

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2836807-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2836807-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2836807-1	C	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2836807-2	C	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2836807-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.40 mm [0.055]	F
INSUL	-	-

APPLICATOR INSTRUCTIONS
408-35042

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: AMPLIVAR SPLICE MINIATURE			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
5.56-7.14 mm [0.219-.281 IN]		∅	
TERMINAL APPLICATION SPECIFICATION		114-2016	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
63431-2			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
633-850 CMA	0.80 +/- 0.05 [0.031 +/- 0.002]	7.0
417-632 CMA	0.74 +/- 0.05 [0.029 +/- 0.002]	7.6
200-416 CMA	0.68 +/- 0.05 [0.027 +/- 0.002]	8.0

- 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.
- SEE CUSTOMER DRAWING 63431 FOR CRIMP HEIGHT FORMULA.
- TERMINAL LUBRICANT IS RECOMMENDED.
- 7. 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	DWN	APVD
		A		RELEASED	21AUG2017	KH	TE
		B		ECR-19-004447	20MAR2019	MZ	YY
		C		ECR-21-118981	28OCT2021	JWC	RK

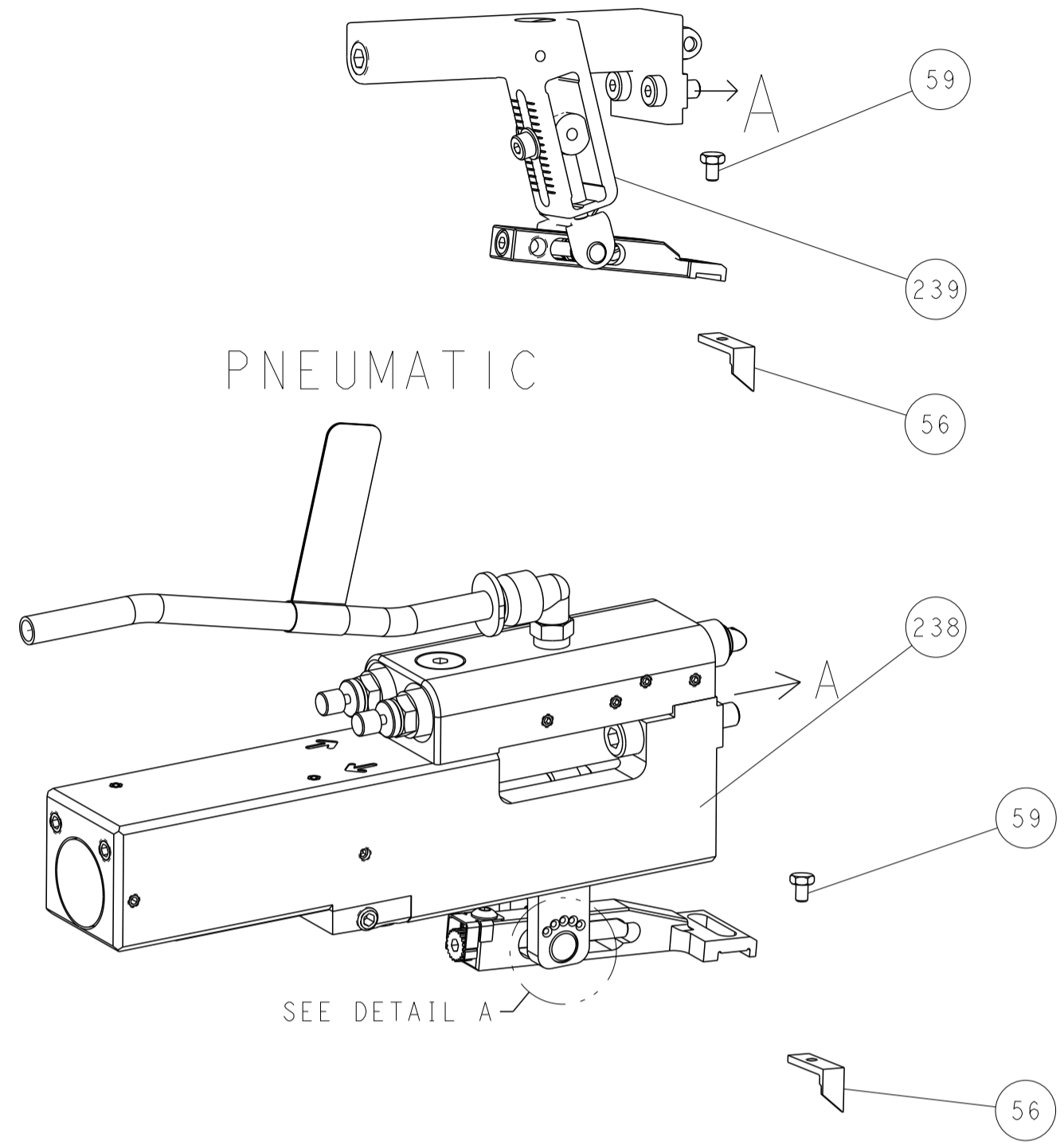
-	1	1	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	283
-	1	1	1	1	2280441-1	INSERT, SHEAR	282
-	1	1	1	1	1803078-2	SPACER, PRECISION	259
-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248
-	-	1	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	1	-	1	-	2844940-1	AIR FEED MODULE	238
-	1	1	1	1	1-356885-4	STOP, SHEAR	237
-	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	1	1	1	1	1-22281-8	SPRING, COMPRESSION	121
-	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	1-690438-0	FRONT STRIP GUIDE	96
-	2	2	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	95
-	1	1	1	1	2168083-6	SCR, SKT HD CAP, RoHS, M5 X 65	93
-	1	1	1	1	455888-7	SPACER, CRIMPER	82
-	1	1	1	1	1803607-3	DOCUMENTATION PACKAGE	71
-	1	1	1	1	2-2119791-2	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	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	65
-	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	1338683-9	FEED PAWL	56
-	2	2	2	2	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	54
-	2	2	2	2	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	53
-	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	1803515-2	RAM ASSEMBLY, SF ATLANTIC	44
-	1	1	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
-	1	1	1	1	1-2305692-2	PLATE, REAR STRIP GUIDE	29
-	2	2	2	2	22283-1	SPRING, COMPRESSION	27
-	1	1	1	1	356835-1	LEVER, DRAG RELEASE	26
-	1	1	1	1	240792-1	DRAG, TERMINAL	25
-	1	1	1	1	4-690487-2	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
-	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	2-690463-8	FLOATING SHEAR, REAR	17
-	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	1803571-1	ANVIL, COMBINATION, REAR CARRIER	8
-	-	-	-	-	-	-	7
-	1	1	1	1	3-690468-5	DEPRESSOR SHEAR, REAR	6
-	1	1	1	1	1803203-1	BLOCK, FRONT DEPRESSOR	5
-	-	-	-	-	-	-	4
-	-	-	-	-	-	-	3
-	-	-	-	-	-	-	2
-	1	2	2	1	1803232-3	CRIMPER, WIRE F	1
-	77	72	71	2	-1	PART NO	ITEM NO

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

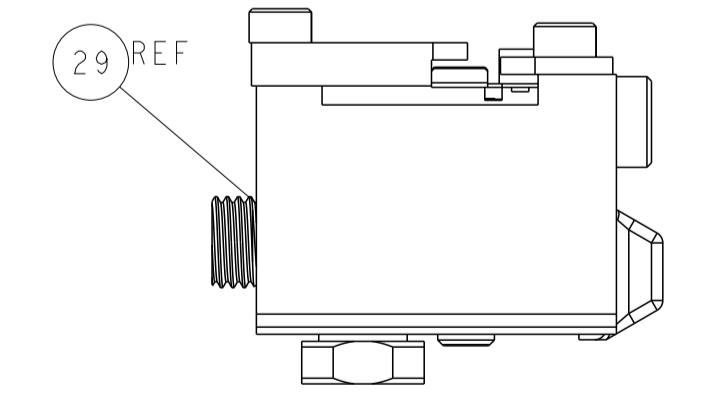
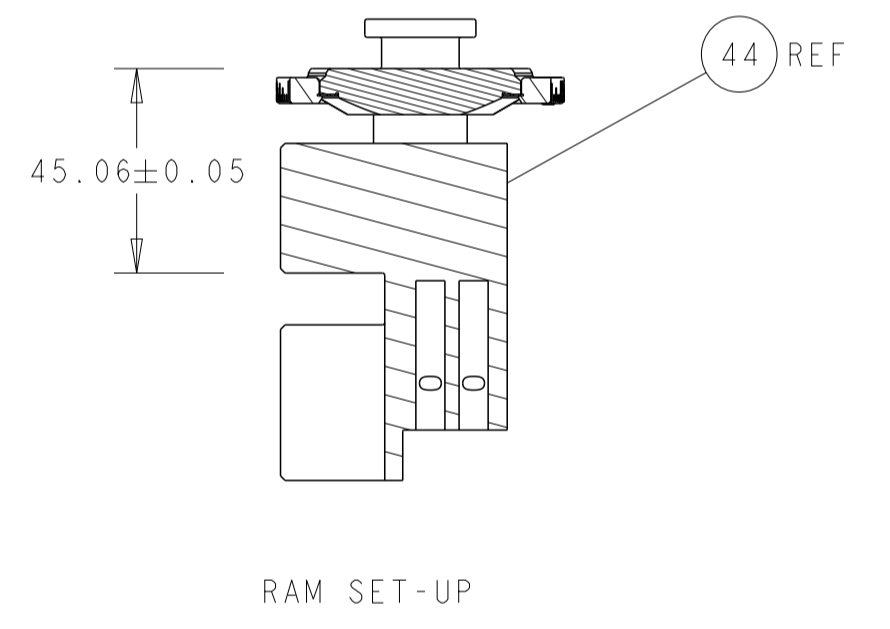
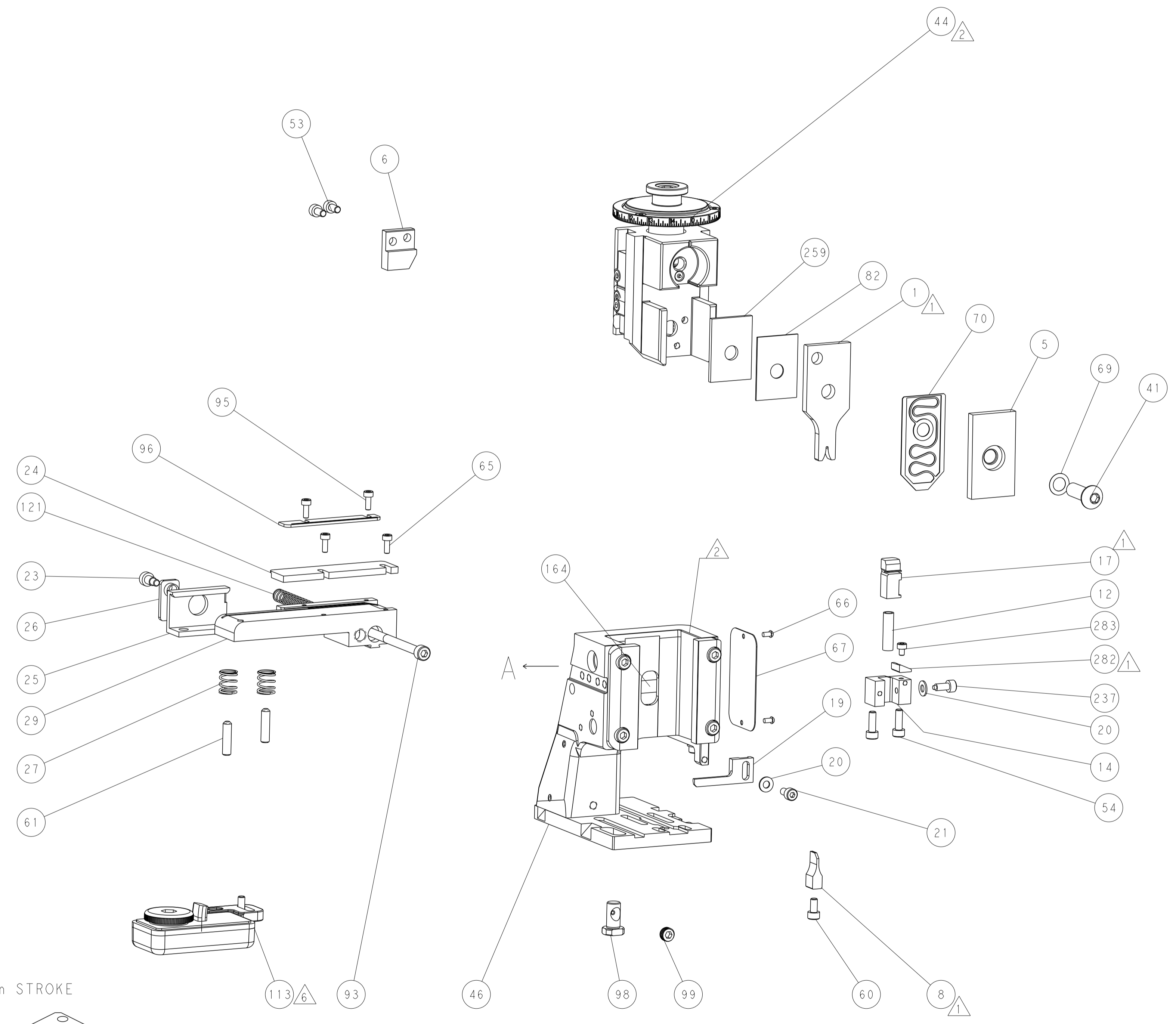
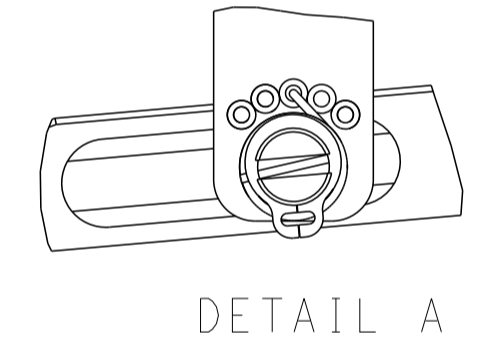
DWN	H. HUANG	27MAY2017	TE Connectivity Harrisburg, PA 17105-3608
CHK	L. ZHANG	27MAY2017	
APVD	L. ZHANG	27MAY2017	NAME
PRODUCT SPEC			Ocean Side Feed Applicator
APPLICATION SPEC			
SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
A1	00779	2836807	
Customer Accessible Production Drawing			SCALE 1:2 SHEET 1 OF 4 REV C

LOC	DIST	REVISIONS			
P	LTN	DESCRIPTION	DATE	DWN	APVD
-	-	SEE SHEET 1	-	-	-

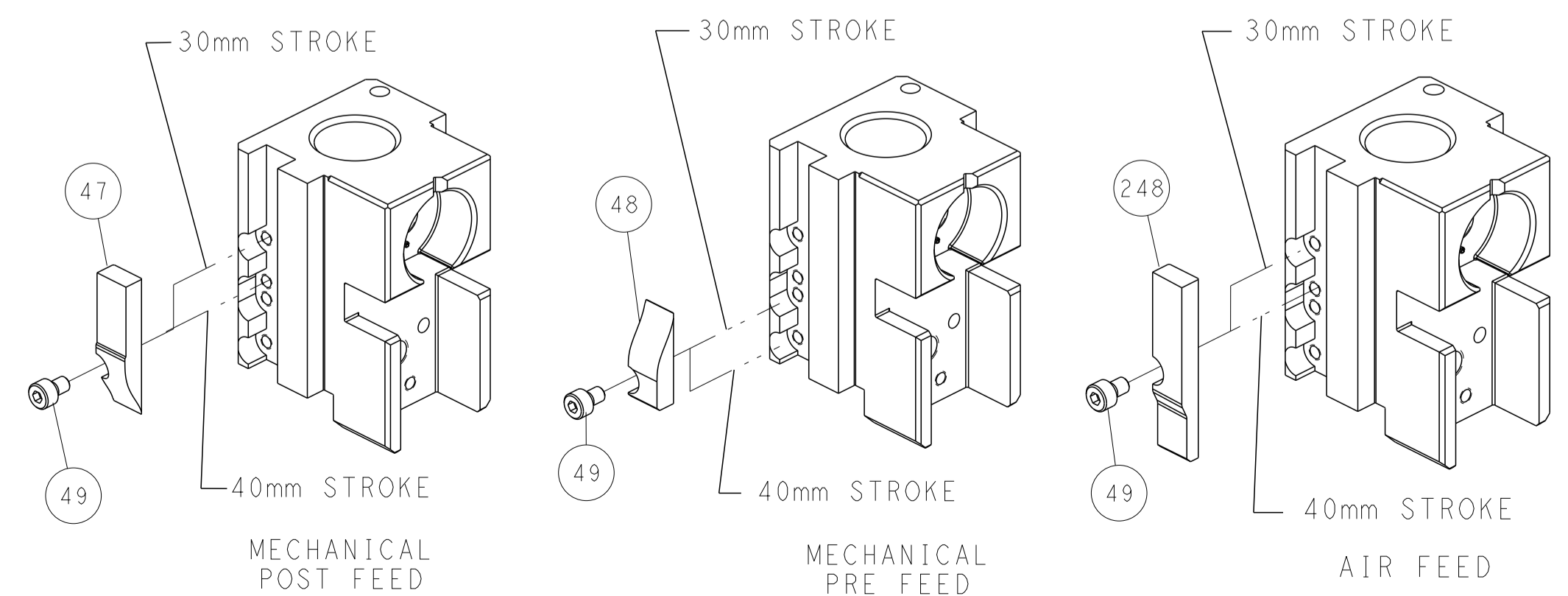
FEED TYPE MECHANICAL



FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



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 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.</small>		DWN: K. HUANG 27MAY2017 CHK: L. ZHANG 27MAY2017 APVD: L. ZHANG 27MAY2017	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: C-2836807	RESTRICTED TO: - SCALE: 1:2 SHEET: 2 OF 4 REV: C
MATERIAL: - FINISH: -		WEIGHT: - Customer Accessible Production Drawing	SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

THIS DRAWING IS UNPUBLISHED.	RELEASED FOR PUBLICATION		
COPYRIGHT 20 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.			
PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2836807-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2836807-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2836807-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.40 mm [.055]	F
INSUL	-	-
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: AMPLIVAR SPLICE MINIATURE			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
5.56-7.14 mm [.219-.281 IN]		Ø	
TERMINAL APPLICATION SPECIFICATION		114-2016	
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
63431-2			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
633-850 CMA	0.80 +/- 0.05 [.031 +/- .002]	7.0
417-632 CMA	0.74 +/- 0.05 [.029 +/- .002]	7.6
200-416 CMA	0.68 +/- 0.05 [.027 +/- .002]	8.0

- 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 SEE CUSTOMER DRAWING 63431 FOR CRIMP HEIGHT FORMULA.
- 6 TERMINAL LUBRICANT IS RECOMMENDED.
- 7. 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	REV	DATE	BY	APPV
A	66				

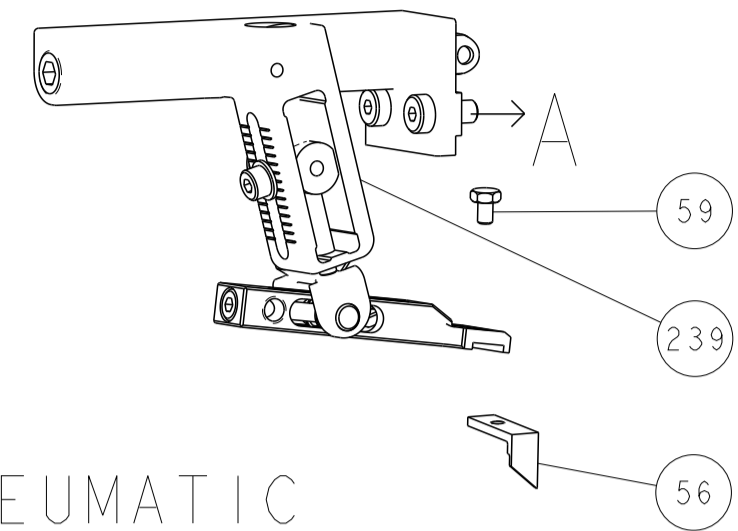
REV	DATE	BY	APPV	DESCRIPTION	ITEM NO
-	1	1		7-18023-7 SCR, SKT HD CAP M3 X 4.0	283
-	1	1		2280441-1 INSERT, SHEAR	282
-	1	1		1803078-2 SPACER, PRECISION	259
-	-	1		2119580-1 MECHANICAL FEED ASSEMBLY	239
-	1	-		2844940-1 AIR FEED MODULE	238
-	1	1		1-356885-4 STOP, SHEAR	237
-	REF	REF		994970-2 COUNTER, MAGNETIC	164
-	1	-		2119641-2 FEED CAM, AIR FEED	151
-	1	1		2168083-8 SCR, SKT HD CAP, RoHS, M4 X 16	144
-	2	2		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		1803516-2 RAM ASSEMBLY, SF PACIFIC	140
-	1	1		1-22281-8 SPRING, COMPRESSION	121
6	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		1-690438-0 FRONT STRIP GUIDE	96
-	2	2		2168083-1 SCR, SKT HD CAP, RoHS, M3 X 8.0	95
-	1	1		2168083-6 SCR, SKT HD CAP, RoHS, M5 X 65	93
-	1	1		455888-7 SPACER, CRIMPER	82
-	1	1		1803607-3 DOCUMENTATION PACKAGE	71
-	1	1		2-2119791-2 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		2168083-1 SCR, SKT HD CAP, RoHS, M3 X 8.0	65
-	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		1338683-9 FEED PAWL	56
-	2	2		2168083-2 SCR, SKT HD CAP, RoHS, M4 X 8.0	53
-	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		1-2305692-2 PLATE, REAR STRIP GUIDE	29
-	2	2		22283-1 SPRING, COMPRESSION	27
-	1	1		356835-1 LEVER, DRAG RELEASE	26
-	1	1		240792-1 DRAG, TERMINAL	25
-	1	1		4-690487-2 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
-	2	2		1-18028-2 WASHER, FLAT, REG M4	20
-	1	1		2119533-1 STRIPPER, SIDE FEED	19
-	1	1		2-690463-8 FLOATING SHEAR, REAR	17
-	1	1		2119862-1 SHEAR HOLDER, REAR	14
-	1	1		3-22280-3 SPRING, COMPRESSION	12
-	-	-		-	10
-	-	-		-	9
1	1	1		1803571-1 ANVIL, COMBINATION, REAR CARRIER	8
-	-	-		-	7
-	1	1		3-690468-5 DEPRESSOR SHEAR, REAR	6
-	1	1		1803203-1 BLOCK, FRONT DEPRESSOR	5
-	-	-		-	4
-	-	-		-	3
-	-	-		-	2
1	1	1		1803232-3 CRIMPER, WIRE F	1
-77	-22	-21		PART NO	DESCRIPTION

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

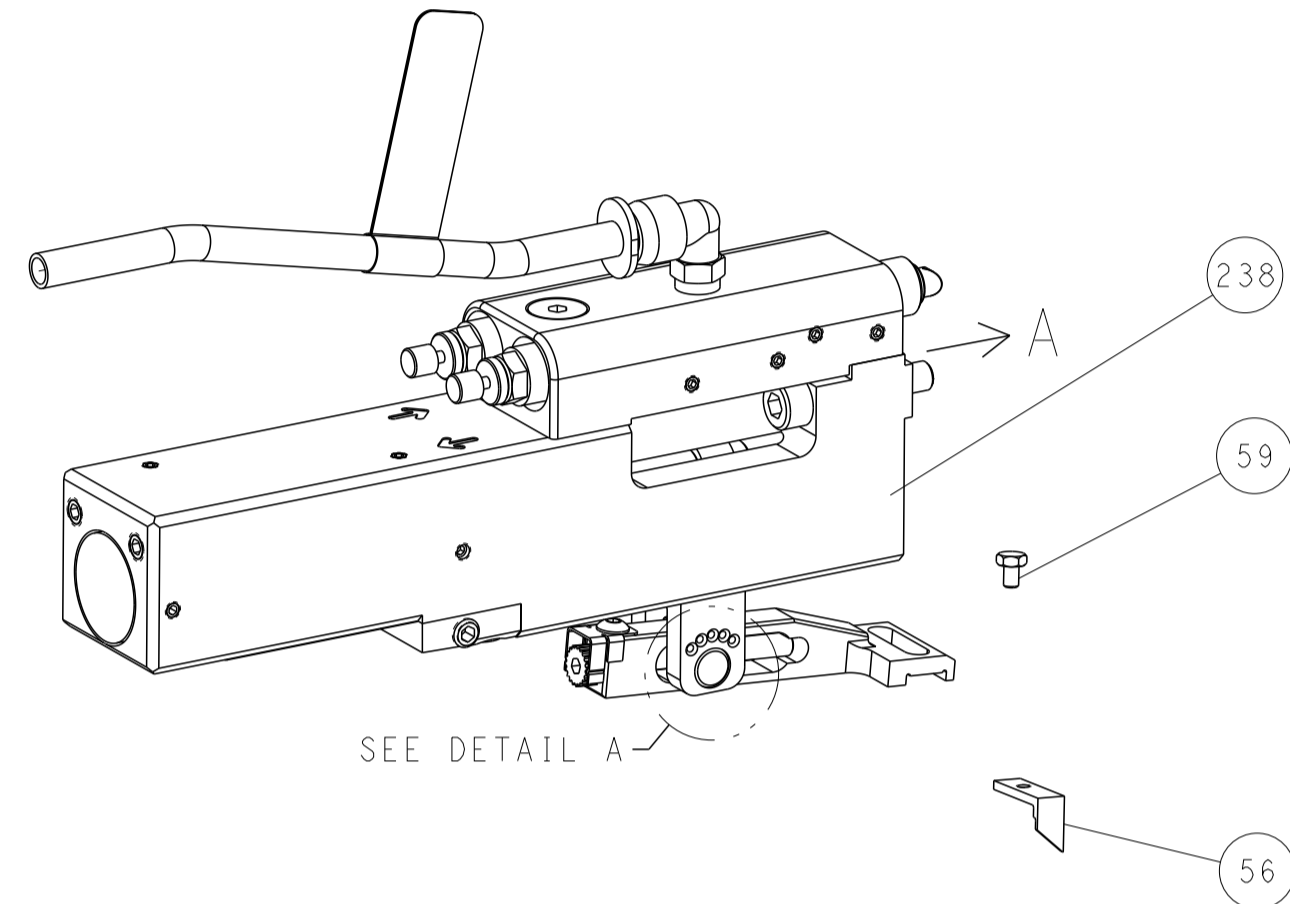
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DRAWN: H. HUANG 27MAY2017		CHK: L. ZHANG 27MAY2017		APVD: L. ZHANG 27MAY2017		NAME: Ocean Side Feed Applicator	
0 PLC ±		1 PLC ±		2 PLC ±		3 PLC ±		4 PLC ±		RESTRICTED TO	
MATERIAL: -		FINISH: -		WEIGHT: -		SCALE: 1:2		SHEET 3 OF 4		REV C	

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

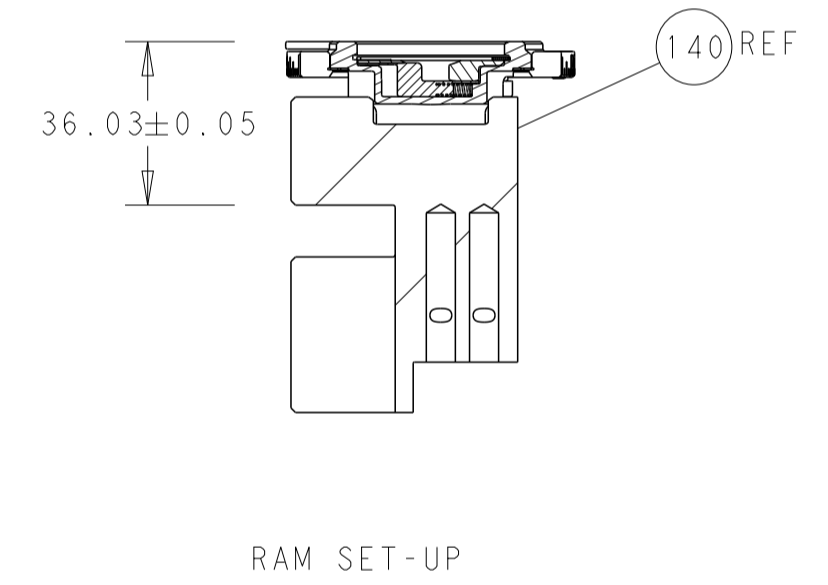
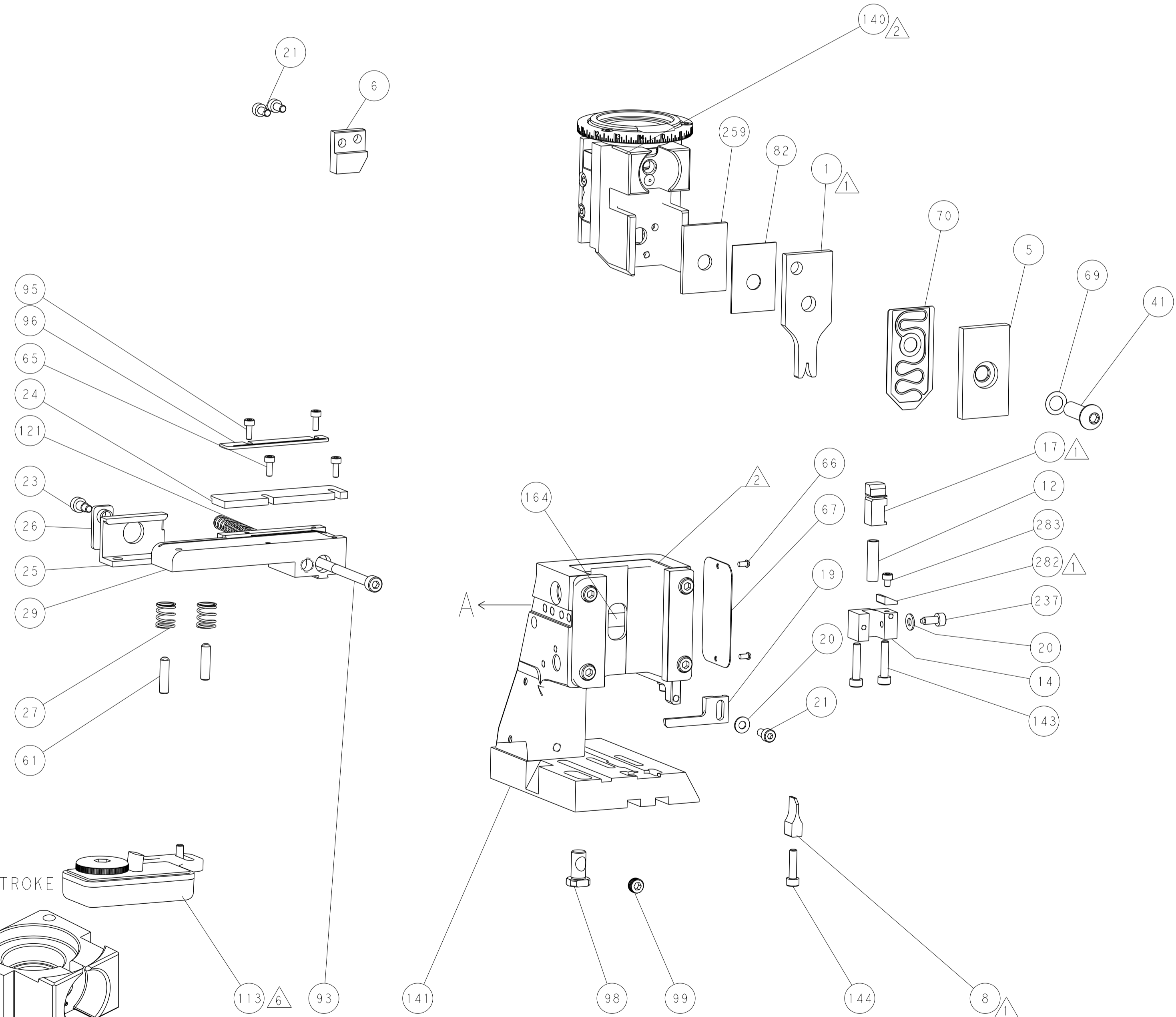
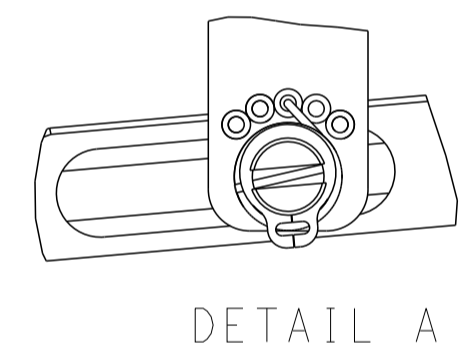
FEED TYPE MECHANICAL



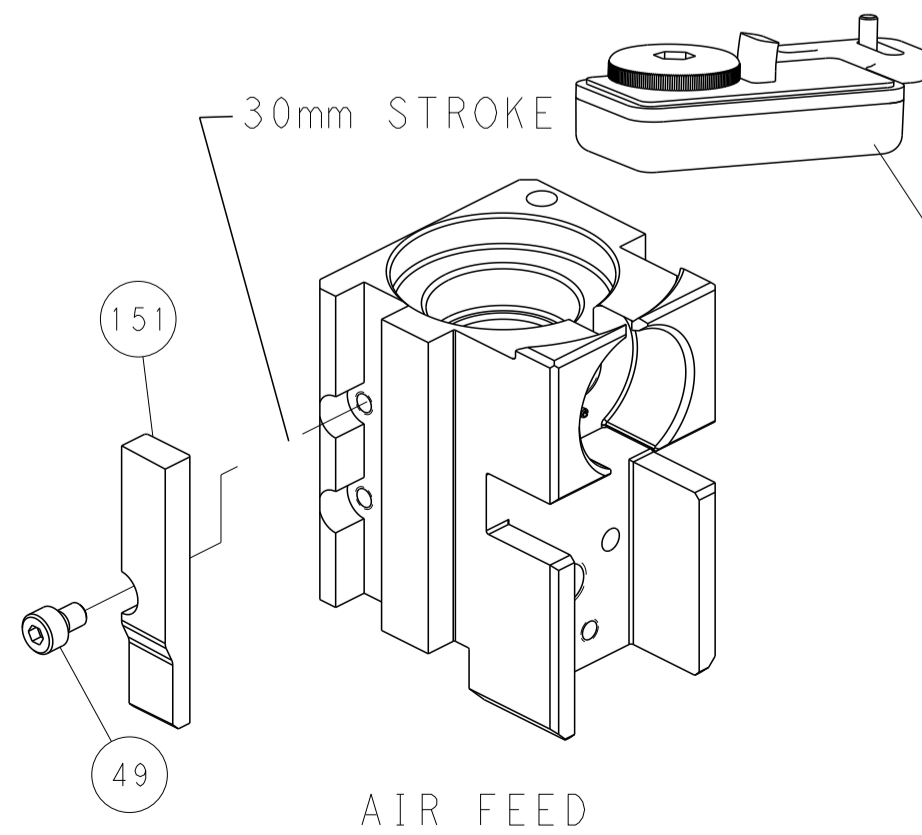
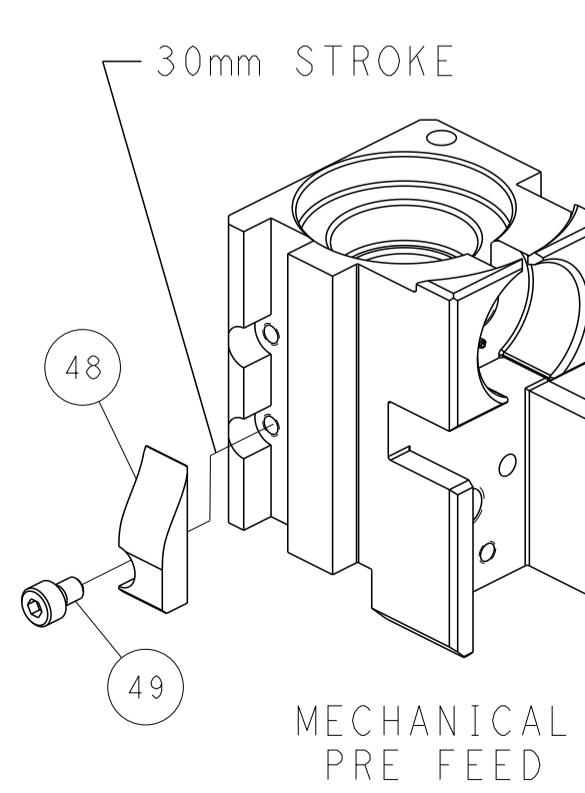
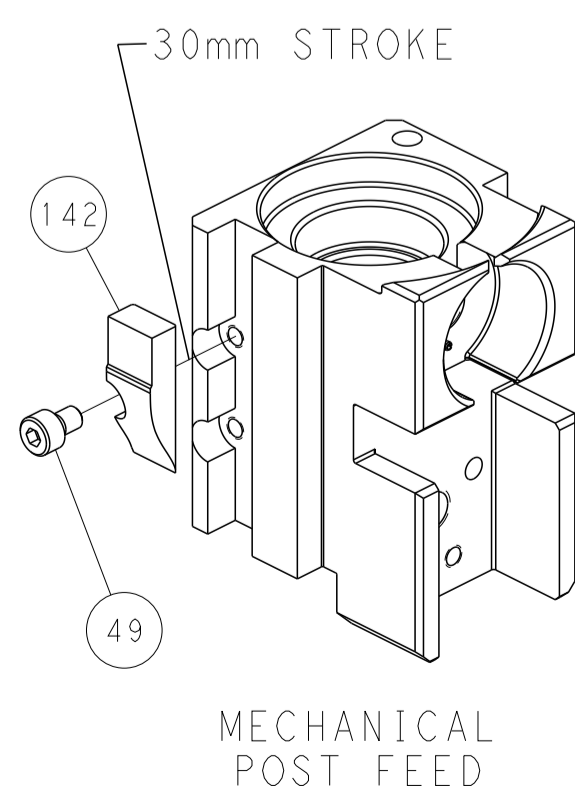
PNEUMATIC



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)

<small>THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION. ALL RIGHTS RESERVED. THIS DRAWING IS THE PROPERTY OF TYCO ELECTRONICS CORPORATION. IT IS TO BE USED ONLY FOR THE PURPOSES SPECIFIED AND IS NOT TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, INCLUDING PHOTOCOPYING, RECORDING, OR BY ANY INFORMATION STORAGE AND RETRIEVAL SYSTEM, WITHOUT THE WRITTEN PERMISSION OF TYCO ELECTRONICS CORPORATION.</small>		DWN: H. HUANG 27MAY2017 CHK: L. ZHANG 27MAY2017 APVD: L. ZHANG 27MAY2017	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: 2836807	RESTRICTED TO: - SCALE: 1:2 SHEET: 4 OF 4 REV: C
MATERIAL: - FINISH: -		WEIGHT: - Customer Accessible Production Drawing	SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION