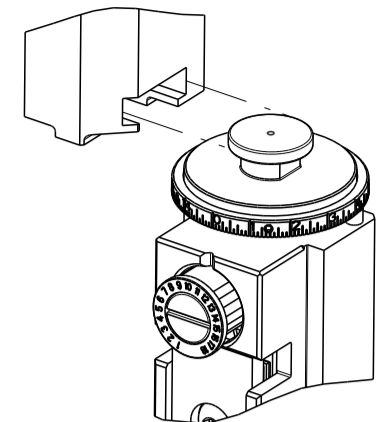


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2836545-2	J	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
3-2836545-2	J	FINE CRIMP HEIGHT ADJUST	DOUBLE ACTING PNEUMATIC WITH SENSORS
5-2836545-2	J	SEAL STRIPPER CRIMPER TERMINATING UNIT	PNEUMATIC
7-2836545-2	J	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2836545-7	A	CRIMP TOOLING KIT	-

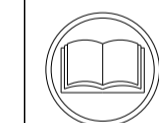
ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.07 mm [.042]	F
INSUL	1.27 mm [.050]	O
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: MCON TERMINAL			
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE		
3.55-3.75 mm [.140-.148 IN]	Ø1.20-1.30 mm [.047-.051 IN]		
TERMINAL APPLICATION SPECIFICATION	114-94191		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
2177909-1	2177909-3	1-2177909-1	1-2177909-2
8-2177909-3			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.35mm2	0.78+/- .02 [.0307+/- .0008]	9.6



- 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 LUBRICANT IS RECOMMENDED.
- 6. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- 7 PRODUCTION ONLY ALLOWED WITH TOOLS WITH PNEUMATIC FEED. MECHANICAL FEED IS NOT ALLOWED.
- 8 THIS APPLICATOR IS EQUIPPED WITH THE DOUBLE ACTING FEED WITH SENSORS AND IS APPLICATION SPECIFIC AND DOES NOT REQUIRE ITEMS 49 & 248.
- 9 THIS APPLICATOR DOES NOT CUT CARRIER STRIP.

\*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
		G1		ECR-21-123441	08DEC2021	FZ	YY
		H		ECR-22-127331	21JAN2022	FJ	RK
		H1		ECR-22-135196	06APR2022	JWC	TE
		J		ECR-22-144271	29JUN2022	JWC	TE

-	1	1	1	1	1-1803945-3	TONKER	300
-	1	1	1	1	22278-9	SPRING, COMPRESSION	299
-	2	2	2	2	4-18032-3	SCR, SET, FLT PNT, M3 X 6.0	298
-	1	1	1	1	1803944-1	SPACER, TONKER	297
-	-	1	-	-	2-1803583-1	APPLICATOR BASIC ASSEMBLY, SF	292
-	-	-	1	-	2844950-1	AIR FEED MODULE	290
8	-	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	2844940-1	AIR FEED MODULE	238
-	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	1	1	1	1	1-22281-8	SPRING, COMPRESSION	121
5	-	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	2168083-6	SCR, SKT HD CAP, RoHS, M5 X 6.5	97
-	2	2	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	96
-	1	1	1	1	1-690438-0	FRONT STRIP GUIDE	95
-	1	1	1	1	455888-4	SPACER, CRIMPER	82
-	1	1	1	1	1803607-3	DOCUMENTATION PACKAGE	71
-	1	1	1	1	2119791-9	DEPRESSOR, WIRE	70
-	1	1	1	1	2119943-1	WASHER, SPACER	69
-	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
-	2	2	2	2	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	53
8	-	1	1	-	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	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	2-18032-5	SCR, SET, FLT PNT, M5 X 20.0	36
-	1	1	1	1	8-1752356-4	SUPPORT, TERMINAL	34
-	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	1	1	1	1	2-1722335-1	THREAD BOLT GEWINDEBOLZEN	31
-	2	2	2	2	2-2844962-3	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	1	1	2844938-1	PLATE, STRIP GUIDE	29
-	2	2	2	2	22283-1	SPRING, COMPRESSION	27
-	1	1	1	1	356835-1	LEVER, DRAG RELEASE	26
-	1	1	1	1	1803142-1	DRAG, TERMINAL	25
-	1	1	1	1	1320928-2	STRIP GUIDE	24
-	1	1	1	1	980371-4	SCR, SKT HD SHLDR 5.0 DIA X 6.0	23
-	1	-	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
-	2	1	2	2	1-18028-2	WASHER, FLAT, REG M4	20
-	1	-	1	1	2119533-1	STRIPPER, SIDE FEED	19
-	1	1	1	1	3-22280-3	SPRING, COMPRESSION	12
-	1	1	1	1	2-519000-1	SCR, SKT HD CAP M4 X 10.0	11
8	-	1	1	1	2119805-1	SHEAR HOLDER, FRONT	10
8	-	1	1	1	1803095-7	FLOATING SHEAR, FRONT	9
8	1	2	1	1	6-1633620-7	ANVIL, COMBINATION	8
-	1	1	1	1	6-240641-3	SPACER	7
-	1	1	1	1	2119757-8	DEPRESSOR, SHEAR	5
-	1	1	1	1	3-238011-8	BLOCK, CRIMPER SPACER	4
8	1	2	1	1	1803143-6	CRIMPER, INSULATION O	3
8	1	2	1	1	2-1333281-7	CRIMPER, WIRE, F, SMALL WIRE APPLICATION	3

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

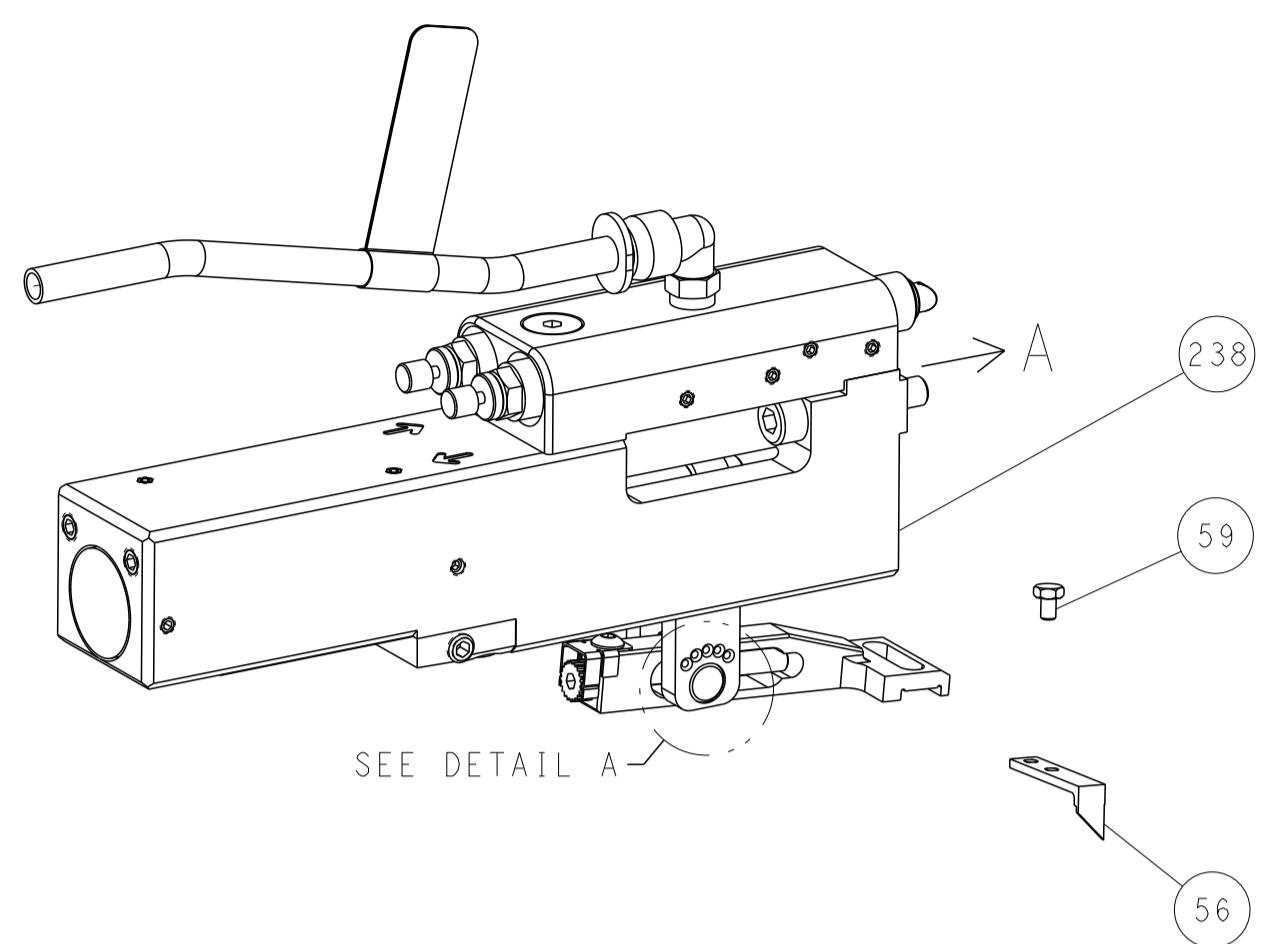
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mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES ±	
MATERIAL:				FINISH:		WEIGHT:	

OWN	M. ZHAO	11NOV2016	
CHK	K. ZHANG	11NOV2016	
APVD	K. ZHANG	11NOV2016	
NAME			
Ocean Side Feed Applicator			
SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
A1	00779	2836545	
Customer Accessible Production Drawing			
SCALE	1:2	SHEET	1 of 4
REV	J		

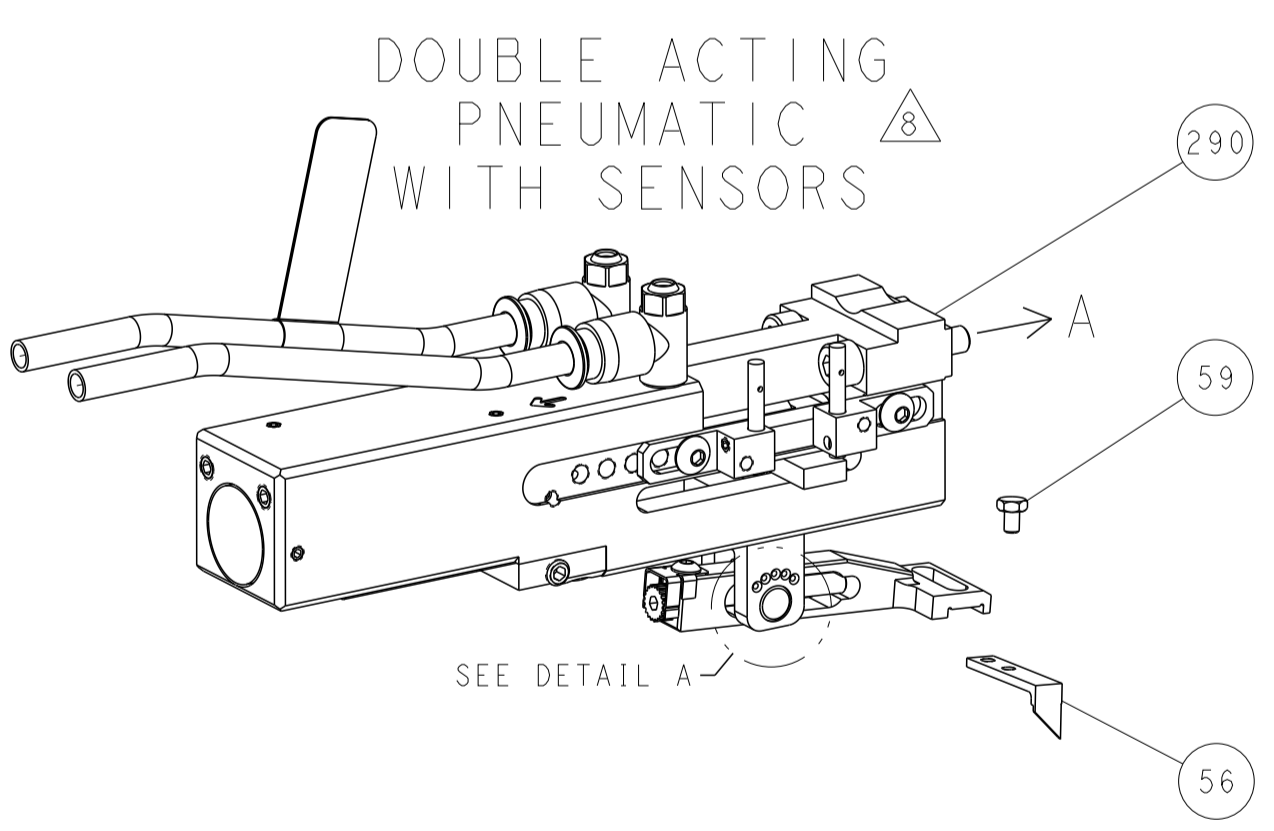
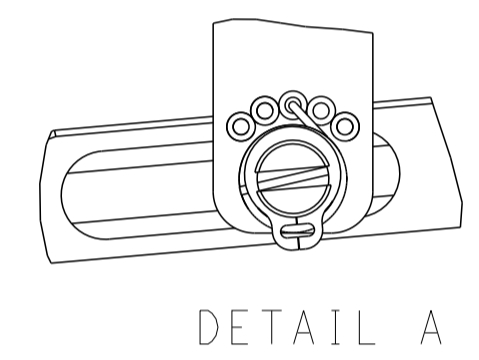
LOC	DIST	REVISIONS					
		P	LTN	DESCRIPTION	DATE	OWN	APVD
A	66	-	-	SEE SHEET 1	-	-	-

# FEED TYPE

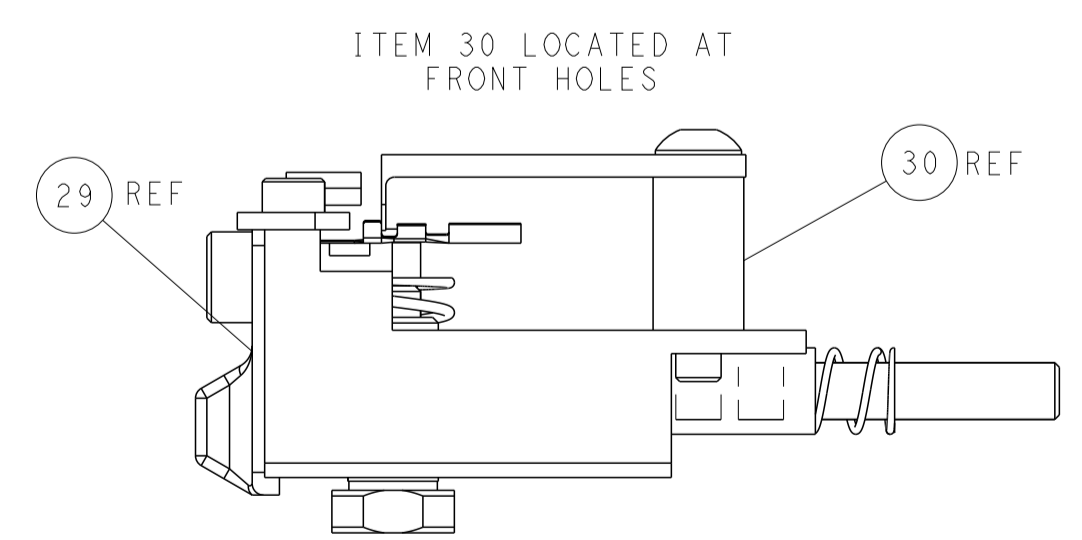
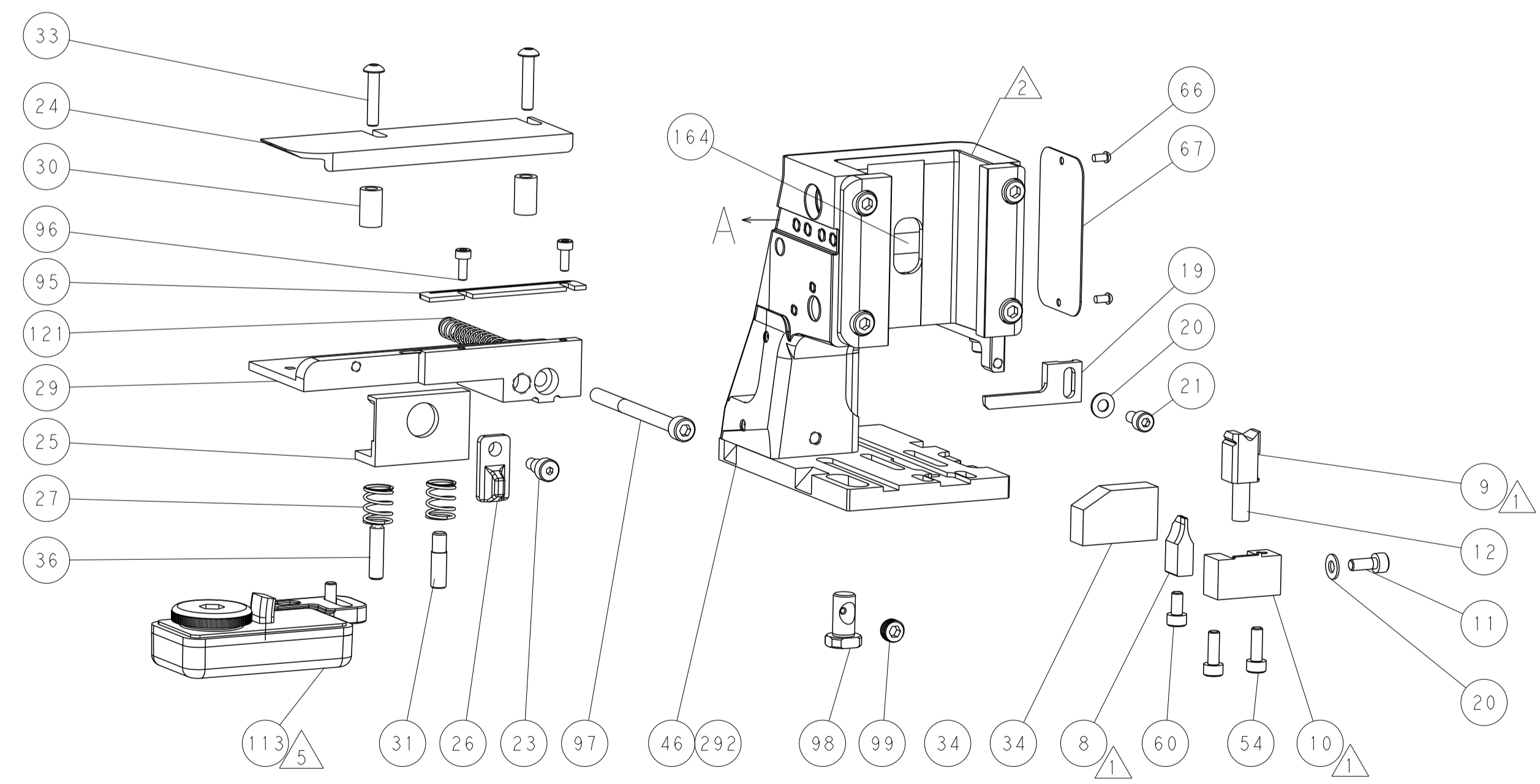
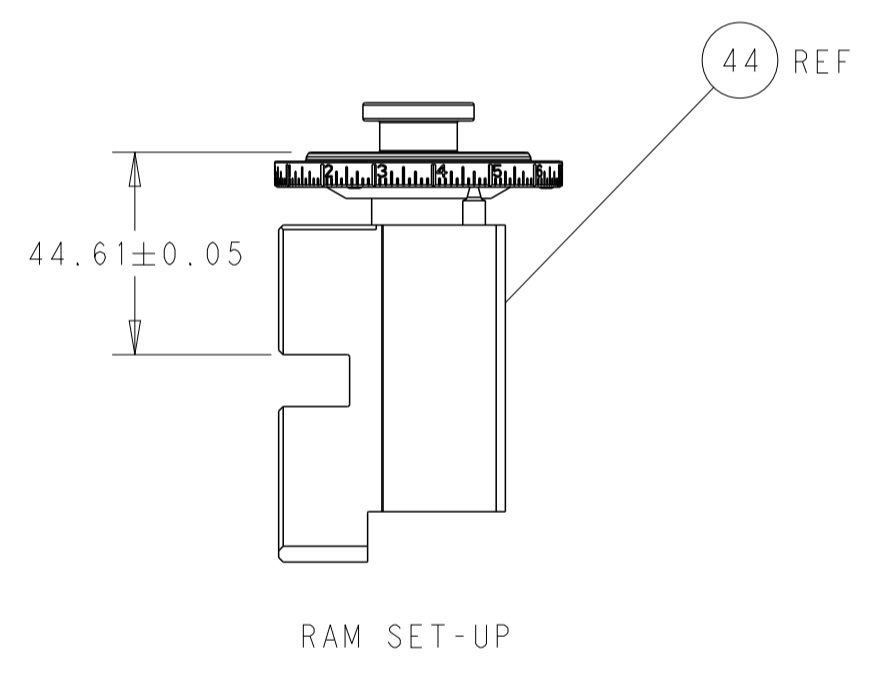
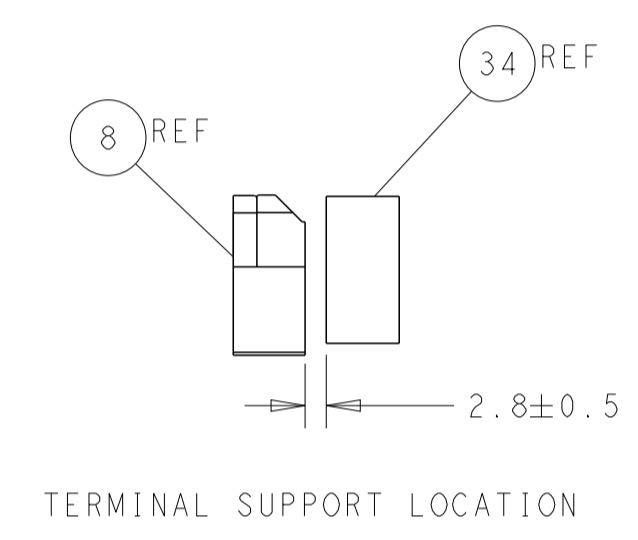
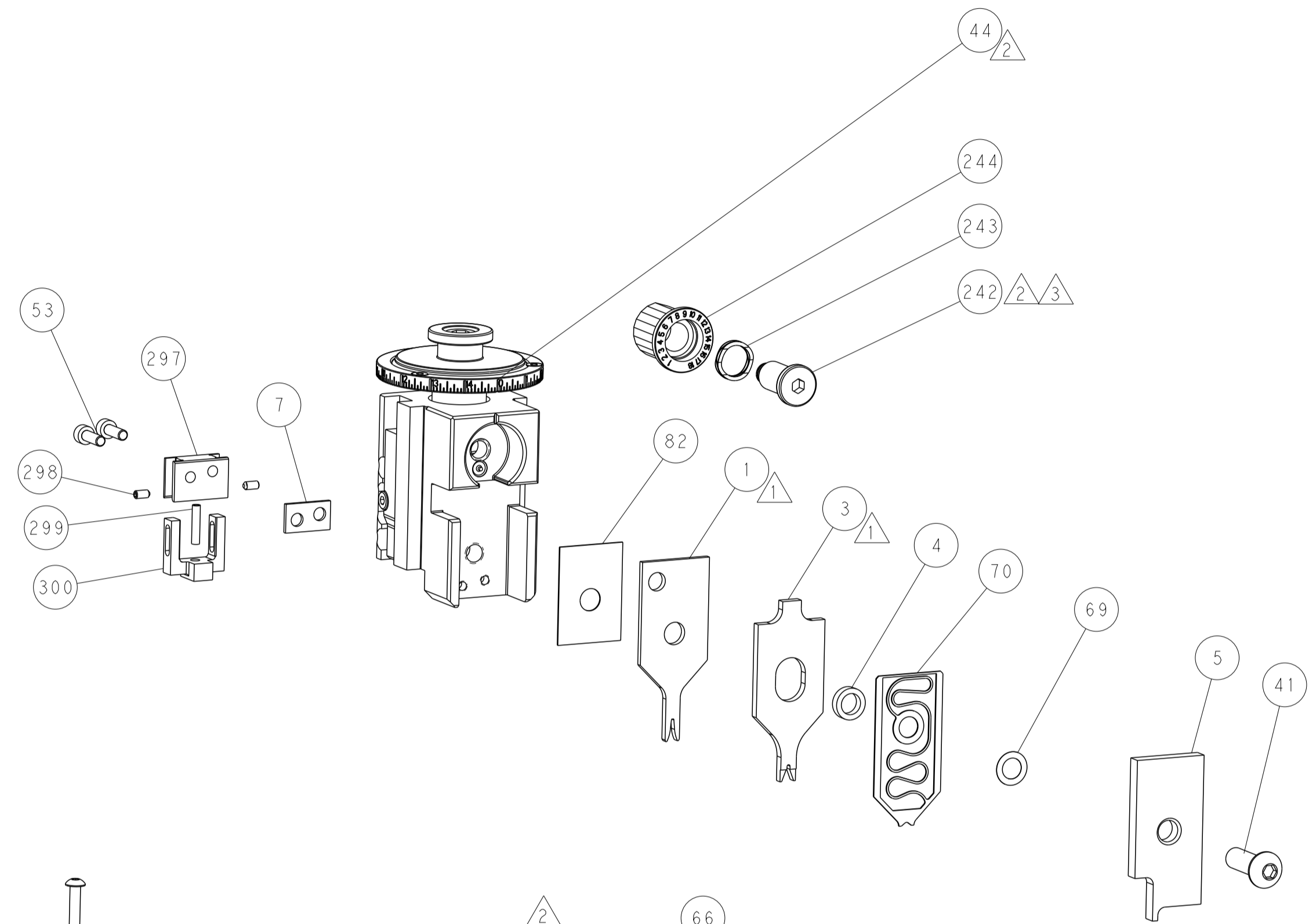
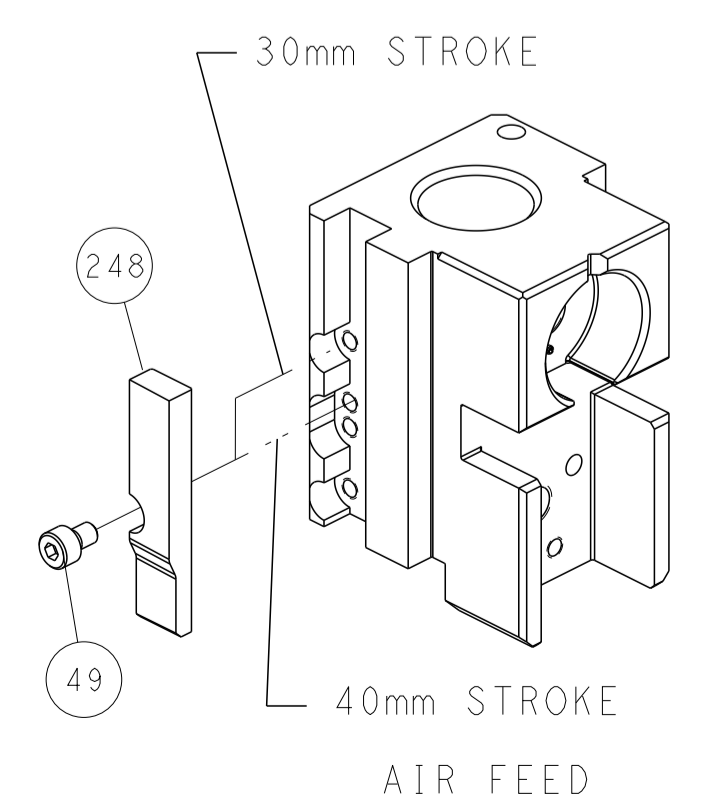
## PNEUMATIC



### FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



## CAM POSITION

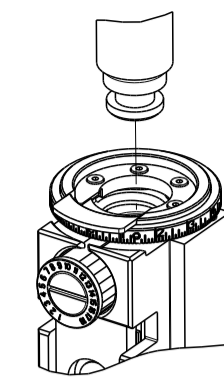


**ATLANTIC VERSION**  
 Shown on sheets 1 of 4 & 2 of 4  
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		OWN: M. ZHAO 11NOV2016	TE Connectivity Harrisburg, PA 17105-3608
mm	0 PLC ±	1 PLC ±	2 PLC ±	CHK: K. ZHANG 11NOV2016	
	3 PLC ±	4 PLC ±	ANGLES ±	APVD: K. ZHANG 11NOV2016	NAME: Ocean Side Feed Applicator
MATERIAL:	FINISH:	WEIGHT:	SCALE: 1:2	SIZE: A1	CAGE CODE: 00779
Customer Accessible Production Drawing				DRAWING NO: C=2836545	RESTRICTED TO: -
				SHEET: 2 OF 4	REV: J

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2836545-2	J	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
4-2836545-2	J	FINE CRIMP HEIGHT ADJUST	DOUBLE ACTNG PNEUMATIC WITH SENSORS
7-2836545-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.07 mm [.042]	F
INSUL	1.27 mm [.050]	0

APPLICATOR INSTRUCTIONS  
408-35042

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: MCON TERMINAL			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
3.55-3.75 mm [.140-.148 IN]		Ø1.20-1.30 mm [.047-.051 IN]	
TERMINAL APPLICATION SPECIFICATION		114-94191	
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
2177909-1	2177909-3	1- 2177909-1	1-2177909-2
8-2177909-3			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.35mm2	0.78+/- .02 [.0307+/- .0008]	9.6

- 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.
- TERMINAL LUBRICANT IS RECOMMENDED.
- 6. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- PRODUCTION ONLY ALLOWED WITH TOOLS WITH PNEUMATIC FEED. MECHANICAL FEED IS NOT ALLOWED.
- THIS APPLICATOR IS EQUIPPED WITH THE DOUBLE ACTING FEED WITH SENSORS AND IS APPLICATION SPECIFIC. IT DOES NOT REQUIRE ITEMS 49 & 151.
- THIS APPLICATOR DOES NOT CUT CARRIER STRIP.

\*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
-	-	-	-	SEE SHEET 1	-	-	-

-	1	1	1-1803945-3	TONKER	300
-	1	1	22278-9	SPRING, COMPRESSION	299
-	2	2	4-18032-3	SCR, SET, FLT PNT, M3 X 6.0	298
-	1	1	1803944-1	SPACER, TONKER	297
-	1	-	2844950-1	AIR FEED MODULE	290
-	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	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	1	1-1803583-0	APPLICATOR BASIC ASSEMBLY, SF	141
-	1	1	1803516-1	RAM ASSEMBLY, SF PACIFIC	140
-	1	1	1-22281-8	SPRING, COMPRESSION	121
-	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	2168083-6	SCR, SKT HD CAP, RoHS, M5 X 65	97
-	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	96
-	1	1	1-690438-0	FRONT STRIP GUIDE	95
-	1	1	455888-4	SPACER, CRIMPER	82
-	1	1	1803607-3	DOCUMENTATION PACKAGE	71
-	1	1	2119791-9	DEPRESSOR, WIRE	70
-	1	1	2119943-1	WASHER, SPACER	69
-	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
-	2	2	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	53
-	-	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
-	1	1	2-18032-5	SCR, SET, FLT PNT, M5 X 20.0	36
-	1	1	8-1752356-4	SUPPORT, TERMINAL	34
-	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	1	1	2-1722335-1	THREAD BOLT GEWINDEBOLZEN	31
-	2	2	2-2844962-3	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	2844938-1	PLATE, STRIP GUIDE	29
-	2	2	22283-1	SPRING, COMPRESSION	27
-	1	1	356835-1	LEVER, DRAG RELEASE	26
-	1	1	1803142-1	DRAG, TERMINAL	25
-	1	1	1320928-2	STRIP GUIDE	24
-	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
-	2	2	1-18028-2	WASHER, FLAT, REG M4	20
-	1	1	2119533-1	STRIPPER, SIDE FEED	19
-	1	1	3-22280-3	SPRING, COMPRESSION	12
-	1	1	2-519000-1	SCR, SKT HD CAP M4 X 10.0	11
-	1	1	2119805-1	SHEAR HOLDER, FRONT	10
-	1	1	1803095-7	FLOATING SHEAR, FRONT	9
-	1	1	6-1633620-7	ANVIL, COMBINATION	8
-	1	1	6-240641-3	SPACER	7
-	1	1	2119757-8	DEPRESSOR, SHEAR	5
-	1	1	3-238011-8	BLOCK, CRIMPER SPACER	4
-	1	1	1803143-6	CRIMPER, INSULATION O	3
-	1	1	2-1333281-7	CRIMPER, WIRE, F, SMALL WIRE APPLICATION	1

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

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

ITEM NO	DESCRIPTION	DATE	OWN	APVD
-77-42-22	PART NO	11NOV2016	M. ZHAO	K. ZHANG

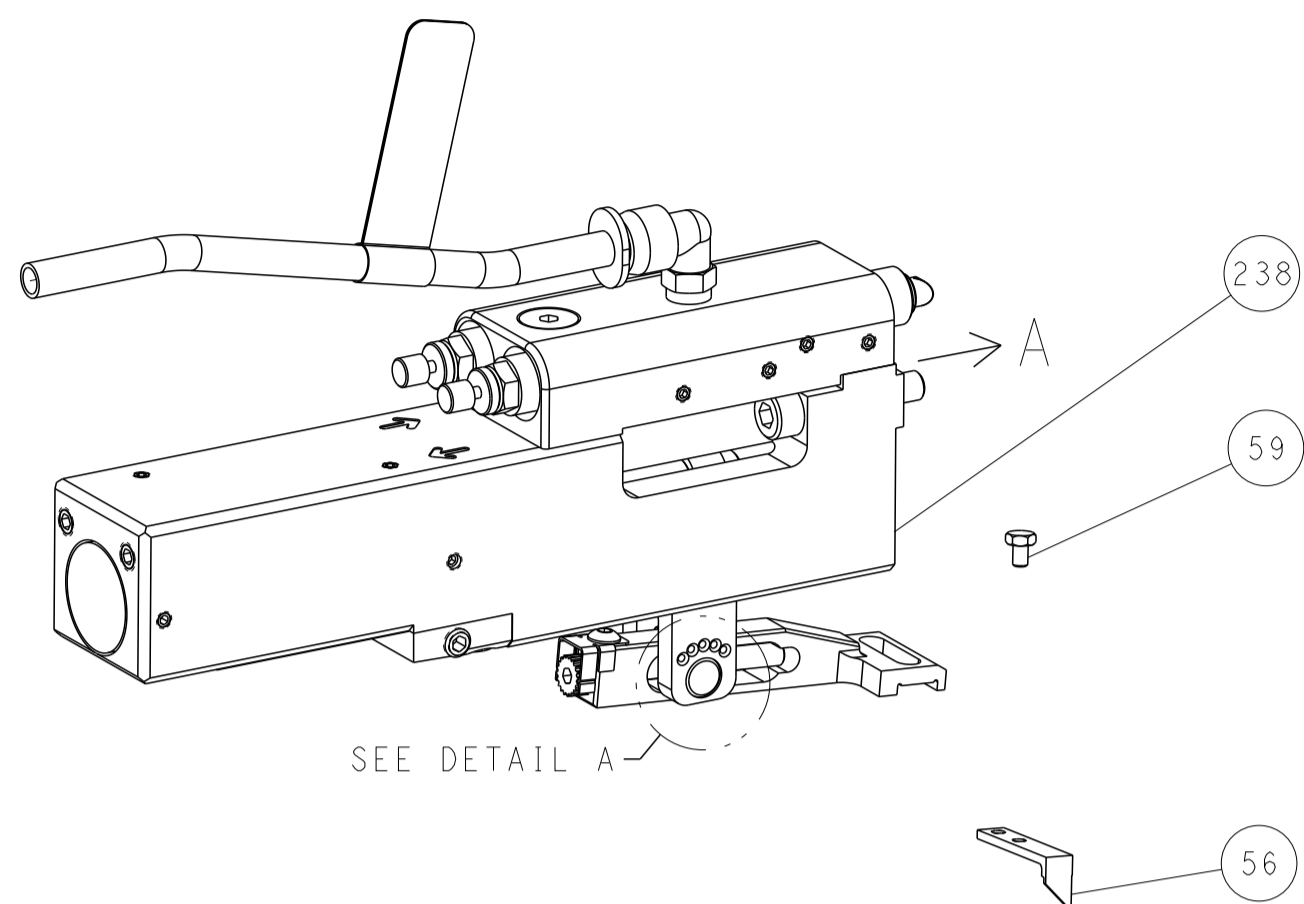
SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
A1	00779	2836545	-

Customer Accessible Production Drawing SCALE 1:2 SHEET 3 OF 4 REV J

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

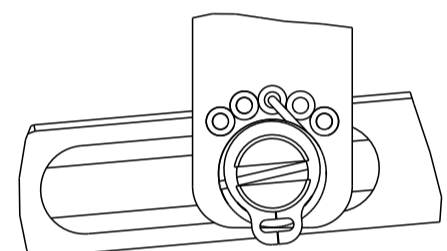
# FEED TYPE

## PNEUMATIC



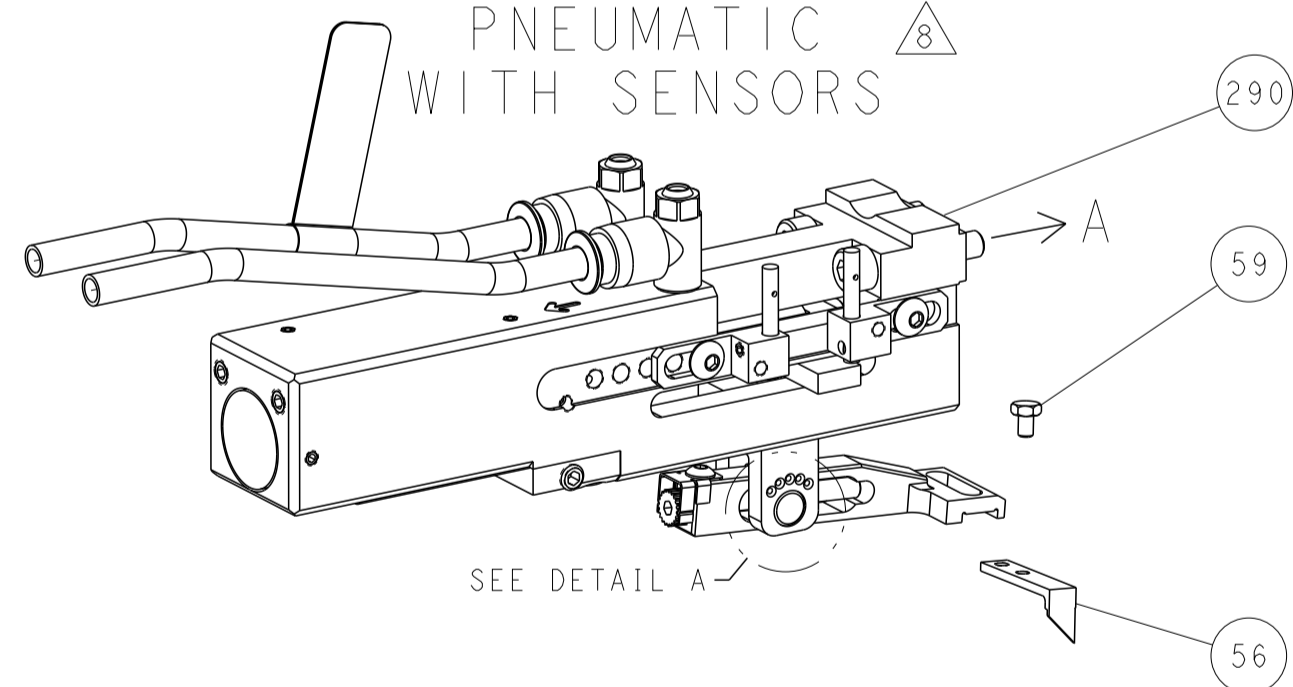
SEE DETAIL A

### FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



DETAIL A

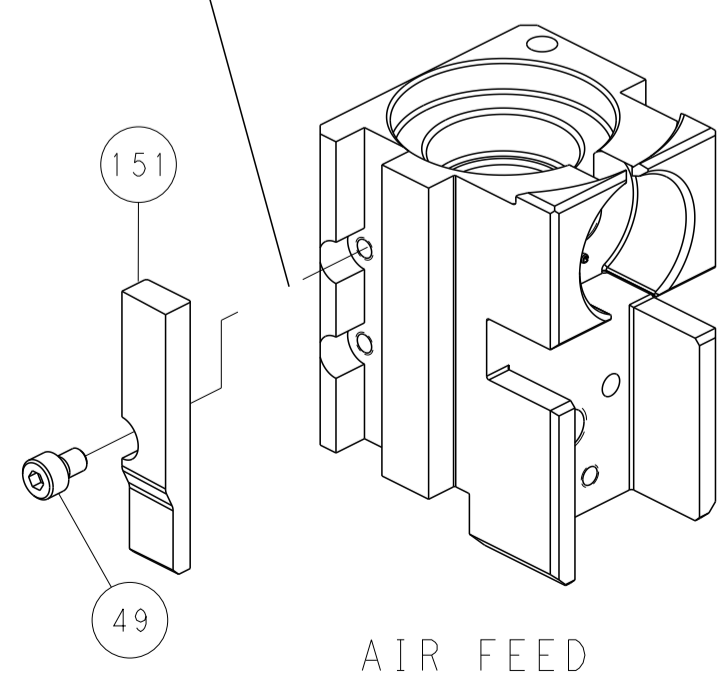
### DOUBLE ACTING PNEUMATIC WITH SENSORS



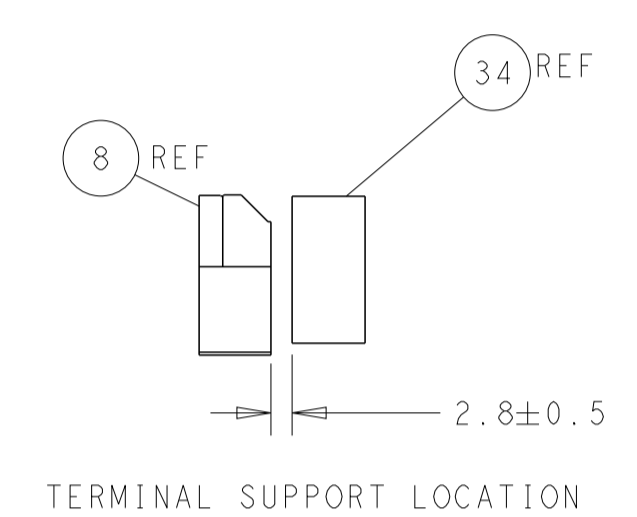
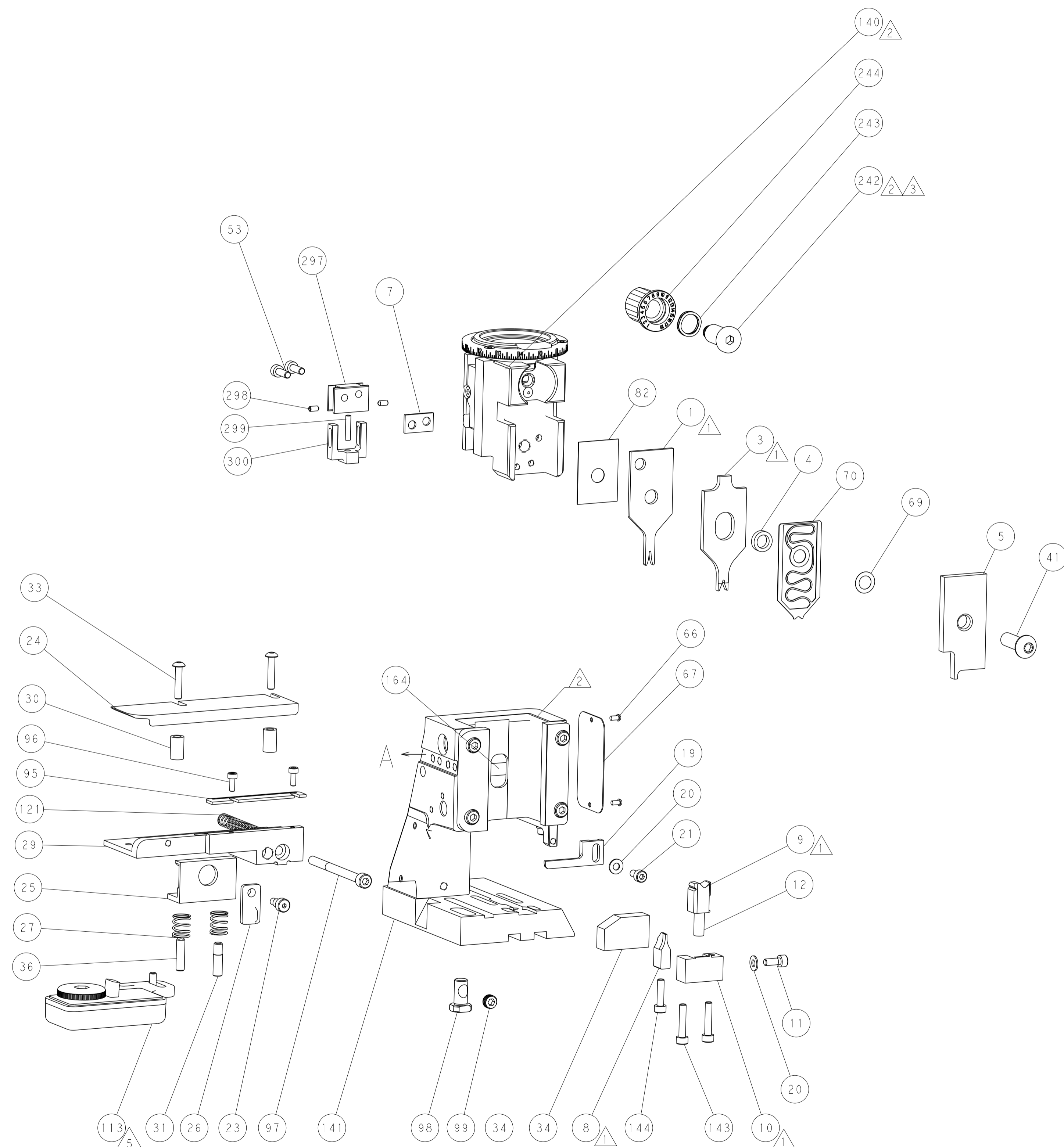
SEE DETAIL A

## CAM POSITION

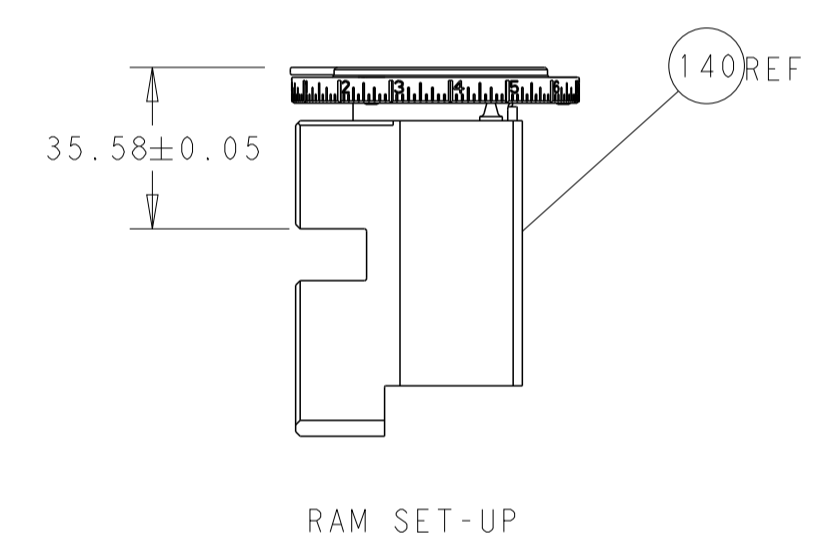
30mm STROKE



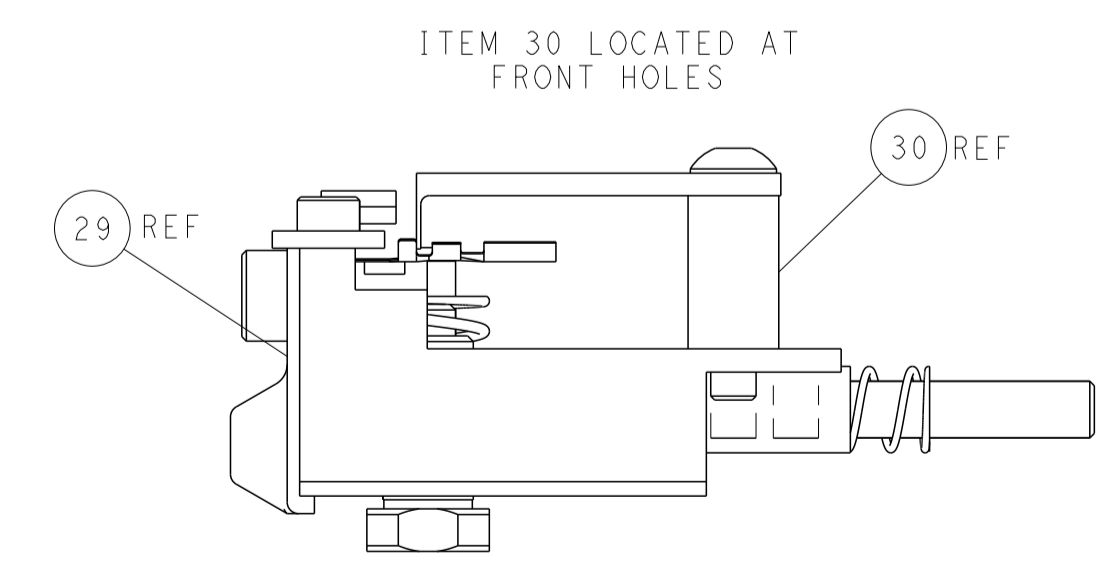
AIR FEED



TERMINAL SUPPORT LOCATION



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 2011. IT IS THE PROPERTY OF TYCO ELECTRONICS CORPORATION. IT IS TO BE USED ONLY FOR THE PROJECT AND INSTALLED ORGANIZATION. SHOULD BE CONTACTED FOR THE LATEST REVISION.</small>		DMN: M. ZHAO 11NOV2016 CHK: K. ZHANG 11NOV2016 APVD: K. ZHANG 11NOV2016	TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH ±		NAME: Ocean Side Feed Applicator PRODUCT SPEC: APPLICATION SPEC: SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2836545	RESTRICTED TO: SCALE: 1:2 SHEET: 4 OF 4 REV: J
MATERIAL:		WEIGHT: Customer Accessible Production Drawing	