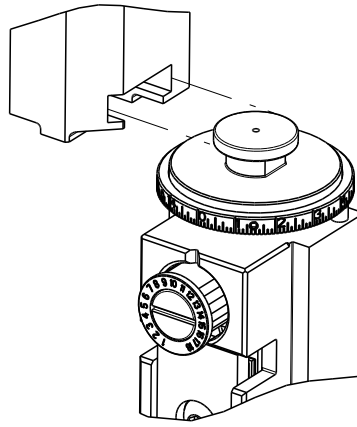
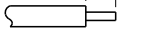


8		7	
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20		20	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2836142-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2836142-2	C	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2836142-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	4.57 mm [.180]	F
INSUL	9.53 mm [.375]	F
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: TERMINAL, HIGH CURRENT HERMAPHRODITIC			
WIRE STRIP LENGTH			INSULATION DIAMETER RANGE
8.74-10.31 mm [.344-.406 IN]			Ø5.08-9.14 mm [.200-.360 IN]
TERMINAL APPLICATION SPECIFICATION		114-1004	-
		-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
350650-1	350650-3		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
8 AWG	3.76+/-0.05 [.148+/- .002]	3.1
10 AWG	3.20+/-0.05 [.126+/- .002]	9.4
12 AWG	2.84+/-0.05 [.112+/- .002]	12.0



- 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

CUT TO LENGHT AT ASSEMBLY.

*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)

2		1							
LOC	DIST	REVISIONS							
A	66	P	LTR	DESCRIPTION			DATE	DWN	APVD
			A	RELEASED			2MAR2016	BW	TE
			B	ECR-18-012190			31JUL2018	AW	GB
			C	ECR-22-135212			06APR2022	JWC	ROY

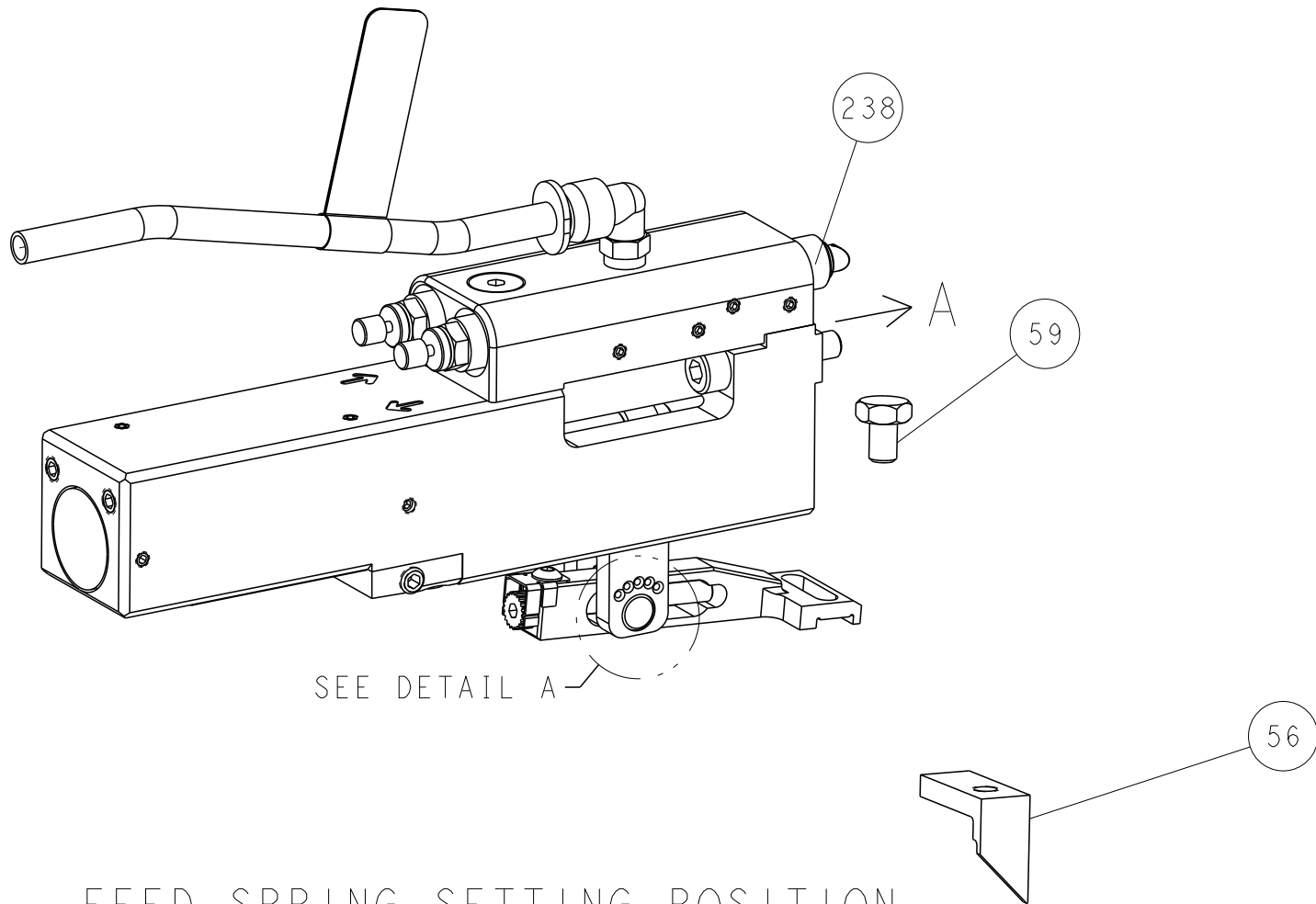
3	-	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	283
	-	1	1	2280441-1	INSERT, SHEAR	282
	-	1	1	2119641-1	FEED CAM, AIR FEED	248
	-	1	1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244
	-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
	-	1	1	2119083-1	RETAINER, INSULATION DIAL	242
	-	1	1	2844940-2	AIR FEED MODULE	238
	-	1	1	1-356885-4	STOP, SHEAR	237
	-	REF	REF	994970-2	COUNTER, MAGNETIC	164
	-	1	1	1-22281-8	SPRING, COMPRESSION	121
	-	1	1	2844908-1	SCREW, LOCKING	99
	-	1	1	2844907-1	POST, LOCKING	98
6	-	1	1	1-690438-0	FRONT STRIP GUIDE	96
	-	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	95
	-	1	1	2168083-6	SCR, SKT HD CAP, RoHS, M5 X 65	93
	-	1	1	1-18028-2	WASHER, FLAT, REG M4	89
	-	1	1	1-455888-1	SPACER, CRIMPER	82
	-	1	1	6-240641-9	SPACER	81
	-	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
	-	2	2	2-18032-5	SCR, SET, FLT PNT, M5 X 20.0	61
	-	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	60
	-	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
	-	1	1	1-1338683-0	FEED PAWL	56
	-	2	2	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	54
	-	2	2	1-2168083-2	SCR, SKT HD CAP, RoHS, M4 X 25	53
	-	1	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49
	-	1	1	1803583-9	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
	-	2	2	1-2168083-3	SCR, SKT HD CAP, RoHS, M3 X 16	33
	-	1	1	1-2305692-3	PLATE, REAR STRIP GUIDE	29
	-	2	2	22283-1	SPRING, COMPRESSION	27
	-	1	1	356835-1	LEVER, DRAG RELEASE	26
	-	1	1	240792-1	DRAG, TERMINAL	25
1	-	1	1	3-189124-1	GUIDE, FRONT STRIP	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
	-	1	1	1-18028-2	WASHER, FLAT, REG M4	20
	-	1	1	2119533-1	STRIPPER, SIDE FEED	19
	-	1	1	2-690518-7	HOLD DOWN, TERMINAL	18
	-	1	1	690463-1	FLOATING SHEAR, REAR	17
	-	2	2	1-2168083-1	SCR, SKT HD CAP, RoHS, M3 X 6	16
	-	1	1	690464-4	SHEAR PLATE, REAR	15
	-	1	1	2119862-1	SHEAR HOLDER, REAR	14
	-	1	1	3-22280-3	SPRING, COMPRESSION	12
	-	-	-	-	-	10
1	-	-	-	-	-	9
	1	2	1	1803320-4	ANVIL, COMBINATION	8
	-	1	1	2-240641-7	SPACER	7
	-	1	1	690468-3	DEPRESSOR SHEAR, REAR	6
1	-	-	-	-	-	5
	-	1	1	2-1803409-5	BLOCK, CRIMPER SPACER	4
	1	2	1	9-1803016-3	CRIMPER, INSULATION F	3
	-	1	1	2-455888-4	SPACER, CRIMPER	2
1	1	2	1	1-456412-6	CRIMPER, WIRE .180 F PREMIUM	1

THIS DRAWING IS A CONTROLLED DOCUMENT FOR THE ELECTRONICS CORPORATION IT IS SUBJECT TO CONTROLLED DOCUMENT AND INSTRUCTIONS ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST EDITION.				DWN R. HUANG CHK L. ZHANG APVD J. GUO	17DEC2015 17DEC2015 17DEC2015	 TE Connectivity Harrisburg, PA 17105-3608									
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		NAME		Ocean Side Feed Applicator									
mm		0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		PRODUCT SPEC		SIZE		CAGE CODE		DRAWING NO		RESTRICTED TO			
		FINISH		WEIGHT		A 00779		C=2836142							
MATERIAL						Customer Accessible Production Drawing		SCALE		1:2		SHEET 1 OF 4		REV C	

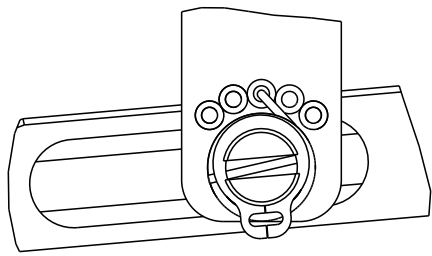
SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

LOC	DIST	REVISIONS					
		P	LTR	DESCRIPTION	DATE	DWN	APVD
A	66	-	-	SEE SHEET 1	-	-	-

FEED TYPE
PNEUMATIC

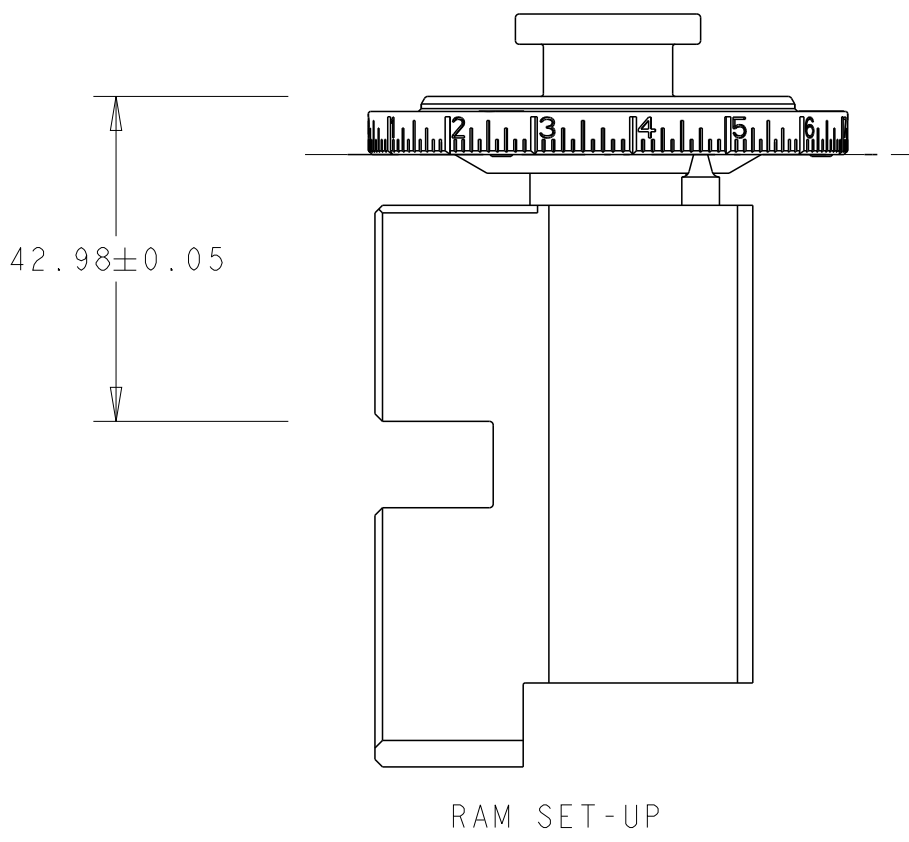
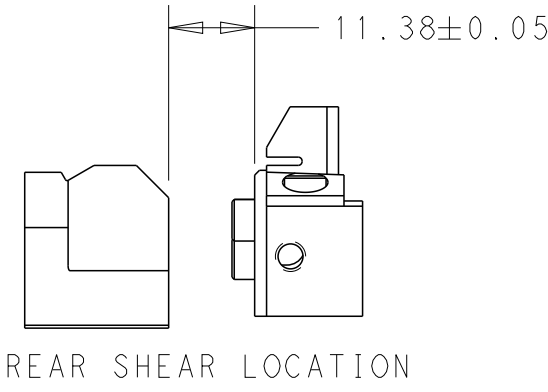
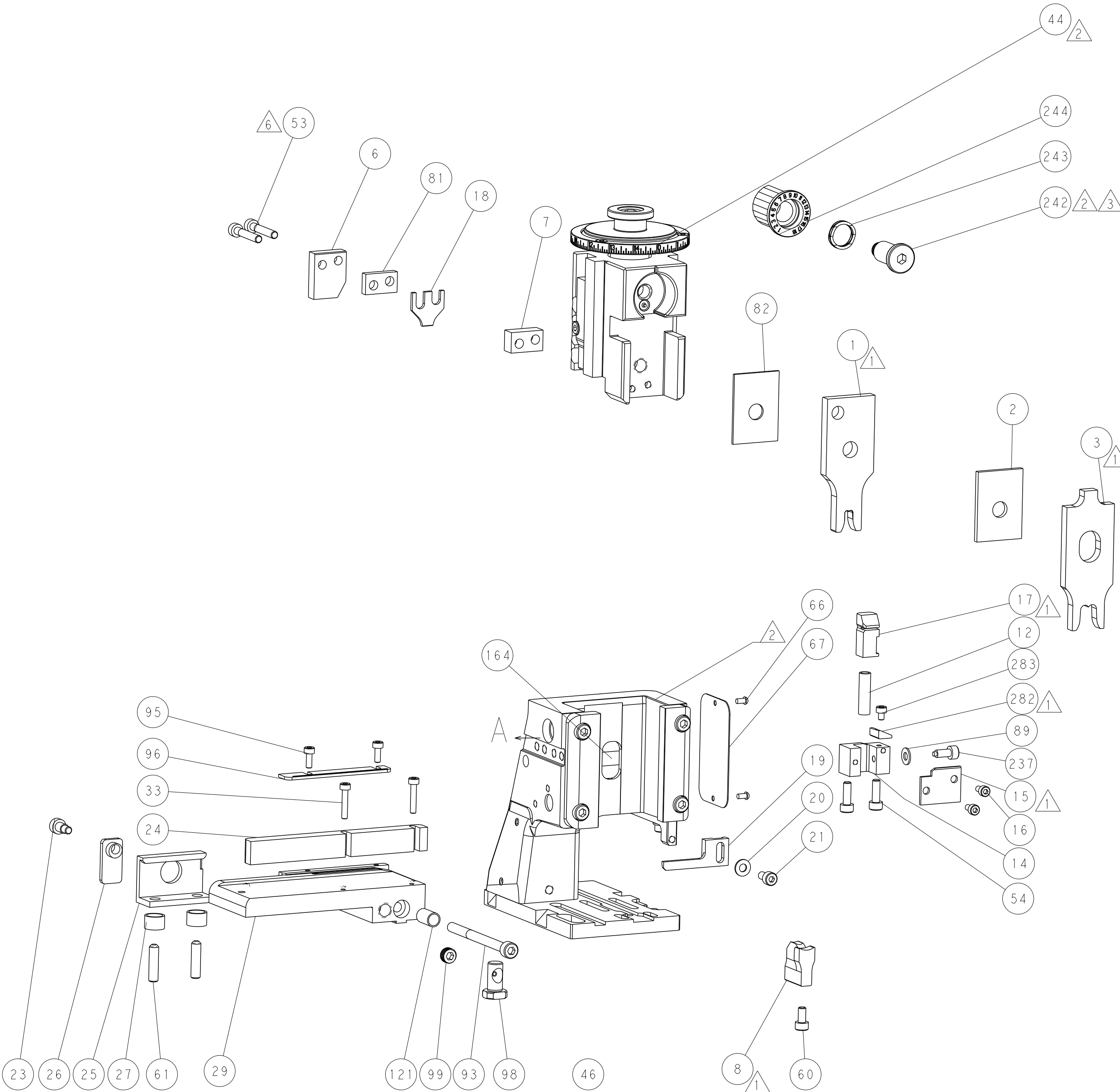
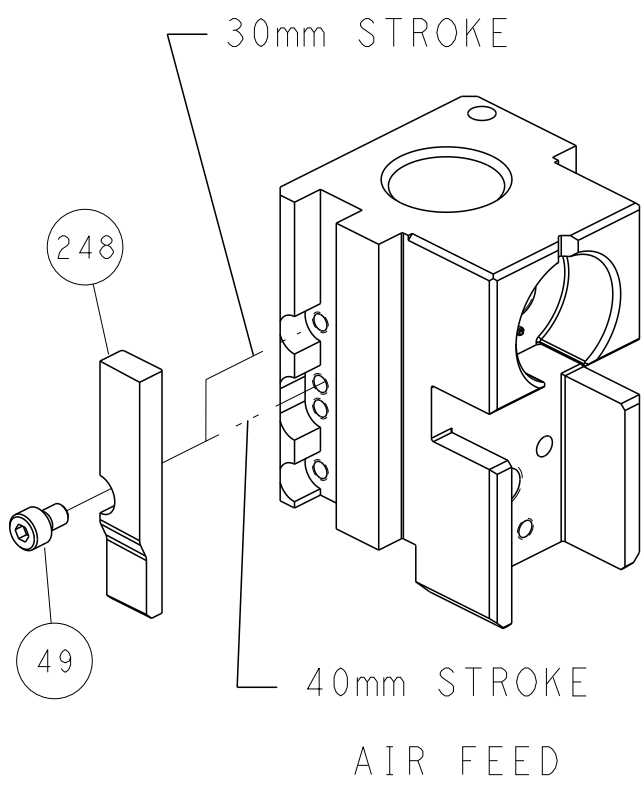


FEED SPRING SETTING POSITION
(SHOWN FROM REAR SIDE)



DETAIL A

CAM POSITION



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

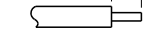
THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO COMPANY CONTROL AND ENDORSEMENT. ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST EDITION.		DWN K. HUANG 17DEC2015	TE Connectivity Harrisburg, PA 17105-3608	
CHK L. ZHANG 17DEC2015		NAME		
APVD J. GUO 17DEC2015		PRODUCT SPEC	Ocean Side Feed Applicator	
		APPLICATION SPEC		
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:	SIZE A1	
		0 PLC ±.0005 1 PLC ±.0005 2 PLC ±.0005 3 PLC ±.0005 4 PLC ±.0005 ANGLES ±.0005 FINISH	CAGE CODE 00779	
MATERIAL -		WEIGHT -	DRAWING NO C=2836142	
		Customer Accessible Production Drawing		RESTRICTED TO -
		SCALE 1:1	SHEET 2	REV C

8	7	
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PART NUMBER	REVISION	DESCRIPTION
2-2836142-2	C	FINE CRIMP HEIGHT ADJUST
7-2836142-7	A	CRIMP TOOLING KIT

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	4.57 mm [.180]	F
INSUL	9.53 mm [.375]	F
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: TERMINAL, HIGH CURRENT HERMAPHRODITIC			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
8.74-10.31 mm [.344-.406 IN]		Ø5.08-9.14 mm [.200-.360 IN]	
TERMINAL APPLICATION SPECIFICATION	114-1004	-	-
			
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
350650-1	350650-3		

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING
8 AWG		3.76+/-0.05 [.148+/- .002]		3.1
10 AWG		3.20+/-0.05 [.126+/- .002]		9.4
12 AWG		2.84+/-0.05 [.112+/- .002]		12.0



- 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 CUT TO LENGHT AT ASSEMBLY.

*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	LTR	DESCRIPTION	DATE
			-	SEE SHEET 1	-

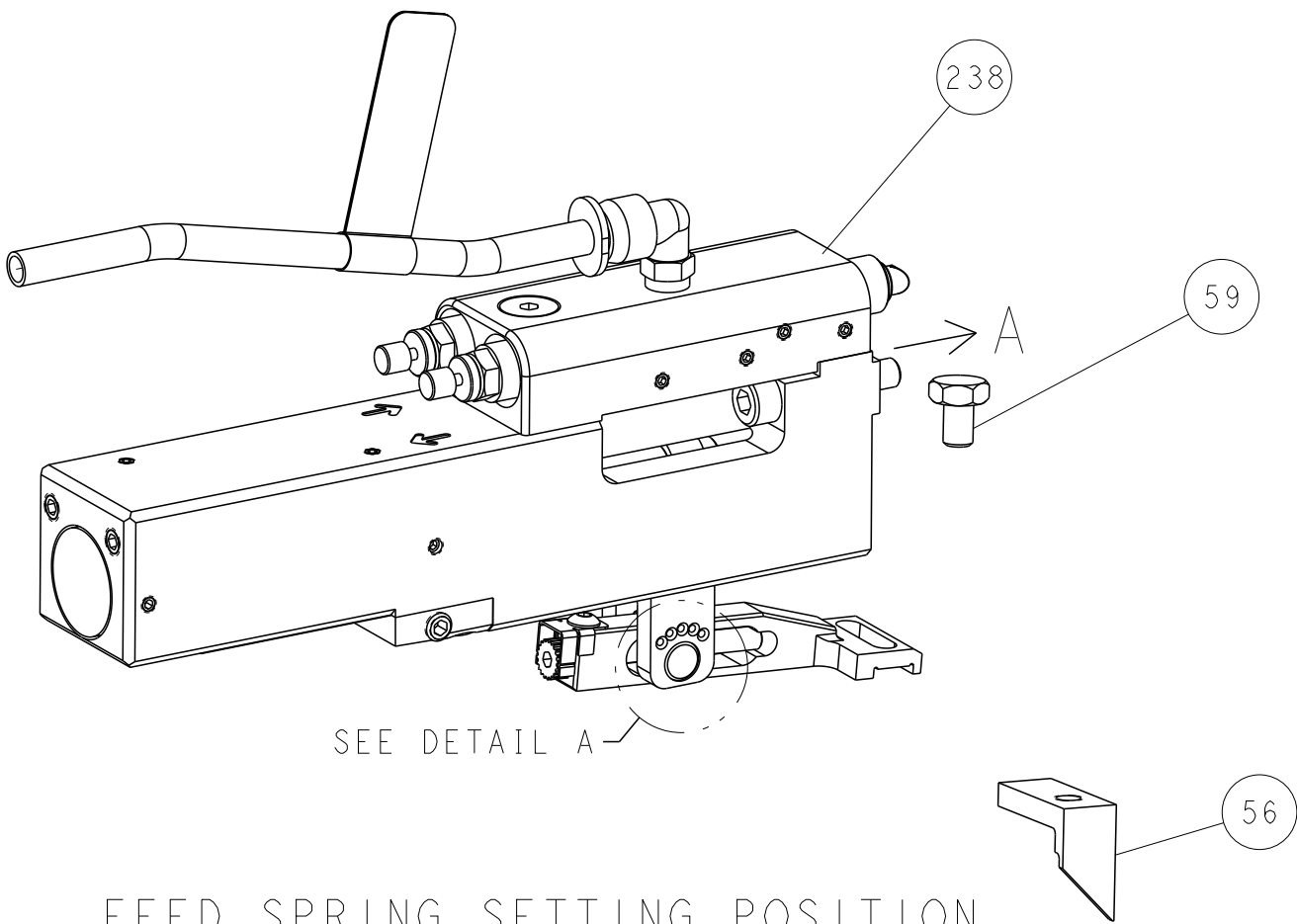
-	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	283
-	1	2280441-1	INSERT, SHEAR	282
-	1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	2844940-2	AIR FEED MODULE	238
-	1	1-356885-4	STOP, SHEAR	237
-	REF	994970-2	COUNTER, MAGNETIC	164
-	1	2119641-2	FEED CAM, AIR FEED	151
-	1	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	144
-	2	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	143
-	1	1-1803583-0	APPLICATOR BASIC ASSEMBLY, SF	141
-	1	1803516-1	RAM ASSEMBLY, SF PACIFIC	140
-	1	1-22281-8	SPRING, COMPRESSION	121
-	1	2844908-1	SCREW, LOCKING	99
-	1	2844907-1	POST, LOCKING	98
-	1	1-690438-0	FRONT STRIP GUIDE	96
-	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	95
-	1	2168083-6	SCR, SKT HD CAP, RoHS, M5 X 65	93
-	1	1-18028-2	WASHER, FLAT, REG M4	89
-	1	1-455888-1	SPACER, CRIMPER	82
-	1	6-240641-9	SPACER	81
-	1	1803607-3	DOCUMENTATION PACKAGE	71
-	1	2119740-1	TAG,IDENTIFICATION	67
-	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	2	2-18032-5	SCR, SET, FLT PNT, M5 X 20.0	61
-	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	1	1-1338683-0	FEED PAWL	56
-	2	1-2168083-2	SCR, SKT HD CAP, RoHS, M4 X 25	53
-	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
-	2	1-2168083-3	SCR, SKT HD CAP, RoHS, M3 X 16	33
-	1	1-2305692-3	PLATE, REAR STRIP GUIDE	29
-	2	22283-1	SPRING, COMPRESSION	27
-	1	356835-1	LEVER, DRAG RELEASE	26
-	1	240792-1	DRAG, TERMINAL	25
-	1	3-189124-1	GUIDE, FRONT STRIP	24
-	1	980371-4	SCR, SKT HD SHLDR 5.0 DIA X 6.0	23
-	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
-	1	1-18028-2	WASHER, FLAT, REG M4	20
-	1	2119533-1	STRIPPER, SIDE FEED	19
-	1	2-690518-7	HOLD DOWN, TERMINAL	18
-	1	690463-1	FLOATING SHEAR, REAR	17
-	2	1-2168083-1	SCR, SKT HD CAP, RoHS, M3 X 6	16
-	1	690464-4	SHEAR PLATE, REAR	15
-	1	2119862-1	SHEAR HOLDER, REAR	14
-	1	3-22280-3	SPRING, COMPRESSION	12
-	-	-	-	10
-	-	-	-	9
1	1	1803320-4	ANVIL, COMBINATION	8
-	1	2-240641-7	SPACER	7
-	1	690468-3	DEPRESSOR SHEAR, REAR	6
-	-	-	-	5
-	1	2-1803409-5	BLOCK, CRIMPER SPACER	4
1	1	9-1803016-3	CRIMPER, INSULATION F	3
-	1	2-455888-4	SPACER, CRIMPER	2
1	1	1-456412-6	CRIMPER, WIRE .180 F PREMIUM	1
-77	-22	PART NO	DESCRIPTION	ITEM NO

THIS DRAWING IS A CONTROLLED DOCUMENT FOR THE CUSTOMER'S INFORMATION. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. THE CUSTOMER'S ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST EDITION.		DWN R. HUANG CHK L. ZHANG APVD J. GUO	17DEC2015 17DEC2015 17DEC2015	STE TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		NAME Ocean Side Feed Applicator	
		0 PLC ±.01 1 PLC ±.01 2 PLC ±.01 3 PLC ±.01 4 PLC ±.01 ANGLES ±.01		PRODUCT SPEC	
MATERIAL		FINISH		APPLICATION SPEC	
-		-		WEIGHT	
-		-		A 00779 ©=2836142	
Customer Accessible Production Drawing		SCALE 1:2		SHEET 3 OF 4	
				REV C	

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

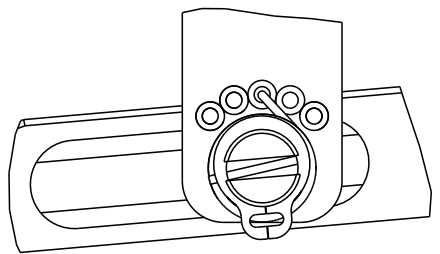
LOC		DIST		REVISIONS					
A		66		P	LTR	DESCRIPTION	DATE	DWN	APVD
					-	SEE SHEET 1	-	-	-

FEED TYPE
PNEUMATIC

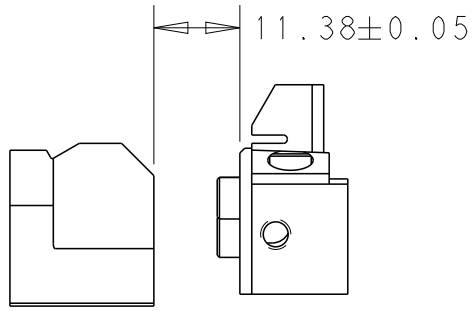


SEE DETAIL A

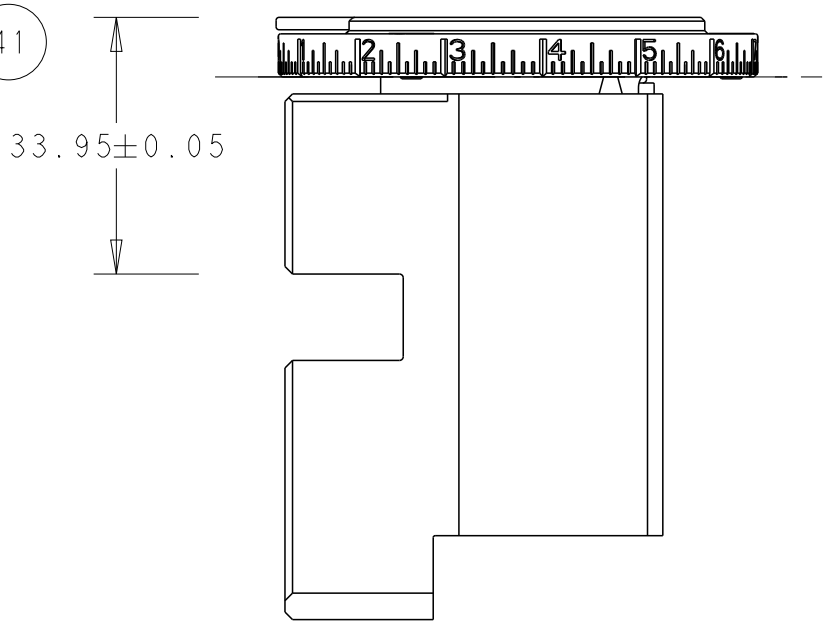
FEED SPRING SETTING POSITION
(SHOWN FROM REAR SIDE)



DETAIL A

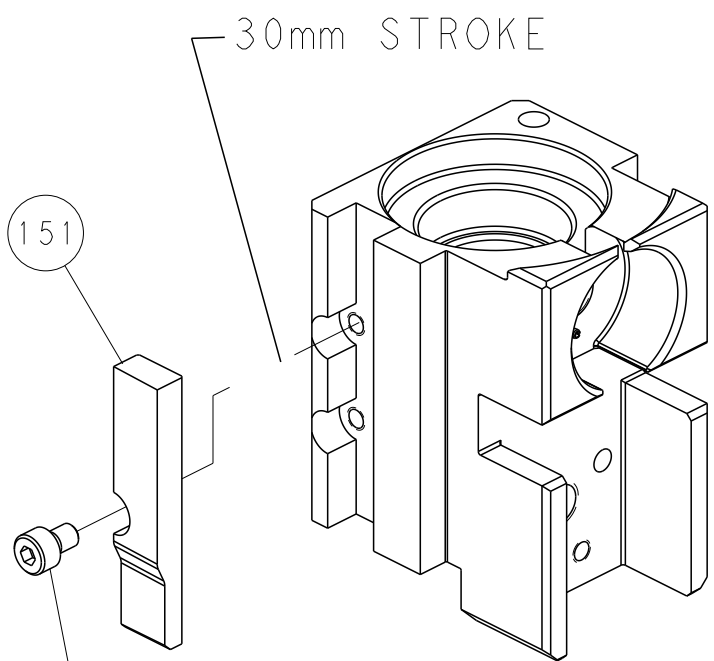


REAR SHEAR LOCATION

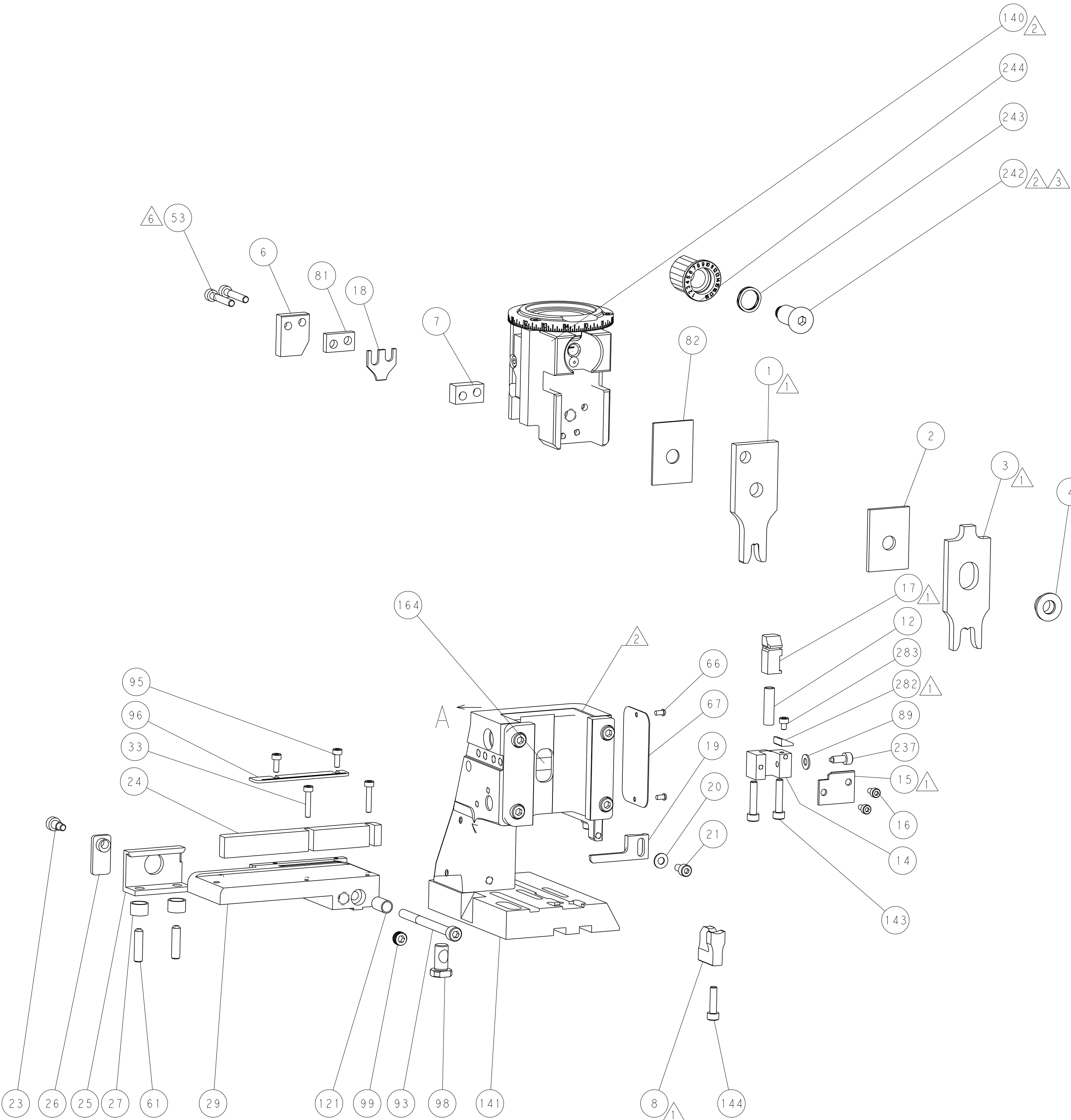


RAM SET-UP

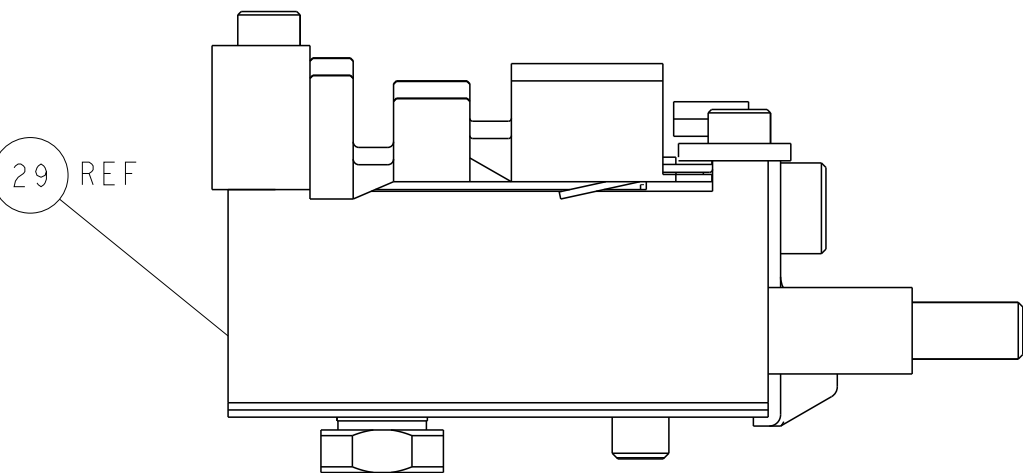
CAM POSITION



AIR FEED



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:		PRODUCT SPEC	
0 PLC 1 PLC 2 PLC 3 PLC 4 PLC		± ± ± ± ±		APPLICATION SPEC	
MATERIAL -		FINISH -		WEIGHT -	
				Customer Accessible Production Drawing	
				SCALE 1:1	
				SHEET 4	
				OF 4	
				REV C	