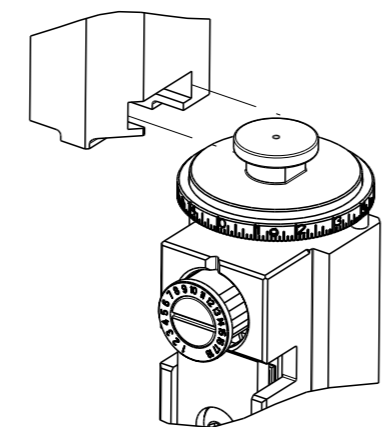


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2836084-2	F	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2836084-2	F	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2836084-7	C	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.30 mm [.091]	F
INSUL	3.10 mm [.122]	F

APPLICATOR INSTRUCTIONS 408-35042

TERMINAL DATA: MOLEX TERMINAL MOLEX CRIMP SPECIFICATION

TERMINAL NAME: .093 DIA. PIN AND SOCKET	
WIRE STRIP LENGTH 3.96-5.54 mm [.156-.218 IN]	INSULATION DIAMETER RANGE Ø1.65-2.79 mm [.065-.110 IN]
TERMINAL APPLICATION SPECIFICATION	ATS-638927100 Rev B

TE TERMINAL	MOLEX TERMINAL	TE TERMINAL	MOLEX TERMINAL
1572331-1	02-09-2101	1572332-5	02-09-5169
1572331-2	02-09-6100	1572332-6	02-09-4104
1572331-3	02-09-6101	1572332-7	02-09-8108
1572332-1	02-09-1102	1572332-8	39-00-0281
1572332-2	02-09-5100	1572332-9	39-00-0282
1572332-3	02-09-5102	1-1572332-0	39-00-0293
1572332-4	02-09-1205	1-1572332-1	39-00-0296

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
14 AWG OR 2.00mm ²	1.50+/-0.05 [.059+/- .002]	7.5
16 AWG OR 1.30mm ²	1.40+/-0.05 [.055+/- .002]	8.3
18 AWG OR 0.80mm ²	1.31+/-0.04 [.052+/- .002]	9.3
20 AWG OR 0.50mm ²	1.27+/-0.05 [.050+/- .002]	9.3

- 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 TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- 6 TERMINAL LUBRICANT IS RECOMMENDED.
- 7 CUT AT ASSEMBLY.
- 8. 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	REVISIONS			
A	66	REV	DATE	BY	APPV
		C	ECR-18-007335	14MAY2018	KH TE
		D	ECR-18-008977	12JUN2018	KH TE
		E	ECR-21-004551	17APR2021	TB RK
		F	ECR-21-005385	12MAY2021	JWC GB

-	1	1	455888-3	SPACER, CRIMPER	279
-	1	1	23238-1	INSERT, COUPLING	278
-	1	1	2030758-3	TUBING, POLYURETHANE	277
-	1	1	5018030-2	NUT, HEX, REG, RoHS, M4	276
-	1	1	986220-3	CLAMP, CABLE, BLACK	275
-	1	1	2217068-1	BRACKET, AIR BLAST	273
1	1	1	2844234-1	PLATE, REAR SHEAR	272
-	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	269
-	1	1	1-1633782-4	FENCE	267
-	1	1	2119641-1	FEED CAM, AIR FEED	248
-	1	1	2119082-7	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	2844940-1	AIR FEED MODULE	238
-	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	2	2	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	143
-	1	1	1-22281-8	SPRING, COMPRESSION	121
6	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	3-690712-7	FRONT STRIP GUIDE	96
-	2	2	1-2168083-3	SCR, SKT HD CAP, RoHS, M3 X 16	95
-	1	1	2168083-6	SCR, SKT HD CAP, RoHS, M5 X 65	93
-	1	1	1-455888-4	SPACER, CRIMPER	82
-	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
-	2	2	2-18032-5	SCR, SET, FLT PNT, M5 X 20.0	61
-	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
-	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	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	1	1	1803583-9	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
7	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	2844962-3	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	2-2844938-2	PLATE, STRIP GUIDE	29
-	2	2	22281-8	SPRING, COMPRESSION	27
-	1	1	356835-1	LEVER, DRAG RELEASE	26
-	1	1	2-690754-1	DRAG, SPECIAL	25
-	1	1	1320860-2	STRIP GUIDE, REAR	24
-	1	1	980371-4	SCR, SKT HD SHLDR 5.0 DIA X 6.0	23
-	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
-	7	7	1-18028-2	WASHER, FLAT, REG M4	20
-	1	1	2119533-6	STRIPPER, SIDE FEED	19
-	-	-	-	-	10
1	1	1	4-853720-3	BLADE, SLUG	9
1	2	1	1633054-6	ANVIL, SPECIAL	8
-	1	1	240641-7	SPACER	7
-	-	-	-	-	6
-	-	-	-	-	5
-	1	1	238009-4	BLOCK, FL CRIMPER SPACER	4
1	2	1	8-1803016-8	CRIMPER, INSULATION F	3
-	1	1	455888-7	SPACER, CRIMPER	2
1	2	1	5-1803188-5	CRIMPER, WIRE	1

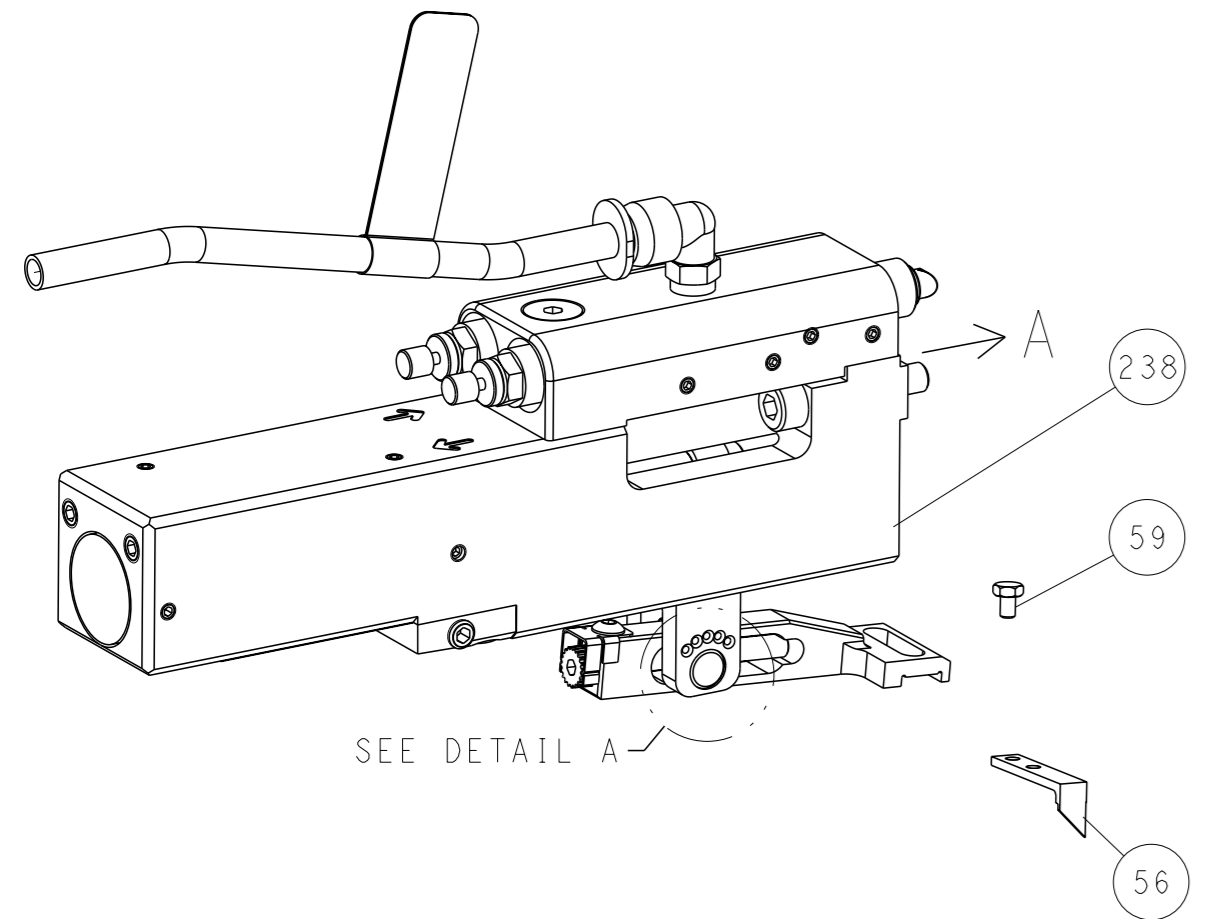
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		APPLICATOR DATA	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±
	ANGLES	FINISH		MATERIAL	

OWN: B. WEAVER	21OCT2015	TE Connectivity Harrisburg, PA 17105-3608
CHK: G. BAILEY	21OCT2015	
APVD: G. BAILEY	21OCT2015	
PRODUCT SPEC		
NAME: Ocean Side Feed Applicator		
SIZE: A1	CAGE CODE: 00779	DRAWING NO: 2836084
Customer Accessible Production Drawing		SCALE: 1:2 SHEET 1 OF 4 REV F

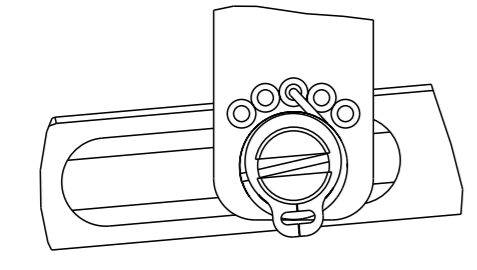
LOC	DIST	REVISIONS					
A	66	P	LYR	DESCRIPTION	DATE	OWN	APVD
		-		SEE SHEET 1	-	-	-

FEED TYPE

PNEUMATIC

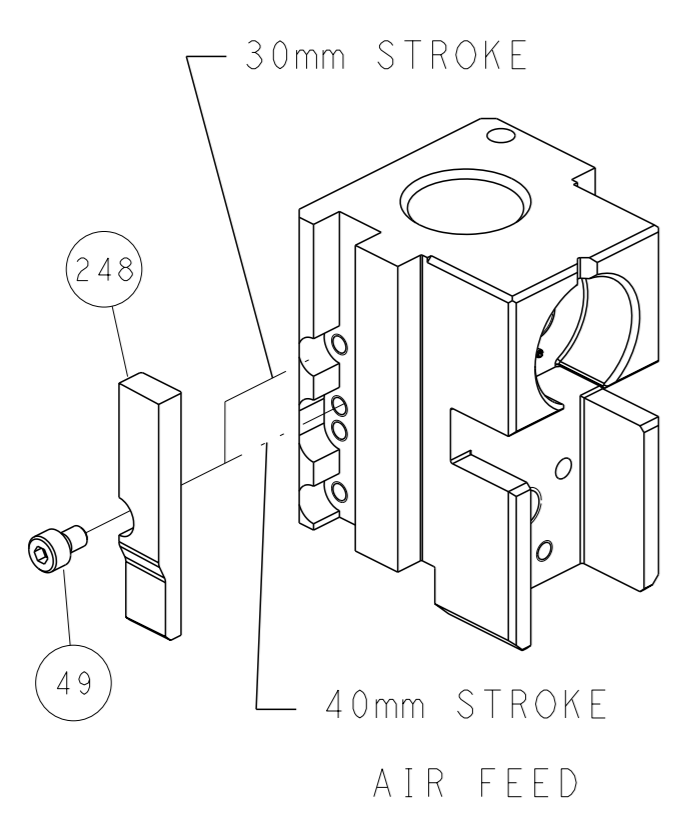


FEED SPRING SETTING POSITION
(SHOWN FROM REAR SIDE)

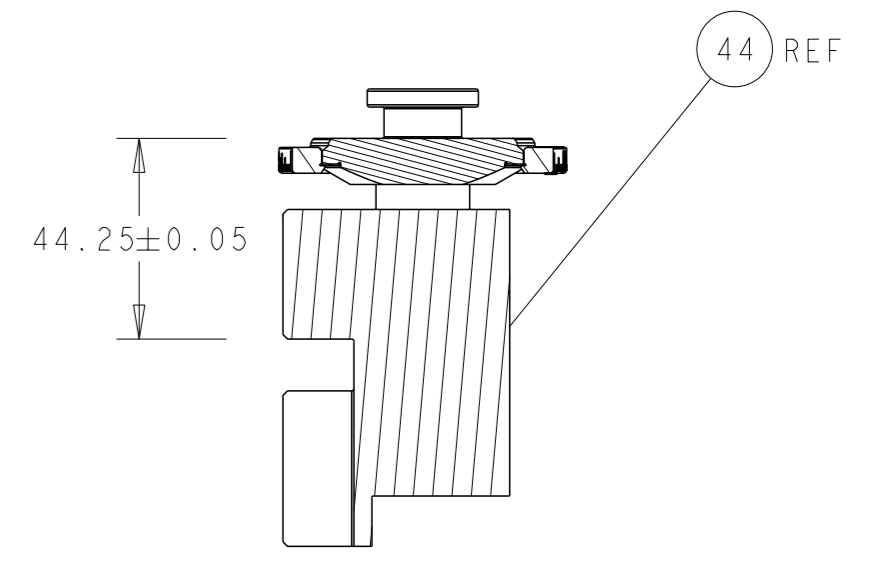
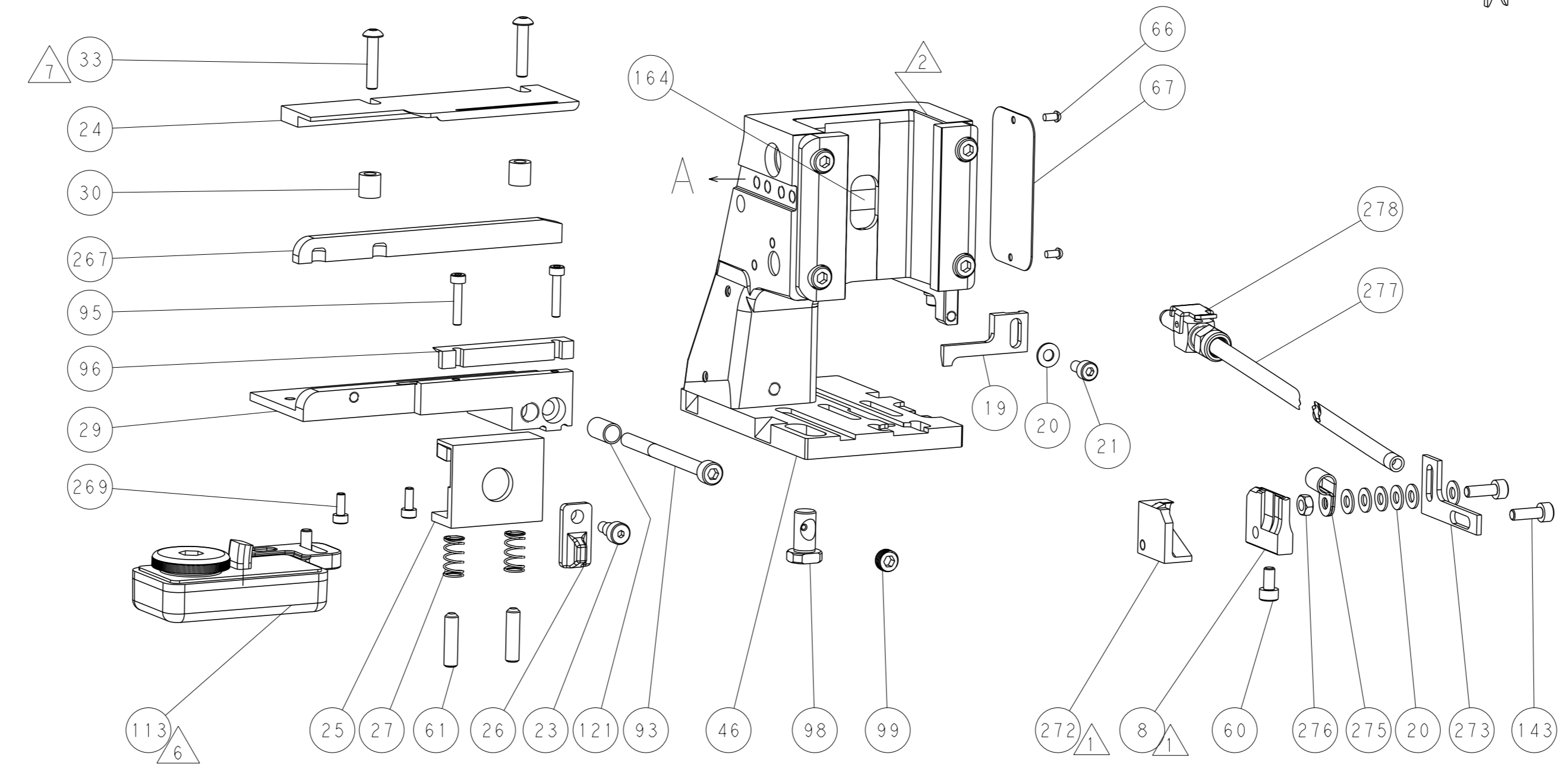
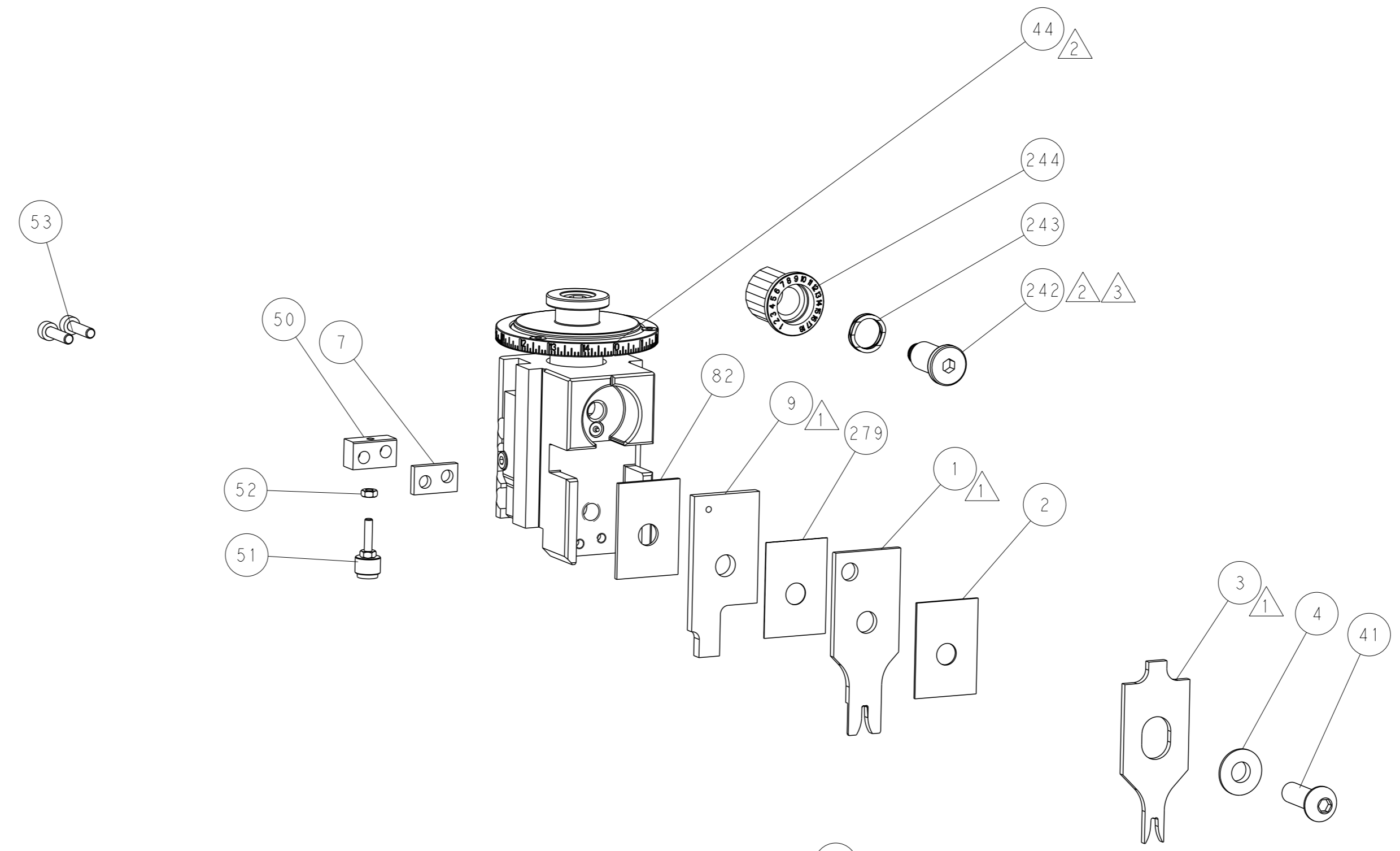


DETAIL A

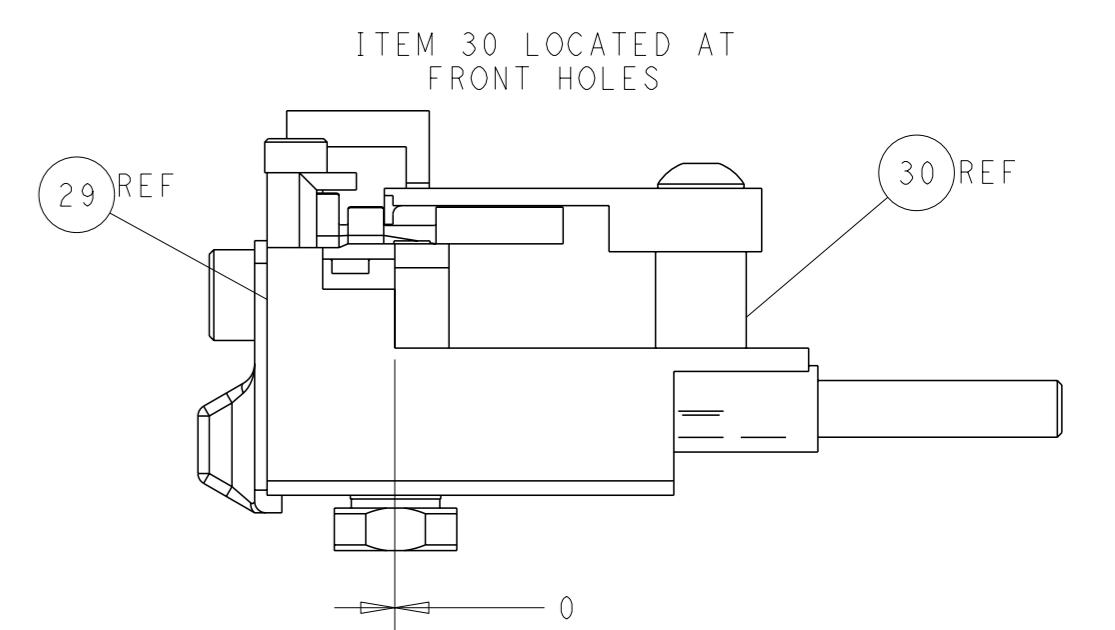
CAM POSITION



AIR FEED



RAM SET-UP



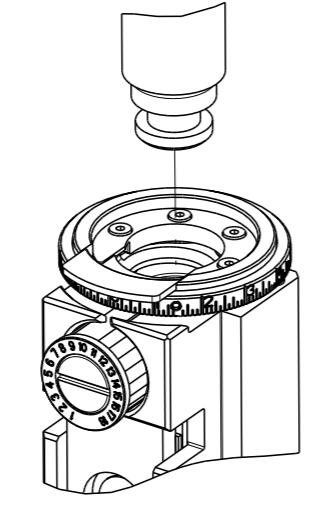
FEED TRACK POSITION
GUIDE BY WIRE BARREL

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

<small>THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE AND THE CONTROLLER'S ENGINEERING DEPARTMENT SHOULD BE CONTACTED FOR THE LATEST REVISION.</small>		OWN: B. WEAVER 21OCT2015 CHK: G. BAILEY 21OCT2015 APVD: G. BAILEY 21OCT2015	TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH ±		NAME: Ocean Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2836084	RESTRICTED TO: - SCALE: 1:2 SHEET: 2 of 4 REV: F
MATERIAL: - FINISH: -		WEIGHT: - Customer Accessible Production Drawing	SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2836084-2	F	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2836084-7	C	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP WIRE	SIZE	TYPE
WIRE	2.30 mm [.091]	F
INSUL	3.10 mm [.122]	F

APPLICATOR INSTRUCTIONS 408-35042

TERMINAL DATA: MOLEX TERMINAL MOLEX CRIMP SPECIFICATION

TERMINAL NAME: .093 DIA. PIN AND SOCKET

WIRE STRIP LENGTH 3.96-5.54 mm [.156-.218 IN]	INSULATION DIAMETER RANGE Ø1.65-2.79 mm [.065-.110 IN]
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TERMINAL APPLICATION SPECIFICATION: MATE-638927100 Rev B

TE TERMINAL	MOLEX TERMINAL	TE TERMINAL	MOLEX TERMINAL
1572331-1	02-09-2101	1572332-5	02-09-5169
1572331-2	02-09-6100	1572332-6	02-09-4104
1572331-3	02-09-6101	1572332-7	02-09-8108
1572332-1	02-09-1102	1572332-8	39-00-0281
1572332-2	02-09-5100	1572332-9	39-00-0282
1572332-3	02-09-5102	1-1572332-0	39-00-0293
1572332-4	02-09-1205	1-1572332-1	39-00-0296

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
14 AWG OR 2.00mm ²	1.50 +/- 0.05 [.059 +/- .002]	7.5
16 AWG OR 1.30mm ²	1.40 +/- 0.05 [.055 +/- .002]	8.3
18 AWG OR 0.80mm ²	1.31 +/- 0.04 [.052 +/- .002]	9.3
20 AWG OR 0.50mm ²	1.27 +/- 0.05 [.050 +/- .002]	9.3



- 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. TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
 - 6. TERMINAL LUBRICANT IS RECOMMENDED.
 - 7. CUT AT ASSEMBLY.
8. 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	REV	DESCRIPTION	DATE	OWN	APVD
A	66	-	SEE SHEET 1	-	-	-

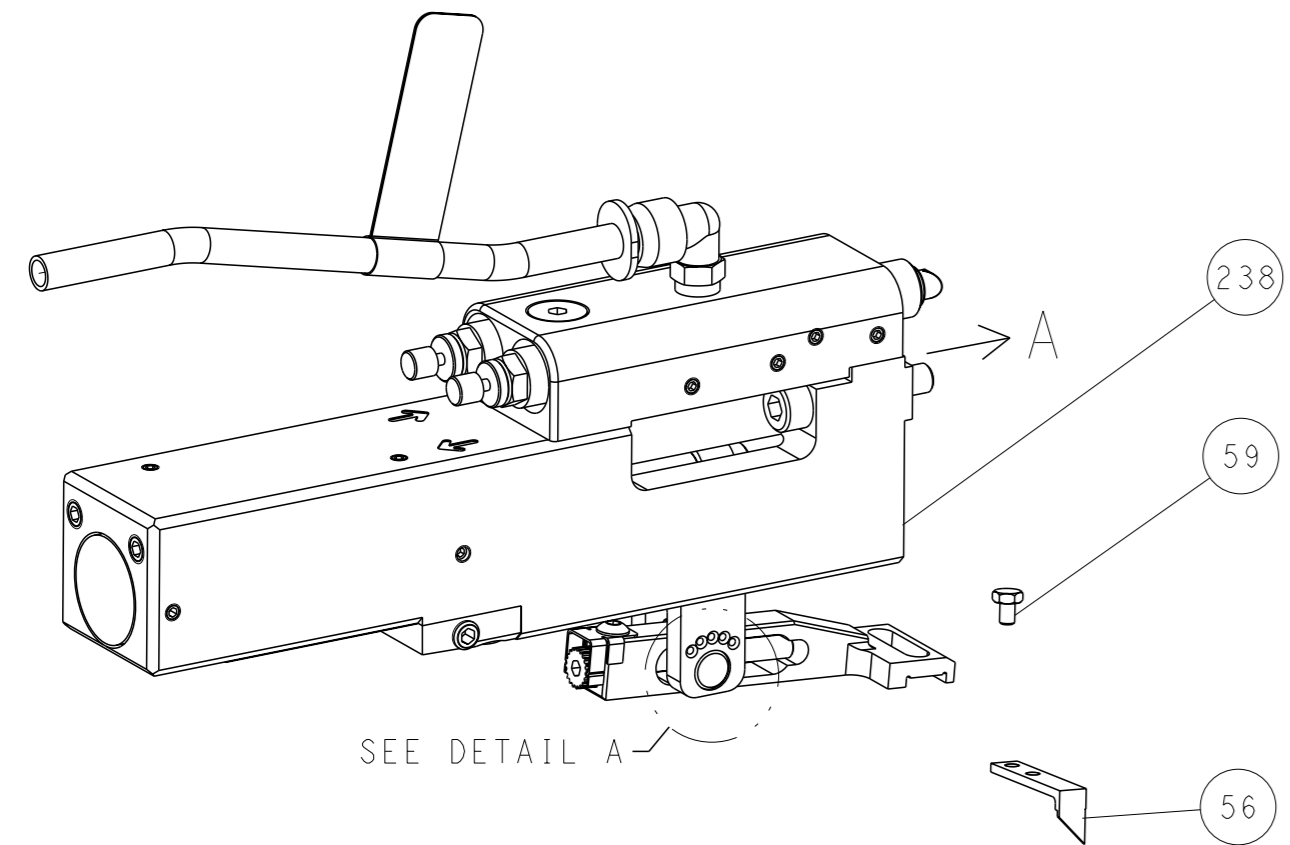
-	1	455888-3	SPACER, CRIMPER	279
-	1	23238-1	INSERT, COUPLING	278
-	1	2030758-3	TUBING, POLYURETHANE	277
-	1	5018030-2	NUT, HEX, REG, RoHS, M4	276
-	1	986220-3	CLAMP, CABLE, BLACK	275
-	1	2217068-1	BRACKET, AIR BLAST	273
1	1	2844234-1	PLATE, REAR SHEAR	272
-	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	269
-	1	1-1633782-4	FENCE	267
-	1	2119082-7	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
3	1	2119083-1	RETAINER, INSULATION DIAL	242
-	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
-	2	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	143
-	1	1-1803583-0	APPLICATOR BASIC ASSEMBLY, SF	141
-	1	1803516-1	RAM ASSEMBLY, SF PACIFIC	140
-	1	1-22281-8	SPRING, COMPRESSION	121
6	1	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113
-	1	2844908-1	SCREW, LOCKING	99
-	1	2844907-1	POST, LOCKING	98
-	1	3-690712-7	FRONT STRIP GUIDE	96
-	2	1-2168083-3	SCR, SKT HD CAP, RoHS, M3 X 16	95
-	1	2168083-6	SCR, SKT HD CAP, RoHS, M5 X 65	93
-	1	1-455888-4	SPACER, CRIMPER	82
-	1	1803607-3	DOCUMENTATION PACKAGE	71
-	1	2119740-1	TAG, IDENTIFICATION	67
-	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	2	2-18032-5	SCR, SET, FLT PNT, M5 X 20.0	61
-	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	1	1338685-1	PAWL, FEED	56
-	2	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	53
-	1	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	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
-	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2844962-3	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	2-2844938-2	PLATE, STRIP GUIDE	29
-	2	22281-8	SPRING, COMPRESSION	27
-	1	356835-1	LEVER, DRAG RELEASE	26
-	1	2-690754-1	DRAG, SPECIAL	25
-	1	1320860-2	STRIP GUIDE, REAR	24
-	1	980371-4	SCR, SKT HD SHLDR 5.0 DIA X 6.0	23
-	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
-	7	1-18028-2	WASHER, FLAT, REG M4	20
-	1	2119533-6	STRIPPER, SIDE FEED	19
-	-	-	-	10
1	1	4-853720-3	BLADE, SLUG	9
1	1	1633054-6	ANVIL, SPECIAL	8
-	1	240641-7	SPACER	7
-	-	-	-	6
-	-	-	-	5
-	1	238009-4	BLOCK, FL CRIMPER SPACER	4
1	1	8-1803016-8	CRIMPER, INSULATION F	3
-	1	455888-7	SPACER, CRIMPER	2
1	1	5-1803188-5	CRIMPER, WIRE	1
-	-	-	-	1

DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH ±		OWN: B. WEAVER 21OCT2015 CHK: G. BAILEY 21OCT2015 APVD: G. BAILEY 21OCT2015 PRODUCT SPEC: - APPLICATION SPEC: - MATERIAL: - FINISH: -		NAME: STE TE Connectivity Harrisburg, PA 17105-3608 Ocean Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2836084 RESTRICTED TO: - SCALE: 1:2 SHEET 3 OF 4 REV F	
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LOC		DIST		REVISIONS			
A	66	P	LYR	DESCRIPTION	DATE	OWN	APVD
		-		SEE SHEET 1	-	-	-

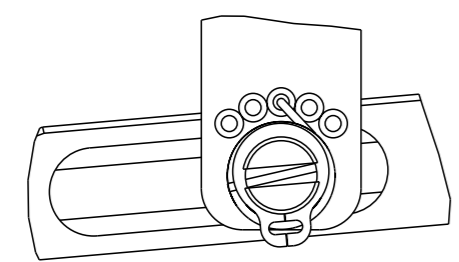
FEED TYPE

PNEUMATIC



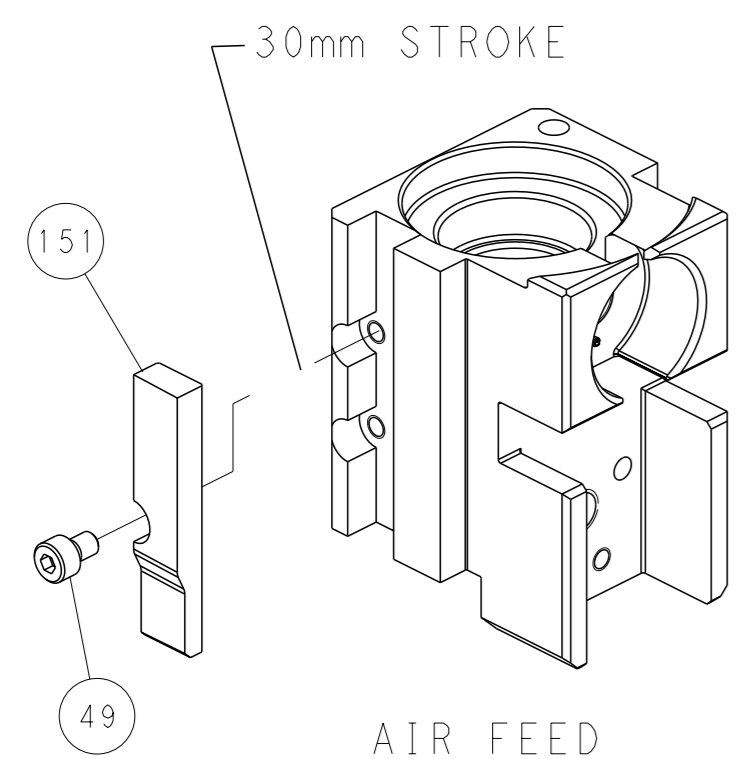
SEE DETAIL A

FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)

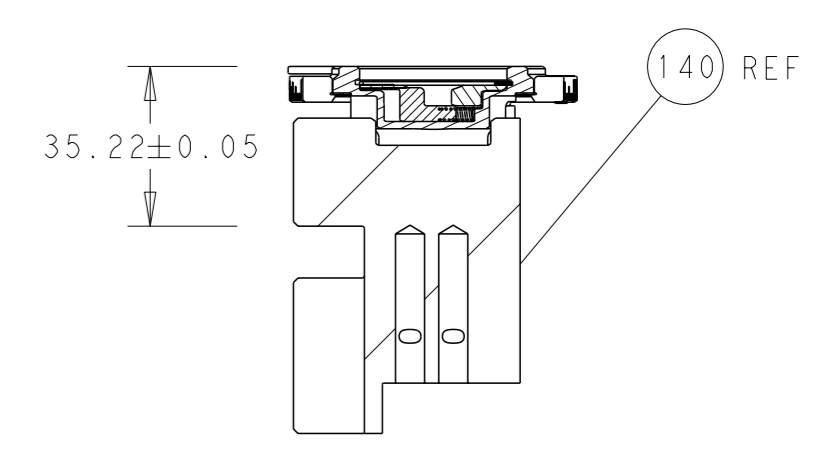
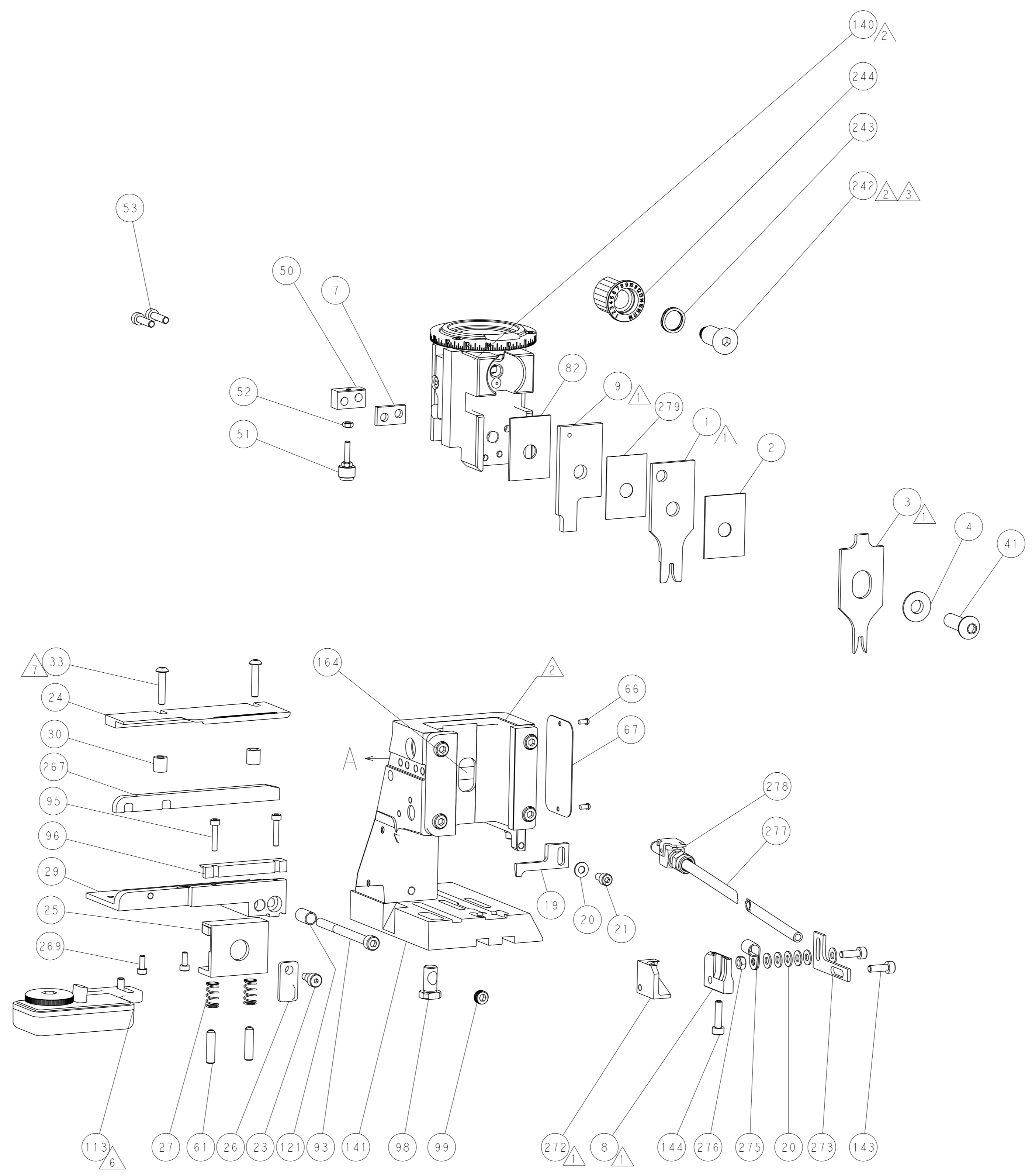


DETAIL A

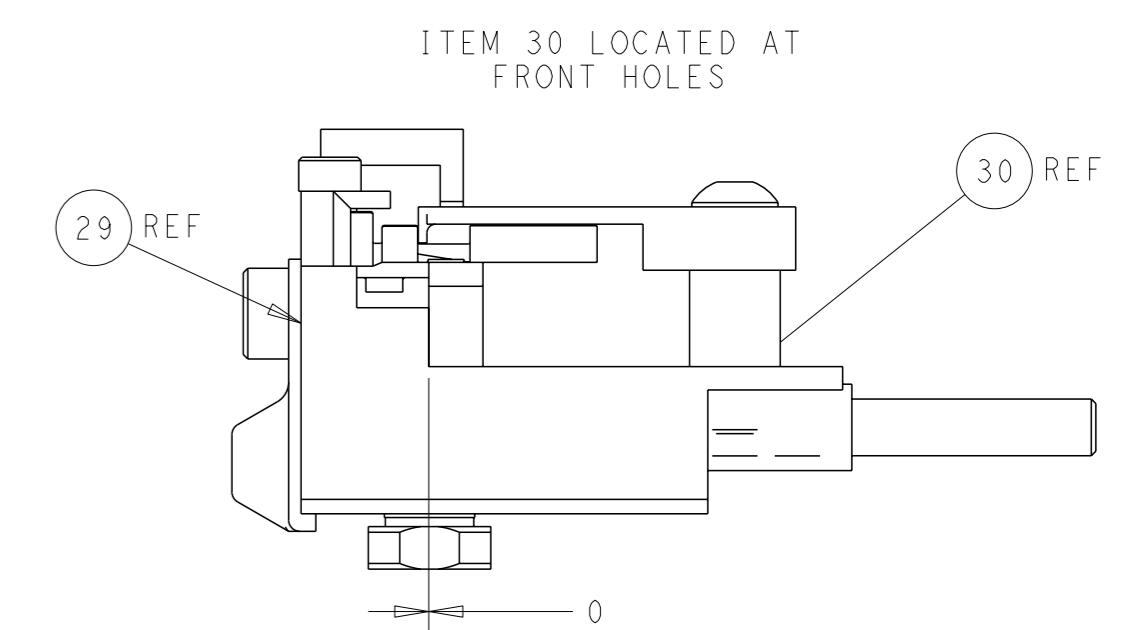
CAM POSITION



AIR FEED



RAM SET-UP



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)

<small>THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE AND THE CONTROL AND ENGINEERING ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST REVISION.</small>		OWN: B. WEAVER CHK: G. BAILEY APVD: G. BAILEY PRODUCT SPEC: - APPLICATION SPEC: - MATERIAL: - WEIGHT: -	21OCT2015 21OCT2015 21OCT2015 - - - -	NAME: Ocean Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2836084 SCALE: 1:2 SHEET: 4 of 4 REV: F	RESTRICTED TO: -
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