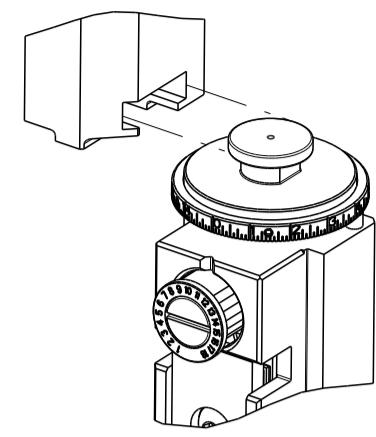


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2836458-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2836458-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2836458-1	B	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2836458-2	B	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2836458-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



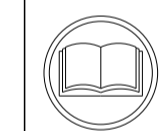
APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.00 mm [.079]	F
INSUL	4.00 mm [.157]	O

APPLICATOR INSTRUCTIONS 408-35042

TERMINAL DATA: TRW TERMINAL		TRW CRIMP SPECIFICATION	
TERMINAL NAME: CONTACT TERMINAL			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
3.47-4.23 mm [.137-.167 IN]		Ø	
TERMINAL APPLICATION SPECIFICATION		Y08 080 3799 Rev 25.05.2009	-

TERMINALS APPLIED				SEAL INSULATION DIAMETER RANGE
TE TERMINAL	TRW TERMINAL	TE SEAL	TRW SEAL	
2303664-1	Y080803799	2303665-1	3918056850	1.52-1.84

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.85mm2	1.41+/-0.03 [.056+/- .001]	7.4
0.75mm2	1.31+/-0.03 [.052+/- .001]	8.6
0.60mm2	1.28+/-0.03 [.050+/- .001]	8.9
0.50mm2	1.25+/-0.03 [.049+/- .001]	9.2



- 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 APPLY TORO-SEAL IN ALLEN SOCKET TO FILL HOLE AFTER FLAT HD HAS BEEN ADJUSTED TO CORRECT HEIGHT AT QUALIFICATION. APPLY #1-23419-5 LOC-TITE TO THREADS.
- 6. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.

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

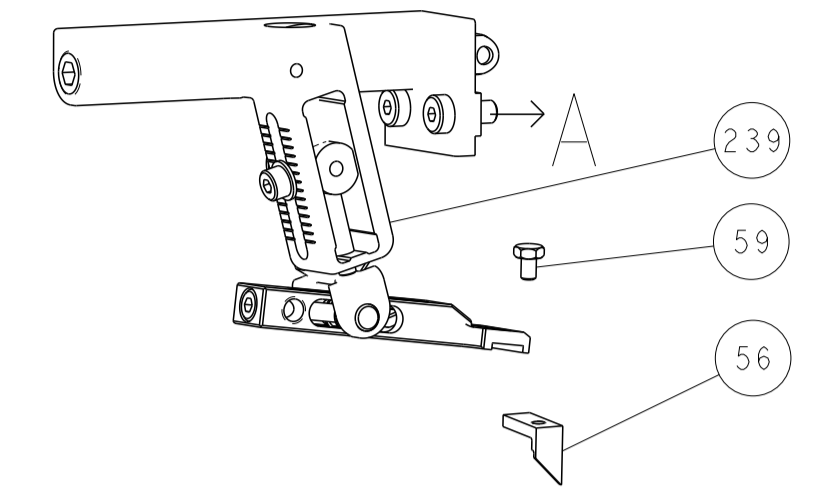
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		P	LTN	DESCRIPTION	DATE	OWN	APVD
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		A		RELEASED	01DEC2016	MEH	TE
		B		ECR-19-003382	03MAR2019	TB	CT

-	1	1	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	283	
-	1	1	1	1	2280441-1	INSERT, SHEAR	282	
-	1	-	1	-	2119640-1	PUSH ROD, AIR FEED	250	
-	1	-	1	-	1803259-1	BUSHING, FLANGED	249	
-	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	
-	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242	
-	-	1	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239	
-	1	-	1	-	2063440-1	AIR FEED MODULE	238	
-	1	1	1	1	356885-6	STOP, SHEAR	237	
-	1	1	1	1	462843-7	TERMINAL SUPPORT	175	
-	2	-	2	-	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172	
-	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164	
-	1	-	1	-	240638-1	SPRING, FEED FINGER	163	
-	1	-	1	-	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854	137	
-	1	-	1	-	2119799-1	HOLDER, FEED FINGER, AF	136	
-	1	1	1	1	1-22281-8	SPRING, COMPRESSION	121	
-	1	1	1	1	2844908-1	SCREW, LOCKING	99	
-	1	1	1	1	2844907-1	POST, LOCKING	98	
-	1	1	1	1	1803258-1	FRONT STRIP GUIDE	96	
-	2	2	2	2	1-2168083-3	SCR, SKT HD CAP, RoHS, M3 X 16	95	
-	1	1	1	1	2168083-6	SCR, SKT HD CAP, RoHS, M5 X 65	93	
-	1	1	1	1	455888-9	SPACER, CRIMPER	82	
-	1	1	1	1	3-240641-0	SPACER	81	
-	1	1	1	1	1803607-1	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	
-	2	2	2	2	2-18032-5	SCR, SET, FLT PNT, M5 X 20.0	61	
-	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	985575-3	SCR, FLT SKT HD CAP M3 X 10.0	57	
-	1	1	1	1	1-1338683-0	FEED PAWL	56	
-	4	4	4	4	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	54	
-	2	2	2	2	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	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	
-	2	2	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	33	
-	1	1	1	1	2-2305692-4	PLATE, REAR STRIP GUIDE	29	
-	1	1	1	1	455888-4	SPACER, CRIMPER	28	
-	2	2	2	2	22281-8	SPRING, COMPRESSION	27	
-	1	1	1	1	356835-1	LEVER, DRAG RELEASE	26	
-	1	1	1	1	240792-3	DRAG, TERMINAL	25	
-	1	1	1	1	2-189124-4	GUIDE, FRONT STRIP	24	
-	1	1	1	1	980371-4	SCR, SKT HD SHLDR 5.0 DIA X 6.0	23	
-	1	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21	
-	1	1	1	1	1-18028-2	WASHER, FLAT, REG M4	20	
-	1	1	1	1	2119533-1	STRIPPER, SIDE FEED	19	
-	1	1	1	1	690463-2	FLOATING SHEAR, REAR	17	
-	2	2	2	2	1-2168083-1	SCR, SKT HD CAP, RoHS, M3 X 6	16	
-	1	1	1	1	1-690464-6	SHEAR PLATE, REAR	15	
-	1	1	1	1	2119862-1	SHEAR HOLDER, REAR	14	
-	1	1	1	1	3-22280-3	SPRING, COMPRESSION	12	
-	-	-	-	-	-	-	10	
-	-	-	-	-	-	-	9	
-	1	2	2	1	1	3-1803252-8	ANVIL, COMBINATION	8
-	-	-	-	-	-	-	7	
-	1	1	1	1	1	690468-7	DEPRESSOR SHEAR, REAR	6
-	1	1	1	1	1	2119781-1	DEPRESSOR, SHEAR	5
-	-	-	-	-	-	-	5	
-	1	1	1	1	1	238011-4	BLOCK, CRIMPER SPACER	4
-	1	2	2	1	1	6-1633965-9	CRIMPER, INSULATION O PREMIUM	3
-	1	1	1	1	1	455888-6	SPACER, CRIMPER	2
-	1	2	2	1	1	6-1803241-9	CRIMPER, WIRE F	1

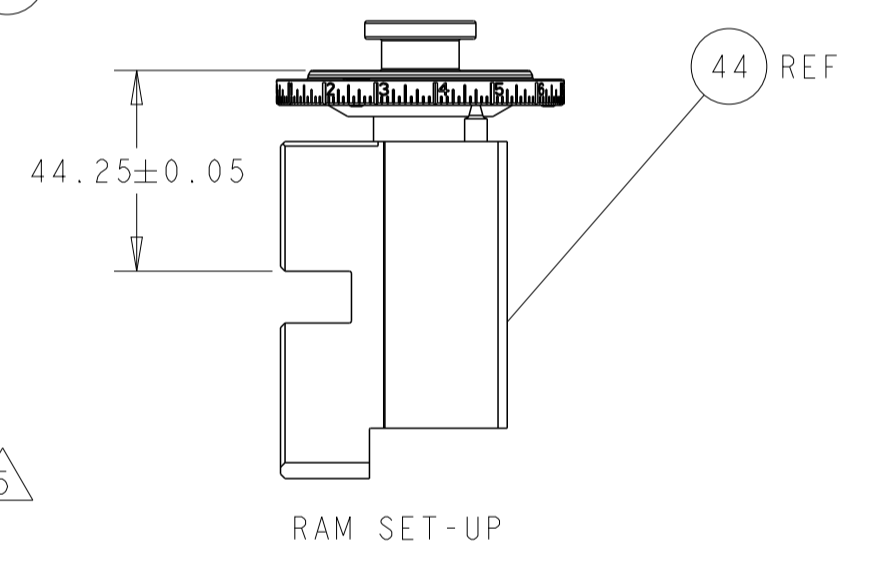
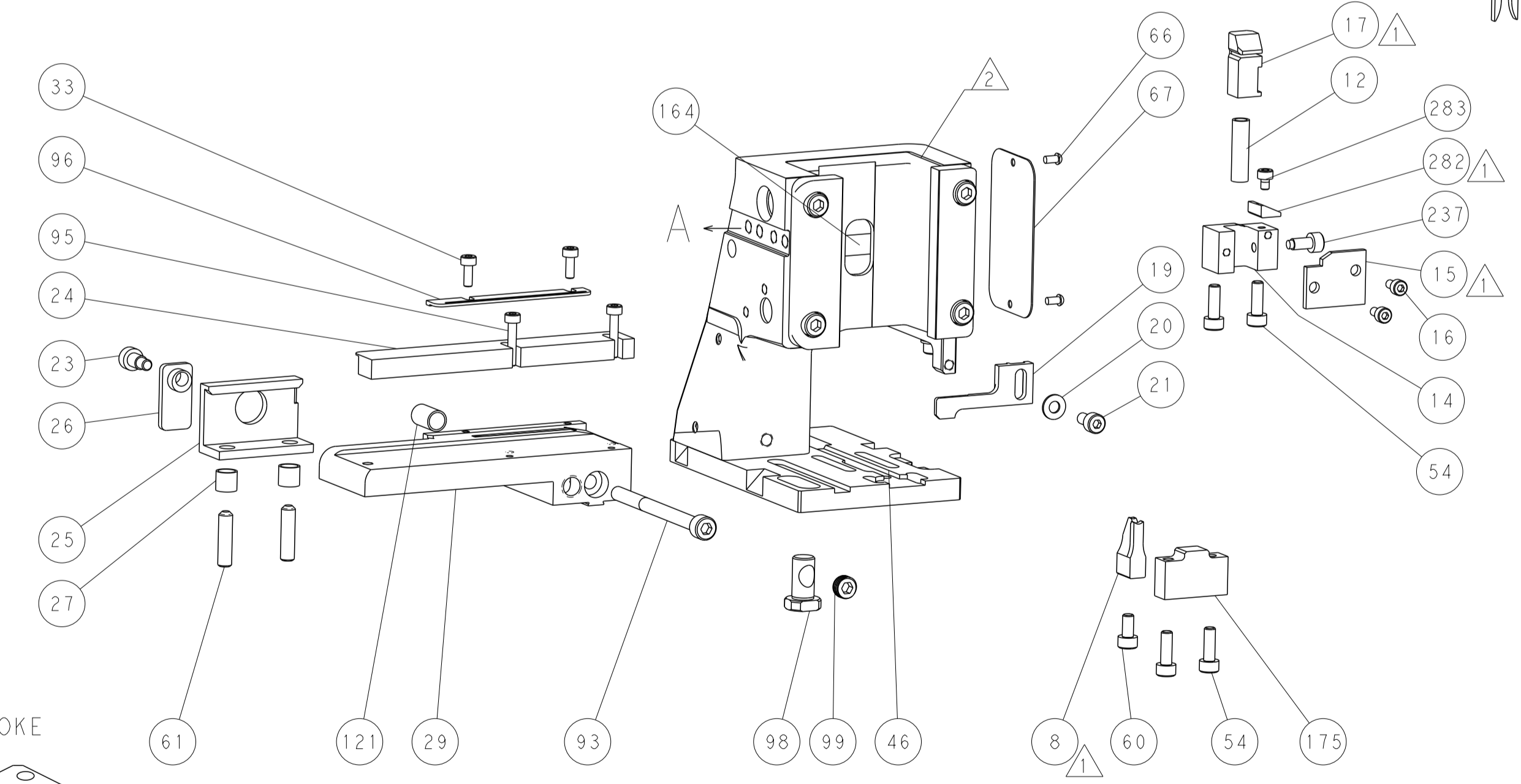
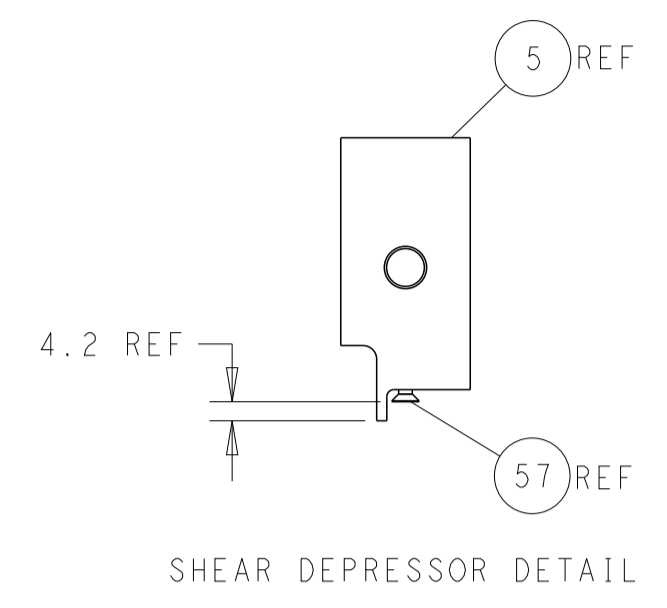
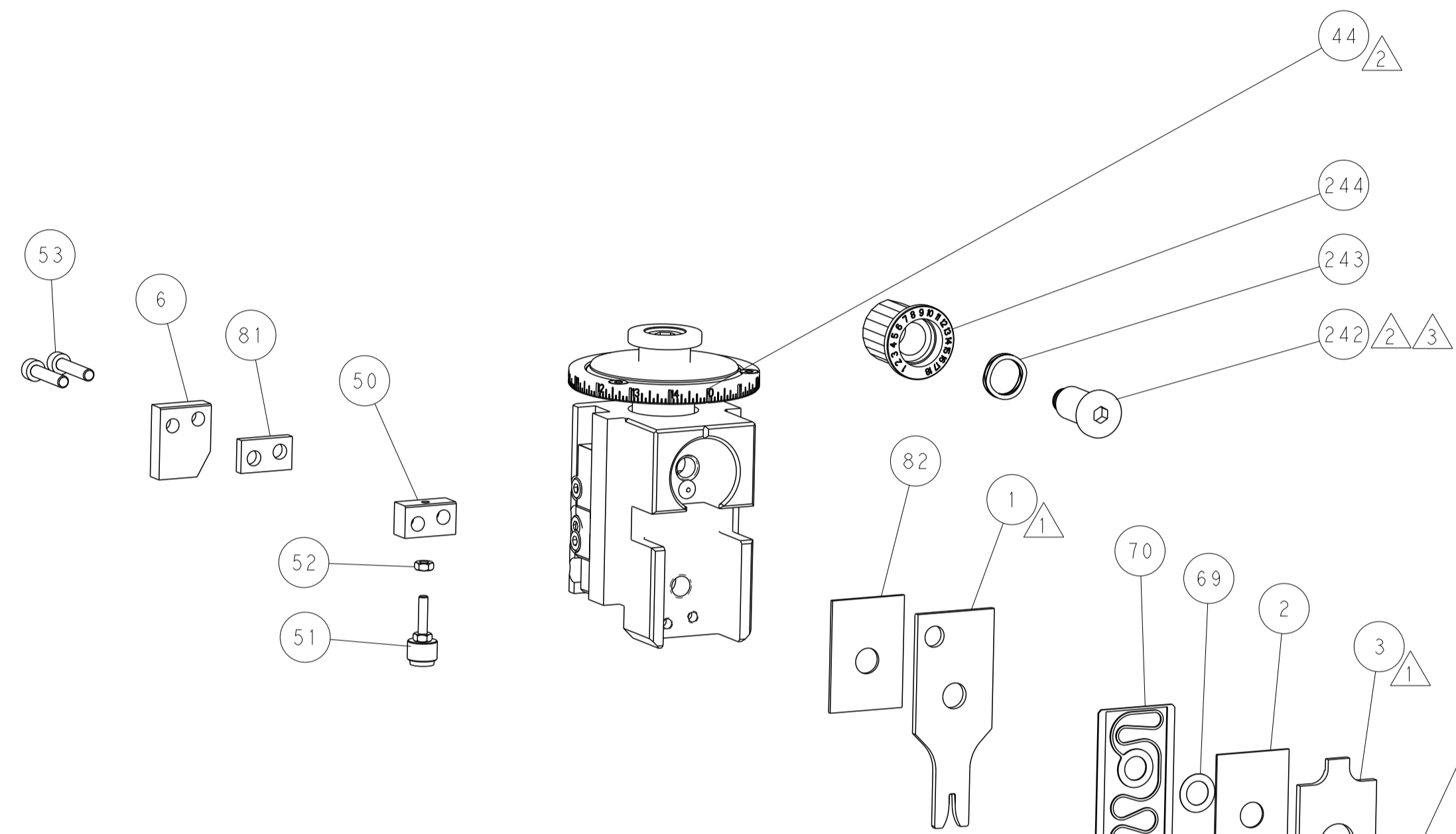
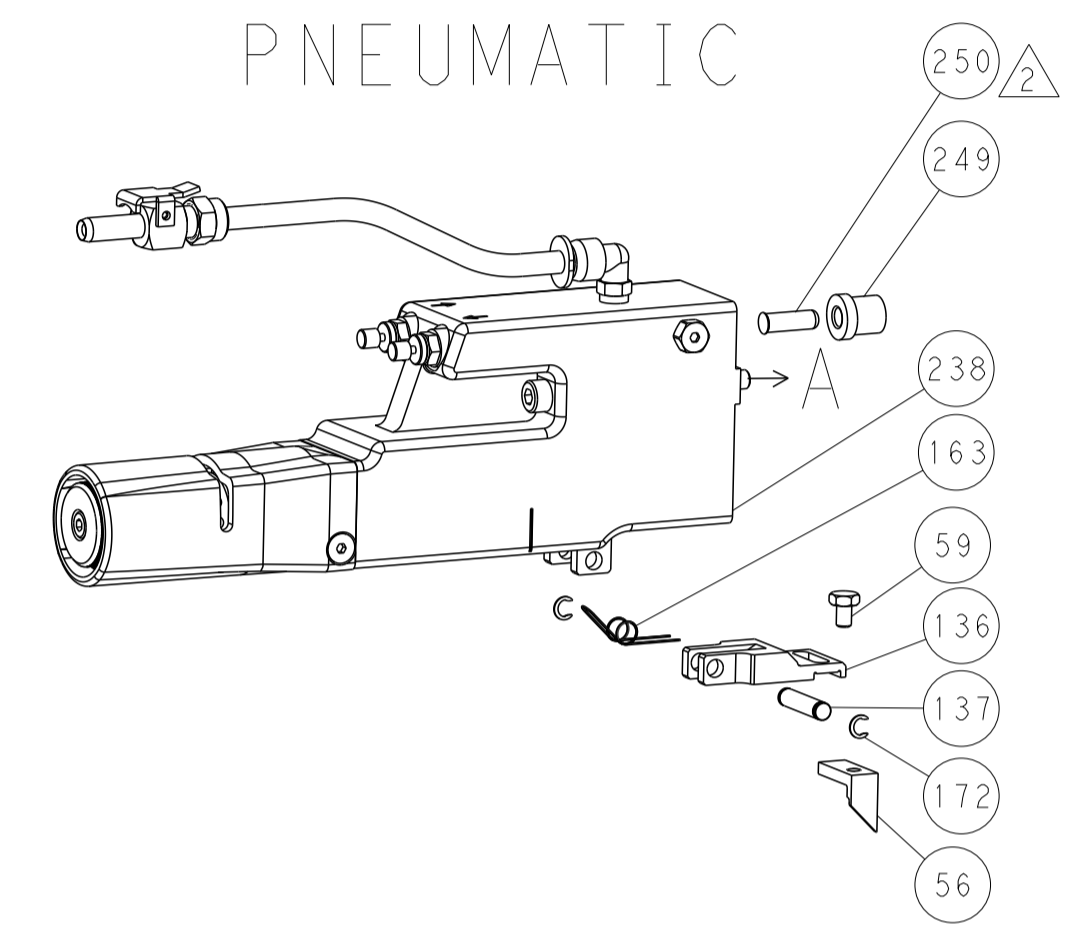
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	3 PLC ±	4 PLC ±	ANGLES ±				Ocean Side Feed Applicator	
MATERIAL	FINISH	WEIGHT	SCALE	Customer Accessible Production Drawing		1:2	SHEET 1 OF 4	REV B

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

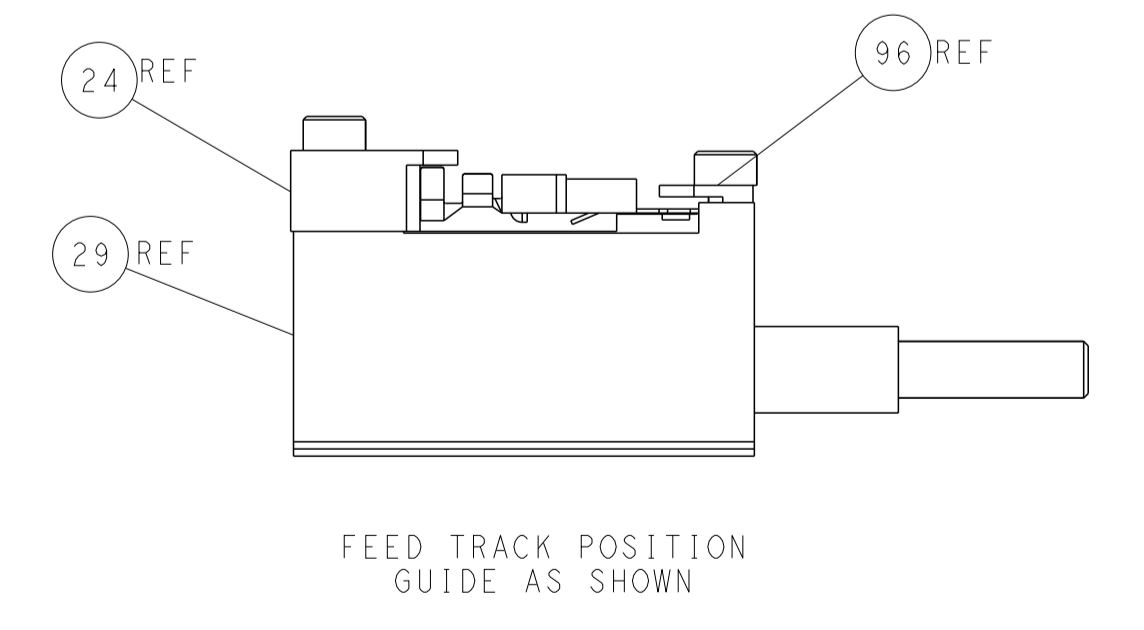
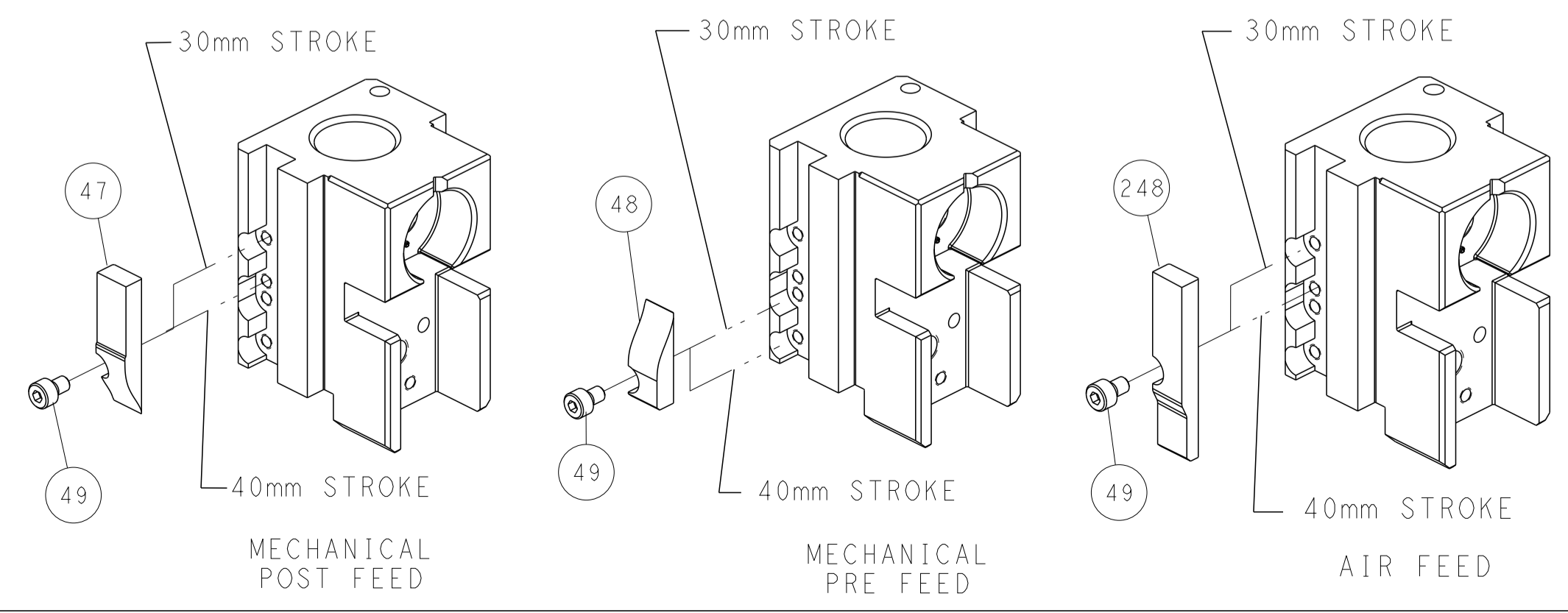
FEED TYPE MECHANICAL



PNEUMATIC



CAM POSITIONS



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 UNPUBLISHED. RELEASED FOR PUBLICATION 2016 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.</small>		DMN: M_HERR 05OCT2016 CHK: T_ELBIN 05OCT2016 APVD: T_ELBIN 05OCT2016	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: 2836458 WEIGHT: - SCALE: 1:2	RESTRICTED TO: - SHEET 2 OF 4 REV B
MATERIAL: - FINISH: -		Customer Accessible Production Drawing	

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2836458-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2836458-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2836458-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.00 mm [.079]	F
INSUL	4.00 mm [1.57]	O
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: TRW TERMINAL	TRW CRIMP SPECIFICATION
TERMINAL NAME: CONTACT TERMINAL	
WIRE STRIP LENGTH 3.47-4.23 mm [1.37-.167 IN]	INSULATION DIAMETER RANGE Ø
TERMINAL APPLICATION SPECIFICATION Y08 080 3799 Rev 25.05.2009	

TE TERMINAL	TRW TERMINAL	TE SEAL	TRW SEAL	SEAL INSULATION DIAMETER RANGE
2303664-1	Y080803799	2303665-1	3918056850	1.52-1.84

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.85mm2	1.41+/-0.03 [1.056+/-0.001]	7.4
0.75mm2	1.31+/-0.03 [1.052+/-0.001]	8.6
0.60mm2	1.28+/-0.03 [1.050+/-0.001]	8.9
0.50mm2	1.25+/-0.03 [1.049+/-0.001]	9.2

- 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.
- APPLY TORQ-SEAL IN ALLEN SOCKET TO FILL HOLE AFTER FLAT HD HAS BEEN ADJUSTED TO CORRECT HEIGHT AT QUALIFICATION. APPLY #1-23419-5 LOC-TITE TO THREADS.
- 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.

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

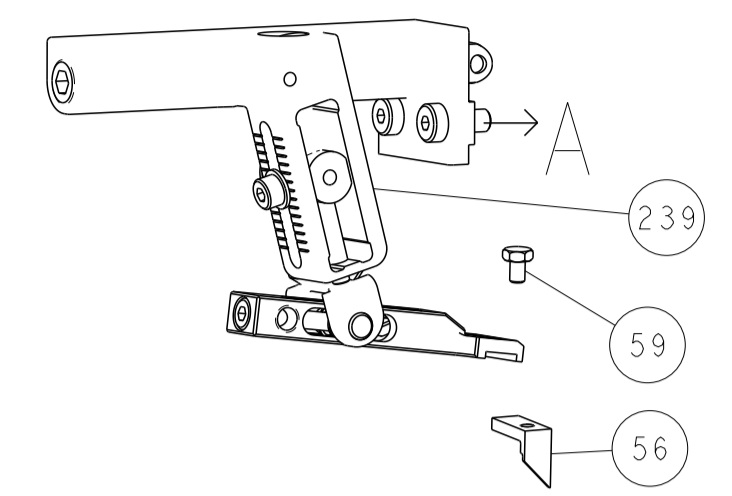
-	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0			283
-	1	1	2280441-1	INSERT, SHEAR			282
-	1	-	2119640-1	PUSH ROD, AIR FEED			250
-	1	-	1803259-1	BUSHING, FLANGED			249
-	1	1	2119082-3	CAM, SNAIL, INSULATION ADJUSTMENT			244
-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST			243
-	1	1	2119083-1	RETAINER, INSULATION DIAL			242
-	-	1	2119580-1	MECHANICAL FEED ASSEMBLY			239
-	1	-	2063440-1	AIR FEED MODULE			238
-	1	1	356885-6	STOP, SHEAR			237
-	1	1	462843-7	TERMINAL SUPPORT			175
-	2	-	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT			172
-	REF	REF	994970-2	COUNTER, MAGNETIC			164
-	1	-	240638-1	SPRING, FEED FINGER			163
-	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	-	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854			137
-	1	-	2119799-1	HOLDER, FEED FINGER, AF			136
-	1	1	1-22281-8	SPRING, COMPRESSION			121
-	1	1	2844908-1	SCREW, LOCKING			99
-	1	1	2844907-1	POST, LOCKING			98
-	1	1	1803258-1	FRONT STRIP GUIDE			96
-	2	2	1-2168083-3	SCR, SKT HD CAP, RoHS, M3 X 16			95
-	1	1	2168083-6	SCR, SKT HD CAP, RoHS, M5 X 65			93
-	1	1	455888-9	SPACER, CRIMPER			82
-	1	1	3-240641-0	SPACER			81
-	1	1	1803607-1	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
-	2	2	2-18032-5	SCR, SET, FLT PNT, M5 X 20.0			61
-	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0			59
-	1	1	985575-3	SCR, FLT SKT HD CAP M3 X 10.0			57
-	1	1	1-1338683-0	FEED PAWL			56
-	2	2	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20			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	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
-	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0			33
-	1	1	2-2305692-4	PLATE, REAR STRIP GUIDE			29
-	1	1	455888-4	SPACER, CRIMPER			28
-	2	2	22281-8	SPRING, COMPRESSION			27
-	1	1	356835-1	LEVER, DRAG RELEASE			26
-	1	1	240792-3	DRAG, TERMINAL			25
-	1	1	2-189124-4	GUIDE, FRONT STRIP			24
-	1	1	980371-4	SCR, SKT HD SHLDR 5.0 DIA X 6.0			23
-	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	2119533-1	STRIPPER, SIDE FEED			19
-	1	1	690463-2	FLOATING SHEAR, REAR			17
-	2	2	1-2168083-1	SCR, SKT HD CAP, RoHS, M3 X 6			16
-	1	1	1-690464-6	SHEAR PLATE, REAR			15
-	1	1	2119862-1	SHEAR HOLDER, REAR			14
-	1	1	3-22280-3	SPRING, COMPRESSION			12
-	-	-	-	-			10
-	-	-	-	-			9
-	1	1	1	3-1803252-8	ANVIL, COMBINATION		8
-	-	-	-	-			7
-	1	1	690468-7	DEPRESSOR SHEAR, REAR			6
-	1	1	2119781-1	DEPRESSOR, SHEAR			5
-	-	-	-	-			5
-	1	1	238011-4	BLOCK, CRIMPER SPACER			4
-	1	1	6-1633965-9	CRIMPER, INSULATION O PREMIUM			3
-	1	1	455888-6	SPACER, CRIMPER			2
-	1	1	6-1803241-9	CRIMPER, WIRE F			1

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

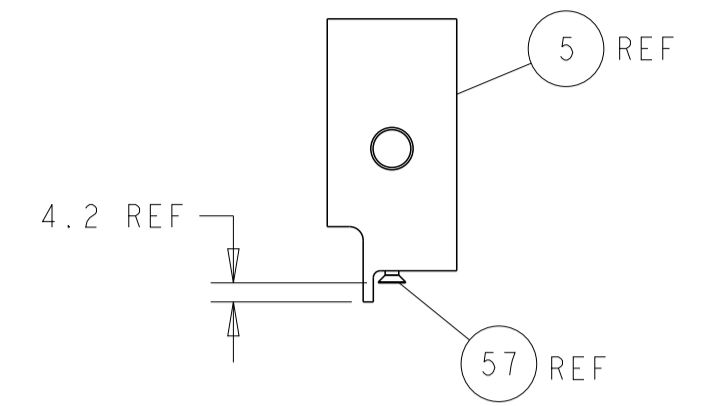
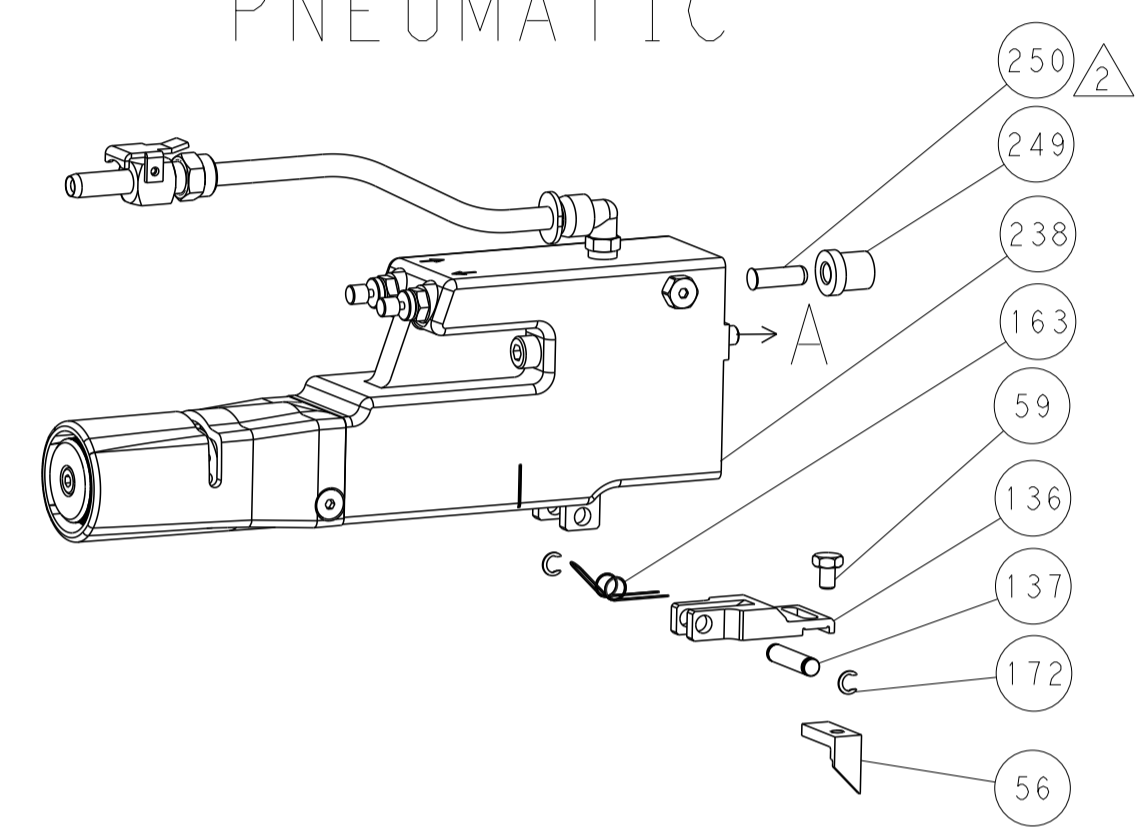
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DRAWING NO		DESCRIPTION		ITEM NO	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	5 PLC ±	6 PLC ±	7 PLC ±	8 PLC ±
MATERIAL:		FINISH:		WEIGHT:		SCALE:		SHEET 3 OF 4	
Customer Accessible Production Drawing		SCALE: 1:2		SHEET 3 OF 4		REV B			

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

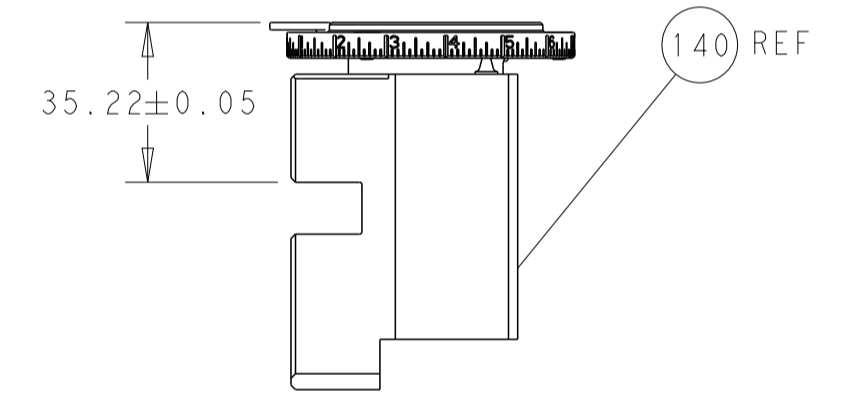
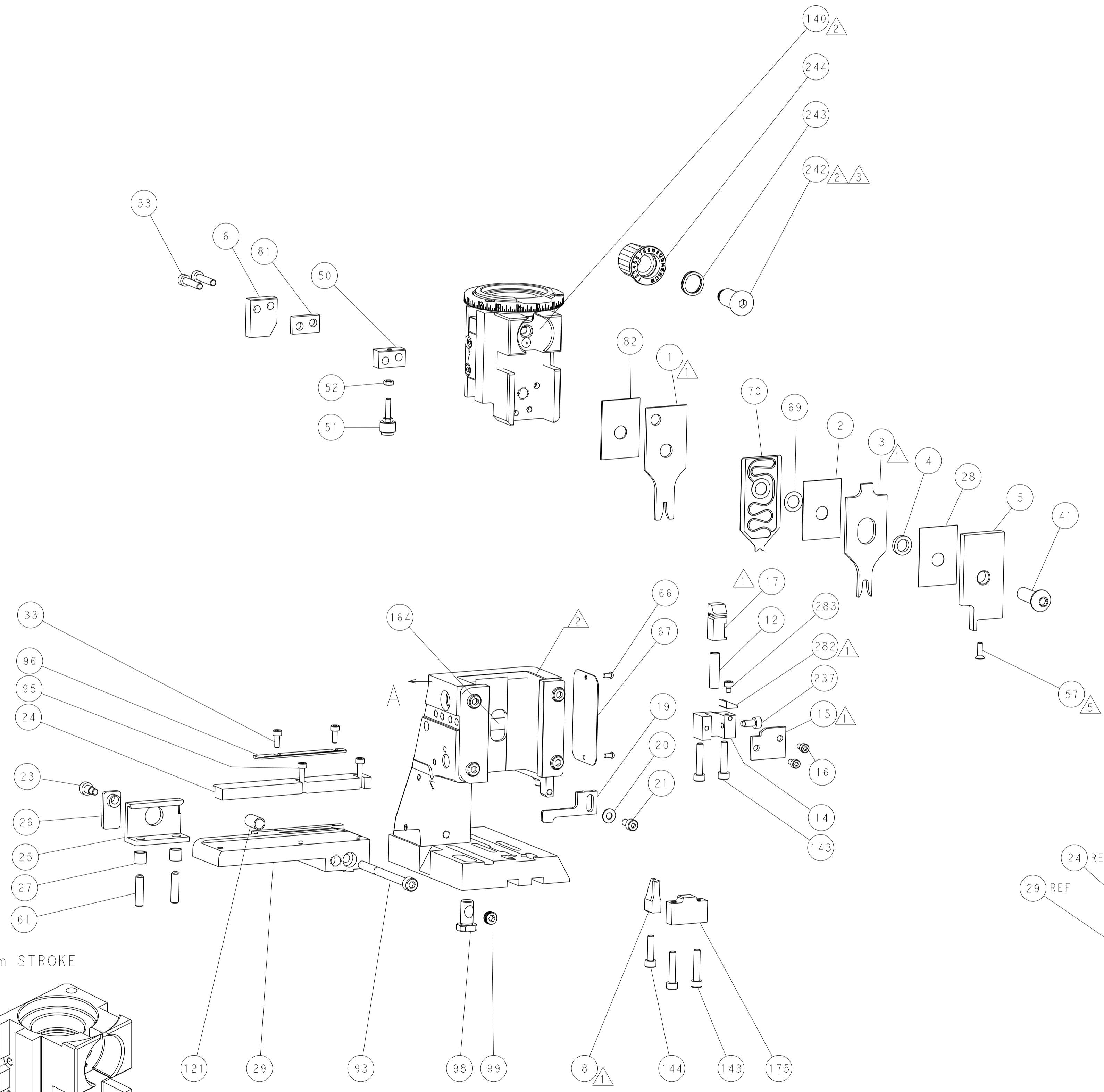
FEED TYPE MECHANICAL



PNEUMATIC

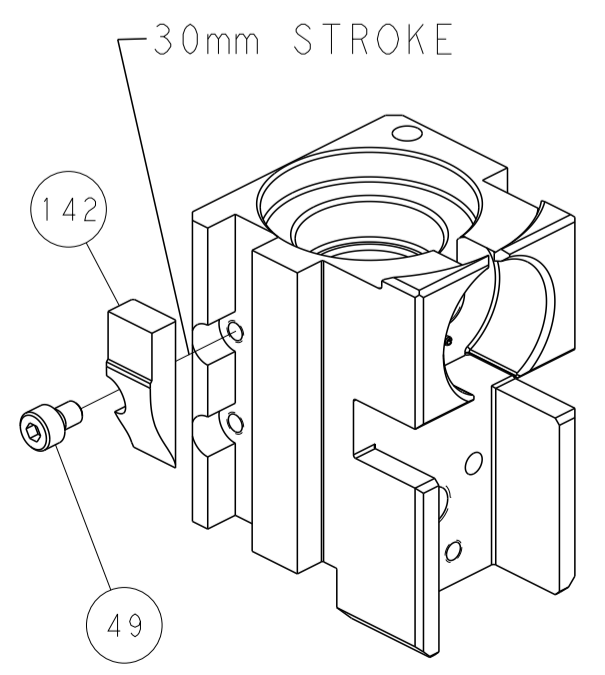


SHEAR DEPRESSOR DETAIL

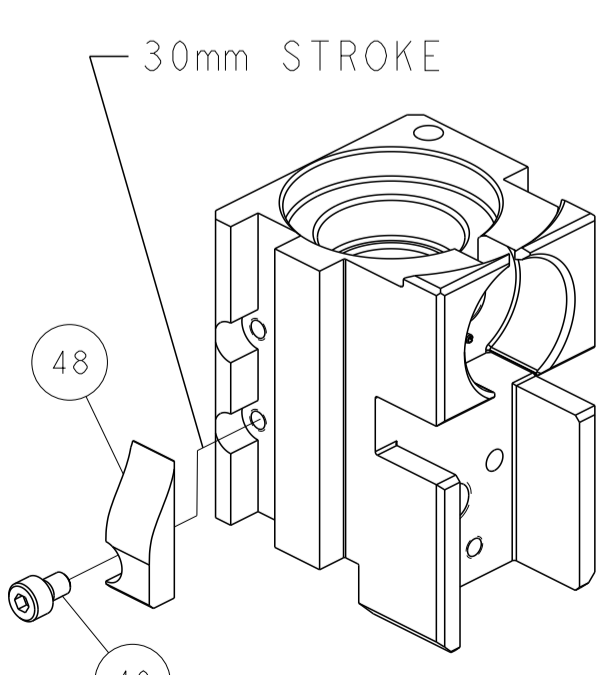


RAM SET-UP

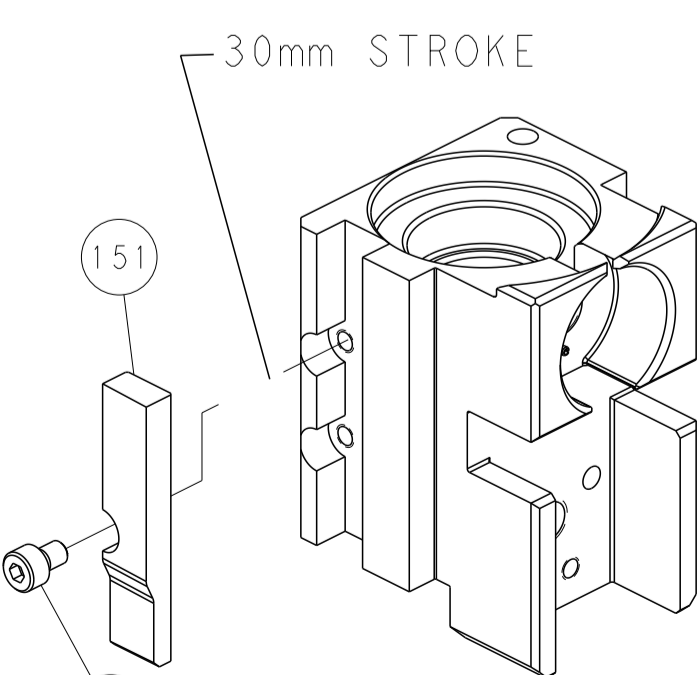
CAM POSITIONS



MECHANICAL POST FEED

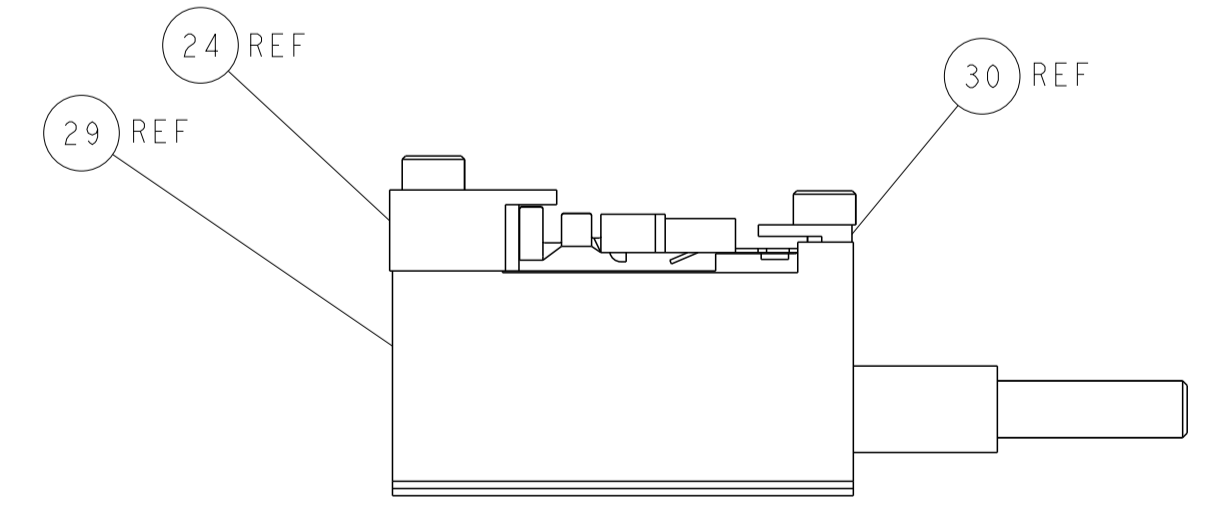


MECHANICAL PRE FEED



AIR FEED

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



FEED TRACK POSITION GUIDE AS SHOWN

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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: A1 CAGE CODE: 00779 DRAWING NO: C=2836458	RESTRICTED TO: - SCALE: 1:2 SHEET: 4 OF 4 REV: B
MATERIAL: - FINISH: -		WEIGHT: - CUSTOMER ACCESSIBLE PRODUCTION DRAWING	SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION