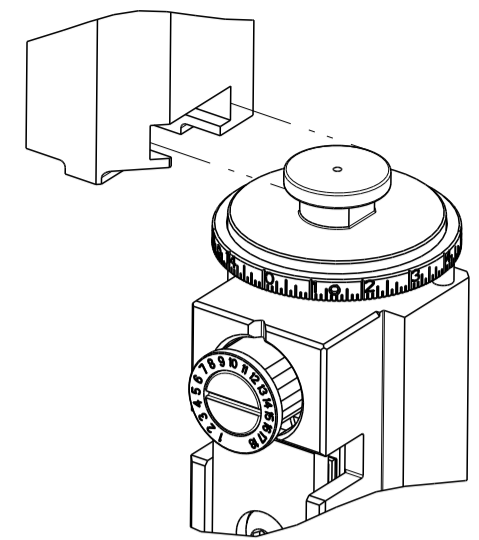


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2836324-2	E	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2836324-2	E	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2836324-7	D	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER

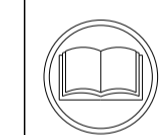


APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	5.03 mm [.198]	SP
INSUL	6.17 mm [.243]	SP

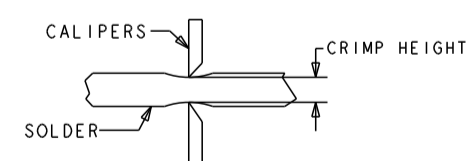
APPLICATOR INSTRUCTIONS
408-35042

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: RECEPTACLE, FASTON, PIDG			
WIRE STRIP LENGTH 7.51-8.33 mm [.296-.328 IN]		INSULATION DIAMETER RANGE Ø2.62-3.56 mm [.103-.140 IN]	
TERMINAL APPLICATION SPECIFICATION 114-1002			
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
640902-1	640910-1	640920-1	640924-1
640908-1	640916-1	640922-1	

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
18 AWG	2.08 +/- 0.05 [.082 +/- .002]	6.7
20 AWG	2.08 +/- 0.05 [.082 +/- .002]	7.0
22 AWG	2.08 +/- 0.05 [.082 +/- .002]	7.0



- 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.
- TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- TO CHECK CRIMP HEIGHT, CRIMP SOLDER (Ø3.18mm [.125 IN] 60/40 SOLID CORE) AND MEASURE AT CENTER OF SLUG.



***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
		B		ECR-16-015986	11NOV2016	TB	CT
		C		ECR-17-001723	07FEB2017	MZ	JDG
		D		ECR-19-006643	25APR2019	FL	CT
		E		ECR-22-132787	16MAR2022	TB	RK

-	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	283	
-	1	1	2280441-1	INSERT, SHEAR	282	
-	2	2	1-2168083-3	SCR, SKT HD CAP, RoHS, M3 X 16	261	
-	1	1	2119641-1	FEED CAM, AIR FEED	248	
-	1	1	2119082-4	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	2844940-1	AIR FEED MODULE	238	
-	1	1	356885-4	STOP, SHEAR	237	
-	REF	REF	994970-2	COUNTER, MAGNETIC	164	
-	1	1	1-22281-8	SPRING, COMPRESSION	121	
-	1	1	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	111	
-	1	1	2844908-1	SCREW, LOCKING	99	
-	1	1	2844907-1	POST, LOCKING	98	
-	1	1	1-690438-0	FRONT STRIP GUIDE	96	
-	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	95	
-	1	1	2168083-6	SCR, SKT HD CAP, RoHS, M5 X 65	93	
-	1	1	455888-5	SPACER, CRIMPER	82	
-	1	1	1-240641-8	SPACER	81	
-	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	
-	2	2	2-18032-5	SCR, SET, FLT PNT, M5 X 20.0	61	
-	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	1-1338683-0	FEED PAWL	56	
-	2	2	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	54	
-	2	2	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	53	
-	1	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49	
-	1	1	1803583-9	APPLICATOR BASIC ASSEMBLY, SF	46	
-	1	1	1803515-1	RAM ASSEMBLY, SF ATLANTIC	44	
-	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41	
-	1	1	2-189124-5	GUIDE, FRONT STRIP	30	
-	1	1	2305692-7	PLATE, REAR STRIP GUIDE	29	
-	2	2	22283-1	SPRING, COMPRESSION	27	
-	1	1	356835-1	LEVER, DRAG RELEASE	26	
-	1	1	240792-1	DRAG, TERMINAL	25	
-	1	1	980371-4	SCR, SKT HD SHLDR 5.0 DIA X 6.0	23	
-	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	2119533-3	STRIPPER, SIDE FEED	19	
-	1	1	189369-1	HOLD DOWN, TERMINAL	18	
-	1	1	690463-1	FLOATING SHEAR, REAR	17	
-	2	2	1-2168083-1	SCR, SKT HD CAP, RoHS, M3 X 6	16	
-	1	1	690464-2	SHEAR PLATE, REAR	15	
-	1	1	2119862-1	SHEAR HOLDER, REAR	14	
-	1	1	3-22280-3	SPRING, COMPRESSION	12	
-	-	-	-	-	10	
-	1	1	454766-9	ANVIL, INSULATION	9	
-	1	2	1	467660-4	ANVIL, WIRE	8
-	-	-	-	-	7	
-	1	1	690468-6	DEPRESSOR SHEAR, REAR	6	
-	-	-	-	-	5	
-	1	1	3-238009-6	BLOCK, FL CRIMPER SPACER	4	
-	1	2	1	1803130-3	CRIMPER, INSULATION FASTON	3
-	-	-	-	-	2	
-	1	2	1	467661-1	CRIMPER, CONFINED WIRE	1
-	-	-	-	-	0	

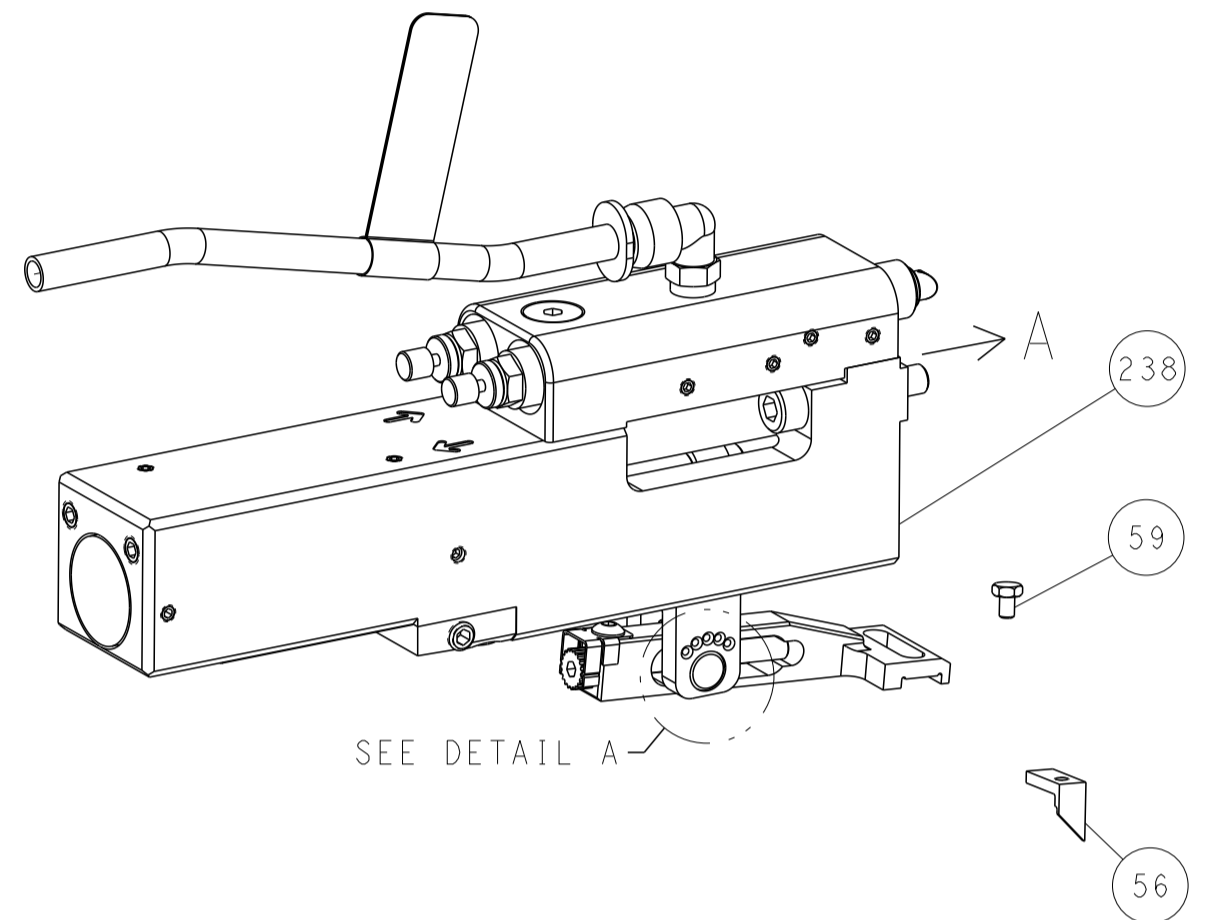
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		MATERIAL:		FINISH:		WEIGHT:		SCALE:		SHEET:		REV:	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES	FINISH	WT	SCALE	SHEET	OF	REV	NO	NO	NO
										1:2	1	4	E		

SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

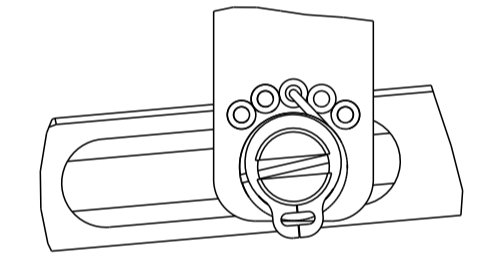
LOC	DIST	REVISIONS					
A	66	P	LTN	DESCRIPTION	DATE	DWN	APVD
		-		SEE SHEET 1	-	-	-

FEED TYPE

PNEUMATIC

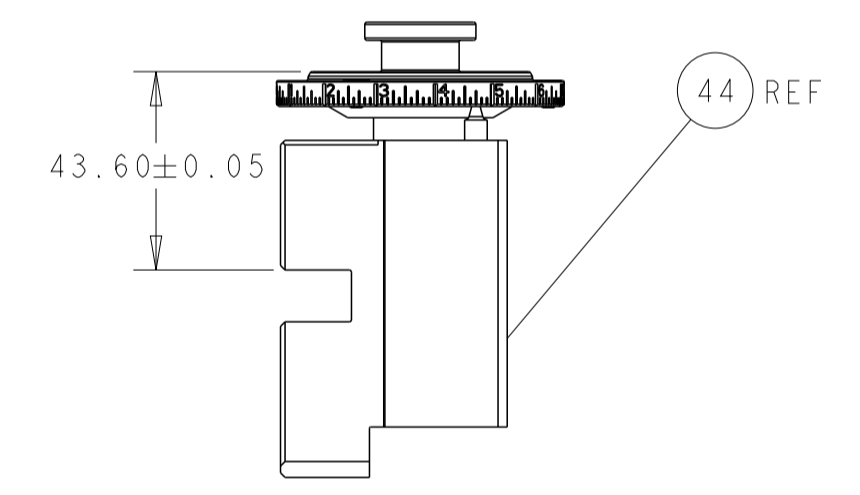
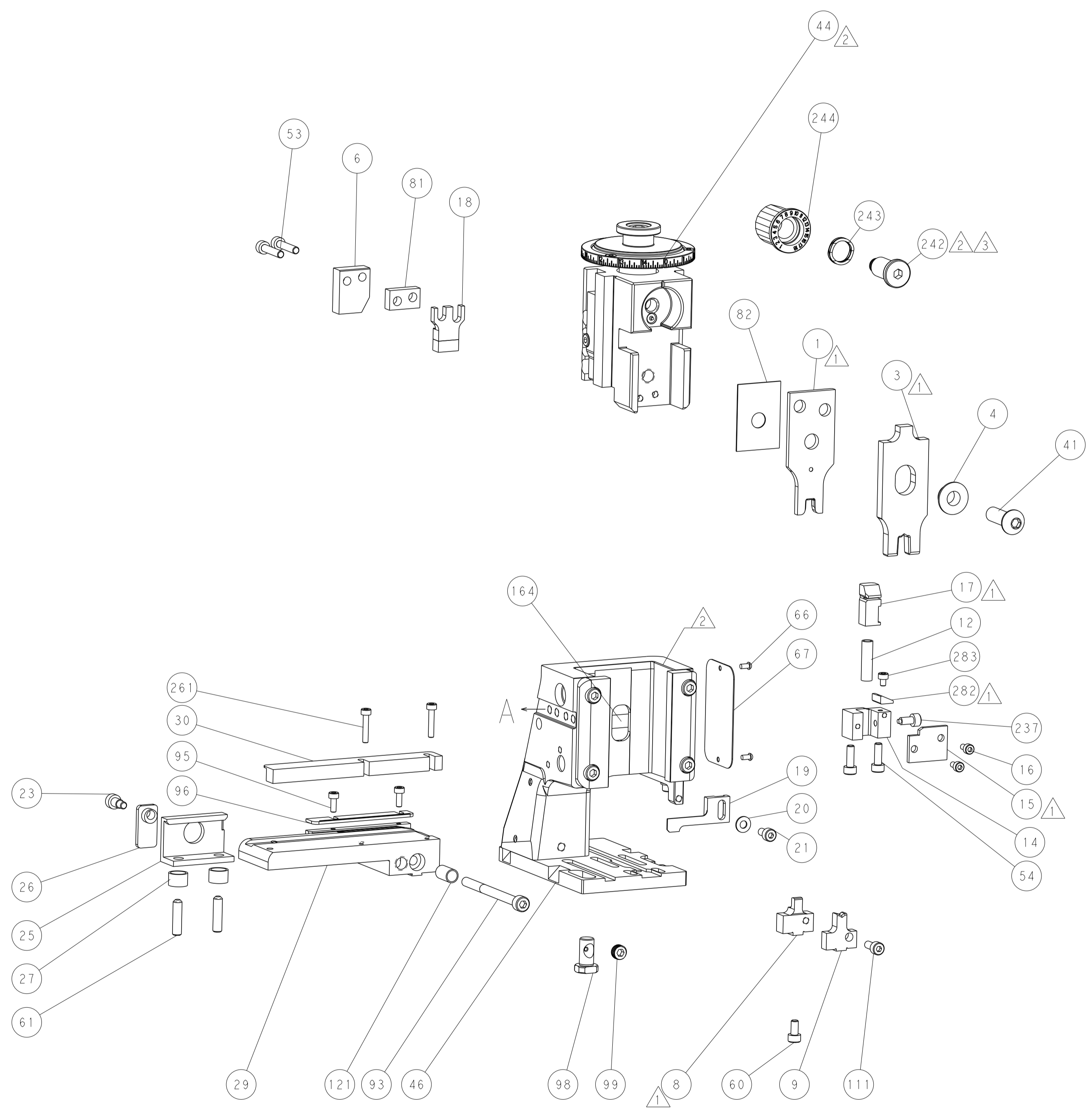
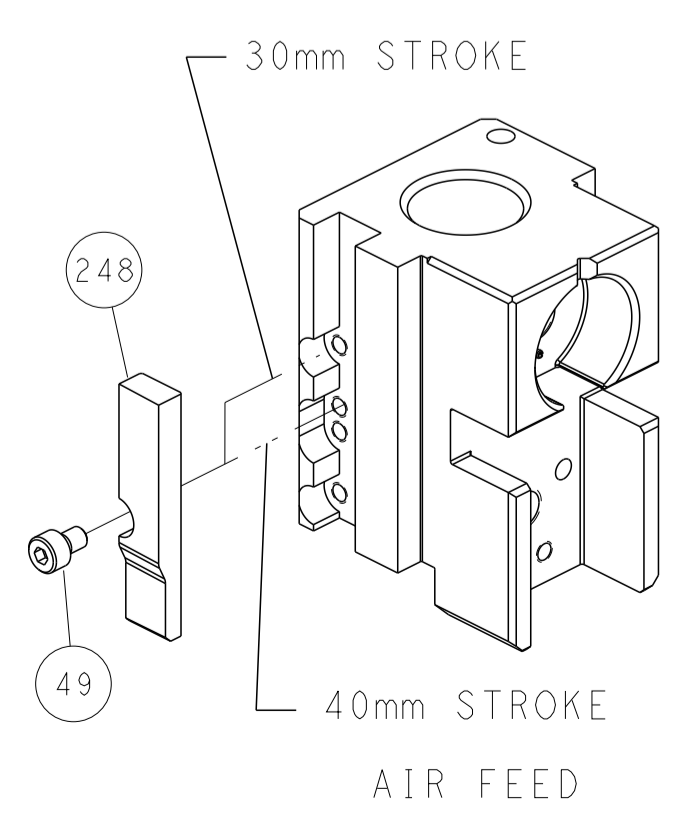


FEED SPRING SETTING POSITION
(SHOWN FROM REAR SIDE)

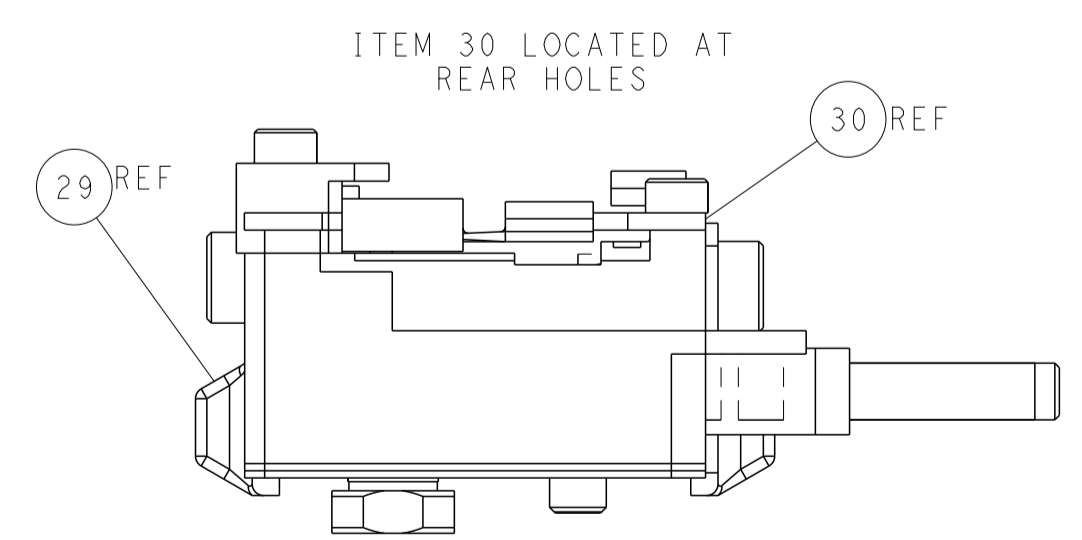


DETAIL A

CAM POSITION



RAM SET-UP



FEED TRACK POSITION
GUIDE BY INSULATION 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 2016. COPYRIGHT 2016 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.</small>		DWN B. WEAVER 25MAY2016 CHK C. TOPPER 25MAY2016 APVD C. TOPPER 25MAY2016	TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± MATERIAL: - FINISH: -		NAME: Ocean Side Feed Applicator PRODUCT SPEC: - APPLICATION SPEC: - WEIGHT: - SCALE: 1:2	RESTRICTED TO: - SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2836324 SHEET 2 OF 4 REV E
Customer Accessible Production Drawing			

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2836324-2	E	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2836324-7	D	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
 INTERFACE ADAPTER



APPLICATOR DATA

CRIMP	SIZE	TYPE
WIRE	5.03 mm [.198]	SP
INSUL	6.17 mm [.243]	SP

APPLICATOR INSTRUCTIONS
 408-35042

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION

TERMINAL NAME: RECEPTACLE, FASTON, PIDG

WIRE STRIP LENGTH	INSULATION DIAMETER RANGE
7.51-8.33 mm [.296-.328 IN]	∅2.62-3.56 mm [.103-.140 IN]

TERMINAL APPLICATION SPECIFICATION 114-1002

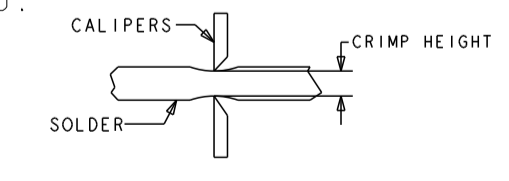
TERMINALS APPLIED 6

TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
640902-1	640910-1	640920-1	640924-1
640908-1	640916-1	640922-1	

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
18 AWG	2.08+/-0.05 [.082+/- .002]	6.7
20 AWG	2.08+/-0.05 [.082+/- .002]	7.0
22 AWG	2.08+/-0.05 [.082+/- .002]	7.0



- 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.
- TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- TO CHECK CRIMP HEIGHT, CRIMP SOLDER (∅3.18mm [.125 IN] 60/40 SOLID CORE) AND MEASURE AT CENTER OF SLUG.



***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	
		DESCRIPTION DATE DWN APVD
		SEE SHEET 1 - - -

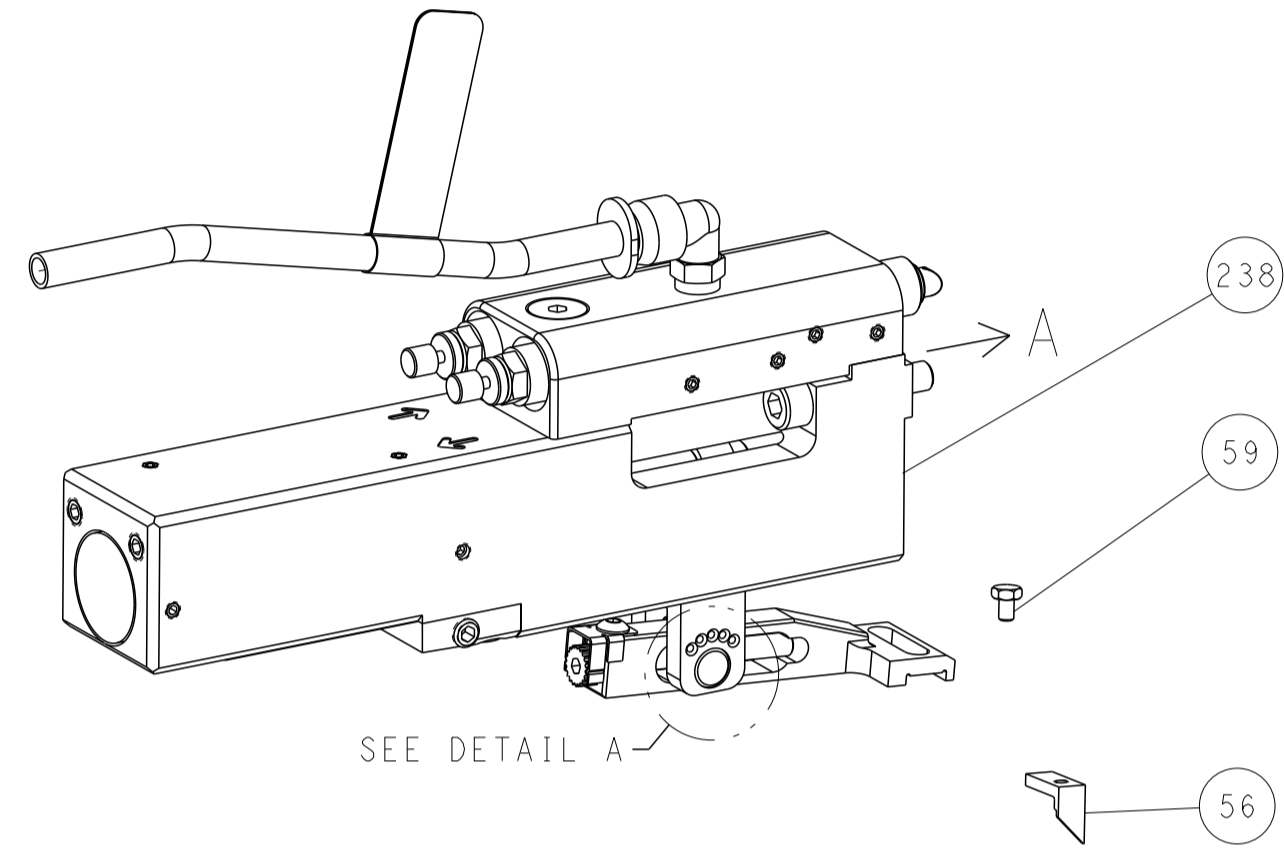
-	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	283	
-	1	2280441-1	INSERT, SHEAR	282	
-	2	1-2168083-3	SCR, SKT HD CAP, RoHS, M3 X 16	261	
-	1	2119082-4	CAM, SNAIL, INSULATION ADJUSTMENT	244	
-	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243	
-	1	2119083-1	RETAINER, INSULATION DIAL	242	
-	1	2844940-1	AIR FEED MODULE	238	
-	1	356885-4	STOP, SHEAR	237	
-	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	
-	2	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	143	
-	1	1-1803583-0	APPLICATOR BASIC ASSEMBLY, SF	141	
-	1	1803516-1	RAM ASSEMBLY, SF PACIFIC	140	
-	1	1-22281-8	SPRING, COMPRESSION	121	
-	1	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	111	
-	1	2844908-1	SCREW, LOCKING	99	
-	1	2844907-1	POST, LOCKING	98	
-	1	1-690438-0	FRONT STRIP GUIDE	96	
-	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	95	
-	1	2168083-6	SCR, SKT HD CAP, RoHS, M5 X 65	93	
-	1	455888-5	SPACER, CRIMPER	82	
-	1	1-240641-8	SPACER	81	
-	1	1803607-3	DOCUMENTATION PACKAGE	71	
-	1	2119740-1	TAG, IDENTIFICATION	67	
-	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66	
-	2	2-18032-5	SCR, SET, FLT PNT, M5 X 20.0	61	
-	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59	
-	1	1-1338683-0	FEED PAWL	56	
-	2	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	53	
-	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49	
-	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41	
-	1	2-189124-5	GUIDE, FRONT STRIP	30	
-	1	2305692-7	PLATE, REAR STRIP GUIDE	29	
-	2	22283-1	SPRING, COMPRESSION	27	
-	1	356835-1	LEVER, DRAG RELEASE	26	
-	1	240792-1	DRAG, TERMINAL	25	
-	1	980371-4	SCR, SKT HD SHLDR 5.0 DIA X 6.0	23	
-	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21	
-	1	1-18028-2	WASHER, FLAT, REG M4	20	
-	1	2119533-3	STRIPPER, SIDE FEED	19	
-	1	189369-1	HOLD DOWN, TERMINAL	18	
-	1	690463-1	FLOATING SHEAR, REAR	17	
-	2	1-2168083-1	SCR, SKT HD CAP, RoHS, M3 X 6	16	
-	1	690464-2	SHEAR PLATE, REAR	15	
-	1	2119862-1	SHEAR HOLDER, REAR	14	
-	1	3-22280-3	SPRING, COMPRESSION	12	
-	-	-	-	10	
-	1	454766-9	ANVIL, INSULATION	9	
-	1	467660-4	ANVIL, WIRE	8	
-	-	-	-	7	
-	1	690468-6	DEPRESSOR SHEAR, REAR	6	
-	-	-	-	5	
-	1	3-238009-6	BLOCK, FL CRIMPER SPACER	4	
-	1	1803130-3	CRIMPER, INSULATION FASTON	3	
-	-	-	-	2	
-	1	467661-1	CRIMPER, CONFINED WIRE	1	
-	77	-22	PART NO	DESCRIPTION	ITEM NO

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG	
mm	0 PLC ±	1 PLC ±	2 PLC ±	WEAVER	25MAY2016
mm	3 PLC ±	4 PLC ±	ANGLES	C. TOPPER	25MAY2016
MATERIAL	FINISH	APVD	PRODUCT SPEC	NAME	
			APPLICATION SPEC		
		WEIGHT	RESTRICTED TO	SIZE	CAGE CODE
				A1	00779
				Customer Accessible Production Drawing	
				SCALE	1:2
				SHEET	3 OF 4
				REV	E

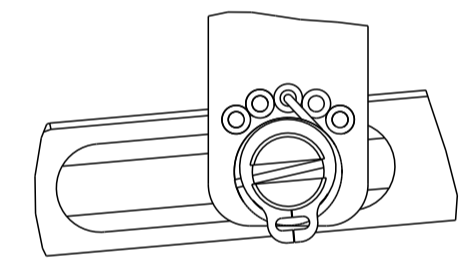
LOC	DIST	REV	DATE	BY	APPD
A	66				

FEED TYPE

PNEUMATIC

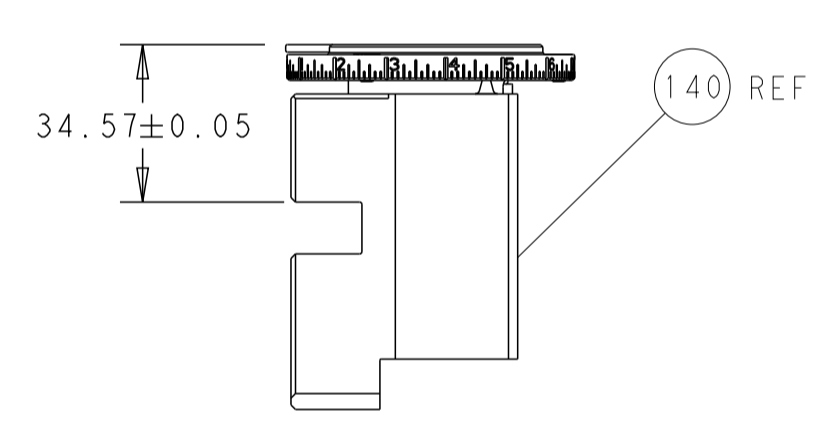
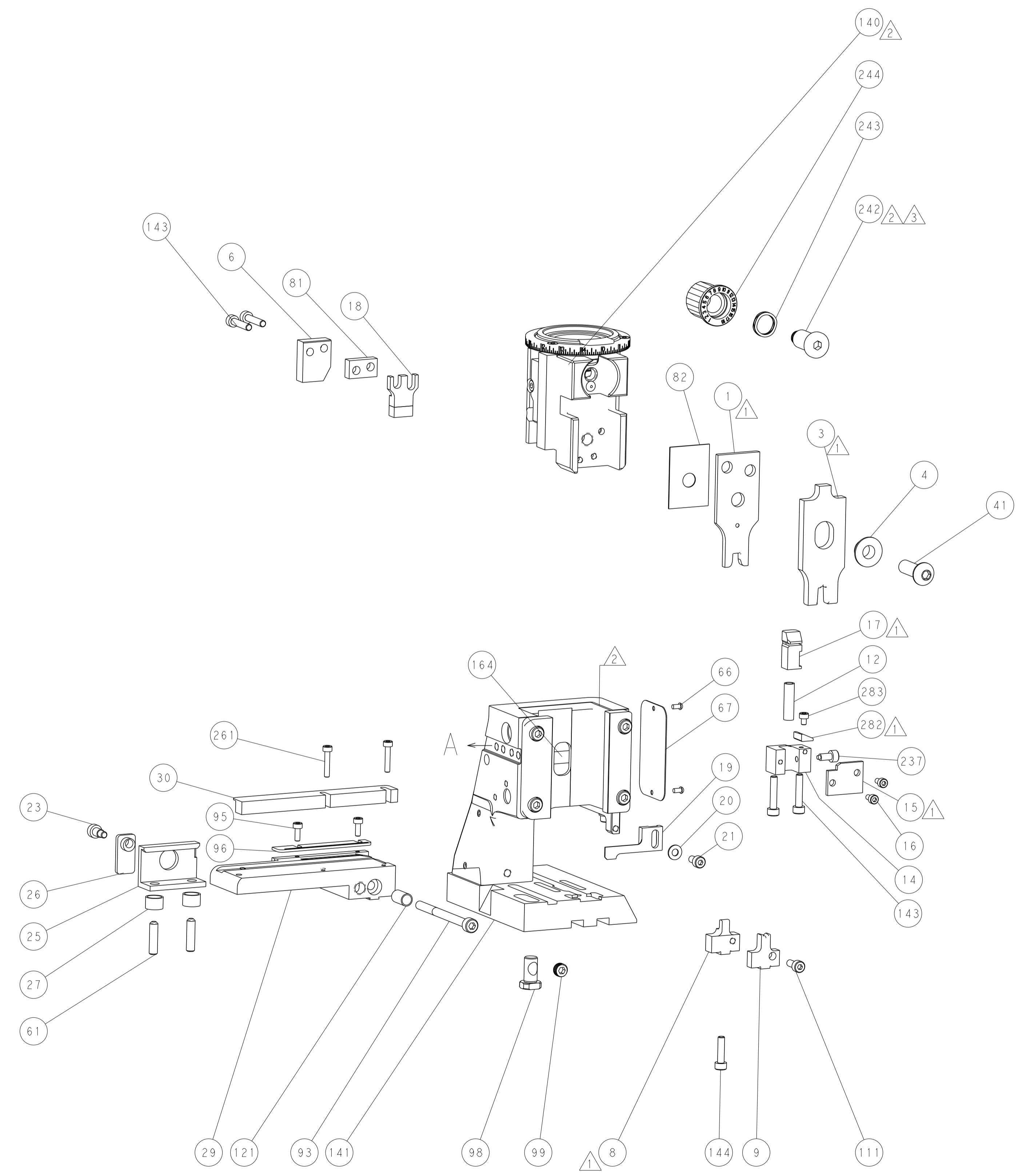
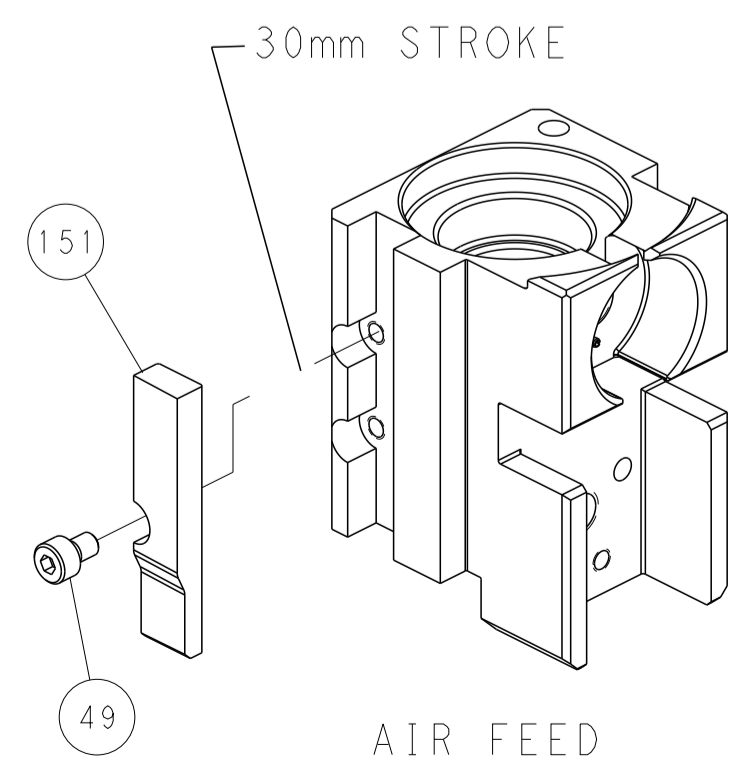


FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)

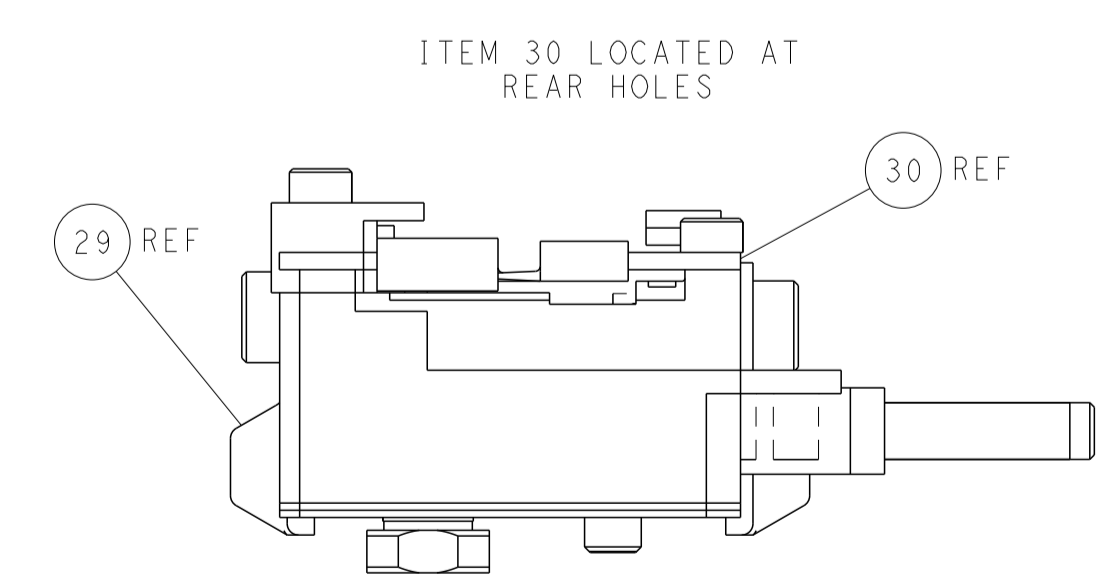


DETAIL A

CAM POSITION



RAM SET-UP



FEED TRACK POSITION
GUIDE BY INSULATION BARREL

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 2016. ALL RIGHTS RESERVED. THIS 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 UPON REQUEST.</small>		DWN B. WEAVER 25MAY2016 CHK C. TOPPER 25MAY2016 APVD C. TOPPER 25MAY2016	NAME Ocean Side Feed Applicator
DIMENSIONS: mm 	TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH	SIZE CAGE CODE DRAWING NO A1 00779 C=2836324	RESTRICTED TO -
MATERIAL	FINISH	WEIGHT	SCALE 1:2 SHEET 4 OF 4 REV E