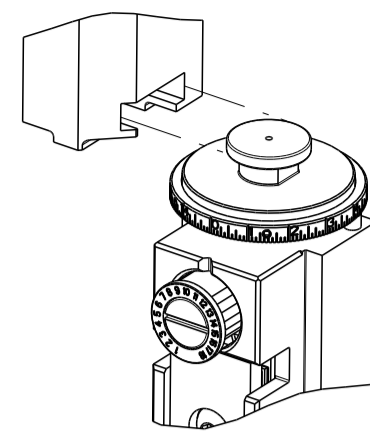


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2837214-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2837214-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
5-2837214-1	C	SEAL STRIPPER CRIMPER TERMINATING UNIT	MECHANICAL
5-2837214-2	C	SEAL STRIPPER CRIMPER TERMINATING UNIT	PNEUMATIC
7-2837214-1	C	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2837214-2	C	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2837214-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.40 mm [.055]	F
INSUL	1.90 mm [.075]	F

APPLICATOR INSTRUCTIONS 408-35042

TERMINAL DATA: JST TERMINAL		JST CRIMP SPECIFICATION	
TERMINAL NAME: SXA 2.5mm JST			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
1.73-2.11 mm [.068-.083 IN]		Ø1.50-1.90 mm [.059-.075 IN]	
TERMINAL APPLICATION SPECIFICATION XA-XAD (W-W) CHM-1-170 Rev R3			
TERMINALS APPLIED			
TE TERMINAL	JST TERMINAL	TE TERMINAL	JST TERMINAL
1572601-1	SXA-01T-P0.6	1572601-3	SXA-01GW-P0.6
1572601-2	SXAM-01T-P0.6	2113096-1	SXM-01T-P0.6

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
20 AWG OR 0.50mm ²	0.90+/-0.05 [.035+/-0.002]	6.6
22 AWG OR 0.35mm ²	0.80+/-0.05 [.031+/-0.002]	7.7
24 AWG OR 0.20mm ²	0.75+/-0.05 [.030+/-0.002]	8.2

- 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. APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 180.
- 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 SUPPORT LOCATION FOR TERMINAL PN 2113096-1
- TERMINAL SUPPORT LOCATION FOR TERMINALS PN 1572601-1, 1572601-2, AND 1572601-3.
- TERMINAL LUBRICANT IS RECOMMENDED.

***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.

REVISIONS				
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C		ECR-21-004644	21APR2021	TB RK

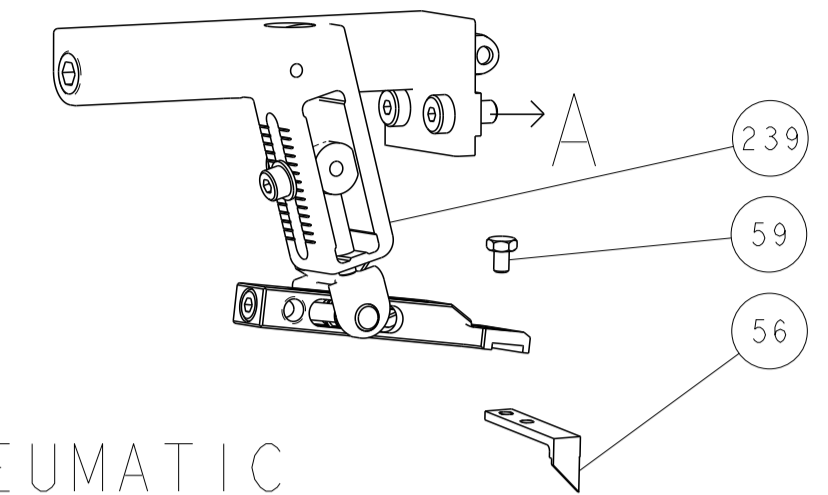
-	-	-	1	1	-	-	1803515-3	RAM ASSEMBLY, SF ATLANTIC	293
-	-	-	1	1	-	-	2-1803583-1	APPLICATOR BASIC ASSEMBLY, SF	292
-	1	1	1	1	1	1	2119791-5	DEPRESSOR, WIRE	286
-	1	-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248
-	1	1	1	1	1	1	2119082-4	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
3	-	1	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	1	1	1	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
-	-	1	-	1	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	1	-	1	-	1	-	2844940-1	AIR FEED MODULE	238
-	-	-	1	1	-	-	4-1722335-3	STRIPPER, SIDE FEED	182
-	-	-	1	1	-	-	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	181
3	-	-	1	1	-	-	1-1752354-8	STANDOFF, HOLD-DOWN	180
-	-	-	1	1	-	-	993111-1	PIN, SLOTTED SPRING 3.0 X 20.0	177
-	-	-	1	1	-	-	5-22280-0	SPRING, COMPRESSION	176
-	-	-	1	1	-	-	1752353-3	GUIDE PIN, HOLDDOWN	175
-	-	-	1	1	-	-	1901680-2	GUIDE PIN, HOLDDOWN	174
-	REF	REF	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
8	-	1	1	1	1	1	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113
-	1	1	1	1	1	1	2844908-1	SCREW, LOCKING	99
-	1	1	1	1	1	1	2844907-1	POST, LOCKING	98
-	1	1	1	1	1	1	1-455888-7	SPACER, CRIMPER	82
-	1	1	1	1	1	1	1803607-3	DOCUMENTATION PACKAGE	71
-	1	1	1	1	1	1	2119943-1	WASHER, SPACER	69
-	1	1	1	1	1	1	2119740-1	TAG, IDENTIFICATION	67
-	2	2	2	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	1	1	1	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	60
-	1	1	1	1	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	1	1	1	1	1	1	1338685-1	PAWL, FEED	56
-	4	4	4	4	4	4	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	54
-	2	2	2	2	2	2	2-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 14	53
-	1	1	1	1	1	1	5018030-1	NUT, HEX, REG, RoHS, M3	52
-	1	1	1	1	1	1	811242-5	BUMPER, HOLD DOWN	51
-	1	1	1	1	1	1	690753-2	SPACER, TONKER	50
-	1	2	1	2	1	2	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	-	1	-	1	-	1	2119652-1	FEED CAM, PRE FEED	48
-	-	1	-	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	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
6	1	1	1	1	1	1	2-1752356-3	SUPPORT, TERMINAL	34
-	2	2	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	2	2	2	2	2-2844962-6	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	1	1	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29
-	1	1	1	1	1	1	455888-3	SPACER, CRIMPER	28
-	1	1	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	1	1	2	2	1-18028-2	WASHER, FLAT, REG M4	20
-	1	1	-	-	1	1	2119533-3	STRIPPER, SIDE FEED	19
1	-	1	1	1	1	1	2119806-1	INSERT, SHEAR	13
-	1	1	1	1	1	1	3-22280-3	SPRING, COMPRESSION	12
-	1	1	1	1	1	1	1-356885-5	STOP, SHEAR	11
1	-	1	1	1	1	1	2119805-1	SHEAR HOLDER, FRONT	10
1	-	1	1	1	1	1	1803095-6	FLOATING SHEAR, FRONT	9
1	2	2	1	1	1	1	1-1633917-5	ANVIL, COMBINATION	8
-	1	1	1	1	1	1	1-240641-6	SPACER	7
-	-	-	-	-	-	-	-	-	6
-	1	1	1	1	1	1	2119757-8	DEPRESSOR, SHEAR	5
-	1	1	1	1	1	1	2-238011-0	BLOCK, CRIMPER SPACER	4
1	2	2	1	1	1	1	8-1633962-3	CRIMPER, INSULATION F PREMIUM	3
-	1	1	1	1	1	1	455888-4	SPACER, CRIMPER	2
1	2	2	1	1	1	1	3-456402-4	CRIMPER, WIRE PREMIUM	1
-77	-72	-71	-52	-51	-2	-1	PART NO	DESCRIPTION	ITEM NO

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

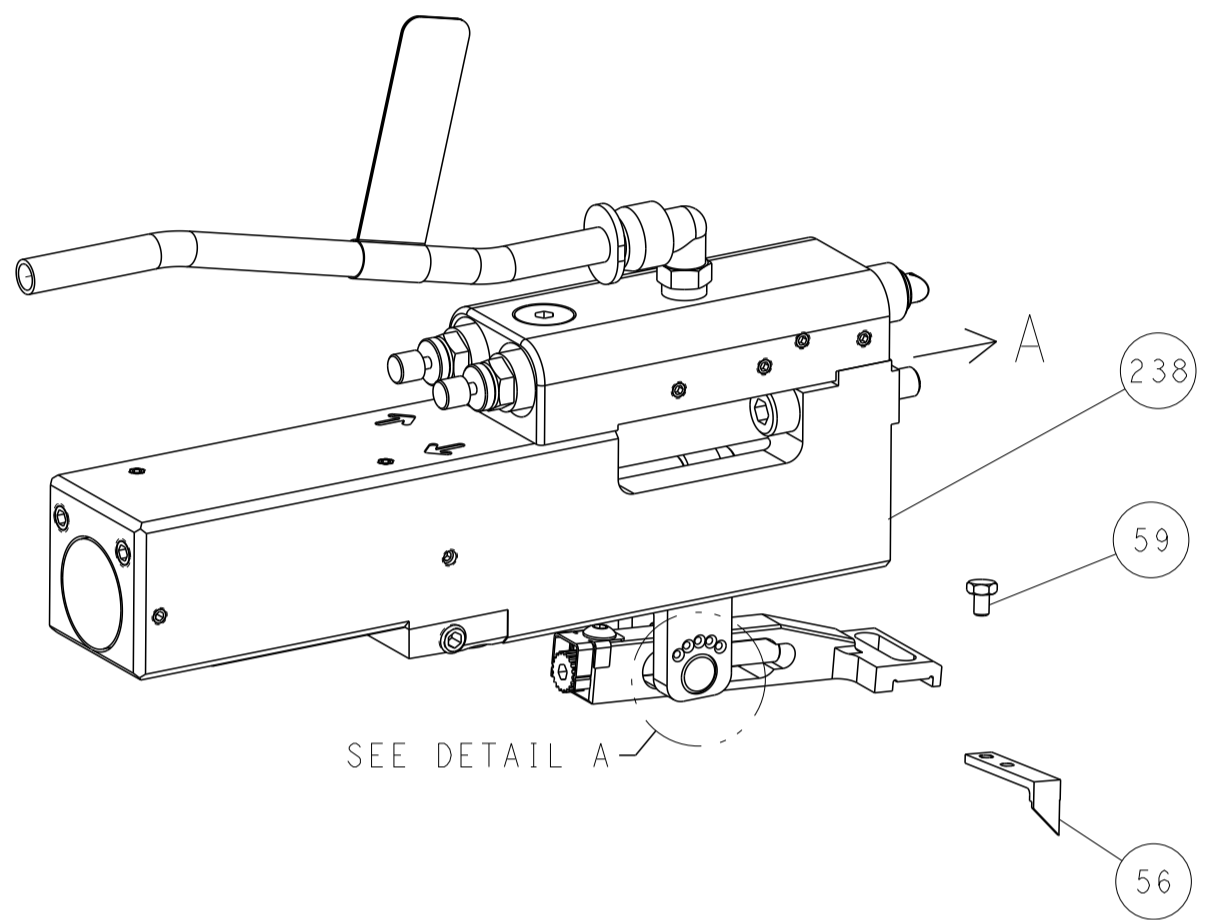
THIS DRAWING IS A CONTROLLED DOCUMENT.		OWN: S. ALVES 05APR2013	TE Connectivity
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TOLERANCES UNLESS OTHERWISE SPECIFIED:		APVD: C. LIMA 05APR2013	NAME: Ocean Side Feed Applicator
0 PLC ±		PRODUCT SPEC	
1 PLC ±		APPLICATION SPEC	SIZE: CAGE CODE DRAWING NO
2 PLC ±		RESTRICTED TO	A100779C=2837214
3 PLC ±		WEIGHT	SCALE: 1:2 SHEET 1 OF 4 REV C
4 PLC ±		CUSTOMER DRAWING	
ANGLES FINISH			

REVISIONS				
P	LTN	DESCRIPTION	DATE	APPD
-	SEE SHEET 1			

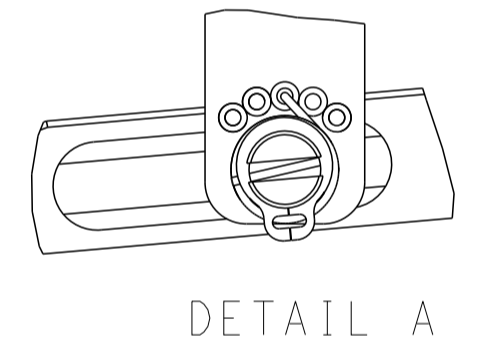
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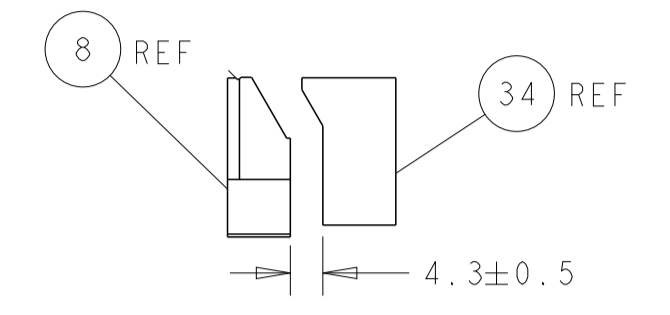
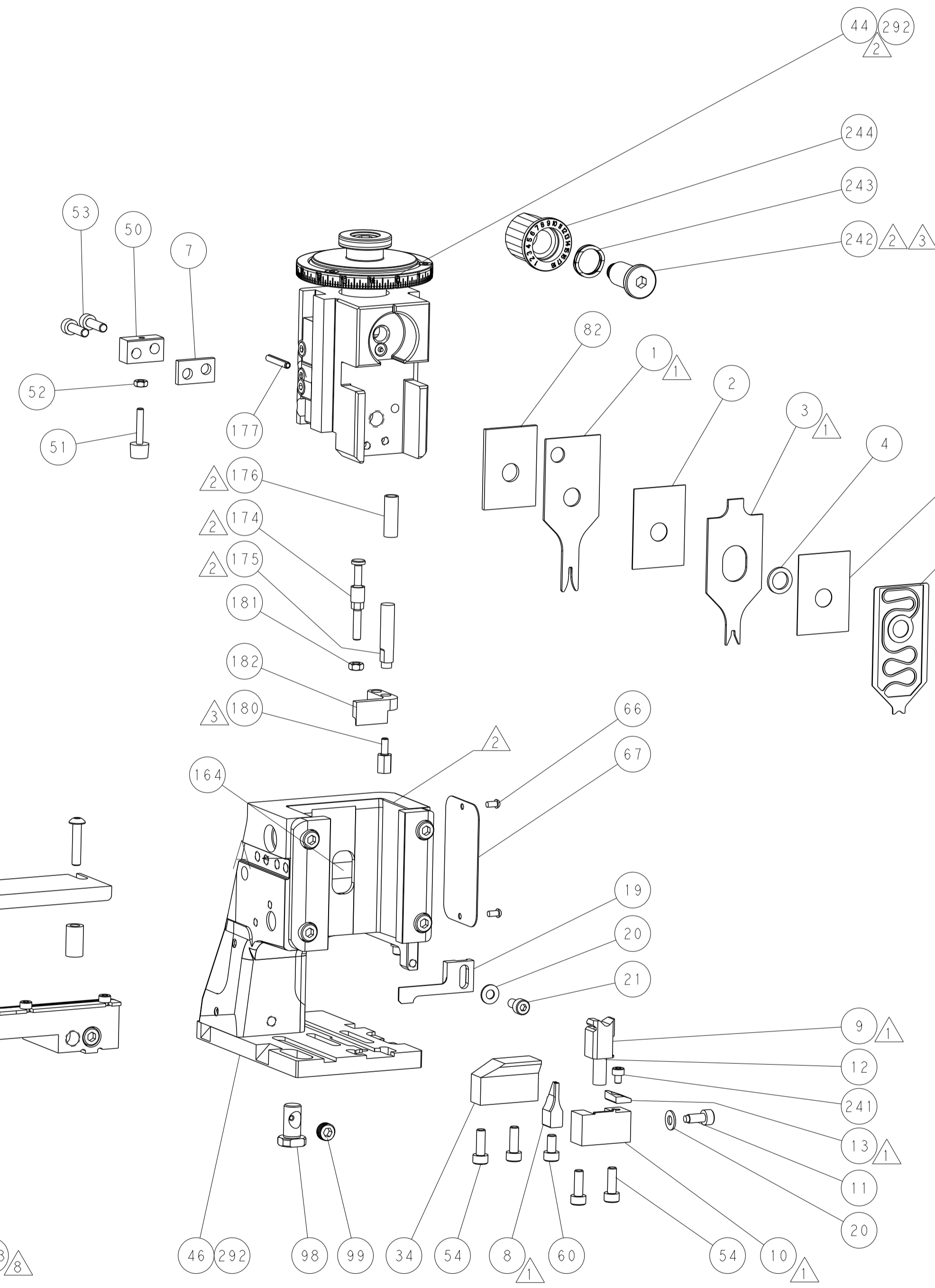
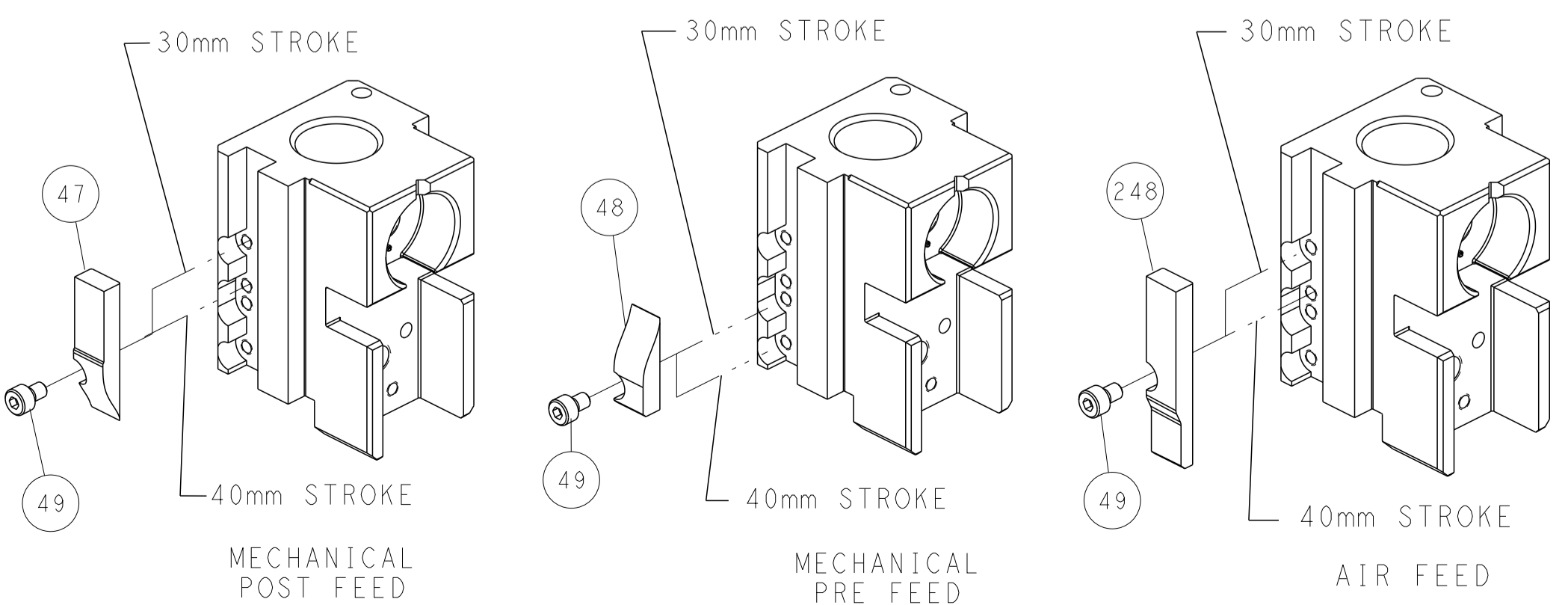
PNEUMATIC



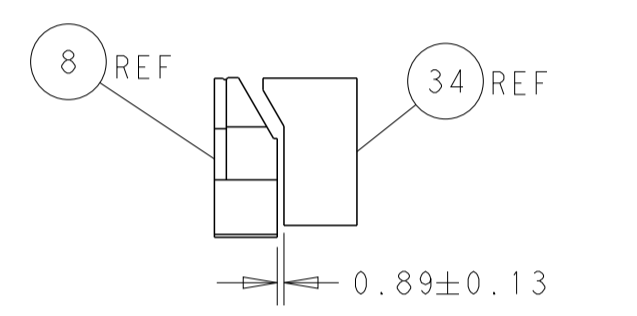
FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



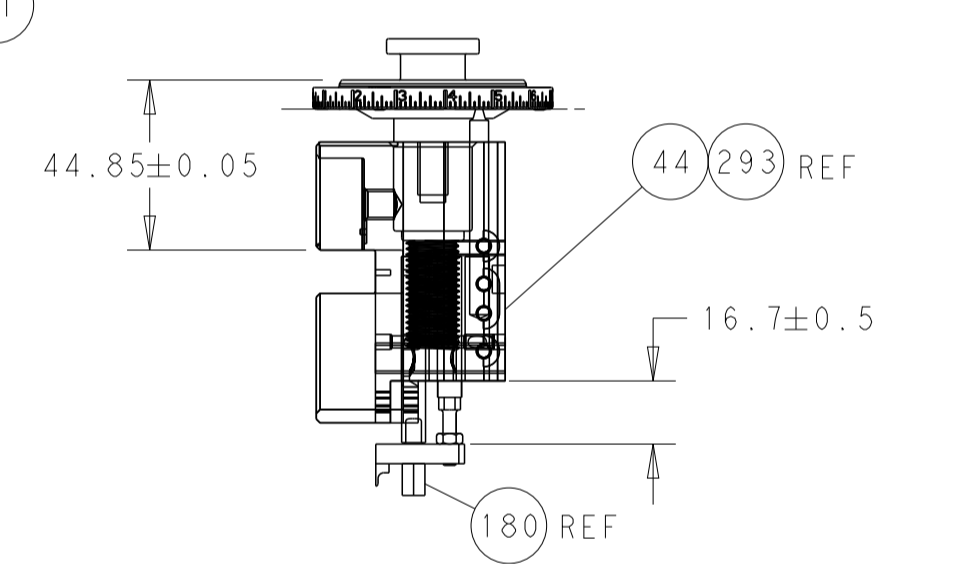
CAM POSITIONS



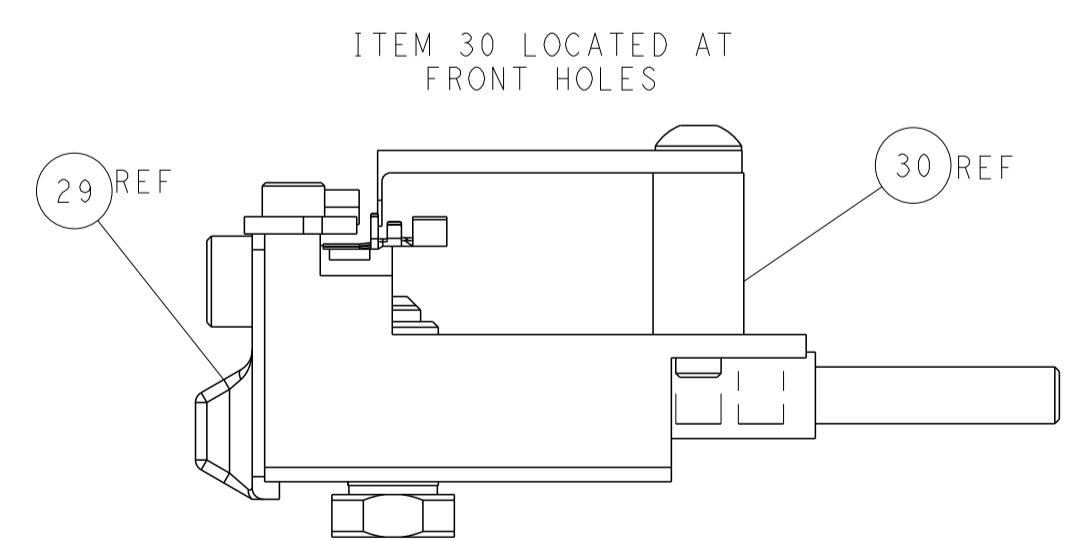
6
TERMINAL SUPPORT LOCATION FOR TERMINAL PN 2113096-1



7
TERMINAL SUPPORT LOCATION FOR TERMINAL PN 1572601-1, 1572601-2, AND 1572601-3.



RAM & HOLD DOWN SET-UP



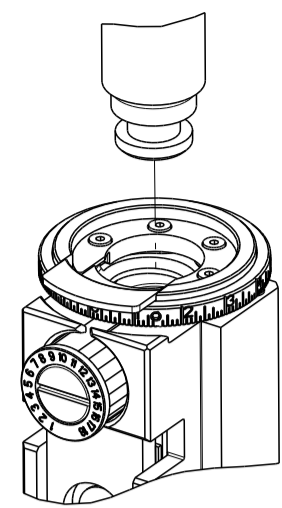
FEED TRACK POSITION GUIDE BY INSULATION BARREL

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

THIS DRAWING IS A CONTROLLED DOCUMENT.		OWN: S. ALVES 05APR2013	
DIMENSIONS: mm		CHK: P. BARLETTA 05APR2013	
TOLERANCES UNLESS OTHERWISE SPECIFIED:		APPD: C. LIMA 05APR2013	NAME: Ocean Side Feed Applicator
0 PLC ±		PRODUCT SPEC	SIZE: CAGE CODE DRAWING NO
1 PLC ±		APPLICATION SPEC	RESTRICTED TO
2 PLC ±		WEIGHT	A 00779 C=2837214
3 PLC ±		CUSTOMER DRAWING	SCALE: 1:2 SHEET 2 OF 4 REV C
4 PLC ±			
ANGLES ±			
MATERIAL			
FINISH			

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2837214-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2837214-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2837214-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.40 mm [.055]	F
INSUL	1.90 mm [.075]	F

APPLICATOR INSTRUCTIONS
408-35042

TERMINAL DATA: JST TERMINAL JST CRIMP SPECIFICATION

TERMINAL NAME: SXA 2.5mm JST	
WIRE STRIP LENGTH 1.73-2.11 mm [.068-.083 IN]	INSULATION DIAMETER RANGE Ø1.50-1.90 mm [.059-.075 IN]

TERMINAL APPLICATION SPECIFICATION XA-XAD (W-W) CHM-1-170 Rev R3

TE TERMINAL	JST TERMINAL	TE TERMINAL	JST TERMINAL
1572601-1	SXA-01T-P0.6	1572601-3	SXA-01GW-P0.6
1572601-2	SXAM-01T-P0.6	2113096-1	SXM-01T-P0.6

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
20 AWG OR 0.50mm ²	0.90 +/- 0.05 [.035 +/- .002]	6.6
22 AWG OR 0.35mm ²	0.80 +/- 0.05 [.031 +/- .002]	7.7
24 AWG OR 0.20mm ²	0.75 +/- 0.05 [.030 +/- .002]	8.2



- △ 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.
- 5. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- △ TERMINAL SUPPORT LOCATION FOR TERMINAL PN 2113096-1
- △ TERMINAL SUPPORT LOCATION FOR TERMINAL PN 1572601-1, 1572601-2, AND 1572601-3.
- △ TERMINAL LUBRICANT IS RECOMMENDED.

***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.

REVISIONS				
P	LTN	DESCRIPTION	DATE	APVD
-	-	SEE SHEET 1	-	-

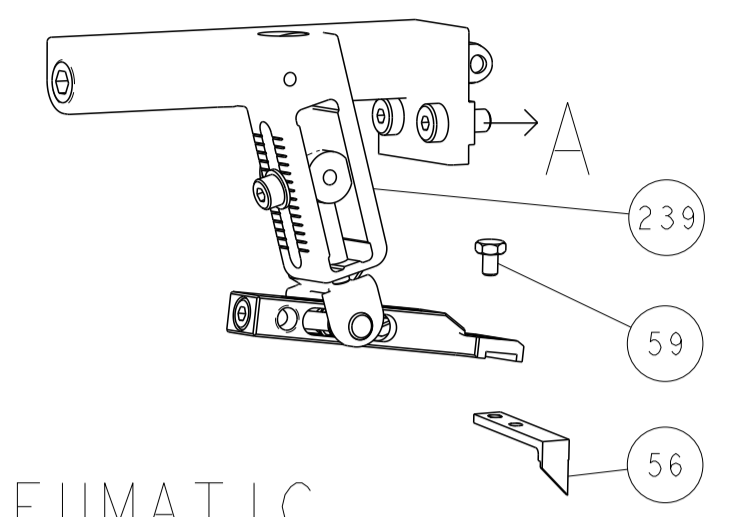
-	1	1	2119791-5	DEPRESSOR, WIRE	286
-	1	1	2119082-4	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
△	-	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
-	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	1	-	2844940-1	AIR 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
△	-	1	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113
-	1	1	2844908-1	SCREW, LOCKING	99
-	1	1	2844907-1	POST, LOCKING	98
-	1	1	1-455888-7	SPACER, CRIMPER	82
-	1	1	1803607-3	DOCUMENTATION PACKAGE	71
-	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
-	2	2	2-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 14	53
-	1	1	5018030-1	NUT, HEX, REG, RoHS, M3	52
-	1	1	811242-5	BUMPER, HOLD DOWN	51
-	1	1	690753-2	SPACER, TONKER	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	2-1752356-3	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	455888-3	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	2119533-3	STRIPPER, SIDE FEED	19
△	-	1	2119806-1	INSERT, SHEAR	13
-	1	1	3-22280-3	SPRING, COMPRESSION	12
-	1	1	1-356885-5	STOP, SHEAR	11
△	-	1	2119805-1	SHEAR HOLDER, FRONT	10
△	-	1	1803095-6	FLOATING SHEAR, FRONT	9
△	1	1	1-1633917-5	ANVIL, COMBINATION	8
-	1	1	1-240641-6	SPACER	7
-	-	-	-	-	6
-	1	1	2119757-8	DEPRESSOR, SHEAR	5
-	1	1	2-238011-0	BLOCK, CRIMPER SPACER	4
△	1	1	8-1633962-3	CRIMPER, INSULATION F PREMIUM	3
-	1	1	455888-4	SPACER, CRIMPER	2
△	1	1	3-456402-4	CRIMPER, WIRE PREMIUM	1

THIS DRAWING IS A CONTROLLED DOCUMENT.		DWN S. ALVES 05APR2013	
DIMENSIONS: mm		CHK P. BARLETTA 05APR2013	
TOLERANCES UNLESS OTHERWISE SPECIFIED:		APVD C. LIMA 05APR2013	NAME Ocean Side Feed Applicator
0 PLC ±		PRODUCT SPEC	SIZE CAGE CODE DRAWING NO
1 PLC ±		APPLICATION SPEC	RESTRICTED TO
2 PLC ±		WEIGHT	A100779C=2837214
3 PLC ±		CUSTOMER DRAWING	SCALE 1:2 SHEET 3 OF 4 REV C
4 PLC ±			
ANGLES FINISH			

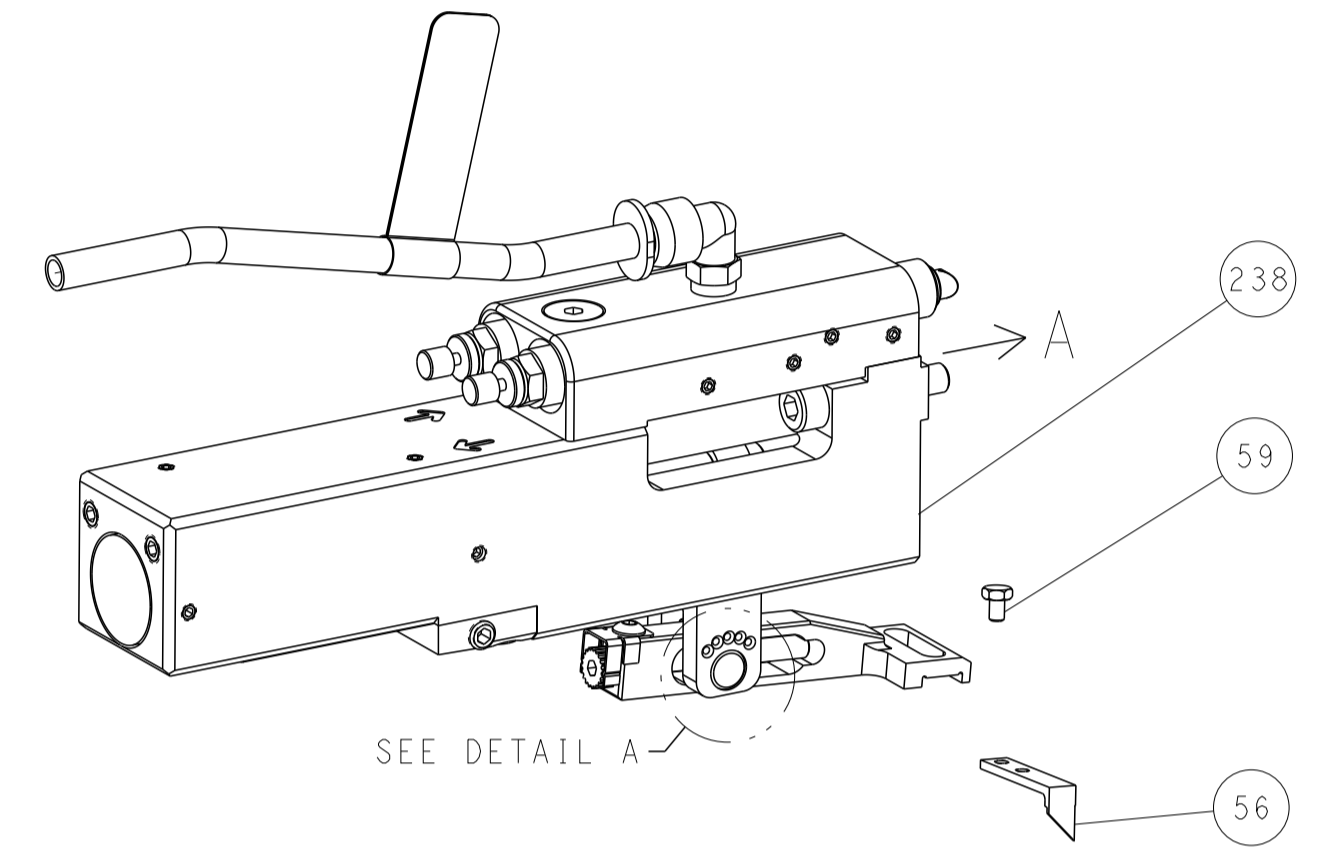
PACIFIC VERSION
Shown on sheets 3 of 4 & 4 of 4
(Atlantic version shown on sheets 1 of 4 & 2 of 4)

REVISIONS				
P	LTN	DESCRIPTION	DATE	APVD
-	-	SEE SHEET 1	-	-

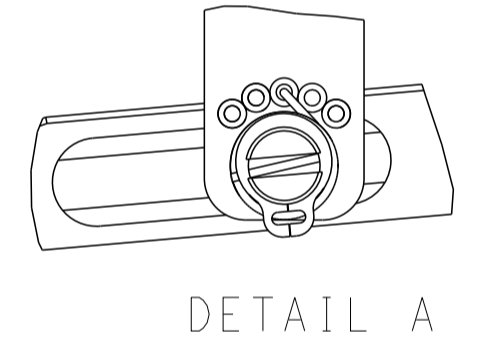
FEED TYPE MECHANICAL



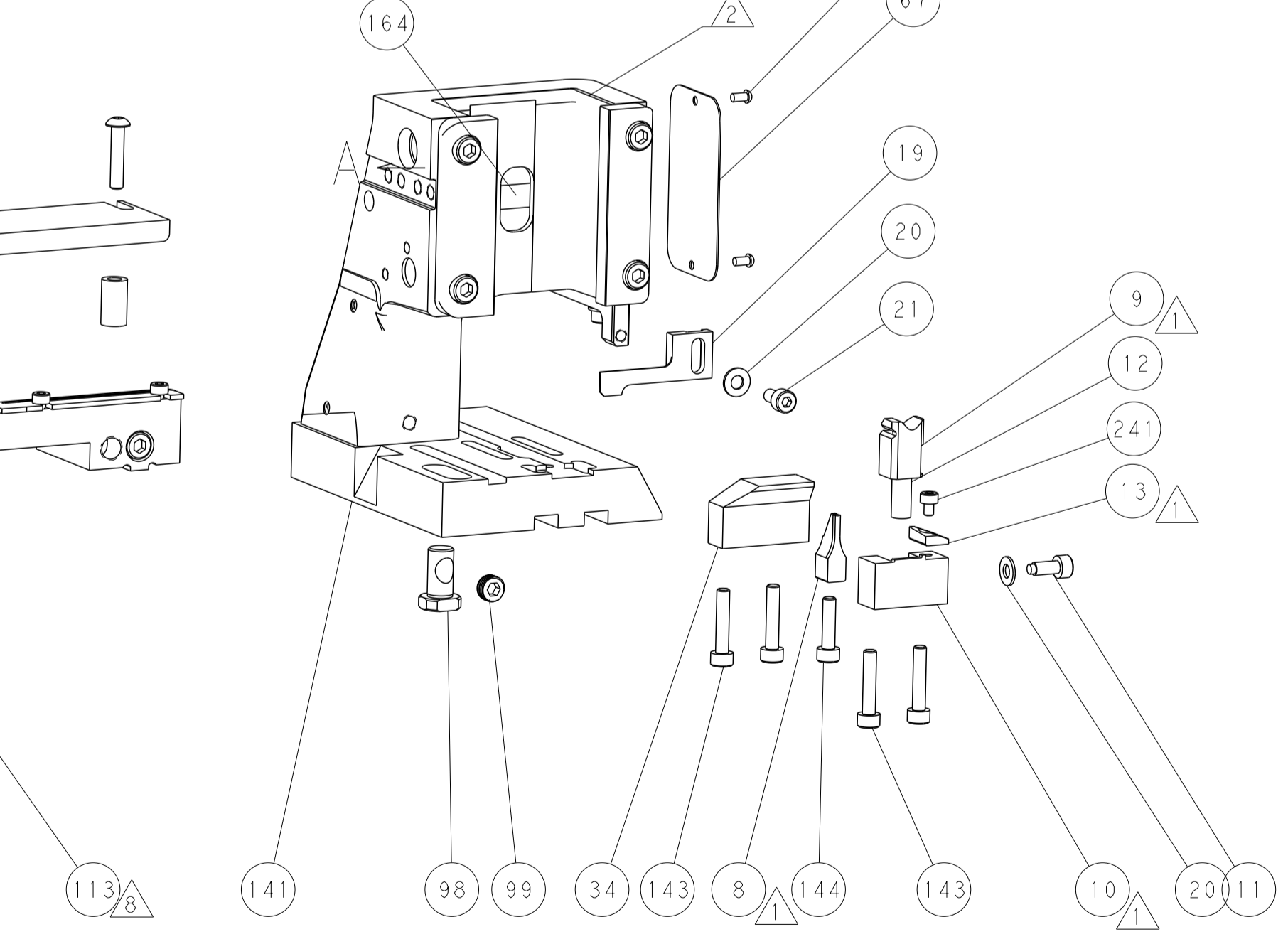
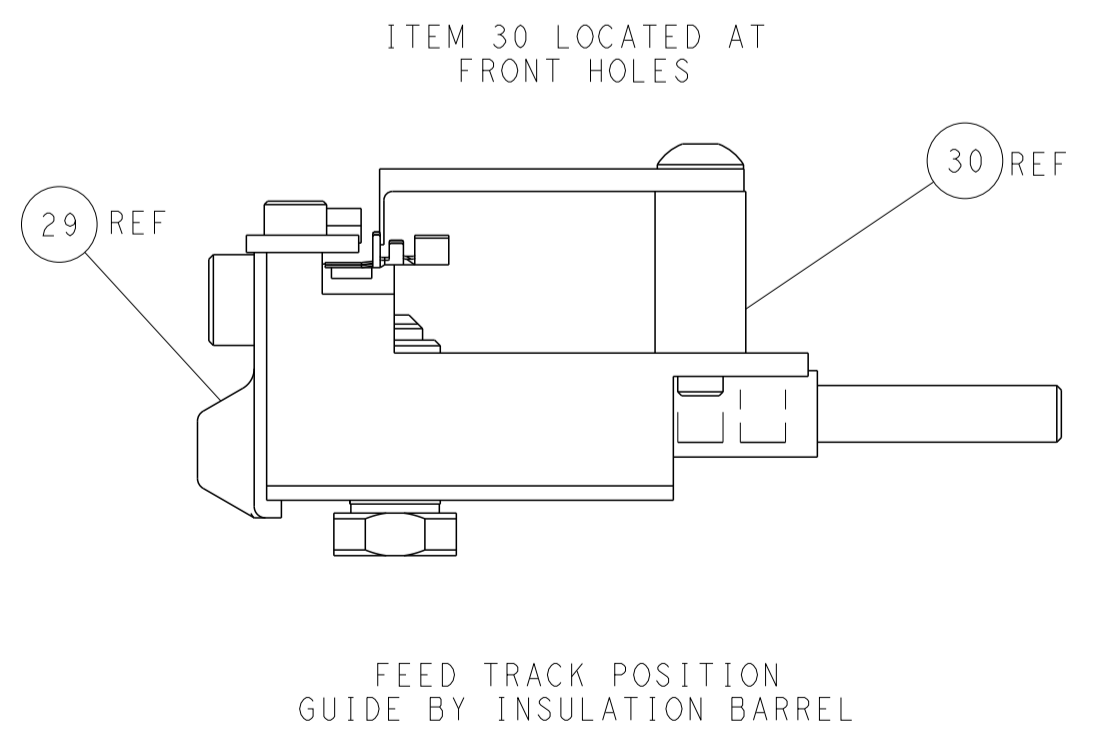
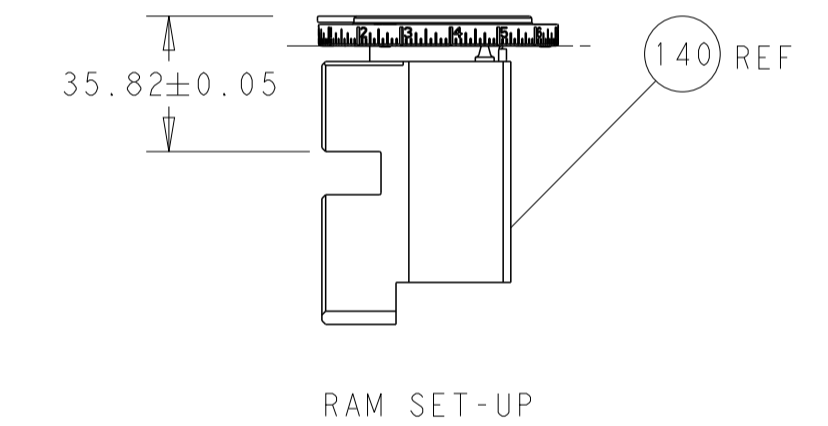
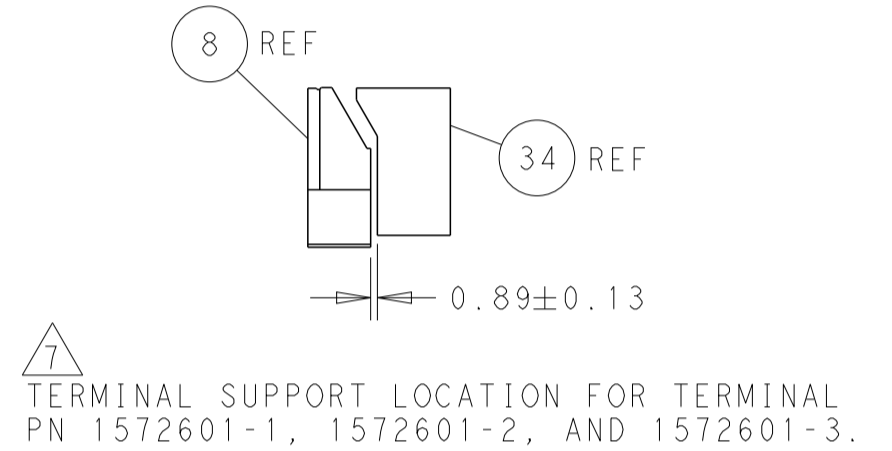
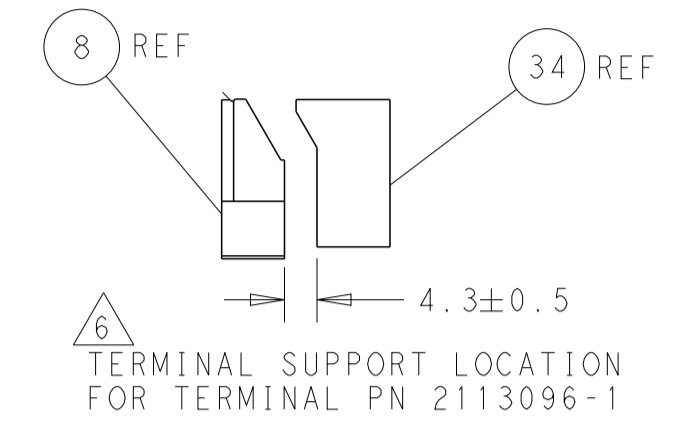
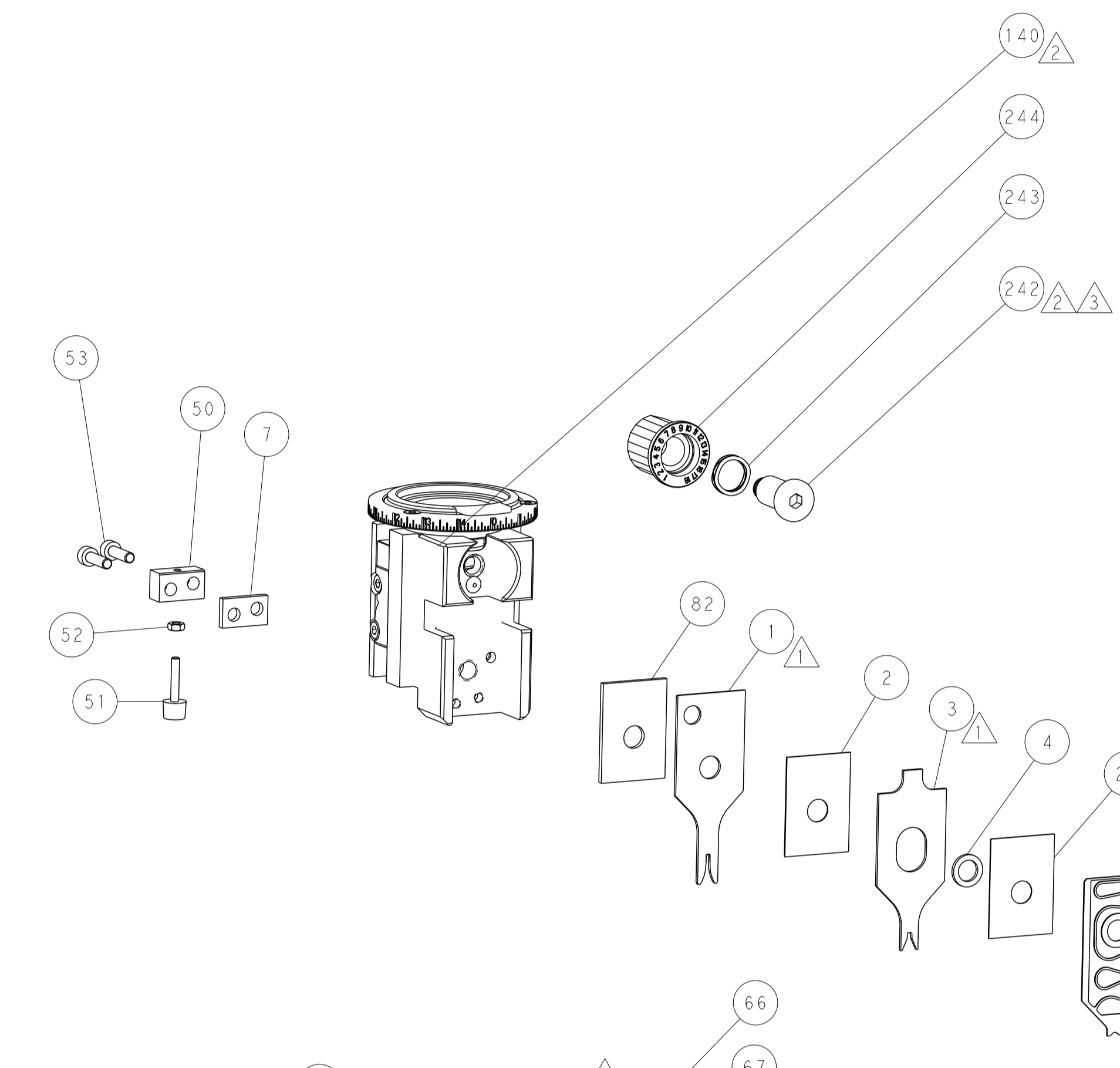
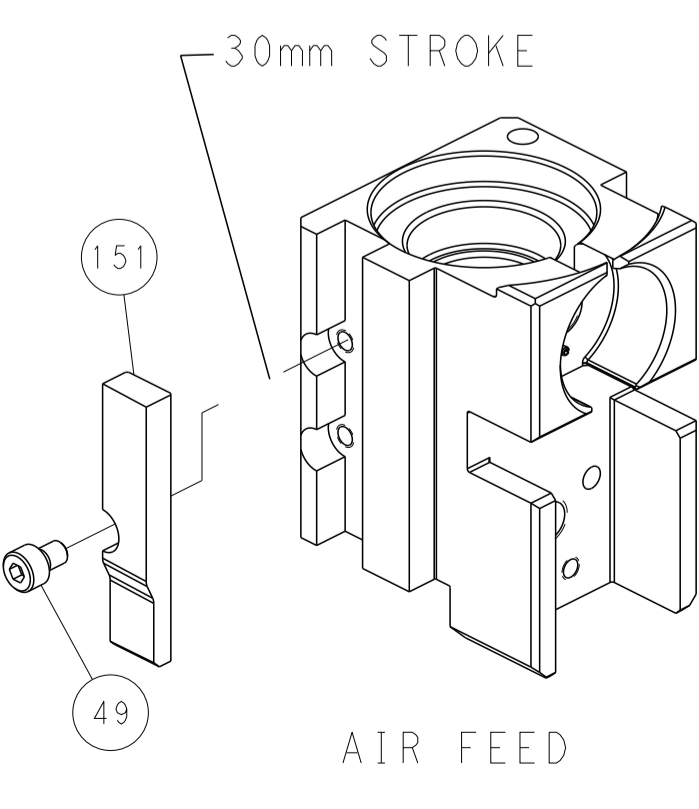
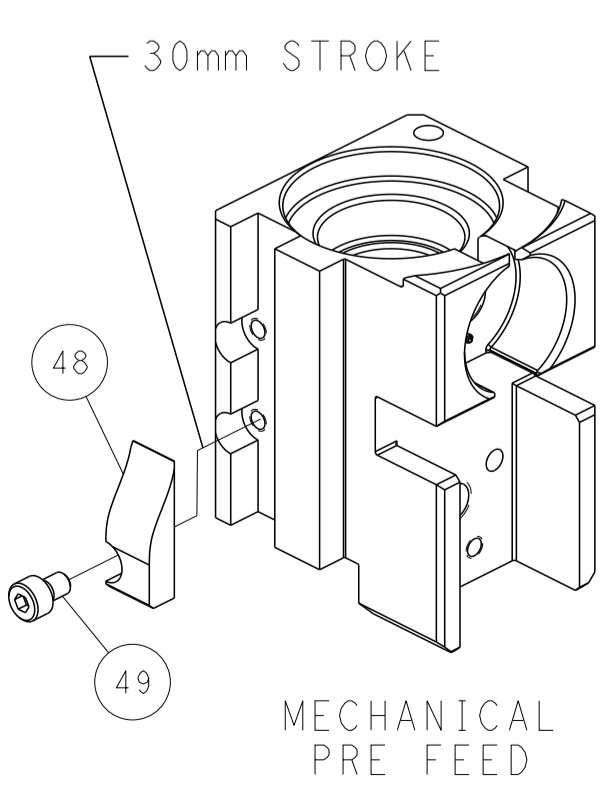
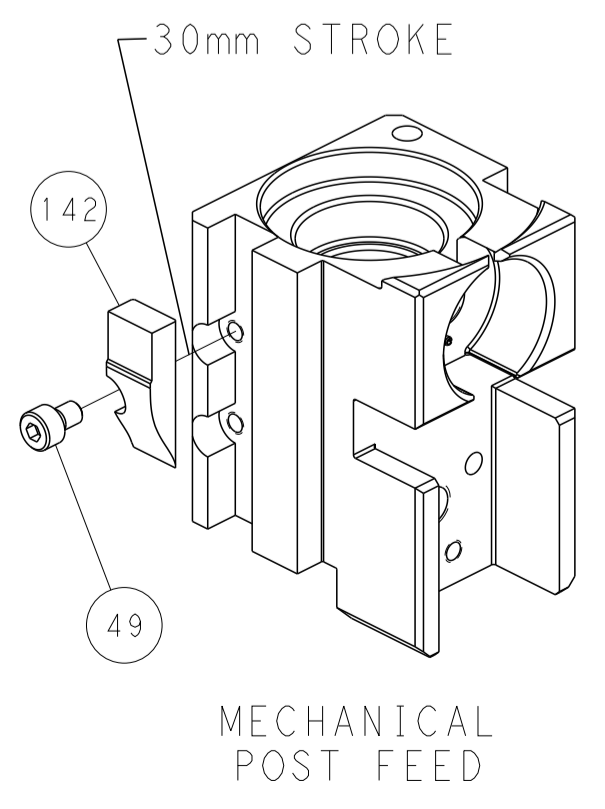
PNEUMATIC



FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



CAM POSITIONS



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

THIS DRAWING IS A CONTROLLED DOCUMENT.		OWN: S. ALVES 05APR2013	
DIMENSIONS: mm		CHK: P. BARLETTA 05APR2013	
TOLERANCES UNLESS OTHERWISE SPECIFIED:		APVD: C. LIMA 05APR2013	NAME: Ocean Side Feed Applicator
		PRODUCT SPEC: -	RESTRICTED TO: -
MATERIAL: -		APPLICATION SPEC: -	SIZE: -
FINISH: -		WEIGHT: -	CAGE CODE: -
CUSTOMER DRAWING		SCALE: 1:2	DRAWING NO: A100779
		SHEET: 4	REV: C
		OF: 4	DATE: 05APR2013