

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2836580-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2836580-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2836580-1	B	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2836580-2	B	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2836580-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.78 mm [.070]	F
INSUL	2.29 mm [.090]	OV

APPLICATOR INSTRUCTIONS 408-35042

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: 2.8mm FASTIN FASTON TAB			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
3.50-4.10 mm [.138-.161 IN]		Ø1.15-1.60 mm [.045-.063 IN]	
TERMINAL APPLICATION SPECIFICATION	114-18014		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
963961-1	963961-2	963961-4	963961-5

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.50mm2	1.21+/-0.03 [.048+/-0.001]	5.7
0.35mm2	1.14+/-0.03 [.045+/-0.001]	6.3
0.25mm2	1.10+/-0.03 [.043+/-0.001]	6.9
0.20mm2	1.08+/-0.03 [.043+/-0.001]	7.1



- 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.

***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	02MAR2017	TB	CT
		B		ECR-20-016913	28NOV2020	TB	RR

-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248	
-	1	1	1	1	2119082-4	CAM, SNAIL, INSULATION ADJUSTMENT	244	
-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243	
-	1	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	-	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	
-	1	1	1	1	1338685-1	PAWL, FEED	56	
-	4	4	4	4	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	54	
-	2	2	2	2	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	53	
-	1	1	1	1	1803382-1	HOLD DOWN, SPRING LOADED	50	
-	1	2	1	2	18023-9	SCR, SKT HD CAP M4 X 6.0	49	
-	-	1	-	1	2119652-1	FEED CAM, PRE FEED	48	
-	-	1	-	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	1752356-2	SUPPORT, TERMINAL	34	
-	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33	
-	2	2	2	2	2-2844962-6	SPACER, CYLINDRICAL, STRIP GUIDE	30	
-	1	1	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29	
-	1	1	1	1	455888-5	SPACER, CRIMPER	28	
-	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	1803095-6	FLOATING SHEAR, FRONT	9	
-	1	2	2	1	1	6-1633919-6	ANVIL, COMBINATION	8
-	1	1	1	1	1-240641-8	SPACER	7	
-	-	-	-	-	-	-	6	
-	1	1	1	1	2119757-4	DEPRESSOR, SHEAR	5	
-	1	1	1	1	2-238011-2	BLOCK, CRIMPER SPACER	4	
-	1	2	2	1	1	3-2119785-0	CRIMPER, INSULATION OVERLAP PREMIUM	3
-	1	1	1	1	1-455888-2	SPACER, CRIMPER	2	
-	1	2	2	1	1	5-568176-6	CRIMPER, WIRE	1
-	77	-72	-71	-2	-1	PART NO	ITEM NO	

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

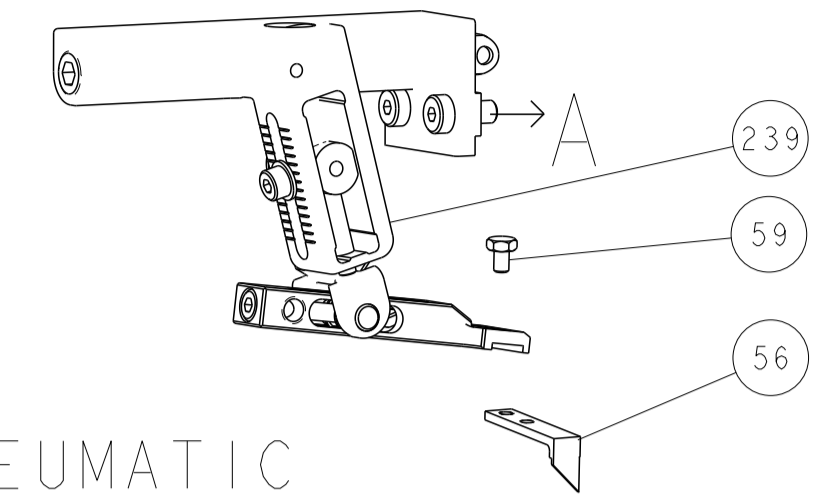
APVD	CHK	DATE	NAME
K. ZHANG	M. ZHAO	05JAN2017	K. ZHANG
05JAN2017			

SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
A1	00779	2836580	

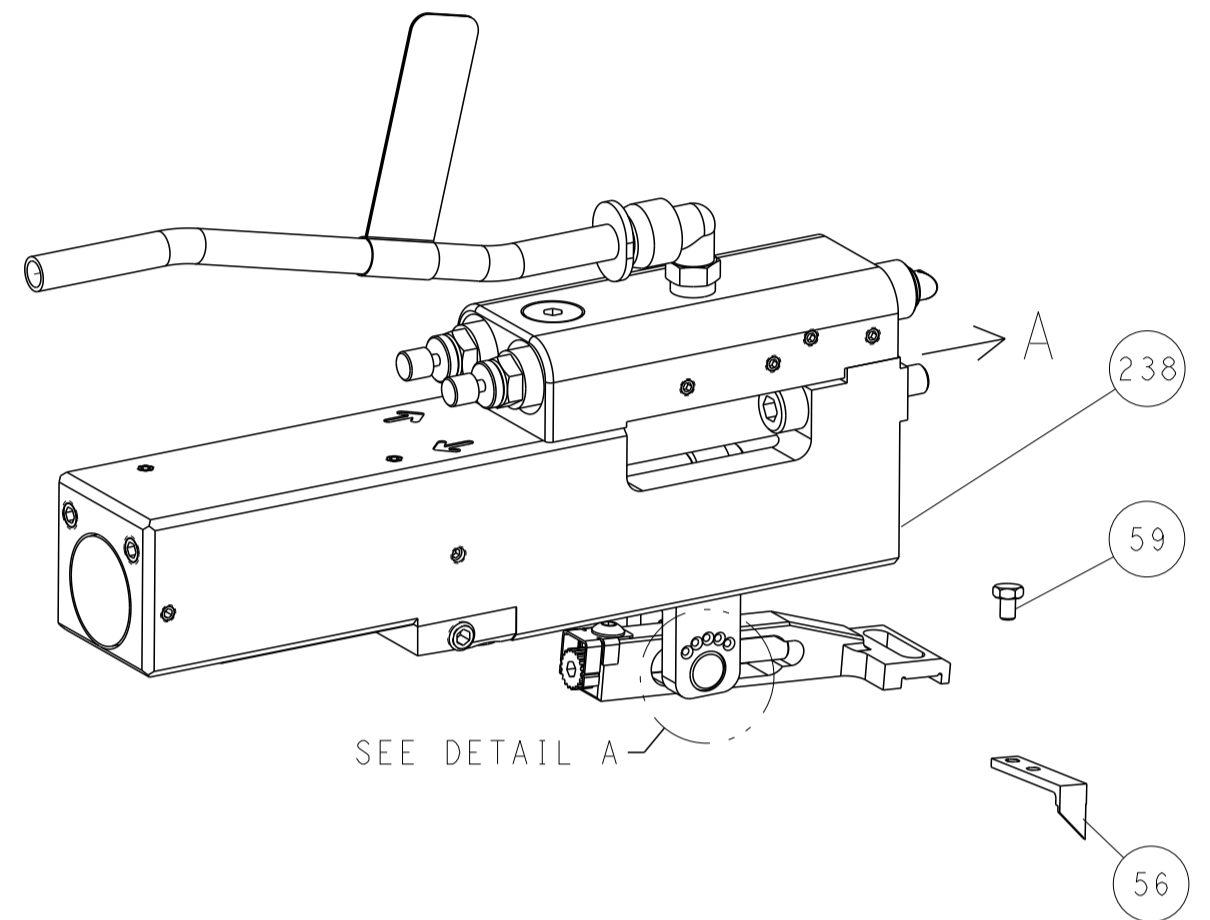
Customer Accessible Production Drawing SCALE 1:2 SHEET 1 OF 4 REV B

REV ISIONS		DATE	DNW	APVD
P	LTN			
		SEE SHEET 1		

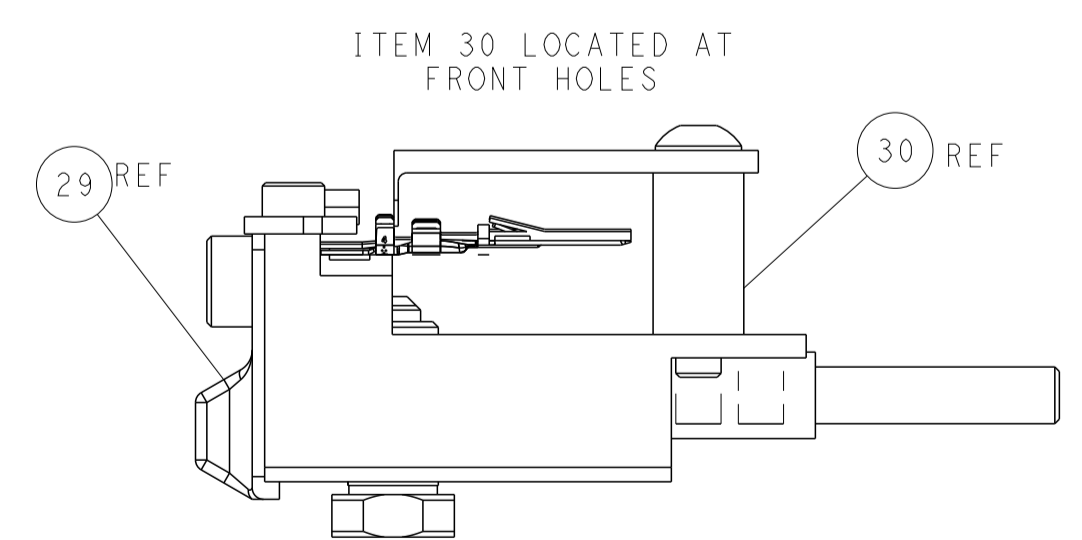
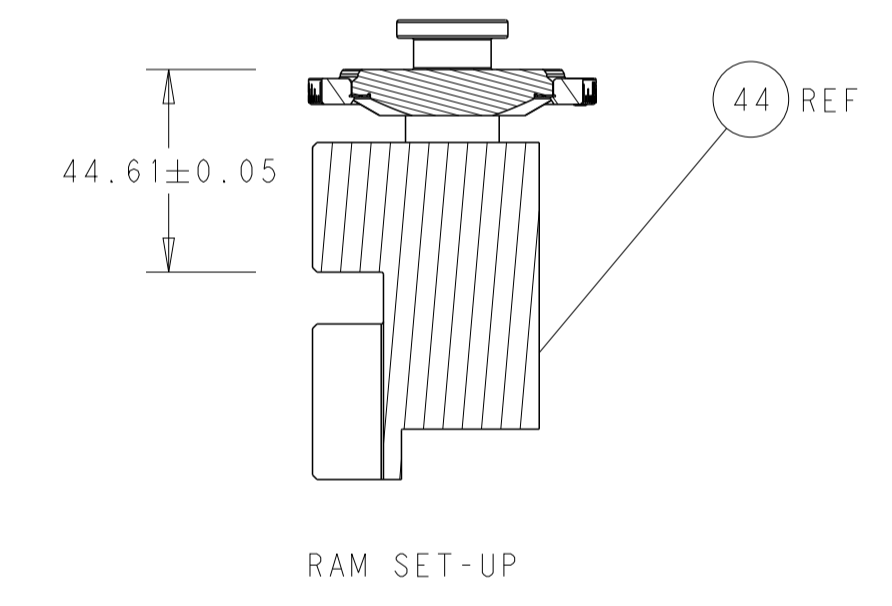
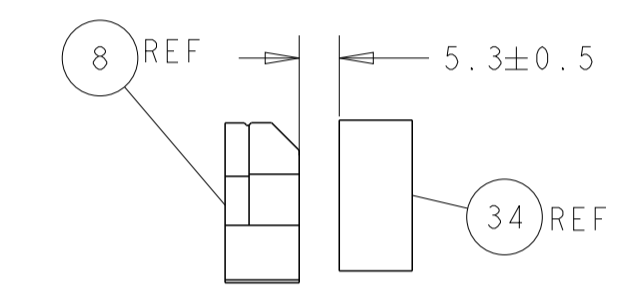
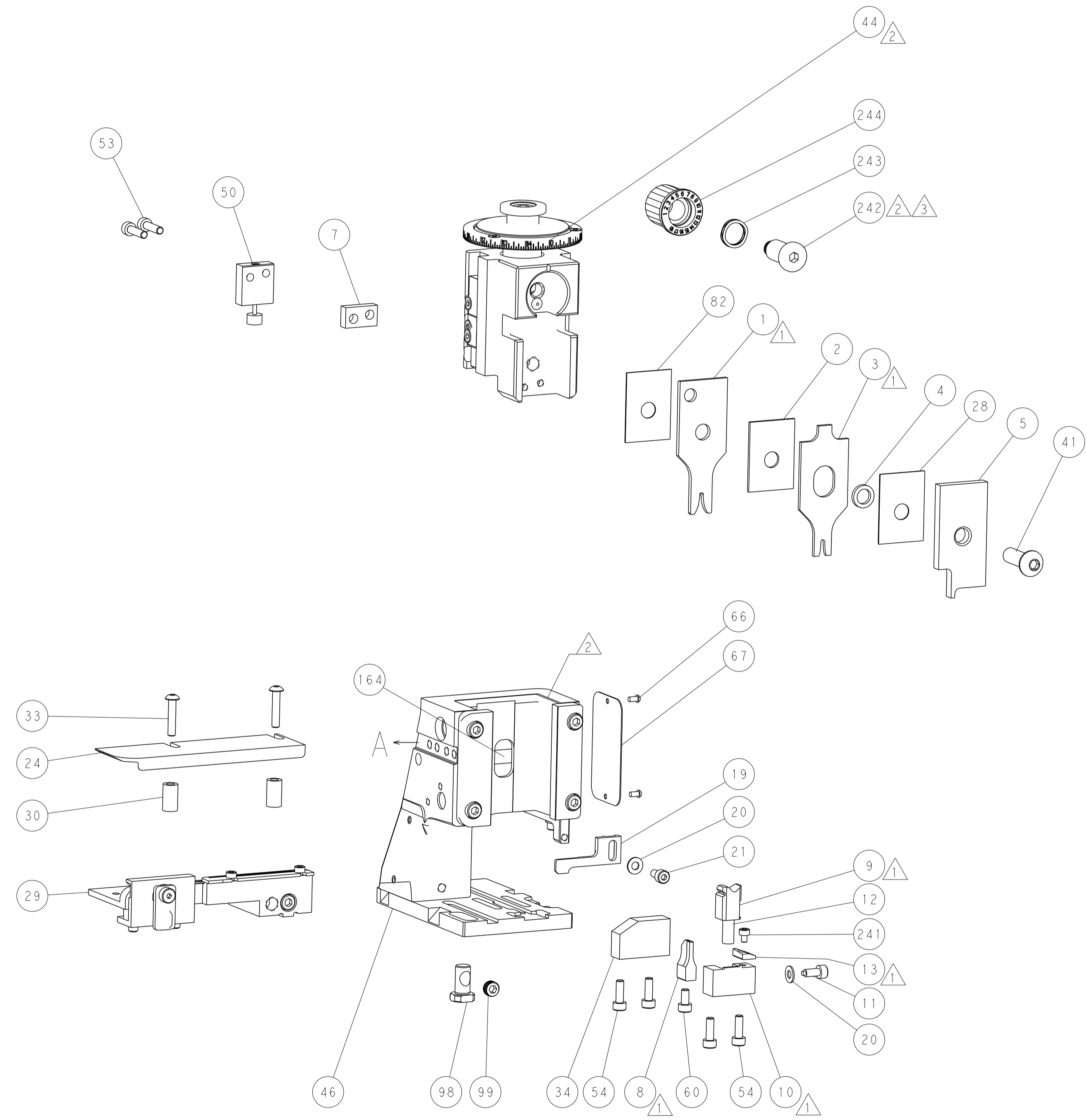
FEED TYPE MECHANICAL



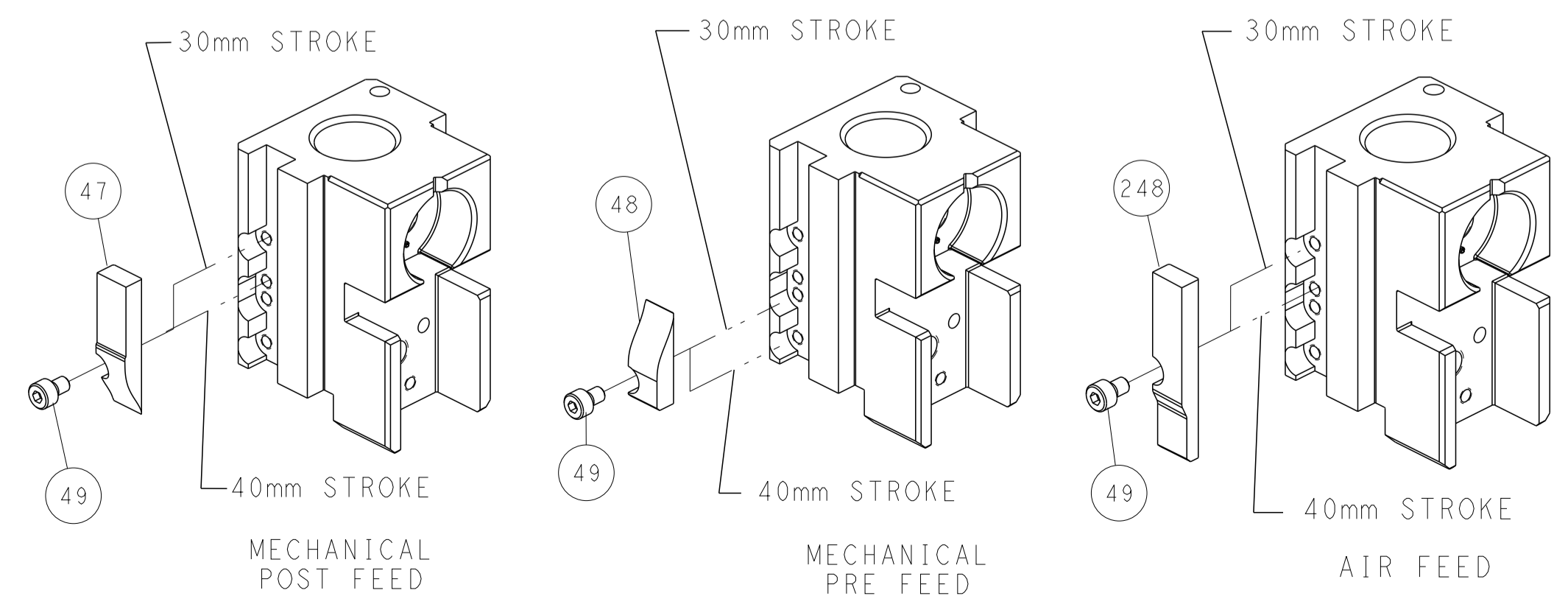
PNEUMATIC



FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



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:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DNW	05JAN2017	TE Connectivity Harrisburg, PA 17105-3608
mm	0 PLC ±	1 PLC ±	2 PLC ±	CHK	05JAN2017	
	3 PLC ±	4 PLC ±	5 PLC ±	APVD	05JAN2017	NAME
	6 PLC ±	7 PLC ±	8 PLC ±			Ocean Side Feed Applicator
	9 PLC ±	10 PLC ±	11 PLC ±			SIZE
	12 PLC ±	13 PLC ±	14 PLC ±			CAGE CODE
	15 PLC ±	16 PLC ±	17 PLC ±			DRAWING NO
	18 PLC ±	19 PLC ±	20 PLC ±			RESTRICTED TO
	21 PLC ±	22 PLC ±	23 PLC ±			SCALE
	24 PLC ±	25 PLC ±	26 PLC ±			1:2
	27 PLC ±	28 PLC ±	29 PLC ±			SHEET
	30 PLC ±	31 PLC ±	32 PLC ±			2 of 4
	33 PLC ±	34 PLC ±	35 PLC ±			REV
	36 PLC ±	37 PLC ±	38 PLC ±			B
	39 PLC ±	40 PLC ±	41 PLC ±			
	42 PLC ±	43 PLC ±	44 PLC ±			
	45 PLC ±	46 PLC ±	47 PLC ±			
	48 PLC ±	49 PLC ±	50 PLC ±			
	51 PLC ±	52 PLC ±	53 PLC ±			
	54 PLC ±	55 PLC ±	56 PLC ±			
	57 PLC ±	58 PLC ±	59 PLC ±			
	60 PLC ±	61 PLC ±	62 PLC ±			
	63 PLC ±	64 PLC ±	65 PLC ±			
	66 PLC ±	67 PLC ±	68 PLC ±			
	69 PLC ±	70 PLC ±	71 PLC ±			
	72 PLC ±	73 PLC ±	74 PLC ±			
	75 PLC ±	76 PLC ±	77 PLC ±			
	78 PLC ±	79 PLC ±	80 PLC ±			
	81 PLC ±	82 PLC ±	83 PLC ±			
	84 PLC ±	85 PLC ±	86 PLC ±			
	87 PLC ±	88 PLC ±	89 PLC ±			
	90 PLC ±	91 PLC ±	92 PLC ±			
	93 PLC ±	94 PLC ±	95 PLC ±			
	96 PLC ±	97 PLC ±	98 PLC ±			
	99 PLC ±	100 PLC ±	101 PLC ±			

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2836580-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2836580-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2836580-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.78 mm [.070]	F
INSUL	2.29 mm [.090]	OV
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: 2.8mm FASTIN FASTON TAB			
WIRE STRIP LENGTH 3.50-4.10 mm [.138-.161 IN]		INSULATION DIAMETER RANGE Ø1.15-1.60 mm [.045-.063 IN]	
TERMINAL APPLICATION SPECIFICATION	114-18014	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
963961-1	963961-2	963961-4	963961-5

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
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0.35mm2	1.14+/-0.03 [.045+/-0.001]	6.3
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0.20mm2	1.08+/-0.03 [.043+/-0.001]	7.1

- 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.

***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	CHK	APPV
A	66					

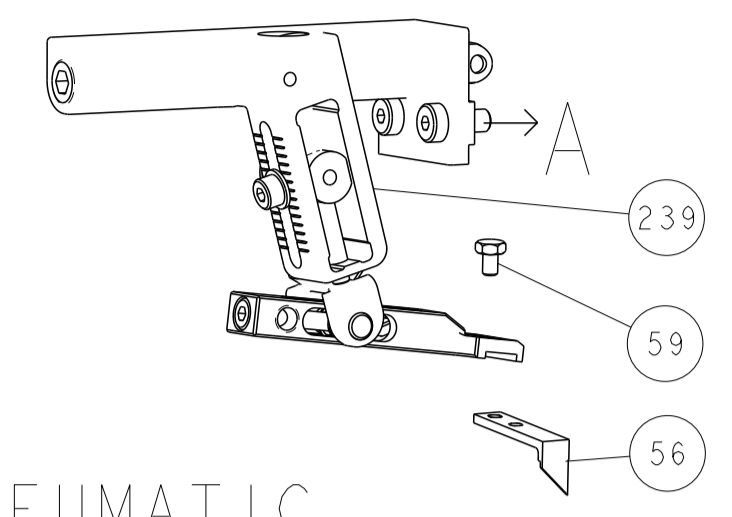
REV	DATE	BY	CHK	APPV	DESCRIPTION	ITEM NO
-	1	1			2119082-4 CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1			2079764-1 WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1			2119083-1 RETAINER, INSULATION DIAL	242
-	1	1			7-18023-7 SCR, SKT HD CAP M3 X 4.0	241
-	-	1			2119580-1 MECHANICAL FEED ASSEMBLY	239
-	1	-			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			1338685-1 PAWL, FEED	56
-	2	2			2168083-8 SCR, SKT HD CAP, RoHS, M4 X 16	53
-	1	1			1803382-1 HOLD DOWN, SPRING LOADED	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			1752356-2 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			2844992-1 ASSEMBLY, STRIP GUIDE	29
-	1	1			455888-5 SPACER, CRIMPER	28
-	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			1803095-6 FLOATING SHEAR, FRONT	9
-	1	1			6-1633919-6 ANVIL, COMBINATION	8
-	1	1			1-240641-8 SPACER	7
-	-	-			-	6
-	1	1			2119757-4 DEPRESSOR, SHEAR	5
-	1	1			2-238011-2 BLOCK, CRIMPER SPACER	4
-	1	1			3-2119785-0 CRIMPER, INSULATION OVERLAP PREMIUM	3
-	1	1			1-455888-2 SPACER, CRIMPER	2
-	1	1			5-568176-6 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)

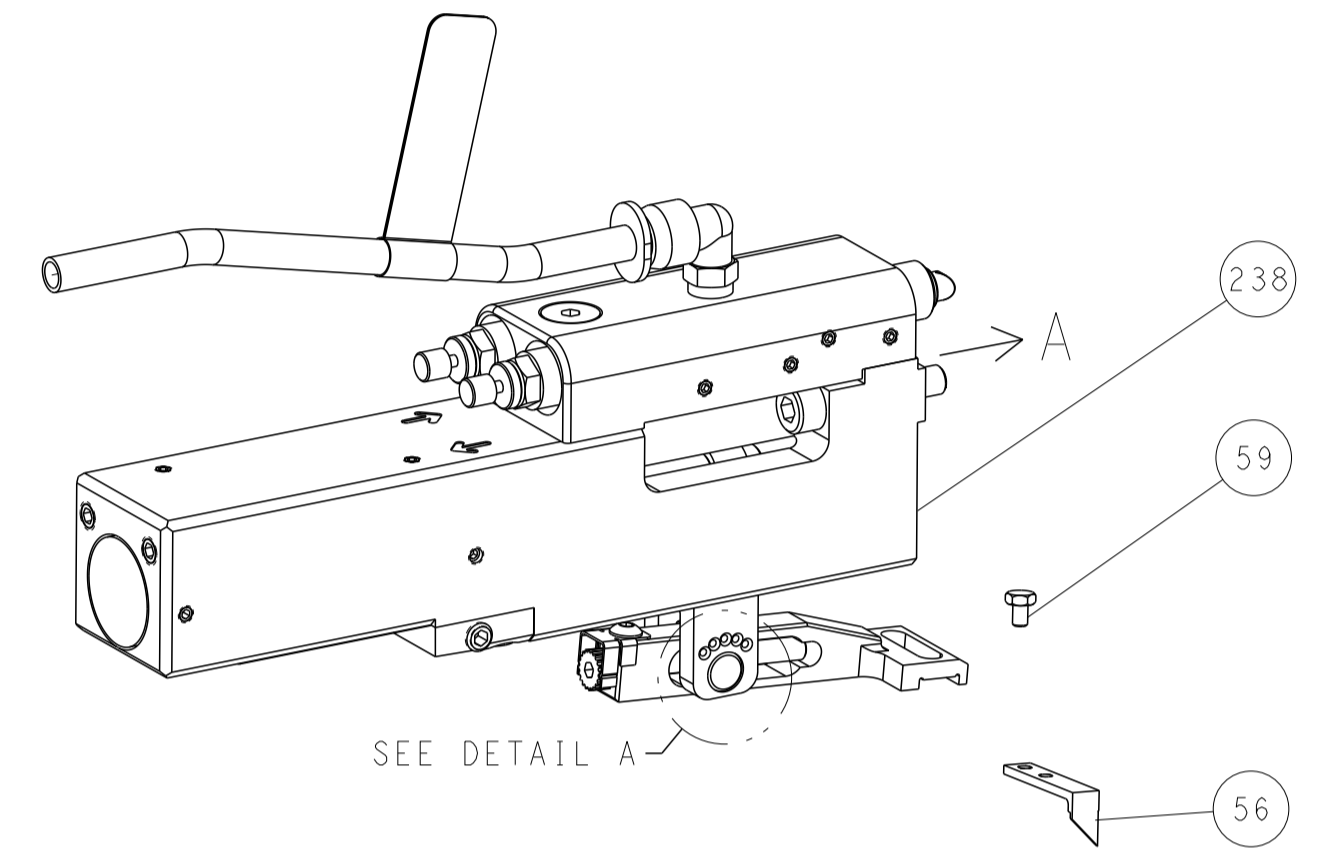
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0 PLC	±	1 PLC	±	APVD: K. ZHANG 05JAN2017	PRODUCT SPEC		SIZE: A1		RESTRICTED TO:
2 PLC	±	3 PLC	±	APPLICATION SPEC		CAGE CODE: 00779		SCALE: 1:2	SHEET: 3 OF 4
4 PLC	±	ANGLES FINISH		WEIGHT		DRAWING NO: 2836580		REV: B	
MATERIAL				CUSTOMER ACCESSIBLE PRODUCTION DRAWING		SCALE: 1:2		SHEET: 3 OF 4	

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

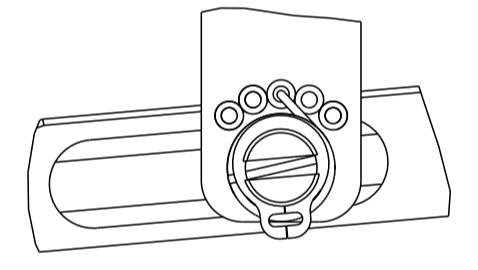
FEED TYPE MECHANICAL



PNEUMATIC

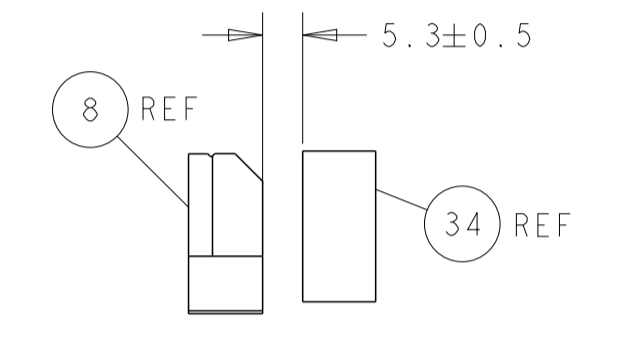
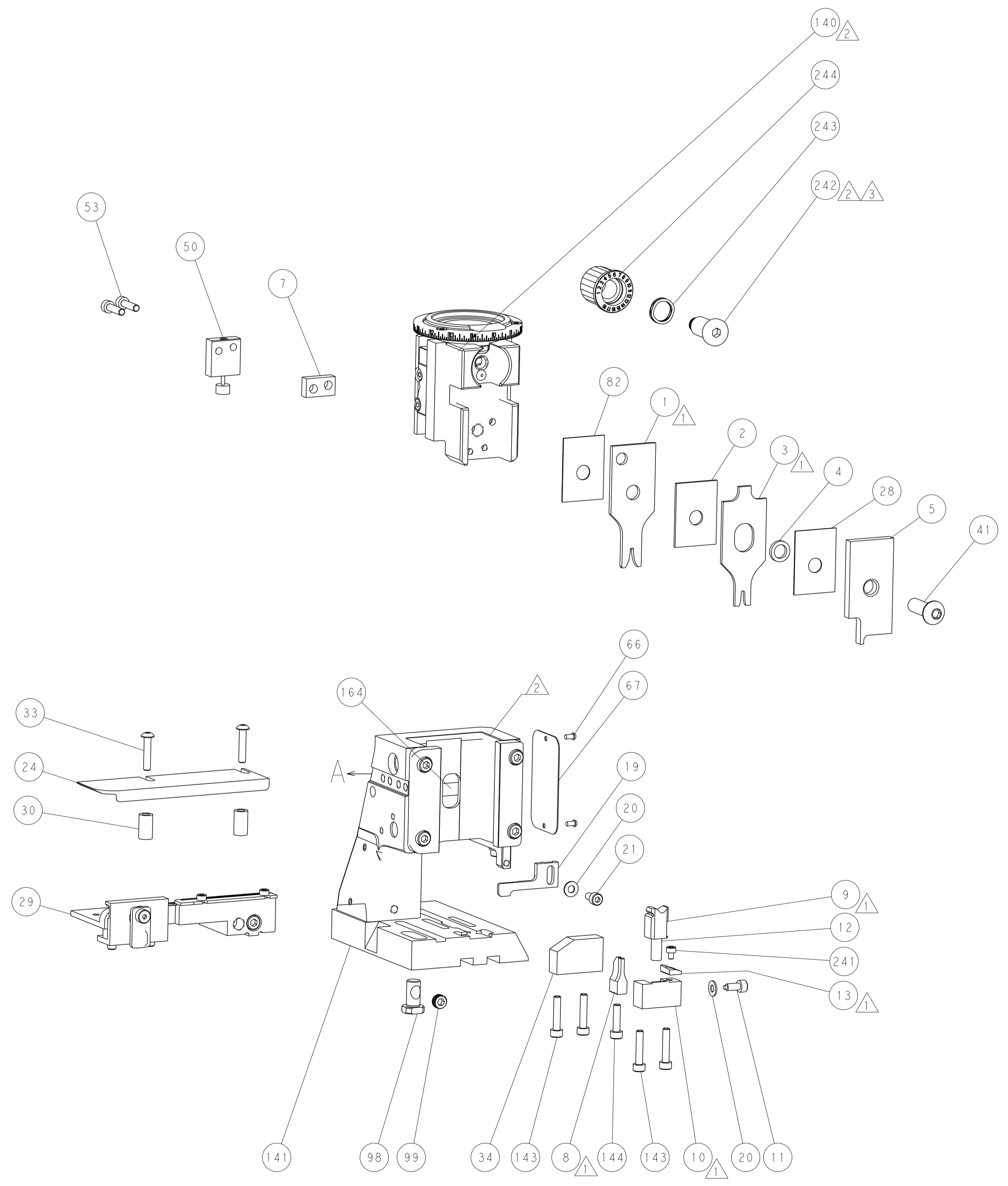
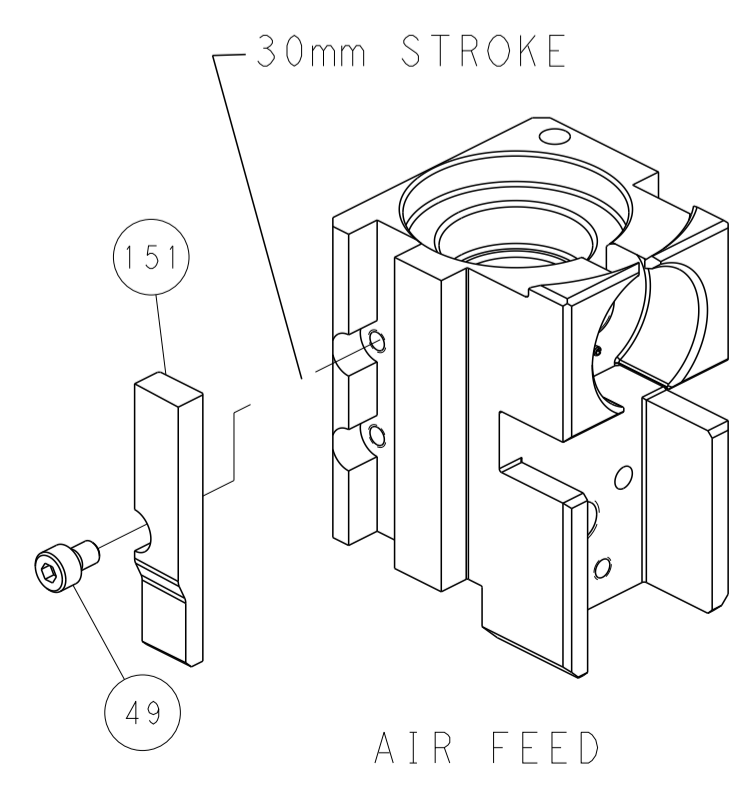
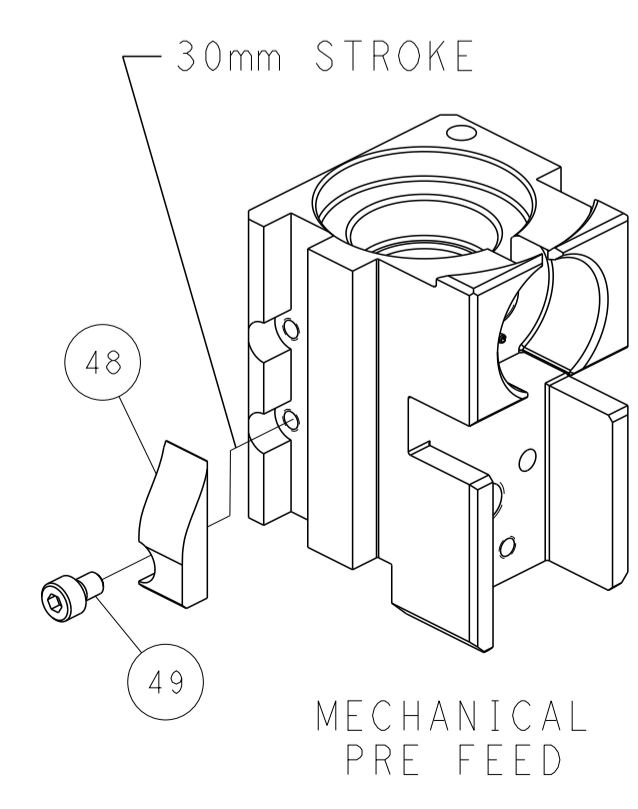
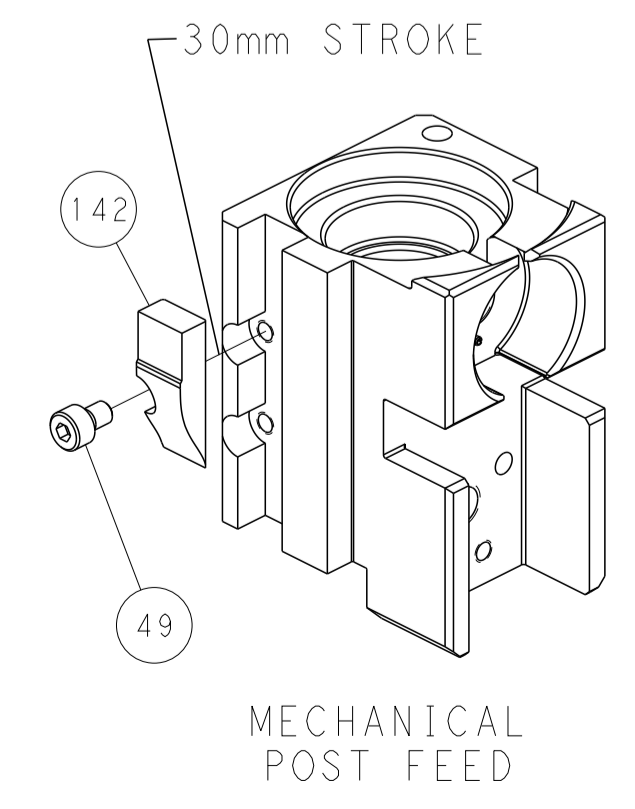


FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)

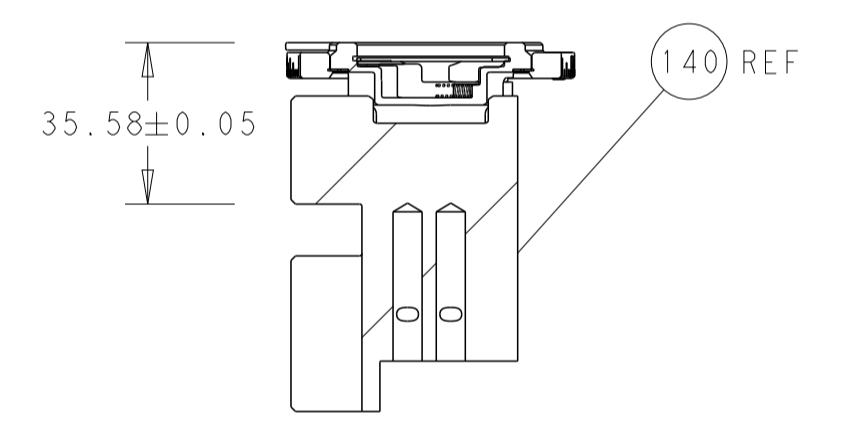


DETAIL A

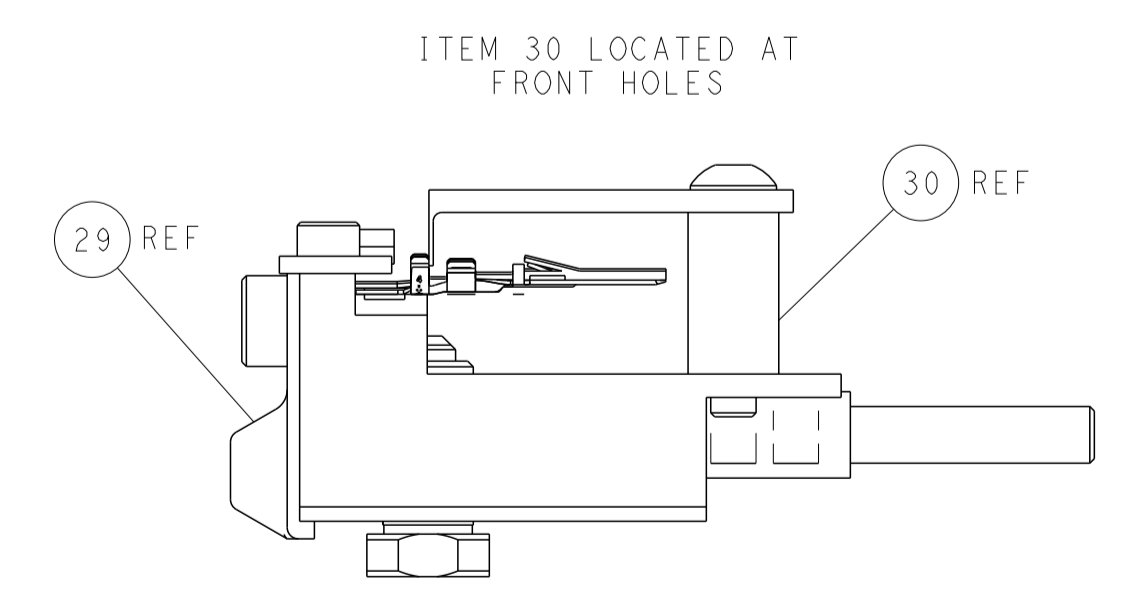
CAM POSITIONS



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)

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DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH ±		NAME: Ocean Side Feed Applicator APPLICATION SPEC: - SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2836580	RESTRICTED TO: - SCALE: 1:2 SHEET: 4 of 4 REV: B
MATERIAL: - FINISH: -		WEIGHT: - CUSTOMER ACCESSIBLE PRODUCTION DRAWING	SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION