

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2836028-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2836028-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2836028-1	B	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2836028-2	B	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2836028-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.75 mm [.069]	F
INSUL	3.40 mm [.134]	O

APPLICATOR INSTRUCTIONS
408-35042

TERMINAL DATA: KET TERMINAL		KET CRIMP SPECIFICATION	
TERMINAL NAME: KET TERMINAL			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
4.50-5.00 mm [1.77-.197 IN]		∅	
TERMINAL APPLICATION SPECIFICATION: SWP MALE TERMINAL Rev 2010.06.30			

TERMINALS APPLIED				
TE TERMINAL	KET TERMINAL	TE SEAL	KET SEAL	CABLE DIAMETER
2113754-1	ST740482-3	1-1949770-0	MG680449	∅1.70-1.90
2113754-2	ST740482-G	1-1949770-1	MG680448	∅1.40-1.70
		TE SEAL	YAZAKI SEAL	
		1-1949770-2	7157-7897-60	∅1.70-1.90

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
AVSS 0.85mm ²	1.25 +/- 0.05 [1.049 +/- .002]	5.6
FLRY-B 0.75mm ²	1.20 +/- 0.05 [1.047 +/- .002]	6.1
AVSS 0.5mm ²	1.15 +/- 0.05 [1.045 +/- .002]	6.8
LEONI 0.35mm ²	1.05 +/- 0.05 [1.041 +/- .002]	7.5
AVSS 0.3mm ²	1.05 +/- 0.05 [1.041 +/- .002]	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 APPLY TORQ-SEAL IN ALLEN SOCKET TO FILL HOLE AFTER FLAT HD HAS BEEN ADJUSTED TO CORRECT HEIGHT AT QUALIFICATION. APPLY #1-23419-5 LOC-TITE TO THREADS.
- 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.

LOC	DIST	REVISIONS					
		P	LTN	DESCRIPTION	DATE	OWN	APVD
A	66	1		DEVELOPMENT	7SEP2015	JH	TE
		A		RELEASED	10OCT2015	JH	TE
		B		ECR-21-114518	21SEP2021	TB	RK
		B1		ECR-21-114518	23NOV2021	JWC	RK

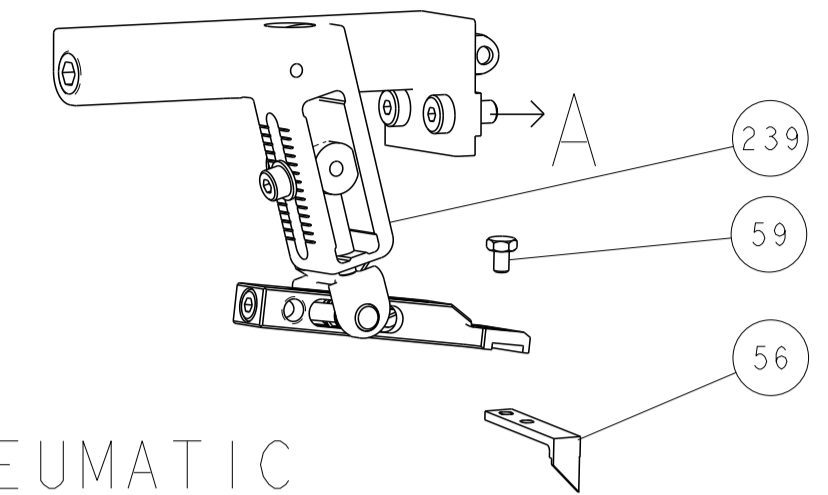
-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248	
-	1	1	1	1	2119082-2	CAM, SNAIL, INSULATION ADJUSTMENT	244	
-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243	
3	-	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242	
-	1	1	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241	
-	-	1	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239	
-	1	-	1	-	2844940-1	AIR FEED MODULE	238	
-	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164	
-	1	1	1	1	2844908-1	SCREW, LOCKING	99	
-	1	1	1	1	2844907-1	POST, LOCKING	98	
-	1	1	1	1	455888-4	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	
5	-	1	1	1	985575-3	SCR, FLT SKT HD CAP M3 X 10.0	57	
-	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	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	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	690753-2	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	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	2844992-1	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	2119533-1	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	1-356885-4	STOP, SHEAR	11	
1	-	1	1	1	2119805-1	SHEAR HOLDER, FRONT	10	
1	-	1	1	1	318707-1	FLOATING SHEAR, FRONT	9	
1	1	2	2	1	1	4-1803055-3	ANVIL, COMBINATION	8
-	1	1	1	1	3-240641-1	SPACER	7	
-	-	-	-	-	-	-	6	
-	1	1	1	1	2-2119781-4	DEPRESSOR, SHEAR	5	
-	1	1	1	1	2-238011-1	BLOCK, CRIMPER SPACER	4	
1	1	2	2	1	1	5-1633966-5	CRIMPER, INSULATION O	3
-	1	1	1	1	1-455888-0	SPACER, CRIMPER	2	
1	1	2	2	1	1	1803241-3	CRIMPER, WIRE F	1

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

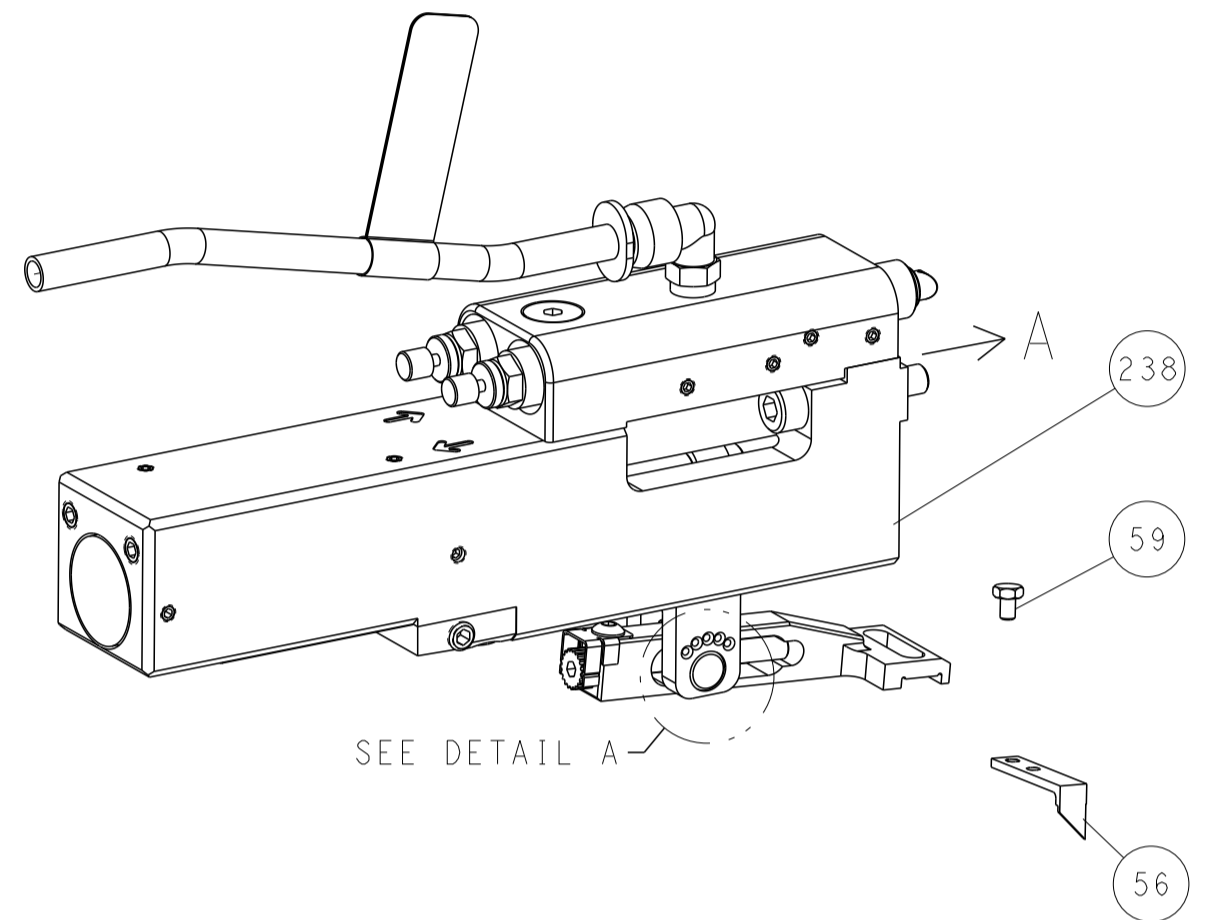
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		OWN	CHK	DATE	TE Connectivity		
mm	0 PLC ±	1 PLC ±	2 PLC ±	J. HOU	L. ZHANG	7SEP2015	Harrisburg, PA 17105-3608		
	3 PLC ±	4 PLC ±	ANGLES ±	APVD	U. GUO	7SEP2015	NAME		
	FINISH						Ocean Side Feed Applicator		
MATERIAL				WEIGHT		SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
						A1	00779	©=2836028	
Customer Accessible Production Drawing							SCALE	SHEET	REV
							1:2	1 OF 4	B1

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

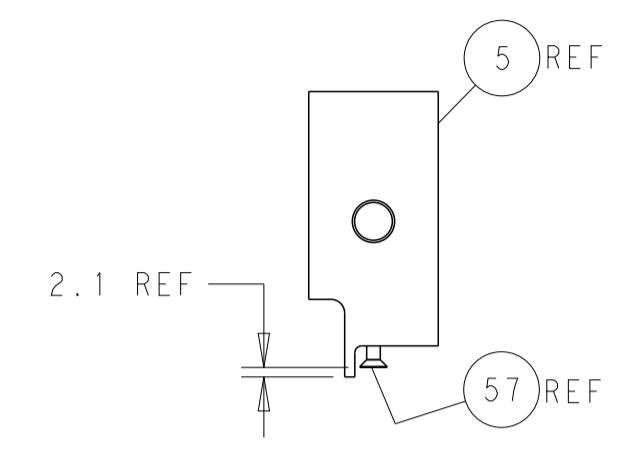
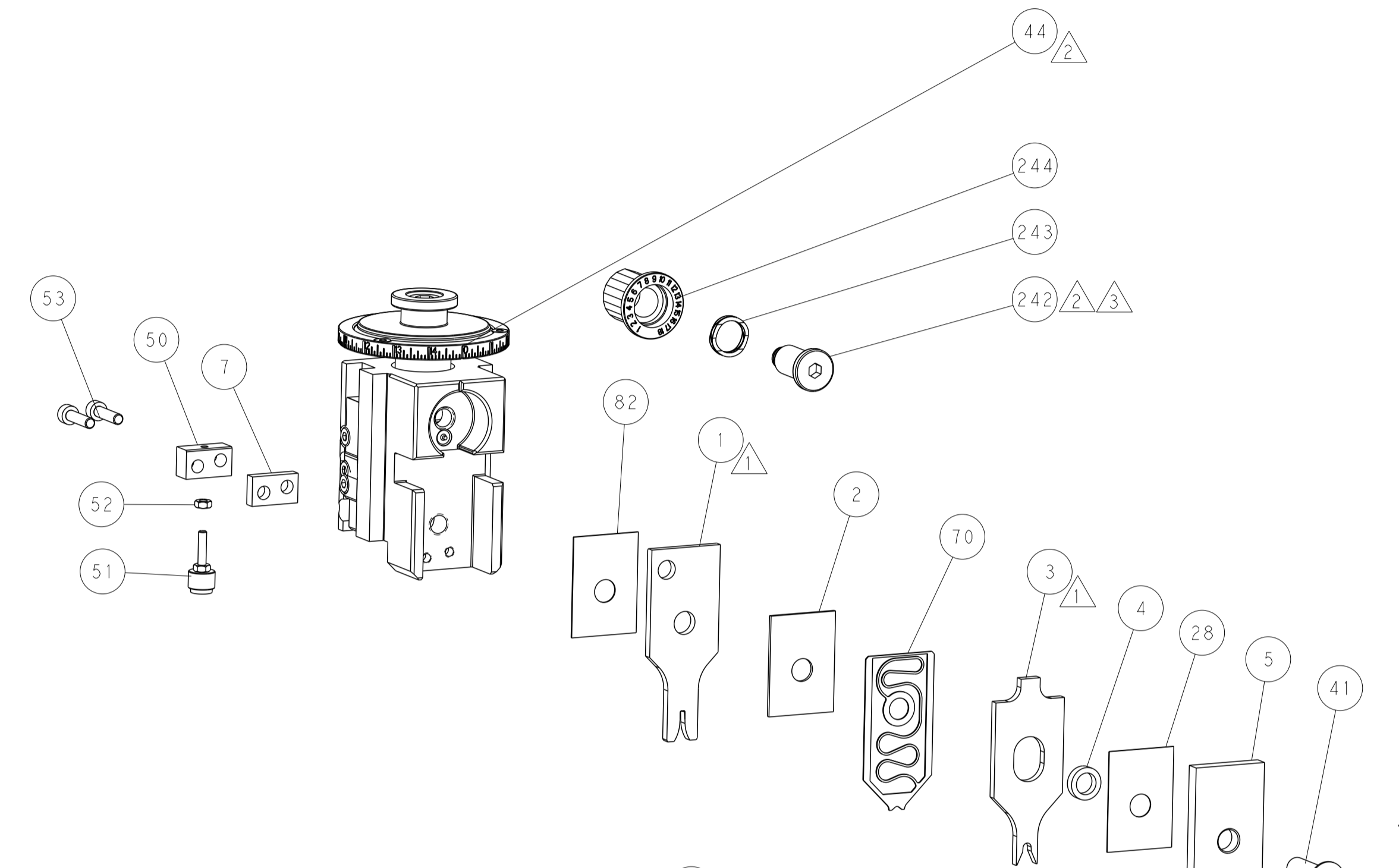
FEED TYPE MECHANICAL



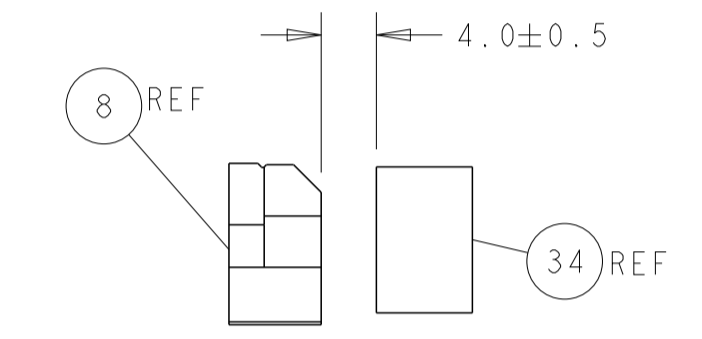
PNEUMATIC



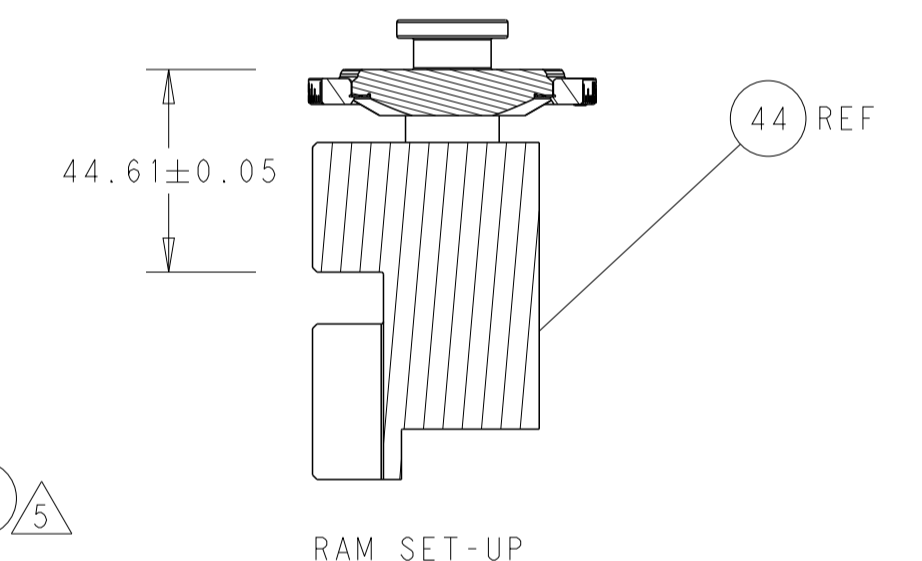
FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



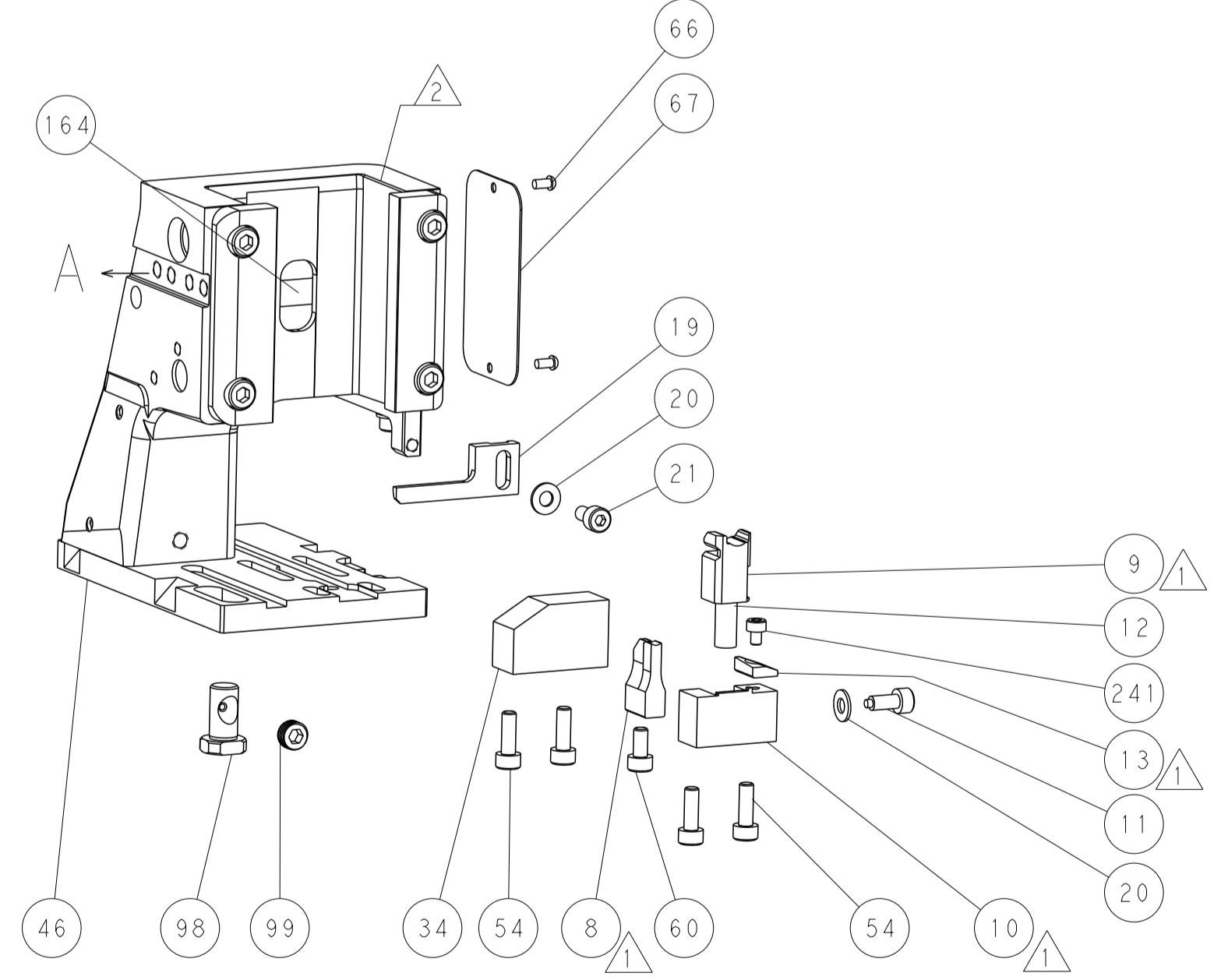
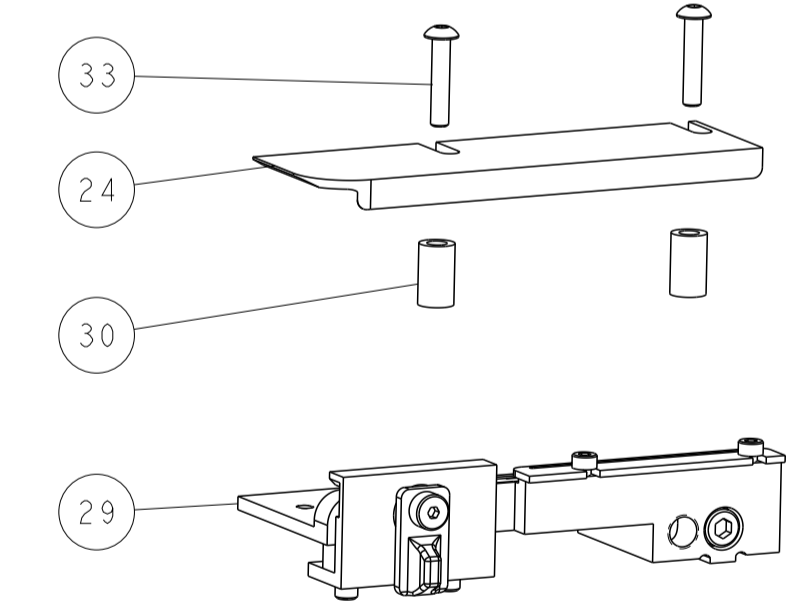
SHEAR DEPRESSOR DETAIL



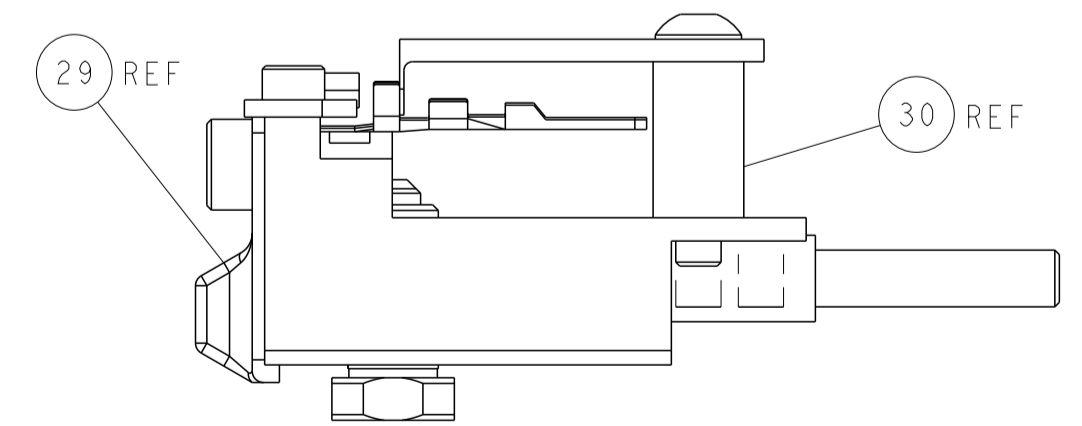
TERMINAL SUPPORT LOCATION



RAM SET-UP

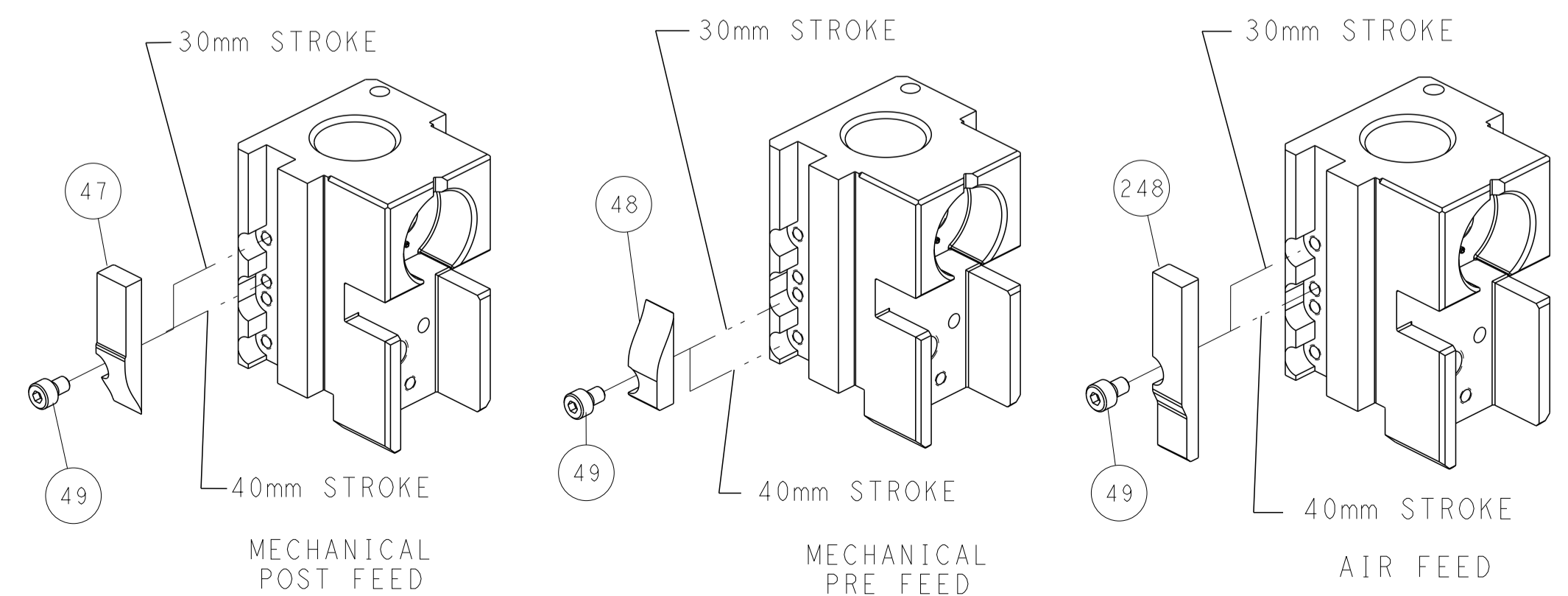


ITEM 30 LOCATED AT FRONT HOLES



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)

<small>THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.</small>		DWN: J. HOU CHK: L. ZHANG APVD: J. GUO	TSEP2015 TSEP2015 TSEP2015	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: 2836028	RESTRICTED TO: - SCALE: 1:2 SHEET: 2 of 4 REV: B1	CUSTOMER ACCESSIBLE PRODUCTION DRAWING

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2836028-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2836028-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2836028-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.75 mm [.069]	F
INSUL	3.40 mm [.134]	O

APPLICATOR INSTRUCTIONS
408-35042

TERMINAL DATA: KET TERMINAL		KET CRIMP SPECIFICATION	
TERMINAL NAME: KET TERMINAL			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
4.50-5.00 mm [1.177-.197 IN]		Ø	
TERMINAL APPLICATION SPECIFICATION	SWP MALE TERMINAL Rev 2010.06.30		
TERMINALS APPLIED			

TE TERMINAL	KET TERMINAL	TE SEAL	KET SEAL	CABLE DIAMETER
2113754-1	ST740482-3	1-1949770-0	MG680449	Ø1.40-1.70
2113754-2	ST740482-6	1-1949770-1	MG680448	Ø1.70-1.90
		TE SEAL	YAZAKI SEAL	
		1-1949770-2	7157-7897-60	Ø1.70-1.90

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
AVSS 0.85mm ²	1.25+/-0.05 [1.049+/-0.002]	5.6
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- 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.
- APPLY TORQ-SEAL IN ALLEN SOCKET TO FILL HOLE AFTER FLAT HD HAS BEEN ADJUSTED TO CORRECT HEIGHT AT QUALIFICATION. APPLY #1-23419-5 LOC-TITE TO THREADS.
- 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.

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

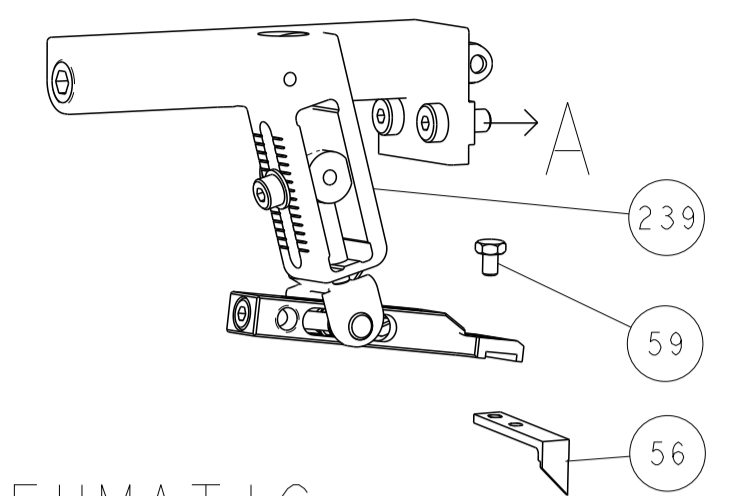
-	1	1	2119082-2	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
-	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	1	-	2844940-1	AIR FEED MODULE	238
-	REF	REF	994970-2	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
-	1	1	2844908-1	SCREW, LOCKING	99
-	1	1	2844907-1	POST, LOCKING	98
-	1	1	455888-4	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
-	1	1	985575-3	SCR, FLT SKT HD CAP M3 X 10.0	57
-	1	1	1338685-1	PAWL, FEED	56
-	2	2	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	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	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	2844992-1	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	2119533-1	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	318707-1	FLOATING SHEAR, FRONT	9
-	1	1	4-1803055-3	ANVIL, COMBINATION	8
-	1	1	3-240641-1	SPACER	7
-	-	-	-	-	6
-	1	1	2-2119781-4	DEPRESSOR, SHEAR	5
-	1	1	2-238011-1	BLOCK, CRIMPER SPACER	4
-	1	1	5-1633966-5	CRIMPER, INSULATION O	3
-	1	1	1-455888-0	SPACER, CRIMPER	2
-	1	1	1803241-3	CRIMPER, WIRE F	1

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

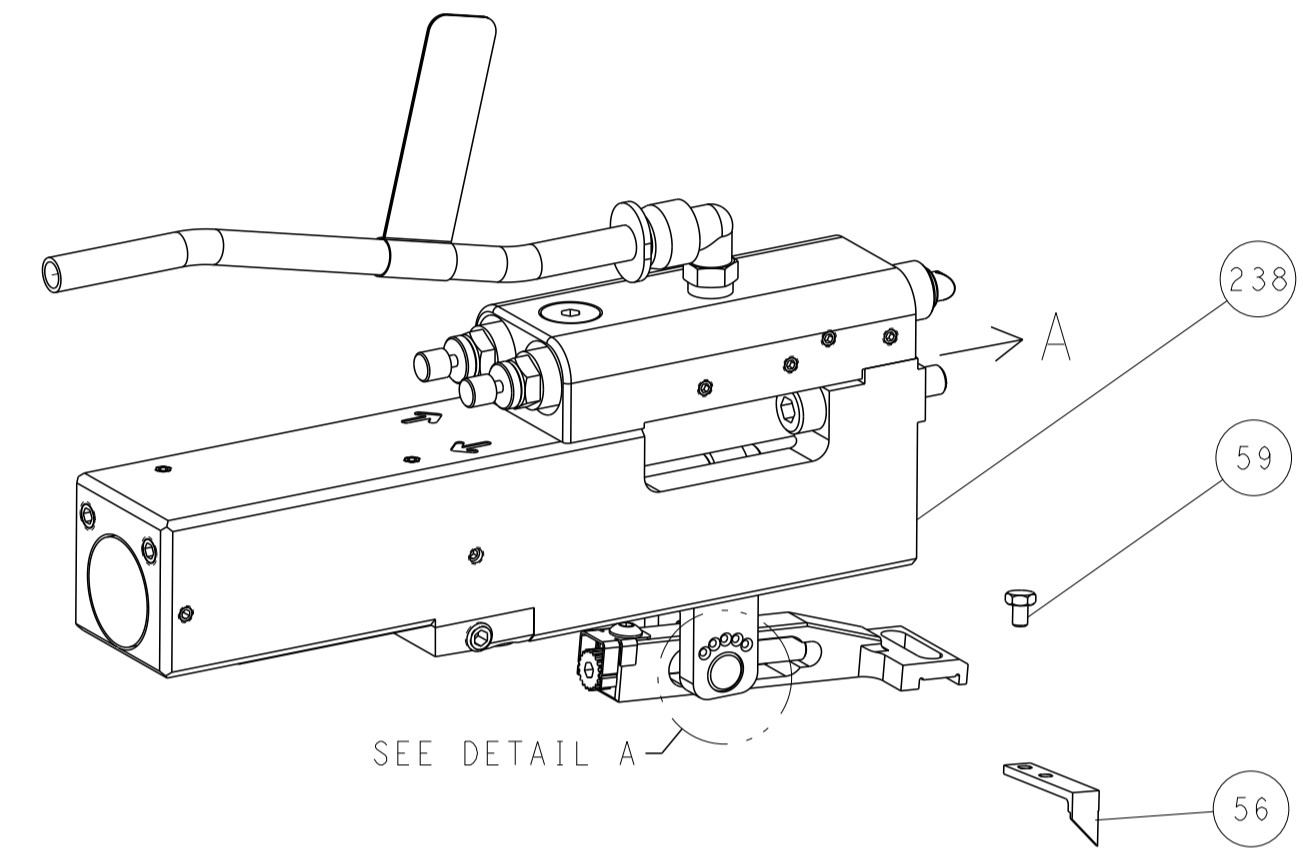
<small>THIS DRAWING IS CONTROLLED DOCUMENT AND THE INFORMATION CONTAINED HEREIN IS THE PROPERTY OF STE CONNECTIVITY. IT IS TO BE KEPT IN CONFIDENTIALITY AND NOT TO BE DISSEMINATED OUTSIDE THE COMPANY WITHOUT THE WRITTEN PERMISSION OF STE CONNECTIVITY. ANY UNAUTHORIZED REPRODUCTION OR DISSEMINATION OF THIS INFORMATION IS STRICTLY PROHIBITED AND WILL BE PUNISHED TO THE FULL EXTENT OF THE LAW.</small>		DWN J. HOU TSEP2015 CHK L. ZHANG TSEP2015 APVD H. GUO TSEP2015	STE 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=2836028 RESTRICTED TO:
MATERIAL: -		WEIGHT: -	SCALE: 1:2 SHEET 3 OF 4 REV: B1

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

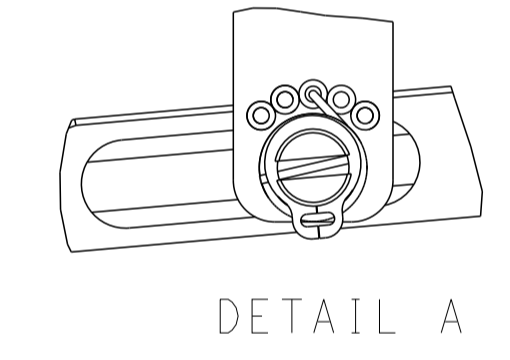
FEED TYPE MECHANICAL



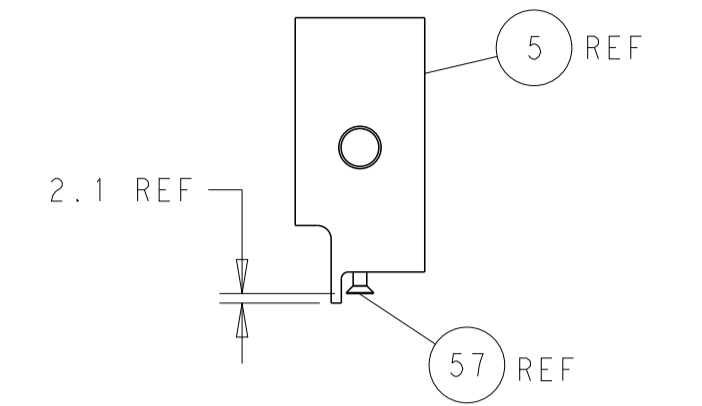
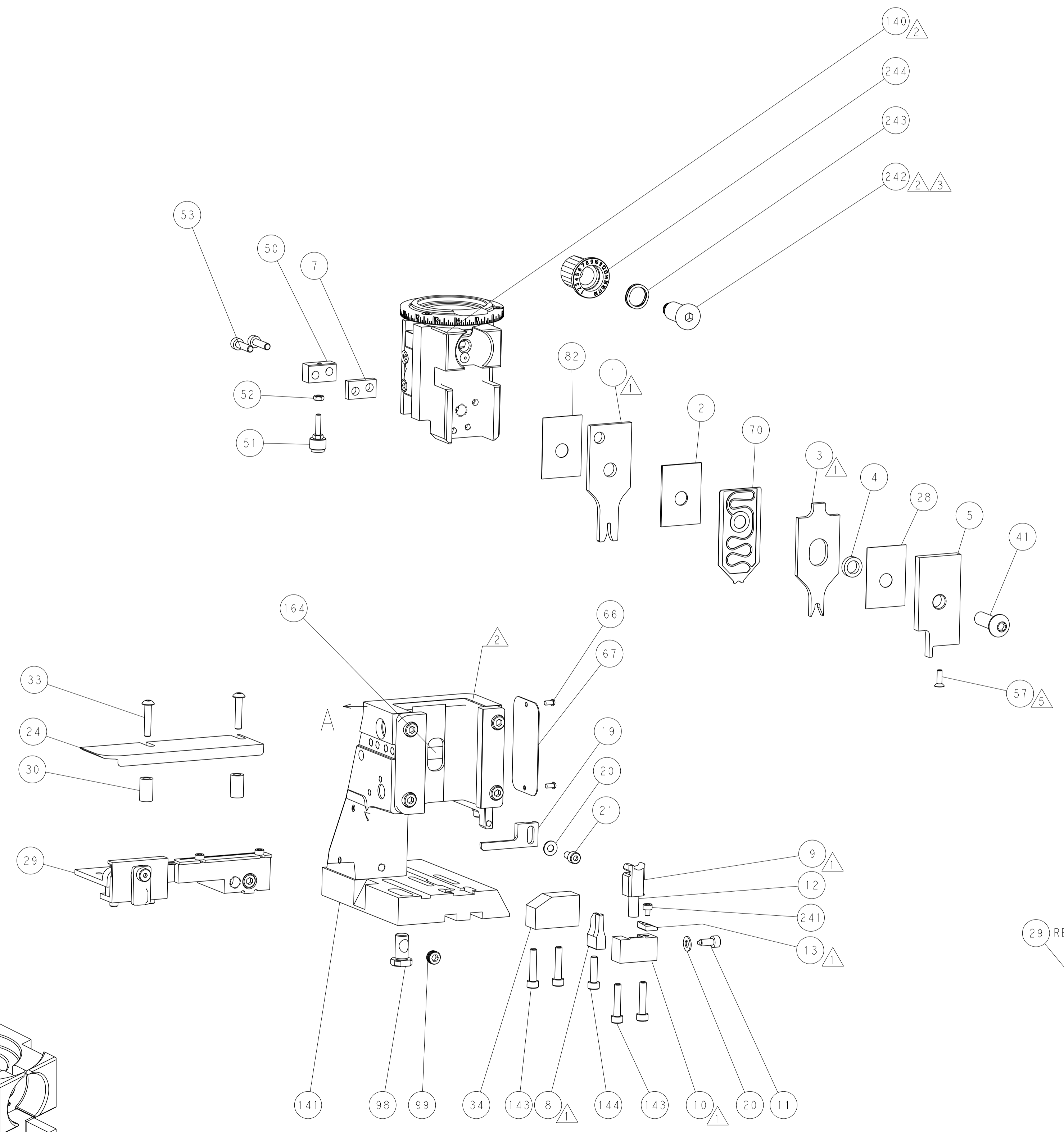
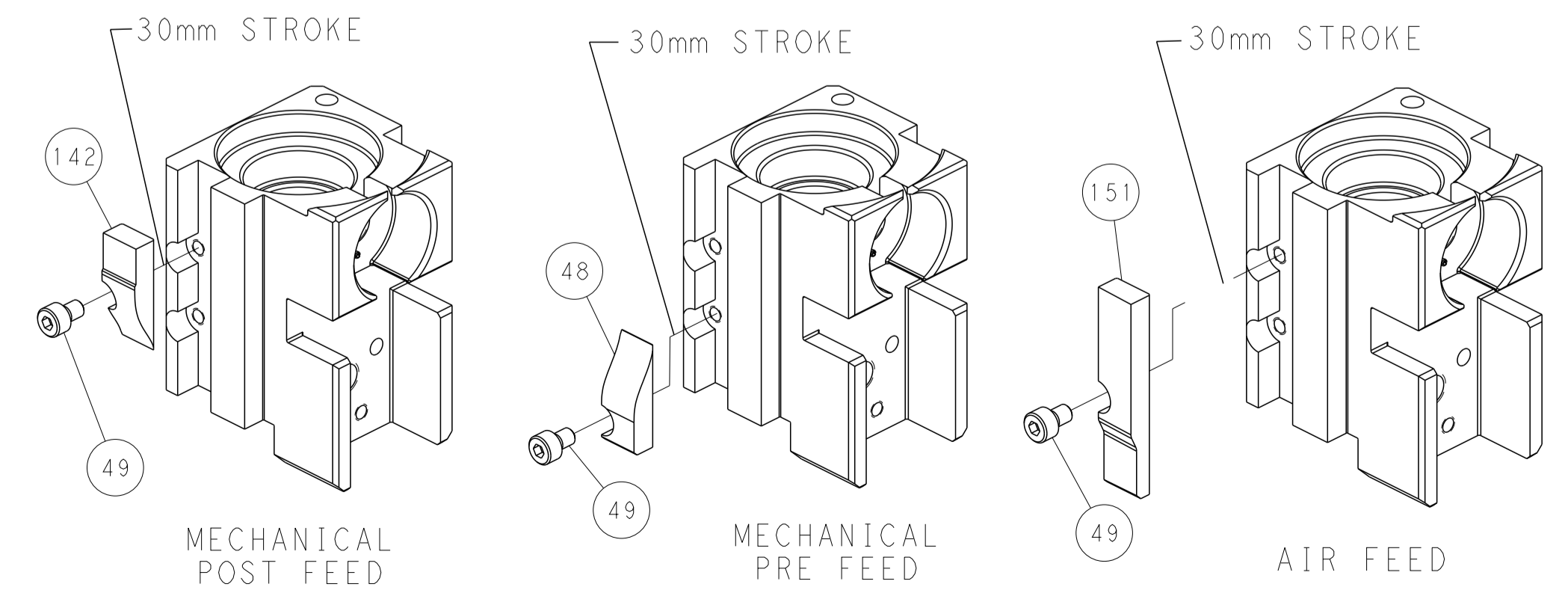
PNEUMATIC



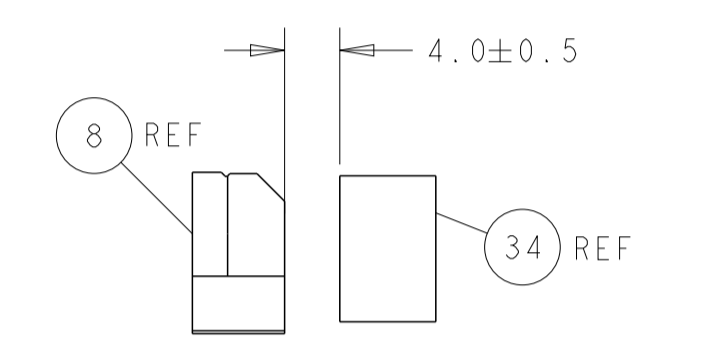
FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



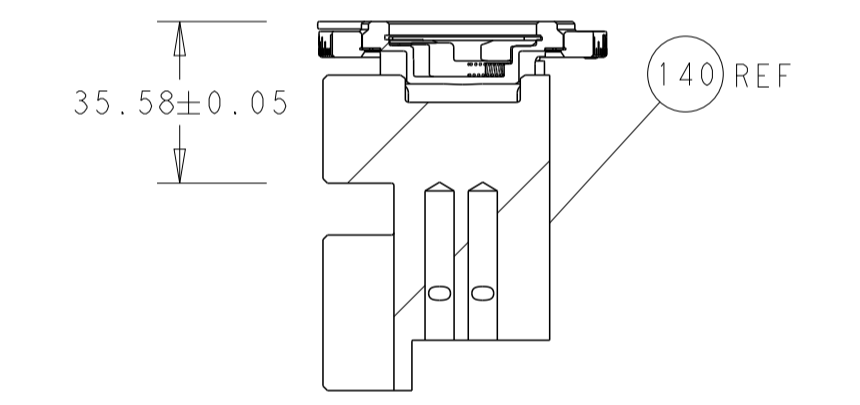
CAM POSITIONS



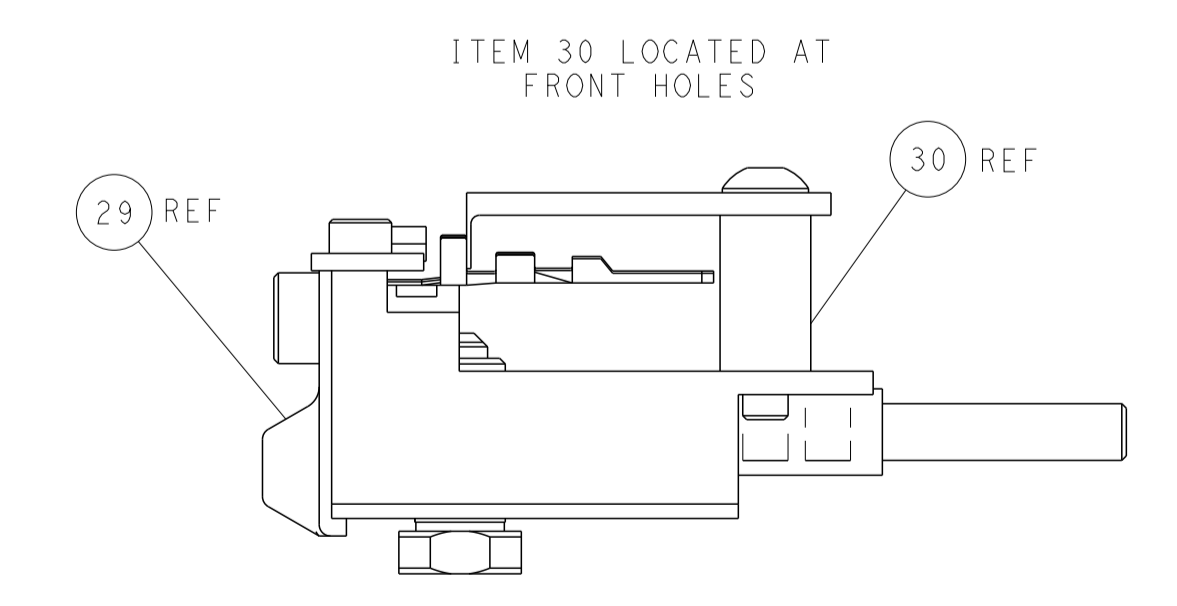
SHEAR DEPRESSOR DETAIL



TERMINAL SUPPORT LOCATION



RAM SET-UP



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)

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DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH ±	MATERIAL: - WEIGHT: - RESTRICTED TO: -	CUSTOMER ACCESSIBLE PRODUCTION DRAWING	TE Connectivity Harrisburg, PA 17105-3608