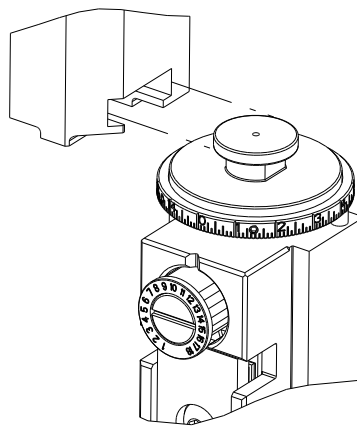


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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2836736-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2836736-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2836736-1	C	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2836736-2	C	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2836736-7	C	CRIMP TOOLING KIT	-

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.73 mm [.068]	F
INSUL	2.90 mm [.114]	Ø
APPLICATOR INSTRUCTIONS 408-35042		



TERMINAL DATA: DELPHI TERMINAL		DELPHI PACKARD CRIMP SPECIFICATION	
TERMINAL NAME: TAXI TERM F GT 150 SEALED			
WIRE STRIP LENGTH 4.75-5.51 mm [.187-.217 IN]		TERMINAL INSULATION DIAMETER RANGE Ø -	
TERMINAL APPLICATION SPECIFICATION		15396680 PAGE 1 OF 5 Rev 2014-07-29	
-		-	
TERMINALS APPLIED			
TE TERMINAL	DELPHI TERMINAL	TE SEAL	DELPHI SEAL
2318268-1	15396680	286970-1	15366021
		286970-3	7165-0045

WIRE SIZE			CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING 
0.50mm ²			1.10+/-0.05 [1.043+/-0.002]		6.8
0.35mm ²			1.00+/-0.05 [1.039+/-0.002]		7.8

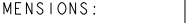


1. RECOMMENDED SPARE PARTS
2. REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
3. APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242.
4. CRIMP HEIGHT REFERENCE SETTING WAS THE SETTING USED WHEN THE APPLICATOR WAS QUALIFIED AT THE FACTORY. ADJUSTMENT MAY BE NECESSARY WHEN RUNNING APPLICATOR IN THE FIELD.
5. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
6. APPLY TORQ-SEAL IN ALLEN SOCKET TO FILL HOLE AFTER FLAT HD HAS BEEN ADJUSTED TO CORRECT HEIGHT AT QUALIFICATION. APPLY #1-23419-5 LOC-TITE TO THREADS.

* 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	REVISIONS						
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			A	RELEASED	25MAY2017	LG	TE	
			B	ECR-19-004108	14MAR2019	FL	CT	
			C	WCR-21-119717	03NOV2021	TB	RK	

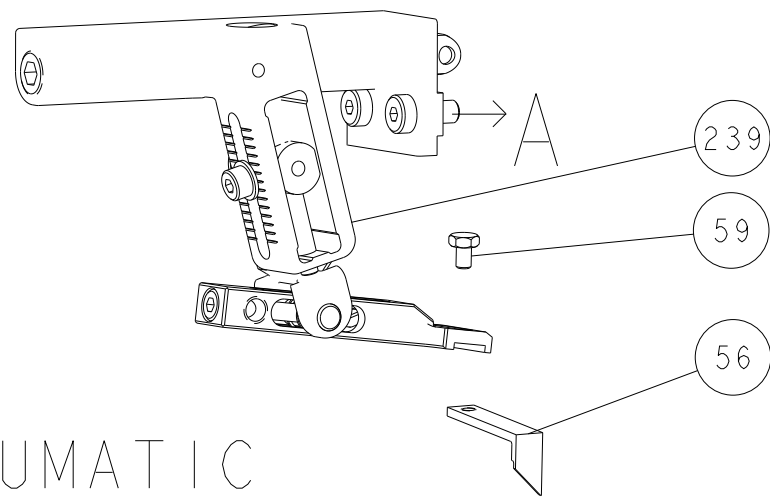
	-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	242
	-	1	1	1	1	2119082-4	CAM, SNAIL, INSULATION ADJUSTMENT	244
	-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
3	-	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
	-	1	1	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
	-	-	1	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
	-	1	-	1	-	2844940-1	AIR FEED MODULE	238
	-	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	455888-7	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	2119943-1	WASHER, SPACER	69
	-	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
6	-	1	1	1	1	985575-3	SCR, FLT SKT HD CAP M3 X 10.0	57
	-	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	2-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 14	53
	-	1	1	1	1	1803382-1	HOLD DOWN, SPRING LOADED	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	1-1752356-8	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	455888-3	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	1	2119806-1	INSERT, SHEAR	13
	-	1	1	1	1	3-22280-3	SPRING, COMPRESSION	12
	-	1	1	1	1	1-356885-5	STOP, SHEAR	11
1	-	1	1	1	1	2119805-1	SHEAR HOLDER, FRONT	10
1	-	1	1	1	1	318707-1	FLOATING SHEAR, FRONT	9
	1	2	2	1	1	7-1803252-1	ANVIL, COMBINATION	8
	-	1	1	1	1	240641-1	SPACER	7
	-	-	-	-	-	-	-	6
	-	1	1	1	1	2119781-1	DEPRESSOR, SHEAR	5
	-	1	1	1	1	4-238011-5	BLOCK, CRIMPER SPACER	4
1	1	2	2	1	1	7-1803019-8	CRIMPER, INSULATION O	3
	-	1	1	1	1	455888-3	SPACER, CRIMPER	2
1	1	2	2	1	1	2-1673600-4	CRIMPER, WIRE	1
	-77	-72	-71	-2	-1	PART NO	DESCRIPTION	ITEM NO

THIS DRAWING IS A CONTROLLED DOCUMENT FOR YOUR ELECTRONIC CORPORATION IF IT IS USED FOR ANY OTHER PURPOSE WITHOUT THE WRITTEN PERMISSION OF THE COMPANY IT IS THE USER'S RESPONSIBILITY TO OBTAIN THE LATEST REVISION.										OWN: B. WEAVER 20APR2017 CHK: T. ELBIN 20APR2017 APVD: T. ELBIN 20APR2017		 TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS:				TOLERANCES UNLESS OTHERWISE SPECIFIED:				NAME		Ocean Side Feed Applicator			
mm				0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±				PRODUCT SPEC		-			
				FINISH				APPLICATION SPEC		-			
MATERIAL				-				WEIGHT		-			
-				-				A1 00779 C=2836736		-			
Customer Accessible Production Drawing								SCALE		1:2			
								SHEET		1 OF 4			
								REV		C			

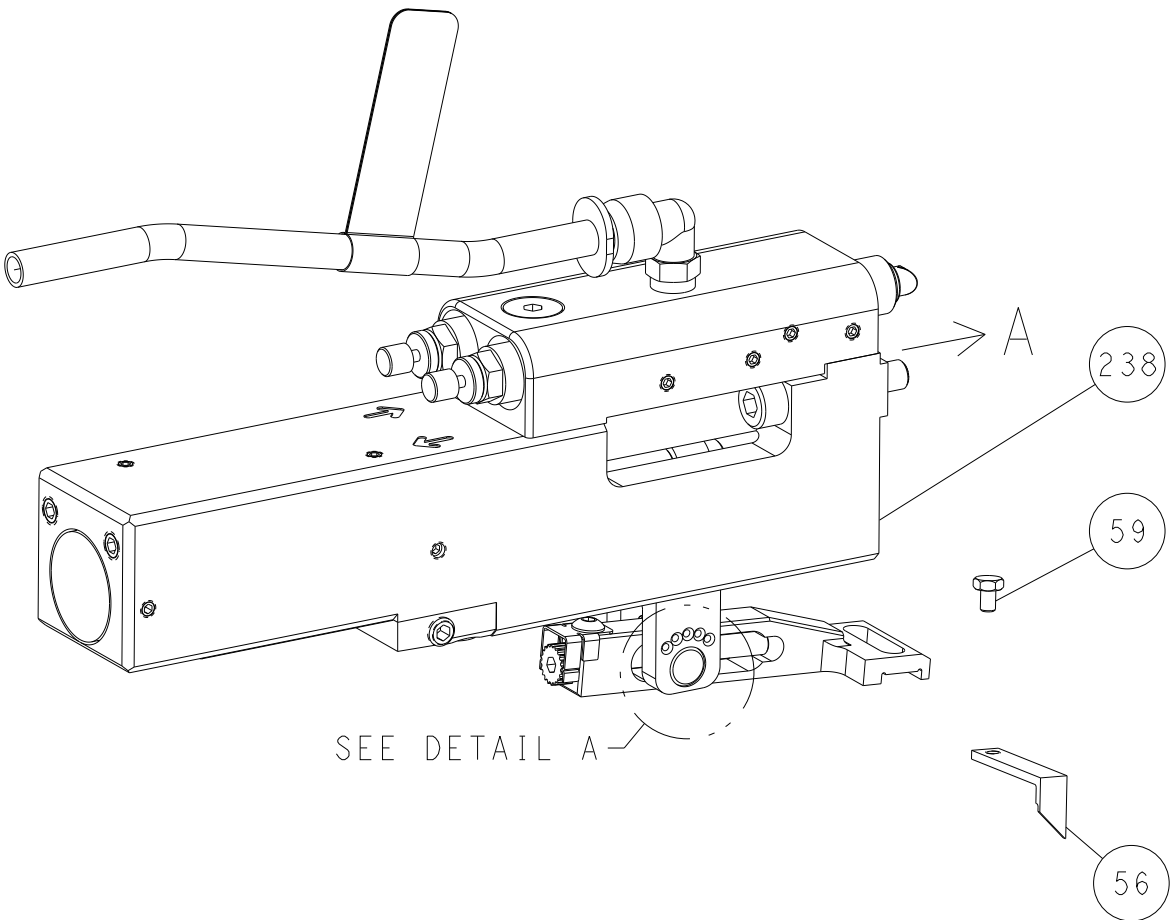
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

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

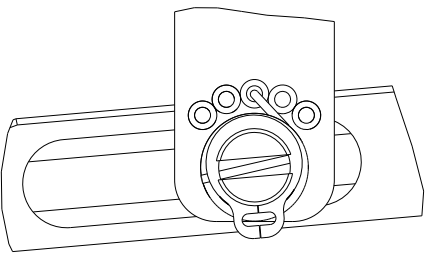
FEED TYPE MECHANICAL



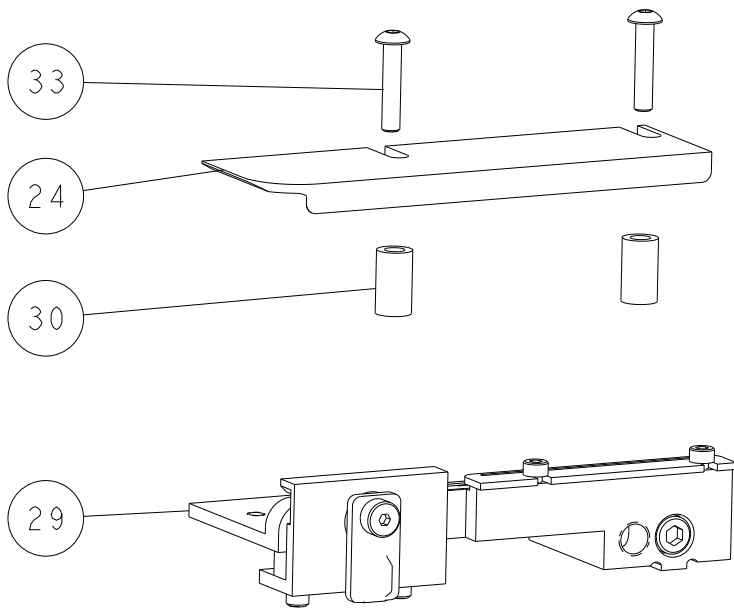
PNEUMATIC



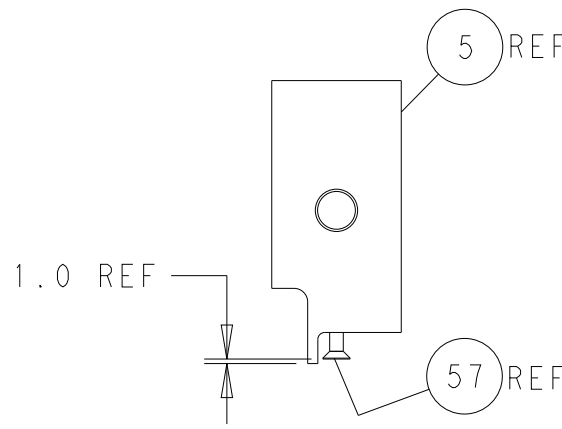
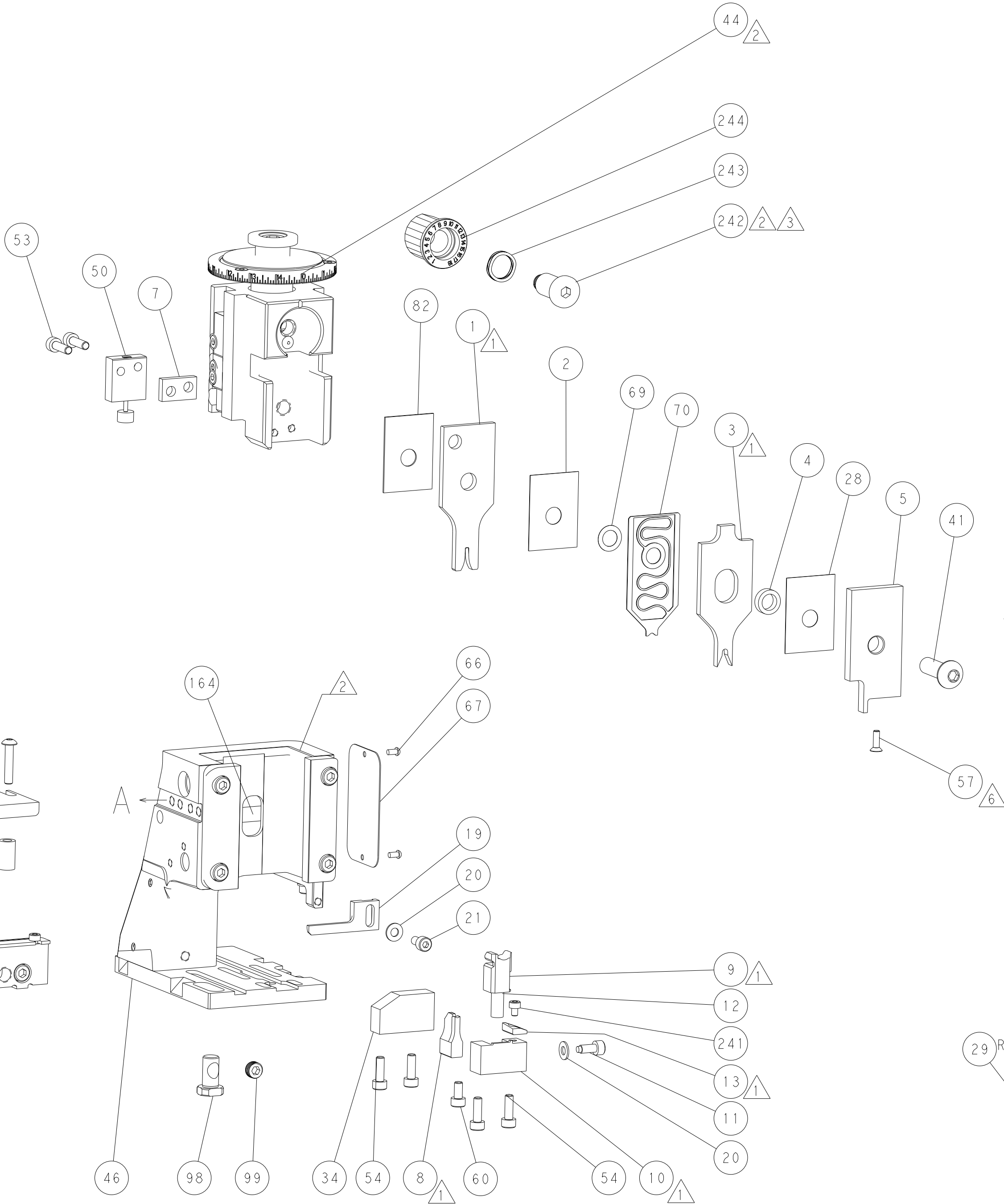
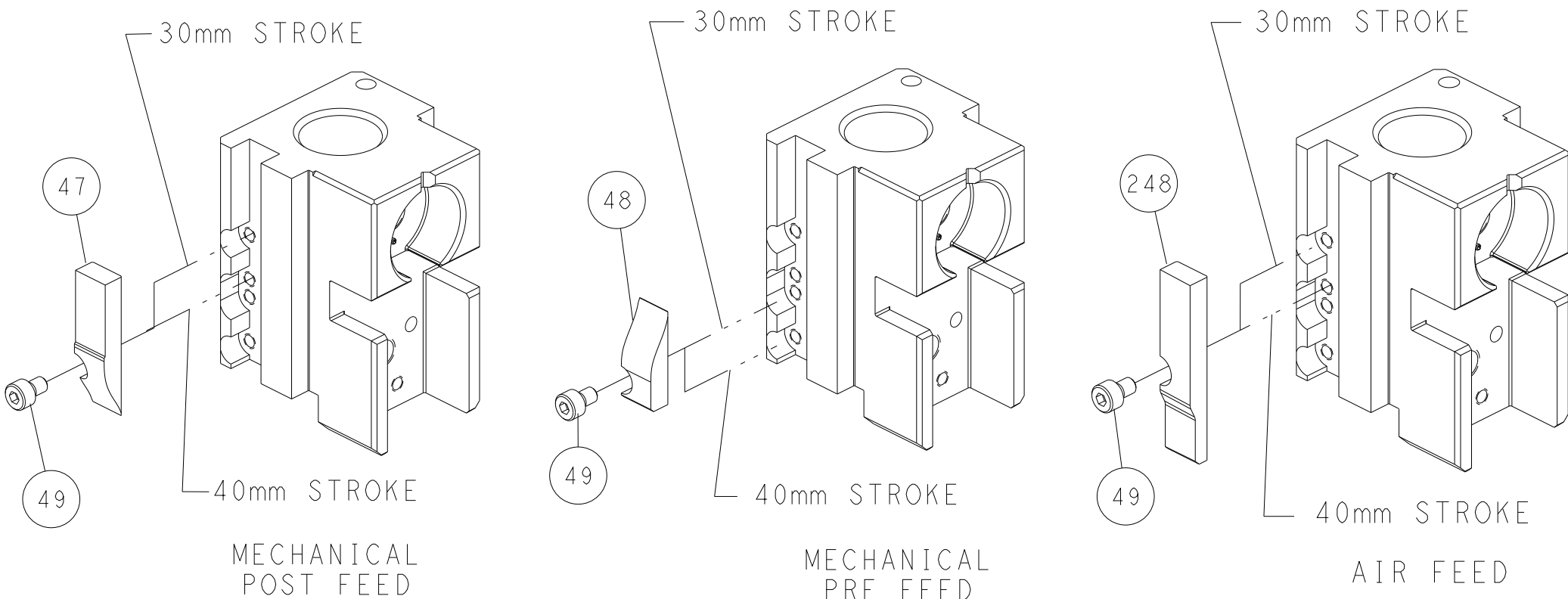
FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



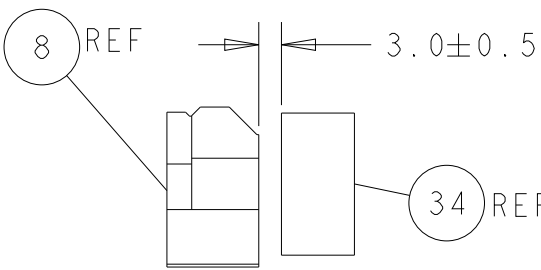
DETAIL A



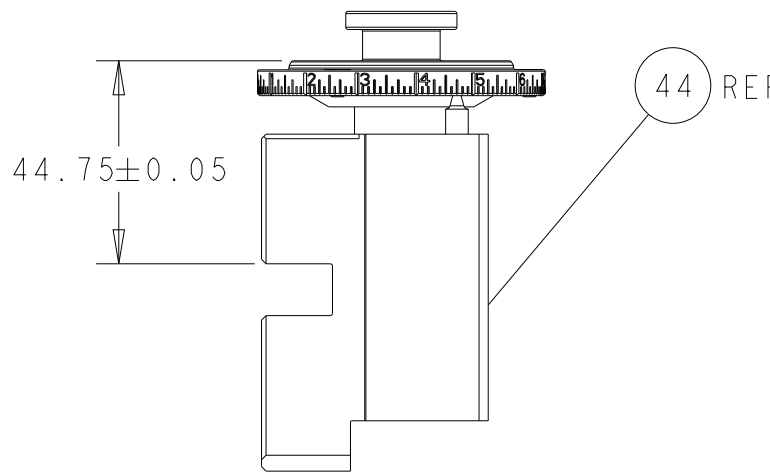
CAM POSITIONS



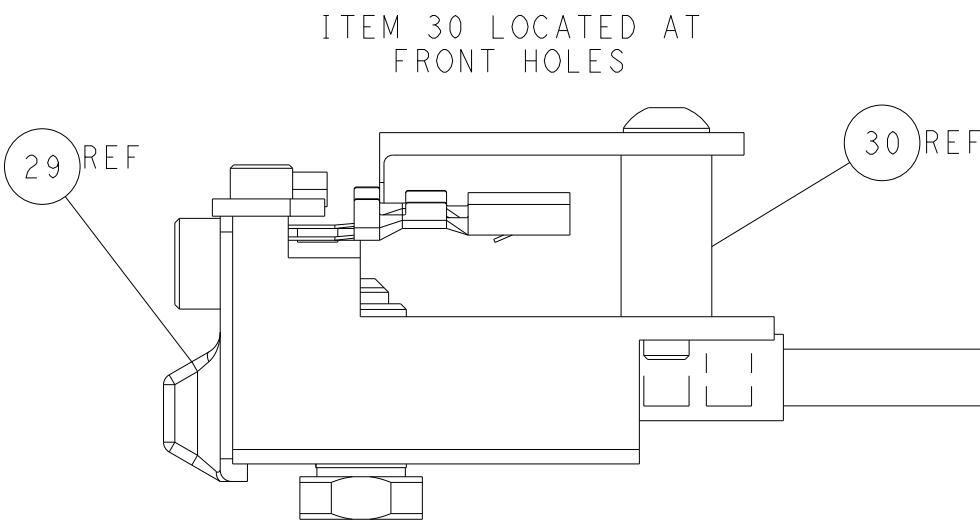
SHEAR DEPRESSOR DETAIL



TERMINAL SUPPORT LOCATION

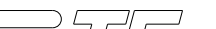


RAM SET-UP



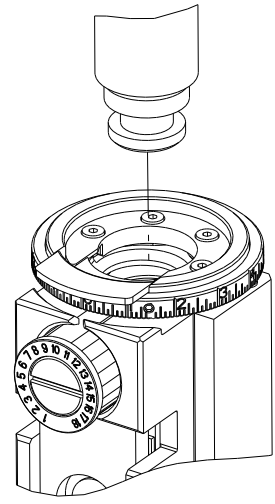
FEED TRACK POSITION
GUIDE BY INSULATION BARREL

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

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CHK T. ELBIN 20APR2017				APVD T. ELBIN 20APR2017	NAME Ocean Side Feed Applicator -						
DIMENSIONS: mm				PRODUCT SPEC							
TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH				APPLICATION SPEC							
MATERIAL -				WEIGHT -							
				Customer Accessible Production Drawing							
				SCALE 1:2							
				SHEET 2 of 4							
				REV C							

8		7	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2836736-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2836736-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2836736-7	C	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.73 mm [.068]	F
INSUL	2.90 mm [.114]	O
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: DELPHI TERMINAL		DELPHI PACKARD CRIMP SPECIFICATION	
TERMINAL NAME: TAXI TERM F GT 150 SEALED			
WIRE STRIP LENGTH			TERMINAL INSULATION DIAMETER RANGE
4.75-5.51 mm [.187-.217 IN]			∅ -
TERMINAL APPLICATION SPECIFICATION 		15396680 PAGE 1 OF 5 Rev 2014-07-29	
		-	-

TERMINALS APPLIED				SEAL INSULATION DIAMETER RANGE
TE TERMINAL	DELPHI TERMINAL	TE SEAL	DELPHI SEAL	
2318268-1	15396680	286970-1	15366021	
		286970-3	7165-0045	Ø1.2-1.9 mm

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.50mm2	1.10+/-0.05 [.043+/- .002]	6.8
0.35mm2	1.00+/-0.05 [.039+/- .002]	7.8



- 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.
- 6 APPLY TORQ-SEAL IN ALLEN SOCKET TO FILL HOLE AFTER FLAT HD HAS BEEN ADJUSTED TO CORRECT HEIGHT AT QUALIFICATION. APPLY #1-23419-5 LOC-TITE TO THREADS.

*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				
		P	LTR	DESCRIPTION	DATE	OWN
A	66	-	-	SEE SHEET 1	-	-

3	-	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	1803516-1	RAM ASSEMBLY, SF PACIFIC	140
	-	1	1	2844908-1	SCREW, LOCKING	99
	-	1	1	2844907-1	POST, LOCKING	98
	-	1	1	455888-7	SPACER, CRIMPER	82
	-	1	1	1803607-3	DOCUMENTATION PACKAGE	71
	6	-	1	1	2119791-5	DEPRESSOR, WIRE
-		1	1	2119943-1	WASHER, SPACER	69
-		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	985575-3	SCR, FLT SKT HD CAP M3 X 10.0	57
-		1	1	1338683-8	FEED PAWL	56
-		2	2	2-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 14	53
-		1	1	1803382-1	HOLD DOWN, SPRING LOADED	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	1-1752356-8	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	455888-3	SPACER, CRIMPER	28
1		-	1	1	1320928-2	STRIP GUIDE
	-	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	2119806-1	INSERT, SHEAR	13
	-	1	1	3-22280-3	SPRING, COMPRESSION	12
	-	1	1	1-356885-5	STOP, SHEAR	11
	-	1	1	2119805-1	SHEAR HOLDER, FRONT	10
	-	1	1	318707-1	FLOATING SHEAR, FRONT	9
	1	1	1	7-1803252-1	ANVIL, COMBINATION	8
	-	1	1	240641-1	SPACER	7
	-	-	-	-	-	6
	-	1	1	2119781-1	DEPRESSOR, SHEAR	5
	-	1	1	4-238011-5	BLOCK, CRIMPER SPACER	4
	1	1	1	7-1803019-8	CRIMPER, INSULATION O	3
	-	1	1	455888-3	SPACER, CRIMPER	2
	1	1	1	2-1673600-4	CRIMPER, WIRE	1

-77	-22	-21	PART NO	DESCRIPTION	ITEM NO
OWN D. WEAVER			20APR2017	TE Connectivity Harrisburg, PA 17105-3608	NAME Ocean Side Feed Applicator
CHK T. ELBIN			20APR2017		
APVD T. ELBIN			20APR2017		
PRODUCT SPEC			APPLICATION SPEC		
DIMENSIONS: mm			TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH	SIZE A	CAGE CODE 00779
MATERIAL -			WEIGHT -	DRAWING NO C=2836736	RESTRICTED TO -
Customer Accessible Production Drawing			SCALE 1:2	SHEET 3	OF 4
			REV C		

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

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

D

C

B

A

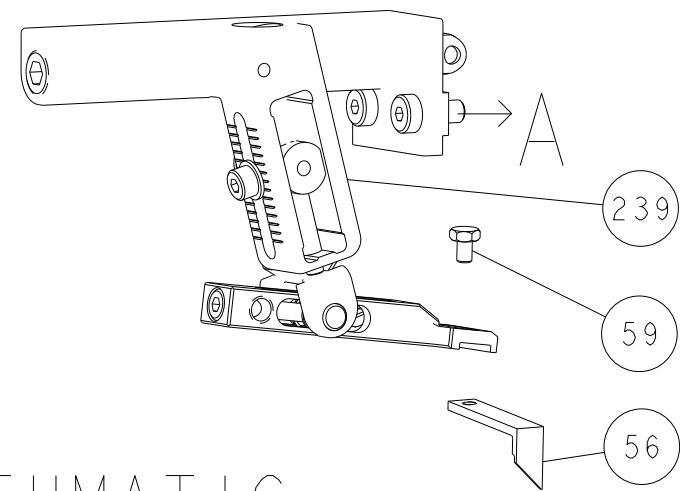
D

C

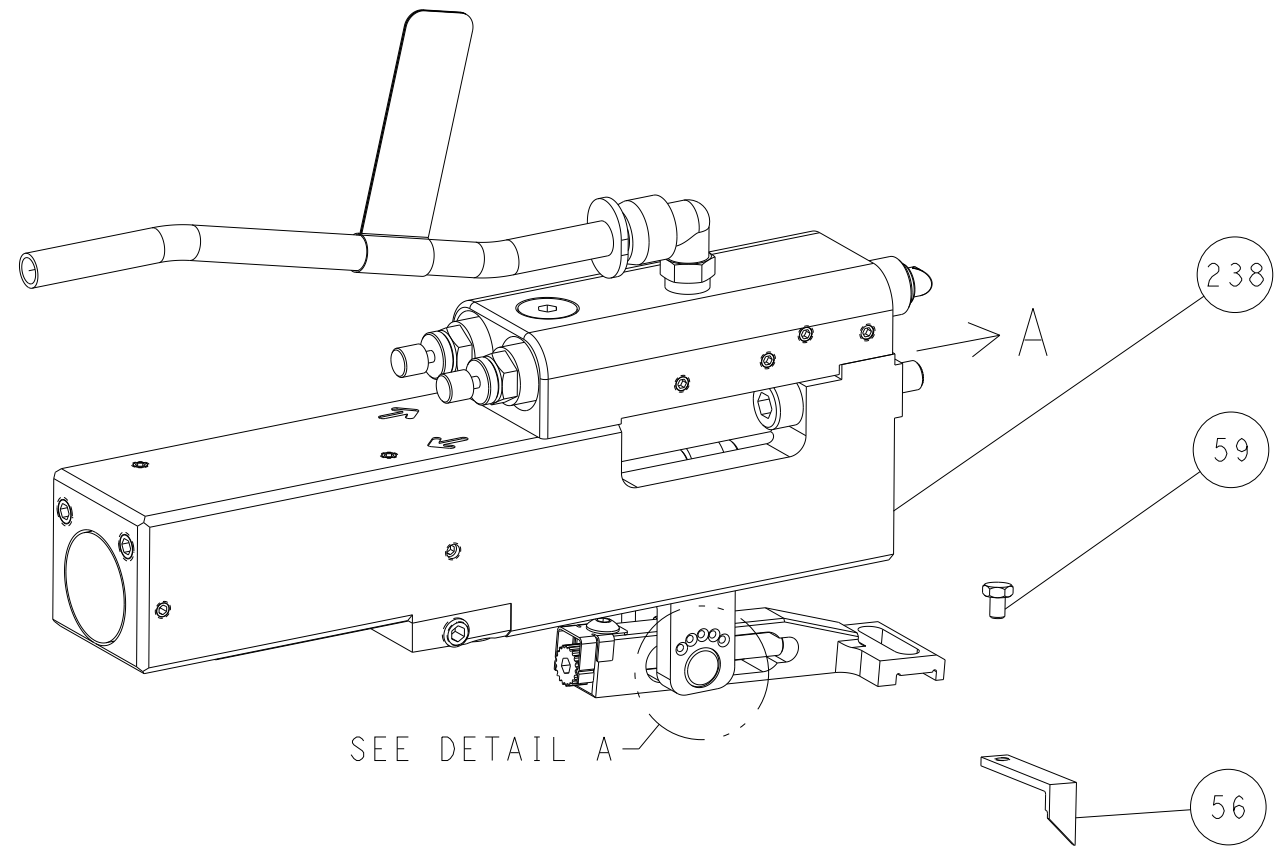
B

A

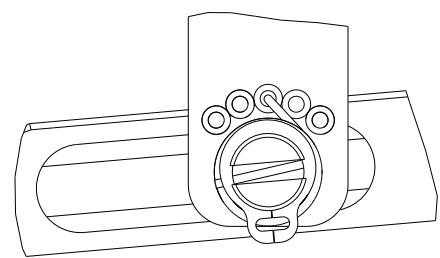
FEED TYPE MECHANICAL



PNEUMATIC

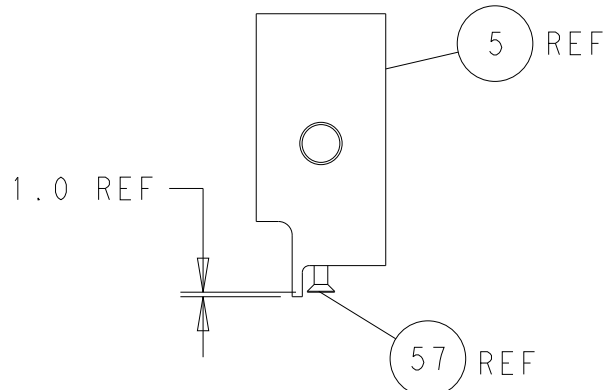
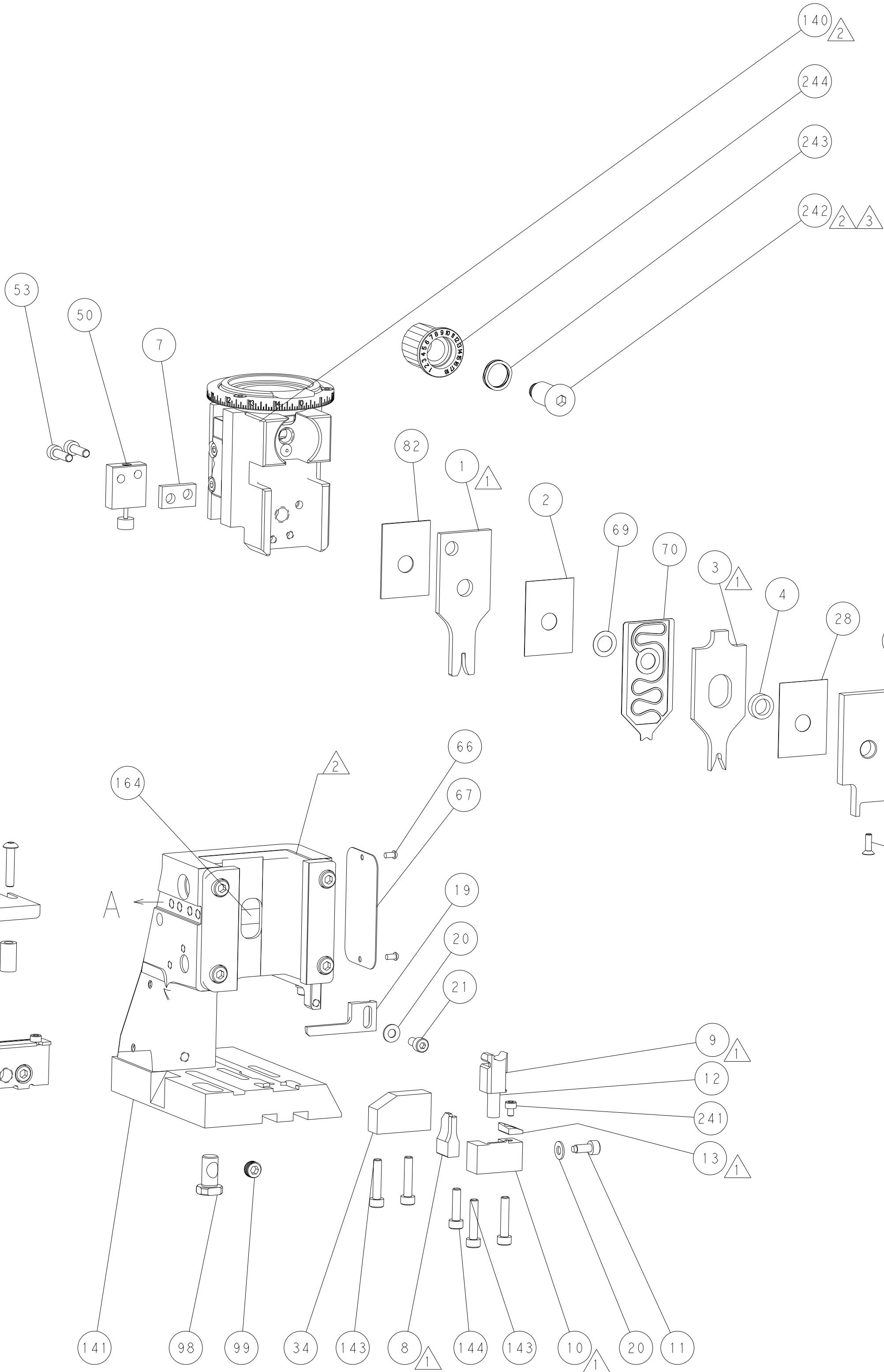
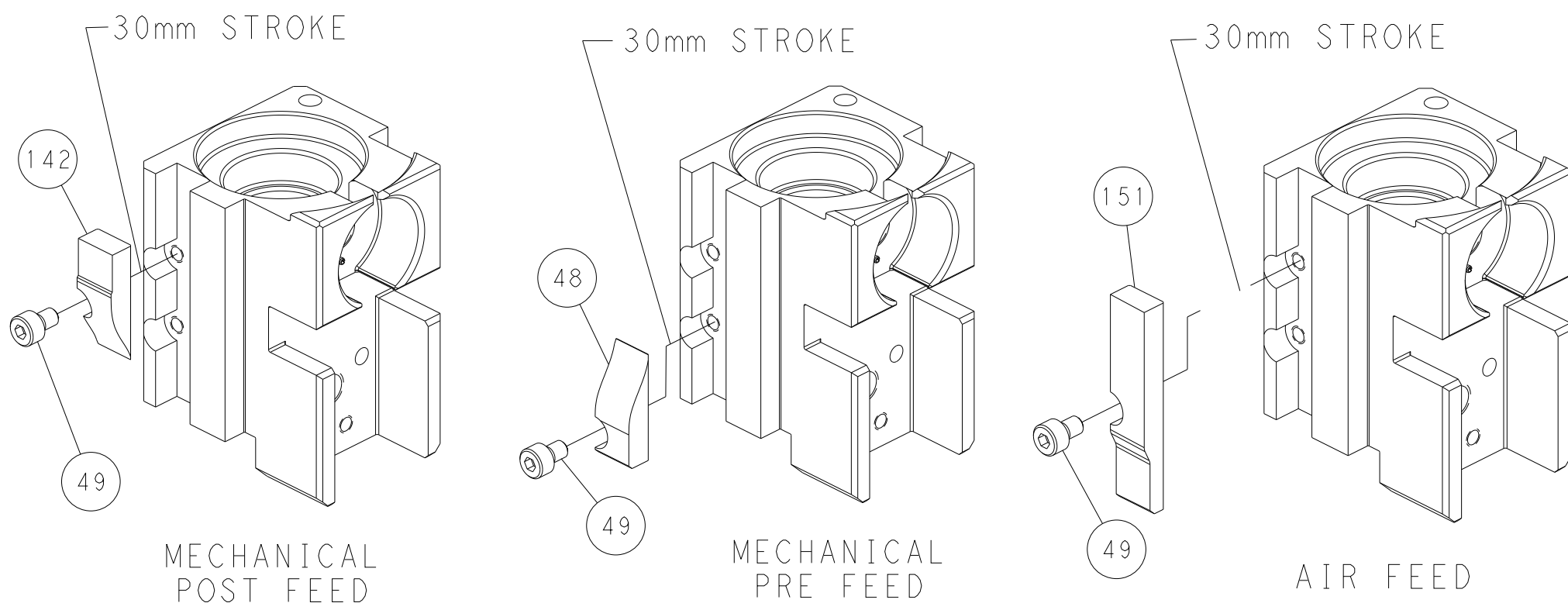


FEED SPRING SETTING POSITION
(SHOWN FROM REAR SIDE)

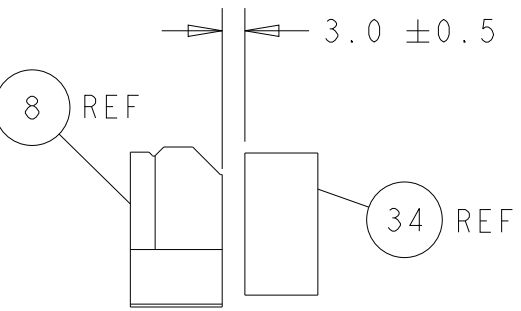


DETAIL A

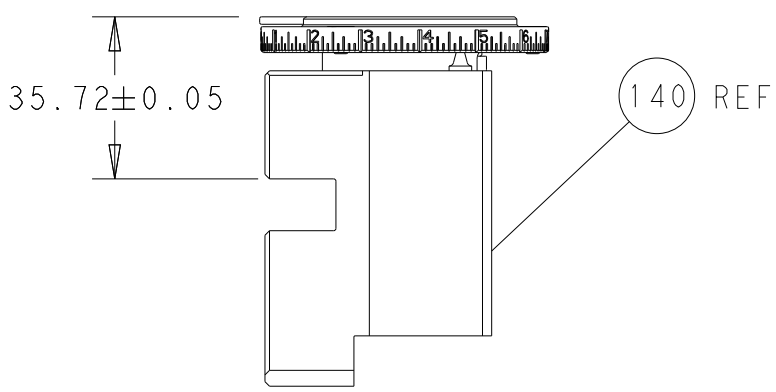
CAM POSITIONS



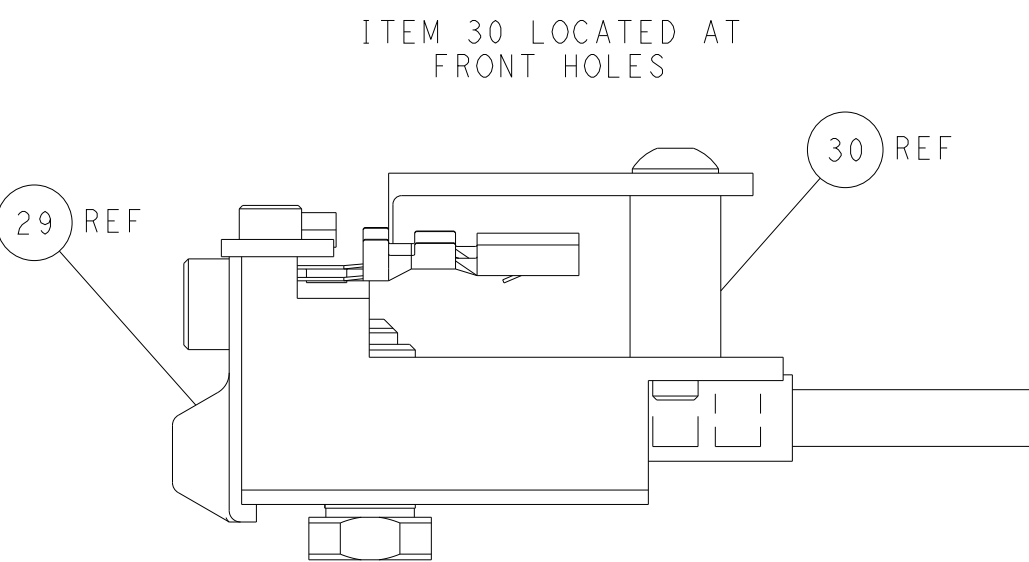
SHEAR DEPRESSOR DETAIL



TERMINAL SUPPORT LOCATION



RAM SET-UP



FEED TRACK POSITION
GUIDE BY INSULATION BARREL

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

THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO COMPANY CONTROL AND INSPECTING ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST REVISION.				DWN B. WEAVER 20APR2017	 TE Connectivity Harrisburg, PA 17105-3608		
				CHK T. ELBIN 20APR2017			
				APVD T. ELBIN 20APR2017	NAME Ocean Side Feed Applicator		
				PRODUCT SPEC			
				APPLICATION SPEC			
				WEIGHT			
				Customer Accessible Production Drawing			
				SCALE			
				SHEET			
				OF			
				REV			

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION