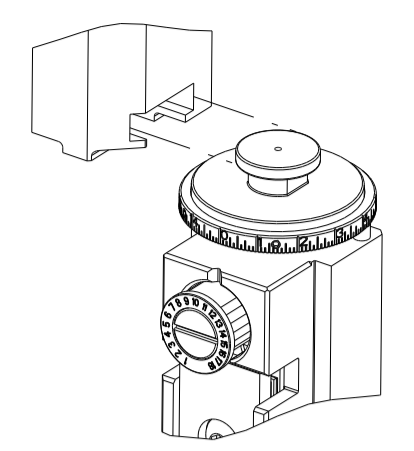


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2836255-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2836255-2	B	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2836255-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.80 mm [.110]	F
INSUL	4.50 mm [.177]	F

APPLICATOR INSTRUCTIONS 408-35042

TERMINAL DATA: JST TERMINAL		JST CRIMP SPECIFICATION	
TERMINAL NAME: RIGHT ANGLE RAST 5 - CRIMP TYPE TERMINAL			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
4.70-5.20 mm [.185-.205 IN]		3.00-3.90 mm [.118-.154 IN]	
TERMINAL APPLICATION SPECIFICATION	HM-H011 Rev 0		
TERMINALS APPLIED			
TE TERMINAL	JST TERMINAL	TE TERMINAL	JST TERMINAL
2113983-1	RASRSF-61T-250A		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
14 AWG OR 2.00mm ²	1.75+/-0.05 [.069+/- .002]	5.1
2 X 0.8mm ²	1.72+/-0.05 [.068+/- .002]	5.2
16 AWG OR 1.31mm ²	1.60+/-0.05 [.063+/- .002]	6.3
1 X 0.8mm ² + 1 X 0.5mm ²	1.57+/-0.05 [.062+/- .002]	6.5
2 X 0.5mm ²	1.55+/-0.05 [.061+/- .002]	6.8
18 AWG OR 0.80mm ²	1.50+/-0.05 [.059+/- .002]	7.3

***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.

- 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.

SET UP GAUGE		LOC	DIST	REVISIONS			
2119599-1		A	66	REV	DATE	BY	CHK
				A	RELEASED	17JUN2016	BW
				B	ECR-23-184126	14AUG2023	TB

-	1	1	1803078-1	SPACER, PRECISION	259	
-	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	2844940-2	AIR FEED MODULE	238	
-	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	99	
-	1	1	2844907-1	POST, LOCKING	98	
-	1	1	980371-4	SCR, SKT HD SHLDR 5.0 DIA X 6.0	94	
-	1	1	2168083-6	SCR, SKT HD CAP, RoHS, M5 X 65	93	
-	1	1	455888-5	SPACER, CRIMPER	82	
-	1	1	1803607-3	DOCUMENTATION PACKAGE	71	
-	1	1	1-2119791-6	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	
-	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	1-1338683-3	FEED PAWL	56	
-	1	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49	
-	1	1	1803583-9	APPLICATOR BASIC ASSEMBLY, SF	46	
-	1	1	1803515-2	RAM ASSEMBLY, SF ATLANTIC	44	
-	1	1	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	43	
-	1	1	1803602-2	SCR, BHSC, RoHS (M8 X 40)	41	
-	1	1	1803378-1	TERMINAL SUPPORT	34	
-	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	33	
-	2	2	1-2168083-3	SCR, SKT HD CAP, RoHS, M3 X 16	32	
-	1	1	2-2305692-0	PLATE, REAR STRIP GUIDE	29	
-	1	1	455888-4	SPACER, CRIMPER	28	
-	2	2	22283-1	SPRING, COMPRESSION	27	
-	1	1	356835-1	LEVER, DRAG RELEASE	26	
-	1	1	1803377-1	DRAG, SPECIAL	25	
-	1	1	4-189124-0	GUIDE, FRONT STRIP	24	
-	1	1	3-690712-8	FRONT STRIP GUIDE	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	2119533-3	STRIPPER, SIDE FEED	19	
-	1	1	2063687-6	PLATE, REAR SHEAR	15	
-	-	-	-	-	10	
-	-	-	-	-	9	
-	-	-	-	-	7	
-	1	1	1-455888-4	SPACER, CRIMPER	6	
-	1	1	1633338-4	BLADE, SLUG	5	
-	1	1	238011-2	BLOCK, CRIMPER SPACER	4	
-	1	2	1	9-1803016-9	CRIMPER, INSULATION F	3
-	1	2	1	7-456408-1	CRIMPER, WIRE PREMIUM	1

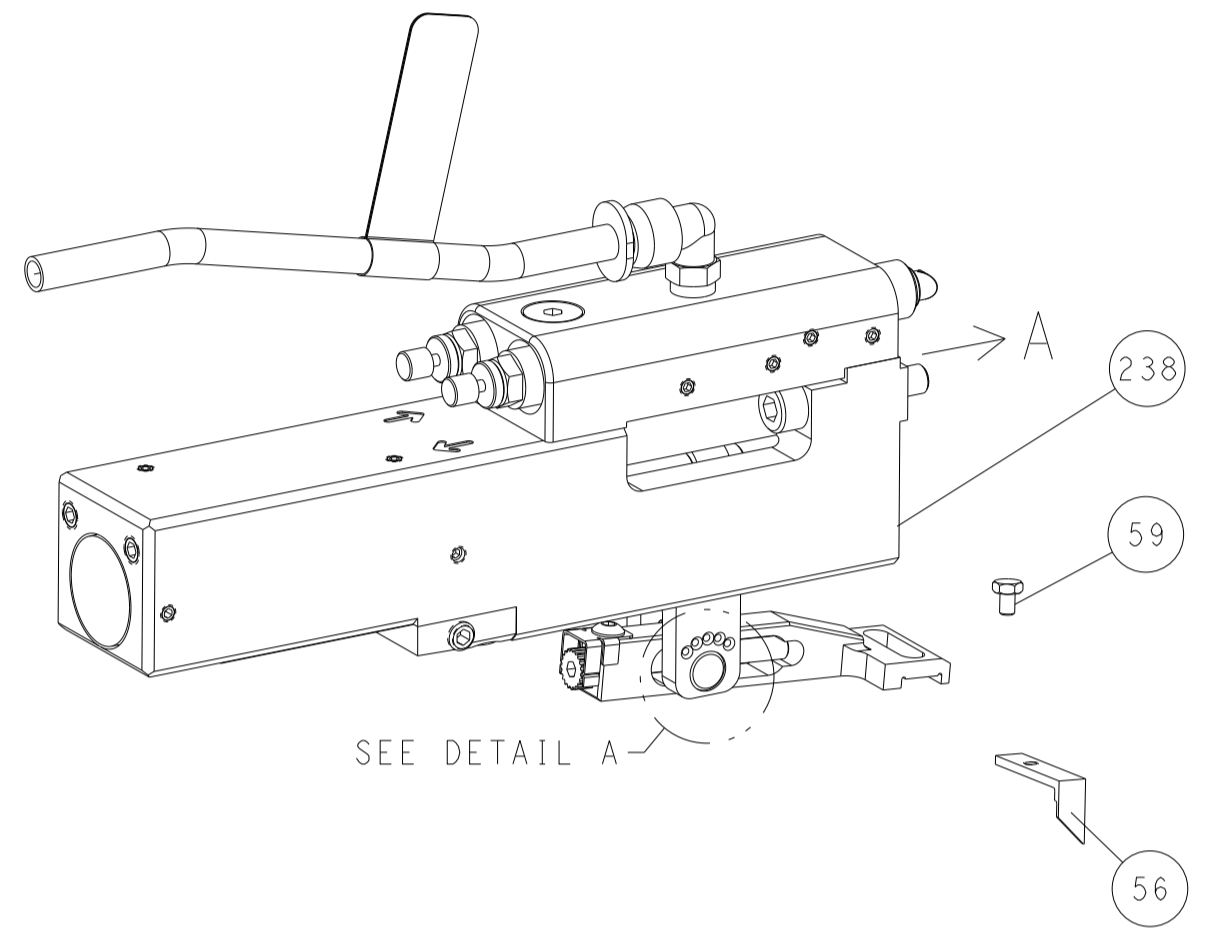
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		MATERIAL:		FINISH:		WEIGHT:		SCALE:		SHEET:		REV:	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES	FINISH			A	00779	1	4	B	

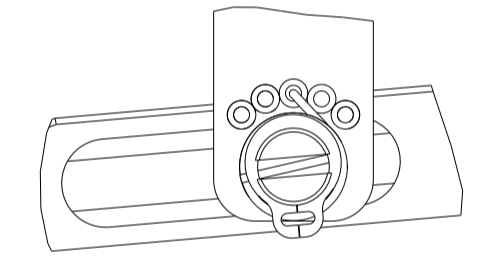
LOC	DIST	REVISIONS			
P	LTN	DESCRIPTION	DATE	OWN	APVD
A	66	SEE SHEET 1	-	-	-

FEED TYPE

PNEUMATIC

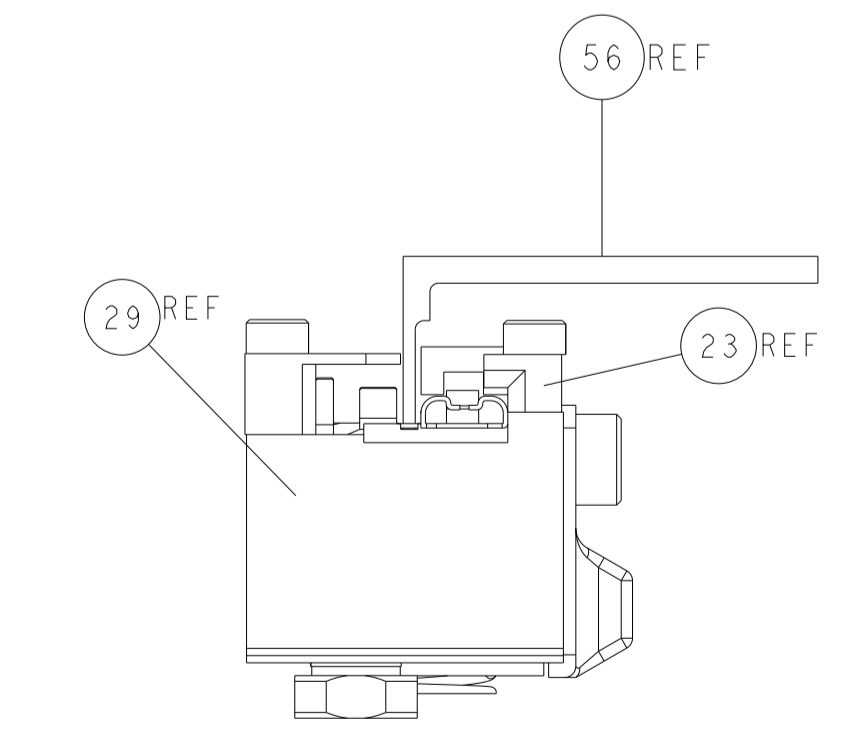
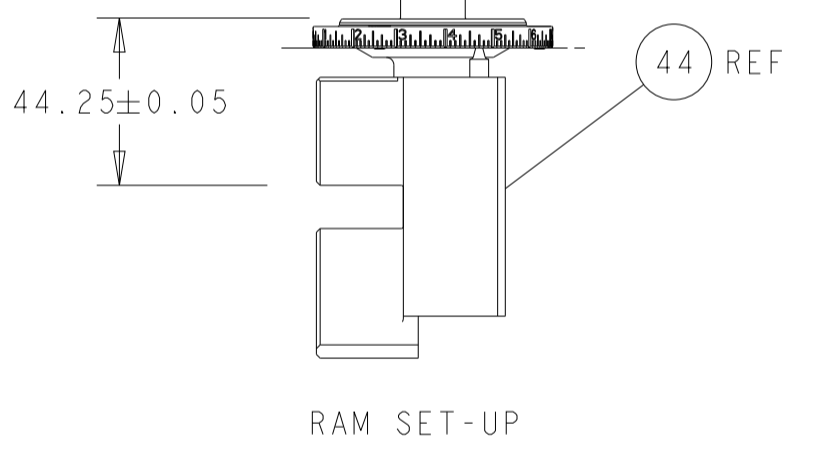
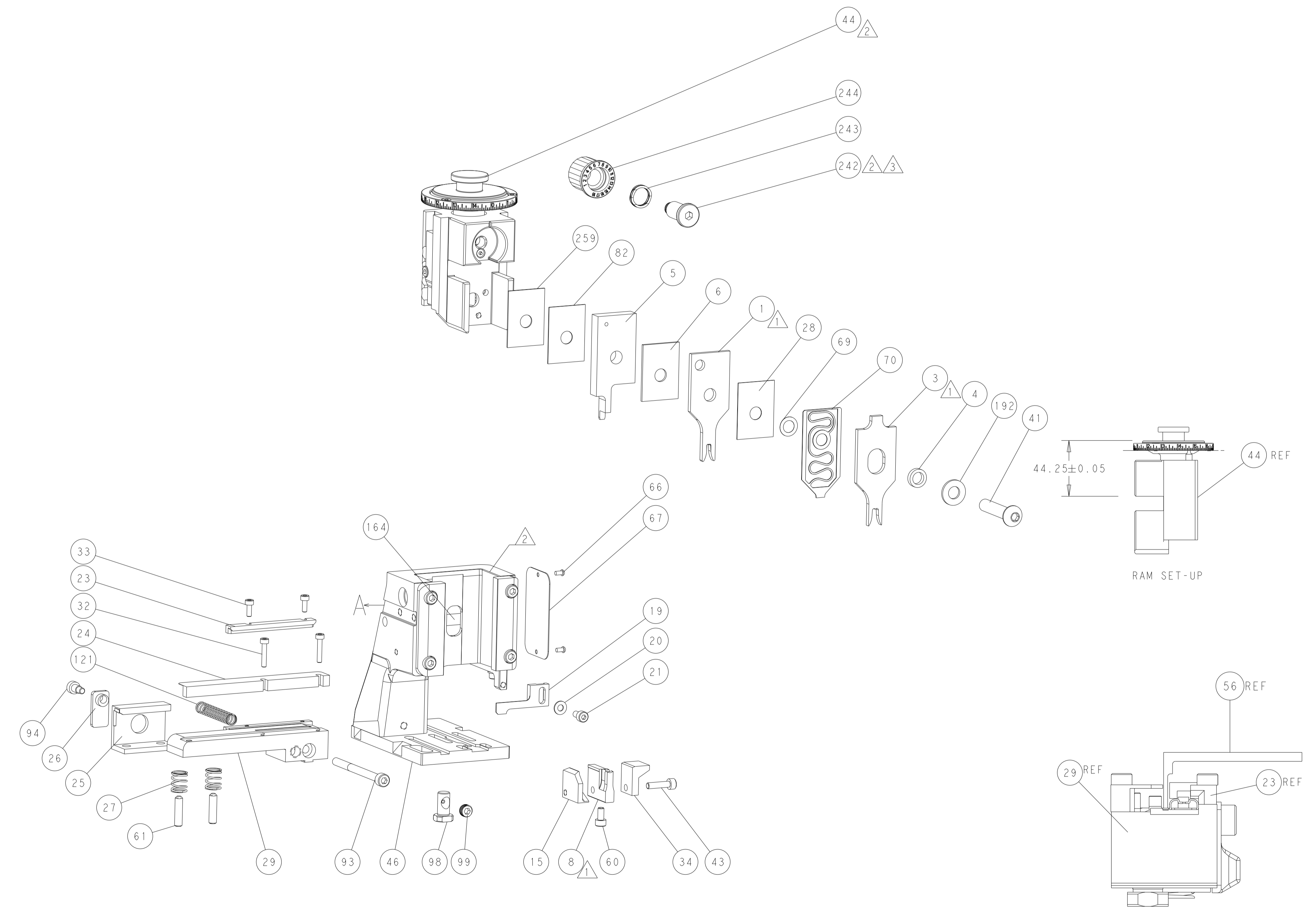
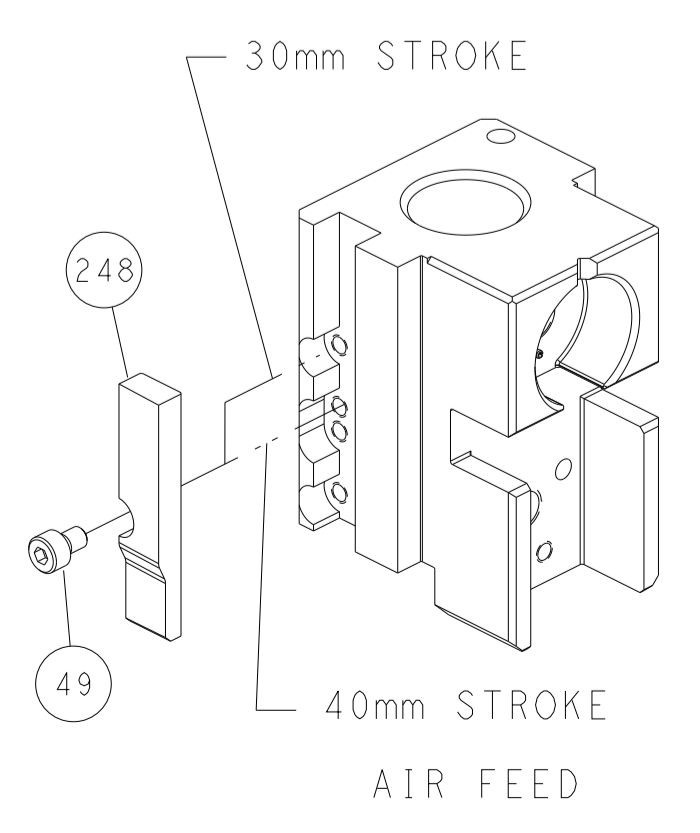


FEED SPRING SETTING POSITION
(SHOWN FROM REAR SIDE)



DETAIL A

CAM POSITION

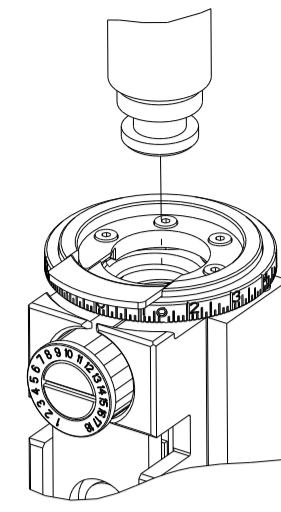


ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

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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 CAGE CODE DRAWING NO. A1 00779 C-2836255 WEIGHT SCALE 1:2 SHEET 2 OF 4 REV B	RESTRICTED TO
MATERIAL:		Customer Accessible Production Drawing	SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2836255-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2836255-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.80 mm [.110]	F
INSUL	4.50 mm [.177]	F
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: JST TERMINAL		JST CRIMP SPECIFICATION	
TERMINAL NAME: RIGHT ANGLE RAST 5 - CRIMP TYPE TERMINAL			
WIRE STRIP LENGTH 4.70-5.20 mm [1.85-.205 IN]		INSULATION DIAMETER RANGE 3.00-3.90 mm [1.18-.154 IN]	
TERMINAL APPLICATION SPECIFICATION	HM-H011 Rev O	-	-
TERMINALS APPLIED			
TE TERMINAL	JST TERMINAL	TE TERMINAL	JST TERMINAL
2113983-1	RASRSF-61T-250A		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
14 AWG OR 2.00mm ²	1.75+/-0.05 [.069+/- .002]	5.1
2 X 0.8mm ²	1.72+/-0.05 [.068+/- .002]	5.2
16 AWG OR 1.31mm ²	1.60+/-0.05 [.063+/- .002]	6.3
1 X 0.8mm ² + 1 X 0.5mm ²	1.57+/-0.05 [.062+/- .002]	6.5
2 X 0.5mm ²	1.55+/-0.05 [.061+/- .002]	6.8
18 AWG OR 0.80mm ²	1.50+/-0.05 [.059+/- .002]	7.3



- 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.

***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.

SET UP GAUGE 2119599-1	LOC A	DIST 66	REVISIONS			
REV	DATE	BY	DESCRIPTION	DATE	BY	
-	-	-	SEE SHEET 1	-	-	

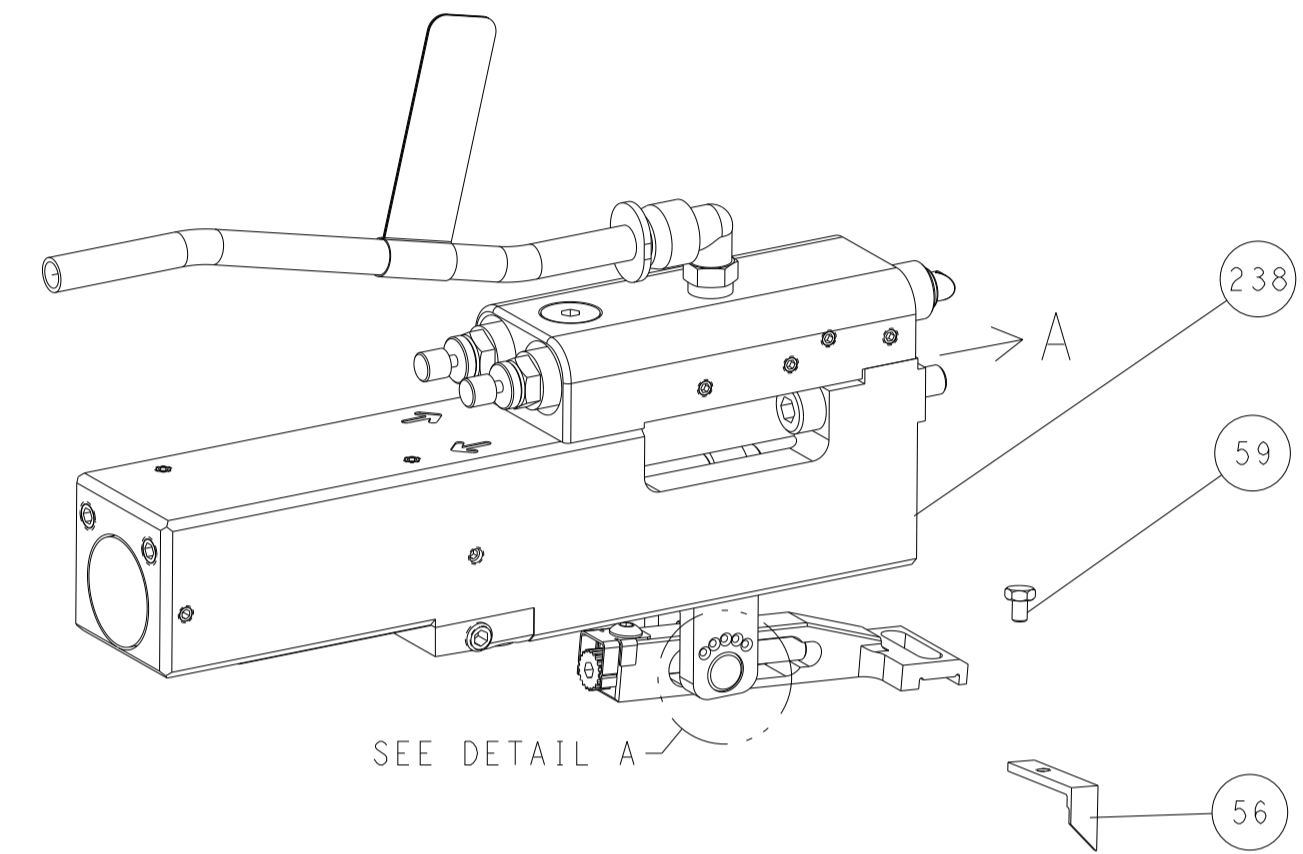
-	1	1803078-1	SPACER, PRECISION	259	
-	1	2119082-4	CAM, SNAIL, INSULATION ADJUSTMENT	244	
-	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243	
3	-	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	2844940-2	AIR FEED MODULE	238	
-	1	1-18028-0	WASHER, FLAT, REG M8	192	
-	REF	994970-2	COUNTER, MAGNETIC	164	
-	1	2119641-2	FEED CAM, AIR FEED	151	
-	1	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	144	
-	1	1-1803583-0	APPLICATOR BASIC ASSEMBLY, SF	141	
-	1	1803516-2	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	980371-4	SCR, SKT HD SHLDR 5.0 DIA X 6.0	94	
-	1	2168083-6	SCR, SKT HD CAP, RoHS, M5 X 65	93	
-	1	455888-5	SPACER, CRIMPER	82	
-	1	1803607-3	DOCUMENTATION PACKAGE	71	
-	1	1-2119791-6	DEPRESSOR, WIRE	70	
-	1	2119943-1	WASHER, SPACER	69	
-	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	1-1338683-3	FEED PAWL	56	
-	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49	
-	1	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	43	
-	1	1803602-2	SCR, BHSC, RoHS (M8 X 40)	41	
-	1	1803378-1	TERMINAL SUPPORT	34	
-	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	33	
-	2	1-2168083-3	SCR, SKT HD CAP, RoHS, M3 X 16	32	
-	1	2-2305692-0	PLATE, REAR STRIP GUIDE	29	
-	1	455888-4	SPACER, CRIMPER	28	
-	2	22283-1	SPRING, COMPRESSION	27	
-	1	356835-1	LEVER, DRAG RELEASE	26	
-	1	1803377-1	DRAG, SPECIAL	25	
-	1	4-189124-0	GUIDE, FRONT STRIP	24	
-	1	3-690712-8	FRONT STRIP GUIDE	23	
-	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21	
-	1	1-18028-2	WASHER, FLAT, REG M4	20	
-	1	2119533-3	STRIPPER, SIDE FEED	19	
1	-	1	2063687-6	PLATE, REAR SHEAR	15
-	-	-	-	10	
-	-	-	-	9	
1	1	1	1633758-4	ANVIL, SPECIAL, COMBINATION	8
-	-	-	-	7	
-	1	1-455888-4	SPACER, CRIMPER	6	
1	-	1	1633338-4	BLADE, SLUG	5
-	1	238011-2	BLOCK, CRIMPER SPACER	4	
1	1	1	9-1803016-9	CRIMPER, INSULATION F	3
1	1	1	7-456408-1	CRIMPER, WIRE PREMIUM	1
-	77	-22	PART NO	DESCRIPTION	ITEM NO

PACIFIC VERSION
Shown on sheets 3 of 4 & 4 of 4
(Atlantic version shown on sheets 1 of 4 & 2 of 4)

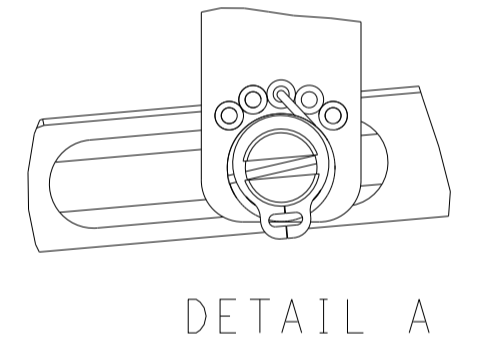
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mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	APVD: G. BAILEY 28MAR2016	NAME: Ocean Side Feed Applicator
MATERIAL:		FINISH:		WEIGHT:		SIZE: A1 00779 C=2836255	
Customer Accessible Production Drawing				SCALE: 1:2		SHEET 3 OF 4 REV B	

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

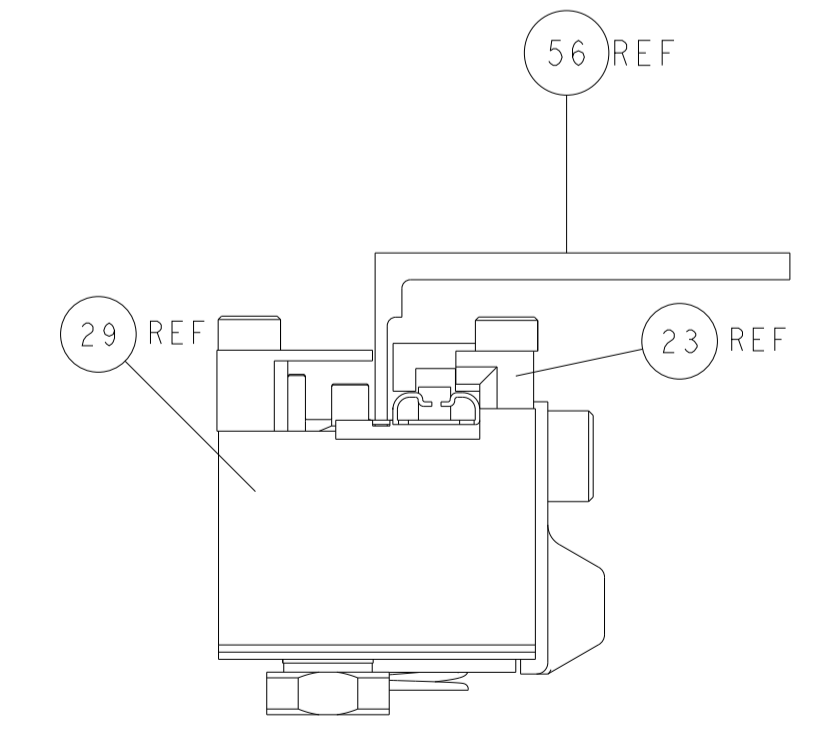
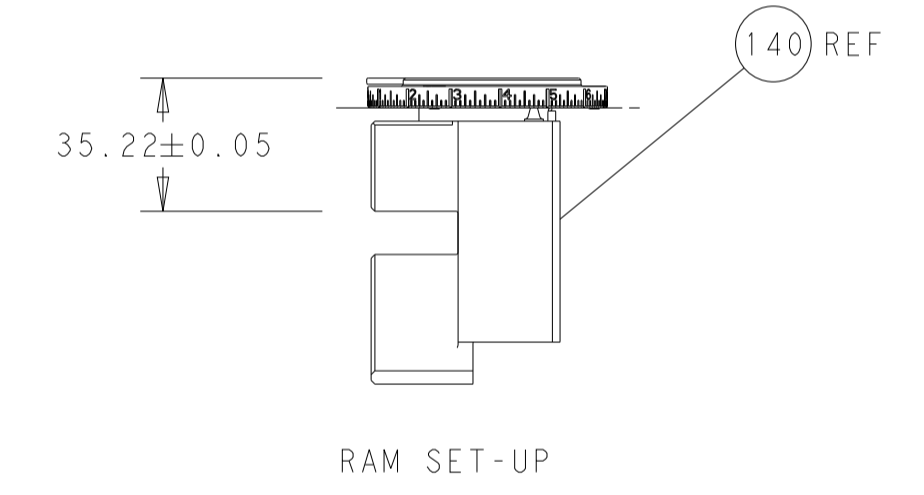
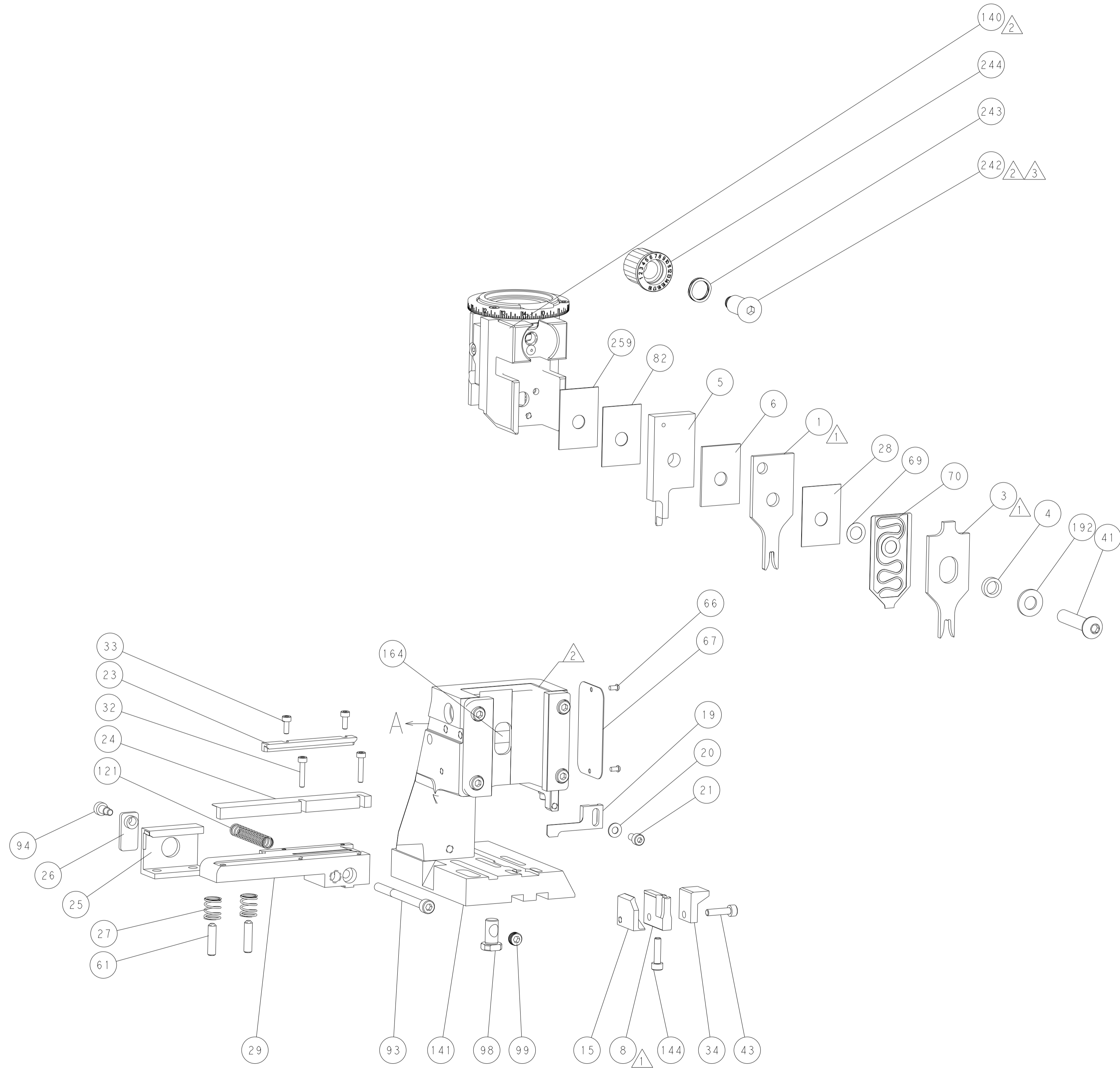
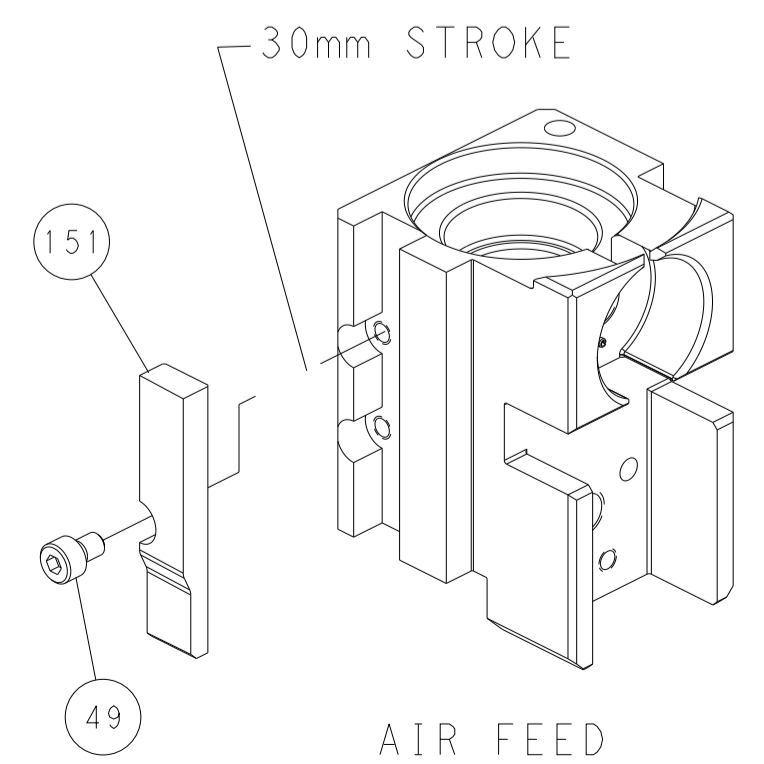
FEED TYPE PNEUMATIC



FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



CAM POSITION



FEED TRACK AND FEED FINGER POSITION GUIDE BY TERMINAL BODY

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 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH ±	TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH ±	WEIGHT -	SCALE 1:2	SHEET 4 OF 4	REV B