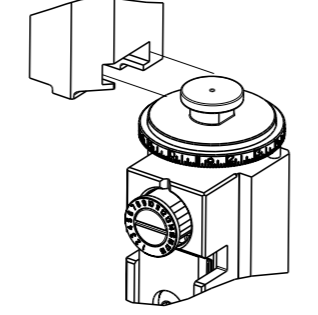


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2836196-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
3-2836196-2	C	FINE CRIMP HEIGHT ADJUST	DOUBLE ACTING PNEUMATIC WITH SENSORS $\Delta$
7-2836196-2	C	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2836196-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER

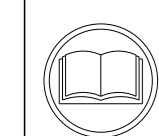


APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.40 mm [.055]	F
INSUL	-	-

APPLICATOR INSTRUCTIONS  
408-35042

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: TE CENTER CONTACT			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
3.10-3.50 mm [.122-.138 IN]		$\varnothing$ 1.32-1.58 mm [.052-.062 IN]	
TERMINAL APPLICATION SPECIFICATION	114-94045		
TERMINALS APPLIED $\Delta$ $\Delta$ $\Delta$ $\Delta$ $\Delta$			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
2293902-1			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.50mm2	0.86 +/- 0.03 [.034 +/- .001]	5.0
0.35mm2	0.78 +/- 0.03 [.031 +/- .001]	5.7



- $\Delta$  RECOMMENDED SPARE PARTS
- $\Delta$  REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- $\Delta$  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.
- $\Delta$  TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- $\Delta$  TERMINAL LUBRICANT IS RECOMMENDED.
- 6. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- $\Delta$  THIS APPLICATOR IS EQUIPPED WITH THE DOUBLE ACTING FEED WITH SENSORS AND IS APPLICATION SPECIFIC AND DOES NOT REQUIRE ITEMS 49 & 248.

**\*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	LY#	DESCRIPTION	DATE	OWN	APVD
A	66			RELEASED	19OCT2017	TB	GB
				ECR-19-008346	27MAY2019	FJ	CT
				ECR-20-017166	11DEC2020	FJ	RR
				ECR-21-002084	18FEB2021	JWC	GB

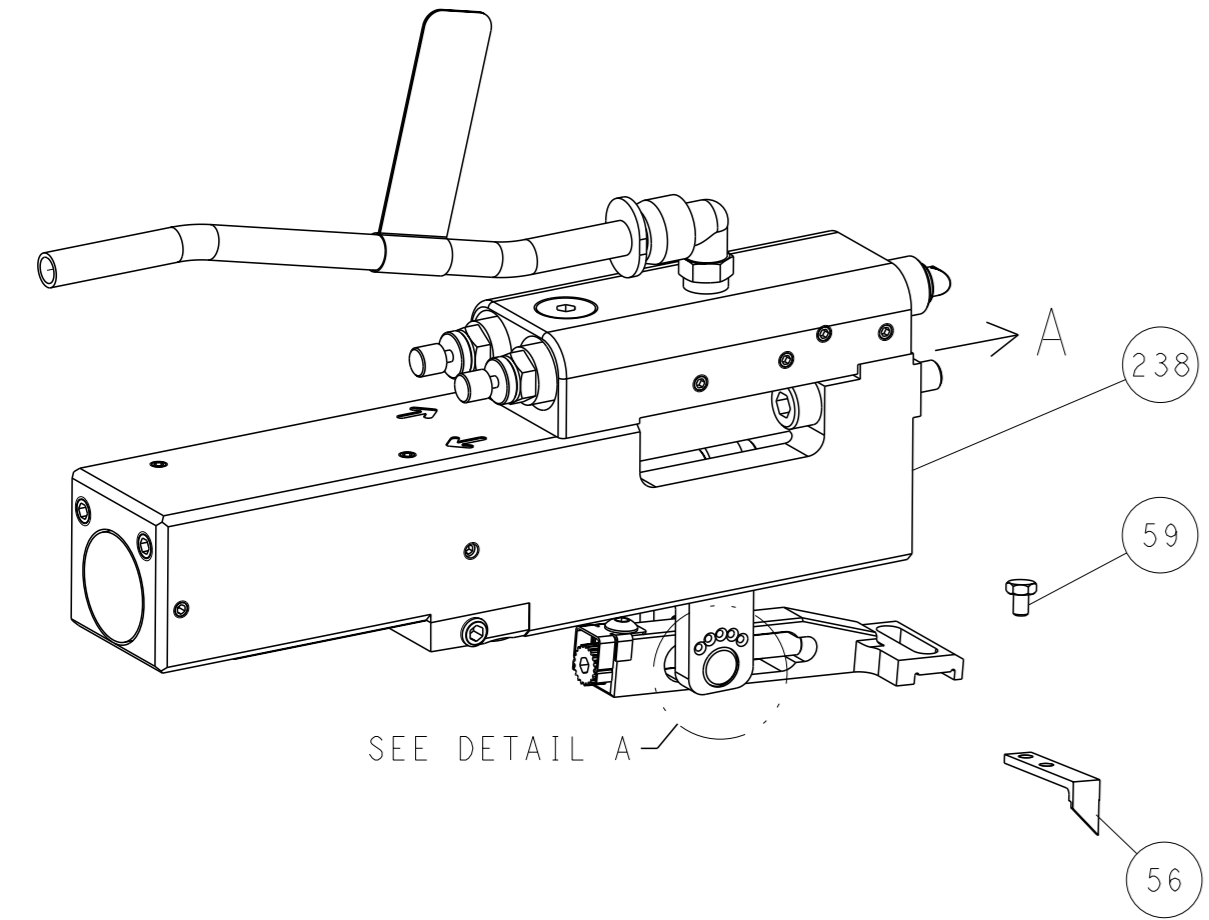
-	-	1	-	2844950-1	AIR FEED MODULE	290	
-	1	-	1	2119641-1	FEED CAM, AIR FEED	248	
-	1	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241	
-	1	-	1	2844940-1	AIR FEED MODULE	238	
-	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164	
-	1	1	1	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113	
-	1	1	1	2844908-1	SCREW, LOCKING	99	
-	1	1	1	2844907-1	POST, LOCKING	98	
-	1	1	1	455888-5	SPACER, CRIMPER	82	
-	1	1	1	5-547505-2	SPRING, COMPRESSION	77	
-	1	1	1	854769-7	HOLDER, INS	74	
-	1	1	1	1803607-3	DOCUMENTATION PACKAGE	71	
-	1	1	1	2119791-9	DEPRESSOR, WIRE	70	
-	1	1	1	2119943-1	WASHER, SPACER	69	
-	1	1	1	2119740-1	TAG, IDENTIFICATION	67	
-	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66	
-	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	60	
-	1	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59	
-	1	1	1	21028-2	PIN, SLOTTED SPRING .062 X .250	58	
-	1	1	1	1338685-1	PAWL, FEED	56	
-	4	4	4	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	54	
-	2	2	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	53	
-	1	1	1	5018030-1	NUT, HEX, REG, RoHS, M3	52	
-	1	1	1	811242-5	BUMPER, HOLD DOWN	51	
-	1	1	1	690753-2	SPACER, TONKER	50	
-	1	-	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49	
-	1	1	1	1803583-9	APPLICATOR BASIC ASSEMBLY, SF	46	
-	1	1	1	1803515-1	RAM ASSEMBLY, SF ATLANTIC	44	
-	1	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41	
-	1	1	1	1752356-1	SUPPORT, TERMINAL	34	
-	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33	
-	2	2	2	2-2844962-3	SPACER, CYLINDRICAL, STRIP GUIDE	30	
-	1	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29	
-	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	2	1-18028-2	WASHER, FLAT, REG M4	20	
-	1	1	1	2119533-1	STRIPPER, SIDE FEED	19	
-	1	1	1	2119806-1	INSERT, SHEAR	13	
-	1	1	1	3-22280-3	SPRING, COMPRESSION	12	
-	1	1	1	1-356885-4	STOP, SHEAR	11	
-	1	1	1	2119805-1	SHEAR HOLDER, FRONT	10	
-	1	1	1	1803095-3	FLOATING SHEAR, FRONT	9	
-	1	2	1	1	7-1633933-1	ANVIL, COMBINATION	8
-	-	-	-	-	-	7	
-	-	-	-	-	-	6	
-	1	1	1	2119780-4	DEPRESSOR, SHEAR	5	
-	-	-	-	-	-	4	
-	-	-	-	-	-	3	
-	-	-	-	-	-	2	
-	1	2	1	1	3-1803224-5	CRIMPER, WIRE	1

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		OWN	CHK	APVD	DATE	DESCRIPTION		ITEM NO	
mm	0 PLC ±	1 PLC ±	2 PLC ±	M	HERR	T	23FEB2016	Ocean Side Feed Applicator			
	3 PLC ±	4 PLC ±	ANGLES ±	M	HERR	E	23FEB2016	Customer Accessible Production Drawing			
MATERIAL								SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
								A1	00779	2836196	
								SCALE	SHEET	OF	REV
								1:2	1	4	C1

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

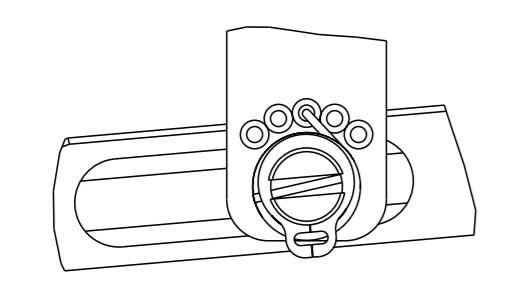
# FEED TYPE

## PNEUMATIC



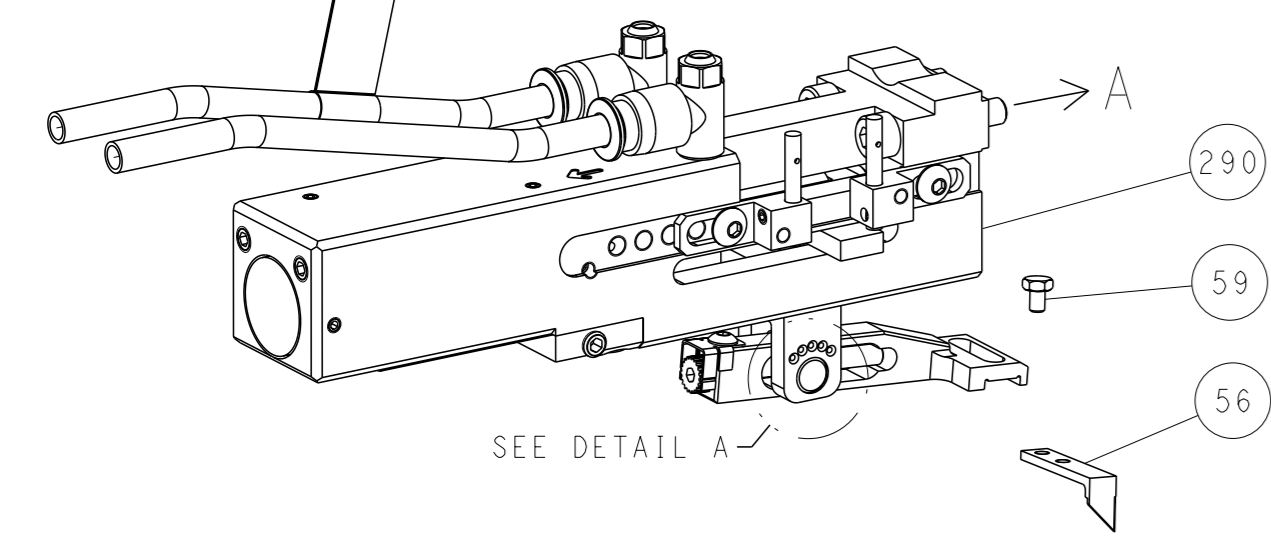
SEE DETAIL A

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



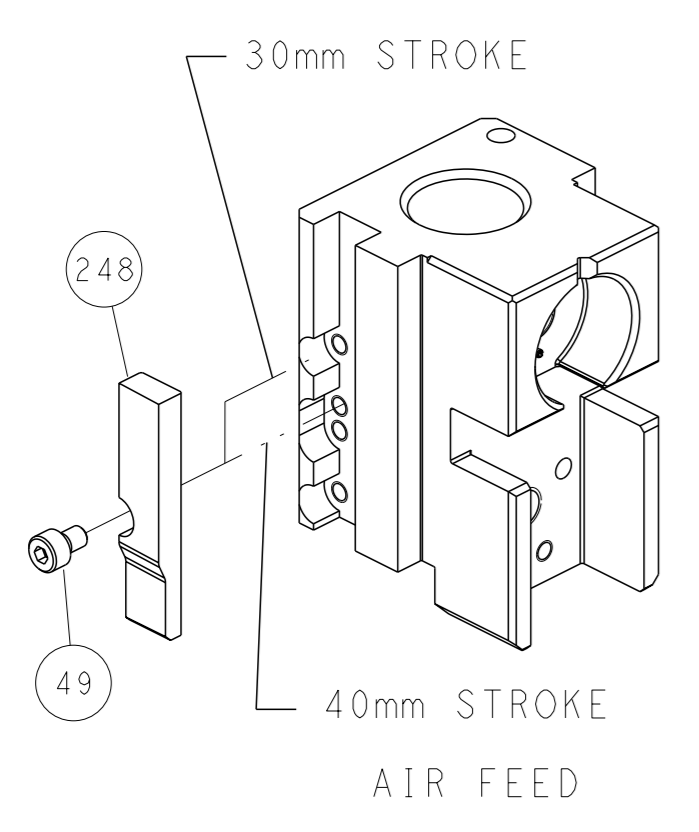
DETAIL A

### DOUBLE ACTING PNEUMATIC WITH SENSORS

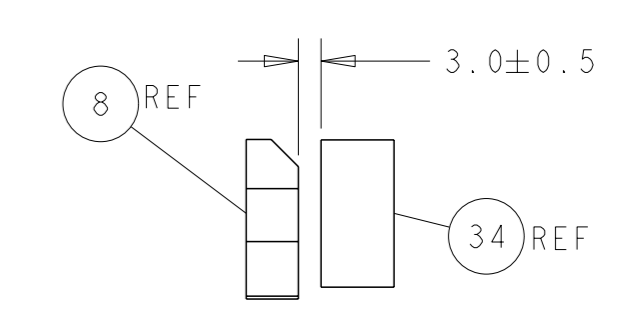
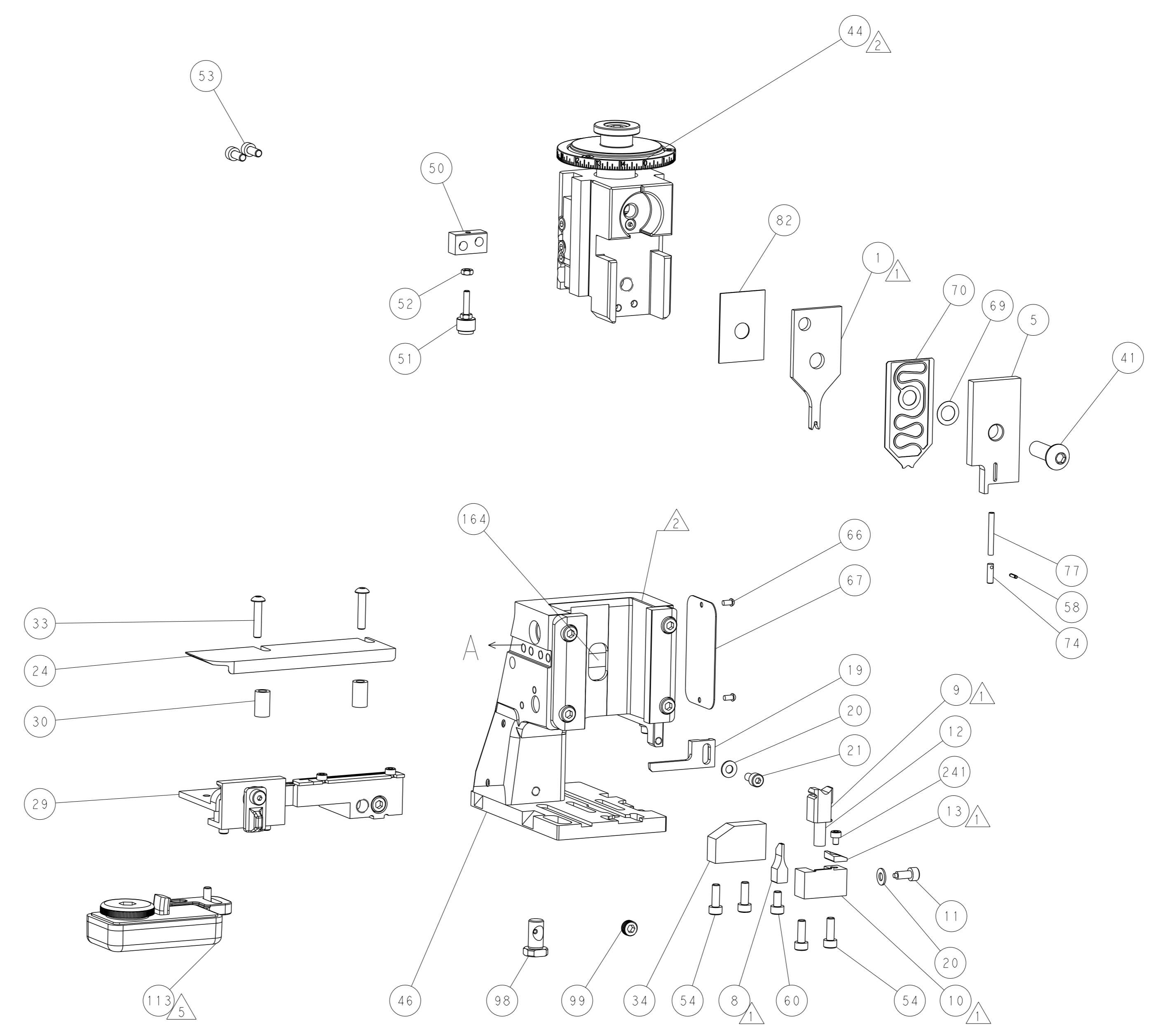


SEE DETAIL A

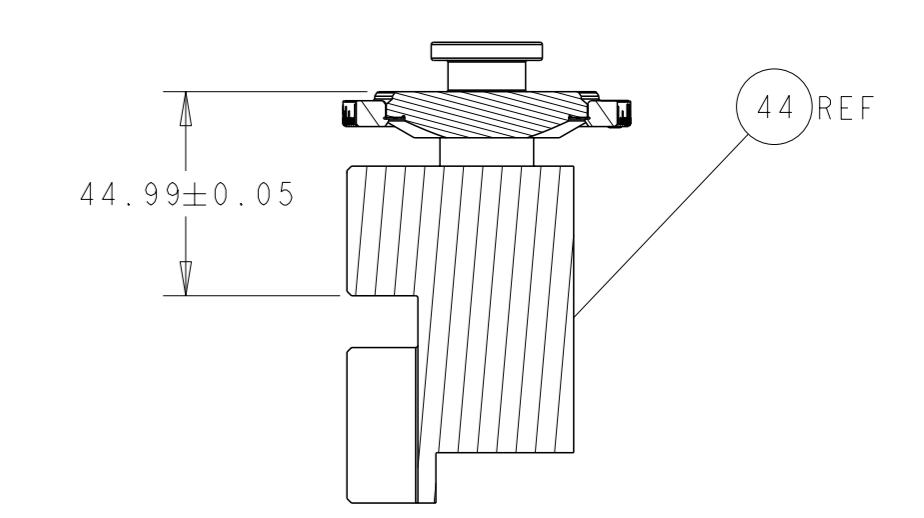
## CAM POSITION



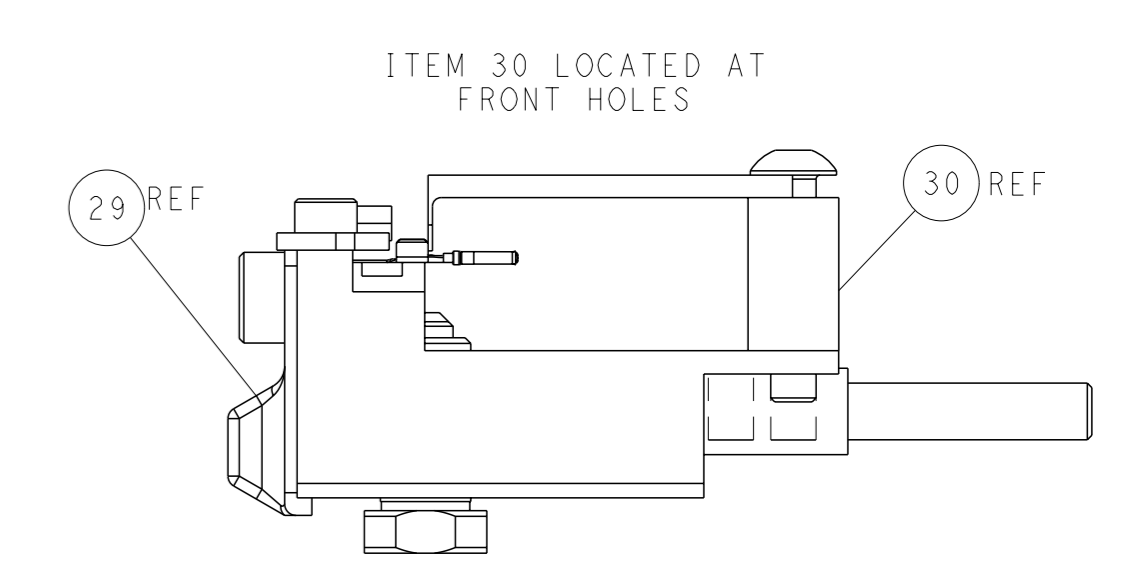
AIR FEED



TERMINAL SUPPORT LOCATION



HOLDDOWN SET-UP



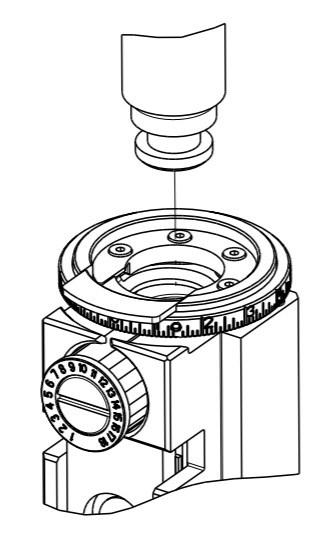
FEED TRACK POSITION GUIDE BY WIRE BARREL

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

<small>THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE AND THE USER'S RESPONSIBILITY TO VERIFY THE DIMENSIONS SHOULD BE CONTACTED FOR THE LATEST REVISION.</small>		OWN: M. HERR 23FEB2016 CHK: M. HERR 23FEB2016 APVD: T. ELBIN 23FEB2016	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 SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2836196 WEIGHT: - SCALE: 1:2	RESTRICTED TO: - SHEET 2 OF 4 REV C1
MATERIAL: - FINISH: -		Customer Accessible Production Drawing	

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2836196-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
4-2836196-2	C	FINE CRIMP HEIGHT ADJUST	DOUBLE ACTING PNEUMATIC WITH SENSORS
7-2836196-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP WIRE	SIZE	TYPE
WIRE	1.40 mm [.055]	F
INSUL	-	-

APPLICATOR INSTRUCTIONS  
408-35042

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: TE CENTER CONTACT			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
3.10-3.50 mm [.122-.138 IN]		Ø1.32-1.58 mm [.052-.062 IN]	
TERMINAL APPLICATION SPECIFICATION		114-94045	
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
2293902-1			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.50mm2	0.86 +/- 0.03 [.034 +/- .001]	5.0
0.35mm2	0.78 +/- 0.03 [.031 +/- .001]	5.7



- 1 RECOMMENDED SPARE PARTS
- 2 REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- 3 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.
- 4 TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- 5 TERMINAL LUBRICANT IS RECOMMENDED.
- 6. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- 7 THIS APPLICATOR IS EQUIPPED WITH THE DOUBLE ACTING FEED WITH SENSORS AND IS APPLICATION SPECIFIC AND DOES NOT REQUIRE ITEMS 49 & 248.

**\*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	REVISIONS					
A	66	P	LYR	DESCRIPTION	DATE	OWN	APVD
		-	-	SEE SHEET 1	-	-	-

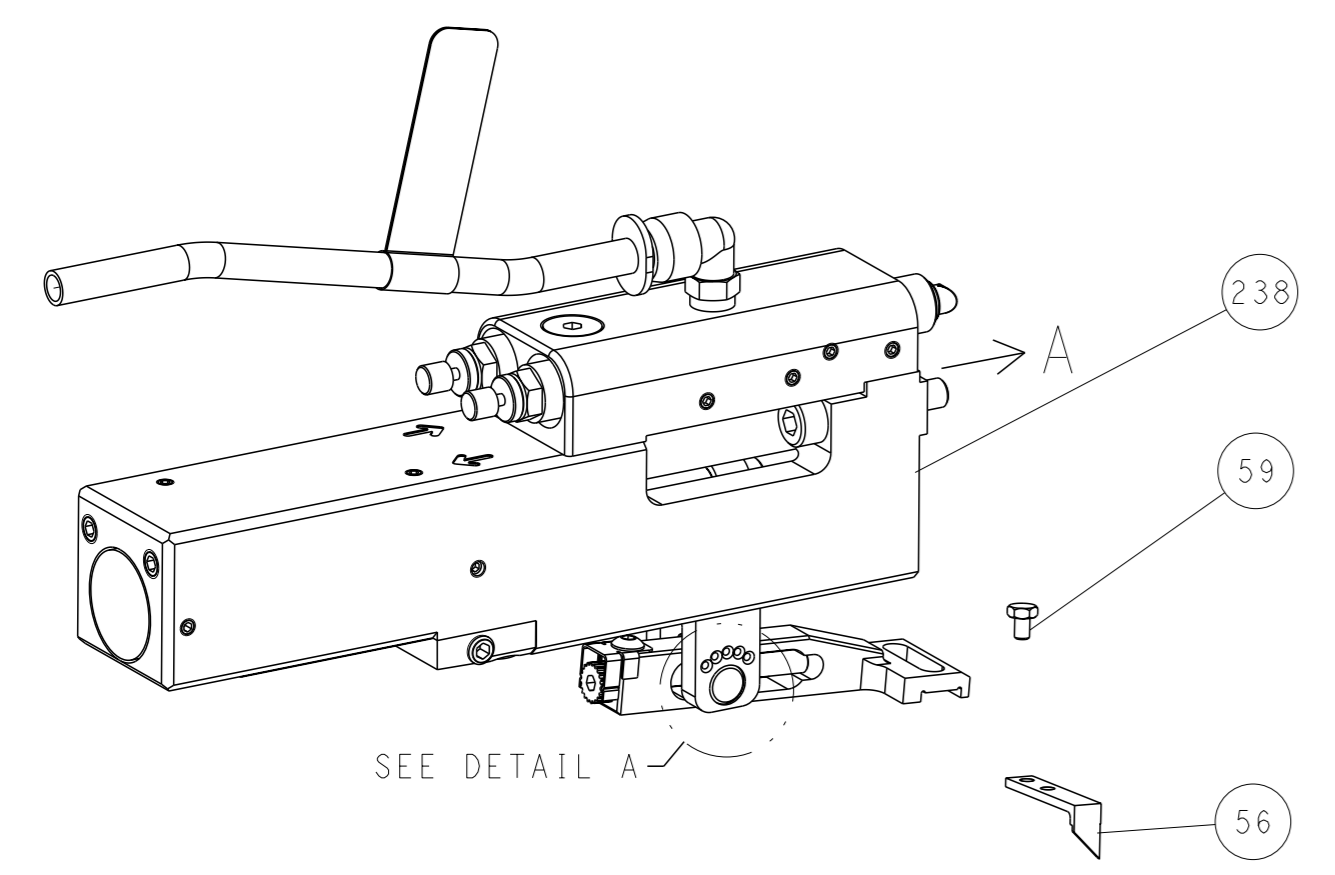
-	1	-	2844950-1	AIR FEED MODULE	290
-	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
-	-	1	2844940-1	AIR FEED MODULE	238
-	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	-	1	2119641-2	FEED CAM, AIR FEED	151
-	1	1	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	144
-	4	4	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	143
-	1	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	455888-5	SPACER, CRIMPER	82
-	1	1	5-547505-2	SPRING, COMPRESSION	77
-	1	1	854769-7	HOLDER, INS	74
-	1	1	1803607-3	DOCUMENTATION PACKAGE	71
-	1	1	2119791-9	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	21028-2	PIN, SLOTTED SPRING .062 X .250	58
-	1	1	1338685-1	PAWL, FEED	56
-	2	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	53
-	1	1	5018030-1	NUT, HEX, REG, RoHS, M3	52
-	1	1	811242-5	BUMPER, HOLD DOWN	51
-	1	1	690753-2	SPACER, TONKER	50
-	-	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
-	1	1	1752356-1	SUPPORT, TERMINAL	34
-	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	2-2844962-3	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29
-	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	1803095-3	FLOATING SHEAR, FRONT	9
-	1	1	7-1633933-1	ANVIL, COMBINATION	8
-	-	-	-	-	7
-	-	-	-	-	6
-	1	1	2119780-4	DEPRESSOR, SHEAR	5
-	-	-	-	-	4
-	-	-	-	-	3
-	-	-	-	-	2
-	1	1	3-1803224-5	CRIMPER, WIRE	1

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		OWN	CHK	APVD	DATE	DESCRIPTION		ITEM NO
mm	0 PLC ±	1 PLC ±	2 PLC ±	M. HERR	M. HERR	T. ELBIN	23FEB2016	STE TE Connectivity		
	3 PLC ±	4 PLC ±	ANGLES FINISH					Ocean Side Feed Applicator		
MATERIAL								SIZE	CAGE CODE	DRAWING NO
								A1	00779	2836196
Customer Accessible Production Drawing								SCALE	1:2	SHEET 3 OF 4

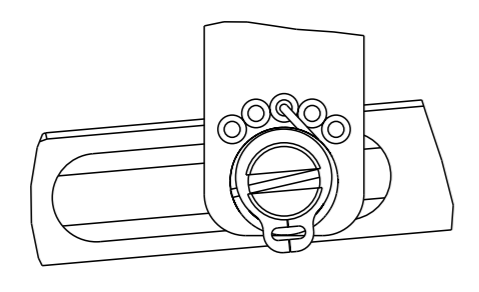
LOC	DIST	REVISIONS					
A	66	P	LYR	DESCRIPTION	DATE	OWN	APVD
		-		SEE SHEET 1	-	-	-

# FEED TYPE

## PNEUMATIC

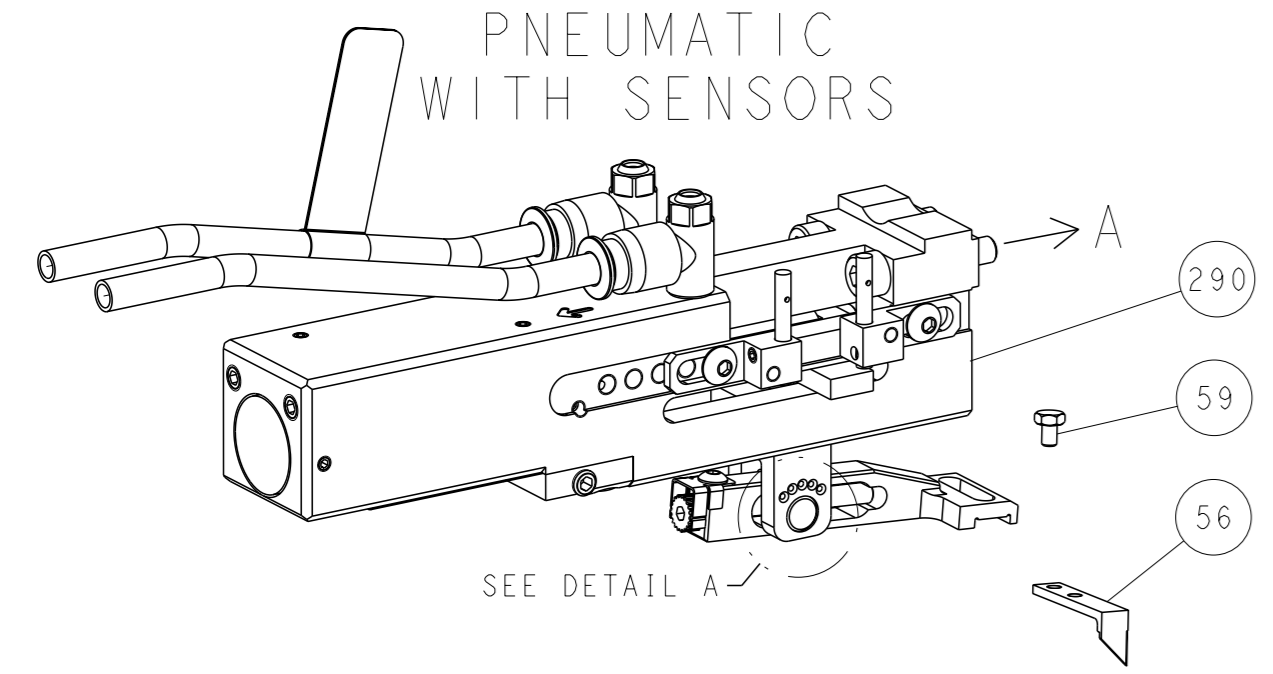


## FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)

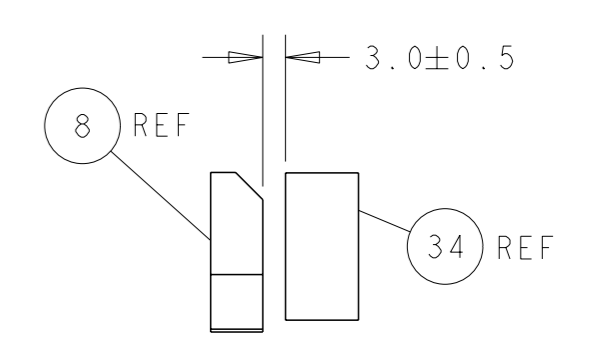
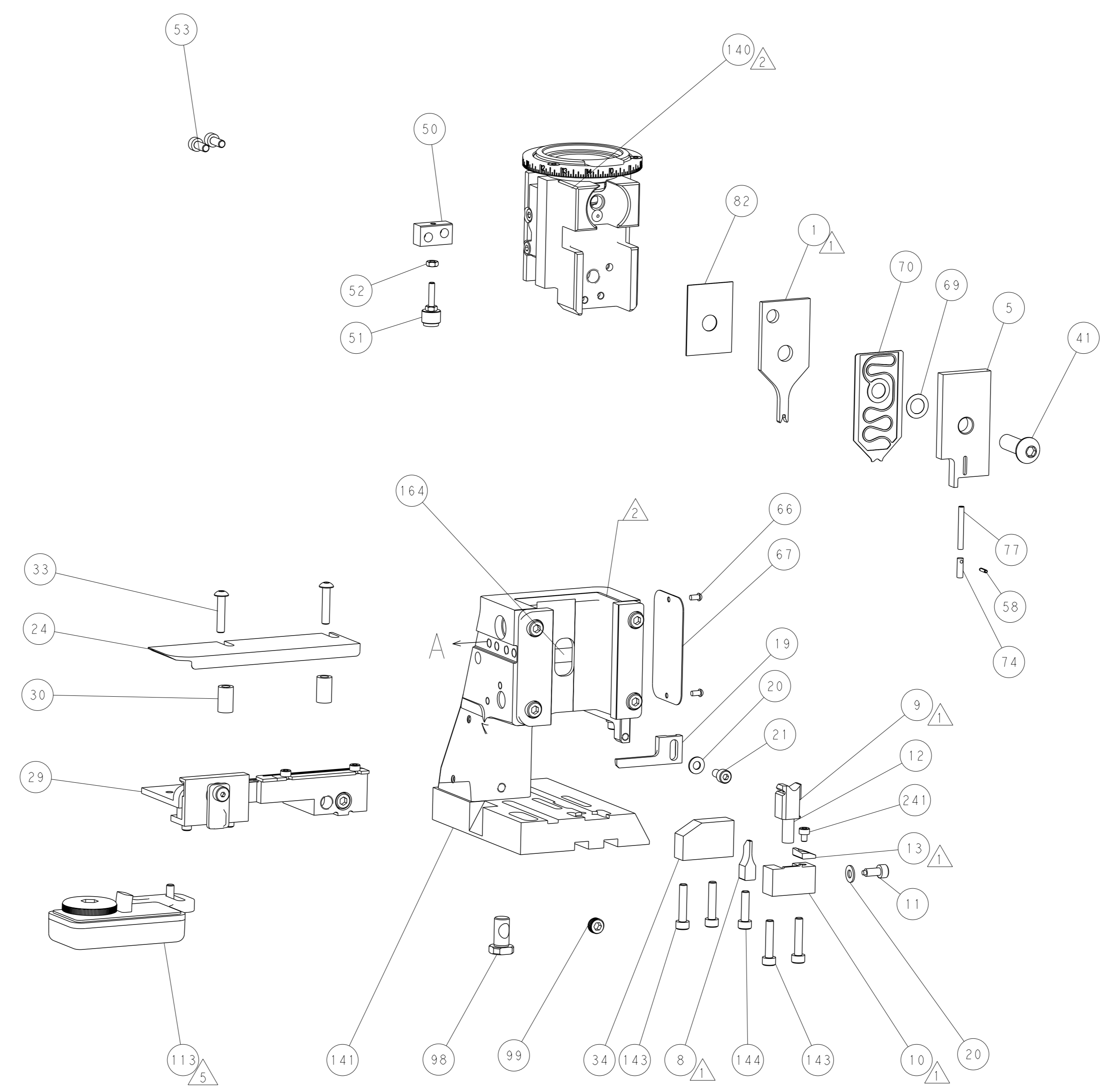
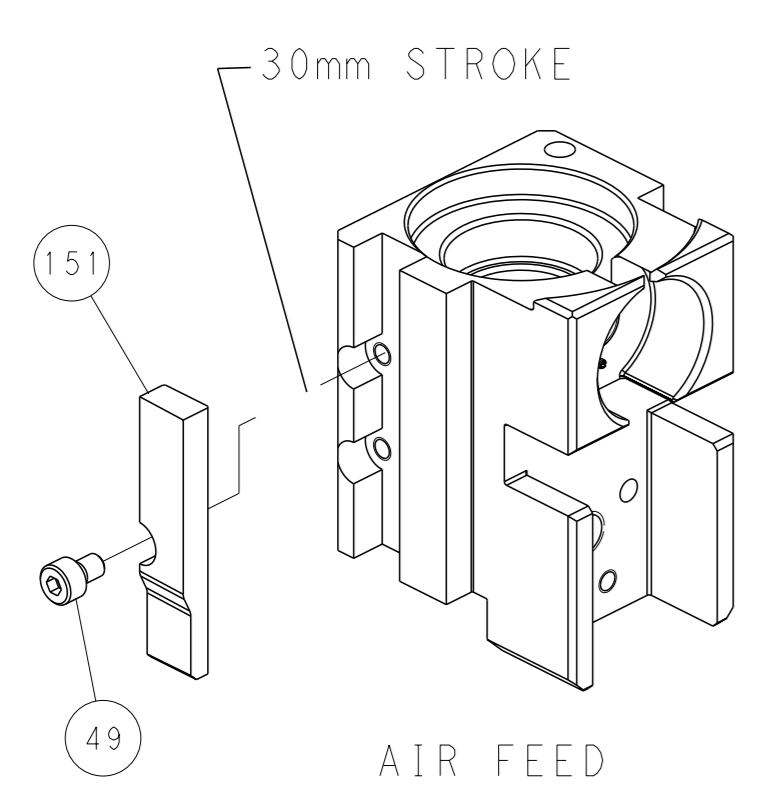


DETAIL A

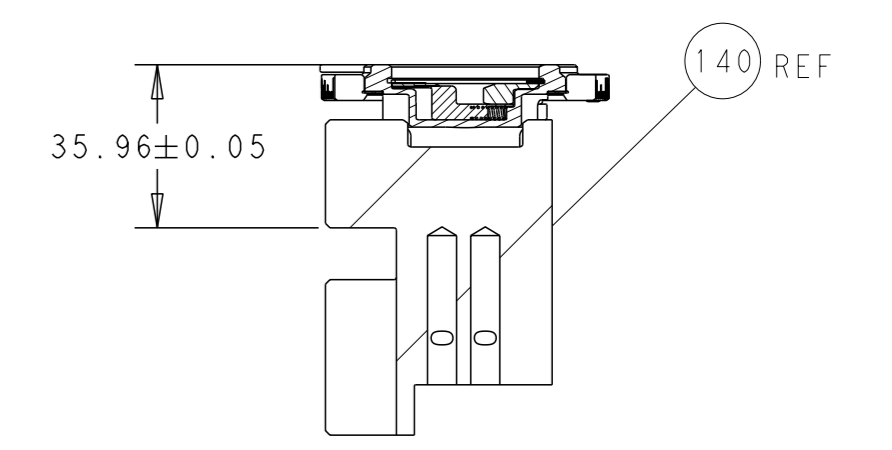
## DOUBLE ACTING PNEUMATIC WITH SENSORS



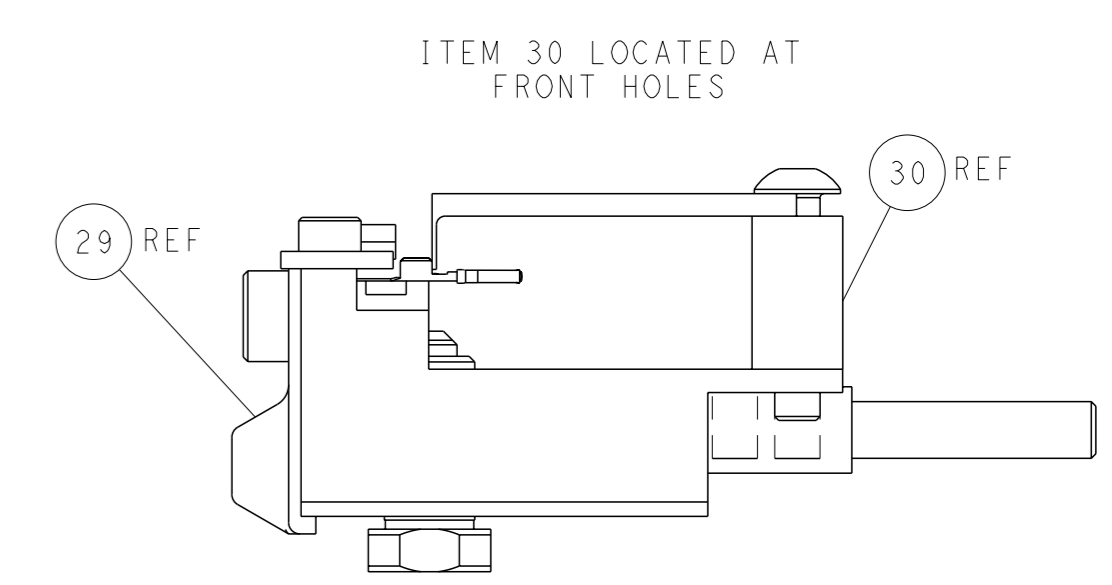
## CAM POSITION



TERMINAL SUPPORT LOCATION



HOLDDOWN SET-UP



FEED TRACK POSITION GUIDE BY WIRE 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. 20                  COPYRIGHT 2016 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.</small>		OWN M. HERR 23FEB2016 CHK M. HERR 23FEB2016 APVD T. ELBIN 23FEB2016	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 APPLICATION SPEC SIZE CAGE CODE DRAWING NO. A1 00779 C=2836196 WEIGHT Customer Accessible Production Drawing	RESTRICTED TO SCALE 1:2 SHEET 4 OF 4 REV C1