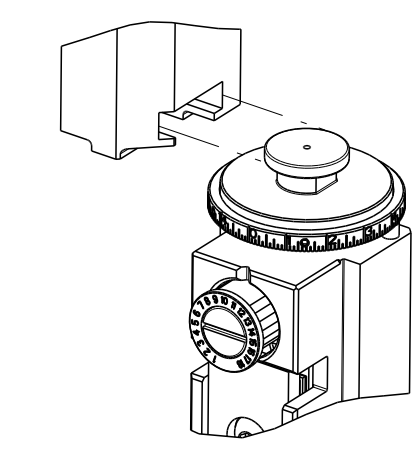


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2837157-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2837157-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2837157-1	C	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2837157-2	C	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2837157-7	C	CRIMP TOOLING KIT	-

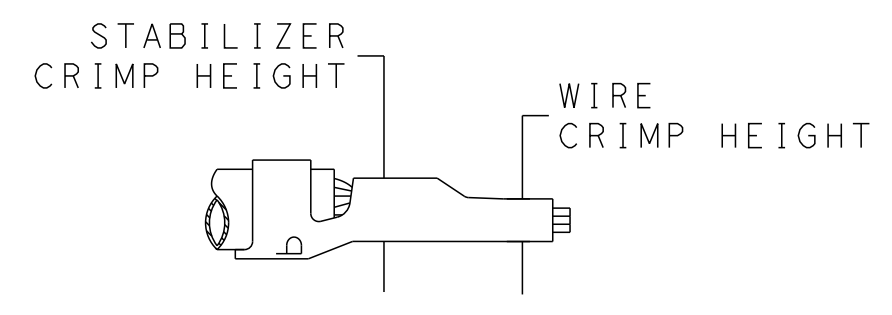
ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



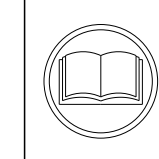
APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.79 mm [.110]	F
STAB	2.79 mm [.110]	O
INSUL	3.94 mm [.155]	O

APPLICATOR INSTRUCTIONS  
408-35042

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: MINI AMP-IN 2000			
WIRE STRIP LENGTH		TERMINAL INSULATION DIAMETER RANGE	
4.83-5.59 mm [.190-.220 IN]		Ø2.29-3.81 mm [.090-.150 IN]	
TERMINAL APPLICATION SPECIFICATION	114-1016		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
3-647334-1			



WIRE SIZE	CRIMP HEIGHT mm [INCH]	WIRE CRIMPER PART NUMBER	STABILIZER CRIMPER HEIGHT mm [INCH]	STABILIZER CRIMPER PART NUMBER	CRIMP HEIGHT REFERENCE SETTING
14 AWG	1.40+/-0.05 [.055+/- .002]	8-456408-4	2.79+0.13/-0.00 [.110+.005/- .000]	815664-2	9.0
16 AWG	1.10+/-0.05 [.043+/- .002]	8-456408-5			8.8
18 AWG	1.10+/-0.05 [.043+/- .002]	8-456408-5			8.7



- 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 ITEM 1 TO BE USED WITH 14 AWG ONLY. ITEM TO BE SHIPPED WITH APPLICATOR.
- 7 ITEM 253 TO BE USED WITH 16 & 18 AWG ONLY. APPLICATOR TO BE SET UP WITH THIS ITEM.

**\*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	LTN	DESCRIPTION	DATE	OWN	APVD
		A		RELEASED	13APR2018	TB	TE
		B		ECR-22-127984	31JAN2022	JWC	TE
		C		ECR-22-159835	29NOV2022	JWC	TE

7	-	1	1	1	1	1803078-3	SPACER, PRECISION	259	
	-	1	1	1	1	8-456408-5	CRIMPER, WIRE PREMIUM	253	
	-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248	
	-	1	1	1	1	2119082-8	CAM, SNAIL, INSULATION ADJUSTMENT	244	
	-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243	
3	-	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	
	-	1	1	1	1	815664-2	CRIMPER, WIRE-O	178	
	-	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	1-455888-0	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	
	-	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	469465-4	STOP, WIRE	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	1320928-2	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	2119533-3	STRIPPER, SIDE FEED	19	
1	-	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	1	2119805-1	SHEAR HOLDER, FRONT	10	
1	-	1	1	1	1	1803095-1	FLOATING SHEAR, FRONT	9	
1	1	2	2	1	1	1-1803703-8	ANVIL, COMBINATION	8	
	-	-	-	-	-	-	-	7	
	-	-	-	-	-	-	-	6	
	-	1	1	1	1	1-2119757-2	DEPRESSOR, SHEAR	5	
	-	1	1	1	1	238011-4	BLOCK, CRIMPER SPACER	4	
1	1	2	2	1	1	7-1803317-0	CRIMPER, INSULATION O	3	
	-	1	1	1	1	1-455888-6	SPACER, CRIMPER	2	
6	1	1	2	2	1	1	8-456408-4	CRIMPER, WIRE PREMIUM	1

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		MATERIAL:		FINISH:		WEIGHT:		SCALE:		SHEET:		REV:	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES	FINISH			A1	00779	1:2	1	4	C

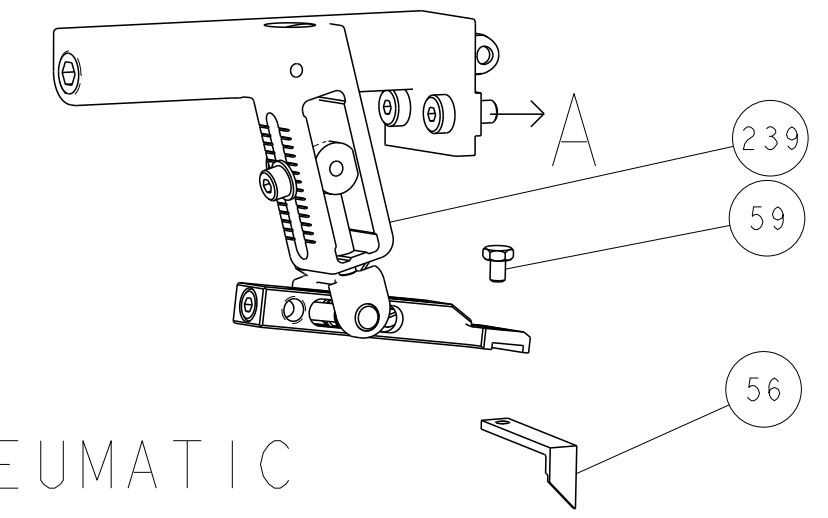


Ocean Side Feed Applicator

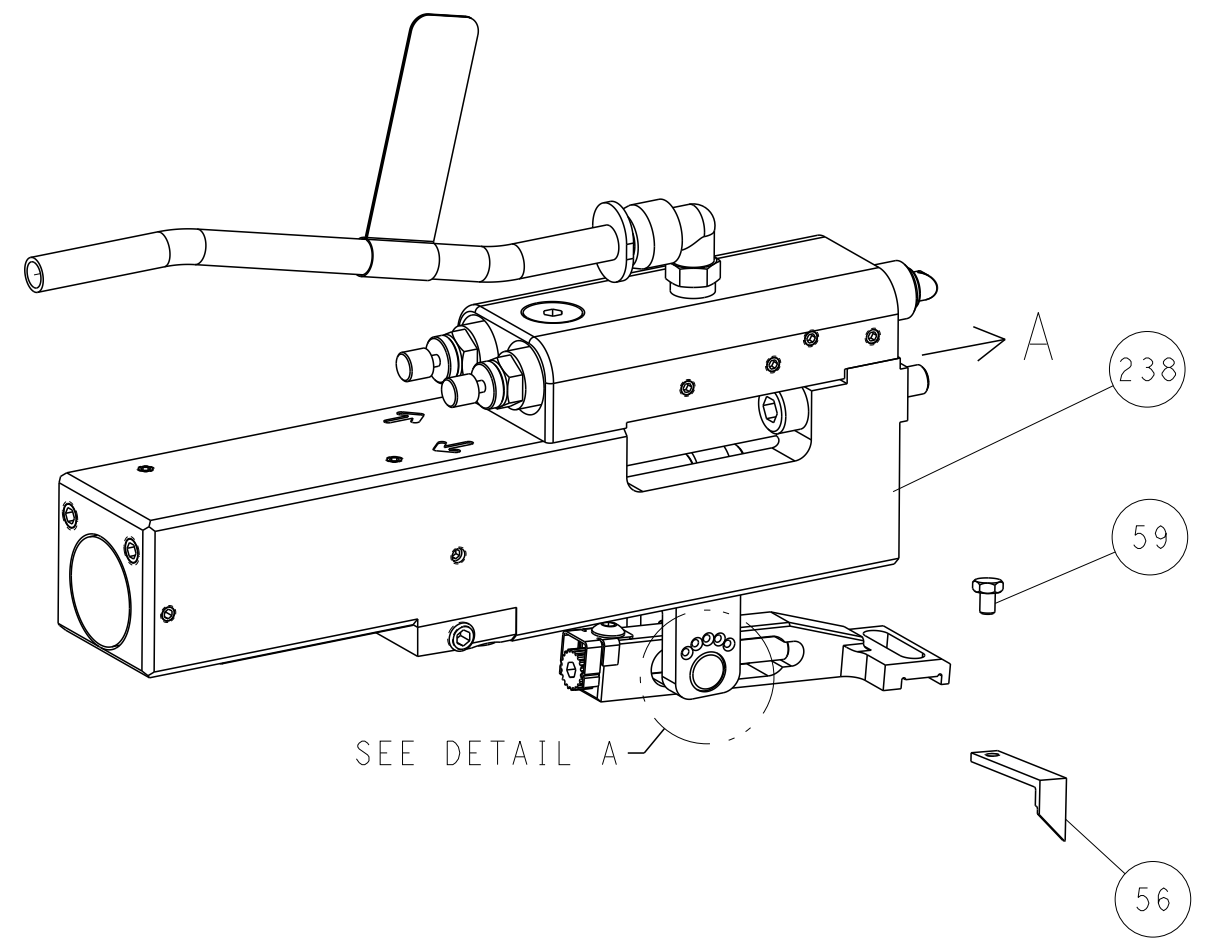
Customer Accessible Production Drawing

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

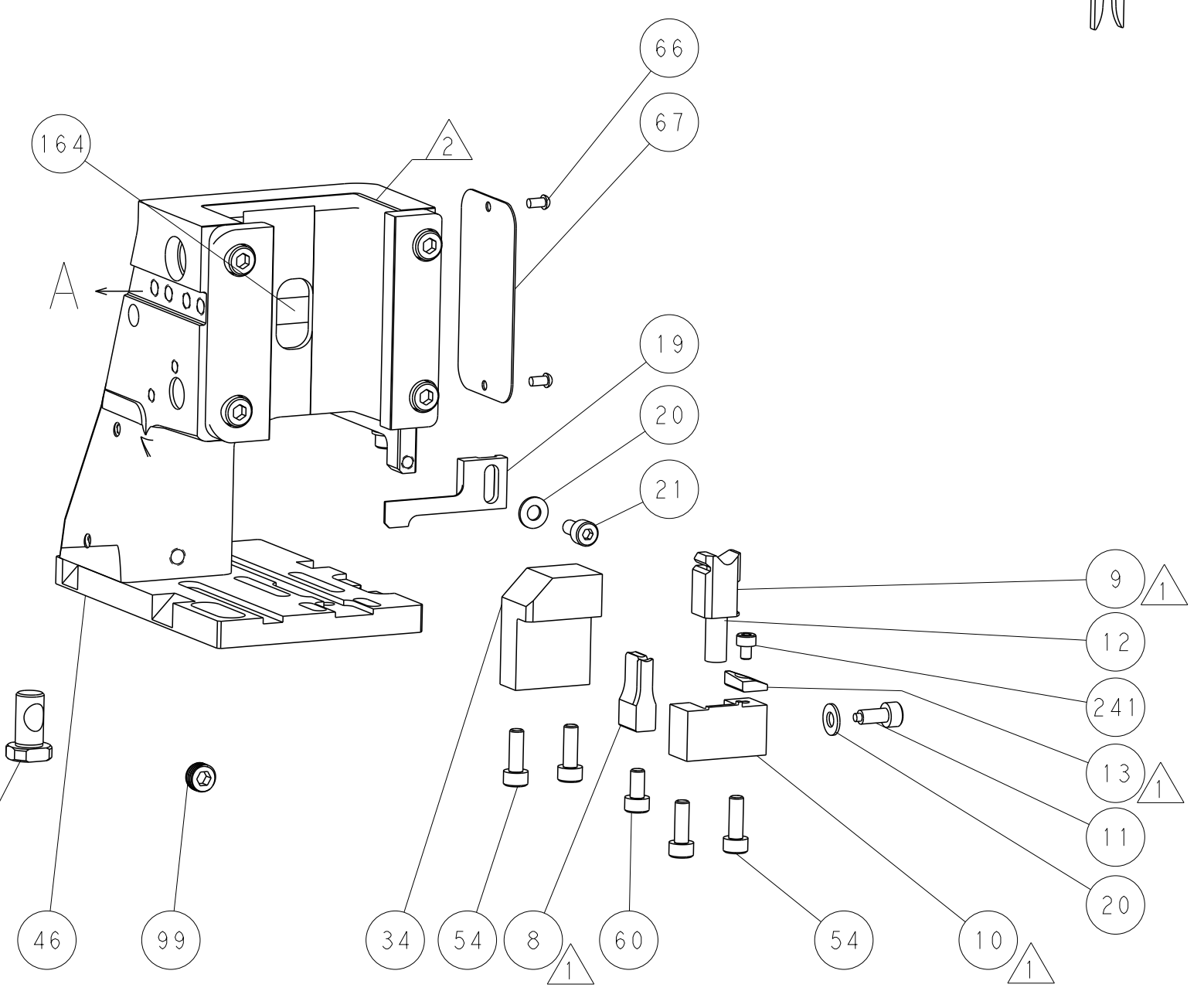
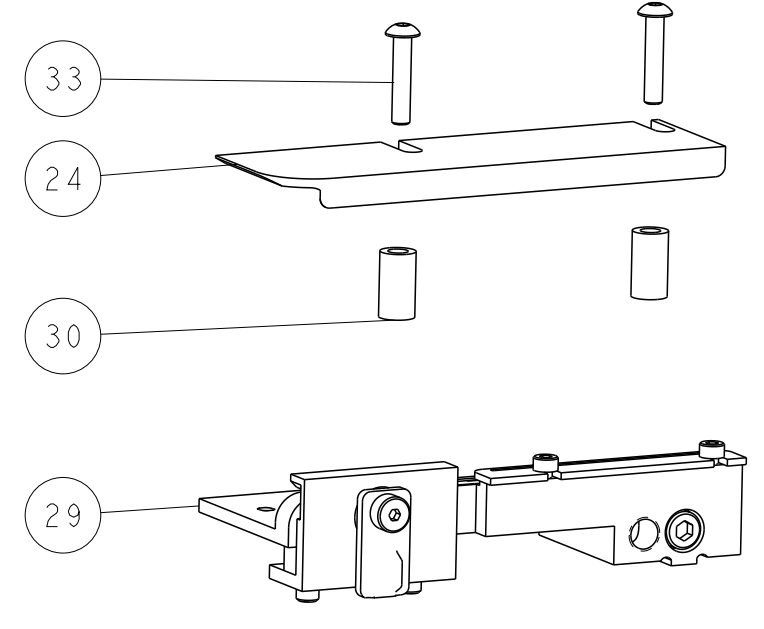
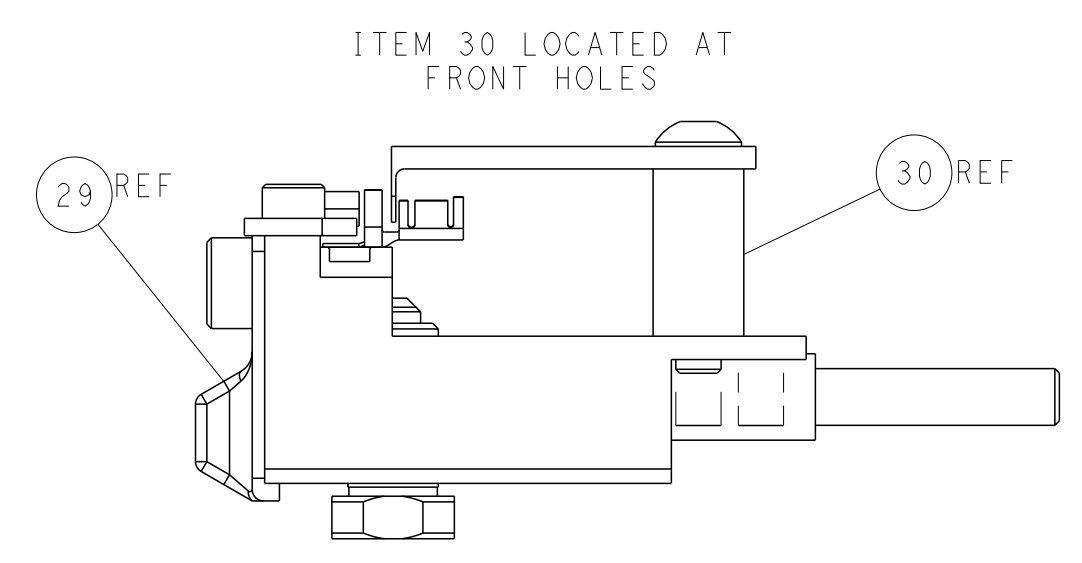
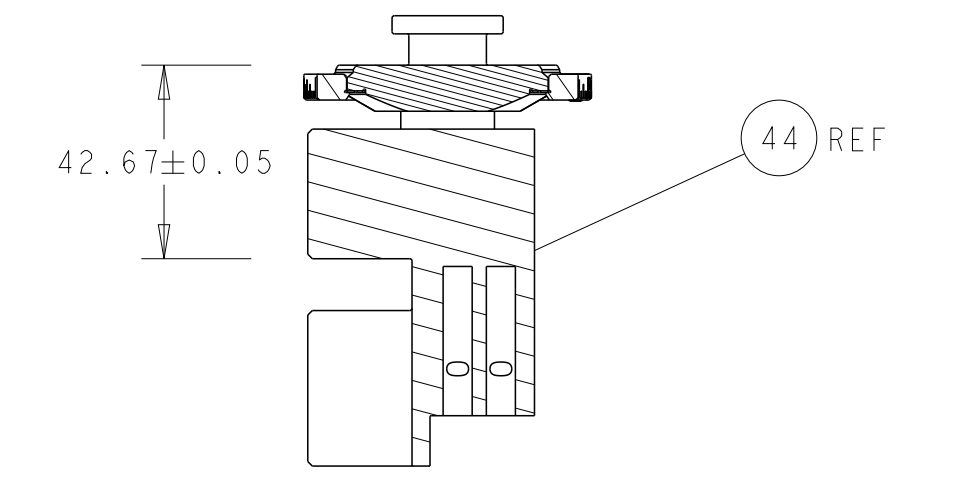
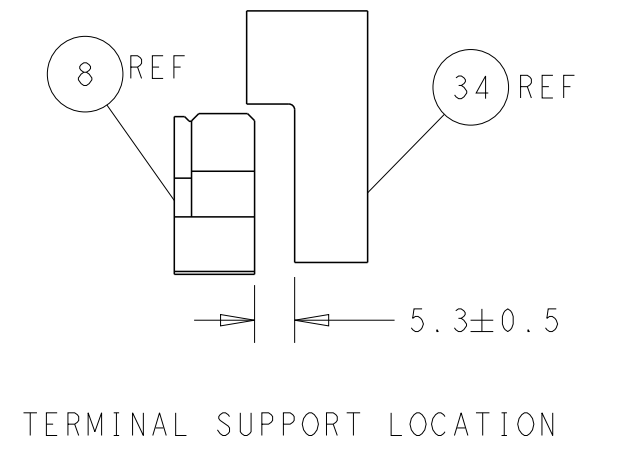
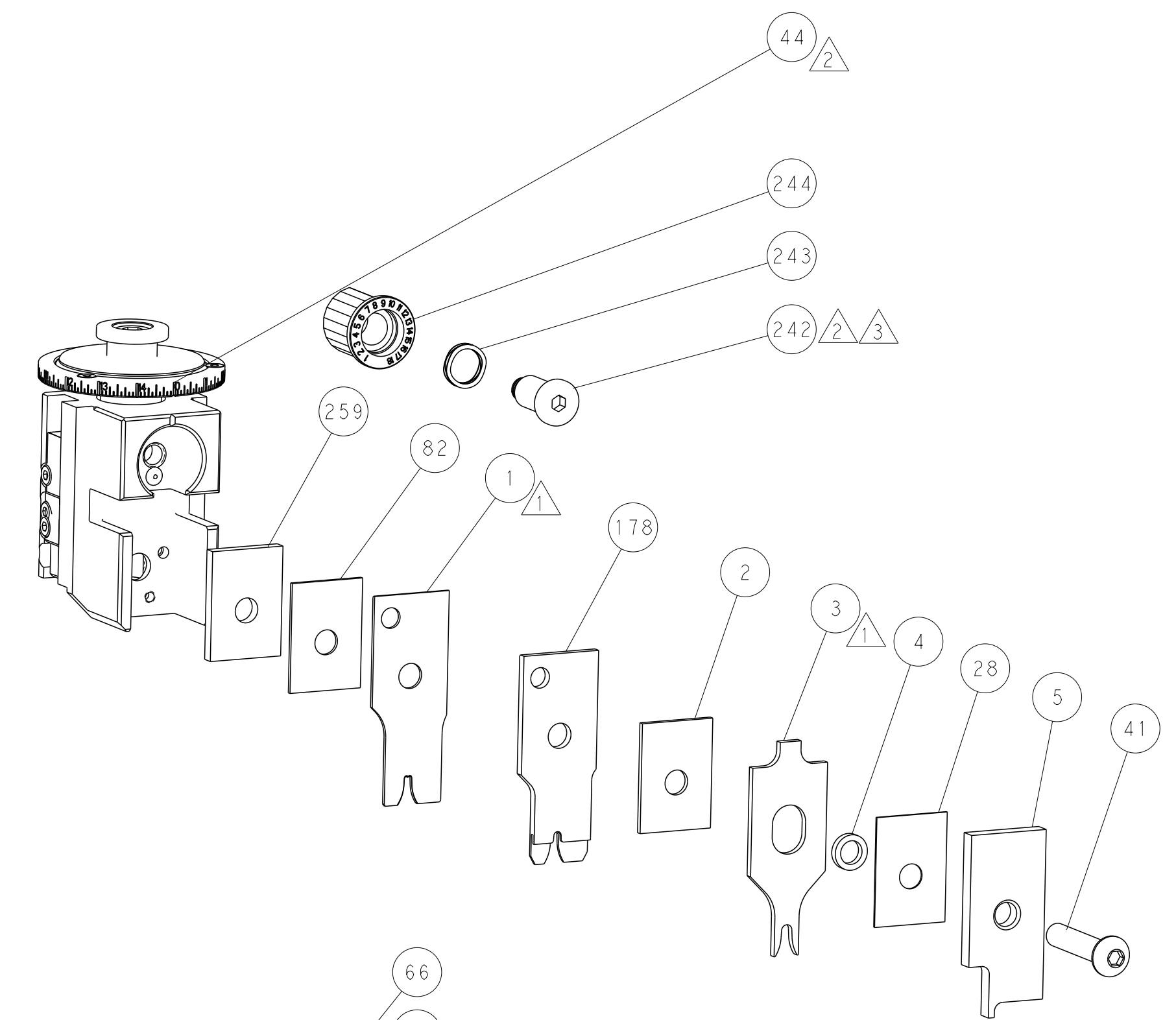
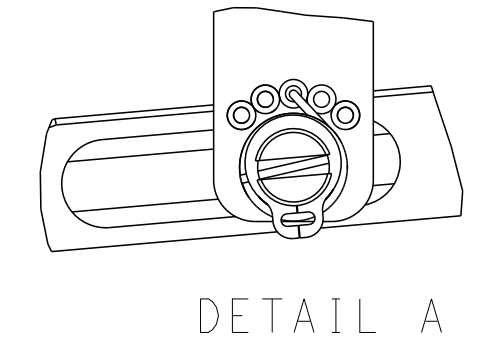
# FEED TYPE MECHANICAL



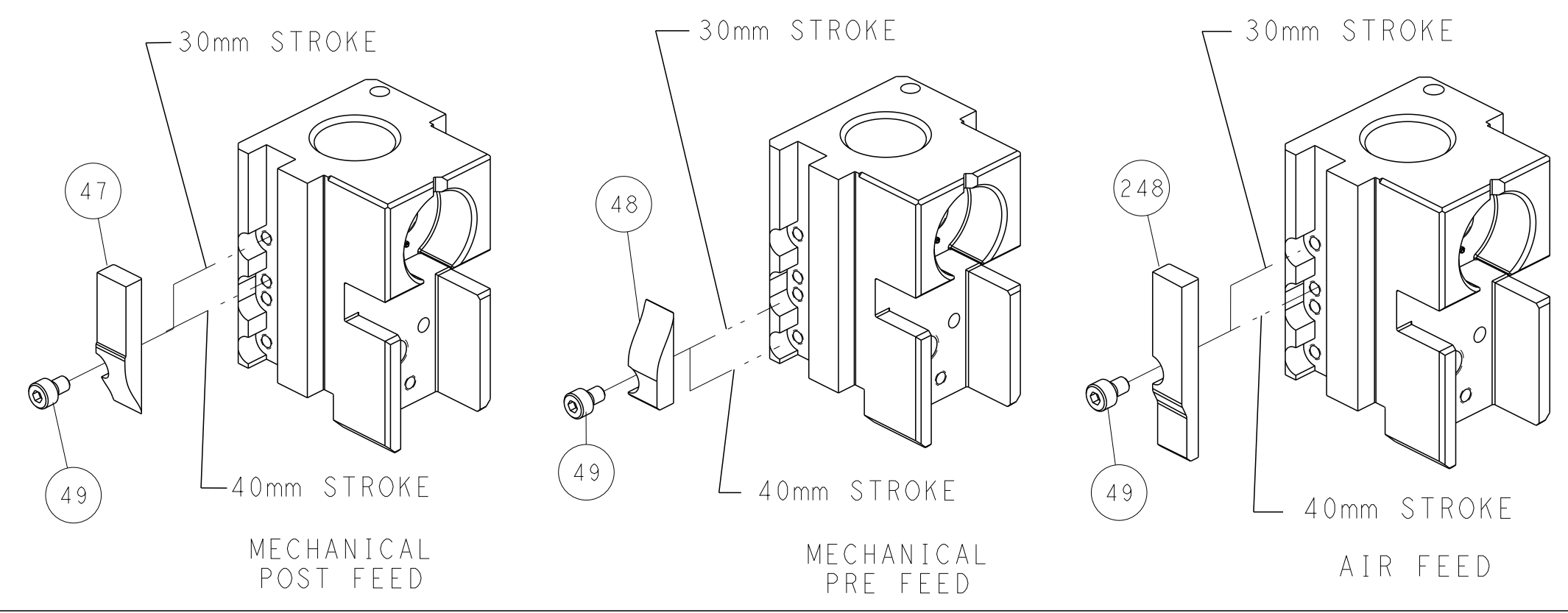
## PNEUMATIC



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



# 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 T. BROOKENS 26FEB2018 CHK M. HERR 26FEB2018 APVD G. BAILEY 26FEB2018 PRODUCT SPEC APPLICATION SPEC WEIGHT Customer Accessible Production Drawing		NAME Ocean Side Feed Applicator SIZE CAGE CODE DRAWING NO A1 00779 C=2837157 SCALE 1:2 SHEET 2 OF 4 REV C	
MATERIAL:				RESTRICTED TO:			

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2837157-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2837157-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2837157-7	C	CRIMP TOOLING KIT	-

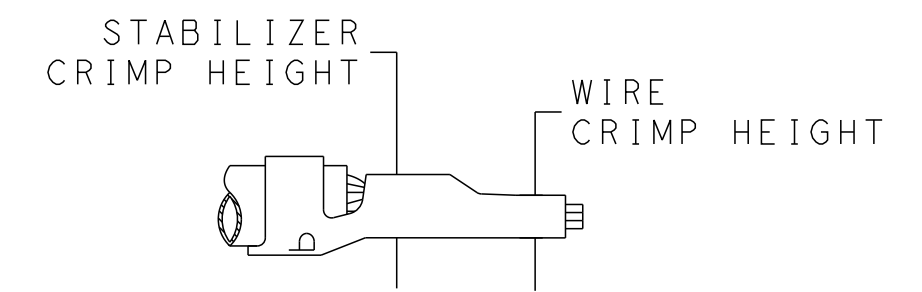
PACIFIC VERSION TERMINATOR  
 INTERFACE ADAPTER



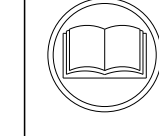
APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.79 mm [.110]	F
STAB	2.79 mm [.110]	O
INSUL	3.94 mm [.155]	O

APPLICATOR INSTRUCTIONS  
 408-35042

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION
TERMINAL NAME: MINI AMP-IN 2000		
WIRE STRIP LENGTH 4.83-5.59 mm [1.90-.220 IN]		TERMINAL INSULATION DIAMETER RANGE Ø2.29-3.81 mm [.090-.150 IN]
TERMINAL APPLICATION SPECIFICATION 114-1016		
TERMINALS APPLIED		
TE TERMINAL	TE TERMINAL	TE TERMINAL
3-647334-1		



WIRE SIZE	CRIMP HEIGHT mm [INCH]	WIRE CRIMPER PART NUMBER	STABILIZER CRIMPER PART NUMBER	STABILIZER CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
14 AWG	1.40+/-0.05 [.055+/-0.002]	8-456408-4			9.0
16 AWG	1.10+/-0.05 [.043+/-0.002]	8-456408-5	815664-2	2.79+0.13/-0.00 [.110+.005/-0.000]	8.8
18 AWG	1.10+/-0.05 [.043+/-0.002]				8.7



- 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 ITEM 1 TO BE USED WITH 14 AWG ONLY. ITEM TO BE SHIPPED WITH APPLICATOR.
- 7 ITEM 253 TO BE USED WITH 16 & 18 AWG ONLY. APPLICATOR TO BE SET UP WITH THIS ITEM.

**\*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	DWN	APVD
		-	-	SEE SHEET 1	-	-	-

1	1	1803078-3	SPACER, PRECISION	259
1	1	8-456408-5	CRIMPER, WIRE PREMIUM	253
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
-	-	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	-	2844940-1	AIR FEED MODULE	238
-	-	815664-2	CRIMPER, WIRE-O	178
-	REF	994970-2	COUNTER, MAGNETIC	164
-	-	2119641-2	FEED CAM, AIR FEED	151
-	-	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	144
-	-	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	143
-	-	2119653-2	FEED CAM, POST FEED	142
-	-	1-1803583-0	APPLICATOR BASIC ASSEMBLY, SF	141
-	-	1803516-2	RAM ASSEMBLY, SF PACIFIC	140
-	-	2844908-1	SCREW, LOCKING	99
-	-	2844907-1	POST, LOCKING	98
-	-	1-455888-0	SPACER, CRIMPER	82
-	-	1803607-3	DOCUMENTATION PACKAGE	71
-	-	2119740-1	TAG, IDENTIFICATION	67
-	-	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	-	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	-	1338683-8	FEED PAWL	56
-	-	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	-	2119652-1	FEED CAM, PRE FEED	48
-	-	1803602-2	SCR, BHSC, RoHS (M8 X 40)	41
-	-	469465-4	STOP, WIRE	34
-	-	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	-	2-2844962-8	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	-	2844992-1	ASSEMBLY, STRIP GUIDE	29
-	-	455888-5	SPACER, CRIMPER	28
-	-	1320928-2	STRIP GUIDE	24
-	-	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
-	-	1-18028-2	WASHER, FLAT, REG M4	20
-	-	2119533-3	STRIPPER, SIDE FEED	19
-	-	2119806-1	INSERT, SHEAR	13
-	-	3-22280-3	SPRING, COMPRESSION	12
-	-	1-356885-4	STOP, SHEAR	11
-	-	2119805-1	SHEAR HOLDER, FRONT	10
-	-	1803095-1	FLOATING SHEAR, FRONT	9
1	1	1-1803703-8	ANVIL, COMBINATION	8
-	-	-	-	7
-	-	-	-	6
-	-	1-2119757-2	DEPRESSOR, SHEAR	5
-	-	238011-4	BLOCK, CRIMPER SPACER	4
1	1	7-1803317-0	CRIMPER, INSULATION O	3
-	-	1-455888-6	SPACER, CRIMPER	2
1	1	8-456408-4	CRIMPER, WIRE PREMIUM	1

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

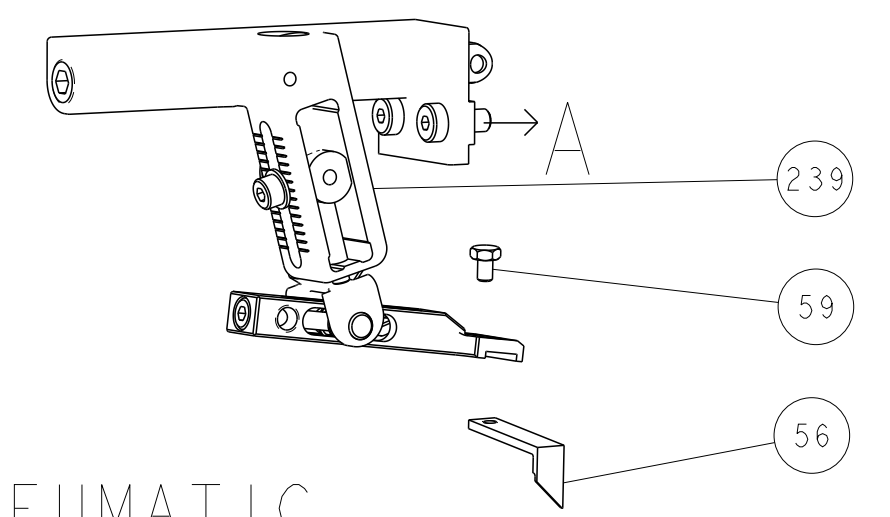
ITEM NO	DESCRIPTION	ITEM NO
-77	-22	-21

OWN	T. BROOKENS	26FEB2018
CHK	M. HERR	26FEB2018
APVD	G. BAILEY	26FEB2018

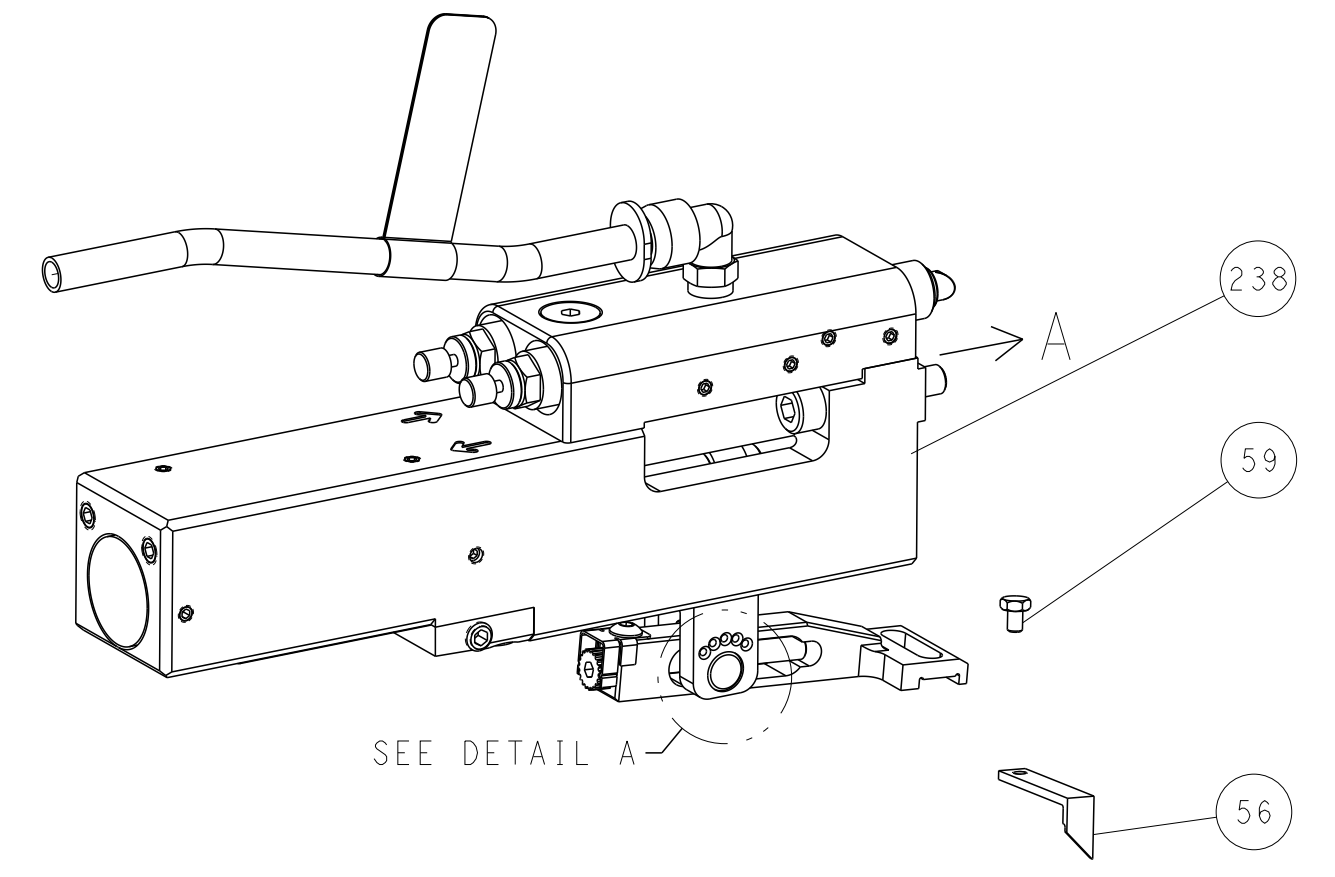
NAME	Ocean Side Feed Applicator		
SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
A1	00779	2837157	
Customer Accessible Production Drawing		SCALE	1:2
SHEET		3	OF 4
REV		C	

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

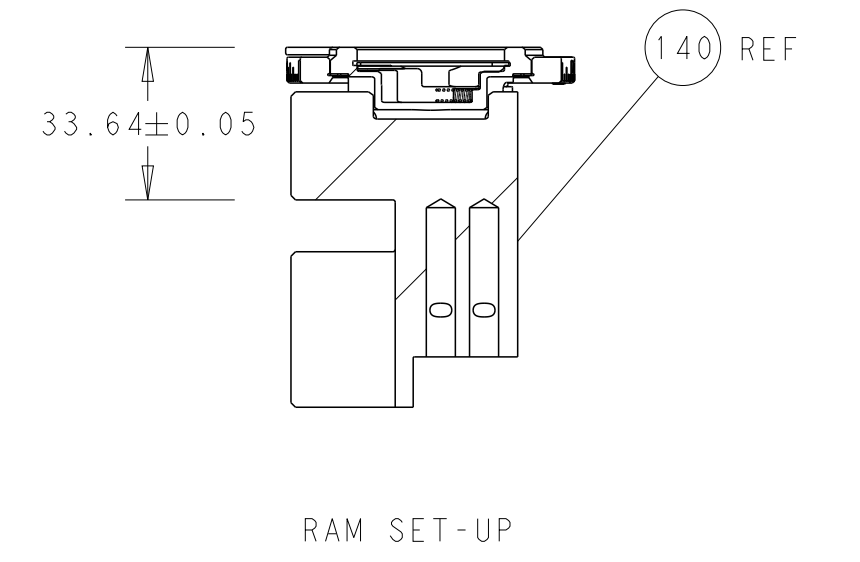
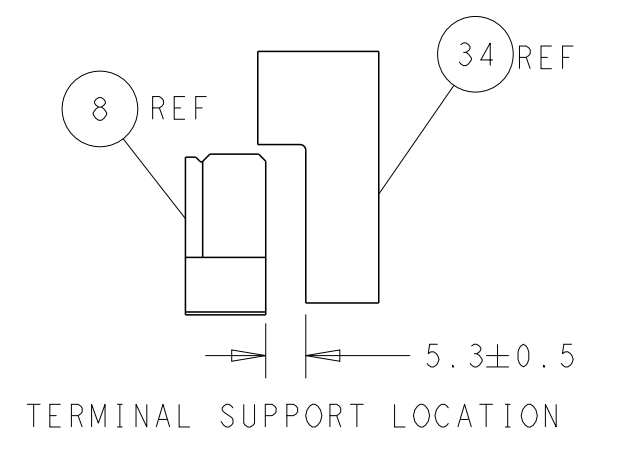
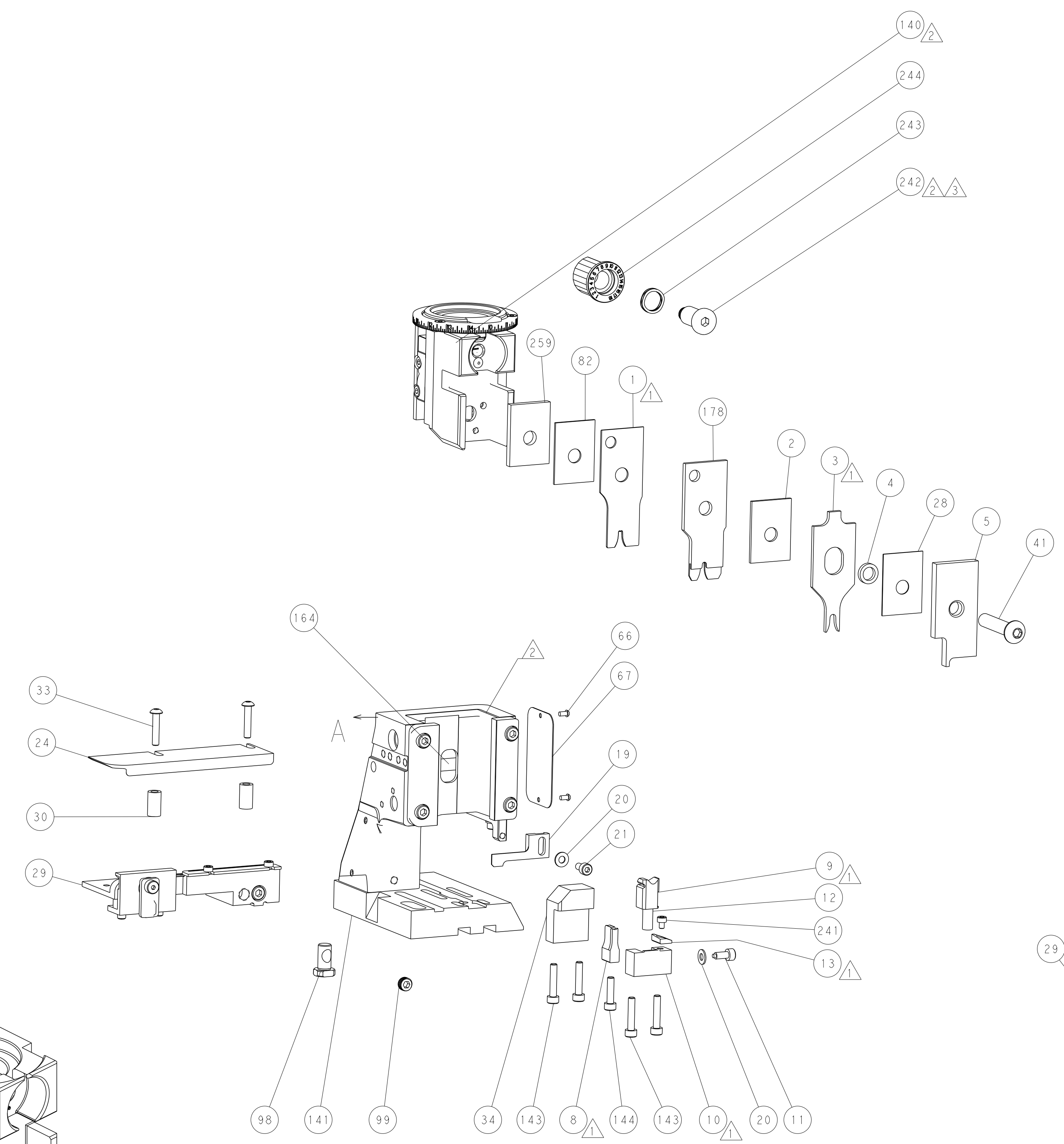
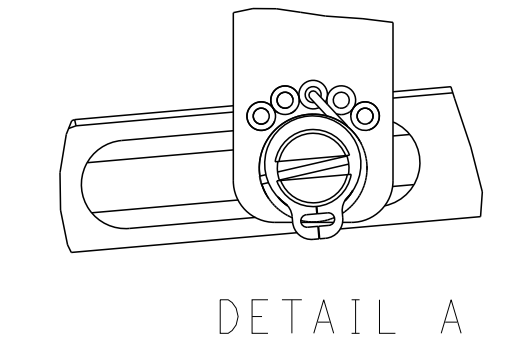
# FEED TYPE MECHANICAL



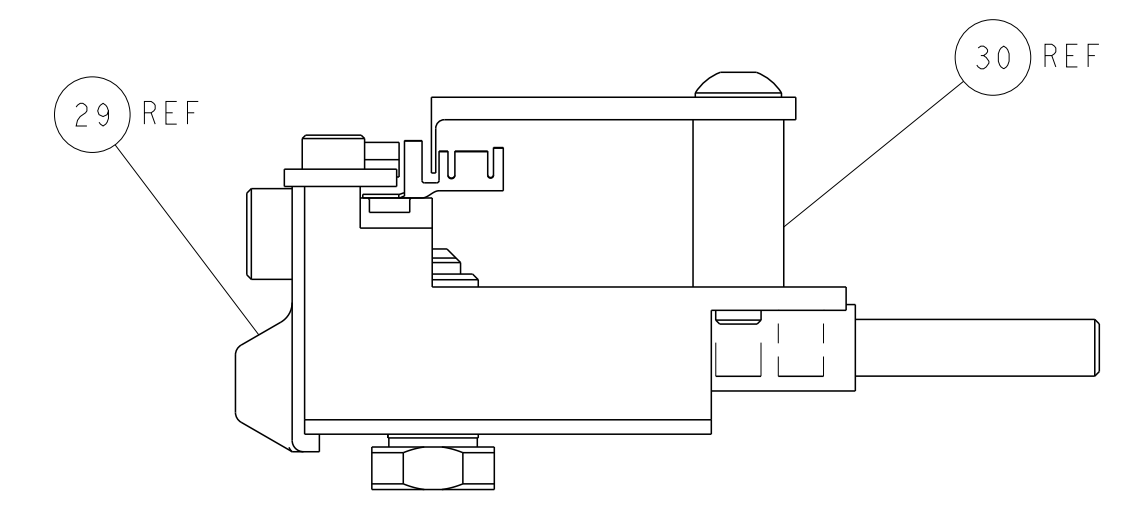
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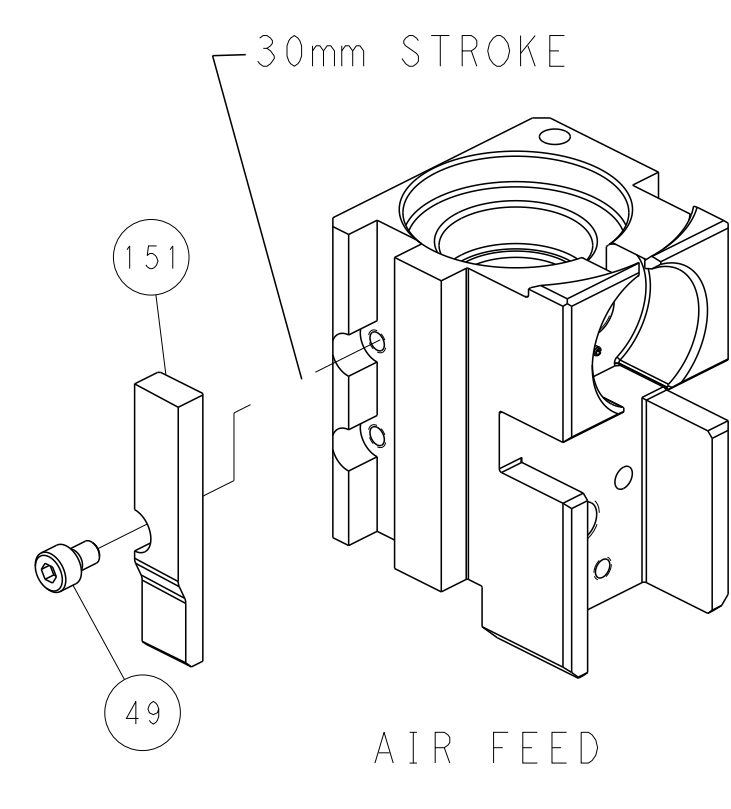
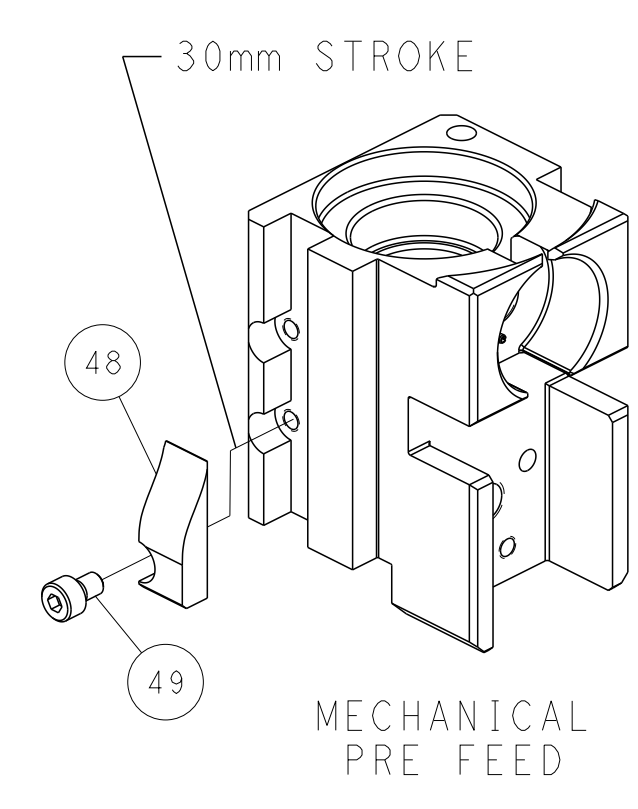
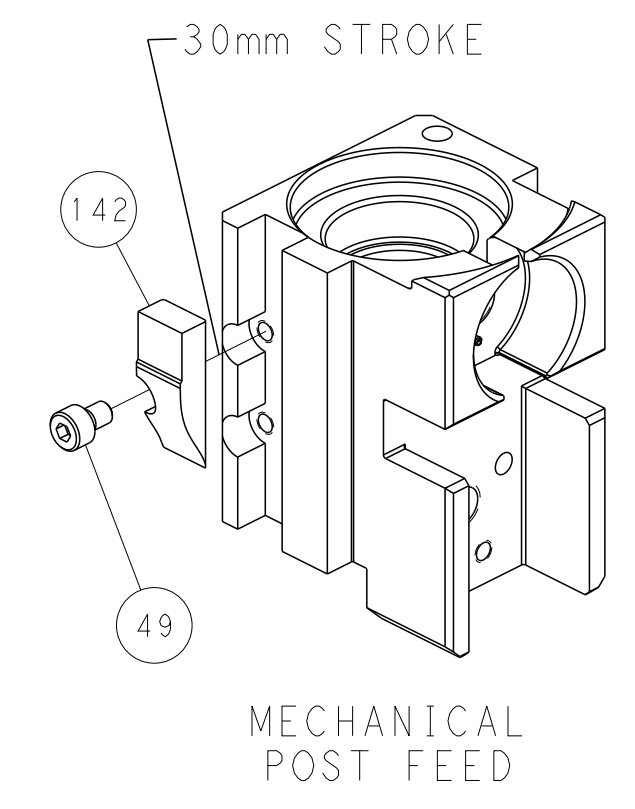
### FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



ITEM 30 LOCATED AT FRONT HOLES



## 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 UNPUBLISHED. RELEASED FOR PUBLICATION. IT IS THE POLICY OF TYCO ELECTRONICS CORPORATION TO CONTINUE TO IMPROVE ITS PRODUCTS AND THE DESIGNATION SHOWN BY CONTACTED FOR THE LATEST POSITION.</small>		DWN T. BROOKENS 26FEB2018 CHK M. HERR 26FEB2018 APVD G. BAILEY 26FEB2018	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 APPLICATION SPEC SIZE CAGE CODE DRAWING NO A1 00779 C=2837157	RESTRICTED TO SCALE 1:2 SHEET 4 OF 4 REV C
MATERIAL:		WEIGHT:	Customer Accessible Production Drawing