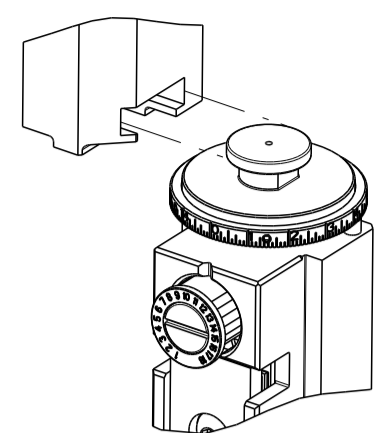


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2836038-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2836038-2	C	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2836038-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER

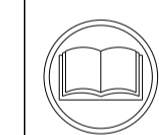


APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	5.30 mm [.209]	F
INSUL	6.90 mm [.272]	F

APPLICATOR INSTRUCTIONS 408-35042

TERMINAL DATA: LEAR TERMINAL		LEAR CRIMP SPECIFICATION	
TERMINAL NAME: MAK [PLUS] 8.0x0.8/9.5x1.2			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
8.11-8.87 mm [.319-.349 IN]		Ø4.00-6.00 mm [.157-.236 IN]	
TERMINAL APPLICATION SPECIFICATION	28223 Rev 5	-	-
TERMINALS APPLIED			
TE TERMINAL	LEAR TERMINAL	TE TERMINAL	LEAR TERMINAL
2113899-1	28223.306.710	2113899-2	28223.306.179
6-1579022-2	6-1579022-2		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
FLRY 10mm <sup>2</sup>	3.30 +/- 0.10 [.130 +/- .004]	5.7
FLRY 6mm <sup>2</sup>	3.00 +/- 0.05 [.118 +/- .002]	8.7



- RECOMMENDED SPARE PARTS
- REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242.
- 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.
- CUT TO LENGTH AT ASSEMBLY.
- 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.

LOC	DIST	REVISIONS					
A	66	P	LTN	DESCRIPTION	DATE	OWN	APVD
		A		RELEASED	23DEC2015	MR	TE
		B		ECR-17-016023	31OCT2017	KH	CT
		C		ECR-20-000469	11JAN2020	TB	RK

-	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	269	
-	1	1	1633782-3	FENCE	267	
-	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	
	-	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	
-	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	318563-1	GUARD, FRONT CHIP	89	
	-	2	2079383-4	SCR, BHSC, RoHS (M4 X 8)	79	
-	1	1	1803096-1	EXTENSION PLATE	78	
-	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	
-	1	1	1-1338683-1	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	811242-6	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	5-1752356-0	SUPPORT, TERMINAL	34	
-	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33	
-	2	2	3-2844962-5	SPACER, CYLINDRICAL, STRIP GUIDE	30	
-	1	1	2844992-6	ASSEMBLY, STRIP GUIDE	29	
-	1	1	455888-5	SPACER, CRIMPER	28	
-	2	2	22283-1	SPRING, COMPRESSION	27	
-	1	1	240792-1	DRAG, TERMINAL	25	
-	1	1	1320928-4	STRIP GUIDE	24	
-	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	1803013-1	STRIPPER, SIDE FEED	19	
	-	1	1	2119806-1	INSERT, SHEAR	13
-	1	1	5-22280-0	SPRING, COMPRESSION	12	
-	1	1	1-356885-3	STOP, SHEAR	11	
	-	1	1	1-2119805-0	SHEAR HOLDER, FRONT	10
	-	1	1	1-318059-0	FLOATING SHEAR, FRONT	9
	1	2	1	1803320-1	ANVIL, COMBINATION	8
-	-	-	-	-	7	
-	-	-	-	-	6	
-	1	1	1803080-1	DEPRESSOR, SHEAR	5	
-	1	1	5-238011-7	BLOCK, CRIMPER SPACER	4	
	1	2	1	5-1803187-6	CRIMPER, INSULATION F	3
-	1	1	2-455888-5	SPACER, CRIMPER	2	
	1	2	1	1803087-2	CRIMPER, WIRE	1

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

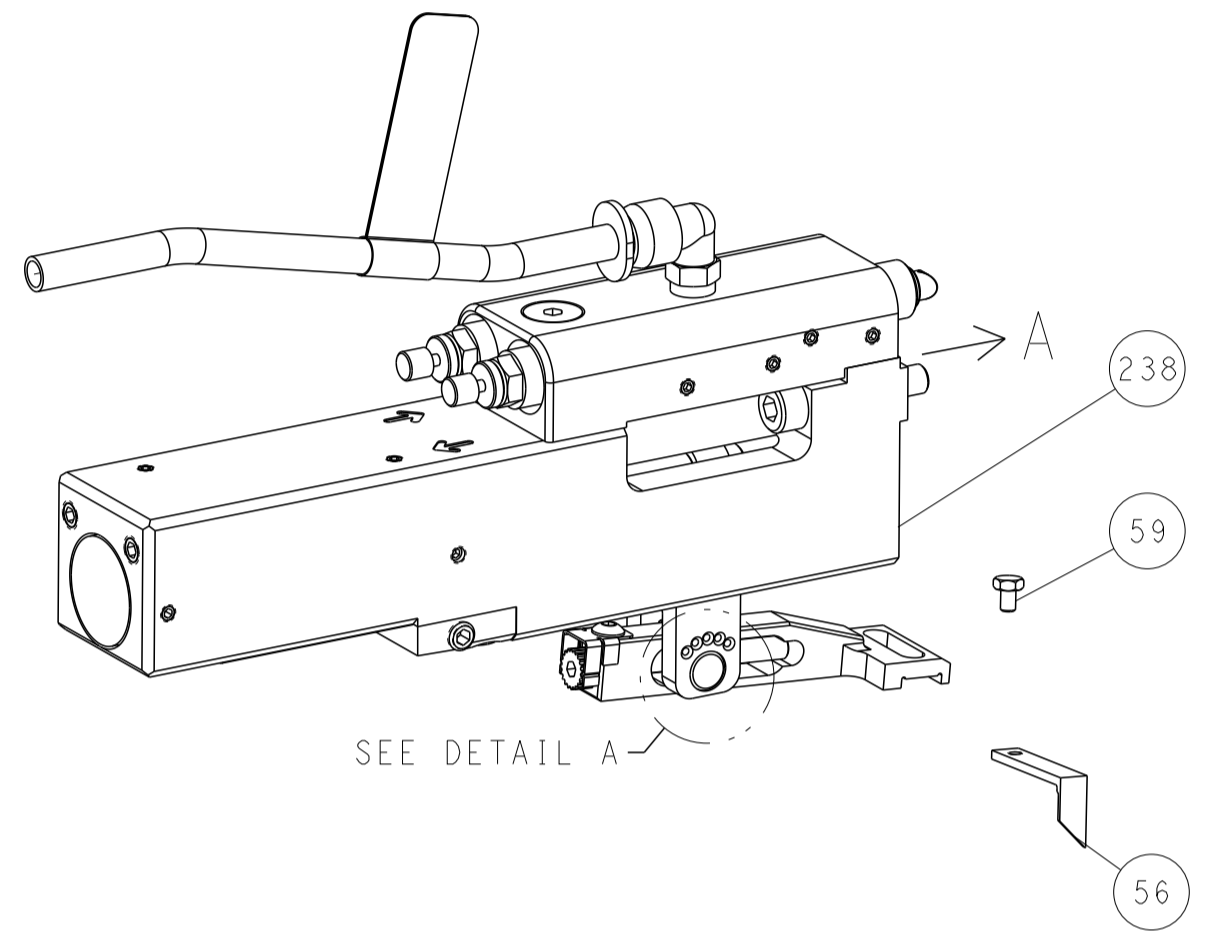
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		MATERIAL:		FINISH:	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES ±	FINISH ±

OWN	D. WEAVER	16OCT2015	CHK	T. ELBIN	16OCT2015	APVD	T. ELBIN	16OCT2015
NAME		Ocean Side Feed Applicator		SIZE		CAGE CODE		DRAWING NO
				A1		00779		2836038
Customer Accessible Production Drawing				SCALE		SHEET		1 OF 4
				REV		C		

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

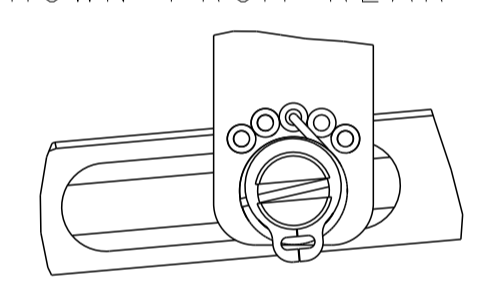
# FEED TYPE

## PNEUMATIC



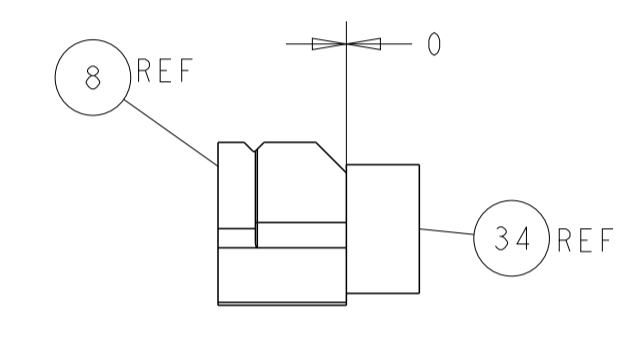
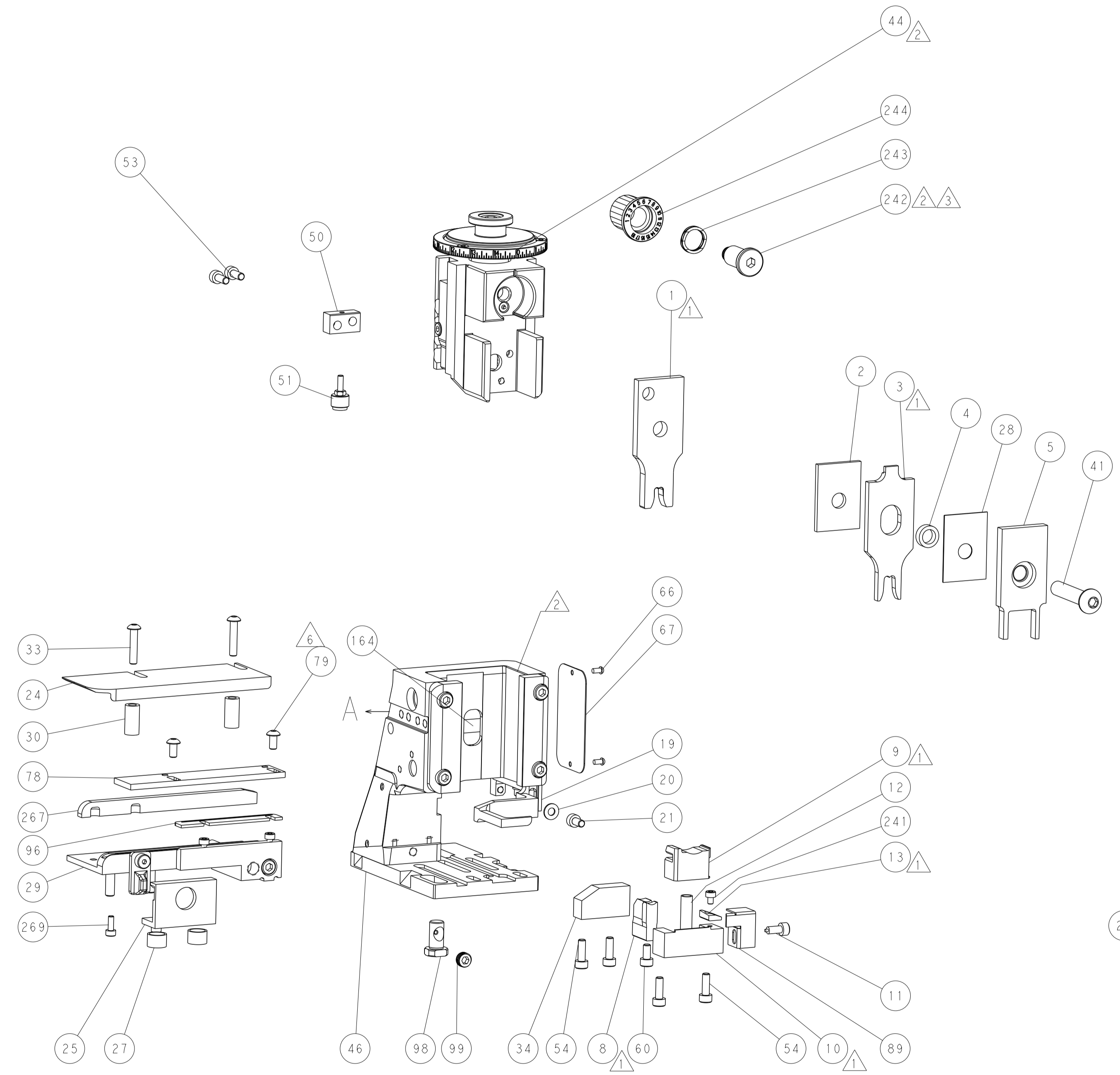
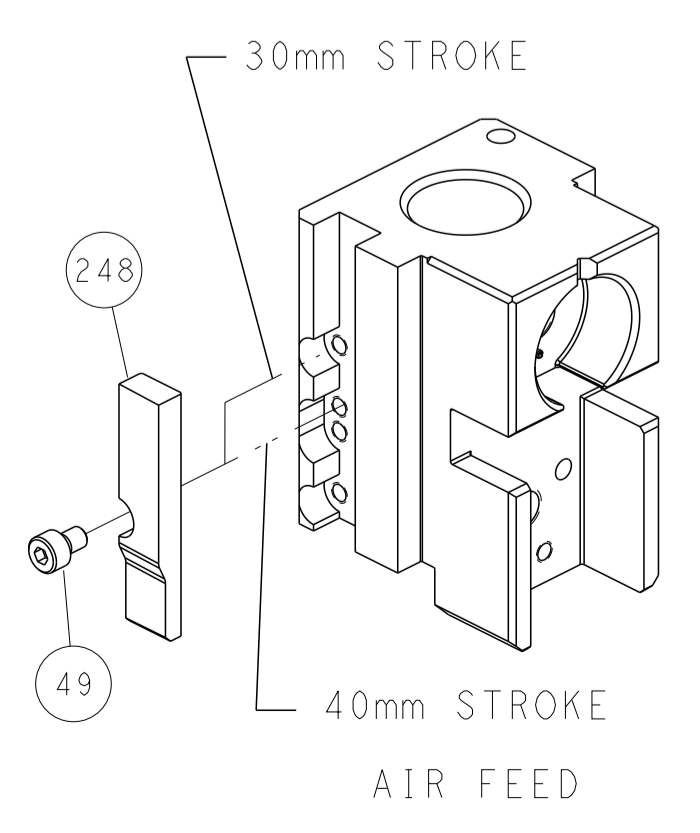
SEE DETAIL A

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

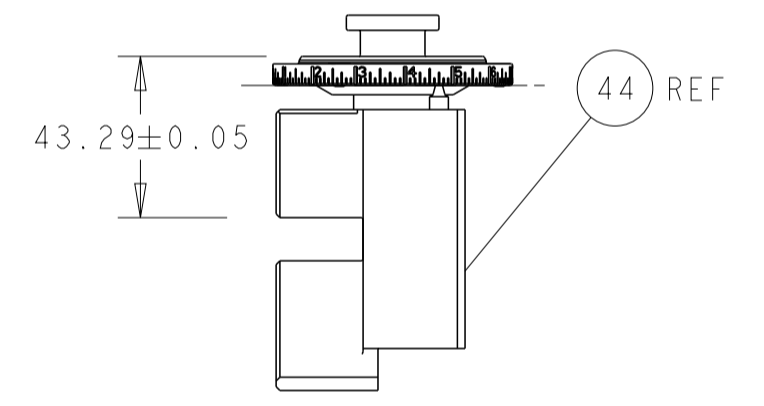


DETAIL A

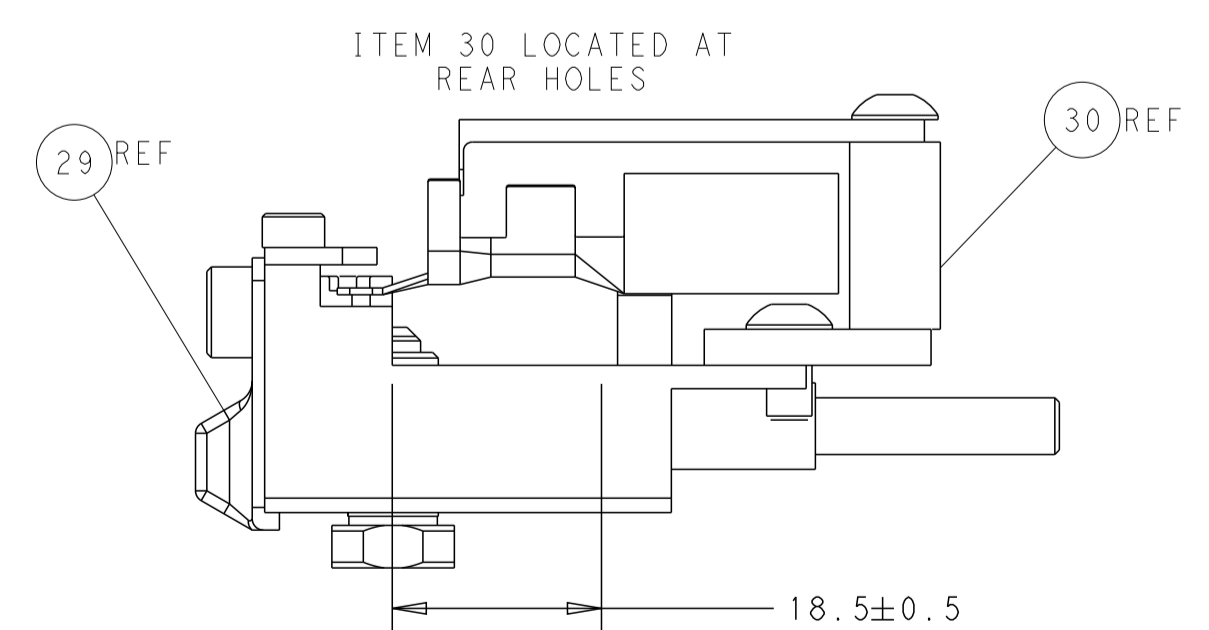
## CAM POSITION



TERMINAL SUPPORT LOCATION



RAM SET-UP



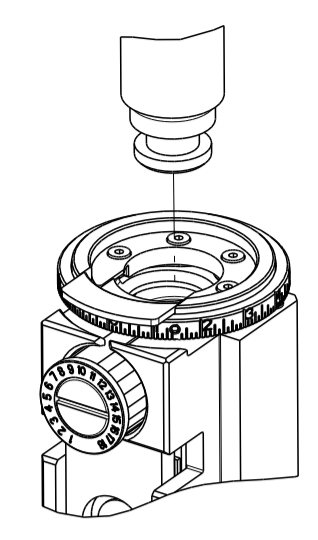
FEED TRACK POSITION  
GUIDE BY INSULATION BARREL

**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:		OWN: B. WEAVER 16OCT2015	TE Connectivity Harrisburg, PA 17105-3608
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	
	4 PLC ±	ANGLES ±	FINISH ±	APVD: T. ELBIN 16OCT2015	NAME: Ocean Side Feed Applicator
MATERIAL:				PRODUCT SPEC	
				APPLICATION SPEC	SIZE: CAGE CODE: DRAWING NO: RESTRICTED TO
				WEIGHT: A1 00779 C=2836038	SCALE: 1:2 SHEET 2 OF 4 REV C
Customer Accessible Production Drawing				Customer Accessible Production Drawing	

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2836038-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2836038-7	A	CRIMP TOOLING KIT	-

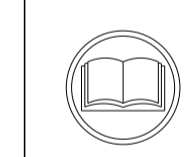
PACIFIC VERSION TERMINATOR  
 INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	5.30 mm [.209]	F
INSUL	6.90 mm [.272]	F
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: LEAR TERMINAL		LEAR CRIMP SPECIFICATION	
TERMINAL NAME: MAK [PLUS] 8.0x0.8/9.5x1.2			
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE		
8.11-8.87 mm [.319-.349 IN]	Ø4.00-6.00 mm [1.57-.236 IN]		
TERMINAL APPLICATION SPECIFICATION	28223 Rev 5		
TERMINALS APPLIED			
TE TERMINAL	LEAR TERMINAL	TE TERMINAL	LEAR TERMINAL
2113899-1	28223.306.710	2113899-2	28223.306.179
6-1579022-2	6-1579022-2		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
FLRY 10mm <sup>2</sup>	3.30+/-0.10 [.130+/-0.004]	5.7
FLRY 6mm <sup>2</sup>	3.00+/-0.05 [.118+/-0.002]	8.7



**\*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 CUT TO LENGTH AT ASSEMBLY.
- 7 TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.

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

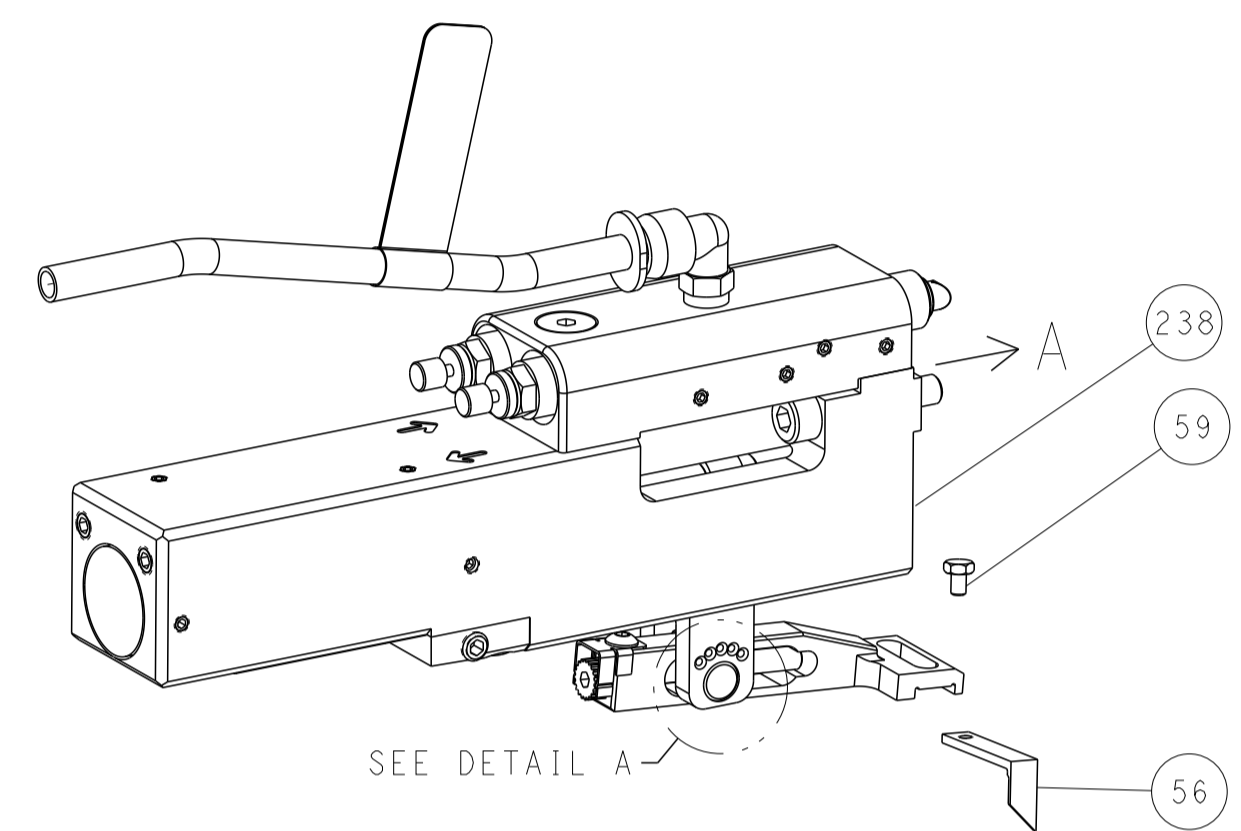
-	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	269	
-	1	1633782-3	FENCE	267	
-	1	2119082-2	CAM, SNAIL, INSULATION ADJUSTMENT	244	
-	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243	
3	-	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241	
-	1	2844940-2	AIR FEED MODULE	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	
-	1	2844908-1	SCREW, LOCKING	99	
-	1	2844907-1	POST, LOCKING	98	
-	1	1-690438-0	FRONT STRIP GUIDE	96	
-	1	318563-1	GUARD, FRONT CHIP	89	
6	-	2	2079383-4	SCR, BHSC, RoHS (M4 X 8)	79
-	1	1803096-1	EXTENSION PLATE	78	
-	1	1803607-3	DOCUMENTATION PACKAGE	71	
-	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	
-	1	1-1338683-1	FEED PAWL	56	
-	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	53	
-	1	811242-6	BUMPER, HOLD DOWN	51	
-	1	690753-2	SPACER, TONKER	50	
-	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49	
-	1	1803602-2	SCR, BHSC, RoHS (M8 X 40)	41	
-	1	5-1752356-0	SUPPORT, TERMINAL	34	
-	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33	
-	2	3-2844962-5	SPACER, CYLINDRICAL, STRIP GUIDE	30	
-	1	2844992-6	ASSEMBLY, STRIP GUIDE	29	
-	1	455888-5	SPACER, CRIMPER	28	
-	2	22283-1	SPRING, COMPRESSION	27	
-	1	240792-1	DRAG, TERMINAL	25	
-	1	1320928-4	STRIP GUIDE	24	
-	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21	
-	1	1-18028-2	WASHER, FLAT, REG M4	20	
-	1	1803013-1	STRIPPER, SIDE FEED	19	
1	-	1	2119806-1	INSERT, SHEAR	13
-	1	5-22280-0	SPRING, COMPRESSION	12	
-	1	1-356885-3	STOP, SHEAR	11	
1	-	1	1-2119805-0	SHEAR HOLDER, FRONT	10
1	-	1	1-318059-0	FLOATING SHEAR, FRONT	9
1	1	1	1803320-1	ANVIL, COMBINATION	8
-	-	-	-	7	
-	-	-	-	6	
-	1	1803080-1	DEPRESSOR, SHEAR	5	
-	1	5-238011-7	BLOCK, CRIMPER SPACER	4	
1	1	1	5-1803187-6	CRIMPER, INSULATION F	3
-	1	2-455888-5	SPACER, CRIMPER	2	
1	1	1	1803087-2	CRIMPER, WIRE	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)

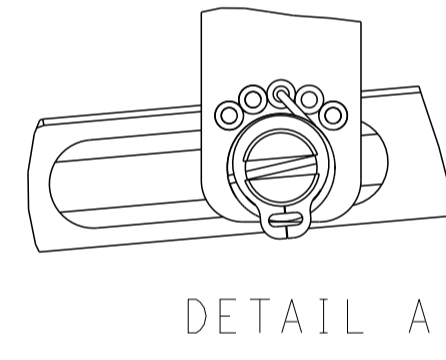
DIMENSIONS:	TOLERANCES UNLESS OTHERWISE SPECIFIED:	DRAWING NO	SCALE	SHEET	OF	REV
mm	0 PLC ±.1 1 PLC ±.2 2 PLC ±.3 3 PLC ±.4 4 PLC ±.5 ANGLES ±.1	160CT2015	1:2	3	4	C
MATERIAL:	FINISH:	WEIGHT:	A	00779	C=2836038	
Customer Accessible Production Drawing			Customer Accessible Production Drawing			

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

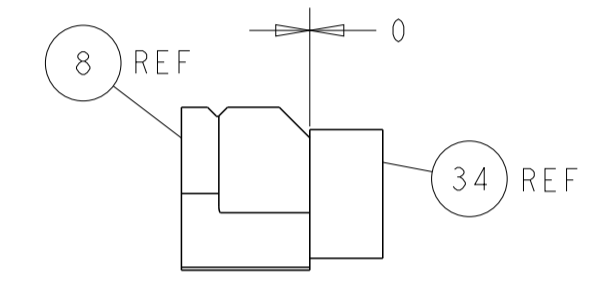
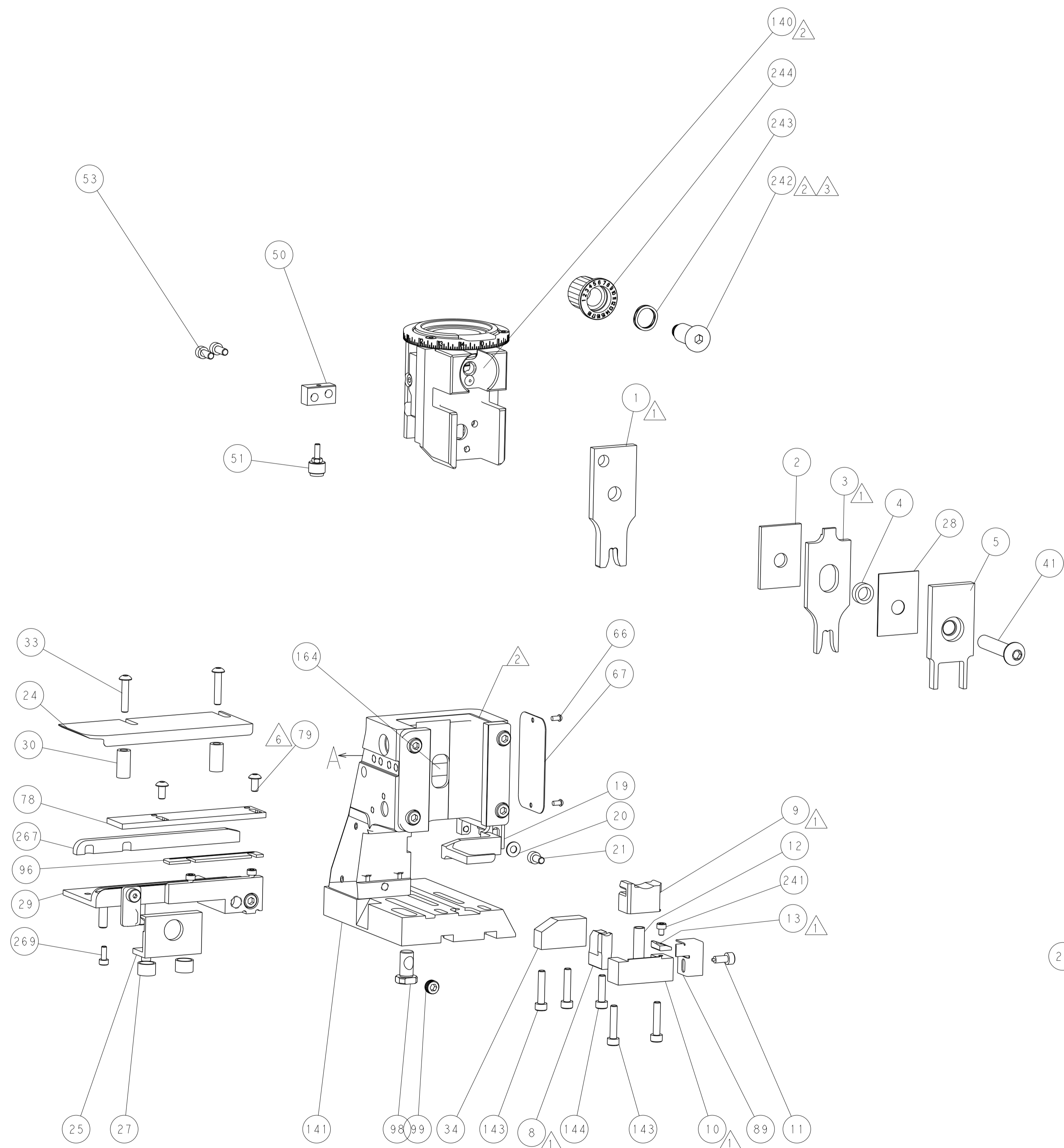
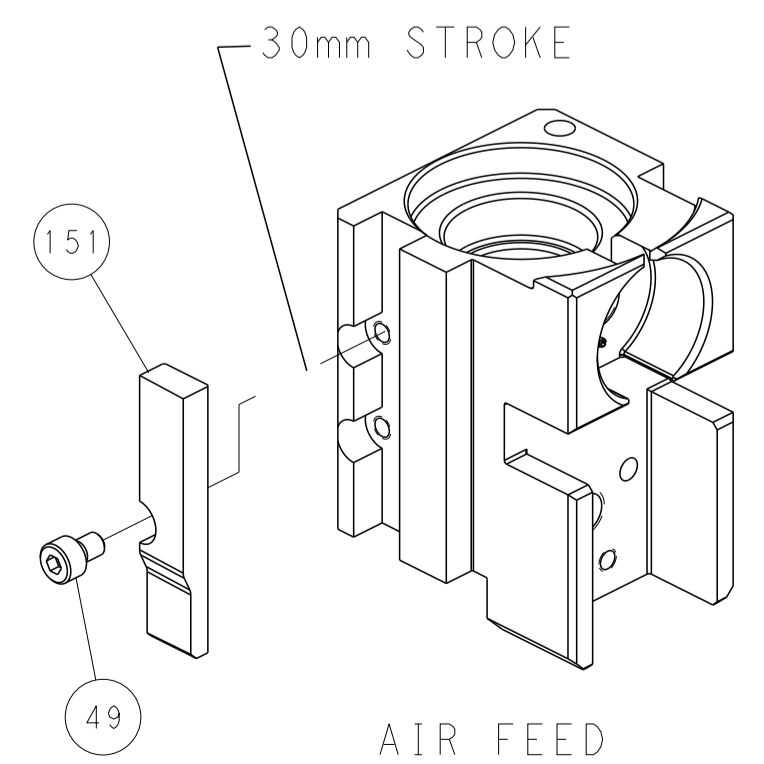
### FEED TYPE PNEUMATIC



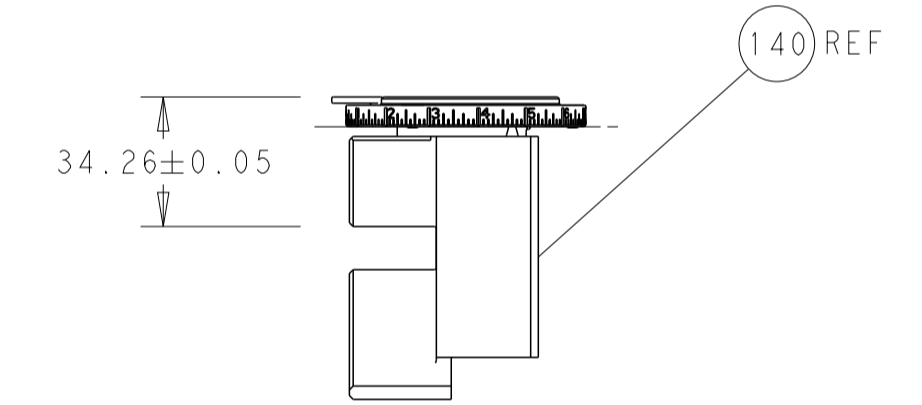
### FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



### CAM POSITION

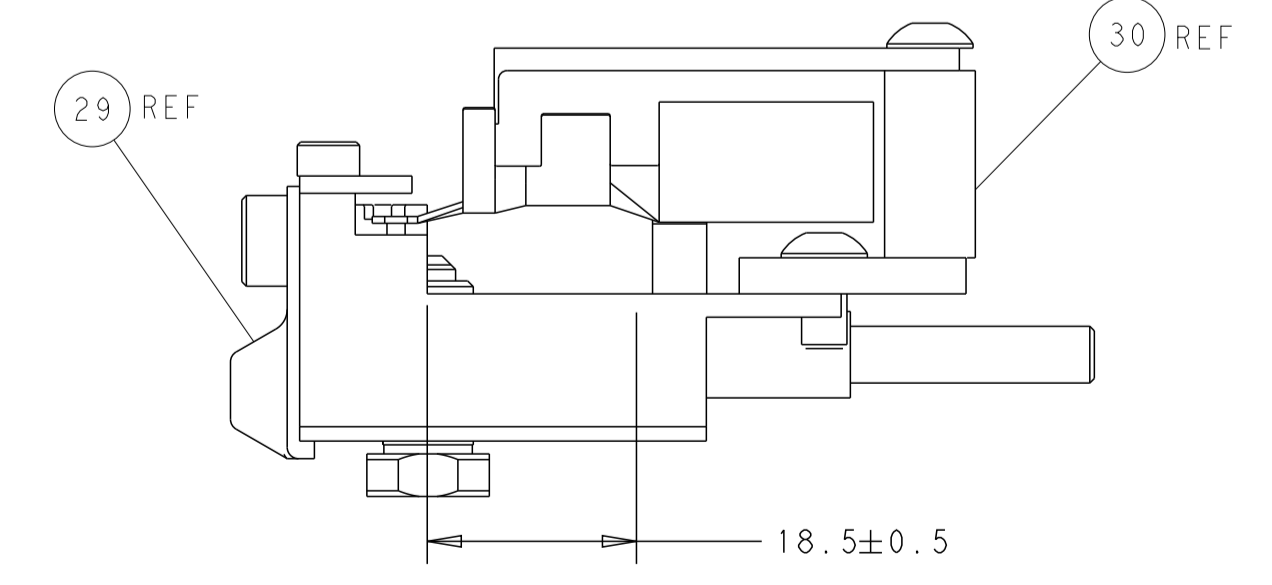


TERMINAL SUPPORT LOCATION



RAM SET-UP

ITEM 30 LOCATED AT REAR HOLES



FEED TRACK POSITION GUIDE BY INSULATION BARREL

**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 2015. COPYRIGHT 2015 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.</small>		DWN B. WEAVER 16OCT2015 CHK T. ELBIN 16OCT2015 APVD T. ELBIN 16OCT2015	TE Connectivity Harrisburg, PA 17105-3608
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 CAGE CODE DRAWING NO. A1 00779 C=2836038 WEIGHT Customer Accessible Production Drawing	RESTRICTED TO SCALE 1:2 SHEET 4 OF 4 REV C