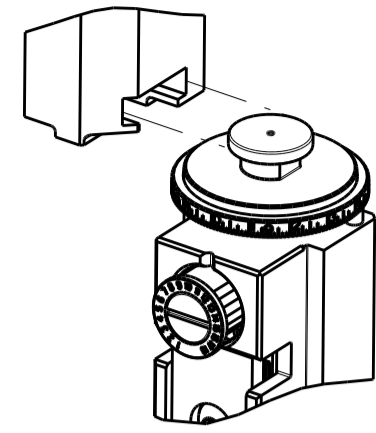


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2836391-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2836391-2	D	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2836391-1	C	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2836391-2	D	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2836391-7	B	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.03 mm [.080]	F
INSUL	2.67 mm [.105]	F

APPLICATOR INSTRUCTIONS 408-35042

TERMINAL DATA:	SUMITOMO TERMINAL	SUMITOMO CRIMP SPECIFICATION
TERMINAL NAME:	HE SRE .090 RECEPTACLE TERMINAL	
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE
4.50-5.50 mm [.177-.217 IN]		1.80-2.90 mm [.071-.114 IN]
TERMINAL APPLICATION SPECIFICATION	HE 090 TYPE UNSEALED CONNECTOR Rev 15/12/04	
TERMINALS APPLIED	5	
TE TERMINAL	SUMITOMO TERMINAL	TE TERMINAL
1949252-1	8100-1472	1949384-1
		SUMITOMO TERMINAL
		8100-1573

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.50mm2	1.40 +/- 0.05 [0.055 +/- .002]	4.5
1.00mm2	1.25 +/- 0.05 [0.049 +/- .002]	6.0
0.75mm2	1.15 +/- 0.05 [0.045 +/- .002]	7.0



- 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. 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
		A1		ECR-17-018098	12DEC2017	RS	LZ
		B		ECR-18-001240	25JAN2018	JAH	CT
		C		ECR-18-014001	06SEP2018	FZ	KZ
		D		ECR-20-013318	18SEP2020	FZ	TE

-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248
-	1	1	1	1	2119082-3	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
3	-	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
-	-	1	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	1	-	1	-	2844940-1	AIR FEED MODULE	238
-	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
5	-	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	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	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	53
-	1	1	1	1	5018030-1	NUT, HEX, REG, RoHS, M3	52
-	1	1	1	1	811242-5	BUMPER, HOLD DOWN	51
-	1	1	1	1	690753-2	SPACER, TONKER	50
-	1	2	1	2	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	-	1	-	1	2119652-1	FEED CAM, PRE FEED	48
-	-	1	-	1	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	1752356-3	SUPPORT, TERMINAL	34
-	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	2	2	2-2844962-6	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29
-	1	1	1	1	1-455888-0	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	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	1803095-6	FLOATING SHEAR, FRONT	9
1	2	2	1	1	4-1803058-8	ANVIL, COMBINATION	8
-	-	-	-	-	-	-	7
-	-	-	-	-	-	-	6
-	1	1	1	1	2119757-4	DEPRESSOR, SHEAR	5
-	1	1	1	1	7-238011-1	BLOCK, CRIMPER SPACER	4
1	2	2	1	1	1-1803457-0	CRIMPER, INSULATION F PREMIUM	3
-	-	-	-	-	-	-	2
1	2	2	1	1	6-456405-4	CRIMPER, WIRE PREMIUM	1
-	77	72	71	-2	-1	PART NO	DESCRIPTION
-	-	-	-	-	-	-	ITEM NO

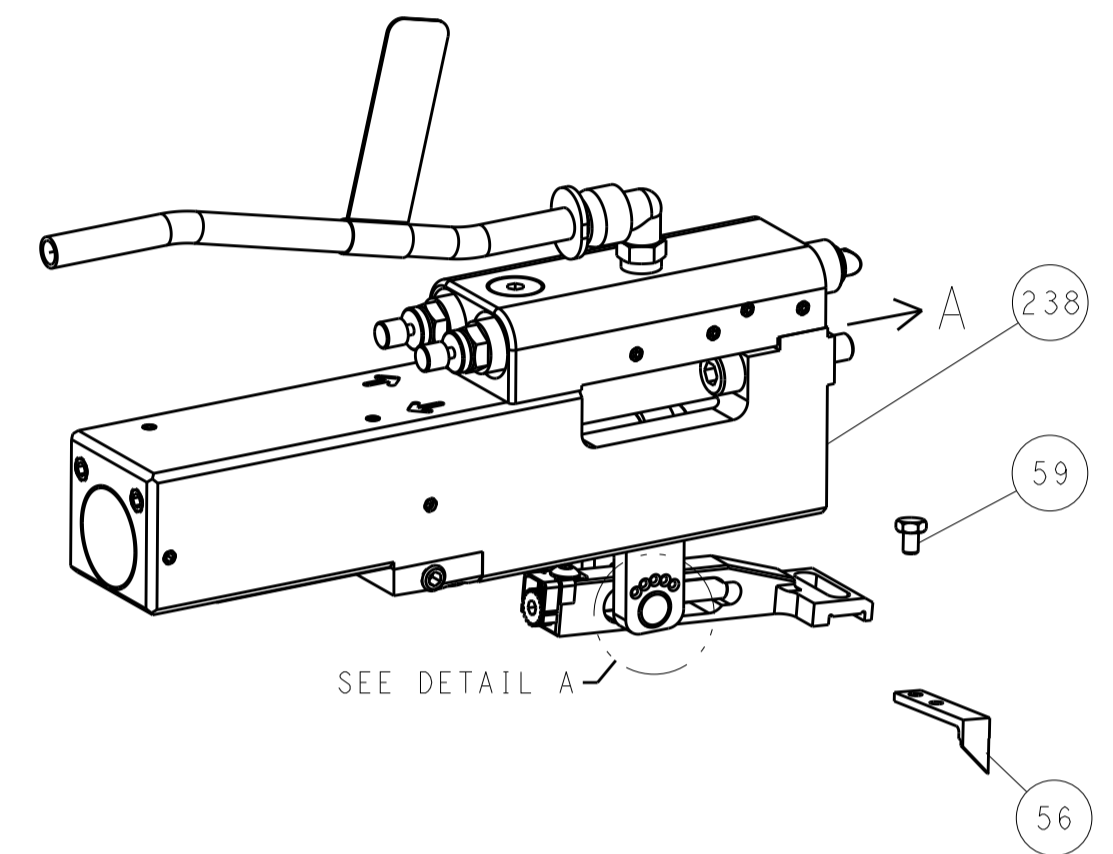
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		1 PLC ±		28JULY2016		28JULY2016		28JULY2016		TE Connectivity Harrisburg, PA 17105-3608	
		2 PLC ±								Customer Accessible Production Drawing	
		3 PLC ±								SCALE 1:2 SHEET 1 OF 4 REV D	
		4 PLC ±								RESTRICTED TO	
		ANGLES ±								SIZE CAGE CODE DRAWING NO	
		FINISH								A1 00779 C=2836391	

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

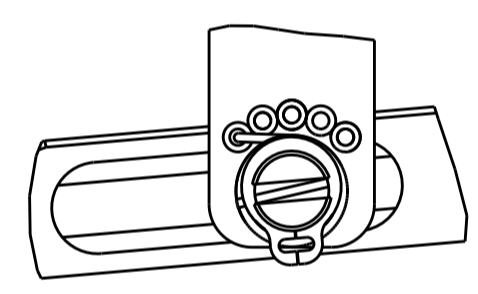
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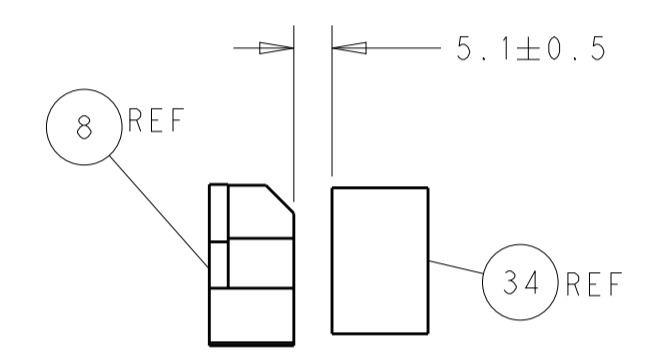
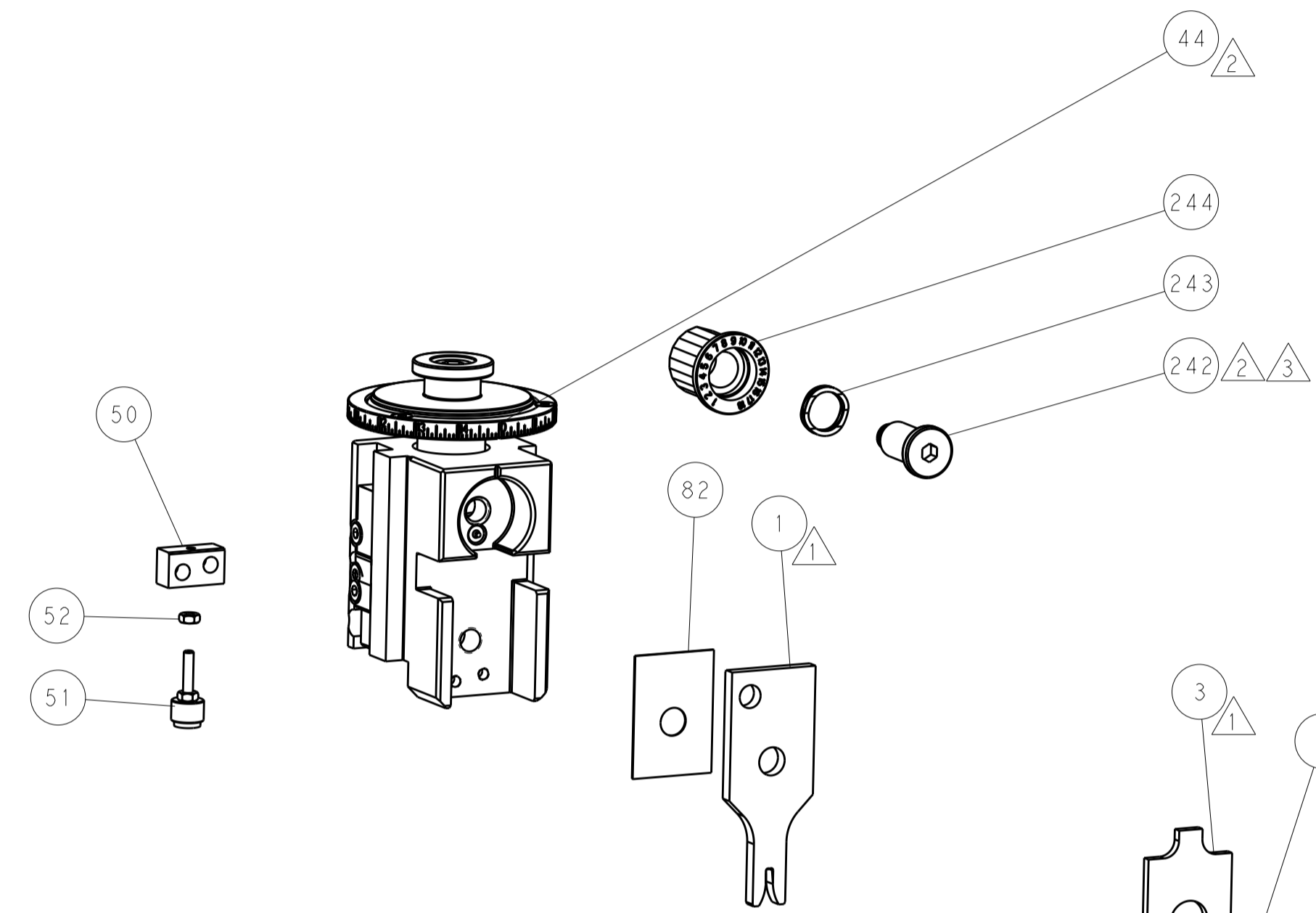
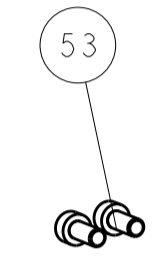
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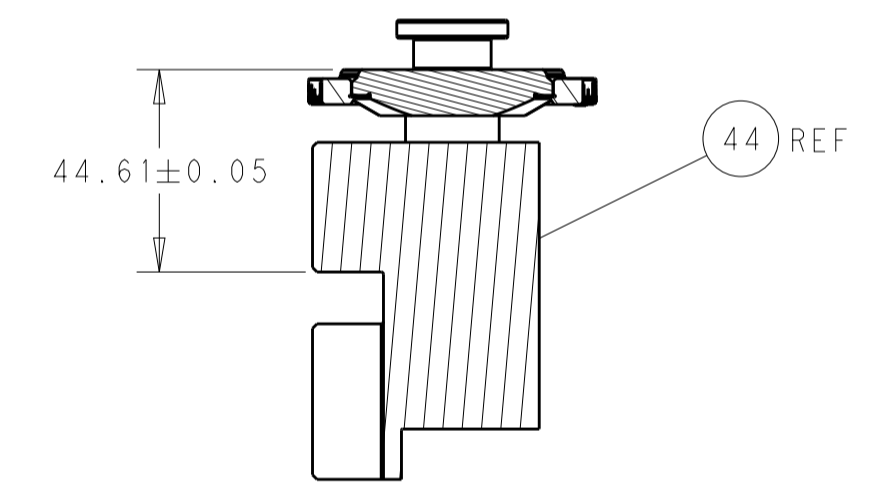
FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



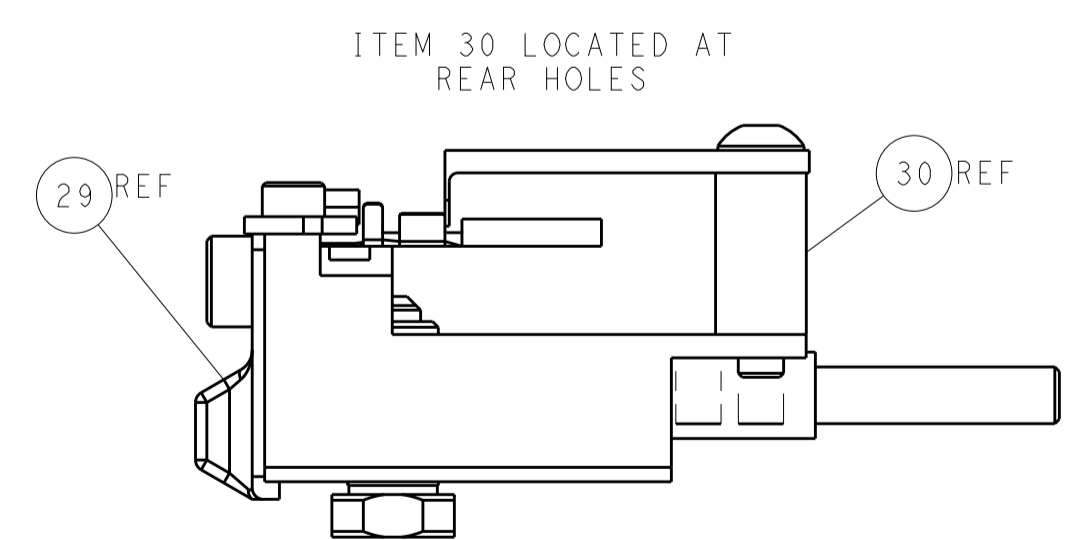
DETAIL A



TERMINAL SUPPORT LOCATION



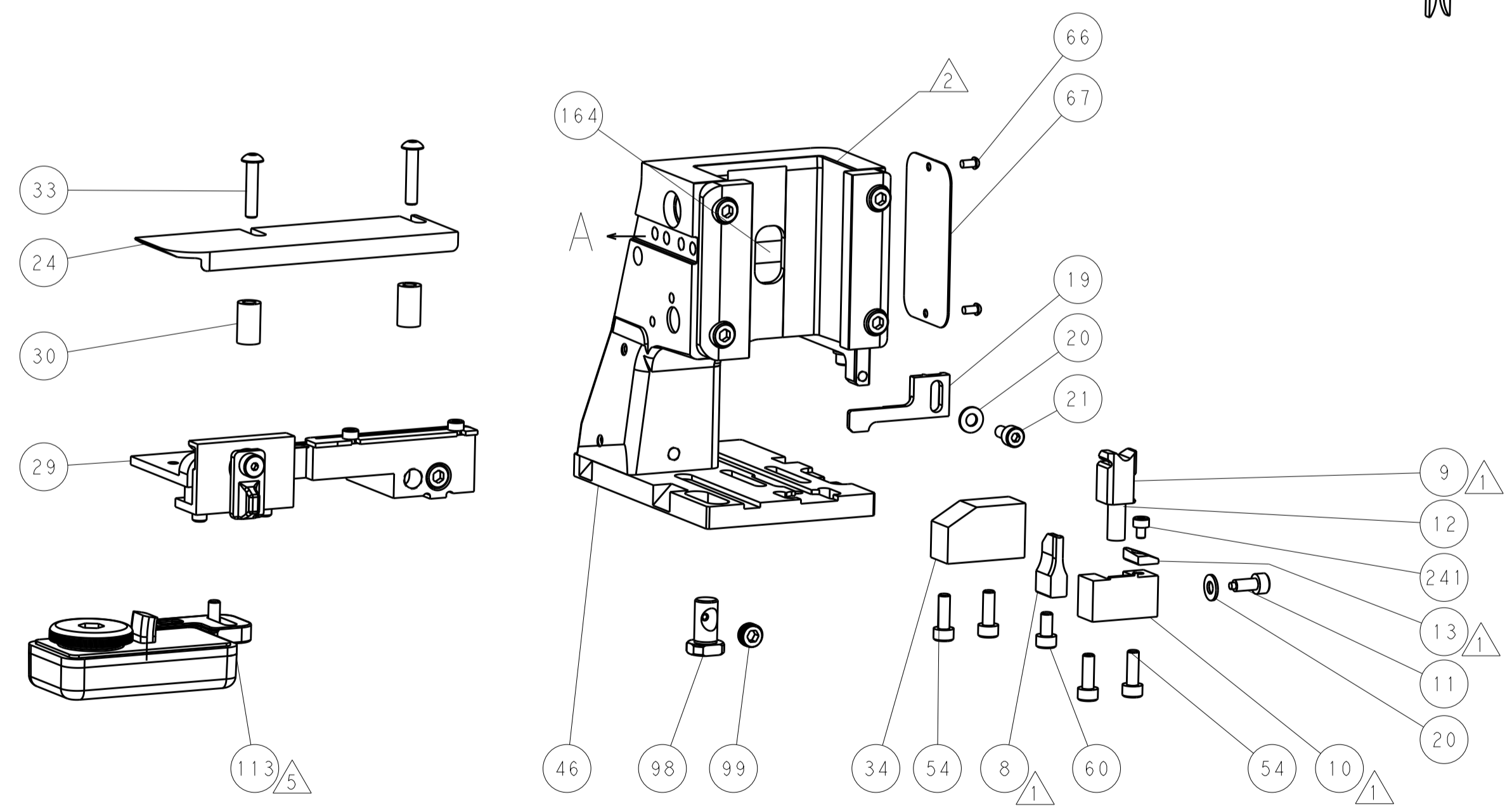
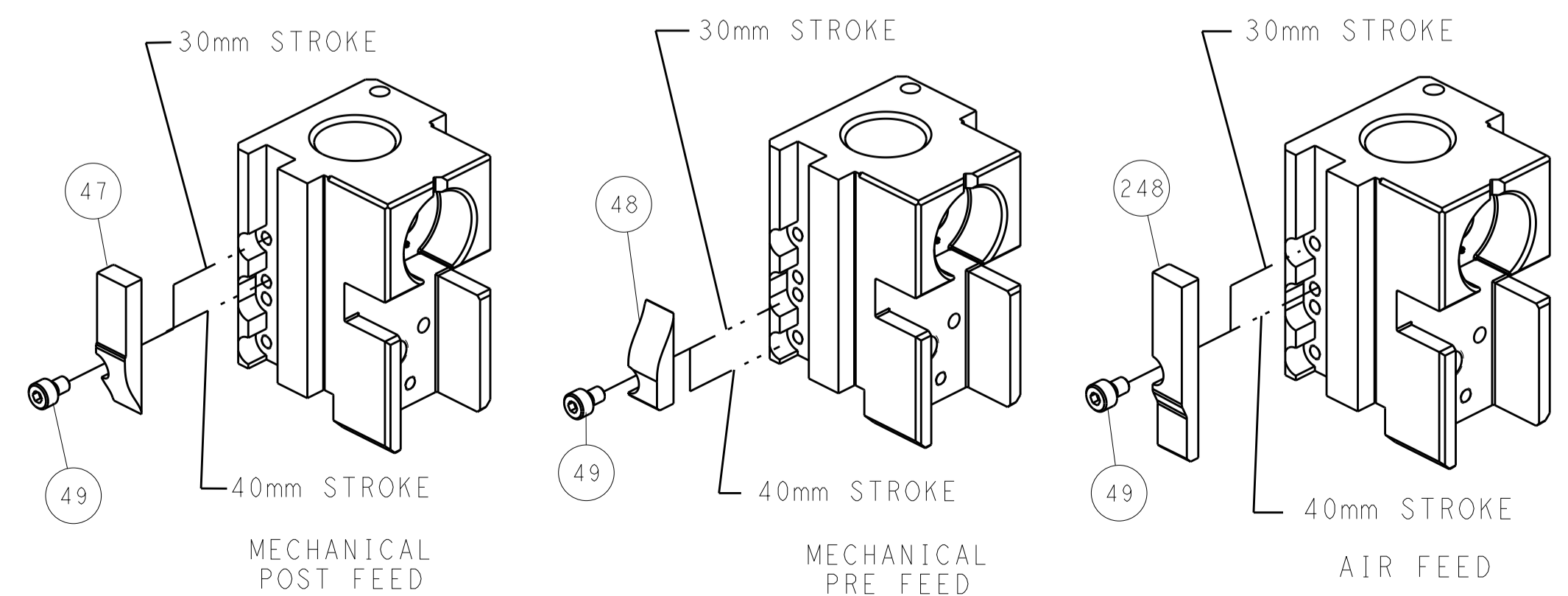
RAM SET-UP



ITEM 30 LOCATED AT REAR HOLES

FEED TRACK POSITION GUIDE BY WIRE BARREL

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: J. HOU 28JULY2016		TE Connectivity	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	Harrisburg, PA 17105-3608	
MATERIAL:		FINISH:		CHK: L. ZHANG 28JULY2016		NAME: Ocean Side Feed Applicator	
Customer Accessible Production Drawing		SCALE: 1:2		SHEET 2 OF 4		REV D	

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2836391-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2836391-2	D	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2836391-7	B	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
 INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.03 mm [.080]	F
INSUL	2.67 mm [.105]	F

APPLICATOR INSTRUCTIONS
 408-35042

TERMINAL DATA:	SUMITOMO TERMINAL	SUMITOMO CRIMP SPECIFICATION								
TERMINAL NAME:	HE SRE .090 RECEPTACLE TERMINAL									
WIRE STRIP LENGTH	4.50-5.50 mm [1.77-.217 IN]	INSULATION DIAMETER RANGE 1.80-2.90 mm [1.071-.114 IN]								
TERMINAL APPLICATION SPECIFICATION	HE 090 TYPE UNSEALED CONNECTOR Rev 15/12/04									
TERMINALS APPLIED	<table border="1"> <thead> <tr> <th>TE TERMINAL</th> <th>SUMITOMO TERMINAL</th> <th>TE TERMINAL</th> <th>SUMITOMO TERMINAL</th> </tr> </thead> <tbody> <tr> <td>1949252-1</td> <td>8100-1472</td> <td>1949384-1</td> <td>8100-1573</td> </tr> </tbody> </table>		TE TERMINAL	SUMITOMO TERMINAL	TE TERMINAL	SUMITOMO TERMINAL	1949252-1	8100-1472	1949384-1	8100-1573
TE TERMINAL	SUMITOMO TERMINAL	TE TERMINAL	SUMITOMO TERMINAL							
1949252-1	8100-1472	1949384-1	8100-1573							

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.50mm ²	1.40 +/- 0.05 [1.055 +/- .002]	4.5
1.00mm ²	1.25 +/- 0.05 [1.049 +/- .002]	6.0
0.75mm ²	1.15 +/- 0.05 [1.045 +/- .002]	7.0



- 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. 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.

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	-	-	-	-

				REVISIONS	
QTY	UNIT	DESCRIPTION	DATE	BY	APPV
-	-	SEE SHEET 1	-	-	-
-	1	2119082-3			244
-	1	2079764-1			243
3	1	2119083-1			242
-	1	7-18023-7			241
-	-	2119580-1			239
-	1	2844940-1			238
-	REF	994970-2			164
-	1	2119641-2			151
-	1	2168083-8			144
-	4	2168083-9			143
-	-	2119653-2			142
-	1	1-1803583-0			141
-	1	1803516-1			140
5	1	2119955-1			113
-	1	2844908-1			99
-	1	2844907-1			98
-	1	455888-4			82
-	1	1803607-3			71
-	1	2119740-1			67
-	2	2168078-1			66
-	1	5-18022-5			59
-	1	1338685-1			56
-	2	1-2168083-0			53
-	1	5018030-1			52
-	1	811242-5			51
-	1	690753-2			50
-	1	18023-9			49
-	-	2119652-1			48
-	1	1803602-1			41
-	1	1752356-3			34
-	2	2079383-5			33
-	2	2-2844962-6			30
-	1	2844992-1			29
-	1	1-455888-0			28
-	1	1320928-2			24
-	1	2168083-2			21
-	2	1-18028-2			20
-	1	2119533-1			19
1	1	2119806-1			13
-	1	3-22280-3			12
-	1	1-356885-4			11
1	1	2119805-1			10
1	1	1803095-6			9
1	1	4-1803058-8			8
-	-	-			7
-	-	-			6
-	1	2119757-4			5
-	1	7-238011-1			4
1	1	1-1803457-0			3
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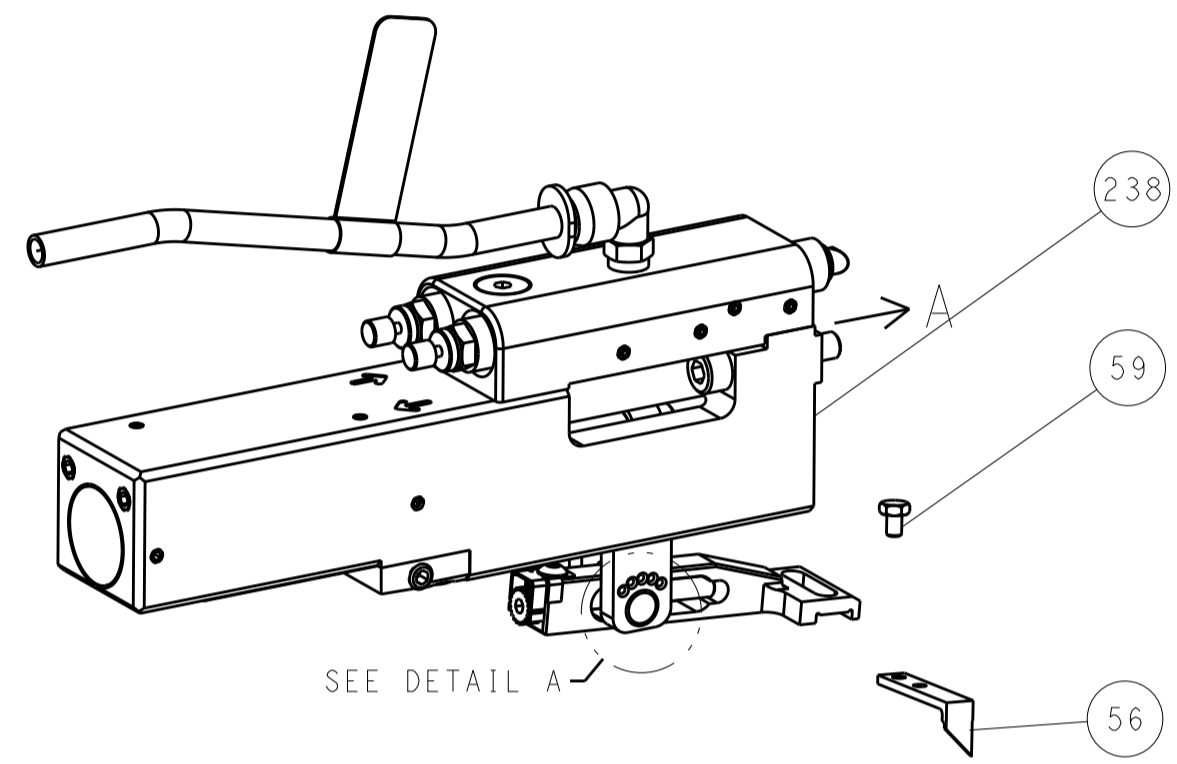
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ANGLES	±	±	±	±	±
MATERIAL:	FINISH:	WEIGHT:	SCALE:	Customer Accessible Production Drawing	
APPLICATOR DATA		APPLICATOR INSTRUCTIONS		APPLICATOR INSTRUCTIONS	
WIRE SIZE		CRIMP HEIGHT		CRIMP HEIGHT REFERENCE SETTING	
1.50mm ²		1.40 +/- 0.05		4.5	
1.00mm ²		1.25 +/- 0.05		6.0	
0.75mm ²		1.15 +/- 0.05		7.0	

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

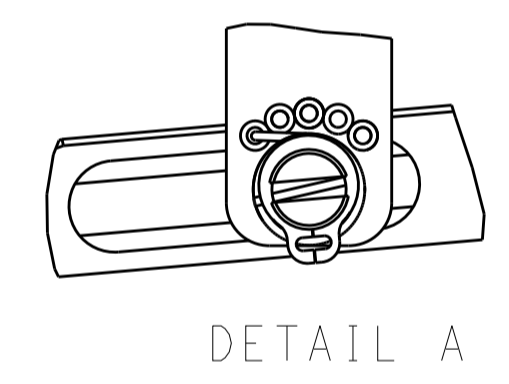
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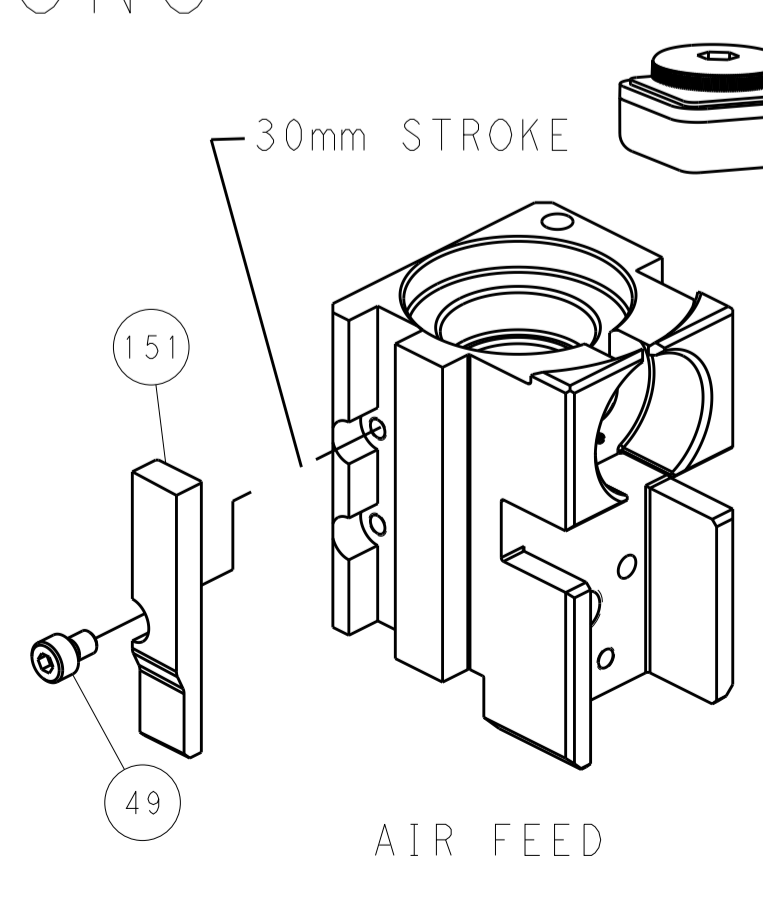
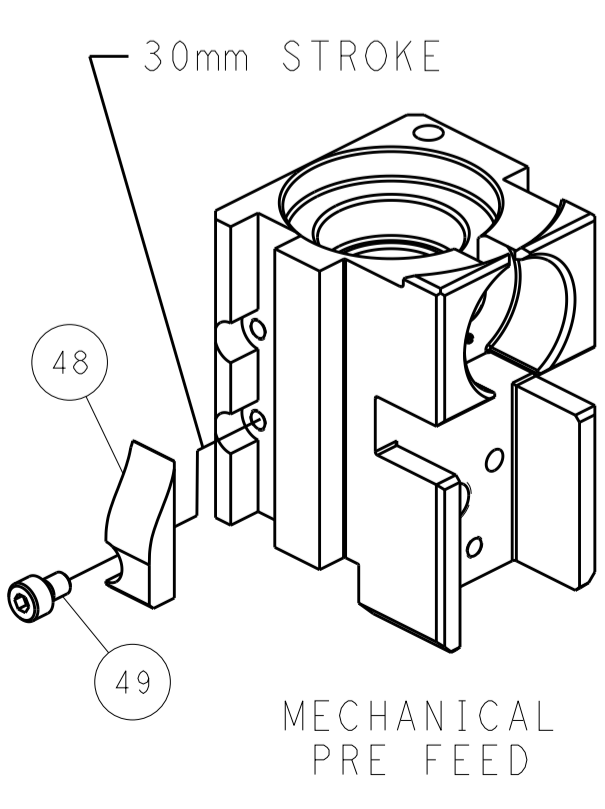
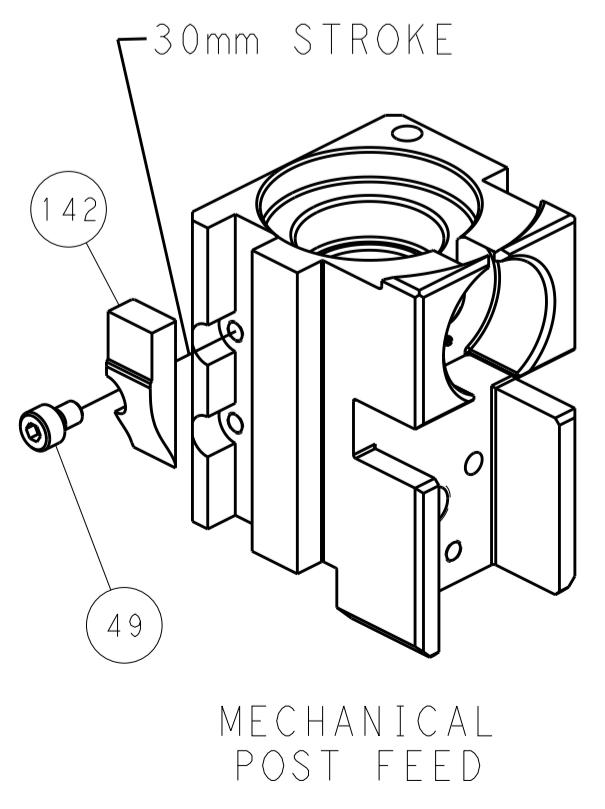
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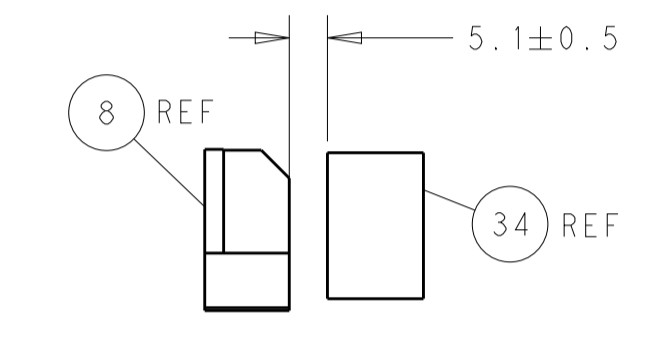
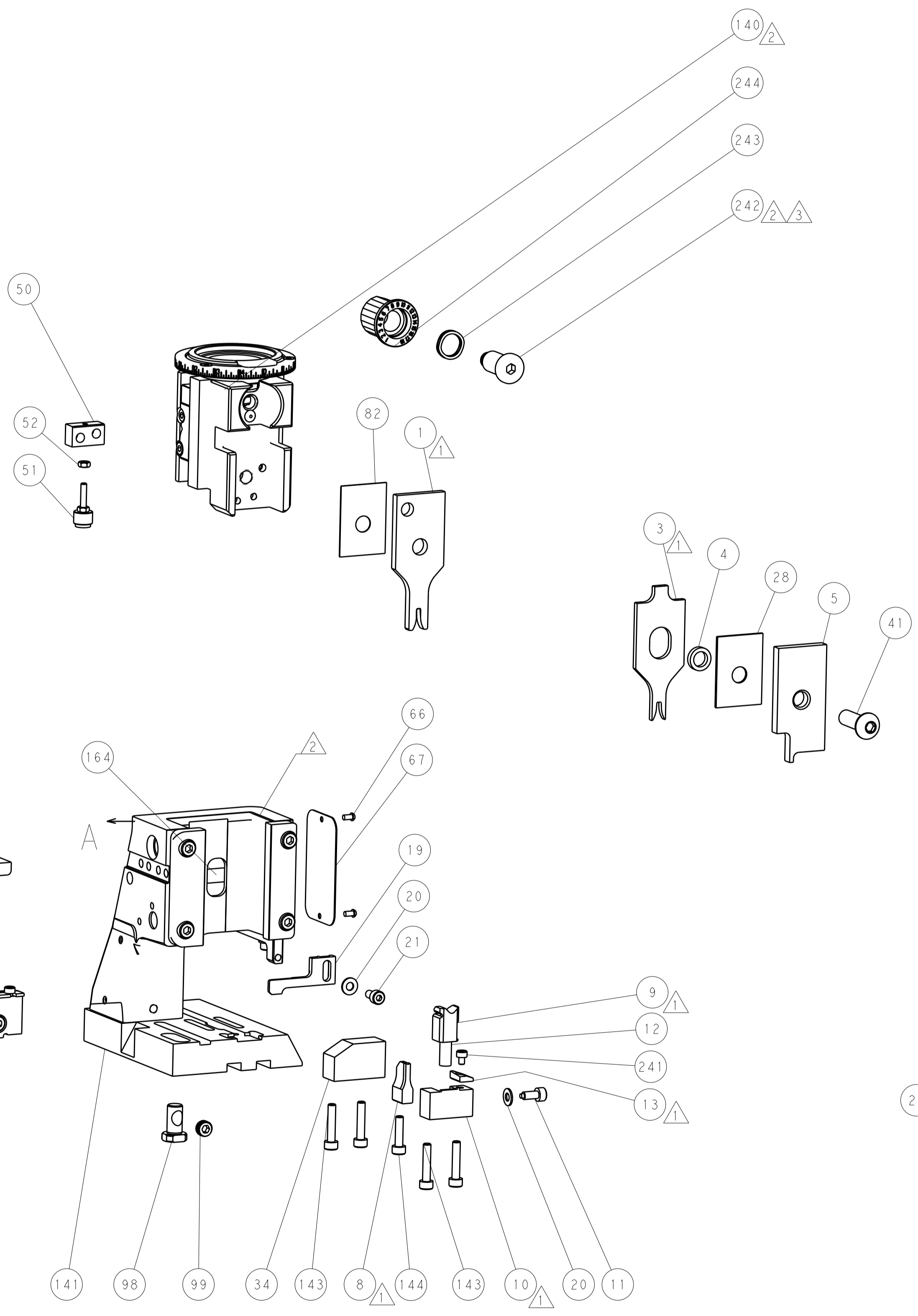
FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



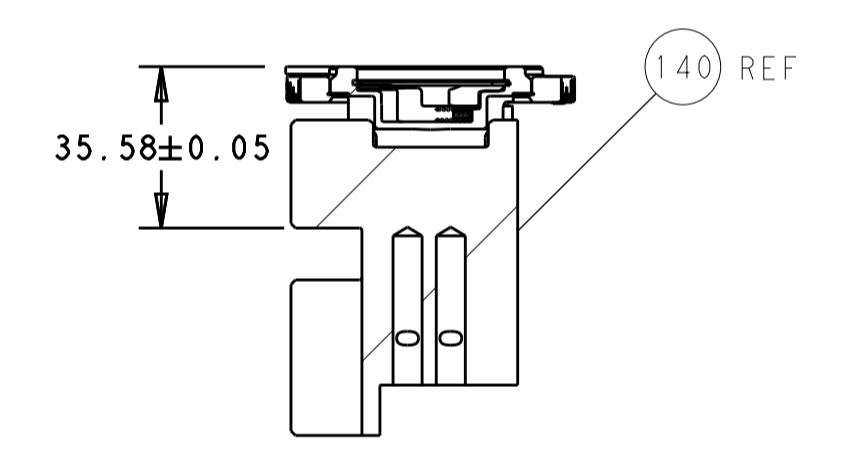
CAM POSITIONS



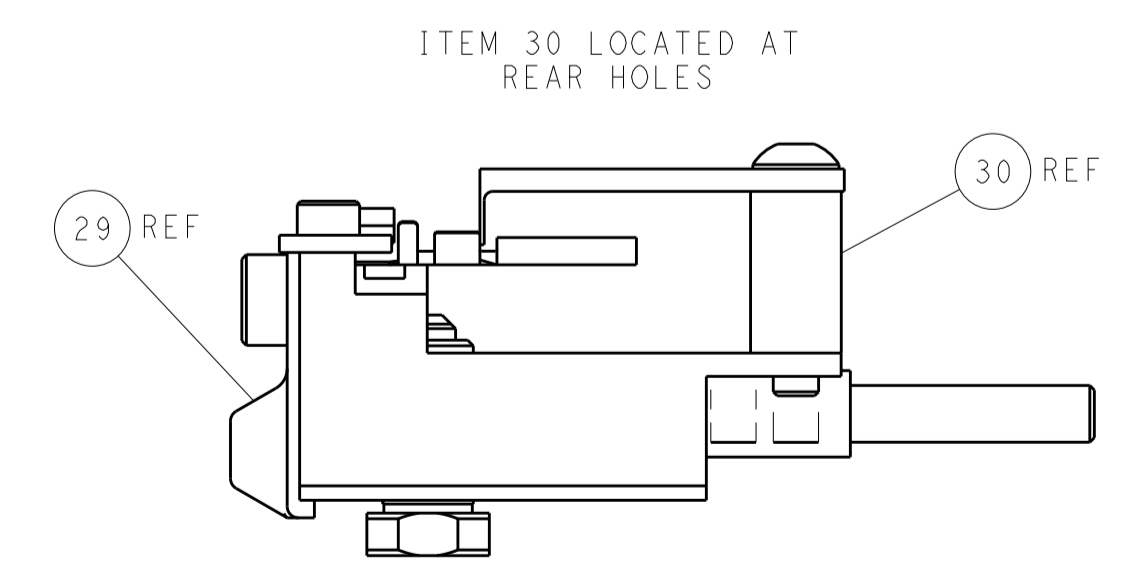
PACIFIC VERSION
 Shown on sheets 3 of 4 & 4 of 4
 (Atlantic version shown on sheets 1 of 4 & 2 of 4)



TERMINAL SUPPORT LOCATION



RAM SET-UP



FEED TRACK POSITION GUIDE BY WIRE BARREL

<small>THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION. IT IS THE PROPERTY OF TYCO ELECTRONICS CORPORATION. IT IS TO BE USED ONLY FOR THE PROJECT AND FOR THE CUSTOMER'S USE. IT IS TO BE RETURNED TO TYCO ELECTRONICS CORPORATION UPON COMPLETION OF THE PROJECT.</small>		DWN: J. HOU 28JULY2016 CHK: L. ZHANG 28JULY2016 APVD: L. ZHANG 28JULY2016	NAME: TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±	PRODUCT SPEC APPLICATION SPEC WEIGHT SCALE: 1:2	SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2836391	RESTRICTED TO: - SHEET 4 OF 4 REV D