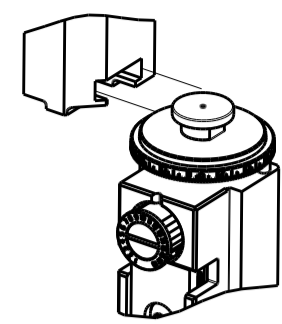


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2837327-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2837327-2	B	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2837327-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER

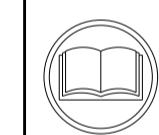


APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	3.43 mm [.135]	F
INSUL	4.57 mm [.180]	F

APPLICATOR INSTRUCTIONS 408-35042

TERMINAL DATA: YAZAKI TERMINAL YAZAKI CRIMP SPECIFICATION	
TERMINAL NAME: 312 TERMINAL, FEMALE	
WIRE STRIP LENGTH 4.50-5.50 mm [.177-.217 IN]	TERMINAL INSULATION DIAMETER RANGE Ø2.90-3.80 mm [.114-.150 IN]
TERMINAL APPLICATION SPECIFICATION 72-WT10-474 Rev WA2053	
TERMINALS APPLIED	
TE TERMINAL	YAZAKI TERMINAL
3311250-1	7116-6041

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
3.00mm2	1.95 +/- 0.05 [0.077 +/- .002]	6.9
2.00mm2	1.80 +/- 0.05 [0.071 +/- .002]	8.5



- 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					
		P	LTN	DESCRIPTION	DATE	DMN	APVD
A	66	A		RELEASED	13SEP2018	RK	TE
		B		ECR-19-014411	16SEP2019	FJ	TE

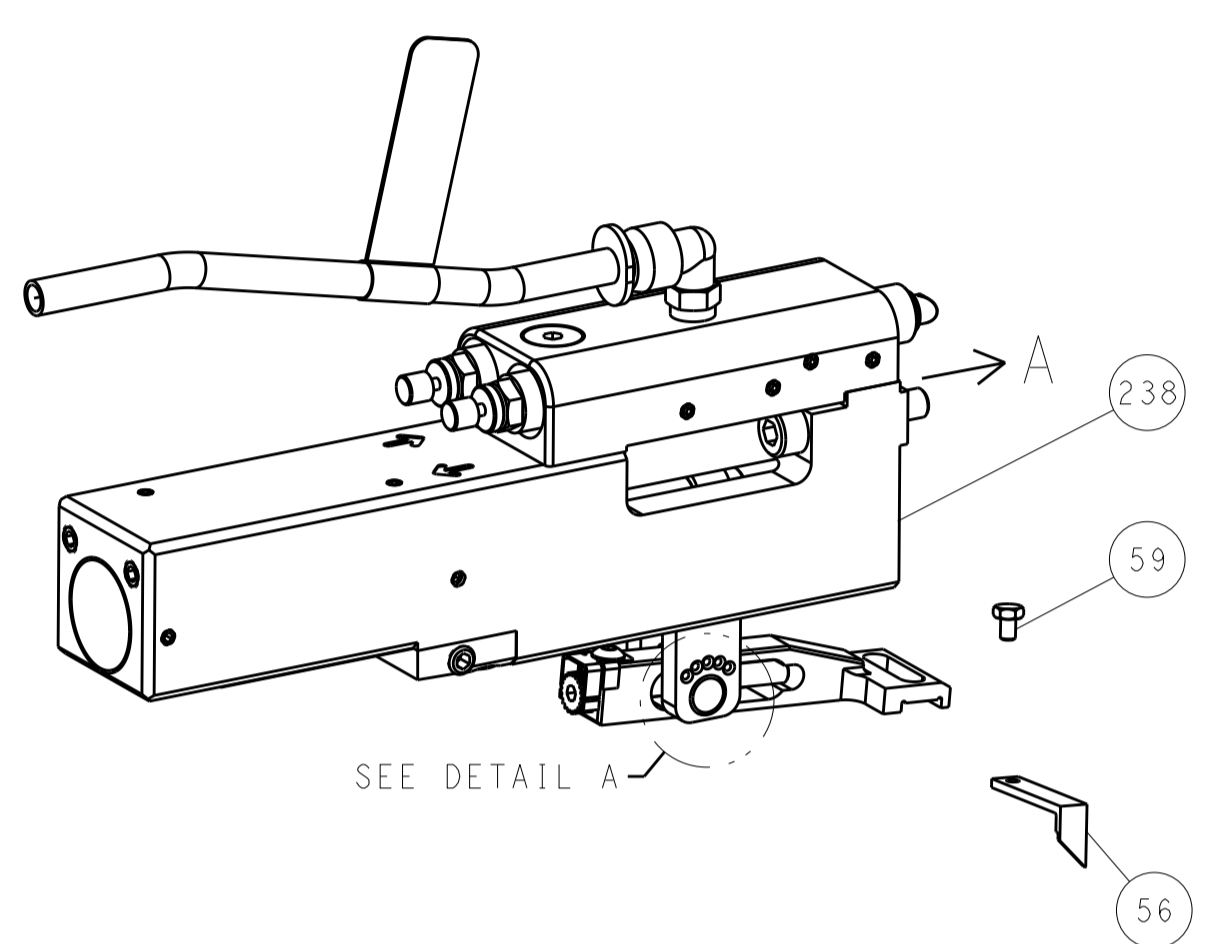
-	1	1	455888-5	SPACER, CRIMPER	285
-	1	1	2119641-1	FEED CAM, AIR FEED	248
-	1	1	2119082-8	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
-	1	1	2844940-2	AIR FEED MODULE	238
-	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	1	1	2844908-1	SCREW, LOCKING	99
-	1	1	2844907-1	POST, LOCKING	98
-	1	1	455888-5	SPACER, CRIMPER	82
-	1	1	1803607-3	DOCUMENTATION PACKAGE	71
-	1	1	2119791-7	DEPRESSOR, WIRE	70
-	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	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	1338683-8	FEED PAWL	56
-	4	4	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	54
-	2	2	2-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 14	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	1752356-3	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	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	2119533-1	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	1-21803512-1	ANVIL, COMBINATION	8
-	1	1	2-240641-9	SPACER	7
-	-	-	-	-	6
-	1	1	1-2119757-0	DEPRESSOR, SHEAR	5
-	1	1	238011-4	BLOCK, CRIMPER SPACER	4
-	1	2	1-21633961-7	CRIMPER, INSULATION F PREMIUM	3
-	1	1	455888-3	SPACER, CRIMPER	2
-	1	2	1-31803470-7	CRIMPER, WIRE F	1
-	77	72	-2	PART NO	ITEM NO

DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG: JM ZHAO 30 JUL 2018		TE Connectivity Harrisburg, PA 17105-3608	
0 PLC	±	0.15	±	CHK: K. ZHANG 30 JUL 2018	NAME: Ocean Side Feed Applicator		
1 PLC	±	0.25	±	APVD: K. ZHANG 30 JUL 2018	SIZE: CAGE CODE: DRAWING NO: RESTRICTED TO		
2 PLC	±	0.38	±	PRODUCT SPEC			
3 PLC	±	0.51	±	APPLICATION SPEC			
4 PLC	±	0.64	±	WEIGHT: A1 00779 C=2837327			
ANGLES	±	0.25	±	Customer Accessible Production Drawing SCALE: 1:2 SHEET 1 OF 4 REV B			

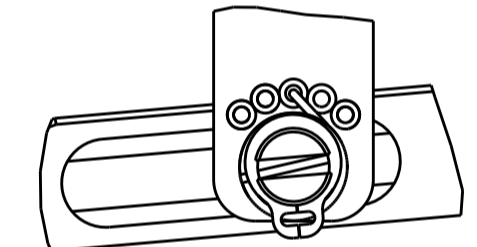
LOC	DIST	REV	DATE	BY	APP'D
A	66				

# FEED TYPE

## PNEUMATIC

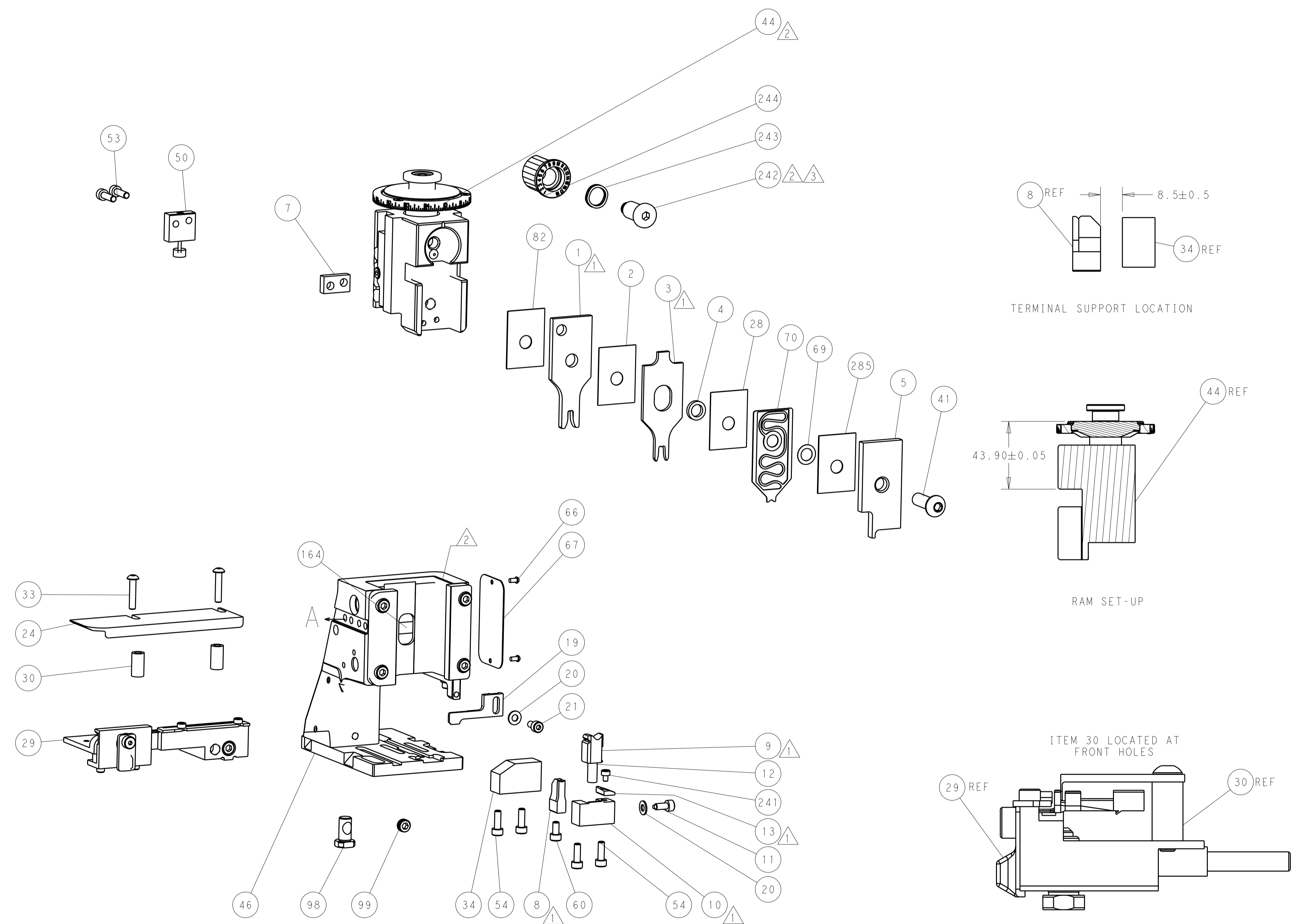
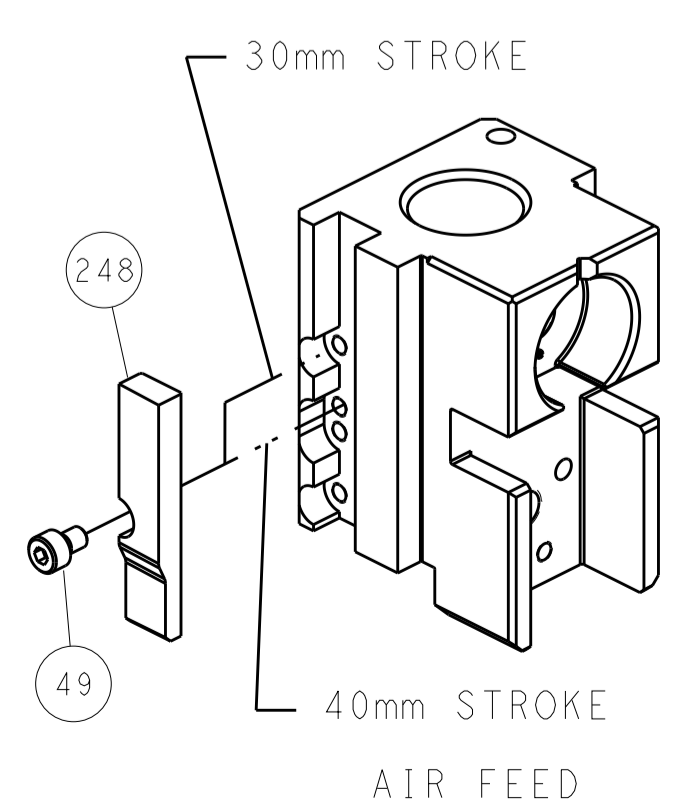


## FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)

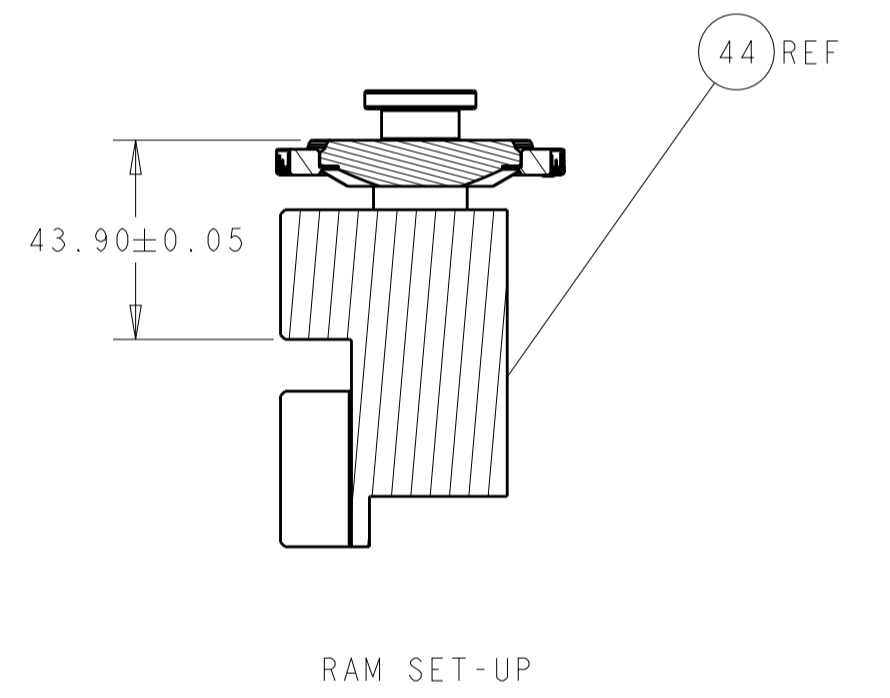


DETAIL A

## CAM POSITION

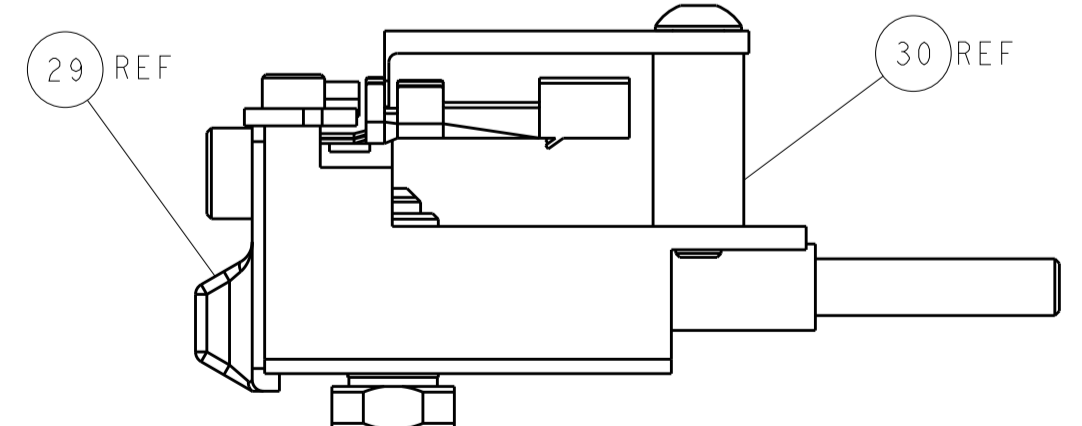


TERMINAL SUPPORT LOCATION



RAM SET-UP

ITEM 30 LOCATED AT FRONT HOLES



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 ±		DWG: M. ZHAO 30JUL2018 CHK: K. ZHANG 30JUL2018 APP'D: K. ZHANG 30JUL2018 PRODUCT SPEC APPLICATION SPEC WEIGHT SCALE: 1:2		NAME: Ocean Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2837327 SHEET 2 OF 4 REV B	
MATERIAL:				FINISH:		RESTRICTED TO:	

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2837327-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2837327-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR  
 INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	3.43 mm [.135]	F
INSUL	4.57 mm [.180]	F

APPLICATOR INSTRUCTIONS  
 408-35042

TERMINAL DATA: YAZAKI TERMINAL YAZAKI CRIMP SPECIFICATION	
TERMINAL NAME: 312 TERMINAL, FEMALE	
WIRE STRIP LENGTH 4.50-5.50 mm [.177-.217 IN]	TERMINAL INSULATION DIAMETER RANGE Ø2.90-3.80 mm [.114-.150 IN]
TERMINAL APPLICATION SPECIFICATION 72-WT10-474 Rev WA2053	
TERMINALS APPLIED	
TE TERMINAL 3311250-1	YAZAKI TERMINAL 7116-6041

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
3.00mm2	1.95+/-0.05 [.077+/-0.002]	6.9
2.00mm2	1.80+/-0.05 [.071+/-0.002]	8.5



- 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)

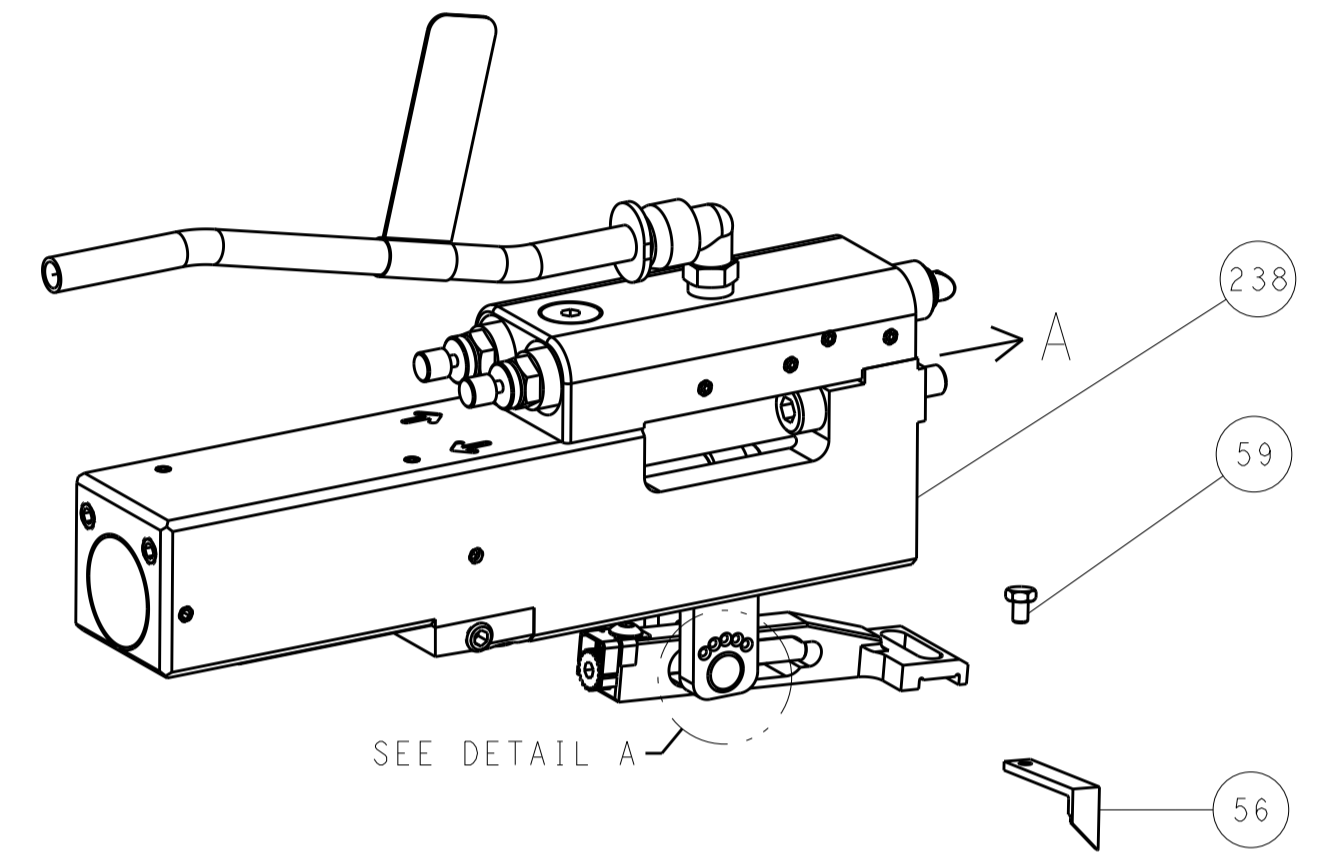
LOC	DIST	REVISIONS					
A	66	P	LTN	DESCRIPTION	DATE	OWN	APVD
-	-	-	-	SEE SHEET 1	-	-	-

-	1	455888-5	SPACER, CRIMPER	285	
-	1	2119082-8	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	455888-5	SPACER, CRIMPER	82	
-	1	1803607-3	DOCUMENTATION PACKAGE	71	
-	1	2119791-7	DEPRESSOR, WIRE	70	
-	1	2119943-1	WASHER, SPACER	69	
-	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	1338683-8	FEED PAWL	56	
-	2	2-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 14	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	1752356-3	SUPPORT, TERMINAL	34	
-	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33	
-	2	3-2844962-0	SPACER, CYLINDRICAL, STRIP GUIDE	30	
-	1	2844992-1	ASSEMBLY, STRIP GUIDE	29	
-	1	455888-3	SPACER, CRIMPER	28	
-	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	2-1803512-1	ANVIL, COMBINATION	8	
-	1	2-240641-9	SPACER	7	
-	-	-	-	6	
-	1	1-2119757-0	DEPRESSOR, SHEAR	5	
-	1	238011-4	BLOCK, CRIMPER SPACER	4	
-	1	2-1633961-7	CRIMPER, INSULATION F PREMIUM	3	
-	1	455888-3	SPACER, CRIMPER	2	
-	1	3-1803470-7	CRIMPER, WIRE F	1	
-	77	-22	PART NO	DESCRIPTION	ITEM NO

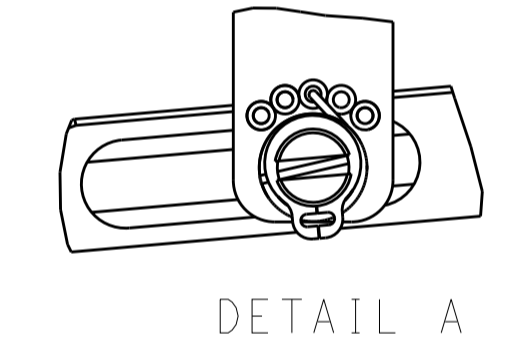
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG: JM ZHAO 30JUL2018		CHK: K. ZHANG 30JUL2018		NAME: Ocean Side Feed Applicator	
0 PLC	±	0 PLC	±	APVD: K. ZHANG 30JUL2018	PRODUCT SPEC		SIZE: A1		RESTRICTED TO:
1 PLC	±	1 PLC	±	APPLICATION SPEC		SCALE: 1:2		SHEET 3 OF 4	
2 PLC	±	2 PLC	±	WEIGHT		REV: B		Customer Accessible Production Drawing	
3 PLC	±	3 PLC	±	MATERIAL		SCALE: 1:2		SHEET 3 OF 4	
4 PLC	±	4 PLC	±	FINISH		SCALE: 1:2		SHEET 3 OF 4	
ANGLES	±	ANGLES	±	MATERIAL		SCALE: 1:2		SHEET 3 OF 4	

LOC		DIST		REVISIONS			
A	66	P	LTM	DESCRIPTION	DATE	DMN	APVD
		-		SEE SHEET 1	-	-	-

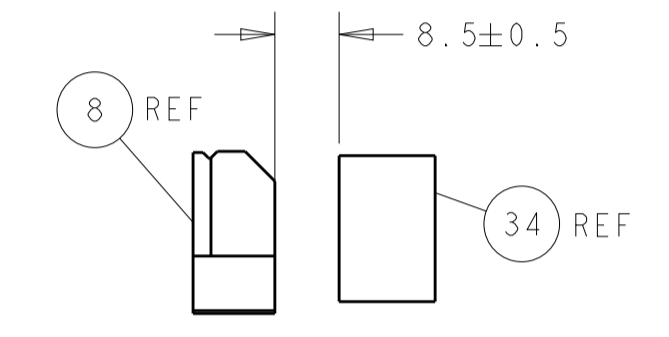
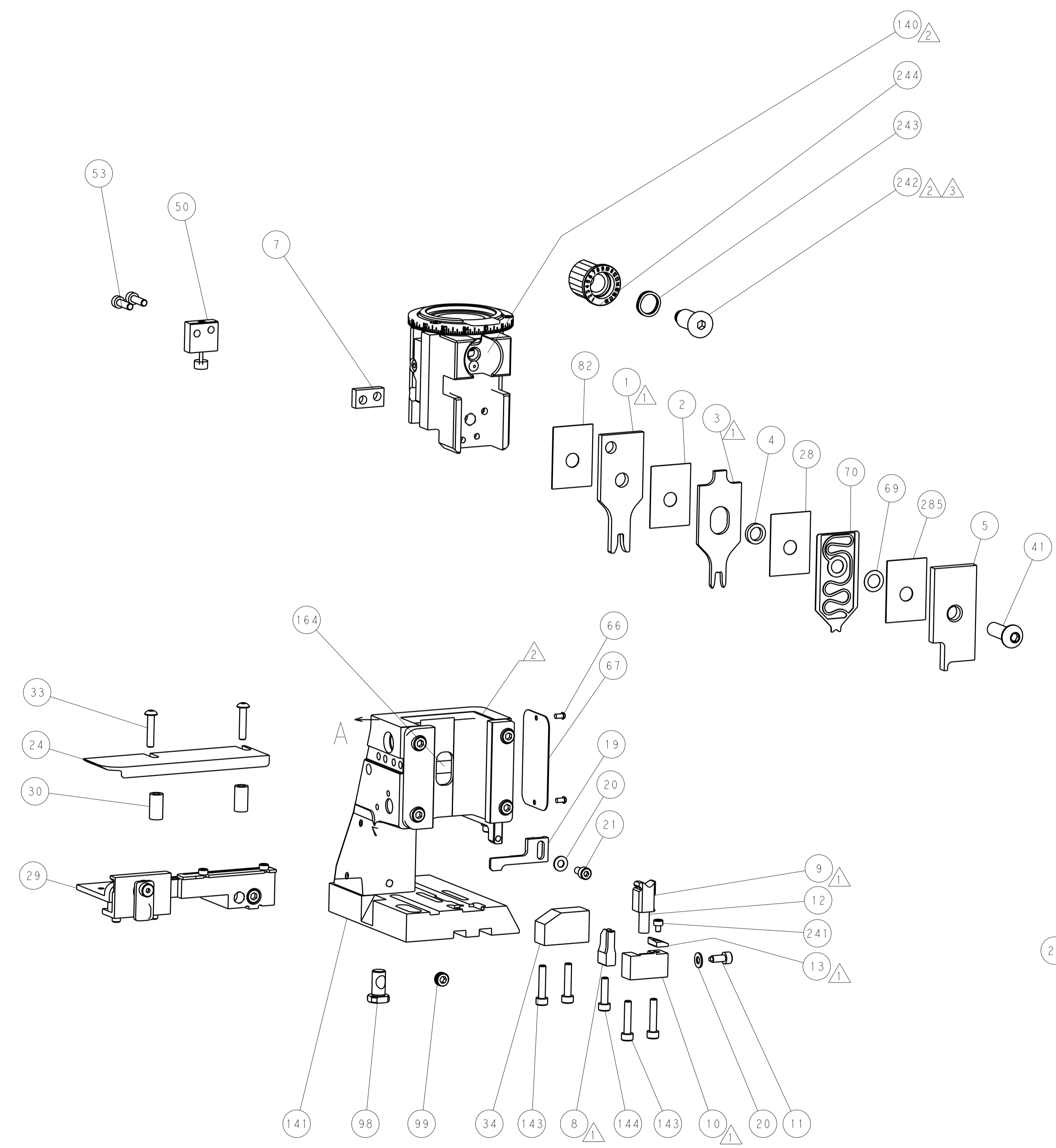
### FEED TYPE PNEUMATIC



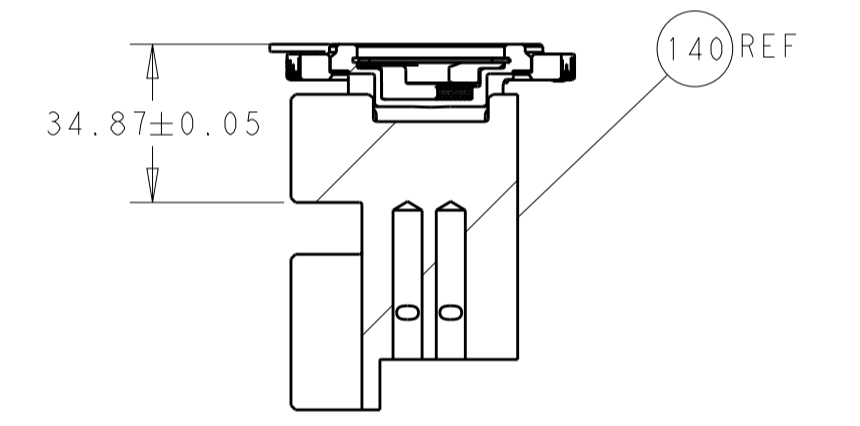
### FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



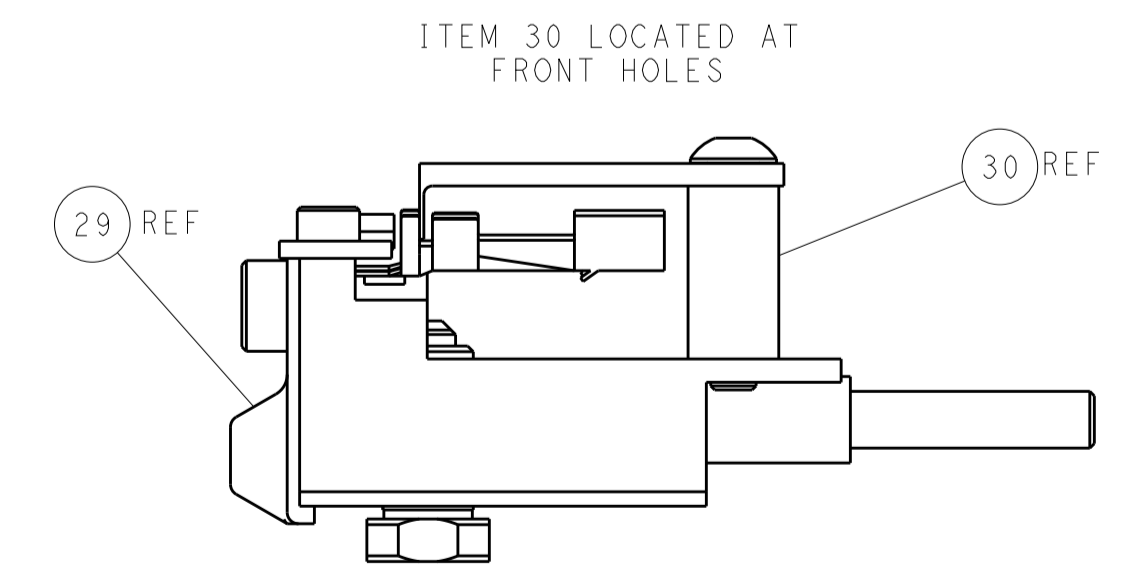
### CAM POSITION



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>THE DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION. IT IS THE PROPERTY OF TYCO ELECTRONICS CORPORATION. IT IS TO BE USED ONLY FOR THE PROJECT AND FOR THE CUSTOMER'S ORGANIZATION. IT IS TO BE RETURNED TO TYCO ELECTRONICS CORPORATION UPON COMPLETION OF THE PROJECT.</small>		DMN: M. ZHAO 30 JUL 2018 CHK: K. ZHANG 30 JUL 2018 APVD: K. ZHANG 30 JUL 2018	NAME: TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±	PRODUCT SPEC APPLICATION SPEC WEIGHT MATERIAL	SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2837327 SCALE: 1:2	RESTRICTED TO: B SHEET 4 OF 4 REV B