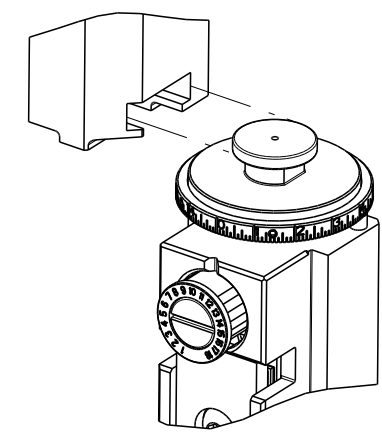


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2837442-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2837442-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2837442-1	C	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2837442-2	C	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2837442-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER

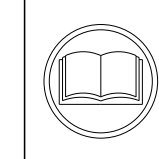


APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.95 mm [.116]	F
INSUL	3.90 mm [.154]	O

APPLICATOR INSTRUCTIONS 408-35042

TERMINAL DATA: AMPPHENOL TERMINAL MC ELECT. CRIMP SPECIFICATION			
TERMINAL NAME: ECO-MATE, SOCKET CONTACT			
WIRE STRIP LENGTH		TERMINAL INSULATION DIAMETER RANGE	
5.17-5.93 mm [.203-.233 IN]		∅2.54-3.30 mm [.100-.130 IN]	
TERMINAL APPLICATION SPECIFICATION		2018-U544-0553 PG2 Rev 9/4/18	
TERMINALS APPLIED			
TE TERMINAL	AMPPHENOL TERMINAL	TE TERMINAL	AMPPHENOL TERMINAL
3311345-1	SS12A1T	3311345-4	SS12A1G15
3311345-2	SS12A1F	3311345-5	SS12A1G30
3311345-3	SS12A1G10		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
12 AWG	1.93 +/- 0.05 [0.076 +/- .002]	6.0
14 AWG	1.61 +/- 0.05 [0.063 +/- .002]	9.8



- 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.

***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)

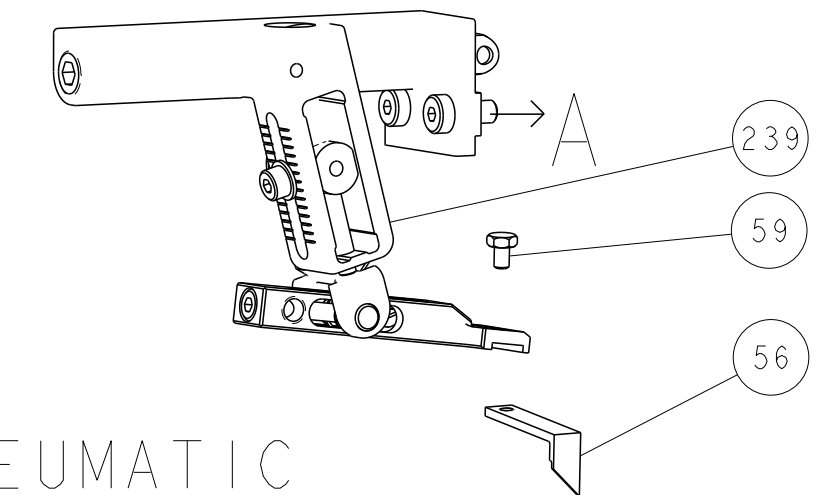
LOC	DIST	REVISIONS					
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		A		RELEASE	07DEC2018	MEH	CT
		B		ECR-21-119979	05NOV2021	TB	RK
		C		ECR-22-128342	01FEB2022	JWC	GB

-	1	1	1	1	1803078-4	SPACER, PRECISION	259	
-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248	
-	1	1	1	1	2119082-4	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	455888-8	SPACER, CRIMPER	82	
-	1	1	1	1	1803607-3	DOCUMENTATION PACKAGE	71	
-	1	1	1	1	2119791-5	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	1338683-8	FEED PAWL	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	1803515-2	RAM ASSEMBLY, SF ATLANTIC	44	
-	1	1	1	1	1803602-2	SCR, BHSC, RoHS (M8 X 40)	41	
-	1	1	1	1	1-1803946-2	SUPPORT, TERMINAL	34	
-	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33	
-	2	2	2	2	3-2844962-0	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	2119533-1	STRIPPER, SIDE FEED	19	
-	1	1	1	1	4-690518-9	HOLD DOWN, TERMINAL	18	
-	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	2119805-1	SHEAR HOLDER, FRONT	10	
-	1	1	1	1	1803095-6	FLOATING SHEAR, FRONT	9	
-	1	2	2	1	1803763-4	COMBINATION, ANVIL	8	
-	-	-	-	-	-	-	7	
-	-	-	-	-	-	-	6	
-	1	1	1	1	2119757-6	DEPRESSOR, SHEAR	5	
-	1	1	1	1	3-238011-1	BLOCK, CRIMPER SPACER	4	
-	1	2	2	1	1-1803143-0	CRIMPER, INSULATION O	3	
-	1	1	1	1	455888-4	SPACER, CRIMPER	2	
-	1	2	2	1	2-1803482-5	CRIMPER, WIRE	1	
-	77	72	71	2	-1	PART NO	DESCRIPTION	ITEM NO

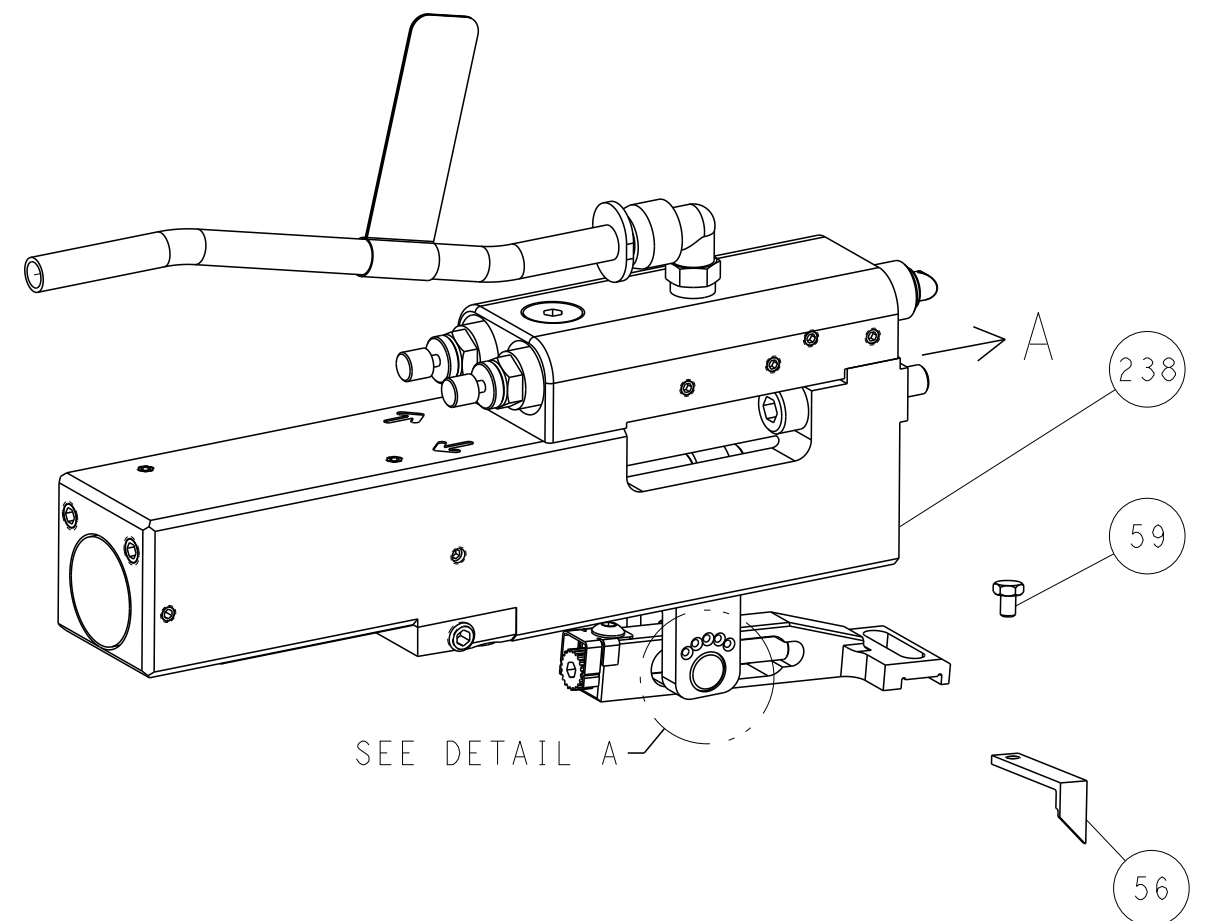
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		OWN	M. HERR	05OCT2018	TE Connectivity	
mm		0 PLC	±	CHK	T. ELBIN	05OCT2018	Harrisburg, PA 17105-3608	
		1 PLC	±	APVD	B. RAIB	05OCT2018	NAME	
		2 PLC	±	PRODUCT SPEC		Ocean Side Feed		
		3 PLC	±	APPLICATION SPEC		Applicator		
		4 PLC	±			SIZE		
		ANGLES	±			CAGE CODE		
		FINISH	±			DRAWING NO		
MATERIAL				WEIGHT		A1 00779		RESTRICTED TO
						C=2837442		
						Customer Accessible Production Drawing		SCALE
						1:2		SHEET
						1		OF
						4		REV
						C		

REVISONS		DATE	OWN	APVD
LOC	DIST			
A	66			
P	LTM			
		SEE SHEET 1		

FEED TYPE MECHANICAL



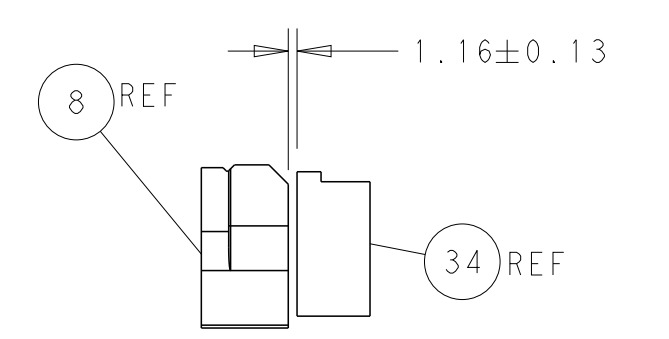
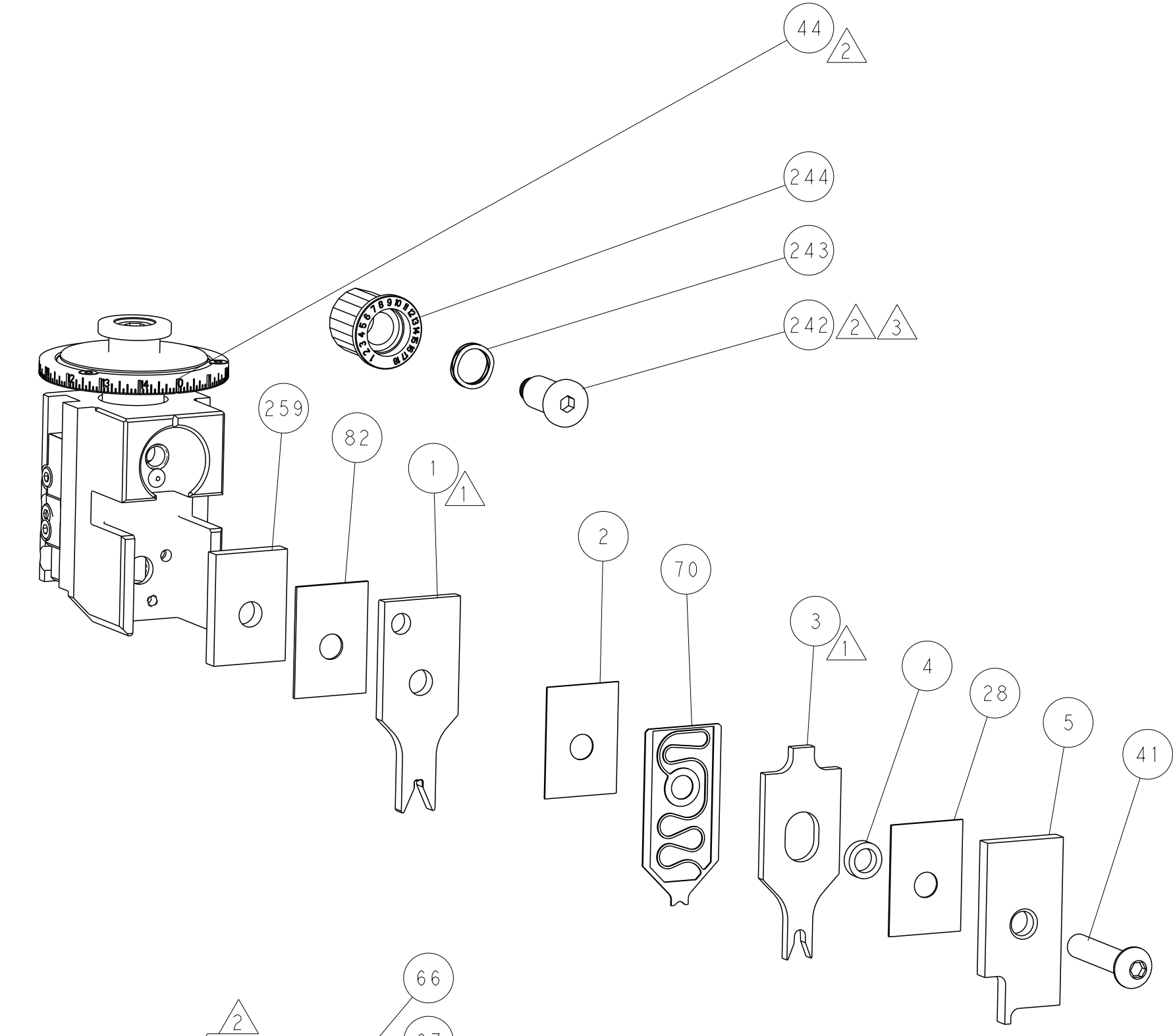
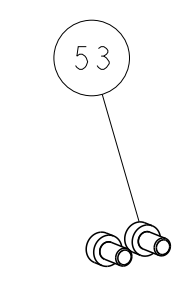
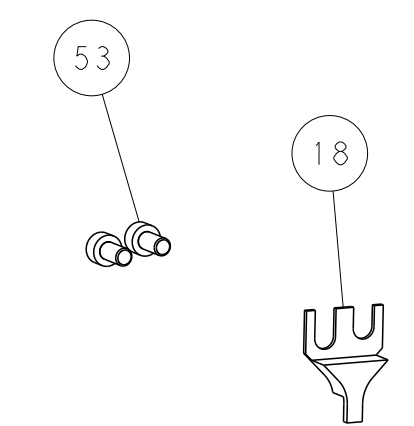
PNEUMATIC



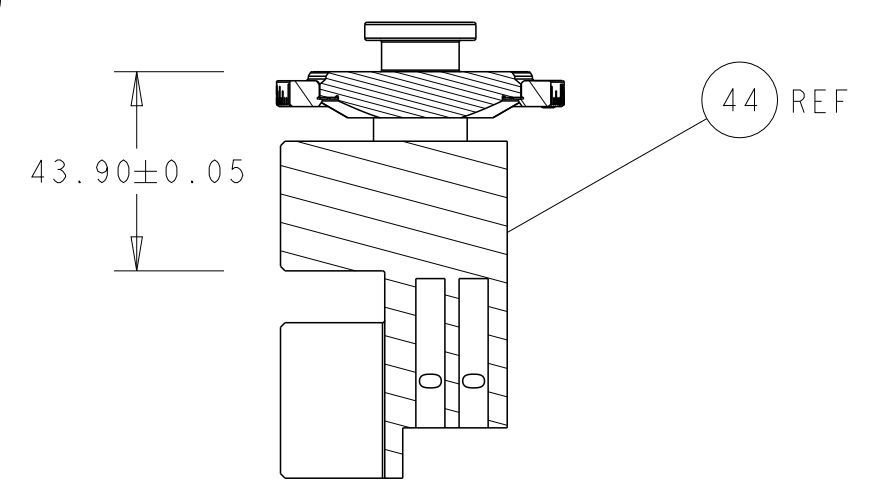
FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



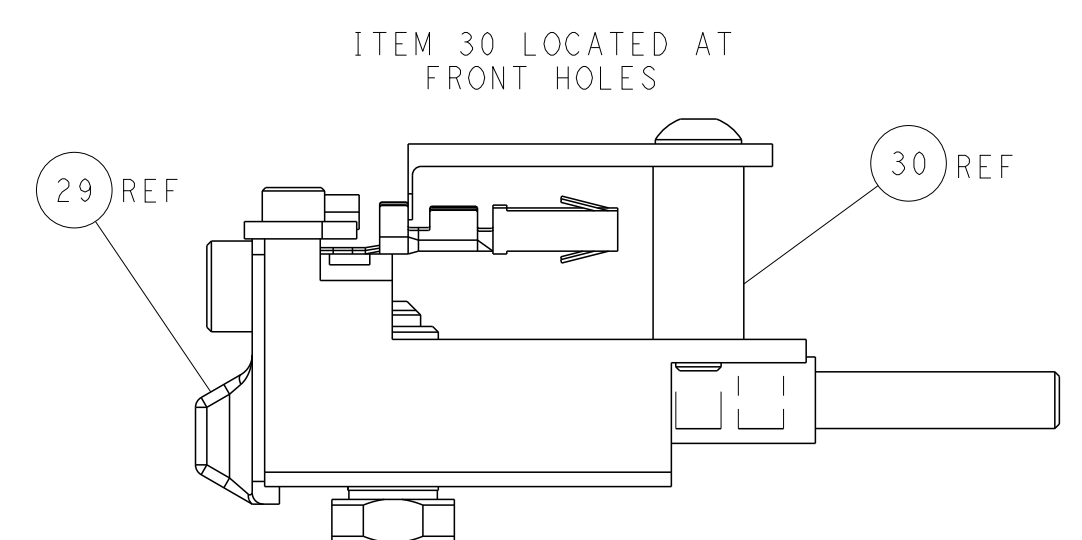
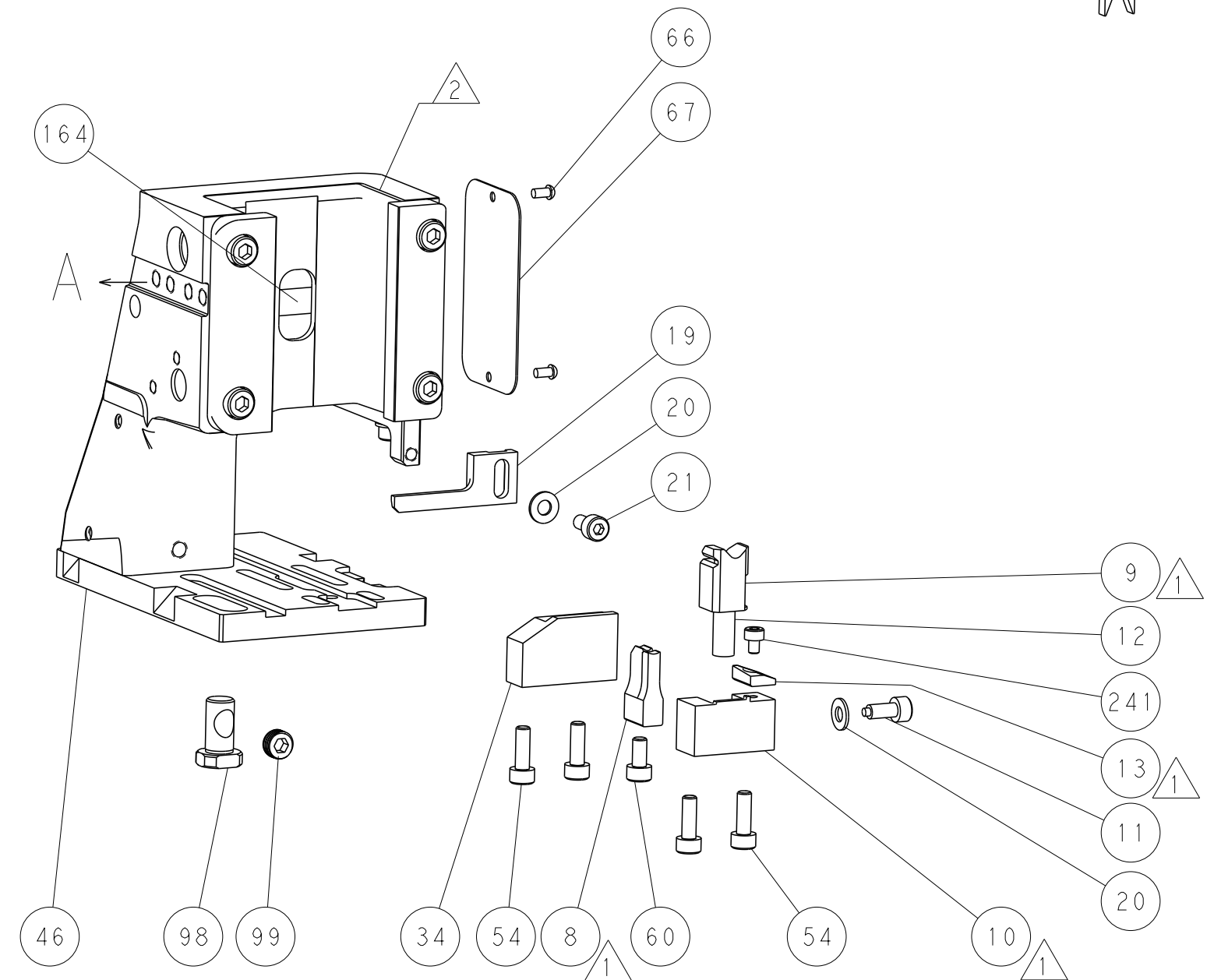
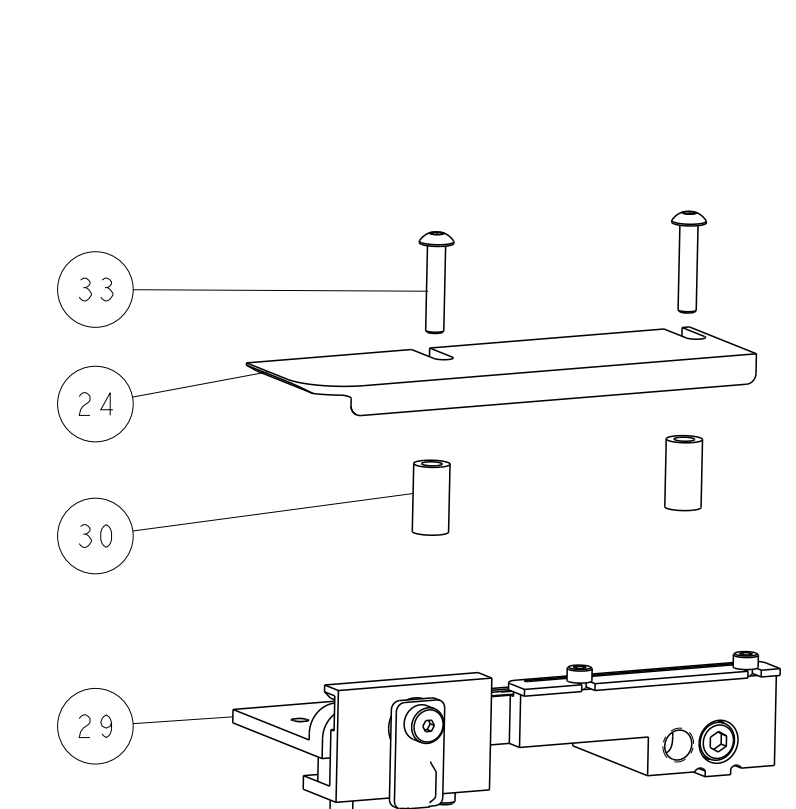
DETAIL A



TERMINAL SUPPORT LOCATION

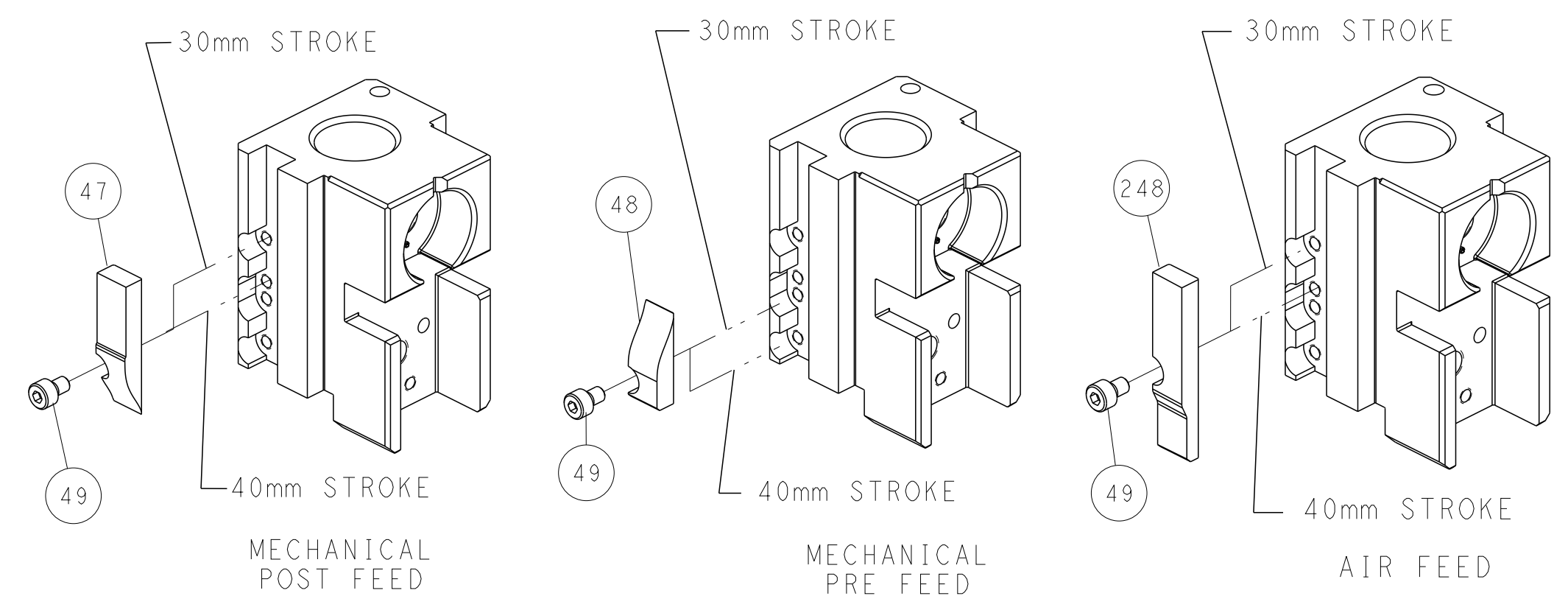


RAM SET-UP



FEED TRACK POSITION GUIDE BY INSULATION 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)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG: M_HERR 05OCT2018		TE Connectivity	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	Harrisburg, PA 17105-3608	
	ANGLES	FINISH		CHK: T_ELBIN 05OCT2018		NAME: Ocean Side Feed Applicator	
MATERIAL:				APVD: B_RAIR 05OCT2018		SIZE: CAGE CODE: DRAWING NO: RESTRICTED TO	
				PRODUCT SPEC		A1 00779 ©=2837442	
				APPLICATION SPEC		Customer Accessible Production Drawing	
				WEIGHT		SCALE: 1:2 SHEET 2 OF 4 REV C	

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2837442-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2837442-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2837442-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.95 mm [.116]	F
INSUL	3.90 mm [.154]	O

APPLICATOR INSTRUCTIONS
408-35042

TERMINAL DATA: AMPHENOL TERMINAL MC ELECT. CRIMP SPECIFICATION			
TERMINAL NAME: ECO-MATE, SOCKET CONTACT			
WIRE STRIP LENGTH		TERMINAL INSULATION DIAMETER RANGE	
5.17-5.93 mm [.203-.233 IN]		2.54-3.30 mm [.100-.130 IN]	
TERMINAL APPLICATION SPECIFICATION	2018-U544-0553 PG2 Rev 9/4/18		
TERMINALS APPLIED			
TE TERMINAL	AMPPHENOL TERMINAL	TE TERMINAL	AMPPHENOL TERMINAL
3311345-1	SS12A1T	3311345-4	SS12A1G15
3311345-2	SS12A1F	3311345-5	SS12A1G30
3311345-3	SS12A1G10		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
12 AWG	1.93+/-0.05 [.076+/-0.002]	6.0
14 AWG	1.61+/-0.05 [.063+/-0.002]	9.8

- 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.
5. 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.

LOC	DIST	REV	DATE	BY	APPV
A	66				

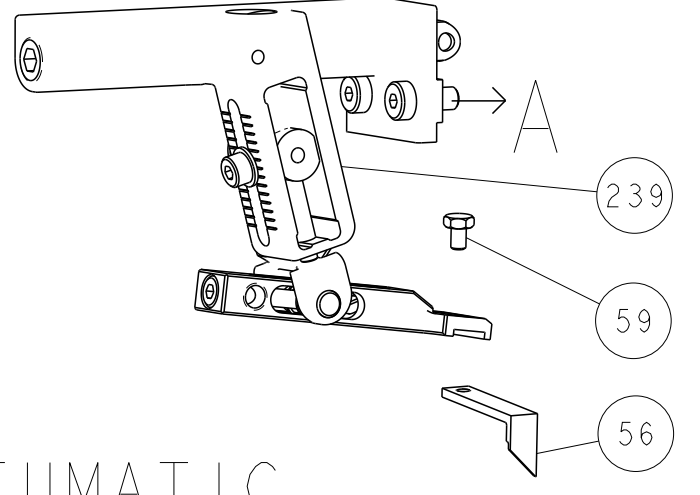
REV	DATE	BY	APPV	DESCRIPTION	ITEM NO
-	1	1		1803078-4 SPACER, PRECISION	259
-	1	1		2119082-4 CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1		2079764-1 WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1		2119083-1 RETAINER, INSULATION DIAL	242
-	1	1		7-18023-7 SCR, SKT HD CAP M3 X 4.0	241
-	-	1		2119580-1 MECHANICAL 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		455888-8 SPACER, CRIMPER	82
-	1	1		1803607-3 DOCUMENTATION PACKAGE	71
-	1	1		2119791-5 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		1338683-8 FEED PAWL	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		1803602-2 SCR, BHSC, RoHS (M8 X 40)	41
-	1	1		1-1803946-2 SUPPORT, TERMINAL	34
-	2	2		2079383-5 SCR, BHSC, RoHS (M4 X 20)	33
-	2	2		3-2844962-0 SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1		2844992-1 ASSEMBLY, STRIP GUIDE	29
-	1	1		455888-5 SPACER, CRIMPER	28
-	1	1		1320928-2 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		4-690518-9 HOLD DOWN, TERMINAL	18
-	1	1		2119806-1 INSERT, SHEAR	13
-	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		1803763-4 COMBINATION, ANVIL	8
-	-	-		-	7
-	-	-		-	6
-	1	1		2119757-6 DEPRESSOR, SHEAR	5
-	1	1		3-238011-1 BLOCK, CRIMPER SPACER	4
-	1	1		1-1803143-0 CRIMPER, INSULATION O	3
-	1	1		455888-4 SPACER, CRIMPER	2
-	1	1		2-1803482-5 CRIMPER, WIRE	1

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

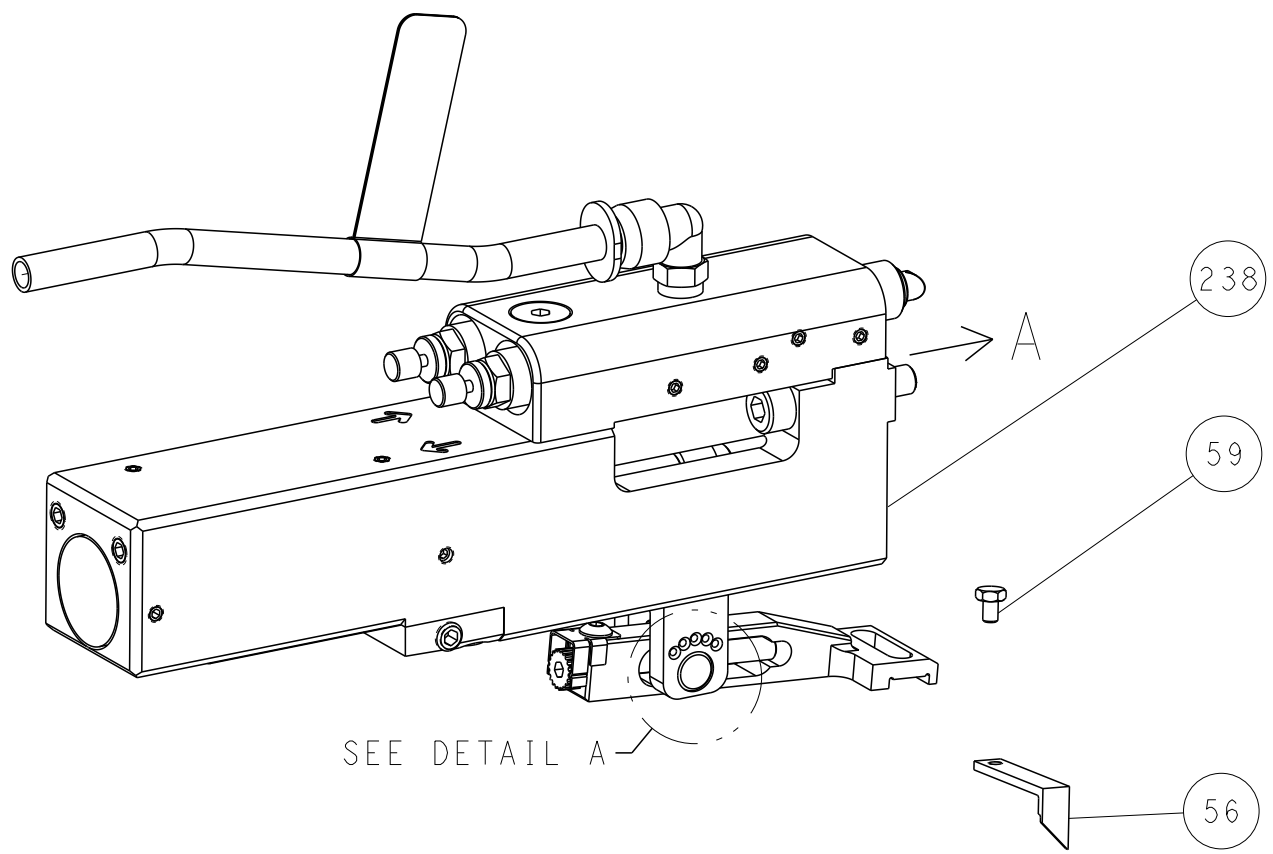
<small>THIS DRAWING IS UNPUBLISHED. IT IS THE PROPERTY OF TYCO ELECTRONICS CORPORATION. IT IS TO BE KEPT IN CONFIDENTIALITY AND NOT TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, INCLUDING PHOTOCOPYING, RECORDING, OR BY ANY INFORMATION STORAGE AND RETRIEVAL SYSTEM. PERMISSION TO REPRODUCE THIS DRAWING FOR THE LATEST REVISION SHOULD BE CONTACTED FOR THE LATEST REVISION.</small>		DWN: M_HERR 05OCT2018 CHK: T_ELBIN 05OCT2018 APVD: B_RABR 05OCT2018	TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH ±		TOLERANCES UNLESS OTHERWISE SPECIFIED: ±.005 ±.01 ±.02 ±.03 ±.04 ±.05 ±.06 ±.07 ±.08 ±.09 ±.10	NAME: Ocean Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2837442 SCALE: 1:2 SHEET: 3 OF 4 REV: C
MATERIAL: - FINISH: -		APPLICATION SPEC: - WEIGHT: -	RESTRICTED TO: - Customer Accessible Production Drawing

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

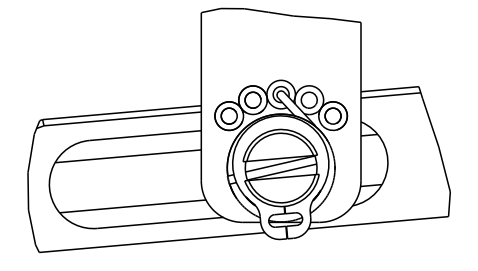
FEED TYPE MECHANICAL



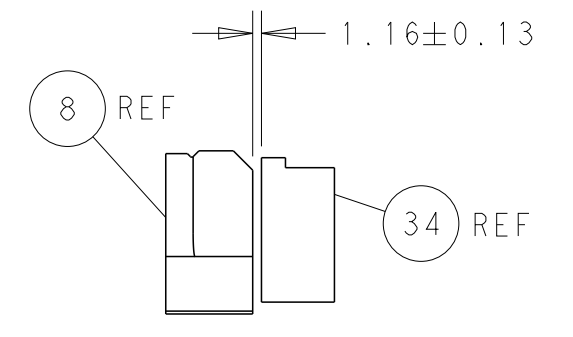
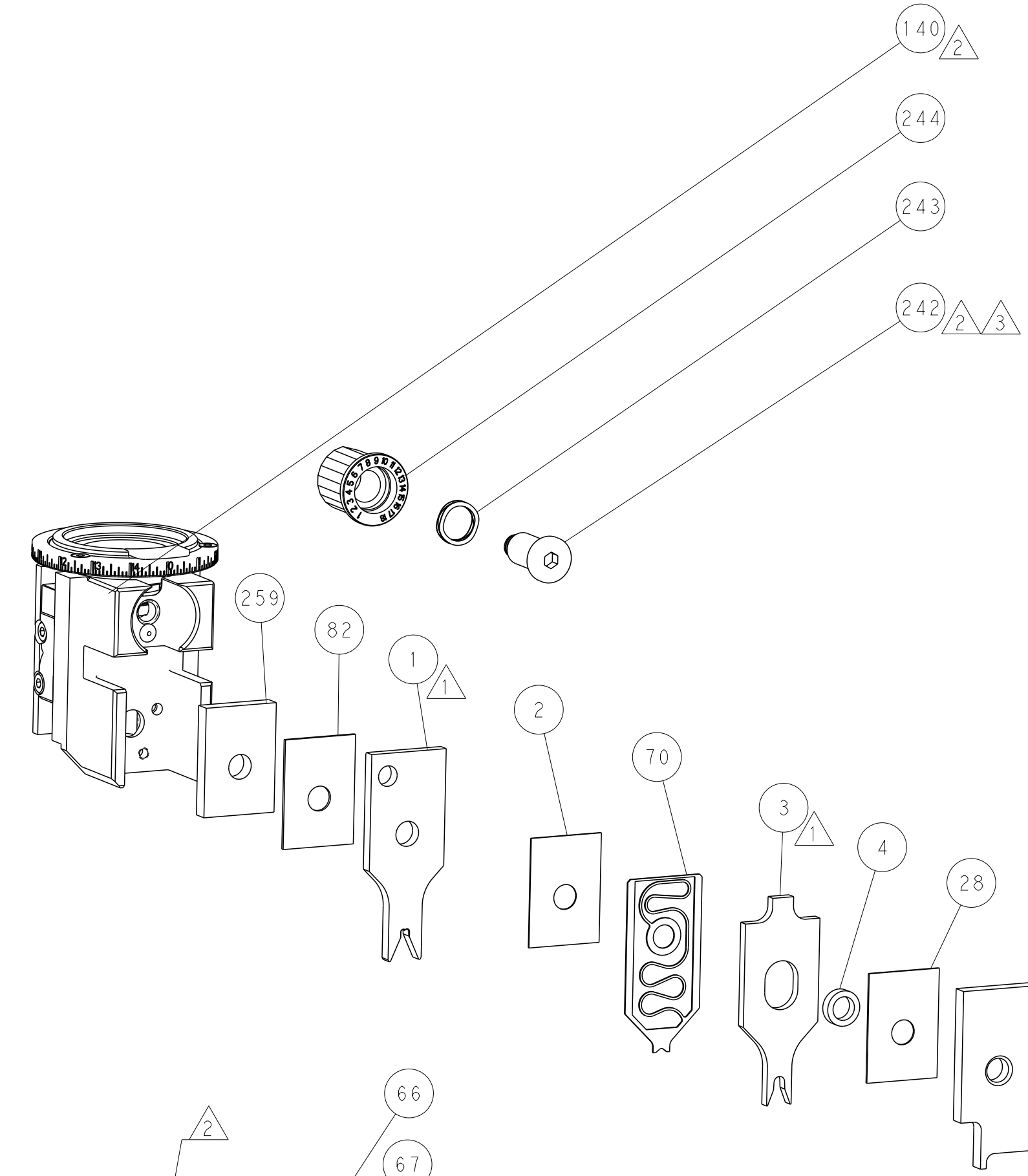
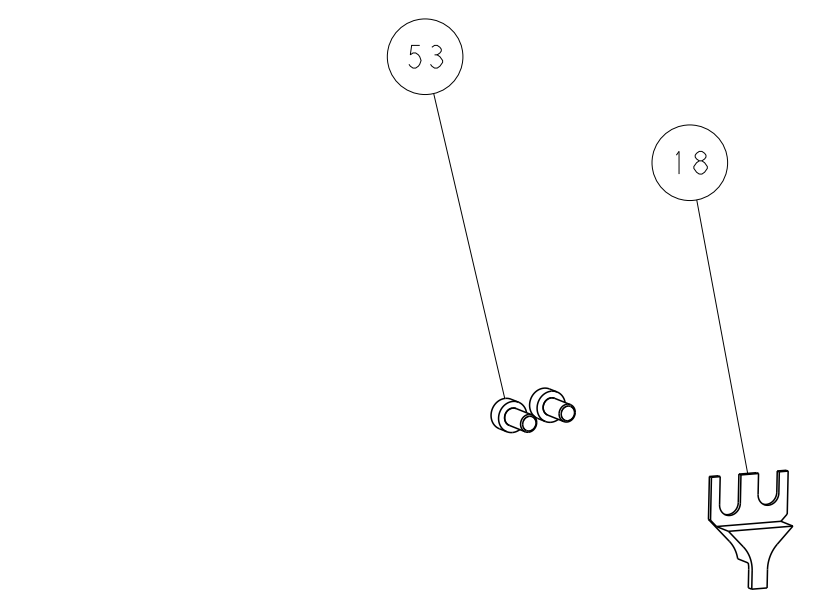
PNEUMATIC



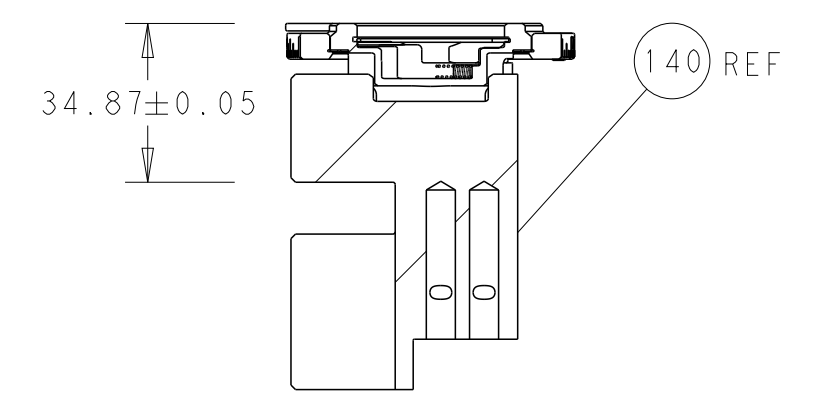
FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



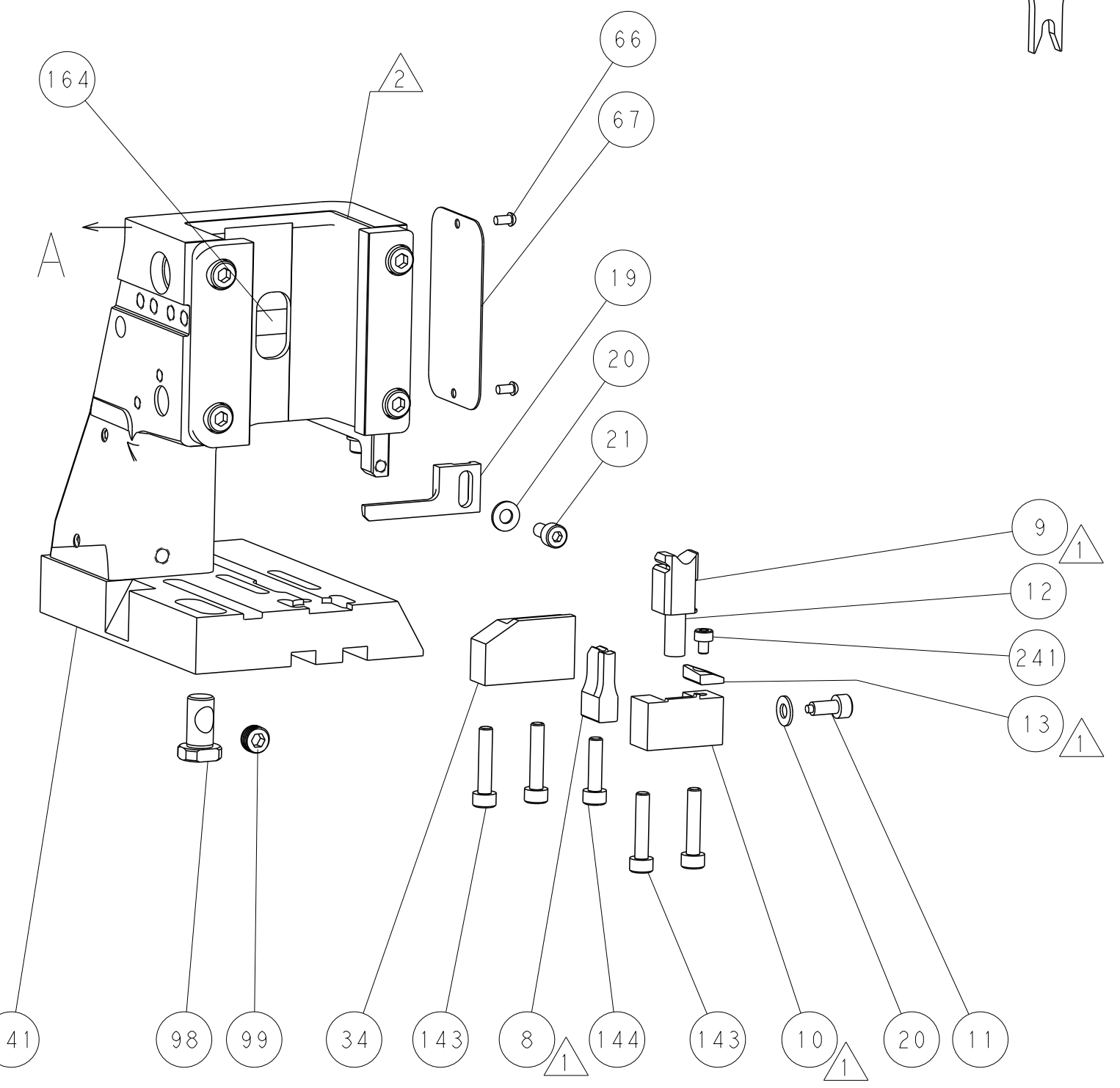
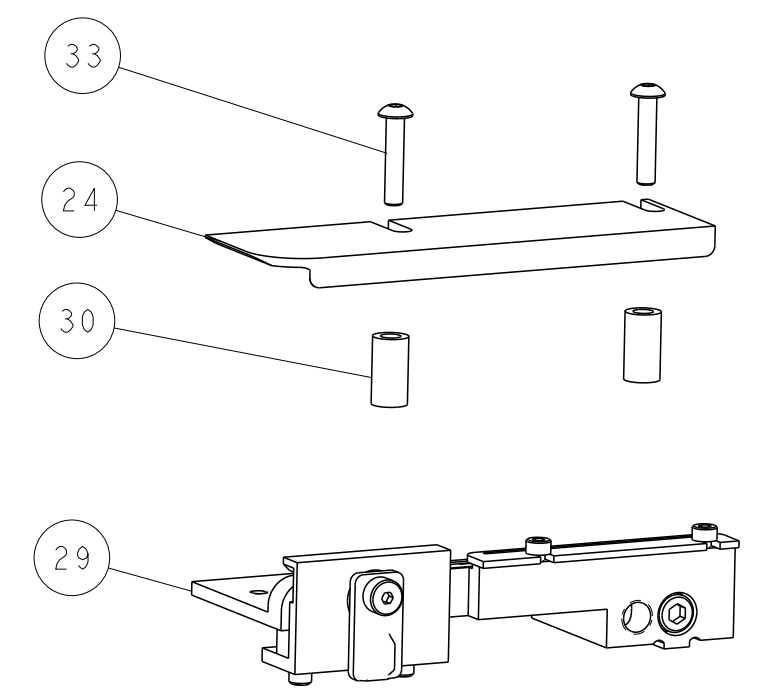
DETAIL A



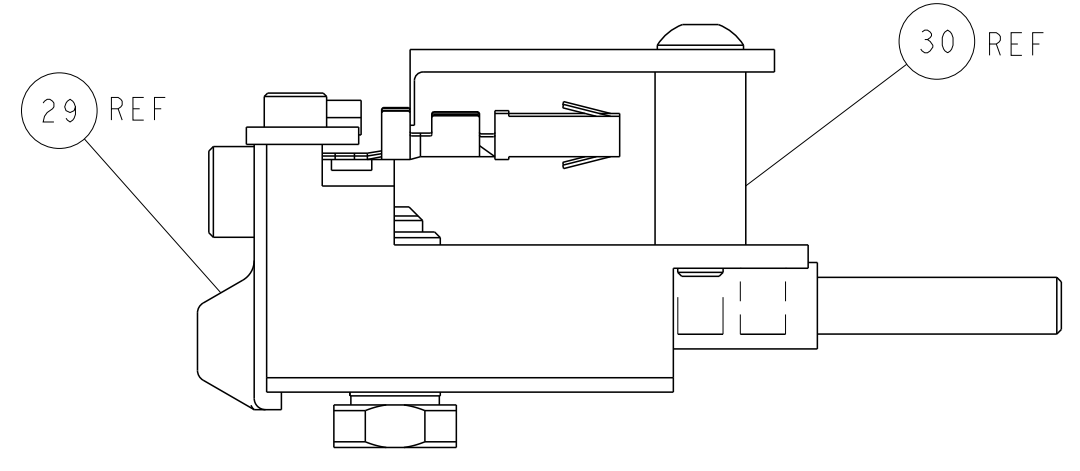
TERMINAL SUPPORT LOCATION



RAM SET-UP

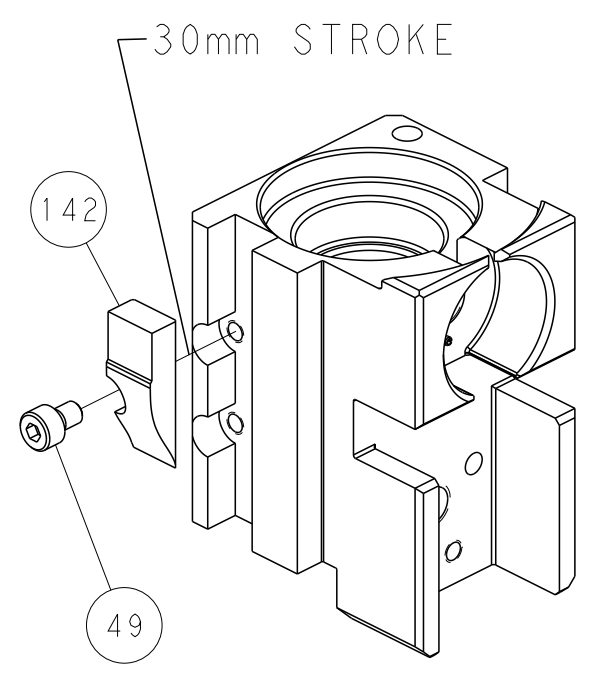


ITEM 30 LOCATED AT
FRONT HOLES

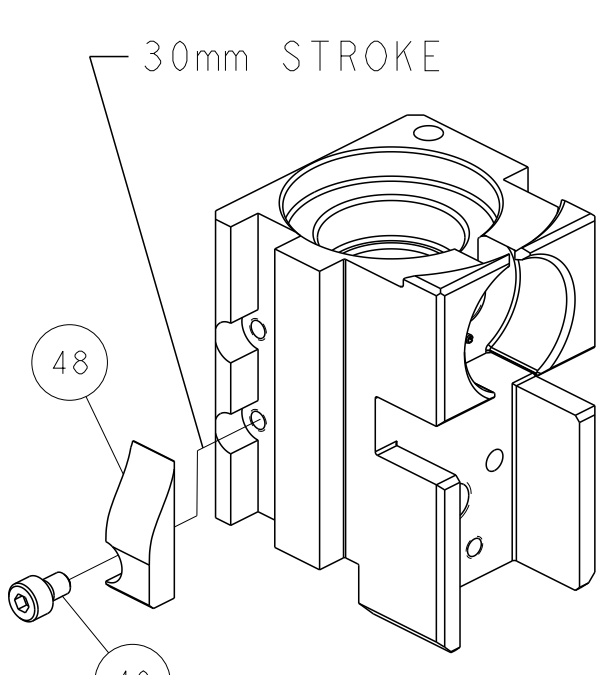


FEED TRACK POSITION
GUIDE BY INSULATION BARREL

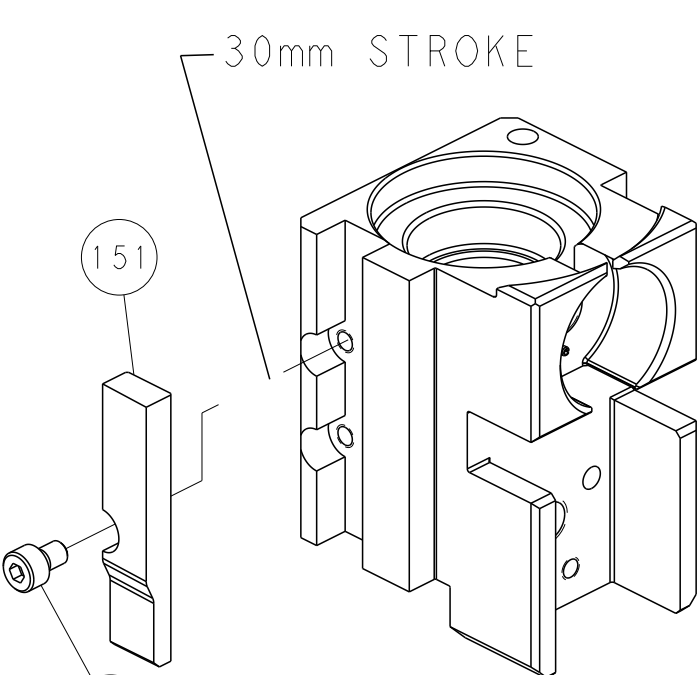
CAM POSITIONS



MECHANICAL
POST FEED



MECHANICAL
PRE FEED



AIR FEED

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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