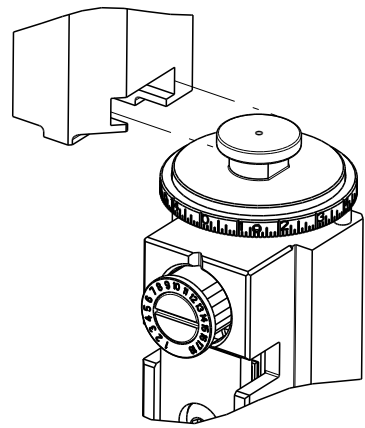


8		7	
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2016		2016	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2836489-2	G	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2836489-2	G	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2836489-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	0.89 mm [.035]	F
INSUL	0.89 mm [.035]	F
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: HIROSE TERMINAL		HIROSE CRIMP SPECIFICATION	
TERMINAL NAME: TERMINAL			
WIRE STRIP LENGTH 1.30-1.70 mm [.051-.067 IN]			INSULATION DIAMETER RANGE Ø0.42-0.58 mm [.017-.023 IN]
TERMINAL APPLICATION SPECIFICATION		DF59M-3032PCF Rev 2016/4/18	
		-	
-		-	
TERMINALS APPLIED			
 			
TE TERMINAL 2303687-1	HIROSE TERMINAL DF59M-3032PCF	TE TERMINAL	HIROSE TERMINAL

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
30 AWG	0.47+/-0.03 [.019+/- .001]	8.8
32 AWG	0.43+/-0.03 [.017+/- .001]	9.1



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. 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)

2			1						
LOC	DIST	REVISIONS							
A	66	P	LTR	DESCRIPTION			DATE	DWN	APVD
		D		ECR-21-125497			30DEC2021	JWC	TE
		E		ECR-22-127989			28JAN2022	FJ	TE
		F		ECR-22-158699			17NOV2022	JWC	GB
		G		ECR-23-168602			08MAR2023	ROY	TLE

-	1	1	1-1803945-4	TONKER	300
-	1	1	22278-9	SPRING, COMPRESSION	299
-	2	2	4-18032-3	SCR, SET, FLT PNT, M3 X 6.0	298
-	1	1	1803944-1	SPACER, TONKER	297
-	1	1	1803078-3	SPACER, PRECISION	259
-	1	1	2119641-1	FEED CAM, AIR FEED	248
-	1	1	2119082-1	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	455888-3	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	1338685-1	PAWL, FEED	56
-	4	4	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	54
-	2	2	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	53
-	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	9-1752356-5	SUPPORT, TERMINAL	34
-	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	2-2844962-2	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29
-	1	1	455888-5	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	1803213-1	STRIPPER	19
-	1	1	2119806-1	INSERT, SHEAR	13
-	1	1	3-22280-3	SPRING, COMPRESSION	12
-	1	1	1-356885-5	STOP, SHEAR	11
-	1	1	2119805-1	SHEAR HOLDER, FRONT	10
-	1	1	1803095-6	FLOATING SHEAR, FRONT	9
1	2	1	4-1803252-0	ANVIL, COMBINATION	8
-	-	-	-	-	7
-	-	-	-	-	6
-	1	1	2-2119757-4	DEPRESSOR, SHEAR	5
-	1	1	2-238011-0	BLOCK, CRIMPER SPACER	4
1	2	1	2-1803223-3	CRIMPER, INSULATION F PREMIUM	3
-	1	1	455888-1	SPACER, CRIMPER	2
1	2	1	7-1633860-7	CRIMPER, WIRE	1

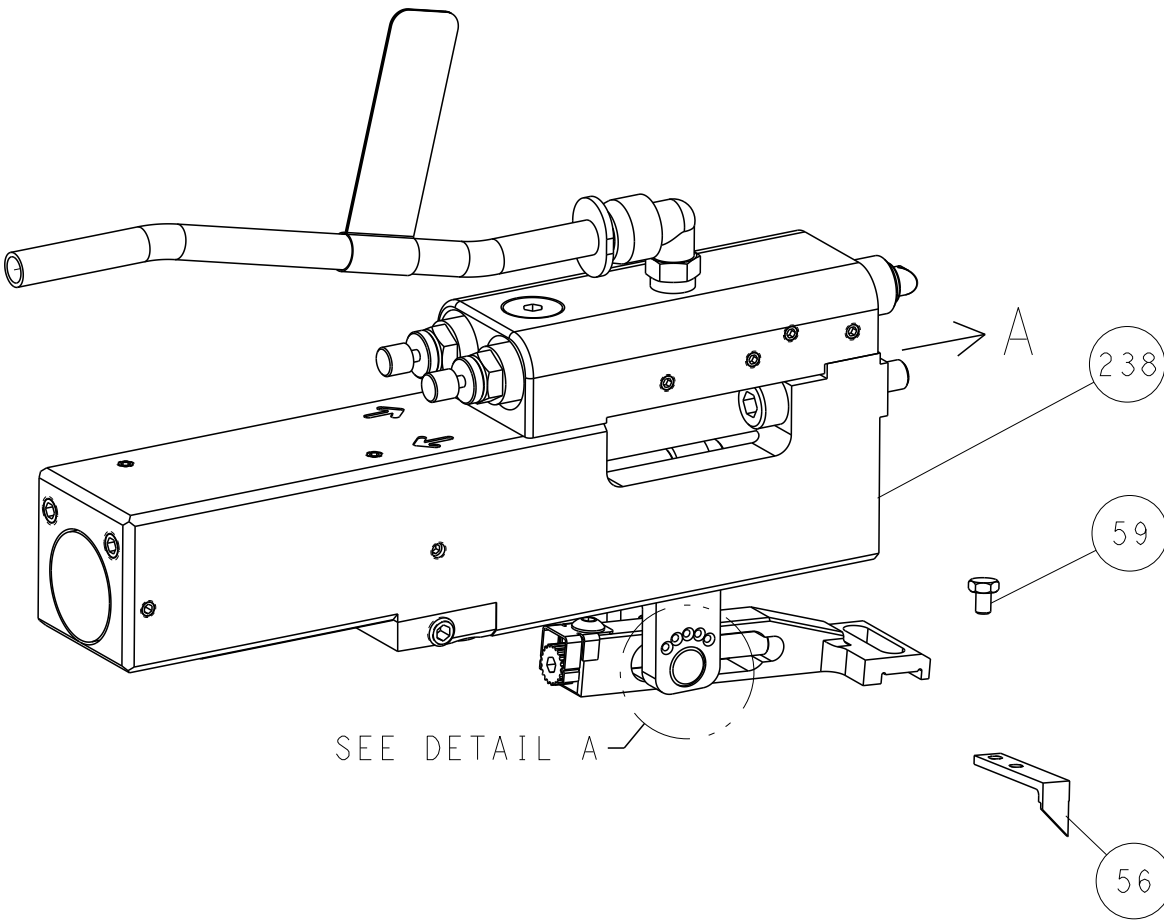
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DWN B. WEAVER		24OCT2016	 TE Connectivity Harrisburg, PA 17105-3608		-
CHK T. ELBIN		24OCT2016			
APVD T. ELBIN		24OCT2016			
PRODUCT SPEC					
APPLICATION SPEC			Ocean Side Feed Applicator		
SIZE		CAGE CODE	DRAWING NO	RESTRICTED TO	
A		00779	©=2836489	-	
Customer Accessible Production Drawing		SCALE	1:2	SHEET	1 OF 4
				REV	G

SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

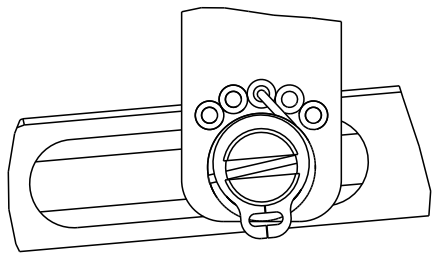
LOC	DIST	REVISIONS					
		P	LTR	DESCRIPTION	DATE	DWN	APVD
A	66	-	-	SEE SHEET 1	-	-	-

FEED TYPE

PNEUMATIC

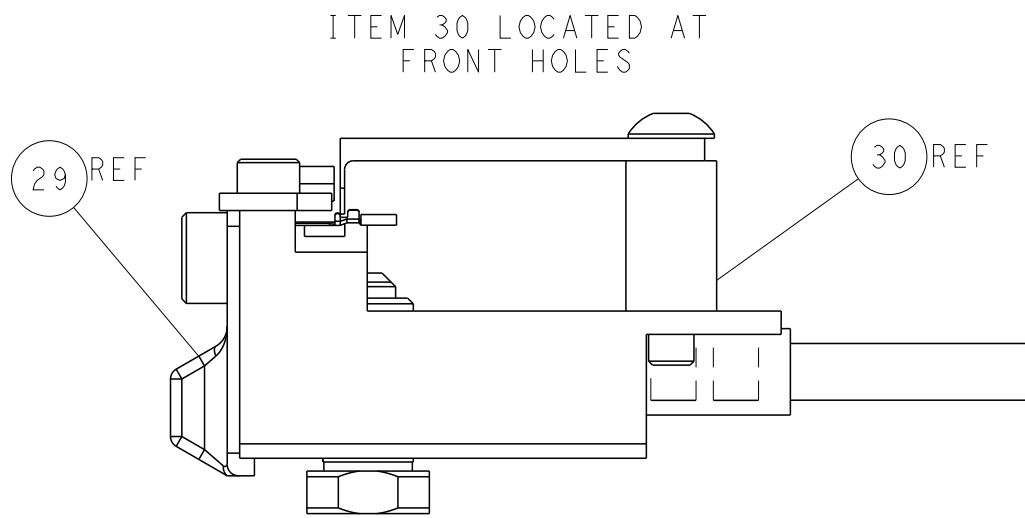
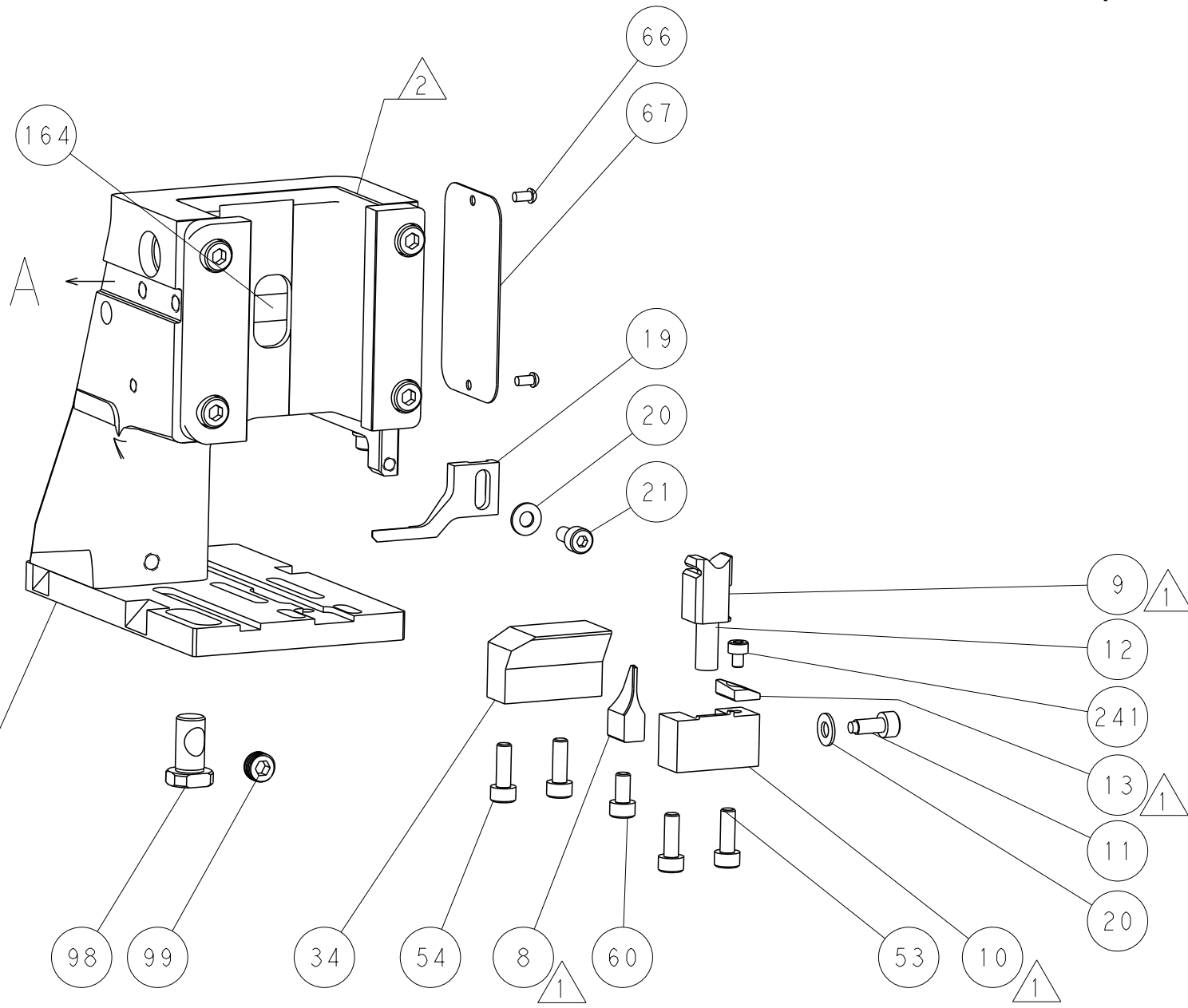
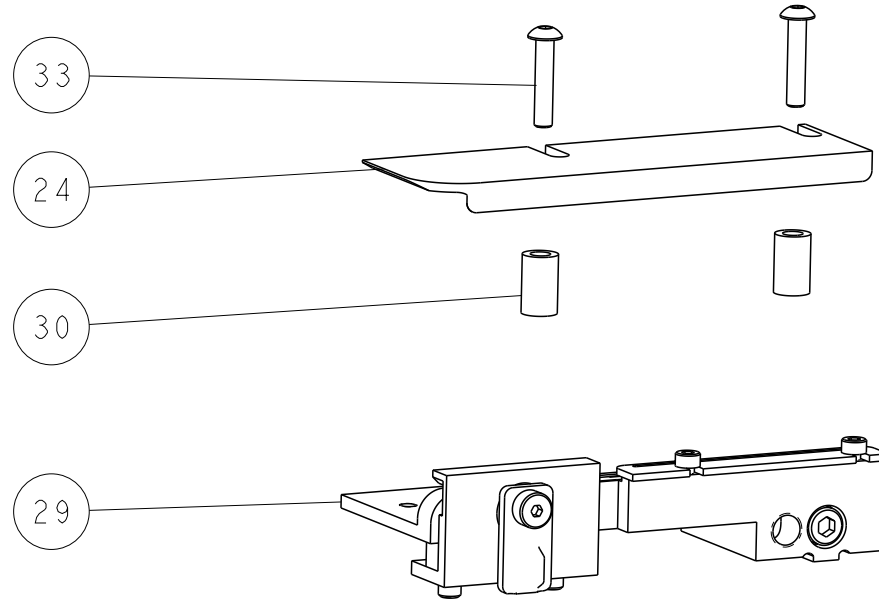
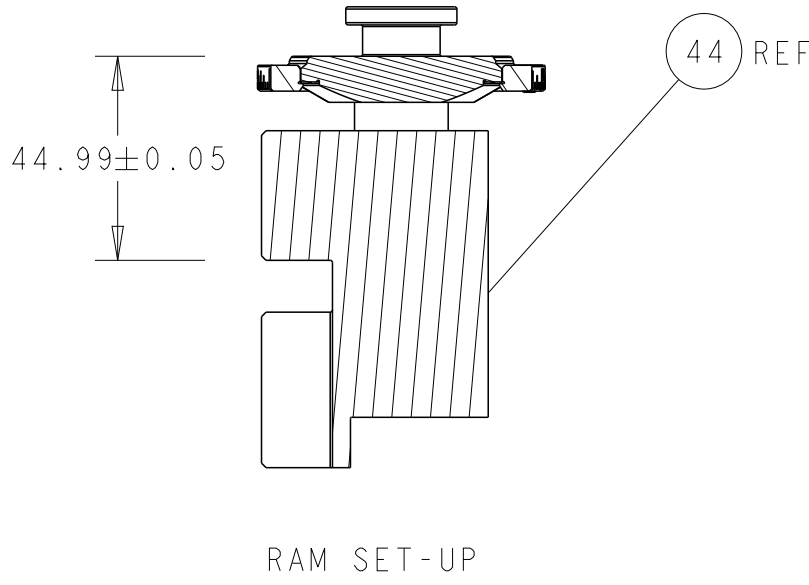
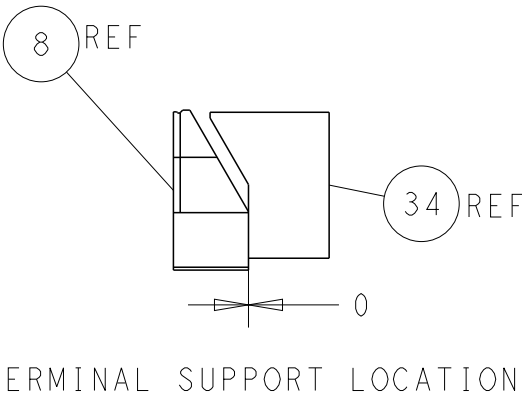
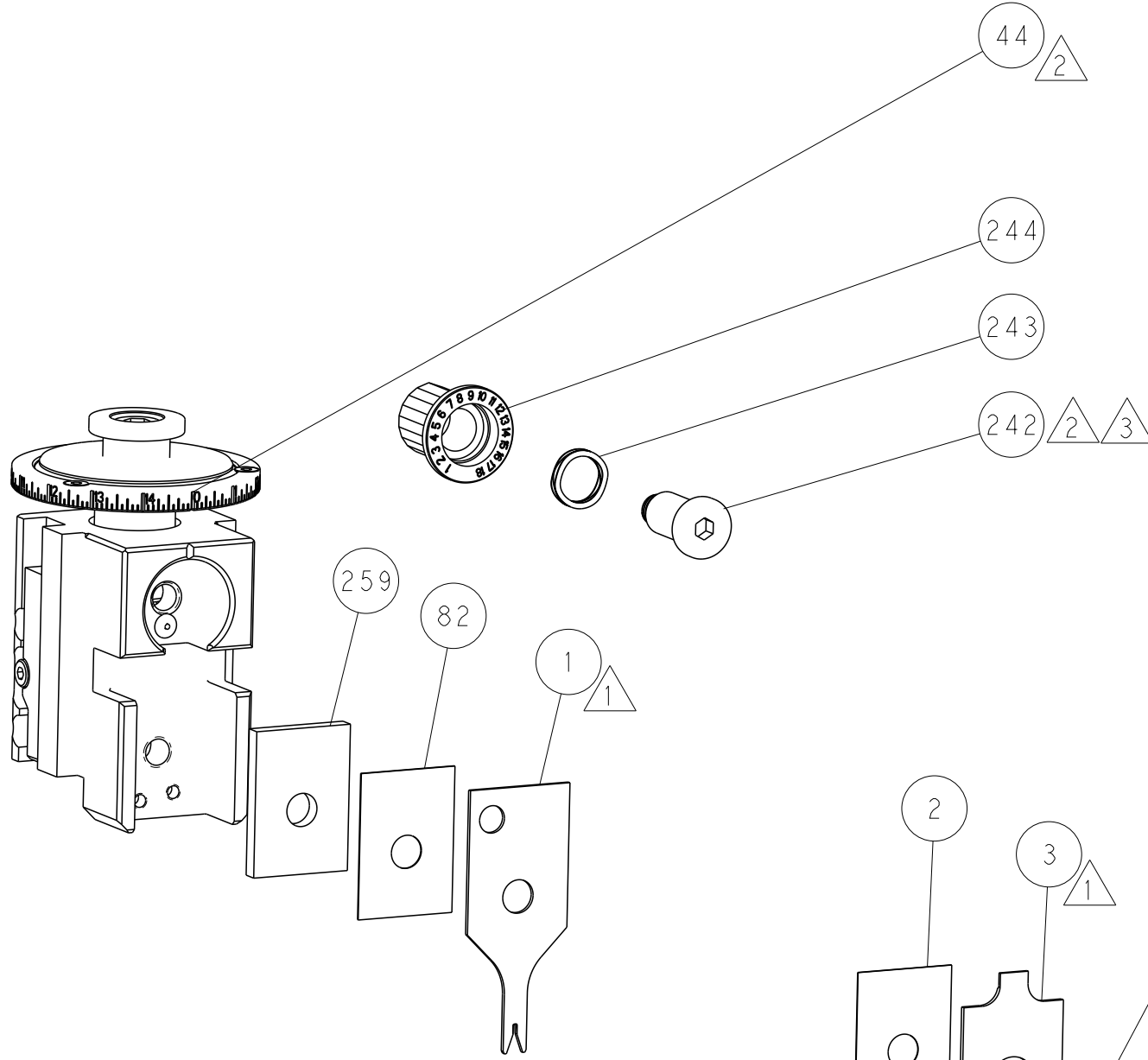
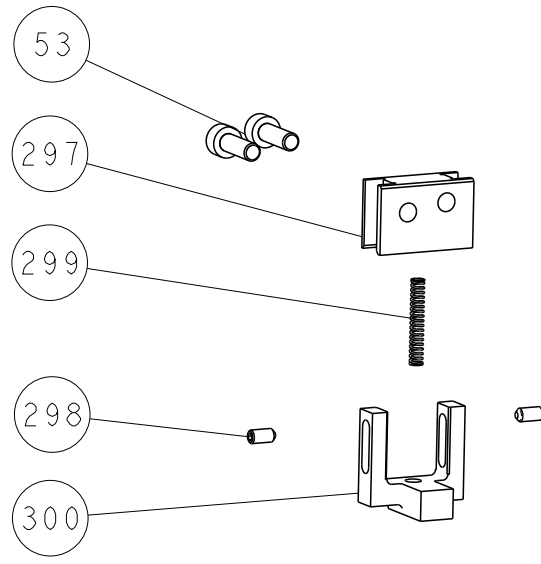
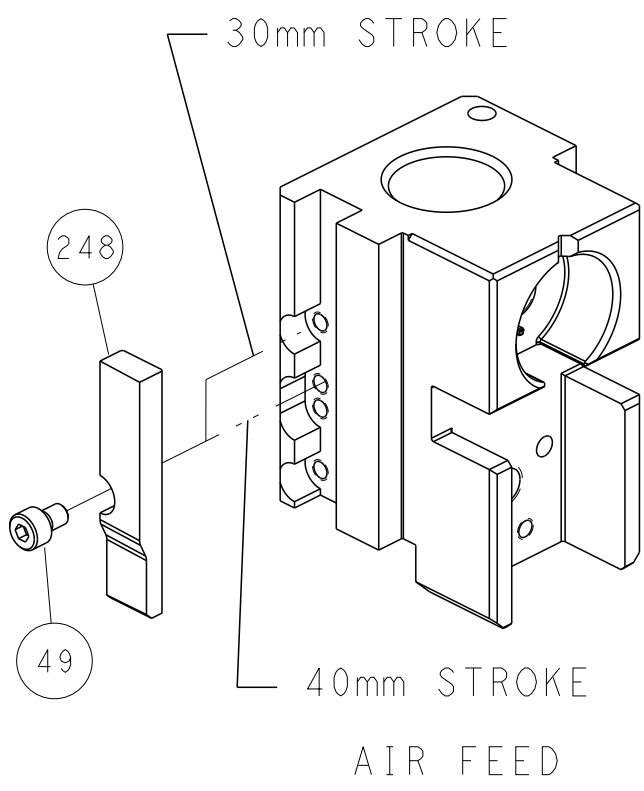


FEED SPRING SETTING POSITION
(SHOWN FROM REAR SIDE)



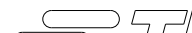
DETAIL A

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)

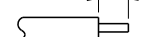
THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION IT IS LOANED TO YOUR COMPANY FOR YOUR COMPANY'S USE ONLY. IT IS NOT TO BE REPRODUCED OR COPIED IN ANY MANNER WITHOUT THE WRITTEN PERMISSION OF TYCO ELECTRONICS CORPORATION. SHOULD BE CONTACTED FOR THE LATEST EDITION.				DWN B. WEAVER	24OCT2016	 TE Connectivity Harrisburg, PA 17105-3608	NAME Ocean Side Feed Applicator	
				CHK T. ELBIN	24OCT2016			
				APVD T. ELBIN	24OCT2016			
				PRODUCT SPEC				
DIMENSIONS:				TOLERANCES UNLESS OTHERWISE SPECIFIED:		APPLICATION SPEC		
mm				0 PLC ±.01		SIZE		
				1 PLC ±.01		CAGE CODE		
				2 PLC ±.01		DRAWING NO		
				3 PLC ±.01		RESTRICTED TO		
				4 PLC ±.01		A1 00779		
				ANGLES		C=2836489		
MATERIAL				FINISH		Customer Accessible Production Drawing		
						SCALE 1:2		
						SHEET 2 OF 4		
						REV G		

8	7
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PART NUMBER	REVISION
DESCRIPTION	FEED TYPE
2-2836489-2	G
FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2836489-7	A
CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	0.89 mm [.035]	F
INSUL	0.89 mm [.035]	F
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: HIROSE TERMINAL		HIROSE CRIMP SPECIFICATION	
TERMINAL NAME: TERMINAL			
WIRE STRIP LENGTH 1.30-1.70 mm [.051-.067 IN]		 INSULATION DIAMETER RANGE Ø0.42-0.58 mm [.017-.023 IN]	
TERMINAL APPLICATION SPECIFICATION  DF59M-3032PCF Rev 2016/4/18		-	
TERMINALS APPLIED  		-	
TE TERMINAL	HIROSE TERMINAL	TE TERMINAL	HIROSE TERMINAL
2303687-1	DF59M-3032PCF		

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING
30 AWG		0.47+/-0.03 [.019+/- .001]		8.8
32 AWG		0.43+/-0.03 [.017+/- .001]		9.1



- 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				
		P	LYR	DESCRIPTION	DATE	OWN
A	66	-	-	SEE SHEET 1	-	-

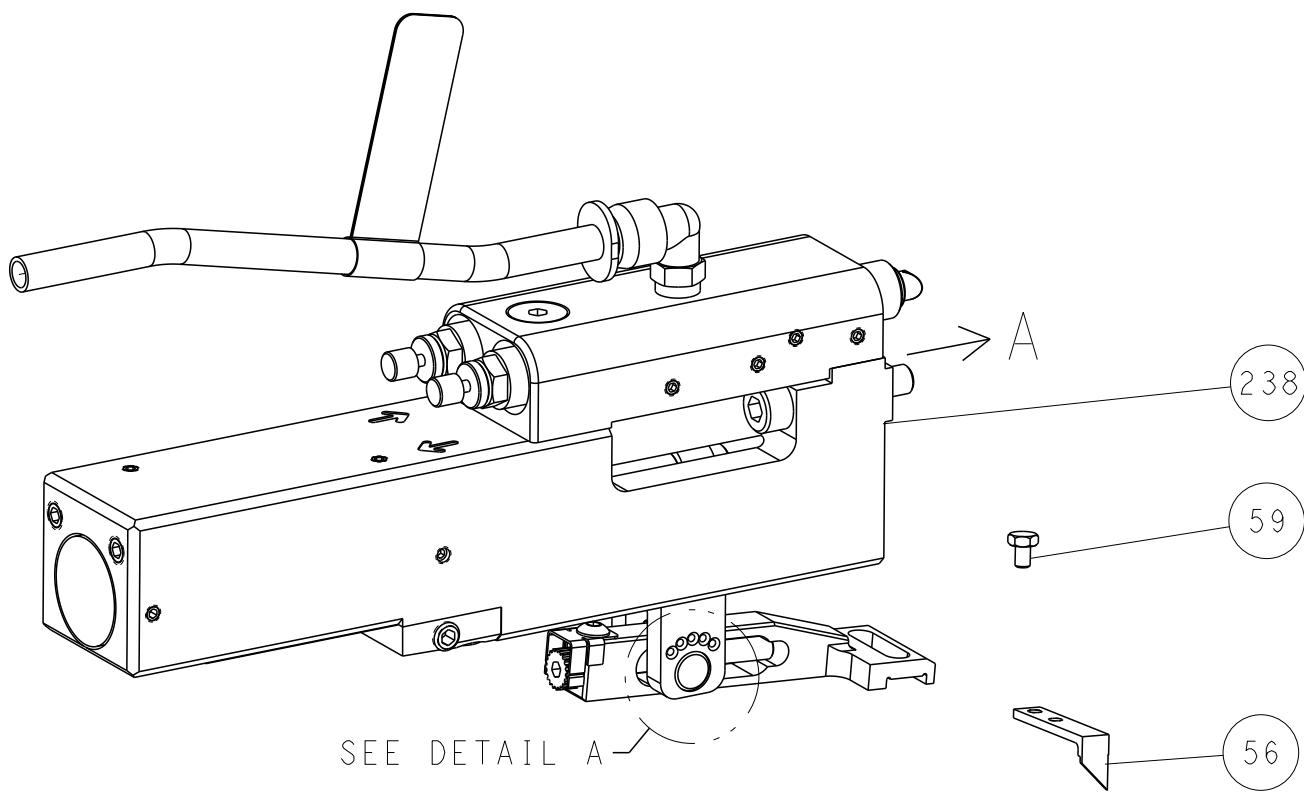
	-	1	1-1803945-4	TONKER	300
	-	1	22278-9	SPRING, COMPRESSION	299
	-	2	4-18032-3	SCR, SET, FLT PNT, M3 X 6.0	298
	-	1	1803944-1	SPACER, TONKER	297
	-	1	1803078-3	SPACER, PRECISION	259
	-	1	2119082-1	CAM, SNAIL, INSULATION ADJUSTMENT	244
	-	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
3	-	1	2119083-1	RETAINER, INSULATION DIAL	242
	-	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
	-	1	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
6	-	1	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113
	-	1	2844908-1	SCREW, LOCKING	99
	-	1	2844907-1	POST, LOCKING	98
	-	1	455888-3	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	1338685-1	PAWL, FEED	56
	-	2	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	53
	-	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49
	-	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
	-	1	9-1752356-5	SUPPORT, TERMINAL	34
	-	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
	-	2	2-2844962-2	SPACER, CYLINDRICAL, STRIP GUIDE	30
	-	1	2844992-1	ASSEMBLY, STRIP GUIDE	29
	-	1	455888-5	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	1803213-1	STRIPPER	19
1	-	1	2119806-1	INSERT, SHEAR	13
	-	1	3-22280-3	SPRING, COMPRESSION	12
	-	1	1-356885-5	STOP, SHEAR	11
1	-	1	2119805-1	SHEAR HOLDER, FRONT	10
1	-	1	1803095-6	FLOATING SHEAR, FRONT	9
1	-	1	4-1803252-0	ANVIL, COMBINATION	8
	-	-	-	-	7
	-	-	-	-	6
	-	1	2-2119757-4	DEPRESSOR, SHEAR	5
	-	1	2-238011-0	BLOCK, CRIMPER SPACER	4
1	-	1	2-1803223-3	CRIMPER, INSULATION F PREMIUM	3
	-	1	455888-1	SPACER, CRIMPER	2
1	-	1	7-1633860-7	CRIMPER, WIRE	1

THIS DRAWING IS A CONTROLLED DOCUMENT FOR THE CUSTOMER'S INFORMATION. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. THE CUSTOMER'S ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST EDITION.		OWN B. WEAVER 24OCT2016	TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm		CHK T. ELBIN 24OCT2016	NAME Ocean Side Feed Applicator	
		APVD T. ELBIN 24OCT2016	PRODUCT SPEC	
			APPLICATION SPEC	
MATERIAL -		WEIGHT -	SIZE A	CAGE CODE 00779
			DRAWING NO C=2836489	RESTRICTED TO -
		Customer Accessible Production Drawing		SCALE 1:2
		SHEET 3 OF 4		REV G

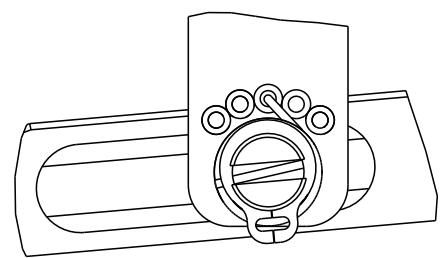
SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

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

FEED TYPE PNEUMATIC

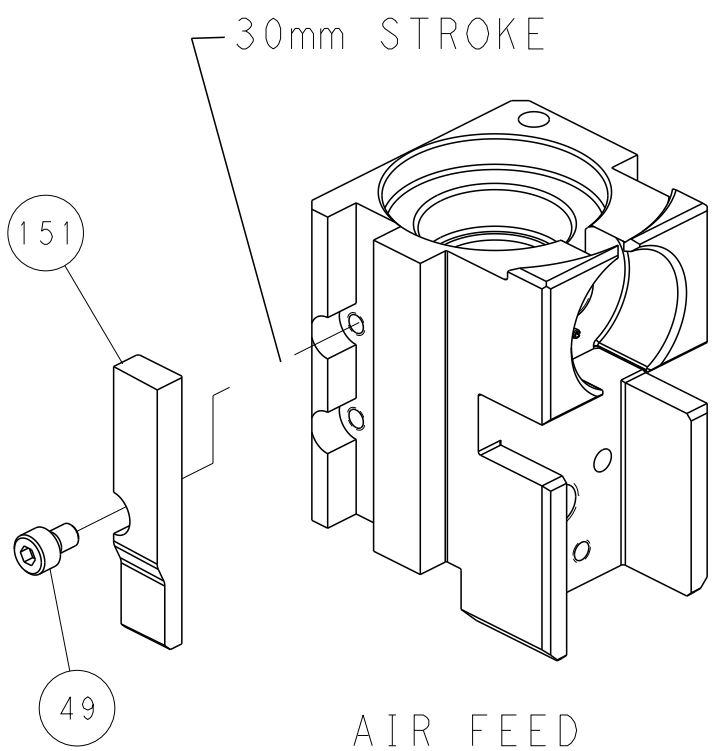


FEED SPRING SETTING POSITION
(SHOWN FROM REAR SIDE)

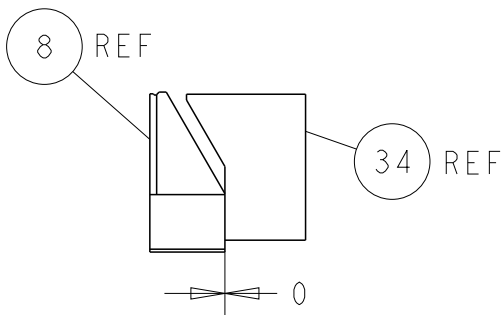
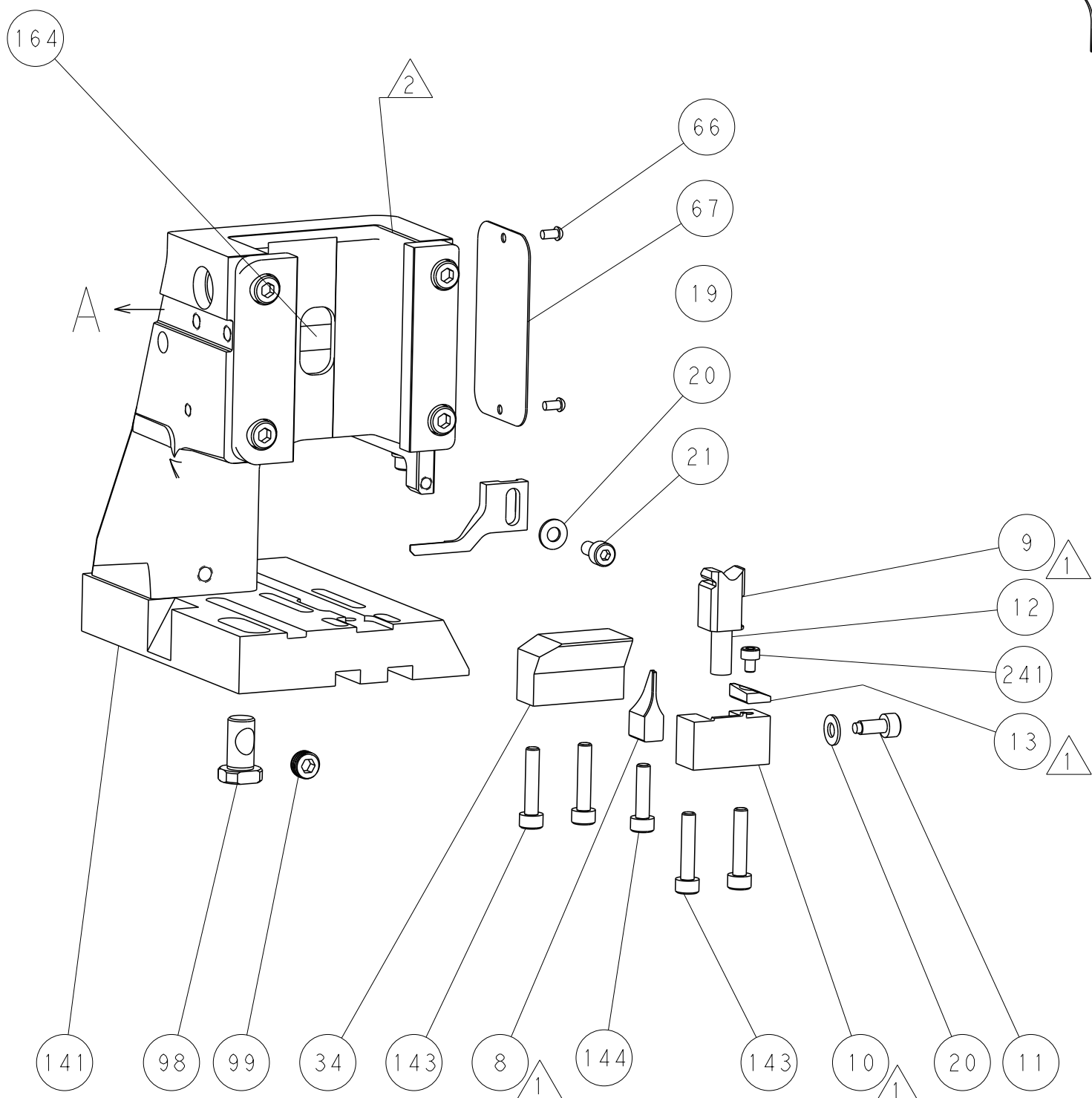
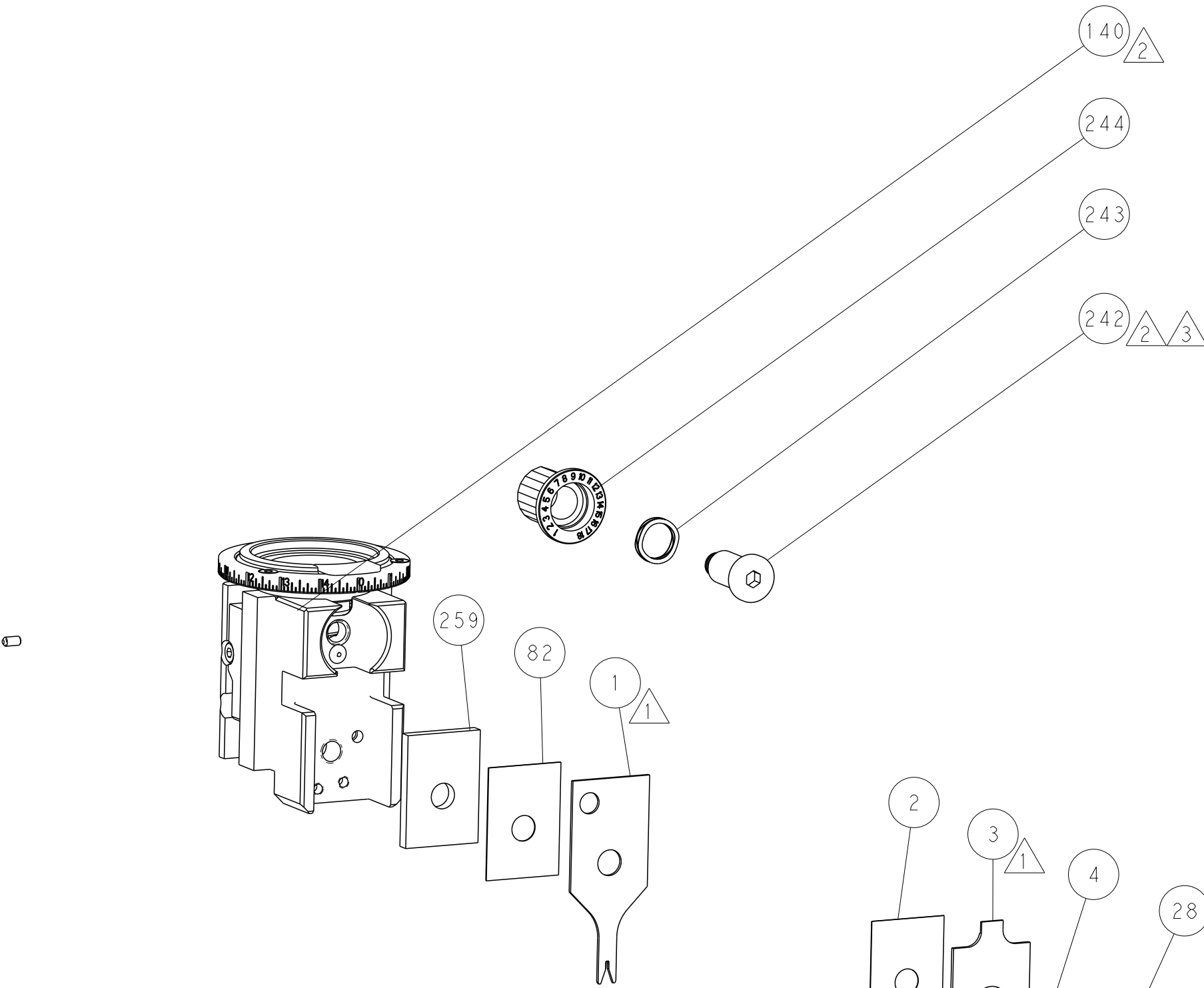
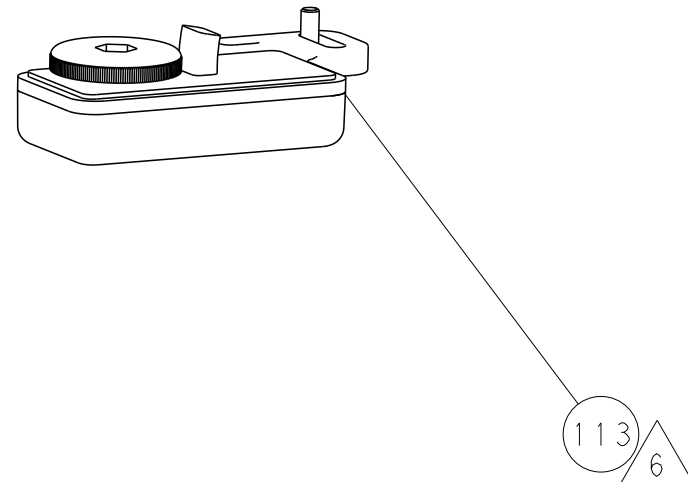
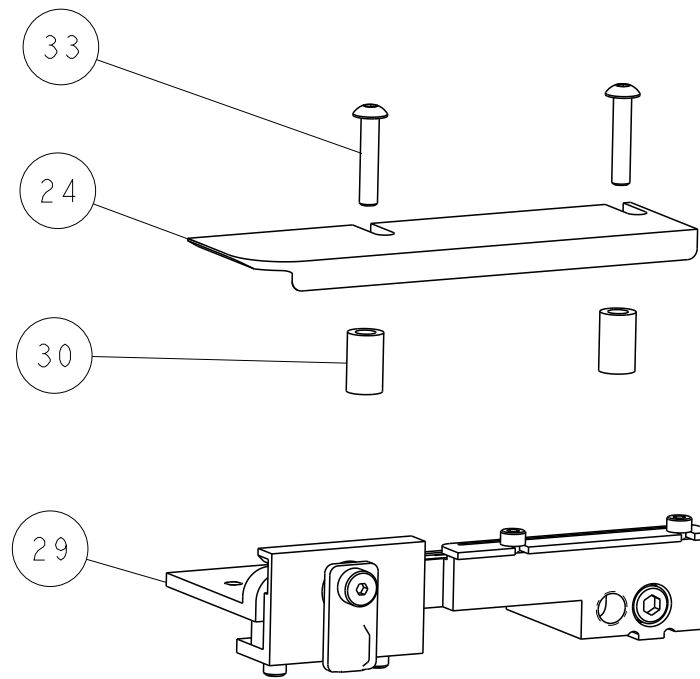
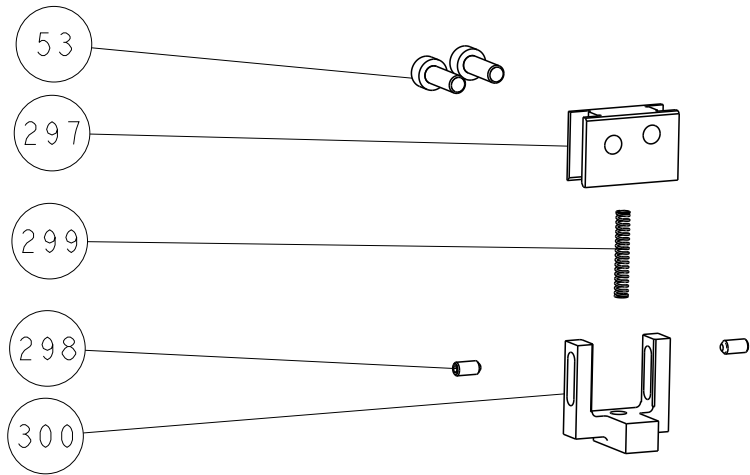


DETAIL A

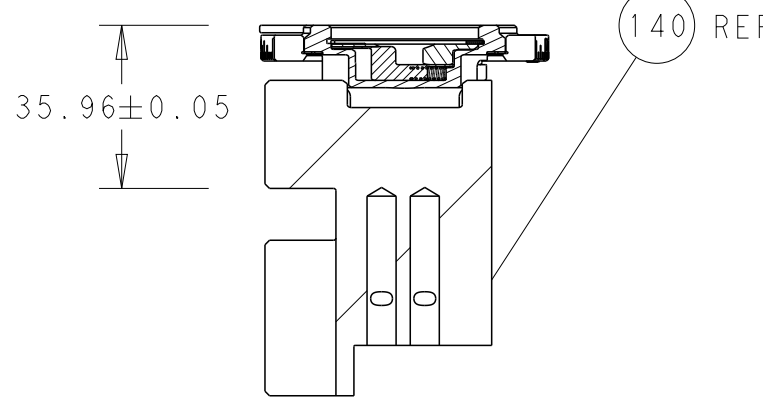
CAM POSITION



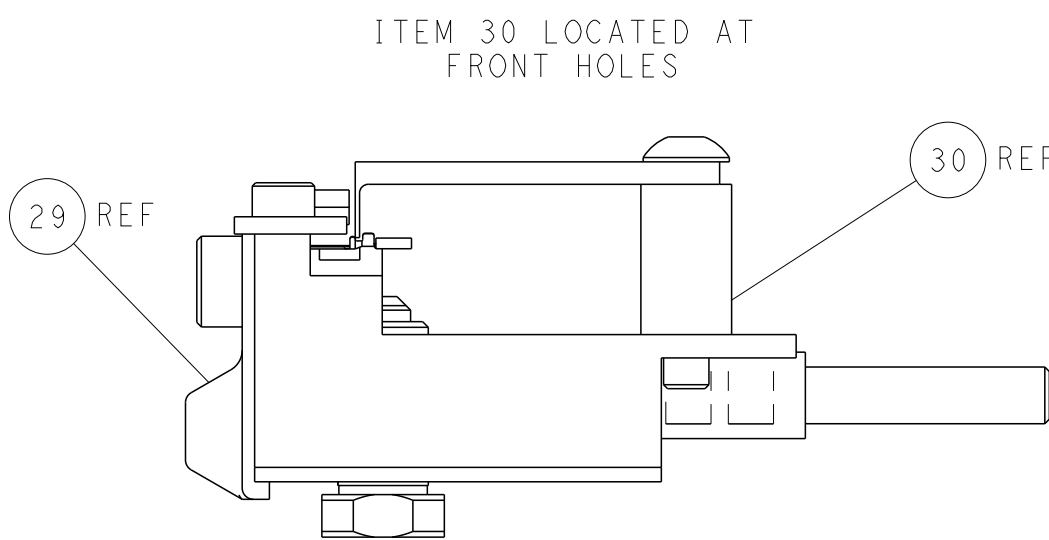
AIR FEED



TERMINAL SUPPORT LOCATION



RAM SET-UP



FEED TRACK POSITION
GUIDE BY INSULATION BARREL

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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				CHK	T. ELBIN	24OCT2016	
				APVD	T. ELBIN	24OCT2016	
				NAME			
DIMENSIONS:				PRODUCT SPEC			Ocean Side Feed Applicator
mm				APPLICATION SPEC			
				WEIGHT			
MATERIAL				Customer Accessible Production Drawing			
				SCALE			1:2
				SHEET			
				OF			
				REV			
				G			

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION