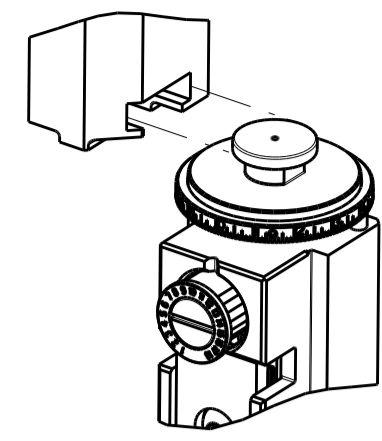


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2836228-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2836228-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2836228-1	B	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2836228-2	B	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2836228-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.60 mm [.063]	F
INSUL	3.81 mm [.150]	O

APPLICATOR INSTRUCTIONS 408-35042

TERMINAL DATA: DELPHI/FCI TERMINAL VW CRIMP SPECIFICATION	
TERMINAL NAME: FLACHKONTAKT HD 2.8	
WIRE STRIP LENGTH 3.53-4.29 mm [.139-.169 IN]	INSULATION DIAMETER RANGE Ø 1.20-2.00 mm [.047-.079 IN]
TERMINAL APPLICATION SPECIFICATION N104426 PAGE 3 Rev -	

TERMINALS APPLIED				
TE TERMINAL	DELPHI/FCI TERMINAL	TE SEAL	DELPHI/FCI SEAL	SEAL INSULATION DIAMETER RANGE
1572980-1	6 001 24 11	2113969-1	357 972 741	1.2-2.0 mm
1572980-5	F192410			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.35mm2	0.98 +/- 0.03 [.039 +/- .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. APPLY TORO-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.

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

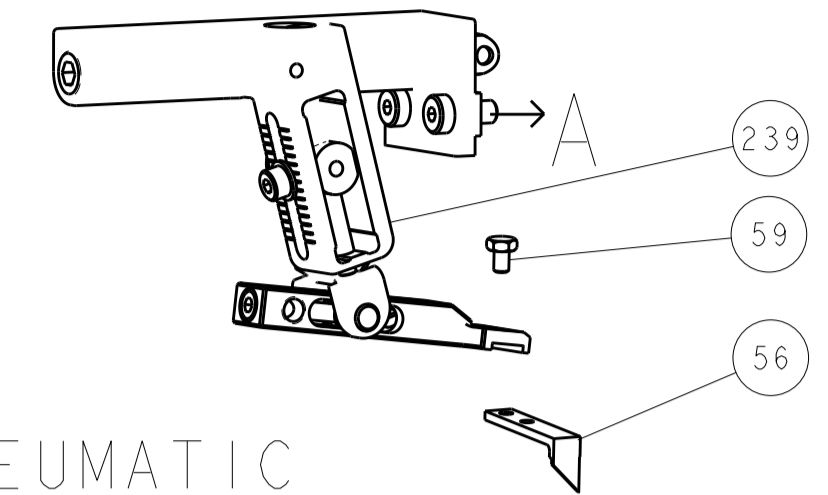
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A	66			RELEASED	23MAR2016	BW	TE
				ECR-20-007539	21MAY2020	FZ	TE

-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248	
-	1	1	1	1	2119082-3	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	-	-	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	455888-5	SPACER, CRIMPER	82	
-	1	1	1	1	1803607-3	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	
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	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	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	-	-	2119652-1	FEED CAM, PRE FEED	48	
-	-	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	1-1752356-7	SUPPORT, TERMINAL	34	
-	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33	
-	2	2	2	2	3-2844962-0	SPACER, CYLINDRICAL, STRIP GUIDE	30	
-	1	1	1	1	2844992-4	ASSEMBLY, STRIP GUIDE	29	
-	1	1	1	1	455888-5	SPACER, CRIMPER	28	
-	1	1	1	1	240792-1	DRAG, TERMINAL	25	
-	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	8-1803171-9	ANVIL, COMBINATION	8
-	-	-	-	-	-	-	7	
-	-	-	-	-	-	-	6	
-	1	1	1	1	2119781-1	DEPRESSOR, SHEAR	5	
-	1	1	1	1	238011-4	BLOCK, CRIMPER SPACER	4	
1	1	2	2	1	1	4-1633965-3	CRIMPER, INSULATION O PREMIUM	3
-	1	1	1	1	1-455888-0	SPACER, CRIMPER	2	
1	1	2	2	1	1	3-1633664-8	CRIMPER, WIRE	1
-	77	-72	-71	-2	-1	PART NO	DESCRIPTION	ITEM NO

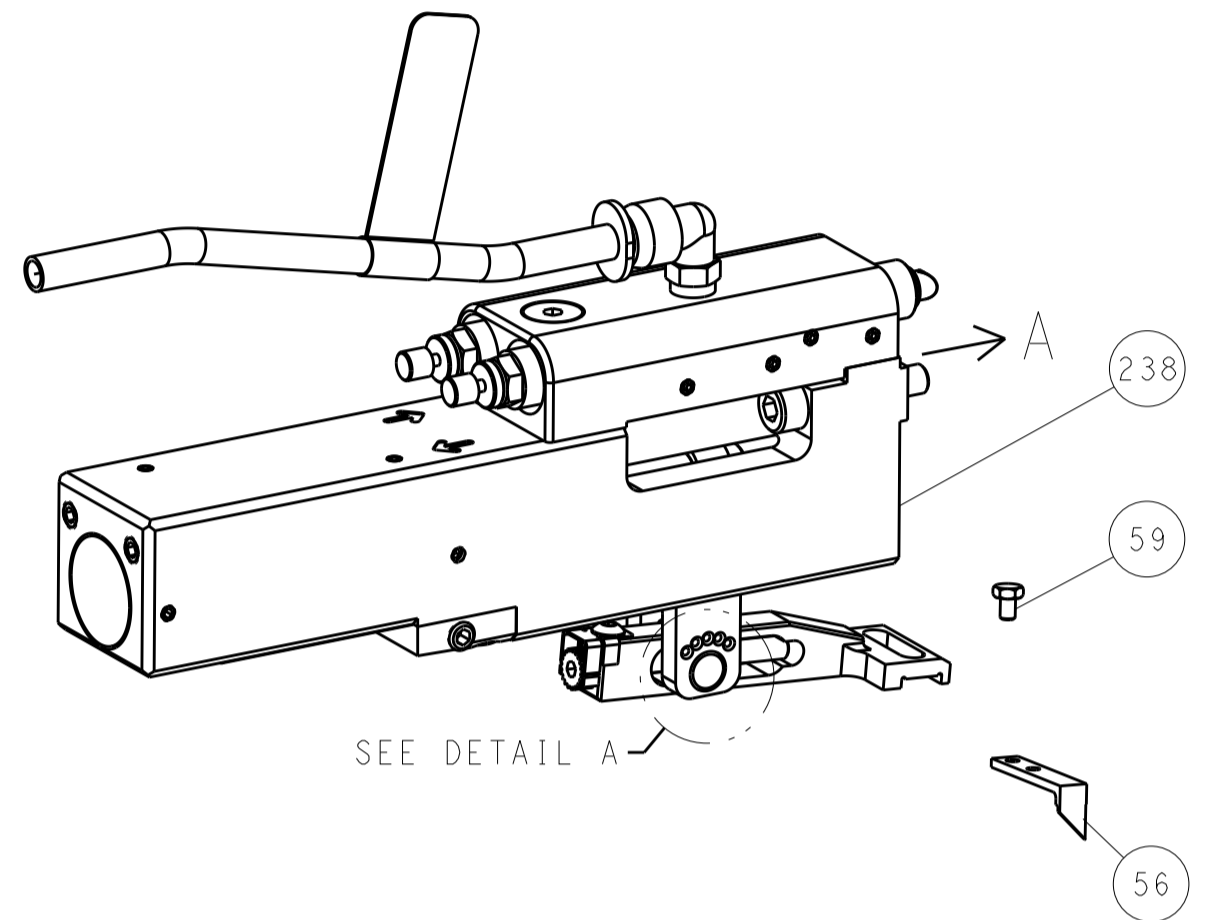
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	3 PLC ±	4 PLC ±	ANGLES ±	APVD	24FEB2016	NAME	
	FINISH			NAME		Ocean Side Feed	
MATERIAL		WEIGHT		SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
				A1	00779	2836228	
Customer Accessible Production Drawing				SCALE	1:2	SHEET	1 of 4
				REV	B		

LOC	DIST	REV	DATE	BY	APP'D
A	66				

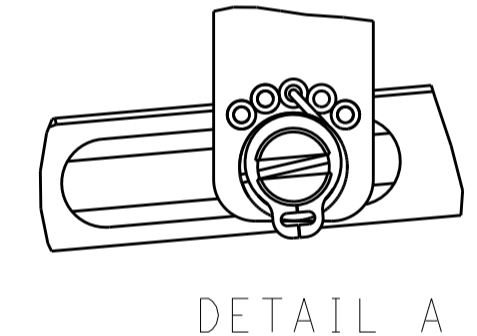
# FEED TYPE MECHANICAL



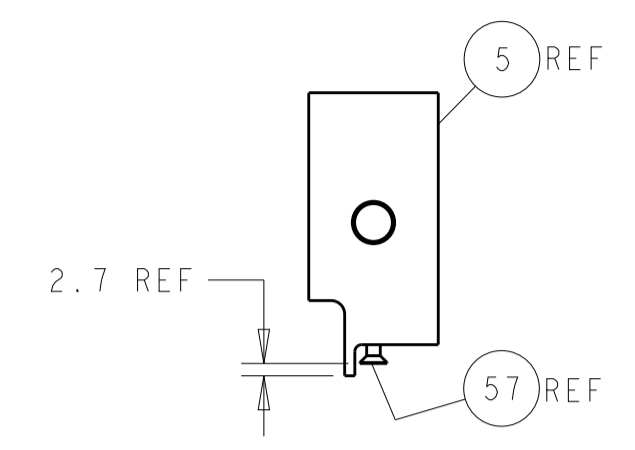
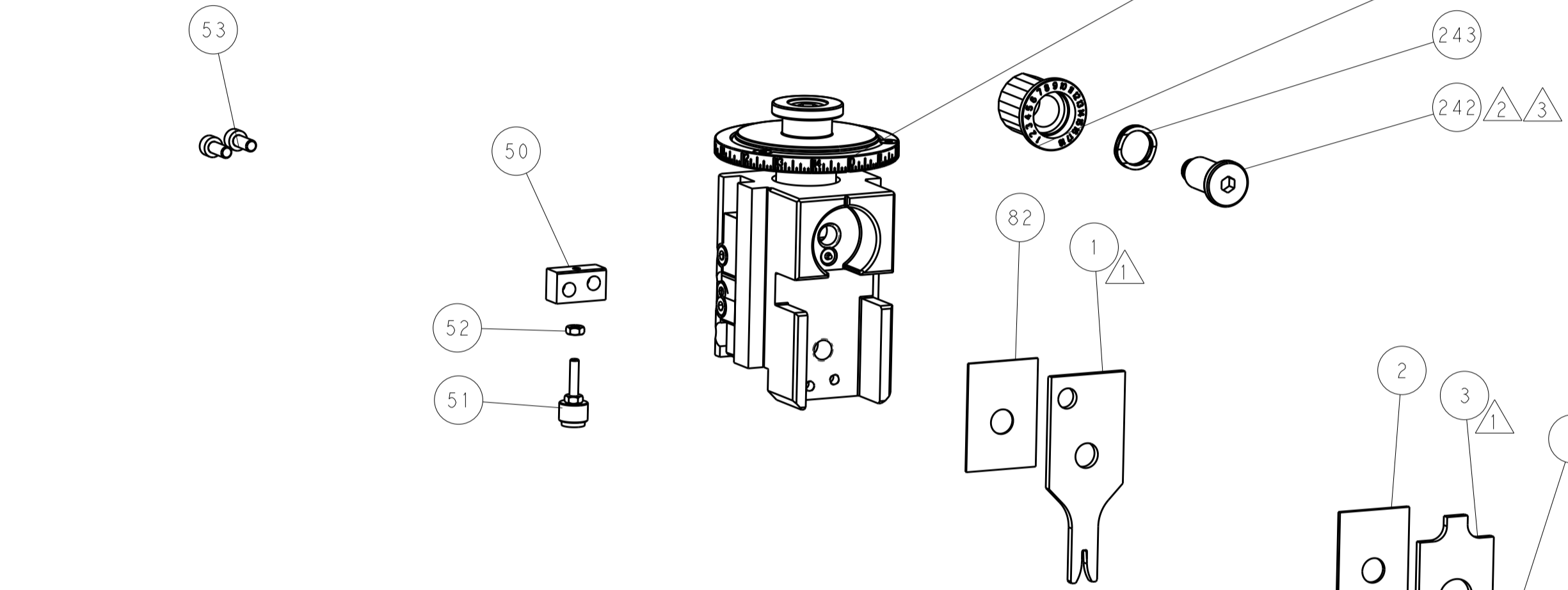
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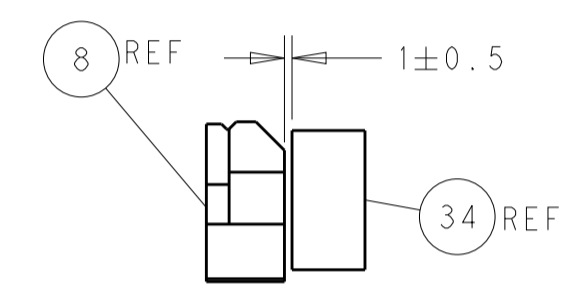
## FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



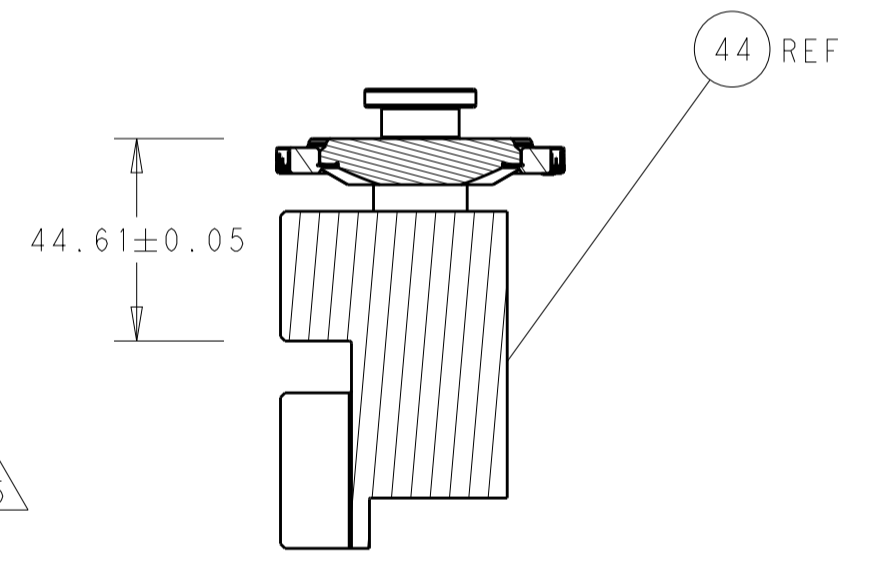
DETAIL A



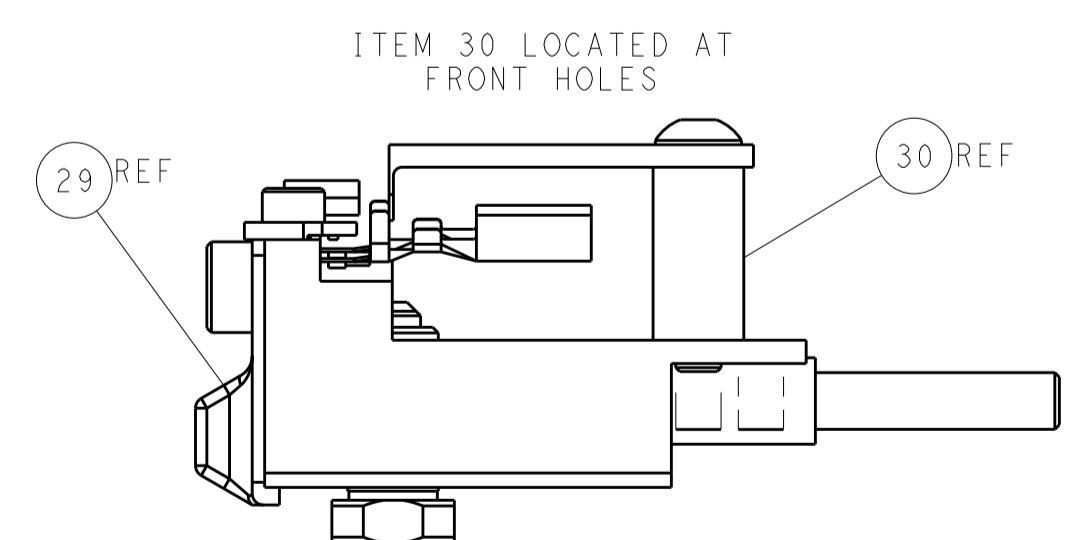
SHEAR DEPRESSOR DETAIL



TERMINAL SUPPORT LOCATION

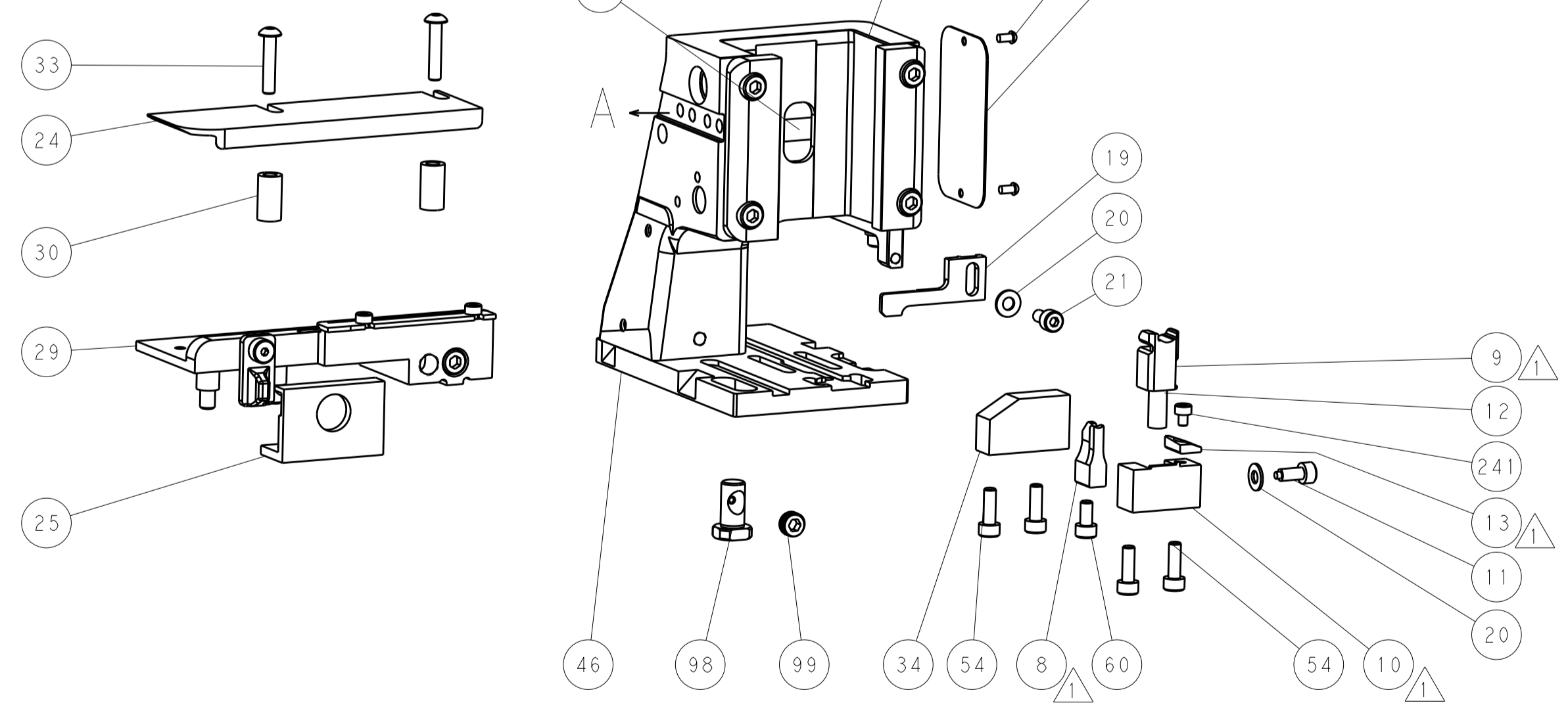
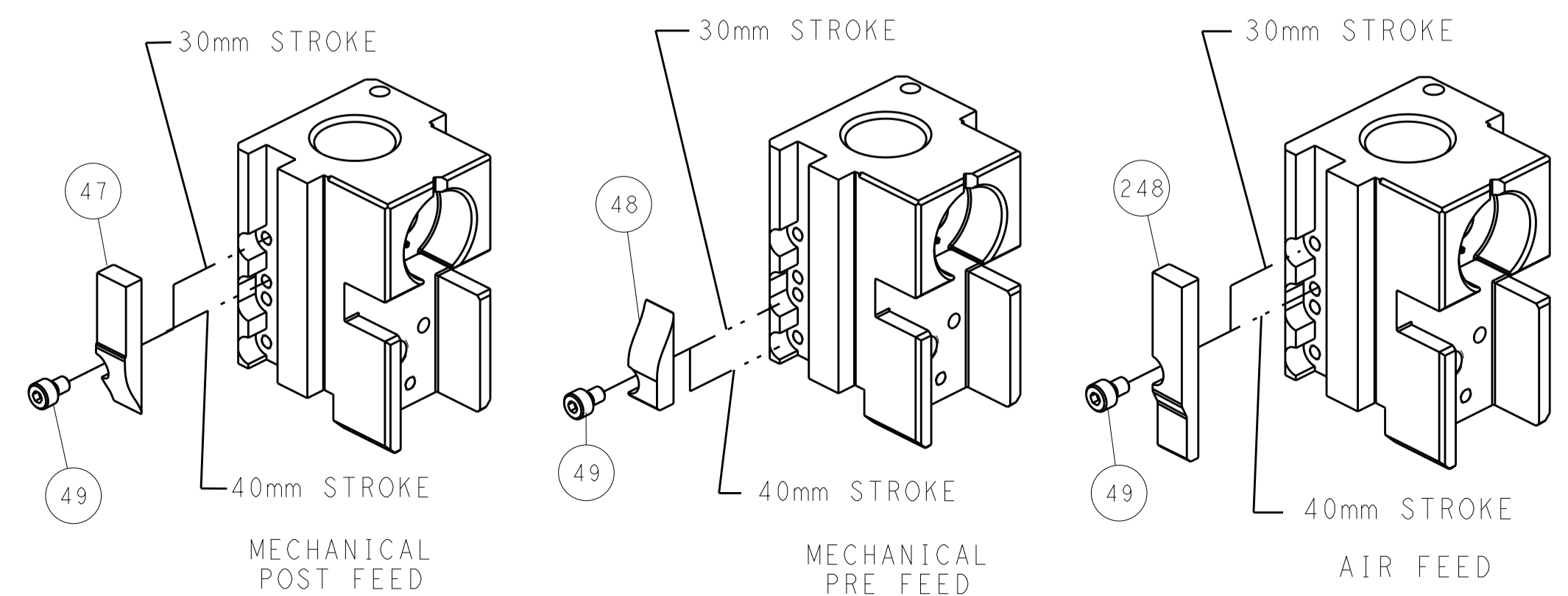


RAM SET-UP



ITEM 30 LOCATED AT FRONT HOLES

# 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 ±		DWN H. HUANG 24FEB2016 CHK L. ZHANG 24FEB2016 APVD H. GUO 24FEB2016		TE Connectivity Harrisburg, PA 17105-3608	
MATERIAL:		FINISH:		NAME: Ocean Side Feed Applicator		SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2836228	
WEIGHT:		SCALE: 1:2		SHEET: 2 OF 4		REV: B	

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2836228-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2836228-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2836228-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR  
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.60 mm [.063]	F
INSUL	3.81 mm [.150]	O

APPLICATOR INSTRUCTIONS  
408-35042

TERMINAL DATA: DELPHI/FCI TERMINAL VW CRIMP SPECIFICATION				
TERMINAL NAME: FLACHKONTAKT HD 2.8				
WIRE STRIP LENGTH 3.53-4.29 mm [1.39-.169 IN]	INSULATION DIAMETER RANGE Ø 1.20-2.00 mm [1.047-.079 IN]			
TERMINAL APPLICATION SPECIFICATION N104426 PAGE 3 Rev -				
TERMINALS APPLIED				
TE TERMINAL	DELPHI/FCI TERMINAL	TE SEAL	DELPHI/FCI SEAL	SEAL INSULATION DIAMETER RANGE
1572980-1	6 001 24 11	2113969-1	357 972 741	1.2-2.0 mm
1572980-5	F192410			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.35mm <sup>2</sup>	0.98 +/- 0.03 [1.039 +/- .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 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	DWN	APVD
A	66	-	-	SEE SHEET 1	-	-	-

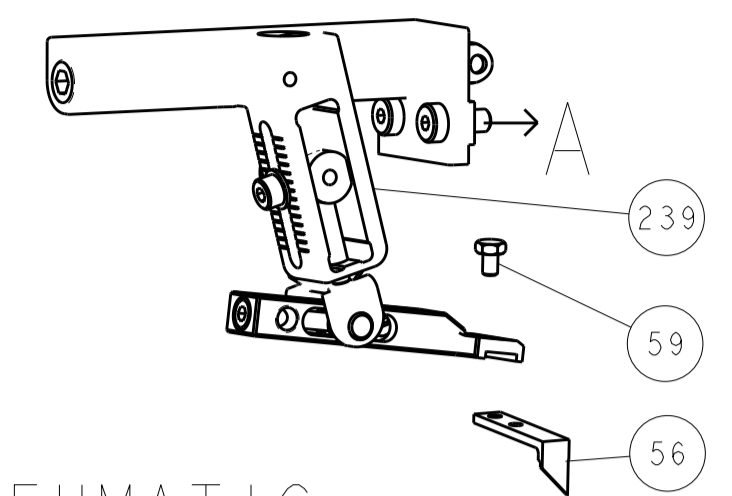
-	1	1	2119082-3	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
-	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	1	-	2844940-1	AIR FEED MODULE	238
-	REF	REF	994970-2	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	455888-5	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	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	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	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	1-1752356-7	SUPPORT, TERMINAL	34
-	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	3-2844962-0	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	2844992-4	ASSEMBLY, STRIP GUIDE	29
-	1	1	455888-5	SPACER, CRIMPER	28
-	1	1	240792-1	DRAG, TERMINAL	25
-	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	8-1803171-9	ANVIL, COMBINATION	8
-	-	-	-	-	7
-	-	-	-	-	6
-	1	1	2119781-1	DEPRESSOR, SHEAR	5
-	1	1	238011-4	BLOCK, CRIMPER SPACER	4
-	1	1	4-1633965-3	CRIMPER, INSULATION O PREMIUM	3
-	1	1	1-455888-0	SPACER, CRIMPER	2
-	1	1	3-1633664-8	CRIMPER, WIRE	1

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

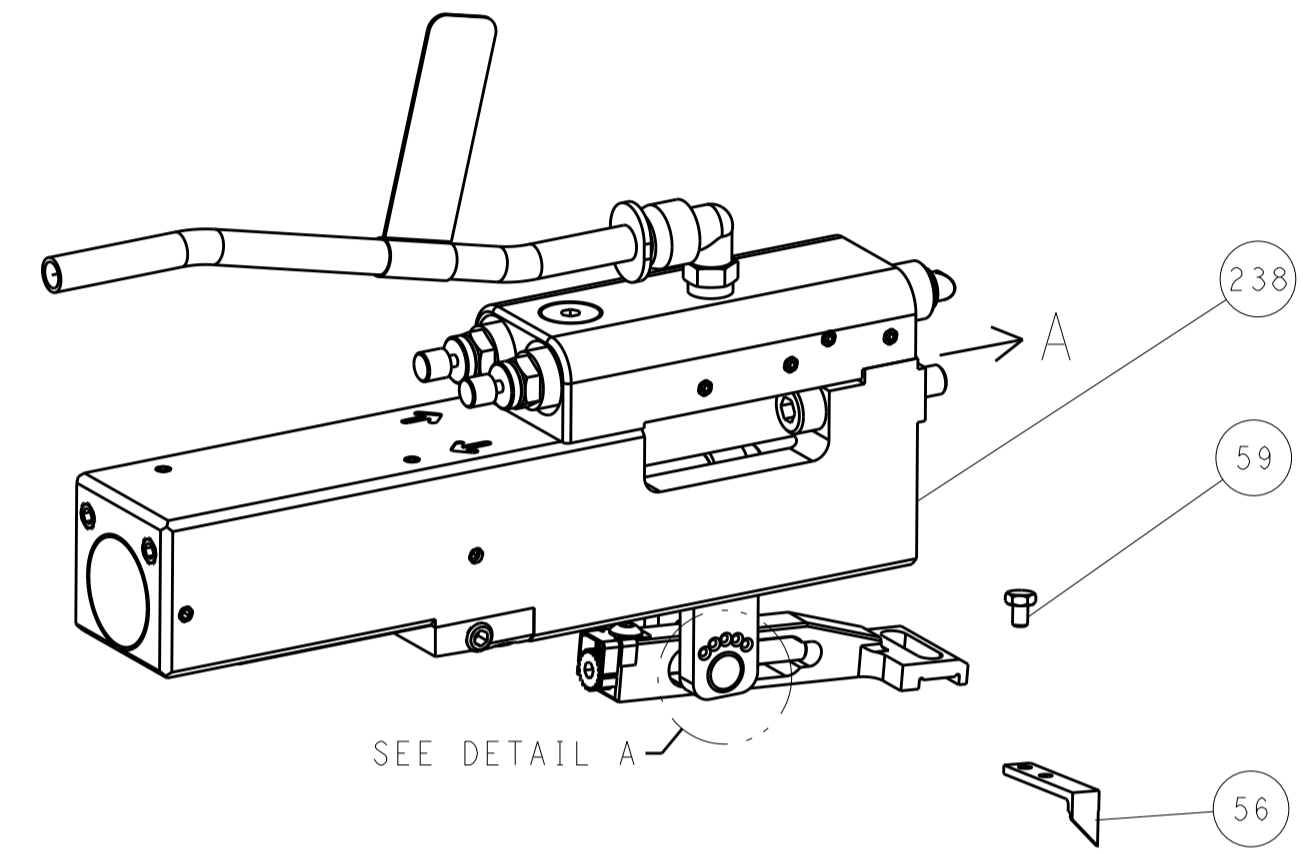
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mm	0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±	FINISH	OTHERWISE SPECIFIED:	CHK L. ZHANG 24FEB2016	NAME Ocean Side Feed Applicator		
MATERIAL				APVD H. GUO 24FEB2016	SIZE	CAGE CODE	DRAWING NO
				PRODUCT SPEC	A1	00779	2836228
				APPLICATION SPEC	SCALE	1:2	SHEET 3 OF 4
				WEIGHT	Customer Accessible Production Drawing		

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

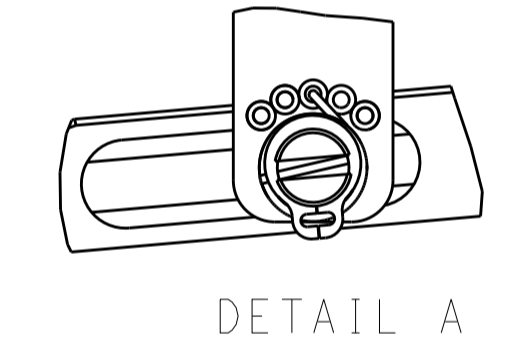
# FEED TYPE MECHANICAL



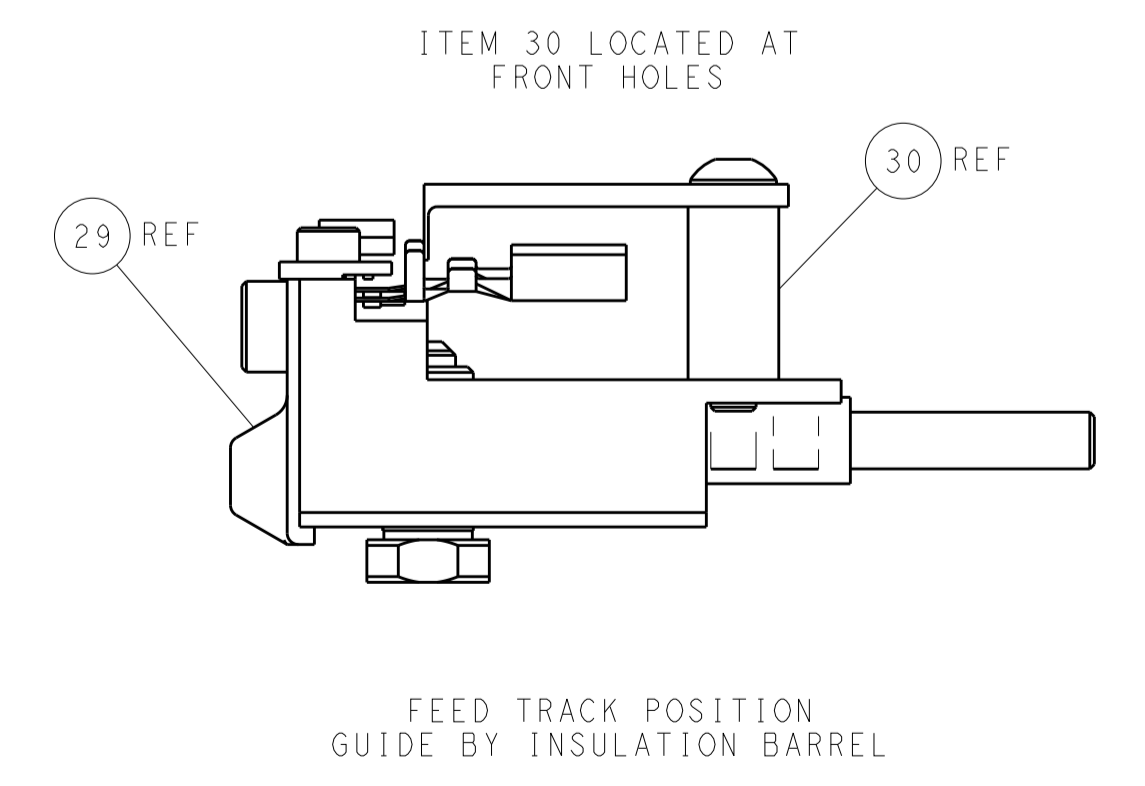
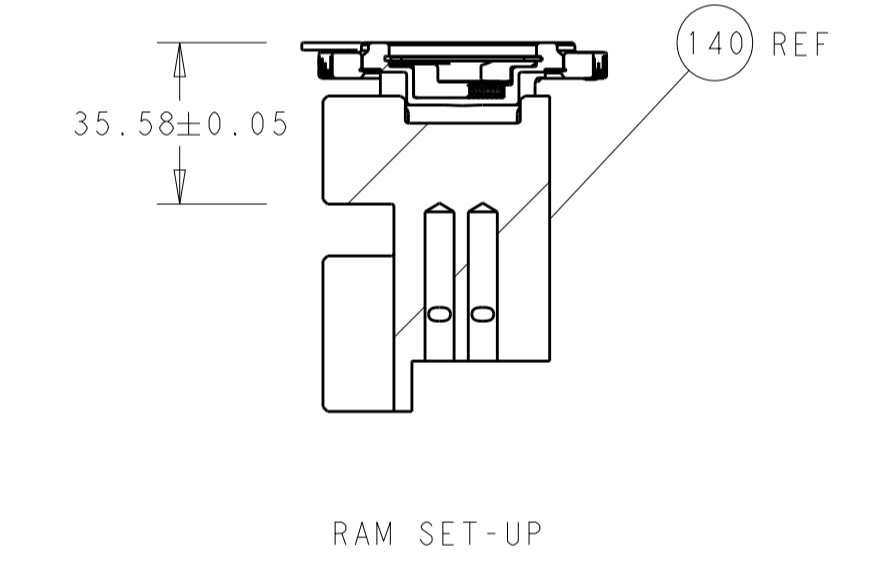
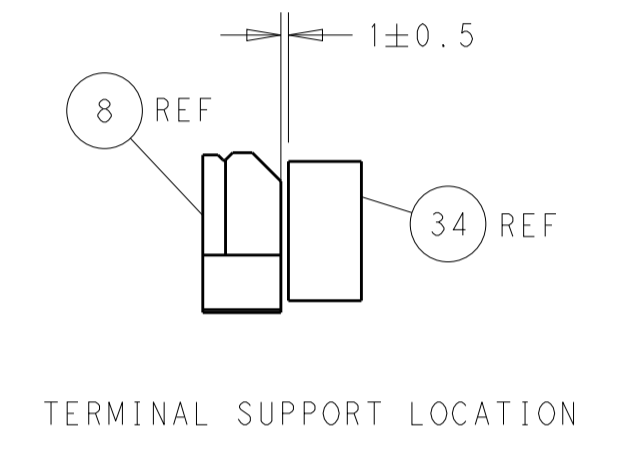
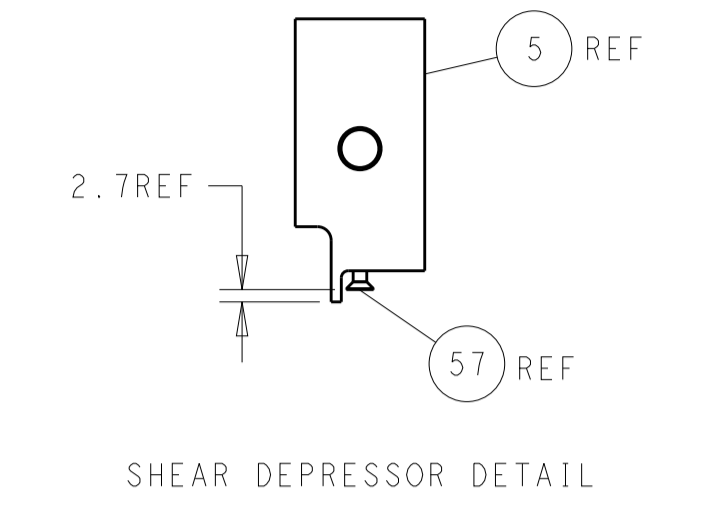
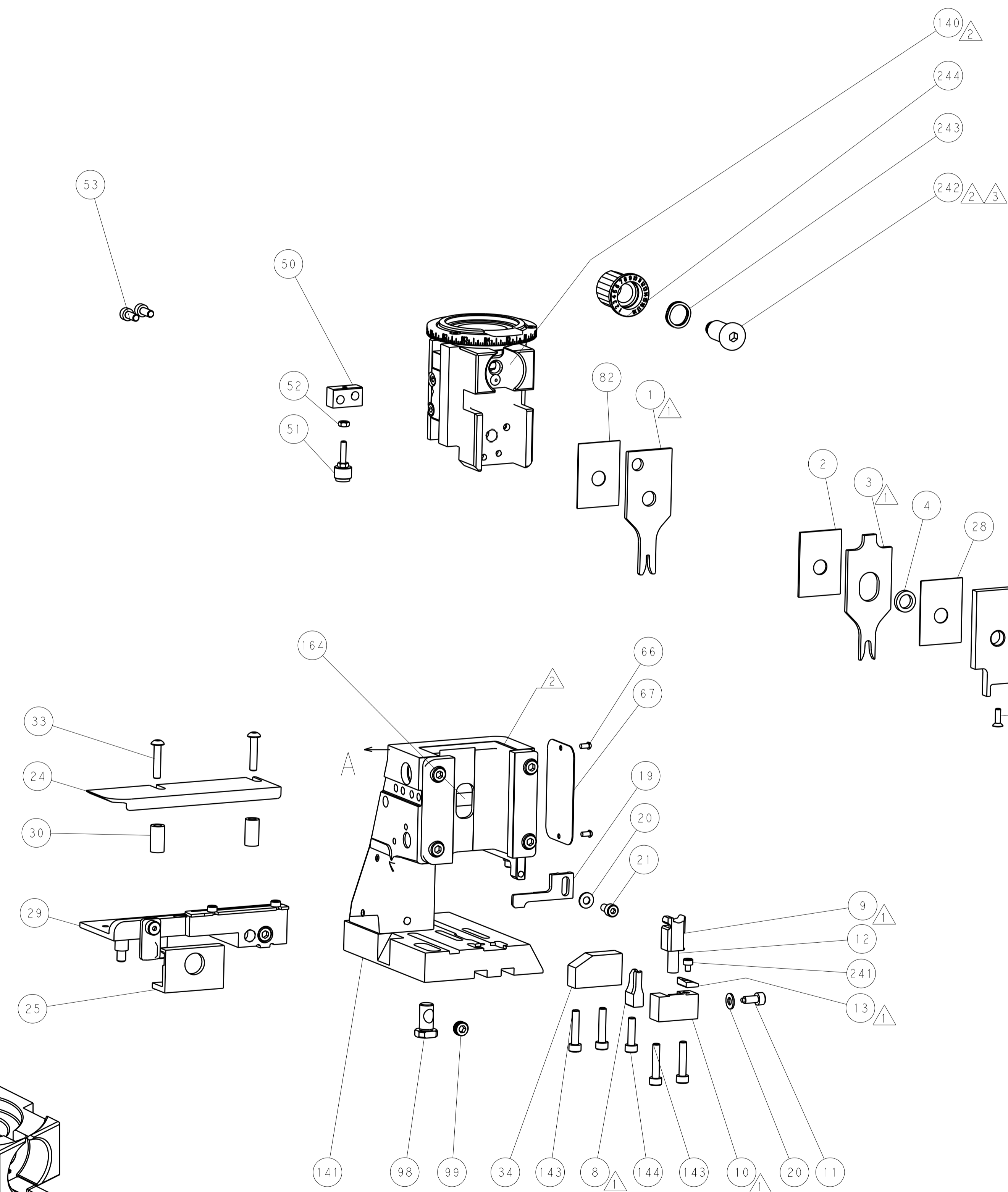
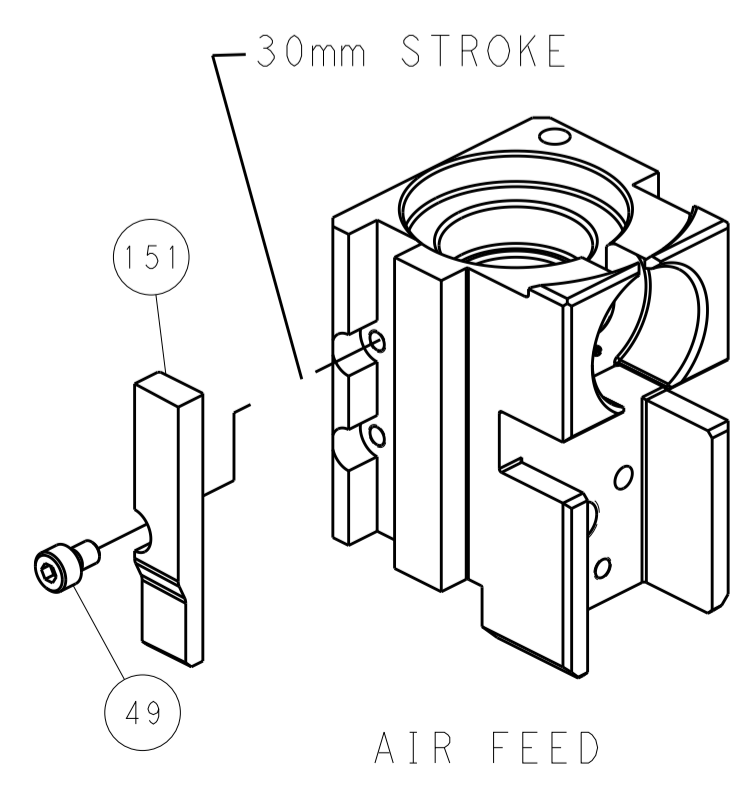
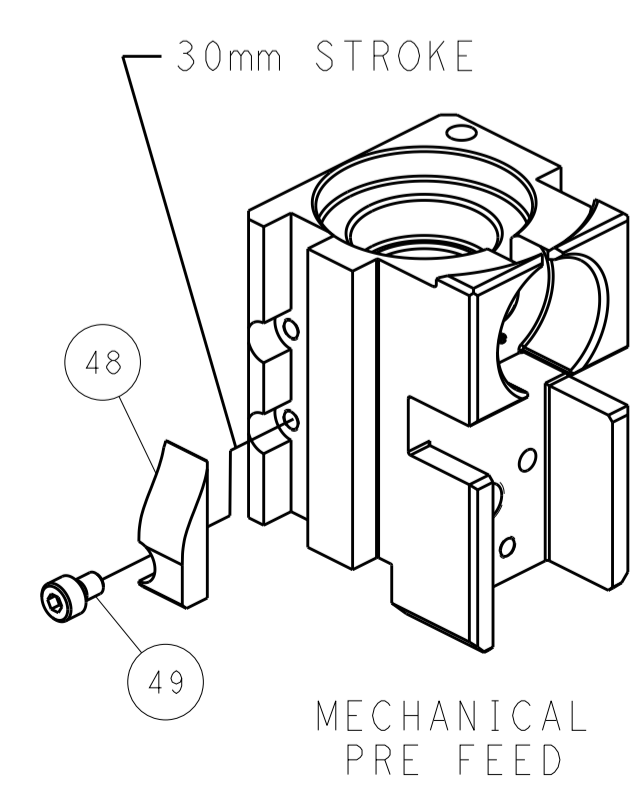
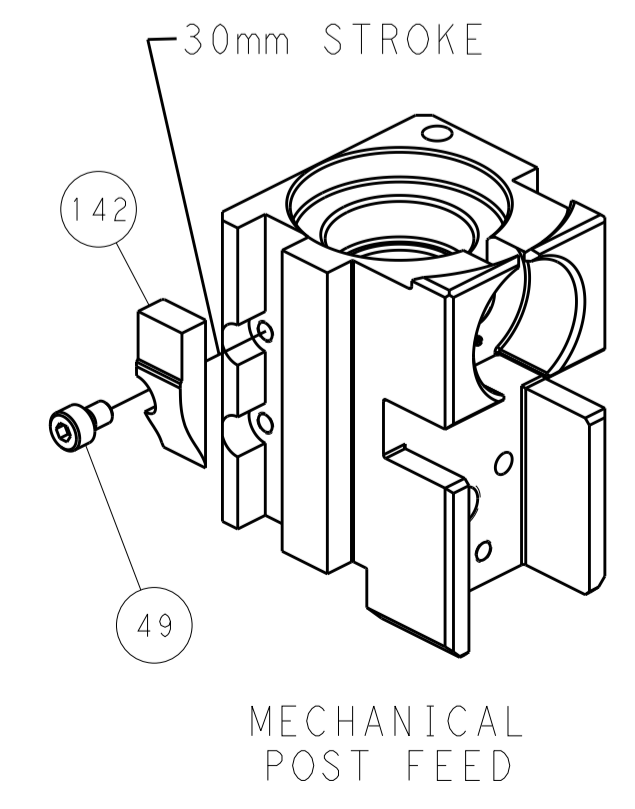
## PNEUMATIC



### 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)

<small>THE DRAWING IS UNPUBLISHED. IT IS THE PROPERTY OF TYCO ELECTRONICS CORPORATION. IT IS TO BE USED ONLY FOR THE PURPOSES AND IN THE MANNER SPECIFIED BY THE DRAWING. IT IS TO BE RETURNED TO TYCO ELECTRONICS CORPORATION WHEN NO LONGER REQUIRED.</small>		DWN: H. HUANG 24FEB2016 CHK: L. ZHANG 24FEB2016 APVD: H. GUO 24FEB2016	TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		NAME: Ocean Side Feed Applicator PRODUCT SPEC: APPLICATION SPEC: SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2836228	RESTRICTED TO: SCALE: 1:2 SHEET: 4 OF 4 REV: B
MATERIAL: FINISH:		WEIGHT:	Customer Accessible Production Drawing