

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2837174-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2837174-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2837174-1	C	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2837174-2	C	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2837174-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER

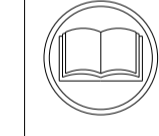


APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.90 mm [.075]	F
INSUL	2.79 mm [.110]	O

APPLICATOR INSTRUCTIONS 408-35042

TERMINAL DATA: DELPHI PACKARD TERMINAL DELPHI PACKARD CRIMP SPECIFICATION			
TERMINAL NAME: TAXI HES 1.6 PIN & SOCKET			
WIRE STRIP LENGTH 4.40-5.16 mm [.173-.203 IN]		TERMINAL INSULATION DIAMETER RANGE Ø 2.30-3.05 mm [.091-.120 IN]	
TERMINAL APPLICATION SPECIFICATION	(A)13663715 CRIMP INFO SHEET		
	(B)13663718 CRIMP INFO SHEET		
TERMINALS APPLIED			
TE TERMINAL (A) 2113308-1	DELPHI PACKARD TERMINAL (A) 13663715	TE TERMINAL (B) 3311132-1	DELPHI PACKARD TERMINAL (B) 13663718

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.80mm2	1.30+/-0.05 [.051+/- .002]	7.1
0.50mm2	1.15+/-0.05 [.045+/- .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.
- 7 SUPPORT 8-1752356-4 FOR PIN TERMINAL 2113308-1.
- 8 SUPPORT 3-1752356-3 FOR SOCKET TERMINAL 3311132-1.

***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)

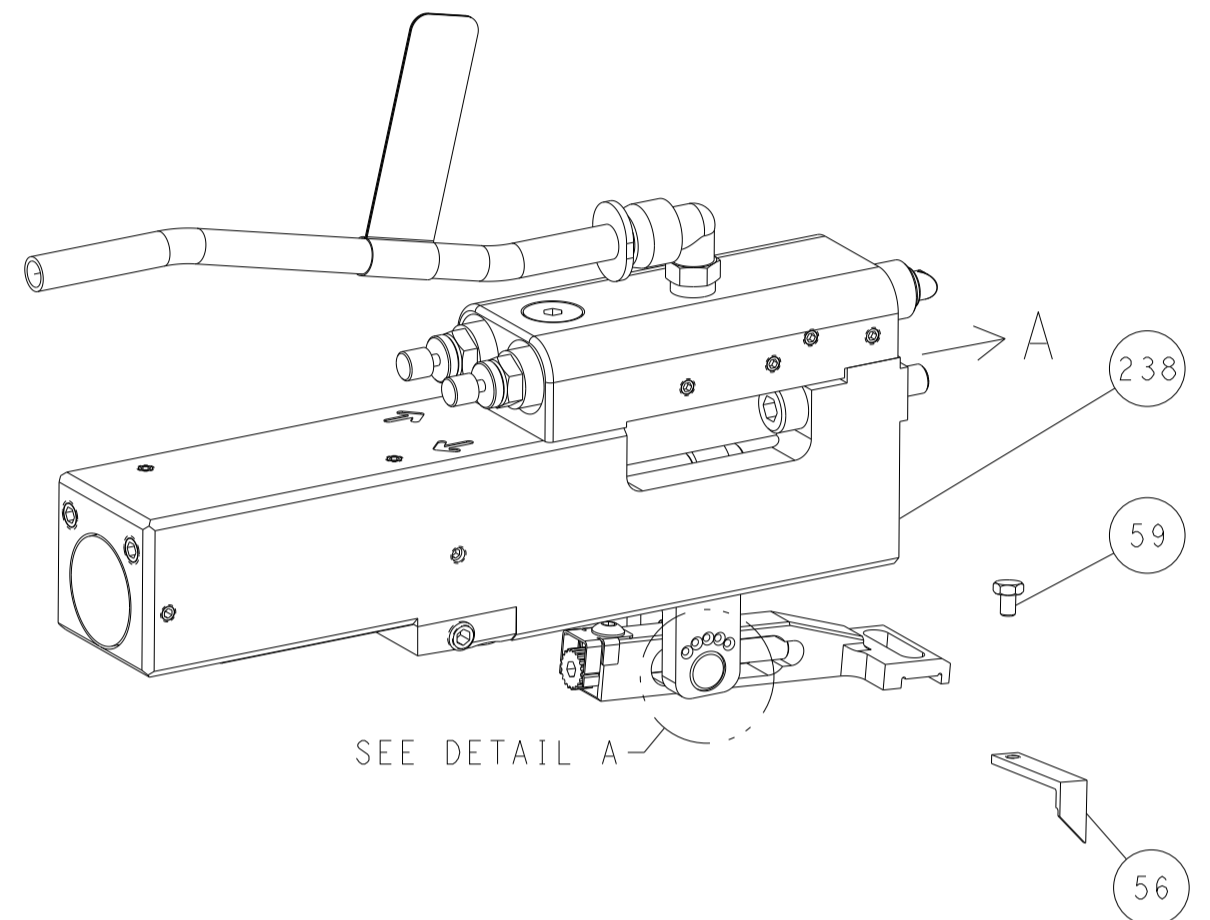
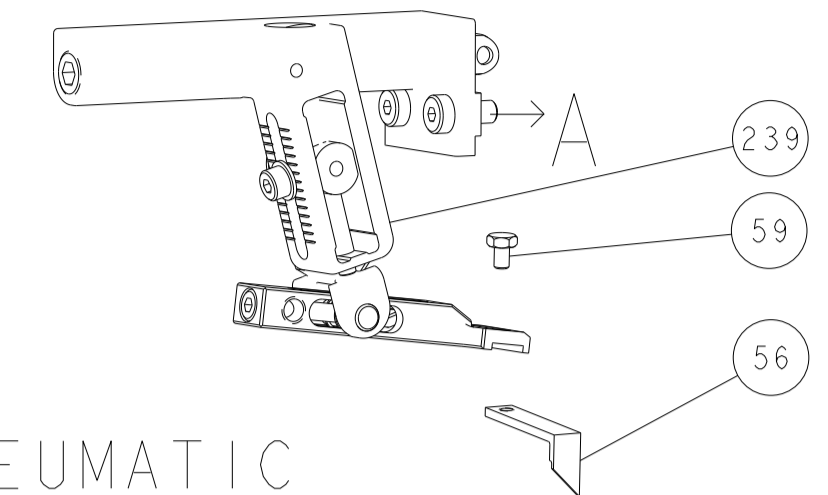
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		P	LTN	DESCRIPTION	DATE	OWN	APVD
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		B		ECR-21-006090	07JUN2021	TB	RK
		C		ECR-22-127766	26JAN2022	FJ	GB

-	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	
3	-	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	
5	-	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	455888-5	SPACER, CRIMPER	82	
-	1	1	1	1	1803607-3	DOCUMENTATION PACKAGE	71	
-	1	1	1	1	2119791-6	DEPRESSOR, WIRE	70	
-	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	2-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 14	53	
-	1	1	1	1	1803382-2	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	
8	-	1	1	1	3-1752356-3	SUPPORT, TERMINAL	35	
7	-	1	1	1	8-1752356-4	SUPPORT, TERMINAL	34	
-	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33	
-	2	2	2	2	2-2844962-8	SPACER, CYLINDRICAL, STRIP GUIDE	30	
-	1	1	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29	
-	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	1803095-6	FLOATING SHEAR, FRONT	9	
1	1	2	2	1	1	9-1803318-3	ANVIL, COMBINATION	8
-	1	1	1	1	240641-3	SPACER	7	
-	-	-	-	-	-	-	6	
-	1	1	1	1	2119757-4	DEPRESSOR, SHEAR	5	
-	1	1	1	1	3-238011-1	BLOCK, CRIMPER SPACER	4	
1	1	2	2	1	1	8-1633965-3	CRIMPER, INSULATION O PREMIUM	3
-	1	1	1	1	455888-6	SPACER, CRIMPER	2	
1	1	2	2	1	1	1-1673600-8	CRIMPER, WIRE	1
-	77	-72	-71	-2	-1	PART NO	DESCRIPTION	ITEM NO

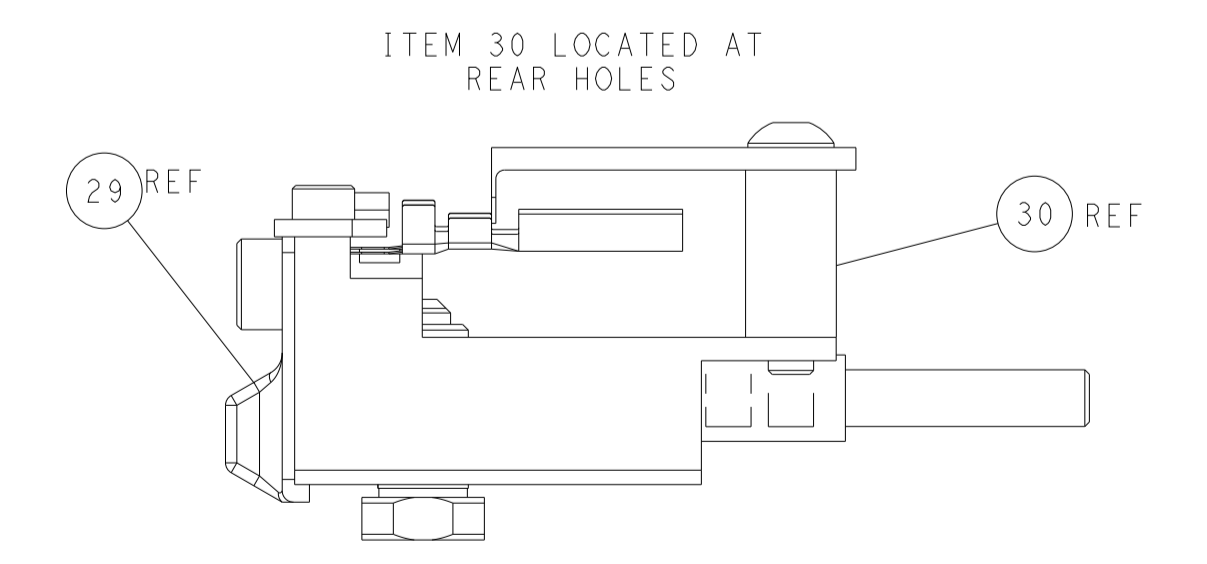
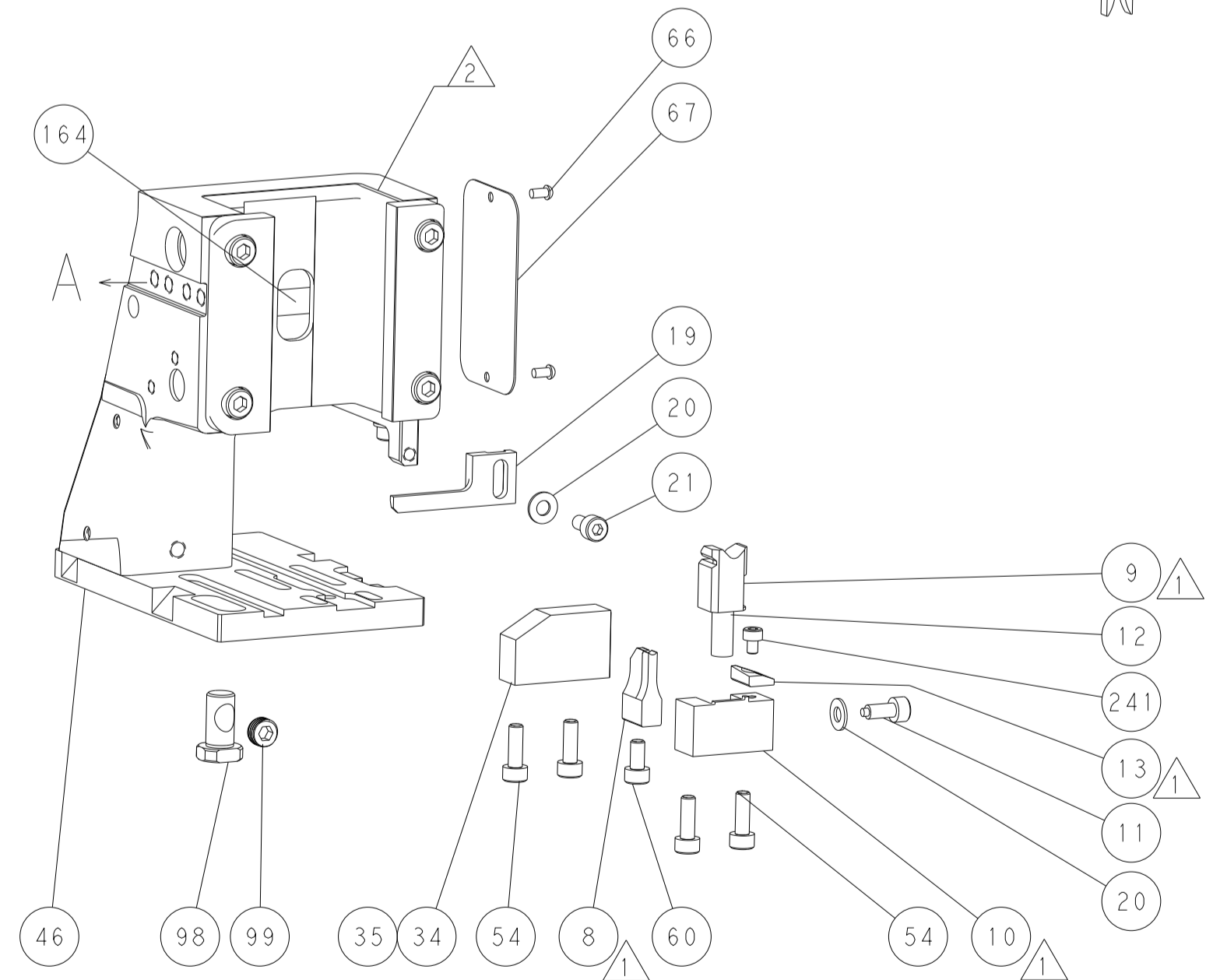
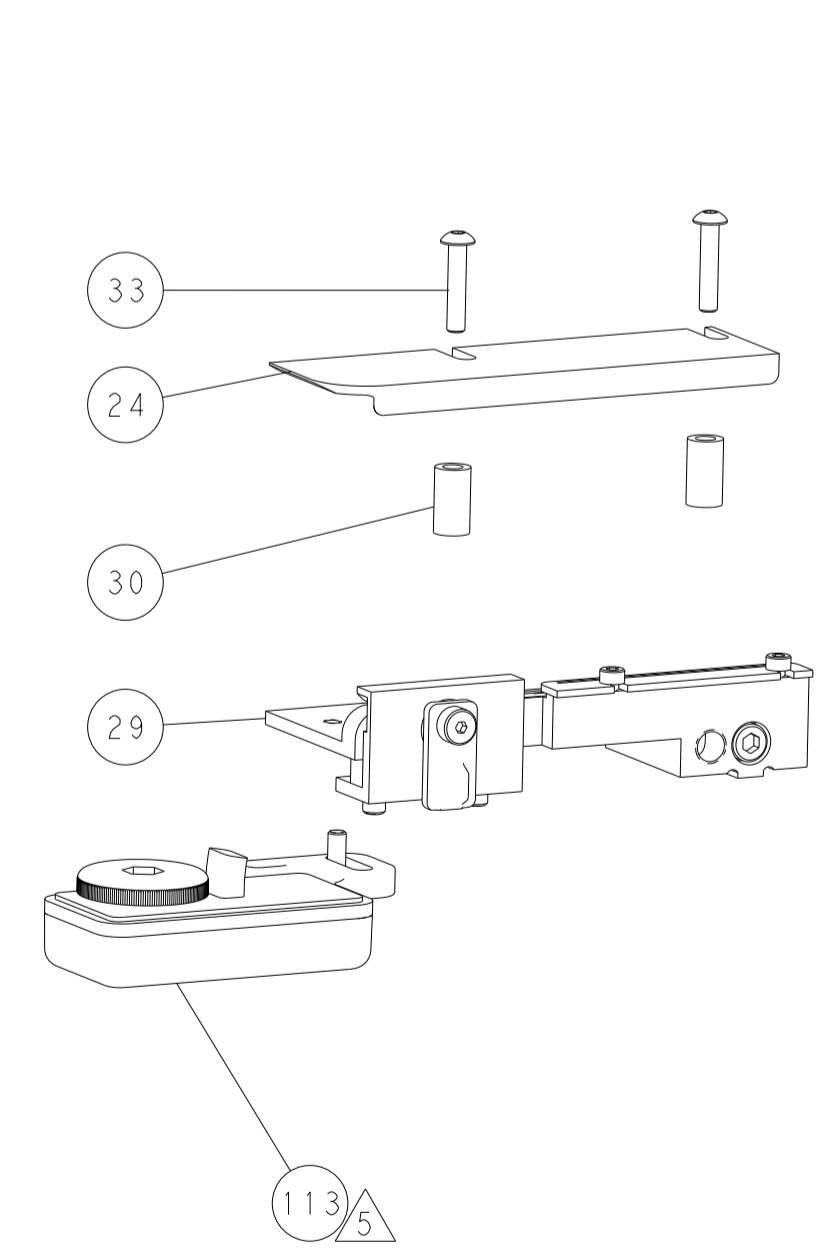
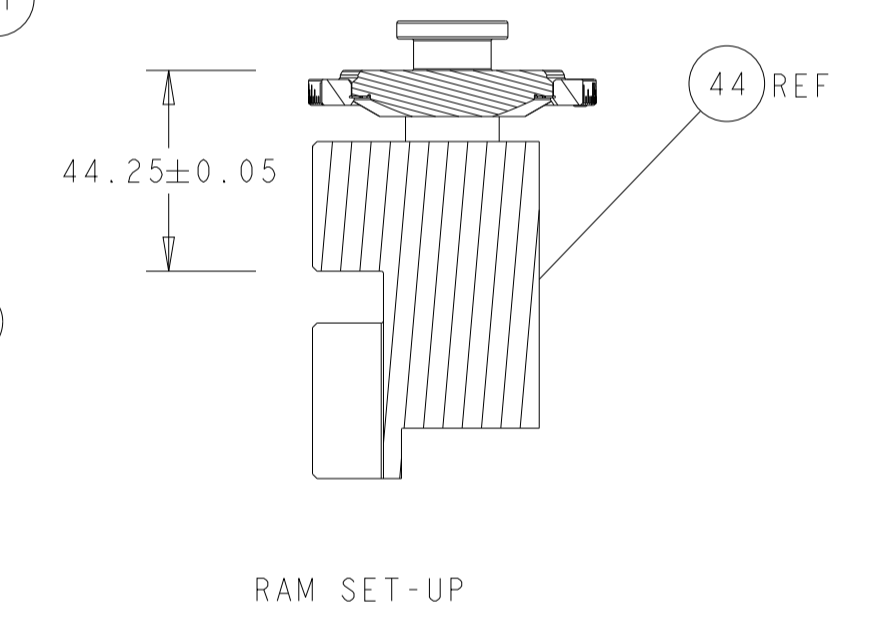
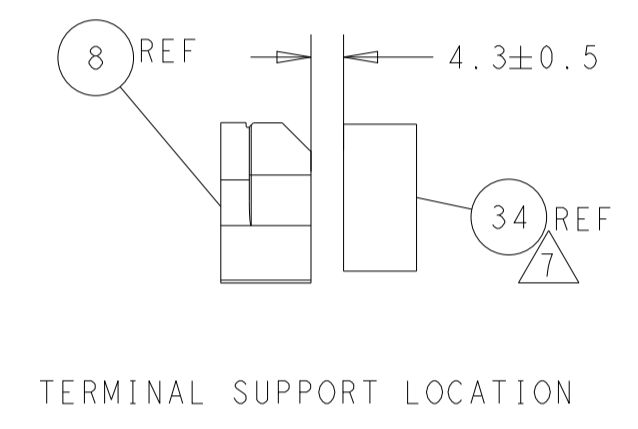
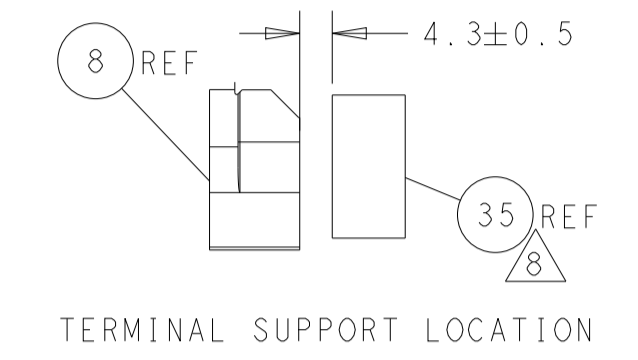
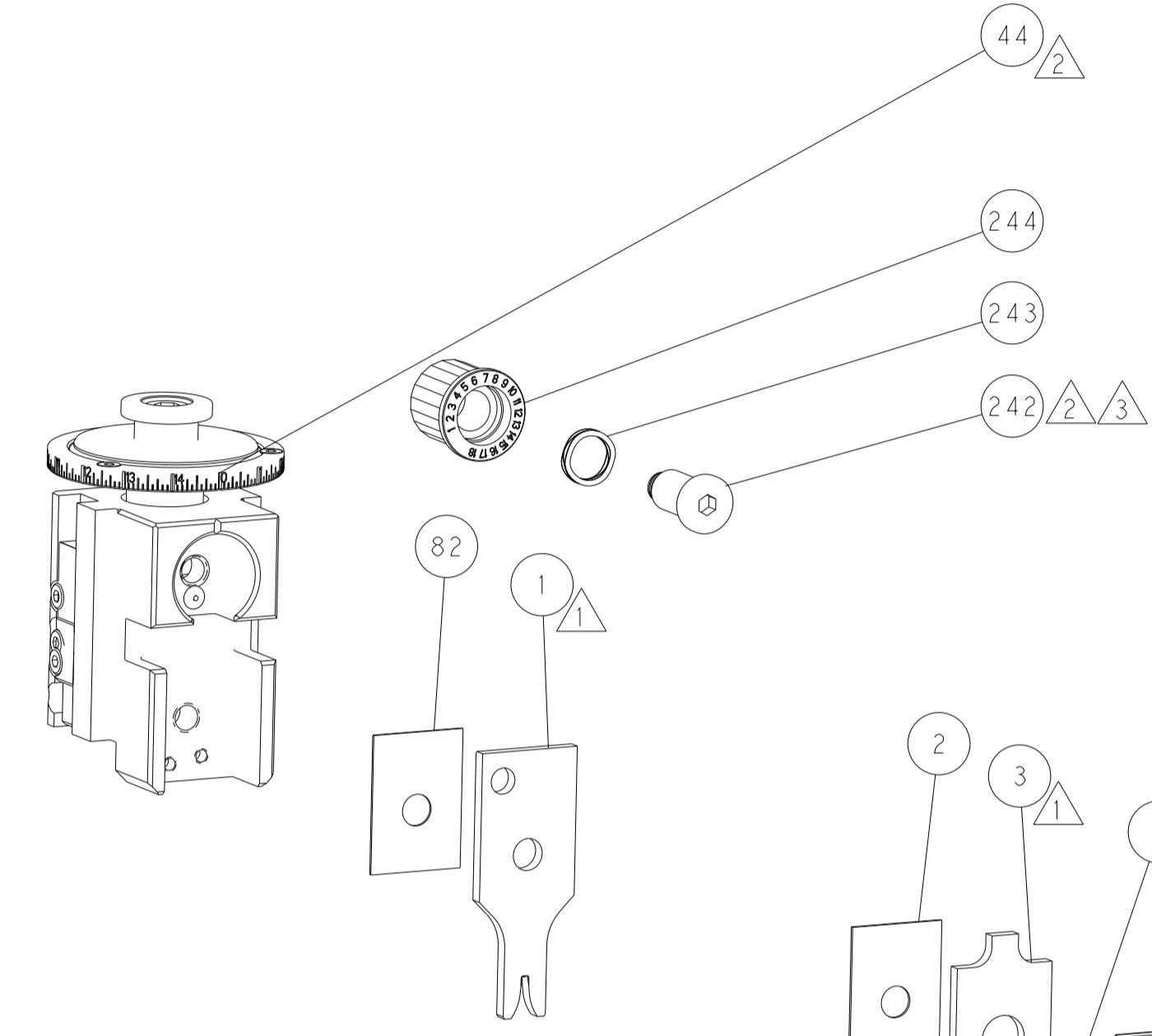
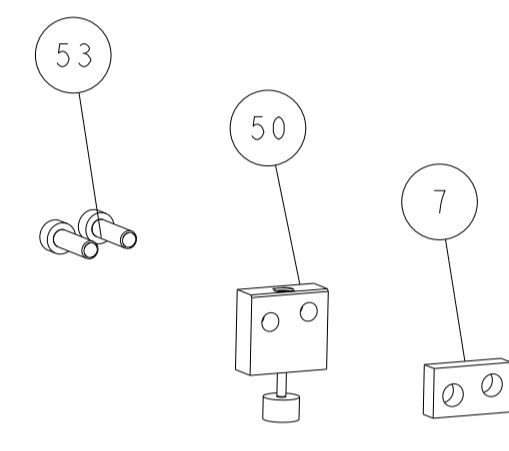
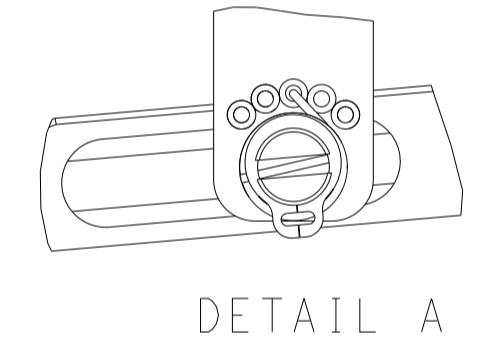
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		OWN F. ZHANG CHK K. ZHANG APVD K. ZHANG		DATE 16MAR2018 16MAR2018 16MAR2018		NAME Ocean Side Feed Applicator	
mm	0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±	FINISH	±	PRODUCT SPEC	APPLICATION SPEC	SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
MATERIAL						A1	00779	2837174	
Customer Accessible Production Drawing						SCALE	1:2	SHEET	1 OF 4

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

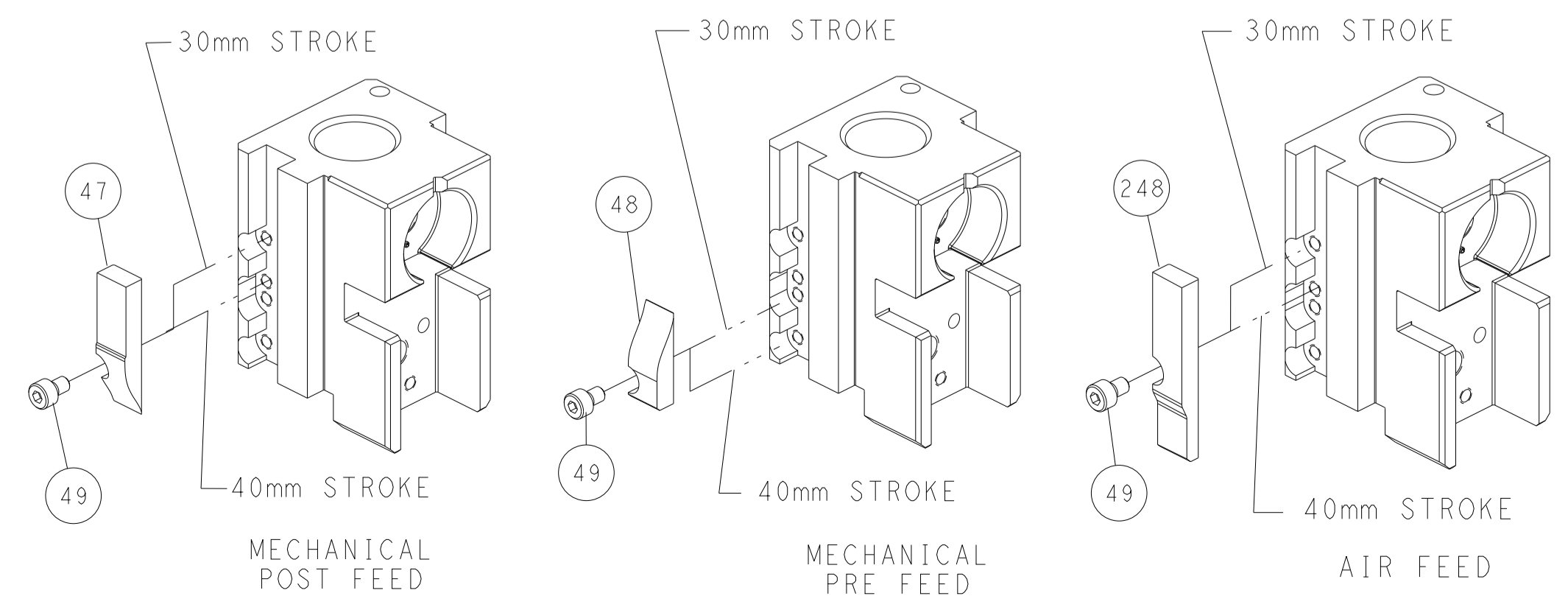
FEED TYPE MECHANICAL



FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



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: F. ZHANG 16MAR2018	NAME: Ocean Side Feed Applicator
mm	0 PLC ±	1 PLC ±	2 PLC ±	CHK: K. ZHANG 16MAR2018	
MATERIAL:		FINISH:		APVD: K. ZHANG 16MAR2018	SIZE: A1
				PRODUCT SPEC:	CAGE CODE: 00779
				APPLICATION SPEC:	DRAWING NO: 2837174
				WEIGHT:	RESTRICTED TO:
				Customer Accessible Production Drawing	SCALE: 1:2
					SHEET 2 OF 4
					REV C

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2837174-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2837174-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2837174-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
 INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.90 mm [.075]	F
INSUL	2.79 mm [.110]	O

APPLICATOR INSTRUCTIONS
 408-35042

TERMINAL DATA: DELPHI PACKARD TERMINAL DELPHI PACKARD CRIMP SPECIFICATION			
TERMINAL NAME: TAXI HES 1.6 PIN & SOCKET			
WIRE STRIP LENGTH 4.40-5.16 mm [1.73-.203 IN]	TERMINAL INSULATION DIAMETER RANGE Ø 2.30-3.05 mm [0.91-.120 IN]		
TERMINAL APPLICATION SPECIFICATION (A)13663715 CRIMP INFO SHEET (B)13663718 CRIMP INFO SHEET			
TERMINALS APPLIED			
TE TERMINAL (A) 2113308-1	DELPHI PACKARD TERMINAL (A) 13663715	TE TERMINAL (B) 3311132-1	DELPHI PACKARD TERMINAL (B) 13663718

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.80mm2	1.30 +/- 0.05 [0.051 +/- .002]	7.1
0.50mm2	1.15 +/- 0.05 [0.045 +/- .002]	8.5



***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.

- 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.
- 7 SUPPORT 8-1752356-4 FOR PIN TERMINAL 2113308-1.
- 8 SUPPORT 3-1752356-3 FOR SOCKET TERMINAL 3311132-1.

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

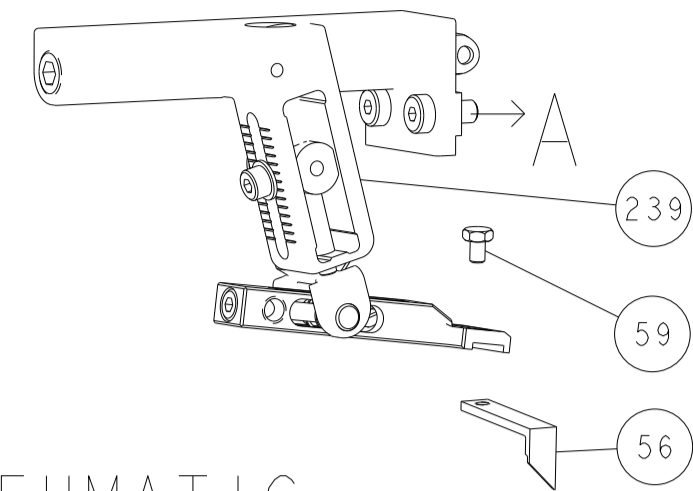
-	1	1	2119082-4	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
-	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	1	-	2844940-1	AIR FEED MODULE	238
-	REF	REF	994970-2	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	1	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113
-	1	1	2844908-1	SCREW, LOCKING	99
-	1	1	2844907-1	POST, LOCKING	98
-	1	1	455888-5	SPACER, CRIMPER	82
-	1	1	1803607-3	DOCUMENTATION PACKAGE	71
-	1	1	2119791-6	DEPRESSOR, WIRE	70
-	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	1338683-8	FEED PAWL	56
-	2	2	2-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 14	53
-	1	1	1803382-2	HOLD DOWN, SPRING LOADED	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	3-1752356-3	SUPPORT, TERMINAL	35
-	1	1	8-1752356-4	SUPPORT, TERMINAL	34
-	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	2-2844962-8	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29
-	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	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	1803095-6	FLOATING SHEAR, FRONT	9
-	1	1	9-1803318-3	ANVIL, COMBINATION	8
-	1	1	240641-3	SPACER	7
-	-	-	-	-	6
-	1	1	2119757-4	DEPRESSOR, SHEAR	5
-	1	1	3-238011-1	BLOCK, CRIMPER SPACER	4
-	1	1	8-1633965-3	CRIMPER, INSULATION O PREMIUM	3
-	1	1	455888-6	SPACER, CRIMPER	2
-	1	1	1-1673600-8	CRIMPER, WIRE	1

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

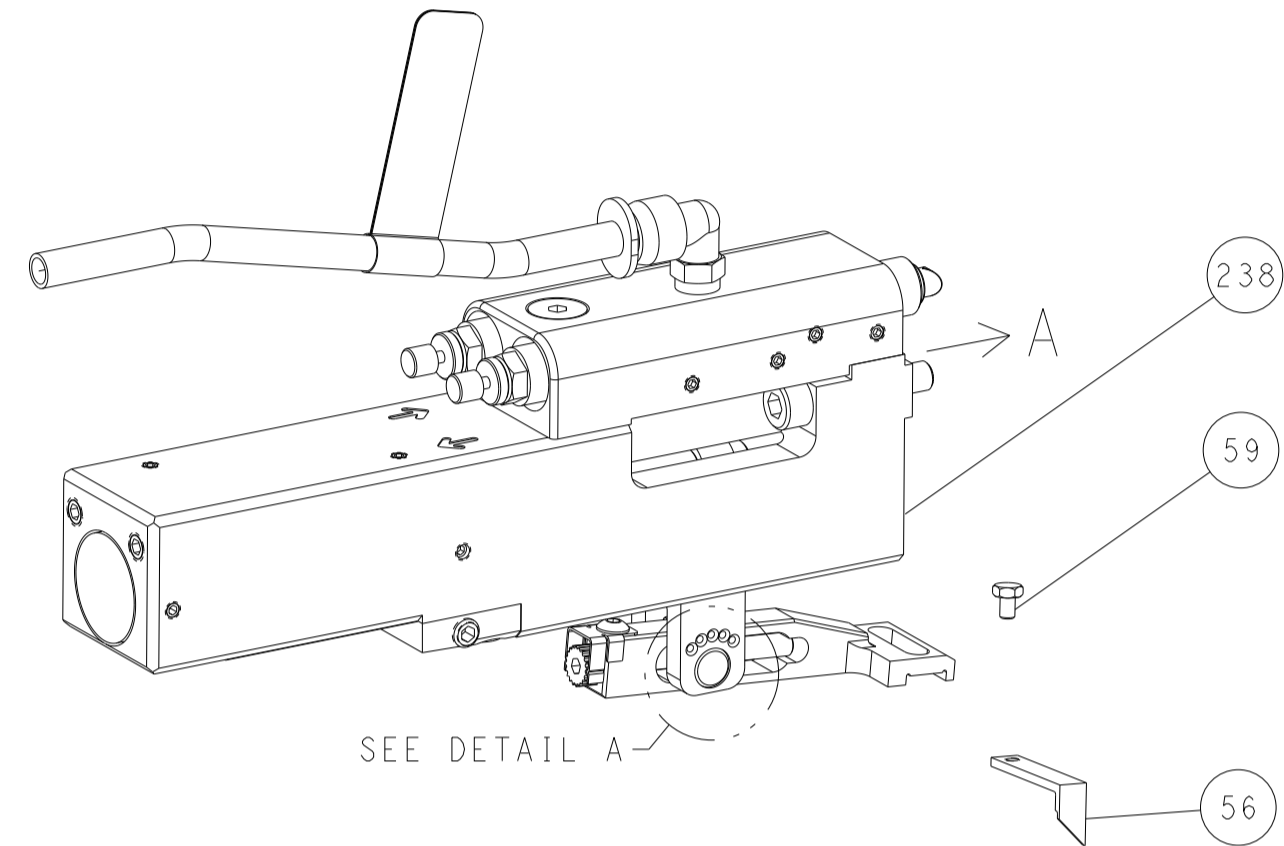
DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH		DWG F. ZHANG 16MAR2018 CHK K. ZHANG 16MAR2018 APVD K. ZHANG 16MAR2018 PRODUCT SPEC APPLICATION SPEC WEIGHT SCALE 1:2 SHEET 3 OF 4 REV C		NAME Ocean Side Feed Applicator SIZE CAGE CODE DRAWING NO A1 00779 C=2837174 RESTRICTED TO Customer Accessible Production Drawing	
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LOC	DIST	REVISIONS					
A	66	P	LTN	DESCRIPTION	DATE	OWN	APVD
		-		SEE SHEET 1	-	-	-

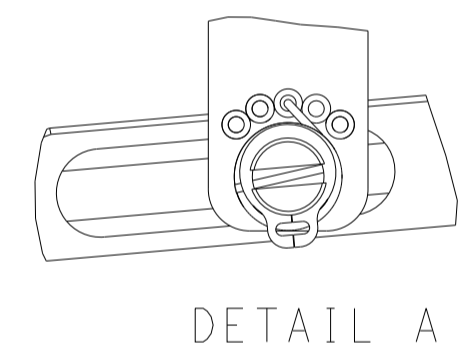
FEED TYPE MECHANICAL



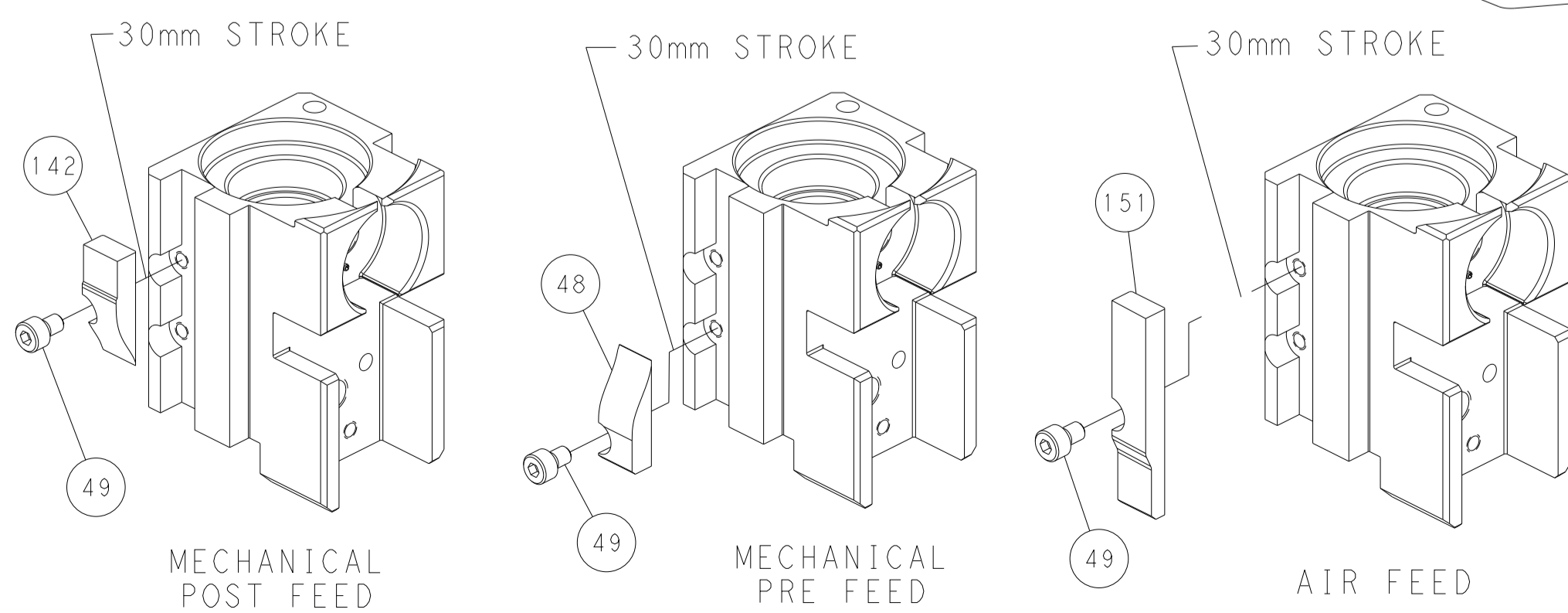
PNEUMATIC



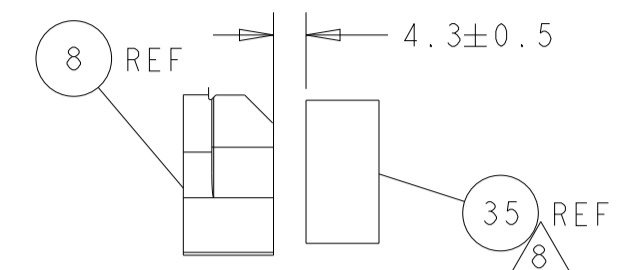
FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



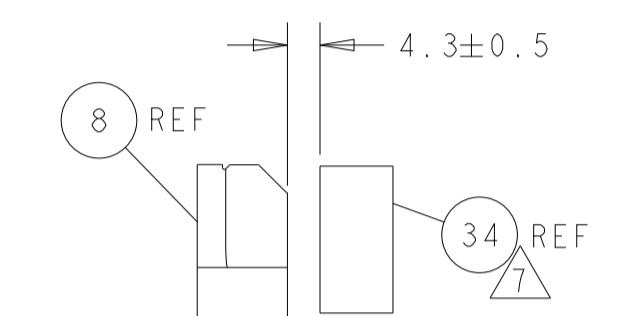
CAM POSITIONS



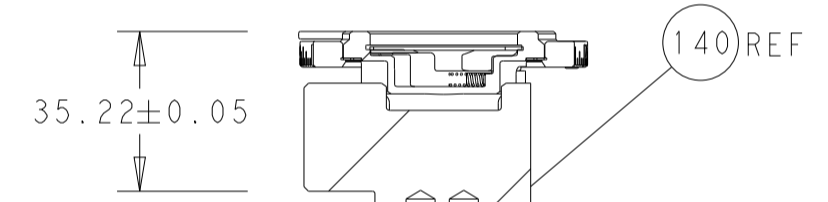
PACIFIC VERSION
 Shown on sheets 3 of 4 & 4 of 4
 (Atlantic version shown on sheets 1 of 4 & 2 of 4)



TERMINAL SUPPORT LOCATION

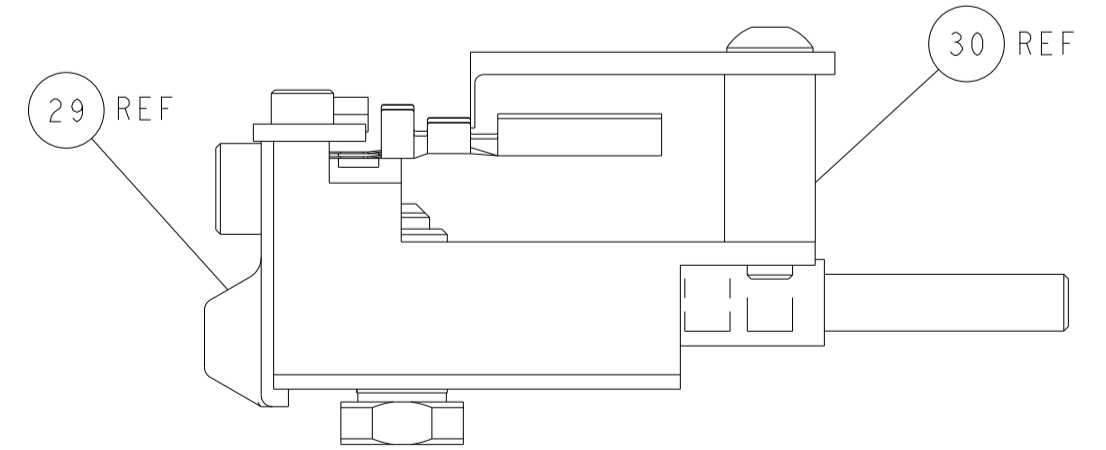


TERMINAL SUPPORT LOCATION



RAM SET-UP

ITEM 30 LOCATED AT
REAR HOLES



FEED TRACK POSITION
GUIDE BY WIRE BARREL

<small>THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION. ALL RIGHTS RESERVED. THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION. ALL RIGHTS RESERVED. THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION. ALL RIGHTS RESERVED.</small>		DWN F. ZHANG 16MAR2018 CHK K. ZHANG 16MAR2018 APVD K. ZHANG 16MAR2018	NAME Ocean Side Feed Applicator
DIMENSIONS: mm 	TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH	SIZE A1 CAGE CODE 00779 DRAWING NO C=2837174	RESTRICTED TO Customer Accessible Production Drawing SCALE 1:2 SHEET 4 OF 4 REV C