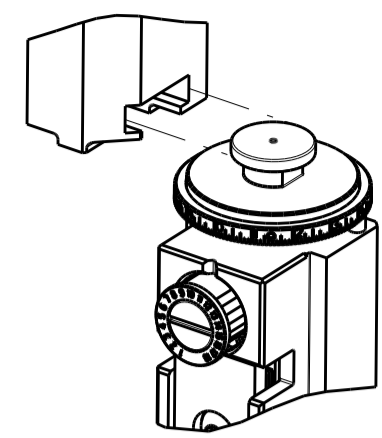


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2836398-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2836398-2	C	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2836398-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.79 mm [.110]	F
INSUL	4.57 mm [.180]	F

APPLICATOR INSTRUCTIONS 408-35042

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: 250 SERIES POSITIVE LOCK RECEPTACLE			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
5.00-6.00 mm [.197-.236 IN]		∅2.10-3.40 mm [.083-.134 IN]	
TERMINAL APPLICATION SPECIFICATION	114-5032		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
170233-1	170233-2	170233-3	170233-4

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
14 AWG OR 2.00mm ²	1.85+/-0.05 [.073+/-0.002]	7.6
16 AWG OR 1.25mm ²	1.61+/-0.05 [.063+/-0.002]	10.7
0.75/0.85mm ² OR 18 AWG	1.49+/-0.05 [.059+/-0.002]	11.3
20 AWG OR 0.50mm ²	1.39+/-0.05 [.055+/-0.002]	12.4

- 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 PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
 - TERMINAL LUBRICANT IS RECOMMENDED.
7. 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	P	LTN	DESCRIPTION	DATE	OWN	APVD
		1		DEVELOPMENT	13JUL2016	MZ	KZ
		A		RELEASED	11AUG2016	YH	KZ
		B		ECR-18-008505	05JUN2018	KH	TE
		C		ECR-20-016561	20NOV2020	FZ	TE

-	1	1	2119641-1	FEED CAM, AIR FEED	248	
-	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	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241	
-	1	1	2844940-1	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	455888-5	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	1338683-8	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	1-1752356-8	SUPPORT, TERMINAL	34	
-	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33	
-	2	2	3-2844962-0	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	3-1633923-1	ANVIL, COMBINATION	8
-	1	1	240641-7	SPACER	7	
-	-	-	-	-	6	
-	1	1	2119757-8	DEPRESSOR, SHEAR	5	
-	1	1	238011-4	BLOCK, CRIMPER SPACER	4	
-	1	2	1	4-2119582-1	CRIMPER, INSULATION F PREMIUM	3
-	1	1	455888-4	SPACER, CRIMPER	2	
-	1	2	1	4-456408-3	CRIMPER, WIRE PREMIUM	1
-	77	-72	-2	PART NO	DESCRIPTION	ITEM NO

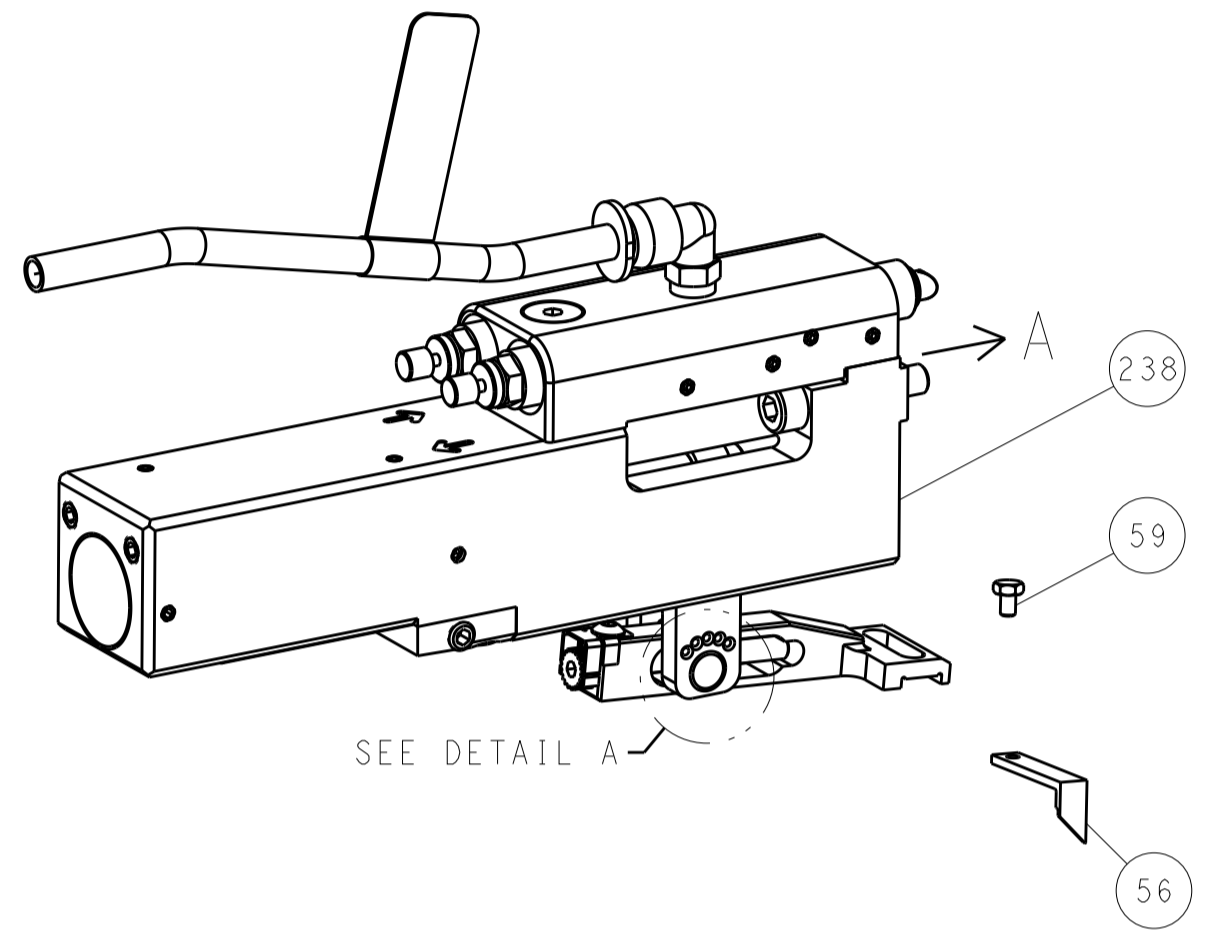
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		MATERIAL:		FINISH:	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES ±	

OWN	JM ZHAO	13JUL2016	CHK	K. ZHANG	13JUL2016	APVD	K. ZHANG	13JUL2016
NAME	Ocean Side Feed Applicator							
PRODUCT SPEC	-							
APPLICATION SPEC	-							
SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO					
A1	00779	2836398	-					
Customer Accessible Production Drawing								SCALE 1:2 SHEET 1 OF 4 REV C

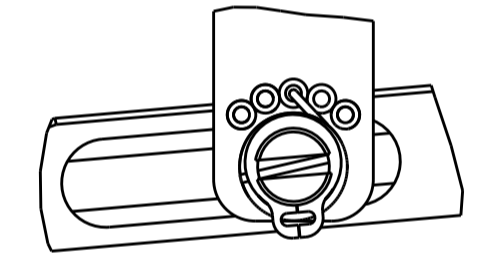
LOC	DIST	REV	DATE	BY	APP'D
A	66				

FEED TYPE

PNEUMATIC

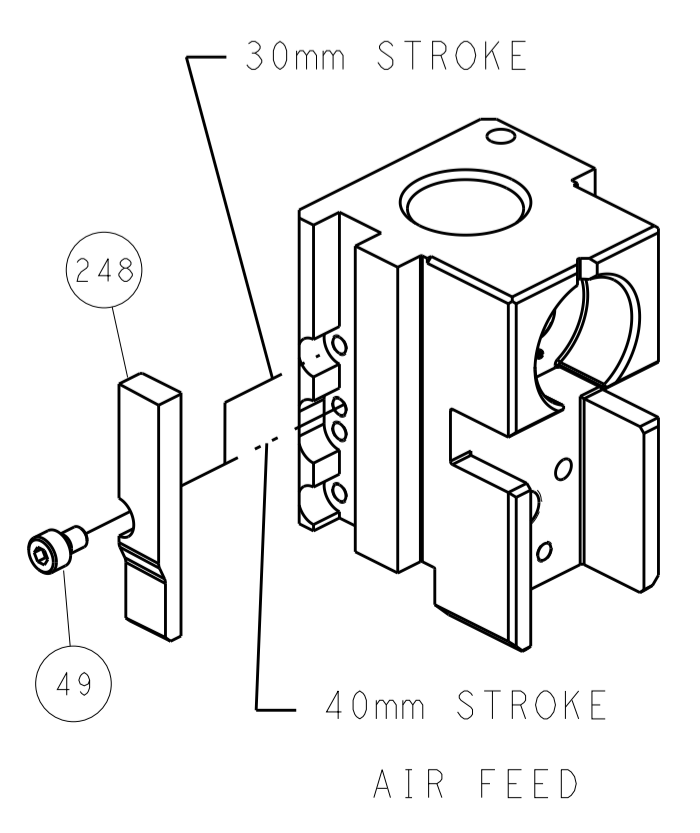


FEED SPRING SETTING POSITION
(SHOWN FROM REAR SIDE)

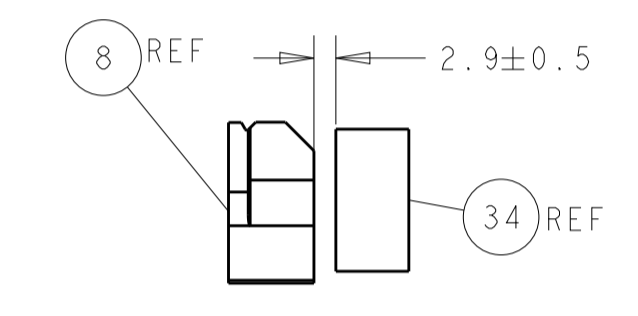
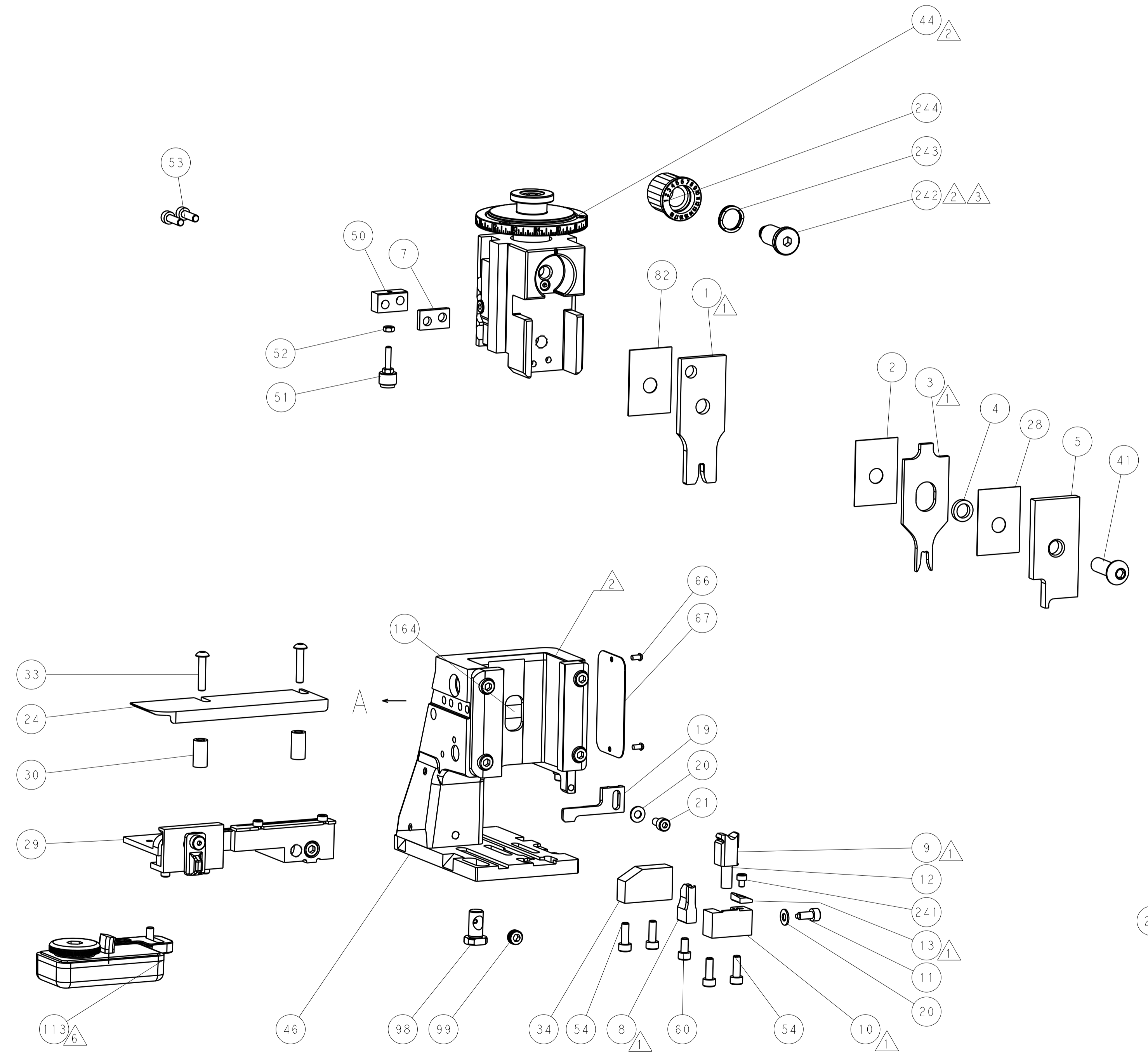


DETAIL A

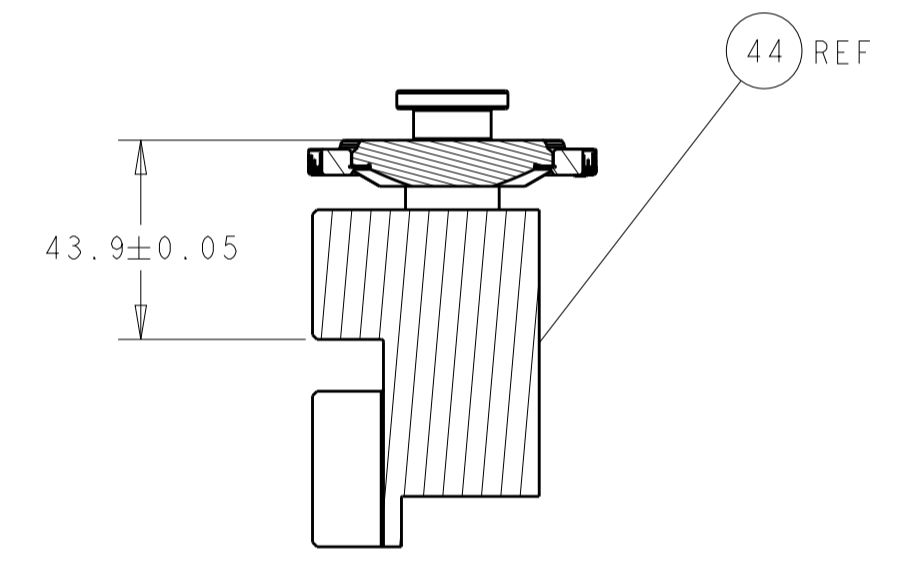
CAM POSITION



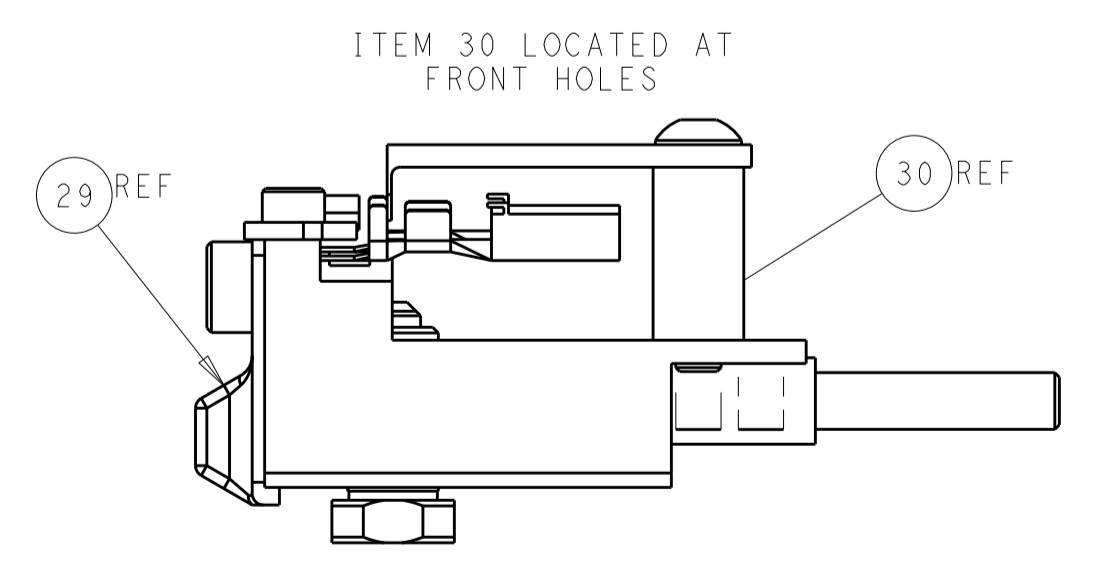
AIR FEED



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: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		DWG: M. ZHAO 13JUL2016 CHK: K. ZHANG 13JUL2016 APP'D: K. ZHANG 13JUL2016 NAME: Ocean Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: C-2836398 SCALE: 1:2 SHEET: 2 OF 4 REV: C	
MATERIAL: -		FINISH: -		RESTRICTED TO: - Customer Accessible Production Drawing	

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2836398-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2836398-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
 INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.79 mm [.110]	F
INSUL	4.57 mm [.180]	F

APPLICATOR INSTRUCTIONS
 408-35042

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: 250 SERIES POSITIVE LOCK RECEPTACLE			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
5.00-6.00 mm [.197-.236 IN]		∅2.10-3.40 mm [.083-.134 IN]	
TERMINAL APPLICATION SPECIFICATION	114-5032	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
170233-1	170233-2	170233-3	170233-4

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
14 AWG OR 2.00mm ²	1.85+/-0.05 [.073+/- .002]	7.6
16 AWG OR 1.25mm ²	1.61+/-0.05 [.063+/- .002]	10.7
0.75/0.85mm ² OR 18 AWG	1.49+/-0.05 [.059+/- .002]	11.3
20 AWG OR 0.50mm ²	1.39+/-0.05 [.055+/- .002]	12.4

- 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 PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
 - TERMINAL LUBRICANT IS RECOMMENDED.
7. 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	LTN	DESCRIPTION	DATE	DMN	APVD
-	-	-	-	SEE SHEET 1	-	-	-

-	1	2119082-4	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	2844940-1	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	
-	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	455888-5	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	1338683-8	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	1-1752356-8	SUPPORT, TERMINAL	34	
-	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33	
-	2	3-2844962-0	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	3-1633923-1	ANVIL, COMBINATION	8	
-	1	240641-7	SPACER	7	
-	-	-	-	6	
-	1	2119757-8	DEPRESSOR, SHEAR	5	
-	1	238011-4	BLOCK, CRIMPER SPACER	4	
-	1	4-2119582-1	CRIMPER, INSULATION F PREMIUM	3	
-	1	455888-4	SPACER, CRIMPER	2	
-	1	4-456408-3	CRIMPER, WIRE PREMIUM	1	
-	77	-22	PART NO	DESCRIPTION	ITEM NO

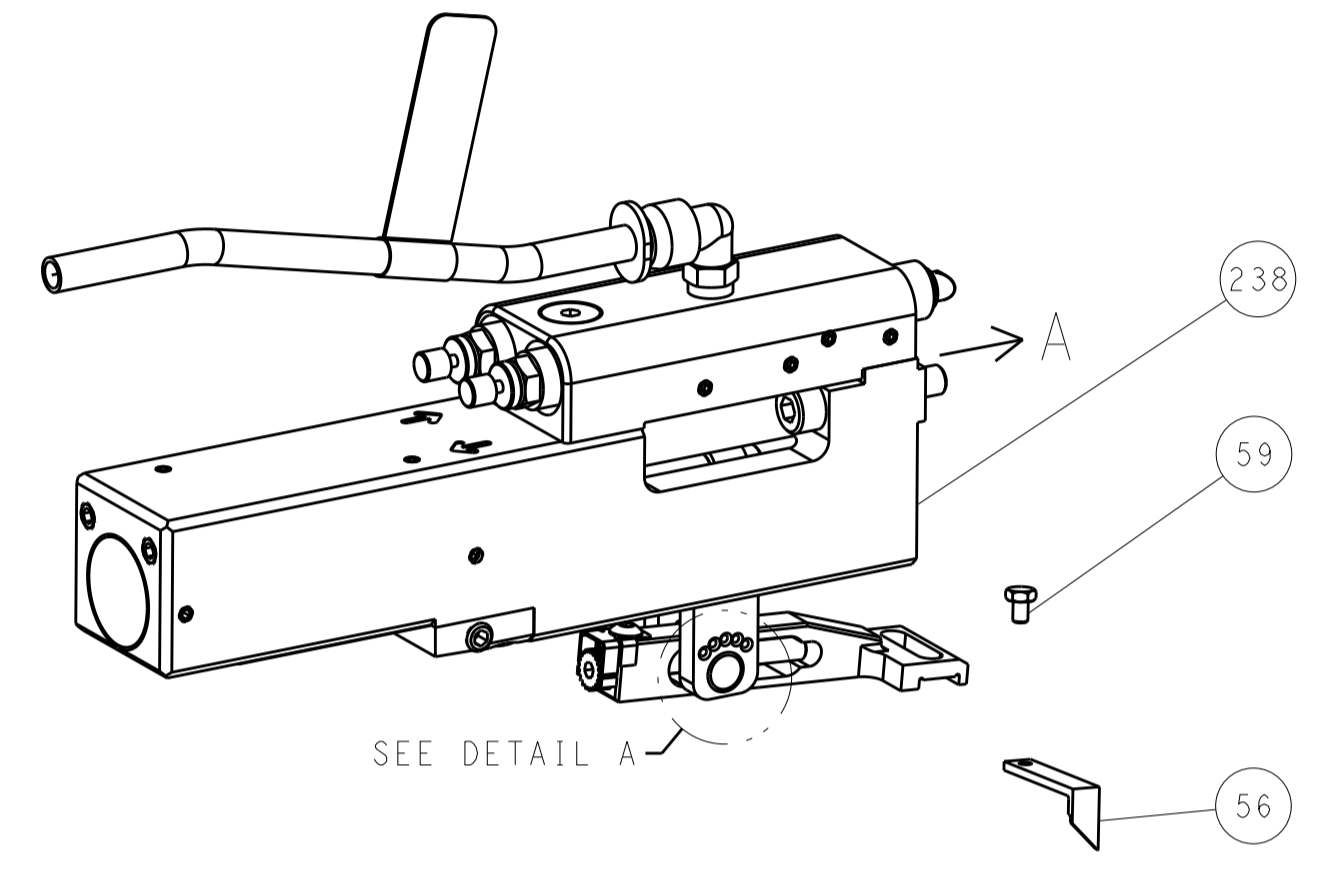
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		MATERIAL:		FINISH:	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES ±	FINISH ±

DMN	JM ZHAO	13JUL2016	TE Connectivity Harrisburg, PA 17105-3608				
CHK	K. ZHANG	13JUL2016					
APVD	K. ZHANG	13JUL2016					
NAME	Ocean Side Feed Applicator						
PRODUCT SPEC			SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO	
APPLICATION SPEC			A1	00779	2836398		
WEIGHT			Customer Accessible Production Drawing				
SCALE	1:2		SHEET	3 OF 4		REV	C

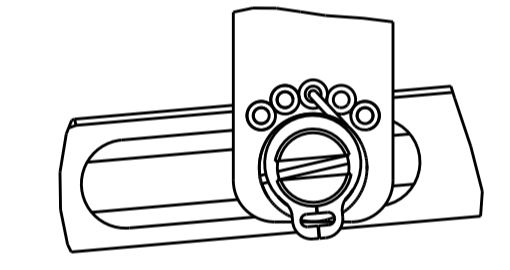
LOC		DIST		REVISIONS			
A	66	P	LTH	DESCRIPTION	DATE	DMN	APVD
		-	-	SEE SHEET 1	-	-	-

FEED TYPE

PNEUMATIC

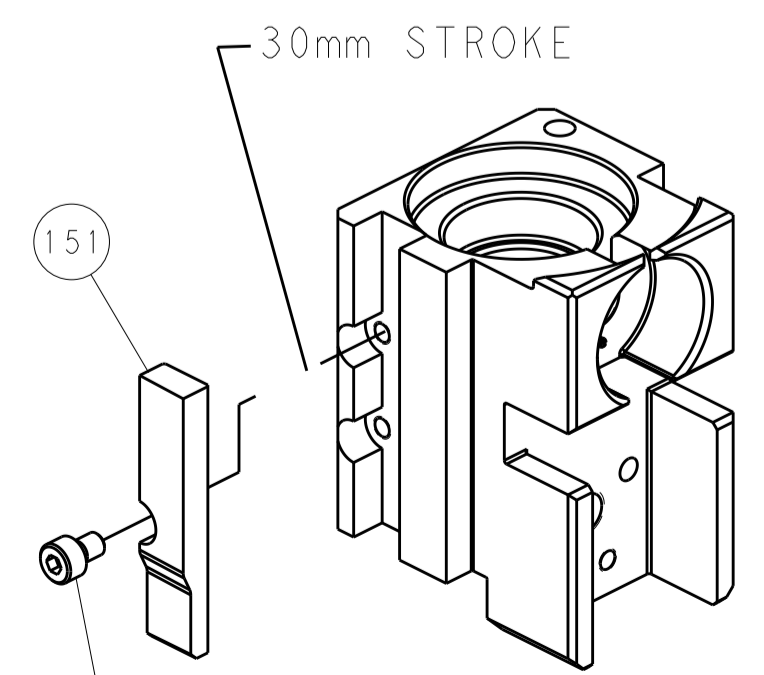


FEED SPRING SETTING POSITION
(SHOWN FROM REAR SIDE)

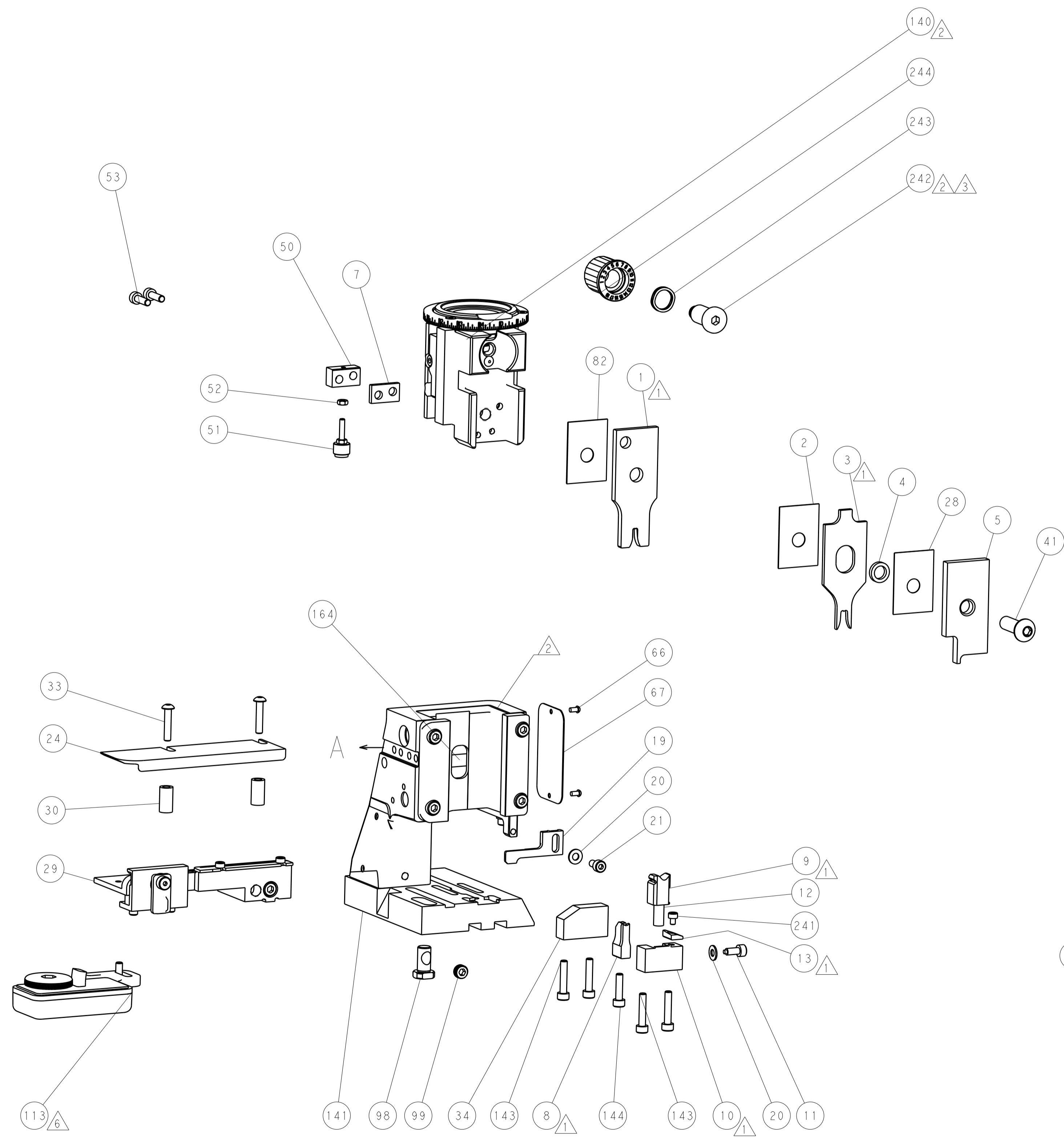


DETAIL A

CAM POSITION



AIR FEED



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)

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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=2836398 SHEET 4 OF 4 REV C

Mouser Electronics

Authorized Distributor

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[TE Connectivity:](#)

[2836398-2](#)