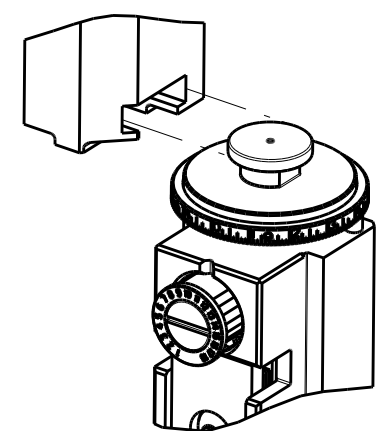


| PART NUMBER | REVISION | DESCRIPTION | FEED TYPE |
|-------------|----------|---------------------------------|-----------|
| 2836162-2 | D | FINE CRIMP HEIGHT ADJUST | PNEUMATIC |
| 7-2836162-2 | D | PNEUMATIC AND CRIMP TOOLING KIT | PNEUMATIC |
| 7-2836162-7 | A | CRIMP TOOLING KIT | - |

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER

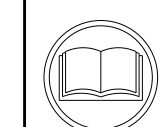


| APPLICATOR DATA | | |
|-----------------|----------------|------|
| CRIMP | SIZE | TYPE |
| WIRE | 3.63 mm [.143] | F |
| INSUL | 4.39 mm [.173] | F |

APPLICATOR INSTRUCTIONS 408-35042

| TERMINAL DATA: LEAR TERMINAL | | LEAR CRIMP SPECIFICATION | |
|------------------------------------|------------------------------|--------------------------|---------------|
| TERMINAL NAME: TERMINAL | | | |
| WIRE STRIP LENGTH | INSULATION DIAMETER RANGE | | |
| 5.10-5.90 mm [.201-.232 IN] | Ø1.90-2.40 mm [.075-.094 IN] | | |
| TERMINAL APPLICATION SPECIFICATION | 28072 | | |
| TERMINALS APPLIED | | | |
| TE TERMINAL | LEAR TERMINAL | TE TERMINAL | LEAR TERMINAL |
| 2113944-1 | 28072.212.179 | 2113944-2 | 28075.122.179 |
| 2113944-3 | 28256.122.179 | | |

| WIRE SIZE | CRIMP HEIGHT mm [INCH] | CRIMP HEIGHT REFERENCE SETTING |
|---------------------|-------------------------------|--------------------------------|
| 1.5mm ² | 2.40 +/- 0.05 [.094 +/- .002] | 9.4 |
| 1mm ² | 2.30 +/- 0.05 [.091 +/- .002] | 10.3 |
| 0.75mm ² | 2.20 +/- 0.05 [.087 +/- .002] | 11.4 |



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

| LOC | DIST | REVISIONS | | | |
|-----|------|-----------|---------------|-----------|-----|
| A | 66 | REV | DATE | BY | CHK |
| | | A | RELEASED | 09FEB2016 | BW |
| | | B | ECR-19-010415 | 03JUL2019 | MZ |
| | | C | ECR-19-014720 | 19SEP2019 | LG |
| | | D | ECR-20-008932 | 23JUN2020 | MZ |

| | | | | | |
|---|-----|-----|-------------|-------------------------------------|-----|
| - | 2 | 2 | 2168083-1 | SCR, SKT HD CAP, RoHS, M3 X 8.0 | 269 |
| - | 1 | 1 | 1633782-8 | FENCE | 267 |
| - | 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 | 1-22281-8 | SPRING, COMPRESSION | 121 |
| - | 1 | 1 | 2844908-1 | SCREW, LOCKING | 99 |
| - | 1 | 1 | 2844907-1 | POST, LOCKING | 98 |
| - | 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 | 455888-6 | 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 |
| - | 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 | 1338683-8 | FEED PAWL | 56 |
| - | 4 | 4 | 2168083-3 | SCR, SKT HD CAP, RoHS, M4 X 12.0 | 54 |
| - | 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 |
| - | 1 | 1 | 1-1752356-8 | SUPPORT, TERMINAL | 34 |
| - | 2 | 2 | 1-2079383-3 | SCR, BHSC, RoHS (M4 X 25) | 33 |
| - | 2 | 2 | 4-2844962-2 | SPACER, CYLINDRICAL, STRIP GUIDE | 30 |
| - | 1 | 1 | 4-2844938-4 | PLATE, STRIP GUIDE | 29 |
| - | 1 | 1 | 455888-3 | SPACER, CRIMPER | 28 |
| - | 2 | 2 | 22283-1 | SPRING, COMPRESSION | 27 |
| - | 1 | 1 | 356835-1 | LEVER, DRAG RELEASE | 26 |
| - | 1 | 1 | 240792-1 | DRAG, TERMINAL | 25 |
| - | 1 | 1 | 1320928-8 | 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 |
| - | 2 | 2 | 1-18028-2 | WASHER, FLAT, REG M4 | 20 |
| - | 1 | 1 | 2119533-1 | STRIPPER, SIDE FEED | 19 |
| - | 1 | 1 | 2119806-1 | INSERT, SHEAR | 13 |
| - | 1 | 1 | 3-22280-3 | SPRING, COMPRESSION | 12 |
| - | 1 | 1 | 1-356885-3 | STOP, SHEAR | 11 |
| - | 1 | 1 | 2119805-1 | SHEAR HOLDER, FRONT | 10 |
| - | 1 | 1 | 1-1803095-2 | FLOATING SHEAR, FRONT | 9 |
| 1 | 2 | 1 | 1803250-5 | ANVIL, COMBINATION | 8 |
| - | - | - | - | - | 7 |
| - | - | - | - | - | 6 |
| - | 1 | 1 | 2119757-6 | DEPRESSOR, SHEAR | 5 |
| - | 1 | 1 | 238011-4 | BLOCK, CRIMPER SPACER | 4 |
| 1 | 2 | 1 | 4-1803187-5 | CRIMPER, INSULATION F | 3 |
| - | 1 | 1 | 455888-9 | SPACER, CRIMPER | 2 |
| 1 | 2 | 1 | 4-1633730-2 | CRIMPER, WIRE | 1 |

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

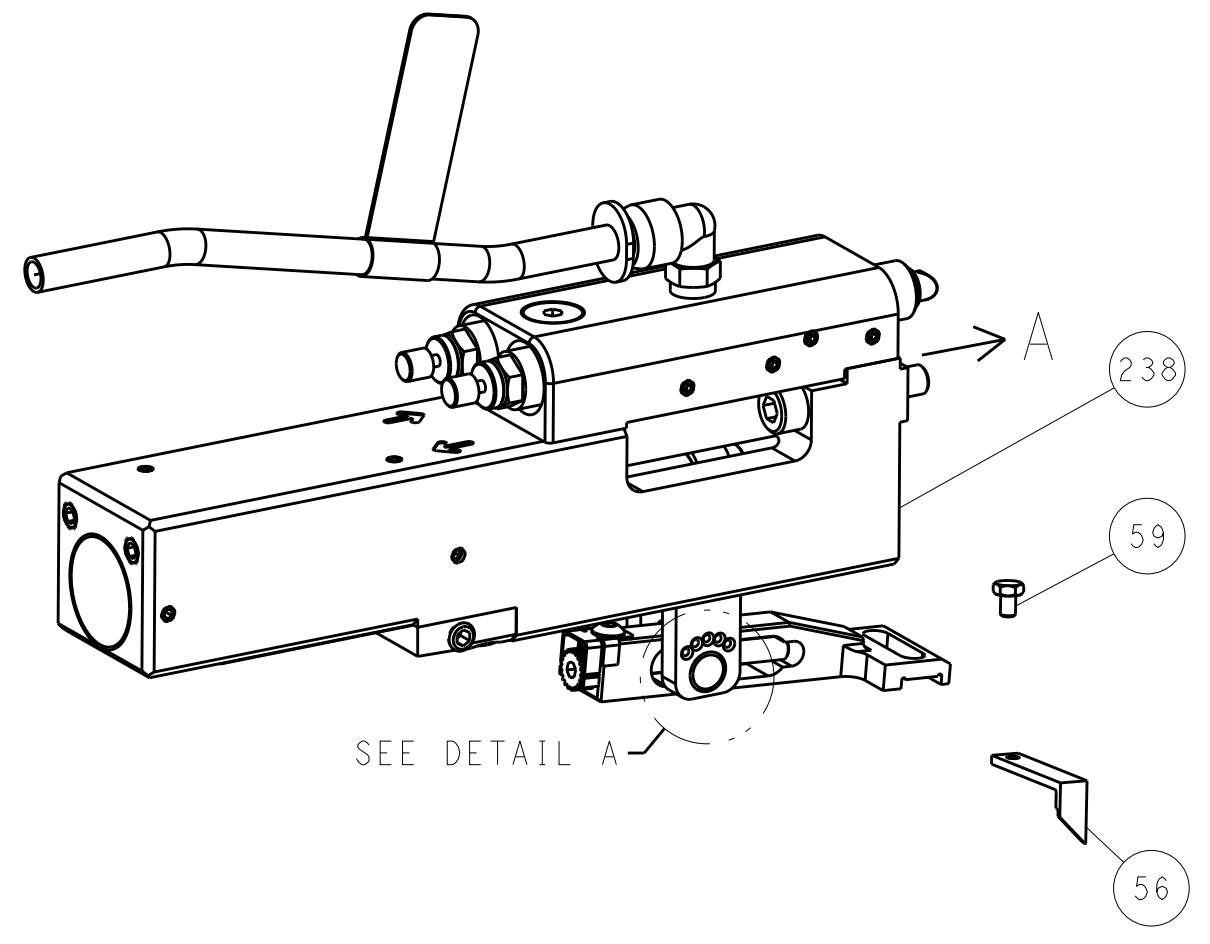
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|-------------|---------|--|---------|-----------|---------|---------|--|
| mm | 0 PLC ± | 1 PLC ± | 2 PLC ± | 3 PLC ± | 4 PLC ± | ANGLES | |
| | | | | | | | |

| | | | |
|--|-----------|------------|--|
| OWN | J. HOU | 12JAN2016 | TE Connectivity Harrisburg, PA 17105-3608 |
| CHK | L. ZHANG | 12JAN2016 | |
| APVD | J. GUO | 12JAN2016 | NAME |
| PRODUCT SPEC | | | Ocean Side Feed |
| APPLICATION SPEC | | | Applicator |
| SIZE | CAGE CODE | DRAWING NO | RESTRICTED TO |
| A1 | 00779 | 2836162 | |
| Customer Accessible Production Drawing | | | SCALE 1:2 SHEET 1 OF 4 REV D |

| LOC | DIST | REVISIONS | | | | | |
|-----|------|-----------|-----|-------------|------|-----|------|
| A | 66 | P. | LTM | DESCRIPTION | DATE | DWN | APVD |
| | | - | - | SEE SHEET 1 | - | - | - |

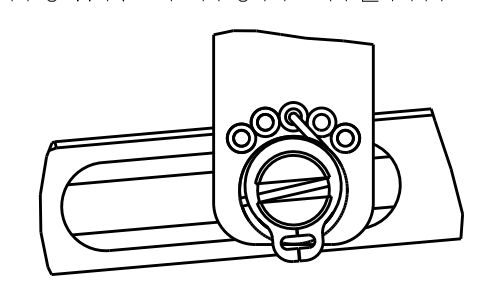
FEED TYPE

PNEUMATIC



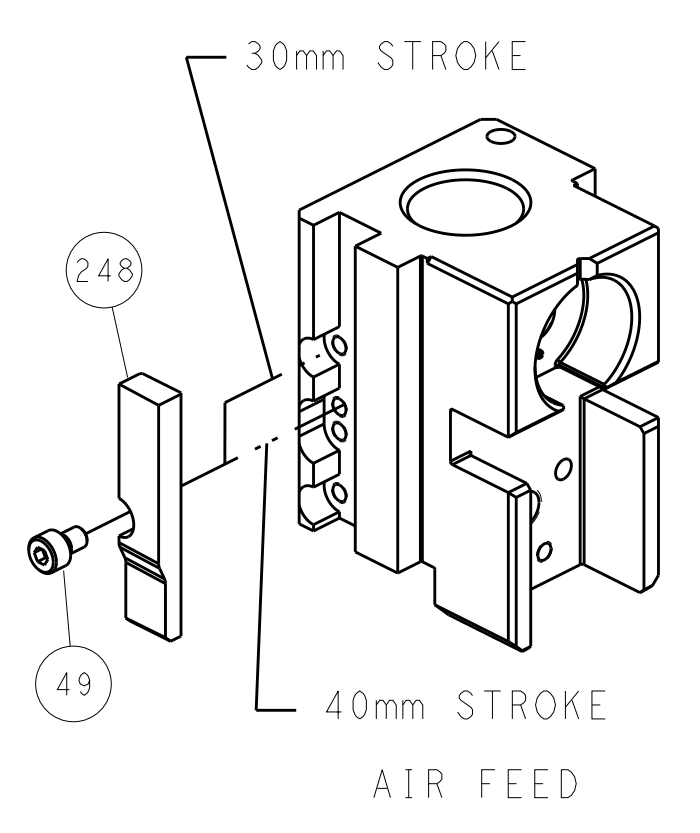
SEE DETAIL A

FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)

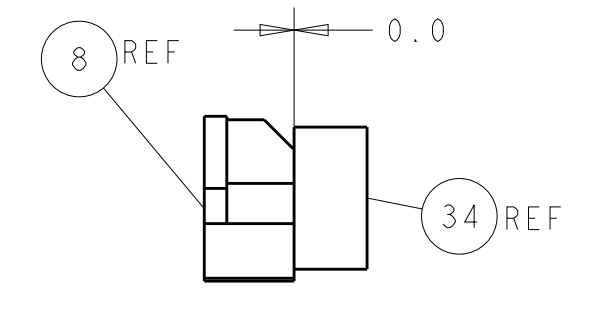
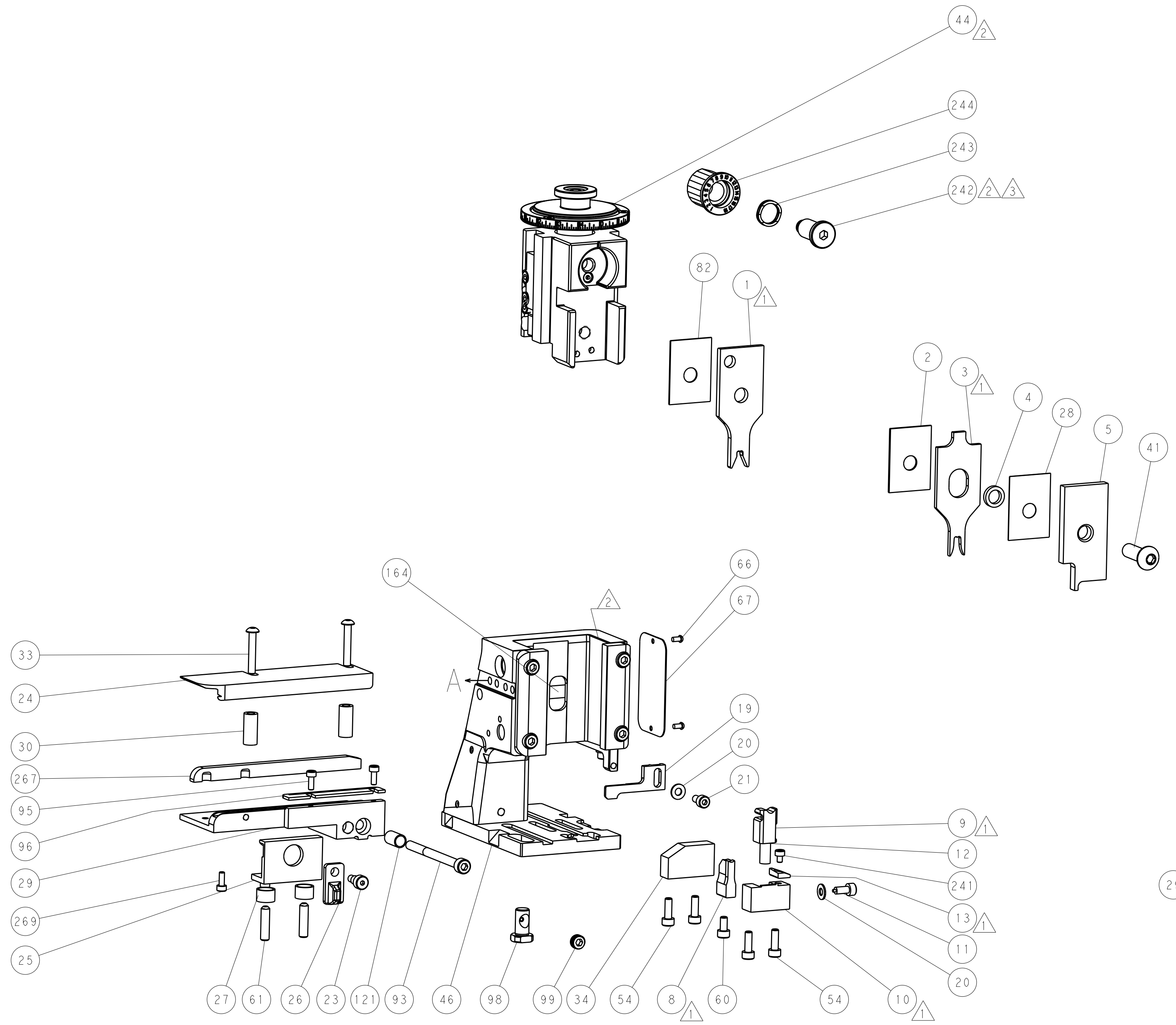


DETAIL A

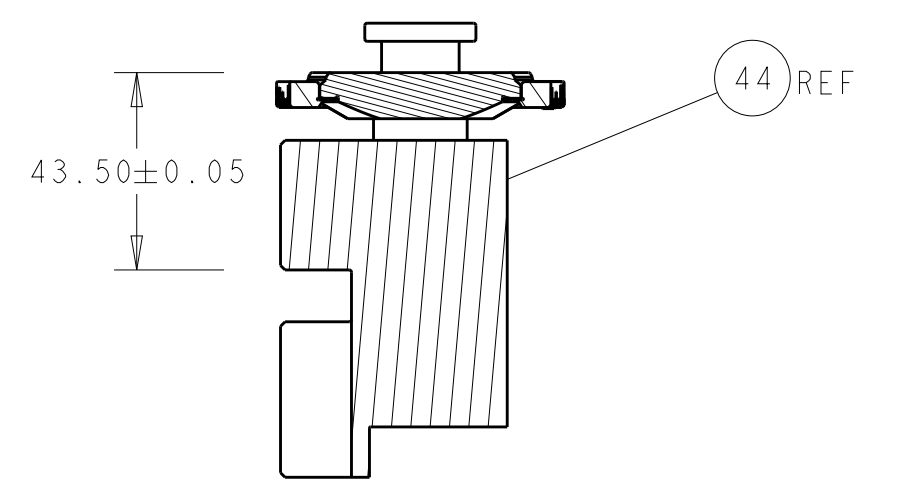
CAM POSITION



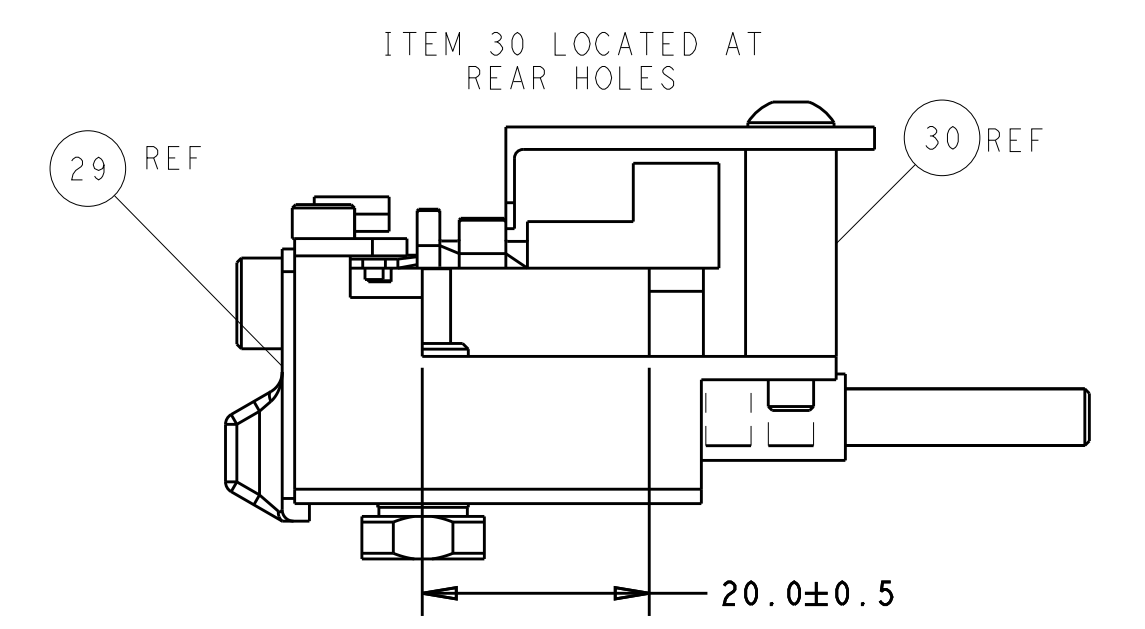
AIR FEED



TERMINAL SUPPORT LOCATION



RAM SET-UP



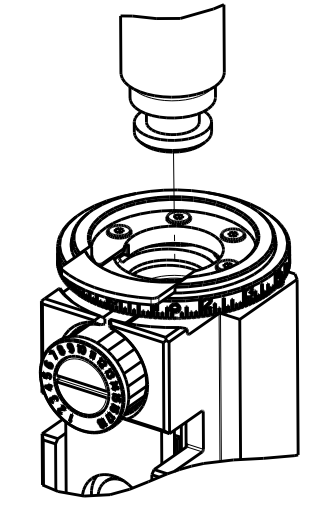
FEED TRACK POSITION GUIDE BY WIRE BARREL

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

| | | | |
|--|--------------------------|--|--|
| <small>THE INFORMATION CONTAINED HEREIN IS UNCLASSIFIED EXCEPT WHERE SHOWN OTHERWISE. IT IS THE POLICY OF TYCO ELECTRONICS CORPORATION TO MAKE THIS INFORMATION AVAILABLE TO THE GENERAL PUBLIC THROUGH THE NATIONAL ARCHIVES AT COLLEGE PARK, MARYLAND. FOR MORE INFORMATION CONTACT THE NATIONAL ARCHIVES AT COLLEGE PARK, MARYLAND.</small> | | DWN: J. HOU 12JAN2016 CHK: L. ZHANG 12JAN2016 APVD: H. GUO 12JAN2016 | TE Connectivity Harrisburg, PA 17105-3608 |
| DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± | MATERIAL: - FINISH: - | PRODUCT SPEC: - APPLICATION SPEC: - WEIGHT: - SCALE: 1:2 | NAME: Ocean Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2836162 SHEET 2 OF 4 REV D |

| PART NUMBER | REVISION | DESCRIPTION | FEED TYPE |
|-------------|----------|--------------------------|-----------|
| 2-2836162-2 | D | FINE CRIMP HEIGHT ADJUST | PNEUMATIC |
| 7-2836162-7 | A | CRIMP TOOLING KIT | - |

PACIFIC VERSION TERMINATOR
 INTERFACE ADAPTER



| APPLICATOR DATA | | |
|-----------------|----------------|------|
| CRIMP | SIZE | TYPE |
| WIRE | 3.63 mm [1.43] | F |
| INSUL | 4.39 mm [1.73] | F |

APPLICATOR INSTRUCTIONS
 408-35042

| TERMINAL DATA: LEAR TERMINAL | | LEAR CRIMP SPECIFICATION | |
|---|-----------------|--|-----------------|
| TERMINAL NAME: TERMINAL | | | |
| WIRE STRIP LENGTH 5.10-5.90 mm [1.201-.232 IN] | | INSULATION DIAMETER RANGE Ø1.90-2.40 mm [0.075-.094 IN] | |
| TERMINAL APPLICATION SPECIFICATION | 28072 | - | - |
| TERMINALS APPLIED | | | |
| TE TERMINAL | LEAR TERMINAL | TE TERMINAL | LEAR TERMINAL |
| 2113944-1 | 28072, 212, 179 | 2113944-2 | 28075, 122, 179 |
| 2113944-3 | 28256, 122, 179 | | |

| WIRE SIZE | CRIMP HEIGHT mm [INCH] | CRIMP HEIGHT REFERENCE SETTING |
|---------------------|--------------------------------|--------------------------------|
| 1.5mm ² | 2.40 +/- 0.05 [1.094 +/- .002] | 9.4 |
| 1mm ² | 2.30 +/- 0.05 [1.091 +/- .002] | 10.3 |
| 0.75mm ² | 2.20 +/- 0.05 [1.087 +/- .002] | 11.4 |



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

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

| REV | DATE | DESCRIPTION | DATE | BY | APPD |
|-----|------|-------------|-------------------------------------|----|------|
| - | 2 | 2168083-1 | SCR, SKT HD CAP, RoHS, M3 X 8.0 | | 269 |
| - | 1 | 1633782-8 | FENCE | | 267 |
| - | 1 | 2119082-4 | CAM, SNAIL, INSULATION ADJUSTMENT | | 244 |
| - | 1 | 2079764-1 | WASHER, WAVE SPRING, CREST-TO-CREST | | 243 |
| - | 1 | 2119083-1 | RETAINER, INSULATION DIAL | | 242 |
| - | 1 | 7-18023-7 | SCR, SKT HD CAP M3 X 4.0 | | 241 |
| - | 1 | 2844940-1 | AIR FEED MODULE | | 238 |
| - | 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 |
| - | 4 | 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 | 455888-6 | SPACER, CRIMPER | | 82 |
| - | 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 | 1338683-8 | FEED PAWL | | 56 |
| - | 1 | 18023-9 | SCR, SKT HD CAP M4 X 6.0 | | 49 |
| - | 1 | 1803602-1 | SCR, BHSC, RoHS (M8 X 25) | | 41 |
| - | 1 | 1-1752356-8 | SUPPORT, TERMINAL | | 34 |
| - | 2 | 1-2079383-3 | SCR, BHSC, RoHS (M4 X 25) | | 33 |
| - | 2 | 4-2844962-2 | SPACER, CYLINDRICAL, STRIP GUIDE | | 30 |
| - | 1 | 4-2844938-4 | PLATE, STRIP GUIDE | | 29 |
| - | 1 | 455888-3 | SPACER, CRIMPER | | 28 |
| - | 2 | 22283-1 | SPRING, COMPRESSION | | 27 |
| - | 1 | 356835-1 | LEVER, DRAG RELEASE | | 26 |
| - | 1 | 240792-1 | DRAG, TERMINAL | | 25 |
| - | 1 | 1320928-8 | STRIP GUIDE | | 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 |
| - | 2 | 1-18028-2 | WASHER, FLAT, REG M4 | | 20 |
| - | 1 | 2119533-1 | STRIPPER, SIDE FEED | | 19 |
| - | 1 | 2119806-1 | INSERT, SHEAR | | 13 |
| - | 1 | 3-22280-3 | SPRING, COMPRESSION | | 12 |
| - | 1 | 1-356885-3 | STOP, SHEAR | | 11 |
| - | 1 | 2119805-1 | SHEAR HOLDER, FRONT | | 10 |
| - | 1 | 1-1803095-2 | FLOATING SHEAR, FRONT | | 9 |
| 1 | 1 | 1803250-5 | ANVIL, COMBINATION | | 8 |
| - | - | - | - | | 7 |
| - | - | - | - | | 6 |
| - | 1 | 2119757-6 | DEPRESSOR, SHEAR | | 5 |
| - | 1 | 238011-4 | BLOCK, CRIMPER SPACER | | 4 |
| 1 | 1 | 4-1803187-5 | CRIMPER, INSULATION F | | 3 |
| - | 1 | 455888-9 | SPACER, CRIMPER | | 2 |
| 1 | 1 | 4-1633730-2 | CRIMPER, WIRE | | 1 |

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: | | MATERIAL: | | FINISH: | |
|-------------|---------|--|---------|-----------|---------|----------|----------|
| mm | 0 PLC ± | 1 PLC ± | 2 PLC ± | 3 PLC ± | 4 PLC ± | ANGLES ± | FINISH ± |

| | | | | | | | |
|------|-----------|-----|--------|------|-----------|-----|----------|
| DATE | 12JAN2016 | CHK | J. HOU | DATE | 12JAN2016 | CHK | L. ZHANG |
| DATE | 12JAN2016 | CHK | J. GUO | DATE | 12JAN2016 | CHK | J. GUO |

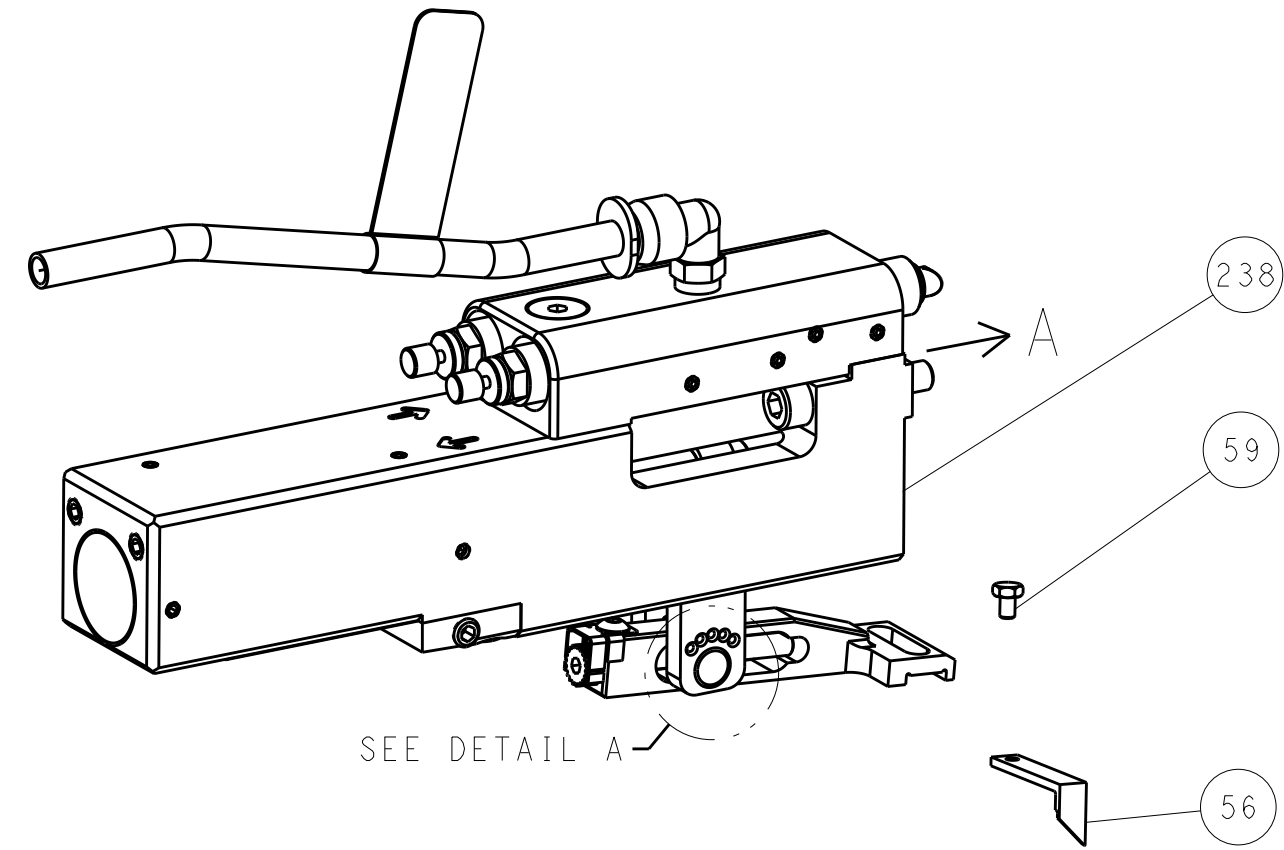
| | | | |
|------|----------------------------|------------|---------------|
| NAME | Ocean Side Feed Applicator | | |
| SIZE | CAGE CODE | DRAWING NO | RESTRICTED TO |
| A1 | 00779 | 2836162 | |

Customer Accessible Production Drawing SCALE 1:2 SHEET 3 OF 4 REV D

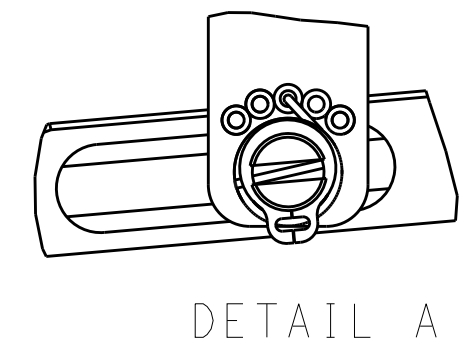
| LOC | | DIST | | REVISIONS | | | |
|-----|----|------|-----|-------------|------|-----|------|
| A | 66 | P | LTH | DESCRIPTION | DATE | DWN | APVD |
| | | - | | SEE SHEET 1 | - | - | - |

FEED TYPE

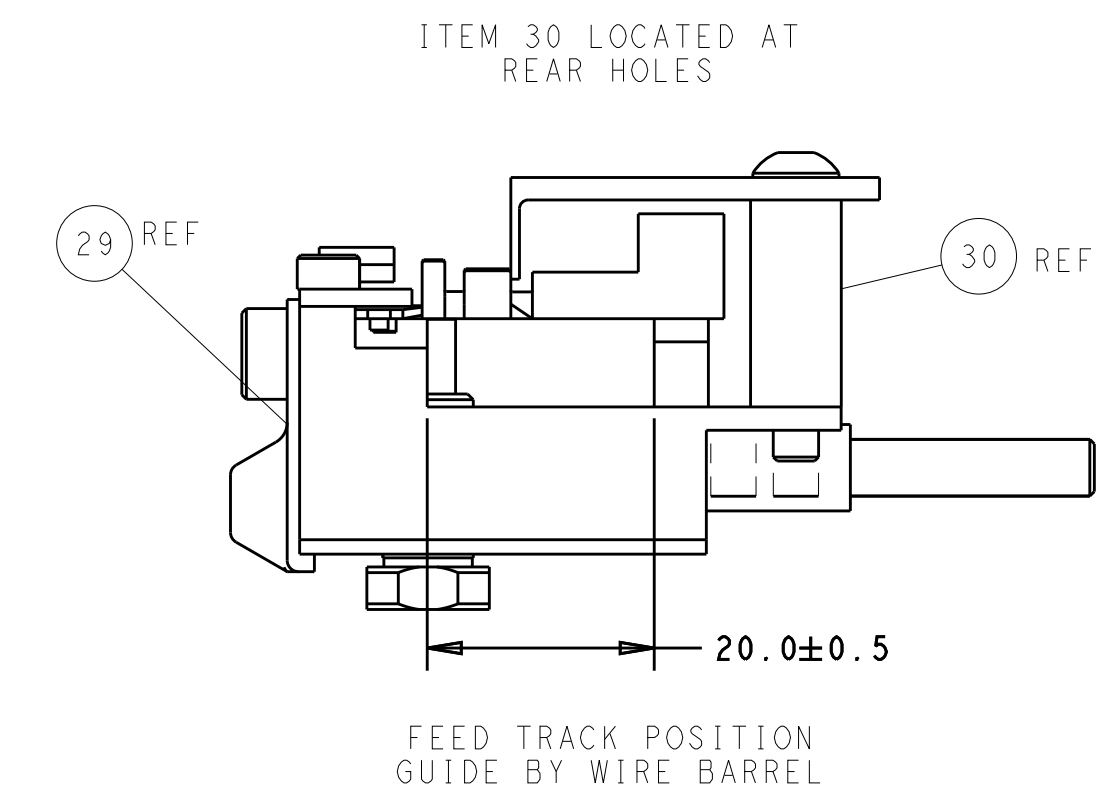
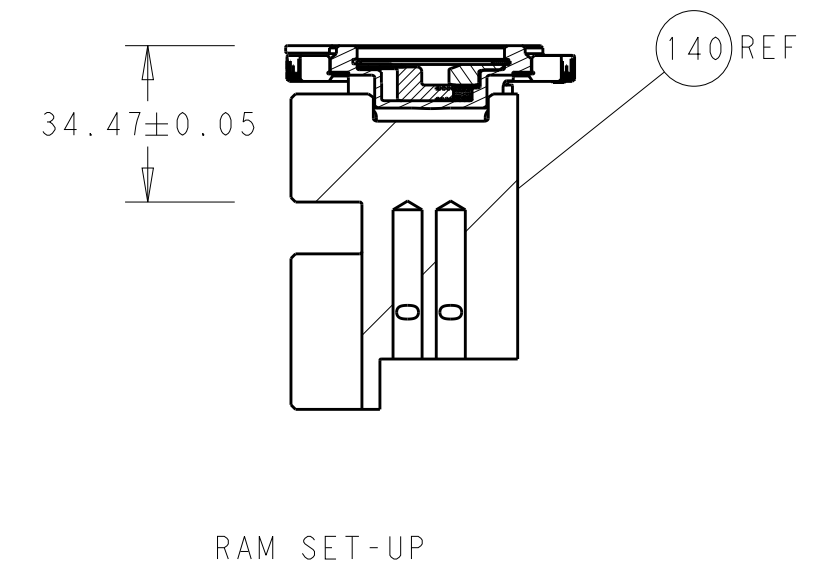
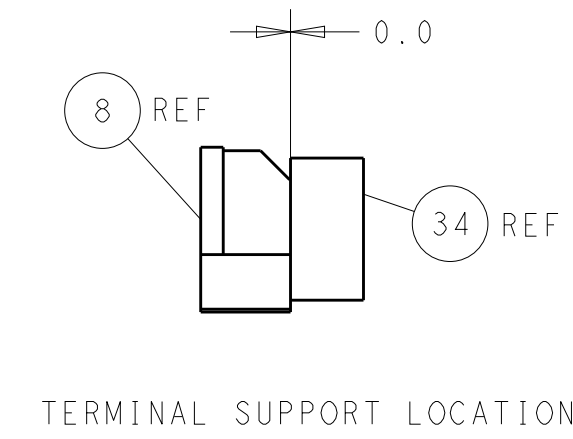
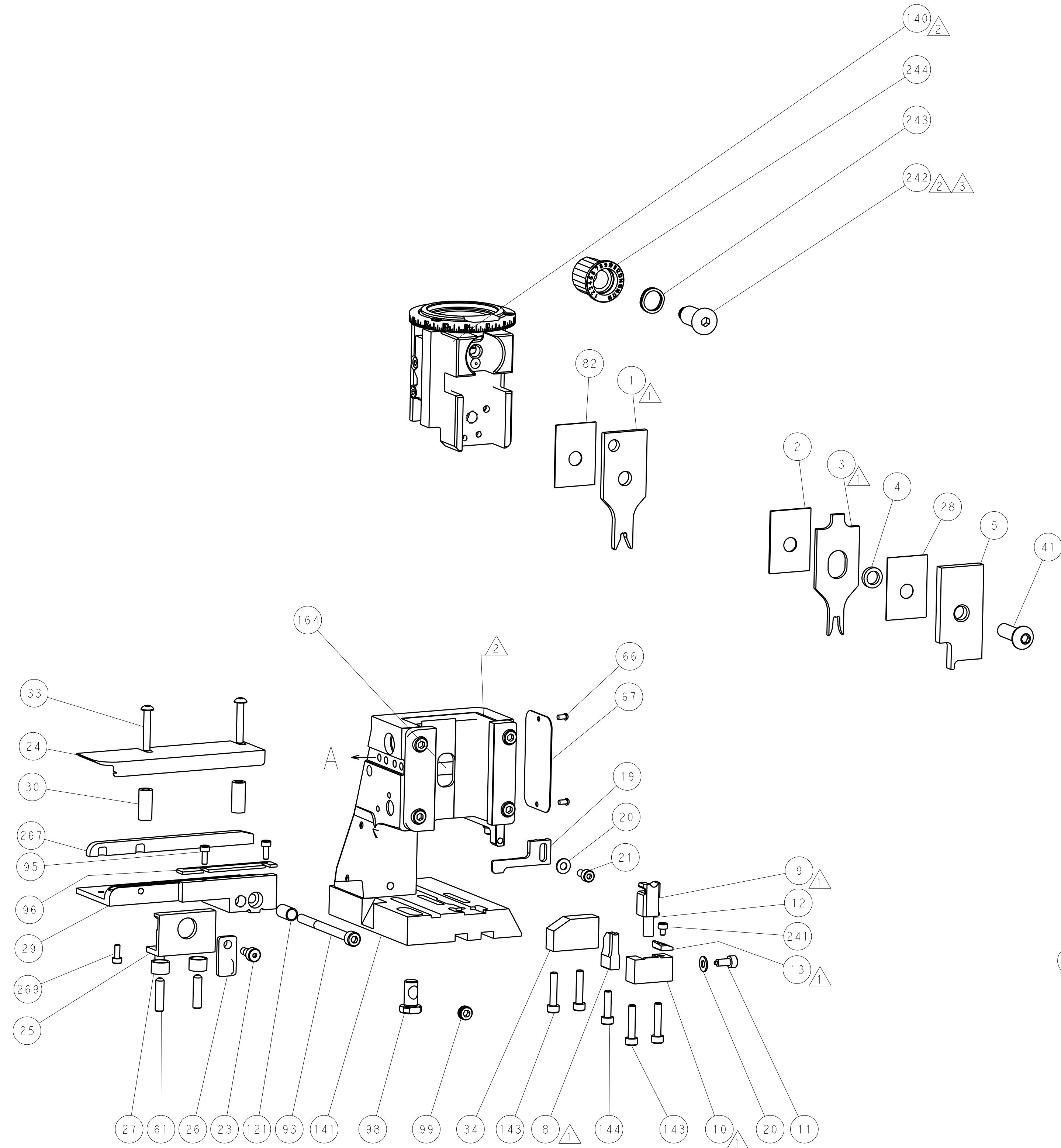
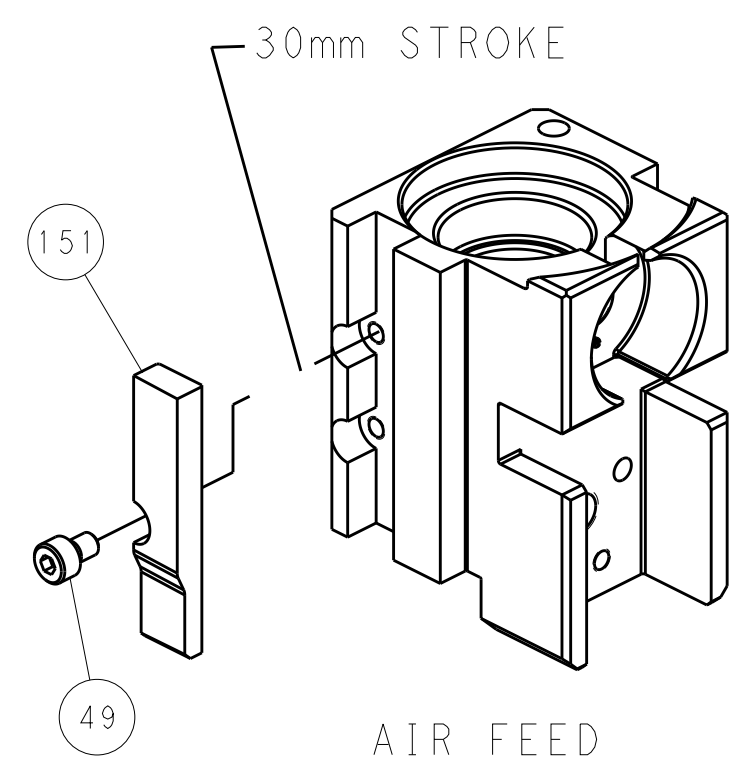
PNEUMATIC



FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



CAM POSITION



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. IT IS THE PROPERTY OF TYCO ELECTRONICS CORPORATION AND IS TO BE USED ONLY FOR THE PURPOSES AND IN THE MANNER SPECIFIED BY THE DRAWING. IT IS TO BE RETURNED TO TYCO ELECTRONICS CORPORATION WHEN NO LONGER REQUIRED.</small> | | DWN: J. HOU 12JAN2016 CHK: L. ZHANG 12JAN2016 APVD: H. GUO 12JAN2016 | 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 SCALE: 1:2 | SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2836162 SHEET 4 OF 4 REV D |
| MATERIAL: - FINISH: - | | RESTRICTED TO: - Customer Accessible Production Drawing | |