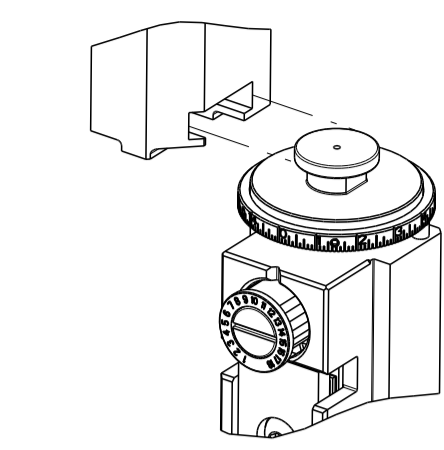


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2836639-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2836639-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2836639-1	B	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2836639-2	B	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2836639-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	3.50 mm [.138]	F
INSUL	5.35 mm [.211]	O

APPLICATOR INSTRUCTIONS 408-35042

TERMINAL DATA: DELPHI TERMINAL DELPHI PACKARD CRIMP SPECIFICATION				
TERMINAL NAME: 280 METRI TAXI TERMINAL, SEALED FEMALE				
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE			
4.60-5.36 mm [.181-.211 IN]	∅2.60-3.70 mm [.102-.146 IN]			
TERMINAL APPLICATION SPECIFICATION 12110853 PAGE 10 OF 13 Rev 2013-10-30				
TERMINALS APPLIED				
TE TERMINAL	DELPHI TERMINAL	TE SEAL	DELPHI SEAL	INSULATION SEAL DIAMETER RANGE
1949895-1	12110853	1572716-3	15324980	∅ 2.81-3.49 mm (GRAY)
		1949896-1	15324981	∅ 3.45-4.30 mm (BLUE)
		1949807-1	15324982	∅ 2.03-2.85 mm (GREEN)

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
2.50mm2	1.90+/-0.05 [.075+/- .002]	7.4

- 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 TERMINAL LUBRICANT IS RECOMMENDED.
- 6. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- 7 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.

**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	DWN	APVD
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		B		ECR-22-136418	19APR2022	JWC	ROY

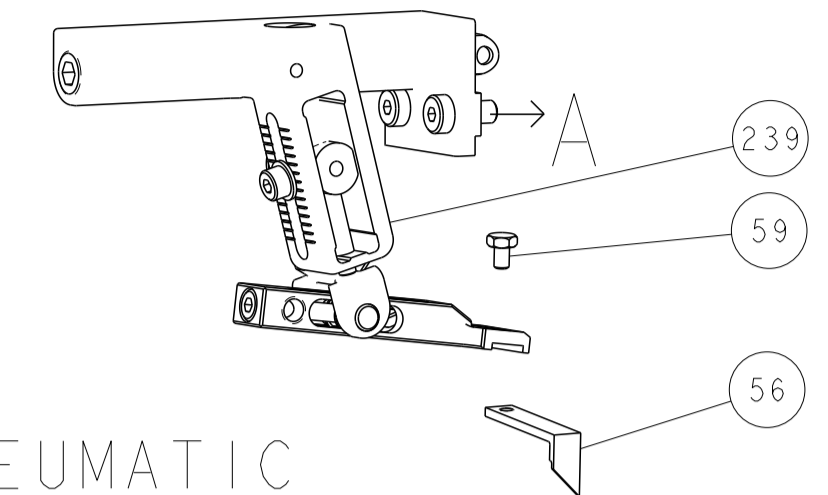
-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248	
-	1	1	1	1	2119082-7	CAM, SNAIL, INSULATION ADJUSTMENT	244	
-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243	
3	-	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242	
-	1	1	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241	
-	-	1	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239	
-	1	-	1	-	2844940-1	AIR FEED MODULE	238	
-	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164	
5	-	1	1	1	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113	
-	1	1	1	1	2844908-1	SCREW, LOCKING	99	
-	1	1	1	1	2844907-1	POST, LOCKING	98	
-	1	1	1	1	455888-6	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	
7	-	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	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	53	
-	1	1	1	1	1803382-2	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	1-1752356-9	SUPPORT, TERMINAL	34	
-	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33	
-	2	2	2	2	3-2844962-5	SPACER, CYLINDRICAL, STRIP GUIDE	30	
-	1	1	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29	
-	1	1	1	1	1-455888-0	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	2119533-2	STRIPPER, SIDE FEED	19	
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	318707-1	FLOATING SHEAR, FRONT	9	
1	1	2	2	1	1-1803334-1	ANVIL, COMBINATION	8	
-	1	1	1	1	1-240641-3	SPACER	7	
-	-	-	-	-	-	-	6	
-	1	1	1	1	2-2119781-4	DEPRESSOR, SHEAR	5	
-	1	1	1	1	3-238011-5	BLOCK, CRIMPER SPACER	4	
1	1	2	2	1	5-1803248-1	CRIMPER, INSULATION O PREMIUM	3	
-	1	1	1	1	455888-7	SPACER, CRIMPER	2	
1	1	2	2	1	9-1633664-4	CRIMPER, WIRE	1	
-	77	-72	-71	-2	-1	PART NO	DESCRIPTION	ITEM NO

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

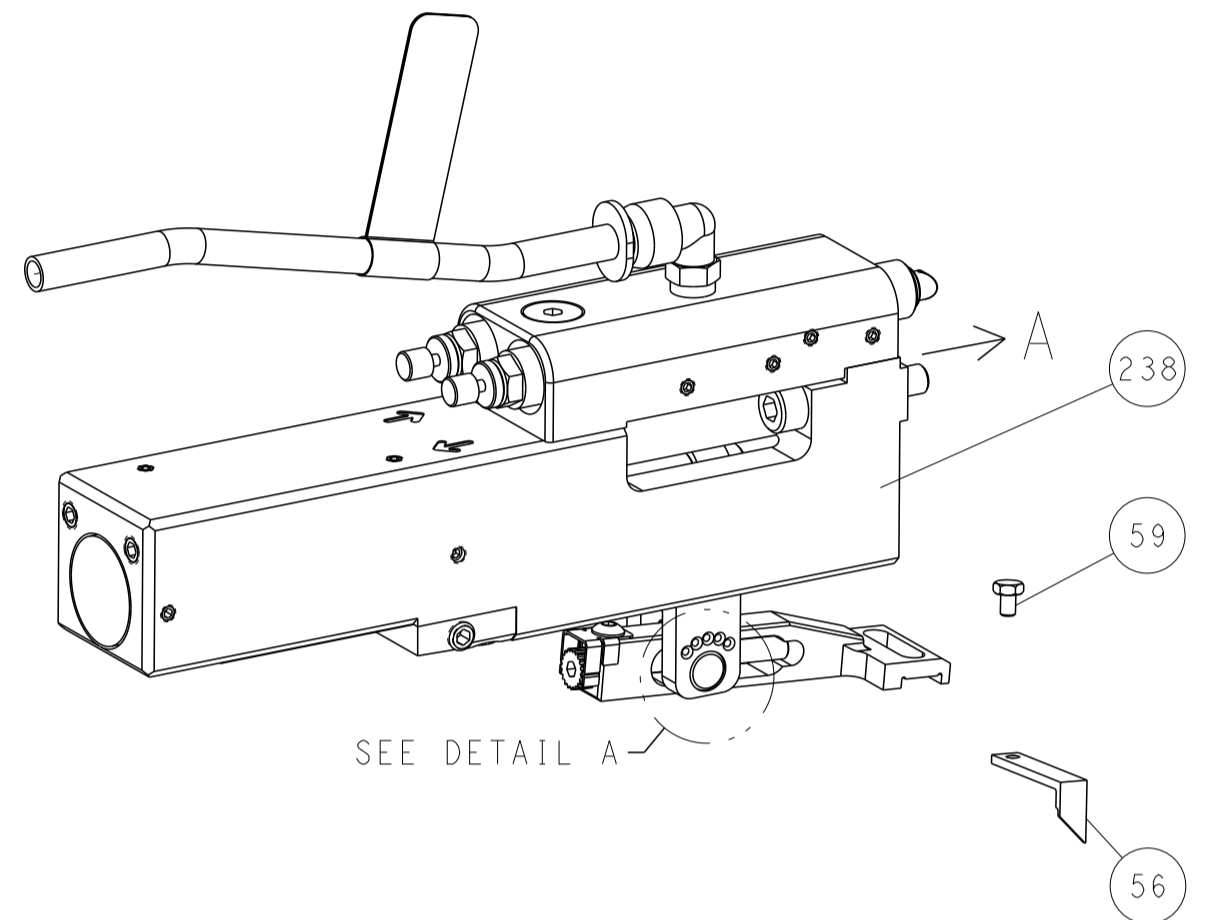
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CHK	K. ZHANG	01MAR2017		Ocean Side Feed Applicator	
APVD	K. ZHANG	01MAR2017	Customer Accessible Production Drawing		
SCALE	1:2	SHEET	1	OF	4
REV	B				

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

# FEED TYPE MECHANICAL



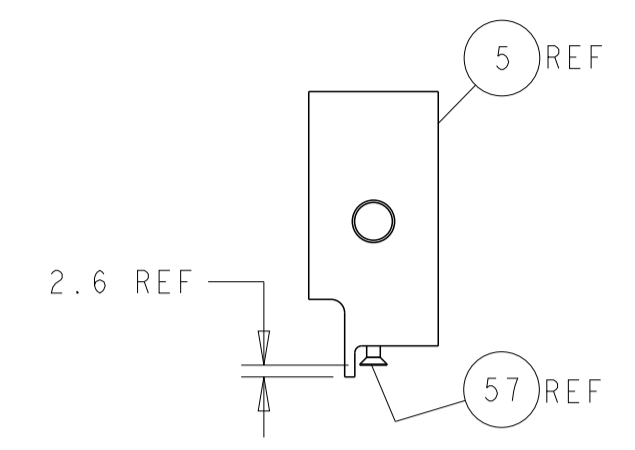
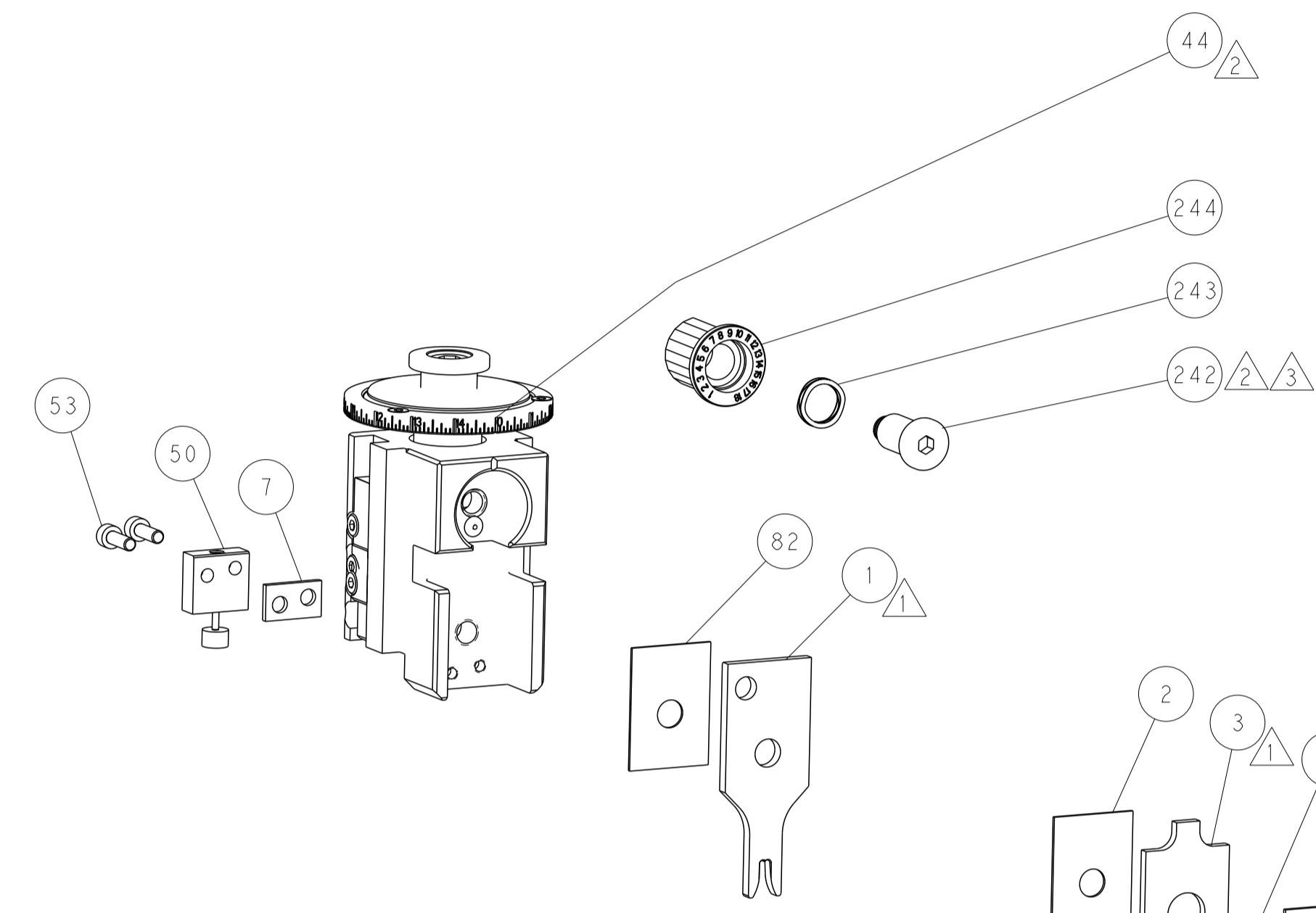
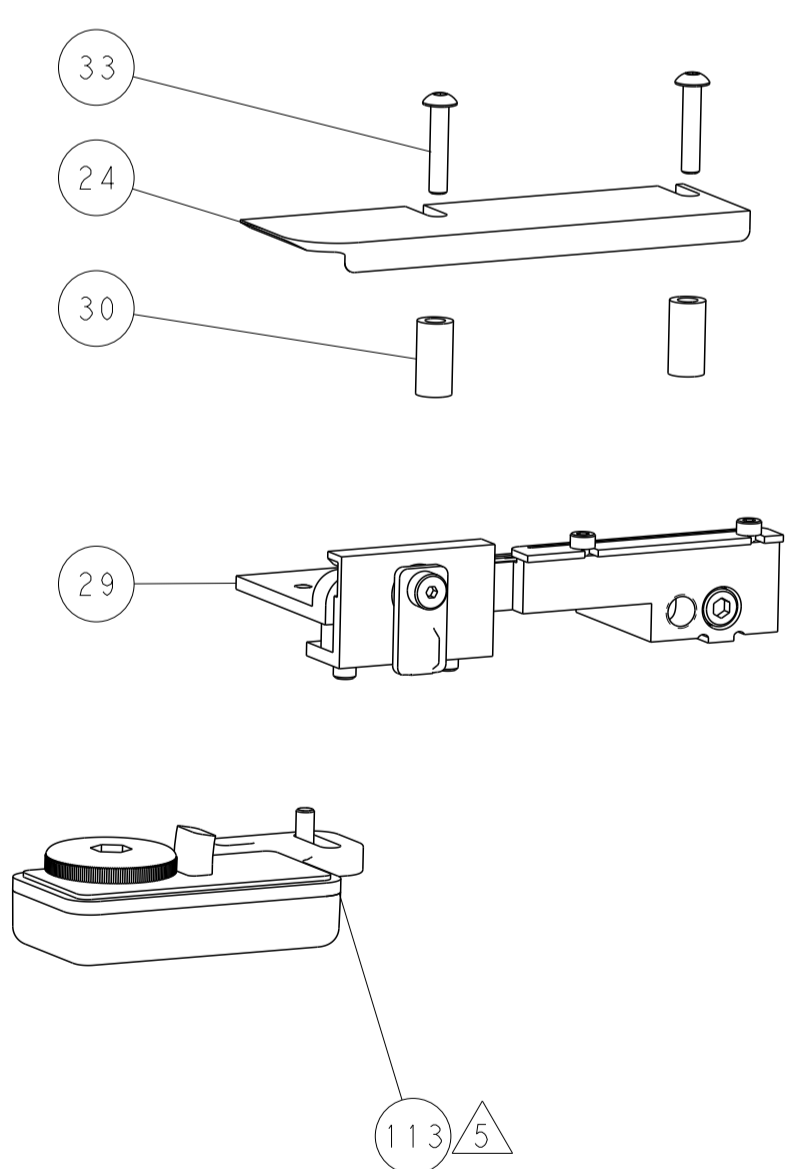
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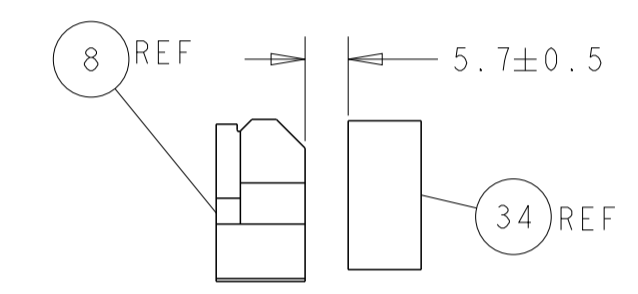
## FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



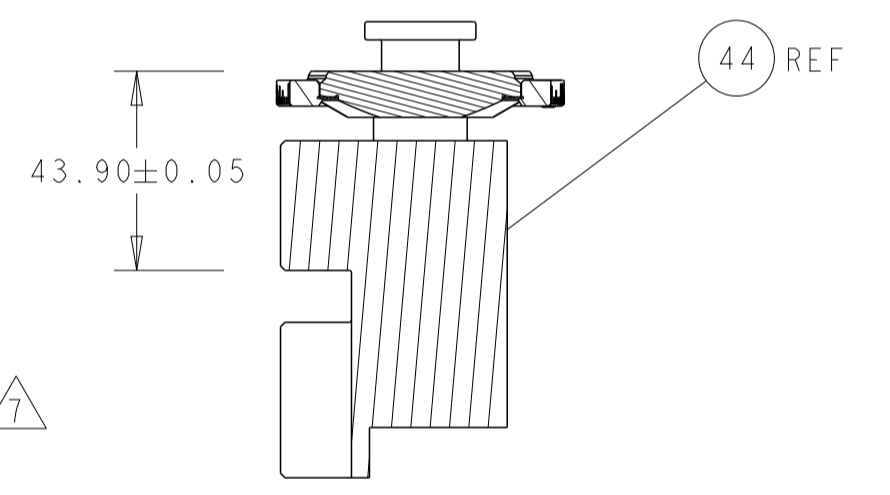
DETAIL A



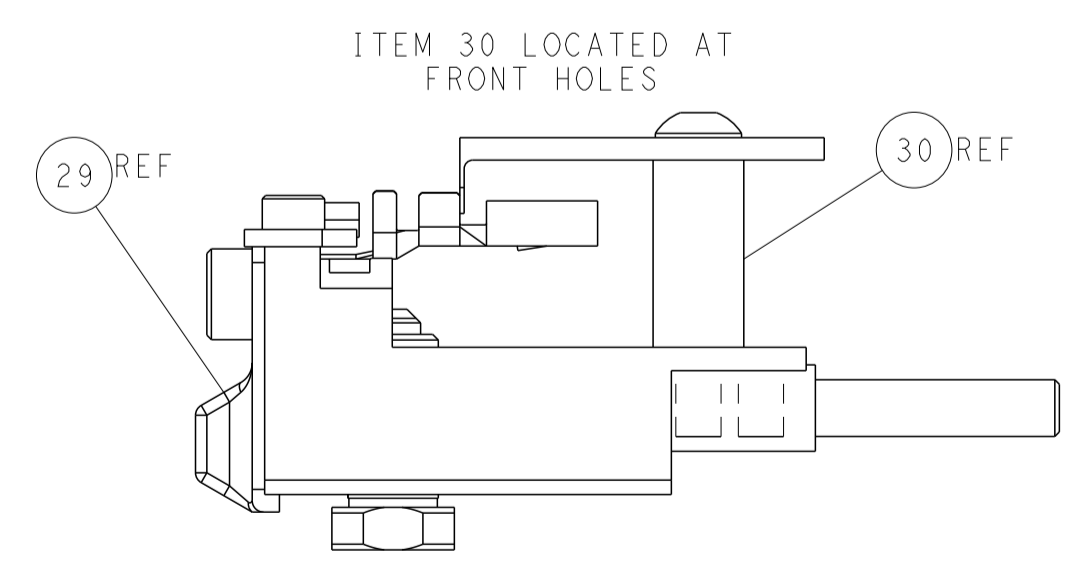
SHEAR DEPRESSOR DETAIL



TERMINAL SUPPORT LOCATION

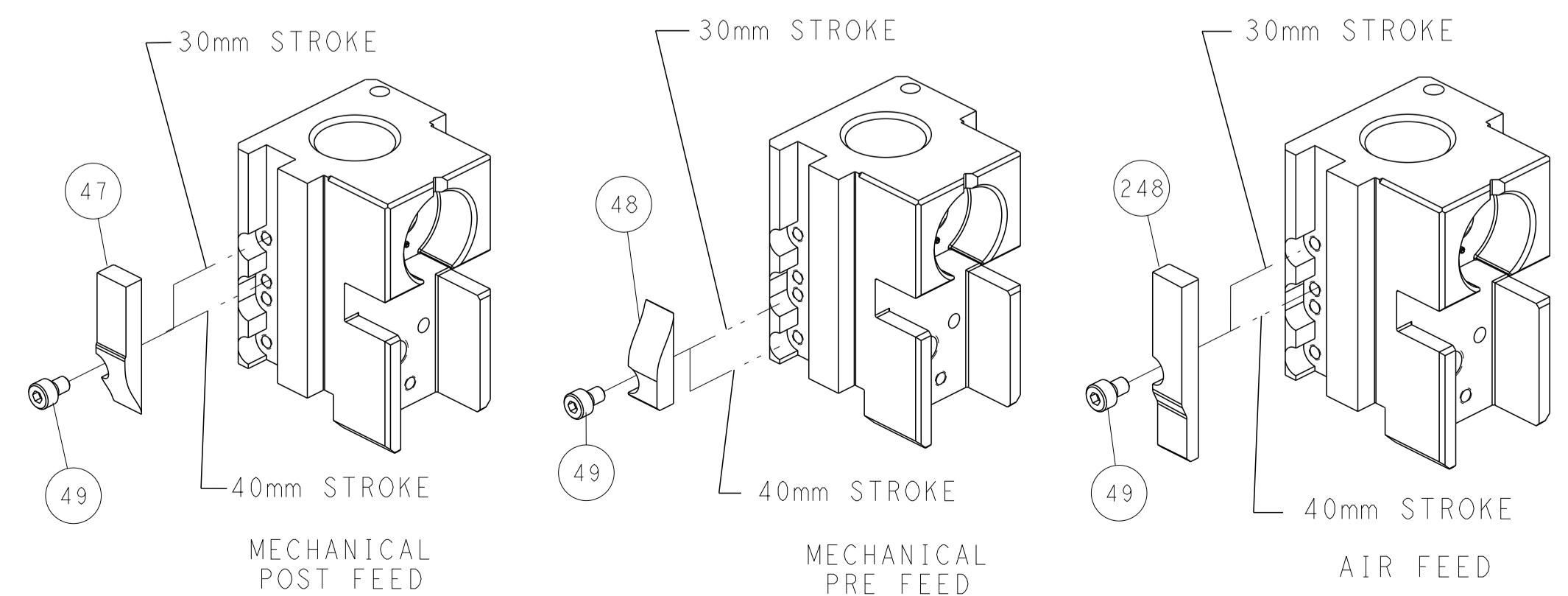


RAM SET-UP



FEED TRACK POSITION GUIDE BY WIRE 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)

<small>THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION. COPYRIGHT 20 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.</small>		DMN: M. ZHAO 01MAR2017 CHK: K. ZHANG 01MAR2017 APVD: K. ZHANG 01MAR2017	NAME: Ocean Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2836639	TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±	MATERIAL: - FINISH: -	WEIGHT: - SCALE: 1:2	SHEET 2 OF 4 REV B	RESTRICTED TO: -

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2836639-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2836639-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2836639-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR  
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	3.50 mm [.138]	F
INSUL	5.35 mm [.211]	O
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: DELPHI TERMINAL DELPHI PACKARD CRIMP SPECIFICATION	
TERMINAL NAME: 280 METRI TAXI TERMINAL, SEALED FEMALE	
WIRE STRIP LENGTH 4.60-5.36 mm [.181-.211 IN]	INSULATION DIAMETER RANGE Ø 2.60-3.70 mm [.102-.146 IN]
TERMINAL APPLICATION SPECIFICATION 12110853 PAGE 10 OF 13 Rev 2013-10-30	

TERMINALS APPLIED				
TE TERMINAL	DELPHI TERMINAL	TE SEAL	DELPHI SEAL	INSULATION SEAL DIAMETER RANGE
1949895-1	12110853	1572716-3	15324980	Ø 2.81-3.49 mm (GRAY)
		1949896-1	15324981	Ø 3.45-4.30 mm (BLUE)
		1949807-1	15324982	Ø 2.03-2.85 mm (GREEN)

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
2.50mm <sup>2</sup>	1.90 +/- 0.05 [.075 +/- .002]	7.4



- 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 TERMINAL LUBRICANT IS RECOMMENDED.
- 6. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- 7 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					
A	66	P	LTN	DESCRIPTION	DATE	OWN	APVD
		-		SEE SHEET 1			

-	1	1	2119082-7	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
3	-	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
5	-	1	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113
-	1	1	2844908-1	SCREW, LOCKING	99
-	1	1	2844907-1	POST, LOCKING	98
-	1	1	455888-6	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
7	-	1	985575-3	SCR, FLT SKT HD CAP M3 X 10.0	57
-	1	1	1338683-8	FEED PAWL	56
-	2	2	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	53
-	1	1	1803382-2	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	1-1752356-9	SUPPORT, TERMINAL	34
-	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	3-2844962-5	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29
-	1	1	1-455888-0	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	2119533-2	STRIPPER, SIDE FEED	19
8	-	1	2119806-1	INSERT, SHEAR	13
-	1	1	3-22280-3	SPRING, COMPRESSION	12
-	1	1	1-356885-4	STOP, SHEAR	11
9	-	1	2119805-1	SHEAR HOLDER, FRONT	10
-	1	1	318707-1	FLOATING SHEAR, FRONT	9
10	1	1	1-1803334-1	ANVIL, COMBINATION	8
-	1	1	1-240641-3	SPACER	7
-	-	-	-	-	6
-	1	1	2-2119781-4	DEPRESSOR, SHEAR	5
-	1	1	3-238011-5	BLOCK, CRIMPER SPACER	4
11	1	1	5-1803248-1	CRIMPER, INSULATION O PREMIUM	3
-	1	1	455888-7	SPACER, CRIMPER	2
12	1	1	9-1633664-4	CRIMPER, WIRE	1

DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DRAWING NO		RESTRICTED TO	
0 PLC	±	0.13	±	01MAR2017	Customer Accessible Production Drawing		
1 PLC	±	0.25	±	01MAR2017	SCALE	1:2	SHEET 3 OF 4
2 PLC	±	0.38	±		REV	B	
3 PLC	±	0.51	±				
4 PLC	±	0.64	±				
ANGLES	±		±				
FINISH							

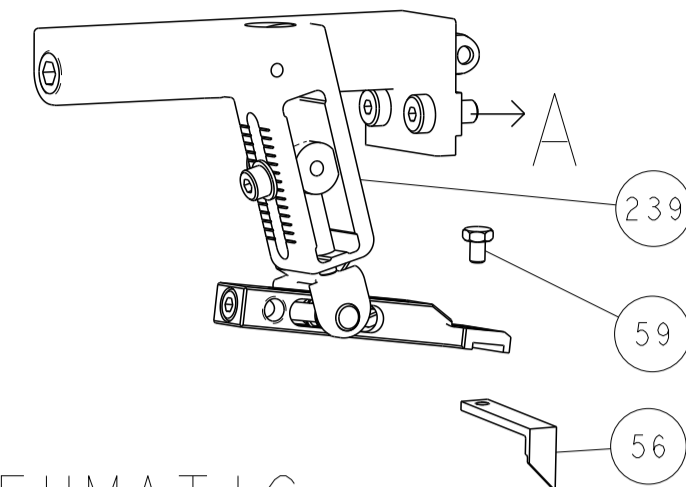


Ocean Side Feed  
Applicator

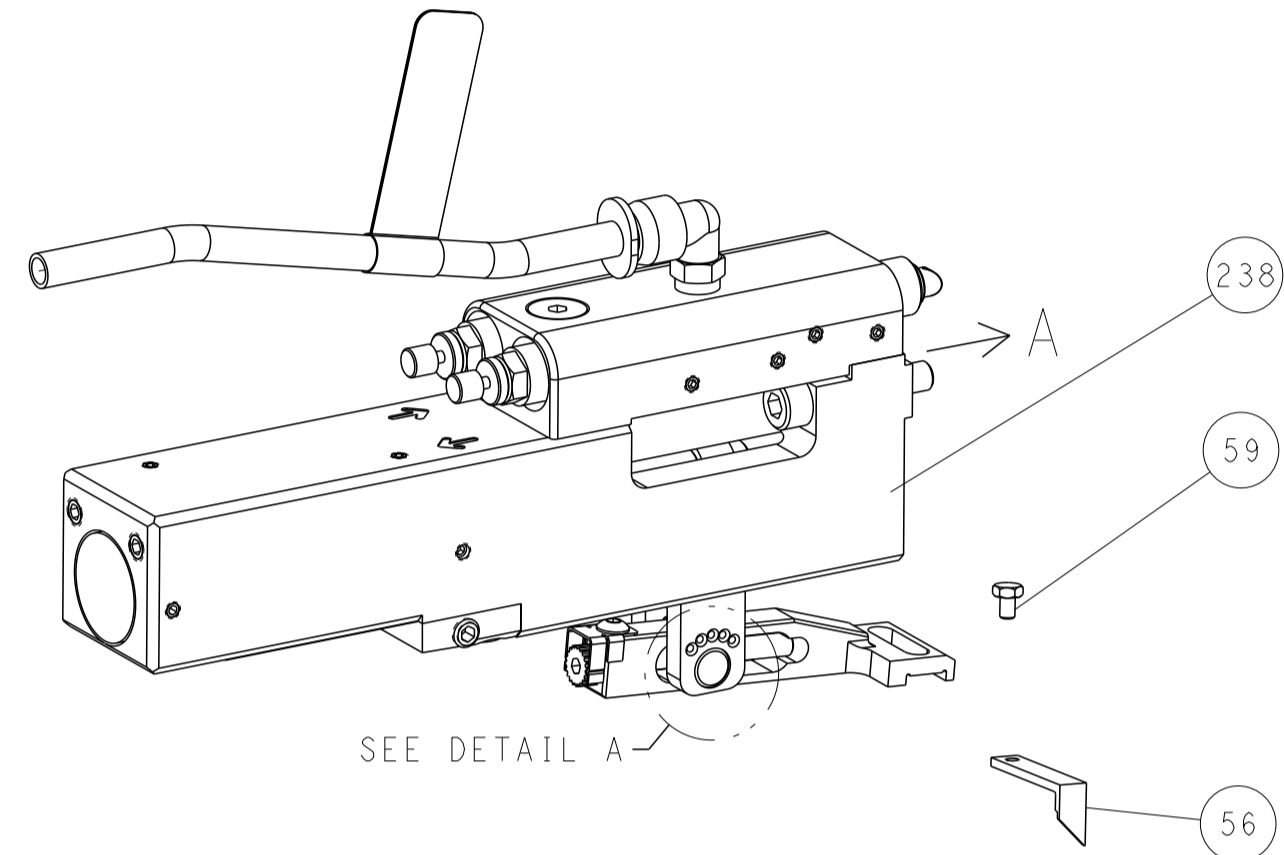
SIZE CAGE CODE DRAWING NO  
A1 00779 C=2836639

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

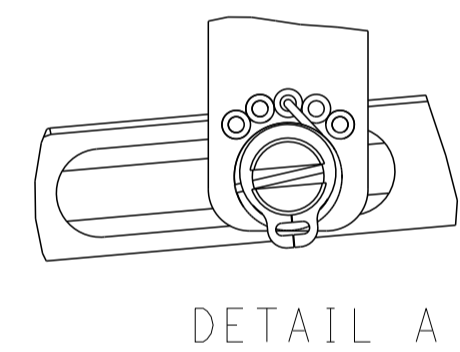
# FEED TYPE MECHANICAL



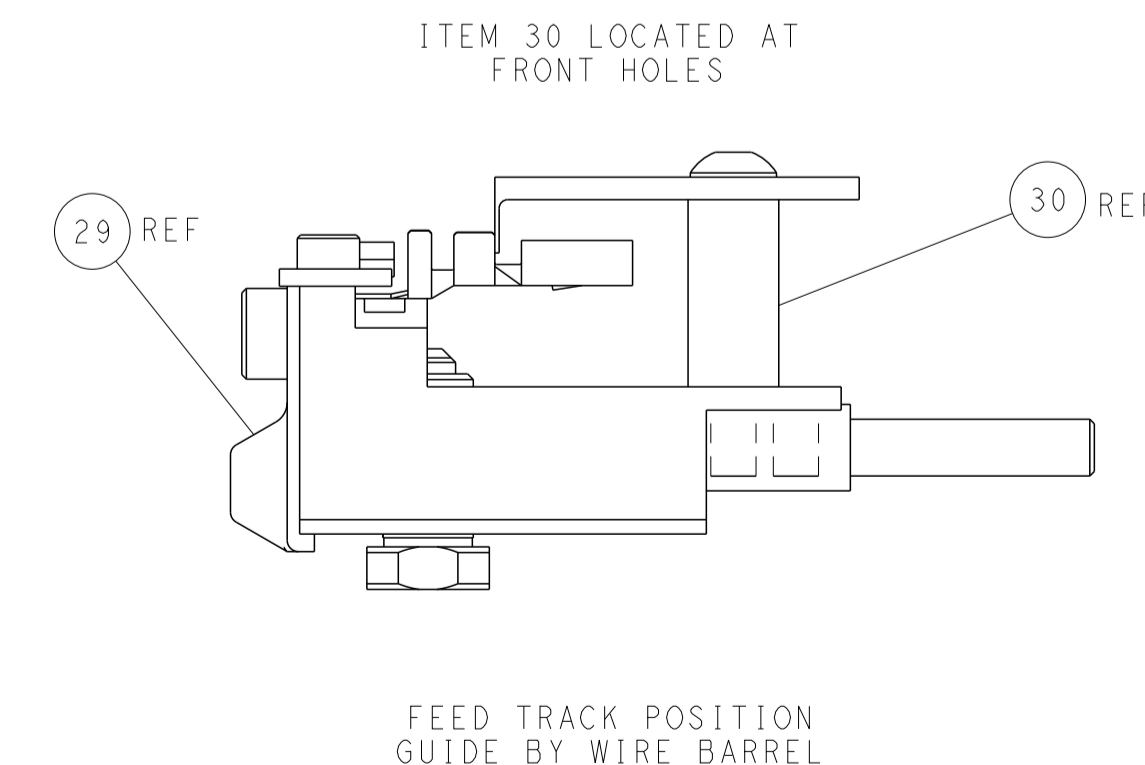
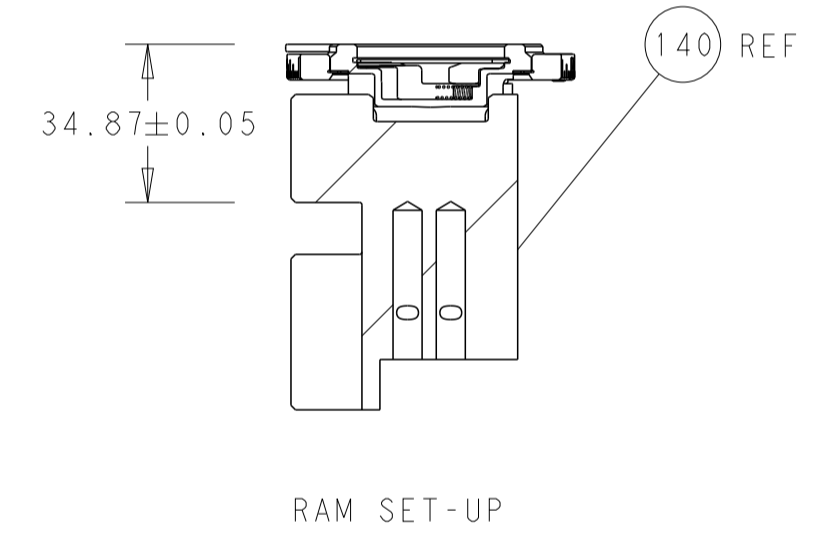
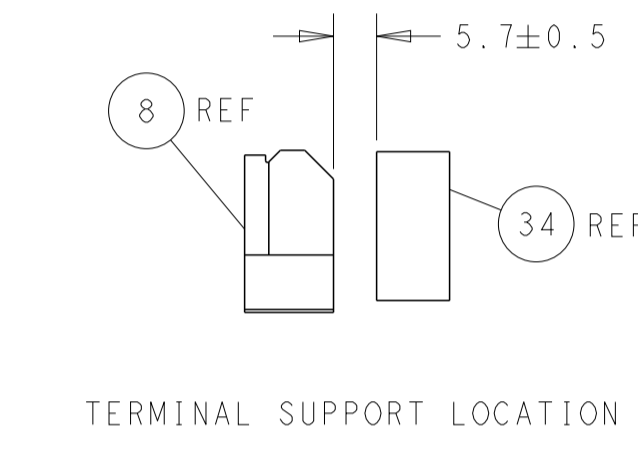
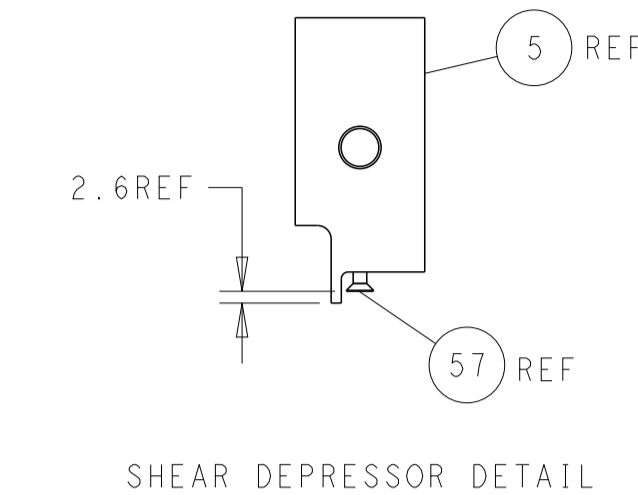
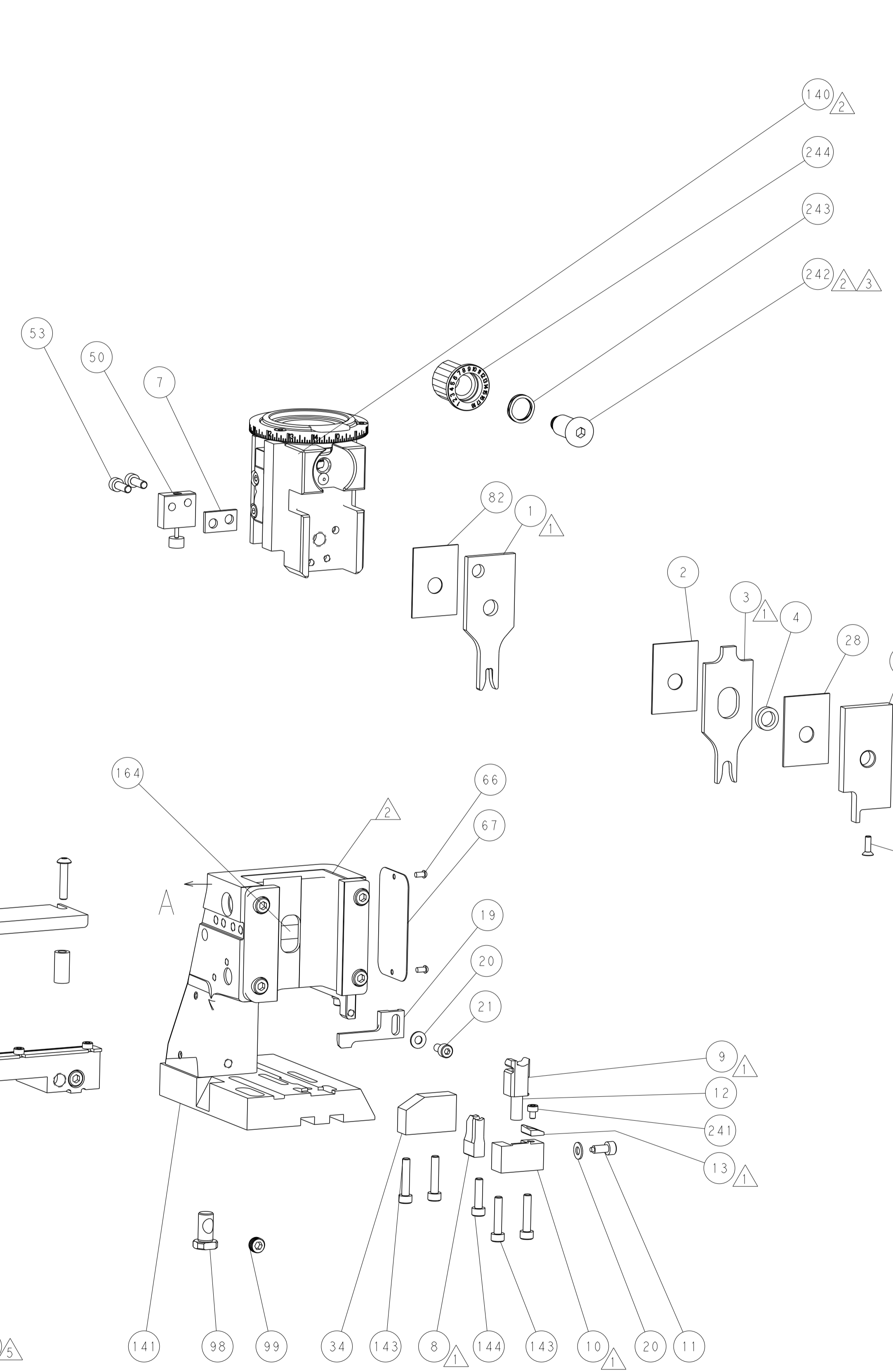
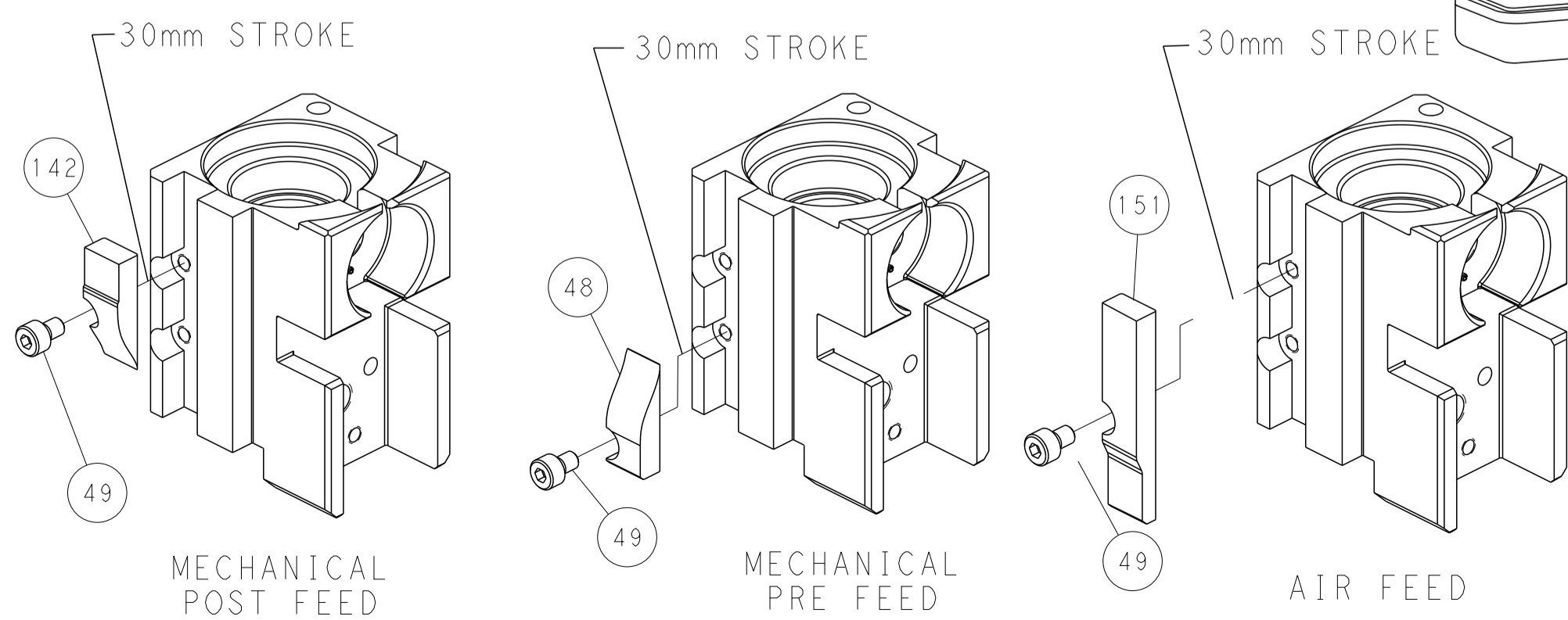
## PNEUMATIC



### FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



## CAM POSITIONS



**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:		DWG: M. ZHAO 01MAR2017		TE Connectivity	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	Harrisburg, PA 17105-3608	
MATERIAL:		FINISH:		CHK: K. ZHANG 01MAR2017		NAME: Ocean Side Feed Applicator	
				APVD: K. ZHANG 01MAR2017		PRODUCT SPEC:	
				APPLICATION SPEC:		SIZE: CAGE CODE: DRAWING NO:	
				WEIGHT:		RESTRICTED TO:	
				A   00779   ©=2836639		SCALE: 1:2 SHEET 4 OF 4 REV B	
Customer Accessible Production Drawing							