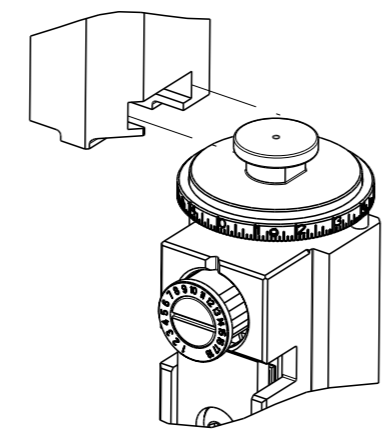


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2836377-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2836377-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2836377-1	C	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2836377-2	C	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2836377-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	0.80 mm [.031]	F
INSUL	0.80 mm [.031]	F

APPLICATOR INSTRUCTIONS 408-35042

TERMINAL DATA: MOLEX TERMINAL		MOLEX CRIMP SPECIFICATION	
TERMINAL NAME: 1.25 WIRE TO BOARD CONN. CRIMP RECEPTACLE			
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE		
1.30-1.70 mm [.051-.067 IN]	∅ 0.50-0.90 mm [.020-.035 IN]		
TERMINAL APPLICATION SPECIFICATION	ATS-639027900 Rev A		
TERMINALS APPLIED			
TE TERMINAL	MOLEX TERMINAL	TE TERMINAL	MOLEX TERMINAL
1949618-1	50641-8041	1949618-2	50641-8052
1949618-4	50641-8099		

TERMINAL DATA: MOLEX TERMINAL		MOLEX CRIMP SPECIFICATION	
TERMINAL NAME: 1.25 WIRE TO BOARD CONN. CRIMP RECEPTACLE			
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE		
1.30-1.70 mm [.051-.067 IN]	∅ 0.50-0.90 mm [.020-.035 IN]		
TERMINAL APPLICATION SPECIFICATION	ATS-639027900 Rev A		
TERMINALS APPLIED			
TE TERMINAL	MOLEX TERMINAL	TE TERMINAL	MOLEX TERMINAL
1949618-3	50753-8041	1949618-5	50753-8099

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
26 AWG	0.65 +/- 0.025 [.025 +/- .001]	6.4
28 AWG	0.60 +/- 0.025 [.024 +/- .001]	6.8
30 AWG	0.57 +/- 0.025 [.023 +/- .001]	7.2

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
30 AWG	0.50 +/- 0.025 [.019 +/- .001]	8.8
32 AWG	0.47 +/- 0.025 [.019 +/- .001]	9.0

- 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. 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					
		#	LY#	DESCRIPTION	DATE	OWN	APVD
A	66	1		DEVELOPMENT	07JUL2016	JH	LZ
		A		RELEASED	11AUG2016	JH	TE
		B		ECR-17-013836	19SEP2017	JAH	TE
		C		ECR-19-013734	03SEP2019	FJ	TE

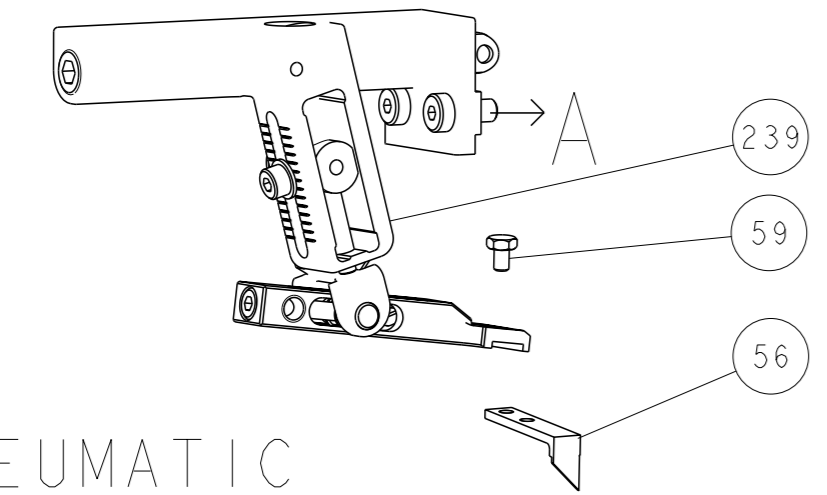
-	1	1	1	1	455888-3	SPACER, CRIMPER	270
-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248
-	1	1	1	1	2119082-1	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	1	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
-	-	1	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	1	-	1	-	2844940-1	AIR FEED MODULE	238
-	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	1	1	1	1	2844908-1	SCREW, LOCKING	99
-	1	1	1	1	2844907-1	POST, LOCKING	98
-	1	1	1	1	1-455888-7	SPACER, CRIMPER	82
-	1	1	1	1	1803607-3	DOCUMENTATION PACKAGE	71
-	1	1	1	1	1-2119791-4	DEPRESSOR, WIRE	70
-	1	1	1	1	2119943-1	WASHER, SPACER	69
-	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
-	2	2	2	2	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	54
-	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
-	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	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	2119533-4	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	1-356885-4	STOP, SHEAR	11
-	1	1	1	1	2119805-1	SHEAR HOLDER, FRONT	10
-	1	1	1	1	1803095-3	FLOATING SHEAR, FRONT -	9
-	1	2	2	1	1-1803318-6	ANVIL, COMBINATION	8
-	-	-	-	-	-	-	7
-	-	-	-	-	-	-	6
-	1	1	1	1	2119757-1	DEPRESSOR, SHEAR	5
-	1	1	1	1	2-238011-8	BLOCK, CRIMPER SPACER	4
-	1	2	2	1	1803260-7	CRIMPER, INSULATION F PREMIUM	3
-	1	1	1	1	455888-5	SPACER, CRIMPER	2
-	1	2	2	1	1-1333281-8	CRIMPER, WIRE PREMIUM	1
-	77	72	71	-2	-1	PART NO	ITEM NO

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

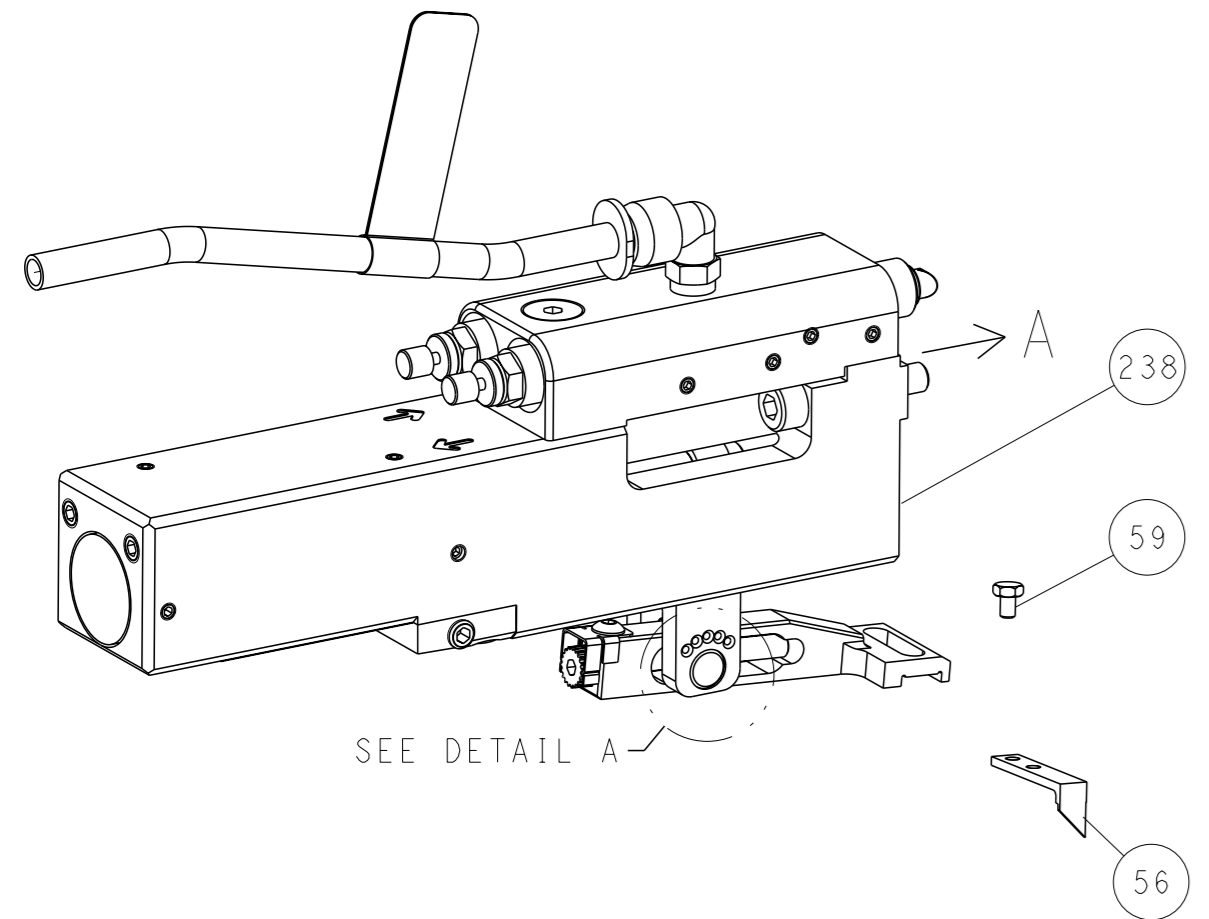
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		APPROVED:		NAME:	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES ±	FINISH ±
MATERIAL:		FINISH:		WEIGHT:		SCALE:	
Customer Accessible Production Drawing		SCALE: 1:2		SHEET 1 of 4		REV C	

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

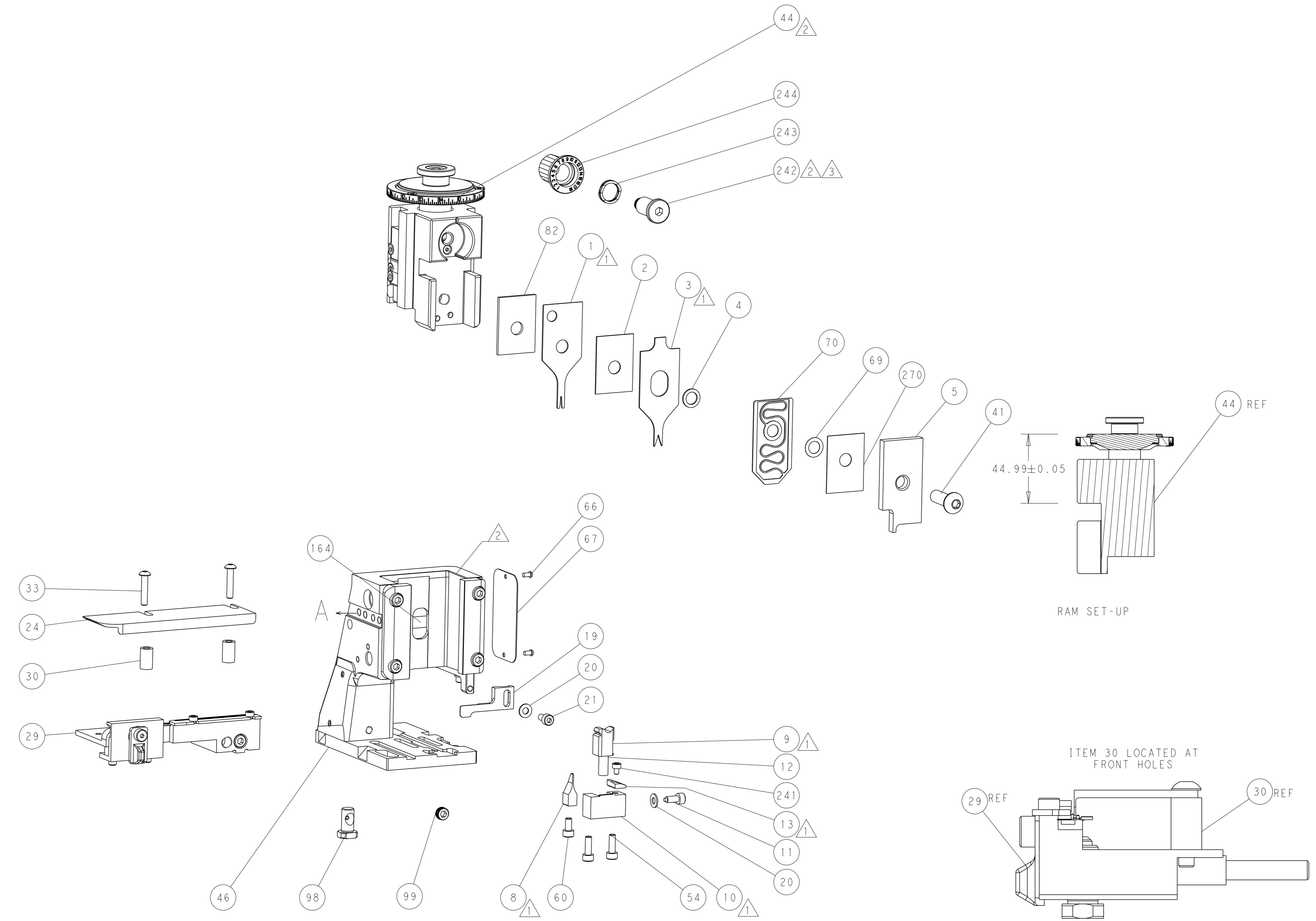
FEED TYPE MECHANICAL



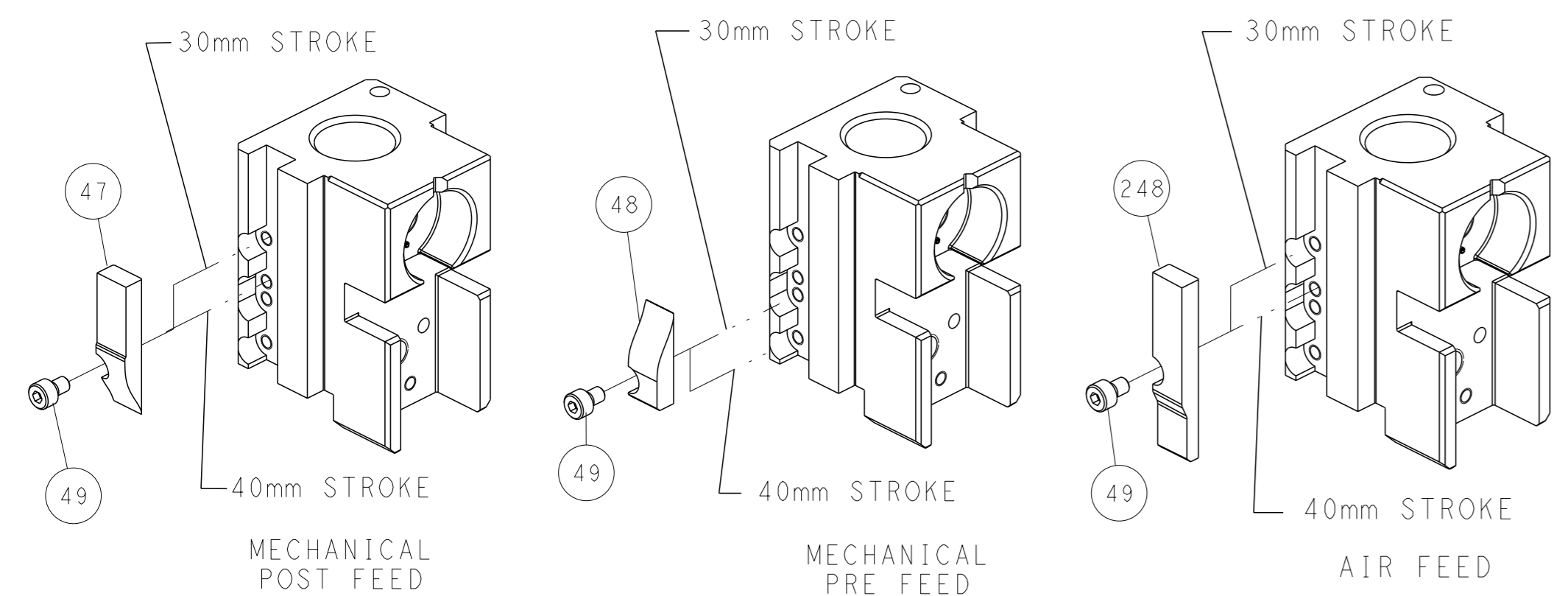
PNEUMATIC



FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



CAM POSITIONS

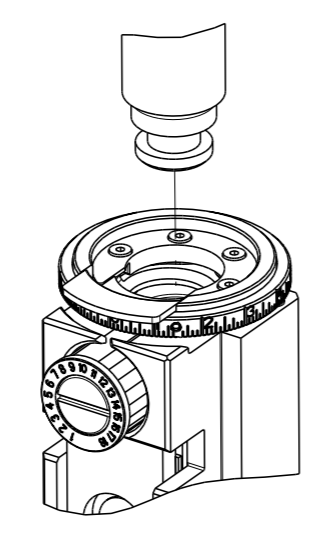


ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

<small>THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE AND TO CONTROLING ENGINEERING DISCRETION. SHOULD BE CONTACTED FOR THE LATEST REVISION.</small>		OWN: J. HOU 07JUL2016 CHK: L. ZHANG 07JUL2016 APVD: L. ZHANG 07JUL2016	NAME: TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH ±	MATERIAL:	PRODUCT SPEC: APPLICATION SPEC: WEIGHT:	SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2836377 RESTRICTED TO:
Customer Accessible Production Drawing		SCALE: 1:2	SHEET 2 of 4 REV C

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2836377-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2836377-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2836377-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	0.80 mm [.031]	F
INSUL	0.80 mm [.031]	F

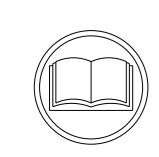
APPLICATOR INSTRUCTIONS
408-35042

TERMINAL DATA: MOLEX TERMINAL		MOLEX CRIMP SPECIFICATION	
TERMINAL NAME: 1.25 WIRE TO BOARD CONN. CRIMP RECEPTACLE			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
1.30-1.70 mm [.051-.067 IN]		∅ 0.50-0.90 mm [.020-.035 IN]	
TERMINAL APPLICATION SPECIFICATION	ATS-639027900 Rev A	-	-
TERMINALS APPLIED			
TE TERMINAL	MOLEX TERMINAL	TE TERMINAL	MOLEX TERMINAL
1949618-1	50641-8041	1949618-2	50641-8052
1949618-4	50641-8099		

TERMINAL DATA: MOLEX TERMINAL		MOLEX CRIMP SPECIFICATION	
TERMINAL NAME: 1.25 WIRE TO BOARD CONN. CRIMP RECEPTACLE			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
1.30-1.70 mm [.051-.067 IN]		∅ 0.50-0.90 mm [.020-.035 IN]	
TERMINAL APPLICATION SPECIFICATION	ATS-639027900 Rev A	-	-
TERMINALS APPLIED			
TE TERMINAL	MOLEX TERMINAL	TE TERMINAL	MOLEX TERMINAL
1949618-3	50753-8041	1949618-5	50753-8099

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
26 AWG	0.65+/-0.025 [.025+/- .001]	6.4
28 AWG	0.60+/-0.025 [.024+/- .001]	6.8
30 AWG	0.57+/-0.025 [.023+/- .001]	7.2

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
30 AWG	0.50+/-0.025 [.019+/- .001]	8.8
32 AWG	0.47+/-0.025 [.019+/- .001]	9.0



- 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. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.

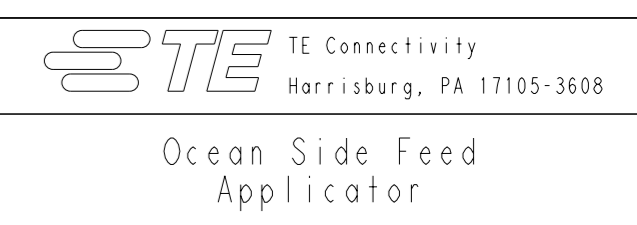
***WARNING**
ON INSTALLATION, SET WIRE DISC TO CRIMP HEIGHT REFERENCE SETTING FOR LARGEST WIRE SIZE. CRIMP HEIGHT REFERENCE SETTINGS GREATER THAN THE VALUE SHOWN MAY CAUSE DAMAGE TO THE CRIMP TOOLING, REFER TO THE INSTRUCTION SHEET FOR PROPER SETUP AND ADJUSTMENTS.

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

-	1	1	455888-3	SPACER, CRIMPER	270
-	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	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
-	2	2	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
-	1	1	2844908-1	SCREW, LOCKING	99
-	1	1	2844907-1	POST, LOCKING	98
-	1	1	1-455888-7	SPACER, CRIMPER	82
-	1	1	1803607-3	DOCUMENTATION PACKAGE	71
-	1	1	1-2119791-4	DEPRESSOR, WIRE	70
-	1	1	2119943-1	WASHER, SPACER	69
-	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
-	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
-	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	2-2844962-3	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	2119533-4	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	1803095-3	FLOATING SHEAR, FRONT	9
1	1	1	1-1803318-6	ANVIL, COMBINATION	8
-	-	-	-	-	7
-	-	-	-	-	6
-	1	1	2119757-1	DEPRESSOR, SHEAR	5
-	1	1	2-238011-8	BLOCK, CRIMPER SPACER	4
1	1	1	1803260-7	CRIMPER, INSULATION F PREMIUM	3
-	1	1	455888-5	SPACER, CRIMPER	2
1	1	1	1-1333281-8	CRIMPER, WIRE PREMIUM	1

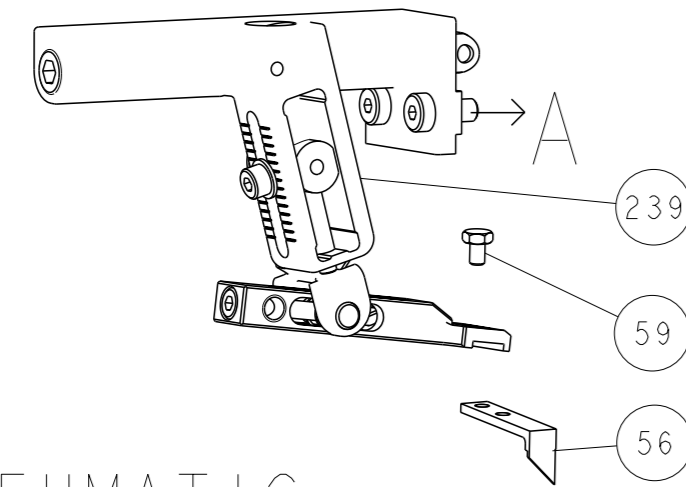
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		OWN	CHK	APVD	DATE	NAME	SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO		
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	FINISH	ANGLES	APPLICATOR SPEC	APPLICATOR SPEC	WEIGHT	SCALE	SHEET	OF	REV
											1:2	3	4	C



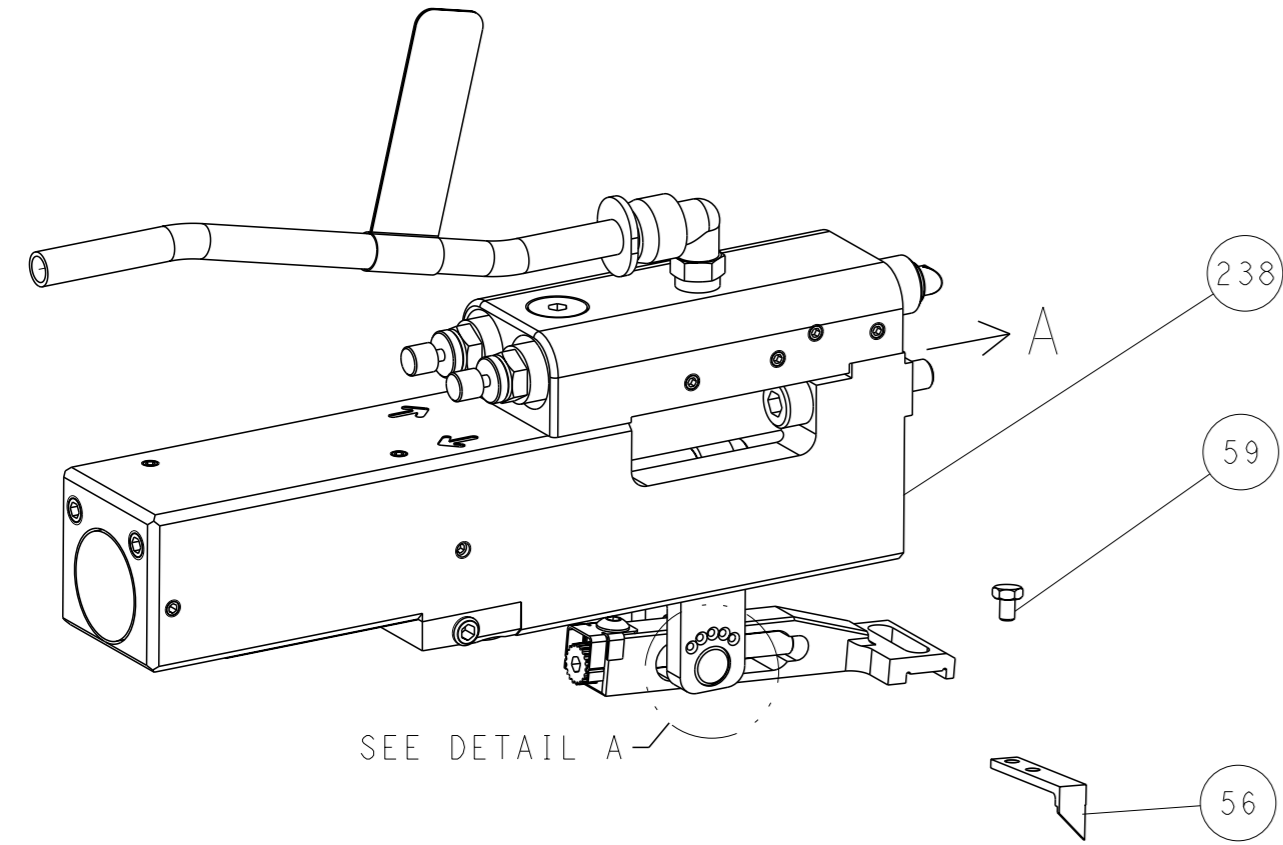
Ocean Side Feed
Applicator

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

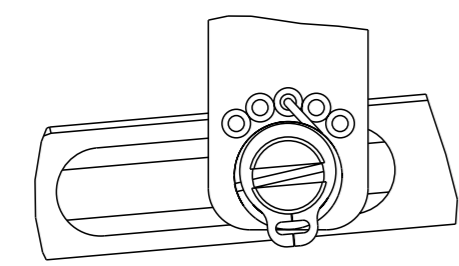
FEED TYPE MECHANICAL



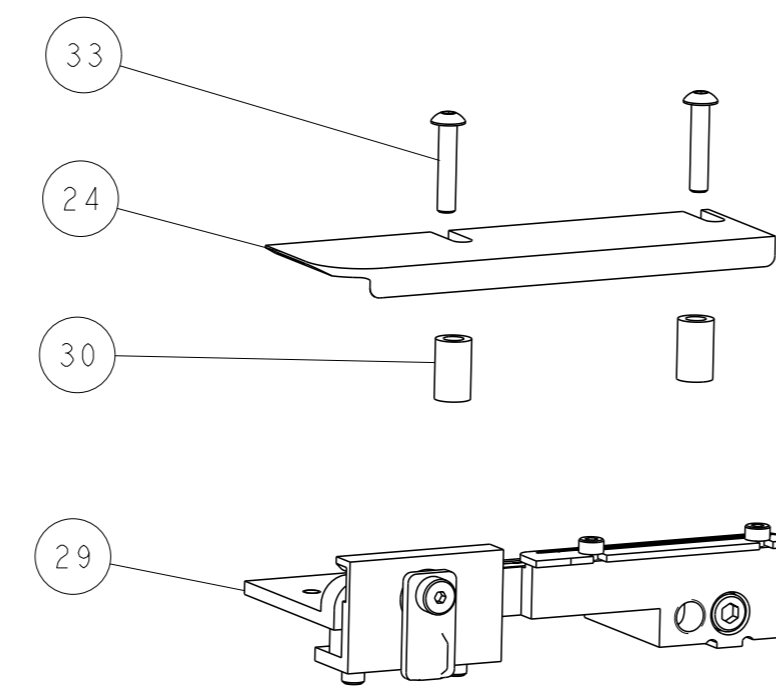
PNEUMATIC



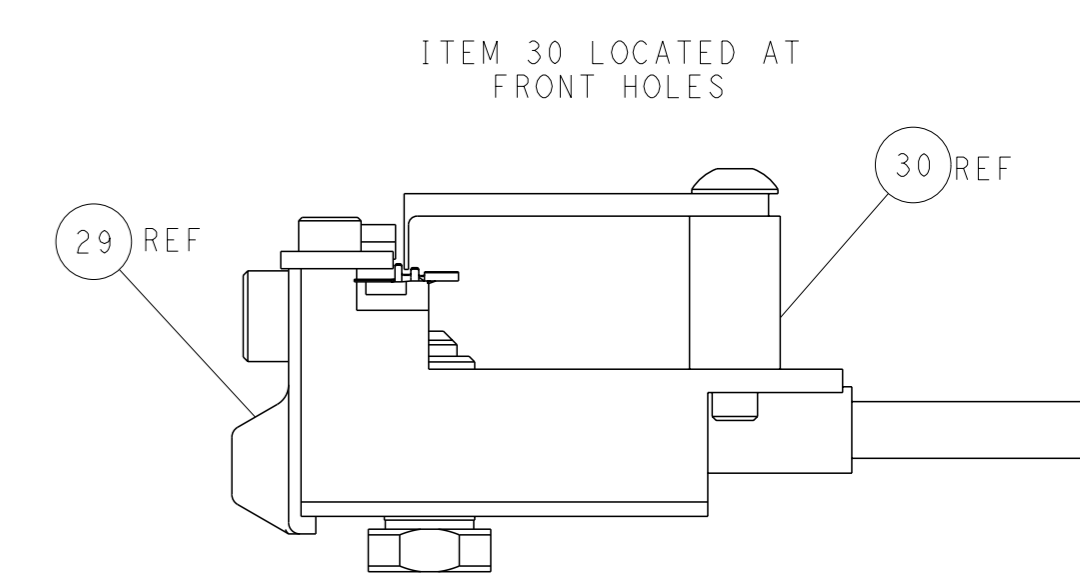
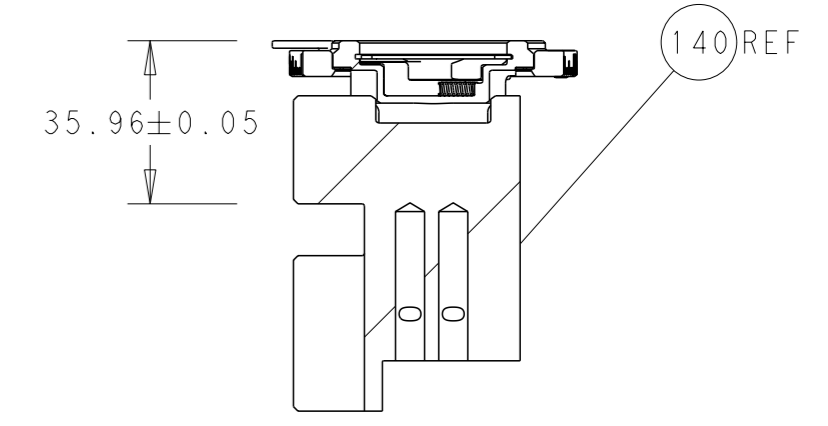
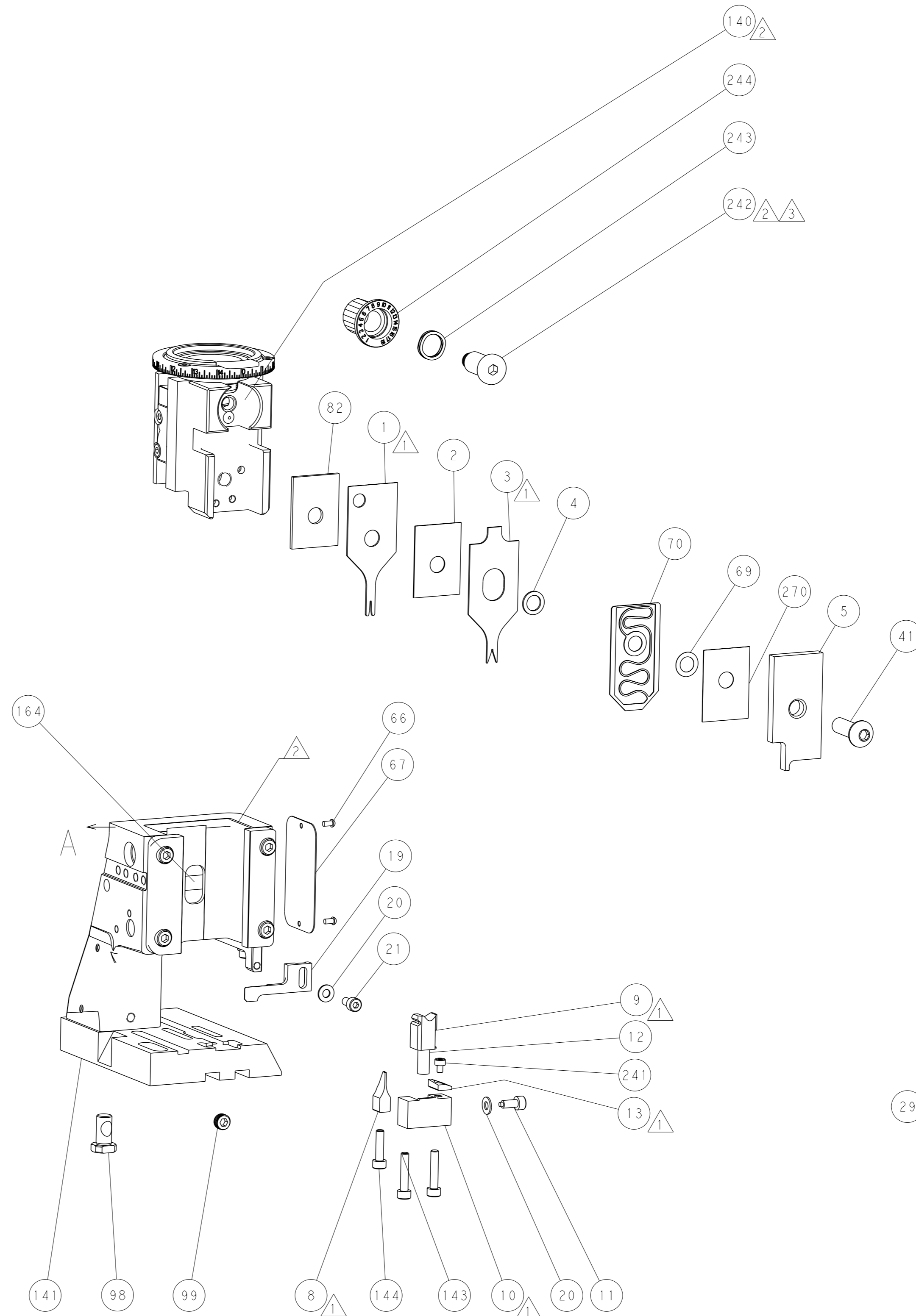
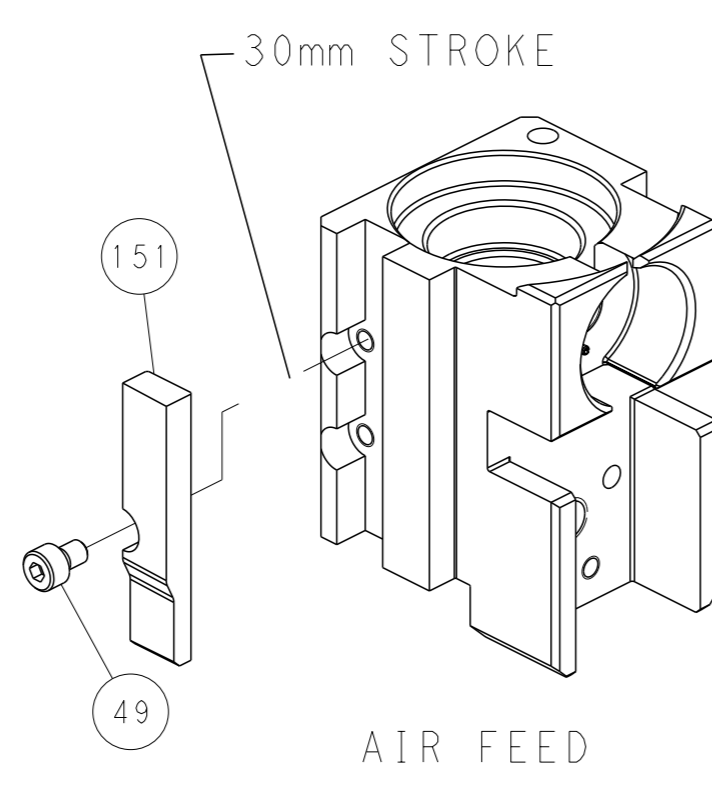
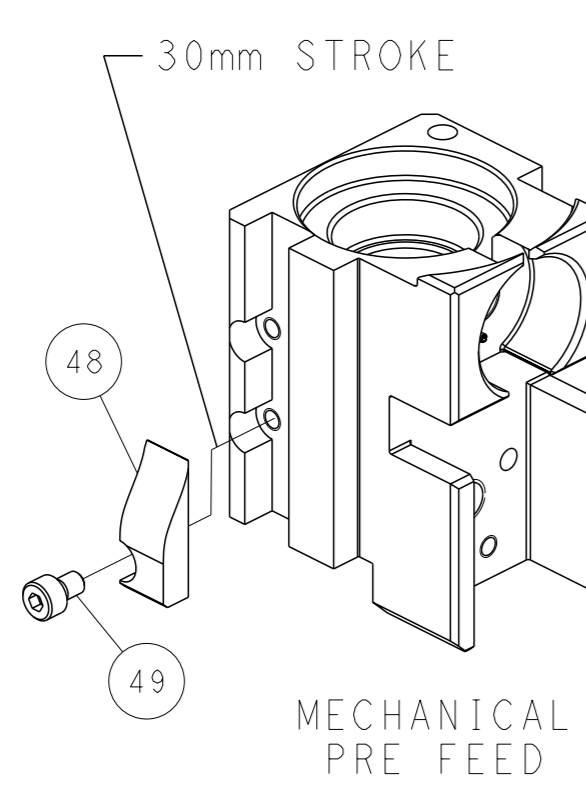
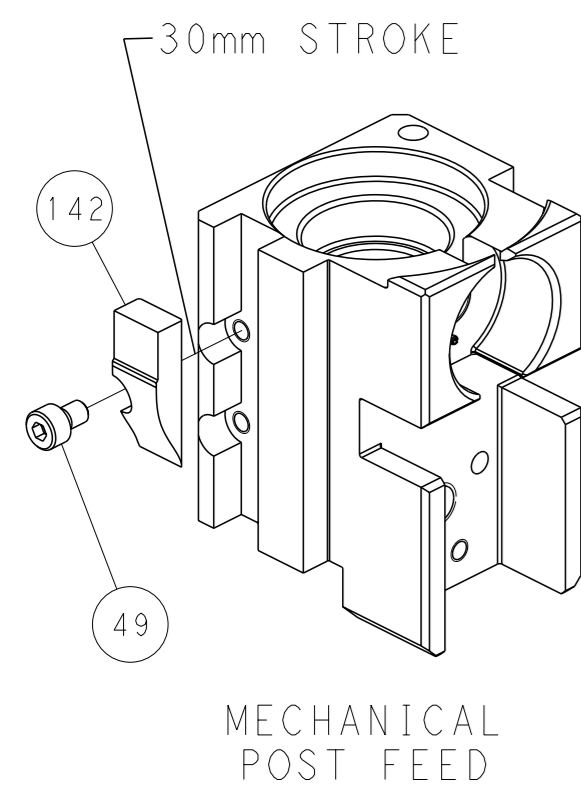
FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



DETAIL A



CAM POSITIONS



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 CONTROL AND EXISTING DISPOSITION SHOULD BE CONTACTED FOR THE LATEST REVISION.</small>		OWN: J. HOU 07JUL2016 CHK: L. ZHANG 07JUL2016 APVD: L. ZHANG 07JUL2016	NAME: TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH ±	APPLICATION SPEC PRODUCT SPEC RESTRICTED TO	SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2836377	SCALE: 1:2 SHEET: 4 of 4 REV: C
MATERIAL:		WEIGHT: Customer Accessible Production Drawing	