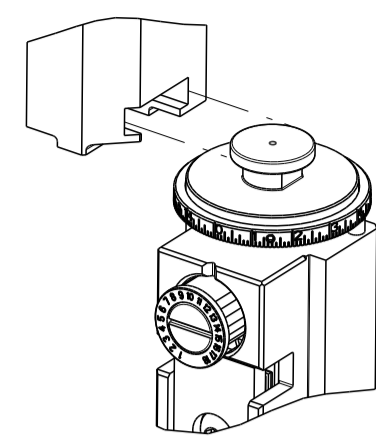


THIS DRAWING IS UNPUBLISHED.	RELEASED FOR PUBLICATION		
COPYRIGHT 20 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.			
PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2836249-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2836249-2	B	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2836249-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER

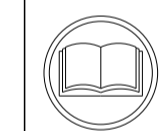


APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	4.00 mm [.157]	F
INSUL	6.60 mm [.260]	O
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: DELPHI PACKARD TERMINAL	DELPHI PACKARD CRIMP SPECIFICATION
TERMINAL NAME: TAB TERMINAL	DUCON 6.3 X 0.8
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE
6.35-7.12 mm [.250-.280 IN]	Ø
TERMINAL APPLICATION SPECIFICATION	15344631 PAGE 2 OF 4 Rev 2013-10-30

TE TERMINAL	DELPHI PACKARD TERMINAL	TE SEAL	DELPHI PACKARD SEAL	CABLE DIAMETER
2113978-1	15344631	1949378-1	12052668	3.61-4.5
		1949378-2	15324996	3.61-4.5
		1949378-3	12059260	3.61-4.5
		1949378-4	15324994	2.81-3.75
		1949378-5	12052387	2.81-3.75
		1949378-6	12059258	2.81-3.75

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
6.00mm2	2.40 +/- 0.05 [.094 +/- .002]	6.7
4.00mm2	2.10 +/- 0.05 [.083 +/- .002]	9.7



- 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 CUT TO LENGTH AT ASSEMBLY.
- 6 APPLY TORO-SEAL IN ALLEN SOCKET TO FILL HOLE AFTER SOCKET HD HAS BEEN ADJUSTED TO CORRECT HEIGHT AT QUALIFICATION. APPLY #1-23419-5 LOC-TITE TO THREADS.
- 7 TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- 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	DWN	APVD
		A		RELEASED	24MAY2016	MR	TE
		B		ECR-20-013291	18SEP2020	TB	RR

-	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	269
-	1	1	1633782-6	FENCE	267
-	1	1	1803078-3	SPACER, PRECISION	259
-	1	1	2119641-1	FEED CAM, AIR FEED	248
-	1	1	2119082-1	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	2844940-1	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	1-455888-1	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	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	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	811242-5	BUMPER, HOLD DOWN	51
-	1	1	690753-2	SPACER, TONKER	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	6-1752356-2	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	2844992-5	ASSEMBLY, STRIP GUIDE	29
-	1	1	455888-3	SPACER, CRIMPER	28
-	2	2	22283-1	SPRING, COMPRESSION	27
-	1	1	240792-1	DRAG, TERMINAL	25
-	1	1	1320928-6	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	4-22280-7	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	1-1633930-1	ANVIL, COMBINATION	8
-	-	-	-	-	7
-	-	-	-	-	6
-	1	1	1803080-1	DEPRESSOR, SHEAR	5
-	1	1	4-238011-5	BLOCK, CRIMPER SPACER	4
-	1	2	1-1803018-9	CRIMPER, INSULATION O	3
-	1	1	1-455888-4	SPACER, CRIMPER	2
-	1	2	1-1633588-3	CRIMPER, WIRE	1

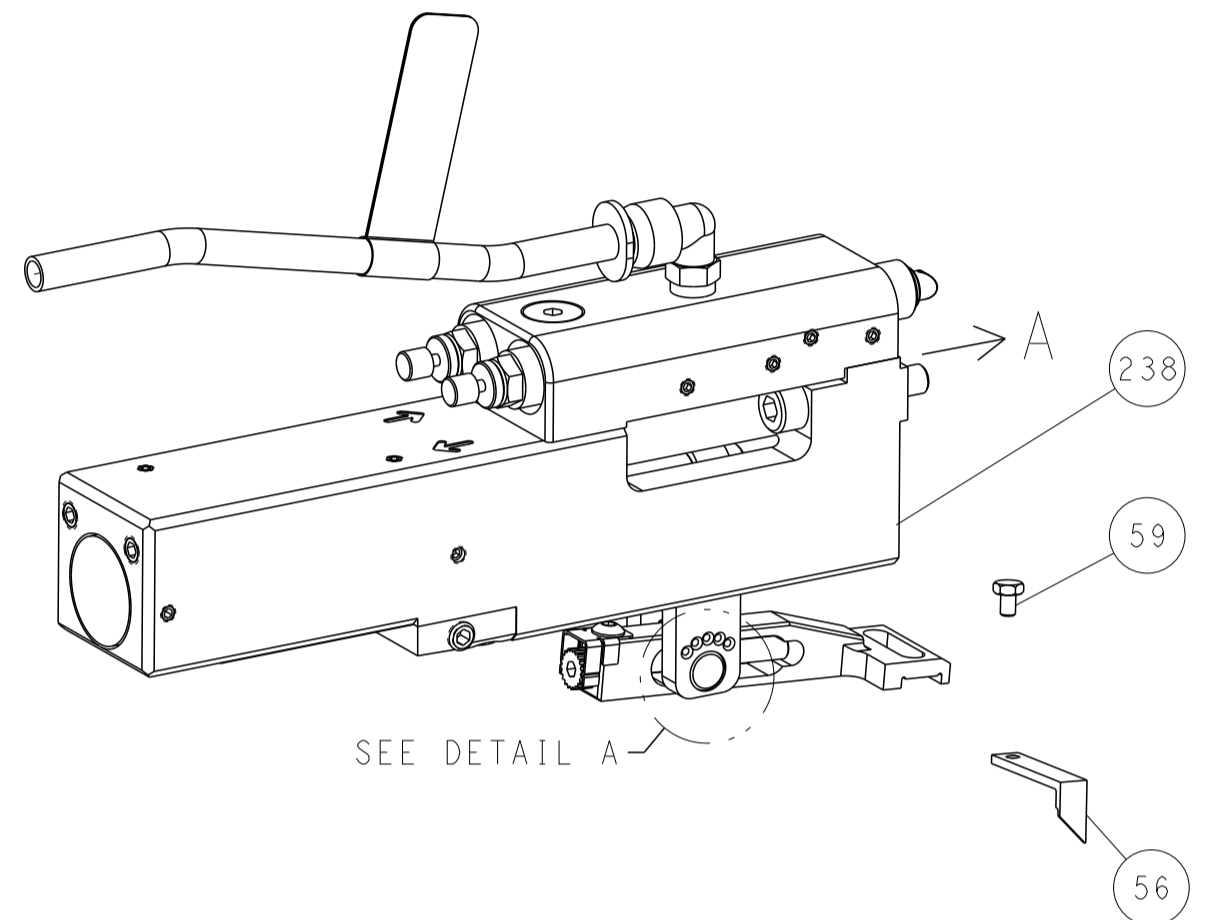
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN H. HUANG 23MAR2016		TE Connectivity Harrisburg, PA 17105-3608	
mm	0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ±	±	±	CHK L. ZHANG 23MAR2016	NAME Ocean Side Feed Applicator		
MATERIAL		FINISH		APVD L. ZHANG 23MAR2016		SIZE A1	
				WEIGHT		CAGE CODE 00779	
				DRAWING NO 2836249		RESTRICTED TO	
				Customer Accessible Production Drawing		SCALE 1:2	
				SHEET 1		OF 4	
				REV B			

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

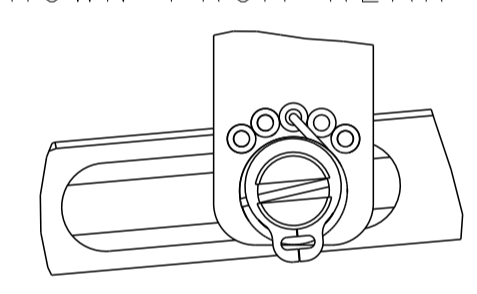
FEED TYPE

PNEUMATIC



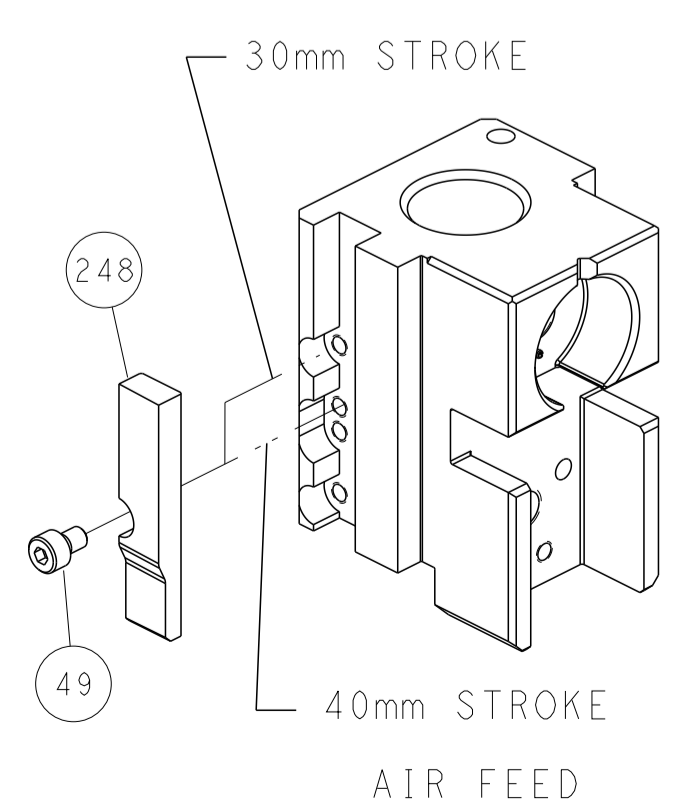
SEE DETAIL A

FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)

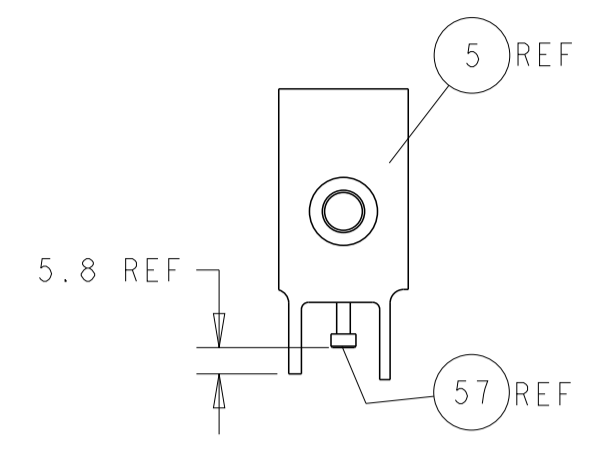
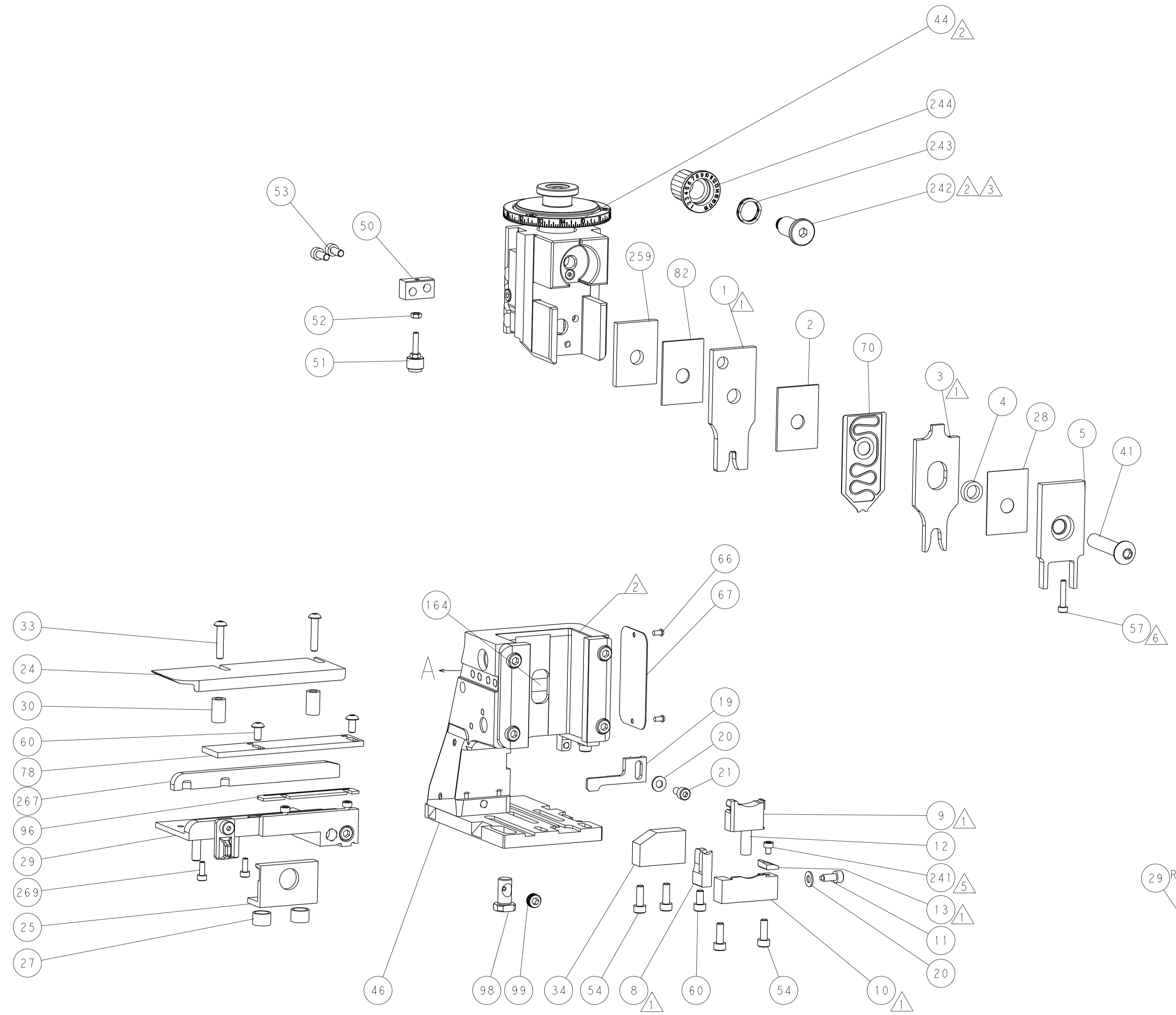


DETAIL A

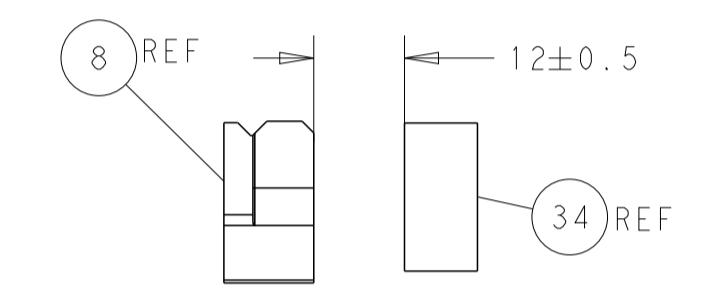
CAM POSITION



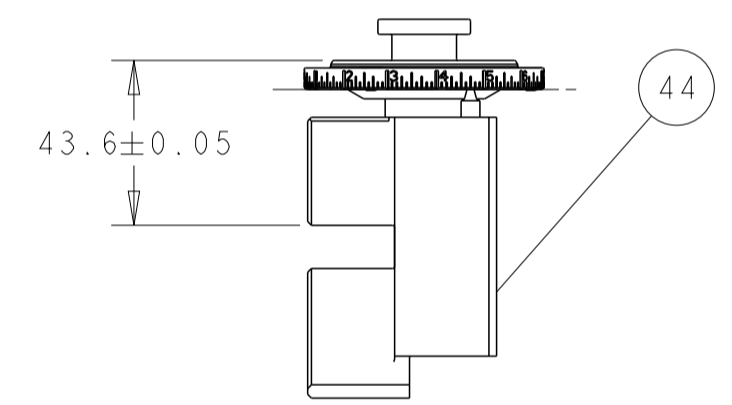
AIR FEED



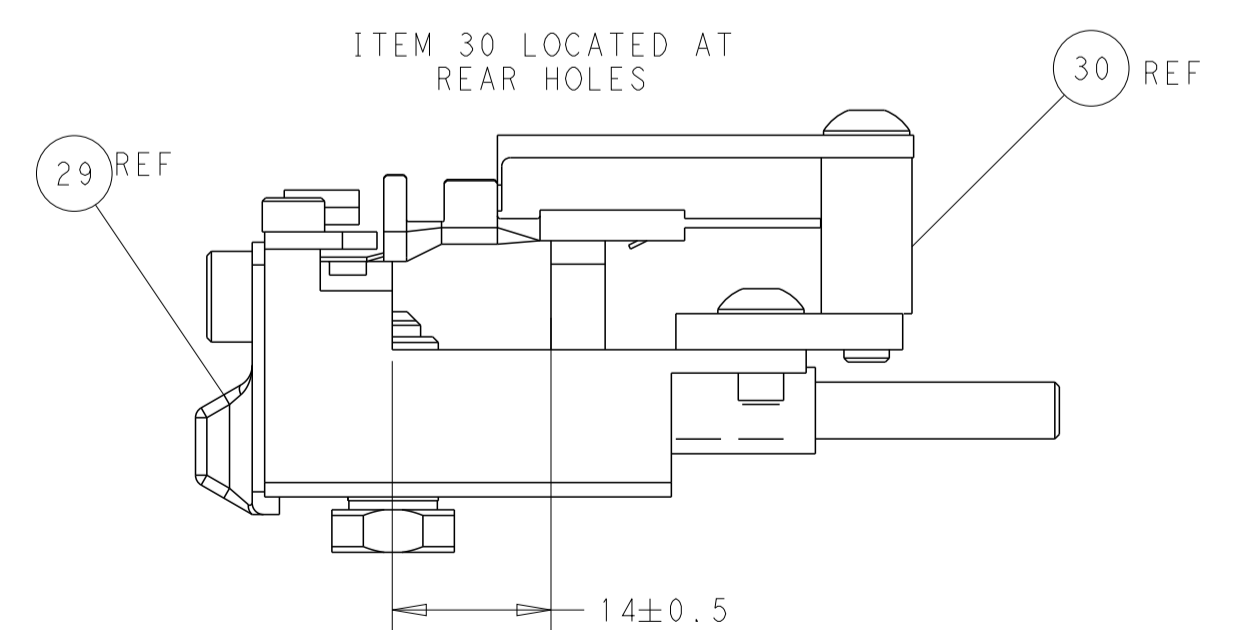
SHEAR DEPRESSOR DETAIL



TERMINAL SUPPORT LOCATION



RAM SET-UP



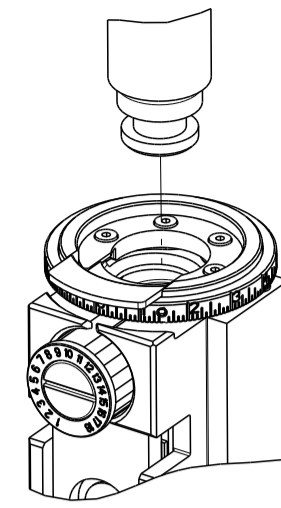
FEED TRACK POSITION GUIDE BY WIRE BARREL

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. 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: R. HUANG 23MAR2016 CHK: L. ZHANG 23MAR2016 APVD: L. ZHANG 23MAR2016	NAME: Ocean Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2836249	TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH	WEIGHT: - SCALE: 1:2 SHEET: 2 OF 4 REV: B	Customer Accessible Production Drawing		

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2836249-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2836249-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	4.00 mm [1.57]	F
INSUL	6.60 mm [2.60]	O
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: DELPHI PACKARD TERMINAL		DELPHI PACKARD CRIMP SPECIFICATION	
TERMINAL NAME: TAB TERMINAL DUCON 6.3 X 0.8			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
6.35-7.12 mm [1.250-.280 IN]			
TERMINAL APPLICATION SPECIFICATION	15344631 PAGE 2 OF 4 Rev 2013-10-30	-	-
TERMINALS APPLIED			

TE TERMINAL	DELPHI PACKARD TERMINAL	TE SEAL	DELPHI PACKARD SEAL	CABLE DIAMETER
2113978-1	15344631	1949378-1	12052668	3.61-4.5
		1949378-2	15324996	3.61-4.5
		1949378-3	12059260	3.61-4.5
		1949378-4	15324994	2.81-3.75
		1949378-5	12052387	2.81-3.75
		1949378-6	12059258	2.81-3.75

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
6.00mm2	2.40 +/- 0.05 [1.094 +/- .002]	6.7
4.00mm2	2.10 +/- 0.05 [1.083 +/- .002]	9.7



- 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.
- CUT TO LENGTH AT ASSEMBLY.
- APPLY TORO-SEAL IN ALLEN SOCKET TO FILL HOLE AFTER SOCKET HD HAS BEEN ADJUSTED TO CORRECT HEIGHT AT QUALIFICATION. APPLY #1-23419-5 LOC-TITE TO THREADS.
- TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- 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	REV	DATE	BY	APPV
A	66				

REVISIONS					
REV	DATE	DESCRIPTION	DATE	BY	APPV
-	-	SEE SHEET 1	-	-	-
-	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0		269
-	1	1633782-6	FENCE		267
-	1	1803078-3	SPACER, PRECISION		259
-	1	2119082-1	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	2844940-1	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	1-455888-1	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	2119791-9	DEPRESSOR, WIRE		70
-	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	811242-5	BUMPER, HOLD DOWN		51
-	1	690753-2	SPACER, TONKER		50
-	1	18023-9	SCR, SKT HD CAP M4 X 6.0		49
-	1	1803602-2	SCR, BHSC, RoHS (M8 X 40)		41
-	1	6-1752356-2	SUPPORT, TERMINAL		34
-	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)		33
-	2	2-2844962-4	SPACER, CYLINDRICAL, STRIP GUIDE		30
-	1	2844992-5	ASSEMBLY, STRIP GUIDE		29
-	1	455888-3	SPACER, CRIMPER		28
-	2	22283-1	SPRING, COMPRESSION		27
-	1	240792-1	DRAG, TERMINAL		25
-	1	1320928-6	STRIP GUIDE		24
-	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0		21
-	2	1-18028-2	WASHER, FLAT, REG M4		20
-	1	2119533-1	STRIPPER, SIDE FEED		19
-	1	2119806-1	INSERT, SHEAR		13
-	1	4-22280-7	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	1-1633930-1	ANVIL, COMBINATION		8
-	-	-	-		7
-	-	-	-		6
-	1	1803080-1	DEPRESSOR, SHEAR		5
-	1	4-238011-5	BLOCK, CRIMPER SPACER		4
-	1	1-1803018-9	CRIMPER, INSULATION O		3
-	1	1-455888-4	SPACER, CRIMPER		2
-	1	1-1633588-3	CRIMPER, WIRE		1
-	77	22	PART NO		
-			DESCRIPTION		ITEM NO

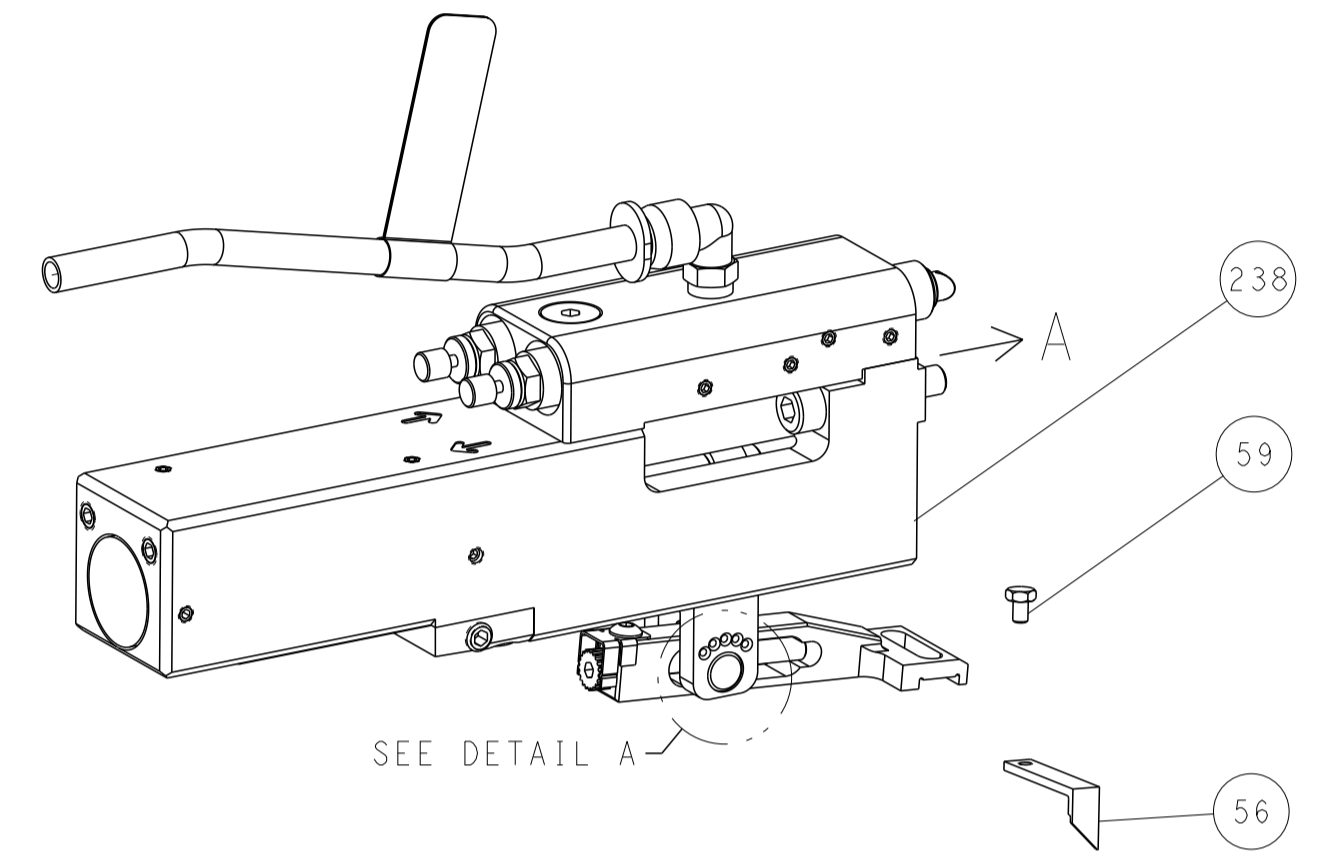
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		MATERIAL:		FINISH:	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES	FINISH

CHK	H. HUANG	23MAR2016	NAME	TE Connectivity
CHK	L. ZHANG	23MAR2016	PRODUCT SPEC	Harrisburg, PA 17105-3608
APPV	L. ZHANG	23MAR2016	APPLICATION SPEC	
SIZE	A1	CAGE CODE	00779	DRAWING NO
SCALE	1:2	SCALE	1:2	SHEET 3 OF 4
REV	B	REV	B	REV

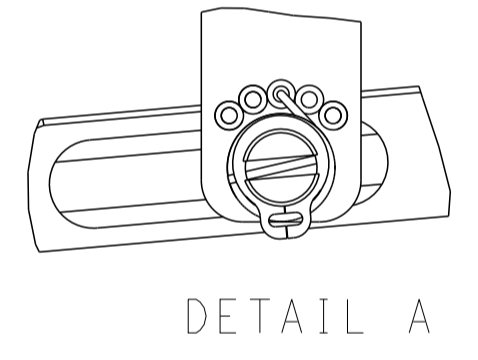
LOC	DIST	REVISIONS					
		P	LTN	DESCRIPTION	DATE	DWN	APVD
A	66	-	-	SEE SHEET 1	-	-	-

FEED TYPE

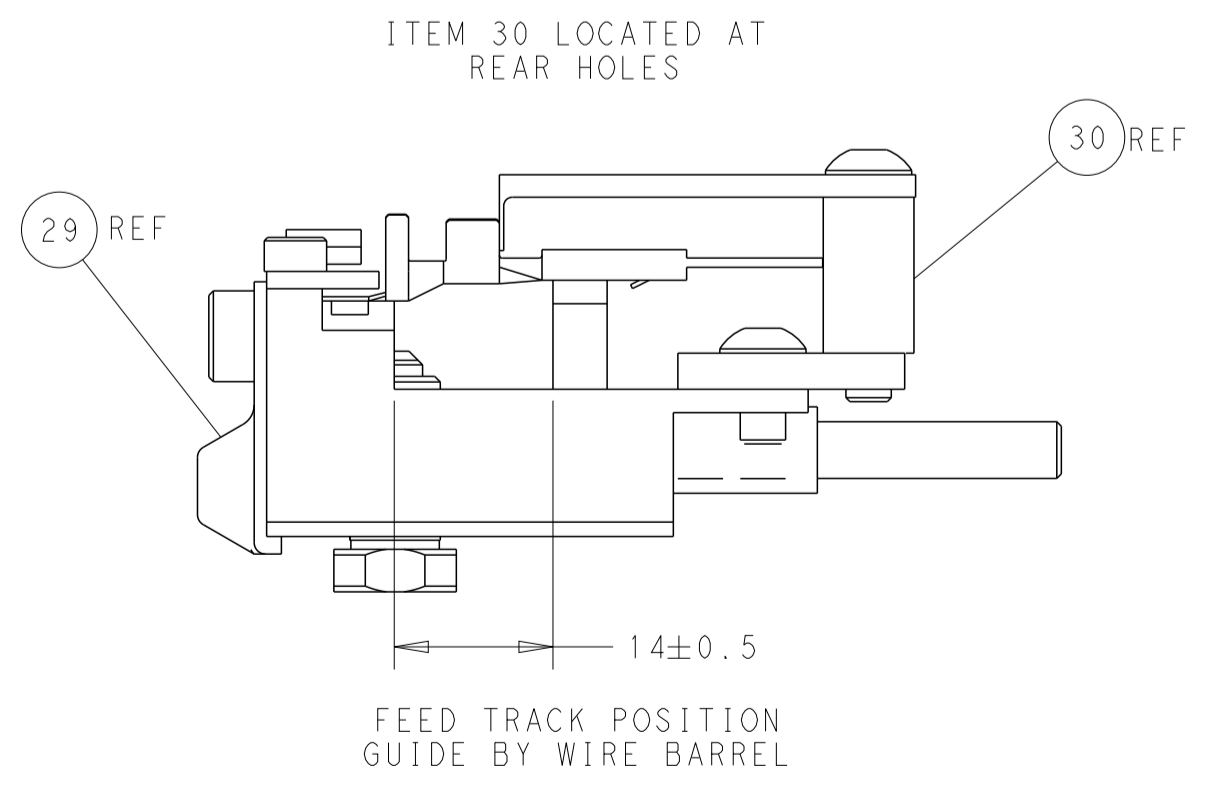
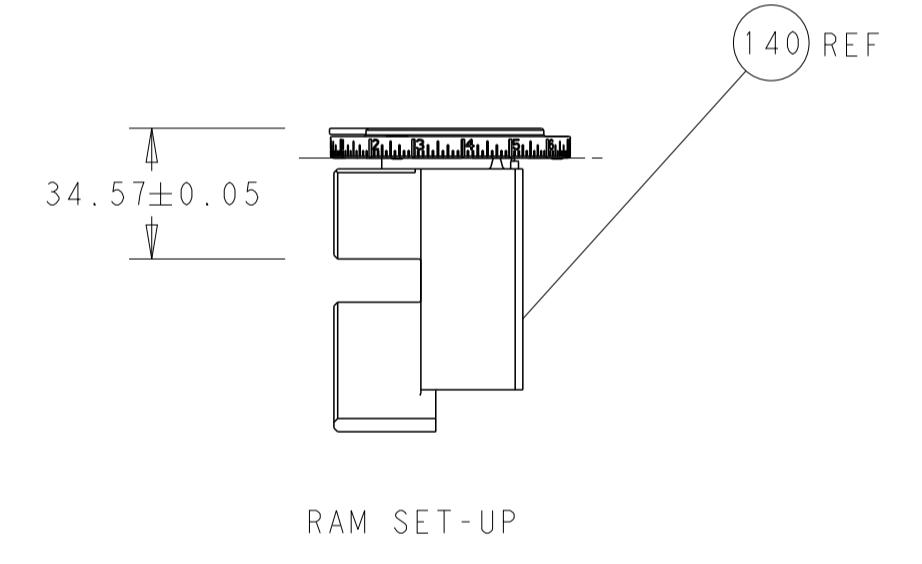
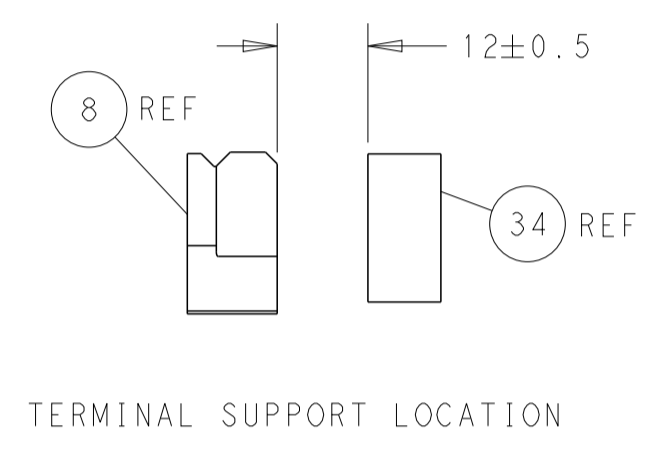
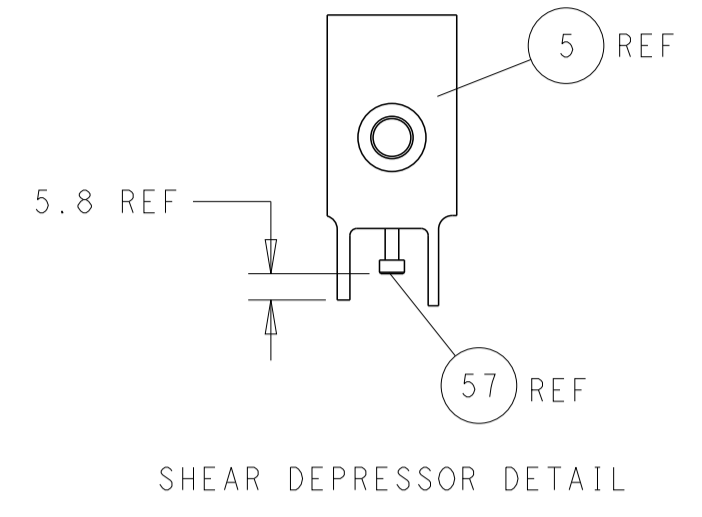
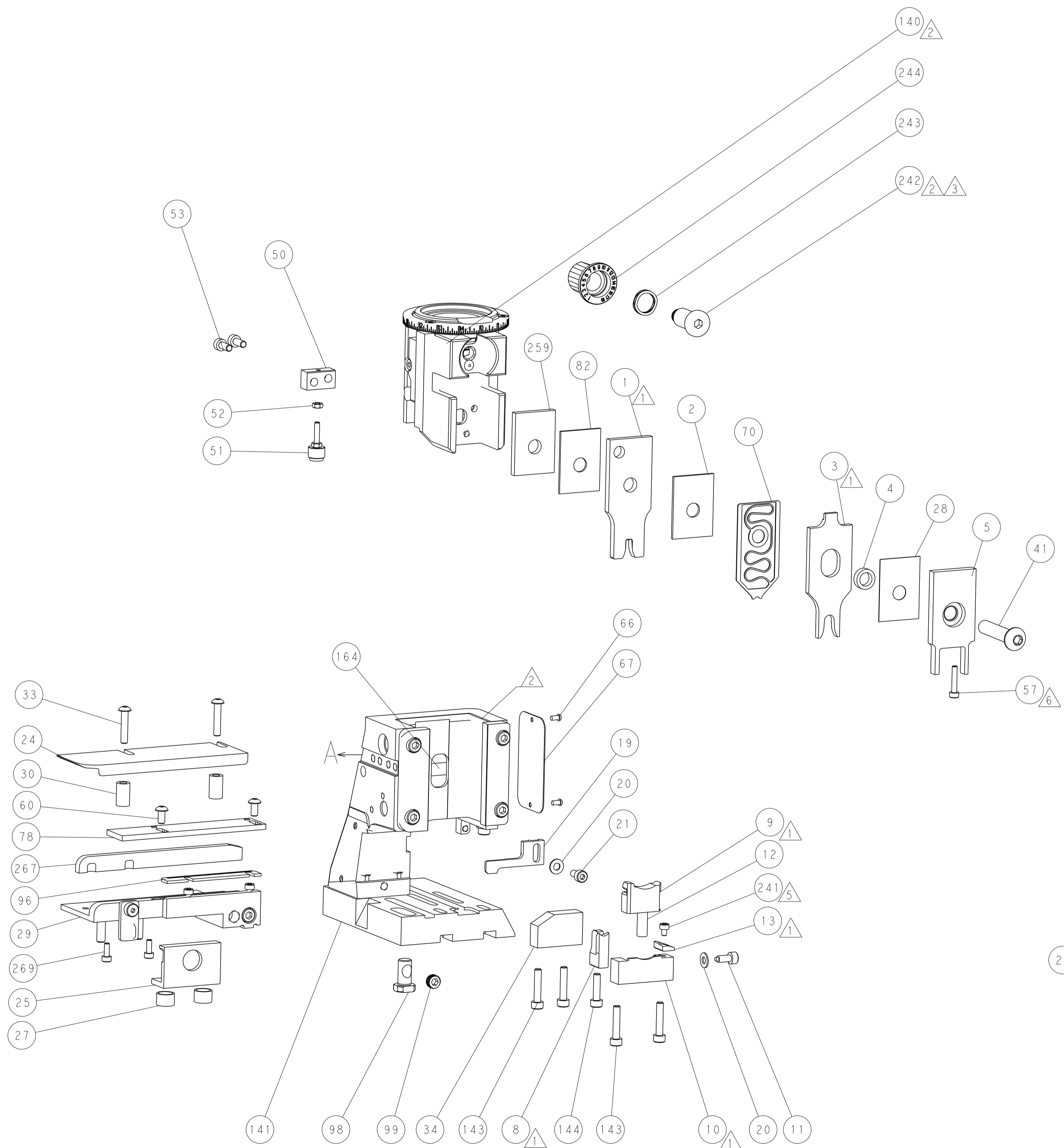
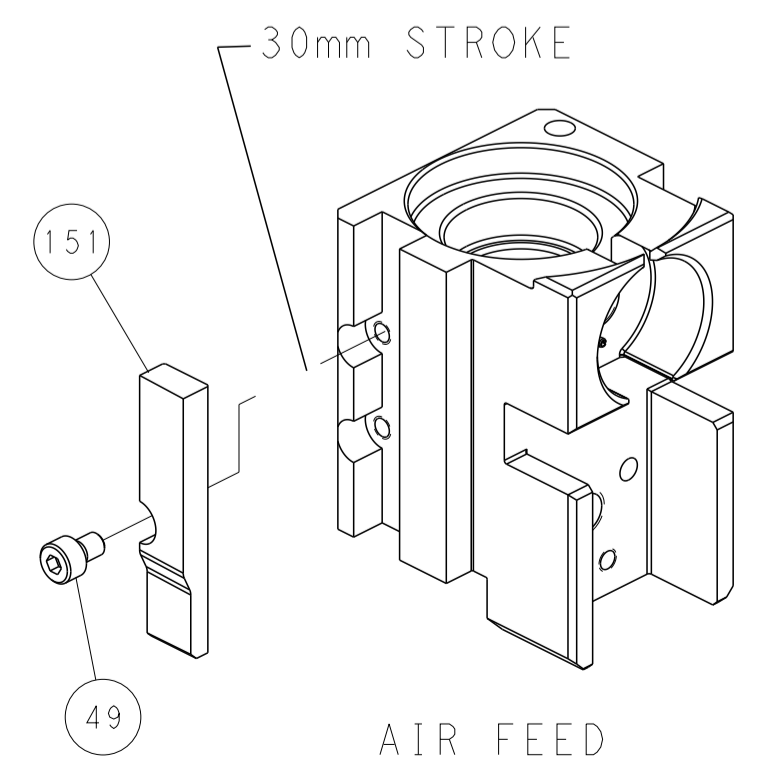
PNEUMATIC



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)

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DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± MATERIAL: - FINISH: -	PRODUCT SPEC: - APPLICATION SPEC: - WEIGHT: - SCALE: 1:2	SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2836249 SHEET 4 OF 4 REV B	RESTRICTED TO: - CUSTOMER ACCESSIBLE PRODUCTION DRAWING