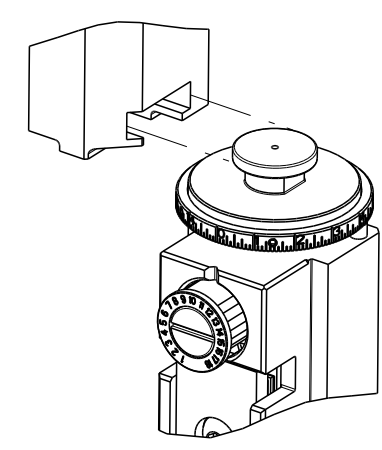


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2837110-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2837110-2	D	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2837110-1	C	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2837110-2	D	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2837110-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER

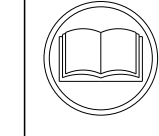


APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.20 mm [.087]	F
INSUL	2.30 mm [.091]	OV

APPLICATOR INSTRUCTIONS 408-35042

TERMINAL DATA: YAZAKI TERMINAL YAZAKI CRIMP SPECIFICATION	
TERMINAL NAME: 060 TERMINAL, MALE	
WIRE STRIP LENGTH 4.00-4.50 mm [.157-.177 IN]	TERMINAL INSULATION DIAMETER RANGE Ø1.65-2.20 mm [.065-.087 IN]
TERMINAL APPLICATION SPECIFICATION 7114738702 Rev -	
TERMINALS APPLIED	
TE TERMINAL	YAZAKI TERMINAL
311084-1	7114-7387-02

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.25mm2	1.35+/-0.05 [.053+/-0.002]	5.0
1.00mm2	1.25+/-0.05 [.049+/-0.002]	6.4
0.75mm2	1.14+/-0.05 [.045+/-0.002]	7.4



- 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. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.

6 THE CUSTOMER ACKNOWLEDGES THAT THE TERMINAL MANUFACTURER'S CRIMP SPECIFICATIONS ARE UNKNOWN. IN ADDITION THE CUSTOMER ACKNOWLEDGES THAT TE CONNECTIVITY HAS CALCULATED CRIMP SPECIFICATIONS FOR THIS PRODUCT THAT MAY NOT MATCH THE TERMINAL MANUFACTURER'S SPECIFICATIONS. TE CONNECTIVITY USES ACCEPTED PRACTICES TO DESIGN TERMINATION TOOLING FOR NON-TE CONNECTIVITY PRODUCTS. HOWEVER, **TE CONNECTIVITY EXPRESSLY DISCLAIMS ANY AND ALL WARRANTIES THAT THE TOOLING WILL RELIABLY APPLY NON-TE CONNECTIVITY PRODUCTS, INCLUDING BUT NOT LIMITED TO IMPLIED WARRANTIES OF MERCHANTABILITY OR FITNESS FOR PARTICULAR PURPOSE. THE CUSTOMER ASSUMES ALL RESPONSIBILITY AND LIABILITY FOR THE PERFORMANCE OF TERMINATED ASSEMBLIES USING SUCH TOOLING.** THE CUSTOMER EXPRESSLY INDEMNIFIES TE CONNECTIVITY AND SHALL HOLD TE CONNECTIVITY HARMLESS FROM ALL CLAIMS, DEMANDS, LOSSES, EXPENSES AND LIABILITIES RESULTING FROM THE USE OF THIS TOOLING ON NON-TE CONNECTIVITY PRODUCTS.

***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					
		P	LTN	DESCRIPTION	DATE	OWN	APVD
A	66			RELEASED	04APR2018	FZ	KZ
				ECR-19-004922	21MAR2019	FJ	TE
				ECR-19-008088	21MAY2019	JAH	CT
				ECR-19-010598	07JUL2019	TB	TE

-	1	1	1	1	2119791-5	DEPRESSOR, WIRE	286	
-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248	
-	1	1	1	1	2119082-4	CAM, SNAIL, INSULATION ADJUSTMENT	244	
-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243	
-	1	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	
-	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	455888-5	SPACER, CRIMPER	82	
-	1	1	1	1	1803607-3	DOCUMENTATION PACKAGE	71	
-	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	1338683-8	FEED PAWL	56	
-	4	4	4	4	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	54	
-	2	2	2	2	2-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 14	53	
-	1	1	1	1	1803382-6	HOLD DOWN, SPRING LOADED	50	
-	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	1803515-1	RAM ASSEMBLY, SF ATLANTIC	44	
-	1	1	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41	
-	1	1	1	1	1-1752356-9	SUPPORT, TERMINAL	34	
-	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33	
-	2	2	2	2	2-2844962-8	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	2119533-1	STRIPPER, SIDE FEED	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	2	2	1	1	8-1803058-6	ANVIL, COMBINATION	8
-	1	1	1	1	1	2-240641-4	SPACER	7
-	-	-	-	-	-	-	6	
-	1	1	1	1	2119757-8	DEPRESSOR, SHEAR	5	
-	1	1	1	1	6-238011-0	BLOCK, CRIMPER SPACER	4	
-	1	2	2	1	1	4-1803199-0	CRIMPER, INSULATION OVERLAP PREMIUM	3
-	1	1	1	1	455888-7	SPACER, CRIMPER	2	
-	1	2	2	1	1	6-1803470-5	CRIMPER, WIRE F	1
-	77	72	71	-2	-1	PART NO	ITEM NO	

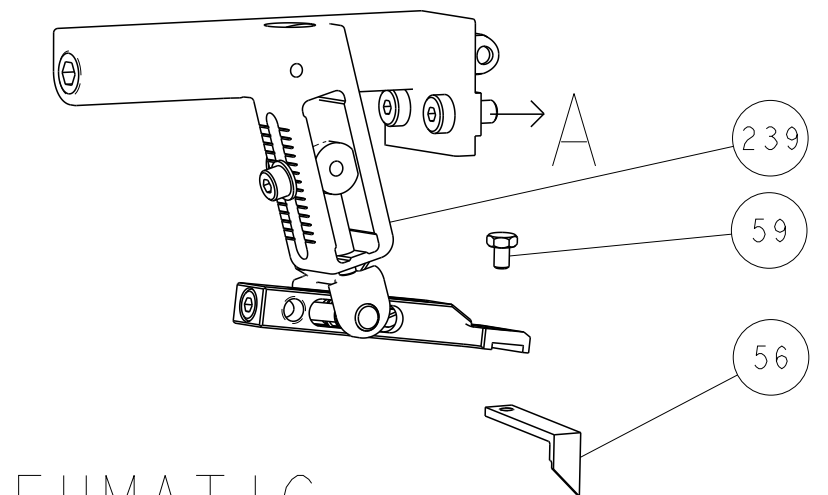
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

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

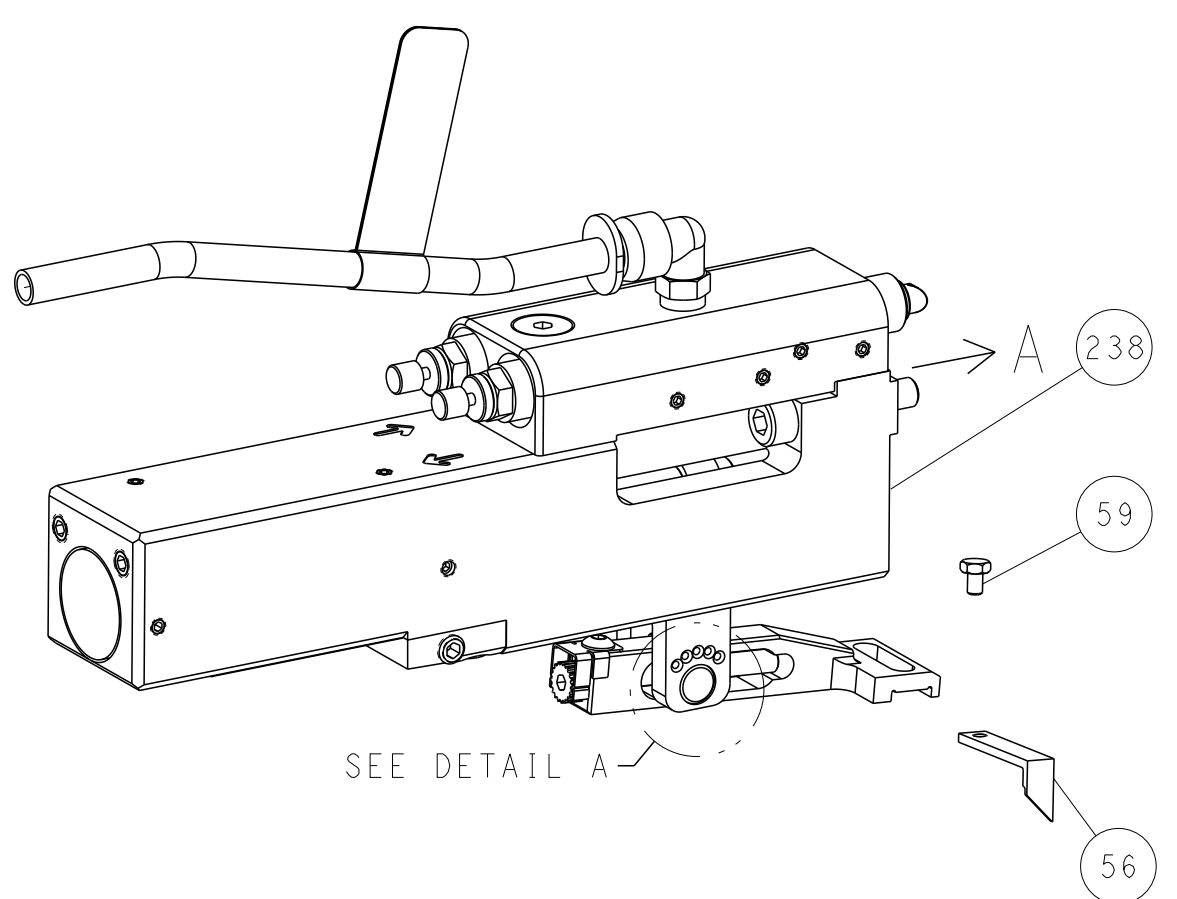
OWN	F. ZHANG	23FEB2018	TE Connectivity Harrisburg, PA 17105-3608
CHK	K. ZHANG	23FEB2018	
APVD	K. ZHANG	23FEB2018	
PRODUCT SPEC			
APPLICATION SPEC			NAME
			Ocean Side Feed Applicator
SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
A1	00779	2837110	
Customer Accessible Production Drawing			SCALE 1:2 SHEET 1 OF 4 REV D

LOC	DIST	REV	DATE	BY	APPV
A	66	-	-	-	-
		SEE SHEET 1			

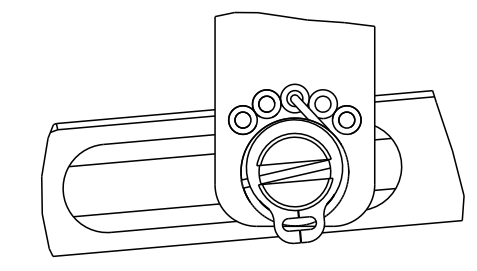
FEED TYPE MECHANICAL



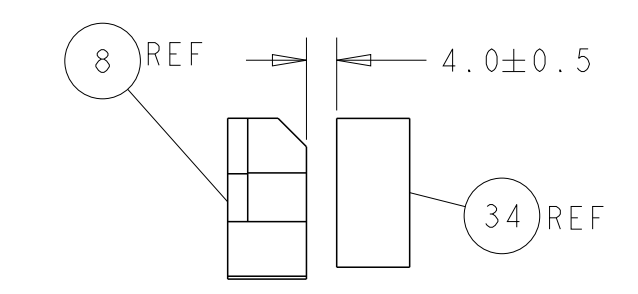
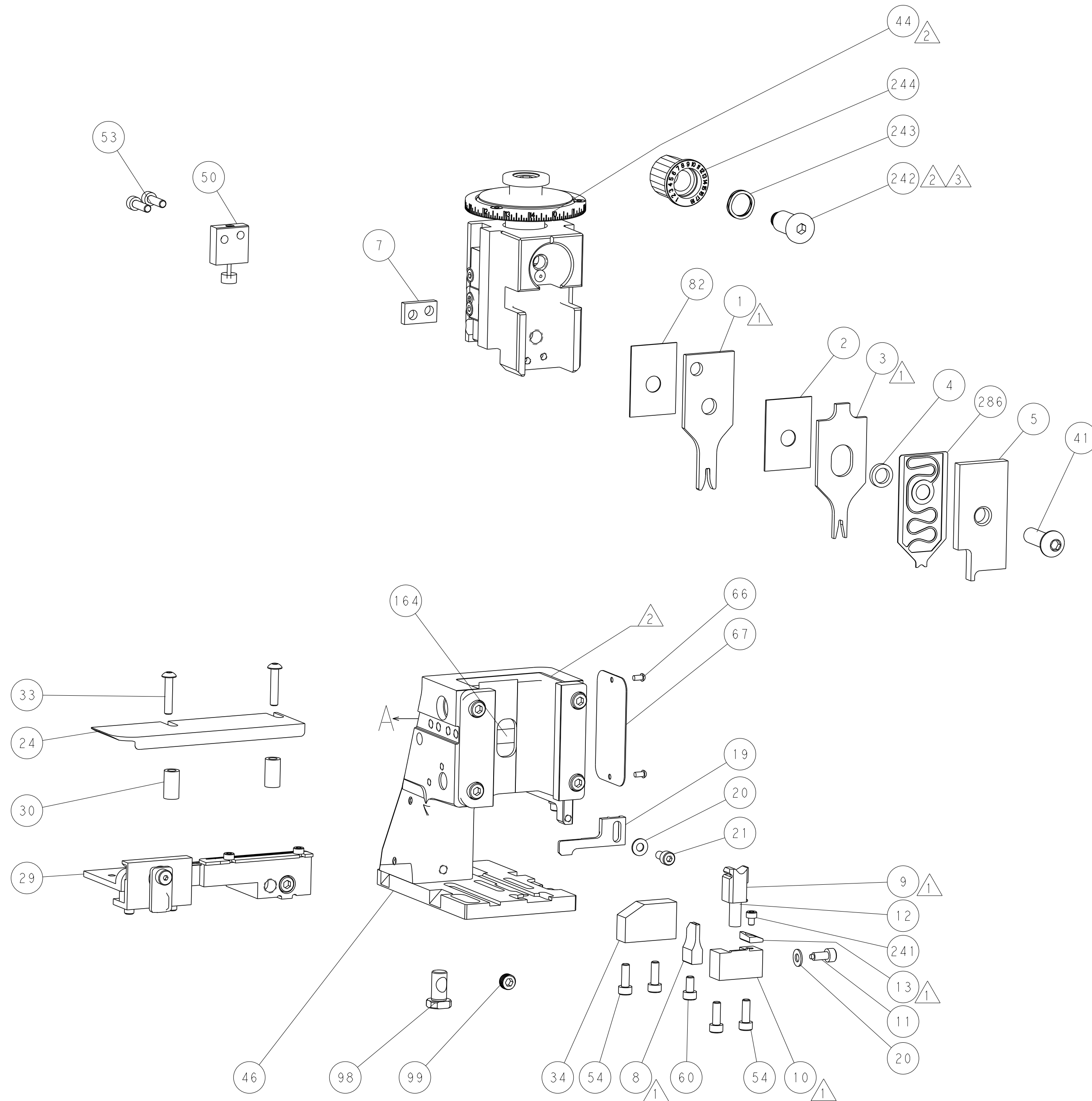
PNEUMATIC



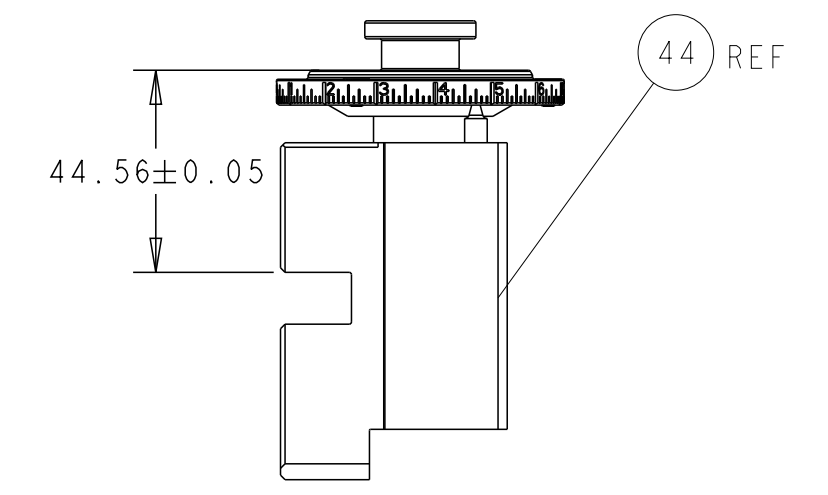
FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



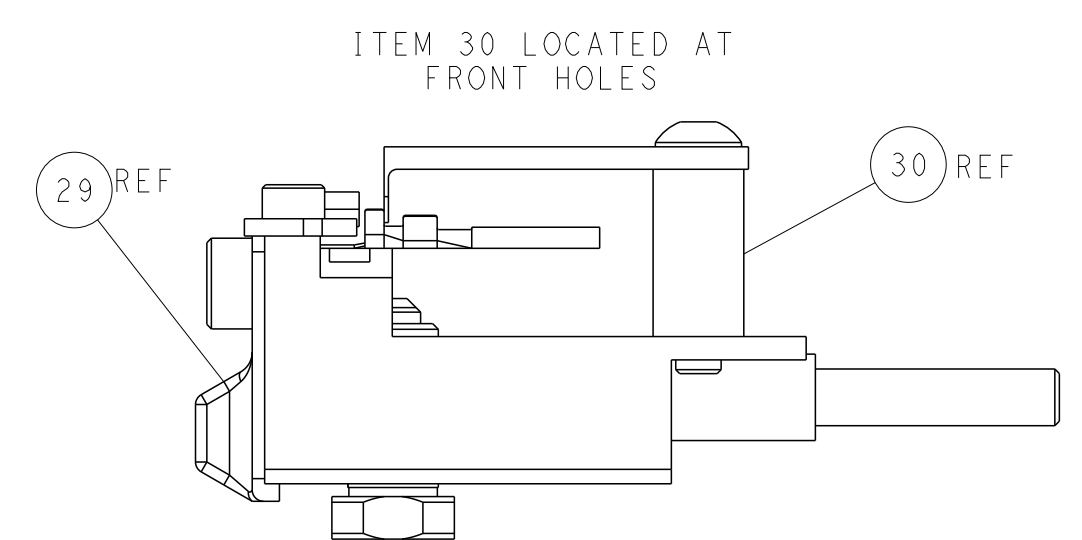
DETAIL A



TERMINAL SUPPORT LOCATION

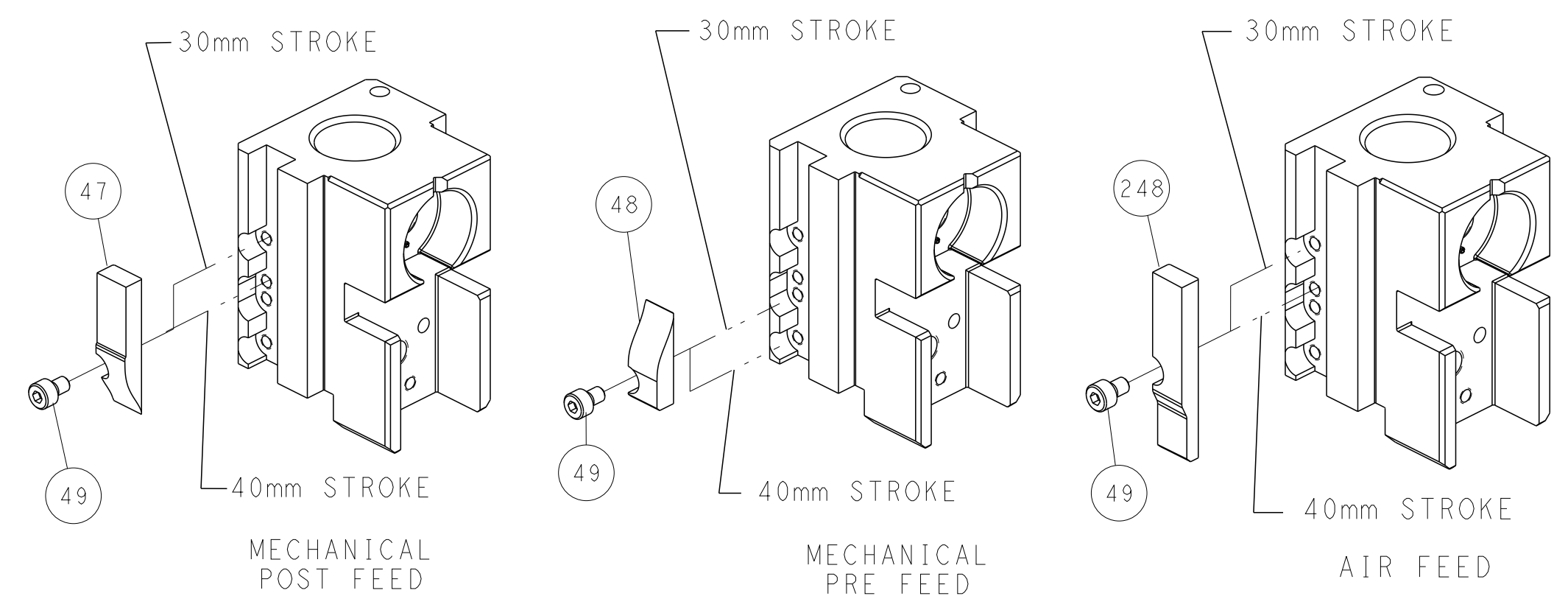


RAM SET-UP



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)

DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH		DWN F. ZHANG 23FEB2018 CHK K. ZHANG 23FEB2018 APVD K. ZHANG 23FEB2018 PRODUCT SPEC APPLICATION SPEC WEIGHT Customer Accessible Production Drawing		NAME Ocean Side Feed Applicator SIZE CAGE CODE DRAWING NO. A1 00779 C=2837110 SCALE 1:2 SHEET 2 OF 4 REV D		RESTRICTED TO	
THIS IS DRAWING IS CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION. IT IS THE PROPERTY OF TYCO ELECTRONICS CORPORATION AND IS NOT TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, INCLUDING PHOTOCOPYING, RECORDING, OR BY ANY INFORMATION STORAGE AND RETRIEVAL SYSTEM, WITHOUT THE WRITTEN PERMISSION OF TYCO ELECTRONICS CORPORATION.				TE Connectivity Harrisburg, PA 17105-3608		SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION			

THIS DRAWING IS UNPUBLISHED.	RELEASED FOR PUBLICATION		
COPYRIGHT 20 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.			
PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2837110-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2837110-2	D	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2837110-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.20 mm [.087]	F
INSUL	2.30 mm [.091]	OV
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: YAZAKI TERMINAL YAZAKI CRIMP SPECIFICATION	
TERMINAL NAME: 060 TERMINAL, MALE	
WIRE STRIP LENGTH 4.00-4.50 mm [.157-.177 IN]	TERMINAL INSULATION DIAMETER RANGE Ø1.65-2.20 mm [.065-.087 IN]
TERMINAL APPLICATION SPECIFICATION 7114738702 Rev -	
TERMINALS APPLIED	
TE TERMINAL	YAZAKI TERMINAL
311084-1	7114-7387-02

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.25mm ²	1.35 +/- 0.05 [.053 +/- .002]	5.0
1.00mm ²	1.25 +/- 0.05 [.049 +/- .002]	6.4
0.75mm ²	1.14 +/- 0.05 [.045 +/- .002]	7.4

***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.

- 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.
- UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- THE CUSTOMER ACKNOWLEDGES THAT THE TERMINAL MANUFACTURER'S CRIMP SPECIFICATIONS ARE UNKNOWN. IN ADDITION THE CUSTOMER ACKNOWLEDGES THAT TE CONNECTIVITY HAS CALCULATED CRIMP SPECIFICATIONS FOR THIS PRODUCT THAT MAY NOT MATCH THE TERMINAL MANUFACTURER'S SPECIFICATIONS. TE CONNECTIVITY USES ACCEPTED PRACTICES TO DESIGN TERMINATION TOOLING FOR NON-TE CONNECTIVITY PRODUCTS. HOWEVER, **TE CONNECTIVITY EXPRESSLY DISCLAIMS ANY AND ALL WARRANTIES THAT THE TOOLING WILL RELIABLY APPLY NON-TE CONNECTIVITY PRODUCTS, INCLUDING BUT NOT LIMITED TO IMPLIED WARRANTIES OF MERCHANTABILITY OR FITNESS FOR PARTICULAR PURPOSE. THE CUSTOMER ASSUMES ALL RESPONSIBILITY AND LIABILITY FOR THE PERFORMANCE OF TERMINATED ASSEMBLIES USING SUCH TOOLING.** THE CUSTOMER EXPRESSLY INDEMNIFIES TE CONNECTIVITY AND SHALL HOLD TE CONNECTIVITY HARMLESS FROM ALL CLAIMS, DEMANDS, LOSSES, EXPENSES AND LIABILITIES RESULTING FROM THE USE OF THIS TOOLING ON NON-TE CONNECTIVITY PRODUCTS.

LOC	DIST	REVISIONS					
A	66	P	LTN	DESCRIPTION	DATE	DWN	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	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	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	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	1338683-8	FEED PAWL	56
-	2	2	2-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 14	53
-	1	1	1803382-6	HOLD DOWN, SPRING LOADED	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	1	1-1752356-9	SUPPORT, TERMINAL	34
-	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	2-2844962-8	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	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	1803095-3	FLOATING SHEAR, FRONT	9
1	1	1	8-1803058-6	ANVIL, COMBINATION	8
-	1	1	2-240641-4	SPACER	7
-	-	-	-	-	6
-	1	1	2119757-8	DEPRESSOR, SHEAR	5
-	1	1	6-238011-0	BLOCK, CRIMPER SPACER	4
1	1	1	4-1803199-0	CRIMPER, INSULATION OVERLAP PREMIUM	3
-	1	1	455888-7	SPACER, CRIMPER	2
1	1	1	6-1803470-5	CRIMPER, WIRE F	1

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:		DWG: F. ZHANG 23FEB2018		CHK: K. ZHANG 23FEB2018		APVD: K. ZHANG 23FEB2018		NAME: Ocean Side Feed Applicator	
0 PLC	±	0.15	±	0.15	±	0.15	±	0.15	±	0.15	±
1 PLC	±	0.25	±	0.25	±	0.25	±	0.25	±	0.25	±
2 PLC	±	0.38	±	0.38	±	0.38	±	0.38	±	0.38	±
3 PLC	±	0.51	±	0.51	±	0.51	±	0.51	±	0.51	±
4 PLC	±	0.64	±	0.64	±	0.64	±	0.64	±	0.64	±
ANGLES	±	0.15	±	0.15	±	0.15	±	0.15	±	0.15	±
MATERIAL		FINISH		WEIGHT		SCALE	1:2	SHEET	3	OF	4
Customer Accessible Production Drawing		RESTRICTED TO		SCALE		SHEET		3		OF 4	

