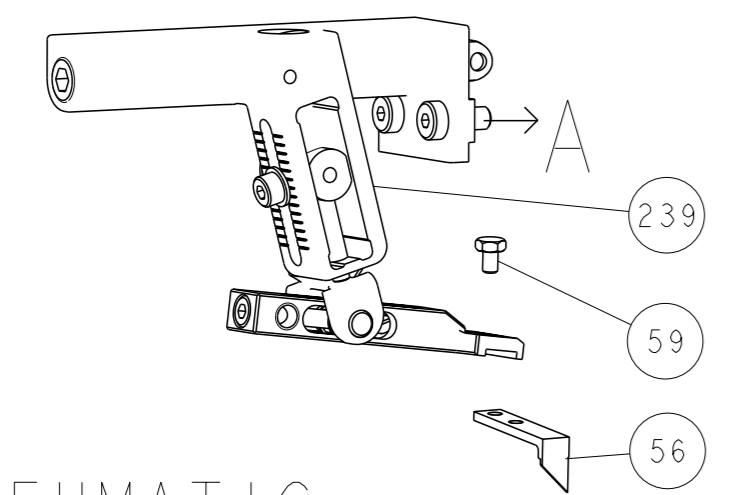
LOC	DIST	REVISIONS					
A	66	P	LYR	DESCRIPTION	DATE	OWN	APVD
		-	-	SEE SHEET 1	-	-	-

-	1	1	1803203-1	BLOCK, FRONT DEPRESSOR	279
-	1	1	23238-1	INSERT, COUPLING	278
-	1	1	2030758-3	TUBING, POLYURETHANE	277
-	1	1	18030-2	NUT, HEX, REG M4	276
-	1	1	986220-3	CLAMP, CABLE, BLACK	275
-	1	1	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	274
-	1	1	2217068-1	BRACKET, AIR BLAST	273
-	1	1	1752737-7	PLATE, REAR SHEAR	272
-	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	269
-	1	1	1633782-3	FENCE	267
-	1	1	1803078-1	SPACER, PRECISION	259
-	1	1	2119082-9	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	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
-	1	1	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	143
-	-	1	2119653-2	FEED CAM, POST FEED	142
-	1	1	1-1803583-0	APPLICATOR BASIC ASSEMBLY, SF	141
-	1	1	1803516-2	RAM ASSEMBLY, SF PACIFIC	140
-	1	1	1-22281-8	SPRING, COMPRESSION	121
-	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	3-690712-6	FRONT STRIP GUIDE	96
-	2	2	1-2168083-3	SCR, SKT HD CAP, RoHS, M3 X 16	95
-	1	1	2168083-6	SCR, SKT HD CAP, RoHS, M5 X 65	93
-	1	1	455888-3	SPACER, CRIMPER	82
-	1	1	1803607-3	DOCUMENTATION PACKAGE	71
-	1	1	1-2119791-0	DEPRESSOR, WIRE	70
-	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	690753-2	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	1803602-2	SCR, BHSC, RoHS (M8 X 40)	41
-	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	2-2844962-6	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	2-2844938-2	PLATE, STRIP GUIDE	29
-	2	2	22281-9	SPRING, COMPRESSION	27
-	1	1	356835-1	LEVER, DRAG RELEASE	26
-	1	1	7-690754-0	DRAG, SPECIAL	25
-	1	1	1-1320928-6	STRIP GUIDE	24
-	1	1	980371-4	SCR, SKT HD SHLDR 5.0 DIA X 6.0	23
-	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
-	8	8	1-18028-2	WASHER, FLAT, REG M4	20
-	1	1	2119533-1	STRIPPER, SIDE FEED	19
-	-	-	-	-	10
-	1	1	4-853720-2	BLADE, SLUG	9
-	1	1	1803321-1	ANVIL, COMBINATION	8
-	-	-	-	-	7
-	-	-	-	-	6
-	-	-	-	-	5
-	1	1	238011-1	BLOCK, CRIMPER SPACER	4
-	1	1	4-1633966-2	CRIMPER, INSULATION O	3
-	1	1	455888-4	SPACER, CRIMPER	2
-	1	1	456414-3	CRIMPER, WIRE	1
-	77	22	21	PART NO	ITEM NO

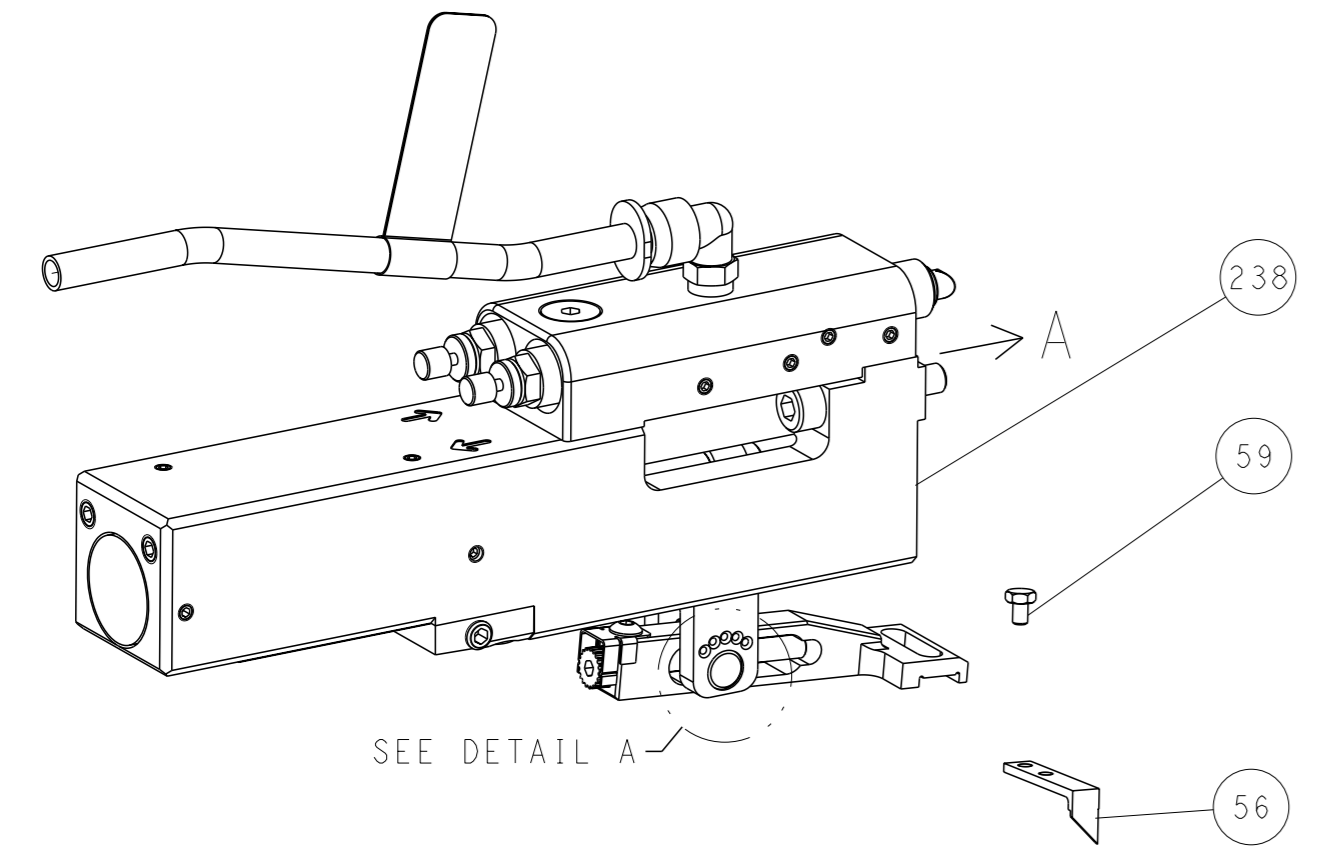
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	ANGLES	FINISH		APVD C. TOPPER 200CT2015		PRODUCT SPEC	Ocean Side Feed Applicator
MATERIAL				APPLICATION SPEC		SIZE	CAGE CODE DRAWING NO
				WEIGHT		A1 00779	©=2836081
				Customer Accessible Production Drawing	SCALE 1:2	SHEET 3 OF 4	REV B

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

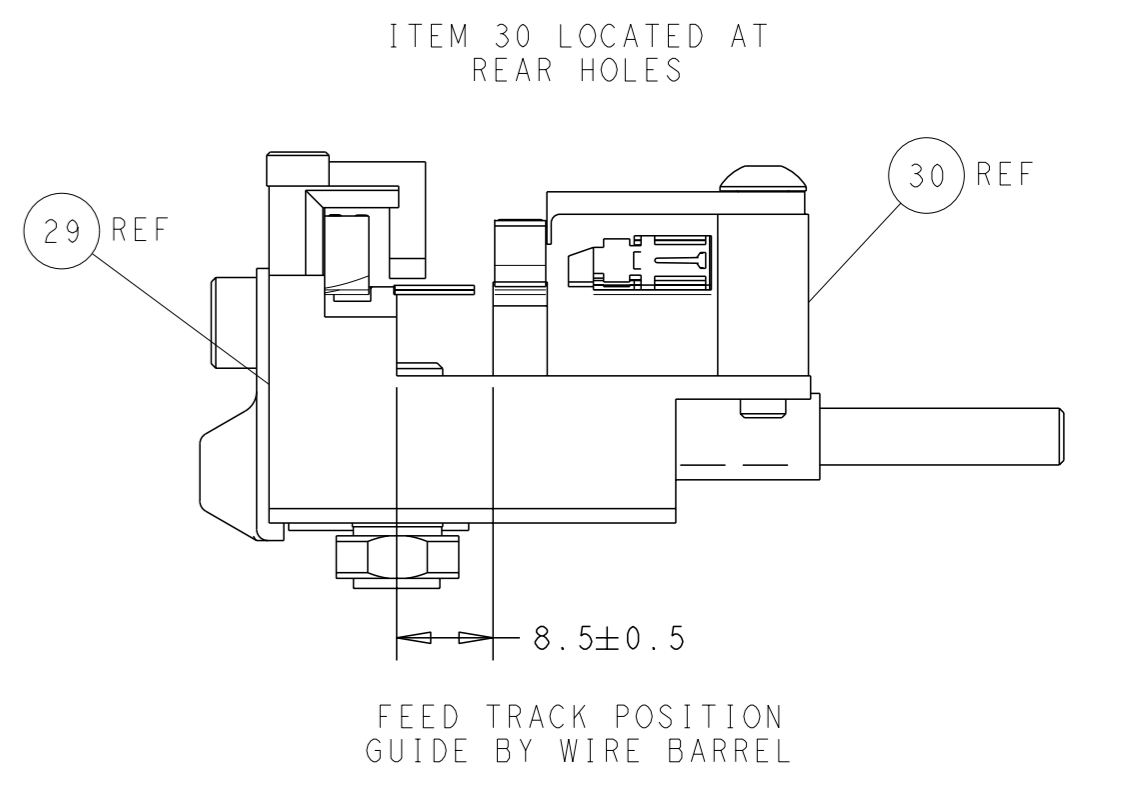
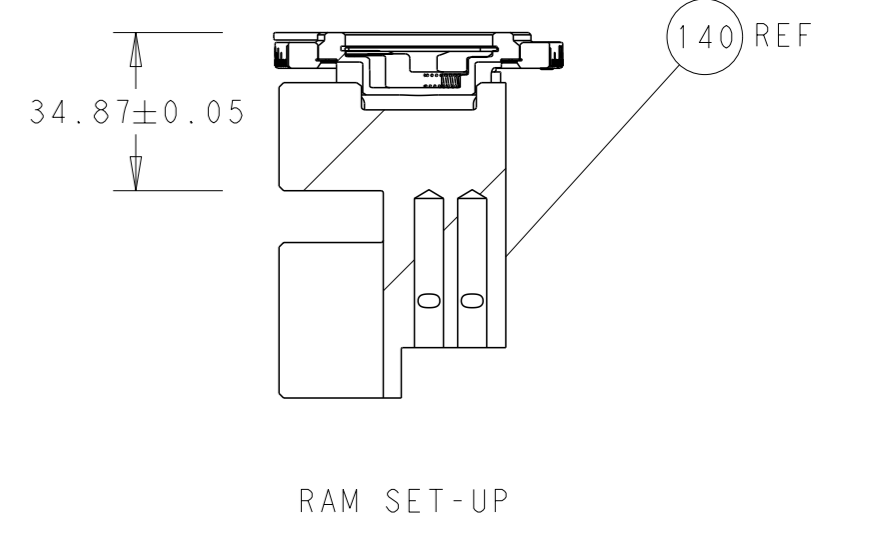
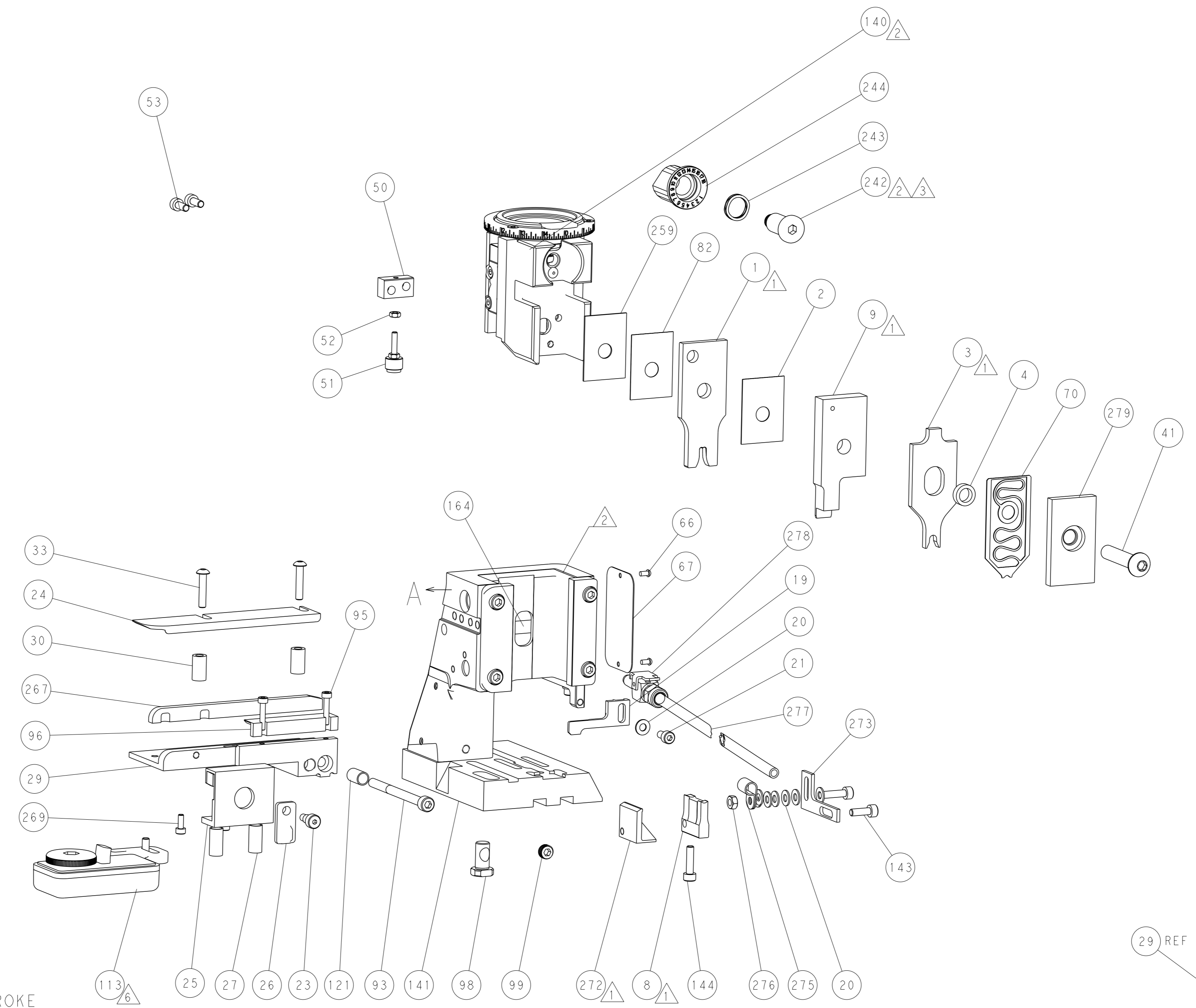
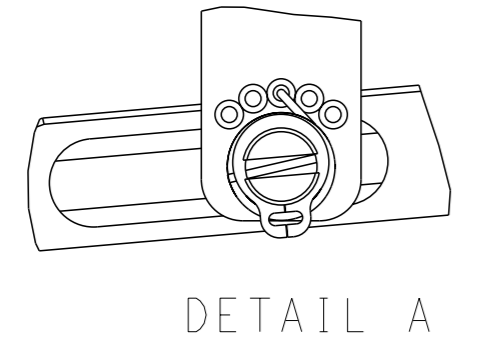
# FEED TYPE MECHANICAL



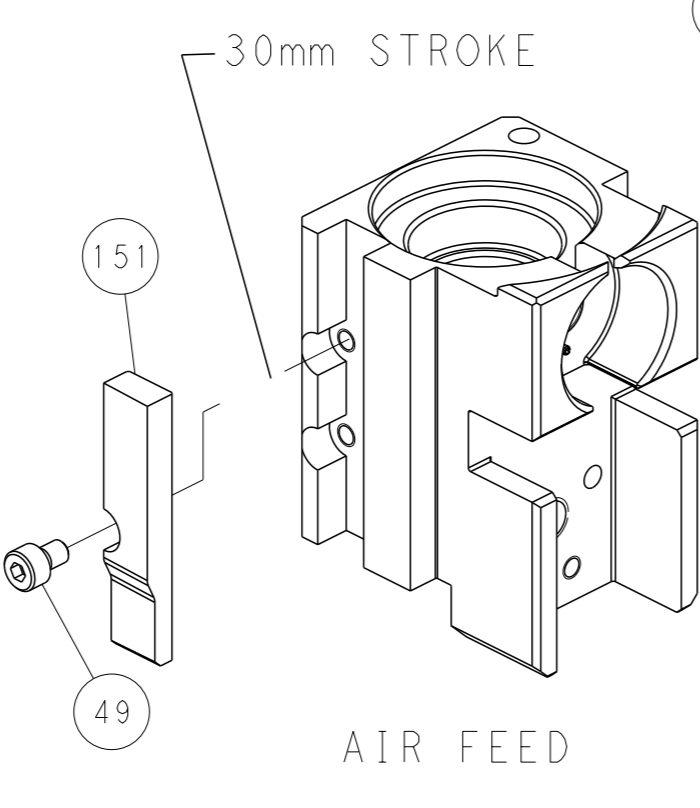
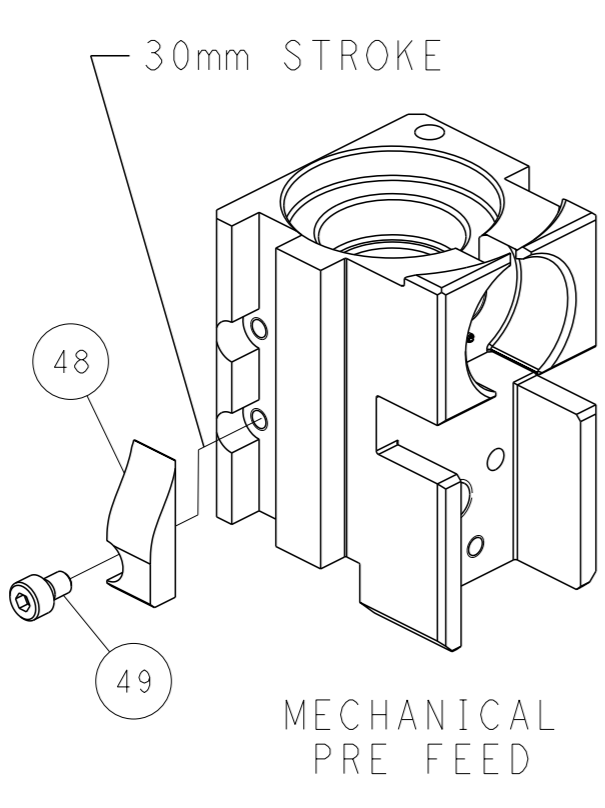
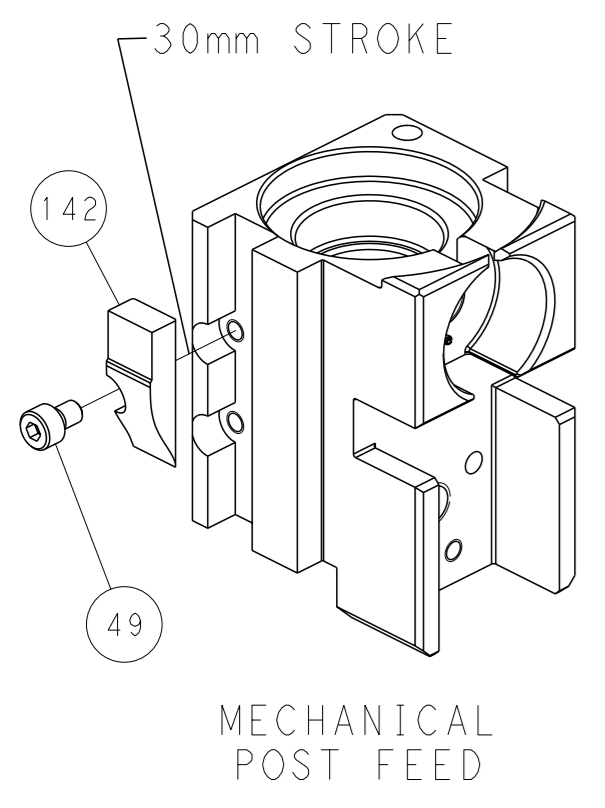
# PNEUMATIC



# FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



# CAM POSITIONS



**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 A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE AND THE CONTROLLING ENGINEERING ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST REVISION.</small>		OWN: B. WEAVER CHK: C. TOPPER APVD: C. TOPPER PRODUCT SPEC: - APPLICATION SPEC: - WEIGHT: - MATERIAL: -	200CT2015 200CT2015 200CT2015 NAME: Ocean Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: C-2836081 SCALE: 1:2 SHEET: 4 of 4 REV: B	TE Connectivity Harrisburg, PA 17105-3608
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