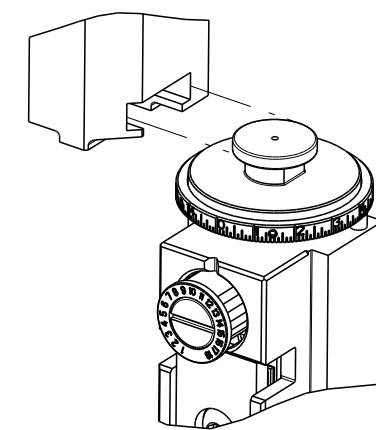


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2836116-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2836116-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2836116-1	B	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2836116-2	B	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2836116-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER

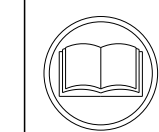


APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	4.62 mm [.182]	F
INSUL	5.40 mm [.213]	F

APPLICATOR INSTRUCTIONS 408-35042

TERMINAL DATA: LEAR/FORD TERMINAL LEAR CRIMP SPECIFICATION			
TERMINAL NAME: TERMINAL, BLADE			
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE		
4.68-5.44 mm [.184-.214 IN]	∅ 4.3 mm [.169 IN] MAX		
TERMINAL APPLICATION SPECIFICATION	381025-JL48 Rev 1		
TERMINALS APPLIED			
TE TERMINAL	LEAR/FORD TERMINAL	TE TERMINAL	LEAR/FORD TERMINAL
2113925-1	381025-JL48-05A	2113925-3	1L5T-14421-AA(FORD)
2113925-2	381025-JL48-05B		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
6.00mm2	3.55+/-0.05 [.140+/- .002]	5.8
5.00mm2	3.40+/-0.05 [.134+/- .002]	7.4
4.00mm2	3.30+/-0.05 [.130+/- .002]	8.3
3.00mm2	3.15+/-0.05 [.124+/- .002]	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 TERMINAL LUBRICANT IS RECOMMENDED.
- 6. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- 7 THIS APPLICATOR DOES NOT CUT THE CARRIER STRIP.

***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	OWN	APVD
		A		RELEASED	19JAN2016	MR	TE
		B		ECR-19-007972	21MAY2019	TB	TE

-	2	2	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	269
-	1	1	1	1	1633782-6	FENCE	267
-	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	1	1	2119082-4	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	-	1	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	1	-	1	-	2063440-1	AIR FEED MODULE	238
-	2	-	2	-	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172
-	REF	REF	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	1	1	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113
-	1	1	1	1	2844908-1	SCREW, LOCKING	99
-	1	1	1	1	2844907-1	POST, LOCKING	98
-	1	1	1	1	455888-5	SPACER, CRIMPER	82
-	2	2	2	2	2079383-4	SCR, BHSC, RoHS (M4 X 8)	79
-	1	1	1	1	1803096-1	EXTENSION PLATE	78
-	1	1	1	1	1803607-1	DOCUMENTATION PACKAGE	71
-	1	1	1	1	2119791-5	DEPRESSOR, WIRE	70
-	1	1	1	1	2119740-1	TAG, IDENTIFICATION	67
-	2	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	1	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	60
-	1	1	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	1	1	1	1	1-1338683-1	FEED PAWL	56
-	4	4	4	4	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	54
-	2	2	2	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	53
-	1	1	1	1	5018030-1	NUT, HEX, REG, RoHS, M3	52
-	1	1	1	1	811242-5	BUMPER, HOLD DOWN	51
-	1	1	1	1	690753-2	SPACER, TONKER	50
-	1	2	1	2	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	-	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	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
-	1	1	1	1	1752356-2	SUPPORT, TERMINAL	34
-	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	2	2	2-2844962-8	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29
-	1	1	1	1	455888-5	SPACER, CRIMPER	28
-	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	2	2	1-18028-2	WASHER, FLAT, REG M4	20
-	1	1	1	1	2119533-1	STRIPPER, SIDE FEED	19
-	1	1	1	1	3-22280-3	SPRING, COMPRESSION	12
-	1	1	1	1	1-356885-3	STOP, SHEAR	11
-	1	1	1	1	2119805-1	SHEAR HOLDER, FRONT	10
-	1	1	1	1	454276-5	FLOATING SHEAR, FRONT	9
-	1	2	2	1	1-1803252-6	ANVIL, COMBINATION	8
-	-	-	-	-	-	-	7
-	-	-	-	-	-	-	6
-	1	1	1	1	1-2119757-4	DEPRESSOR, SHEAR	5
-	1	1	1	1	3-238011-5	BLOCK, CRIMPER SPACER	4
-	1	2	2	1	1803246-7	CRIMPER, INSULATION F PREMIUM	3
-	1	1	1	1	455888-4	SPACER, CRIMPER	2
-	1	2	2	1	1803224-8	CRIMPER, WIRE	1

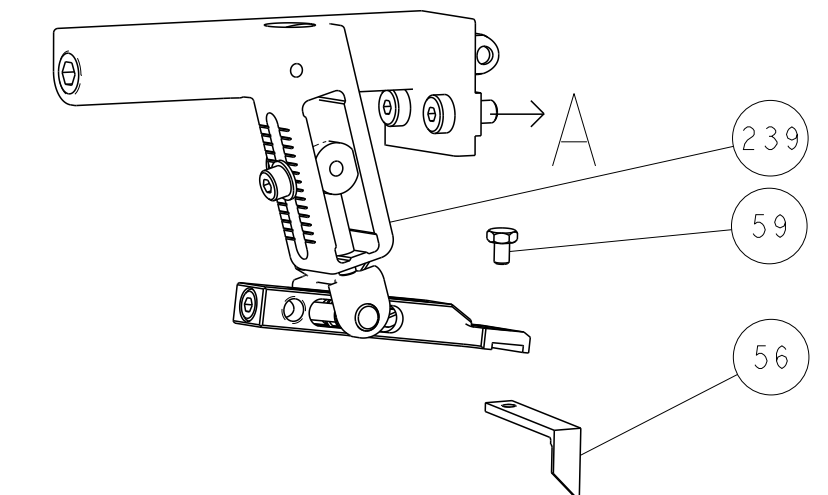
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		MATERIAL:		FINISH:	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES ±	FINISH ±

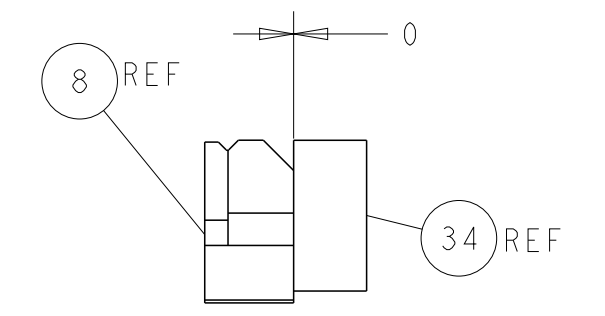
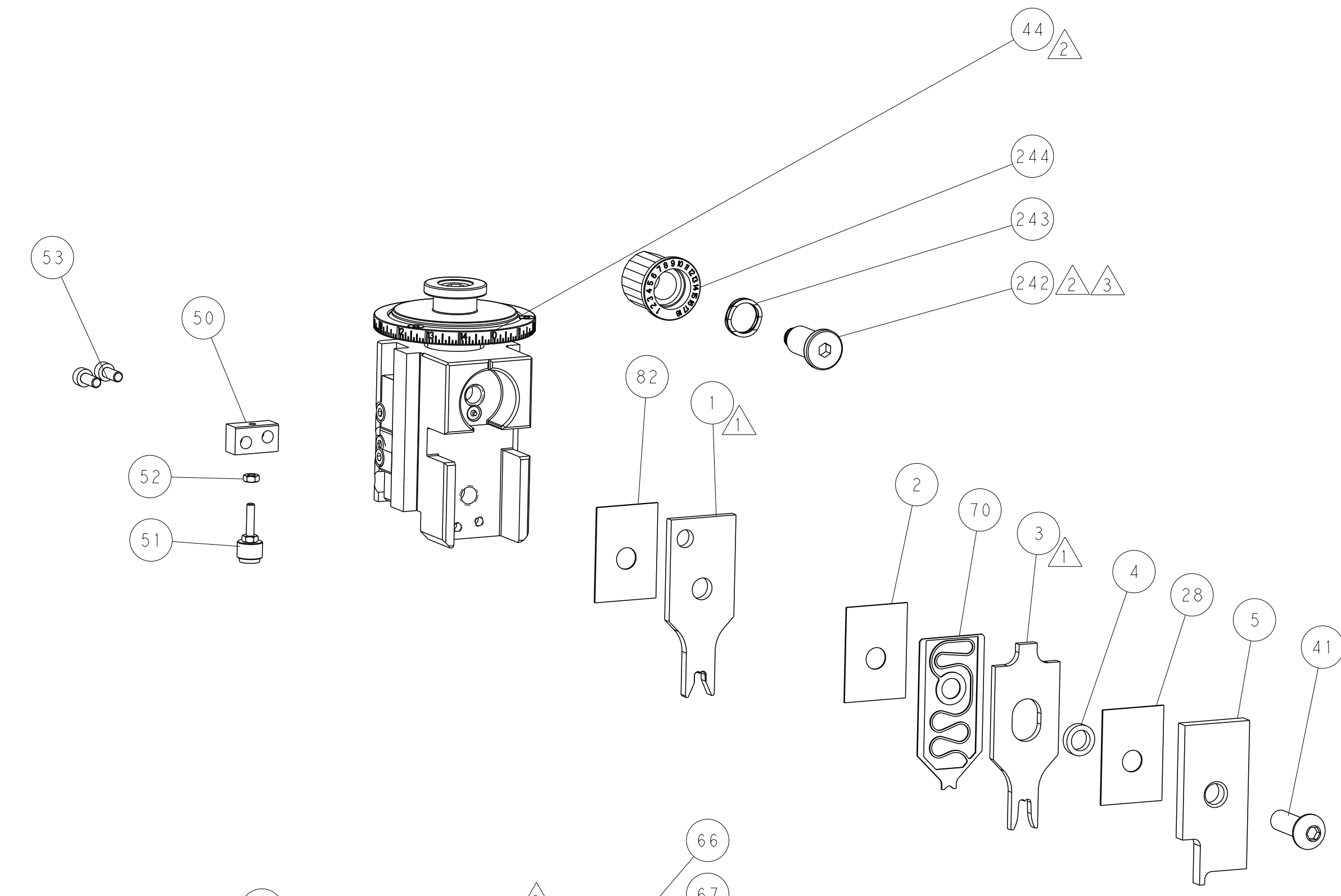
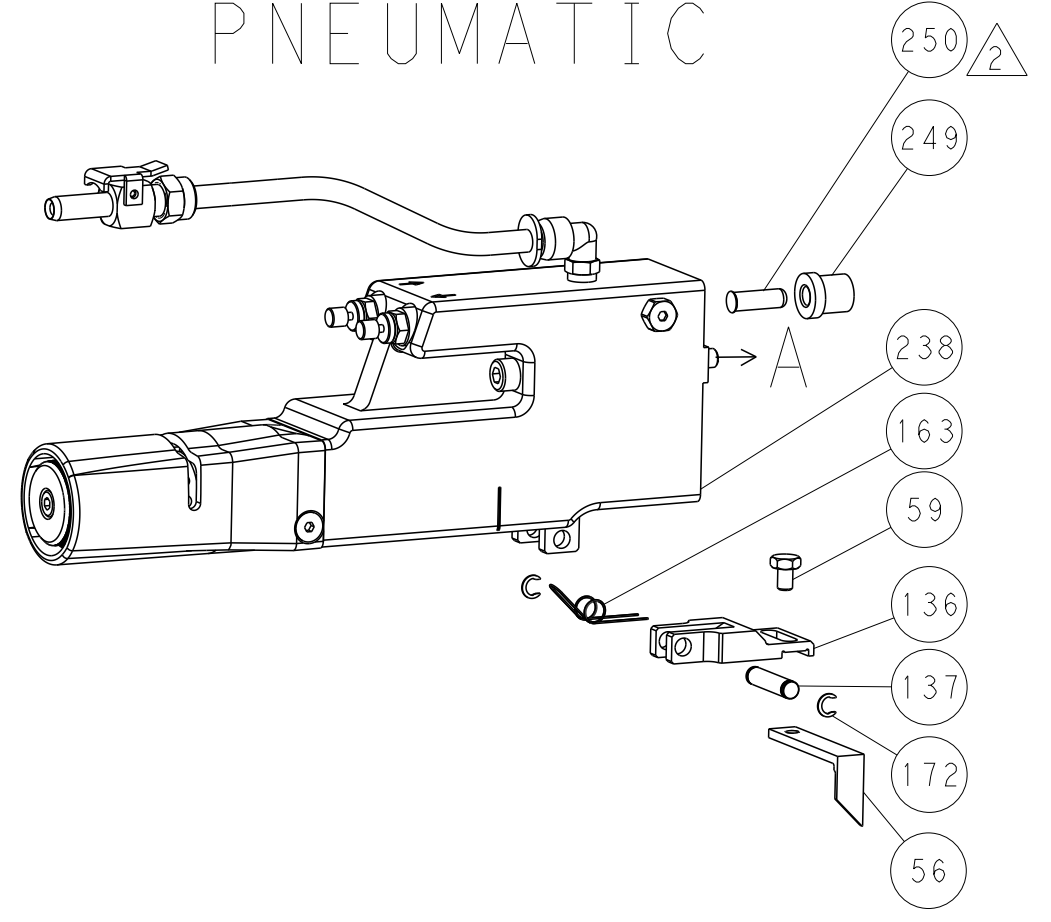
OWN	M. RILEY	19JAN2016	CHK	T. ELBIN	19JAN2016	APVD	J. DEGRANGE	19JAN2016
NAME	Ocean Side Feed Applicator							
SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO					
A1	00779	2836116						
Customer Accessible Production Drawing			SCALE	1:2	SHEET	1	OF	4
			REV	B				

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

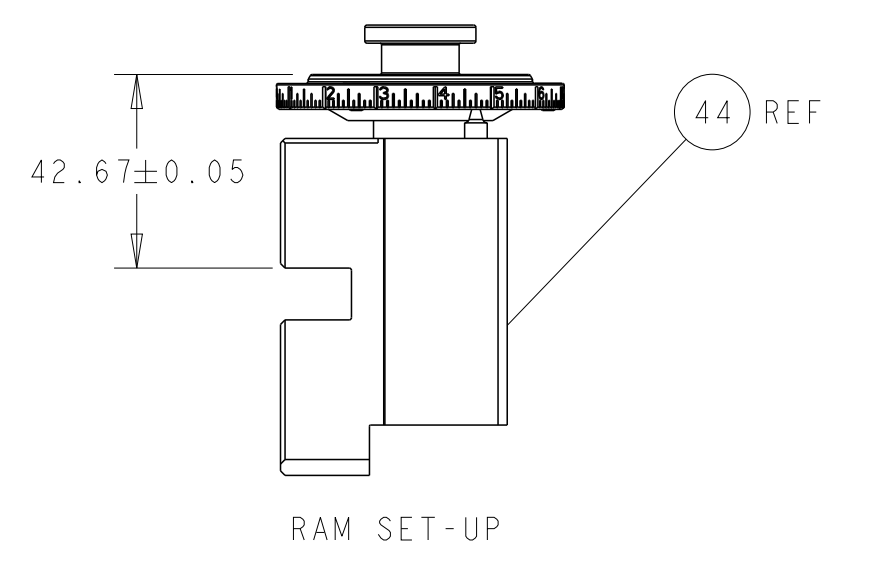
FEED TYPE MECHANICAL



PNEUMATIC

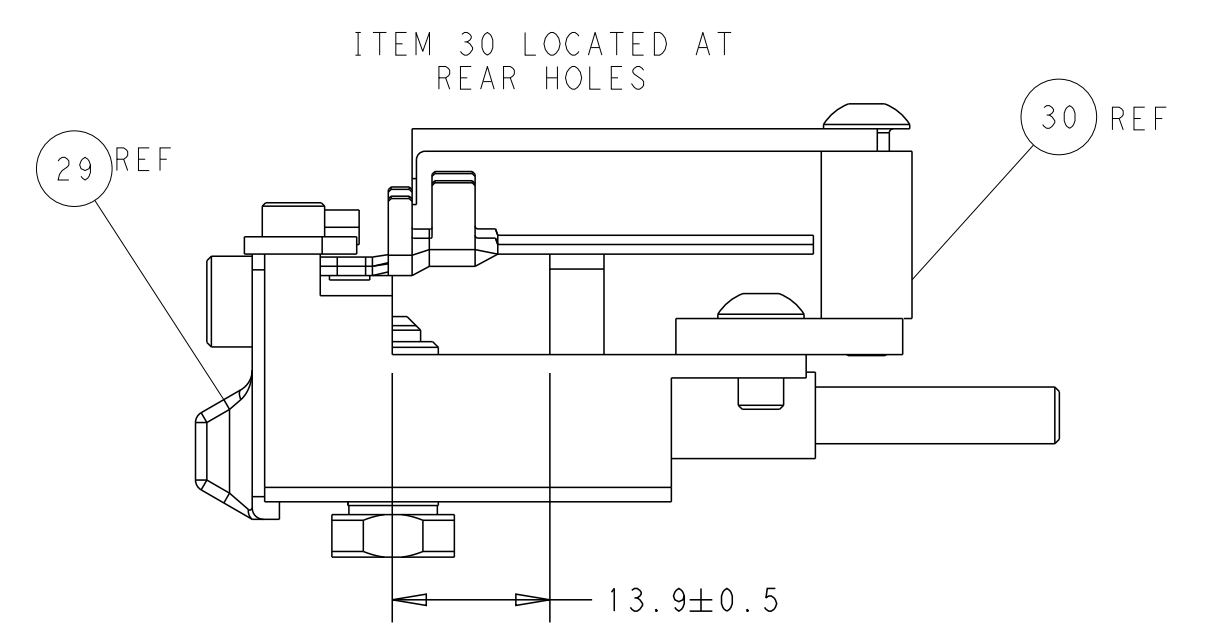
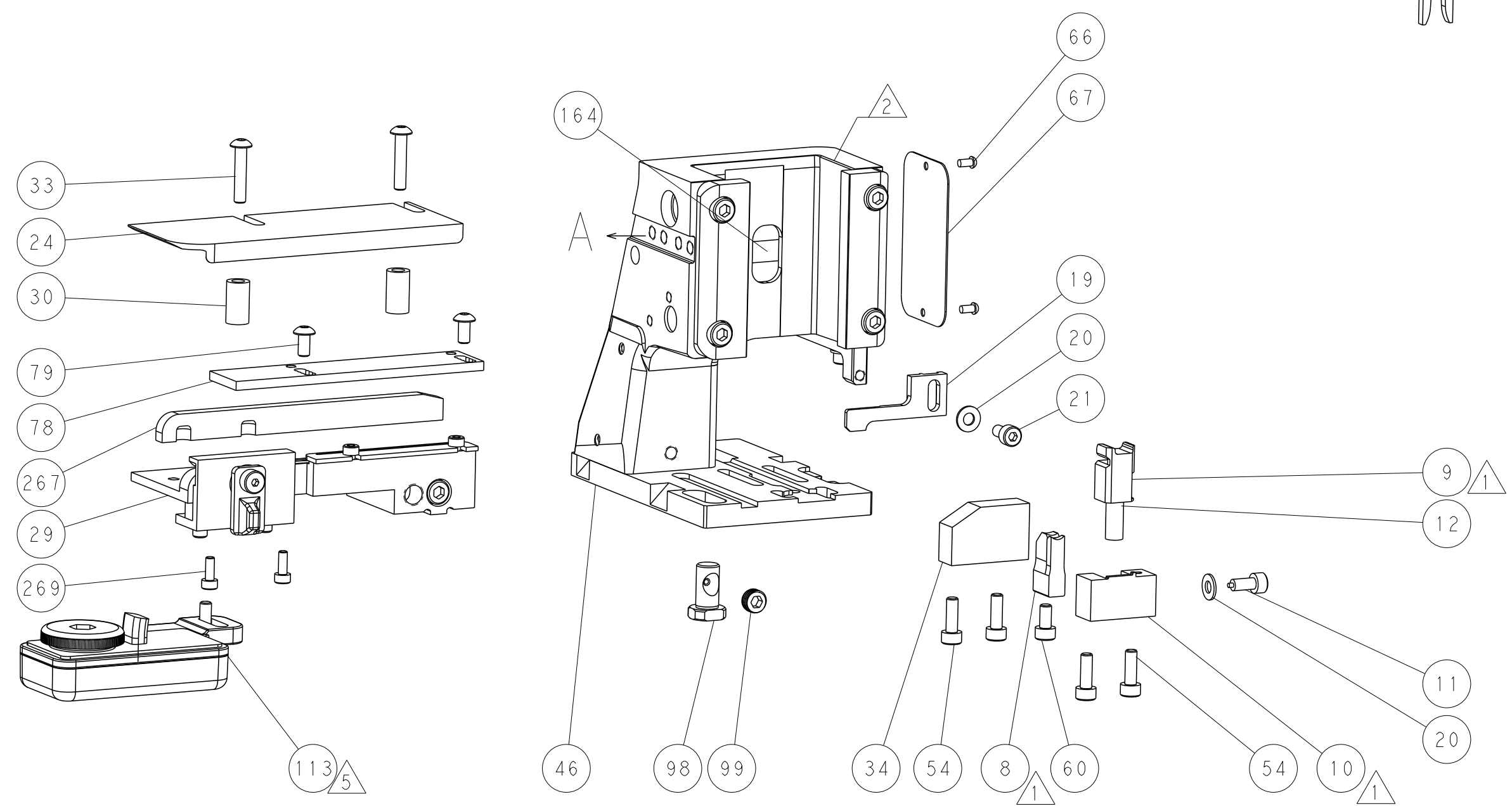
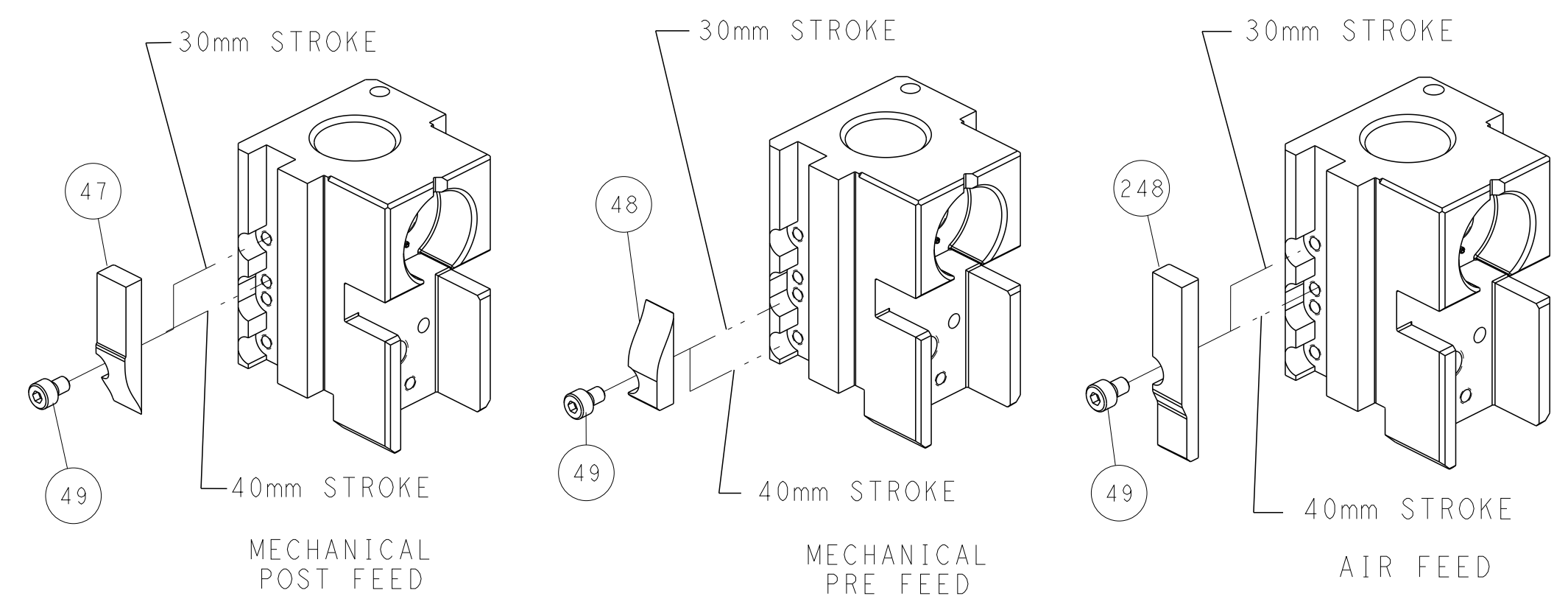


TERMINAL SUPPORT LOCATION



RAM SET-UP

CAM POSITIONS



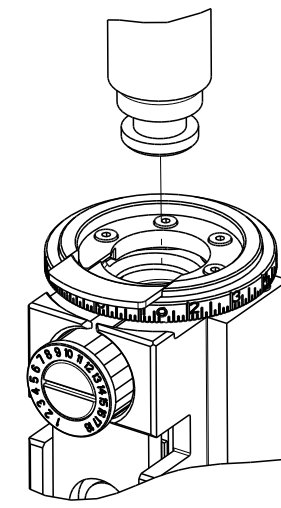
FEED TRACK POSITION GUIDE BY INSULATION BARREL

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

DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH		DMN M. RILEY 19JAN2016 CHS T. ELBIN 19JAN2016 APVD J. DEGRANGE 19JAN2016 PRODUCT SPEC APPLICATION SPEC WEIGHT Customer Accessible Production Drawing		NAME Ocean Side Feed Applicator SIZE CAGE CODE DRAWING NO A1 00779 C=2836116 SCALE 1:2 SHEET 2 OF 4 REV B		RESTRICTED TO TE Connectivity Harrisburg, PA 17105-3608	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2836116-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2836116-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2836116-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	4.62 mm [.182]	F
INSUL	5.40 mm [.213]	F
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: LEAR/FORD TERMINAL LEAR CRIMP SPECIFICATION			
TERMINAL NAME: TERMINAL, BLADE			
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE		
4.68-5.44 mm [.184-.214 IN]	∅ 4.3 mm [.169 IN] MAX		
TERMINAL APPLICATION SPECIFICATION	381025-JL48 Rev 1	-	-
TERMINALS APPLIED			
TE TERMINAL	LEAR/FORD TERMINAL	TE TERMINAL	LEAR/FORD TERMINAL
2113925-1	381025-JL48-05A	2113925-3	15T-14421-AA(FORD)
2113925-2	381025-JL48-05B		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
6.00mm2	3.55+/-0.05 [.140+/- .002]	5.8
5.00mm2	3.40+/-0.05 [.134+/- .002]	7.4
4.00mm2	3.30+/-0.05 [.130+/- .002]	8.3
3.00mm2	3.15+/-0.05 [.124+/- .002]	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.
- TERMINAL LUBRICANT IS RECOMMENDED.
- 6. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- THIS APPLICATOR DOES NOT CUT THE CARRIER STRIP.

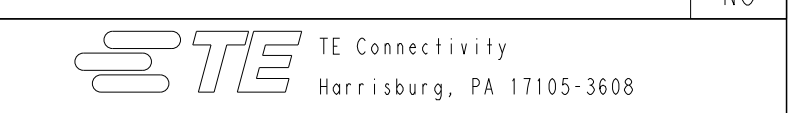
***WARNING**
ON INSTALLATION, SET WIRE DISC TO CRIMP HEIGHT REFERENCE SETTING FOR LARGEST WIRE SIZE. CRIMP HEIGHT REFERENCE SETTINGS GREATER THAN THE VALUE SHOWN MAY CAUSE DAMAGE TO THE CRIMP TOOLING. REFER TO THE INSTRUCTION SHEET FOR PROPER SETUP AND ADJUSTMENTS.

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

-	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	269
-	1	1	1633782-6	FENCE	267
-	1	-	2119640-1	PUSH ROD, AIR FEED	250
-	1	-	1803259-1	BUSHING, FLANGED	249
-	1	1	2119082-4	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	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	1	-	2063440-1	AIR FEED MODULE	238
-	2	-	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172
-	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	1	-	240638-1	SPRING, FEED FINGER	163
-	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
-	1	-	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854	137
-	1	-	2119799-1	HOLDER, FEED FINGER, AF	136
-	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	1803607-1	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	1-1338683-1	FEED PAWL	56
-	2	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	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	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	1752356-2	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	455888-5	SPACER, CRIMPER	28
-	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	2119533-1	STRIPPER, SIDE FEED	19
-	1	1	3-22280-3	SPRING, COMPRESSION	12
-	1	1	1-356885-3	STOP, SHEAR	11
-	1	1	2119805-1	SHEAR HOLDER, FRONT	10
-	1	1	454276-5	FLOATING SHEAR, FRONT	9
-	1	1	1-1803252-6	ANVIL, COMBINATION	8
-	-	-	-	-	7
-	-	-	-	-	6
-	1	1	1-2119757-4	DEPRESSOR, SHEAR	5
-	1	1	3-238011-5	BLOCK, CRIMPER SPACER	4
-	1	1	1803246-7	CRIMPER, INSULATION F PREMIUM	3
-	1	1	455888-4	SPACER, CRIMPER	2
-	1	1	1803224-8	CRIMPER, WIRE	1

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

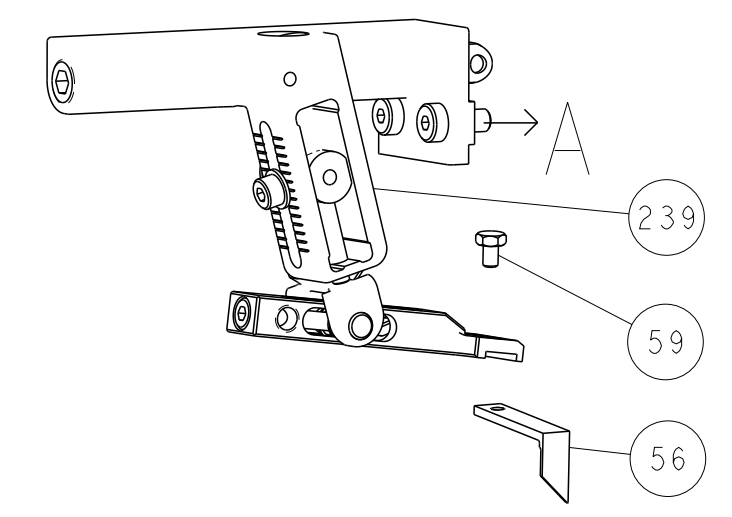
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		MATERIAL:		FINISH:		WEIGHT:		SCALE:		SHEET:		REV:		
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES	FINISH			A1	00779	C=2836116	1:2	3	4	B



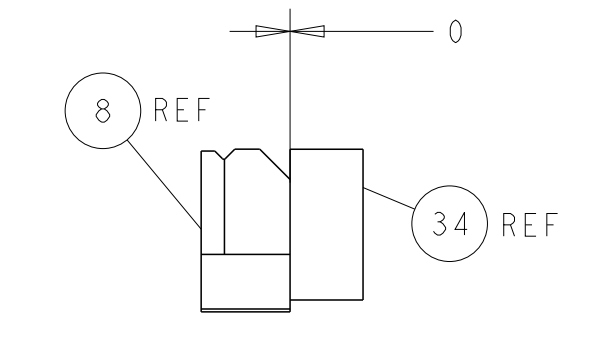
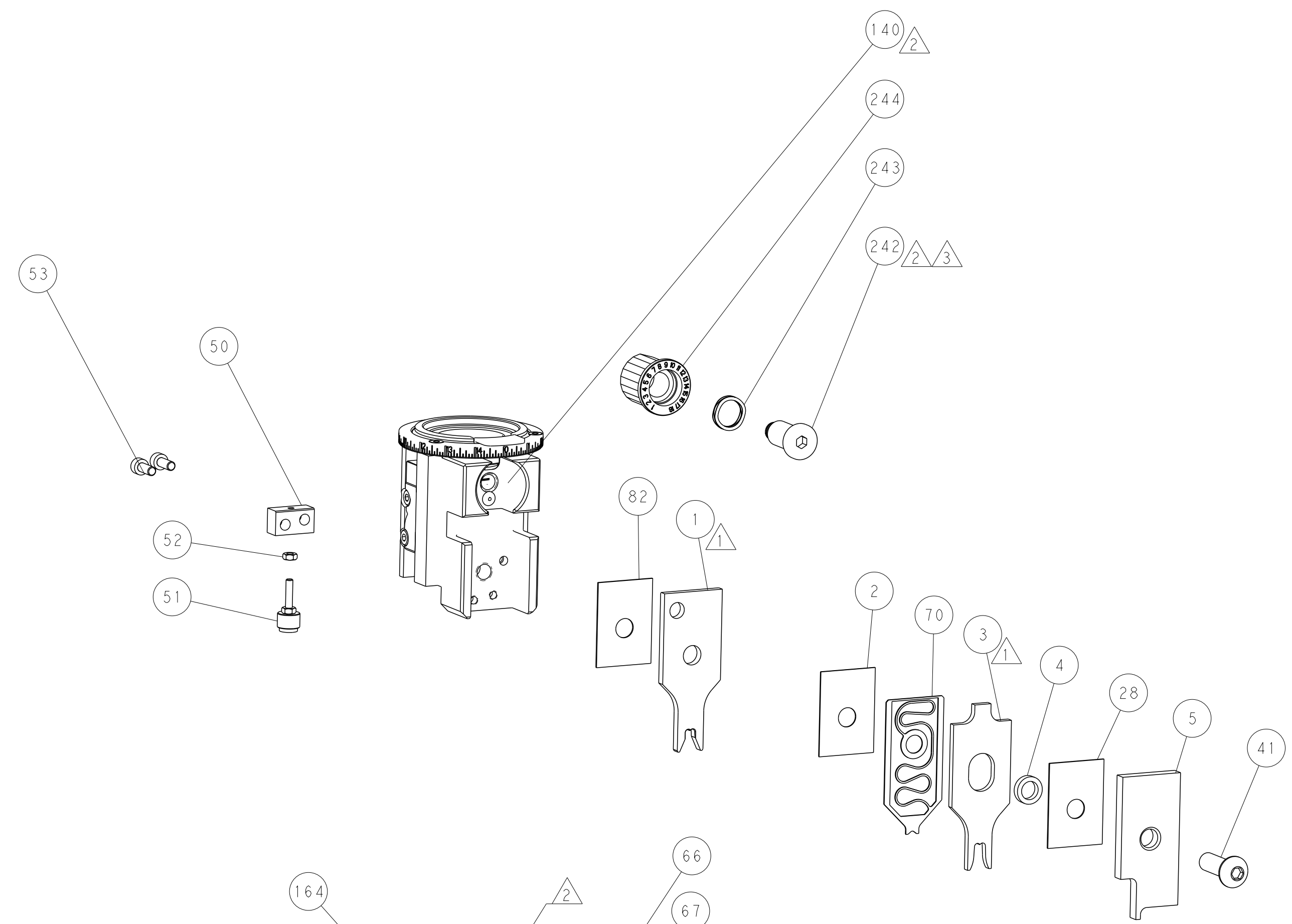
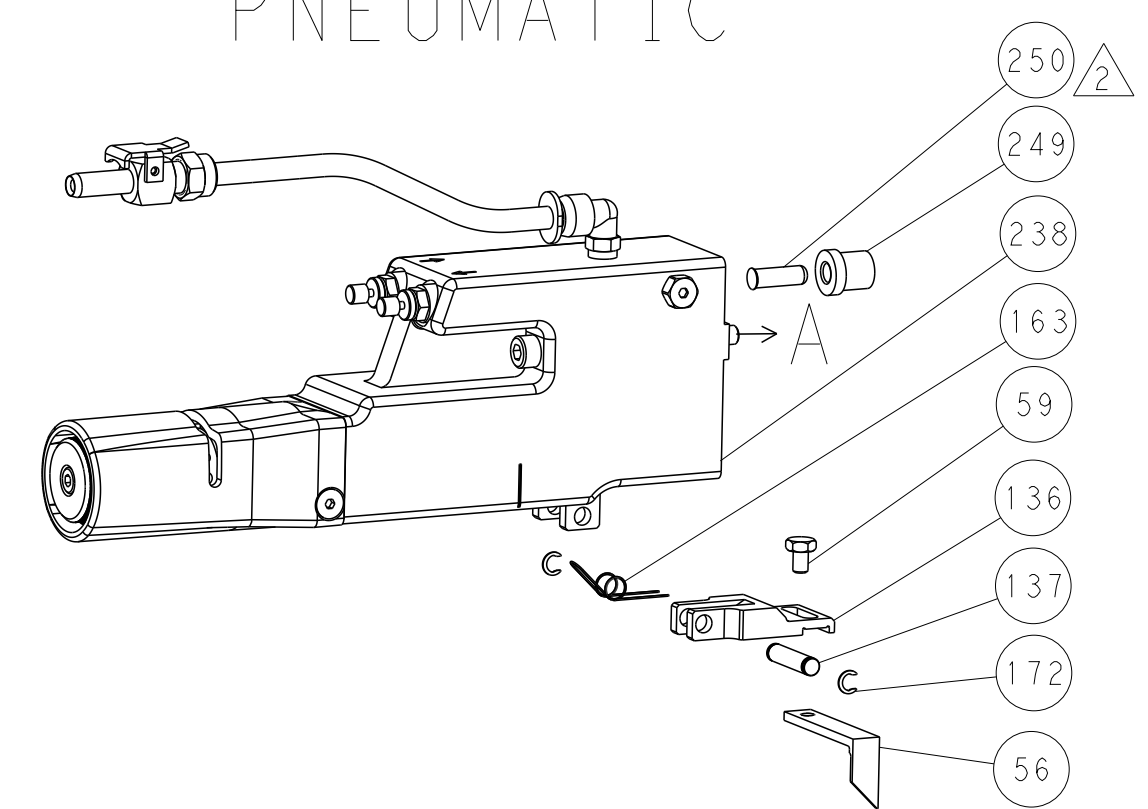
Ocean Side Feed
Applicator

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

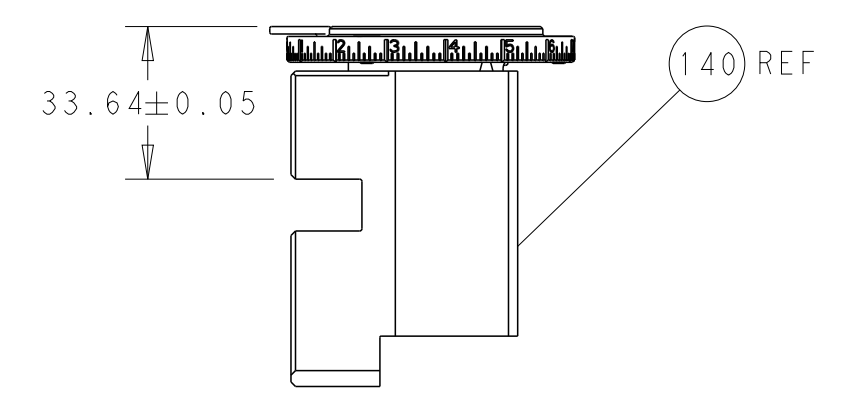
FEED TYPE MECHANICAL



PNEUMATIC

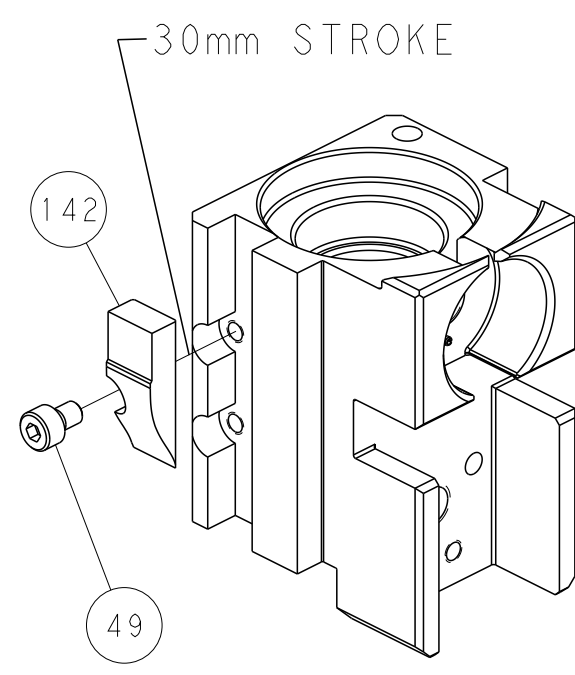


TERMINAL SUPPORT LOCATION

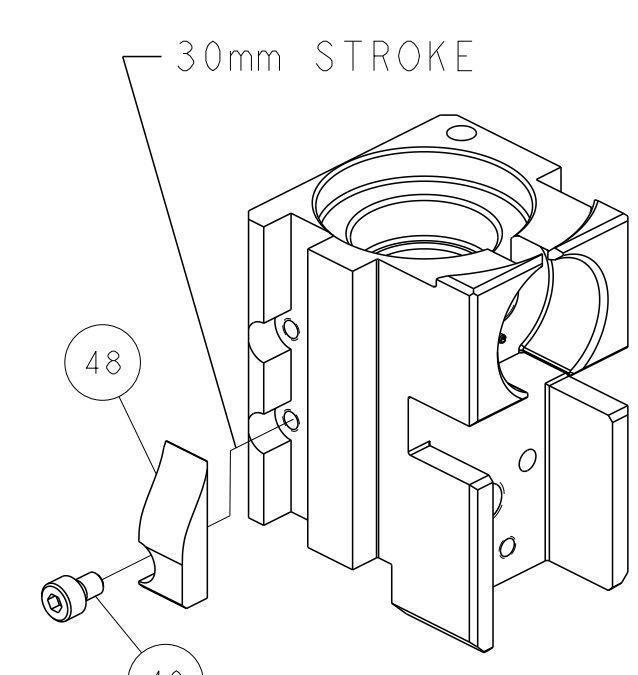


RAM SET-UP

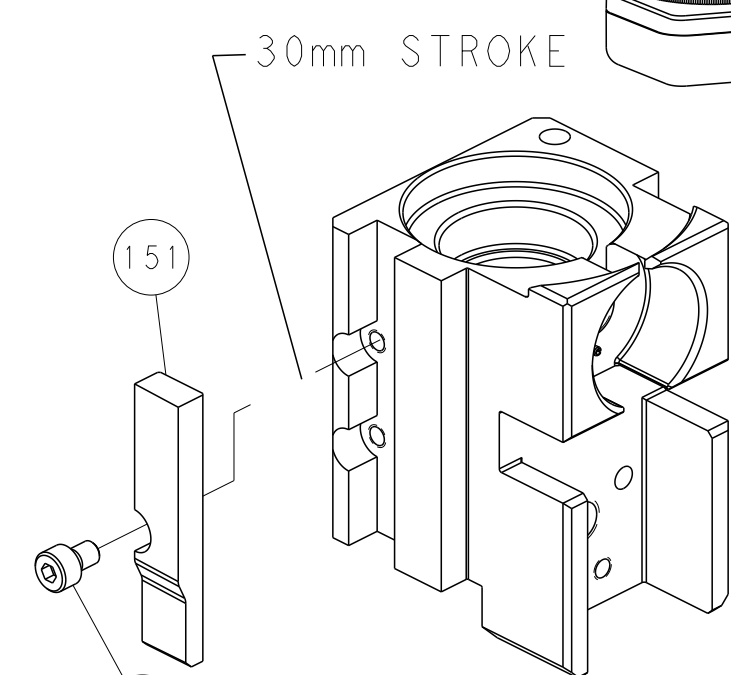
CAM POSITIONS



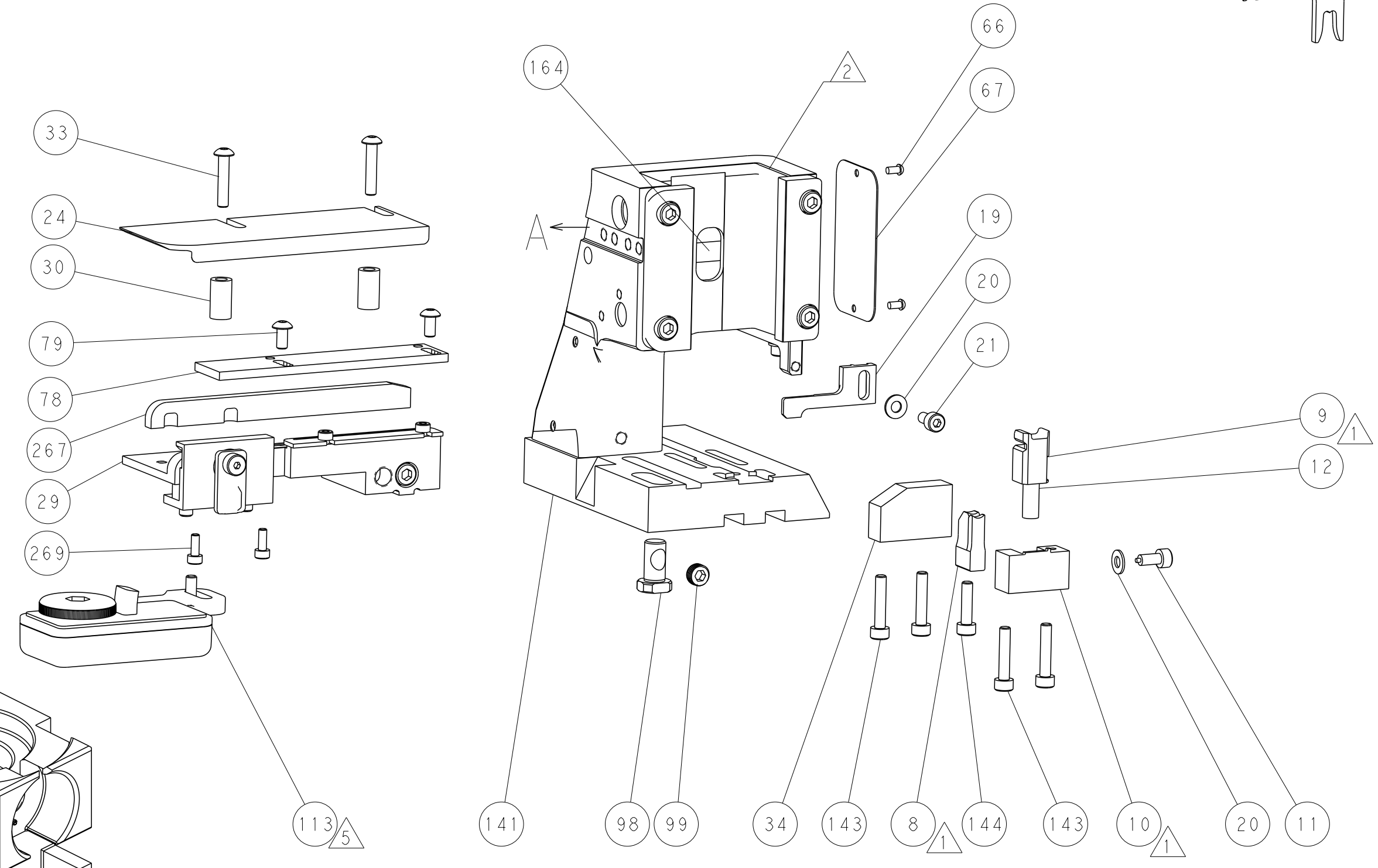
MECHANICAL POST FEED



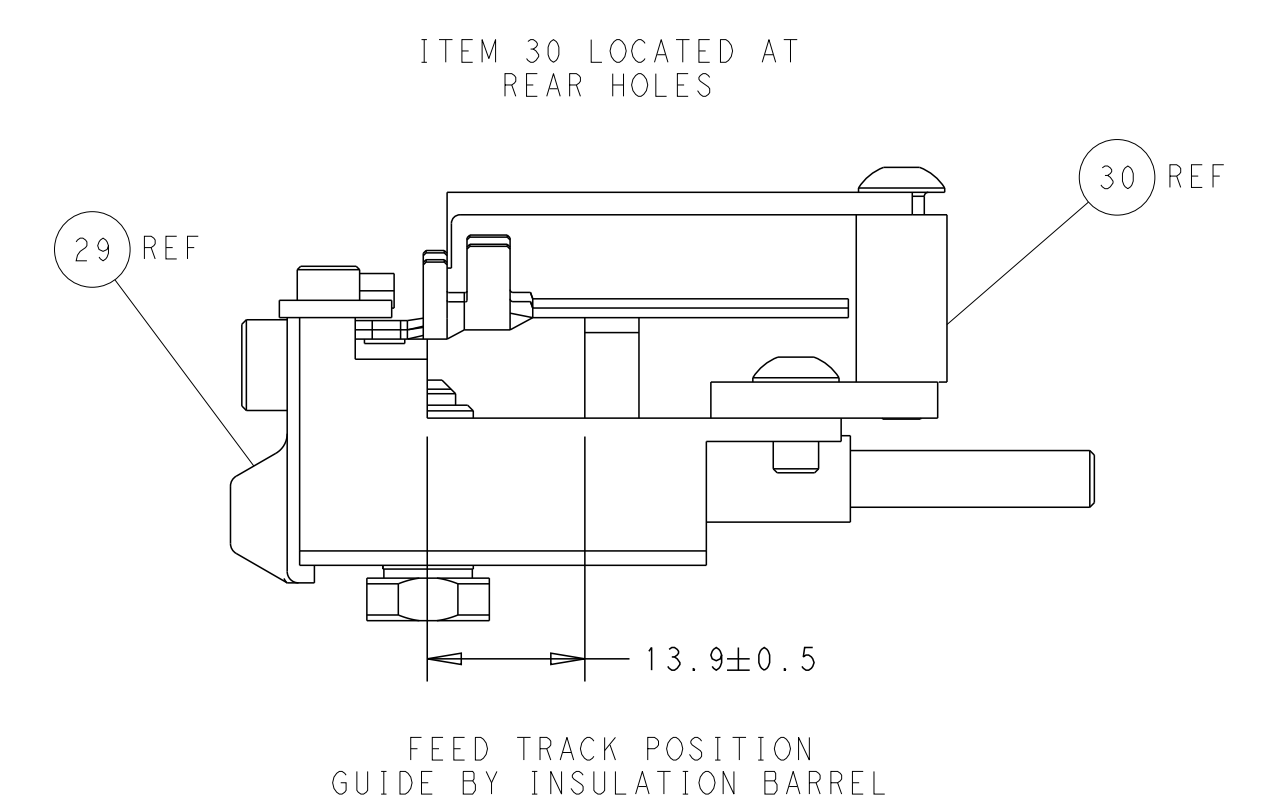
MECHANICAL PRE FEED



AIR FEED



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



FEED TRACK POSITION GUIDE BY INSULATION BARREL

<small>THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION. ALL RIGHTS RESERVED. © 2016 BY TYCO ELECTRONICS CORPORATION.</small>		DWN: M. RILEY 19JAN2016 CHK: T. ELBIN 19JAN2016 APVD: J. DEGRANGE 19JAN2016	NAME: TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH	MATERIAL:	PRODUCT SPEC: APPLICATION SPEC: WEIGHT:	SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2836116 RESTRICTED TO:
Customer Accessible Production Drawing		SCALE: 1:2	SHEET 4 OF 4 REV B

Mouser Electronics

Authorized Distributor

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[TE Connectivity:](#)

[2836116-1](#)