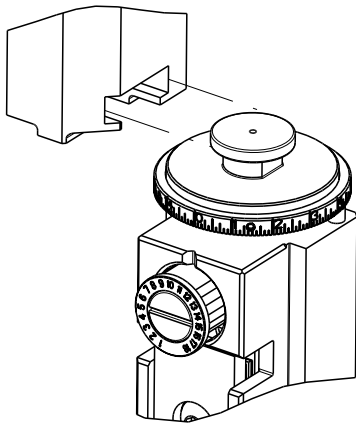


8		7	
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2016		2016	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2836537-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2836537-2	C	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2836537-7	C	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	4.40 mm [.173]	○
INSUL	6.86 mm [.270]	○
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: OUTER FERRULE, 180 DEGREE, SEALED FAKRA			
WIRE STRIP LENGTH			TERMINAL INSULATION DIAMETER RANGE
114-32145			Ø4.40-5.50 mm [.173-.217 IN]
TERMINAL APPLICATION SPECIFICATION			

TE TERMINAL	TE TERMINAL	TE SEAL	TE SEAL	SEAL INSULATION DIAMETER RANGE
2272633-4		2301641-4		4.30 - 5.20 mm

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
RG-58		5.0



- RECOMMENDED SPARE PARTS
- REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 180. 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 TORO-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.
- SEE APPLICATION SPECIFICATION 114-32145 RECOMMENDED FOR STRIP LENGTH DIMENSIONS. CUT TO LENGTH AT ASSEMBLY.
- MUST FEED OFF OF SLOT.
- SEE APPLICATION SPECIFICATION 114-32145 FOR SOLDER DIAMETER TO VERIFY BRAID CRIMP HEIGHT.
- UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.

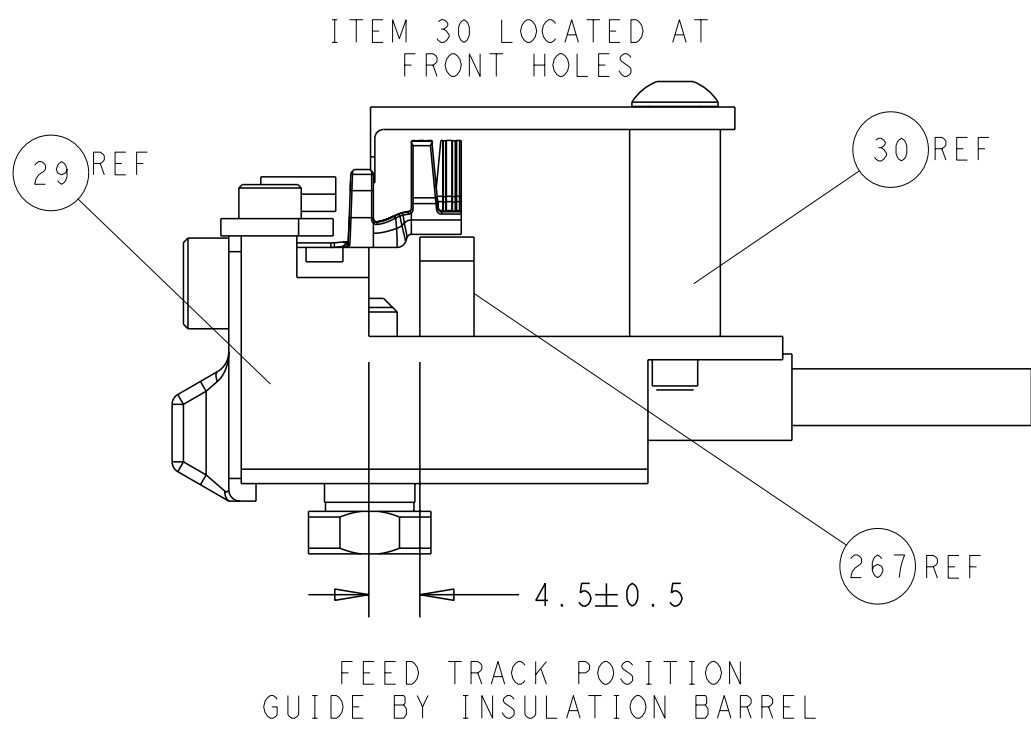
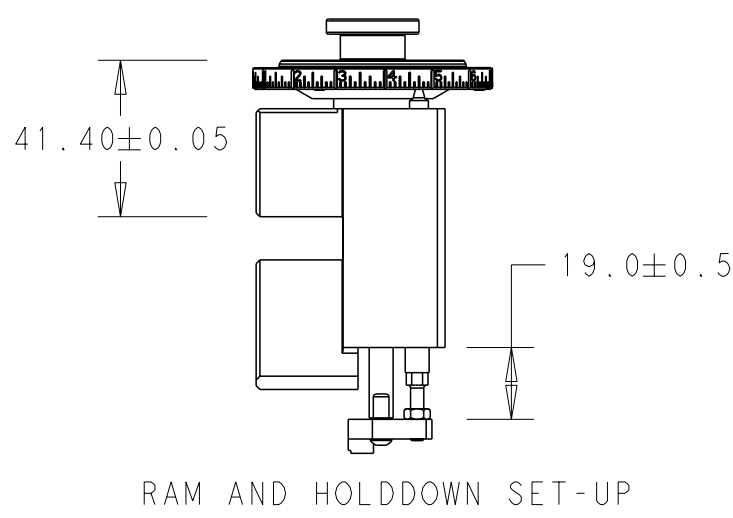
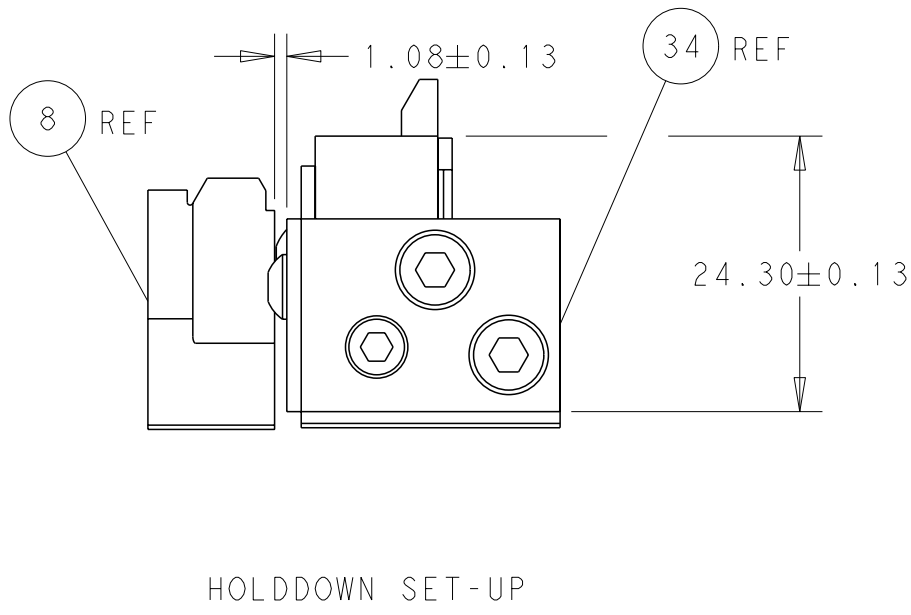
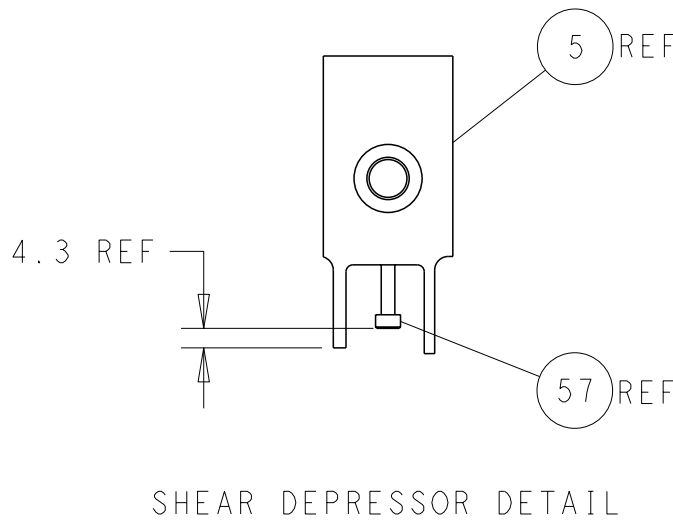
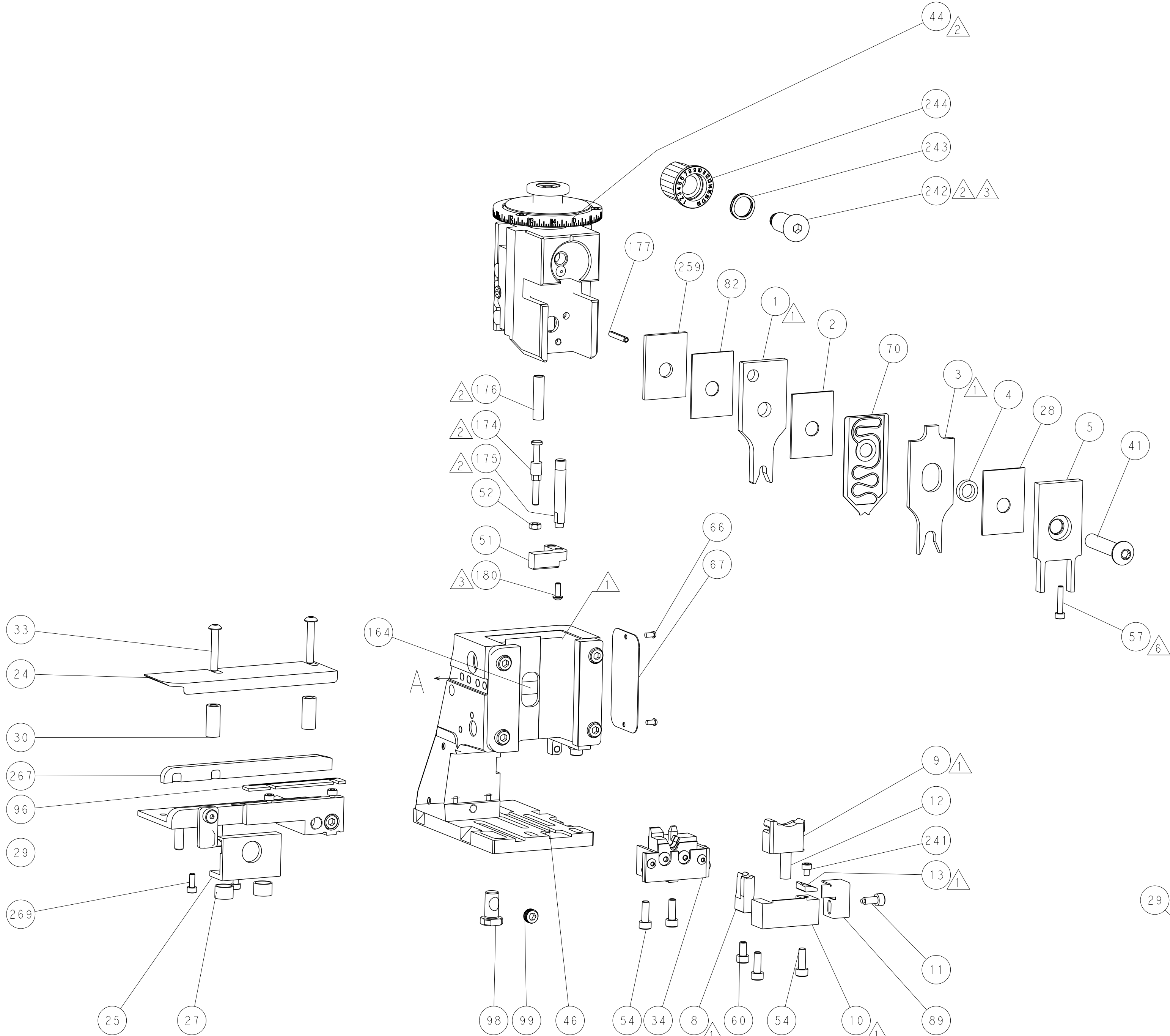
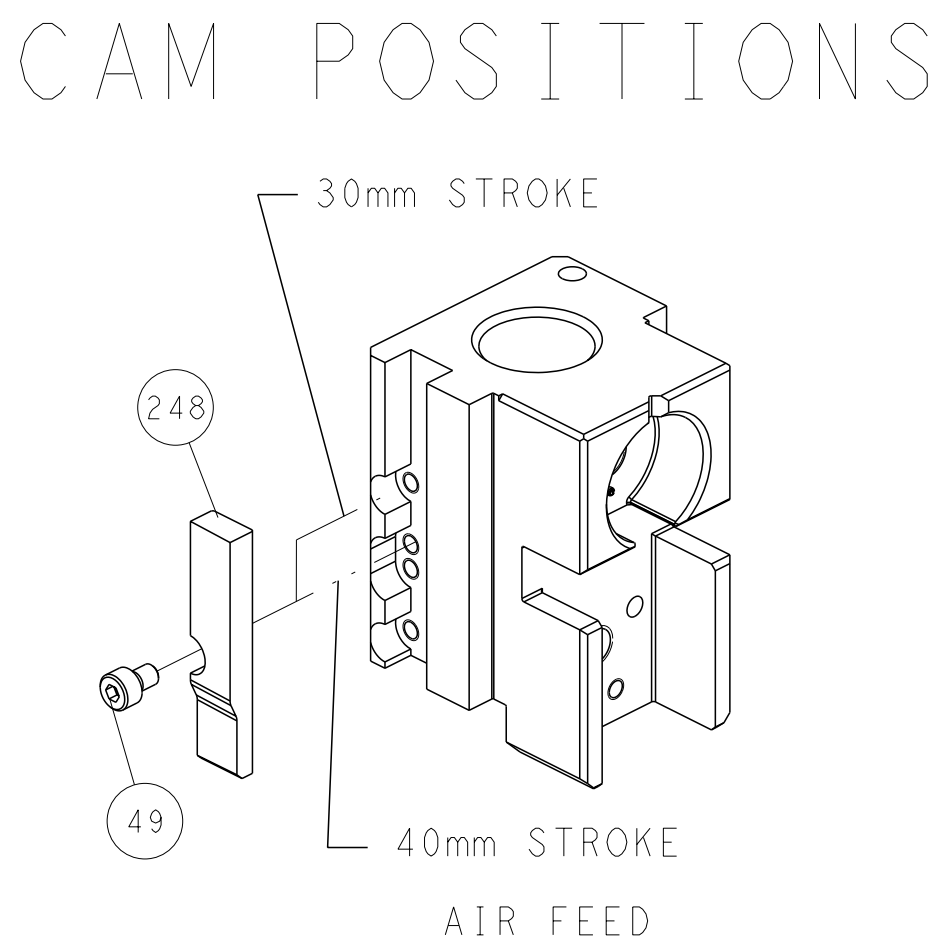
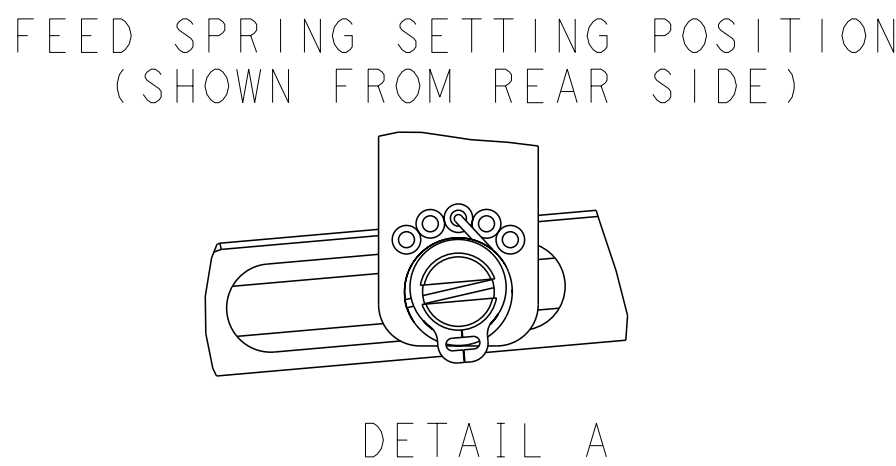
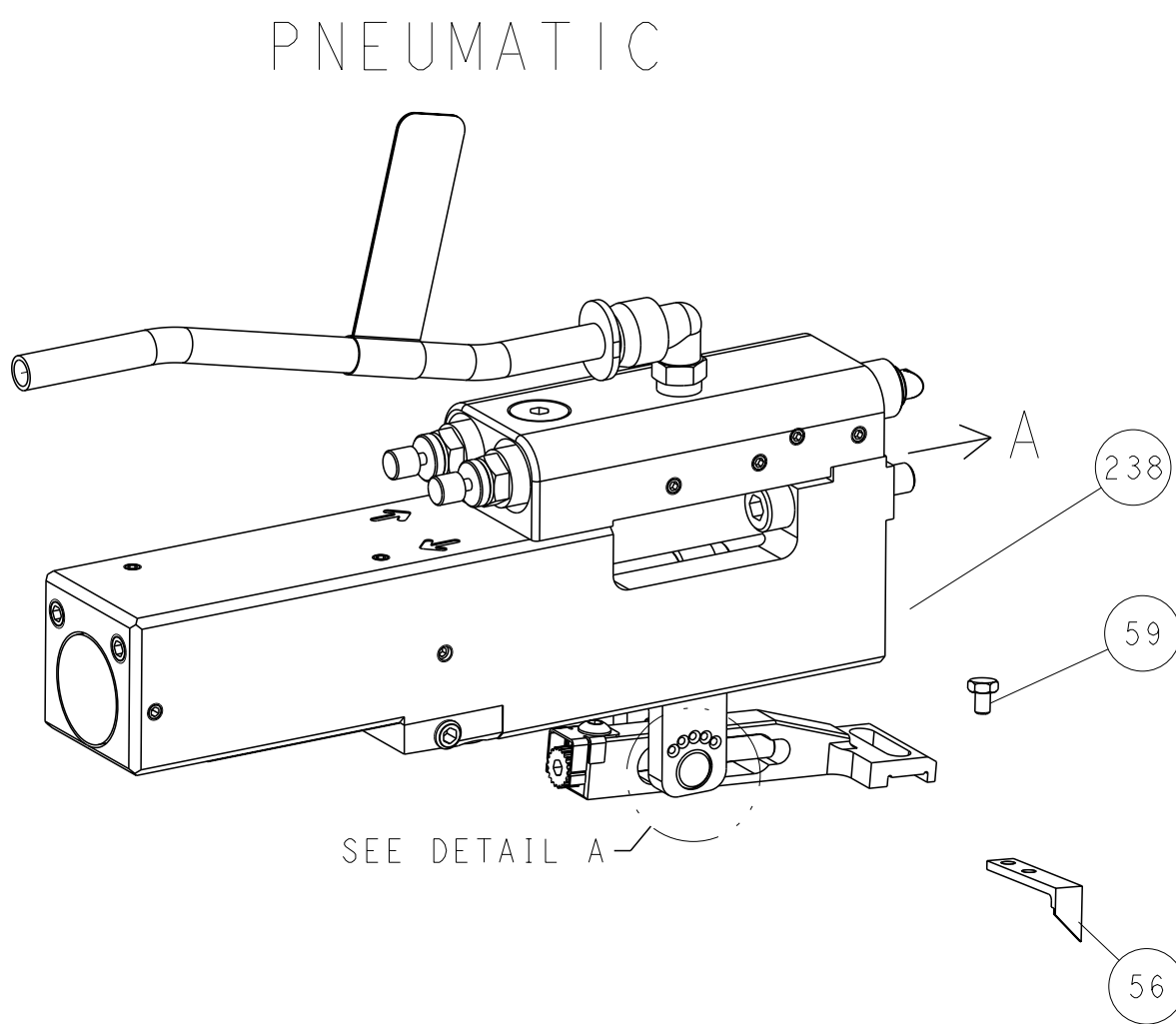
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

2			1					
LOC	DIST	REVISIONS						
A	66	P	LTR	DESCRIPTION		DATE	DWN	APVD
			A	RELEASED		20FEB2017	TB	GB
			A1	ECR-18-000468		11JAN2018	KH	TE
			B	ECR-18-017245		31OCT2018	TB	GB
			C	ECR-19-009480		17JUN2019	JAH	GB

-	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	269
-	1	1	1633782-4	FENCE	267
-	1	1	1803078-2	SPACER, PRECISION	259
-	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
-	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
-	1	1	2079383-1	SCR, BHSC, RoHS (M3 X 8)	180
-	1	1	993111-1	PIN, SLOTTED SPRING 3.0 X 20.0	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	1	2844908-1	SCREW, LOCKING	99
-	1	1	2844907-1	POST, LOCKING	98
-	1	1	1-690438-0	FRONT STRIP GUIDE	96
-	1	1	318563-1	GUARD, FRONT CHIP	89
-	1	1	455888-8	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	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	1338685-4	PAWL, FEED	56
-	4	4	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	54
-	1	1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52
-	1	1	1803816-1	HOLDDOWN, TERMINAL SPECIAL	51
-	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	1803602-2	SCR, BHSC, RoHS (M8 X 40)	41
-	1	1	1803746-2	ADJUSTABLE TERMINAL SUPPORT	34
-	2	2	1-2079383-3	SCR, BHSC, RoHS (M4 X 25)	33
-	2	2	4-2844962-2	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	1320928-2	STRIP GUIDE	24
-	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	1-2119805-8	SHEAR HOLDER, FRONT	10
-	1	1	1803808-1	FLOATING SHEAR, FRONT SPECIAL	9
-	1	2	1803813-2	ANVIL, COMBINATION SPECIAL	8
-	-	-	-	-	7
-	-	-	-	-	6
-	1	1	1-1803080-2	DEPRESSOR, SHEAR	5
-	1	1	2-238011-1	BLOCK, CRIMPER SPACER	4
-	1	2	9-1803019-1	CRIMPER, INSULATION O	3
-	1	1	1-455888-0	SPACER, CRIMPER	2
-	1	2	3-1633723-2	CRIMPER, WIRE O	1

-77-72	-2	PART NO	DESCRIPTION	ITEM NO
Customer Accessible Production Drawing				
SCALE 1:2 SHEET 1 OF 4 REV C				

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

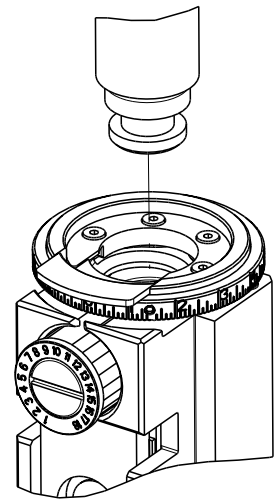


ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE AND TO CONTROL AND ENGINEERING DISCRETION. CHANGES SHOULD BE CONTACTED FOR THE LATEST REVISION.				OWN M. HERR	16DEC2016	 TE Connectivity Harrisburg, PA 17105-3608	NAME Ocean Side Feed Applicator
DIMENSIONS: mm				CHK T. ELBIN	16DEC2016		
TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH ±				APVD T. ELBIN	16DEC2016		
MATERIAL -				PRODUCT SPEC -	APPLICATION SPEC -		
WEIGHT -				SIZE A1	CAGE CODE 00779	DRAWING NO C=2836537	RESTRICTED TO -
Customer Accessible Production Drawing				SCALE 1:2	SHEET 2	OF 4	REV C

SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

8		7	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2836537-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2836537-7	C	CRIMP TOOLING KIT	-



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	4.40 mm [.173]	Ø
INSUL	6.86 mm [.270]	Ø
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: OUTER FERRULE, 180 DEGREE, SEALED FAKRA			
WIRE STRIP LENGTH		TERMINAL INSULATION DIAMETER RANGE	
	114-32145	$\varnothing 4.40\text{-}5.50\text{ mm}$ [1.73-.217 IN]	
TERMINAL APPLICATION SPECIFICATION		-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE SEAL	TE SEAL
2272633-4		2301641-4	

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
RG-58	9	5.0



- 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 ITEMS 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 TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- ⑥ APPLY TORO-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.
- ⑦ SEE APPLICATION SPECIFICATION 114-32145 RECOMMENDED FOR STRIP LENGTH DIMENSIONS.
CUT TO LENGTH AT ASSEMBLY.
- ⑧ MUST FEED OFF OF SLOT.
- ⑨ SEE APPLICATION SPECIFICATION 114-32145 FOR SOLDER DIAMETER TO VERIFY BRAID CRIMP HEIGHT.
10. 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.

[illegible]

	-	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	269
	-	1	1633782-4	FENCE	267
	-	1	1803078-2	SPACER, PRECISION	259
	-	1	2119082-4	CAM, SNAIL, INSULATION ADJUSTMENT	244
	-	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
3	-	1	2119083-1	RETAINER, INSULATION DIAL	242
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	-	1	2844940-1	AIR FEED MODULE	238
3	-	1	2079383-1	SCR, BHSC, RoHS (M3 X 8)	180
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	-	1	8-22280-7	SPRING, COMPRESSION	176
	-	1	1752353-2	GUIDE PIN,HOLDDOWN	175
	-	1	1901680-2	GUIDE PIN,HOLDDOWN	174
	-	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	2844908-1	SCREW, LOCKING	99
	-	1	2844907-1	POST, LOCKING	98
	-	1	1-690438-0	FRONT STRIP GUIDE	96
	-	1	318563-1	GUARD, FRONT CHIP	89
	-	1	455888-8	SPACER, CRIMPER	82
	-	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
6	-	1	1-2168083-3	SCR, SKT HD CAP, RoHS, M3 X 16	57
8	-	1	1338685-4	PAWL, FEED	56
	-	1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52
	-	1	1803816-1	HOLDDOWN, TERMINAL SPECIAL	51
	-	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49
	-	1	1803602-2	SCR, BHSC, RoHS (M8 X 40)	41
	-	1	1803746-2	ADJUSTABLE TERMINAL SUPPORT	34
	-	2	1-2079383-3	SCR, BHSC, RoHS (M4 X 25)	33
	-	2	4-2844962-2	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	1320928-2	STRIP GUIDE	24
1	-	1	2119806-1	INSERT, SHEAR	13
	-	1	3-22280-3	SPRING, COMPRESSION	12
	-	1	1-356885-4	STOP, SHEAR	11
1	-	1	1-2119805-8	SHEAR HOLDER, FRONT	10
1	-	1	1803808-1	FLOATING SHEAR, FRONT SPECIAL	9
1	1	1	1803813-2	ANVIL, COMBINATION SPECIAL	8
	-	-	-	-	7
	-	-	-	-	6
	-	1	1-1803080-2	DEPRESSOR, SHEAR	5
	-	1	2-238011-1	BLOCK, CRIMPER SPACER	4
1	1	1	9-1803019-1	CRIMPER, INSULATION O	3
	-	1	1-455888-0	SPACER, CRIMPER	2
1	1	1	3-1633723-2	CRIMPER, WIRE O	1
-77 -22 PART NO				DESCRIPTION	ITEM NO

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CHG T. ELBIN 16DEC2016		APD T. ELBIN 16DEC2016			
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH		NAME Ocean Side Feed Applicator	
		PRODUCT SPEC APPLICATION SPEC		SIZE CAGE CODE DRAWING NO A 00779 C=2836537	
MATERIAL -		WEIGHT -		RESTRICTED TO -	
Customer Accessible Production Drawing					
				SCALE 1:2	SHEET 3 of 4
REV C					

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

PACIFIC VERSION

Shown on sheets 3 of 4 & 4 of 4

(Atlantic version shown on sheets 1 of 4 & 2 of 4)

Mouser Electronics

Authorized Distributor

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[TE Connectivity:](#)

[7-2836537-7](#)