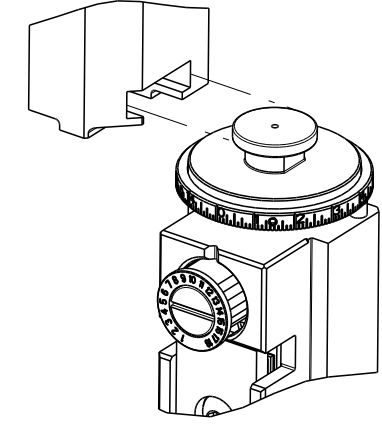


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2836426-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2836426-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2836426-1	B	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2836426-2	B	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2836426-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.03 mm [.080]	F
STABILIZER	4.83 mm [.190]	O
INSUL	2.79 mm [.110]	OV

APPLICATOR INSTRUCTIONS  
408-35042

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: MNL .140 DIA PIN & SOCKET			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
5.94-6.35 mm [.234-.250 IN]		Ø1.40-2.30 mm [.055-.091 IN]	
TERMINAL APPLICATION SPECIFICATION	114-1007		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
927843-1	927843-2	927843-3	927843-4
927841-2	927841-4		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING	STABILIZER SETTINGS
16 AWG OR 1.00mm2	1.42+/-0.05 [.056+/- .002]	5.5	3
18 AWG OR 0.75mm2	1.33+/-0.05 [.052+/- .002]	6.4	2
20 AWG OR 0.50mm2	1.24+/-0.05 [.049+/- .002]	7.2	1

- 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.
- ITEMS 50, 51, 52 & 53 REQUIRED FOR TERMINAL 927841.
- ITEMS 18, 261 REQUIRED FOR TERMINAL 927843.
- SEE TERMINAL APPLICATION SPEC FOR CORRECT STABILIZER CRIMP HEIGHT.

**\*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	27SEP2016	KH	TE
		A1		ECR-17-011990	17AUG2017	RS	LZ
		B		ECR-21-002546	28FEB2021	TB	RK

	-	2	2	2	2	2168083-5	SCR, SKT HD CAP, RoHS, M4 X 6.0	261	
	-	1	1	1	1	1803078-4	SPACER, PRECISION	259	
	1	2	2	1	1	2119787-1	CRIMPER, STABILIZER O PREMIUM	258	
	-	1	1	1	1	238011-2	BLOCK, CRIMPER SPACER	257	
	-	1	1	1	1	2119348-2	SNAIL CAM, STABILIZER CRIMP ADJUSTMENT	256	
	-	2	2	2	2	2079844-1	SPRING PLUNGER, M4	255	
	-	1	1	1	1	2119347-1	KNOB, STABILIZER CRIMP ADJUSTMENT	254	
	-	1	1	1	1	18032-1	SCR, SET, FLT PNT, M3 X 5.0	253	
	-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248	
	-	1	1	1	1	2119082-7	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	
	-	-	1	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239	
	-	1	-	1	-	2844940-1	AIR FEED MODULE	238	
	REF	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164	
	-	1	1	1	1	2844908-1	SCREW, LOCKING	99	
	-	1	1	1	1	2844907-1	POST, LOCKING	98	
	-	1	1	1	1	455888-5	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	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	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	1803515-2	RAM ASSEMBLY, SF ATLANTIC	44	
	-	1	1	1	1	1803602-2	SCR, BHSC, RoHS (M8 X 40)	41	
	-	1	1	1	1	3-1752356-4	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	2119797-2	SPACER, CRIMPER, SPECIAL	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	2119533-3	STRIPPER, SIDE FEED	19	
	-	1	1	1	1	1-457754-0	TOOL, SIZING	18	
	-	1	1	1	1	2119797-1	SPACER, CRIMPER, SPECIAL	15	
	-	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	1	1633776-1	ANVIL	8	
	-	1	1	1	1	2-240641-1	SPACER	7	
	-	-	-	-	-	-	-	6	
	-	1	1	1	1	2119349-2	SHEAR DEPRESSOR, STAB. CRIMP ADJ.	5	
	-	1	1	1	1	2-238011-2	BLOCK, CRIMPER SPACER	4	
	1	2	2	1	1	1803090-2	CRIMPER, INSULATION OV PREM, SPECIAL	3	
	-	1	1	1	1	455888-4	SPACER, CRIMPER	2	
	1	2	2	1	1	2-456405-4	CRIMPER, WIRE PREMIUM	1	
		-77	-72	-71	-2	-1	PART NO	DESCRIPTION	ITEM NO

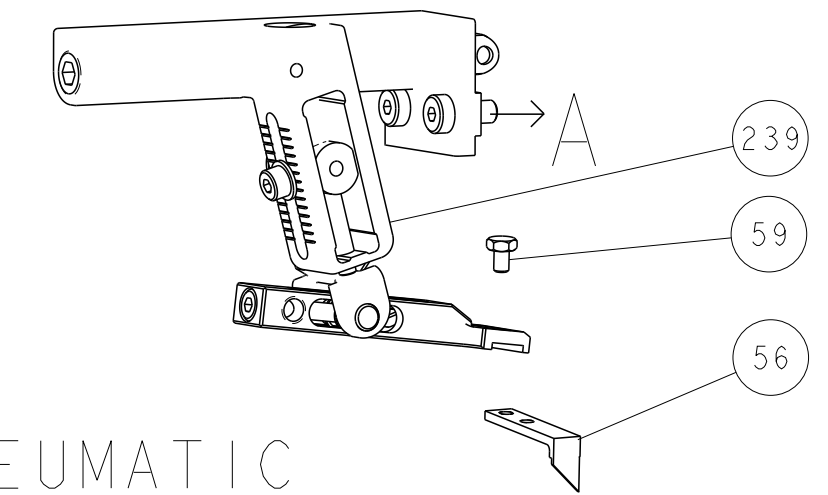
ATLANTIC VERSION  
Shown on sheets 1 of 4 & 2 of 4  
(Pacific version shown on sheets 3 of 4 & 4 of 4)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		MATERIAL:		FINISH:		WEIGHT:		SCALE:		SHEET:		REV:	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES	FINISH			A1	00779	2836426	1	4	B

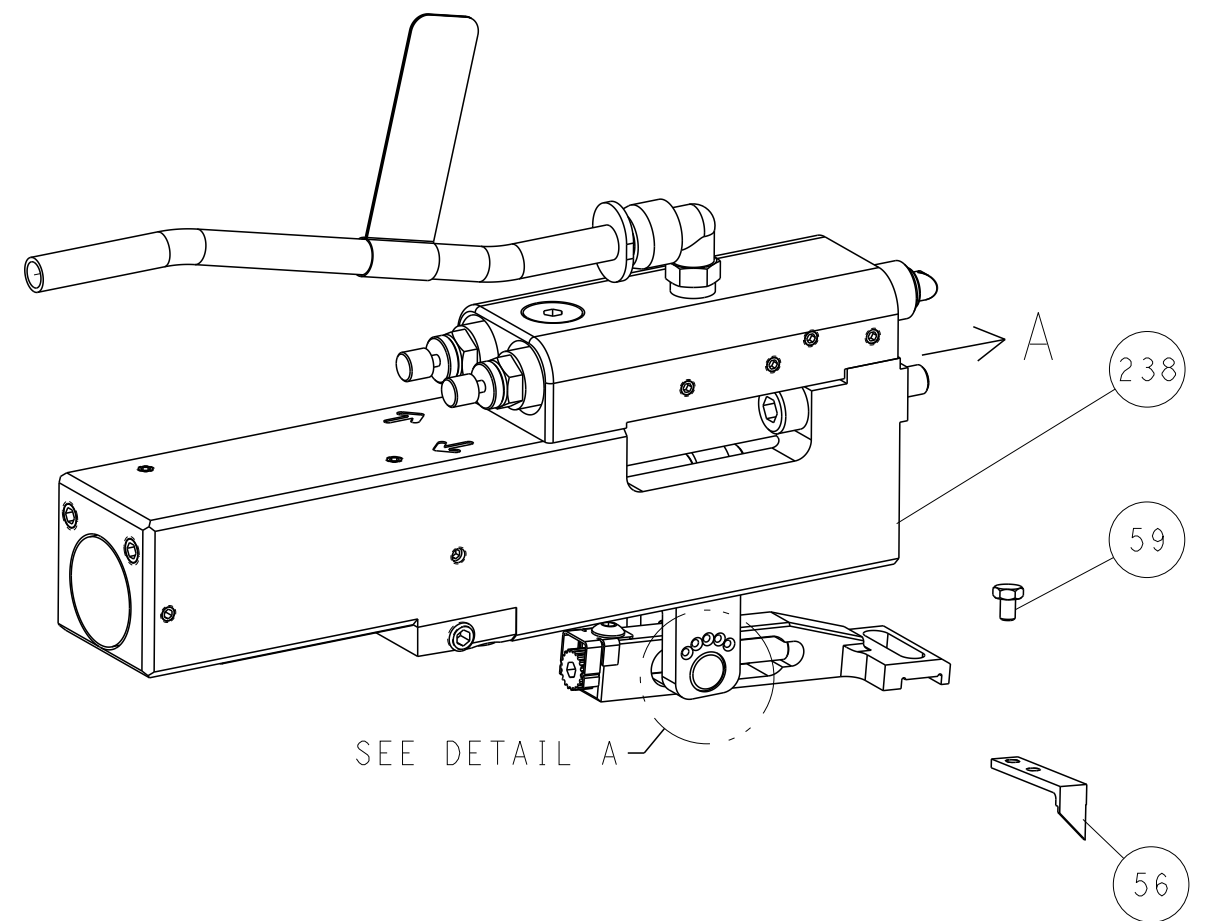
Customer Accessible Production Drawing

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

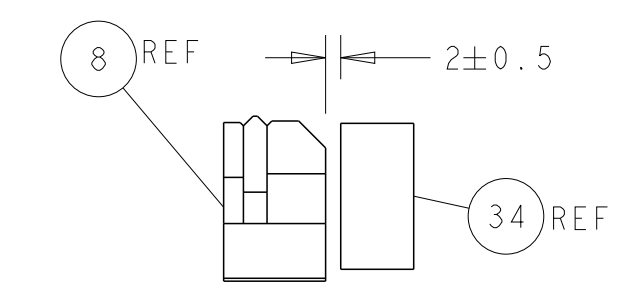
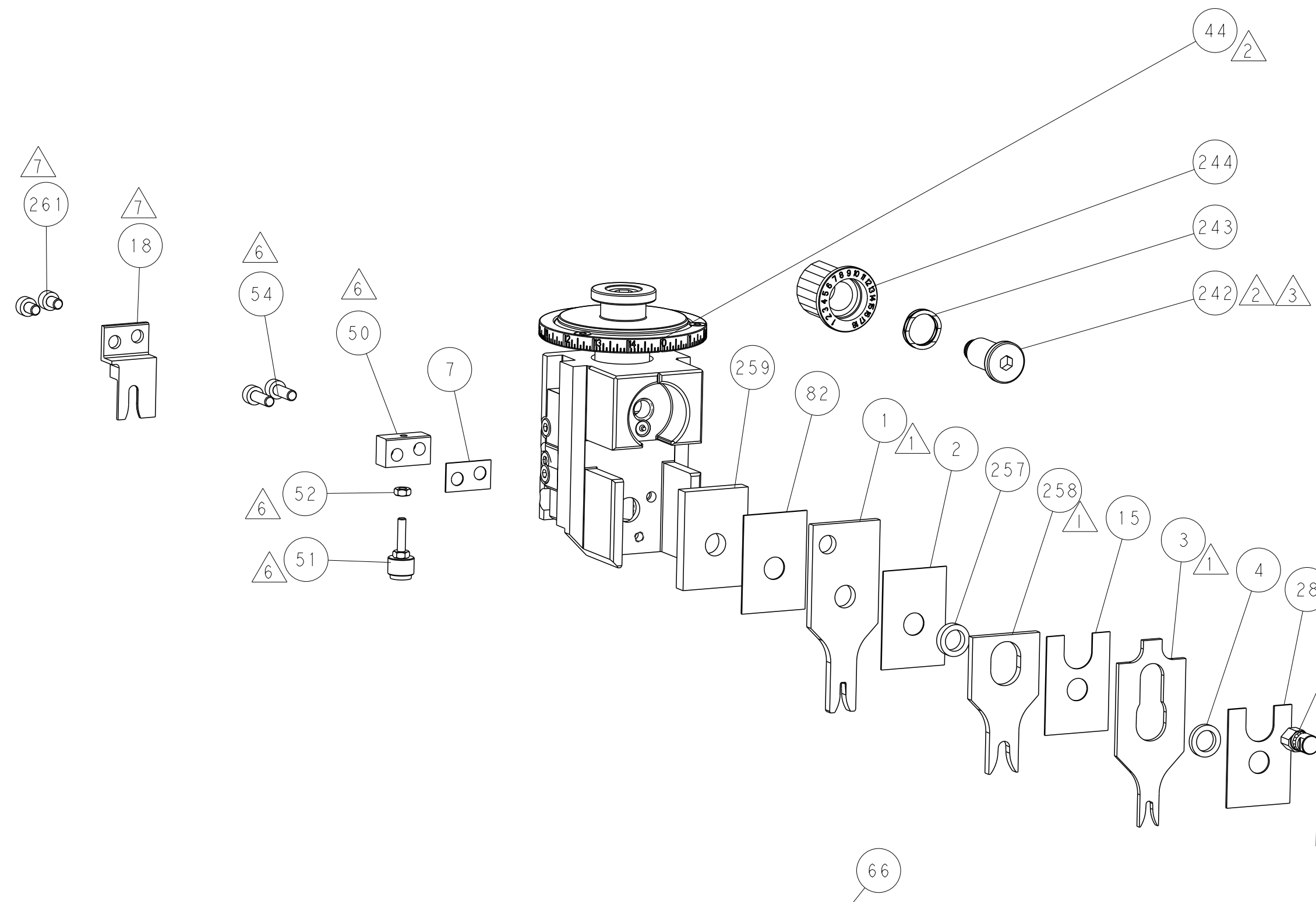
# FEED TYPE MECHANICAL



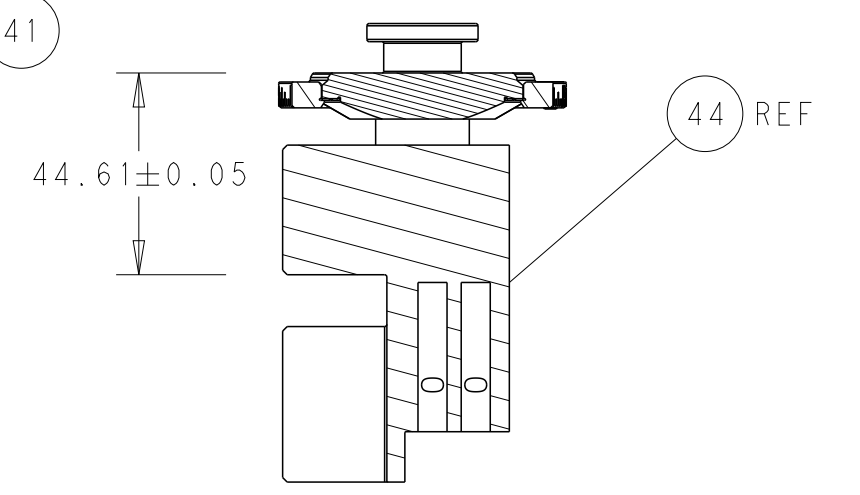
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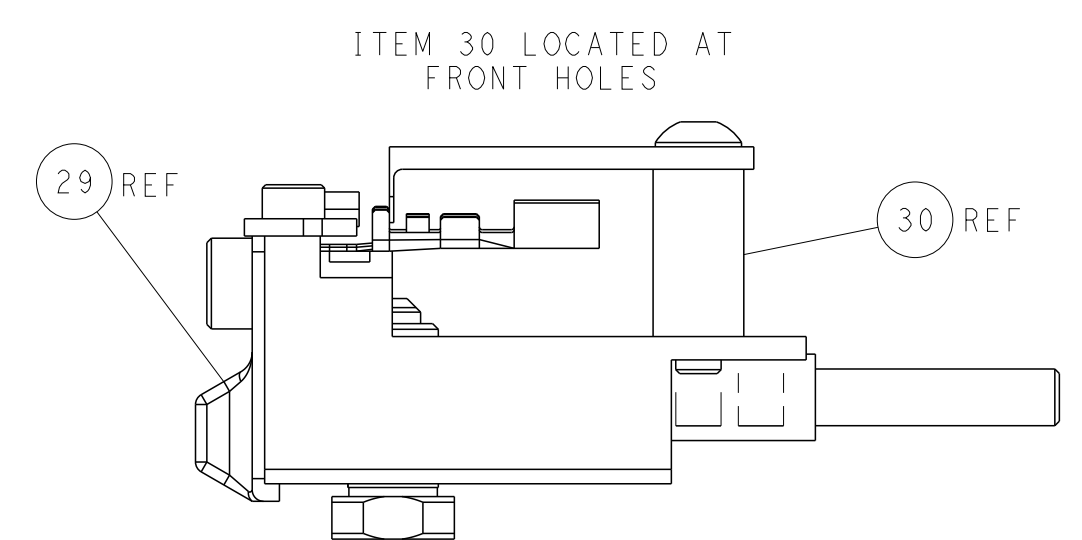
## FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



TERMINAL SUPPORT LOCATION

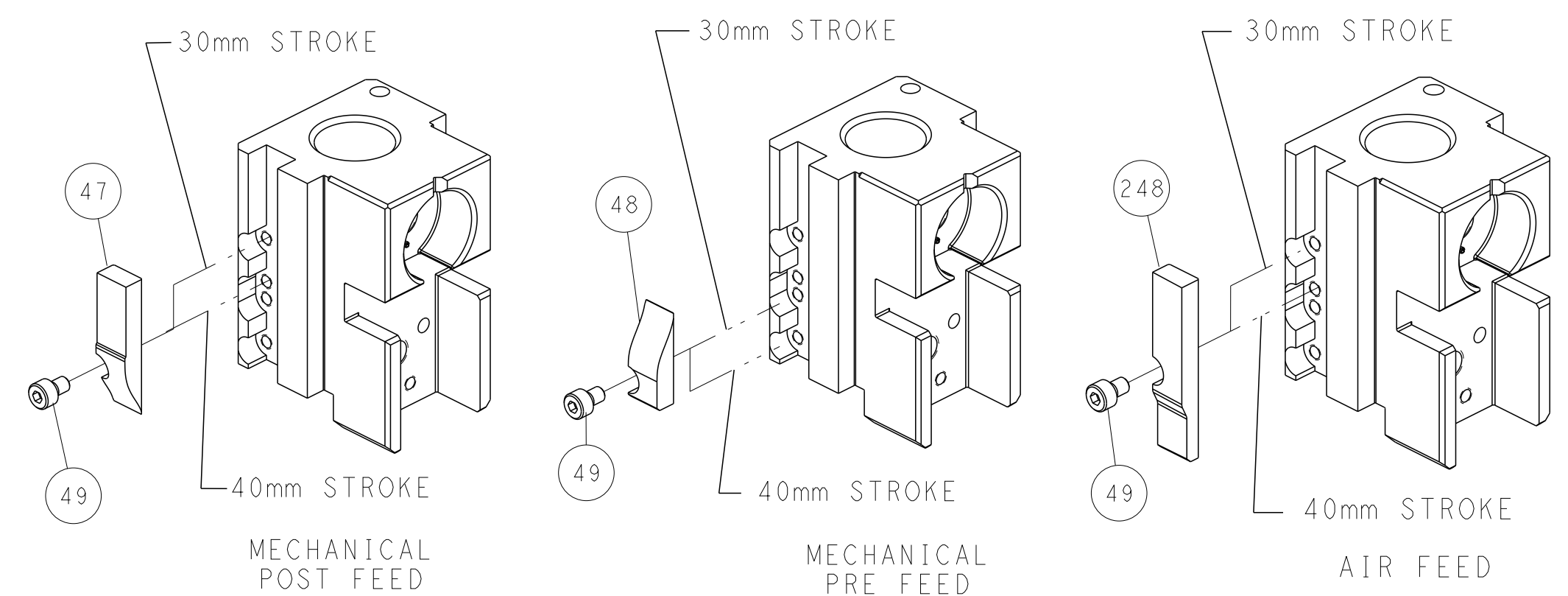


RAM SET-UP



FEED TRACK POSITION GUIDE BY INSULATION 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:		DWN R. HUANG 18AUG2016		TE Connectivity Harrisburg, PA 17105-3608	
mm	0 PLC	±		CHK L. ZHANG 18AUG2016	NAME	Ocean Side Feed Applicator	
	1 PLC	±		APVD L. ZHANG 18AUG2016	PRODUCT SPEC	SIZE	CAGE CODE
	2 PLC	±			APPLICATION SPEC	A1	00779
	3 PLC	±			WEIGHT	SCALE	1:2
	4 PLC	±			RESTRICTED TO	SHEET	2 OF 4
	ANGLES	±			Customer Accessible Production Drawing	REV	B
	FINISH	±					

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2836426-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2836426-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2836426-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR  
 INTERFACE ADAPTER



APPLICATOR DATA

CRIMP	SIZE	TYPE
WIRE	2.03 mm [.080]	F
STABILIZER	4.83 mm [.190]	O
INSUL	2.79 mm [.110]	OV

APPLICATOR INSTRUCTIONS  
 408-35042

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION

TERMINAL NAME: MNL .140 DIA PIN & SOCKET

WIRE STRIP LENGTH	INSULATION DIAMETER RANGE
5.94-6.35 mm [.234-.250 IN]	Ø1.40-2.30 mm [.055-.091 IN]

TERMINAL APPLICATION SPECIFICATION

TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
927843-1	927843-2	927843-3	927843-4
927841-2	927841-4		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING	STABILIZER SETTINGS
16 AWG OR 1.00mm <sup>2</sup>	1.42+/-0.05 [.056+/-0.002]	5.5	3
18 AWG OR 0.75mm <sup>2</sup>	1.33+/-0.05 [.052+/-0.002]	6.4	2
20 AWG OR 0.50mm <sup>2</sup>	1.24+/-0.05 [.049+/-0.002]	7.2	1



- 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.
- UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- ITEMS 50, 51, 52 & 53 REQUIRED FOR TERMINAL 927841.
- ITEMS 18, 261 REQUIRED FOR TERMINAL 927843.
- SEE TERMINAL APPLICATION SPEC FOR CORRECT STABILIZER CRIMP HEIGHT.

**\*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				

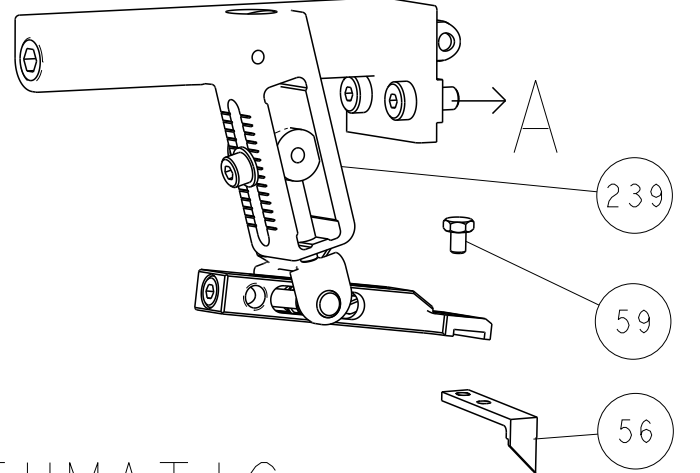
REV	DATE	BY	APPV	DESCRIPTION	ITEM NO
-	2	2		2168083-5 SCR, SKT HD CAP, RoHS, M4 X 6.0	261
-	1	1		1803078-4 SPACER, PRECISION	259
1	1	1		2119787-1 CRIMPER, STABILIZER O PREMIUM	258
-	1	1		238011-2 BLOCK, CRIMPER SPACER	257
-	1	1		2119348-2 SNAIL CAM, STABILIZER CRIMP ADJUSTMENT	256
-	2	2		2079844-1 SPRING PLUNGER, M4	255
-	1	1		2119347-1 KNOB, STABILIZER CRIMP ADJUSTMENT	254
-	1	1		18032-1 SCR, SET, FLT PNT, M3 X 5.0	253
-	1	1		2119082-7 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		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		1803516-2 RAM ASSEMBLY, SF PACIFIC	140
-	1	1		2844908-1 SCREW, LOCKING	99
-	1	1		2844907-1 POST, LOCKING	98
-	1	1		455888-5 SPACER, CRIMPER	82
-	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		5-18022-5 SCR, HEX HD CAP, M4 X 6.0	59
-	1	1		1338685-1 PAWL, FEED	56
6	2	2		2168083-3 SCR, SKT HD CAP, RoHS, M4 X 12.0	53
6	1	1		5018030-1 NUT, HEX, REG, RoHS, M3	52
6	1	1		811242-5 BUMPER, HOLD DOWN	51
6	1	1		690753-2 SPACER, TONKER	50
-	1	2		18023-9 SCR, SKT HD CAP M4 X 6.0	49
-	-	1		2119652-1 FEED CAM, PRE FEED	48
-	1	1		1803602-2 SCR, BHSC, RoHS (M8 X 40)	41
-	1	1		3-1752356-4 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		2119797-2 SPACER, CRIMPER, SPECIAL	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		2119533-3 STRIPPER, SIDE FEED	19
1	1	1		1-457754-0 TOOL, SIZING	18
-	1	1		2119797-1 SPACER, CRIMPER, SPECIAL	15
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	1		2119805-1 SHEAR HOLDER, FRONT	10
1	1	1		1803095-6 FLOATING SHEAR, FRONT	9
1	1	1		1633776-1 ANVIL	8
-	1	1		2-240641-1 SPACER	7
-	-	-		-	6
-	1	1		2119349-2 SHEAR DEPRESSOR, STAB. CRIMP ADJ.	5
-	1	1		2-238011-2 BLOCK, CRIMPER SPACER	4
1	1	1		1803090-2 CRIMPER, INSULATION OV PREM, SPECIAL	3
-	1	1		455888-4 SPACER, CRIMPER	2
1	1	1		2-456405-4 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)

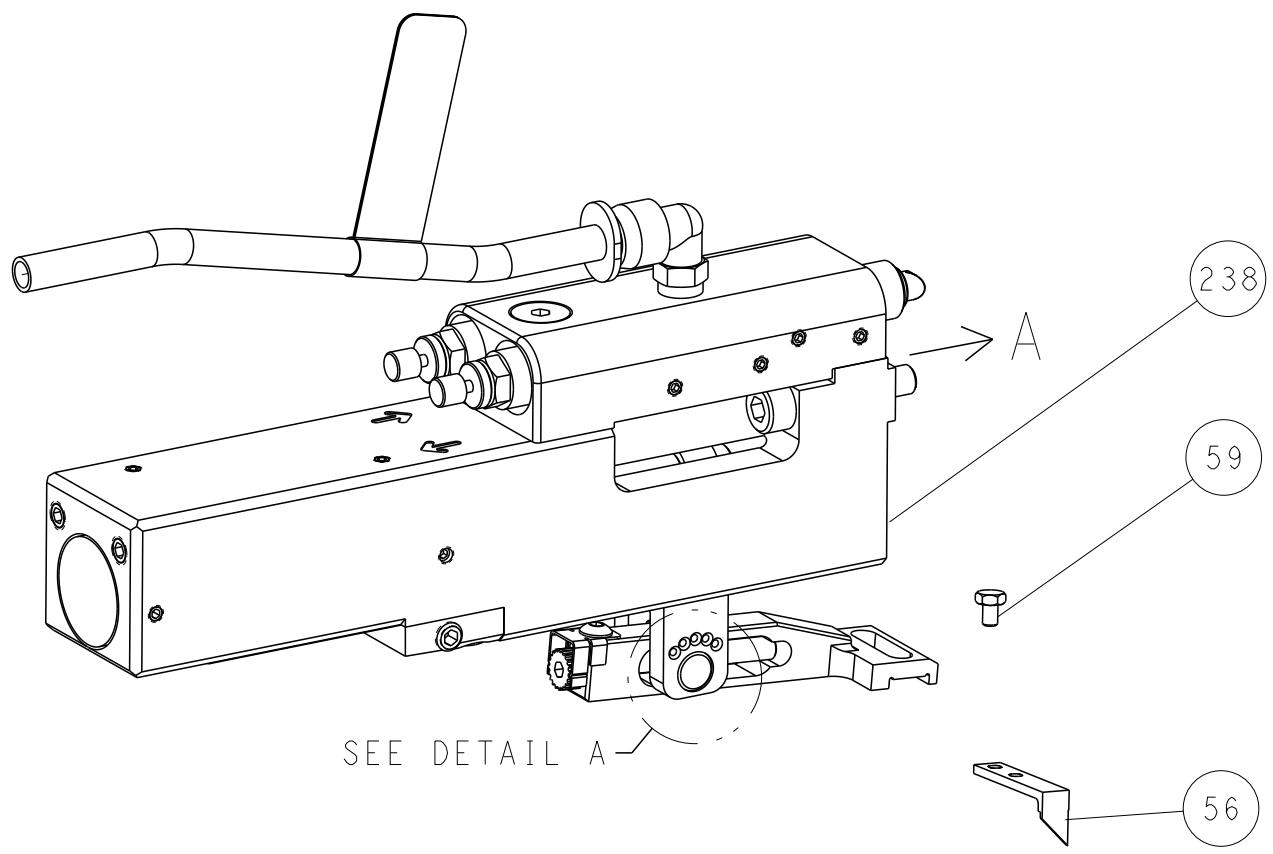
DIMENSIONS:	TOLERANCES UNLESS OTHERWISE SPECIFIED:	APV	DATE	DESCRIPTION	ITEM NO
mm	0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH	L. ZHANG	18AUG2016	Ocean Side Feed Applicator	
MATERIAL:				Customer Accessible Production Drawing	

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

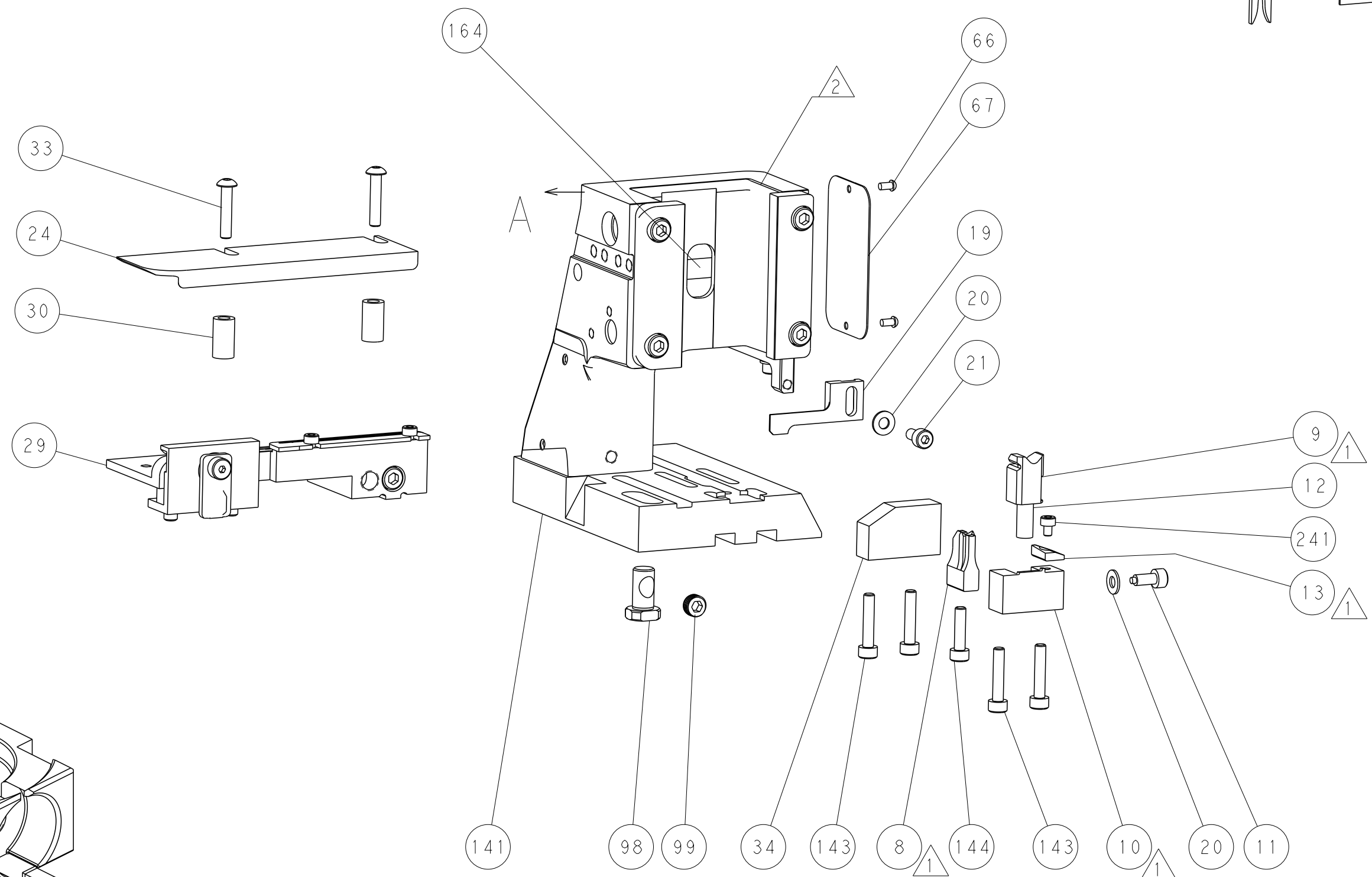
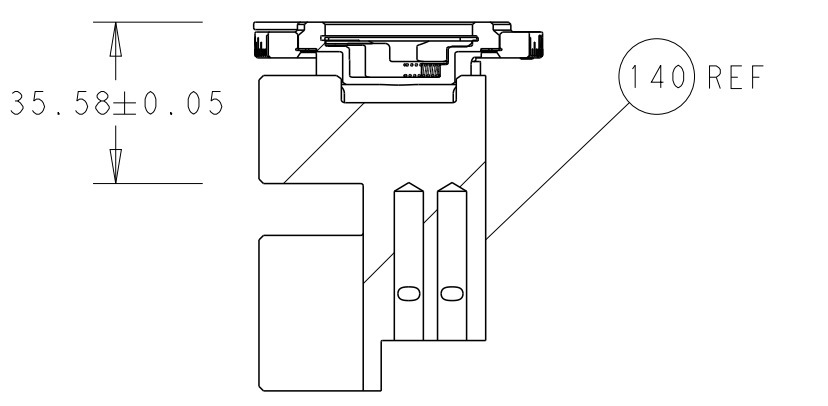
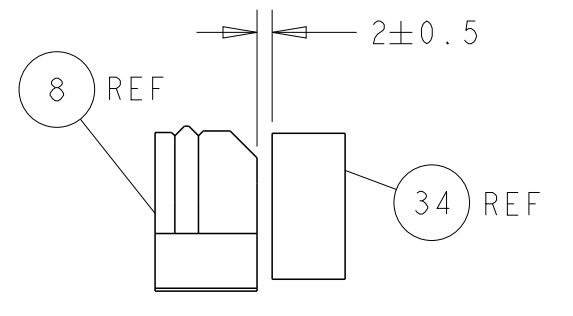
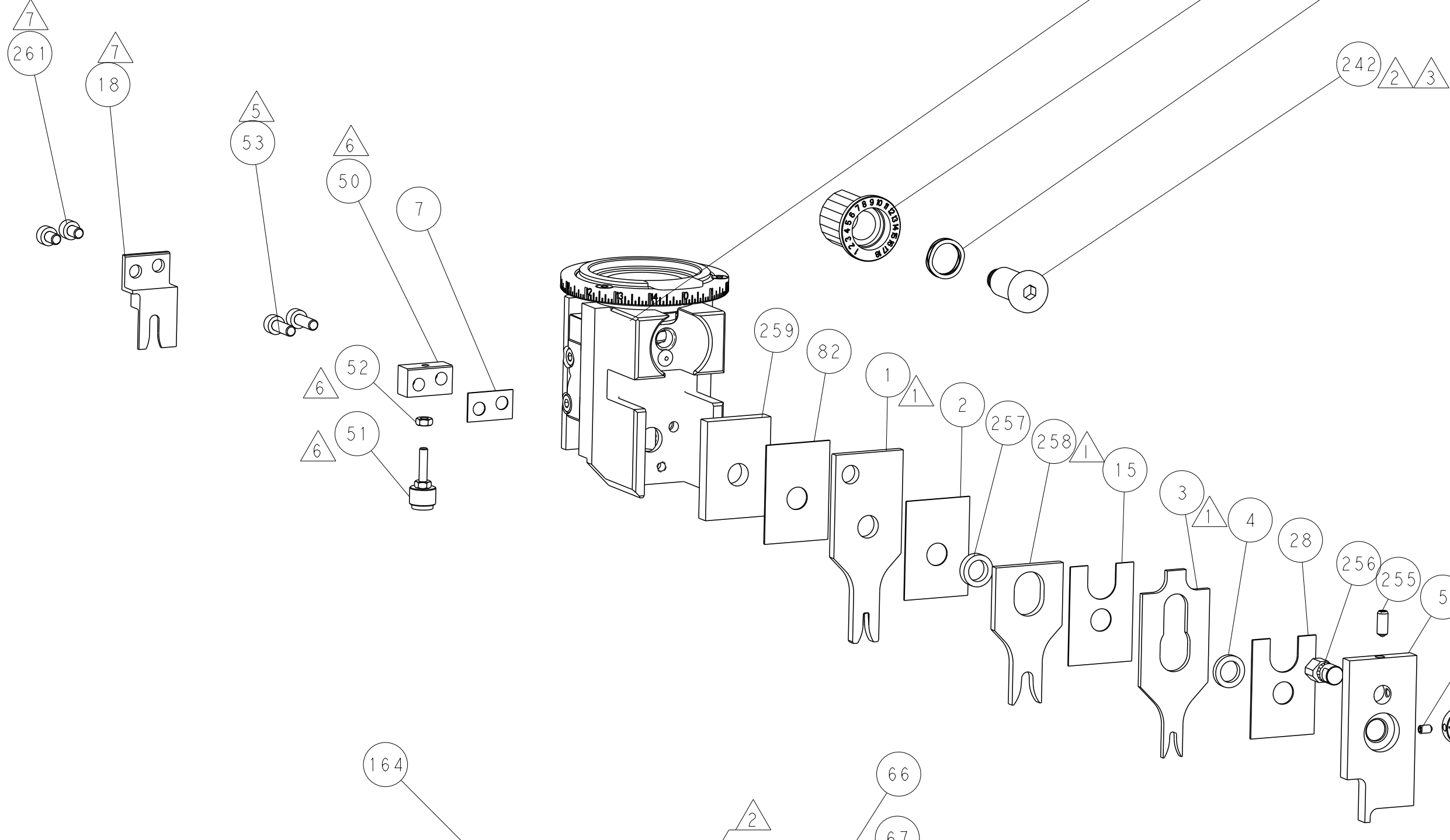
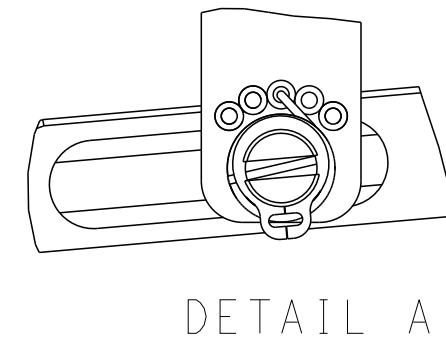
# FEED TYPE MECHANICAL



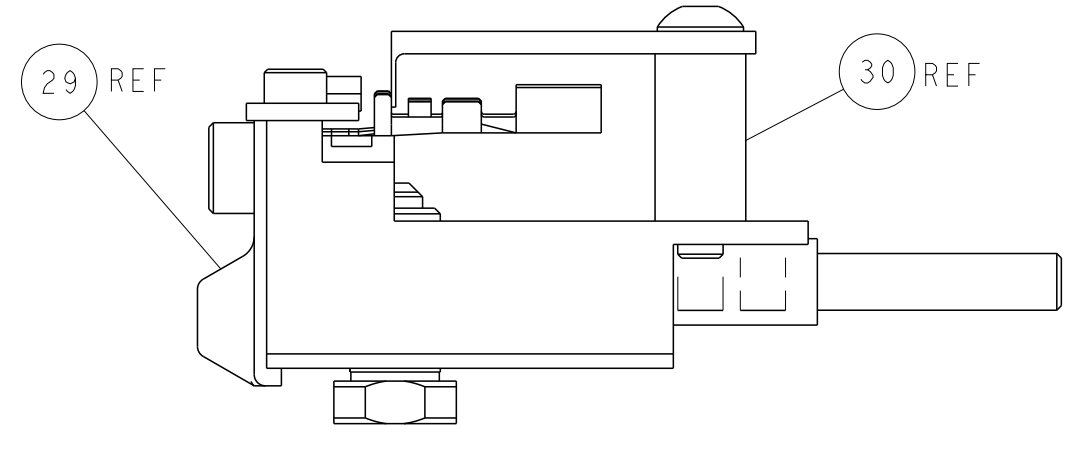
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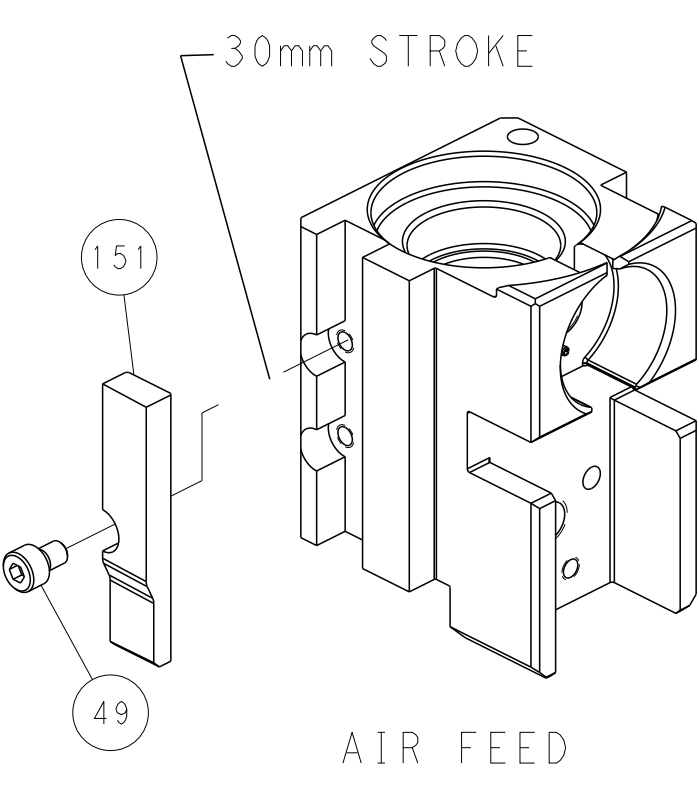
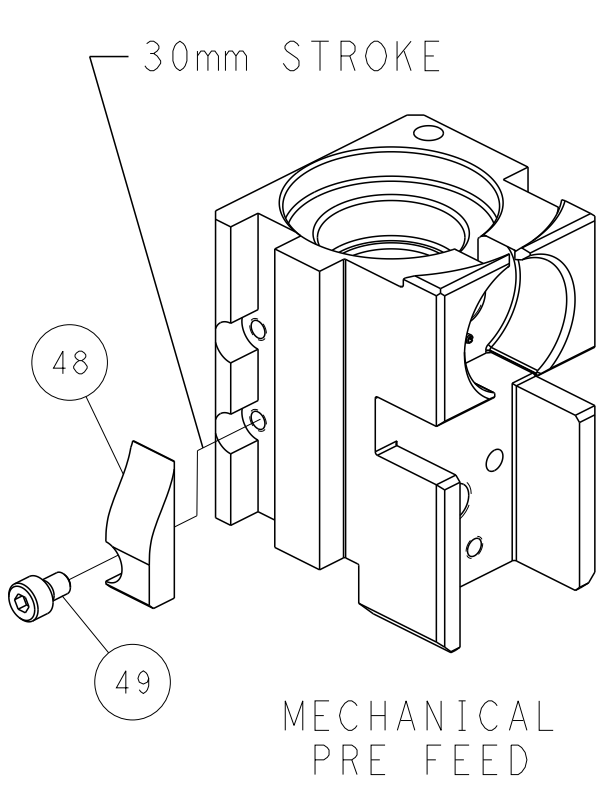
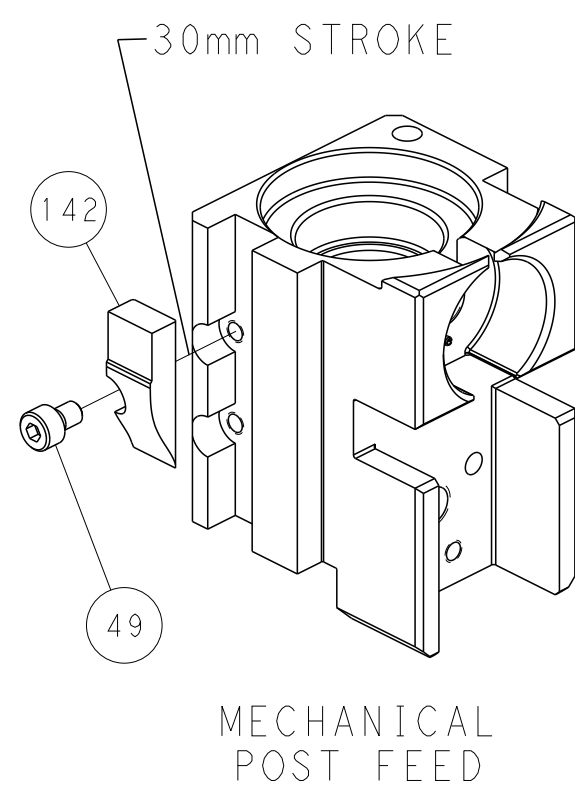
### FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



ITEM 30 LOCATED AT  
FRONT HOLES



## CAM POSITIONS



**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 R. HUANG 18AUG2016		CHK L. ZHANG 18AUG2016		NAME Ocean Side Feed Applicator	
mm	0 PLC	±		PRODUCT SPEC		SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
	1 PLC	±		APPLICATION SPEC		A1	00779	2836426	
	2 PLC	±				Customer Accessible Production Drawing		SCALE	1:2
	3 PLC	±						SHEET	4 OF 4
	4 PLC	±						REV	B
	ANGLES	±							
	FINISH	±							