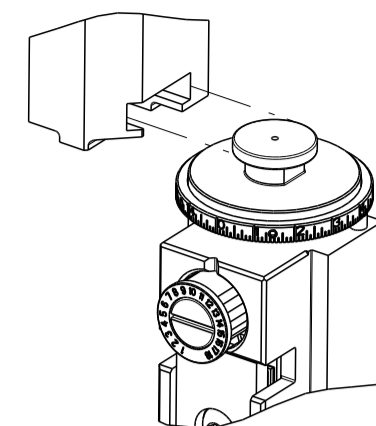


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2836317-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2836317-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
5-2836317-1	C	SEAL STRIPPER CRIMPER TERMINATING UNIT	MECHANICAL
5-2836317-2	C	SEAL STRIPPER CRIMPER TERMINATING UNIT	PNEUMATIC
7-2836317-1	C	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2836317-2	C	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2836317-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER

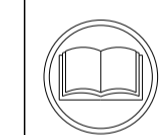


APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.70 mm [.067]	F
INSUL	2.29 mm [.090]	F

APPLICATOR INSTRUCTIONS 408-35042

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: AUTOMOTIVE SOCKET CONTACT (IMM SYSTEM)			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
3.95-4.45 mm [.156-.175 IN]		Ø1.60-1.90 mm [.063-.075 IN]	
TERMINAL APPLICATION SPECIFICATION	114-3118		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
1437284-9			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
20 AWG	1.00 +/- 0.05 [.039 +/- .002]	8.6



- 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 LUBRICANT IS RECOMMENDED.
- 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.

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

LOC	DIST	REVISIONS					
A	66	P	LTN	DESCRIPTION	DATE	OWN	APVD
		A		RELEASED	17JUN2016	CT	GB
		B		ECR-20-014376	10OCT2020	FJ	TE
		C		ECR-22-161265	14DEC2022	TB	TE

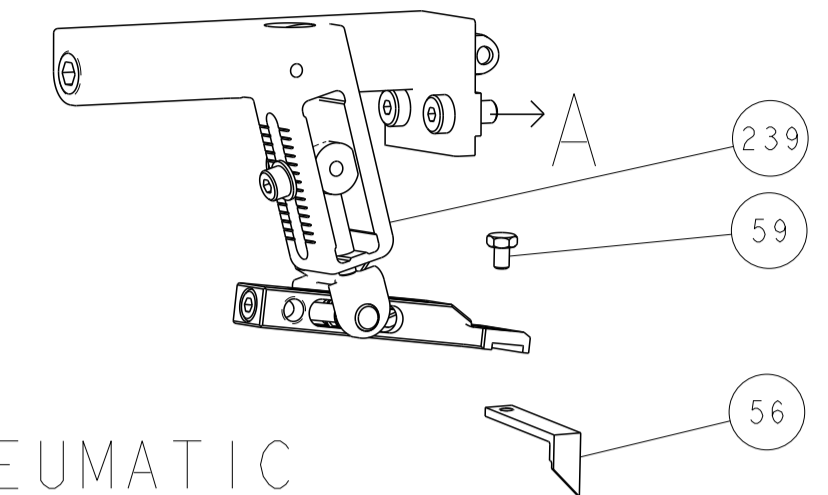
-	1	1	1	1	1	1803945-4	TONKER	300
-	1	1	1	1	1	4-22278-3	SPRING, COMPRESSION	299
-	2	2	2	2	2	4-18032-3	SCR, SET, FLT PNT, M3 X 6.0	298
-	1	1	1	1	1	1803944-1	SPACER, TONKER	297
-	-	-	1	1	-	2-1803583-1	APPLICATOR BASIC ASSEMBLY, SF	292
-	1	-	1	-	1	2119641-1	FEED CAM, AIR FEED	248
-	1	1	1	1	1	2119082-8	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	1	1	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
-	-	1	-	1	-	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	1	-	1	-	1	2844940-1	AIR FEED MODULE	238
-	REF	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	1	1	1	1	1	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113
-	1	1	1	1	1	2844908-1	SCREW, LOCKING	99
-	1	1	1	1	1	2844907-1	POST, LOCKING	98
-	1	1	1	1	1	455888-7	SPACER, CRIMPER	82
-	1	1	1	1	1	1803607-3	DOCUMENTATION PACKAGE	71
-	1	1	1	1	1	2119791-5	DEPRESSOR, WIRE	70
-	1	1	1	1	1	2119740-1	TAG, IDENTIFICATION	67
-	2	2	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	1	1	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	60
-	1	1	1	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	1	1	1	1	1	1338683-8	FEED PAWL	56
-	4	4	4	4	4	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	54
-	2	2	2	2	2	2-2168083-6	SCR, SKT HD CAP, RoHS, M4 X 18	53
-	1	2	1	2	1	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	1803583-9	APPLICATOR BASIC ASSEMBLY, SF	46
-	1	1	1	1	1	1803515-1	RAM ASSEMBLY, SF ATLANTIC	44
-	1	1	1	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
-	1	1	1	1	1	1752356-3	SUPPORT, TERMINAL	34
-	2	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	2	2	2	2-2844962-8	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	1	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29
-	1	1	1	1	1	455888-5	SPACER, CRIMPER	28
-	1	1	1	1	1	1320928-2	STRIP GUIDE	24
-	1	1	-	-	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
-	2	2	1	1	2	1-18028-2	WASHER, FLAT, REG M4	20
-	1	1	-	-	1	2119533-1	STRIPPER, SIDE FEED	19
-	1	1	1	1	1	2119806-1	INSERT, SHEAR	13
-	1	1	1	1	1	3-22280-3	SPRING, COMPRESSION	12
-	1	1	1	1	1	1-356885-4	STOP, SHEAR	11
-	1	1	1	1	1	2119805-1	SHEAR HOLDER, FRONT	10
-	1	1	1	1	1	1803095-6	FLOATING SHEAR, FRONT	9
-	1	2	2	1	1	9-1803171-7	ANVIL, COMBINATION	8
-	1	1	1	1	1	3-240641-5	SPACER	7
-	-	-	-	-	-	-	-	6
-	1	1	1	1	1	2119757-4	DEPRESSOR, SHEAR	5
-	1	1	1	1	1	2-238011-5	BLOCK, CRIMPER SPACER	4
-	1	2	2	1	1	9-2119582-9	CRIMPER, INSULATION F PREMIUM	3
-	-	-	-	-	-	-	-	2
-	1	2	2	1	1	2-1633664-6	CRIMPER, WIRE	1

ITEM NO	PART NO	DESCRIPTION	ITEM NO
-77	-72	-71	-52
-51	-2	-1	

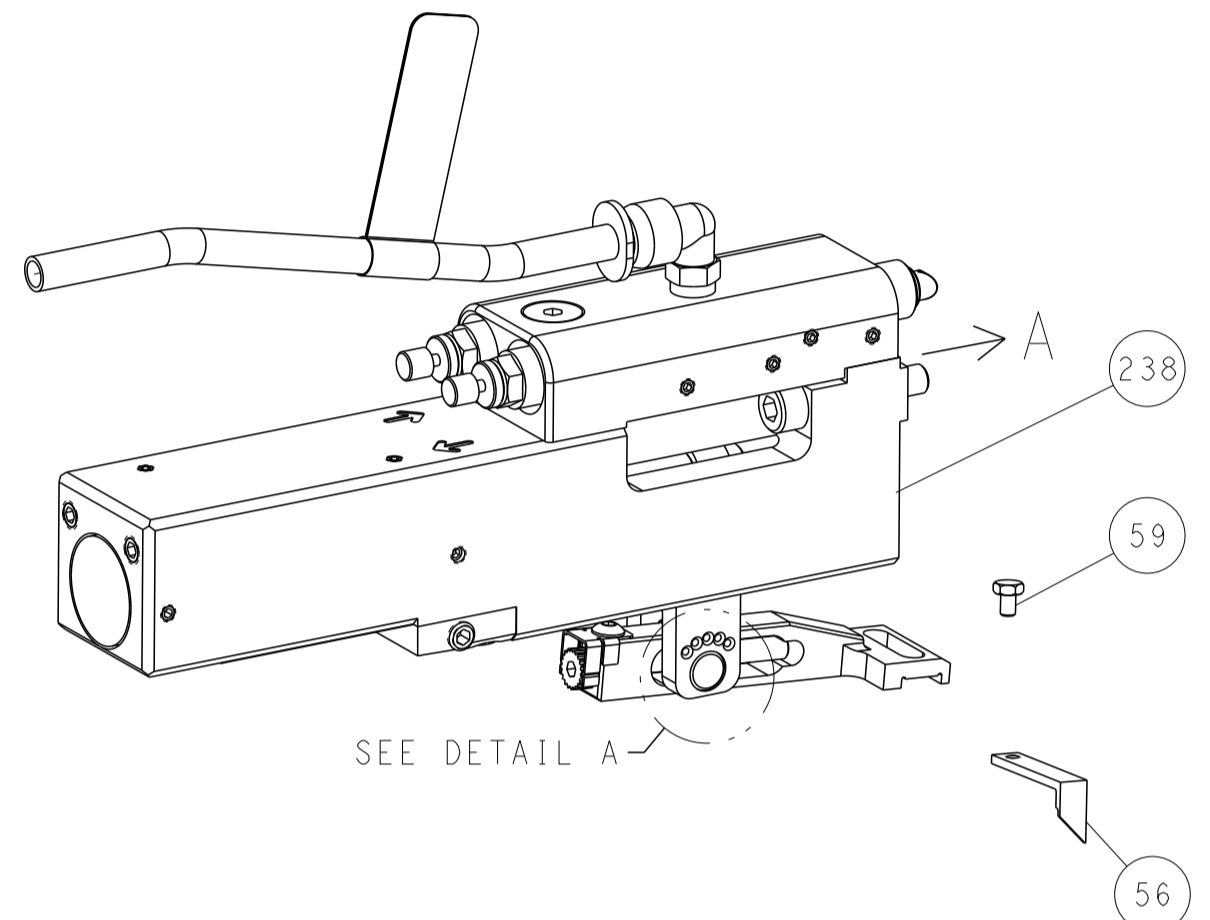
DIMENSIONS: mm 	TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH	DWN: M. ZHAO 20MAY2016 CHK: K. ZHANG 20MAY2016 APVD: K. ZHANG 20MAY2016 PRODUCT SPEC APPLICATION SPEC MATERIAL: - FINISH: - WEIGHT: - SCALE: 1:2 SHEET 1 OF 4 REV C	TE Connectivity Harrisburg, PA 17105-3608 NAME: Ocean Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2836317 RESTRICTED TO: - Customer Accessible Production Drawing
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LOC	DIST	REVISIONS					
A	66	P	LYN	DESCRIPTION	DATE	OWN	APVD
		-		SEE SHEET 1			

FEED TYPE MECHANICAL



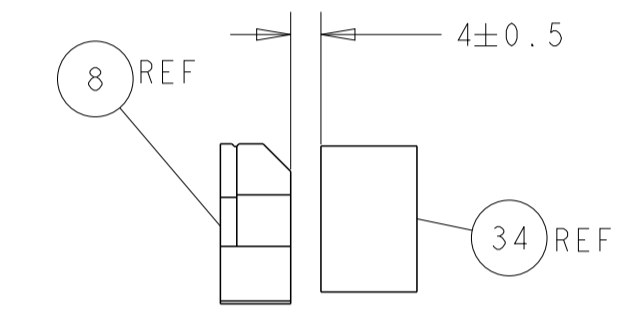
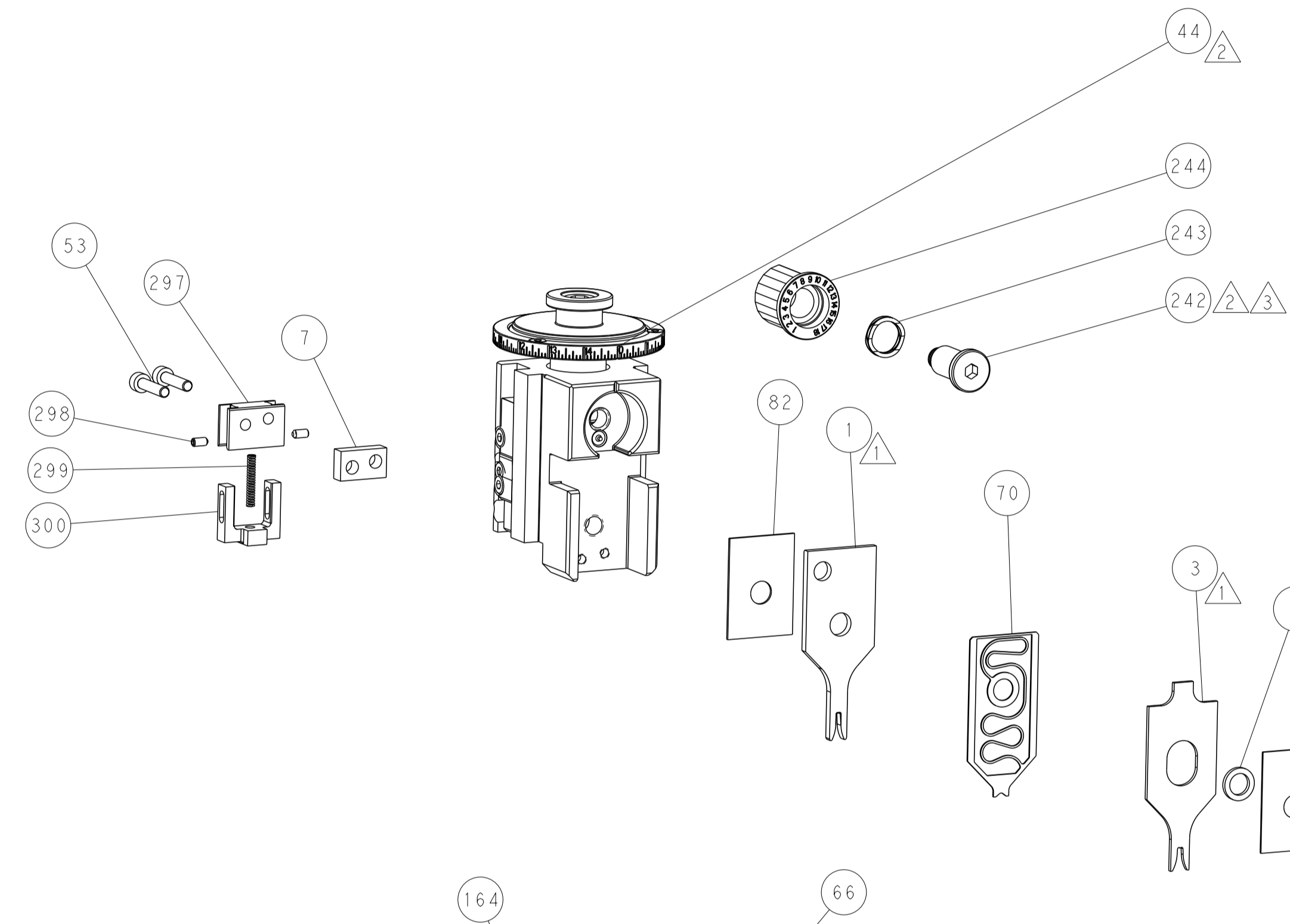
PNEUMATIC



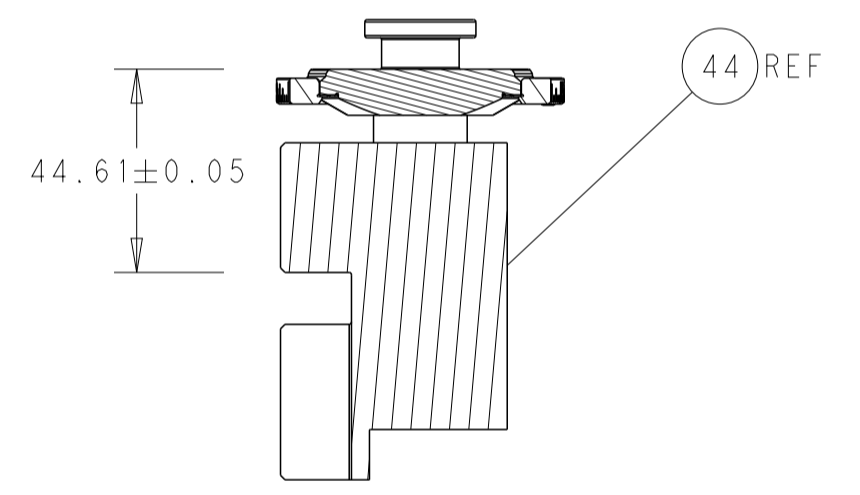
FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



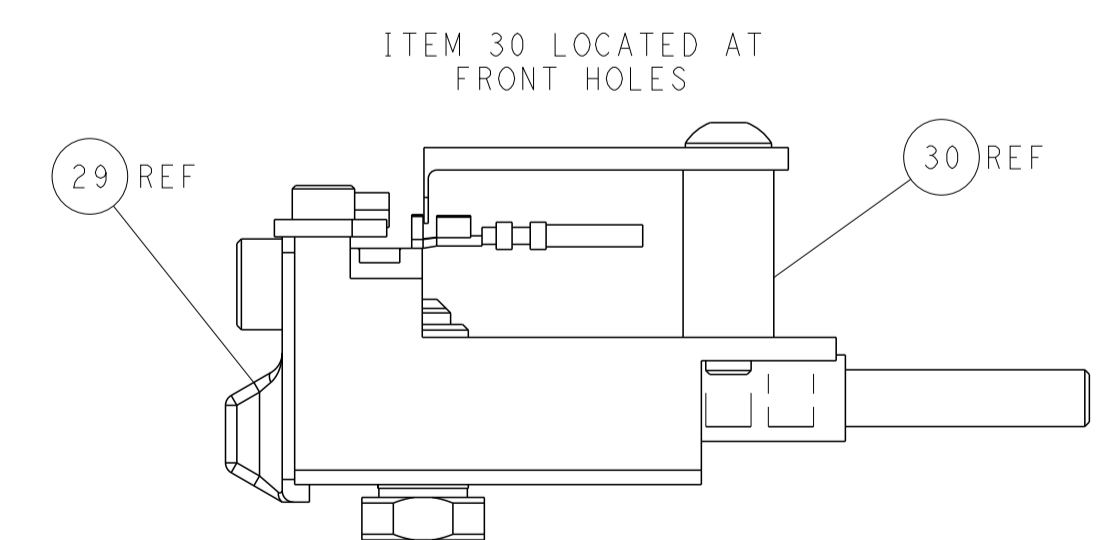
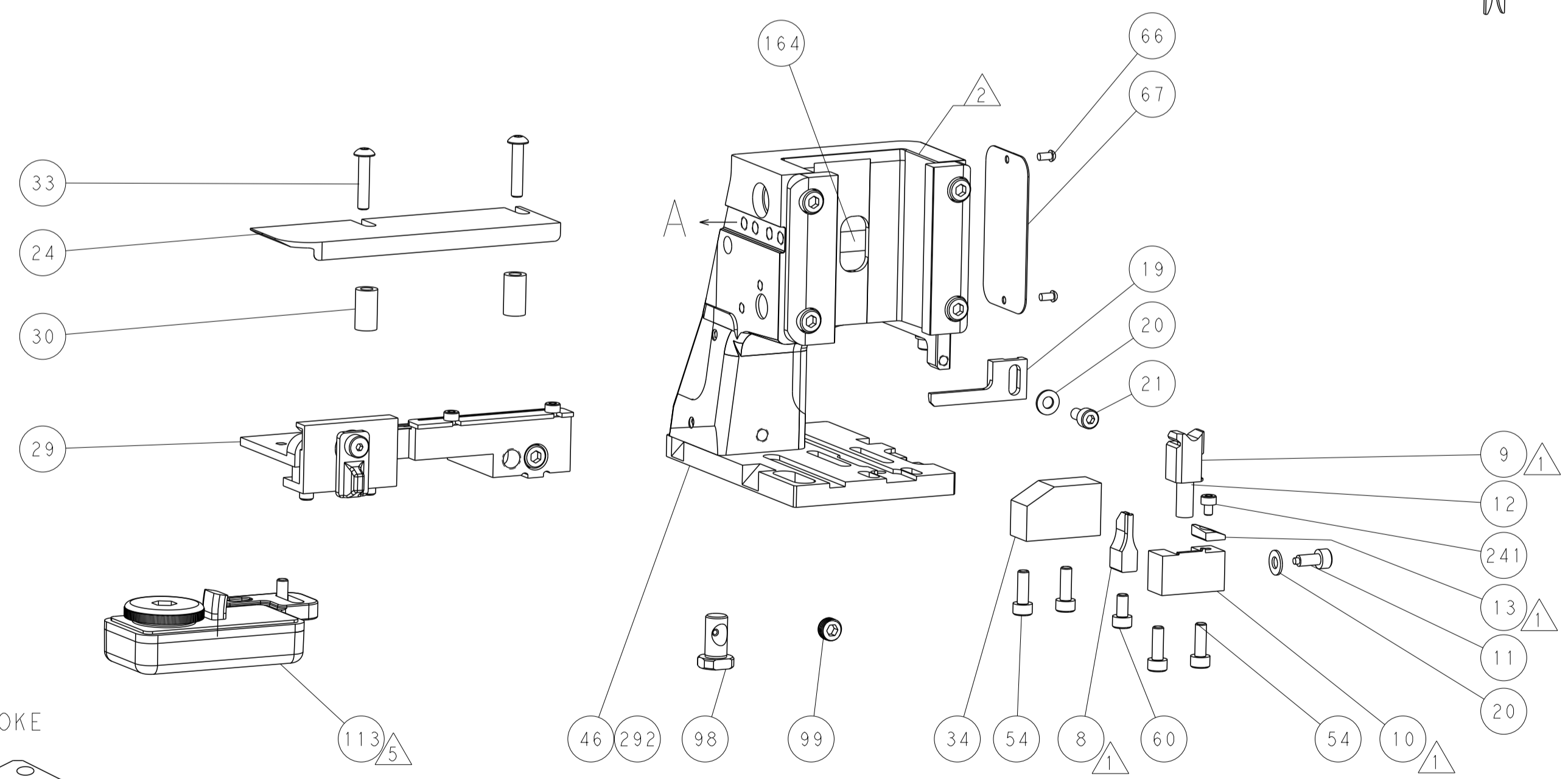
DETAIL A



TERMINAL SUPPORT LOCATION

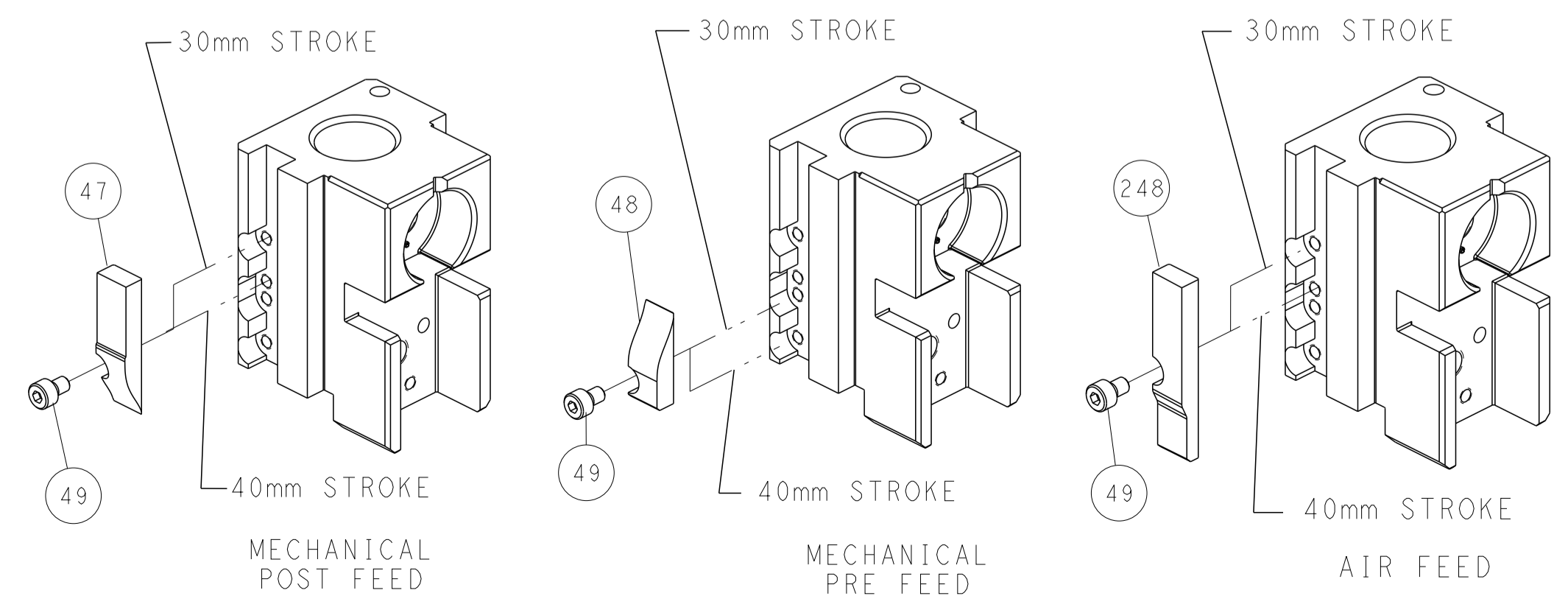


RAM SET-UP



FEED TRACK POSITION GUIDE BY INSULATION BARREL

CAM POSITIONS

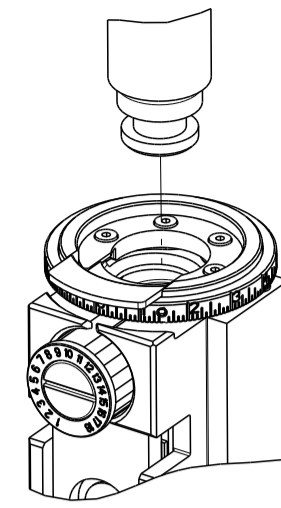


ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH ±		DWN M. ZHAO 20MAY2016 CHK K. ZHANG 20MAY2016 APVD K. ZHANG 20MAY2016 PRODUCT SPEC APPLICATION SPEC WEIGHT MATERIAL		NAME Ocean Side Feed Applicator SIZE CAGE CODE DRAWING NO. A1 00779 C=2836317 RESTRICTED TO	
Customer Accessible Production Drawing				SCALE 1:2	SHEET 2 OF 4	REV C	

THIS DRAWING IS UNPUBLISHED.	RELEASED FOR PUBLICATION		
COPYRIGHT 20 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.			
PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2836317-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2836317-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2836317-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.70 mm [.067]	F
INSUL	2.29 mm [.090]	F
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: AUTOMOTIVE SOCKET CONTACT(1MM SYSTEM)			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
3.95-4.45 mm [.156-.175 IN]		∅1.60-1.90 mm [.063-.075 IN]	
TERMINAL APPLICATION SPECIFICATION	114-3118	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
1437284-9			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
20 AWG	1.00 +/- 0.05 [.039 +/- .002]	8.6

- 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 LUBRICANT IS RECOMMENDED.
- 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.

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

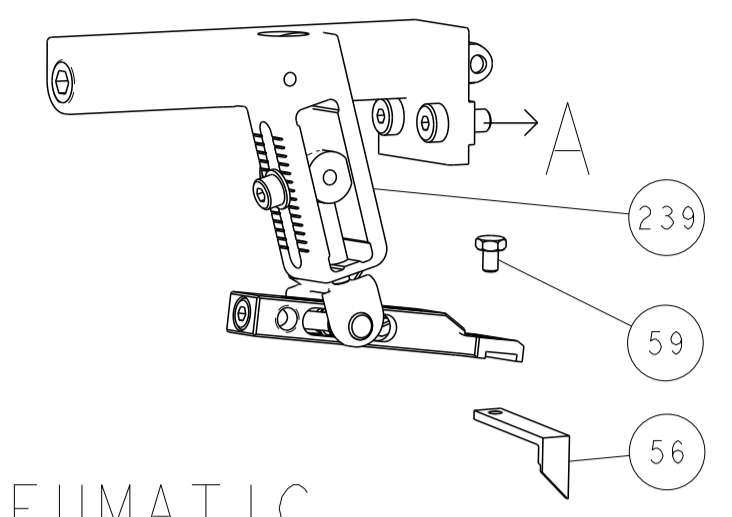
LOC	DIST	REV	DATE	BY	CHK	APPV
A	66	-	-	-	-	-

REV	DATE	BY	CHK	APPV	DESCRIPTION	ITEM NO
-	1	1			1803945-4 TONKER	300
-	1	1			4-22278-3 SPRING, COMPRESSION	299
-	2	2			4-18032-3 SCR, SET, FLT PNT, M3 X 6.0	298
-	1	1			1803944-1 SPACER, TONKER	297
-	1	1			2119082-8 CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1			2079764-1 WASHER, WAVE SPRING, CREST-TO-CREST	243
3	-	1			2119083-1 RETAINER, INSULATION DIAL	242
-	1	1			7-18023-7 SCR, SKT HD CAP M3 X 4.0	241
-	-	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
-	4	4			2168083-9 SCR, SKT HD CAP, RoHS, M4 X 20	143
-	-	1			2119653-2 FEED CAM, POST FEED	142
-	1	1			1-1803583-0 APPLICATOR BASIC ASSEMBLY, SF	141
5	-	1			1803516-1 RAM ASSEMBLY, SF PACIFIC	140
-	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			455888-7 SPACER, CRIMPER	82
-	1	1			1803607-3 DOCUMENTATION PACKAGE	71
-	1	1			2119791-5 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			1338683-8 FEED PAWL	56
-	2	2			2-2168083-6 SCR, SKT HD CAP, RoHS, M4 X 18	53
-	1	2			18023-9 SCR, SKT HD CAP M4 X 6.0	49
-	-	1			2119652-1 FEED CAM, PRE FEED	48
-	1	1			1803602-1 SCR, BHSC, RoHS (M8 X 25)	41
-	1	1			1752356-3 SUPPORT, TERMINAL	34
-	2	2			2079383-5 SCR, BHSC, RoHS (M4 X 20)	33
-	2	2			2-2844962-8 SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1			2844992-1 ASSEMBLY, STRIP GUIDE	29
-	1	1			455888-5 SPACER, CRIMPER	28
-	1	1			1320928-2 STRIP GUIDE	24
-	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			1-356885-4 STOP, SHEAR	11
1	-	1			2119805-1 SHEAR HOLDER, FRONT	10
1	-	1			1803095-6 FLOATING SHEAR, FRONT	9
1	1	1			9-1803171-7 ANVIL, COMBINATION	8
-	1	1			3-240641-5 SPACER	7
-	-	-			-	6
-	1	1			2119757-4 DEPRESSOR, SHEAR	5
-	1	1			2-238011-5 BLOCK, CRIMPER SPACER	4
1	1	1			9-2119582-9 CRIMPER, INSULATION F PREMIUM	3
-	-	-			-	2
1	1	1			2-1633664-6 CRIMPER, WIRE	1

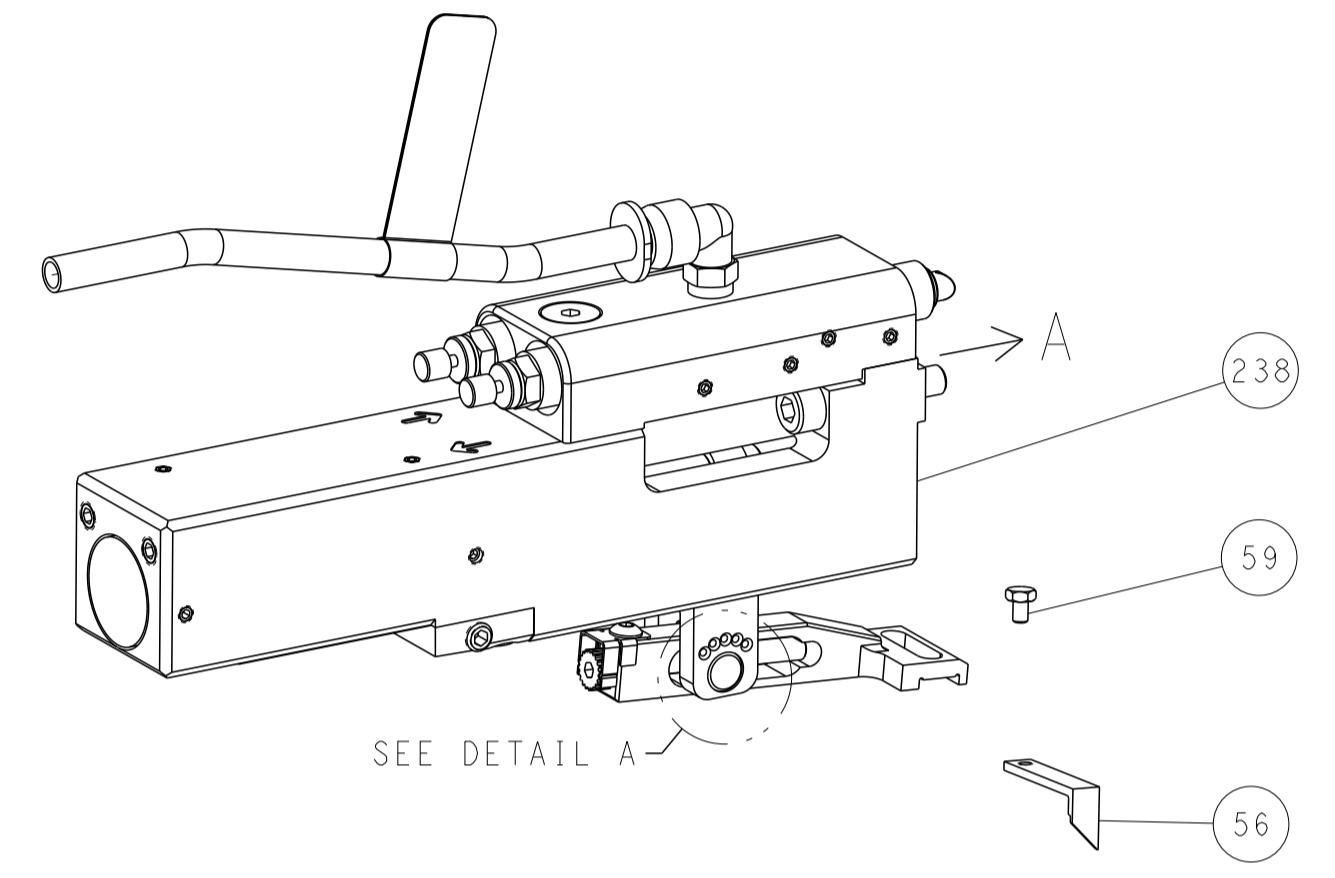
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DRAWING NO		RESTRICTED TO	
0 PLC	±	0 PLC	±	00779	2836317	3	4
1 PLC	±	1 PLC	±	Customer Accessible Production Drawing			
2 PLC	±	2 PLC	±	SCALE 1:2 SHEET 3 OF 4 REV C			
3 PLC	±	3 PLC	±	SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION			
4 PLC	±	4 PLC	±				
ANGLES	±	ANGLES	±				
FINISH	±	FINISH	±				

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

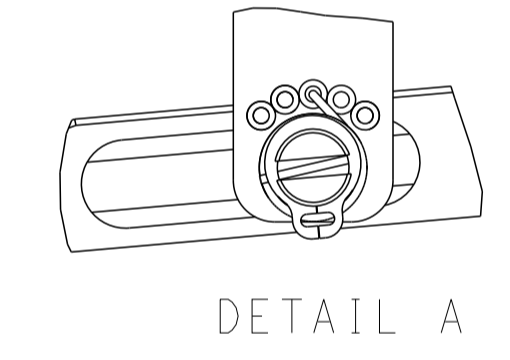
FEED TYPE MECHANICAL



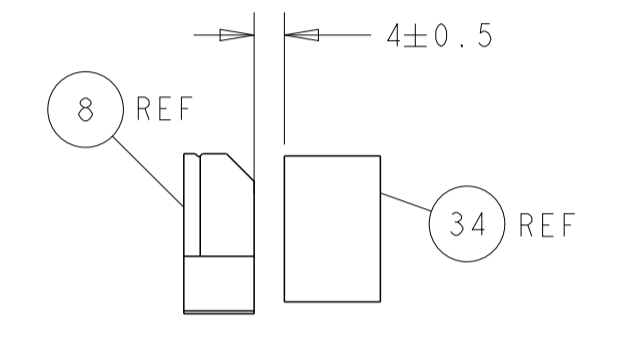
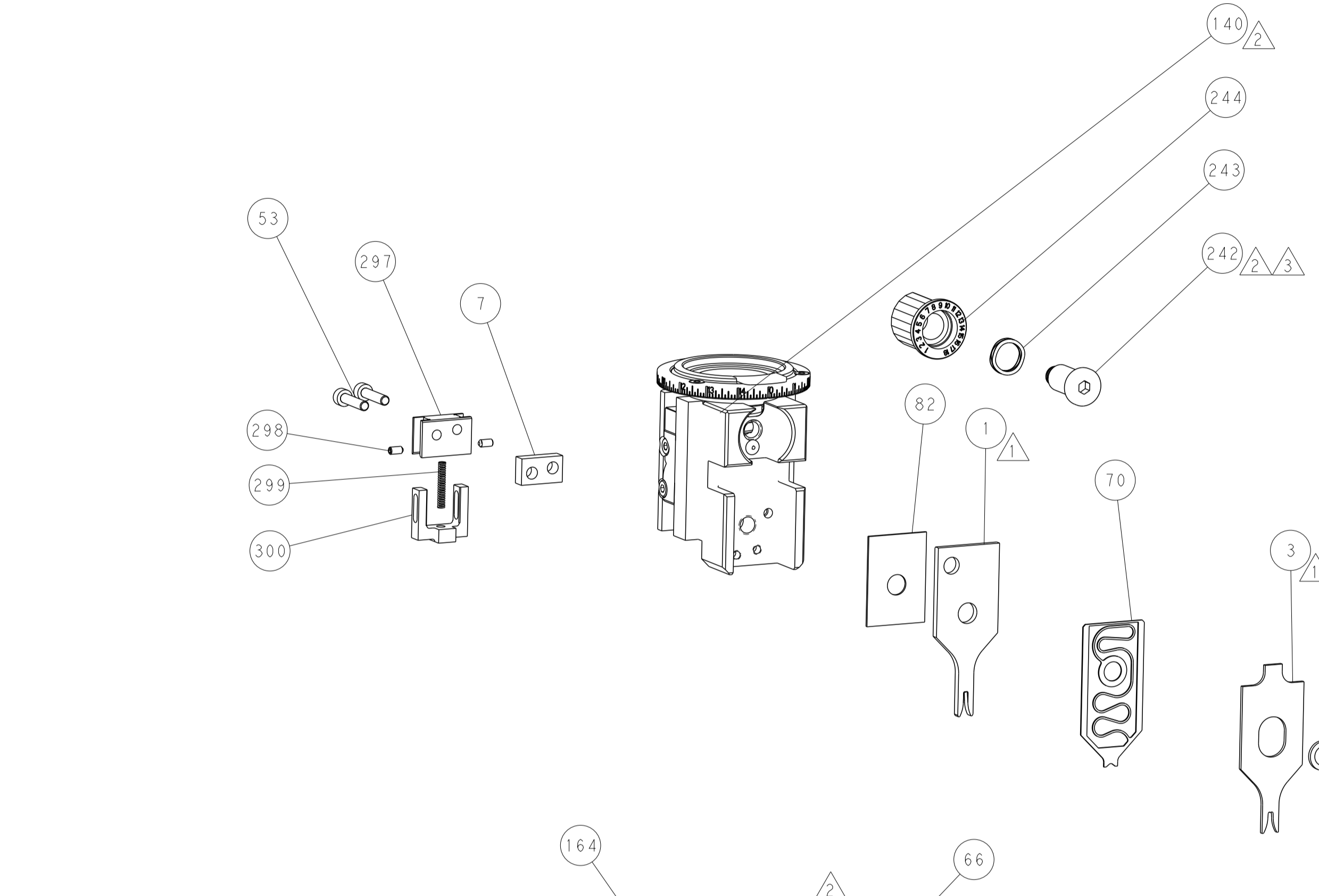
PNEUMATIC



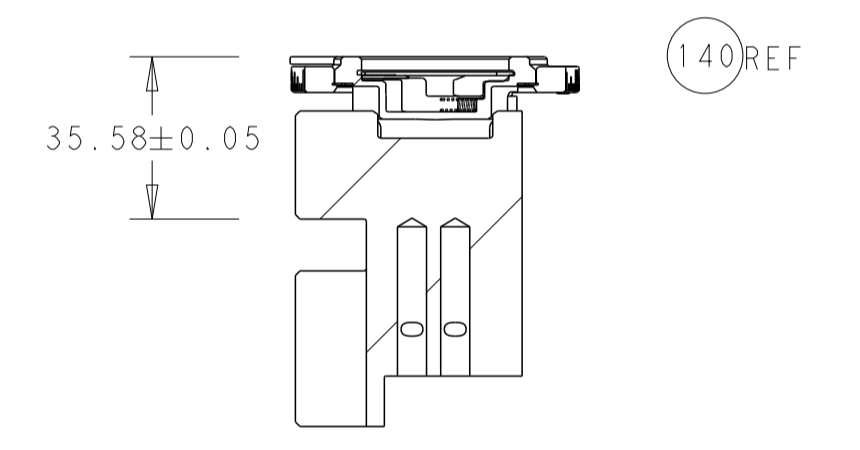
FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



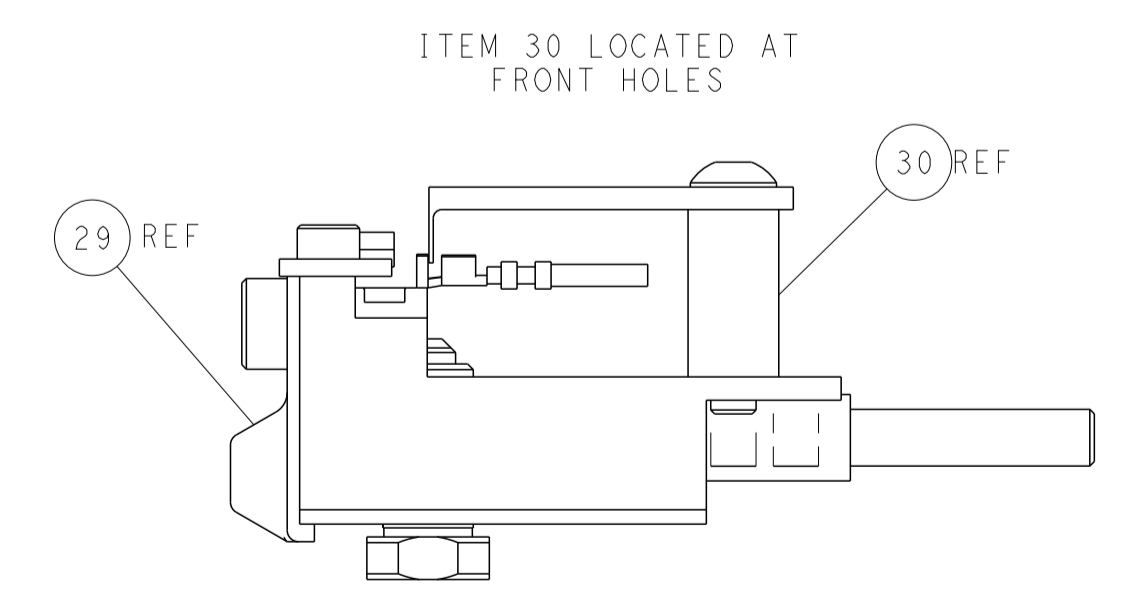
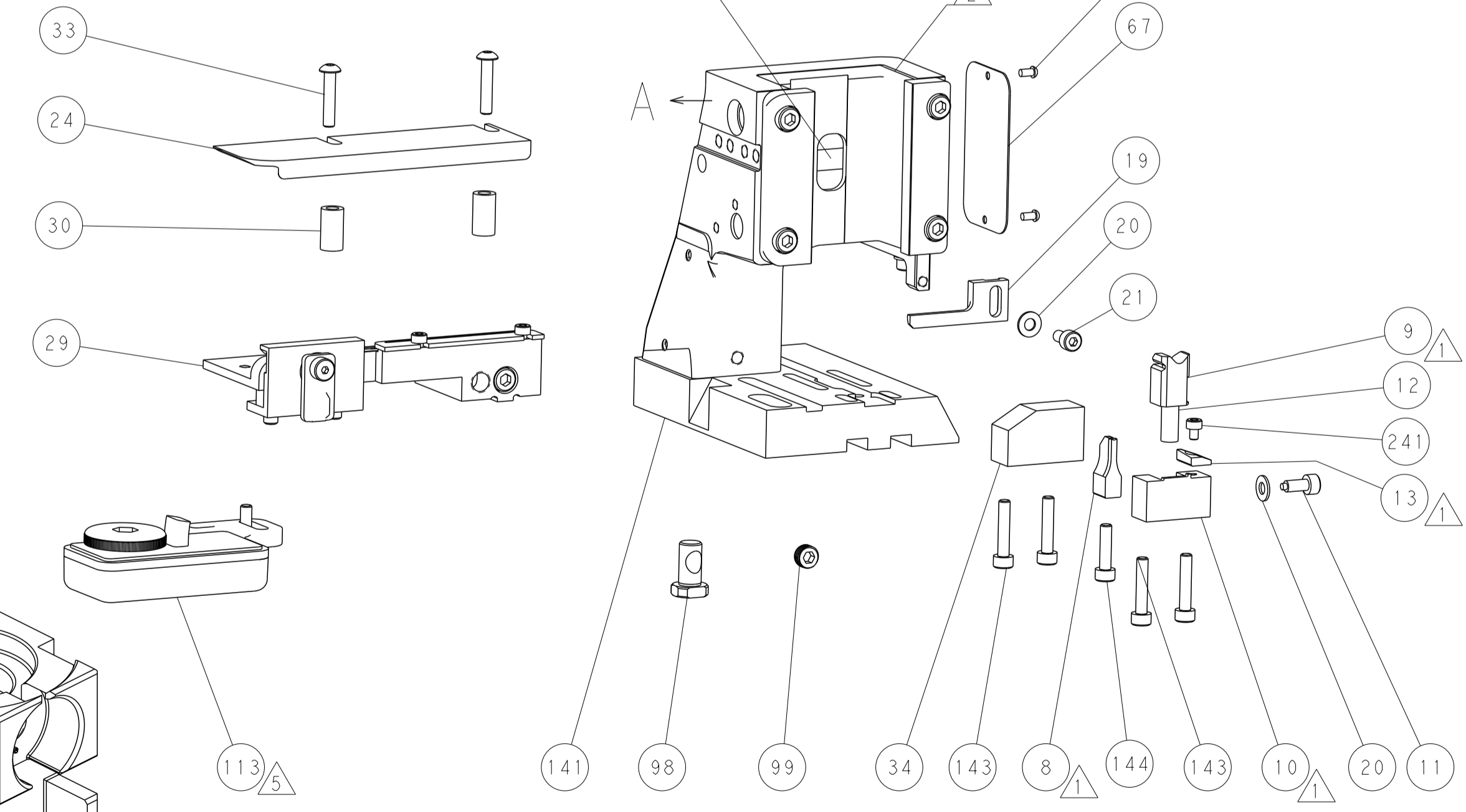
DETAIL A



TERMINAL SUPPORT LOCATION

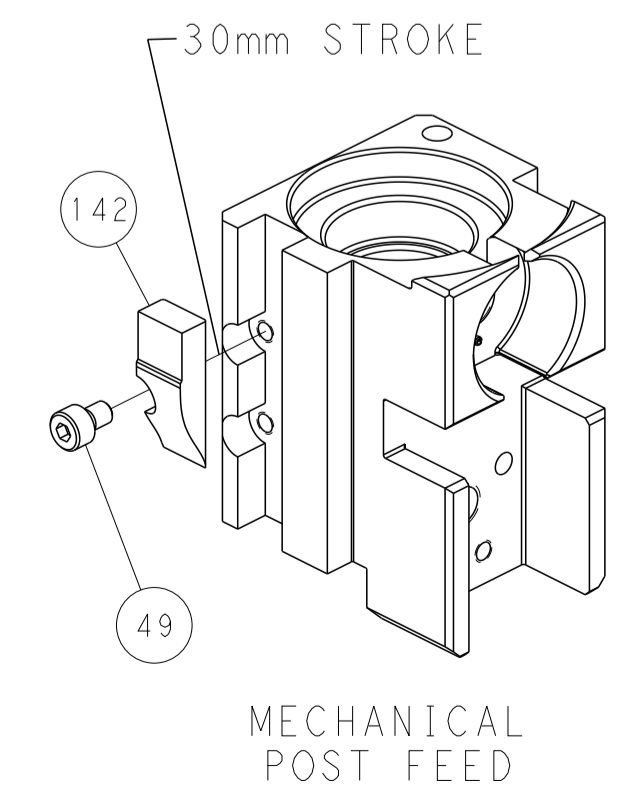


RAM SET-UP

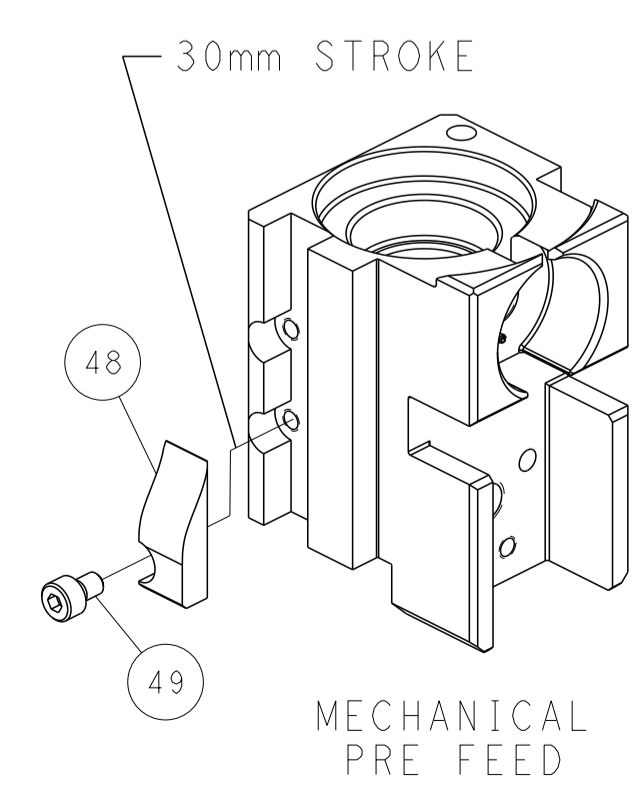


FEED TRACK POSITION
GUIDE BY INSULATION BARREL

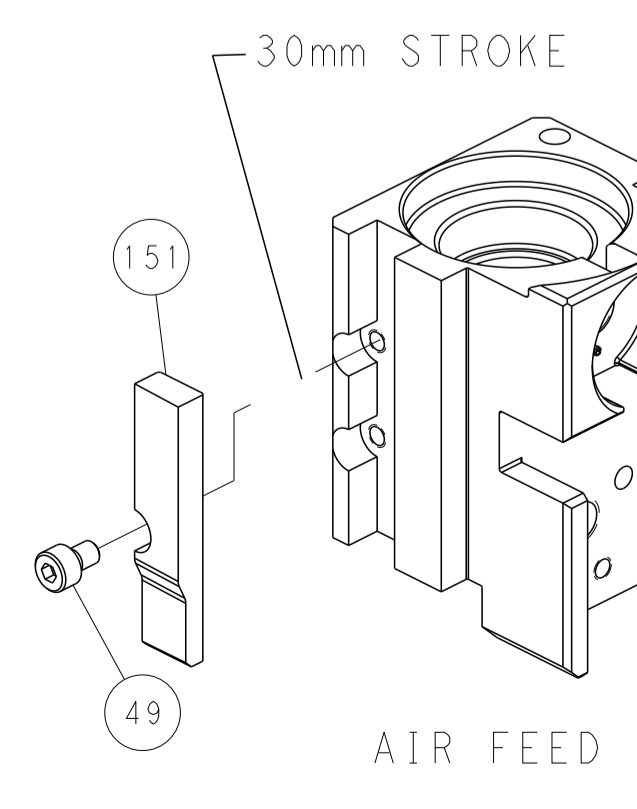
CAM POSITIONS



MECHANICAL
POST FEED



MECHANICAL
PRE FEED



AIR FEED

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:		DWG: M. ZHAO 20MAY2016		TE Connectivity	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	Harrisburg, PA 17105-3608	
MATERIAL:		FINISH:		CHK: K. ZHANG 20MAY2016		NAME: Ocean Side Feed Applicator	
				APVD: K. ZHANG 20MAY2016		SIZE: A1	
				PRODUCT SPEC:		CAGE CODE: 00779	
				APPLICATION SPEC:		DRAWING NO: 2836317	
				WEIGHT:		SCALE: 1:2	
				Customer Accessible Production Drawing		SHEET 4 OF 4 REV C	