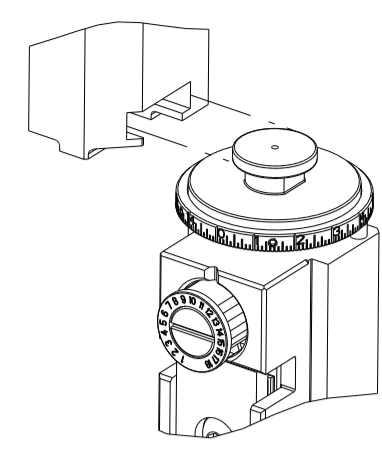


| PART NUMBER | REVISION | DESCRIPTION | FEED TYPE |
|-------------|----------|---------------------------------|-----------|
| 2836055-2 | C | FINE CRIMP HEIGHT ADJUST | PNEUMATIC |
| 7-2836055-2 | C | PNEUMATIC AND CRIMP TOOLING KIT | PNEUMATIC |
| 7-2836055-7 | A | CRIMP TOOLING KIT | - |

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



| APPLICATOR DATA | | |
|-----------------|----------------|------|
| CRIMP | SIZE | TYPE |
| WIRE | 4.20 mm [.165] | F |
| INSUL | 6.20 mm [.244] | OV |

APPLICATOR INSTRUCTIONS 408-35042

| TERMINAL DATA: TE TERMINAL | | TE CRIMP SPECIFICATION | |
|------------------------------------|-----------|---------------------------|---|
| TERMINAL NAME: TERMINAL | | | |
| WIRE STRIP LENGTH | | INSULATION DIAMETER RANGE | |
| 6.10-6.86 mm [.240-.270 IN] | | ∅ | |
| TERMINAL APPLICATION SPECIFICATION | 114-15108 | - | - |

| TERMINALS APPLIED | | | | SEAL INSULATION DIAMETER RANGE |
|-------------------|-------------|-----------|---------|--------------------------------|
| TE TERMINAL | TE TERMINAL | TE SEAL | TE SEAL | ∅ 2.65-4.00 mm |
| 1544967-1 | 1544967-2 | 1544970-1 | | |

| WIRE SIZE | CRIMP HEIGHT mm [INCH] | CRIMP HEIGHT REFERENCE SETTING |
|-----------|-------------------------------|--------------------------------|
| 4.00mm2 | 2.09 +/- 0.05 [.082 +/- .002] | 5.5 |
| 3.00mm2 | 2.00 +/- 0.05 [.079 +/- .002] | 6.6 |
| 2.50mm2 | 1.76 +/- 0.05 [.069 +/- .002] | 9.0 |

- 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. TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- 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.
- 7. CUT TO LENGTH AT ASSEMBLY.
- 8. 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 |
| | | A | | RELEASED | 07JUN2016 | MR | TE |
| | | B | | ECR-19-017778 | 18NOV2019 | FJ | TE |
| | | C | | ECR-21-115787 | 30SEP2021 | TB | RK |

| | | | | | |
|---|-----|-----|-------------|-------------------------------------|-----|
| - | 2 | 2 | 2168083-1 | SCR, SKT HD CAP, RoHS, M3 X 8.0 | 269 |
| - | 1 | 1 | 1633782-6 | FENCE | 267 |
| - | 1 | 1 | 1803078-5 | SPACER, PRECISION | 259 |
| - | 1 | 1 | 2119641-1 | FEED CAM, AIR FEED | 248 |
| - | 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 | 1 | 2844940-5 | AIR FEED MODULE | 238 |
| - | REF | REF | 994970-2 | COUNTER, MAGNETIC | 164 |
| - | 1 | 1 | 2844908-1 | SCREW, LOCKING | 99 |
| - | 1 | 1 | 2844907-1 | POST, LOCKING | 98 |
| - | 1 | 1 | 1-690438-0 | FRONT STRIP GUIDE | 96 |
| - | 1 | 1 | 318563-1 | GUARD, FRONT CHIP | 89 |
| - | 1 | 1 | 455888-8 | SPACER, CRIMPER | 82 |
| - | 2 | 2 | 2079383-4 | SCR, BHSC, RoHS (M4 X 8) | 79 |
| - | 1 | 1 | 1803096-1 | EXTENSION PLATE | 78 |
| - | 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 | 2168083-2 | SCR, SKT HD CAP, RoHS, M4 X 8.0 | 60 |
| - | 1 | 1 | 5-18022-5 | SCR, HEX HD CAP, M4 X 6.0 | 59 |
| - | 1 | 1 | 1-2168083-3 | SCR, SKT HD CAP, RoHS, M3 X 16 | 57 |
| - | 1 | 1 | 1338683-8 | FEED PAWL | 56 |
| - | 4 | 4 | 2168083-3 | SCR, SKT HD CAP, RoHS, M4 X 12.0 | 54 |
| - | 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 | 1803382-6 | HOLD DOWN, SPRING LOADED | 50 |
| - | 1 | 1 | 18023-9 | SCR, SKT HD CAP M4 X 6.0 | 49 |
| - | 1 | 1 | 1-1803583-7 | APPLICATOR BASIC ASSEMBLY, SF | 46 |
| - | 1 | 1 | 1803515-2 | RAM ASSEMBLY, SF ATLANTIC | 44 |
| - | 1 | 1 | 1803602-2 | SCR, BHSC, RoHS (M8 X 40) | 41 |
| - | 1 | 1 | 1-1752356-9 | SUPPORT, TERMINAL | 34 |
| - | 2 | 2 | 2079383-5 | SCR, BHSC, RoHS (M4 X 20) | 33 |
| - | 2 | 2 | 2-2844962-6 | SPACER, CYLINDRICAL, STRIP GUIDE | 30 |
| - | 1 | 1 | 2844992-6 | ASSEMBLY, STRIP GUIDE | 29 |
| - | 1 | 1 | 1-455888-0 | SPACER, CRIMPER | 28 |
| - | 2 | 2 | 22283-1 | SPRING, COMPRESSION | 27 |
| - | 1 | 1 | 240792-1 | DRAG, TERMINAL | 25 |
| - | 1 | 1 | 1320928-4 | STRIP GUIDE | 24 |
| - | 1 | 1 | 2168083-2 | SCR, SKT HD CAP, RoHS, M4 X 8.0 | 21 |
| - | 1 | 1 | 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 | 2119805-7 | SHEAR HOLDER, FRONT | 10 |
| - | 1 | 1 | 318059-9 | FLOATING SHEAR, FRONT | 9 |
| 1 | 2 | 1 | 3-1803249-9 | ANVIL, COMBINATION | 8 |
| - | - | - | - | - | 7 |
| - | - | - | - | - | 6 |
| - | 1 | 1 | 1803080-1 | DEPRESSOR, SHEAR | 5 |
| - | 1 | 1 | 2-238011-4 | BLOCK, CRIMPER SPACER | 4 |
| 1 | 2 | 1 | 1803208-9 | CRIMPER, INSULATION OVERLAP PREMIUM | 3 |
| - | 1 | 1 | 1-455888-5 | SPACER, CRIMPER | 2 |
| 1 | 2 | 1 | 8-1633860-0 | CRIMPER, WIRE | 1 |

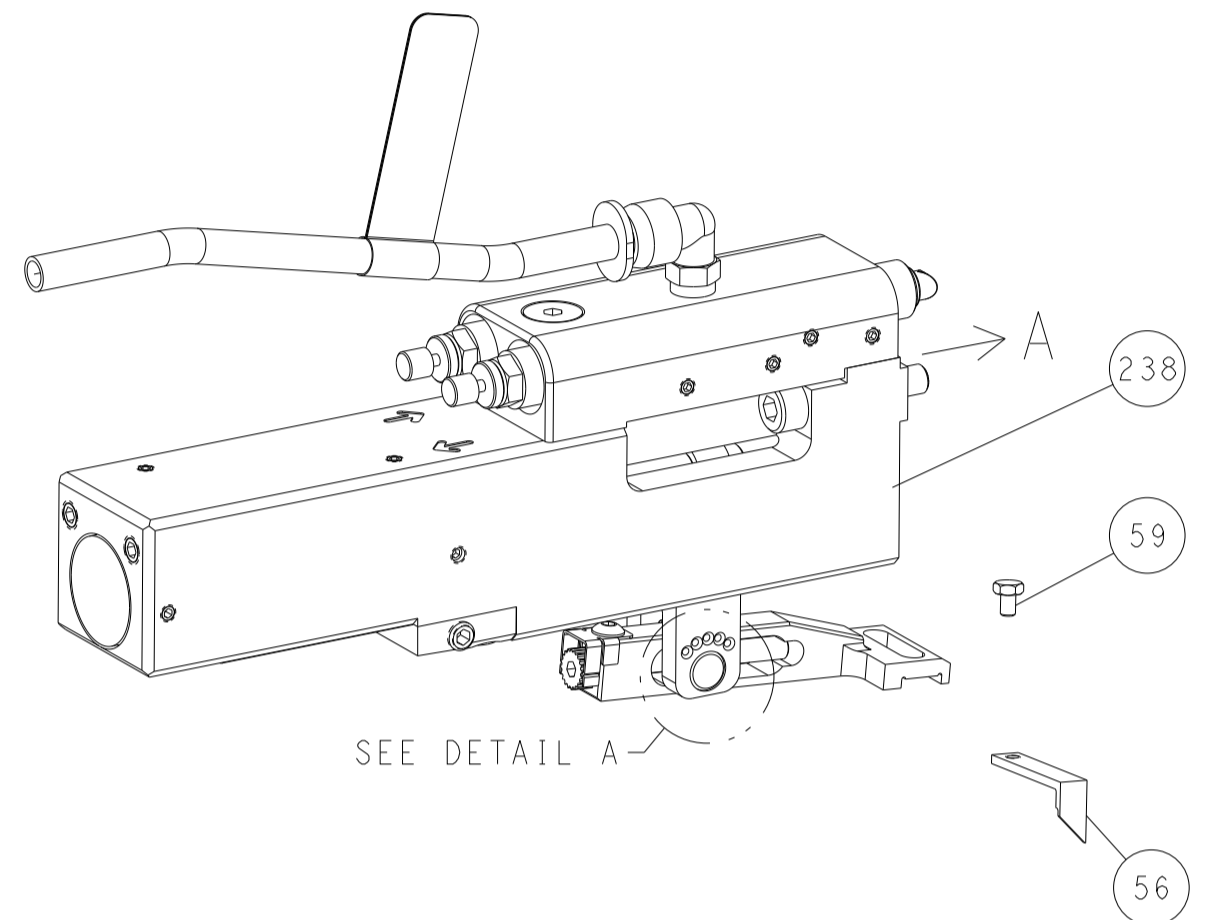
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|-------------|---------|--|---------|-----------|---------|---------|--------|---------|--|--------|-------|--------|---|------|--|
| mm | 0 PLC ± | 1 PLC ± | 2 PLC ± | 3 PLC ± | 4 PLC ± | ANGLES | FINISH | | | A | 00779 | 1 | 4 | C | |

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 | | | |
|-----|------|-------------|------|-----|------|
| P | LTN | DESCRIPTION | DATE | OWN | APVD |
| A | 66 | SEE SHEET 1 | - | - | - |

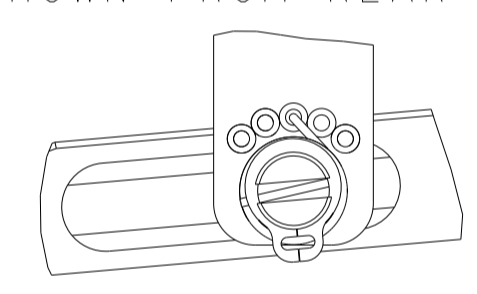
FEED TYPE

PNEUMATIC



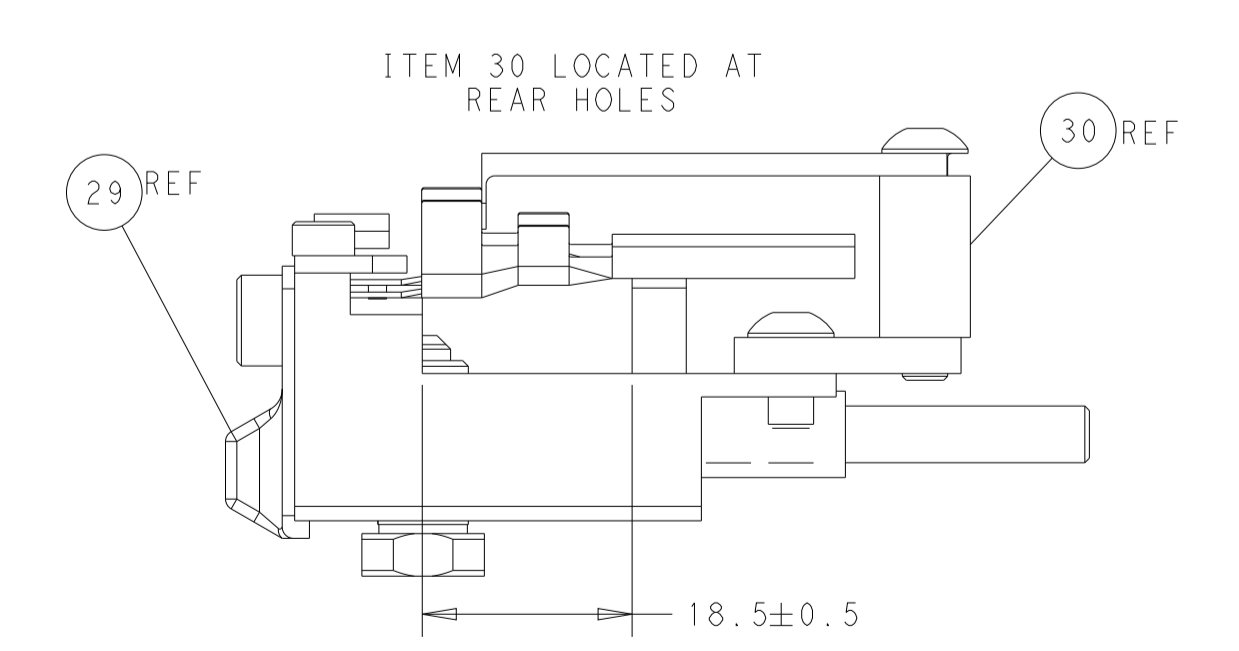
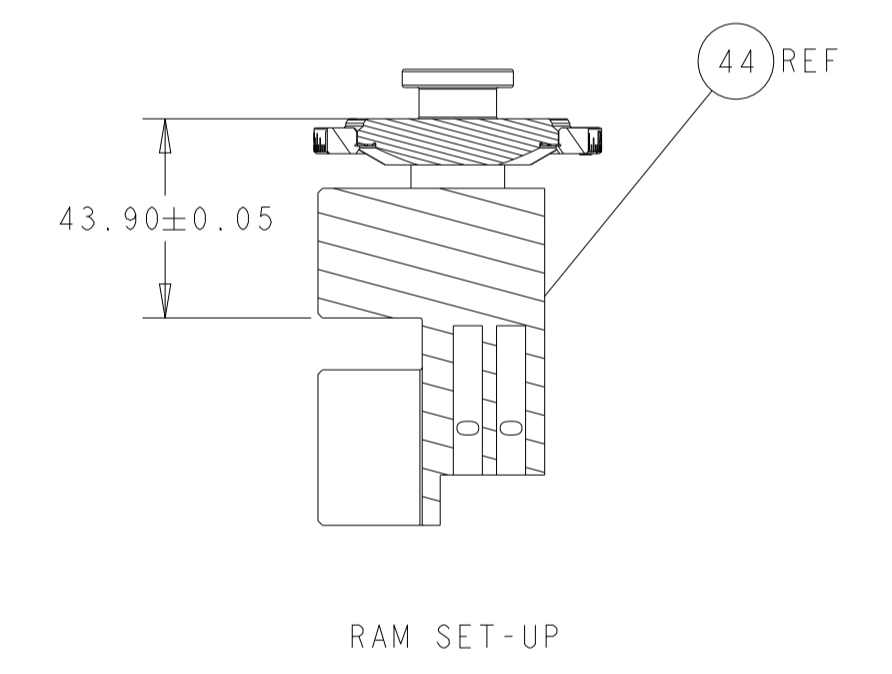
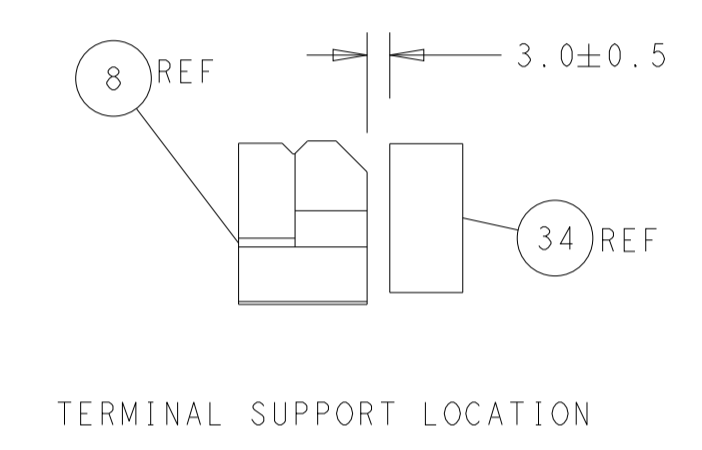
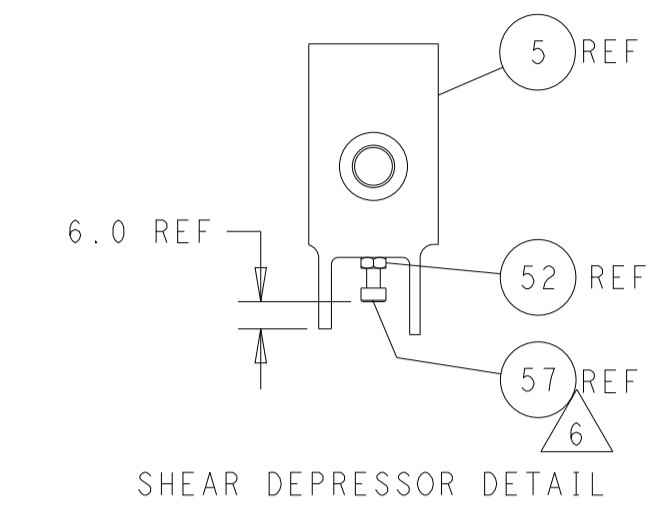
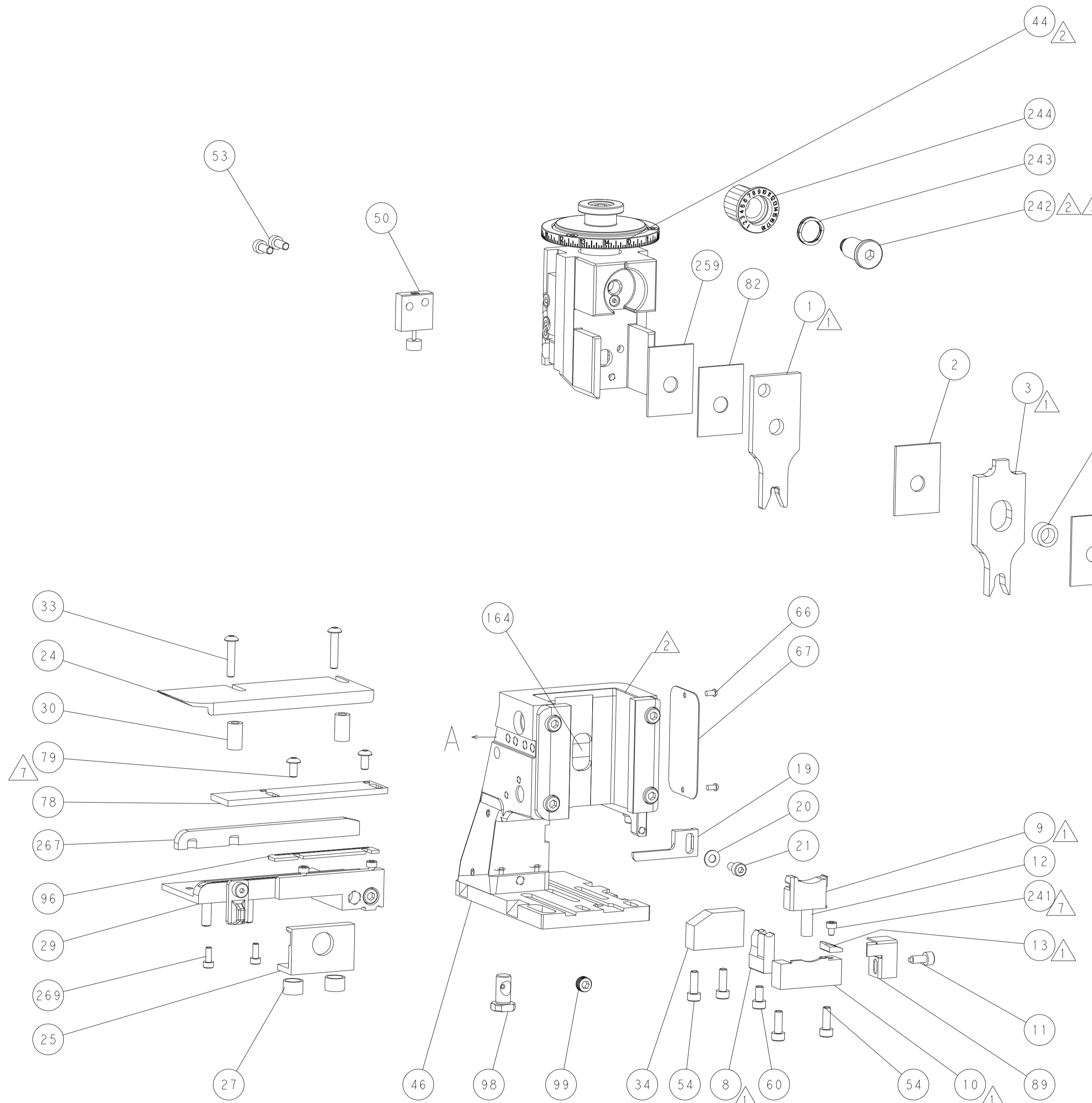
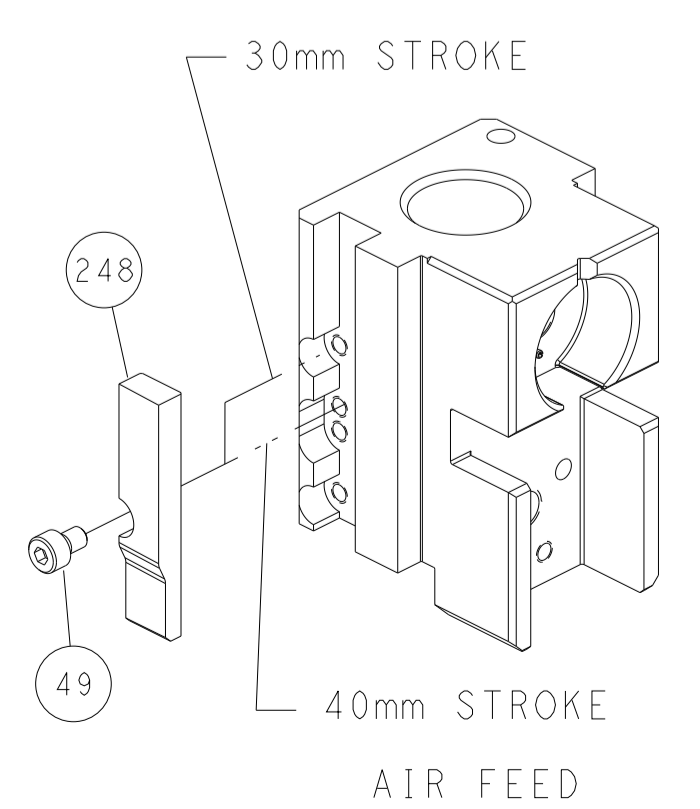
SEE DETAIL A

FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



DETAIL A

CAM POSITION



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: J. HOU 15APR2016 | TE Connectivity Harrisburg, PA 17105-3608 |
| mm | 0 PLC ± | 1 PLC ± | 2 PLC ± | CHK: L. ZHANG 15APR2016 | |
| MATERIAL: | FINISH: | 3 PLC ± | 4 PLC ± | APVD: L. ZHANG 15APR2016 | NAME: Ocean Side Feed Applicator |
| | | ANGLES ± | ANGLES ± | PRODUCT SPEC | |
| Customer Accessible Production Drawing | | SCALE: 1:2 | SHEET: 2 OF 4 | REV: C | RESTRICTED TO: |

| PART NUMBER | REVISION | DESCRIPTION | FEED TYPE |
|-------------|----------|--------------------------|-----------|
| 2-2836055-2 | C | FINE CRIMP HEIGHT ADJUST | PNEUMATIC |
| 7-2836055-7 | A | CRIMP TOOLING KIT | - |

PACIFIC VERSION TERMINATOR
 INTERFACE ADAPTER



| APPLICATOR DATA | | |
|-----------------|----------------|------|
| CRIMP | SIZE | TYPE |
| WIRE | 4.20 mm [1.65] | F |
| INSUL | 6.20 mm [2.44] | OV |

APPLICATOR INSTRUCTIONS
 408-35042

| TERMINAL DATA: TE TERMINAL | | TE CRIMP SPECIFICATION | |
|------------------------------------|-----------|---------------------------|---|
| TERMINAL NAME: TERMINAL | | | |
| WIRE STRIP LENGTH | | INSULATION DIAMETER RANGE | |
| 6.10-6.86 mm [2.40-.270 IN] | | ∅ | |
| TERMINAL APPLICATION SPECIFICATION | 114-15108 | - | - |

| TERMINALS APPLIED | | | | SEAL INSULATION DIAMETER RANGE |
|-------------------|-------------|-----------|---------|--------------------------------|
| TE TERMINAL | TE TERMINAL | TE SEAL | TE SEAL | |
| 1544967-1 | 1544967-2 | 1544970-1 | | ∅2.65-4.00 mm |

| WIRE SIZE | CRIMP HEIGHT mm [INCH] | CRIMP HEIGHT REFERENCE SETTING |
|-----------|-----------------------------|--------------------------------|
| 4.00mm2 | 2.09+/-0.05 [1.082+/-0.002] | 5.5 |
| 3.00mm2 | 2.00+/-0.05 [1.079+/-0.002] | 6.6 |
| 2.50mm2 | 1.76+/-0.05 [1.069+/-0.002] | 9.0 |

- 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 TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
 - 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.
 - 7 CUT TO LENGTH AT ASSEMBLY.
8. 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.

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

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

| | | | | |
|---|-----|-------------|-------------------------------------|-----|
| - | 2 | 2168083-1 | SCR, SKT HD CAP, RoHS, M3 X 8.0 | 269 |
| - | 1 | 1633782-6 | FENCE | 267 |
| - | 1 | 1803078-5 | SPACER, PRECISION | 259 |
| - | 1 | 2119082-2 | CAM, SNAIL, INSULATION ADJUSTMENT | 244 |
| - | 1 | 2079764-1 | WASHER, WAVE SPRING, CREST-TO-CREST | 243 |
| - | 1 | 2119083-1 | RETAINER, INSULATION DIAL | 242 |
| - | 1 | 7-18023-7 | SCR, SKT HD CAP M3 X 4.0 | 241 |
| - | 1 | 2844940-5 | AIR FEED MODULE | 238 |
| - | REF | 994970-2 | COUNTER, MAGNETIC | 164 |
| - | 1 | 2119641-2 | FEED CAM, AIR FEED | 151 |
| - | 1 | 2168083-8 | SCR, SKT HD CAP, RoHS, M4 X 16 | 144 |
| - | 4 | 2168083-9 | SCR, SKT HD CAP, RoHS, M4 X 20 | 143 |
| - | 1 | 1-1803583-8 | APPLICATOR BASIC ASSEMBLY, SF | 141 |
| - | 1 | 1803516-2 | RAM ASSEMBLY, SF PACIFIC | 140 |
| - | 1 | 2844908-1 | SCREW, LOCKING | 99 |
| - | 1 | 2844907-1 | POST, LOCKING | 98 |
| - | 1 | 1-690438-0 | FRONT STRIP GUIDE | 96 |
| - | 1 | 318563-1 | GUARD, FRONT CHIP | 89 |
| - | 1 | 455888-8 | SPACER, CRIMPER | 82 |
| - | 2 | 2079383-4 | SCR, BHSC, RoHS (M4 X 8) | 79 |
| - | 1 | 1803096-1 | EXTENSION PLATE | 78 |
| - | 1 | 1803607-3 | DOCUMENTATION PACKAGE | 71 |
| - | 1 | 2119740-1 | TAG, IDENTIFICATION | 67 |
| - | 2 | 2168078-1 | SCREW, DRIVE, RH, RoHS, 2 x .188 | 66 |
| - | 1 | 5-18022-5 | SCR, HEX HD CAP, M4 X 6.0 | 59 |
| - | 1 | 1-2168083-3 | SCR, SKT HD CAP, RoHS, M3 X 16 | 57 |
| - | 1 | 1338683-8 | FEED PAWL | 56 |
| - | 2 | 1-2168083-0 | SCR, SKT HD CAP, RoHS, M4 X 10 | 53 |
| - | 1 | 5018030-1 | NUT, HEX, REG, RoHS, M3 | 52 |
| - | 1 | 1803382-6 | HOLD DOWN, SPRING LOADED | 50 |
| - | 1 | 18023-9 | SCR, SKT HD CAP M4 X 6.0 | 49 |
| - | 1 | 1803602-2 | SCR, BHSC, RoHS (M8 X 40) | 41 |
| - | 1 | 1-1752356-9 | SUPPORT, TERMINAL | 34 |
| - | 2 | 2079383-5 | SCR, BHSC, RoHS (M4 X 20) | 33 |
| - | 2 | 2-2844962-6 | SPACER, CYLINDRICAL, STRIP GUIDE | 30 |
| - | 1 | 2844992-6 | ASSEMBLY, STRIP GUIDE | 29 |
| - | 1 | 1-455888-0 | SPACER, CRIMPER | 28 |
| - | 2 | 22283-1 | SPRING, COMPRESSION | 27 |
| - | 1 | 240792-1 | DRAG, TERMINAL | 25 |
| - | 1 | 1320928-4 | STRIP GUIDE | 24 |
| - | 1 | 2168083-2 | SCR, SKT HD CAP, RoHS, M4 X 8.0 | 21 |
| - | 1 | 1-18028-2 | WASHER, FLAT, REG M4 | 20 |
| - | 1 | 2119533-1 | STRIPPER, SIDE FEED | 19 |
| - | 1 | 2119806-1 | INSERT, SHEAR | 13 |
| - | 1 | 3-22280-3 | SPRING, COMPRESSION | 12 |
| - | 1 | 1-356885-4 | STOP, SHEAR | 11 |
| - | 1 | 2119805-7 | SHEAR HOLDER, FRONT | 10 |
| - | 1 | 318059-9 | FLOATING SHEAR, FRONT | 9 |
| - | 1 | 3-1803249-9 | ANVIL, COMBINATION | 8 |
| - | - | - | - | 7 |
| - | - | - | - | 6 |
| - | 1 | 1803080-1 | DEPRESSOR, SHEAR | 5 |
| - | 1 | 2-238011-4 | BLOCK, CRIMPER SPACER | 4 |
| - | 1 | 1803208-9 | CRIMPER, INSULATION OVERLAP PREMIUM | 3 |
| - | 1 | 1-455888-5 | SPACER, CRIMPER | 2 |
| - | 1 | 8-1633860-0 | CRIMPER, WIRE | 1 |

| DIMENSIONS: | | TOLERANCES UNLESS OTHERWISE SPECIFIED: | | MATERIAL: | | FINISH: | | WEIGHT: | | SCALE: | |
|-------------|---------|--|---------|-----------|---------|---------|--------|---------|---|--------|--------------|
| mm | 0 PLC ± | 1 PLC ± | 2 PLC ± | 3 PLC ± | 4 PLC ± | ANGLES | FINISH | - | - | 1:2 | SHEET 3 OF 4 |

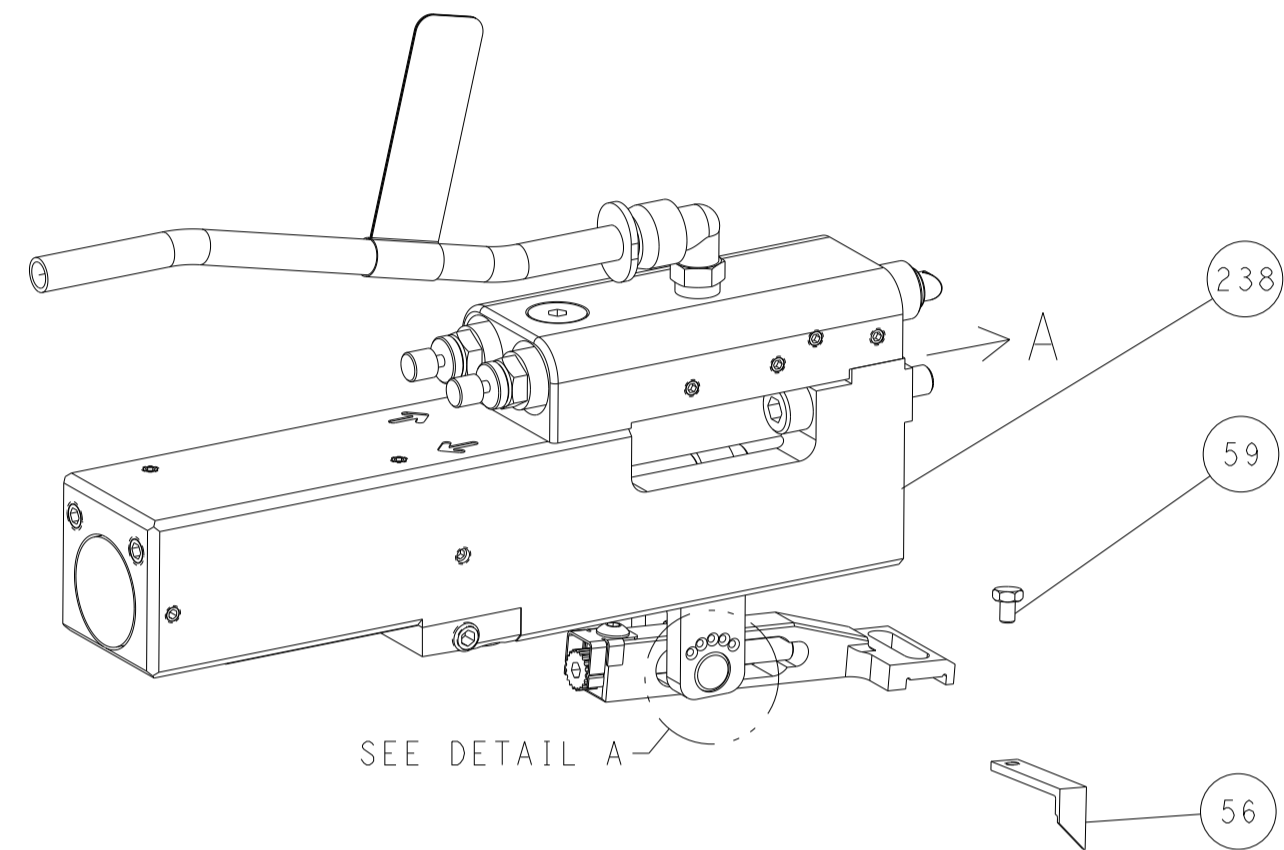
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|--------|----------|----------|-----------|------|------|-----------|------------|---------------|
| J. HOU | L. ZHANG | L. ZHANG | 15APR2016 | NAME | A1 | 00779 | 2836055 | - |

Customer Accessible Production Drawing

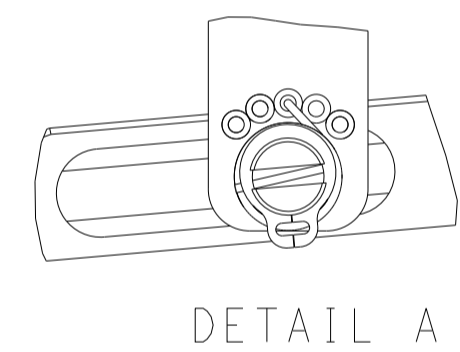
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|-----|------|-----|------|----|------|
| A | 66 | | | | |
| | | | | | |
| | | | | | |

FEED TYPE

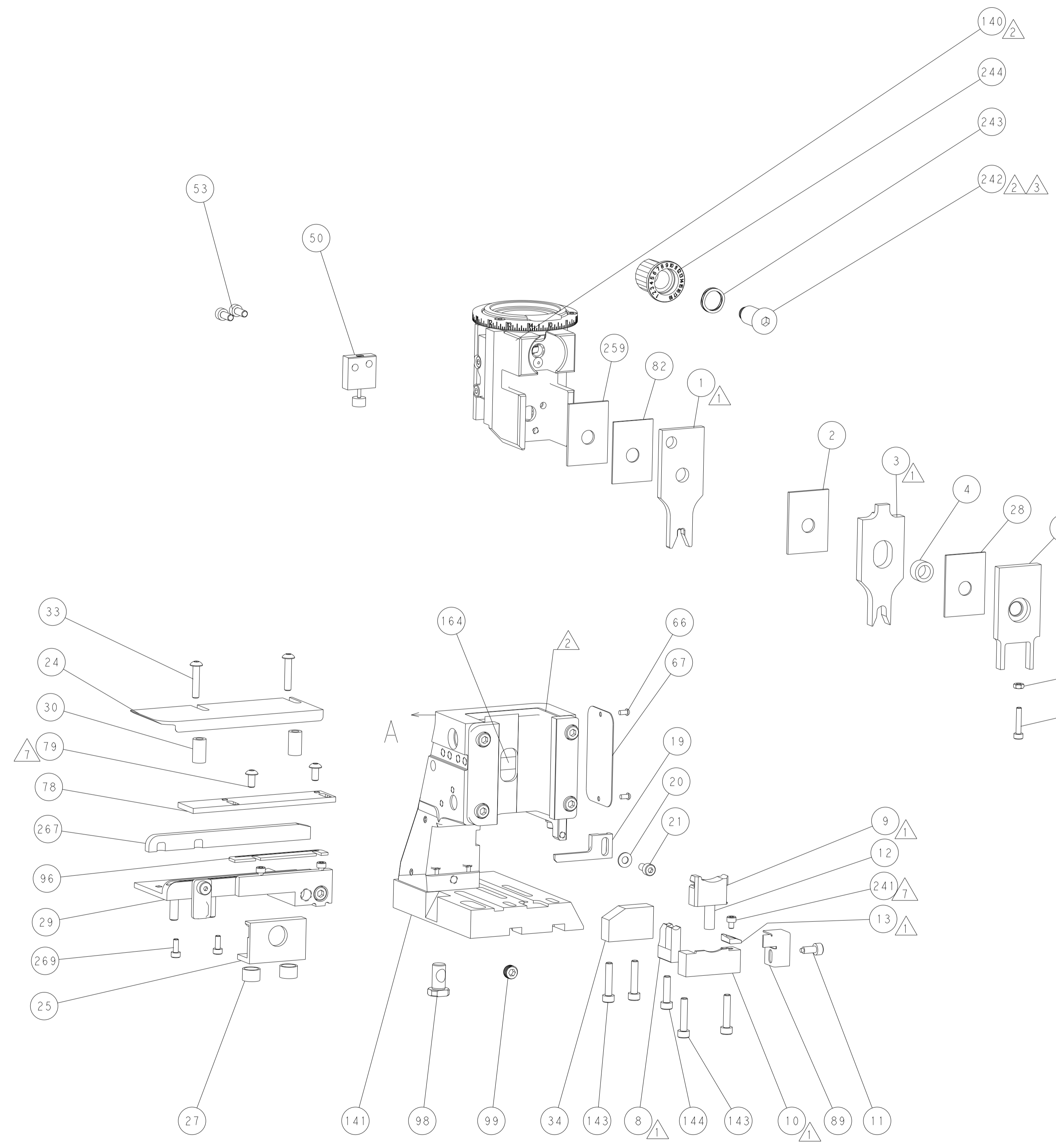
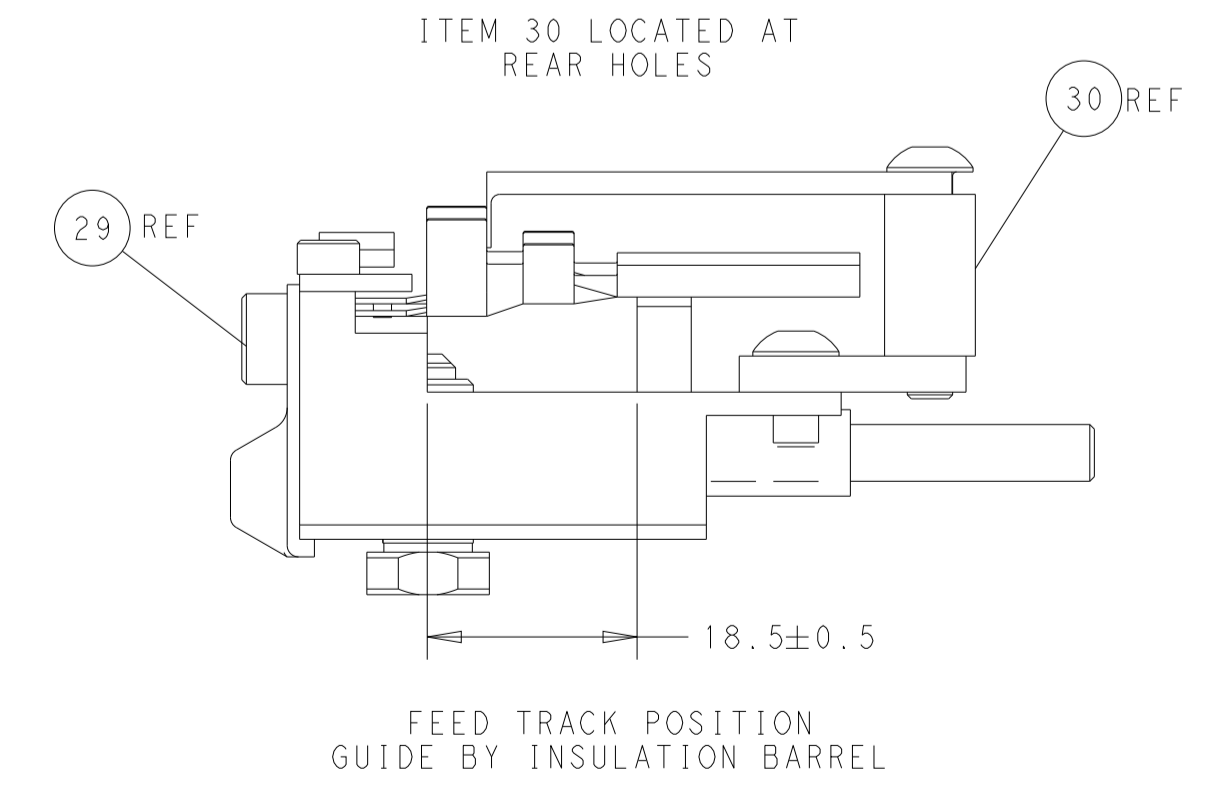
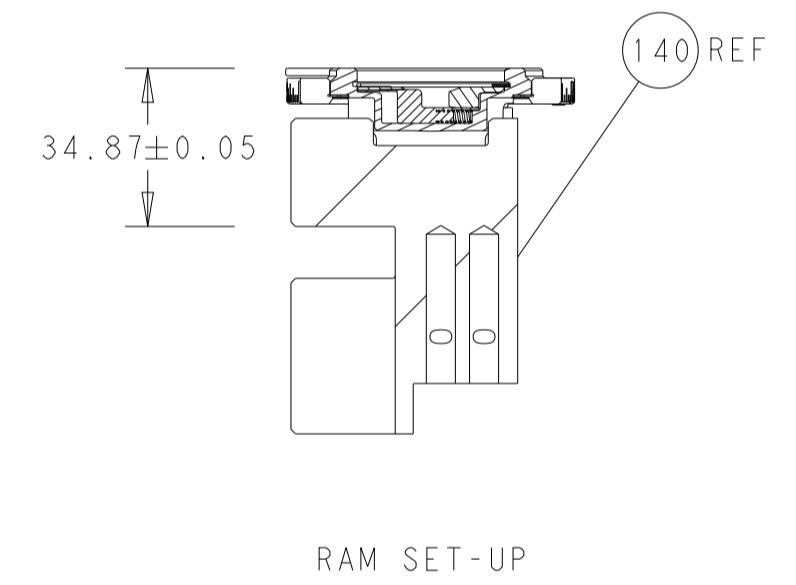
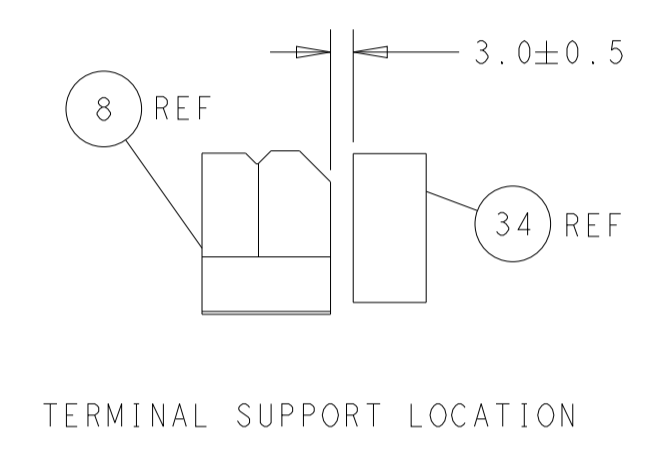
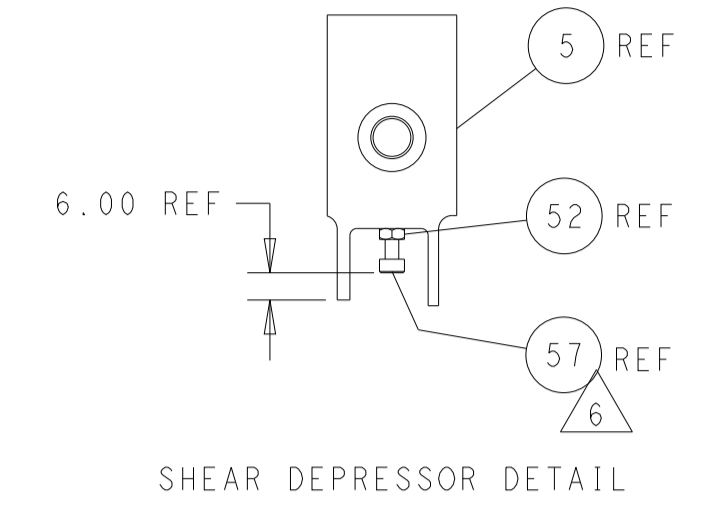
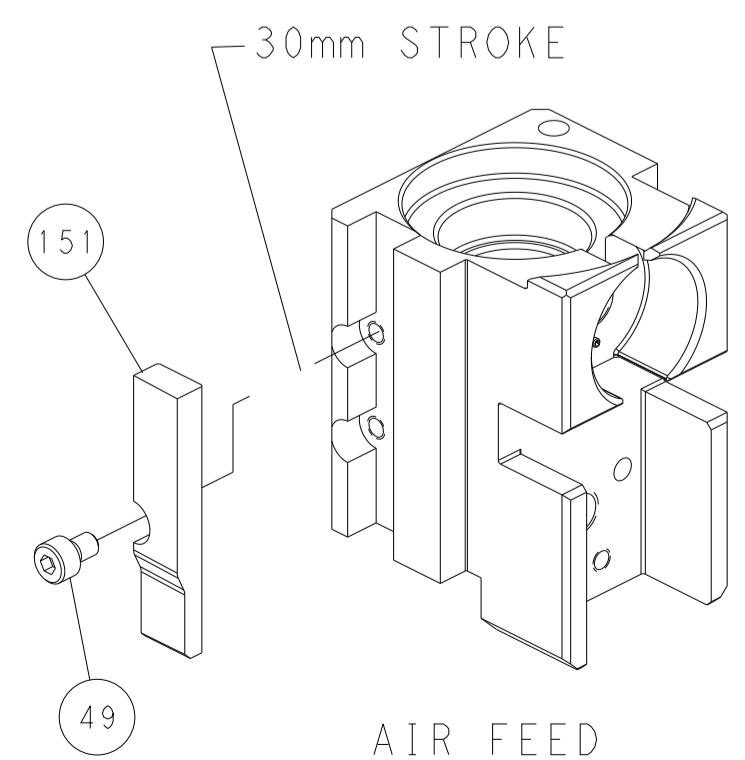
PNEUMATIC



FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



CAM POSITION



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 20. COPYRIGHT 20 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.</small> | | DWN: J. HOU 15APR2016 CHK: L. ZHANG 15APR2016 APVD: L. ZHANG 15APR2016 | NAME: TE Connectivity Harrisburg, PA 17105-3608 |
| DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH ± | PRODUCT SPEC APPLICATION SPEC SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2836055 | RESTRICTED TO: - SCALE: 1:2 SHEET: 4 OF 4 REV: C | CUSTOMER ACCESSIBLE PRODUCTION DRAWING |