

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2837154-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2837154-2	B	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2837154-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	5.20 mm [.205]	F
INSUL	7.30 mm [.287]	F

APPLICATOR INSTRUCTIONS 408-35042

TERMINAL DATA: DELPHI TERMINAL DELPHI CRIMP SPECIFICATION			
TERMINAL NAME: TAXI TERMINAL, FEMALE M/P 630			
WIRE STRIP LENGTH		TERMINAL INSULATION DIAMETER RANGE	
4.80-5.56 mm [.189-.219 IN]		∅3.49-5.24 mm [.137-.206 IN]	
TERMINAL APPLICATION SPECIFICATION		12084596 Rev 10/30/13	
TERMINALS APPLIED			
TE TERMINAL	DELPHI TERMINAL	TE TERMINAL	DELPHI TERMINAL
2113034-1	12084596		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
2 X 3.0mm2	2.10 +/- 0.05 [.083 +/- .002]	6.3

- 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.
- TERMINAL LUBRICANT IS RECOMMENDED.
- 6. 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	REVISIONS					
A	66	P	LTN	DESCRIPTION	DATE	OWN	APVD
		1		PRELIMINARY	22MAR2018	MEH	TE
		A		RELEASE	17MAY2018	AW	TE
		B		ECR-22-141469	06JUN2022	JWC	TE

-	1	1	2119641-1	FEED CAM, AIR FEED	248	
-	1	1	2119082-8	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	1	2844940-1	AIR FEED MODULE	238	
-	REF	REF	994970-2	COUNTER, MAGNETIC	164	
-	1	1	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113	
-	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	455888-4	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	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	
-	1	1	1338683-8	FEED PAWL	56	
-	4	4	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	54	
-	2	2	2-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 14	53	
-	1	1	1803382-2	HOLD DOWN, SPRING LOADED	50	
-	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	
-	1	1	1752356-1	SUPPORT, TERMINAL	34	
-	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33	
-	2	2	3-2844962-2	SPACER, CYLINDRICAL, STRIP GUIDE	30	
-	1	1	2844992-5	ASSEMBLY, STRIP GUIDE	29	
-	1	1	455888-5	SPACER, CRIMPER	28	
-	1	1	240792-1	DRAG, TERMINAL	25	
-	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	2119806-1	INSERT, SHEAR	13	
-	1	1	3-22280-3	SPRING, COMPRESSION	12	
-	1	1	1-356885-4	STOP, SHEAR	11	
-	1	1	2119805-7	SHEAR HOLDER, FRONT	10	
-	1	1	318059-9	FLOATING SHEAR, FRONT	9	
-	1	2	1	9-1633930-7	ANVIL, COMBINATION	8
-	1	1	240641-1	SPACER	7	
-	-	-	-	-	6	
-	1	1	1-1803080-6	DEPRESSOR, SHEAR	5	
-	1	1	3-238011-1	BLOCK, CRIMPER SPACER	4	
-	1	2	1	3-1803260-4	CRIMPER, INSULATION F PREMIUM	3
-	1	1	1-455888-1	SPACER, CRIMPER	2	
-	1	2	1	2-1803556-0	CRIMPER, WIRE F	1

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

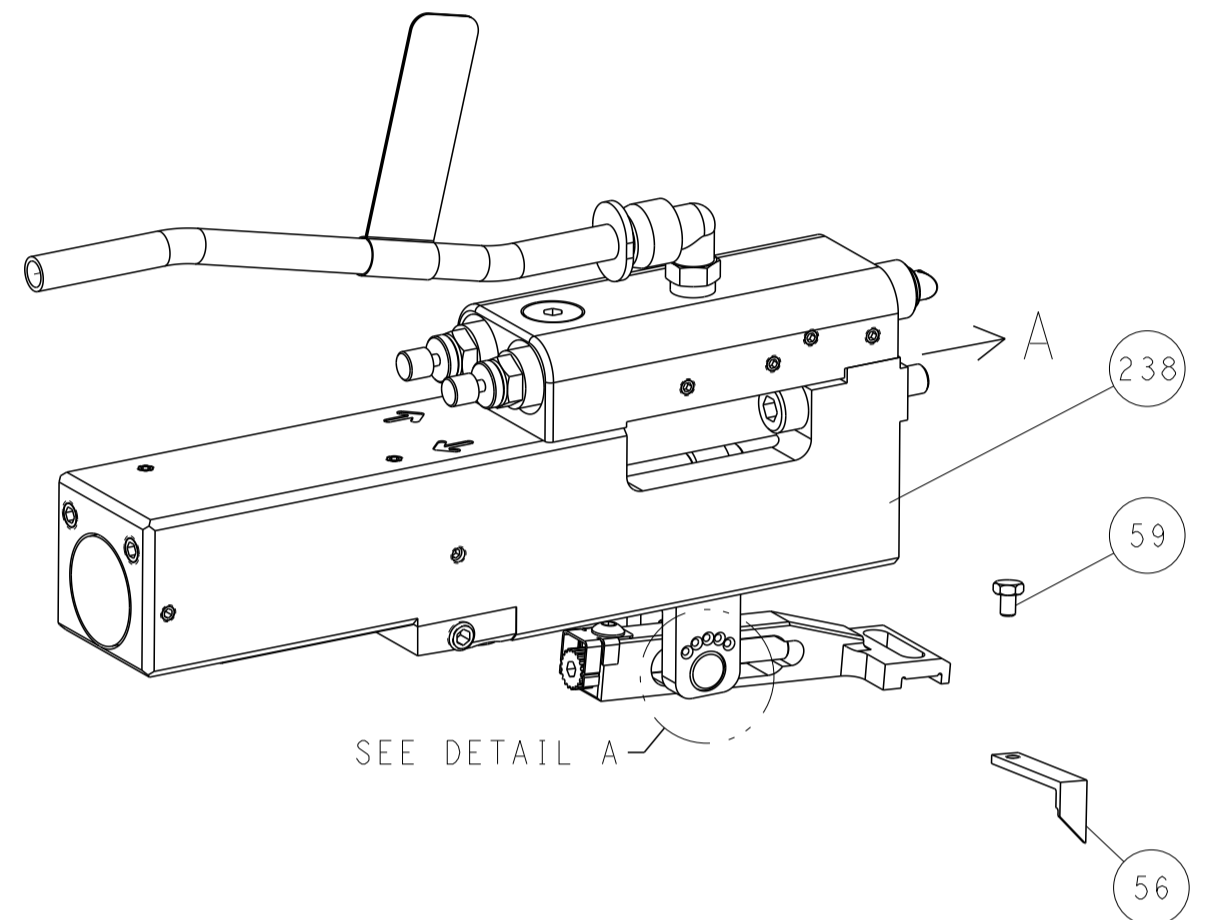
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mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES ±	FINISH ±

OWN	M. HERR	22MAR2018
CHK	T. ELBIN	22MAR2018
APVD	T. ELBIN	22MAR2018
PRODUCT SPEC		
APPLICATION SPEC		
SIZE	CAGE CODE	DRAWING NO
A1	00779	2837154
Customer Accessible Production Drawing		
SCALE	SHEET	REV
1:2	1 OF 4	B

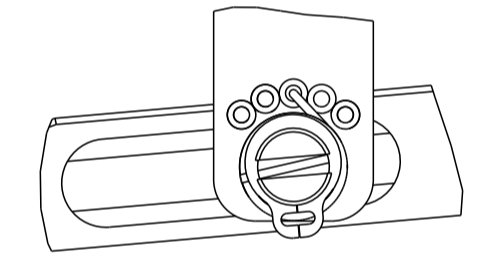
LOC	DIST	REVISIONS					
		P	LTN	DESCRIPTION	DATE	OWN	APVD
A	66	-	-	SEE SHEET 1	-	-	-

FEED TYPE

PNEUMATIC

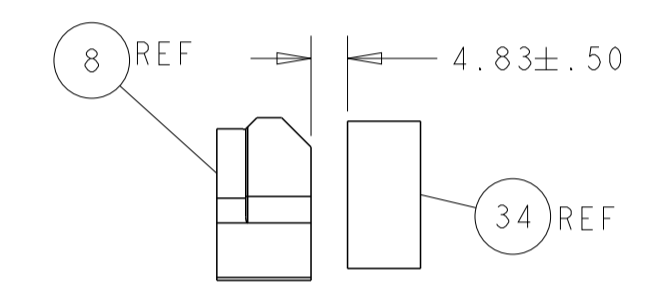
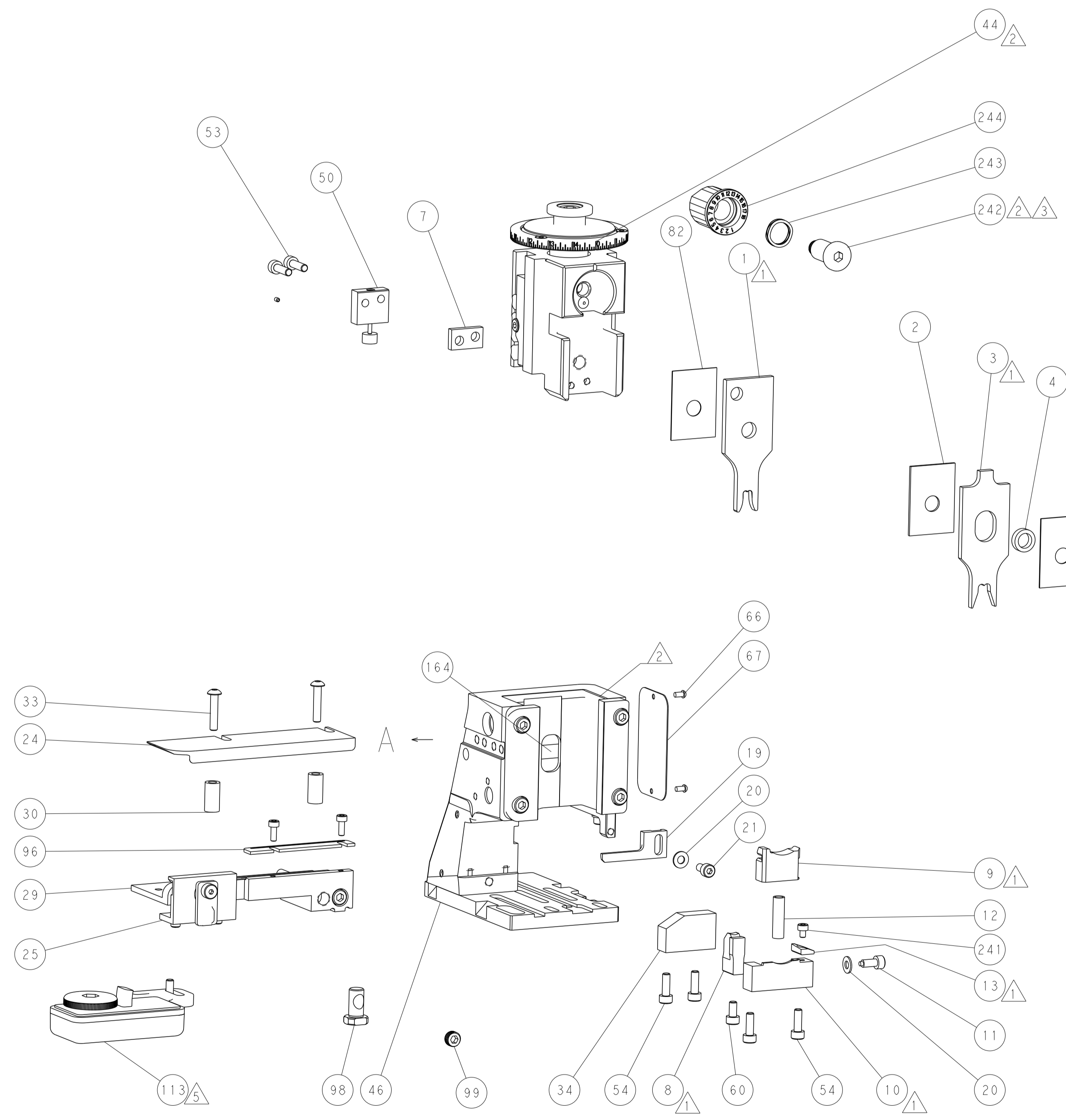
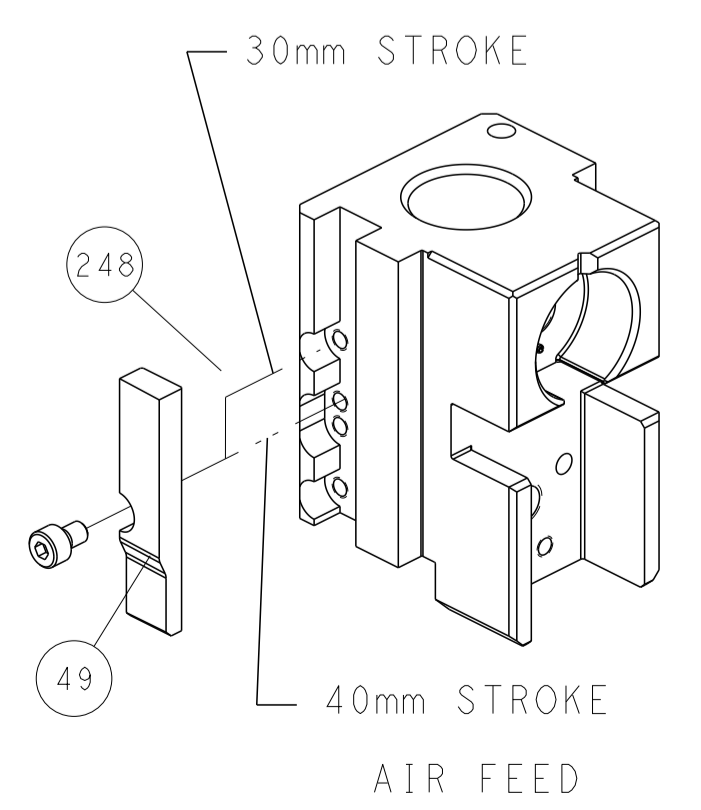


FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)

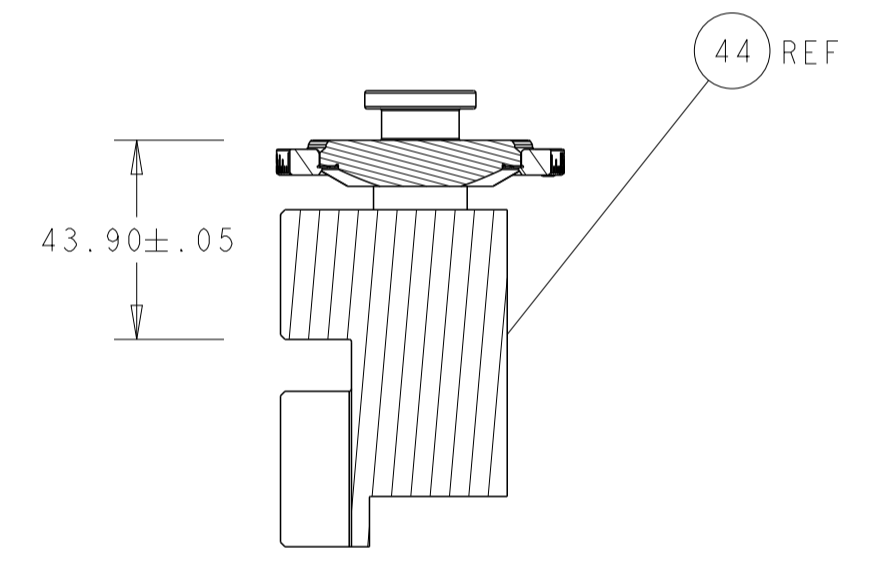


DETAIL A

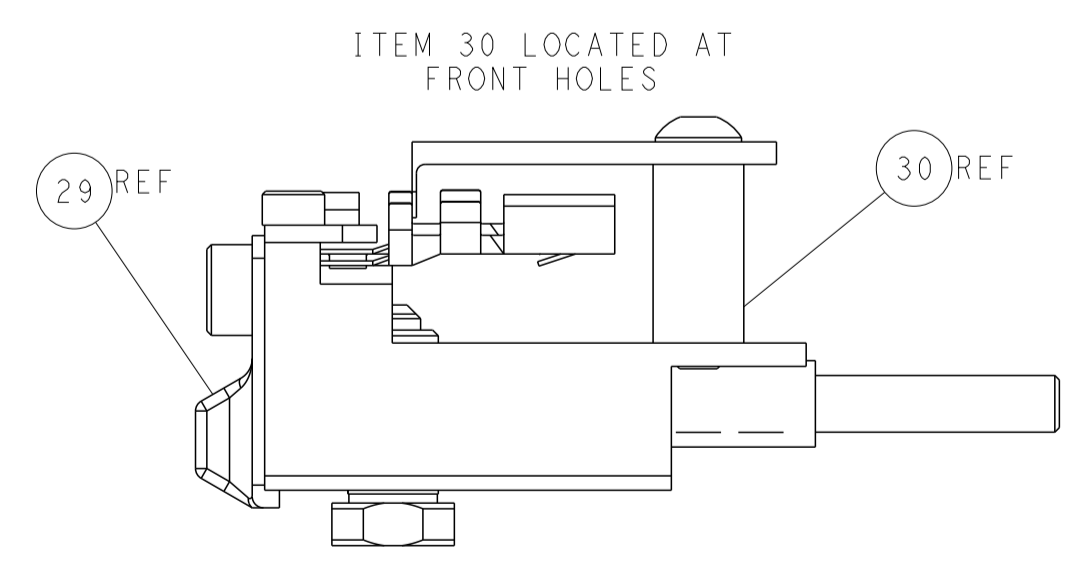
CAM POSITIONS



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)

<small>THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION 2018. COPYRIGHT 2018 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.</small>		DWN: M. HERR 22MAR2018 CHK: T. ELBIN 22MAR2018 APVD: T. ELBIN 22MAR2018	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: -		NAME: Ocean Side Feed Applicator PRODUCT SPEC: - APPLICATION SPEC: - WEIGHT: - SCALE: 1:2	SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2837154 SHEET: 2 OF 4 REV: B
AMP 4805 REV 31MAR2000		Customer Accessible Production Drawing	

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2837154-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2837154-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
 INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	5.20 mm [.205]	F
INSUL	7.30 mm [.287]	F

APPLICATOR INSTRUCTIONS
 408-35042

TERMINAL DATA: DELPHI TERMINAL DELPHI CRIMP SPECIFICATION	
TERMINAL NAME: TAXI TERMINAL, FEMALE M/P 630	
WIRE STRIP LENGTH 4.80-5.56 mm [.189-.219 IN]	TERMINAL INSULATION DIAMETER RANGE 3.49-5.24 mm [.137-.206 IN]
TERMINAL APPLICATION SPECIFICATION 12084596 Rev 10/30/13	
TERMINALS APPLIED	
TE TERMINAL 2113034-1	DELPHI TERMINAL 12084596

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
2 X 3.0mm2	2.10 +/- 0.05 [.083 +/- .002]	6.3



- 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.
 - TERMINAL LUBRICANT IS RECOMMENDED.
6. 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	REVISIONS					
		P	LTN	DESCRIPTION	DATE	OWN	APVD
A	66	-	-	SEE SHEET 1	-	-	-

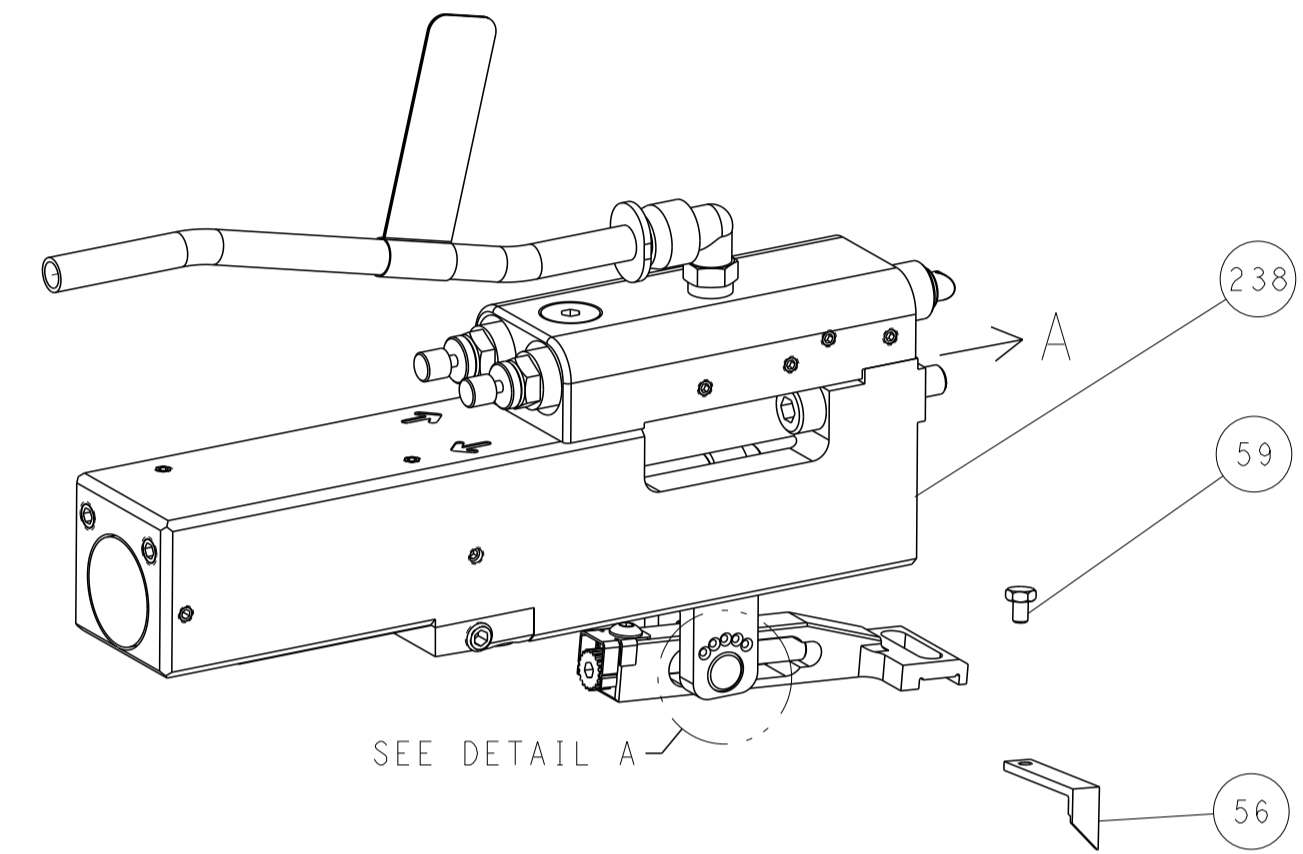
-	1	2119082-8	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
-	1	2844940-1	AIR FEED MODULE	238
-	REF	994970-2	COUNTER, MAGNETIC	164
-	1	2119641-2	FEED CAM, AIR FEED	151
-	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	1-1803583-0	APPLICATOR BASIC ASSEMBLY, SF	141
-	1	1803516-1	RAM ASSEMBLY, SF PACIFIC	140
-	1	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113
-	1	2844908-1	SCREW, LOCKING	99
-	1	2844907-1	POST, LOCKING	98
-	1	1-690438-0	FRONT STRIP GUIDE	96
-	1	455888-4	SPACER, CRIMPER	82
-	1	1803607-3	DOCUMENTATION PACKAGE	71
-	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
-	1	1338683-8	FEED PAWL	56
-	2	2-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 14	53
-	1	1803382-2	HOLD DOWN, SPRING LOADED	50
-	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
-	1	1752356-1	SUPPORT, TERMINAL	34
-	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	3-2844962-2	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	2844992-5	ASSEMBLY, STRIP GUIDE	29
-	1	455888-5	SPACER, CRIMPER	28
-	1	240792-1	DRAG, TERMINAL	25
-	1	1320928-2	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	2119806-1	INSERT, SHEAR	13
-	1	3-22280-3	SPRING, COMPRESSION	12
-	1	1-356885-4	STOP, SHEAR	11
-	1	2119805-7	SHEAR HOLDER, FRONT	10
-	1	318059-9	FLOATING SHEAR, FRONT	9
-	1	9-1633930-7	ANVIL, COMBINATION	8
-	1	240641-1	SPACER	7
-	-	-	-	6
-	1	1-1803080-6	DEPRESSOR, SHEAR	5
-	1	3-238011-1	BLOCK, CRIMPER SPACER	4
-	1	1-3-1803260-4	CRIMPER, INSULATION F PREMIUM	3
-	1	1-455888-1	SPACER, CRIMPER	2
-	1	2-1803556-0	CRIMPER, WIRE F	1
-	77	-22	PART NO	ITEM NO

DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG: M. HERR 22MAR2018		CHK: T. ELBIN 22MAR2018		NAME: Ocean Side Feed Applicator	
0 PLC	±	0 PLC	±	APVD: T. ELBIN 22MAR2018	PRODUCT SPEC	SIZE: A1	CAGE CODE: 00779	DRAWING NO: C=2837154	RESTRICTED TO: -
1 PLC	±	1 PLC	±	APPLICATION SPEC		SCALE: 1:2		SHEET 3 OF 4	
2 PLC	±	2 PLC	±	MATERIAL		REV B		Customer Accessible Production Drawing	
3 PLC	±	3 PLC	±	FINISH		SCALE: 1:2		SHEET 3 OF 4	
4 PLC	±	4 PLC	±	WEIGHT		SCALE: 1:2		SHEET 3 OF 4	
ANGLES	±	ANGLES	±	WEIGHT		SCALE: 1:2		SHEET 3 OF 4	

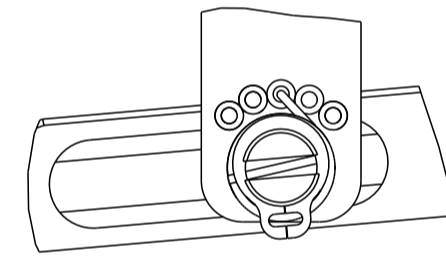
LOC	DIST	REV	DATE	BY	APPD
A	66				
REVISIONS			DESCRIPTION	DATE	BY
			SEE SHEET 1		

FEED TYPE

PNEUMATIC

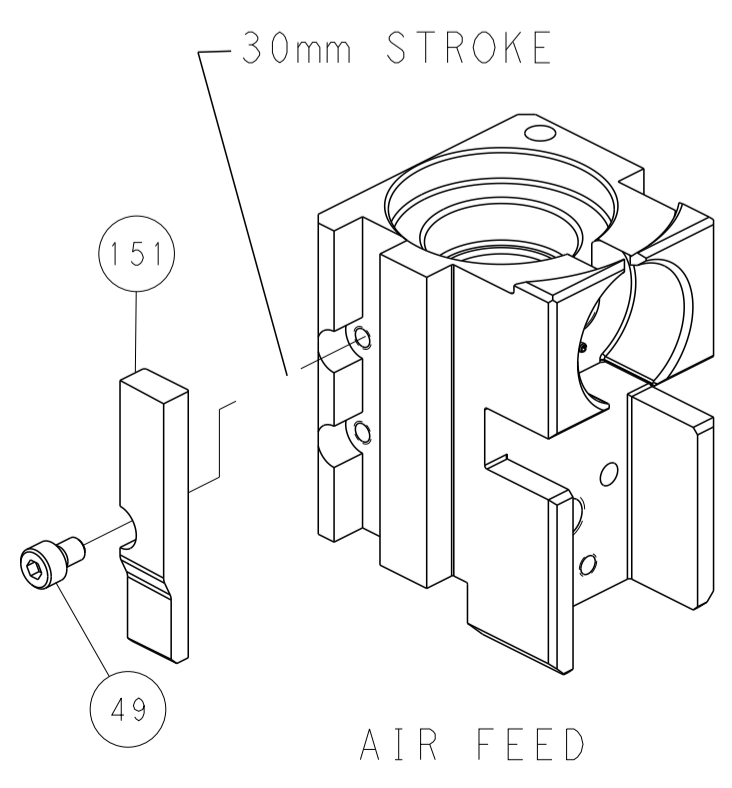


FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)

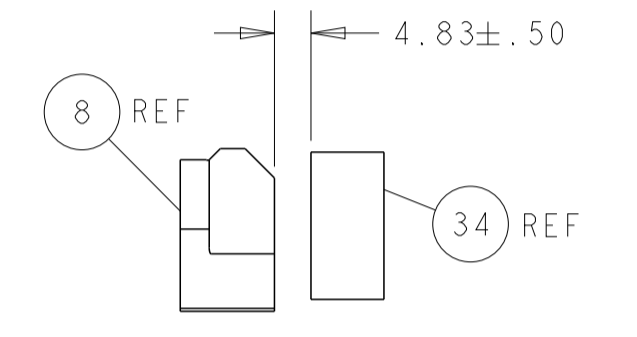
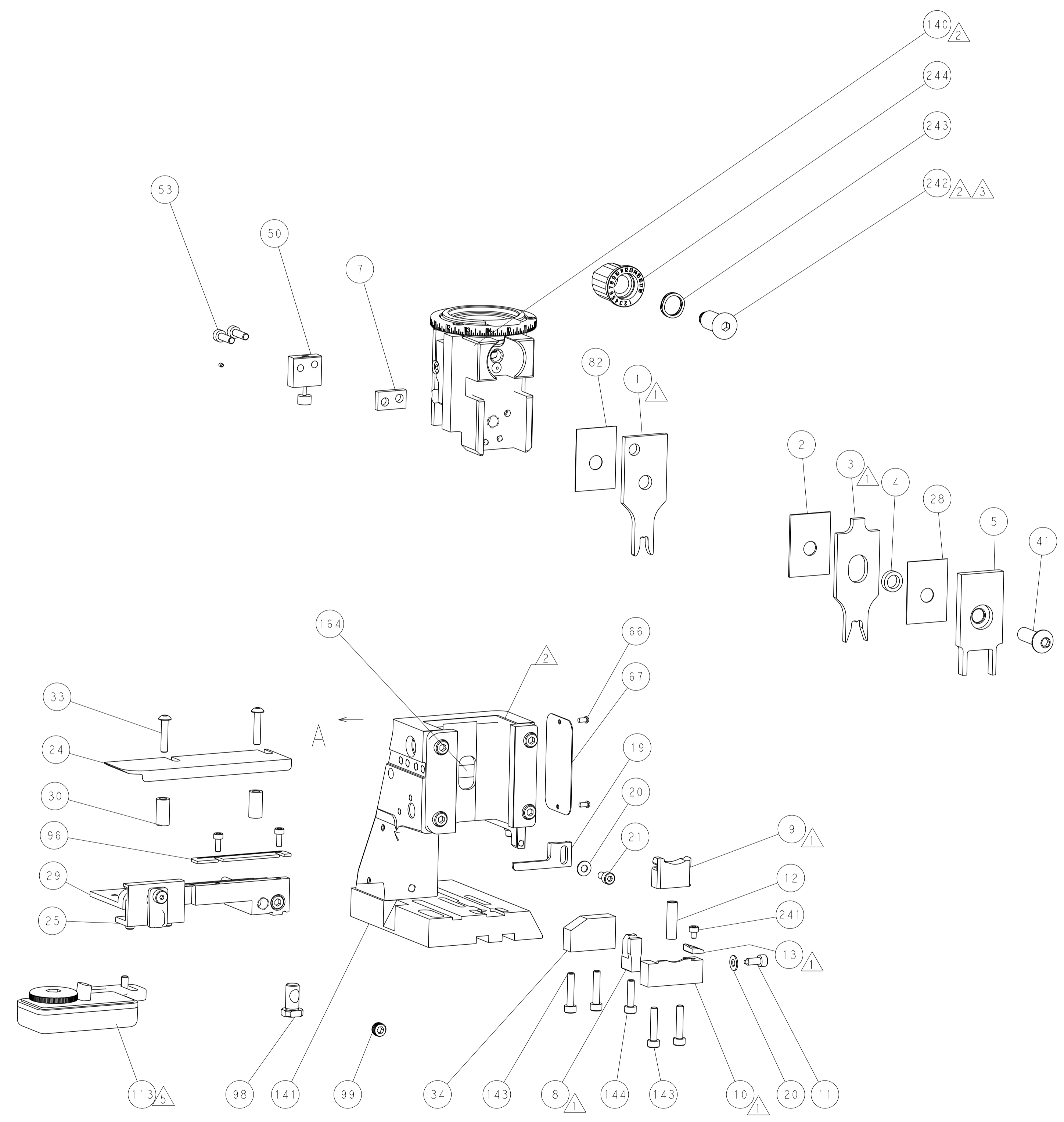


DETAIL A

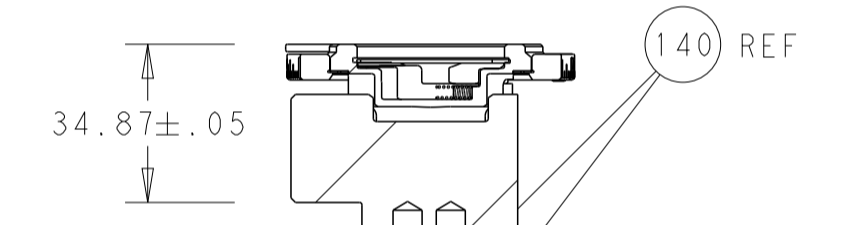
CAM POSITIONS



AIR FEED

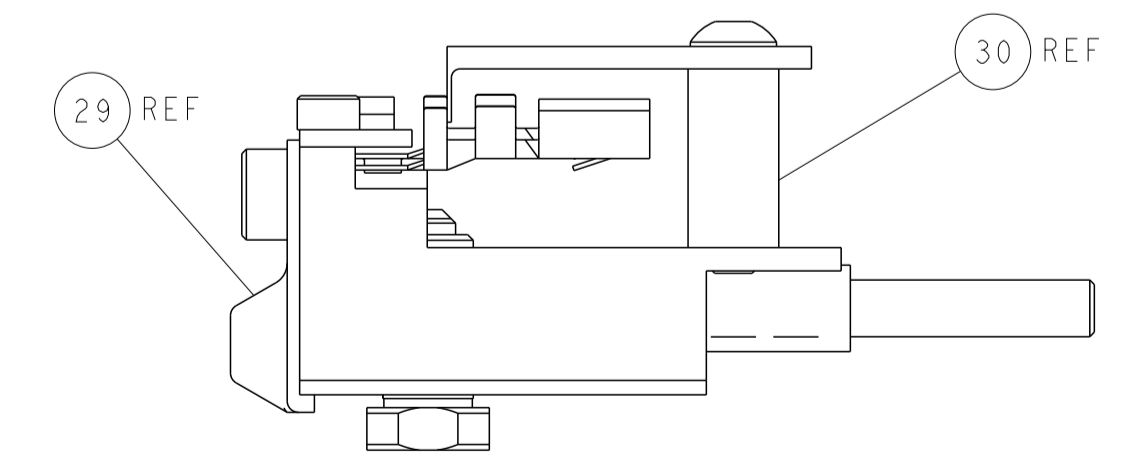


TERMINAL SUPPORT LOCATION



RAM SET-UP

ITEM 30 LOCATED AT FRONT HOLES



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)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		OWN	M. HERR	22MAR2018	TE Connectivity Harrisburg, PA 17105-3608
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES ±	
MATERIAL	FINISH	WEIGHT	SCALE	APVD	T. ELBIN	22MAR2018	NAME
			1:2	PRODUCT SPEC			Ocean Side Feed Applicator
				APPLICATION SPEC			SIZE
							CAGE CODE
							DRAWING NO
							RESTRICTED TO
							A1 00779 ©=2837154
							Customer Accessible Production Drawing
							SHEET 4 OF 4 REV B