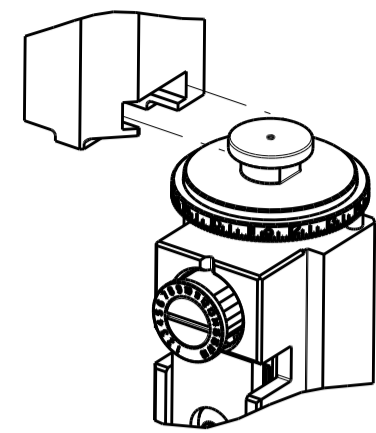


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2836908-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2836908-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2836908-1	B	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2836908-2	B	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2836908-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.03 mm [.080]	F
INSUL	3.05 mm [.120]	O

APPLICATOR INSTRUCTIONS 408-35042

TERMINAL DATA: DELPHI PACKARD/FCI TERMINAL DELPHI PACKARD CRIMP SPECIFICATION	
TERMINAL NAME: APEX 1.2 TERMINAL, FEMALE	
WIRE STRIP LENGTH	TERMINAL INSULATION DIAMETER RANGE
4.84-5.60 mm [.191-.221 IN]	Ø1.70-2.41 mm [.067-.095 IN]
TERMINAL APPLICATION SPECIFICATION	13576990 PAGE 1 & 3 OF 4 Rev 2014-07-29

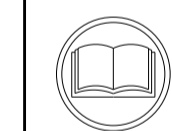
TE TERMINAL	DELPHI PACKARD/FCI TERMINAL	TE SEAL	DELPHI PACKARD/FCI SEAL	SEAL INSULATION DIAMETER RANGE
2318366-1	13805376	2318367-1	C528010	1.7-2.4mm
2318366-2	F731400	2318367-2	A-0419	1.7-2.4mm
2318366-3	13576990	2318367-3	13898958	1.7-2.4mm
2318366-4	54001864	2318367-4	13576991	
2318366-5	13587331	2318367-5	13814607	
2318366-6	54001866			
2318366-7	13579640			
2318366-8	54001863			

TERMINAL DATA: DELPHI PACKARD/FCI TERMINAL TE CRIMP SPECIFICATION	
TERMINAL NAME: APEX 1.2 TERMINAL, FEMALE	
WIRE STRIP LENGTH	TERMINAL INSULATION DIAMETER RANGE
4.84-5.60 mm [.191-.221 IN]	Ø1.70-2.41 mm [.067-.095 IN]
TERMINAL APPLICATION SPECIFICATION	NONE

TE TERMINAL	DELPHI PACKARD/FCI TERMINAL	TE SEAL	DELPHI PACKARD/FCI SEAL	SEAL INSULATION DIAMETER RANGE
2318366-1	13805376	2318367-1	C528010	1.7-2.4mm
2318366-2	F731400	2318367-2	A-0419	1.7-2.4mm
2318366-3	13576990	2318367-3	13898958	1.7-2.4mm
2318366-4	54001864	2318367-4	13576991	
2318366-5	13587331	2318367-5	13814607	
2318366-6	54001866			
2318366-7	13579640			
2318366-8	54001863			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.50mm2	1.45+/-0.05 [.057+/- .002]	6.2
1.00mm2	1.25+/-0.05 [.049+/- .002]	8.4
0.75mm2	1.20+/-0.05 [.047+/- .002]	8.9
0.80mm2	1.15+/-0.05 [.045+/- .002]	9.4

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.25mm2	1.35+/-0.05 [.053+/- .002]	7.3



- 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 APPLY TORO-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.
- 6 THIS CRIMP PARAMETER IS PROVIDED TO MEET A CUSTOM AND UNIQUE CUSTOMER REQUIREMENT. IT HAS BEEN EVALUATED AND IS CONDITIONALLY SPECIFIED BY TE CONNECTIVITY. THIS CUSTOMIZED CRIMP PARAMETER IS NOT LISTED AS AN APPROVED APPLICATION WITHIN THE TERMINAL MANUFACTURER'S SPECIFICATIONS. **TE CONNECTIVITY EXPRESSLY DISCLAIMS ANY AND ALL WARRANTIES THAT THE PRODUCT WILL PERFORM SIMILARLY TO VALIDATED AND APPROVED APPLICATIONS, AS STATED WITHIN THE MANUFACTURER'S APPLICATION SPECIFICATIONS, INCLUDING BUT NOT LIMITED TO IMPLIED WARRANTIES OF MERCHANTABILITY OR FITNESS FOR PARTICULAR PURPOSE.** AS SUCH, IT IS HIGHLY RECOMMENDED THAT THE CUSTOMER PERFORM FURTHER DETAILED EVALUATION TO ASSESS PRODUCT PERFORMANCE IN THE SPECIFIC APPLICATION AND OBTAIN APPROVAL FROM TERMINAL MANUFACTURER FOR THIS CUSTOM REQUIREMENT.
- 7 TERMINAL LUBRICANT IS RECOMMENDED.

8. 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)

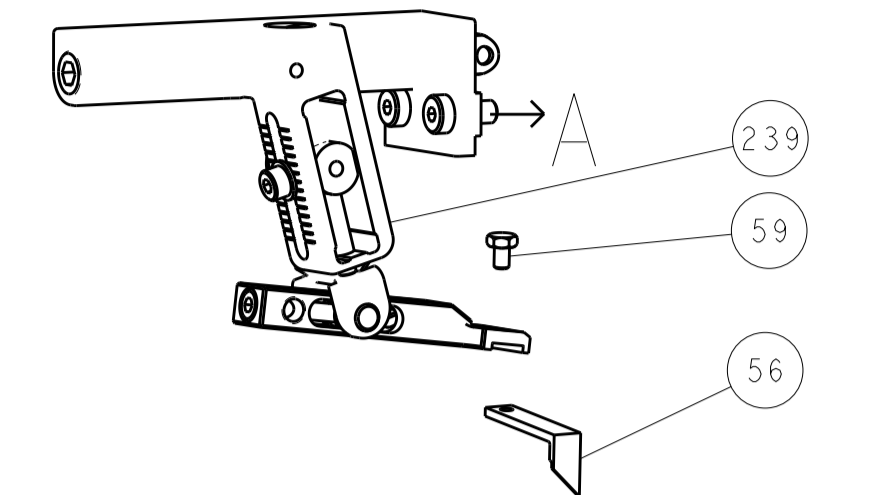
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		B	ECR-19-001393	28JAN2019	FZ KZ

-	1	-	1	-	2119640-1	PUSH ROD, AIR FEED	250	
-	1	-	1	-	1803259-1	BUSHING, FLANGED	249	
-	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	
-	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	-	2063440-1	AIR FEED MODULE	238	
-	2	-	2	-	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172	
-	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164	
-	1	-	1	-	240638-1	SPRING, FEED FINGER	163	
-	1	-	1	-	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854	137	
-	1	-	1	-	2119799-1	HOLDER, FEED FINGER, AF	136	
-	1	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	455888-4	SPACER, CRIMPER	82	
-	1	1	1	1	1803607-1	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	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	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	53	
-	1	1	1	1	5018030-1	NUT, HEX, REG, RoHS, M3	52	
-	1	1	1	1	811242-5	BUMPER, HOLD DOWN	51	
-	1	1	1	1	690753-2	SPACER, TONKER	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	1752356-3	SUPPORT, TERMINAL	34	
-	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33	
-	2	2	2	2	2-2844962-8	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	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	2	2	1	1	8-1633920-0	ANVIL, COMBINATION	8
-	-	-	-	-	-	-	7	
-	-	-	-	-	-	-	6	
-	1	1	1	1	2119781-5	DEPRESSOR, SHEAR	5	
-	1	1	1	1	2-238011-1	BLOCK, CRIMPER SPACER	4	
-	1	2	2	1	1	1-1803143-4	CRIMPER, INSULATION O	3
-	1	1	1	1	455888-7	SPACER, CRIMPER	2	
-	1	2	2	1	1	2-456405-7	CRIMPER, WIRE PREMIUM	1

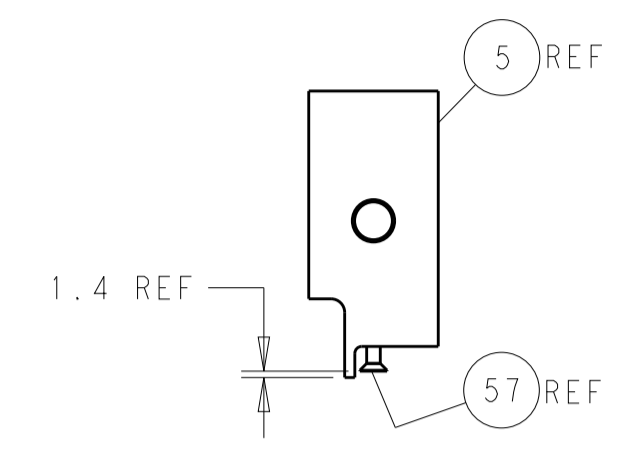
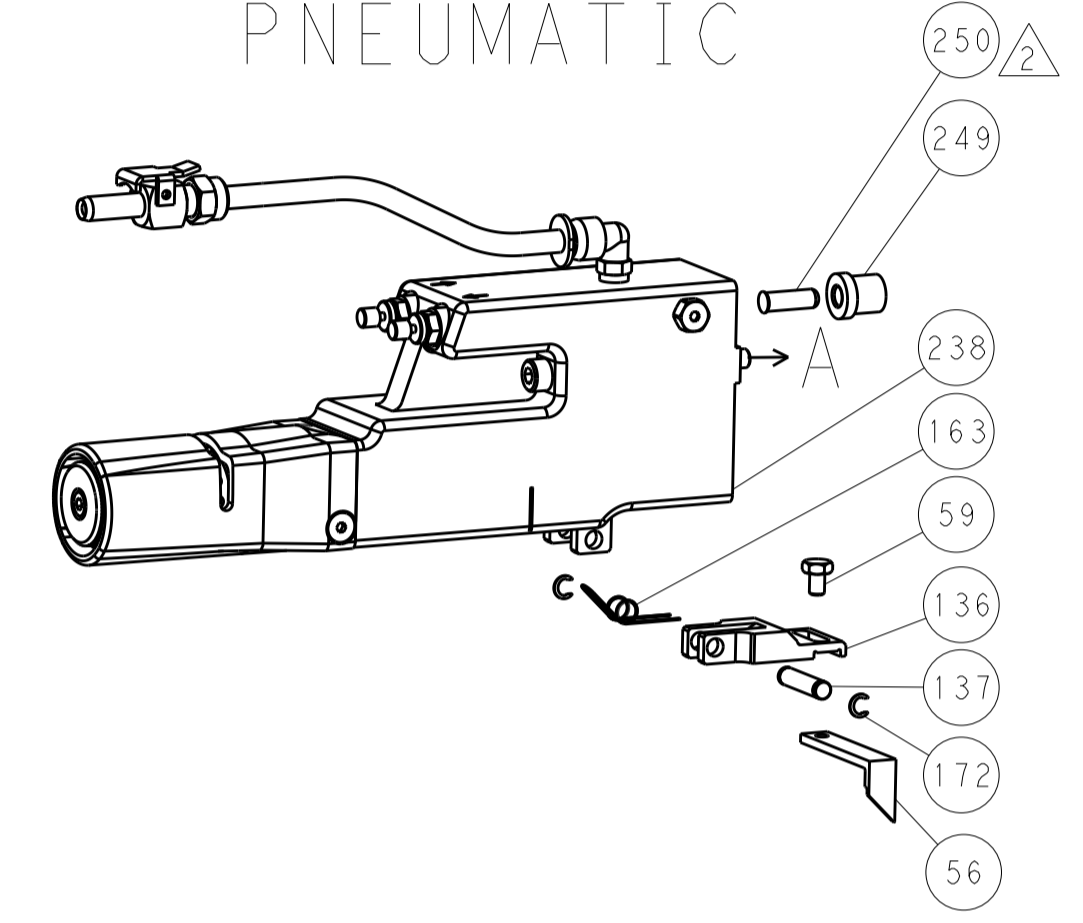
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mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES ±	FINISH	WT	SCALE	SHEET	REV
									1:2	1 OF 4	B

LOC	DIST	REV	DATE	BY	CHK	APP'D
A	66					

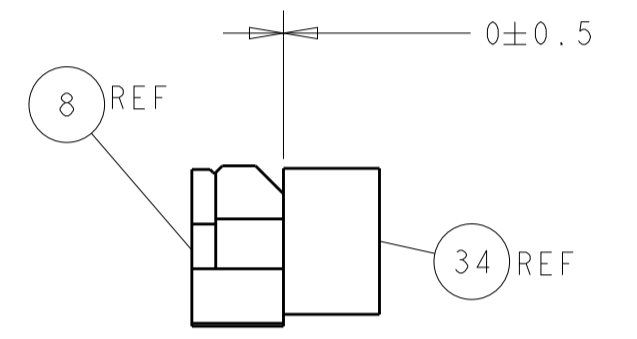
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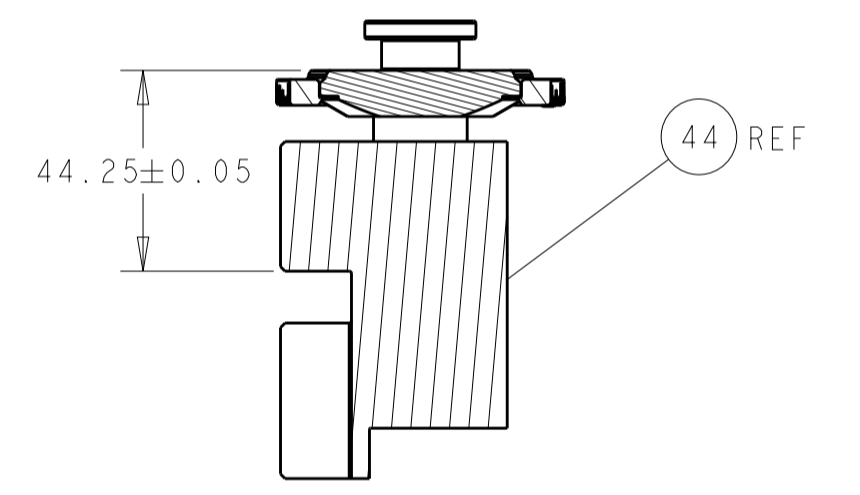
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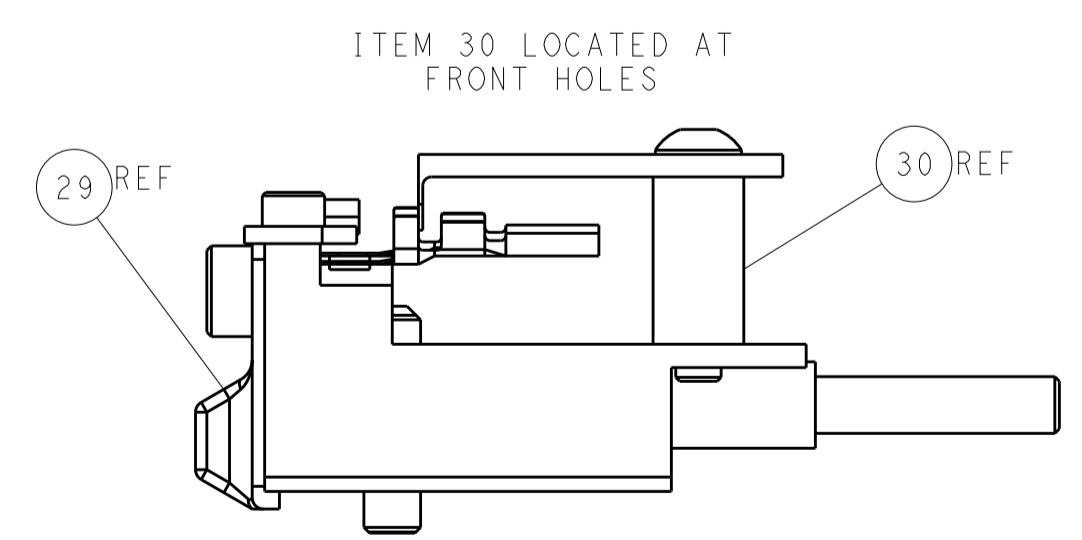
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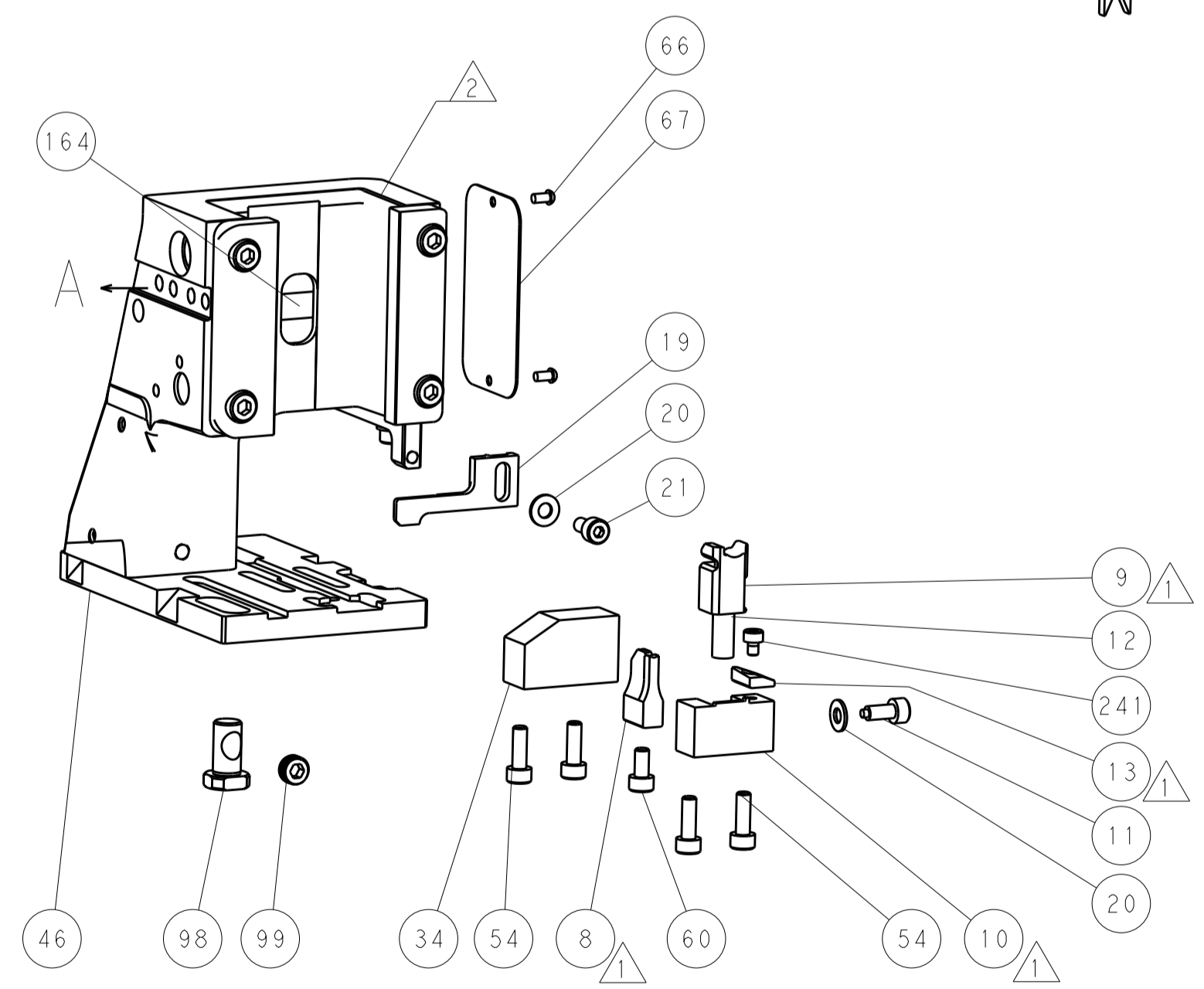
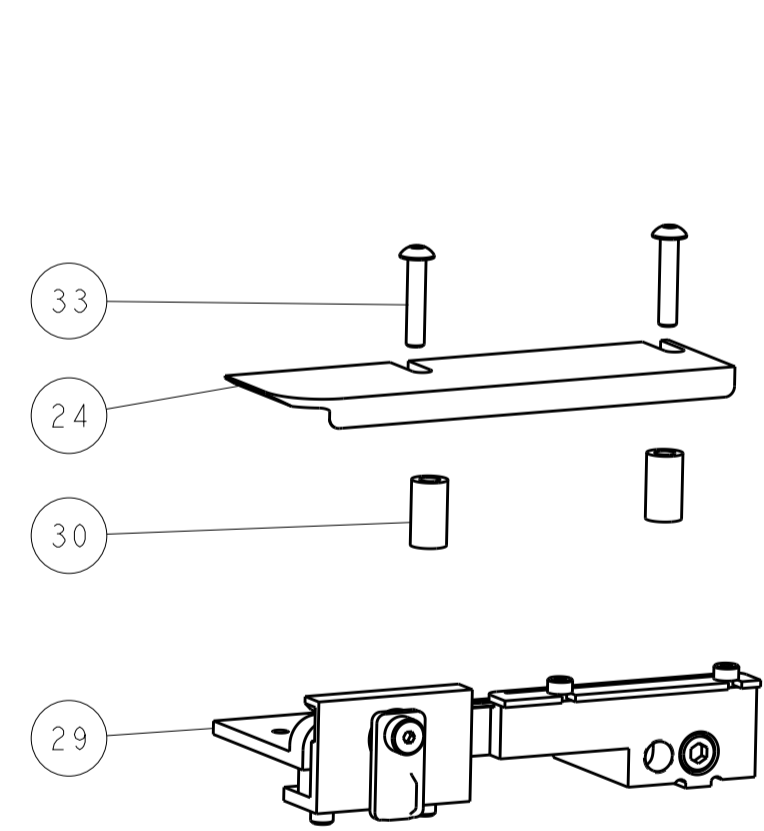
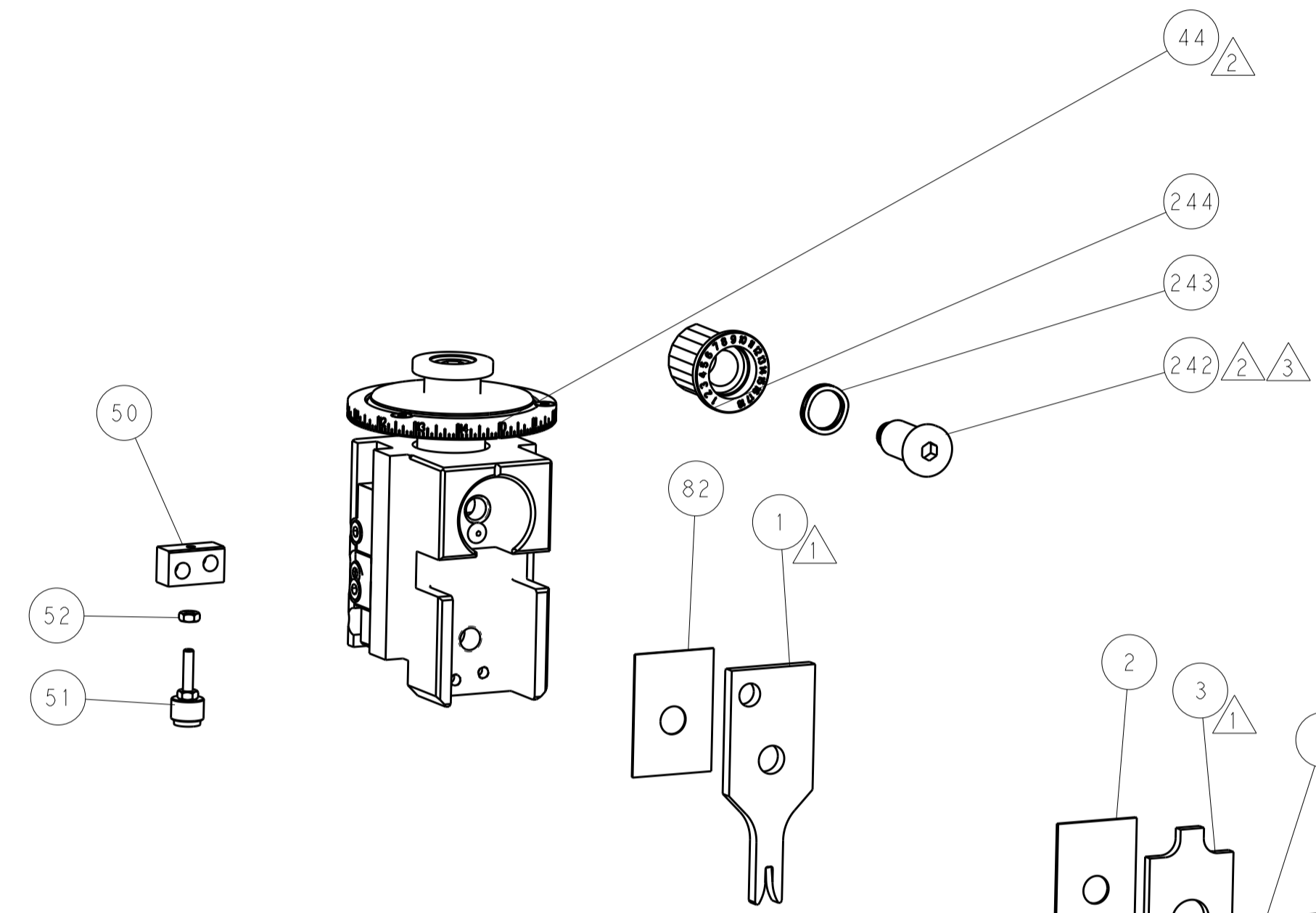
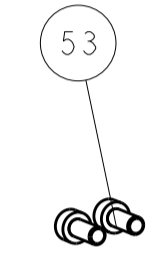
TERMINAL SUPPORT LOCATION



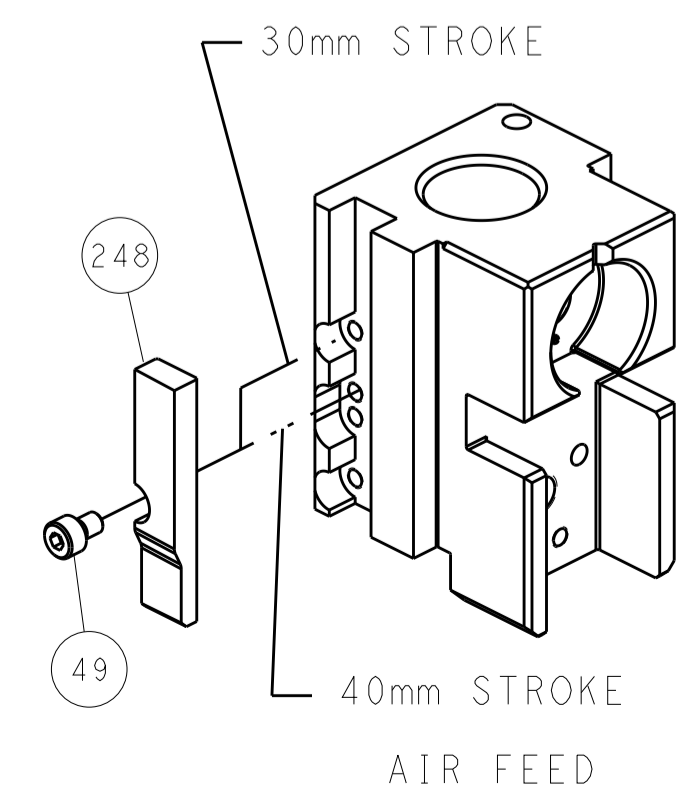
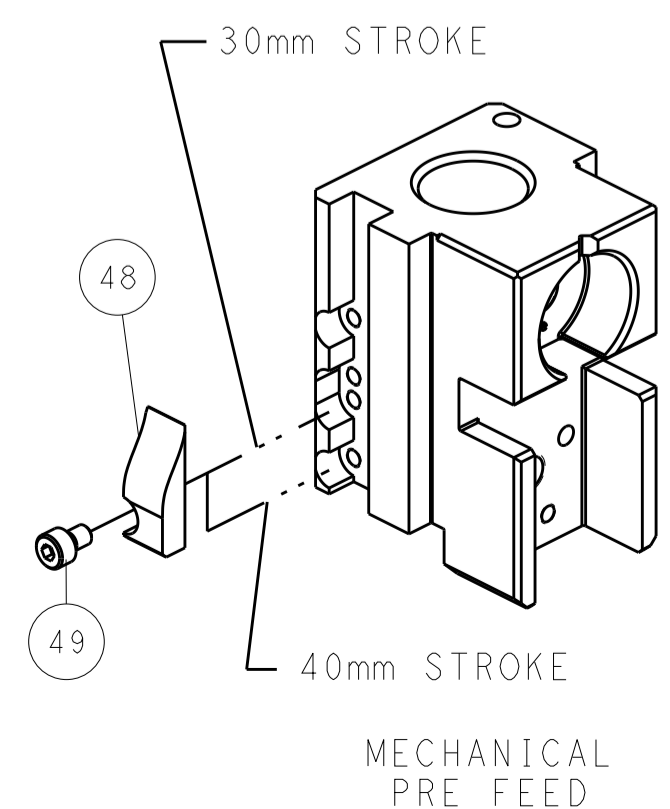
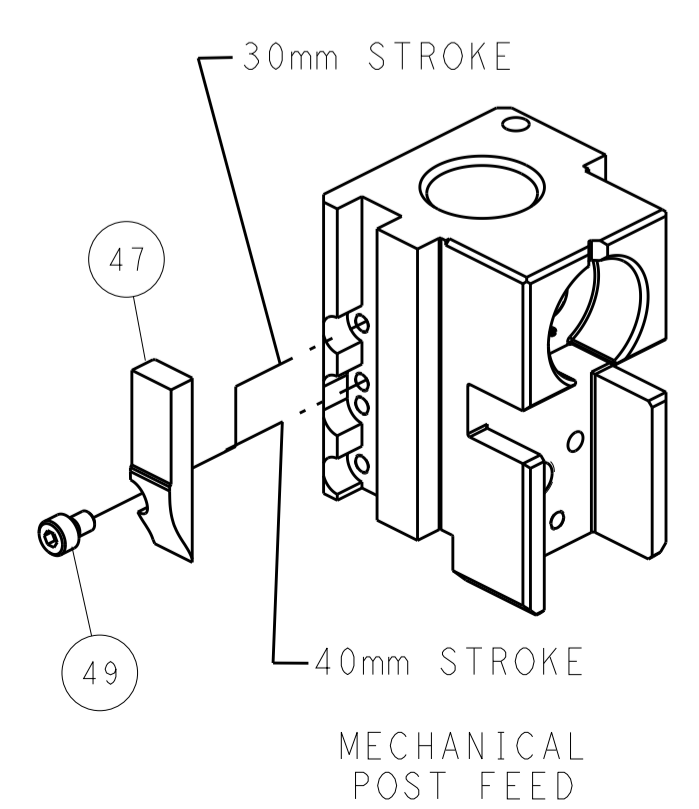
RAM SET-UP



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. ZHAO 24AUG2017		TE Connectivity	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	Harrisburg, PA 17105-3608	
MATERIAL:		FINISH:		CHK: K. ZHANG 24AUG2017		NAME: Ocean Side Feed Applicator	
				APVD: K. ZHANG 24AUG2017		SIZE: CAGE CODE: DRAWING NO: A1 00779 ©=2836908	
				WEIGHT:		RESTRICTED TO: Customer Accessible Production Drawing	
				SCALE: 1:2		SHEET 2 OF 4 REV B	

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2836908-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2836908-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2836908-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.03 mm [.080]	F
INSUL	3.05 mm [.120]	O

APPLICATOR INSTRUCTIONS
408-35042

TERMINAL DATA: DELPHI PACKARD/FCI TERMINAL DELPHI PACKARD CRIMP SPECIFICATION	
TERMINAL NAME: APEX 1.2 TERMINAL, FEMALE	
WIRE STRIP LENGTH 4.84-5.60 mm [.191-.221 IN]	TERMINAL INSULATION DIAMETER RANGE Ø1.70-2.41 mm [.067-.095 IN]
TERMINAL APPLICATION SPECIFICATION 13576990 PAGE 1 & 3 OF 4 Rev 2014-07-29	

TERMINALS APPLIED				
TE TERMINAL	DELPHI PACKARD/FCI TERMINAL	TE SEAL	DELPHI PACKARD/FCI SEAL	SEAL INSULATION DIAMETER RANGE
2318366-1	13805376	2318367-1	C528010	1.7-2.4mm
2318366-2	F731400	2318367-2	A-0419	1.7-2.4mm
2318366-3	13576990	2318367-3	13898958	1.7-2.4mm
2318366-4	54001864	2318367-4	13576991	
2318366-5	13587331	2318367-5	13814607	
2318366-6	54001866			
2318366-7	13579640			
2318366-8	54001863			

TERMINAL DATA: DELPHI PACKARD/FCI TERMINAL TE CRIMP SPECIFICATION	
TERMINAL NAME: APEX 1.2 TERMINAL, FEMALE	
WIRE STRIP LENGTH 4.84-5.60 mm [.191-.221 IN]	TERMINAL INSULATION DIAMETER RANGE Ø1.70-2.41 mm [.067-.095 IN]
TERMINAL APPLICATION SPECIFICATION NONE	

TERMINALS APPLIED				
TE TERMINAL	DELPHI PACKARD/FCI TERMINAL	TE SEAL	DELPHI PACKARD/FCI SEAL	SEAL INSULATION DIAMETER RANGE
2318366-1	13805376	2318367-1	C528010	1.7-2.4mm
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2318366-6	54001866			
2318366-7	13579640			
2318366-8	54001863			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.50mm2	1.45+/-0.05 [.057+/-0.002]	6.2
1.00mm2	1.25+/-0.05 [.049+/-0.002]	8.4
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0.80mm2	1.15+/-0.05 [.045+/-0.002]	9.4

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.25mm2	1.35+/-0.05 [.053+/-0.002]	7.3

- 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 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.
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- 7 TERMINAL LUBRICANT IS RECOMMENDED.
- 8. 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.

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	CHK	APPV
A	66					

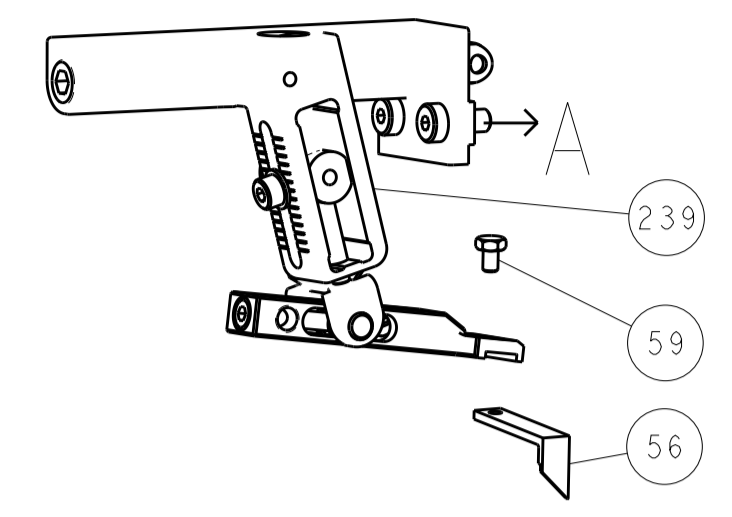
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-	1	2079764-1				243
-	1	2119083-1				242
-	1	7-18023-7				241
-	-	2119580-1				239
-	1	2063440-1				238
-	2	21045-3				172
-	REF	994970-2				164
-	1	240638-1				163
-	1	2119641-2				151
-	1	2168083-8				144
-	4	2168083-9				143
-	-	2119653-2				142
-	1	1-1803583-0				141
-	1	1803516-1				140
-	1	3-23627-7				137
-	1	2119799-1				136
-	1	2119955-1				113
-	1	2844908-1				99
-	1	2844907-1				98
-	1	455888-4				82
-	1	1803607-1				71
-	1	2119740-1				67
-	2	2168078-1				66
-	1	5-18022-5				59
-	1	985575-3				57
-	1	1338683-8				56
-	2	1-2168083-0				53
-	1	5018030-1				52
-	1	811242-5				51
-	1	690753-2				50
-	1	18023-9				49
-	-	2119652-1				48
-	1	1803602-1				41
-	1	1752356-3				34
-	2	2079383-5				33
-	2	2-2844962-8				30
-	1	2844992-1				29
-	1	455888-3				28
-	1	1320928-2				24
-	1	2168083-2				21
-	2	1-18028-2				20
-	1	2119533-1				19
-	1	2119806-1				13
-	1	3-22280-3				12
-	1	1-356885-4				11
-	1	2119805-1				10
-	1	318707-1				9
-	1	8-1633920-0				8
-	-	-				7
-	-	-				6
-	1	2119781-5				5
-	1	2-238011-1				4
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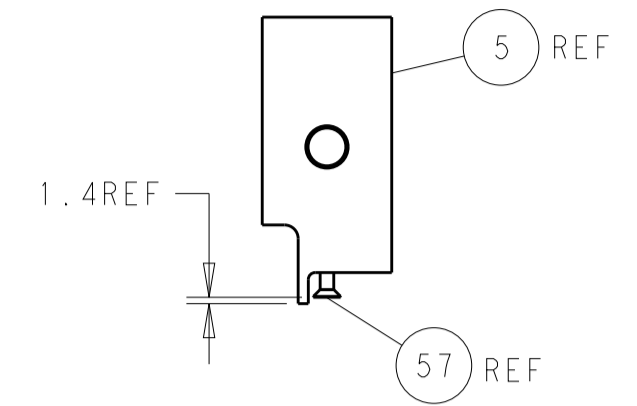
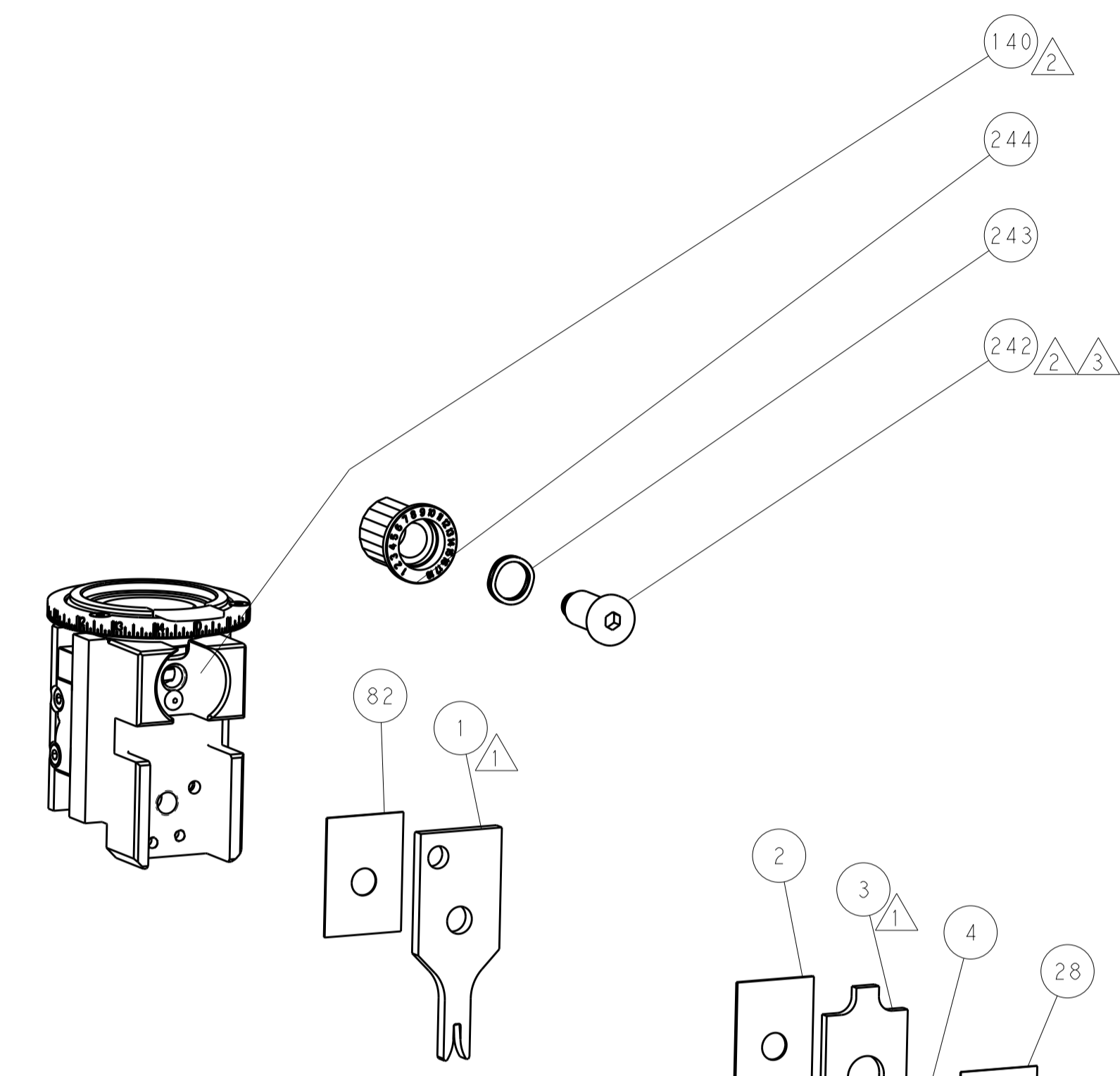
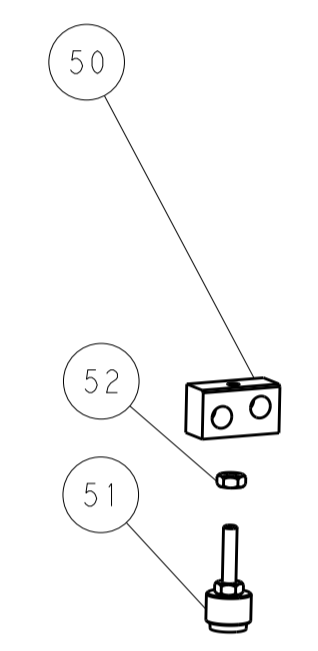
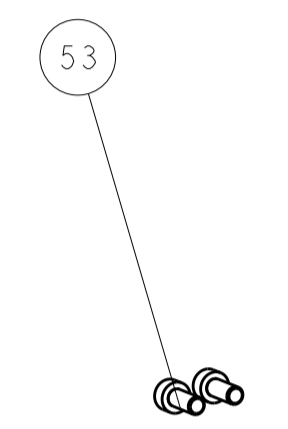
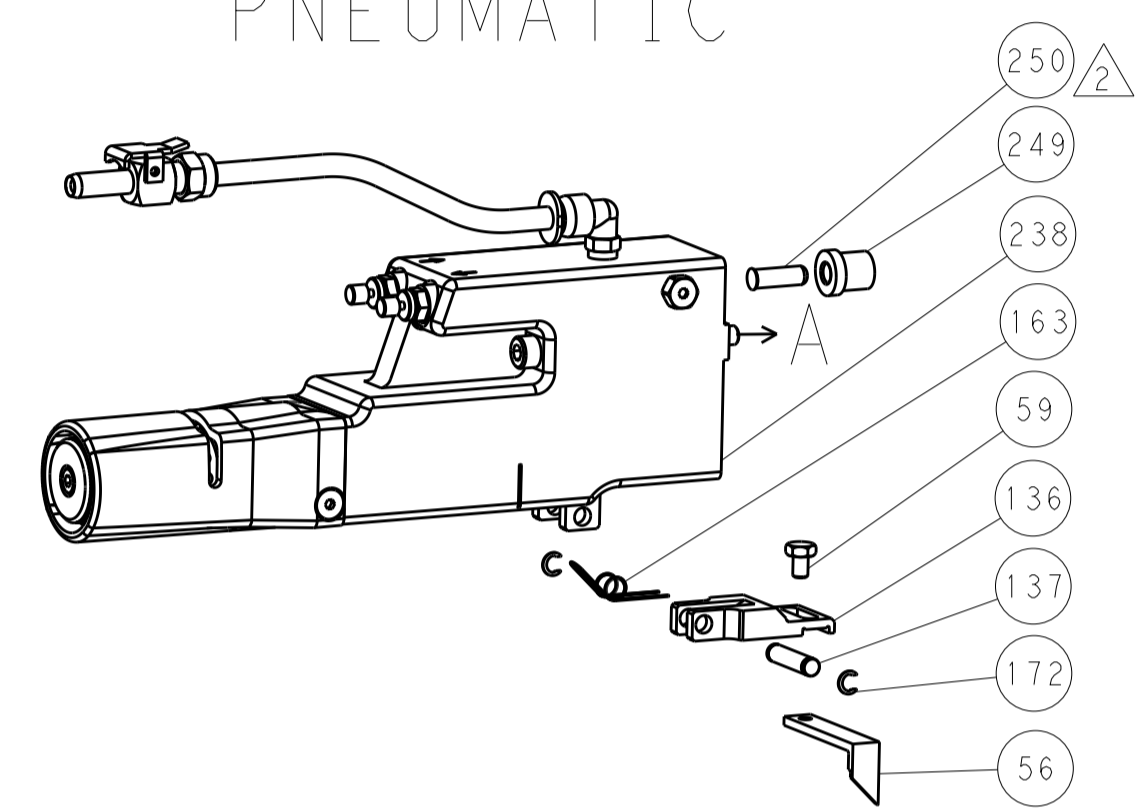
TE CONNECTIVITY	24AUG2017	DM ZHAO	24AUG2017	CHK K. ZHANG	24AUG2017	APPV K. ZHANG	24AUG2017
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		NAME		RESTRICTED TO	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES ±	FINISH ±
MATERIAL		FINISH		WEIGHT		SCALE	
				A1 00779		SCALE 1:2 SHEET 3 OF 4 REV B	

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

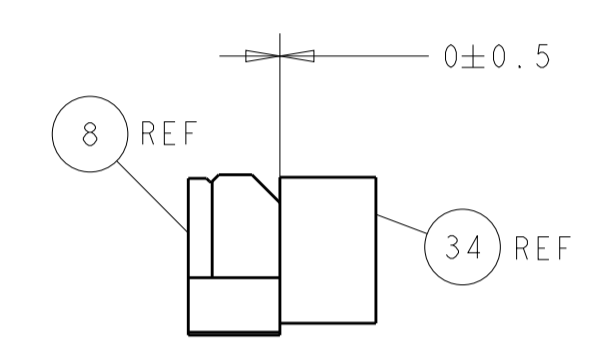
FEED TYPE MECHANICAL



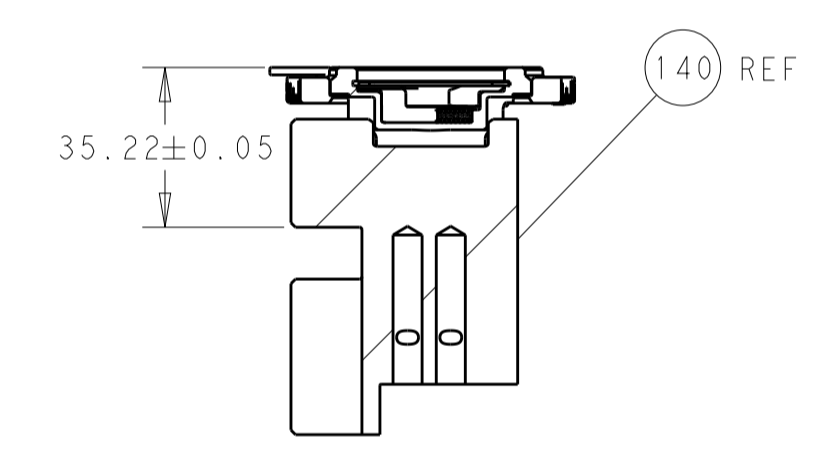
PNEUMATIC



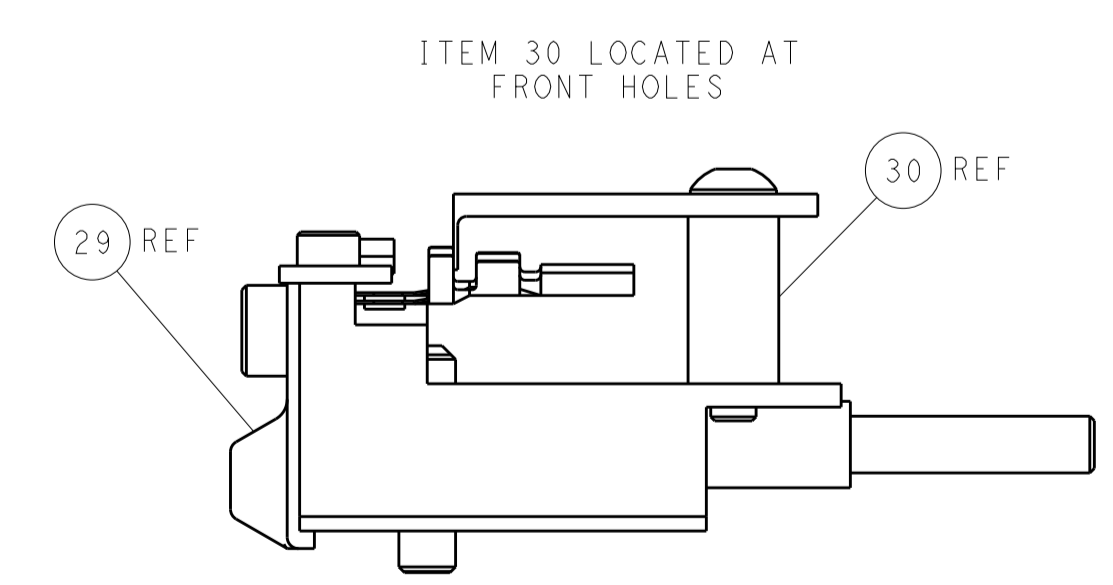
SHEAR DEPRESSOR DETAIL



TERMINAL SUPPORT LOCATION

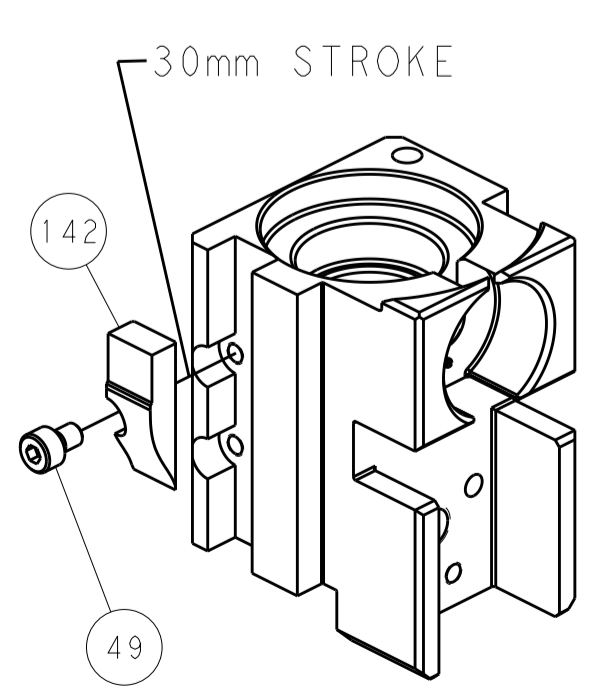


RAM SET-UP

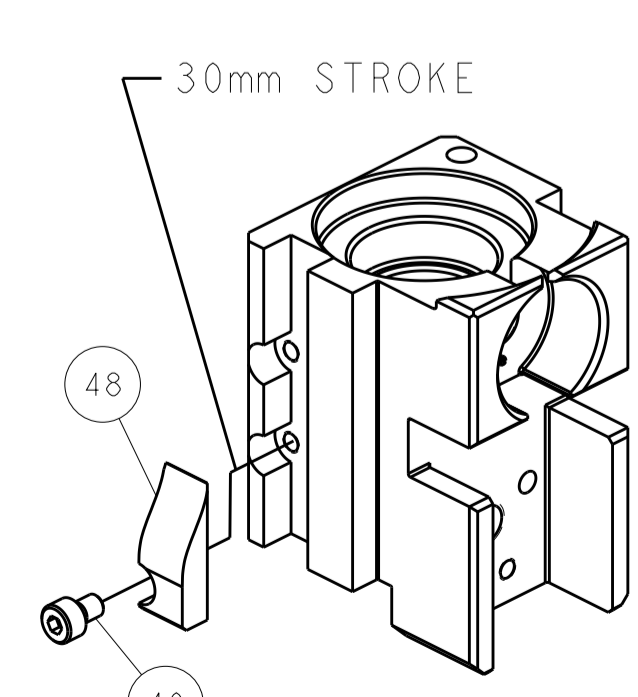


FEED TRACK POSITION GUIDE BY INSULATION BARREL

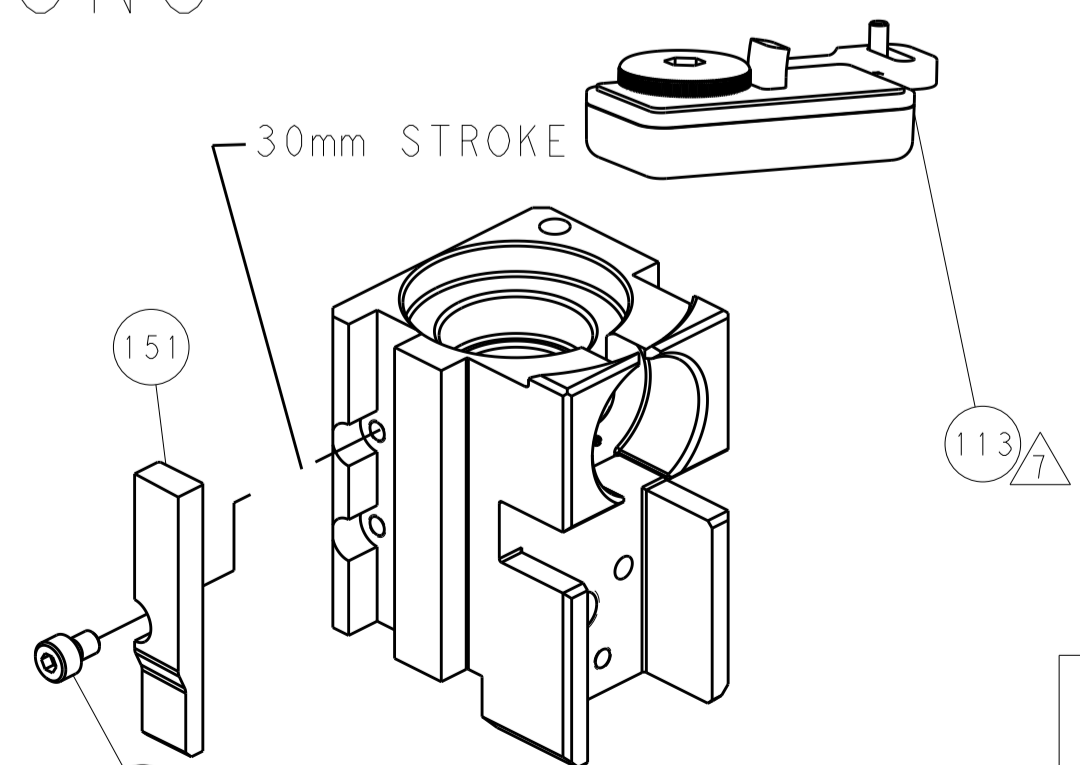
CAM POSITIONS



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)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG: M. ZHAO 24AUG2017		TE Connectivity	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	5 PLC ±	Harrisburg, PA 17105-3608
MATERIAL:	FINISH:	WEIGHT:	SCALE:	APVD: K. ZHANG 24AUG2017	NAME:	Customer Accessible Production Drawing	RESTRICTED TO:
			1:2	00779	Ocean Side Feed Applicator	SCALE: 1:2	
				00779	©=2836908	SHEET 4 OF 4	REV B