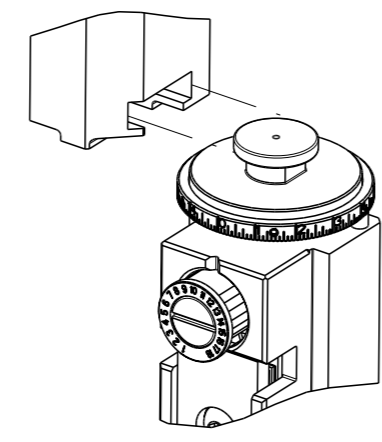


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2837276-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2837276-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2837276-1	B	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2837276-2	B	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2837276-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.54 mm [.100]	F
INSUL	4.83 mm [.190]	O

APPLICATOR INSTRUCTIONS 408-35042

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: .187 SERIES SEALED CONNECTOR			
WIRE STRIP LENGTH		TERMINAL INSULATION DIAMETER RANGE	
6.00-6.00 mm [.236-.236 IN]		Ø2.00-2.60 mm [.079-.102 IN]	
TERMINAL APPLICATION SPECIFICATION	114-5126		

TERMINALS APPLIED				SEAL INSULATION DIAMETER RANGE
TE TERMINAL	TE TERMINAL	TE SEAL	TE SEAL	
175090-1	175087-1	85024-1	YULONG SEAL	1.6-2.9mm
		TE SEAL	250-7620	
		2082209-1		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.25mm2	1.64+/-0.05 [1.065+/-0.002]	5.3
0.85mm2	1.51+/-0.05 [1.059+/-0.002]	6.7
0.50mm2	1.40+/-0.05 [1.055+/-0.002]	8.0

- 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 APPLICATOR FEED NEED TO READJUST WHEN SWITCHING TERMINALS.
- 6 APPLY TORQ-SEAL IN ALLEN SOCKET TO FILL HOLE AFTER FLAT HD HAS BEEN ADJUSTED TO CORRECT HEIGHT AT QUALIFICATION. APPLY #1-23419-5 LOC-TITE TO THREADS.
- 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)

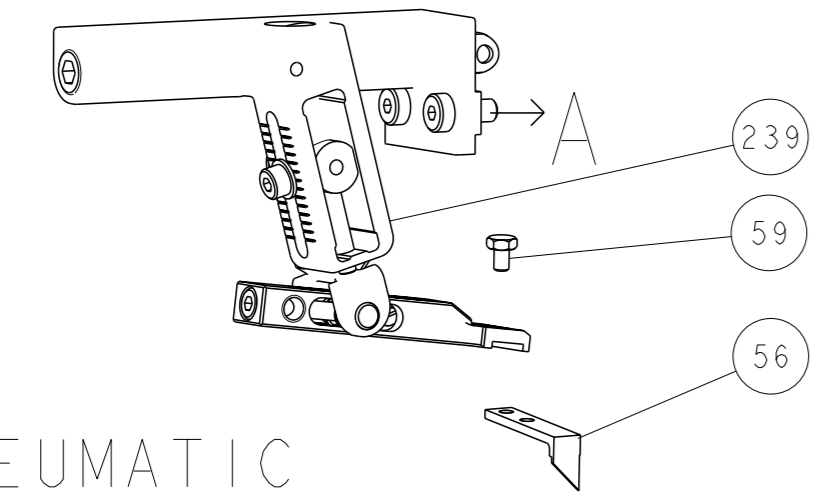
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A	66			RELEASED	25SEP2018	RK	CT
				ECR-19-019003	06DEC2019	FJ	TE

-	2	2	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	269	
-	1	1	1	1	1633782-3	FENCE	267	
-	1	1	1	1	1803078-3	SPACER, PRECISION	259	
-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248	
-	1	1	1	1	2119082-3	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	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	985575-3	SCR, FLT SKT HD CAP M3 X 10.0	57	
-	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	
-	2	2	2	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	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	1803515-2	RAM ASSEMBLY, SF ATLANTIC	44	
-	1	1	1	1	1803602-2	SCR, BHSC, RoHS (M8 X 40)	41	
-	1	1	1	1	1752356-3	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	455888-5	SPACER, CRIMPER	28	
-	1	1	1	1	1320928-6	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	1-356885-5	STOP, SHEAR	11	
-	1	1	1	1	2119805-1	SHEAR HOLDER, FRONT	10	
-	1	1	1	1	318707-1	FLOATING SHEAR, FRONT	9	
-	1	2	2	1	1	2-1803512-4	ANVIL, COMBINATION	8
-	-	-	-	-	-	-	7	
-	-	-	-	-	-	-	6	
-	1	1	1	1	2119781-5	DEPRESSOR, SHEAR	5	
-	1	1	1	1	238011-2	BLOCK, CRIMPER SPACER	4	
-	1	2	2	1	1	1-1803712-5	CRIMPER, INSULATION O	3
-	1	1	1	1	1-455888-4	SPACER, CRIMPER	2	
-	1	2	2	1	1	456407-6	CRIMPER, WIRE PREMIUM	1

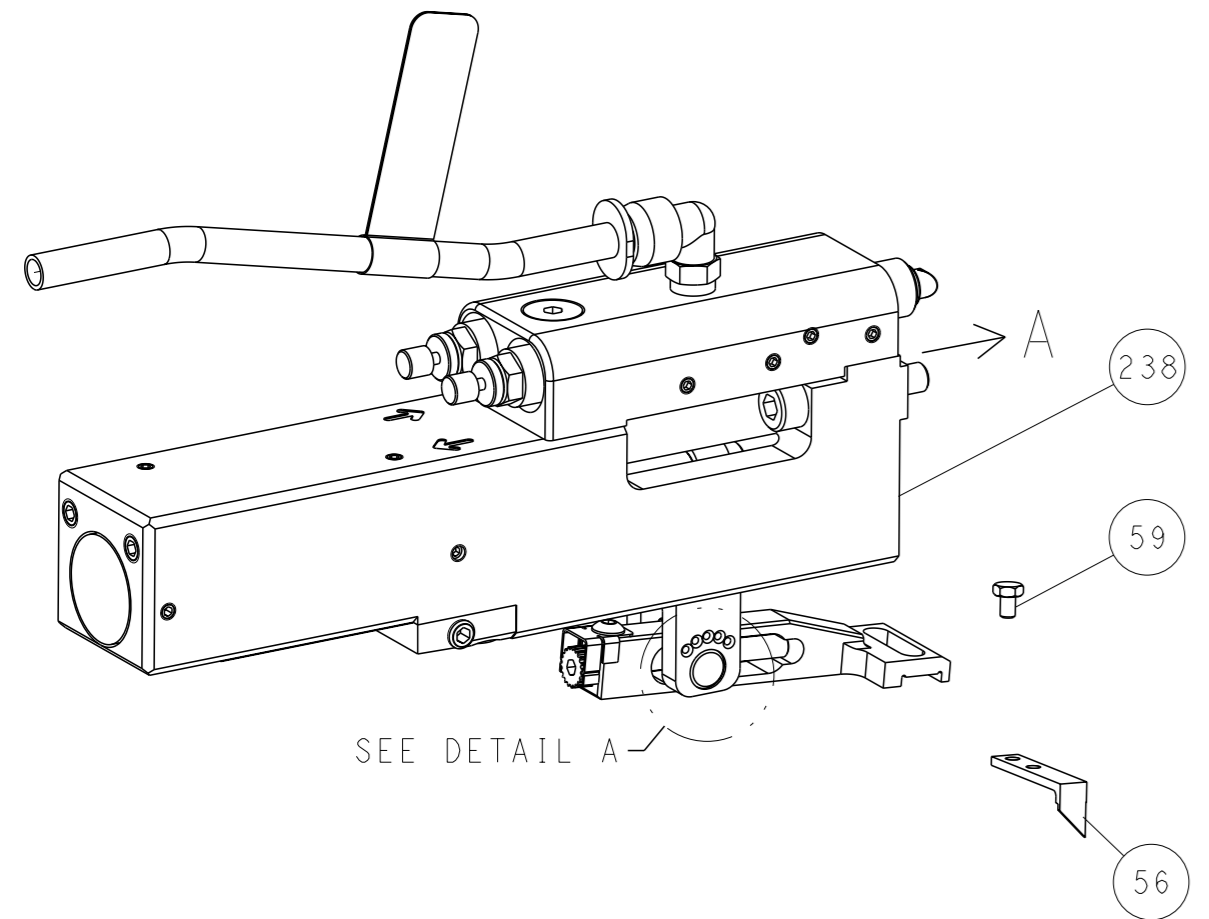
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	3 PLC ±	4 PLC ±	ANGLES ±	L. ZHANG	L. ZHANG	22AUG2018	Customer Accessible Production Drawing	
MATERIAL	FINISH	WEIGHT	SCALE	SHEET		REV		B

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

# FEED TYPE MECHANICAL



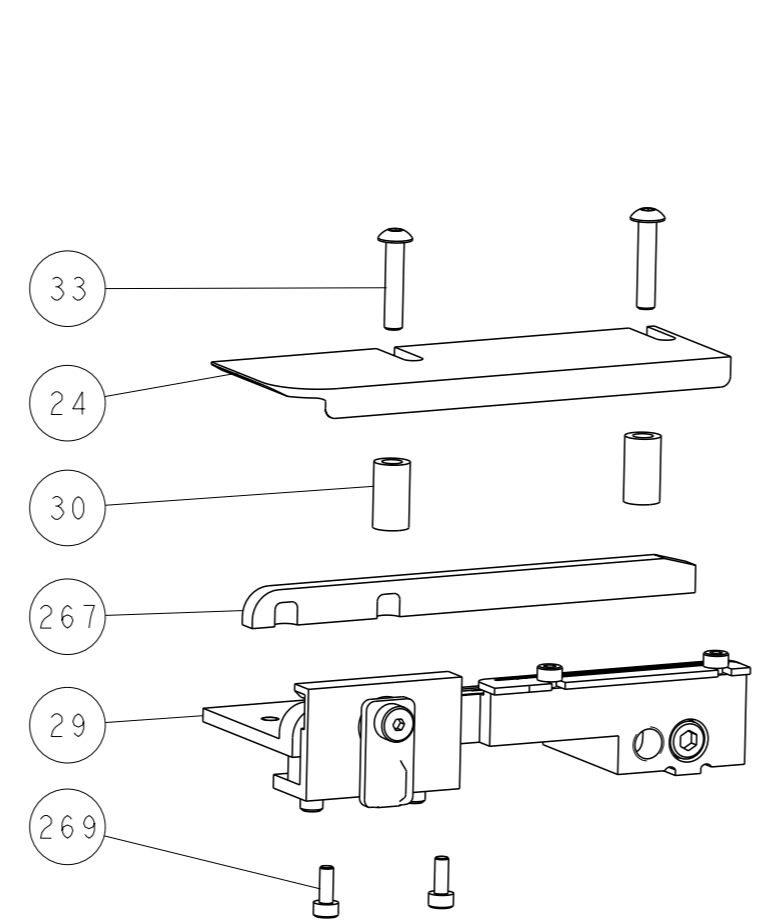
## PNEUMATIC



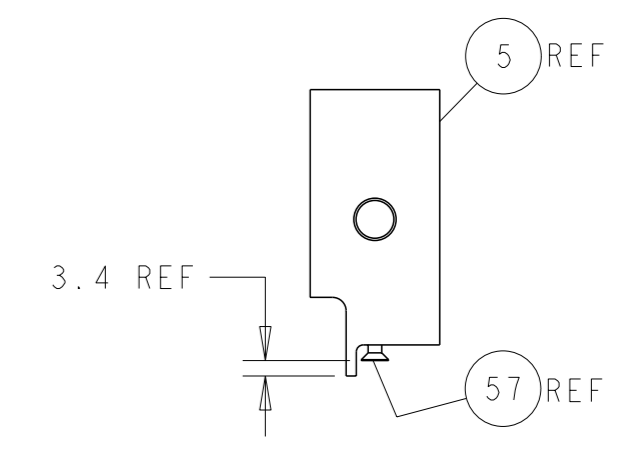
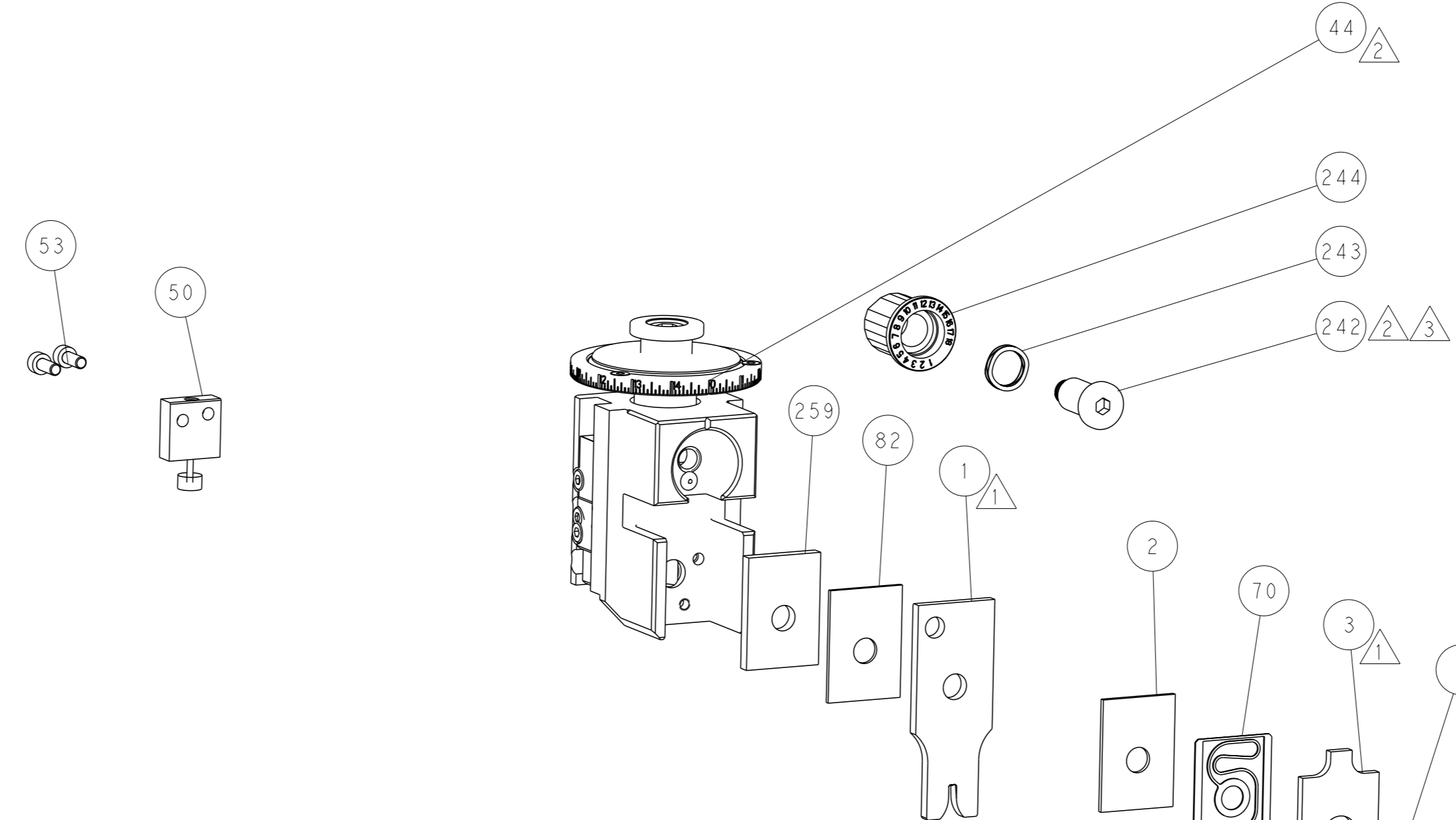
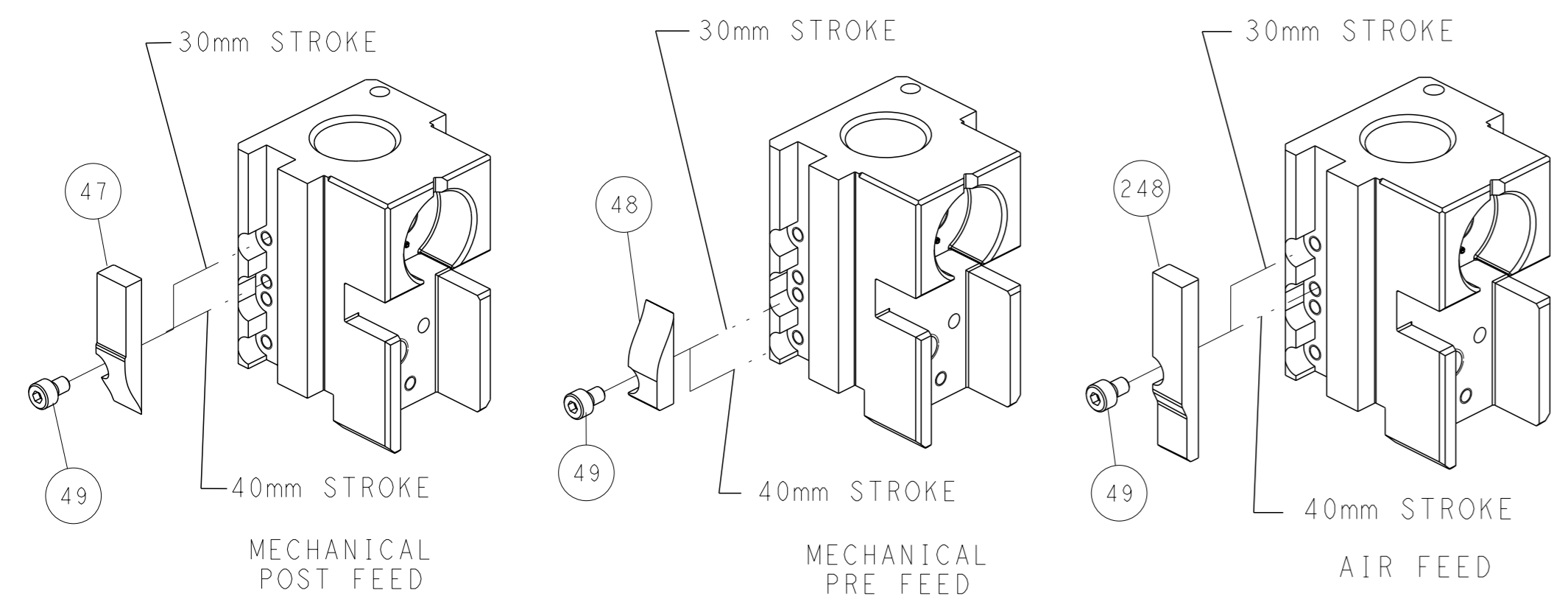
## FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



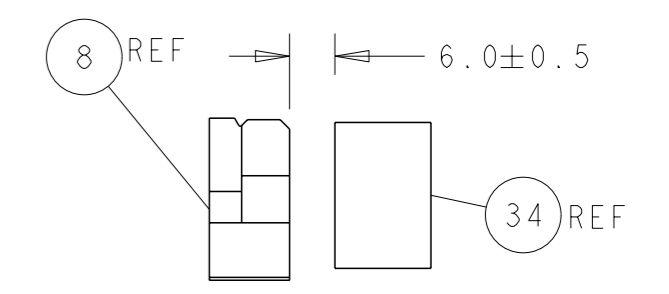
DETAIL A



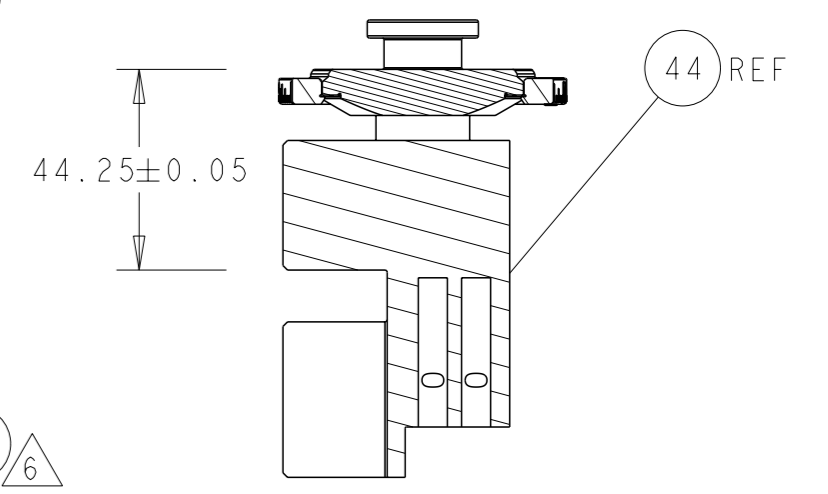
# CAM POSITIONS



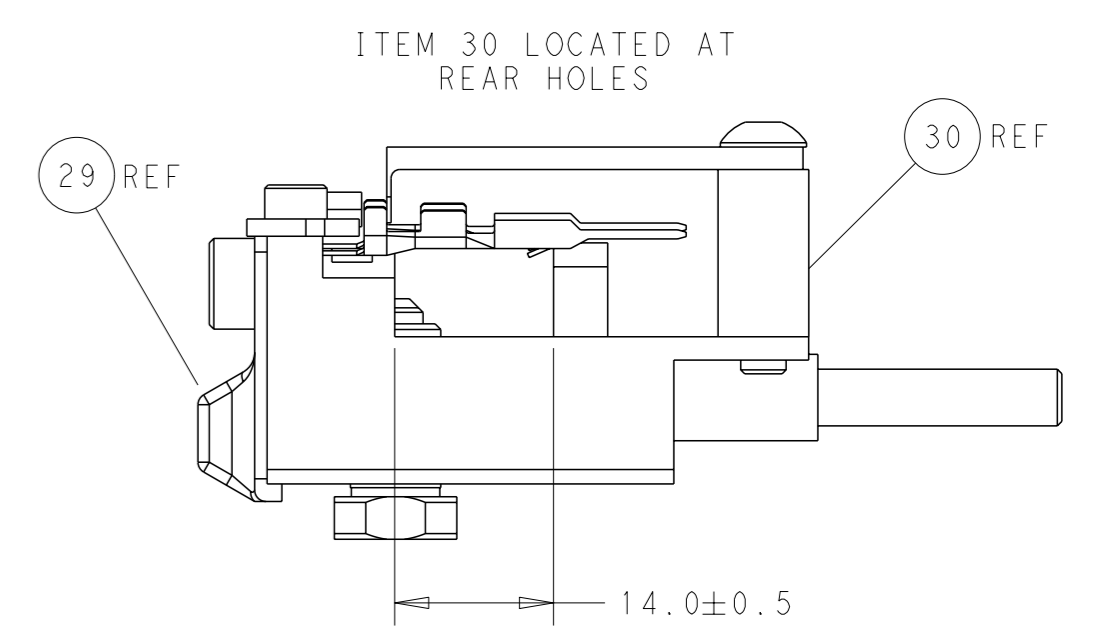
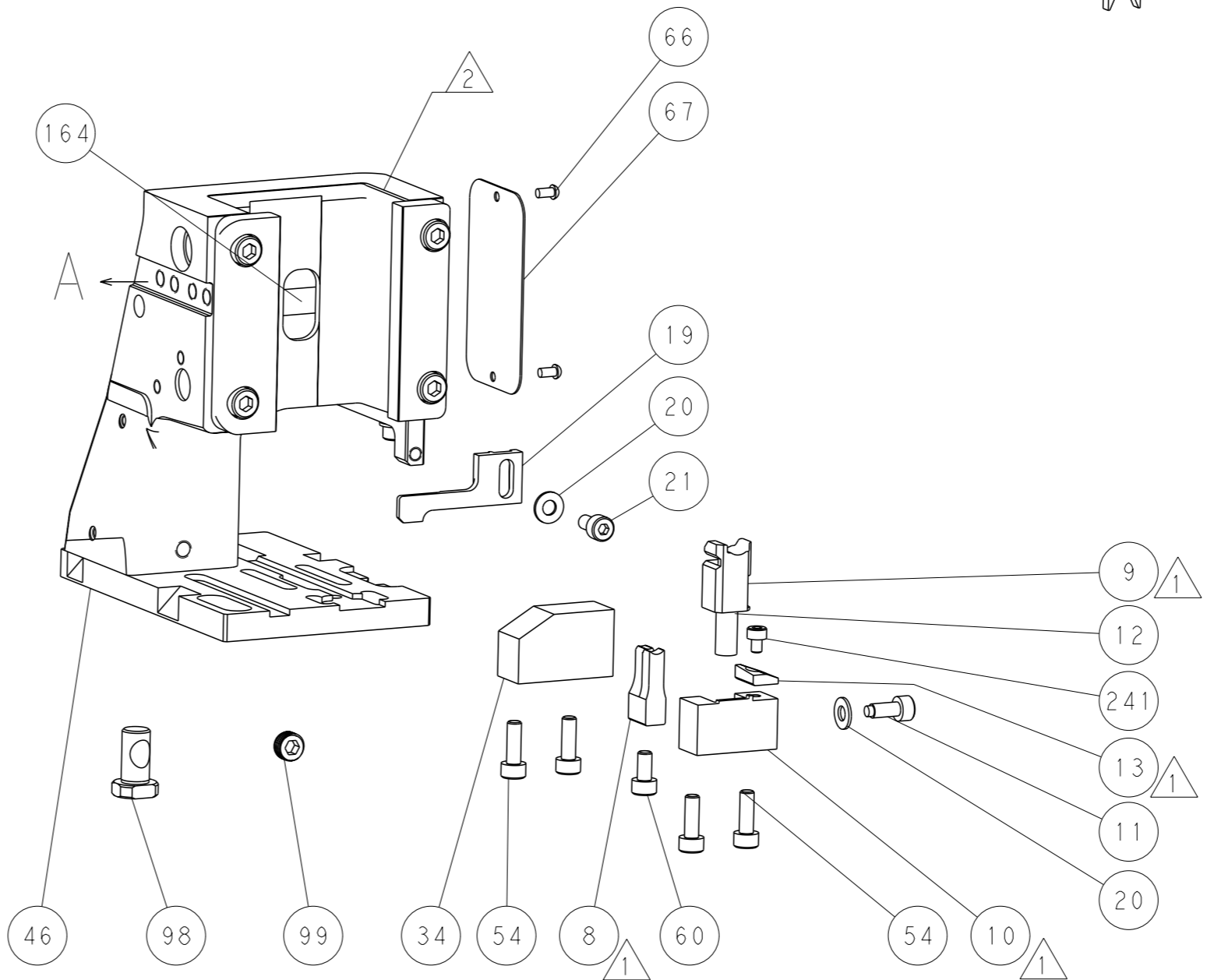
SHEAR DEPRESSOR DETAIL



TERMINAL SUPPORT LOCATION



RAM SET-UP



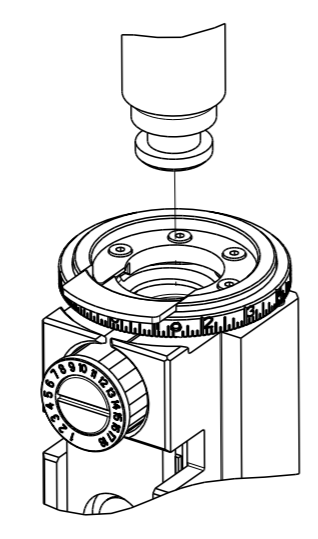
FEED TRACK POSITION GUIDE BY INSULATION BARREL

**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 CONTROL AND REVISIONS DISPOSITION SHOULD BE CONTACTED FOR THE LATEST REVISION.</small>		DWN: H. HUANG 22AUG2018 CHK: L. ZHANG 22AUG2018 APVD: L. ZHANG 22AUG2018	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: 2837276	WEIGHT: - SCALE: 1:2 SHEET: 2 of 4 REV: B	RESTRICTED TO: -
MATERIAL: -		Customer Accessible Production Drawing	

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2837276-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2837276-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2837276-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR  
 INTERFACE ADAPTER

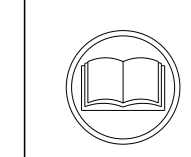


APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.54 mm [.100]	F
INSUL	4.83 mm [.190]	O
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: .187 SERIES SEALED CONNECTOR			
WIRE STRIP LENGTH 6.00-6.00 mm [.236-.236 IN]		TERMINAL INSULATION DIAMETER RANGE Ø2.00-2.60 mm [.079-.102 IN]	
TERMINAL APPLICATION SPECIFICATION 114-5126			

TERMINALS APPLIED				SEAL INSULATION DIAMETER RANGE
TE TERMINAL	TE TERMINAL	TE SEAL	TE SEAL	
175090-1	175087-1	85024-1	YULONG SEAL	1.6-2.9mm
		TE SEAL	250-7620	
		2082209-1		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.25mm <sup>2</sup>	1.64+/-0.05 [1.065+/-0.002]	5.3
0.85mm <sup>2</sup>	1.51+/-0.05 [1.059+/-0.002]	6.7
0.50mm <sup>2</sup>	1.40+/-0.05 [1.055+/-0.002]	8.0



- 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 APPLICATOR FEED NEED TO READJUST WHEN SWITCHING TERMINALS.
- 6 APPLY TORO-SEAL IN ALLEN SOCKET TO FILL HOLE AFTER FLAT HD HAS BEEN ADJUSTED TO CORRECT HEIGHT AT QUALIFICATION. APPLY #1-23419-5 LOC-TITE TO THREADS.
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)

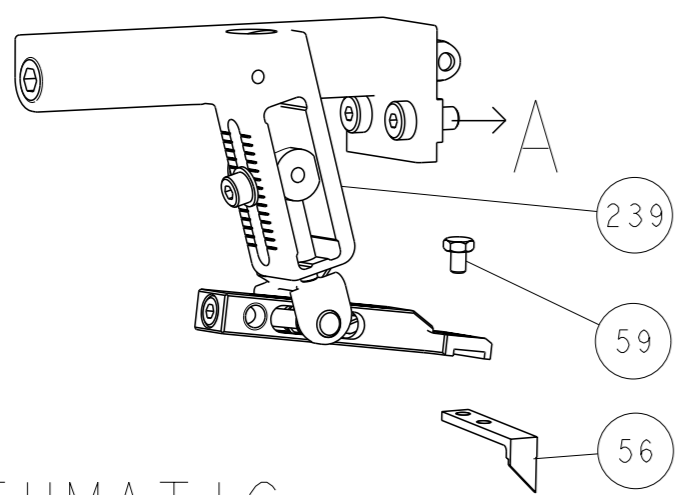
LOC	DIST	REVISIONS			
A	66	REV	DATE	BY	APPV
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-	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	269
-	1	1	1633782-3	FENCE	267
-	1	1	1803078-3	SPACER, PRECISION	259
-	1	1	2119082-3	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	2079764-1	WASHER, WAVE SPRING, 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	1803516-2	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	985575-3	SCR, FLT SKT HD CAP M3 X 10.0	57
-	1	1	1338685-1	PAWL, FEED	56
-	2	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	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	1803602-2	SCR, BHSC, RoHS (M8 X 40)	41
-	1	1	1752356-3	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	455888-5	SPACER, CRIMPER	28
-	1	1	1320928-6	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	1-356885-5	STOP, SHEAR	11
-	1	1	2119805-1	SHEAR HOLDER, FRONT	10
-	1	1	318707-1	FLOATING SHEAR, FRONT	9
1	1	1	2-1803512-4	ANVIL, COMBINATION	8
-	-	-	-	-	7
-	-	-	-	-	6
-	1	1	2119781-5	DEPRESSOR, SHEAR	5
-	1	1	238011-2	BLOCK, CRIMPER SPACER	4
1	1	1	1-1803712-5	CRIMPER, INSULATION O	3
-	1	1	1-455888-4	SPACER, CRIMPER	2
1	1	1	456407-6	CRIMPER, WIRE PREMIUM	1
-	-	-	-77-22-21	PART NO	ITEM NO

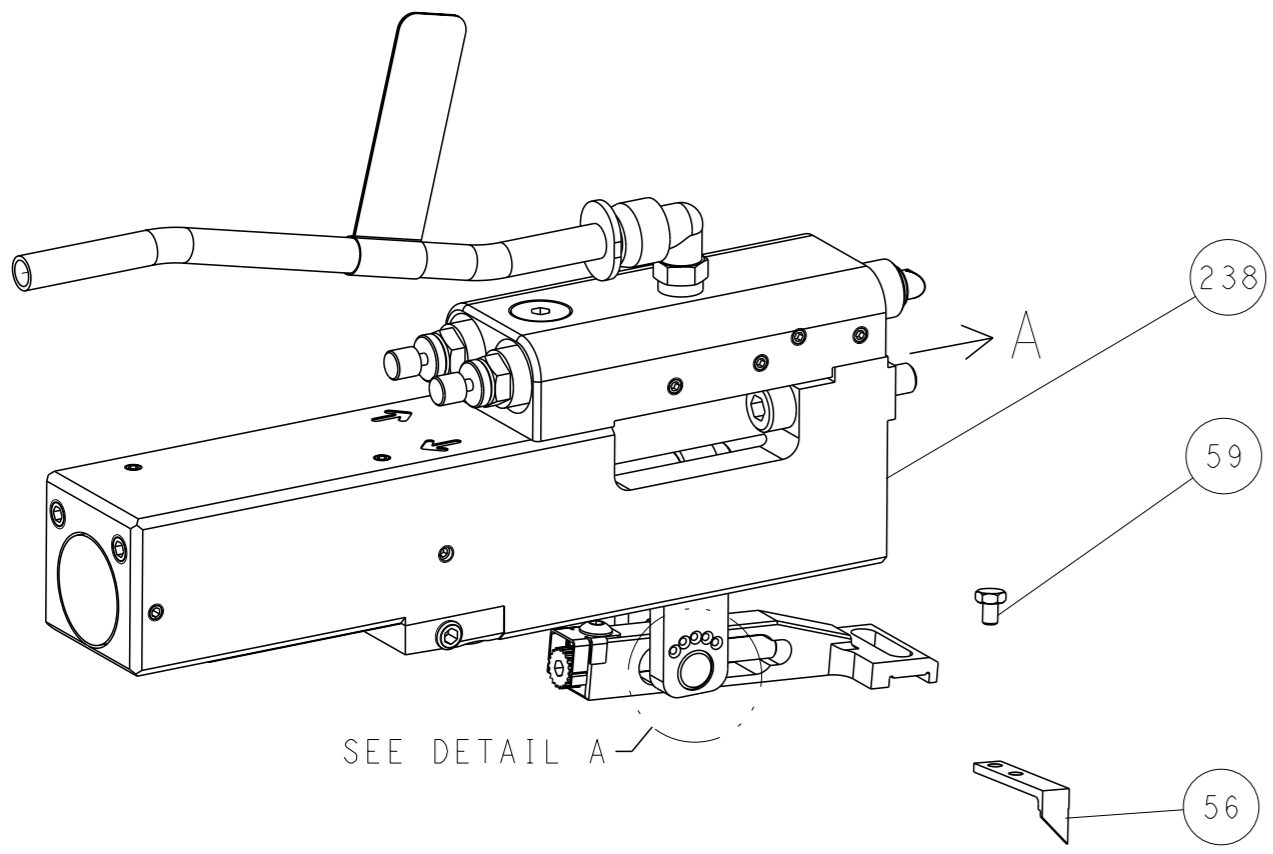
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		OWN		NAME	
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	3 PLC ±	4 PLC ±	ANGLES ±	CHK	22AUG2018	Harrisburg, PA 17105-3608	
	FINISH			APV	22AUG2018	Ocean Side Feed Applicator	
MATERIAL				PRODUCT SPEC		SIZE	CAGE CODE DRAWING NO
				APPLICATION SPEC		A1	00779 C=2837276
				WEIGHT		SCALE	1:2 SHEET 3 OF 4 REV B
						Customer Accessible Production Drawing	

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

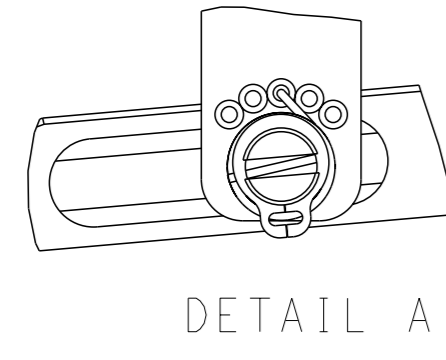
# FEED TYPE MECHANICAL



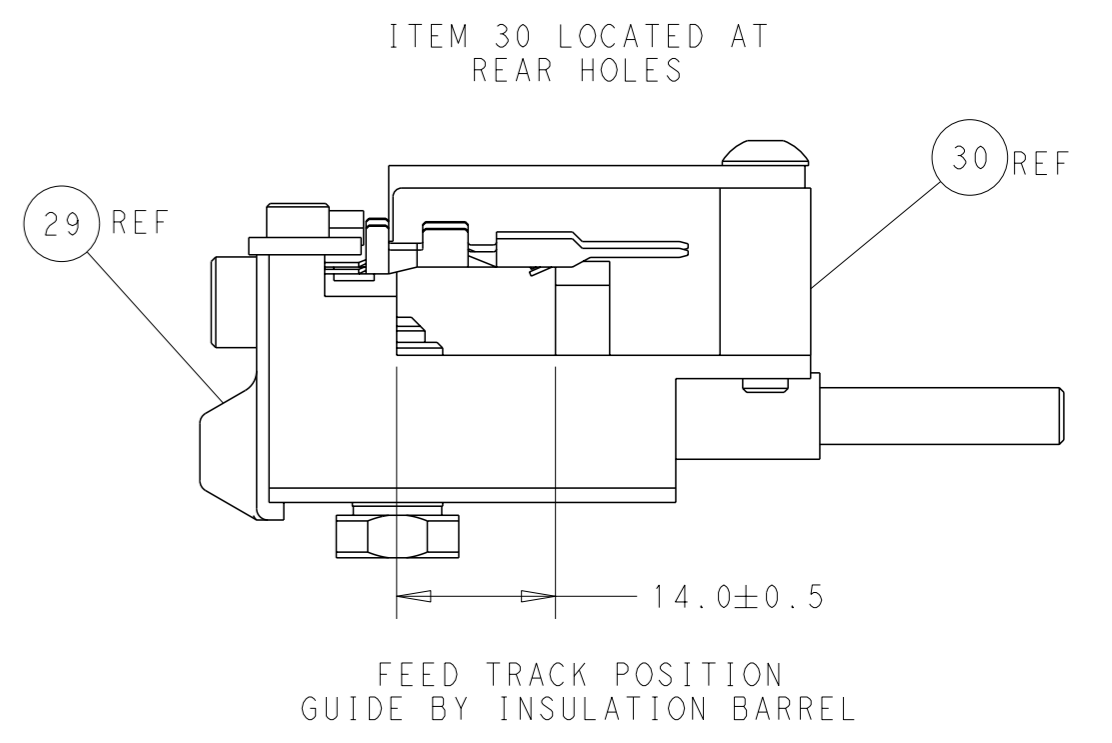
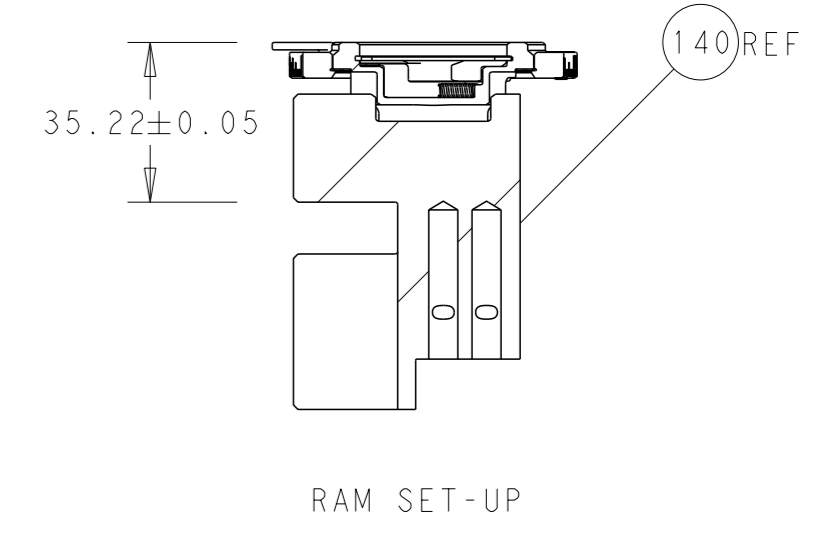
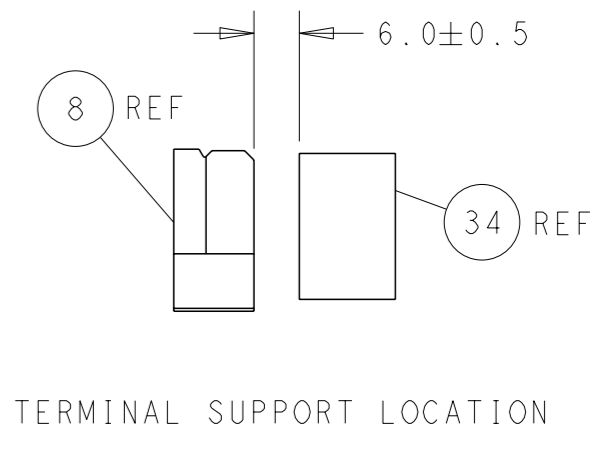
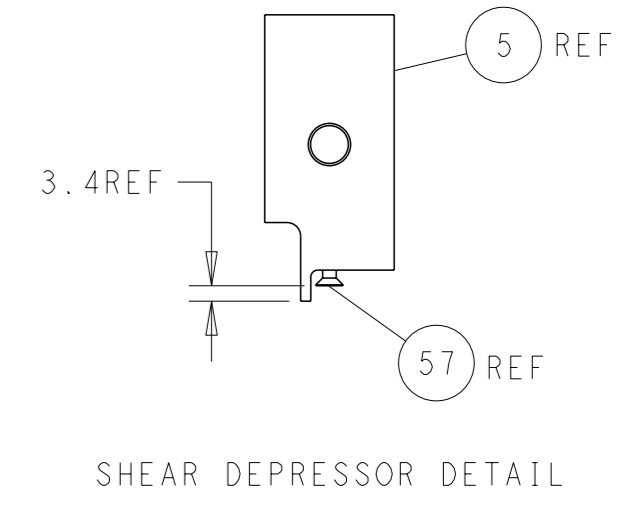
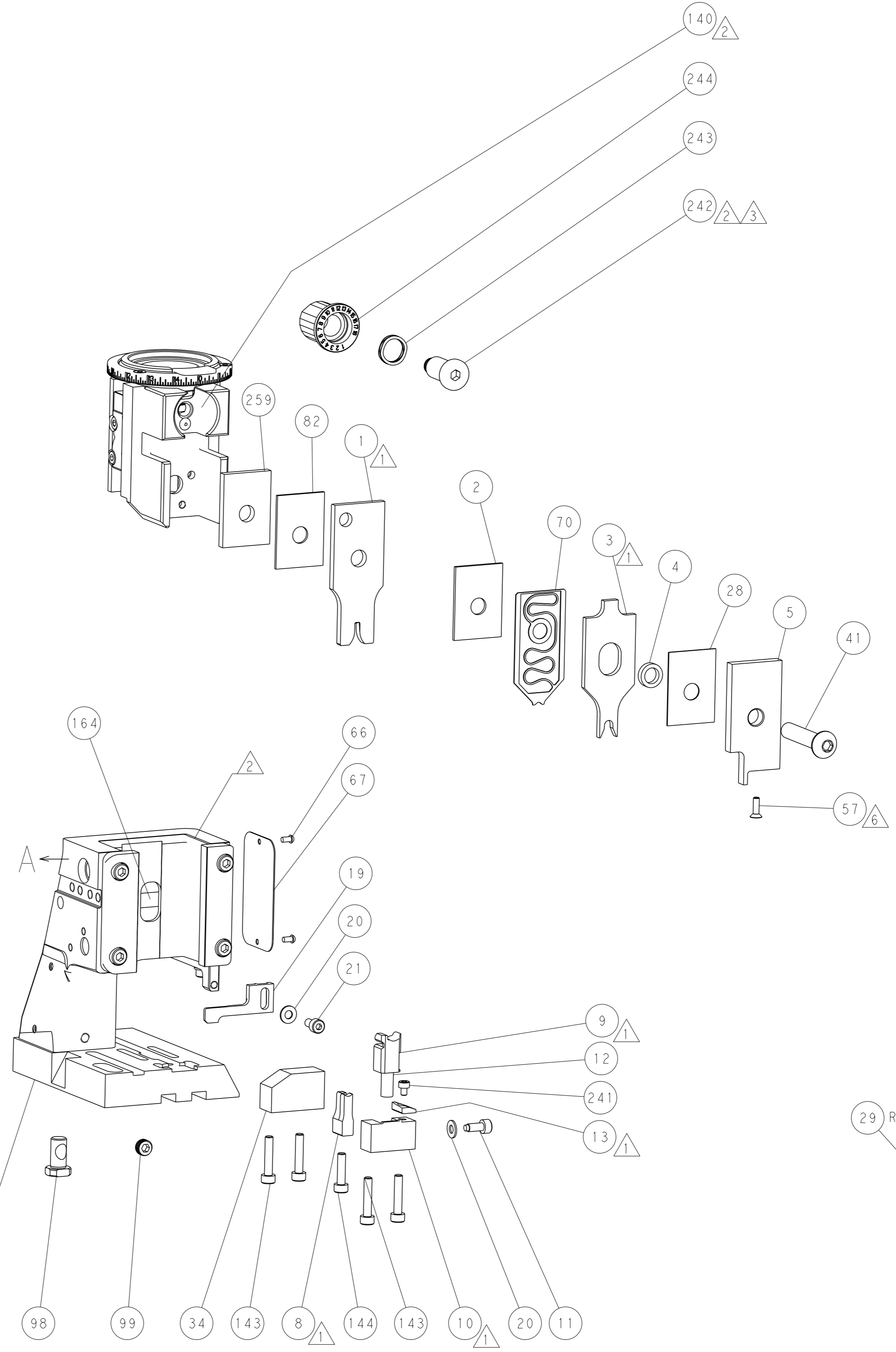
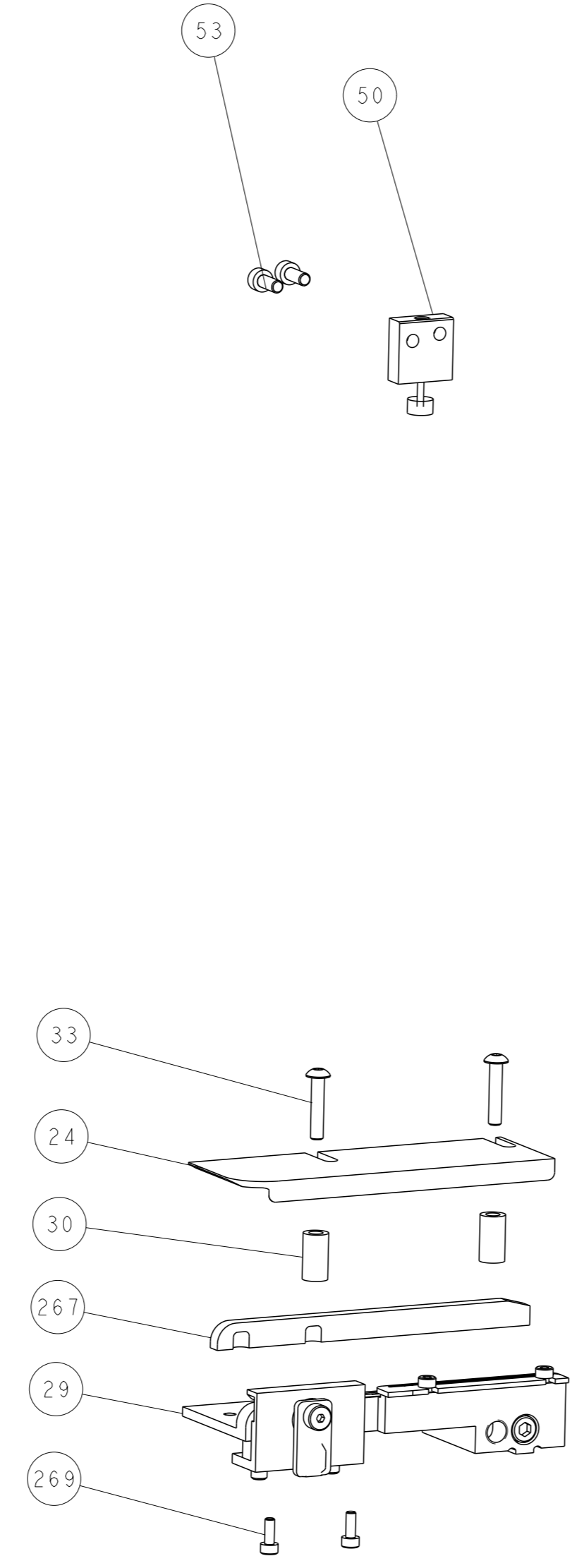
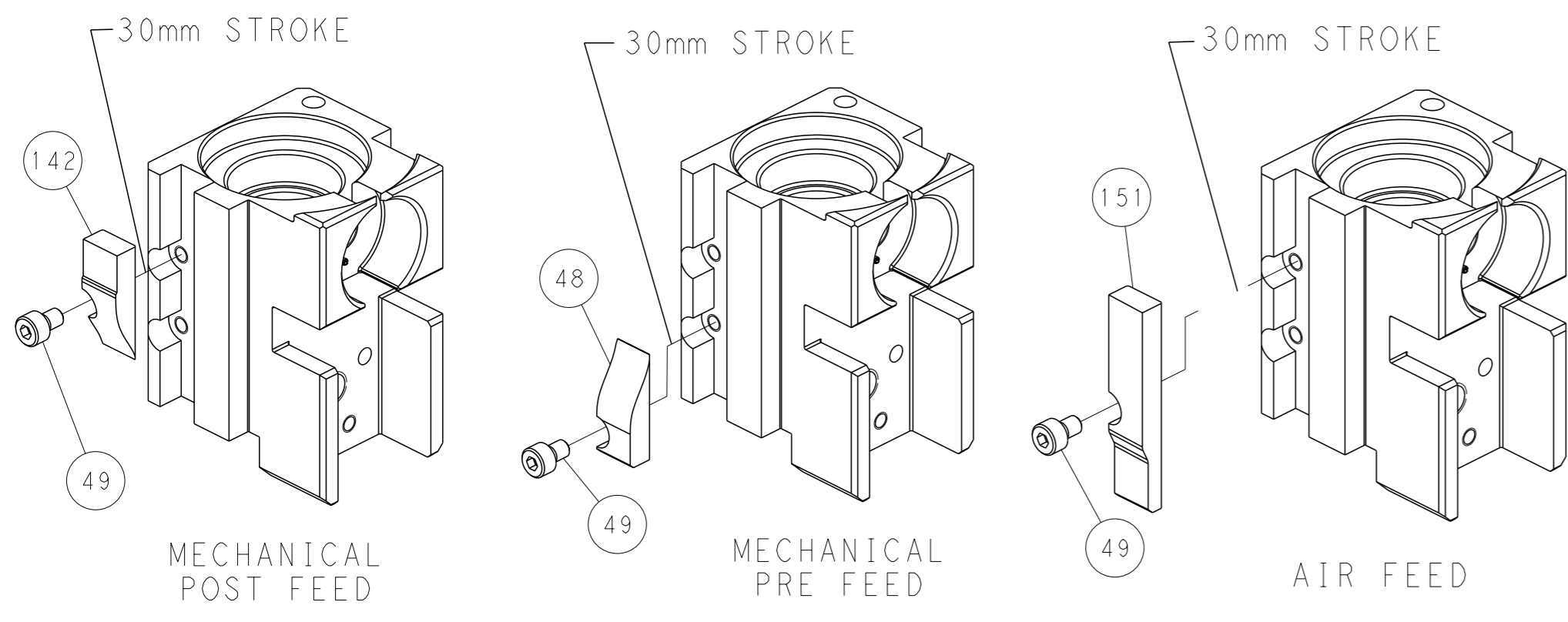
## PNEUMATIC



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



# CAM POSITIONS



**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 CONTROLLING ENGINEERING ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST REVISION.</small>		OWN: H. HUANG 22AUG2018 CHK: L. ZHANG 22AUG2018 APVD: L. ZHANG 22AUG2018	NAME: TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH ±	APPLICATION SPEC: - WEIGHT: - SCALE: 1:2	SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2837276	RESTRICTED TO: - SHEET 4 OF 4 REV B
MATERIAL: -		Customer Accessible Production Drawing	