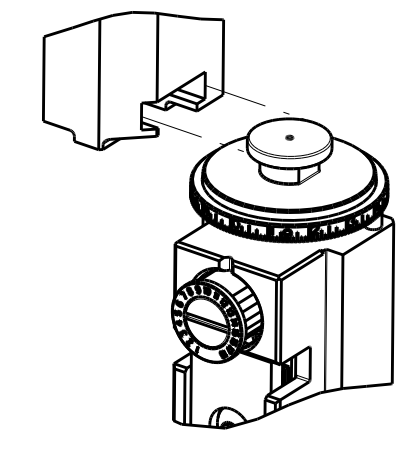


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2836871-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2836871-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
3-2836871-2	B	FINE CRIMP HEIGHT ADJUST	DOUBLE ACTING PNEUMATIC WITH SENSORS
7-2836871-1	B	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2836871-2	B	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2836871-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.40 mm [.055]	F
INSUL	1.68 mm [.066]	F

APPLICATOR INSTRUCTIONS  
408-35042

TERMINAL DATA: DELPHI PACKARD TERMINAL DELPHI CRIMP SPECIFICATION			
TERMINAL NAME: TAXI TERMINAL F OCS 1.2			
WIRE STRIP LENGTH	TERMINAL INSULATION DIAMETER RANGE		
3.90-4.70 mm [1.54-.185 IN]	Ø1.20-1.60 mm [0.047-.063 IN]		
TERMINAL APPLICATION SPECIFICATION	DELPHI Rev		
	5		
TERMINALS APPLIED			
TE TERMINAL	DELPHI PACKARD TERMINAL	TE TERMINAL	DELPHI PACKARD TERMINAL
2318346-1	33103493	2237157-1	35080799
2336845-1	35072409		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.50mm2	0.90 +/- 0.05 [.035 +/- .002]	3.7
0.35mm2	0.85 +/- 0.05 [.033 +/- .002]	4.0

- 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. THIS APPLICATOR IS EQUIPPED WITH THE DOUBLE ACTING FEED WITH SENSORS AND IS APPLICATION SPECIFIC. IT DOES NOT REQUIRE ITEMS 49 & 248.
- 7. 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)

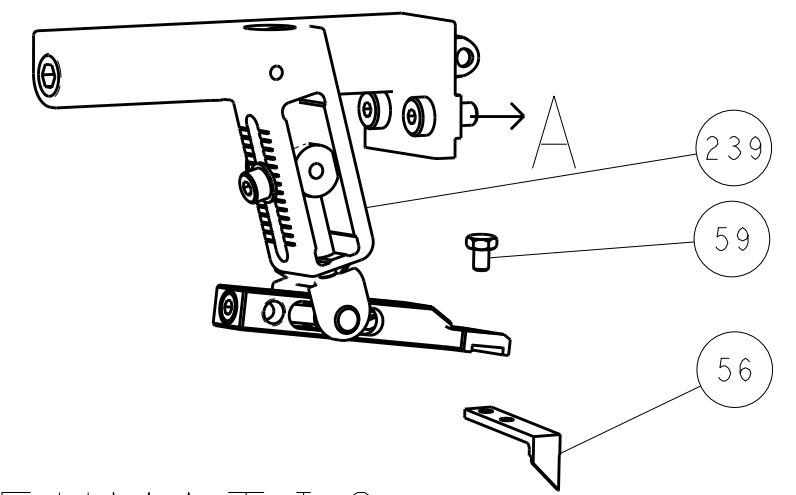
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		B		ECR-19-002752	20FEB2019	FJ	TE
		B1		ECR-19-009881	25JUN2019	FZ	TE

-	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	1	2119082-5	CAM, SNAIL, INSULATION ADJUSTMENT	244	
-	1	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243	
-	1	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242	
-	1	1	1	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241	
-	1	1	-	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239	
-	1	-	-	1	-	2063440-1	AIR FEED MODULE	238	
-	2	-	2	2	-	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172	
-	REF	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164	
-	1	-	1	1	-	240638-1	SPRING, FEED FINGER	163	
-	1	-	1	1	-	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854	137	
-	1	-	1	1	-	2119799-1	HOLDER, FEED FINGER, AF	136	
-	1	1	1	1	1	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113	
-	1	1	1	1	1	2844908-1	SCREW, LOCKING	99	
-	1	1	1	1	1	2844907-1	POST, LOCKING	98	
-	1	1	1	1	1	455888-5	SPACER, CRIMPER	82	
-	1	1	1	1	1	1803607-1	DOCUMENTATION PACKAGE	71	
-	1	1	1	1	1	2119791-9	DEPRESSOR, WIRE	70	
-	1	1	1	1	1	2119740-1	TAG, IDENTIFICATION	67	
-	2	2	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66	
-	1	1	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	60	
-	1	1	1	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59	
-	1	1	1	1	1	1338685-1	PAWL, FEED	56	
-	4	4	4	4	4	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	54	
-	2	2	2	2	2	2-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 14	53	
-	1	1	1	1	1	5018030-1	NUT, HEX, REG, RoHS, M3	52	
-	1	1	1	1	1	811242-5	BUMPER, HOLD DOWN	51	
-	1	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	1	1803583-9	APPLICATOR BASIC ASSEMBLY, SF	46	
-	1	1	1	1	1	1803515-1	RAM ASSEMBLY, SF ATLANTIC	44	
-	1	1	1	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41	
-	1	1	1	1	1	1752356-6	SUPPORT, TERMINAL	34	
-	2	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33	
-	2	2	2	2	2	2-2844962-4	SPACER, CYLINDRICAL, STRIP GUIDE	30	
-	1	1	1	1	1	2844992-2	ASSEMBLY, STRIP GUIDE	29	
-	1	1	1	1	1	1320928-2	STRIP GUIDE	24	
-	1	1	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21	
-	2	2	2	2	2	1-18028-2	WASHER, FLAT, REG M4	20	
-	1	1	1	1	1	2119533-1	STRIPPER, SIDE FEED	19	
-	1	1	1	1	1	2119806-1	INSERT, SHEAR	13	
-	1	1	1	1	1	3-22280-3	SPRING, COMPRESSION	12	
-	1	1	1	1	1	1-356885-4	STOP, SHEAR	11	
-	1	1	1	1	1	2119805-1	SHEAR HOLDER, FRONT	10	
-	1	1	1	1	1	1803095-6	FLOATING SHEAR, FRONT	9	
-	1	2	2	1	1	6-1633917-5	ANVIL, COMBINATION	8	
-	1	1	1	1	1	240641-5	SPACER	7	
-	-	-	-	-	-	-	-	6	
-	1	1	1	1	1	2119757-4	DEPRESSOR, SHEAR	5	
-	1	1	1	1	1	238011-4	BLOCK, CRIMPER SPACER	4	
-	1	2	2	1	1	8-1633961-4	CRIMPER, INSULATION F PREMIUM	3	
-	1	1	1	1	1	455888-7	SPACER, CRIMPER	2	
-	1	2	2	1	1	456402-6	CRIMPER, WIRE PREMIUM	1	
-	77	-72	-71	-32	-2	-1	PART NO	DESCRIPTION	ITEM NO

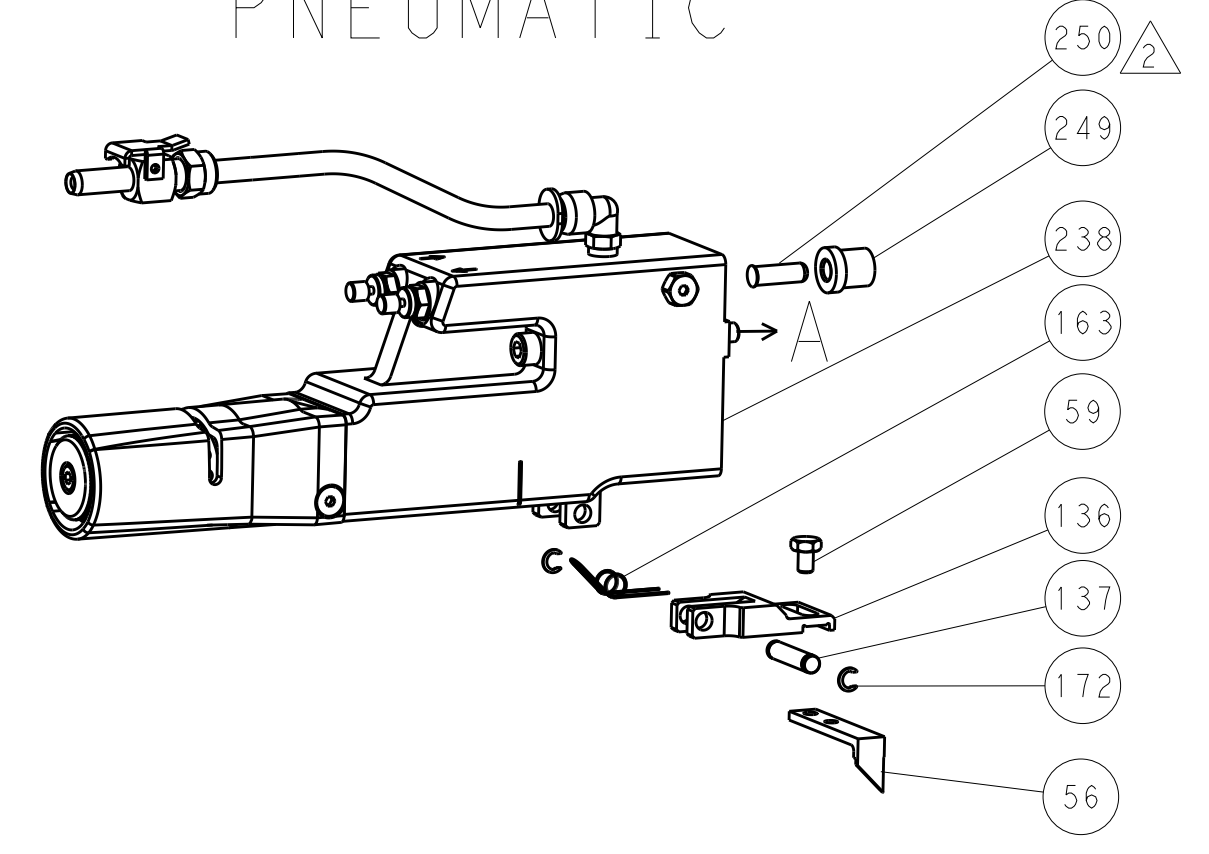
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mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES	FINISH			Customer Accessible Production Drawing	SCALE 1:2
OWN: F. ZHANG 22AUG2017		CHK: K. ZHANG 22AUG2017		APVD: K. ZHANG 22AUG2017		PRODUCT SPEC		NAME: Ocean Side Feed Applicator		RESTRICTED TO: REV B1	
SIZE: A1		CAGE CODE: 00779		DRAWING NO: 2836871		SHEET 1 OF 4		REV B1		SHEET 3 OF 4	

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

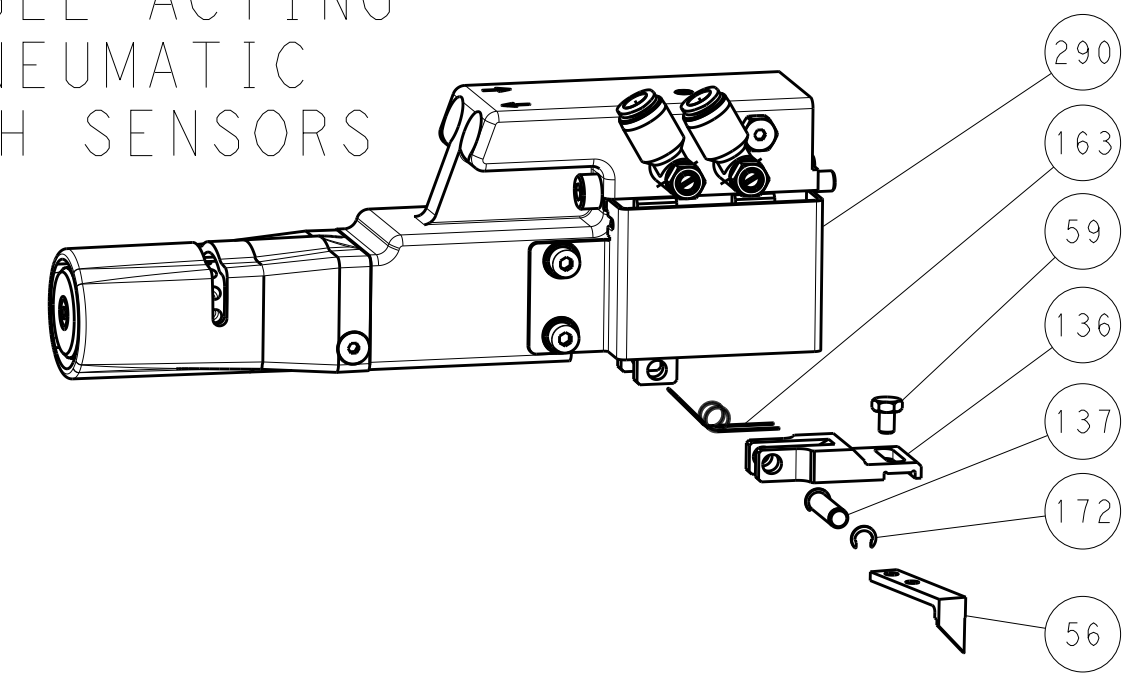
### FEED TYPE MECHANICAL



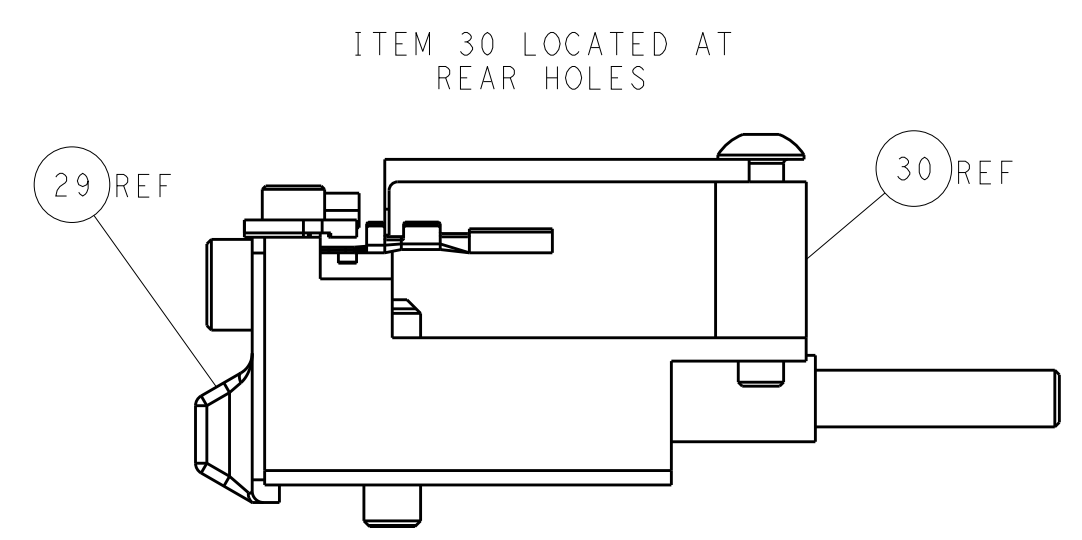
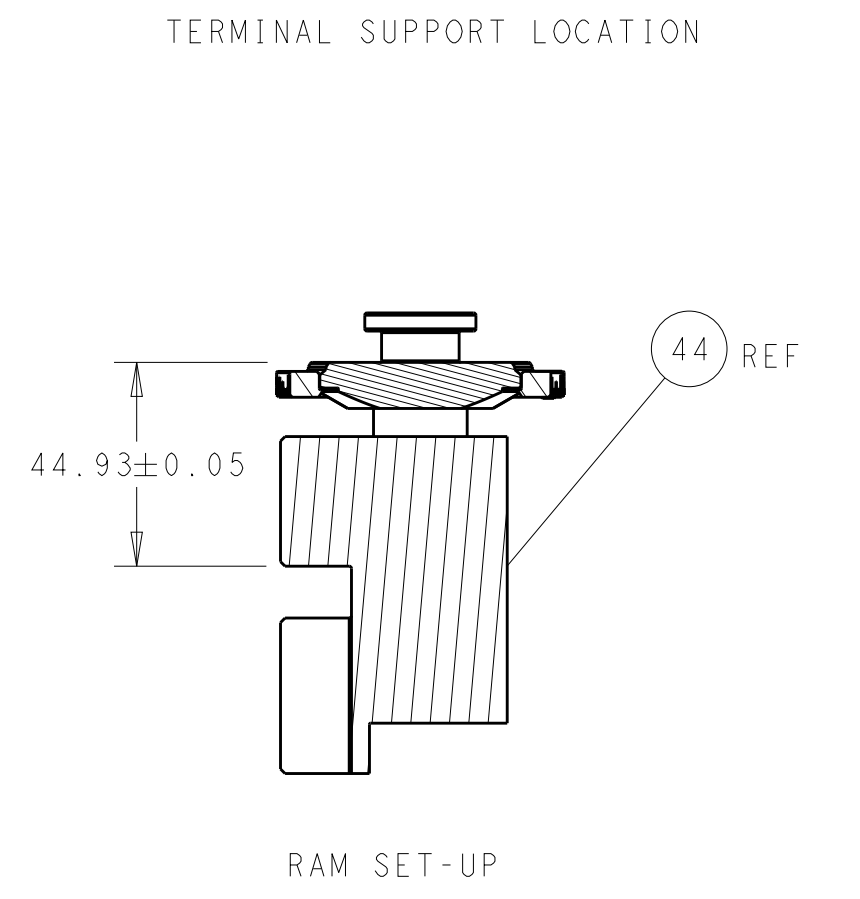
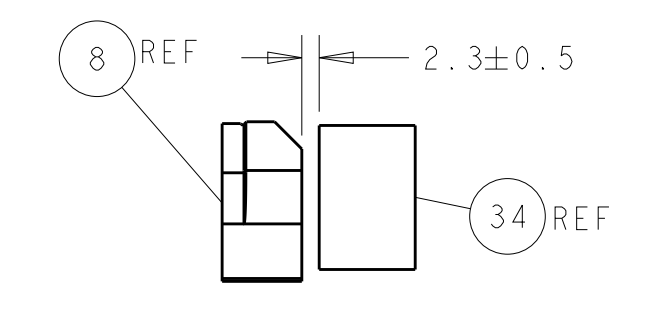
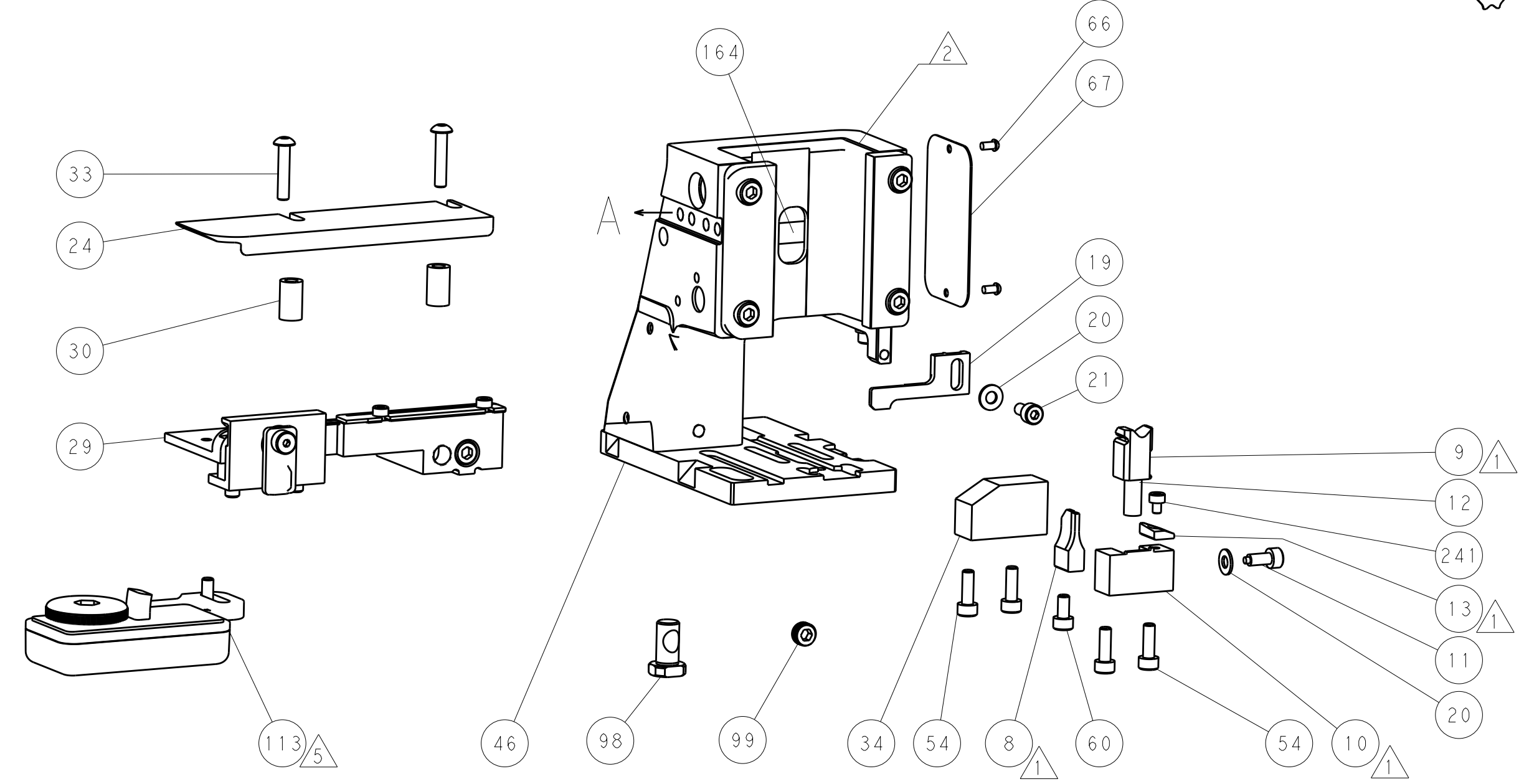
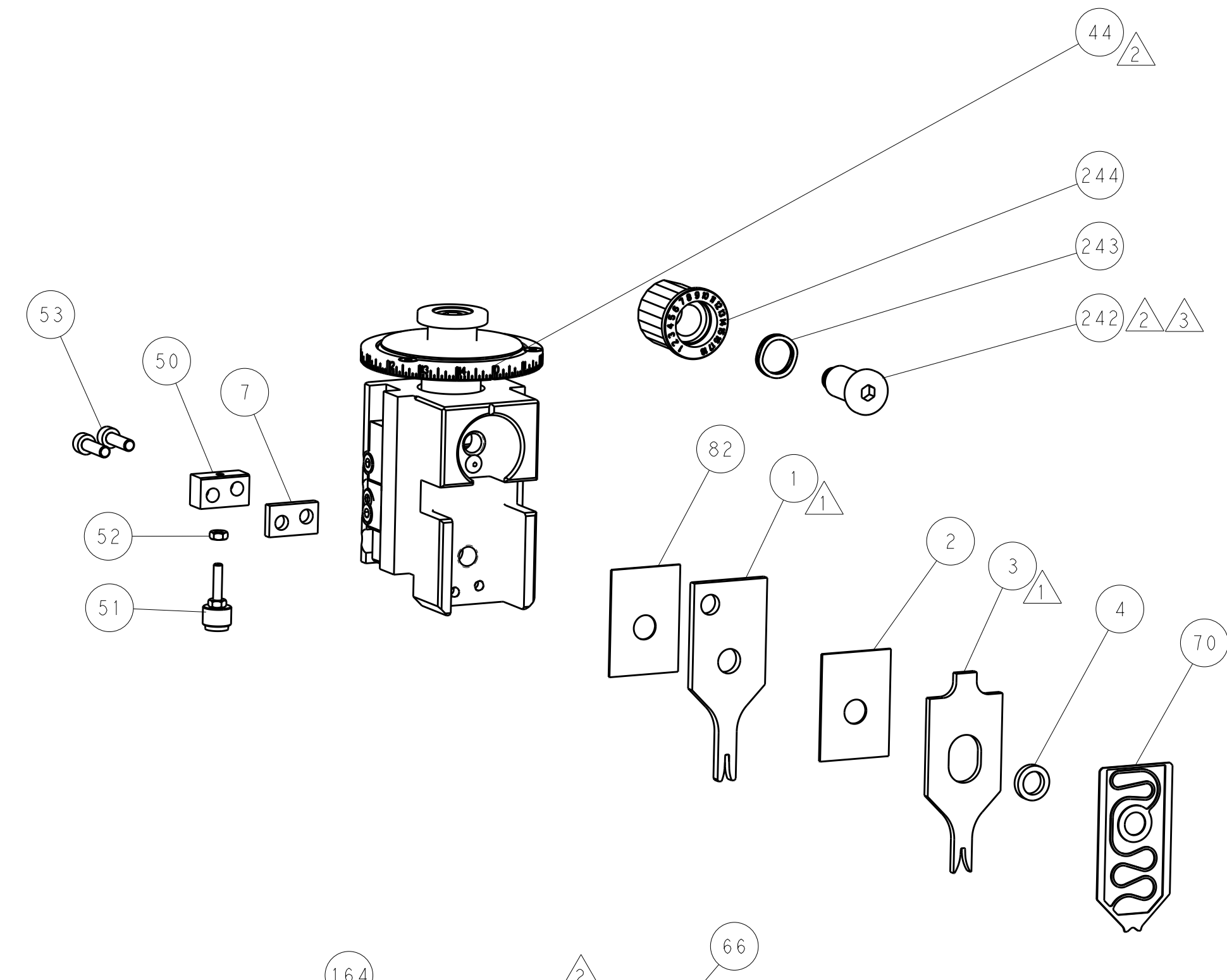
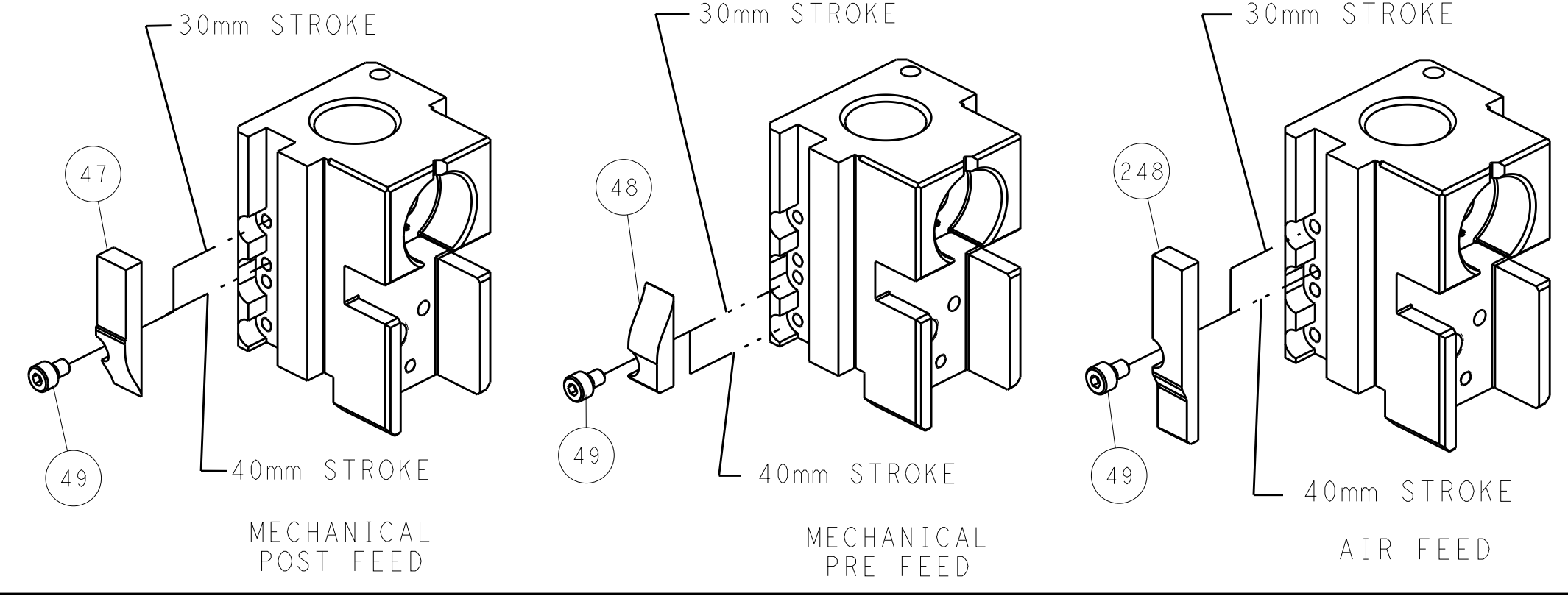
### PNEUMATIC



### DOUBLE ACTING PNEUMATIC WITH SENSORS



### CAM POSITIONS



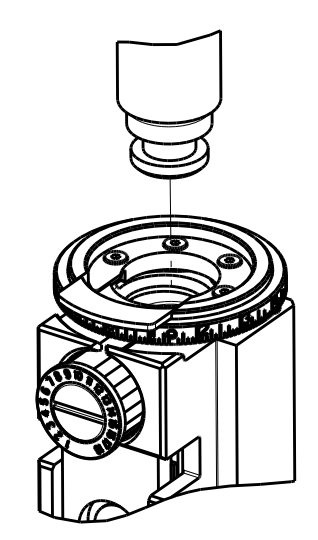
FEED TRACK POSITION GUIDE BY INSULATION BARREL

**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 F. ZHANG 22AUG2017		TE Connectivity	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	Harrisburg, PA 17105-3608	
MATERIAL:		FINISH:		CHK K. ZHANG 22AUG2017		NAME Ocean Side Feed Applicator	
				APVD K. ZHANG 22AUG2017		PRODUCT SPEC	
						APPLICATION SPEC	
				WEIGHT		SIZE CAGE CODE DRAWING NO RESTRICTED TO	
				Customer Accessible Production Drawing		A1 00779 C=2836871	
				SCALE 1:2		SHEET 2 OF 4 REV B1	

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2836871-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2836871-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
4-2836871-2	B	FINE CRIMP HEIGHT ADJUST	DOUBLE ACTING PNEUMATIC WITH SENSORS
7-2836871-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.40 mm [.055]	F
INSUL	1.68 mm [.066]	F

APPLICATOR INSTRUCTIONS  
408-35042

TERMINAL DATA: DELPHI PACKARD TERMINAL DELPHI CRIMP SPECIFICATION

TERMINAL NAME: TAXI TERMINAL F OCS 1.2

WIRE STRIP LENGTH 3.90-4.70 mm [.154-.185 IN]	TERMINAL INSULATION DIAMETER RANGE Ø1.20-1.60 mm [.047-.063 IN]
--	--

TERMINAL APPLICATION SPECIFICATION DELPHI Rev 5

TE TERMINAL	DELPHI PACKARD TERMINAL	TE TERMINAL	DELPHI PACKARD TERMINAL
2318346-1	33103493	2237157-1	35080799
2336845-1	35072409		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.50mm <sup>2</sup>	0.90 +/- 0.05 [.035 +/- .002]	3.7
0.35mm <sup>2</sup>	0.85 +/- 0.05 [.033 +/- .002]	4.0

- 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. THIS APPLICATOR IS EQUIPPED WITH THE DOUBLE ACTING FEED WITH SENSORS AND IS APPLICATION SPECIFIC. IT DOES NOT REQUIRE ITEMS 49 & 248.
- 7. 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)

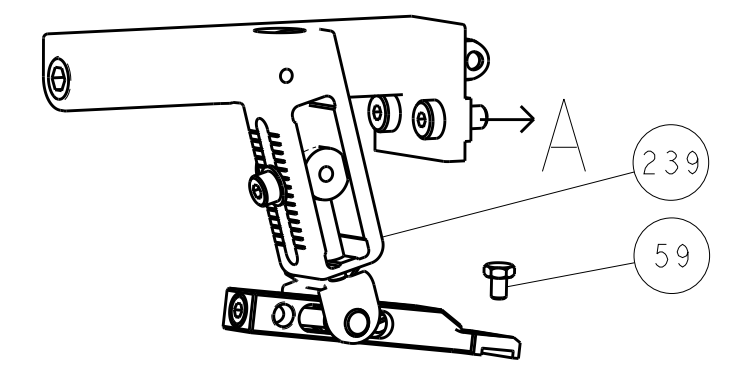
LOC	DIST	REVISIONS					
		P	LTN	DESCRIPTION	DATE	OWN	APVD
A	66	-	-	SEE SHEET 1	-	-	-

-	-	1	-	2119640-1	PUSH ROD, AIR FEED	250
-	-	1	-	1803259-1	BUSHING, FLANGED	249
-	1	1	1	2119082-5	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
-	-	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	-	1	-	2063440-1	AIR FEED MODULE	238
-	2	2	-	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172
-	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	1	1	-	240638-1	SPRING, FEED FINGER	163
-	-	1	-	2119641-2	FEED CAM, AIR FEED	151
-	1	1	1	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	144
-	4	4	4	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	143
-	-	-	1	2119653-2	FEED CAM, POST FEED	142
-	1	1	1	1-1803583-0	APPLICATOR BASIC ASSEMBLY, SF	141
-	1	1	1	1803516-1	RAM ASSEMBLY, SF PACIFIC	140
-	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	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113
-	1	1	1	2844908-1	SCREW, LOCKING	99
-	1	1	1	2844907-1	POST, LOCKING	98
-	1	1	1	455888-5	SPACER, CRIMPER	82
-	1	1	1	1803607-1	DOCUMENTATION PACKAGE	71
-	1	1	1	2119791-9	DEPRESSOR, WIRE	70
-	1	1	1	2119740-1	TAG, IDENTIFICATION	67
-	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	1	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	1	1	1	1338685-1	PAWL, FEED	56
-	2	2	2	2-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 14	53
-	1	1	1	5018030-1	NUT, HEX, REG, RoHS, M3	52
-	1	1	1	811242-5	BUMPER, HOLD DOWN	51
-	1	1	1	690753-2	SPACER, TONKER	50
-	-	1	2	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	-	-	1	2119652-1	FEED CAM, PRE FEED	48
-	1	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
-	1	1	1	1752356-6	SUPPORT, TERMINAL	34
-	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	2	2-2844962-4	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	1	2844992-2	ASSEMBLY, STRIP GUIDE	29
-	1	1	1	1320928-2	STRIP GUIDE	24
-	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
-	2	2	2	1-18028-2	WASHER, FLAT, REG M4	20
-	1	1	1	2119533-1	STRIPPER, SIDE FEED	19
-	1	1	1	2119806-1	INSERT, SHEAR	13
-	1	1	1	3-22280-3	SPRING, COMPRESSION	12
-	1	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	6-1633917-5	ANVIL, COMBINATION	8
-	1	1	1	240641-5	SPACER	7
-	-	-	-	-	-	6
-	1	1	1	2119757-4	DEPRESSOR, SHEAR	5
-	1	1	1	238011-4	BLOCK, CRIMPER SPACER	4
-	1	1	1	8-1633961-4	CRIMPER, INSULATION F PREMIUM	3
-	1	1	1	455888-7	SPACER, CRIMPER	2
-	1	1	1	456402-6	CRIMPER, WIRE PREMIUM	1
-	77	-42	-22	-21	PART NO	ITEM NO

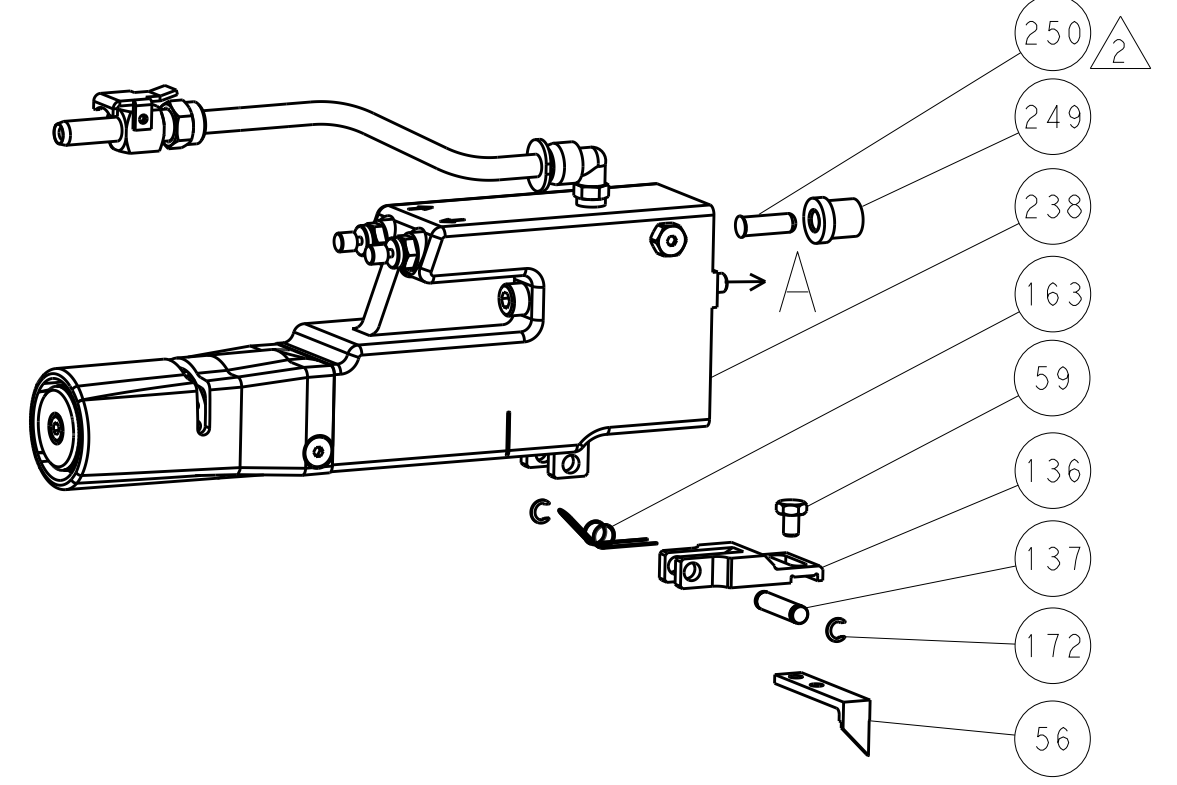
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MATERIAL		FINISH		WEIGHT		SCALE	
				A1 00779		C=2836871	
Customer Accessible Production Drawing				SHEET 3 OF 4		REV B1	

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

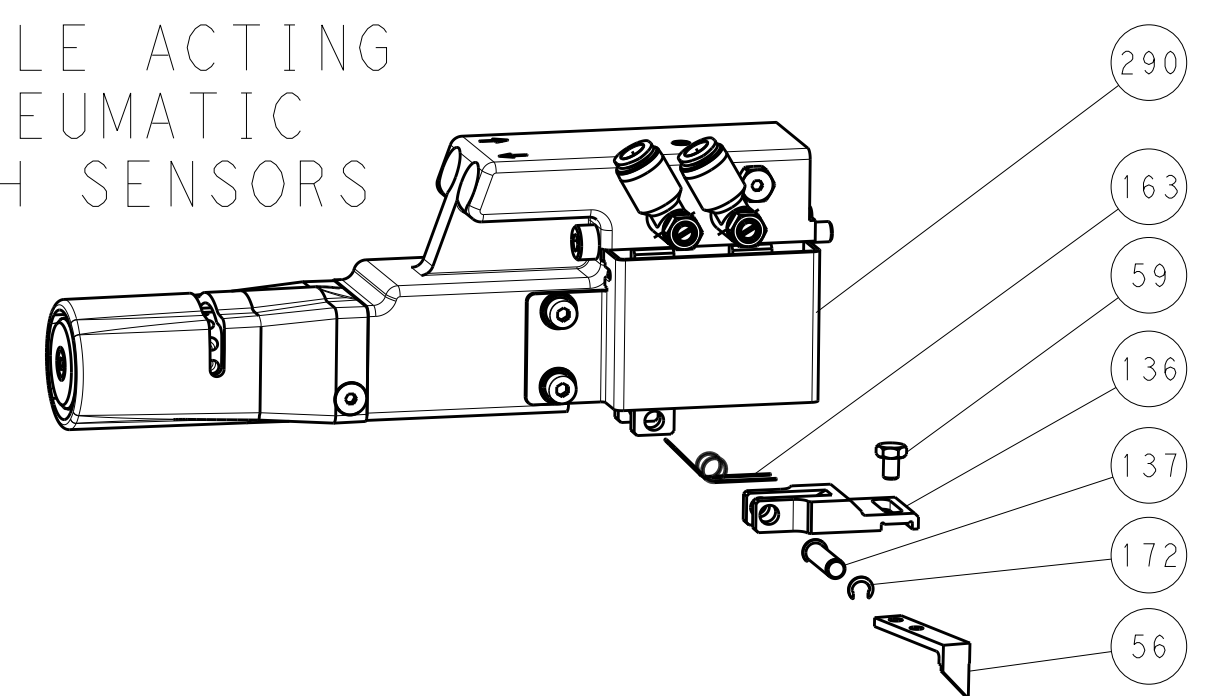
# FEED TYPE MECHANICAL



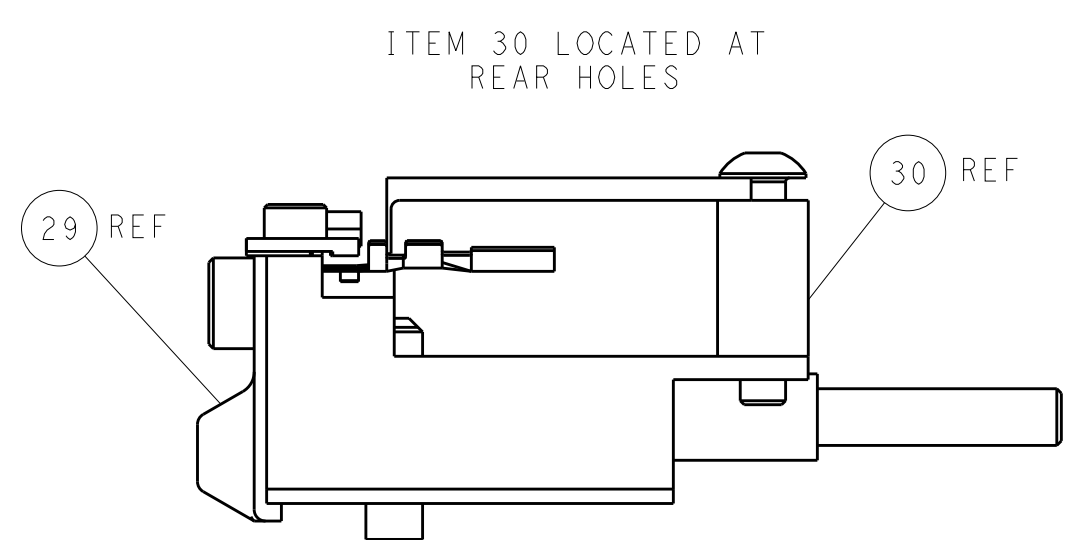
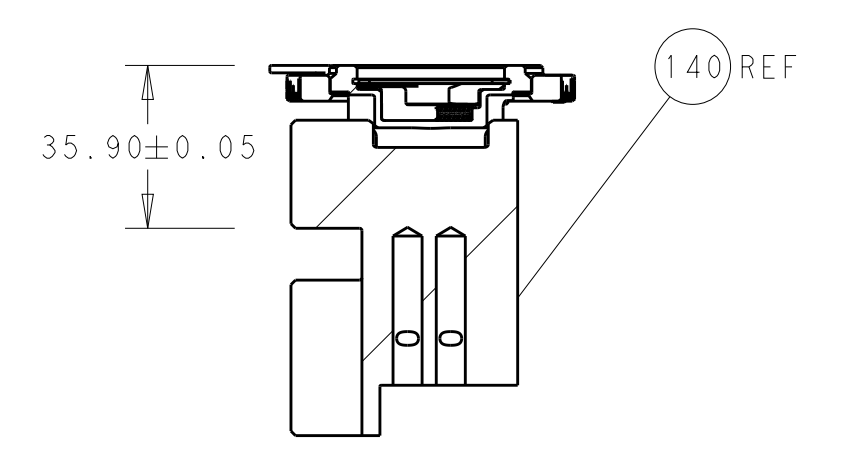
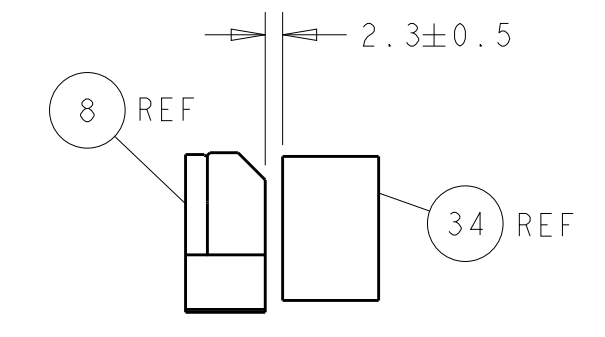
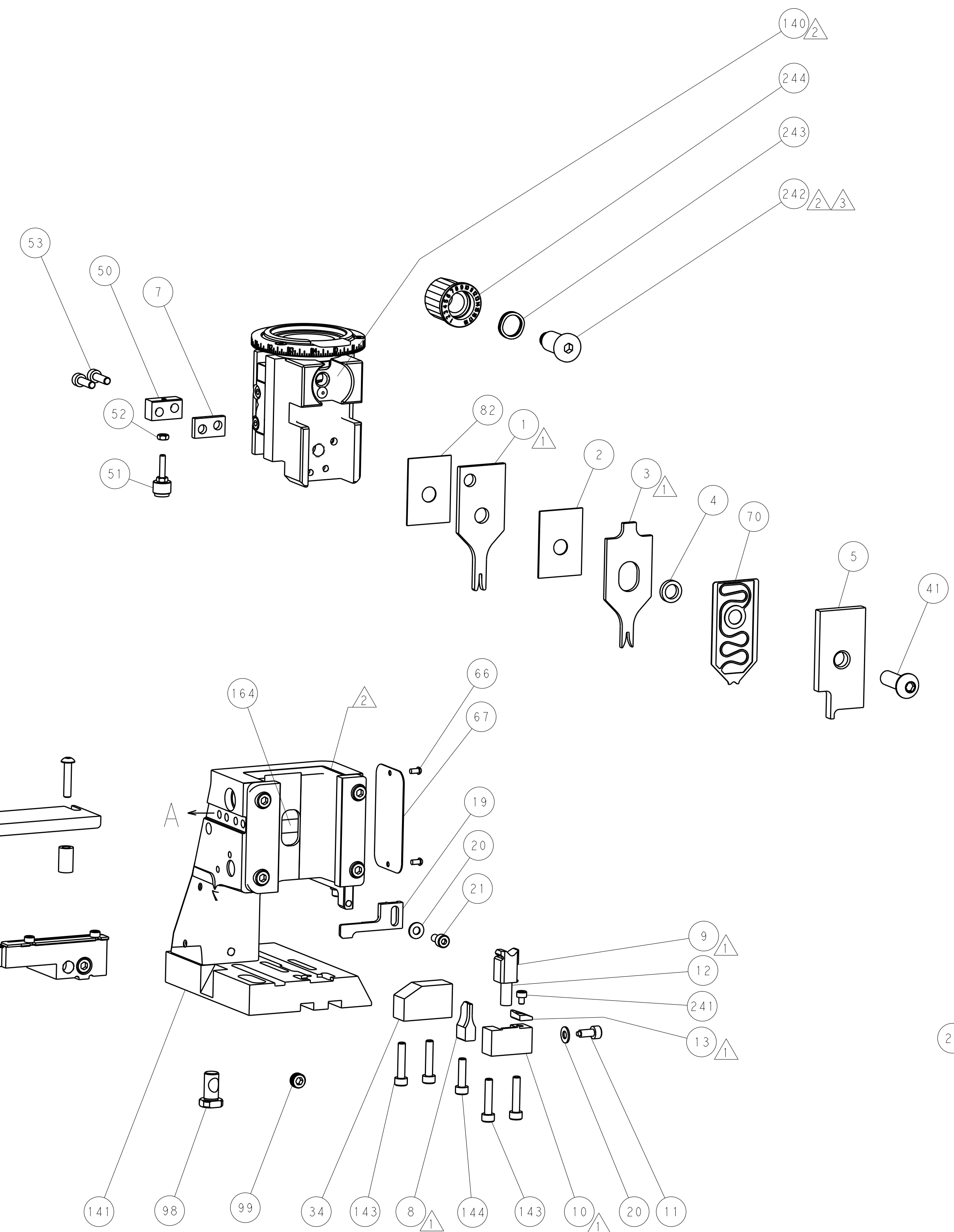
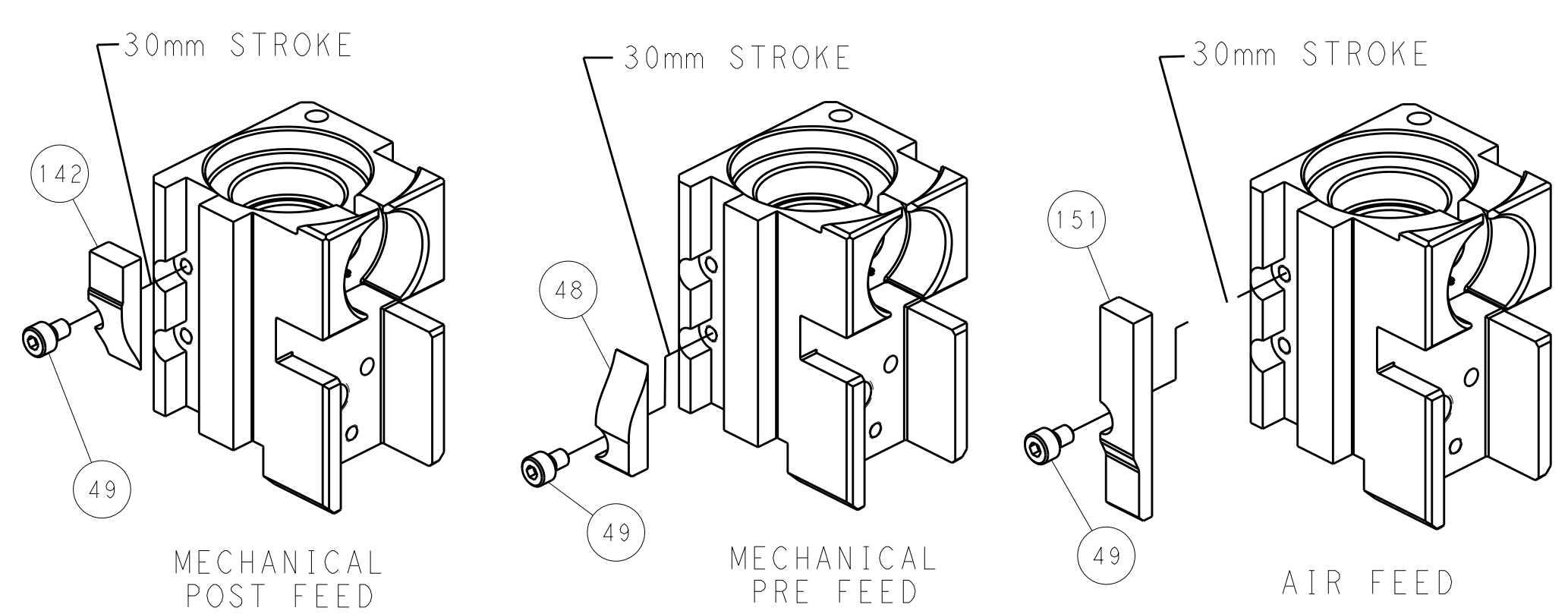
# PNEUMATIC



# DOUBLE ACTING PNEUMATIC WITH SENSORS



# CAM POSITIONS



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

<small>THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION. IT IS THE PROPERTY OF TYCO ELECTRONICS CORPORATION. IT IS TO BE USED ONLY FOR THE PURPOSES AND IN THE ORGANIZATION FOR WHICH IT WAS PREPARED. IT IS NOT TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, INCLUDING PHOTOCOPYING, RECORDING, OR BY ANY INFORMATION STORAGE AND RETRIEVAL SYSTEM, WITHOUT THE WRITTEN PERMISSION OF TYCO ELECTRONICS CORPORATION.</small>		DMN: F. ZHANG 22AUG2017 CHK: K. ZHANG 22AUG2017 APVD: K. ZHANG 22AUG2017	TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		PRODUCT SPEC APPLICATION SPEC WEIGHT SCALE: 1:2	NAME: Ocean Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2836871 SHEET 4 OF 4 REV B1

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