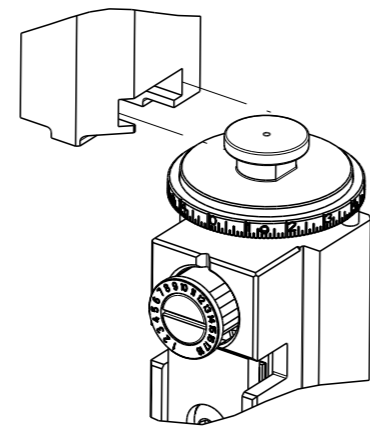


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2836608-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2836608-2	C	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2836608-7	B	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.80 mm [.110]	F
INSUL	3.40 mm [.134]	F

APPLICATOR INSTRUCTIONS 408-35042

TERMINAL DATA: DELPHI TERMINAL DELPHI PACKARD CRIMP SPECIFICATION			
TERMINAL NAME: F 56 TAXI TERMINAL			
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE		
4.43-5.19 mm [.174-.204 IN]	Ø1.60-2.40 mm [.063-.094 IN]		
TERMINAL APPLICATION SPECIFICATION	(A)02965510 PAGE 1 OF 2 Rev 2013-10-29		
TERMINALS APPLIED 5/6			
TE TERMINAL	DELPHI TERMINAL	TE TERMINAL	DELPHI TERMINAL
(A) 1572983-1	(A) 02965510	(A) 1572127-1	(A) 02965141
(A) 1572127-2	(A) 02962572	(A) 1572127-3	(A) 02962508
(A) 1572127-4	(A) 02965401		

TERMINAL DATA: DELPHI TERMINAL DELPHI PACKARD CRIMP SPECIFICATION			
TERMINAL NAME: F 56 TAXI TERMINAL			
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE		
4.43-5.19 mm [.174-.204 IN]	Ø1.60-2.40 mm [.063-.094 IN]		
TERMINAL APPLICATION SPECIFICATION	(B)NONE		
TERMINALS APPLIED 5/6			
TE TERMINAL	DELPHI TERMINAL	TE TERMINAL	DELPHI TERMINAL
(B) 1572983-1	(B) 02965510	(B) 1572127-1	(B) 02965141
(B) 1572127-2	(B) 02962572	(B) 1572127-3	(B) 02962508
(B) 1572127-4	(B) 02965401		

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TERMINAL APPLICATION SPECIFICATION	(A)02965510 PAGE 1 OF 2 Rev 2013-10-29		
TERMINALS APPLIED 5/6			
TE TERMINAL	DELPHI TERMINAL	TE TERMINAL	DELPHI TERMINAL
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(A) 1572127-2	(A) 02962572	(A) 1572127-3	(A) 02962508
(A) 1572127-4	(A) 02965401		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.00mm2	1.50+/-0.05 [.059+/- .002]	3.8
0.80mm2	1.45+/-0.05 [.057+/- .002]	4.5

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.75mm2	1.44+/-0.05 [.057+/- .002]	4.7

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.50mm2	1.45+/-0.05 [.057+/- .002]	4.2

- 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. THE CUSTOMER ACKNOWLEDGES THAT THE TERMINAL MANUFACTURER'S CRIMP SPECIFICATIONS ARE UNKNOWN. IN ADDITION THE CUSTOMER ACKNOWLEDGES THAT TE CONNECTIVITY HAS CALCULATED CRIMP SPECIFICATIONS FOR THIS PRODUCT THAT MAY NOT MATCH THE TERMINAL MANUFACTURER'S SPECIFICATIONS. TE CONNECTIVITY USES ACCEPTED PRACTICES TO DESIGN TERMINATION TOOLING FOR NON-TE CONNECTIVITY PRODUCTS. HOWEVER, **TE CONNECTIVITY EXPRESSLY DISCLAIMS ANY AND ALL WARRANTIES THAT THE TOOLING WILL RELIABLY APPLY NON-TE CONNECTIVITY PRODUCTS, INCLUDING BUT NOT LIMITED TO IMPLIED WARRANTIES OF MERCHANTABILITY OR FITNESS FOR PARTICULAR PURPOSE. THE CUSTOMER ASSUMES ALL RESPONSIBILITY AND LIABILITY FOR THE PERFORMANCE OF TERMINATED ASSEMBLIES USING SUCH TOOLING.** THE CUSTOMER EXPRESSLY INDEMNIFIES TE CONNECTIVITY AND SHALL HOLD TE CONNECTIVITY HARMLESS FROM ALL CLAIMS, DEMANDS, LOSSES, EXPENSES AND LIABILITIES RESULTING FROM THE USE OF THIS TOOLING ON NON-TE CONNECTIVITY PRODUCTS.
- 8. THIS CRIMP PARAMETER IS PROVIDED TO MEET A CUSTOM AND UNIQUE CUSTOMER REQUIREMENT. IT HAS BEEN EVALUATED AND IS CONDITIONALLY SPECIFIED BY TE CONNECTIVITY. THIS CUSTOMIZED CRIMP PARAMETER IS NOT LISTED AS AN APPROVED APPLICATION WITHIN THE TERMINAL MANUFACTURER'S SPECIFICATIONS. **TE CONNECTIVITY EXPRESSLY DISCLAIMS ANY AND ALL WARRANTIES THAT THE PRODUCT WILL PERFORM SIMILARLY TO VALIDATED AND APPROVED APPLICATIONS, AS STATED WITHIN THE MANUFACTURER'S APPLICATION SPECIFICATIONS, INCLUDING BUT NOT LIMITED TO IMPLIED WARRANTIES OF MERCHANTABILITY OR FITNESS FOR PARTICULAR PURPOSE.** AS SUCH, IT IS HIGHLY RECOMMENDED THAT THE CUSTOMER PERFORM FURTHER DETAILED EVALUATION TO ASSESS PRODUCT PERFORMANCE IN THE SPECIFIC APPLICATION AND OBTAIN APPROVAL FROM TERMINAL MANUFACTURER FOR THIS CUSTOM REQUIREMENT.
- 9. 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	REV	DATE	OWN	APVD
		A	RELEASED	05MAY2017	TB GB
		B	ECR-19-002805	21FEB2019	JAH TE
		C	ECR-19-009781	24JUN2019	FJ TE
		C1	ECR-21-000418	13JAN2021	JAH RK

-	1	1	2119641-1	FEED CAM, AIR FEED	248	
-	1	1	2119082-5	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	2844940-1	AIR FEED MODULE	238	
-	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	237	
-	1	1	1-18028-0	WASHER, FLAT, REG M8	192	
-	REF	REF	994970-2	COUNTER, MAGNETIC	164	
-	1	1	1-22281-8	SPRING, COMPRESSION	121	
-	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	1-693855-0	FRONT STRIP GUIDE	96	
-	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	95	
-	1	1	2168083-6	SCR, SKT HD CAP, RoHS, M5 X 65	93	
-	2	2	1-2168083-3	SCR, SKT HD CAP, RoHS, M3 X 16	85	
-	1	1	455888-4	SPACER, CRIMPER	82	
-	1	1	6-240641-2	SPACER	81	
-	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	
-	2	2	2-18032-5	SCR, SET, FLT PNT, M5 X 20.0	61	
-	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	1338683-1	FEED PAWL	56	
-	2	2	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	54	
-	2	2	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	53	
-	1	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49	
-	1	1	1803583-9	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	3-2305692-0	PLATE, REAR STRIP GUIDE	29	
-	2	2	22281-8	SPRING, COMPRESSION	27	
-	1	1	356835-1	LEVER, DRAG RELEASE	26	
-	1	1	1673009-1	DRAG, TERMINAL	25	
-	1	1	4-189124-3	GUIDE, FRONT STRIP	24	
-	1	1	980371-4	SCR, SKT HD SHLDR 5.0 DIA X 6.0	23	
-	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21	
-	1	1	1-18028-2	WASHER, FLAT, REG M4	20	
-	1	1	2119533-1	STRIPPER, SIDE FEED	19	
-	1	1	1673257-7	SHEAR, FLOATING	17	
-	2	2	1-2168083-1	SCR, SKT HD CAP, RoHS, M3 X 6	16	
-	1	1	1673256-7	PLATE, REAR SHEAR	15	
-	1	1	1673255-3	HOLDER, REAR SHEAR	14	
-	1	1	3-22280-3	SPRING, COMPRESSION	12	
-	-	-	-	-	10	
-	-	-	-	-	9	
-	1	2	1	8-1633928-0	ANVIL, COMBINATION	8
-	-	-	-	-	7	
-	1	1	1	1-690468-7	DEPRESSOR SHEAR, REAR	6
-	-	-	-	-	5	
-	1	1	1	3-238011-1	BLOCK, CRIMPER SPACER	4
-	1	2	1	1-1803384-4	CRIMPER, INSULATION F	3
-	1	1	1	1-455888-1	SPACER, CRIMPER	2
-	1	2	1	456408-8	CRIMPER, WIRE PREMIUM	1
-	77	-72	-2	PART NO	DESCRIPTION	ITEM NO

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

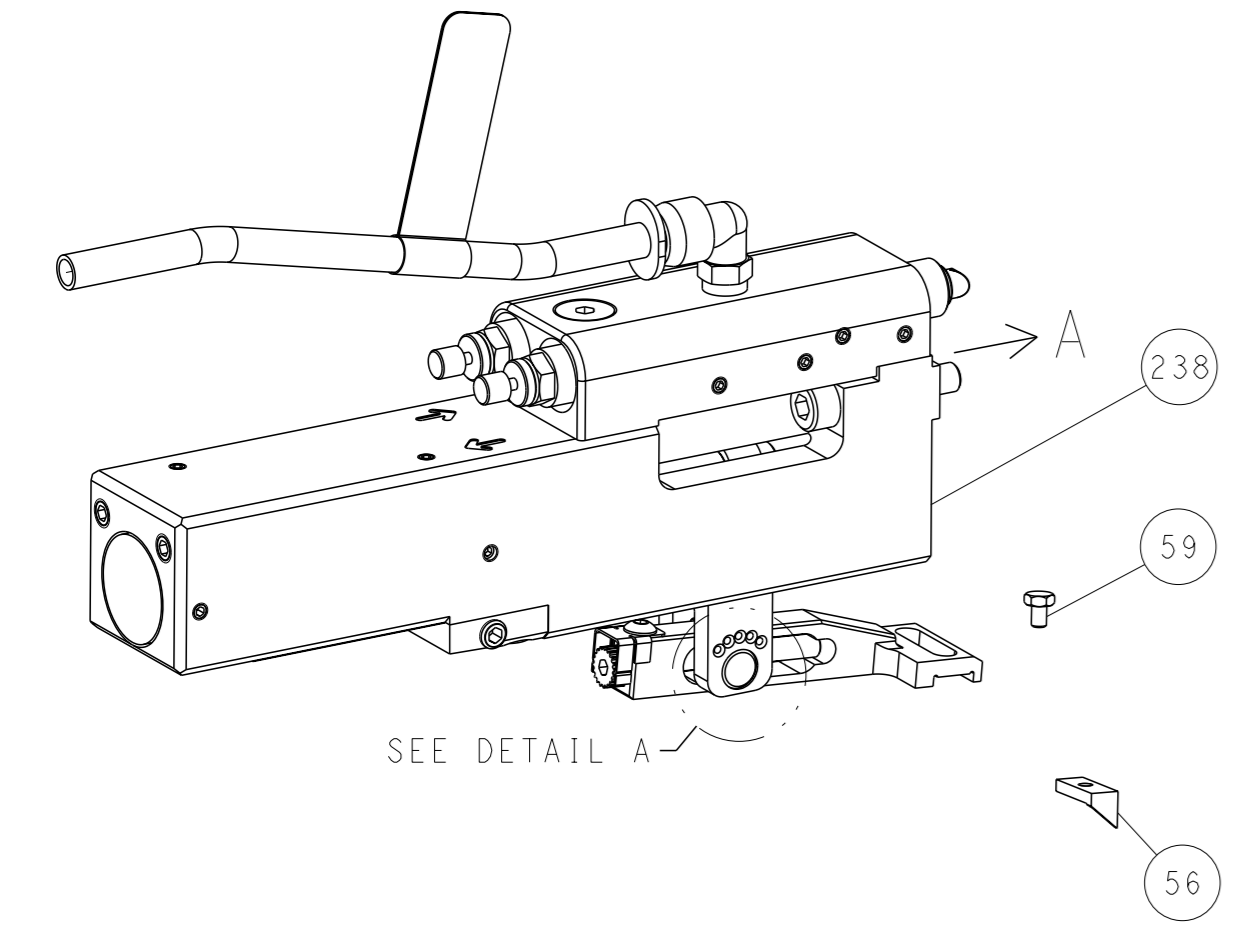
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mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±
	ANGLES	FINISH			

OWN	M. HERR	10MAR2917
CHK	T. ELBIN	10MAR2917
APVD	T. ELBIN	10MAR2917
PRODUCT SPEC		
APPLICATION SPEC		
WEIGHT		
SIZE	CAGE CODE	DRAWING NO
A1	00779	2836608
Customer Accessible Production Drawing		SCALE 1:2 SHEET 1 of 4 REV C1

LOC	DIST	REVISIONS			
A	66	REV	DATE	OWN	APVD
		1	SEE SHEET 1		

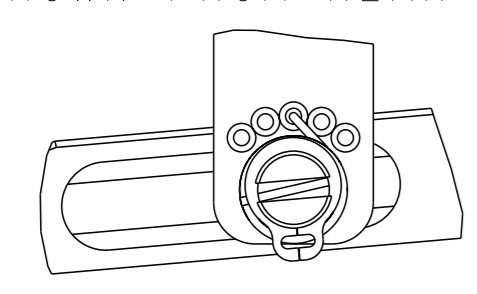
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PNEUMATIC



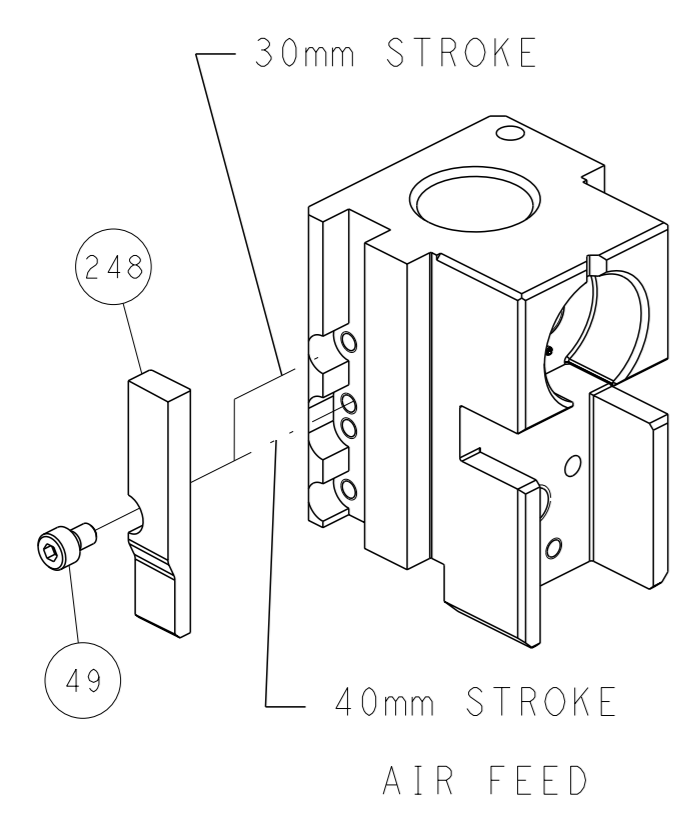
SEE DETAIL A

FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)

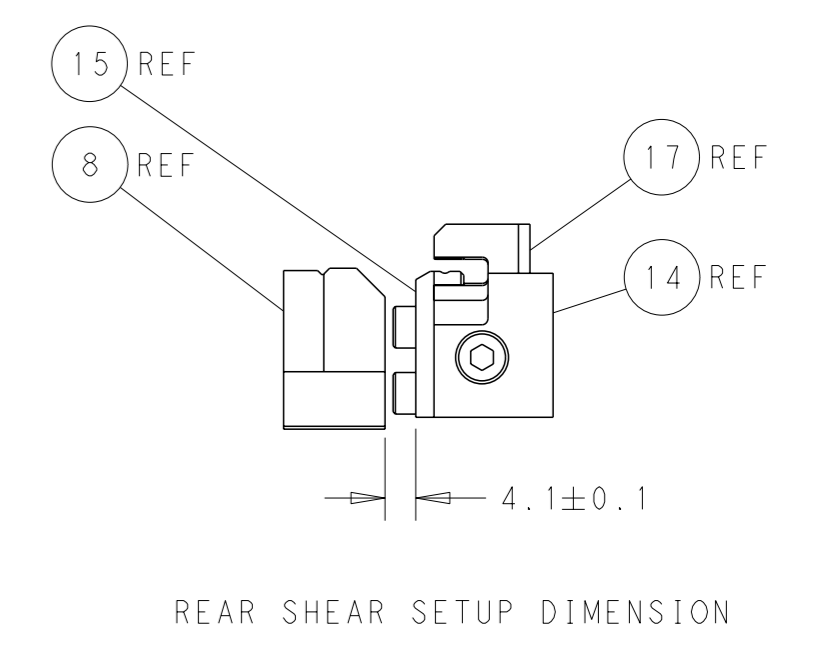
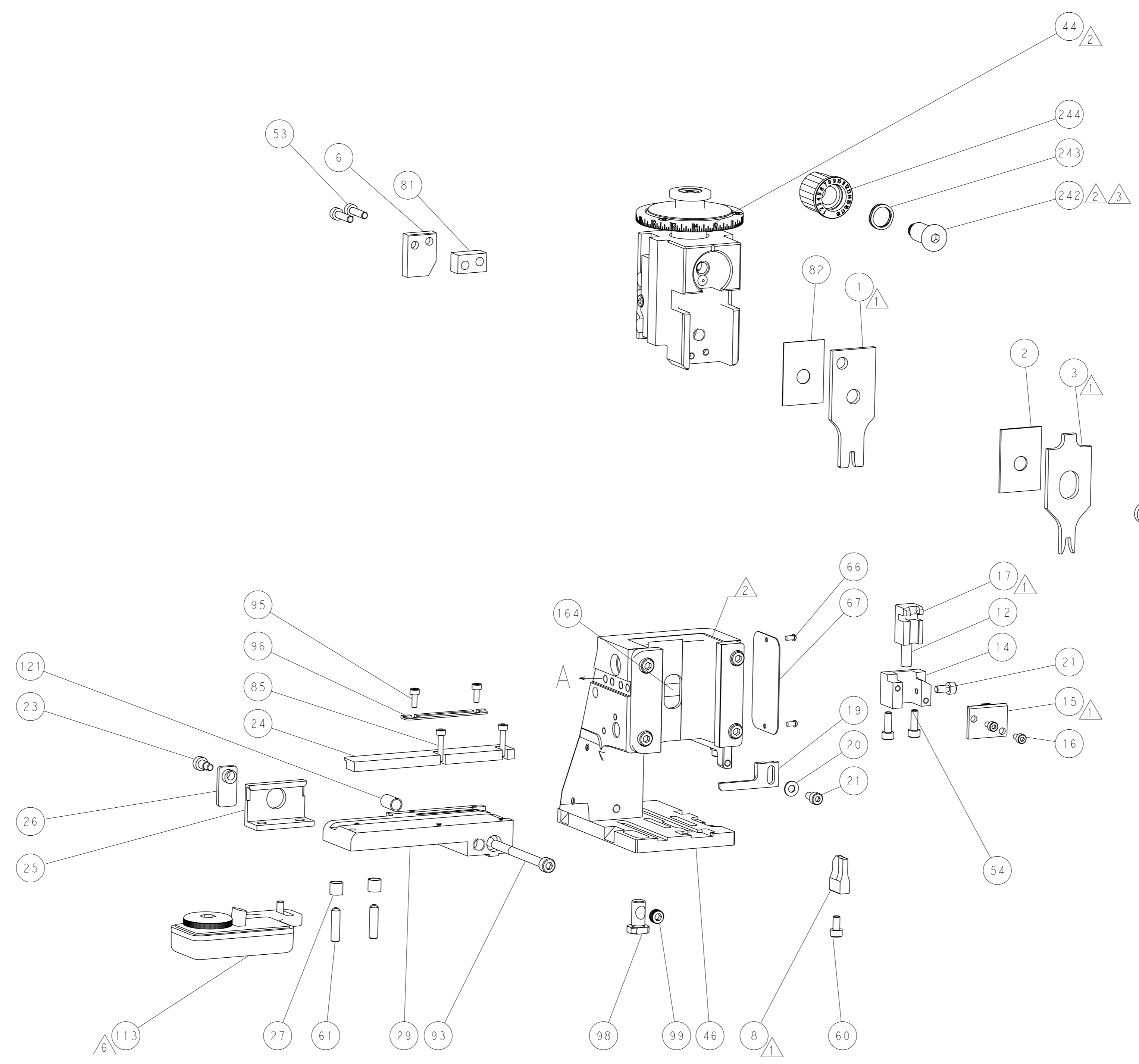


DETAIL A

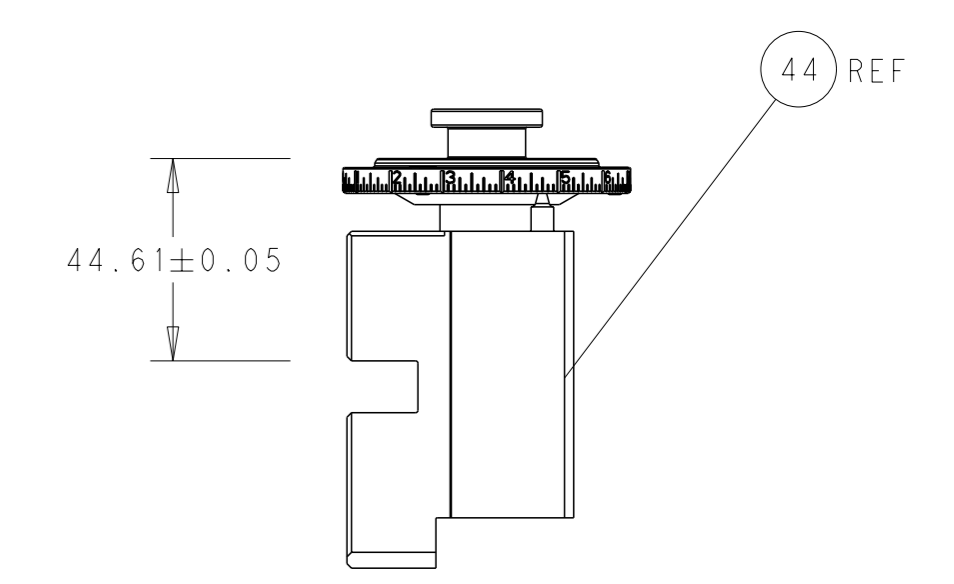
CAM POSITION



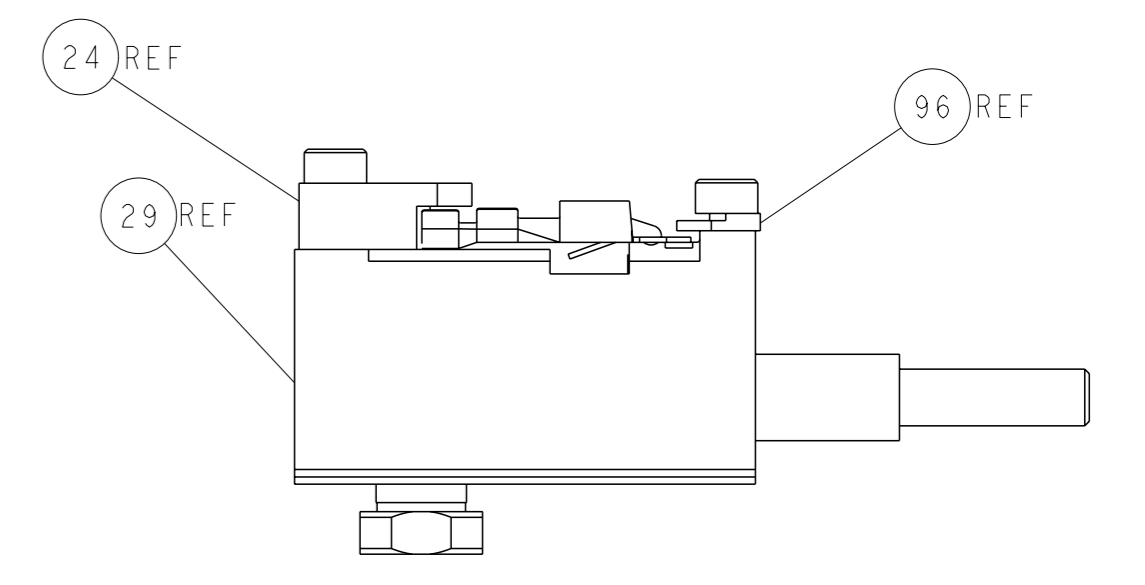
AIR FEED



REAR SHEAR SETUP DIMENSION



RAM SET-UP



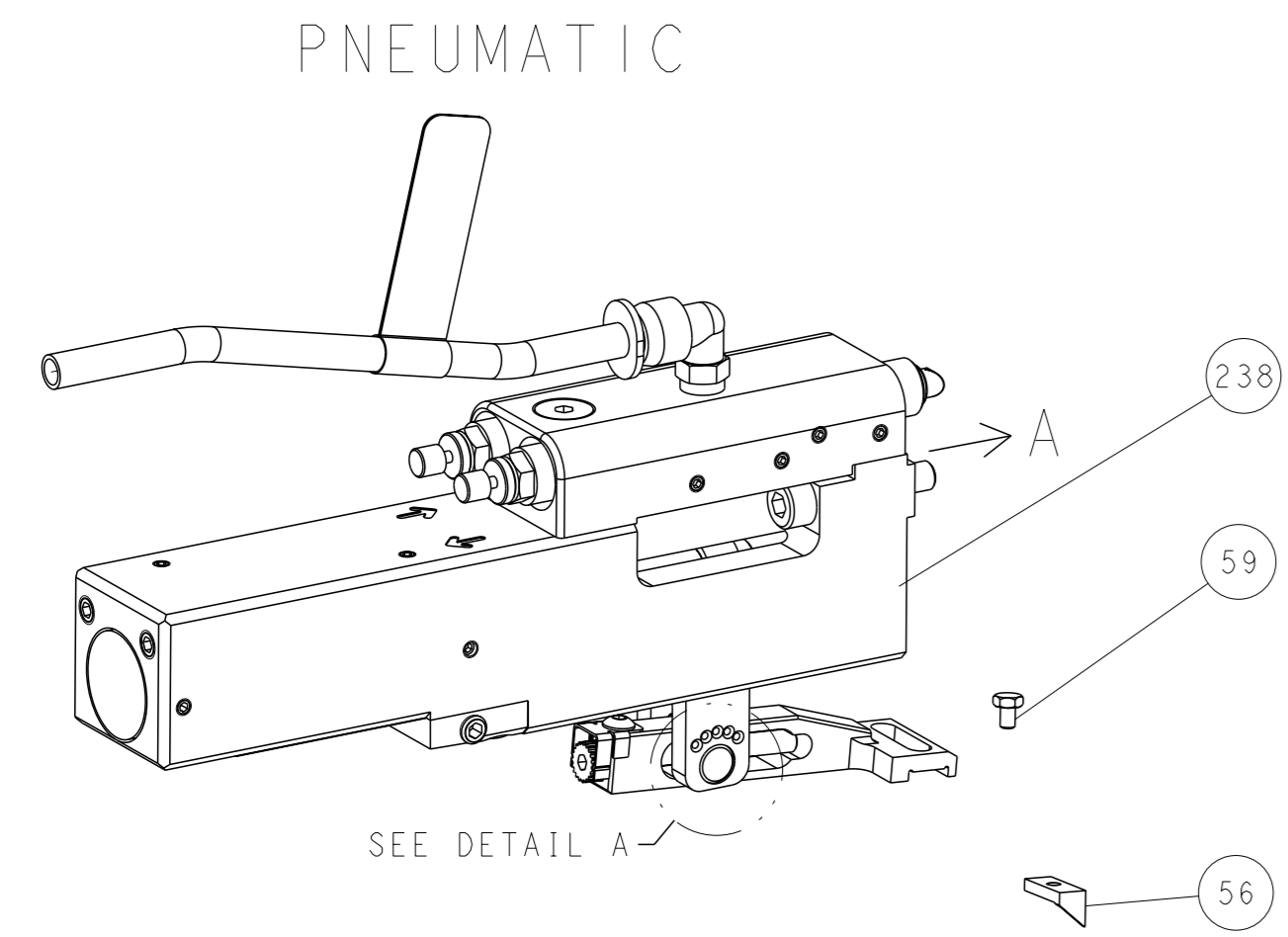
FEED TRACK POSITION GUIDE AS SHOWN

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

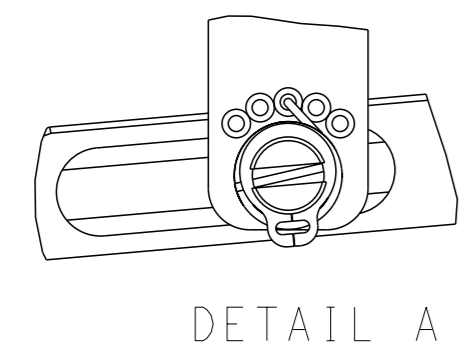
<small>THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE AND TO CONTROLING ENGINEERING DISCRETION SHOULD BE CONTACTED FOR THE LATEST REVISION.</small>		OWN: M. HERR CHK: T. ELBIN APVD: T. ELBIN	10MAR2917 10MAR2917 10MAR2917	TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH *		NAME: Ocean Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2836608 RESTRICTED TO:		
MATERIAL:		WEIGHT: - SCALE: 1:2 SHEET: 2 of 4 REV: C1		

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

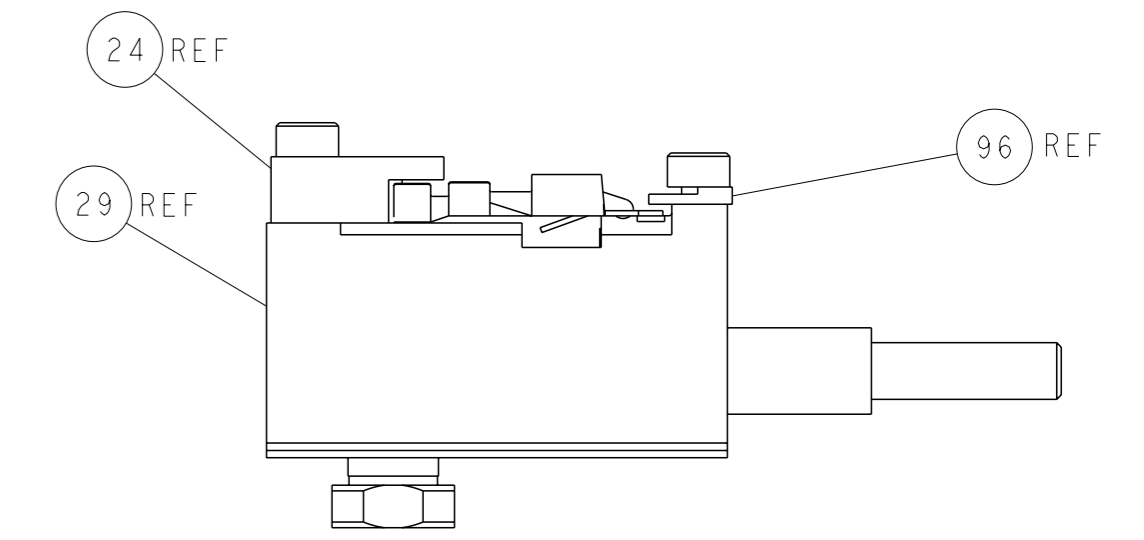
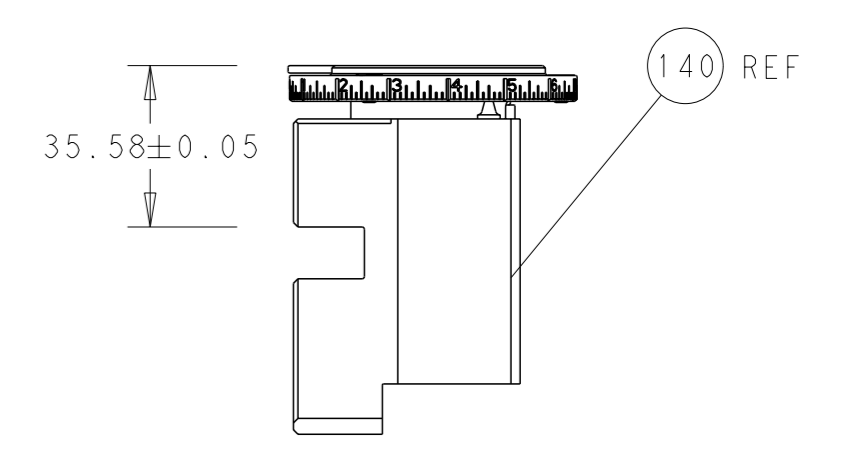
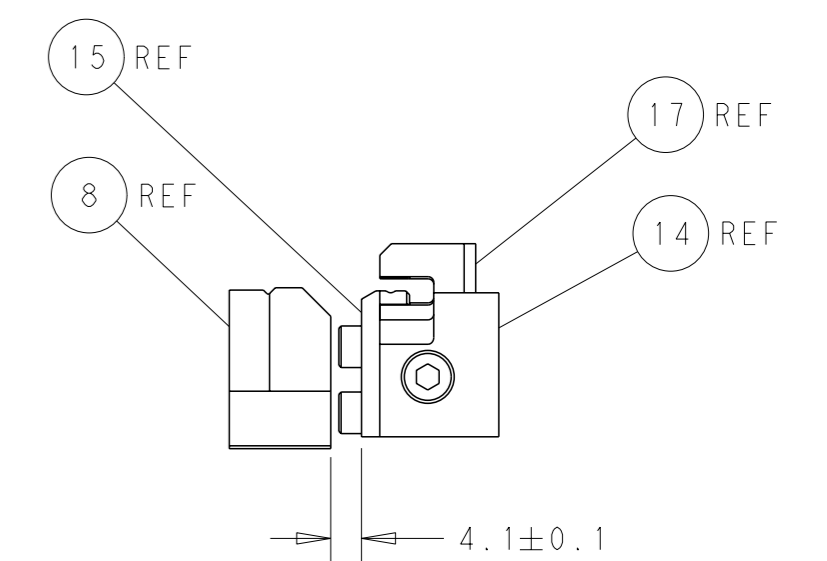
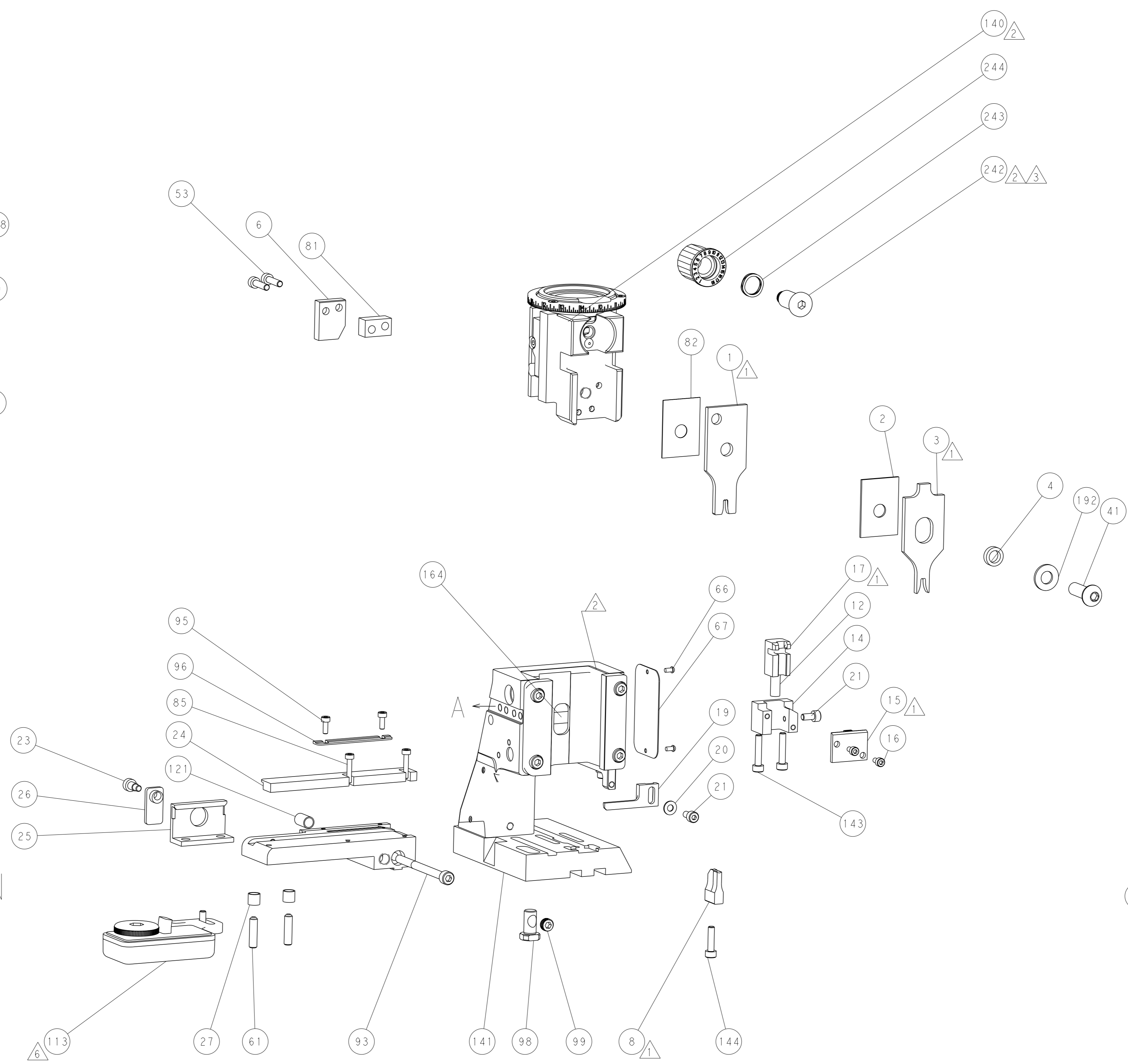
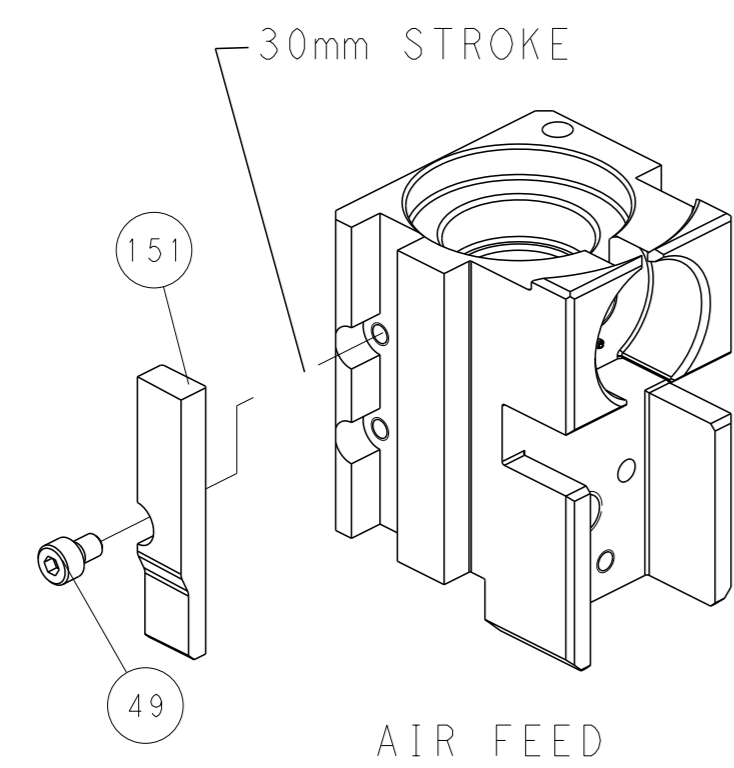
FEED TYPE



FEED SPRING SETTING POSITION
(SHOWN FROM REAR SIDE)



CAM POSITION



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 A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE AND THE CONTROLLER'S ENGINEERING DEPARTMENT SHOULD BE CONTACTED FOR THE LATEST REVISION.</small>		OWN: HERR 10MAR2917 CHK: T. ELBIN 10MAR2917 APVD: T. ELBIN 10MAR2917	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 Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2836608 WEIGHT: - SCALE: 1:2 SHEET: 4 of 4 REV: C1	RESTRICTED TO: -
MATERIAL: -		Customer Accessible Production Drawing	