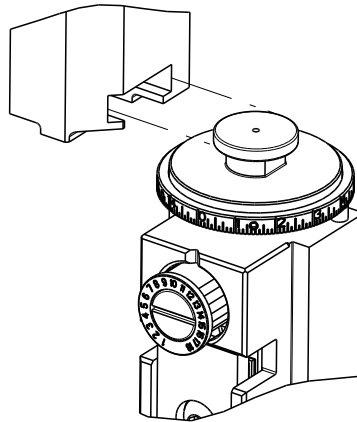


8		7	
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20		20	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2836028-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2836028-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2836028-1	B	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2836028-2	B	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2836028-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.75 mm [.069]	F
INSUL	3.40 mm [1.34]	O
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: KET TERMINAL		KET CRIMP SPECIFICATION		
TERMINAL NAME: KET TERMINAL				
WIRE STRIP LENGTH 4.50-5.00 mm [1.77-1.97 IN]			INSULATION DIAMETER RANGE Ø	
TERMINAL APPLICATION SPECIFICATION		SWP MALE TERMINAL Rev 2010-06.30		-
		-	-	-
TERMINALS APPLIED				
TE TERMINAL	KET TERMINAL	TE SEAL	KET SEAL	CABLE DIAMETER
2113754-1	ST740482-3	1-1949770-0	MG680449	Ø 1.70-1.90
2113754-2	ST740482-G	1-1949770-1	MG680448	Ø 1.40-1.70
		TE SEAL	YAZAKI SEAL	
		1-1949770-2	7157-7897-60	Ø 1.70-1.90

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
AVSS 0.85mm ²	1.25+/-0.05 [1.049+/-0.002]	5.6
FLRY-B 0.75mm ²	1.20+/-0.05 [1.047+/-0.002]	6.1
AVSS 0.5mm ²	1.15+/-0.05 [1.045+/-0.002]	6.8
LEONI 0.35mm ²	1.05+/-0.05 [1.041+/-0.002]	7.5
AVSS 0.3mm ²	1.05+/-0.05 [1.041+/-0.002]	7.9



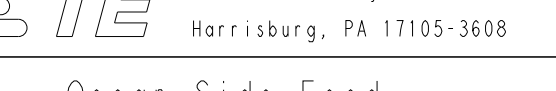
- 1 RECOMMENDED SPARE PARTS
- 2 REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- 3 APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242.
- 4 CRIMP HEIGHT REFERENCE SETTING WAS THE SETTING USED WHEN THE APPLICATOR WAS QUALIFIED AT THE FACTORY. ADJUSTMENT 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. 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.

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

LOC	DIST	REVISONS			
A	66	P	LTR	DESCRIPTION	DATE
		I		DEVELOPMENT	7SEP2015
		A		RELEASED	10OCT2015
		B		ECR-21-114518	21SEP2021
		B1		ECR-21-114518	23NOV2021

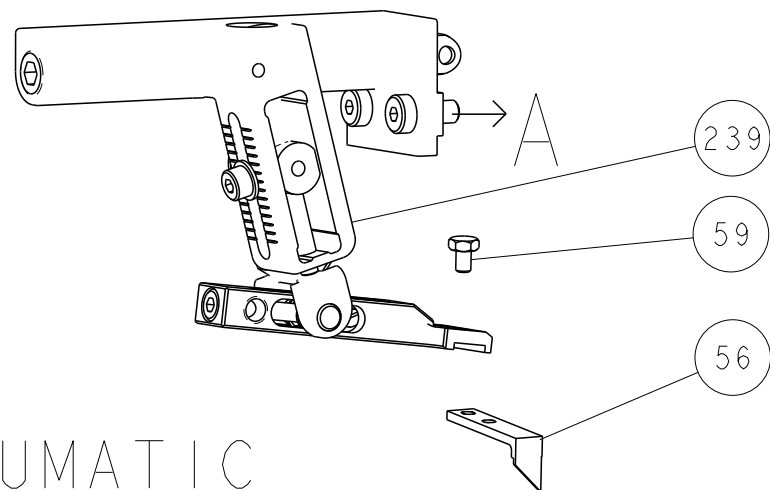
	-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248
	-	1	1	1	1	2119082-2	CAM, SNAIL, INSULATION ADJUSTMENT	244
	-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
3	-	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
	-	1	1	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
	-	-	1	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
	-	1	-	1	-	2844940-1	AIR FEED MODULE	238
	-	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
	-	1	1	1	1	2844908-1	SCREW, LOCKING	99
	-	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
	-	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
5	-	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
	-	4	4	4	4	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	54
	-	2	2	2	2	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	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	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	1752356-3	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	2119533-1	STRIPPER, SIDE FEED	19
1	-	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	1	2119805-1	SHEAR HOLDER, FRONT	10
1	-	1	1	1	1	318707-1	FLOATING SHEAR, FRONT	9
1	1	2	2	1	1	4-1803055-3	ANVIL, COMBINATION	8
	-	1	1	1	1	3-240641-1	SPACER	7
	-	-	-	-	-	-	-	6
	-	1	1	1	1	2-2119781-4	DEPRESSOR, SHEAR	5
	-	1	1	1	1	2-238011-1	BLOCK, CRIMPER SPACER	4
1	1	2	2	1	1	5-1633966-5	CRIMPER, INSULATION O	3
	-	1	1	1	1	1-455888-0	SPACER, CRIMPER	2
1	1	2	2	1	1	1803241-3	CRIMPER, WIRE F	1

THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. THE USER SHALL BE RESPONSIBLE FOR VERIFYING THE LATEST VERSION OF THIS DRAWING. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. THE USER SHALL BE RESPONSIBLE FOR VERIFYING THE LATEST VERSION OF THIS DRAWING.				OWN	J. HOU	7SEP2015	 TE Connectivity Harrisburg, PA 17105-3608				
DIMENSIONS:				CHK	L. ZHANG	7SEP2015	NAME				
mm				APVD	J. GUO	7SEP2015					
TOLERANCES UNLESS OTHERWISE SPECIFIED:				PRODUCT SPEC		SIZE					
0 PLC ±				APPLICATION SPEC		CAGE CODE					
1 PLC ±				WEIGHT		DRAWING NO					
2 PLC ±				FINISH		00779					
3 PLC ±				SCALE		1:2					
4 PLC ±				SHEET		1 OF 4					
MATERIAL				REV		B1					
Customer Accessible Production Drawing				SCALE		1:2					

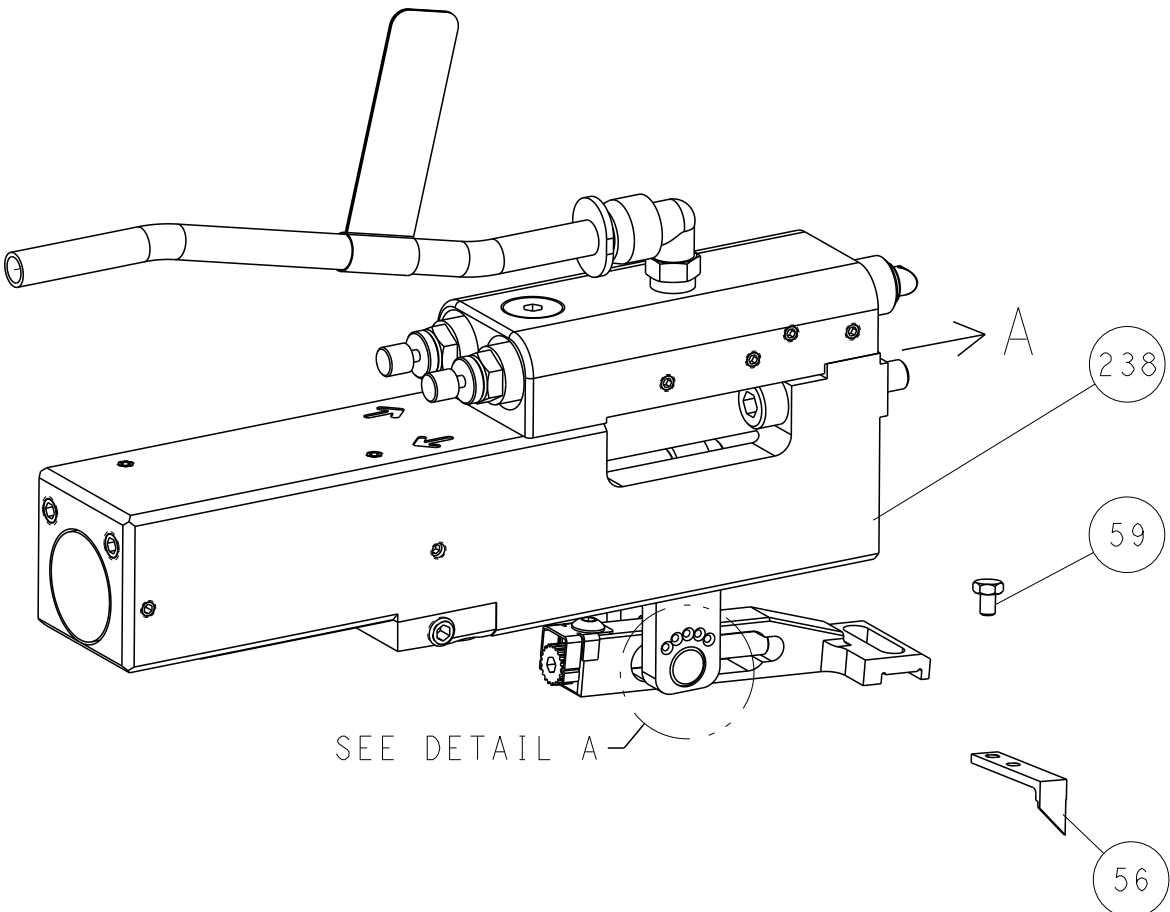
SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

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

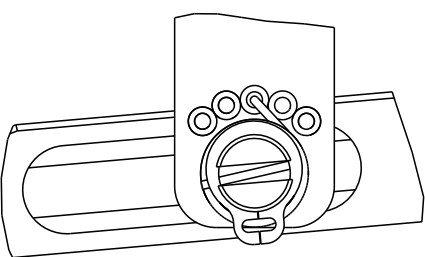
FEED TYPE MECHANICAL



PNEUMATIC

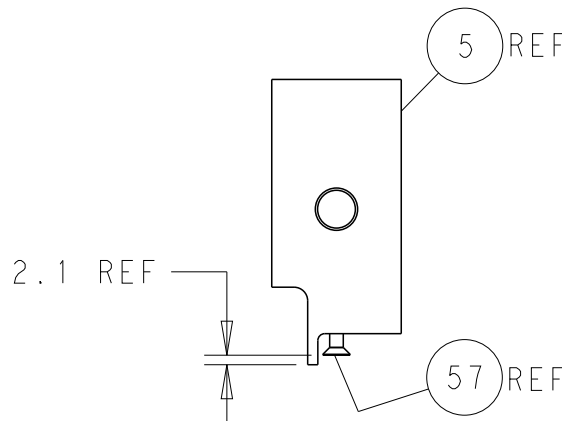
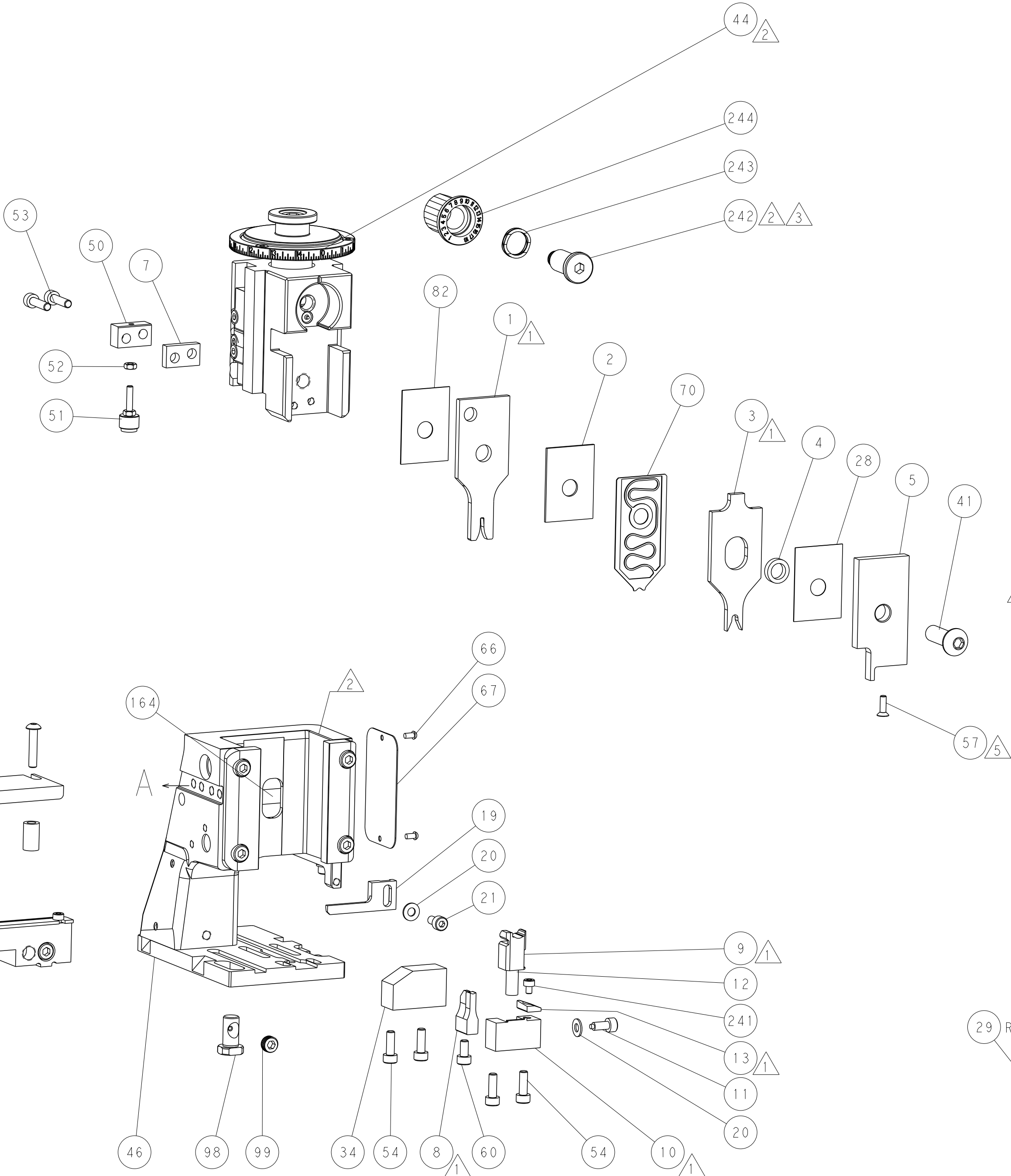
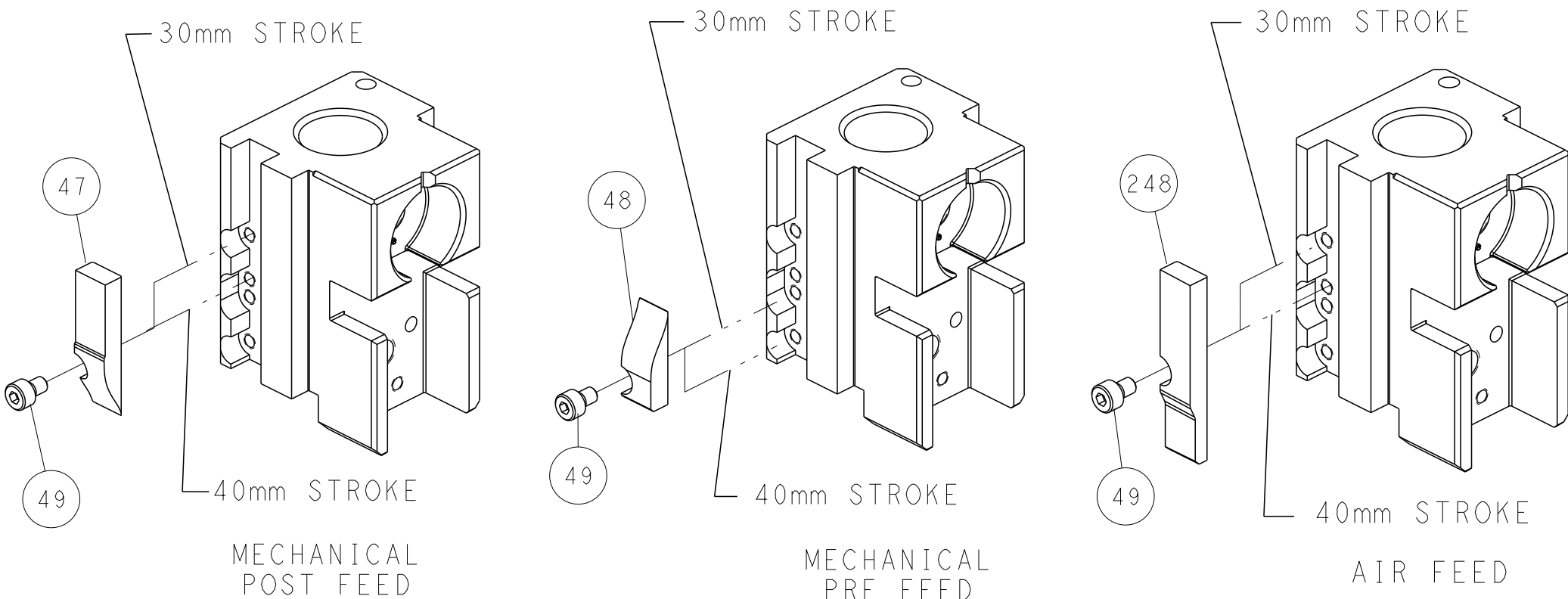


FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)

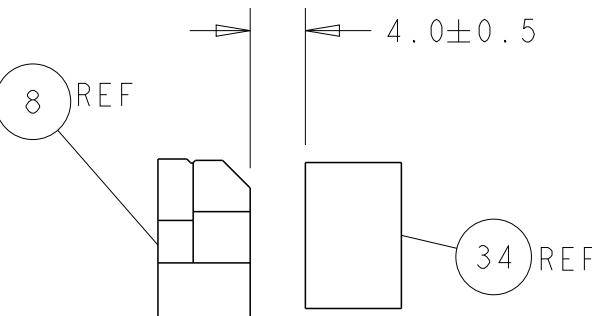


DETAIL A

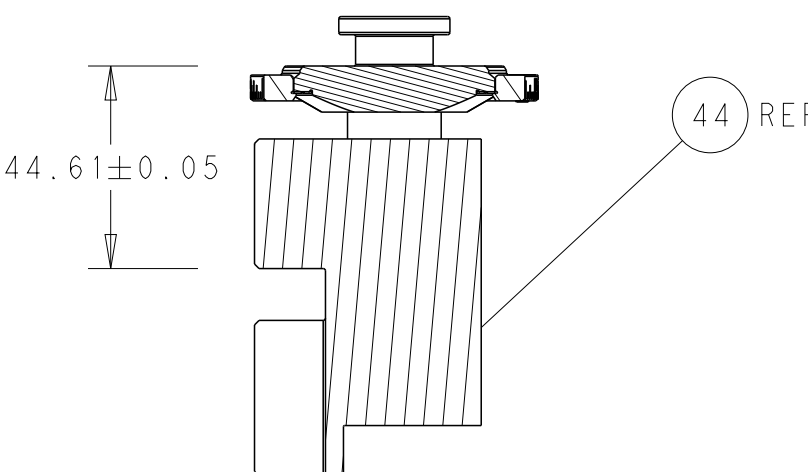
CAM POSITIONS



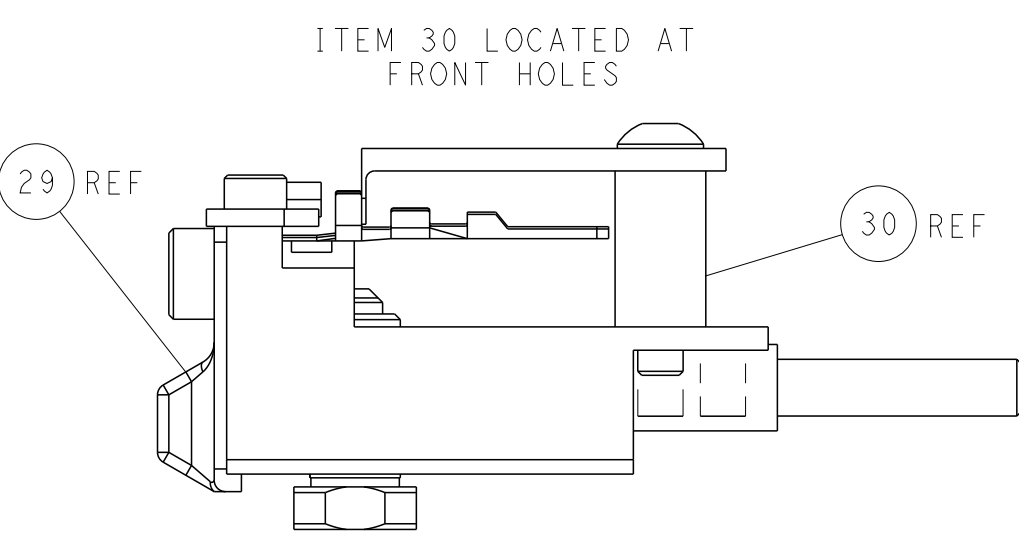
SHEAR DEPRESSOR DETAIL



TERMINAL SUPPORT LOCATION



RAM SET-UP



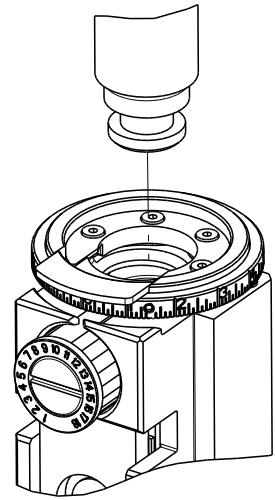
FEED TRACK POSITION
GUIDE BY INSULATION BARREL

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

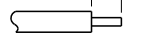
THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. ANY CHANGES TO THIS DRAWING SHOULD BE CONTACTED FOR THE LATEST VERSION.				DWN: J. HOU 7SEP2015				TE Connectivity Harrisburg, PA 17105-3608			
CHK: L. ZHANG 7SEP2015				APVD: J. GUO 7SEP2015				NAME: Ocean Side Feed Applicator			
DIMENSIONS: mm				TOLERANCES UNLESS OTHERWISE SPECIFIED:				PRODUCT SPEC			
0 PLC ±.1				1 PLC ±.1				APPLICATION SPEC			
2 PLC ±.1				3 PLC ±.1				SIZE: A1			
4 PLC ±.1				ANGLES FINISH				CAGE CODE: 00779			
MATERIAL: -				WEIGHT: -				DRAWING NO: C=2836028			
				Customer Accessible Production Drawing				SCALE: 1:2			
								SHEET: 2 of 4			
								REV: B1			

8		7	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2836028-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2836028-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2836028-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.75 mm [.069]	F
INSUL	3.40 mm [.134]	O
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: KET TERMINAL		KET CRIMP SPECIFICATION		
TERMINAL NAME: KET TERMINAL				
WIRE STRIP LENGTH 4.50-5.00 mm [.177-.197 IN]			INSULATION DIAMETER RANGE Ø	
TERMINAL APPLICATION SPECIFICATION		SWP MALE TERMINAL Rev 2010.06.30		
		-	-	-
TERMINALS APPLIED				
TE TERMINAL	KET TERMINAL	TE SEAL	KET SEAL	CABLE DIAMETER
2113754-1	ST740482-3	1-1949770-0	MG680449	Ø 1.40-1.70
2113754-2	ST740482-G	1-1949770-1	MG680448	Ø 1.70-1.90
		TE SEAL	YAZAKI SEAL	
		1-1949770-2	7157-7897-60	Ø 1.70-1.90

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
AVSS 0.85mm ²	1.25+/-0.05 [.049+/- .002]	5.6
FLRY-B 0.75mm ²	1.20+/-0.05 [.047+/- .002]	6.1
AVSS 0.5mm ²	1.15+/-0.05 [.045+/- .002]	6.8
LEONI 0.35mm ²	1.05+/-0.05 [.041+/- .002]	7.5
AVSS 0.3mm ²	1.05+/-0.05 [.041+/- .002]	7.9



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. 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				
		P	LTR	DESCRIPTION	DATE	DWN
A	66	-	-	SEE SHEET 1	-	-

3	-	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	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
5	-	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	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	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	1752356-3	SUPPORT, TERMINAL	34
	-	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
	-	2	2	2-2844962-4	SPACER, CYLINDRICAL, STRIP GUIDE	30
	-	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29
	-	1	1	455888-3	SPACER, CRIMPER	28
	-	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	318707-1	FLOATING SHEAR, FRONT	9
1	1	1	1	4-1803055-3	ANVIL, COMBINATION	8
	-	1	1	3-240641-1	SPACER	7
	-	-	-	-	-	6
	-	1	1	2-2119781-4	DEPRESSOR, SHEAR	5
	-	1	1	2-238011-1	BLOCK, CRIMPER SPACER	4
	1	1	1	5-1633966-5	CRIMPER, INSULATION O	3
1	-	1	1	1-455888-0	SPACER, CRIMPER	2
	1	1	1	1803241-3	CRIMPER, WIRE F	1

THIS DRAWING IS A CONTROLLED DOCUMENT AND ITS CONTENTS ARE UNCLASSIFIED INFORMATION. IT IS SUBJECT TO CONTROLLED DOCUMENT AND INFORMATION MANAGEMENT SYSTEMS. IT SHOULD BE CONTROLLED FOR THE LATEST EDITION.		DWN J. HOU 7SEP2015	TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm		CHK L. ZHANG 7SEP2015	NAME Ocean Side Feed Applicator	
TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH		APVD J. GUO 7SEP2015	PRODUCT SPEC APPLICATION SPEC	
MATERIAL -		WEIGHT -	SIZE A1	CAGE CODE 00779
Customer Accessible Production Drawing		SCALE 1:2	SHEET 3	OF 4
		REV B1		

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

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

D

C

B

A

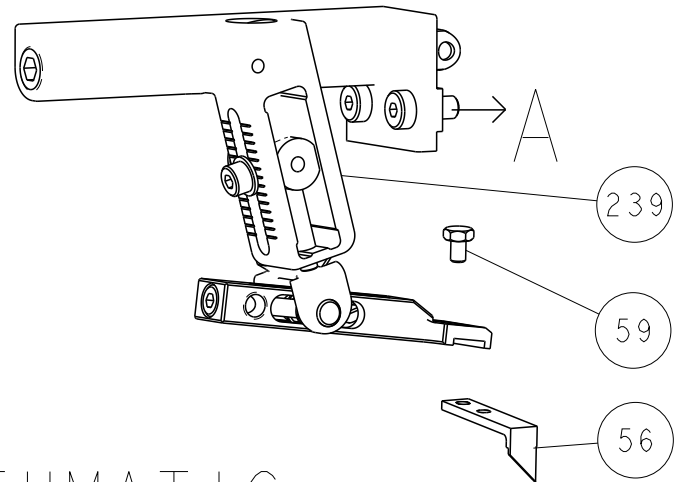
D

C

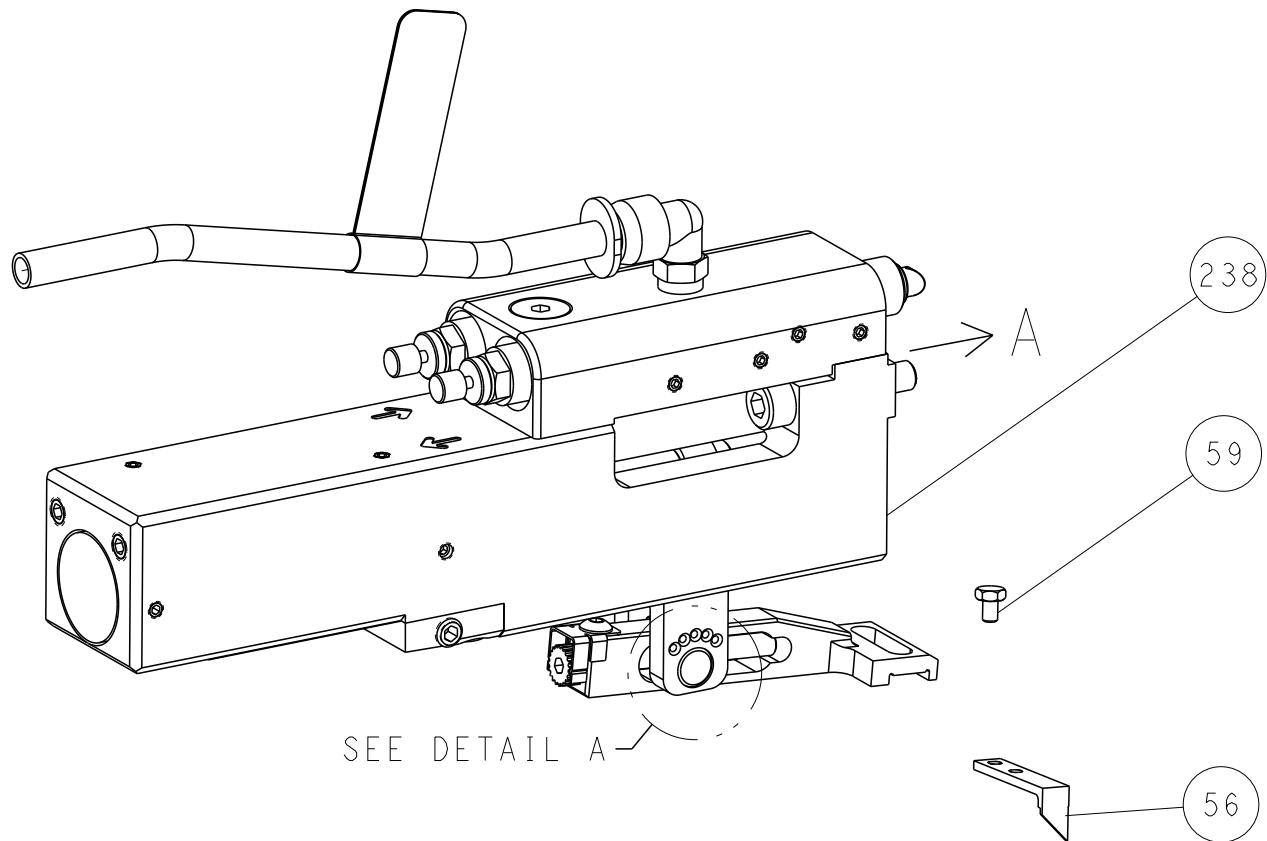
B

A

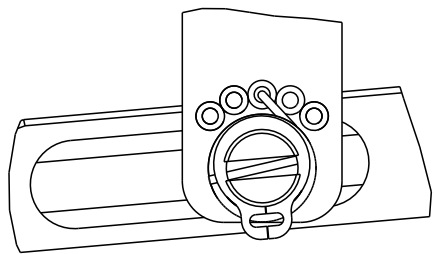
FEED TYPE MECHANICAL



PNEUMATIC

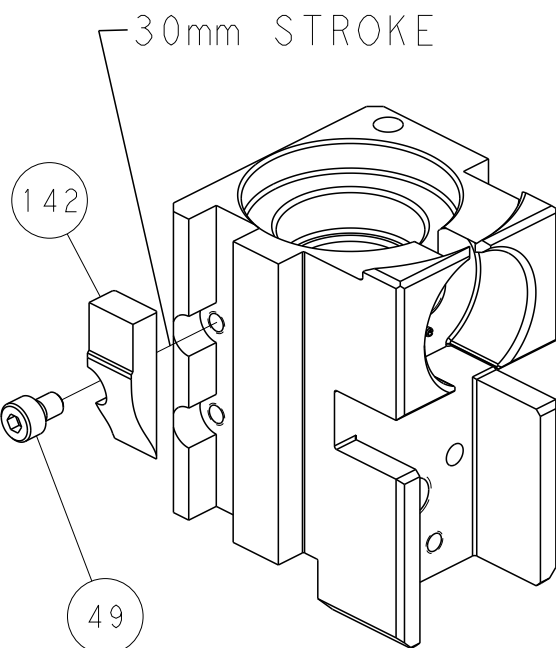


FEED SPRING SETTING POSITION
(SHOWN FROM REAR SIDE)

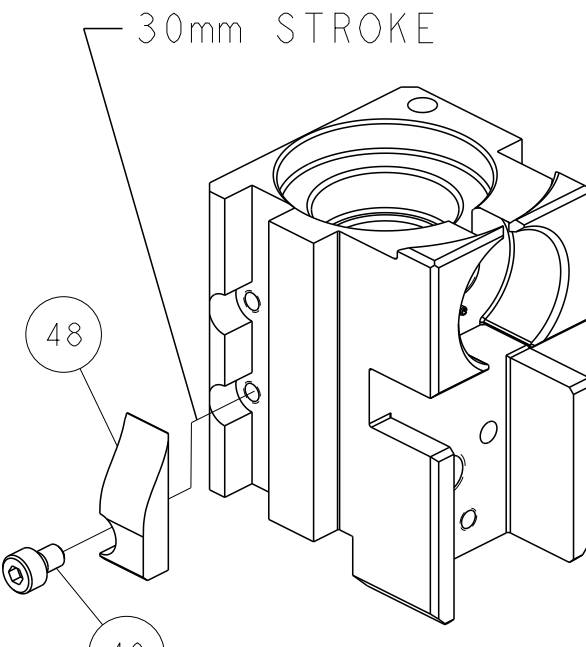


DETAIL A

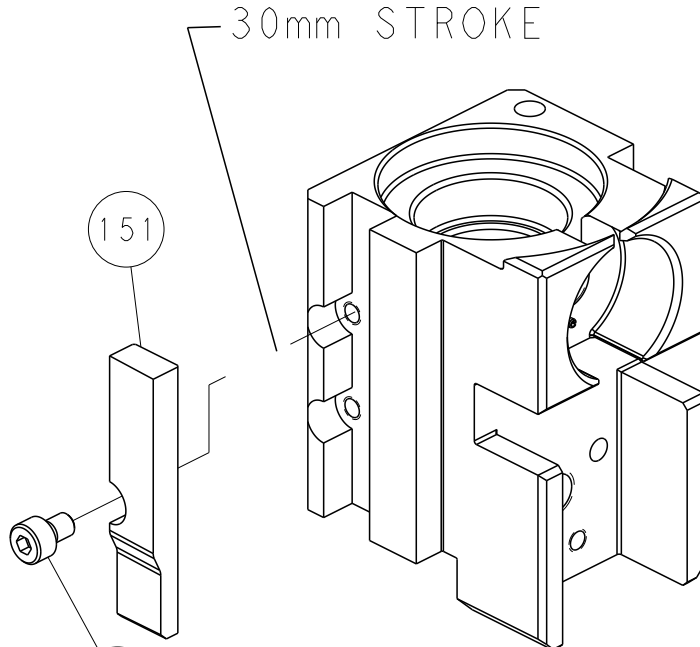
CAM POSITIONS



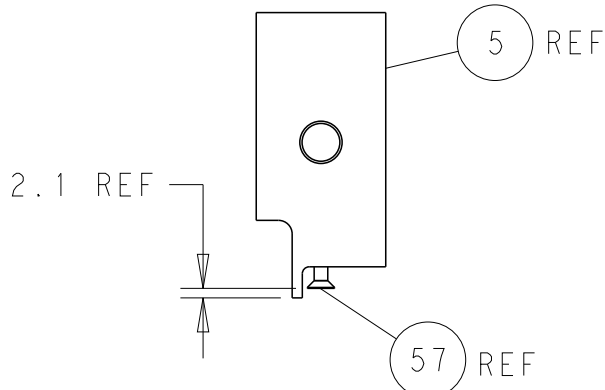
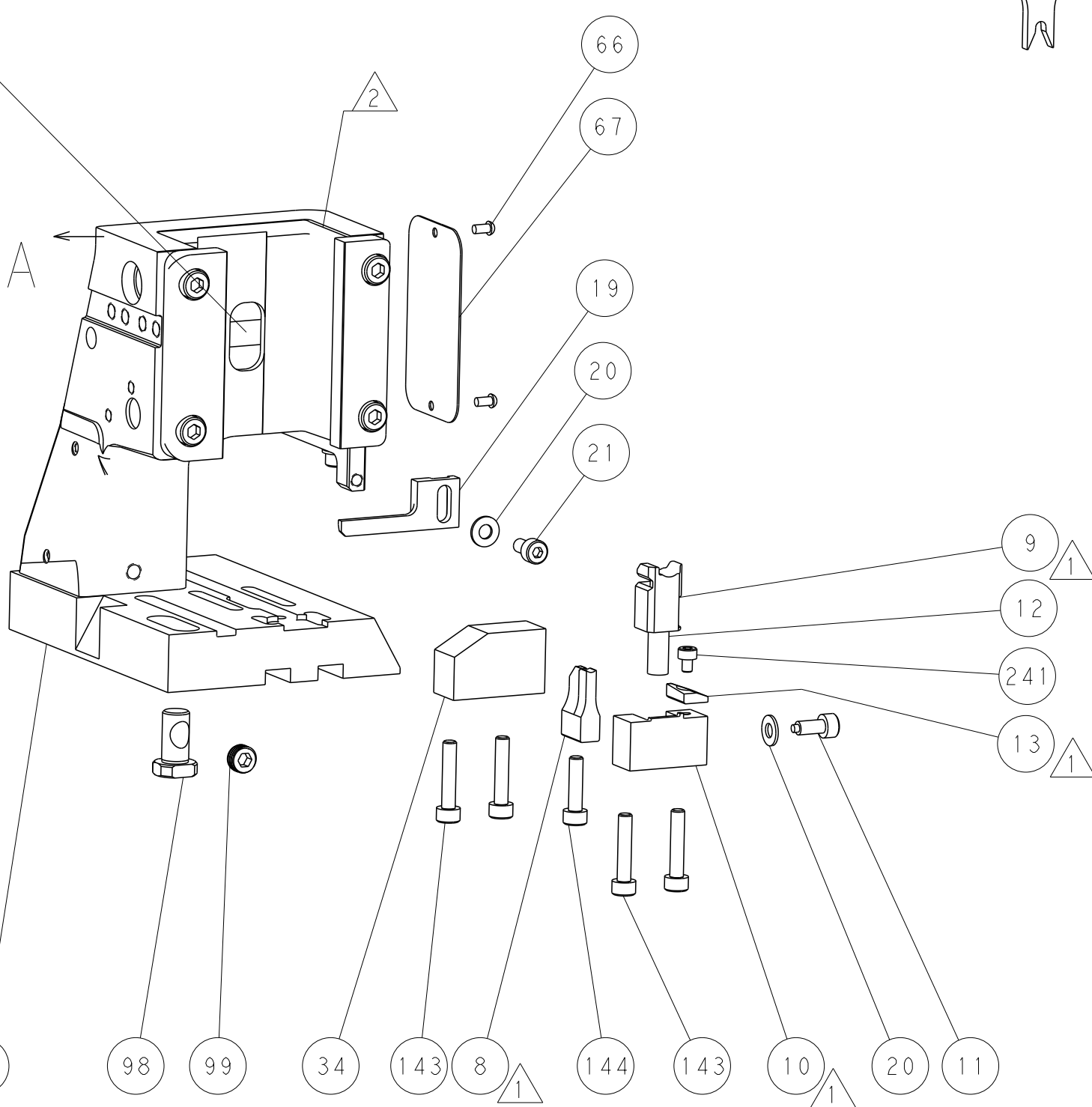
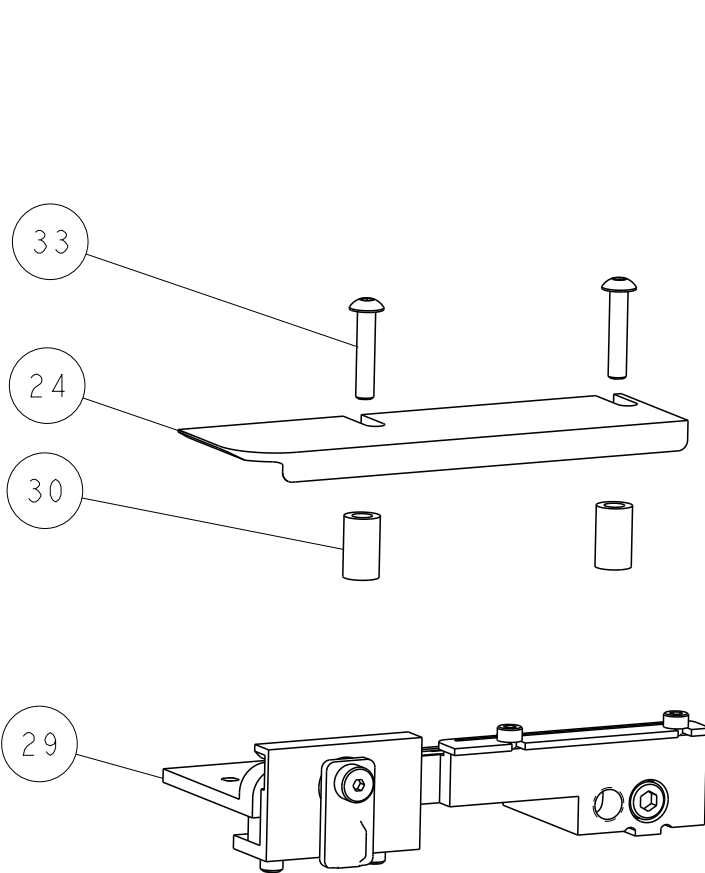
MECHANICAL
POST FEED



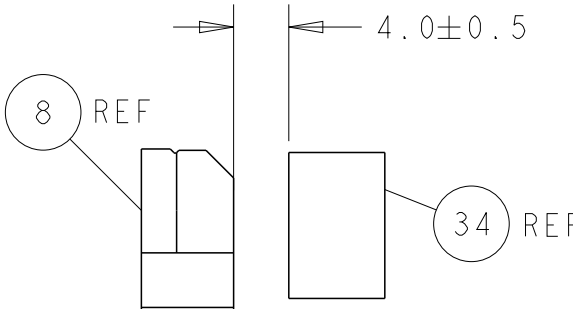
MECHANICAL
PRE FEED



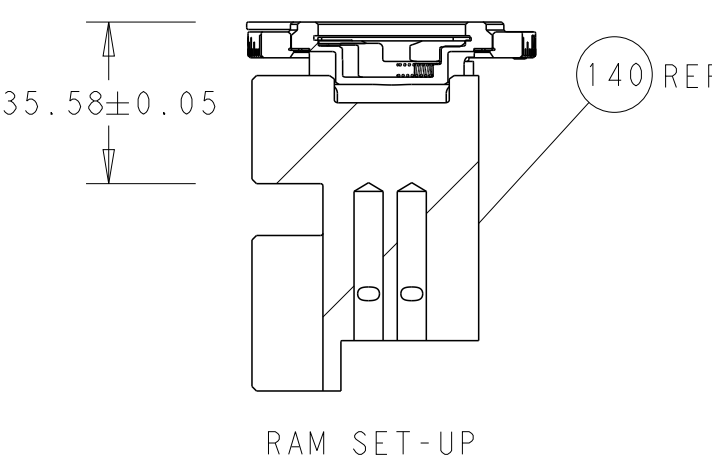
AIR FEED



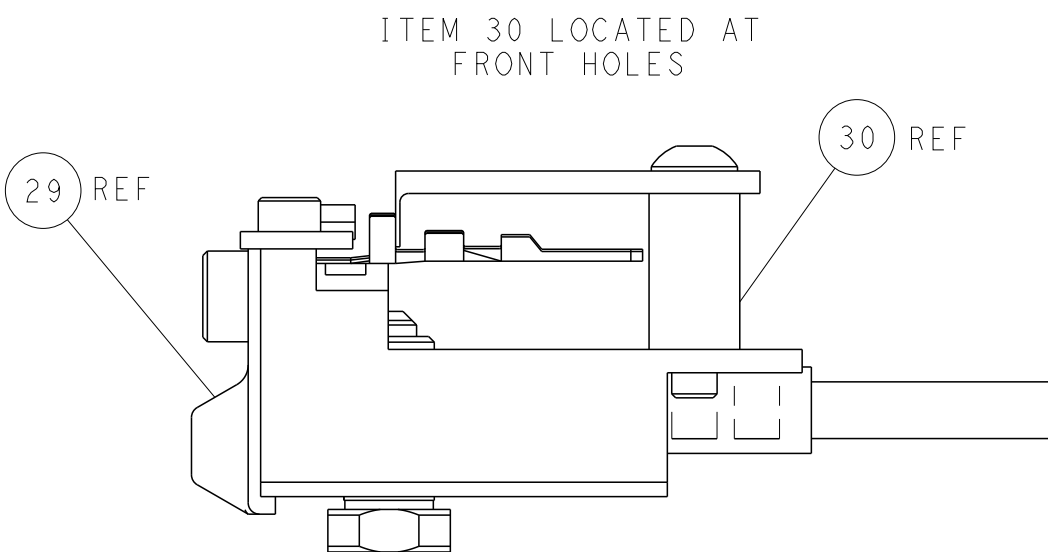
SHEAR DEPRESSOR DETAIL



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)

THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. THE USER SHALL BE RESPONSIBLE FOR VERIFYING THE LATEST VERSION OF THE DRAWING. IF A CHANGE IS REQUIRED, THE USER SHALL CONTACT THE ORGANIZATION THAT ISSUED THE DRAWING.				OWN	7SEP2015		 TE Connectivity Harrisburg, PA 17105-3608			
DIMENSIONS:				CHK	7SEP2015					
mm				APVD	7SEP2015		NAME			
TOLERANCES UNLESS OTHERWISE SPECIFIED:				PRODUCT SPEC			Ocean Side Feed Applicator			
0 PLC ±				APPLICATION SPEC						
1 PLC ±				WEIGHT			SIZE			
2 PLC ±				MATERIAL			CAGE CODE			
3 PLC ±				FINISH			DRAWING NO			
4 PLC ±				SCALE			RESTRICTED TO			
ANGLES				1:2			SHEET			
Customer Accessible Production Drawing				4			OF			
				REV			B1			

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

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