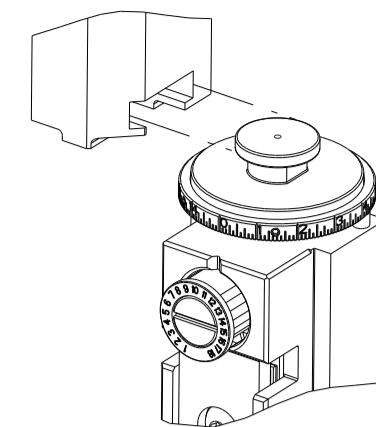


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2836174-2	D	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2836174-2	D	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2836174-7	E	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER

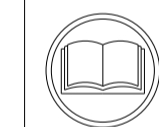


APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	4.47 mm [.176]	SP
INSUL	4.39 mm [.173]	D

APPLICATOR INSTRUCTIONS 408-35042

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: ULTRA FAST PLUS FULLY INSULATED FASTON			
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE		
6.73-7.54 mm [.265-.297 IN]	∅ 1.52-3.05 mm [.060-.120 IN]		
TERMINAL APPLICATION SPECIFICATION	114-2123		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
2-520932-2	2-520979-2		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING	∅ SOLDER
18 AWG	1.78+/-0.05 [.070+/-0.002]	6.1	.125 IN [3.18mm]
(2) 22 AWG	1.78+/-0.05 [.070+/-0.002]	6.1	.125 IN [3.18mm]
20 AWG	1.65+/-0.05 [.065+/-0.002]	7.6	.125 IN [3.18mm]
22 AWG	1.65+/-0.05 [.065+/-0.002]	7.6	.125 IN [3.18mm]



- 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. TO CHECK CRIMP HEIGHT, CRIMP SOLDER (∅.125 IN [3.18mm]) 60/40 SOLID CORE AND MEASURE AT CENTER OF SLUG.
- 6. TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- 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.

LOC	DIST	REVISIONS					
A	66	P	LTN	DESCRIPTION	DATE	OWN	APVD
		B		ECR-18-017219	31OCT2018	JAH	CT
		C		ECR-19-003389	01MAR2019	JAH	TE
		D		ECR-19-009770	23JUN2019	TB	TE
		E		ECR-22-150408	25AUG2022	FZ	TE

-	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	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
-	1	1	2844940-1	AIR FEED MODULE	238
-	1	1	356885-4	STOP, SHEAR	237
-	1	1	1-18028-0	WASHER, FLAT, REG M8	192
-	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	1	1	1-22281-8	SPRING, COMPRESSION	121
-	1	1	2844908-1	SCREW, LOCKING	98
-	1	1	2844907-1	POST, LOCKING	97
-	1	1	1-690438-0	FRONT STRIP GUIDE	96
-	1	1	2168083-6	SCR, SKT HD CAP, RoHS, M5 X 6.5	93
-	1	1	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	84
-	6	6	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	83
-	1	1	455888-5	SPACER, CRIMPER	82
-	1	1	240641-9	SPACER	81
-	1	1	1803607-3	DOCUMENTATION PACKAGE	71
-	2	2	1-18028-4	WASHER, FLAT, REG M3	68
-	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	2079383-4	SCR, BHSC, RoHS (M4 X 8)	60
-	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	1	1	462427-2	FINGER, FEED	56
-	2	2	2168400-1	SHCS, LOW HEAD, RoHS, M4 X 12	54
-	2	2	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	53
-	1	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	1	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	2161336-2	PLATE, REAR STRIP GUIDE	29
-	2	2	22281-9	SPRING, COMPRESSION	27
-	1	1	356835-1	LEVER, DRAG RELEASE	26
-	1	1	240792-1	DRAG, TERMINAL	25
-	1	1	684042-4	GUIDE, STRIP, FRONT	24
-	1	1	980371-4	SCR, SKT HD SHLDR 5.0 DIA X 6.0	23
-	1	1	2161335-2	SHEAR PLATE, REAR	22
-	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	463460-3	HOLD DOWN, TERMINAL	18
-	1	1	803925-2	GUIDE, CARRIER SCRAP	17
-	2	2	1-2079383-0	SCR, BHSC, RoHS (M3 X 6)	16
-	1	1	469542-3	REAR FLOATING SHEAR	15
-	1	1	2119862-2	SHEAR HOLDER, REAR	14
-	1	1	2280441-1	INSERT, SHEAR	13
-	1	1	3-22280-3	SPRING, COMPRESSION	12
-	-	-	-	-	10
-	1	1	1-454766-7	ANVIL, INSULATION	9
-	1	2	808025-3	ANVIL	8
-	1	1	690468-6	DEPRESSOR SHEAR, REAR	6
-	-	-	-	-	5
-	1	1	4-238011-4	BLOCK, CRIMPER SPACER	4
-	1	2	1803130-4	CRIMPER, INSULATION FASTON	3
-	-	-	-	-	2
-	1	2	464290-1	CRIMPER, SEMI-FLAT 22-18	1

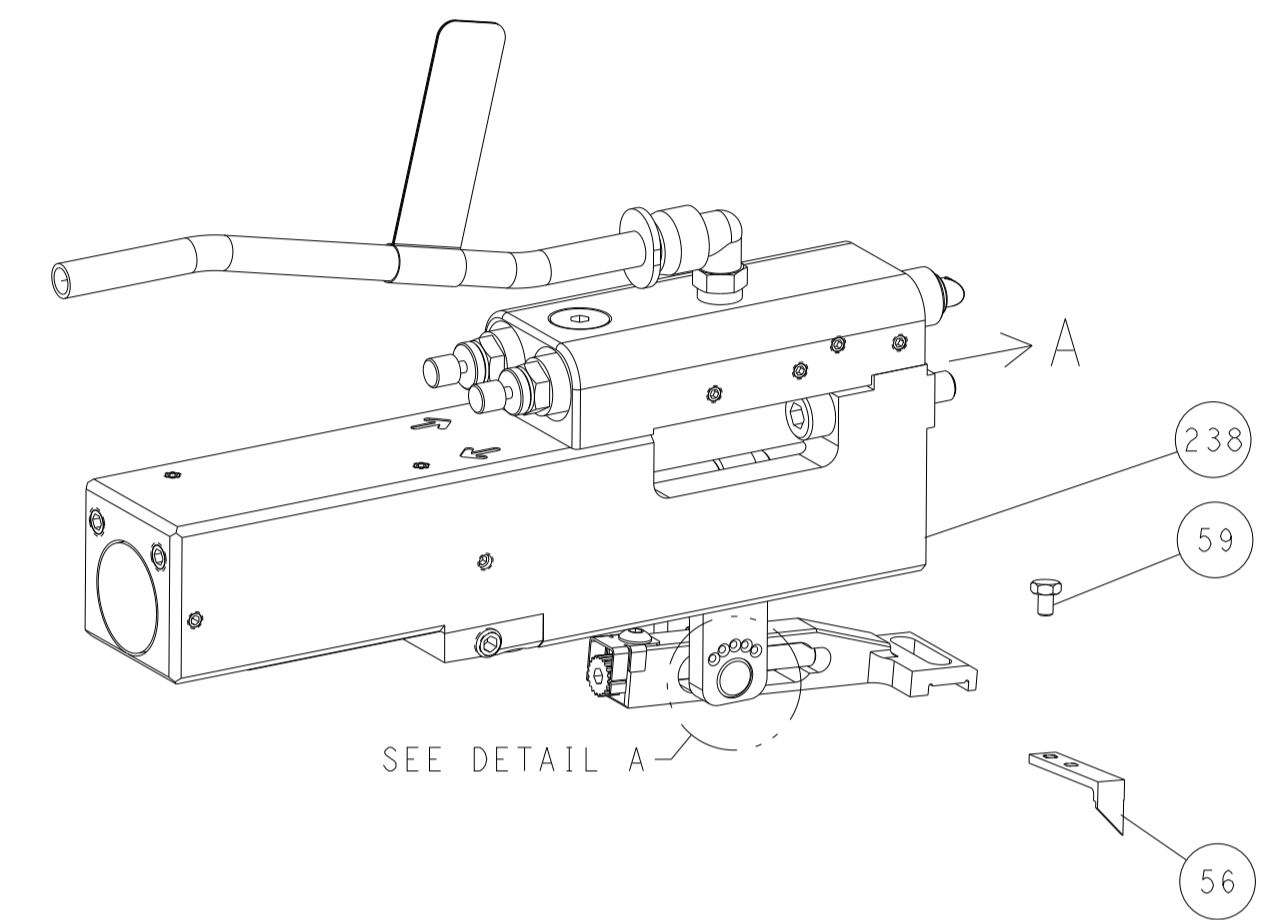
ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		APVD		NAME	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	APPLICATOR SPEC	
	ANGLES	FINISH				PRODUCT SPEC	
MATERIAL				WEIGHT		SIZE	CAGE CODE
						A1	00779
Customer Accessible Production Drawing				SCALE	1:2	SHEET	1 of 4

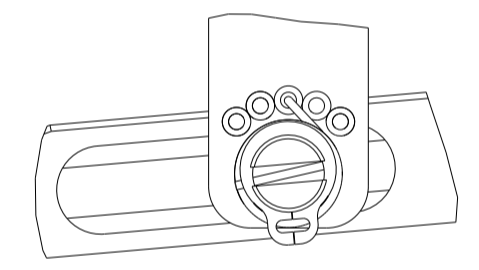
LOC	DIST	REVISIONS					
		P	LTN	DESCRIPTION	DATE	OWN	APVD
A	66	-	-	SEE SHEET 1	-	-	-

FEED TYPE

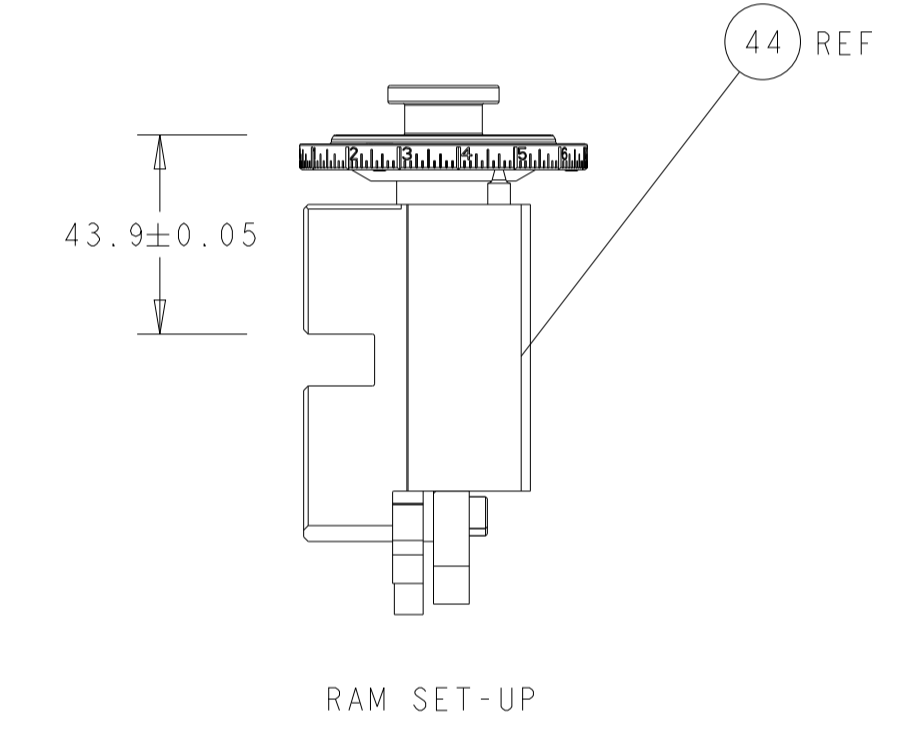
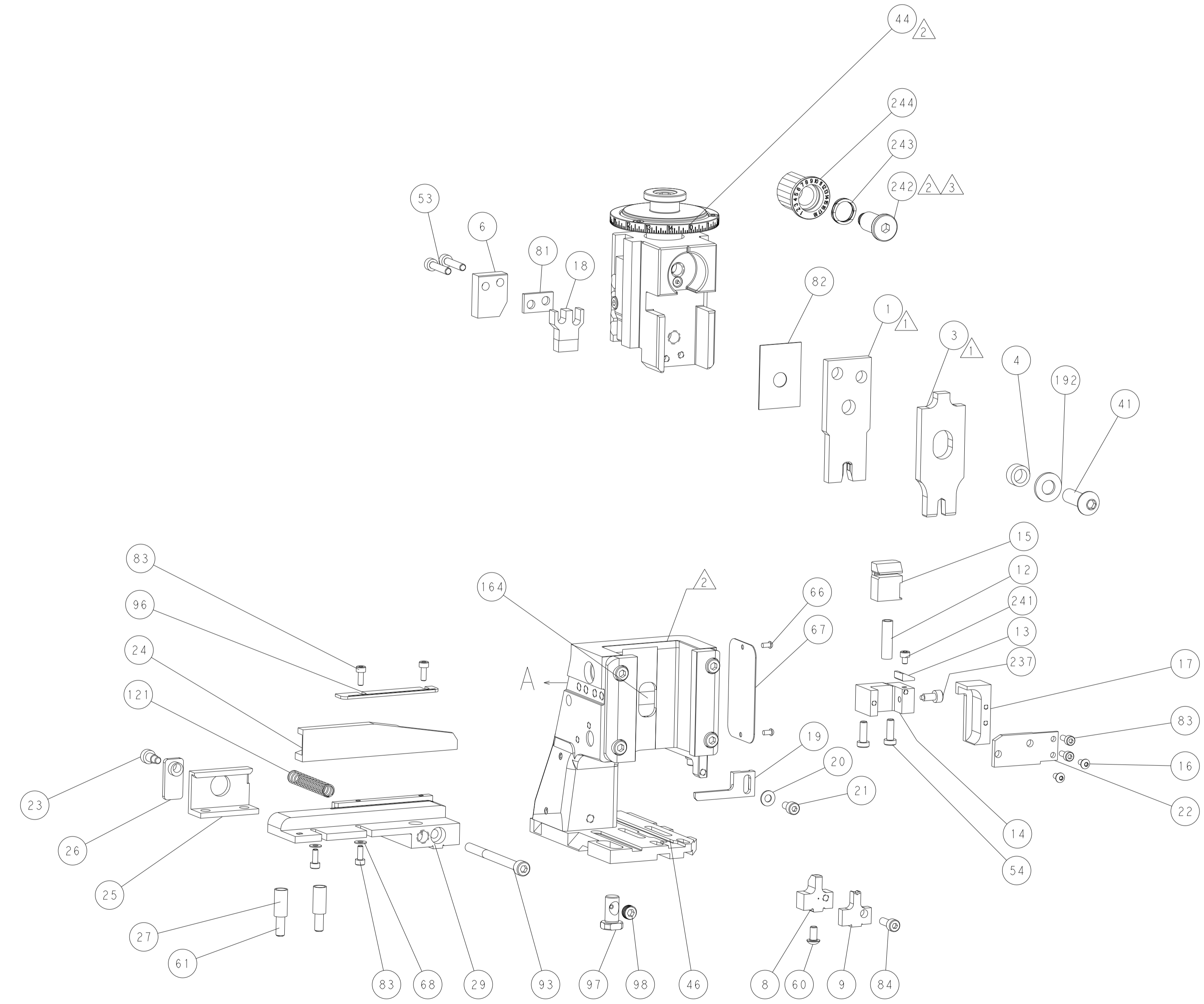
PNEUMATIC



FEED SPRING SETTING POSITION
(SHOWN FROM REAR SIDE)

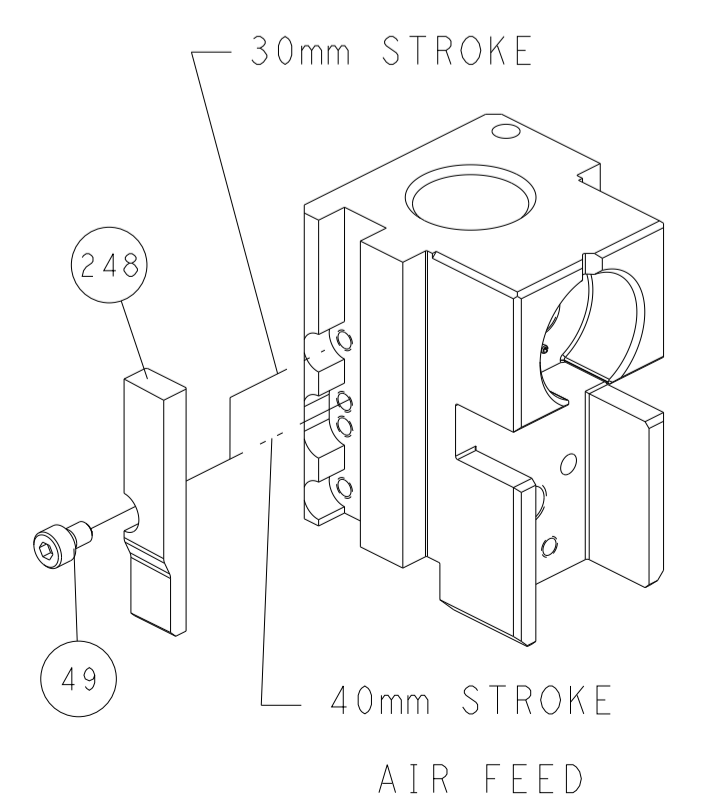


DETAIL A



RAM SET-UP

CAM POSITION



AIR FEED

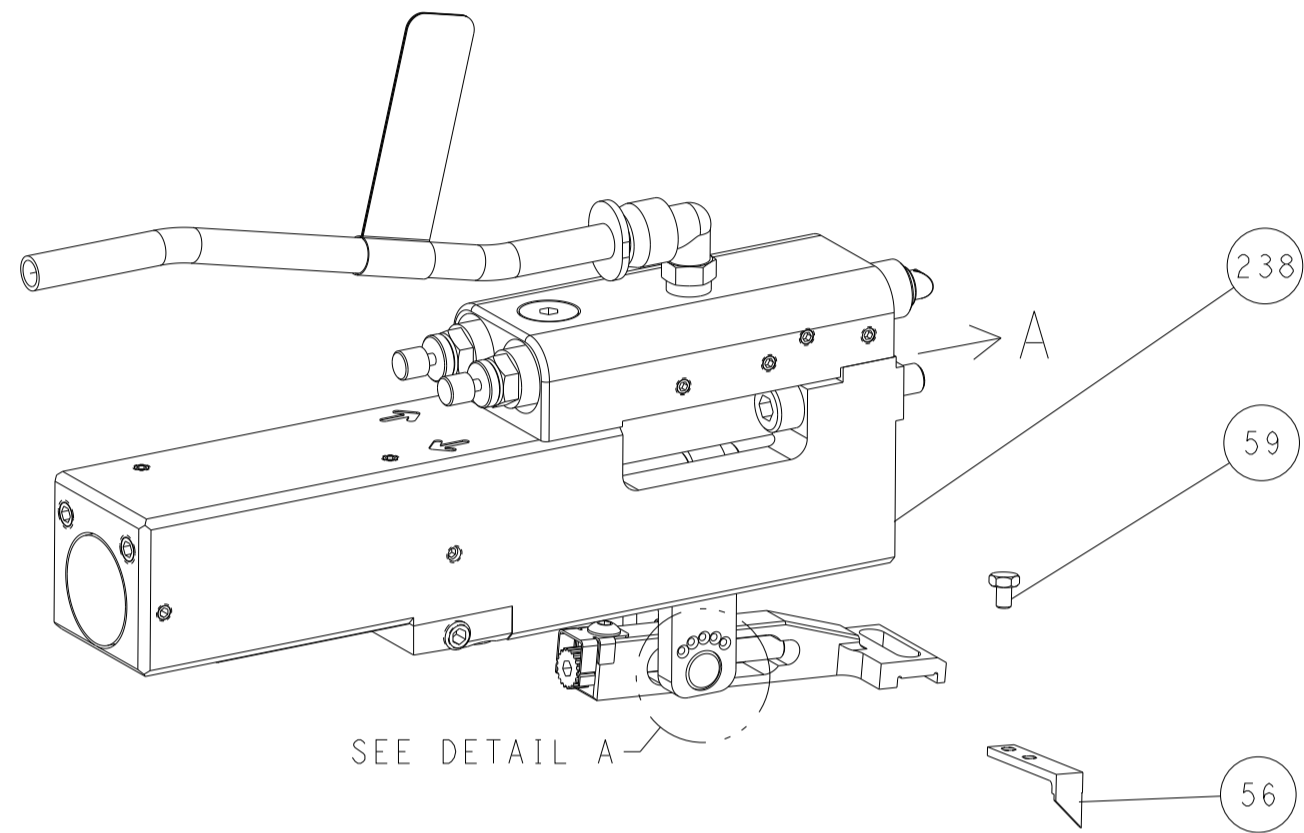
ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

<small>THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION 2016 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.</small>		DWN B. WEAVER 21JAN2016 CHK T. ELBIN 21JAN2016 APVD T. ELBIN 21JAN2016	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 WEIGHT SCALE 1:2 SHEET 2 OF 4 REV E	SIZE CAGE CODE DRAWING NO RESTRICTED TO A 00779 C=2836174
MATERIAL:		Customer Accessible Production Drawing	

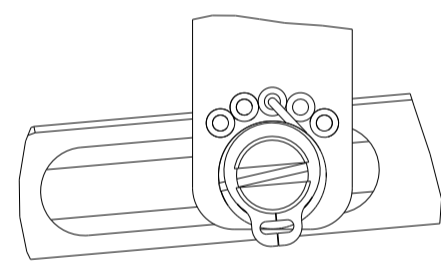
LOC	DIST	REVISIONS			
P	LTN	DESCRIPTION	DATE	OWN	APVD
A	66	SEE SHEET 1	-	-	-

FEED TYPE

PNEUMATIC

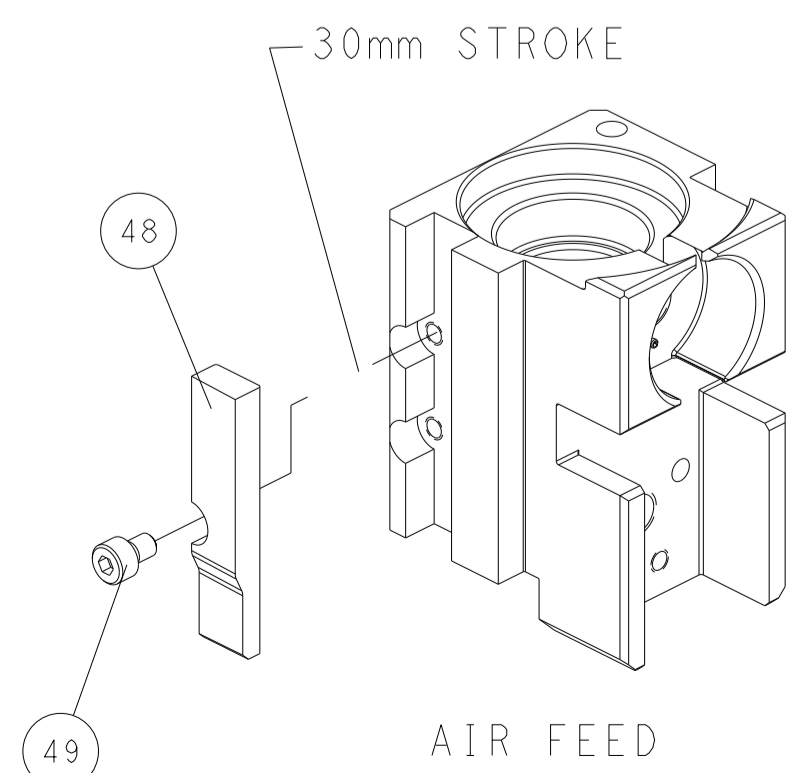


FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)

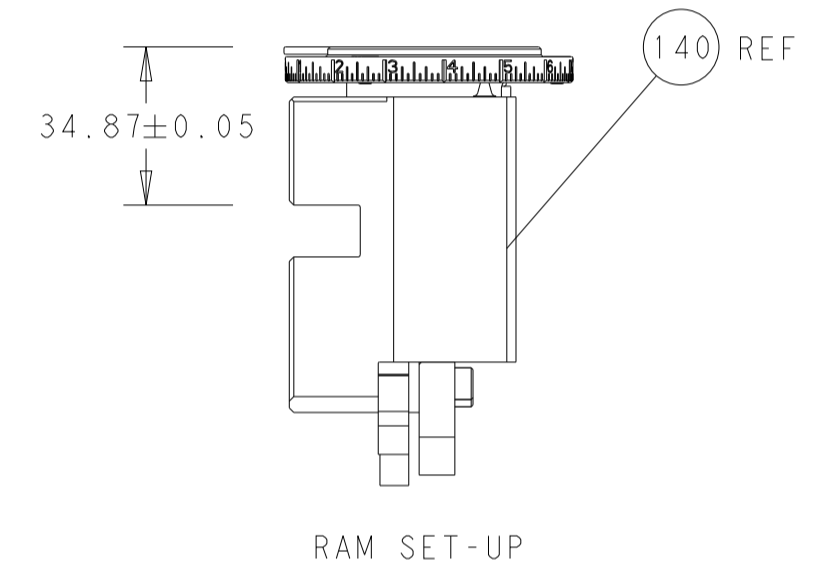
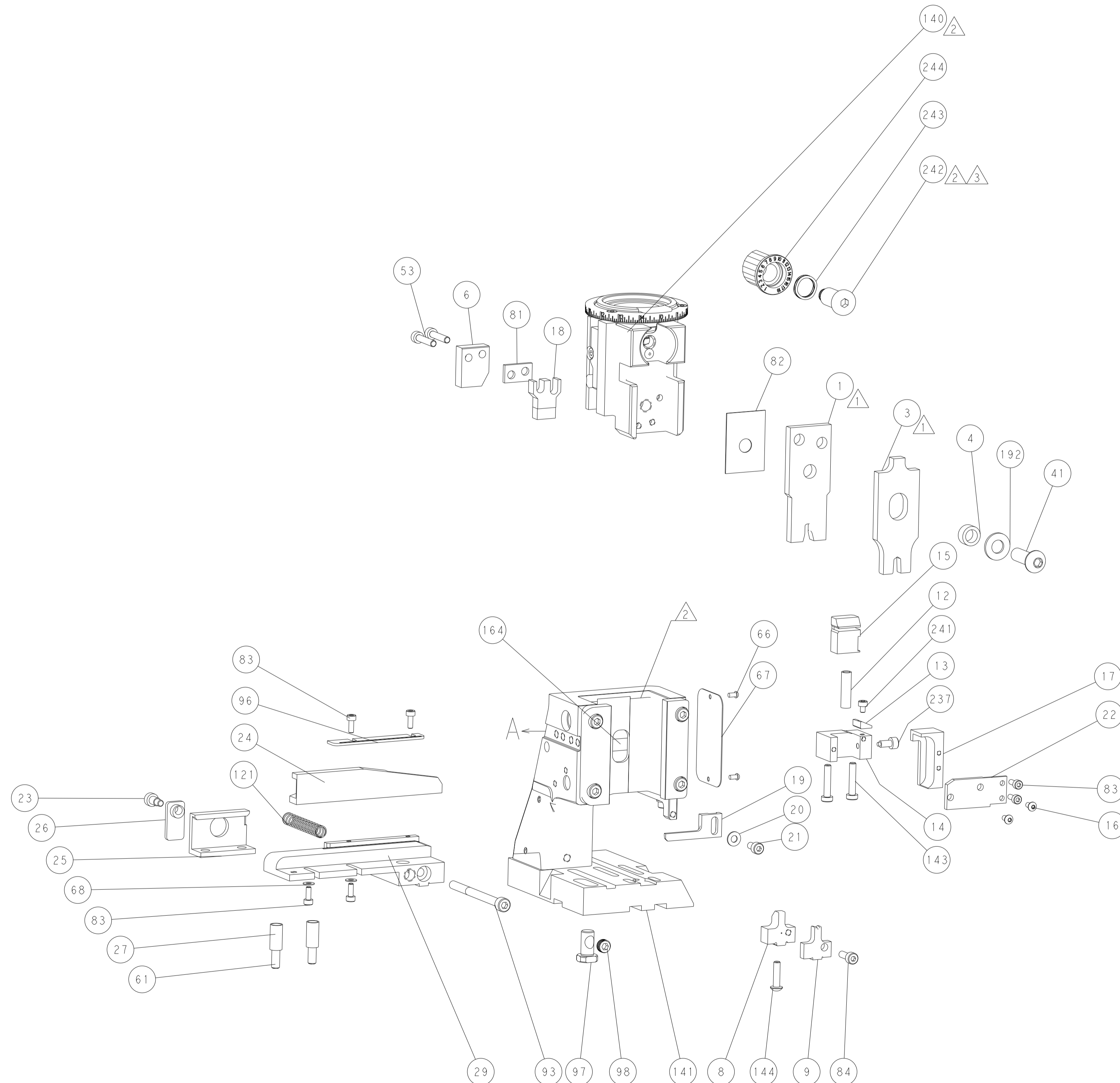


DETAIL A

CAM POSITION



AIR FEED



RAM SET-UP

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 2016. COPYRIGHT 2016 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.</small>		DWN: B. WEAVER 21JAN2016 CHK: T. ELBIN 21JAN2016 APVD: T. ELBIN 21JAN2016	NAME: Ocean Side Feed Applier SIZE: A1 CAGE CODE: 00779 DRAWING NO: C-2836174	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 ± FINISH ±	MATERIAL: - FINISH: -	WEIGHT: - CUSTOMER ACCESSIBLE PRODUCTION DRAWING	TE Connectivity Harrisburg, PA 17105-3608	SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION