

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2837321-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2837321-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2837321-1	B	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2837321-2	C	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2837321-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.20 mm [.047]	F
INSUL	1.40 mm [.055]	F

APPLICATOR INSTRUCTIONS  
408-35042

TERMINAL DATA: MOLEX TERMINAL		MOLEX CRIMP SPECIFICATION	
TERMINAL NAME: 2.0 WIRE TO BOARD CONN.			
WIRE STRIP LENGTH		TERMINAL INSULATION DIAMETER RANGE	
1.30-1.80 mm [.051-.071 IN]		Ø1.15-1.50 mm [.045-.059 IN]	
TERMINAL APPLICATION SPECIFICATION	CS-505153-001 Rev E		
TERMINALS APPLIED			
TE TERMINAL	MOLEX TERMINAL	TE TERMINAL	MOLEX TERMINAL
3311245-1	505153-8000		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.30mm2	0.72+/- .025 [.028+/- .001]	5.3
22 AWG	0.68+/- .025 [.027+/- .001]	5.8
24 AWG	0.62+/- .025 [.024+/- .001]	6.3

- 1. RECOMMENDED SPARE PARTS
- 2. REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- 3. APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 180. 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					
A	66	P	LTN	DESCRIPTION	DATE	DWN	APVD
		A		RELEASED	11SEP2018	RK	TE
		B		ECR-19-000180	07JAN2019	FL	CT
		C		ECR-20-013008	14SEP2020	TB	RK

-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248	
-	1	1	1	1	2119082-5	CAM, SNAIL, INSULATION ADJUSTMENT	244	
-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243	
3	-	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	
-	2	2	2	2	1-2079383-0	SCR, BHSC, RoHS (M3 X 6)	230	
3	-	1	1	1	1-1752354-5	STANDOFF, HOLD-DOWN	180	
-	1	1	1	1	1-1633764-5	HOLD DOWN, TERMINAL	179	
-	1	1	1	1	6-993111-6	PIN, SLOTTED SPRING 3.0 X 14.0	177	
-	1	1	1	1	8-22280-7	SPRING, COMPRESSION	176	
-	1	1	1	1	1752353-2	GUIDE PIN, HOLDDOWN	175	
-	1	1	1	1	1901680-2	GUIDE PIN, HOLDDOWN	174	
-	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	1-455888-1	SPACER, CRIMPER	82	
-	1	1	1	1	1803607-3	DOCUMENTATION PACKAGE	71	
-	1	1	1	1	2119791-9	DEPRESSOR, WIRE	70	
-	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	
-	4	4	4	4	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	54	
-	1	1	1	1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52	
-	1	1	1	1	1901681-8	HOLDDOWN, TERMINAL	51	
-	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	1803515-3	RAM ASSEMBLY, SF ATLANTIC	44	
-	1	1	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41	
-	1	1	1	1	7-1752356-9	SUPPORT, TERMINAL	34	
-	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	1803213-1	STRIPPER	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	1	2	2	1	1	3-1803703-9	ANVIL, COMBINATION	8
-	-	-	-	-	-	-	7	
-	-	-	-	-	-	-	6	
-	1	1	1	1	2119757-1	DEPRESSOR, SHEAR	5	
-	1	1	1	1	4-238011-8	BLOCK, CRIMPER SPACER	4	
1	1	2	2	1	1	5-1803017-8	CRIMPER, INSULATION F	3
-	1	1	1	1	455888-6	SPACER, CRIMPER	2	
1	1	2	2	1	1	1803188-2	CRIMPER, WIRE	1

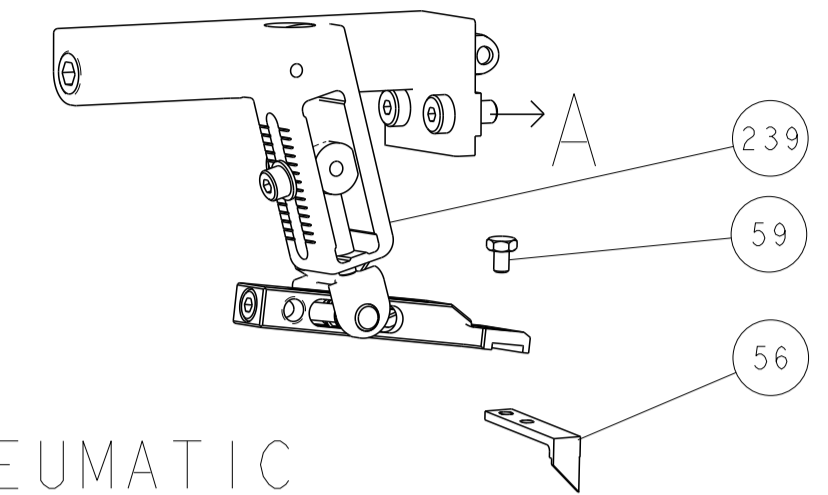
**ATLANTIC VERSION**  
Shown on sheets 1 of 4 & 2 of 4  
(Pacific version shown on sheets 3 of 4 & 4 of 4)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		MATERIAL:		FINISH:	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES ±	FINISH ±

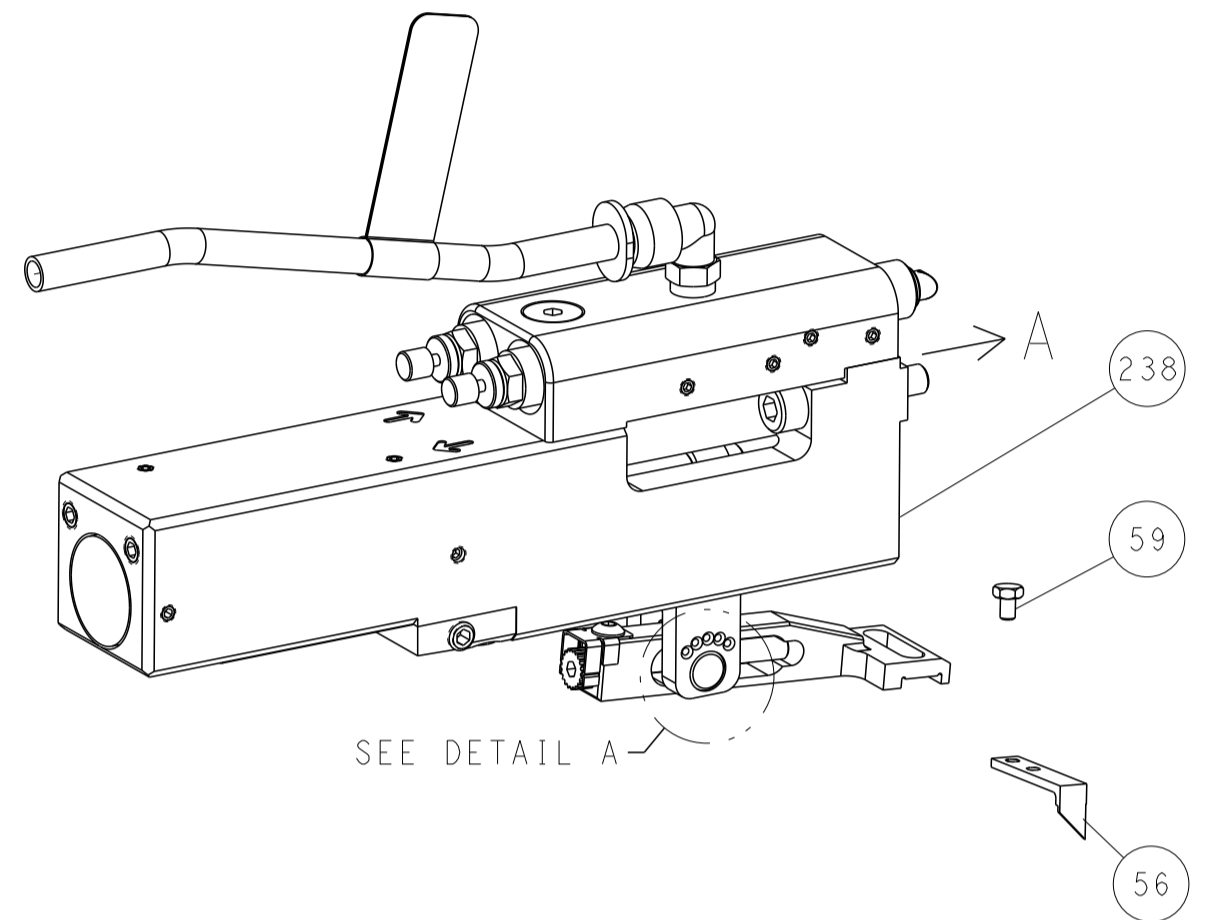
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CHK	M. HERR	03JUL2018	
APVD	C. TOPPER	03JUL2018	
PRODUCT SPEC			
APPLICATION SPEC			
SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
A1	00779	2837321	
Customer Accessible Production Drawing			SCALE 1:2 SHEET 1 OF 4 REV C

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

# FEED TYPE MECHANICAL



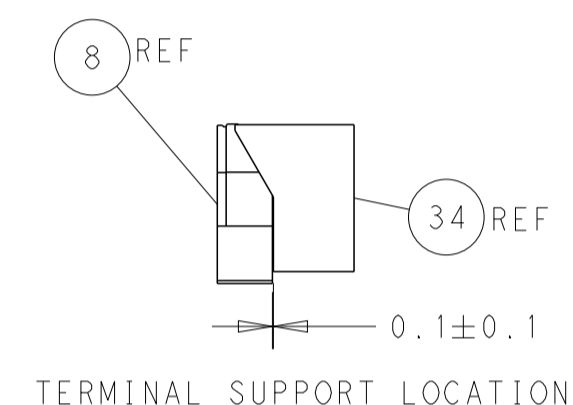
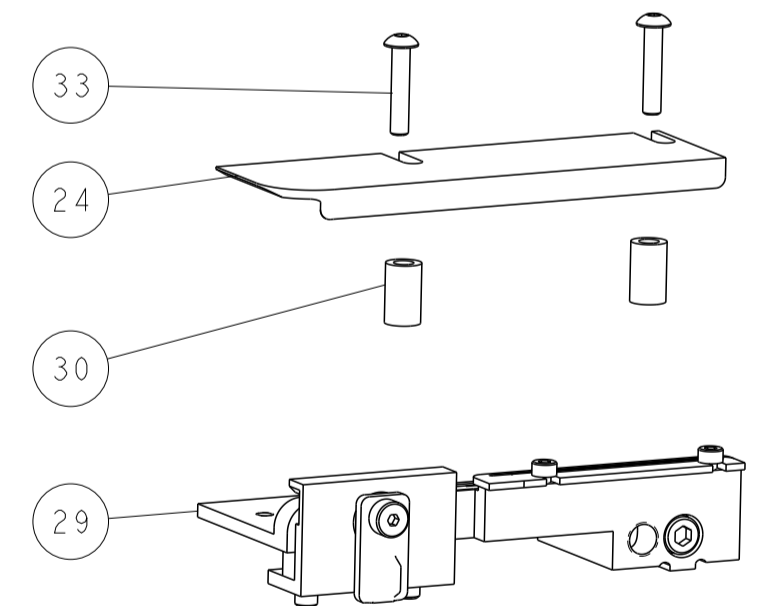
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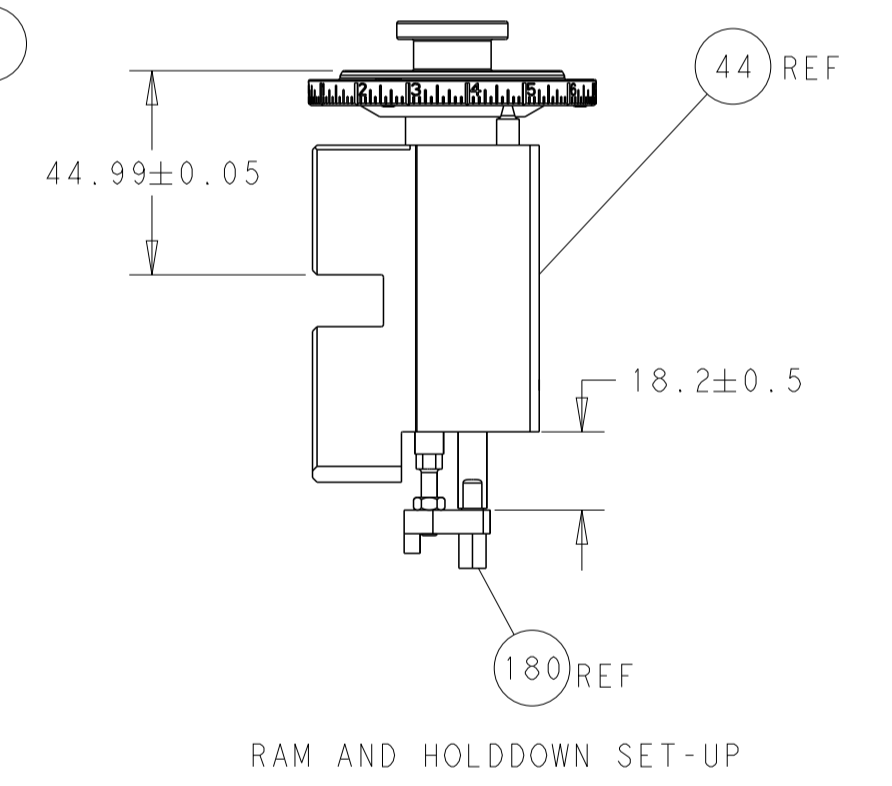
## FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



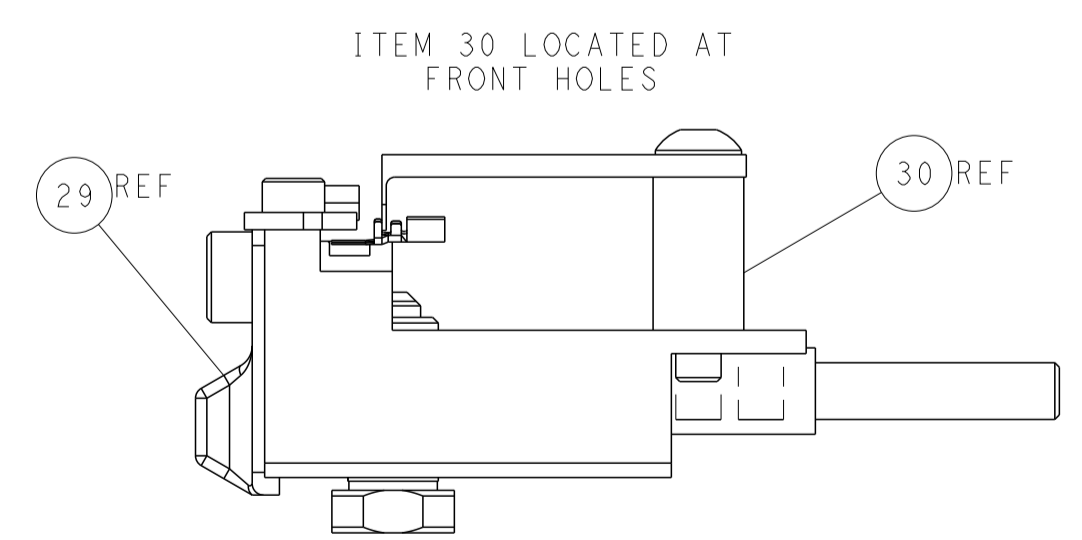
DETAIL A



TERMINAL SUPPORT LOCATION

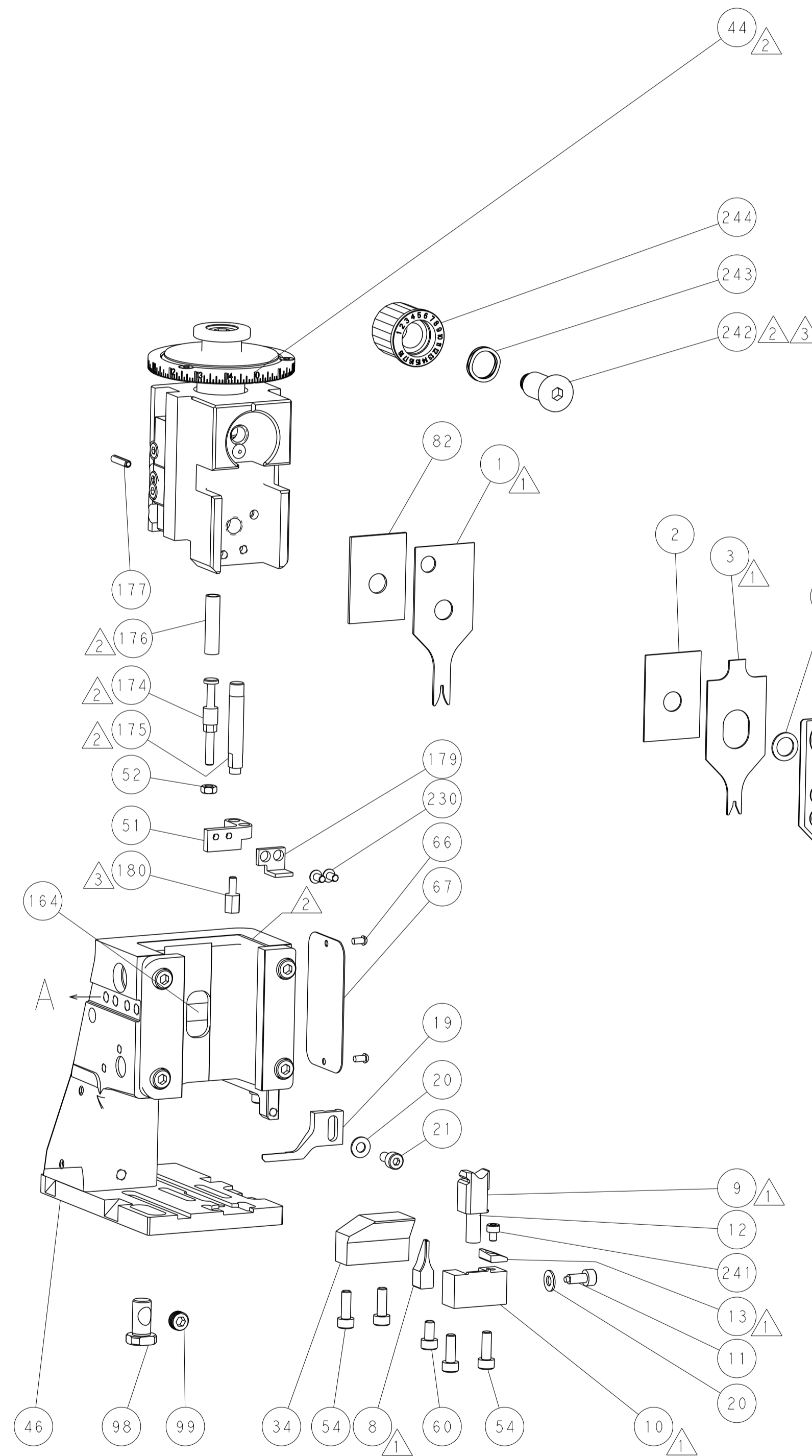
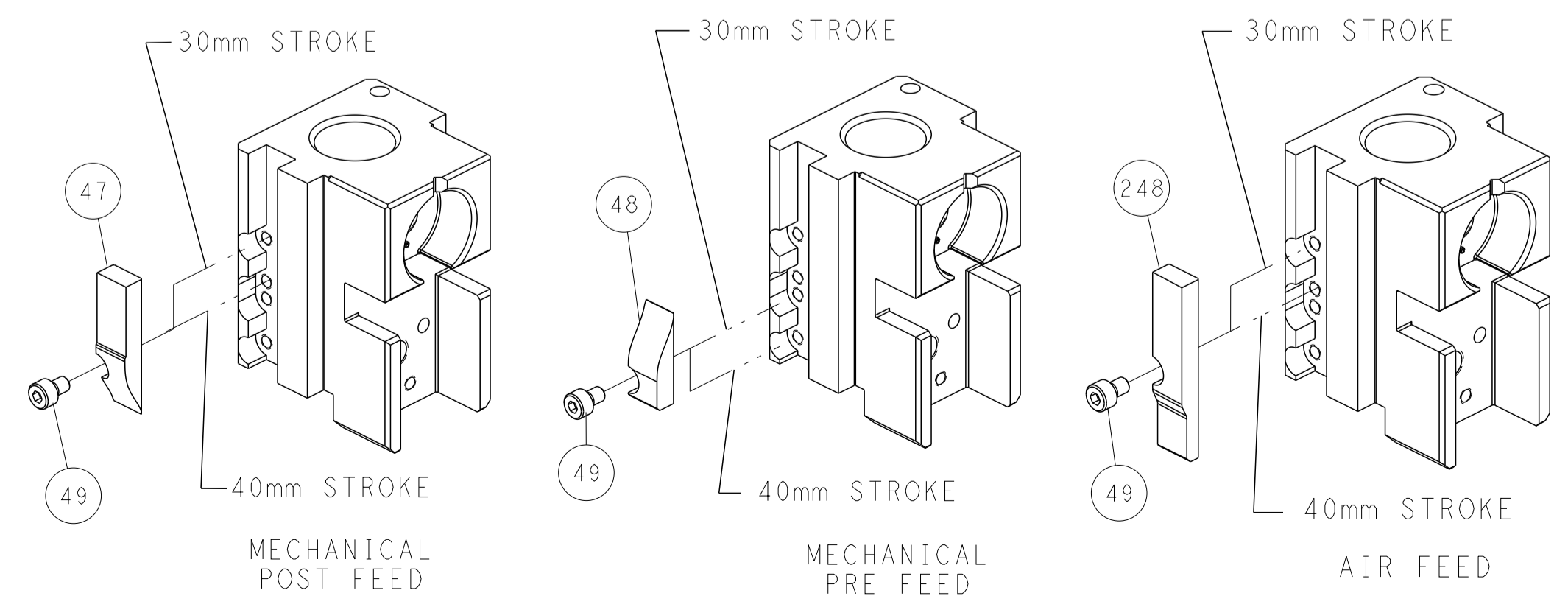


RAM AND HOLDDOWN SET-UP



FEED TRACK POSITION GUIDE BY INSULATION 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 UNPUBLISHED. RELEASED FOR PUBLICATION BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.</small>		DWN T. BROOKENS 03JUL2018 CHK M. HERR 03JUL2018 APVD C. TOPPER 03JUL2018	NAME Ocean Side Feed Applicator SIZE CAGE CODE DRAWING NO. A1 00779 C=2837321 RESTRICTED TO -
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH ±	WEIGHT - SCALE 1:2 SHEET 2 OF 4 REV C	TE Connectivity Harrisburg, PA 17105-3608	

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2837321-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2837321-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2837321-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR  
 INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.20 mm [.047]	F
INSUL	1.40 mm [.055]	F

APPLICATOR INSTRUCTIONS  
 408-35042

TERMINAL DATA: MOLEX TERMINAL MOLEX CRIMP SPECIFICATION	
TERMINAL NAME: 2.0 WIRE TO BOARD CONN.	
WIRE STRIP LENGTH 1.30-1.80 mm [.051-.071 IN]	TERMINAL INSULATION DIAMETER RANGE Ø1.15-1.50 mm [.045-.059 IN]
TERMINAL APPLICATION SPECIFICATION CS-505153-001 Rev E	
TERMINALS APPLIED	
TE TERMINAL	MOLEX TERMINAL
3311245-1	505153-8000

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.30mm2	0.72 +/- .025 [.028 +/- .001]	5.3
22 AWG	0.68 +/- .025 [.027 +/- .001]	5.8
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- 1 RECOMMENDED SPARE PARTS
- 2 REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- 3 APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 180. 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					
A	66	P	LTN	DESCRIPTION	DATE	OWN	APVD
-	-	-	-	SEE SHEET 1	-	-	-

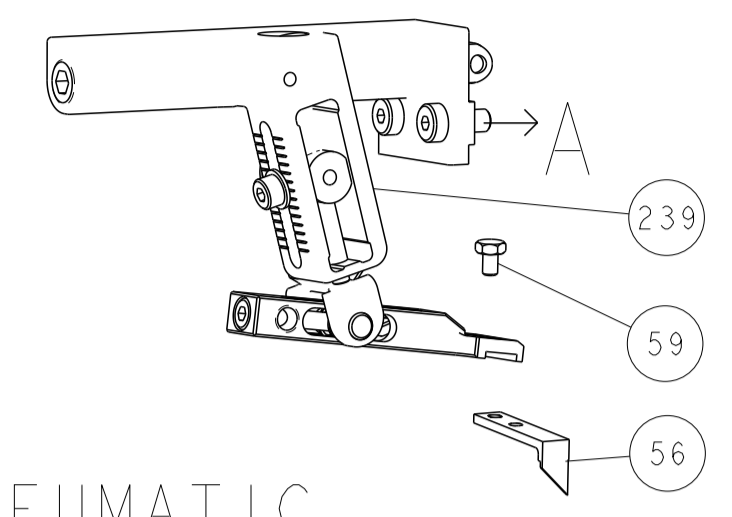
-	1	1	2119082-5	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
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3	-	1	1-1752354-5	STANDOFF, HOLD-DOWN	180
-	1	1	1-1633764-5	HOLD DOWN, TERMINAL	179
-	1	1	6-993111-6	PIN, SLOTTED SPRING 3.0 X 14.0	177
-	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	-	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	2844908-1	SCREW, LOCKING	99
-	1	1	2844907-1	POST, LOCKING	98
-	1	1	1-455888-1	SPACER, CRIMPER	82
-	1	1	1803607-3	DOCUMENTATION PACKAGE	71
-	1	1	2119791-9	DEPRESSOR, WIRE	70
-	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	1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52
-	1	1	1901681-8	HOLDDOWN, TERMINAL	51
-	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	7-1752356-9	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	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	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	1803095-3	FLOATING SHEAR, FRONT	9
1	1	1	3-1803703-9	ANVIL, COMBINATION	8
-	-	-	-	-	7
-	-	-	-	-	6
-	1	1	2119757-1	DEPRESSOR, SHEAR	5
-	1	1	4-238011-8	BLOCK, CRIMPER SPACER	4
1	1	1	5-1803017-8	CRIMPER, INSULATION F	3
-	1	1	455888-6	SPACER, CRIMPER	2
1	1	1	1803188-2	CRIMPER, WIRE	1
-	77	-22	-21	PART NO	ITEM NO

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

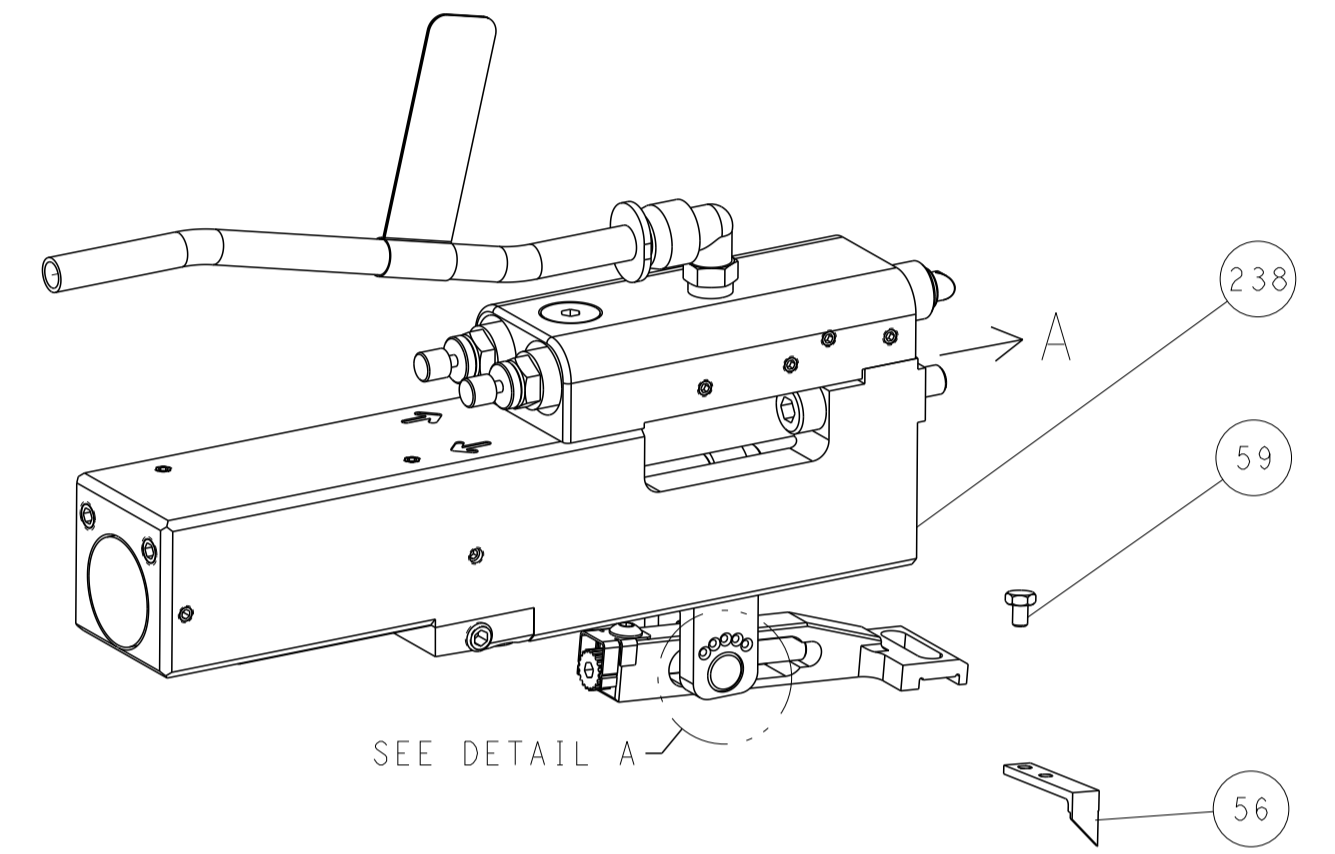
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN T. BROOKENS 03JUL2018		CHK M. HERR 03JUL2018		NAME Ocean Side Feed Applicator	
0 PLC ±		1 PLC ±		APVD C. TOPPER 03JUL2018		PRODUCT SPEC		SIZE CAGE CODE DRAWING NO RESTRICTED TO	
2 PLC ±		3 PLC ±		APPLICATION SPEC		WEIGHT		SCALE 1:2 SHEET 3 OF 4 REV C	
4 PLC ±		ANGLES ±		MATERIAL		FINISH		Customer Accessible Production Drawing	

LOC	DIST	REV	DESCRIPTION	DATE	OWN	APVD
A	66		SEE SHEET 1			

# FEED TYPE MECHANICAL



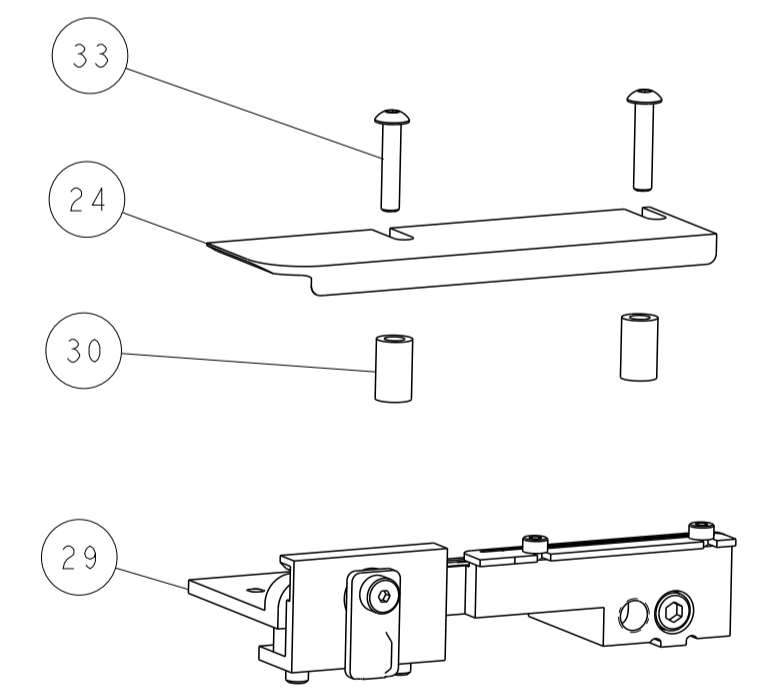
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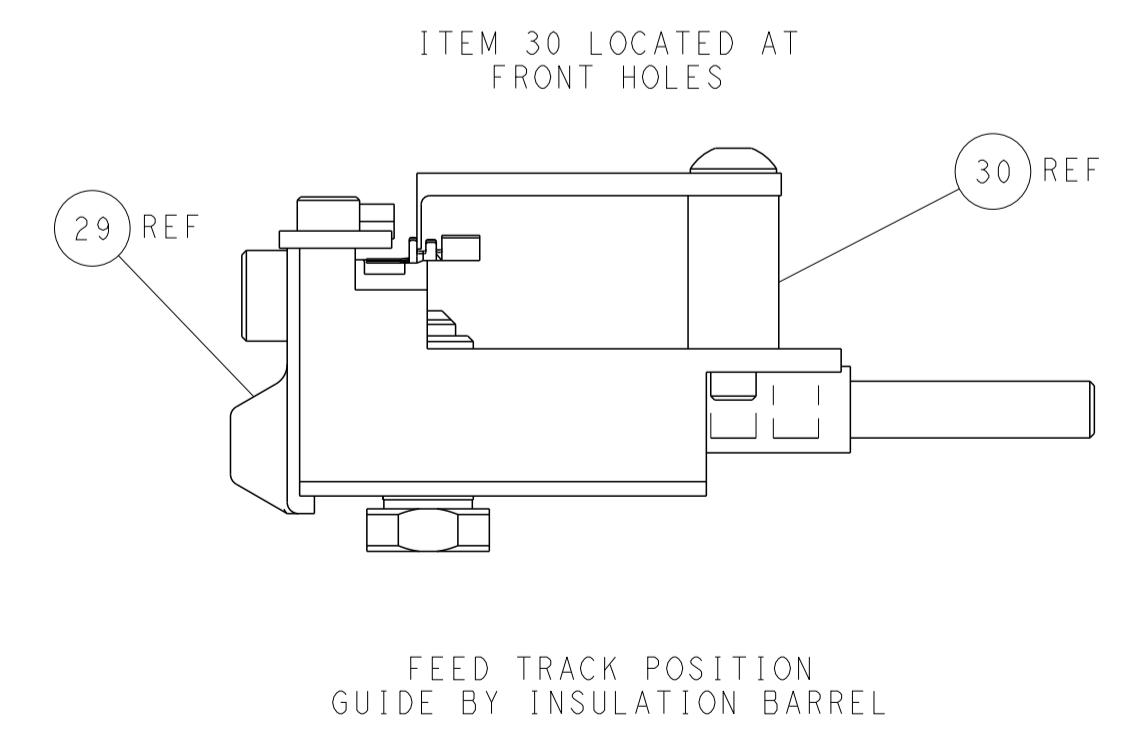
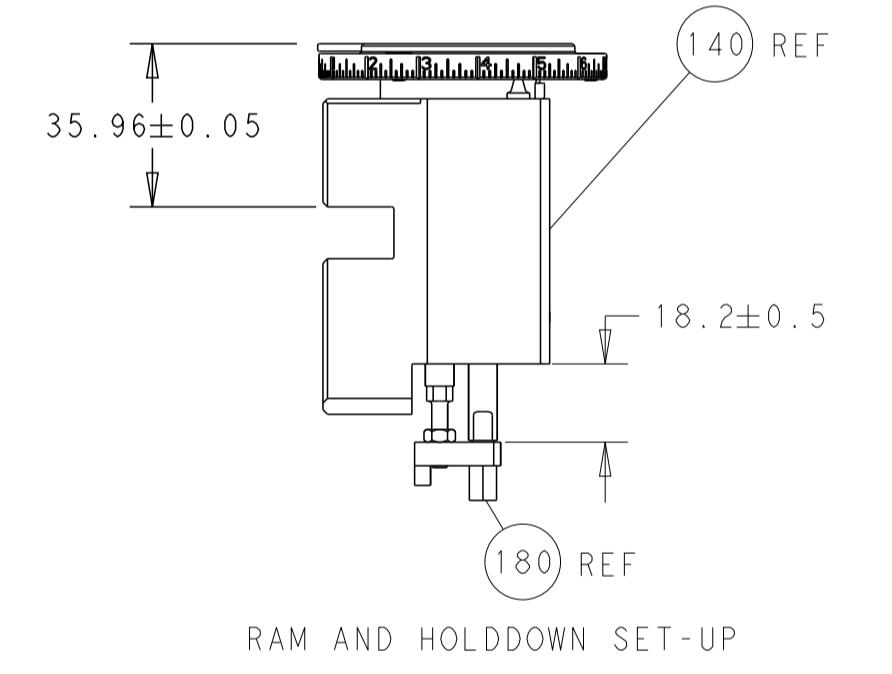
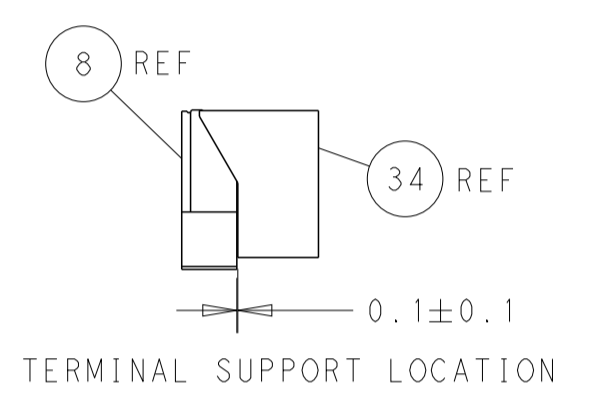
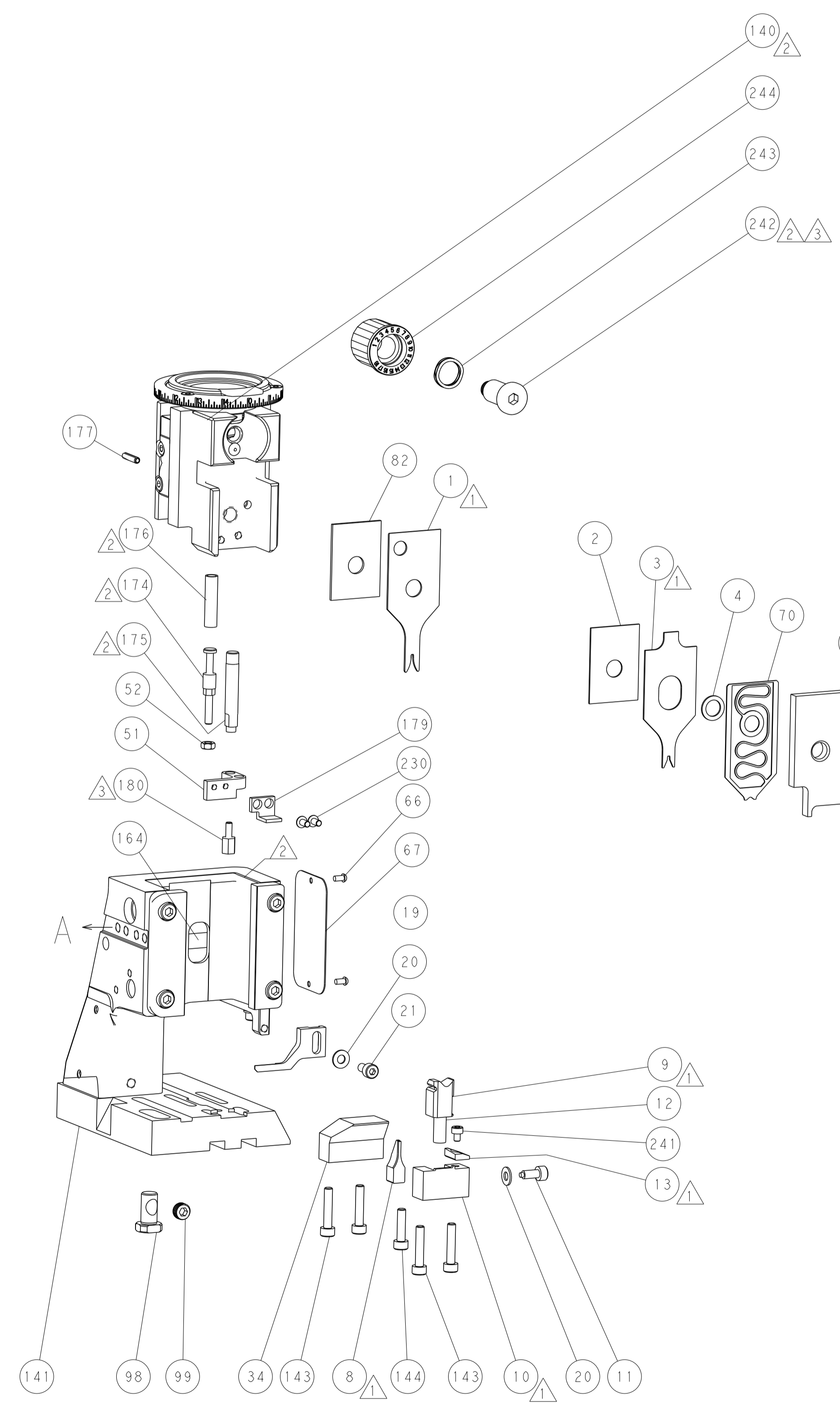
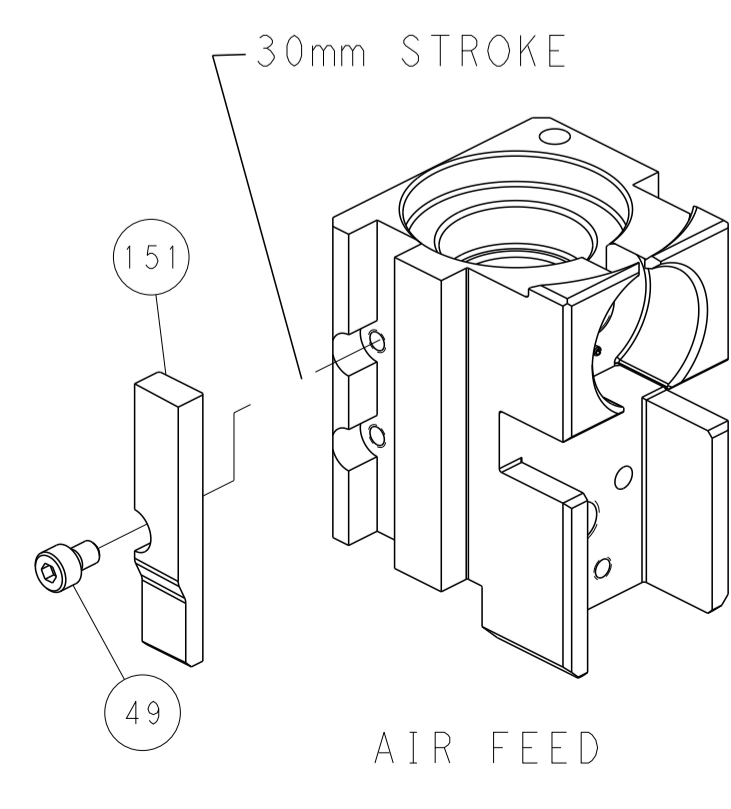
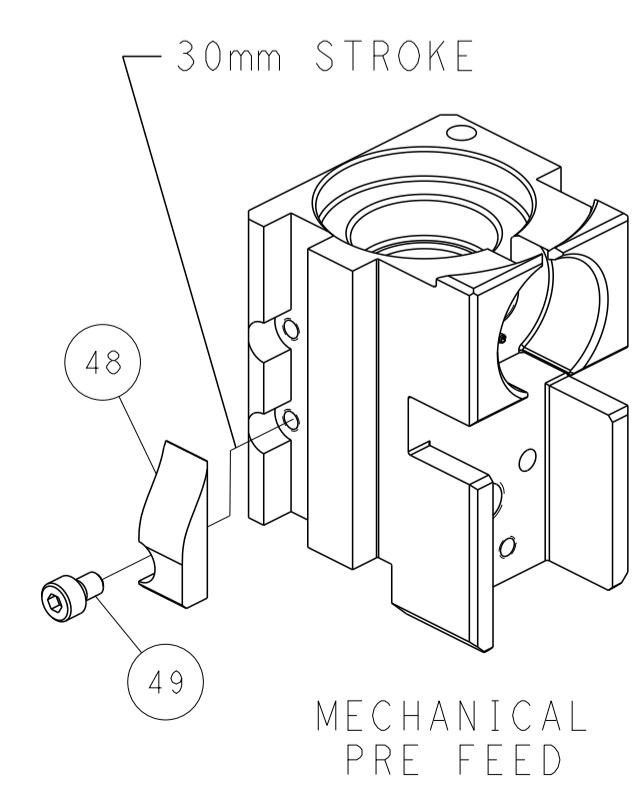
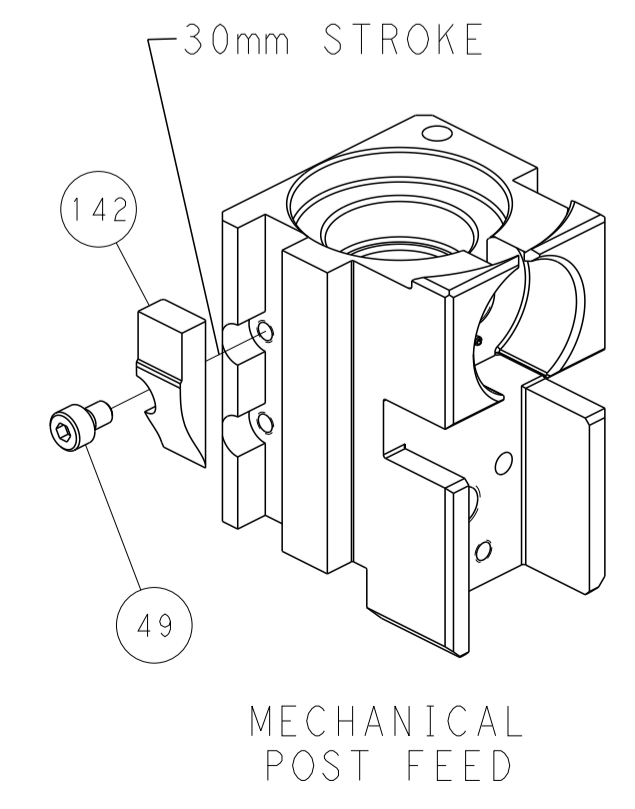
### FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



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)

DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH		DWN T. BROOKS 03JUL2018 CHK M. HERR 03JUL2018 APVD C. TOPPER 03JUL2018 PRODUCT SPEC APPLICATION SPEC WEIGHT SCALE 1:2		NAME Ocean Side Feed Applicator SIZE CAGE CODE DRAWING NO A1 00779 C=2837321 RESTRICTED TO SHEET 4 OF 4 REV C	
MATERIAL:				Customer Accessible Production Drawing			