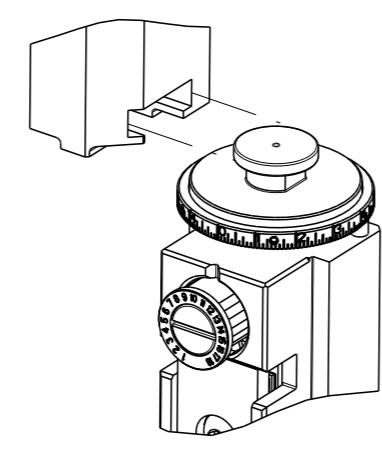


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2836079-2	F	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2836079-2	F	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2836079-7	D	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA

CRIMP	SIZE	TYPE
WIRE	4.83 mm [.190]	F
INSUL	10.40 mm [.409]	O

APPLICATOR INSTRUCTIONS  
408-35042

TERMINAL DATA: LEAR TERMINAL TE CRIMP SPECIFICATION

TERMINAL NAME: TERMINAL

WIRE STRIP LENGTH	TERMINAL INSULATION DIAMETER RANGE
8.57-9.33 mm [.337-.367 IN]	Ø

TERMINAL APPLICATION SPECIFICATION

NONE	-	-
------	---	---

TERMINALS APPLIED

TE TERMINAL	LEAR TERMINAL	TE SEAL	LEAR SEAL	SEAL INSULATION DIAMETER RANGE
2113913-1	28225.306.710	2113914-1	PDM-TWS-L4	Ø 4.6-5.3mm
2113913-2	28225.306.179			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
10.00mm2	4.04 +/- 0.05 [.159 +/- .002]	3.0
8 AWG OR 8.00mm2	3.70 +/- 0.05 [.146 +/- .002]	6.5
6.00mm2	3.35 +/- 0.05 [.132 +/- .002]	9.7

- 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. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- 6. TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- 7. TERMINAL LUBRICANT IS RECOMMENDED.
- 8. APPLY TORQ-SEAL IN ALLEN SOCKET TO FILL HOLE AFTER SOCKET HEAD HAS BEEN ADJUSTED TO CORRECT HEIGHT AT QUALIFICATION.
- 9. CUT TO LENGTH AT ASSEMBLY.
- 10. RELOCATE ITEM 19 TO BACK OF APPLICATOR.

**\*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.

LOC	DIST	REVISIONS			
A	66	REV	DATE	BY	APPV
		C	ECR-19-008843	05JUN2019	FJ TE
		D	ECR-19-009897	02JUL2019	FZ GB
		E	ECR-20-006575	07MAY2020	TB GB
		F	ECR-20-009625	06JUL2020	JAH GB

-	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	269	
-	1	1	1633782-3	FENCE	267	
-	1	1	1803078-1	SPACER, PRECISION	259	
-	1	1	2119641-1	FEED CAM, AIR FEED	248	
-	1	1	2119082-8	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	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241	
-	1	1	2844940-6	AIR FEED MODULE	238	
-	REF	REF	994970-2	COUNTER, MAGNETIC	164	
-	1	1	455888-4	SPACER, CRIMPER	120	
7	-	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	2-690438-2	FRONT STRIP GUIDE	96	
-	1	1	455888-8	SPACER, CRIMPER	82	
9	-	2	2	2079383-4	SCR, BHSC, RoHS (M4 X 8)	79
-	1	1	1803096-1	EXTENSION PLATE	78	
-	1	1	1803607-3	DOCUMENTATION PACKAGE	71	
-	1	1	1-2119791-3	DEPRESSOR, WIRE	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	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	
8	-	1	1	1-2168083-3	SCR, SKT HD CAP, RoHS, M3 X 16	57
-	1	1	1-1338683-1	FEED PAWL	56	
-	4	4	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	54	
-	2	2	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	53	
-	2	2	5018030-1	NUT, HEX, REG, RoHS, M3	52	
-	1	1	1-811242-0	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	1803602-2	SCR, BHSC, RoHS (M8 X 40)	41	
-	1	1	1-1752356-5	SUPPORT, TERMINAL	34	
9	-	2	2	1-2079383-3	SCR, BHSC, RoHS (M4 X 25)	33
-	2	2	3-2844962-7	SPACER, CYLINDRICAL, STRIP GUIDE	30	
-	1	1	2844992-6	ASSEMBLY, STRIP GUIDE	29	
-	1	1	1-455888-9	SPACER, CRIMPER	28	
-	2	2	22281-8	SPRING, COMPRESSION	27	
-	1	1	240792-1	DRAG, TERMINAL	25	
-	1	1	1320928-2	STRIP GUIDE	24	
-	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21	
-	3	3	1-18028-2	WASHER, FLAT, REG M4	20	
-	1	1	1803013-1	STRIPPER, SIDE FEED	19	
-	1	1	2119806-1	INSERT, SHEAR	13	
-	1	1	4-22280-7	SPRING, COMPRESSION	12	
-	1	1	1-356885-5	STOP, SHEAR	11	
1	-	1	1	2119805-7	SHEAR HOLDER, FRONT	10
1	-	1	1	318059-9	FLOATING SHEAR, FRONT	9
1	2	1	4-1803320-0	ANVIL, COMBINATION	8	
-	1	1	2-240641-9	SPACER	7	
-	-	-	-	-	6	
-	1	1	2-1803080-0	DEPRESSOR, SHEAR	5	
-	1	1	5-238011-8	BLOCK, CRIMPER SPACER	4	
1	2	1	4-1633996-6	CRIMPER, INSULATION SPECIAL	3	
-	1	1	455888-7	SPACER, CRIMPER	2	
1	2	1	6-1633664-6	CRIMPER, WIRE	1	

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

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		APPROVED:		NAME:	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES ±	FINISH
MATERIAL		WEIGHT		SCALE		SHEET	
Customer Accessible Production Drawing		SCALE 1:2		SHEET 1 of 4		REV F	

OWN: H. HUANG 19OCT2015  
 CHK: L. ZHANG 19OCT2015  
 APVD: H. GUO 19OCT2015

TE Connectivity  
 Harrisburg, PA 17105-3608

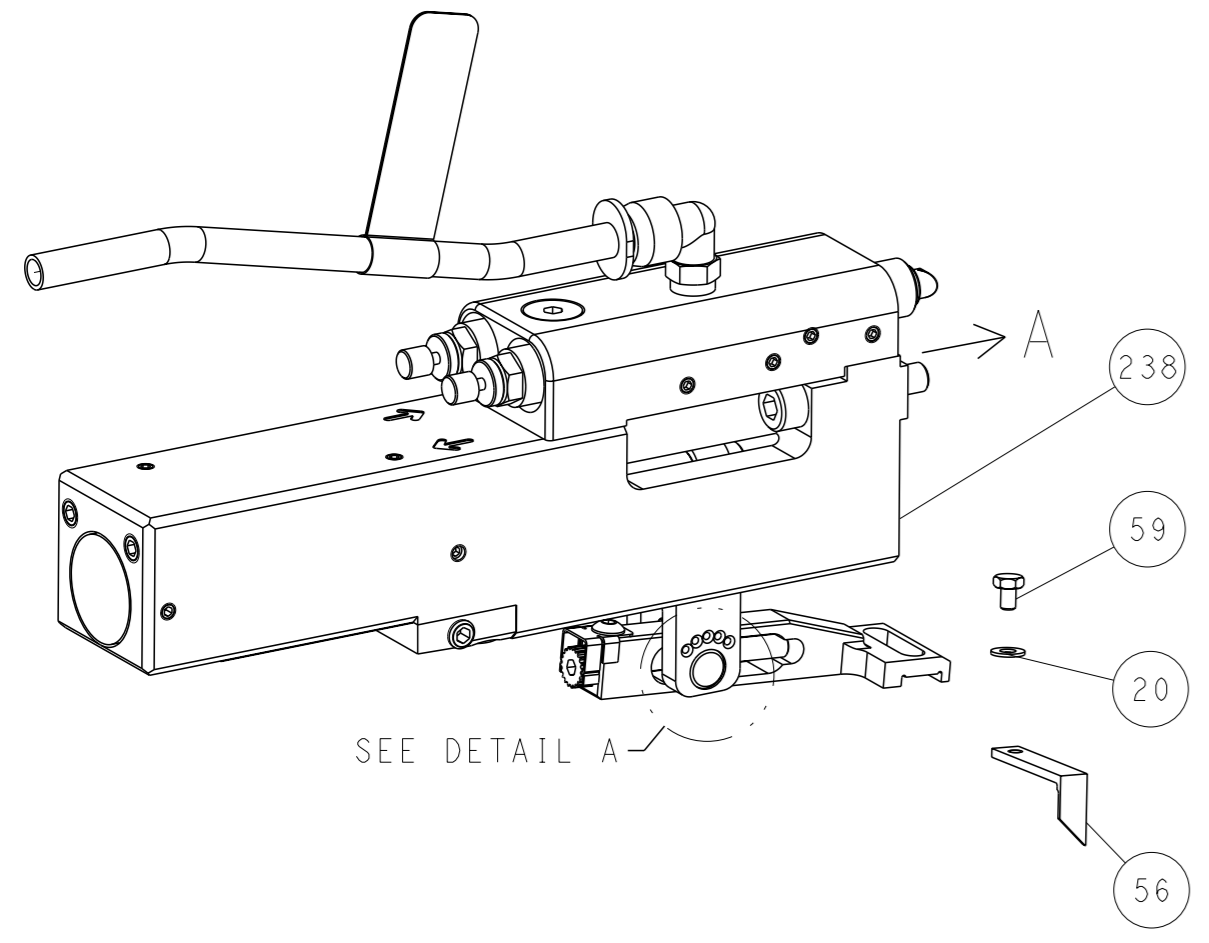
Ocean Side Feed  
 Applicator

SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2836079

LOC	DIST	REVISIONS			
		REV	DATE	OWN	APVD
A	66	1	SEE SHEET 1	-	-

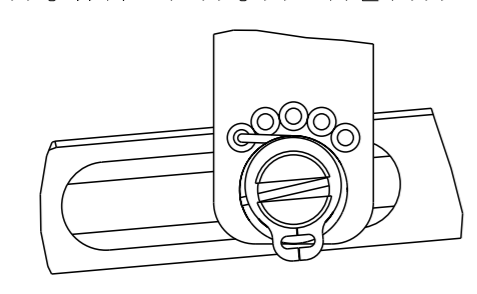
### FEED TYPE

#### PNEUMATIC



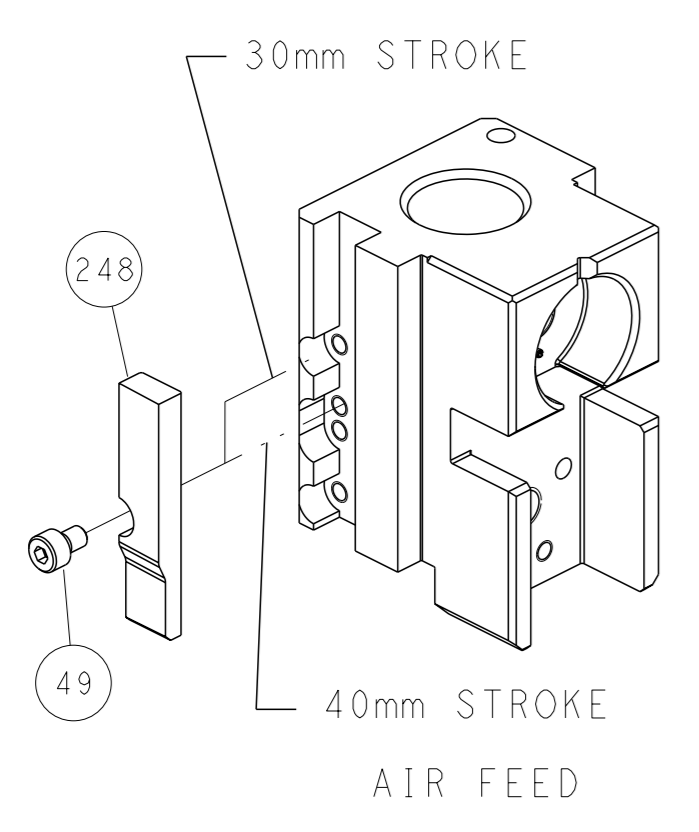
SEE DETAIL A

#### FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)

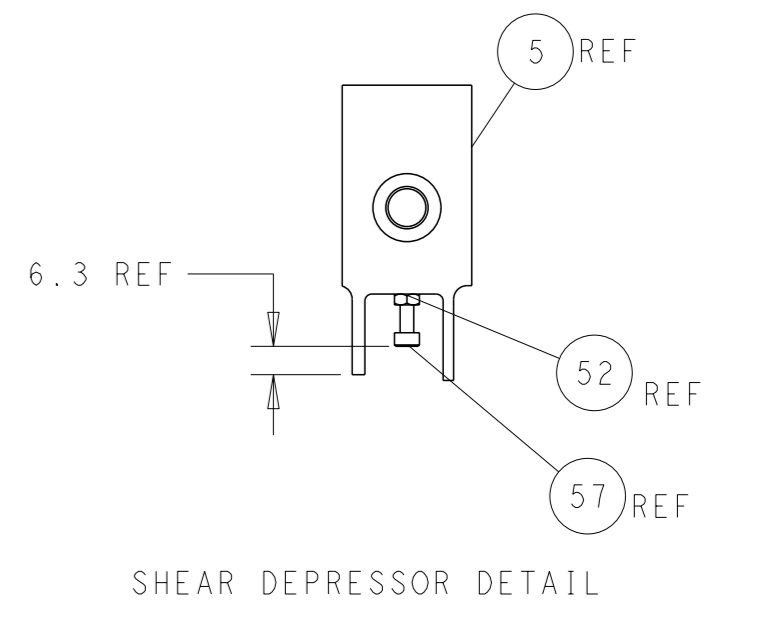
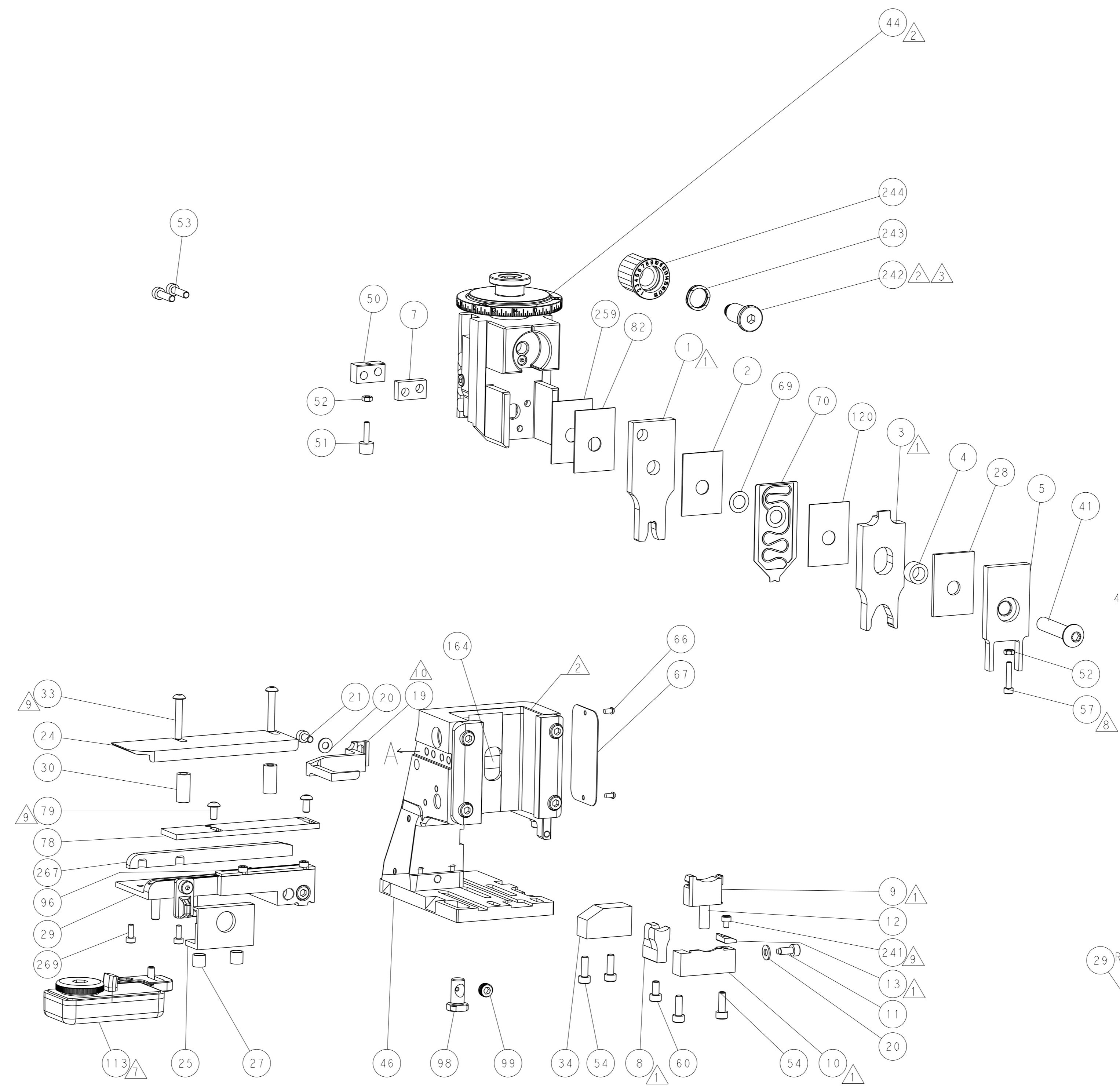


DETAIL A

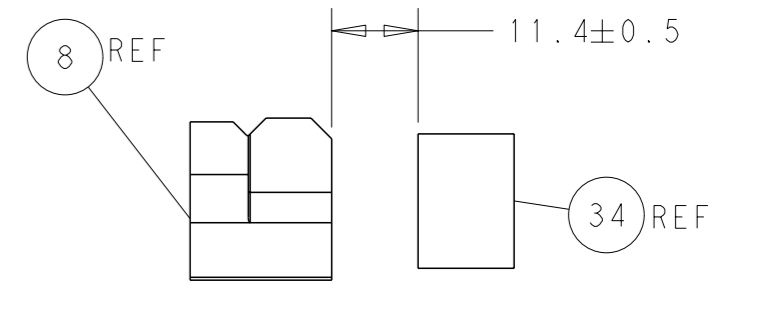
### CAM POSITION



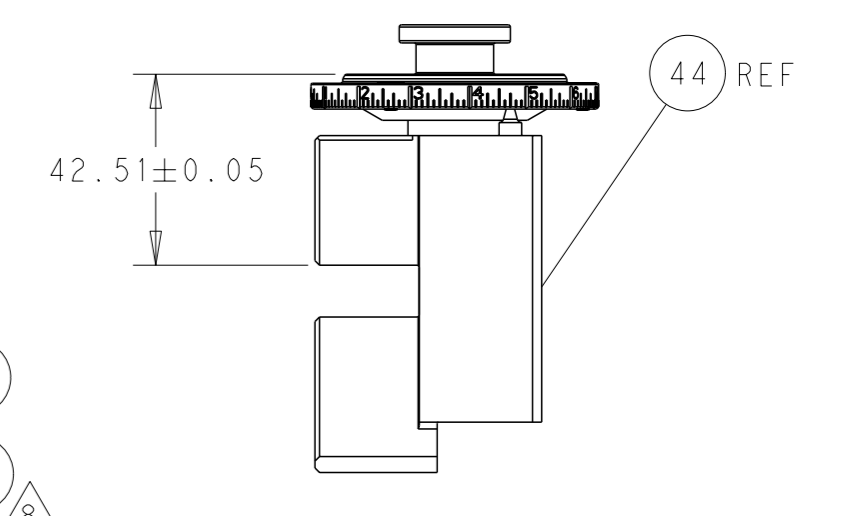
AIR FEED



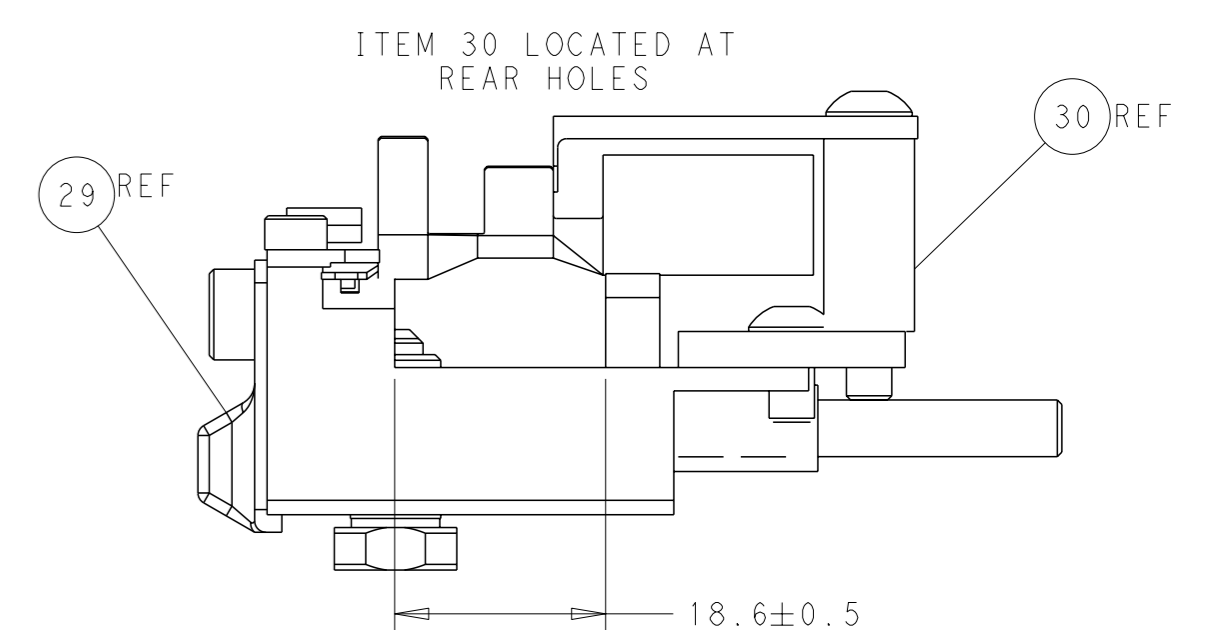
SHEAR DEPRESSOR DETAIL



TERMINAL SUPPORT LOCATION



RAM SET-UP



FEED TRACK POSITION GUIDE BY WIRE BARREL

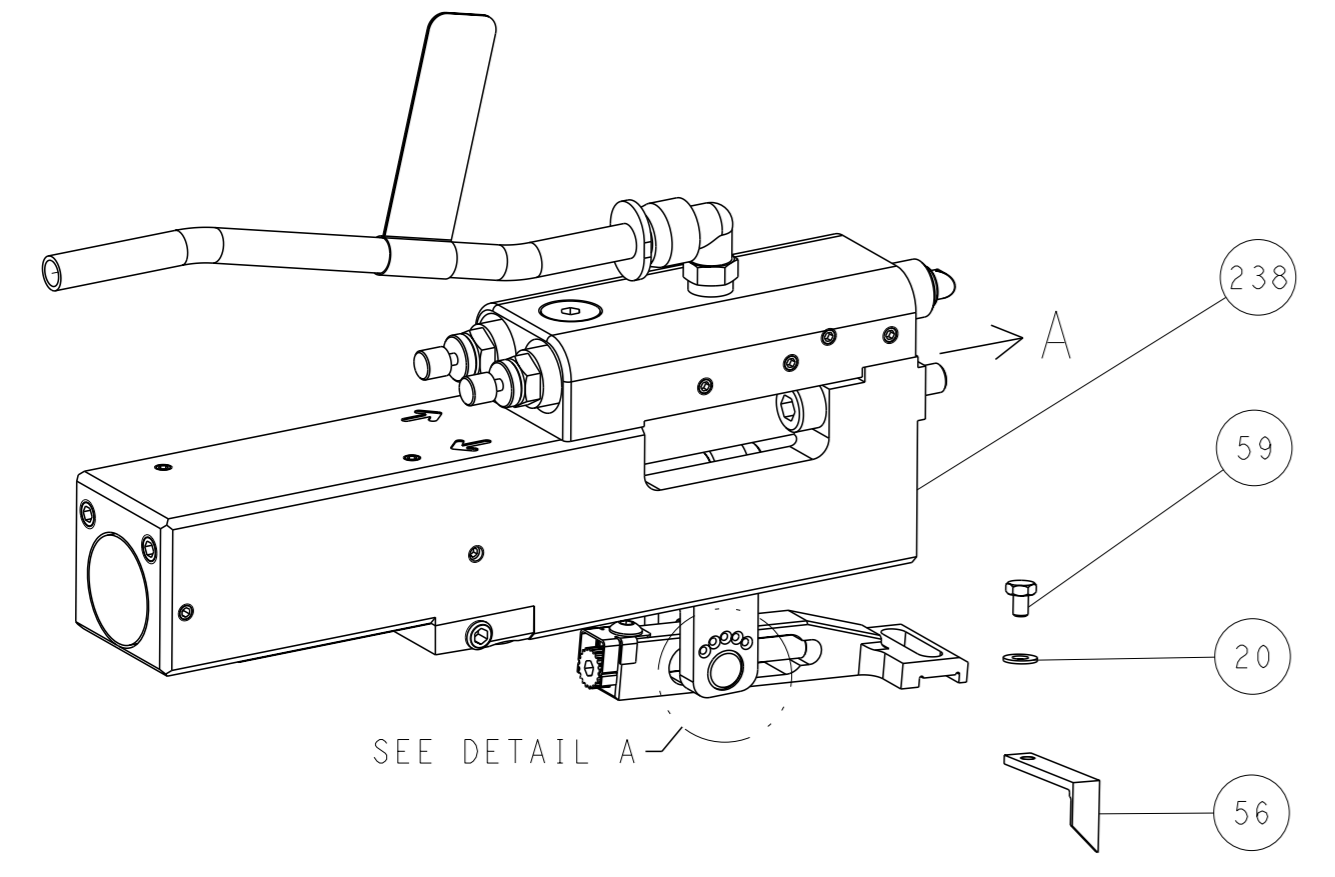
**ATLANTIC VERSION**  
 Shown on sheets 1 of 4 & 2 of 4  
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

<small>THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION. IT IS SUBJECT TO CHANGE AND THE CONTROLLER ENGINEERING DEPARTMENT SHOULD BE CONTACTED FOR THE LATEST REVISION.</small>		DWN: K. HUANG 19OCT2015 CHK: L. ZHANG 19OCT2015 APVD: J. GUO 19OCT2015	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: 2836079 RESTRICTED TO:	SCALE: 1:2 SHEET: 2 of 4 REV: F
MATERIAL:		WEIGHT:	Customer Accessible Production Drawing



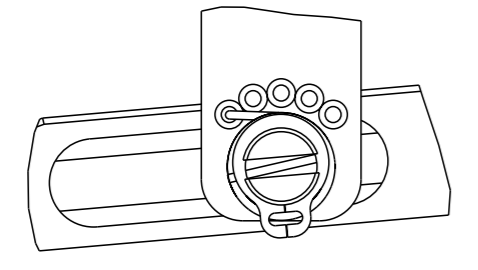
LOC		DIST		REVISIONS			
A	66	P	LYR	DESCRIPTION	DATE	OWN	APVD
		-		SEE SHEET 1	-	-	-

### FEED TYPE PNEUMATIC



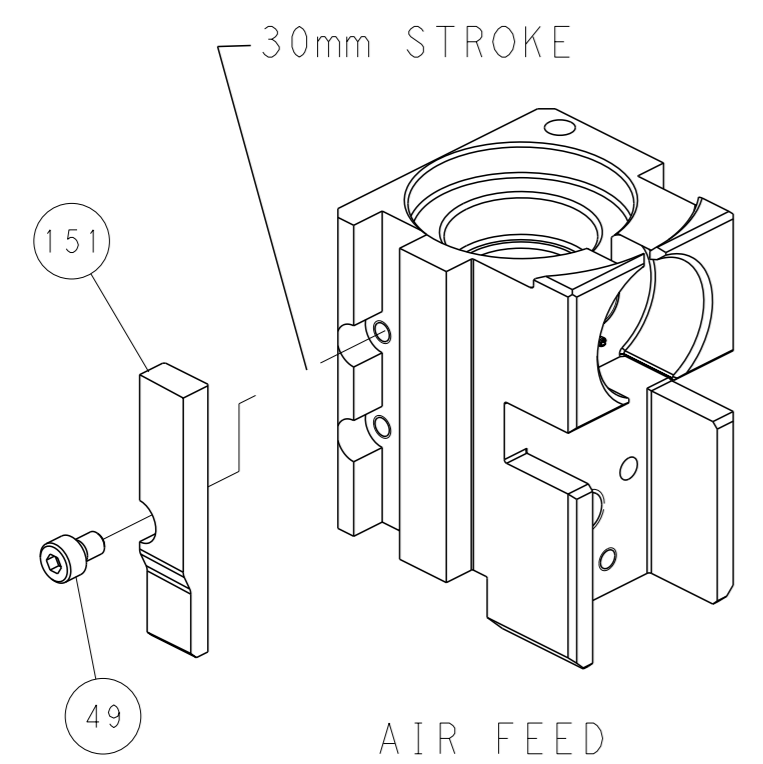
SEE DETAIL A

### FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)

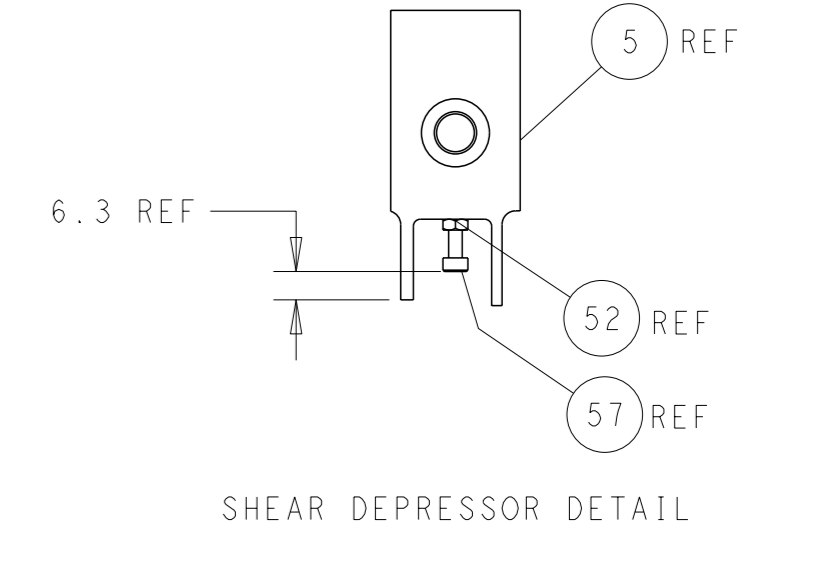
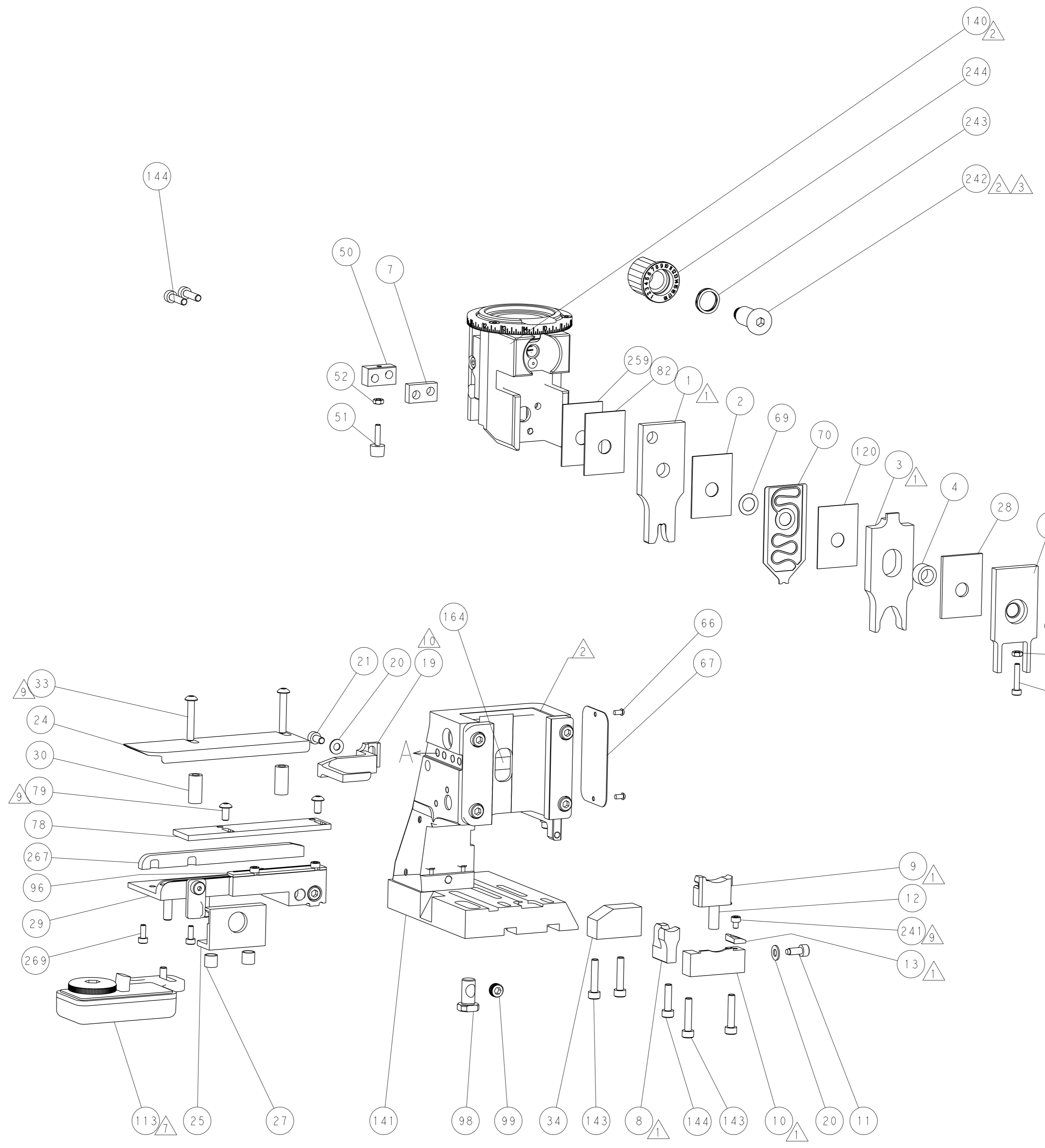


DETAIL A

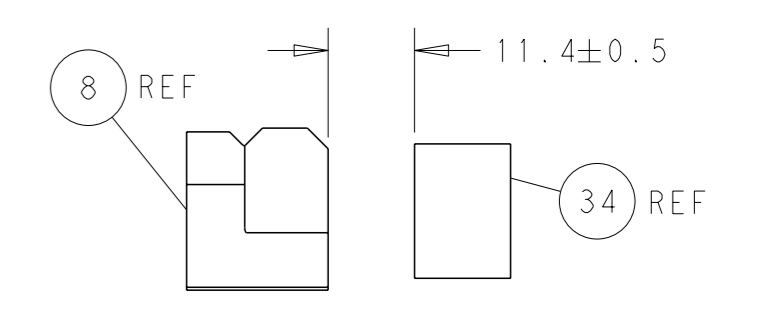
### CAM POSITION



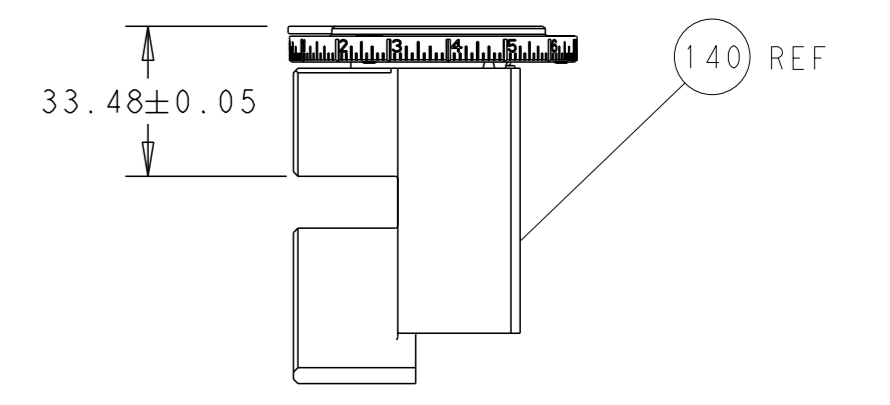
AIR FEED



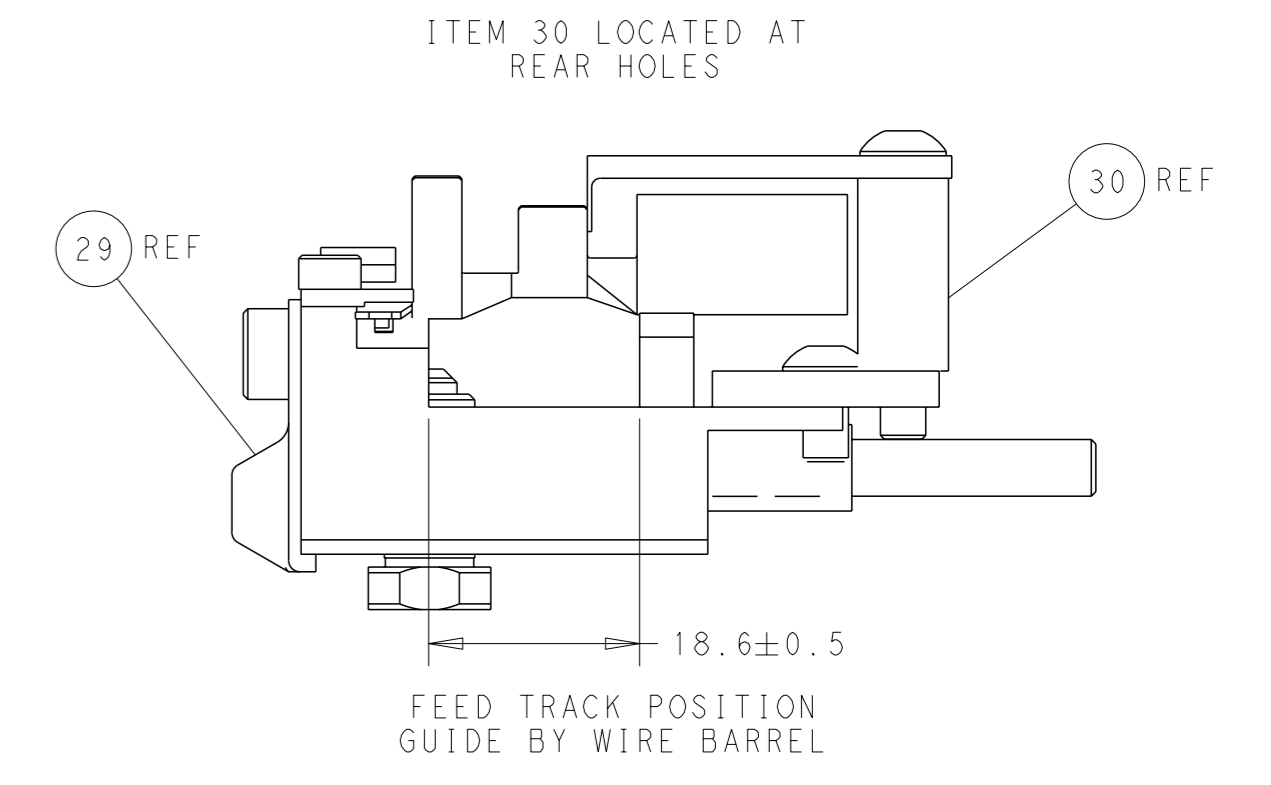
SHEAR DEPRESSOR DETAIL



TERMINAL SUPPORT LOCATION



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 CONTROLLER'S ENGINEERING DEPARTMENT SHOULD BE CONTACTED FOR THE LATEST REVISION.</small>		DWN K. HUANG 19OCT2015 CHK L. ZHANG 19OCT2015 APVD J. GUO 19OCT2015	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=2836079	RESTRICTED TO: - SCALE: 1:2 SHEET: 4 of 4 REV: F
MATERIAL: - WEIGHT: -		Customer Accessible Production Drawing	