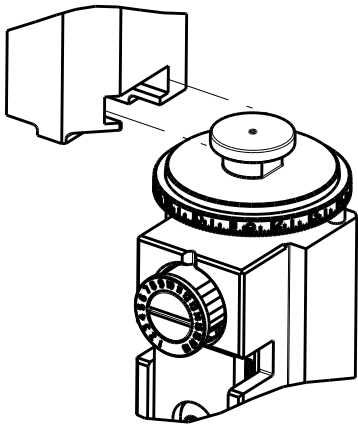


8		7	
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20		20	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2836066-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2836066-2	B	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2836066-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	3.56 mm [.140]	F
INSUL	4.32 mm [.170]	F
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: LEAR/FORD TERMINAL TE CRIMP SPECIFICATION			
TERMINAL NAME: TERMINAL, WIRE SNAP ON FEMALE			
WIRE STRIP LENGTH 4.67-5.43 mm [.184-.214 IN]		INSULATION DIAMETER RANGE Ø3.40-4.00 mm [.134-.157 IN]	
TERMINAL APPLICATION SPECIFICATION	NONE	-	-
TERMINALS APPLIED			
TE TERMINAL	LEAR/FORD TERMINAL	TE TERMINAL	LEAR/FORD TERMINAL
1949398-1	F4UB-14474-AA	2208343-3	361030-YF200

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
10 AWG OR 5.00mm2	2.49+/-0.05 [.098+/- .002]	4.8
4.00mm2	2.26+/-0.05 [.089+/- .002]	7.1
12 AWG OR 3.00mm2	2.03+/-0.05 [.080+/- .002]	9.8



- 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. 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				
		P	LTR	DESCRIPTION	DATE	OWN
A	66		A	RELEASED	09DEC2015	RK
			B	ECR-18-009727	21JUN2019	MZ

-	1	1	2119640-1	PUSH ROD, AIR FEED	250
-	1	1	1803259-1	BUSHING, FLANGED	249
-	1	1	2119641-1	FEED CAM, AIR FEED	248
-	1	1	2119082-3	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	2063440-2	AIR FEED MODULE	238
-	2	2	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172
-	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	1	1	240638-1	SPRING, FEED FINGER	163
-	1	1	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854	137
-	1	1	2119799-1	HOLDER, FEED FINGER, AF	136
-	1	1	2844908-1	SCREW, LOCKING	99
-	1	1	2844907-1	POST, LOCKING	98
-	1	1	455888-5	SPACER, CRIMPER	82
-	1	1	1803607-1	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	1338683-8	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
-	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	1-1752356-8	SUPPORT, TERMINAL	34
-	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	3-2844962-2	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	1803095-1	FLOATING SHEAR, FRONT -	9
1	2	1	1-1633926-1	ANVIL, COMBINATION	8
-	1	1	2-240641-0	SPACER	7
-	-	-	-	-	6
-	1	1	1-2119757-2	DEPRESSOR, SHEAR	5
-	1	1	238011-4	BLOCK, CRIMPER SPACER	4
1	2	1	7-1803016-6	CRIMPER, INSULATION F	3
-	1	1	1-455888-0	SPACER, CRIMPER	2
1	2	1	2-456411-2	CRIMPER, WIRE PREMIUM	1
-77-72	-2		PART NO	DESCRIPTION	ITEM NO

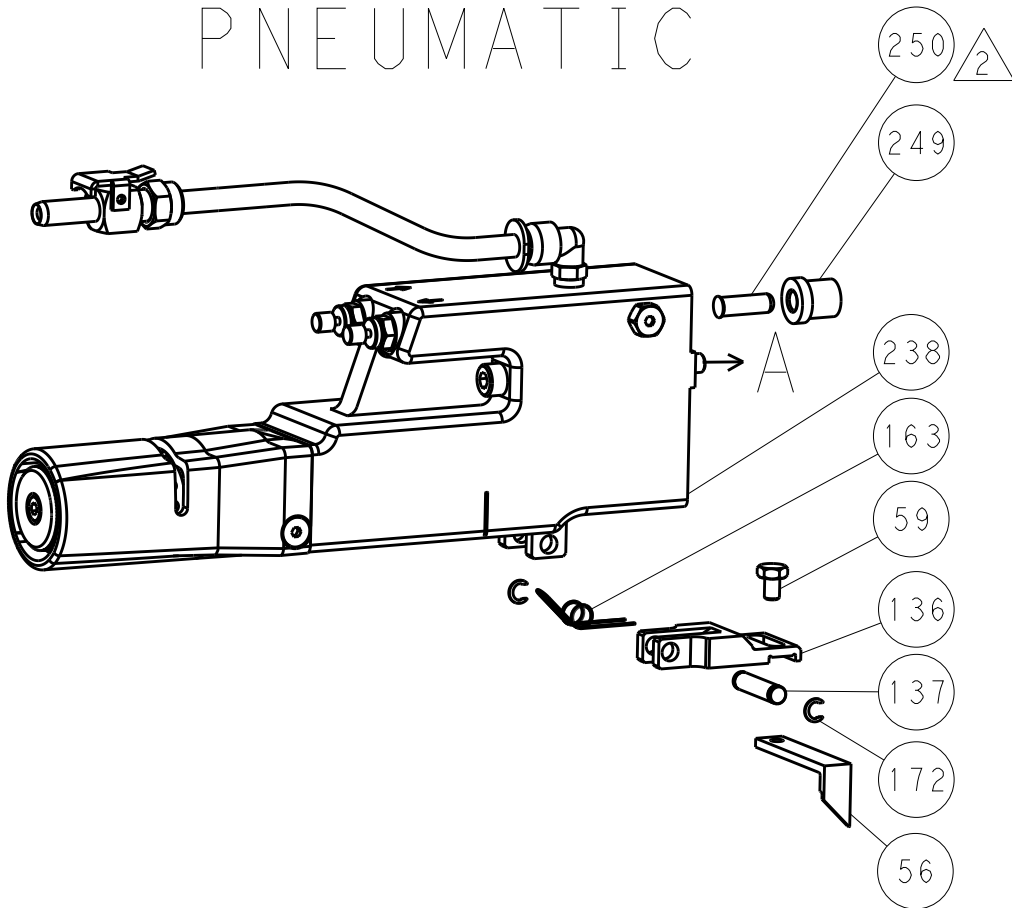
THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. IT IS SUBJECT TO CHANGE WITHOUT NOTICE.			OWN J. HOU 21OCT2015	TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm			CHK L. ZHANG 21OCT2015	NAME Ocean Side Feed Applicator	
TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH ±			APVD J. GUO 21OCT2015	PRODUCT SPEC APPLICATION SPEC	
MATERIAL			SIZE 00779	CAGE CODE C=2836066	RESTRICTED TO -
Customer Accessible Production Drawing			SCALE 1:2	SHEET 1 OF 4	REV B

SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

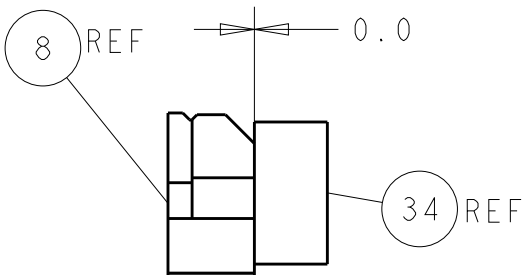
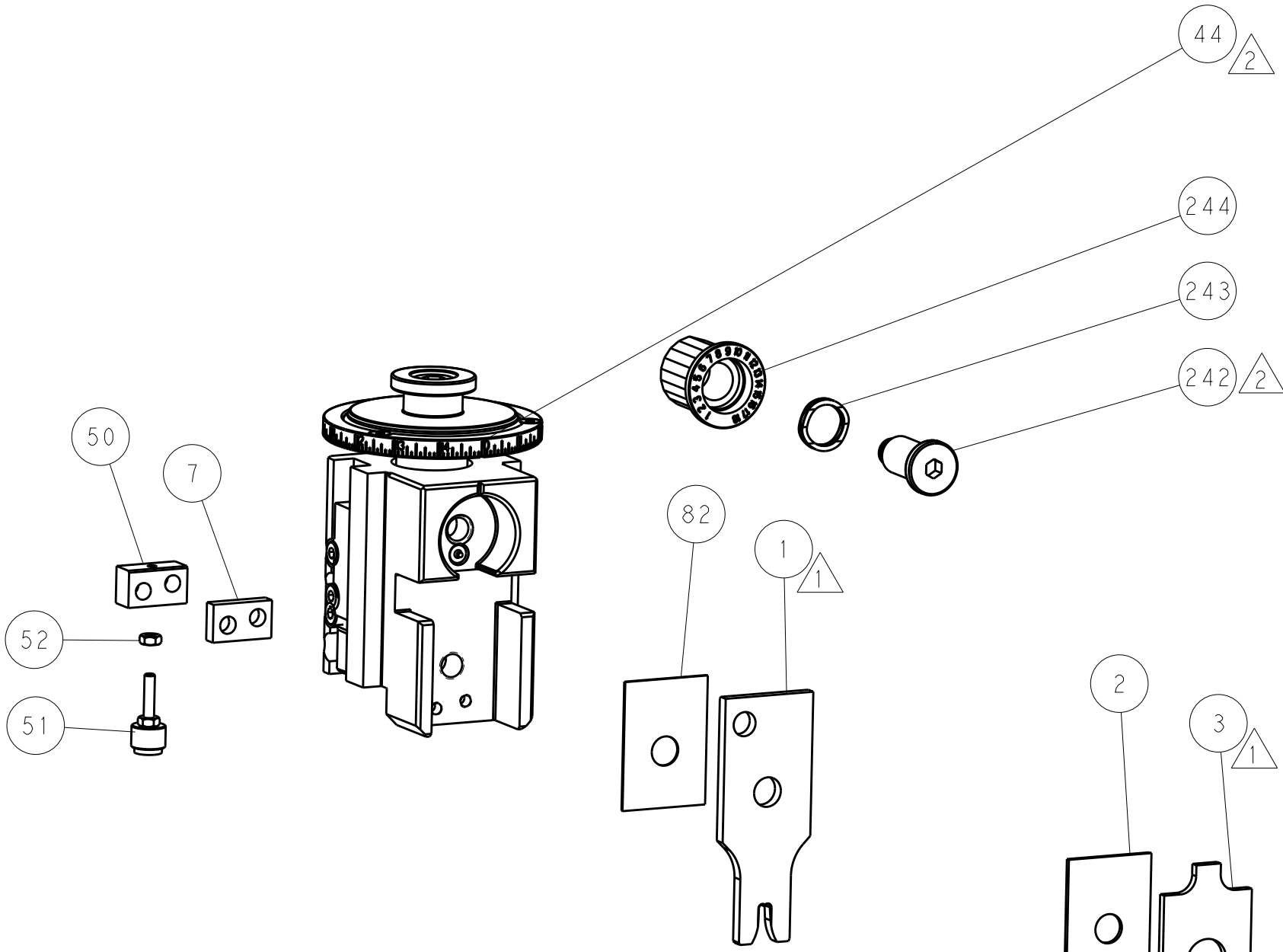
LOC	DIST	REVISIONS					
		P	LTR	DESCRIPTION	DATE	DWN	APVD
A	66	-	-	SEE SHEET 1	-	-	-

FEED TYPE

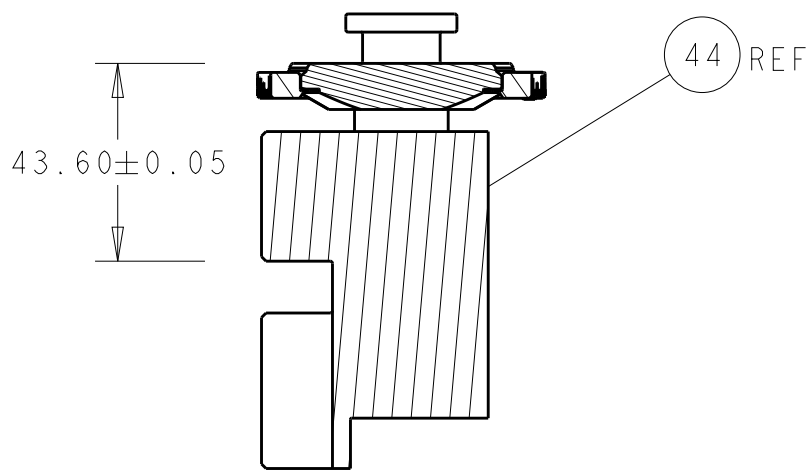
PNEUMATIC



53

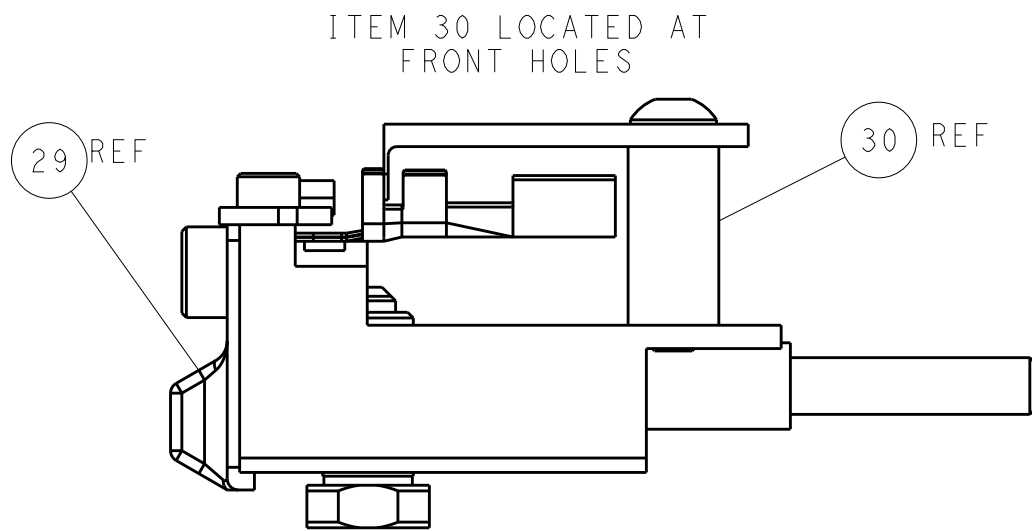
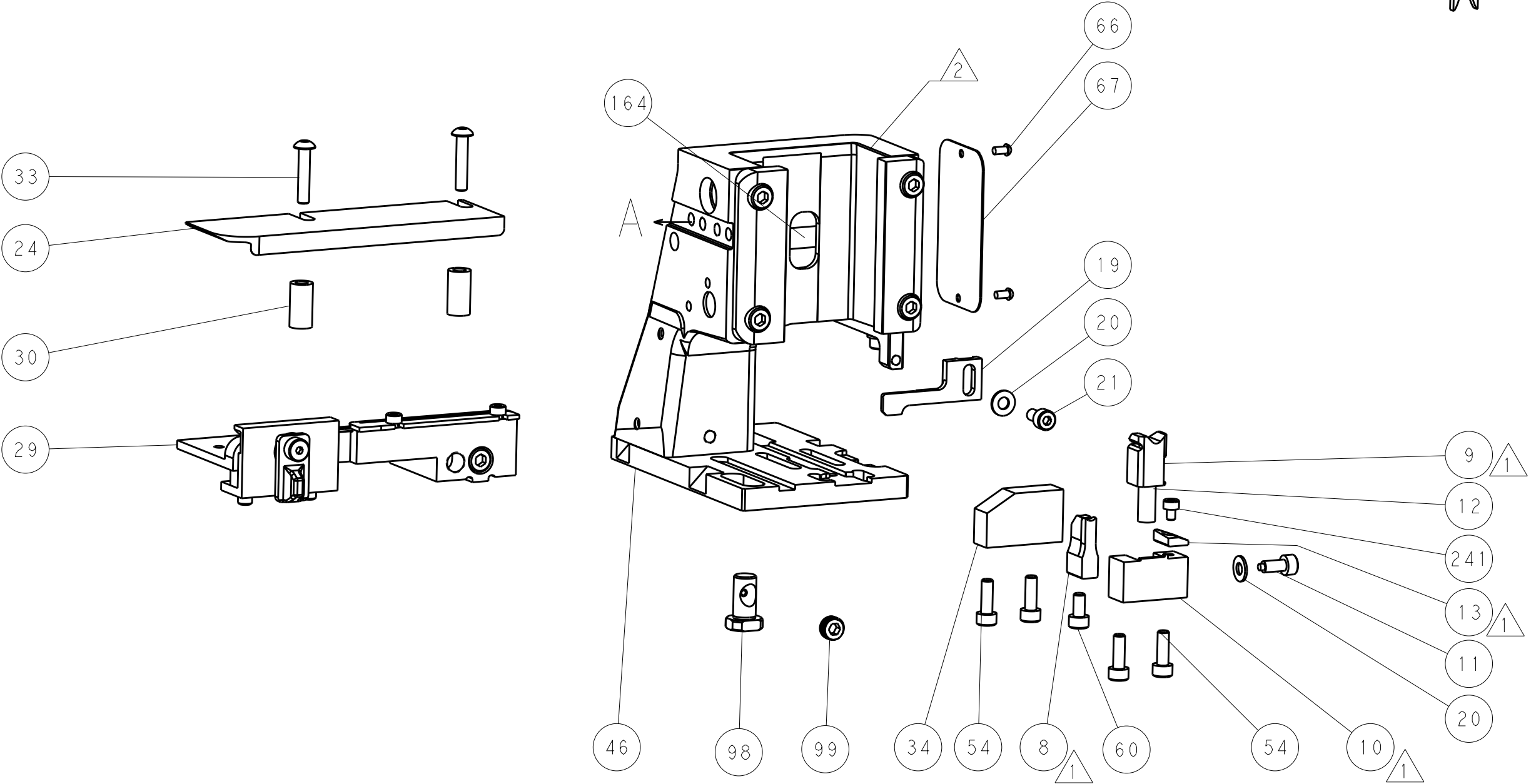
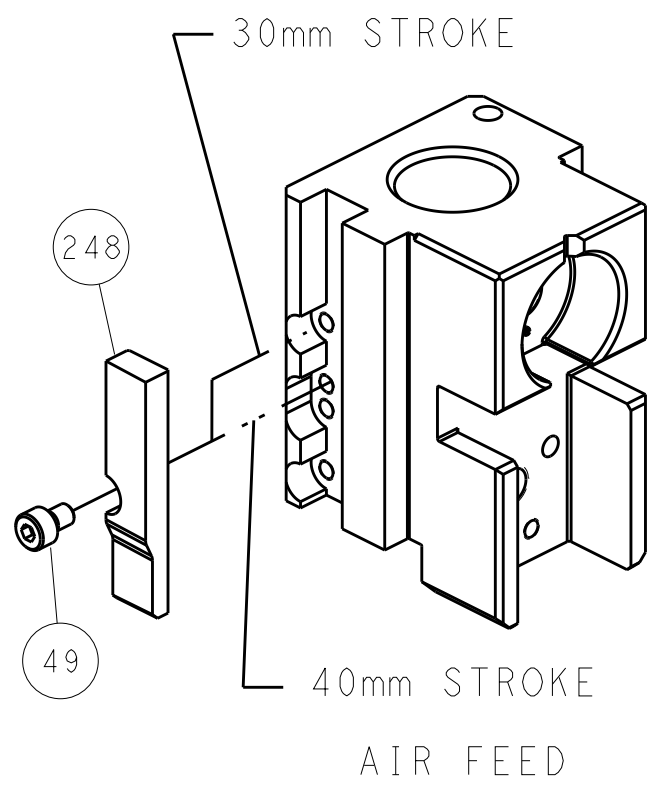


TERMINAL SUPPORT LOCATION



RAM SET-UP

CAM POSITION



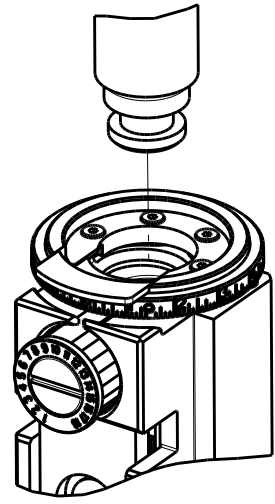
FEED TRACK POSITION
GUIDE BY INSULATION BARREL

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

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DIMENSIONS: mm		CHK L. ZHANG 21OCT2015	NAME Ocean Side Feed Applicator	
TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.1 1 PLC ±.1 2 PLC ±.1 3 PLC ±.1 4 PLC ±.1 ANGLES ±.1 FINISH		APVD J. GUO 21OCT2015	PRODUCT SPEC APPLICATION SPEC	
MATERIAL		SIZE A1	CAGE CODE 00779	
		WEIGHT	C=2836066	
		Customer Accessible Production Drawing		RESTRICTED TO
		SCALE 1:2	SHEET 2 OF 4	
		REV B		

8		7	
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20		20	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2836066-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2836066-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	3.56 mm [.140]	F
INSUL	4.32 mm [.170]	F
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: LEAR/FORD TERMINAL TE CRIMP SPECIFICATION			
TERMINAL NAME: TERMINAL, WIRE SNAP ON FEMALE			
WIRE STRIP LENGTH 4.67-5.43 mm [.184-.214 IN]		INSULATION DIAMETER RANGE Ø3.40-4.00 mm [.134-.157 IN]	
TERMINAL APPLICATION SPECIFICATION	NONE	-	-
TERMINALS APPLIED 5			
TE TERMINAL	LEAR/FORD TERMINAL	TE TERMINAL	LEAR/FORD TERMINAL
1949398-1	F4UB-14474-AA	2208343-3	361030-YF200

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
10 AWG OR 5.00mm2	2.49+/-0.05 [.098+/-0.002]	4.8
4.00mm2	2.26+/-0.05 [.089+/-0.002]	7.1
12 AWG OR 3.00mm2	2.03+/-0.05 [.080+/-0.002]	9.8



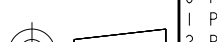
- 1 RECOMMENDED SPARE PARTS
- 2 REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- 3 APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242.
- 4 CRIMP HEIGHT REFERENCE SETTING WAS THE SETTING USED WHEN THE APPLICATOR WAS QUALIFIED AT THE FACTORY. ADJUSTMENT MAY BE NECESSARY WHEN RUNNING APPLICATOR IN THE FIELD.
- 5 TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
6. 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	REVISIONS					
A	66	P	LTR	DESCRIPTION	DATE	DWN	APVD
			-	SEE SHEET 1	-	-	-

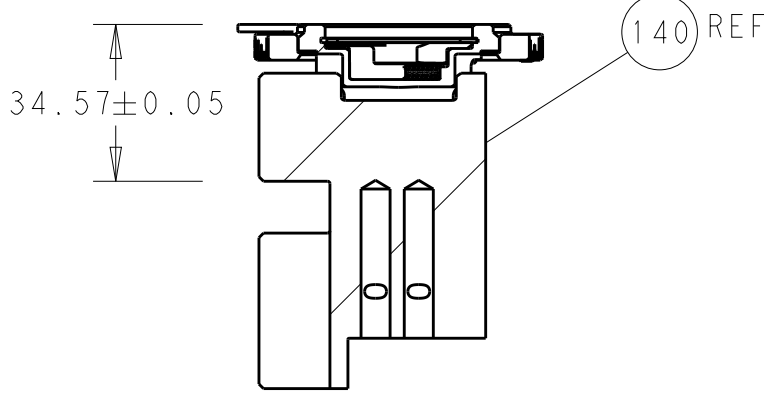
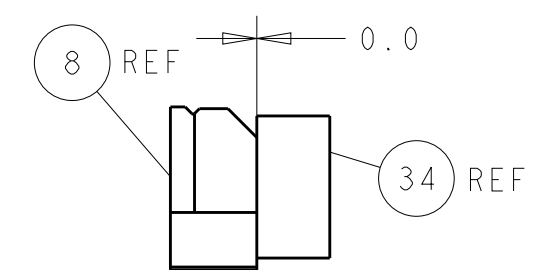
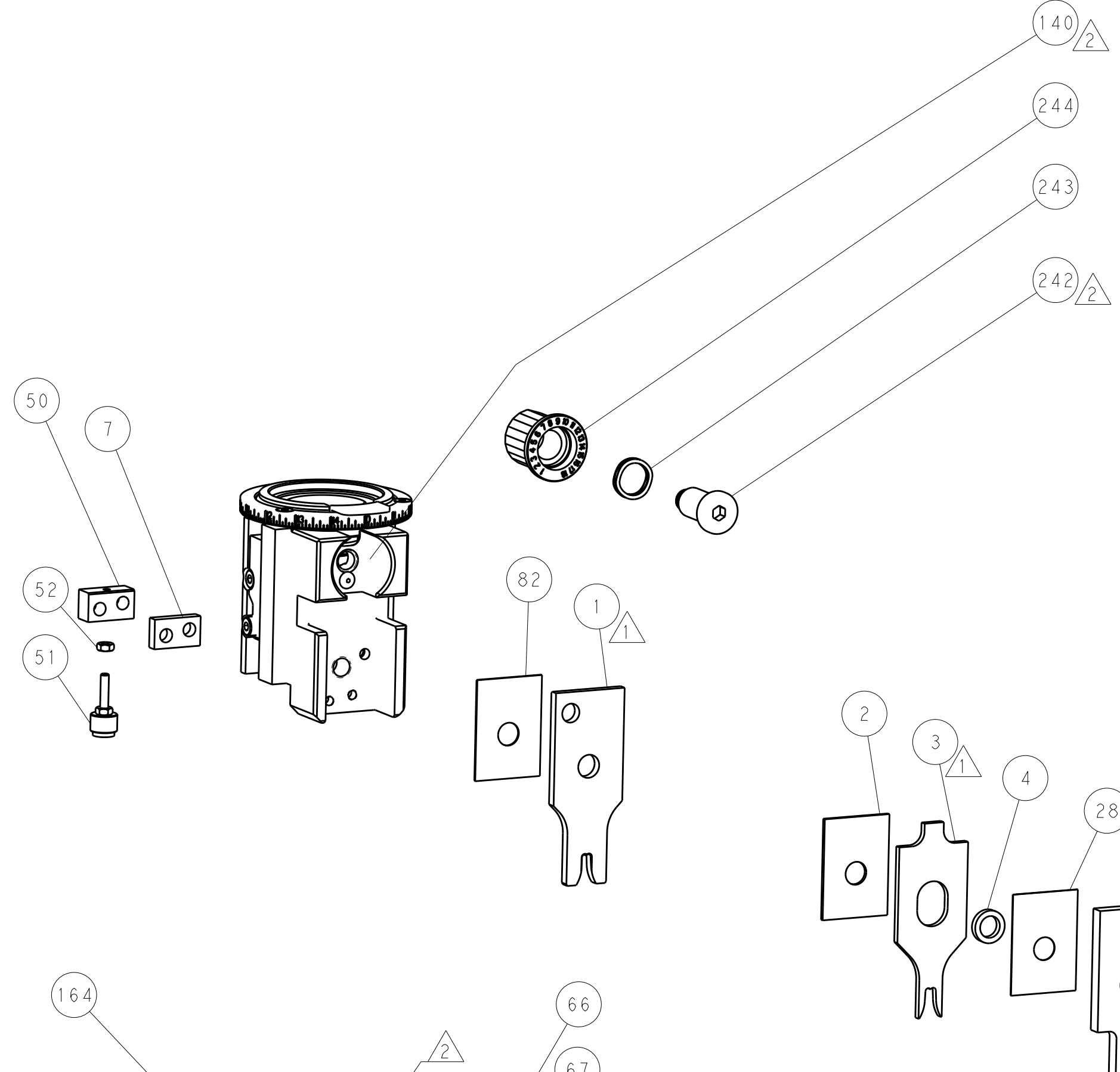
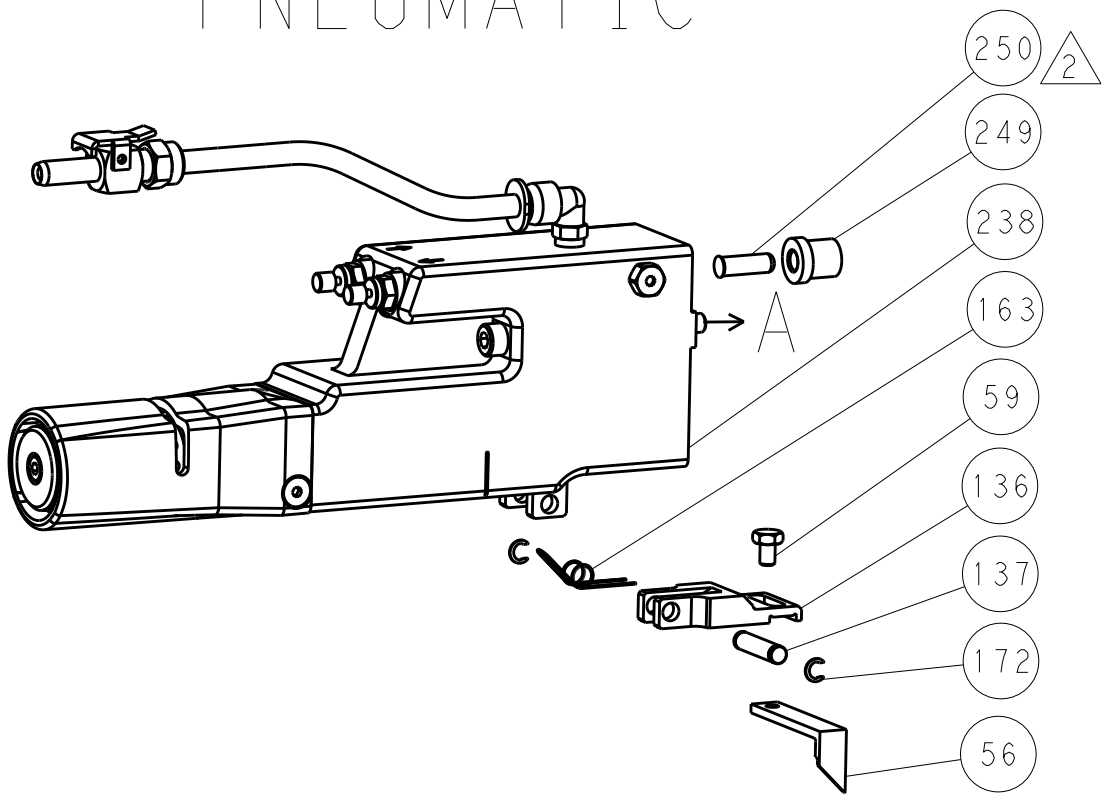
-	1	2119640-1	PUSH ROD, AIR FEED	250	
-	1	1803259-1	BUSHING, FLANGED	249	
-	1	2119082-3	CAM, SNAIL, INSULATION ADJUSTMENT	244	
-	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243	
3	-	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241	
-	1	2063440-2	AIR FEED MODULE	238	
-	2	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172	
-	REF	994970-2	COUNTER, MAGNETIC	164	
-	1	240638-1	SPRING, FEED FINGER	163	
-	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	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854	137	
-	1	2119799-1	HOLDER,FEED FINGER, AF	136	
-	1	2844908-1	SCREW, LOCKING	99	
-	1	2844907-1	POST, LOCKING	98	
-	1	455888-5	SPACER, CRIMPER	82	
-	1	1803607-1	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	1338683-8	FEED PAWL	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	
-	1	1-1752356-8	SUPPORT, TERMINAL	34	
-	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33	
-	2	3-2844962-2	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	-	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	1803095-1	FLOATING SHEAR, FRONT -	9	
1	1	1-1633926-1	ANVIL, COMBINATION	8	
-	1	2-240641-0	SPACER	7	
-	-	-	-	6	
-	1	1-2119757-2	DEPRESSOR, SHEAR	5	
-	1	238011-4	BLOCK, CRIMPER SPACER	4	
1	1	7-1803016-6	CRIMPER, INSULATION F	3	
-	1	1-455888-0	SPACER, CRIMPER	2	
1	1	2-456411-2	CRIMPER, WIRE PREMIUM	1	
-77	-22	PART NO	DESCRIPTION	ITEM NO	

THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. THE USER SHALL BE RESPONSIBLE FOR VERIFYING THE LATEST REVISION. SHOULD BE CONTACTED FOR THE LATEST REVISION.				DWN J. HOU 21OCT2015	 TE Connectivity Harrisburg, PA 17105-3608						
CHK L. ZHANG 21OCT2015				APVD J. GUO 21OCT2015	NAME Ocean Side Feed Applicator - SIZE CAGE CODE DRAWING NO RESTRICTED TO A 00779 C=2836066 - Customer Accessible Production Drawing SCALE 1:2 SHEET 3 OF 4 REV B						
DIMENSIONS: mm				PRODUCT SPEC							
TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH ±				APPLICATION SPEC							
											
MATERIAL											
-											
-											
-											
-											

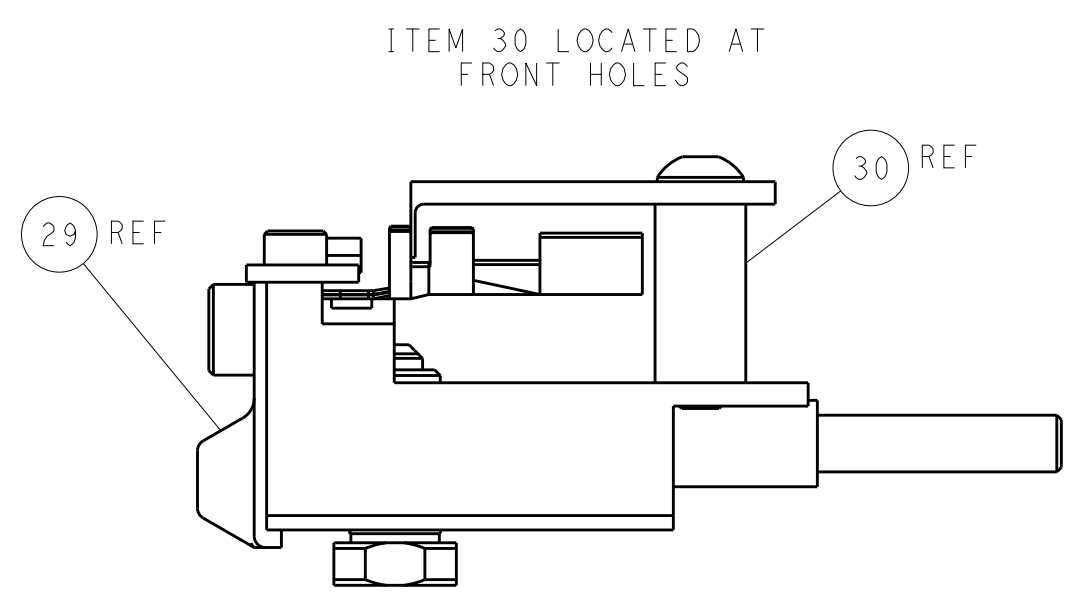
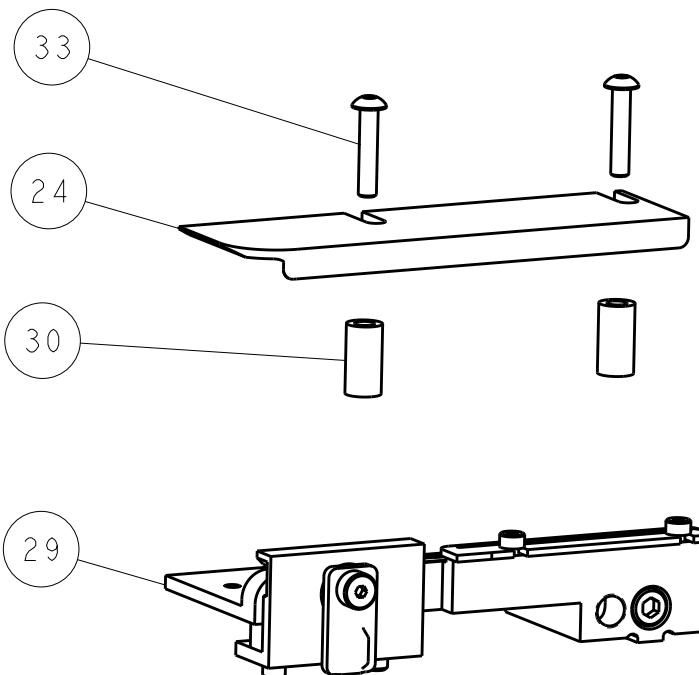
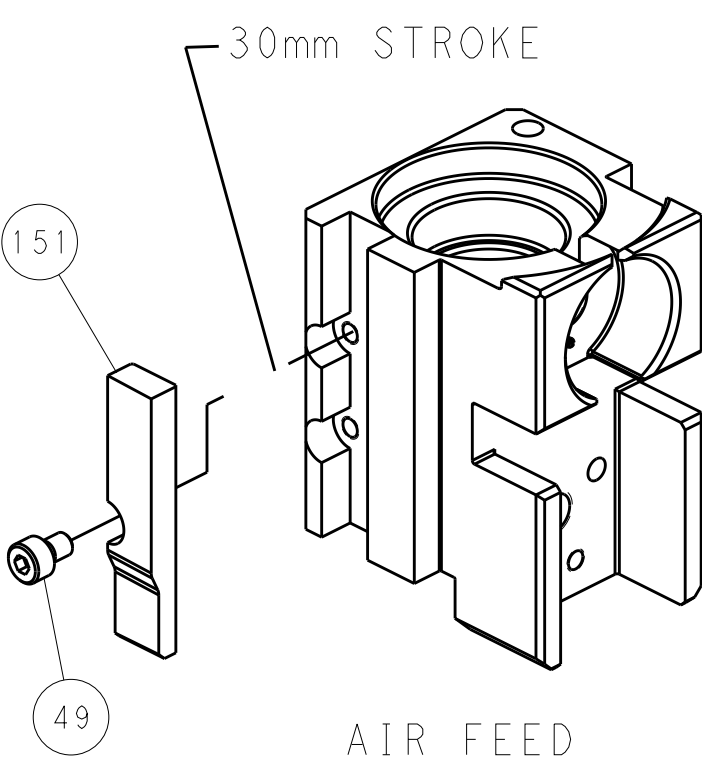
SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

LOC	DIST	REVISIONS					
		P	LTR	DESCRIPTION	DATE	DWN	APVD
A	66	-	-	SEE SHEET 1	-	-	-

FEED TYPE
PNEUMATIC



CAM POSITION



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

THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. ANY CHANGES TO THIS DRAWING SHOULD BE CONTACTED FOR THE LATEST REVISION.				DWN J. HOU 21OCT2015	 TE Connectivity Harrisburg, PA 17105-3608						
				CHK L. ZHANG 21OCT2015							
				APVD J. GUO 21OCT2015							
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:			NAME	Ocean Side Feed Applicator					
		0 PLC ±.1 1 PLC ±.1 2 PLC ±.1 3 PLC ±.1 4 PLC ±.1 ANGLES ±.1 FINISH -			PRODUCT SPEC						
MATERIAL					APPLICATION SPEC	SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO		
-		-			WEIGHT	A1	00779	C=2836066	-		
Customer Accessible Production Drawing					SCALE	1:2	SHEET	4	OF 4	REV	B