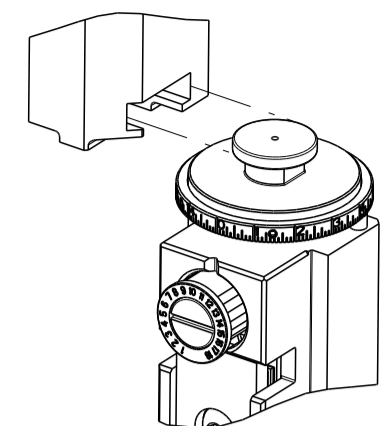


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2836138-1	H	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2836138-2	H	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2836138-1	H	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2836138-2	H	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2836138-7	F	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.40 mm [.055]	F
INSUL	2.75 mm [.108]	OV

APPLICATOR INSTRUCTIONS 408-35042

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: AMP POWER DBL LOCK CONN, REC. CONTACT			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
3.00-4.00 mm [.118-.157 IN]		∅ 1.30-2.00 mm [.051-.079 IN]	
TERMINAL APPLICATION SPECIFICATION	(A)114-5175		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
(A) 177914-1	(A) 177914-2	(A) 177916-1	

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: AMP POWER DBL LOCK CONN, REC. CONTACT			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
3.00-4.00 mm [.118-.157 IN]		∅ 1.30-2.00 mm [.051-.079 IN]	
TERMINAL APPLICATION SPECIFICATION	(A)114-5175		
	(B)114-61016		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
(B) 1743728-1	(A) 2232902-1	(A) 2369501-1	

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
2 x 24AWG OR 2 x 0.22mm ²	0.91+/-0.05 [.036+/- .002]	2.6
22 AWG OR 0.34mm ²	0.89+/-0.05 [.035+/- .002]	2.9
24 AWG OR 0.22mm ²	0.85+/-0.05 [.033+/- .002]	3.4
26 AWG OR 0.14mm ²	0.80+/-0.05 [.031+/- .002]	3.9

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
22 AWG OR 0.34mm ²	0.89+/-0.05 [.035+/- .002]	2.9
24 AWG OR 0.22mm ²	0.85+/-0.05 [.033+/- .002]	3.4
26 AWG OR 0.14mm ²	0.80+/-0.05 [.031+/- .002]	3.9

- 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.
- TERMINAL LUBRICANT IS RECOMMENDED.
- 6. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- ∅ 1.52-2.00mm [.060-.079IN] FOR SINGLE WIRES
∅ 1.4 MAX X2 [.055IN MAX X2] FOR DOUBLE WIRES.

***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	REV	DATE	BY	CHK
		E	19NOV2021	FJ	RK
		F	05MAY2022	FJ	TE
		G	19AUG2022	FJ	TE
		H	16JAN2023	FZ	JAH

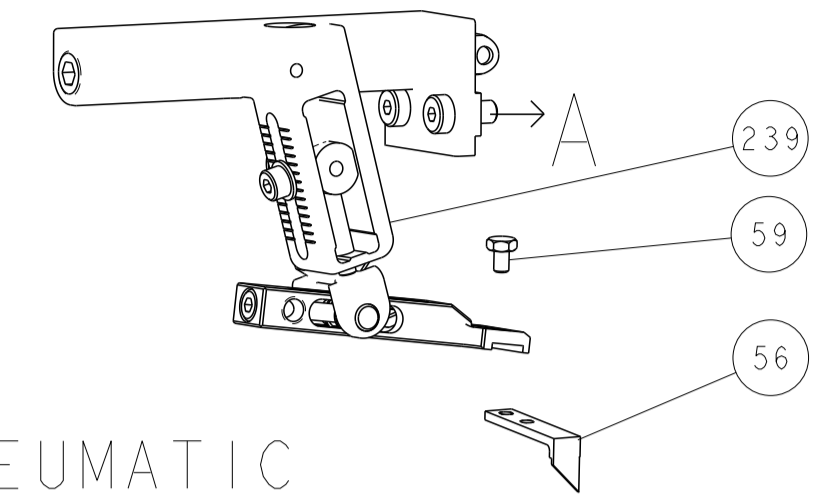
-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248
-	1	1	1	1	2119082-5	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	1	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
-	-	-	-	-	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	1	-	1	-	2844940-1	AIR FEED MODULE	238
-	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
	1	1	1	1	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113
-	1	1	1	1	2844908-1	SCREW, LOCKING	99
-	1	1	1	1	2844907-1	POST, LOCKING	98
-	1	1	1	1	455888-4	SPACER, CRIMPER	82
-	1	1	1	1	1803607-3	DOCUMENTATION PACKAGE	71
-	1	1	1	1	2119791-5	DEPRESSOR, WIRE	70
-	1	1	1	1	2119943-1	WASHER, SPACER	69
-	1	1	1	1	2119740-1	TAG, IDENTIFICATION	67
-	2	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	1	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	60
-	1	1	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	1	1	1	1	1338685-1	PAWL, FEED	56
-	4	4	4	4	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	54
-	2	2	2	2	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	53
-	1	1	1	1	1803382-1	HOLD DOWN, SPRING LOADED	50
-	1	2	1	2	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	-	-	-	-	2119652-1	FEED CAM, PRE FEED	48
-	-	-	-	-	2119653-1	FEED CAM, POST FEED	47
-	1	1	1	1	1803583-9	APPLICATOR BASIC ASSEMBLY, SF	46
-	1	1	1	1	1803515-1	RAM ASSEMBLY, SF ATLANTIC	44
-	1	1	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
-	1	1	1	1	2-1752356-5	SUPPORT, TERMINAL	34
-	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	2	2	2-2844962-8	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29
-	1	1	1	1	455888-5	SPACER, CRIMPER	28
-	1	1	1	1	1320928-2	STRIP GUIDE	24
-	1	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
-	2	2	2	2	1-18028-2	WASHER, FLAT, REG M4	20
-	1	1	1	1	2119533-1	STRIPPER, SIDE FEED	19
	1	1	1	1	1633988-1	CRIMPER, INSULATION BOX PREMIUM	14
	1	1	1	1	2119806-1	INSERT, SHEAR	13
-	1	1	1	1	3-22280-3	SPRING, COMPRESSION	12
-	1	1	1	1	1-356885-4	STOP, SHEAR	11
	1	1	1	1	2119805-1	SHEAR HOLDER, FRONT	10
	1	1	1	1	1803095-6	FLOATING SHEAR, FRONT	9
	1	2	2	1	4-1633128-4	ANVIL, COMBINATION .055	8
-	1	1	1	1	240641-9	SPACER	7
-	-	-	-	-	-	-	6
-	1	1	1	1	2119757-4	DEPRESSOR, SHEAR	5
-	1	1	1	1	238011-9	BLOCK, CRIMPER SPACER	4
	1	2	2	1	8-2119785-4	CRIMPER, INSULATION OVERLAP PREMIUM	3
-	1	1	1	1	455888-3	SPACER, CRIMPER	2
	1	2	2	1	456402-1	CRIMPER, WIRE PREMIUM	1

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		MATERIAL:		FINISH:		WEIGHT:		SCALE:	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES	FINISH	WT	SCALE	SHEET	REV
									1:2	1 OF 4	H

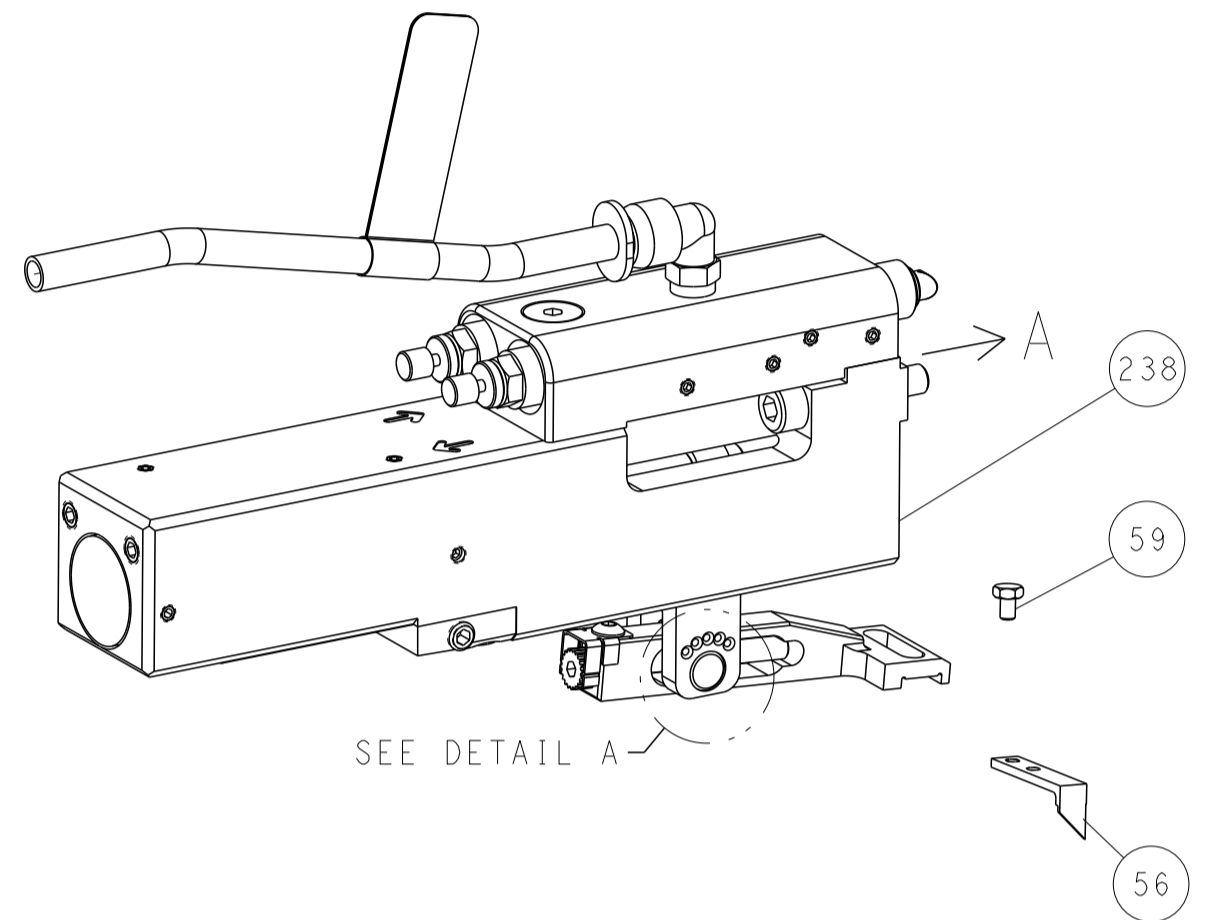
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

LOC	DIST	REV	DATE	BY	APPV
A	66				

FEED TYPE MECHANICAL



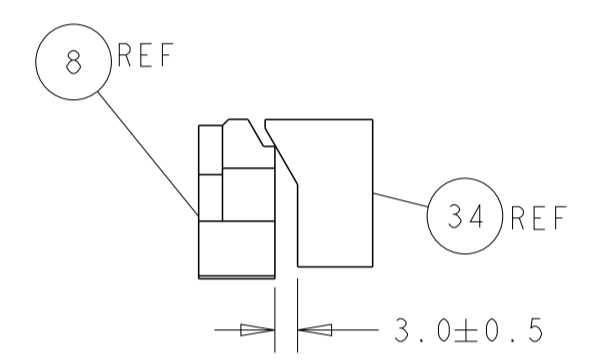
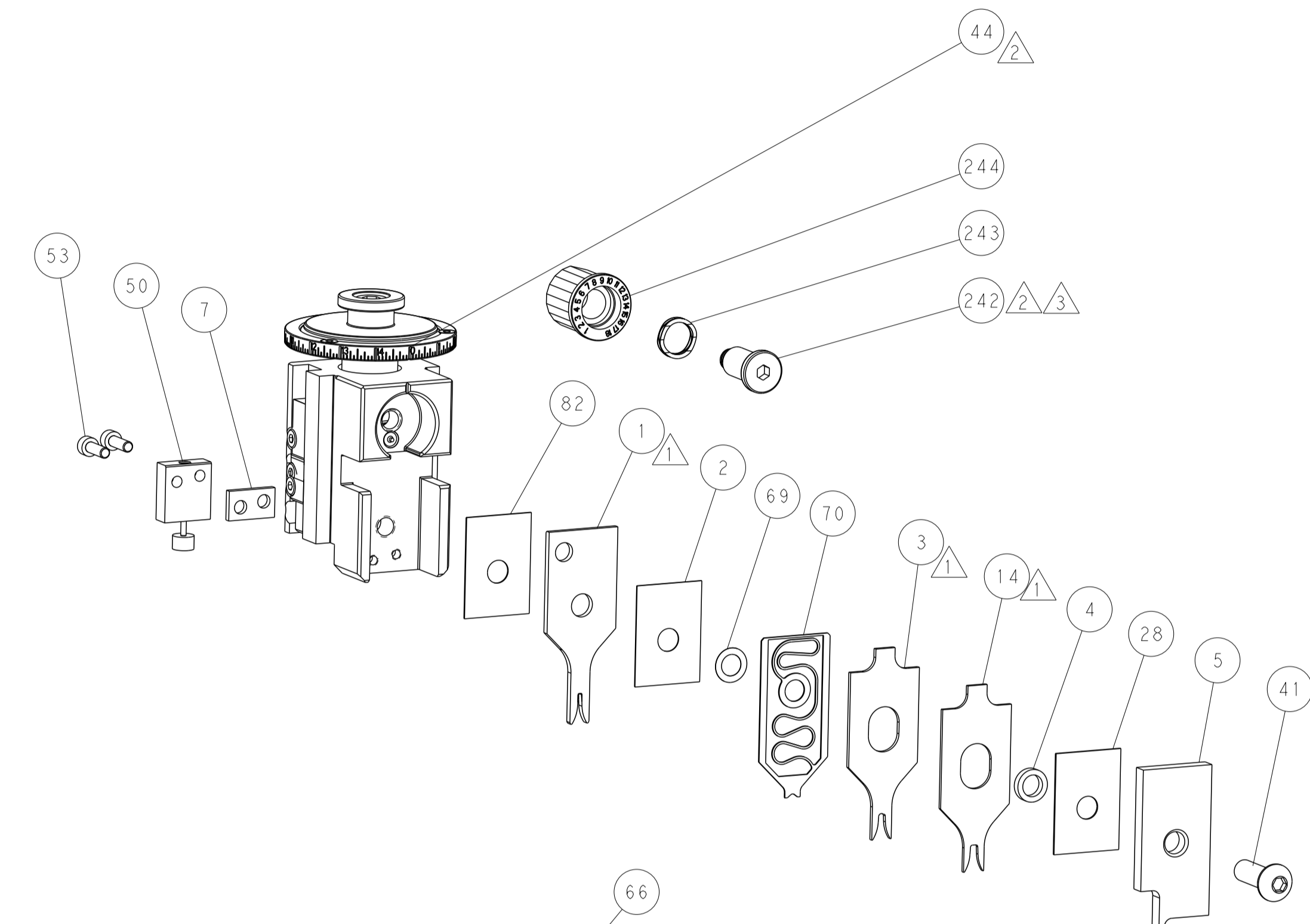
PNEUMATIC



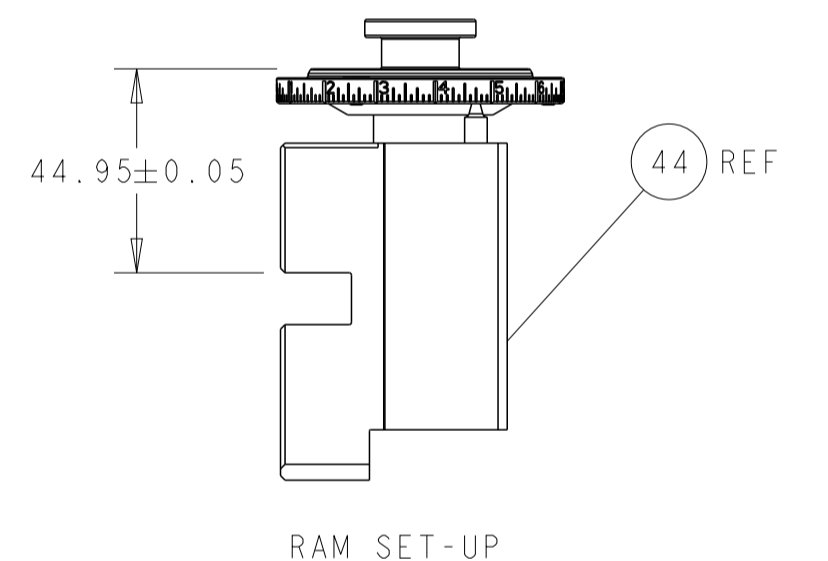
FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



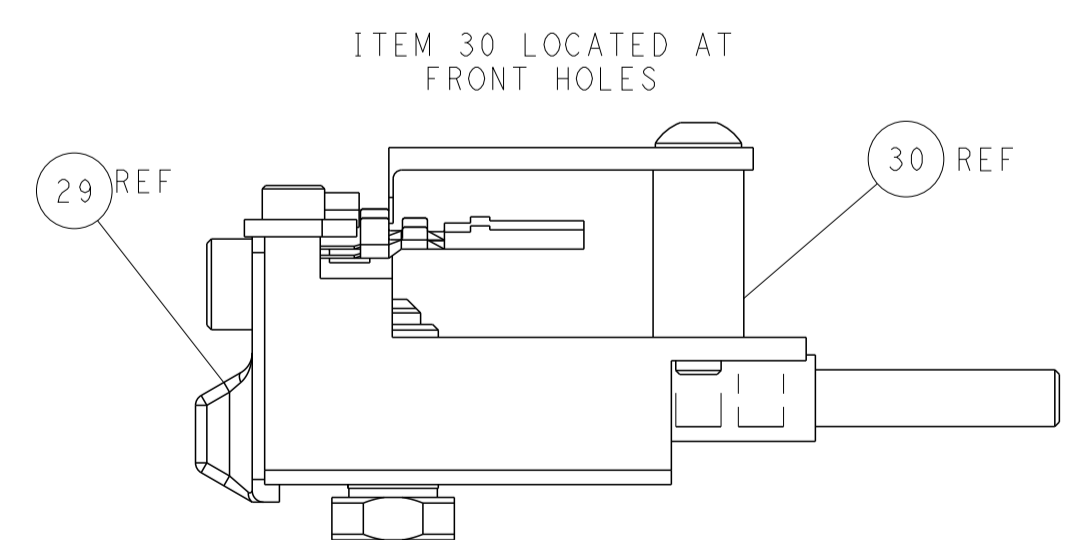
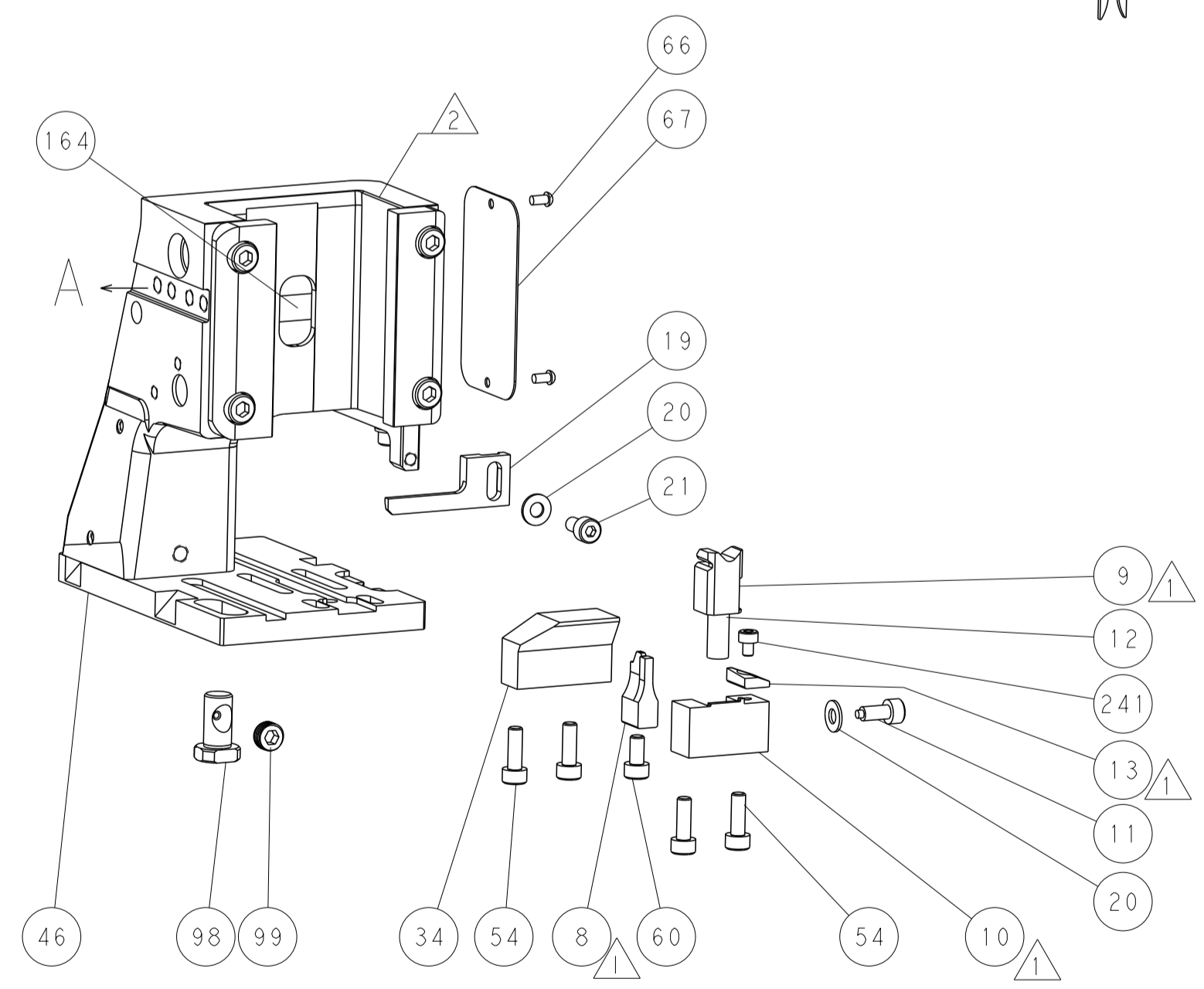
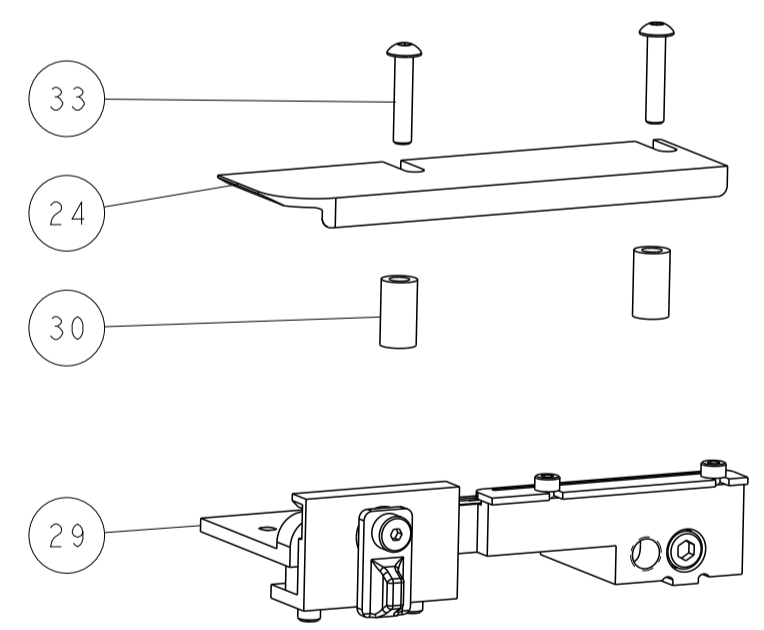
DETAIL A



TERMINAL SUPPORT LOCATION

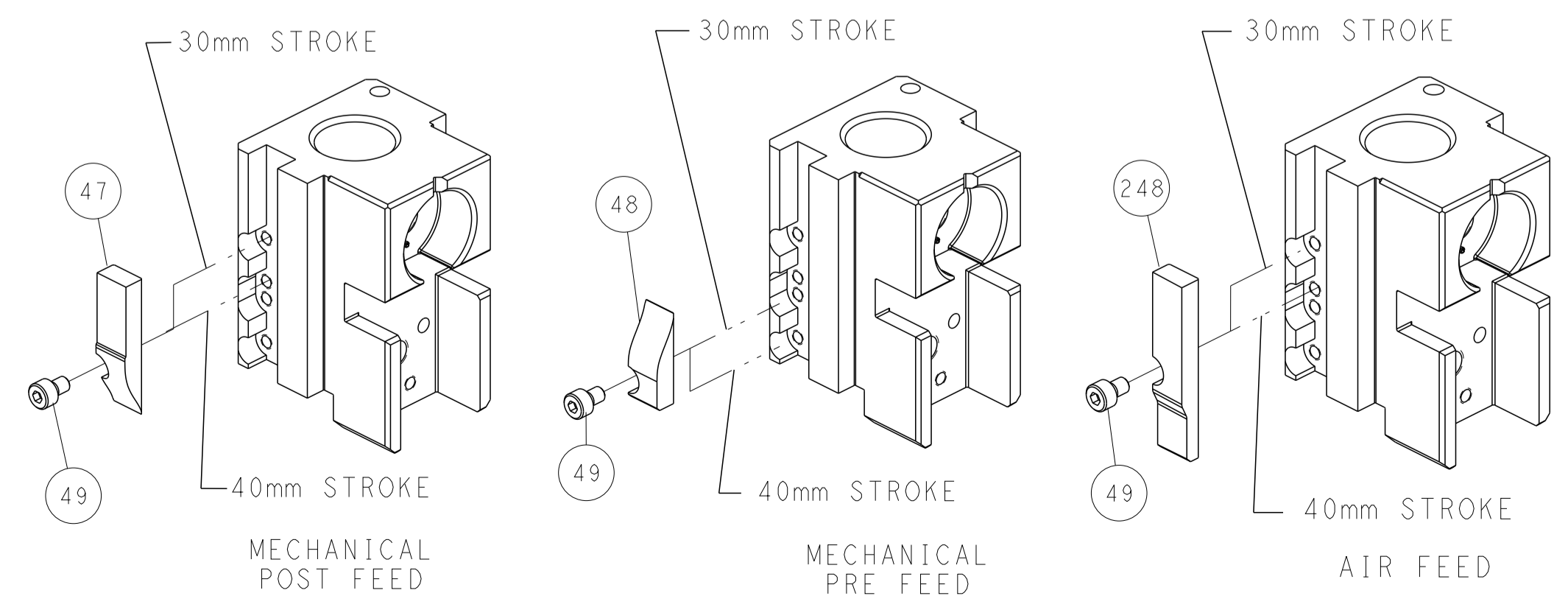


RAM SET-UP



ITEM 30 LOCATED AT FRONT HOLES

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:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG: H. HUANG 26NOV2015		TE Connectivity	
mm		0 PLC ±		CHK: L. ZHANG 26NOV2015		Harrisburg, PA 17105-3608	
Ø		1 PLC ±		APPV: J. GUO 26NOV2015		NAME: Ocean Side Feed Applicator	
H		2 PLC ±		PRODUCT SPEC		SIZE: CAGE CODE: DRAWING NO: RESTRICTED TO	
D		3 PLC ±		APPLICATION SPEC		A1 00779 ©=2836138	
R		4 PLC ±		WEIGHT		SCALE: 1:2 SHEET 2 OF 4 REV H	
ANGLES		FINISH		Customer Accessible Production Drawing			

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2836138-1	H	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2836138-2	H	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2836138-7	F	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.40 mm [.055]	F
INSUL	2.75 mm [.108]	OV
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: AMP POWER DBL LOCK CONN, REC. CONTACT			
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE		
3.00-4.00 mm [.118-.157 IN]	∅ 1.30-2.00 mm [.051-.079 IN]		
TERMINAL APPLICATION SPECIFICATION	(A)114-5175	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
(A) 177914-1	(A) 177914-2	(A) 177916-1	

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: AMP POWER DBL LOCK CONN, REC. CONTACT			
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE		
3.00-4.00 mm [.118-.157 IN]	∅ 1.30-2.00 mm [.051-.079 IN]		
TERMINAL APPLICATION SPECIFICATION	(A)114-5175	-	-
	(B)114-61016	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
(B) 1743728-1	(A) 2232902-1	(A) 2369501-1	

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
2 x 24AWG OR 2 x 0.22mm ²	0.91+/-0.05 [.036+/- .002]	2.6
22 AWG OR 0.34mm ²	0.89+/-0.05 [.035+/- .002]	2.9
24 AWG OR 0.22mm ²	0.85+/-0.05 [.033+/- .002]	3.4
26 AWG OR 0.14mm ²	0.80+/-0.05 [.031+/- .002]	3.9

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
22 AWG OR 0.34mm ²	0.89+/-0.05 [.035+/- .002]	2.9
24 AWG OR 0.22mm ²	0.85+/-0.05 [.033+/- .002]	3.4
26 AWG OR 0.14mm ²	0.80+/-0.05 [.031+/- .002]	3.9

- △ 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.
- △ TERMINAL LUBRICANT IS RECOMMENDED.
- 6. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- △ ∅1.52-2.00mm [.060-.079IN] FOR SINGLE WIRES
∅1.4 MAX X2 [.055IN MAX X2] FOR DOUBLE WIRES.

***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	REV	DATE	BY	APPV
A	66	-	-	-	-

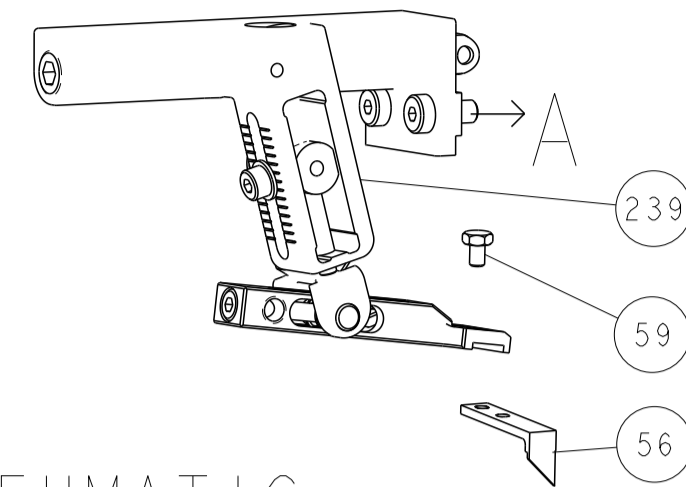
REV	DATE	BY	APPV	DESCRIPTION	ITEM NO
-	-	-	-	SEE SHEET 1	-
-	1	1	2119082-5	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
-	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	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
-	1	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	455888-4	SPACER, CRIMPER	82
-	1	1	1803607-3	DOCUMENTATION PACKAGE	71
-	1	1	2119791-5	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
-	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	1	1	1338685-1	PAWL, FEED	56
-	2	2	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	53
-	1	1	1803382-1	HOLD DOWN, SPRING LOADED	50
-	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	2-1752356-5	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	1633988-1	CRIMPER, INSULATION BOX PREMIUM	14
△	-	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	1803095-6	FLOATING SHEAR, FRONT	9
△	1	1	4-1633128-4	ANVIL, COMBINATION .055	8
-	1	1	240641-9	SPACER	7
-	-	-	-	-	6
-	1	1	2119757-4	DEPRESSOR, SHEAR	5
-	1	1	238011-9	BLOCK, CRIMPER SPACER	4
△	1	1	8-2119785-4	CRIMPER, INSULATION OVERLAP PREMIUM	3
-	1	1	455888-3	SPACER, CRIMPER	2
△	1	1	456402-1	CRIMPER, WIRE PREMIUM	1

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

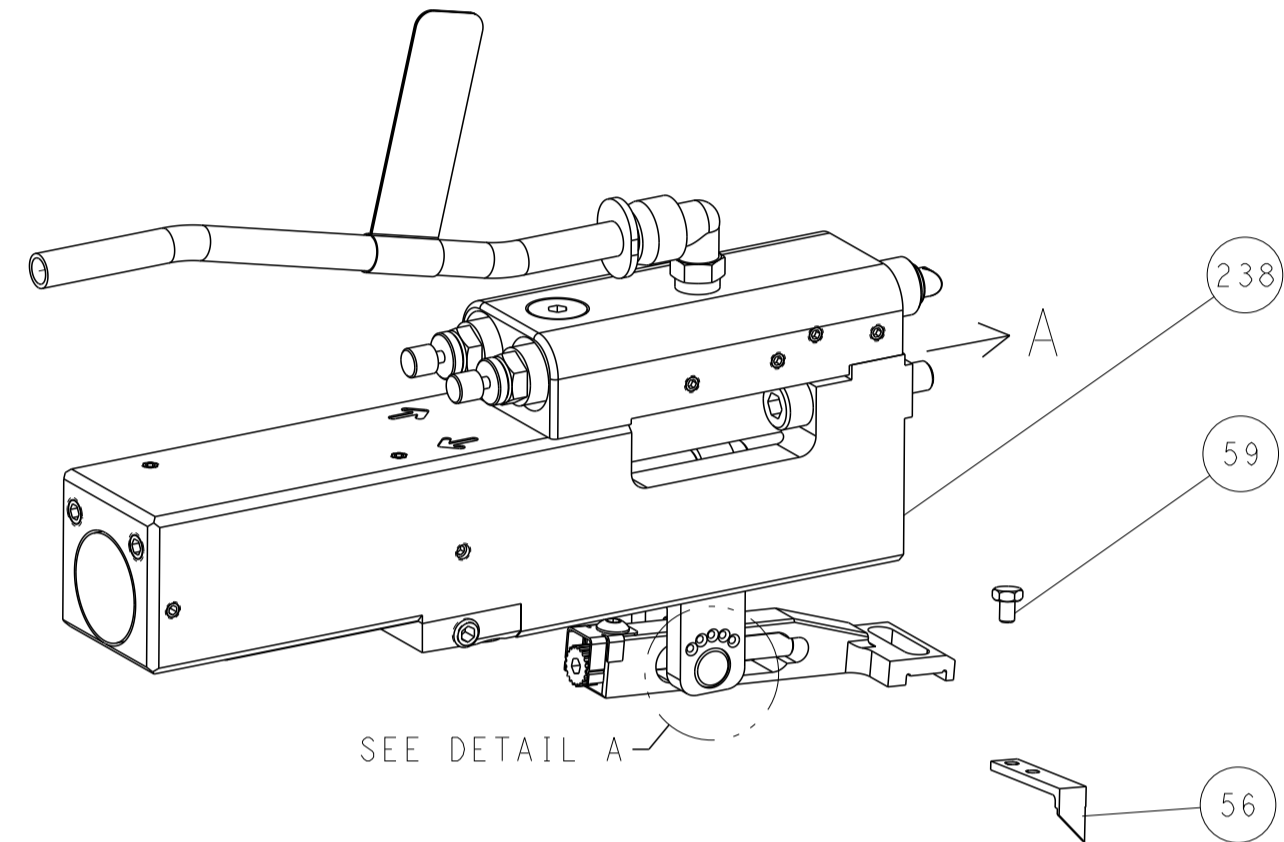
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mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES ±	FINISH	SIZE: A1	CAGE CODE: 00779	DRAWING NO: C=2836138	RESTRICTED TO: -
MATERIAL: -								WEIGHT: -	Customer Accessible Production Drawing		SCALE: 1:2
								SHEET 3 OF 4		REV H	

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

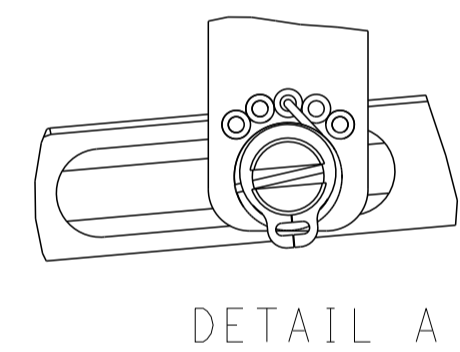
FEED TYPE MECHANICAL



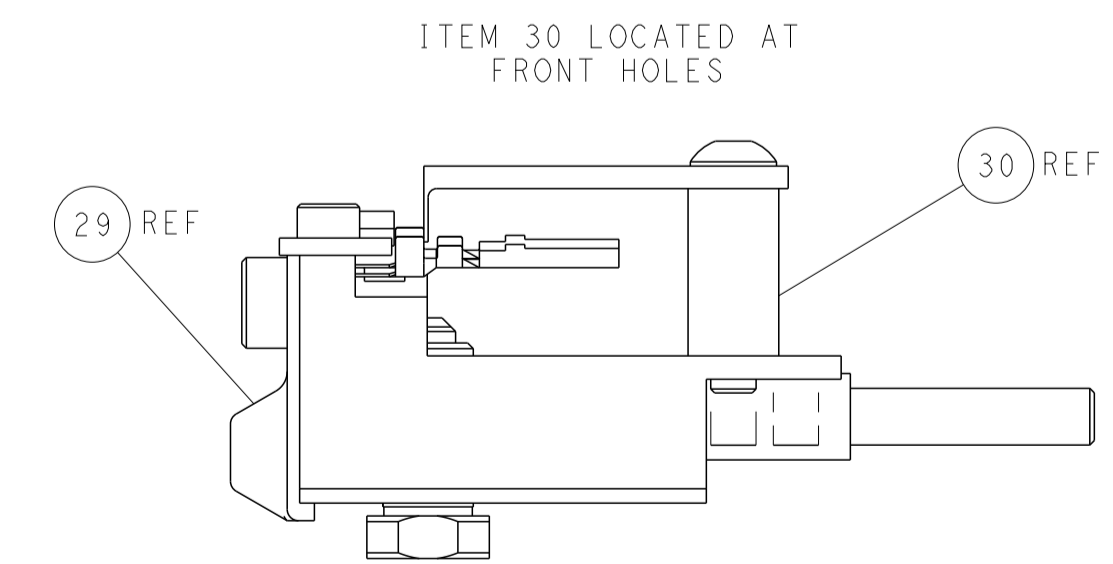
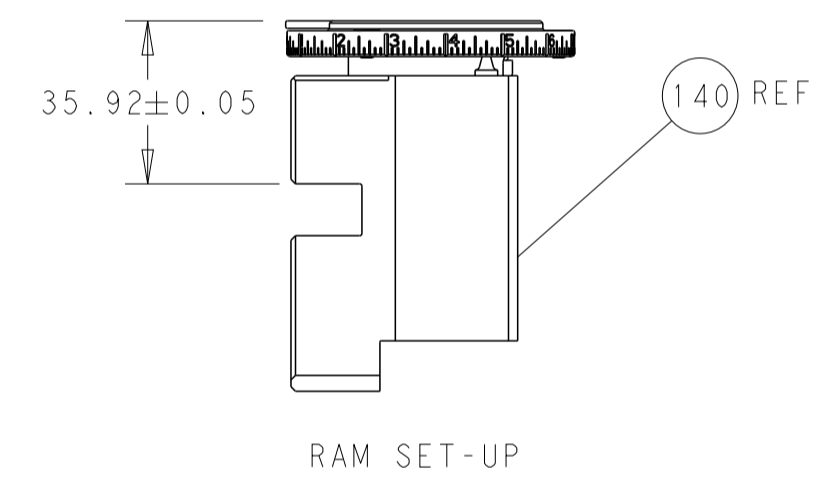
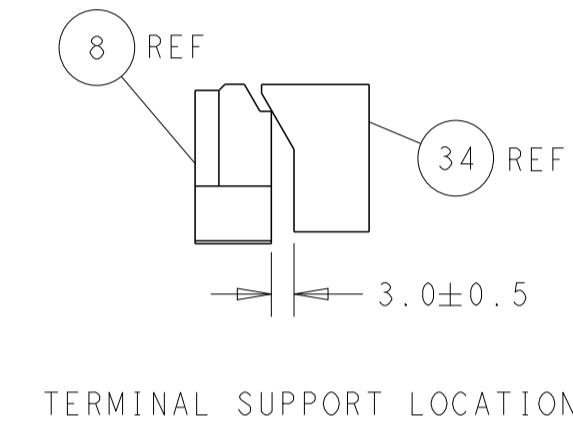
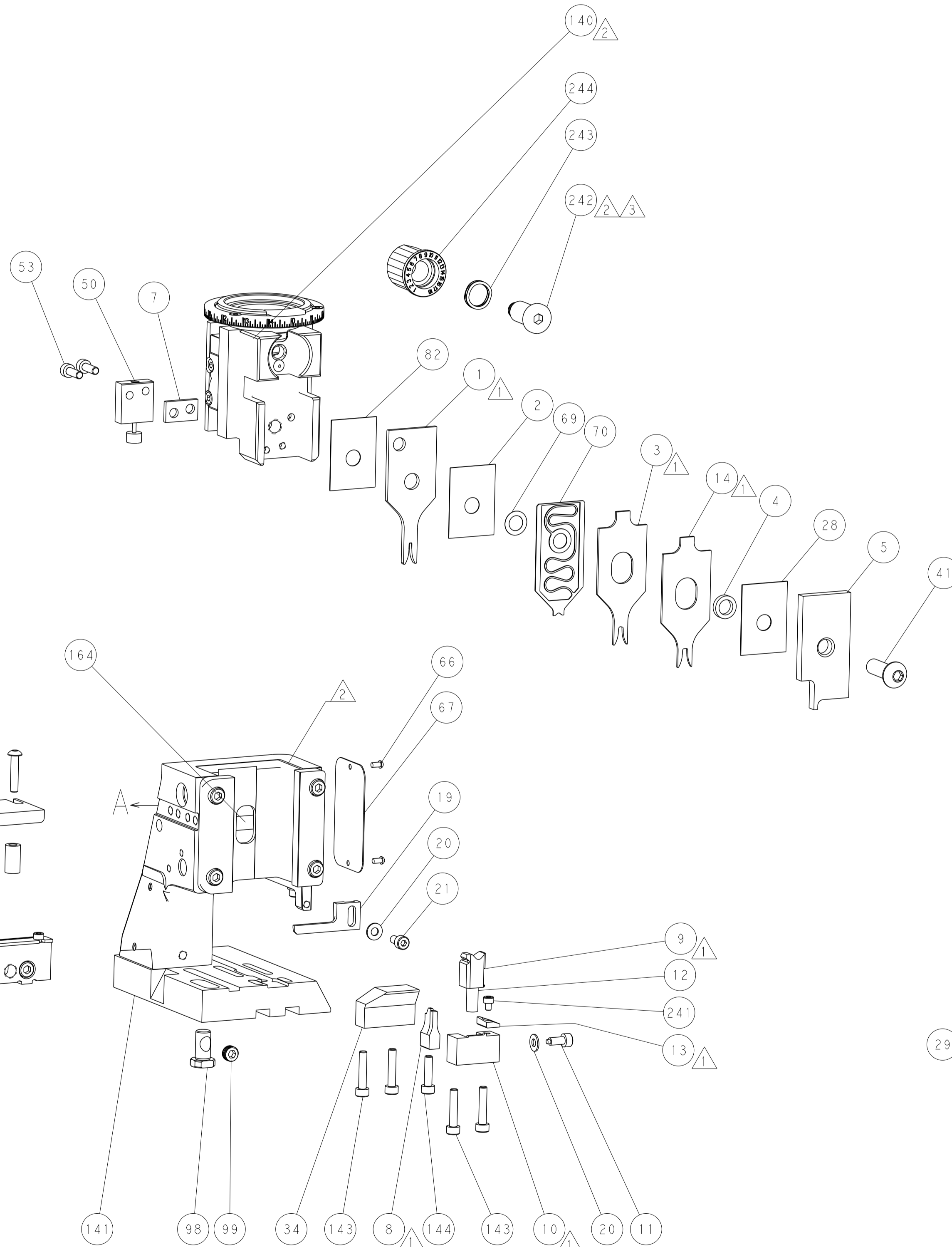
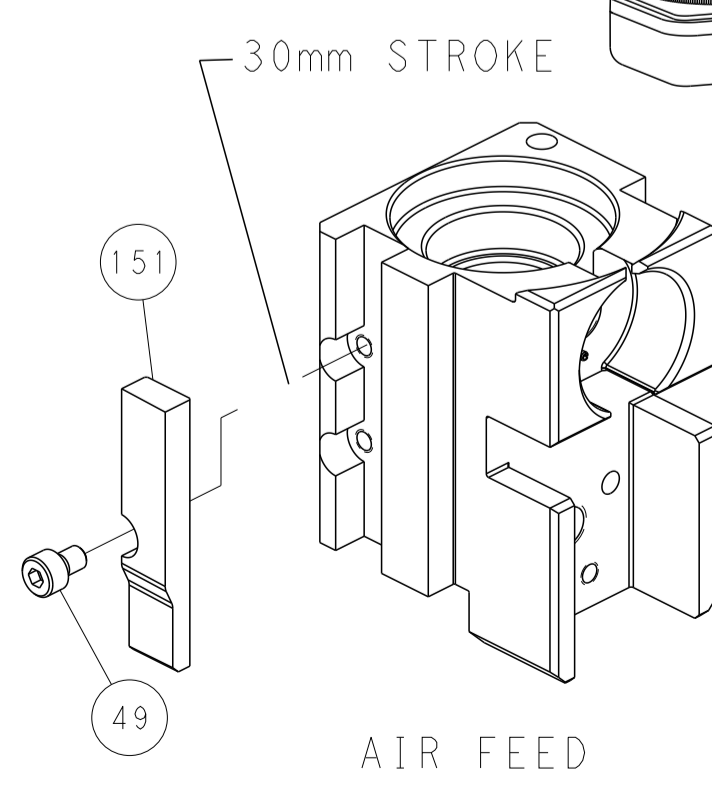
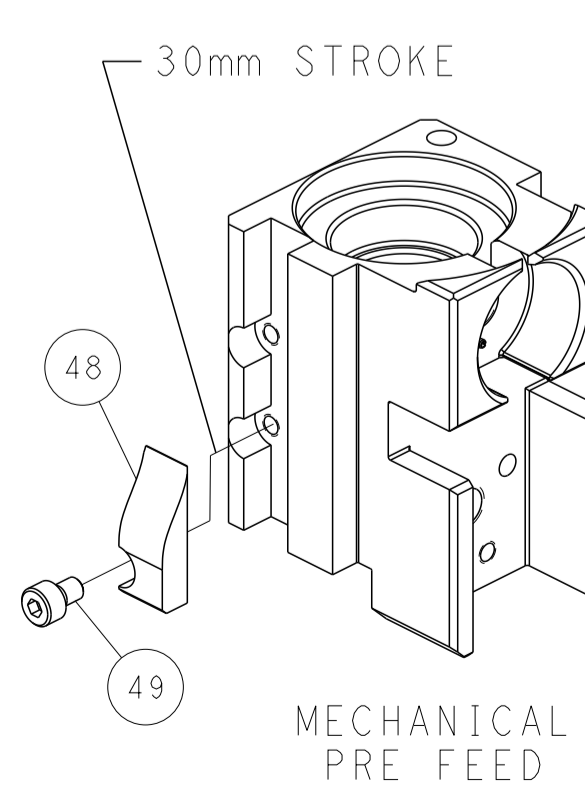
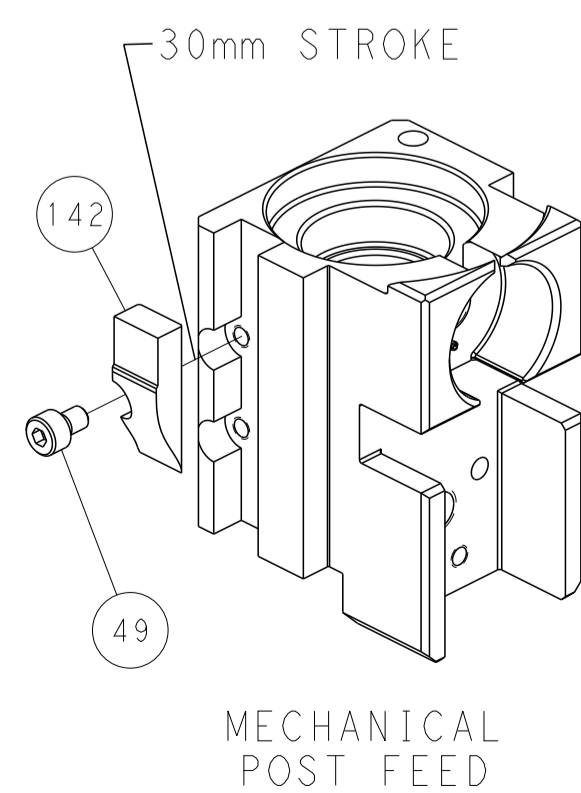
PNEUMATIC



FEED SPRING SETTING POSITION
(SHOWN FROM REAR SIDE)



CAM POSITIONS



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. ALL RIGHTS RESERVED. THIS DRAWING IS THE PROPERTY OF TYCO ELECTRONICS CORPORATION. IT IS TO BE USED ONLY FOR THE PURPOSES SPECIFIED AND 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 THE WRITTEN PERMISSION OF TYCO ELECTRONICS CORPORATION.</small>		DWN: H. HUANG 26NOV2015 CHK: L. ZHANG 26NOV2015 APVD: J. GUO 26NOV2015	NAME: Ocean Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: C-2836138 SCALE: 1:2 SHEET: 4 OF 4 REV: H
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 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: - MATERIAL: -	RESTRICTED TO: - CUSTOMER ACCESSIBLE PRODUCTION DRAWING