

8		7	
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2016		2016	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2836334-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2836334-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
5-2836334-1	B	SEAL STRIPPER CRIMPER TERMINATING UNIT	MECHANICAL
5-2836334-2	B	SEAL STRIPPER CRIMPER TERMINATING UNIT	PNEUMATIC
7-2836334-1	B	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2836334-2	B	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2836334-7	A	CRIMP TOOLING KIT	-

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.93 mm [.076]	F
INSUL	4.00 mm [.157]	O
APPLICATOR INSTRUCTIONS 408-35042		

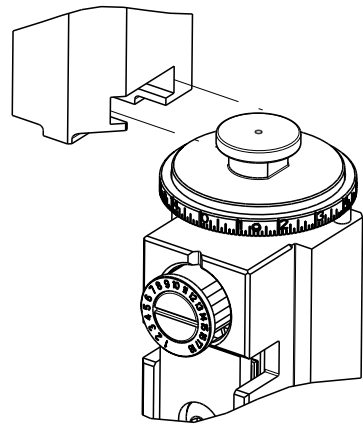
TERMINAL DATA: DELPHI TERMINAL DELPHI CRIMP SPECIFICATION			
TERMINAL NAME: TAXI TERM M M/P 150 SEALED			
WIRE STRIP LENGTH 4.94-5.70 mm [.194-.224 IN]		INSULATION DIAMETER RANGE Ø -	
TERMINAL APPLICATION SPECIFICATION 12077628 page 9 of 32 Rev 2014-01-09			
TERMINALS APPLIED 			
SEAL INSULATION DIAMETER RANGE			
TE TERMINAL	DELPHI TERMINAL	TE SEAL	DELPHI SEAL
1572275-1	12077628	1572277-2	15324974
1572275-2	15359163	286867-5	15324976
1572275-3	12191888	286867-2	15324973
			Ø 1.29-1.70mm
			Ø 1.60-2.19mm
			Ø 2.03-2.85mm

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.50mm2	1.15+/-0.05 [1.045+/- .002]	6.6
0.35mm2	1.10+/-0.05 [1.043+/- .002]	7.1



- 1 RECOMMENDED SPARE PARTS
- 2 REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- 3 APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 180. 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 TERMINAL LUBRICANT IS RECOMMENDED.
7. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.

ATLANTIC VERSION TERMINATOR
INTERFACE ADAPTER



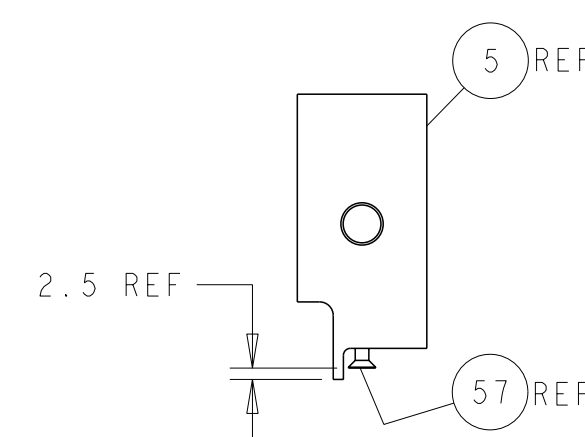
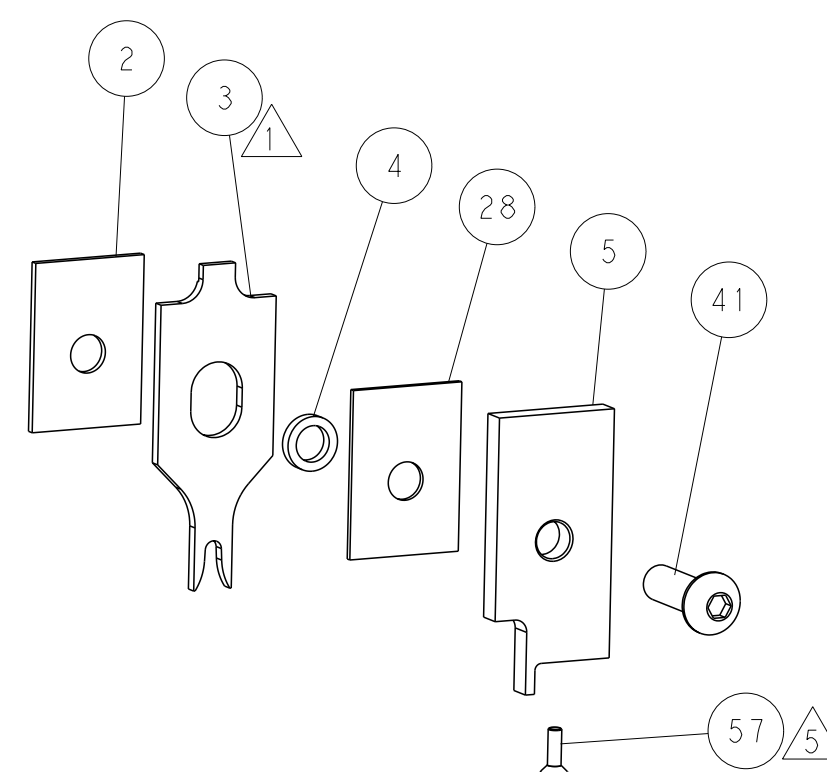
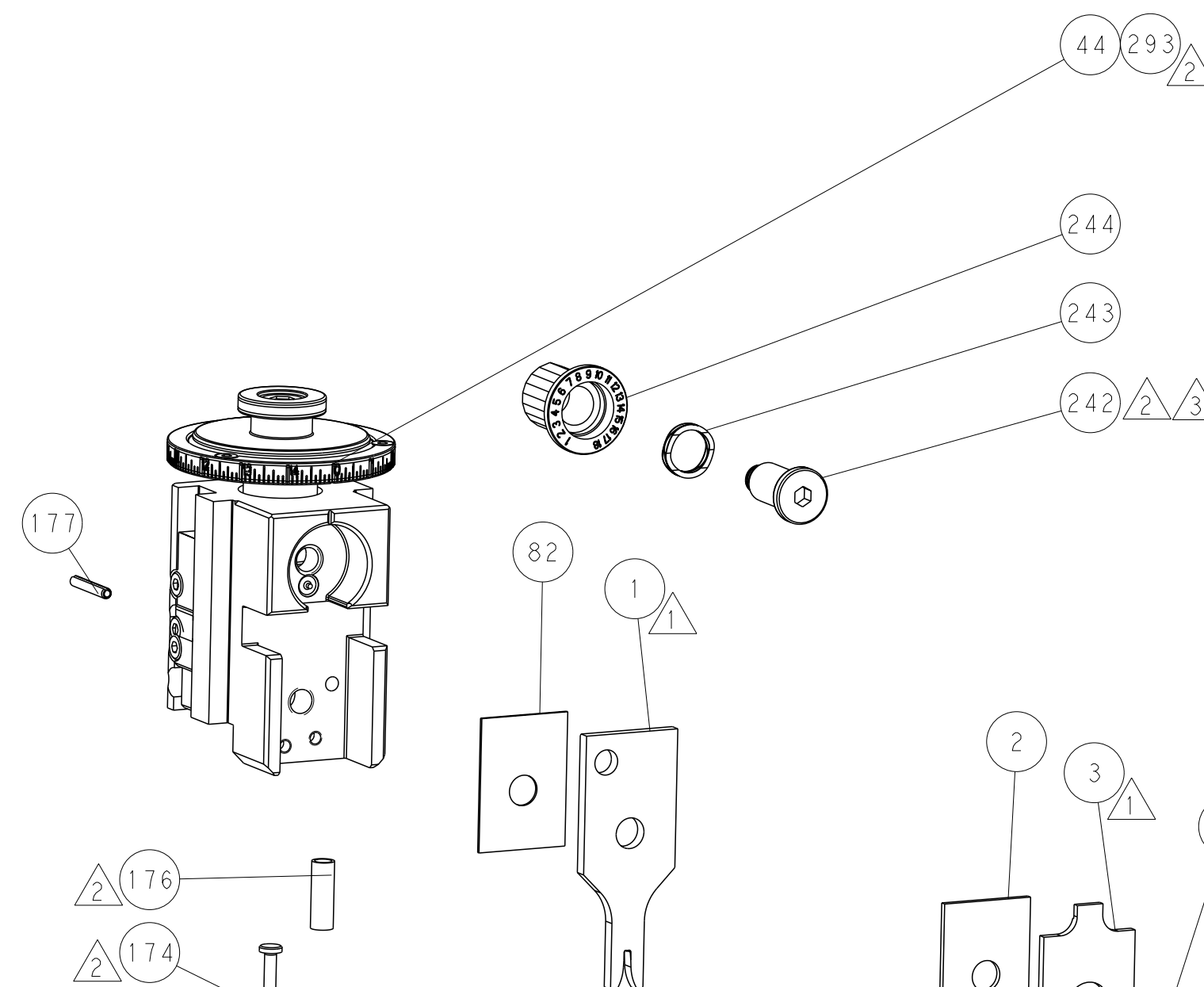
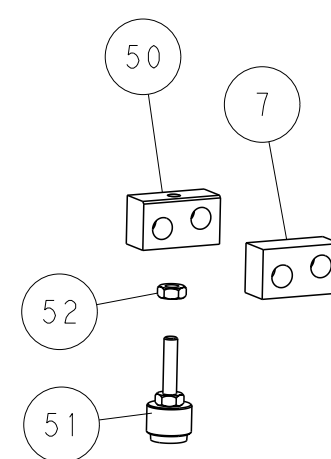
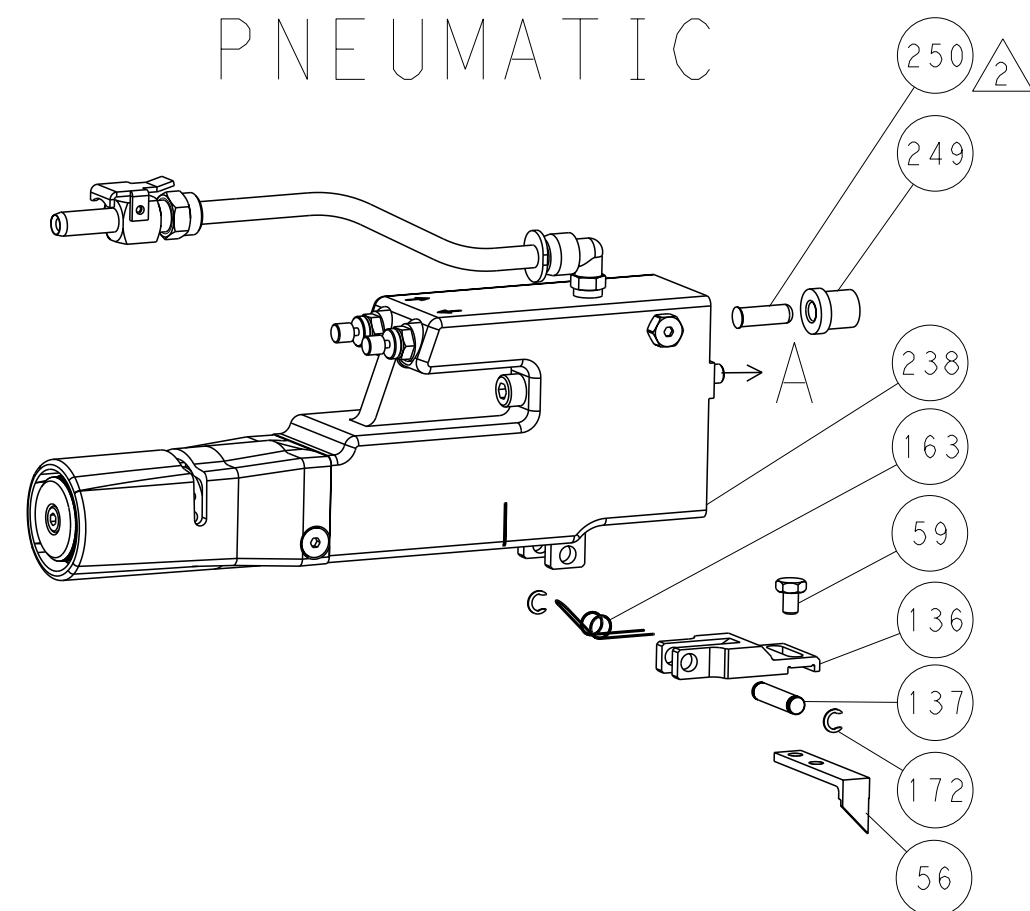
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

2		1					
LOC	DIST	REVISIONS					
A	66	P	LTR	DESCRIPTION	DATE	DWN	APVD
		A		RELEASED	28JUN2016	BW	CT
		B		ECR-19-000368	09JAN2019	JAH	TE

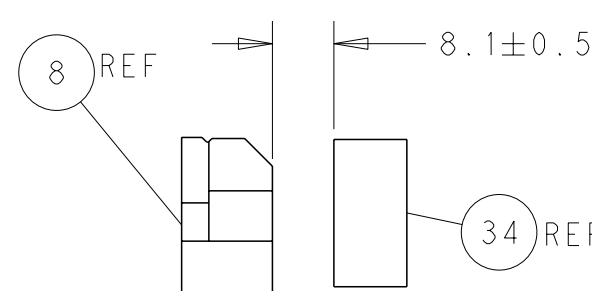
-	-	-	1	1	-	-	1803515-3	RAM ASSEMBLY, SF ATLANTIC	293
-	-	-	1	1	-	-	2-1803583-1	APPLICATOR BASIC ASSEMBLY, SF	292
-	1	-	1	-	1	-	2119640-1	PUSH ROD, AIR FEED	250
-	1	-	1	-	1	-	1803259-1	BUSHING, FLANGED	249
-	1	-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248
-	1	1	1	1	1	1	2119082-1	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	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	-	1	-	2063440-1	AIR FEED MODULE	238
-	-	-	1	1	-	-	4-1722335-3	STRIPPER, SIDE FEED	182
-	-	-	1	1	-	-	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	181
-	-	-	1	1	-	-	1-1752354-7	STANDOFF,HOLD-DOWN	180
-	-	-	1	1	-	-	993111-1	PIN, SLOTTED SPRING 3.0 X 20.0	177
-	-	-	1	1	-	-	5-22280-0	SPRING, COMPRESSION	176
-	-	-	1	1	-	-	1752353-3	GUIDE PIN,HOLDDOWN	175
-	-	-	1	1	-	-	1901680-2	GUIDE PIN,HOLDDOWN	174
-	2	-	2	-	2	-	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172
-	REF	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	1	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113
-	1	1	1	1	1	1	2844908-1	SCREW, LOCKING	99
-	1	1	1	1	1	1	2844907-1	POST, LOCKING	98
-	1	1	1	1	1	1	455888-6	SPACER, CRIMPER	82
-	1	1	1	1	1	1	1803607-1	DOCUMENTATION PACKAGE	71
-	1	1	1	1	1	1	2119740-1	TAG,IDENTIFICATION	67
-	2	2	2	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	1	1	1	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	60
-	1	1	1	1	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	1	1	1	1	1	1	985575-3	SCR, FLT SKT HD CAP M3 X 10.0	57
-	1	1	1	1	1	1	1338685-1	PAWL, FEED	56
-	4	4	4	4	4	4	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	54
-	2	2	2	2	2	2	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	53
-	1	1	1	1	1	1	5018030-1	NUT, HEX, REG, RoHS, M3	52
-	1	1	1	1	1	1	811242-5	BUMPER, HOLD DOWN	51
-	1	1	1	1	1	1	690753-2	SPACER, TONKER	50
-	1	2	1	2	1	2	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	-	1	-	1	-	1	2119652-1	FEED CAM, PRE FEED	48
-	-	1	-	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	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
-	1	1	1	1	1	1	1752356-1	SUPPORT, TERMINAL	34
-	2	2	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	2	2	2	2	2-2844962-0	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	1	1	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29
-	1	1	1	1	1	1	1-455888-0	SPACER, CRIMPER	28
-	1	1	1	1	1	1	1320928-5	STRIP GUIDE	24
-	1	1	-	-	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
-	2	2	1	1	2	2	1-18028-2	WASHER, FLAT, REG M4	20
-	1	1	-	-	1	1	2119533-1	STRIPPER, SIDE FEED	19
-	1	1	1	1	1	1	2119806-1	INSERT, SHEAR	13
-	1	1	1	1	1	1	3-22280-3	SPRING, COMPRESSION	12
-	1	1	1	1	1	1	1-356885-4	STOP, SHEAR	11
-	1	1	1	1	1	1	2119805-1	SHEAR HOLDER, FRONT	10
-	1	1	1	1	1	1	1803095-1	FLOATING SHEAR, FRONT -	9
1	2	2	1	1	1	1	4-1803249-1	ANVIL, COMBINATION	8
-	1	1	1	1	1	1	7-240641-2	SPACER	7
-	-	-	-	-	-	-	-	-	6
-	1	1	1	1	1	1	2-2119781-4	DEPRESSOR, SHEAR	5
-	1	1	1	1	1	1	238011-4	BLOCK, CRIMPER SPACER	4
1	2	2	1	1	1	1	6-1633965-9	CRIMPER, INSULATION O PREMIUM	3
-	1	1	1	1	1	1	1-455888-5	SPACER, CRIMPER	2
1	2	2	1	1	1	1	4-1803241-6	CRIMPER, WIRE F	1

-77-72-71-52-51-2-1			PART NO		DESCRIPTION			ITEM NO	
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DIMENSIONS: mm 			TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.1 1 PLC ±.1 2 PLC ±.1 3 PLC ±.1 4 PLC ±.1 ANGLES ±.1		OWN B. WEAVER 02JUN2016	 TE Connectivity Harrisburg, PA 17105-3608			
					CMR C. TOPPER 02JUN2016				
					APVD C. TOPPER 02JUN2016				
					NAME				
					PRODUCT SPEC				
					SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO	
MATERIAL			FINISH		WEIGHT	A1	00779	C=2836334	-
Customer Accessible Production Drawing						SCALE	1:2	SHEET 1 OF 4	REV B

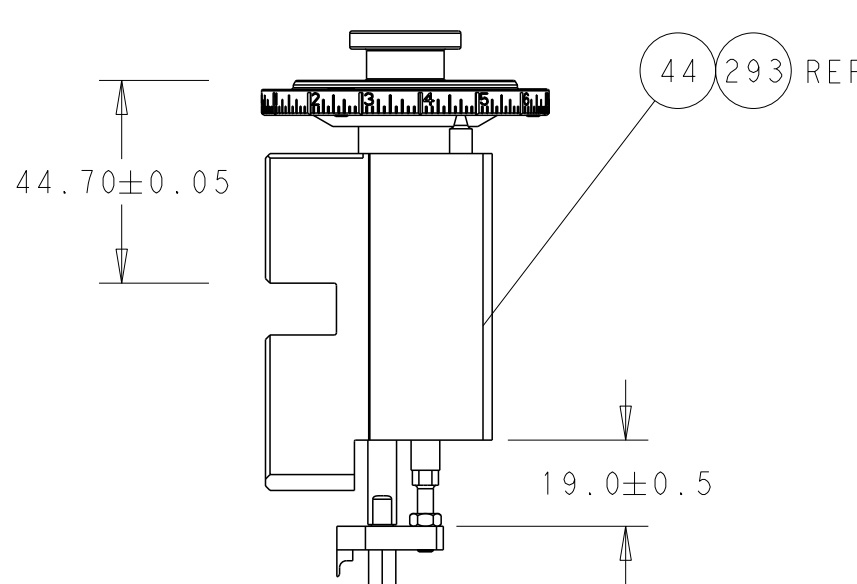
PNEUMATIC



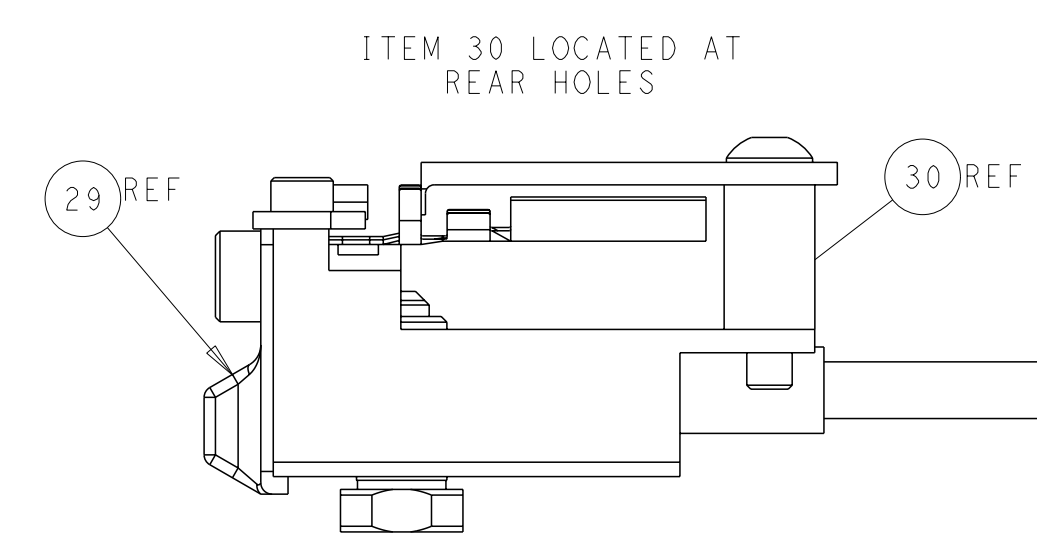
SHEAR DEPRESSOR DETAIL



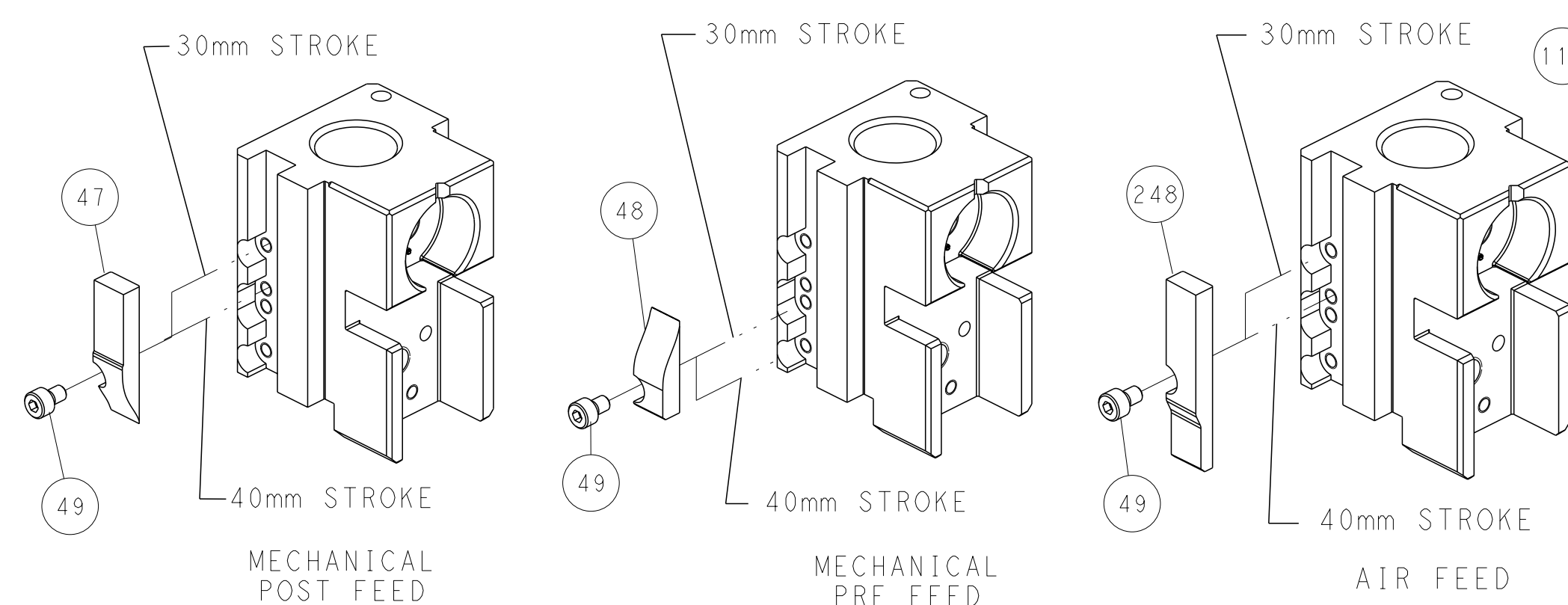
TERMINAL SUPPORT LOCATION



RAM AND HOLDDOWN SET-UP



FEED TRACK POSITION GUIDE BY INSULATION BARREL

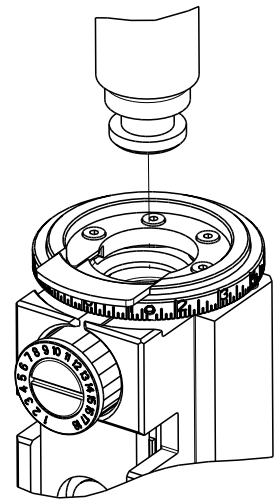


Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

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DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		NAME	

8		7	
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2016		2016	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2836334-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2836334-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2836334-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.93 mm [.076]	F
INSUL	4.00 mm [.157]	O
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: DELPHI TERMINAL				DELPHI CRIMP SPECIFICATION	
TERMINAL NAME: TAXI TERM M M/P 150 SEALED					
WIRE STRIP LENGTH			INSULATION DIAMETER RANGE		
4.94-5.70 mm [.194-.224 IN]			Ø -		
TERMINAL APPLICATION SPECIFICATION		12077628 page 9 of 32 Rev 2014-01-09			
					
TERMINALS APPLIED 					
TE TERMINAL		DELPHI TERMINAL		TE SEAL	DELPHI SEAL
1572275-1		12077628		1572277-2	15324974
1572275-2		15359163		286867-5	15324976
1572275-3		12191888		286867-2	15324973
					SEAL INSULATION DIAMETER RANGE
					Ø 1.29-1.70mm
					Ø 1.60-2.19mm
					Ø 2.03-2.85mm

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.50mm2	1.15+/-0.05 [.045+/-0.002]	6.6
0.35mm2	1.10+/-0.05 [.043+/-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 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 TERMINAL LUBRICANT IS RECOMMENDED.
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)

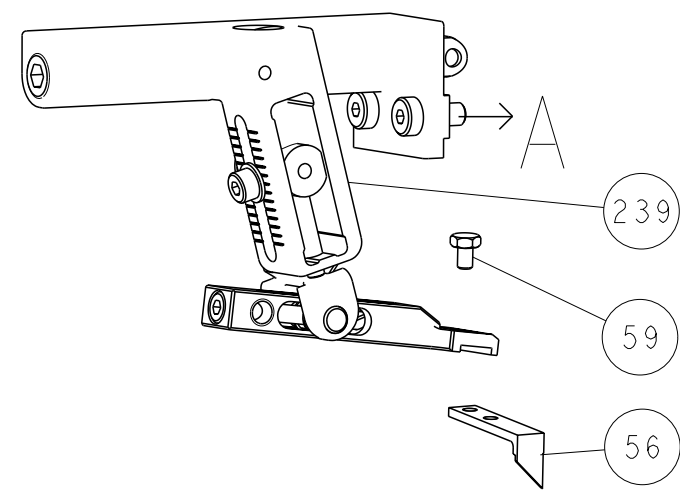
2		1						
LOC	DIST	REVISIONS						
A	66	P	LTR	DESCRIPTION	DATE	DWN	APVD	
		-		SEE SHEET 1	-	-	-	

3	-	1	-	2119640-1	PUSH ROD, AIR FEED	250
	-	1	-	1803259-1	BUSHING, FLANGED	249
	-	1	1	2119082-1	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	2119580-1	MECHANICAL FEED ASSEMBLY	239
	-	1	-	2063440-1	AIR FEED MODULE	238
	-	2	-	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172
	-	REF	REF	994970-2	COUNTER, MAGNETIC	164
6	-	1	-	240638-1	SPRING, FEED FINGER	163
	-	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	1803516-1	RAM ASSEMBLY, SF PACIFIC	140
	-	1	-	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854	137
	-	1	-	2119799-1	HOLDER,FEED FINGER, AF	136
	-	1	1	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113
5	-	1	1	2844908-1	SCREW, LOCKING	99
	-	1	1	2844907-1	POST, LOCKING	98
	-	1	1	455888-6	SPACER, CRIMPER	82
	-	1	1	1803607-1	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	985575-3	SCR, FLT SKT HD CAP M3 X 10.0	57
	-	1	1	1338685-1	PAWL, FEED	56
	-	2	2	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	53
1	-	1	1	5018030-1	NUT, HEX, REG, RoHS, M3	52
	-	1	1	811242-5	BUMPER, HOLD DOWN	51
	-	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	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	2-2844962-0	SPACER, CYLINDRICAL, STRIP GUIDE	30
	-	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29
1	-	1	1	1-455888-0	SPACER, CRIMPER	28
	-	1	1	1320928-5	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	2119805-1	SHEAR HOLDER, FRONT	10
	-	1	1	1803095-1	FLOATING SHEAR, FRONT -	9
1	1	1	1	4-1803249-1	ANVIL, COMBINATION	8
	-	1	1	7-240641-2	SPACER	7
	-	-	-	-	-	6
	-	1	1	2-2119781-4	DEPRESSOR, SHEAR	5
	-	1	1	238011-4	BLOCK, CRIMPER SPACER	4
	1	1	1	6-1633965-9	CRIMPER, INSULATION O PREMIUM	3
	-	1	1	1-455888-5	SPACER, CRIMPER	2
	1	1	1	4-1803241-6	CRIMPER, WIRE F	1
	-77	-22	21	PART NO	DESCRIPTION	ITEM NO

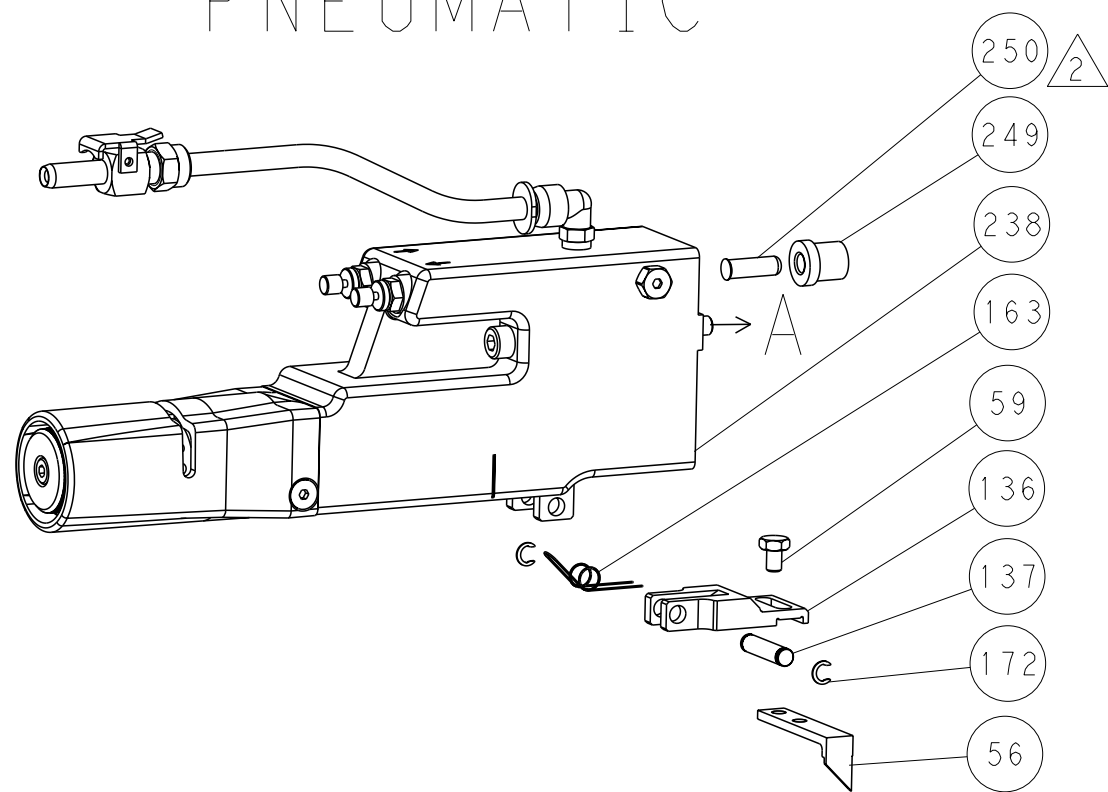
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DIMENSIONS: mm				CHK C. TOPPER 02JUN2016	NAME Ocean Side Feed Applicator	
TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±				APVD C. TOPPER 02JUN2016	PRODUCT SPEC	
MATERIAL -				APPLICATION SPEC		SIZE A1
FINISH -				WEIGHT -		CAGE CODE 00779
Customer Accessible Production Drawing				SCALE 1:2		DRAWING NO C=2836334
SHEET 3 OF 4				RESTRICTED TO -		REV B

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

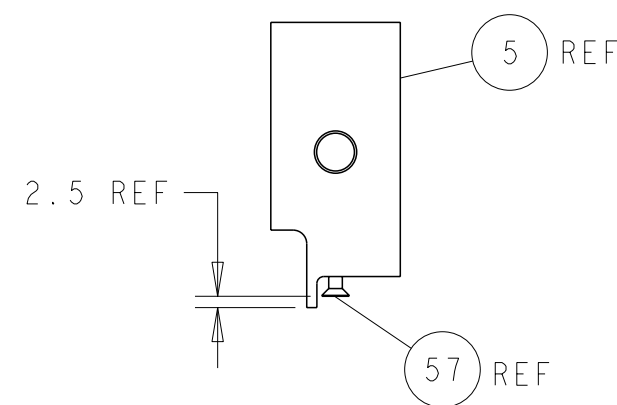
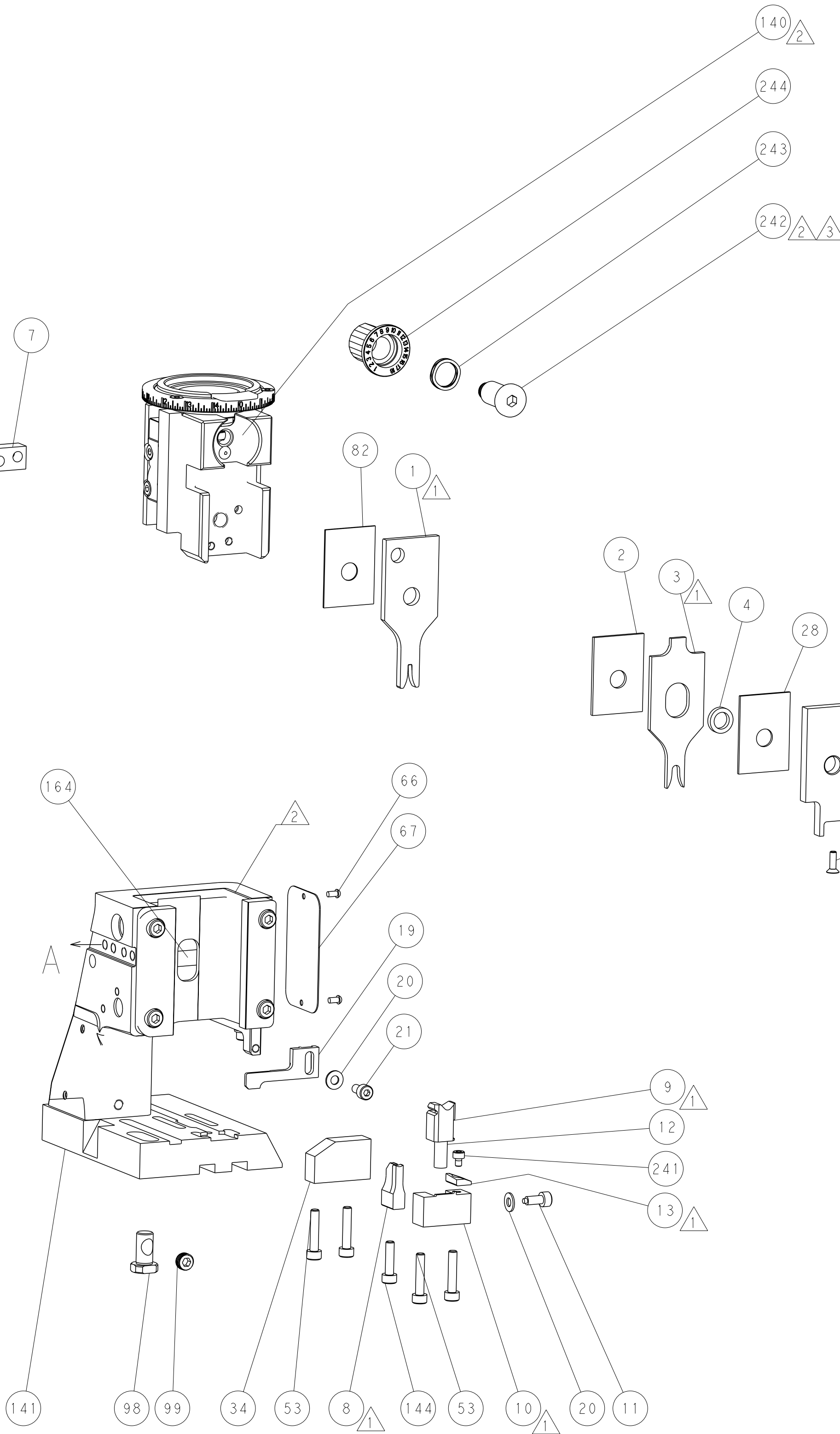
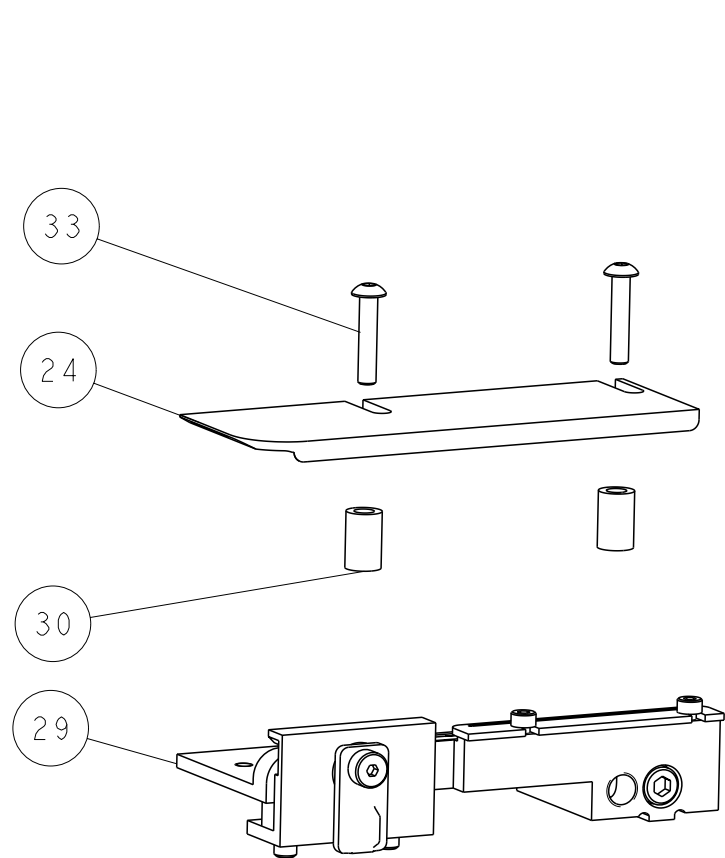
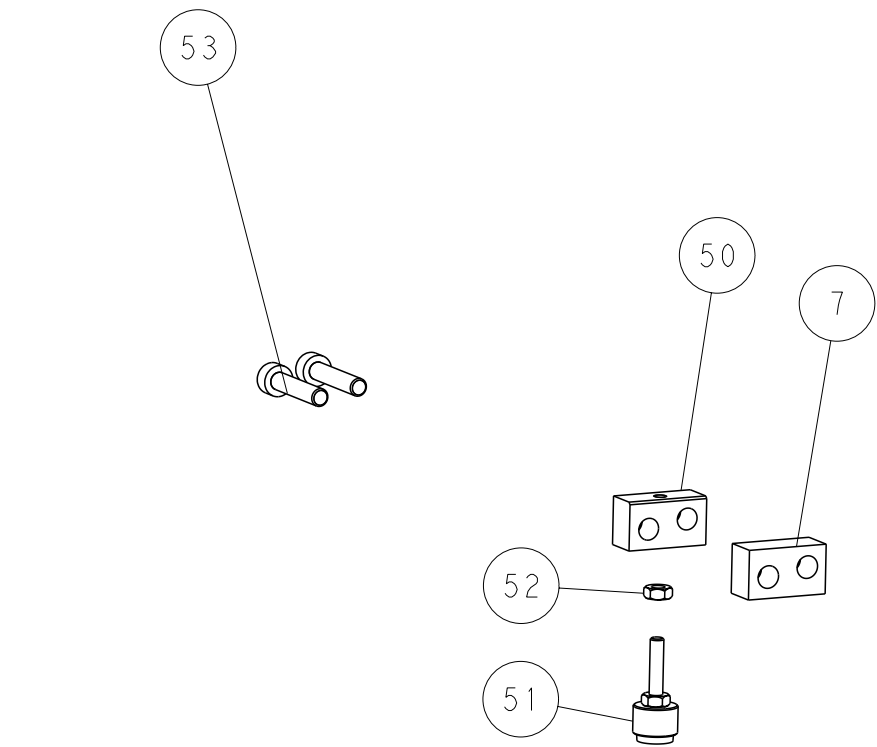
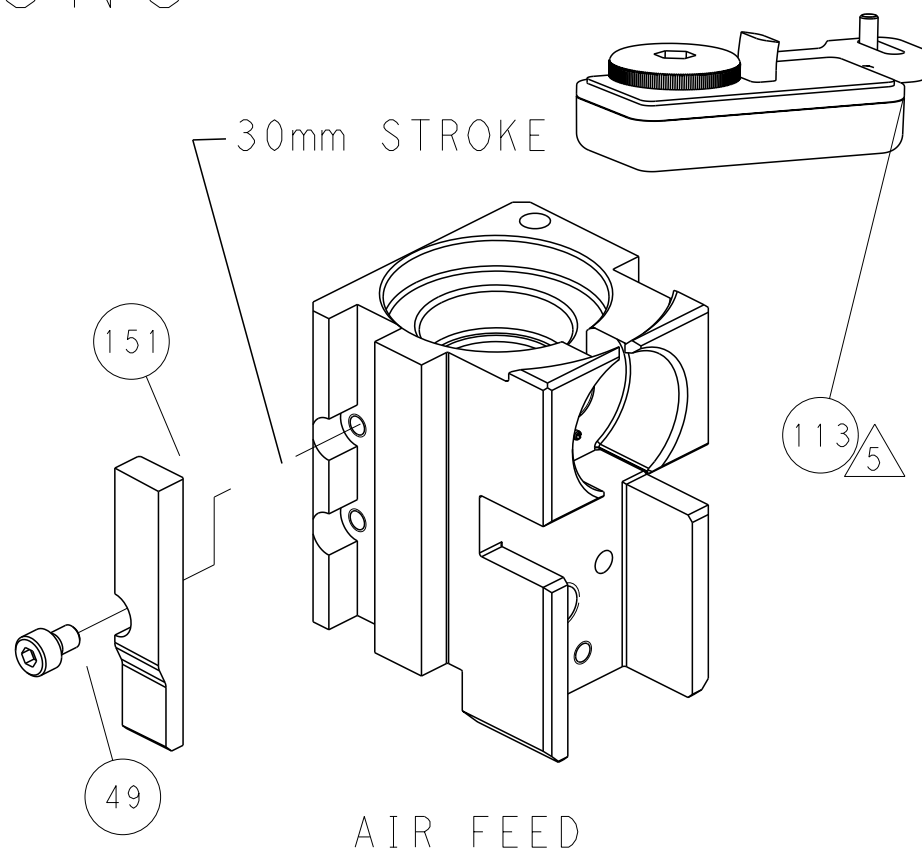
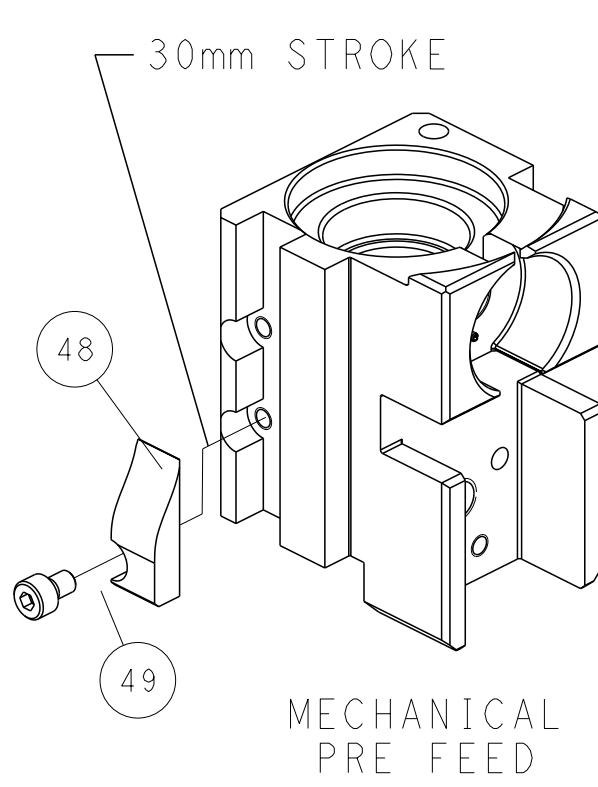
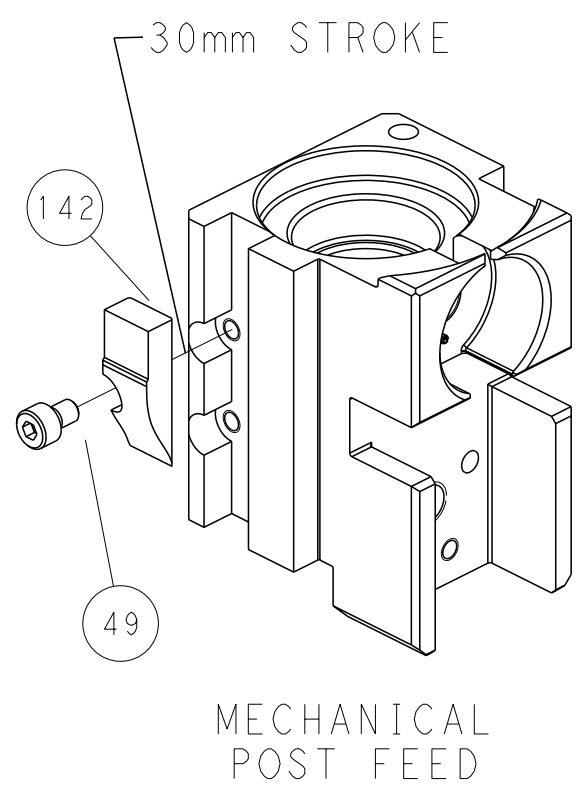
FEED TYPE
MECHANICAL



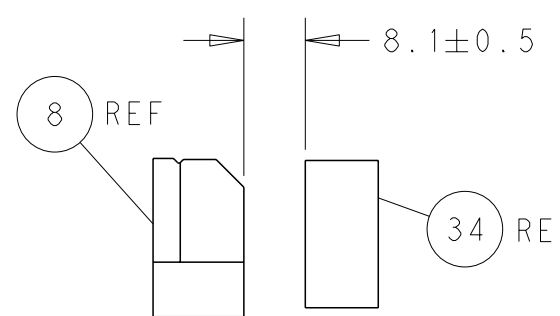
PNEUMATIC



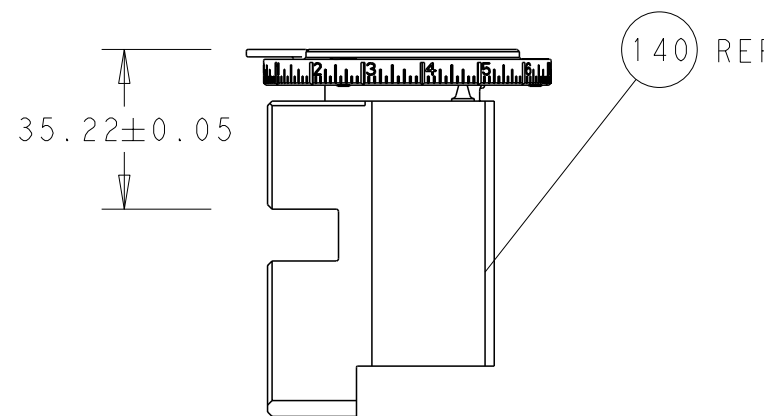
CAM POSITIONS



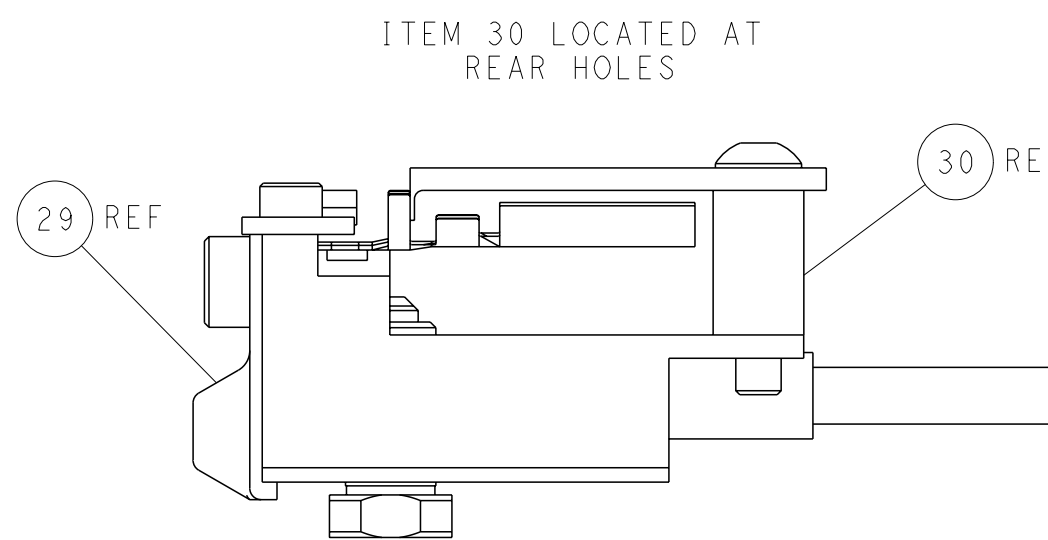
SHEAR DEPRESSOR DETAIL



TERMINAL SUPPORT LOCATION



RAM SET-UP



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 A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE AND TO THE CONTROL AND ENGINEERING DEPARTMENT. ANY CHANGES SHOULD BE CONTACTED FOR THE LATEST REVISION.		OWN B. WEAVER 02JUN2016	TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm		CHK C. TOPPER 02JUN2016	NAME Ocean Side Feed Applicator	
TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH ±		APVD C. TOPPER 02JUN2016	SIZE A1 00779 C=2836334	
MATERIAL -		PRODUCT SPEC -	RESTRICTED TO -	
WEIGHT -		APPLICATION SPEC -	Customer Accessible Production Drawing	
SCALE 1:2		SHEET 4		REV B