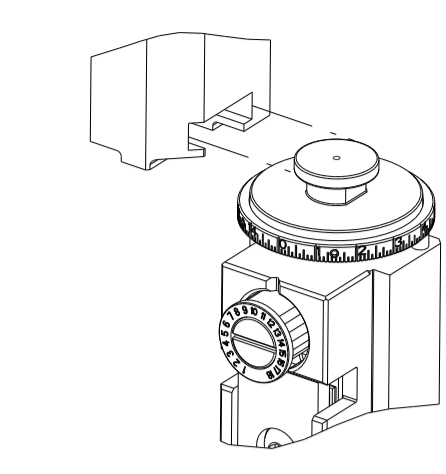


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2836080-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2836080-2	C	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2836080-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.29 mm [.090]	F
INSUL	3.30 mm [.130]	F

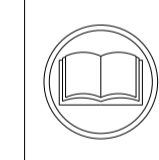
APPLICATOR INSTRUCTIONS 408-35042

TERMINAL DATA: TE TERMINAL				TE CRIMP SPECIFICATION			
TERMINAL NAME: POSITIVE LOCK RECEPTACLE CONTACT							
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE		WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
5.40-6.16 mm [.213-.243 IN]		Ø1.50-2.40 mm [.059-.094 IN]		5.40-6.16 mm [.213-.243 IN]		Ø1.50-2.40 mm [.059-.094 IN]	
TERMINAL APPLICATION SPECIFICATION				TERMINAL APPLICATION SPECIFICATION			
(A)1114-20036				(B)1114-20029			
TERMINALS APPLIED				TERMINALS APPLIED			
TE TERMINAL		TE TERMINAL		TE TERMINAL		TE TERMINAL	
(A) 282167-1		(A) 282167-3					

TERMINAL DATA: TE TERMINAL				TE CRIMP SPECIFICATION			
TERMINAL NAME: AMP POSITIVE LOCK TERMINAL WITH LATCHING DEVICE							
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE		WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
5.40-6.16 mm [.213-.243 IN]		Ø1.50-2.40 mm [.059-.094 IN]		5.40-6.16 mm [.213-.243 IN]		Ø1.50-2.40 mm [.059-.094 IN]	
TERMINAL APPLICATION SPECIFICATION				TERMINAL APPLICATION SPECIFICATION			
(A)1114-20036				(B)1114-20029			
TERMINALS APPLIED				TERMINALS APPLIED			
TE TERMINAL		TE TERMINAL		TE TERMINAL		TE TERMINAL	
(B) 282162-1							

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.50mm2	1.65+/-0.03 [.065+/- .001]	6.8
1.00mm2	1.60+/-0.03 [.063+/- .001]	7.3
0.75mm2	1.50+/-0.03 [.059+/- .001]	8.3
0.50mm2	1.45+/-0.03 [.057+/- .001]	8.9

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.50mm2	1.65+/-0.03 [.065+/- .001]	6.8
1.00mm2	1.60+/-0.03 [.063+/- .001]	7.3
0.75mm2	1.50+/-0.03 [.059+/- .001]	8.3
0.50mm2	1.45+/-0.03 [.057+/- .001]	8.9



- 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.

***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	APPD
		A	RELEASED	04DEC2015	KH TE
		B	ECR-22-134482	31MAR2022	TB RK
		C	ECR-22-147086	22JUL2022	FJ TE

-	1	1	2119641-1	FEED CAM, AIR FEED	248
-	1	1	2119082-6	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	2844940-2	AIR FEED MODULE	238
-	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	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	455888-6	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
-	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	1-1338683-6	FEED PAWL	56
-	4	4	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	54
-	2	2	2-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 14	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
-	1	1	1-1752356-3	SUPPORT, TERMINAL	34
-	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	2-2844962-8	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29
-	1	1	455888-3	SPACER, CRIMPER	28
-	1	1	1320928-2	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	2119533-1	STRIPPER, SIDE FEED	19
-	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	2119805-1	SHEAR HOLDER, FRONT	10
-	1	1	1803095-6	FLOATING SHEAR, FRONT	9
-	1	2	1-1633921-1	ANVIL, COMBINATION	8
-	1	1	240641-5	SPACER	7
-	-	-	-	-	6
-	1	1	2119757-8	DEPRESSOR, SHEAR	5
-	1	1	238011-4	BLOCK, CRIMPER SPACER	4
-	1	2	5-1803187-5	CRIMPER, INSULATION F	3
-	1	1	455888-7	SPACER, CRIMPER	2
-	1	2	5-1803188-3	CRIMPER, WIRE	1

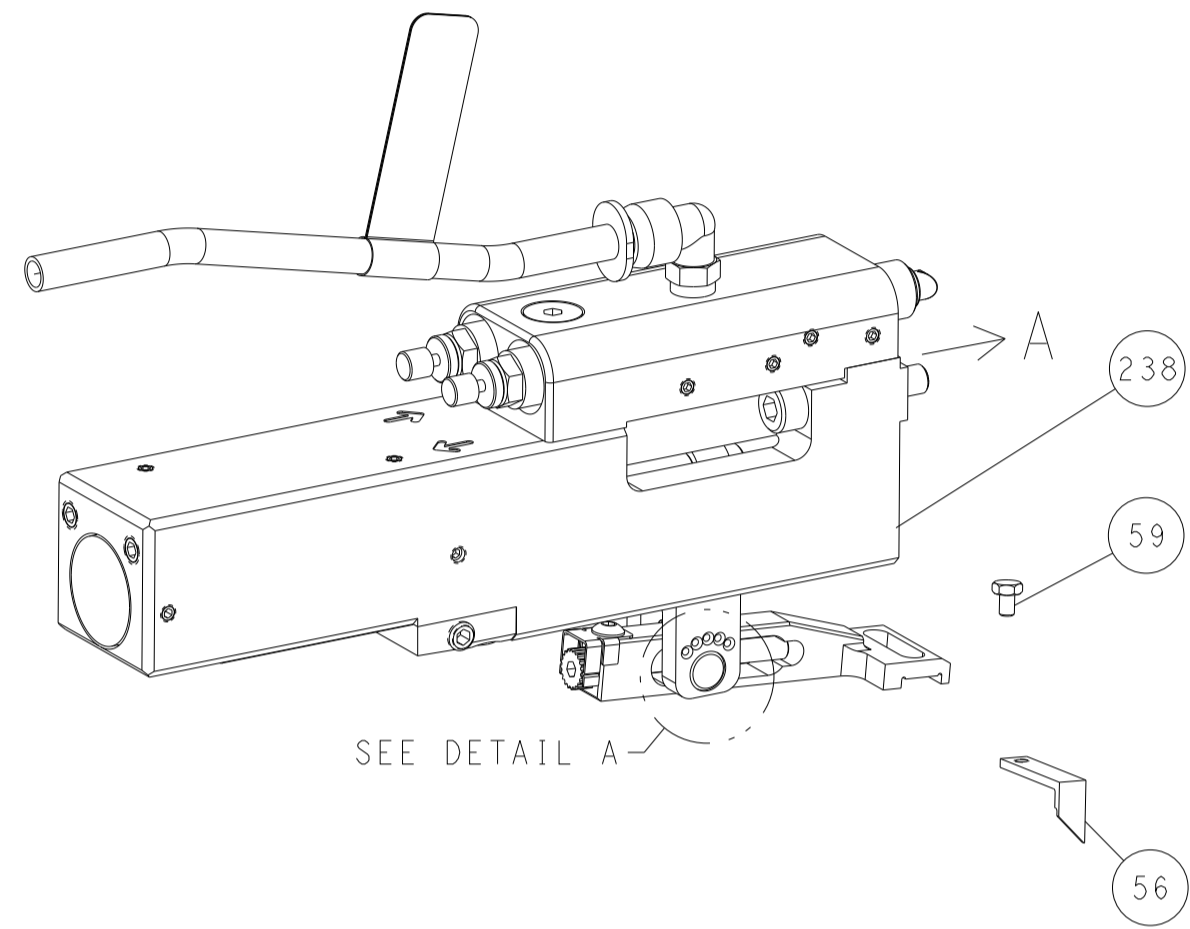
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		MATERIAL:		FINISH:		WEIGHT:		SCALE:	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES	FINISH	WT	SCALE	SHEET	REV
									1:2	1 OF 4	C

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			
P	LTN	DESCRIPTION	DATE	OWN	APVD
A	66	SEE SHEET 1	-	-	-

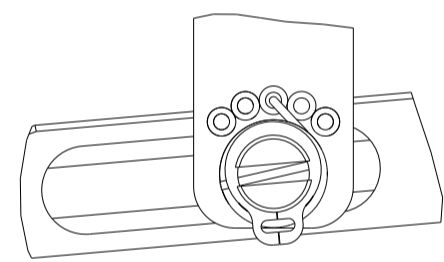
FEED TYPE

PNEUMATIC



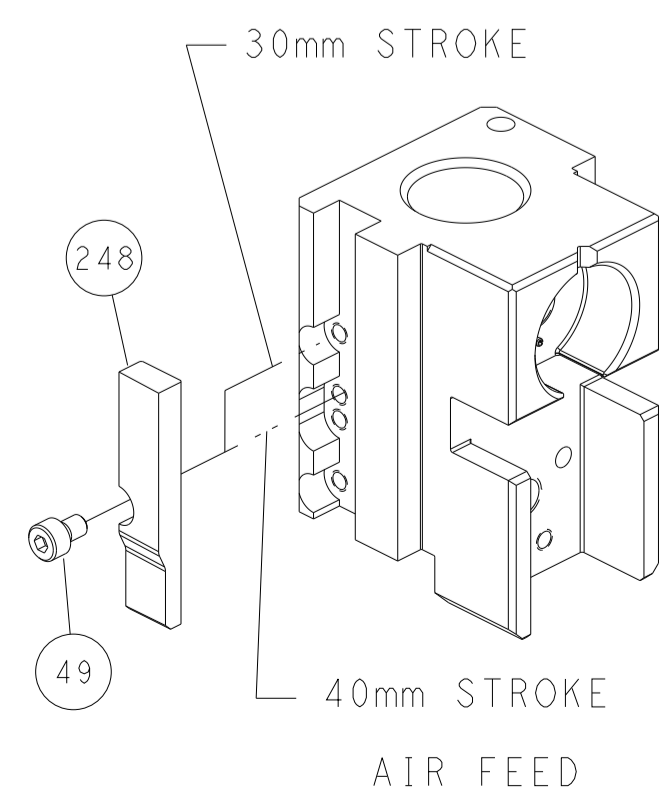
SEE DETAIL A

FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)

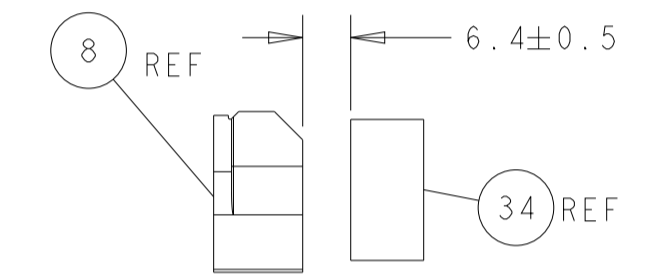
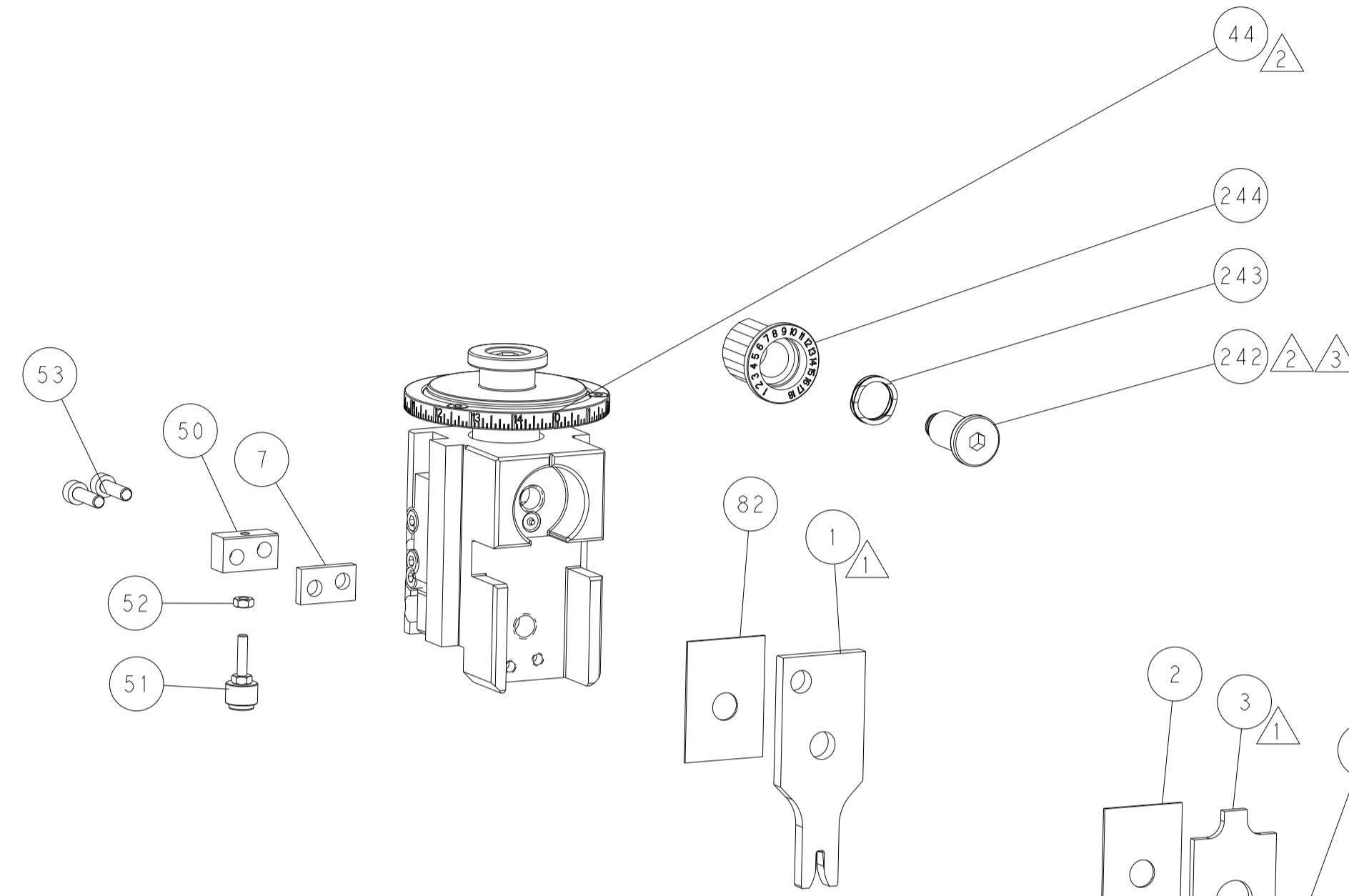


DETAIL A

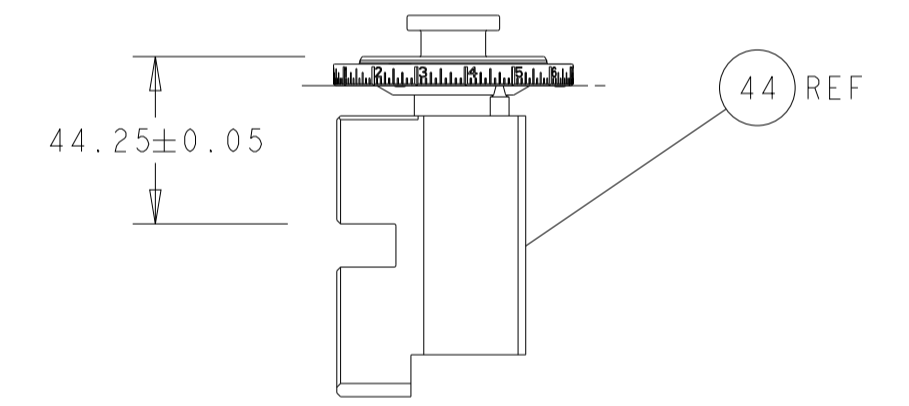
CAM POSITION



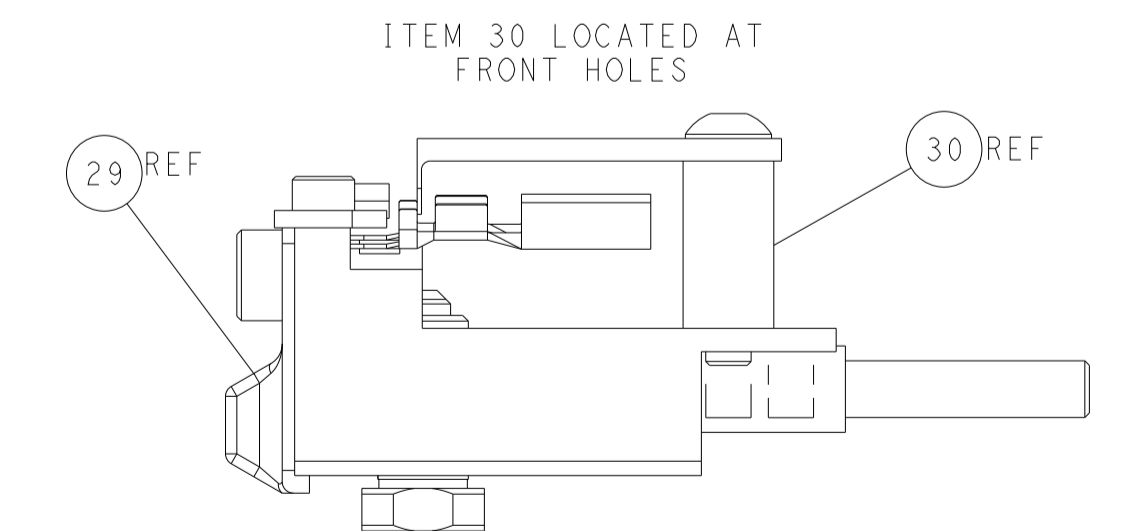
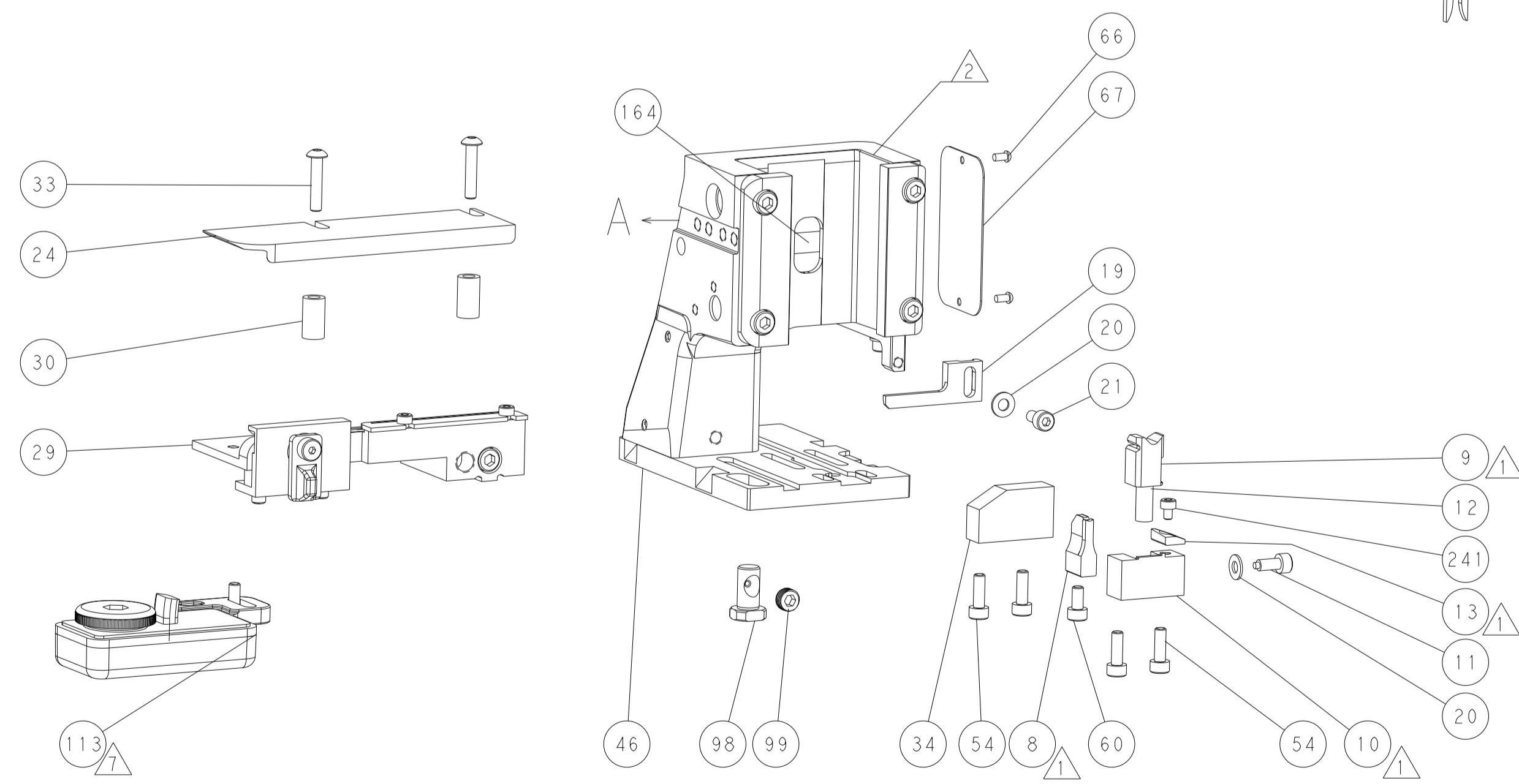
AIR FEED



TERMINAL SUPPORT LOCATION



RAM SET-UP



FEED TRACK POSITION GUIDE BY INSULATION BARREL

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:		OWN	15OCT2015	TE Connectivity Harrisburg, PA 17105-3608	
mm	0 PLC ±	1 PLC ±	2 PLC ±	CHK	15OCT2015		
	3 PLC ±	4 PLC ±	ANGLES ±	APVD	15OCT2015	NAME	
	MATERIAL	FINISH	WEIGHT	J. GUO L. ZHANG U. GUO		Ocean Side Feed Applicator	
Customer Accessible Production Drawing		SCALE	1:2	SHEET	2 of 4	REV	C

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2836080-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2836080-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



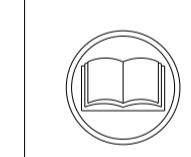
APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.29 mm [.090]	F
INSUL	3.30 mm [.130]	F
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: POSITIVE LOCK RECEPTACLE CONTACT			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
5.40-6.16 mm [.213-.243 IN]		Ø1.50-2.40 mm [.059-.094 IN]	
TERMINAL APPLICATION SPECIFICATION	(A)114-20036	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
(A) 282167-1	(A) 282167-3		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: AMP POSITIVE LOCK TERMINAL WITH LATCHING DEVICE			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
5.40-6.16 mm [.213-.243 IN]		Ø1.50-2.40 mm [.059-.094 IN]	
TERMINAL APPLICATION SPECIFICATION	(B)114-20029	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
(B) 282162-1			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.50mm2	1.65+/-0.03 [.065+/-0.001]	6.8
1.00mm2	1.60+/-0.03 [.063+/-0.001]	7.3
0.75mm2	1.50+/-0.03 [.059+/-0.001]	8.3
0.50mm2	1.45+/-0.03 [.057+/-0.001]	8.9

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.50mm2	1.65+/-0.03 [.065+/-0.001]	6.8
1.00mm2	1.60+/-0.03 [.063+/-0.001]	7.3
0.75mm2	1.50+/-0.03 [.059+/-0.001]	8.3
0.50mm2	1.45+/-0.03 [.057+/-0.001]	8.9



- 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.
- 5. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- 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.

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

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

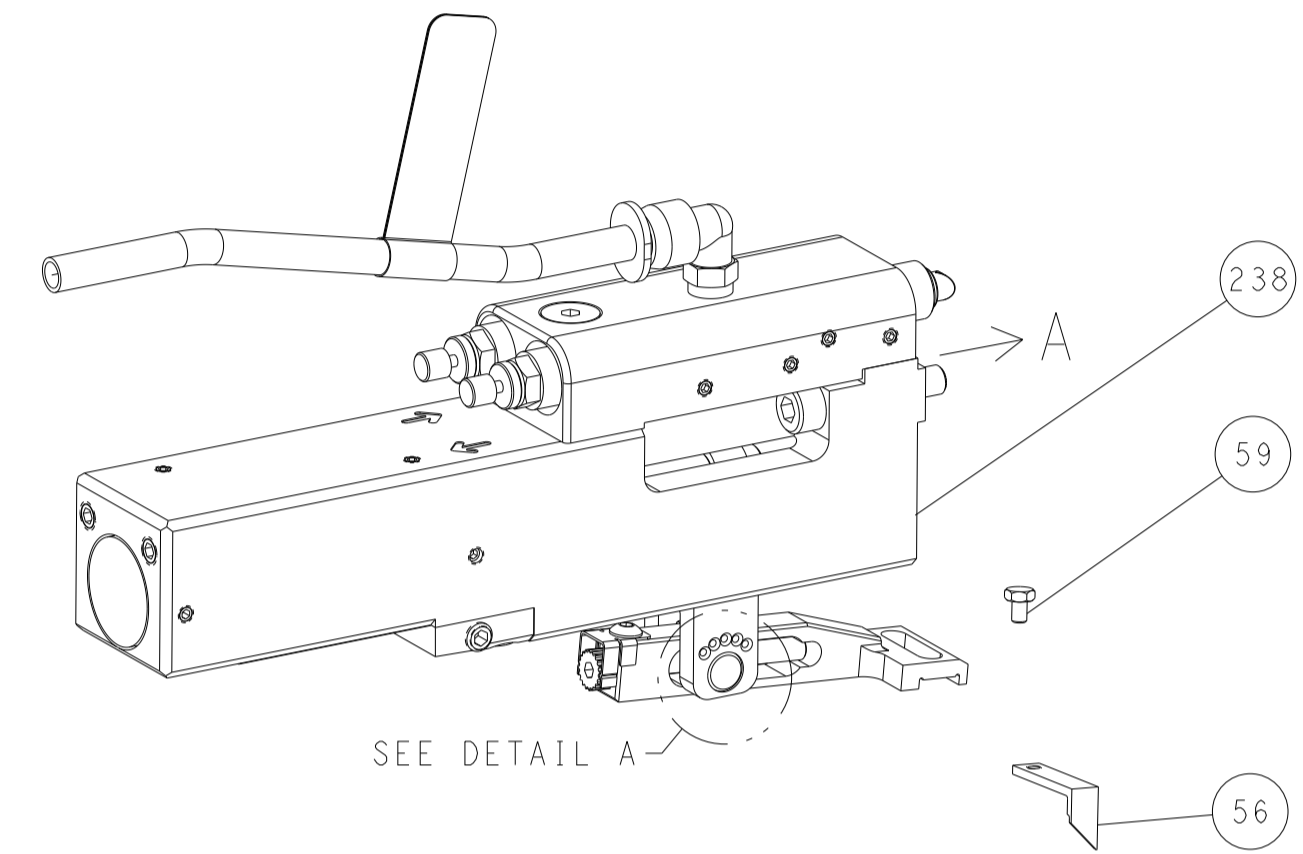
-	1	2119082-6	CAM, SNAIL, INSULATION ADJUSTMENT	244	
-	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243	
-	1	2119083-1	RETAINER, INSULATION DIAL	242	
-	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241	
-	1	2844940-2	AIR FEED MODULE	238	
-	REF	994970-2	COUNTER, MAGNETIC	164	
-	1	2119641-2	FEED CAM, AIR FEED	151	
-	1	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	144	
-	4	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	143	
-	1	1-1803583-0	APPLICATOR BASIC ASSEMBLY, SF	141	
-	1	1803516-1	RAM ASSEMBLY, SF PACIFIC	140	
-	1	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113	
-	1	2844908-1	SCREW, LOCKING	99	
-	1	2844907-1	POST, LOCKING	98	
-	1	455888-6	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	
-	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59	
-	1	1-1338683-6	FEED PAWL	56	
-	2	2-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 14	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	
-	1	1-1752356-3	SUPPORT, TERMINAL	34	
-	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33	
-	2	2-2844962-8	SPACER, CYLINDRICAL, STRIP GUIDE	30	
-	1	2844992-1	ASSEMBLY, STRIP GUIDE	29	
-	1	455888-3	SPACER, CRIMPER	28	
-	1	1320928-2	STRIP GUIDE	24	
-	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21	
-	2	1-18028-2	WASHER, FLAT, REG M4	20	
-	1	2119533-1	STRIPPER, SIDE FEED	19	
-	1	2119806-1	INSERT, SHEAR	13	
-	1	3-22280-3	SPRING, COMPRESSION	12	
-	1	1-356885-4	STOP, SHEAR	11	
-	1	2119805-1	SHEAR HOLDER, FRONT	10	
-	1	1803095-6	FLOATING SHEAR, FRONT	9	
-	1	2-1633921-1	ANVIL, COMBINATION	8	
-	1	240641-5	SPACER	7	
-	-	-	-	6	
-	1	2119757-8	DEPRESSOR, SHEAR	5	
-	1	238011-4	BLOCK, CRIMPER SPACER	4	
-	1	5-1803187-5	CRIMPER, INSULATION F	3	
-	1	455888-7	SPACER, CRIMPER	2	
-	1	5-1803188-3	CRIMPER, WIRE	1	
-	77	-22	PART NO	DESCRIPTION	ITEM NO

<small>THIS DRAWING IS A CONTROLLED DOCUMENT. FOR THE LATEST REVISION INFORMATION, IT IS THE USER'S RESPONSIBILITY TO CONTACT THE CONTROLLING ORGANIZATION. SHOULD BE CONTACTED FOR THE LATEST POSITION.</small>		DWN: J. HOU 15OCT2015 CHK: L. ZHANG 15OCT2015 APVD: U. GUO 15OCT2015	TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH	PRODUCT SPEC APPLICATION SPEC	NAME: Ocean Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2836080 RESTRICTED TO:	SCALE: 1:2 SHEET: 3 OF 4 REV: C
MATERIAL: -		WEIGHT: -	Customer Accessible Production Drawing

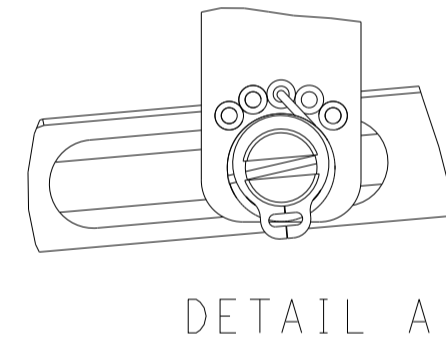
LOC	DIST	REVISIONS					
A	66	P	LTM	DESCRIPTION	DATE	OWN	APVD
		-		SEE SHEET 1			

FEED TYPE

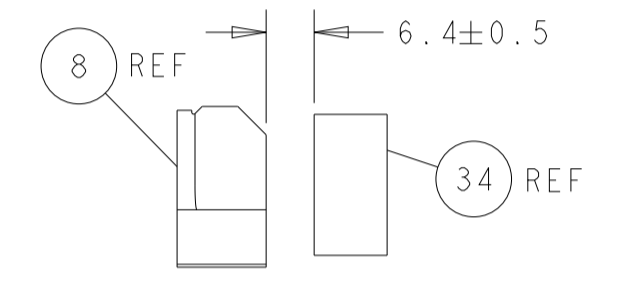
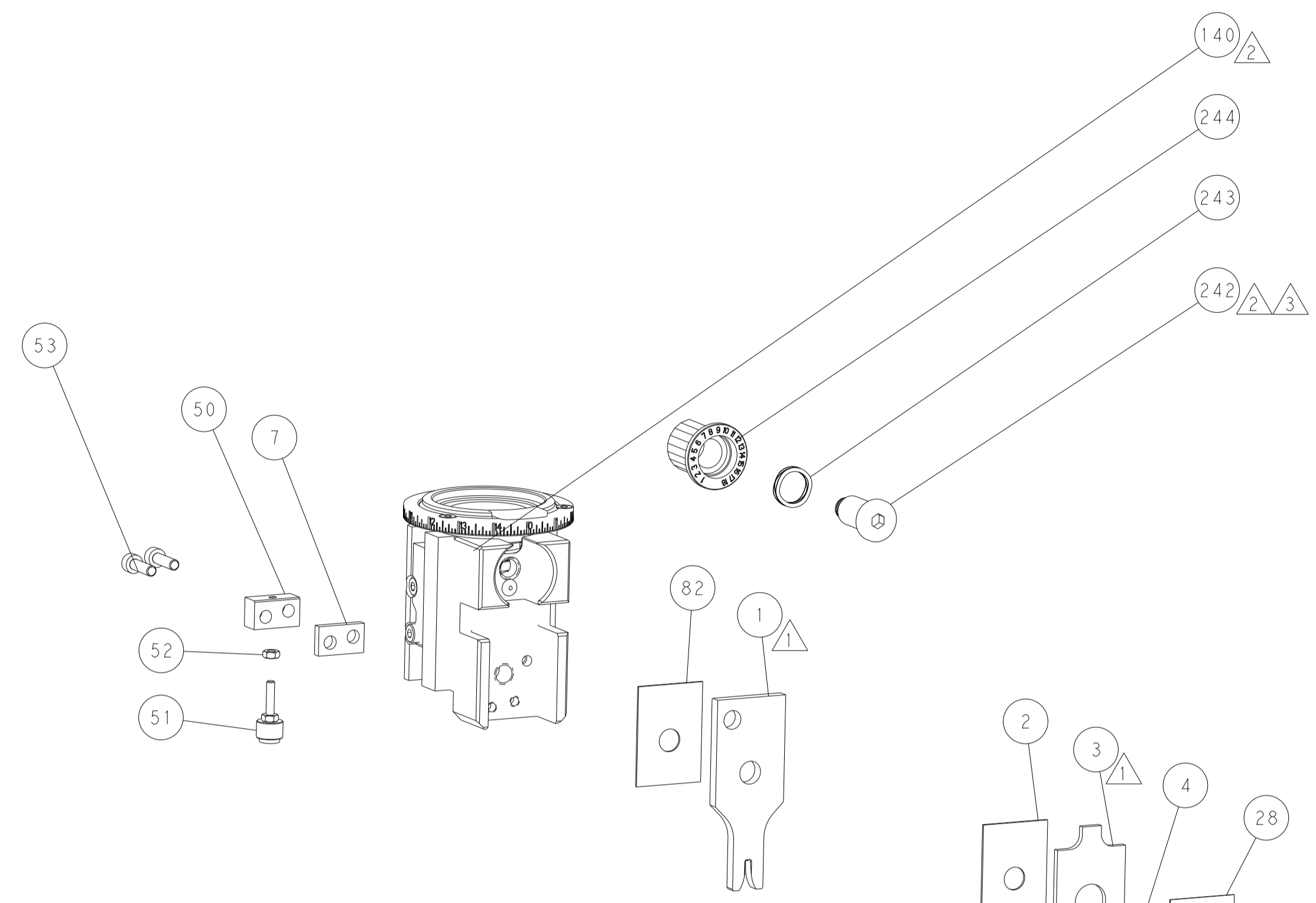
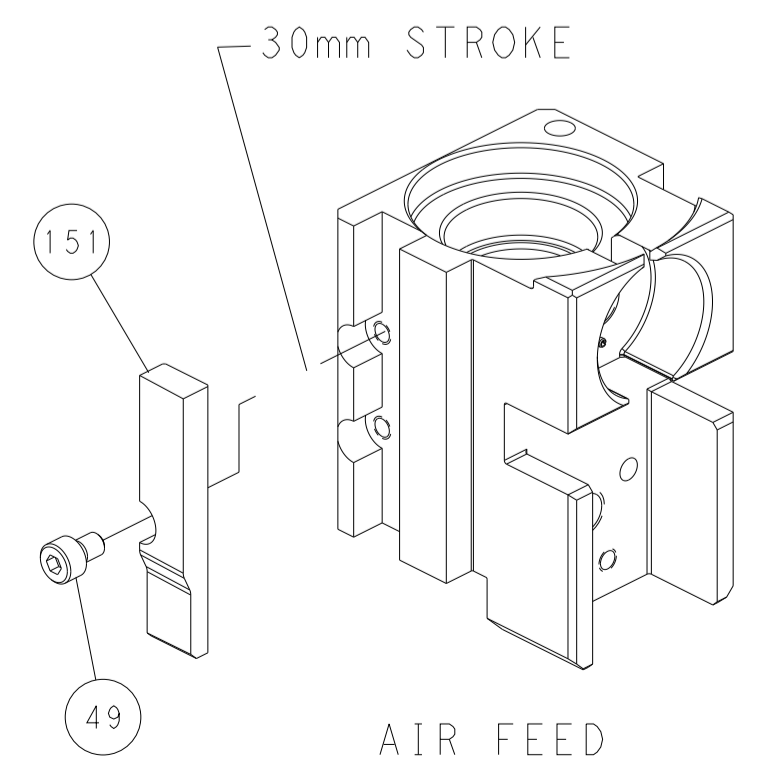
PNEUMATIC



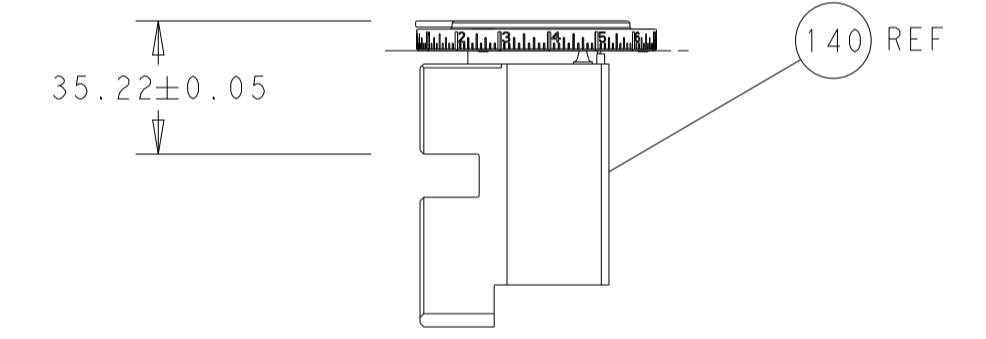
FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



CAM POSITION

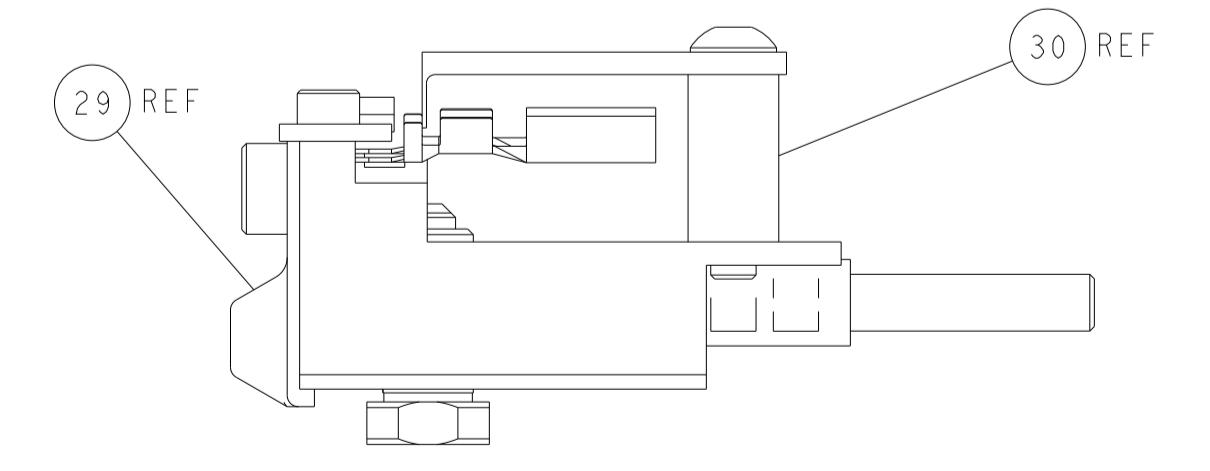


TERMINAL SUPPORT LOCATION

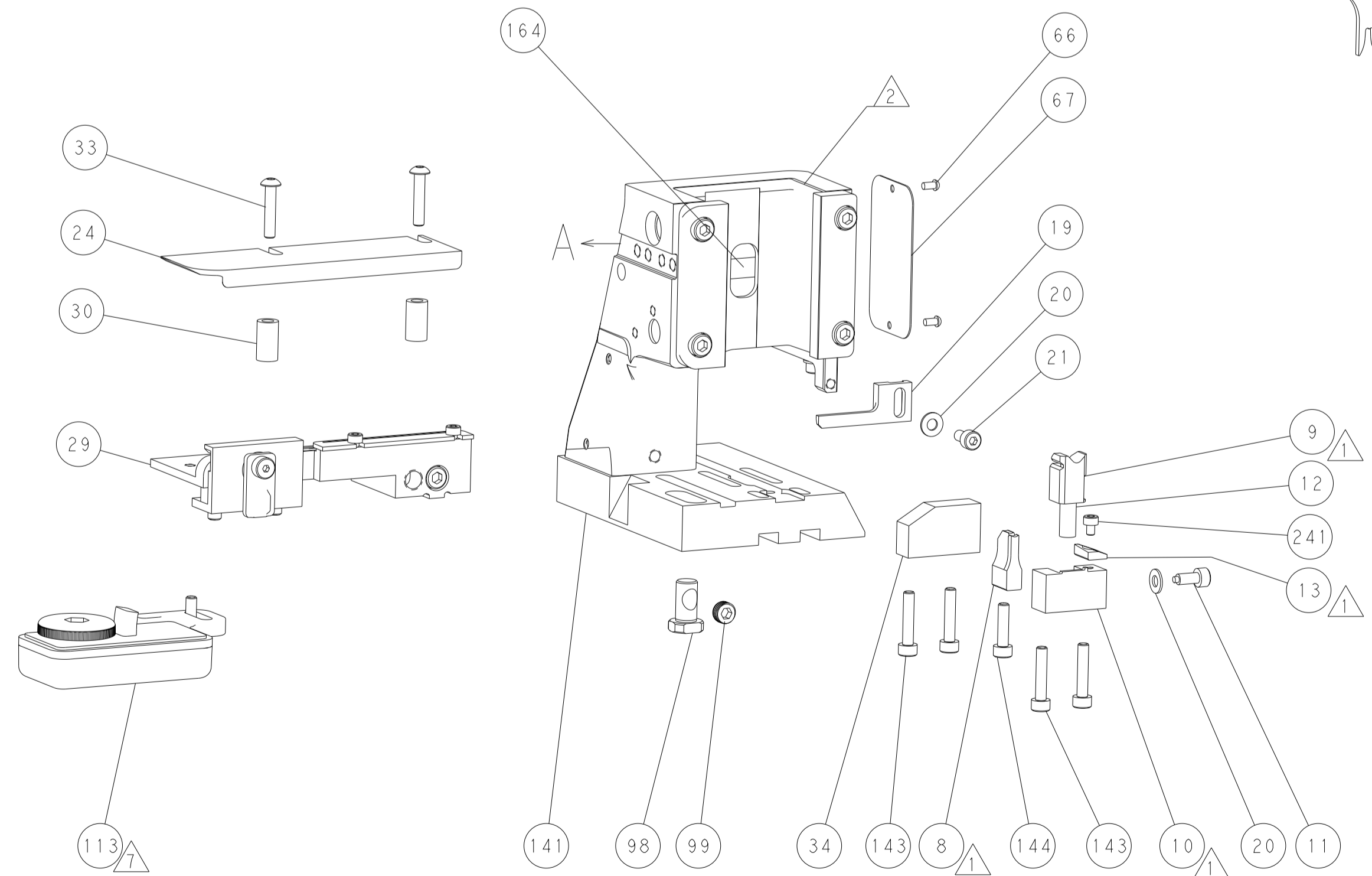


RAM SET-UP

ITEM 30 LOCATED AT FRONT HOLES



FEED TRACK POSITION GUIDE BY INSULATION 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 UNPUBLISHED. RELEASED FOR PUBLICATION 20. COPYRIGHT 20 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.</small>		DWN: J. HOU 15OCT2015 CHK: L. ZHANG 15OCT2015 APVD: J. GUO 15OCT2015	TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ° ± MATERIAL: - FINISH: -	PRODUCT SPEC APPLICATION SPEC WEIGHT: - SCALE: 1:2	NAME: Ocean Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2836080 SHEET 4 OF 4	RESTRICTED TO: - REV: C