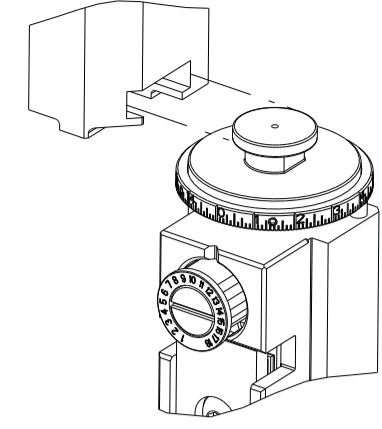


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2837165-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2837165-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2837165-1	C	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2837165-2	C	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2837165-7	C	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	3.60 mm [1.42]	F
INSUL	-	-

APPLICATOR INSTRUCTIONS
408-35042

TERMINAL DATA: MOLEX TERMINAL		MOLEX CRIMP SPECIFICATION	
TERMINAL NAME: SUPER SABRE REC. TERMINAL			
WIRE STRIP LENGTH		TERMINAL INSULATION DIAMETER RANGE	
7.90-8.30 mm [.311-.327 IN]		Ø4.00-4.60 mm [1.57-.181 IN]	
TERMINAL APPLICATION SPECIFICATION	ATS-638953200 Rev B		
TERMINALS APPLIED			
TE TERMINAL	MOLEX TERMINAL	TE TERMINAL	MOLEX TERMINAL
3311125-1	171825-0100		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
10 AWG	2.38+/-0.05 [1.094+/-0.002]	6.4
5.00mm2	2.18+/-0.08 [1.086+/-0.003]	8.6
4.00mm2	2.14+/-0.08 [1.084+/-0.003]	8.5
12 AWG	1.99+/-0.05 [1.078+/-0.002]	10.4

- 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.
- 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.

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	LTN	DESCRIPTION	DATE	OWN	APVD
		1		DEVELOPMENT	07MAR2018	KH	LZ
		A		RELEASE	26APR2018	AW	TE
		B		ECR-20-012245	31AUG2020	FJ	TE
		C		ECR-23-187867	25SEP2023	FZ	TE

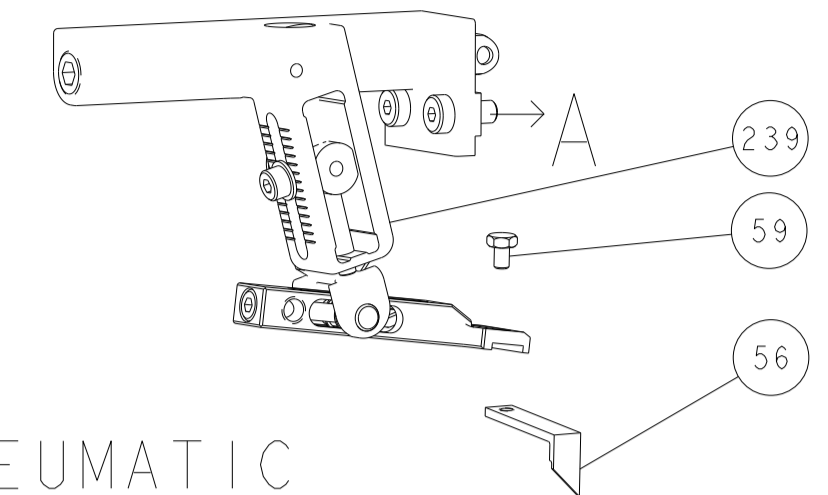
-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248
-	1	1	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
-	-	1	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	1	-	1	-	2844940-1	AIR FEED MODULE	238
-	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	1	1	1	1	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113
-	1	1	1	1	2844908-1	SCREW, LOCKING	99
-	1	1	1	1	2844907-1	POST, LOCKING	98
-	1	1	1	1	455888-5	SPACER, CRIMPER	82
-	1	1	1	1	1-22278-0	SPRING, COMPRESSION	77
-	1	1	1	1	854769-4	HOLDER, INS	74
-	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	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	21028-2	PIN, SLOTTED SPRING .062 X .250	58
-	1	1	1	1	1338683-8	FEED PAWL	56
-	4	4	4	4	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	54
-	2	2	2	2	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	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	1-1752356-9	SUPPORT, TERMINAL	34
-	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	2	2	3-2844962-0	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29
-	1	1	1	1	1-455888-0	SPACER, CRIMPER	28
-	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	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	1803095-1	FLOATING SHEAR, FRONT	9
1	2	2	1	1	1803333-4	ANVIL, COMBINATION	8
-	1	1	1	1	4-240641-5	SPACER	7
-	-	-	-	-	-	-	6
-	1	1	1	1	2119780-9	DEPRESSOR, SHEAR	5
-	-	-	-	-	-	-	4
-	-	-	-	-	-	-	3
-	-	-	-	-	-	-	2
1	2	2	1	1	1-1803266-0	CRIMPER, WIRE	1

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		OWN		NAME	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	APVD	PRODUCT SPEC
	ANGLES ±	FINISH		APVD		APVD	APPLICATION SPEC
MATERIAL				WEIGHT			

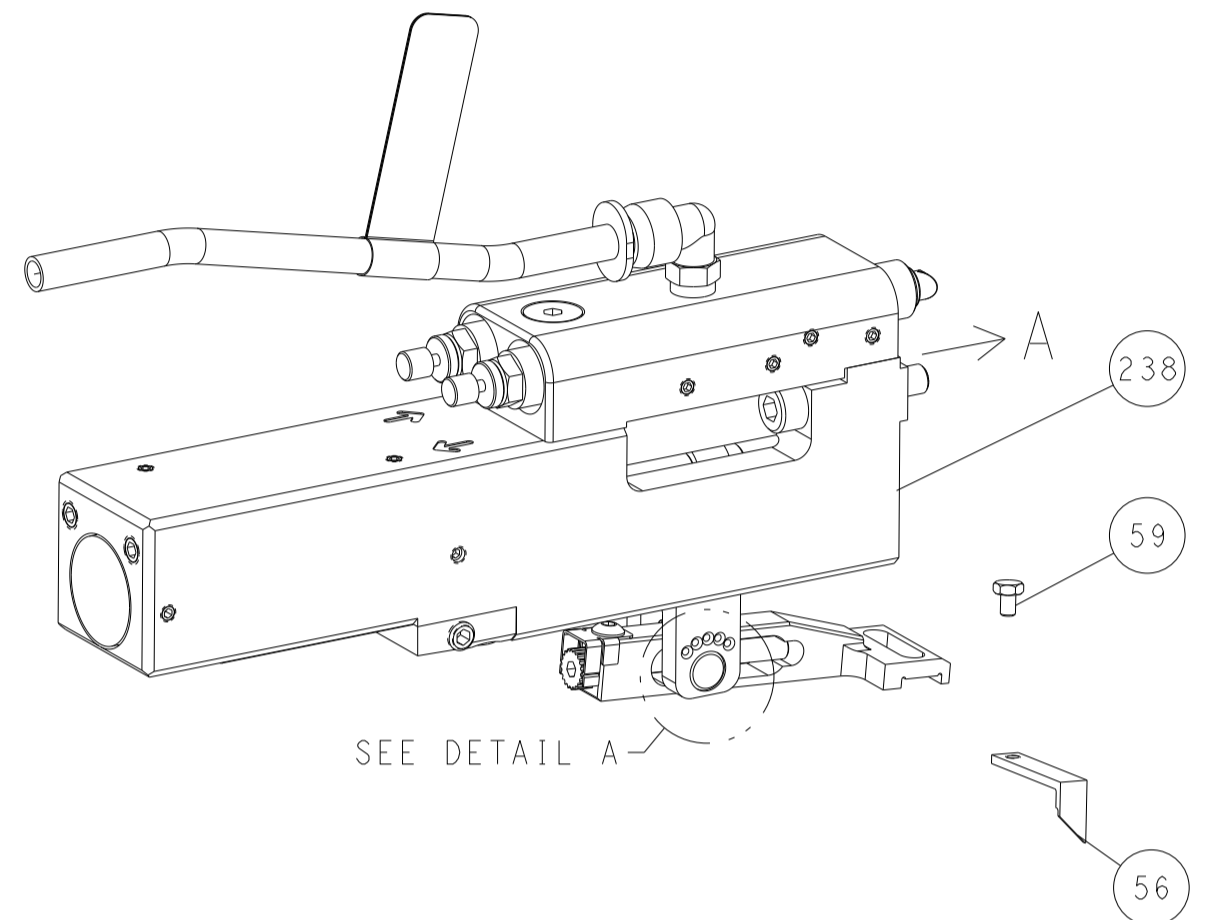
CHK	H. HUANG	07MAR2018	TE Connectivity Harrisburg, PA 17105-3608
CHK	L. ZHANG	07MAR2018	
APVD	L. ZHANG	07MAR2018	
SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
A1	00779	2837165	
Customer Accessible Production Drawing			SCALE 1:2 SHEET 1 OF 4 REV C

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

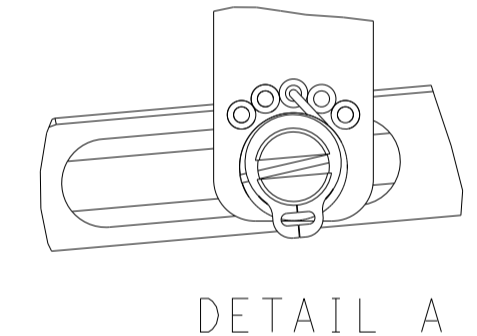
FEED TYPE MECHANICAL



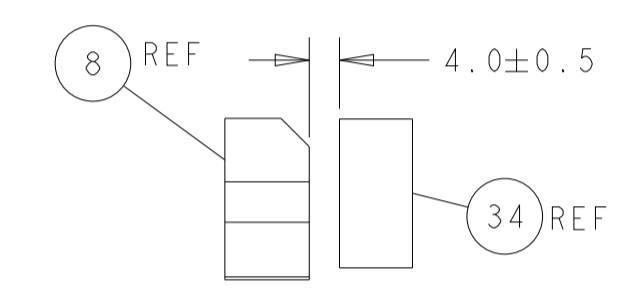
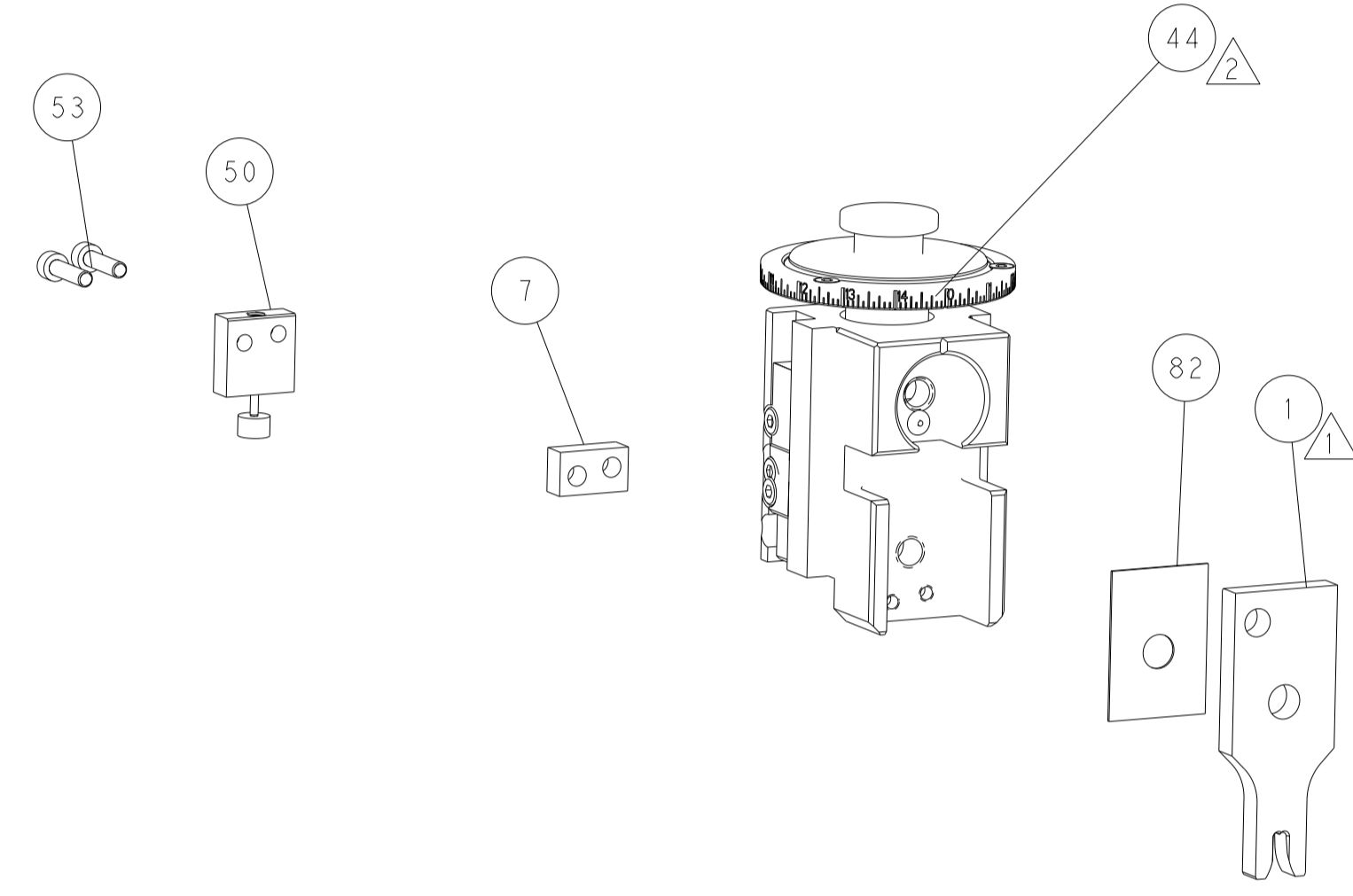
PNEUMATIC



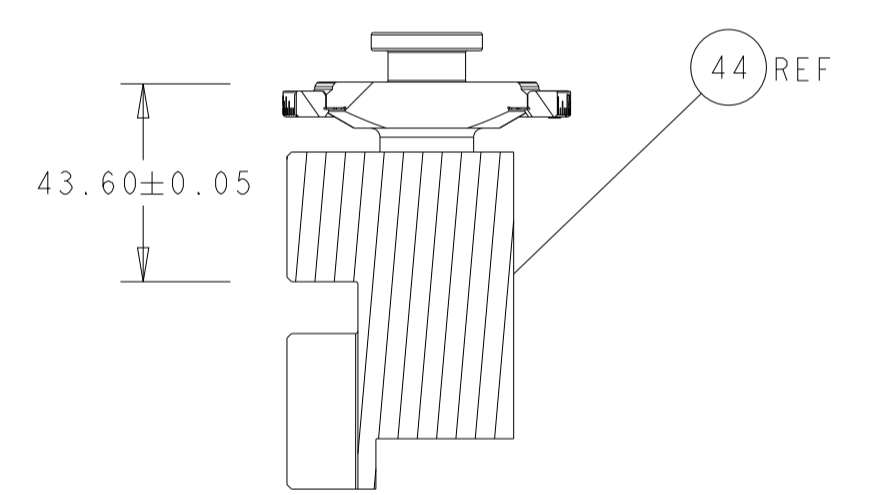
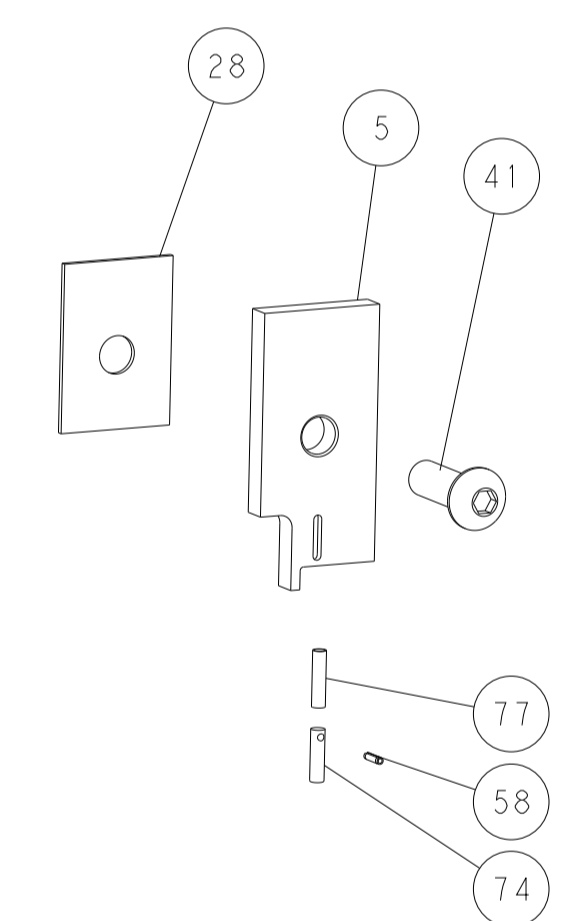
FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



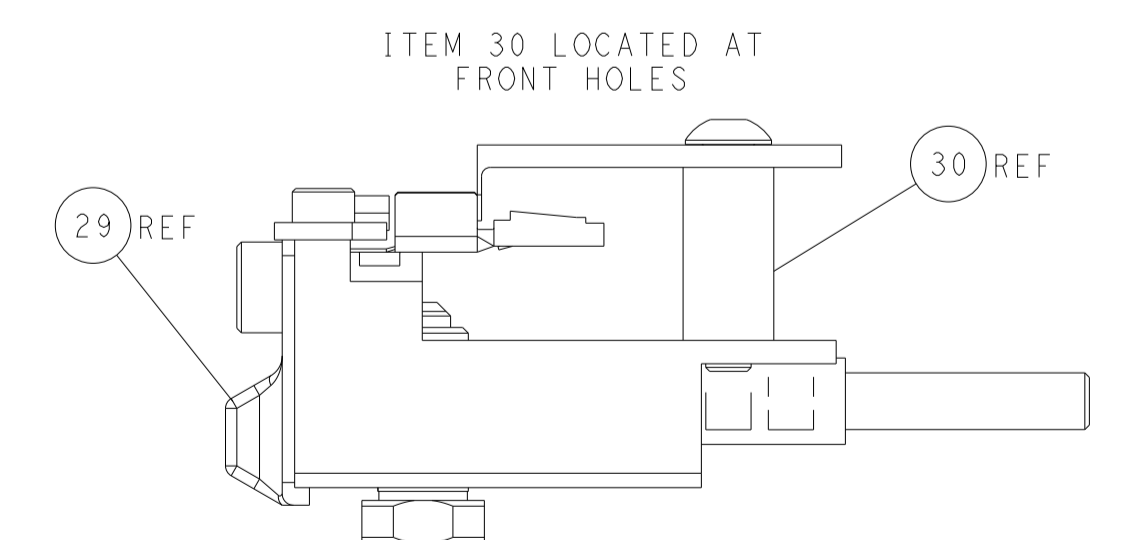
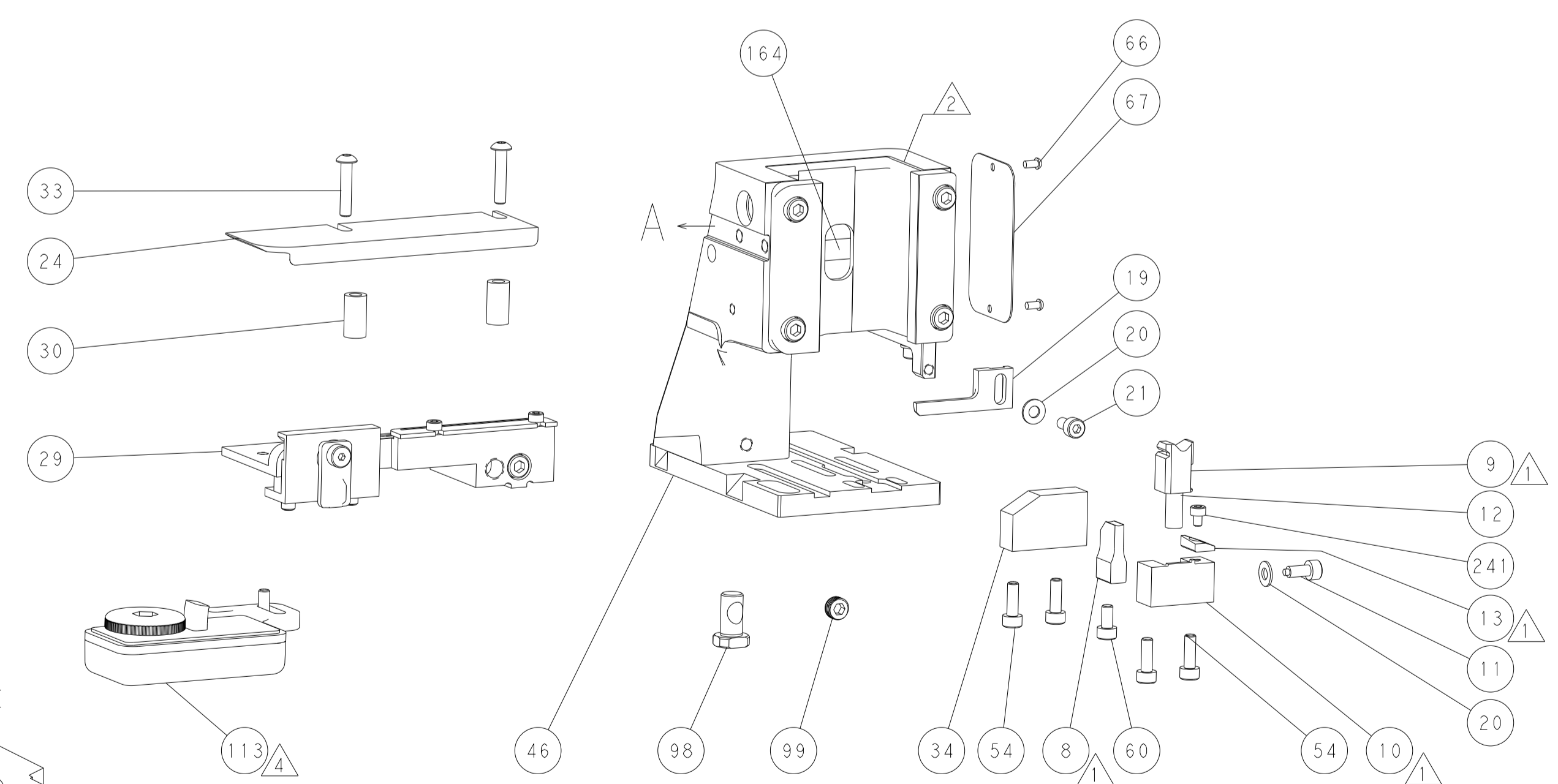
DETAIL A



TERMINAL SUPPORT LOCATION

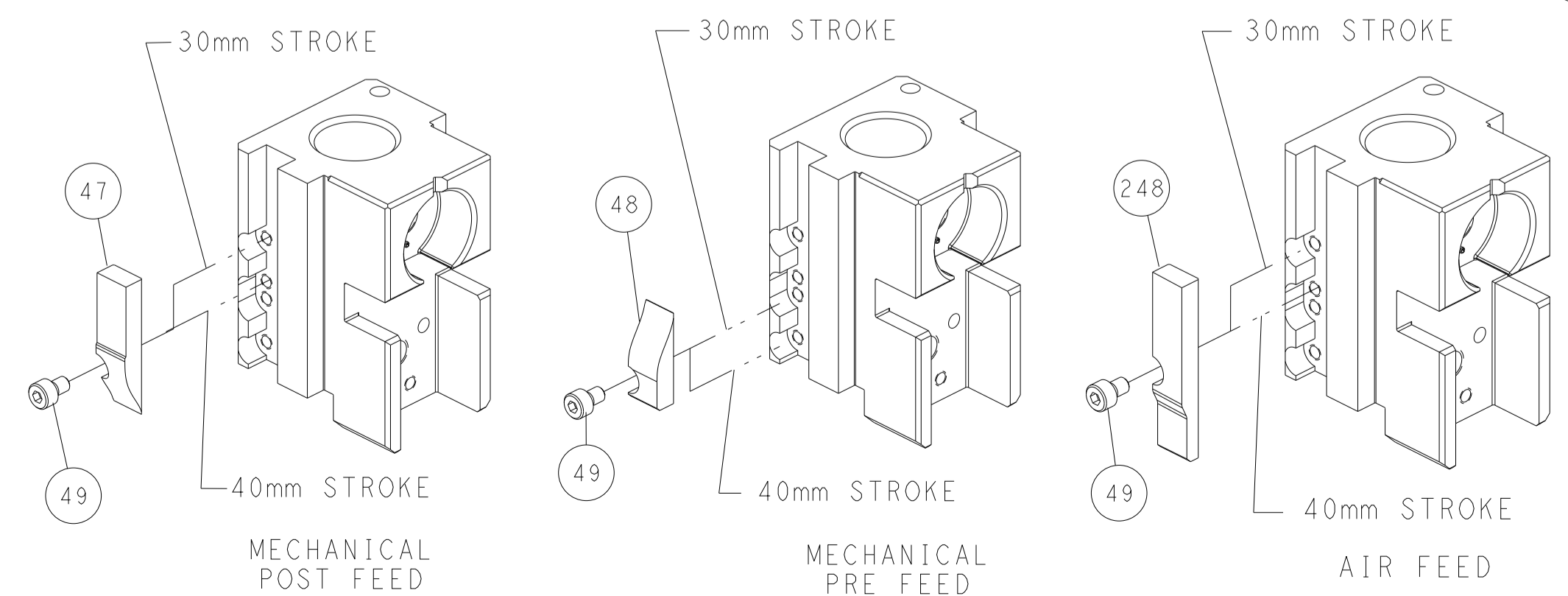


RAM SET-UP



FEED TRACK POSITION GUIDE BY WIRE BARREL

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 THE PROPERTY OF TYCO ELECTRONICS CORPORATION AND IS NOT TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, INCLUDING PHOTOCOPYING, RECORDING, OR BY ANY INFORMATION STORAGE AND RETRIEVAL SYSTEM, WITHOUT THE WRITTEN PERMISSION OF TYCO ELECTRONICS CORPORATION.</small>		DWN: R. HUANG 07MAR2018 CHK: L. ZHANG 07MAR2018 APVD: L. ZHANG 07MAR2018	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: C=2837165	RESTRICTED TO: - SCALE: 1:2 SHEET: 2 OF 4 REV: C
MATERIAL: - FINISH: -		WEIGHT: - Customer Accessible Production Drawing	SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2837165-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2837165-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2837165-7	C	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
 INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	3.60 mm [.142]	F
INSUL	-	-

APPLICATOR INSTRUCTIONS
 408-35042

TERMINAL DATA: MOLEX TERMINAL		MOLEX CRIMP SPECIFICATION	
TERMINAL NAME: SUPER SABRE REC. TERMINAL			
WIRE STRIP LENGTH		TERMINAL INSULATION DIAMETER RANGE	
7.90-8.30 mm [.311-.327 IN]		Ø4.00-4.60 mm [.157-.181 IN]	
TERMINAL APPLICATION SPECIFICATION			
ATS-638953200 Rev B			
TERMINALS APPLIED			
TE TERMINAL	MOLEX TERMINAL	TE TERMINAL	MOLEX TERMINAL
331125-1	171825-0100		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
10 AWG	2.38+/-0.05 [.094+/-0.002]	6.4
5.00mm2	2.18+/-0.08 [.086+/-0.003]	8.6
4.00mm2	2.14+/-0.08 [.084+/-0.003]	8.5
12 AWG	1.99+/-0.05 [.078+/-0.002]	10.4



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

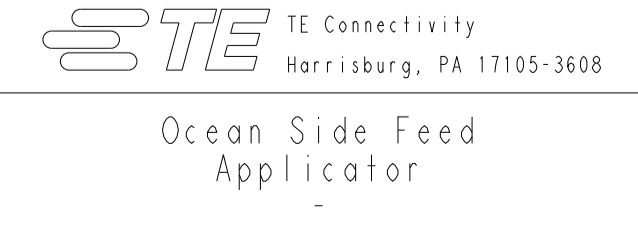
***WARNING**
 ON INSTALLATION, SET WIRE DISC TO CRIMP HEIGHT REFERENCE SETTING FOR LARGEST WIRE SIZE. CRIMP HEIGHT REFERENCE SETTINGS GREATER THAN THE VALUE SHOWN MAY CAUSE DAMAGE TO THE CRIMP TOOLING, REFER TO THE INSTRUCTION SHEET FOR PROPER SETUP AND ADJUSTMENTS.

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	LTN	DESCRIPTION	DATE	OWN	APVD
-	-	-	-	SEE SHEET 1	-	-	-

-	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
-	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	455888-5	SPACER, CRIMPER	82
-	1	1	1-22278-0	SPRING, COMPRESSION	77
-	1	1	854769-4	HOLDER, INS	74
-	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	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	1	1	21028-2	PIN, SLOTTED SPRING .062 X .250	58
-	1	1	1338683-8	FEED PAWL	56
-	2	2	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	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	1-1752356-9	SUPPORT, TERMINAL	34
-	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	3-2844962-0	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29
-	1	1	1-455888-0	SPACER, CRIMPER	28
-	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	1803095-1	FLOATING SHEAR, FRONT	9
-	1	1	1803333-4	ANVIL, COMBINATION	8
-	1	1	4-240641-5	SPACER	7
-	-	-	-	-	6
-	1	1	2119780-9	DEPRESSOR, SHEAR	5
-	-	-	-	-	4
-	-	-	-	-	3
-	-	-	-	-	2
-	1	1	1-1803266-0	CRIMPER, WIRE	1

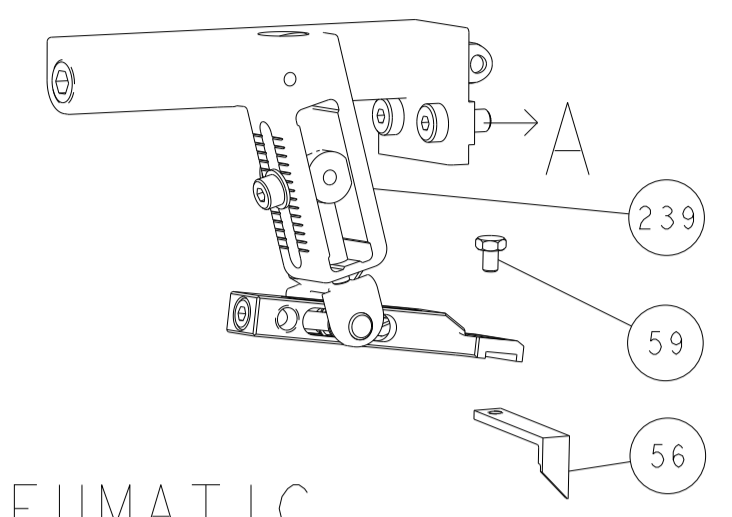
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		MATERIAL:		FINISH:		WEIGHT:		SCALE:		SHEET:		REV:	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES	FINISH			A1	00779	3	4	C	



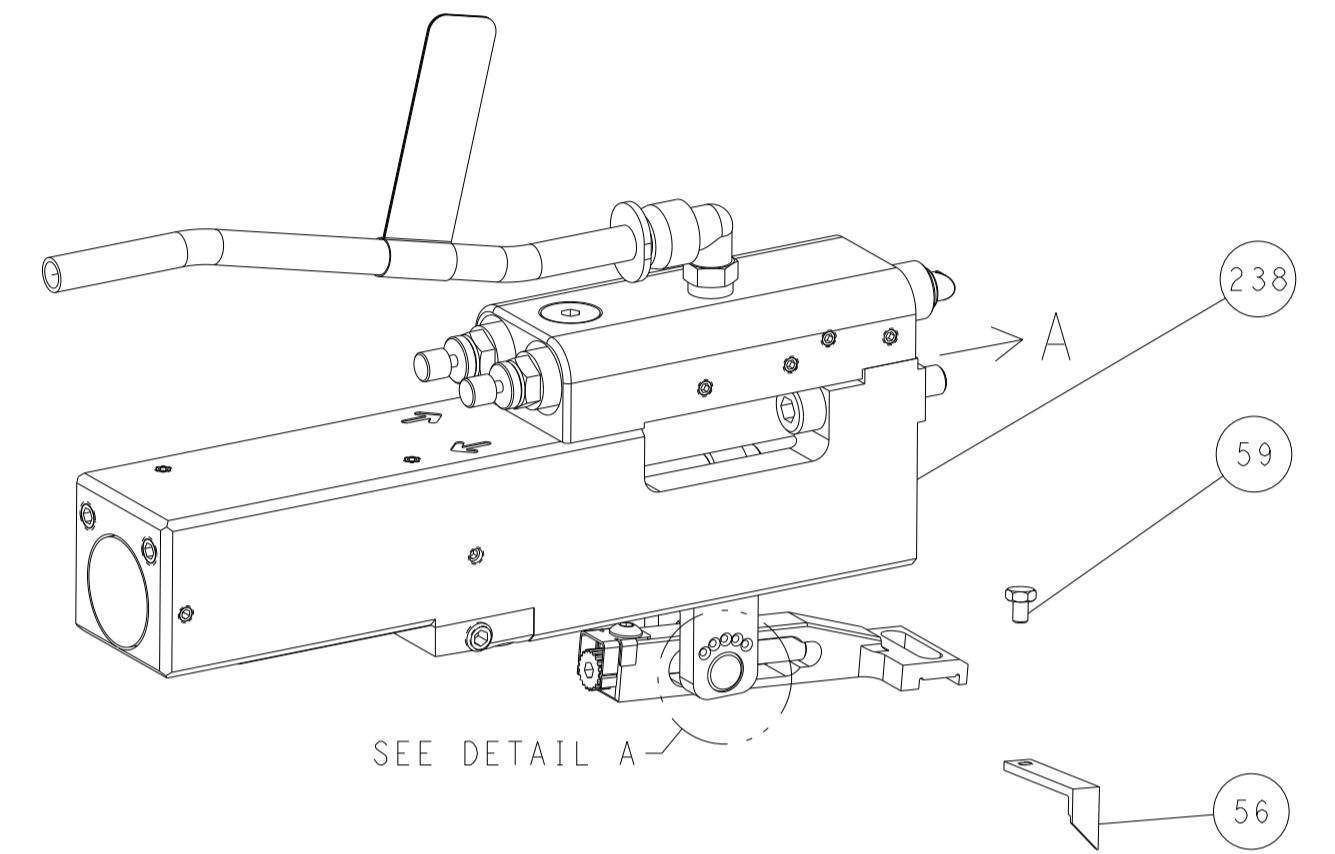
Ocean Side Feed
 Applicator

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

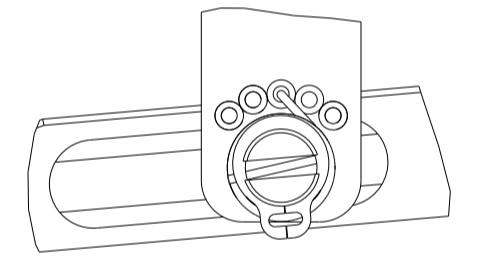
FEED TYPE MECHANICAL



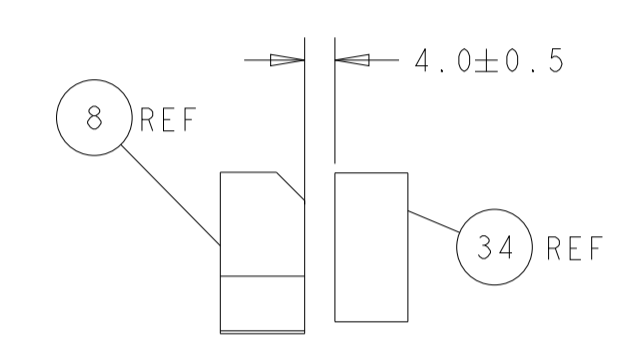
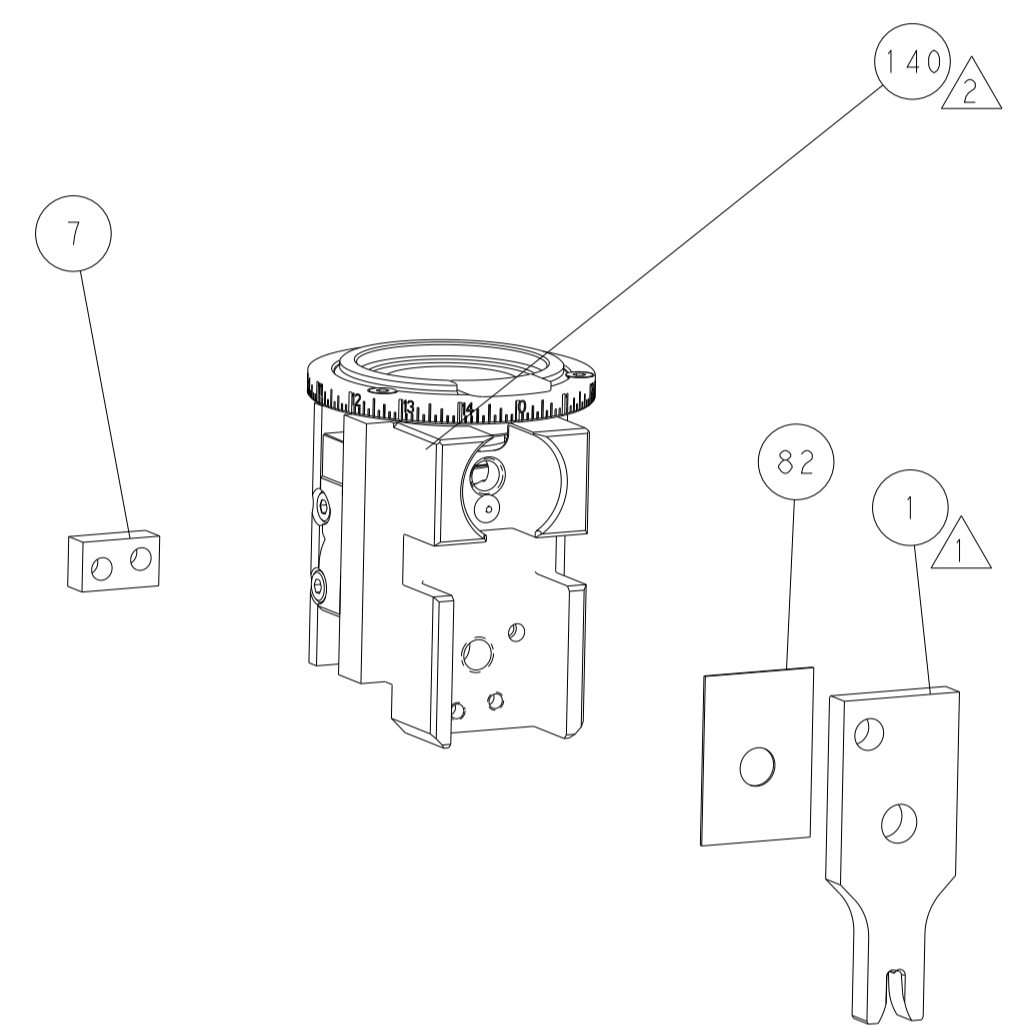
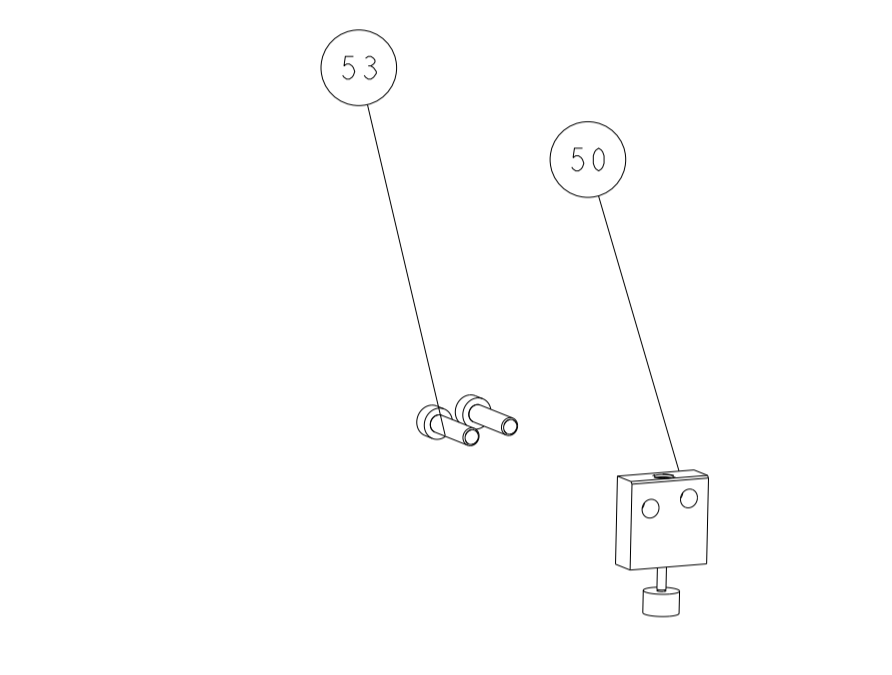
PNEUMATIC



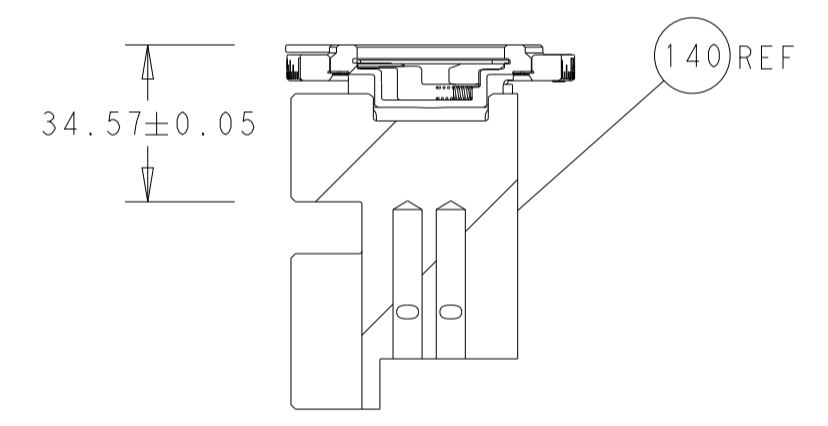
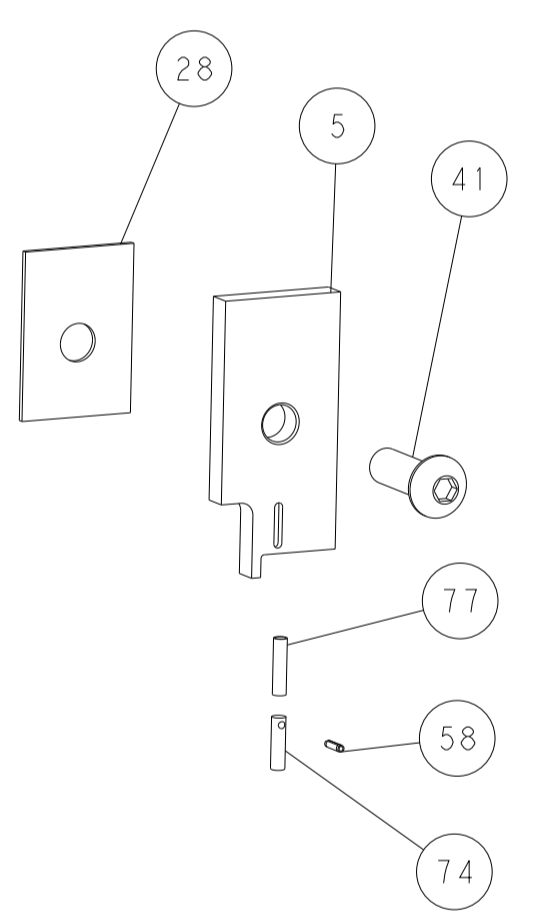
FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



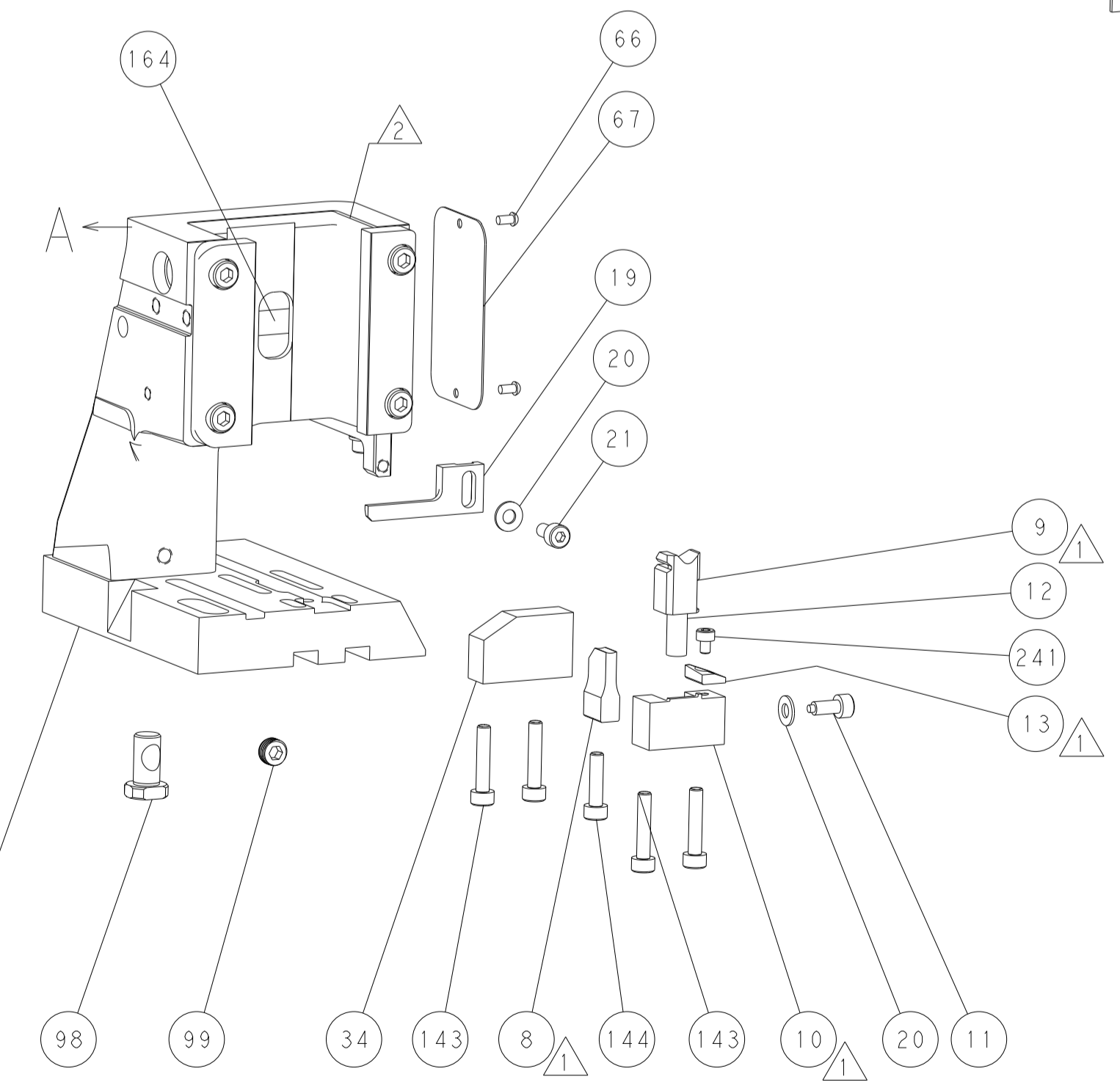
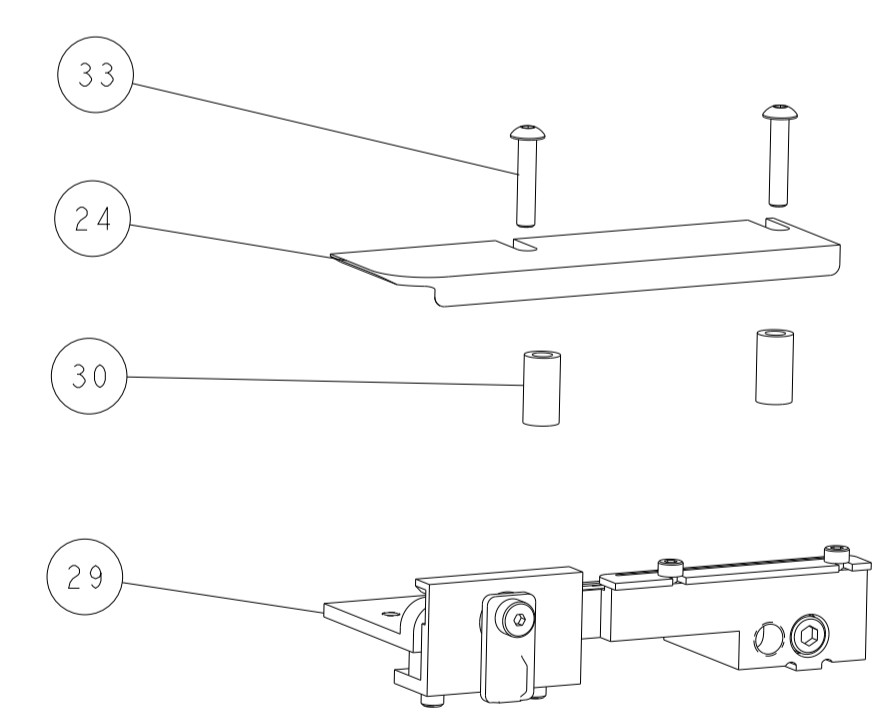
DETAIL A



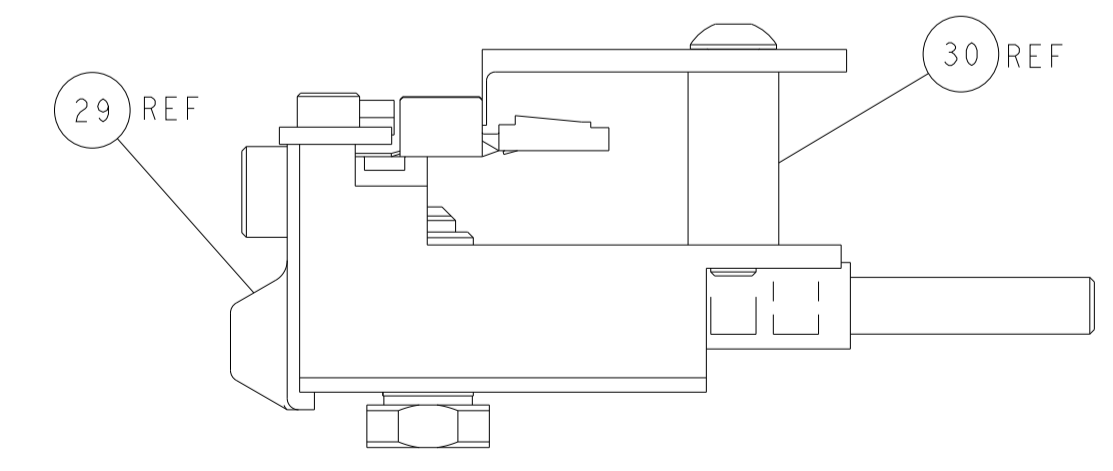
TERMINAL SUPPORT LOCATION



RAM SET-UP

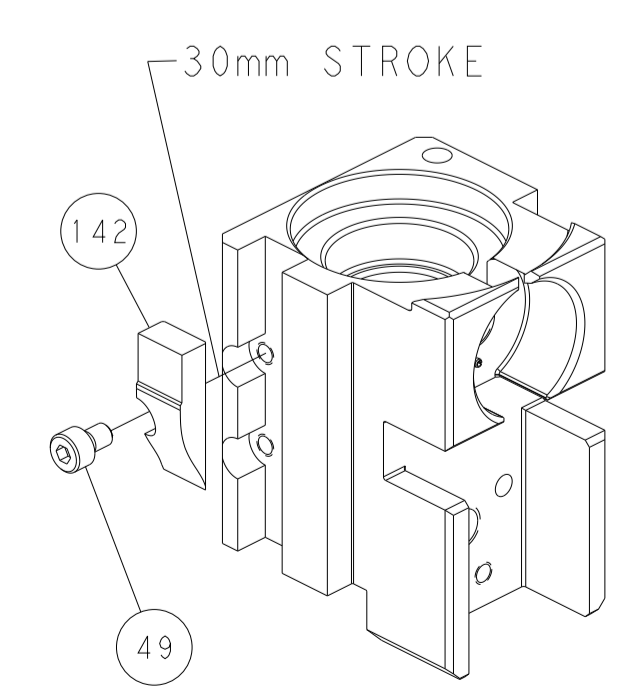


ITEM 30 LOCATED AT
FRONT HOLES

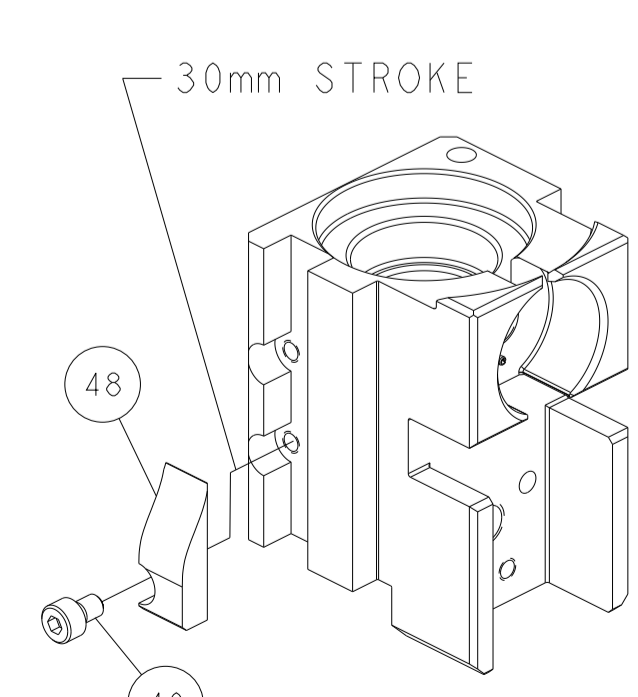


FEED TRACK POSITION
GUIDE BY WIRE BARREL

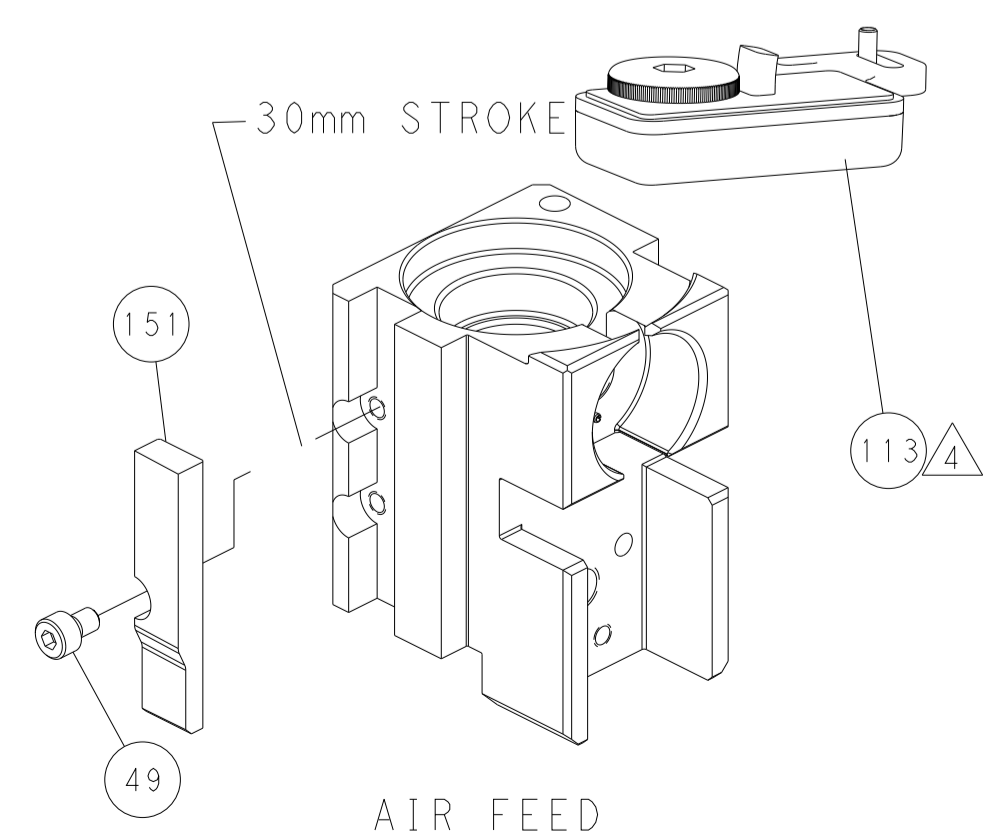
CAM POSITIONS



MECHANICAL
POST FEED



MECHANICAL
PRE FEED



AIR FEED

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:		DWN K. HUANG 07MAR2018		TE Connectivity Harrisburg, PA 17105-3608	
mm	0 PLC	±		CHK L. ZHANG 07MAR2018	NAME	Ocean Side Feed Applicator	
	1 PLC	±		APVD L. ZHANG 07MAR2018	PRODUCT SPEC	RESTRICTED TO	
	2 PLC	±			APPLICATION SPEC	SIZE CAGE CODE DRAWING NO	
	3 PLC	±				A1 00779 C=2837165	
	4 PLC	±				Customer Accessible Production Drawing	
	ANGLES	±			SCALE	1:2 SHEET 4 OF 4 REV C	
	FINISH	±					