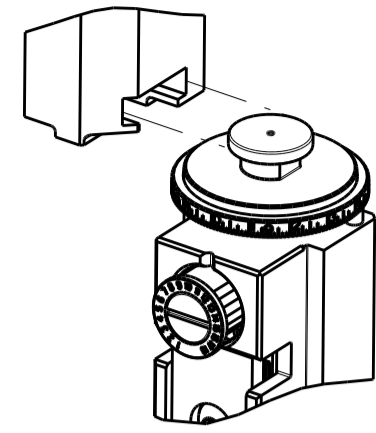


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2836310-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2836310-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2836310-1	B	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2836310-2	C	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2836310-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.29 mm [.090]	F

APPLICATOR INSTRUCTIONS 408-35042

TERMINAL DATA: LEAR TERMINAL		LEAR CRIMP SPECIFICATION	
TERMINAL NAME: PIGTAIL TERMINAL			
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE		
7.60-8.40 mm [.299-.331 IN]	∅ -		
TERMINAL APPLICATION SPECIFICATION	25863 Rev 28	-	-

TERMINALS APPLIED			
TE TERMINAL	LEAR TERMINAL	TE TERMINAL	LEAR TERMINAL
2303573-1	25863.123.009	2303573-6	25863.213.111
2303573-2	25863.123.003	2303573-7	25863.201.178
2303573-3	25863.213.179	2303573-8	25863.160.009
2303573-4	25863.411.131	2303573-9	25863.123.179
2303573-5	25863.213.178	1-2303573-0	25863.123.178

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
(2) 0.35mm ² +0.75 mm ²	1.50+/-0.05 [.059+/- .002]	5.3
0.35mm ² +1 mm ²	1.45+/-0.05 [.057+/- .002]	5.9
(2) 0.5 mm ²	1.40+/-0.05 [.055+/- .002]	6.4
1.00mm ²	1.35+/-0.05 [.053+/- .002]	6.9
(3) 0.35 mm ²	1.35+/-0.05 [.053+/- .002]	6.9
0.75mm ²	1.30+/-0.05 [.051+/- .002]	7.3

- 1 RECOMMENDED SPARE PARTS
- 2 REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- 3 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.
- 4 TERMINAL LUBRICANT IS RECOMMENDED.
- 5 LOCATE ITEM 19 BETWEEN ITEMS 1 AND 5
- 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	DWN	APVD
		A		RELEASED	12JUL2016	BW	TE
		A1		ECR-18-017113	30OCT2016	MZ	KZ
		B		ECR-19-001627	31JAN2019	JAH	TE
		C		ECR-19-011339	22JUL2019	FZ	TE

-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248	
-	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	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	455888-5	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	
-	1	1	1	1	1338685-1	PAWL, FEED	56	
-	2	2	2	2	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	54	
-	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	
-	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33	
-	2	2	2	2	1-2844962-5	SPACER, CYLINDRICAL, STRIP GUIDE	30	
-	1	1	1	1	2844992-7	ASSEMBLY, STRIP GUIDE	29	
-	1	1	1	1	1803078-2	SPACER, PRECISION	28	
-	1	1	1	1	1-1320928-0	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	2119533-2	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	1803095-5	FLOATING SHEAR, FRONT	9	
-	1	2	2	1	1	7-1633933-8	ANVIL, COMBINATION	8
-	-	-	-	-	-	-	7	
-	-	-	-	-	-	-	6	
-	1	1	1	1	2119757-6	DEPRESSOR, SHEAR	5	
-	-	-	-	-	-	-	4	
-	-	-	-	-	-	-	3	
-	-	-	-	-	-	-	2	
-	1	2	2	1	1	4-1803241-9	CRIMPER, WIRE F	1
-	77	72	71	-2	-1	PART NO	DESCRIPTION	ITEM NO

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

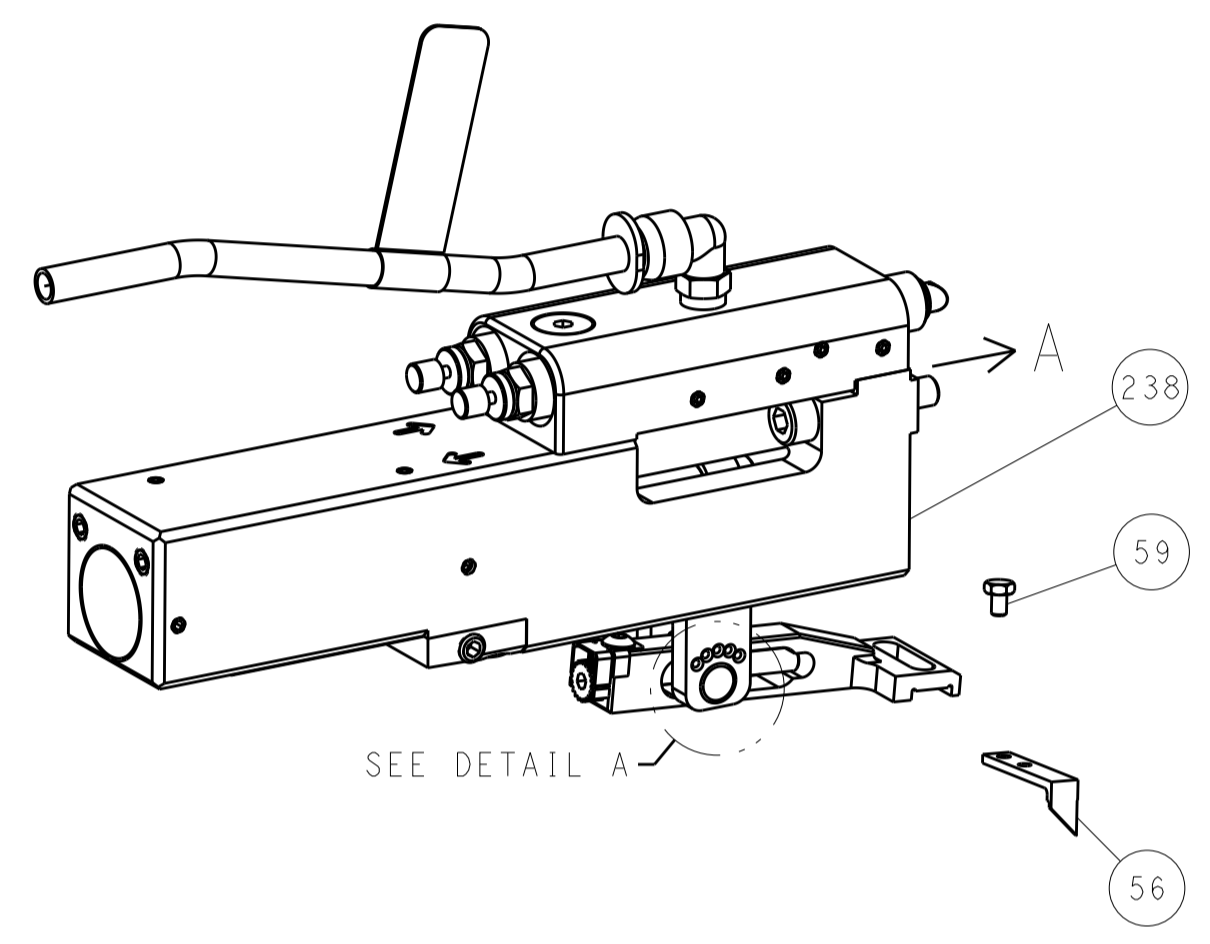
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0 PLC ±		1 PLC ±		2 PLC ±		3 PLC ±		4 PLC ±		SIZE: A1	
ANGLES		FINISH		WEIGHT		SCALE: 1:2		SHEET: 1 of 4		REV: C	
MATERIAL		FINISH		WEIGHT		SCALE: 1:2		SHEET: 1 of 4		REV: C	

LOC	DIST	REV	DATE	BY	APPV
A	66				

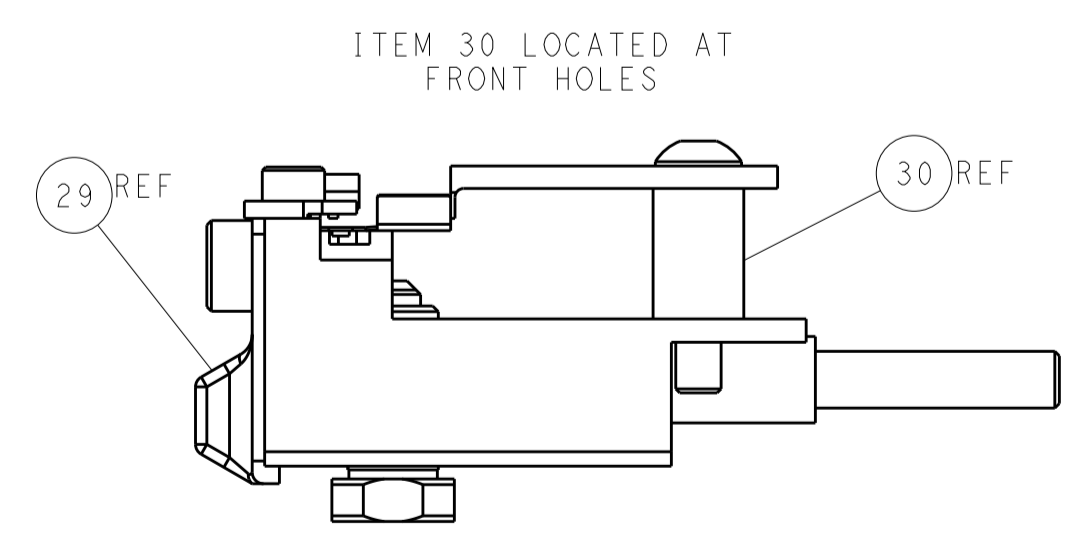
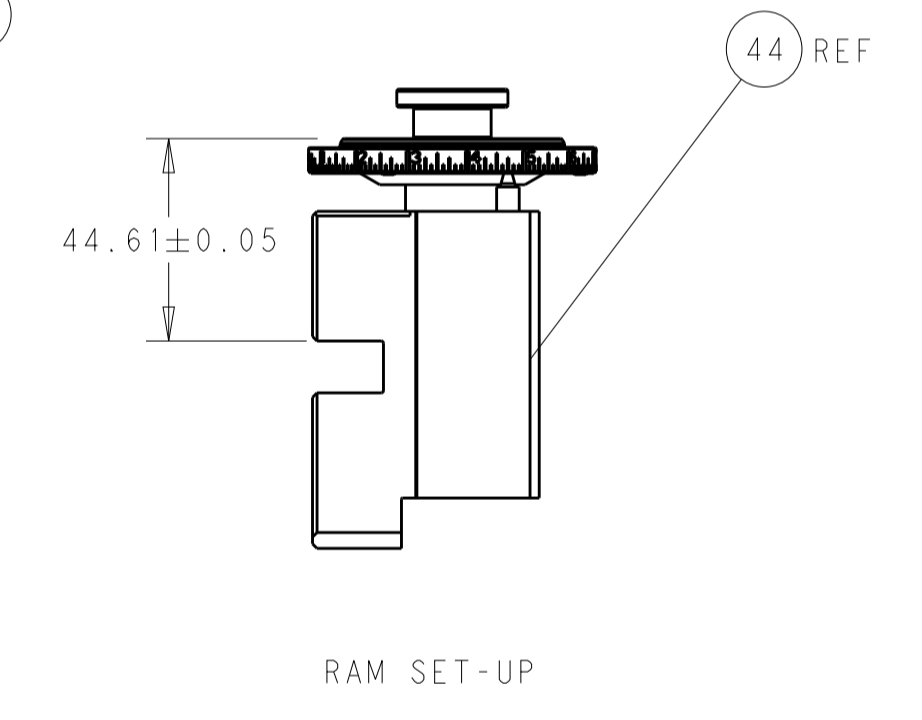
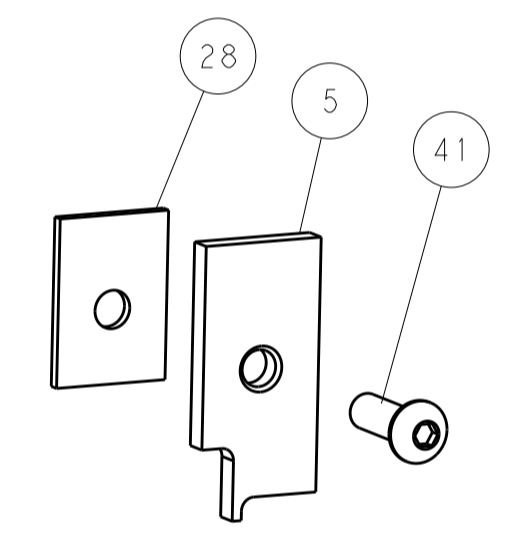
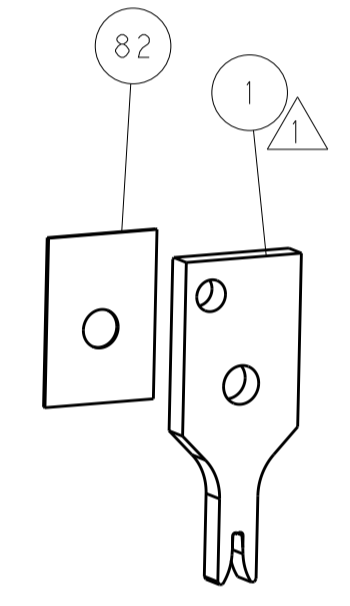
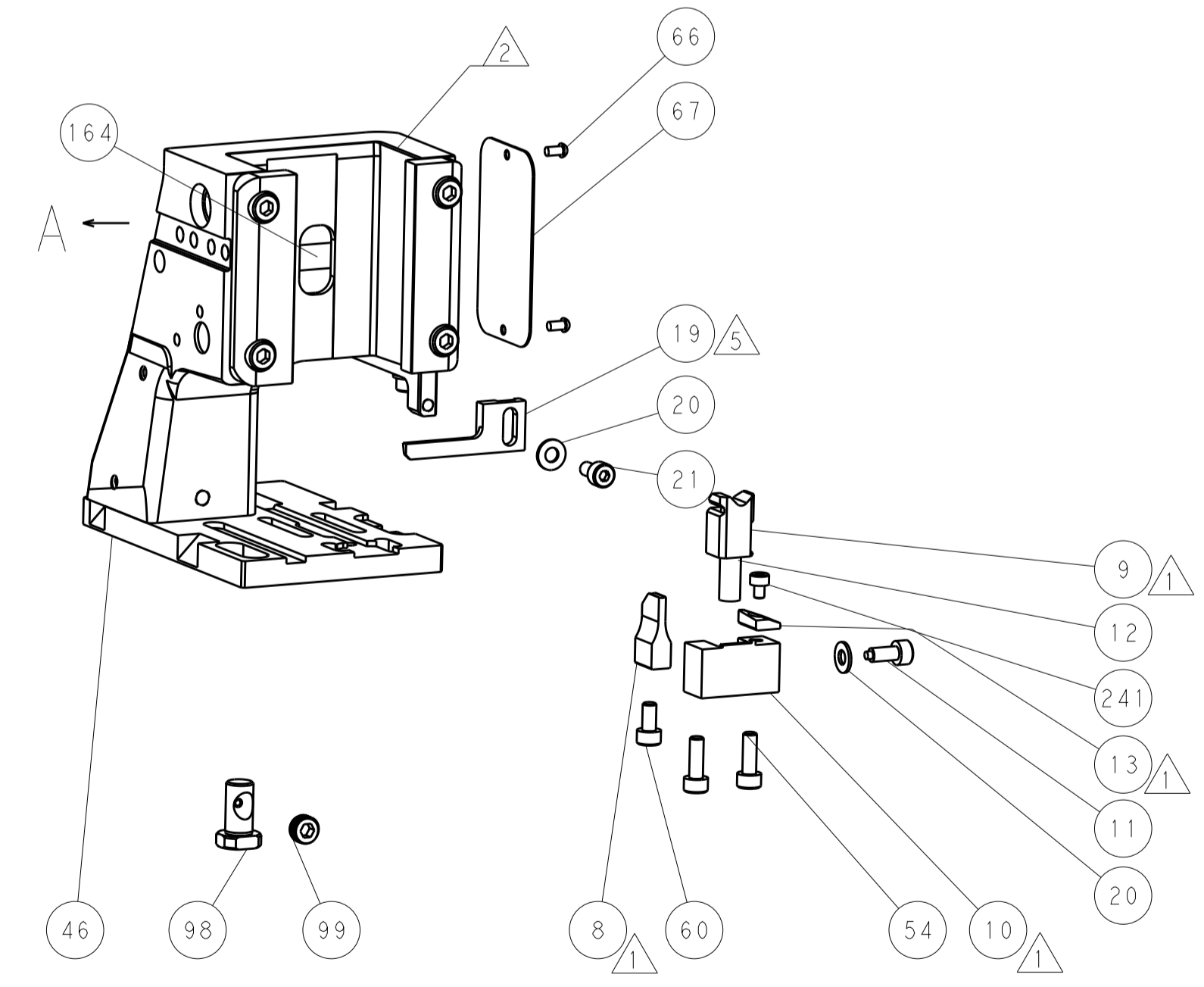
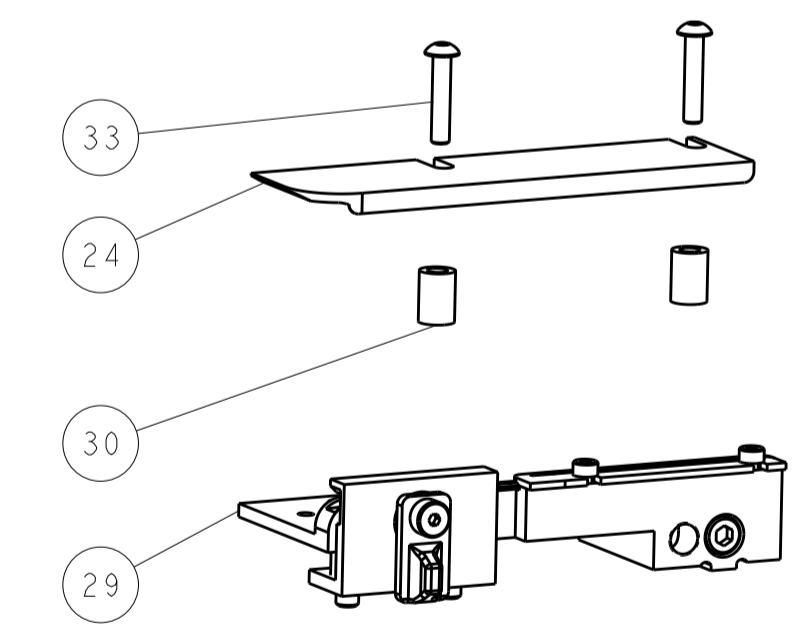
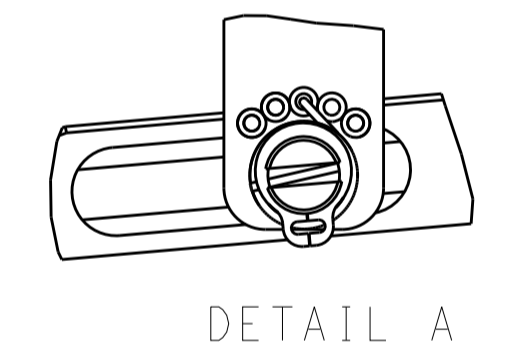
FEED TYPE MECHANICAL



PNEUMATIC



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)

DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		DWN B. WEAVER 06JUN2016 CHK T. ELBIN 06JUN2016 APVD T. ELBIN 06JUN2016 PRODUCT SPEC APPLICATION SPEC WEIGHT Customer Accessible Production Drawing		TE Connectivity Harrisburg, PA 17105-3608 NAME Ocean Side Feed Applicator SIZE CAGE CODE DRAWING NO A1 00779 C=2836310 SCALE 1:2 SHEET 2 OF 4 REV C	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2836310-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2836310-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2836310-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.29 mm [.090]	F

APPLICATOR INSTRUCTIONS
408-35042

TERMINAL DATA: LEAR TERMINAL LEAR CRIMP SPECIFICATION

TERMINAL NAME: PIGTAIL TERMINAL

WIRE STRIP LENGTH	INSULATION DIAMETER RANGE
7.60-8.40 mm [.299-.331 IN]	Ø -

TERMINAL APPLICATION SPECIFICATION	25863 Rev 28	-	-
-	-	-	-

TERMINALS APPLIED

TE TERMINAL	LEAR TERMINAL	TE TERMINAL	LEAR TERMINAL
2303573-1	25863.123.009	2303573-6	25863.213.111
2303573-2	25863.123.003	2303573-7	25863.201.178
2303573-3	25863.213.179	2303573-8	25863.160.009
2303573-4	25863.411.131	2303573-9	25863.123.179
2303573-5	25863.213.178	1-2303573-0	25863.123.178

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
(2) 0.35mm ² +0.75 mm ²	1.50+/-0.05 [.059+/- .002]	5.3
0.35mm ² +1 mm ²	1.45+/-0.05 [.057+/- .002]	5.9
(2) 0.5 mm ²	1.40+/-0.05 [.055+/- .002]	6.4
1.00mm ²	1.35+/-0.05 [.053+/- .002]	6.9
(3) 0.35 mm ²	1.35+/-0.05 [.053+/- .002]	6.9
0.75mm ²	1.30+/-0.05 [.051+/- .002]	7.3



- 1. RECOMMENDED SPARE PARTS
- 2. REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- 3. 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.
- 4. TERMINAL LUBRICANT IS RECOMMENDED.
- 5. LOCATE ITEM 19 BETWEEN ITEMS 1 AND 5
- 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	REV	DATE	BY	APPV
A	66	-	-	-	-

QTY	REF	REF	DESCRIPTION	ITEM NO
-	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
-	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	1803516-1 RAM ASSEMBLY, SF PACIFIC	140
-	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	455888-5 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	1338685-1 PAWL, FEED	56
-	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
-	2	2	2079383-5 SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	1-2844962-5 SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	2844992-7 ASSEMBLY, STRIP GUIDE	29
-	1	1	1803078-2 SPACER, PRECISION	28
-	1	1	1-1320928-0 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	2119533-2 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	1803095-5 FLOATING SHEAR, FRONT	9
-	1	1	7-1633933-8 ANVIL, COMBINATION	8
-	-	-	-	7
-	-	-	-	6
-	1	1	2119757-6 DEPRESSOR, SHEAR	5
-	-	-	-	4
-	-	-	-	3
-	-	-	-	2
-	1	1	4-1803241-9 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)

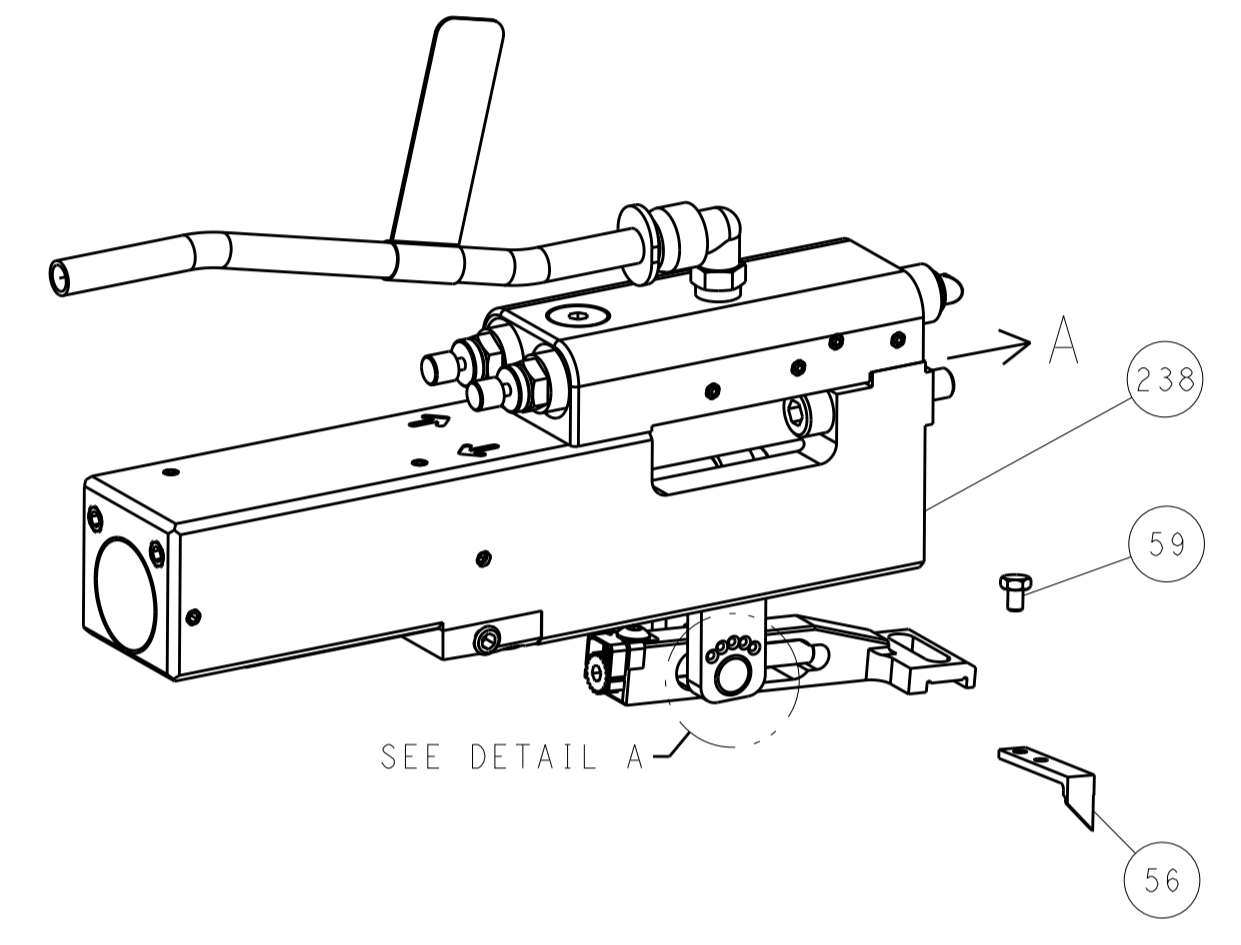
<small>THIS DRAWING IS CONTROLLED DOCUMENT AND IS THE PROPERTY OF STE CONNECTIVITY. IT IS SUBJECT TO CHANGE AND WITHOUT NOTICE. ANY REVISIONS OR MODIFICATIONS SHALL BE CONTACTED FOR THE LATEST VERSION.</small>		DWN: B. WEAVER 06JUN2016 CHK: T. ELBIN 06JUN2016 APVD: T. ELBIN 06JUN2016	TE Connectivity 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 SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2836310 RESTRICTED TO: -
MATERIAL: - FINISH: -		WEIGHT: - SCALE: 1:2 SHEET: 3 OF 4 REV: C	Customer Accessible Production Drawing

LOC	DIST	REV	DATE	BY	APPV
A	66				

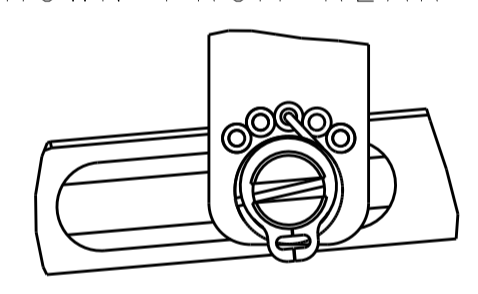
FEED TYPE MECHANICAL



PNEUMATIC

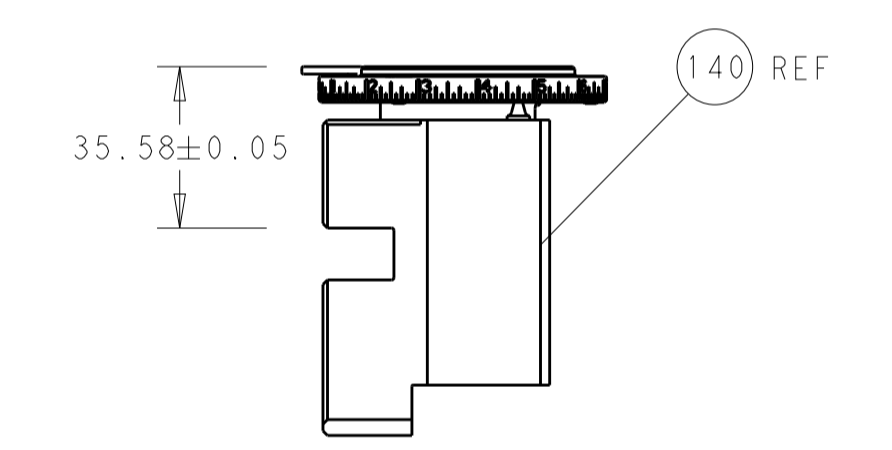
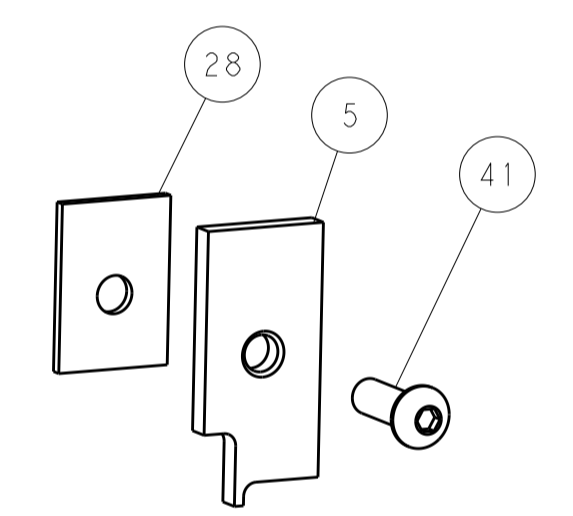
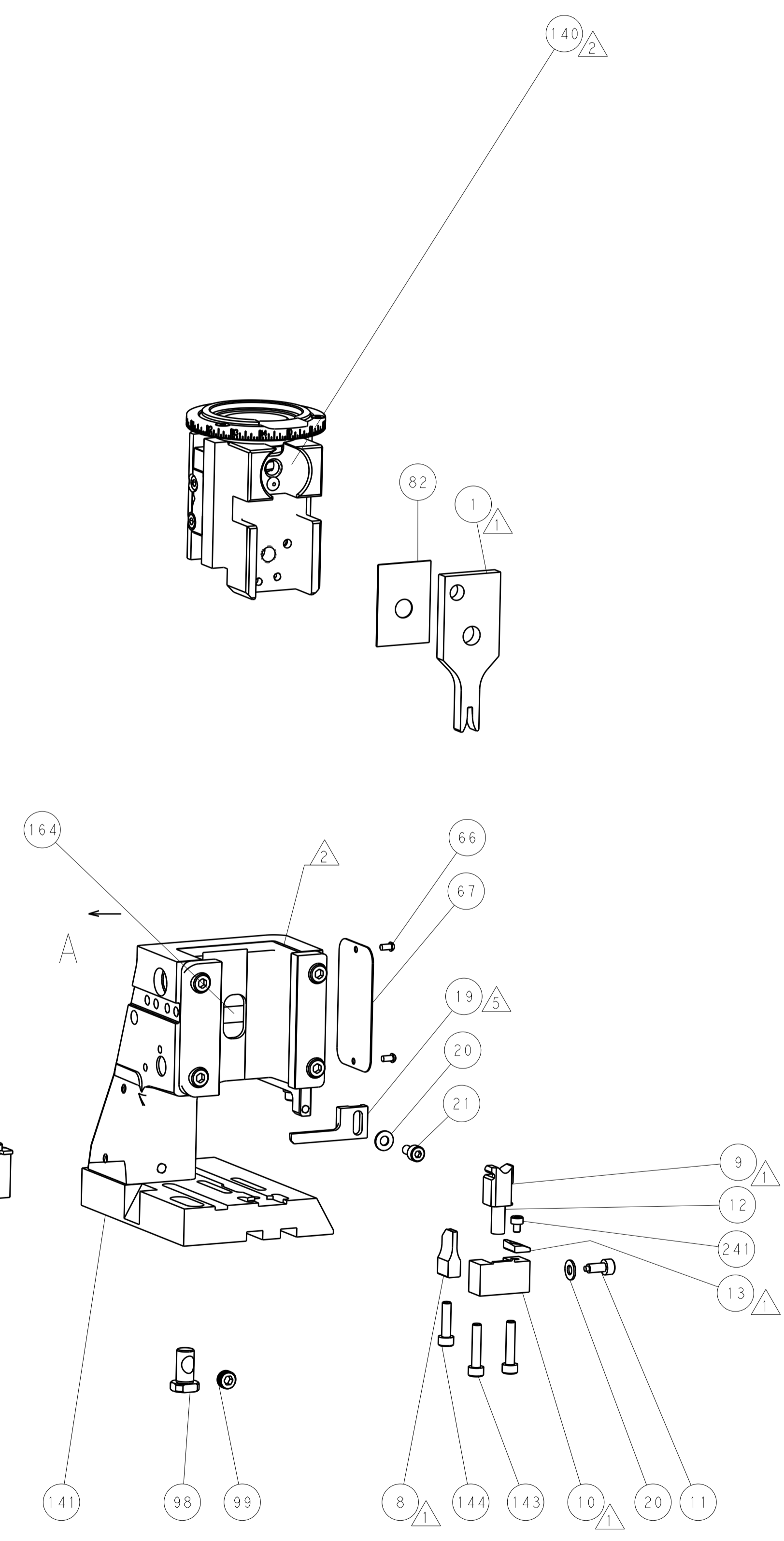
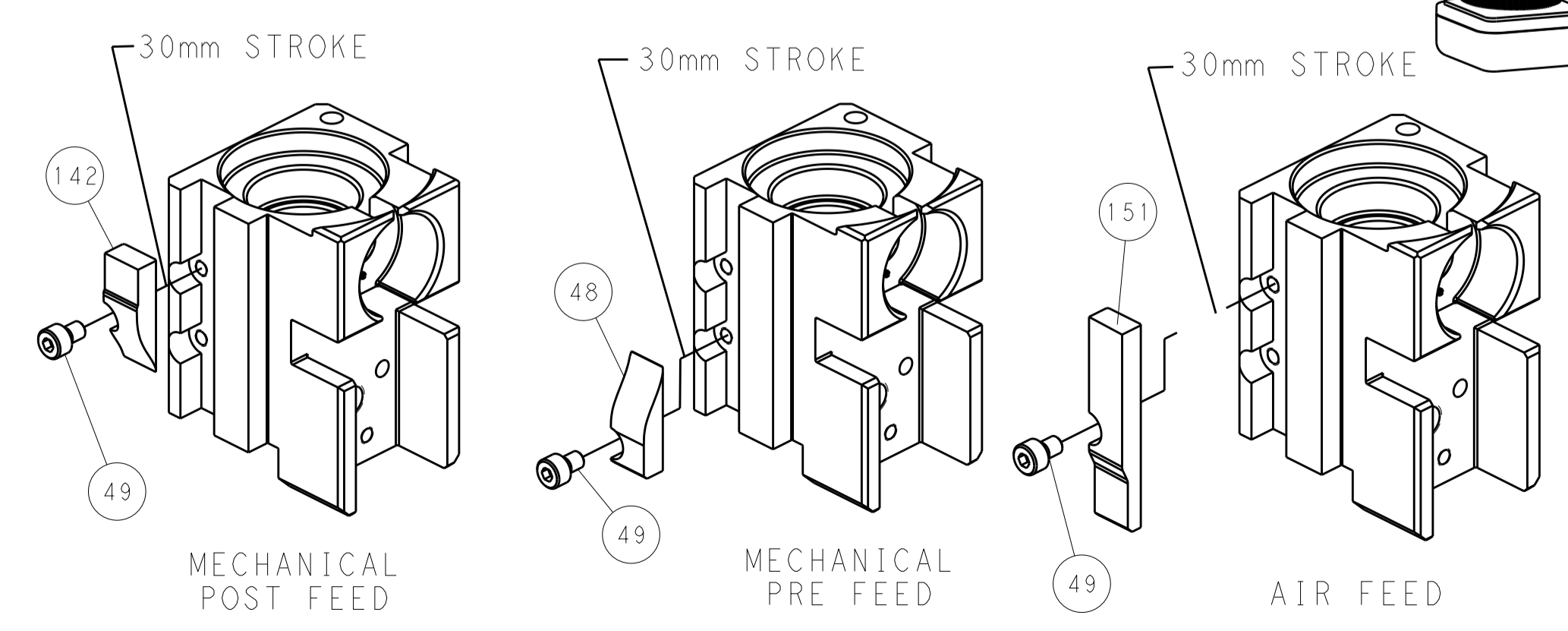


FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)

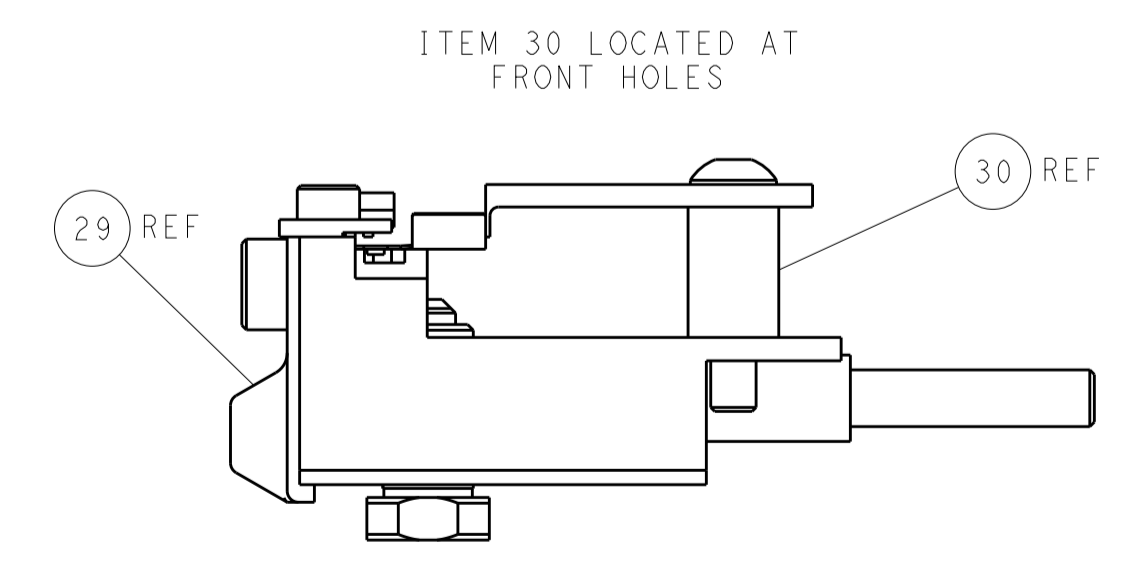


DETAIL A

CAM POSITIONS



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)

DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		DWN B. WEAVER 06JUN2016 CHK T. ELBIN 06JUN2016 APVD T. ELBIN 06JUN2016		NAME Ocean Side Feed Applicator	
MATERIAL:		FINISH:		WEIGHT:		SIZE: CAGE CODE DRAWING NO. RESTRICTED TO A1 00779 C=2836310	
Customer Accessible Production Drawing				SCALE: 1:2		SHEET 4 OF 4 REV C	