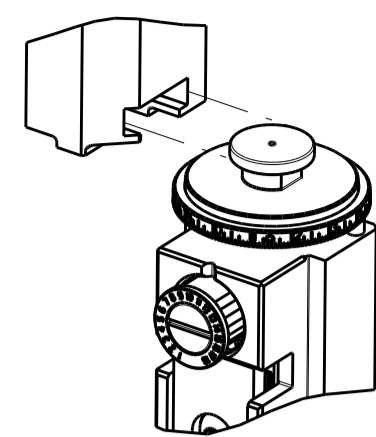


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2836671-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2836671-2	B	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2836671-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER

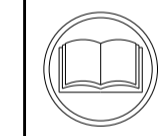


APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	3.30 mm [.130]	F
INSUL	7.00 mm [.276]	O

APPLICATOR INSTRUCTIONS 408-35042

TERMINAL DATA: KOSTAL TERMINAL KOSTAL CRIMP SPECIFICATION			
TERMINAL NAME: SLK 2.8 PLUG TERMINAL			
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE		
5.91-6.67 mm [.233-.263 IN]	3.40-3.70 mm [.134-.146 IN]		
TERMINAL APPLICATION SPECIFICATION 1 99 00 49907 0 Rev 3			
TERMINALS APPLIED			
TE TERMINAL	KOSTAL TERMINAL	TE SEAL	KOSTAL SEAL
2303739-1	1 01 24 49916 0	2303740-1	1 08 00444 52 4
2303739-2	1 01 25 49916 0		
2303739-3	1 01 40 49916 0		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
4.00mm2	2.05+/-0.05 [.081+/- .002]	8.9



- 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. 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.
- 6. TERMINAL LUBRICANT IS RECOMMENDED.
- 7. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- 8. 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.

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					
		P	LTN	DESCRIPTION	DATE	OWN	APVD
A	66	1		PRELIMINARY	29MAR2017	MEH	TE
		A		RELEASED	28APR2017	MEH	CT
		B		ECR-20-000961	20JAN2020	FZ	TE

-	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	269	
-	1	1	1-1633782-4	FENCE	267	
-	1	1	1803078-4	SPACER, PRECISION	259	
-	1	1	2119641-1	FEED CAM, AIR FEED	248	
-	1	1	2119082-6	CAM, SNAIL, INSULATION ADJUSTMENT	244	
-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243	
3	-	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	
6	-	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	1-690438-0	FRONT STRIP GUIDE	96	
-	1	1	455888-5	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	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	
5	-	1	1	1-2168083-3	SCR, SKT HD CAP, RoHS, M3 X 16	57
-	1	1	1338683-8	FEED PAWL	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	
-	1	1	1803382-1	HOLD DOWN, SPRING LOADED	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	4-1752356-2	SUPPORT, TERMINAL	34	
-	2	2	1-2079383-3	SCR, BHSC, RoHS (M4 X 25)	33	
-	2	2	4-2844962-0	SPACER, CYLINDRICAL, STRIP GUIDE	30	
-	1	1	2844992-5	ASSEMBLY, STRIP GUIDE	29	
-	1	1	455888-3	SPACER, CRIMPER	28	
-	2	2	22283-1	SPRING, COMPRESSION	27	
-	1	1	240792-1	DRAG, TERMINAL	25	
-	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	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	8-1633930-5	ANVIL, COMBINATION	8	
-	1	1	5-240641-4	SPACER	7	
-	-	-	-	-	6	
-	1	1	1803080-1	DEPRESSOR, SHEAR	5	
-	1	1	3-238011-0	BLOCK, CRIMPER SPACER	4	
1	2	1	1803453-5	CRIMPER, INSULATION O	3	
-	1	1	455888-3	SPACER, CRIMPER	2	
1	2	1	456410-1	CRIMPER, WIRE PREMIUM	1	
-	77-72	-2	PART NO	DESCRIPTION	ITEM NO	

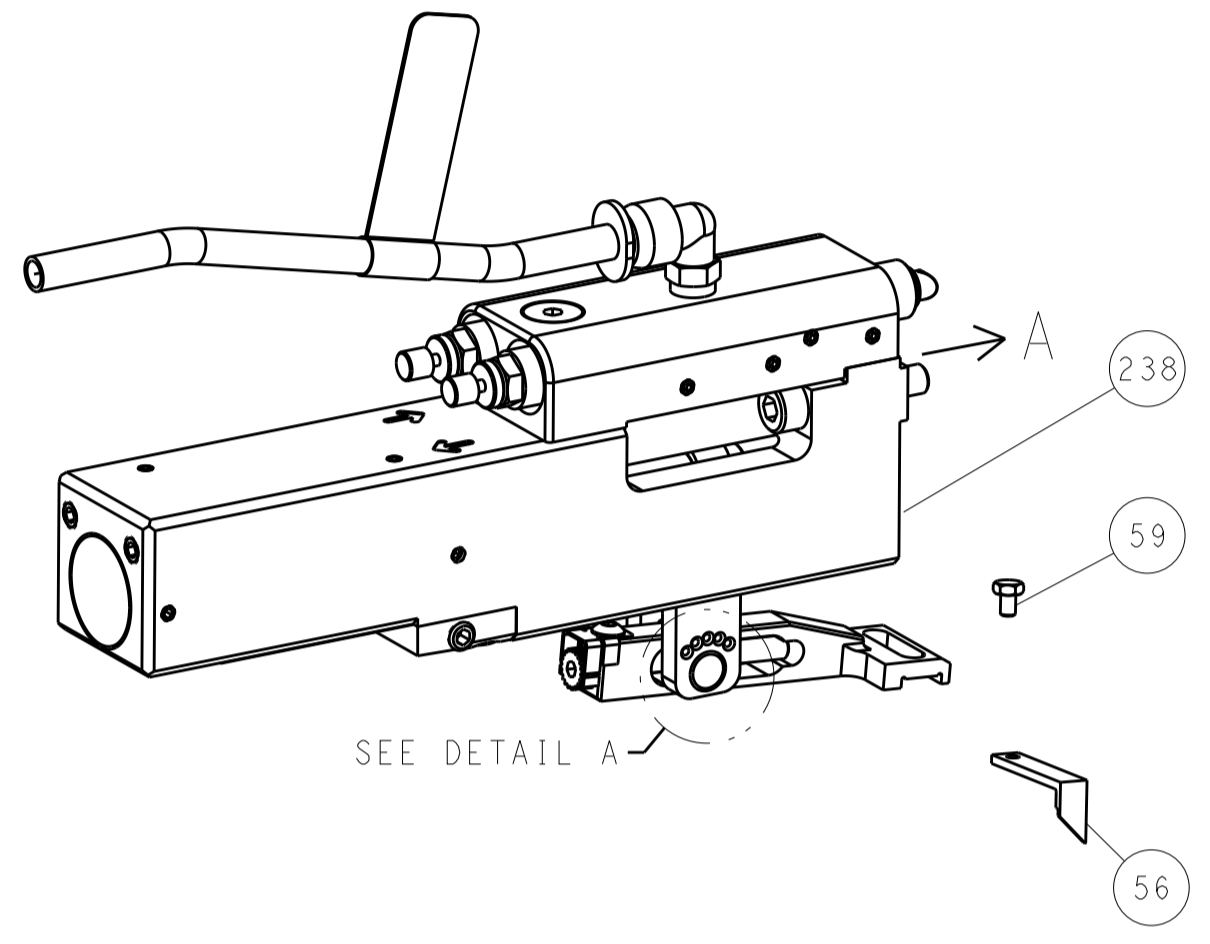
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mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES ±	

OWN	JM_HERR	29MAR2017	
CHK	T. ELBIN	29MAR2017	
APVD	T. ELBIN	29MAR2017	
NAME	Ocean Side Feed Applicator		
SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
A1	00779	2836671	
Customer Accessible Production Drawing			SCALE 1:2 SHEET 1 OF 4 REV B

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

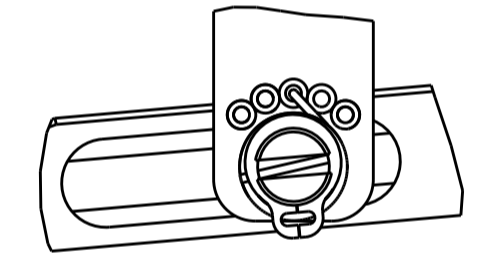
### FEED TYPE

#### PNEUMATIC



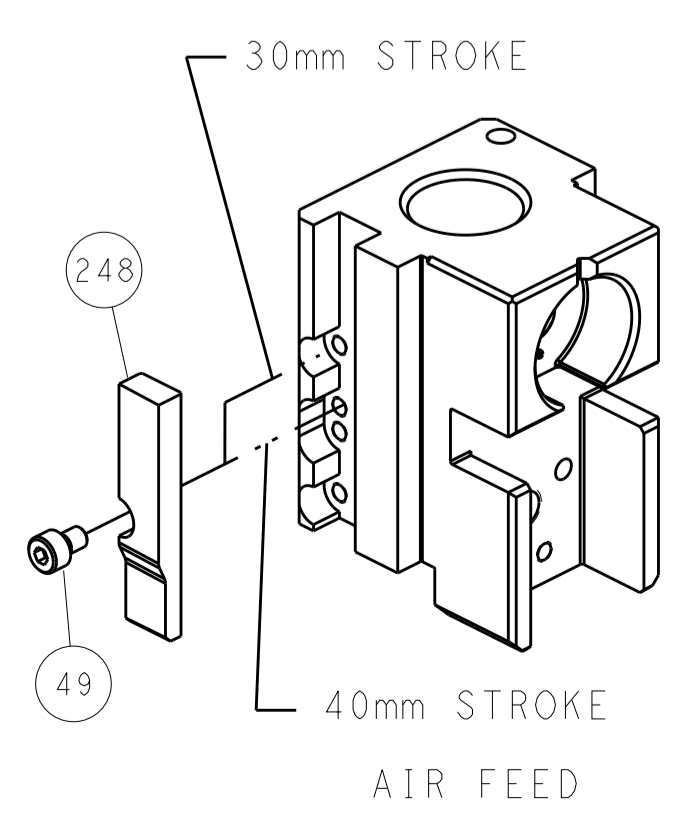
SEE DETAIL A

#### FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)

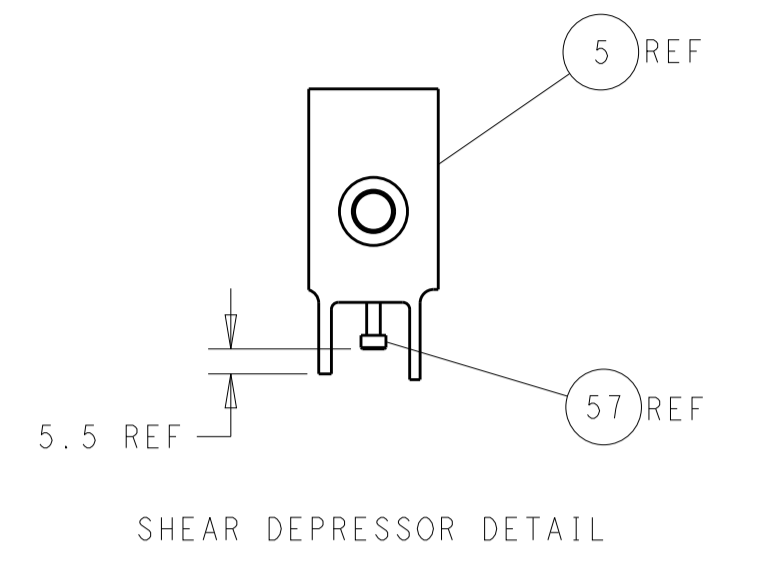
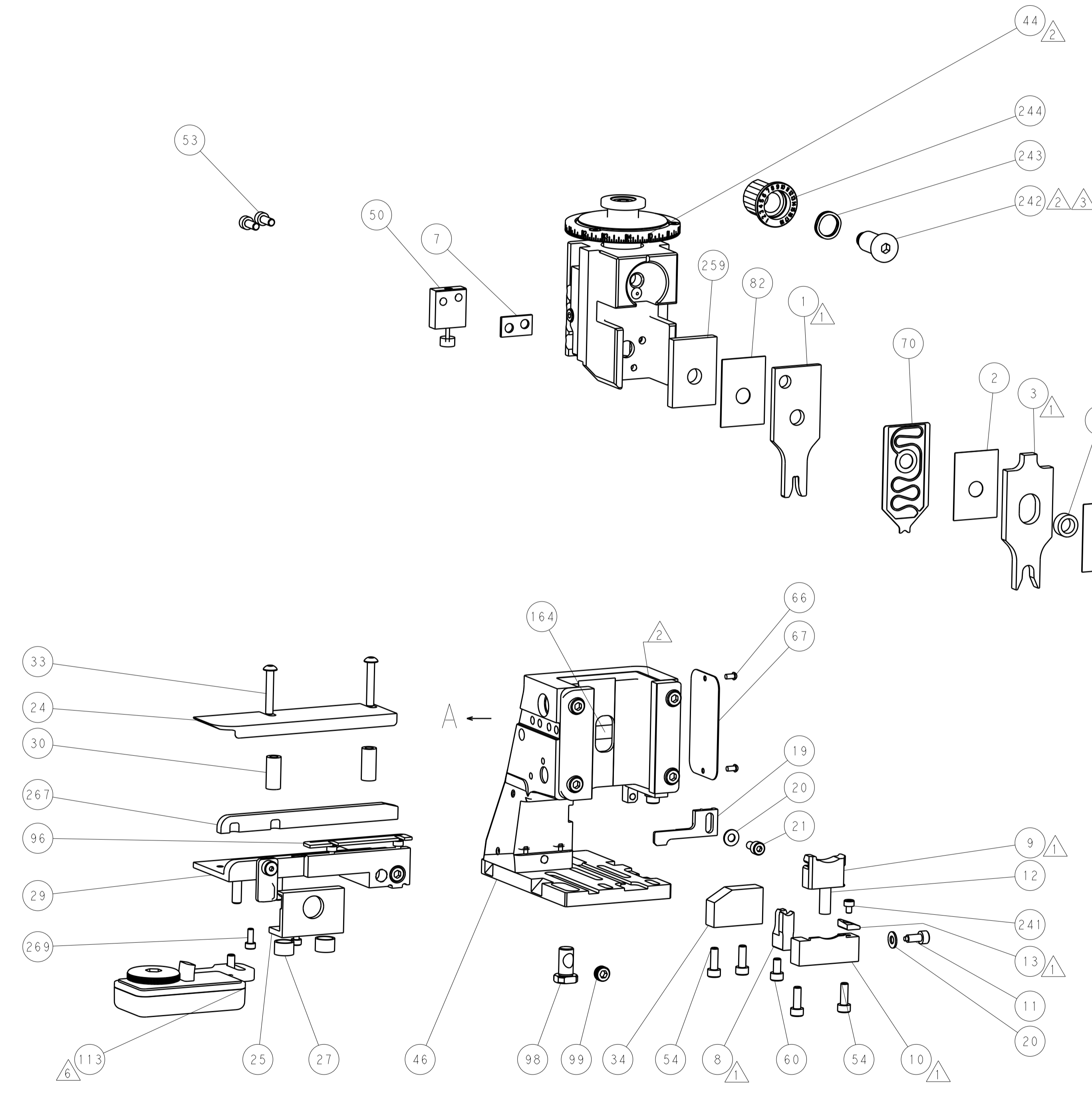


DETAIL A

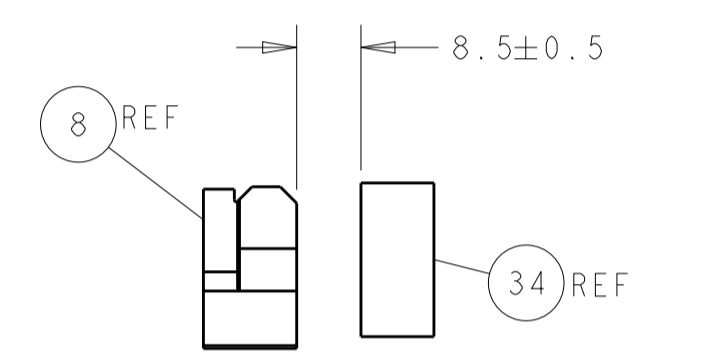
### CAM POSITION



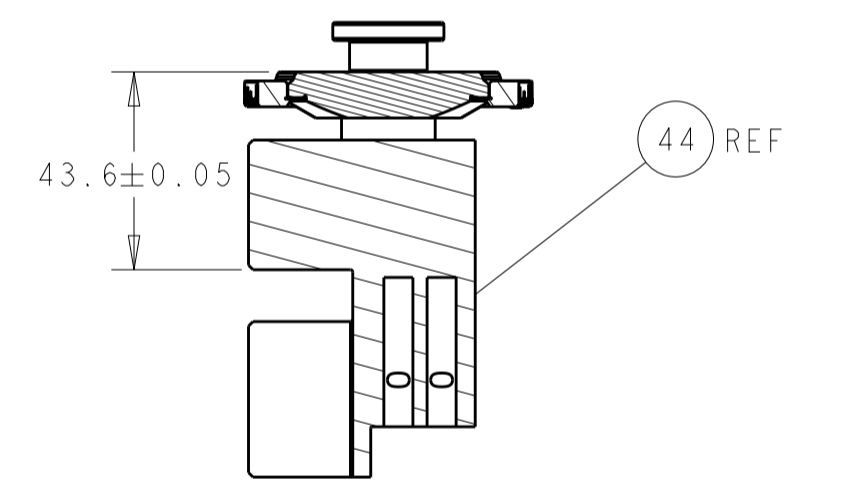
AIR FEED



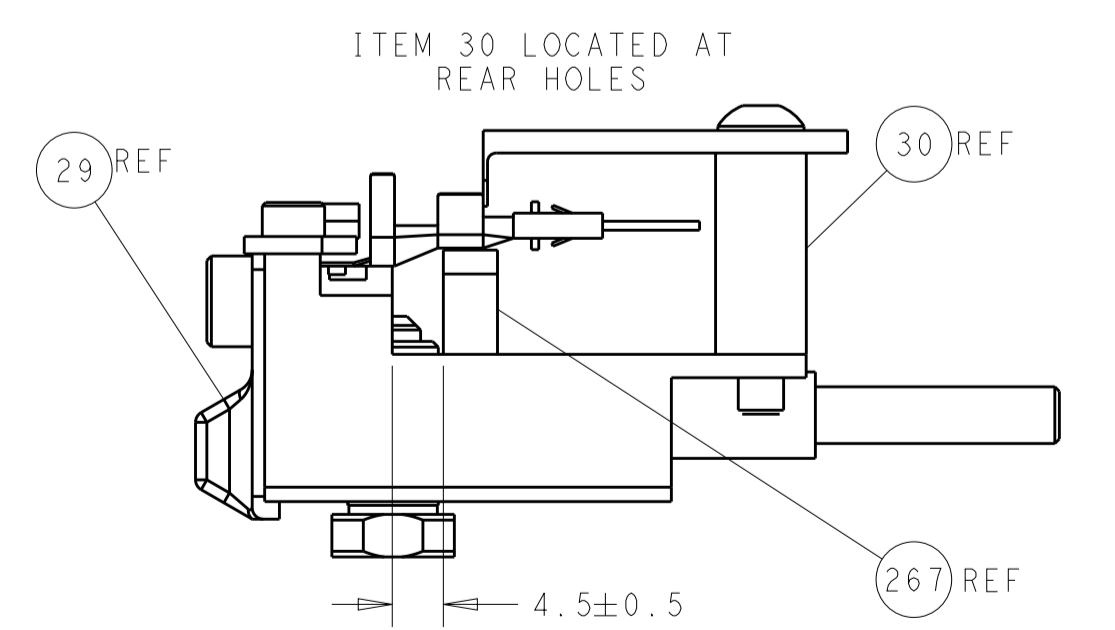
SHEAR DEPRESSOR DETAIL



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)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DMN: M_HERR 29MAR2017	TE Connectivity Harrisburg, PA 17105-3608
mm	0 PLC ±	1 PLC ±	2 PLC ±	CHK: T_ELBIN 29MAR2017	
	3 PLC ±	4 PLC ±	ANGLES ±	APVD: T_ELBIN 29MAR2017	NAME: Ocean Side Feed Applicator
MATERIAL:	FINISH:	WEIGHT:	SCALE: 1:2	SIZE: A1	
Customer Accessible Production Drawing				CAGE CODE: 00779	DRAWING NO: 2836671
				SHEET 2 OF 4	REV B

THIS DRAWING IS UNPUBLISHED.	RELEASED FOR PUBLICATION	2017	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2836671-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2836671-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR  
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	3.30 mm [1.30]	F
INSUL	7.00 mm [2.76]	O
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: KOSTAL TERMINAL		KOSTAL CRIMP SPECIFICATION	
TERMINAL NAME: SLK 2.8 PLUG TERMINAL			
WIRE STRIP LENGTH 5.91-6.67 mm [2.33-.263 IN]		INSULATION DIAMETER RANGE 3.40-3.70 mm [1.34-.146 IN]	
TERMINAL APPLICATION SPECIFICATION 1 99 00 49907 0 Rev 3			
TERMINALS APPLIED			
TE TERMINAL	KOSTAL TERMINAL	TE SEAL	KOSTAL SEAL
2303739-1	1 01 24 49916 0	2303740-1	1 08 00444 52 4
2303739-2	1 01 25 49916 0		
2303739-3	1 01 40 49916 0		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
4.00mm2	2.05 +/- 0.05 [1.081 +/- .020]	8.9



- 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 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.
- 6 TERMINAL LUBRICANT IS RECOMMENDED.
- 7 UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- 8 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.

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

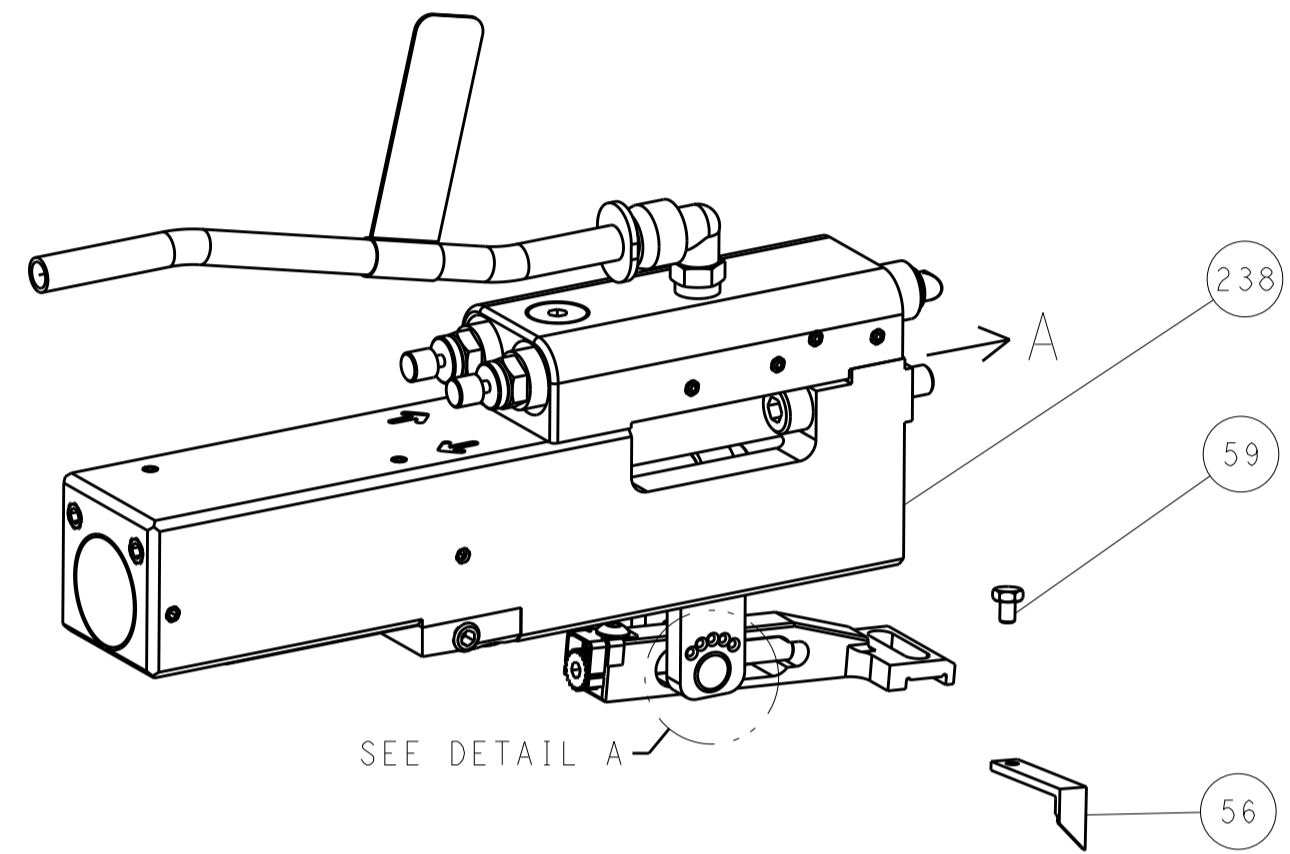
LOC	DIST	REV	DATE	BY	APPD
A	66				

REVISIONS					
REV	DATE	DESCRIPTION	DATE	BY	APPD
-	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0		269
-	1	1-1633782-4	FENCE		267
-	1	1803078-4	SPACER, PRECISION		259
-	1	2119082-6	CAM, SNAIL, INSULATION ADJUSTMENT		244
-	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST		243
3	-	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	1-1803583-8	APPLICATOR BASIC ASSEMBLY, SF		141
-	1	1803516-2	RAM ASSEMBLY, SF PACIFIC		140
6	-	2119955-1	ASSY, LUBRICATOR, SIDE FEED		113
-	1	2844908-1	SCREW, LOCKING		99
-	1	2844907-1	POST, LOCKING		98
-	1	1-690438-0	FRONT STRIP GUIDE		96
-	1	455888-5	SPACER, CRIMPER		82
-	1	1803607-3	DOCUMENTATION PACKAGE		71
-	1	2119791-5	DEPRESSOR, WIRE		70
-	1	2119740-1	TAG IDENTIFICATION		67
-	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188		66
-	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0		59
5	-	1-2168083-3	SCR, SKT HD CAP, RoHS, M3 X 16		57
-	1	1338683-8	FEED PAWL		56
-	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10		53
-	1	1803382-1	HOLD DOWN, SPRING LOADED		50
-	1	18023-9	SCR, SKT HD CAP M4 X 6.0		49
-	1	1803602-2	SCR, BHSC, RoHS (M8 X 40)		41
-	1	4-1752356-2	SUPPORT, TERMINAL		34
-	2	1-2079383-3	SCR, BHSC, RoHS (M4 X 25)		33
-	2	4-2844962-0	SPACER, CYLINDRICAL, STRIP GUIDE		30
-	1	2844992-5	ASSEMBLY, STRIP GUIDE		29
-	1	455888-3	SPACER, CRIMPER		28
-	2	22283-1	SPRING, COMPRESSION		27
-	1	240792-1	DRAG, TERMINAL		25
-	1	1320928-2	STRIP GUIDE		24
-	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	1-356885-4	STOP, SHEAR		11
1	-	2119805-7	SHEAR HOLDER, FRONT		10
1	-	318059-9	FLOATING SHEAR, FRONT		9
1	1	8-1633930-5	ANVIL, COMBINATION		8
-	1	5-240641-4	SPACER		7
-	-	-	-		6
-	1	1803080-1	DEPRESSOR, SHEAR		5
-	1	3-238011-0	BLOCK, CRIMPER SPACER		4
1	1	1803453-5	CRIMPER, INSULATION O		3
-	1	455888-3	SPACER, CRIMPER		2
1	1	456410-1	CRIMPER, WIRE PREMIUM		1

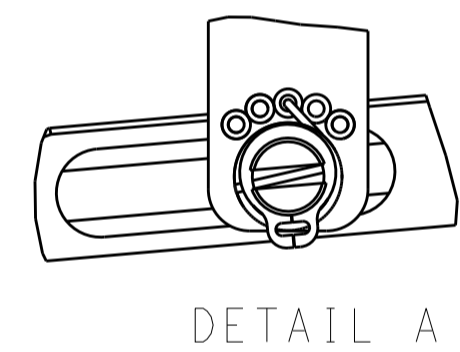
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mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	NAME: Ocean Side Feed Applicator	
MATERIAL:		FINISH:		APVD: ELBIN 29MAR2017		SIZE: CAGE CODE: DRAWING NO: 00779 C=2836671	
				WEIGHT:		RESTRICTED TO: Customer Accessible Production Drawing	
				SCALE: 1:2		SHEET 3 OF 4 REV B	

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

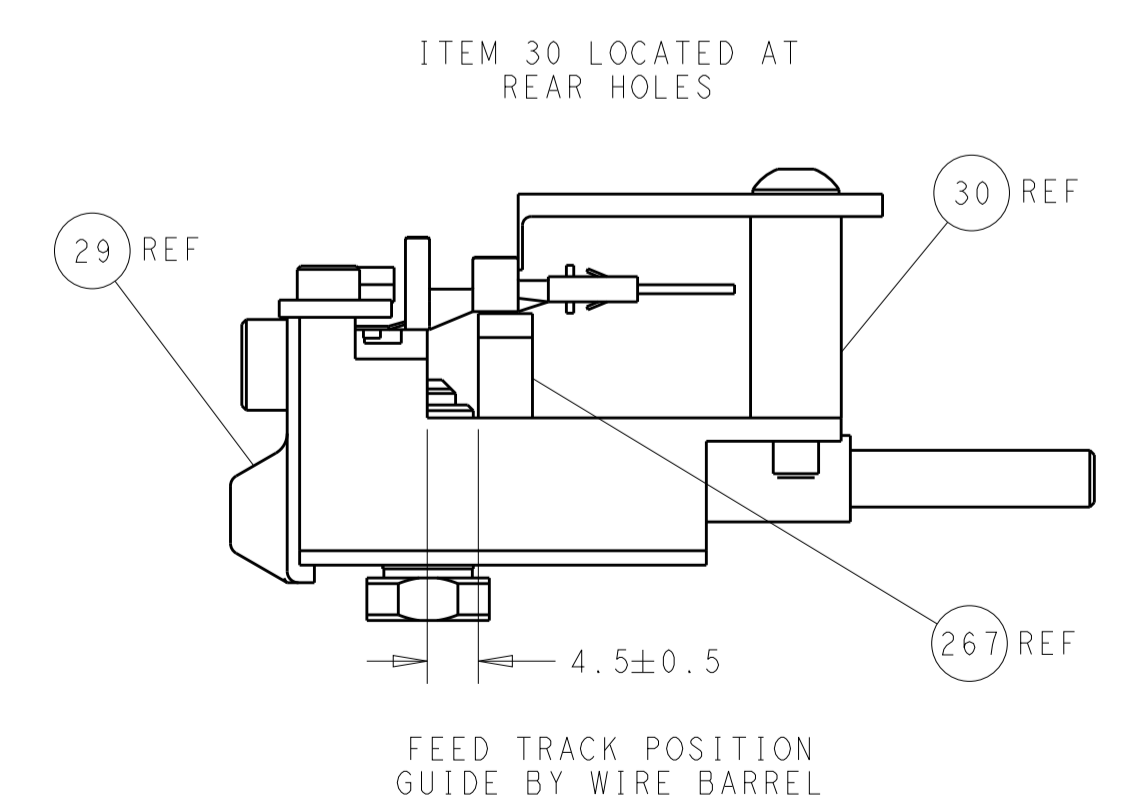
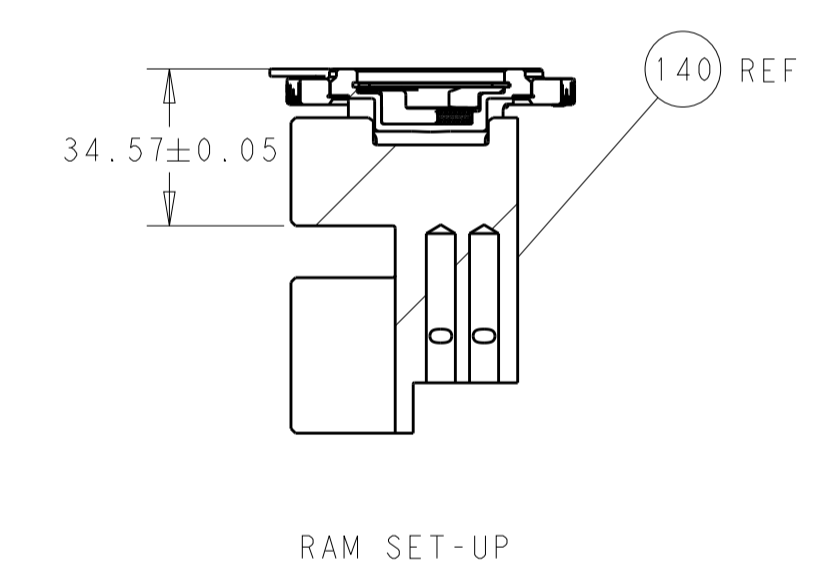
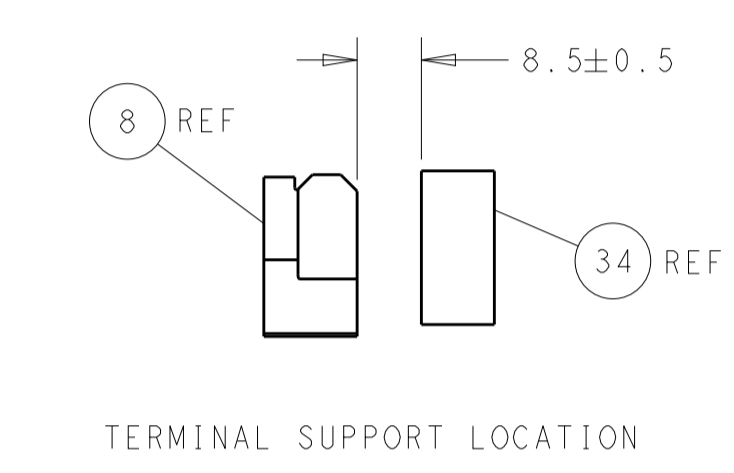
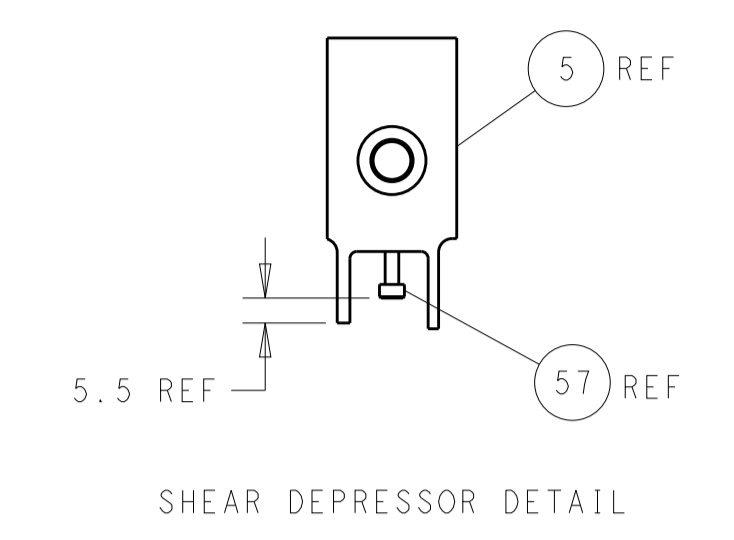
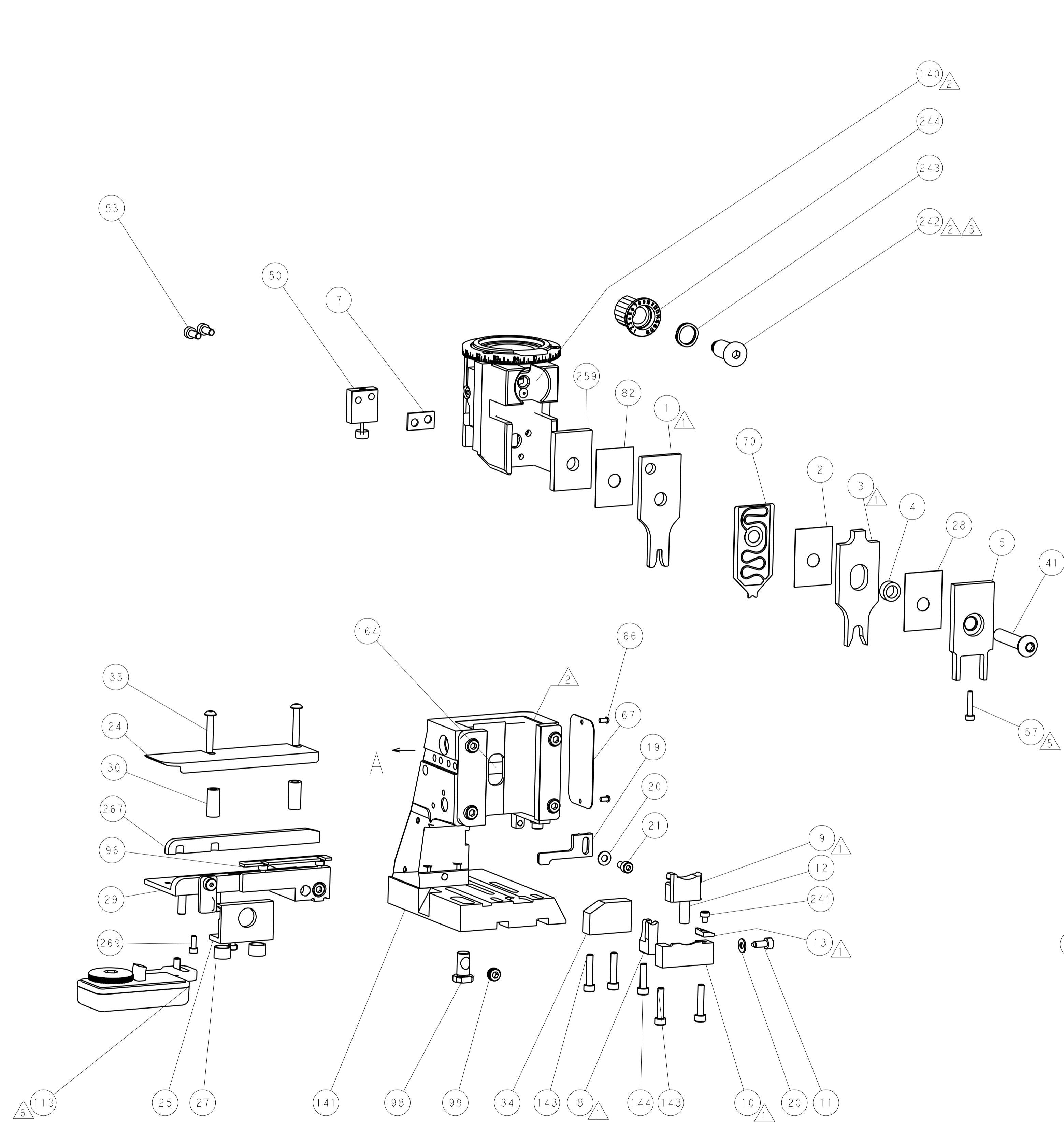
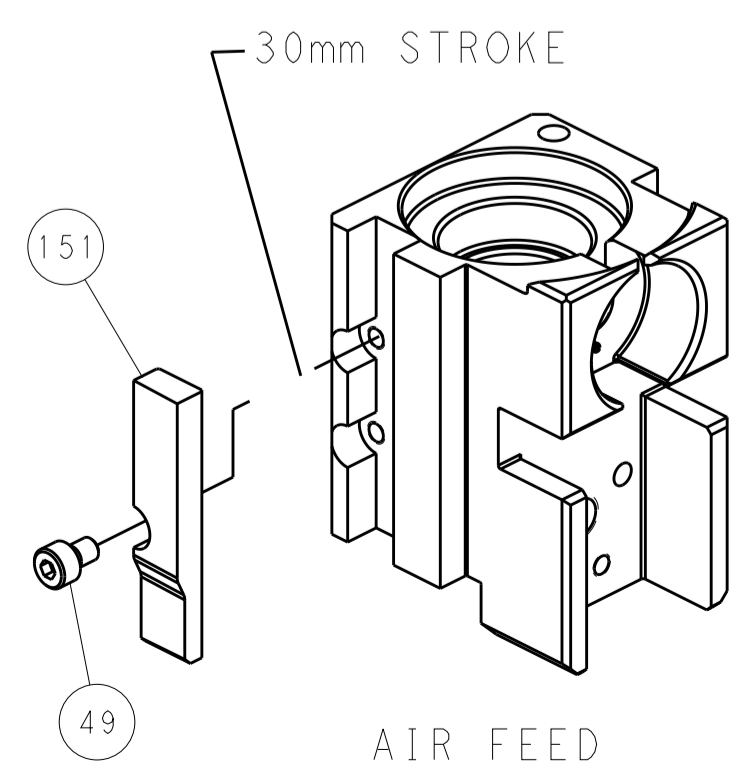
### FEED TYPE PNEUMATIC



### 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)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN: M_HERR 29MAR2017		TE Connectivity	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	Harrisburg, PA 17105-3608	
	ANGLES	FINISH		APVD: T_ELFIN 29MAR2017		NAME: Ocean Side Feed Applicator	
MATERIAL:				PRODUCT SPEC:		SIZE: CAGE CODE: DRAWING NO:	
				APPLICATION SPEC:		A1 00779 ©=2836671	
				WEIGHT:		RESTRICTED TO:	
				Customer Accessible Production Drawing		SCALE: 1:2 SHEET 4 OF 4 REV B	