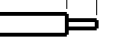


8		7	
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20		20	
(C) COPYRIGHT 20 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.			
PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2836074-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2836074-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
5-2836074-1	B	SEAL STRIPPER CRIMPER TERMINATING UNIT	MECHANICAL
5-2836074-2	C	SEAL STRIPPER CRIMPER TERMINATING UNIT	PNEUMATIC
7-2836074-1	B	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2836074-2	C	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2836074-7	A	CRIMP TOOLING KIT	-

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.58 mm [.062]	F
INSUL	2.29 mm [.090]	O
APPLICATOR INSTRUCTIONS 408-35042		

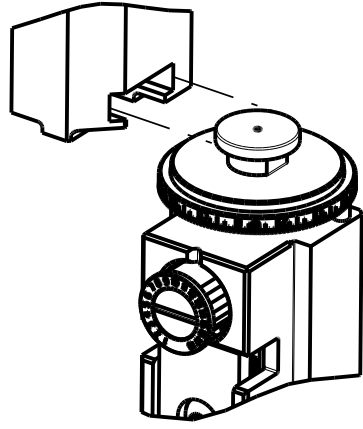
TERMINAL DATA: AMPHENOL TERMINAL				TE CRIMP SPECIFICATION	
TERMINAL NAME: TERMINAL, PIN AND SOCKET					
WIRE STRIP LENGTH					
2.50-3.00 mm [.098-.118 IN]			INSULATION DIAMETER RANGE		
			Ø1.00-2.00 mm [.039-.079 IN]		
TERMINAL APPLICATION SPECIFICATION				NONE	
				-	
				-	
TERMINALS APPLIED					
					
TE TERMINAL		AMPHENOL TERMINAL		TE TERMINAL	
1949386-1		TN0201600031		1-1949387-1	
1949386-6		TN0201600032		1-1949387-2	
1949386-7		TN0201600034		1-1949387-3	
1949387-1		TN0101600031		1-1949387-4	
1-1949387-0		TN0101600032			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
20 AWG OR 0.50mm2	1.16+/-0.05 [.046+/- .002]	7.1
22 AWG OR 0.35mm2	1.08+/-0.05 [.043+/- .002]	7.5
24 AWG OR 0.20mm2	1.00+/-0.05 [.039+/- .002]	8.2
26 AWG OR 0.14mm2	0.97+/-0.05 [.038+/- .002]	8.5



- 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. APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 180.
- 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.
- 6 TERMINAL LUBRICANT IS RECOMMENDED.

ATLANTIC VERSION TERMINATOR
INTERFACE ADAPTER



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

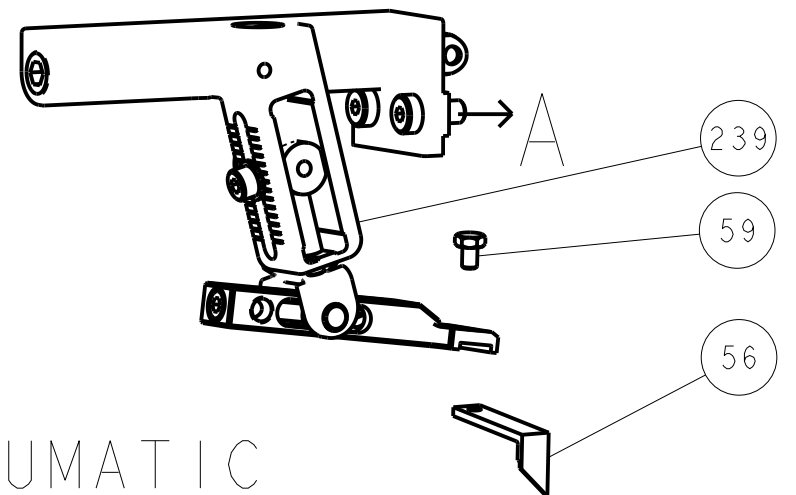
LOC	DIST	REVISIONS					
A	66	P	LTR	DESCRIPTION	DATE	DWN	APVD
			A	RELEASED	09DEC2015	LG	TE
			B	ECR-18-014198	07SEP2018	TB	TE
			B1	ECR-18-018846	30NOV2018	TB	TE
			C	ECR-19-011616	24JUL2019	FJ	TE

-	-	-	1	1	-	-	1803515-3	RAM ASSEMBLY, SF ATLANTIC	293
-	-	-	1	1	-	-	2-1803583-1	APPLICATOR BASIC ASSEMBLY, SF	292
-	1	1	1	1	1	1	2119791-9	DEPRESSOR, WIRE	286
-	2	2	2	2	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	269
-	1	1	1	1	1	1	1633782-3	FENCE	267
-	1	-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248
-	1	1	1	1	1	1	2119082-8	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	1	1	1	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
-	-	1	-	1	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	1	-	1	-	1	-	2844940-1	AIR FEED MODULE	238
-	-	-	1	1	-	-	4-1722335-3	STRIPPER, SIDE FEED	182
-	-	-	1	1	-	-	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	181
-	-	-	1	1	-	-	1-1752354-9	STANDOFF,HOLD-DOWN	180
-	-	-	1	1	-	-	9931111-1	PIN, SLOTTED SPRING 3.0 X 20.0	177
-	-	-	1	1	-	-	5-22280-0	SPRING, COMPRESSION	176
-	-	-	1	1	-	-	1752353-3	GUIDE PIN,HOLDDOWN	175
-	-	-	1	1	-	-	1901680-2	GUIDE PIN,HOLDDOWN	174
-	REF	REF	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	1	1	1	1	1	1	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113
-	1	1	1	1	1	1	2844908-1	SCREW, LOCKING	99
-	1	1	1	1	1	1	2844907-1	POST, LOCKING	98
-	1	1	1	1	1	1	455888-5	SPACER, CRIMPER	82
-	2	2	2	2	2	2	2079383-4	SCR, BHSC, RoHS (M4 X 8)	79
-	1	1	1	1	1	1	1803096-1	EXTENSION PLATE	78
-	1	1	1	1	1	1	1803607-3	DOCUMENTATION PACKAGE	71
-	1	1	1	1	1	1	2119791-5	DEPRESSOR, WIRE	70
-	1	1	1	1	1	1	2119740-1	TAG,IDENTIFICATION	67
-	2	2	2	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	1	1	1	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	60
-	1	1	1	1	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	1	1	1	1	1	1	1338683-8	FEED PAWL	56
-	4	4	4	4	4	4	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	54
-	2	2	2	2	2	2	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	53
-	1	1	1	1	1	1	1803382-6	HOLD DOWN, SPRING LOADED	50
-	1	2	1	2	1	2	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	1	-	1	-	1	-	2119652-1	FEED CAM, PRE FEED	48
-	-	1	-	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	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
-	1	1	1	1	1	1	1752356-1	SUPPORT, TERMINAL	34
-	2	2	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	2	2	2	2	1-2844962-4	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	1	1	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29
-	1	1	1	1	1	1	1320928-4	STRIP GUIDE	24
-	1	1	-	-	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
-	2	2	1	1	2	2	1-18028-2	WASHER, FLAT, REG M4	20
-	1	1	-	-	1	1	2119533-3	STRIPPER, SIDE FEED	19
-	1	1	1	1	1	1	2119806-1	INSERT, SHEAR	13
-	1	1	1	1	1	1	3-22280-3	SPRING, COMPRESSION	12
-	1	1	1	1	1	1	1-356885-4	STOP, SHEAR	11
-	1	1	1	1	1	1	2119805-1	SHEAR HOLDER, FRONT	10
-	1	1	1	1	1	1	1803095-3	FLOATING SHEAR, FRONT	9
-	1	2	2	1	1	1	2-1633129-0	ANVIL, COMBINATION .062	8
-	1	1	1	1	1	1	2-240641-5	SPACER	7
-	-	-	-	-	-	-	-	-	6
-	1	1	1	1	1	1	2119757-8	DEPRESSOR, SHEAR	5
-	1	1	1	1	1	1	238011-9	BLOCK, CRIMPER SPACER	4
-	1	1	1	1	1	1	1803019-5	CRIMPER, INSULATION O	3
-	1	1	1	1	1	1	455888-1	SPACER, CRIMPER	2
-	1	2	2	1	1	1	4-456403-2	CRIMPER, WIRE PREMIUM	1

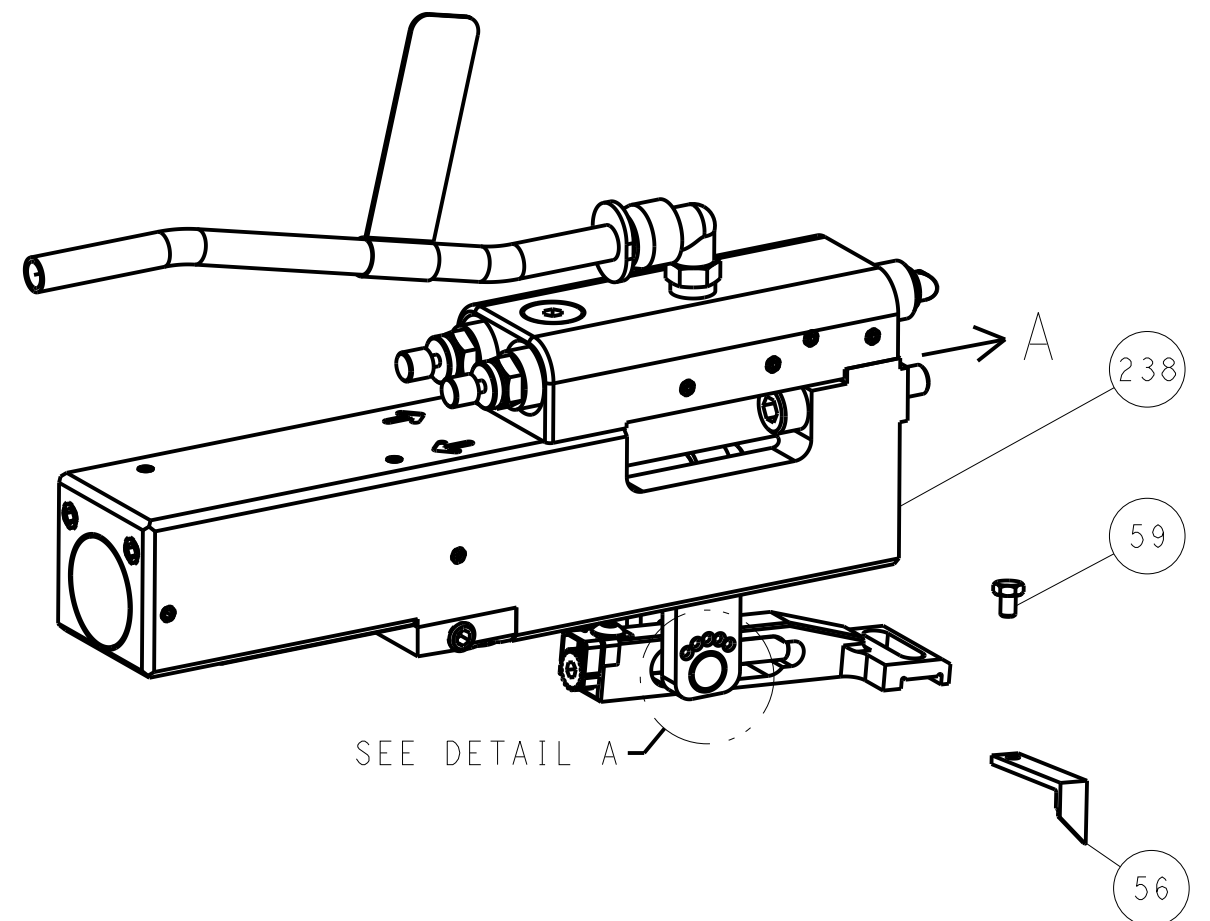
-77		-72	-71	-52	-51	-2	-1	PART NO	DESCRIPTION	ITEM NO
TYPICAL DIMENSIONS AND TOLERANCES FOR THE ATLANTIC VERSION THIS IS SUBJECT TO CHANGE AND FOR THE LATEST REVISIONS, CONTACT THE ORGANIZATION SHOWN BE CONTACTED FOR THE LATEST REVISION								DWN X.ZHAO 22OCT2015	TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm								CHK L.ZHANG 22OCT2015	NAME Ocean Side Feed Applicator	
TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±								APVD J.GUO 22OCT2015	PRODUCT SPEC	
MATERIAL								FINISH	APPLICATION SPEC	
									SIZE CASE CODE DRAWING NO	
									RESTRICTED TO	
									A1 00779 ©=2836074	
									Customer Accessible Production Drawing	
									SCALE 1:2 SHEET 1 OF 4 REV C	

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

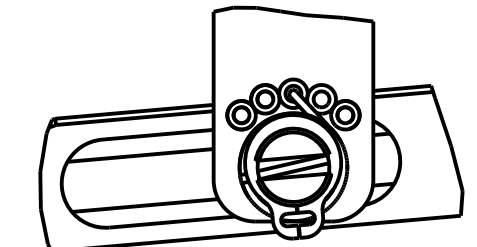
FEED TYPE
MECHANICAL



PNEUMATIC

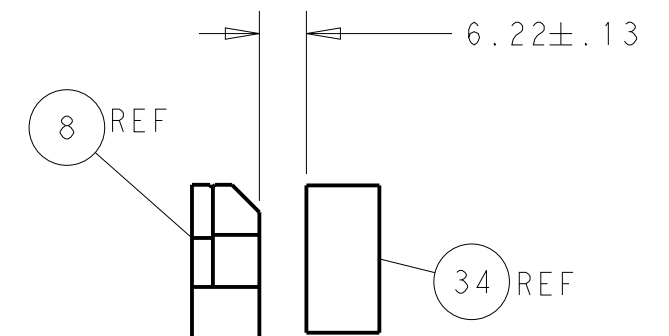
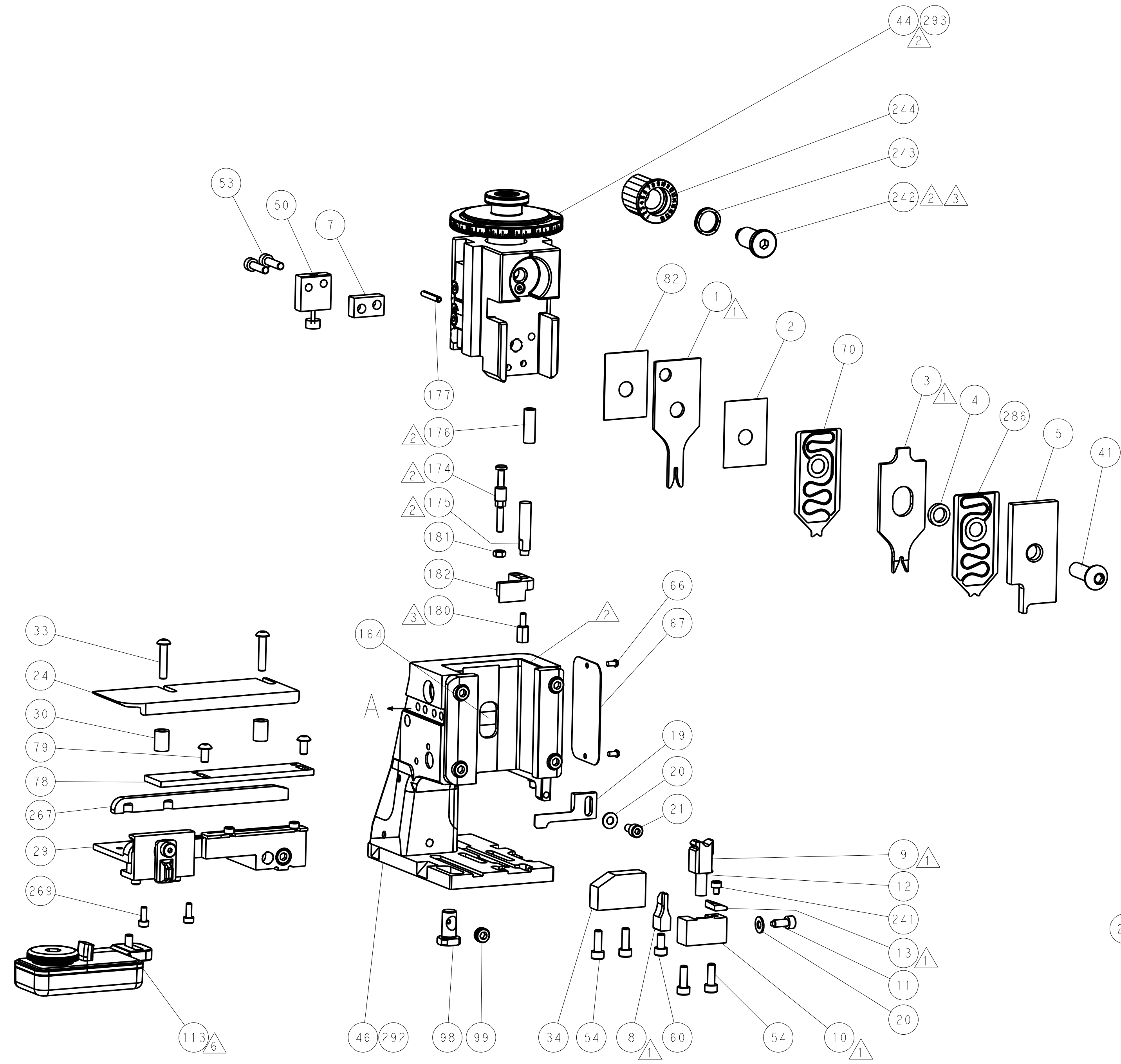
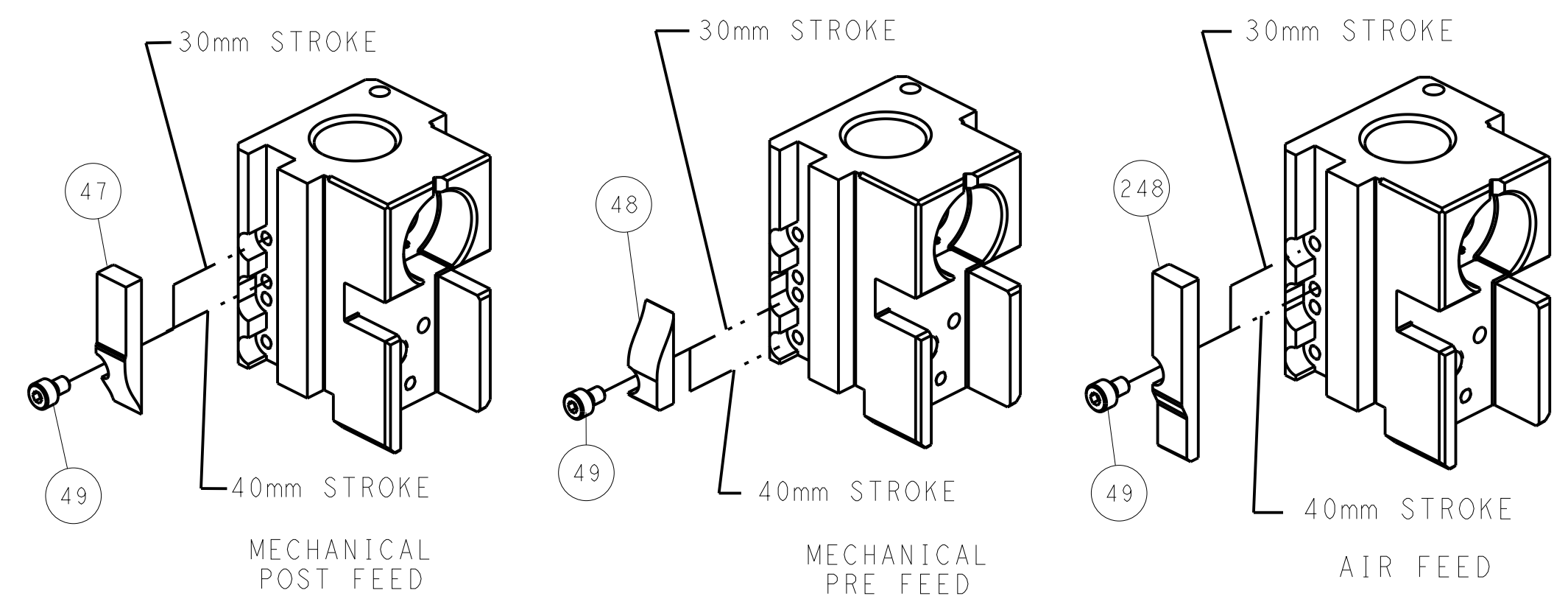


FEED SPRING SETTING POSITION
(SHOWN FROM REAR SIDE)

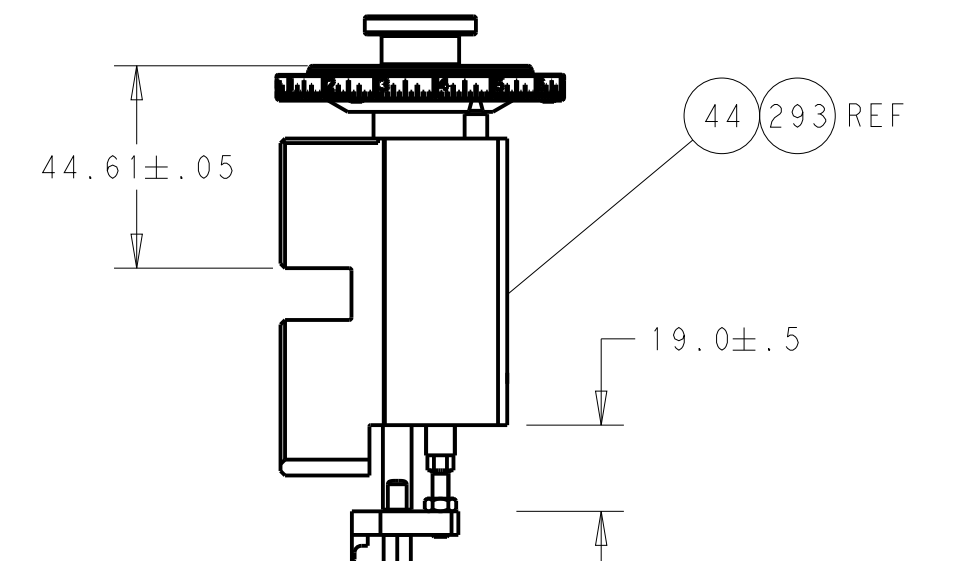


DETAIL A

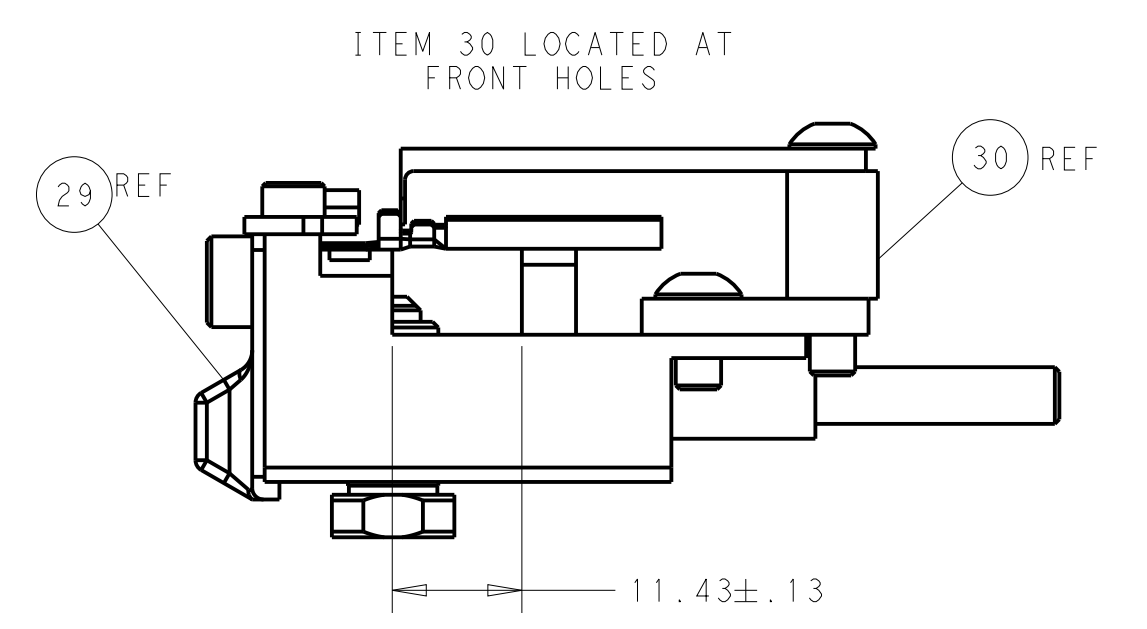
CAM POSITIONS



TERMINAL SUPPORT LOCATION



RAM AND HOLDDOWN SET-UP



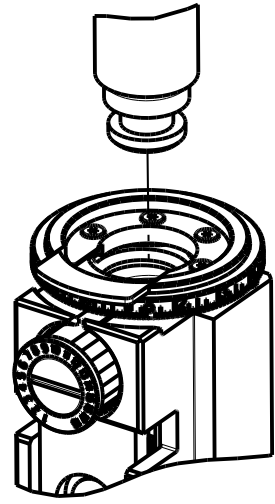
FEED TRACK POSITION
GUIDE BY INSULATION BARREL

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

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN X. ZHAO 22OCT2015		CHK L. ZHANG 22OCT2015		APVD H. GUO 22OCT2015		NAME Ocean Side Feed Applicator	
mm		0 PLC ±.1		1 PLC ±.1		2 PLC ±.1		3 PLC ±.1		4 PLC ±.1	
MATERIAL		FINISH		WEIGHT		Customer Accessible Production Drawing		SCALE 1:2		SHEET 2 OF 4	
										REV C	

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PART NUMBER		REVISION		DESCRIPTION				FEED TYPE			
2-2836074-1		B		FINE CRIMP HEIGHT ADJUST				MECHANICAL			
2-2836074-2		C		FINE CRIMP HEIGHT ADJUST				PNEUMATIC			
7-2836074-7		A		CRIMP TOOLING KIT				-			

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.58 mm [.062]	F
INSUL	2.29 mm [.090]	O
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: AMPHENOL TERMINAL TE CRIMP SPECIFICATION			
TERMINAL NAME: TERMINAL, PIN AND SOCKET			
WIRE STRIP LENGTH 2.50-3.00 mm [.098-.118 IN]		INSULATION DIAMETER RANGE Ø1.00-2.00 mm [.039-.079 IN]	
TERMINAL APPLICATION SPECIFICATION	NONE	-	-
TERMINALS APPLIED 6			
TE TERMINAL	AMPHENOL TERMINAL	TE TERMINAL	AMPHENOL TERMINAL
1949386-1	TN0201600031	1-1949387-1	TN0101600034
1949386-6	TN0201600032	1-1949387-2	TN0101600039
1949386-7	TN0201600034	1-1949387-3	TN0101600111
1949387-1	TN0101600031	1-1949387-4	TN0101600112
1-1949387-0	TN0101600032		

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING 4
20 AWG OR 0.50mm2		1.16+/-0.05 [.046+/- .002]		7.1
22 AWG OR 0.35mm2		1.08+/-0.05 [.043+/- .002]		7.5
24 AWG OR 0.20mm2		1.00+/-0.05 [.039+/- .002]		8.2
26 AWG OR 0.14mm2		0.97+/-0.05 [.038+/- .002]		8.5



- 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.
- 6 TERMINAL LUBRICANT IS RECOMMENDED.

*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)

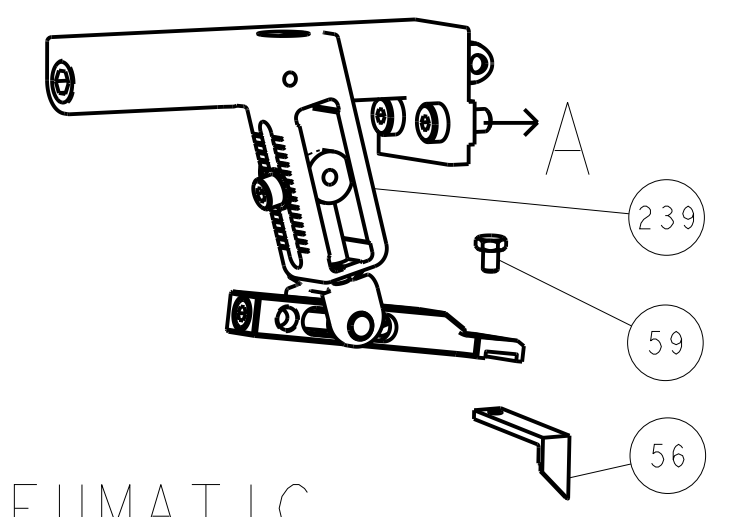
LOC	DIST	REVISIONS					
A	66	P	LTR	DESCRIPTION	DATE	DWN	APVD
			-	SEE SHEET 1	-	-	-

	-	1	1	2119791-9	DEPRESSOR, WIRE	286
	-	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	269
	-	1	1	1633782-3	FENCE	267
	-	1	1	2119082-8	CAM, SNAIL, INSULATION ADJUSTMENT	244
	-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
3	-	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
6	-	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	455888-5	SPACER, CRIMPER	82
	-	2	2	2079383-4	SCR, BHSC, RoHS (M4 X 8)	79
	-	1	1	1803096-1	EXTENSION PLATE	78
	-	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
	-	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
	-	1	1	1338683-8	FEED PAWL	56
	-	2	2	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	53
	-	1	1	1803382-6	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	1752356-1	SUPPORT, TERMINAL	34
	-	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
	-	2	2	1-2844962-4	SPACER, CYLINDRICAL, STRIP GUIDE	30
	-	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29
	-	1	1	1320928-4	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	2119533-3	STRIPPER, SIDE FEED	19
1	-	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	1	2119805-1	SHEAR HOLDER, FRONT	10
1	-	1	1	1803095-3	FLOATING SHEAR, FRONT	9
1	1	1	1	2-1633129-0	ANVIL, COMBINATION .062	8
	-	1	1	2-240641-5	SPACER	7
	-	-	-	-	-	6
	-	1	1	2119757-8	DEPRESSOR, SHEAR	5
	-	1	1	238011-9	BLOCK, CRIMPER SPACER	4
1	1	1	1	1803019-5	CRIMPER, INSULATION O	3
	-	1	1	455888-1	SPACER, CRIMPER	2
1	1	1	1	4-456403-2	CRIMPER, WIRE PREMIUM	1
	-77	-22	-21	PART NO	DESCRIPTION	ITEM NO

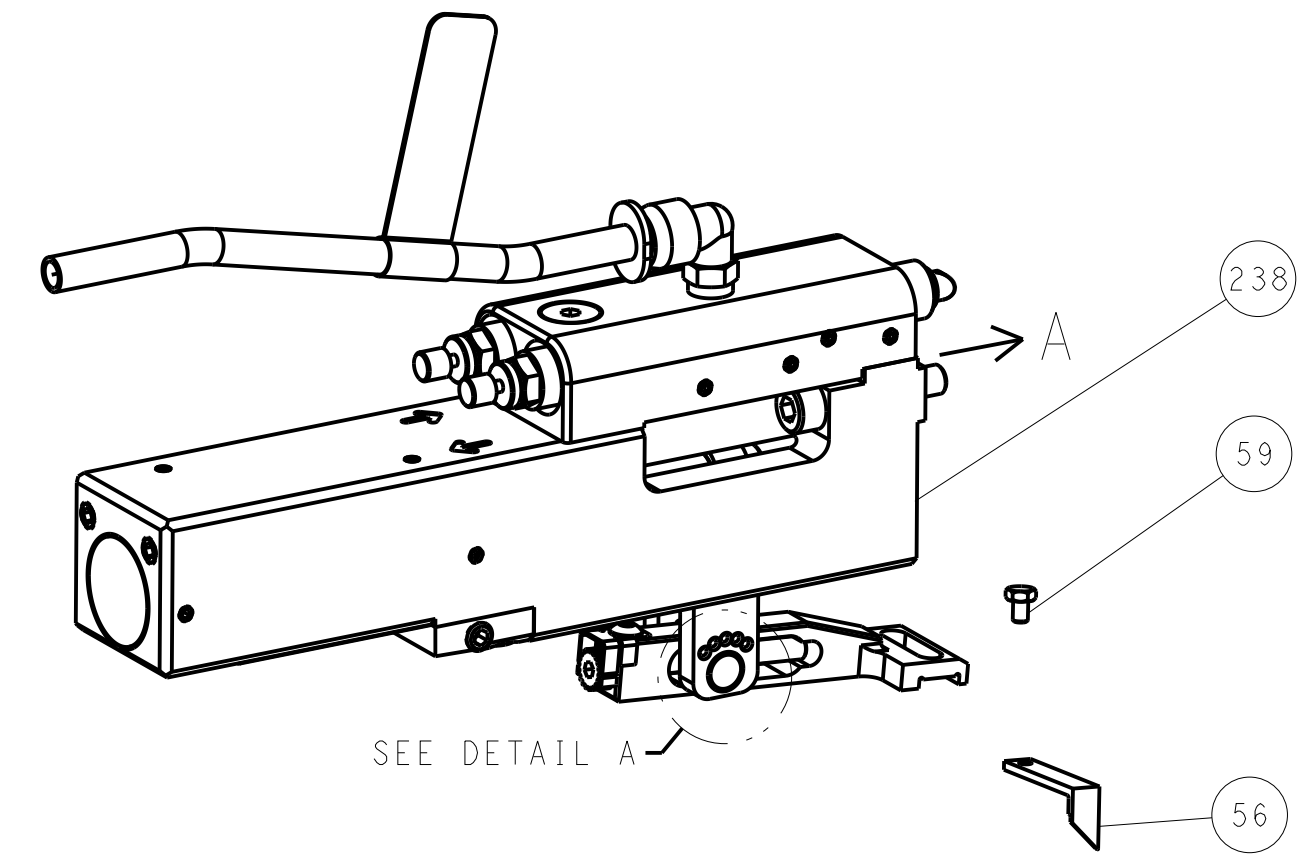
THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE AND THE USER SHALL BE RESPONSIBLE FOR OBTAINING THE LATEST EDITION. SHOULD BE CONTACTED FOR THE LATEST EDITION.				DWN X. ZHAO 22OCT2015	TE Connectivity Harrisburg, PA 17105-3608	
TOLERANCES UNLESS OTHERWISE SPECIFIED:				CHK L. ZHANG 22OCT2015	NAME	
DIMENSIONS:				APVD J. GUO 22OCT2015	Ocean Side Feed Applicator	
mm				PRODUCT SPEC	SIZE	
0 PLC ±				APPLICATION SPEC	CAGE CODE	
1 PLC ±				WEIGHT	DRAWING NO	
2 PLC ±				FINISH	RESTRICTED TO	
3 PLC ±					A1 00779	
4 PLC ±					C=2836074	
MATERIAL					Customer Accessible Production Drawing	
					SCALE 1:2	
					SHEET 3 OF 4	
					REV C	

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

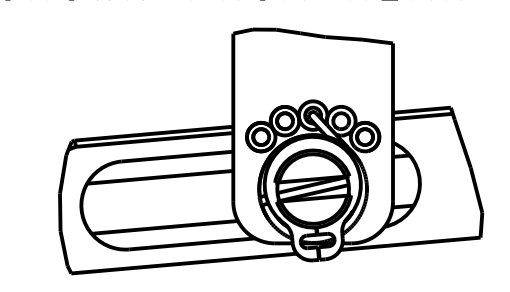
FEED TYPE MECHANICAL



PNEUMATIC

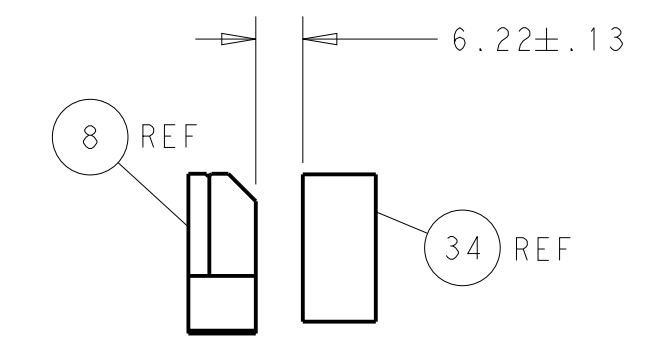
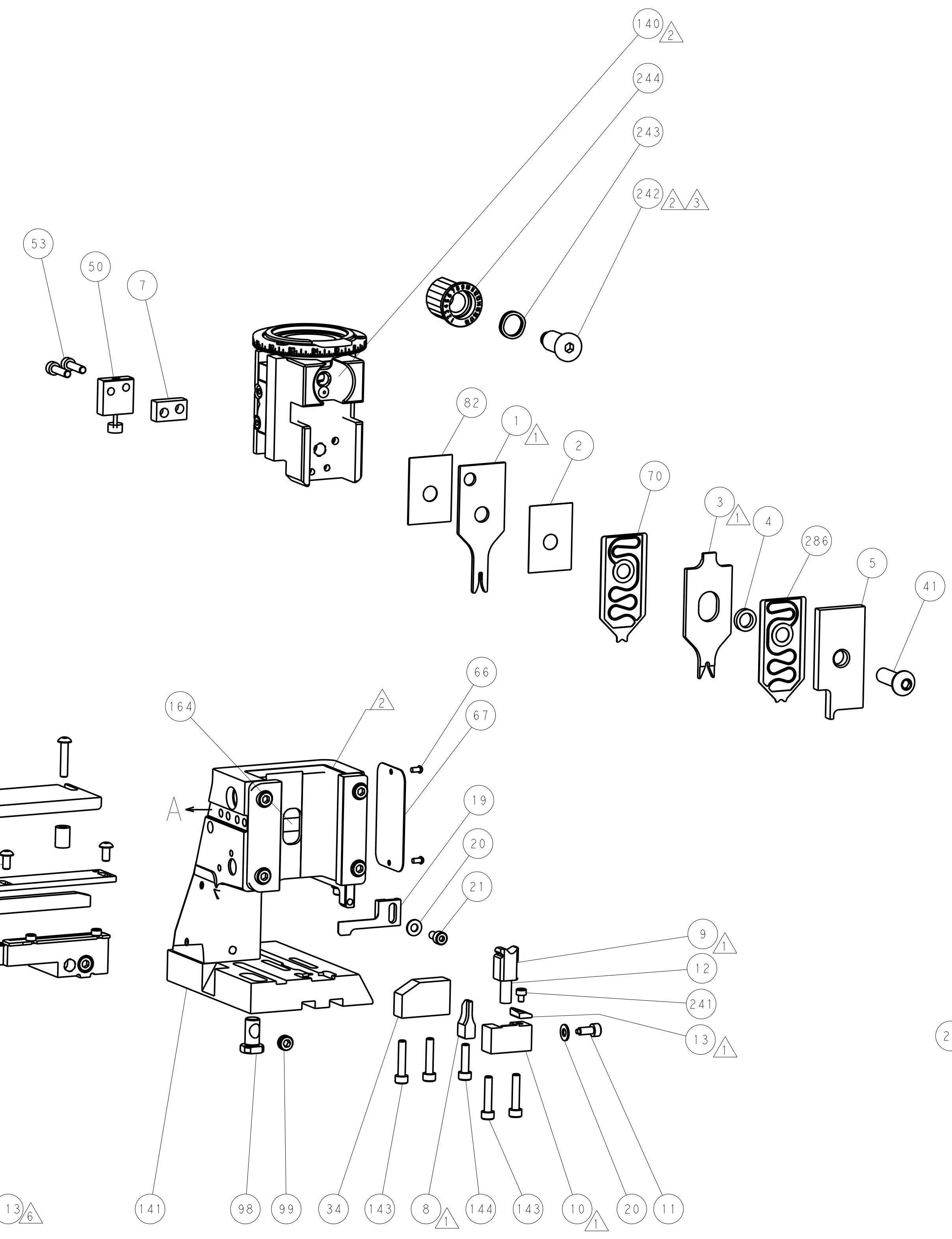
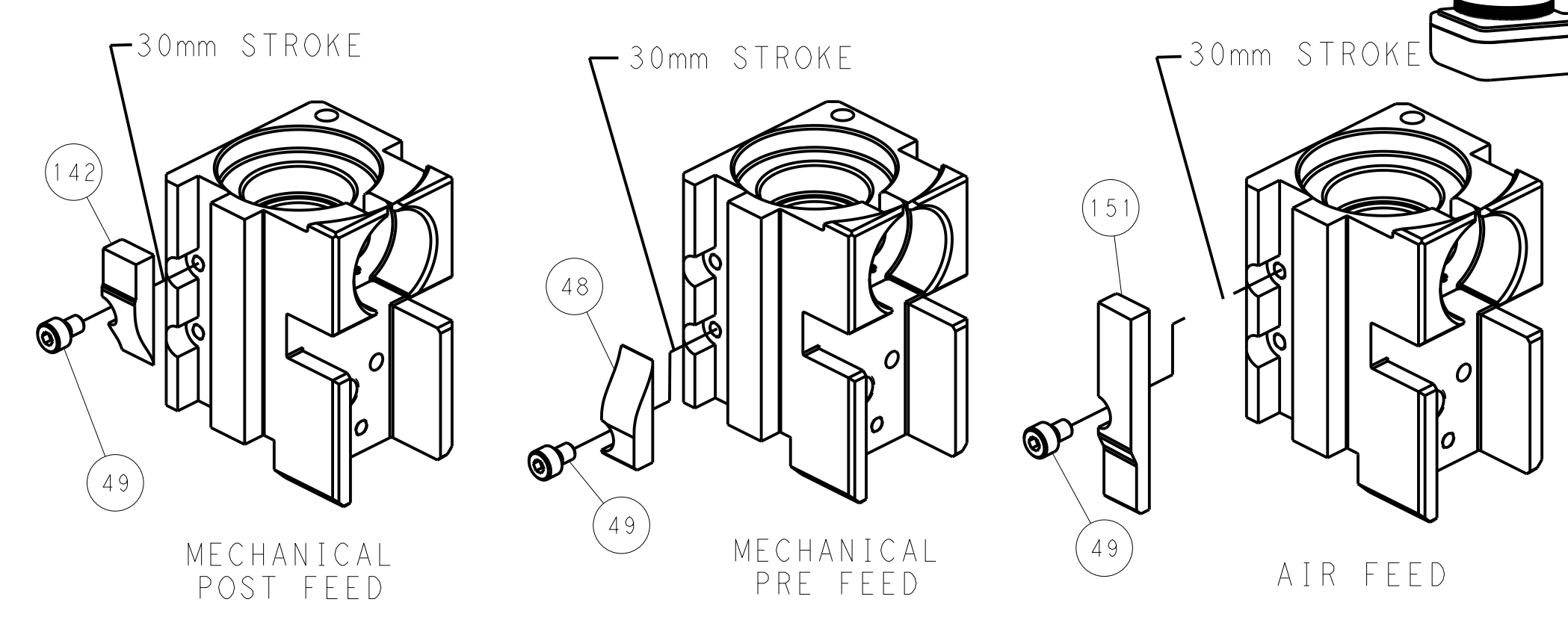


FEED SPRING SETTING POSITION
(SHOWN FROM REAR SIDE)

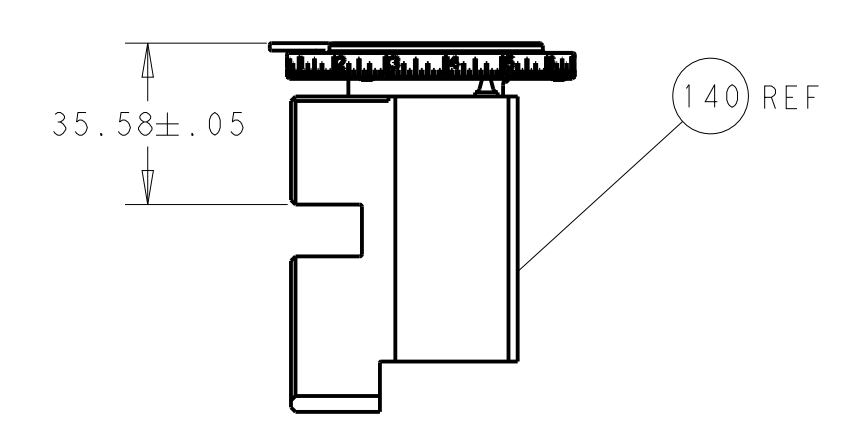


DETAIL A

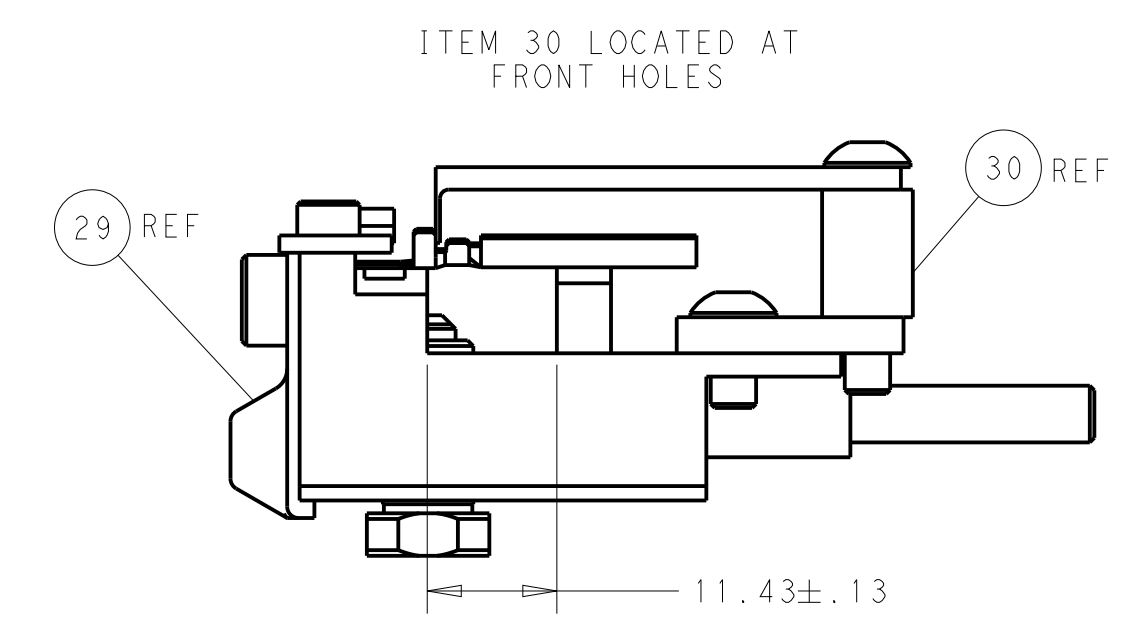
CAM POSITIONS



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)

DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN X. ZHAO 22OCT2015		CHK L. ZHANG 22OCT2015		APVD H. GUO 22OCT2015		NAME Ocean Side Feed Applicator	
0 PLC ±.1		1 PLC ±.1		2 PLC ±.1		3 PLC ±.1		4 PLC ±.1		SIZE A1	
MATERIAL -		FINISH -		WEIGHT -		Customer Accessible Production Drawing		SCALE 1:2		SHEET 4	
										REV C	

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