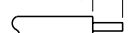


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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2836577-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2836577-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2836577-1	B	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2836577-2	B	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2836577-7	A	CRIMP TOOLING KIT	-

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.78 mm [.070]	F
INSUL	3.30 mm [.130]	F
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: AMP-IN TERMINAL			
WIRE STRIP LENGTH 2.97-3.73 mm [.117-.147 IN]			INSULATION DIAMETER RANGE Ø1.52-2.79 mm [.060-.110 IN]
TERMINAL APPLICATION	114-5028	-	-
SPECIFICATION	-	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
170338-1			

WIRE SIZE			CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING
18 AWG OR	0.75mm2		1.18+/-0.05 [0.046+/-0.002]		5.5
20 AWG OR	0.50mm2		1.06+/-0.05 [0.042+/-0.002]		6.7
22 AWG OR	0.30mm2		0.96+/-0.05 [0.038+/-0.002]		7.8



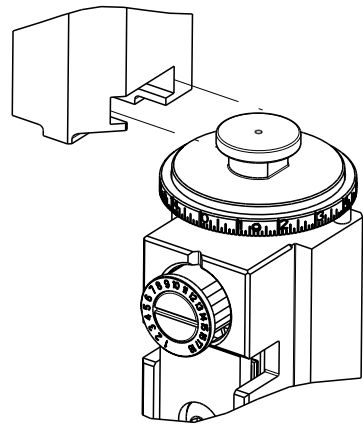
 RECOMMENDED SPARE PARTS

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. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.

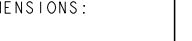
ATLANTIC VERSION TERMINATOR
INTERFACE ADAPTER

LOC	DIST	REVISIONS					
A	66	P LTR		DESCRIPTION	DATE	DWN	APVD
			A	RELEASED	22 JAN 2017	KH	CT
			B	ECR-18-008834	08 JUN 2018	VLA	JDG

	-	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	2119082-4	CAM, SNAIL, INSULATION ADJUSTMENT	244
	-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
3	-	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	-	2063440-1	AIR FEED MODULE	238
	-	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	2844908-1	SCREW, LOCKING	99
	-	1	1	1	1	2844907-1	POST, LOCKING	98
	-	1	1	1	1	455888-6	SPACER, CRIMPER	82
	-	1	1	1	1	1803607-1	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	690753-6	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	2-1752356-4	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	455888-3	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	2119533-3	STRIPPER, SIDE FEED	19
1	-	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	1	2119805-1	SHEAR HOLDER, FRONT	10
1	-	1	1	1	1	1803095-1	FLOATING SHEAR, FRONT -	9
1	1	2	2	1	1	6-1633919-5	ANVIL, COMBINATION	8
	-	-	-	-	-	-	-	7
	-	-	-	-	-	-	-	6
	-	1	1	1	1	2119757-8	DEPRESSOR, SHEAR	5
	-	1	1	1	1	238011-7	BLOCK, CRIMPER SPACER	4
1	1	2	2	1	1	2119582-1	CRIMPER, INSULATION F PREMIUM	3
	-	1	1	1	1	455888-4	SPACER, CRIMPER	2
1	1	2	2	1	1	2-456404-5	CRIMPER, WIRE PREMIUM	1
	-77	-72	-71	-2	-1	PART NO	DESCRIPTION	ITEM NO

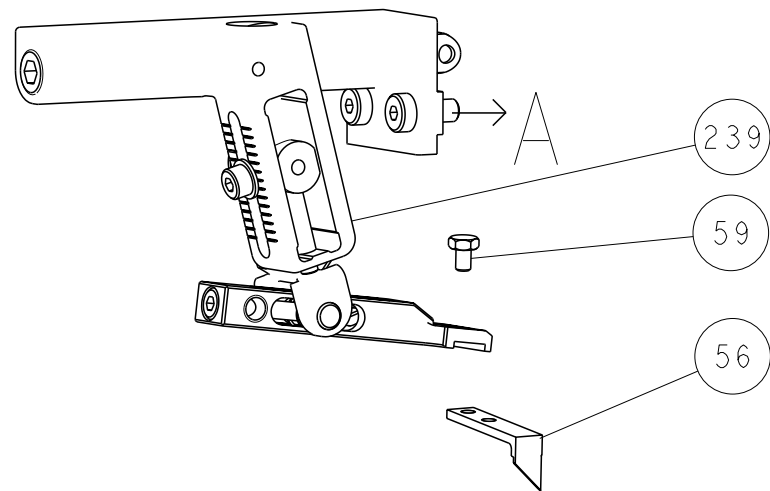
*WARNING
ON INSTALLATION, SET WIRE DISC TO CRIMP HEIGHT REFERENCE SETTING
FOR LARGEST WIRE SIZE. CRIMP HEIGHT REFERENCE SETTINGS GREATER
THAN THE VALUE SHOWN MAY CAUSE DAMAGE TO THE CRIMP TOOLING,
REFER TO THE INSTRUCTION SHEET FOR PROPER SETUP AND ADJUSTMENTS.

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

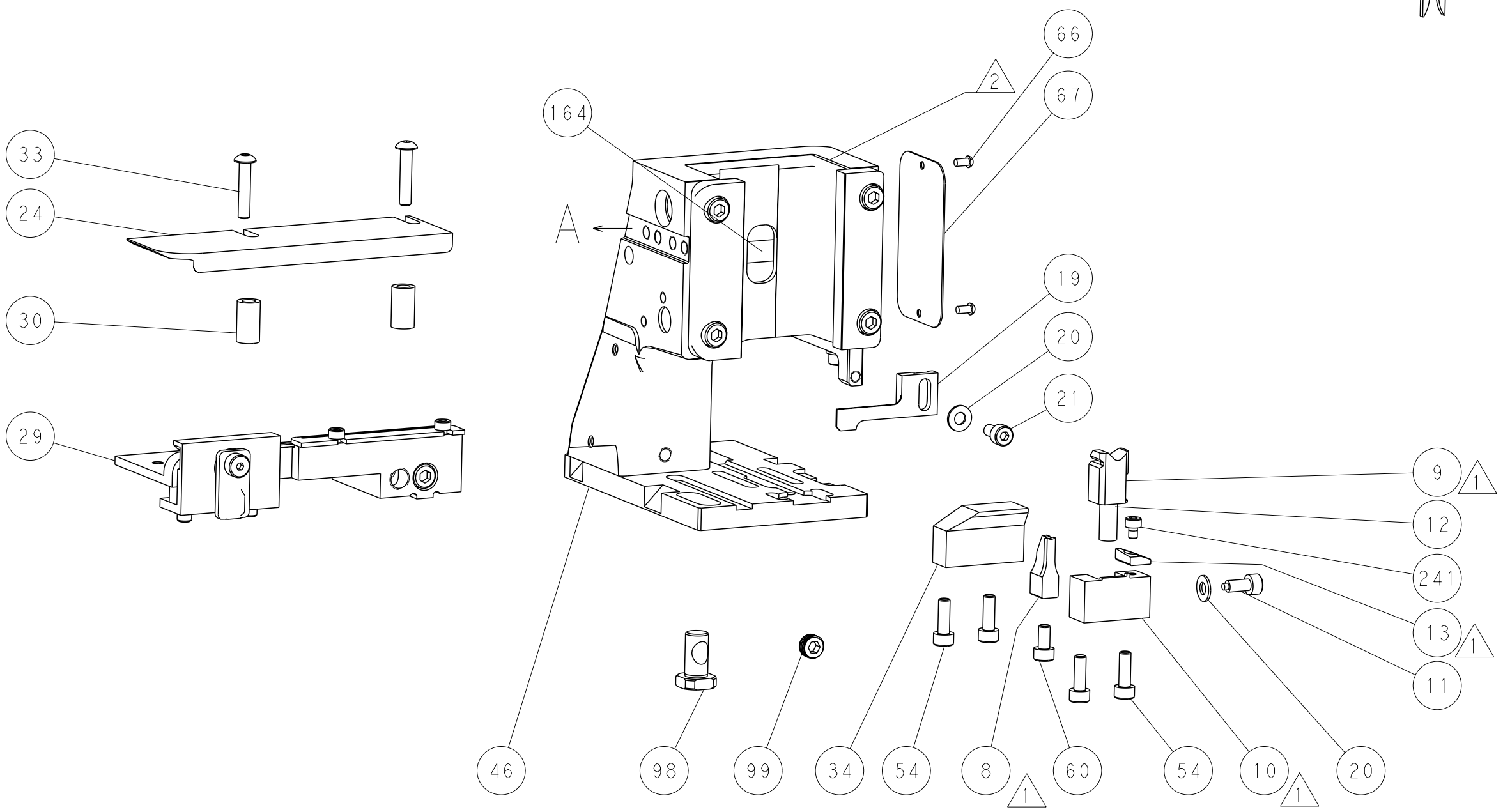
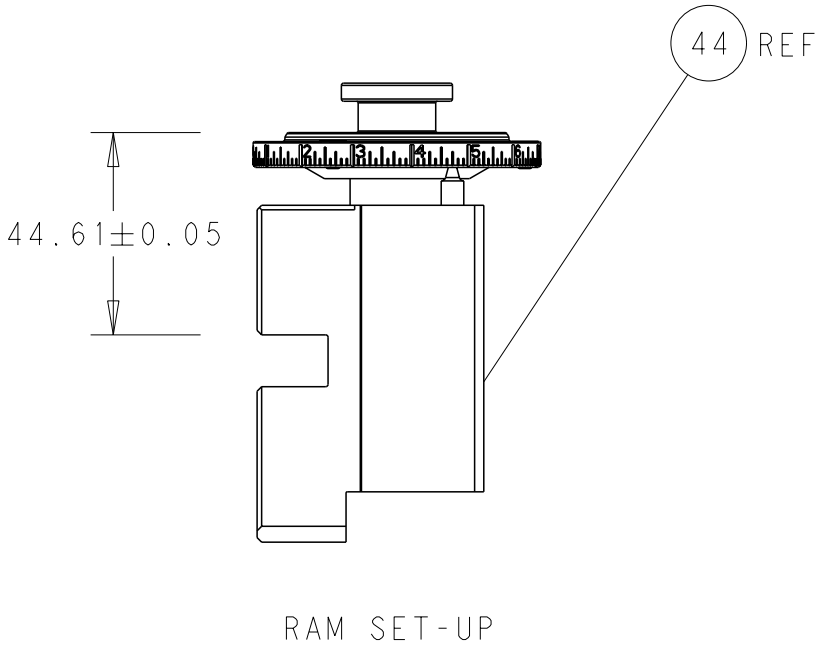
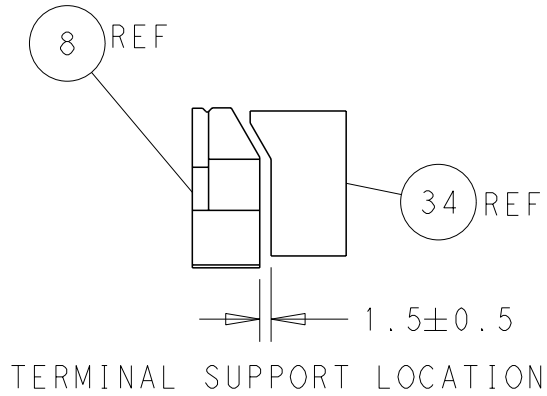
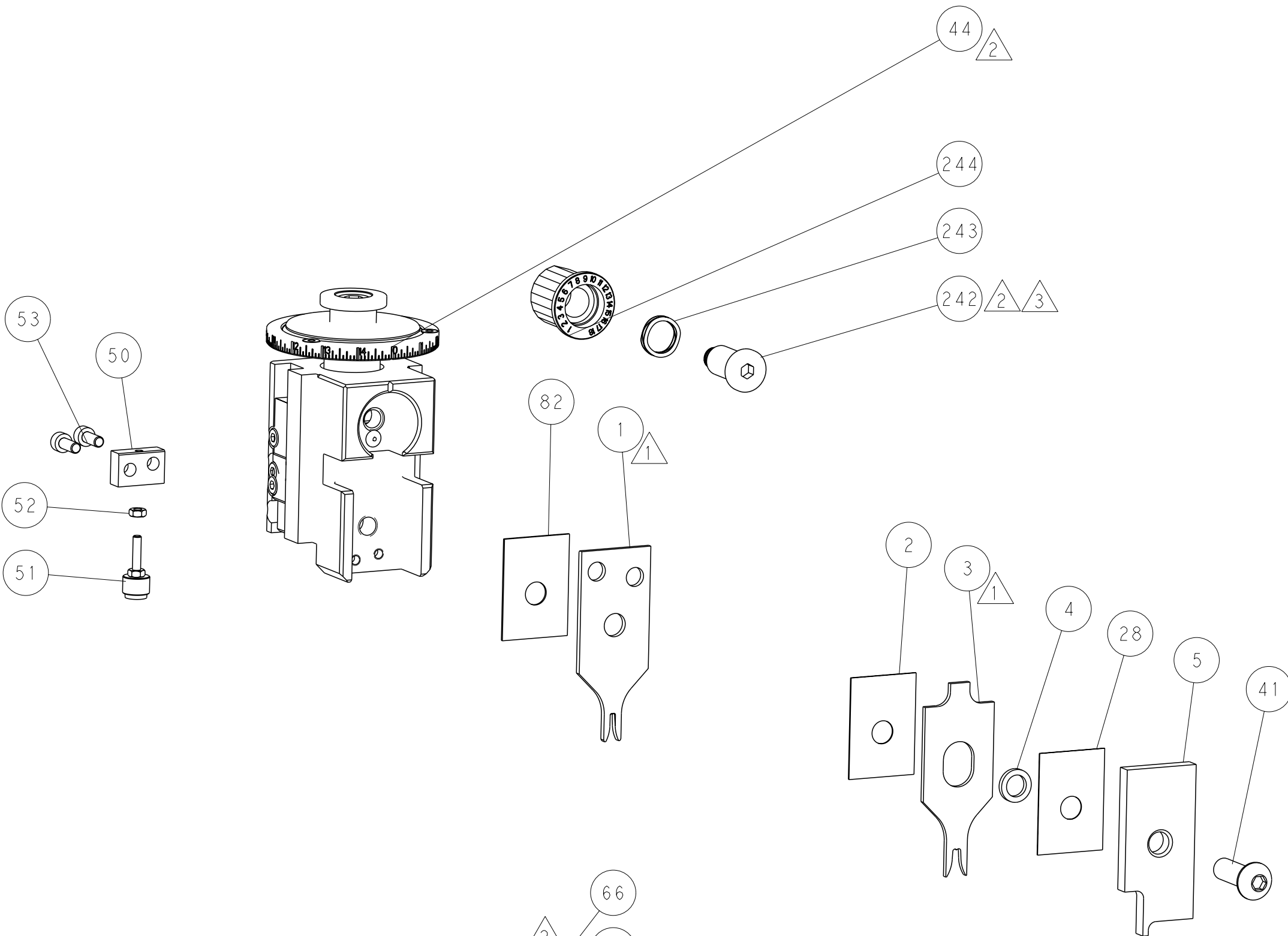
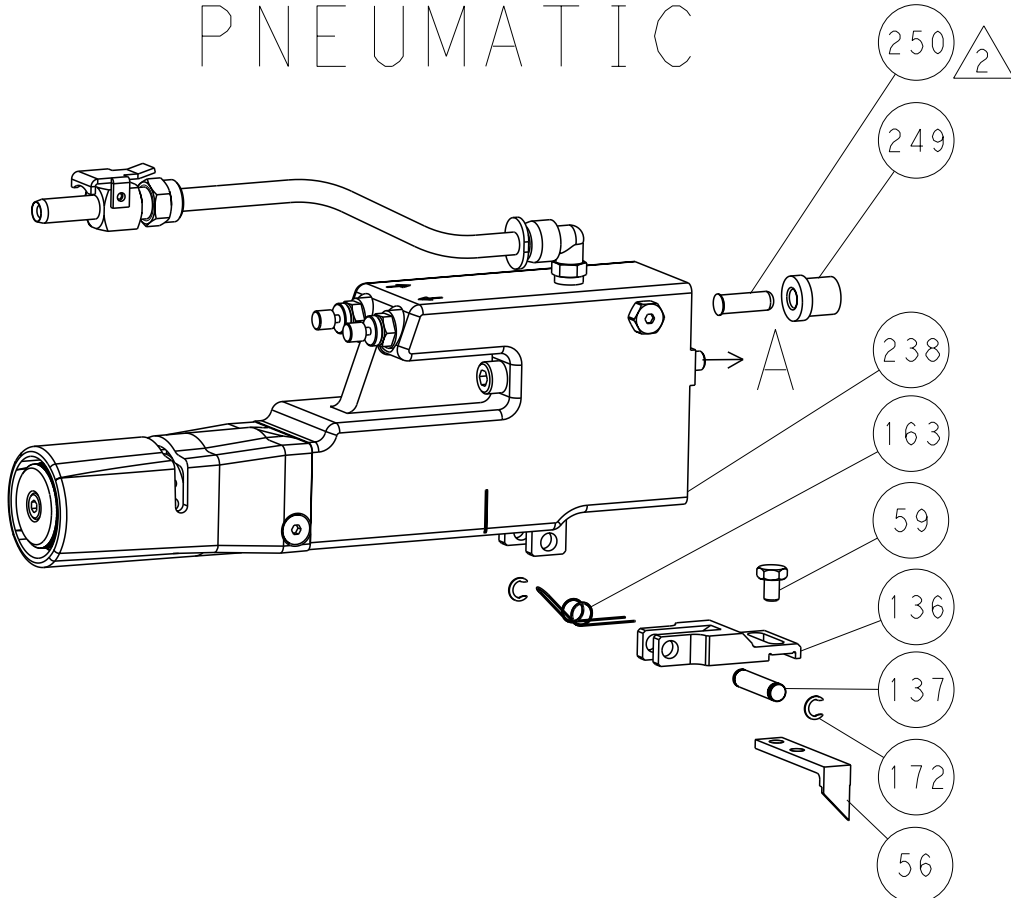
THIS DRAWING IS A CONTROLLED DOCUMENT FOR THIS ELECTRONIC CORPORATION IT IS VOID OF FORCE AND EFFECT WITHOUT THE CONTROL AND ENDORSEMENT ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST REVISION.		DWN R. HUANG 29DEC2016		 TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS : mm		TOLERANCES UNLESS OTHERWISE SPECIFIED : 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH -		NAME Ocean Side Feed Applicator -	
		DWN L. ZHANG 29DEC2016 APVD L. ZHANG 29DEC2016 PRODUCT SPEC - APPLICATION SPEC -		SIZE A	
MATERIAL -		WEIGHT -		CASE CODE 00779	
				DRAWING NO C=2836577	
		Customer Accessible Production Drawing		RESTRICTED TO -	
				SCALE 1:2	
				SHEET 1 of 4	
				REV B	

LOC		DIST		REVISONS				
A	66	P	LYR	DESCRIPTION	DATE	DWN	APVD	
		-		SEE SHEET 1	-	-	-	

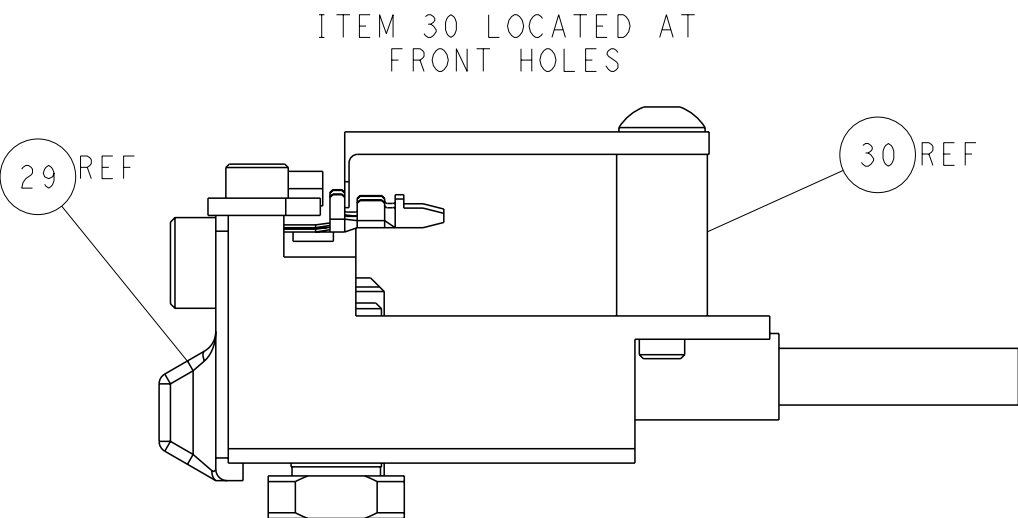
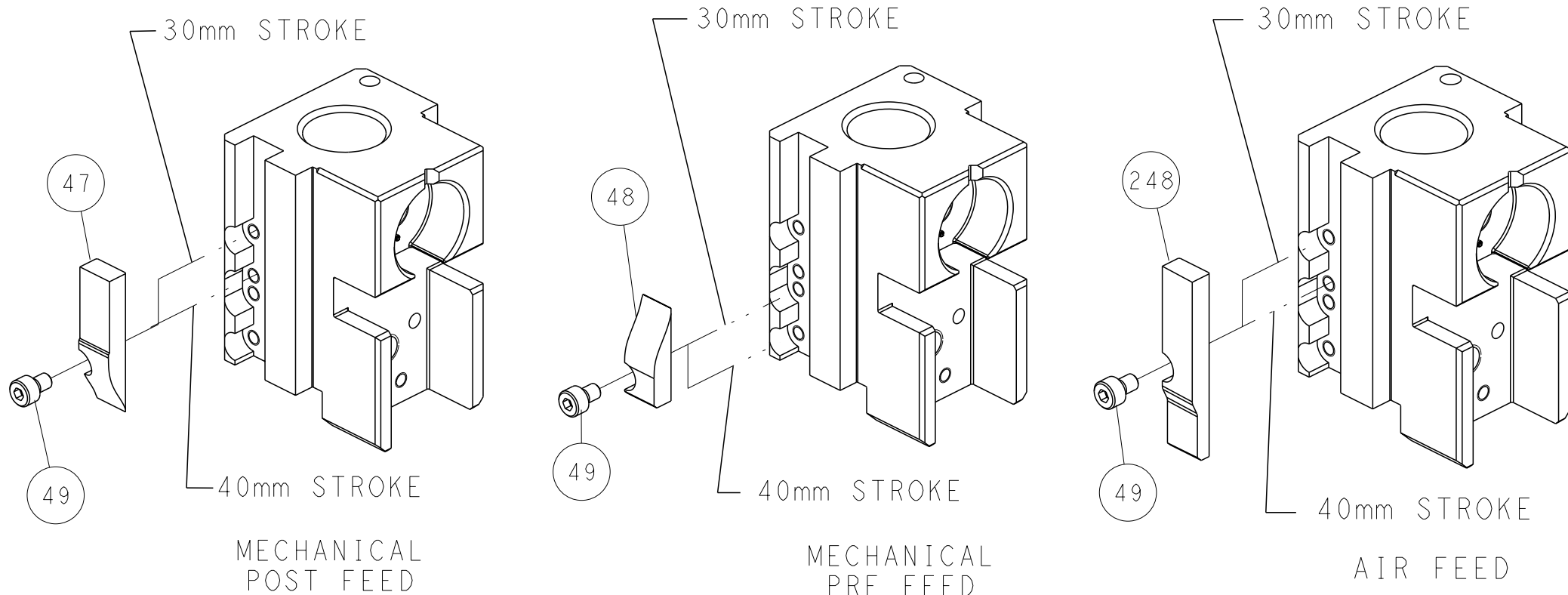
FEED TYPE MECHANICAL



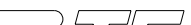
PNEUMATIC



CAM POSITIONS

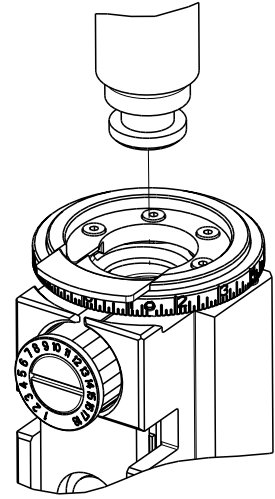


ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

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DIMENSIONS:				TOLERANCES UNLESS OTHERWISE SPECIFIED:				CHK L. ZHANG		29DEC2016					
mm								APVD L. ZHANG		29DEC2016					
				0 PLC				±		NAME Ocean Side Feed Applicator -					
				1 PLC				±							
				2 PLC				±							
				3 PLC				±							
				4 PLC				±							
ANGLES				±				PRODUCT SPEC							
FINISH				±				APPLICATION SPEC							
MATERIAL				-				SIZE		CASE CODE		DRAWING NO		RESTRICTED TO	
-				-				A		00779		C=2836577		-	
Customer Accessible Production Drawing				SCALE				1:2		SHEET		2 of 4		REV B	

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2836577-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2836577-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2836577-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.78 mm [.070]	F
INSUL	3.30 mm [.130]	F
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: AMP-IN TERMINAL			
WIRE STRIP LENGTH			INSULATION DIAMETER RANGE
2.97-3.73 mm [.117-.147 IN]			Ø1.52-2.79 mm [.060-.110 IN]
TERMINAL APPLICATION SPECIFICATION		114-5028	
		-	-
		-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
170338-1			

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING	
18 AWG OR 0.75mm2		1.18+/-0.05 [.046+/-0.002]		5.5	
20 AWG OR 0.50mm2		1.06+/-0.05 [.042+/-0.002]		6.7	
22 AWG OR 0.30mm2		0.96+/-0.05 [.038+/-0.002]		7.8	



- 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. 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)

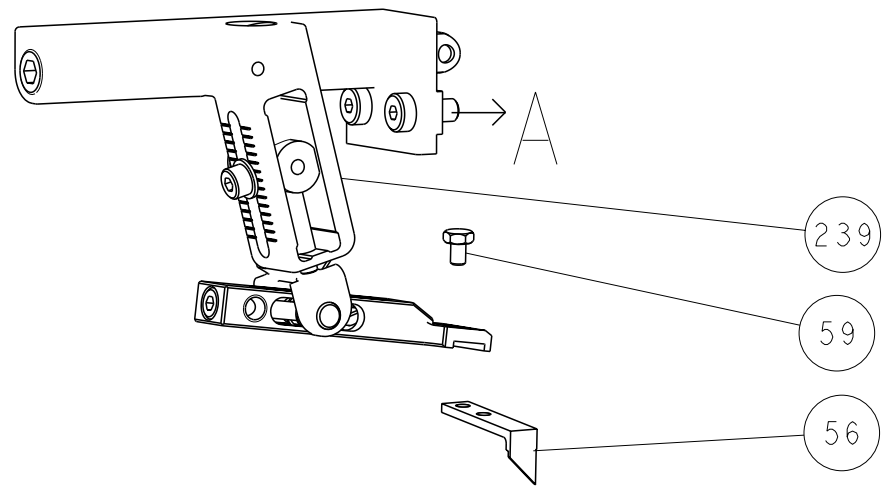
LOC	DIST	REVISIONS				
		#	LYR	DESCRIPTION	DATE	OWN
A	66	-	-	SEE SHEET 1	-	-

-	1	-	2119640-1	PUSH ROD, AIR FEED	250
-	1	-	1803259-1	BUSHING, FLANGED	249
-	1	1	2119082-4	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
3	-	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	-	2063440-1	AIR FEED MODULE	238
-	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	2844908-1	SCREW, LOCKING	99
-	1	1	2844907-1	POST, LOCKING	98
-	1	1	455888-6	SPACER, CRIMPER	82
-	1	1	1803607-1	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
-	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	690753-6	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
-	1	1	2-1752356-4	SUPPORT, TERMINAL	34
-	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	2-2844962-6	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29
-	1	1	455888-3	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	2119533-3	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	1803095-1	FLOATING SHEAR, FRONT -	9
1	1	1	6-1633919-5	ANVIL, COMBINATION	8
-	-	-	-	-	7
-	-	-	-	-	6
-	1	1	2119757-8	DEPRESSOR, SHEAR	5
-	1	1	238011-7	BLOCK, CRIMPER SPACER	4
1	1	1	2119582-1	CRIMPER, INSULATION F PREMIUM	3
-	1	1	455888-4	SPACER, CRIMPER	2
1	1	1	2-456404-5	CRIMPER, WIRE PREMIUM	1

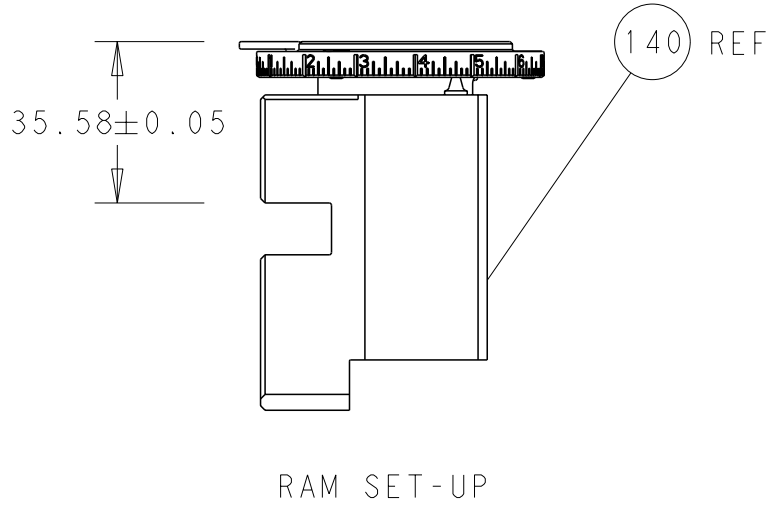
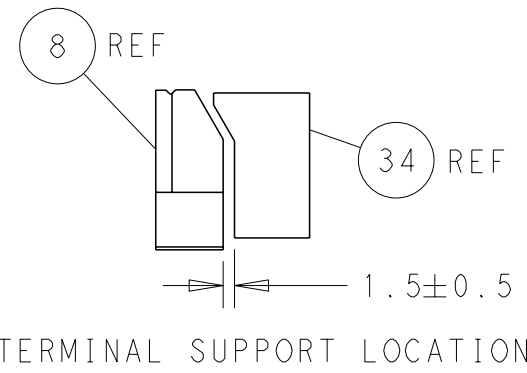
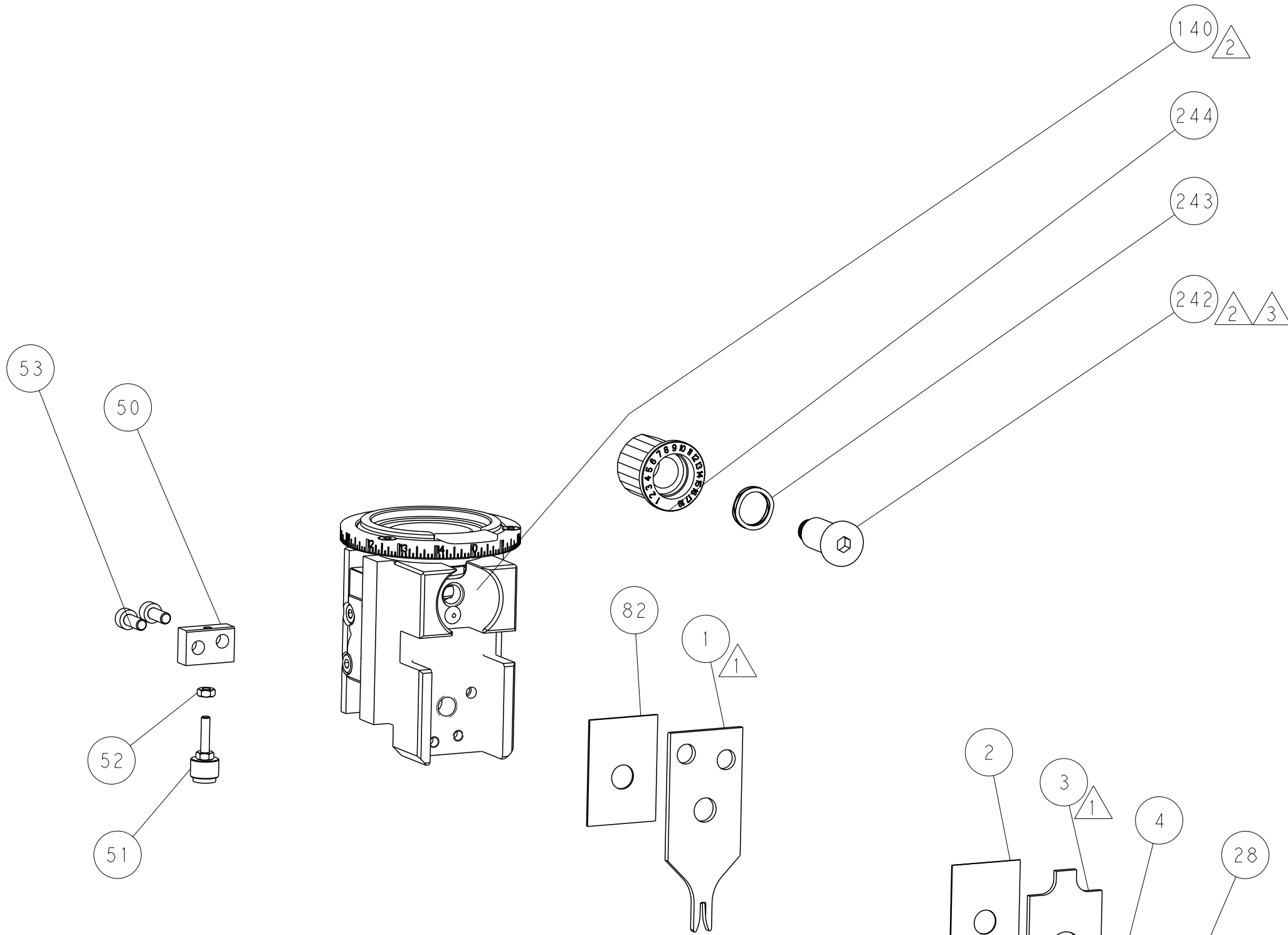
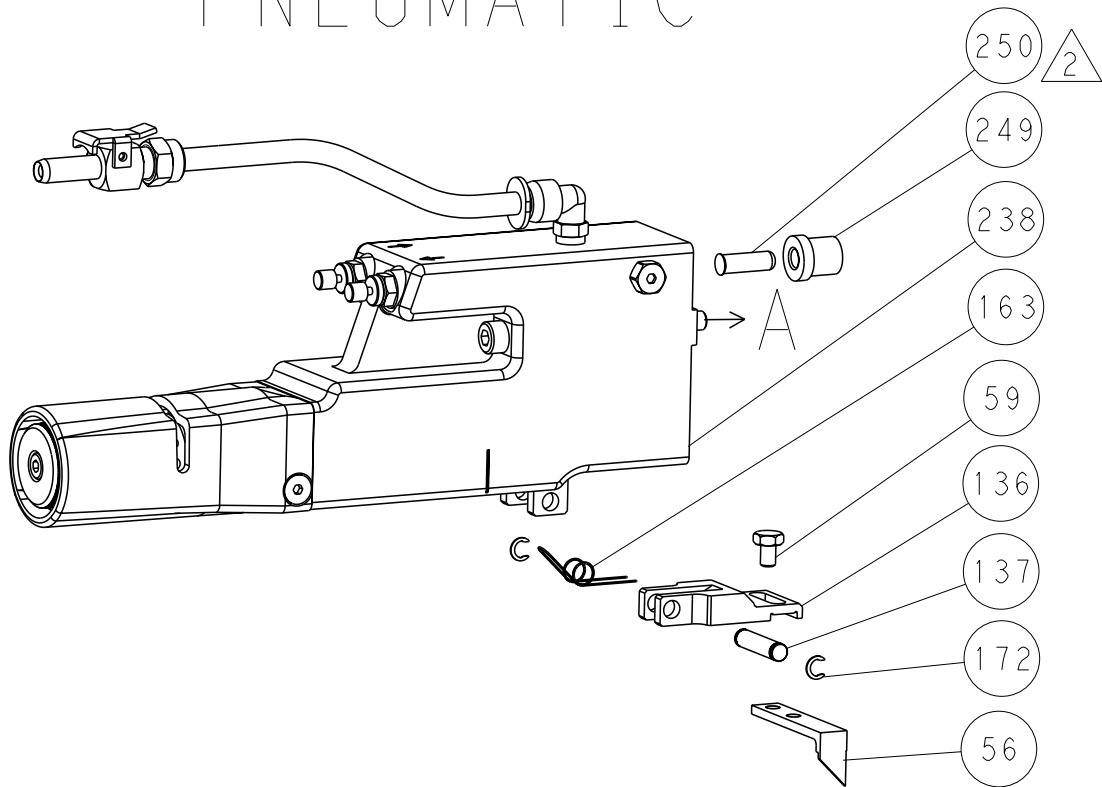
-77	-22	-21	PART NO	DESCRIPTION	ITEM NO
			OWN R. HUANG CHK L. ZHANG APVD L. ZHANG	29DEC2016 29DEC2016 29DEC2016	29DEC2016
			DIMENSIONS: mm	TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±	NAME Ocean Side Feed Applicator
			MATERIAL -	FINISH -	SIZE A1
			Customer Accessible Production Drawing	SCALE 1:2	SHEET 3
			00779	©=2836577	REV B

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

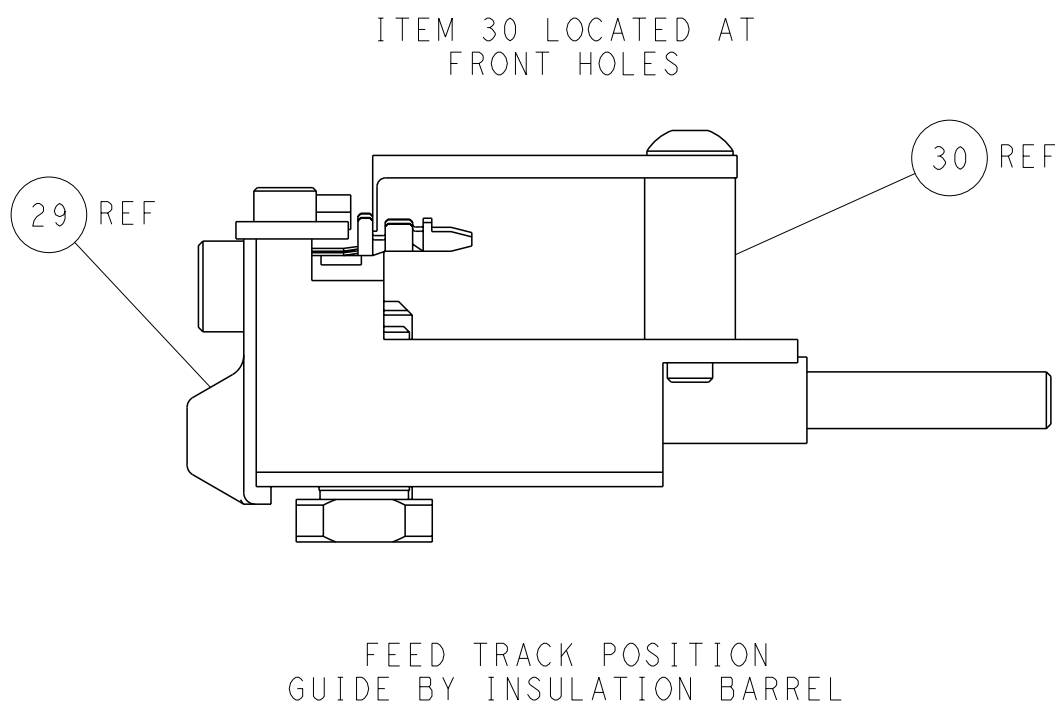
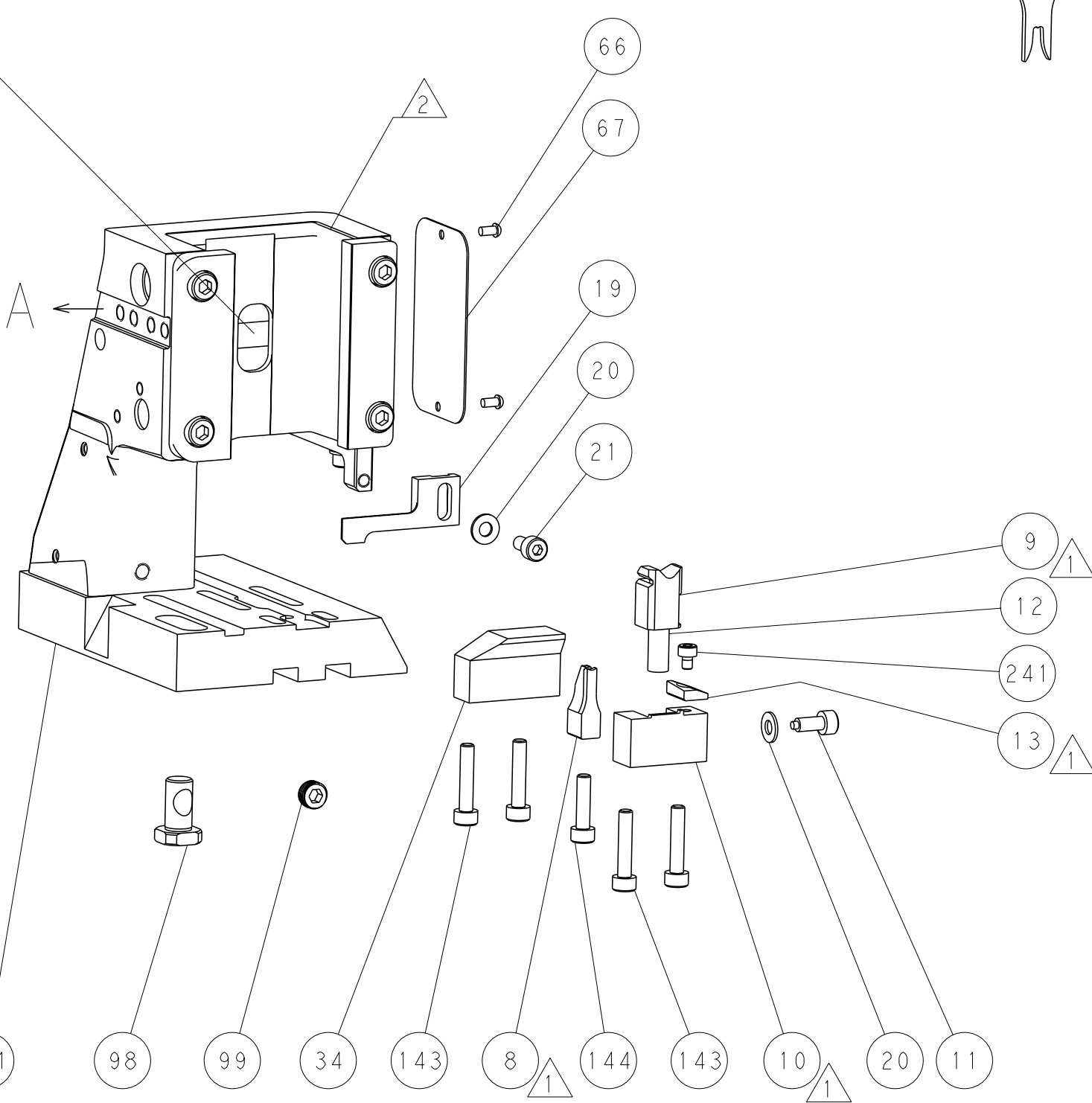
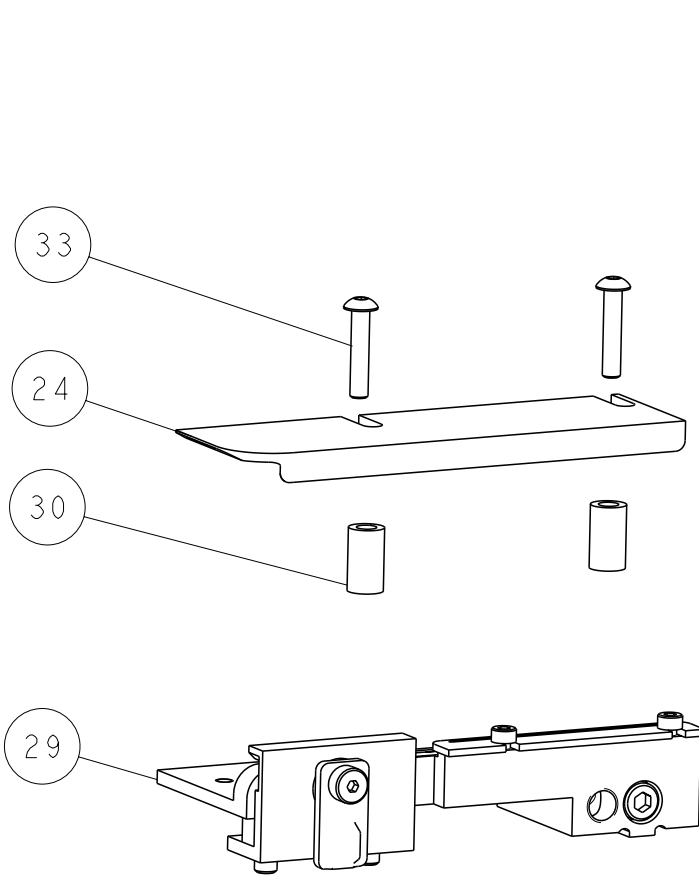
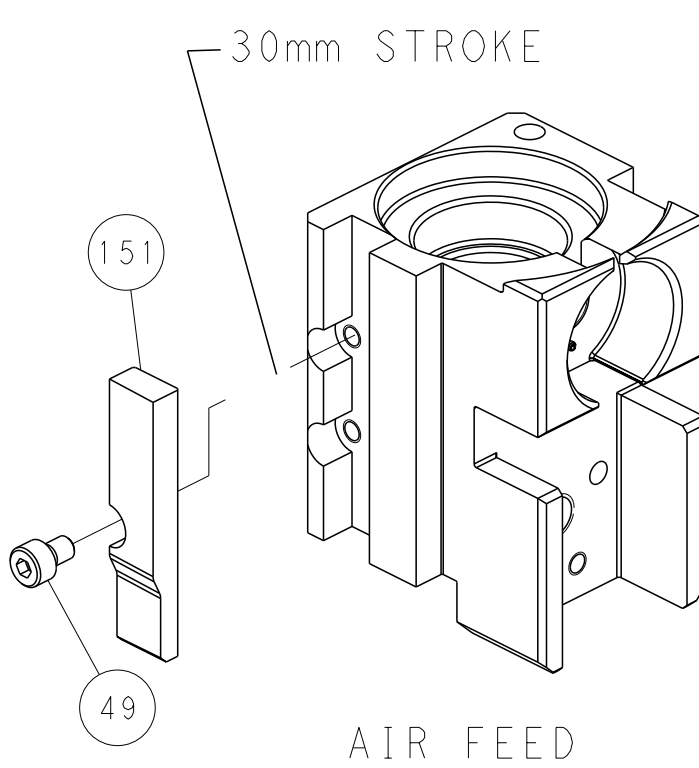
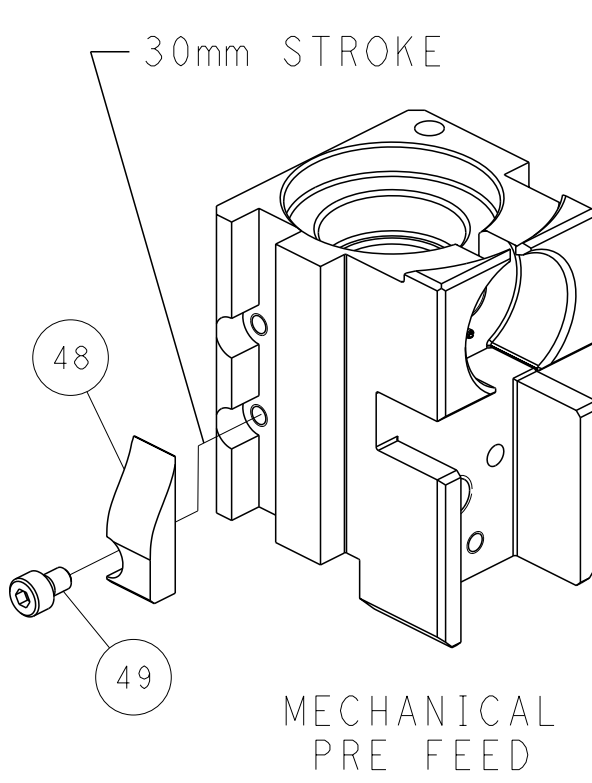
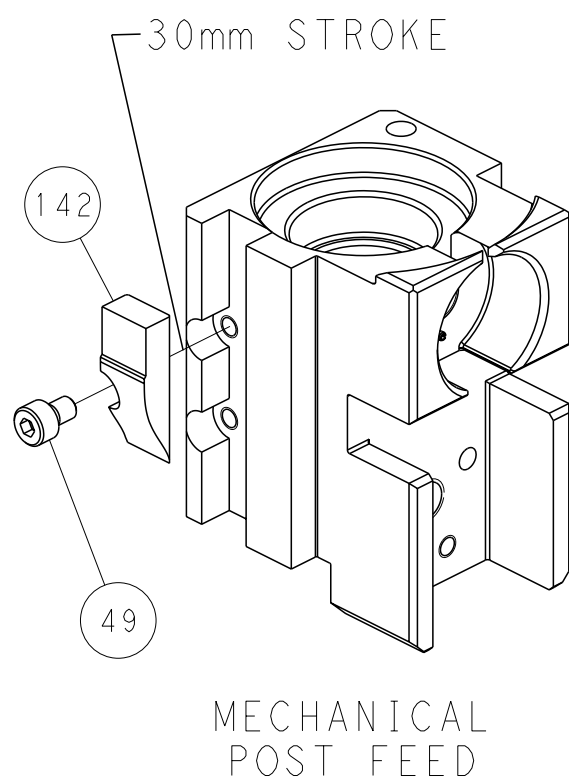
FEED TYPE
MECHANICAL



PNEUMATIC



CAM POSITIONS



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

1. THIS DRAWING IS A CONTROL DOCUMENT FOR THE MANUFACTURING OF THE PARTS OF THE PRODUCT. IT IS THE PROPERTY OF THE COMPANY AND IS NOT TO BE REPRODUCED OR COPIED FOR ANY OTHER PURPOSE. IT IS THE PROPERTY OF THE COMPANY AND IS NOT TO BE REPRODUCED OR COPIED FOR ANY OTHER PURPOSE.				DWN		29DEC2016		 TE Connectivity Harrisburg, PA 17105-3608																	
				CHK		29DEC2016																			
DIMENSIONS:				TOLERANCES UNLESS OTHERWISE SPECIFIED:				NAME		Ocean Side Feed Applicator															
mm																									
				0 PLC ±				SIZE		CAGE CODE		DRAWING NO		RESTRICTED TO											
				1 PLC ±																					
				2 PLC ±																					
				3 PLC ±																					
				4 PLC ±																					
ANGLES				±																					
FINISH																									
MATERIAL								WEIGHT		A 00779		C=2836577													
Customer Accessible Production Drawing														SCALE		1:2		SHEET		4 of 4		REV		B	