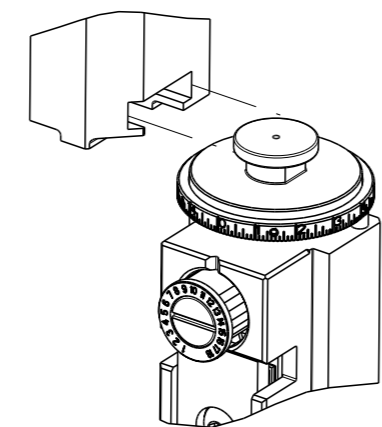


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2836084-2	F	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2836084-2	F	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2836084-7	C	CRIMP TOOLING KIT	-

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	

TERMINALS APPLIED

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 <sup>2</sup>	1.50+/-0.05 [.059+/- .002]	7.5
16 AWG OR 1.30mm <sup>2</sup>	1.40+/-0.05 [.055+/- .002]	8.3
18 AWG OR 0.80mm <sup>2</sup>	1.31+/-0.04 [.052+/- .002]	9.3
20 AWG OR 0.50mm <sup>2</sup>	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

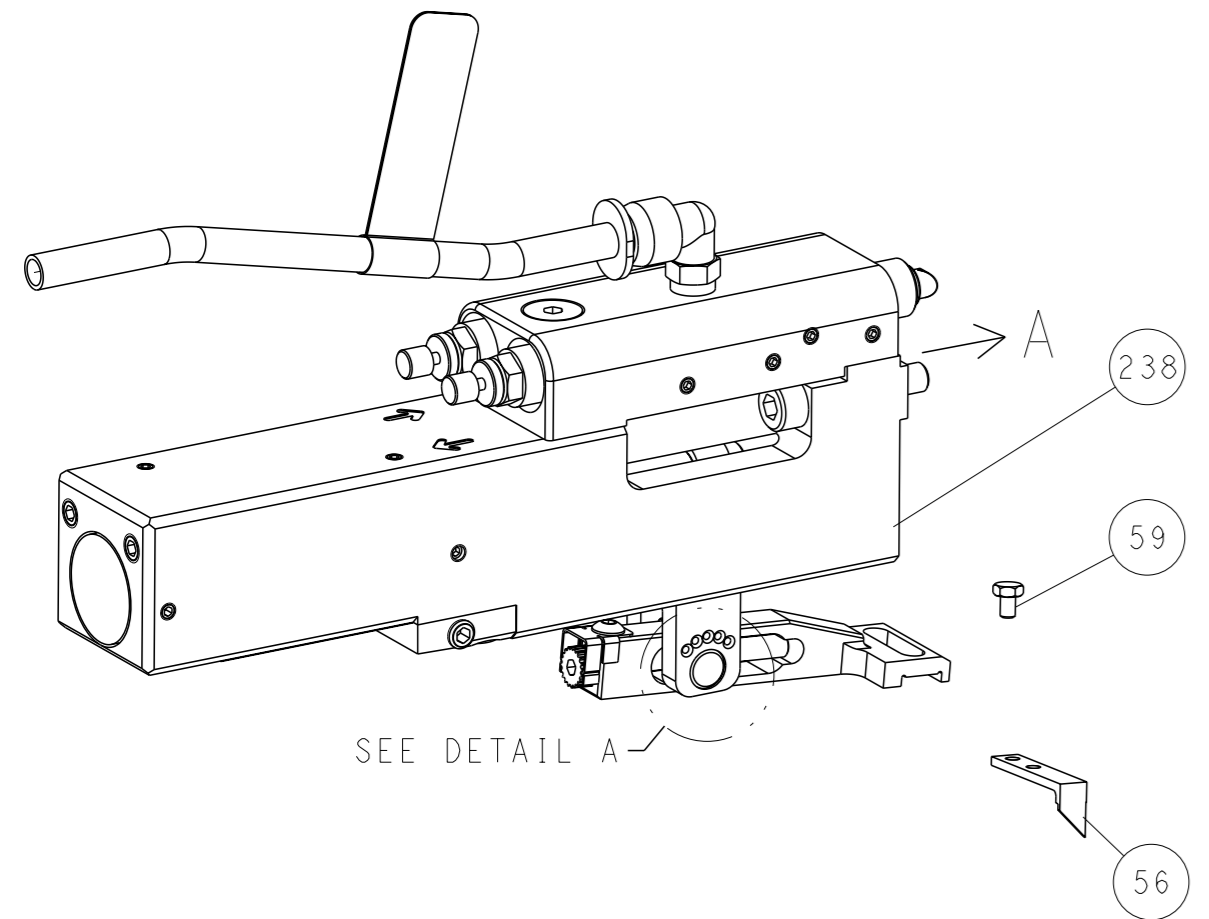
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mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±
	ANGLES	FINISH		MATERIAL	

OWN	B. WEAVER	21OCT2015	TE Connectivity Harrisburg, PA 17105-3608
CHK	G. BAILEY	21OCT2015	
APVD	G. BAILEY	21OCT2015	
PRODUCT SPEC	NAME		
APPLICATION SPEC			Ocean Side Feed Applicator
SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
A1	00779	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	-	-	-

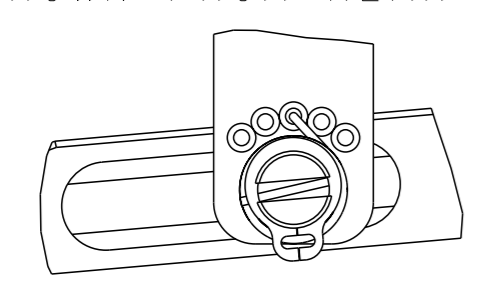
# FEED TYPE

## PNEUMATIC



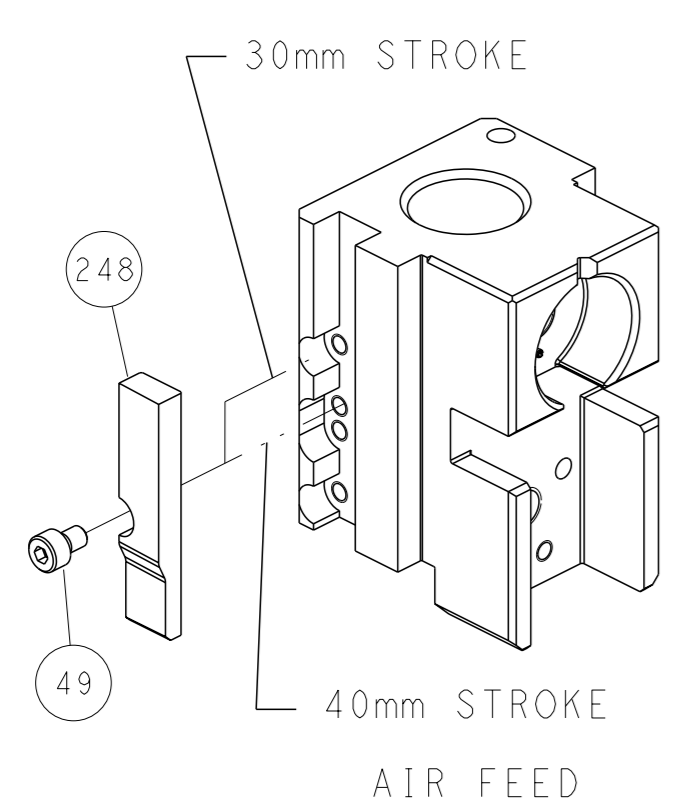
SEE DETAIL A

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

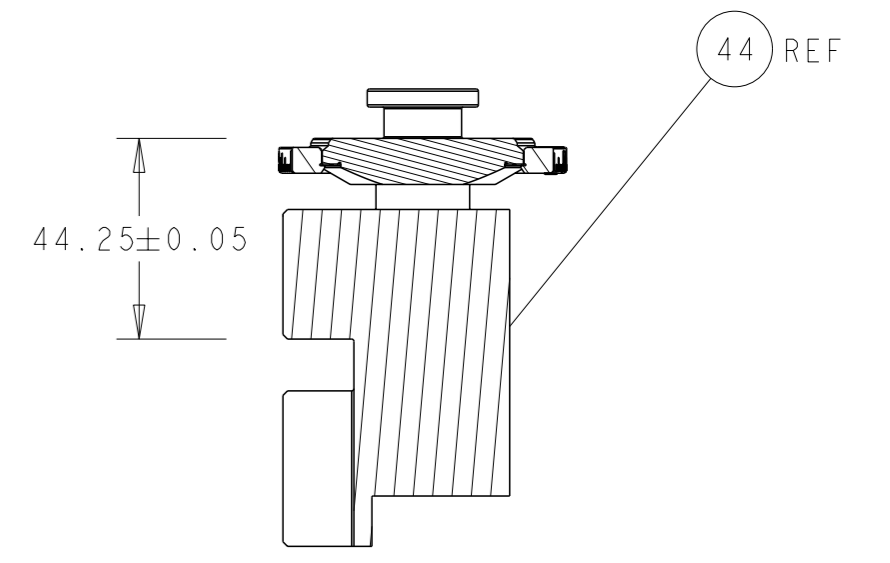
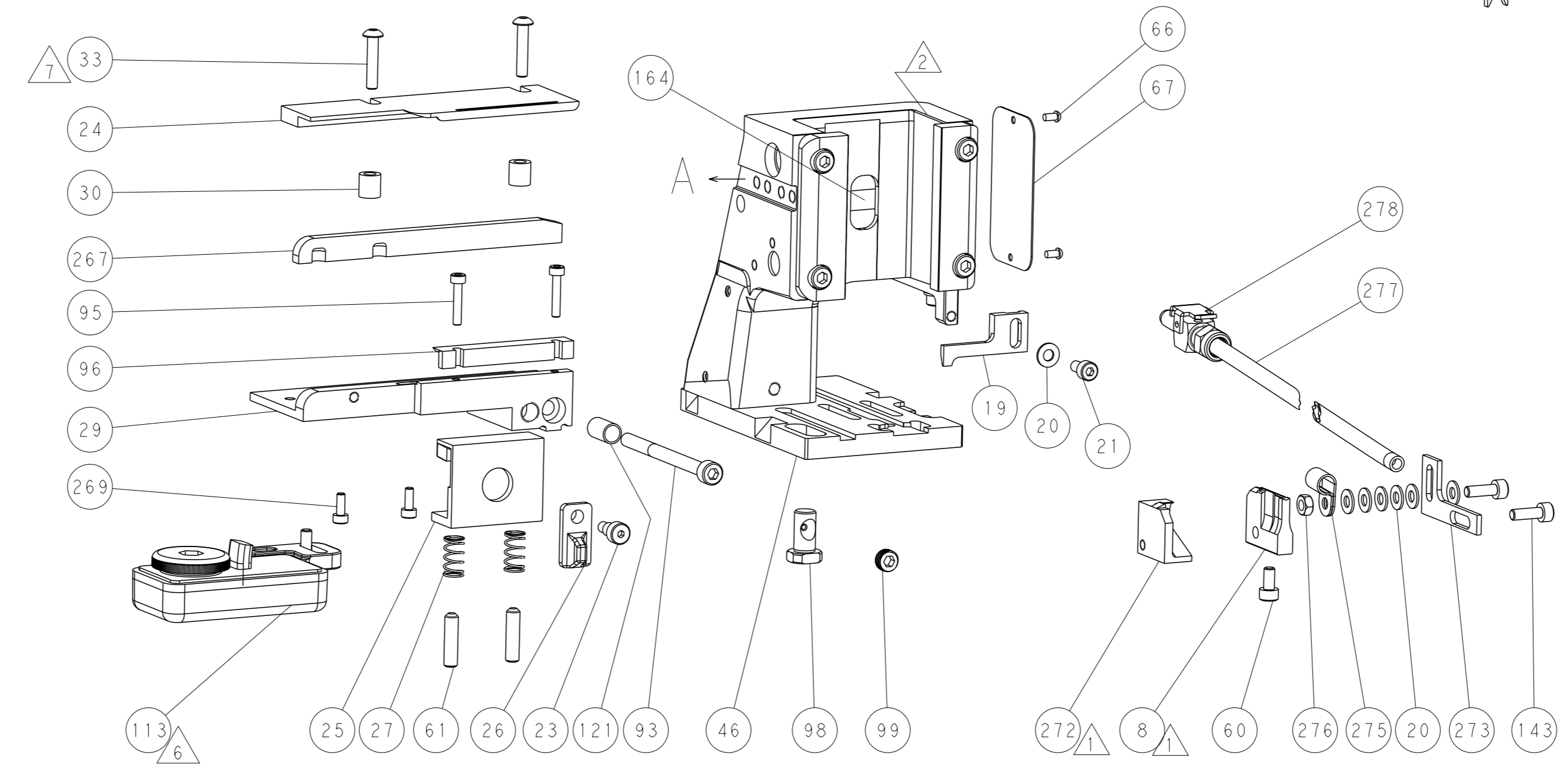
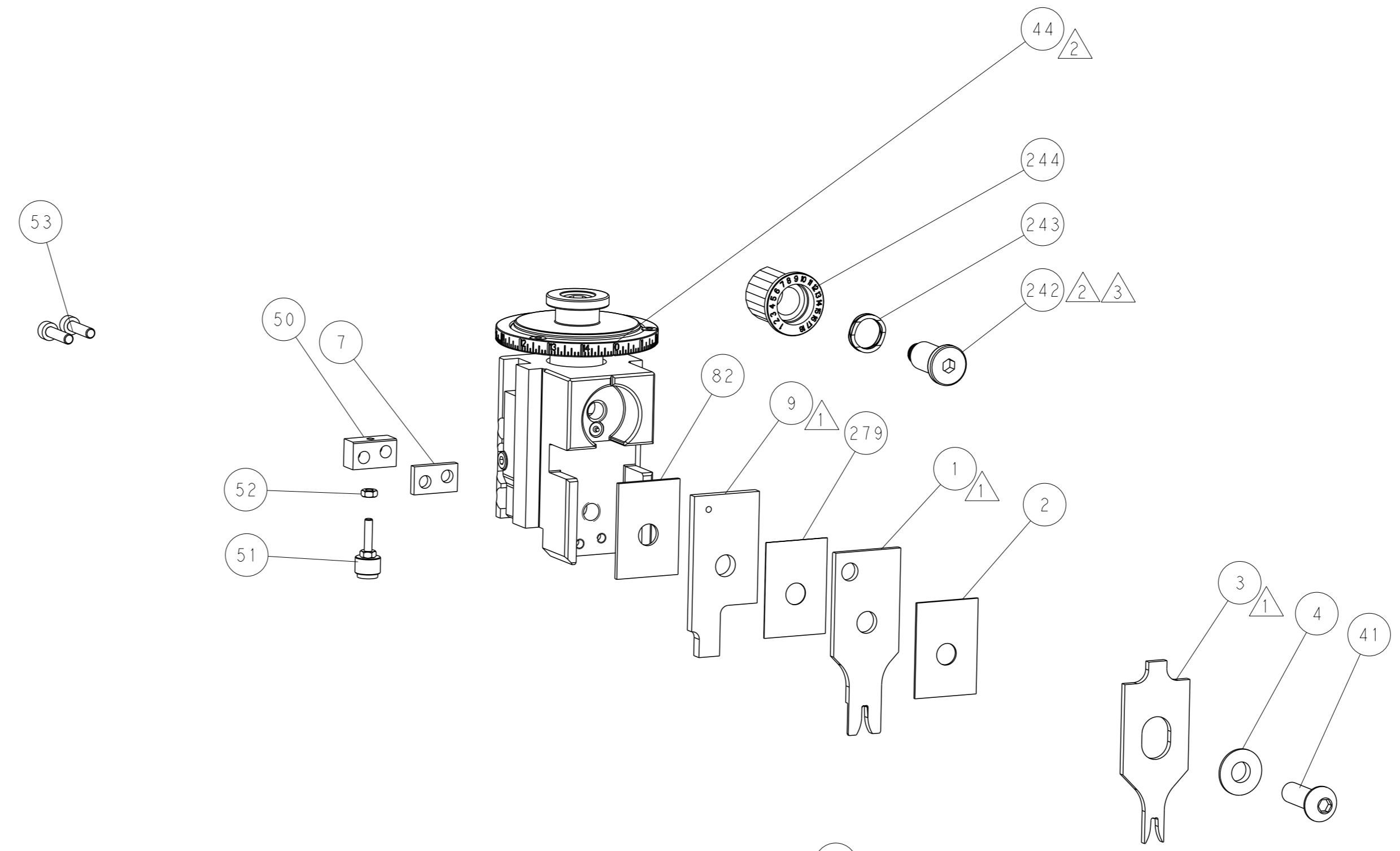


DETAIL A

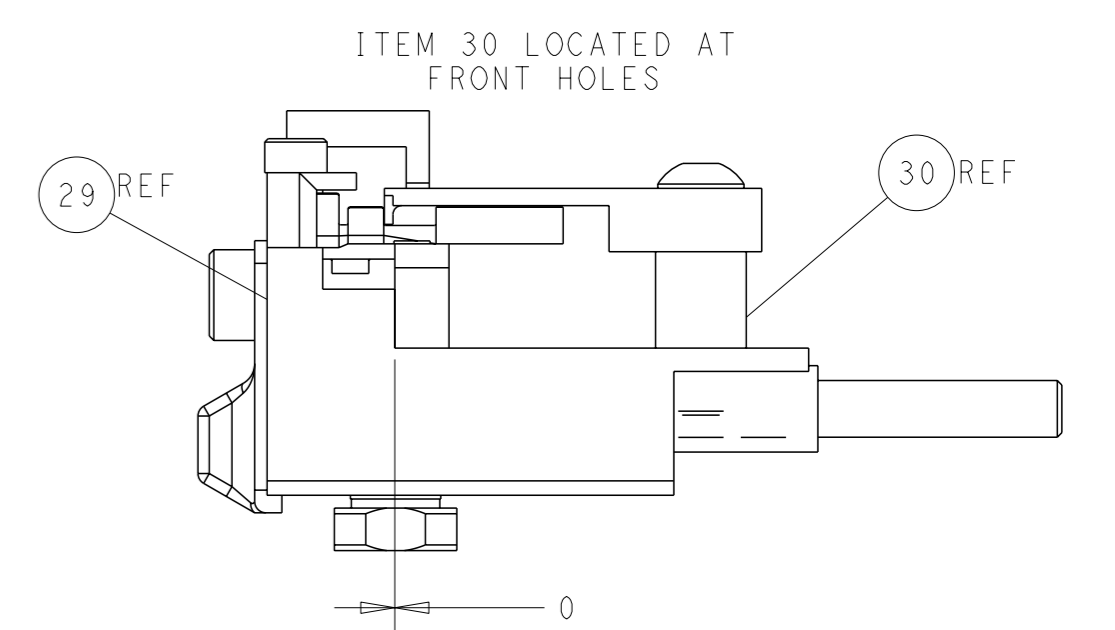
## CAM POSITION



AIR FEED



RAM SET-UP



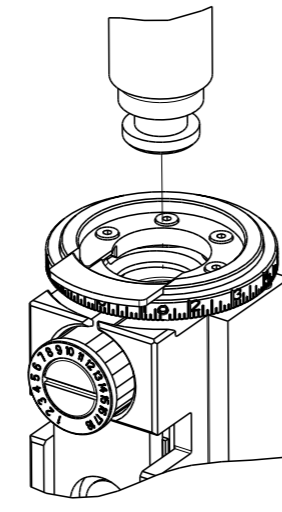
FEED TRACK POSITION  
GUIDE BY WIRE BARREL

**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 CONTROL AND REVISIONS DISPOSITION                  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 WEIGHT: - SCALE: 1:2	RESTRICTED TO: - SHEET 2 of 4 REV F
MATERIAL: - FINISH: -		Customer Accessible Production Drawing	

THIS DRAWING IS UNPUBLISHED.	RELEASED FOR PUBLICATION	2015	
COPYRIGHT 2015 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.			
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	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	INSULATION DIAMETER RANGE
3.96-5.54 mm [.156-.218 IN]	Ø1.65-2.79 mm [.065-.110 IN]

TERMINAL APPLICATION SPECIFICATION: MATE-638927100 Rev B

TERMINALS APPLIED

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 <sup>2</sup>	1.50+/-0.05 [.059+/-0.002]	7.5
16 AWG OR 1.30mm <sup>2</sup>	1.40+/-0.05 [.055+/-0.002]	8.3
18 AWG OR 0.80mm <sup>2</sup>	1.31+/-0.04 [.052+/-0.002]	9.3
20 AWG OR 0.50mm <sup>2</sup>	1.27+/-0.05 [.050+/-0.002]	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	-	-	-

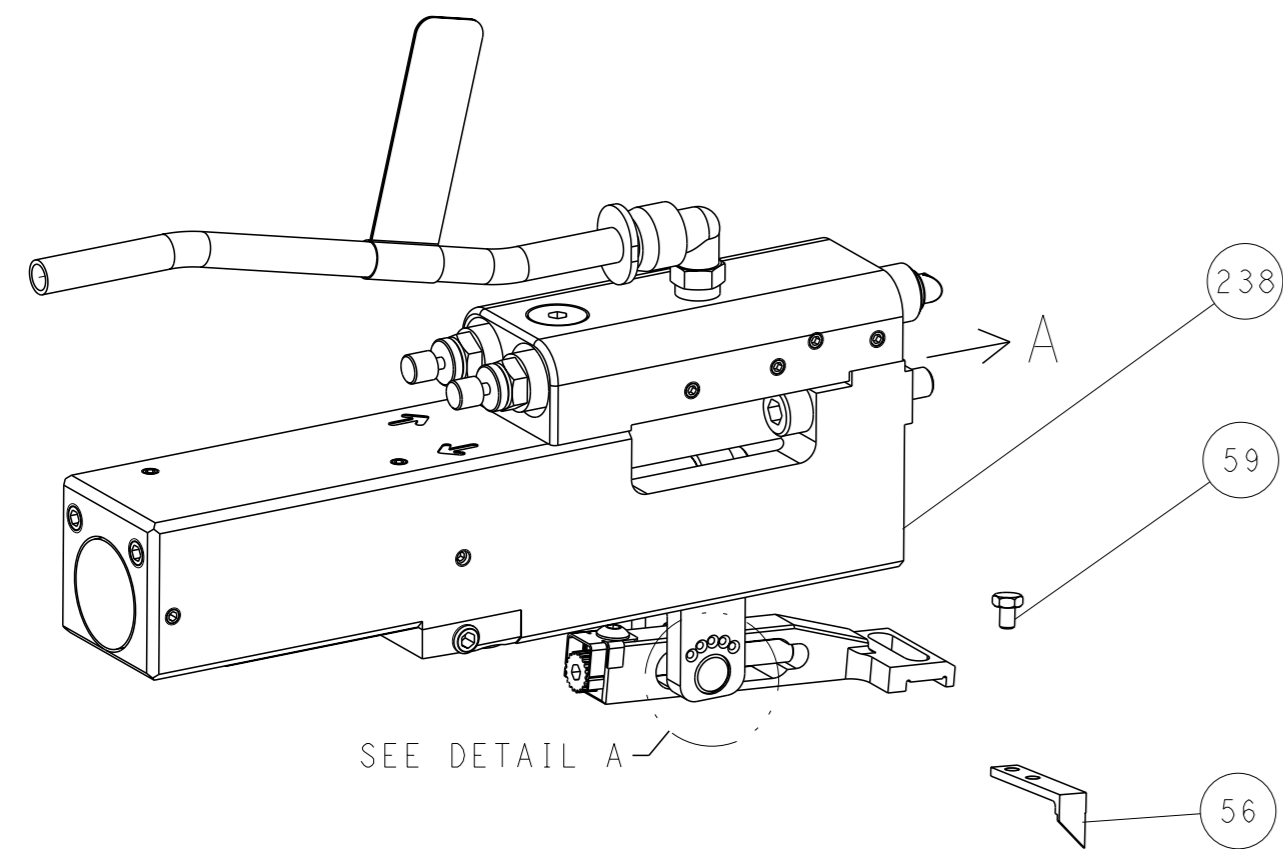
QTY	LOC	DIST	REV	DESCRIPTION	DATE	OWN	APVD
-	1			455888-3 SPACER, CRIMPER			279
-	1			23238-1 INSERT, COUPLING			278
-	1			2030758-3 TUBING, POLYURETHANE			277
-	1			5018030-2 NUT, HEX, REG, RoHS, M4			276
-	1			986220-3 CLAMP, CABLE, BLACK			275
-	1			2217068-1 BRACKET, AIR BLAST			273
1	1			2844234-1 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			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
-77	-22			PART NO			ITEM NO

<small>THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE AND THE USER ASSUMES ALL RESPONSIBILITY FOR THE LATEST REVISION. TOLERANCES UNLESS OTHERWISE SPECIFIED:</small>		OWN: B. WEAVER 21OCT2015 CHK: G. BAILEY 21OCT2015 APVD: G. BAILEY 21OCT2015	NAME: STE TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH ±	TOLERANCES UNLESS OTHERWISE SPECIFIED: ± ± ± ± ±	PRODUCT SPEC APPLICATION SPEC	SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2836084 RESTRICTED TO: -
MATERIAL: -		WEIGHT: -	SCALE: 1:2 SHEET 3 OF 4 REV F

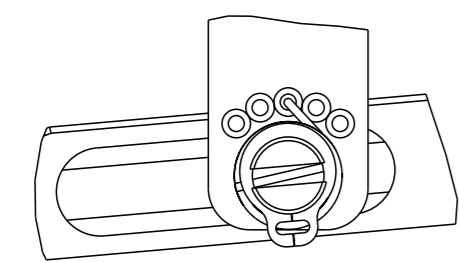
LOC		DIST		REVISIONS			
A	66	P	LYR	DESCRIPTION	DATE	OWN	APVD
		-		SEE SHEET 1			

# FEED TYPE

## PNEUMATIC

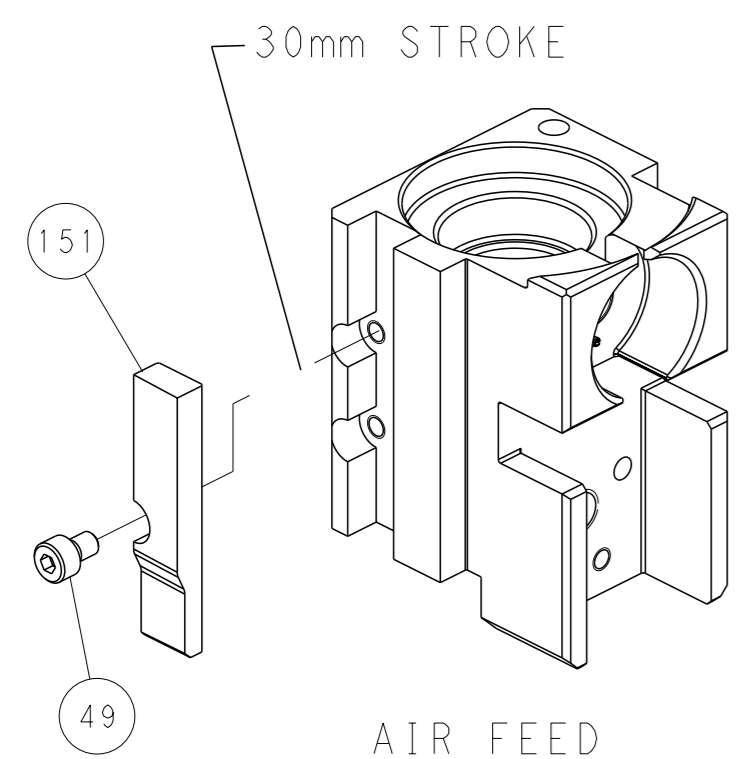


## FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)

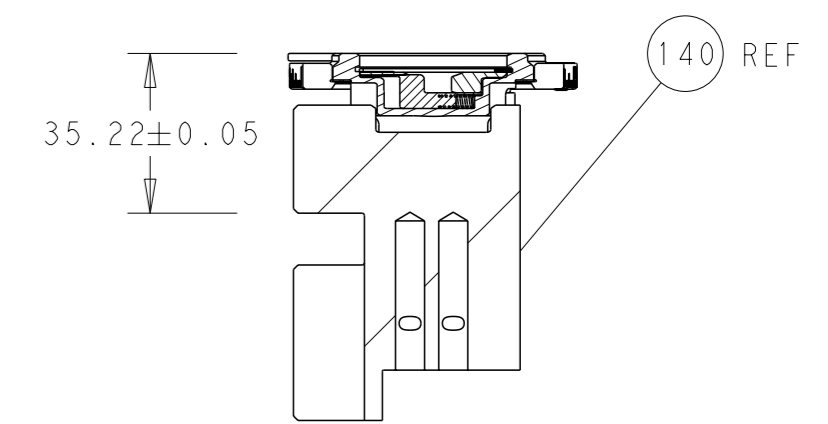
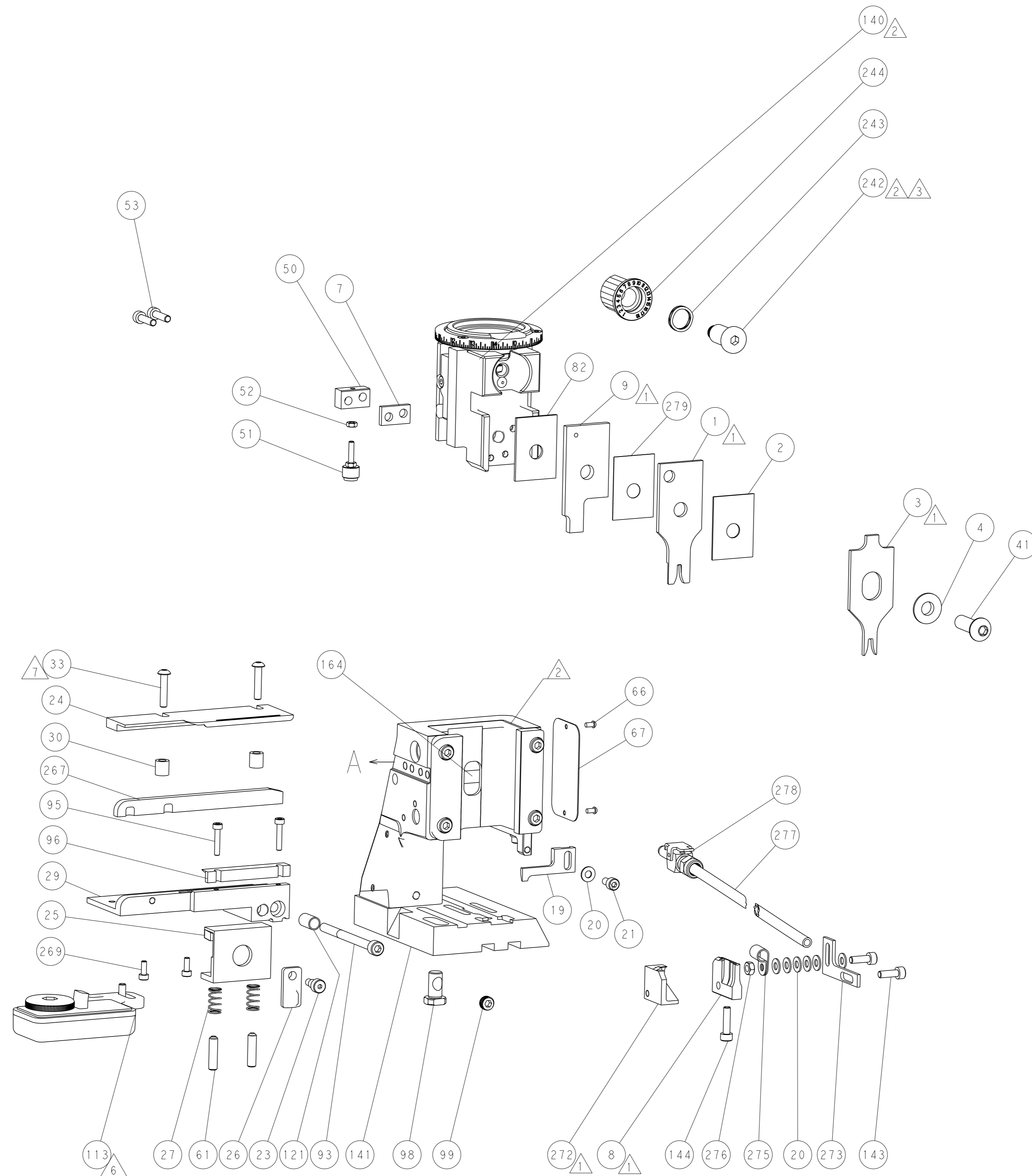


DETAIL A

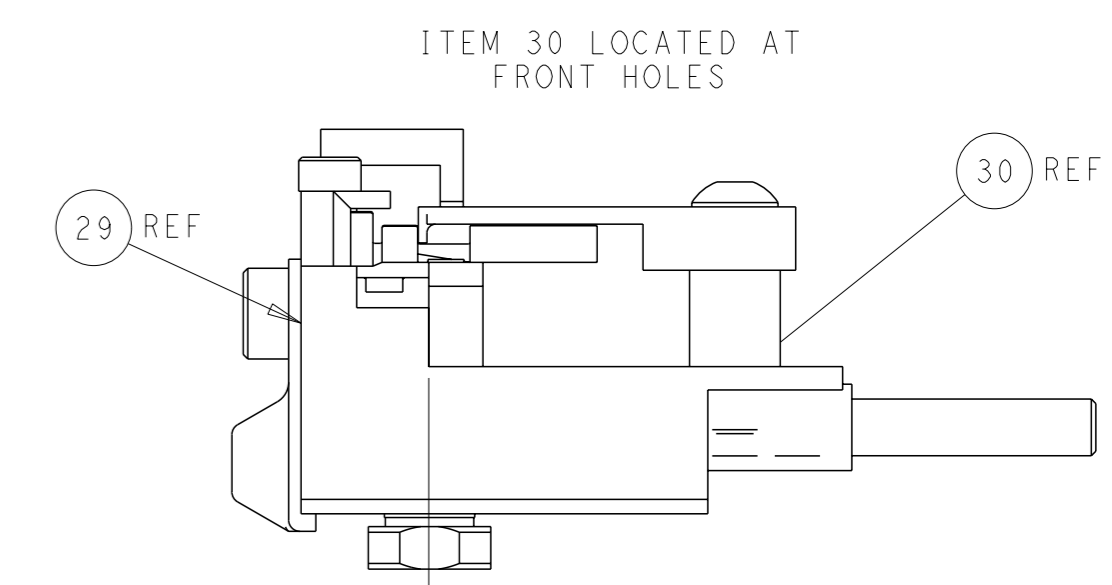
## CAM POSITION



AIR FEED



RAM SET-UP



FEED TRACK POSITION GUIDE BY WIRE BARREL

**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: -	21OCT2015 21OCT2015 21OCT2015 - - -	NAME: Ocean Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2836084 SCALE: 1:2 SHEET: 4 of 4 REV: F	TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH ±		WEIGHT: - CUSTOMER ACCESSIBLE PRODUCTION DRAWING	RESTRICTED TO: -	SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION	