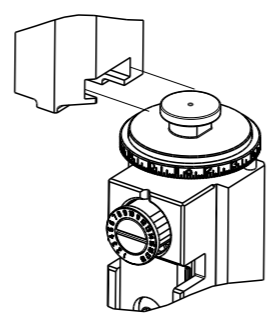


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2837488-2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2837488-1	A	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2837488-2	A	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2837488-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER

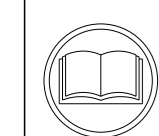


APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.27 mm [.050]	F
INSUL	1.65 mm [.065]	F

APPLICATOR INSTRUCTIONS  
408-35042

TERMINAL DATA: HIROSE TERMINAL HIROSE CRIMP SPECIFICATION			
TERMINAL NAME: QR/P1 SERIES CONNECTOR			
WIRE STRIP LENGTH	TERMINAL INSULATION DIAMETER RANGE		
3.35-4.11 mm [.132-.162 IN]	Ø0.90-1.50 mm [.035-.059 IN]		
TERMINAL APPLICATION SPECIFICATION	TC-QR/P1-SC2A Rev 12/2/96		
TERMINALS APPLIED			
TE TERMINAL	HIROSE TERMINAL	TE TERMINAL	HIROSE TERMINAL
3311387-1	QR/P1-SC2A-211(12)	3311388-1	QR/P1-PC2A-211(12)

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
24 AWG	0.75 +/- 0.04 [.030 +/- .002]	8.4
26 AWG	0.72 +/- 0.04 [.028 +/- .002]	8.7
28 AWG	0.71 +/- 0.04 [.028 +/- .002]	8.8



- 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.
  - PART OPTIONAL FOR BETTER LEADMAKER PERFORMANCE.
  - TERMINAL NOT COMPATIBLE WITH MECHANICAL FEED.
7. 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	LY#	DESCRIPTION	DATE	OWN	APVD
		1		RELEASED	17DEC2018	MEH	TE
		A		RELEASED	30JAN2019	MEH	TE

5	-	1	1	1	2079383-1	SCR, BHSC, RoHS (M3 X 8)	284
5	-	1	1	1	1633289-4	STABILIZER	283
	-	1	1	1	1803461-1	HOLDER, STABILIZER	282
	-	1	1	1	1-18028-3	WASHER, FLAT, REG M5	281
	-	1	1	1	1803196-1	STUD, ADJUSTMENT SCREW	280
	-	1	1	1	2330046-1	RESIN COLLAR, FLANGED	261
	-	1	-	1	2119640-1	PUSH ROD, AIR FEED	250
	-	1	-	1	1803259-1	BUSHING, FLANGED	249
	-	1	-	1	2119641-1	FEED CAM, AIR FEED	248
	-	1	1	1	2119082-5	CAM, SNAIL, INSULATION ADJUSTMENT	244
	-	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	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
	-	1	-	1	2063440-1	AIR FEED MODULE	238
	-	2	-	2	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172
	REF	REF	REF		994970-2	COUNTER, MAGNETIC	164
	-	1	-	1	240638-1	SPRING, FEED FINGER	163
	-	1	-	1	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854	137
	-	1	-	1	2119799-1	HOLDER, FEED FINGER, AF	136
	-	1	1	1	1-22281-6	SPRING, COMPRESSION	121
	-	1	1	1	2844908-1	SCREW, LOCKING	99
	-	1	1	1	2844907-1	POST, LOCKING	98
	-	1	1	1	1-690438-0	FRONT STRIP GUIDE	96
	-	2	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	95
	-	1	1	1	2-994962-2	SCR, SKT HD CAP M3 X 55.0	93
	-	1	1	1	1803607-1	DOCUMENTATION PACKAGE	71
	-	1	1	1	2119791-1	DEPRESSOR, WIRE	70
	-	1	1	1	2119740-1	TAG, IDENTIFICATION	67
	-	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
	-	2	2	2	2-18032-5	SCR, SET, FLT PNT, M5 X 20.0	61
	-	1	1	1	2161425-1	SCREW, SHOULDER	60
	-	1	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
	-	1	1	1	1338685-1	PAWL, FEED	56
	-	4	4	4	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	54
	-	2	2	2	2-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 14	53
	-	1	1	1	5018030-1	NUT, HEX, REG, RoHS, M3	52
	-	1	1	1	811242-5	BUMPER, HOLD DOWN	51
	-	1	1	1	690753-2	SPACER, TONKER	50
	-	1	2	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49
	-	1	1	1	2-1803583-5	APPLICATOR BASIC ASSEMBLY, SF	46
	-	1	1	1	1803515-1	RAM ASSEMBLY, SF ATLANTIC	44
	-	1	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
	-	1	1	1	1752356-3	SUPPORT, TERMINAL	34
	-	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
	-	2	2	2	2-2844962-3	SPACER, CYLINDRICAL, STRIP GUIDE	30
	-	1	1	1	2844938-1	PLATE, STRIP GUIDE	29
	-	1	1	1	1-455888-0	SPACER, CRIMPER	28
	-	2	2	2	22283-1	SPRING, COMPRESSION	27
	-	1	1	1	356835-1	LEVER, DRAG RELEASE	26
	-	1	1	1	240792-1	DRAG, TERMINAL	25
	-	1	1	1	1320928-2	STRIP GUIDE	24
	-	1	1	1	980371-4	SCR, SKT HD SHLDR 5.0 DIA X 6.0	23
	-	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
	-	2	2	2	1-18028-2	WASHER, FLAT, REG M4	20
	-	1	1	1	1803213-1	STRIPPER	19
	-	1	1	1	2119806-1	INSERT, SHEAR	13
	-	1	1	1	3-22280-3	SPRING, COMPRESSION	12
	-	1	1	1	1-356885-5	STOP, SHEAR	11
	-	1	1	1	2119805-1	SHEAR HOLDER, FRONT	10
	-	1	1	1	1803095-6	FLOATING SHEAR, FRONT	9
	1	2	2	1	1803797-1	ANVIL, COMBINATION	8
	-	1	1	1	240641-1	SPACER	7
	-	-	-	-	-	-	6
	-	1	1	1	1-2119757-8	DEPRESSOR, SHEAR	5
	-	1	1	1	5-238011-6	BLOCK, CRIMPER SPACER	4
	1	2	2	1	1803692-2	CRIMPER, INSULATION F PREMIUM	3
	-	1	1	1	455888-6	SPACER, CRIMPER	2
	1	2	2	1	4-1803407-1	CRIMPER, WIRE PREMIUM	1

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		OWN	CHK	APVD	DATE
mm	0 PLC ±	1 PLC ±	2 PLC ±	M	HERR	B	17DEC2018
	3 PLC ±	4 PLC ±	ANGLES ±	T	ELBIN	B	17DEC2018
	FINISH						

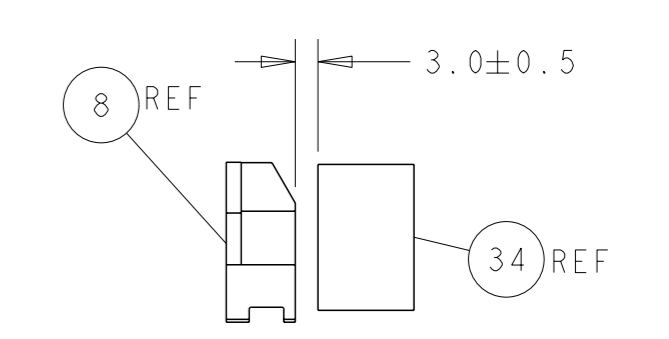
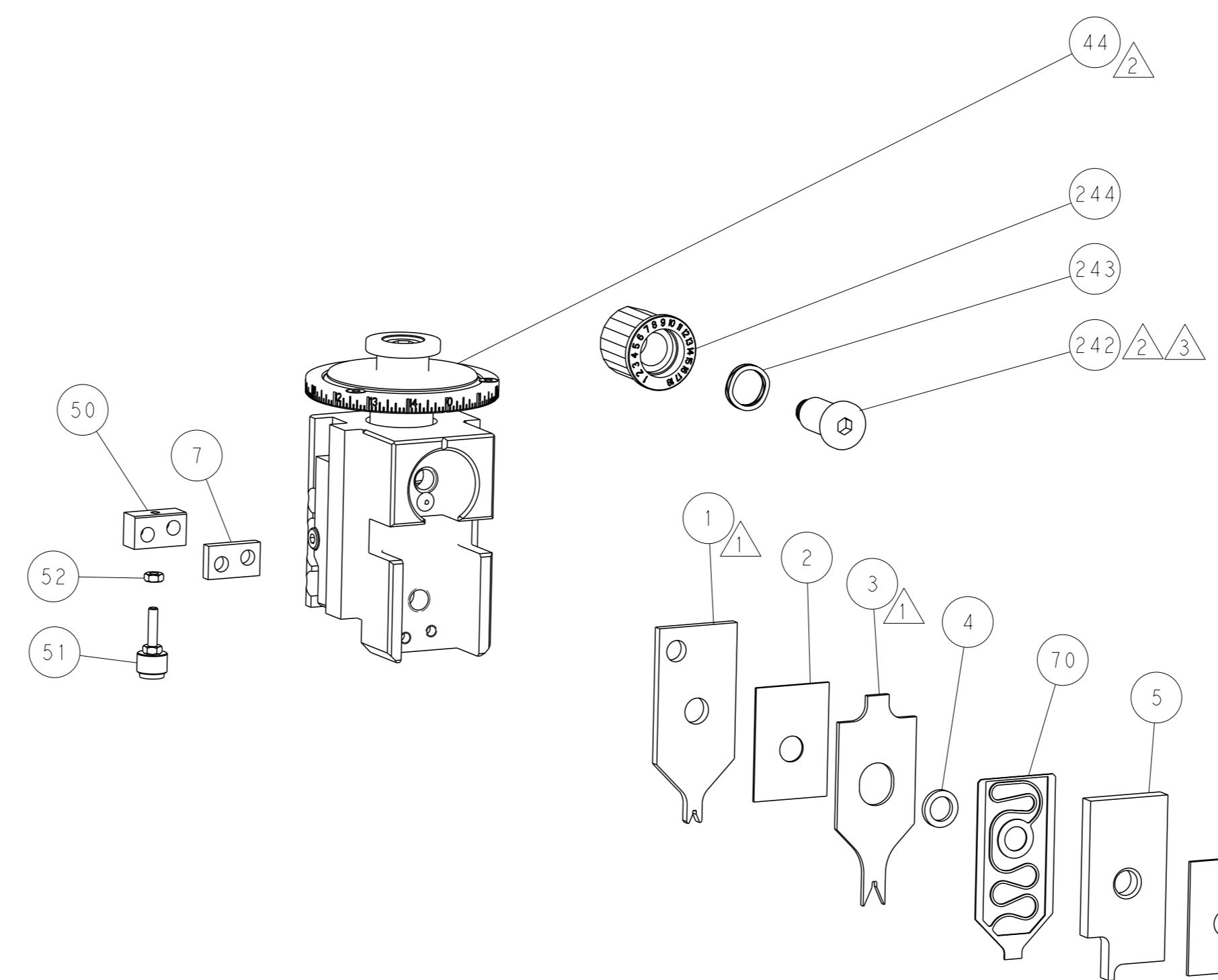
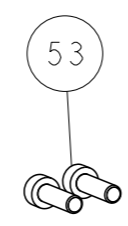
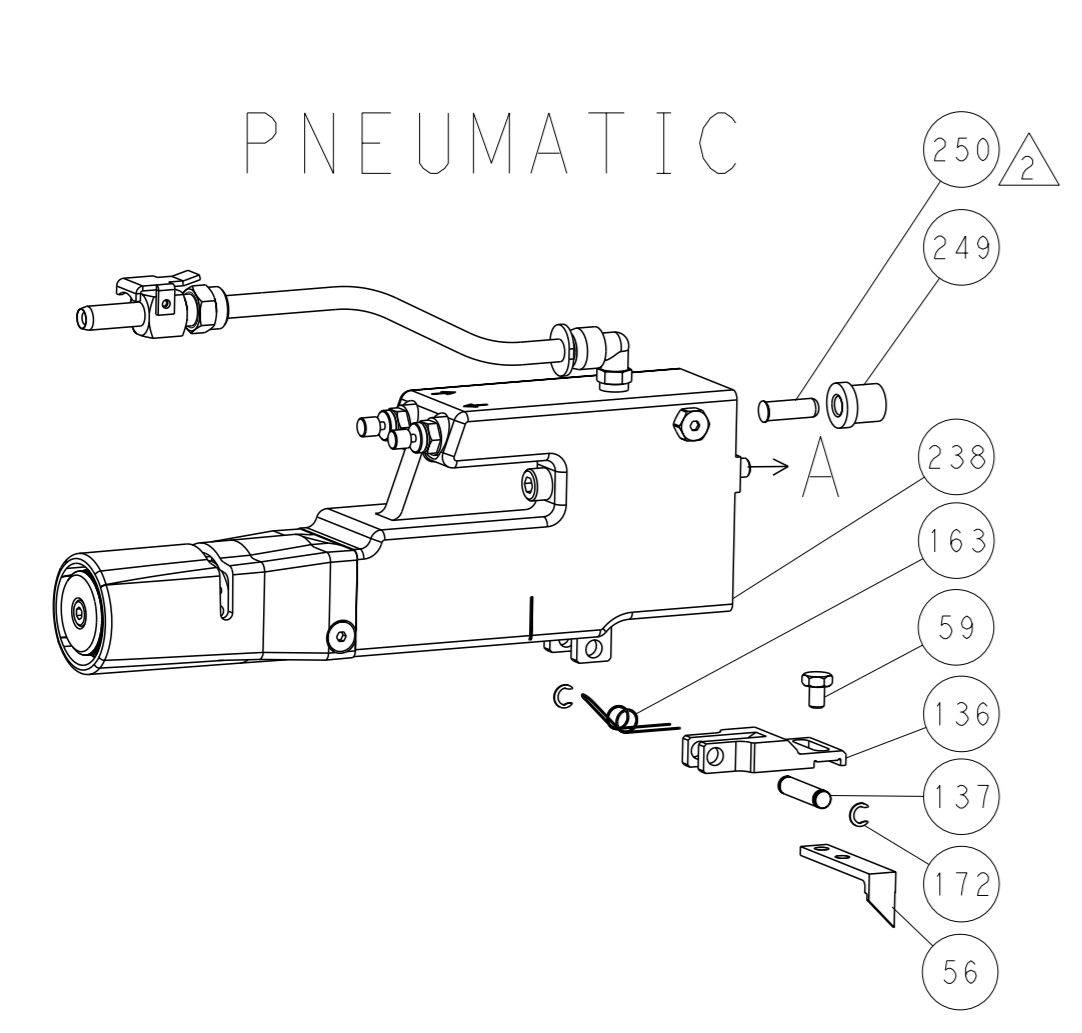
NAME	SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
Ocean Side Feed Applicator	A1	00779	2837488	-

CUSTOMER DRAWING SCALE 1:2 SHEET 1 OF 4 REV A

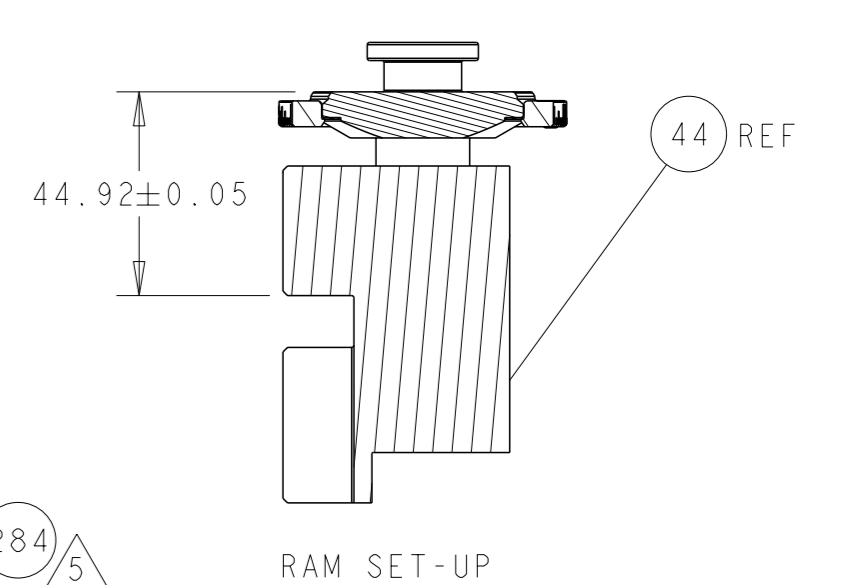
LOC	DIST	REV	DESCRIPTION	DATE	OWN	APVD
A	66	-	SEE SHEET 1	-	-	-

### FEED TYPE

#### PNEUMATIC

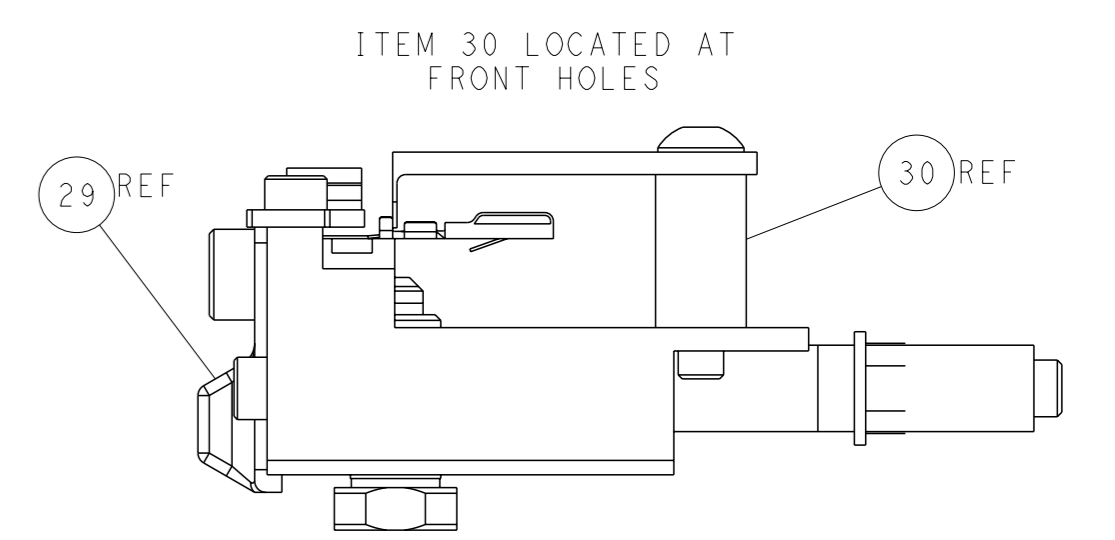
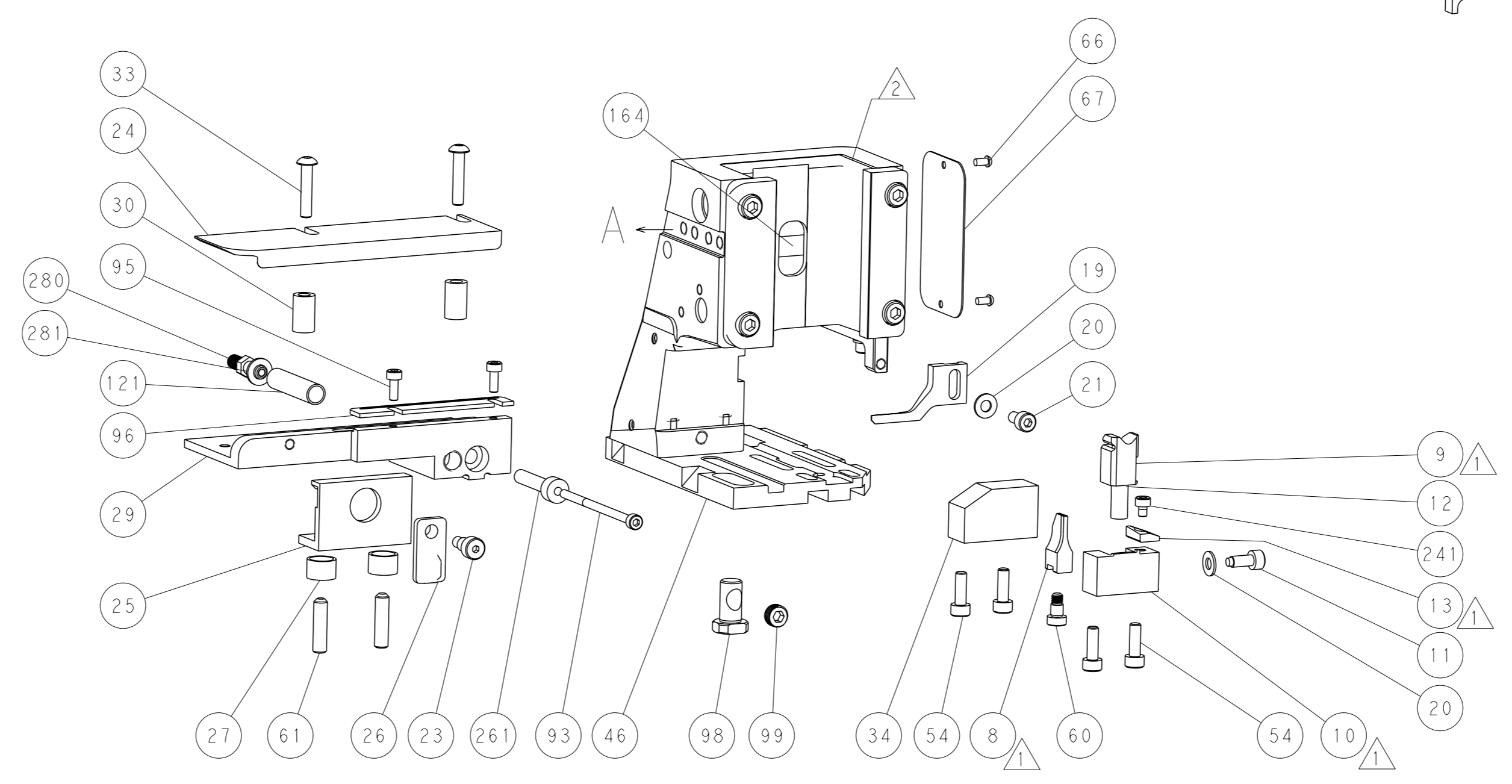
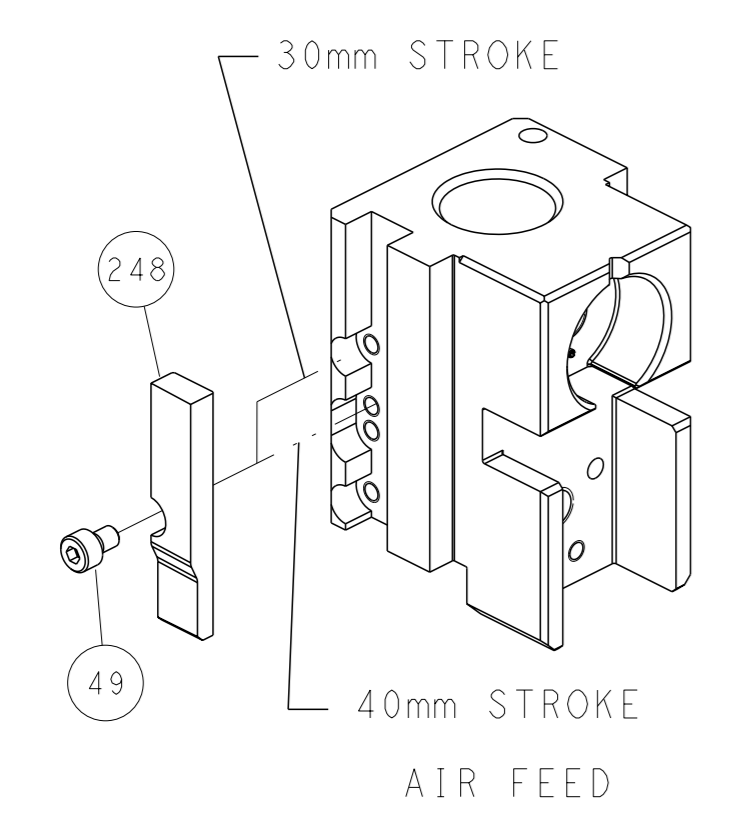


TERMINAL SUPPORT LOCATION



RAM SET-UP

### CAM POSITION



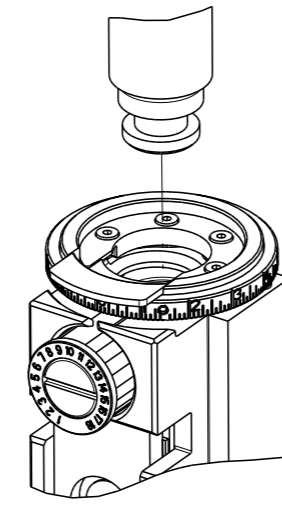
FEED TRACK POSITION GUIDE BY INSULATION BARREL

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

<small>THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE AND THE CONTROLLER'S DISCRETION SHOULD BE CONTACTED FOR THE LATEST REVISION.</small>		OWN: M. HERR CHK: T. ELBIN APVD: B. BAIR PRODUCT SPEC: 17DEC2018 APPLICATION SPEC: 17DEC2018	NAME: Ocean Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2837488 RESTRICTED TO: -
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH ±	MATERIAL: - FINISH: -	WEIGHT: - CUSTOMER DRAWING: -	SCALE: 1:2 SHEET: 2 of 4 REV: A

THIS DRAWING IS UNPUBLISHED.	RELEASED FOR PUBLICATION	2018	
COPYRIGHT 2018 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.			
PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2837488-2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2837488-7	A	CRIMP TOOLING KIT	-

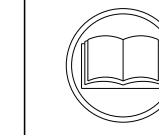
PACIFIC VERSION TERMINATOR  
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.27 mm (.050)	F
INSUL	1.65 mm (.065)	F
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: HIROSE TERMINAL HIROSE CRIMP SPECIFICATION	
TERMINAL NAME: QR/P1 SERIES CONNECTOR	
WIRE STRIP LENGTH 3.35-4.11 mm [.132-.162 IN]	TERMINAL INSULATION DIAMETER RANGE Ø0.90-1.50 mm [.035-.059 IN]
TERMINAL APPLICATION SPECIFICATION TC-QR/P1-SC2A Rev. 12/2/96	
TERMINALS APPLIED	
TE TERMINAL 3311387-1	HIROSE TERMINAL QR/P1-SC2A-211(12)
TE TERMINAL 3311388-1	HIROSE TERMINAL QR/P1-PC2A-211(12)

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
24 AWG	0.75+/-0.04 [.030+/-0.002]	8.4
26 AWG	0.72+/-0.04 [.028+/-0.002]	8.7
28 AWG	0.71+/-0.04 [.028+/-0.002]	8.8



- △ 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.
- △ PART OPTIONAL FOR BETTER LEADMAKER PERFORMANCE.
- △ TERMINAL NOT COMPATIBLE WITH MECHANICAL FEED.
- 7. 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)

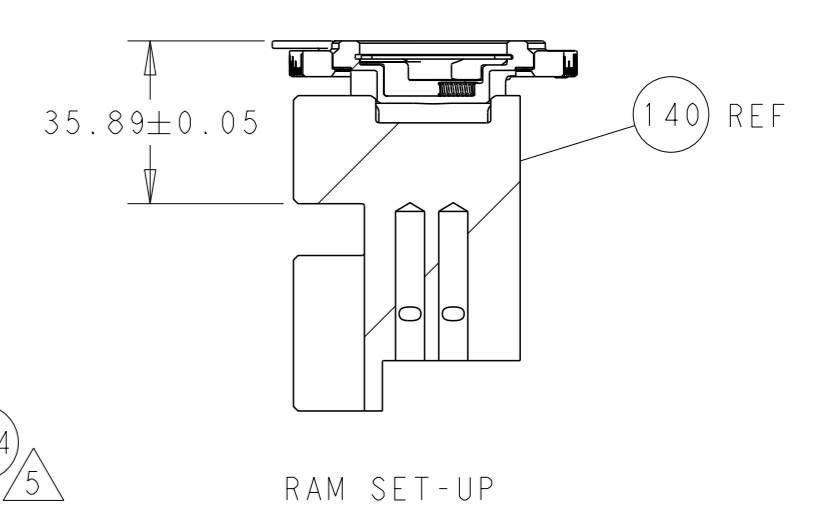
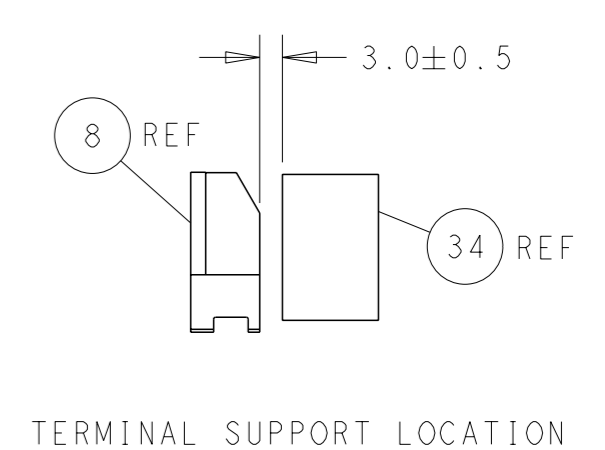
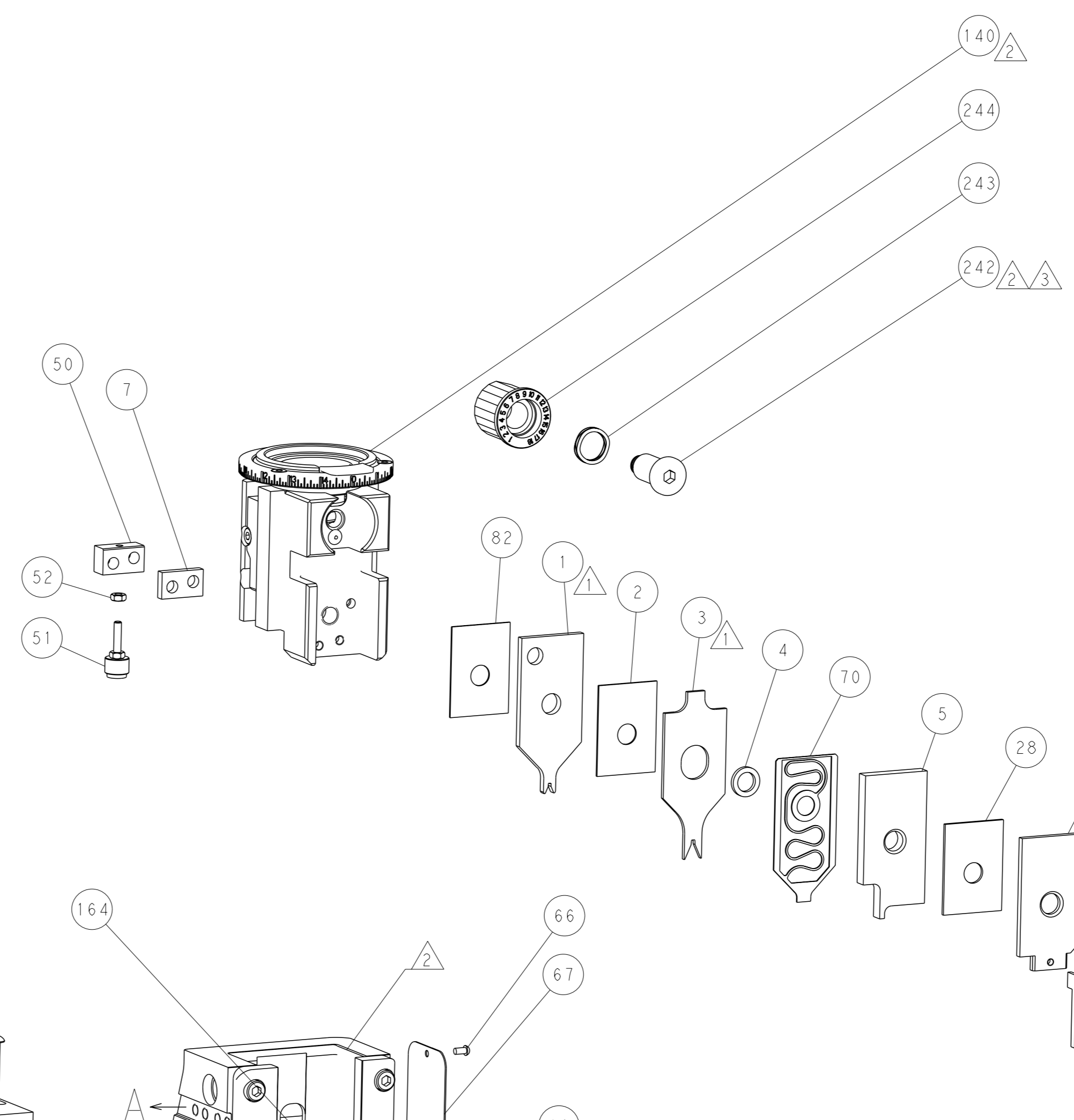
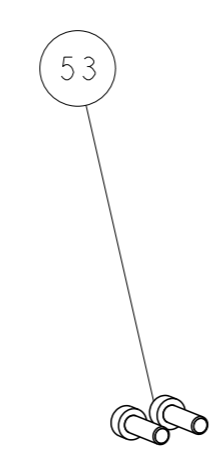
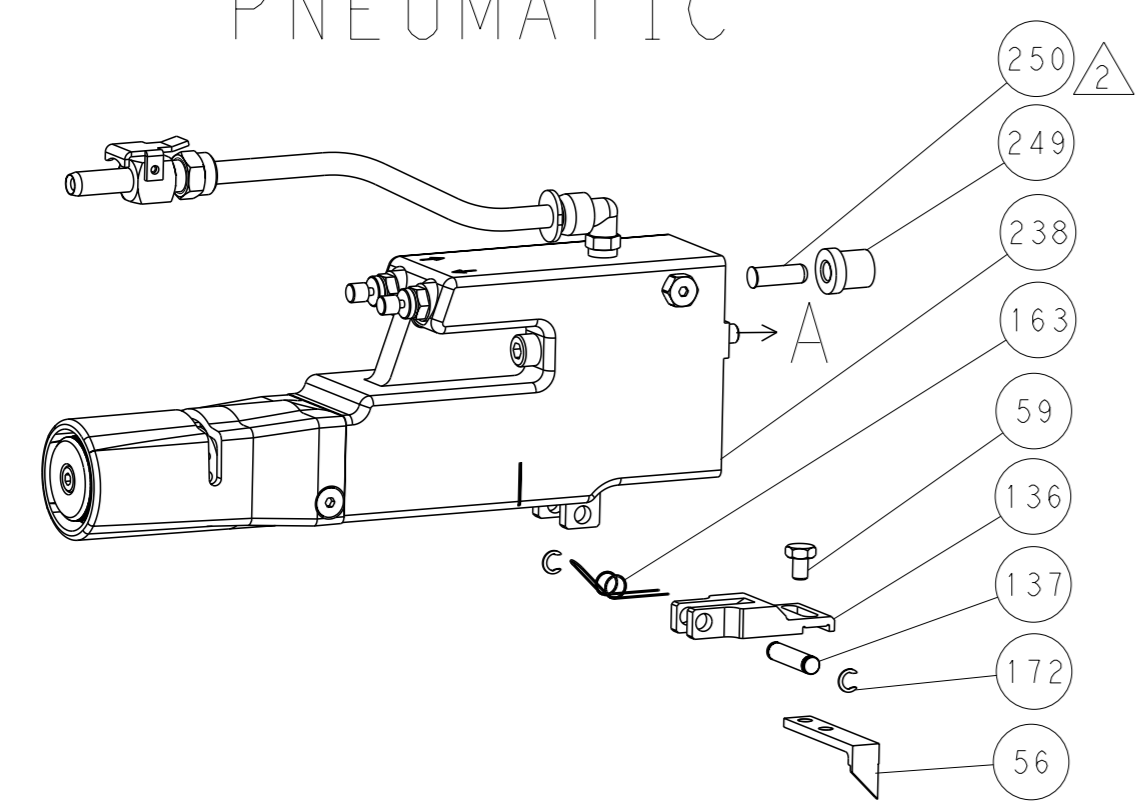
LOC	DIST	REV	DESCRIPTION	DATE	OWN	APVD
A	66		SEE SHEET 1			

QTY	LOC	DIST	REV	DESCRIPTION	DATE	OWN	APVD
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	2119640-1	PUSH ROD, AIR FEED			250
1	-	1	1803259-1	BUSHING, FLANGED			249
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	2063440-1	AIR FEED MODULE			238
2	-	2	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT			172
REF	-	REF	994970-2	COUNTER, MAGNETIC			164
1	-	1	240638-1	SPRING, FEED FINGER			163
1	-	1	2119641-2	FEED CAM, AIR FEED			151
1	-	1	2161425-1	SCREW, SHOULDER			144
4	-	4	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20			143
1	-	1	3-1803583-0	APPLICATOR BASIC ASSEMBLY, SF			141
1	-	1	1803516-1	RAM ASSEMBLY, SF PACIFIC			140
1	-	1	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854			137
1	-	1	2119799-1	HOLDER, FEED FINGER, AF			136
1	-	1	1-22281-6	SPRING, COMPRESSION			121
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	2-994962-2	SCR, SKT HD CAP M3 X 55.0			93
1	-	1	455888-5	SPACER, CRIMPER			82
1	-	1	1803607-1	DOCUMENTATION PACKAGE			71
1	-	1	2119791-1	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	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	-	1	18023-9	SCR, SKT HD CAP M4 X 6.0			49
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	2-2844962-3	SPACER, CYLINDRICAL, STRIP GUIDE			30
1	-	1	2844938-1	PLATE, STRIP GUIDE			29
1	-	1	1-455888-0	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	1-356885-5	STOP, SHEAR			11
1	-	1	2119805-1	SHEAR HOLDER, FRONT			10
1	-	1	1803095-6	FLOATING SHEAR, FRONT			9
1	-	1	1803797-1	ANVIL, COMBINATION			8
1	-	1	240641-1	SPACER			7
-	-	-	-	-			6
1	-	1	1-2119757-8	DEPRESSOR, SHEAR			5
1	-	1	5-238011-6	BLOCK, CRIMPER SPACER			4
1	-	1	1803692-2	CRIMPER, INSULATION F PREMIUM			3
1	-	1	455888-6	SPACER, CRIMPER			2
1	-	1	4-1803407-1	CRIMPER, WIRE PREMIUM			1
-77	-22		PART NO	DESCRIPTION			ITEM NO

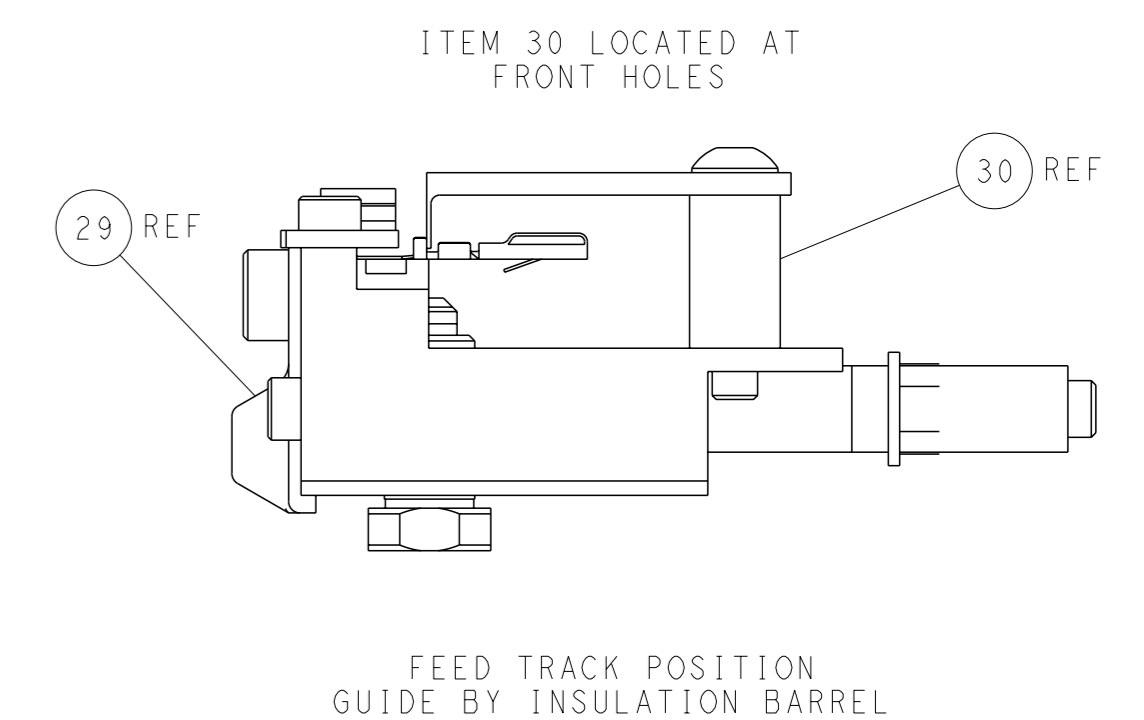
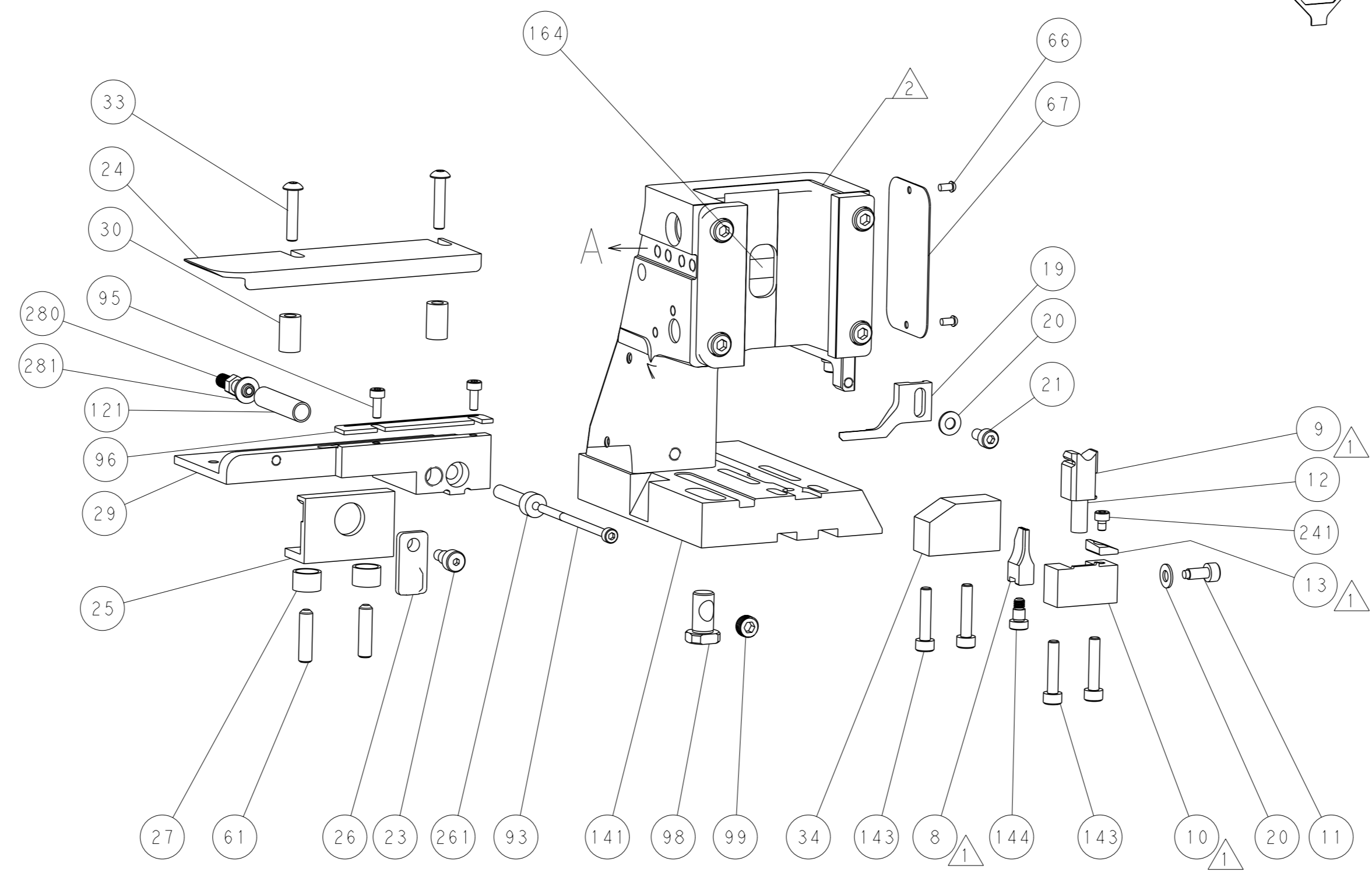
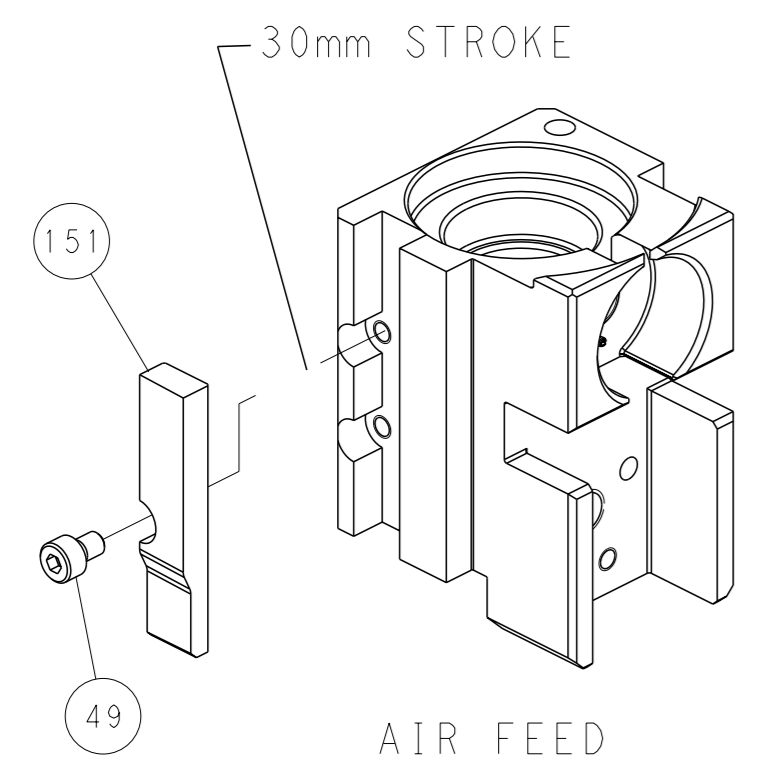
<small>THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE AND THE CUSTOMER'S RESPONSIBILITY TO CONTACT THE MANUFACTURER FOR THE LATEST REVISION.</small>		OWN: M. HERR 17DEC2018 CHK: T. ELBIN 17DEC2018 APVD: B. BAIR 17DEC2018	TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm TOLERANCES UNLESS 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=2837488	RESTRICTED TO: - SCALE: 1:2 SHEET: 3 of 4 REV: A
MATERIAL: -		WEIGHT: -	CUSTOMER DRAWING

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

### FEED TYPE PNEUMATIC



### CAM POSITION



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

<small>THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE AND THE CONTROLLER'S ENGINEERING DEPARTMENT SHOULD BE CONTACTED FOR THE LATEST REVISION.</small>		OWN: M. HERR CHK: T. ELBIN APVD: B. BAIR PRODUCT SPEC: 17DEC2018 APPLICATION SPEC: 17DEC2018	NAME: Ocean Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2837488 SCALE: 1:2 SHEET: 4 of 4 REV: A
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH ±	MATERIAL:	WEIGHT:	CUSTOMER DRAWING: