

8		7	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2836041-2	D	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2836041-2	D	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2836041-7	C	CRIMP TOOLING KIT	-

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	0.80 mm [.031]	F
INSUL	0.80 mm [.031]	F
APPLICATOR INSTRUCTIONS		
408-35042		

TERMINAL DATA: MOLEX TERMINAL		MOLEX CRIMP SPECIFICATION	
TERMINAL NAME: 1.25mm PITCH WIRE-TO BOARD TERMINALS			
WIRE STRIP LENGTH 1.50-1.70 mm [.059-.067 IN]		INSULATION DIAMETER RANGE Ø0.80-1.00 mm [.031-.039 IN]	
TERMINAL APPLICATION SPECIFICATION		ATS-639006600 Rev C	
TERMINALS APPLIED			
TE TERMINAL	MOLEX TERMINAL	TE TERMINAL	MOLEX TERMINAL
2113902-1	502381-0000	2113902-2	502381-0010

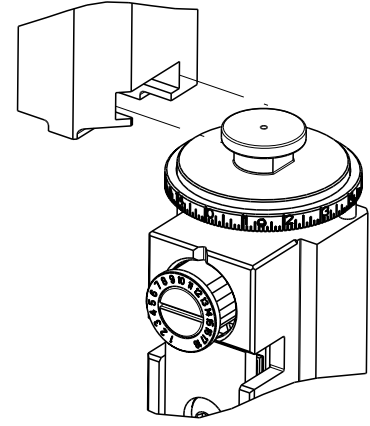
WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING	
26 AWG OR 0.14mm2		0.58+/-0.025 [.023+/- .001]		6.4	
28 AWG OR 0.08mm2		0.56+/-0.025 [.022+/- .001]		6.7	



- 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.
- 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.

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)

2		1						
LOC	DIST	REVISIONS						
A	66	P	LTR	DESCRIPTION		DATE	DWN	APVD
		B		ECR-16-011950		29AUG2016	XZ	CT
		C		ECR-16-013542		22SEP2016	KH	CT
		C1		ECR-18-006162		23APR2018	KH	JDG
		D		ECR-20-004649		30MAR2020	FZ	TE

	-	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
7	-	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	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	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	1-2168083-4	SCR, SKT HD CAP, RoHS, M4 X 5	53
	-	1	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49
	-	1	1	2-1803583-5	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	2-1752356-6	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	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	1803338-1	STRIPPER, SIDE FEED	19
	-	1	1	2-690518-8	HOLD DOWN, TERMINAL	18
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	2	1	1803437-1	ANVIL, COMBINATION	8
	-	-	-	-	-	7
	-	-	-	-	-	6
	-	1	1	1-2119757-8	DEPRESSOR, SHEAR	5
	-	1	1	6-238011-3	BLOCK, CRIMPER SPACER	4
1	1	2	1	1803438-1	CRIMPER, INSULATION F	3
	-	1	1	455888-3	SPACER, CRIMPER	2
1	1	2	1	1803433-1	CRIMPER, WIRE PREMIUM	1

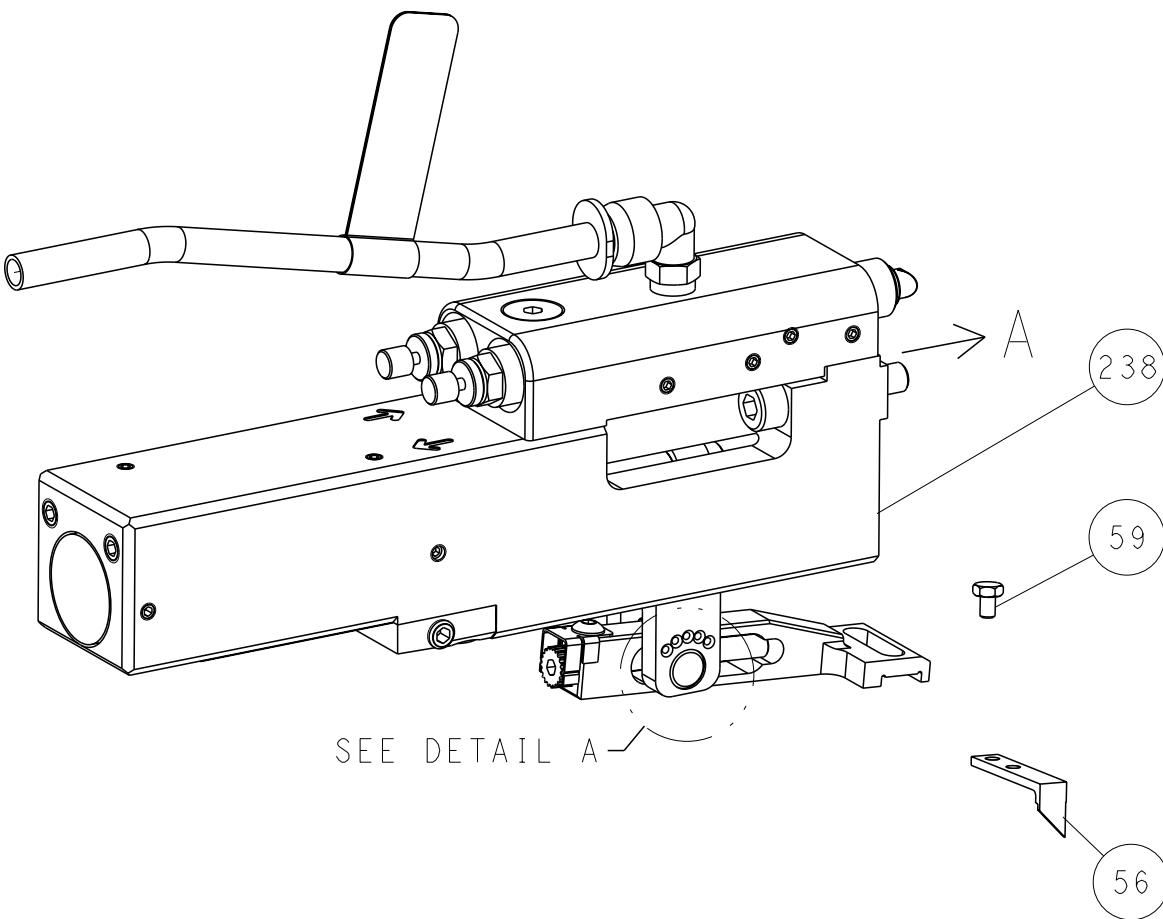
THIS DRAWING IS A CONTROLLED DOCUMENT FOR THE ELECTRICAL CONSTRUCTION. IT IS SUBJECT TO CHANGE AND TO CANCELLATION WITHOUT NOTICE. ANY REVISIONS SHOULD BE CONTACTED FOR THE LATEST REVISION.				DWN C. HUANG	22OCT2015	 TE Connectivity Harrisburg, PA 17105-3608					
				CHK L. ZHANG	22OCT2015						
				APVD J. GUO	22OCT2015						
				NAME							
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		PRODUCT SPEC		Ocean Side Feed Applicator					
mm		0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ±		APPLICATION SPEC							
		ANGLES FINISH ±		-							
MATERIAL				WEIGHT		SIZE		CAGE CODE	DRAWING NO	RESTRICTED TO	
				A		00779		C=2836041		-	
Customer Accessible Production Drawing						SCALE		1:2		SHEET 1 of 4	REV D

SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

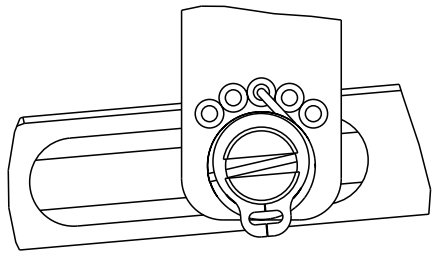
LOC	DIST	REVISIONS					
		P	LTR	DESCRIPTION	DATE	DWN	APVD
A	66	-	-	SEE SHEET 1	-	-	-

FEED TYPE

PNEUMATIC

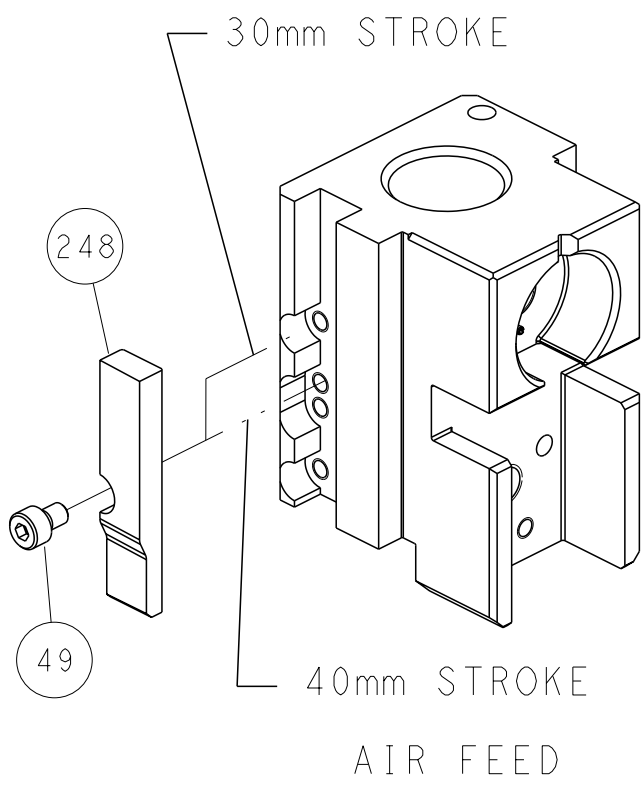


FEED SPRING SETTING POSITION
(SHOWN FROM REAR SIDE)

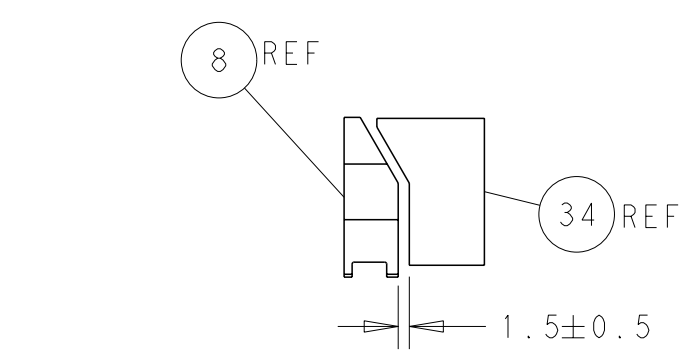
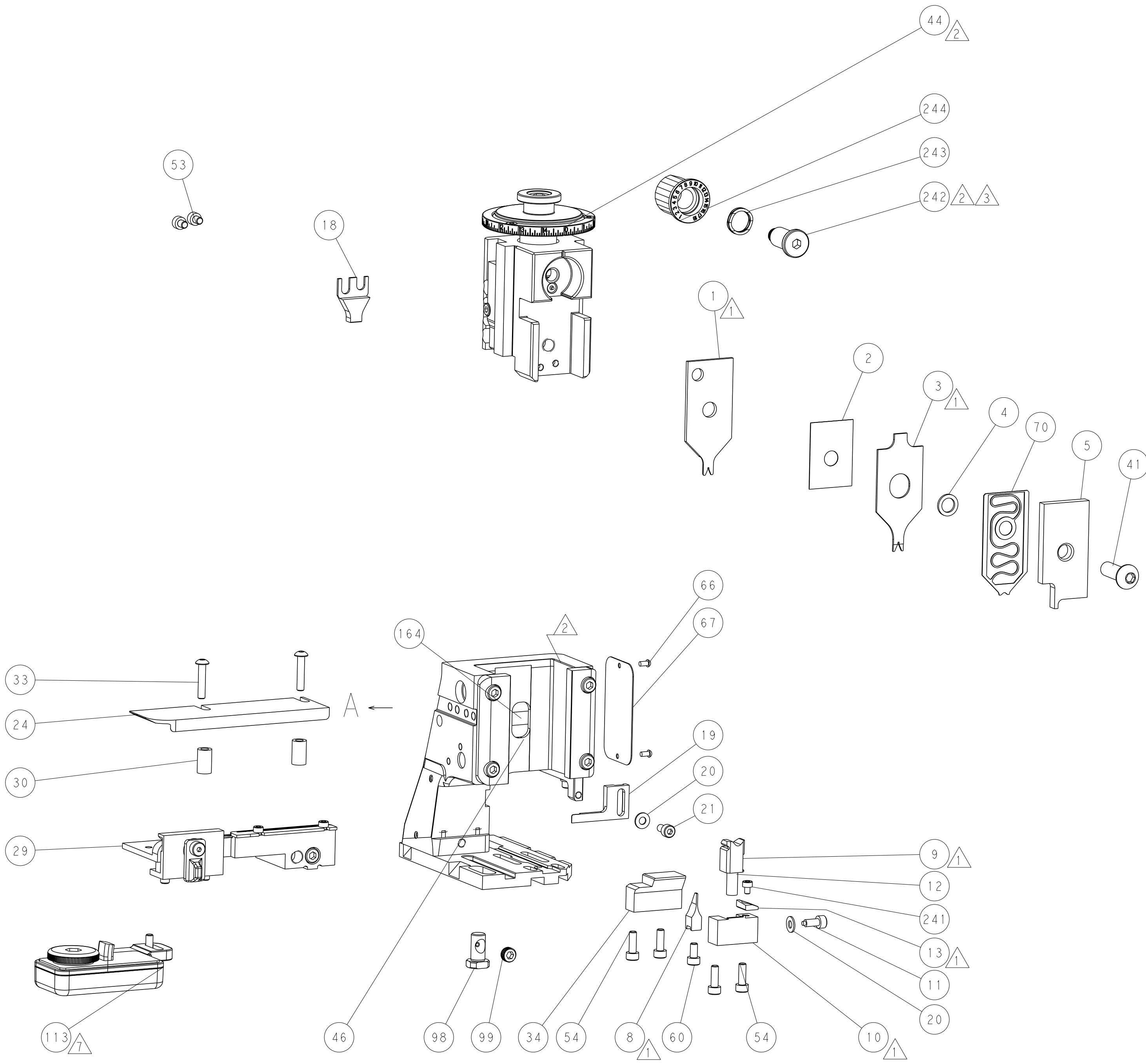


DETAIL A

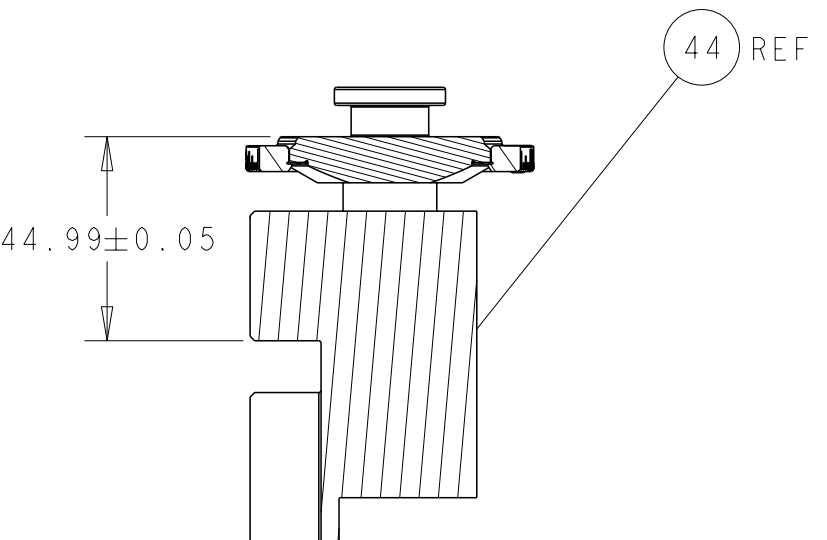
CAM POSITION



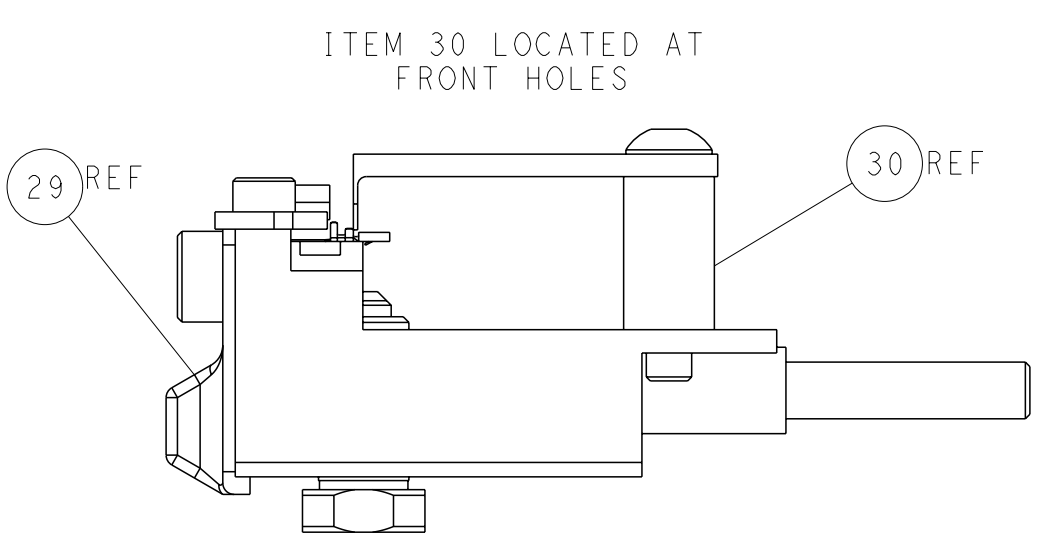
AIR FEED



TERMINAL SUPPORT LOCATION



RAM SET-UP



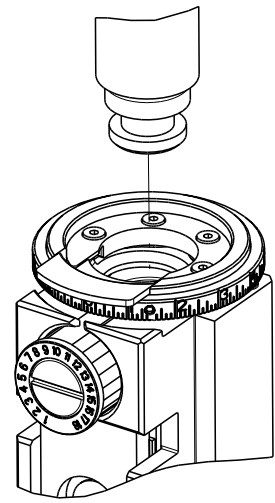
FEED TRACK POSITION
GUIDE BY WIRE BARREL

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

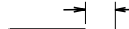
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DIMENSIONS: mm 				CHK L. ZHANG 22OCT2015			NAME	Ocean Side Feed Applicator			
				APPD U. GUO 22OCT2015							
				TOLERANCES UNLESS OTHERWISE SPECIFIED:							
0 PLC ±				PRODUCT SPEC		SIZE		CAGE CODE	DRAWING NO	RESTRICTED TO	
1 PLC ±				-		-		-		-	
2 PLC ±				APPLICATION SPEC		-		-		-	
3 PLC ±				-		-		-		-	
4 PLC ±				-		-		-		-	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2836041-2	D	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2836041-7	C	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	0.80 mm [.031]	F
INSUL	0.80 mm [.031]	F
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: MOLEX TERMINAL		MOLEX CRIMP SPECIFICATION	
TERMINAL NAME: 1.25mm PITCH WIRE-TO BOARD TERMINALS			
WIRE STRIP LENGTH 1.50-1.70 mm [.059-.067 IN]		 INSULATION DIAMETER RANGE Ø0.80-1.00 mm [.031-.039 IN]	
TERMINAL APPLICATION SPECIFICATION ATS-639006600 Rev C		-	-
		-	-
TERMINALS APPLIED  			
TE TERMINAL	MOLEX TERMINAL	TE TERMINAL	MOLEX TERMINAL
2113902-1	502381-0000	2113902-2	502381-0010

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING
26 AWG OR 0.14mm2		0.58+/-0.025 [.023+/- .001]		6.4
28 AWG OR 0.08mm2		0.56+/-0.025 [.022+/- .001]		6.7



- 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 PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- 7 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				
		P	LYR	DESCRIPTION	DATE	OWN
A	66	-	-	SEE SHEET 1	-	-

-	1	2119082-4	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	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	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	3-1803583-0	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	1803607-3	DOCUMENTATION PACKAGE	71
-	1	2119791-9	DEPRESSOR, WIRE	70
-	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	1-2168083-4	SCR, SKT HD CAP, RoHS, M4 X 5	53
-	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
-	1	2-1752356-6	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	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	1803338-1	STRIPPER, SIDE FEED	19
-	1	2-690518-8	HOLD DOWN, TERMINAL	18
-	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	1803095-3	FLOATING SHEAR, FRONT -	9
-	1	1803437-1	ANVIL, COMBINATION	8
-	-	-	-	7
-	-	-	-	6
-	1	1-2119757-8	DEPRESSOR, SHEAR	5
-	1	6-238011-3	BLOCK, CRIMPER SPACER	4
-	1	1803438-1	CRIMPER, INSULATION F	3
-	1	455888-3	SPACER, CRIMPER	2
-	1	1803433-1	CRIMPER, WIRE PREMIUM	1
-	77	-22	PART NO	

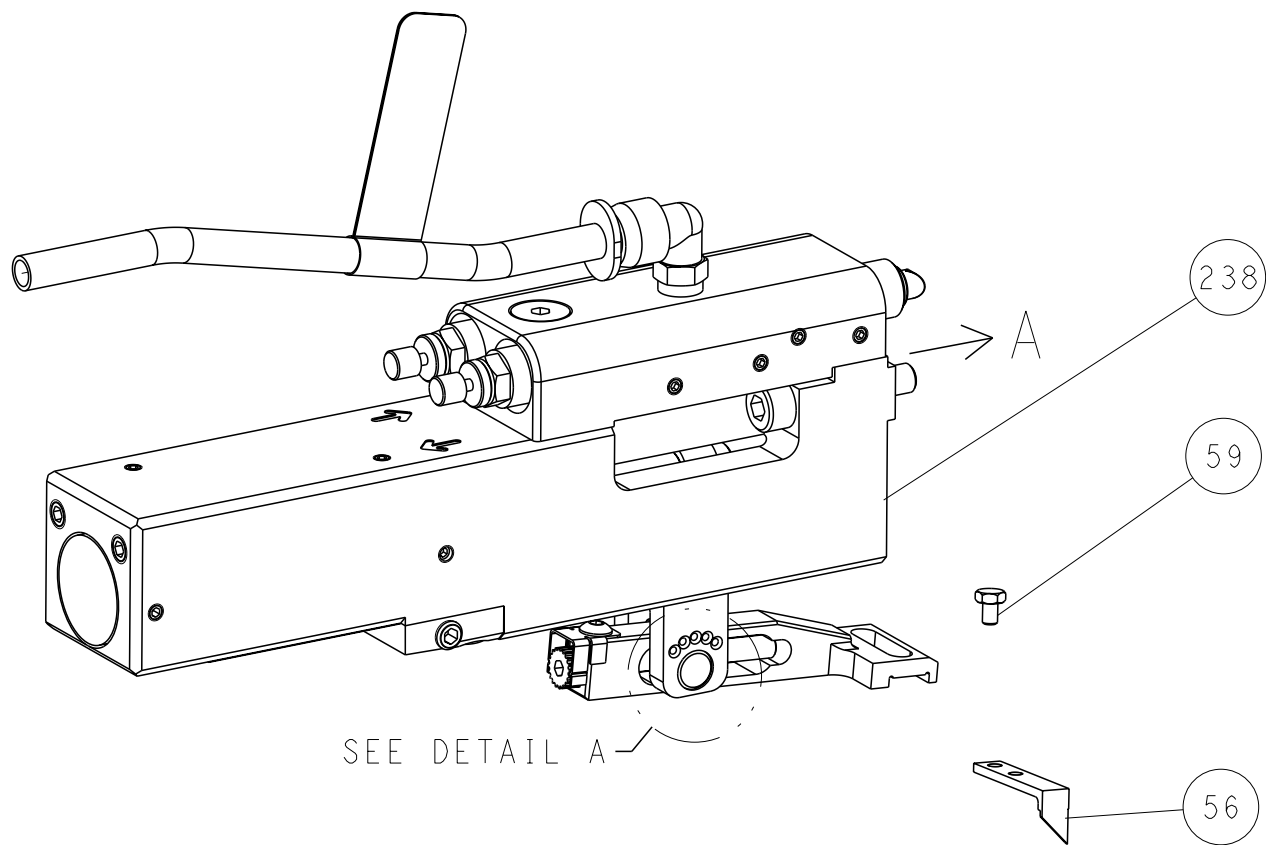
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DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		NAME Ocean Side Feed Applicator	
		APPLICATION SPEC		SIZE 00779	
MATERIAL -		WEIGHT -		DRAWING NO C=2836041	
		Customer Accessible Production Drawing		SCALE 1:2	
				SHEET 3	
				OF 4	
				REV D	

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

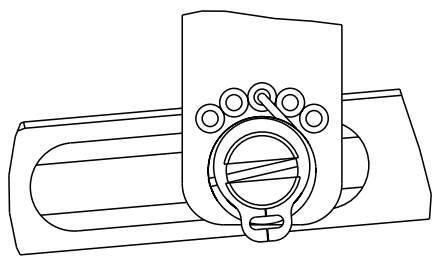
LOC		DIST		REVISIONS					
A		66		P	LTR	DESCRIPTION	DATE	DWN	APVD
					-	SEE SHEET 1	-	-	-

FEED TYPE

PNEUMATIC

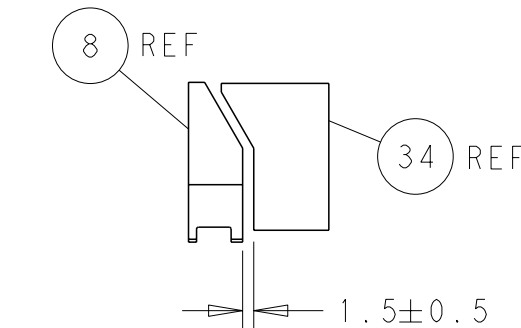
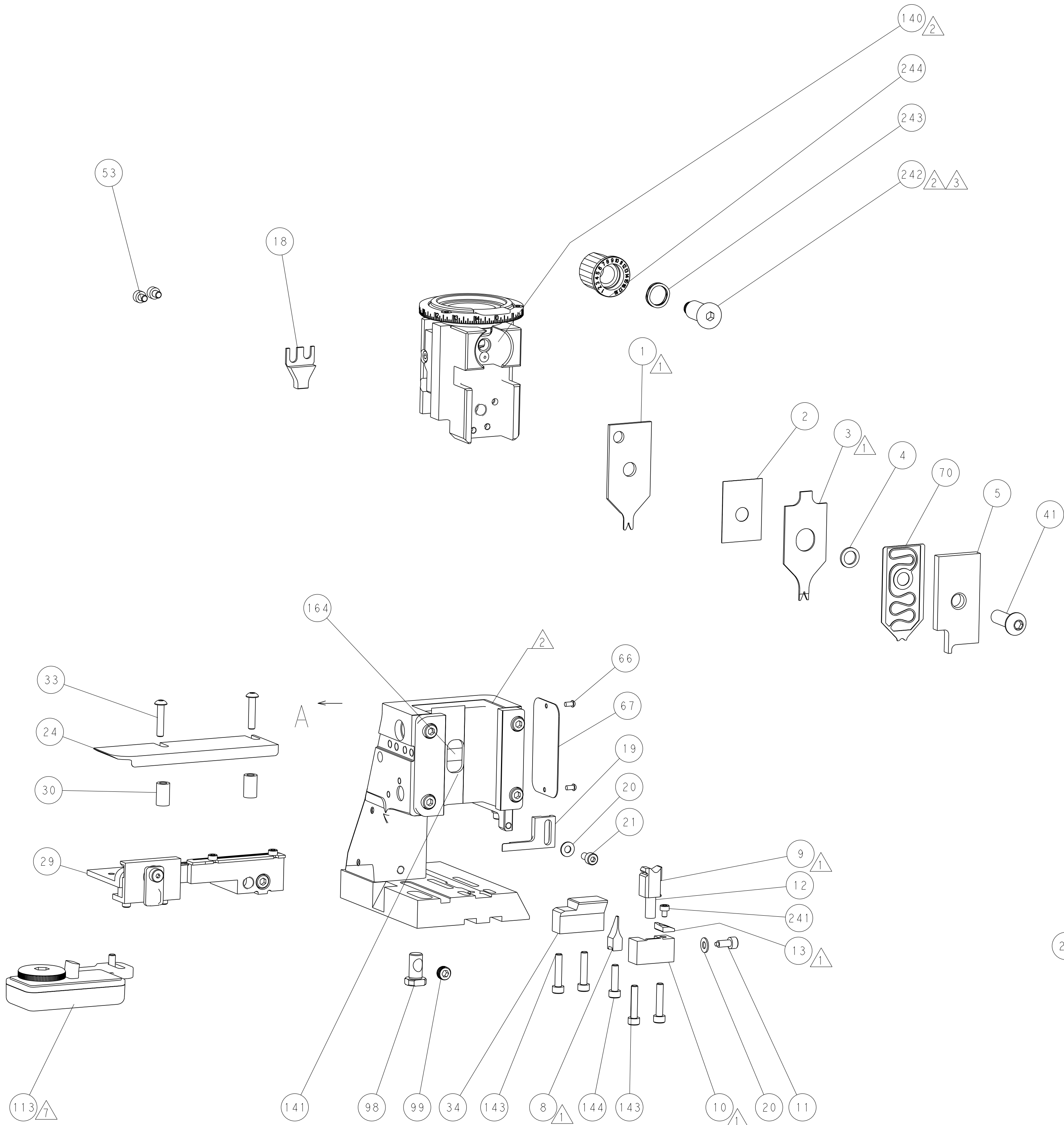
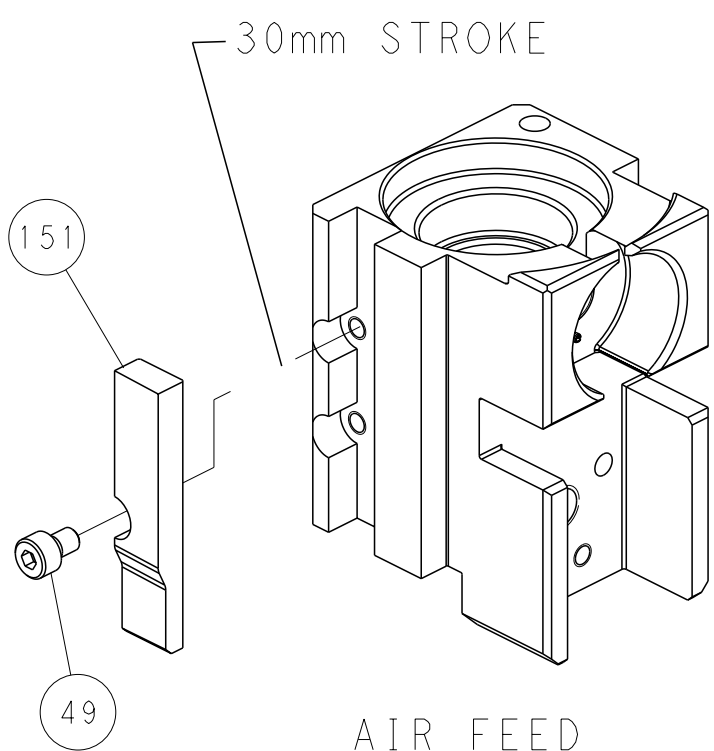


FEED SPRING SETTING POSITION
(SHOWN FROM REAR SIDE)

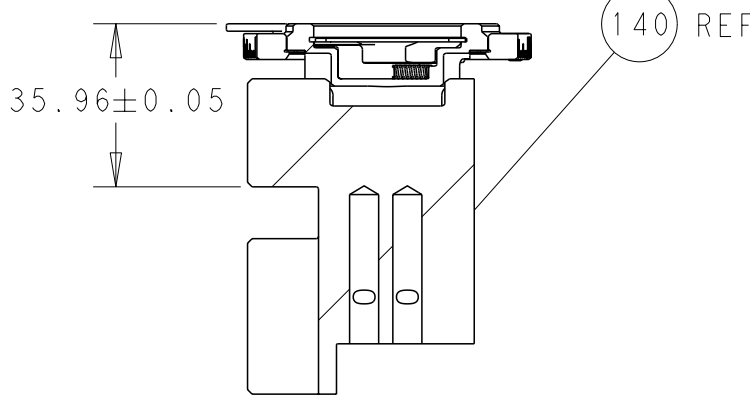


DETAIL A

CAM POSITION

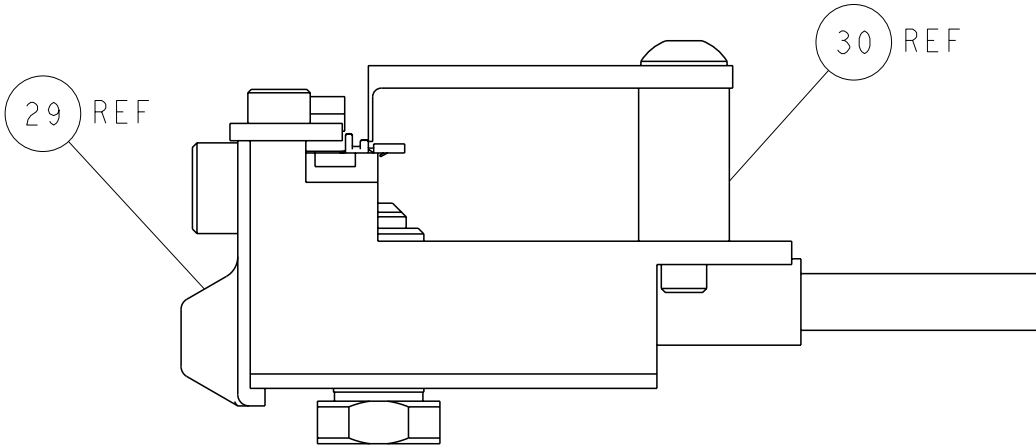


TERMINAL SUPPORT LOCATION



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)

THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION IT IS SUBJECT TO CHANGE AND TO CONTROL AND ENGINEERING DEPARTMENT SHALL BE CONTACTED FOR THE LATEST REVISION				DWN K. HUANG 22OCT2015	22OCT2015	STE TE Connectivity Harrisburg, PA 17105-3608		
				CHK L. ZHANG 22OCT2015	22OCT2015	NAME Ocean Side Feed Applicator		
				APVD U. GUO 22OCT2015	22OCT2015	SIZE A1		
DIMENSIONS: mm				TOLERANCES UNLESS OTHERWISE SPECIFIED:		CAGE CODE 00779		
				0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		DRAWING NO C=2836041		
MATERIAL -				FINISH -		RESTRICTED TO -		
				WEIGHT -		Customer Accessible Production Drawing		
						SCALE 1:2		
						SHEET 4		
						OF 4		
						REV D		

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