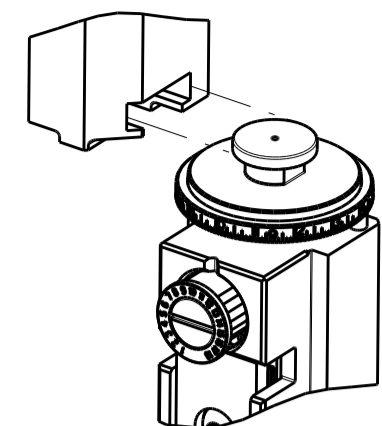


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2837164-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2837164-2	B	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2837164-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER

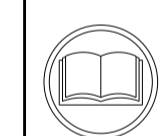


APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	0.84 mm [.033]	F
INSUL	0.89 mm [.035]	F

APPLICATOR INSTRUCTIONS
408-35042

TERMINAL DATA: HIROSE TERMINAL - CRIMP SPECIFICATION			
TERMINAL NAME: HR30 Series Miniature Terminal			
WIRE STRIP LENGTH		TERMINAL INSULATION DIAMETER RANGE	
1.37-2.13 mm [.054-.084 IN]		Ø0.50-1.00 mm [.020-.039 IN]	
TERMINAL APPLICATION SPECIFICATION	NONE		
TERMINALS APPLIED			
TE TERMINAL	HIROSE TERMINAL	TE TERMINAL	HIROSE TERMINAL
1572953-1	HR30-SC-211	1572953-2	HR30-PC-211

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
26 AWG	0.55 +/- 0.03 [.022 +/- .001]	5.4
28 AWG	0.51 +/- 0.03 [.020 +/- .001]	5.8
30 AWG	0.49 +/- 0.03 [.019 +/- .001]	6.1



- RECOMMENDED SPARE PARTS
- REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 180. 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.
- 5. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- PART OPTIONAL FOR BETTER LEADMAKER PERFORMANCE.
- TERMINAL LUBRICANT IS RECOMMENDED.

***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	REV	DATE	BY	APPD
		1	PRELIMINARY	03MAR2018	CT GB
		A	RELEASE	10APR2018	AW CT
		B	ECR-20-016875	27NOV2020	FZ TE

-	1	1	2079383-1	SCR, BHSC, RoHS (M3 X 8)	284
	-	1	1633289-4	STABILIZER	283
-	1	1	1803461	HOLDER, STABILIZER	282
-	1	1	1-18028-3	WASHER, FLAT, REG M5	281
-	1	1	1803196-1	STUD, ADJUSTMENT SCREW	280
-	1	1	2-2119791-2	DEPRESSOR, WIRE	265
-	1	1	2330046-1	RESIN COLLAR, FLANGED	261
-	1	1	2119641-1	FEED CAM, AIR FEED	248
-	1	1	2119082-8	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
	-	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
	-	1	2844940-1	AIR FEED MODULE	238
	-	1	1-1752354-1	STANDOFF, HOLD-DOWN	180
-	1	1	6-993111-6	PIN, SLOTTED SPRING 3.0 X 14.0	177
-	1	1	8-22280-7	SPRING, COMPRESSION	176
-	1	1	1752353-2	GUIDE PIN, HOLDDOWN	175
-	1	1	1901680-2	GUIDE PIN, HOLDDOWN	174
-	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	1	1	2-22281-3	SPRING, COMPRESSION	121
	-	1	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113
-	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	1-994962-8	SCR, SKT HD CAP M3 X 45.0	93
-	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
-	2	2	2-18032-5	SCR, SET, FLT PNT, M5 X 20.0	61
-	1	1	2161425-1	SCREW, SHOULDER	60
-	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	1	1	1338685-1	PAWL, FEED	56
-	4	4	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	54
-	1	1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52
-	1	1	1901681-1	HOLDDOWN, TERMINAL	51
-	1	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	1	1	2-1803583-5	APPLICATOR BASIC ASSEMBLY, SF	46
-	1	1	1803515-3	RAM ASSEMBLY, SF ATLANTIC	44
-	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
-	1	1	3-1752356-4	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	455888-6	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	2119806-1	INSERT, SHEAR	13
-	1	1	3-22280-3	SPRING, COMPRESSION	12
-	1	1	1-18023-1	SCR, SKT HD CAP M4 X 10.0	11
	-	1	2119805-1	SHEAR HOLDER, FRONT	10
	-	1	1803095-3	FLOATING SHEAR, FRONT	9
	1	2	1803655-2	ANVIL, COMBINATION	8
-	-	-	-	-	7
-	-	-	-	-	6
-	1	1	2119757-2	DEPRESSOR, SHEAR	5
-	1	1	3-238011-6	BLOCK, CRIMPER SPACER	4
	1	2	1803493-9	CRIMPER, INSULATION F PREMIUM	3
-	1	1	455888-1	SPACER, CRIMPER	2
	1	2	2-1803407-7	CRIMPER, WIRE PREMIUM	1

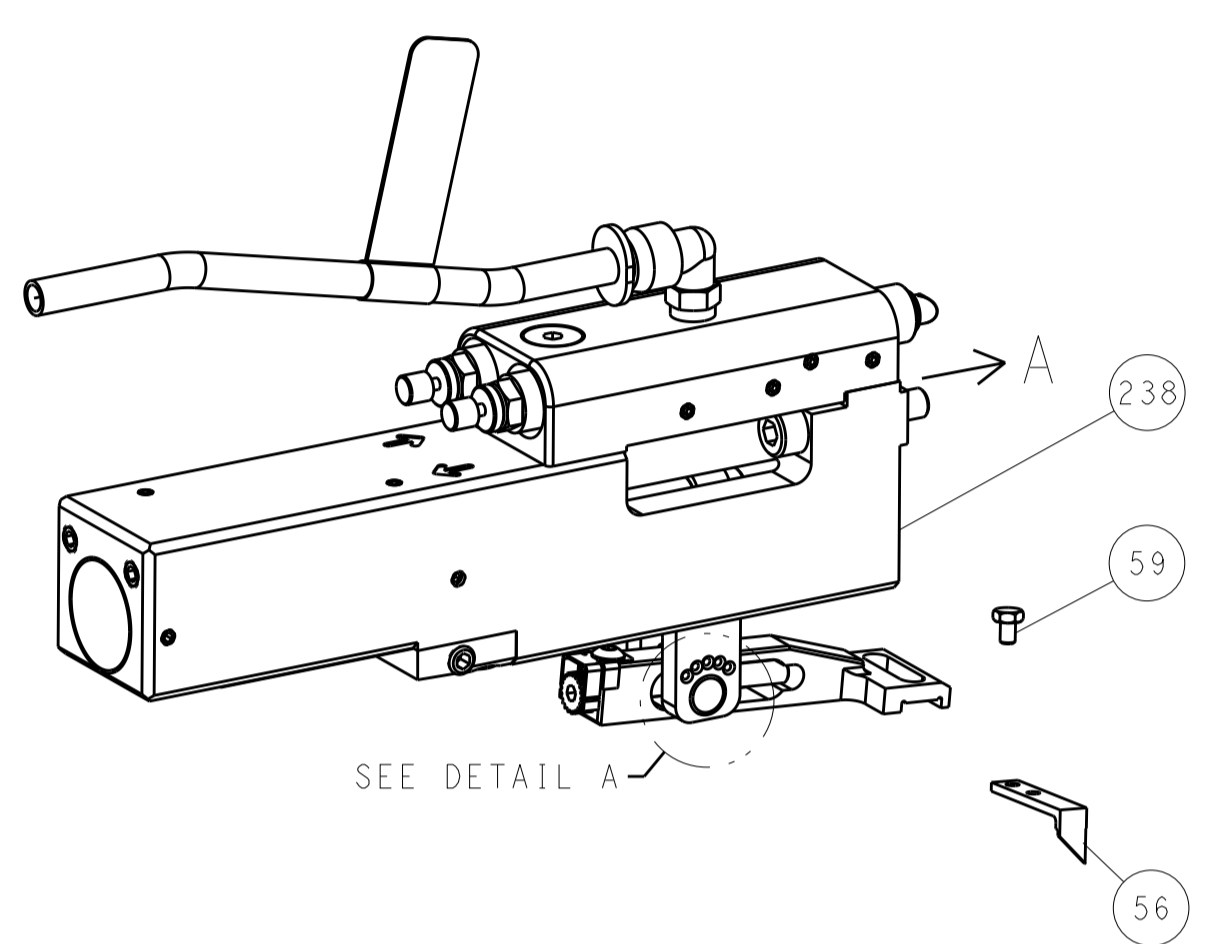
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		MATERIAL:		FINISH:	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES ±	

OWN	C. TOPPER	03MAR2018	
CHK	G. BAILEY	03MAR2018	
APVD	J. DEGRANGE	03MAR2018	
NAME	Ocean Side Feed Applicator		
SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
A1	00779	2837164	
Customer Accessible Production Drawing		SCALE	SHEET 1 OF 4
		1:2	REV B

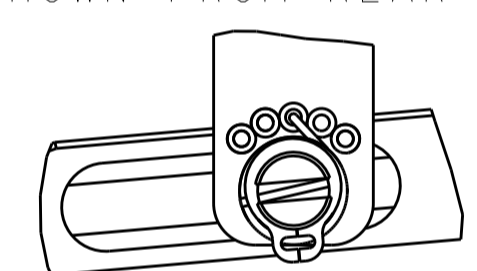
LOC		DIST		REVISIONS			
A	66	P	LTM	DESCRIPTION	DATE	DWN	APVD
		-		SEE SHEET 1	-	-	-

FEED TYPE

PNEUMATIC

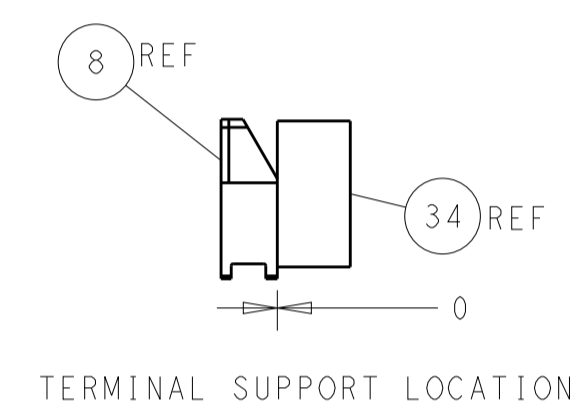
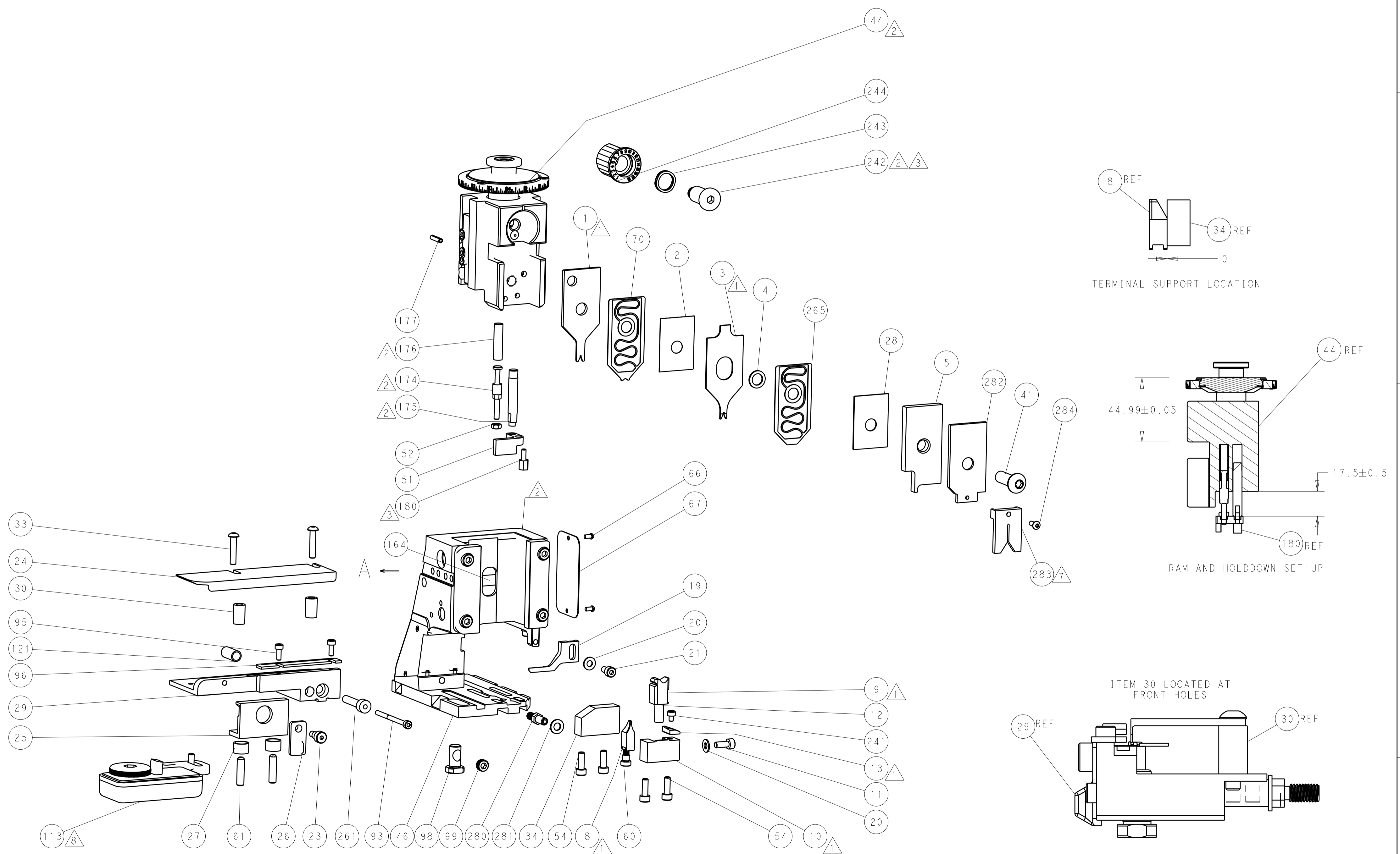
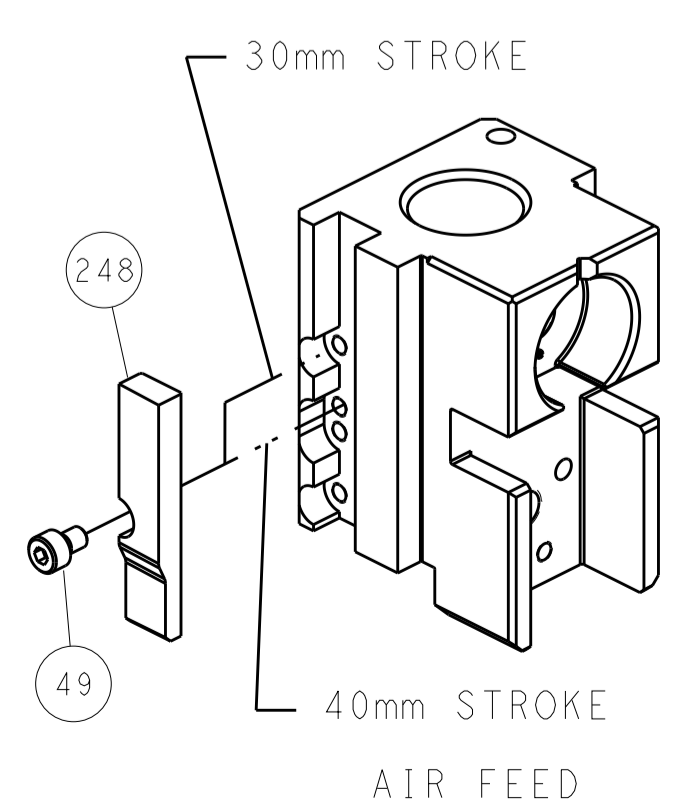


FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)

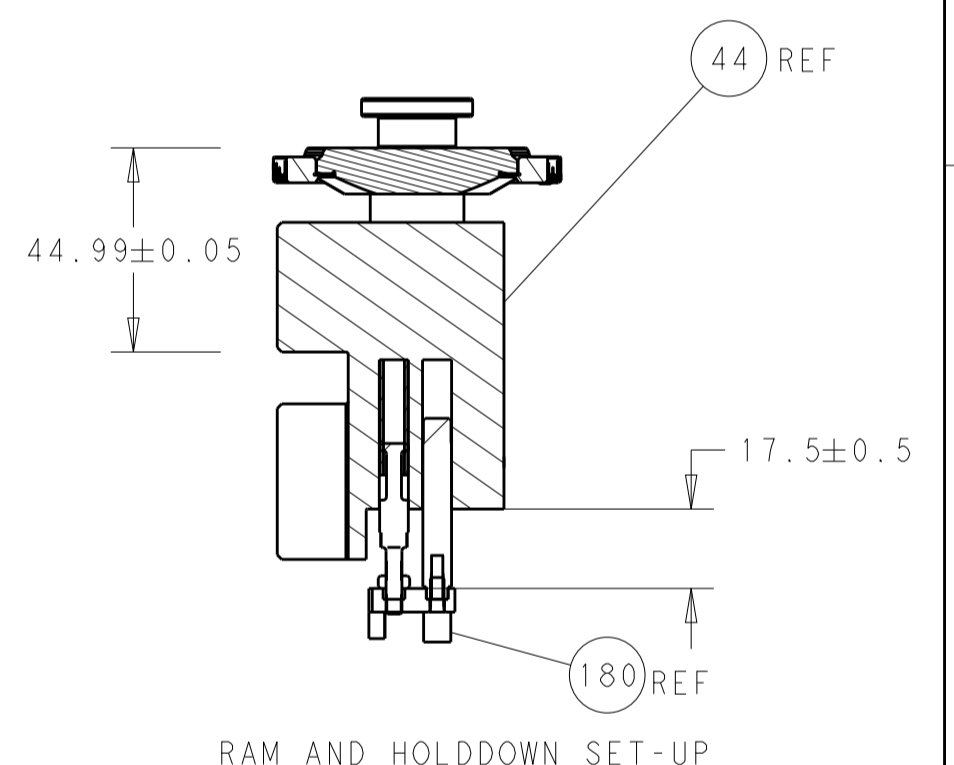


DETAIL A

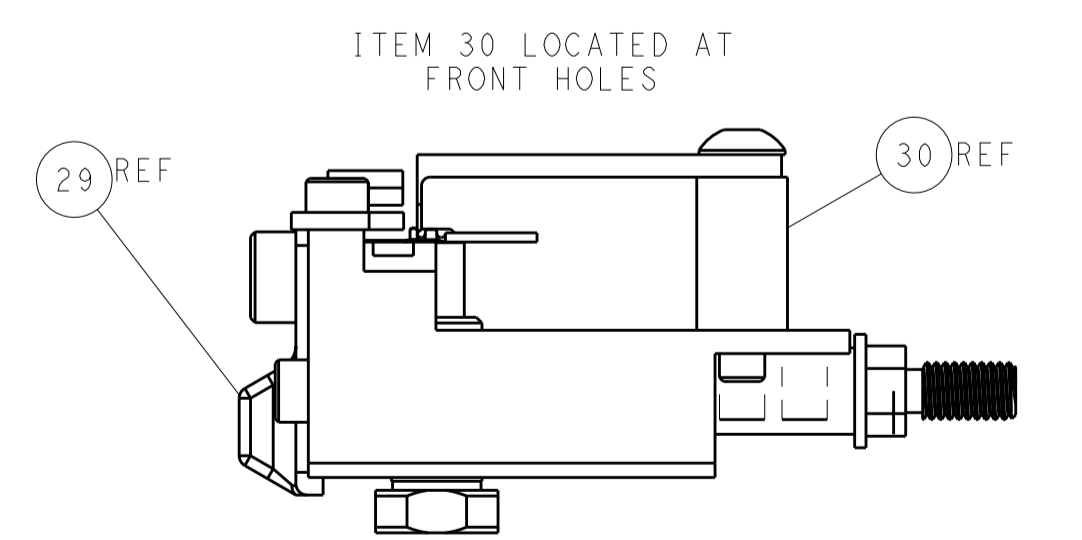
CAM POSITION



TERMINAL SUPPORT LOCATION



RAM AND HOLDDOWN 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)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN C. TOPPER 03MAR2018		TE Connectivity	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	Harrisburg, PA 17105-3608	
	ANGLES	FINISH		CHK G. BAILEY 03MAR2018		NAME	
				APVD J. DEGRANGE 03MAR2018		Ocean Side Feed Applicator	
MATERIAL				PRODUCT SPEC		RESTRICTED TO	
				APPLICATION SPEC		SIZE CAGE CODE DRAWING NO	
				WEIGHT		A1 00779 C=2837164	
				Customer Accessible Production Drawing		SCALE 1:2 SHEET 2 OF 4 REV B	

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2837164-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2837164-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	0.84 mm [.033]	F
INSUL	0.89 mm [.035]	F
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: HIROSE TERMINAL - CRIMP SPECIFICATION			
TERMINAL NAME: HR30 Series Miniature Terminal			
WIRE STRIP LENGTH 1.37-2.13 mm [.054-.084 IN]		TERMINAL INSULATION DIAMETER RANGE Ø0.50-1.00 mm [.020-.039 IN]	
TERMINAL APPLICATION SPECIFICATION NONE	-	-	-
TERMINALS APPLIED			
TE TERMINAL 1572953-1	HIROSE TERMINAL HR30-SC-211	TE TERMINAL 1572953-2	HIROSE TERMINAL HR30-PC-211

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
26 AWG	0.55 +/- 0.03 [.022 +/- .001]	5.4
28 AWG	0.51 +/- 0.03 [.020 +/- .001]	5.8
30 AWG	0.49 +/- 0.03 [.019 +/- .001]	6.1



- RECOMMENDED SPARE PARTS
- REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 180. 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.
- 5. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- PART OPTIONAL FOR BETTER LEADMAKER PERFORMANCE.
- TERMINAL LUBRICANT IS RECOMMENDED.

***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	DATE	BY	APPV
A	66				

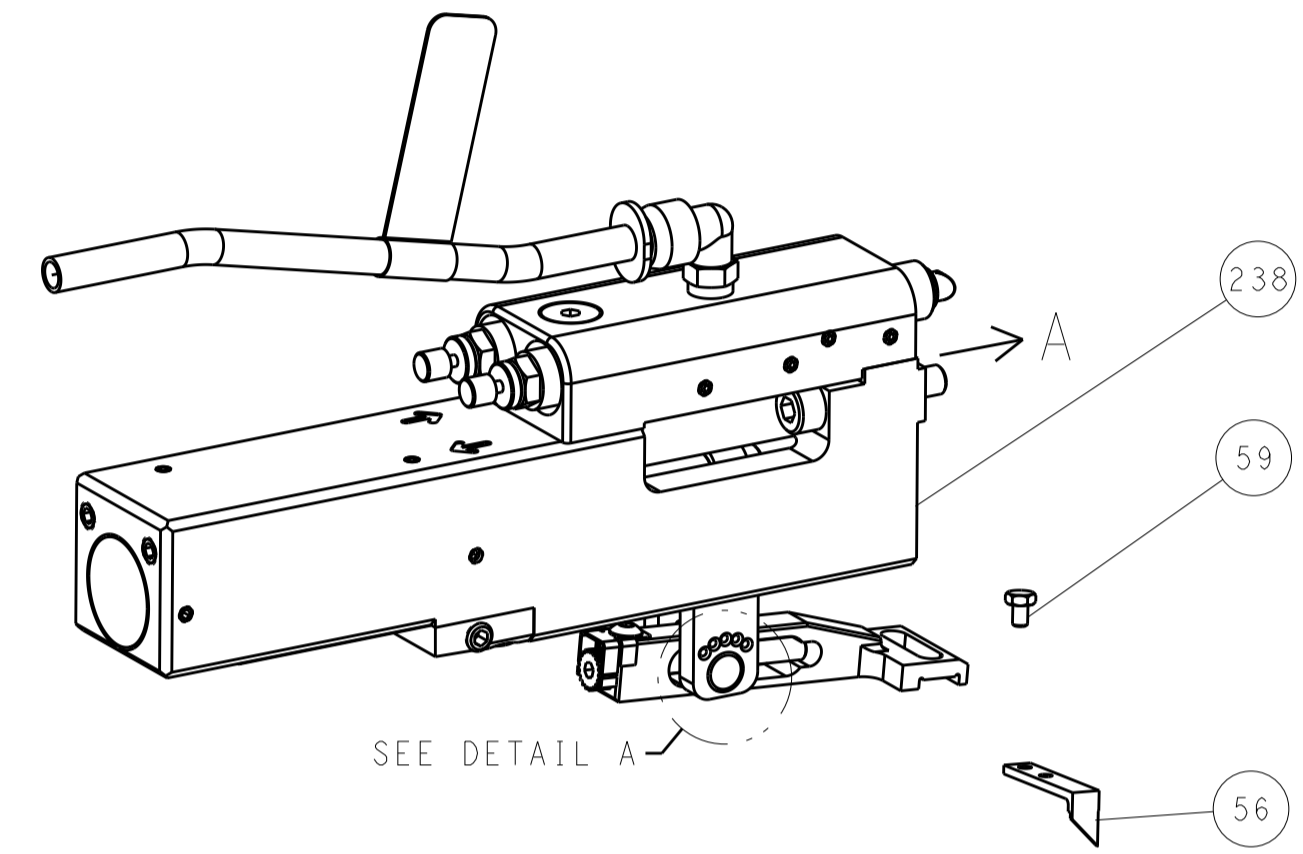
REVISIONS					
REV	DATE	DESCRIPTION	DATE	BY	APPV
-	-	SEE SHEET 1	-	-	-
-	1	2079383-1	SCR, BHSC, RoHS (M3 X 8)		284
-	1	1633289-4	STABILIZER		283
-	1	1803461	HOLDER, STABILIZER		282
-	1	1-18028-3	WASHER, FLAT, REG M5		281
-	1	1803196-1	STUD, ADJUSTMENT SCREW		280
-	1	2-2119791-2	DEPRESSOR, WIRE		265
-	1	2330046-1	RESIN COLLAR, FLANGED		261
-	1	2119082-8	CAM, SNAIL, INSULATION ADJUSTMENT		244
-	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST		243
-	1	2119083-1	RETAINER, INSULATION DIAL		242
-	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0		241
-	1	2844940-1	AIR FEED MODULE		238
-	1	1-1752354-1	STANDOFF, HOLD-DOWN		180
-	1	6-993111-6	PIN, SLOTTED SPRING 3.0 X 14.0		177
-	1	8-22280-7	SPRING, COMPRESSION		176
-	1	1752353-2	GUIDE PIN, HOLDDOWN		175
-	1	1901680-2	GUIDE PIN, HOLDDOWN		174
-	REF	994970-2	COUNTER, MAGNETIC		164
-	1	2119641-2	FEED CAM, AIR FEED		151
-	4	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20		143
-	-	2119653-2	FEED CAM, POST FEED		142
-	1	3-1803583-0	APPLICATOR BASIC ASSEMBLY, SF		141
-	1	1803516-1	RAM ASSEMBLY, SF PACIFIC		140
-	1	2-22281-3	SPRING, COMPRESSION		121
-	1	2119955-1	ASSY, LUBRICATOR, SIDE FEED		113
-	1	2844908-1	SCREW, LOCKING		99
-	1	2844907-1	POST, LOCKING		98
-	1	1-690438-0	FRONT STRIP GUIDE		96
-	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0		95
-	1	1-994962-8	SCR, SKT HD CAP M3 X 45.0		93
-	1	1803607-3	DOCUMENTATION PACKAGE		71
-	1	2119791-9	DEPRESSOR, WIRE		70
-	1	2119740-1	TAG, IDENTIFICATION		67
-	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188		66
-	2	2-18032-5	SCR, SET, FLT PNT, M5 X 20.0		61
-	1	2161425-1	SCREW, SHOULDER		60
-	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0		59
-	1	1338685-1	PAWL, FEED		56
-	1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5		52
-	1	1901681-1	HOLDDOWN, TERMINAL		51
-	1	18023-9	SCR, SKT HD CAP M4 X 6.0		49
-	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)		41
-	1	3-1752356-4	SUPPORT, TERMINAL		34
-	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)		33
-	2	2-2844962-3	SPACER, CYLINDRICAL, STRIP GUIDE		30
-	1	2844938-1	PLATE, STRIP GUIDE		29
-	1	455888-6	SPACER, CRIMPER		28
-	2	22283-1	SPRING, COMPRESSION		27
-	1	356835-1	LEVER, DRAG RELEASE		26
-	1	240792-1	DRAG, TERMINAL		25
-	1	1320928-2	STRIP GUIDE		24
-	1	980371-4	SCR, SKT HD SHLDR 5.0 DIA X 6.0		23
-	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0		21
-	2	1-18028-2	WASHER, FLAT, REG M4		20
-	1	1803213-1	STRIPPER		19
-	1	2119806-1	INSERT, SHEAR		13
-	1	3-22280-3	SPRING, COMPRESSION		12
-	1	1-18023-1	SCR, SKT HD CAP M4 X 10.0		11
-	1	2119805-1	SHEAR HOLDER, FRONT		10
-	1	1803095-3	FLOATING SHEAR, FRONT		9
-	1	1803655-2	ANVIL, COMBINATION		8
-	-	-	-		7
-	-	-	-		6
-	1	2119757-2	DEPRESSOR, SHEAR		5
-	1	3-238011-6	BLOCK, CRIMPER SPACER		4
-	1	1803493-9	CRIMPER, INSULATION F PREMIUM		3
-	1	455888-1	SPACER, CRIMPER		2
-	1	2-1803407-7	CRIMPER, WIRE PREMIUM		1

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN: C. TOPPER 03MAR2018		TE Connectivity Harrisburg, PA 17105-3608	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	APVD: G. BAILEY 03MAR2018	NAME: Ocean Side Feed Applicator
MATERIAL:		FINISH:		APVD: DEGRANGE 03MAR2018		SIZE: A1 00779 C=2837164	
Customer Accessible Production Drawing		SCALE: 1:2		SHEET 3 OF 4		REV B	

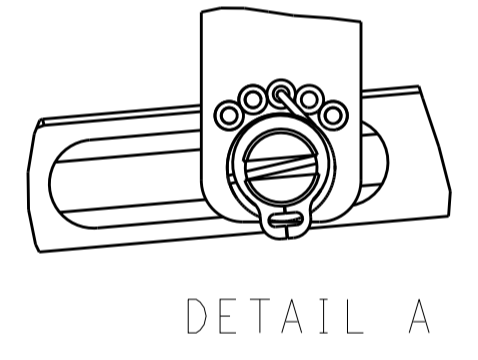
LOC		DIST		REVISIONS			
A	66	P	LTM	DESCRIPTION	DATE	DWN	APVD
		-		SEE SHEET 1			

FEED TYPE

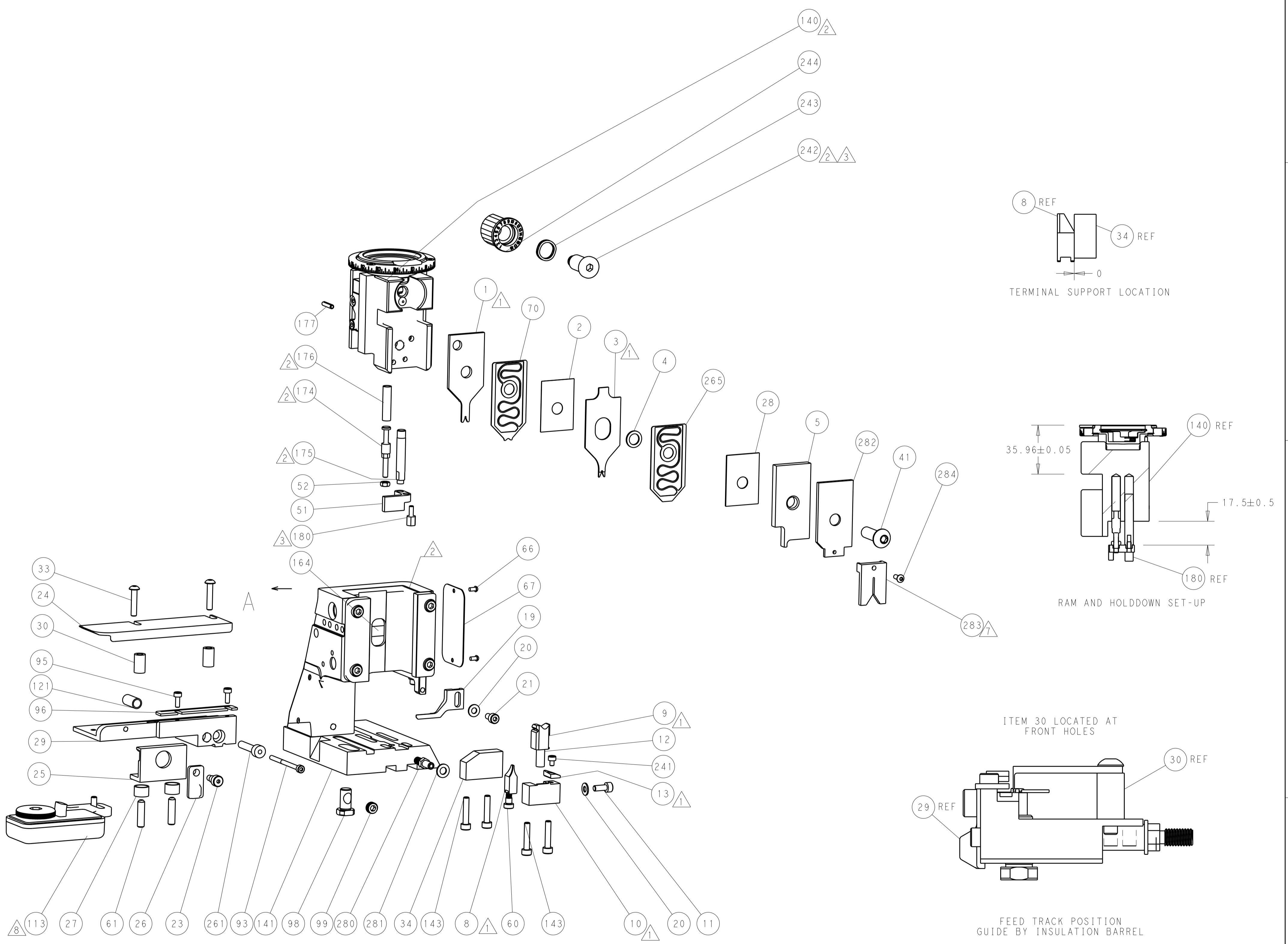
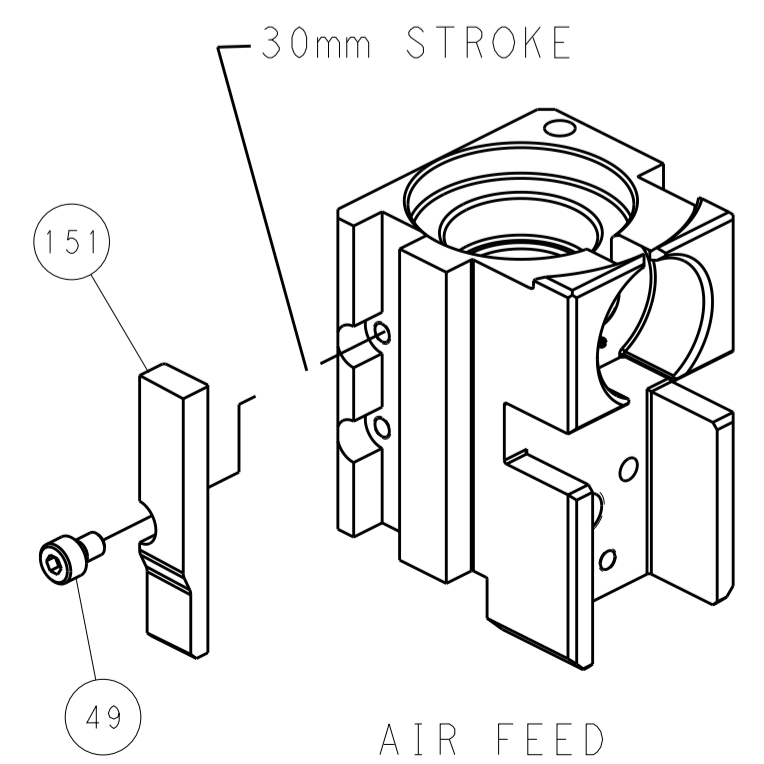
PNEUMATIC



FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



CAM POSITION



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

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN C. TOPPER 03MAR2018		STE TE Connectivity	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	Harrisburg, PA 17105-3608	
	ANGLES ±			APVD J. DEGRANGE 03MAR2018	NAME Ocean Side Feed Applicator		
MATERIAL	FINISH	WEIGHT	SCALE 1:2	Customer Accessible Production Drawing	SIZE A1	CAGE CODE 00779	DRAWING NO. C=2837164
				SHEET 4 OF 4		REV B	