

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2837173-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2837173-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2837173-1	B	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2837173-2	B	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2837173-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.79 mm [.110]	F
INSUL	3.18 mm [.125]	O

APPLICATOR INSTRUCTIONS 408-35042

TERMINAL DATA: DELPHI TERMINAL DELPHI PACKARD CRIMP SPECIFICATION			
TERMINAL NAME: TAXI ASM TERM F HES 1.6			
WIRE STRIP LENGTH		TERMINAL INSULATION DIAMETER RANGE	
4.43-5.19 mm [.174-.204 IN]		∅2.45-3.25 mm [.096-.128 IN]	
TERMINAL APPLICATION SPECIFICATION	(A)13697416 CRIMP INFO SHT-Rev 2013-10-30		
	(B)13697410 CRIMP INFO SHT-Rev 2013-10-30		
TERMINALS APPLIED			
TE TERMINAL	DELPHI TERMINAL	TE TERMINAL	DELPHI TERMINAL
(A) 3311130-1	(A) 13697416	(B) 3311131-1	(B) 13697410

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
3.00mm2	1.90+/-0.05 [.075+/- .002]	6.3
2.50mm2	1.85+/-0.05 [.073+/- .002]	6.6
2.00mm2	1.65+/-0.05 [.065+/- .002]	8.5

- 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. 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)

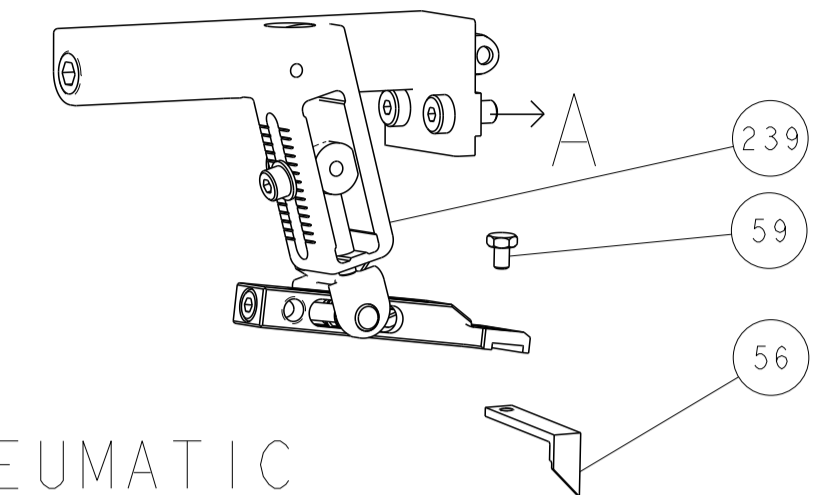
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		P	LTN	DESCRIPTION	DATE	OWN	APVD
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				ECR-22-138291	09MAY2022	JWC	ROY

-	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	455888-6	SPACER, CRIMPER	82	
-	1	1	1	1	1803607-3	DOCUMENTATION PACKAGE	71	
-	1	1	1	1	2119791-9	DEPRESSOR, WIRE	70	
-	1	1	1	1	2119943-1	WASHER, SPACER	69	
-	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	1338683-8	FEED PAWL	56	
-	4	4	4	4	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	54	
-	2	2	2	2	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	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	1803515-1	RAM ASSEMBLY, SF ATLANTIC	44	
-	1	1	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41	
-	1	1	1	1	1-1752356-3	SUPPORT, TERMINAL	34	
-	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33	
-	2	2	2	2	3-2844962-2	SPACER, CYLINDRICAL, STRIP GUIDE	30	
-	1	1	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29	
-	1	1	1	1	455888-3	SPACER, CRIMPER	28	
-	1	1	1	1	1320928-2	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	1803095-1	FLOATING SHEAR, FRONT	9	
-	1	2	2	1	1	4-1633923-5	ANVIL, COMBINATION	8
-	-	-	-	-	-	-	7	
-	-	-	-	-	-	-	6	
-	1	1	1	1	2119757-4	DEPRESSOR, SHEAR	5	
-	1	1	1	1	4-238011-5	BLOCK, CRIMPER SPACER	4	
-	1	2	2	1	1	1803453-6	CRIMPER, INSULATION O	3
-	-	-	-	-	-	-	2	
-	1	2	2	1	1	2-1803454-6	CRIMPER, WIRE	1
-	77	72	71	2	1	PART NO	ITEM NO	

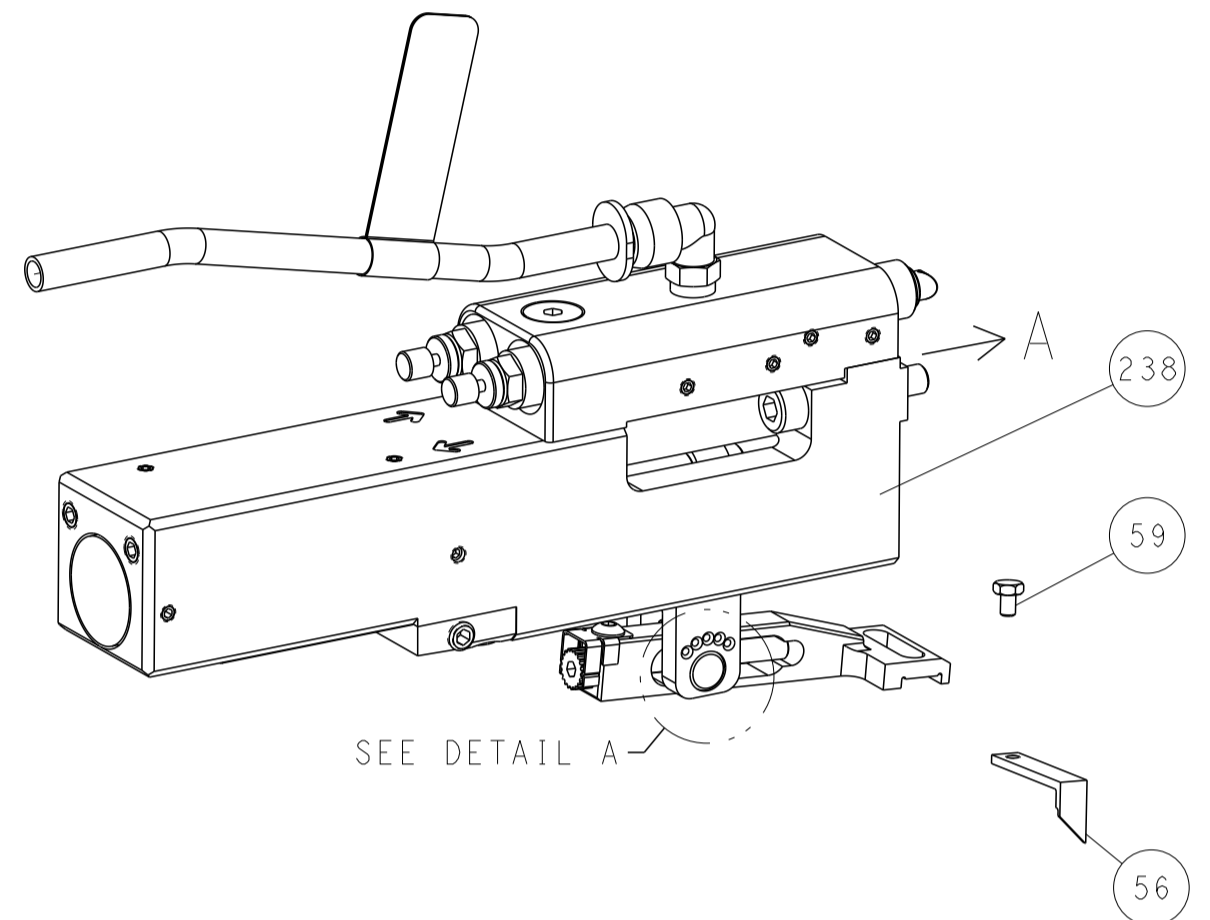
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DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH	NAME Ocean Side Feed Applicator SIZE CAGE CODE DRAWING NO A1 00779 C=2837173 RESTRICTED TO
MATERIAL:		WEIGHT:	Customer Accessible Production Drawing SCALE 1:2 SHEET 1 OF 4 REV B

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

FEED TYPE MECHANICAL



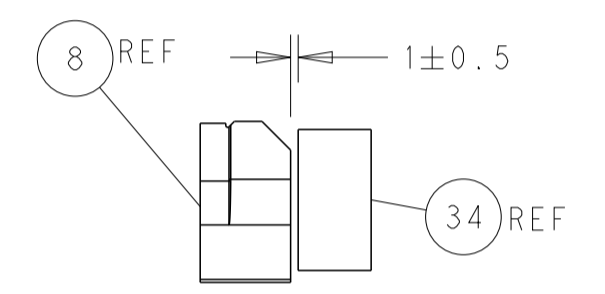
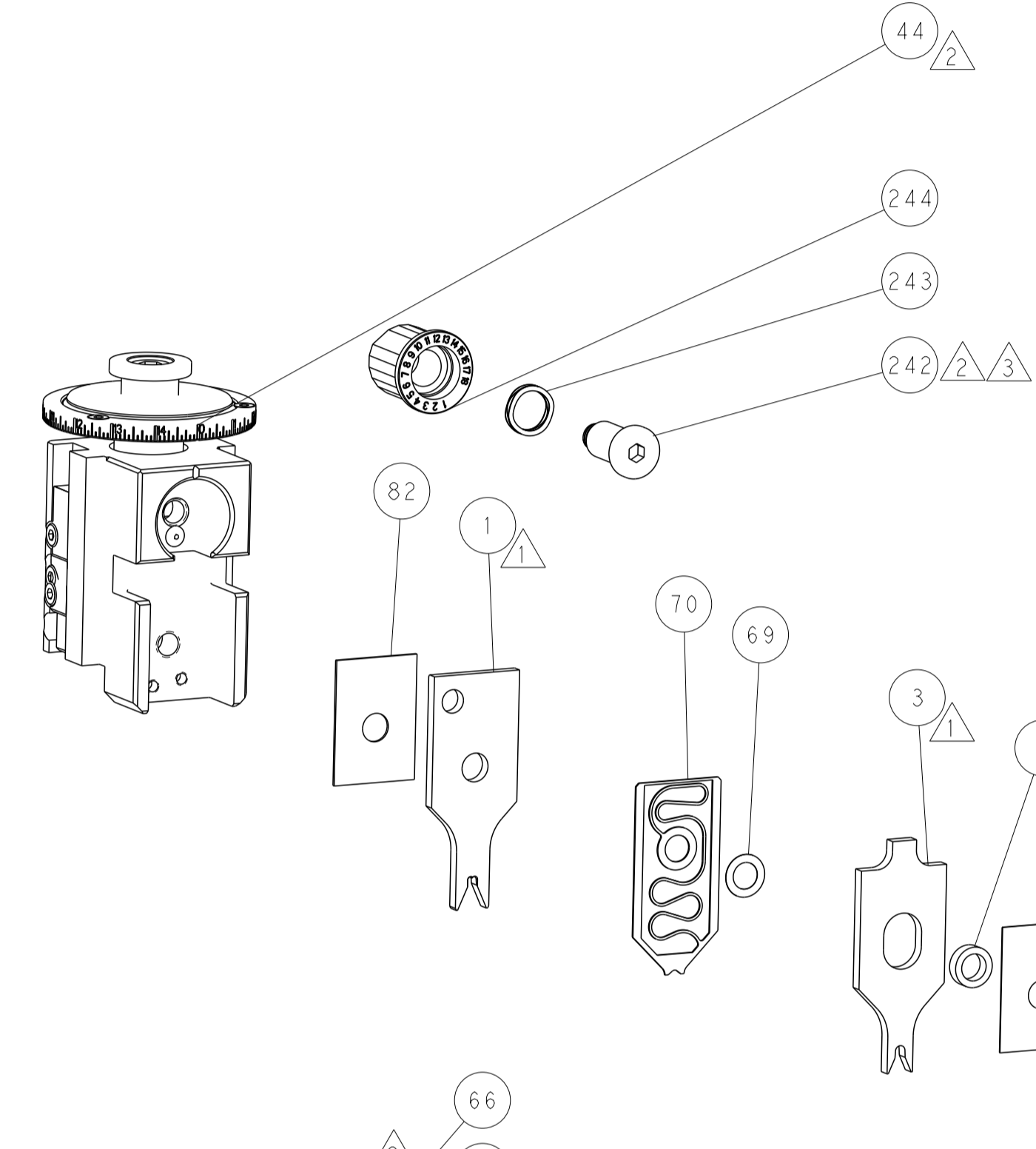
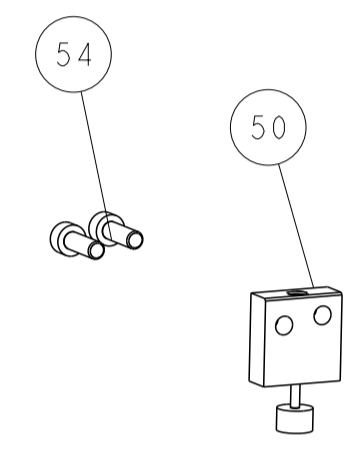
PNEUMATIC



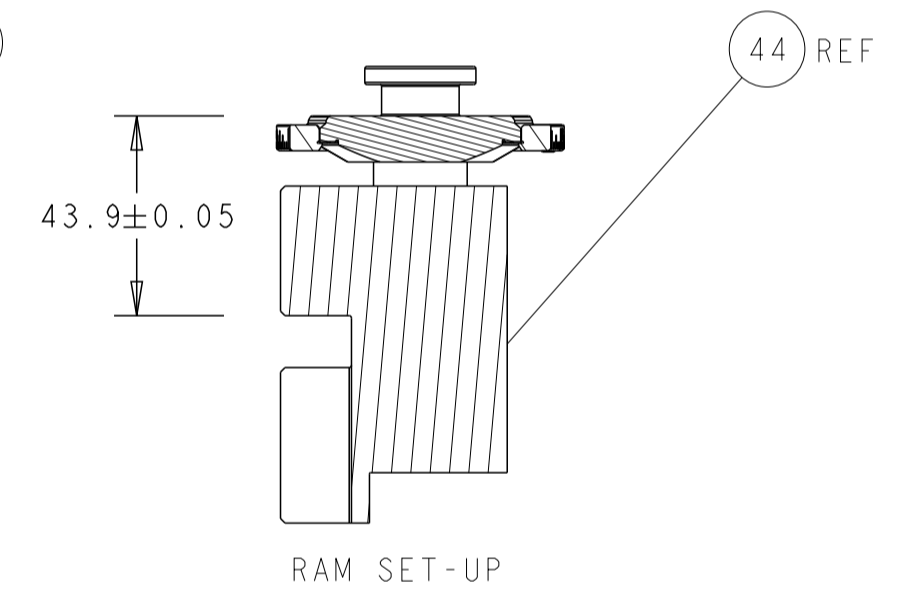
FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



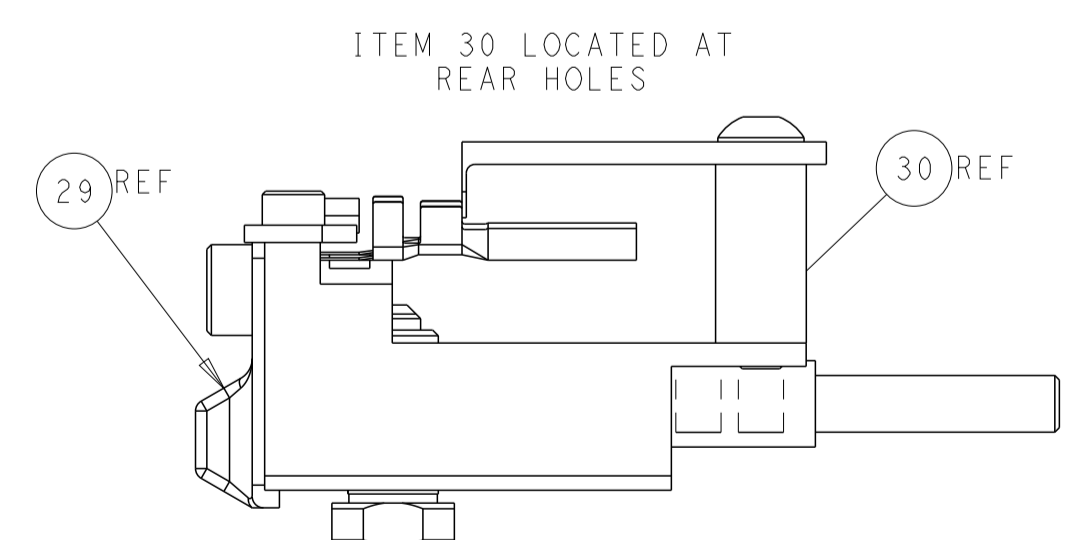
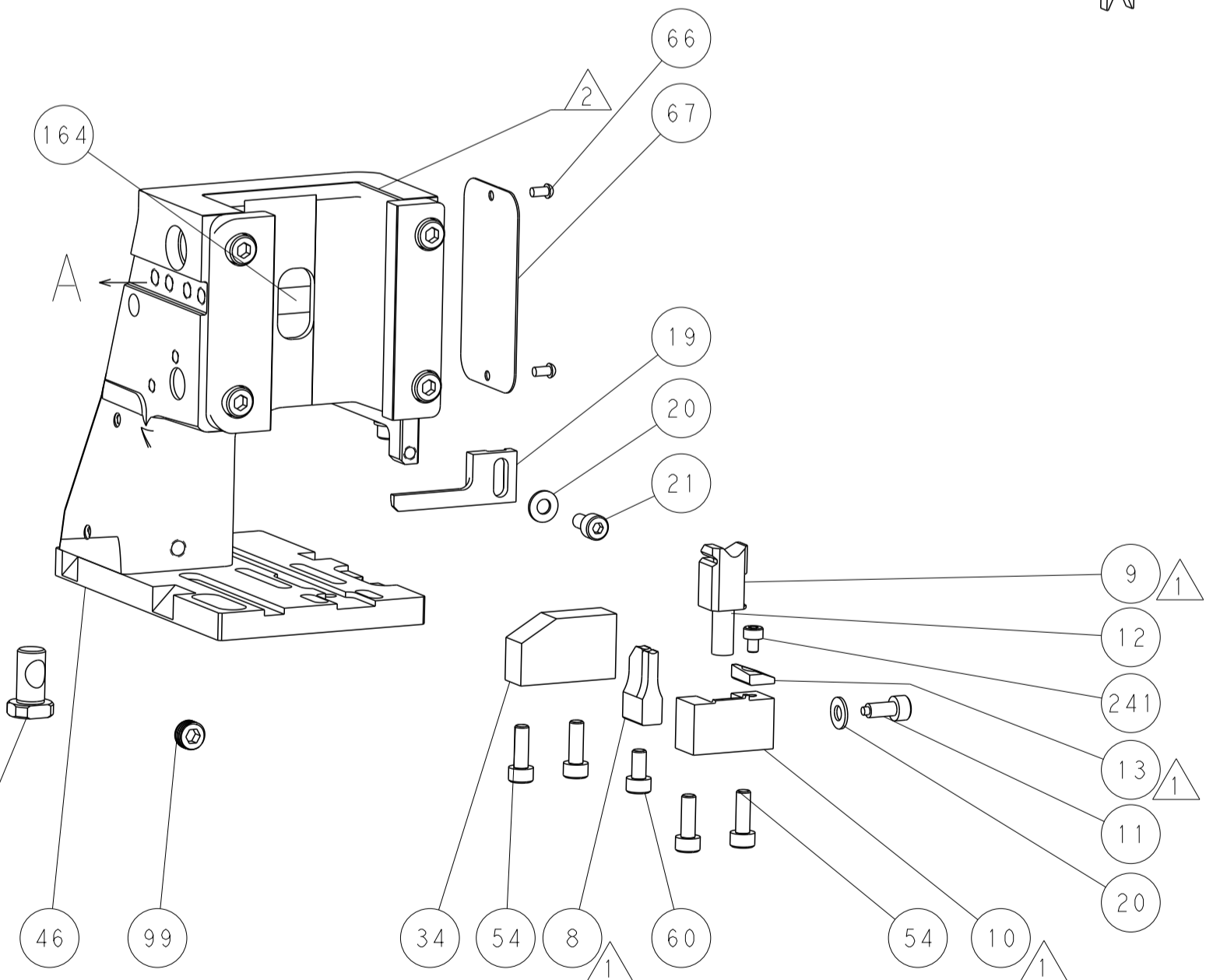
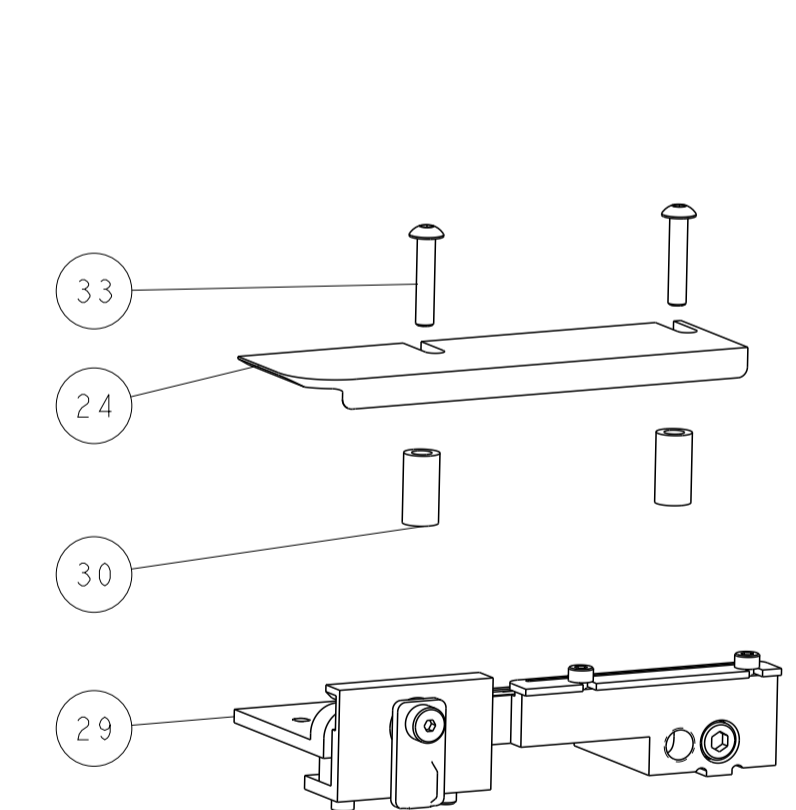
DETAIL A



TERMINAL SUPPORT LOCATION

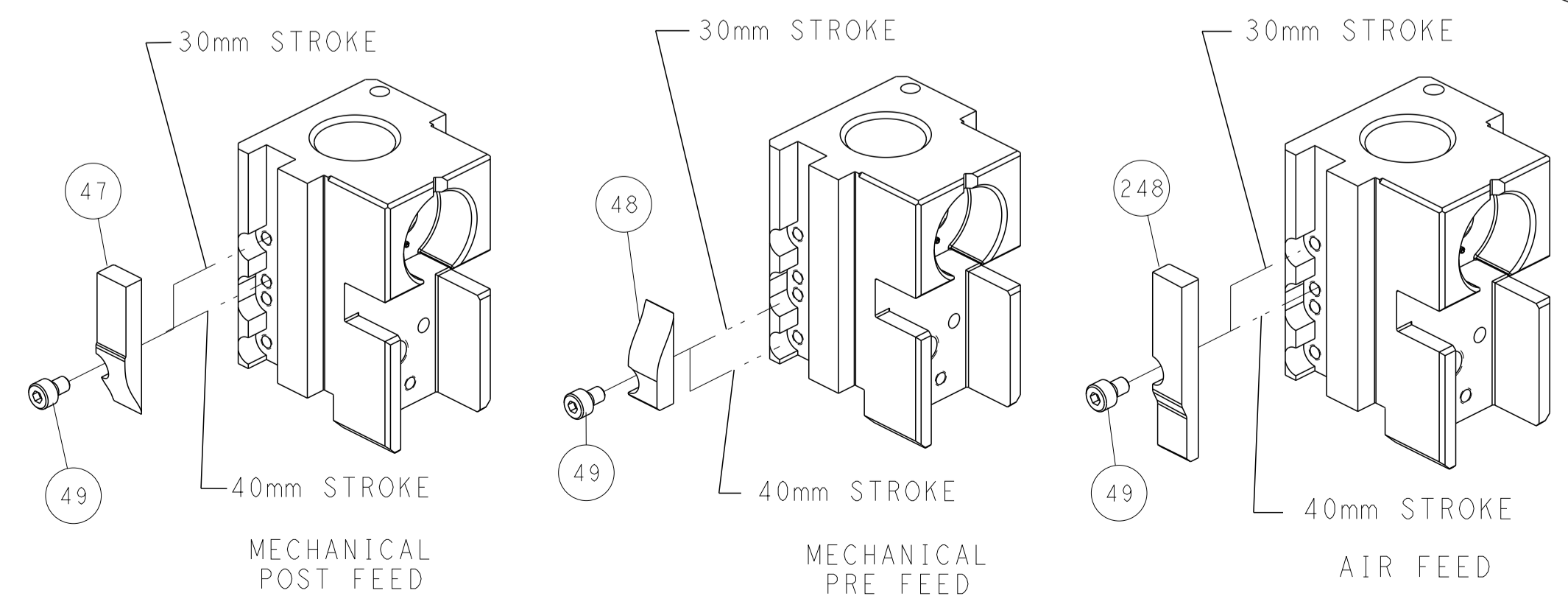


RAM SET-UP



FEED TRACK POSITION GUIDE BY WIRE 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)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		OWN	14MAR2018	TE Connectivity Harrisburg, PA 17105-3608
mm	0 PLC ±	1 PLC ±	2 PLC ±	CHK	14MAR2018	
	3 PLC ±	4 PLC ±	ANGLES ±	APVD	14MAR2018	NAME
MATERIAL	FINISH	WEIGHT	Customer Accessible Production Drawing	A1 00779 ©=2837173		RESTRICTED TO
SCALE			1:2	SHEET 2 OF 4		REV B

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COPYRIGHT 20 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.			
PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2837173-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2837173-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2837173-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.79 mm [.110]	F
INSUL	3.18 mm [.125]	O
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: DELPHI TERMINAL DELPHI PACKARD CRIMP SPECIFICATION	
TERMINAL NAME: TAXI ASM TERM F HES 1.6	
WIRE STRIP LENGTH 4.43-5.19 mm [.174-.204 IN]	TERMINAL INSULATION DIAMETER RANGE Ø2.45-3.25 mm [.096-.128 IN]
TERMINAL APPLICATION SPECIFICATION (A)13697416 CRIMP INFO SHT-Rev 2013-10-30	(B)13697410 CRIMP INFO SHT-Rev 2013-10-30
TERMINALS APPLIED	
TE TERMINAL (A) 3311130-1	DELPHI TERMINAL (A) 13697416
TE TERMINAL (B) 3311131-1	DELPHI TERMINAL (B) 13697410

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
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- △ 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.
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PACIFIC VERSION
Shown on sheets 3 of 4 & 4 of 4
(Atlantic version shown on sheets 1 of 4 & 2 of 4)

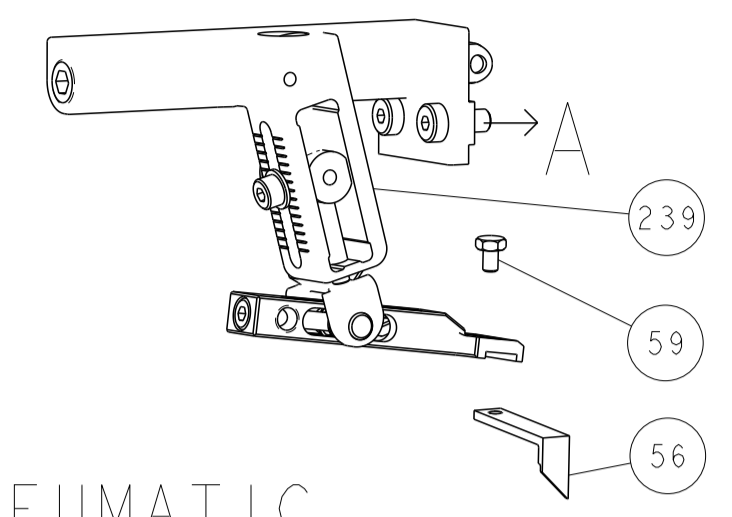
LOC	DIST	REVISIONS					
A	66	P	LTN	DESCRIPTION	DATE	OWN	APVD
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-	1	1	2119082-4	CAM, SNAIL, INSULATION ADJUSTMENT	244	
-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243	
△	-	1	2119083-1	RETAINER, INSULATION DIAL	242	
-	1	1	7-18023-7	SCR, SKT HD 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	1803516-1	RAM ASSEMBLY, SF PACIFIC	140	
△	-	1	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113	
-	1	1	2844908-1	SCREW, LOCKING	99	
-	1	1	2844907-1	POST, LOCKING	98	
-	1	1	455888-6	SPACER, CRIMPER	82	
-	1	1	1803607-3	DOCUMENTATION PACKAGE	71	
-	1	1	2119791-9	DEPRESSOR, WIRE	70	
-	1	1	2119943-1	WASHER, SPACER	69	
-	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	
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-	2	2	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	53	
-	1	1	1803382-6	HOLD DOWN, SPRING LOADED	50	
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-	1	1	1320928-2	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	2119806-1	INSERT, SHEAR	13	
-	1	1	3-22280-3	SPRING, COMPRESSION	12	
-	1	1	1-356885-4	STOP, SHEAR	11	
△	-	1	2119805-1	SHEAR HOLDER, FRONT	10	
△	-	1	1803095-1	FLOATING SHEAR, FRONT	9	
△	1	1	1	4-1633923-5	ANVIL, COMBINATION	8
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-	-	-	-	-	6	
-	1	1	2119757-4	DEPRESSOR, SHEAR	5	
-	1	1	4-238011-5	BLOCK, CRIMPER SPACER	4	
△	1	1	1	1803453-6	CRIMPER, INSULATION O	3
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△	1	1	1	2-1803454-6	CRIMPER, WIRE	1

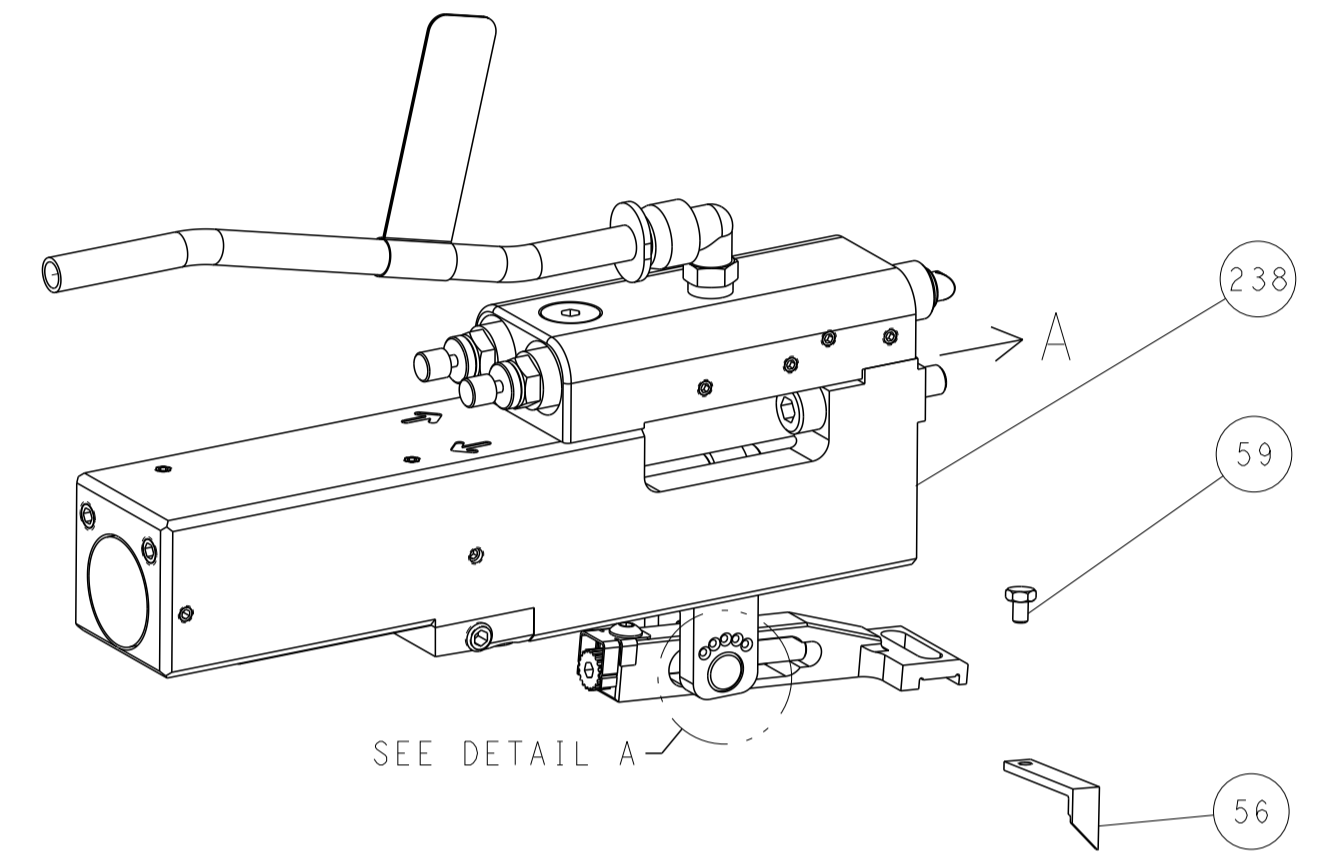
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mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	APVD L. ZHANG 14MAR2018	NAME Ocean Side Feed Applicator
MATERIAL		FINISH		WEIGHT		SIZE CAGE CODE DRAWING NO RESTRICTED TO	
						A 00779 C=2837173	
Customer Accessible Production Drawing				SCALE 1:2		SHEET 3 OF 4 REV B	

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

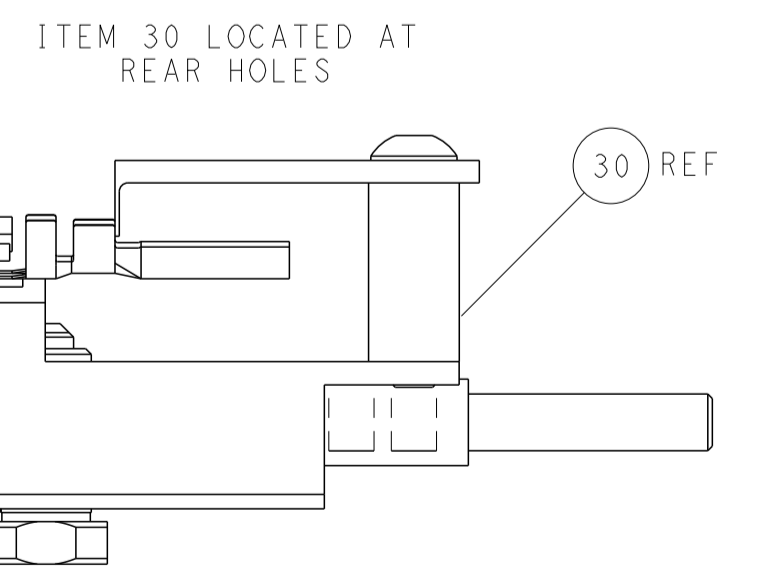
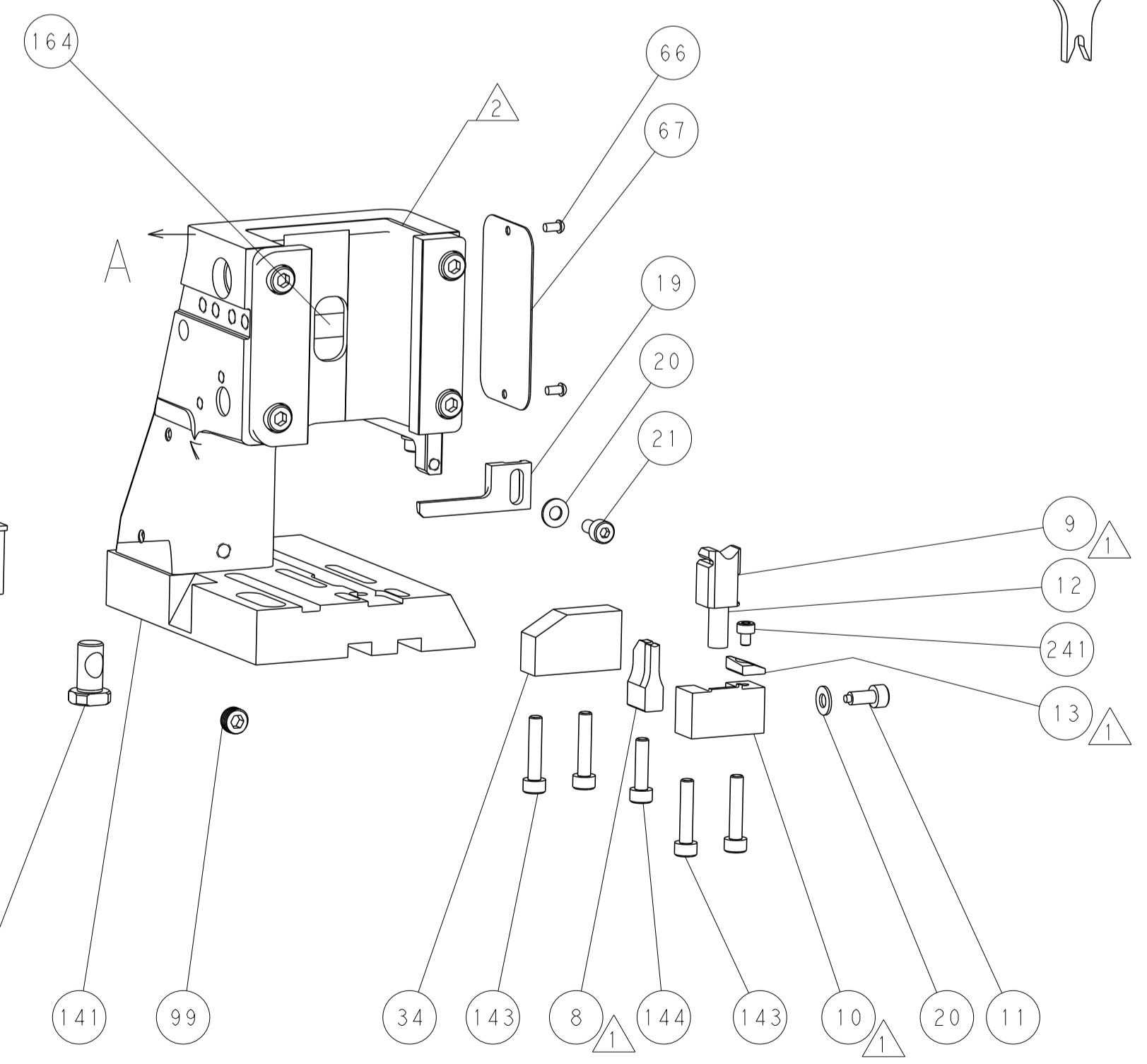
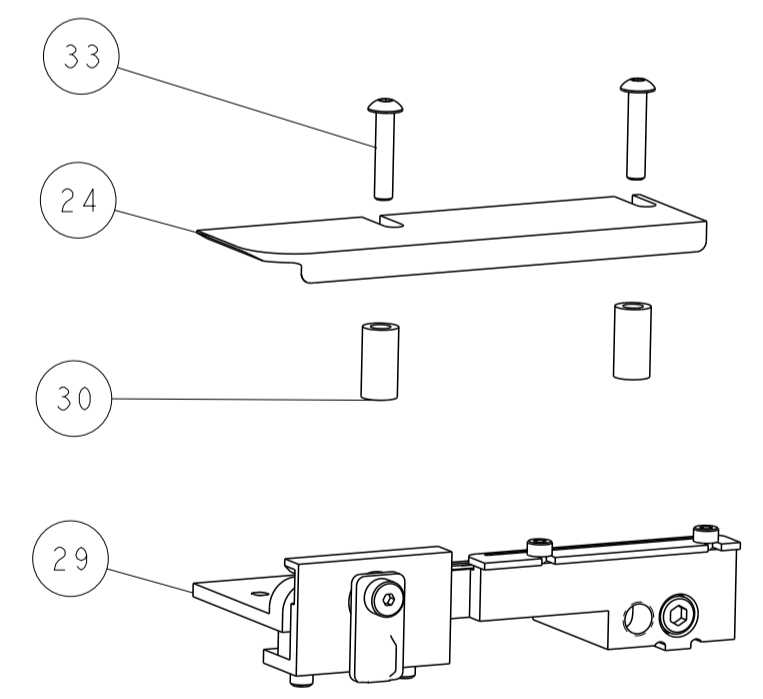
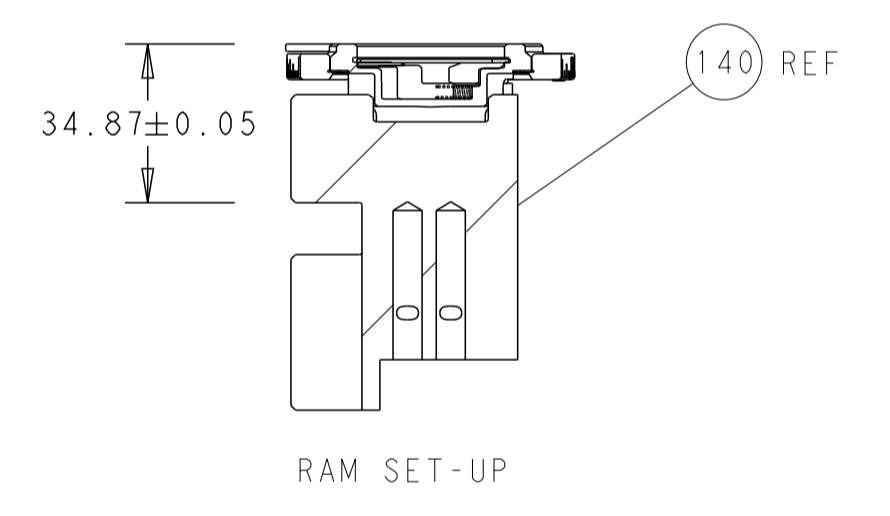
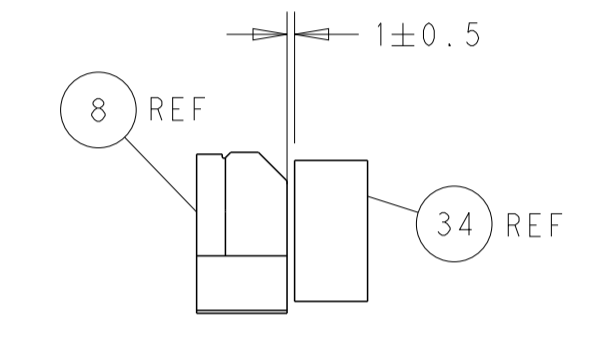
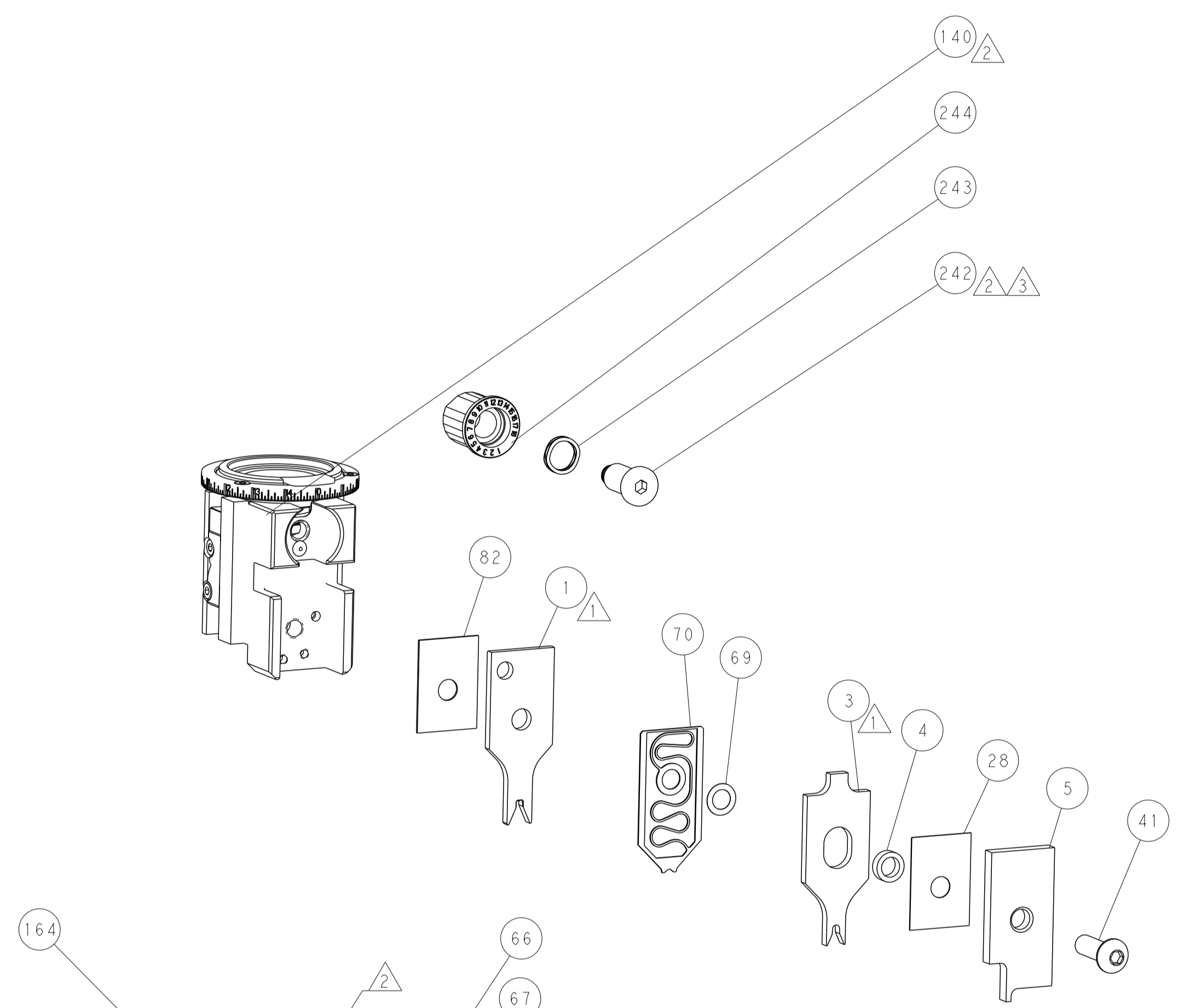
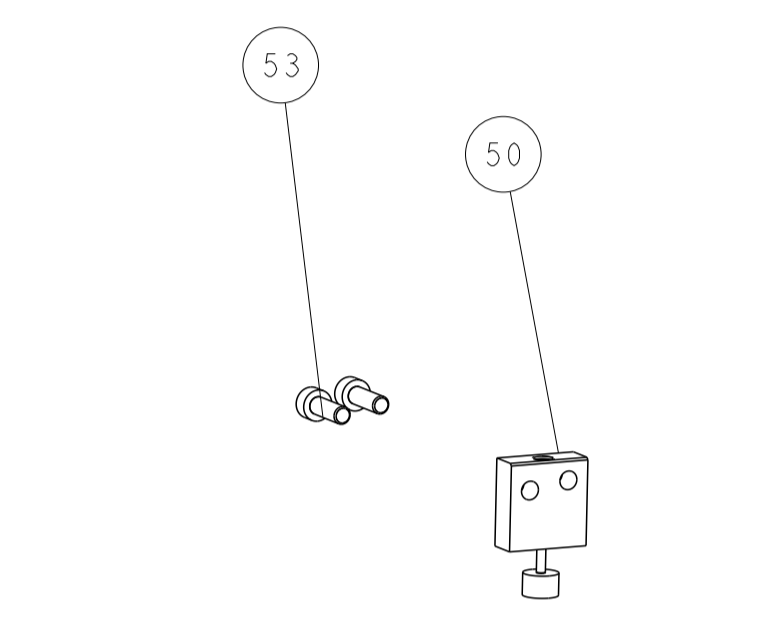
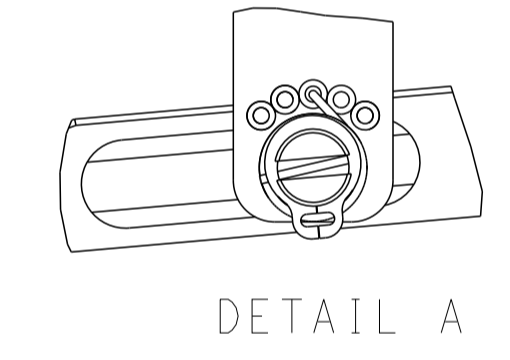
FEED TYPE MECHANICAL



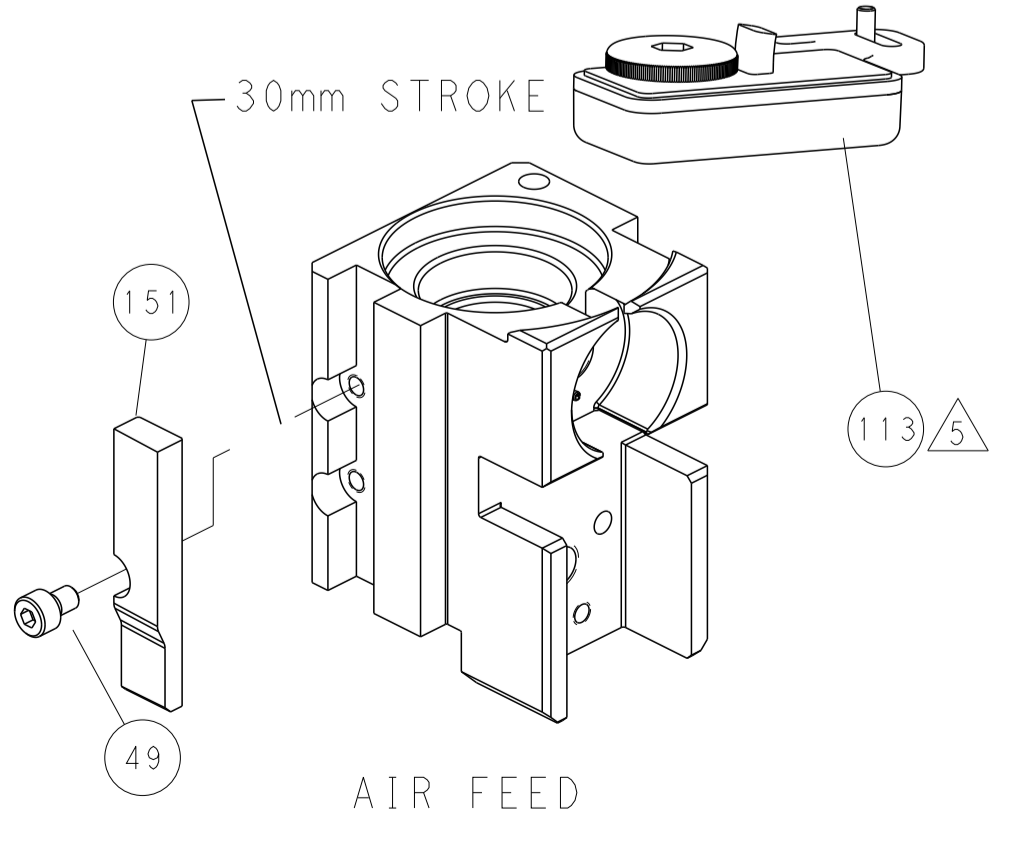
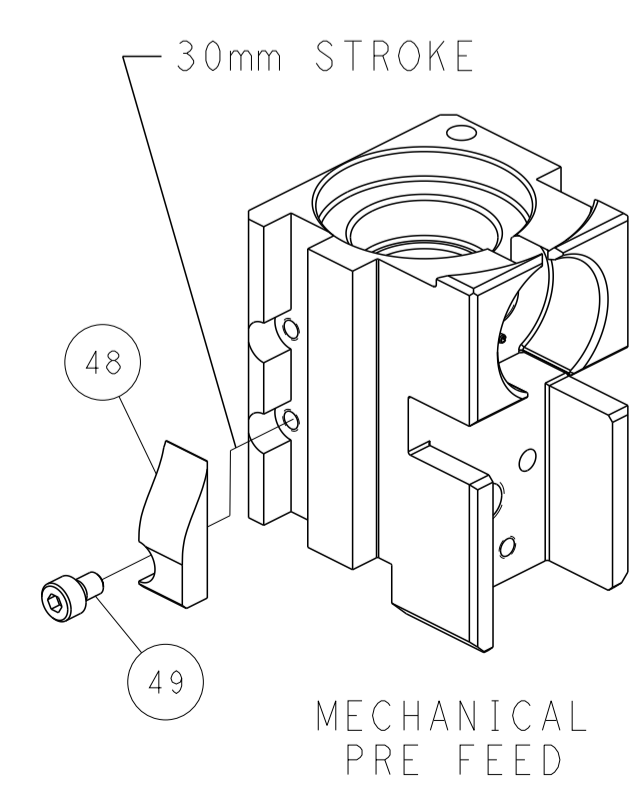
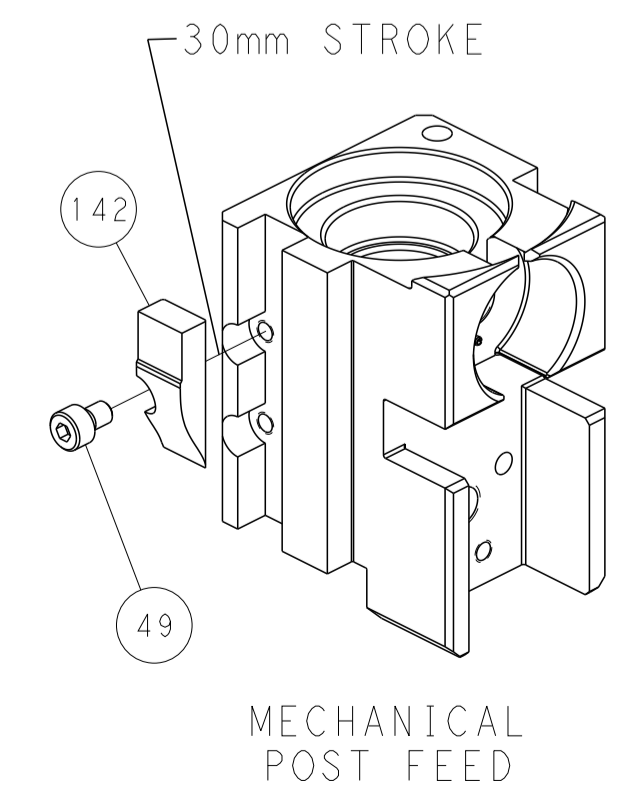
PNEUMATIC



FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



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:		DWG: H. HUANG 14MAR2018		NAME: TE Connectivity	
mm	0 PLC	±		CHK: L. ZHANG 14MAR2018	Harrisburg, PA 17105-3608		
	1 PLC	±		APVD: L. ZHANG 14MAR2018	Ocean Side Feed Applicator		
	2 PLC	±		PRODUCT SPEC			
	3 PLC	±		APPLICATION SPEC			
	4 PLC	±		RESTRICTED TO			
	ANGLES	±		SIZE: CAGE CODE: DRAWING NO.			
	FINISH	±		A 00779 C=2837173			
MATERIAL:				WEIGHT:		SCALE: 1:2 SHEET 4 OF 4 REV B	
Customer Accessible Production Drawing				Customer Accessible Production Drawing			