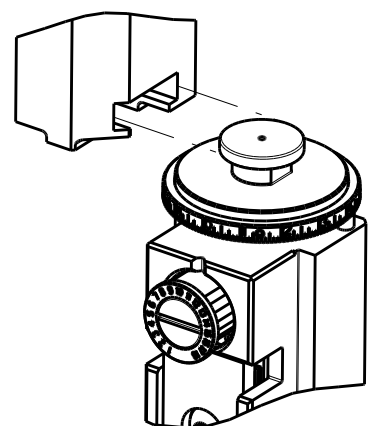


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8		20	
(C) COPYRIGHT 20 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.			
PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2836776-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2836776-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2836776-1	C	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2836776-2	C	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2836776-7	A	CRIMP TOOLING KIT	-



ATLANTIC VERSION TERMINATOR
INTERFACE ADAPTER

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.80 mm [.071]	F
INSUL	4.06 mm [.160]	O
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: G&H(LEAR) TERMINAL LEAR CRIMP SPECIFICATION		
TERMINAL NAME: MDK3 PLUS TERMINAL		
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE
4.41-5.17 mm [.173-.203 IN]		Ø2.00-2.70 mm [.079-.106 IN]
TERMINAL APPLICATION SPECIFICATION	26628 Rev 2	-
	-	-

TERMINALS APPLIED 				SEAL INSULATION DIAMETER RANGE
TE TERMINAL	G&H(LEAR) TERMINAL	TE SEAL	G&H(LEAR) SEAL	
1949701-1	26628.331.179	1572316-1	16695.627.642	1.2-2.1mm
1949701-2	26402.213.178	1572316-2	16695.627.619	1.2-2.1mm
1949701-3	26628.331.710	1572316-5	16276.627.642	1.2-2.1mm
1949701-4	26402.221.702	1949095-1	16694.627.626	1.9-3.0mm

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING 
1.00mm2		1.30+/-0.05 [0.051+/-0.002]		6.7
0.75mm2		1.25+/-0.05 [0.049+/-0.002]		7.3
0.50mm2		1.20+/-0.05 [0.047+/-0.002]		7.8

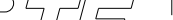
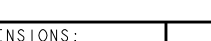


1. RECOMMENDED SPARE PARTS
2. REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
3. APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242.
4. CRIMP HEIGHT REFERENCE SETTING WAS THE SETTING USED WHEN THE APPLICATOR WAS QUALIFIED AT THE FACTORY. ADJUSTMENT MAY BE NECESSARY WHEN RUNNING APPLICATOR IN THE FIELD.
5. APPLY TORQ-SEAL IN ALLEN SOCKET TO FILL HOLE AFTER FLAT HD HAS BEEN ADJUSTED TO CORRECT HEIGHT AT QUALIFICATION. APPLY #1-23419-5 LOC-TITE TO THREADS.
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.

2		1						
LOC	DIST	REVISIONS						
A	66	P	LTR	DESCRIPTION		DATE	DWN	APVD
			A	RELEASED		20JUNE2017	TB	CT
			B	ECR-20-015411		29OCT2020	FJ	TE
			C	ECR-20-018078		24DEC2020	FZ	RK

3	-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248
	-	1	1	1	1	2119082-2	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
6	-	-	1	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
	-	1	-	1	-	2844940-1	AIR FEED MODULE	238
	-	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
	-	1	1	1	1	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113
	-	1	1	1	1	2844908-1	SCREW, LOCKING	99
5	-	1	1	1	1	2844907-1	POST, LOCKING	98
	-	1	1	1	1	455888-4	SPACER, CRIMPER	82
	-	1	1	1	1	1803607-3	DOCUMENTATION PACKAGE	71
	-	1	1	1	1	2119791-9	DEPRESSOR, WIRE	70
	-	1	1	1	1	2119740-1	TAG, IDENTIFICATION	67
1	-	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	985575-3	SCR, FLT SKT HD CAP M3 X 10.0	57
	-	1	1	1	1	1338685-1	PAWL, FEED	56
1	-	4	4	4	4	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	54
	-	2	2	2	2	2-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 14	53
	-	1	1	1	1	5018030-1	NUT, HEX, REG, RoHS, M3	52
	-	1	1	1	1	811242-5	BUMPER, HOLD DOWN	51
	-	1	1	1	1	690753-2	SPACER, TONKER	50
1	-	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	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
	-	1	1	1	1	3-1752356-4	SUPPORT, TERMINAL	34
	-	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
	-	2	2	2	2	2-2844962-8	SPACER, CYLINDRICAL, STRIP GUIDE	30
	-	1	1	1	1	2844992-4	ASSEMBLY, STRIP GUIDE	29
1	-	1	1	1	1	455888-3	SPACER, CRIMPER	28
	-	1	1	1	1	240792-1	DRAG, TERMINAL	25
	-	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	1	2119533-1	STRIPPER, SIDE FEED	19
	-	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	1	318707-1	FLOATING SHEAR, FRONT	9
	1	2	2	1	1	8-1803252-3	ANVIL, COMBINATION	8
	-	1	1	1	1	240641-2	SPACER	7
	-	-	-	-	-	-	-	6
	-	1	1	1	1	2119781-2	DEPRESSOR, SHEAR	5
1	-	1	1	1	1	3-238011-1	BLOCK, CRIMPER SPACER	4
	1	2	2	1	1	1-1803248-0	CRIMPER, INSULATION O PREMIUM	3
	-	1	1	1	1	455888-3	SPACER, CRIMPER	2
	1	2	2	1	1	2-1803470-0	CRIMPER, WIRE F	1
	-	77	-72	71	-2	-1	PART NO	DESCRIPTION

THIS DRAWING IS A COMPUTER GENERATED DRAWING. NO DIMENSIONAL INFORMATION SHOULD BE OBTAINED FROM THIS DRAWING FOR CONSTRUCTION PURPOSES. DIMENSIONS SHOULD BE OBTAINED FROM THE LATEST REVISION.										DWG C_K HUANG		ZSMAY2017		 TE Connectivity Harrisburg, PA 17105-3608			
DIMENSIONS: mm				TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±				DWG C_K HUANG		ZSMAY2017		NAME Ocean Side Feed Applicator					
								APVD C_K HUANG		ZSMAY2017		PRODUCT SPEC - APPLICATION SPEC -					
MATERIAL -				FINISH -				WEIGHT -		SIZE A		CASE CODE 00779		DRAWING NO C=2836776		RESTRICTED TO -	
Customer Accessible Production Drawing										SCALE 1:2		SHEET 1 OF 4		REV C			

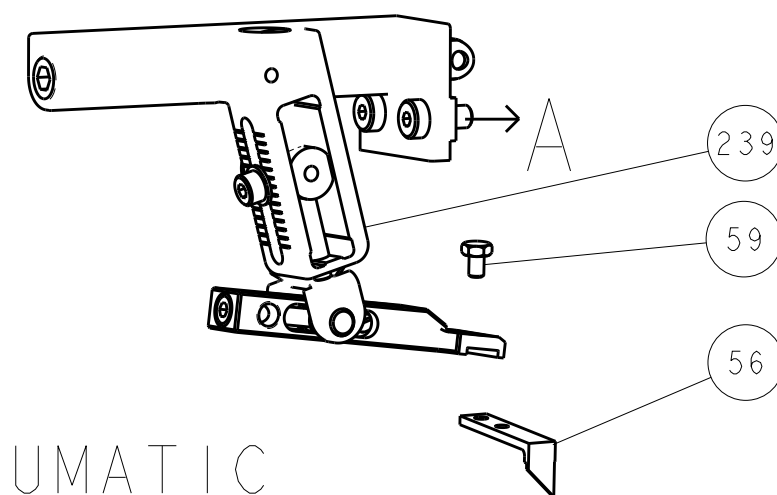
SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

AMP 4805 REV 31MAR2000

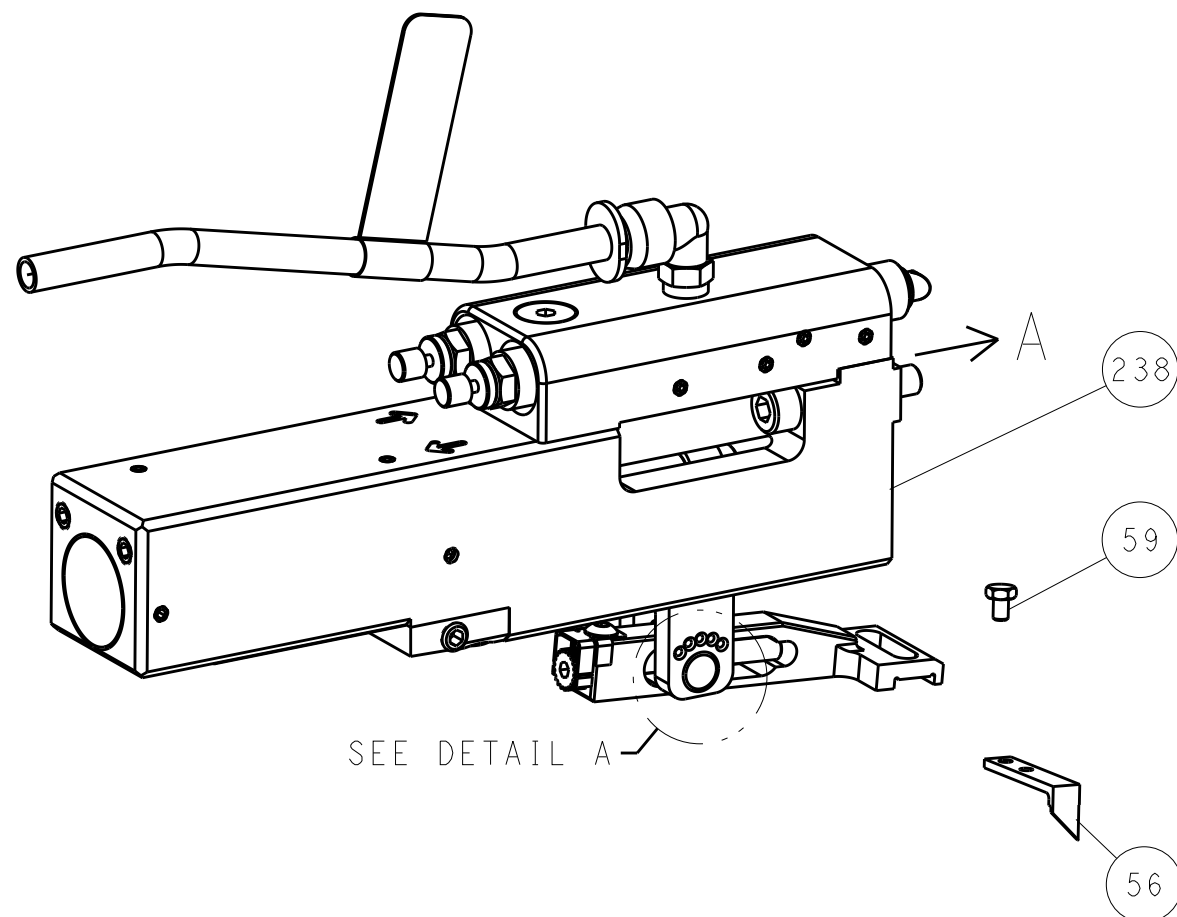
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

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

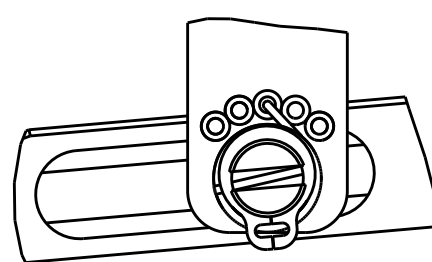
FEED TYPE MECHANICAL



PNEUMATIC

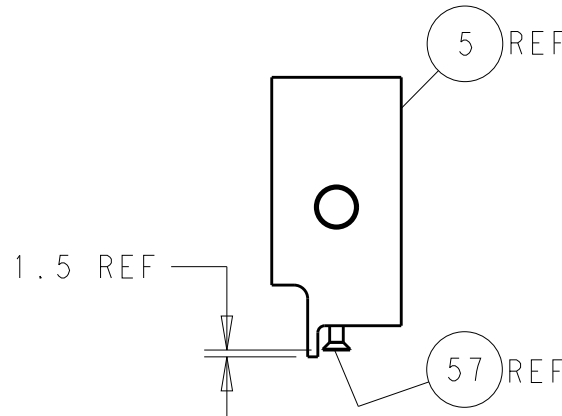
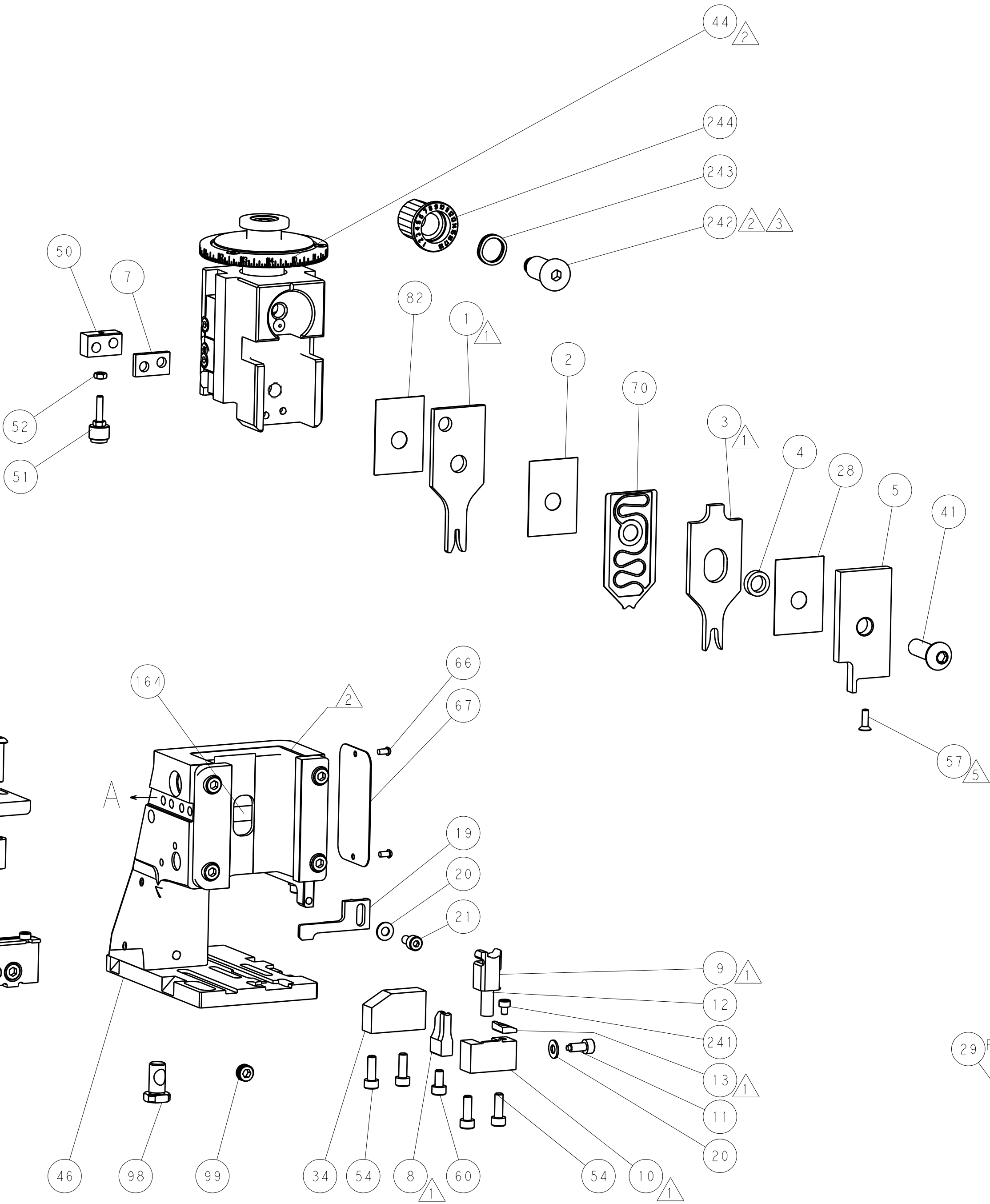
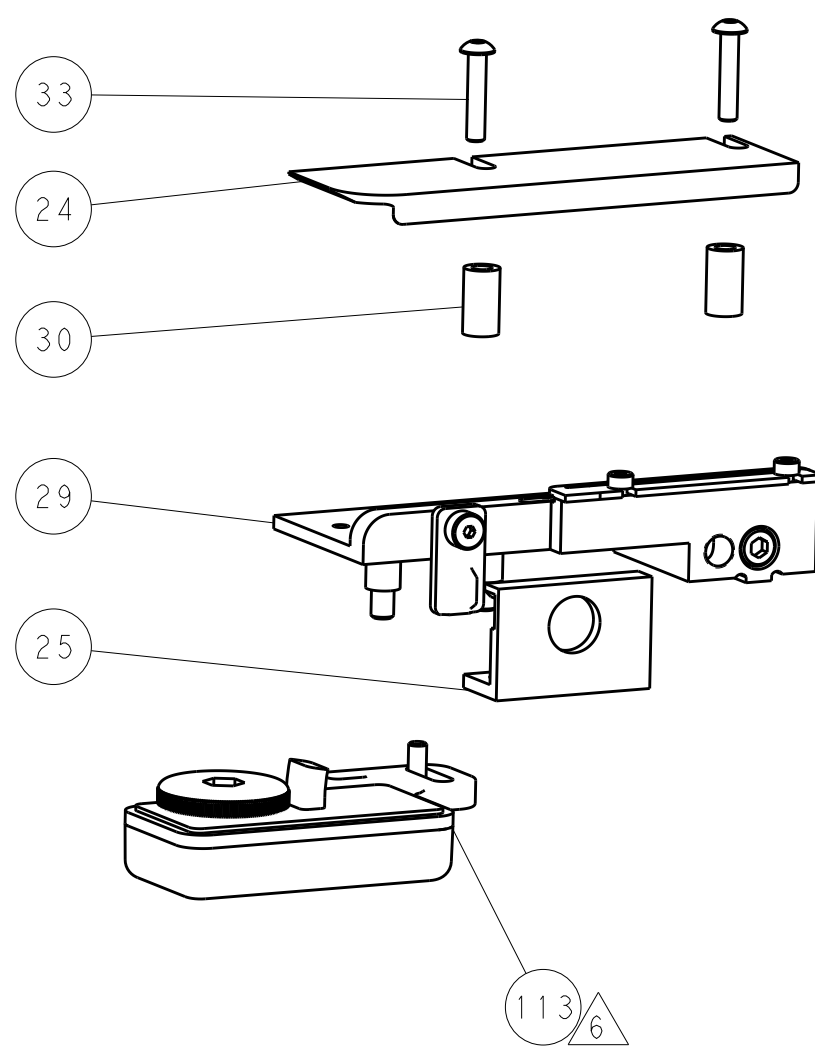
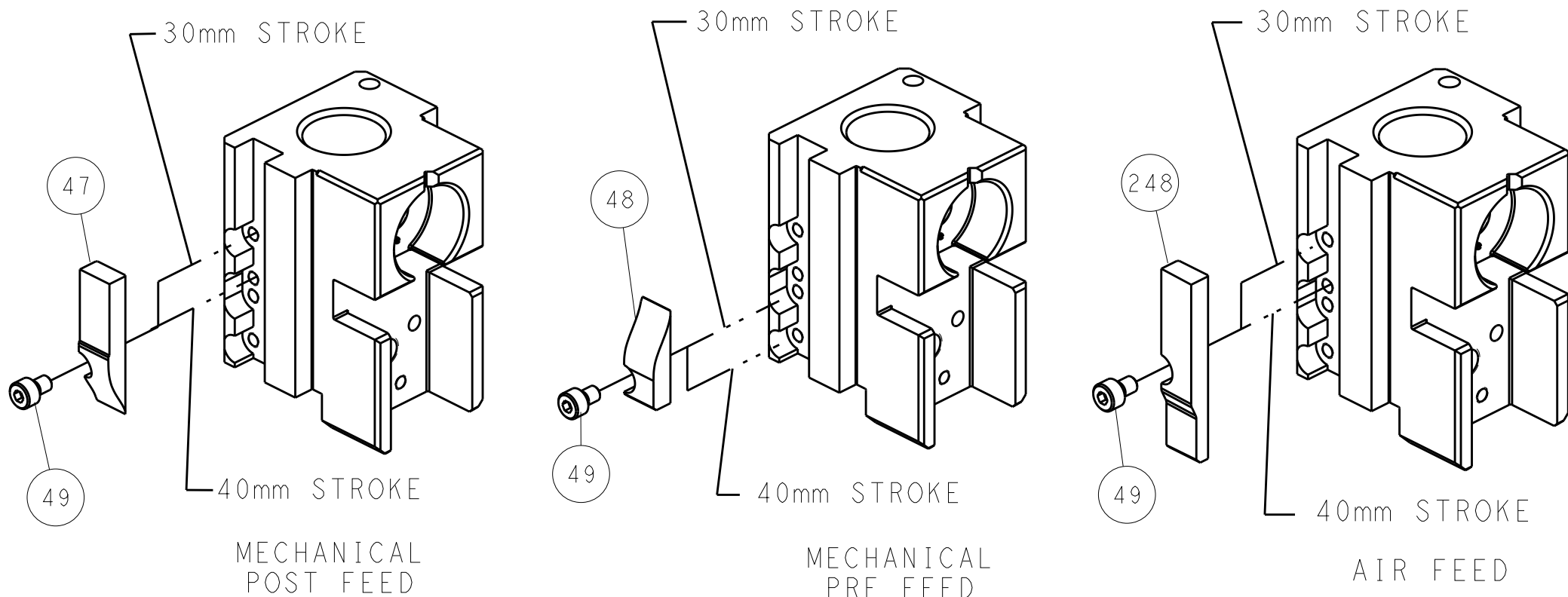


FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)

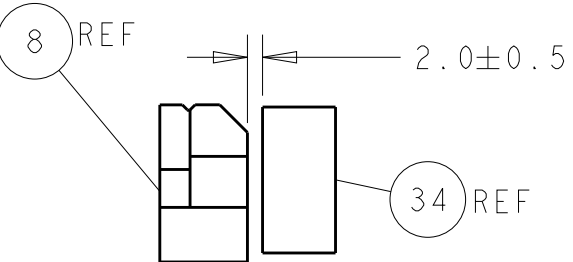


DETAIL A

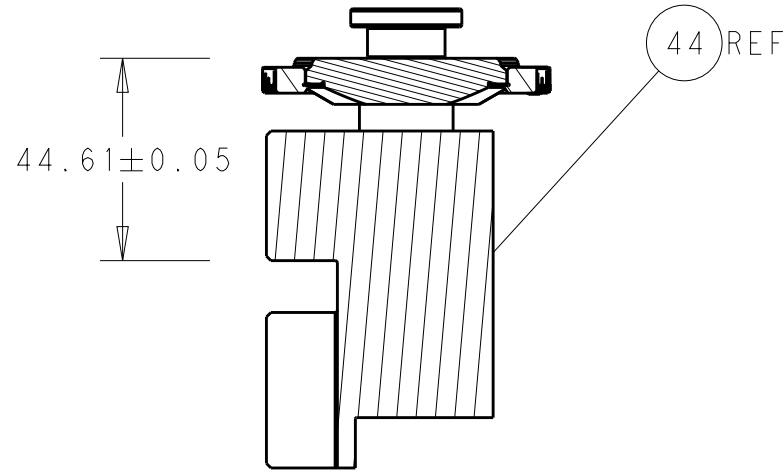
CAM POSITIONS



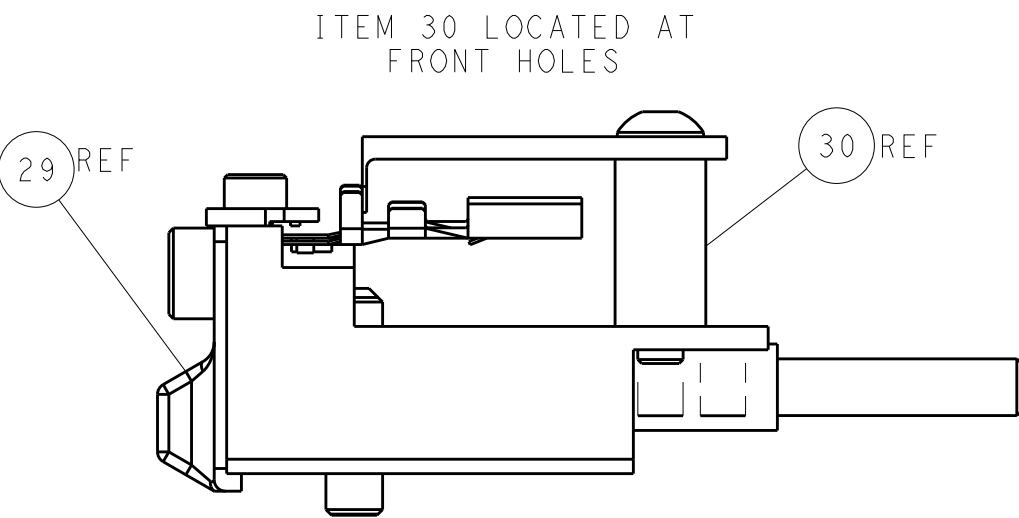
SHEAR DEPRESSOR DETAIL



TERMINAL SUPPORT LOCATION



RAM SET-UP



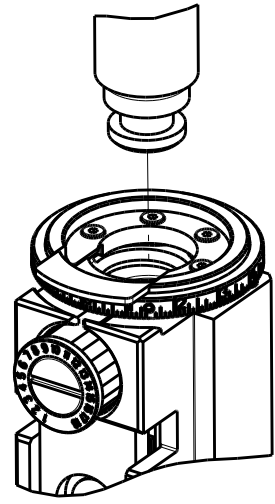
FEED TRACK POSITION
GUIDE BY INSULATION BARREL

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

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN		25MAY2017		TE Connectivity	
mm		0 PLC ±		CHK		25MAY2017		Harrisburg, PA 17105-3608	
		1 PLC ±		CHK		25MAY2017		NAME	
		2 PLC ±		CHK		25MAY2017		Ocean Side Feed	
		3 PLC ±		CHK		25MAY2017		Applicator	
		4 PLC ±		CHK		25MAY2017		-	
		5 PLC ±		CHK		25MAY2017		SIZE	
		6 PLC ±		CHK		25MAY2017		CAGE CODE	
		7 PLC ±		CHK		25MAY2017		DRAWING NO	
		8 PLC ±		CHK		25MAY2017		00779	
		9 PLC ±		CHK		25MAY2017		©=2836776	
		10 PLC ±		CHK		25MAY2017		RESTRICTED TO	
		11 PLC ±		CHK		25MAY2017		-	
		12 PLC ±		CHK		25MAY2017		Customer Accessible Production Drawing	
		13 PLC ±		CHK		25MAY2017		SCALE	
		14 PLC ±		CHK		25MAY2017		1:2	
		15 PLC ±		CHK		25MAY2017		SHEET	
		16 PLC ±		CHK		25MAY2017		2 of 4	
		17 PLC ±		CHK		25MAY2017		REV	
		18 PLC ±		CHK		25MAY2017		C	

8		7	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2836776-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2836776-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2836776-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.80 mm [.071]	F
INSUL	4.06 mm [.160]	O
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: G&H(LEAR) TERMINAL LEAR CRIMP SPECIFICATION	
TERMINAL NAME: MDK3 PLUS TERMINAL	
WIRE STRIP LENGTH 4.41-5.17 mm [.173-.203 IN]	INSULATION DIAMETER RANGE Ø 2.00-2.70 mm [.079-.106 IN]
TERMINAL APPLICATION SPECIFICATION 26628 Rev 2	-
-	-

TERMINALS APPLIED				SEAL INSULATION DIAMETER RANGE
TE TERMINAL	G&H(LEAR) TERMINAL	TE SEAL	G&H(LEAR) SEAL	
1949701-1	26628.331.179	1572316-1	16695.627.642	1.2-2.1mm
1949701-2	26402.213.178	1572316-2	16695.627.619	1.2-2.1mm
1949701-3	26628.331.710	1572316-5	16276.627.642	1.2-2.1mm
1949701-4	26402.221.702	1949095-1	16694.627.626	1.9-3.0mm

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.00mm2	1.30+/-0.05 [.051+/-0.002]	6.7
0.75mm2	1.25+/-0.05 [.049+/-0.002]	7.3
0.50mm2	1.20+/-0.05 [.047+/-0.002]	7.8



- 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.
- APPLY TORQ-SEAL IN ALLEN SOCKET TO FILL HOLE AFTER FLAT HD HAS BEEN ADJUSTED TO CORRECT HEIGHT AT QUALIFICATION. APPLY #1-23419-5 LOC-TITE TO THREADS.
- 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)

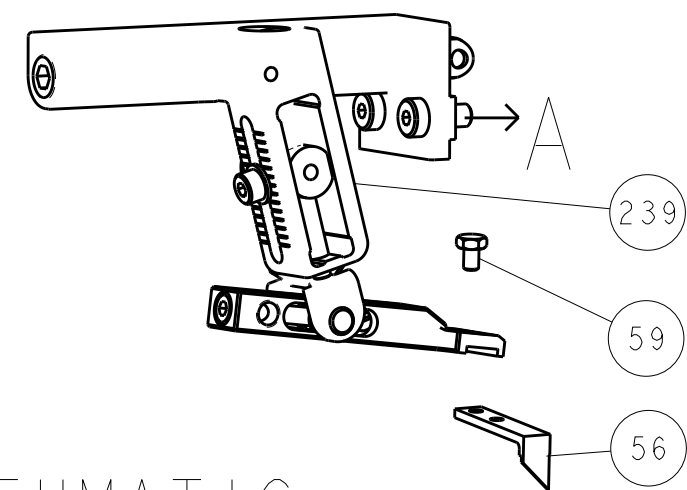
LOC	DIST	REVISIONS					
A	66	P	LTR	DESCRIPTION	DATE	DWN	APVD
			-	SEE SHEET 1	-	-	-

-	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	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
-	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	455888-4	SPACER, CRIMPER	82
-	1	1	1803607-3	DOCUMENTATION PACKAGE	71
-	1	1	2119791-9	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	985575-3	SCR, FLT SKT HD CAP M3 X 10.0	57
-	1	1	1338685-1	PAWL, FEED	56
-	2	2	2-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 14	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	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	3-1752356-4	SUPPORT, TERMINAL	34
-	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	2-2844962-8	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	2844992-4	ASSEMBLY, STRIP GUIDE	29
-	1	1	455888-3	SPACER, CRIMPER	28
-	1	1	240792-1	DRAG, TERMINAL	25
-	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	2119806-1	INSERT, SHEAR	13
-	1	1	3-22280-3	SPRING, COMPRESSION	12
-	1	1	1-356885-4	STOP, SHEAR	11
-	1	1	2119805-1	SHEAR HOLDER, FRONT	10
-	1	1	318707-1	FLOATING SHEAR, FRONT	9
1	1	1	8-1803252-3	ANVIL, COMBINATION	8
-	1	1	240641-2	SPACER	7
-	-	-	-	-	6
-	1	1	2119781-2	DEPRESSOR, SHEAR	5
-	1	1	3-238011-1	BLOCK, CRIMPER SPACER	4
1	1	1	1-1803248-0	CRIMPER, INSULATION O PREMIUM	3
-	1	1	455888-3	SPACER, CRIMPER	2
1	1	1	2-1803470-0	CRIMPER, WIRE F	1
-77	-22	-21	PART NO	DESCRIPTION	ITEM NO

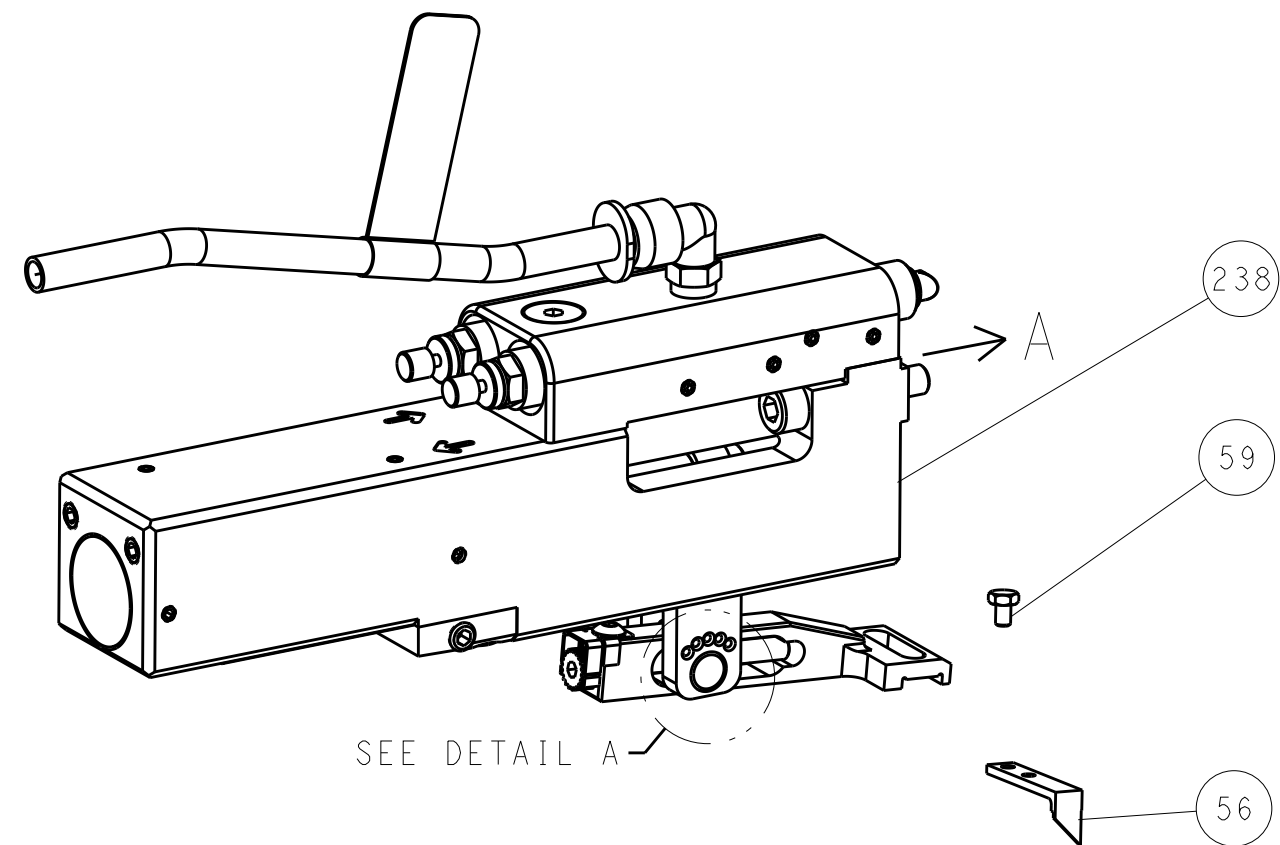
THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE WITHOUT NOTICE AND WITHOUT LIABILITY. IT IS SUBJECT TO CHANGE WITHOUT NOTICE AND WITHOUT LIABILITY. IT IS SUBJECT TO CHANGE WITHOUT NOTICE AND WITHOUT LIABILITY.		DWN K. HUANG 25MAY2017	STE TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm		CHK K. HUANG 25MAY2017	NAME Ocean Side Feed Applicator	
TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH ±		APVD L. ZHANG 25MAY2017	PRODUCT SPEC APPLICATION SPEC	
MATERIAL		WEIGHT	SIZE A1	CAGE CODE 00779
Customer Accessible Production Drawing		SCALE 1:2	DRAWING NO C=2836776	RESTRICTED TO -
SHEET 3 OF 4		REV C		

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

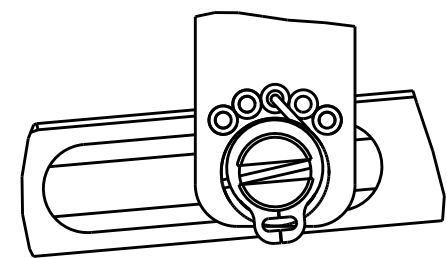
FEED TYPE MECHANICAL



PNEUMATIC

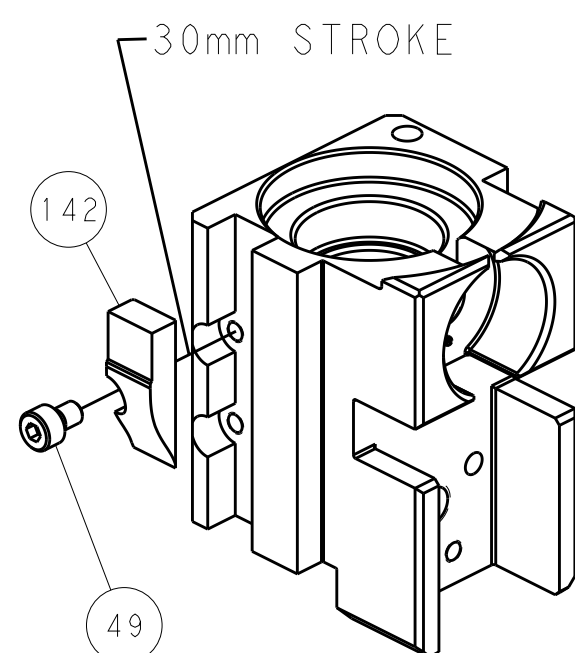


FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)

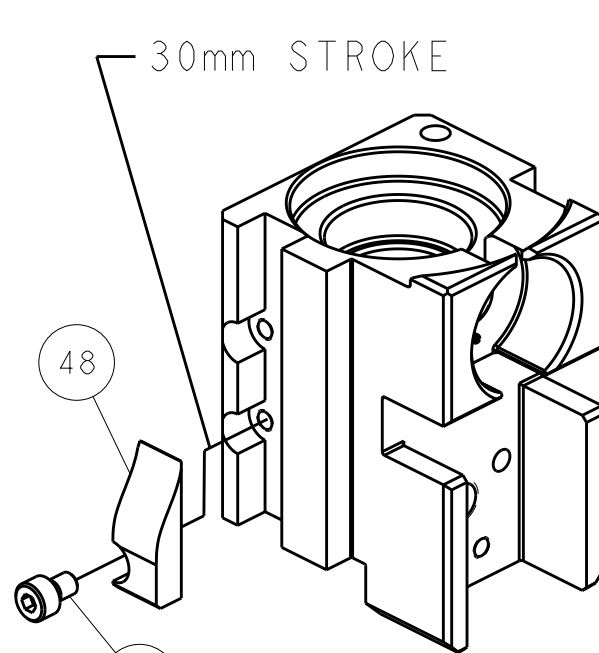


DETAIL A

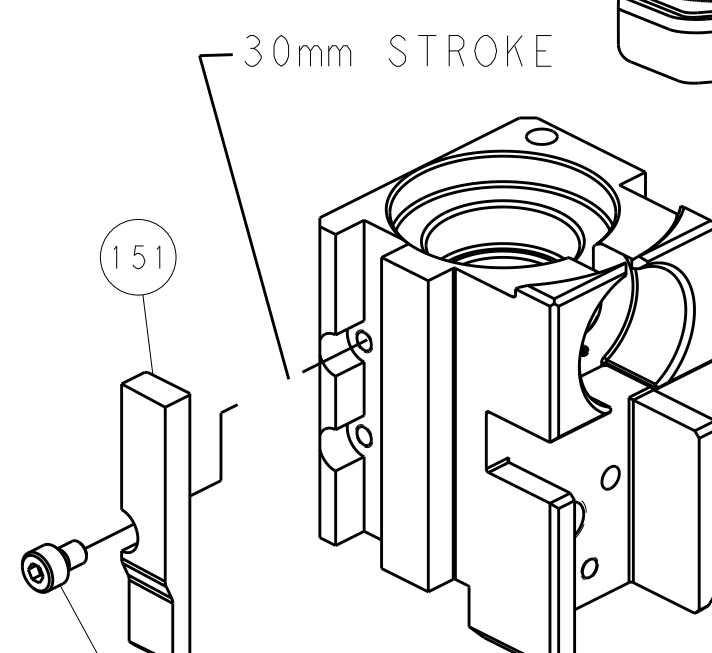
CAM POSITIONS



MECHANICAL
POST FEED



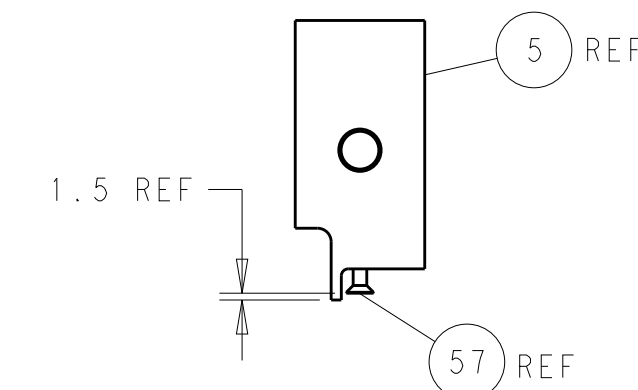
MECHANICAL
PRE FEED



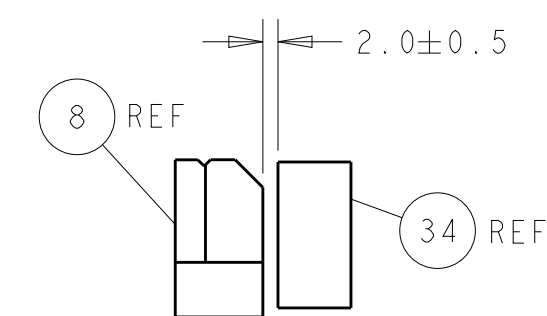
AIR FEED

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

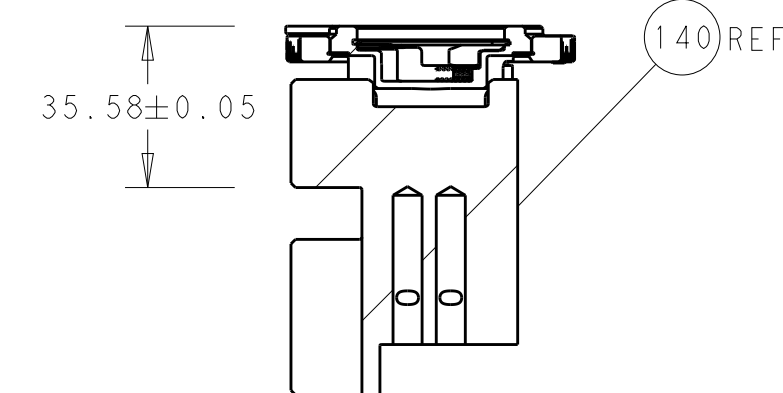
LOC	DIST	REVISIONS					
		P	LTR	DESCRIPTION	DATE	DWN	APVD
A	66	-	-	SEE SHEET 1	-	-	-



SHEAR DEPRESSOR DETAIL

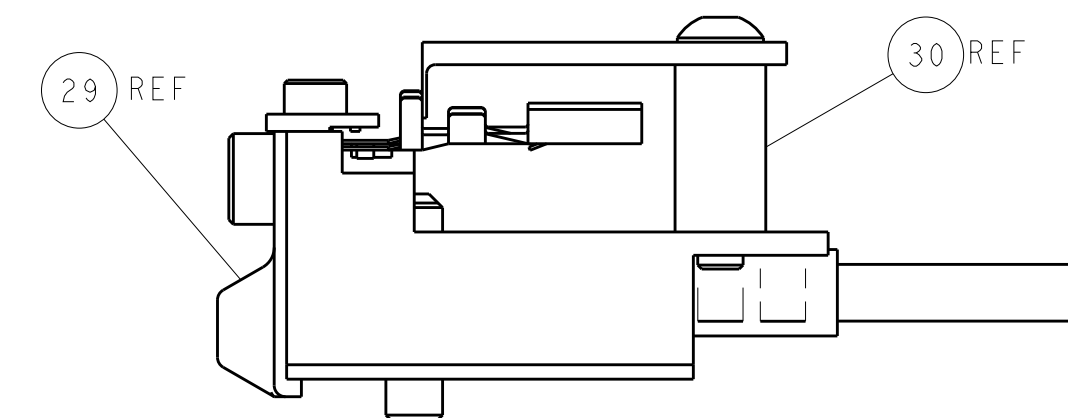


TERMINAL SUPPORT LOCATION



RAM SET-UP

ITEM 30 LOCATED AT
FRONT HOLES



FEED TRACK POSITION
GUIDE BY INSULATION BARREL

THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. THE USER SHALL BE RESPONSIBLE FOR VERIFYING THE LATEST REVISIONS. SHOULD BE CONTACTED FOR THE LATEST REVISIONS.		DWN K. HUANG 25MAY2017	TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm		CHK K. HUANG 25MAY2017	NAME Ocean Side Feed Applicator	
TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH		APVD L. ZHANG 25MAY2017	PRODUCT SPEC APPLICATION SPEC	
MATERIAL		WEIGHT	SIZE A1	CAGE CODE 00779
		Customer Accessible Production Drawing	SCALE 1:2	SHEET 4
			OF 4	REV C

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

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