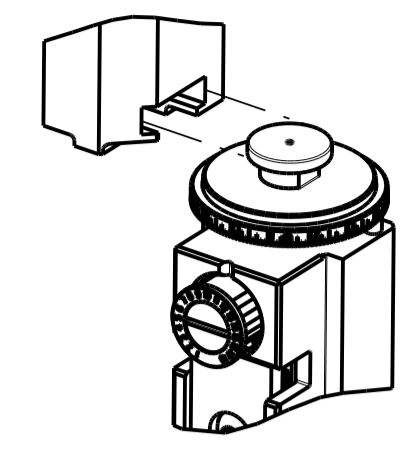


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2836074-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2836074-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
5-2836074-1	B	SEAL STRIPPER CRIMPER TERMINATING UNIT	MECHANICAL
5-2836074-2	C	SEAL STRIPPER CRIMPER TERMINATING UNIT	PNEUMATIC
7-2836074-1	B	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2836074-2	C	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2836074-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA

CRIMP	SIZE	TYPE
WIRE	1.58 mm [.062]	F
INSUL	2.29 mm [.090]	O

APPLICATOR INSTRUCTIONS  
408-35042

TERMINAL DATA: AMPHENOL TERMINAL TE CRIMP SPECIFICATION

TERMINAL NAME: TERMINAL, PIN AND SOCKET

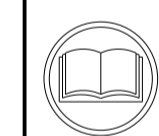
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE
2.50-3.00 mm [.098-.118 IN]	Ø1.00-2.00 mm [.039-.079 IN]

TERMINAL APPLICATION SPECIFICATION: NONE

TERMINALS APPLIED

TE TERMINAL	AMPHENOL TERMINAL	TE TERMINAL	AMPHENOL TERMINAL
1949386-1	TN0201600031	1-1949387-1	TN0101600034
1949386-6	TN0201600032	1-1949387-2	TN0101600039
1949386-7	TN0201600034	1-1949387-3	TN0101600111
1949387-1	TN0101600031	1-1949387-4	TN0101600112
1-1949387-0	TN0101600032		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
20 AWG OR 0.50mm2	1.16+/-0.05 [.046+/- .002]	7.1
22 AWG OR 0.35mm2	1.08+/-0.05 [.043+/- .002]	7.5
24 AWG OR 0.20mm2	1.00+/-0.05 [.039+/- .002]	8.2
26 AWG OR 0.14mm2	0.97+/-0.05 [.038+/- .002]	8.5



- 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. APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 180.
- 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 LUBRICANT IS RECOMMENDED.

**\*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)

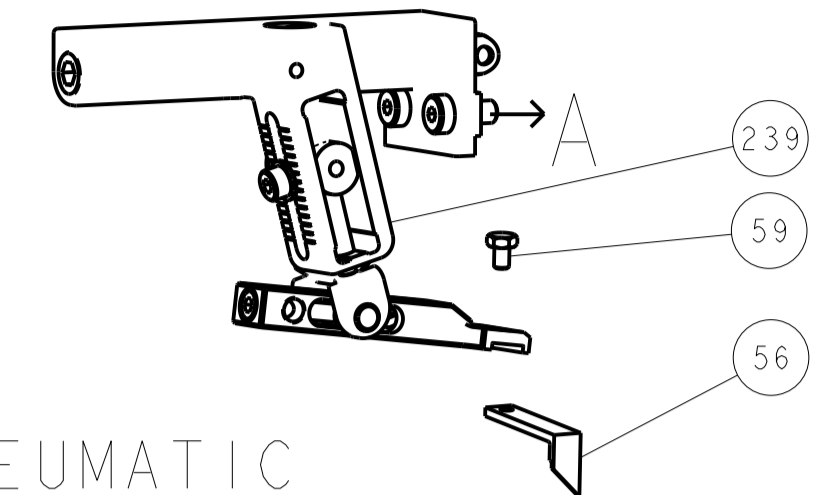
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		B	07SEP2018	TB	TE	
		B1	30NOV2018	TB	TE	
		C	24JUL2019	FJ	TE	

REV	DATE	BY	CHK	APPD	DESCRIPTION	ITEM NO			
-	-	-	1	1	-	1803515-3	RAM ASSEMBLY, SF ATLANTIC	293	
-	-	-	1	1	-	2-1803583-1	APPLICATOR BASIC ASSEMBLY, SF	292	
-	1	1	1	1	1	2119791-9	DEPRESSOR, WIRE	286	
-	2	2	2	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	269	
-	1	1	1	1	1	1633782-3	FENCE	267	
-	1	-	1	-	1	2119641-1	FEED CAM, AIR FEED	248	
-	1	1	1	1	1	2119082-8	CAM, SNAIL, INSULATION ADJUSTMENT	244	
-	1	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243	
-	1	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242	
-	1	1	1	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241	
-	1	-	1	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239	
-	1	-	1	-	1	2844940-1	AIR FEED MODULE	238	
-	-	-	1	1	-	4-1722335-3	STRIPPER, SIDE FEED	182	
-	-	-	1	1	-	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	181	
-	-	-	1	1	-	1-1752354-9	STANDOFF,HOLD-DOWN	180	
-	-	-	1	1	-	9931111-1	PIN, SLOTTED SPRING 3.0 X 20.0	177	
-	-	-	1	1	-	5-22280-0	SPRING, COMPRESSION	176	
-	-	-	1	1	-	1752353-3	GUIDE PIN,HOLDDOWN	175	
-	-	-	1	1	-	1901680-2	GUIDE PIN,HOLDDOWN	174	
-	REF	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164	
-	1	1	1	1	1	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113	
-	1	1	1	1	1	2844908-1	SCREW, LOCKING	99	
-	1	1	1	1	1	2844907-1	POST, LOCKING	98	
-	1	1	1	1	1	455888-5	SPACER, CRIMPER	82	
-	2	2	2	2	2	2079383-4	SCR, BHSC, RoHS (M4 X 8)	79	
-	1	1	1	1	1	1803096-1	EXTENSION PLATE	78	
-	1	1	1	1	1	1803607-3	DOCUMENTATION PACKAGE	71	
-	1	1	1	1	1	2119791-5	DEPRESSOR, WIRE	70	
-	1	1	1	1	1	2119740-1	TAG, IDENTIFICATION	67	
-	2	2	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66	
-	1	1	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	60	
-	1	1	1	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59	
-	1	1	1	1	1	1338683-8	FEED PAWL	56	
-	4	4	4	4	4	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	54	
-	2	2	2	2	2	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	53	
-	1	1	1	1	1	1803382-6	HOLD DOWN, SPRING LOADED	50	
-	1	2	1	2	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49	
-	1	-	1	-	1	2119652-1	FEED CAM, PRE FEED	48	
-	-	1	-	1	-	2119653-1	FEED CAM, POST FEED	47	
-	1	1	-	1	1	1803583-9	APPLICATOR BASIC ASSEMBLY, SF	46	
-	1	1	-	1	1	1803515-1	RAM ASSEMBLY, SF ATLANTIC	44	
-	1	1	1	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41	
-	1	1	1	1	1	1752356-1	SUPPORT, TERMINAL	34	
-	2	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33	
-	2	2	2	2	2	1-2844962-4	SPACER, CYLINDRICAL, STRIP GUIDE	30	
-	1	1	1	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29	
-	1	1	1	1	1	1320928-4	STRIP GUIDE	24	
-	1	1	-	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21	
-	2	2	1	1	2	1-18028-2	WASHER, FLAT, REG M4	20	
-	1	1	-	1	1	2119533-3	STRIPPER, SIDE FEED	19	
-	1	1	1	1	1	2119806-1	INSERT, SHEAR	13	
-	1	1	1	1	1	3-22280-3	SPRING, COMPRESSION	12	
-	1	1	1	1	1	1-356885-4	STOP, SHEAR	11	
-	1	1	1	1	1	2119805-1	SHEAR HOLDER, FRONT	10	
-	1	1	1	1	1	1803095-3	FLOATING SHEAR, FRONT	9	
-	1	2	2	1	1	1	2-1633129-0	ANVIL, COMBINATION .062	8
-	1	1	1	1	1	1	2-240641-5	SPACER	7
-	-	-	-	-	-	-	-	6	
-	1	1	1	1	1	1	2119757-8	DEPRESSOR, SHEAR	5
-	1	1	1	1	1	1	238011-9	BLOCK, CRIMPER SPACER	4
-	1	2	2	1	1	1	1803019-5	CRIMPER, INSULATION O	3
-	1	1	1	1	1	1	455888-1	SPACER, CRIMPER	2
-	1	2	2	1	1	1	4-456403-2	CRIMPER, WIRE PREMIUM	1

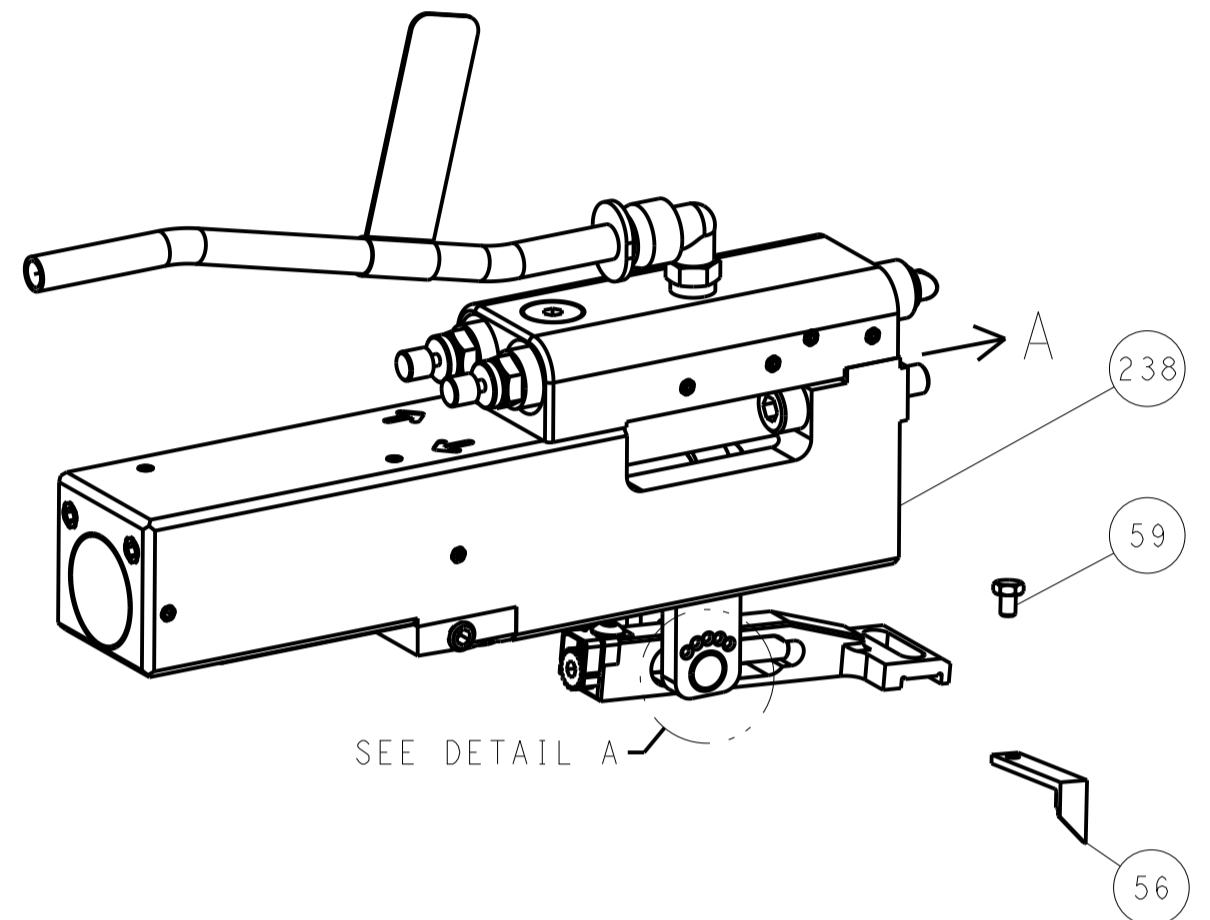
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mm	0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±	22OCT2015	CHAO	ZHAO	ZHAO	TE Connectivity Harrisburg, PA 17105-3608	A1	00779	2836074	Customer Accessible Production Drawing
MATERIAL	FINISH	SCALE	SHEET	OF	REV					

LOC	DIST	REV	DATE	BY	APPV
A	66				
REVISIONS			DATE	BY	APPV
- SEE SHEET 1			-	-	-

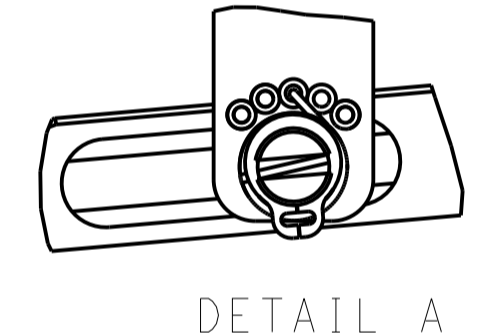
# FEED TYPE MECHANICAL



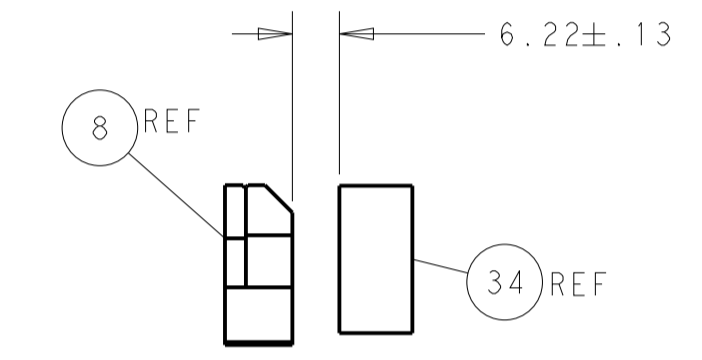
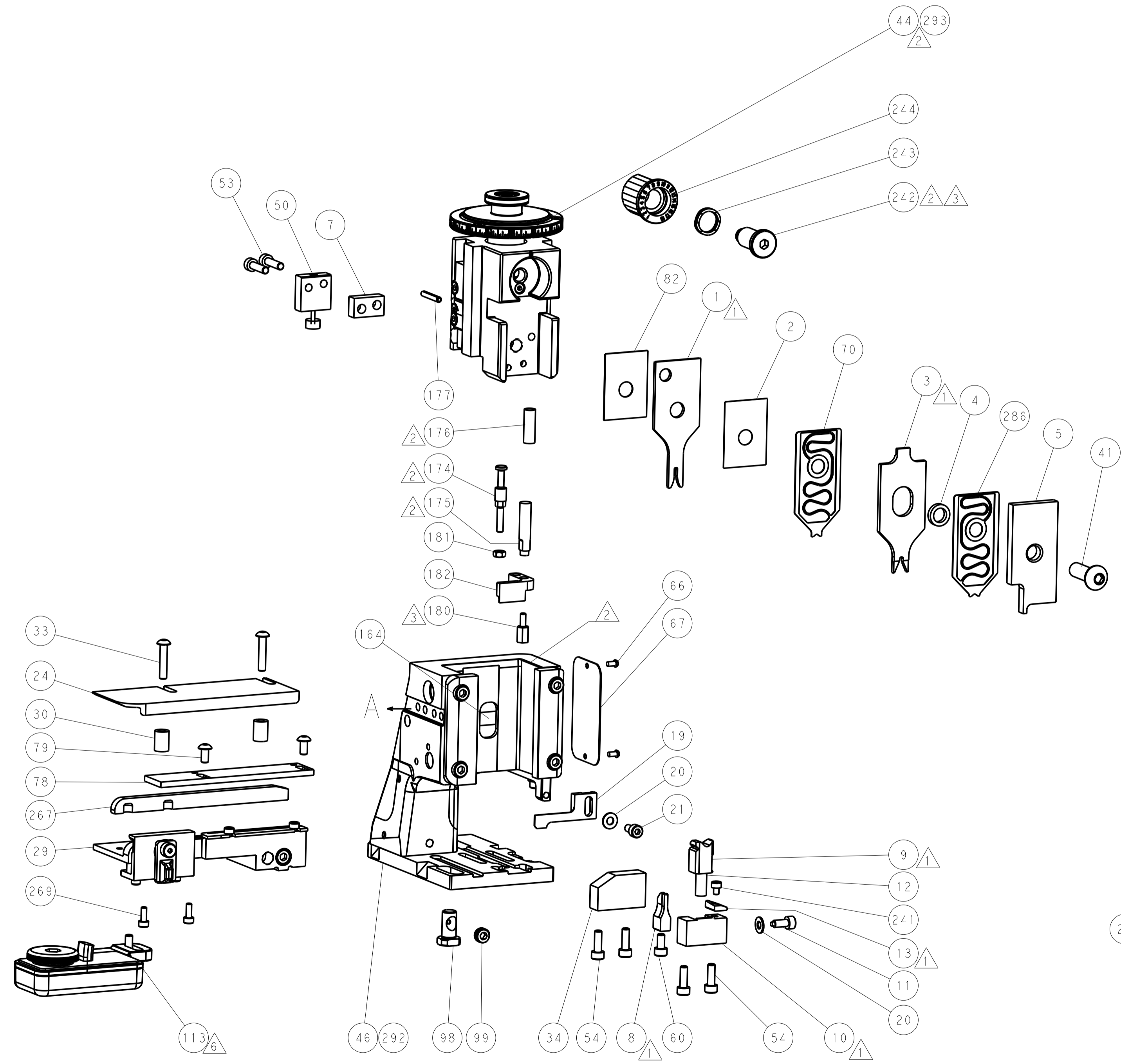
## PNEUMATIC



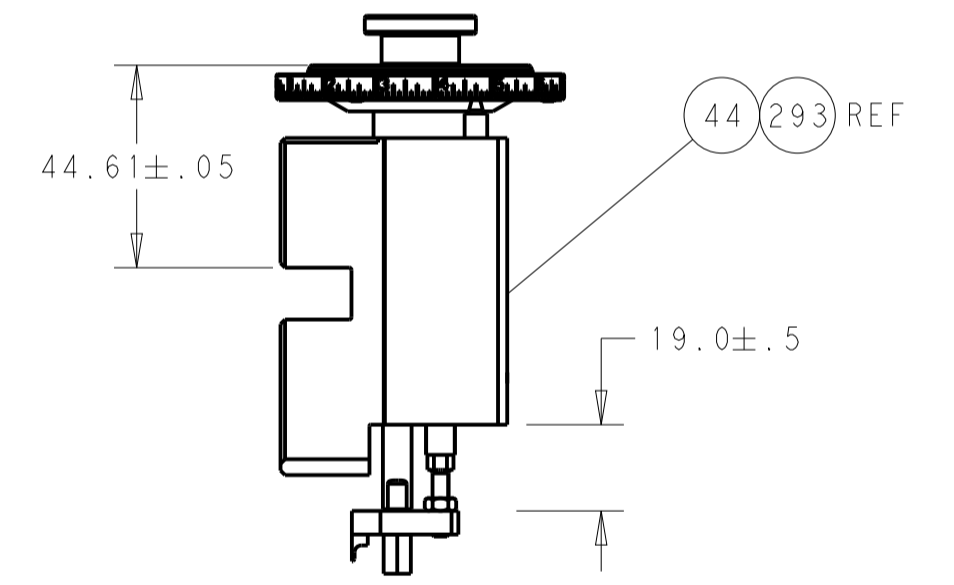
## FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



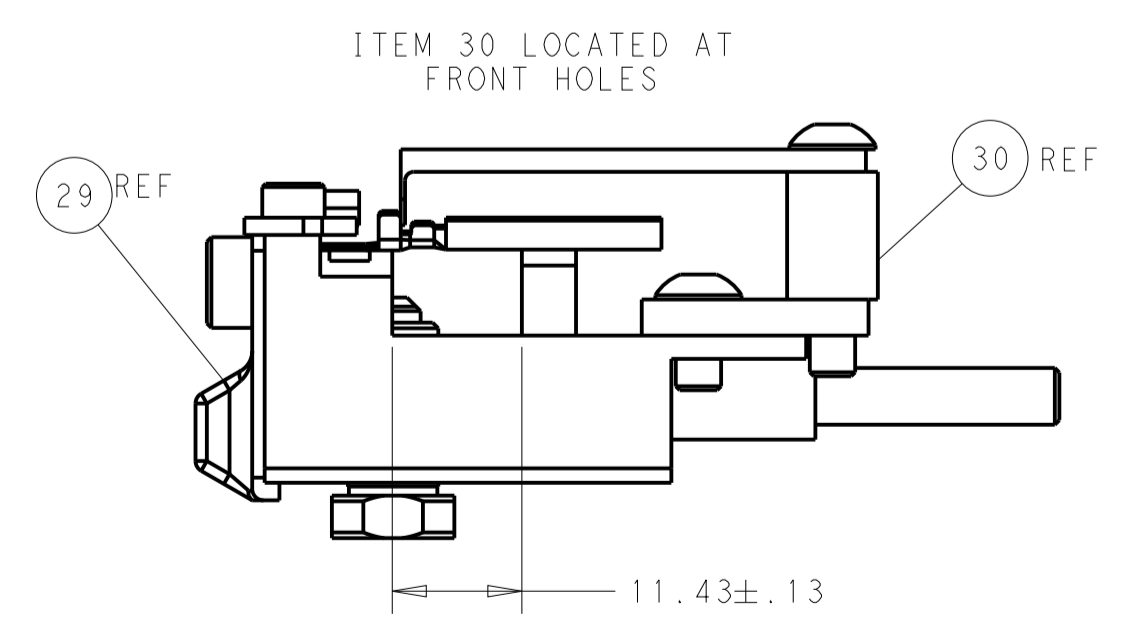
DETAIL A



TERMINAL SUPPORT LOCATION

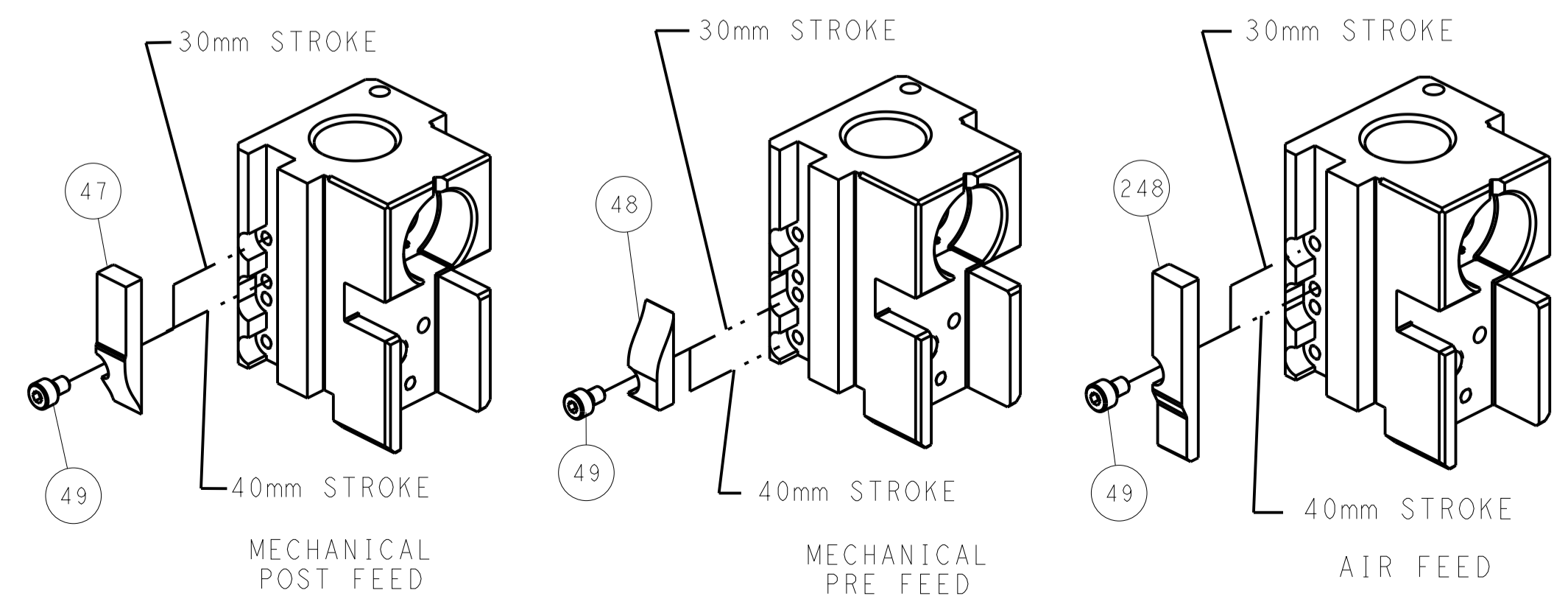


RAM AND HOLDDOWN SET-UP



FEED TRACK POSITION GUIDE BY INSULATION BARREL

# CAM POSITIONS

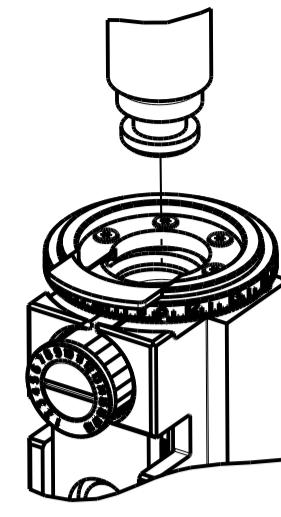


**ATLANTIC VERSION**  
 Shown on sheets 1 of 4 & 2 of 4  
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG: X_ZHAO 22OCT2015		TE Connectivity	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	5 PLC ±	Harrisburg, PA 17105-3608
	ANGLES ±			CHK: L_ZHANG 22OCT2015	NAME: Ocean Side Feed Applicator		
MATERIAL:	FINISH:			APV: H_GUO 22OCT2015	SIZE: CAGE CODE: DRAWING NO: RESTRICTED TO		
				PRODUCT SPEC:		A1 00779 ©=2836074	
				APPLICATION SPEC:		Customer Accessible Production Drawing	
				WEIGHT:		SCALE: 1:2 SHEET 2 OF 4 REV C	

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2836074-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2836074-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2836074-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR  
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.58 mm [0.062]	F
INSUL	2.29 mm [0.090]	O

APPLICATOR INSTRUCTIONS  
408-35042

TERMINAL DATA: AMPHENOL TERMINAL TE CRIMP SPECIFICATION

TERMINAL NAME: TERMINAL, PIN AND SOCKET

WIRE STRIP LENGTH	INSULATION DIAMETER RANGE
2.50-3.00 mm [0.098-.118 IN]	∅1.00-2.00 mm [0.039-.079 IN]

TERMINAL APPLICATION SPECIFICATION	NONE	-	-

TERMINALS APPLIED

TE TERMINAL	AMPHENOL TERMINAL	TE TERMINAL	AMPHENOL TERMINAL
1949386-1	TN0201600031	1-1949387-1	TN0101600034
1949386-6	TN0201600032	1-1949387-2	TN0101600039
1949386-7	TN0201600034	1-1949387-3	TN0101600111
1949387-1	TN0101600031	1-1949387-4	TN0101600112
1-1949387-0	TN0101600032		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
20 AWG OR 0.50mm <sup>2</sup>	1.16 +/- 0.05 [0.046 +/- 0.002]	7.1
22 AWG OR 0.35mm <sup>2</sup>	1.08 +/- 0.05 [0.043 +/- 0.002]	7.5
24 AWG OR 0.20mm <sup>2</sup>	1.00 +/- 0.05 [0.039 +/- 0.002]	8.2
26 AWG OR 0.14mm <sup>2</sup>	0.97 +/- 0.05 [0.038 +/- 0.002]	8.5



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.

UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.

TERMINAL LUBRICANT IS RECOMMENDED.

**\*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	P	LTN	DESCRIPTION	DATE	DMN	APVD
-	-	-	-	SEE SHEET 1	-	-	-

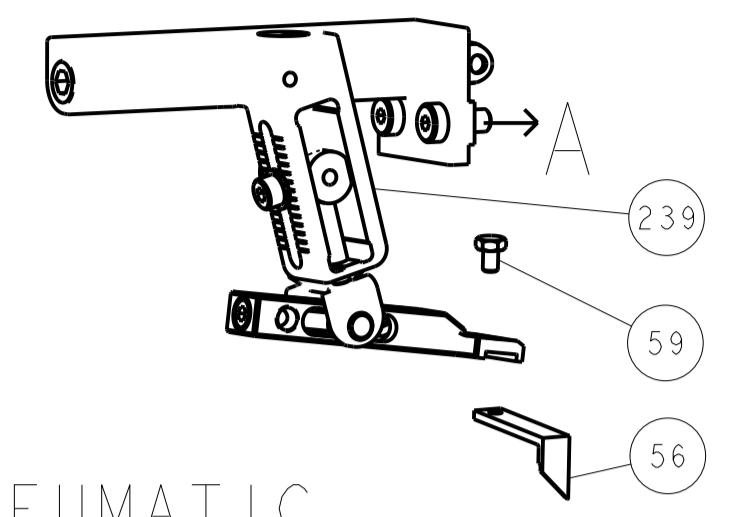
-	1	1	2119791-9	DEPRESSOR, WIRE			286
-	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0			269
-	1	1	1633782-3	FENCE			267
-	1	1	2119082-8	CAM, SNAIL, INSULATION ADJUSTMENT			244
-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST			243
3	1	1	2119083-1	RETAINER, INSULATION DIAL			242
-	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0			241
-	-	1	2119580-1	MECHANICAL FEED ASSEMBLY			239
-	1	-	2844940-1	AIR FEED MODULE			238
-	REF	REF	994970-2	COUNTER, MAGNETIC			164
-	1	-	2119641-2	FEED CAM, AIR FEED			151
-	1	1	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16			144
-	4	4	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20			143
-	-	1	2119653-2	FEED CAM, POST FEED			142
-	1	1	1-1803583-0	APPLICATOR BASIC ASSEMBLY, SF			141
-	1	1	1803516-1	RAM ASSEMBLY, SF PACIFIC			140
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	455888-5	SPACER, CRIMPER			82
-	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	2119791-5	DEPRESSOR, WIRE			70
-	1	1	2119740-1	TAG IDENTIFICATION			67
-	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188			66
-	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0			59
-	1	1	1338683-8	FEED PAWL			56
-	2	2	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16			53
-	1	1	1803382-6	HOLD DOWN, SPRING LOADED			50
-	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
-	1	1	1752356-1	SUPPORT, TERMINAL			34
-	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)			33
-	2	2	1-2844962-4	SPACER, CYLINDRICAL, STRIP GUIDE			30
-	1	1	2844992-1	ASSEMBLY, STRIP GUIDE			29
-	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	2119533-3	STRIPPER, SIDE FEED			19
1	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	2119805-1	SHEAR HOLDER, FRONT			10
1	1	1	1803095-3	FLOATING SHEAR, FRONT			9
1	1	1	2-1633129-0	ANVIL, COMBINATION .062			8
-	1	1	2-240641-5	SPACER			7
-	-	-	-	-			6
-	1	1	2119757-8	DEPRESSOR, SHEAR			5
-	1	1	238011-9	BLOCK, CRIMPER SPACER			4
1	1	1	1803019-5	CRIMPER, INSULATION O			3
-	1	1	455888-1	SPACER, CRIMPER			2
1	1	1	4-456403-2	CRIMPER, WIRE PREMIUM			1

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

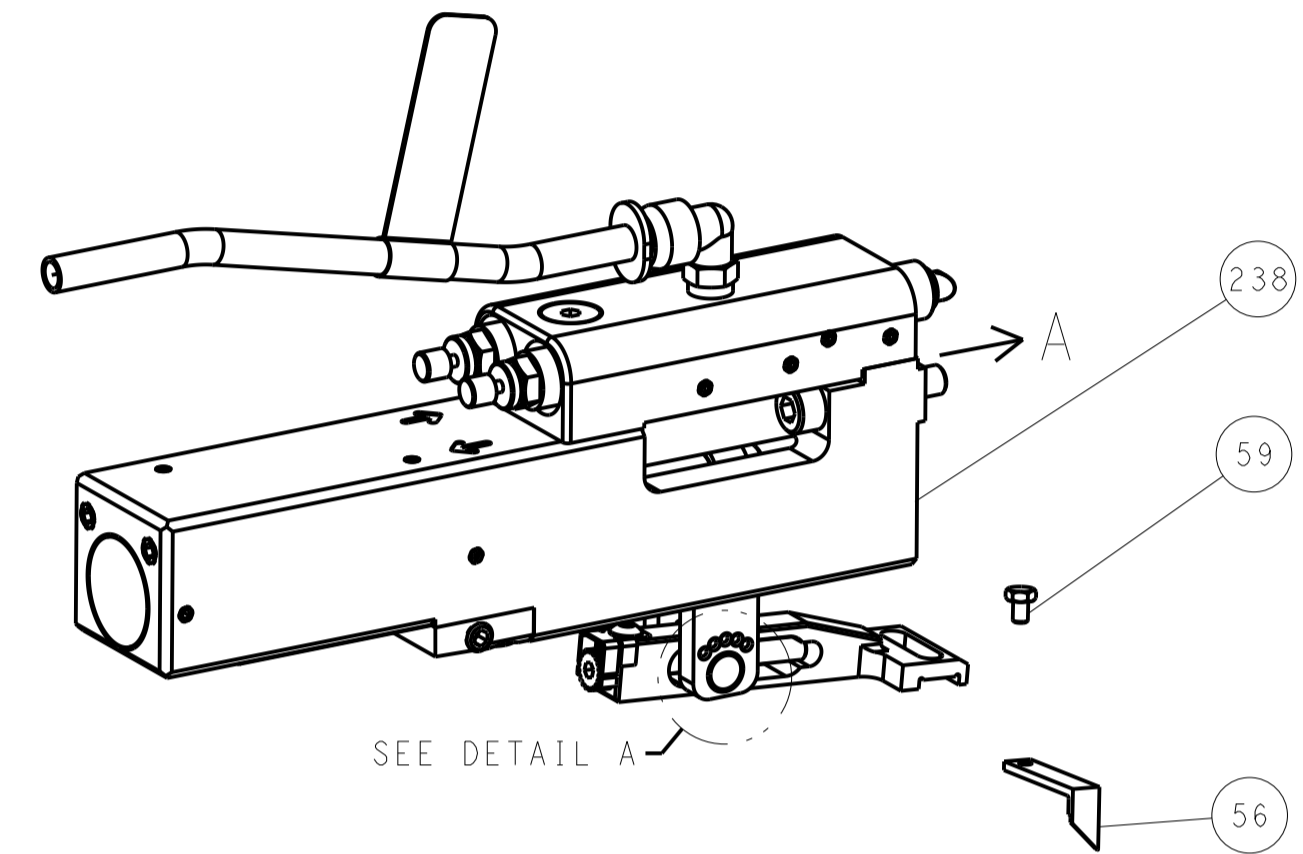
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG: X.ZHAO 22OCT2015		CHK: L.ZHANG 22OCT2015		APVD: H.GUO 22OCT2015		NAME: Ocean Side Feed Applicator	
MATERIAL:		FINISH:		PRODUCT SPEC:		APPLICATION SPEC:		SIZE: A1		CAGE CODE: 00779	
				WEIGHT:		SCALE: 1:2		SHEET: 3 OF 4		REV: C	

LOC	DIST	REV	DATE	BY	APPV
A	66				

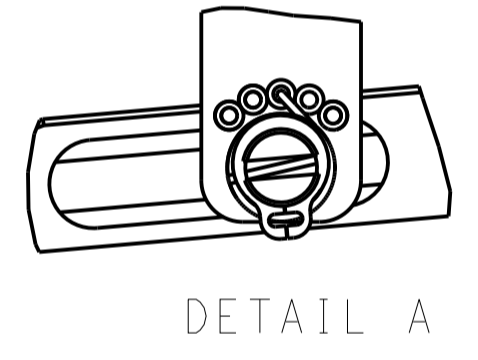
# FEED TYPE MECHANICAL



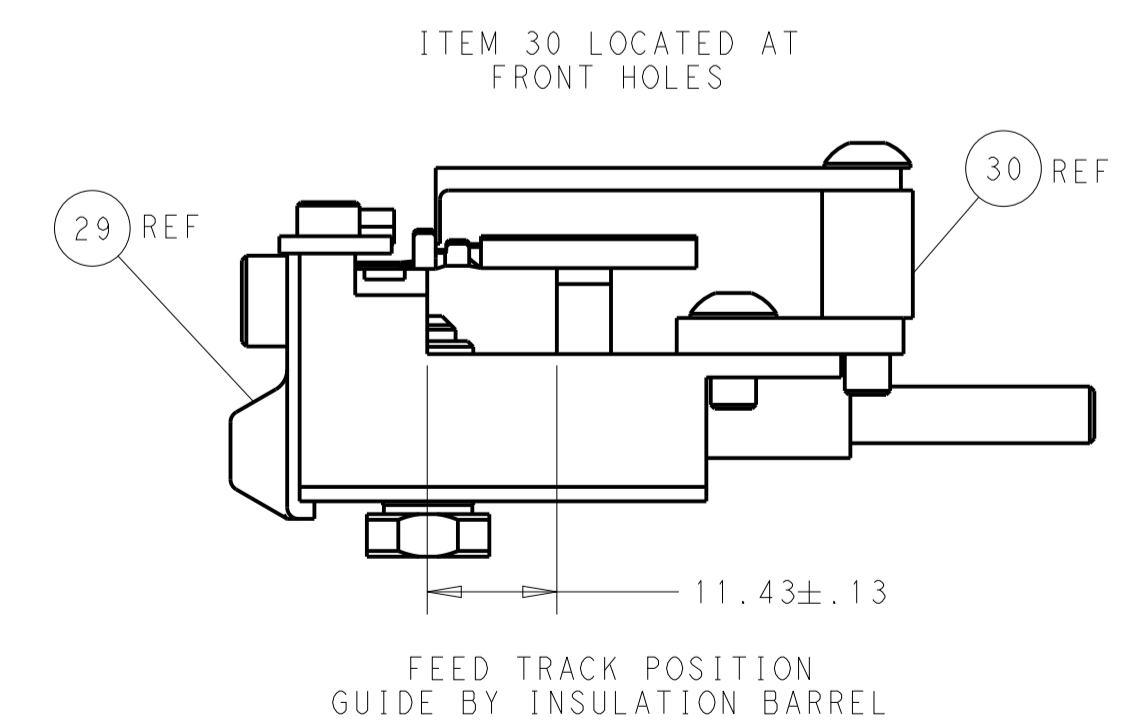
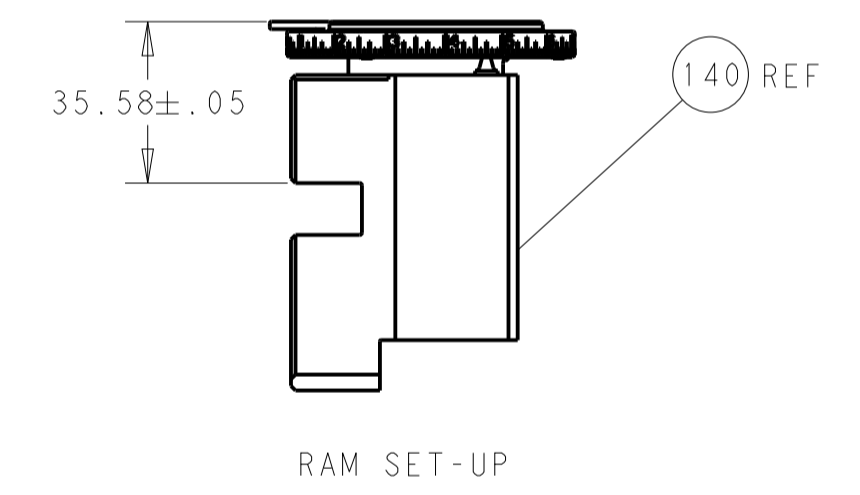
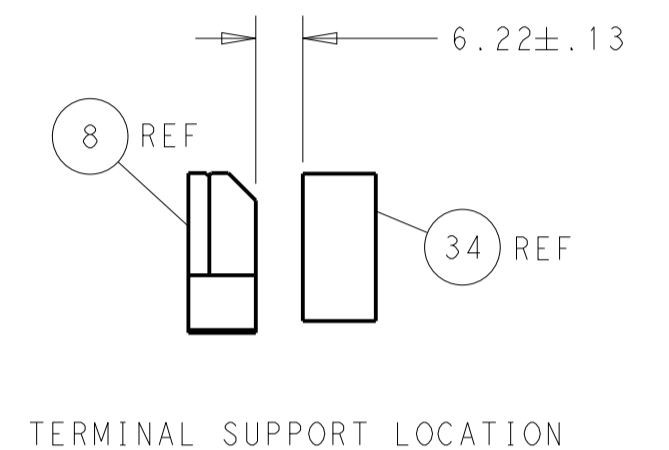
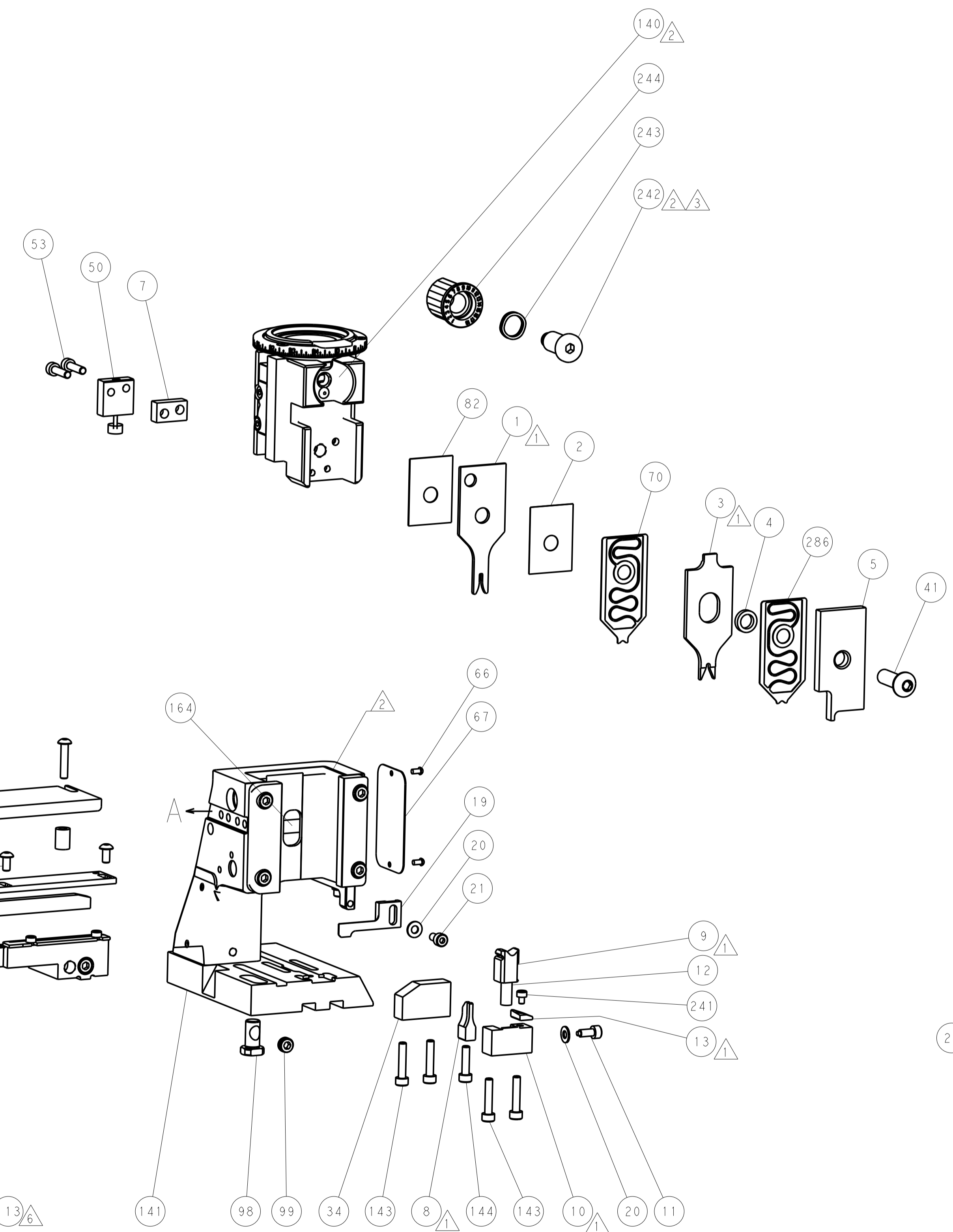
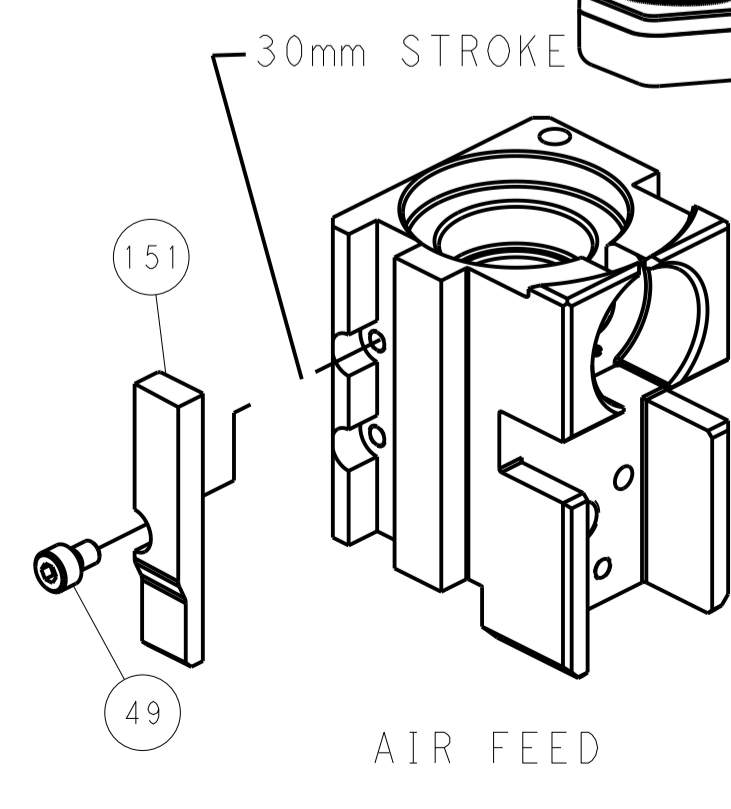
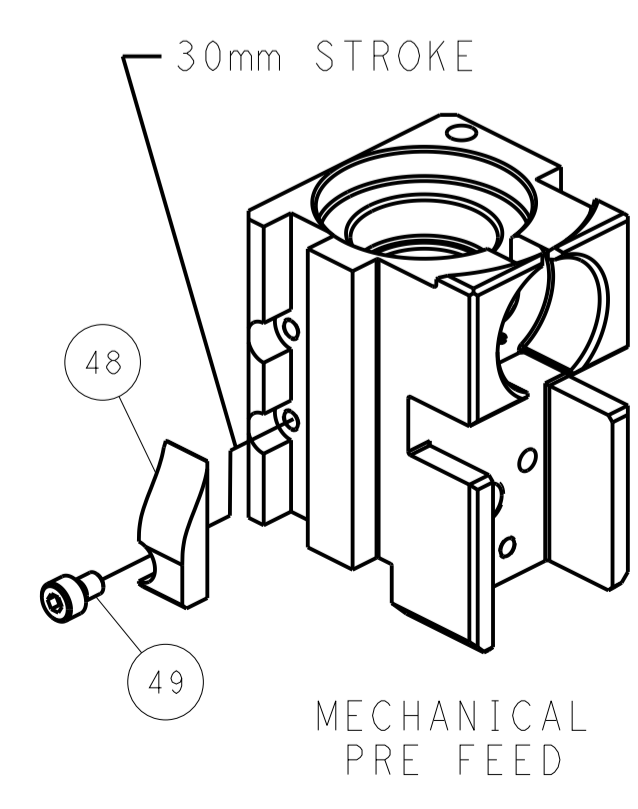
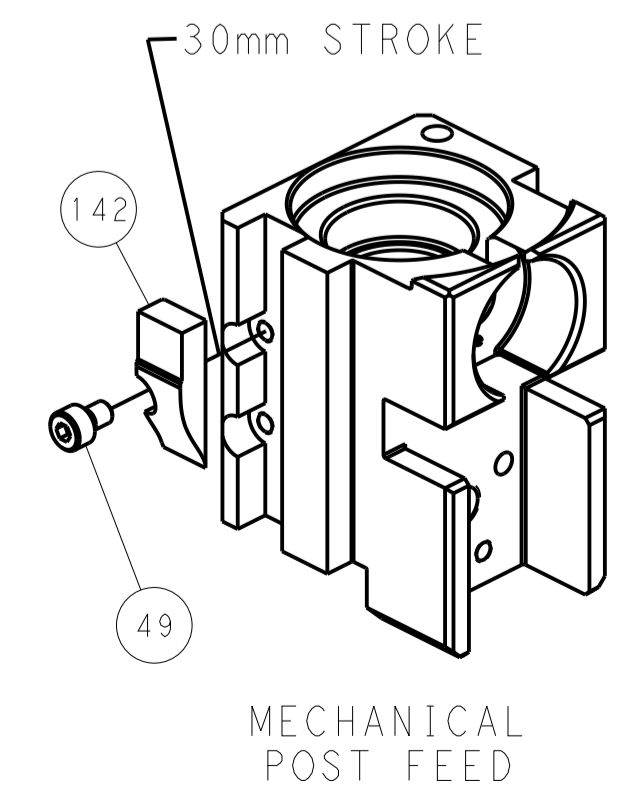
## PNEUMATIC



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



# CAM POSITIONS



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

DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		DWN X ZHAO 22OCT2015 CHK L ZHANG 22OCT2015 APVD H GUO 22OCT2015		NAME Ocean Side Feed Applicator	
MATERIAL FINISH		WEIGHT SCALE 1:2		SIZE CAGE CODE DRAWING NO A 00779 C=2836074		RESTRICTED TO SHEET 4 OF 4 REV C	