

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2837221-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2837221-2	C	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2837221-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER

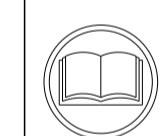


APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.27 mm [.050]	F
INSUL	1.40 mm [.055]	F
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: JAE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: SOCKET CONTACT TERMINAL			
WIRE STRIP LENGTH		TERMINAL INSULATION DIAMETER RANGE	
1.41-2.17 mm [.055-.085 IN]		Ø0.80-1.10 mm [.031-.043 IN]	
TERMINAL APPLICATION SPECIFICATION	NONE		
TERMINALS APPLIED			
TE TERMINAL	JAE TERMINAL	TE TERMINAL	JAE TERMINAL
331155-1	D02-22-26S-10000		

TERMINAL DATA: JAE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: PIN CONTACT TERMINAL			
WIRE STRIP LENGTH		TERMINAL INSULATION DIAMETER RANGE	
1.38-2.14 mm [.054-.084 IN]		Ø0.80-1.10 mm [.031-.043 IN]	
TERMINAL APPLICATION SPECIFICATION	NONE		
TERMINALS APPLIED			
TE TERMINAL	JAE TERMINAL	TE TERMINAL	JAE TERMINAL
3311692-1	D02-22-26P-10000		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
26 AWG	0.64 +/- 0.02 [.025 +/- .001]	6.0
28 AWG	0.61 +/- 0.02 [.024 +/- .001]	6.4



- 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 LUBRICANT IS RECOMMENDED.
- 6. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- PART OPTIONAL FOR BETTER LEADMAKER PERFORMANCE.

***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					
A	66	P	LTN	DESCRIPTION	DATE	OWN	APVD
		A		RELEASED	15JUN2018	TB	CT
		B		ECR-20-009765	13JUL2020	TB	RR
		C		ECR-20-011658	18AUG2020	TB	TE

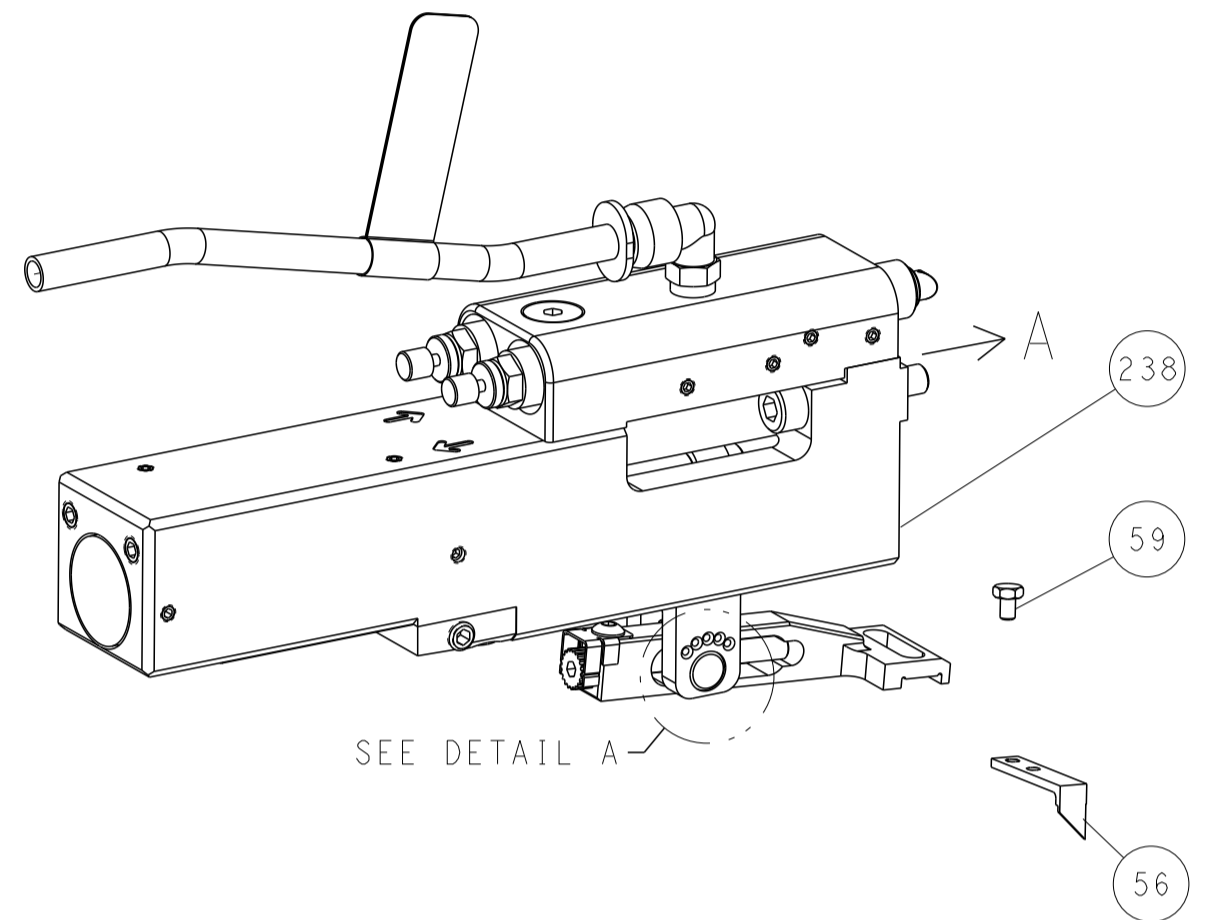
	-	1	1	2079383-1	SCR, BHSC, RoHS (M3 X 8)	284
	-	1	1	1633289-4	STABILIZER	283
	-	1	1	1803461-1	HOLDER, STABILIZER	282
	-	1	1	1-18028-3	WASHER, FLAT, REG M5	281
	-	1	1	1803196-1	STUD, ADJUSTMENT SCREW	280
	-	1	1	2330046-1	RESIN COLLAR, FLANGED	261
	-	1	1	2119641-1	FEED CAM, AIR FEED	248
	-	1	1	2119082-5	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	2844940-1	AIR FEED MODULE	238
	-	2	2	1-2079383-0	SCR, BHSC, RoHS (M3 X 6)	230
	-	1	1	1-1752354-3	STANDOFF, HOLD-DOWN	180
	-	1	1	2-1633764-2	HOLD DOWN, TERMINAL	179
	-	1	1	993111-1	PIN, SLOTTED SPRING 3.0 X 20.0	177
	-	1	1	8-22280-7	SPRING, COMPRESSION	176
	-	1	1	1752353-2	GUIDE PIN, HOLDDOWN	175
	-	1	1	1901680-2	GUIDE PIN, HOLDDOWN	174
	-	REF	REF	994970-2	COUNTER, MAGNETIC	164
	-	1	1	2161425-1	SCREW, SHOULDER	144
	-	1	1	1-22281-6	SPRING, COMPRESSION	121
	-	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	1-690438-0	FRONT STRIP GUIDE	96
	-	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	95
	-	1	1	1-994962-8	SCR, SKT HD CAP M3 X 45.0	93
	-	1	1	1803607-3	DOCUMENTATION PACKAGE	71
	-	2	2	2-2119791-2	DEPRESSOR, WIRE	70
	-	1	1	2119740-1	TAG, IDENTIFICATION	67
	-	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
	-	2	2	2-18032-5	SCR, SET, FLT PNT, M5 X 20.0	61
	-	1	1	2161425-1	SCREW, SHOULDER	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
	-	1	1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52
	-	1	1	1901681-8	HOLDDOWN, TERMINAL	51
	-	1	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49
	-	1	1	2-1803583-5	APPLICATOR BASIC ASSEMBLY, SF	46
	-	1	1	1803515-3	RAM ASSEMBLY, SF ATLANTIC	44
	-	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
	-	1	1	6-1752356-7	SUPPORT, TERMINAL	34
	-	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
	-	2	2	2-2844962-3	SPACER, CYLINDRICAL, STRIP GUIDE	30
	-	1	1	2844938-1	PLATE, STRIP GUIDE	29
	-	1	1	455888-5	SPACER, CRIMPER	28
	-	2	2	22283-1	SPRING, COMPRESSION	27
	-	1	1	356835-1	LEVER, DRAG RELEASE	26
	-	1	1	240792-1	DRAG, TERMINAL	25
	-	1	1	1320928-2	STRIP GUIDE	24
	-	1	1	980371-4	SCR, SKT HD SHLDR 5.0 DIA X 6.0	23
	-	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	1803213-1	STRIPPER	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	2-1803395-2	ANVIL, COMBINATION	8
	-	-	-	-	-	7
	-	-	-	-	-	6
	-	1	1	2119757-1	DEPRESSOR, SHEAR	5
	-	1	1	5-238011-3	BLOCK, CRIMPER SPACER	4
	1	2	1	1-1803493-4	CRIMPER, INSULATION F PREMIUM	3
	-	-	-	-	-	2
	1	2	1	2-1803407-8	CRIMPER, WIRE PREMIUM	1

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

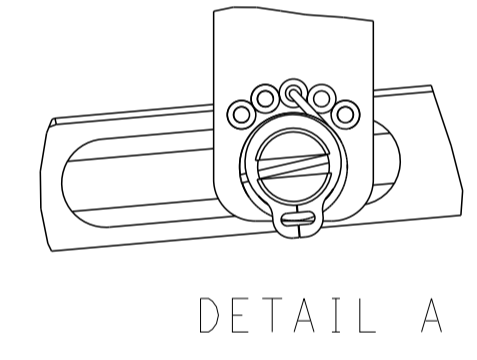
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MATERIAL: - FINISH: -		NAME: Ocean Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2837221 RESTRICTED TO: -		CUSTOMER ACCESSIBLE PRODUCTION DRAWING SCALE: 1:2 SHEET: 1 OF 4 REV: C	

LOC	DIST	REV	DATE	BY	APPD
A	66				

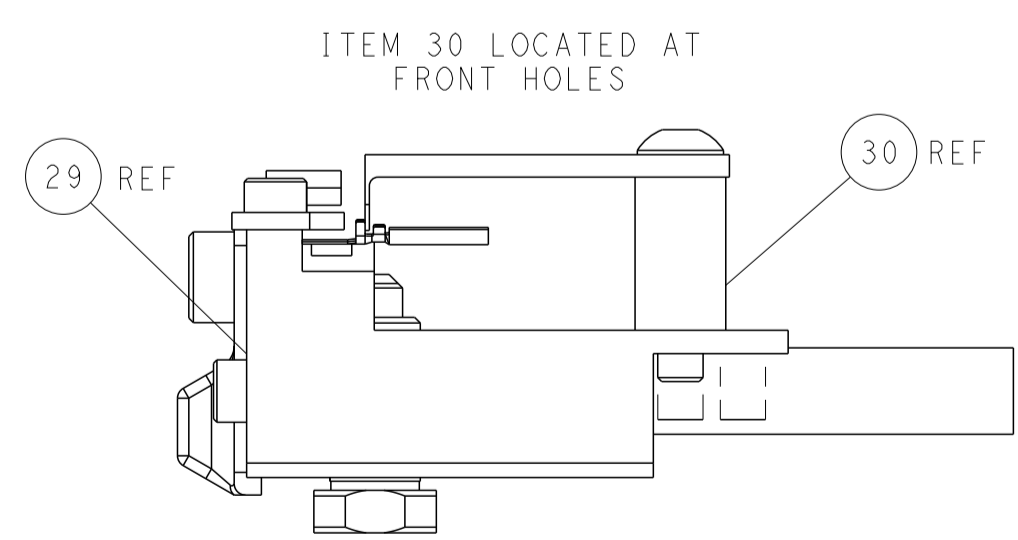
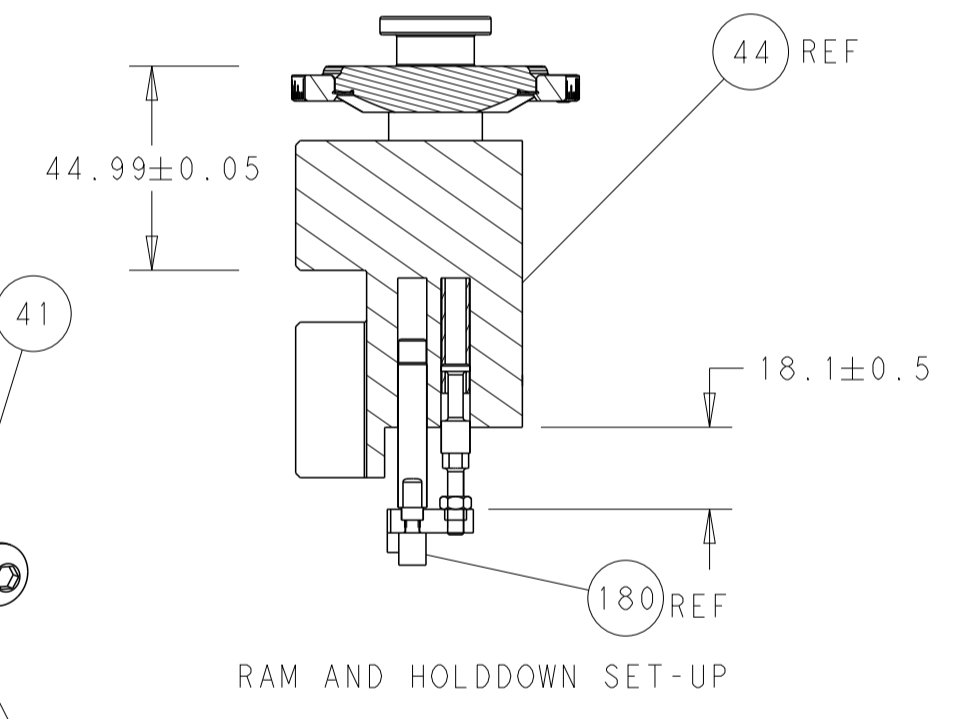
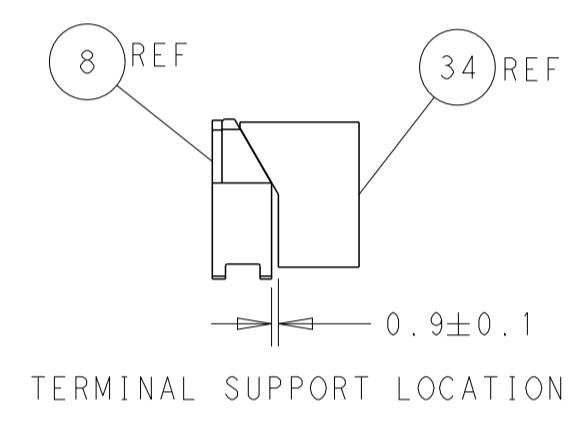
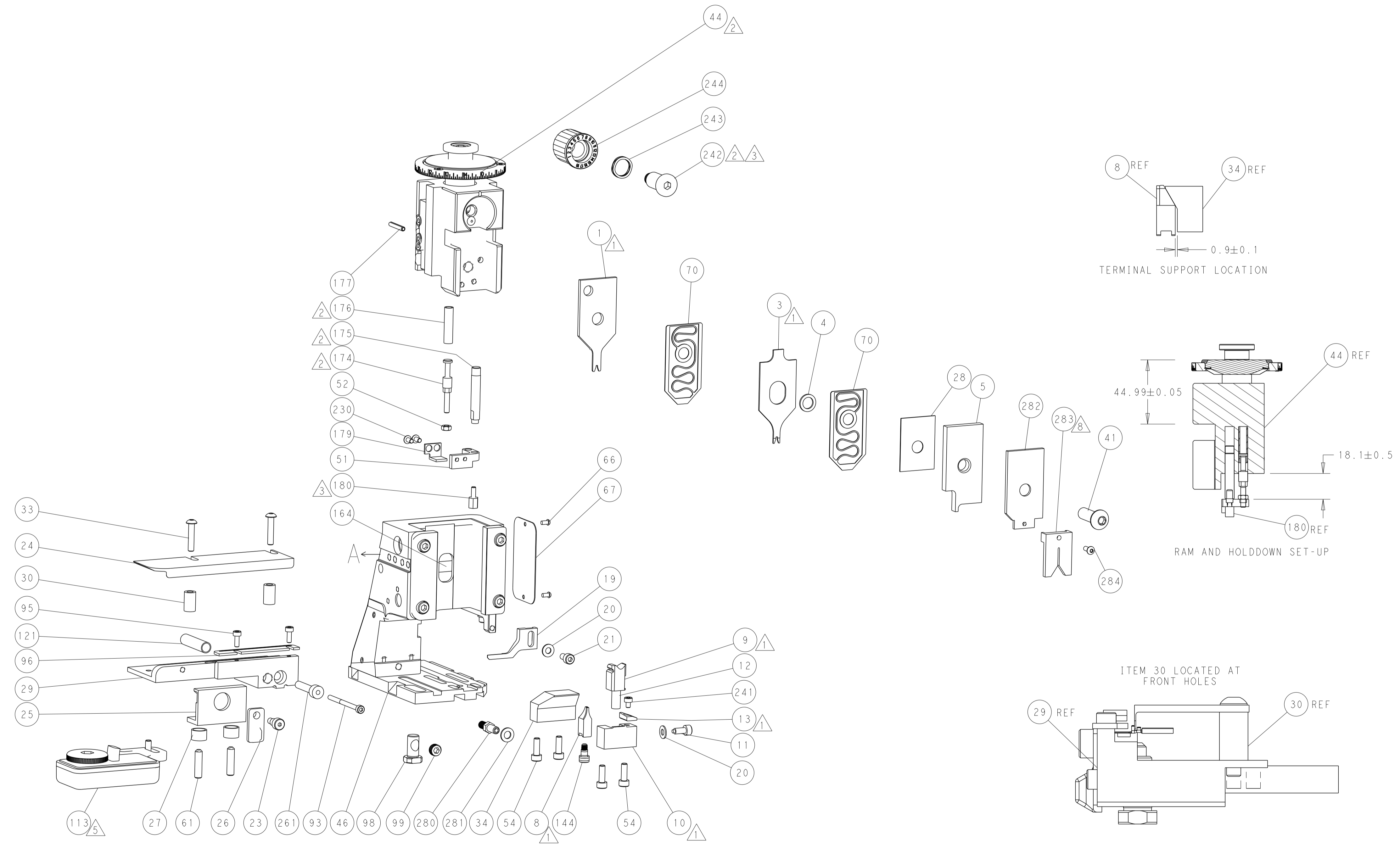
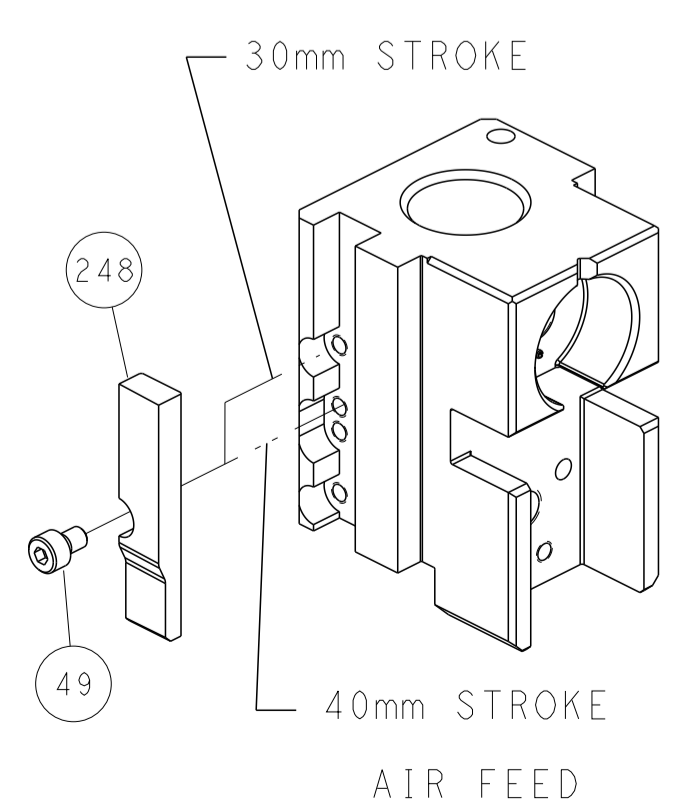
FEED TYPE PNEUMATIC



FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



CAM POSITION



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)

DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH		DWN T. BROOKS 12APR2018 CHK M. HERR 12APR2018 APVD C. TOPPER 12APR2018 PRODUCT SPEC APPLICATION SPEC WEIGHT SCALE 1:2 SHEET 2 OF 4 REV C		NAME Ocean Side Feed Applicator SIZE CAGE CODE DRAWING NO. RESTRICTED TO A1 00779 C=2837221	
MATERIAL:				CUSTOMER ACCESSIBLE PRODUCTION DRAWING			

8	7	6	5	4	3	2	1
THIS DRAWING IS UNPUBLISHED.		RELEASED FOR PUBLICATION		20			
COPYRIGHT 20 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.							
PART NUMBER	REVISION	DESCRIPTION	FEED TYPE				
2-2837221-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC				
7-2837221-7	A	CRIMP TOOLING KIT	-				

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.27 mm [.050]	F
INSUL	1.40 mm [.055]	F
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: JAE TERMINAL TE CRIMP SPECIFICATION			
TERMINAL NAME: SOCKET CONTACT TERMINAL			
WIRE STRIP LENGTH		TERMINAL INSULATION DIAMETER RANGE	
1.41-2.17 mm [.055-.085 IN]		Ø0.80-1.10 mm [.031-.043 IN]	
TERMINAL APPLICATION SPECIFICATION	NONE	-	-
TERMINALS APPLIED			
TE TERMINAL	JAE TERMINAL	TE TERMINAL	JAE TERMINAL
3311155-1	D02-22-26S-10000		

TERMINAL DATA: JAE TERMINAL TE CRIMP SPECIFICATION			
TERMINAL NAME: PIN CONTACT TERMINAL			
WIRE STRIP LENGTH		TERMINAL INSULATION DIAMETER RANGE	
1.38-2.14 mm [.054-.084 IN]		Ø0.80-1.10 mm [.031-.043 IN]	
TERMINAL APPLICATION SPECIFICATION	NONE	-	-
TERMINALS APPLIED			
TE TERMINAL	JAE TERMINAL	TE TERMINAL	JAE TERMINAL
3311692-1	D02-22-26P-10000		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
26 AWG	0.64 +/- 0.02 [.025 +/- .001]	6.0
28 AWG	0.61 +/- 0.02 [.024 +/- .001]	6.4



- 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 LUBRICANT IS RECOMMENDED.
- 6. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- PART OPTIONAL FOR BETTER LEADMAKER PERFORMANCE.

***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					
A	66	P	LTN	DESCRIPTION	DATE	DWN	APVD
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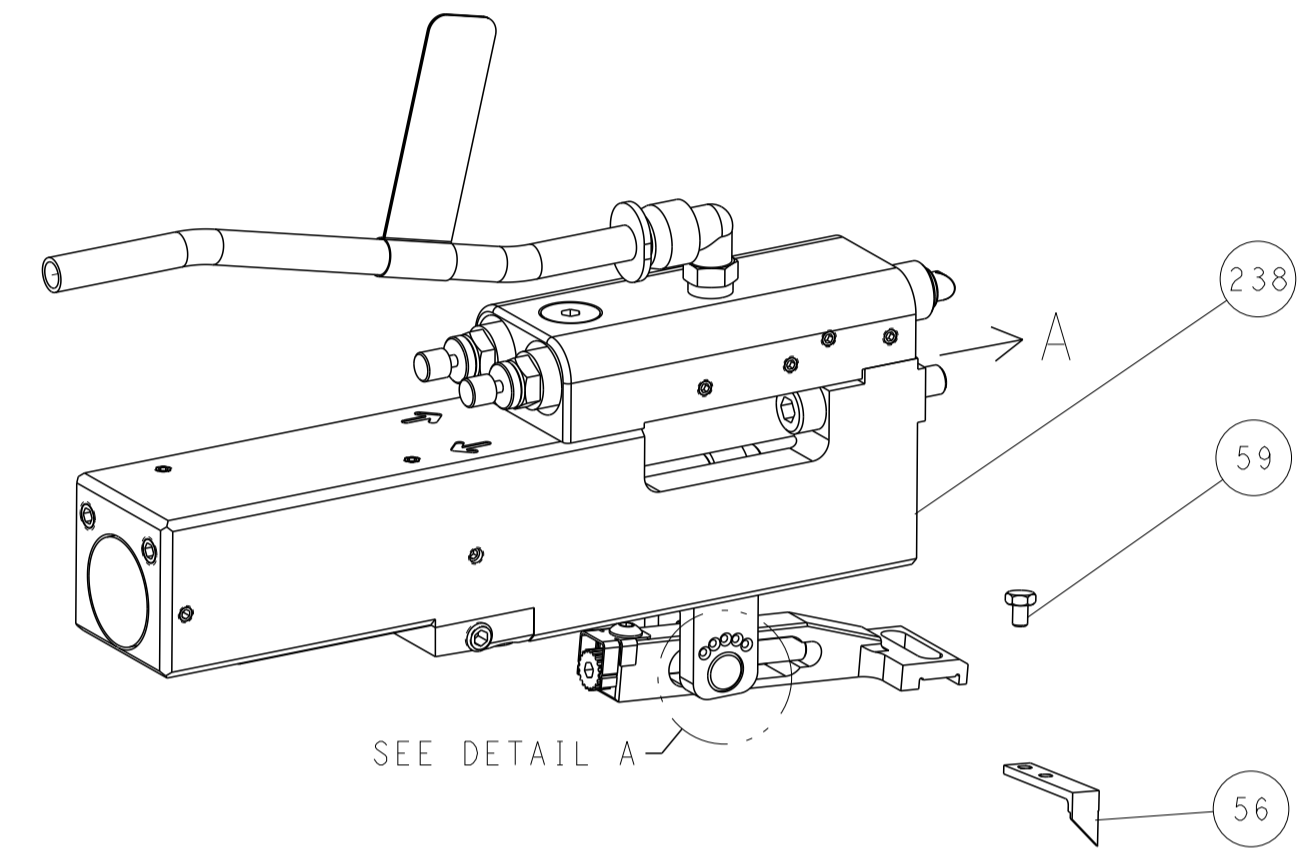
	-	1	2079383-1	SCR, BHSC, RoHS (M3 X 8)	284
	-	1	1633289-4	STABILIZER	283
	-	1	1803461-1	HOLDER, STABILIZER	282
	-	1	1-18028-3	WASHER, FLAT, REG M5	281
	-	1	1803196-1	STUD, ADJUSTMENT SCREW	280
	-	1	2330046-1	RESIN COLLAR, FLANGED	261
	-	1	2119082-5	CAM, SNAIL, INSULATION ADJUSTMENT	244
	-	1	2079764-1	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	2844940-1	AIR FEED MODULE	238
	-	2	1-2079383-0	SCR, BHSC, RoHS (M3 X 6)	230
	-	1	1-1752354-3	STANDOFF, HOLD-DOWN	180
	-	1	2-1633764-2	HOLD DOWN, TERMINAL	179
	-	1	993111-1	PIN, SLOTTED SPRING 3.0 X 20.0	177
	-	1	8-22280-7	SPRING, COMPRESSION	176
	-	1	1752353-2	GUIDE PIN, HOLDDOWN	175
	-	1	1901680-2	GUIDE PIN, HOLDDOWN	174
	REF		994970-2	COUNTER, MAGNETIC	164
	-	1	2119641-2	FEED CAM, AIR FEED	151
	-	1	2161425-1	SCREW, SHOULDER	144
	-	4	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	143
	-	1	3-1803583-0	APPLICATOR BASIC ASSEMBLY, SF	141
	-	1	1803516-1	RAM ASSEMBLY, SF PACIFIC	140
	-	1	1-22281-6	SPRING, COMPRESSION	121
	-	1	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113
	-	1	2844908-1	SCREW, LOCKING	99
	-	1	2844907-1	POST, LOCKING	98
	-	1	1-690438-0	FRONT STRIP GUIDE	96
	-	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	95
	-	1	1-994962-8	SCR, SKT HD CAP M3 X 45.0	93
	-	1	1803607-3	DOCUMENTATION PACKAGE	71
	-	2	2-2119791-2	DEPRESSOR, WIRE	70
	-	1	2119740-1	TAG, IDENTIFICATION	67
	-	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
	-	2	2-18032-5	SCR, SET, FLT PNT, M5 X 20.0	61
	-	1	2161425-1	SCREW, SHOULDER	60
	-	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
	-	1	1338685-1	PAWL, FEED	56
	-	1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52
	-	1	1901681-8	HOLDDOWN, TERMINAL	51
	-	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49
	-	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
	-	1	6-1752356-7	SUPPORT, TERMINAL	34
	-	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
	-	2	2-2844962-3	SPACER, CYLINDRICAL, STRIP GUIDE	30
	-	1	2844938-1	PLATE, STRIP GUIDE	29
	-	1	455888-5	SPACER, CRIMPER	28
	-	2	22283-1	SPRING, COMPRESSION	27
	-	1	356835-1	LEVER, DRAG RELEASE	26
	-	1	240792-1	DRAG, TERMINAL	25
	-	1	1320928-2	STRIP GUIDE	24
	-	1	980371-4	SCR, SKT HD SHLDR 5.0 DIA X 6.0	23
	-	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
	-	2	1-18028-2	WASHER, FLAT, REG M4	20
	-	1	1803213-1	STRIPPER	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	2-1803395-2	ANVIL, COMBINATION	8
	-	-	-	-	7
	-	-	-	-	6
	-	1	2119757-1	DEPRESSOR, SHEAR	5
	-	1	5-238011-3	BLOCK, CRIMPER SPACER	4
	1	1	1-1803493-4	CRIMPER, INSULATION F PREMIUM	3
	-	-	-	-	2
	1	1	2-1803407-8	CRIMPER, WIRE PREMIUM	1

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

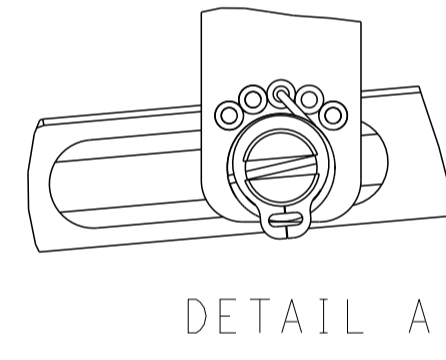
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN T. BROOKENS 12APR2018	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±
	ANGLES	FINISH		APVD C. TOPPER 12APR2018	CHK M. HERR 12APR2018
MATERIAL				PRODUCT SPEC	NAME
				APPLICATION SPEC	Ocean Side Feed Applicator
				SIZE	CAGE CODE
				A1	00779
				SCALE	1:2
				SHEET	3 OF 4
				REV	C

LOC	DIST	REV	DATE	BY	APPD
A	66				
REVISIONS			DESCRIPTION	DATE	BY
-			SEE SHEET 1	-	-

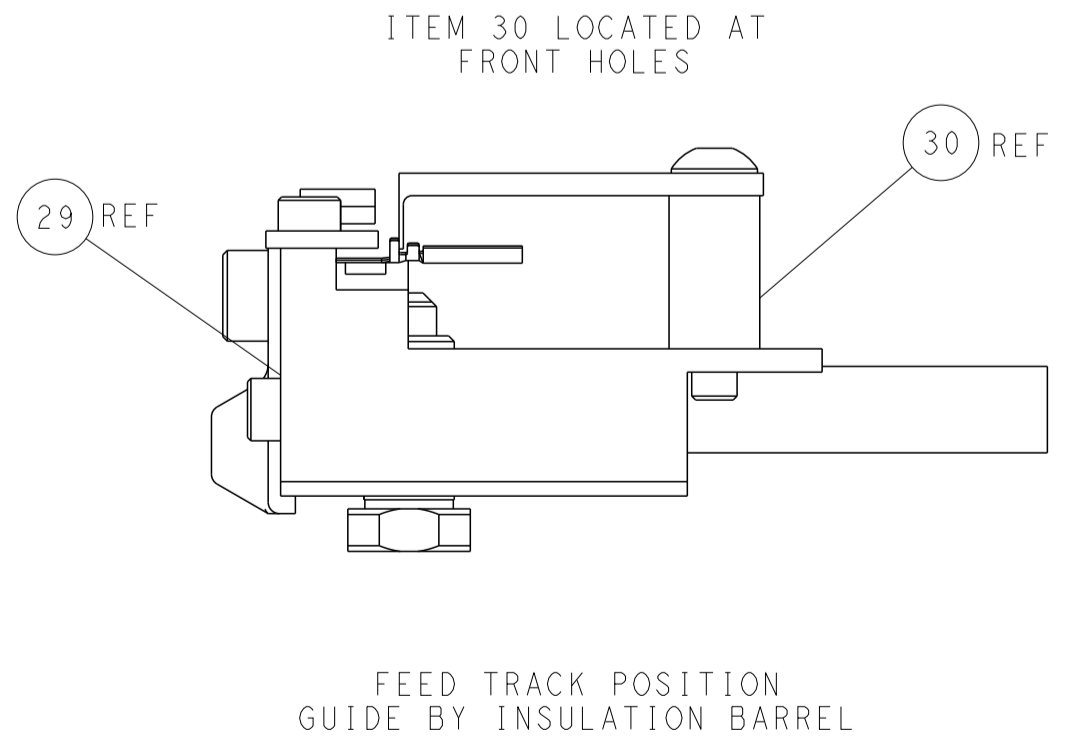
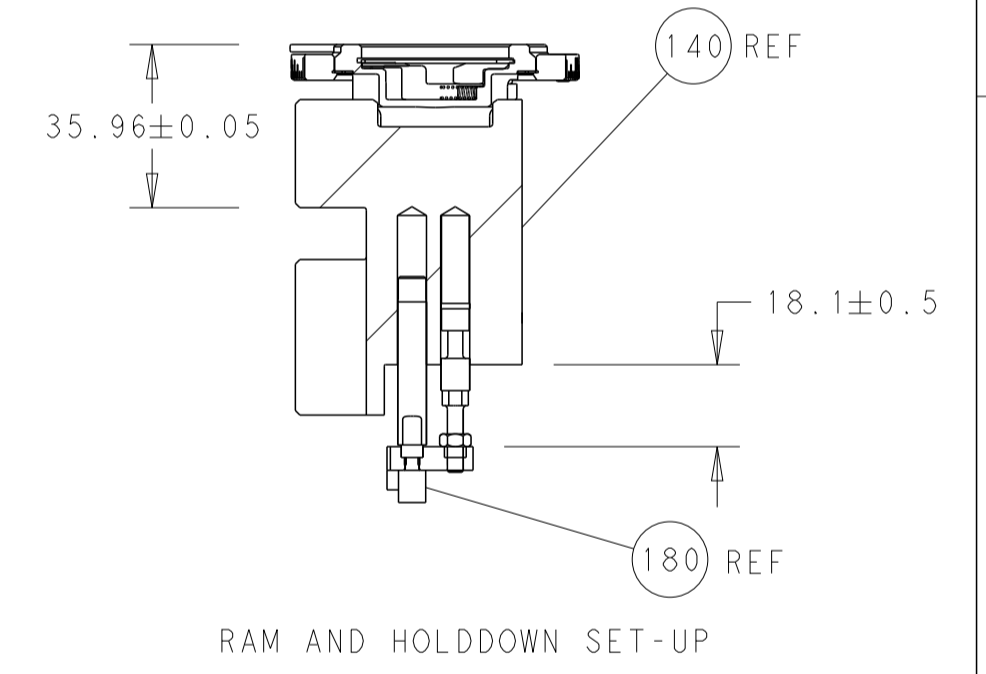
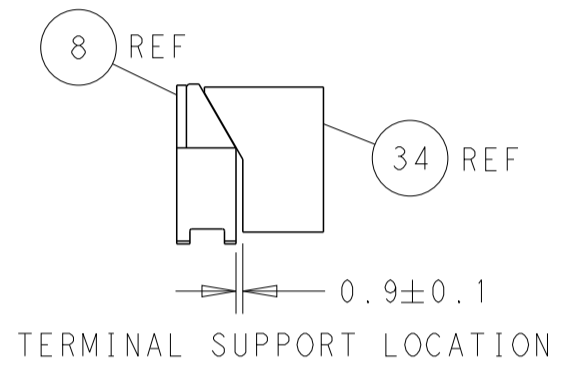
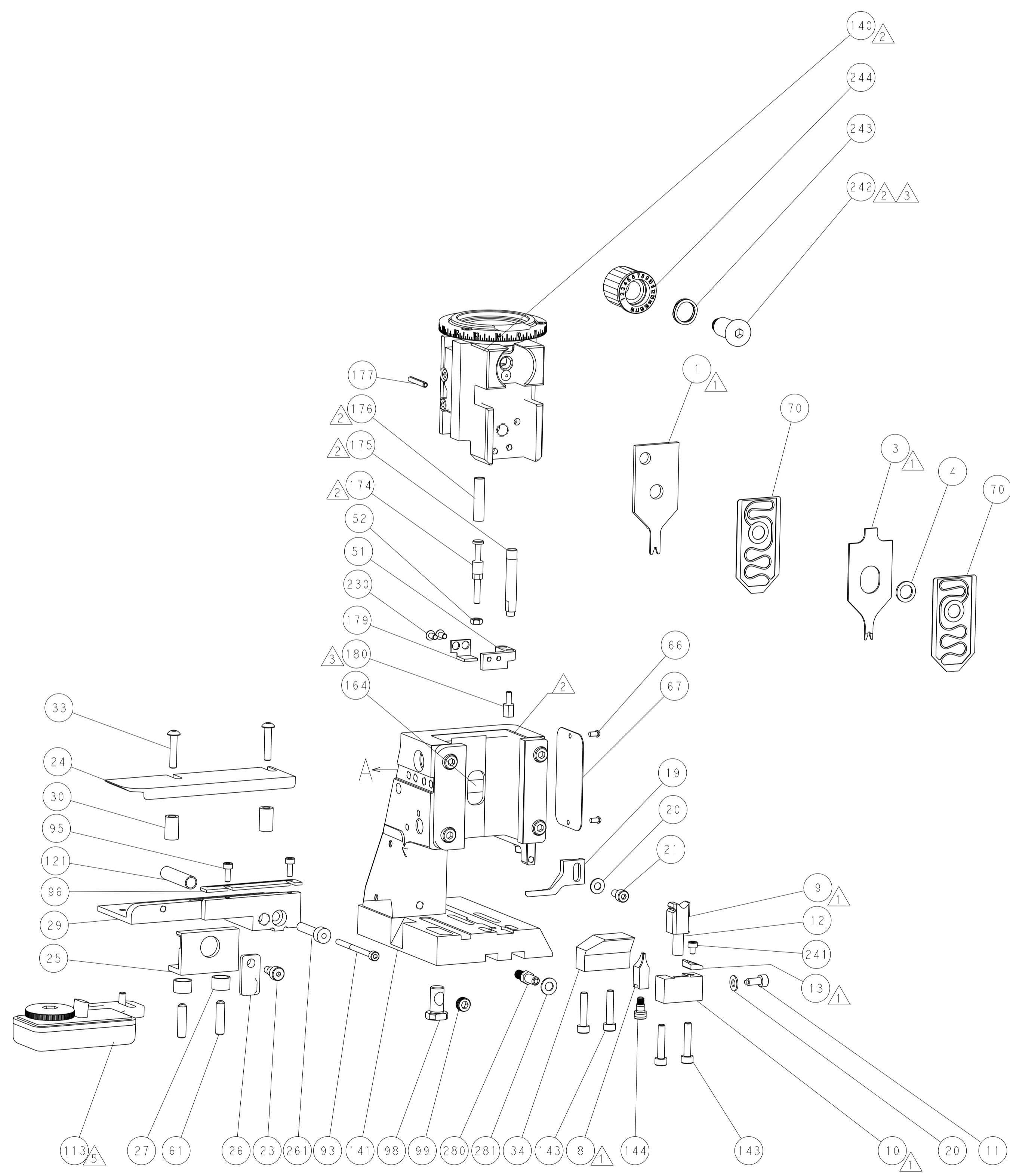
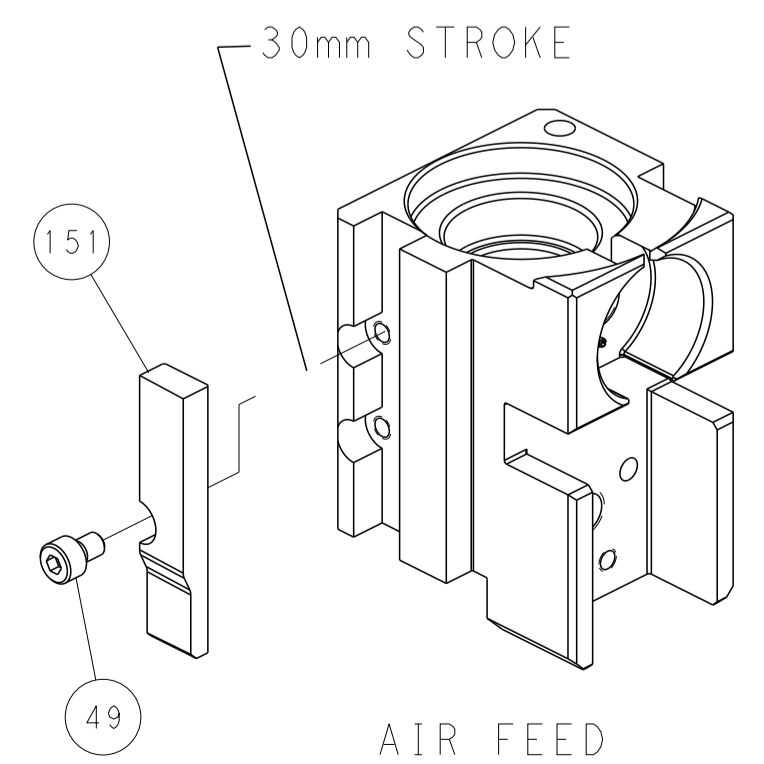
FEED TYPE PNEUMATIC



FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



CAM POSITION



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 T. BROOKENS 12APR2018		TE Connectivity	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	5 PLC ±	Harrisburg, PA 17105-3608
	ANGLES	FINISH		CHK M. HERR 12APR2018	NAME	Ocean Side Feed Applicator	
MATERIAL				APVD C. TOPPER 12APR2018	PRODUCT SPEC	RESTRICTED TO	
				APPLICATION SPEC	SIZE	CAGE CODE	DRAWING NO
				WEIGHT	A1	00779	2837221
Customer Accessible Production Drawing				SCALE	1:2	SHEET	4 OF 4