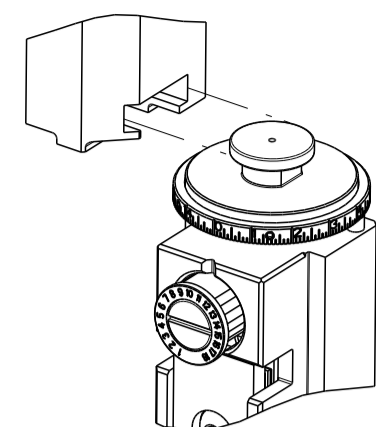


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2836648-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2836648-2	B	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2836648-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



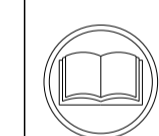
APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	3.05 mm [.120]	F
INSUL	7.00 mm [.276]	O

APPLICATOR INSTRUCTIONS 408-35042

TERMINAL DATA: ERICH JAEGER TERMINAL		PKC CRIMP SPECIFICATION	
TERMINAL NAME: 1.5-2.5mm <sup>2</sup> TUBE TERMINAL			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
4.69-5.45 mm [.185-.215 IN]		∅	△
TERMINAL APPLICATION SPECIFICATION	PKC Rev 2/21/2017	-	-

TERMINALS APPLIED				
TE TERMINAL	ERICH JAEGER TERMINAL	TE SEAL	ERICH JAEGER SEAL	INSULATION DIAMETER
2303730-1	037742-4	2303743-1	037743	∅2.2-3.5mm
		963244-1		∅2.2-3.0mm

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
2.50mm <sup>2</sup>	2.52+/-0.05 [.099+/-0.002]	6.0
2.00mm <sup>2</sup>	2.39+/-0.05 [.094+/-0.002]	7.4
1.50mm <sup>2</sup>	2.25+/-0.05 [.089+/-0.002]	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 THIS APPLICATOR APPLIES TERMINAL WITH A SEAL.
- 7 APPLY TORQ-SEAL IN ALLEN SOCKET TO FILL HOLE AFTER FLAT HD HAS BEEN ADJUSTED TO CORRECT HEIGHT AT QUALIFICATION. APPLY #1-23419-5 LOC-TITE TO THREADS.
- 8. 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	28APR2017	LG	TE
		B		ECR-22-153198	21SEP2022	JWC	TE
		B1		ECR-23-184919	22AUG2023	TB	GB

-	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	269
-	1	1	1-1633782-4	FENCE	267
-	1	1	1803078-2	SPACER, PRECISION	259
-	1	1	2119641-1	FEED CAM, AIR FEED	248
-	1	1	2119082-2	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	1	2844940-2	AIR FEED MODULE	238
-	REF	REF	994970-2	COUNTER, MAGNETIC	164
5	-	1	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113
-	1	1	2844908-1	SCREW, LOCKING	99
-	1	1	2844907-1	POST, LOCKING	98
-	1	1	1-690438-0	FRONT STRIP GUIDE	96
-	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
-	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
7	-	1	1-2168083-3	SCR, SKT HD CAP, RoHS, M3 X 16	57
-	1	1	1338685-1	PAWL, FEED	56
-	4	4	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	54
-	2	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	53
-	2	2	5018030-1	NUT, HEX, REG, RoHS, M3	52
-	1	1	811242-5	BUMPER, HOLD DOWN	51
-	1	1	690753-2	SPACER, TONKER	50
-	1	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	1	1	1-1803583-7	APPLICATOR BASIC ASSEMBLY, SF	46
-	1	1	1803515-2	RAM ASSEMBLY, SF ATLANTIC	44
-	1	1	1803602-2	SCR, BHSC, RoHS (M8 X 40)	41
-	1	1	1-1752356-3	SUPPORT, TERMINAL	34
-	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	2-2844962-7	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	2844992-5	ASSEMBLY, STRIP GUIDE	29
-	1	1	1-455888-0	SPACER, CRIMPER	28
-	2	2	22283-1	SPRING, COMPRESSION	27
-	1	1	240792-1	DRAG, TERMINAL	25
-	1	1	1320928-6	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	1803013-1	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	2119805-7	SHEAR HOLDER, FRONT	10
1	-	1	318059-9	FLOATING SHEAR, FRONT	9
1	2	1	8-1633930-3	ANVIL, COMBINATION	8
-	-	-	-	-	7
-	-	-	-	-	6
-	1	1	1803080-1	DEPRESSOR, SHEAR	5
-	1	1	3-238011-5	BLOCK, CRIMPER SPACER	4
1	2	1	1803464-4	CRIMPER, INSULATION O	3
-	1	1	2-455888-2	SPACER, CRIMPER	2
1	2	1	456409-5	CRIMPER, WIRE .120 "F" PREMIUM	1

<small>THIS DRAWING IS UNPUBLISHED. IT IS THE PROPERTY OF TYCO ELECTRONICS CORPORATION. IT IS TO BE USED ONLY FOR THE PURPOSES SPECIFIED IN THE DRAWING. IT IS TO BE RETURNED TO TYCO ELECTRONICS CORPORATION UPON REQUEST. IT IS NOT TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, INCLUDING PHOTOCOPYING, RECORDING, OR BY ANY INFORMATION STORAGE AND RETRIEVAL SYSTEM. WITHOUT PERMISSION IN WRITING FROM TYCO ELECTRONICS CORPORATION.</small>		DWN CHS APVD	B. WEAVER T. ELBIN T. ELBIN	13MAR2017 13MAR2017 13MAR2017	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	
MATERIAL:		WEIGHT:		SIZE CAGE CODE DRAWING NO RESTRICTED TO A1 00779 C=2836648	
Customer Accessible Production Drawing		SCALE 1:2		SHEET 1 OF 4 REV B1	



PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2836648-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2836648-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR  
 INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	3.05 mm [1.20]	F
INSUL	7.00 mm [2.76]	O

APPLICATOR INSTRUCTIONS  
 408-35042

TERMINAL DATA: ERICH JAEGER TERMINAL PKC CRIMP SPECIFICATION	
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE
4.69-5.45 mm [1.85-.215 IN]	Ø 2.2-3.5mm

TERMINAL APPLICATION SPECIFICATION PKC Rev 2/21/2017

TE TERMINAL	ERICH JAEGER TERMINAL	TE SEAL	ERICH JAEGER SEAL	INSULATION DIAMETER
2303730-1	037742-4	2303743-1	037743	Ø2.2-3.5mm
		963244-1		Ø2.2-3.0mm

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
2.50mm <sup>2</sup>	2.52 +/- 0.05 [1.099 +/- .002]	6.0
2.00mm <sup>2</sup>	2.39 +/- 0.05 [1.094 +/- .002]	7.4
1.50mm <sup>2</sup>	2.25 +/- 0.05 [1.089 +/- .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.
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- 5 TERMINAL LUBRICANT IS RECOMMENDED.
- 6 THIS APPLICATOR APPLIES TERMINAL WITH A SEAL.
- 7 APPLY TORQ-SEAL IN ALLEN SOCKET TO FILL HOLE AFTER FLAT HD HAS BEEN ADJUSTED TO CORRECT HEIGHT AT QUALIFICATION. APPLY #1-23419-5 LOC-TITE TO THREADS.
- 8. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.

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

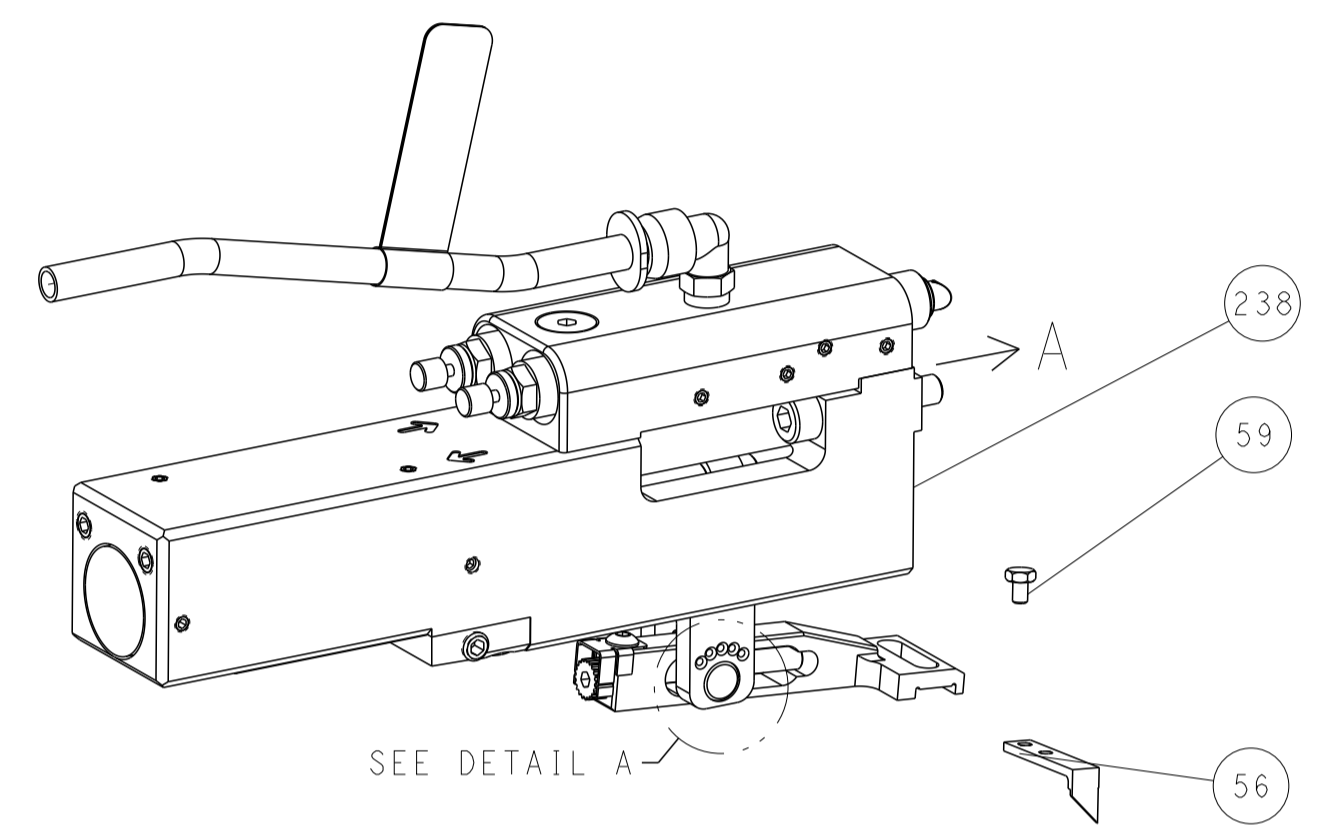
LOC	DIST	REV	DATE	BY	APPV
A	66				

REV	DATE	BY	APPV	DESCRIPTION	ITEM NO	
-	2			SCR, SKT HD CAP, RoHS, M3 X 8.0	269	
-	1			FENCE	267	
-	1			SPACER, PRECISION	259	
-	1			CAM, SNAIL, INSULATION ADJUSTMENT	244	
-	1			WASHER, WAVE SPRING, CREST-TO-CREST	243	
3	1			RETAINER, INSULATION DIAL	242	
-	1			SCR, SKT HD CAP M3 X 4.0	241	
-	1			AIR FEED MODULE	238	
-	REF			COUNTER, MAGNETIC	164	
-	1			FEED CAM, AIR FEED	151	
-	1			SCR, SKT HD CAP, RoHS, M4 X 16	144	
-	4			SCR, SKT HD CAP, RoHS, M4 X 20	143	
-	1			APPLICATOR BASIC ASSEMBLY, SF	141	
-	1			RAM ASSEMBLY, SF PACIFIC	140	
5	1			ASSY, LUBRICATOR, SIDE FEED	113	
-	1			SCREW, LOCKING	99	
-	1			POST, LOCKING	98	
-	1			FRONT STRIP GUIDE	96	
-	1			SPACER, CRIMPER	82	
-	1			DOCUMENTATION PACKAGE	71	
-	1			TAG, IDENTIFICATION	67	
-	2			SCREW, DRIVE, RH, RoHS, 2 x .188	66	
-	1			SCR, HEX HD CAP, M4 X 6.0	59	
7	1			SCR, SKT HD CAP, RoHS, M3 X 16	57	
-	1			PAWL, FEED	56	
-	2			SCR, SKT HD CAP, RoHS, M4 X 10	53	
-	2			NUT, HEX, REG, RoHS, M3	52	
-	1			BUMPER, HOLD DOWN	51	
-	1			SPACER, TONKER	50	
-	1			SCR, SKT HD CAP M4 X 6.0	49	
-	1			SCR, BHSC, RoHS (M8 X 40)	41	
-	1			SUPPORT, TERMINAL	34	
-	2			SCR, BHSC, RoHS (M4 X 20)	33	
-	2			SPACER, CYLINDRICAL, STRIP GUIDE	30	
-	1			ASSEMBLY, STRIP GUIDE	29	
-	1			SPACER, CRIMPER	28	
-	2			SPRING, COMPRESSION	27	
-	1			DRAG, TERMINAL	25	
-	1			STRIP GUIDE	24	
-	1			SCR, SKT HD CAP, RoHS, M4 X 8.0	21	
-	2			WASHER, FLAT, REG M4	20	
-	1			STRIPPER, SIDE FEED	19	
1	1			INSERT, SHEAR	13	
-	1			SPRING, COMPRESSION	12	
-	1			STOP, SHEAR	11	
1	1			SHEAR HOLDER, FRONT	10	
1	1			FLOATING SHEAR, FRONT	9	
1	1			ANVIL, COMBINATION	8	
-	-			-	7	
-	-			-	6	
-	1			DEPRESSOR, SHEAR	5	
-	1			BLOCK, CRIMPER SPACER	4	
1	1			CRIMPER, INSULATION O	3	
-	1			SPACER, CRIMPER	2	
1	1			CRIMPER, WIRE .120 "F" PREMIUM	1	
-77	-22			PART NO	DESCRIPTION	ITEM NO

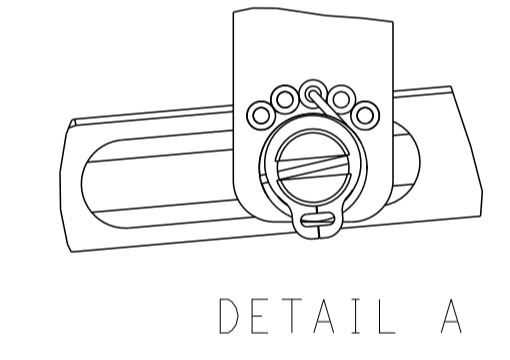
DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH		DWG: B. WEAVER 13MAR2017 CHK: T. ELBIN 13MAR2017 APVD: T. ELBIN 13MAR2017 PRODUCT SPEC APPLICATION SPEC WEIGHT: - SCALE: 1:2 SHEET 3 OF 4 REV: B1		NAME: Ocean Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2836648 RESTRICTED TO: - Customer Accessible Production Drawing	
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LOC	DIST	REVISIONS					
A	66	P	LYR	DESCRIPTION	DATE	DWN	APVD
		-	-	SEE SHEET 1	-	-	-

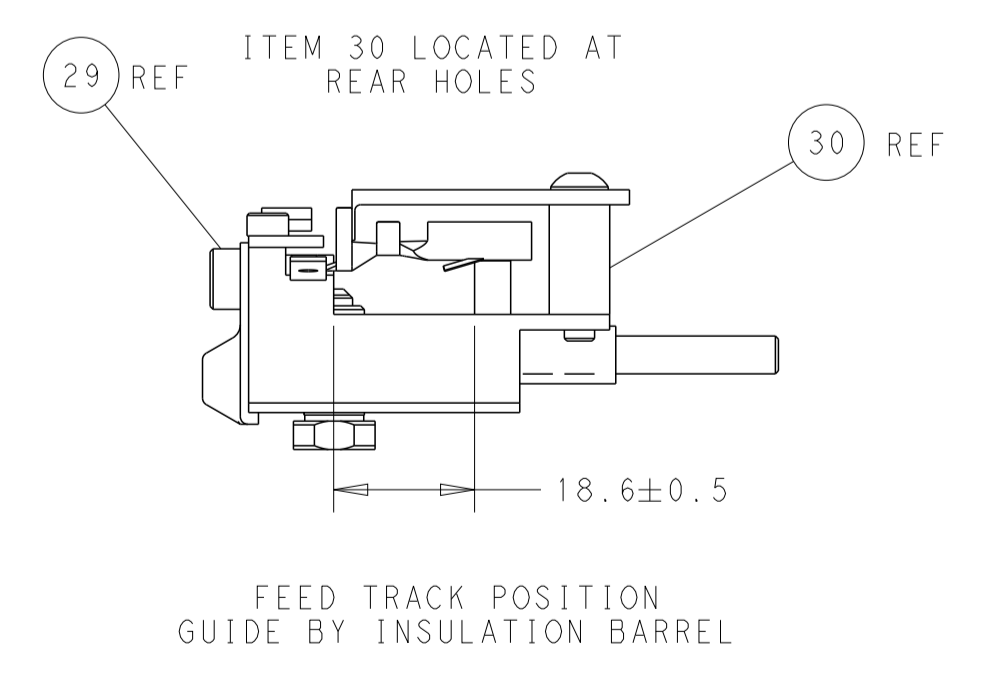
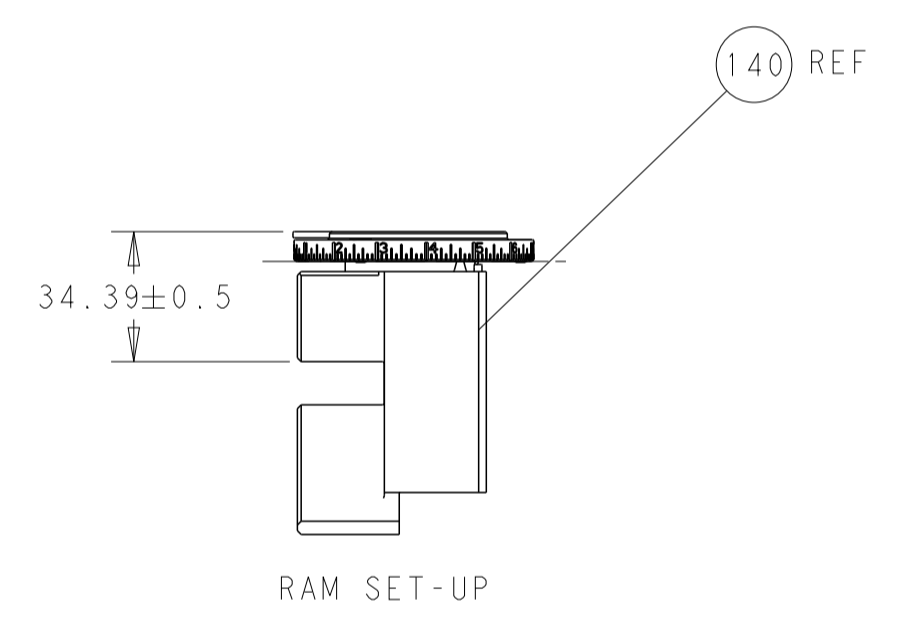
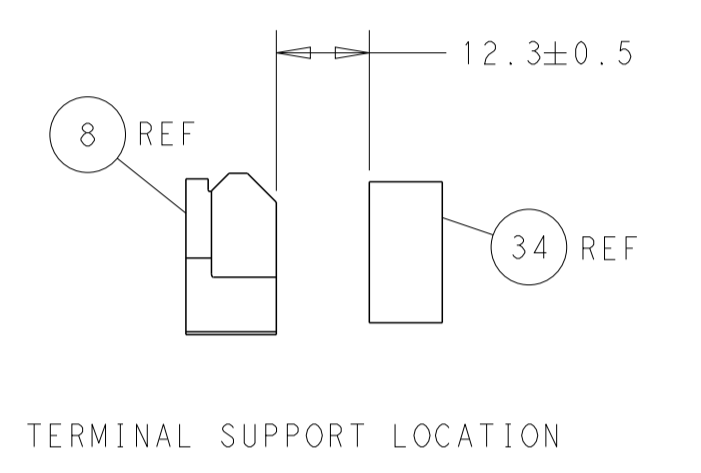
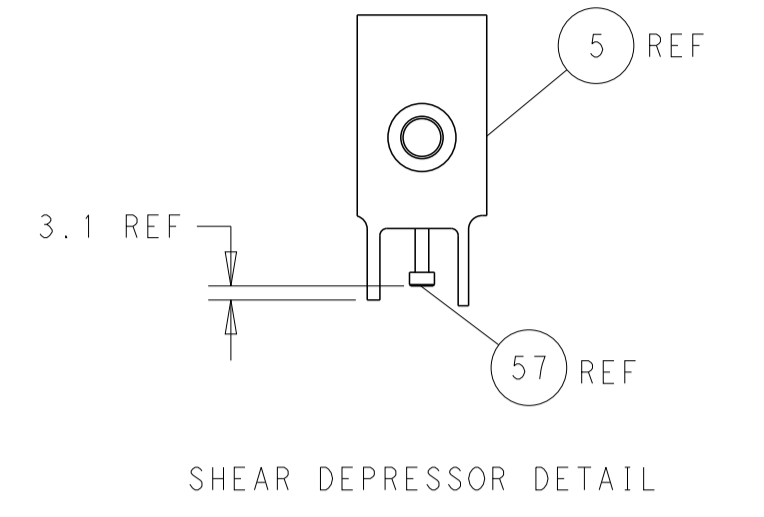
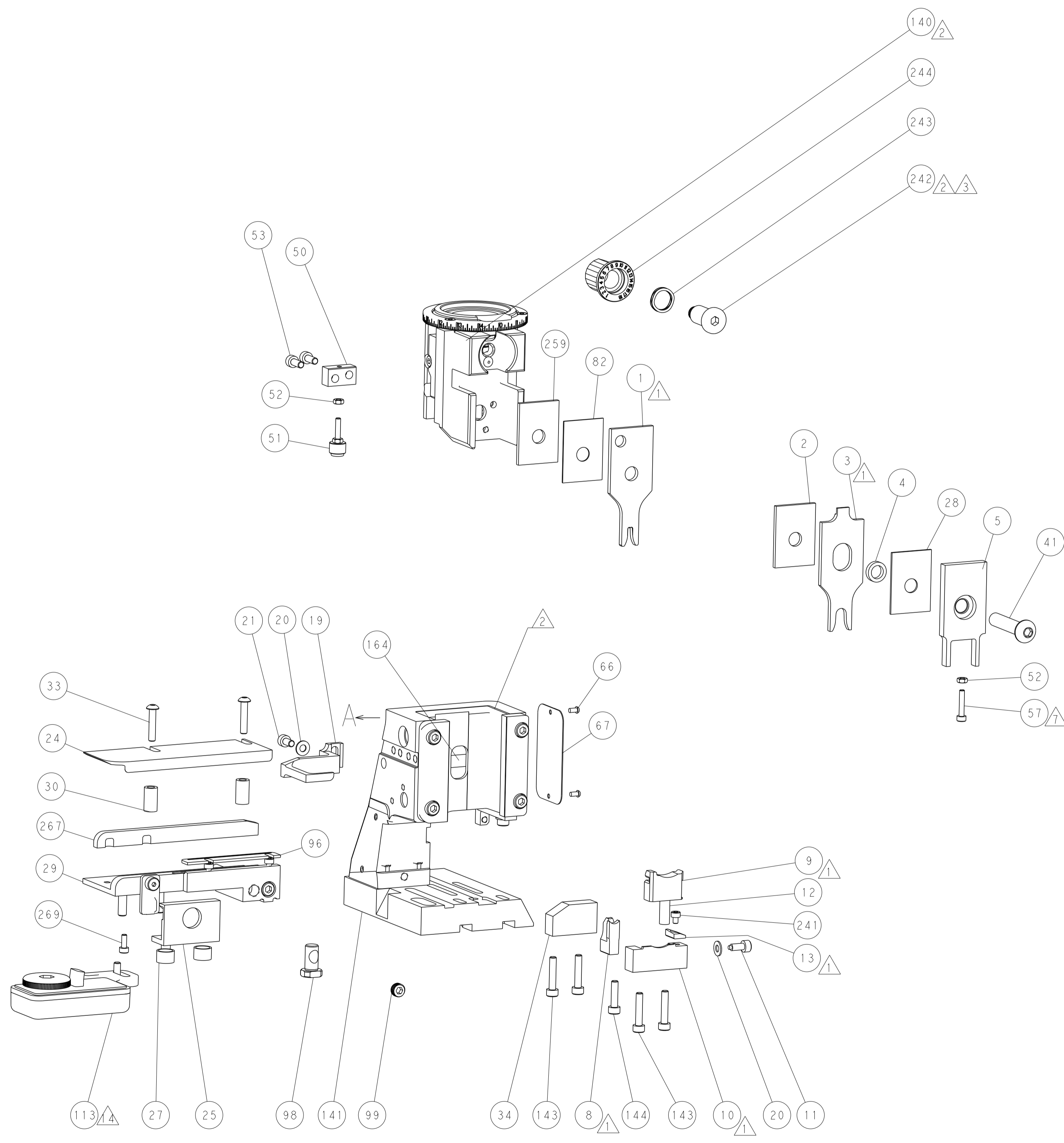
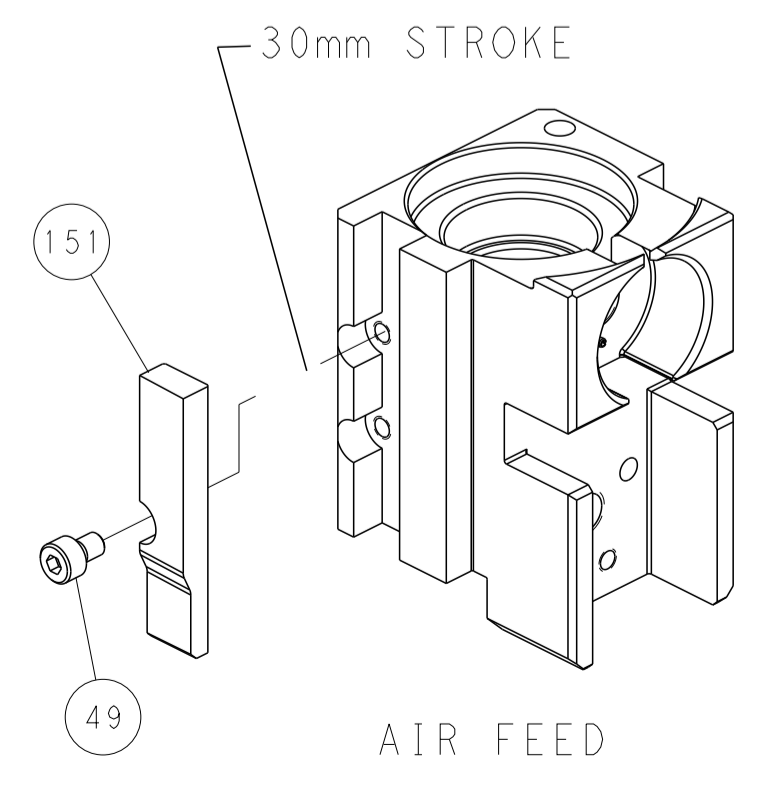
### FEED TYPE PNEUMATIC



### 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)

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DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± MATERIAL: - FINISH: -		NAME: Ocean Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2836648 WEIGHT: - SCALE: 1:2 SHEET: 4 OF 4 REV: B1	RESTRICTED TO: -