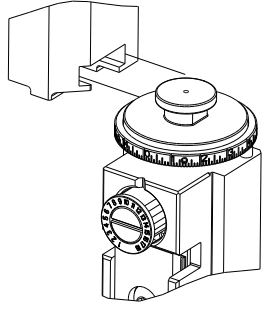


8		7	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2836329-2	E	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2836329-2	E	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2836329-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.97 mm [.117]	F
INSUL	5.08 mm [.200]	O
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: YAZAKI TERMINAL YAZAKI CRIMP SPECIFICATION			
TERMINAL NAME: 6.3 SYSTEM SEALED CONNECTOR, FEMALE TERMINAL			
WIRE STRIP LENGTH 5.00-5.50 mm [.197-.217 IN]		TERMINAL INSULATION DIAMETER RANGE Ø 2.1-3.0mm [.083-.118 IN]	
TERMINAL APPLICATION SPECIFICATION	YZK Rev WA2279	-	-
TERMINALS APPLIED			
TE TERMINAL	YAZAKI TERMINAL	TE SEAL	YAZAKI SEAL
1572591-1	7116-4141-02	1572593-1	7158-3082-90
1572592-1	7114-4141-02		
			SEAL INSULATION DIAMETER RANGE 2.1-3.0 mm

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING
2.50mm2		1.95+/-0.05 [.077+/- .002]		6.5
2.00mm2		1.75+/-0.05 [.069+/- .002]		8.9
1.50mm2		1.60+/-0.05 [.063+/- .002]		10.6



- 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.
- TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- 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.
- FEED ADJUSTMENT NECESSARY WHEN CHANGING TERMINALS.

9. 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)

2		1							
LOC	DIST	REVISIONS							
A	66	P	LTR	DESCRIPTION			DATE	DWN	APVD
		B		ECR-17-006333			04MAY2017	TB	CT
		C		ECR-19-002245			13FEB2019	FJ	YY
		D		ECR-19-009816			24JUN2019	TB	GB
		E		ECR-21-006610			01JUL2021	FZ	TE

3	-	1	1	1633782-4	FENCE	267
	-	1	1	1803078-1	SPACER, PRECISION	259
	-	1	1	2119641-1	FEED CAM, AIR FEED	248
	-	1	1	2119082-1	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	1	2844940-1	AIR FEED MODULE	238
7	-	REF	REF	994970-2	COUNTER, MAGNETIC	164
	-	1	1	1803078-2	SPACER, PRECISION	120
	-	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	1-690438-0	FRONT STRIP GUIDE	96
	-	1	1	455888-7	SPACER, CRIMPER	82
	-	2	2	2079383-4	SCR, BHSC, RoHS (M4 X 8)	79
6	-	1	1	1803096-1	EXTENSION PLATE	78
	-	1	1	1803607-3	DOCUMENTATION PACKAGE	71
	-	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	1-2168083-3	SCR, SKT HD CAP, RoHS, M3 X 16	57
	-	1	1	1338683-8	FEED PAWL	56
1	-	4	4	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	54
	-	2	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	53
	-	2	2	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	1-1803583-7	APPLICATOR BASIC ASSEMBLY, SF	46
	-	1	1	1803515-2	RAM ASSEMBLY, SF ATLANTIC	44
1	-	1	1	1803602-2	SCR, BHSC, RoHS (M8 X 40)	41
	-	1	1	3-1752356-4	SUPPORT, TERMINAL	34
	-	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
	-	2	2	2-2844962-1	SPACER, CYLINDRICAL, STRIP GUIDE	30
	-	1	1	2844992-5	ASSEMBLY, STRIP GUIDE	29
	-	1	1	1-455888-0	SPACER, CRIMPER	28
	-	2	2	22283-1	SPRING, COMPRESSION	27
	-	1	1	240792-1	DRAG, TERMINAL	25
1	-	1	1	1320928-4	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	4-22280-7	SPRING, COMPRESSION	12
	-	1	1	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	11
	-	1	1	2-2119805-0	SHEAR HOLDER, FRONT	10
1	-	1	1	318059-9	FLOATING SHEAR, FRONT	9
	1	2	1	2-1803252-5	ANVIL, COMBINATION	8
	-	-	-	-	-	7
	-	-	-	-	-	6
	-	1	1	1-1803080-6	DEPRESSOR, SHEAR	5
	-	1	1	238011-4	BLOCK, CRIMPER SPACER	4
	1	2	1	3-2119784-4	CRIMPER, INSULATION O PREMIUM	3
	-	1	1	1-455888-2	SPACER, CRIMPER	2
1	2	1	9-1633305-0	CRIMPER, WIRE PREMIUM	1	

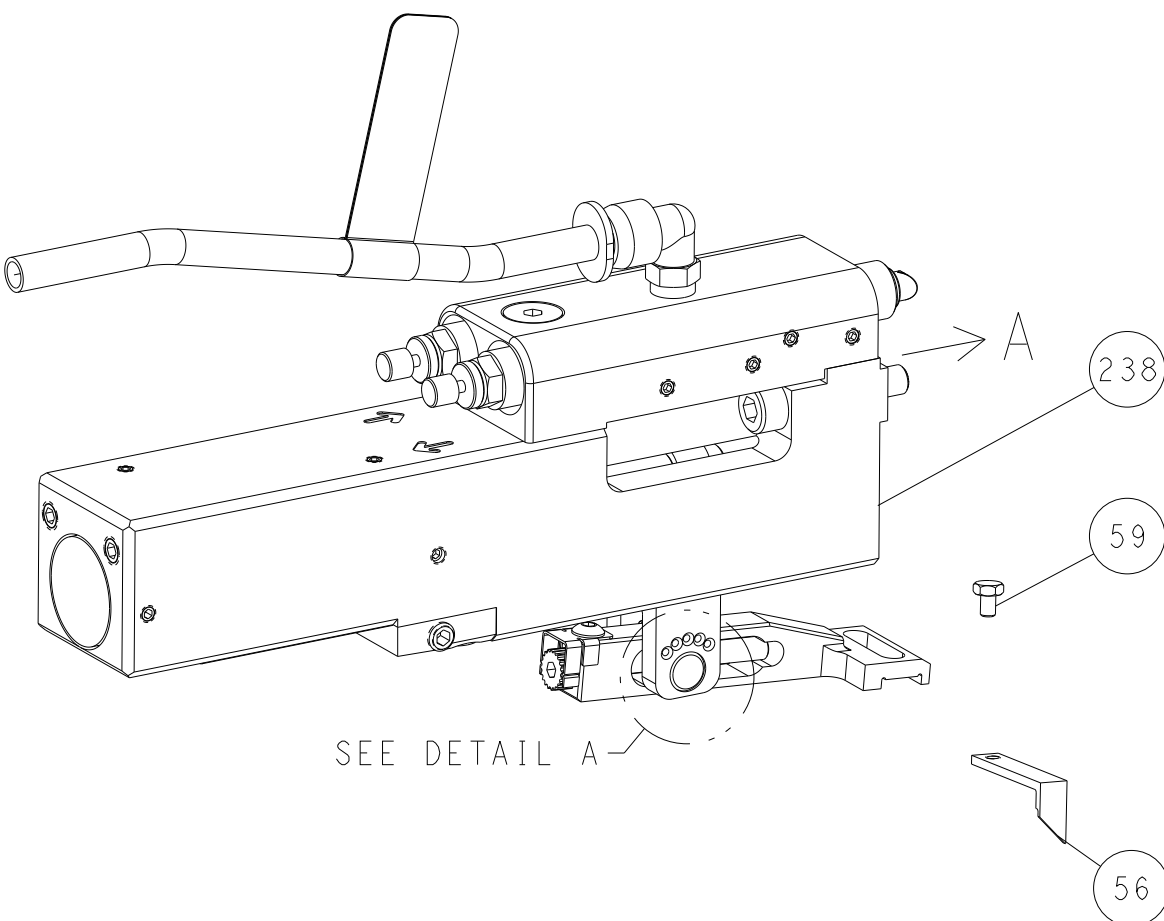
-77-72	-2	PART NO	DESCRIPTION	ITEM NO
		DWN M. RILEY CHK T. ELBIN APVD J. DEGRANGE	TE Connectivity Harrisburg, PA 17105-3608	
		NAME	Ocean Side Feed Applicator	
		PRODUCT SPEC		
		APPLICATION SPEC		
		SIZE	CAGE CODE	DRAWING NO
		A1	00779	©=2836329
		RESTRICTED TO		
		Customer Accessible Production Drawing	SCALE	1:2
		SHEET	1	OF 4
		REV	E	

SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

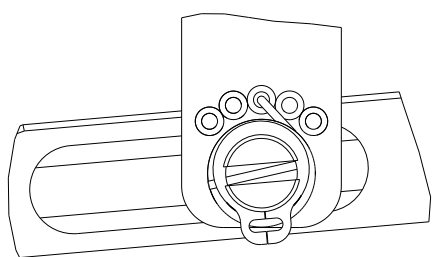
LOC	DIST	REVISIONS					
		P	LYR	DESCRIPTION	DATE	DWN	APVD
A	66	-	-	SEE SHEET 1	-	-	-

FEED TYPE

PNEUMATIC

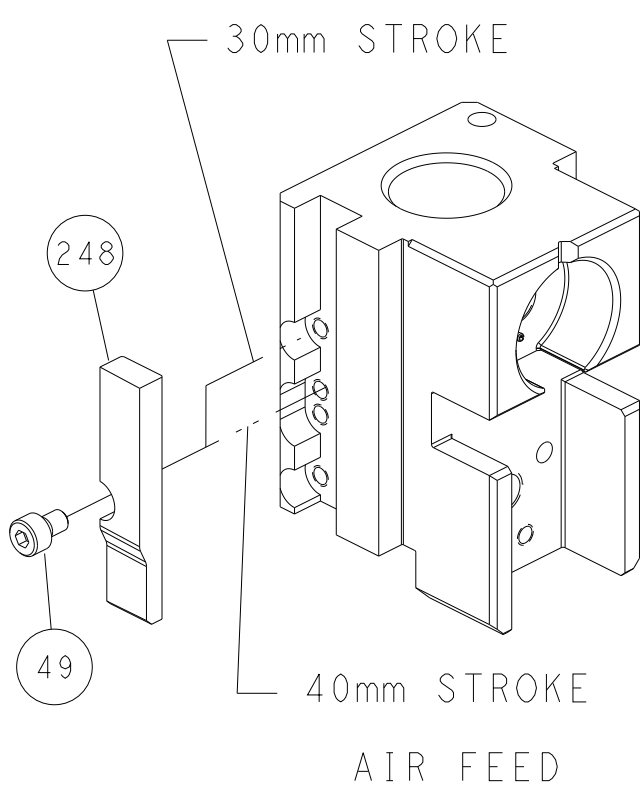


FEED SPRING SETTING POSITION
(SHOWN FROM REAR SIDE)

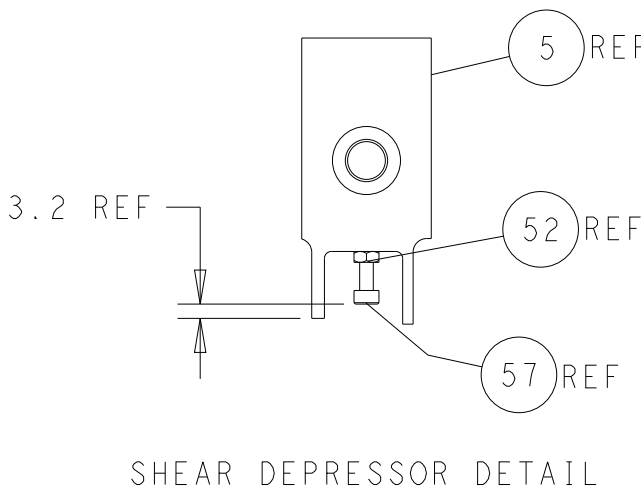


DETAIL A

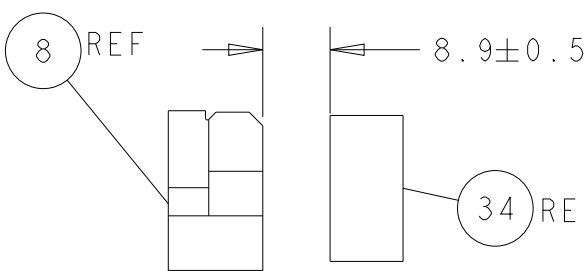
CAM POSITION



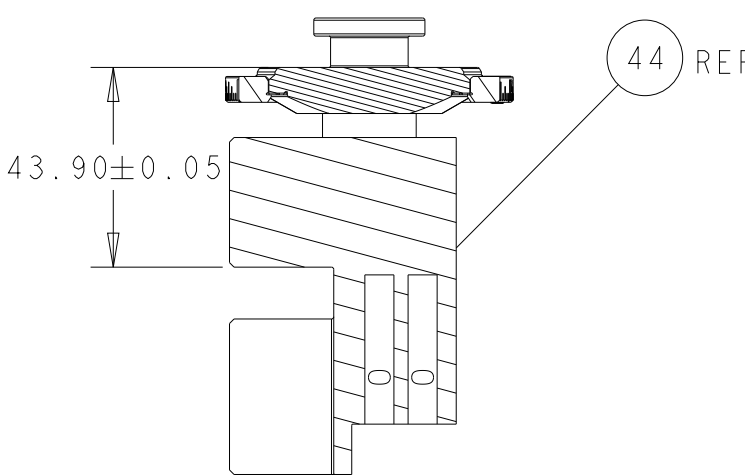
AIR FEED



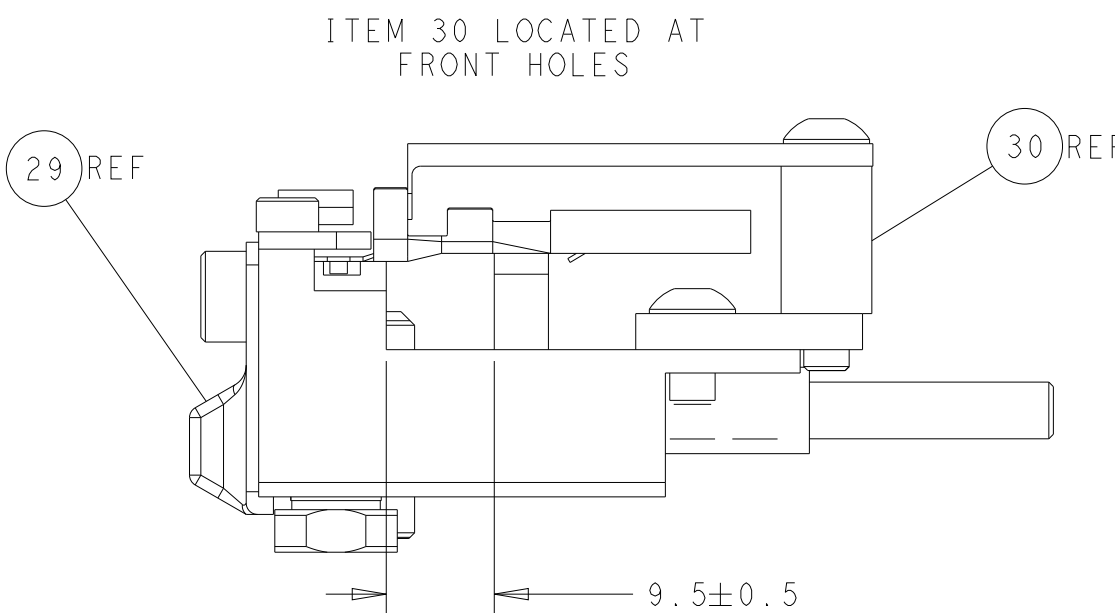
SHEAR DEPRESSOR DETAIL



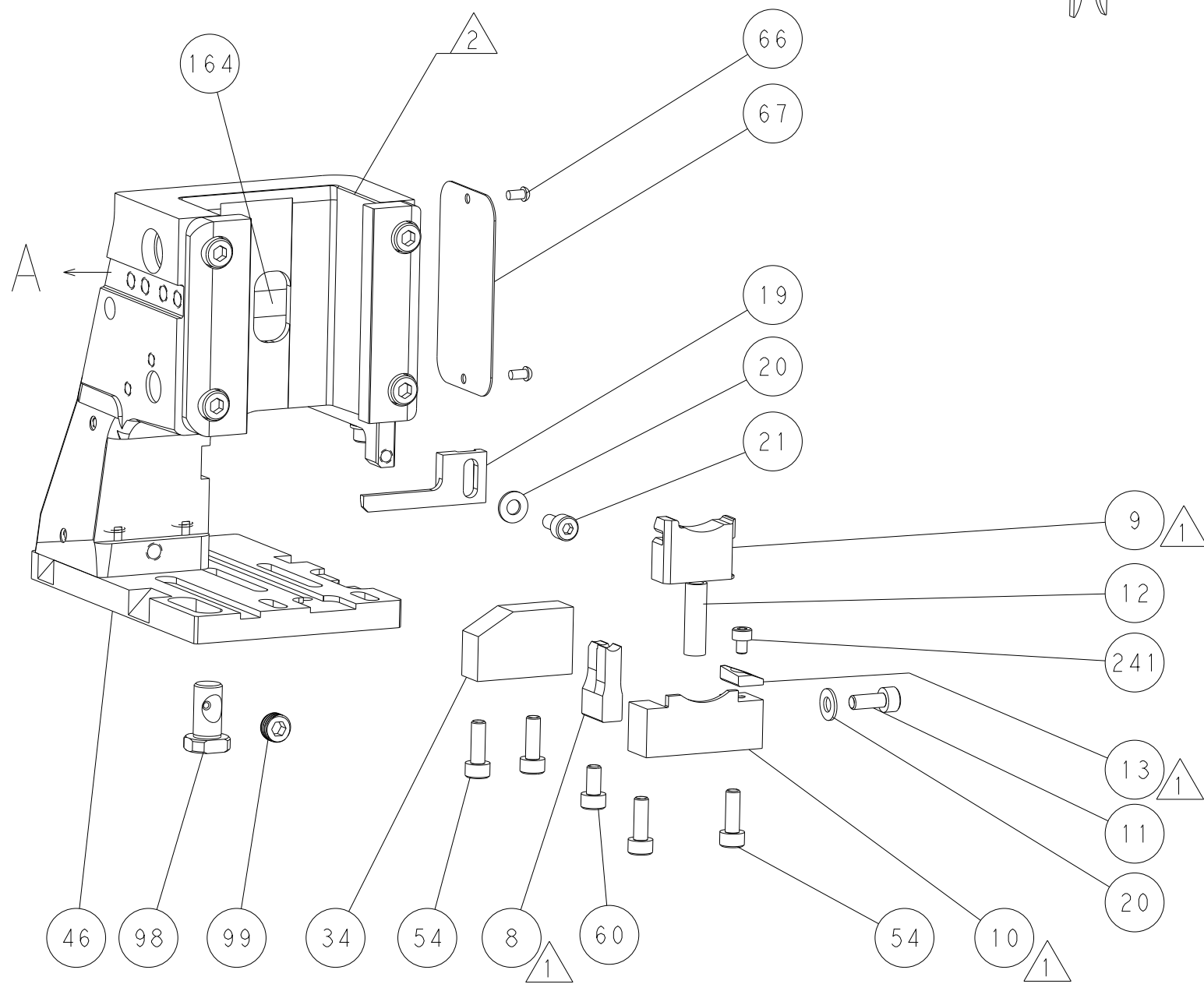
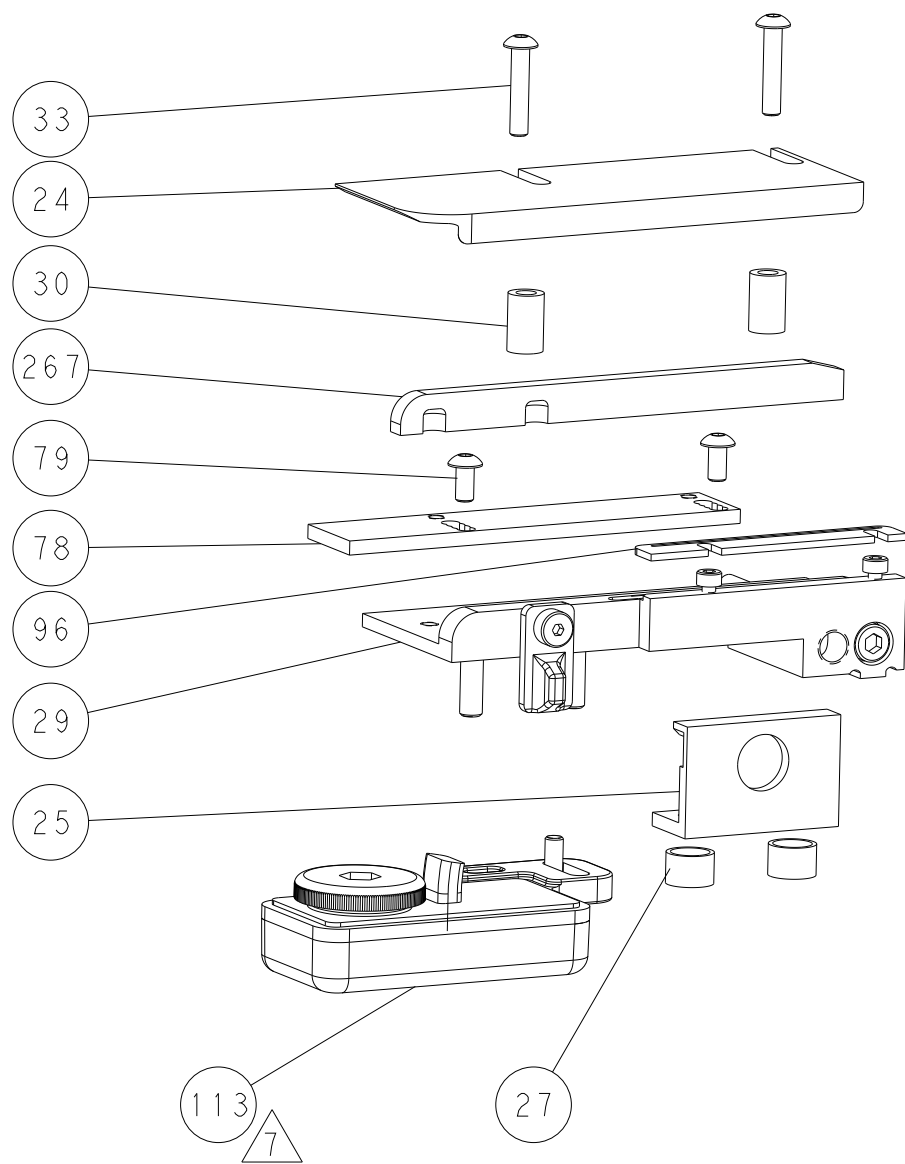
TERMINAL SUPPORT LOCATION



RAM SET-UP



FEED TRACK POSITION
GUIDE BY INSULATION BARREL



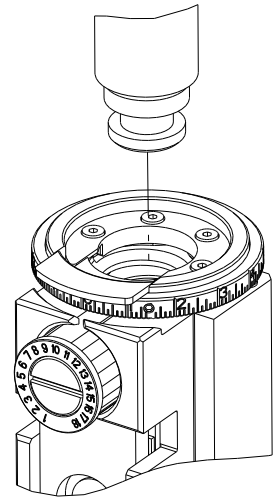
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO COMPANY CONTROL AND DISTRIBUTION ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST EDITION.		OWN M. RILEY CHK T. ELBIN APVD J. DEGRANGE	10JUN2016 10JUN2016 10JUN2016	TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.1 1 PLC ±.1 2 PLC ±.1 3 PLC ±.1 4 PLC ±.1 ANGLES ±.1 FINISH		NAME Ocean Side Feed Applicator	
MATERIAL -		WEIGHT -		SIZE A1	
				CAGE CODE 00779	
				DRAWING NO. 2836329	
				RESTRICTED TO -	
				Customer Accessible Production Drawing	
				SCALE 1:2	
				SHEET 2	
				OF 4	
				REV E	

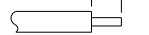
SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

8		7	
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20		20	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2836329-2	E	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2836329-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.97 mm [.117]	F
INSUL	5.08 mm [.200]	O
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: YAZAKI TERMINAL		YAZAKI CRIMP SPECIFICATION	
TERMINAL NAME: 6.3 SYSTEM SEALED CONNECTOR, FEMALE TERMINAL			
WIRE STRIP LENGTH 5.00-5.50 mm [.197-.217 IN]			TERMINAL INSULATION DIAMETER RANGE Ø 2.1-3.0mm [.083-.118 IN]
TERMINAL APPLICATION SPECIFICATION		YZK Rev WA2279	-
		-	-
TERMINALS APPLIED 			
TE TERMINAL	YAZAKI TERMINAL	TE SEAL	YAZAKI SEAL
1572591-1	7116-4141-02	1572593-1	7158-3082-90
1572592-1	7114-4141-02		

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING
2.50mm2		1.95+/-0.05 [.077+/-0.002]		6.5
2.00mm2		1.75+/-0.05 [.069+/-0.002]		8.9
1.50mm2		1.60+/-0.05 [.063+/-0.002]		10.6



- 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.
- TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- 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.
- FEED ADJUSTMENT NECESSARY WHEN CHANGING TERMINALS.
9. 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)

2		1					
LOC	DIST	REVISIONS					
A	66	P	LTR	DESCRIPTION	DATE	DWN	APVD
		-		SEE SHEET 1	-	-	-

3	-	1	1633782-4	FENCE	267
	-	1	1803078-1	SPACER, PRECISION	259
	-	1	2119082-1	CAM, SNAIL, INSULATION ADJUSTMENT	244
	-	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
7	-	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	1-1803583-8	APPLICATOR BASIC ASSEMBLY, SF	141
	-	1	1803516-2	RAM ASSEMBLY, SF PACIFIC	140
	-	1	1803078-2	SPACER, PRECISION	120
	-	1	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113
	-	1	2844908-1	SCREW, LOCKING	99
	-	1	2844907-1	POST, LOCKING	98
	-	1	1-690438-0	FRONT STRIP GUIDE	96
	-	1	455888-7	SPACER, CRIMPER	82
	6	-	2	2079383-4	SCR, BHSC, RoHS (M4 X 8)
-		1	1803096-1	EXTENSION PLATE	78
-		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	1-2168083-3	SCR, SKT HD CAP, RoHS, M3 X 16	57
-		1	1338683-8	FEED PAWL	56
-		2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	53
-		2	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	1803602-2	SCR, BHSC, RoHS (M8 X 40)	41
-		1	3-1752356-4	SUPPORT, TERMINAL	34
1		-	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)
	-	2	2-2844962-1	SPACER, CYLINDRICAL, STRIP GUIDE	30
	-	1	2844992-5	ASSEMBLY, STRIP GUIDE	29
	-	1	1-455888-0	SPACER, CRIMPER	28
	-	2	22283-1	SPRING, COMPRESSION	27
	-	1	240792-1	DRAG, TERMINAL	25
	-	1	1320928-4	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	2119533-1	STRIPPER, SIDE FEED	19
	-	1	2119806-1	INSERT, SHEAR	13
	-	1	4-22280-7	SPRING, COMPRESSION	12
	-	1	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	11
	-	1	2-2119805-0	SHEAR HOLDER, FRONT	10
	-	1	318059-9	FLOATING SHEAR, FRONT	9
	1	1	2-1803252-5	ANVIL, COMBINATION	8
1	-	-	-	-	7
	-	-	-	-	6
	-	1	1-1803080-6	DEPRESSOR, SHEAR	5
	-	-	238011-4	BLOCK, CRIMPER SPACER	4
	1	1	3-2119784-4	CRIMPER, INSULATION O PREMIUM	3
	-	1	1-455888-2	SPACER, CRIMPER	2
	1	1	9-1633305-0	CRIMPER, WIRE PREMIUM	1
	-	-	-	-	-
	-	-	-	-	-
	-	-	-	-	-

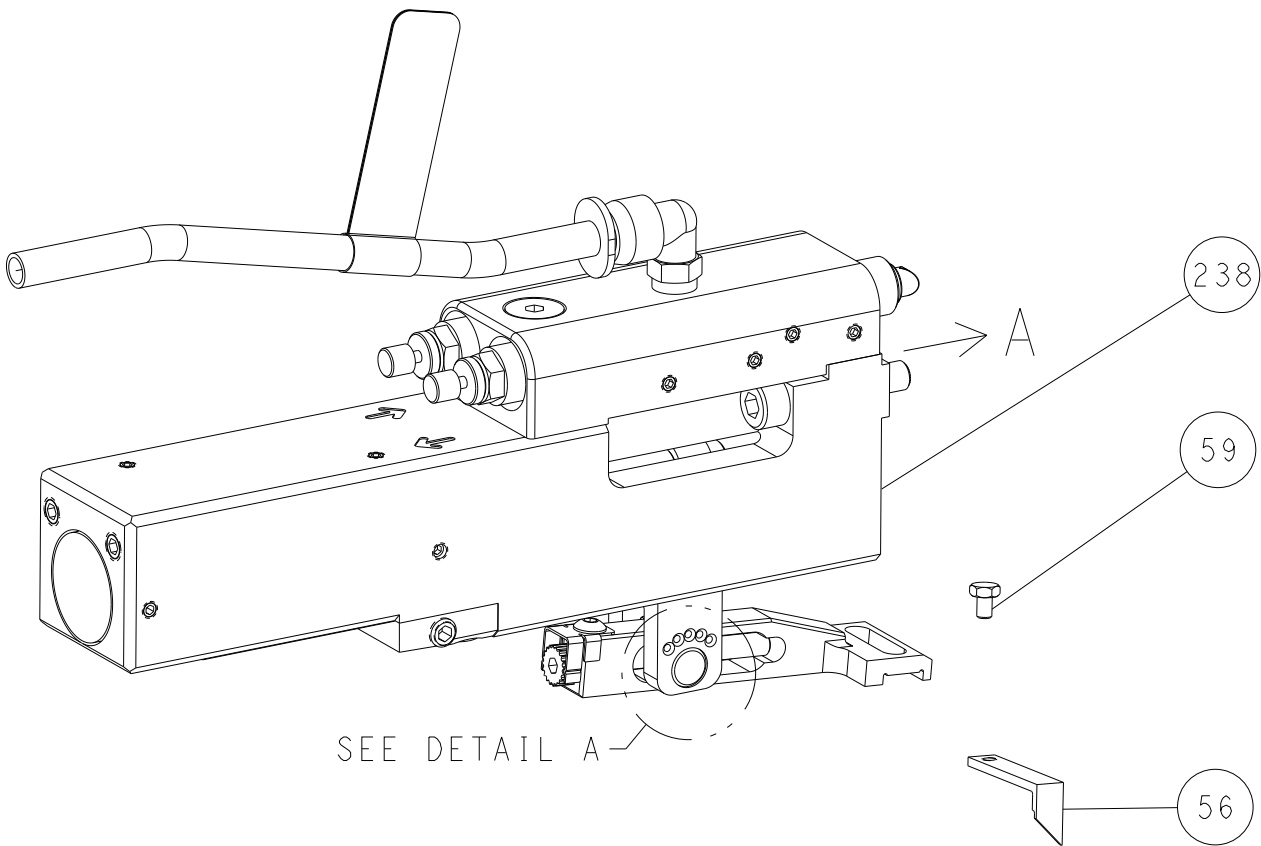
-77	-22	PART NO	DESCRIPTION	ITEM NO
OWN		M. RILEY	10JUN2016	
CHK		T. ELBIN	10JUN2016	
APVD		J. DEGRANGE	10JUN2016	
PRODUCT SPEC		NAME		
APPLICATION SPEC		Ocean Side Feed Applicator		
MATERIAL		SIZE	CAGE CODE	DRAWING NO
-		A1	00779	2836329
WEIGHT		-		
Customer Accessible Production Drawing		SCALE	1:2	SHEET 3 OF 4
		REV	E	

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

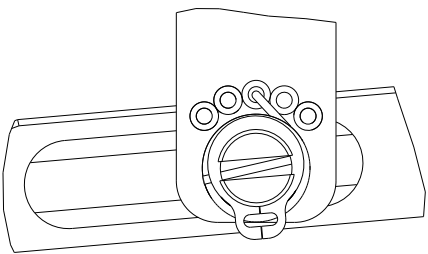
LOC		DIST		REVISIONS			
A	66	P	LTR	DESCRIPTION	DATE	DWN	APVD
		-		SEE SHEET 1	-	-	-

FEED TYPE

PNEUMATIC

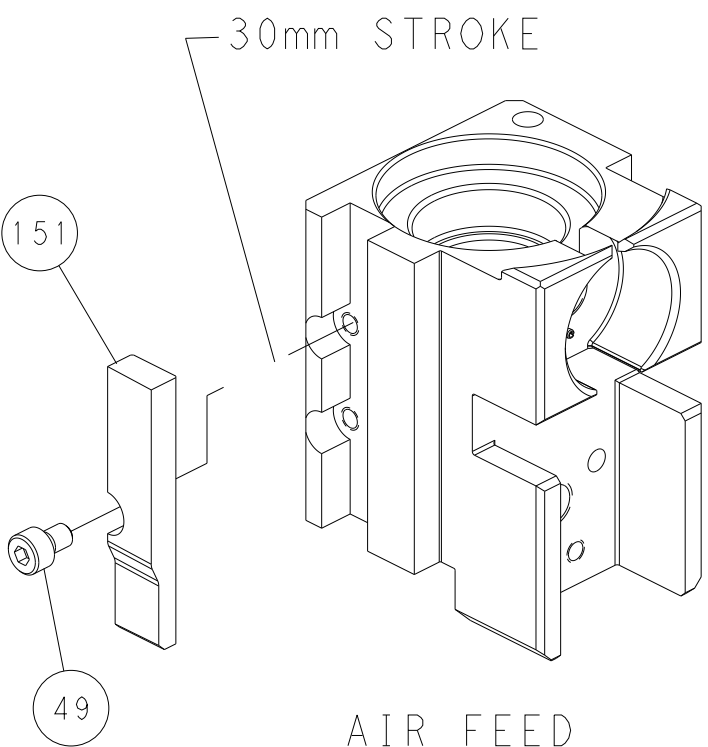


FEED SPRING SETTING POSITION
(SHOWN FROM REAR SIDE)

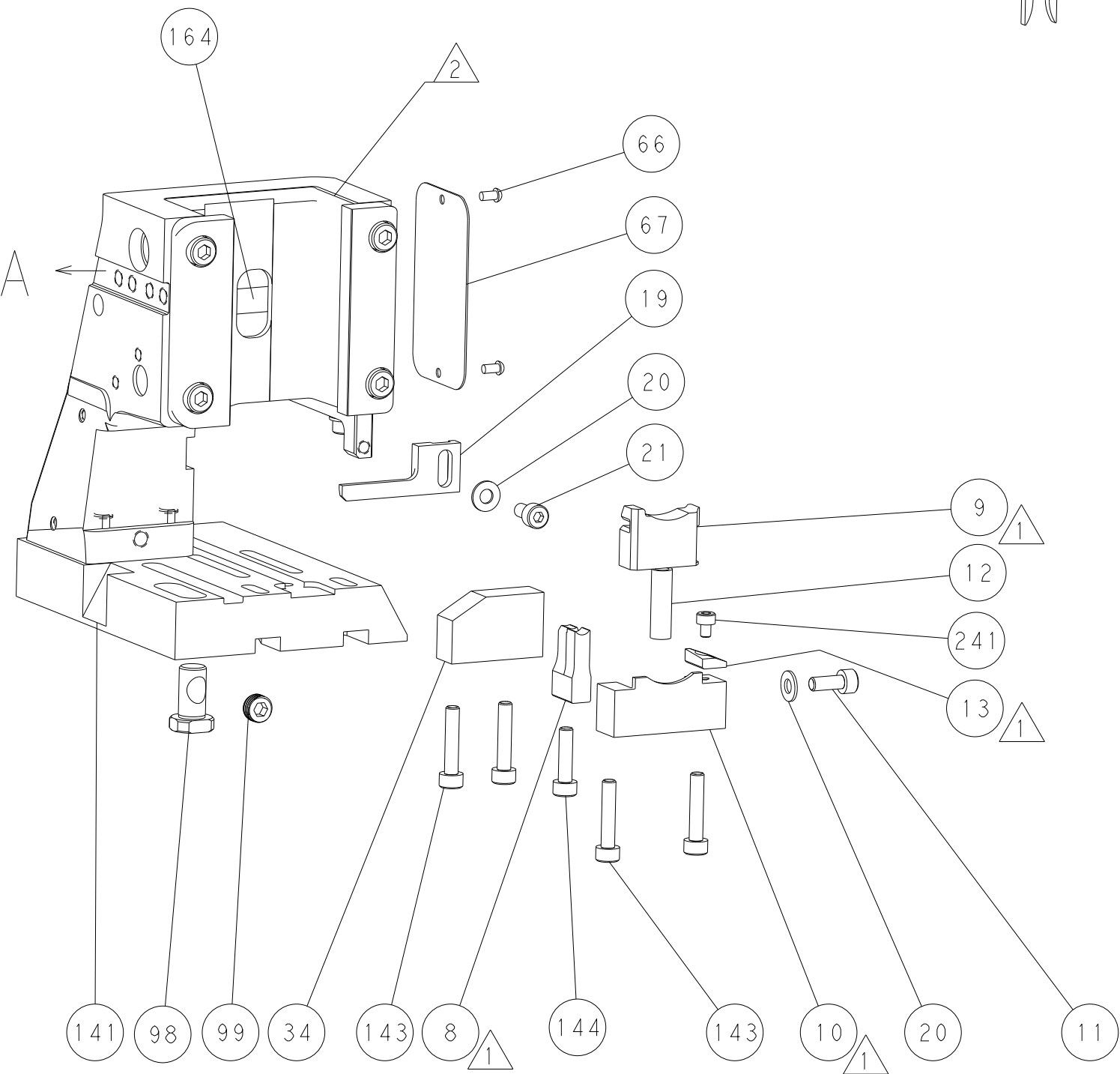
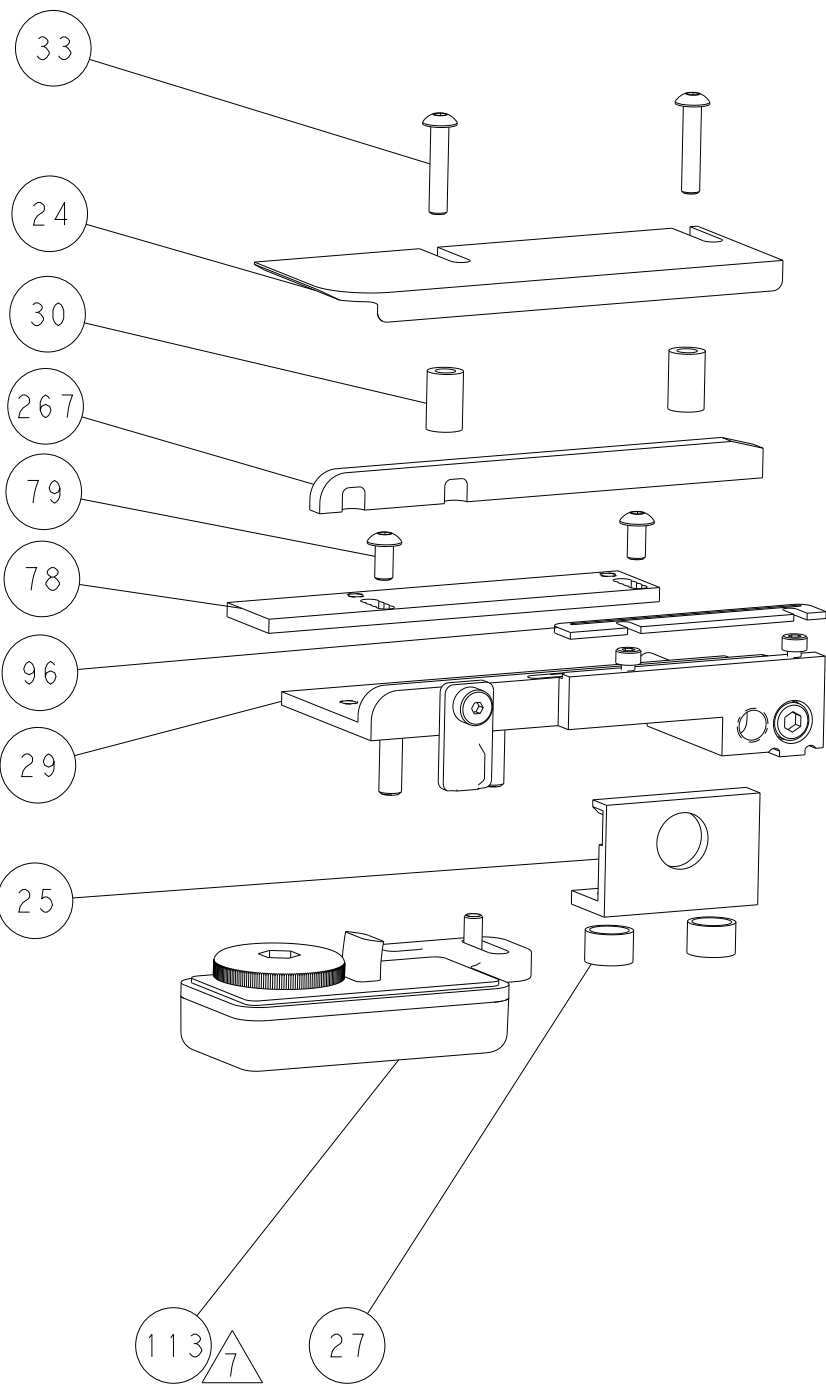


DETAIL A

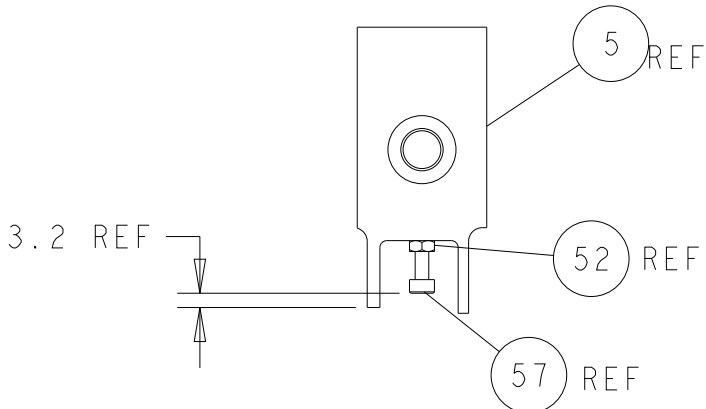
CAM POSITION



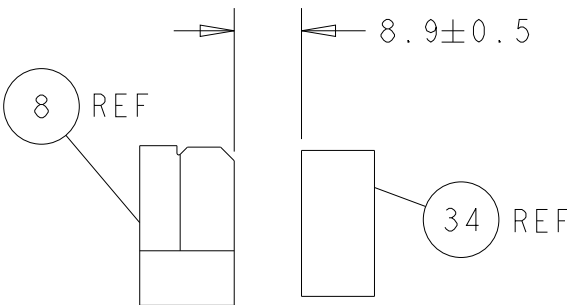
AIR FEED



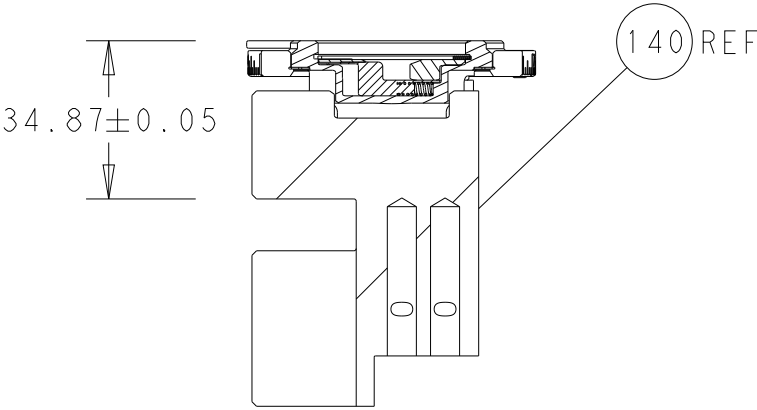
PACIFIC VERSION
Shown on sheets 3 of 4 & 4 of 4
(Atlantic version shown on sheets 1 of 4 & 2 of 4)



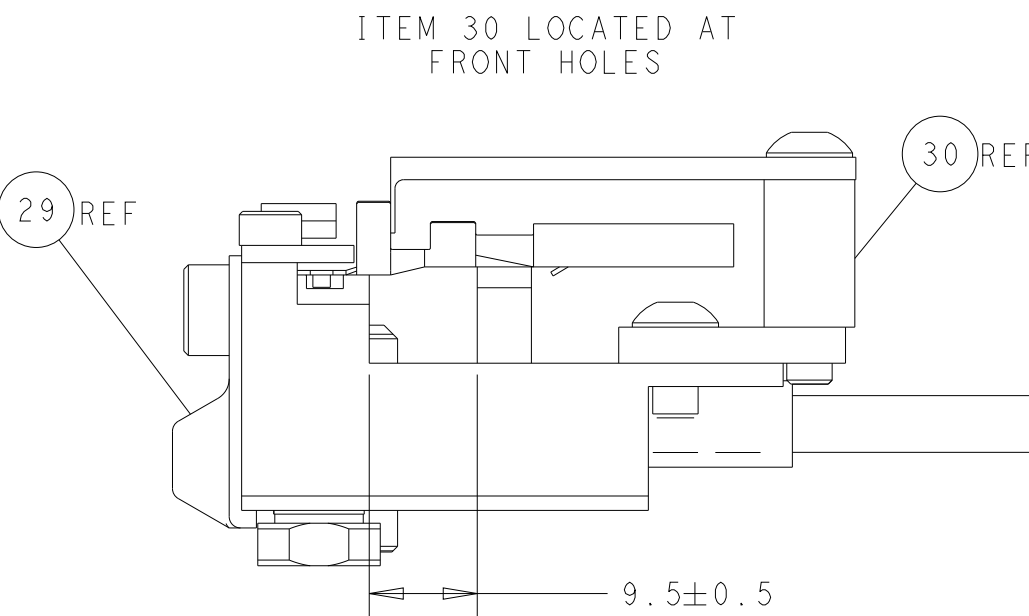
SHEAR DEPRESSOR DETAIL



TERMINAL SUPPORT LOCATION



RAM SET-UP



FEED TRACK POSITION
GUIDE BY INSULATION BARREL

THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION IT IS SUBJECT TO COMPANY CONTROL AND INSISTING ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST VERSION.				DWN	M. RILEY	10JUN2016	 TE Connectivity Harrisburg, PA 17105-3608		NAME	Ocean Side Feed Applicator					
				CHK	T. ELBIN	10JUN2016									
				APVD	J. DEGRANGE	10JUN2016									
				PRODUCT SPEC											
				APPLICATION SPEC											
DIMENSIONS:				TOLERANCES UNLESS OTHERWISE SPECIFIED:							SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO	
mm				0 PLC ±											
				1 PLC ±											
				2 PLC ±											
				3 PLC ±											
				4 PLC ±							A	00779	C=2836329	-	
				ANGLES											
				FINISH											
MATERIAL										Customer Accessible Production Drawing					
										SCALE 1:2					
										SHEET 4 OF 4					
										REV E					

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

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