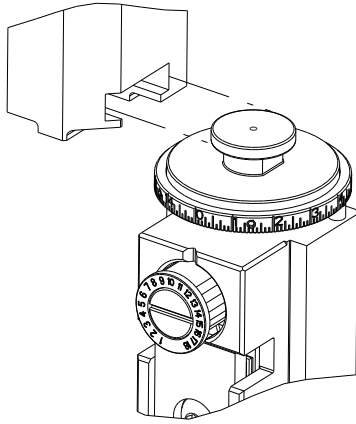


8	7
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20	
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PART NUMBER	REVISION
2836524-1	C
2836524-2	C
7-2836524-1	C
7-2836524-2	C
7-2836524-7	A
DESCRIPTION	FEED TYPE
FINE CRIMP HEIGHT ADJUST	MECHANICAL
FINE CRIMP HEIGHT ADJUST	PNEUMATIC
MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	3.05 mm [.120]	F
INSUL	5.59 mm [.220]	F
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL			
TE CRIMP SPECIFICATION			
TERMINAL NAME: RING TONGUE			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
4.38-5.18 mm [.172-.204 IN]		Ø3.05-4.45 mm [.120-.175 IN]	
TERMINAL APPLICATION SPECIFICATION	114-2084	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
350199-1			

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING
14 AWG		2.08+/-0.05 [.082+/-0.002]		6.5
(2)18		1.98+/-0.05 [.078+/-0.002]		7.7
16 AWG		1.91+/-0.05 [.075+/-0.002]		8.3
18 AWG		1.78+/-0.05 [.070+/-0.002]		9.8



- 1 RECOMMENDED SPARE PARTS
- 2 REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- 3 APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 180. 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.

*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.

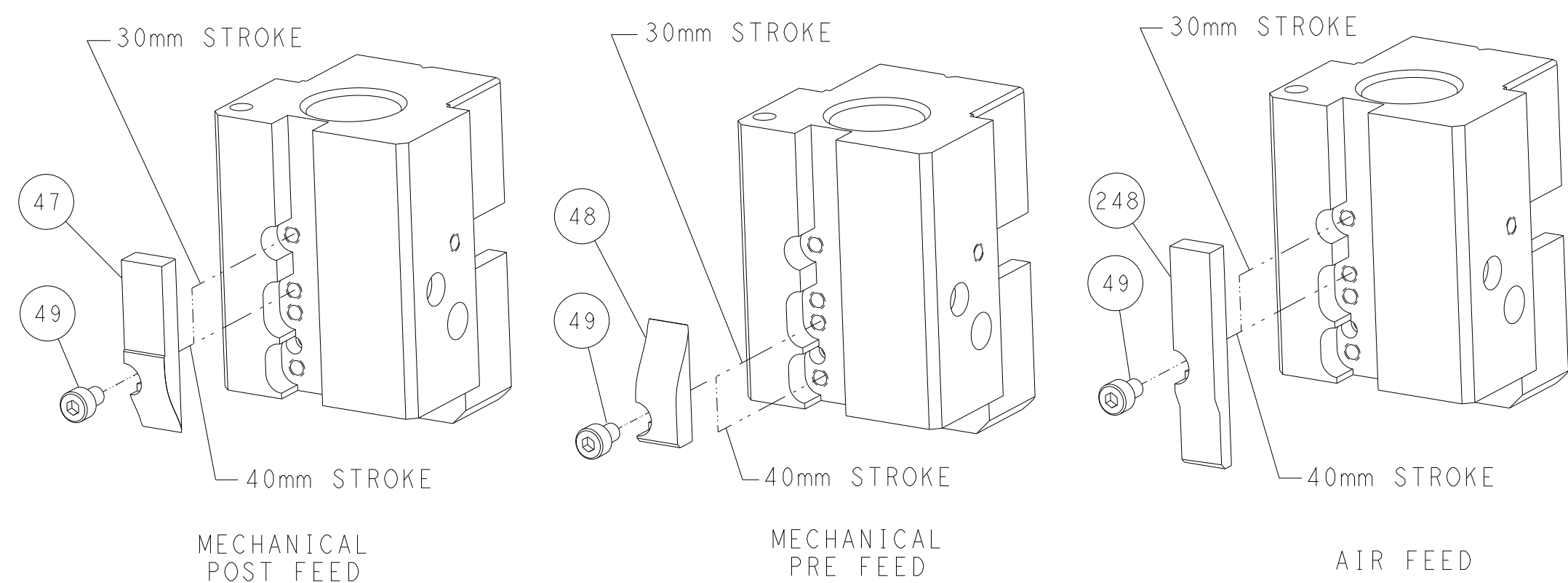
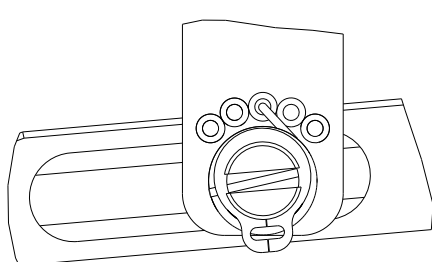
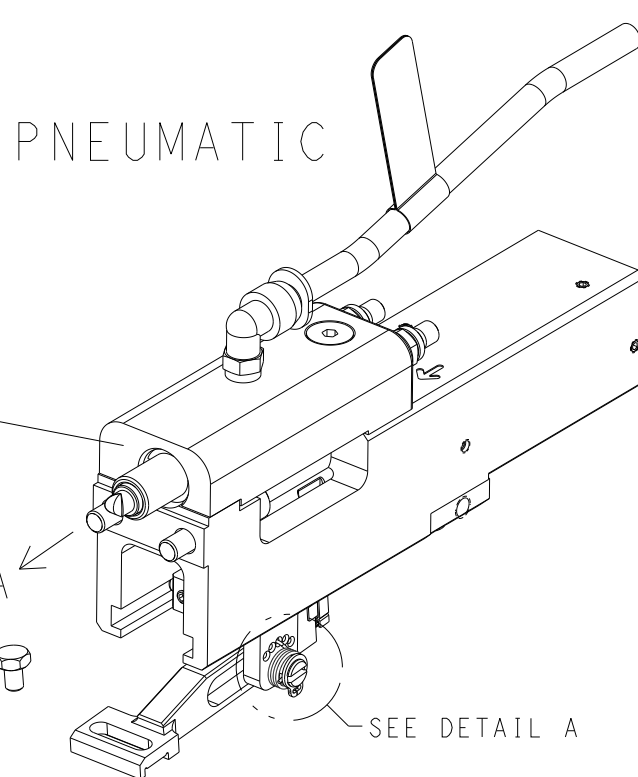
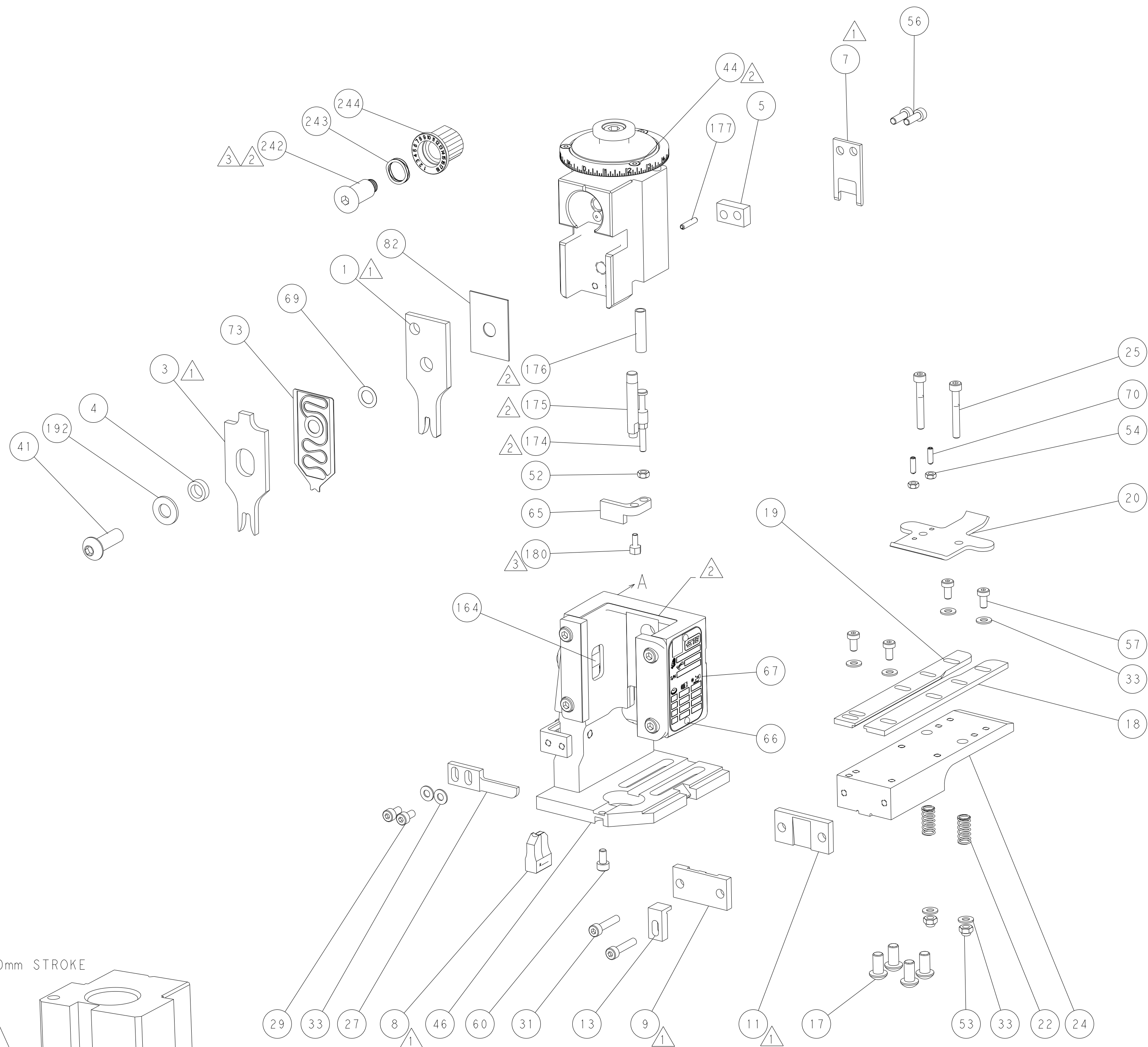
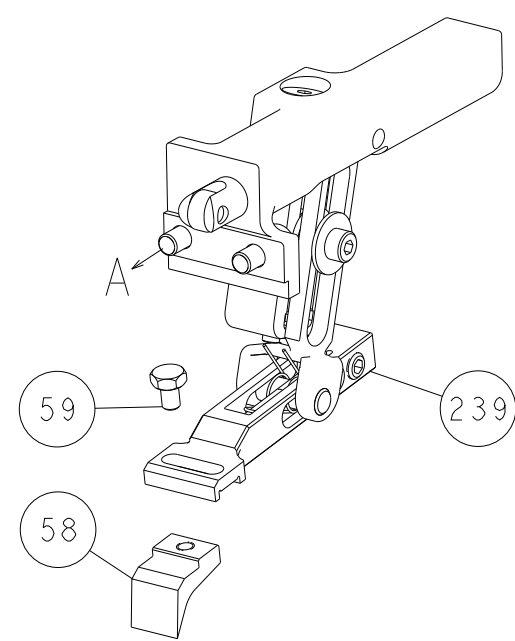
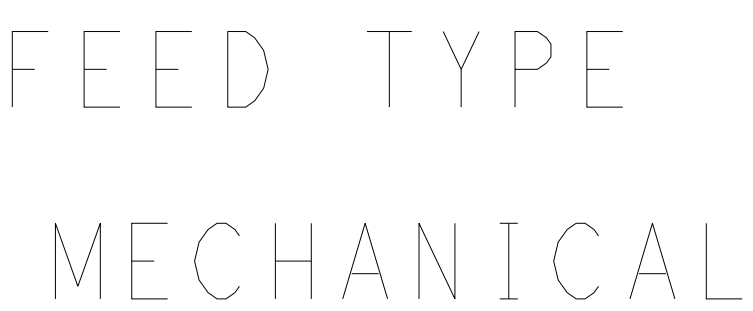
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

LOC	DIST	REVISONS			
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		C		ECR-21-113164	08SEP2021


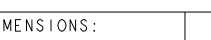
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	-	1	1	1	1	2119082-6	CAM, SNAIL, INSULATION ADJUSTMENT	244
	-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
3	-	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
	-	-	1	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
	-	1	-	1	-	2844940-3	AIR FEED MODULE	238
3	-	1	1	1	1	1-18028-0	WASHER, FLAT, REG M8	192
	-	1	1	1	1	4-1752354-1	STANDOFF,HOLD-DOWN	180
	-	1	1	1	1	6-993111-6	PIN, SLOTTED SPRING 3.0 X 14.0	177
	-	1	1	1	1	8-22280-7	SPRING, COMPRESSION	176
	-	1	1	1	1	1752353-2	GUIDE PIN,HOLDDOWN	175
	-	1	1	1	1	1901680-2	GUIDE PIN,HOLDDOWN	174
	-	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
	-	1	1	1	1	455888-6	SPACER, CRIMPER	82
	-	1	1	1	1	2119791-5	DEPRESSOR, WIRE	73
	-	1	1	1	1	1803607-4	DOCUMENTATION PACKAGE	71
	-	2	2	2	2	2-18032-2	SCR, SET, FLT PNT, M3 X 10.0	70
	-	1	1	1	1	2119943-1	WASHER, SPACER	69
	-	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	1901681-1	HOLDDOWN, TERMINAL	65
	-	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	2063961-1	FEED FINGER	58
	-	4	4	4	4	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57
	-	2	2	2	2	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	56
	-	2	2	2	2	5018030-1	NUT, HEX, REG, RoHS, M3	54
	-	2	2	2	2	986965-8	NUT, LOCK, HEX, TORQUE (M4)	53
	-	1	1	1	1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52
	-	1	-	1	-	2063961-1	FEED FINGER	51
	-	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	2119655-5	APPLICATOR BASIC ASSEMBLY, EF	46
	-	1	1	1	1	1803517-1	RAM ASSEMBLY, EF ATLANTIC	44
	-	1	1	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
	-	8	8	8	8	1-18028-2	WASHER, FLAT, REG M4	33
	-	2	2	2	2	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	31
	-	2	2	2	2	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	29
	-	1	1	1	1	240639-1	STRIPPER (MACHINING)	27
	-	2	2	2	2	1-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 30	25
	-	1	1	1	1	1752371-5	PLATE, STRIP GUIDE	24
	-	2	2	2	2	2-22281-3	SPRING, COMPRESSION	22
	-	1	1	1	1	1803292-4	DRAG	20
	-	1	1	1	1	1-1901696-0	STRIP GUIDE, REAR	19
	-	1	1	1	1	1-1901695-0	STRIP GUIDE, FRONT	18
	-	4	4	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17
	-	1	1	1	1	1752360-1	SPACER,HOLD-DOWN	13
1	-	1	1	1	1	240644-1	PLATE, REAR SHEAR	11
	-	-	-	-	-	-	-	10
1	-	1	1	1	1	690482-4	PLATE, FRONT SHEAR	9
1	1	2	2	1	1	4-1803060-8	ANVIL, COMBINATION, END FEED	8
1	-	1	1	1	1	1-2217206-0	BLADE, SLUG	7
	-	-	-	-	-	-	-	6
	-	1	1	1	1	2-240641-5	SPACER	5
	-	1	1	1	1	4-238011-5	BLOCK, CRIMPER SPACER	4
1	1	2	2	1	1	8-2119582-3	CRIMPER, INSULATION F PREMIUM	3
	-	-	-	-	-	-	-	2
1	1	2	2	1	1	456409-8	CRIMPER, WIRE .120 "F" PREMIUM	1
	-77-72-71-2-1					PART NO	DESCRIPTION	ITEM NO

THE INFORMATION IS CONTAINED HEREIN IS UNCLASSIFIED EXCEPT WHERE SHOWN OTHERWISE. IT IS SUBJECT TO CHANGE WITHOUT NOTICE AND THE CONTROLLING ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST EDITION.				DWN	M. RILEY	25OCT2016	TE Connectivity Harrisburg, PA 17105-3608				
				CHK	C. TOPPER	09DEC2016	NAME				
				APVD	J. DEGRANGE	09DEC2016	Ocean End Feed Applicator				
DIMENSIONS:				TOLERANCES UNLESS OTHERWISE SPECIFIED:		PRODUCT SPEC					
mm				0 PLC ±		APPLICATION SPEC					
				1 PLC ±		SIZE					
				2 PLC ±		CAGE CODE					
				3 PLC ±		DRAWING NO					
				4 PLC ±		RESTRICTED TO					
				ANGLES ±		A1 00779 ©=2836524					
MATERIAL				FINISH		WEIGHT					
-				-		-					
						Customer Accessible Production Drawing					
						SCALE 1:1					
						SHEET 1 of 4					
						REV C					

SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

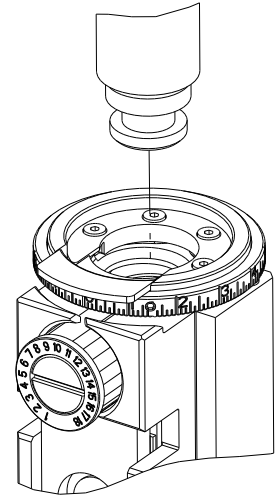


ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)


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DIMENSIONS:		TOLERANCES, UNLESS OTHERWISE SPECIFIED:		NAME	
mm		0 PLC ±.1 1 PLC ±.1 2 PLC ±.1 3 PLC ±.1 4 PLC ±.1 ANGLES ±.1 FINISH		Ocean End Feed Applicator	
		PRODUCT SPEC		SIZE CASE CODE DRAWING NO	
MATERIAL		APPLICATION SPEC		RESTRICTED TO	
-		WEIGHT		A 00779 C = 2836524	
-		Customer Accessible Production Drawing		SCALE 1:1 SHEET 2 of 4 REV C	

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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2836524-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2836524-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2836524-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	3.05 mm [.120]	F
INSUL	5.59 mm [.220]	F
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: RING TONGUE			
WIRE STRIP LENGTH 4.38-5.18 mm [.172-.204 IN]		INSULATION DIAMETER RANGE Ø3.05-4.45 mm [.120-.175 IN]	
TERMINAL APPLICATION SPECIFICATION	 114-2084	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
350199-1			

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING
14 AWG		2.08+/-0.05 [.082+/- .002]		6.5
(2)18		1.98+/-0.05 [.078+/- .002]		7.7
16 AWG		1.91+/-0.05 [.075+/- .002]		8.3
18 AWG		1.78+/-0.05 [.070+/- .002]		9.8



- 1 RECOMMENDED SPARE PARTS
- 2 REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- 3 APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 180.
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.

*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)

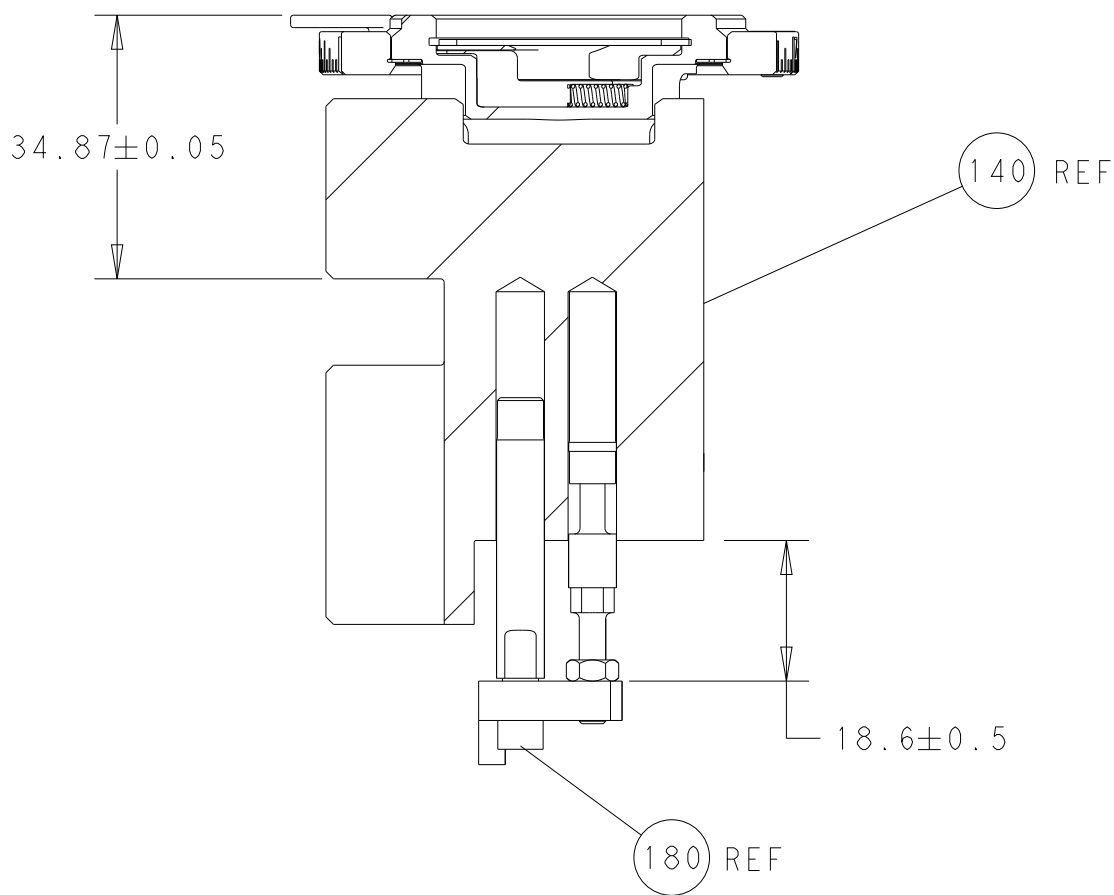
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LOC	DIST	REVISIONS					
A	66	P	LTR	DESCRIPTION	DATE	DWN	APVD
		-		SEE SHEET 1	-	-	-

	-	1	1	2119082-6	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	2119580-1	MECHANICAL FEED ASSEMBLY	239
	-	1	-	2844940-3	AIR FEED MODULE	238
	-	1	1	1-18028-0	WASHER, FLAT, REG M8	192
	-	4	4	2079383-9	SCR, BHSC, RoHS (M6 X 20)	186
3	-	1	1	4-1752354-1	STANDOFF,HOLD-DOWN	180
	-	1	1	6-993111-6	PIN, SLOTTED SPRING 3.0 X 14.0	177
	-	1	1	8-22280-7	SPRING, COMPRESSION	176
	-	1	1	1752353-2	GUIDE PIN,HOLDDOWN	175
	-	1	1	1901680-2	GUIDE PIN,HOLDDOWN	174
	-	REF	REF	994970-2	COUNTER, MAGNETIC	164
	-	1	-	2119641-2	FEED CAM, AIR FEED	152
	-	1	1	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	144
	-	-	1	2119653-2	FEED CAM, POST FEED	142
	-	1	1	2119655-6	APPLICATOR BASIC ASSEMBLY, EF	141
	-	1	1	1803518-1	RAM ASSEMBLY, EF PACIFIC	140
	-	1	1	455888-6	SPACER, CRIMPER	82
	-	1	1	2119791-5	DEPRESSOR, WIRE	73
	-	1	1	1803607-4	DOCUMENTATION PACKAGE	71
	-	2	2	2-18032-2	SCR, SET, FLT PNT, M3 X 10.0	70
	-	1	1	2119943-1	WASHER, SPACER	69
	-	1	1	2119740-1	TAG,IDENTIFICATION	67
	-	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
	-	1	1	1901681-1	HOLDDOWN, TERMINAL	65
	-	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
	-	-	1	2063961-1	FEED FINGER	58
	-	4	4	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57
	-	2	2	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	56
	-	2	2	5018030-1	NUT, HEX, REG, RoHS, M3	54
	-	2	2	986965-8	NUT, LOCK, HEX, TORQUE (M4)	53
	-	1	1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52
	-	1	-	2063961-1	FEED FINGER	51
	-	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
	-	8	8	1-18028-2	WASHER, FLAT, REG M4	33
	-	2	2	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	31
	-	2	2	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	29
	-	1	1	240639-1	STRIPPER (MACHINING)	27
	-	2	2	1-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 30	25
	-	1	1	1752371-5	PLATE, STRIP GUIDE	24
	-	2	2	2-22281-3	SPRING, COMPRESSION	22
	-	1	1	1803292-4	DRAG	20
	-	1	1	1-1901696-0	STRIP GUIDE, REAR	19
	-	1	1	1-1901695-0	STRIP GUIDE, FRONT	18
	-	1	1	1752360-1	SPACER,HOLD-DOWN	13
1	-	1	1	240644-1	PLATE, REAR SHEAR	11
	-	-	-	-	-	10
1	-	1	1	690482-4	PLATE, FRONT SHEAR	9
1	1	1	1	4-1803060-8	ANVIL, COMBINATION, END FEED	8
1	-	1	1	1-2217206-0	BLADE, SLUG	7
	-	-	-	-	-	6
	-	1	1	2-240641-5	SPACER	5
	-	1	1	4-238011-5	BLOCK, CRIMPER SPACER	4
1	1	1	1	8-2119582-3	CRIMPER, INSULATION F PREMIUM	3
	-	-	-	-	-	2
1	1	1	1	456409-8	CRIMPER, WIRE .120 "F" PREMIUM	1
	-77	-22	-21	PART NO	DESCRIPTION	ITEM NO

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DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH		NAME Ocean End Feed Applicator	
		APPLICATION SPEC		SIZE A	
MATERIAL -		WEIGHT -		CAGE CODE 00779	
				DRAWING NO 2836524	
				RESTRICTED TO -	
				Customer Accessible Production Drawing	
				SCALE 1:1	
				SHEET 3 of 4	
				REV C	

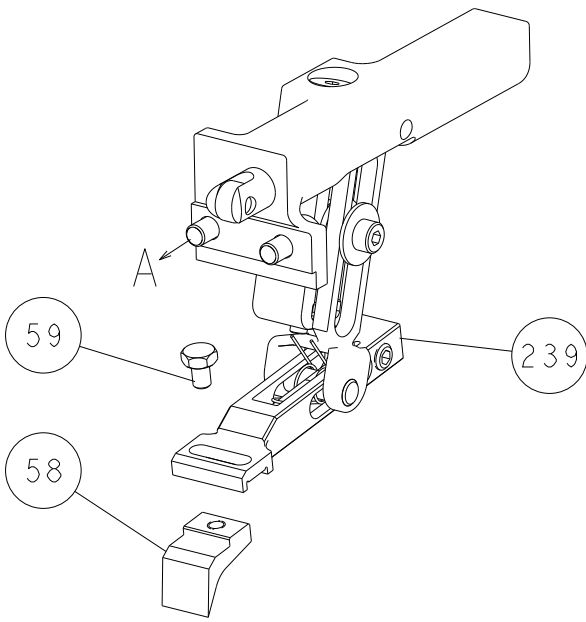
SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

LOC		DIST		REVISIONS			
P	LYR	DESCRIPTION		DATE	DWN	APVD	
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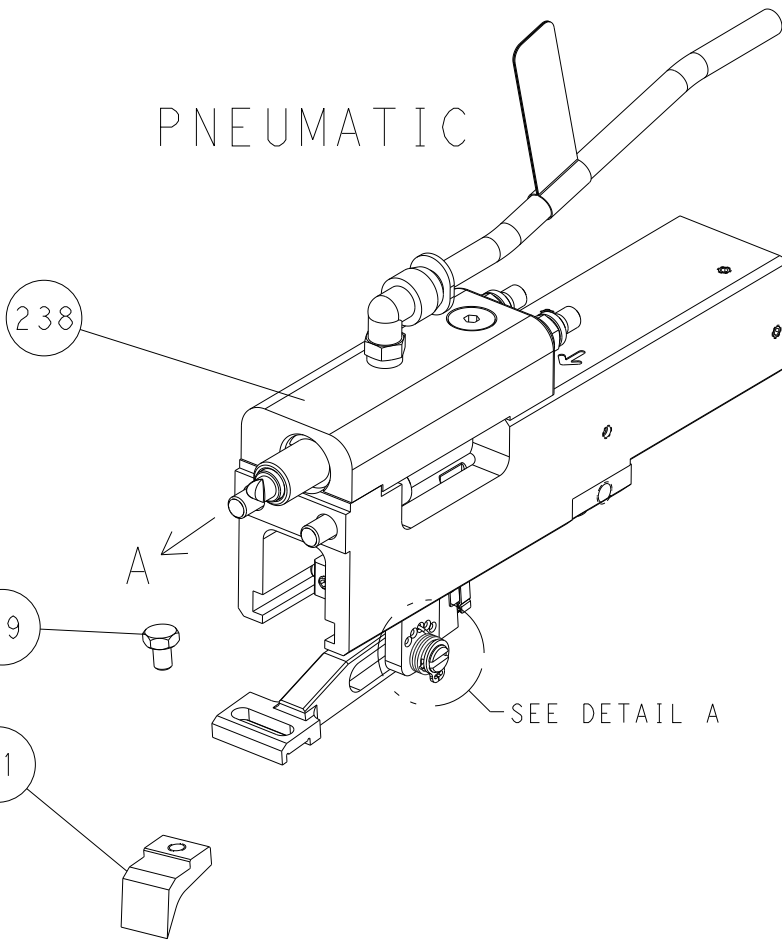


RAM AND HOLDDOWN SET-UP

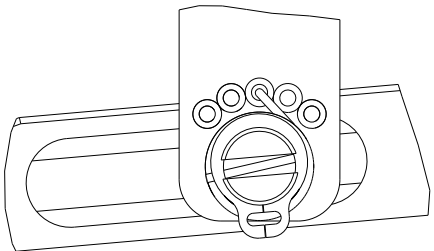
FEED TYPE
MECHANICAL



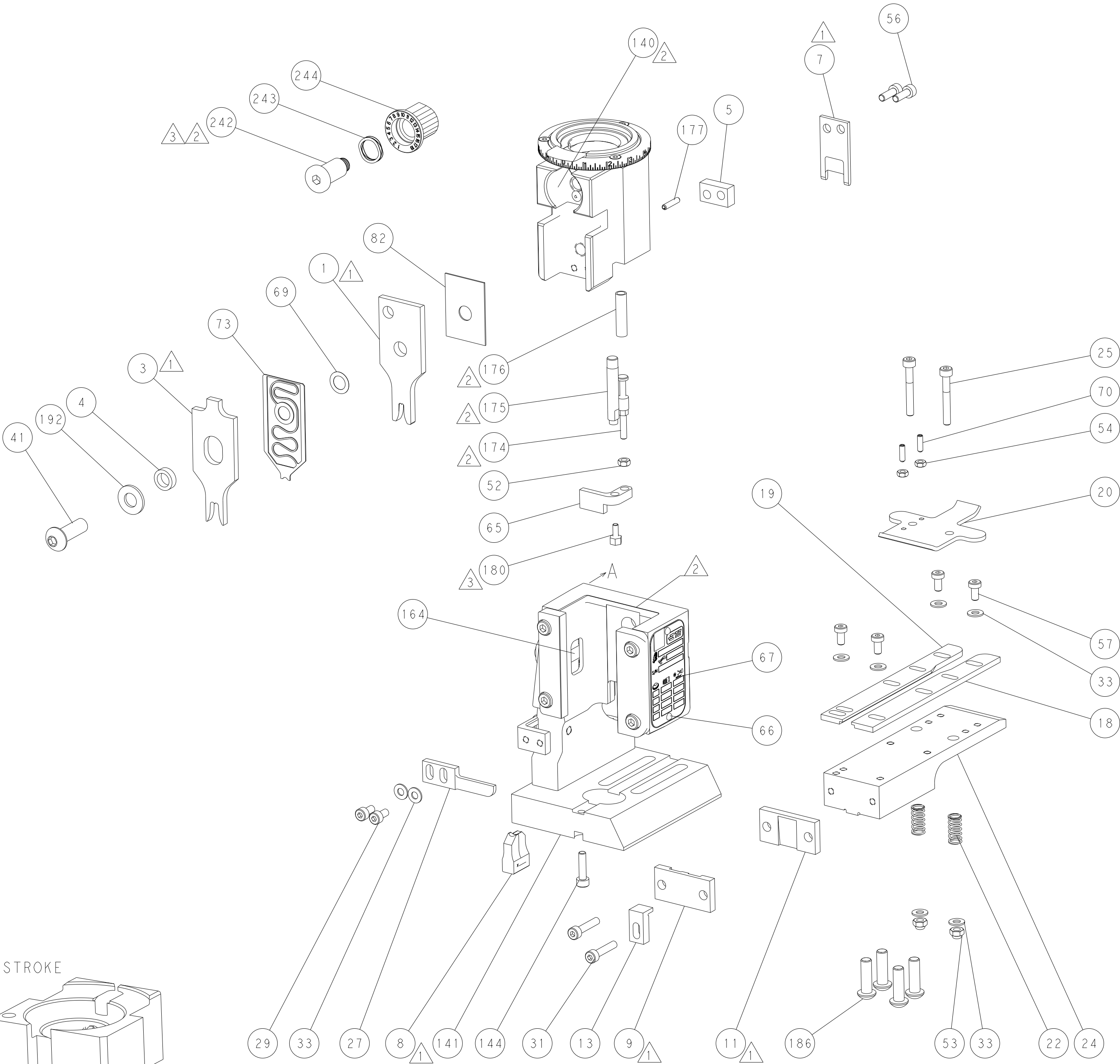
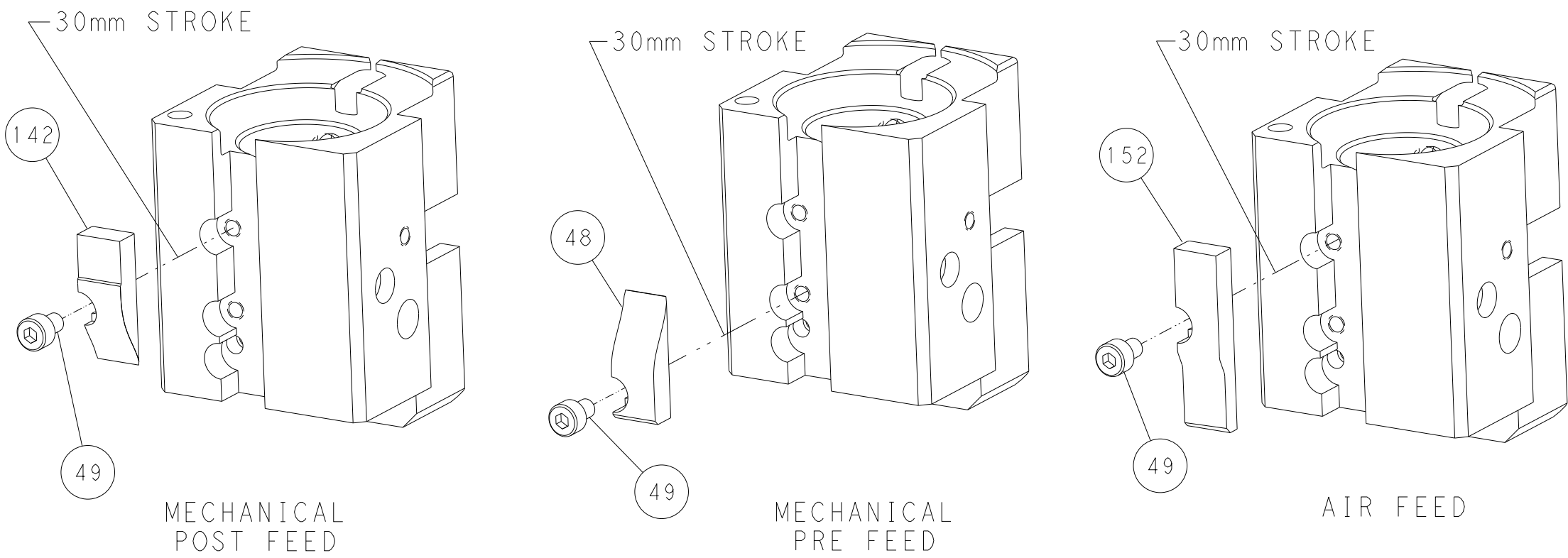
PNEUMATIC




FEED SPRING
SETTING POSITION



CAM POSITIONS



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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										CHK C. TOPPER 09DEC2016							
										APVD J. DEGRANGE 09DEC2016		NAME Ocean End Feed Applicator -					
										PRODUCT SPEC							
										APPLICATION SPEC							
										WEIGHT -		SIZE A 00779		DRAWING NO C=2836524		RESTRICTED TO -	
										Customer Accessible Production Drawing		SCALE 1:1		SHEET 4 of 4		REV C	

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Authorized Distributor

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[TE Connectivity:](#)

[2836524-1](#)