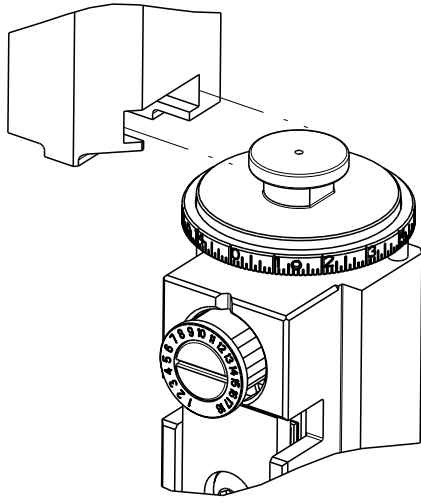
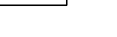


8		7	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2836869-2	E	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2836869-2	E	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2836869-7	C	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	7.11 mm [.280]	F
INSUL	8.64 mm [.340]	O
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: RING TERMINAL			
WIRE STRIP LENGTH 5.18-5.94 mm [.204-.234 IN]			INSULATION DIAMETER RANGE Ø5.33-7.37 mm [.210-.290 IN]
TERMINAL APPLICATION SPECIFICATION		114-2084	
			
TERMINALS APPLIED			
TE TERMINAL 61866-3	TE TERMINAL	TE TERMINAL	TE TERMINAL

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING
6 AWG		4.72+/-0.05 [.186+/- .002]		1.9
8 AWG		4.17+/-0.05 [.164+/- .002]		7.1
10 AWG		3.76+/-0.05 [.148+/- .002]		12.7



- 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 PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- 6 TERMINAL LUBRICANT IS RECOMMENDED.
- 7 RECOMMENDED FOR USE ONLY WITH GII+ PRESS.

8. 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	LYR	DESCRIPTION	DATE	DWN	APVD	
			C	ECR-18-000908	22JAN2018	JAH	CT	
			D	ECR-18-003559	19MAR2018	AW	CT	
			D1	ECR-18-005308	10APR2018	FZ	KZ	
			E	ECR-19-017881	20NOV2019	FJ	TE	

-	1	1	1803078-3	SPACER, PRECISION	259
-	1	1	2119641-1	FEED CAM, AIR FEED	248
-	1	1	2119082-6	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	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
-	1	1	2844940-2	AIR FEED MODULE	238
-	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	1	1	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113
-	1	1	2844908-1	SCREW, LOCKING	99
-	1	1	2844907-1	POST, LOCKING	98
-	1	1	455888-6	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	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	60
-	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	1	1	1338683-8	FEED PAWL	56
-	4	4	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	54
-	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	690753-2	SPACER, TONKER	50
-	1	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	1	1	1803583-9	APPLICATOR BASIC ASSEMBLY, SF	46
-	1	1	1803515-2	RAM ASSEMBLY, SF ATLANTIC	44
-	1	1	1803602-2	SCR, BHSC, RoHS (M8 X 40)	41
-	1	1	1752356-6	SUPPORT, TERMINAL	34
-	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	3-2844962-5	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	2844992-9	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	2119533-1	STRIPPER, SIDE FEED	19
-	1	1	2119806-1	INSERT, SHEAR	13
-	1	1	3-22280-3	SPRING, COMPRESSION	12
-	1	1	1-356885-3	STOP, SHEAR	11
-	1	1	2119805-1	SHEAR HOLDER, FRONT	10
-	1	1	454276-5	FLOATING SHEAR, FRONT	9
1	2	1	1633929-5	ANVIL, COMBINATION	8
-	-	-	-	-	7
-	-	-	-	-	6
-	1	1	1-2119757-7	DEPRESSOR, SHEAR	5
-	1	1	238011-3	BLOCK, CRIMPER SPACER	4
1	2	1	4-1803018-3	CRIMPER, INSULATION O	3
-	1	1	455888-3	SPACER, CRIMPER	2
1	2	1	6-1673600-6	CRIMPER, WIRE	1

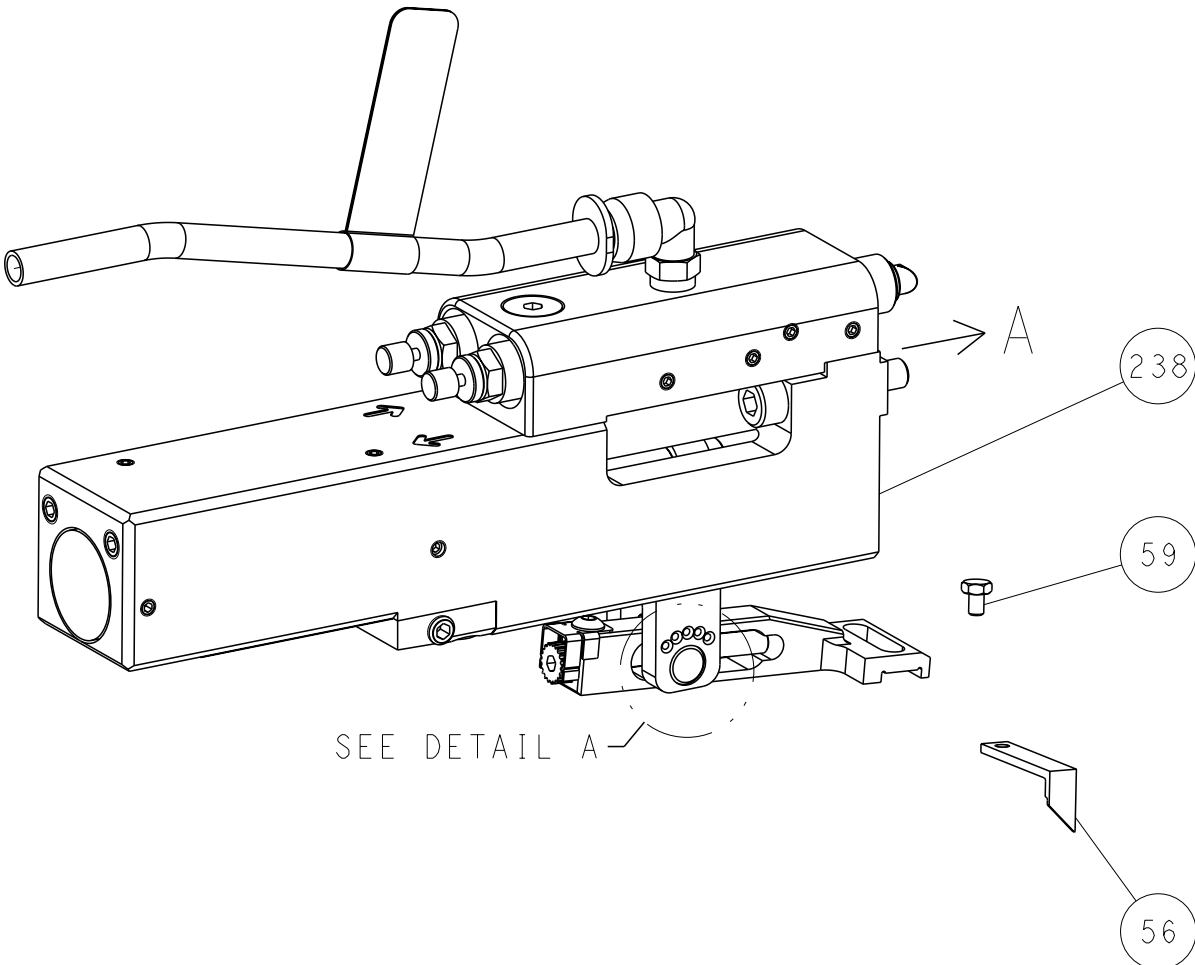
-77-72	-2	PART NO	DESCRIPTION	ITEM NO
Customer Accessible Production Drawing				
SCALE 1:2 SHEET 1 OF 4 REV E				

THIS DRAWING IS CONTROLLED DOCUMENT FOR THE ELECTRICAL CONNECTIONS. IT IS SUBJECT TO CHANGE AND TO CONTROL THE ENGINEERING ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST REVISION.		DWN F. ZHANG 20JUL2017	TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm		CHK T. BROOKENS 20JUL2017	NAME Ocean Side Feed Applicator	
TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		APVD C. TOPPER 20JUL2017	SIZE 00779	
MATERIAL		WEIGHT	DRAWING NO 00779	
FINISH		RESTRICTED TO	C=2836869	

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

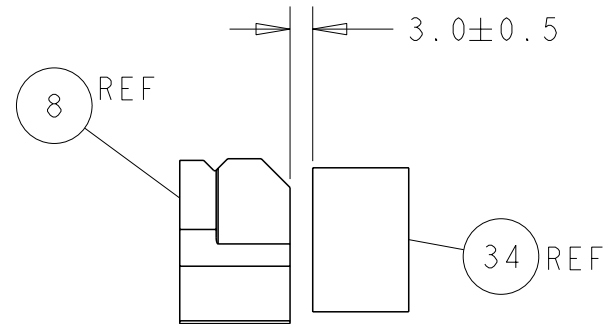
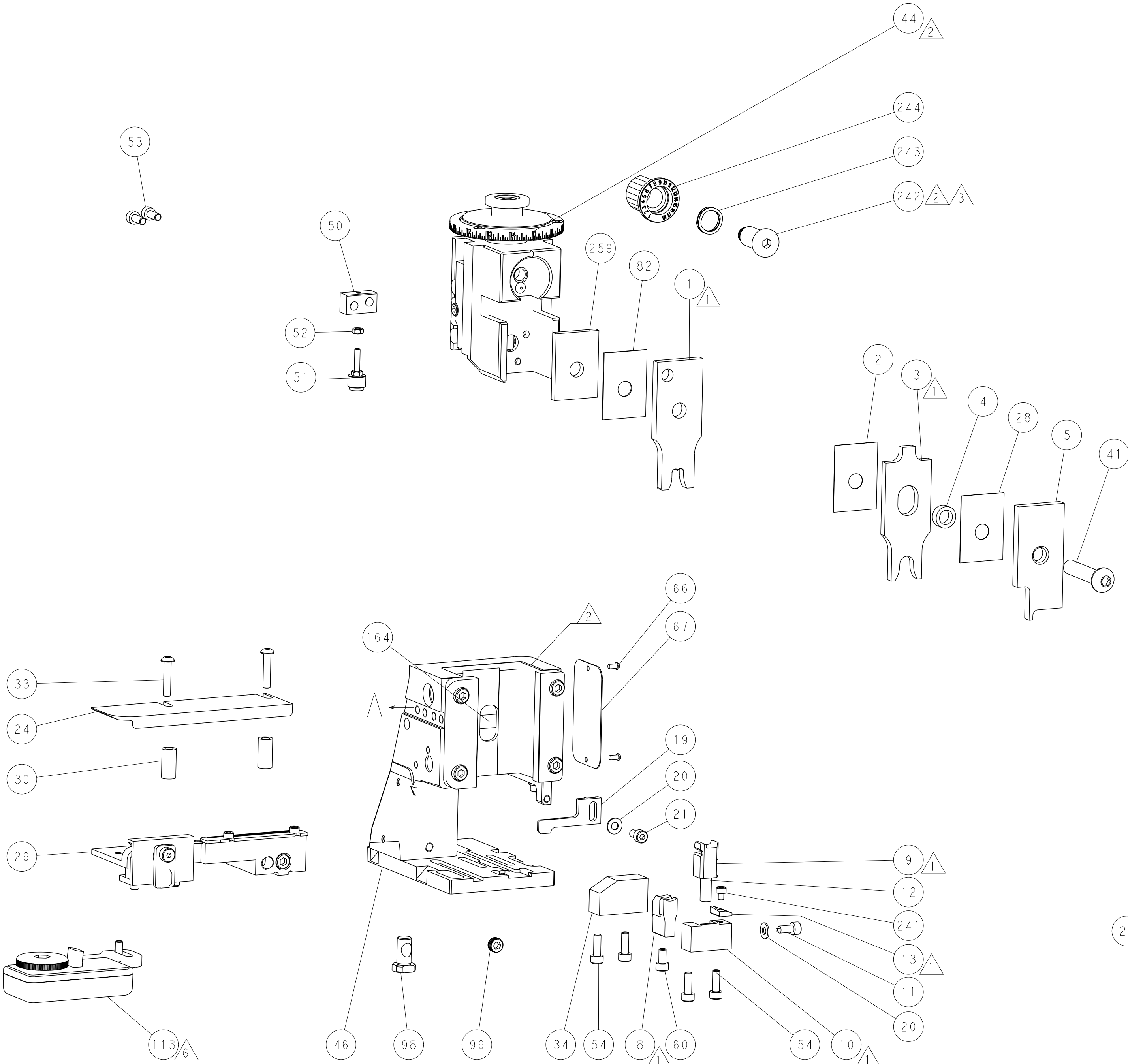
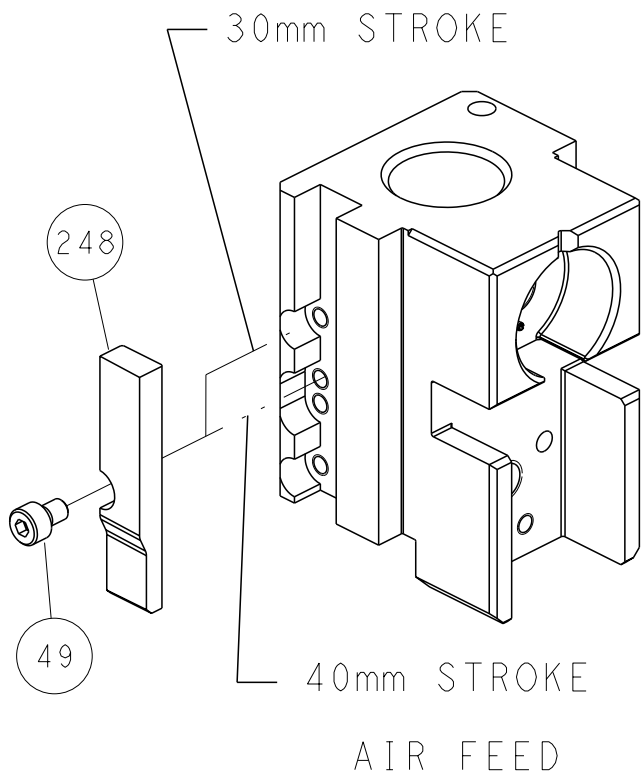
FEED TYPE

PNEUMATIC

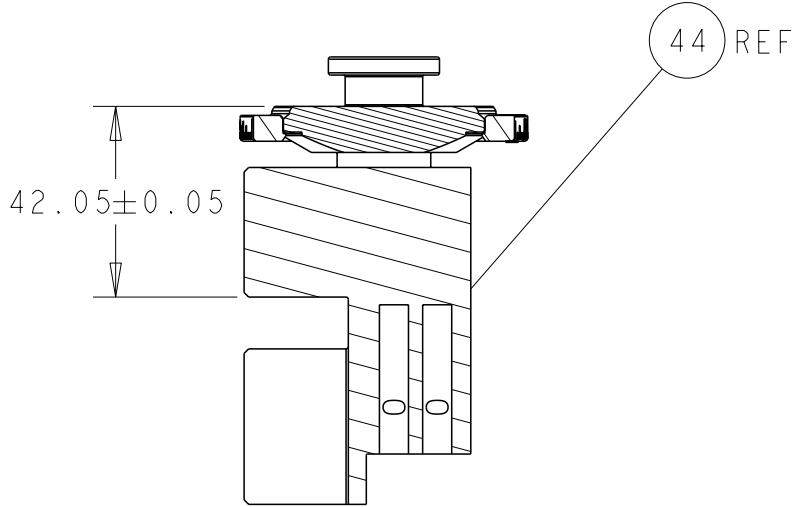


DETAIL A

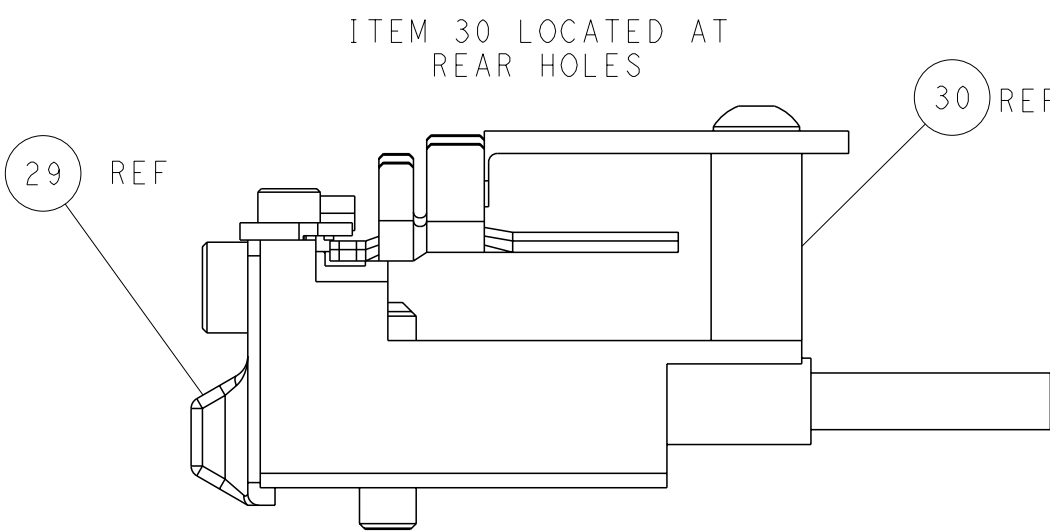
CAM POSITION



TERMINAL SUPPORT LOCATION



RAM SET-UP



FEED TRACK POSITION GUIDE BY WIRE BARREL

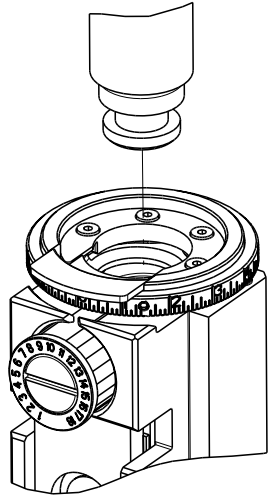
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE AND TO CONTROL AND ENGINEERING DEPARTMENT SHOULD BE CONTACTED FOR THE LATEST REVISION.		DWN F. ZHANG 20JUL2017	20JUL2017	TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm		CHK T. BROOKENS 20JUL2017	20JUL2017	NAME Ocean Side Feed Applicator	
TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		APVD C. TOPPER 20JUL2017	20JUL2017	SIZE A1	
MATERIAL -		APPLICATION SPEC -		CAGE CODE DRAWING NO 00779 C=2836869	
FINISH -		WEIGHT -		RESTRICTED TO -	
		Customer Accessible Production Drawing		SCALE 1:2	SHEET 2 OF 4
				REV E	

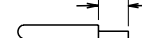
SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

8		7	
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20		20	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2836869-2	E	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2836869-7	C	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	7.11 mm [.280]	F
INSUL	8.64 mm [.340]	O
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: RING TERMINAL			
WIRE STRIP LENGTH 5.18-5.94 mm [.204-.234 IN]			INSULATION DIAMETER RANGE Ø5.33-7.37 mm [.210-.290 IN]
TERMINAL APPLICATION SPECIFICATION		114-2084	-
		-	-
TERMINALS APPLIED  			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
61866-3			

WIRE SIZE		CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
6 AWG		4.72+/-0.05 [.186+/- .002]	1.9
8 AWG		4.17+/-0.05 [.164+/- .002]	7.1
10 AWG		3.76+/-0.05 [.148+/- .002]	12.7



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 PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
6. TERMINAL LUBRICANT IS RECOMMENDED.
7. RECOMMENDED FOR USE ONLY WITH GII+ PRESS.
8. 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)

2		1						
LOC	DIST	REVISIONS						
A	66	P	LYR	DESCRIPTION	DATE	DWN	APVD	
		-		SEE SHEET 1	-	-	-	

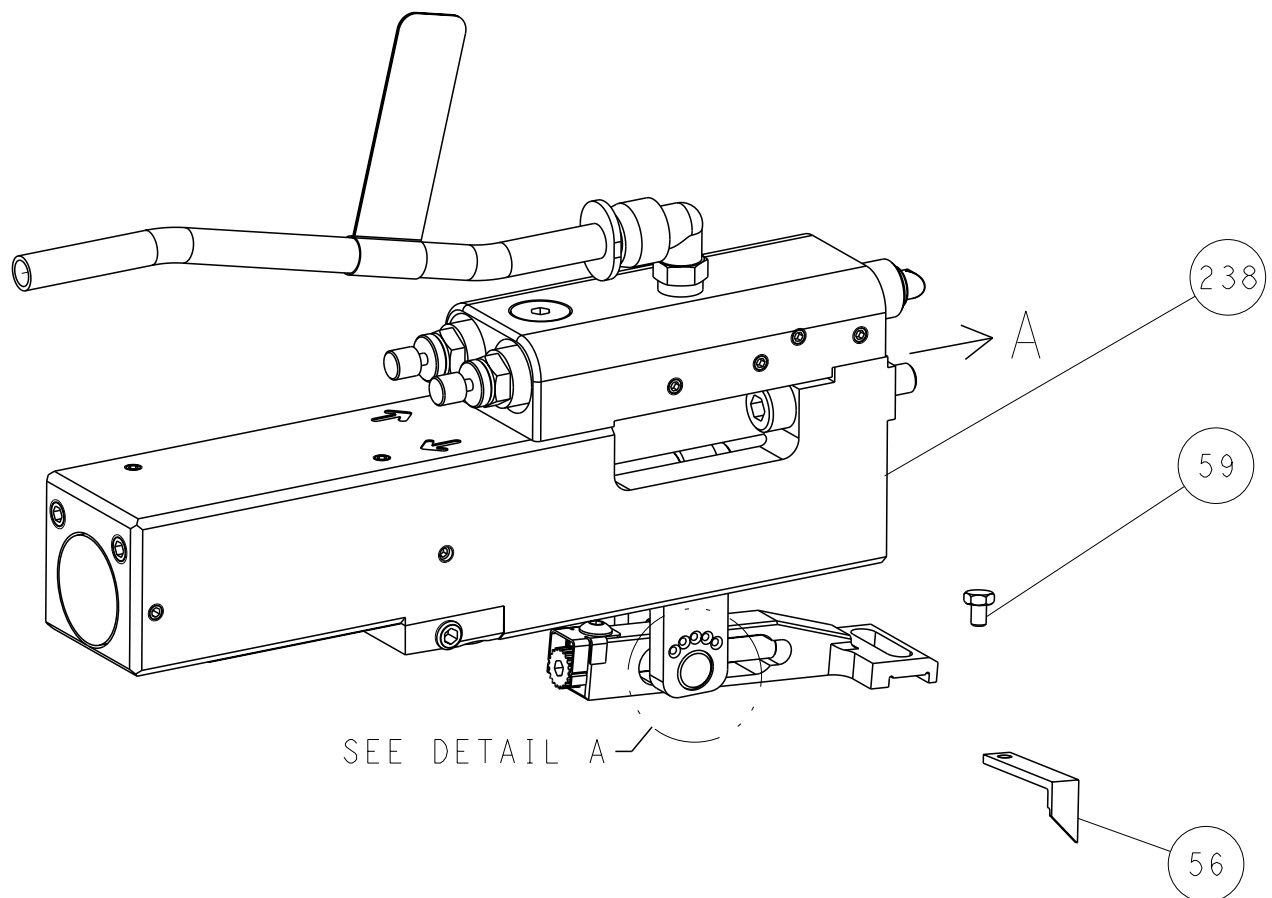
-	1	1803078-3	SPACER, PRECISION	259
-	1	2119082-6	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
3	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
-	1	2844940-2	AIR FEED MODULE	238
-	REF	994970-2	COUNTER, MAGNETIC	164
-	1	2119641-2	FEED CAM, AIR FEED	151
-	1	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	144
-	4	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	143
-	1	1-1803583-0	APPLICATOR BASIC ASSEMBLY, SF	141
-	1	1803516-2	RAM ASSEMBLY, SF PACIFIC	140
6	1	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113
-	1	2844908-1	SCREW, LOCKING	99
-	1	2844907-1	POST, LOCKING	98
-	1	455888-6	SPACER, CRIMPER	82
-	1	1803607-3	DOCUMENTATION PACKAGE	71
-	1	2119740-1	TAG, IDENTIFICATION	67
-	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	1	1338683-8	FEED PAWL	56
-	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	53
-	1	5018030-1	NUT, HEX, REG, RoHS, M3	52
-	1	811242-5	BUMPER, HOLD DOWN	51
-	1	690753-2	SPACER, TONKER	50
-	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	1	1803602-2	SCR, BHSC, RoHS (M8 X 40)	41
-	1	1752356-6	SUPPORT, TERMINAL	34
-	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	3-2844962-5	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	2844992-9	ASSEMBLY, STRIP GUIDE	29
-	1	455888-3	SPACER, CRIMPER	28
-	1	1320928-2	STRIP GUIDE	24
-	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
-	2	1-18028-2	WASHER, FLAT, REG M4	20
-	1	2119533-1	STRIPPER, SIDE FEED	19
1	1	2119806-1	INSERT, SHEAR	13
-	1	3-22280-3	SPRING, COMPRESSION	12
-	1	1-356885-3	STOP, SHEAR	11
1	1	2119805-1	SHEAR HOLDER, FRONT	10
1	1	454276-5	FLOATING SHEAR, FRONT	9
1	1	1633929-5	ANVIL, COMBINATION	8
-	-	-	-	7
-	-	-	-	6
-	1	1-2119757-7	DEPRESSOR, SHEAR	5
-	1	238011-3	BLOCK, CRIMPER SPACER	4
1	1	4-1803018-3	CRIMPER, INSULATION O	3
-	1	455888-3	SPACER, CRIMPER	2
1	1	6-1673600-6	CRIMPER, WIRE	1

THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE AND TO BE CONTROLLED BY THE ENGINEERING ORGANIZATION. IT SHOULD BE CONTACTED FOR THE LATEST REVISION.				DWN F. ZHANG 20JUL2017	TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm				CHK T. BROOKENS 20JUL2017	NAME Ocean Side Feed Applicator	
TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±				APVD C. TOPPER 20JUL2017	SIZE 00779	
MATERIAL -				APPLICATION SPEC -	CAGE CODE 00779	
FINISH -				WEIGHT -	DRAWING NO 2836869	
Customer Accessible Production Drawing				SCALE 1:2	SHEET 3	OF 4
				REV E		

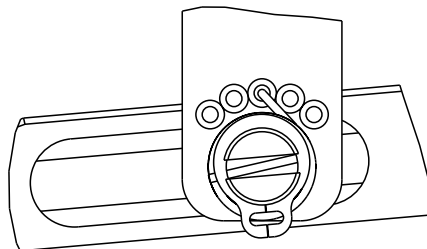
SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

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

FEED TYPE
PNEUMATIC

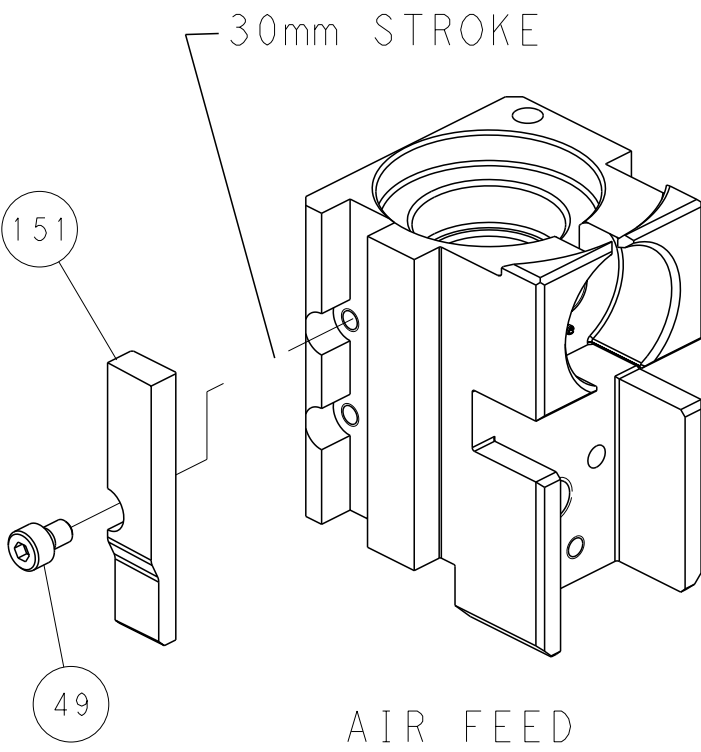


FEED SPRING SETTING POSITION
(SHOWN FROM REAR SIDE)

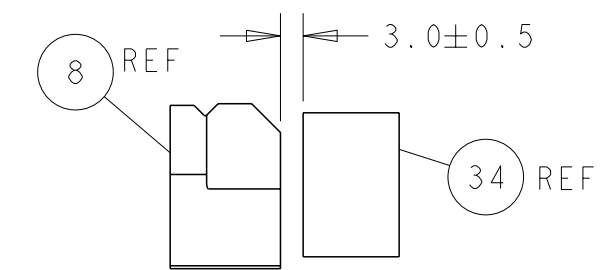
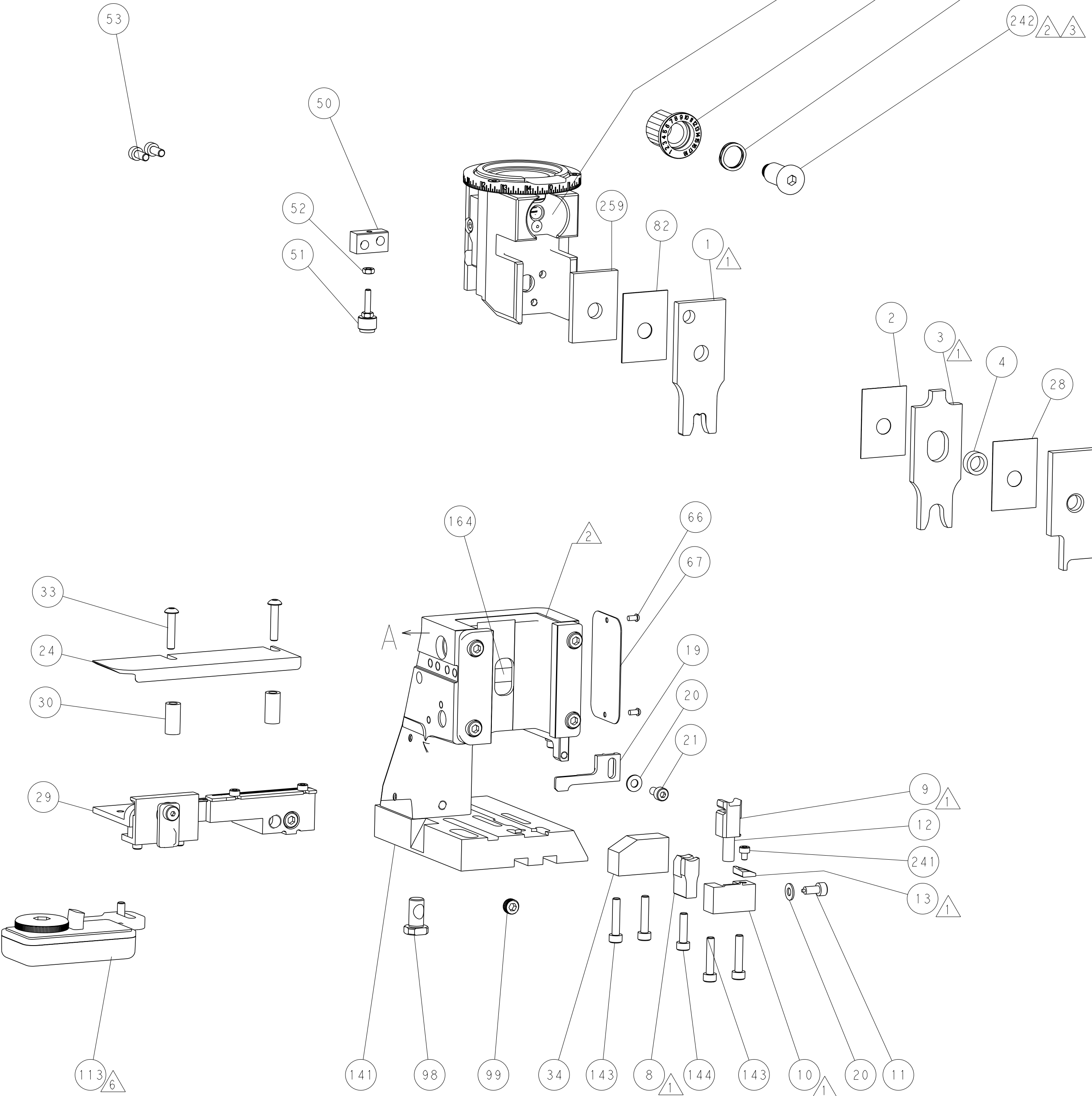


DETAIL A

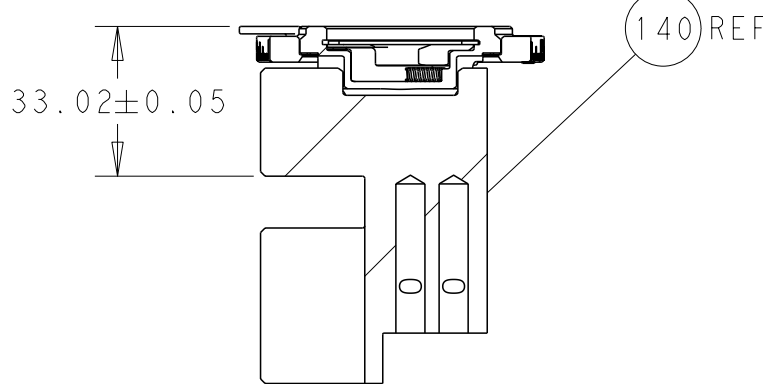
CAM POSITION



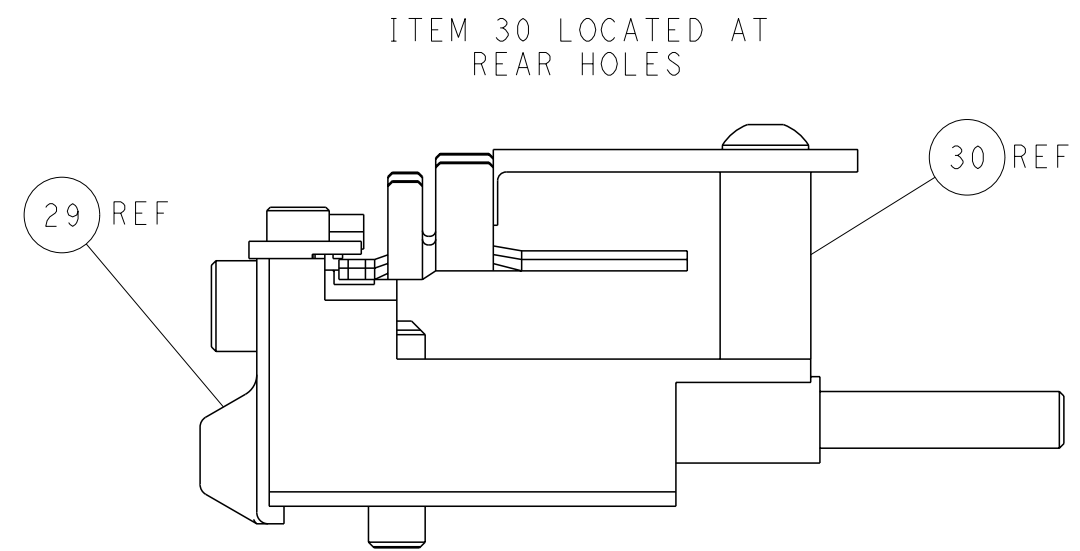
AIR FEED



TERMINAL SUPPORT LOCATION



RAM SET-UP



FEED TRACK POSITION
GUIDE BY WIRE BARREL

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

THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE AND TO CONTROL AND ENGINEERING DISCRETION. SHOULD BE CONTACTED FOR THE LATEST REVISION.		DWN F. ZHANG 20JUL2017	TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm		CHK T. BROOKENS 20JUL2017	NAME Ocean Side Feed Applicator	
TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH -		APVD C. TOPPER 20JUL2017	SIZE A1	
MATERIAL -		PRODUCT SPEC APPLICATION SPEC WEIGHT -	CAGE CODE DRAWING NO 00779 C=2836869	
		Customer Accessible Production Drawing	SCALE 1:2	SHEET 4 OF 4
			REV E	