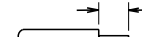


8		7	
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20		20	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2837060-1	D	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2837060-2	D	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2837060-1	D	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2837060-2	D	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2837060-7	A	CRIMP TOOLING KIT	-

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.93 mm [.076]	F
INSUL	1.93 mm [.076]	O
APPLICATOR INSTRUCTIONS 408-35042		

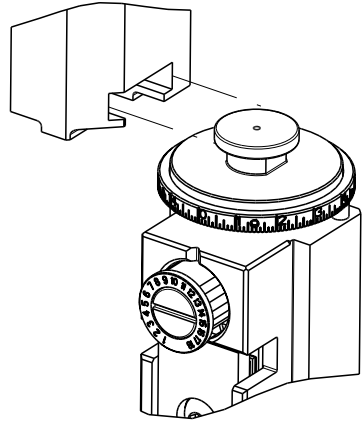
TERMINAL DATA: JAE TERMINAL		JAE CRIMP SPECIFICATION	
TERMINAL NAME: SOCKET CONTACT			
WIRE STRIP LENGTH			TERMINAL INSULATION DIAMETER RANGE
3.70-4.30 mm [.146-.169 IN]			Ø1.60-2.20 mm [.063-.087 IN]
TERMINAL APPLICATION SPECIFICATION	JABL-1728-4 Rev 1	-	-
		-	-
TERMINALS APPLIED			
			
TE TERMINAL	JAE TERMINAL	TE TERMINAL	JAE TERMINAL
1572618-1	M23S05K351		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.25mm2	1.28+/-0.05 [.050+/- .002]	5.3
0.85mm2	1.18+/-0.05 [.046+/- .002]	6.2
0.50mm2	1.13+/-0.05 [.044+/- .002]	6.6



- 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 LUBRICANT IS RECOMMENDED.
6. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.

ATLANTIC VERSION TERMINATOR
INTERFACE ADAPTER



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
			A	RELEASED		27SEP2018	RK	TE
			B	ECR-19-005143		30MAR2019	TB	CT
			C	ECR-19-017662		13NOV2019	JAH	RK
			D	ECR-21-123461		08DEC2021	FJ	RK

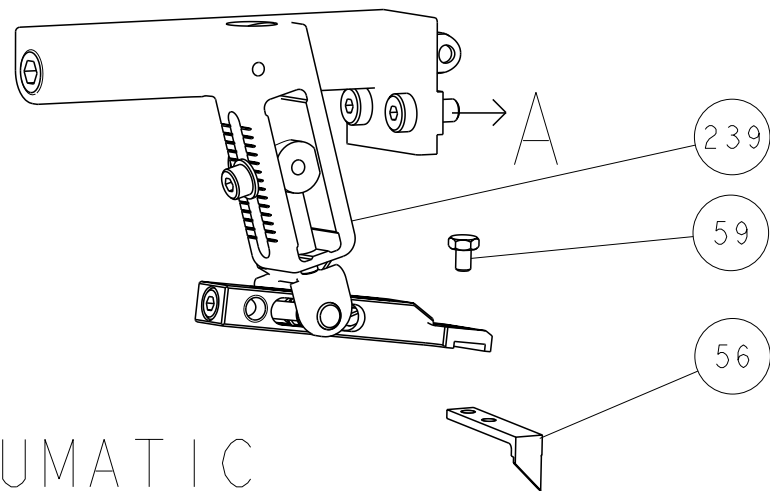
	-	1	-	1		2119641-1	FEED CAM, AIR FEED	248
	-	1	1	1	1	2119082-5	CAM, SNAIL, INSULATION ADJUSTMENT	244
	-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
3	-	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
	-	1	1	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
	-	-	1	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
	-	1	-	1	-	2844940-1	AIR FEED MODULE	238
5	-	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
	-	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	455888-4	SPACER, CRIMPER	82
	-	1	1	1	1	1803607-3	DOCUMENTATION PACKAGE	71
	-	1	1	1	1	2119791-5	DEPRESSOR, WIRE	70
	-	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	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
	-	1	1	1	1	1803382-6	HOLD DOWN, SPRING LOADED	50
	-	1	2	1	2	18023-9	SCR, SKT HD CAP M4 X 6.0	49
	-	-	1	-	1	2119652-1	FEED CAM, PRE FEED	48
	-	-	1	-	1	2119653-1	FEED CAM, POST FEED	47
	-	1	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	1752356-3	SUPPORT, TERMINAL	34
	-	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
	-	2	2	2	2	2-2844962-6	SPACER, CYLINDRICAL, STRIP GUIDE	30
	-	1	1	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29
	-	1	1	1	1	1320928-2	STRIP GUIDE	24
	-	1	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
	-	2	2	2	2	1-18028-2	WASHER, FLAT, REG M4	20
	-	1	1	1	1	2119533-1	STRIPPER, SIDE FEED	19
1	-	1	1	1	1	2119806-1	INSERT, SHEAR	13
	-	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	1803095-6	FLOATING SHEAR, FRONT	9
1	1	2	2	1	1	2-1803703-8	ANVIL, COMBINATION	8
	-	-	-	-	-	-	-	7
	-	-	-	-	-	-	-	6
	-	1	1	1	1	2119757-8	DEPRESSOR, SHEAR	5
	-	1	1	1	1	3-238011-1	BLOCK, CRIMPER SPACER	4
1	1	2	2	1	1	3-1803453-7	CRIMPER, INSULATION O	3
	-	-	-	-	-	-	-	2
1	1	2	2	1	1	1803766-2	CRIMPER, WIRE PREMIUM	1
	-77	-72	-71	-2	-1	PART NO	DESCRIPTION	ITEM NO

THE DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE AND TO BE CONTROLLED BY THE ENGINEERING ORGANIZATION. IT SHOULD BE CONTACTED FOR THE LATEST REVISION.				DWN R. KNEPPER 22-MAY-18	TE Connectivity Harrisburg, PA 17105-3608		
DIMENSIONS:				CHK T. BROOKENS 22-MAY-18	NAME		
mm				APVD J. DEGRANGE 22-MAY-18	PRODUCT SPEC		
					APPLICATION SPEC		
					SIZE		
					CAGE CODE		
					DRAWING NO		
					RESTRICTED TO		
MATERIAL					WEIGHT		
					A1 00779 ©=2837060		
					Customer Accessible Production Drawing		
					SCALE		
					1:2		
					SHEET		
					1 of 4		
					REV		
					D		

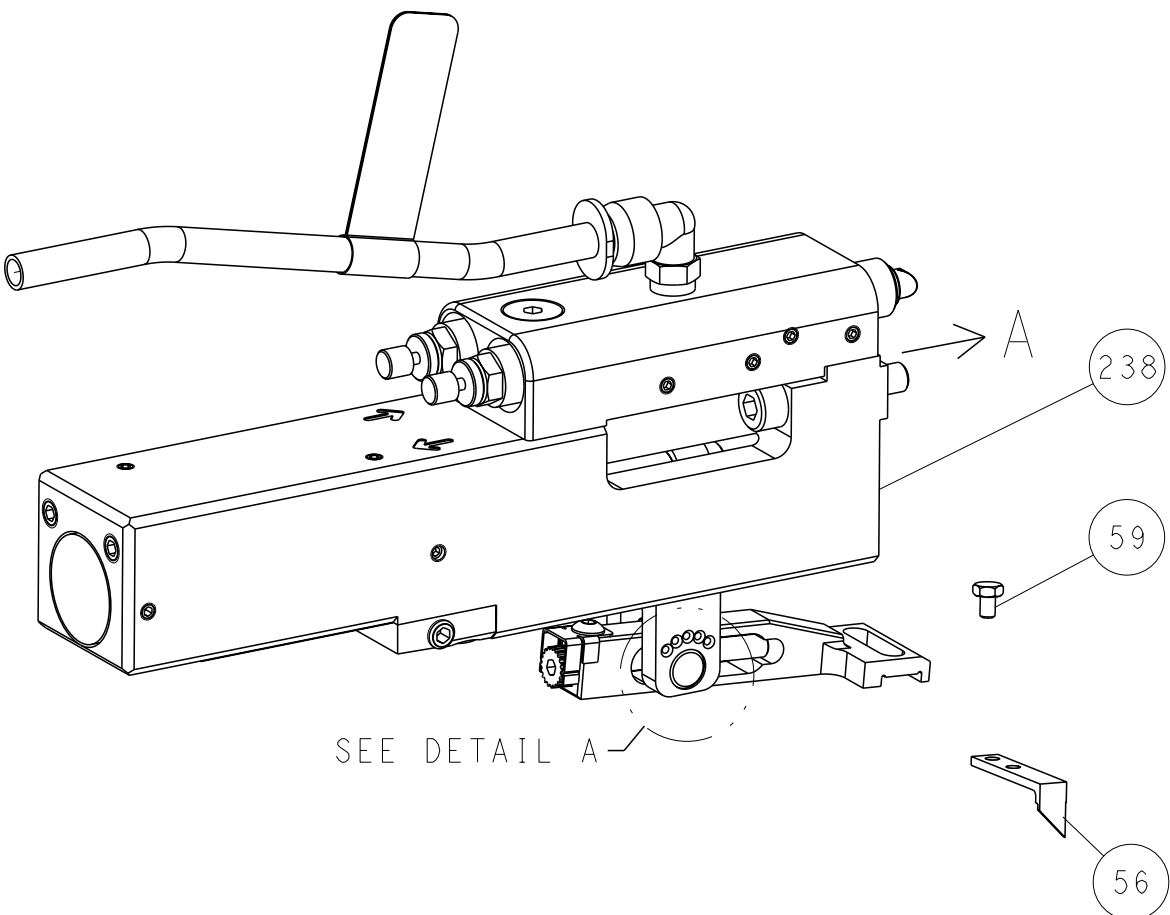
SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

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

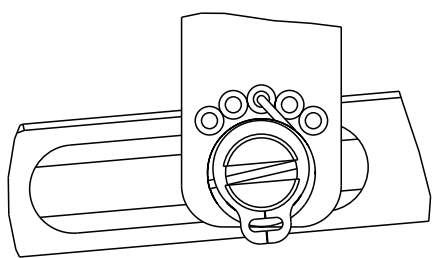
FEED TYPE MECHANICAL



PNEUMATIC

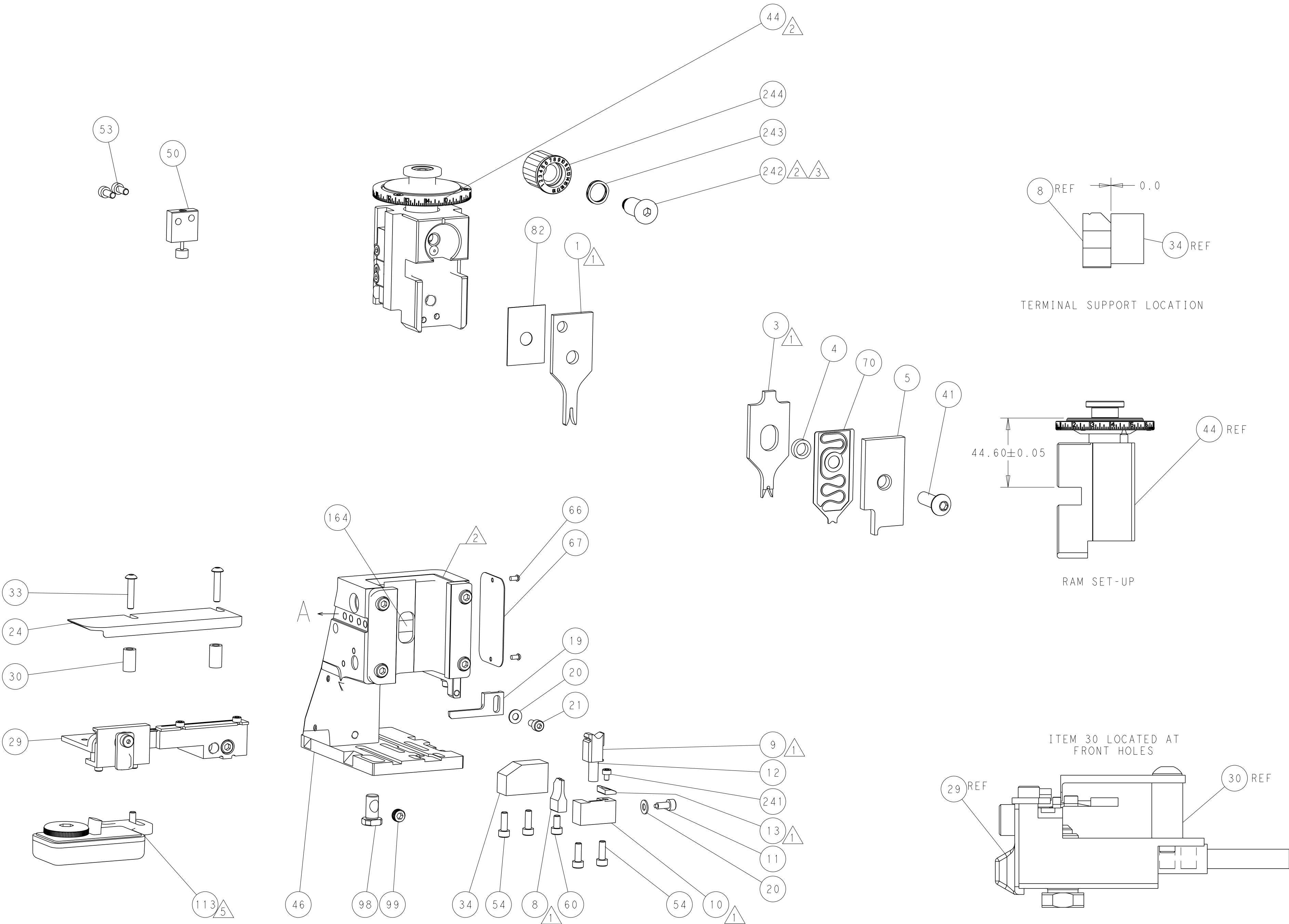
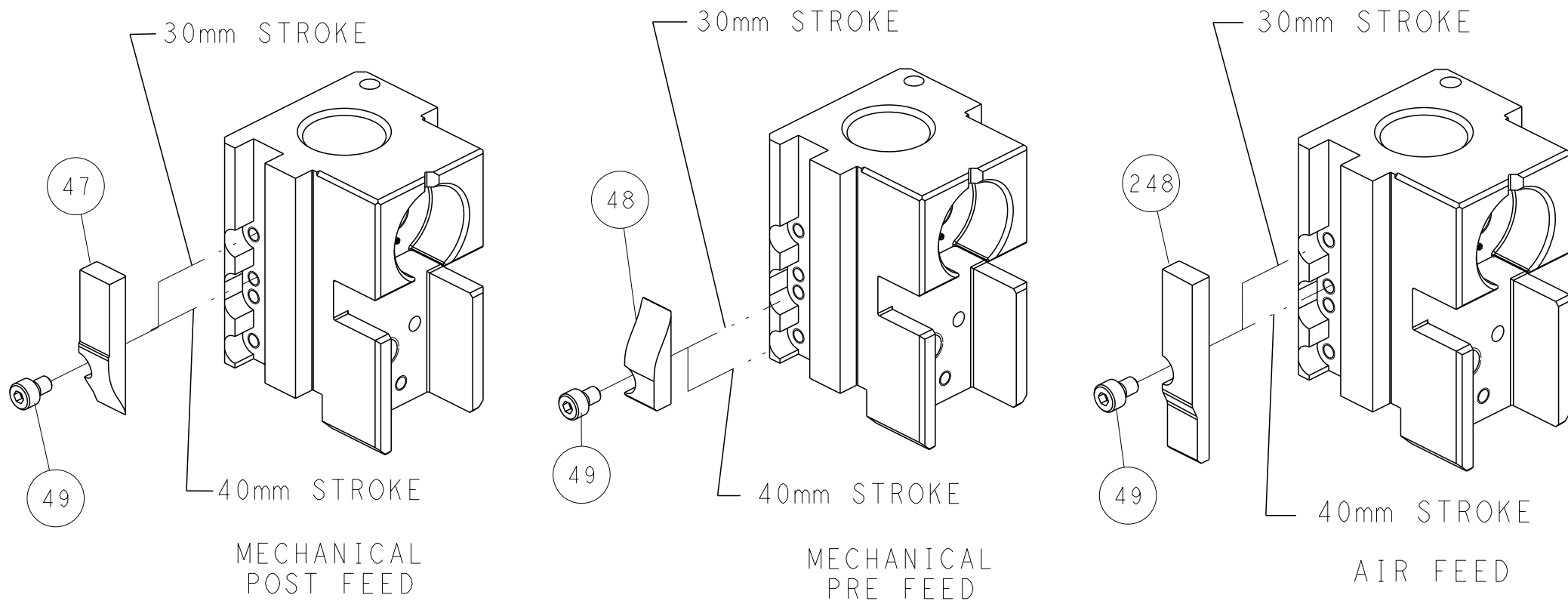


FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



DETAIL A

CAM POSITIONS

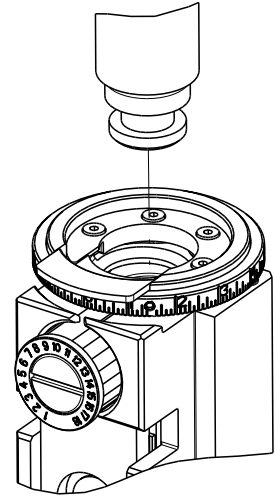


ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE AND TO THE CONTROL AND ENGINEERING ORGANIZATION. SHOULD BE CONTACTED FOR THE LATEST REVISION.		OWN R. KNEPPER 22-MAY-18	22-MAY-18	TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm		CHK T. BROOKENS 22-MAY-18	22-MAY-18	NAME Ocean Side Feed Applicator	
TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		APVD J. DEGRANGE	22-MAY-18	SIZE A1	
MATERIAL -		FINISH -		CAGE CODE 00779	
-		WEIGHT -		DRAWING NO C=2837060	
-		Customer Accessible Production Drawing		RESTRICTED TO -	
-		SCALE 1:2		SHEET 2 of 4	
-		REV D			

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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2837060-1	D	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2837060-2	D	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2837060-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.93 mm [.076]	F
INSUL	1.93 mm [.076]	O
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: JAE TERMINAL		JAE CRIMP SPECIFICATION	
TERMINAL NAME: SOCKET CONTACT			
WIRE STRIP LENGTH 3.70-4.30 mm [.146-.169 IN]		TERMINAL INSULATION DIAMETER RANGE Ø1.60-2.20 mm [.063-.087 IN]	
TERMINAL APPLICATION SPECIFICATION JABL-1728-4 Rev 1		-	
TERMINALS APPLIED		-	
TERMINALS APPLIED			
TE TERMINAL	JAE TERMINAL	TE TERMINAL	JAE TERMINAL
1572618-1	M23S05K351		

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING
1.25mm2		1.28+/-0.05 [.050+/- .002]		5.3
0.85mm2		1.18+/-0.05 [.046+/- .002]		6.2
0.50mm2		1.13+/-0.05 [.044+/- .002]		6.6



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 LUBRICANT IS RECOMMENDED.
6. 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)

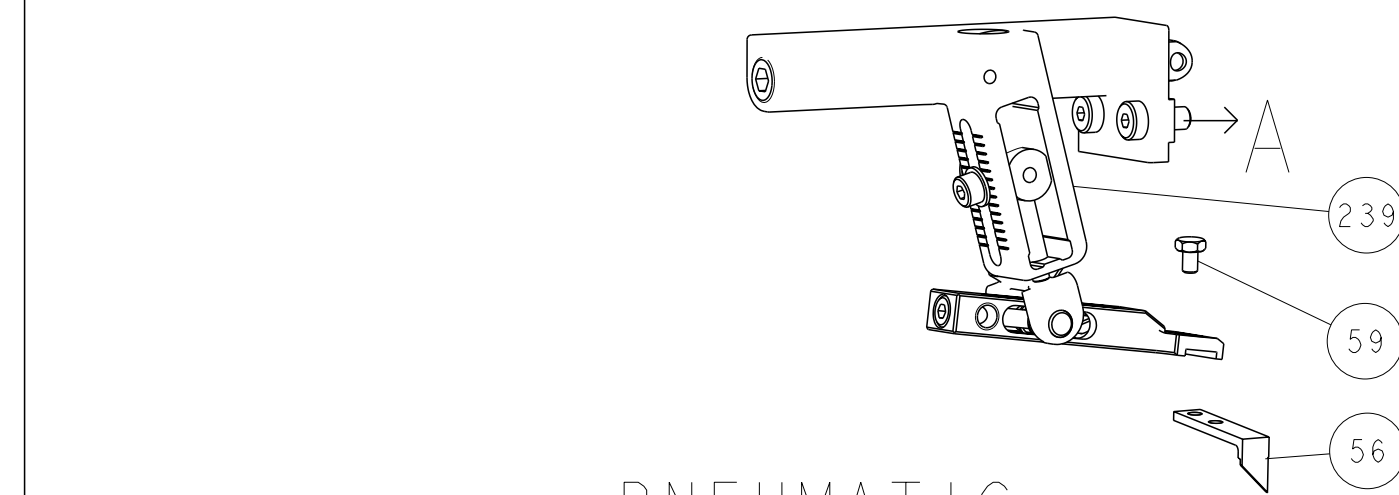
2		1						
LOC	DIST	REVISIONS						
A	66	P	LYR	DESCRIPTION	DATE	DWN	APVD	
		-		SEE SHEET 1	-	-	-	

-	1	1	2119082-5	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
3	-	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
-	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	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	2119653-2	FEED CAM, POST FEED	142
-	1	1	1-1803583-0	APPLICATOR BASIC ASSEMBLY, SF	141
-	1	1	1803516-1	RAM ASSEMBLY, SF PACIFIC	140
5	-	1	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113
-	1	1	2844908-1	SCREW, LOCKING	99
-	1	1	2844907-1	POST, LOCKING	98
-	1	1	455888-4	SPACER, CRIMPER	82
-	1	1	1803607-3	DOCUMENTATION PACKAGE	71
-	1	1	2119791-5	DEPRESSOR, WIRE	70
-	1	1	2119740-1	TAG, IDENTIFICATION	67
-	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	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	1	1803382-6	HOLD DOWN, SPRING LOADED	50
-	1	2	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	-	1	2119652-1	FEED CAM, PRE FEED	48
-	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
-	1	1	1752356-3	SUPPORT, TERMINAL	34
-	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	2-2844962-6	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29
-	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	1	1	2-1803703-8	ANVIL, COMBINATION	8
-	-	-	-	-	7
-	-	-	-	-	6
-	1	1	2119757-8	DEPRESSOR, SHEAR	5
-	1	1	3-238011-1	BLOCK, CRIMPER SPACER	4
1	1	1	3-1803453-7	CRIMPER, INSULATION O	3
-	-	-	-	-	2
1	1	1	1803766-2	CRIMPER, WIRE PREMIUM	1
-77	-22	-21	PART NO	DESCRIPTION	ITEM NO

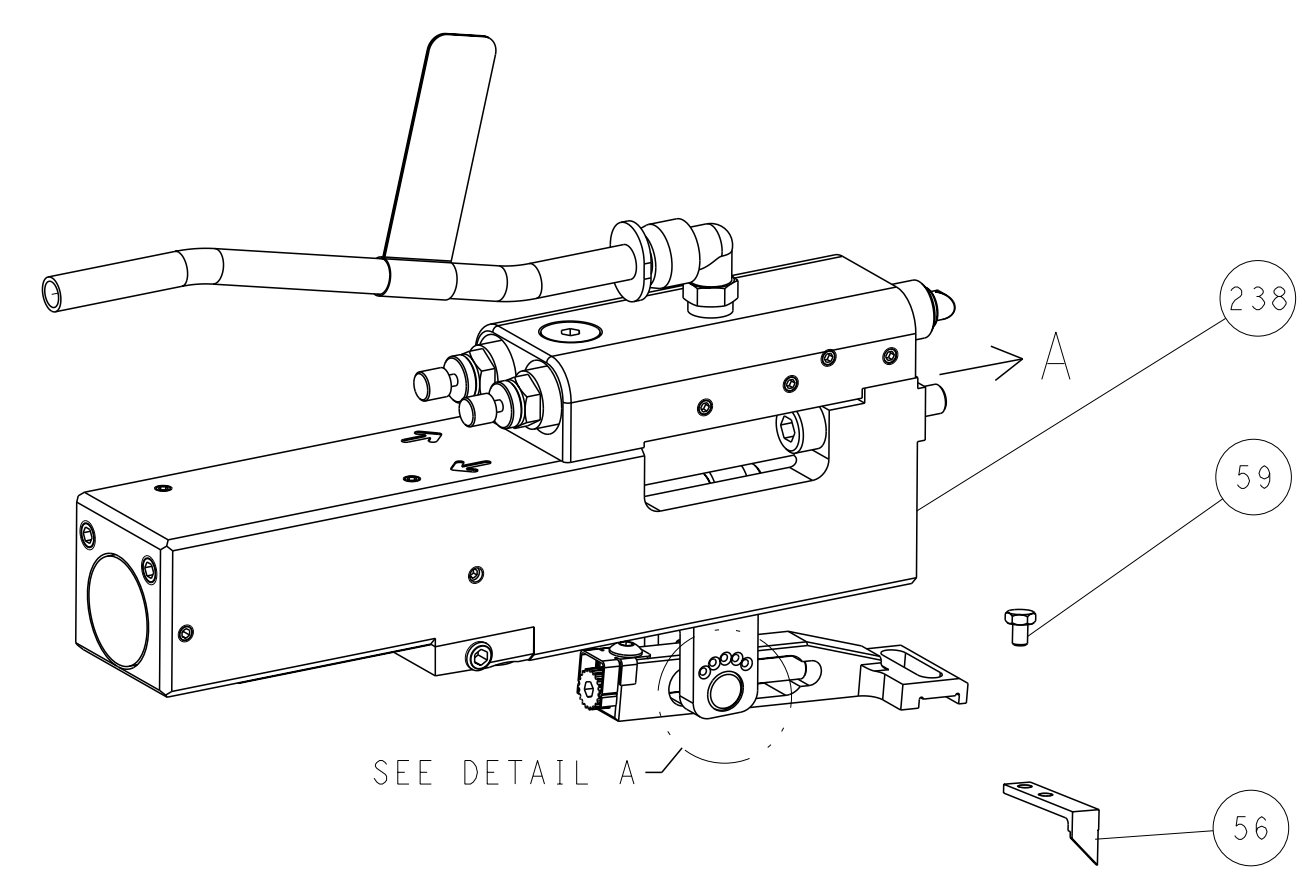
THIS DRAWING IS A CONTROLLED DOCUMENT FOR THE ELECTRONIC INDUSTRY. IT IS SUBJECT TO CHANGE AND TO THE EXTENT OF THE CHANGES, THE USER SHOULD BE CONTACTED FOR THE LATEST REVISION.		DWN R. KNEPPER 22-MAY-18	TE Connectivity Harrisburg, PA 17105-3608		
DIMENSIONS: mm		CHK T. BROOKENS 22-MAY-18	NAME Ocean Side Feed Applicator		
TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		APVD J. DEGRANGE 22-MAY-18	PRODUCT SPEC		
MATERIAL -		FINISH -	APPLICATION SPEC		
		WEIGHT -	SIZE A1		
		Customer Accessible Production Drawing	SCALE 1:2		
			SHEET 3		
			OF 4		
			REV D		

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

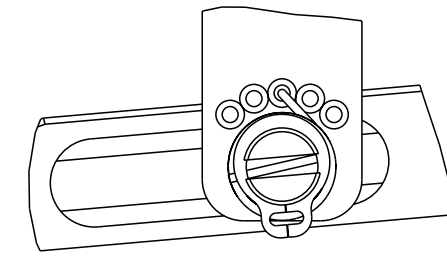
FEED TYPE MECHANICAL



PNEUMATIC

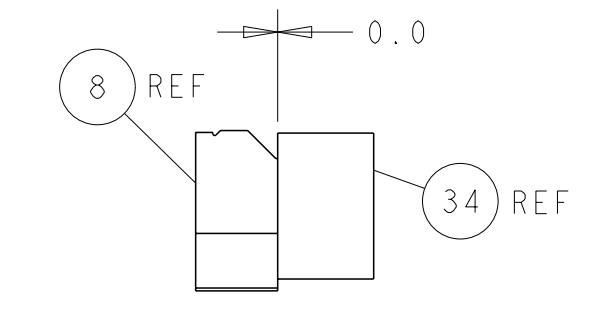
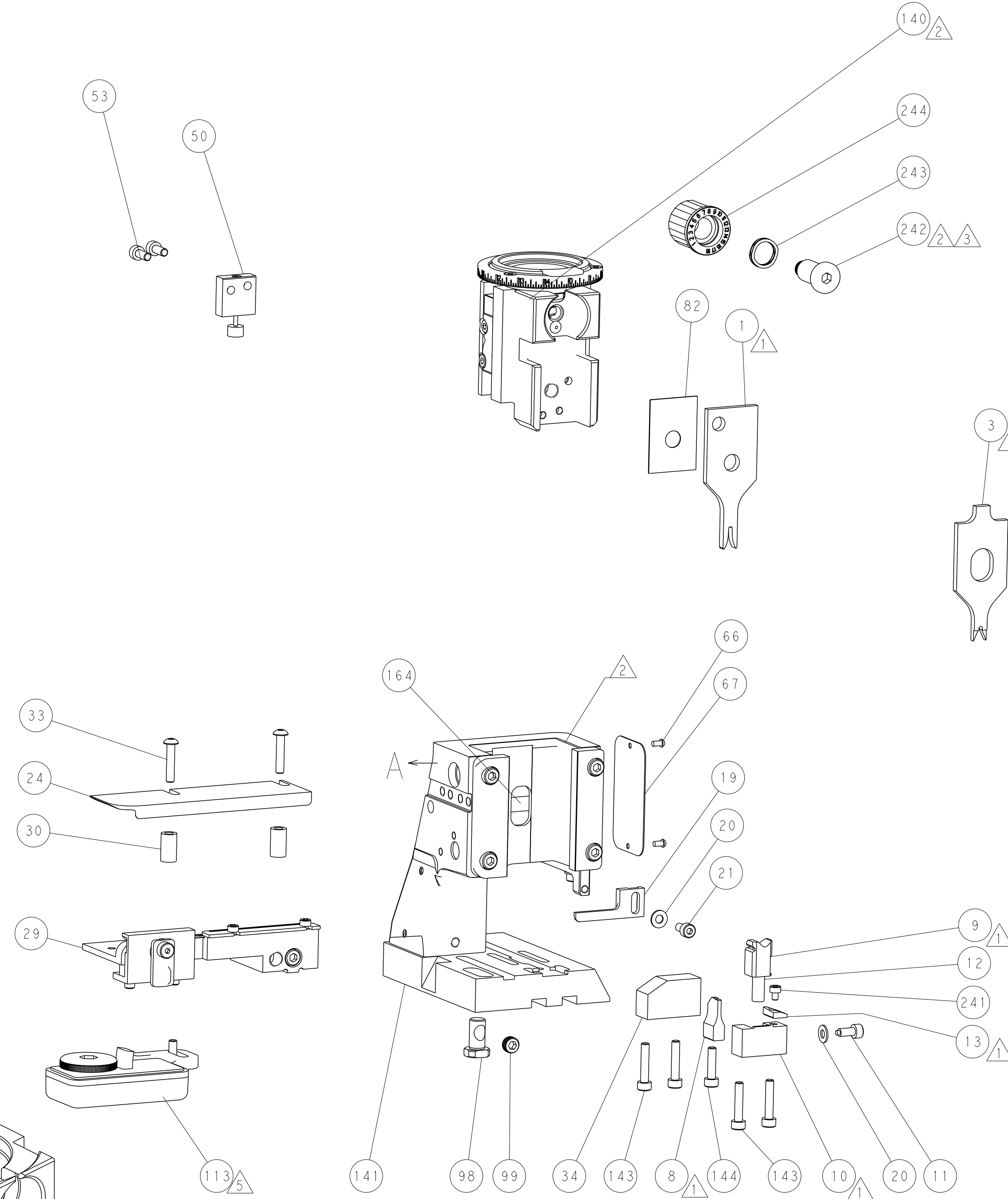
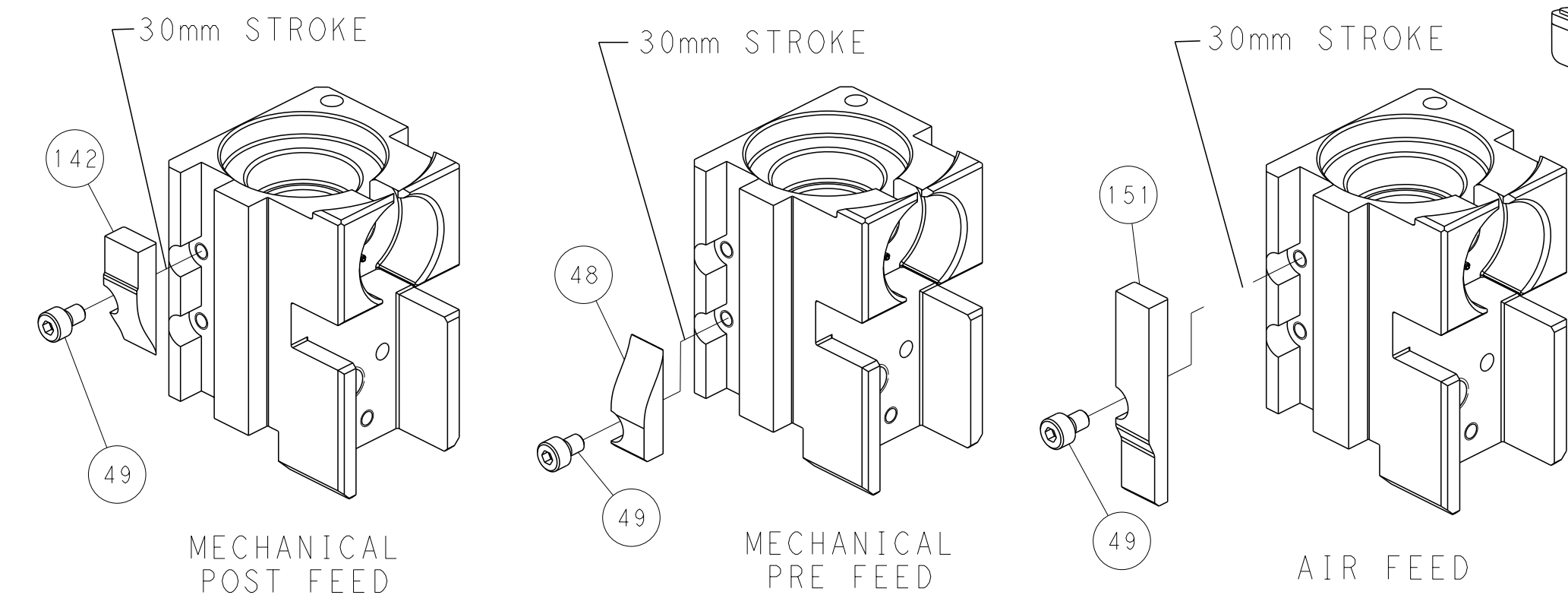


FEED SPRING SETTING POSITION
(SHOWN FROM REAR SIDE)

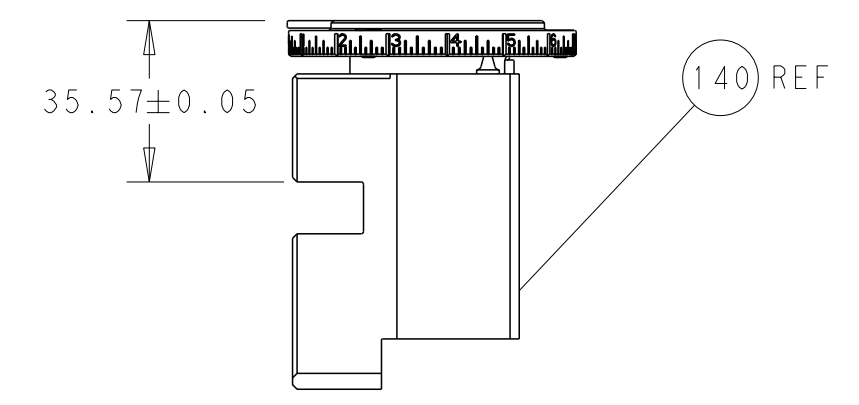


DETAIL A

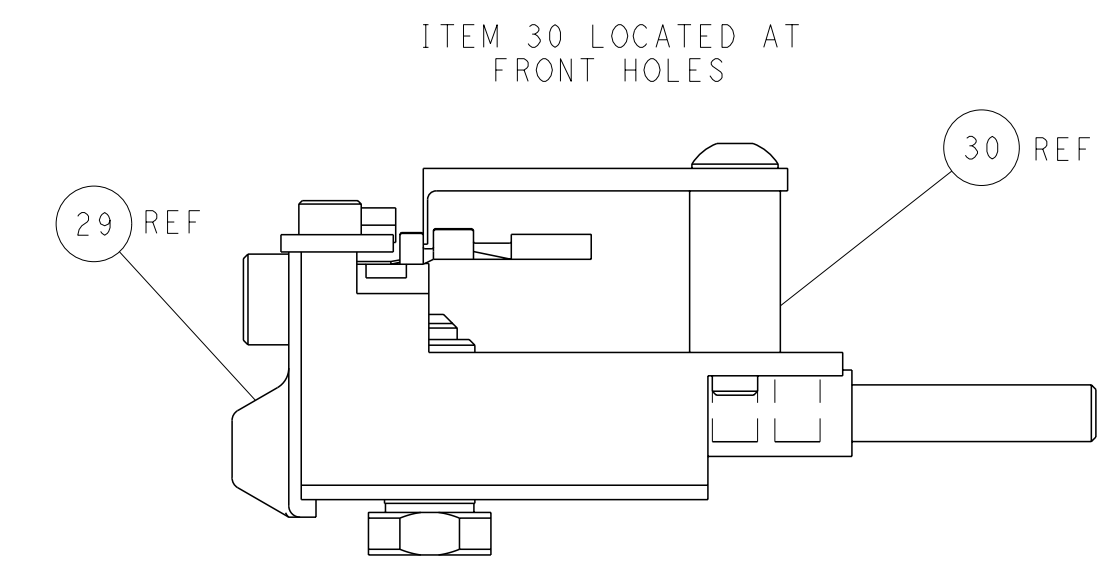
CAM POSITIONS



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)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		OWN		DATE		REV		NAME	
mm		0 PLC ±		R. KNEPPER		22-MAY-18		CM		T. BROOKS	
		1 PLC ±						APVD		J. DEGRANGE	
		2 PLC ±						PRODUCT SPEC			
		3 PLC ±						APPLICATION SPEC			
		4 PLC ±						WEIGHT		SIZE	
		ANGLES						-		CAGE CODE	
		FINISH						-		DRAWING NO	
								-		00779	
								Customer Accessible Production Drawing		SCALE	
								1:2		SHEET	
								4		OF	
								4		REV	
								D			

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