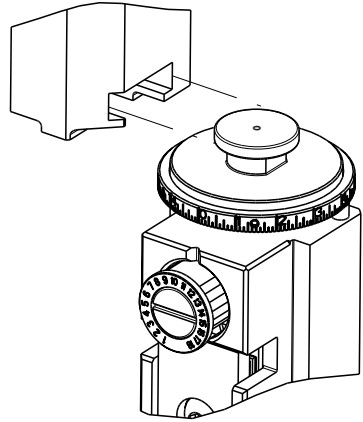


8	7
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RELEASED FOR PUBLICATION	
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PART NUMBER	REVISION
2837270-2	D
7-2837270-2	D
7-2837270-7	A
DESCRIPTION	
FINE CRIMP HEIGHT ADJUST	
PNEUMATIC AND CRIMP TOOLING KIT	
CRIMP TOOLING KIT	
FEED TYPE	
PNEUMATIC	
PNEUMATIC	
-	

ATLANTIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	0.70 mm [.028]	F
INSUL	0.75 mm [.030]	F
APPLICATOR INSTRUCTIONS		
408-35042		

TERMINAL DATA: MOLEX TERMINAL		MOLEX CRIMP SPECIFICATION	
TERMINAL NAME: 1.0mm PITCH		WIRE TO BOARD CONN	
WIRE STRIP LENGTH		TERMINAL INSULATION DIAMETER RANGE	
1.00-1.30 mm [.039-.051 IN]		Ø0.40-0.80 mm [.016-.031 IN]	
TERMINAL APPLICATION SPECIFICATION		ATS-639019400 Rev C	
TERMINALS APPLIED			
TE TERMINAL	MOLEX TERMINAL	TE TERMINAL	MOLEX TERMINAL
3311207-1	501334-0000	3311207-3	501193-3000
3311207-2	501193-2000	3311207-4	501193-0099
3311207-5	501193-5000	3311207-6	501193-6000
3311207-7	501193-8000	3311207-8	501193-9000
3311207-9	501193-7000		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
28 AWG	0.46+/-0.02 [.018+/- .001]	7.1
30 AWG	0.43+/-0.02 [.017+/- .001]	7.4
32 AWG	0.41+/-0.02 [.016+/- .001]	7.6



- RECOMMENDED SPARE PARTS
- REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 180. 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.
5. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- TERMINAL LUBRICANT IS RECOMMENDED.
- PART OPTIONAL FOR BETTER LEADMAKER PERFORMANCE.

*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	LYR	DESCRIPTION	DATE
		B		ECR-19-003181	21FEB2019
		C		ECR-19-004200	15MAR2019
		D		ECR-19-009781	24JUN2019
		D1		ECR-20-013368	21SEP2020

8	-	1	1	2079383-1	SCR, BHSC, RoHS (M3 X 8)	284
	-	1	1	1633289-4	STABILIZER	283
	-	1	1	1803461	HOLDER, STABILIZER	282
	-	1	1	1-18028-3	WASHER, FLAT, REG M5	281
	-	1	1	1803196-1	STUD, ADJUSTMENT SCREW	280
	-	1	1	2330046-1	RESIN COLLAR, FLANGED	261
	-	1	1	2119641-1	FEED CAM, AIR FEED	248
	-	1	1	2119082-5	CAM, SNAIL, INSULATION ADJUSTMENT	244
	-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
	-	1	1	2119083-1	RETAINER, INSULATION DIAL	242
3	-	1	1	2844940-1	AIR FEED MODULE	238
	-	2	2	1-2079383-0	SCR, BHSC, RoHS (M3 X 6)	230
3	-	1	1	1-1752354-4	STANDOFF, HOLD-DOWN	180
	-	1	1	2-1633764-2	HOLD DOWN, TERMINAL	179
	-	1	1	9931111-1	PIN, SLOTTED SPRING 3.0 X 20.0	177
	-	1	1	8-22280-7	SPRING, COMPRESSION	176
	-	1	1	1752353-2	GUIDE PIN,HOLDDOWN	175
	-	1	1	1901680-2	GUIDE PIN,HOLDDOWN	174
	-	REF	REF	994970-2	COUNTER, MAGNETIC	164
	-	1	1	1-22281-6	SPRING, COMPRESSION	121
1	-	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	1-994962-8	SCR, SKT HD CAP M3 X 45.0	93
	-	1	1	1803607-3	DOCUMENTATION PACKAGE	71
	-	1	1	2-2119791-2	DEPRESSOR, WIRE	70
	-	1	1	2119740-1	TAG,IDENTIFICATION	67
	-	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
	-	2	2	2-18032-5	SCR, SET, FLT PNT, M5 X 20.0	61
	-	1	1	2161425-1	SCREW, SHOULDER	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
	-	1	1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52
	-	1	1	1901681-8	HOLDDOWN, TERMINAL	51
	-	1	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49
	-	1	1	2-1803583-5	APPLICATOR BASIC ASSEMBLY, SF	46
	-	1	1	1803515-3	RAM ASSEMBLY, SF ATLANTIC	44
	-	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
	-	1	1	4-1752356-7	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	2844938-1	PLATE, STRIP GUIDE	29
	-	1	1	455888-5	SPACER, CRIMPER	28
	-	2	2	22281-8	SPRING, COMPRESSION	27
	-	1	1	356835-1	LEVER, DRAG RELEASE	26
	-	1	1	240792-1	DRAG, TERMINAL	25
	-	1	1	1320928-6	STRIP GUIDE	24
	-	1	1	9803711-4	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	1803213-1	STRIPPER	19
	-	1	1	3-22280-3	SPRING, COMPRESSION	12
	-	1	1	1-356885-4	STOP, SHEAR	11
1	-	1	1	2119805-1	SHEAR HOLDER, FRONT	10
	-	1	1	1803095-6	FLOATING SHEAR, FRONT -	9
1	1	2	1	1803655-4	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	1-1803493-5	CRIMPER, INSULATION F PREMIUM	3
1	-	-	-	-	-	2
	1	2	1	3-1803407-0	CRIMPER, WIRE PREMIUM	1
	-77-72	-2	PART NO	DESCRIPTION	ITEM NO	

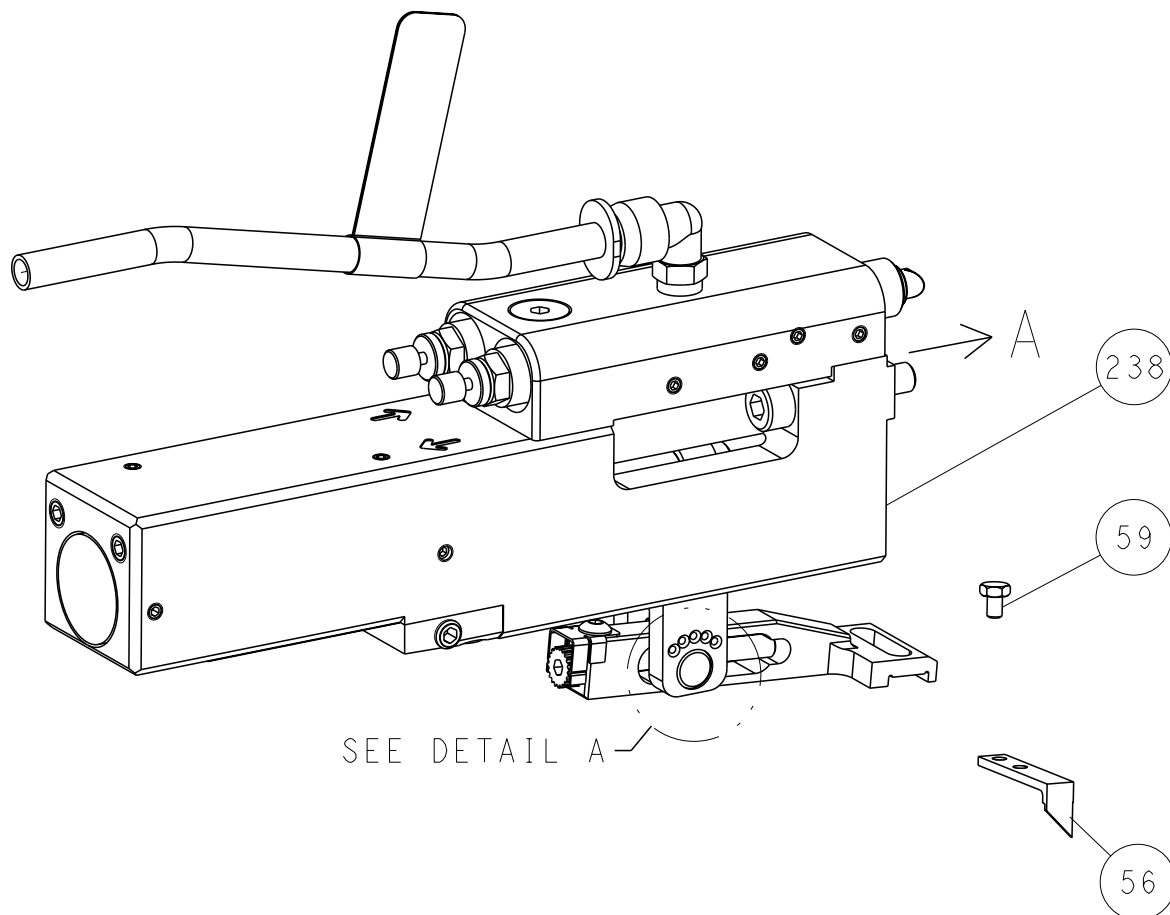
THIS DRAWING IS A CONTROLLED DOCUMENT FOR THE ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE AND TO BE CONTROLLED BY THE ENGINEERING ORGANIZATION. SHOULD BE CONTACTED FOR THE LATEST REVISION.		OWN T. BROOKS 17MAY2018	TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm		CHK R. KNEPPER 17MAY2018	NAME Ocean Side Feed Applicator	
TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		APVD T. ELBIN 17MAY2018	PRODUCT SPEC	
MATERIAL			APPLICATION SPEC	
			SIZE CASE CODE DRAWING NO	
			A1 00779 ©=2837270	
			RESTRICTED TO	
			Customer Accessible Production Drawing	
			SCALE 1:2 SHEET 1 OF 4 REV D1	

SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

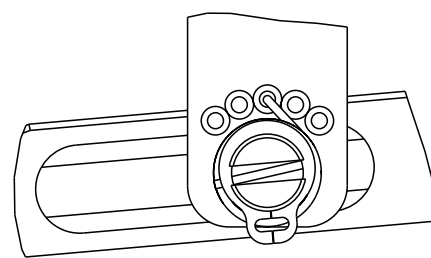
LOC		DIST		REVISIONS					
A		66		P	LYR	DESCRIPTION	DATE	DWN	APVD
					-	SEE SHEET 1	-	-	-

FEED TYPE

PNEUMATIC

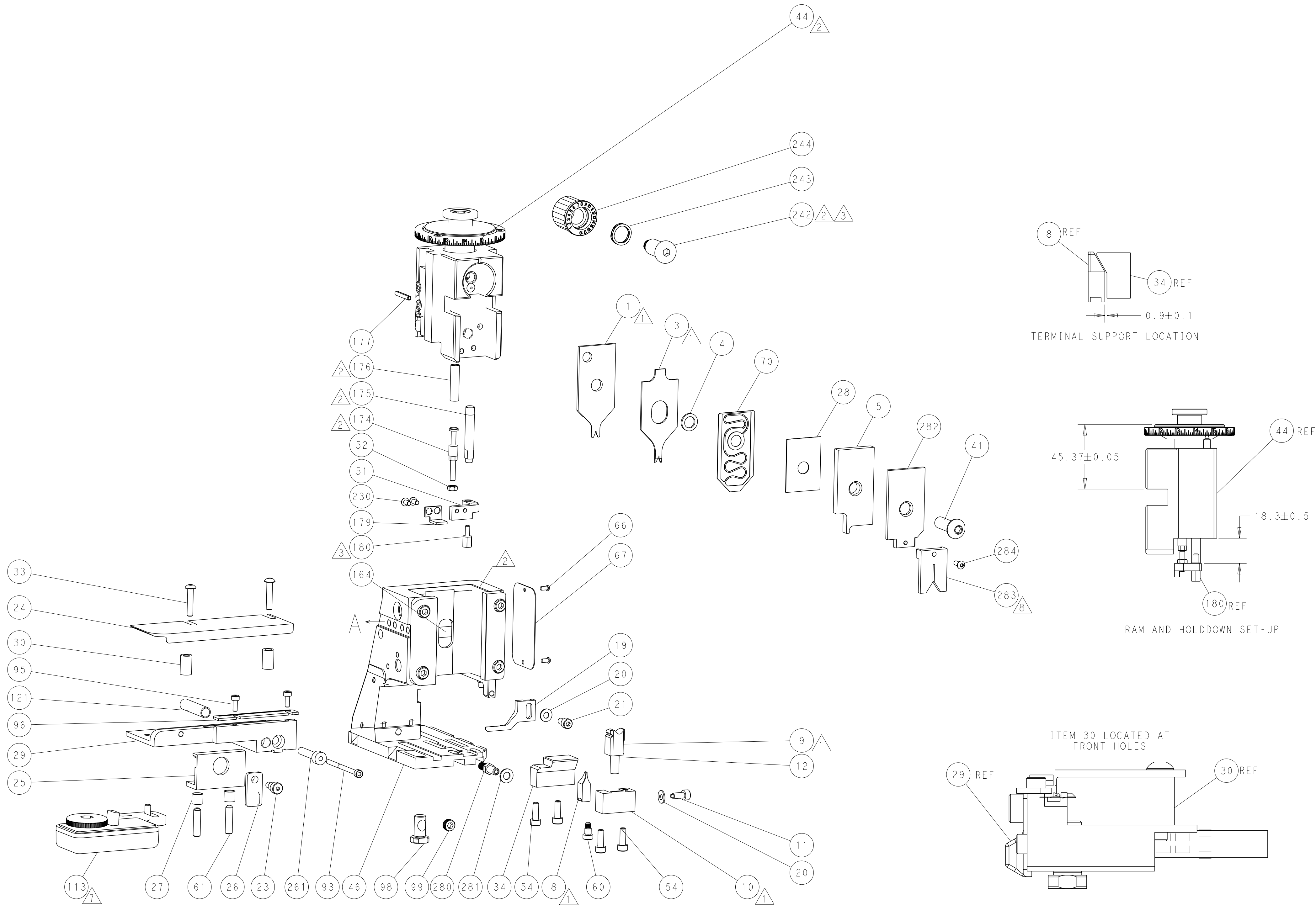
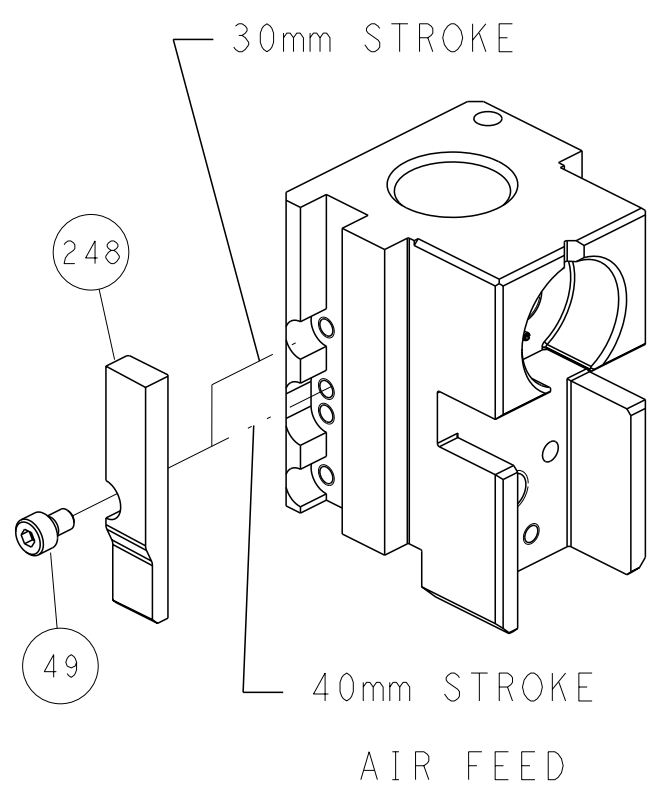


FEED SPRING SETTING POSITION
(SHOWN FROM REAR SIDE)



DETAIL A

CAM POSITION



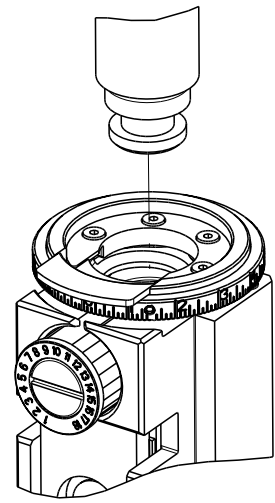
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION IT IS SUBJECT TO CHANGE AND TO CONTROL AND ENGINEERING DISCRETION SHALL BE CONTACTED FOR THE LATEST REVISION		DWN T. BROOKS 17MAY2018	TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm		CHK R. KNEPPER 17MAY2018	NAME Ocean Side Feed Applicator	
TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		APVD T. ELBIN 17MAY2018	SIZE A1	
MATERIAL -		PRODUCT SPEC -	CAGE CODE DRAWING NO 00779 C=2837270	
FINISH -		APPLICATION SPEC -	RESTRICTED TO -	
-		WEIGHT -	Customer Accessible Production Drawing	
		SCALE 1:2	SHEET 2 OF 4	
			REV D1	




SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

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20		20	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2837270-2	D	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2837270-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	0.70 mm [.028]	F
INSUL	0.75 mm [.030]	F
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: MOLEX TERMINAL		MOLEX CRIMP SPECIFICATION	
TERMINAL NAME: 1.0mm PITCH		WIRE TO BOARD CONN	
WIRE STRIP LENGTH 1.00-1.30 mm [.039-.051 IN]		TERMINAL INSULATION DIAMETER RANGE Ø0.40-0.80 mm [.016-.031 IN]	
TERMINAL APPLICATION SPECIFICATION	ATS-639019400 Rev C	-	-
	-	-	-
TERMINALS APPLIED  			
TE TERMINAL	MOLEX TERMINAL	TE TERMINAL	MOLEX TERMINAL
3311207-1	501334-0000	3311207-3	501193-3000
3311207-2	501193-2000	3311207-4	501193-0099
3311207-5	501193-5000	3311207-6	501193-6000
3311207-7	501193-8000	3311207-8	501193-9000
3311207-9	501193-7000		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
28 AWG	0.46 +/- 0.02 [.018 +/- .001]	7.1
30 AWG	0.43 +/- 0.02 [.017 +/- .001]	7.4
32 AWG	0.41 +/- 0.02 [.016 +/- .001]	7.6



- RECOMMENDED SPARE PARTS
- REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 180.
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.
- UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- TERMINAL LUBRICANT IS RECOMMENDED.
- PART OPTIONAL FOR BETTER LEADMAKER PERFORMANCE.

***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)

2		1						
LOC	DIST	REVISIONS						
A	66	P	LYR	DESCRIPTION	DATE	DWN	APVD	
		-		SEE SHEET 1	-	-	-	

8	-	1	2079383-1	SCR, BHSC, RoHS (M3 X 8)	284
	-	1	1633289-4	STABILIZER	283
	-	1	1803461	HOLDER, STABILIZER	282
	-	1	1-18028-3	WASHER, FLAT, REG M5	281
3	-	1	1803196-1	STUD, ADJUSTMENT SCREW	280
	-	1	2330046-1	RESIN COLLAR, FLANGED	261
	-	1	2119082-5	CAM, SNAIL, INSULATION ADJUSTMENT	244
	-	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
3	-	1	2119083-1	RETAINER, INSULATION DIAL	242
	-	1	2844940-1	AIR FEED MODULE	238
	-	2	1-2079383-0	SCR, BHSC, RoHS (M3 X 6)	230
	-	1	1-1752354-4	STANDOFF, HOLD-DOWN	180
3	-	1	2-1633764-2	HOLD DOWN, TERMINAL	179
	-	1	993111-1	PIN, SLOTTED SPRING 3.0 X 20.0	177
	-	1	8-22280-7	SPRING, COMPRESSION	176
	-	1	1752353-2	GUIDE PIN, HOLDDOWN	175
7	-	1	1901680-2	GUIDE PIN, HOLDDOWN	174
	-	REF	994970-2	COUNTER, MAGNETIC	164
	-	1	2119641-2	FEED CAM, AIR FEED	151
	-	1	2161425-2	SCREW, SHOULDER	144
7	-	4	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	143
	-	1	3-1803583-0	APPLICATOR BASIC ASSEMBLY, SF	141
	-	1	1803516-1	RAM ASSEMBLY, SF PACIFIC	140
	-	1	1-22281-6	SPRING, COMPRESSION	121
7	-	1	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113
	-	1	2844908-1	SCREW, LOCKING	99
	-	1	2844907-1	POST, LOCKING	98
	-	1	1-690438-0	FRONT STRIP GUIDE	96
7	-	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	95
	-	1	1-994962-8	SCR, SKT HD CAP M3 X 45.0	93
	-	1	1803607-3	DOCUMENTATION PACKAGE	71
	-	1	2-2119791-2	DEPRESSOR, WIRE	70
7	-	1	2119740-1	TAG, IDENTIFICATION	67
	-	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
	-	2	2-18032-5	SCR, SET, FLT PNT, M5 X 20.0	61
	-	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
7	-	1	1338685-1	PAWL, FEED	56
	-	1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52
	-	1	1901681-8	HOLDDOWN, TERMINAL	51
	-	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49
7	-	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
	-	1	4-1752356-7	SUPPORT, TERMINAL	34
	-	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
	-	2	2-2844962-3	SPACER, CYLINDRICAL, STRIP GUIDE	30
7	-	1	2844938-1	PLATE, STRIP GUIDE	29
	-	1	455888-5	SPACER, CRIMPER	28
	-	2	22281-8	SPRING, COMPRESSION	27
	-	1	356835-1	LEVER, DRAG RELEASE	26
7	-	1	240792-1	DRAG, TERMINAL	25
	-	1	1320928-6	STRIP GUIDE	24
	-	1	980371-4	SCR, SKT HD SHLDR 5.0 DIA X 6.0	23
	-	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
7	-	2	1-18028-2	WASHER, FLAT, REG M4	20
	-	1	1803213-1	STRIPPER	19
	-	1	3-22280-3	SPRING, COMPRESSION	12
	-	1	1-356885-4	STOP, SHEAR	11
7	-	1	2119805-1	SHEAR HOLDER, FRONT	10
	-	1	1803095-6	FLOATING SHEAR, FRONT -	9
	1	1	1803655-4	ANVIL, COMBINATION	8
	-	-	-	-	7
7	-	-	-	-	6
	-	1	2-2119757-4	DEPRESSOR, SHEAR	5
	-	1	2-238011-0	BLOCK, CRIMPER SPACER	4
	1	1	1-1803493-5	CRIMPER, INSULATION F PREMIUM	3
7	-	-	-	-	2
	1	1	3-1803407-0	CRIMPER, WIRE PREMIUM	1
	-	-	-	-	0
	-	-	-	-	0

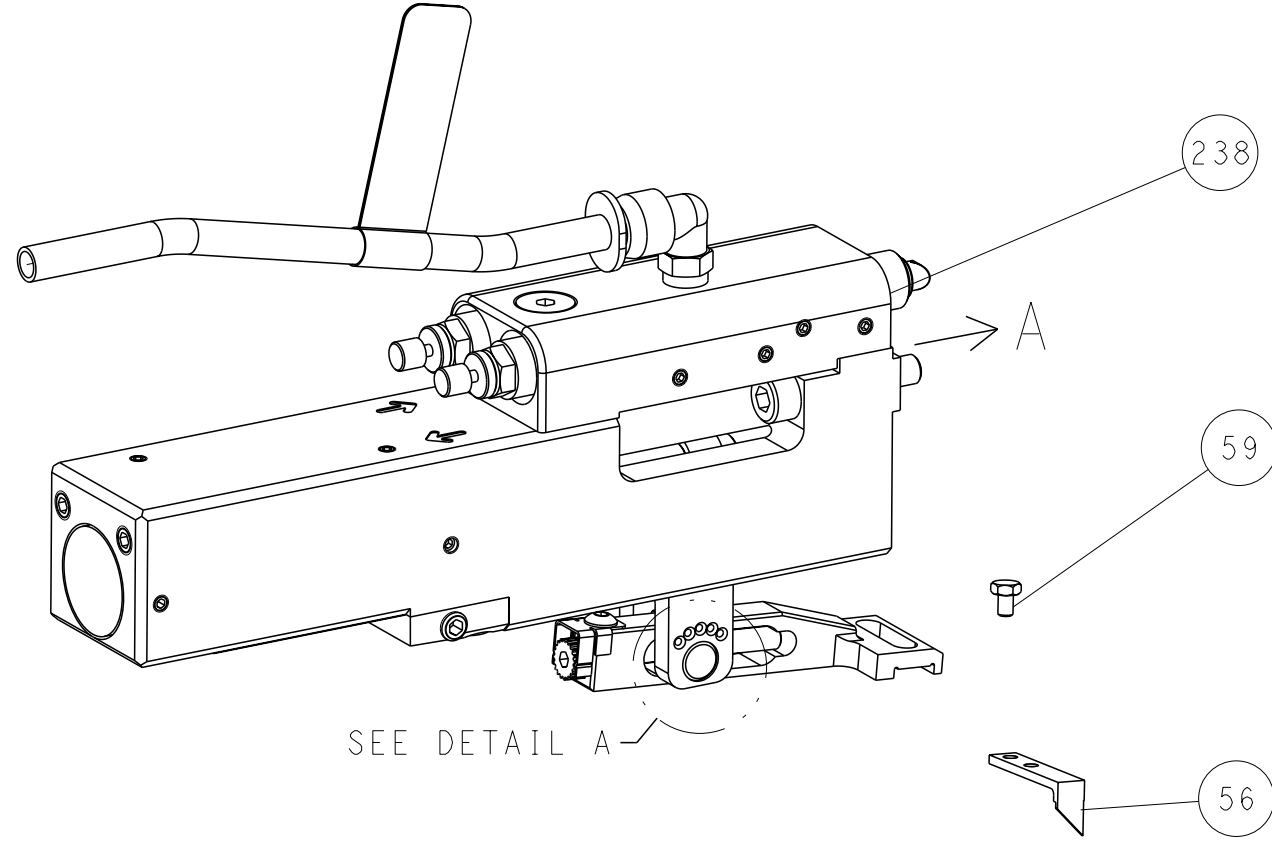
THIS DRAWING IS A CONTROLLED DOCUMENT FOR THE ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE AND TO THE CONTROLLED DOCUMENTS ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST REVISION.		OWN T. BROOKS CHK R. KNEPPER APVD T. ELBIN	17MAY2018 17MAY2018 17MAY2018	TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		NAME Ocean Side Feed Applicator	
MATERIAL -		WEIGHT -		SIZE A1	
-		-		CASE CODE 00779	
-		-		DRAWING NO C=2837270	
-		-		RESTRICTED TO -	
-		-		Customer Accessible Production Drawing	
-		-		SCALE 1:2	
-		-		SHEET 3	
-		-		OF 4	
-		-		REV D1	

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

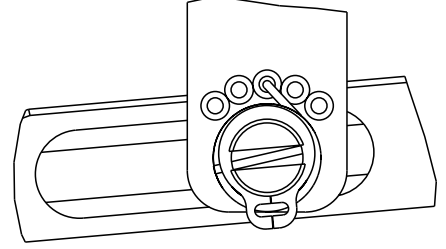
LOC		DIST		REVISIONS					
A		66		P	LYR	DESCRIPTION	DATE	DWN	APVD
					-	SEE SHEET 1	-	-	-

FEED TYPE

PNEUMATIC

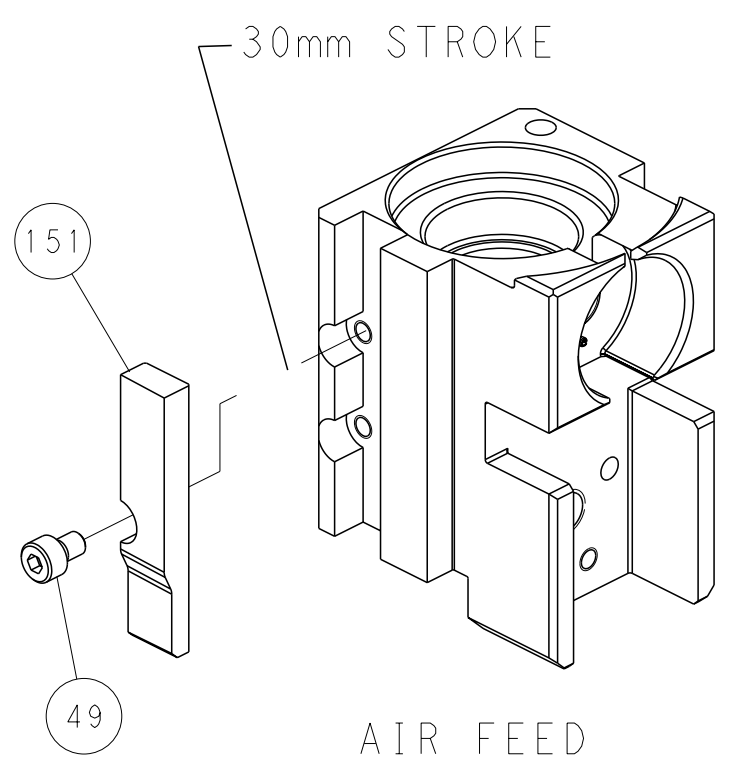


FEED SPRING SETTING POSITION
(SHOWN FROM REAR SIDE)

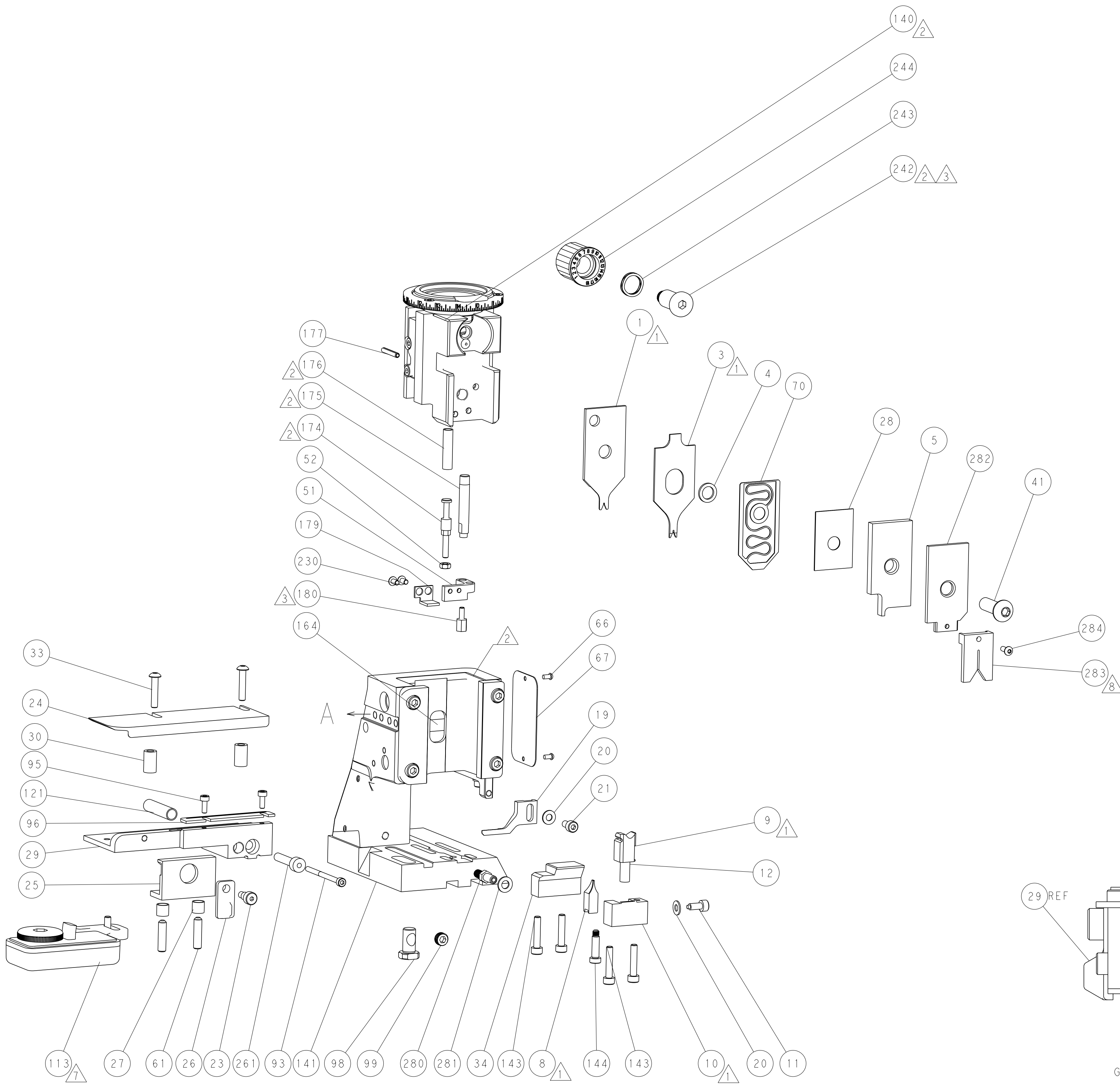


DETAIL A

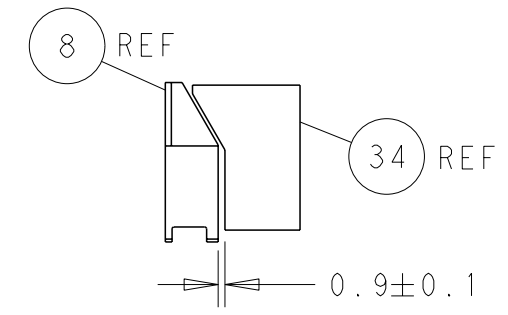
CAM POSITION



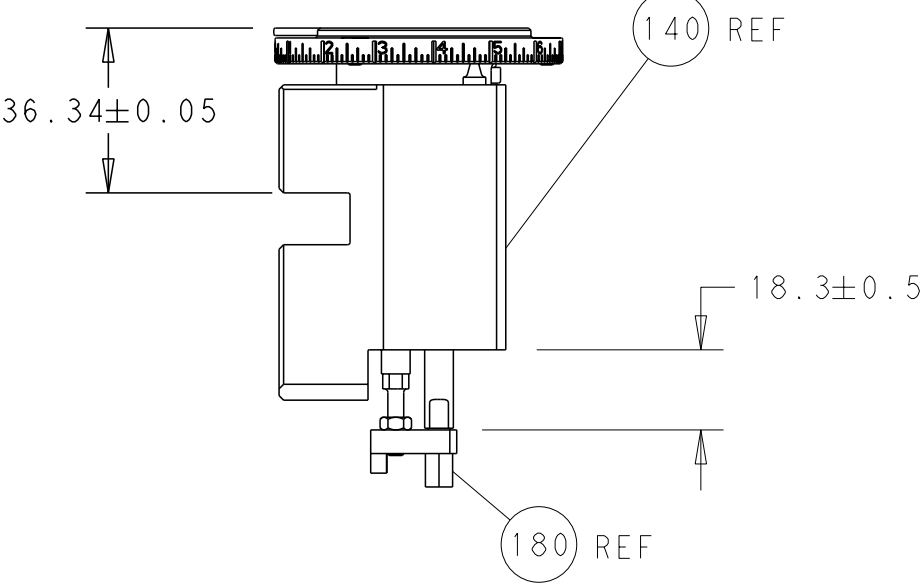
AIR FEED



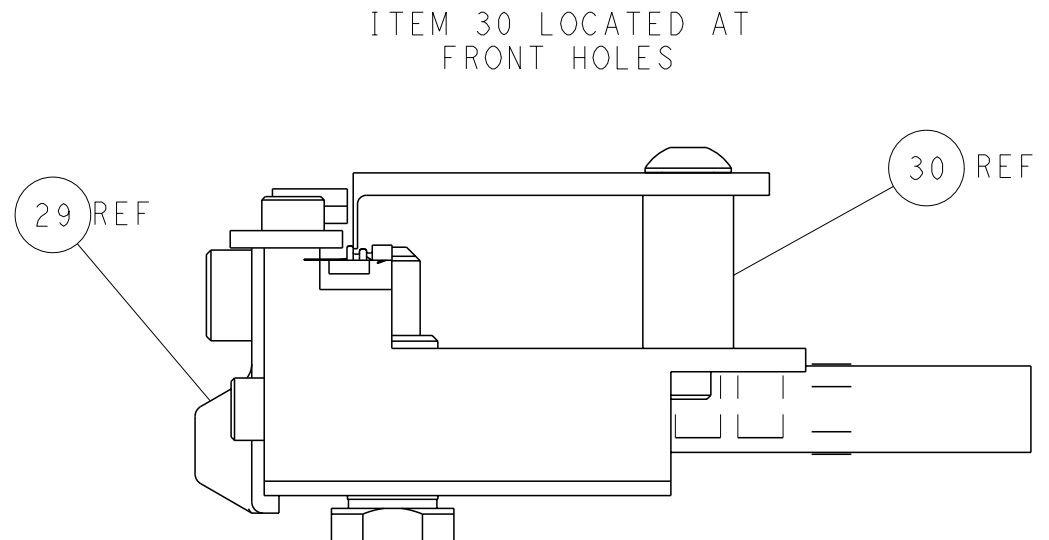
PACIFIC VERSION
Shown on sheets 3 of 4 & 4 of 4
(Atlantic version shown on sheets 1 of 4 & 2 of 4)



TERMINAL SUPPORT LOCATION



RAM AND HOLDDOWN SET-UP



FEED TRACK POSITION
GUIDE BY INSULATION BARREL

THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE AND TO CONTROL AND ENGINEERING DISCRETION. SHOULD BE CONTACTED FOR THE LATEST REVISION.		DWN T. BROOKS 17MAY2018	TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm		CHK R. KNEPPER 17MAY2018	NAME Ocean Side Feed Applicator	
TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH ±		APVD T. ELBIN 17MAY2018	PRODUCT SPEC	
MATERIAL			APPLICATION SPEC	
			SIZE	
			CAGE CODE	
			DRAWING NO	
			RESTRICTED TO	
			A1 00779 C=2837270	
			Customer Accessible Production Drawing	
			SCALE 1:2	
			SHEET 4 OF 4	
			REV D1	

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

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