

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2837521-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2837521-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2837521-1	B	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2837521-2	B	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2837521-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.40 mm [0.055]	F
INSUL	-	-

APPLICATOR INSTRUCTIONS
408-35042

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION			
TERMINAL NAME: CENTER CONTACT, 180 DEGREE, FAKRA			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
2.86-3.36 mm [0.113-.132 IN]		Ø1.49-1.65 mm [0.059-.065 IN]	
TERMINAL APPLICATION SPECIFICATION	114-32145		
	(B)114-32217		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
(A) 2203260-9	(A) 1-2203260-0	(A) 1-2203260-5	(A) 2203270-9
(A) 1-2203270-0	(A) 1-2203270-5	(A) 1-2203260-9	(A) 1-2203270-9
(B) 1-2304634-0			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
RG-58LL	0.96 +/- 0.03 [0.038 +/- 0.001]	7.5
RG-58	0.96 +/- 0.03 [0.038 +/- 0.001]	7.5
AMC-4 mm	0.94 +/- 0.03 [0.037 +/- 0.001]	7.7

- RECOMMENDED SPARE PARTS
- REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- 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.
- THIS APPLICATOR IS DESIGNED FOR BENCH APPLICATIONS. THIS TERMINAL CANNOT RUN ON AUTOMATED EQUIPMENT.
- TERMINAL LUBRICANT IS RECOMMENDED.
- 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.

FOR BENCH APPLICATION ONLY

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

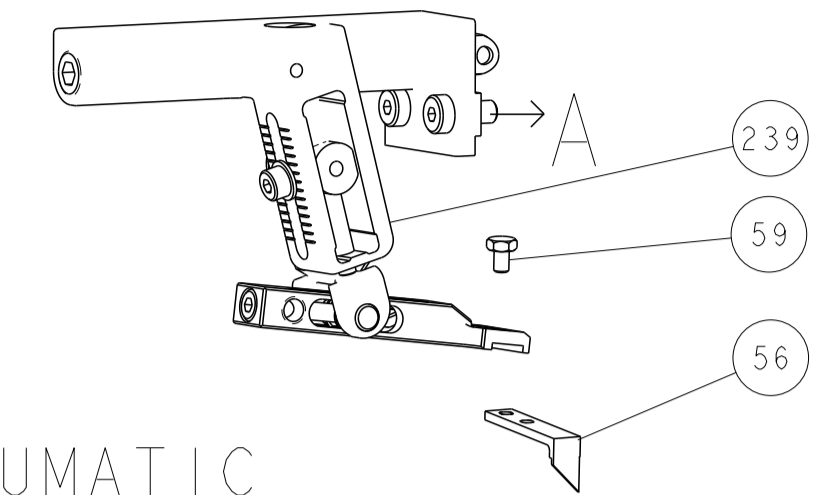
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		A1		ECR-20-005928	23APR2020	FZ	GB
		B		ECR-21-112950	07SEP2021	TB	RK

-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248		
-	-	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	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113	
-	1	1	1	1	2844908-1	SCREW, LOCKING	99		
-	1	1	1	1	2844907-1	POST, LOCKING	98		
-	1	1	1	1	455888-2	SPACER, CRIMPER	82		
-	1	1	1	1	5-547505-2	SPRING, COMPRESSION	77		
-	1	1	1	1	854769-4	HOLDER, INS	74		
-	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	21028-2	PIN, SLOTTED SPRING .062 X .250	58		
-	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	5018030-1	NUT, HEX, REG, RoHS, M3	52		
-	1	1	1	1	811242-5	BUMPER, HOLD DOWN	51		
-	1	1	1	1	690753-6	SPACER, TONKER	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	4-1752356-3	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	1-455888-9	SPACER, CRIMPER	28		
-	1	1	1	1	1320928-2	STRIP GUIDE	24		
-	1	1	1	1	3-22280-3	SPRING, COMPRESSION	12		
-	1	1	1	1	356885-5	STOP, SHEAR	11		
	-	1	1	1	1552193-1	HOLDER, SHEAR	10		
	-	1	1	1	1-1338293-2	SHEAR, FLOATING	9		
	1	2	2	1	1	2-1633933-0	ANVIL, COMBINATION	8	
-	-	-	-	-	-	-	7		
-	-	-	-	-	-	-	6		
-	1	1	1	1	1803349-2	DEPRESSOR, SHEAR	5		
-	-	-	-	-	-	-	4		
-	-	-	-	-	-	-	3		
-	-	-	-	-	-	-	2		
	1	2	2	1	1	1803087-3	CRIMPER, WIRE	1	
-	77	72	71	2	-	1	PART NO	DESCRIPTION	ITEM NO

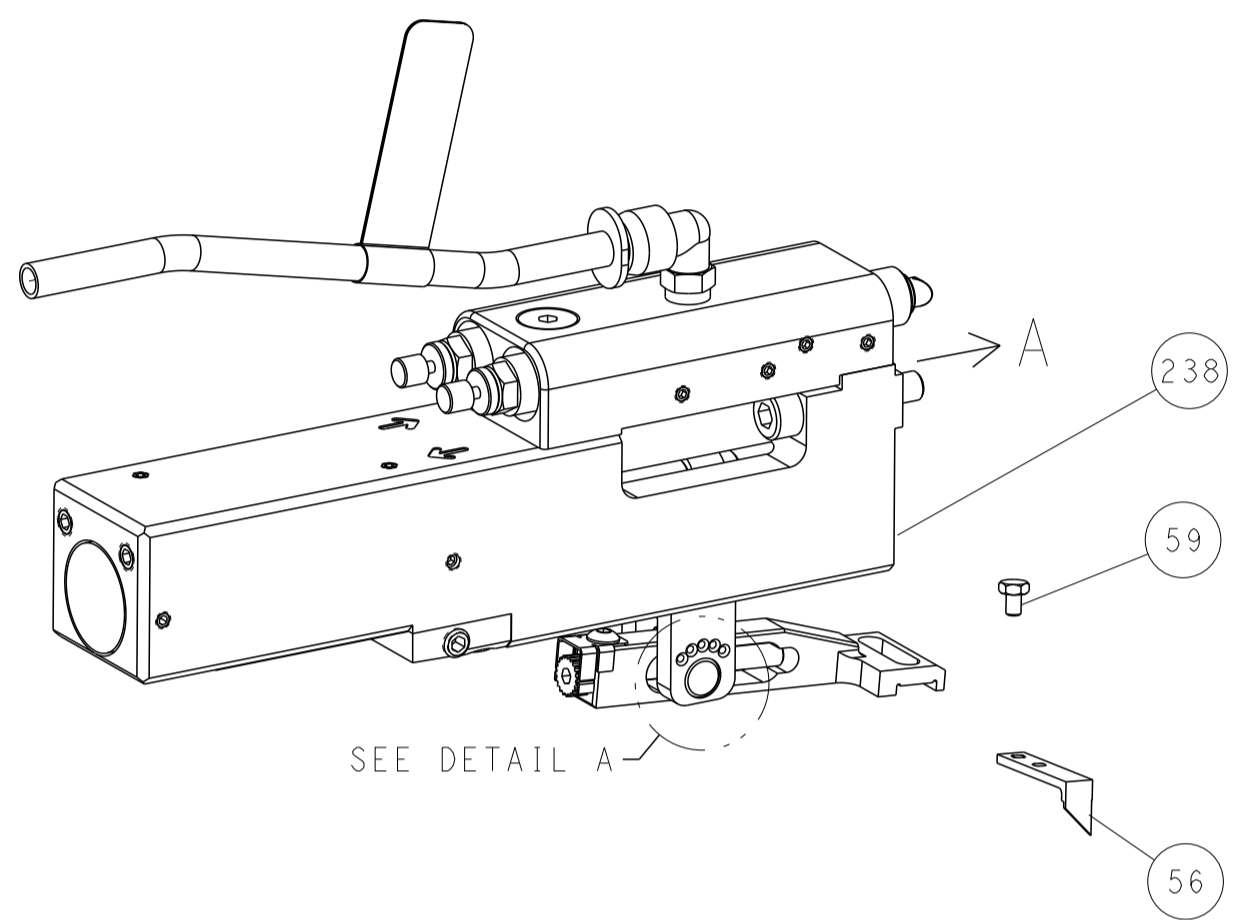
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mm	0 PLC ±	1 PLC ±	2 PLC ±	CHK F. LIANG 28FEB2019	
	3 PLC ±	4 PLC ±	ANGLES ±	APVD S. JIO 28FEB2019	NAME Ocean Side Feed Applicator
MATERIAL	FINISH	WEIGHT	SCALE	SIZE CAGE CODE DRAWING NO	RESTRICTED TO
-	-	-	1:2	A1 00779 C=2837521	-
Customer Accessible Production Drawing				SHEET 1 OF 4	REV B

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

FEED TYPE MECHANICAL



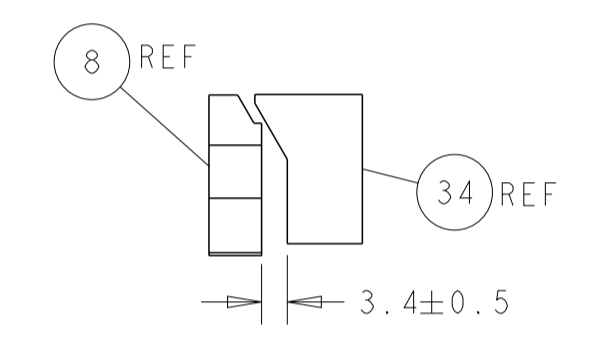
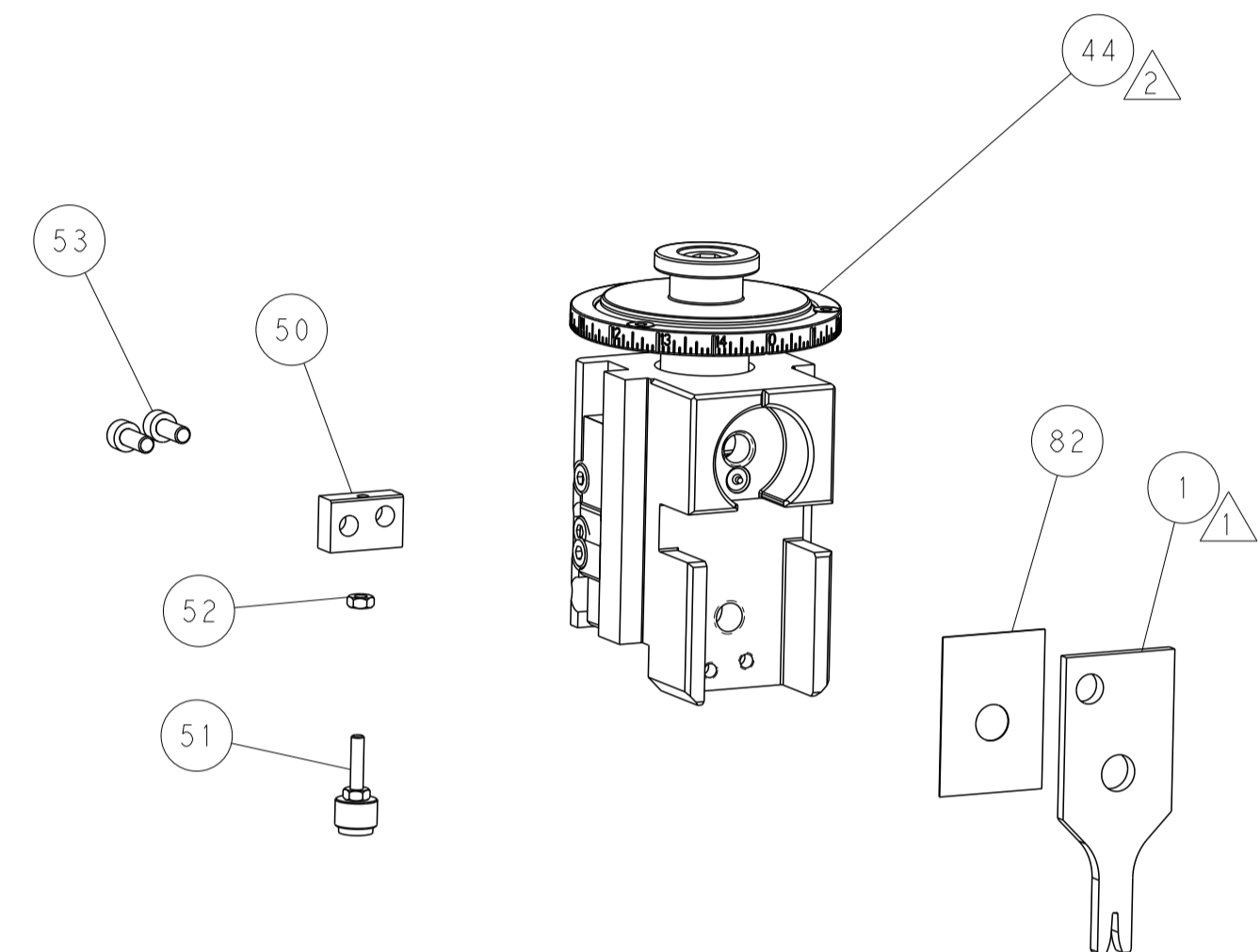
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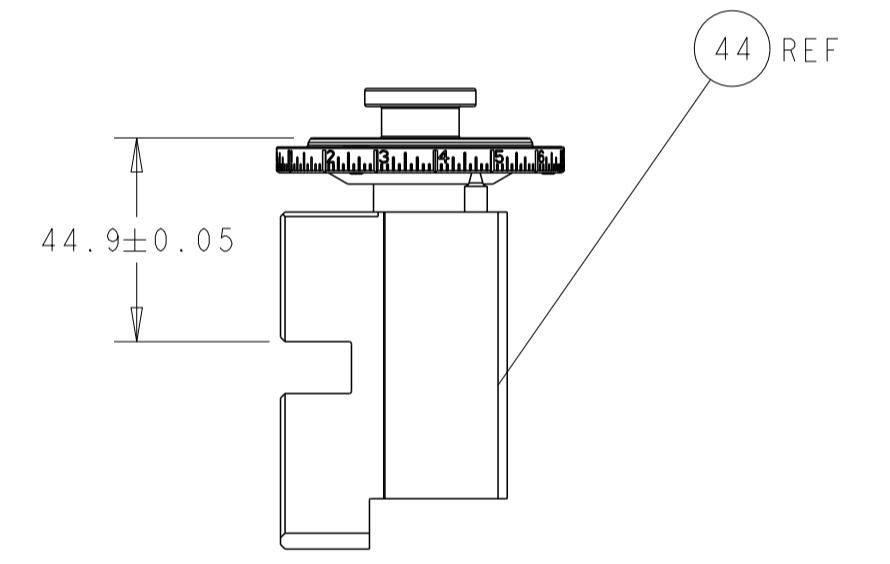
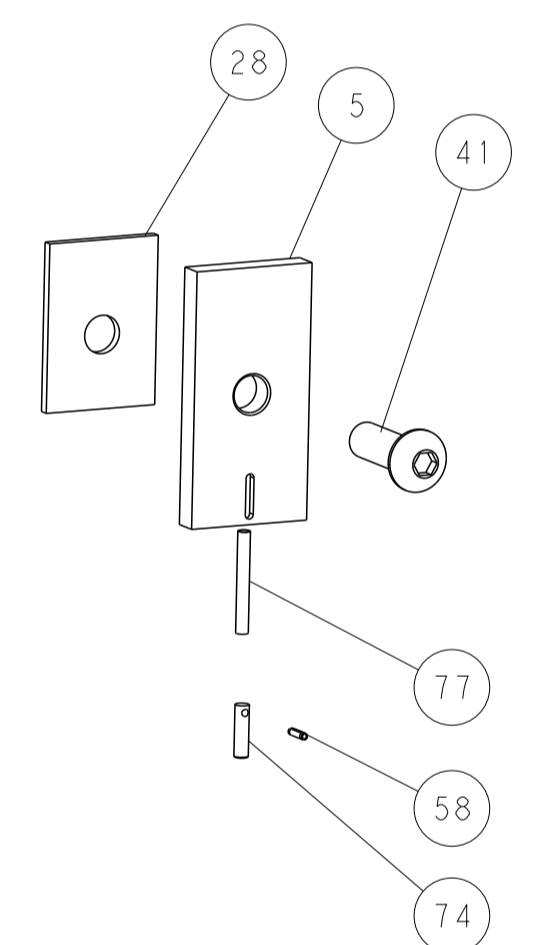
FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



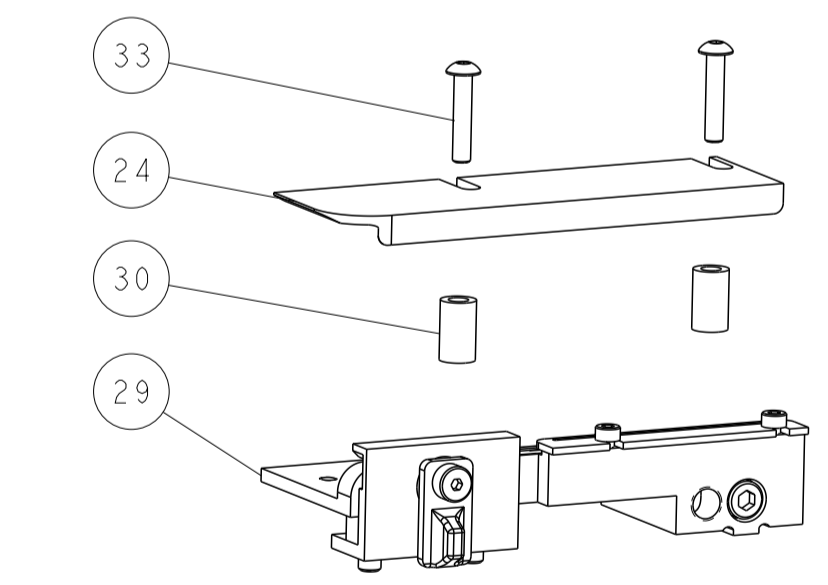
DETAIL A



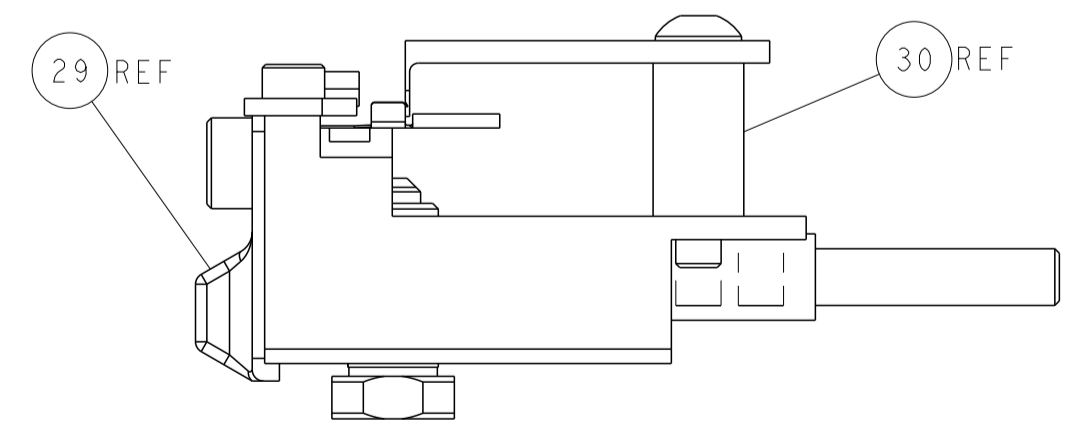
TERMINAL SUPPORT LOCATION



RAM SET-UP

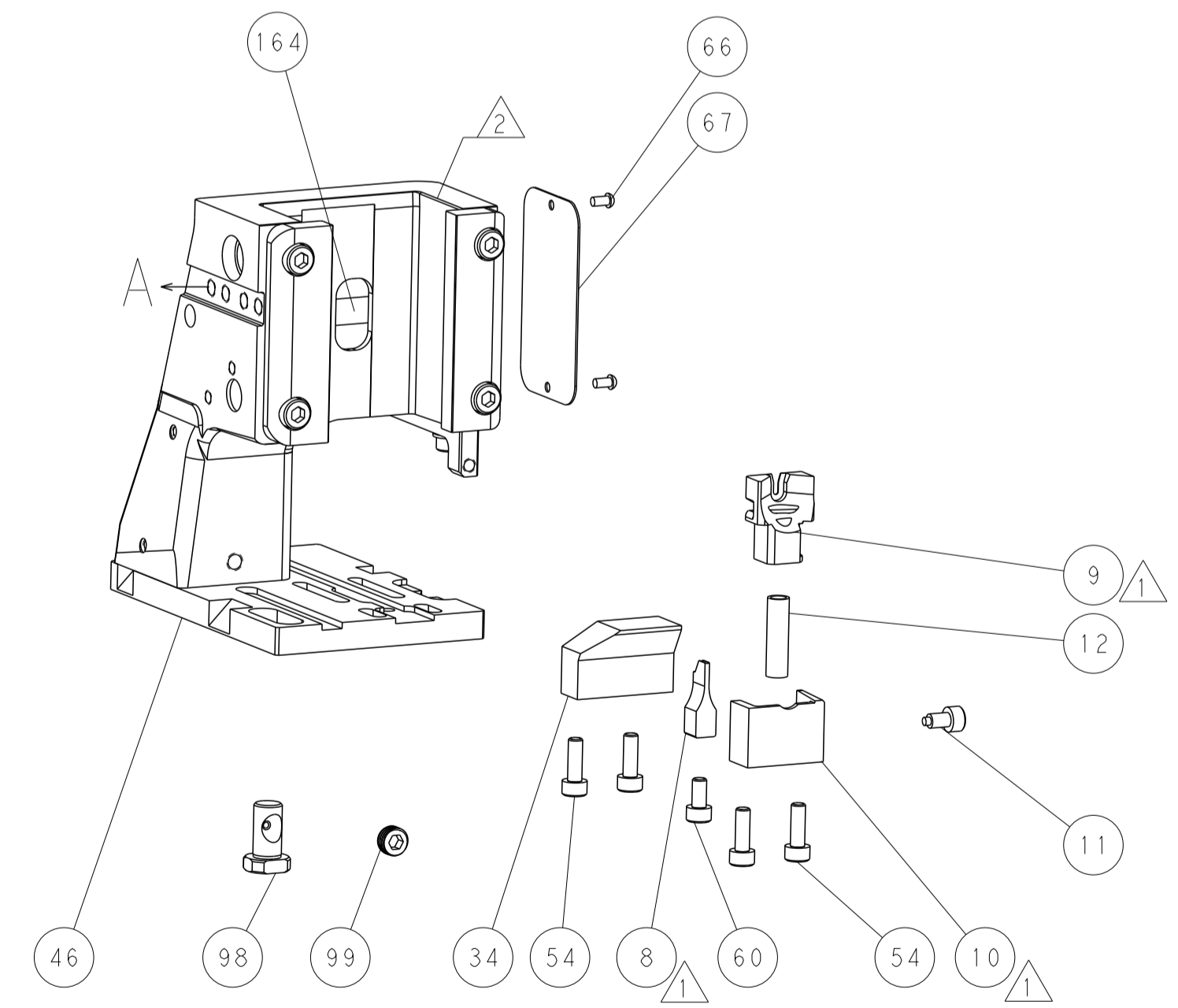
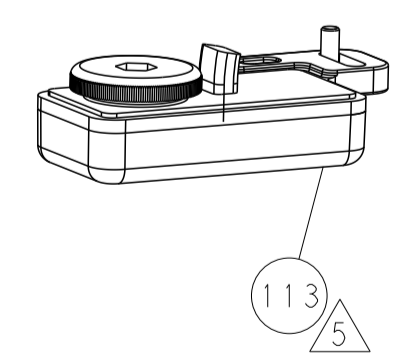
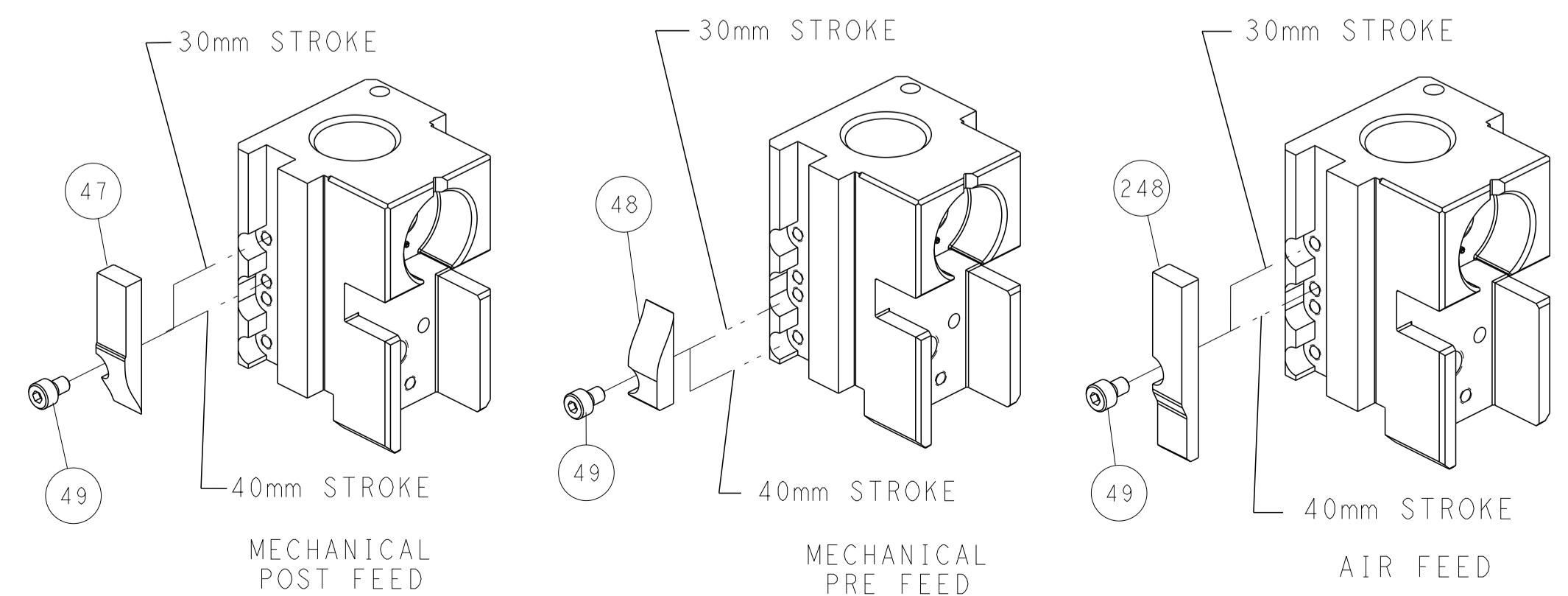


ITEM 30 LOCATED AT FRONT HOLES



FEED TRACK POSITION GUIDE BY WIRE 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 J. FENG 28FEB2019 CHK F. LIANG 28FEB2019 APVD S. JIANG 28FEB2019	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 PRODUCT SPEC APPLICATION SPEC SIZE CAGE CODE DRAWING NO. A1 00779 C=2837521 WEIGHT Customer Accessible Production Drawing	RESTRICTED TO SCALE 1:2 SHEET 2 OF 4 REV B

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2837521-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2837521-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2837521-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
 INTERFACE ADAPTER



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

APPLICATOR INSTRUCTIONS
 408-35042

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: CENTER CONTACT, 180 DEGREE, FAKRA			
WIRE STRIP LENGTH 2.86-3.36 mm [1.13-1.32 IN]		INSULATION DIAMETER RANGE Ø1.49-1.65 mm [1.059-.065 IN]	
TERMINAL APPLICATION SPECIFICATION	114-32145	-	-
	(B)114-32217	-	-
TERMINALS APPLIED $\triangle 4/5$			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
(A) 2203260-9	(A) 1-2203260-0	(A) 1-2203260-5	(A) 2203270-9
(A) 1-2203270-0	(A) 1-2203270-5	(A) 1-2203260-9	(A) 1-2203270-9
(B) 1-2304634-0			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
RG-58LL	0.96 +/- 0.03 [1.038 +/- .001]	7.5
RG-58	0.96 +/- 0.03 [1.038 +/- .001]	7.5
AMC-4 mm	0.94 +/- 0.03 [1.037 +/- .001]	7.7

- $\triangle 1$ RECOMMENDED SPARE PARTS
 - $\triangle 2$ REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
 - $\triangle 3$ 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.
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 - $\triangle 5$ TERMINAL LUBRICANT IS RECOMMENDED.
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.

FOR BENCH APPLICATION ONLY

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

-	-	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
$\triangle 5$	-	1	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113
-	1	1	2844908-1	SCREW, LOCKING	99
-	1	1	2844907-1	POST, LOCKING	98
-	1	1	455888-2	SPACER, CRIMPER	82
-	1	1	5-547505-2	SPRING, COMPRESSION	77
-	1	1	854769-4	HOLDER, INS	74
-	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	21028-2	PIN, SLOTTED SPRING .062 X .250	58
-	1	1	1338685-1	PAWL, FEED	56
-	2	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	53
-	1	1	5018030-1	NUT, HEX, REG, RoHS, M3	52
-	1	1	811242-5	BUMPER, HOLD DOWN	51
-	1	1	690753-6	SPACER, TONKER	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	4-1752356-3	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	2844992-1	ASSEMBLY, STRIP GUIDE	29
-	1	1	1-455888-9	SPACER, CRIMPER	28
-	1	1	1320928-2	STRIP GUIDE	24
-	1	1	3-22280-3	SPRING, COMPRESSION	12
-	1	1	356885-5	STOP, SHEAR	11
$\triangle 1$	-	1	1552193-1	HOLDER, SHEAR	10
$\triangle 1$	-	1	1-1338293-2	SHEAR, FLOATING	9
$\triangle 1$	1	1	1-1633933-0	ANVIL, COMBINATION	8
-	-	-	-	-	7
-	-	-	-	-	6
-	1	1	1803349-2	DEPRESSOR, SHEAR	5
-	-	-	-	-	4
-	-	-	-	-	3
-	-	-	-	-	2
$\triangle 1$	1	1	1803087-3	CRIMPER, WIRE	1

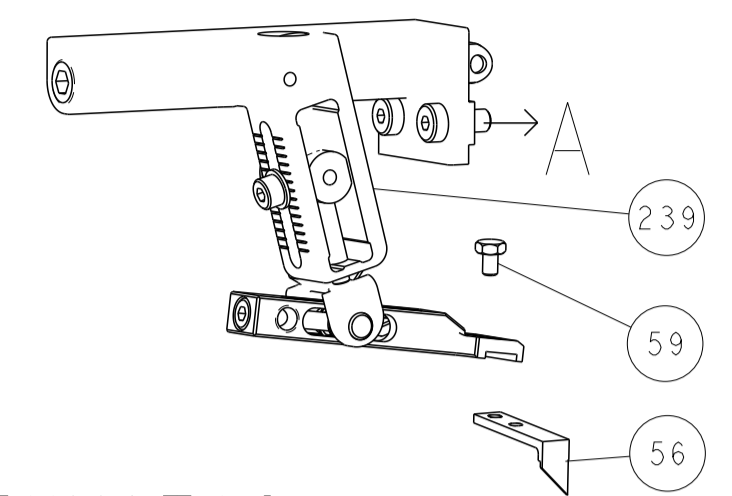
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mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES	FINISH			1:2	SHEET 3 OF 4

ITEM NO	PART NO	DESCRIPTION
-77	-22	-21

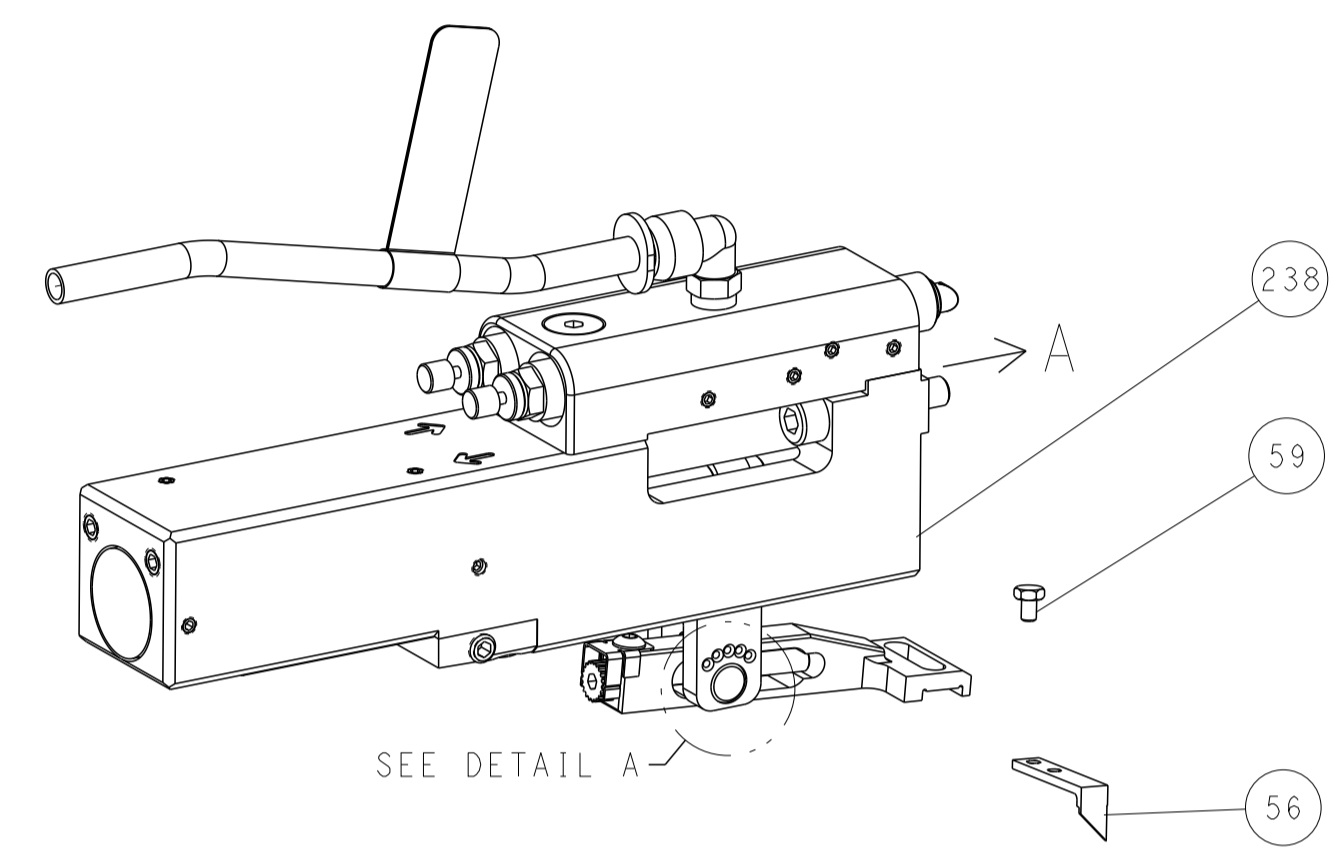
OWN: J. FENG	28FEB2019	TE Connectivity
CHK: F. LIANG	28FEB2019	Harrisburg, PA 17105-3608
APVD: S. JIO	28FEB2019	
NAME:	Ocean Side Feed Applicator	
SIZE:	CAGE CODE:	DRAWING NO:
A1	00779	C=2837521
Customer Accessible Production Drawing		

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

FEED TYPE MECHANICAL



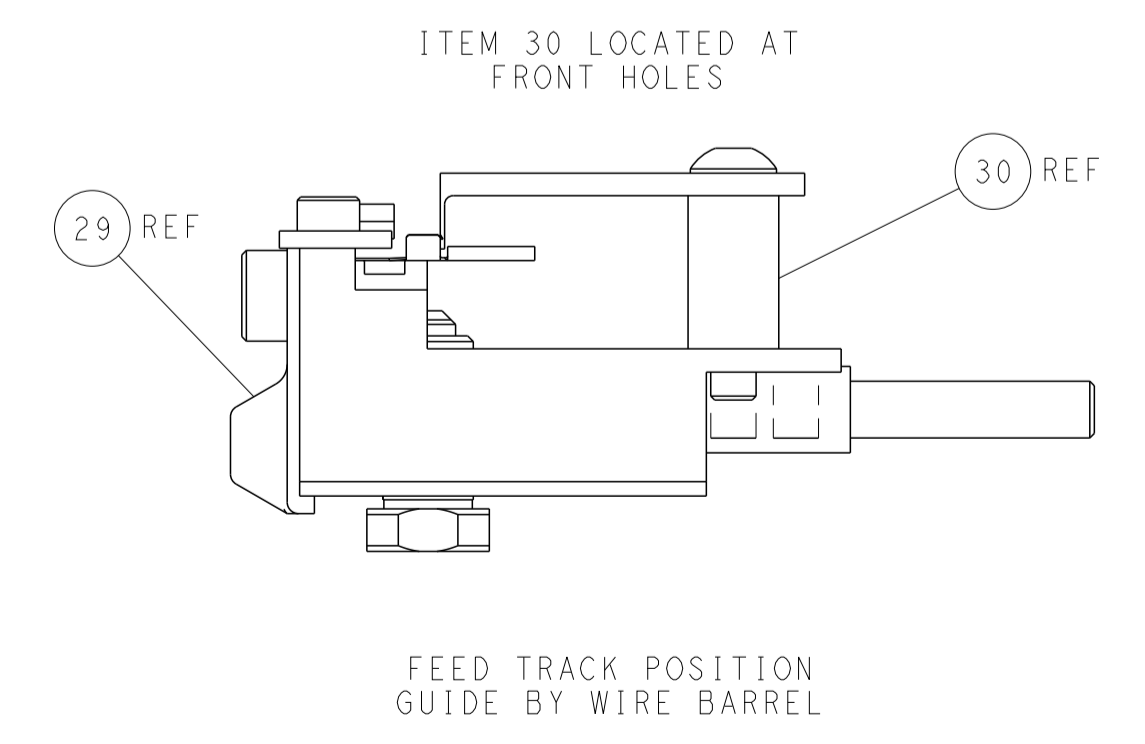
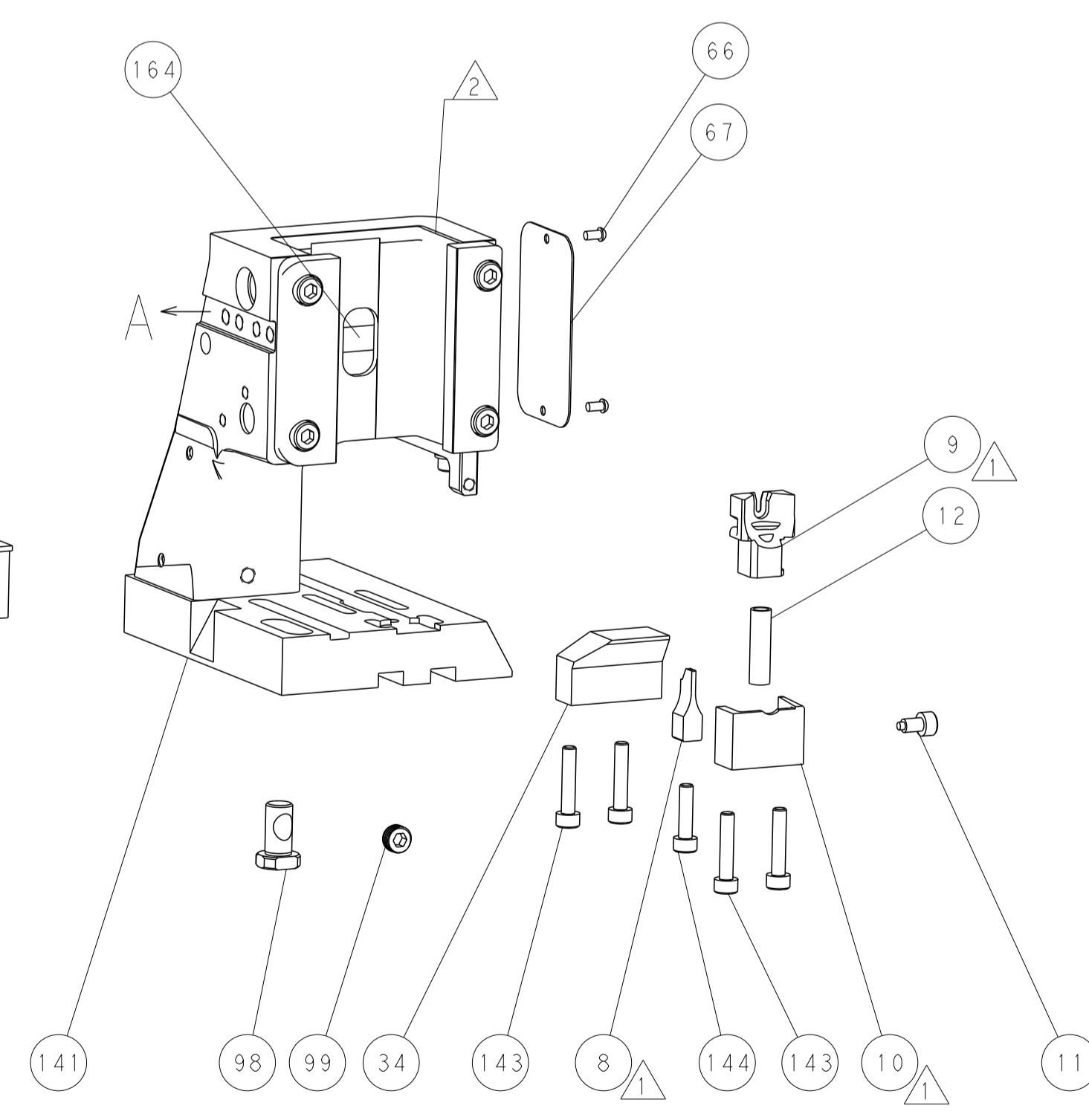
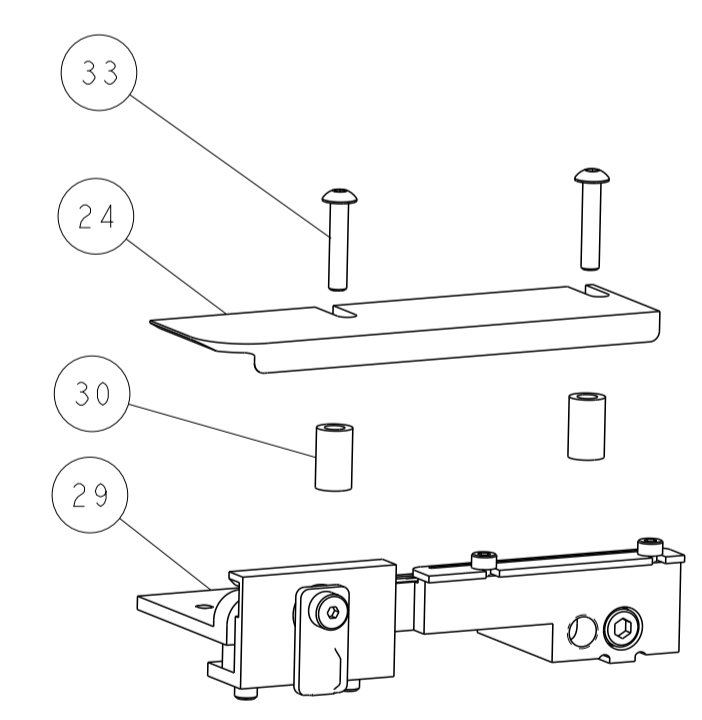
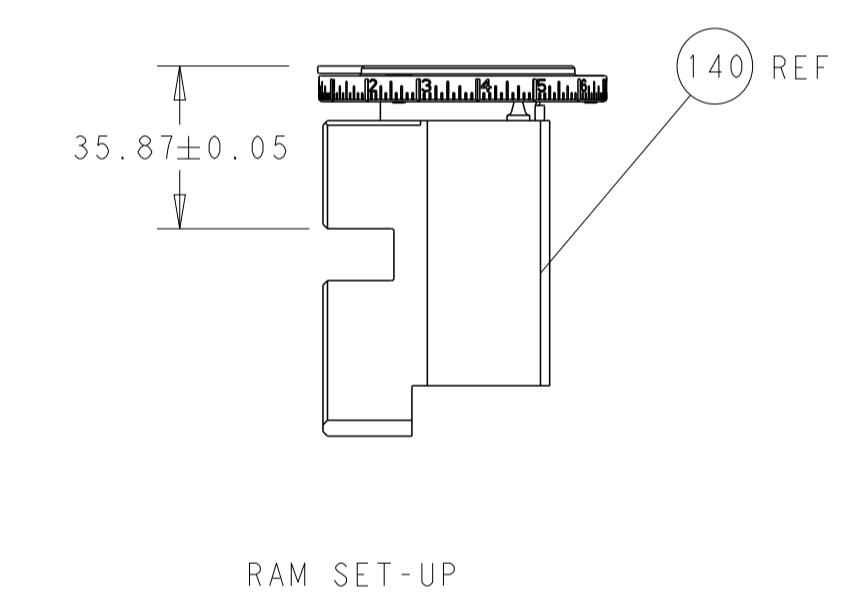
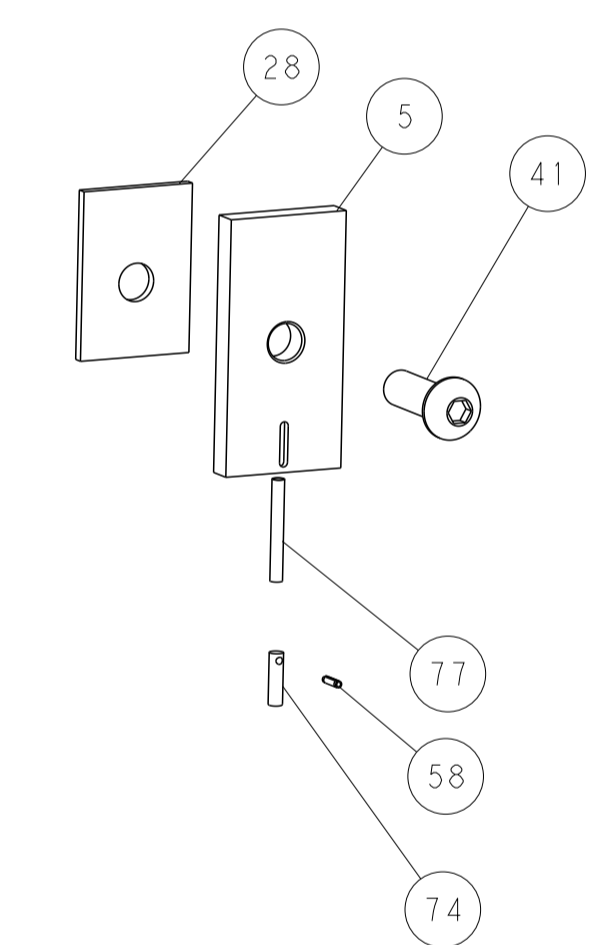
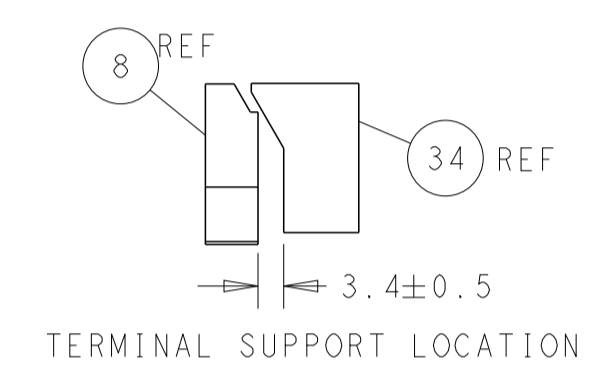
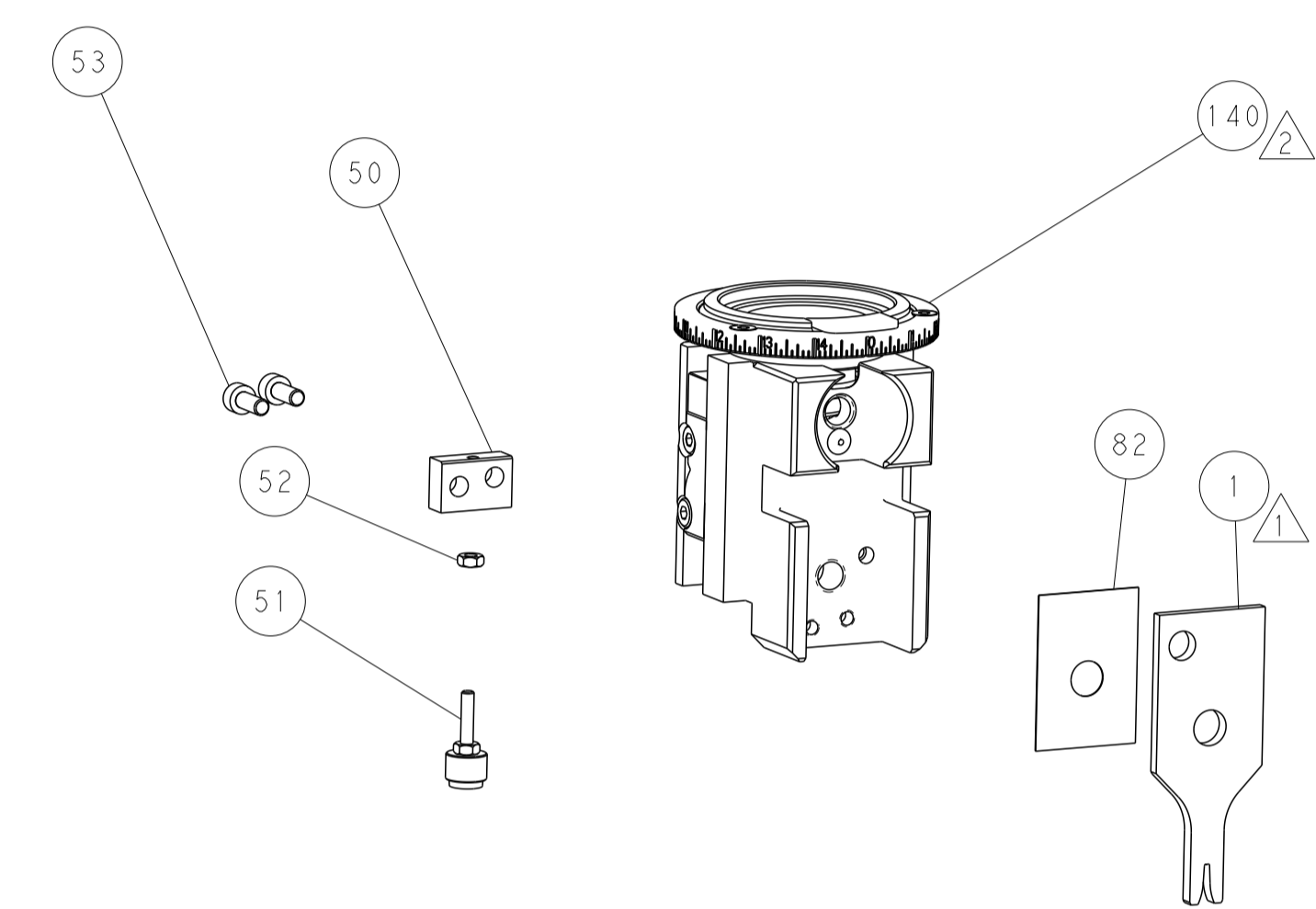
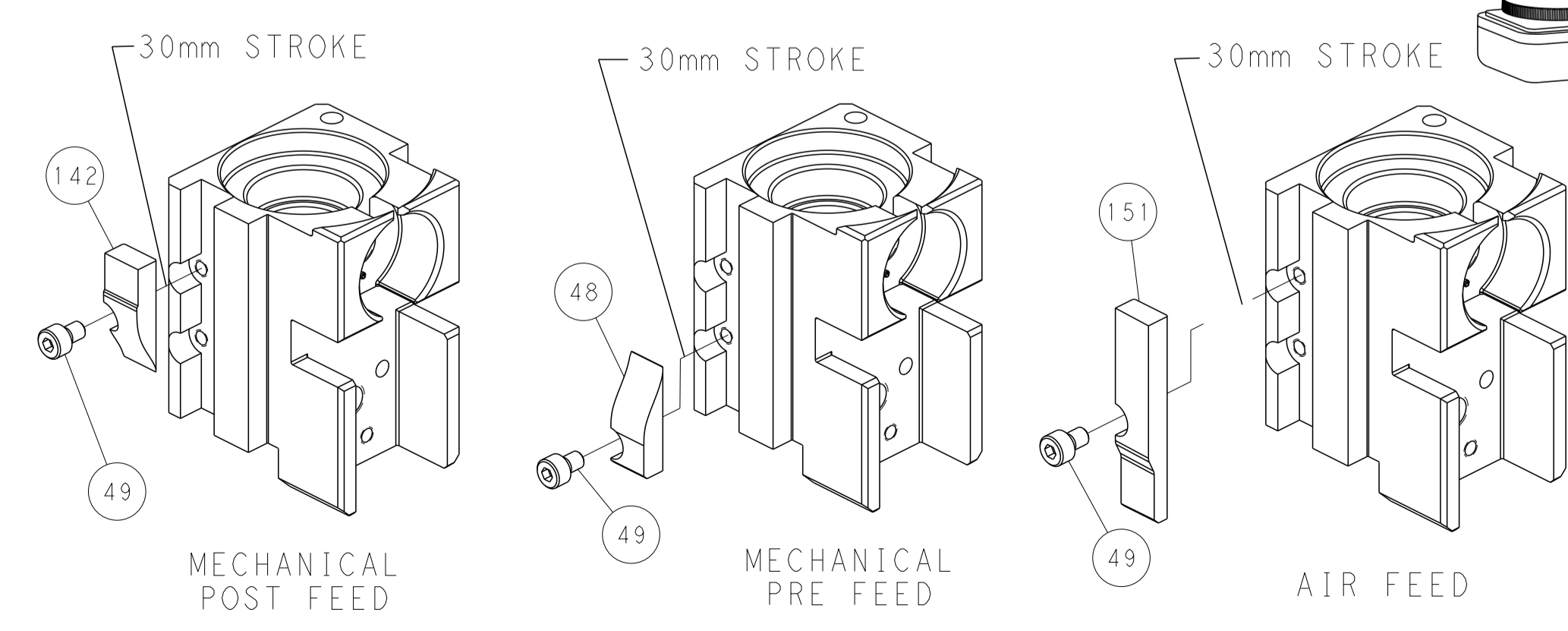
PNEUMATIC



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)

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DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH ±		NAME Ocean Side Feed Applicator APPLICATION SPEC PRODUCT SPEC SIZE CAGE CODE DRAWING NO. A1 00779 C=2837521 WEIGHT MATERIAL	RESTRICTED TO SCALE 1:2 SHEET 4 OF 4 REV B