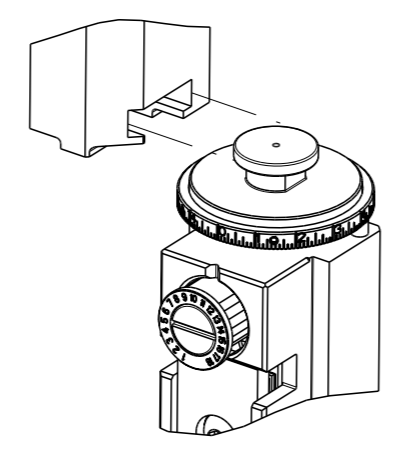


REVISONS		DATE	OWN	APVD
F	LYH			
A		06JUL2017	FZ	KZ
B		25SEP2020	FJ	GB

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2836820-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2836820-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2836820-1	B	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2836820-2	B	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2836820-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.83 mm [.072]	F
INSUL	2.30 mm [.091]	F

APPLICATOR INSTRUCTIONS
408-35042

TERMINAL DATA: SUMITOMO TERMINASUMITOMO CRIMP SPECIFICATION			
TERMINAL NAME: 2.8 FEMALE TERMINAL			
WIRE STRIP LENGTH 4.43-5.19 mm [.174-.204 IN]	INSULATION DIAMETER RANGE Ø1.90-2.20 mm [.075-.087 IN]		
TERMINAL APPLICATION SPECIFICATION (A)82400423 Rev 2017/01/23			
TERMINALS APPLIED 6			
TE TERMINAL (A) 2318317-1	SUMITOMO TERMINAL (A) 8240-0423	TE TERMINAL	SUMITOMO TERMINAL

TERMINAL DATA: SUMITOMO TERMINASUMITOMO CRIMP SPECIFICATION			
TERMINAL NAME: 2.8 FEMALE TERMINAL			
WIRE STRIP LENGTH 4.43-5.19 mm [.174-.204 IN]	INSULATION DIAMETER RANGE Ø1.90-2.20 mm [.075-.087 IN]		
TERMINAL APPLICATION SPECIFICATION (B)NONE			
TERMINALS APPLIED 5 6			
TE TERMINAL (B) 2318317-1	SUMITOMO TERMINAL (B) 8240-0423	TE TERMINAL	SUMITOMO TERMINAL

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.35 + 0.5mm ²	1.30 +/- 0.05 [.051 +/- .002]	7.1
2 X 0.35mm ²	1.25 +/- 0.05 [.049 +/- .002]	7.6

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.00mm ²	1.38 +/- 0.05 [.054 +/- .002]	6.2
0.50mm ²	1.17 +/- 0.05 [.046 +/- .002]	8.5

					ITEM NO		
-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248
-	1	1	1	1	2119082-7	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	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	1-690438-0	FRONT STRIP GUIDE	96
-	2	2	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	95
-	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
-	2	2	2	2	2-18032-5	SCR, SET, FLT PNT, M5 X 20.0	61
-	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	1338685-3	PAWL, FEED	56
-	4	4	4	4	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	54
-	2	2	2	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	53
-	1	1	1	1	5018030-1	NUT, HEX, REG, RoHS, M3	52
-	1	1	1	1	811242-5	BUMPER, HOLD DOWN	51
-	1	1	1	1	690753-2	SPACER, TONKER	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	1752356-3	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	2844992-3	ASSEMBLY, STRIP GUIDE	29
-	1	1	1	1	455888-5	SPACER, CRIMPER	28
-	2	2	2	2	22283-1	SPRING, COMPRESSION	27
-	1	1	1	1	356835-1	LEVER, DRAG RELEASE	26
-	1	1	1	1	240792-3	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	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	1803537-4	ANVIL, COMBINATION	8
-	-	-	-	-	-	-	7
-	-	-	-	-	-	-	6
-	1	1	1	1	2119757-6	DEPRESSOR, SHEAR	5
-	1	1	1	1	238011-5	BLOCK, CRIMPER SPACER	4
-	1	2	2	1	1-1803187-5	CRIMPER, INSULATION F	3
-	1	1	1	1	455888-9	SPACER, CRIMPER	2
-	1	2	2	1	1633305-6	CRIMPER, WIRE PREMIUM	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 THE CUSTOMER ACKNOWLEDGES THAT THE TERMINAL MANUFACTURER'S CRIMP SPECIFICATIONS ARE UNKNOWN. IN ADDITION THE CUSTOMER ACKNOWLEDGES THAT TE CONNECTIVITY HAS CALCULATED CRIMP SPECIFICATIONS FOR THIS PRODUCT THAT MAY NOT MATCH THE TERMINAL MANUFACTURER'S SPECIFICATIONS. TE CONNECTIVITY USES ACCEPTED PRACTICES TO DESIGN TERMINATION TOOLING FOR NON-TE CONNECTIVITY PRODUCTS. HOWEVER, **TE CONNECTIVITY EXPRESSLY DISCLAIMS ANY AND ALL WARRANTIES THAT THE TOOLING WILL RELIABLY APPLY NON-TE CONNECTIVITY PRODUCTS, INCLUDING BUT NOT LIMITED TO IMPLIED WARRANTIES OF MERCHANTABILITY OR FITNESS FOR PARTICULAR PURPOSE. THE CUSTOMER ASSUMES ALL RESPONSIBILITY AND LIABILITY FOR THE PERFORMANCE OF TERMINATED ASSEMBLIES USING SUCH TOOLING.** THE CUSTOMER EXPRESSLY INDEMNIFIES TE CONNECTIVITY AND SHALL HOLD TE CONNECTIVITY HARMLESS FROM ALL CLAIMS, DEMANDS, LOSSES, EXPENSES AND LIABILITIES RESULTING FROM THE USE OF THIS TOOLING ON NON-TE CONNECTIVITY PRODUCTS.
 - △ 6 TERMINAL LUBRICANT IS RECOMMENDED.
7. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.

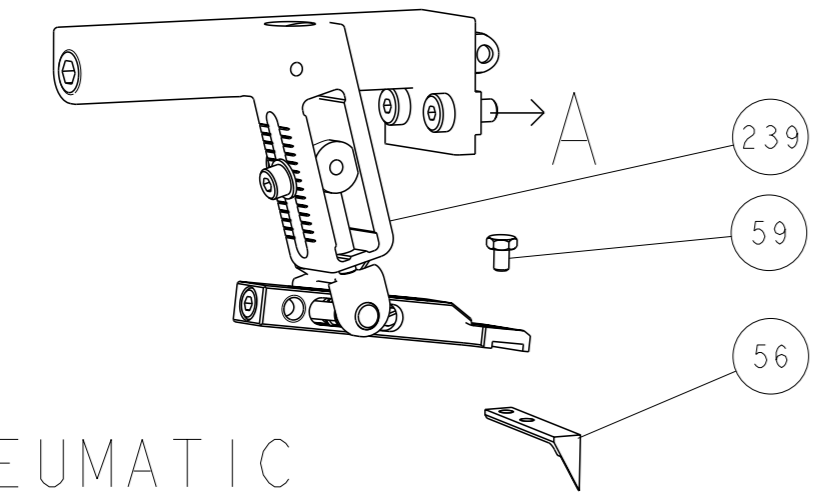
***WARNING**
ON INSTALLATION, SET WIRE DISC TO CRIMP HEIGHT REFERENCE SETTING FOR LARGEST WIRE SIZE. CRIMP HEIGHT REFERENCE SETTINGS GREATER THAN THE VALUE SHOWN MAY CAUSE DAMAGE TO THE CRIMP TOOLING, REFER TO THE INSTRUCTION SHEET FOR PROPER SETUP AND ADJUSTMENTS.

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

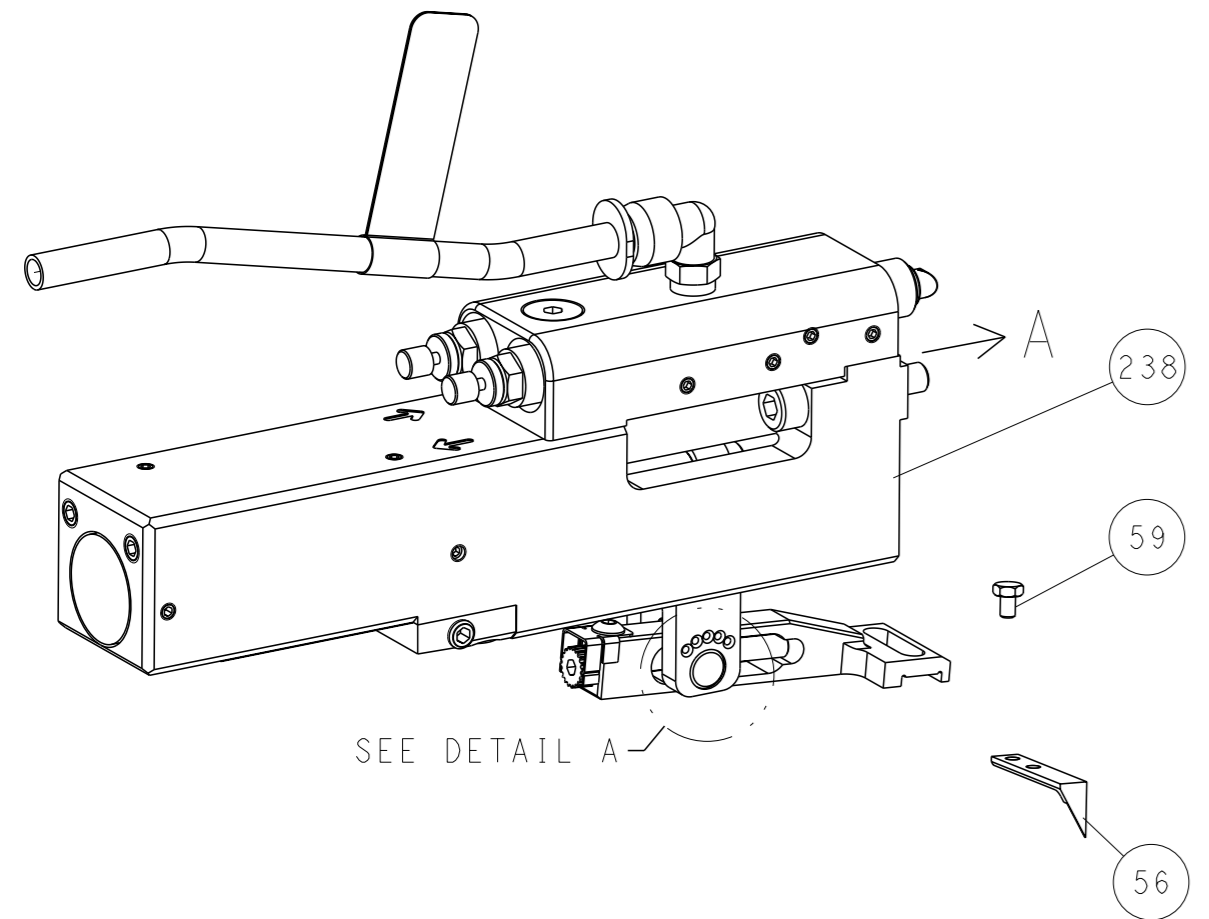
<p>THE DRAWING IS UNPUBLISHED. THIS DRAWING IS UNPUBLISHED. THE CUSTOMER ACKNOWLEDGES THAT THE INFORMATION PROVIDED IS FOR INFORMATION ONLY AND DOES NOT CONSTITUTE A CONTRACT. THE CUSTOMER ASSUMES ALL RESPONSIBILITY AND LIABILITY FOR THE PERFORMANCE OF TERMINATED ASSEMBLIES USING SUCH TOOLING.</p> <p>TE Connectivity Ocean Side Feed Applicator</p>	<p>OWN F. ZHANG 14JUN2017</p> <p>CHK K. ZHANG 14JUN2017</p> <p>APVD K. ZHANG 14JUN2017</p> <p>PRODUCT SPEC</p> <p>APPLICATION SPEC</p> <p>MATERIAL</p>	<p>NAME Ocean Side Feed Applicator</p> <p>SIZE A1</p> <p>CAGE CODE 00779</p> <p>DRAWING NO. C=2836820</p> <p>RESTRICTED TO</p> <p>Customer Accessible Production Drawing</p> <p>SCALE 1:2 SHEET 1 OF 4 REV B</p>
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LOC	DIST	REVISIONS			
A	66	REV	DATE	OWN	APVD
-	-	SEE SHEET 1	-	-	-

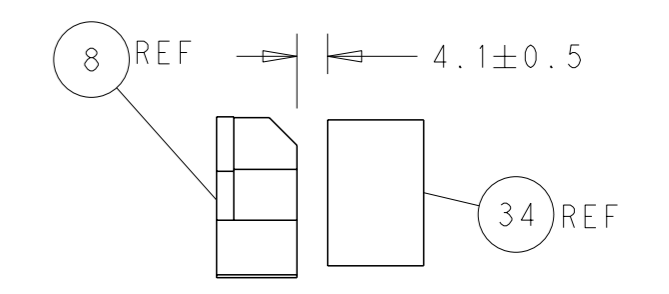
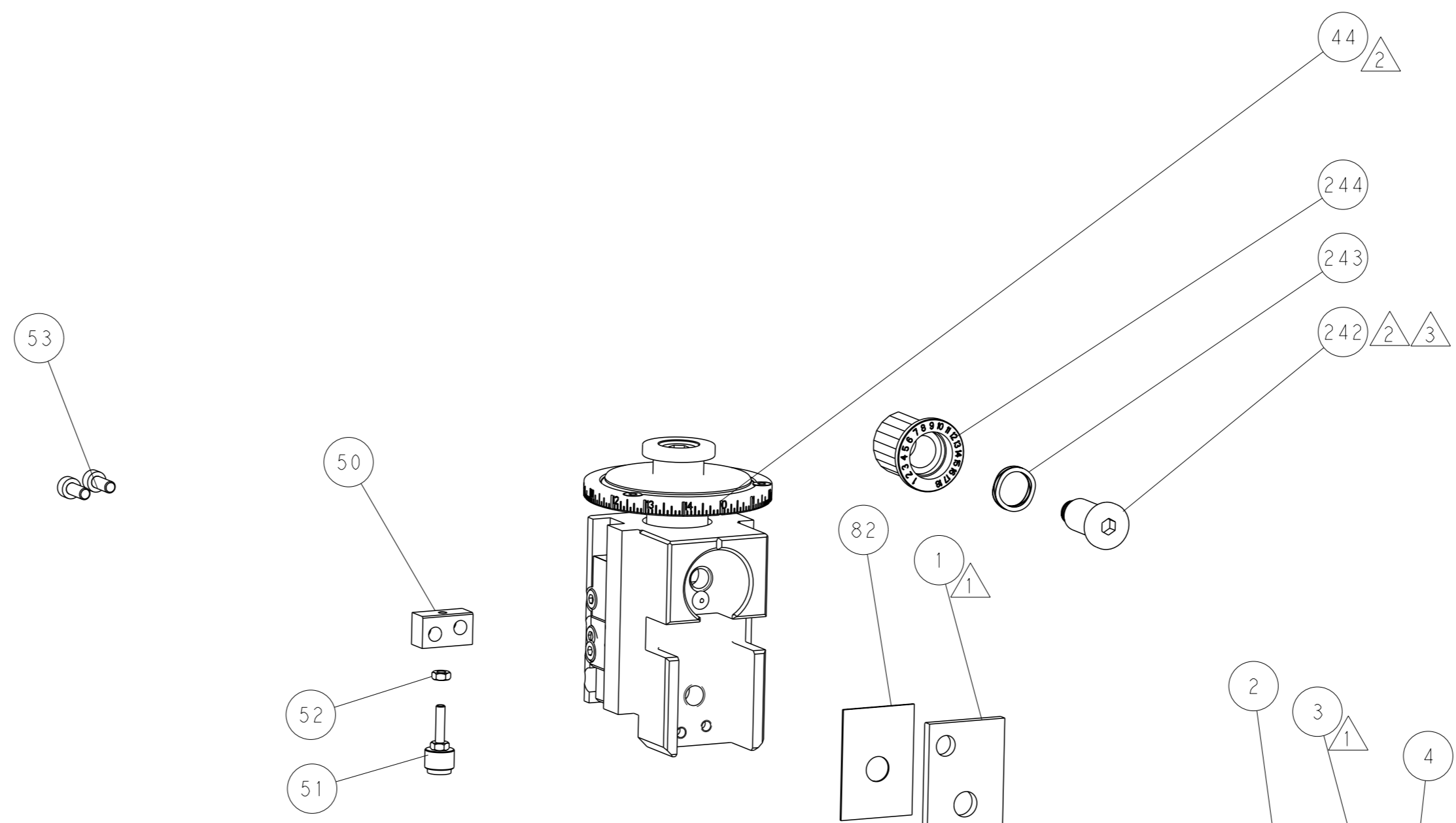
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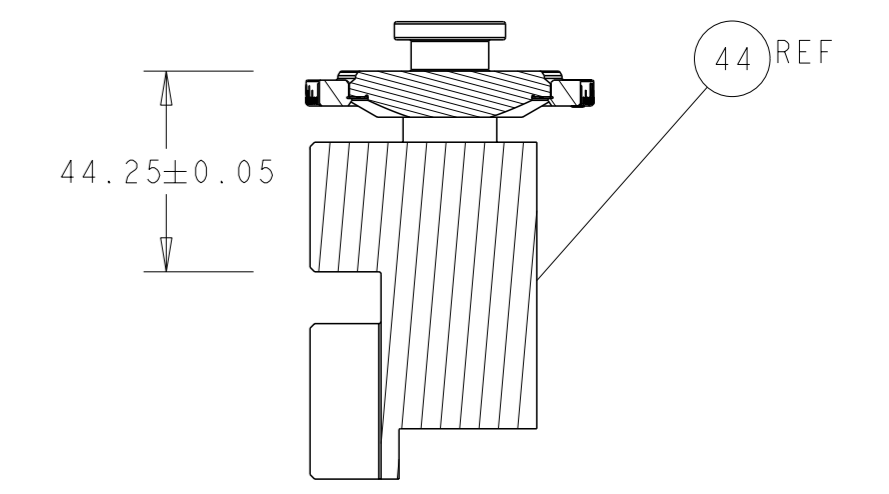
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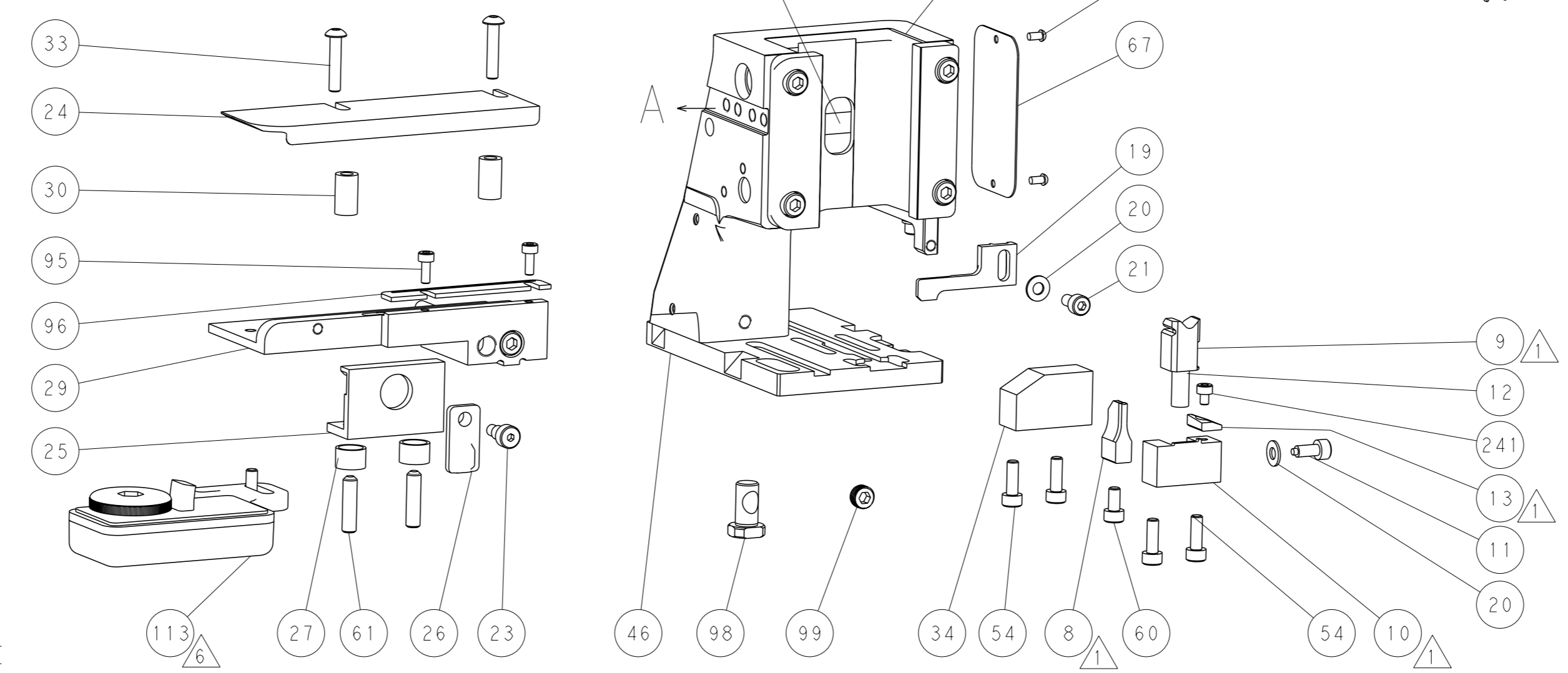
FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



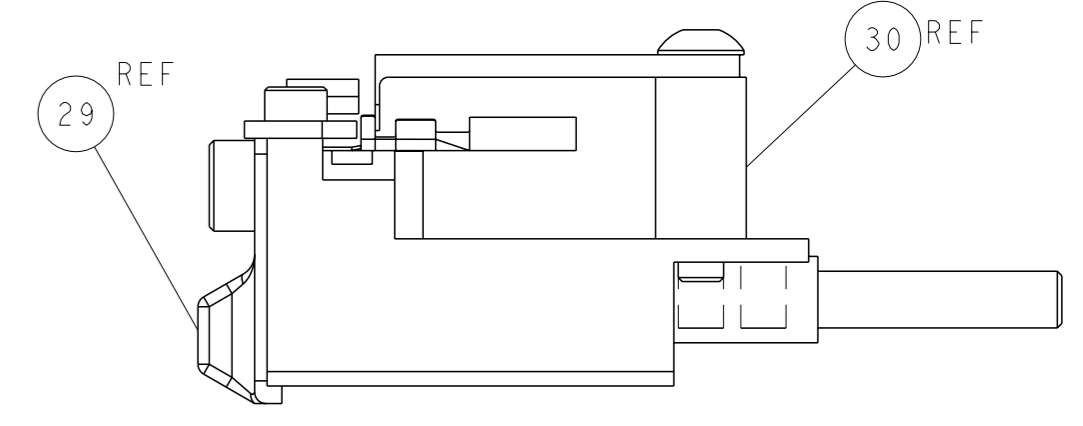
TERMINAL SUPPORT LOCATION



RAM SET-UP

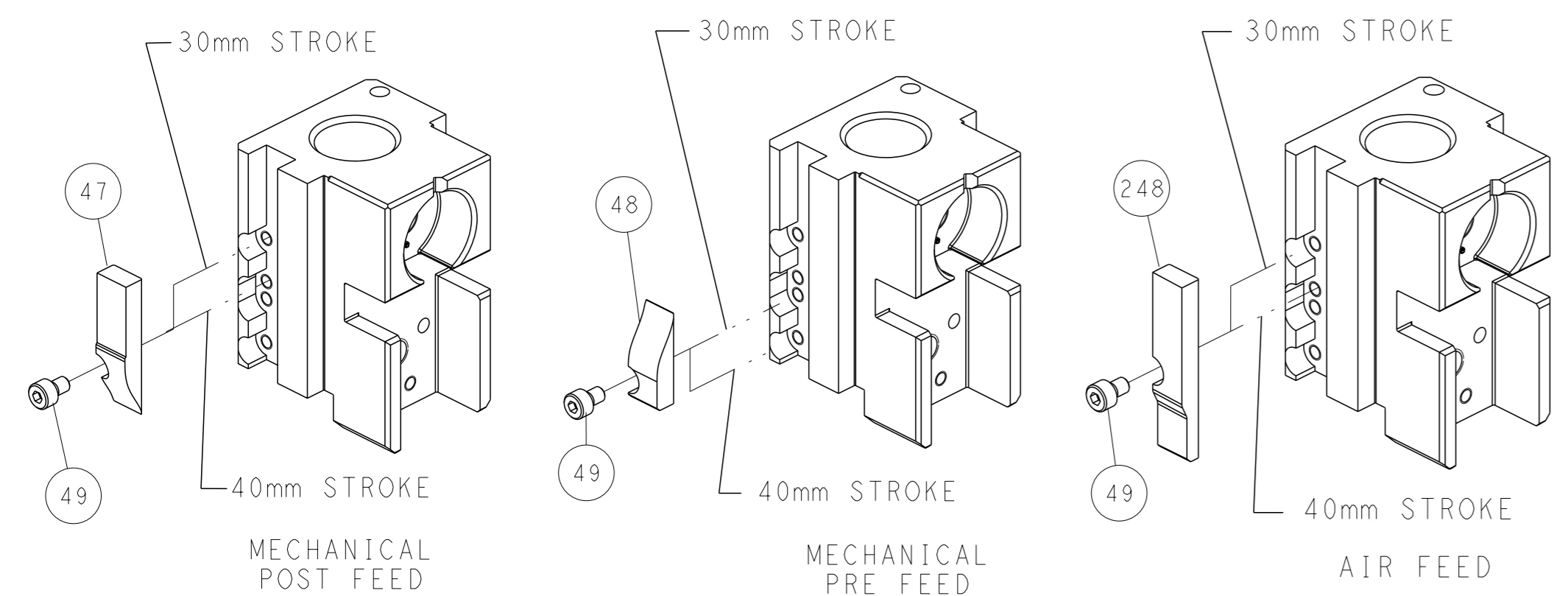


ITEM 30 LOCATED AT FRONT HOLES



FEED TRACK POSITION GUIDE BY INSULATION BARREL

CAM POSITIONS

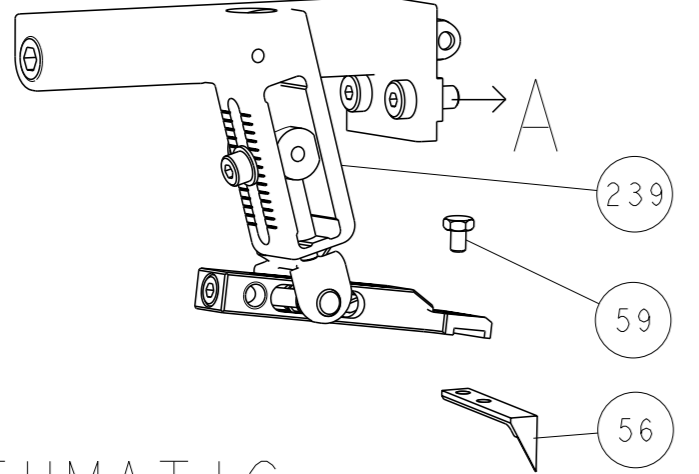


ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

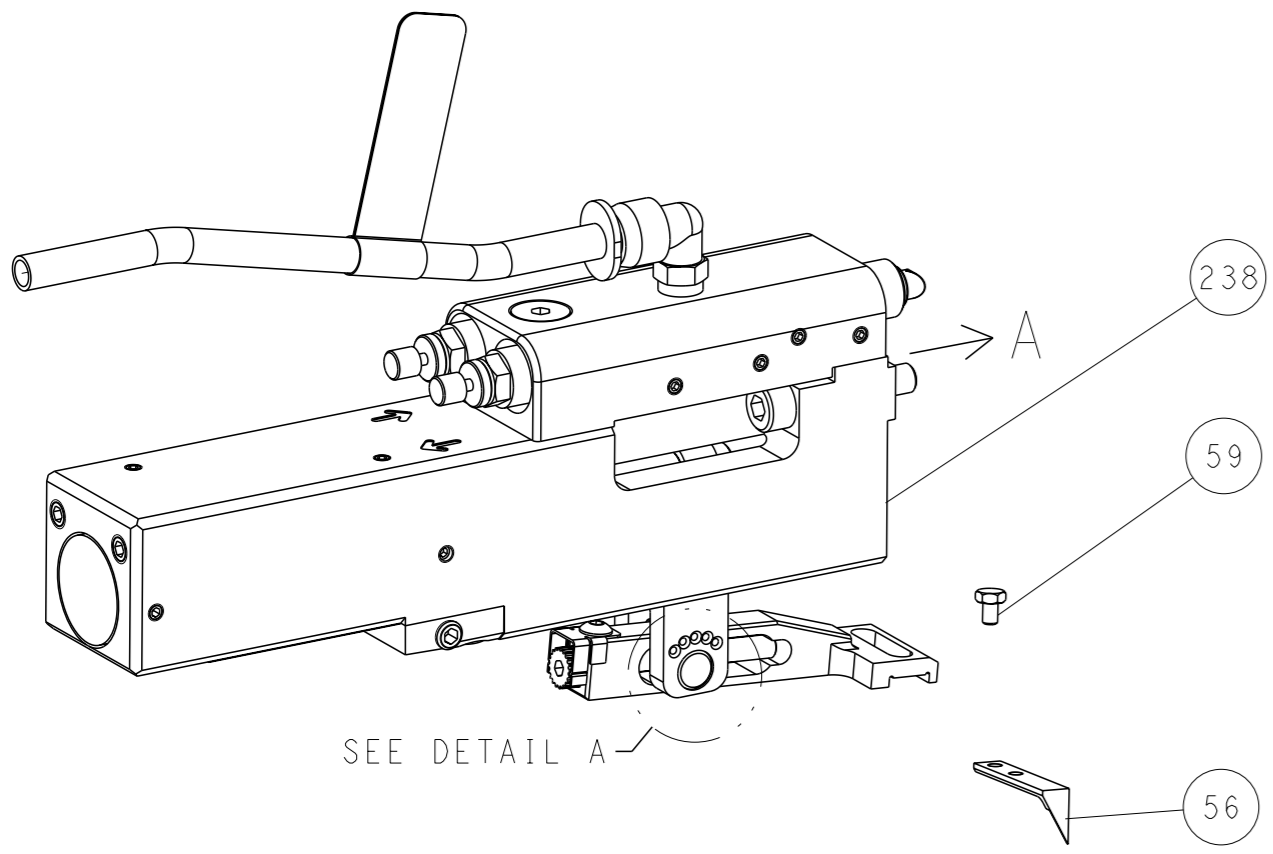
<small>THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE AND THE USER'S RESPONSIBILITY TO OBTAIN THE LATEST REVISION SHOULD BE CONTACTED FOR THE LATEST REVISION.</small>		DWN F. ZHANG 14JUN2017 CHK K. ZHANG 14JUN2017 APVD K. ZHANG 14JUN2017	TE Connectivity 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 CAGE CODE DRAWING NO. RESTRICTED TO A1 00779 C=2836820
MATERIAL:		WEIGHT:	SCALE 1:2 SHEET 2 of 4 REV B Customer Accessible Production Drawing

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

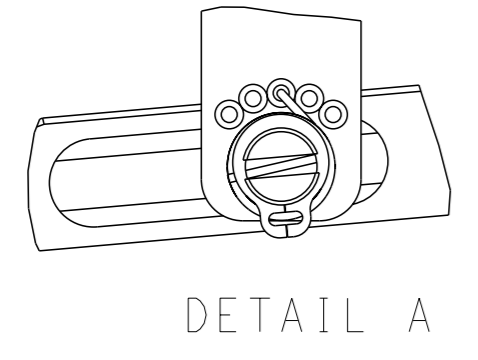
FEED TYPE MECHANICAL



PNEUMATIC

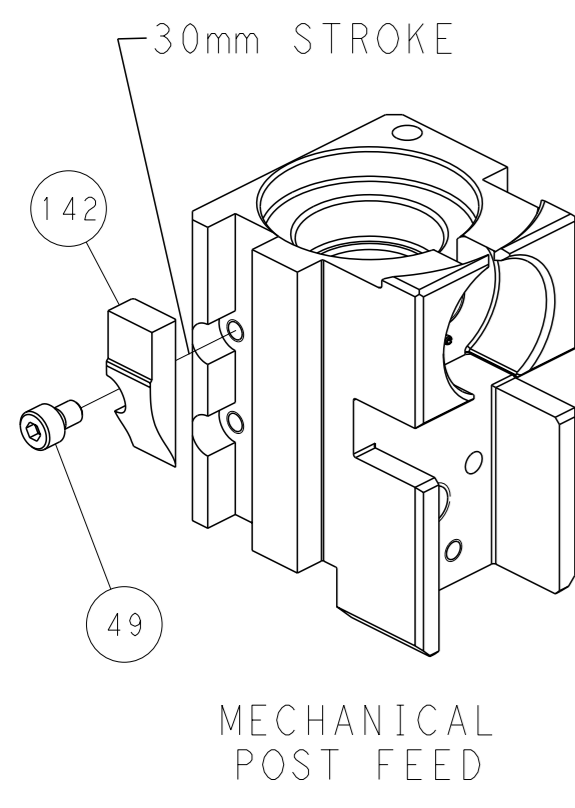


FEED SPRING SETTING POSITION
(SHOWN FROM REAR SIDE)

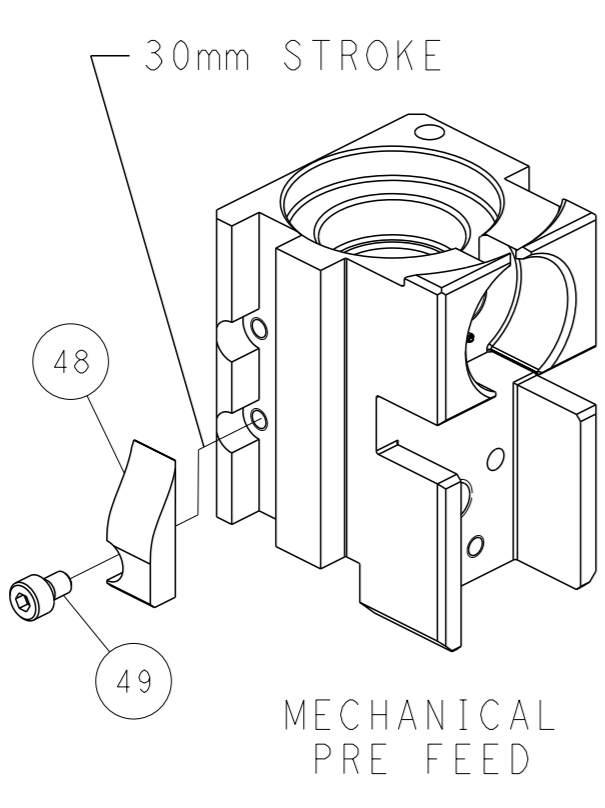


DETAIL A

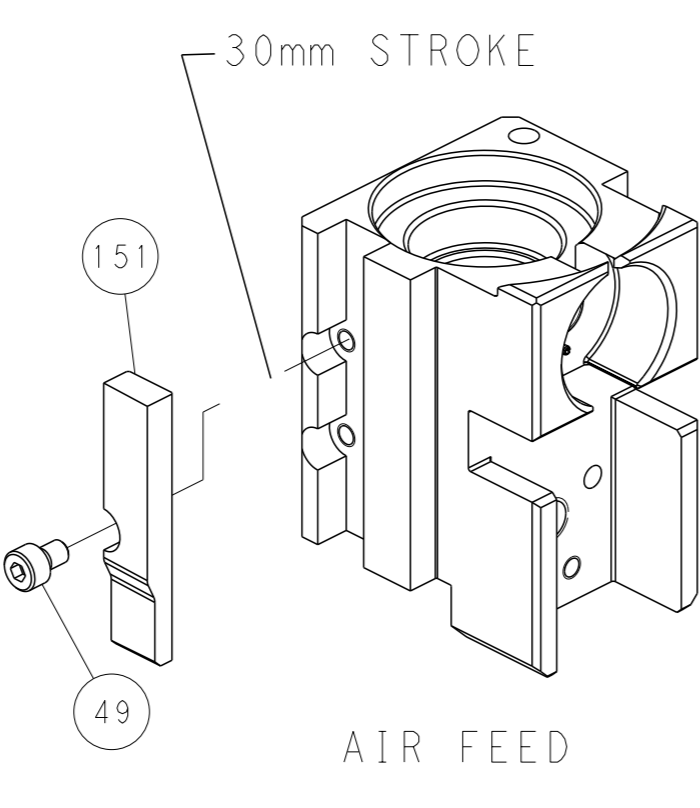
CAM POSITIONS



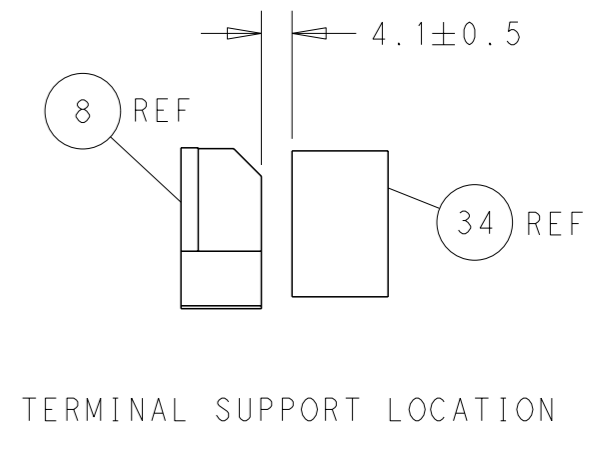
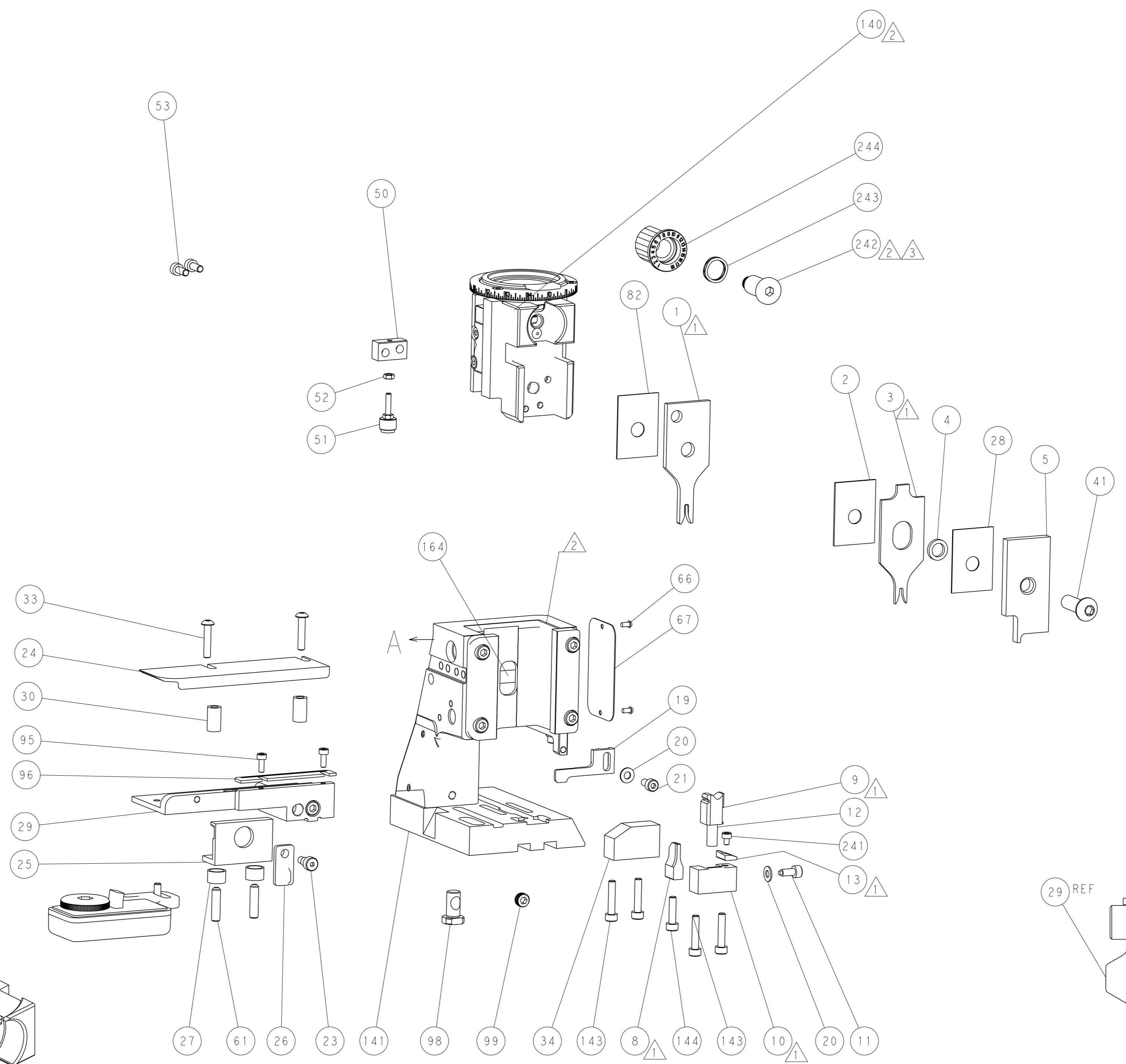
MECHANICAL
POST FEED



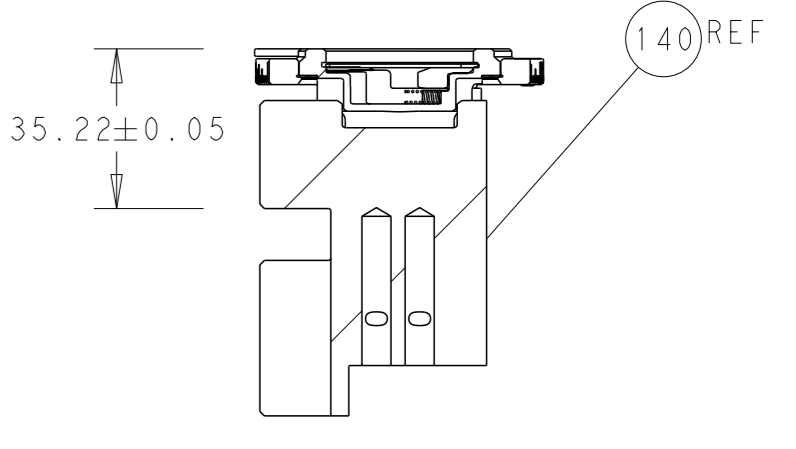
MECHANICAL
PRE FEED



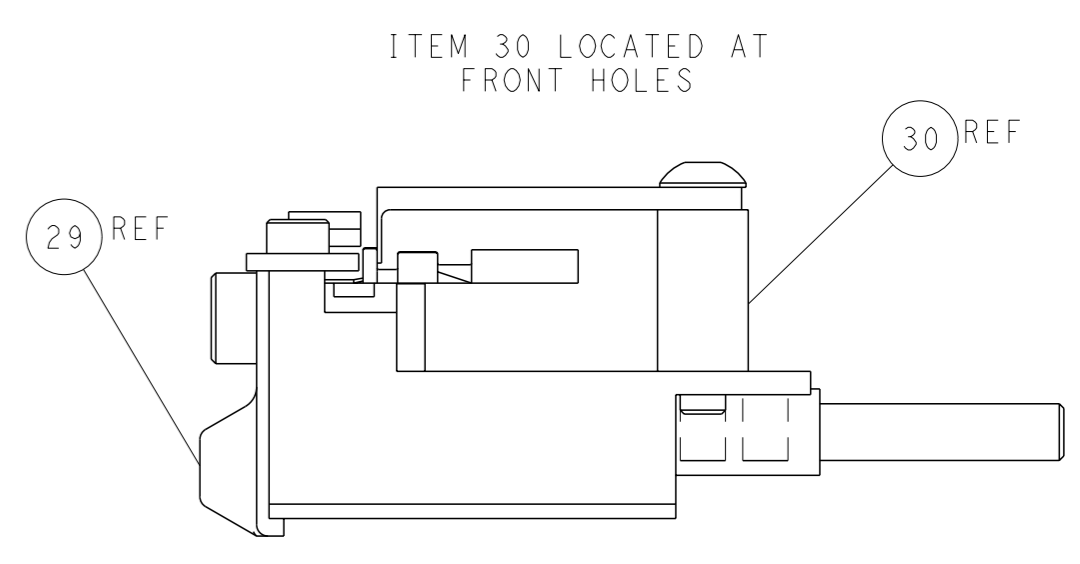
AIR FEED



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 A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE AND THE CONTROLLER'S DISCRETION SHOULD BE CONTACTED FOR THE LATEST REVISION.</small>		OWN: F. ZHANG 14JUN2017 CHK: K. ZHANG 14JUN2017 APVD: K. ZHANG 14JUN2017	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 *	APPLICATION SPEC WEIGHT SCALE: 1:2	PRODUCT SPEC RESTRICTED TO: A	SIZE: 00779 CAGE CODE: 2836820 SHEET 4 OF 4 REV B
MATERIAL:		Customer Accessible Production Drawing	