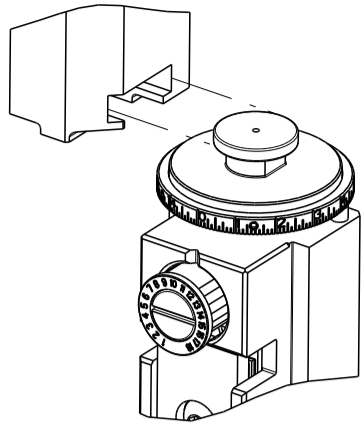





8		7	
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2017		2017	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2836948-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2836948-2	B	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2836948-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	4.83 mm [.190]	F
INSUL	6.00 mm [.236]	F
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: KOSTAL/LEAR TERMINAL		KOSTAL CRIMP SPECIFICATION	
TERMINAL NAME: LSK 8 TERMINAL			
WIRE STRIP LENGTH 8.00-9.00 mm [.315-.354 IN]			INSULATION DIAMETER RANGE Ø4.00-5.00 mm [.157-.197 IN]
TERMINAL APPLICATION SPECIFICATION		DOC00074177 Appendix 1 Rev-March 2010	
		-	-
TERMINALS APPLIED 			
TE TERMINAL	KOSTAL/LEAR TERMINAL	TE TERMINAL	KOSTAL/LEAR TERMINAL
2318399-1	22124472860	2318399-2	22125472860
2318399-3	22142472860	2318399-4	E09778700

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
6.00mm2	3.17+/-0.06 [.125+/- .002]	4.0
4.00mm2	2.65+/-0.06 [.104+/- .002]	9.8



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. THIS APPLICATOR DOES NOT CUT CARRIER STRIP.
6. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
7. TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.

*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)

2		1					
LOC	DIST	REVISIONS					
A	66	P	LTR	DESCRIPTION	DATE	DWN	APVD
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			B	ECR-20-010440	22JUL2020	TB	RK

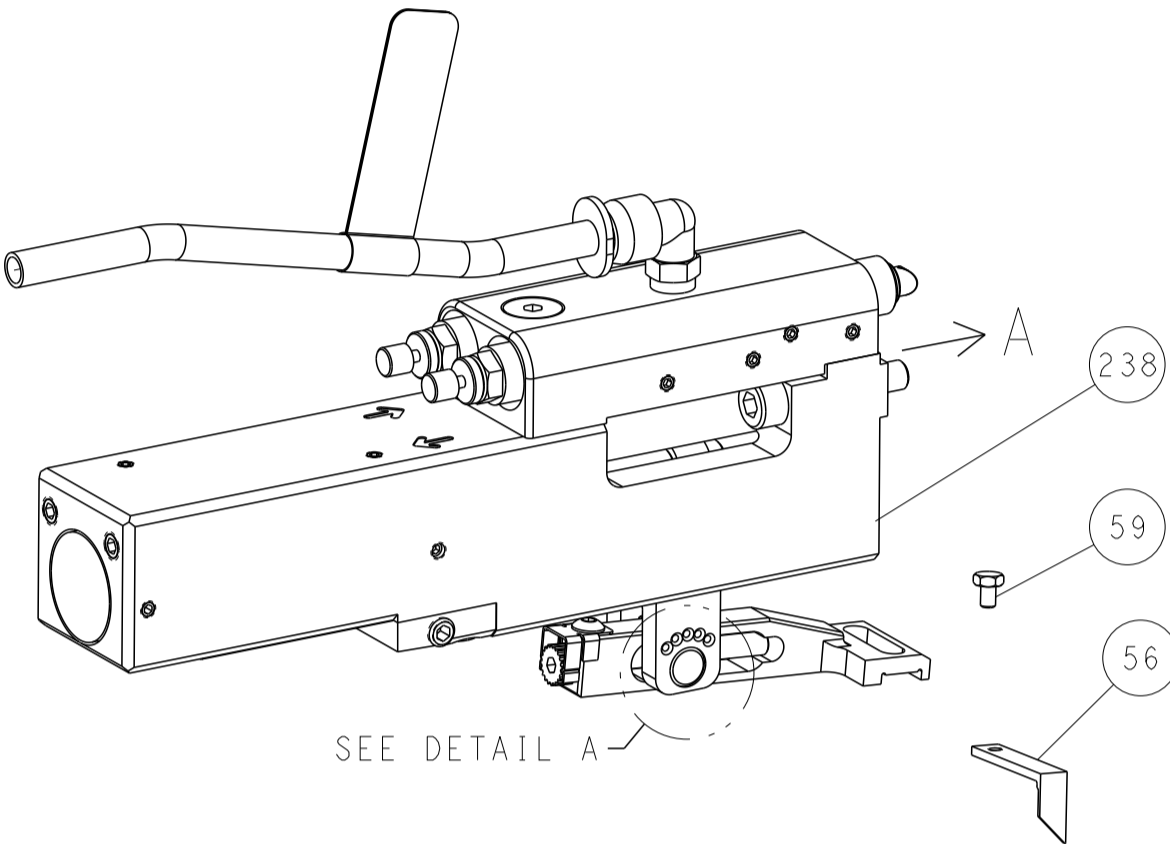
-	1	1	4-679651-1	FRONT STRIP GUIDE	270
-	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	269
-	1	1	1633782-3	FENCE	267
-	1	1	2119641-1	FEED CAM, AIR FEED	248
-	1	1	2119082-2	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	1	2844940-2	AIR FEED MODULE	238
-	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	1	1	1-22281-8	SPRING, COMPRESSION	121
-	1	1	2844908-1	SCREW, LOCKING	99
-	1	1	2844907-1	POST, LOCKING	98
-	2	2	1655316-2	SCR, SKT HD CAP, M3 X 16.0	95
-	1	1	2168083-6	SCR, SKT HD CAP, RoHS, M5 X 65	93
-	1	1	2-455888-2	SPACER, CRIMPER	82
-	1	1	1803607-3	DOCUMENTATION PACKAGE	71
-	1	1	2119791-5	DEPRESSOR, WIRE	70
-	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	1-1338683-1	FEED PAWL	56
-	4	4	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	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	2-1803583-8	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	1752356-3	SUPPORT, TERMINAL	34
-	1	1	2844938-5	PLATE, STRIP GUIDE	29
-	1	1	455888-5	SPACER, CRIMPER	28
-	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
-	2	2	1-18028-2	WASHER, FLAT, REG M4	20
-	1	1	2119533-1	STRIPPER, SIDE FEED	19
-	1	1	3-22280-5	SPRING, COMPRESSION	12
-	1	1	1-356885-5	STOP, SHEAR	11
-	1	1	2119805-1	SHEAR HOLDER, FRONT	10
-	1	1	454276-5	FLOATING SHEAR, FRONT	9
1	2	1	7-1803318-0	ANVIL, COMBINATION	8
-	1	1	5-240641-3	SPACER	7
-	-	-	-	-	6
-	1	1	1-2119757-1	DEPRESSOR, SHEAR	5
-	1	1	238011-3	BLOCK, CRIMPER SPACER	4
1	2	1	1803457-5	CRIMPER, INSULATION F PREMIUM	3
-	1	1	1-455888-4	SPACER, CRIMPER	2
1	2	1	4-1803470-5	CRIMPER, WIRE F	1
-77-72	-2		PART NO	DESCRIPTION	ITEM NO

THIS DRAWING IS A CONTROLLED DOCUMENT AND THE INFORMATION CONTAINED HEREIN IS THE PROPERTY OF TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE WITHOUT NOTICE AND THE USER SHALL BE RESPONSIBLE FOR THE LATEST EDITION.				DWN B. WEAVER 20OCT2017	TE Connectivity Harrisburg, PA 17105-3608		
TOLERANCES UNLESS OTHERWISE SPECIFIED:				CHK T. ELBIN 20OCT2017	NAME		
DIMENSIONS:				APVD T. ELBIN 20OCT2017	PRODUCT SPEC		
mm					APPLICATION SPEC		
MATERIAL					SIZE CASE CODE DRAWING NO		
-					A1 00779 C=2836948		
Customer Accessible Production Drawing					RESTRICTED TO		
					SCALE 1:2 SHEET 1 OF 4 REV B		

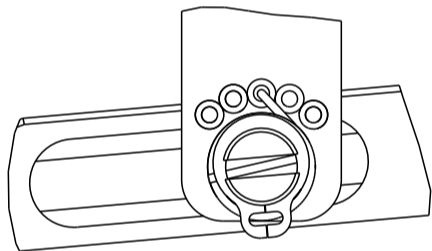
SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

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

FEED TYPE
PNEUMATIC

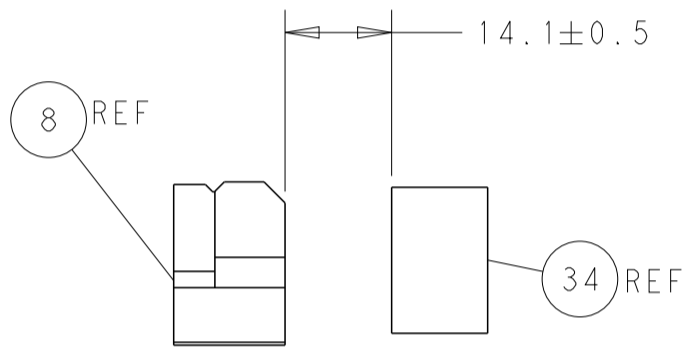
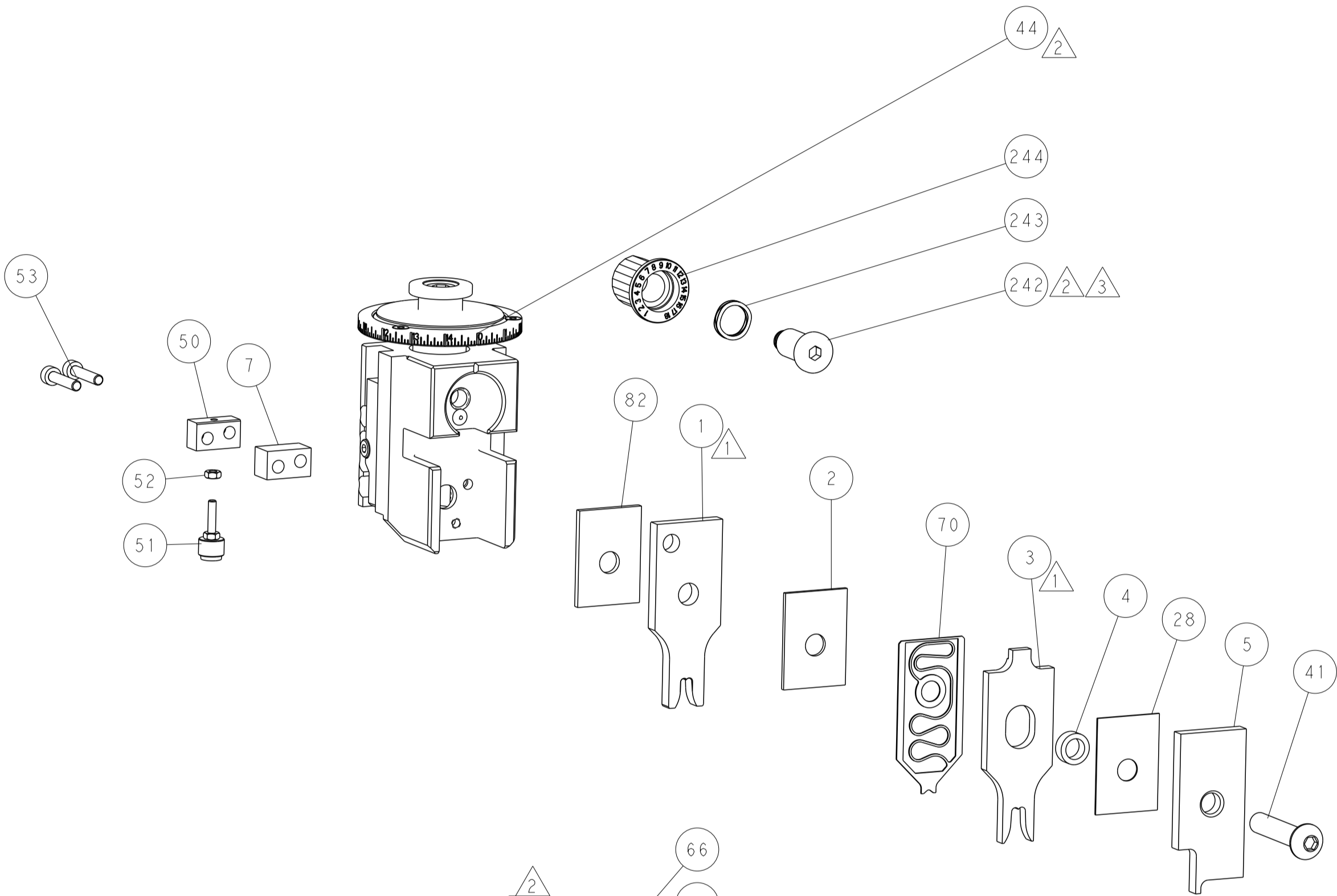
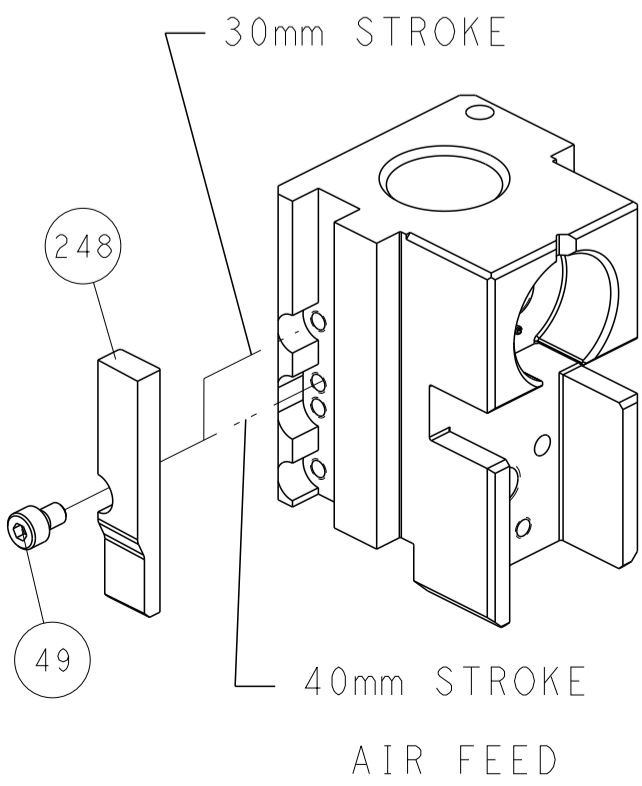


FEED SPRING SETTING POSITION
(SHOWN FROM REAR SIDE)

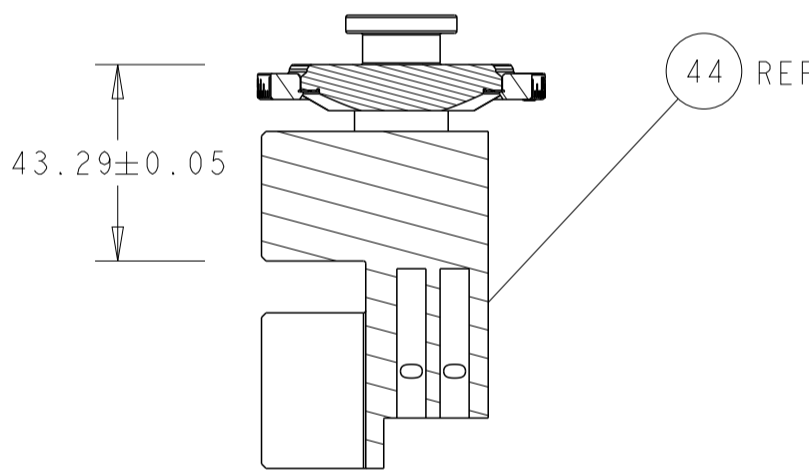


DETAIL A

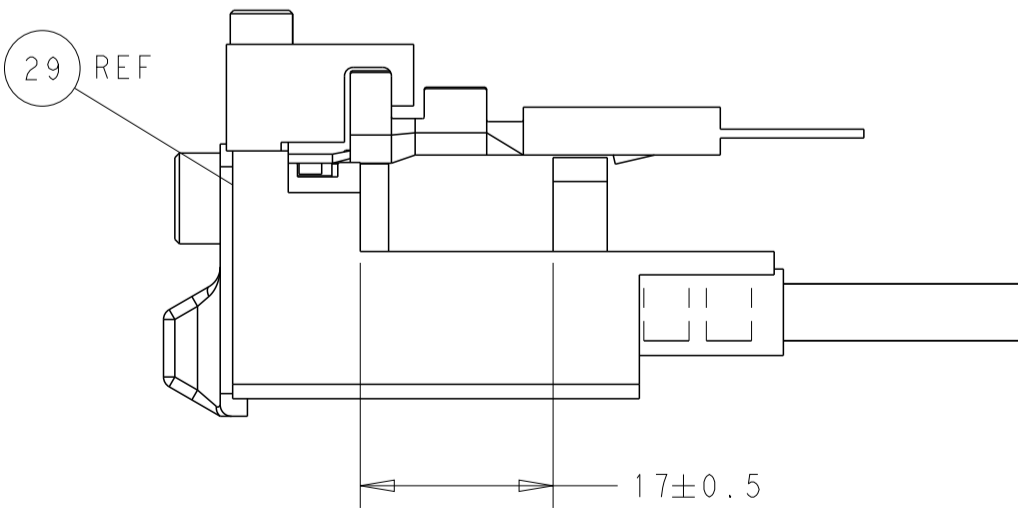
CAM POSITION



TERMINAL SUPPORT LOCATION

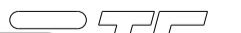



RAM SET-UP



FEED TRACK POSITION
GUIDE BY INSULATION BARREL

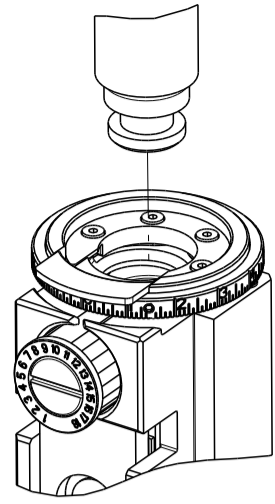
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

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				CHG T. ELBIN 20OCT2017							
				APVD T. ELBIN 20OCT2017	NAME						
DIMENSIONS: mm				PRODUCT SPEC - APPLICATION SPEC - SIZE				Ocean Side Feed Applicator - CAGE CODE DRAWING NO RESTRICTED TO			
				TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.1 1 PLC ±.1 2 PLC ±.1 3 PLC ±.1 4 PLC ±.1 ANGLES ±.1 FINISH				WEIGHT - A 00779 C=2836948			
MATERIAL -				-				-			
				Customer Accessible Production Drawing				SCALE 1:2 SHEET 2 of 4 REV B			

SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

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PART NUMBER	REVISION
DESCRIPTION	FEED TYPE
2-2836948-2	B
7-2836948-7	A
FINE CRIMP HEIGHT ADJUST	PNEUMATIC
CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	4.83 mm [.190]	F
INSUL	6.00 mm [.236]	F
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: KOSTAL/LEAR TERMINAL KOSTAL CRIMP SPECIFICATION			
TERMINAL NAME: LSK 8 TERMINAL			
WIRE STRIP LENGTH 8.00-9.00 mm [.315-.354 IN]		INSULATION DIAMETER RANGE Ø4.00-5.00 mm [.157-.197 IN]	
TERMINAL APPLICATION SPECIFICATION	DOC00074177 Appendix 1 Rev-March 2010	-	-
TERMINALS APPLIED			
TE TERMINAL	KOSTAL/LEAR TERMINAL	TE TERMINAL	KOSTAL/LEAR TERMINAL
2318399-1	22124472860	2318399-2	22125472860
2318399-3	22142472860	2318399-4	E09778700

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING
6.00mm2		3.17+/-0.06 [.125+/-0.002]		4.0
4.00mm2		2.65+/-0.06 [.104+/-0.002]		9.8



- 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.
- THIS APPLICATOR DOES NOT CUT CARRIER STRIP.
6. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
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*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	REVISONS			
A	66	P	LTR	DESCRIPTION	DATE
				SEE SHEET 1	-
					-
					-

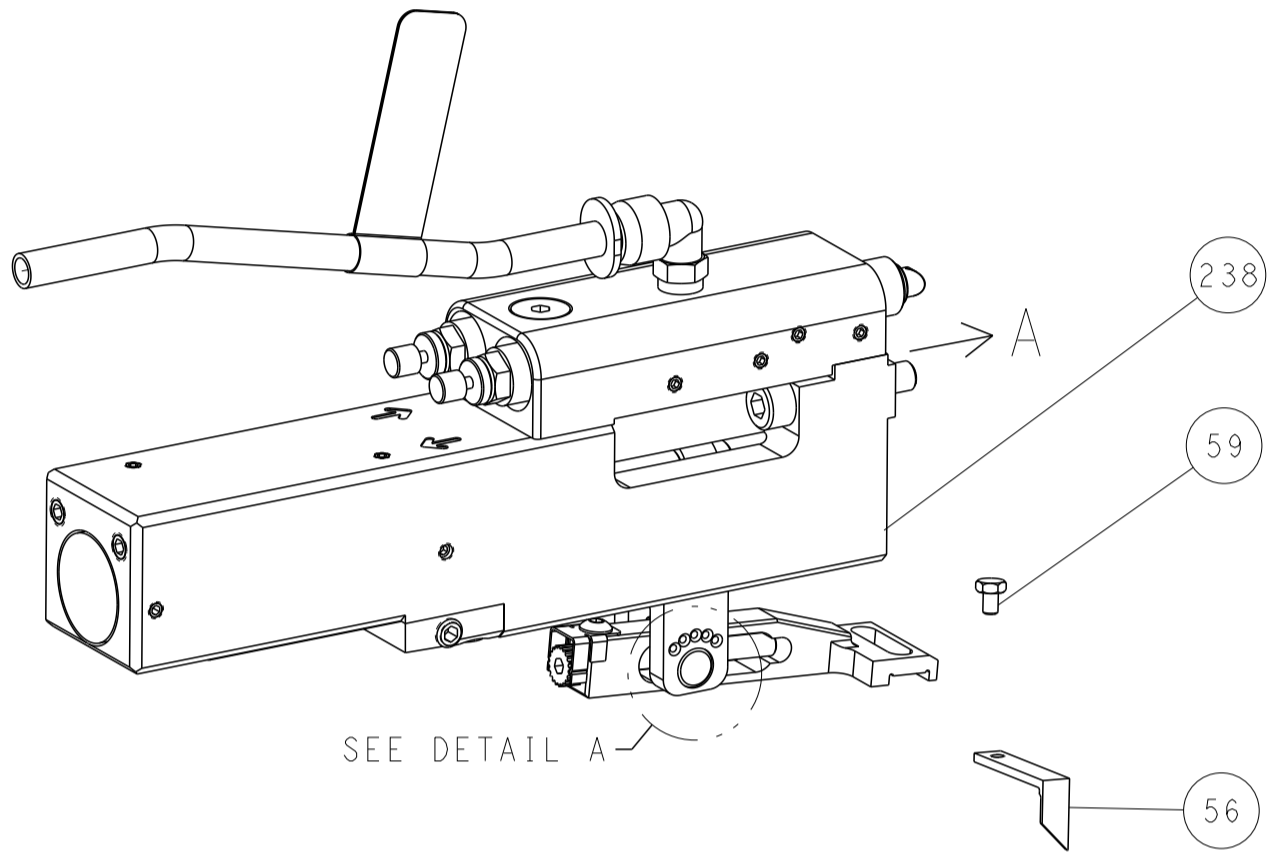
3	-	1	4-679651-1	FRONT STRIP GUIDE	270
	-	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	269
	-	1	1633782-3	FENCE	267
	-	1	2119082-2	CAM, SNAIL, INSULATION ADJUSTMENT	244
	-	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
	-	1	2119083-1	RETAINER, INSULATION DIAL	242
	-	1	2844940-2	AIR FEED MODULE	238
	-	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	2-1803583-9	APPLICATOR BASIC ASSEMBLY, SF	141
	-	1	1803516-2	RAM ASSEMBLY, SF PACIFIC	140
	-	1	1-22281-8	SPRING, COMPRESSION	121
	-	1	2844908-1	SCREW, LOCKING	99
	-	1	2844907-1	POST, LOCKING	98
	-	2	1655316-2	SCR, SKT HD CAP, M3 X 16.0	95
	-	1	2168083-6	SCR, SKT HD CAP, RoHS, M5 X 65	93
	-	1	2-455888-2	SPACER, CRIMPER	82
	-	1	1803607-3	DOCUMENTATION PACKAGE	71
	-	1	2119791-5	DEPRESSOR, WIRE	70
	-	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	1-1338683-1	FEED PAWL	56
	-	2	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	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	1752356-3	SUPPORT, TERMINAL	34
-	1	2844938-5	PLATE, STRIP GUIDE	29	
-	1	455888-5	SPACER, CRIMPER	28	
-	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	
-	2	1-18028-2	WASHER, FLAT, REG M4	20	
-	1	2119533-1	STRIPPER, SIDE FEED	19	
-	1	3-22280-5	SPRING, COMPRESSION	12	
-	1	1-356885-5	STOP, SHEAR	11	
-	1	2119805-1	SHEAR HOLDER, FRONT	10	
-	1	454276-5	FLOATING SHEAR, FRONT	9	
1	1	7-1803318-0	ANVIL, COMBINATION	8	
-	1	5-240641-3	SPACER	7	
-	-	-	-	6	
-	1	1-2119757-1	DEPRESSOR, SHEAR	5	
-	1	238011-3	BLOCK, CRIMPER SPACER	4	
1	1	1803457-5	CRIMPER, INSULATION F PREMIUM	3	
-	1	1-455888-4	SPACER, CRIMPER	2	
1	1	4-1803470-5	CRIMPER, WIRE F	1	
-77	-22	PART NO	DESCRIPTION	ITEM NO	

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DIMENSIONS: mm		CHK T. ELBIN 20OCT2017	NAME	
		APVD T. ELBIN 20OCT2017	Ocean Side Feed Applicator	
TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH ±		PRODUCT SPEC APPLICATION SPEC	SIZE CASE CODE DRAWING NO	
MATERIAL		WEIGHT	A 00779 ©=2836948	
Customer Accessible Production Drawing		SCALE 1:2	SHEET 3 OF 4	
			REV B	

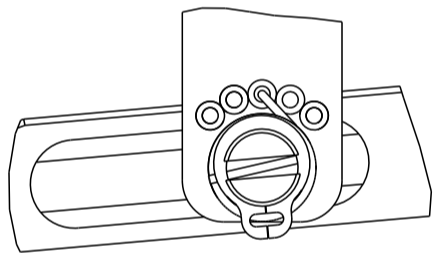
SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

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

FEED TYPE
PNEUMATIC

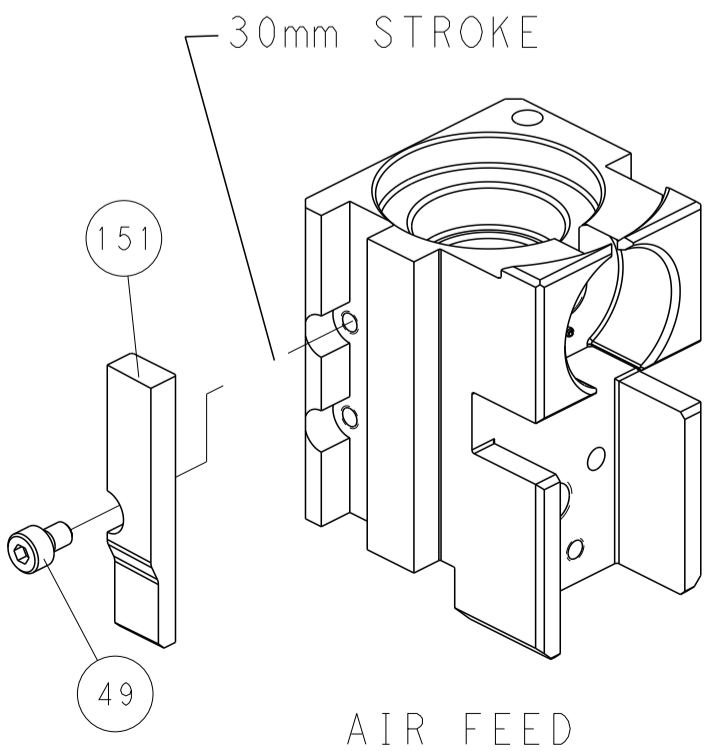


FEED SPRING SETTING POSITION
(SHOWN FROM REAR SIDE)

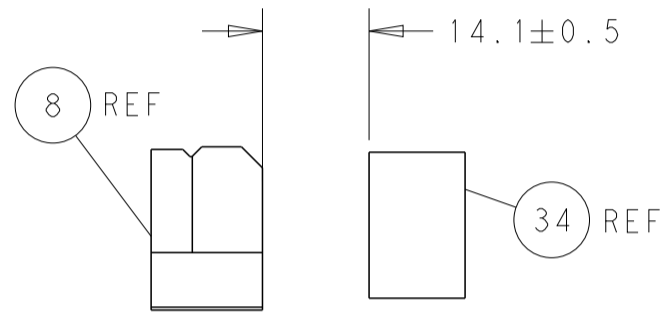
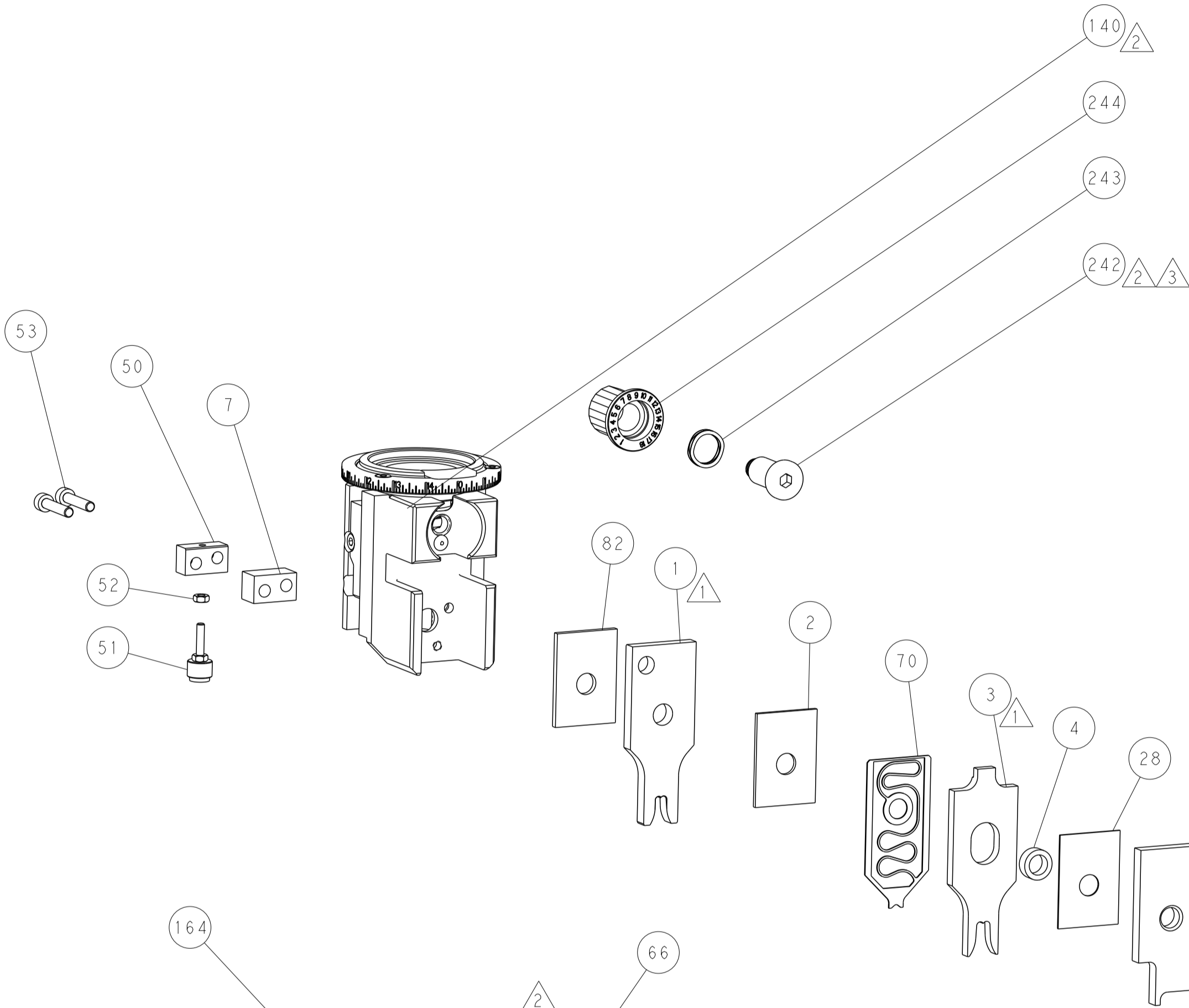


DETAIL A

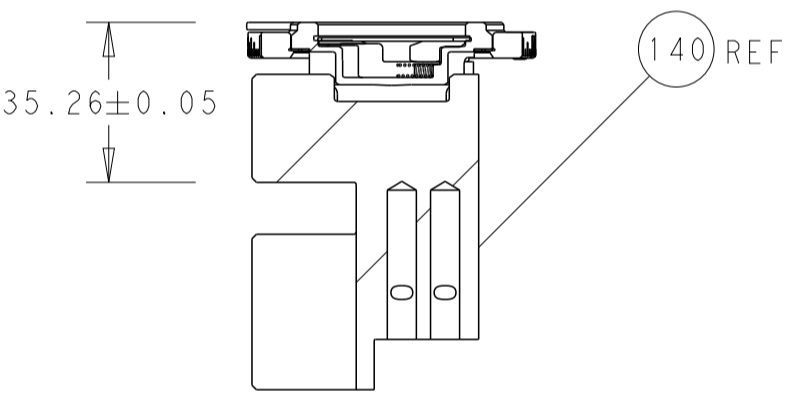
CAM POSITION



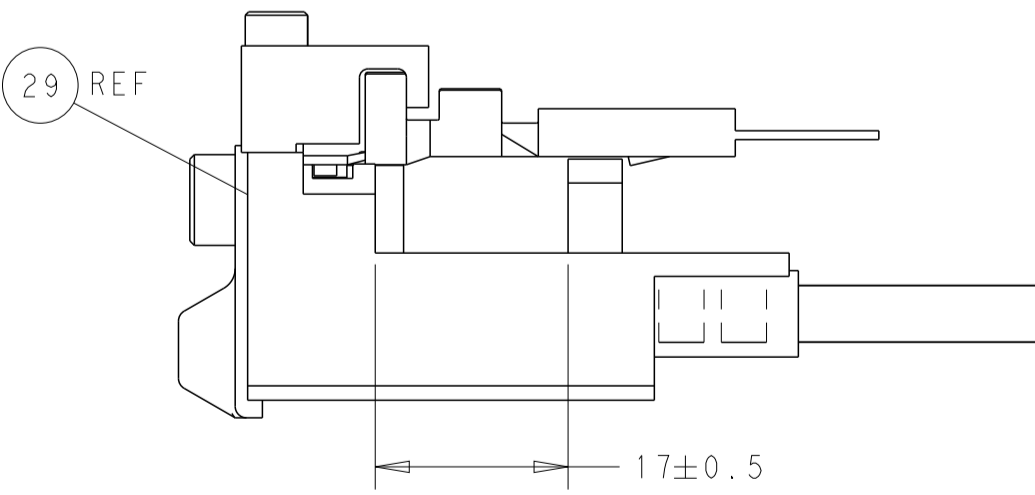
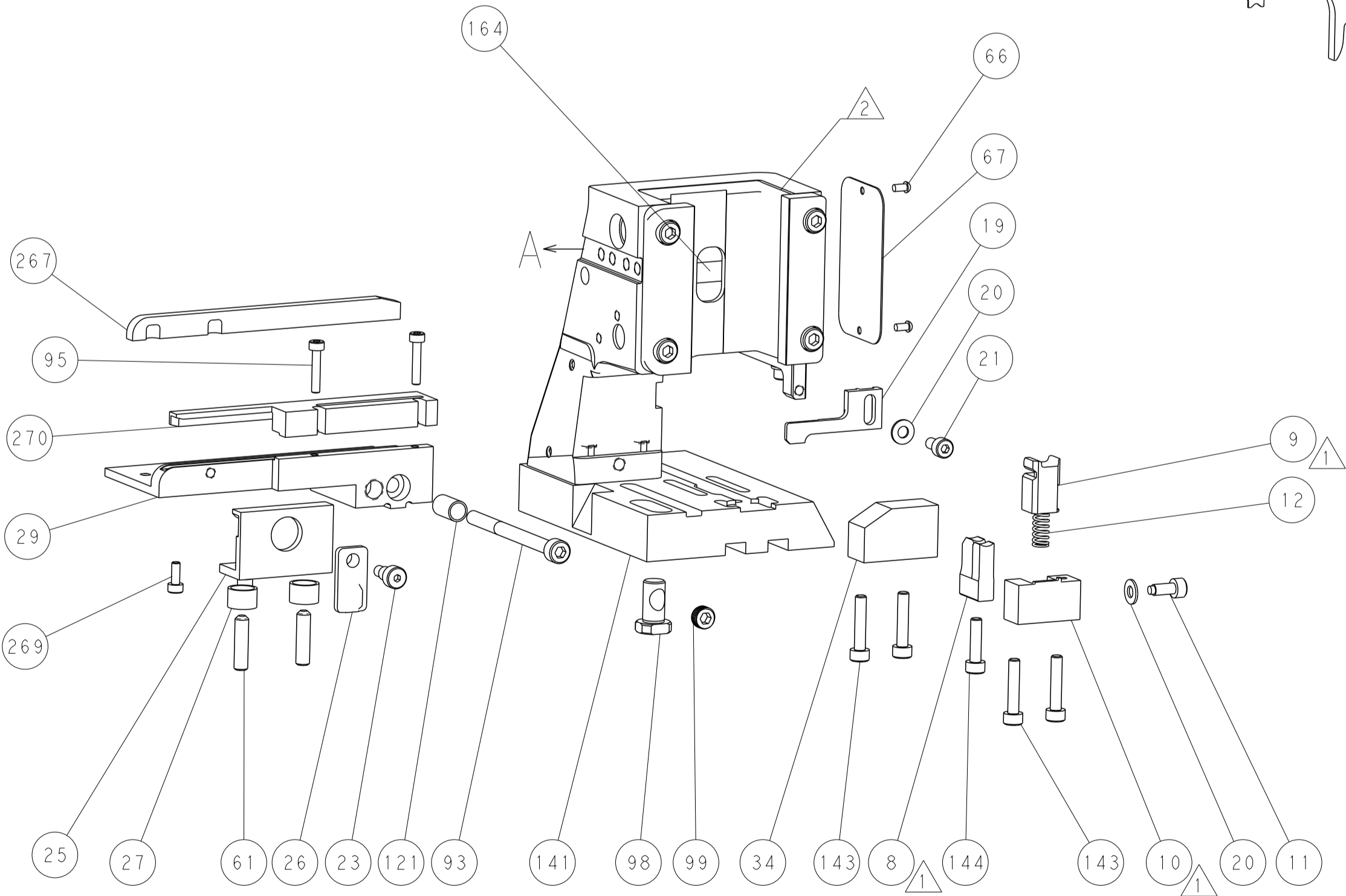
AIR FEED



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)

THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION IT IS SUBJECT TO CHANGE WITHOUT NOTICE AND THE USER'S ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST EDITION.				DWN B. WEAVER	20OCT2017	 TE Connectivity Harrisburg, PA 17105-3608
				CHK T. ELBIN	20OCT2017	
				APVD T. ELBIN	20OCT2017	
				PRODUCT SPEC		
DIMENSIONS: mm				TOLERANCES UNLESS OTHERWISE SPECIFIED:		NAME Ocean Side Feed Applicator -