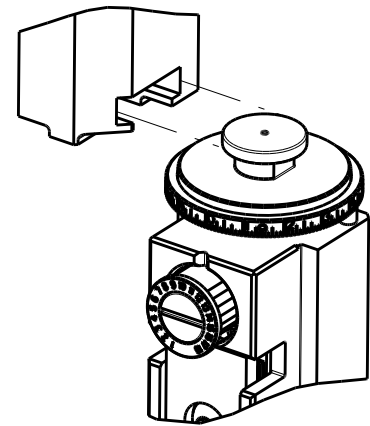


8		7	
THIS DRAWING IS UNPUBLISHED.		RELEASED FOR PUBLICATION	
20		20	
COPYRIGHT 20		BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.	
PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2836871-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2836871-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
3-2836871-2	B	FINE CRIMP 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 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	
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)

2		1						
LOC	DIST	REVISIONS						
A	66	P	LTR	DESCRIPTION	DATE	DWN	APVD	
			A	RELEASED	13SEP2017	TB	CT	
			A1	ECR-18-004769	29MAR2018	MEH	JDG	
			B	ECR-19-002752	20FEB2019	FJ	TE	
			B1	ECR-19-009881	25JUN2019	FZ	TE	

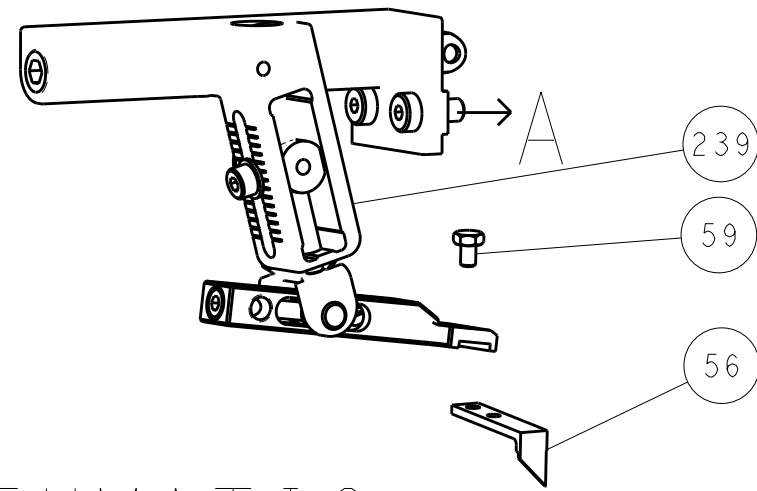
-	1	-	-	1	-	2119640-1	PUSH ROD, AIR FEED	250
-	1	-	-	1	-	1803259-1	BUSHING, FLANGED	249
-	1	-	-	1	-	2119641-1	FEED CAM, AIR FEED	248
-	1	1	1	1	1	2119082-5	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	1	1	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
-	-	1	-	-	1	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	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	1	8-1633961-4	CRIMPER, INSULATION F PREMIUM	3
-	1	1	1	1	1	455888-7	SPACER, CRIMPER	2
1	2	2	1	1	1	456402-6	CRIMPER, WIRE PREMIUM	1
-77	-72	-71	-32	-2	-1	PART NO	DESCRIPTION	ITEM NO

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DIMENSIONS: mm				CHK K. ZHANG 22AUG2017	NAME Ocean Side Feed Applicator			
TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH ±				APVD K. ZHANG 22AUG2017	PRODUCT SPEC			
MATERIAL					APPLICATION SPEC			
					SIZE CASE CODE DRAWING NO			
					WEIGHT			
					A1 00779 ©=2836871			
					Customer Accessible Production Drawing			
					SCALE 1:2 SHEET 1 OF 4 REV B1			

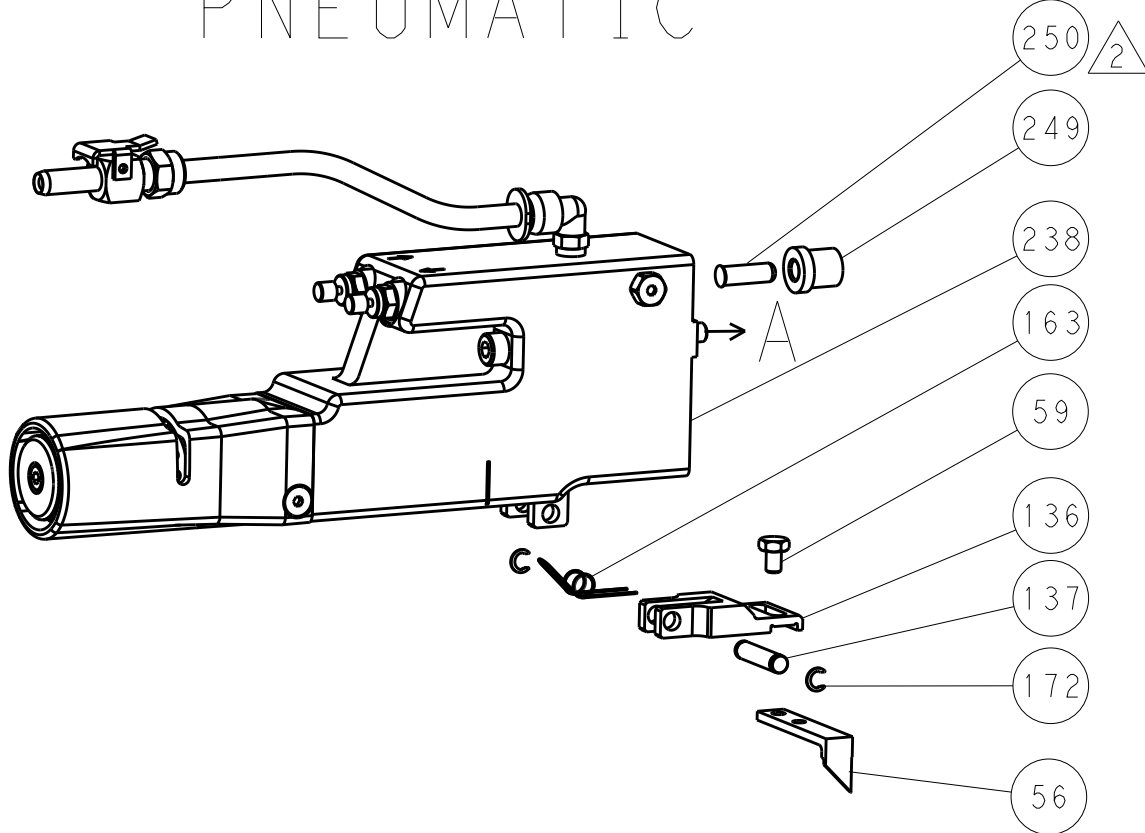
SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

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

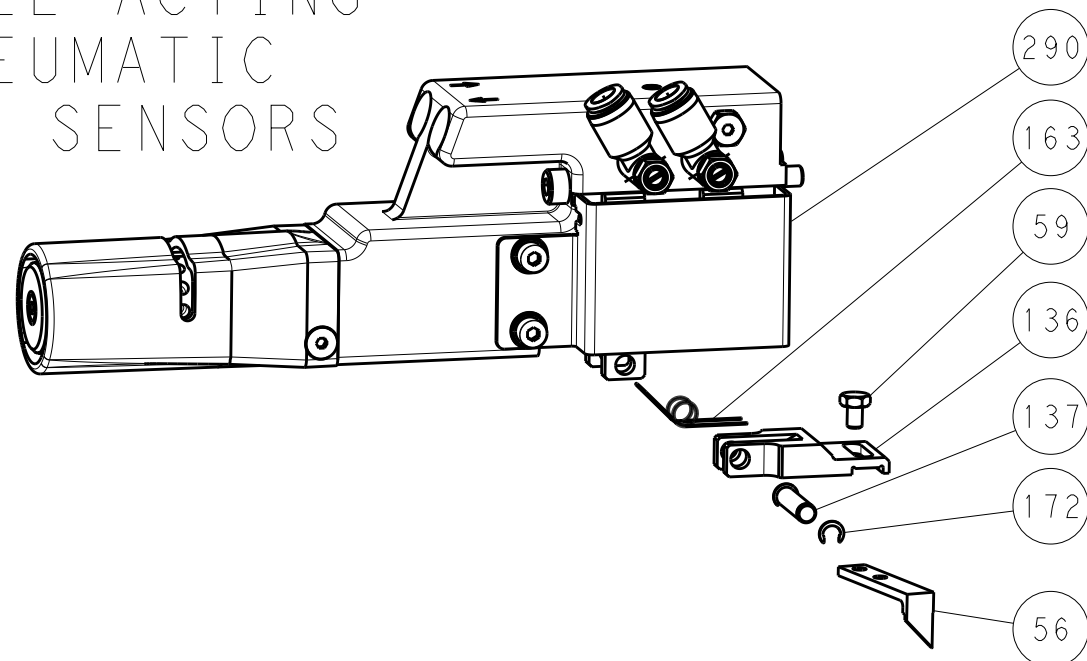
# FEED TYPE MECHANICAL



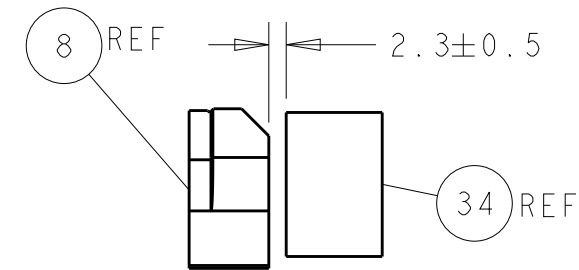
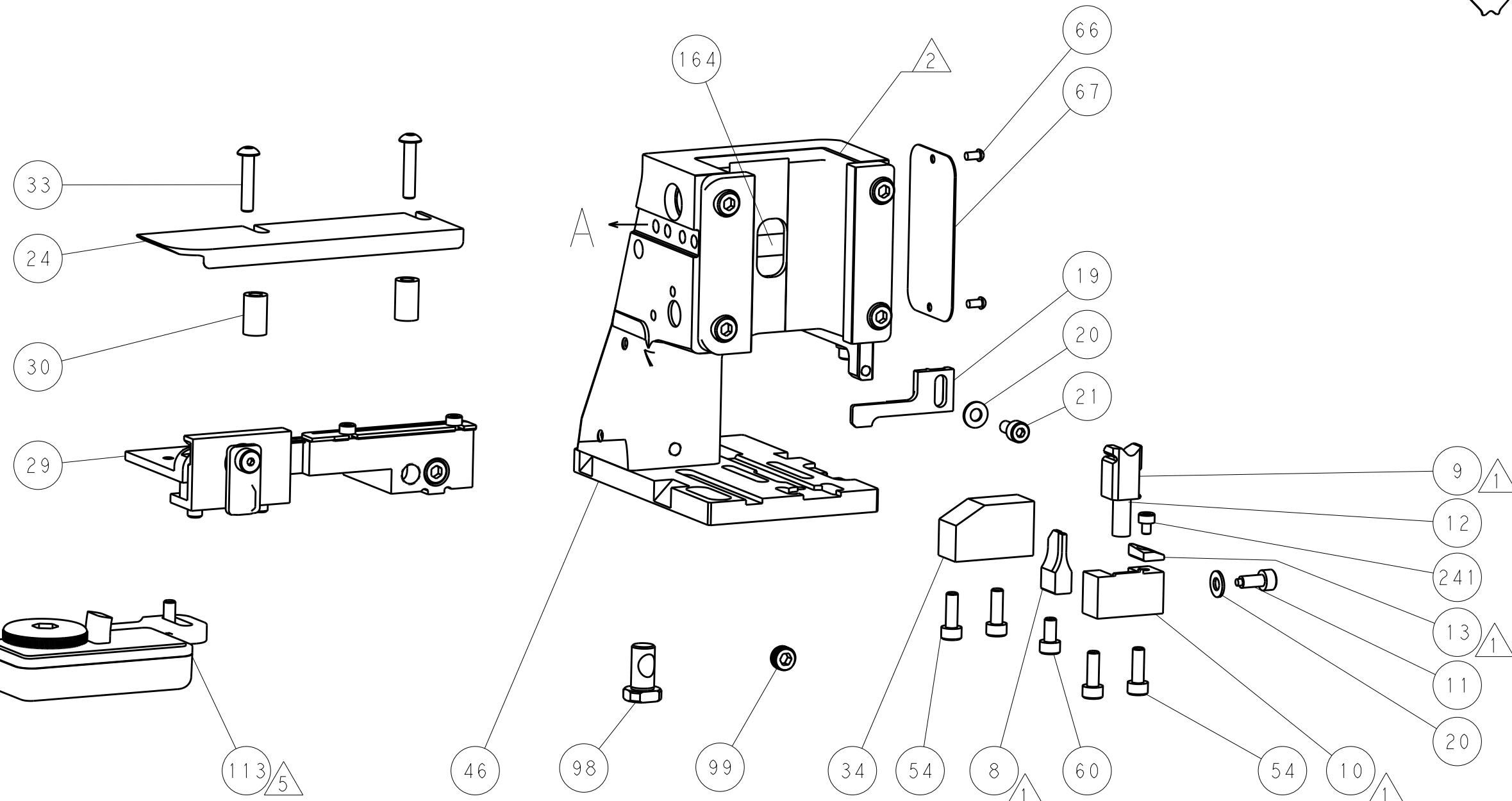
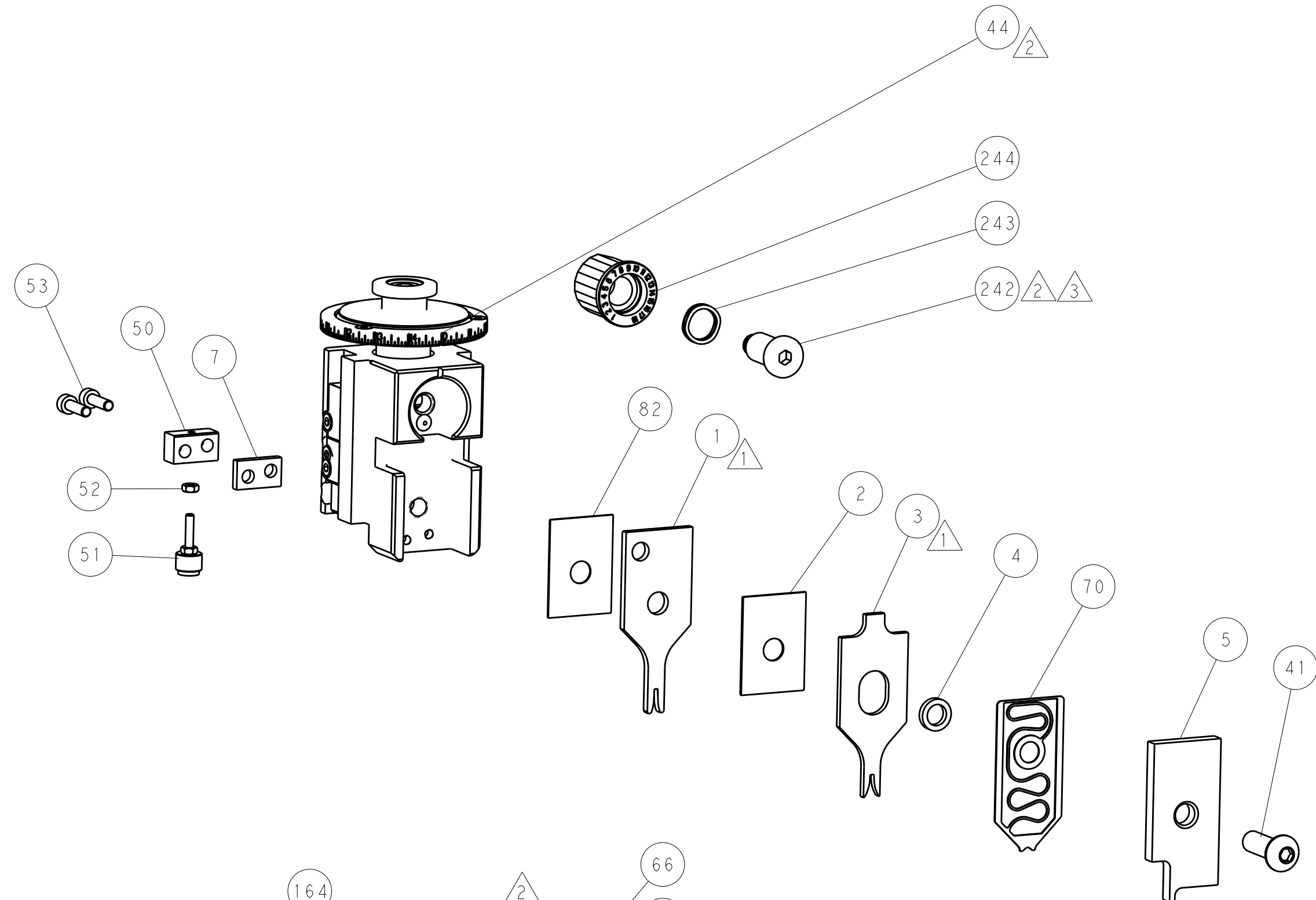
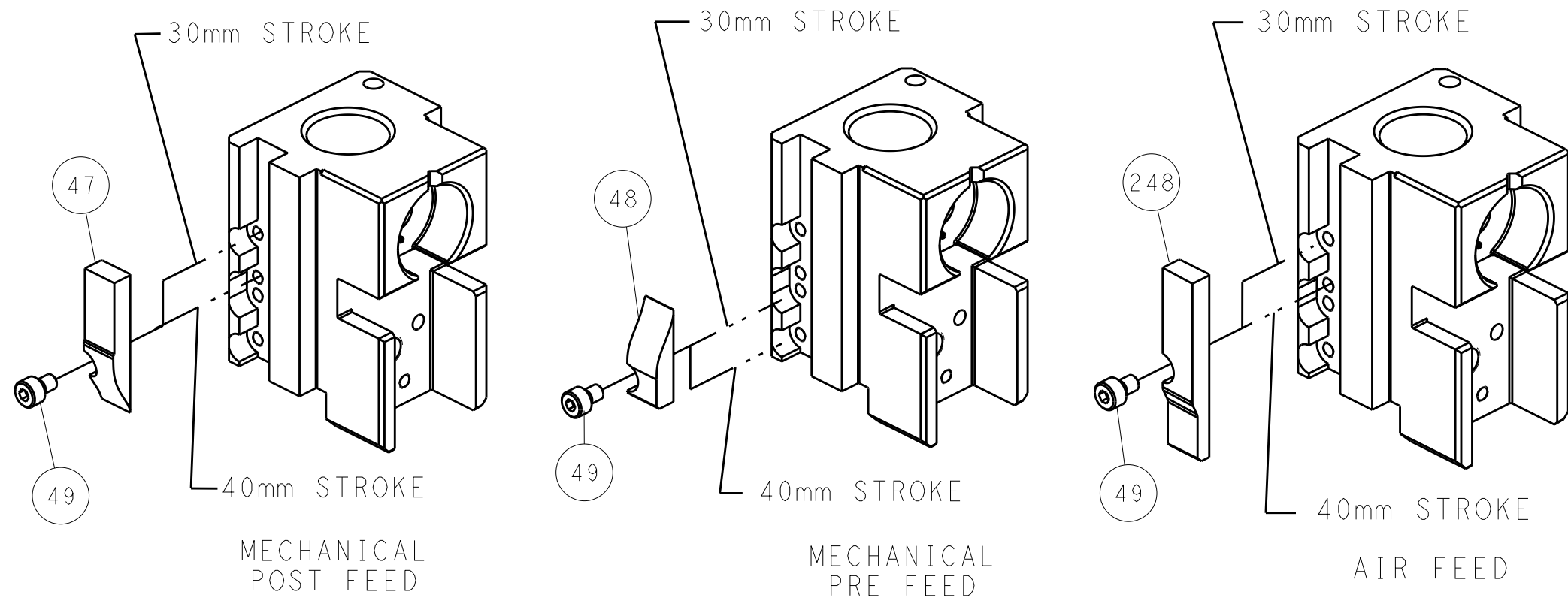
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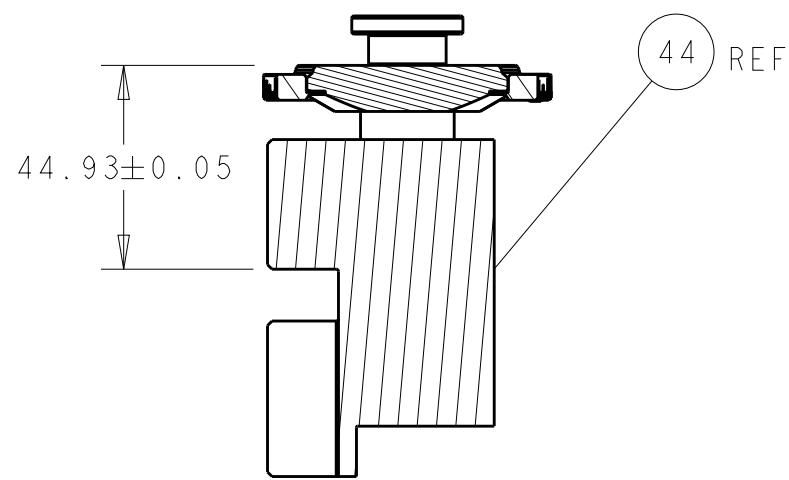
# DOUBLE ACTING PNEUMATIC WITH SENSORS



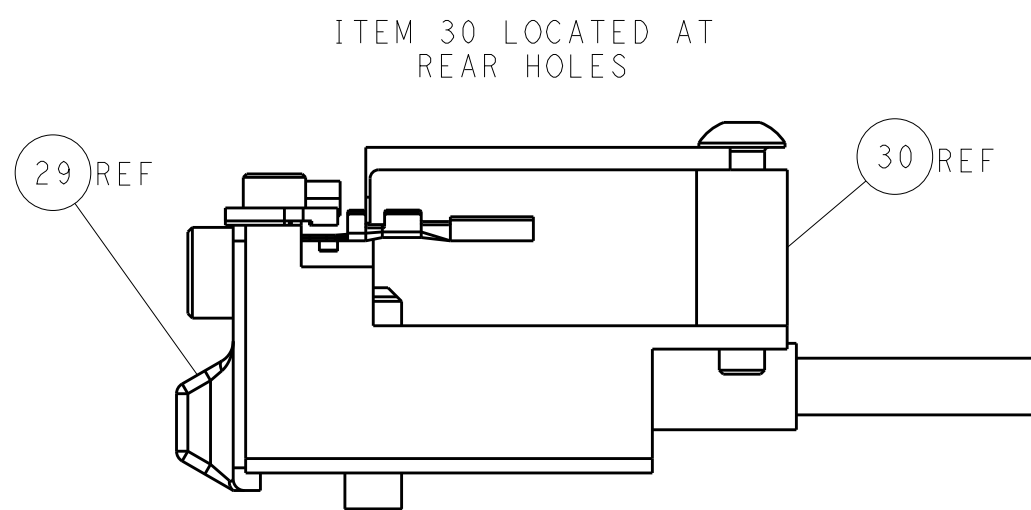
# CAM POSITIONS



TERMINAL SUPPORT LOCATION



RAM SET-UP



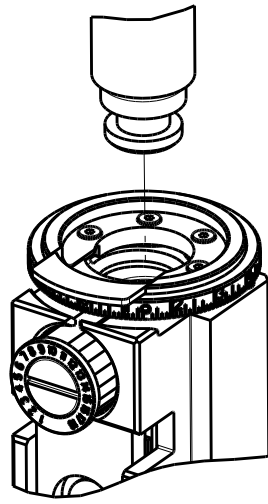
FEED TRACK POSITION  
GUIDE BY INSULATION BARREL

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

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DIMENSIONS: mm				TOLERANCES UNLESS OTHERWISE SPECIFIED:		PRODUCT SPEC		APPLICATION SPEC		SIZE A1	
				0 PLC ±.00		1 PLC ±.00		2 PLC ±.00		3 PLC ±.00	
				4 PLC ±.00		5 PLC ±.00		6 PLC ±.00		7 PLC ±.00	
				ANGLES		WEIGHT		Customer Accessible Production Drawing		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	-	-
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+/-0.002]		3.7
0.35mm2		0.85+/-0.05 [.033+/-0.002]		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)

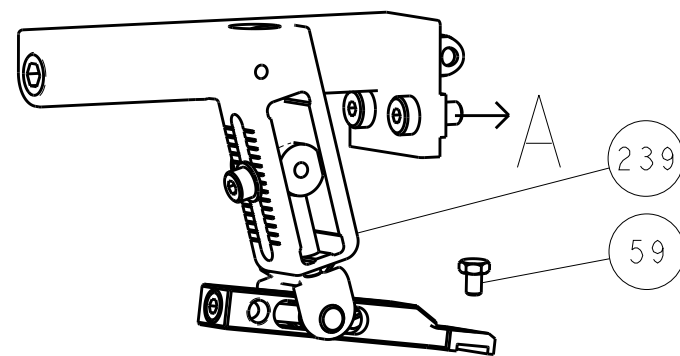
LOC	DIST	REVISIONS				
		P	LTR	DESCRIPTION	DATE	OWN
A	66	-	-	SEE SHEET 1	-	-

-	-	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	DESCRIPTION	ITEM NO

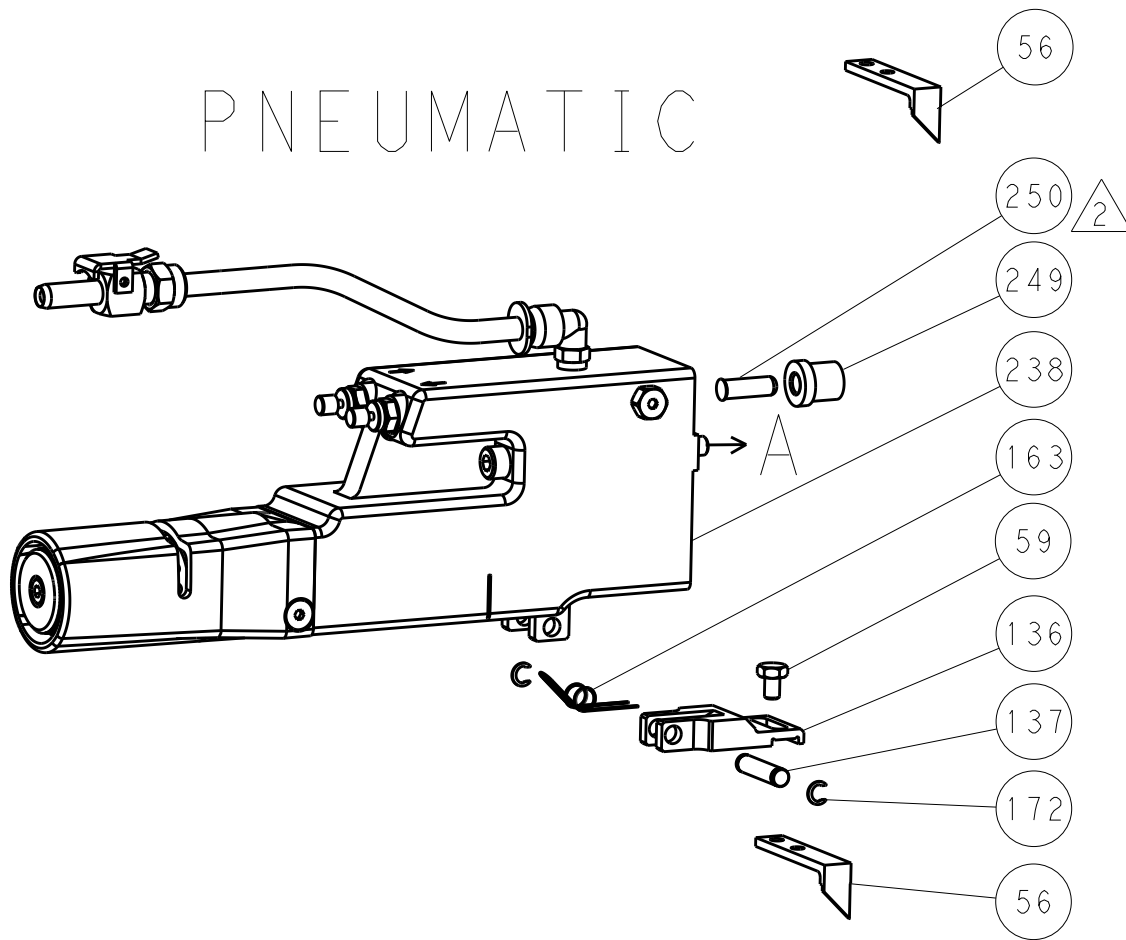
THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE WITHOUT NOTICE AND WITHOUT LIABILITY. ANY CHANGES TO THIS DRAWING SHALL BE CONTACTED FOR THE LATEST REVISION.				OWN F. ZHANG CHK K. ZHANG APVD K. ZHANG	22AUG2017 22AUG2017 22AUG2017	TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		PRODUCT SPEC		NAME	
mm		0 PLC ±.01 1 PLC ±.01 2 PLC ±.01 3 PLC ±.01 4 PLC ±.01		APPLICATION SPEC		SIZE	
		ANGLES		WEIGHT		00779	
MATERIAL		FINISH		Customer Accessible Production Drawing		SCALE	
-		-		-		1:2	
						3	
						4	
						REV	
						B1	

LOC		DIST		REVISONS			
A	66	P	LTR	DESCRIPTION	DATE	DWN	APVD
		-		SEE SHEET 1	-	-	-

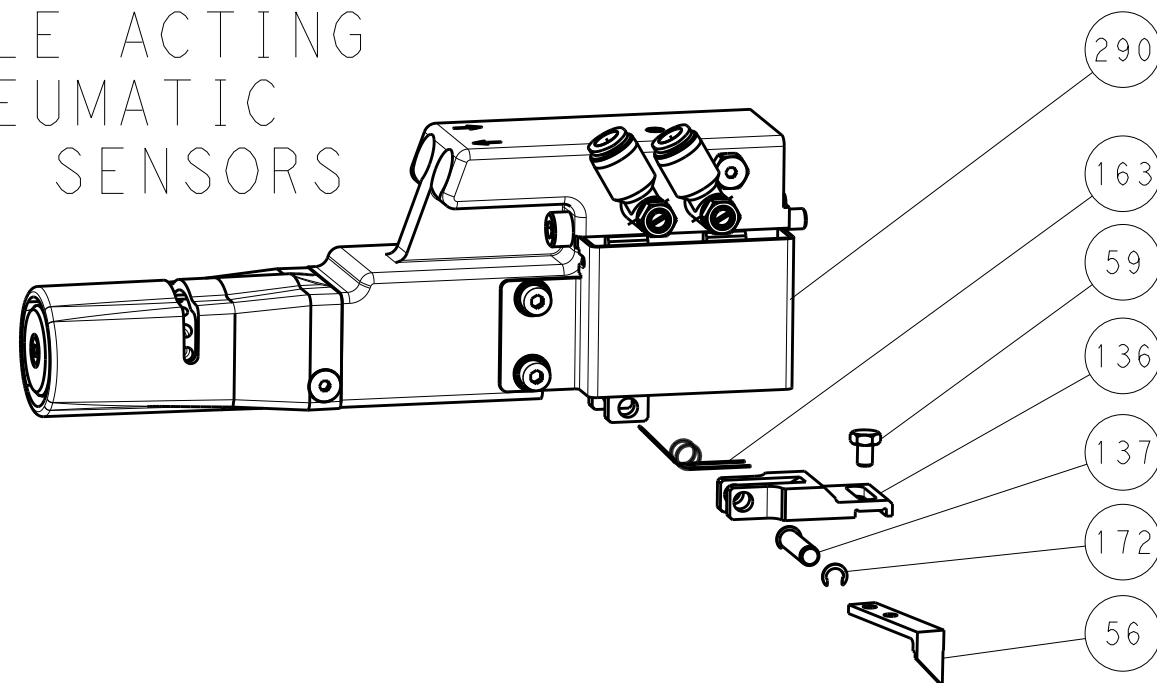
# FEED TYPE MECHANICAL



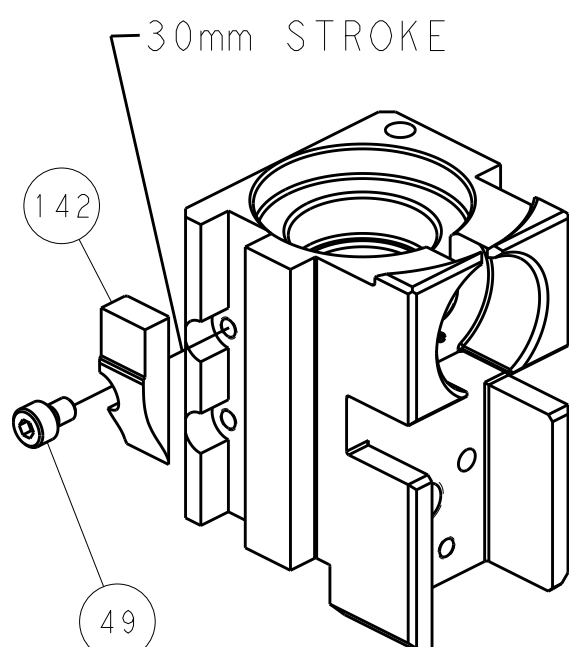
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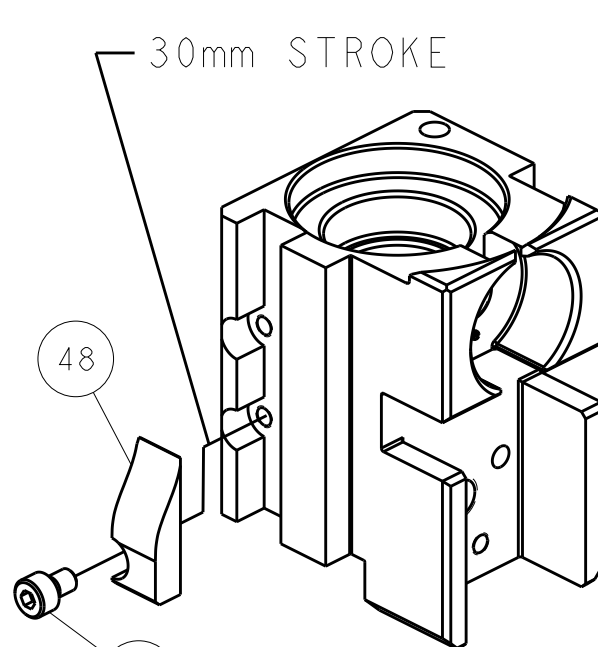
# DOUBLE ACTING PNEUMATIC WITH SENSORS



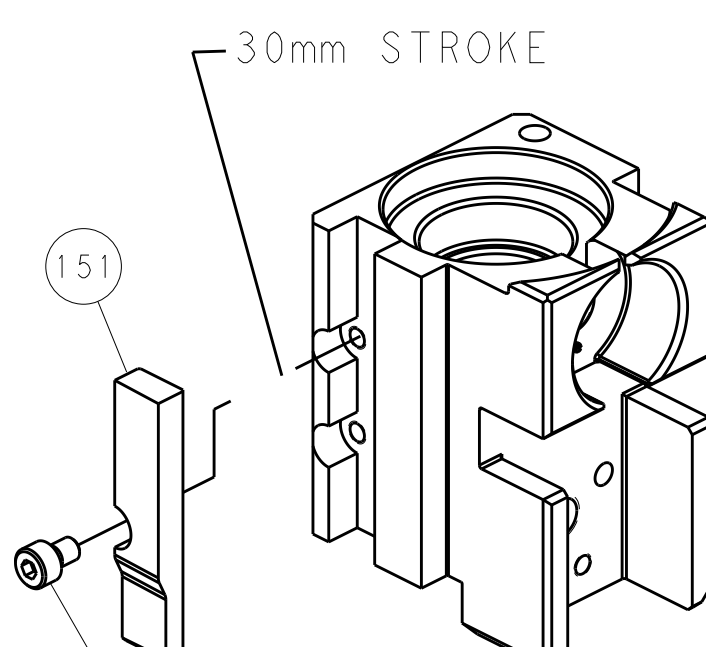
# CAM POSITIONS



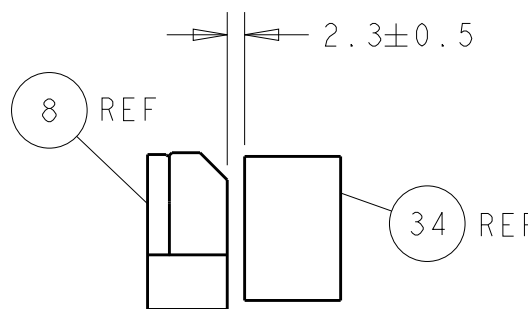
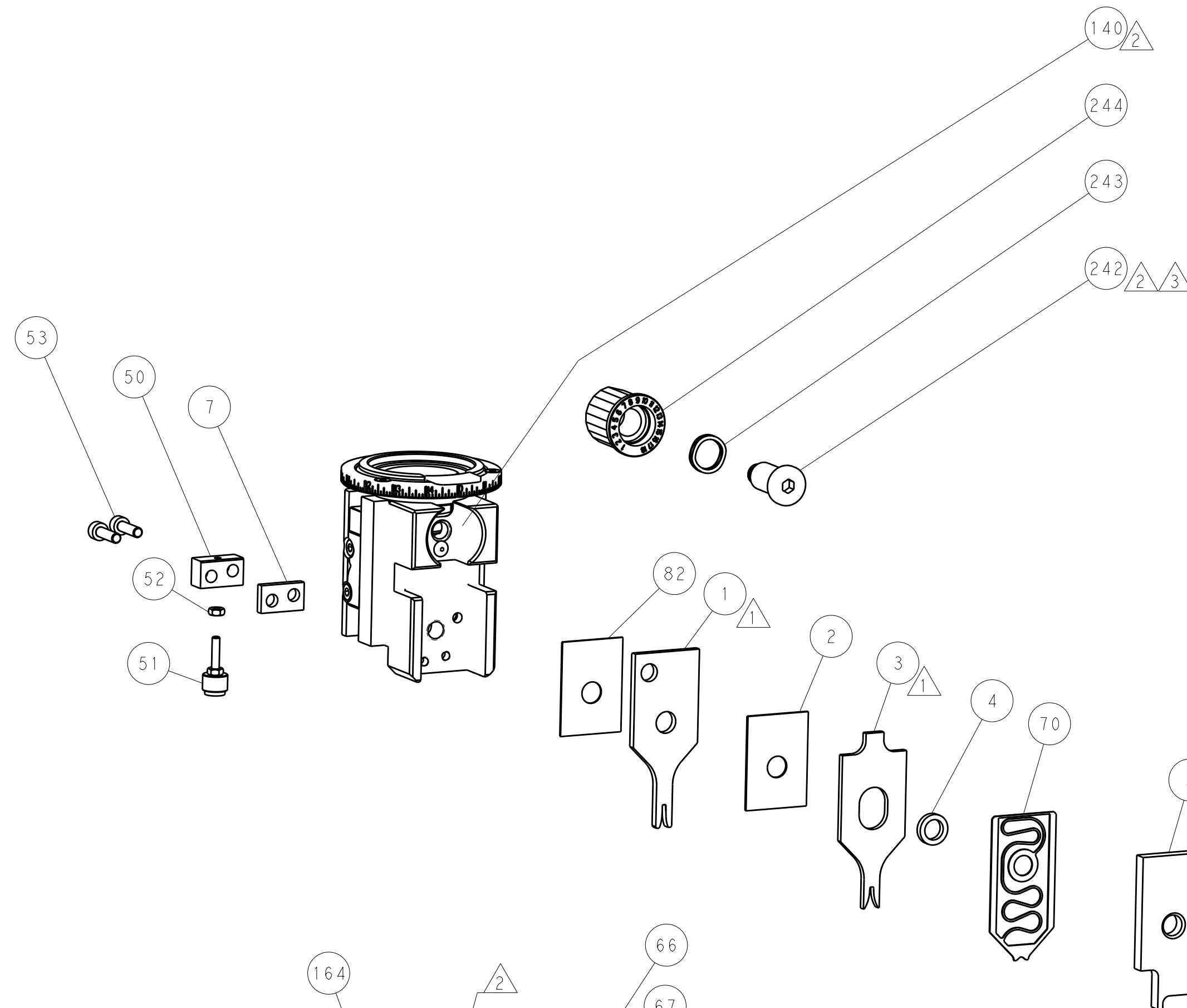
MECHANICAL  
POST FEED



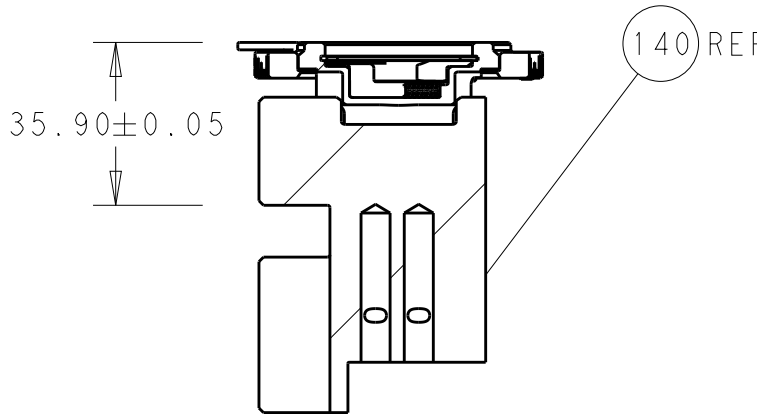
MECHANICAL  
PRE FEED



AIR FEED

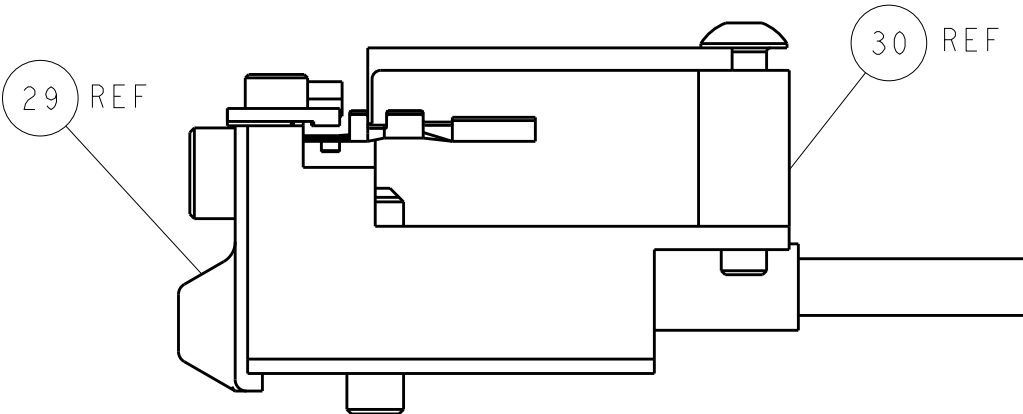


TERMINAL SUPPORT LOCATION



RAM SET-UP

ITEM 30 LOCATED AT  
REAR 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)

THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. ANY CHANGES TO THIS DRAWING SHOULD BE CONTACTED FOR THE LATEST VERSION.				DWN F. ZHANG 22AUG2017	STE TE Connectivity Harrisburg, PA 17105-3608		
				CHK K. ZHANG 22AUG2017			
				APVD K. ZHANG 22AUG2017	NAME Ocean Side Feed Applicator		
DIMENSIONS: mm				PRODUCT SPEC			
				APPLICATION SPEC			
MATERIAL				WEIGHT	SIZE A1		
				Customer Accessible Production Drawing	SCALE 1:2		
					SHEET 4		
					REV B1		

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