

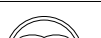





APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.17 mm [.046]	F
INSUL	-	-
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: CENTER CONTACT, PIN, 180 DEG MINI COAX			
WIRE STRIP LENGTH 2.35-2.65 mm [.093-.104 IN]			INSULATION DIAMETER RANGE Ø
TERMINAL APPLICATION SPECIFICATION 		114-94413	-
TERMINALS APPLIED 		-	-
TE TERMINAL 2298125-1	TE TERMINAL	TE TERMINAL	TE TERMINAL

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING
RTK031		0.69+/-0.03 [0.027+/-0.001]		6.8



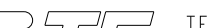

1. RECOMMENDED SPARE PARTS
2. REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
3. CRIMP HEIGHT REFERENCE SETTING WAS THE SETTING USED WHEN THE APPLICATOR WAS QUALIFIED AT THE FACTORY. ADJUSTMENT MAY BE NECESSARY WHEN RUNNING APPLICATOR IN THE FIELD.
4. TERMINAL LUBRICANT IS RECOMMENDED.
5. TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
6. THIS APPLICATOR IS EQUIPPED WITH THE DOUBLE ACTING FEED WITH SENSORS AND IS APPLICATION SPECIFIC. IT DOES NOT REQUIRE ITEMS 49 & 248.
7. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
8. ITEM 19 (STRIPPER) MAY BE REMOVED FOR CERTAIN LEADMAKER APPLICATIONS.

ATLANTIC VERSION

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

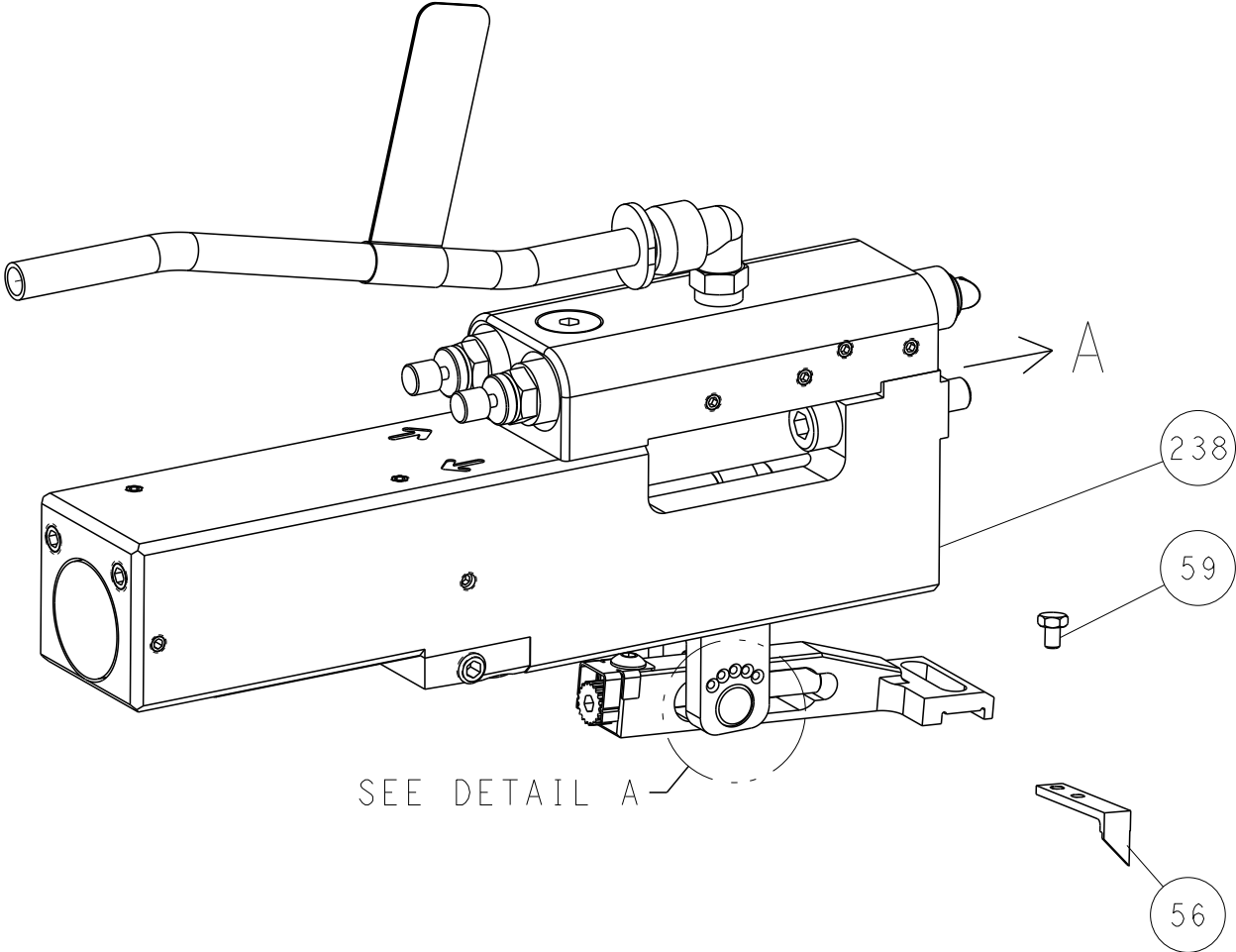
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			C	ECR-23-129686	15FEB2022	ROY	TLE	
			D	ECR-23-167351	23FEB2023	TB	GB	
			D1	ECR-23-171237	04APR2023	TB	GB	
			E	ECR-23-174019	02MAY2023	TB	GB	

	-	1	1	1	1	2392024-1	TONKER	300
	-	1	1	1	1	22278-9	SPRING, COMPRESSION	299
	-	4	4	4	4	1-18032-3	SCR, SET, FLT PNT, M3 X 6.0	298
	-	1	1	1	1	1803944-1	SPACER, TONKER	297
	-	-	1	-	-	2-1803583-1	APPLICATOR BASIC ASSEMBLY, SF	292
	-	-	-	1	-	2844950-1	AIR FEED MODULE	290
6	-	1	1	-	1	2119641-1	FEED CAM, AIR FEED	248
	-	1	1	-	1	2844940-1	AIR FEED MODULE	238
	-	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
5	-	1	1	1	1	1-22281-8	SPRING, COMPRESSION	12
	-	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	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	9-1722371-1	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
	-	2	2	2	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	53
6	-	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	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	3-1752356-9	SUPPORT, TERMINAL	34
	-	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
	-	1	1	1	1	2-1722335-1	Thread bolt Gewindebolzen	31
	-	2	2	2	2	2-2844962-3	SPACER, CYLINDRICAL, STRIP GUIDE	30
	-	1	1	1	1	1803829-1	PLATE, STRIP GUIDE, SPECIAL	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
8	-	2	1	2	2	1-18028-2	WASHER, FLAT, REG M4	20
	-	1	-	1	1	2119533-3	STRIPPER, SIDE FEED	19
	-	1	1	1	1	3-22280-3	SPRING, COMPRESSION	12
	-	1	1	1	1	1-356885-4	STOP, SHEAR	11
1	-	1	1	1	1	2119805-1	SHEAR HOLDER, FRONT	10
1	-	1	1	1	1	1803095-1	FLOATING SHEAR, FRONT	9
	1	2	1	1	1	9-1722371-3	ANVIL, COMBINATION	8
	-	-	-	-	-	-	-	7
	-	-	-	-	-	-	-	6
	-	1	1	1	1	2119757-4	DEPRESSOR, SHEAR	5
	-	-	-	-	-	-	-	4
	-	-	-	-	-	-	-	3
	-	-	-	-	-	-	-	2
1	1	2	1	1	1	1722381-1	CRIMPER, WIRE	1
	-77	-72	-52	-32	-2	PART NO	DESCRIPTION	ITEM NO

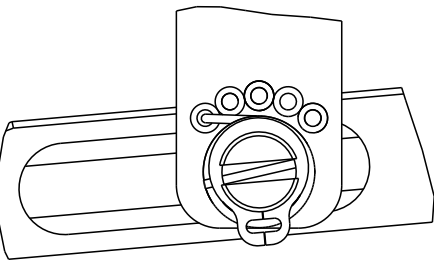
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DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH		NAME Ocean Side Feed Applicator -	
		CHG 30APR2019 M HERR T ELBIN PRODUCT SPEC APPLICATION SPEC		SIZE CAGE CODE DRAWING NO A 00779 C=2836902	
MATERIAL -		WEIGHT -		RESTRICTED TO -	
Customer Accessible Production Drawing				SCALE 1:2 SHEET 1 OF 4 REV E	

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

FEED TYPE
PNEUMATIC

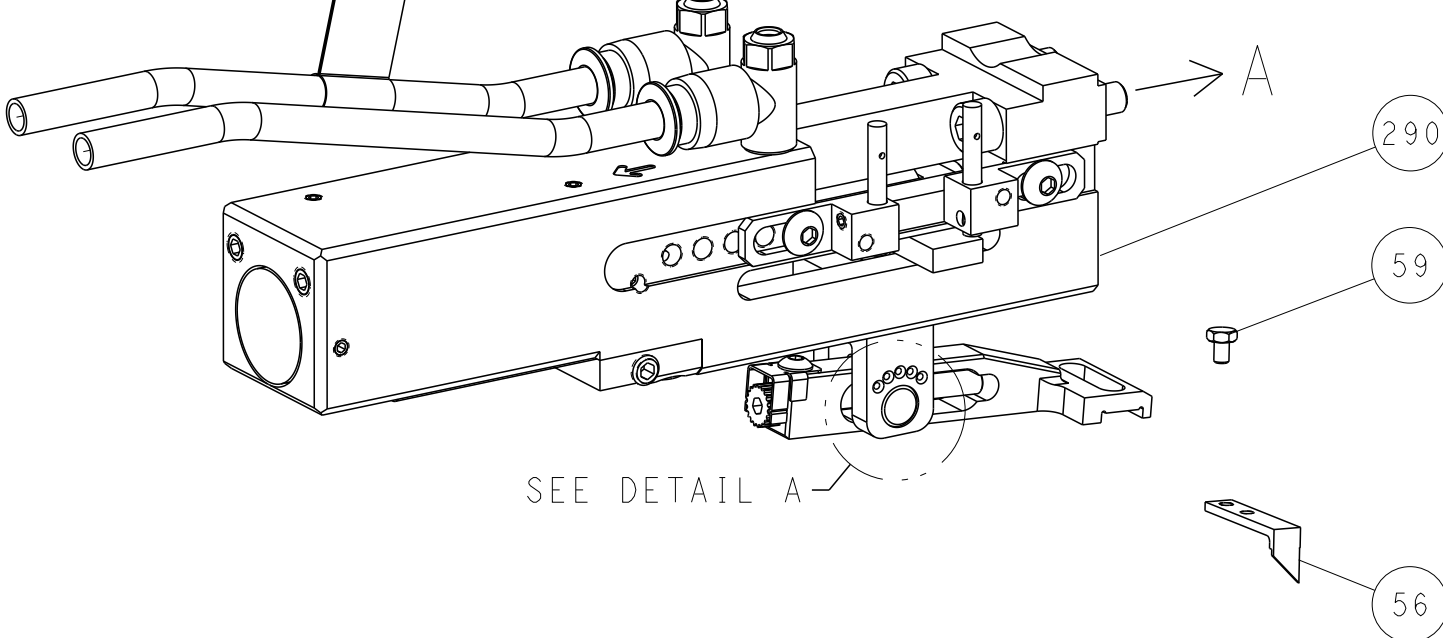


FEED SPRING SETTING POSITION
(SHOWN FROM REAR SIDE)

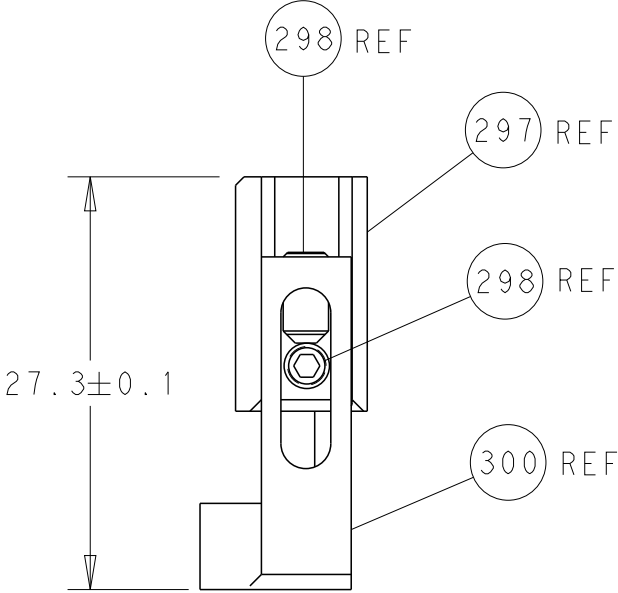
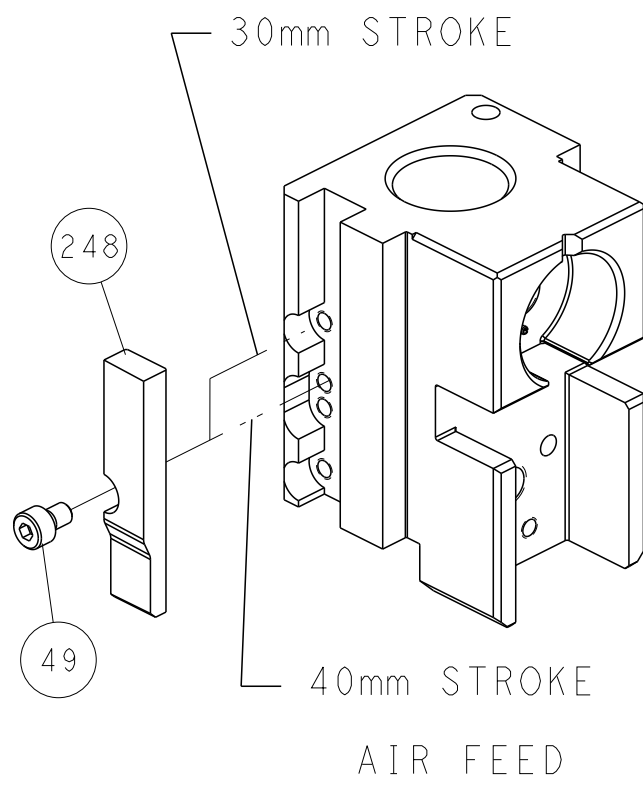


DETAIL A

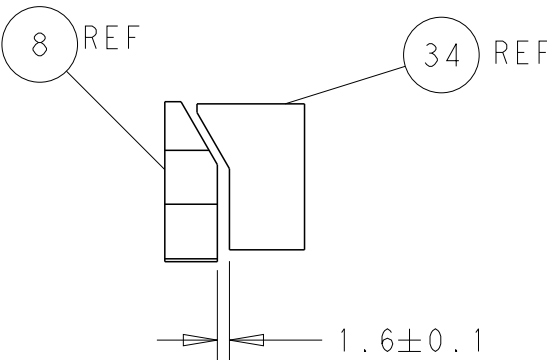
DOUBLE ACTING
PNEUMATIC
WITH SENSORS



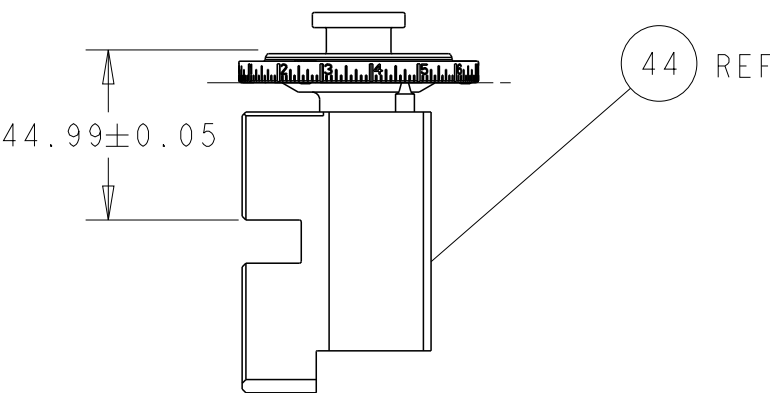
CAM POSITION



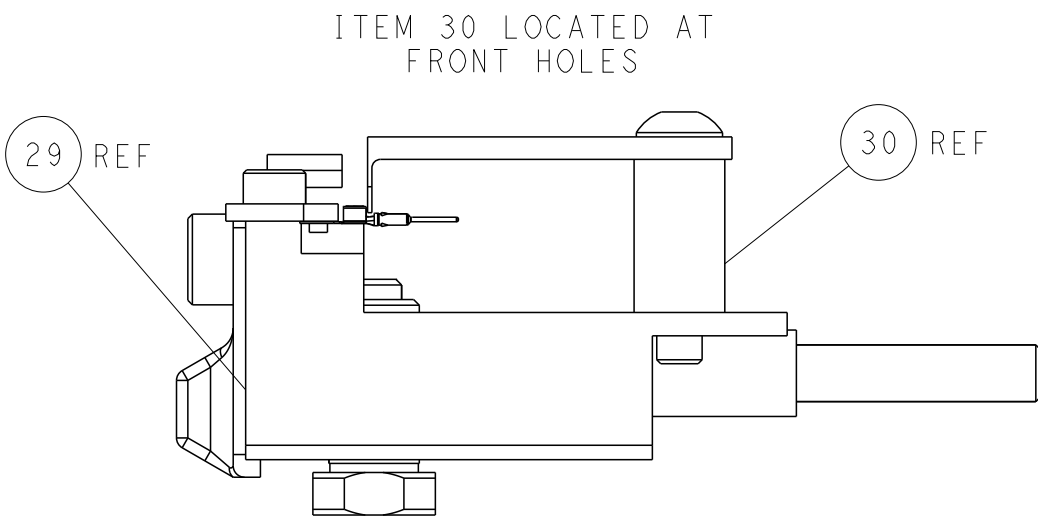
HOLD DOWN SET-UP



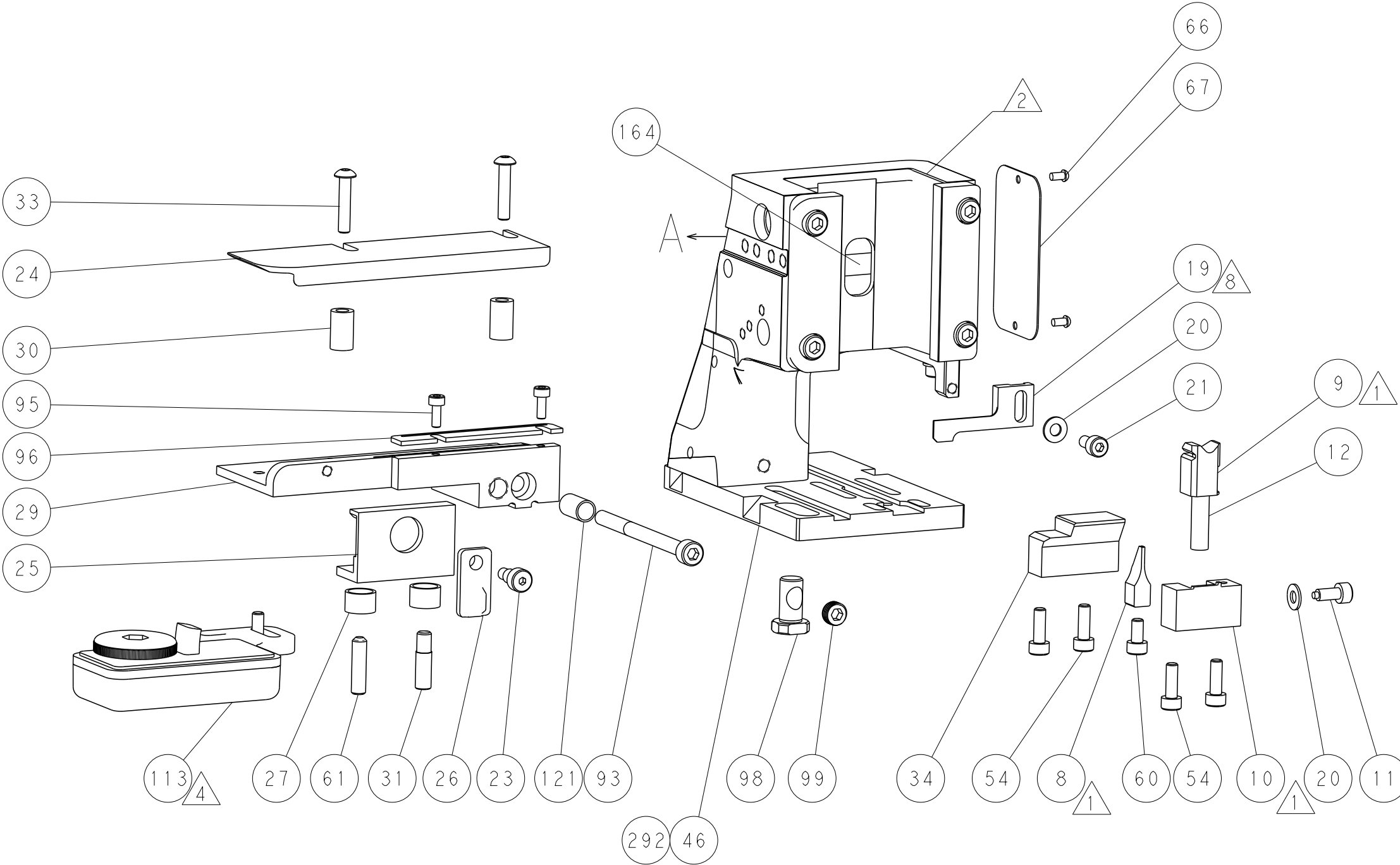
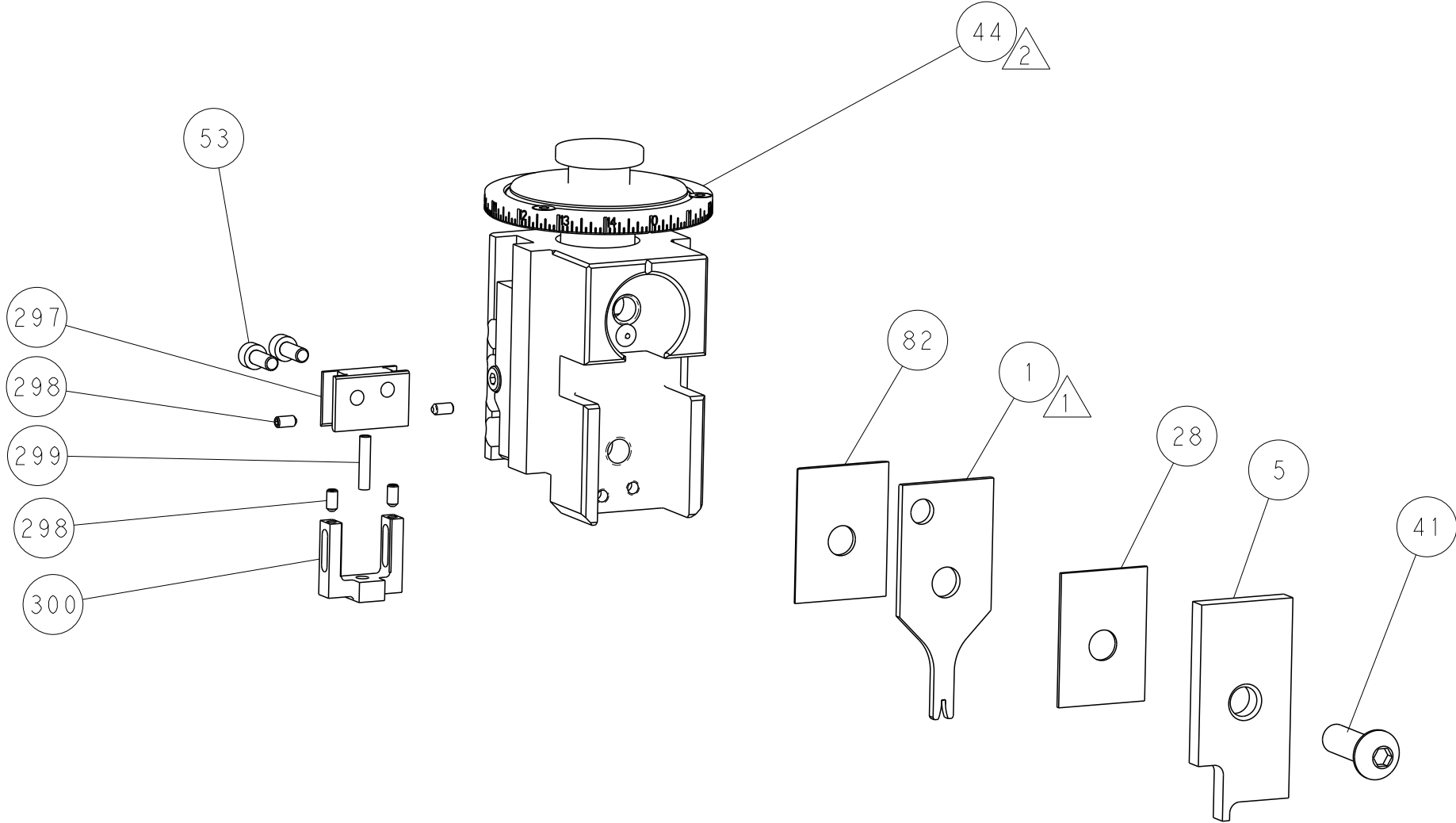
TERMINAL SUPPORT LOCATION



RAM SET-UP



FEED TRACK POSITION
GUIDE BY WIRE BARREL



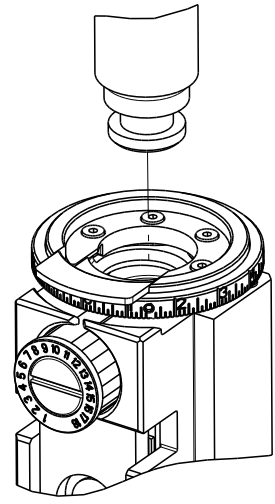
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

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CHK M. HERR 30APR2019		NAME T. ELBIN 30APR2019	Ocean Side Feed Applicator	
APVD T. ELBIN 30APR2019		PRODUCT SPEC	SIZE A1	
APPLICATION SPEC		WEIGHT -	CAGE CODE 00779	
MATERIAL -		FINISH -	Customer Accessible Production Drawing	
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH	DRAWING NO 2836902	
SCALE 1:2		SHEET 2		REV E





SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

8		7	
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20		20	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2836902-2	E	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
4-2836902-2	E	FINE CRIMP HEIGHT ADJUST	DOUBLE ACTING PNEUMATIC WITH SENSORS
7-2836902-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.17 mm [.046]	F
INSUL	-	-
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: CENTER CONTACT, PIN, 180 DEG MINI COAX			
WIRE STRIP LENGTH 2.35-2.65 mm [.093-.104 IN]			INSULATION DIAMETER RANGE Ø
TERMINAL APPLICATION SPECIFICATION		114-94413	-
		-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
2298125-1			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
RTK031	0.69+/-0.03 [.027+/- .001]	6.8



- RECOMMENDED SPARE PARTS
- REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- 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.
- TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- THIS APPLICATOR IS EQUIPPED WITH THE DOUBLE ACTING FEED WITH SENSORS AND IS APPLICATION SPECIFIC. IT DOES NOT REQUIRE ITEMS 49 & 151.
- UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- ITEM 19 (STRIPPER) MAY BE REMOVED FOR CERTAIN LEADMAKER APPLICATIONS.

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

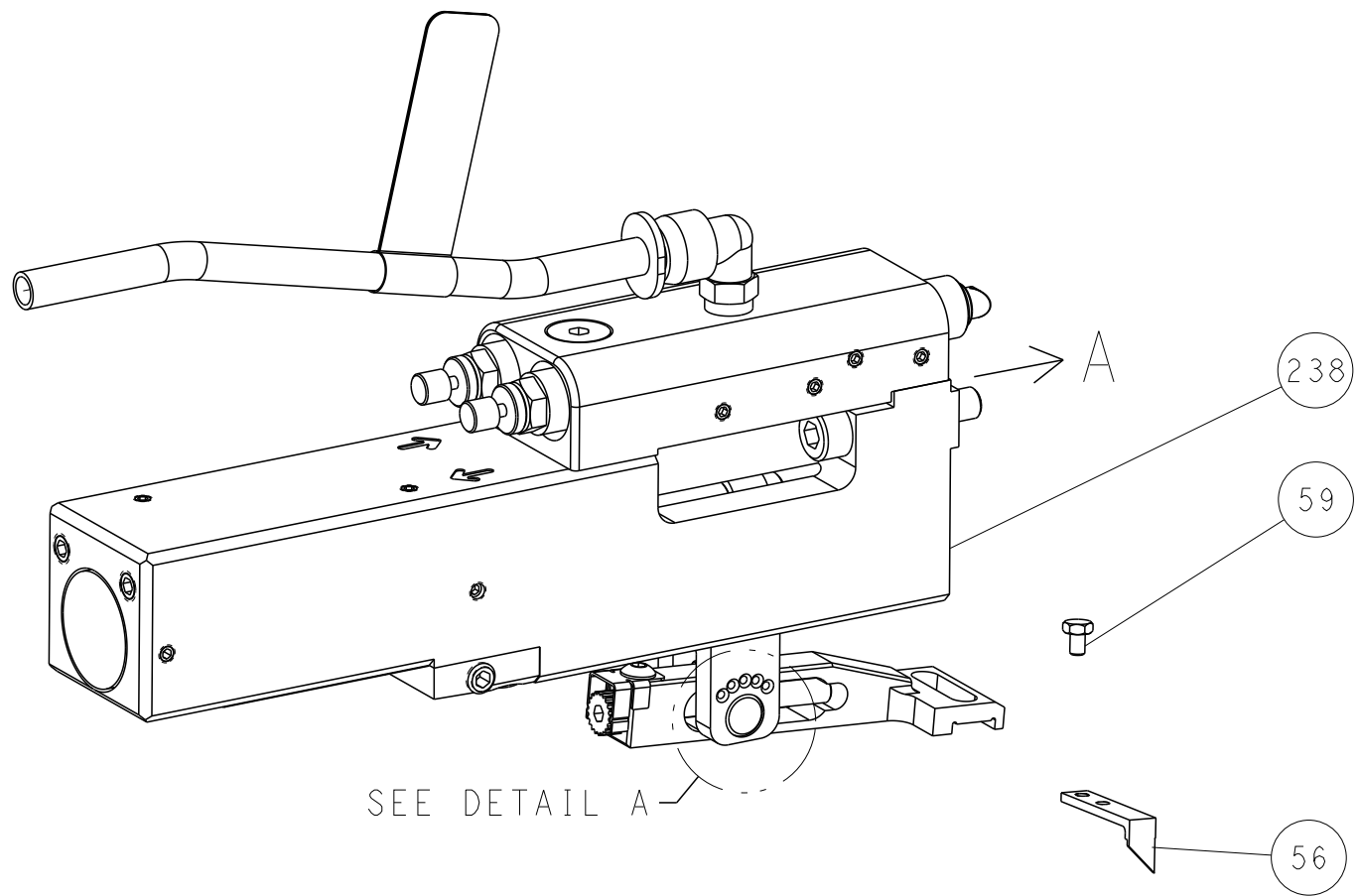
LOC		DIST		REVISIONS				
A		66		P	LTR	DESCRIPTION	DATE	OWN
				-	-	SEE SHEET 1	-	-

-	1	1	2392024-1	TONKER	300
-	1	1	22278-9	SPRING, COMPRESSION	299
-	4	4	4-18032-3	SCR, SET, FLT PNT, M3 X 6.0	298
-	1	1	1803944-1	SPACER, TONKER	297
-	1	-	2844950-1	AIR FEED MODULE	290
-	-	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	9-1722371-1	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
-	2	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	53
-	-	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	3-1752356-9	SUPPORT, TERMINAL	34
-	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	1	1	2-1722335-1	Thread bolt Gewindebolzen	31
-	2	2	2-2844962-3	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	1803829-1	PLATE, STRIP GUIDE, SPECIAL	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	2119533-3	STRIPPER, SIDE FEED	19
-	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	1803095-1	FLOATING SHEAR, FRONT	9
-	1	1	1	1	1
-	-	-	-	-	7
-	-	-	-	-	6
-	1	1	2119757-4	DEPRESSOR, SHEAR	5
-	-	-	-	-	4
-	-	-	-	-	3
-	-	-	-	-	2
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-	1	1	1722381-1	CRIMPER, WIRE	1
-77	-42	-22	PART NO	DESCRIPTION	ITEM NO

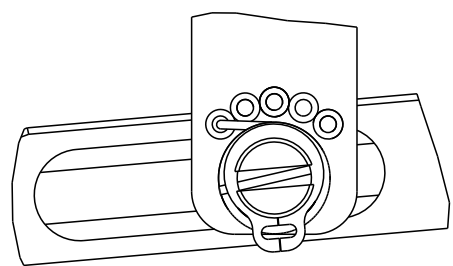
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DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH		NAME Ocean Side Feed Applicator	
MATERIAL		WEIGHT		SIZE 00779	
				CAGE CODE 2836902	
				DRAWING NO 1:2	
				SHEET 3 OF 4	
				REV E	

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

FEED TYPE PNEUMATIC

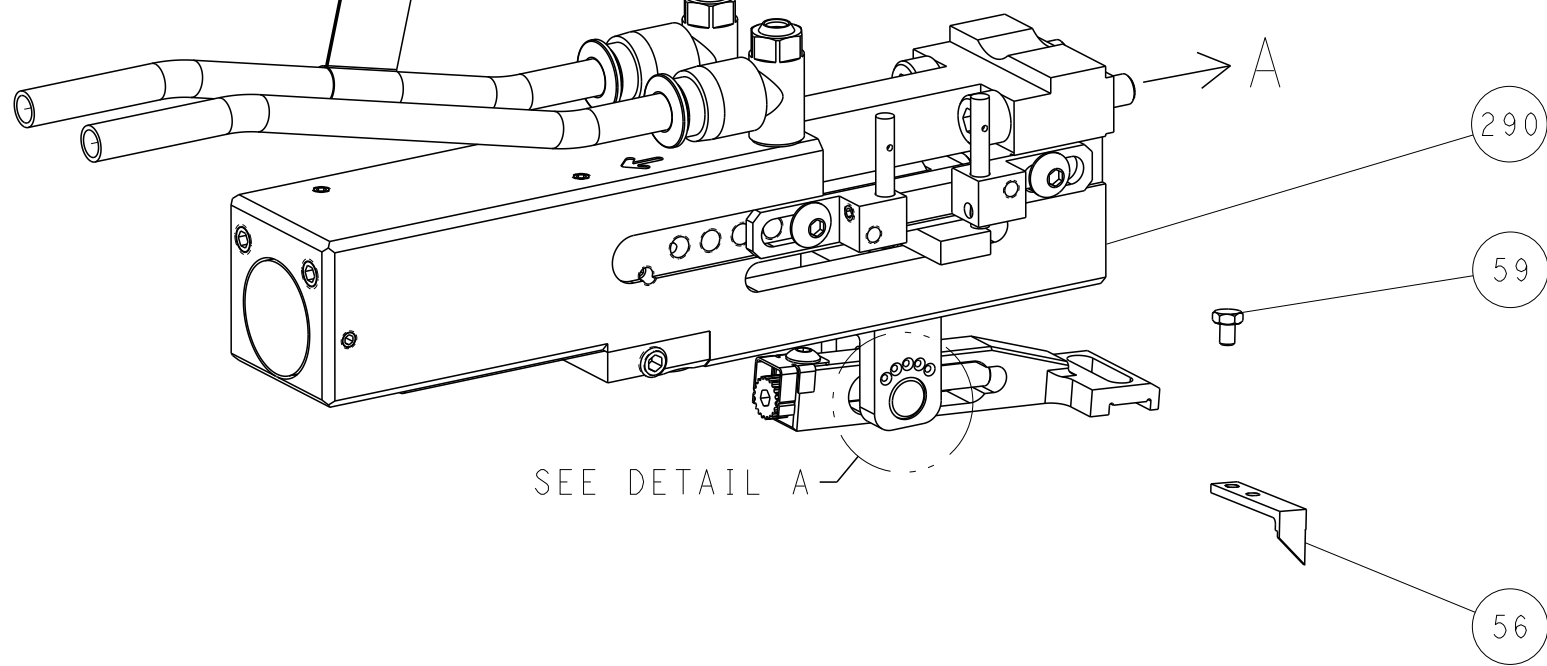


FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)

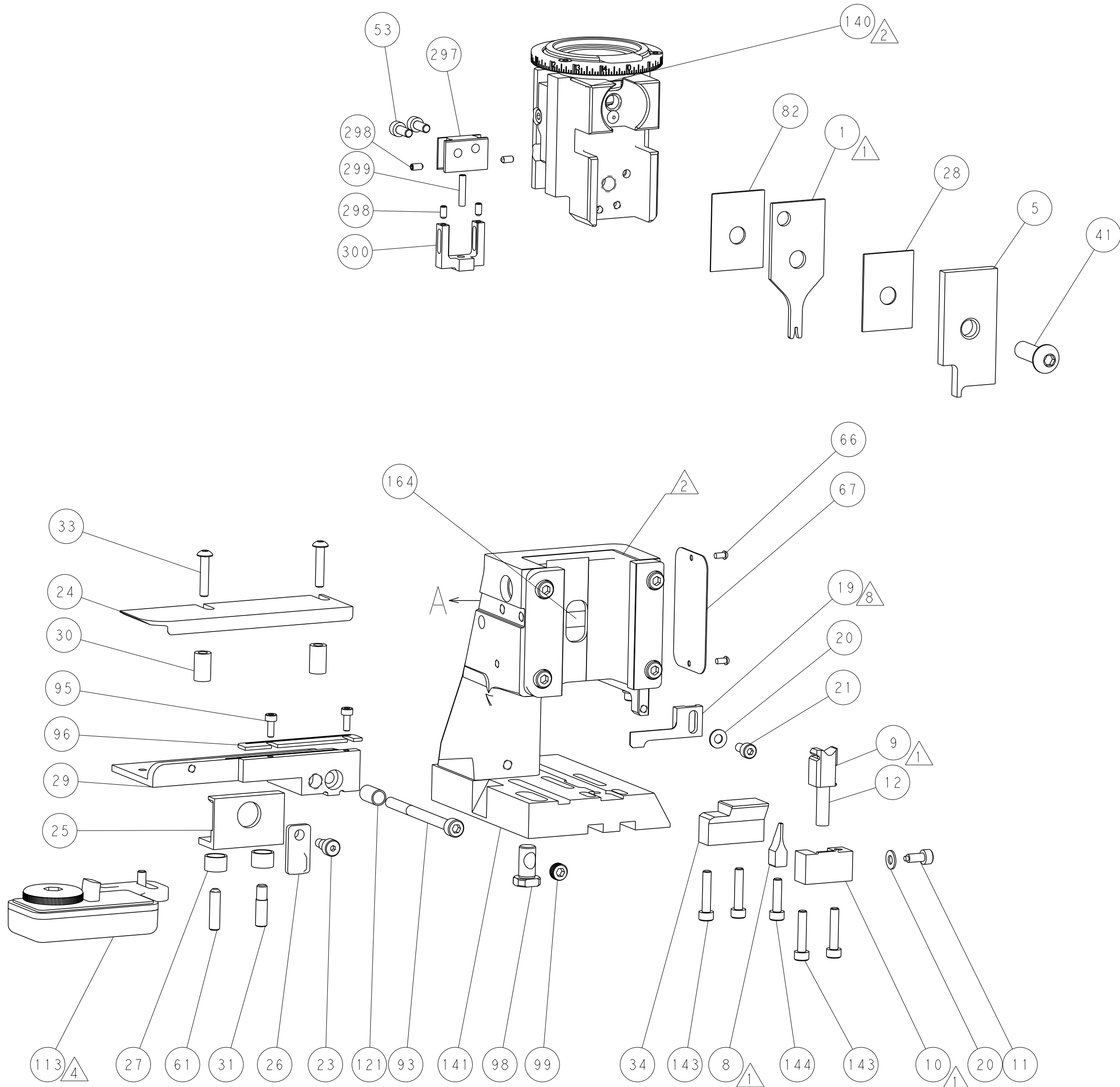
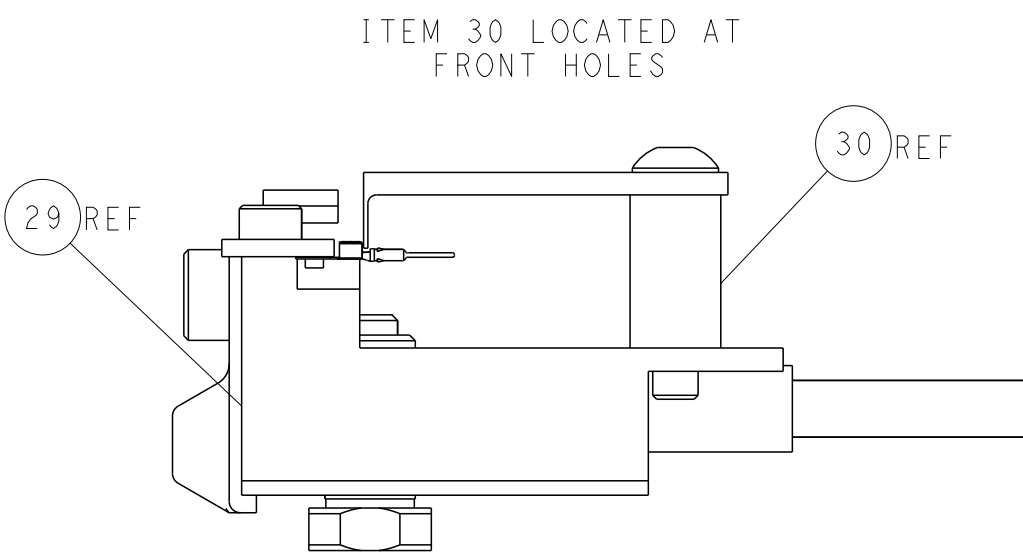
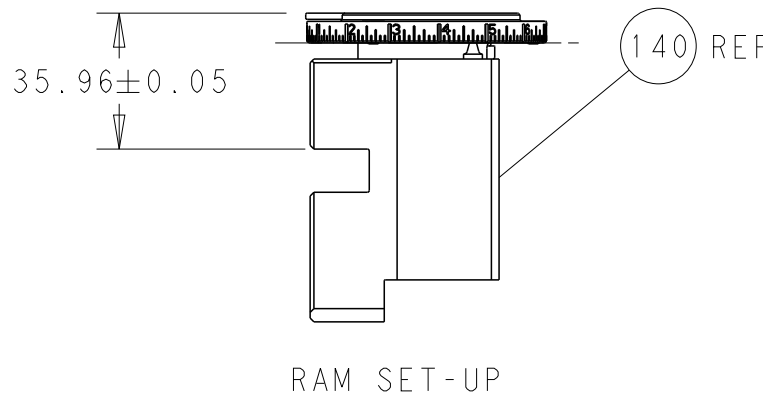
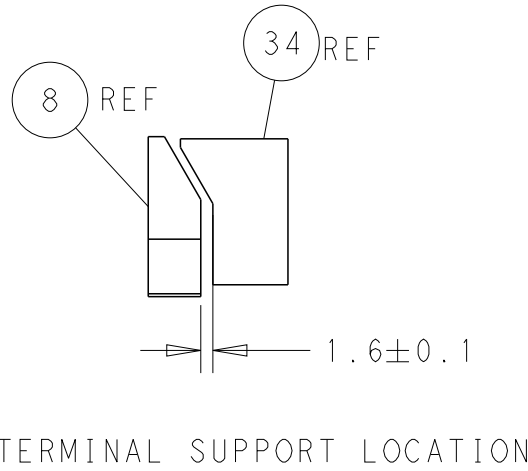
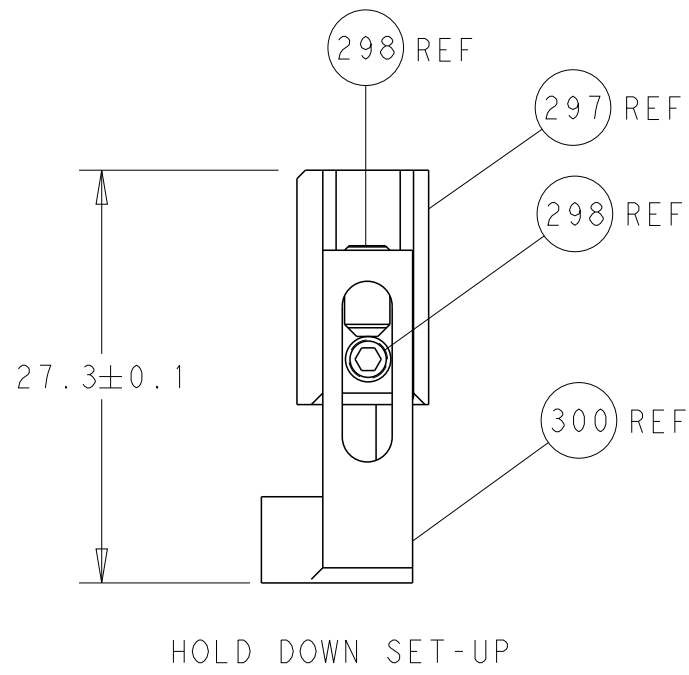
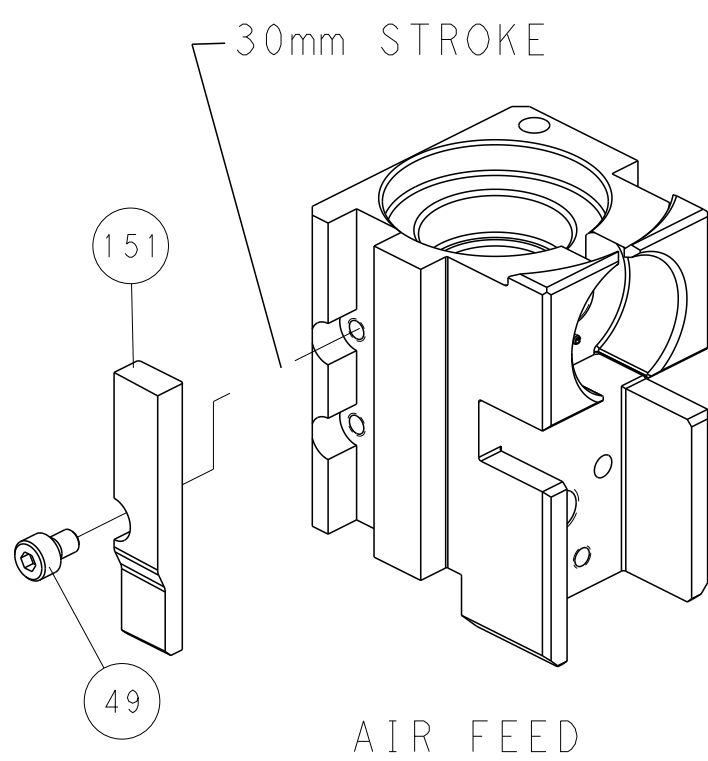


DETAIL A

DOUBLE ACTING PNEUMATIC WITH SENSORS



CAM POSITION



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		CHK M. HERR 30APR2019	NAME Ocean Side Feed Applicator	
TOLERANCES UNLESS OTHERWISE SPECIFIED:		APVD T. ELBIN 30APR2019	SIZE A1	
0 PLC ±.1		PRODUCT SPEC	CAGE CODE 00779	
1 PLC ±.1		APPLICATION SPEC	DRAWING NO 2836902	
2 PLC ±.1		WEIGHT	SCALE 1:2	
3 PLC ±.1		RESTRICTED TO	SHEET 4	
4 PLC ±.1		Customer Accessible Production Drawing	OF 4	
ANGLES FINISH		REV E		