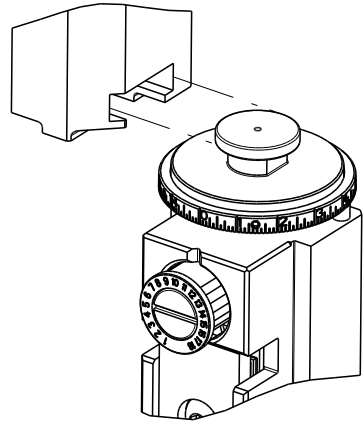
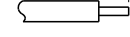


8		7	
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20		20	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2836399-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2836399-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2836399-1	B	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2836399-2	B	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2836399-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.07 mm [.042]	F
INSUL	1.78 mm [.070]	F
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: MINI AMP-IN CONTACT			
WIRE STRIP LENGTH 1.72-2.48 mm [.068-.098 IN]			INSULATION DIAMETER RANGE Ø1.02-1.52 mm [.040-.060 IN]
TERMINAL APPLICATION SPECIFICATION		114-1016	-
		-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
925819-2	925819-3		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.35mm2	0.99+/-0.05 [.039+/- .002]	8.3
22 AWG OR 0.32mm2	0.96+/-0.05 [.038+/- .002]	8.8
0.25mm2	0.90+/-0.05 [.035+/- .002]	9.4
24 AWG OR 0.20mm2	0.86+/-0.05 [.034+/- .002]	9.8
26 AWG OR 0.14mm2	0.81+/-0.05 [.032+/- .002]	10.4
0.12mm2	0.79+/-0.05 [.031+/- .002]	10.0



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

D

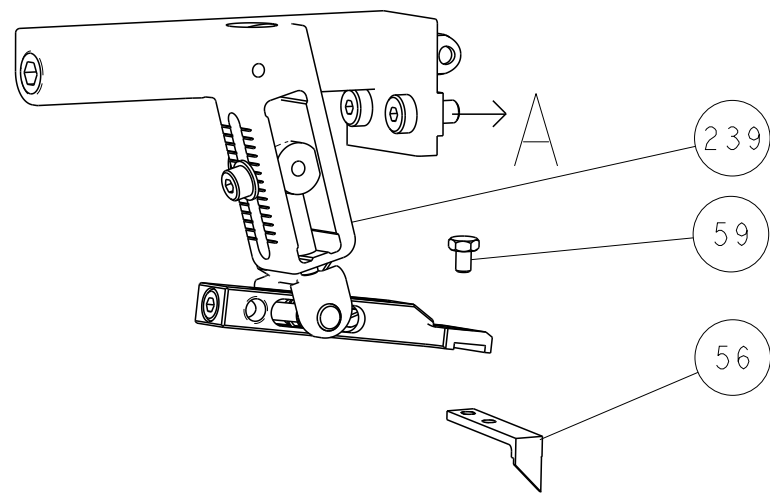
-	1	-	1	-	2119640-1	PUSH ROD, AIR FEED	250
-	1	-	1	-	1803259-1	BUSHING, FLANGED	249
-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248
-	1	1	1	1	2119082-5	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	1	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
-	-	1	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	1	-	1	-	2063440-1	AIR FEED MODULE	238
-	2	-	2	-	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172
-	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	1	-	1	-	240638-1	SPRING, FEED FINGER	163
-	1	-	1	-	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854	137
-	1	-	1	-	2119799-1	HOLDER, FEED FINGER, AF	136
-	1	1	1	1	2844908-1	SCREW, LOCKING	99
-	1	1	1	1	2844907-1	POST, LOCKING	98
-	1	1	1	1	455888-6	SPACER, CRIMPER	82
-	1	1	1	1	1803607-1	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
-	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	1338685-1	PAWL, FEED	56
-	4	4	4	4	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	54
-	2	2	2	2	1-2168083-4	SCR, SKT HD CAP, RoHS, M4 X 5	53
-	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	2-1752356-7	SUPPORT, TERMINAL	34
-	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	2	2	2-2844962-4	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29
-	1	1	1	1	455888-3	SPACER, CRIMPER	28
-	1	1	1	1	1320928-2	STRIP GUIDE	24
-	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	2119533-3	STRIPPER, SIDE FEED	19
-	1	1	1	1	2-690518-6	HOLD DOWN, TERMINAL	18
-	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	1803095-1	FLOATING SHEAR, FRONT -	9
-	1	2	2	1	1-1633916-5	ANVIL, COMBINATION	8
-	-	-	-	-	-	-	7
-	-	-	-	-	-	-	6
-	1	1	1	1	2119757-8	DEPRESSOR, SHEAR	5
-	1	1	1	1	238011-7	BLOCK, CRIMPER SPACER	4
-	1	2	2	1	4-1633961-8	CRIMPER, INSULATION F PREMIUM	3
-	1	1	1	1	455888-2	SPACER, CRIMPER	2
-	1	2	2	1	1-456401-7	CRIMPER, WIRE .042 F PREMIUM	1
-	77	-72	-71	-2	-1	PART NO	ITEM NO
-	-	-	-	-	-	DESCRIPTION	

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DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH		NAME Ocean Side Feed Applicator	
MATERIAL		WEIGHT		SIZE CASE CODE DRAWING NO A 00779 C=2836399	
Customer Accessible Production Drawing		SCALE 1:2		SHEET 1 OF 4 REV B	

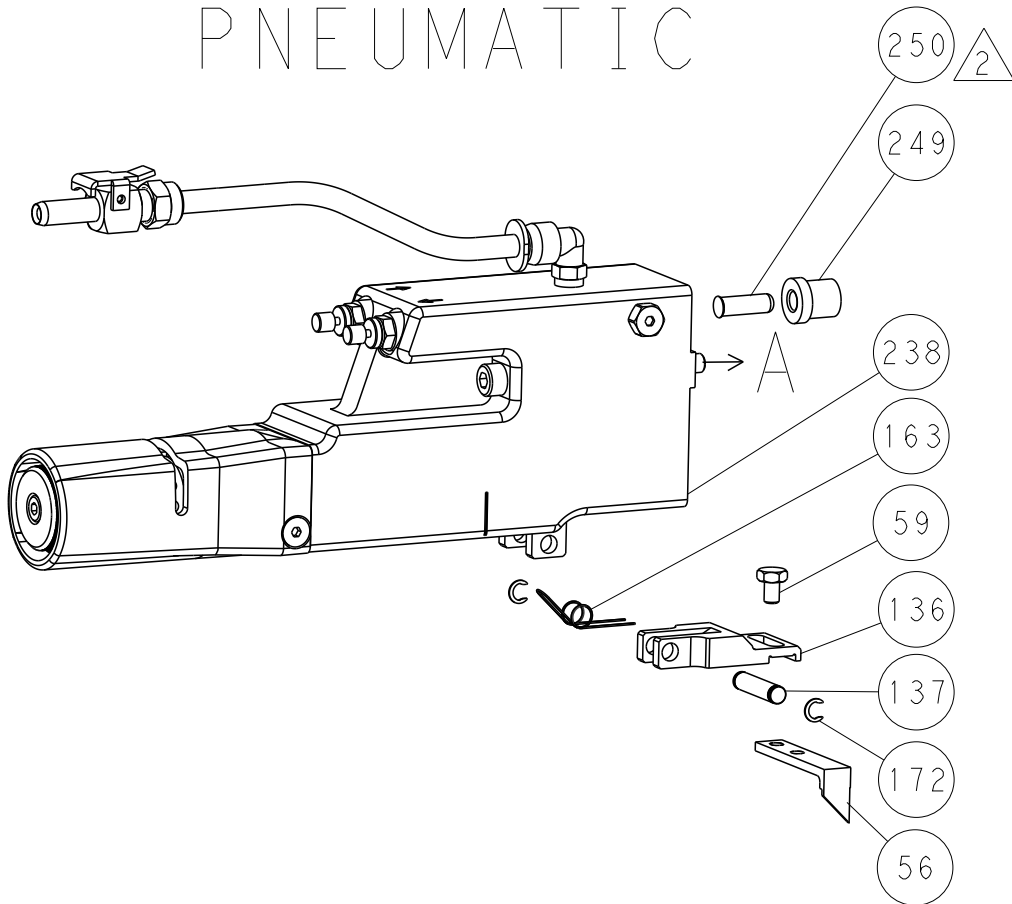
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

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

FEED TYPE
MECHANICAL

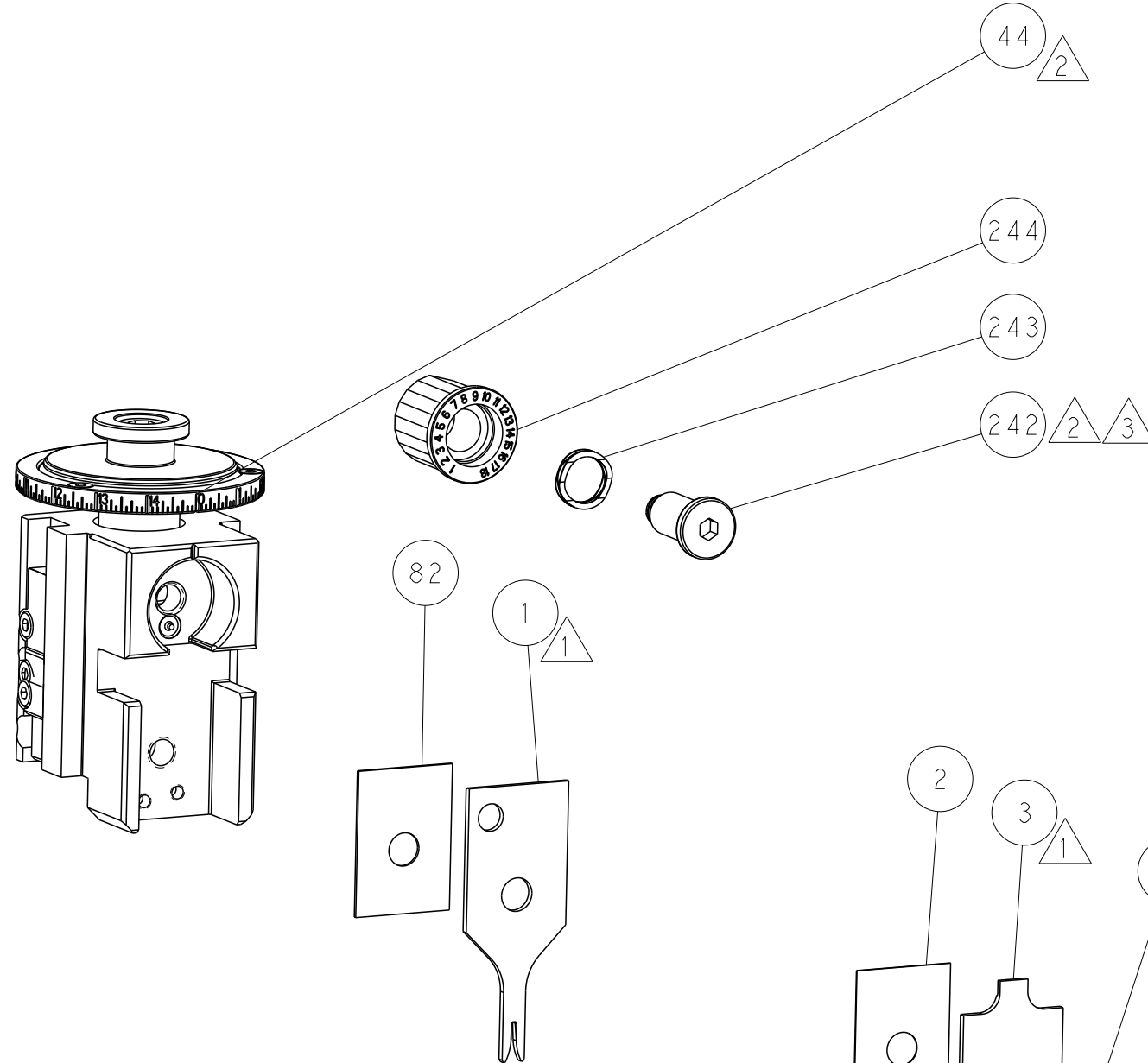


PNEUMATIC



53

18

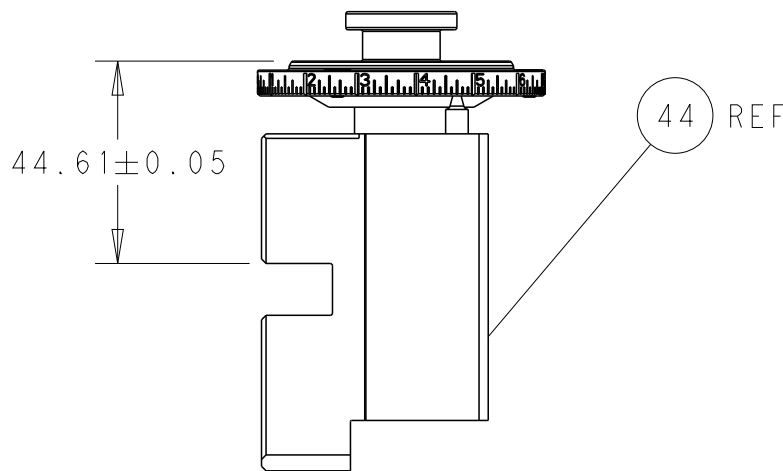


8 REF

34 REF

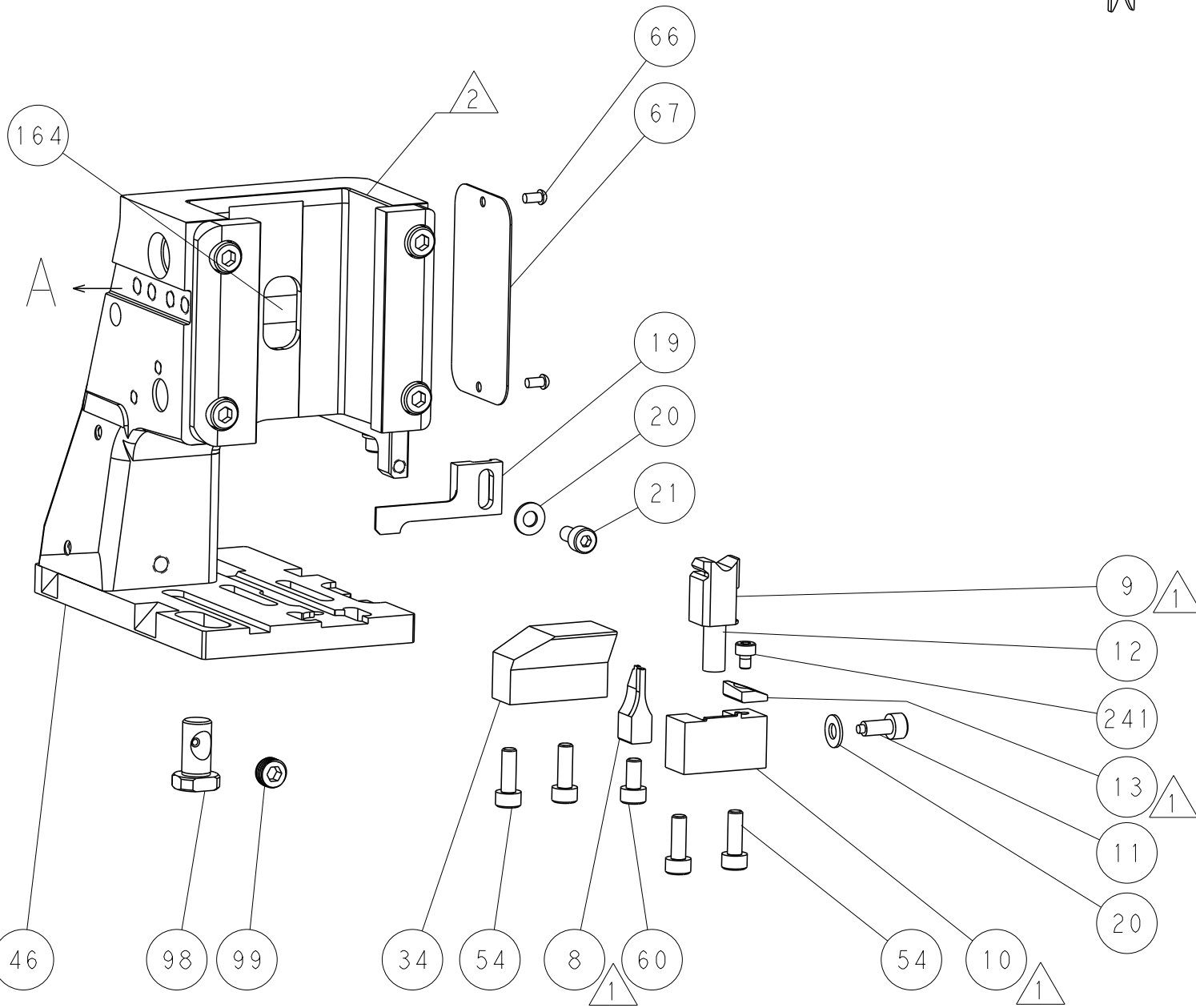
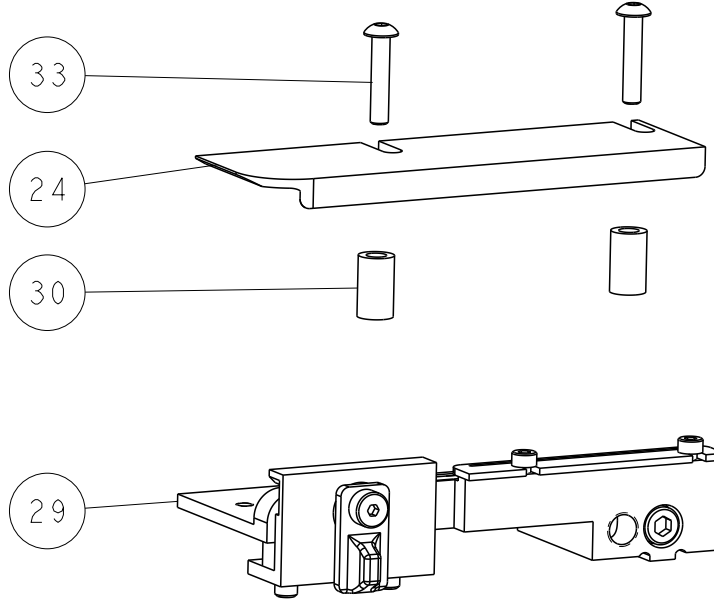
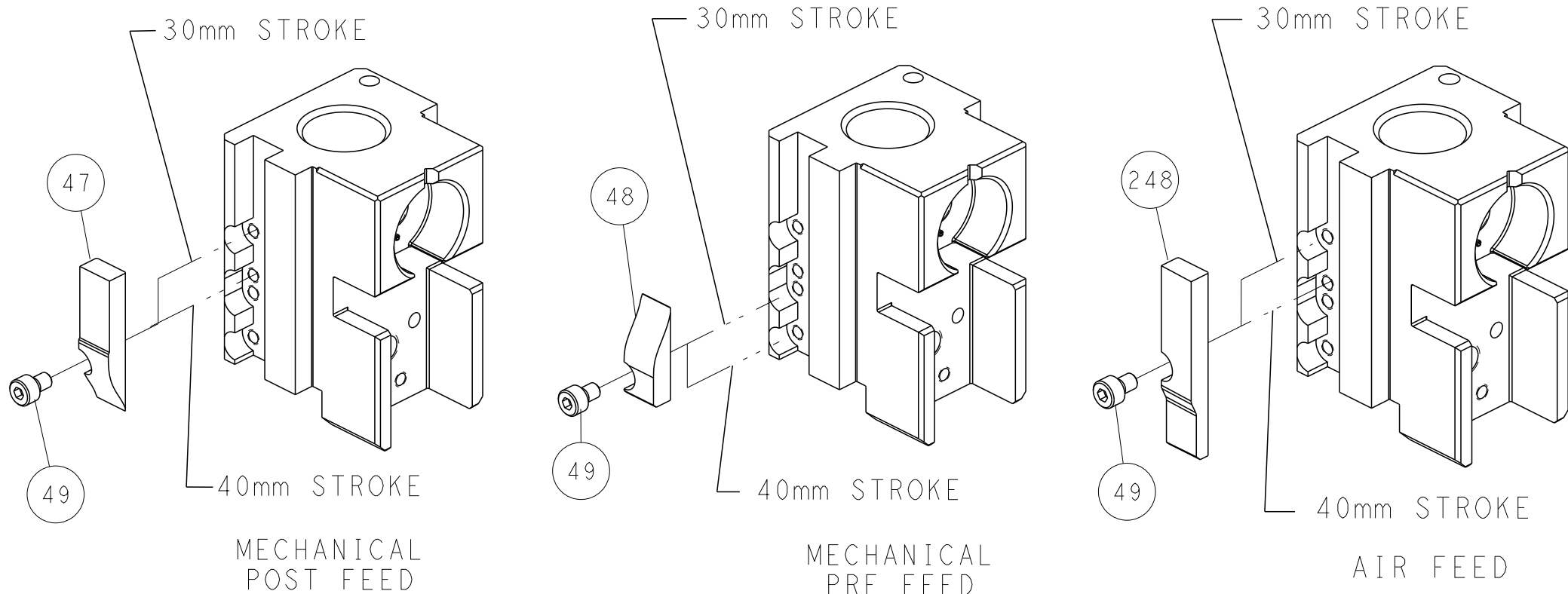
3.0±0.5

TERMINAL SUPPORT LOCATION

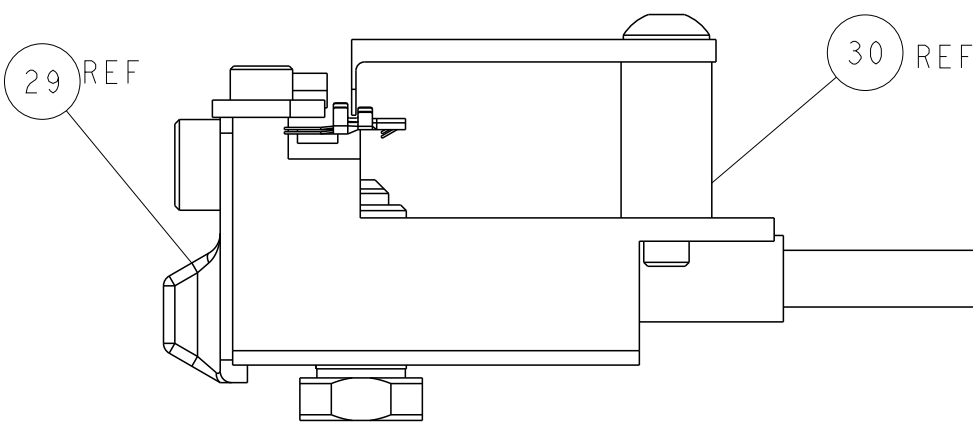


RAM SET-UP

CAM POSITIONS

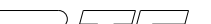
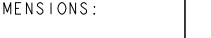


ITEM 30 LOCATED AT
FRONT HOLES



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)

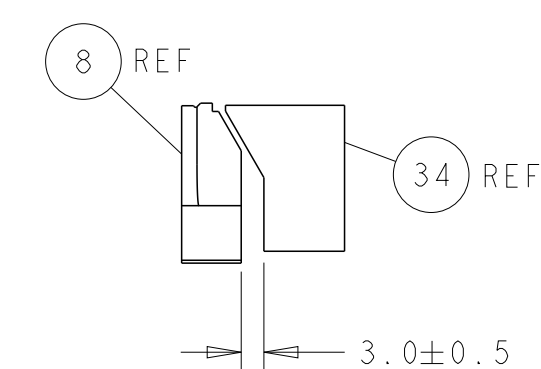
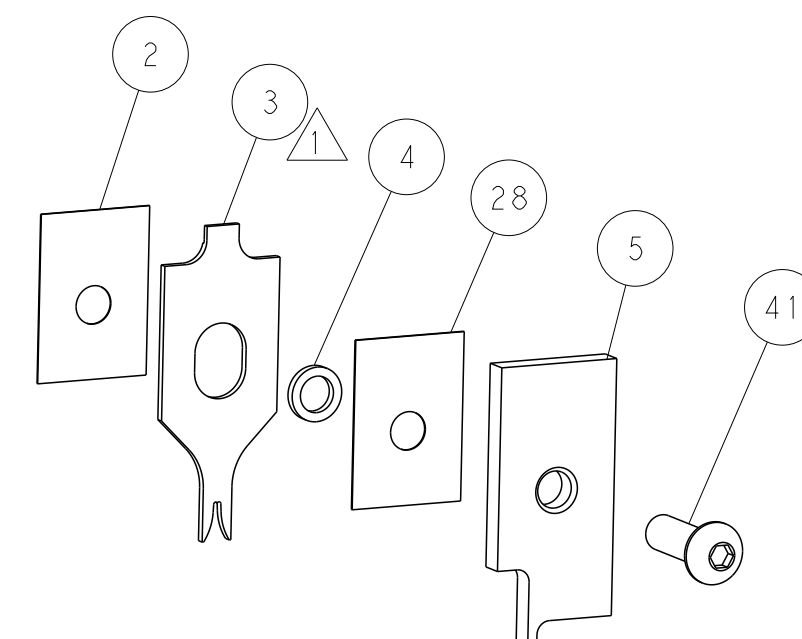
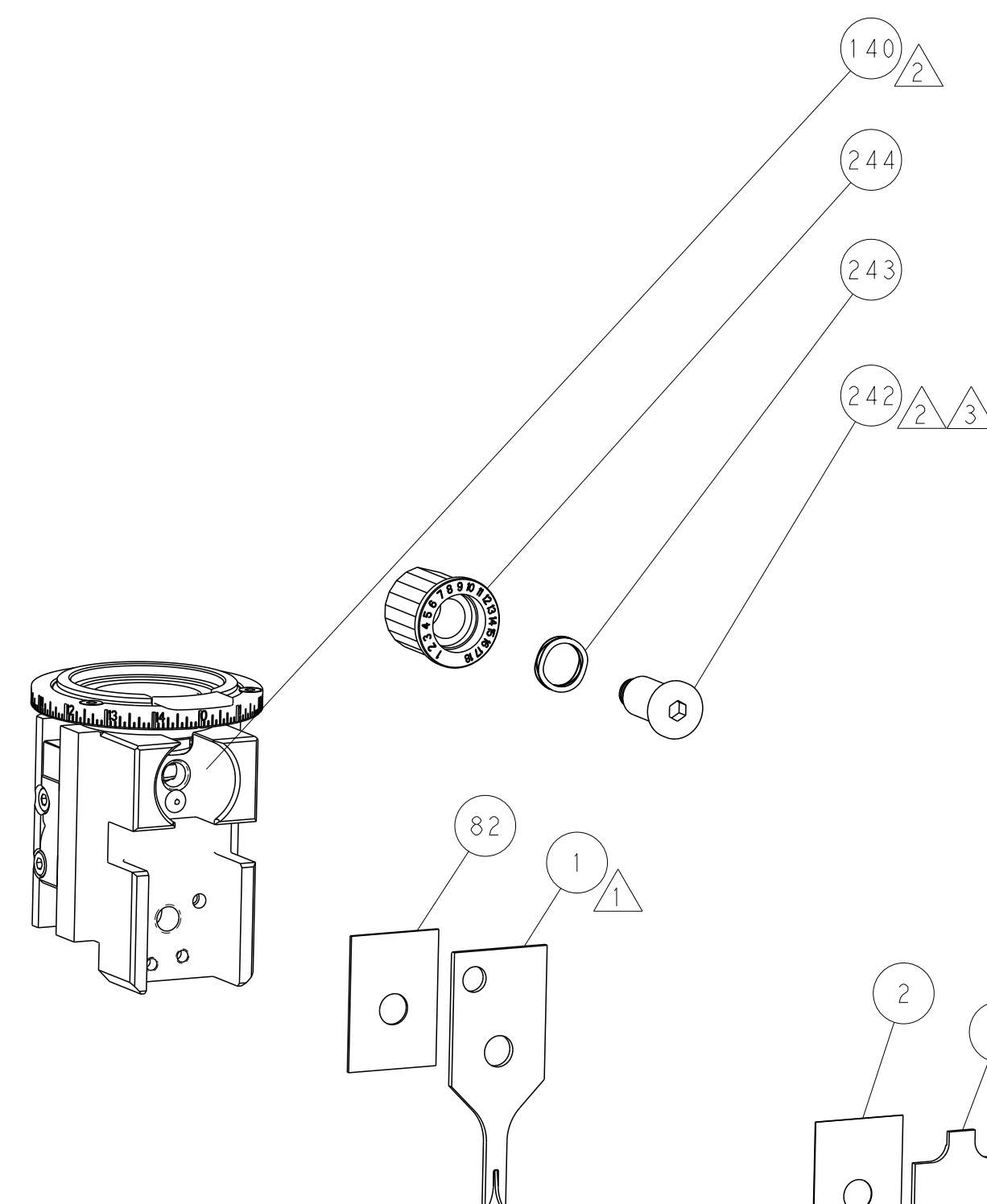
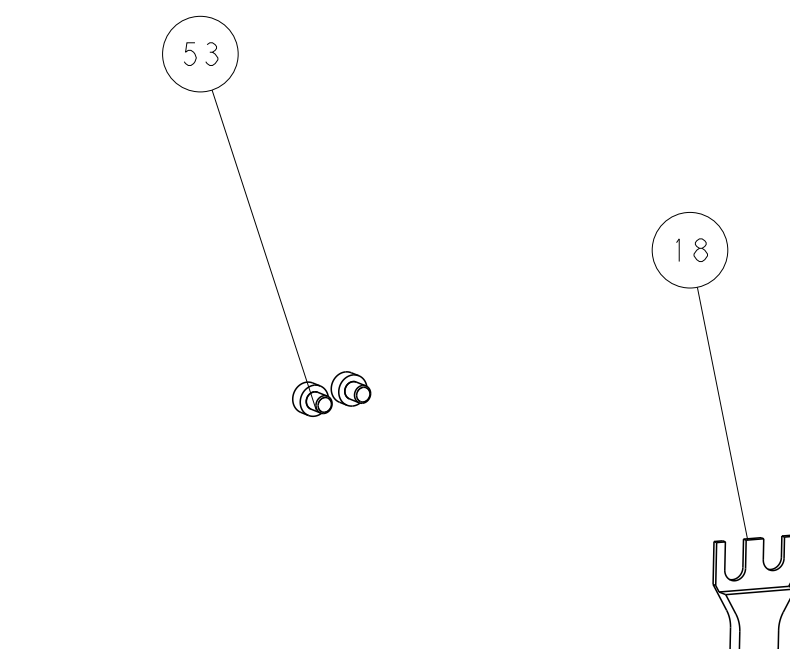
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DIMENSIONS: mm 					CHK	L. ZHANG	14JUL2016												
					APVD	L. ZHANG	14JUL2016												
					TOLERANCES UNLESS OTHERWISE SPECIFIED:							PRODUCT SPEC							
					APPLICATION SPEC			Ocean Side Feed Applicator -											
					SIZE							CAGE CODE	DRAWING NO	RESTRICTED TO					
					WEIGHT							A1	00779		C=2836399				
MATERIAL					Customer Accessible Production Drawing					SCALE	1:2	SHEET	2	of	4	REV	B		
-					-					-					-				

SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

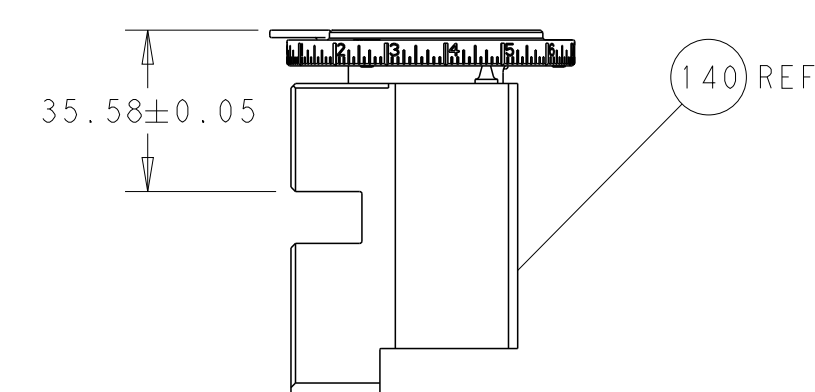
PNEUMATIC

Diagram illustrating the assembly of a pneumatic cylinder. The main components are shown in an exploded view, with callouts indicating the sequence of assembly:

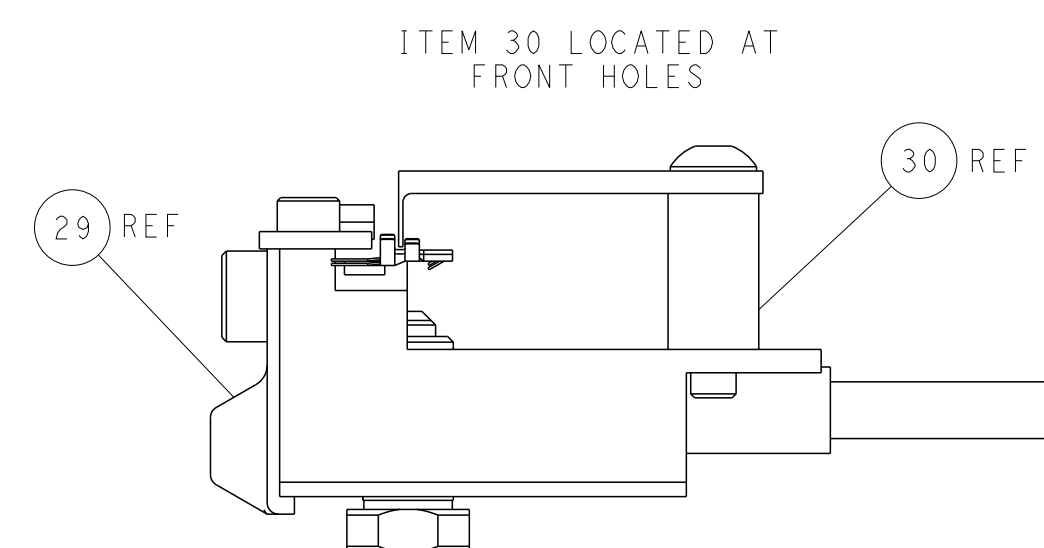
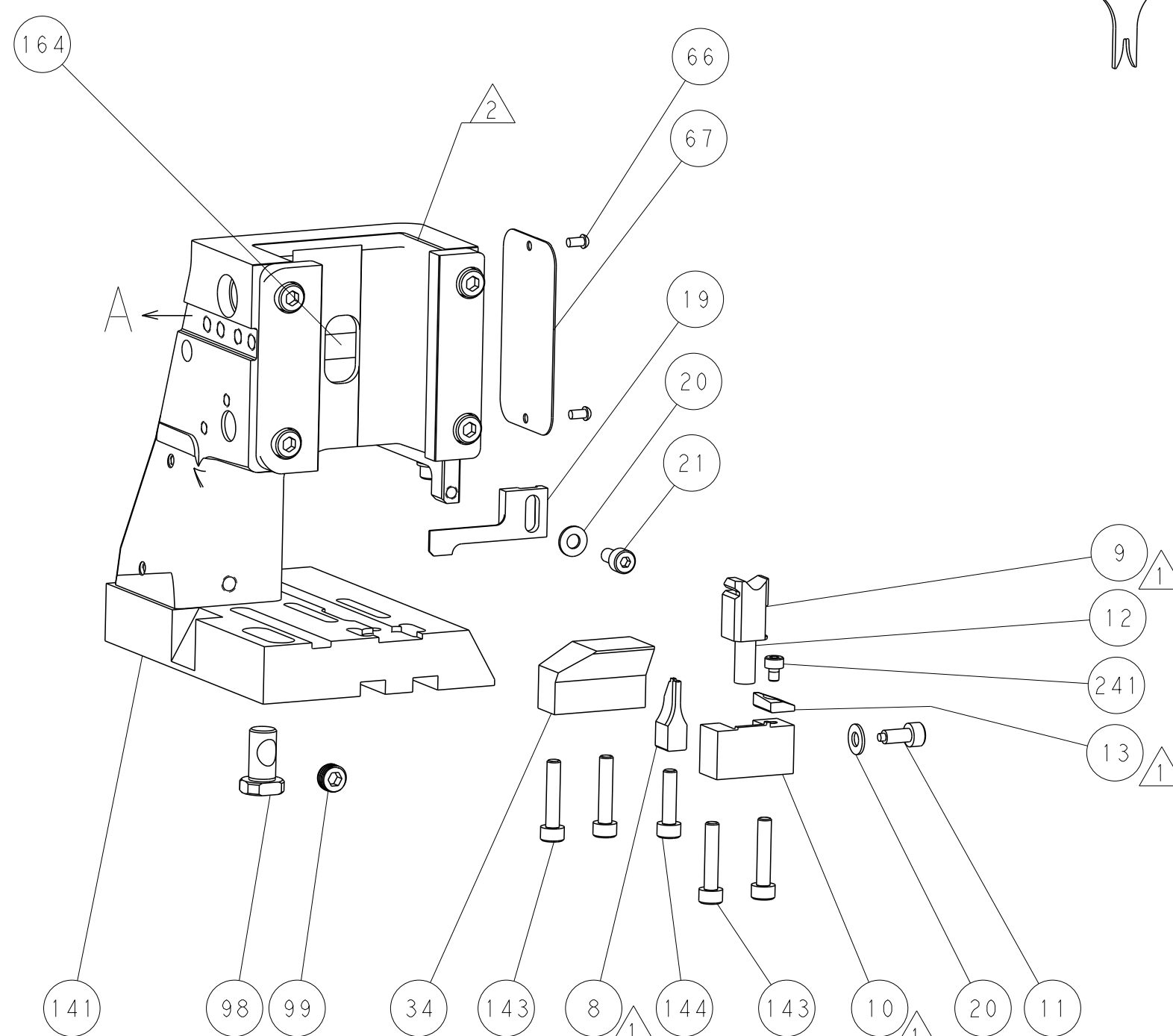
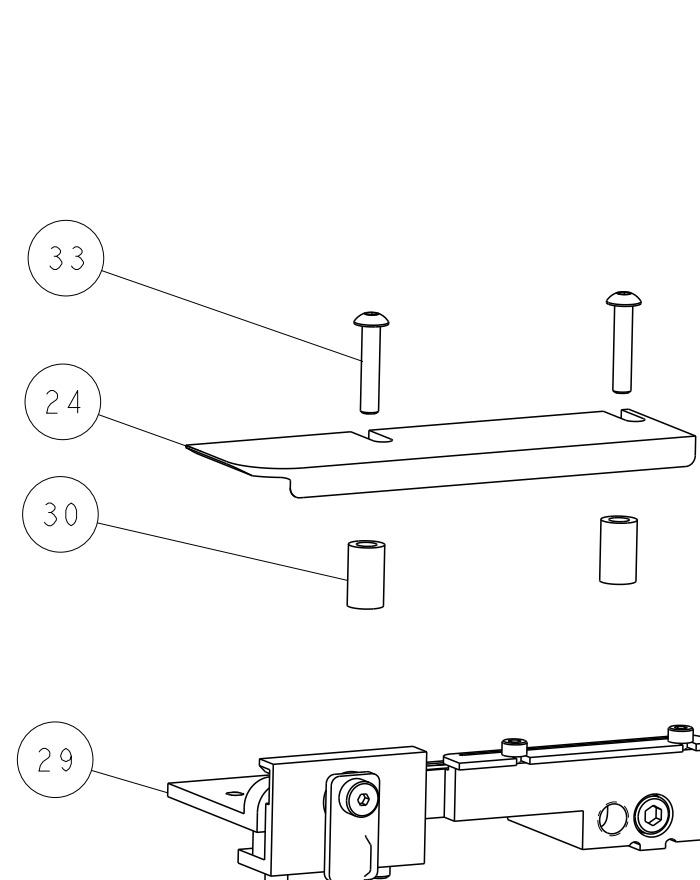
- 250: End cap
- 249: End cap seal
- 238: End cap seal
- 163: Piston rod
- 59: Piston rod seal
- 136: Piston rod seal
- 137: Piston rod seal
- 172: Piston rod seal
- 56: Piston rod seal
- A: Piston rod seal
- C: Piston rod seal



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)

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DIMENSIONS: mm 			CHK L. ZHANG 14JUL2016																											
			TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±			APVD L. ZHANG 14JUL2016		NAME Ocean Side Feed Applicator																						
MATERIAL -			FINISH -		PRODUCT SPEC		SIZE			CAGE CODE		DRAWING NO		RESTRICTED TO																
			APPLICATION SPEC		WEIGHT -		A1		00779		C=2836399		-																	
Customer Accessible Production Drawing															SCALE		1-2		SHEET		4		OF		4		REV		B	

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