

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2836915-1	D	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2836915-2	D	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2836915-1	D	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2836915-2	D	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2836915-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.57 mm [.062]	F
INSUL	2.03 mm [.080]	O

APPLICATOR INSTRUCTIONS
408-35042

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: SIZE 2.8 AMPLIVAR FASTON RECPT			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
5.70-6.46 mm [.224-.254 IN]		Ø0.00-1.70 mm [.000-.067 IN]	
TERMINAL APPLICATION SPECIFICATION	114-58501		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
1494212-1	1494212-2		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
MAG WIRE Ø 0.75	0.95+/-0.05 [.037+/- .002]	7.0
MAG WIRE Ø 0.68	0.91+/-0.05 [.036+/- .002]	7.5
MAG WIRE Ø 0.57	0.86+/-0.05 [.034+/- .002]	8.3
MAG WIRE Ø 0.45	0.82+/-0.05 [.032+/- .002]	8.8

- 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.
- 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)

LOC	DIST	REVISIONS					
A	66	P	LTN	DESCRIPTION	DATE	OWN	APVD
		A		RELEASED	31OCT2017	TB	CT
		B		ECR-18-005534	12APR2018	MZ	KZ
		C		ECR-18-009216	13JUN2018	VLA	JDG
		D		ECR-19-006311	18APR2019	FL	TE

-	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	
-	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	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	455888-7	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	1803382-6	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	1752356-3	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	2844992-2	ASSEMBLY, STRIP GUIDE	29	
-	1	1	1	1	455888-5	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	2119533-1	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	1-356885-5	STOP, SHEAR	11	
-	1	1	1	1	2119805-1	SHEAR HOLDER, FRONT	10	
-	1	1	1	1	1803095-1	FLOATING SHEAR, FRONT	9	
-	1	2	2	1	1803591-1	ANVIL, WIRE - F	8	
-	-	-	-	-	-	-	7	
-	-	-	-	-	-	-	6	
-	1	1	1	1	2119757-2	DEPRESSOR, SHEAR	5	
-	1	1	1	1	1-238011-0	BLOCK, CRIMPER SPACER	4	
-	1	2	2	1	2119784-3	CRIMPER, INSULATION O PREMIUM	3	
-	1	1	1	1	455888-3	SPACER, CRIMPER	2	
-	1	2	2	1	7-456403-0	CRIMPER, WIRE PREMIUM	1	
-	77	-72	-71	-2	-1	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 ±

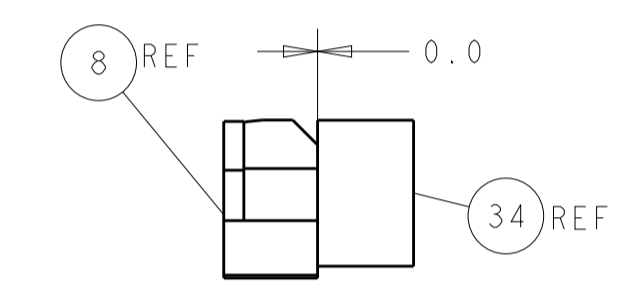
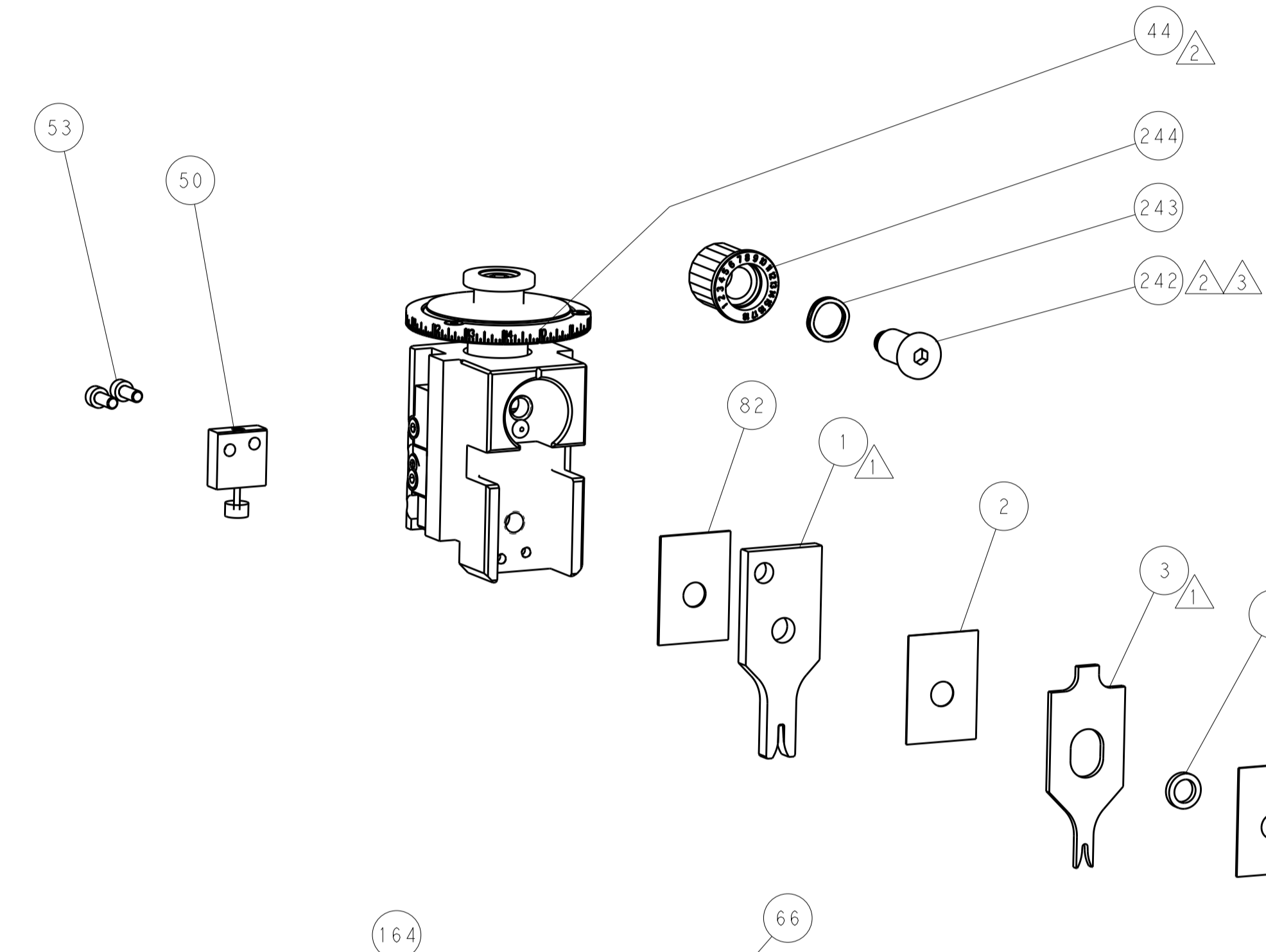
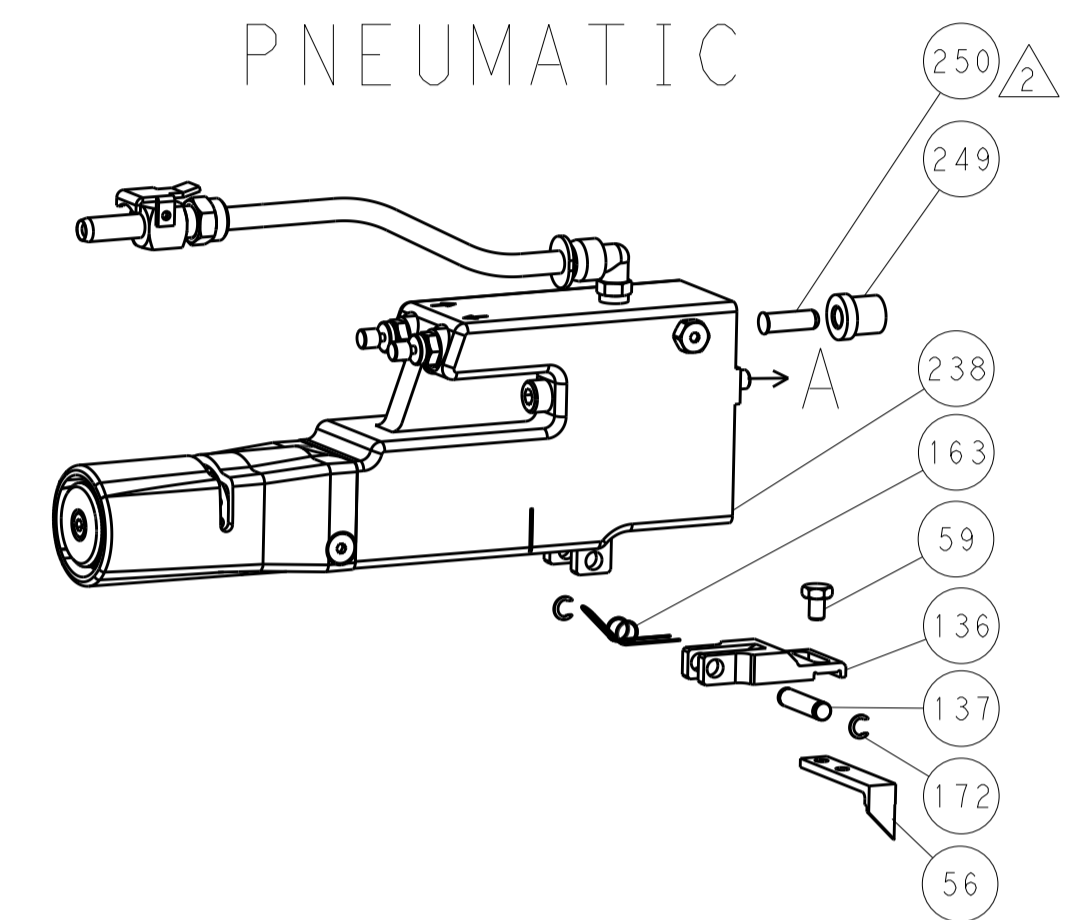
OWN	T. BROOKENS	05SEP2017
CHK	M. HERR	05SEP2017
APVD	T. ELBIN	05SEP2017
NAME	Ocean Side Feed Applicator	
SIZE	CAGE CODE	DRAWING NO
A1	00779	2836915
Customer Accessible Production Drawing		
SCALE	1:2	SHEET 1 OF 4
REV	D	

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

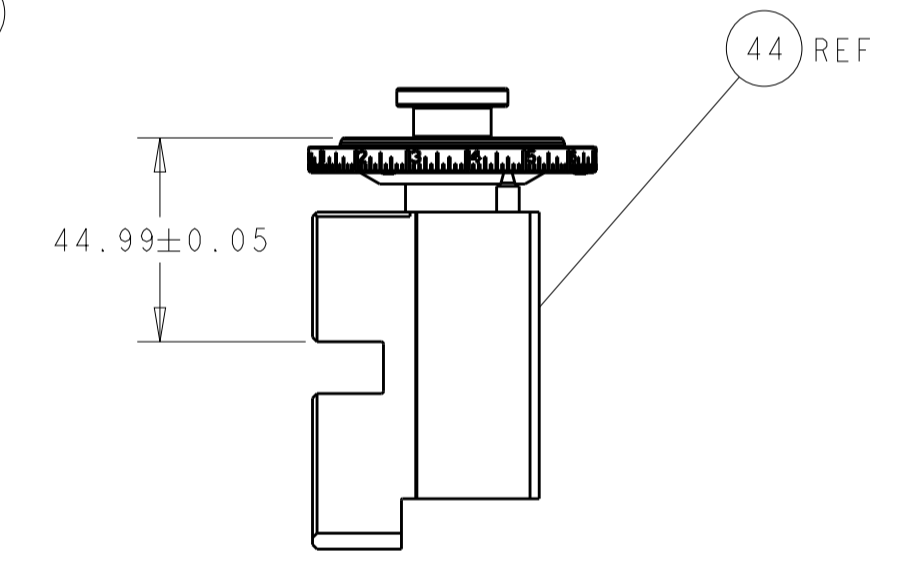
FEED TYPE MECHANICAL



PNEUMATIC

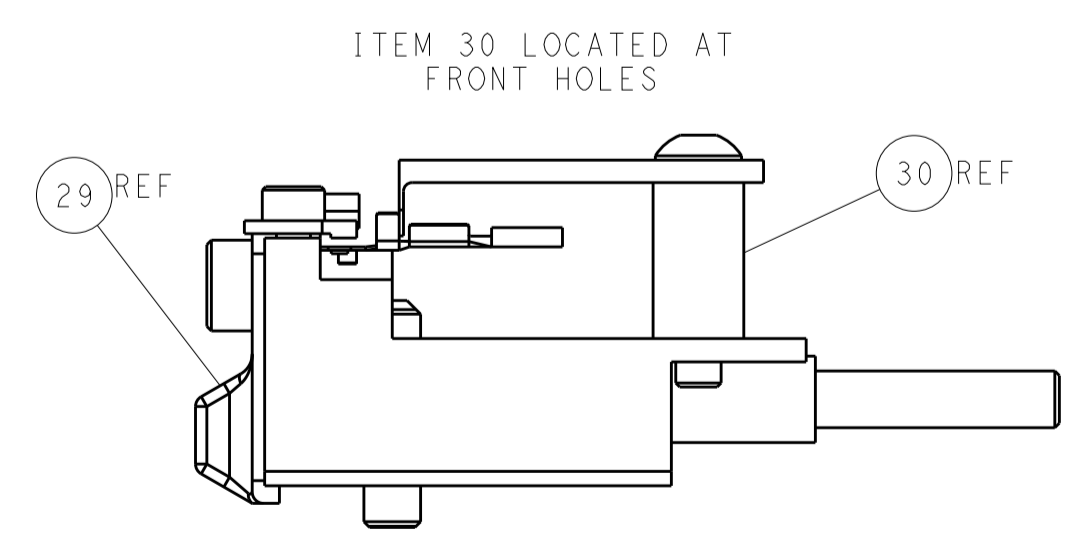
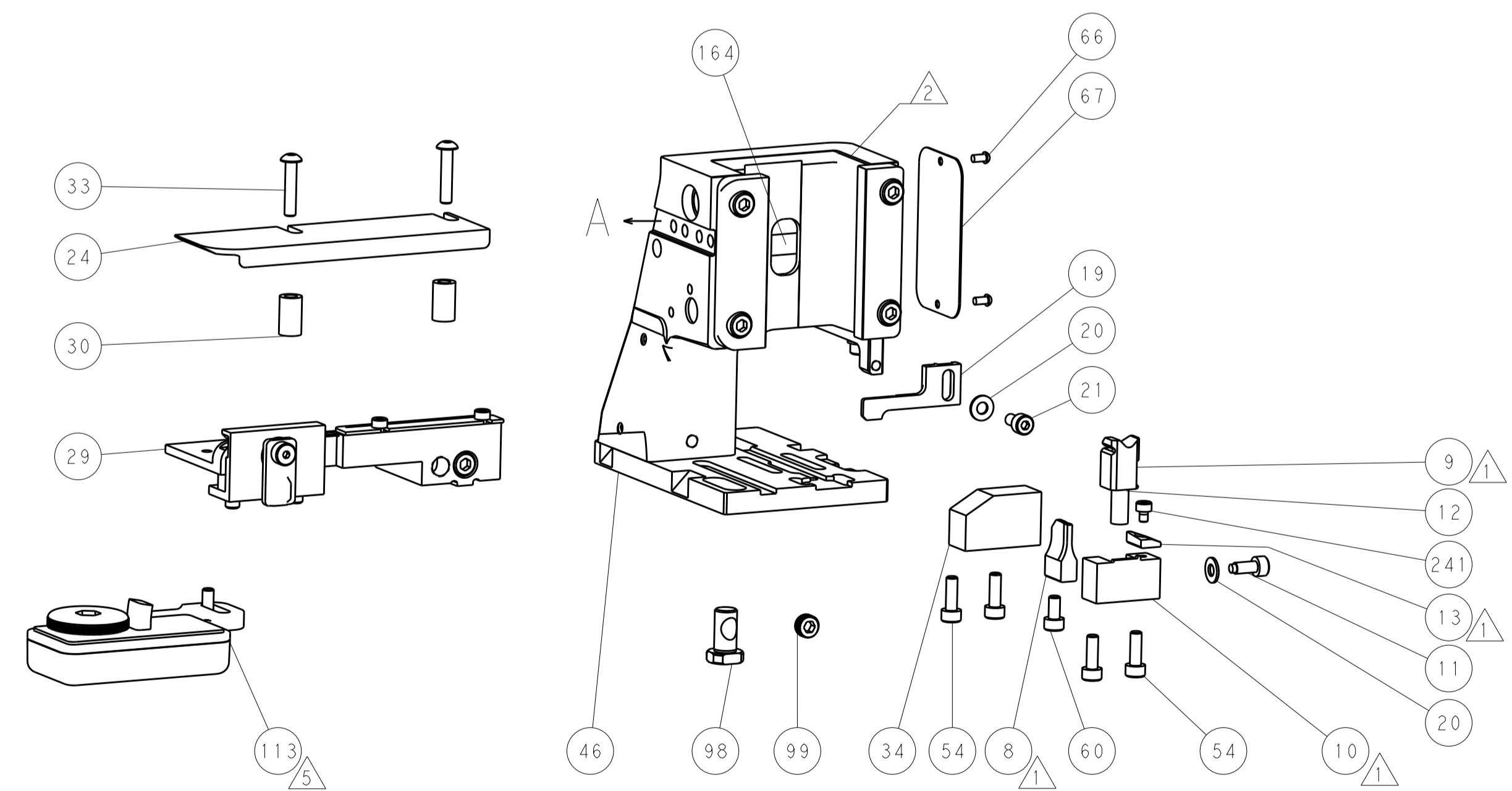
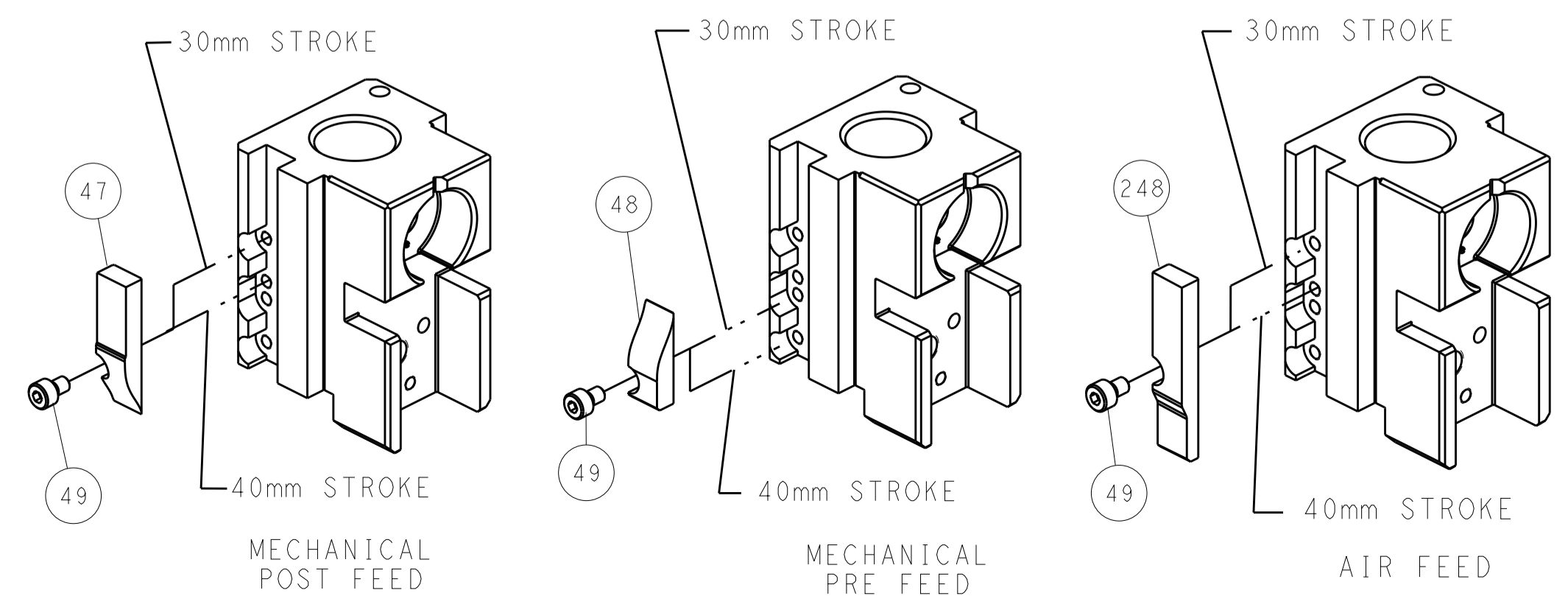


TERMINAL SUPPORT LOCATION



RAM SET-UP

CAM POSITIONS



FEED TRACK POSITION GUIDE BY INSULATION BARREL

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 T. BROOKENS 05SEP2017		TE Connectivity	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	Harrisburg, PA 17105-3608	
MATERIAL:		FINISH:		CHK M. HERR 05SEP2017		NAME	
				APVD T. ELBIN 05SEP2017		Ocean Side Feed Applicator	
				PRODUCT SPEC		SIZE	
				APPLICATION SPEC		CAGE CODE DRAWING NO	
				WEIGHT		RESTRICTED TO	
				A 00779		©=2836915	
				Customer Accessible Production Drawing		SCALE 1:2 SHEET 2 OF 4 REV D	

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2836915-1	D	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2836915-2	D	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2836915-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.57 mm [.062]	F
INSUL	2.03 mm [.080]	O

APPLICATOR INSTRUCTIONS
408-35042

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: SIZE 2.8 AMPLIVAR FASTON RECPT			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
5.70-6.46 mm [.224-.254 IN]		Ø0.00-1.70 mm [.000-.067 IN]	
TERMINAL APPLICATION SPECIFICATION	114-58501	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
1494212-1	1494212-2		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
MAG WIRE Ø 0.75	0.95+/-0.05 [.037+/-0.002]	7.0
MAG WIRE Ø 0.68	0.91+/-0.05 [.036+/-0.002]	7.5
MAG WIRE Ø 0.57	0.86+/-0.05 [.034+/-0.002]	8.3
MAG WIRE Ø 0.45	0.82+/-0.05 [.032+/-0.002]	8.8

- 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 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.

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

LOC	DIST	REV	DATE	BY	APPD
A	66	-	-	-	-

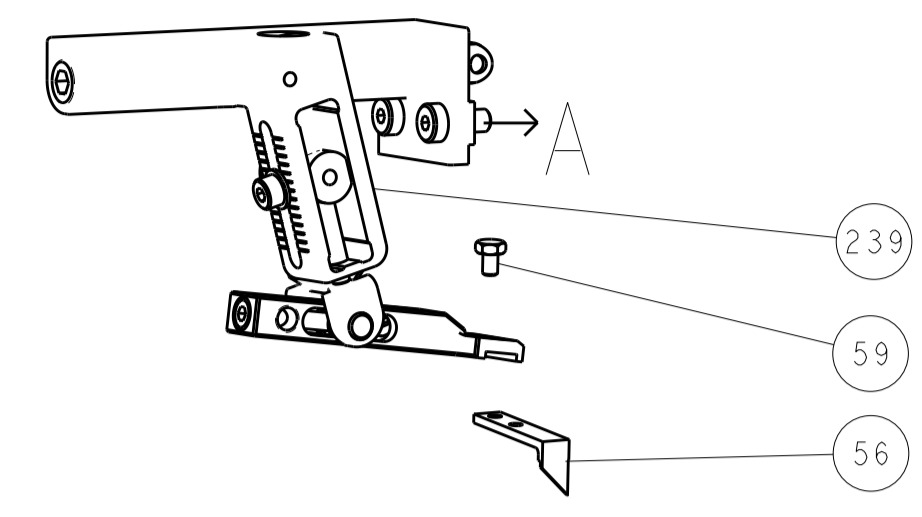
REV	DATE	BY	APPD	DESCRIPTION	ITEM NO
-	1	-	-	2119640-1 PUSH ROD, AIR FEED	250
-	1	-	-	1803259-1 BUSHING, FLANGED	249
-	1	1	-	2119082-4 CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	-	2079764-1 WASHER, WAVE SPRING, CREST-TO-CREST	243
3	-	1	1	2119083-1 RETAINER, INSULATION DIAL	242
-	1	1	-	7-18023-7 SCR, 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
5	-	1	-	2119799-1 HOLDER, FEED FINGER, AF	136
-	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	-	455888-7 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	-	1803382-6 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	-	1752356-3 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	-	2844992-2 ASSEMBLY, STRIP GUIDE	29
-	1	1	-	455888-5 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	-	1-356885-5 STOP, SHEAR	11
1	-	1	-	2119805-1 SHEAR HOLDER, FRONT	10
1	-	1	-	1803095-1 FLOATING SHEAR, FRONT	9
1	1	1	-	1803591-1 ANVIL, WIRE - F	8
-	-	-	-	-	7
-	-	-	-	-	6
-	1	1	-	2119757-2 DEPRESSOR, SHEAR	5
-	1	1	-	1-238011-0 BLOCK, CRIMPER SPACER	4
1	1	1	-	2119784-3 CRIMPER, INSULATION O PREMIUM	3
-	1	1	-	455888-3 SPACER, CRIMPER	2
1	1	1	-	7-456403-0 CRIMPER, WIRE PREMIUM	1

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		MATERIAL:		FINISH:	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES ±	FINISH ±

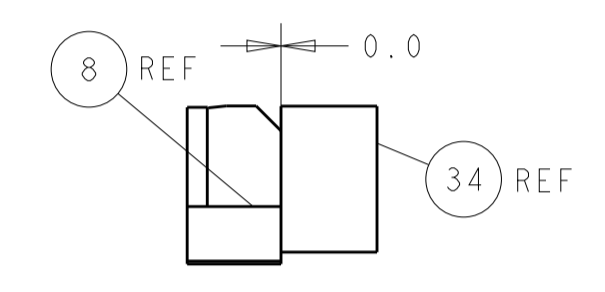
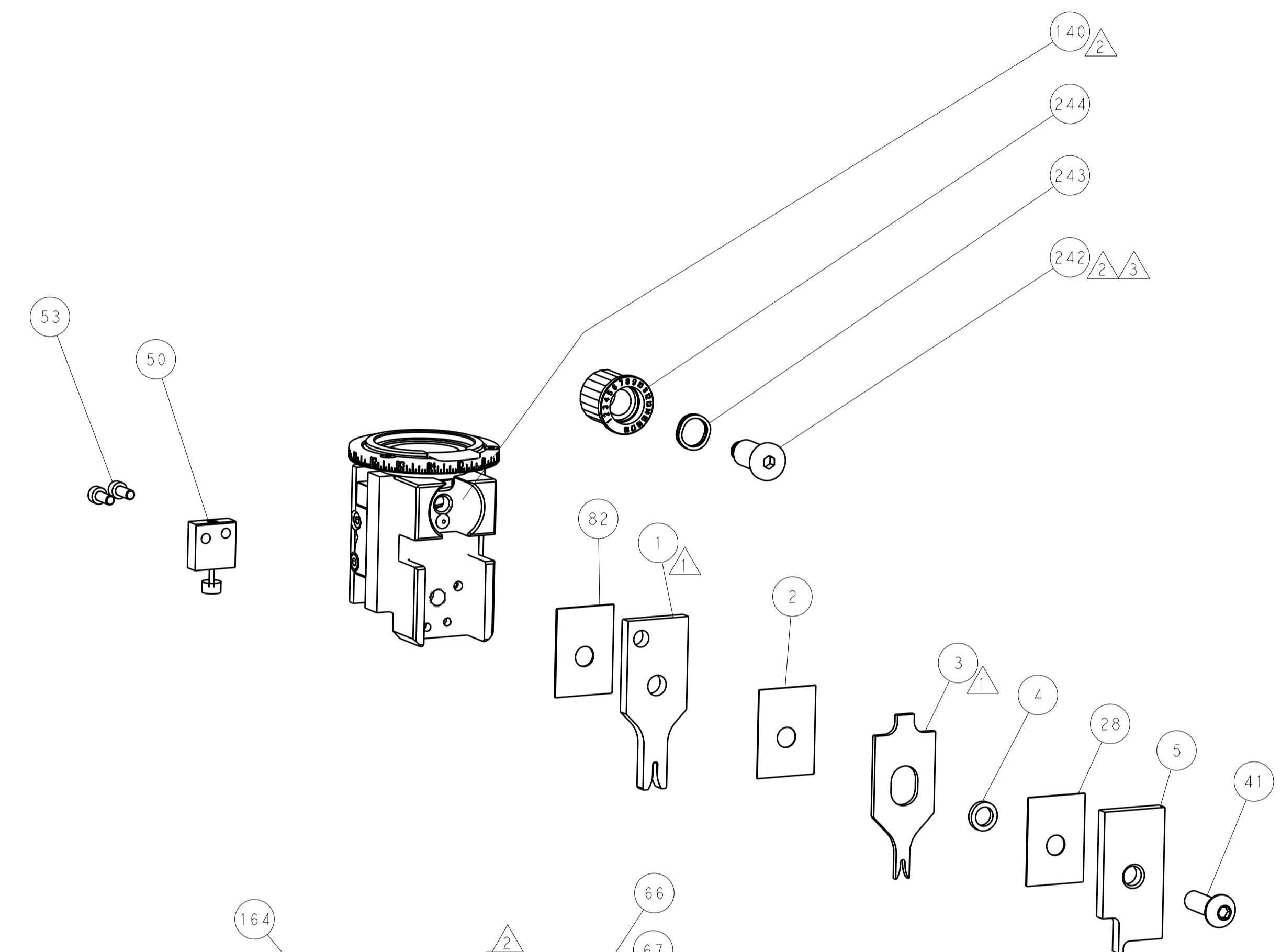
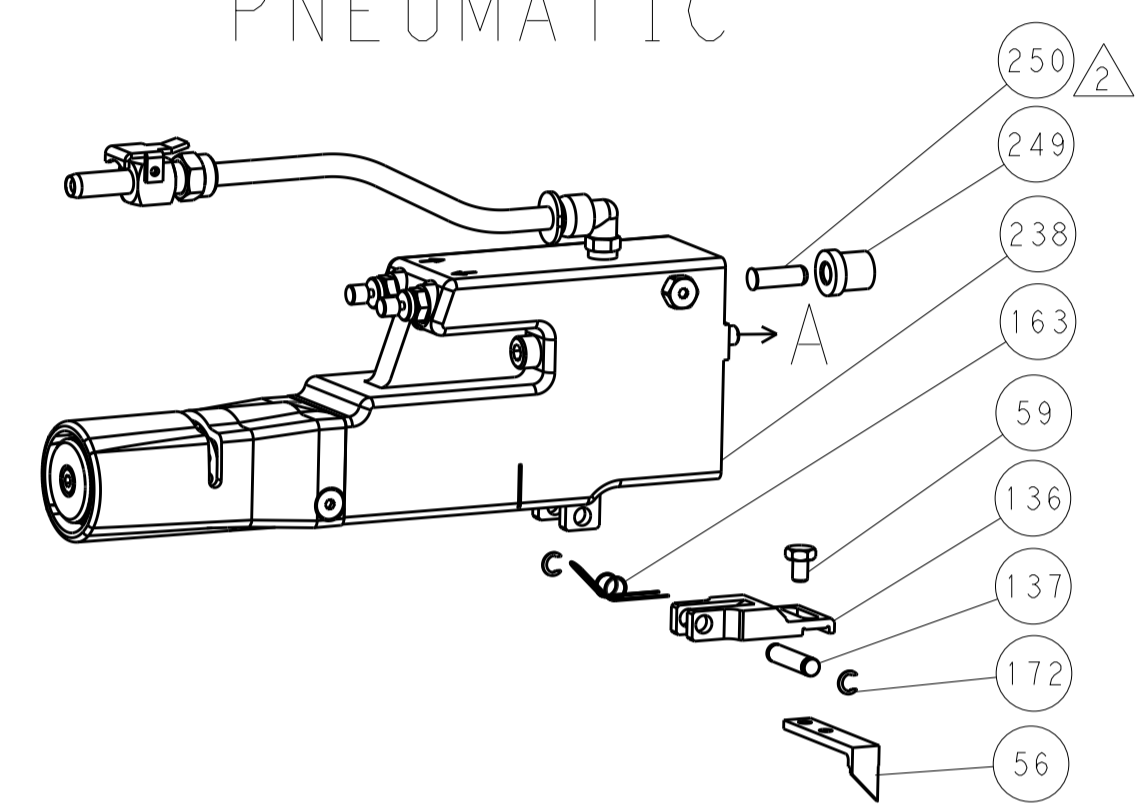
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CHK	M. HERR	OSSEP2017
APPD	T. ELBIN	OSSEP2017
PRODUCT SPEC		
APPLICATION SPEC		
SIZE	CAGE CODE	DRAWING NO
A1	00779	2836915
Customer Accessible Production Drawing		
SCALE	1:2	SHEET 3 OF 4
REV	D	

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

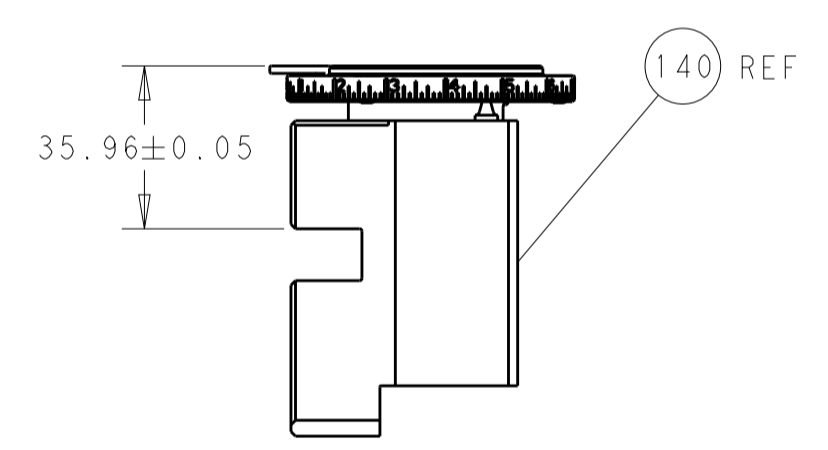
FEED TYPE MECHANICAL



PNEUMATIC

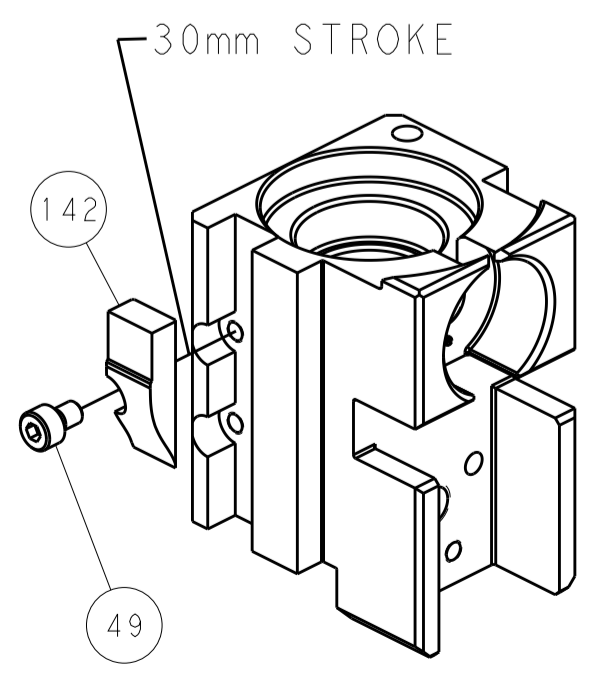


TERMINAL SUPPORT LOCATION

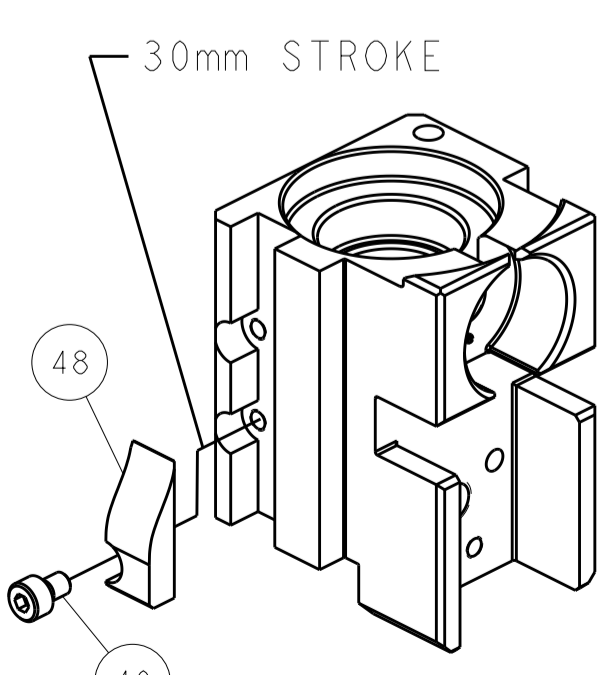


RAM SET-UP

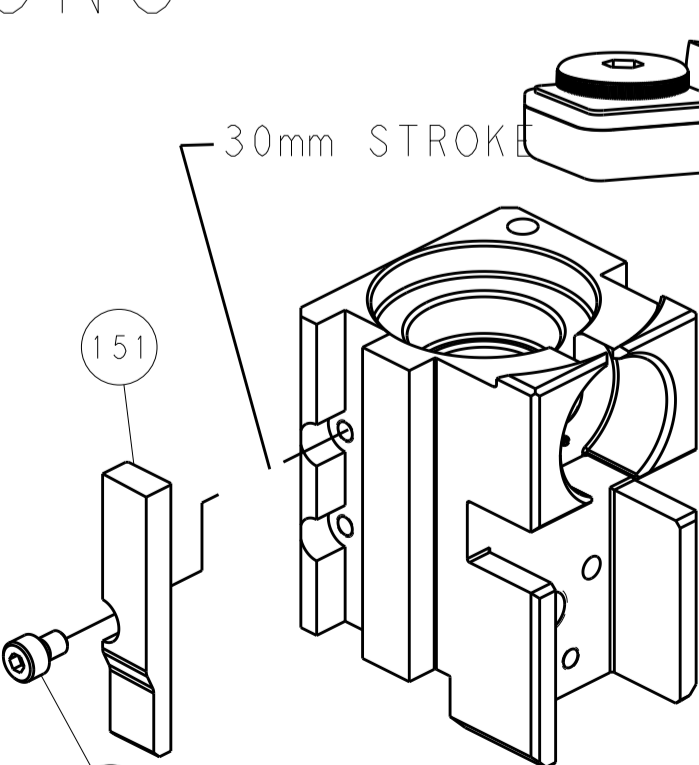
CAM POSITIONS



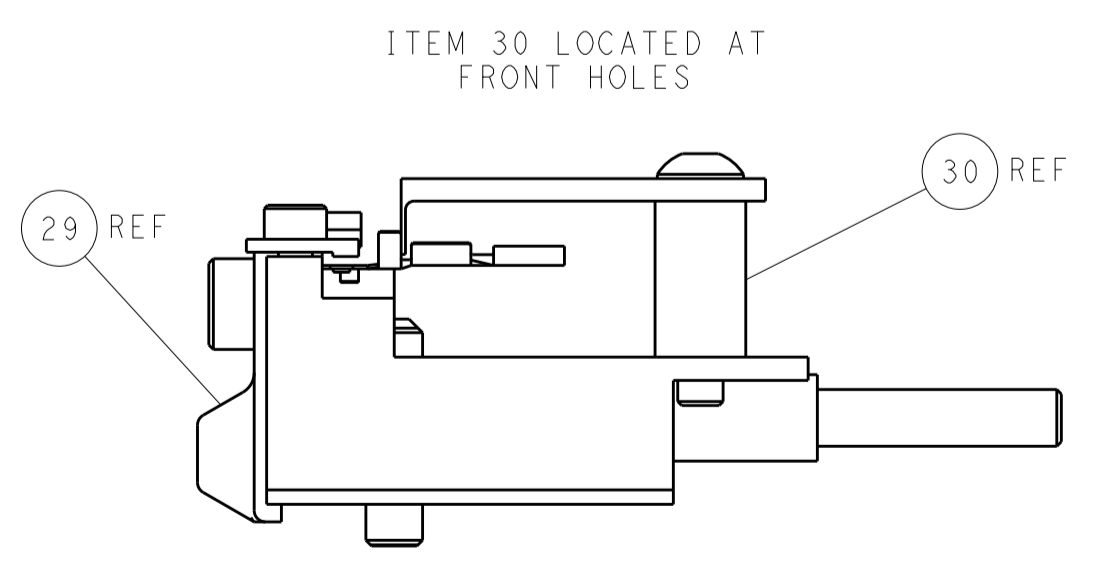
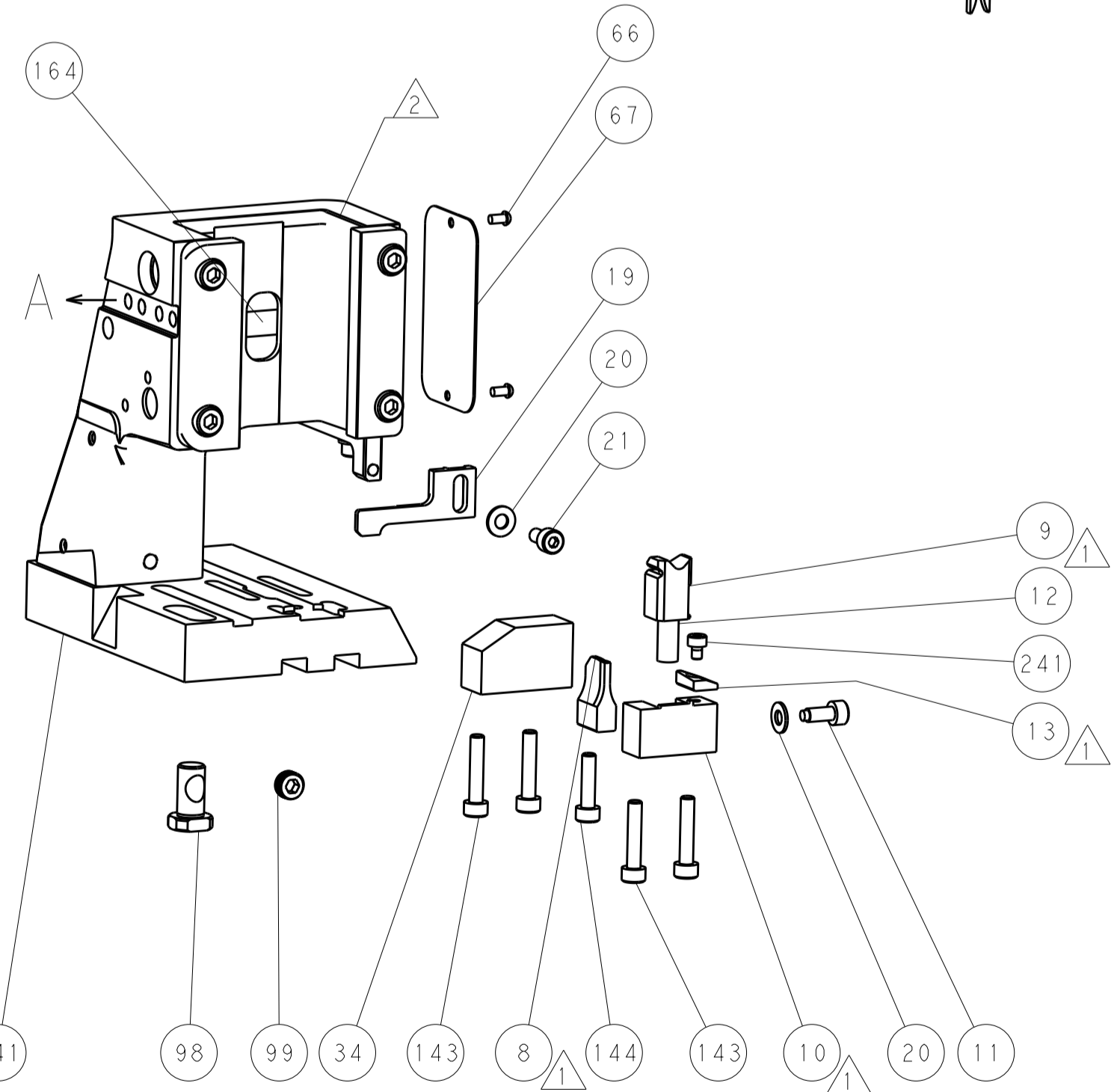
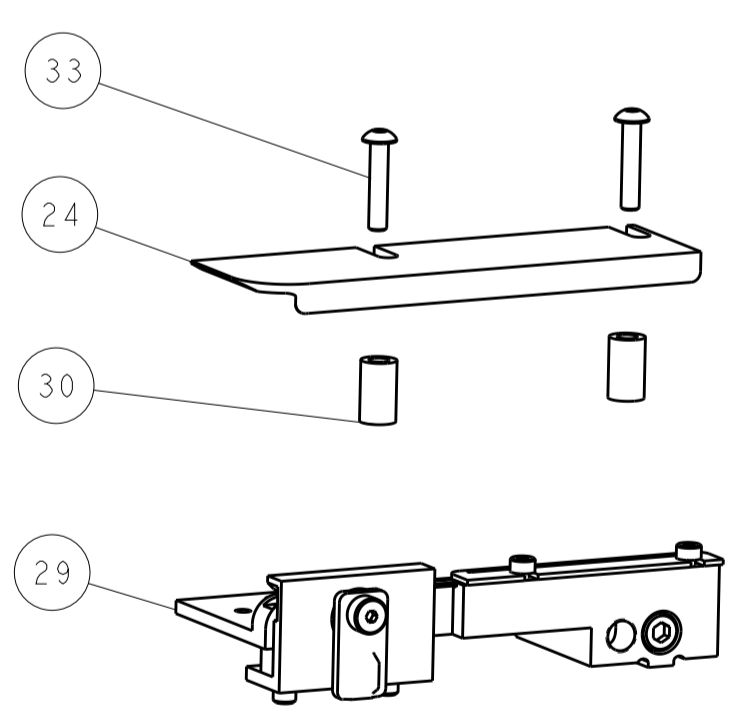
MECHANICAL POST FEED



MECHANICAL PRE FEED



AIR FEED



FEED TRACK POSITION GUIDE BY INSULATION BARREL

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 T. BROOKS 05SEP2017		TE Connectivity	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	5 PLC ±	Harrisburg, PA 17105-3608
MATERIAL:		FINISH:		CHK M. HERR 05SEP2017		NAME	
				T. ELBIN 05SEP2017		Ocean Side Feed Applicator	
				APVD		SIZE CAGE CODE DRAWING NO	
				PRODUCT SPEC		RESTRICTED TO	
				APPLICATION SPEC		A 00779 C=2836915	
				WEIGHT		SCALE 1:2 SHEET 4 OF 4 REV D	
				Customer Accessible Production Drawing			