

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2836618-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2836618-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2836618-1	B	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2836618-2	B	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2836618-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.07 mm [.042]	F
INSUL	1.57 mm [.062]	O

APPLICATOR INSTRUCTIONS 408-35042

TERMINAL DATA: DDK LTD TERMINAL DDK CRIMP SPECIFICATION			
TERMINAL NAME: CM09 SERIES PIN/SOCKET CONTACT			
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE		
3.00-3.50 mm [.118-.138 IN]	Ø1.18-1.42 mm [.046-.056 IN]		
TERMINAL APPLICATION SPECIFICATION	TC-470 Rev C		
TERMINALS APPLIED			
TE TERMINAL	DDK LTD TERMINAL	TE TERMINAL	DDK LTD TERMINAL
1949450-1	CM09-#22PC-1000	1949451-1	CM09-#22SC-1000

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
24 AWG	0.71+/-0.03 [.028+/- .001]	7.1
26 AWG	0.67+/-0.03 [.026+/- .001]	7.6
28 AWG	0.64+/-0.03 [.025+/- .001]	7.9

- 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)

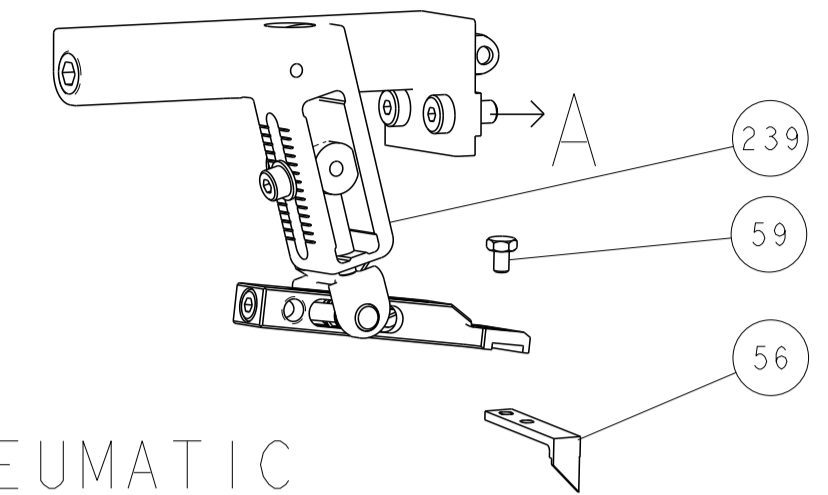
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		P	LTN	DESCRIPTION	DATE	OWN	APVD
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				ECR-21-122798	01DEC2021	JWC	TE

-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248
-	1	1	1	1	2119082-5	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	994970-2	COUNTER, MAGNETIC	164
-	1	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	455888-5	SPACER, CRIMPER	82
-	1	1	1	1	1803607-3	DOCUMENTATION PACKAGE	71
-	1	1	1	1	2119791-9	DEPRESSOR, WIRE	70
-	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	1803382-1	HOLD DOWN, SPRING LOADED	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	2-1752356-7	SUPPORT, TERMINAL	34
-	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	2	2	2-2844962-4	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29
-	1	1	1	1	1320928-2	STRIP GUIDE	24
-	1	1	1	1	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	21
-	2	2	2	2	1-18028-2	WASHER, FLAT, REG M4	20
-	1	1	1	1	2119533-4	STRIPPER, SIDE FEED	19
-	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	1803095-3	FLOATING SHEAR, FRONT	9
1	2	2	1	1	1-1633916-6	ANVIL, COMBINATION	8
-	-	-	-	-	-	-	7
-	-	-	-	-	-	-	6
-	1	1	1	1	2119757-4	DEPRESSOR, SHEAR	5
-	1	1	1	1	4-238011-7	BLOCK, CRIMPER SPACER	4
1	2	2	1	1	1633966-2	CRIMPER, INSULATION O	3
-	-	-	-	-	-	-	2
1	2	2	1	1	7-1633713-5	CRIMPER, WIRE PREMIUM	1
-	77	-72	-71	-2	-1	PART NO	ITEM NO

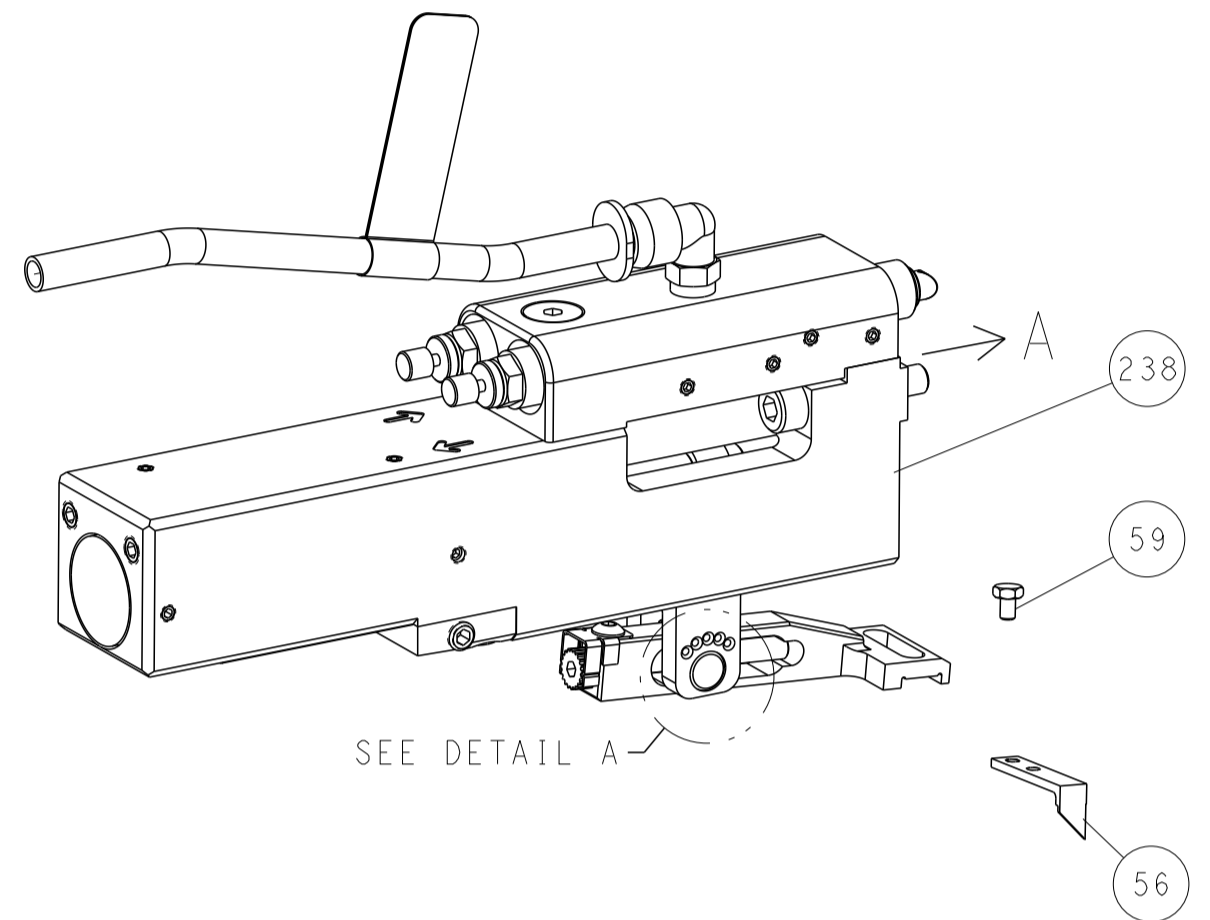
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mm	0 PLC	±													
	1 PLC	±													
	2 PLC	±													
	3 PLC	±													
	4 PLC	±													
	ANGLES	±													

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

FEED TYPE MECHANICAL



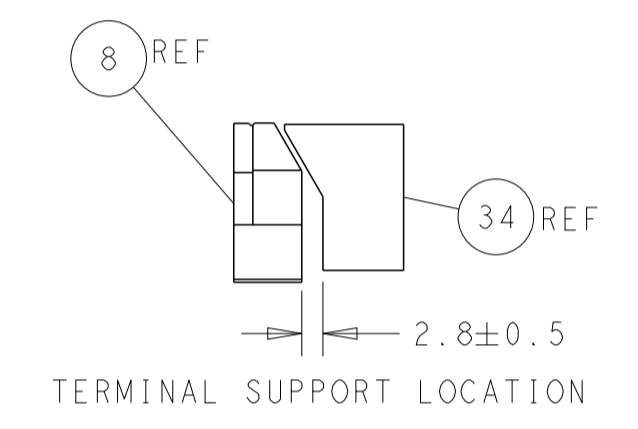
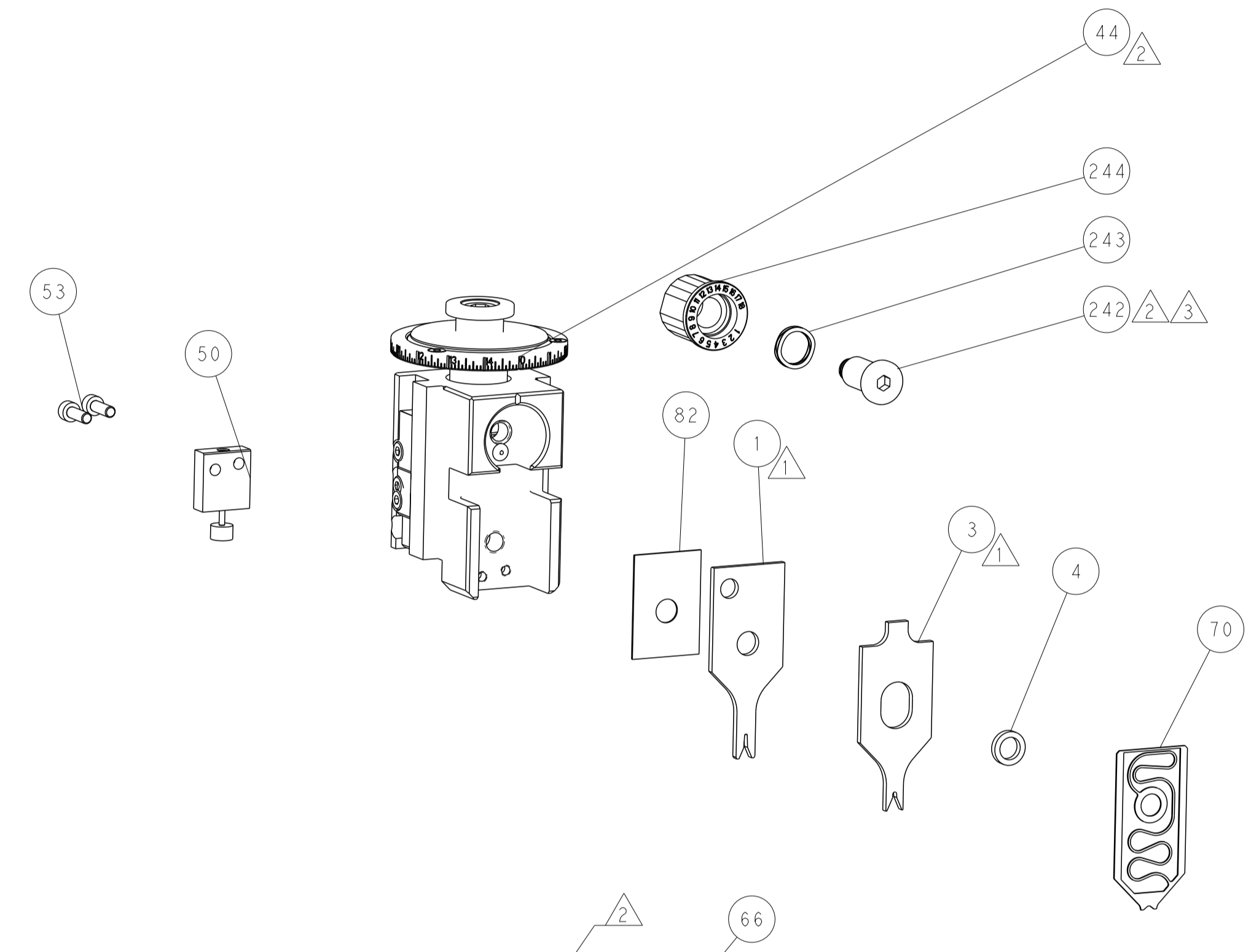
PNEUMATIC



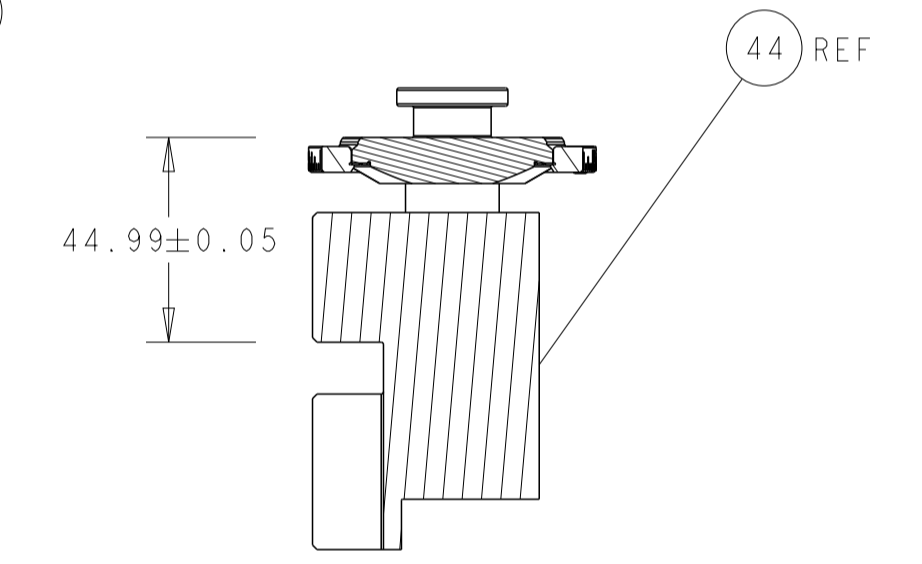
FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



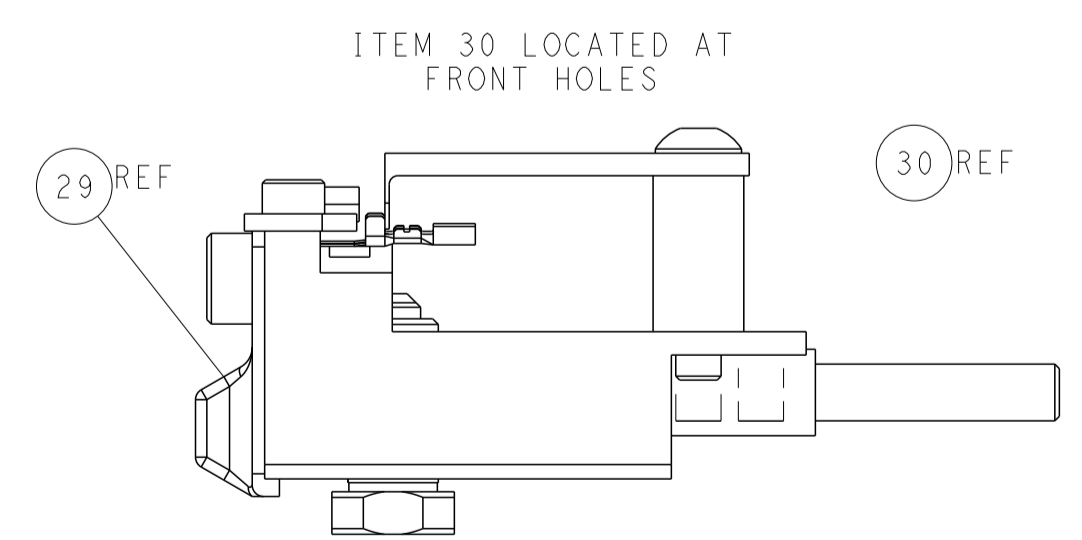
DETAIL A



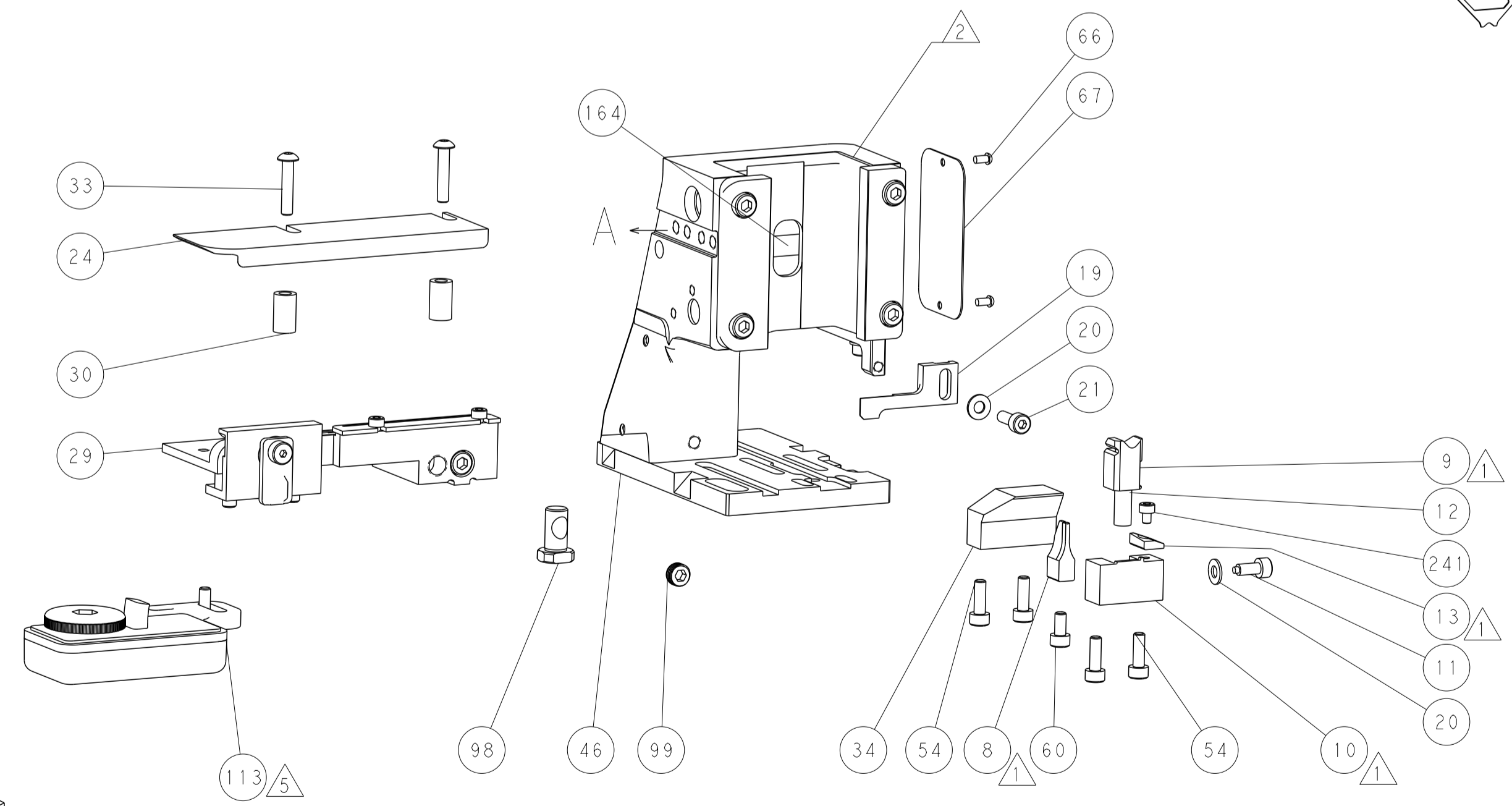
TERMINAL SUPPORT LOCATION



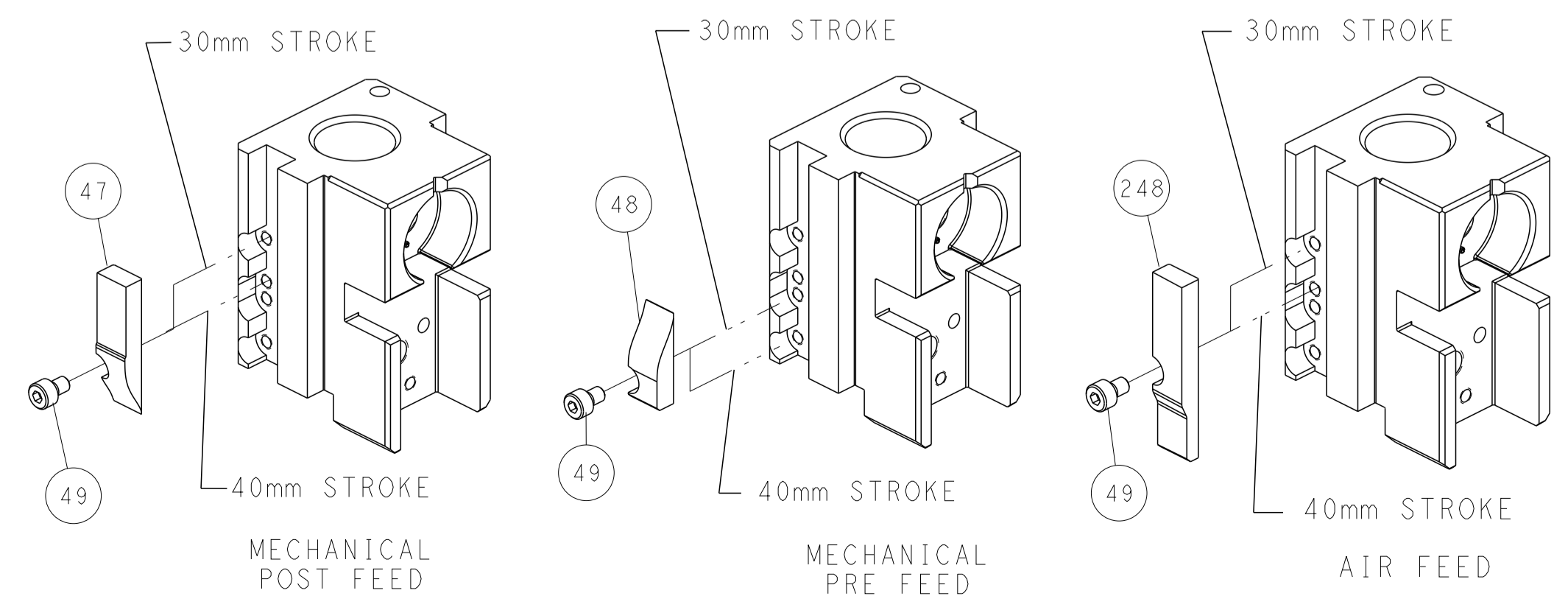
RAM SET-UP



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: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH		DWN M_ZHAO 06FEB2017 CHK T_ELBIN 06FEB2017 APVD T_ELBIN 06FEB2017 NAME PRODUCT SPEC APPLICATION SPEC WEIGHT Customer Accessible Production Drawing		TE Connectivity Harrisburg, PA 17105-3608 SIZE CAGE CODE DRAWING NO A1 00779 C=2836618 SCALE 1:2 SHEET 2 OF 4 REV B	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2836618-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2836618-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2836618-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
 INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.07 mm [.042]	F
INSUL	1.57 mm [.062]	O

APPLICATOR INSTRUCTIONS
 408-35042

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

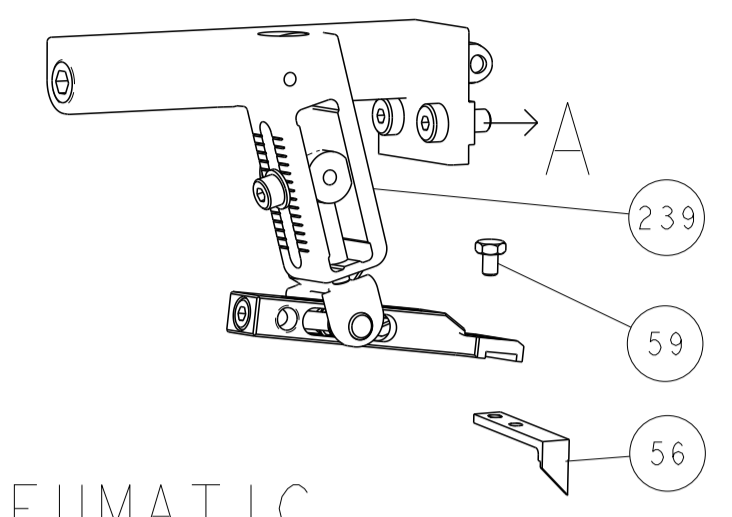
LOC	DIST	REVISIONS					
		P	LTN	DESCRIPTION	DATE	OWN	APVD
A	66	-	-	SEE SHEET 1	-	-	-

-	1	1	2119082-5	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	-	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	1803516-1	RAM ASSEMBLY, SF PACIFIC	140
5	-	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	1803607-3	DOCUMENTATION PACKAGE	71
-	1	1	2119791-9	DEPRESSOR, WIRE	70
-	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
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-	2	2	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	53
-	1	1	1803382-1	HOLD DOWN, SPRING LOADED	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	2-1752356-7	SUPPORT, TERMINAL	34
-	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	2-2844962-4	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29
-	1	1	1320928-2	STRIP GUIDE	24
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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	1	1-1633916-6	ANVIL, COMBINATION	8
-	-	-	-	-	7
-	-	-	-	-	6
-	1	1	2119757-4	DEPRESSOR, SHEAR	5
-	1	1	4-238011-7	BLOCK, CRIMPER SPACER	4
1	1	1	1633966-2	CRIMPER, INSULATION O	3
-	-	-	-	-	2
1	1	1	7-1633713-5	CRIMPER, WIRE PREMIUM	1
-77	-22	-21	PART NO	DESCRIPTION	ITEM NO

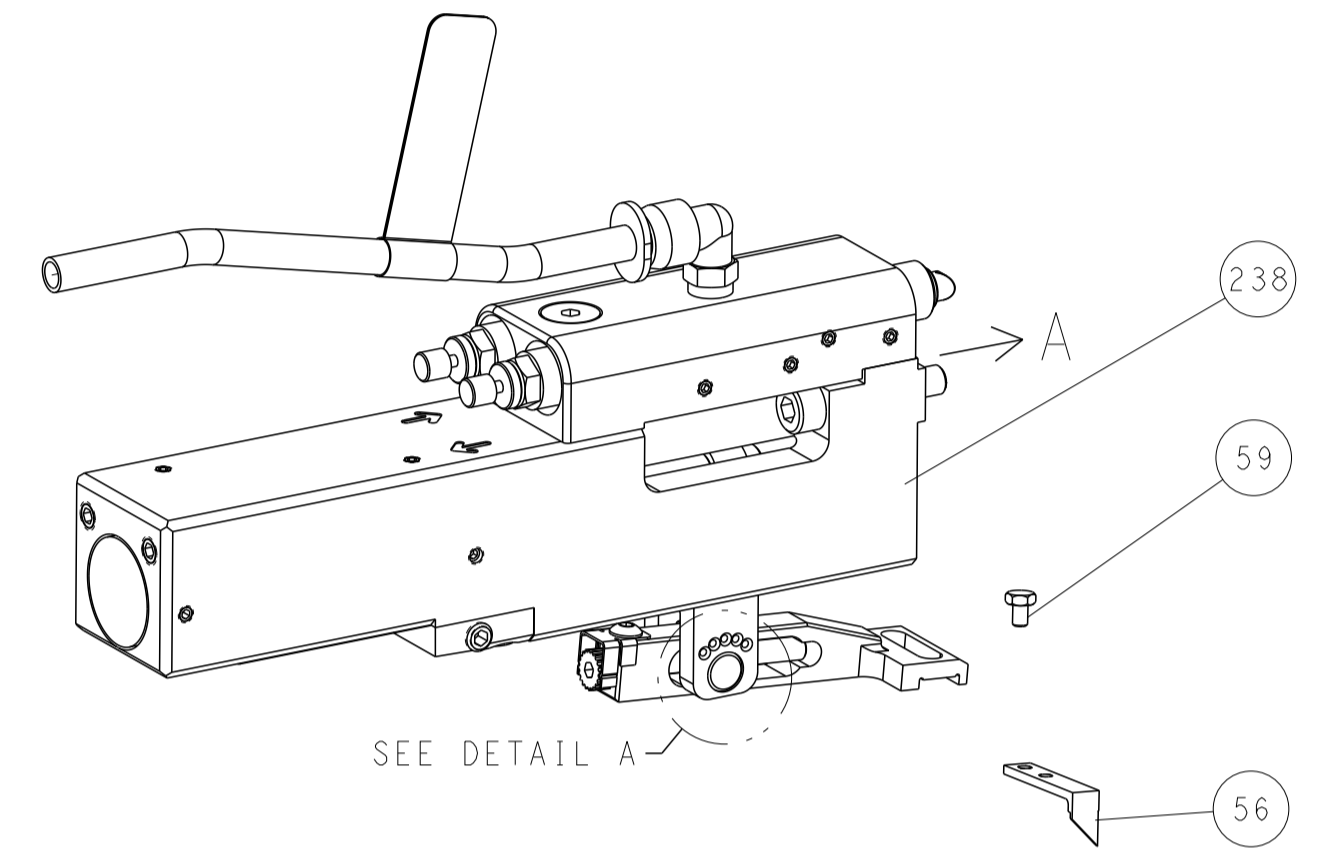
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		MATERIAL:		FINISH:	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES	FINISH
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CHG		CHG		CHG		CHG	
DATE		DATE		DATE		DATE	
06FEB2017		06FEB2017		06FEB2017		06FEB2017	
M. ZHAO		T. ELBIN		T. ELBIN		T. ELBIN	
NAME		NAME		NAME		NAME	
Ocean Side Feed		Ocean Side Feed		Ocean Side Feed		Ocean Side Feed	
Applicator		Applicator		Applicator		Applicator	
SIZE		CAGE CODE		DRAWING NO		RESTRICTED TO	
A1		00779		C=2836618		-	
Customer Accessible Production Drawing		SCALE		SHEET		REV	
-		1:2		3 OF 4		B	

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

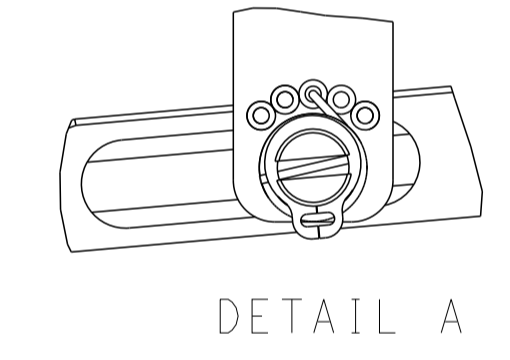
FEED TYPE MECHANICAL



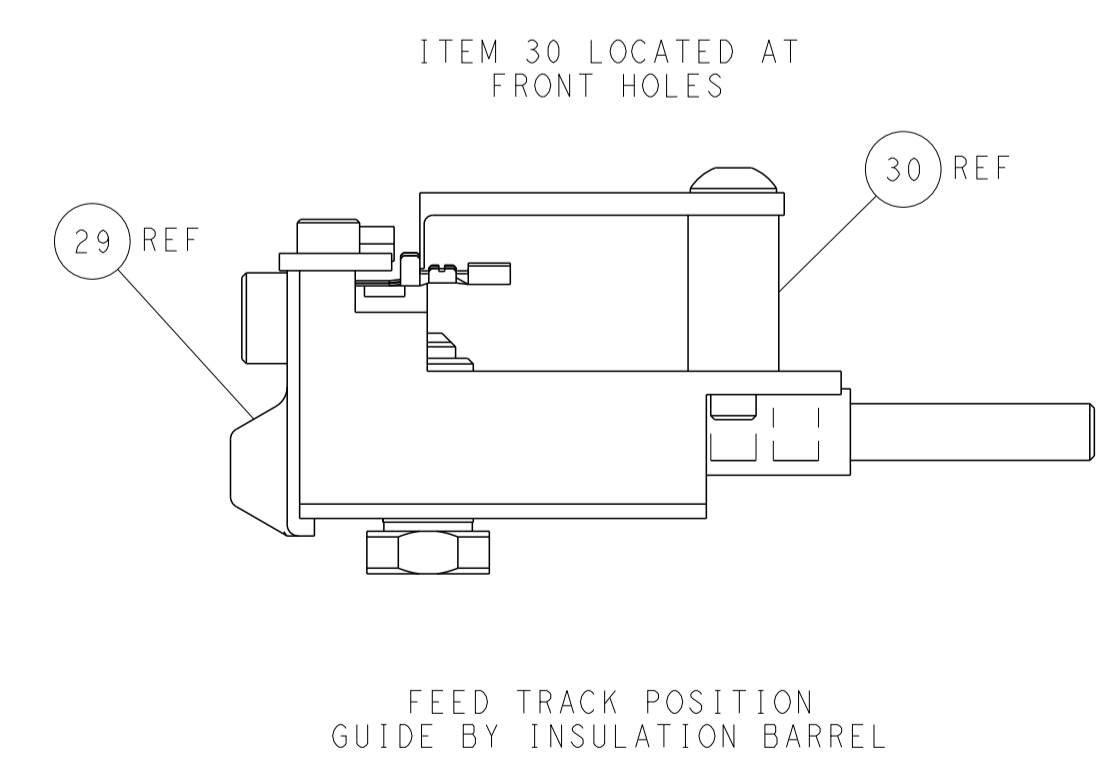
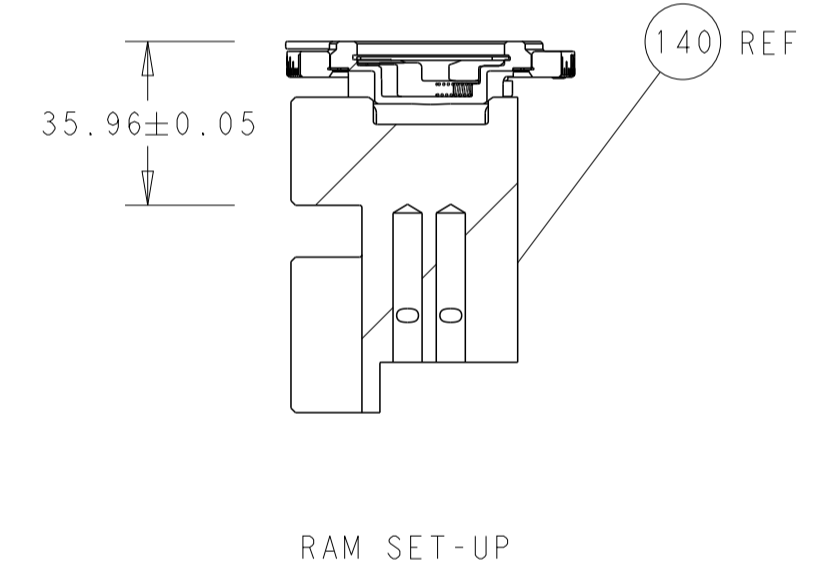
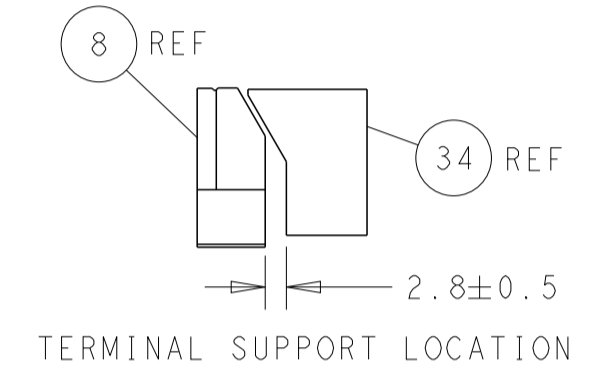
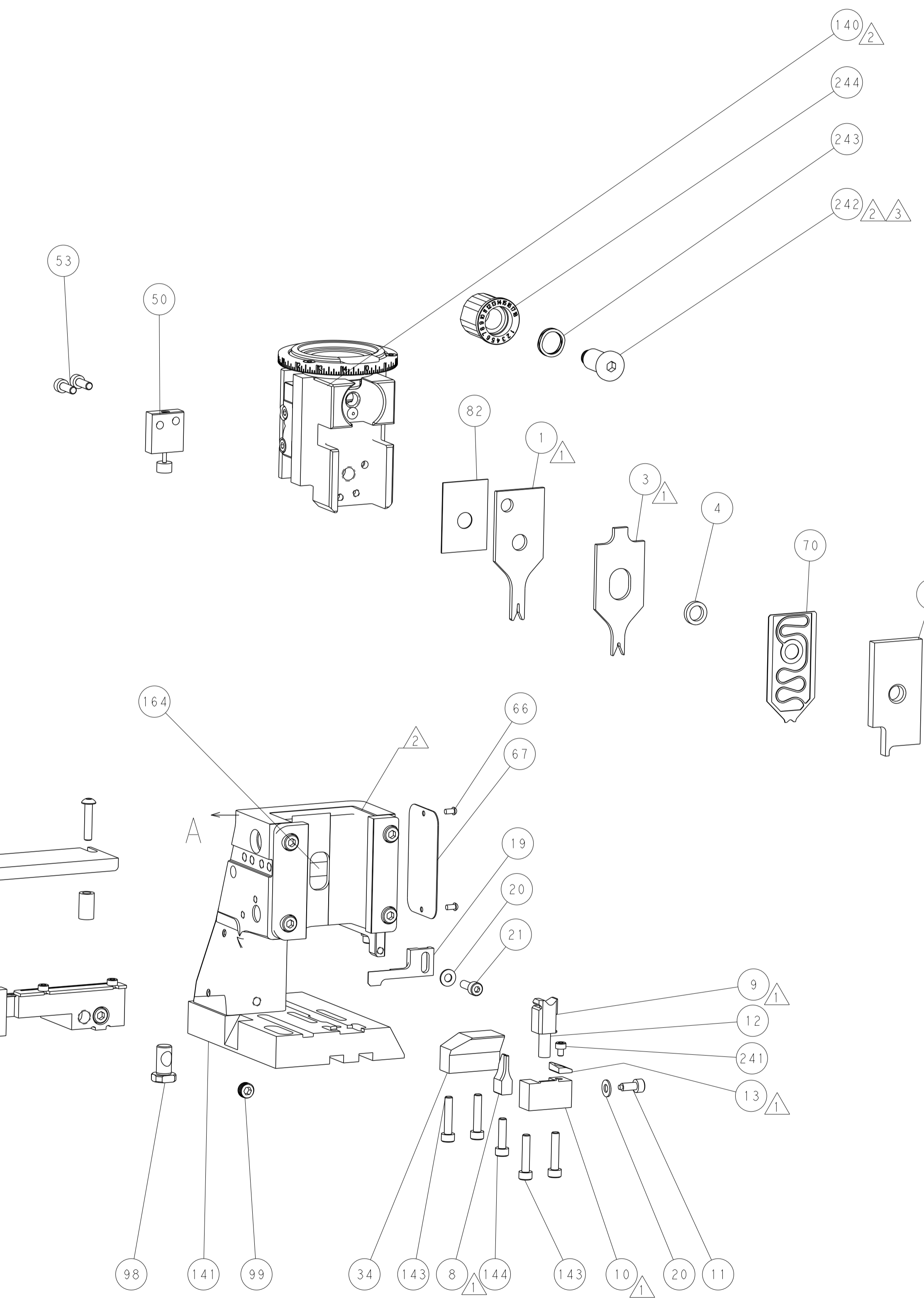
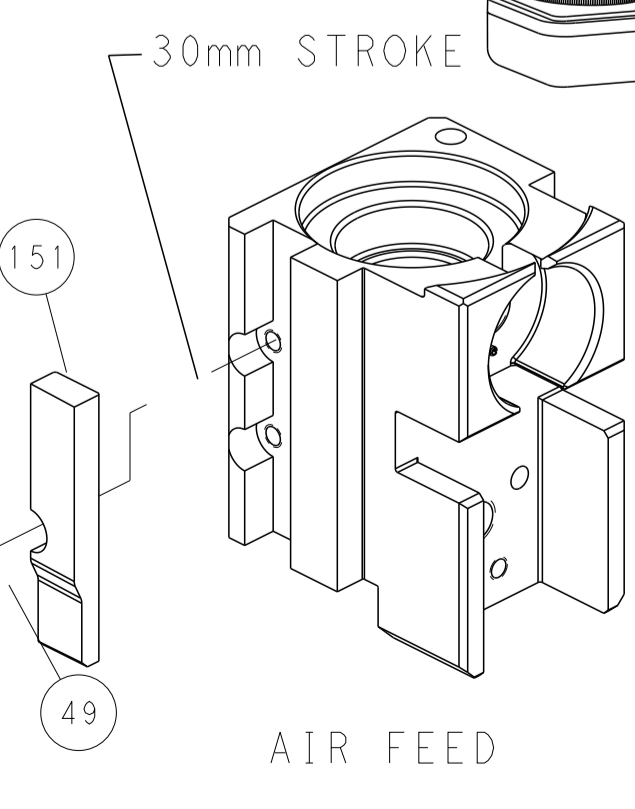
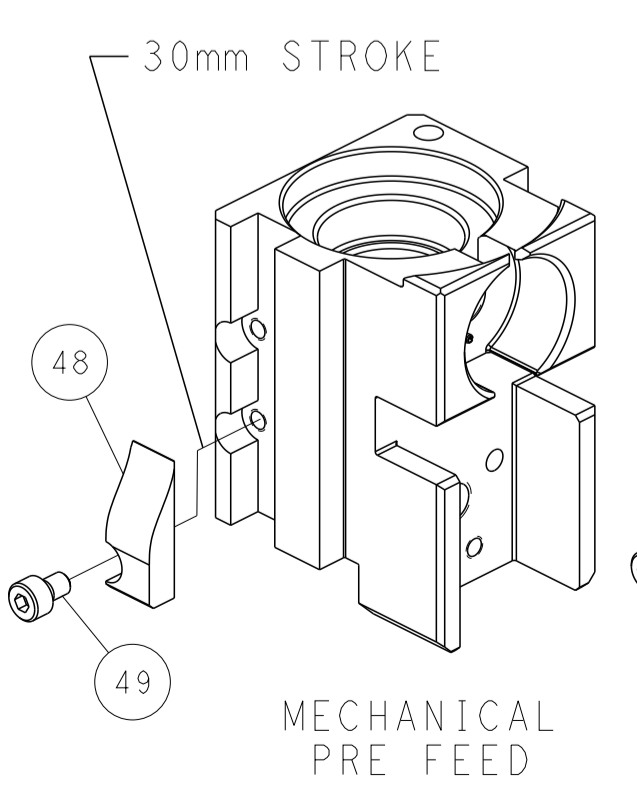
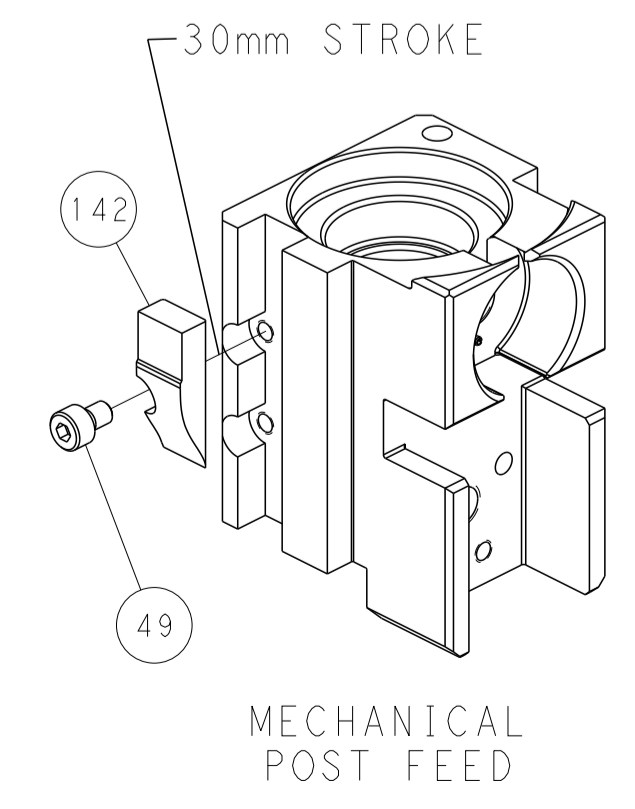
PNEUMATIC



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)

DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH ±		DWN M_ZHAO 06FEB2017 CHK T_ELBIN 06FEB2017 APVD T_ELBIN 06FEB2017 PRODUCT SPEC APPLICATION SPEC WEIGHT Customer Accessible Production Drawing		NAME Ocean Side Feed Applicator SIZE CAGE CODE DRAWING NO A1 00779 C=2836618 SCALE 1:2 SHEET 4 OF 4 REV B		RESTRICTED TO -	
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