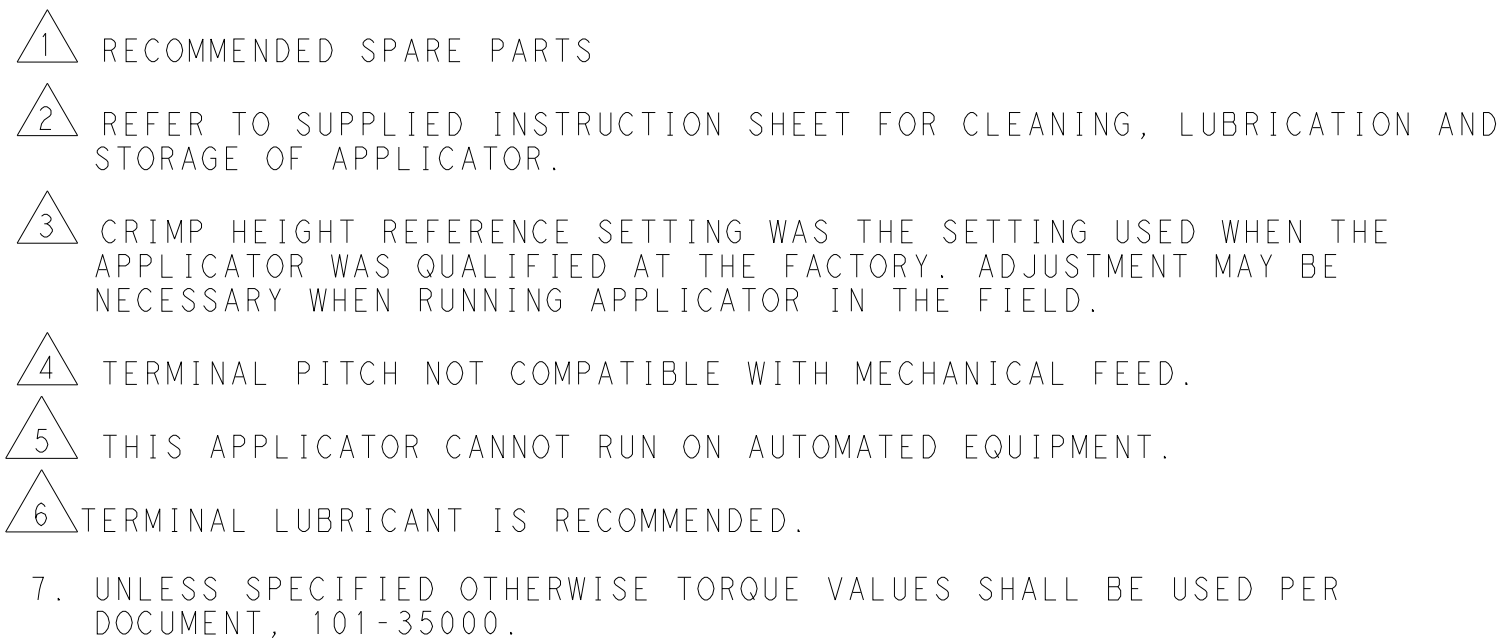


WIRE SIZE			CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING
RG316 OR RG174			0.83+/-0.03 [0.033+/-0.001]		4.0



*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.

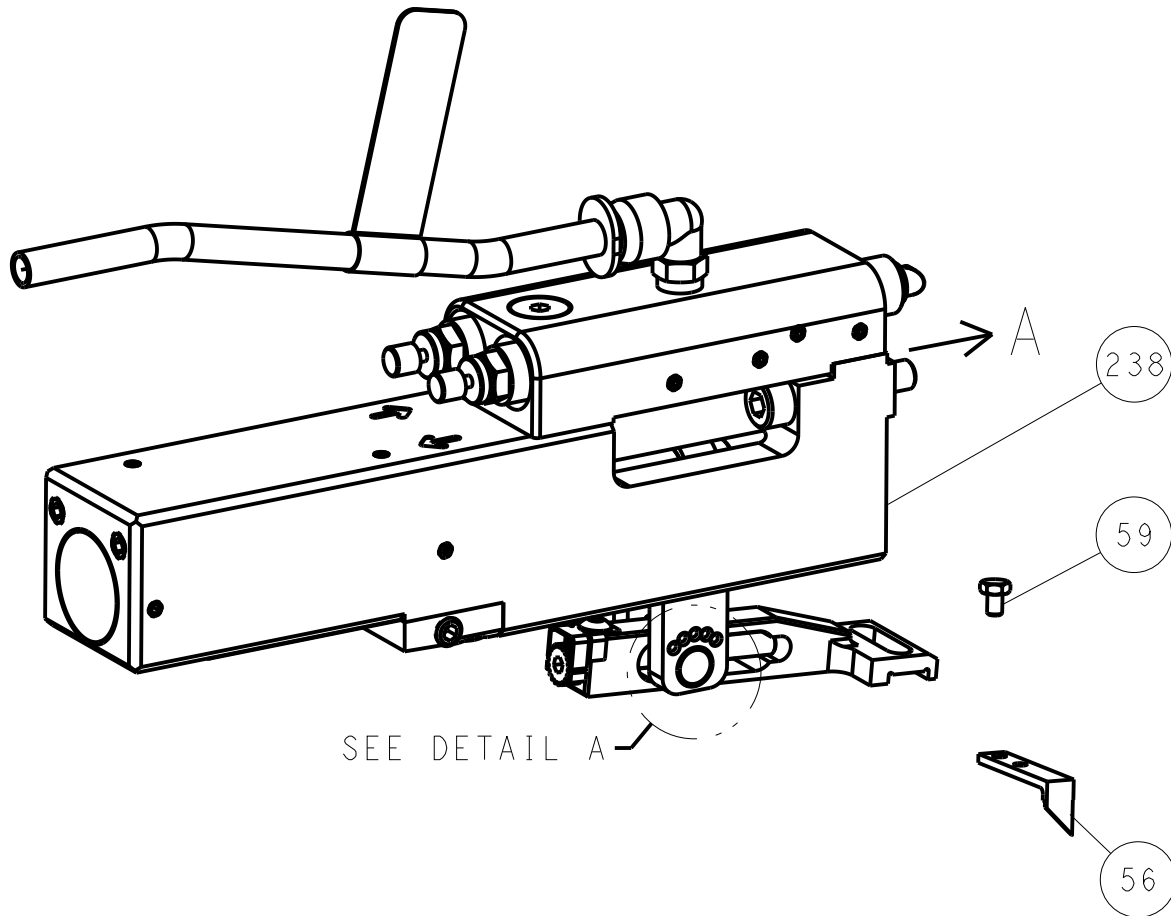
6	-	1	1	2119641-1	FEED CAM, AIR FEED	248
	-	1	1	2844940-1	AIR FEED MODULE	238
	-	REF	REF	994970-2	COUNTER, MAGNETIC	164
	-	1	1	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113
	-	1	1	2844908-1	SCREW, LOCKING	99
	-	1	1	2844907-1	POST, LOCKING	98
	-	1	1	455888-6	SPACER, CRIMPER	82
	-	1	1	1803607-3	DOCUMENTATION PACKAGE	7 1
	-	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
	-	4	4	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	54
	-	2	2	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	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	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
	-	1	1	1752356-1	SUPPORT, TERMINAL	34
	-	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	455888-7	SPACER, CRIMPER	28	
-	1	1	1320928-2	STRIP GUIDE	24	
-	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21	
-	3	3	1-18028-2	WASHER, FLAT, REG M4	20	
-	1	1	2119533-1	STRIPPER, SIDE FEED	19	
-	1	1	3-22280-3	SPRING, COMPRESSION	12	
-	1	1	356885-4	STOP, SHEAR	11	
-	1	1	1803216-1	HOLDER, SHEAR	10	
-	1	1	1338293-4	SHEAR, FLOATING	9	
1	2	1	1803190-8	ANVIL, WIRE	8	
-	1	1	1-240641-3	SPACER	7	
-	-	-	-	-	6	
-	1	1	1-2119757-6	DEPRESSOR, SHEAR	5	
-	-	-	-	-	4	
-	-	-	-	-	3	
-	-	-	-	-	2	
1	2	1	3-1803241-5	CRIMPER, WIRE F	1	
-77-72	-2	PART NO			DESCRIPTION	ITEM NO

SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

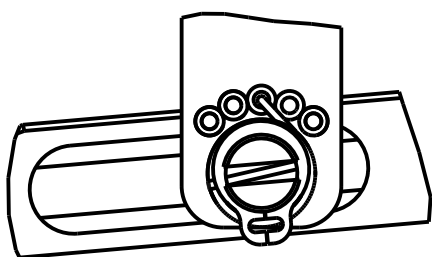
LOC	DIST	REVISIONS					
		P	LTR	DESCRIPTION	DATE	DWN	APVD
A	66	-	-	SEE SHEET 1	-	-	-

FEED TYPE

PNEUMATIC

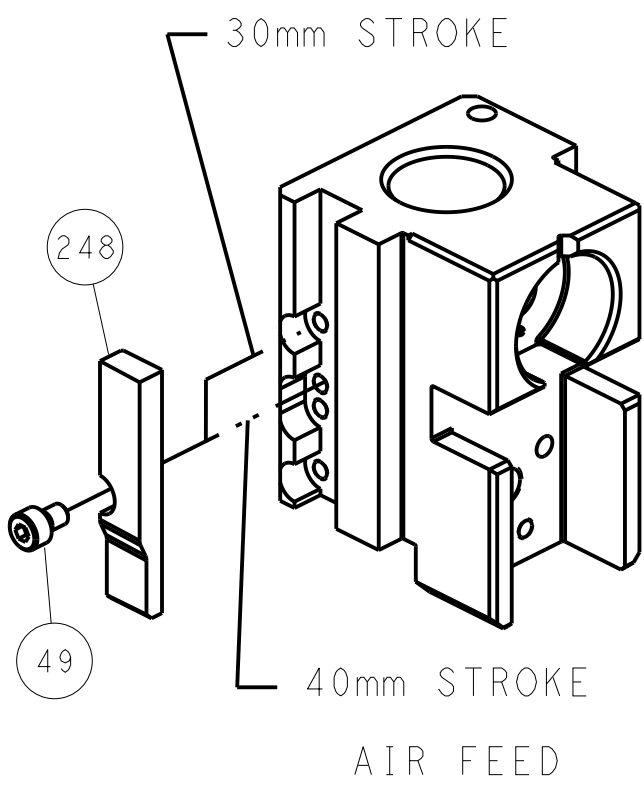


FEED SPRING SETTING POSITION
(SHOWN FROM REAR SIDE)

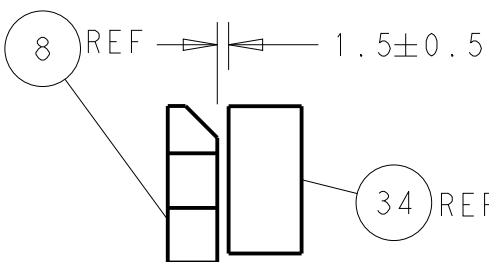
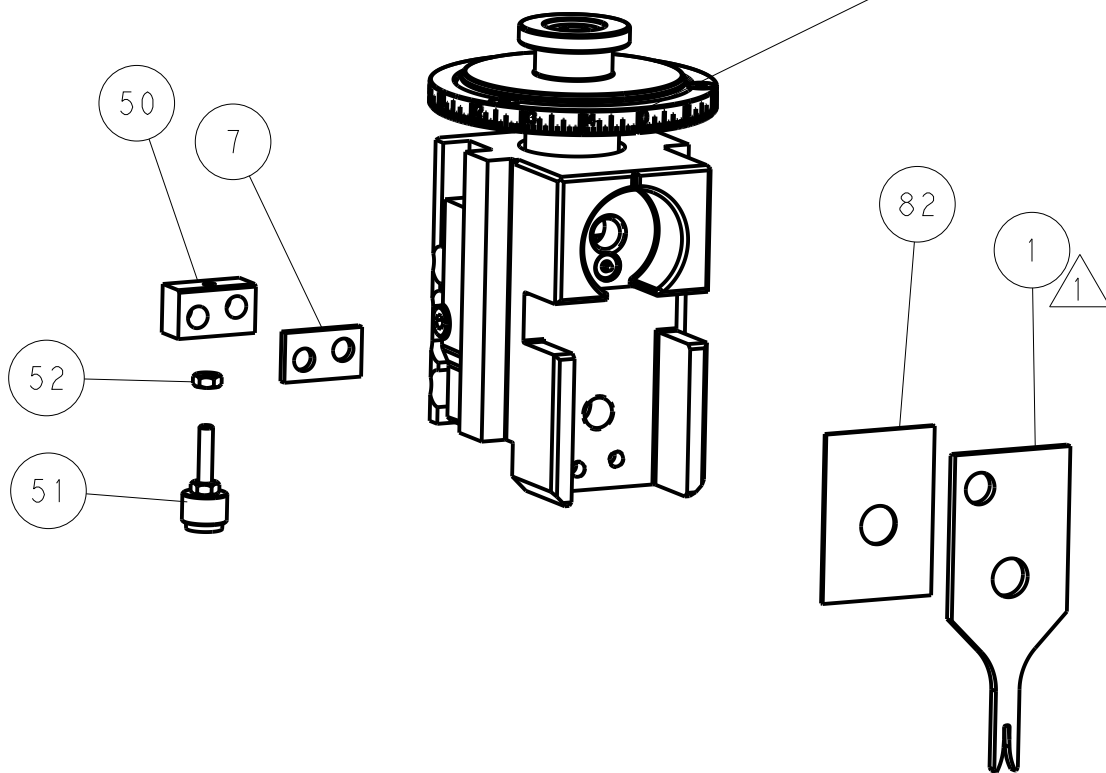


DETAIL A

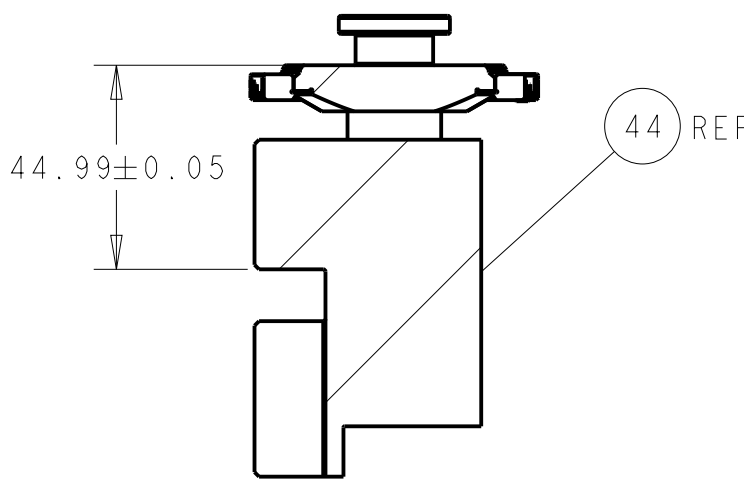
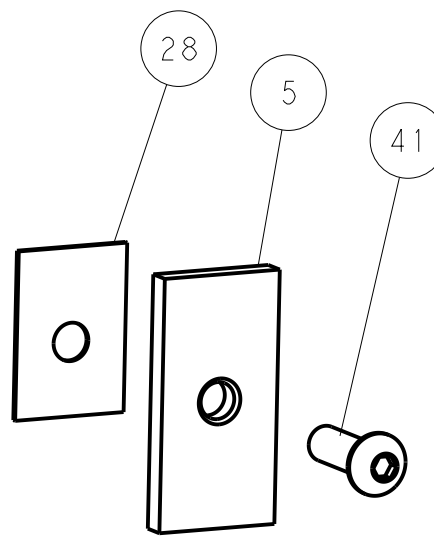
CAM POSITION



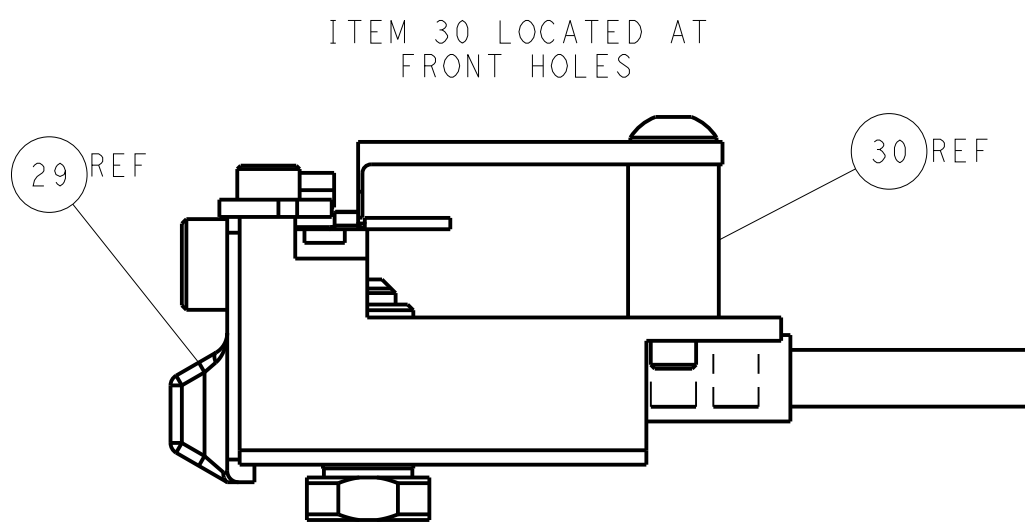
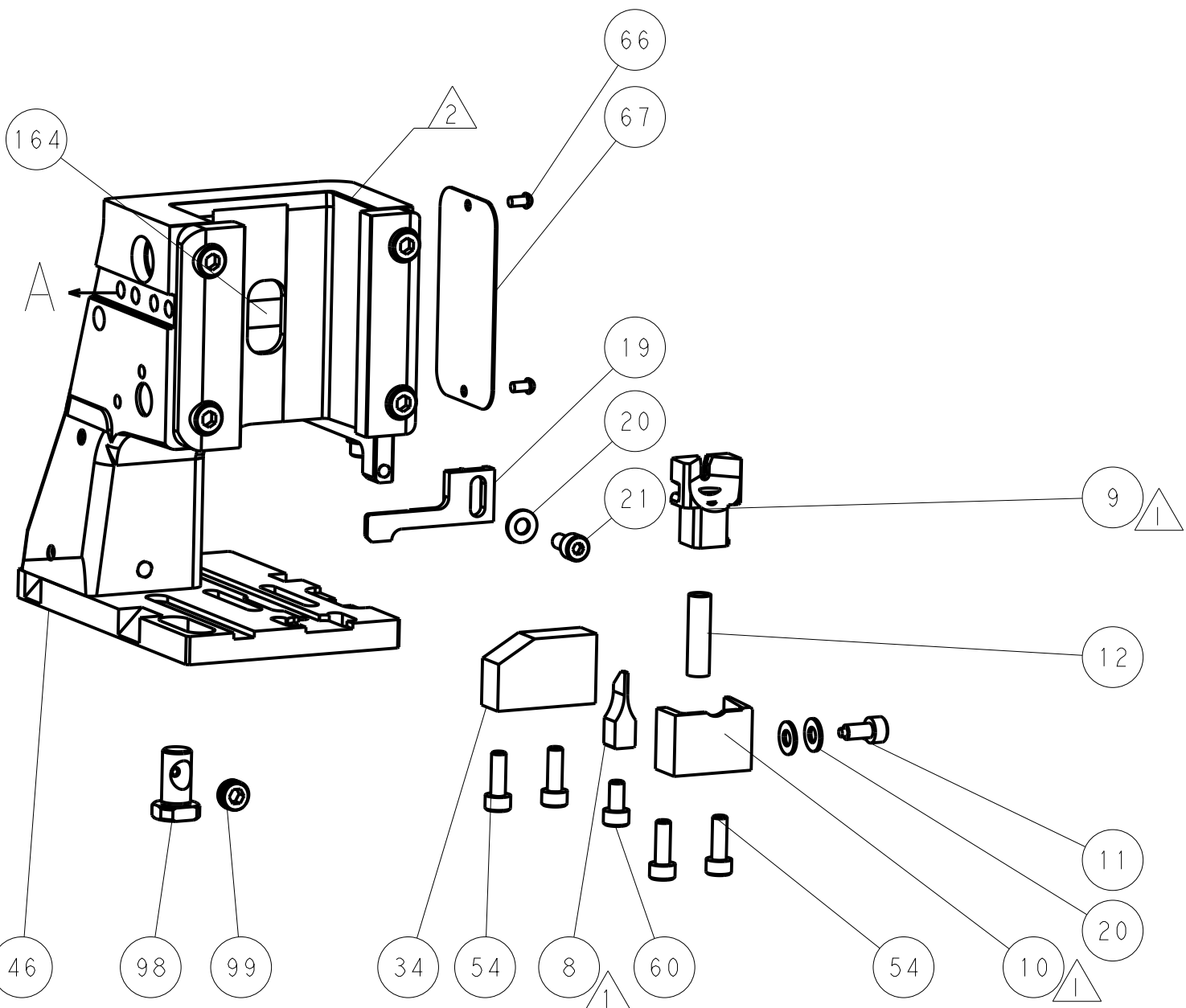
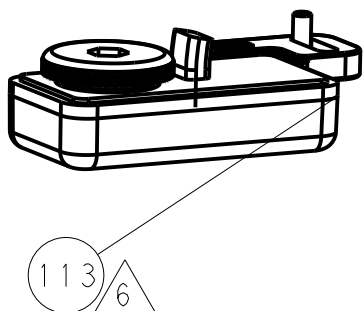
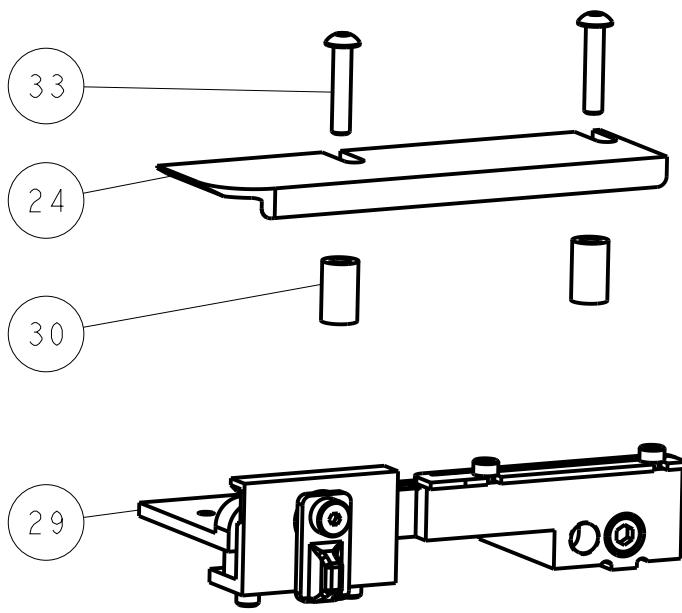
54



TERMINAL SUPPORT LOCATION



RAM SET-UP



FEED TRACK POSITION
GUIDE BY WIRE BARREL

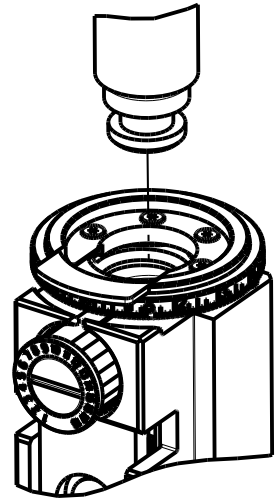
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE AND SHOULD NOT BE USED FOR CONSTRUCTION OR REPAIR WITHOUT THE APPROVAL OF THE DESIGNING ORGANIZATION. IT IS SUBJECT TO CHANGE AND SHOULD NOT BE USED FOR CONSTRUCTION OR REPAIR WITHOUT THE APPROVAL OF THE DESIGNING ORGANIZATION.		OWN BOB HIGMAN CHK G. BAILEY APVD G. BAILEY	23FEB2016 23FEB2016 23FEB2016	TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		NAME Ocean Side Feed Applicator
0 PLC 1 PLC 2 PLC 3 PLC 4 PLC ANGLES		± ± ± ± ± ±		SIZE A1
MATERIAL -		FINISH -		RESTRICTED TO -
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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20		20	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2836194-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2836194-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.04 mm [.041]	F
INSUL	-	-
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: MOLEX TERMINAL		MOLEX CRIMP SPECIFICATION	
TERMINAL NAME: FAKRA II JACK TERMINAL			
WIRE STRIP LENGTH 2.86-3.62 mm [.113-.143 IN]		INSULATION DIAMETER RANGE Ø3.05-3.18 mm [.120-.125 IN]	
TERMINAL APPLICATION SPECIFICATION AS-73597-042 Rev A2		5 - -	
TERMINALS APPLIED		4 6	
TE TERMINAL	MOLEX TERMINAL	TE TERMINAL	MOLEX TERMINAL
2113958-1	89538-0251		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
RG316 OR RG174	0.83+/-0.03 [.033+/- .001]	4.0



- 1 RECOMMENDED SPARE PARTS
- 2 REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- 3 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.
- 4 TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- 5 THIS APPLICATOR CANNOT RUN ON AUTOMATED EQUIPMENT.
- 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.

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	DWN	APVD
		-		SEE SHEET 1	-	-	-

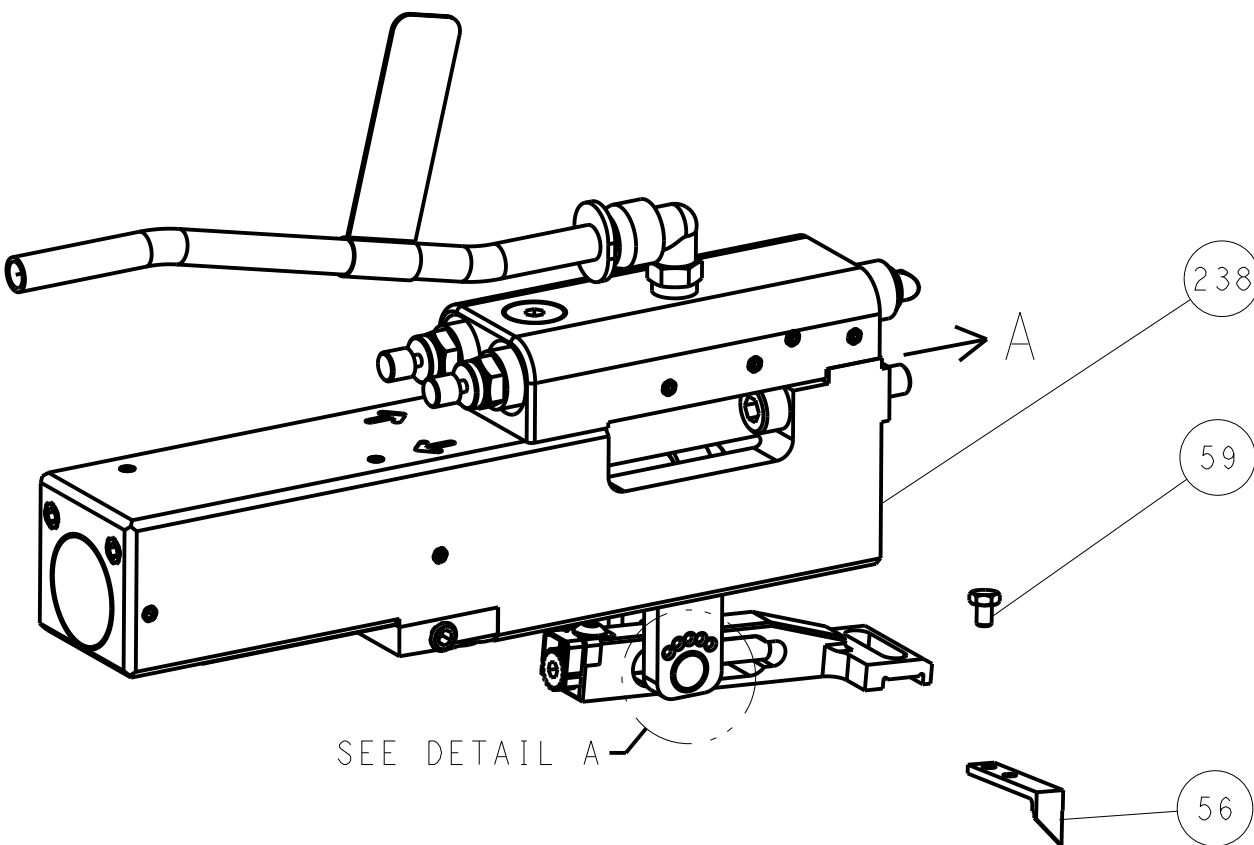
-	1	2844940-1	AIR FEED MODULE	238
-	REF	994970-2	COUNTER, MAGNETIC	164
-	1	2119641-2	FEED CAM, AIR FEED	151
-	1	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	144
-	4	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	143
-	1	1-1803583-0	APPLICATOR BASIC ASSEMBLY, SF	141
-	1	1803516-1	RAM ASSEMBLY, SF PACIFIC	140
-	1	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113
-	1	2844908-1	SCREW, LOCKING	99
-	1	2844907-1	POST, LOCKING	98
-	1	455888-6	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
-	2	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	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	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
-	1	1752356-1	SUPPORT, TERMINAL	34
-	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	455888-7	SPACER, CRIMPER	28
-	1	1320928-2	STRIP GUIDE	24
-	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
-	3	1-18028-2	WASHER, FLAT, REG M4	20
-	1	2119533-1	STRIPPER, SIDE FEED	19
-	1	3-22280-3	SPRING, COMPRESSION	12
-	1	356885-4	STOP, SHEAR	11
-	1	1803216-1	HOLDER, SHEAR	10
-	1	1338293-4	SHEAR, FLOATING	9
-	1	1803190-8	ANVIL, WIRE	8
-	1	1-240641-3	SPACER	7
-	-	-	-	6
-	1	1-2119757-6	DEPRESSOR, SHEAR	5
-	-	-	-	4
-	-	-	-	3
-	-	-	-	2
-	1	3-1803241-5	CRIMPER, WIRE F	1
-	77	-22	PART NO	ITEM NO

THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE. FOR CONTROL AND IDENTIFICATION PURPOSES, IT SHOULD BE CONTACTED FOR THE LATEST REVISION.				OWN: BOB HIGMAN 23FEB2016 CHK: G.BAILEY 23FEB2016 APVD: G.BAILEY 23FEB2016				STE TE Connectivity Harrisburg, PA 17105-3608			
DIMENSIONS:				TOLERANCES UNLESS OTHERWISE SPECIFIED:				NAME: Ocean Side Feed Applicator			
mm				0 PLC ±.001 1 PLC ±.001 2 PLC ±.001 3 PLC ±.001 4 PLC ±.001 ANGLES ±.001				SIZE: 00779			
MATERIAL: -				FINISH: -				WEIGHT: -			
Customer Accessible Production Drawing				SCALE: 1:2				SHEET: 3 OF 4			

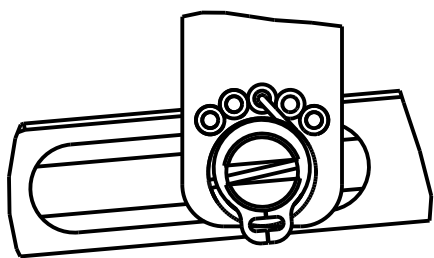
LOC		DIST		REVISIONS			
A	66	P	LTR	DESCRIPTION	DATE	DWN	APVD
		-		SEE SHEET 1	-	-	-

FEED TYPE

PNEUMATIC

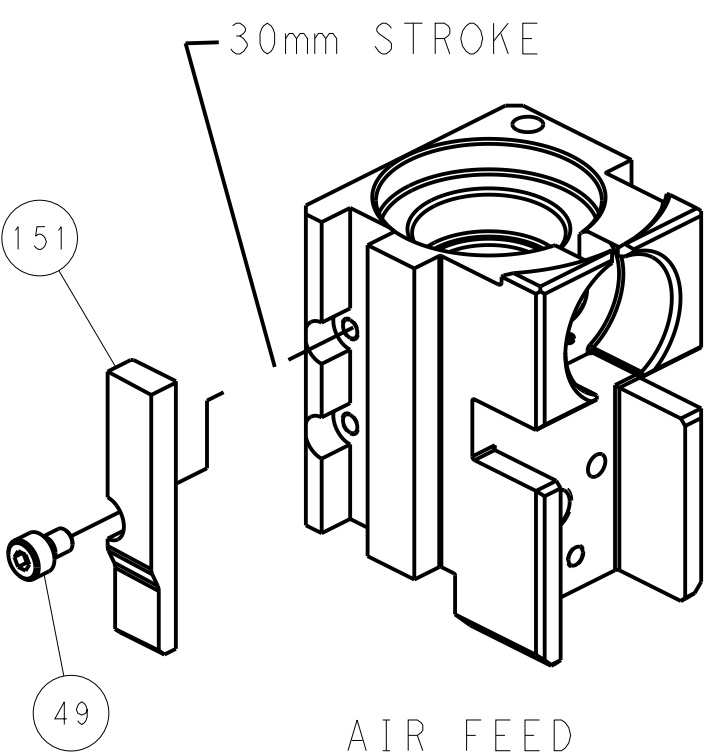


FEED SPRING SETTING POSITION
(SHOWN FROM REAR SIDE)

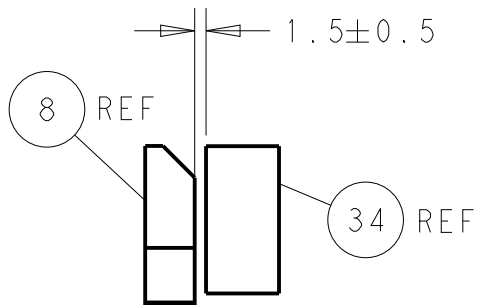
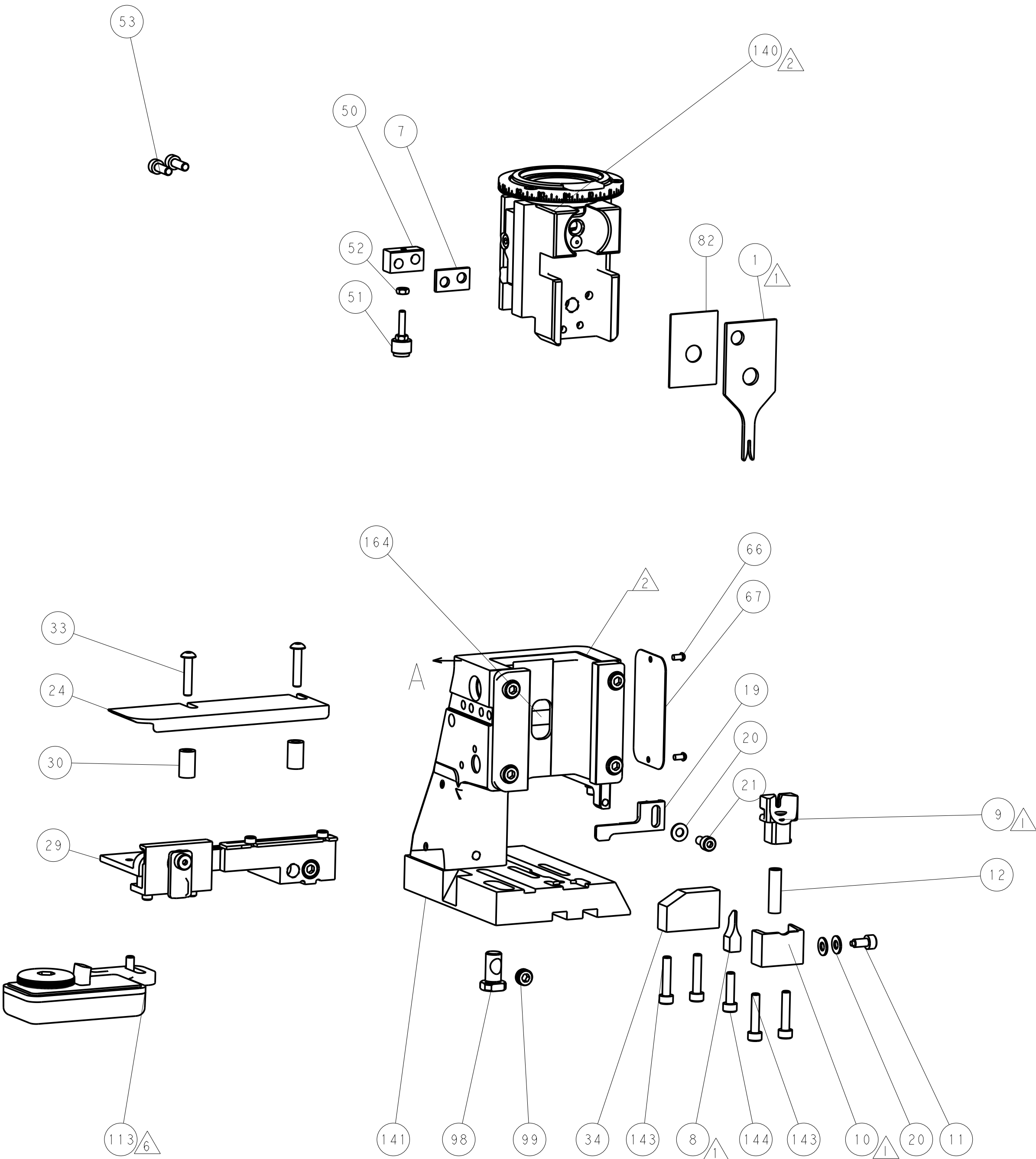


DETAIL A

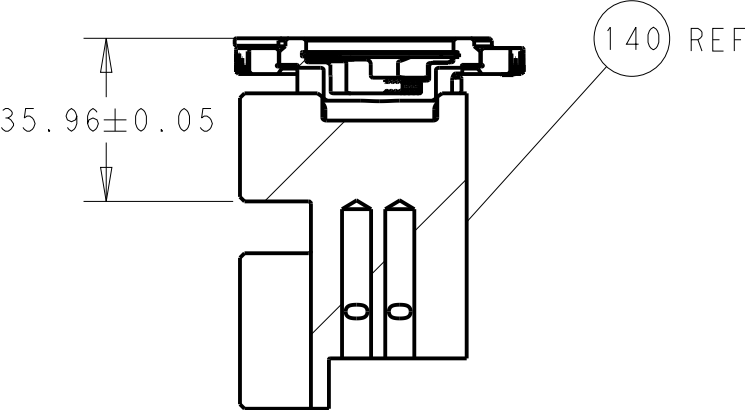
CAM POSITION



AIR FEED

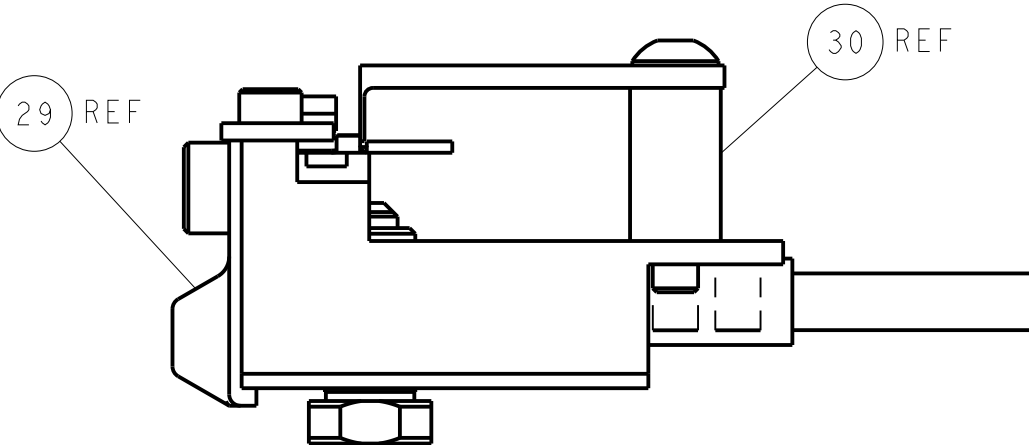


TERMINAL SUPPORT LOCATION



RAM SET-UP

ITEM 30 LOCATED AT
FRONT HOLES



FEED TRACK POSITION
GUIDE BY WIRE 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:		CHK: G. BAILEY 23FEB2016	NAME: Ocean Side Feed Applicator	
mm		APVD: G. BAILEY 23FEB2016	SIZE: A1	
TOLERANCES UNLESS OTHERWISE SPECIFIED:		PRODUCT SPEC	CAGE CODE: 00779	
0 PLC ±.1		APPLICATION SPEC	DRAWING NO: 2836194	
1 PLC ±.1		WEIGHT	Customer Accessible Production Drawing	
2 PLC ±.1		SCALE: 1:2	SHEET 4 OF 4	
3 PLC ±.1		RESTRICTED TO	REV B	
4 PLC ±.1				
ANGLES				
FINISH				

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[2836194-2](#)