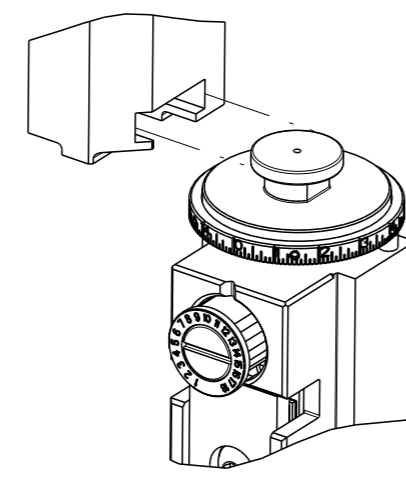


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2837114-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2837114-2	B	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2837114-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER

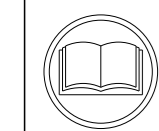


APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.30 mm [.091]	F
INSUL	3.70 mm [.146]	OV

APPLICATOR INSTRUCTIONS
408-35042

TERMINAL DATA: YAZAKI TERMINAL YAZAKI CRIMP SPECIFICATION			
TERMINAL NAME: M TYPE TERMINAL			
WIRE STRIP LENGTH		TERMINAL INSULATION DIAMETER RANGE	
5.00-6.00 mm [.197-.236 IN]		Ø1.75-2.25 mm [.069-.089 IN]	
TERMINAL APPLICATION SPECIFICATION		72-WT10-1718 Rev WA2080	
TERMINALS APPLIED			
TE TERMINAL	YAZAKI TERMINAL	TE TERMINAL	YAZAKI TERMINAL
3311085-1	7116-2928-02	3311085-2	7116-2991-02

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.25mm ²	1.35 +/- 0.05 [1.053 +/- .002]	5.3
1.00mm ²	1.25 +/- 0.05 [1.049 +/- .002]	6.4
0.75mm ²	1.25 +/- 0.05 [1.049 +/- .002]	6.2



- 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.
- 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)

LOC	DIST	REVISIONS					
		#	LY#	DESCRIPTION	DATE	OWN	APVD
A	66	A		RELEASED	28FEB2018	RK	GB
		A1		ECR-18-009972	27JUN2018	MZ	KZ
		B		ECR-20-016091	11NOV2020	LG	RR

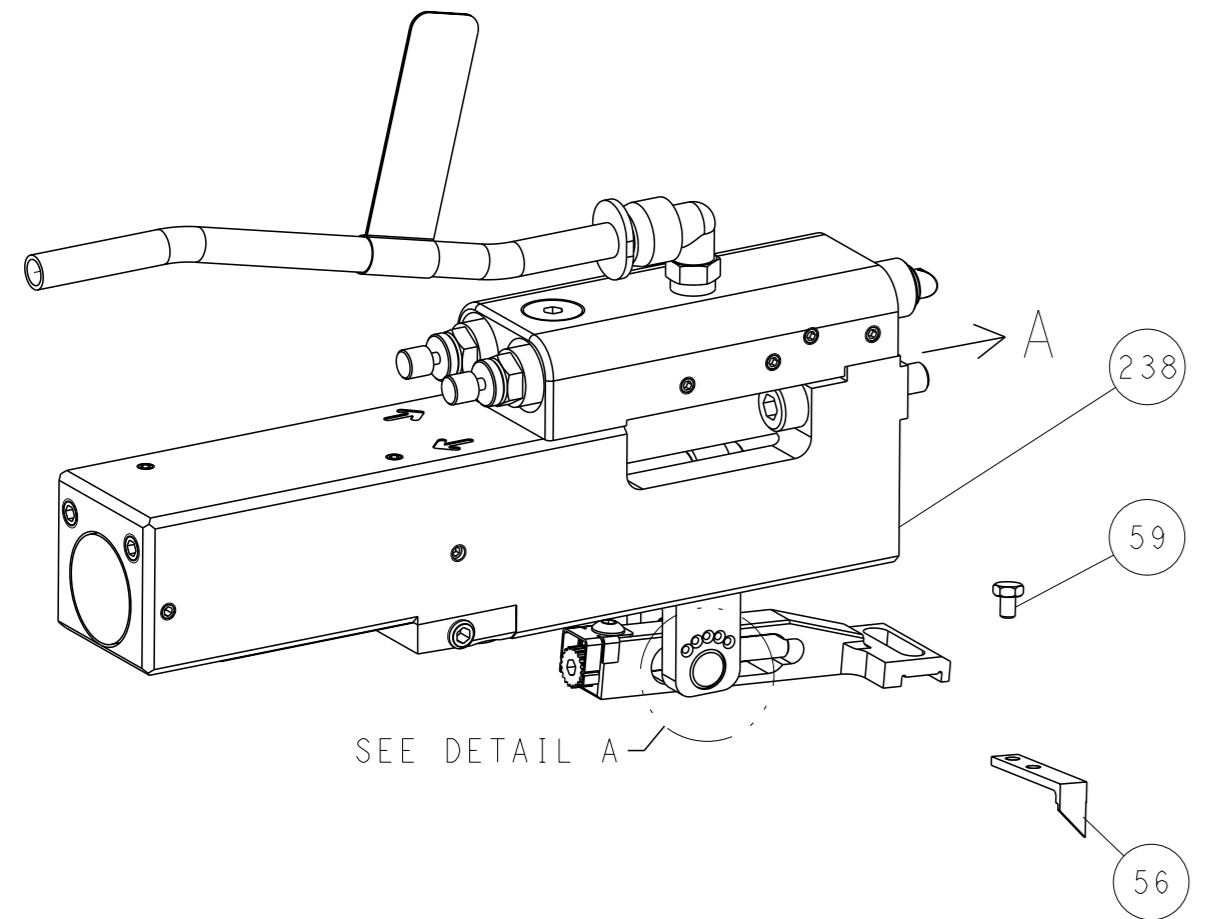
-	1	1	2119641-1	FEED CAM, AIR FEED	248
-	1	1	2119082-4	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
-	1	1	2844940-2	AIR FEED MODULE	238
-	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	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	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	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	53
-	1	1	1803382-2	HOLD DOWN, SPRING LOADED	50
-	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	2-1752356-0	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	2	1-1803335-1	ANVIL, COMBINATION	8
-	-	-	-	-	7
-	-	-	-	-	6
-	1	1	2119757-8	DEPRESSOR, SHEAR	5
-	1	1	3-238011-5	BLOCK, CRIMPER SPACER	4
-	1	2	1-1803199-2	CRIMPER, INSULATION OVERLAP PREMIUM	3
-	1	1	455888-8	SPACER, CRIMPER	2
-	1	2	4-1803241-3	CRIMPER, WIRE F	1
-	77	72	-2	PART NO	
-				DESCRIPTION	ITEM NO

<small>THE DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE AND THE CUSTOMER'S RESPONSIBILITY TO VERIFY THE DIMENSIONS AND TOLERANCES SHOWN ON THIS DRAWING. DIMENSIONS SHOULD BE CONTACTED FOR THE LATEST REVISION.</small>		OWN: K. HUANG 07FEB2018 CHK: K. HUANG 07FEB2018 APVD: L. ZHANG 07FEB2018	TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH ±		TOLERANCES UNLESS OTHERWISE SPECIFIED: ± ± ± ± ±	NAME: Ocean Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2837114 RESTRICTED TO: - SCALE: 1:2 SHEET: 1 of 4 REV: B
MATERIAL: -		WEIGHT: -	Customer Accessible Production Drawing

LOC	DIST	REVISIONS			
		REV	DATE	OWN	APVD
A	66	1	SEE SHEET 1	-	-

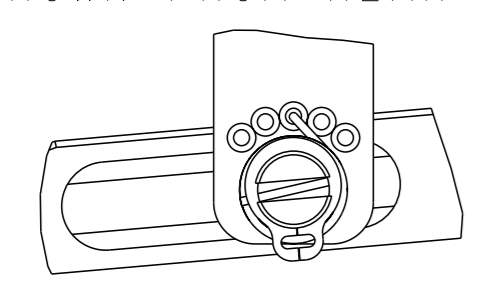
FEED TYPE

PNEUMATIC



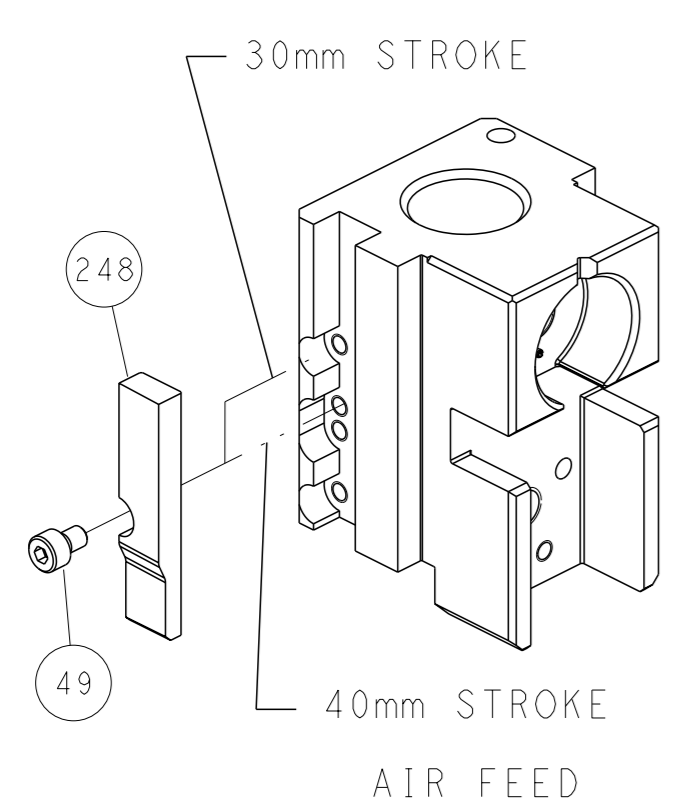
SEE DETAIL A

FEED SPRING SETTING POSITION
(SHOWN FROM REAR SIDE)

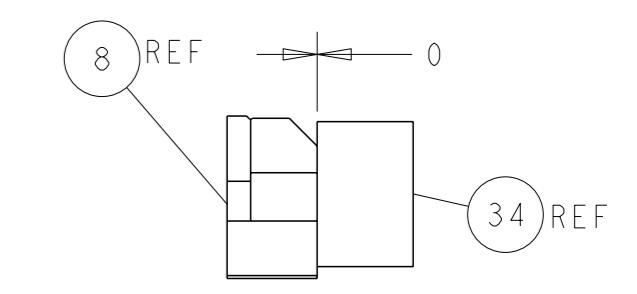
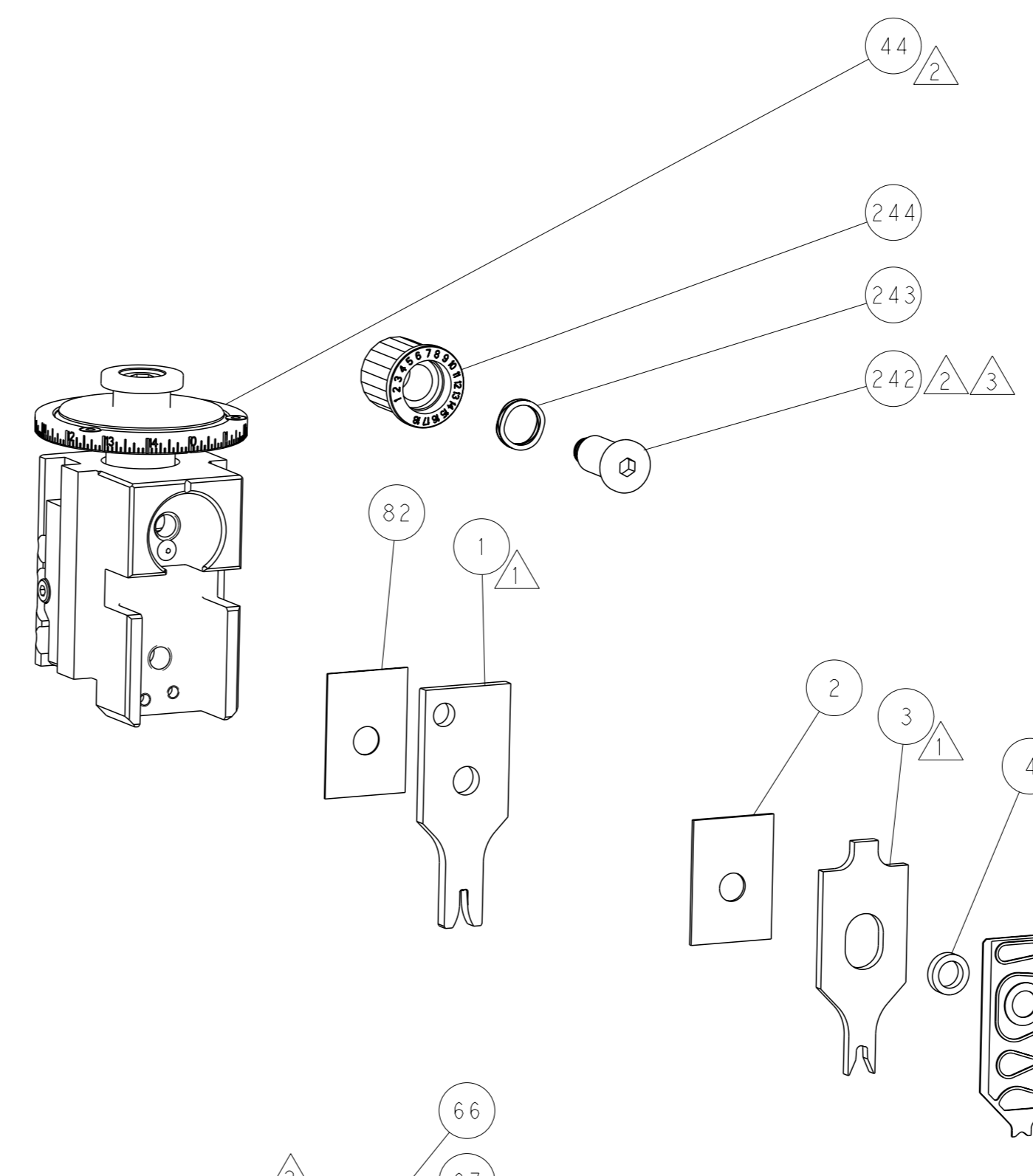
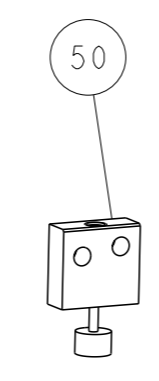


DETAIL A

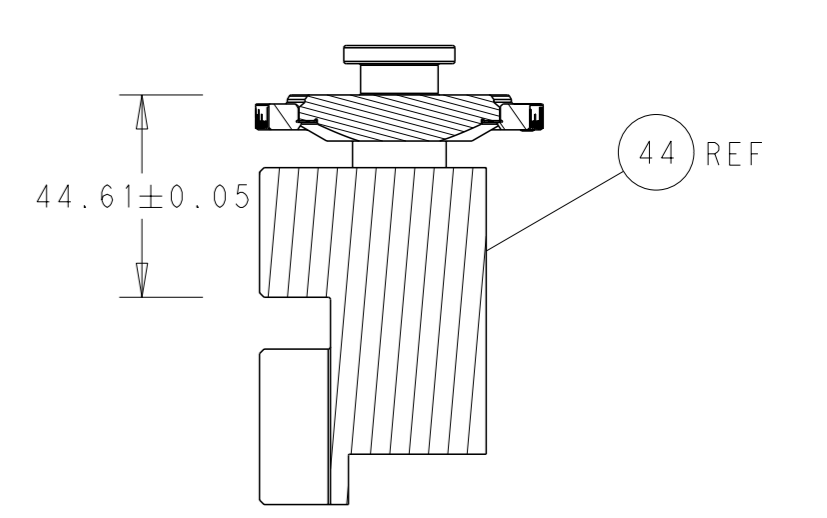
CAM POSITION



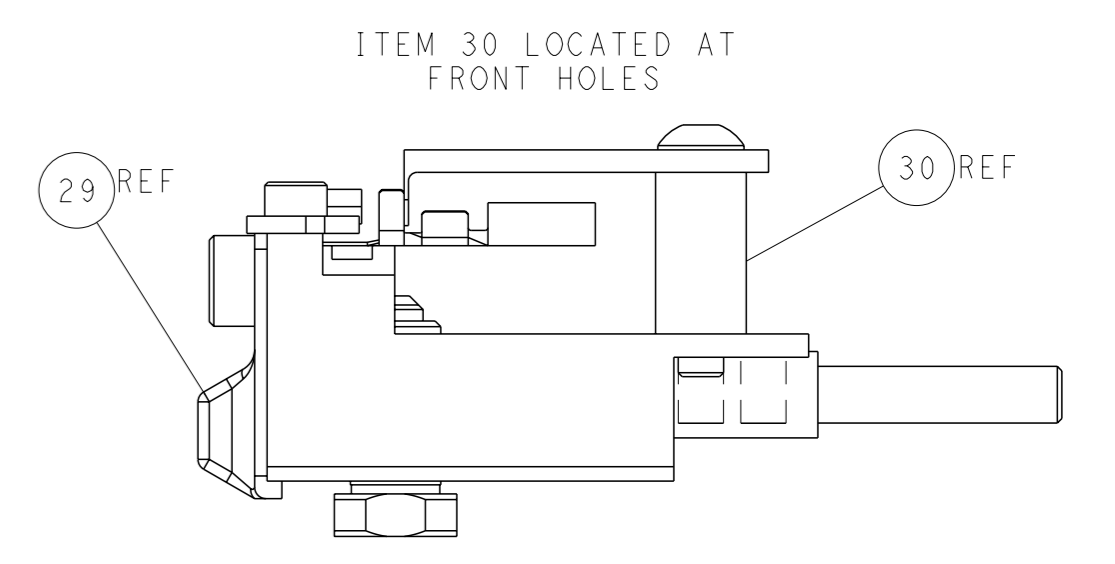
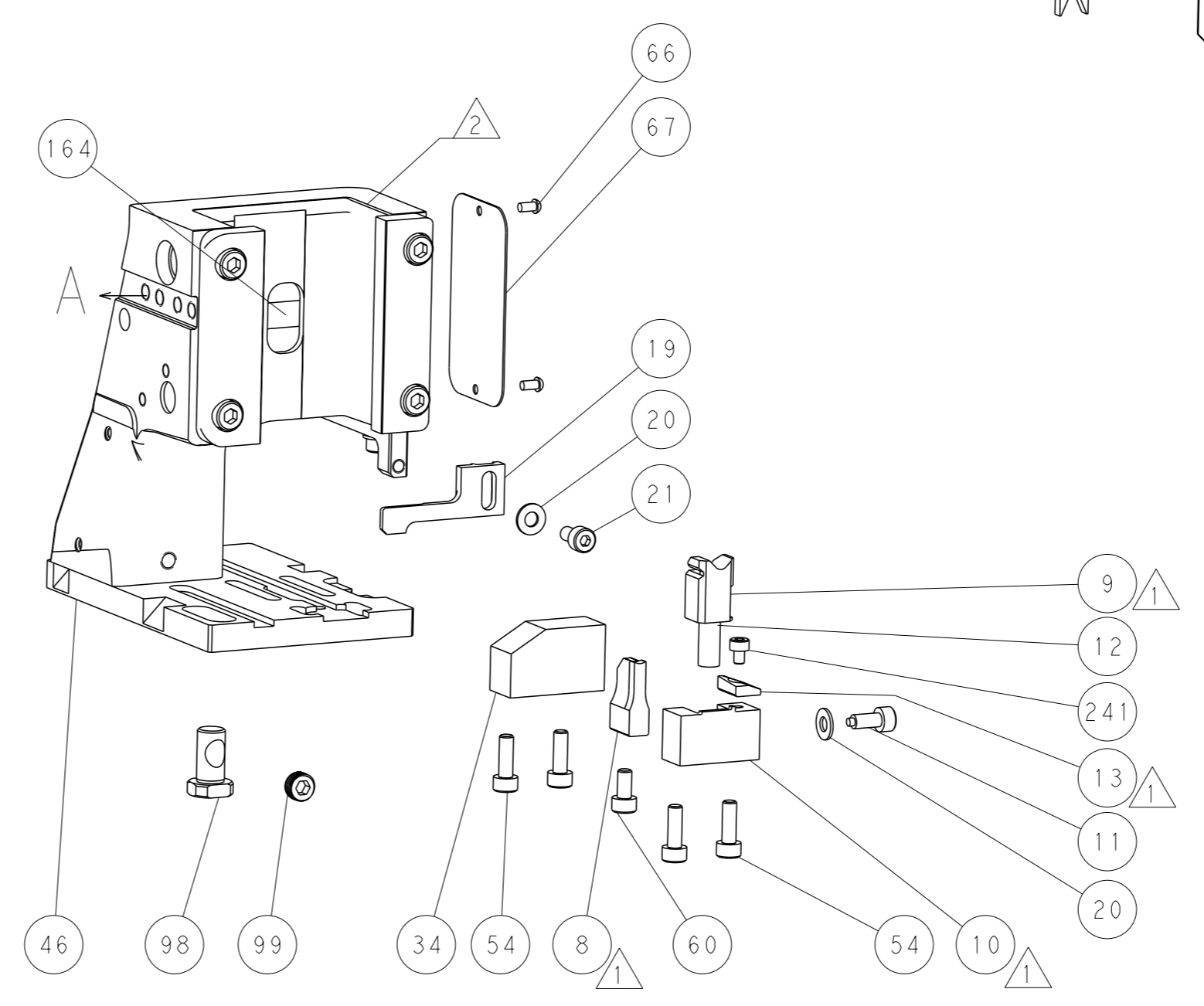
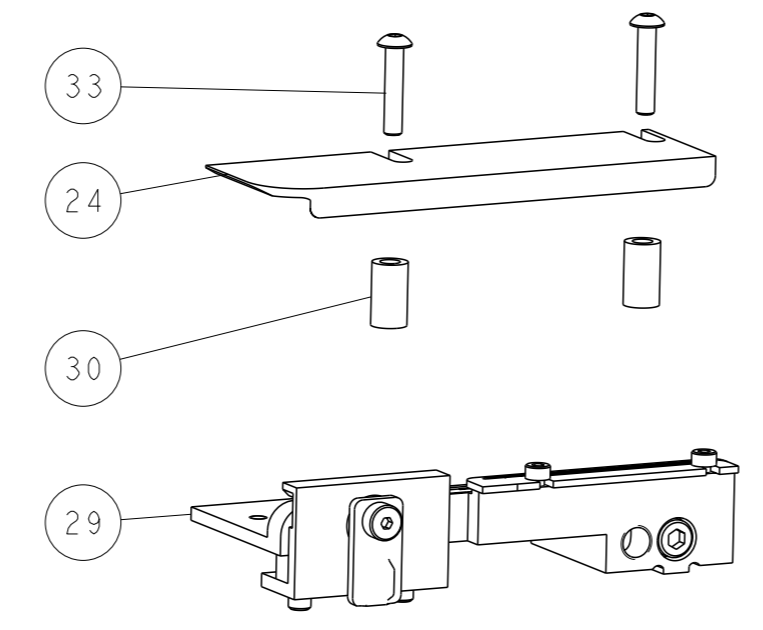
53



TERMINAL SUPPORT LOCATION



RAM SET-UP



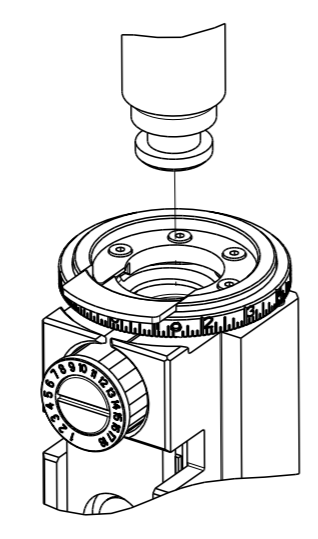
FEED TRACK POSITION
GUIDE BY INSULATION BARREL

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

<small>THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE AND THE CONTROLLER ENGINEERING ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST REVISION.</small>		DWN: K. HUANG 07FEB2018 CHK: K. HUANG 07FEB2018 APVD: L. ZHANG 07FEB2018	TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH ±		NAME: Ocean Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2837114 RESTRICTED TO:	SCALE: 1:2 SHEET: 2 of 4 REV: B
MATERIAL:		WEIGHT:	Customer Accessible Production Drawing

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2837114-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2837114-7	A	CRIMP TOOLING KIT	-

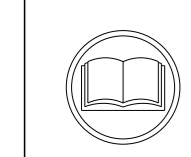
PACIFIC VERSION TERMINATOR
 INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.30 mm [.091]	F
INSUL	3.70 mm [.146]	OV
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: YAZAKI TERMINAL YAZAKI CRIMP SPECIFICATION	
TERMINAL NAME: M TYPE TERMINAL	
WIRE STRIP LENGTH 5.00-6.00 mm [.197-.236 IN]	TERMINAL INSULATION DIAMETER RANGE Ø1.75-2.25 mm [.069-.089 IN]
TERMINAL APPLICATION SPECIFICATION 72-WT10-1718 Rev WA2080	
TERMINALS APPLIED	
TE TERMINAL	YAZAKI TERMINAL
3311085-1	7116-2928-02
TE TERMINAL	YAZAKI TERMINAL
3311085-2	7116-2991-02

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.25mm ²	1.35+/-0.05 [.053+/-0.002]	5.3
1.00mm ²	1.25+/-0.05 [.049+/-0.002]	6.4
0.75mm ²	1.25+/-0.05 [.049+/-0.002]	6.2



- 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. 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)

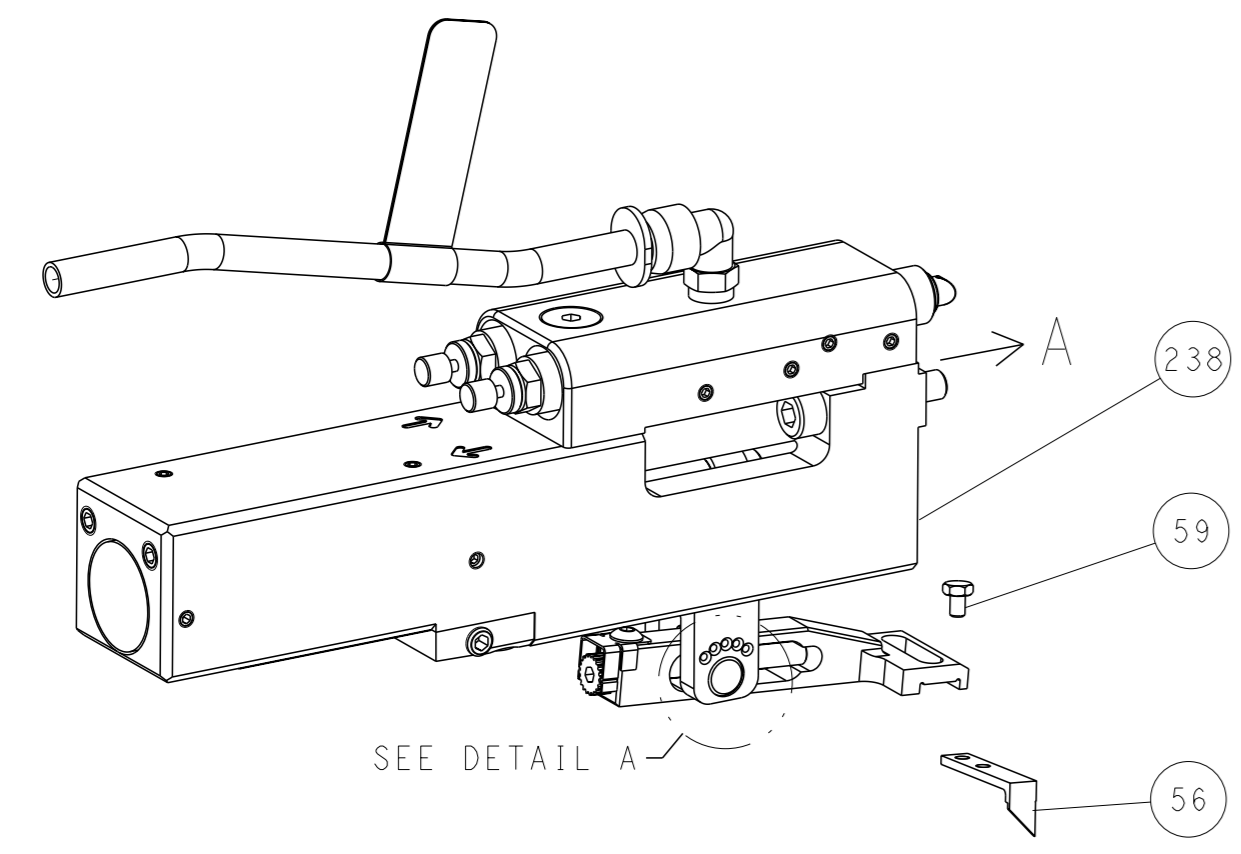
LOC	DIST	REVISIONS					
		P	LY#	DESCRIPTION	DATE	OWN	APVD
A	66	-	-	SEE SHEET 1	-	-	-

-	1	2119082-4	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
-	1	2844940-2	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
-	1	2844908-1	SCREW, LOCKING	99
-	1	2844907-1	POST, LOCKING	98
-	1	455888-4	SPACER, CRIMPER	82
-	1	1803607-3	DOCUMENTATION PACKAGE	71
-	1	2119791-5	DEPRESSOR, WIRE	70
-	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	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	53
-	1	1803382-2	HOLD DOWN, SPRING LOADED	50
-	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
-	1	2-1752356-0	SUPPORT, TERMINAL	34
-	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2-2844962-6	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	2844992-1	ASSEMBLY, STRIP GUIDE	29
-	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	2119533-1	STRIPPER, SIDE FEED	19
-	1	2119806-1	INSERT, SHEAR	13
-	1	3-22280-3	SPRING, COMPRESSION	12
-	1	1-356885-4	STOP, SHEAR	11
-	1	2119805-1	SHEAR HOLDER, FRONT	10
-	1	1803095-6	FLOATING SHEAR, FRONT	9
-	1	1-1803335-1	ANVIL, COMBINATION	8
-	-	-	-	7
-	-	-	-	6
-	1	2119757-8	DEPRESSOR, SHEAR	5
-	1	3-238011-5	BLOCK, CRIMPER SPACER	4
-	1	3-1803199-2	CRIMPER, INSULATION OVERLAP PREMIUM	3
-	1	455888-8	SPACER, CRIMPER	2
-	1	4-1803241-3	CRIMPER, WIRE F	1
-	77	-22	PART NO	ITEM NO

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		OWN	K. HUANG	07FEB2018	STE TE Connectivity Harrisburg, PA 17105-3608
mm		0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ±		CHK	K. HUANG	07FEB2018	
MATERIAL:		FINISH:		APVD	L. ZHANG	07FEB2018	NAME
				PRODUCT SPEC		Ocean Side Feed Applicator	
				APPLICATION SPEC		SIZE	
				WEIGHT		CAGE CODE	
				SCALE		DRAWING NO	
				RESTRICTED TO		00779	
				Customer Accessible Production Drawing		©=2837114	
				SCALE		SHEET 3 of 4	
				REV		B	

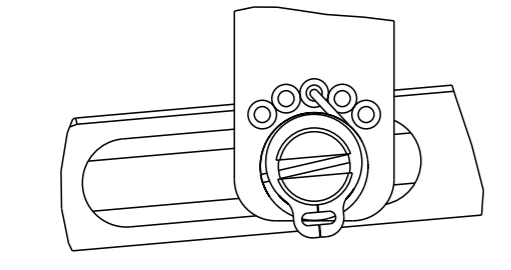
LOC	DIST	REVISIONS					
A	66	P	LYR	DESCRIPTION	DATE	OWN	APVD
		-		SEE SHEET 1	-	-	-

FEED TYPE PNEUMATIC



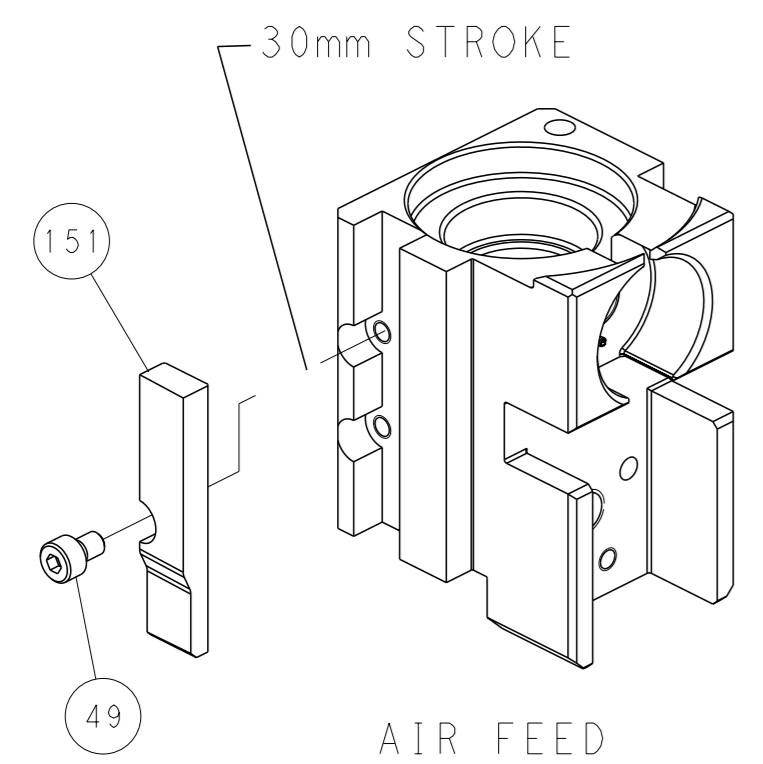
SEE DETAIL A

FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)

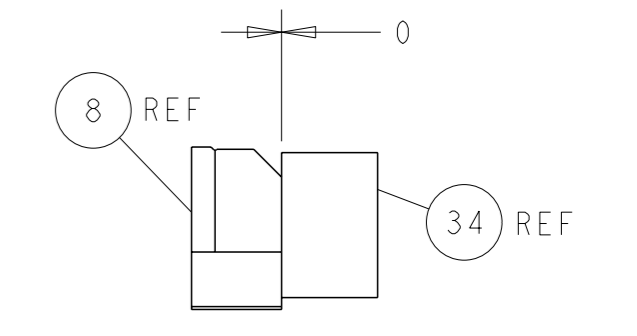
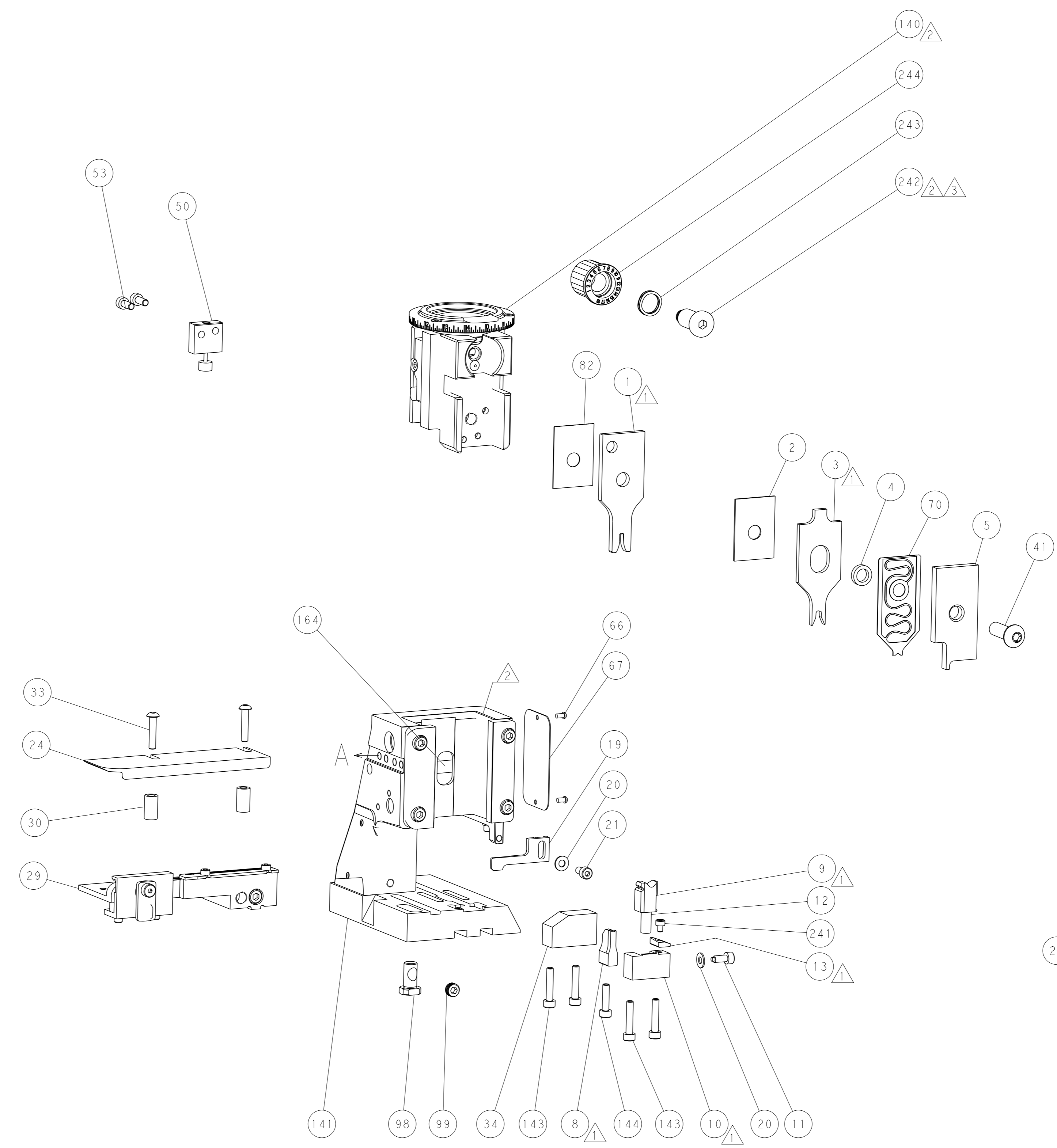


DETAIL A

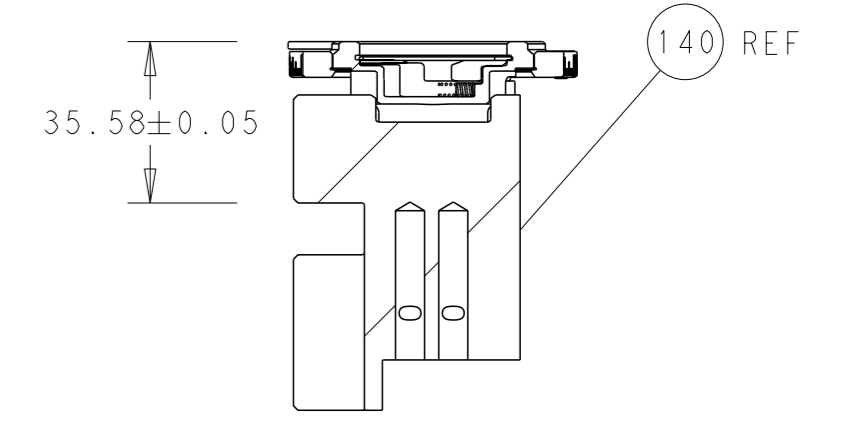
CAM POSITION



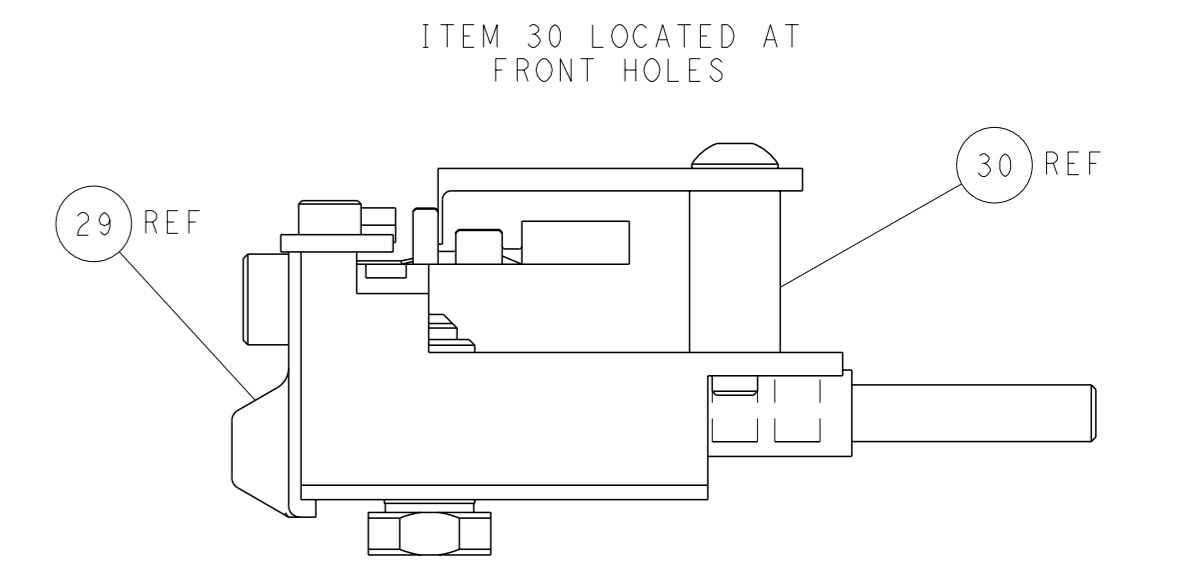
AIR FEED



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)

<small>THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE AND THE CONTROLLER'S DISCRETION SHOULD BE CONTACTED FOR THE LATEST REVISION.</small>		DWN K. HUANG 07FEB2018 CHK K. HUANG 07FEB2018 APVD L. ZHANG 07FEB2018	NAME STE 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 MATERIAL	WEIGHT SCALE 1:2 SHEET 4 of 4 REV B	RESTRICTED TO SIZE CAGE CODE DRAWING NO A1 00779 C=2837114
Customer Accessible Production Drawing			Customer Accessible Production Drawing