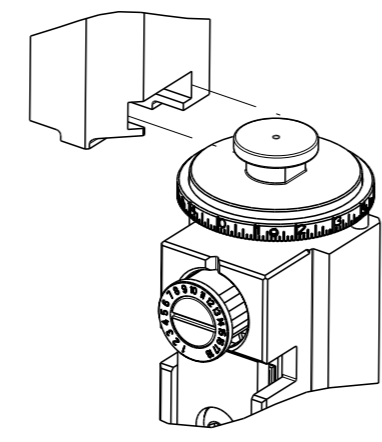


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2837211-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2837211-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2837211-1	C	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2837211-2	C	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2837211-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.40 mm [.055]	F
INSUL	1.75 mm [.069]	O

APPLICATOR INSTRUCTIONS
408-35042

TERMINAL DATA: DELPHI TERMINAL DELPHI CRIMP SPECIFICATION			
TERMINAL NAME: 0.64 MICRO TERMINAL SYSTEM II			
WIRE STRIP LENGTH	TERMINAL INSULATION DIAMETER RANGE		
3.00-3.76 mm [.118-.148 IN]	Ø1.20-1.70 mm [.047-.067 IN]		
TERMINAL APPLICATION SPECIFICATION	15440183 PG 2 Rev 2013-10-30		
TERMINALS APPLIED			
TE TERMINAL	DELPHI TERMINAL	TE TERMINAL	DELPHI TERMINAL
3311167-1	15440183	3311167-2	15440179

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.50mm2	1.05 +/- 0.05 [.041 +/- .002]	6.4
0.35mm2	0.95 +/- 0.05 [.037 +/- .002]	7.4

- 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.
- THIS APPLICATOR DOES NOT CUT THE CARRIER STRIP.

***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					
		P	LY#	DESCRIPTION	DATE	OWN	APVD
A	66	1		DEVELOPMENT	23MAR2018	TB	TE
		A		RELEASE	15MAY2018	AW	CT
		B		ECR-20-001859	10FEB2020	FZ	TE
		C		ECR-20-007013	14MAY2020	JAH	GB

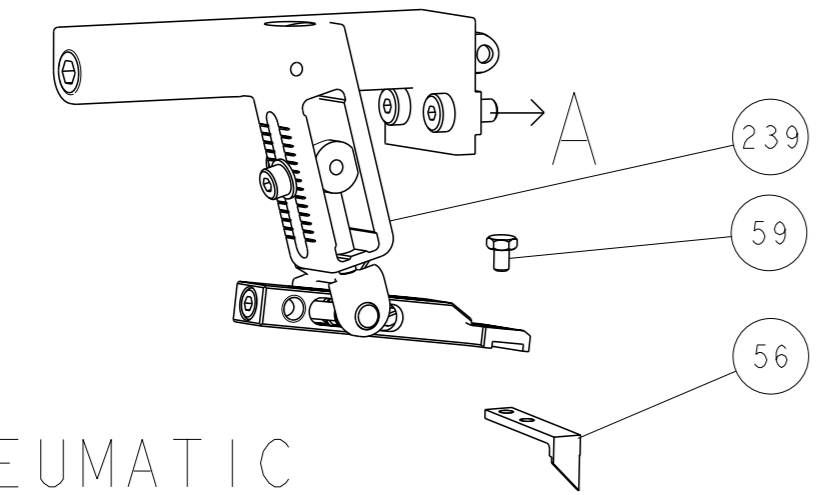
-	1	1	1	1	2119791-5	DEPRESSOR, WIRE	286	
-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248	
-	1	1	1	1	2119082-5	CAM, SNAIL, INSULATION ADJUSTMENT	244	
-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243	
-	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242	
-	-	1	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	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	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	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	53	
-	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	1752356-6	SUPPORT, TERMINAL	34	
-	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33	
-	2	2	2	2	2-2844962-6	SPACER, CYLINDRICAL, STRIP GUIDE	30	
-	1	1	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29	
-	1	1	1	1	455888-4	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	
-	4	4	4	4	1-18028-2	WASHER, FLAT, REG M4	20	
-	1	1	1	1	2119533-1	STRIPPER, SIDE FEED	19	
-	1	1	1	1	5-690518-8	HOLD DOWN, TERMINAL	18	
-	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	1803095-6	FLOATING SHEAR, FRONT	9	
1	2	2	1	1	1-1803703-7	ANVIL, COMBINATION	8	
-	1	1	1	1	6-240641-3	SPACER	7	
-	-	-	-	-	-	-	6	
-	1	1	1	1	1-2119757-8	DEPRESSOR, SHEAR	5	
-	1	1	1	1	1-238011-0	BLOCK, CRIMPER SPACER	4	
1	2	2	1	1	1803712-3	CRIMPER, INSULATION O	3	
-	1	1	1	1	455888-6	SPACER, CRIMPER	2	
1	2	2	1	1	7-456402-4	CRIMPER, WIRE PREMIUM	1	
-	77	-72	-71	-2	-1	PART NO	DESCRIPTION	ITEM NO

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		APPROVED:		NAME:	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	APPLICATOR SPEC	RESTRICTED TO
MATERIAL:		FINISH:		WEIGHT:		SCALE: 1:2 SHEET 1 OF 4 REV C	

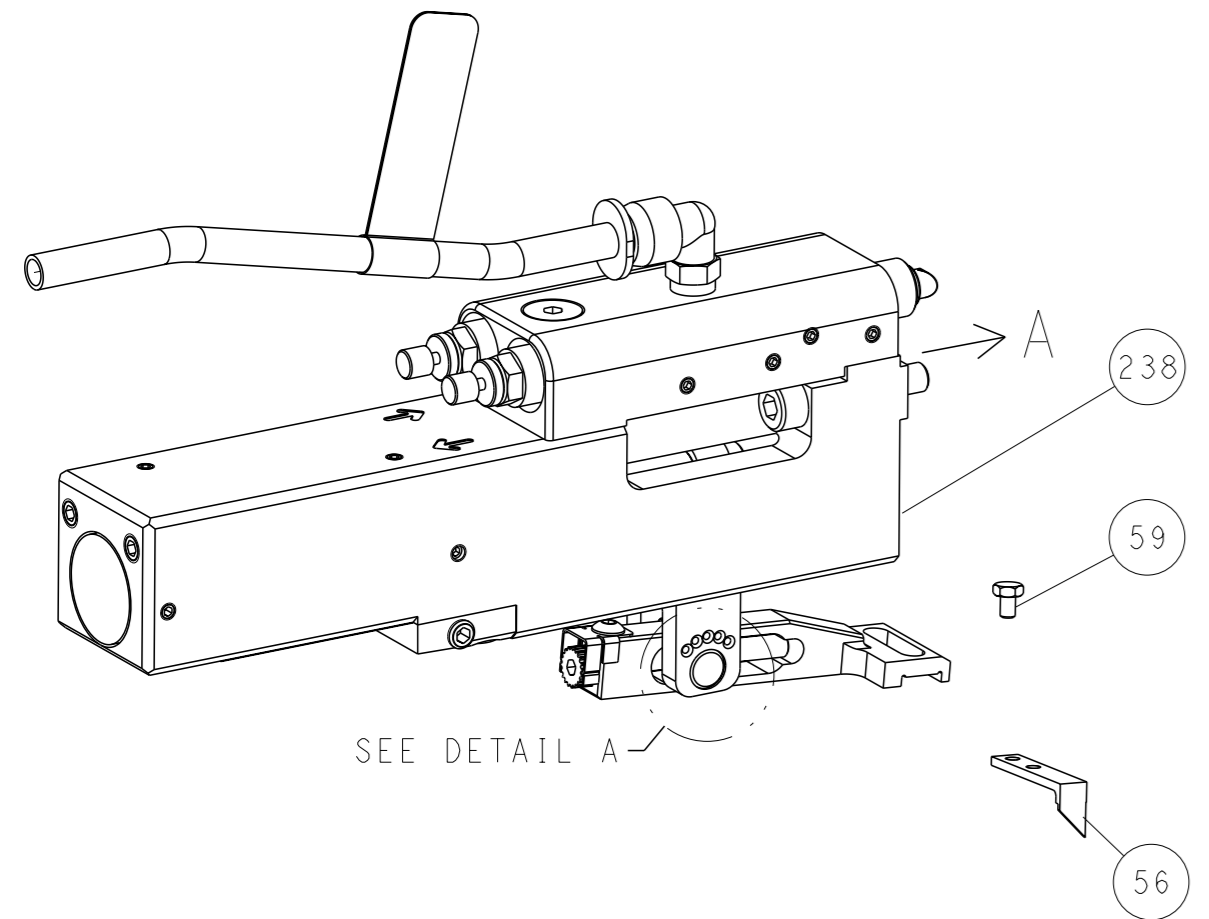
Customer Accessible Production Drawing

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

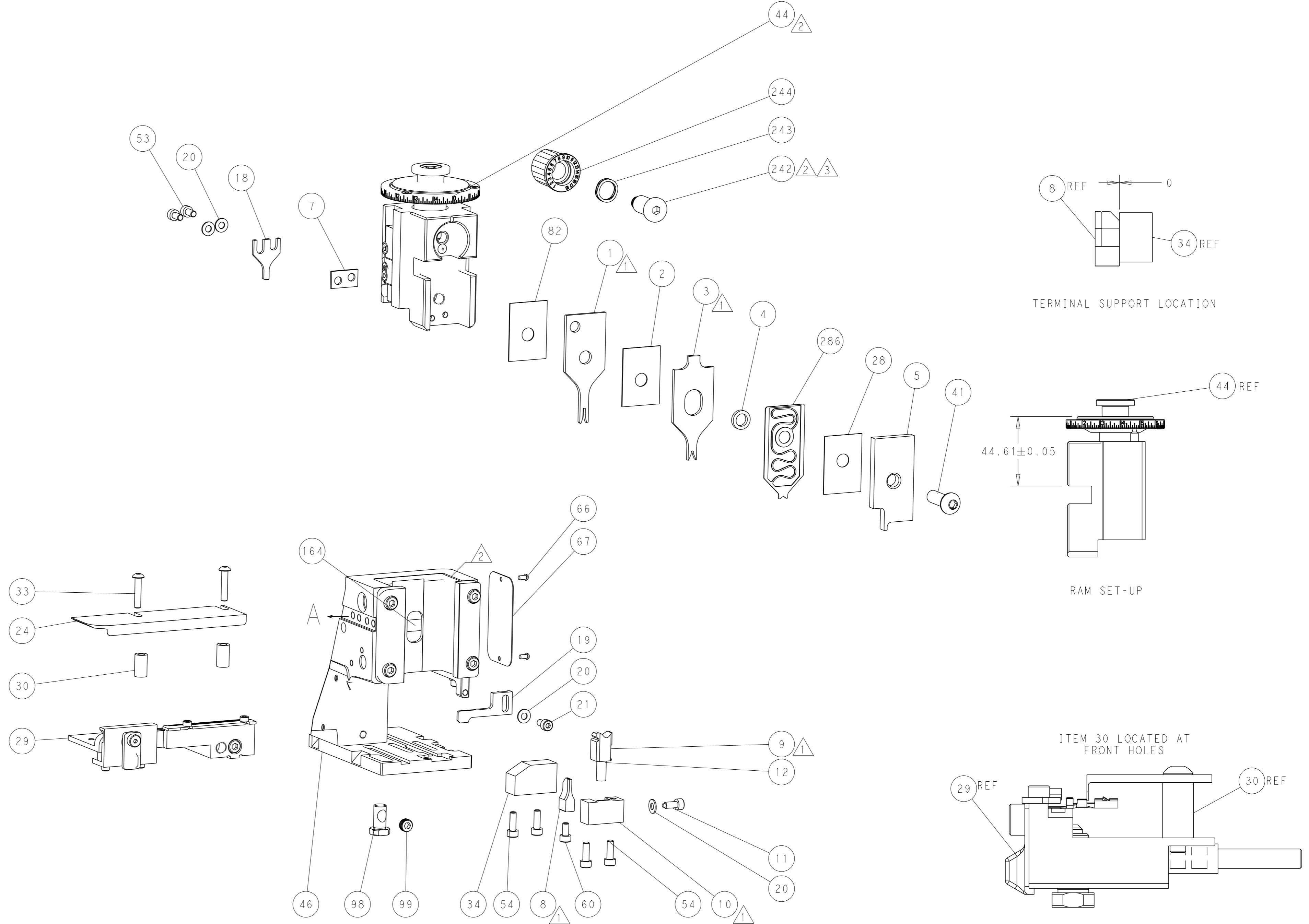
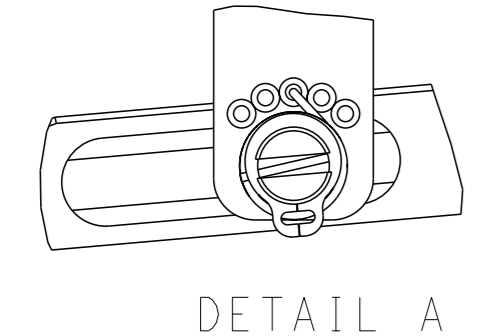
FEED TYPE MECHANICAL



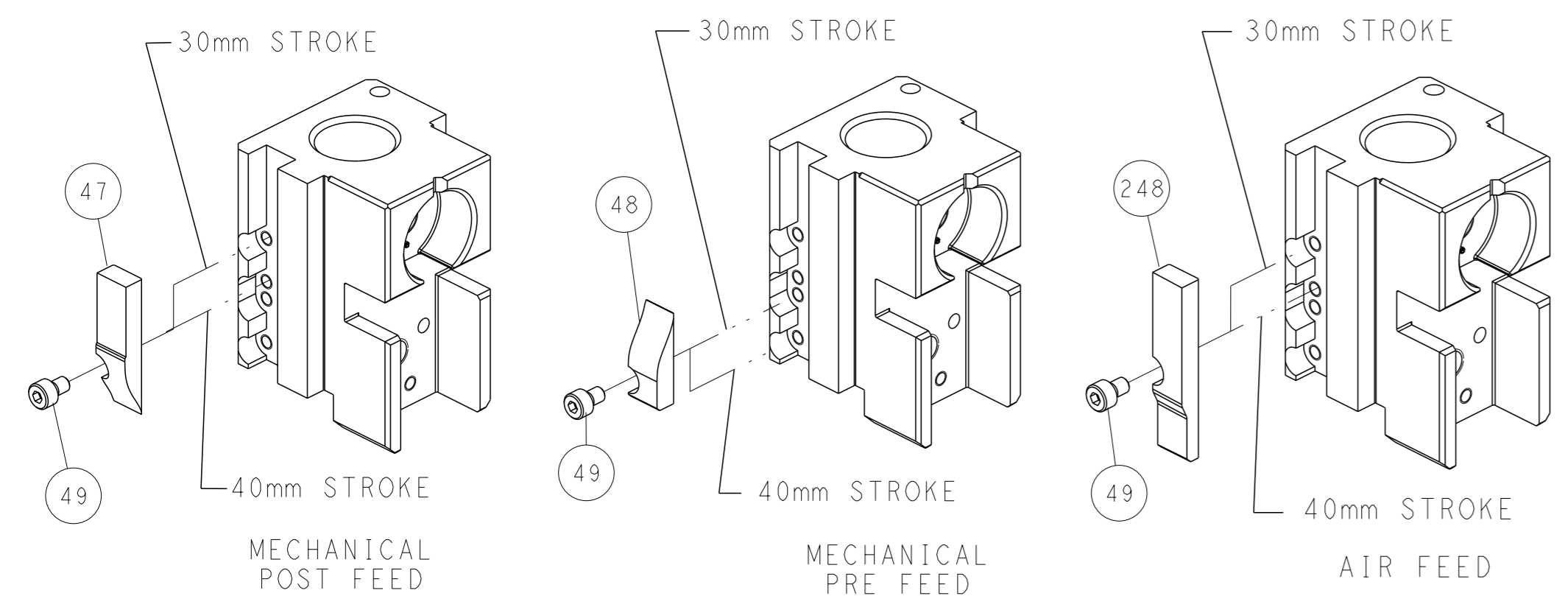
PNEUMATIC



FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



CAM POSITIONS

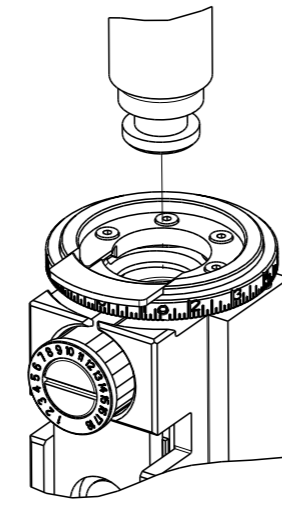


ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

<small>THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE AND THE CONTROL AND REVISIONS ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST REVISION.</small>		DWN T. BROOKS 23MAR2018 CHK M. HERR 23MAR2018 APVD J. ELBIN 23MAR2018	TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ° ±		NAME Ocean Side Feed Applicator SIZE A1 CAGE CODE 00779 DRAWING NO. ©=2837211	RESTRICTED TO SCALE 1:2 SHEET 2 OF 4 REV C
MATERIAL:		WEIGHT:	Customer Accessible Production Drawing

THIS DRAWING IS UNPUBLISHED.	RELEASED FOR PUBLICATION		
© COPYRIGHT 20 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.	20		
PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2837211-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2837211-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2837211-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.40 mm [.055]	F
INSUL	1.75 mm [.069]	O
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: DELPHI TERMINAL DELPHI CRIMP SPECIFICATION	
TERMINAL NAME: 0.64 MICRO TERMINAL SYSTEM II	
WIRE STRIP LENGTH 3.00-3.76 mm [.118-.148 IN]	TERMINAL INSULATION DIAMETER RANGE Ø1.20-1.70 mm [.047-.067 IN]
TERMINAL APPLICATION SPECIFICATION 15440183 PG 2 Rev 2013-10-30	-
TERMINALS APPLIED	
TE TERMINAL 3311167-1	DELPHI TERMINAL 15440183
TE TERMINAL 3311167-2	DELPHI TERMINAL 15440179

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.50mm2	1.05+/-0.05 [.041+/-0.002]	6.4
0.35mm2	0.95+/-0.05 [.037+/-0.002]	7.4

- 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.
- THIS APPLICATOR DOES NOT CUT THE CARRIER STRIP.

***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)

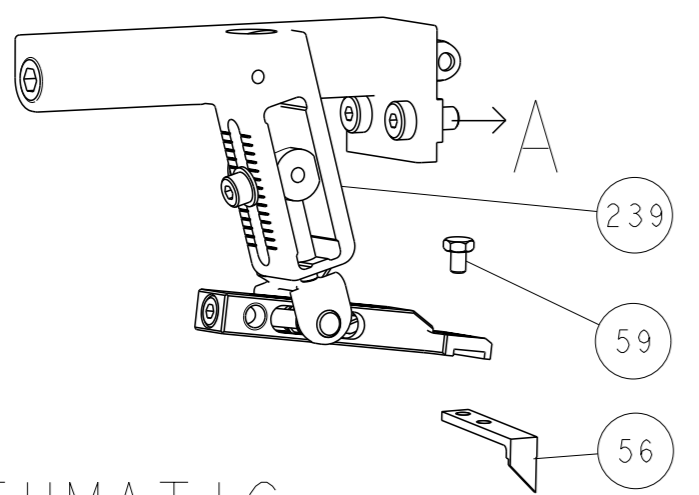
LOC	DIST	REV	DATE	BY	APPV
A	66				

REV	DATE	BY	APPV	DESCRIPTION	ITEM NO
-	-	-	-	SEE SHEET 1	-
-	1	1		2119791-5 DEPRESSOR, WIRE	286
-	1	1		2119082-5 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		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		1338685-1 PAWL, FEED	56
-	2	2		2168083-2 SCR, SKT HD CAP, RoHS, M4 X 8.0	53
-	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		1752356-6 SUPPORT, TERMINAL	34
-	2	2		2079383-5 SCR, BHSC, RoHS (M4 X 20)	33
-	2	2		2-2844962-6 SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1		2844992-1 ASSEMBLY, STRIP GUIDE	29
-	1	1		455888-4 SPACER, CRIMPER	28
-	1	1		1320928-2 STRIP GUIDE	24
-	1	1		2168083-2 SCR, SKT HD CAP, RoHS, M4 X 8.0	21
-	4	4		1-18028-2 WASHER, FLAT, REG M4	20
-	1	1		2119533-1 STRIPPER, SIDE FEED	19
-	1	1		5-690518-8 HOLD DOWN, TERMINAL	18
-	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		1803095-6 FLOATING SHEAR, FRONT	9
-	1	1		1-1803703-7 ANVIL, COMBINATION	8
-	1	1		6-240641-3 SPACER	7
-	-	-		-	6
-	1	1		1-2119757-8 DEPRESSOR, SHEAR	5
-	1	1		1-238011-0 BLOCK, CRIMPER SPACER	4
-	1	1		1803712-3 CRIMPER, INSULATION O	3
-	1	1		455888-6 SPACER, CRIMPER	2
-	1	1		7-456402-4 CRIMPER, WIRE PREMIUM	1
-	77	22	21	PART NO	
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-	-	-	-	ITEM NO	

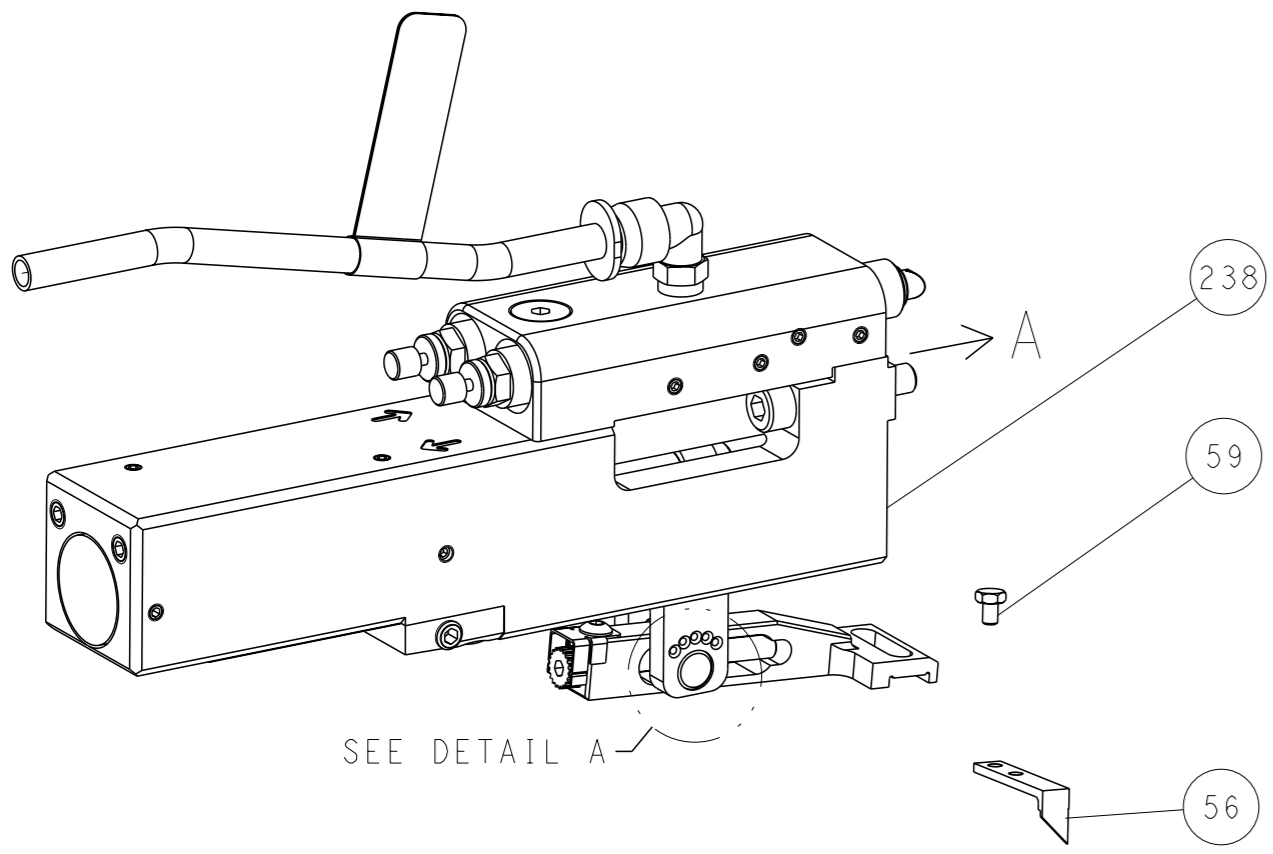
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1 PLC	±	0.25	±	APVD: J. ELBIN 23MAR2018	
2 PLC	±	0.38	±		
3 PLC	±	0.51	±		
4 PLC	±	0.64	±		
5 PLC	±	0.76	±		
6 PLC	±	0.89	±		
7 PLC	±	1.02	±		
8 PLC	±	1.14	±		
9 PLC	±	1.27	±		
10 PLC	±	1.40	±		
11 PLC	±	1.52	±		
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13 PLC	±	1.78	±		
14 PLC	±	1.90	±		
15 PLC	±	2.03	±		
16 PLC	±	2.15	±		
17 PLC	±	2.28	±		
18 PLC	±	2.40	±		
19 PLC	±	2.53	±		
20 PLC	±	2.65	±		
21 PLC	±	2.78	±		
22 PLC	±	2.90	±		
23 PLC	±	3.03	±		
24 PLC	±	3.15	±		
25 PLC	±	3.28	±		
26 PLC	±	3.40	±		
27 PLC	±	3.53	±		
28 PLC	±	3.65	±		
29 PLC	±	3.78	±		
30 PLC	±	3.90	±		
31 PLC	±	4.03	±		
32 PLC	±	4.15	±		
33 PLC	±	4.28	±		
34 PLC	±	4.40	±		
35 PLC	±	4.53	±		
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38 PLC	±	4.90	±		
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40 PLC	±	5.15	±		
41 PLC	±	5.28	±		
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73 PLC	±	9.28	±		
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95 PLC	±	12.03	±		
96 PLC	±	12.15	±		
97 PLC	±	12.28	±		
98 PLC	±	12.40	±		
99 PLC	±	12.53	±		
100 PLC	±	12.65	±		

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

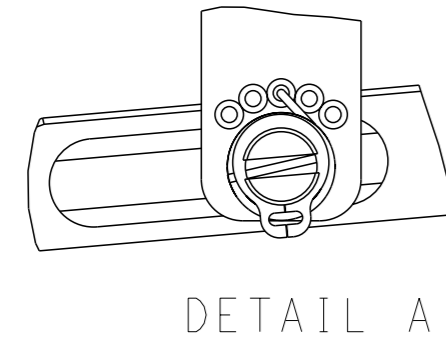
FEED TYPE MECHANICAL



PNEUMATIC

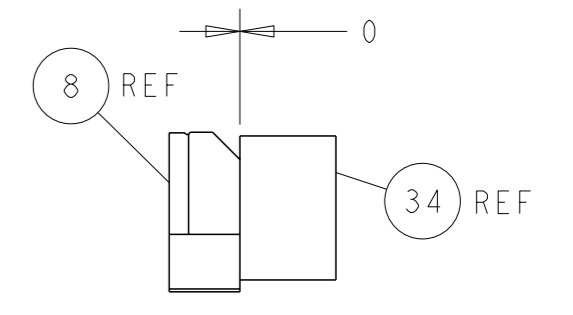
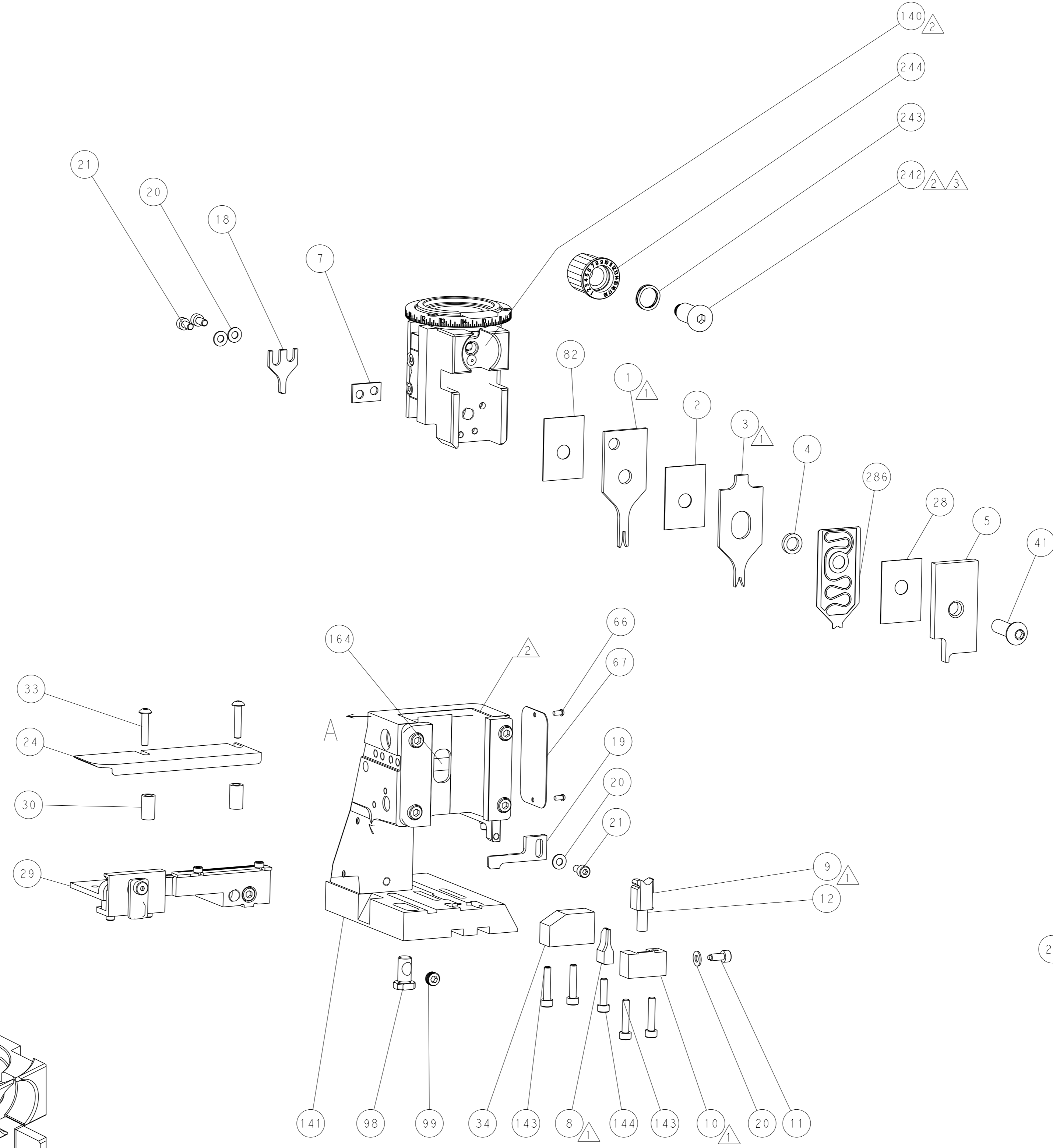
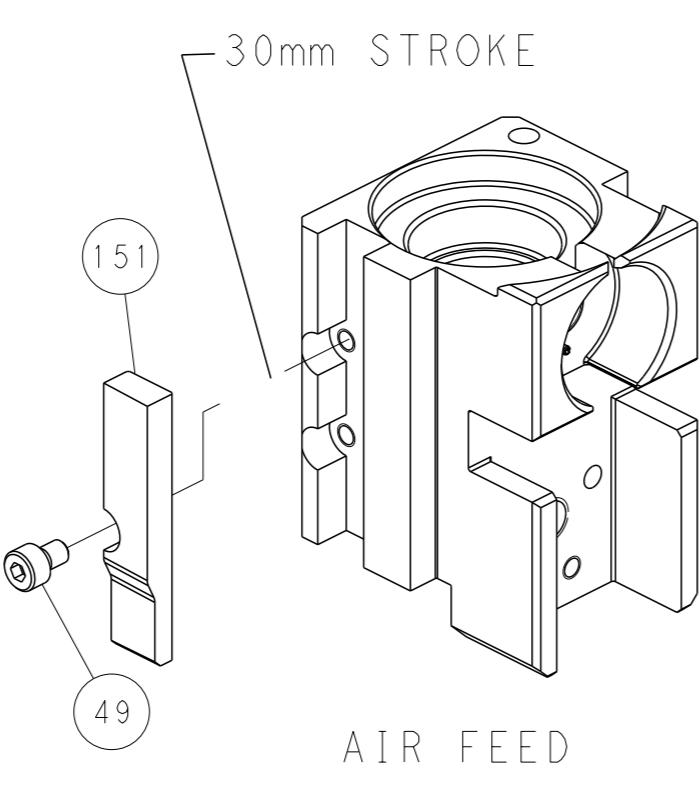
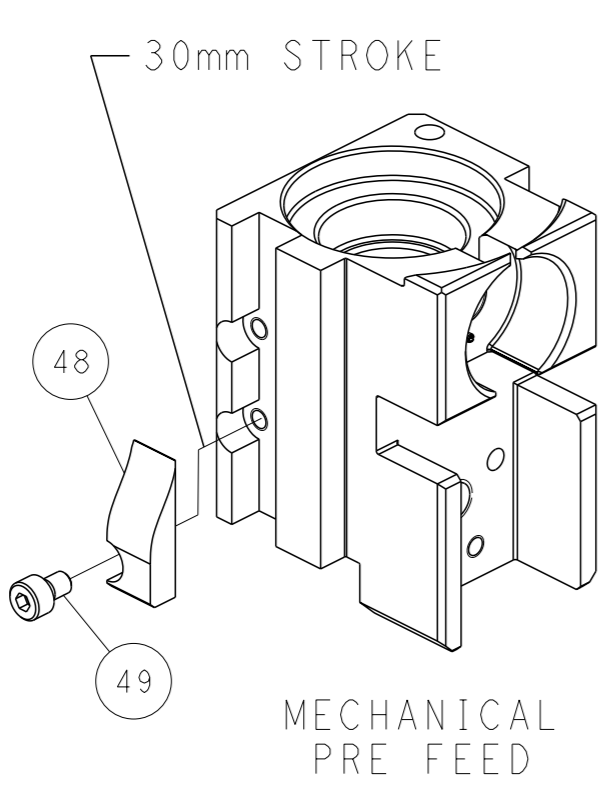
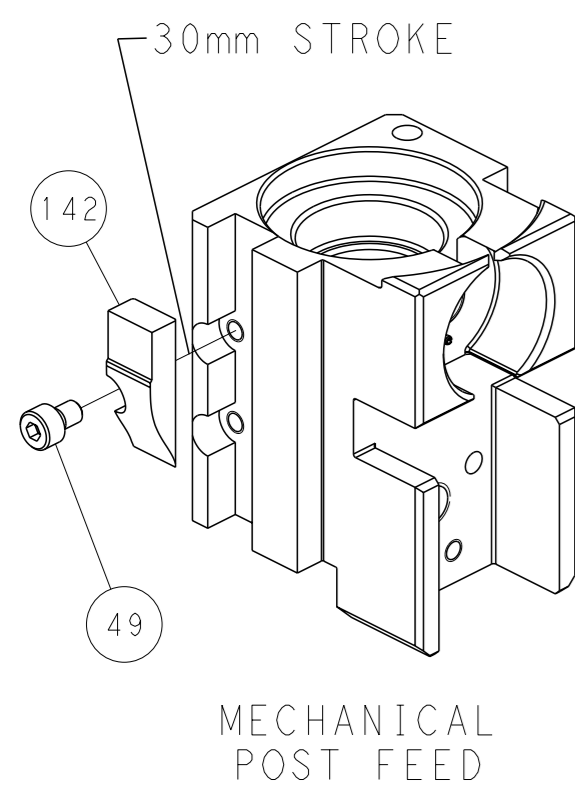


FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)

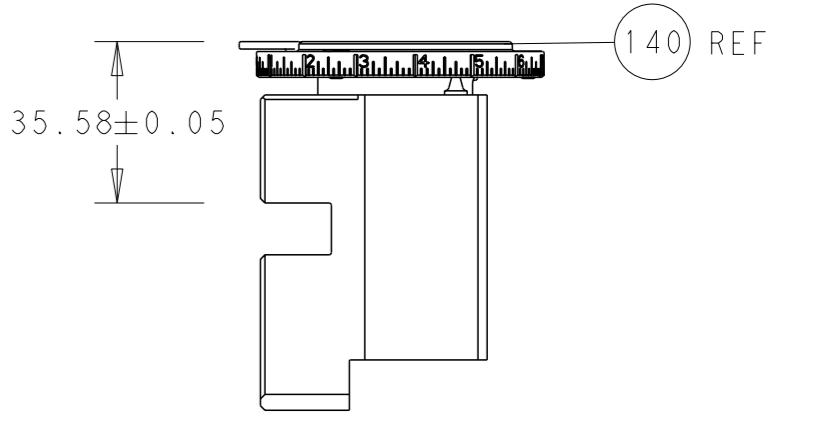


DETAIL A

CAM POSITIONS

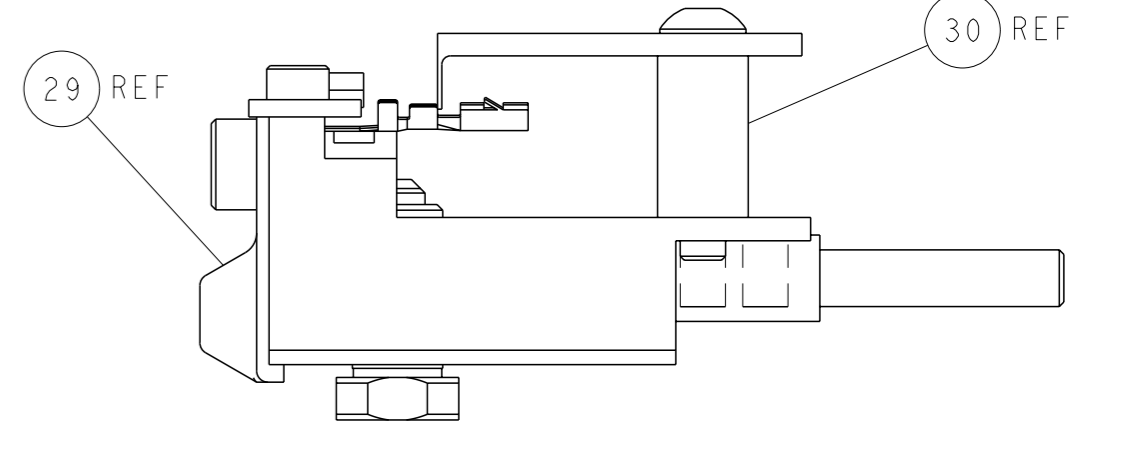


TERMINAL SUPPORT LOCATION



RAM SET-UP

ITEM 30 LOCATED AT FRONT HOLES



FEED TRACK POSITION GUIDE BY WIRE BARREL

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>		DWN T. BROOKS 23MAR2018 CHK M. HERR 23MAR2018 APVD T. ELBIN 23MAR2018	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-2837211 WEIGHT Customer Accessible Production Drawing	RESTRICTED TO SCALE 1:2 SHEET 4 OF 4 REV C