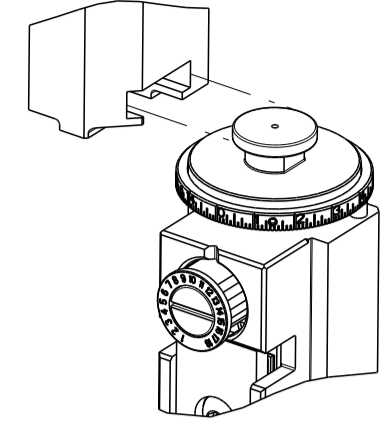


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2837866-1	A	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2837866-2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2837866-1	A	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2837866-2	A	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2837866-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.01 mm [.079]	F
INSUL	2.48 mm [.098]	O

APPLICATOR INSTRUCTIONS  
408-35042

TERMINAL DATA: DELPHI TERMINAL DELPHI CRIMP SPECIFICATION			
TERMINAL NAME: TAXI TERM M/P 480 SPL			
WIRE STRIP LENGTH		TERMINAL INSULATION DIAMETER RANGE	
5.34-6.10 mm [.210-.240 IN]		Ø1.85-2.40 mm [.073-.094 IN]	
TERMINAL APPLICATION SPECIFICATION	12065891 PG 1 Rev 2013-10-29		
TERMINALS APPLIED		AT9106	
TE TERMINAL	DELPHI TERMINAL	TE TERMINAL	DELPHI TERMINAL
286735-1	12065894		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.00mm2	1.30 +/- 0.05 [0.051 +/- .002]	5.3
0.80mm2	1.15 +/- 0.05 [0.045 +/- .002]	7.1

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

**\*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)

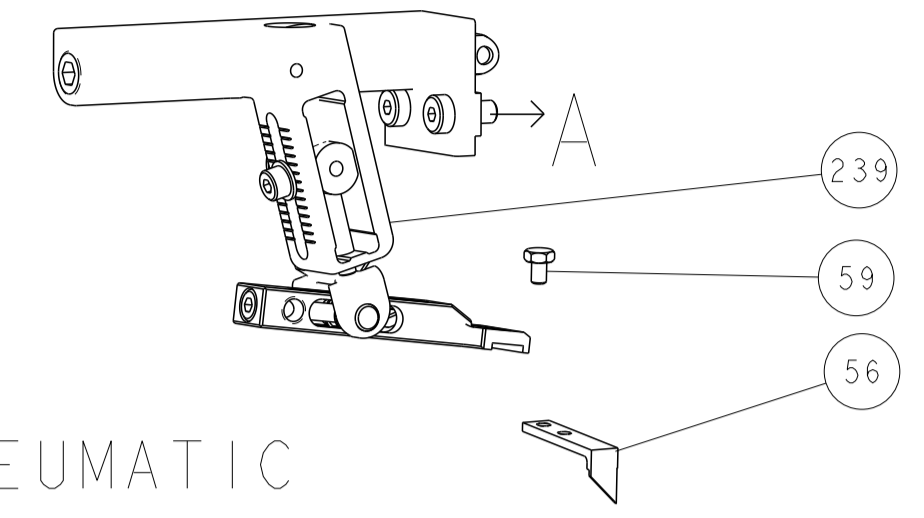
LOC	DIST	REVISIONS					
		P	LTN	DESCRIPTION	DATE	DWN	APVD
A	66			RELEASED	21SEP2020	TB	RK

-	1	1	1	1	2119791-5	DEPRESSOR, WIRE	286	
-	1	1	1	1	1-1803078-6	SPACER, PRECISION	259	
-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248	
-	1	1	1	1	2119082-4	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	-	2844940-1	AIR FEED MODULE	238	
-	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164	
	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	1-455888-1	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	
-	1	1	1	1	1338685-1	PAWL, FEED	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	1803382-6	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	1803515-2	RAM ASSEMBLY, SF ATLANTIC	44	
-	1	1	1	1	1803602-2	SCR, BHSC, RoHS (M8 X 40)	41	
-	1	1	1	1	1752356-1	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	1-2844992-1	ASSEMBLY, STRIP GUIDE	29	
-	1	1	1	1	455888-5	SPACER, CRIMPER	28	
-	1	1	1	1	1320928-6	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	1803095-6	FLOATING SHEAR, FRONT	9	
	1	2	2	1	1	8-1803751-5	ANVIL, COMBINATION	8
-	-	-	-	-	-	-	7	
-	-	-	-	-	-	-	6	
-	1	1	1	1	2119757-8	DEPRESSOR, SHEAR	5	
-	1	1	1	1	3-238011-1	BLOCK, CRIMPER SPACER	4	
	1	2	2	1	1	3-1803018-0	CRIMPER, INSULATION O	3
-	1	1	1	1	1-455888-4	SPACER, CRIMPER	2	
	1	2	2	1	1	3-1633305-1	CRIMPER, WIRE PREMIUM	1
-	77	-72	-71	-2	-1	PART NO	DESCRIPTION	ITEM NO

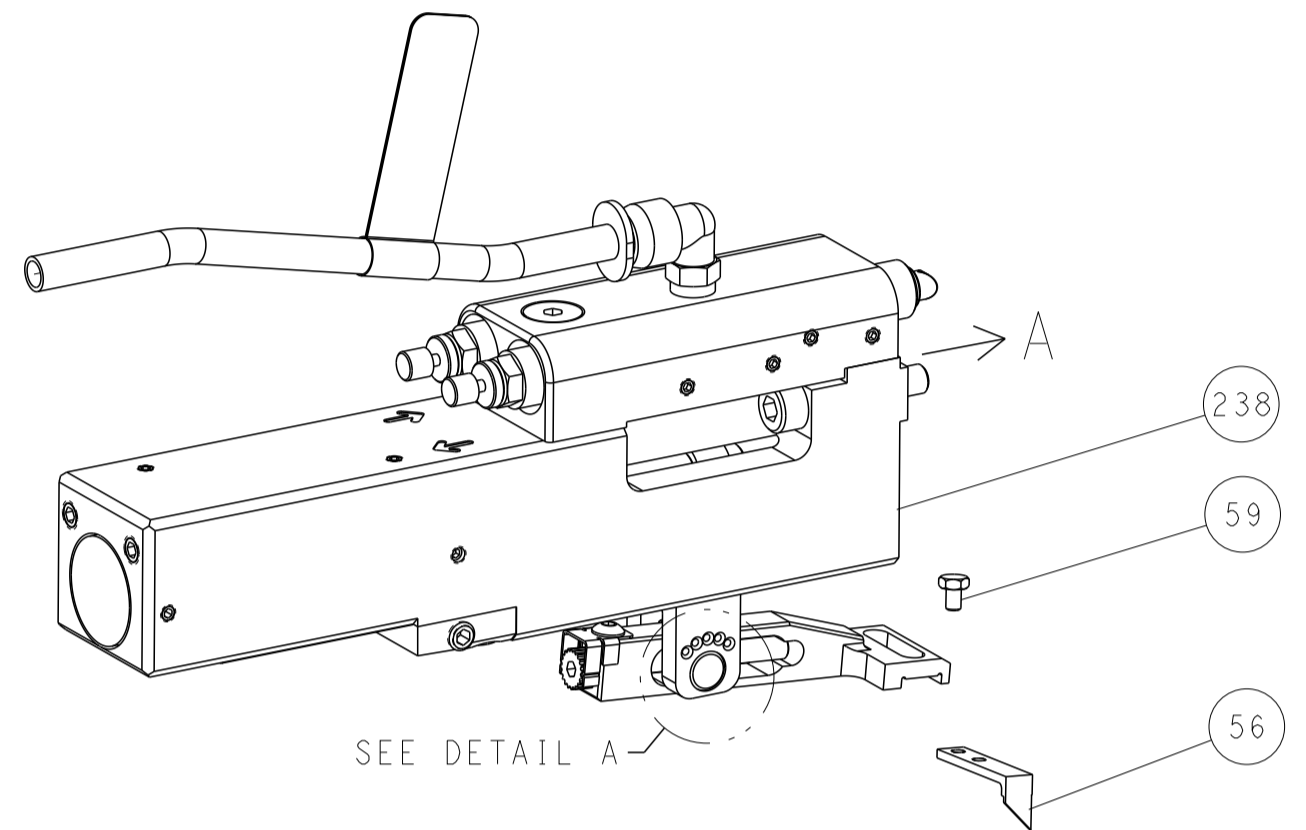
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mm	0 PLC ±	1 PLC ±	2 PLC ±	CHK	M. HERR	10AUG2020	
	3 PLC ±	4 PLC ±	ANGLES ±	APVD	T. ELBIN	10AUG2020	NAME
	FINISH						OCEAN 2.0 Side Feed Applicator
MATERIAL				APPLICATION SPEC			SIZE
				WEIGHT			CAGE CODE
							DRAWING NO
							00779
							©=2837866
							Customer Accessible Production Drawing
							SCALE
							1:2
							SHEET
							1 of 4
							REV
							A

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

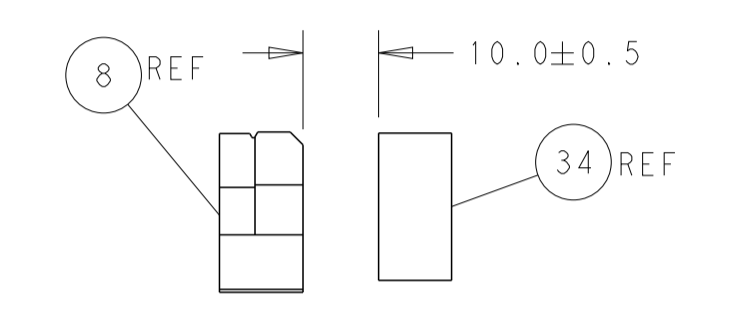
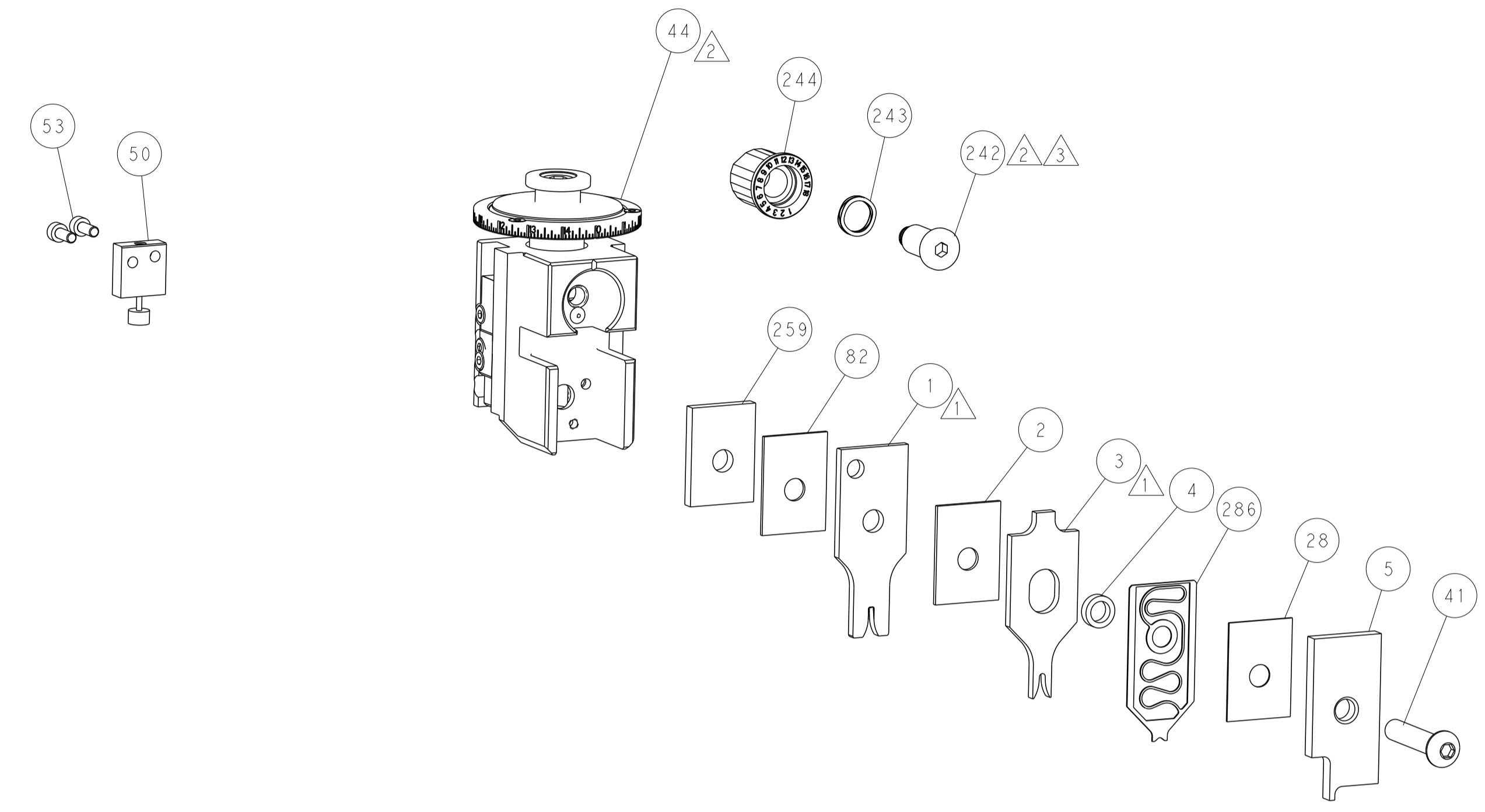
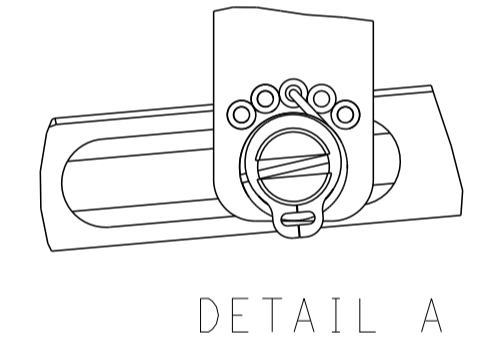
# FEED TYPE MECHANICAL



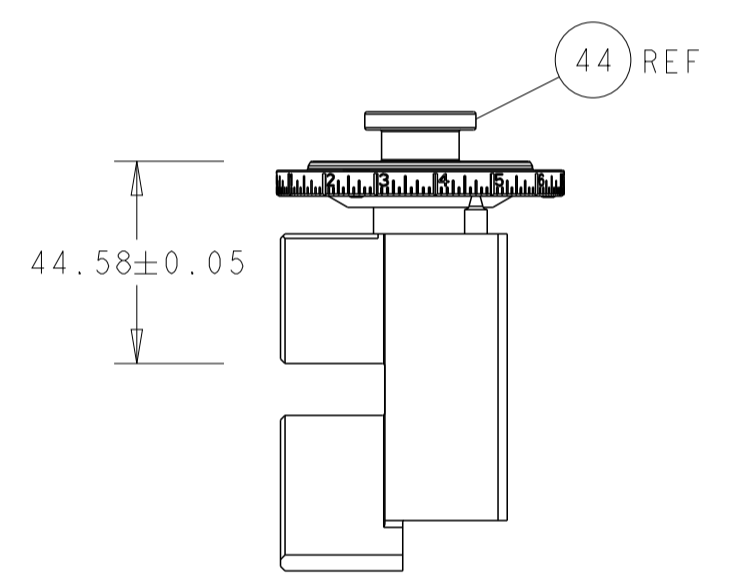
## PNEUMATIC



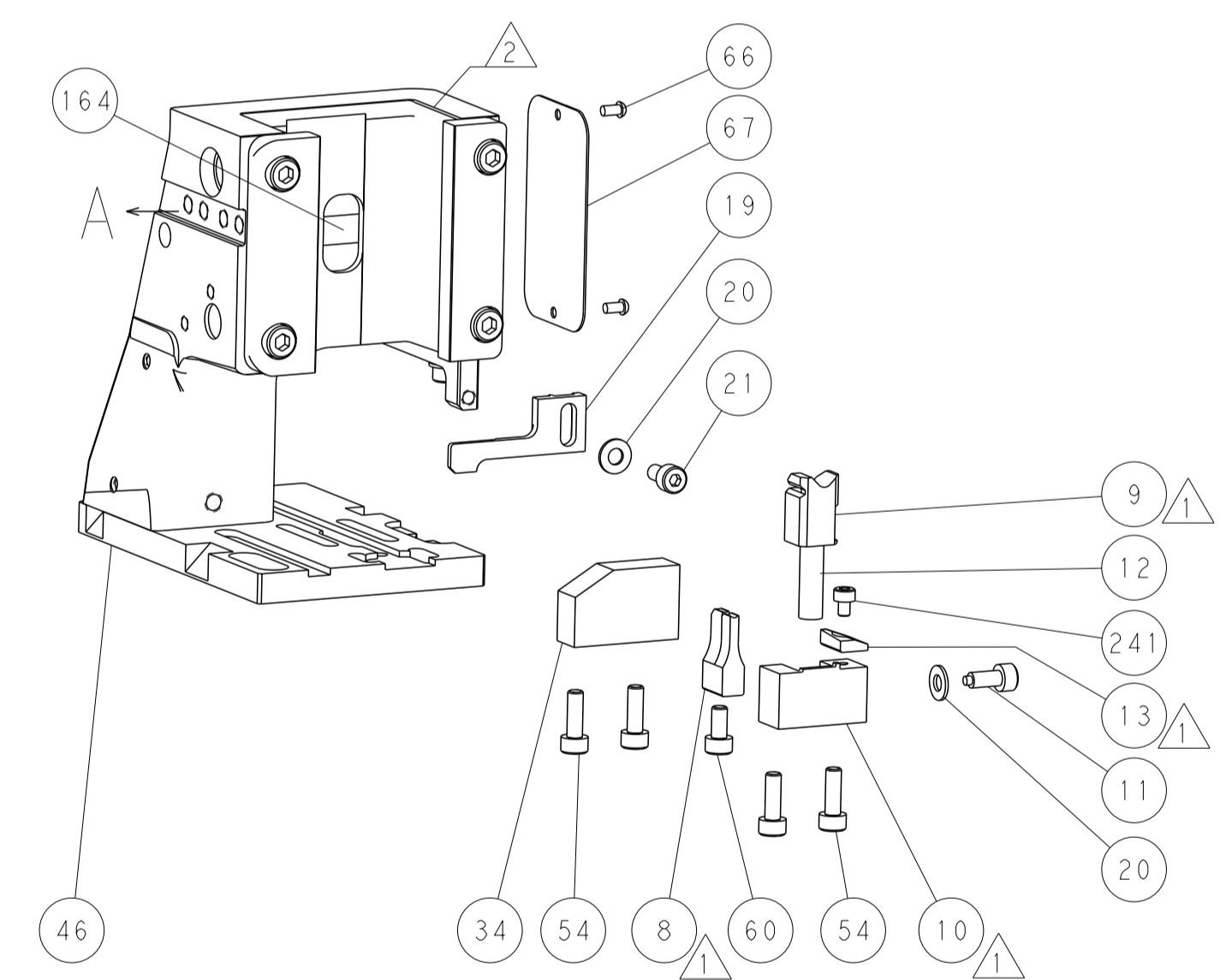
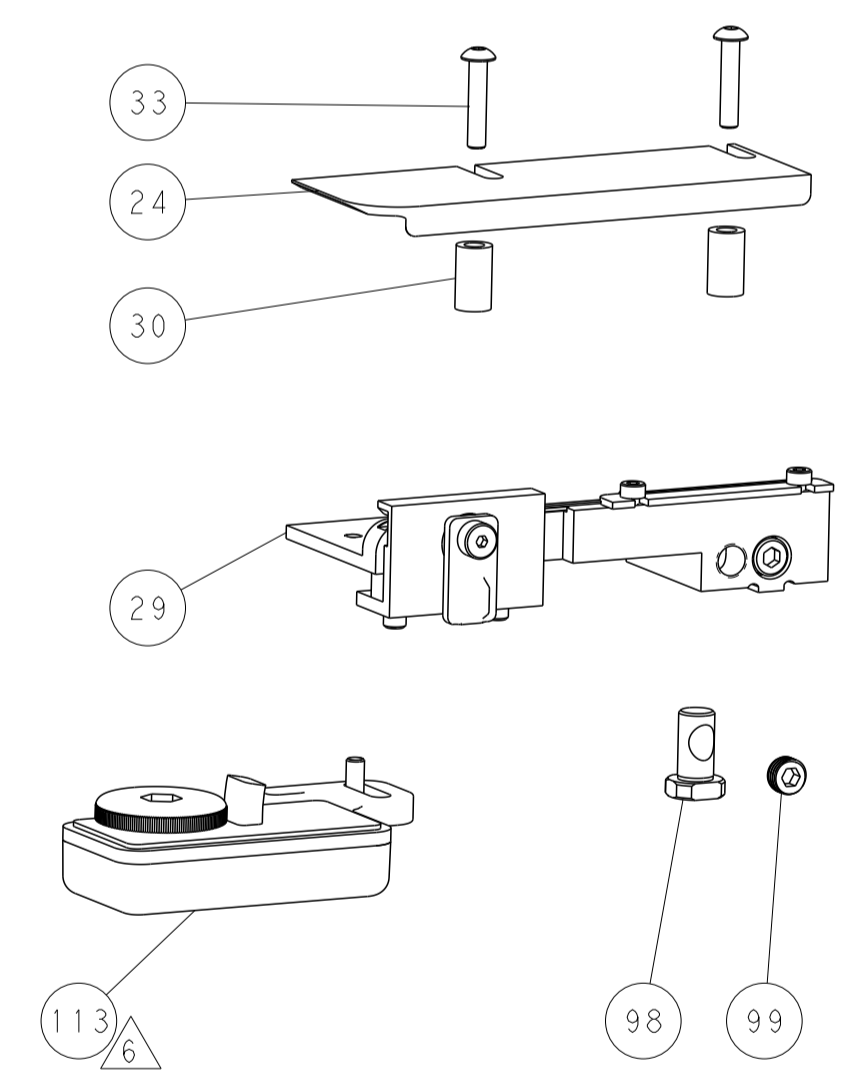
## FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



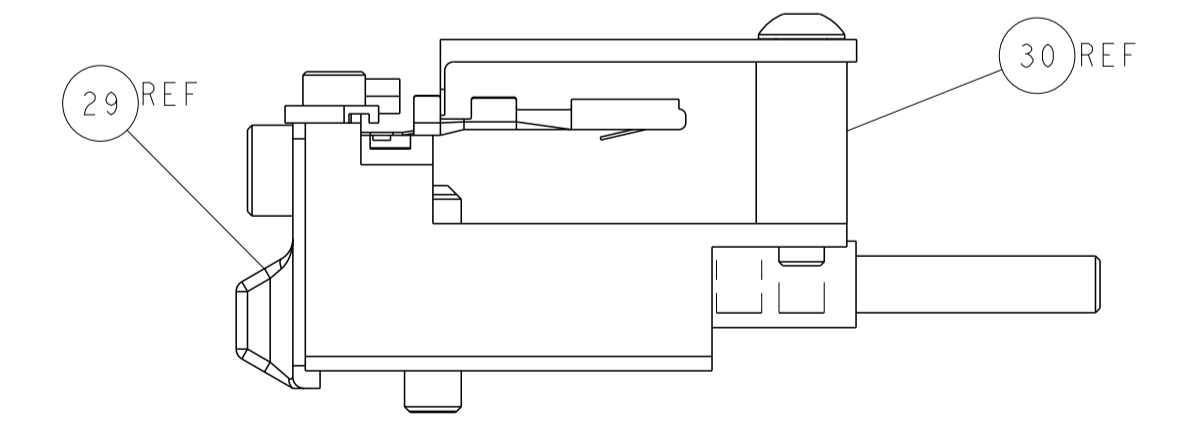
TERMINAL SUPPORT LOCATION



RAM SET-UP

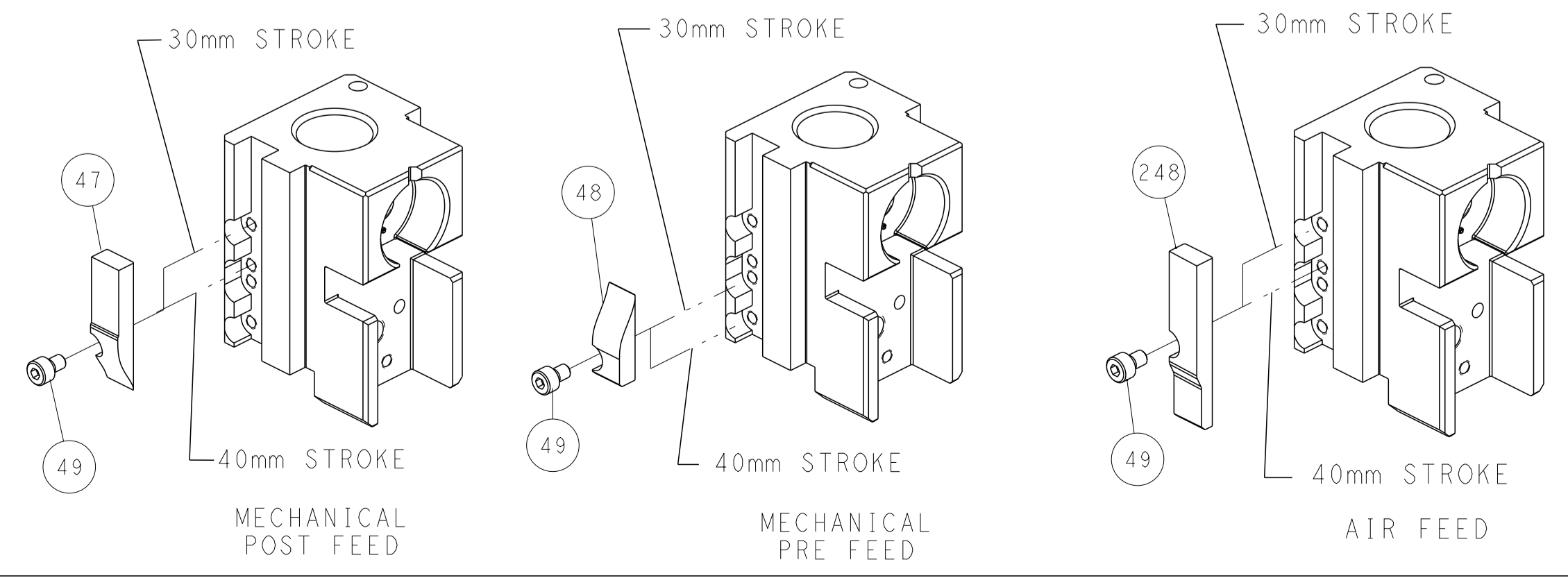


ITEM 30 LOCATED AT REAR HOLES



FEED TRACK POSITION GUIDE BY INSULATION BARREL

# CAM POSITIONS

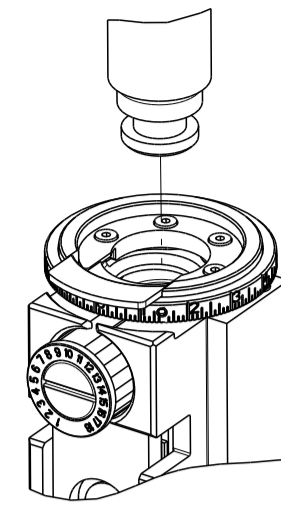


**ATLANTIC VERSION**  
 Shown on sheets 1 of 4 & 2 of 4  
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

<small>THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.</small>		DWN T. BROOKS 10AUG2020 CHK M. HERR 10AUG2020 APVD T. ELBIN 10AUG2020	<b>STE</b> TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH		NAME OCEAN 2.0 Side Feed Applicator SIZE CAGE CODE DRAWING NO. RESTRICTED TO A1 00779 C=2837866	WEIGHT SCALE 1:2 SHEET 2 OF 4 REV A
MATERIAL		Customer Accessible Production Drawing	SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

THIS DRAWING IS UNPUBLISHED.	RELEASED FOR PUBLICATION		
COPYRIGHT 20 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.			
PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2837866-1	A	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2837866-2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2837866-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR  
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.01 mm [.079]	F
INSUL	2.48 mm [.098]	O
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: DELPHI TERMINAL DELPHI CRIMP SPECIFICATION	
TERMINAL NAME: TAXI TERM M/P 480 SPL	
WIRE STRIP LENGTH 5.34-6.10 mm [.210-.240 IN]	TERMINAL INSULATION DIAMETER RANGE Ø1.85-2.40 mm [.073-.094 IN]
TERMINAL APPLICATION SPECIFICATION 12065891 PG 1 Rev 2013-10-29	AT9106
TERMINALS APPLIED	
TE TERMINAL 286735-1	DELPHI TERMINAL 12065894

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.00mm2	1.30+/-0.05 [.051+/-0.002]	5.3
0.80mm2	1.15+/-0.05 [.045+/-0.002]	7.1

- 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. TERMINAL LUBRICANT IS RECOMMENDED.

**\*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)

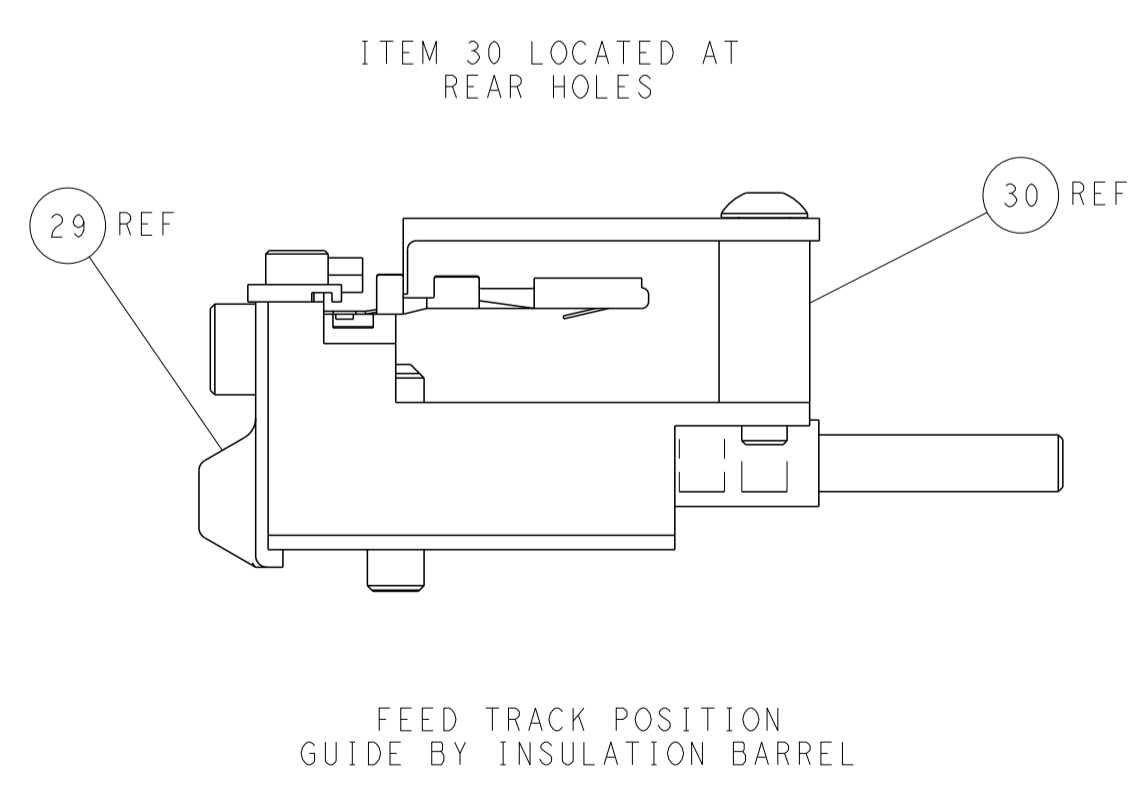
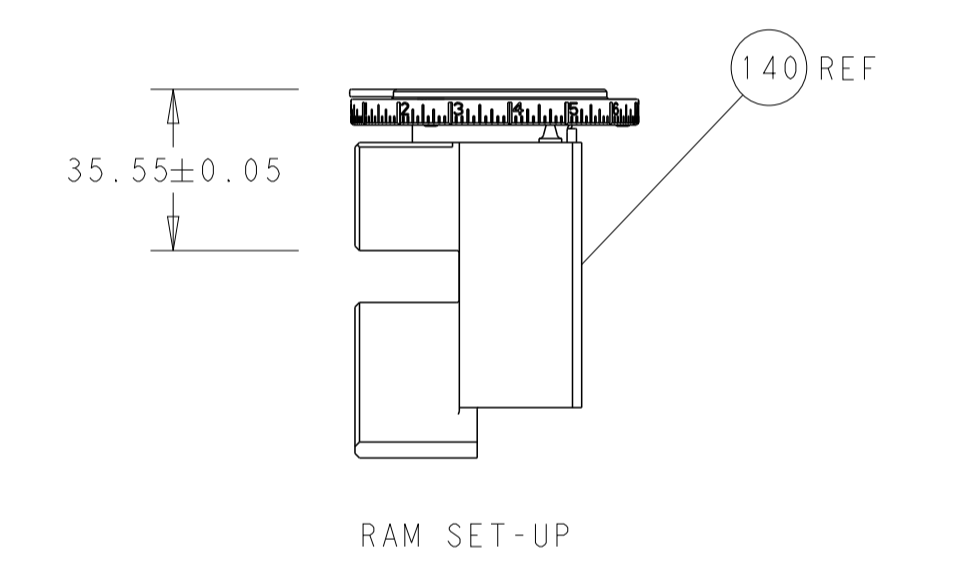
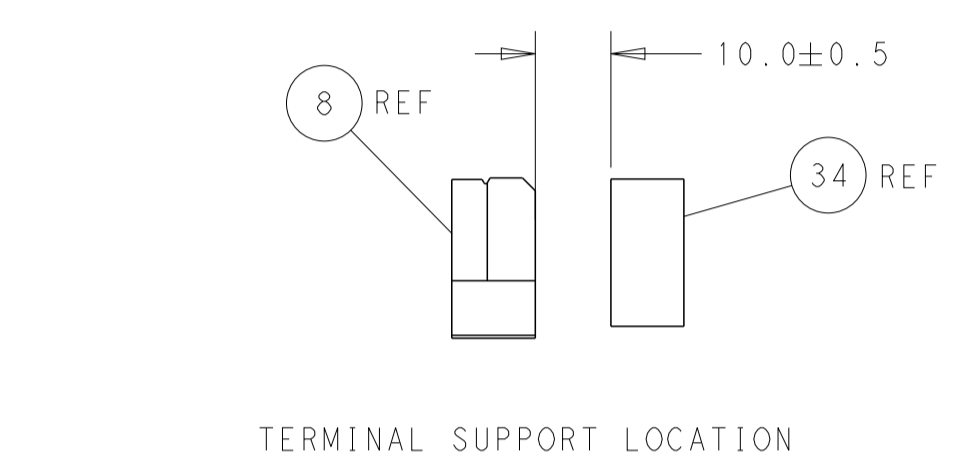
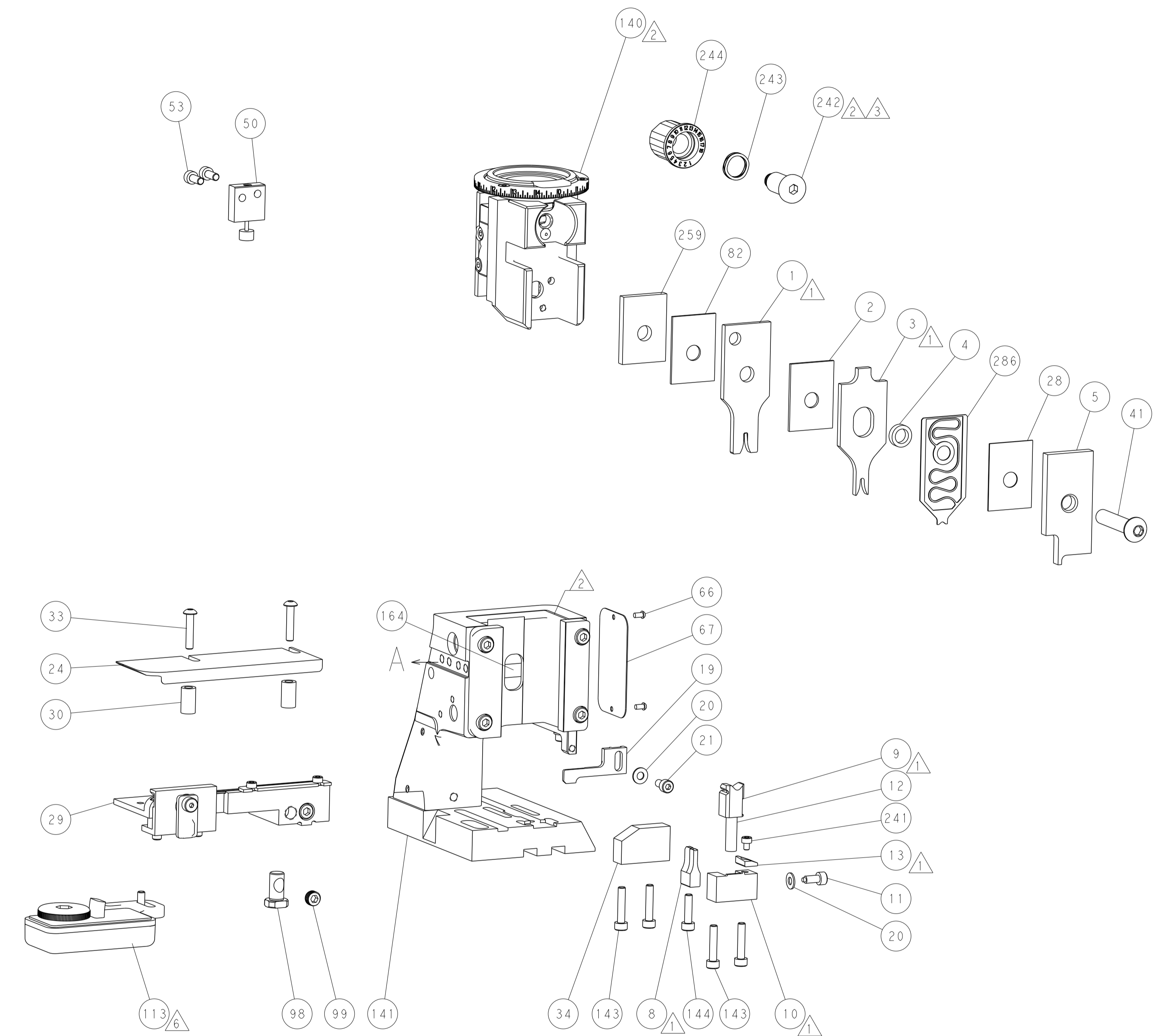
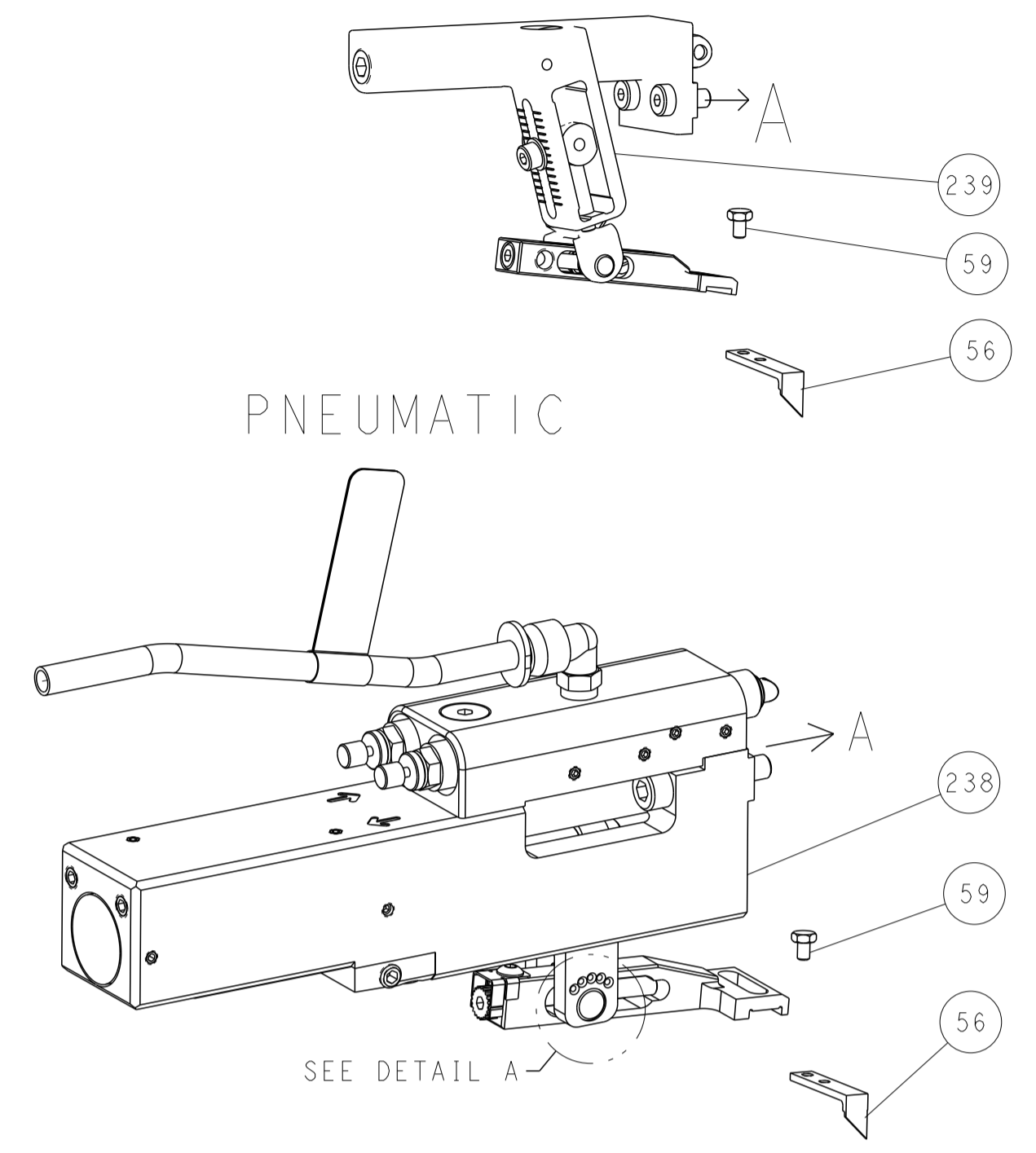
LOC	DIST	REV	DATE	BY	CHKD	APVD
A	66					

REV	DATE	BY	CHKD	APVD	DESCRIPTION	ITEM NO
-	1	1			2119791-5 DEPRESSOR, WIRE	286
-	1	1			1-1803078-6 SPACER, PRECISION	259
-	1	1			2119082-4 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
-	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			1803516-2 RAM ASSEMBLY, SF PACIFIC	140
6	-	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			1-455888-1 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
-	1	1			1338685-1 PAWL, FEED	56
-	2	2			1-2168083-0 SCR, SKT HD CAP, RoHS, M4 X 10	53
-	1	1			1803382-6 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			1803602-2 SCR, BHSC, RoHS (M8 X 40)	41
-	1	1			1752356-1 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			1-2844992-1 ASSEMBLY, STRIP GUIDE	29
-	1	1			455888-5 SPACER, CRIMPER	28
-	1	1			1320928-6 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		2119806-1 INSERT, SHEAR	13
-	1	1			3-22280-3 SPRING, COMPRESSION	12
-	1	1			1-356885-4 STOP, SHEAR	11
1	-	1	1		2119805-1 SHEAR HOLDER, FRONT	10
1	-	1	1		1803095-6 FLOATING SHEAR, FRONT	9
1	1	1	1		8-1803751-5 ANVIL, COMBINATION	8
-	-	-	-		-	7
-	-	-	-		-	6
-	1	1			2119757-8 DEPRESSOR, SHEAR	5
-	1	1			3-238011-1 BLOCK, CRIMPER SPACER	4
1	1	1	1		3-1803018-0 CRIMPER, INSULATION O	3
-	1	1	1		1-455888-4 SPACER, CRIMPER	2
1	1	1	1		3-1633305-1 CRIMPER, WIRE PREMIUM	1

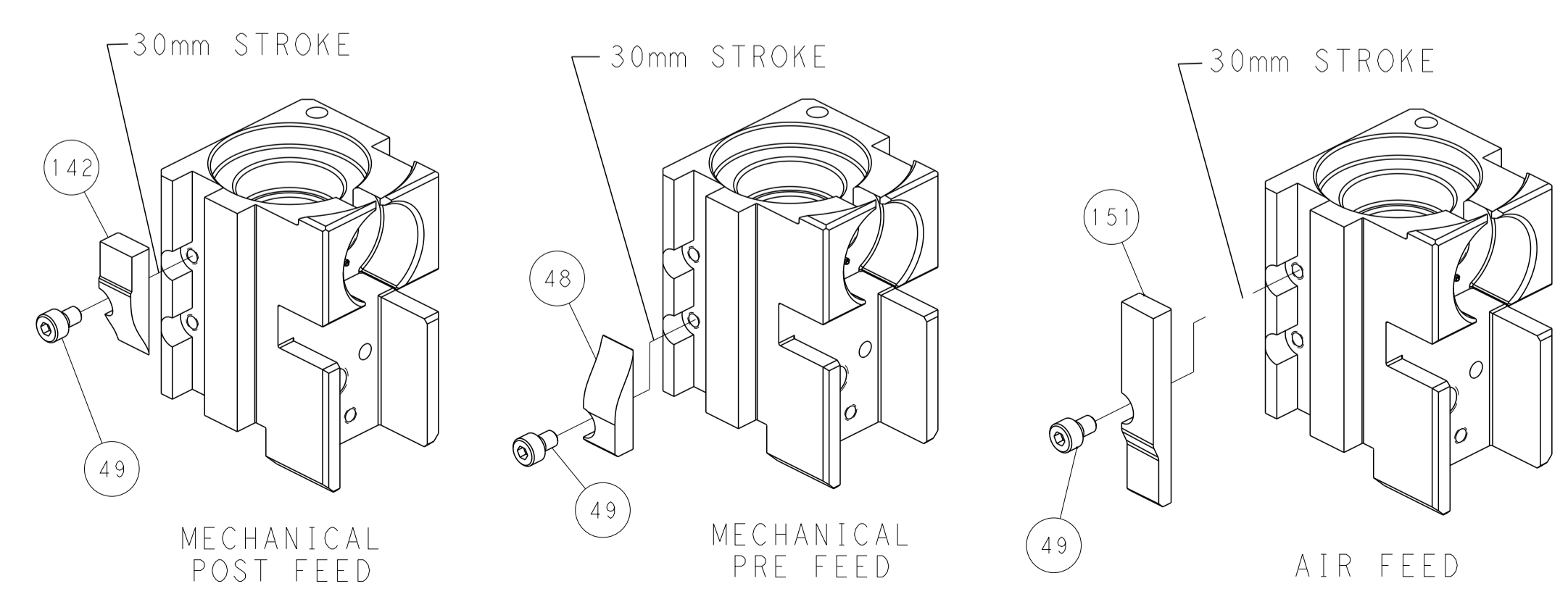
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG T. BROOKENS 10AUG2020		CHK M. HERR 10AUG2020		APVD T. ELBIN 10AUG2020		NAME	
0 PLC	±	1 PLC	±	TE Connectivity		Harrisburg, PA 17105-3608		OCEAN 2.0 Side Feed		Applicator	
2 PLC	±	3 PLC	±	Customer Accessible Production Drawing		SCALE 1:2		SHEET 3 OF 4		REV A	
4 PLC	±	FINISH		WEIGHT		A 00779 ©=2837866		Customer Accessible Production Drawing		SCALE 1:2 SHEET 3 OF 4 REV A	

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

# FEED TYPE MECHANICAL



# 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:		DWN T. BROOKS 10AUG2020		TE Connectivity	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	Harrisburg, PA 17105-3608	
ANGLES	FINISH	MATERIAL		APVD M. HERR 10AUG2020		NAME	
				PRODUCT SPEC		OCEAN 2.0 Side Feed Applicator	
				APPLICATION SPEC		SIZE CAGE CODE DRAWING NO	
				WEIGHT		RESTRICTED TO	
				A 00779 C=2837866		SCALE 1:2 SHEET 4 OF 4 REV A	
				Customer Accessible Production Drawing			