

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2836265-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2836265-2	C	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2836265-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



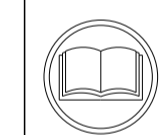
APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.95 mm [.116]	F
INSUL	5.90 mm [.232]	O

APPLICATOR INSTRUCTIONS 408-35042

TERMINAL DATA: DELPHI PACKARD TERMINAL DELPHI CRIMP SPECIFICATION	
TERMINAL NAME: TAXI TERM M/P 480	
WIRE STRIP LENGTH 5.24-6.00 mm [.206-.236 IN]	INSULATION DIAMETER RANGE $\varnothing$
TERMINAL APPLICATION SPECIFICATION	CRIMP INFORMATION SHEET Rev 2013-10-30

TE TERMINAL	DELPHI PACKARD TERMINAL	TE SEAL	DELPHI PACKARD SEAL	CABLE DIAMETER
1572548-1	12065196	2113929-1	15324988	2.01-2.85
		1572026-1	15324989	2.81-3.76
		1949389-1	12048442	2.81-3.76

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
2.00mm2	1.65 +/- 0.05 [0.065 +/- .002]	6.6
1.00mm2	1.45 +/- 0.05 [0.057 +/- .002]	8.7



- 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.
- APPLY TORQ-SEAL IN ALLEN SOCKET TO FILL HOLE AFTER SOCKET HD HAS BEEN ADJUSTED TO CORRECT HEIGHT AT QUALIFICATION.
- UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- CUT TO LENGTH AT ASSEMBLY.
- TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.

**\*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	15JUN2016	KH	GB
		B		ECR-17-006386	04MAY2017	MZ	TE
		C		ECR-22-139776	19MAY2022	TB	RK

1	-	1	1	2280441-1	INSERT, SHEAR		282
	-	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0		269
	-	1	1	1-1633782-4	FENCE		267
	-	1	1	5018030-1	NUT, HEX, REG, RoHS, M3		261
	-	1	1	2119641-1	FEED CAM, AIR FEED		248
	-	1	1	2119082-1	CAM, SNAIL, INSULATION ADJUSTMENT		244
	-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST		243
3	-	1	1	2119083-1	RETAINER, INSULATION DIAL		242
7	-	2	2	7-18023-7	SCR, SKT HD CAP M3 X 4.0		241
	-	1	1	2844940-1	AIR FEED MODULE		238
	-	1	1	1-356885-0	STOP, SHEAR		237
	-	REF	REF	994970-2	COUNTER, MAGNETIC		164
	-	1	1	2844908-1	SCREW, LOCKING		99
	-	1	1	2844907-1	POST, LOCKING		98
	-	1	1	1-690438-0	FRONT STRIP GUIDE		96
	-	1	1	455888-7	SPACER, CRIMPER		82
	-	1	1	4-240641-5	SPACER		81
7	-	2	2	2079383-4	SCR, BHSC, RoHS (M4 X 8)		79
	-	1	1	1803096-1	EXTENSION PLATE		78
	-	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	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0		60
	-	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0		59
5	-	1	1	1-2168083-3	SCR, SKT HD CAP, RoHS, M3 X 16		57
	-	1	1	1338685-1	PAWL, FEED		56
	-	4	4	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0		54
	-	2	2	1-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 30		53
	-	1	1	18023-9	SCR, SKT HD CAP M4 X 6.0		49
	-	1	1	1-1803583-7	APPLICATOR BASIC ASSEMBLY, SF		46
	-	1	1	1803515-1	RAM ASSEMBLY, SF ATLANTIC		44
	-	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)		41
	-	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)		33
	-	2	2	1-2844962-7	SPACER, CYLINDRICAL, STRIP GUIDE		30
	-	1	1	2844992-5	ASSEMBLY, STRIP GUIDE		29
	-	1	1	455888-4	SPACER, CRIMPER		28
	-	2	2	22283-1	SPRING, COMPRESSION		27
	-	1	1	240792-1	DRAG, TERMINAL		25
	-	1	1	2-1320928-7	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	1-690518-1	HOLD DOWN, TERMINAL		18
1	-	1	1	690463-1	FLOATING SHEAR, REAR		17
	-	2	2	1-2168083-1	SCR, SKT HD CAP, RoHS, M3 X 6		16
1	-	1	1	1-690464-6	SHEAR PLATE, REAR		15
	-	1	1	2119862-1	SHEAR HOLDER, REAR		14
1	-	1	1	2119806-1	INSERT, SHEAR		13
	-	2	2	3-22280-3	SPRING, COMPRESSION		12
	-	1	1	1-356885-4	STOP, SHEAR		11
1	-	1	1	2119805-7	SHEAR HOLDER, FRONT		10
1	-	1	1	318059-9	FLOATING SHEAR, FRONT		9
1	1	2	1	8-1803056-2	ANVIL, COMBINATION		8
	-	1	1	7-240641-3	SPACER		7
	-	1	1	1-690468-7	DEPRESSOR SHEAR, REAR		6
	-	1	1	1803080-1	DEPRESSOR, SHEAR		5
	-	1	1	238011-2	BLOCK, CRIMPER SPACER		4
1	1	2	1	5-2119784-2	CRIMPER, INSULATION O PREMIUM		3
	-	1	1	455888-9	SPACER, CRIMPER		2
1	1	2	1	9-1803188-0	CRIMPER, WIRE		1

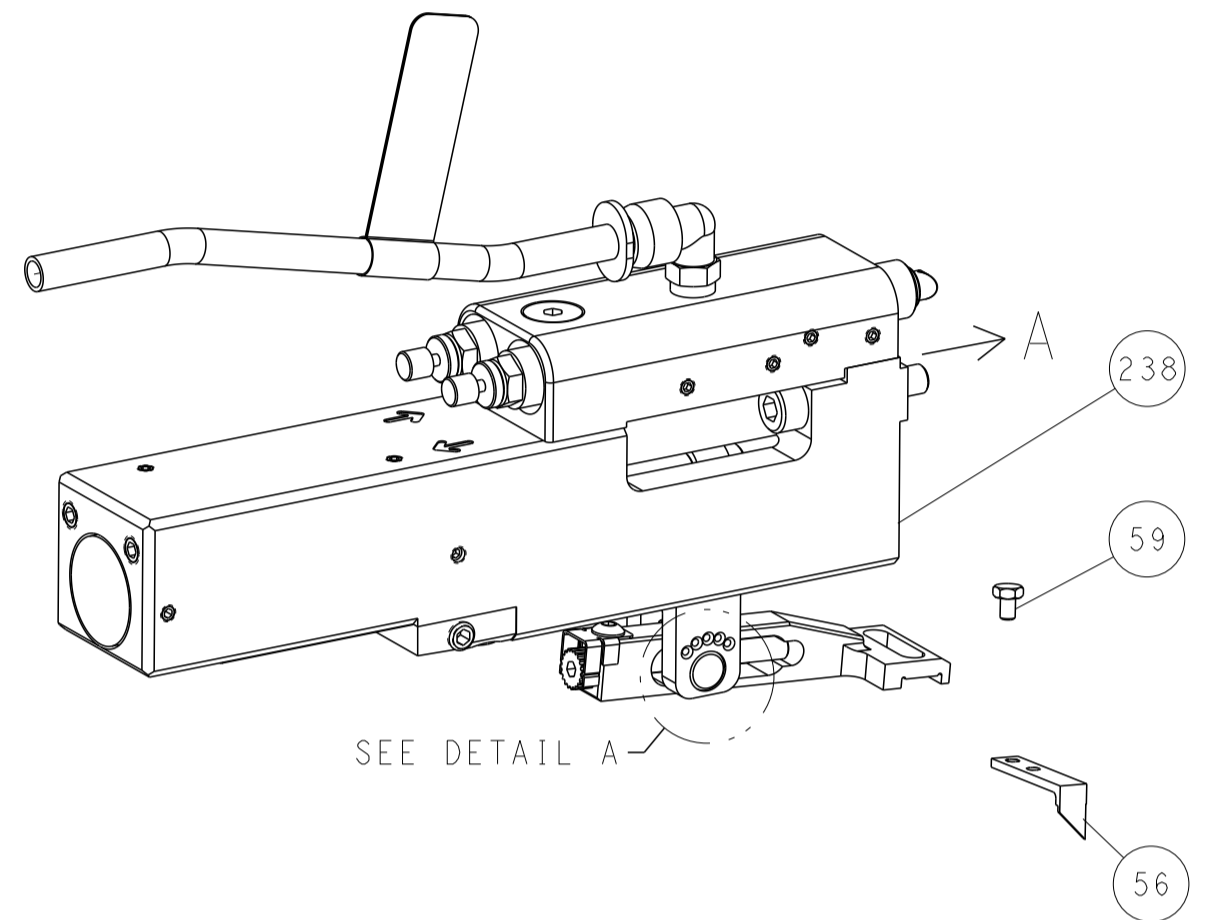
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mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES ±	FINISH ±

ITEM NO	PART NO	DESCRIPTION
-77-72-2		

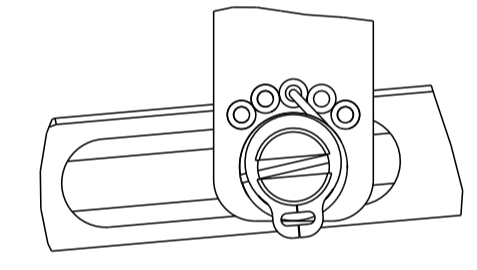
OWN: H. HUANG	DATE: 07APR2016	TE Connectivity Harrisburg, PA 17105-3608
CHK: L. ZHANG	DATE: 07APR2016	
APVD: L. ZHANG	DATE: 07APR2016	
NAME: Ocean Side Feed Applicator		
SIZE: A1	CAGE CODE: 00779	DRAWING NO: 2836265
Customer Accessible Production Drawing		SCALE: 1:2
SHEET 1 OF 4		REV C

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

### FEED TYPE PNEUMATIC

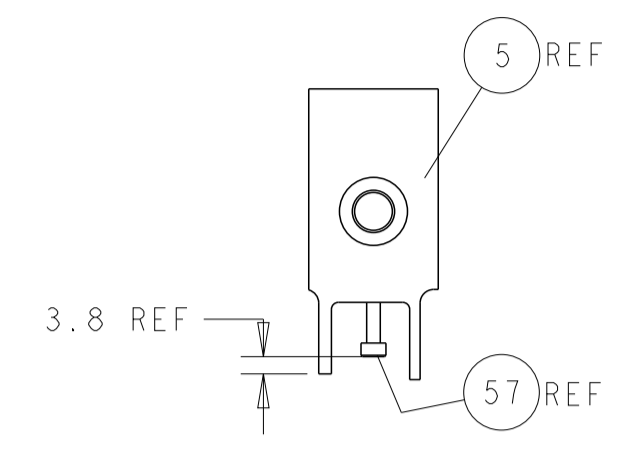
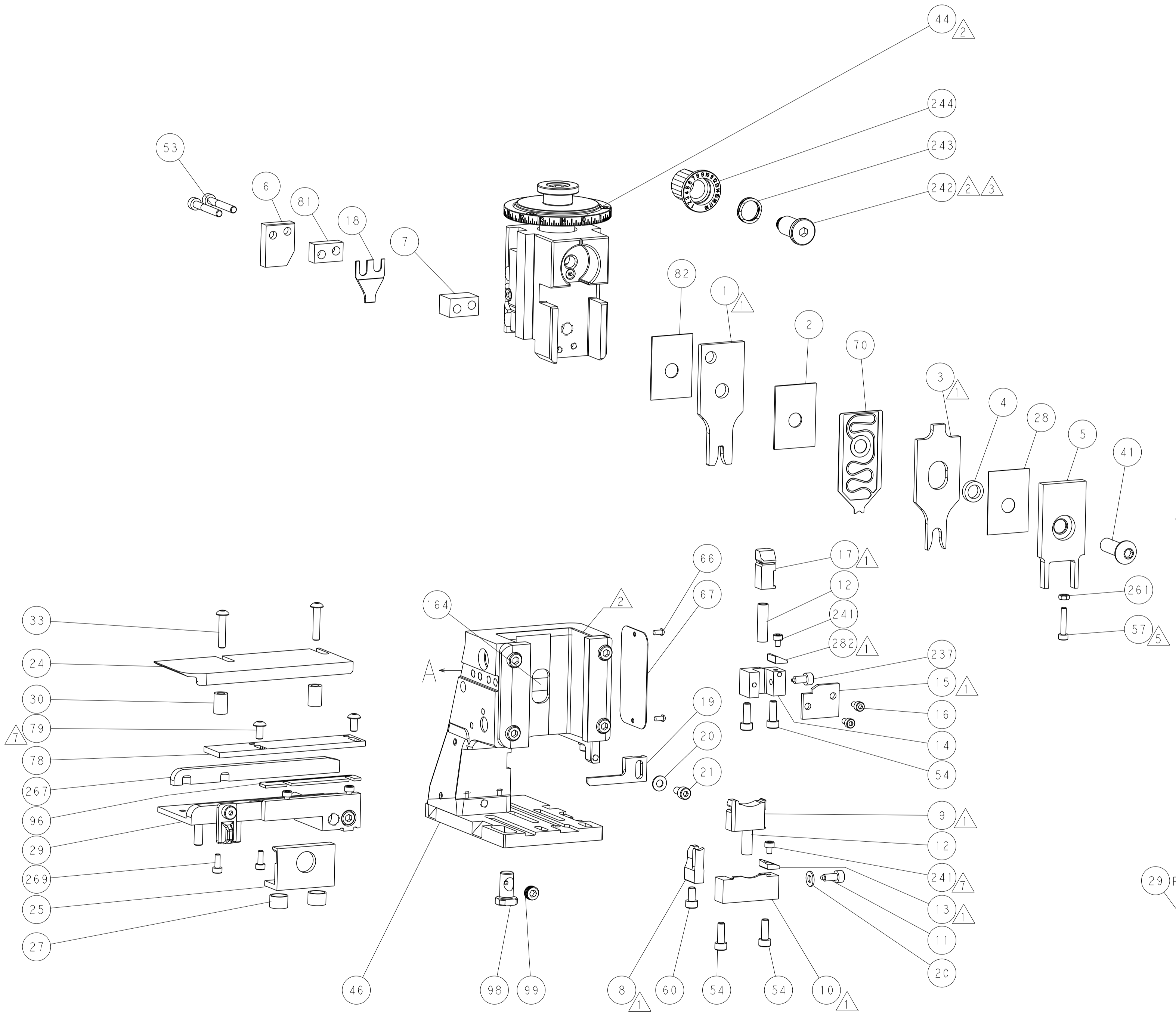
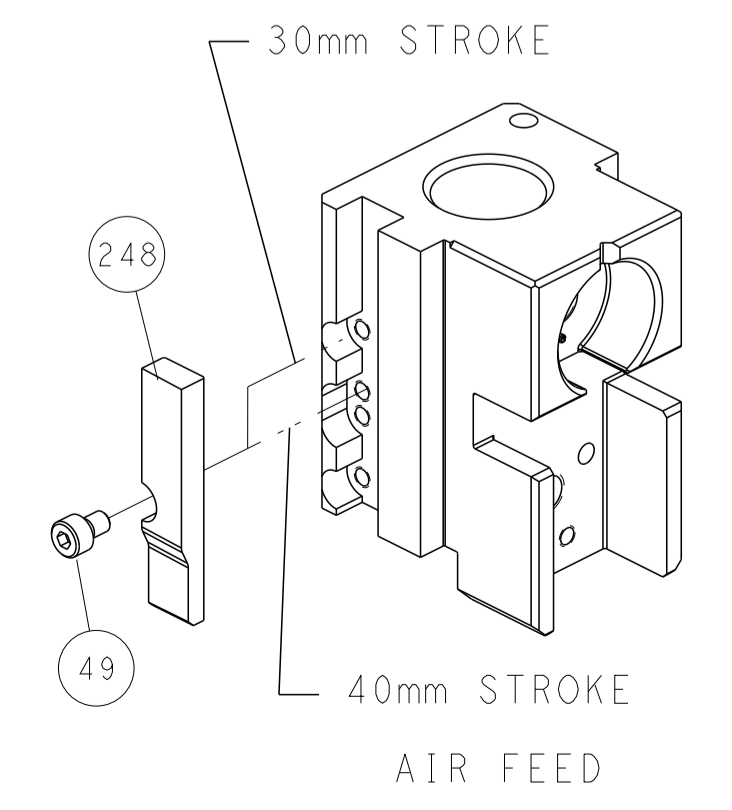


FEED SPRING SETTING POSITION  
(SHOWN FROM REAR SIDE)

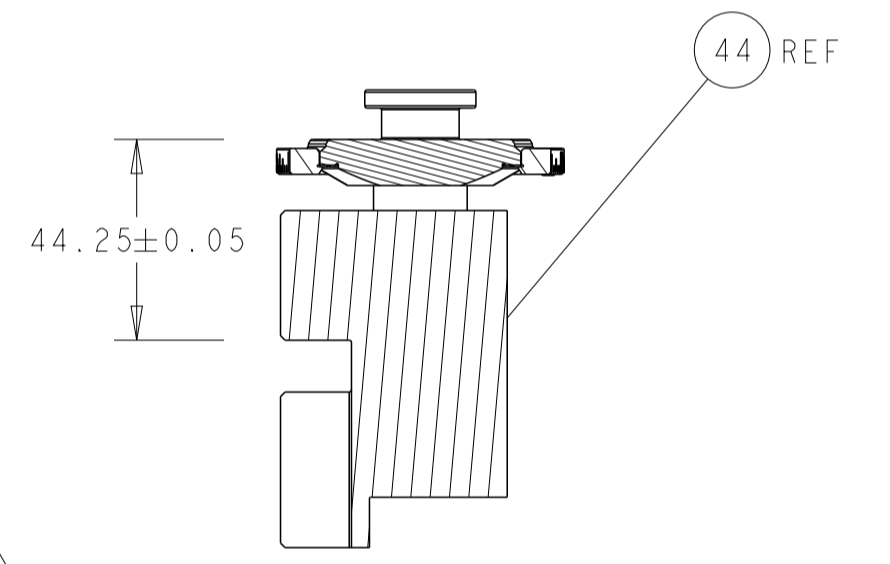


DETAIL A

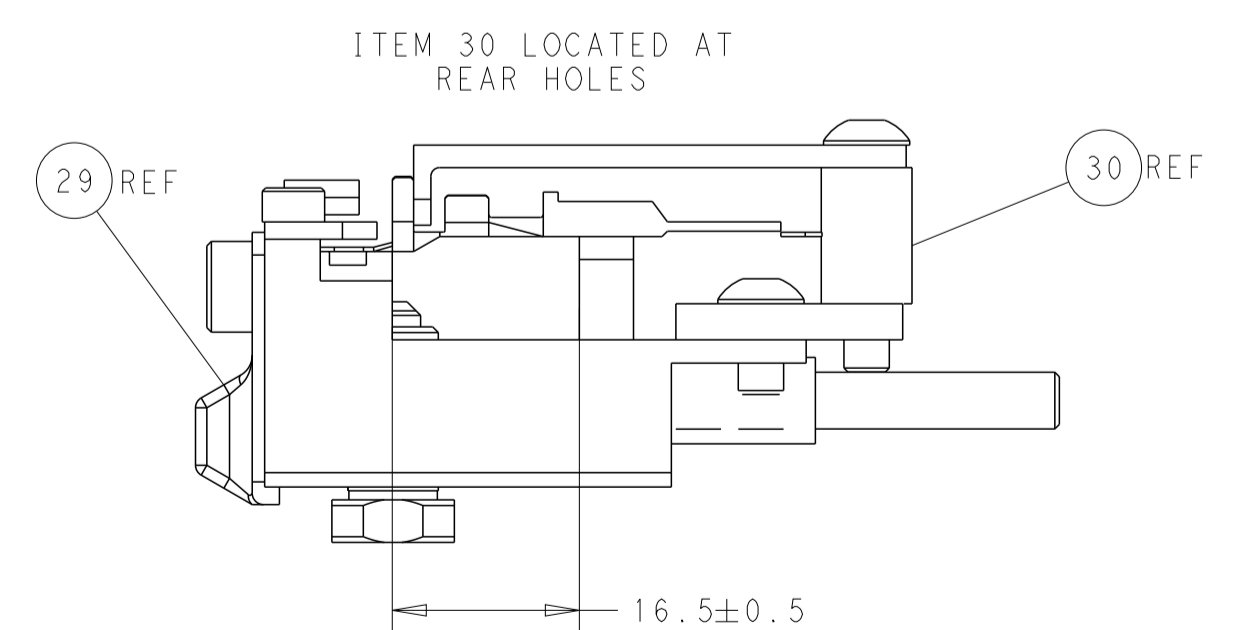
### CAM POSITION



SHEAR DEPRESSOR DETAIL



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)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN: H. HUANG 07APR2016		TE Connectivity	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	Harrisburg, PA 17105-3608	
MATERIAL:		FINISH:		CHK: L. ZHANG 07APR2016		NAME: Ocean Side Feed Applicator	
				APVD: L. ZHANG 07APR2016		PRODUCT SPEC:	
						APPLICATION SPEC:	
				WEIGHT:		SIZE: A1	
						CAGE CODE: 00779	
						DRAWING NO: C=2836265	
				Customer Accessible Production Drawing		RESTRICTED TO:	
				SCALE: 1:2		SHEET 2 OF 4 REV C	

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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2836265-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2836265-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR  
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.95 mm [.116]	F
INSUL	5.90 mm [.232]	O
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: DELPHI PACKARD TERMINAL DELPHI CRIMP SPECIFICATION

TERMINAL NAME: TAXI TERM M/P 480				
WIRE STRIP LENGTH 5.24-6.00 mm [1.206-.236 IN]	INSULATION DIAMETER RANGE Ø			
TERMINAL APPLICATION SPECIFICATION	CRIMP INFORMATION SHEET Rev 2013-10-30			
TERMINALS APPLIED				
TE TERMINAL	DELPHI PACKARD TERMINAL	TE SEAL	DELPHI PACKARD SEAL	CABLE DIAMETER
1572548-1	12065196	2113929-1	15324988	2.01-2.85
		1572026-1	15324989	2.81-3.76
		1949389-1	12048442	2.81-3.76

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
2.00mm2	1.65+/-0.05 [1.065+/-0.002]	6.6
1.00mm2	1.45+/-0.05 [1.057+/-0.002]	8.7

- 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.
- APPLY TORQ-SEAL IN ALLEN SOCKET TO FILL HOLE AFTER SOCKET HD HAS BEEN ADJUSTED TO CORRECT HEIGHT AT QUALIFICATION.
- UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- CUT TO LENGTH AT ASSEMBLY.
- TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.

**\*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					
A	66	P	LTN	DESCRIPTION	DATE	OWN	APVD
		-		SEE SHEET 1			

1	-	1	2280441-1	INSERT, SHEAR	282
	-	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	269
	-	1	1-1633782-4	FENCE	267
	-	1	5018030-1	NUT, HEX, REG, RoHS, M3	261
	-	1	2119082-1	CAM, SNAIL, INSULATION ADJUSTMENT	244
	-	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
3	-	1	2119083-1	RETAINER, INSULATION DIAL	242
7	-	2	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
	-	1	2844940-1	AIR FEED MODULE	238
	-	1	1-356885-0	STOP, SHEAR	237
	REF		994970-2	COUNTER, MAGNETIC	164
	-	1	2119641-2	FEED CAM, AIR FEED	151
	-	1	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	144
	-	4	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	143
	-	1	1-1803583-8	APPLICATOR BASIC ASSEMBLY, SF	141
	-	1	1803516-1	RAM ASSEMBLY, SF PACIFIC	140
	-	1	2844908-1	SCREW, LOCKING	99
	-	1	2844907-1	POST, LOCKING	98
	-	1	1-690438-0	FRONT STRIP GUIDE	96
	-	1	455888-7	SPACER, CRIMPER	82
	-	1	4-240641-5	SPACER	81
7	-	2	2079383-4	SCR, BHSC, RoHS (M4 X 8)	79
	-	1	1803096-1	EXTENSION PLATE	78
	-	1	1803607-3	DOCUMENTATION PACKAGE	71
	-	1	2119791-5	DEPRESSOR, WIRE	70
	-	1	2119740-1	TAG IDENTIFICATION	67
	-	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
	-	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
5	-	1	1-2168083-3	SCR, SKT HD CAP, RoHS, M3 X 16	57
	-	1	1338685-1	PAWL, FEED	56
	-	2	1-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 30	53
	-	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49
	-	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
	-	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
	-	2	1-2844962-7	SPACER, CYLINDRICAL, STRIP GUIDE	30
	-	1	2844992-5	ASSEMBLY, STRIP GUIDE	29
	-	1	455888-4	SPACER, CRIMPER	28
	-	2	22283-1	SPRING, COMPRESSION	27
	-	1	240792-1	DRAG, TERMINAL	25
	-	1	2-1320928-7	STRIP GUIDE	24
	-	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
	-	2	1-18028-2	WASHER, FLAT, REG M4	20
	-	1	2119533-1	STRIPPER, SIDE FEED	19
	-	1	1-690518-1	HOLD DOWN, TERMINAL	18
1	-	1	690463-1	FLOATING SHEAR, REAR	17
	-	2	1-2168083-1	SCR, SKT HD CAP, RoHS, M3 X 6	16
1	-	1	1-690464-6	SHEAR PLATE, REAR	15
	-	1	2119862-1	SHEAR HOLDER, REAR	14
1	-	1	2119806-1	INSERT, SHEAR	13
	-	2	3-22280-3	SPRING, COMPRESSION	12
	-	1	1-356885-4	STOP, SHEAR	11
1	-	1	2119805-7	SHEAR HOLDER, FRONT	10
1	-	1	318059-9	FLOATING SHEAR, FRONT	9
1	1	1	8-1803056-2	ANVIL, COMBINATION	8
	-	1	7-240641-3	SPACER	7
	-	1	1-690468-7	DEPRESSOR SHEAR, REAR	6
	-	1	1803080-1	DEPRESSOR, SHEAR	5
	-	1	238011-2	BLOCK, CRIMPER SPACER	4
1	1	1	5-2119784-2	CRIMPER, INSULATION O PREMIUM	3
	-	1	455888-9	SPACER, CRIMPER	2
1	1	1	9-1803188-0	CRIMPER, WIRE	1

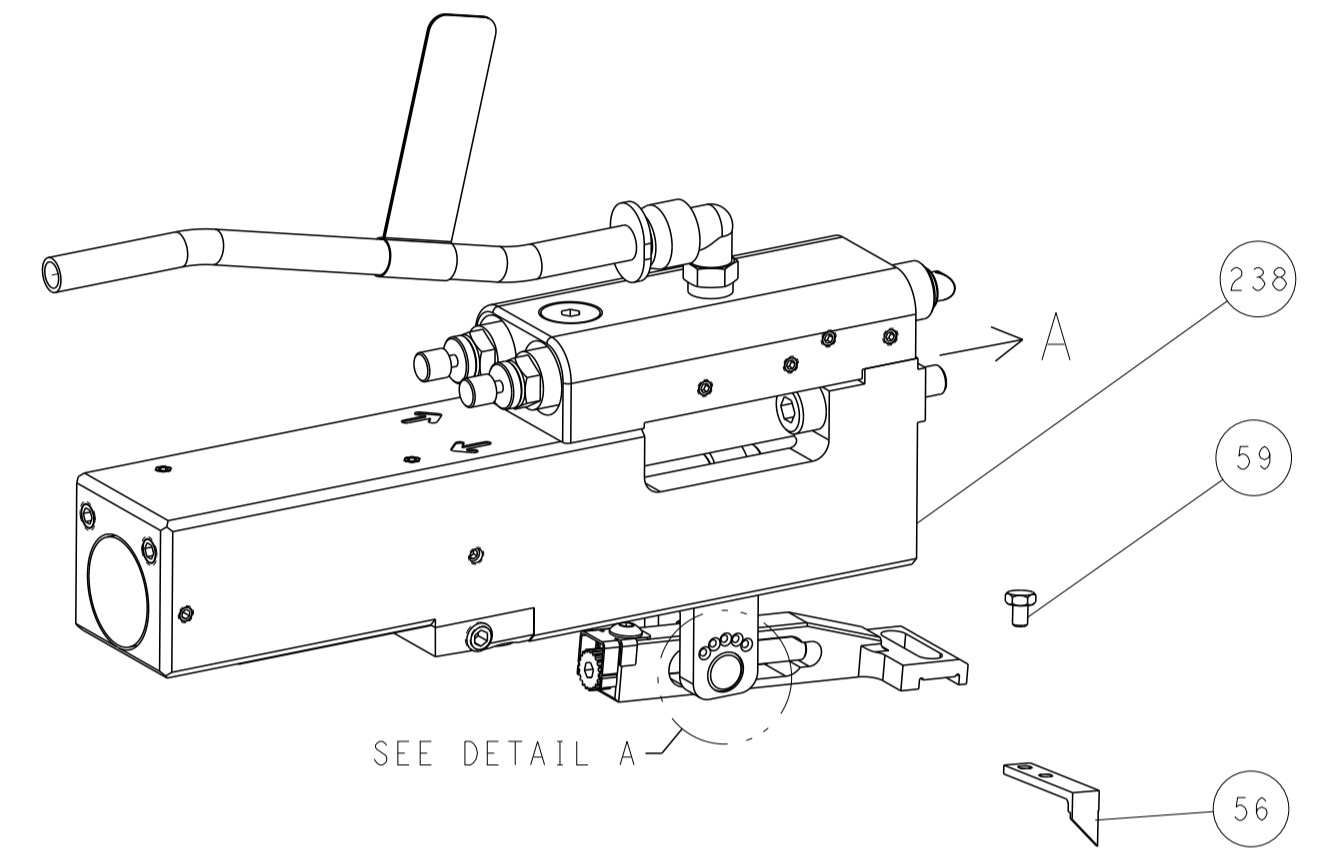
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG: H. HUANG 07APR2016		CHK: L. ZHANG 07APR2016		APVD: L. ZHANG 07APR2016		NAME: Ocean Side Feed Applicator	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES ±	FINISH	SIZE: A1	CAGE CODE: 00779	DRAWING NO: C=2836265	RESTRICTED TO: -
MATERIAL: -								WEIGHT: -		SCALE: 1:2	
Customer Accessible Production Drawing								SHEET 3 OF 4		REV C	

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

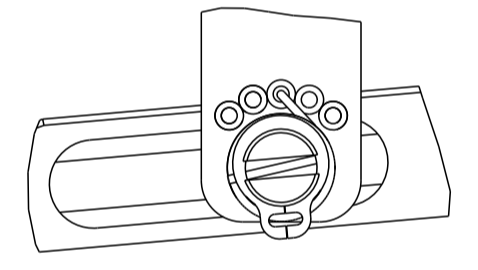
LOC	DIST	REVISIONS					
		P	LTN	DESCRIPTION	DATE	DWN	APVD
A	66	-	-	SEE SHEET 1	-	-	-

# FEED TYPE

## PNEUMATIC

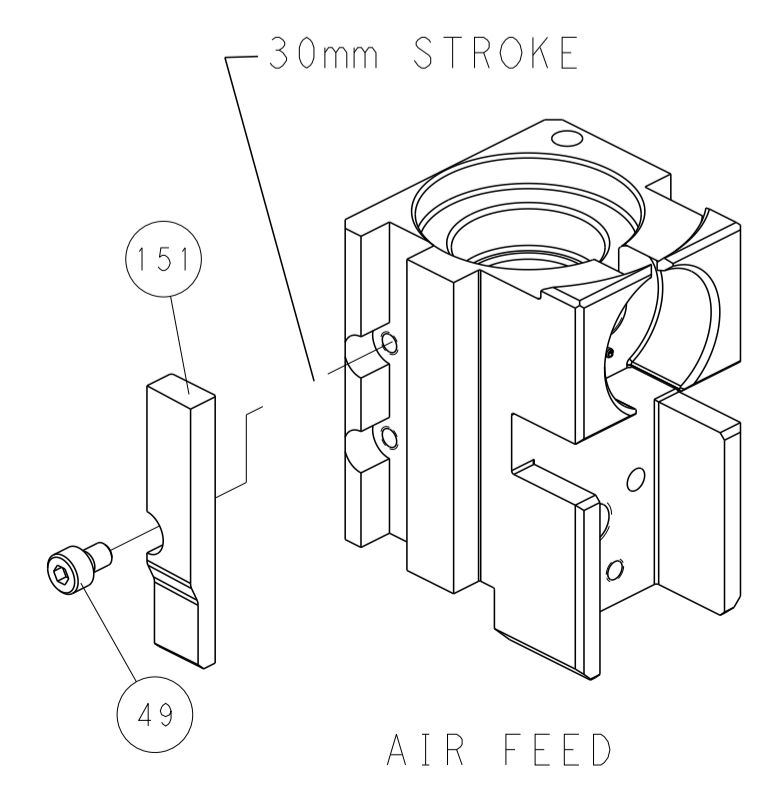


FEED SPRING SETTING POSITION  
(SHOWN FROM REAR SIDE)

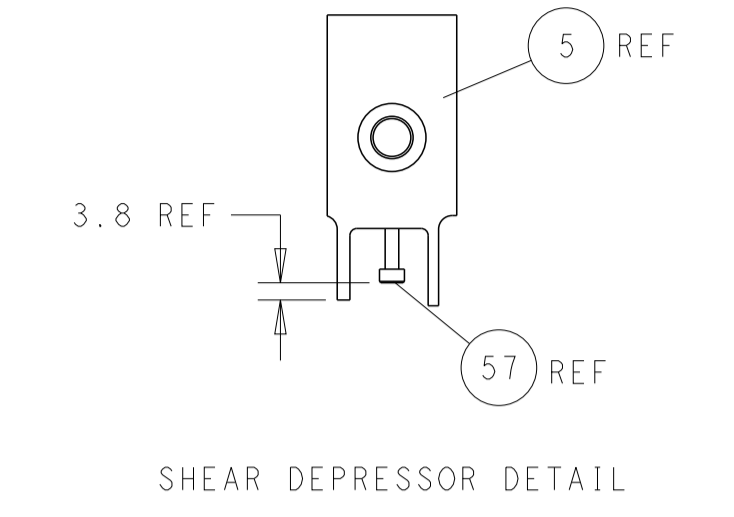
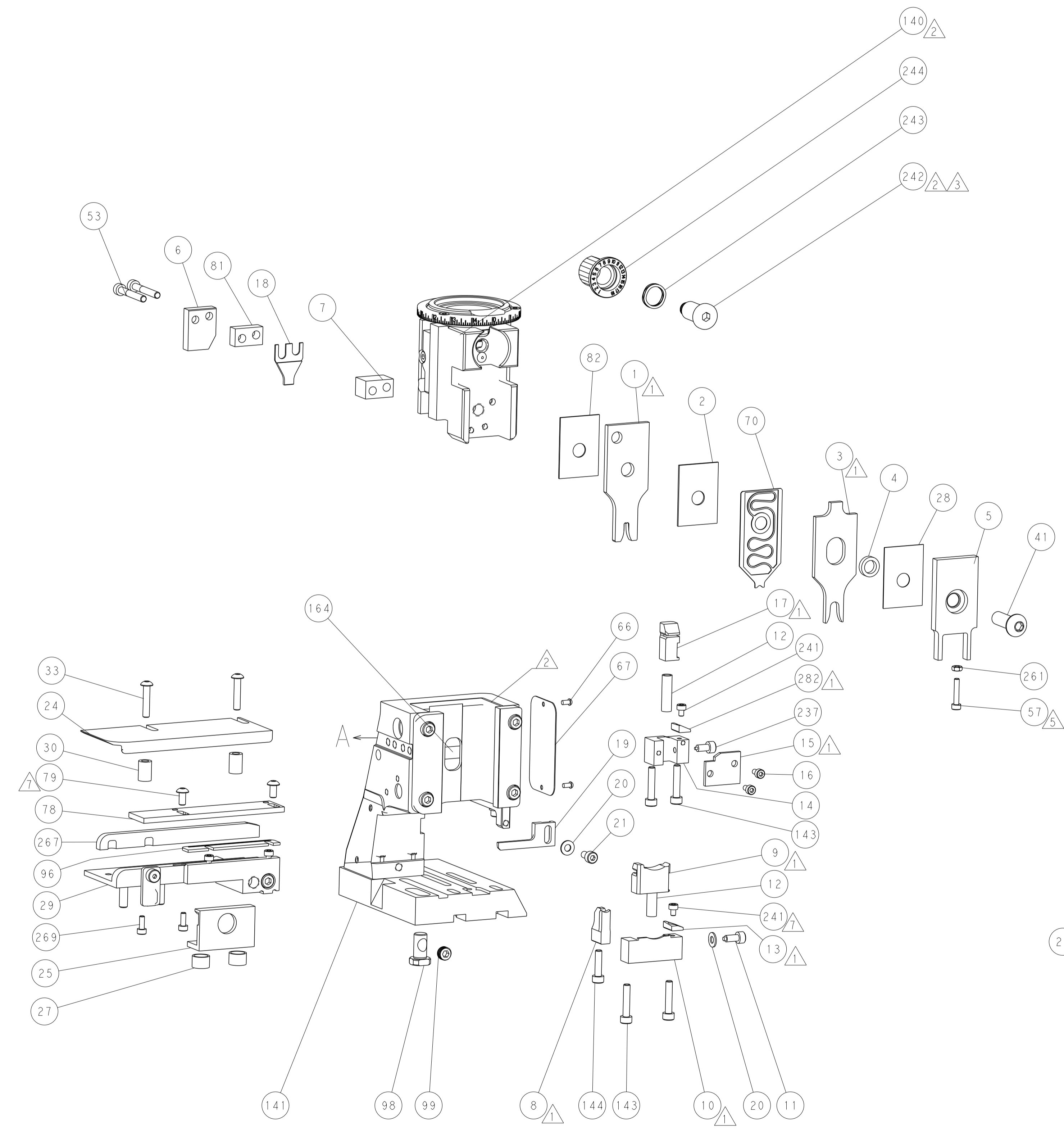


DETAIL A

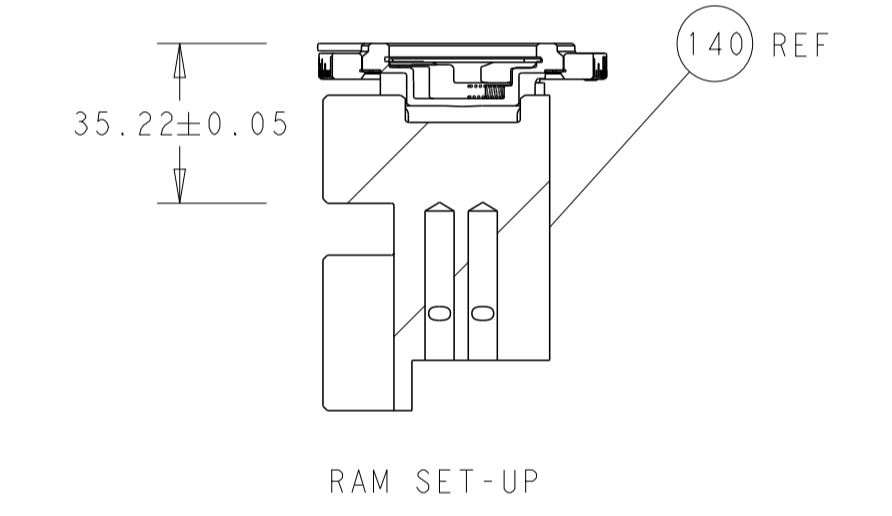
## CAM POSITION



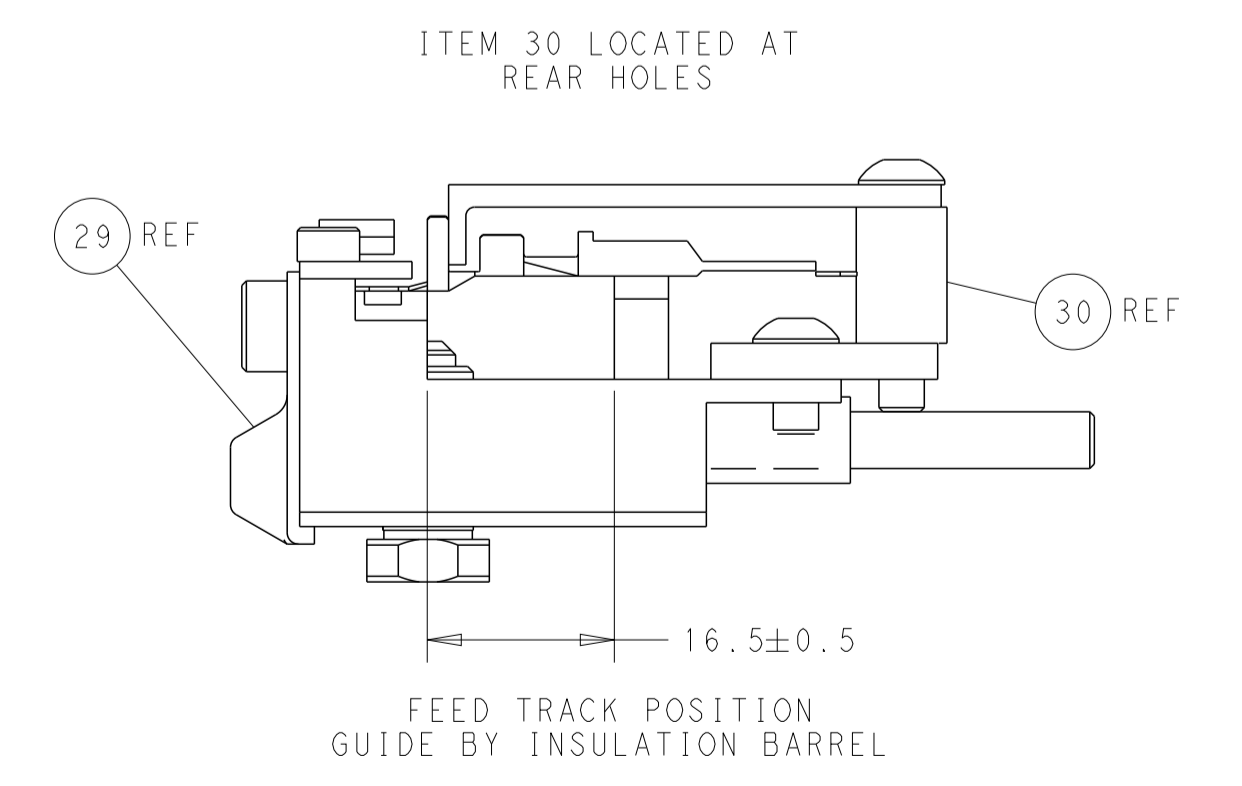
AIR FEED



SHEAR DEPRESSOR DETAIL



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)

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DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± MATERIAL: - FINISH: -	PRODUCT SPEC: - APPLICATION SPEC: - WEIGHT: - SCALE: 1:2	SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2836265	RESTRICTED TO: - SHEET: 4 OF 4 REV: C