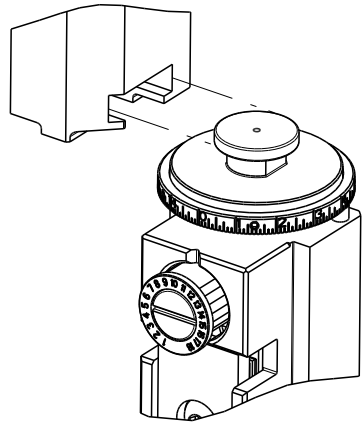


8	7
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RELEASED FOR PUBLICATION 2016	
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PART NUMBER	REVISION
2836154-2	B
7-2836154-2	B
7-2836154-7	A
DESCRIPTION	
FINE CRIMP HEIGHT ADJUST	
PNEUMATIC AND CRIMP TOOLING KIT	
CRIMP TOOLING KIT	
FEED TYPE	
PNEUMATIC	
PNEUMATIC	
-	

ATLANTIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.20 mm [.047]	F
INSUL	1.90 mm [.075]	F
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: MOLEX TERMINAL		MOLEX CRIMP SPECIFICATION	
TERMINAL NAME: R/A B-IN TERMINAL			
WIRE STRIP LENGTH 1.80-2.20 mm [.071-.087 IN]			INSULATION DIAMETER RANGE Ø 1.90 mm MAX [.075 IN MAX]
TERMINAL APPLICATION SPECIFICATION		ATS-639029100 Rev A	-
-		-	-
TERMINALS APPLIED 			
TE TERMINAL	MOLEX TERMINAL	TE TERMINAL	MOLEX TERMINAL
2113937-1	350211160	2113937-4	350211100
2113937-2	350211110	2113937-5	350211101
2113937-3	350211001		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
22 AWG OR 0.32mm2	0.74+/-0.025 [.029+/- .001]	5.0
24 AWG OR 0.20mm2	0.69+/-0.025 [.027+/- .001]	5.3
26 AWG OR 0.13mm2	0.64+/-0.025 [.025+/- .001]	5.8
28 AWG OR 0.08mm2	0.59+/-0.025 [.023+/- .001]	6.5



- 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.
5. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- 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)

LOC	DIST	REVISIONS			
A	66	P	LTR	DESCRIPTION	DATE
			A	RELEASED	11MAR2016
			B	ECR-20-015458	29OCT2020

	-	1	1	2119641-1	FEED CAM, AIR FEED	248
	-	1	1	2119082-4	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	1	2844940-1	AIR FEED MODULE	238
	-	REF	REF	994970-2	COUNTER, MAGNETIC	164
	-	1	1	2844908-1	SCREW, LOCKING	99
	-	1	1	2844907-1	POST, LOCKING	98
	-	1	1	1-455888-2	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	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	1338685-1	PAWL, FEED	56
	-	2	2	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	54
	-	1	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49
	-	1	1	1803583-9	APPLICATOR BASIC ASSEMBLY, SF	46
	-	1	1	1803515-1	RAM ASSEMBLY, SF ATLANTIC	44
	-	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
	-	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
	-	2	2	2-2844962-3	SPACER, CYLINDRICAL, STRIP GUIDE	30
	-	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29
	-	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	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	1803095-6	FLOATING SHEAR, FRONT -	9
1	1	2	1	6-1803057-8	ANVIL, COMBINATION	8
	-	-	-	-	-	7
	-	-	-	-	-	6
	-	1	1	2119757-4	DEPRESSOR, SHEAR	5
	-	1	1	5-238011-3	BLOCK, CRIMPER SPACER	4
1	1	2	1	1-1803223-0	CRIMPER, INSULATION F PREMIUM	3
	-	1	1	1-455888-4	SPACER, CRIMPER	2
1	1	2	1	9-1633730-2	CRIMPER, WIRE	1
	-77-72	-2		PART NO	DESCRIPTION	ITEM NO

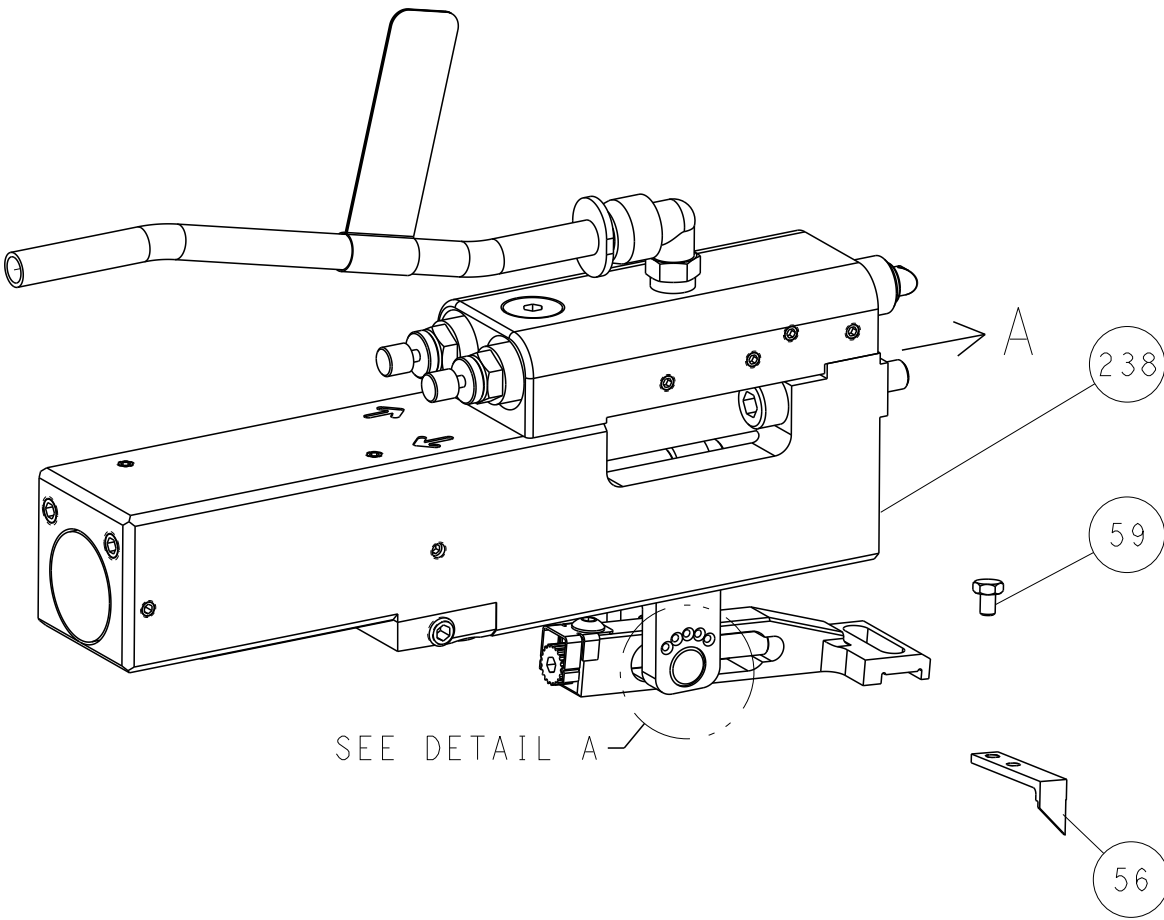
THIS DRAWING IS A CONTROLLED DOCUMENT AND THE LATEST EDITION SHOULD BE CONSULTED FOR THE LATEST NOTATION.				OWN B. WEAVER 08FEB2016		 TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS:				CHK T. ELBIN 08FEB2016		NAME	
mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		APVD T. ELBIN 08FEB2016		Ocean Side Feed Applicator	

SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

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

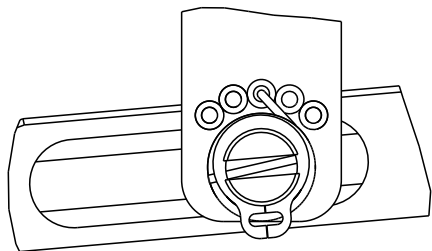
FEED TYPE

PNEUMATIC



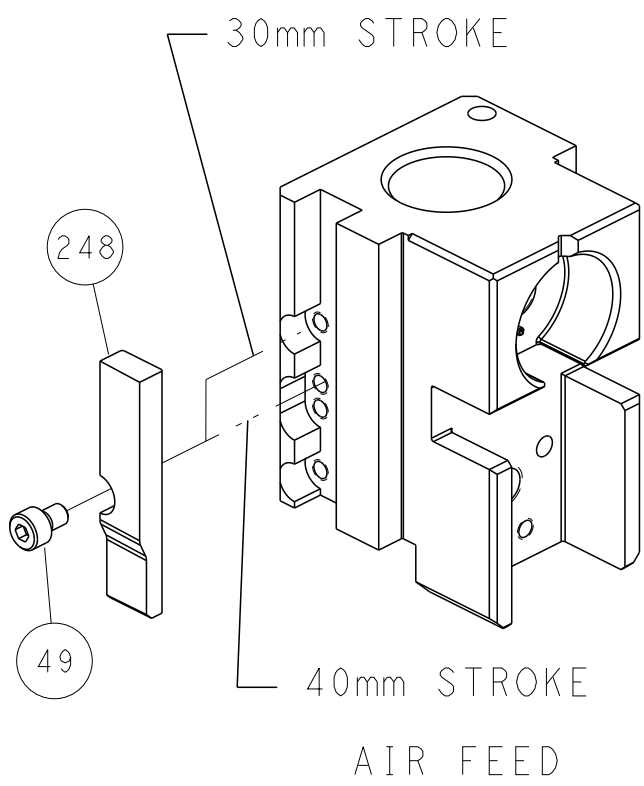
SEE DETAIL A

FEED SPRING SETTING POSITION
(SHOWN FROM REAR SIDE)

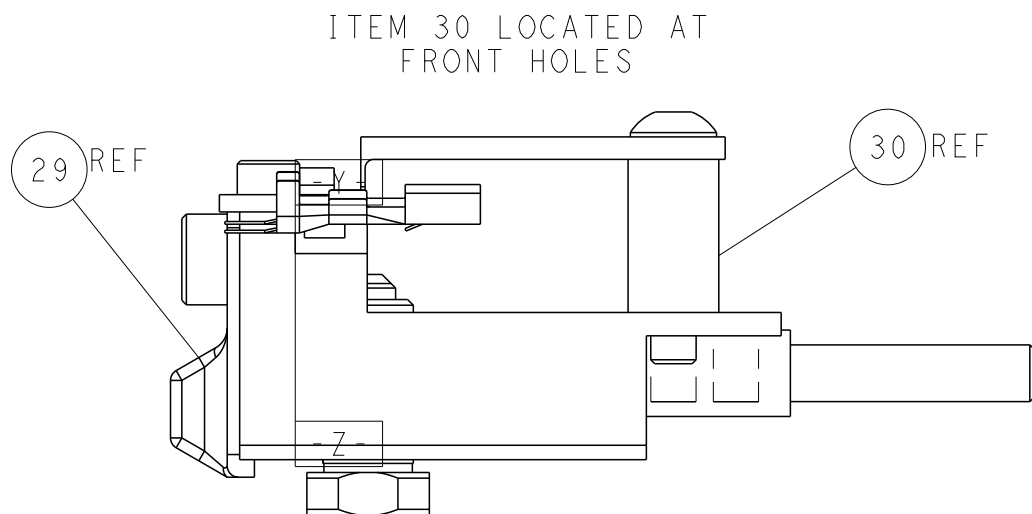
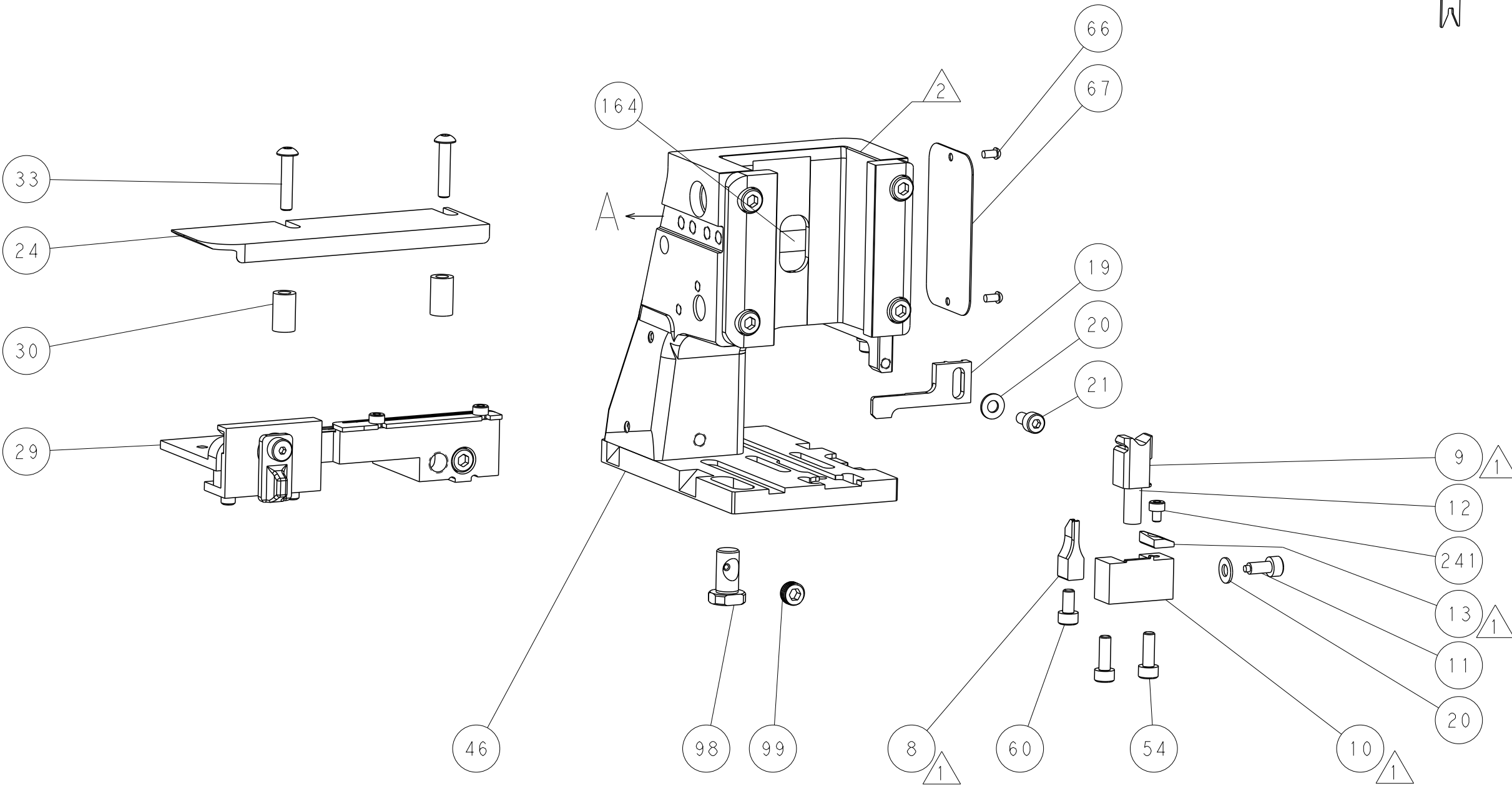
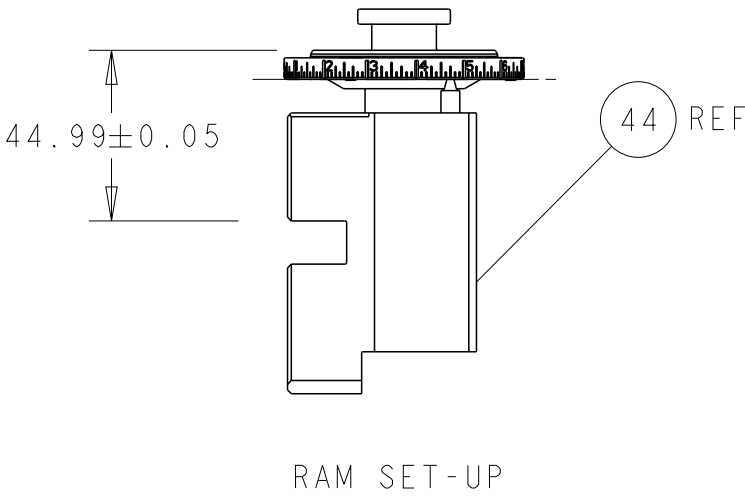
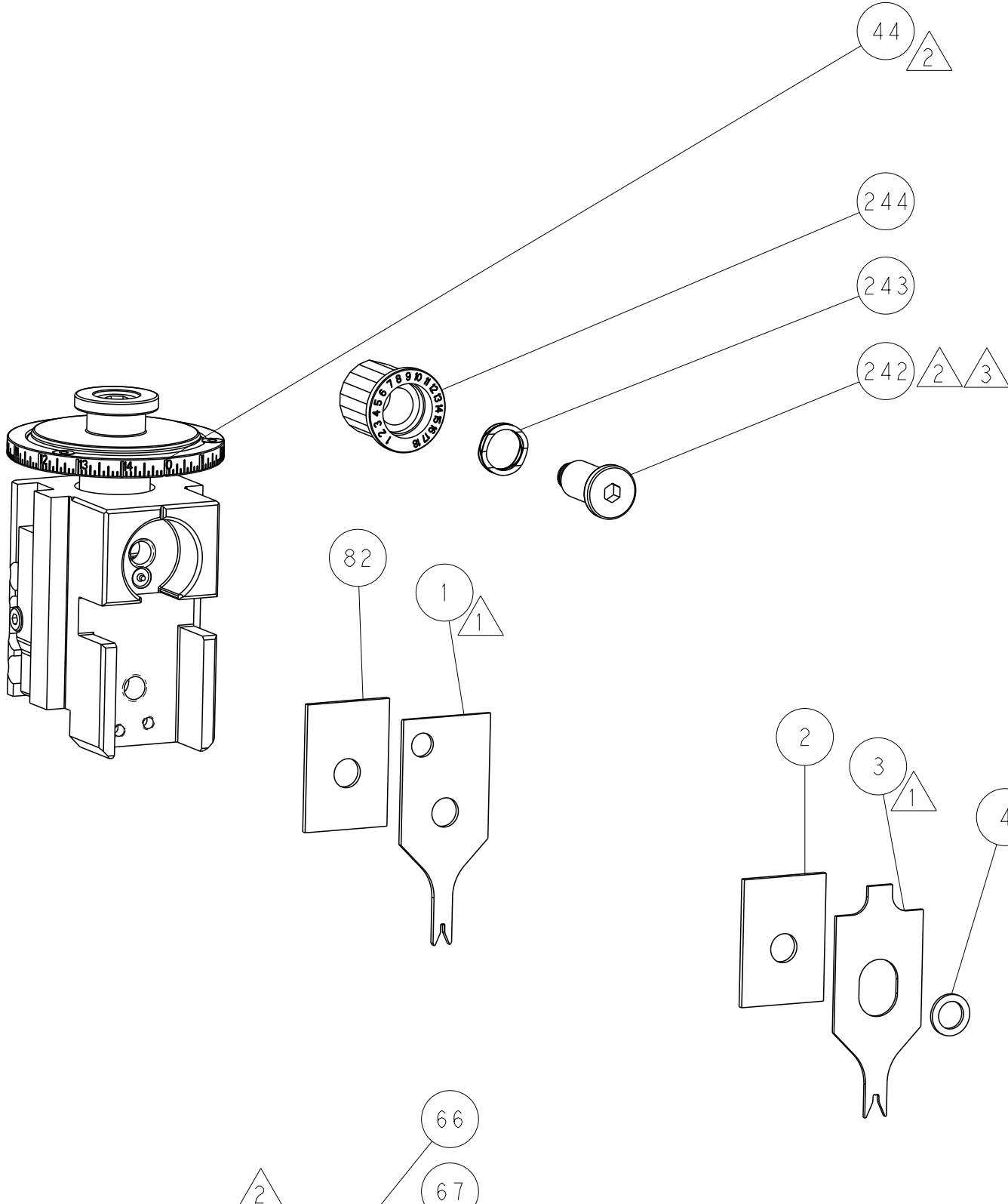


DETAIL A

CAM POSITION



AIR FEED



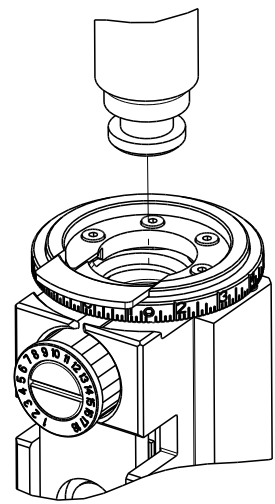
FEED TRACK POSITION
GUIDE BY INSULATION BARREL

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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				CHK'd T. ELBIN	08FEB2016	
				APVD T. ELBIN	08FEB2016	
				PRODUCT SPEC		
DIMENSIONS: mm				APPLICATION SPEC		NAME Ocean Side Feed Applicator -
				0 PLC	±	
				1 PLC	±	
				2 PLC	±	
				3 PLC	±	
				4 PLC	±	
				ANGLES	±	
				FINISH	±	
MATERIAL -				WEIGHT -		SIZE A1
				Customer Accessible Production Drawing		
				SCALE 1:2		
				SHEET 2	OF 4	
				REV B		

SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

8		7	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2836154-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2836154-7	A	CRIMP TOOLING KIT	-



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.20 mm [.047]	F
INSUL	1.90 mm [.075]	F
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: MOLEX TERMINAL		MOLEX CRIMP SPECIFICATION	
TERMINAL NAME: R/A B-IN TERMINAL			
WIRE STRIP LENGTH 1.80-2.20 mm [.071-.087 IN]		INSULATION DIAMETER RANGE Ø 1.90 mm MAX [.075 IN MAX]	
TERMINAL APPLICATION SPECIFICATION ATS-639029100 Rev A		-	-
TERMINALS APPLIED 			
TE TERMINAL	MOLEX TERMINAL	TE TERMINAL	MOLEX TERMINAL
2113937-1	350211160	2113937-4	350211100
2113937-2	350211110	2113937-5	350211101
2113937-3	350211001		

WIRE SIZE			CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING
22 AWG OR 0.32mm2			0.74+/-0.025 [0.029+/-0.001]		5.0
24 AWG OR 0.20mm2			0.69+/-0.025 [0.027+/-0.001]		5.3
26 AWG OR 0.13mm2			0.64+/-0.025 [0.025+/-0.001]		5.8
28 AWG OR 0.08mm2			0.59+/-0.025 [0.023+/-0.001]		6.5



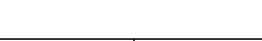
- △ RECOMMENDED SPARE PARTS
- △ REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- △ APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242.
- △ CRIMP HEIGHT REFERENCE SETTING WAS THE SETTING USED WHEN THE APPLICATOR WAS QUALIFIED AT THE FACTORY. ADJUSTMENT MAY BE NECESSARY WHEN RUNNING APPLICATOR IN THE FIELD.
5. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- △ TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.

PACIFIC VERSION

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

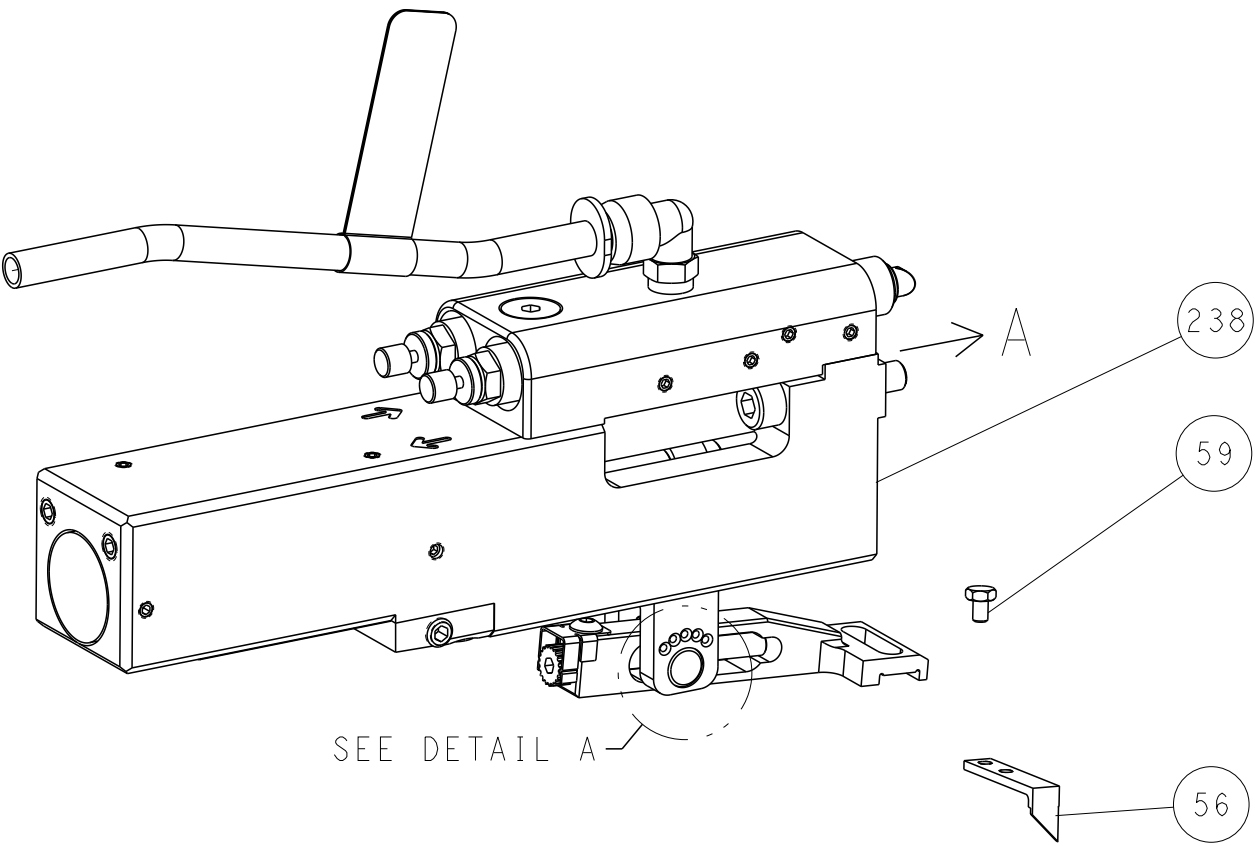
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	-	1	2119082-4	CAM, SNAIL, INSULATION ADJUSTMENT	243
	-	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
3	-	1	2119083-1	RETAINER, INSULATION DIAL	242
	-	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
	-	1	2844940-1	AIR FEED MODULE	238
	-	REF	994970-2	COUNTER, MAGNETIC	164
	-	1	2119641-2	FEED CAM, AIR FEED	155
	-	1	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	144
	-	2	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	143
	-	1	1-1803583-0	APPLICATOR BASIC ASSEMBLY, SF	141
	-	1	1803516-1	RAM ASSEMBLY, SF PACIFIC	140
	-	1	2844908-1	SCREW, LOCKING	99
	-	1	2844907-1	POST, LOCKING	98
	-	1	1-455888-2	SPACER, CRIMPER	82
	-	1	1803607-3	DOCUMENTATION PACKAGE	71
	-	1	2119740-1	TAG, IDENTIFICATION	67
	-	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
	-	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
	-	1	1338685-1	PAWL, FEED	56
	-	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49
	-	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
	-	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
	-	2	2-2844962-3	SPACER, CYLINDRICAL, STRIP GUIDE	30
	-	1	2844992-1	ASSEMBLY, STRIP GUIDE	29
	-	1	1320928-2	STRIP GUIDE	24
	-	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	-	1	2119806-1	INSERT, SHEAR	13
	-	1	3-22280-3	SPRING, COMPRESSION	12
	-	1	1-356885-4	STOP, SHEAR	11
	-	1	2119805-1	SHEAR HOLDER, FRONT	10
	-	1	1803095-6	FLOATING SHEAR, FRONT -	9
1	1	1	6-1803057-8	ANVIL, COMBINATION	8
	-	-	-	-	7
	-	-	-	-	6
	-	1	2119757-4	DEPRESSOR, SHEAR	5
	-	1	5-238011-3	BLOCK, CRIMPER SPACER	4
1	1	1	1-1803223-0	CRIMPER, INSULATION F PREMIUM	3
	-	1	1-455888-4	SPACER, CRIMPER	2
1	1	1	9-1633730-2	CRIMPER, WIRE	1
-77	-22		PART NO	DESCRIPTION	ITEM NO

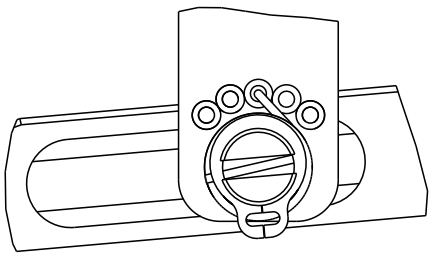
THIS DRAWING IS A CONTROLLED DOCUMENT AND THE ELECTRICAL INFORMATION SHOULD BE CHECKED FOR THE LATEST VERSION.		OWN S. WEAVER 08FEB2016 CHK T. ELBIN 08FEB2016 APP'D T. ELBIN 08FEB2016		 TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± ANGLES ± FINISH		NAME Ocean Side Feed Applicator	
		PRODUCT SPEC - APPLICATION SPEC -		SIZE CASE CODE DRAWING NO A 00779 C=2836154	
MATERIAL -		WEIGHT -		RESTRICTED TO -	
Customer Accessible Production Drawing				SCALE 1:2 SHEET 3 OF 4 REV B	

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

FEED TYPE
PNEUMATIC

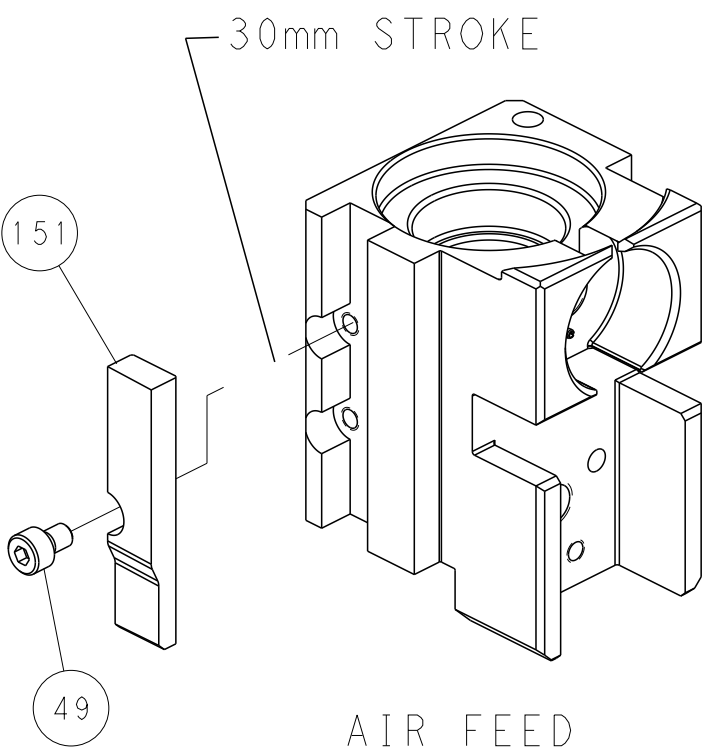


FEED SPRING SETTING POSITION
(SHOWN FROM REAR SIDE)

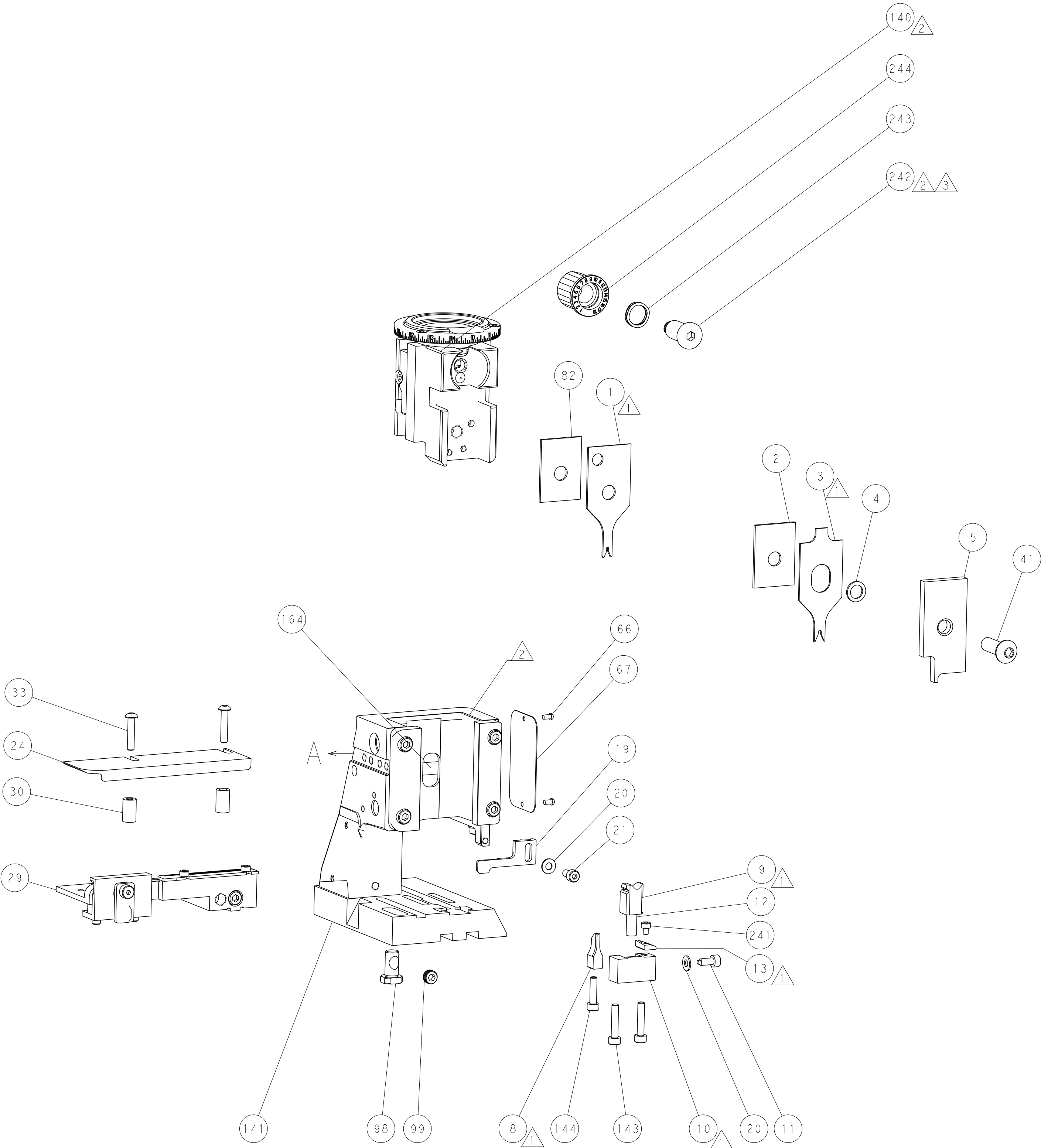


DETAIL A

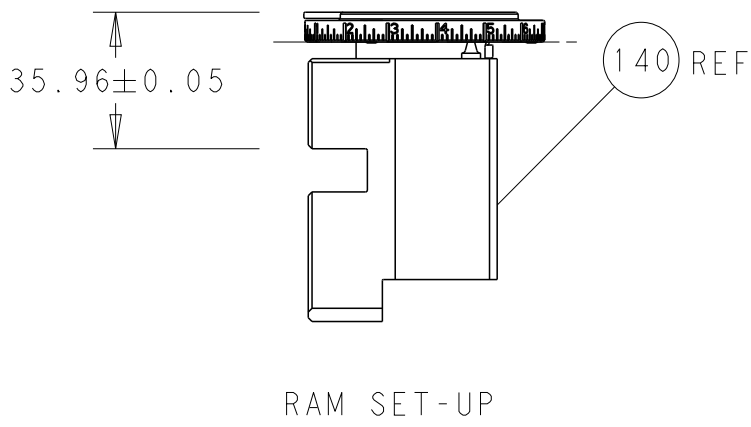
CAM POSITION



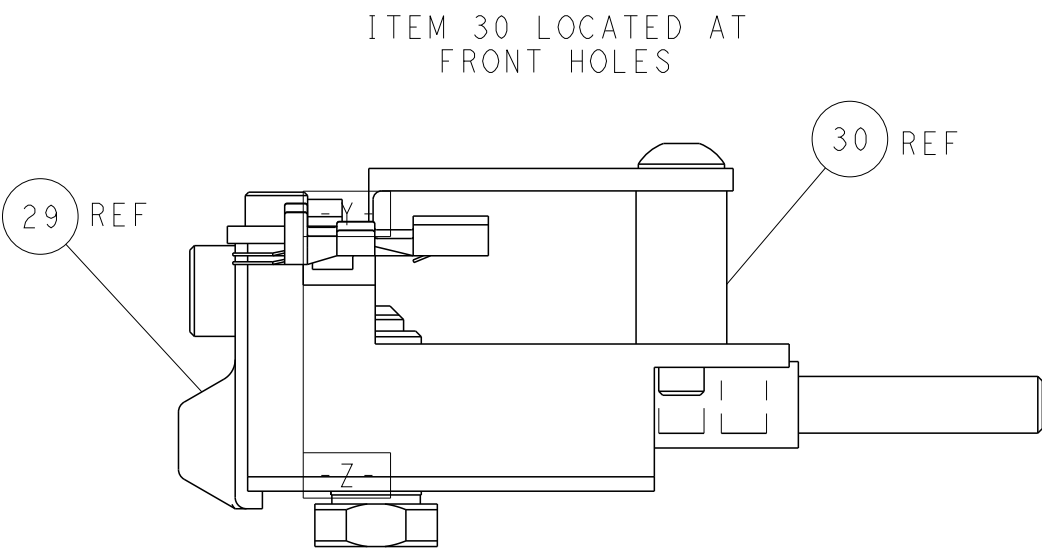
AIR FEED



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



RAM SET-UP



FEED TRACK POSITION
GUIDE BY INSULATION BARREL

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				CHK T. ELBIN	08FEB2016				
				APVD T. ELBIN	08FEB2016	NAME Ocean Side Feed Applicator			
				PRODUCT SPEC					
				APPLICATION SPEC					
DIMENSIONS:				TOLERANCES, UNLESS OTHERWISE SPECIFIED:					
mm									

Mouser Electronics

Authorized Distributor

Click to View Pricing, Inventory, Delivery & Lifecycle Information:

[TE Connectivity:](#)

[2836154-2](#)