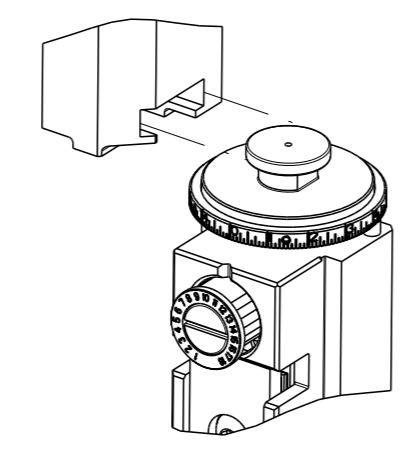


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2836263-2	E	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
3-2836263-2	E	FINE CRIMP HEIGHT ADJUST	DOUBLE ACTING PNEUMATIC WITH SENSORS ⁶
5-2836263-2	E	SEAL STRIPPER CRIMPER TERMINATING UNIT	PNEUMATIC
7-2836263-2	E	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2836263-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA

CRIMP	SIZE	TYPE
WIRE	1.17 mm (.046)	F
INSUL	-	-

APPLICATOR INSTRUCTIONS
408-10389

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION

TERMINAL NAME: CENTER CONTACT, SOCKET, 180 DEG MINI COAX

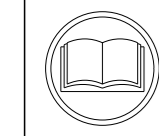
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE
2.35-2.65 mm [.093-.104 IN]	Ø

TERMINAL APPLICATION SPECIFICATION 114-94413

TERMINALS APPLIED ⁵/₆/₇

TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
2298121-1			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
RTK031	0.69 +/- 0.03 [.027 +/- .001]	5.7



- ¹ RECOMMENDED SPARE PARTS
- ² REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- ³ APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 180.
- 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 THIS APPLICATOR IS EQUIPPED WITH THE DOUBLE ACTING FEED WITH SENSORS AND IS APPLICATION SPECIFIC AND DOES NOT REQUIRE ITEMS 49 & 248.
- ⁷ TERMINAL LUBRICANT IS RECOMMENDED.
- 8. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.

LOC	DIST	REV	DESCRIPTION	DATE	OWN	APVD
A	66	B	ECR-18-010080	02JUL2018	YY	GB
		C	ECR-18-018688	28NOV2018	JAH	CT
		D	ECR-19-010748	10JUL2019	JAH	TE
		E	ECR-19-019141	09DEC2019	JAH	TE

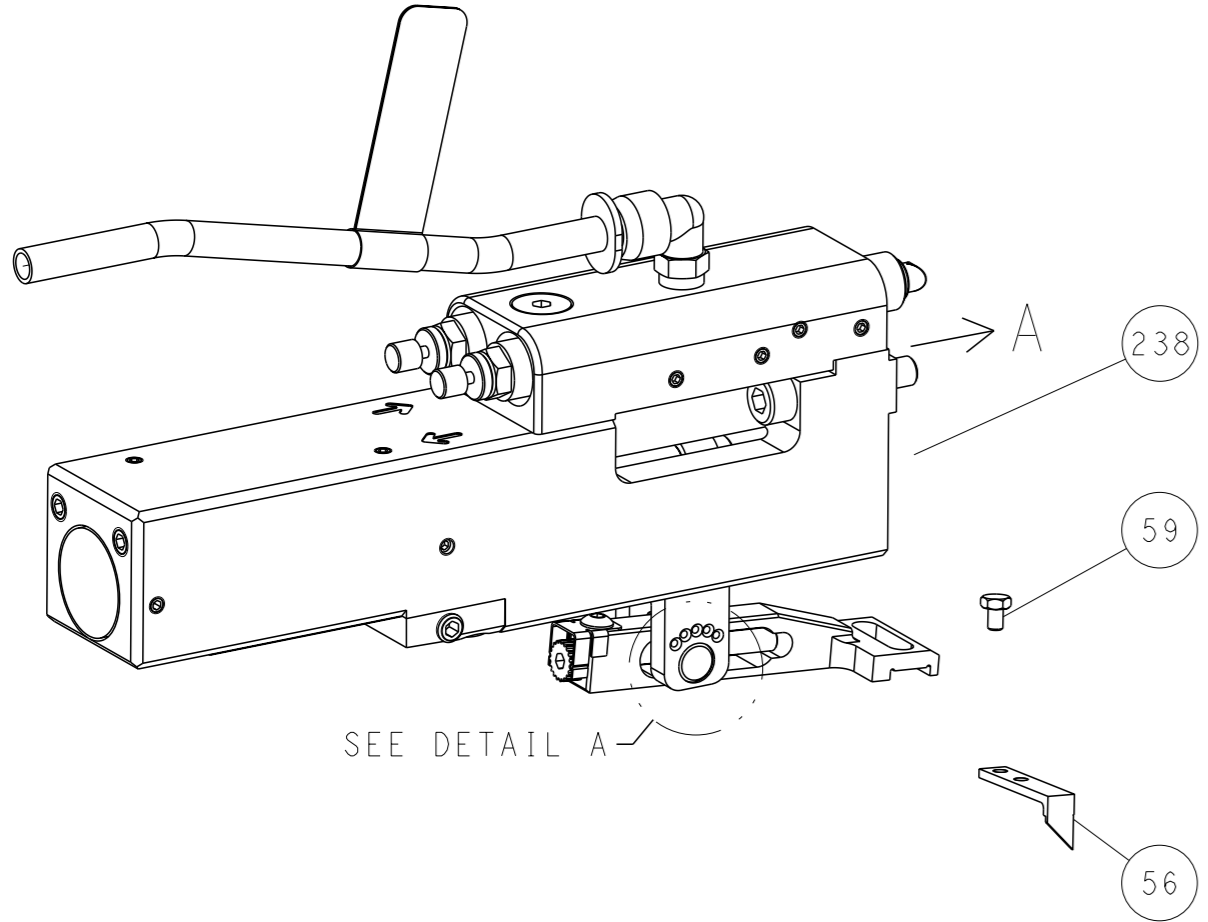
-	-	1	-	-	1803515-3	RAM ASSEMBLY, SF ATLANTIC	293
-	-	1	-	-	2-1803583-1	APPLICATOR BASIC ASSEMBLY, SF	292
-	-	-	1	-	2844950-1	AIR FEED MODULE	290
-	1	1	1	1	2-1722335-1	THREAD BOLT GEWINDEBOLZEN	261
-	1	1	-	1	2119641-1	FEED CAM, AIR FEED	248
-	1	1	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
-	1	1	-	1	2844940-1	AIR FEED MODULE	238
-	-	1	-	-	4-1722335-3	STRIPPER, SIDE FEED	182
-	-	1	-	-	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	181
³	-	-	1	-	1-1752354-3	STANDOFF, HOLD-DOWN	180
-	-	1	-	-	993111-1	PIN, SLOTTED SPRING 3.0 X 20.0	177
-	-	1	-	-	5-22280-0	SPRING, COMPRESSION	176
-	-	1	-	-	1752353-3	GUIDE PIN, HOLDDOWN	175
-	-	1	-	-	1901680-2	GUIDE PIN, HOLDDOWN	174
-	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	1	1	1	1	1-22281-8	SPRING, COMPRESSION	121
⁷	-	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	1-690438-0	FRONT STRIP GUIDE	96
-	2	2	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	95
-	1	1	1	1	2168083-6	SCR, SKT HD CAP, RoHS, M5 X 65	93
-	1	1	1	1	1-455888-1	SPACER, CRIMPER	82
-	1	1	1	1	1803607-3	DOCUMENTATION PACKAGE	71
-	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	2-18032-5	SCR, SET, FLT PNT, M5 X 20.0	61
-	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	1338685-1	PAWL, FEED	56
-	4	4	4	4	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	54
-	1	1	-	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	1	-	1	1	1803583-9	APPLICATOR BASIC ASSEMBLY, SF	46
-	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	7-1752356-1	SUPPORT, TERMINAL	34
-	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	2	2	2-2844962-3	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	1	1	3-2844938-5	PLATE, STRIP GUIDE	29
-	1	1	1	1	455888-8	SPACER, CRIMPER	28
-	2	2	2	2	22283-1	SPRING, COMPRESSION	27
-	1	1	1	1	356835-1	LEVER, DRAG RELEASE	26
-	1	1	1	1	1803142-1	DRAG, TERMINAL	25
-	1	1	1	1	1320928-2	STRIP GUIDE	24
-	1	1	1	1	980371-4	SCR, SKT HD SHLDR 5.0 DIA X 6.0	23
-	1	-	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
-	2	1	2	2	1-18028-2	WASHER, FLAT, REG M4	20
-	1	-	1	1	2119533-5	STRIPPER, SIDE FEED	19
¹	-	1	1	1	2119806-1	INSERT, SHEAR	13
-	1	1	1	1	3-22280-3	SPRING, COMPRESSION	12
-	1	1	1	1	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	11
-	1	1	1	1	2119805-1	SHEAR HOLDER, FRONT	10
¹	-	1	1	1	1803095-1	FLOATING SHEAR, FRONT	9
¹	1	2	1	1	1-1633933-0	ANVIL, COMBINATION	8
-	-	-	-	-	-	-	7
-	-	-	-	-	-	-	6
-	1	1	1	1	2119757-4	DEPRESSOR, SHEAR	5
-	-	-	-	-	-	-	4
-	-	-	-	-	-	-	3
-	-	-	-	-	-	-	2
¹	1	2	1	1	1-1803125-5	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:	OWN	CHK	DATE	NAME	SCALE	SHEET	OF	REV
mm	0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±	M. HERR	G. BAILEY	07APR2016	TE Connectivity Harrisburg, PA 17105-3608	1:2	1	4	E
MATERIAL:	FINISH:	APVD	PRODUCT SPEC	APPLICATION SPEC	Customer Accessible Production Drawing	00779	2836263		

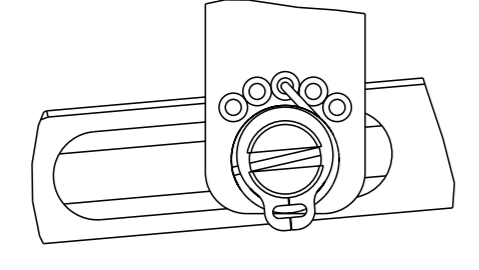
LOC	DIST	REV	DESCRIPTION	DATE	OWN	APVD
A	66		SEE SHEET 1			

FEED TYPE PNEUMATIC



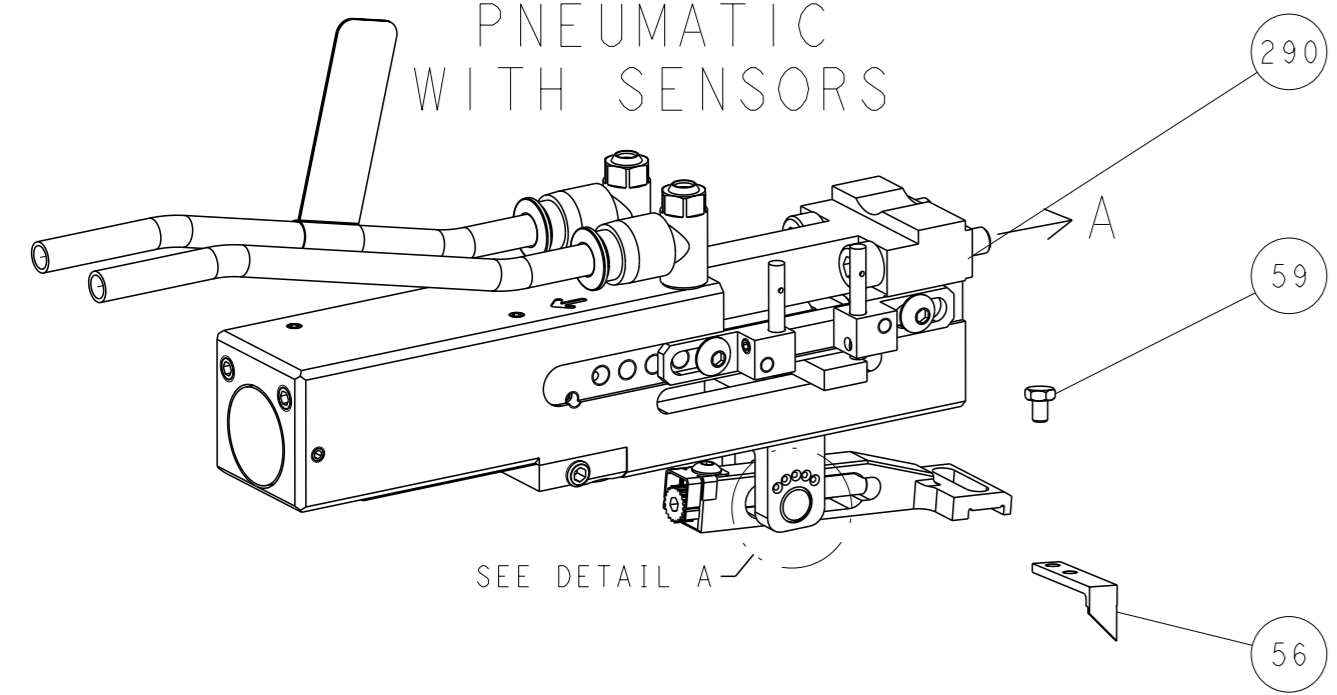
SEE DETAIL A

FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



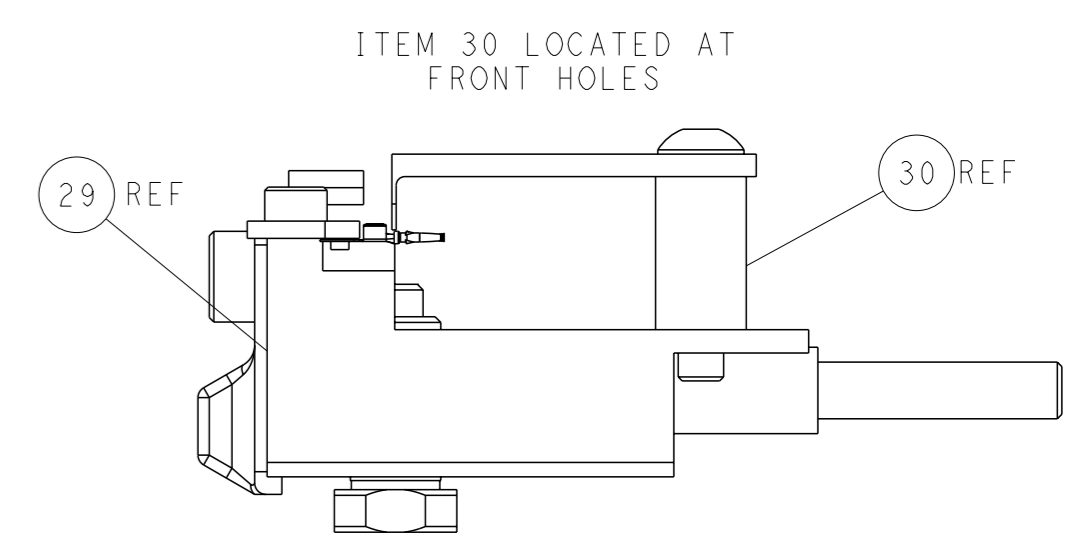
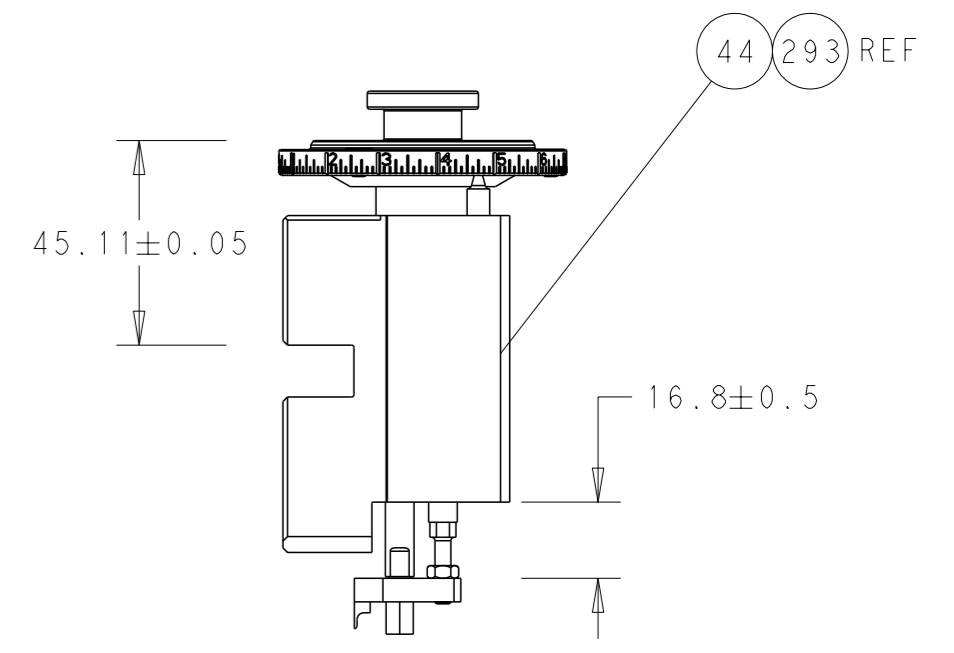
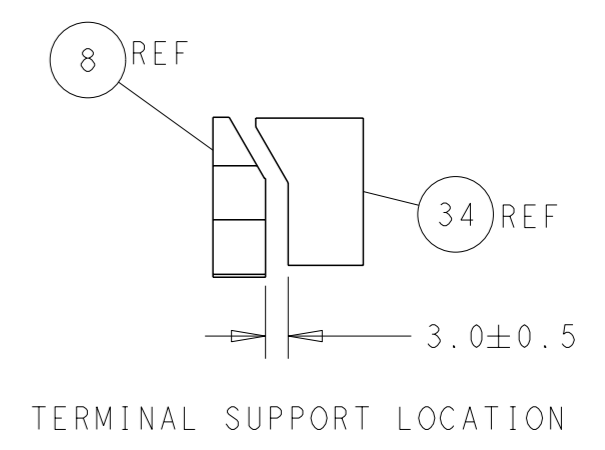
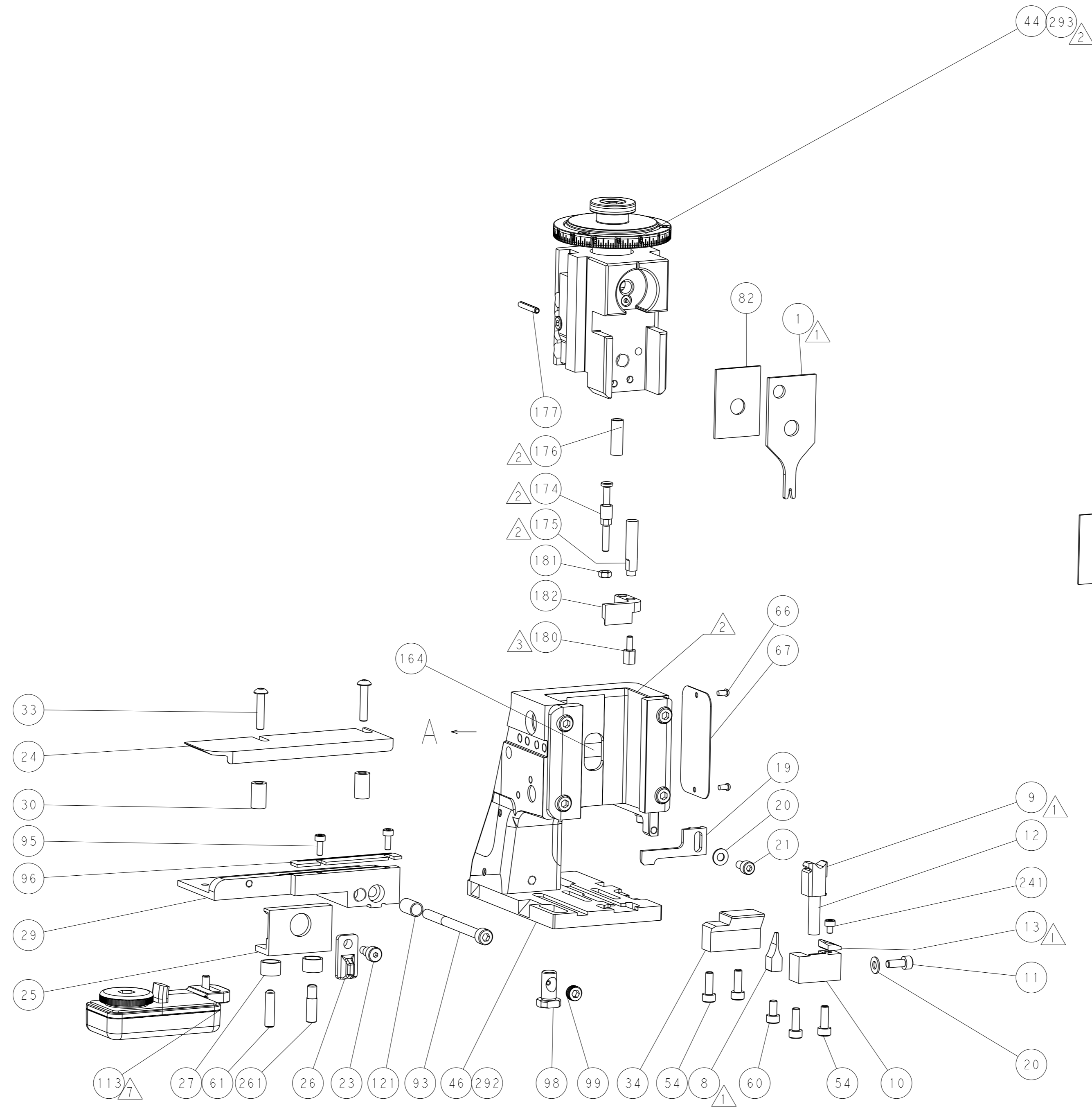
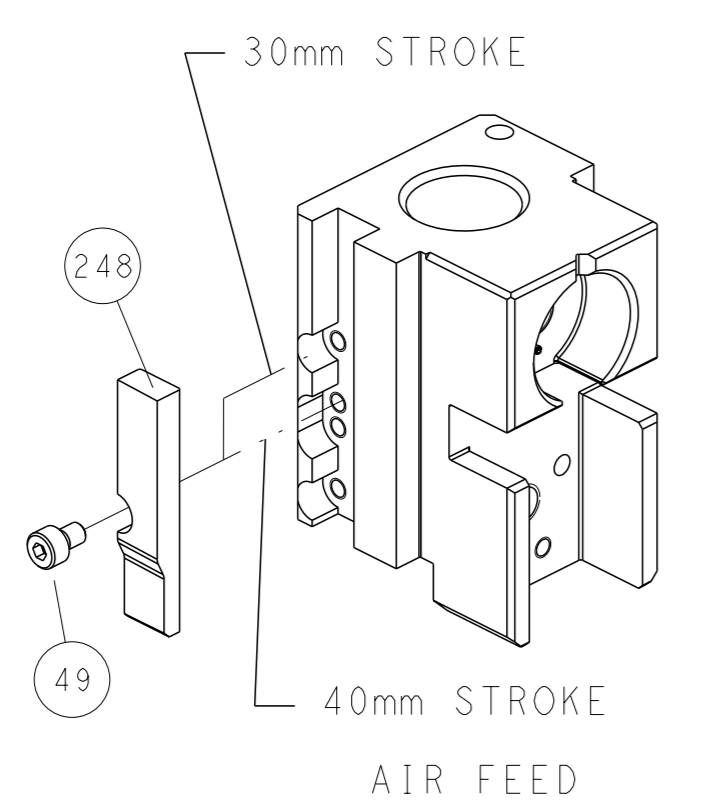
DETAIL A

DOUBLE ACTING PNEUMATIC WITH SENSORS



SEE DETAIL A

CAM POSITIONS

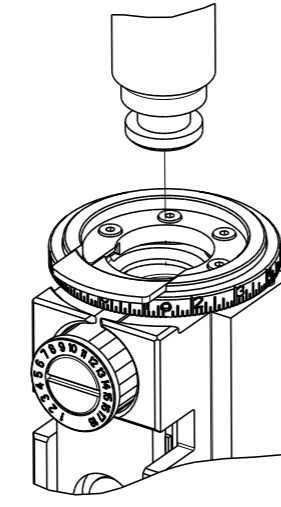


ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH ±		OWN M_HERR 07APR2016 CHK M_HERR 08APR2016 APVD M_HERR 08APR2016 PRODUCT SPEC APPLICATION SPEC WEIGHT Customer Accessible Production Drawing		NAME Ocean Side Feed Applicator SIZE CAGE CODE DRAWING NO. A1 00779 C=2836263 SCALE 1:2 SHEET 2 OF 4 REV E		TE Connectivity Harrisburg, PA 17105-3608	
--------------------	--	--	--	---	--	--	--	--	--

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2836263-2	D	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
4-2836263-2	D	FINE CRIMP HEIGHT ADJUST	DOUBLE ACTING PNEUMATIC WITH SENSORS ⁶
7-2836263-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.17 mm (.046)	F
INSUL	-	-
APPLICATOR INSTRUCTIONS 408-10389		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: CENTER CONTACT, SOCKET, 180 DEG MINI COAX			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
2.35-2.65 mm [.093-.104 IN]		∅	
TERMINAL APPLICATION SPECIFICATION		114-94413	-
TERMINALS APPLIED ⁴ ⁵			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
2298121-1			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING ³
RTK031	0.69+/-0.03 [.027+/- .001]	5.7



- ¹ RECOMMENDED SPARE PARTS
 - ² REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
 - ³ 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.
 - ⁴ TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
 - ⁵ THIS APPLICATOR IS EQUIPPED WITH THE DOUBLE ACTING FEED WITH SENSORS AND IS APPLICATION SPECIFIC AND DOES NOT REQUIRE ITEMS 49 & 151.
 - ⁶ 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.

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

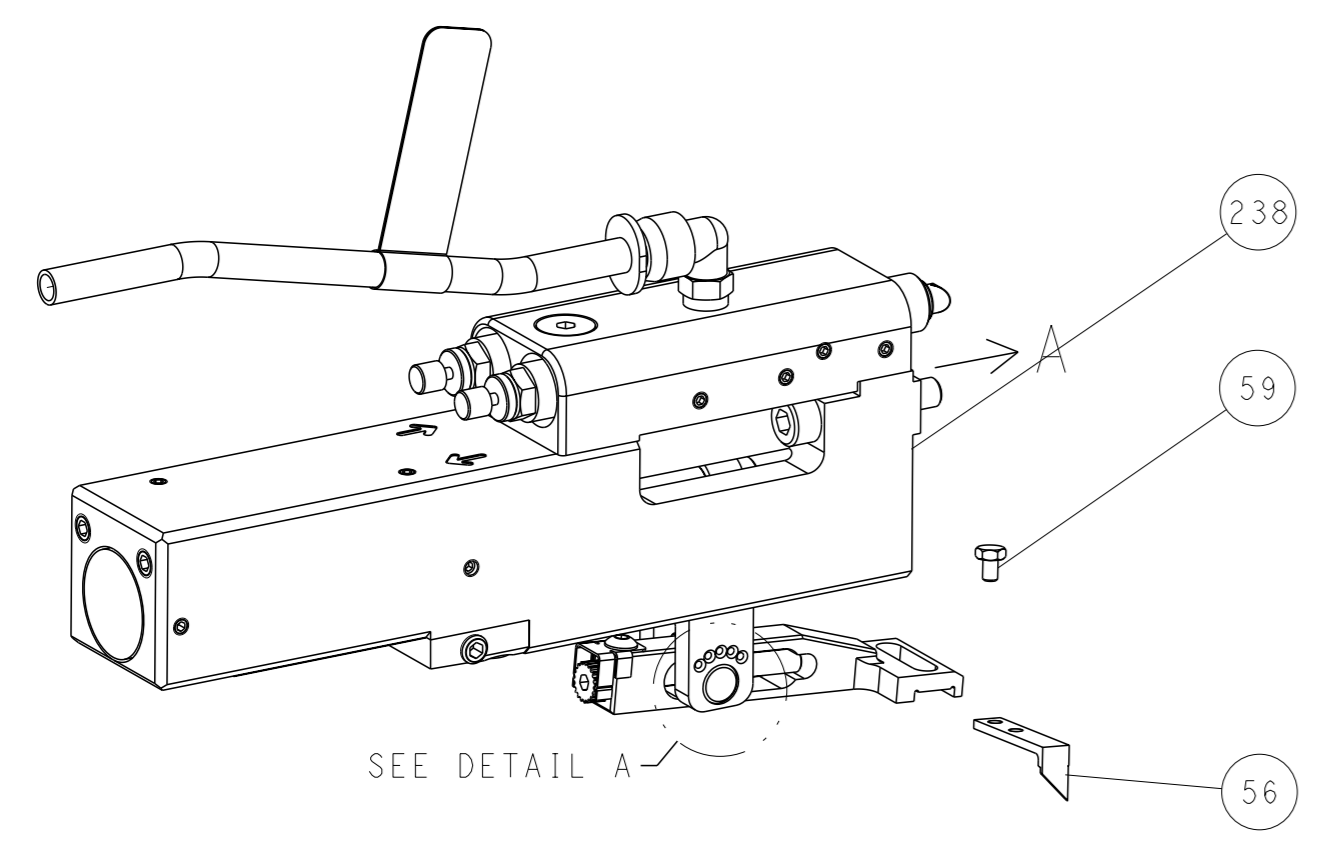
-	1	-	2844950-1	AIR FEED MODULE	290
-	1	1	2-1722335-1	THREAD BOLT GEWINDEBOLZEN	261
-	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
-	-	1	2844940-1	AIR FEED MODULE	238
-	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	-	1	2119641-2	FEED CAM, AIR FEED	151
-	1	1	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	144
-	4	4	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	143
-	1	1	1-1803583-0	APPLICATOR BASIC ASSEMBLY, SF	141
-	1	1	1803516-1	RAM ASSEMBLY, SF PACIFIC	140
-	1	1	1-22281-8	SPRING, COMPRESSION	121
-	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	1-690438-0	FRONT STRIP GUIDE	96
-	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	95
-	1	1	2168083-6	SCR, SKT HD CAP, RoHS, M5 X 65	93
-	1	1	1-455888-1	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	2-18032-5	SCR, SET, FLT PNT, M5 X 20.0	61
-	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	1	1	1338685-1	PAWL, FEED	56
-	-	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
-	1	1	7-1752356-1	SUPPORT, TERMINAL	34
-	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	2-2844962-3	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	3-2844938-5	PLATE, STRIP GUIDE	29
-	1	1	455888-8	SPACER, CRIMPER	28
-	2	2	22283-1	SPRING, COMPRESSION	27
-	1	1	356835-1	LEVER, DRAG RELEASE	26
-	1	1	1803142-1	DRAG, TERMINAL	25
-	1	1	1320928-2	STRIP GUIDE	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
-	2	2	1-18028-2	WASHER, FLAT, REG M4	20
-	1	1	2119533-5	STRIPPER, SIDE FEED	19
-	1	1	2119806-1	INSERT, SHEAR	13
-	1	1	3-22280-3	SPRING, COMPRESSION	12
-	1	1	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	11
-	1	1	2119805-1	SHEAR HOLDER, FRONT	10
-	1	1	1803095-1	FLOATING SHEAR, FRONT	9
-	1	1	1-1633933-0	ANVIL, COMBINATION	8
-	-	-	-	-	7
-	-	-	-	-	6
-	1	1	2119757-4	DEPRESSOR, SHEAR	5
-	-	-	-	-	4
-	-	-	-	-	3
-	-	-	-	-	2
-	1	1	1-1803125-5	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)

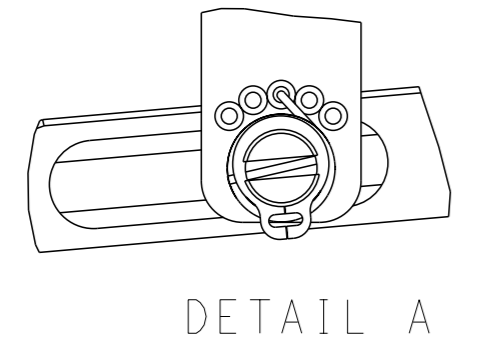
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		OWN	CHK	APVD	DATE	DESCRIPTION	ITEM NO
mm	0 PLC ±	1 PLC ±	2 PLC ±	M	M	M	07APR2016	TE Connectivity	
	3 PLC ±	4 PLC ±	ANGLES FINISH	M	M	M	08APR2016	Harrisburg, PA 17105-3608	
								Ocean Side Feed Applicator	
								Customer Accessible Production Drawing	
								SCALE 1:2 SHEET 3 of 4 REV E	

LOC	DIST	REVISIONS			
A	66	REV	DATE	OWN	APVD
		-	SEE SHEET 1	-	-

FEED TYPE PNEUMATIC

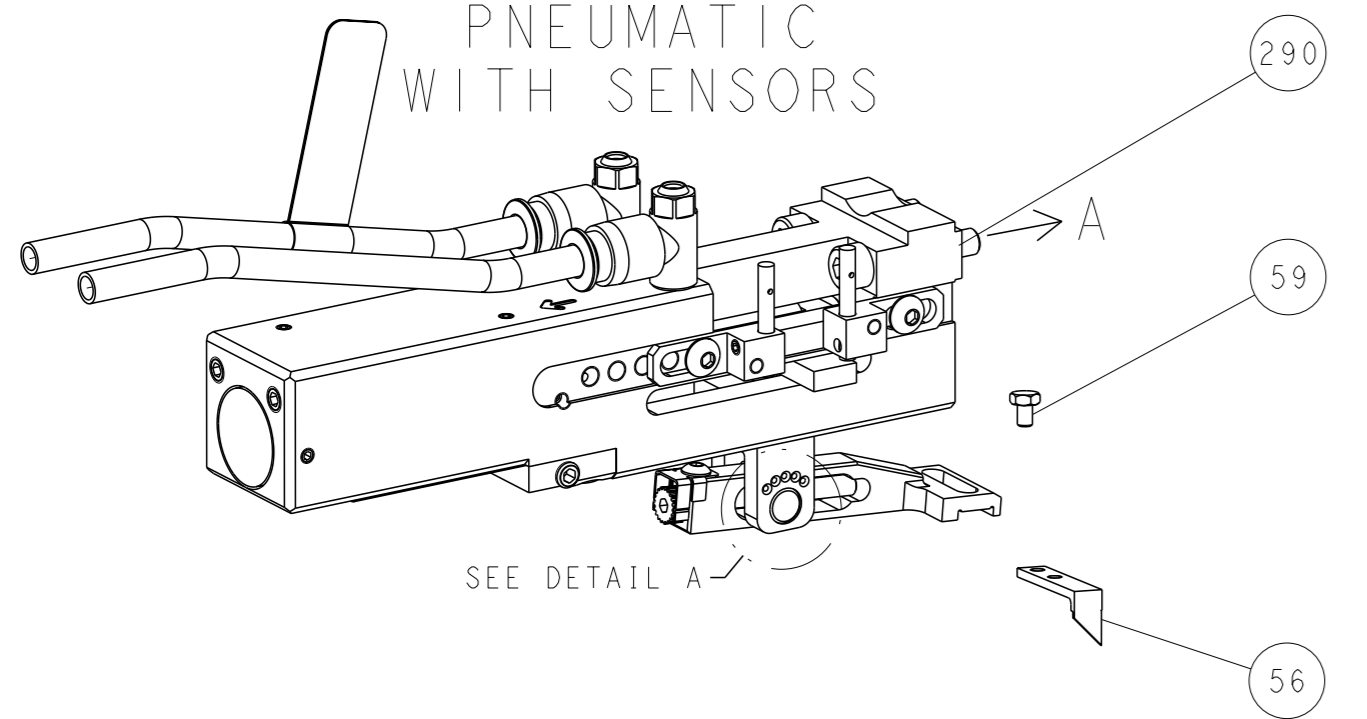


FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



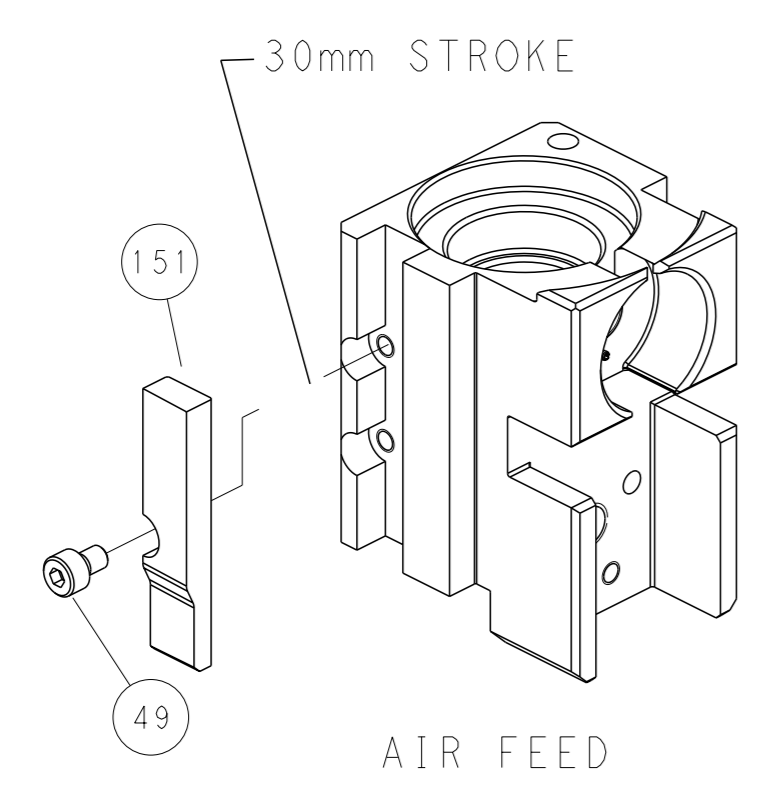
DETAIL A

DOUBLE ACTING PNEUMATIC WITH SENSORS

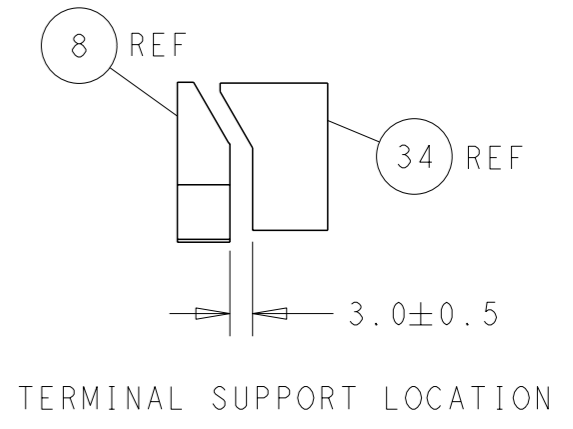
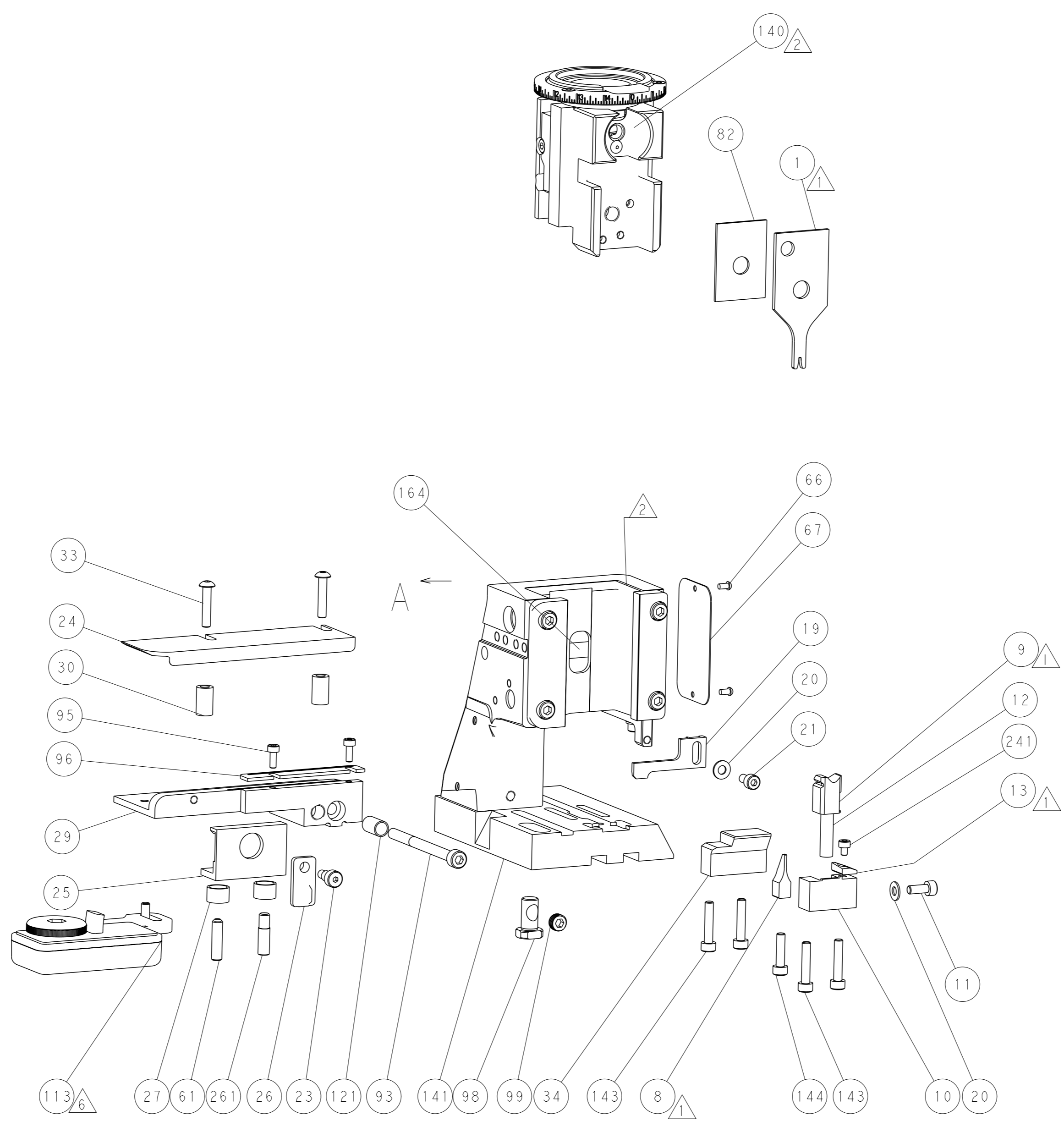


SEE DETAIL A

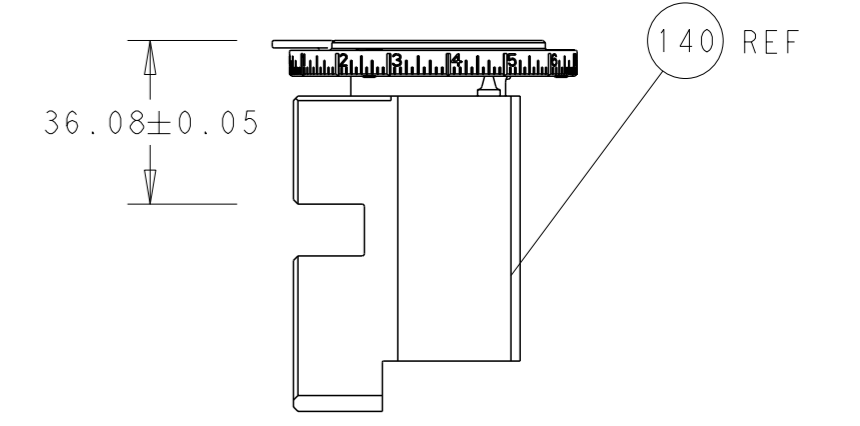
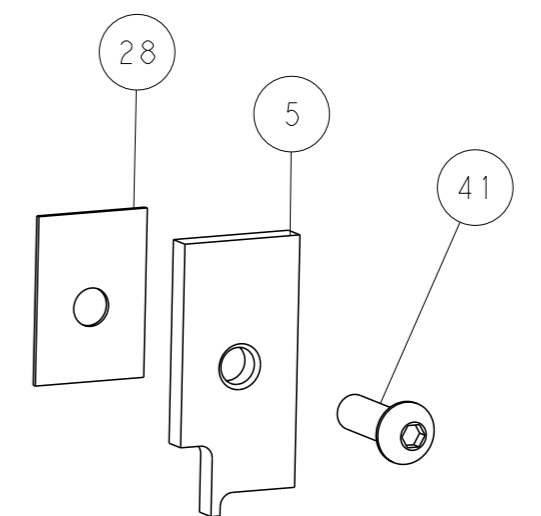
CAM POSITIONS



AIR FEED

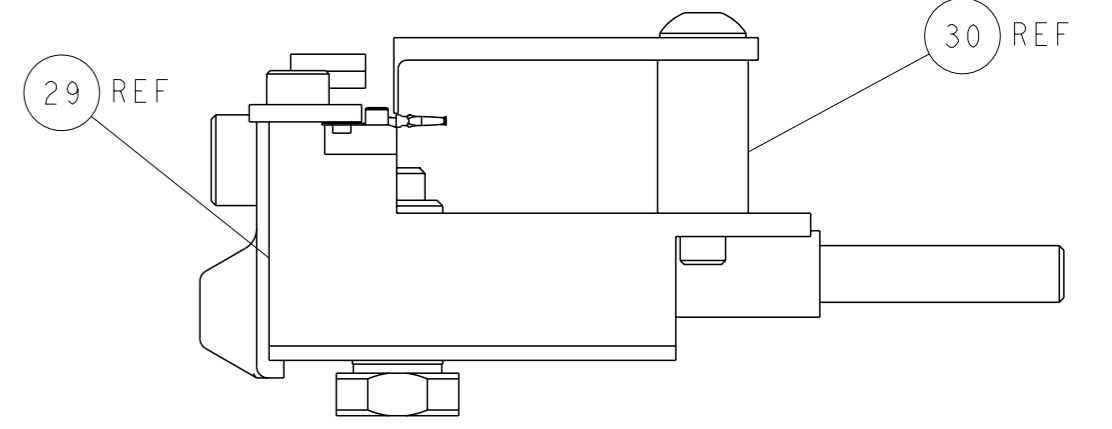


TERMINAL SUPPORT LOCATION



RAM SET-UP

ITEM 30 LOCATED AT FRONT HOLES



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 CONTROLLER'S ENGINEERING DEPARTMENT SHOULD BE CONTACTED FOR THE LATEST REVISION.</small>		OWN: M. HERR CHK: M. HERR APVD: M. HERR DATE: 07APR2016 PRODUCT SPEC: 08APR2016	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 APPLICATION SPEC: - SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2836263 WEIGHT: - SCALE: 1:2	RESTRICTED TO: - SHEET: 4 of 4 REV: E
MATERIAL: - FINISH: -		Customer Accessible Production Drawing	

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[9-22280-9](#) [986096-2](#) [992438-3](#) [1-21000-3](#) [1-21000-1](#) [1-25022-4](#) [1302263353](#) [1302263355](#) [1302261057](#) [1302261101](#) [1302261206](#)
[1302261560](#) [1302263123](#) [1302264036](#) [1424264-1](#) [1424267-1](#) [1428211-1](#) [1428287-1](#) [1-455755-6](#) [1752744-1](#) [18023-9](#) [189763-1](#) [1901726-1](#)
[2079747-1](#) [21001-2](#) [2119083-1](#) [2119085-1](#) [2119371-1](#) [2161930-1](#) [2217088-2](#) [2217339-1](#) [22281-9](#) [22374-7](#) [284565-000](#) [F1 Handle Spring](#)
[19228-0213](#) [2030790-2](#)