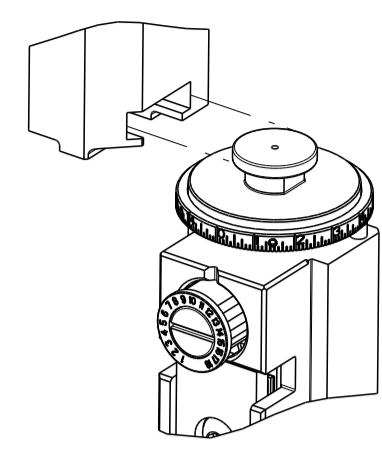


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2836024-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2836024-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2836024-1	B	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2836024-2	B	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2836024-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



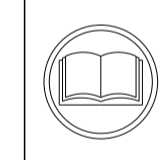
APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.00 mm [.079]	F
INSUL	3.80 mm [.150]	O

APPLICATOR INSTRUCTIONS
408-35042

TERMINAL DATA: FCI/DELPHI TERMINAL DELPHI CRIMP SPECIFICATION	
TERMINAL NAME: TERMINAL, 2.8mm FEMALE	
WIRE STRIP LENGTH 3.60-4.20 mm [.142-.165 IN]	INSULATION DIAMETER RANGE Ø
TERMINAL APPLICATION SPECIFICATION 9 084 13 00 Rev D	

TE TERMINAL	FCI/DELPHI TERMINAL	TE SEAL	FCI/DELPHI SEAL	CABLE DIAMETER
2113872-1	60013731	2113590-1	60994015	Ø1.2-2.0
2113872-2	60013734	2113590-2	10779162	Ø1.2-2.0

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.00mm2	1.30 +/- 0.04 [.051 +/- .002]	9.0
0.75mm2	1.26 +/- 0.04 [.050 +/- .002]	9.5
0.50mm2	1.20 +/- 0.04 [.047 +/- .002]	10.2



- 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. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- 6 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.

***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
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		B		ECR-20-018178	30DEC2020	TB	RR

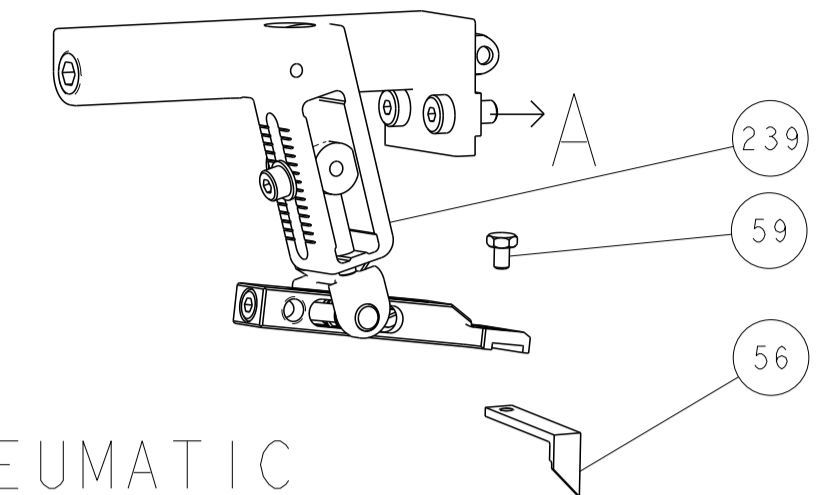
-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248
-	1	1	1	1	2119082-3	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
3	-	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	1	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
-	-	1	-	-	2119580-1	MECHANICAL FEED ASSEMBLY	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
6	-	1	1	1	985575-3	SCR, FLT SKT HD CAP M3 X 10.0	57
-	1	1	1	1	1338683-8	FEED PAWL	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	3-2844962-2	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	1	1	2844992-4	ASSEMBLY, STRIP GUIDE	29
-	1	1	1	1	455888-3	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	1803095-1	FLOATING SHEAR, FRONT	9
1	1	2	2	1	1-1803252-2	ANVIL, COMBINATION	8
-	-	-	-	-	-	-	7
-	-	-	-	-	-	-	6
-	1	1	1	1	2-2119781-4	DEPRESSOR, SHEAR	5
-	1	1	1	1	238011-4	BLOCK, CRIMPER SPACER	4
1	1	2	2	1	9-1633965-4	CRIMPER, INSULATION O PREMIUM	3
-	1	1	1	1	455888-6	SPACER, CRIMPER	2
1	1	2	2	1	4-1633664-2	CRIMPER, WIRE	1
-	77	-72	-71	-2	-1	PART NO	ITEM NO

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

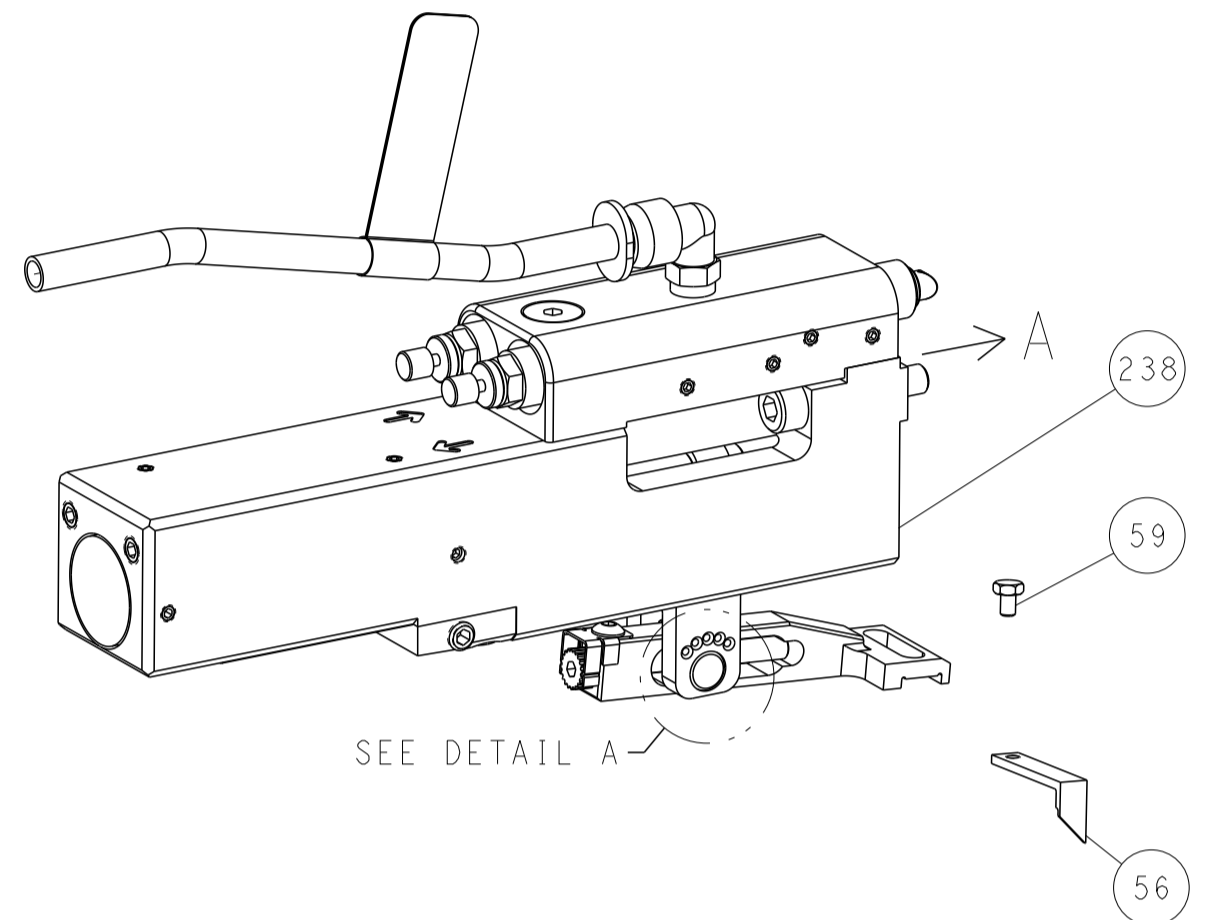
OWN: B. WEAVER 06OCT2015	CHK: T. ELBIN 06OCT2015	APVD: T. ELBIN 06OCT2015	NAME: Ocean Side Feed Applicator
SIZE: A1	CAGE CODE: 00779	DRAWING NO: C=2836024	RESTRICTED TO: B
Customer Accessible Production Drawing			SCALE: 1:2 SHEET 1 OF 4 REV B

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

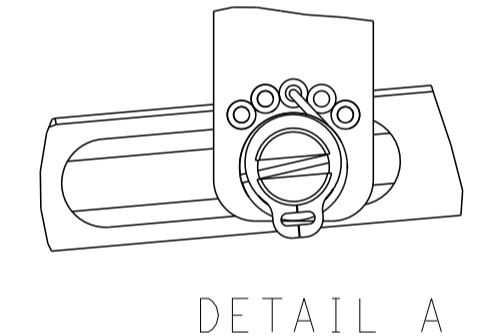
FEED TYPE MECHANICAL



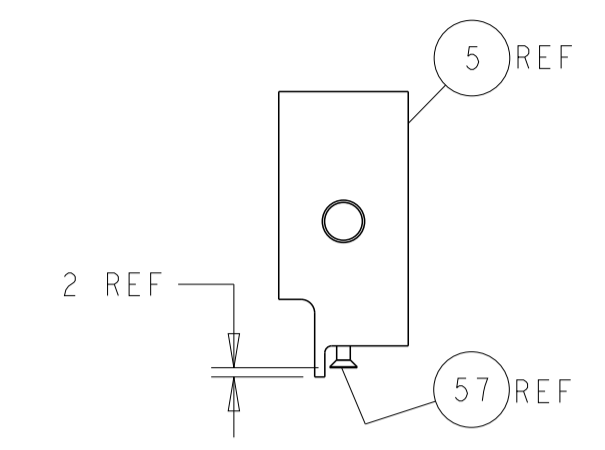
PNEUMATIC



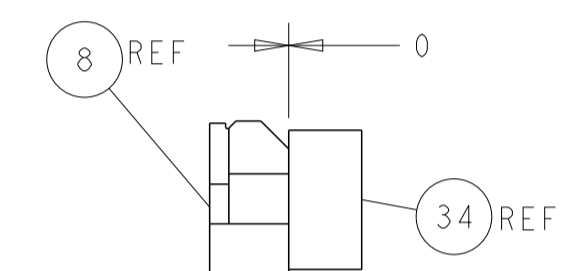
FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



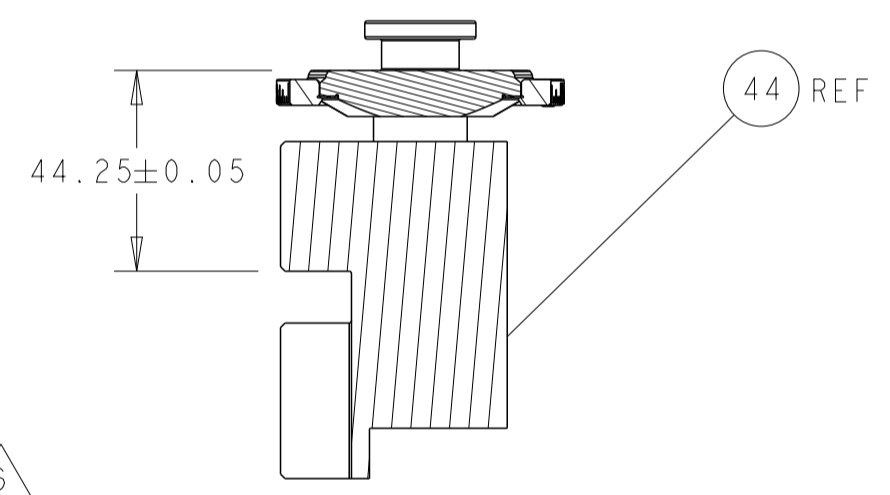
DETAIL A



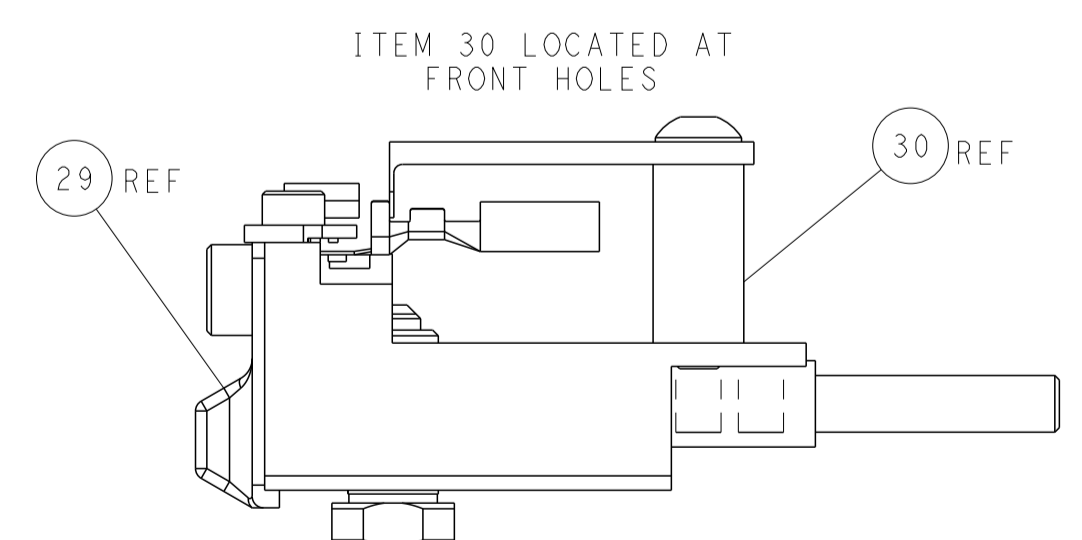
SHEAR DEPRESSOR DETAIL



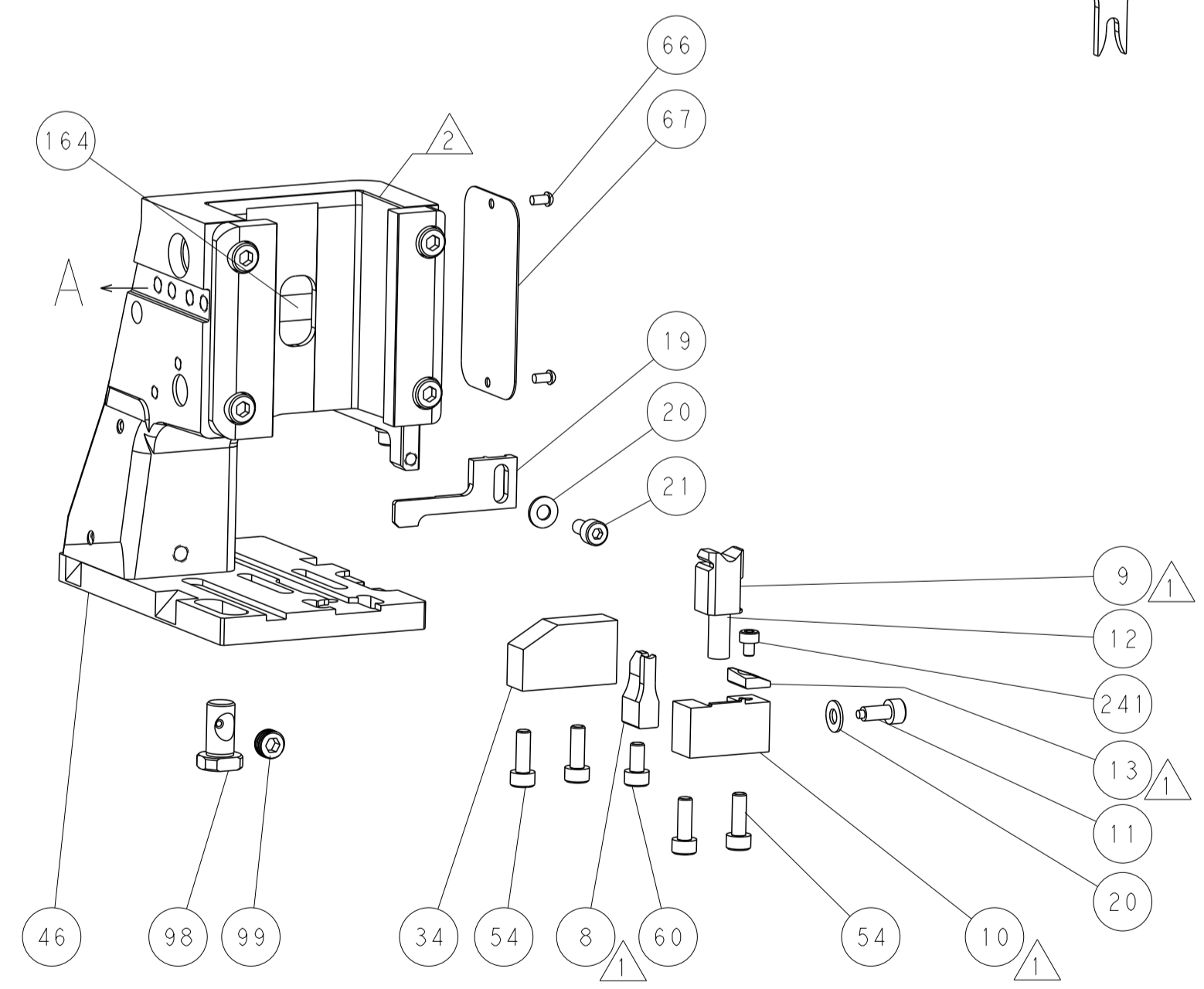
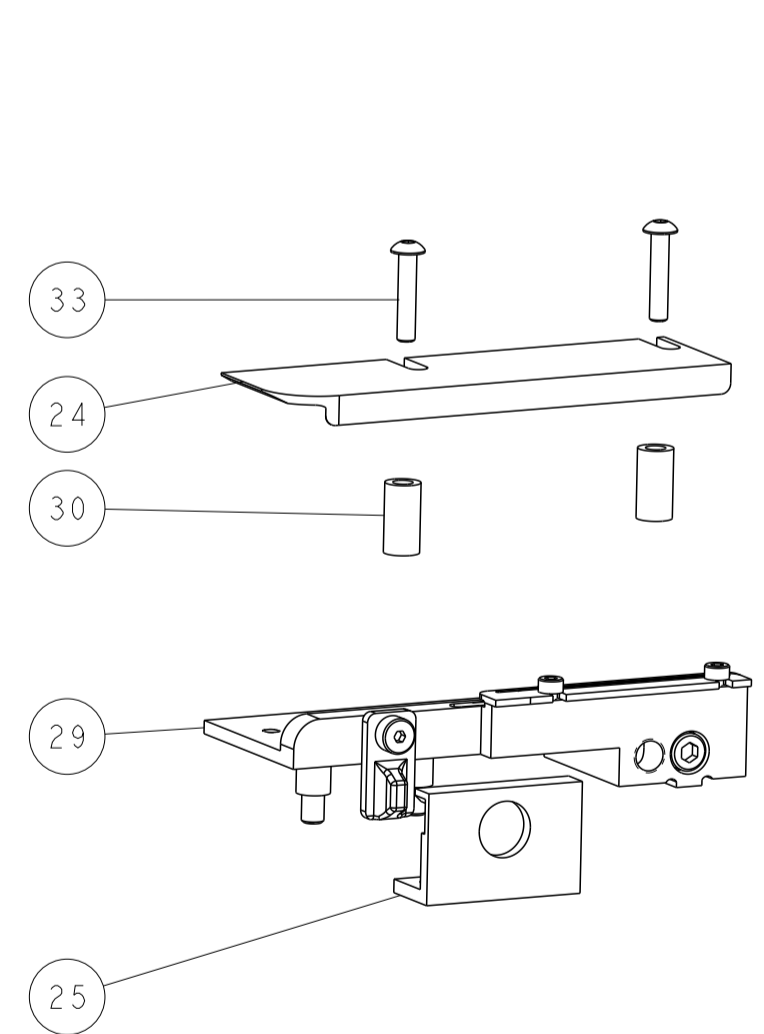
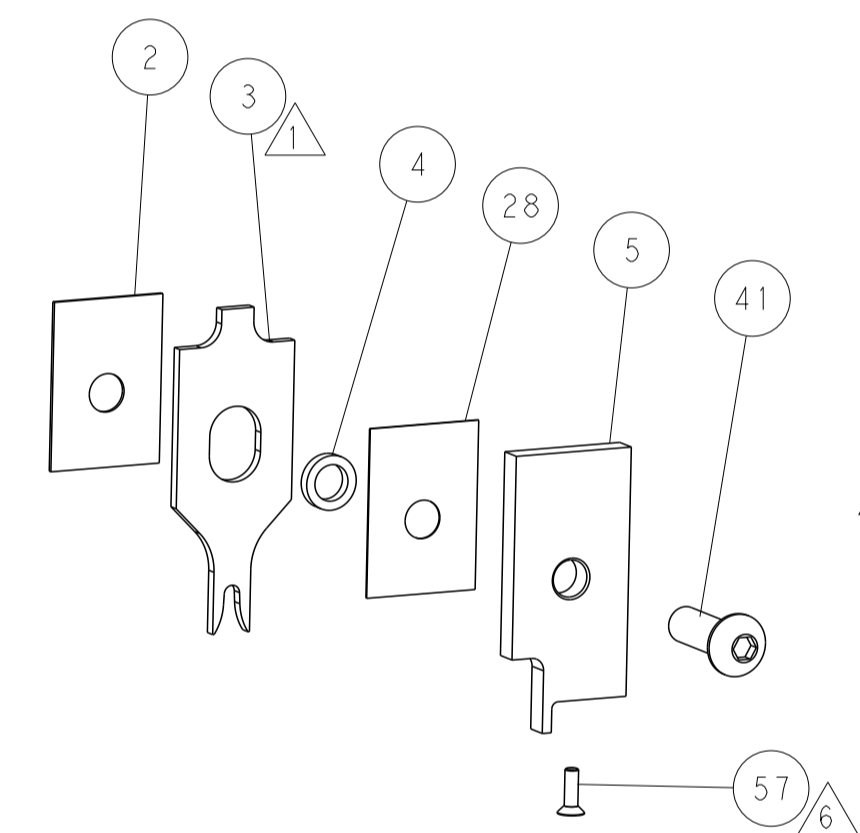
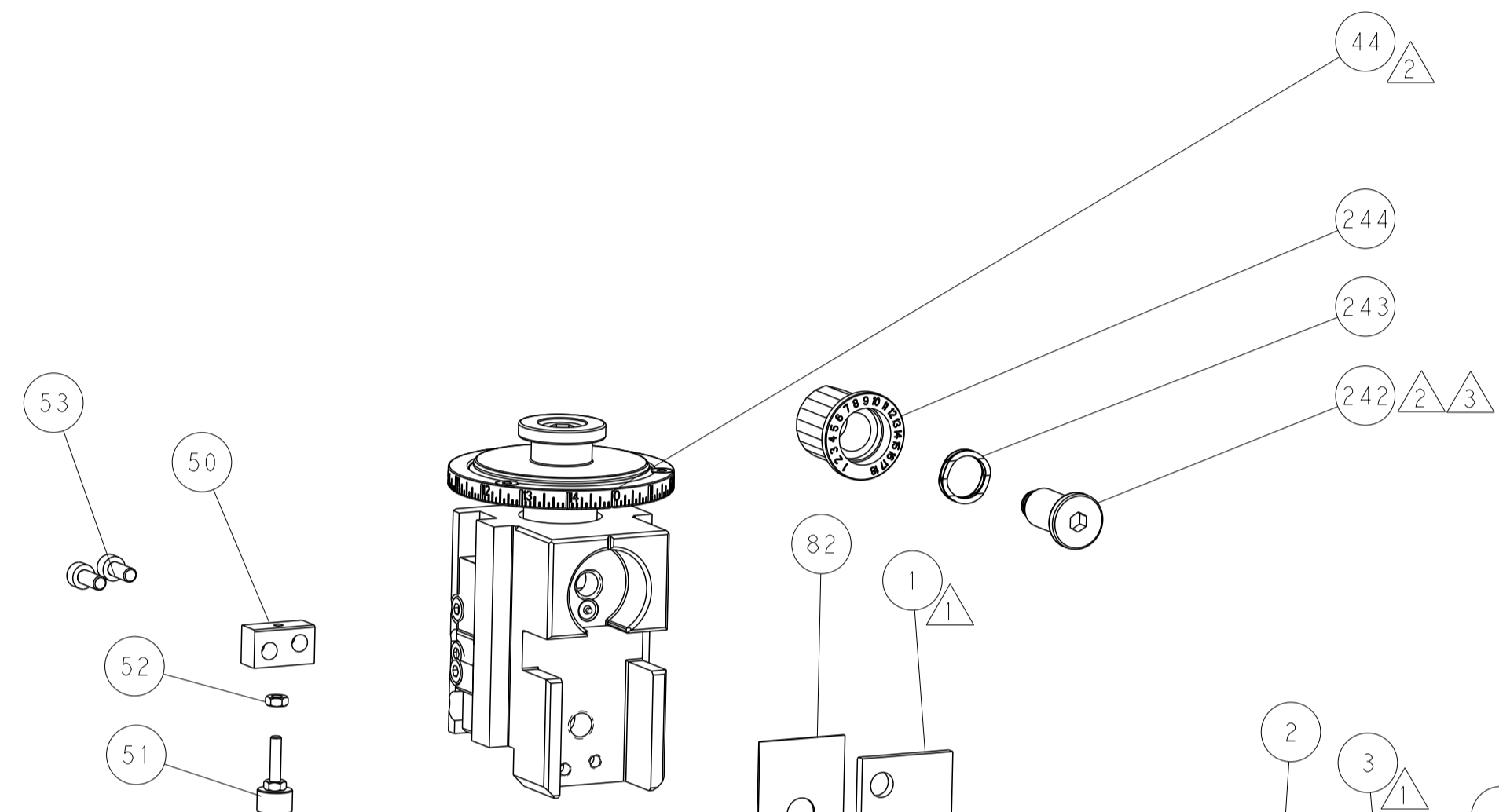
TERMINAL SUPPORT LOCATION



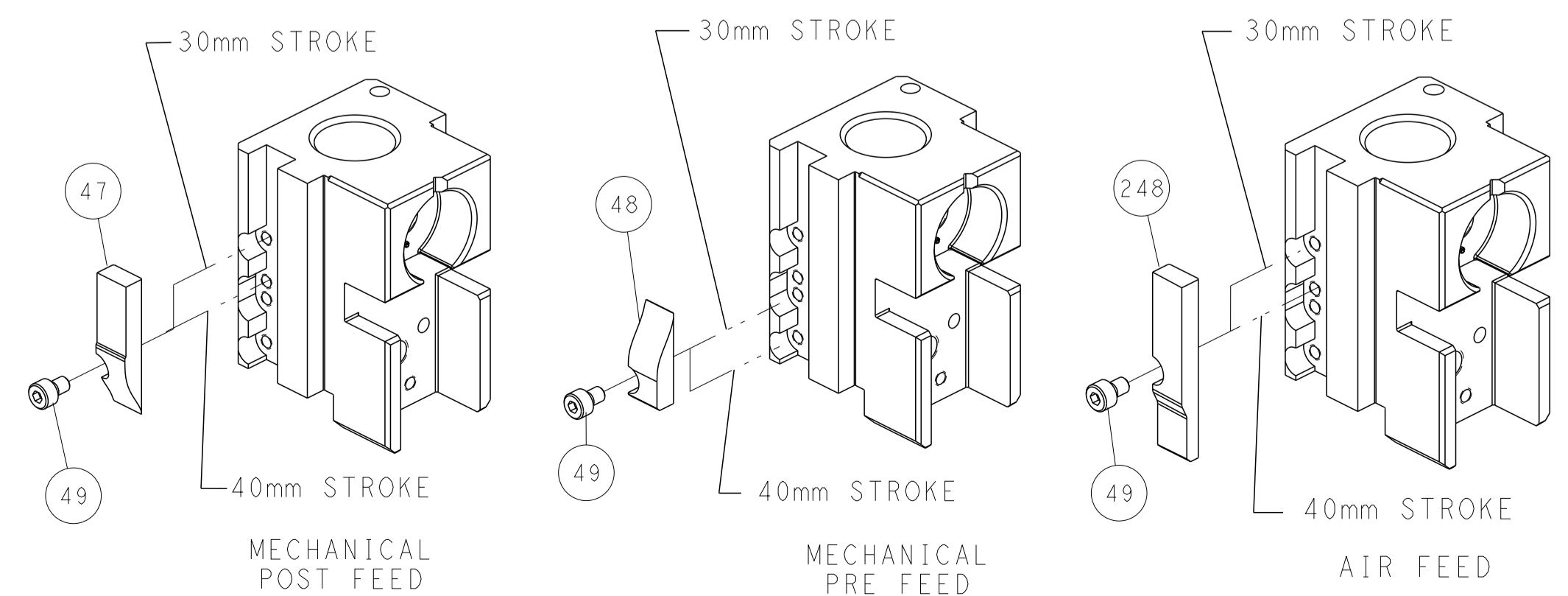
RAM SET-UP



FEED TRACK POSITION GUIDE BY INSULATION BARREL



CAM POSITIONS

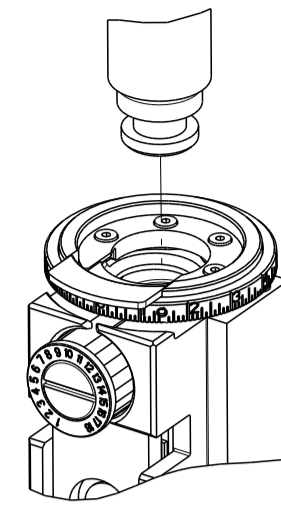


ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH		DWN B. WEAVER 06OCT2015 CHK T. ELBIN 06OCT2015 APVD T. ELBIN 06OCT2015 PRODUCT SPEC APPLICATION SPEC WEIGHT Customer Accessible Production Drawing	NAME Ocean Side Feed Applicator SIZE CAGE CODE DRAWING NO. RESTRICTED TO A1 00779 ©=2836024 2 OF 4 REV B
MATERIAL:		SCALE 1:2	SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2836024-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2836024-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2836024-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.00 mm [.079]	F
INSUL	3.80 mm [.150]	O

APPLICATOR INSTRUCTIONS
408-35042

TERMINAL DATA: FCI/DELPHI TERMINAL DELPHI CRIMP SPECIFICATION	
TERMINAL NAME: TERMINAL, 2.8mm FEMALE	
WIRE STRIP LENGTH 3.60-4.20 mm [1.42-.165 IN]	INSULATION DIAMETER RANGE Ø
TERMINAL APPLICATION SPECIFICATION 9 084 13 00 Rev D	
TERMINALS APPLIED	
TE TERMINAL	FCI/DELPHI TERMINAL
2113872-1	60013731
2113872-2	60013734
TE SEAL	FCI/DELPHI SEAL
2113590-1	60994015
2113590-2	10779162
CABLE DIAMETER	Ø1.2-2.0

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.00mm2	1.30+/-0.04 [0.051+/-0.002]	9.0
0.75mm2	1.26+/-0.04 [0.050+/-0.002]	9.5
0.50mm2	1.20+/-0.04 [0.047+/-0.002]	10.2

- 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.
- UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- 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.

***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				

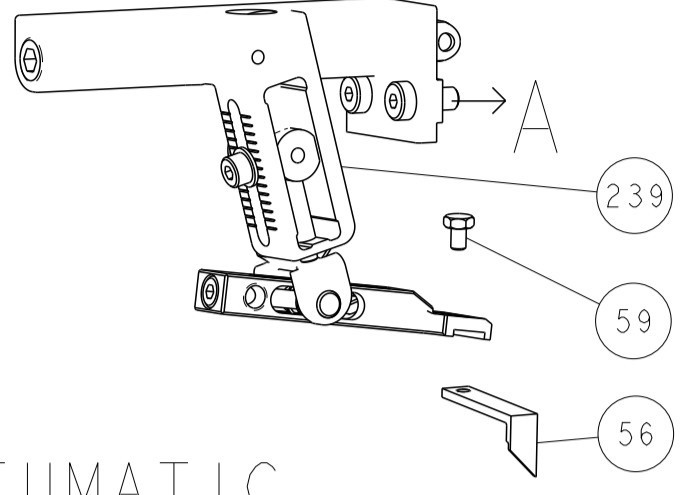
REV	DATE	BY	APPV	DESCRIPTION	ITEM NO	
-	1	1		2119082-3	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1		2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1		2119083-1	RETAINER, INSULATION DIAL	242
-	1	1		7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
-	-	1		2119580-1	MECHANICAL FEED ASSEMBLY	239
-	1	-		2844940-1	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		1338683-8	FEED PAWL	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		3-2844962-2	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1		2844992-4	ASSEMBLY, STRIP GUIDE	29
-	1	1		455888-3	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		1803095-1	FLOATING SHEAR, FRONT	9
-	1	1		1-1803252-2	ANVIL, COMBINATION	8
-	-	-		-	-	7
-	-	-		-	-	6
-	1	1		2-2119781-4	DEPRESSOR, SHEAR	5
-	1	1		238011-4	BLOCK, CRIMPER SPACER	4
-	1	1		9-1633965-4	CRIMPER, INSULATION O PREMIUM	3
-	1	1		455888-6	SPACER, CRIMPER	2
-	1	1		4-1633664-2	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)

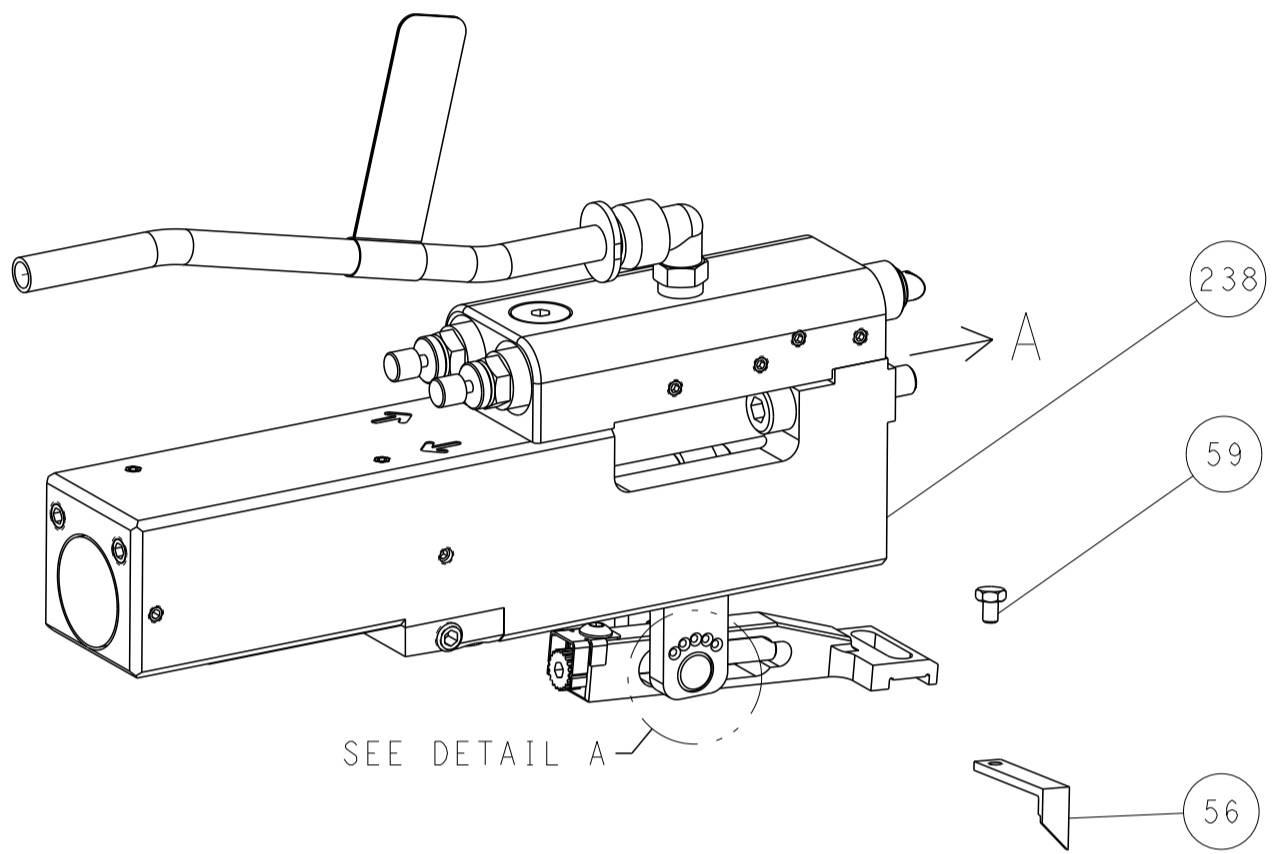
DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH		DWG: B. WEAVER 06OCT2015 CHK: T. ELBIN 06OCT2015 APVD: T. ELBIN 06OCT2015 PRODUCT SPEC APPLICATION SPEC WEIGHT: - SCALE: 1:2 SHEET 3 OF 4 REV B		NAME: Ocean Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2836024 RESTRICTED TO: -	
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LOC	DIST	REVISIONS					
A	66	P	LTN	DESCRIPTION	DATE	OWN	APVD
		-		SEE SHEET 1	-	-	-

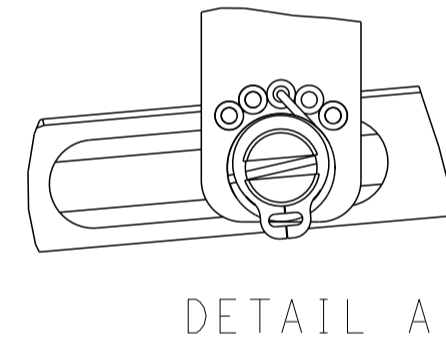
FEED TYPE MECHANICAL



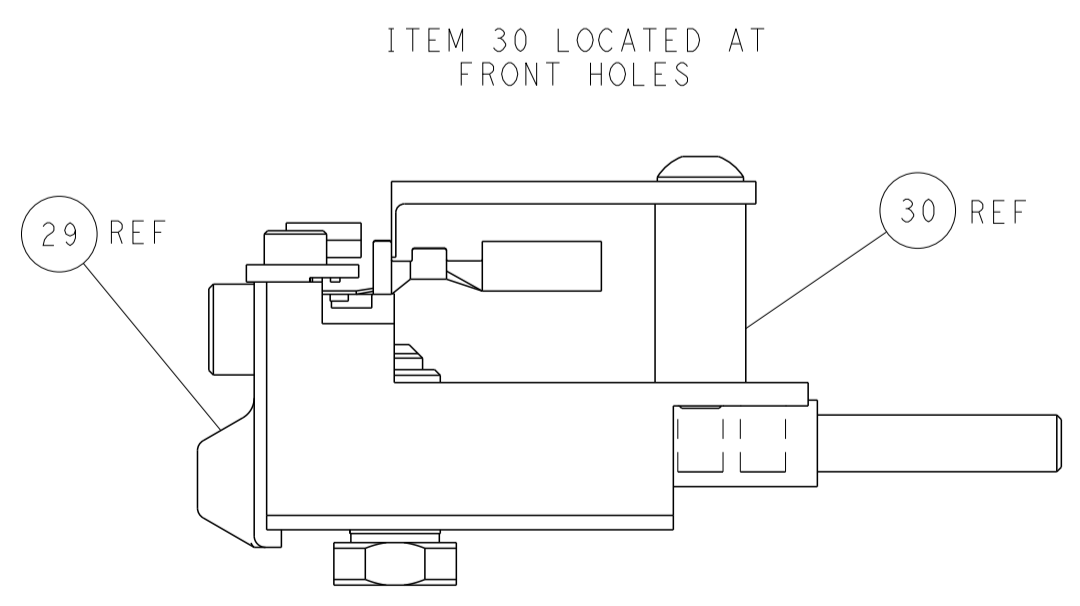
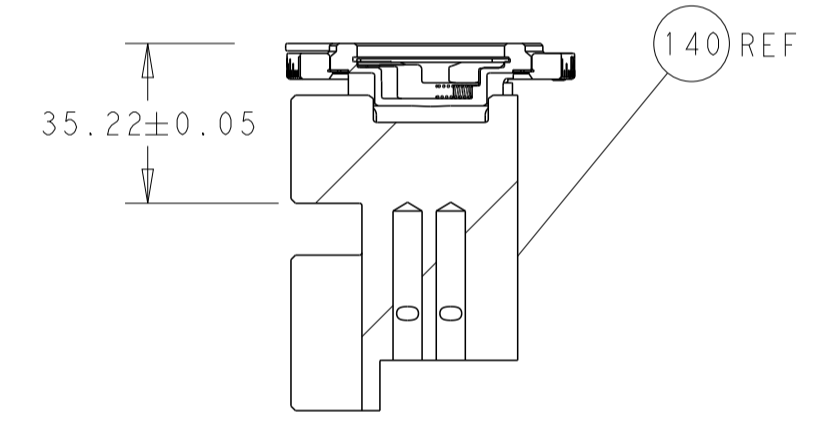
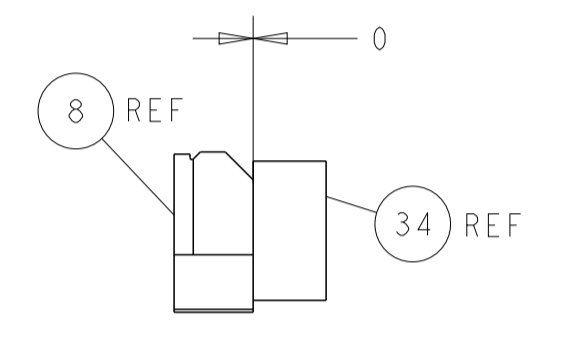
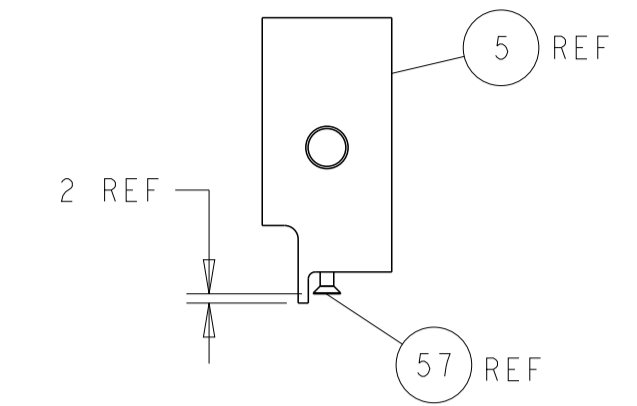
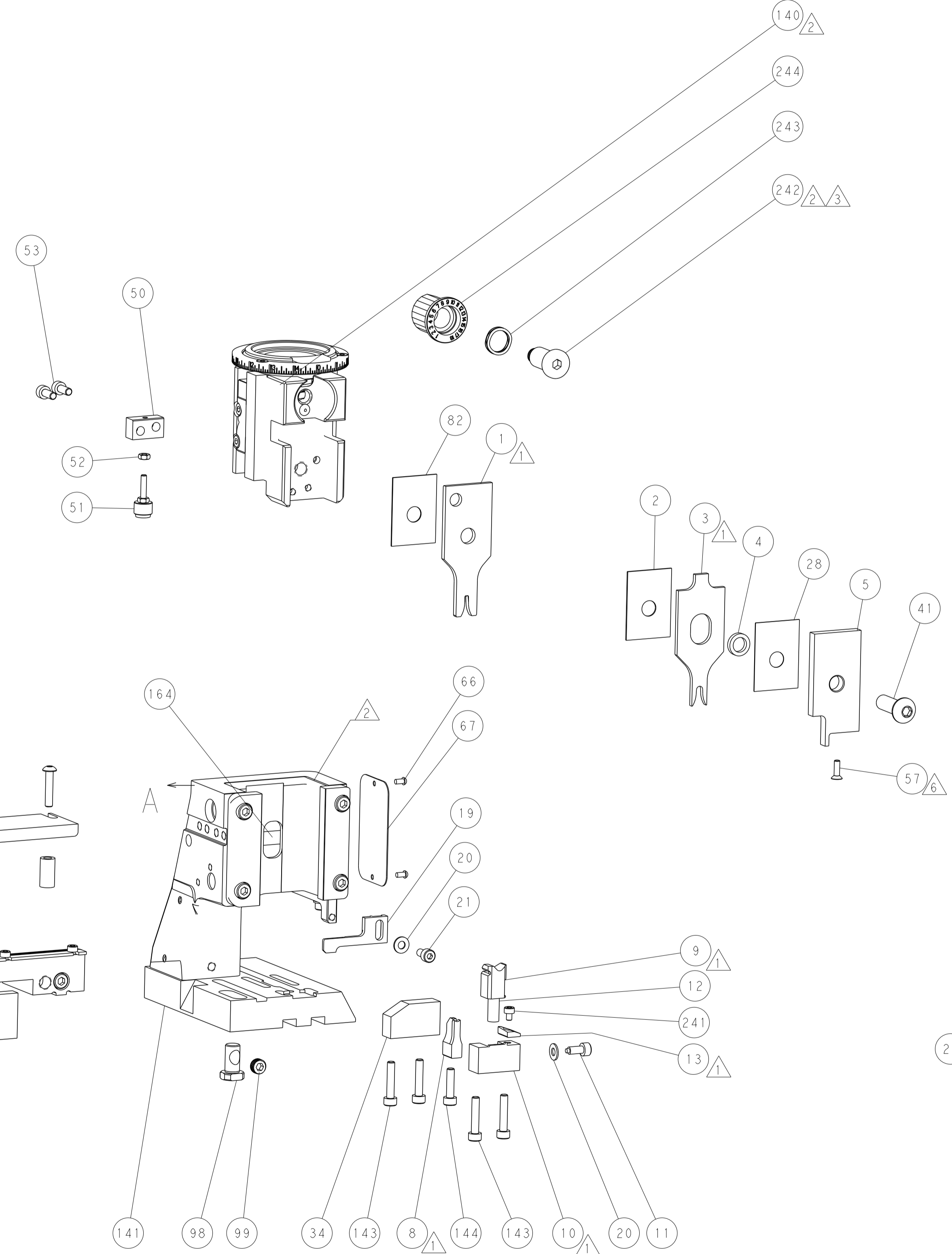
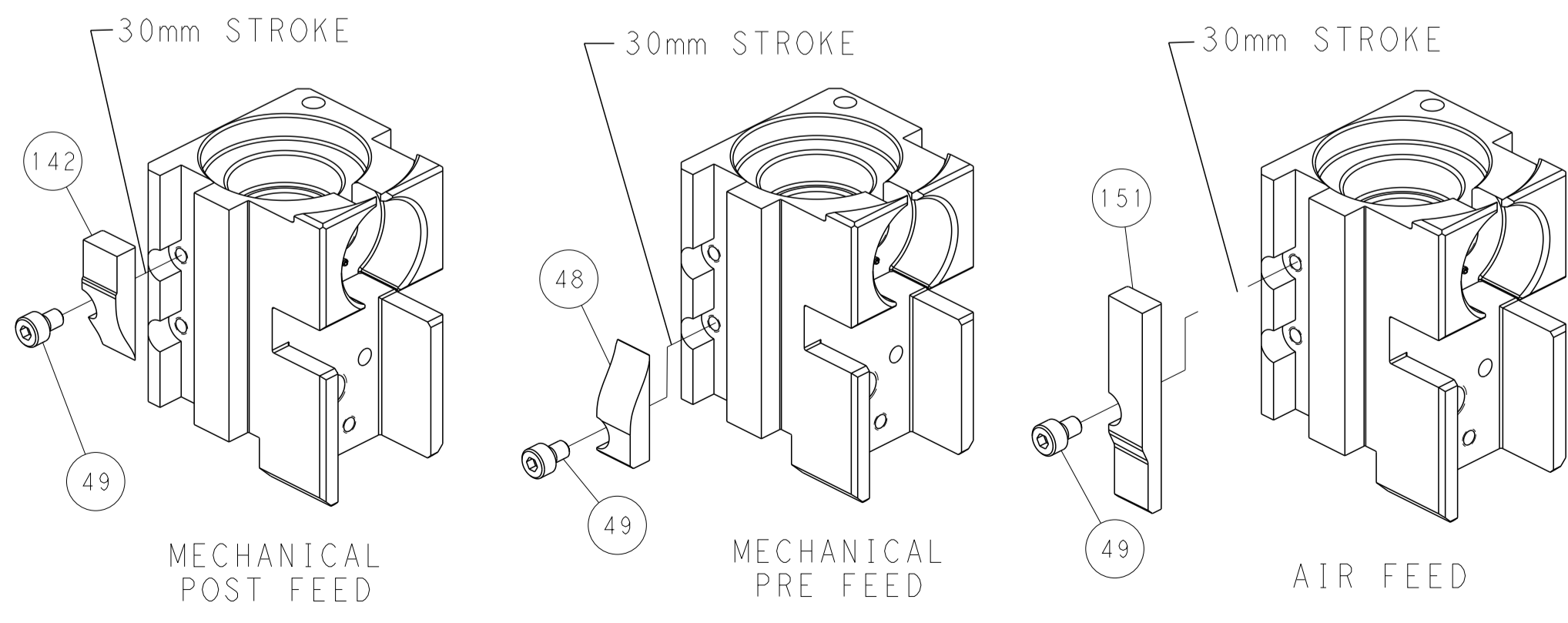
PNEUMATIC



FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



CAM POSITIONS



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 ± FINISH		DWN B. WEAVER 06OCT2015 CHK T. ELBIN 06OCT2015 APVD T. ELBIN 06OCT2015 PRODUCT SPEC APPLICATION SPEC WEIGHT Customer Accessible Production Drawing		NAME Ocean Side Feed Applicator SIZE CAGE CODE DRAWING NO A1 00779 C=2836024 SCALE 1:2 SHEET 4 OF 4 REV B		RESTRICTED TO -	
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