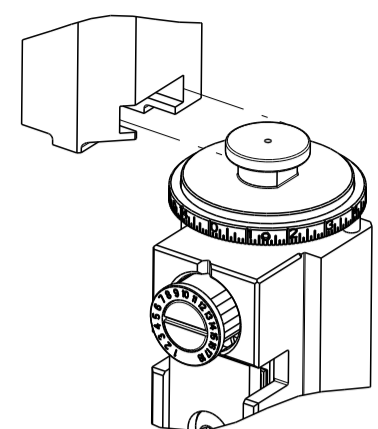


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2836131-2	D	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2836131-2	D	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2836131-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	3.56 mm [.140]	F
INSUL	6.50 mm [.256]	O

APPLICATOR INSTRUCTIONS 408-35042

TERMINAL DATA: DELPHI TERMINAL DELPHI CRIMP SPECIFICATION	
TERMINAL NAME: F M/P 480 TERMINAL	
WIRE STRIP LENGTH	TERMINAL INSULATION DIAMETER RANGE
5.05-5.81 mm [.199-.229 IN]	∅ .137-.206 IN [3.49-5.24 mm]
TERMINAL APPLICATION SPECIFICATION (A) SHEET PAGE 11	Rev 2013-10-30

TERMINALS APPLIED				
TE TERMINAL	DELPHI TERMINAL	TE SEAL	DELPHI SEAL	SEAL INSULATION DIAMETER RANGE
(A) 1572196-1	(A) 12052139	(A) 1572026-1	(A) 15324989	2.7-3.8mm
		(A) 2113971-1	(A) 15324990	3.6-4.5mm
		(A) 1572197-1	(A) 12048443	3.6-4.5mm

TERMINAL DATA: DELPHI TERMINAL DELPHI CRIMP SPECIFICATION	
TERMINAL NAME: F M/P 480 TERMINAL	
WIRE STRIP LENGTH	TERMINAL INSULATION DIAMETER RANGE
5.05-5.81 mm [.199-.229 IN]	∅ 3.49-5.24 mm [.137-.206 IN]
TERMINAL APPLICATION SPECIFICATION (B) SHEET PAGE 12 OF 15	Rev 2013-10-30

TERMINALS APPLIED				
TE TERMINAL	DELPHI TERMINAL	TE SEAL	DELPHI SEAL	SEAL INSULATION DIAMETER RANGE
(B) 1572196-1	(B) 12052139	(B) 1572026-1	(B) 15324989	2.7-3.8mm
		(B) 2113971-1	(B) 15324990	3.6-4.5mm

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
4.00mm2	2.10 +/- 0.05 [.083 +/- .002]	6.0

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
4.00mm2	2.30 +/- 0.05 [.091 +/- .002]	4.0
3.00mm2	2.15 +/- 0.05 [.085 +/- .002]	5.5

**\*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 PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- 6. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.

LOC	DIST	REVISIONS					
A	66	P	LTN	DESCRIPTION	DATE	OWN	APVD
		A2		ECR-18-010160	29JUN2018	FZ	KZ
		B		ECR-18-011222	16JUL2018	KH	CT
		C		ECR-19-002536	18FEB2019	TB	CT
		D		ECR-19-009012	08JUN2019	TB	TE

-	1	1	2119641-1	FEED CAM, AIR FEED	248	
-	1	1	2119082-6	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	1-356885-5	STOP, SHEAR	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	2844908-1	SCREW, LOCKING	99	
-	1	1	2844907-1	POST, LOCKING	98	
-	1	1	690438-6	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	
-	1	1	1-455888-7	SPACER, CRIMPER	82	
-	1	1	8-240641-5	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	2-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 14	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	
-	2	2	1-2168083-3	SCR, SKT HD CAP, RoHS, M3 X 16	33	
-	1	1	1-2305692-9	PLATE, REAR STRIP GUIDE	29	
-	2	2	22284-1	SPRING, COMPRESSION	27	
-	1	1	356835-1	LEVER, DRAG RELEASE	26	
-	1	1	240792-1	DRAG, TERMINAL	25	
-	1	1	1-189124-2	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	
-	3	3	1-18028-2	WASHER, FLAT, REG M4	20	
-	1	1	2119533-2	STRIPPER, SIDE FEED	19	
-	1	1	1673662-1	FLOATING SHEAR, REAR	17	
-	2	2	1-2168083-1	SCR, SKT HD CAP, RoHS, M3 X 6	16	
-	1	1	1673661-1	SHEAR PLATE, REAR	15	
-	1	1	1803345-1	SHEAR HOLDER, REAR	14	
-	2	2	3-22280-3	SPRING, COMPRESSION	12	
-	-	-	-	-	10	
-	-	-	-	-	9	
-	1	2	1	5-1633930-6	ANVIL, COMBINATION	8
-	-	-	-	-	7	
-	1	1	1	1-690468-5	DEPRESSOR SHEAR, REAR	6
-	-	-	-	-	5	
-	1	1	1	4-238011-5	BLOCK, CRIMPER SPACER	4
-	1	2	1	7-1633966-1	CRIMPER, INSULATION O	3
-	1	1	1	1-455888-2	SPACER, CRIMPER	2
-	1	2	1	1-456411-8	CRIMPER, WIRE PREMIUM	1

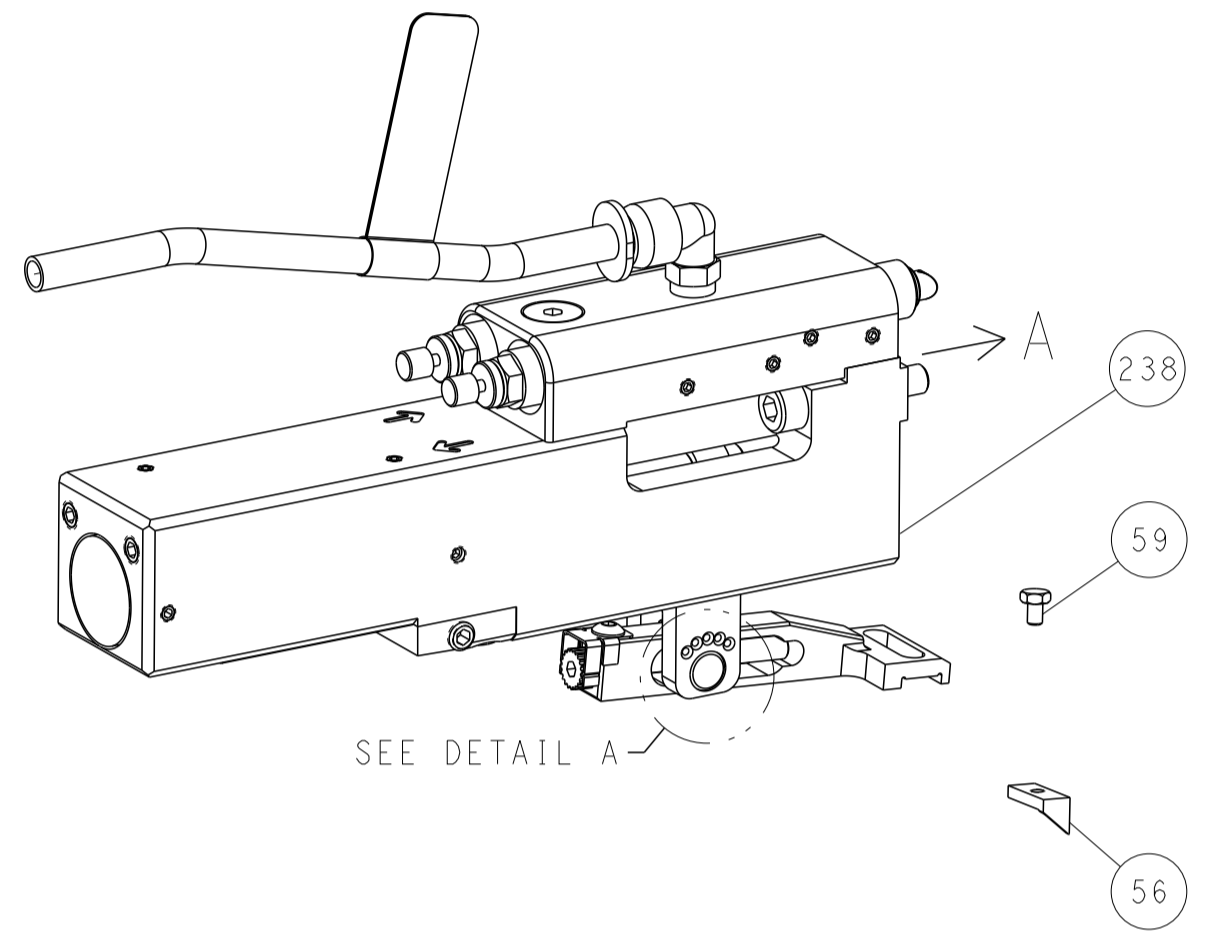
ATLANTIC VERSION  
Shown on sheets 1 of 4 & 2 of 4  
(Pacific version shown on sheets 3 of 4 & 4 of 4)

DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG: BOB HIGMAN 28DEC2015		CHK: T. ELBIN 28DEC2015		APVD: T. ELBIN 28DEC2015		NAME: Ocean Side Feed Applicator	
0 PLC ±		1 PLC ±		2 PLC ±		3 PLC ±		4 PLC ±		RESTRICTED TO	
MATERIAL:		FINISH:		WEIGHT:		SCALE: 1:2		SHEET 1 OF 4		REV D	

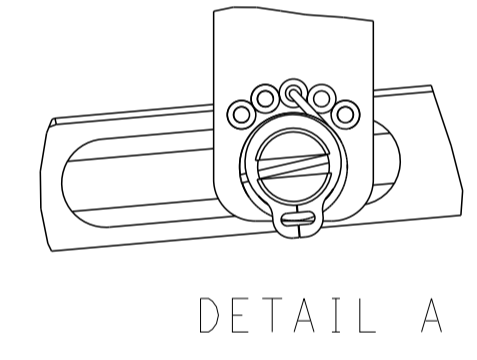
Customer Accessible Production Drawing

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

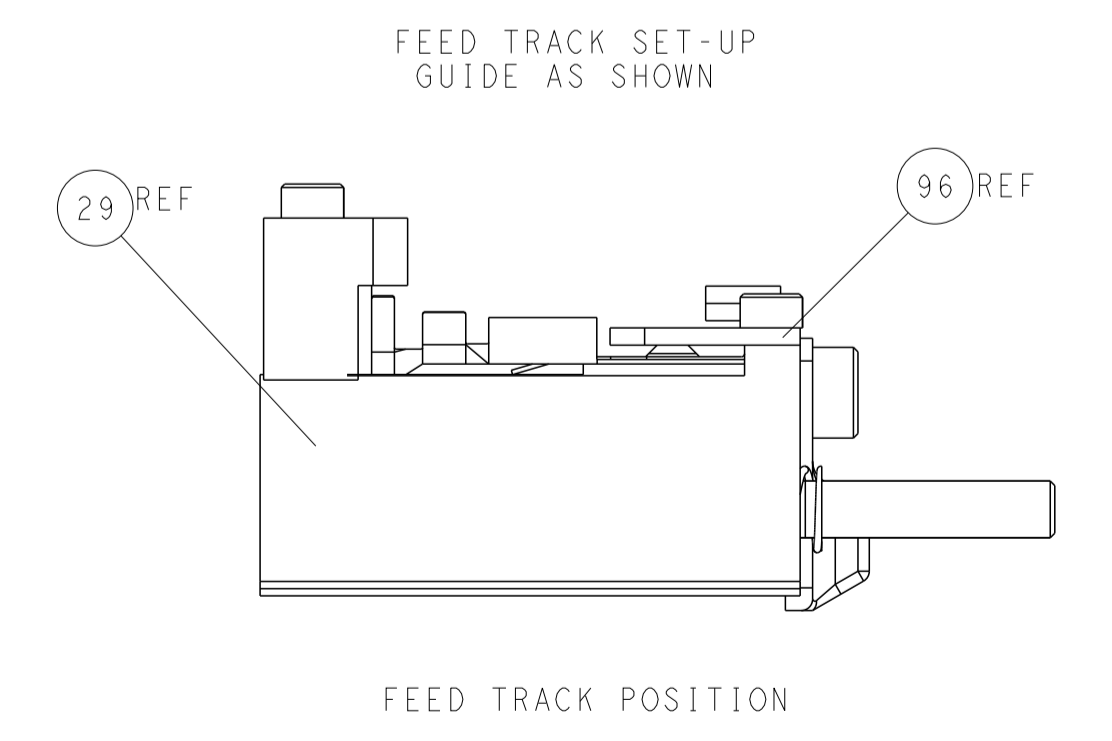
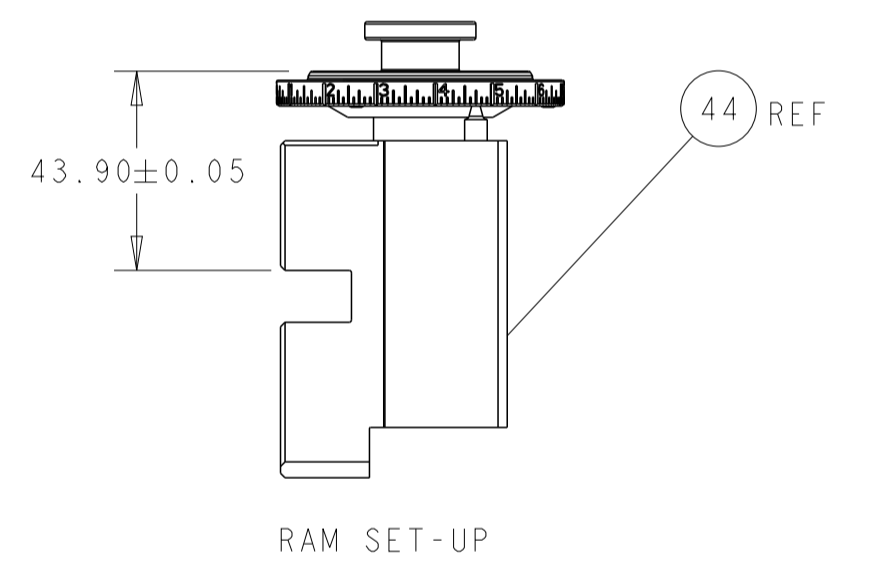
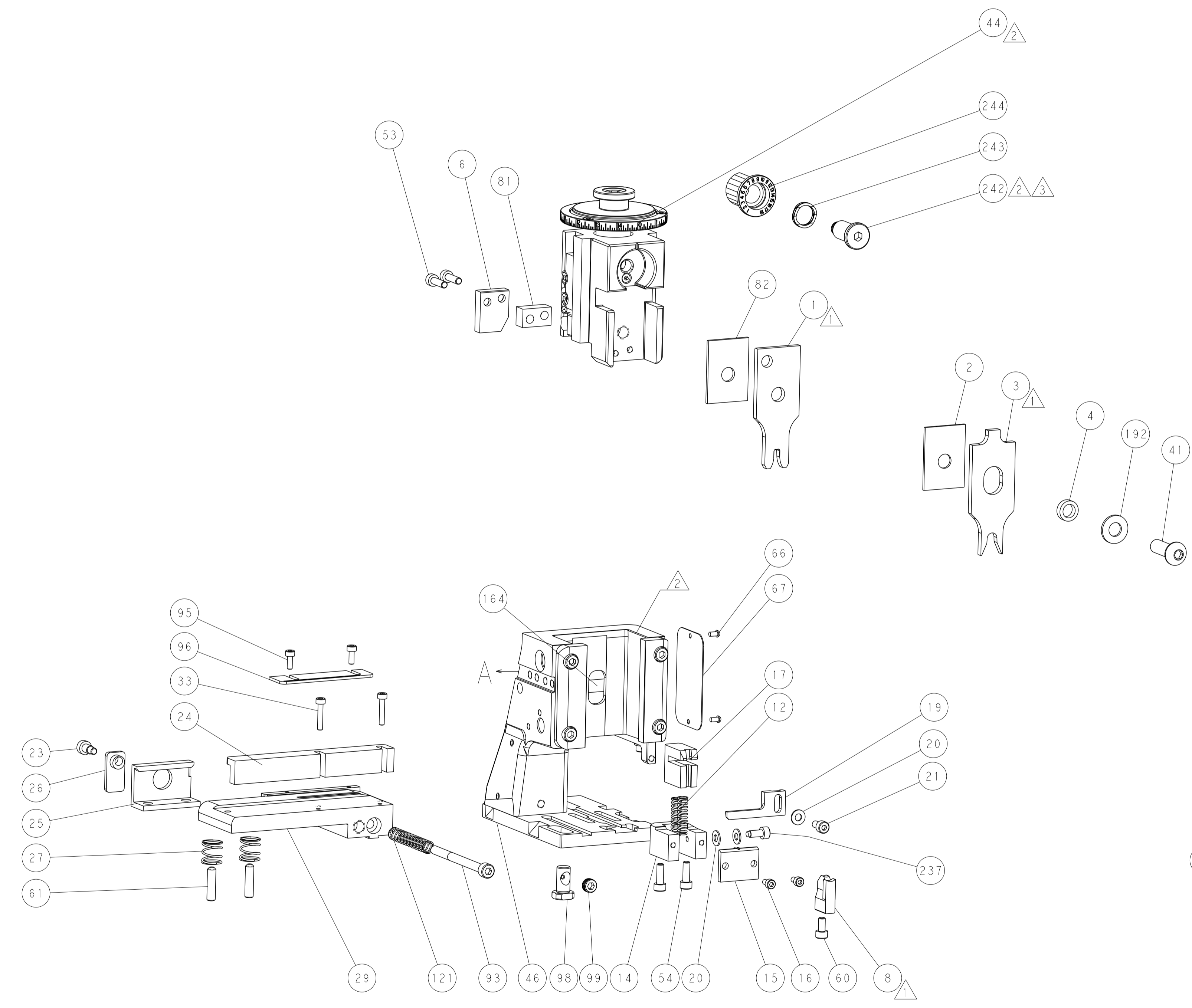
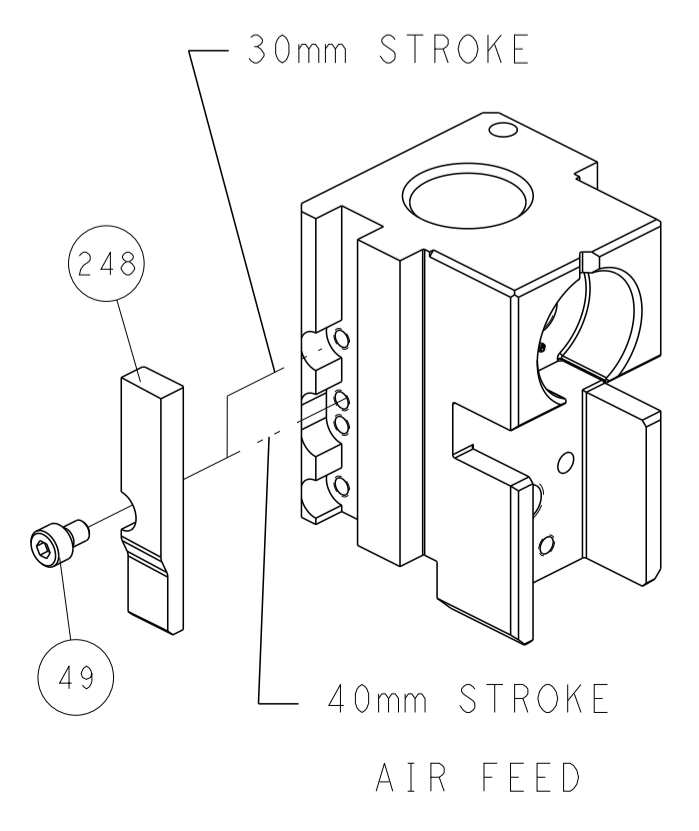
### FEED TYPE PNEUMATIC



### FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



### CAM POSITION



**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 UNPUBLISHED. RELEASED FOR PUBLICATION BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.</small>		DWN BOB HIGMAN 28DEC2015 CHK T. ELBIN 28DEC2015 APVD T. ELBIN 28DEC2015	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 PRODUCT SPEC APPLICATION SPEC SIZE CAGE CODE DRAWING NO. RESTRICTED TO A1 00779 C=2836131	WEIGHT SCALE 1:2 SHEET 2 OF 4 REV D
MATERIAL:		Customer Accessible Production Drawing	

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2836131-2	D	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2836131-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR  
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	3.56 mm [.140]	F
INSUL	6.50 mm [.256]	O

APPLICATOR INSTRUCTIONS  
408-35042

TERMINAL DATA: DELPHI TERMINAL DELPHI CRIMP SPECIFICATION				
TERMINAL NAME: F M/P 480 TERMINAL				
WIRE STRIP LENGTH	TERMINAL INSULATION DIAMETER RANGE			
5.05-5.81 mm [.199-.229 IN]	∅ .137-.206 IN [3.49-5.24 mm]			
TERMINAL APPLICATION SPECIFICATION (A) SHEET PAGE 11 Rev 2013-10-30				
TERMINALS APPLIED				
TE TERMINAL	DELPHI TERMINAL	TE SEAL	DELPHI SEAL	SEAL INSULATION DIAMETER RANGE
(A) 1572196-1	(A) 12052139	(A) 1572026-1	(A) 15324989	2.7-3.8mm
		(A) 2113971-1	(A) 15324990	3.6-4.5mm
		(A) 1572197-1	(A) 12048443	3.6-4.5mm

TERMINAL DATA: DELPHI TERMINAL DELPHI CRIMP SPECIFICATION				
TERMINAL NAME: F M/P 480 TERMINAL				
WIRE STRIP LENGTH	TERMINAL INSULATION DIAMETER RANGE			
5.05-5.81 mm [.199-.229 IN]	∅ 3.49-5.24 mm [.137-.206 IN]			
TERMINAL APPLICATION SPECIFICATION (B) SHEET PAGE 12 OF 15 Rev 2013-10-30				
TERMINALS APPLIED				
TE TERMINAL	DELPHI TERMINAL	TE SEAL	DELPHI SEAL	SEAL INSULATION DIAMETER RANGE
(B) 1572196-1	(B) 12052139	(B) 1572026-1	(B) 15324989	2.7-3.8mm
		(B) 2113971-1	(B) 15324990	3.6-4.5mm

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
4.00mm2	2.10 +/- 0.05 [.083 +/- .002]	6.0

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
4.00mm2	2.30 +/- 0.05 [.091 +/- .002]	4.0
3.00mm2	2.15 +/- 0.05 [.085 +/- .002]	5.5

- 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.
  - 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.
  - TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
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.

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

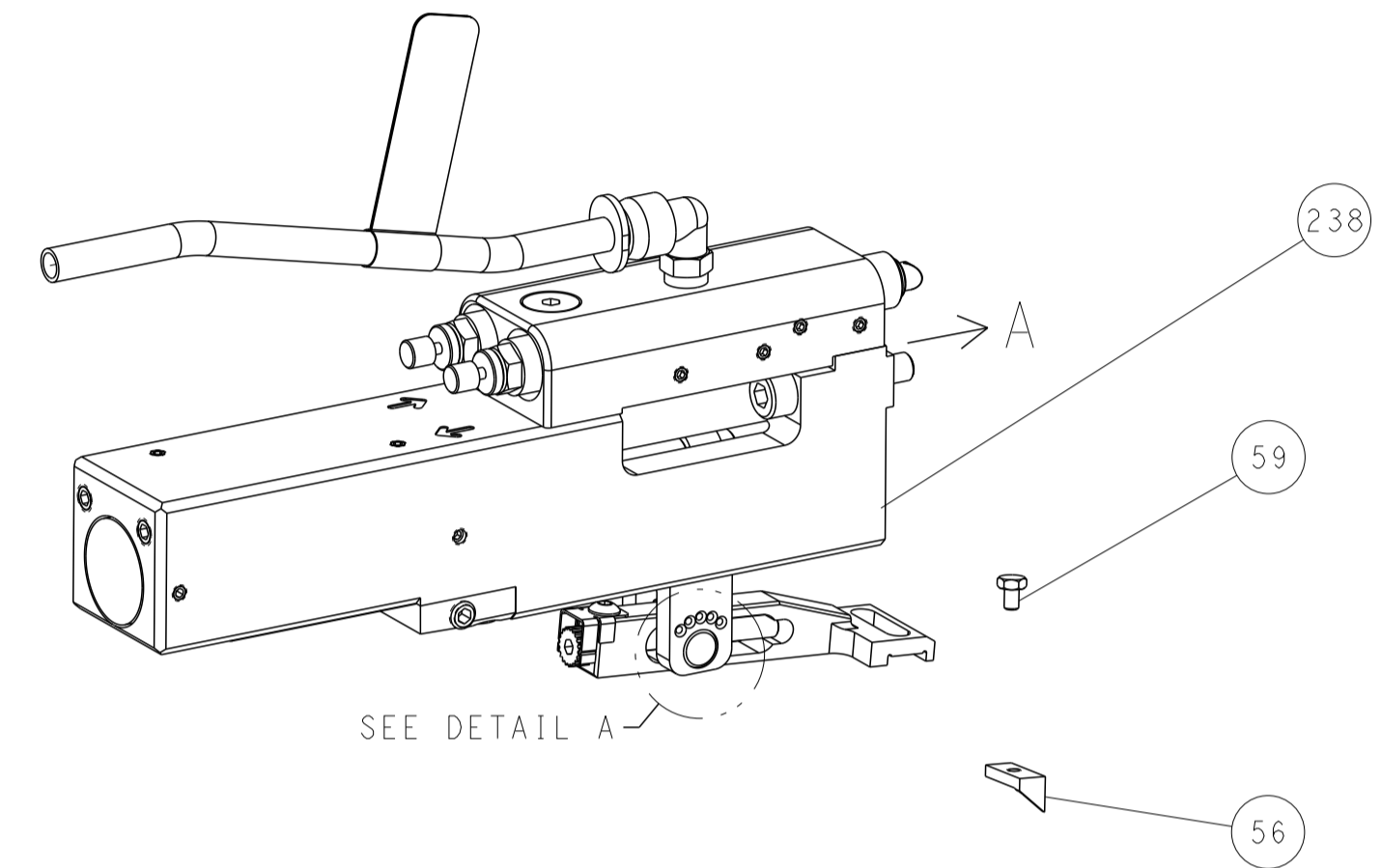
-	1	2119082-6	CAM, SNAIL, INSULATION ADJUSTMENT	244	
-	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243	
-	1	2119083-1	RETAINER, INSULATION DIAL	242	
-	1	2844940-1	AIR FEED MODULE	238	
-	1	1-356885-5	STOP, SHEAR	237	
-	1	1-18028-0	WASHER, FLAT, REG M8	192	
-	REF	994970-2	COUNTER, MAGNETIC	164	
-	1	2119641-2	FEED CAM, AIR FEED	151	
-	1	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	144	
-	2	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	143	
-	1	1-1803583-0	APPLICATOR BASIC ASSEMBLY, SF	141	
-	1	1803516-1	RAM ASSEMBLY, SF PACIFIC	140	
-	1	1-22281-8	SPRING, COMPRESSION	121	
-	1	2844908-1	SCREW, LOCKING	99	
-	1	2844907-1	POST, LOCKING	98	
-	1	690438-6	FRONT STRIP GUIDE	96	
-	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	95	
-	1	2168083-6	SCR, SKT HD CAP, RoHS, M5 X 65	93	
-	1	1-455888-7	SPACER, CRIMPER	82	
-	1	8-240641-5	SPACER	81	
-	1	1803607-3	DOCUMENTATION PACKAGE	71	
-	1	2119740-1	TAG, IDENTIFICATION	67	
-	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66	
-	2	2-18032-5	SCR, SET, FLT PNT, M5 X 20.0	61	
-	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59	
-	1	1338683-1	FEED PAWL	56	
-	2	2-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 14	53	
-	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49	
-	1	1803583-9	APPLICATOR BASIC ASSEMBLY, SF	46	
-	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41	
-	2	1-2168083-3	SCR, SKT HD CAP, RoHS, M3 X 16	33	
-	1	1-2305692-9	PLATE, REAR STRIP GUIDE	29	
-	2	22284-1	SPRING, COMPRESSION	27	
-	1	356835-1	LEVER, DRAG RELEASE	26	
-	1	240792-1	DRAG, TERMINAL	25	
-	1	1-189124-2	GUIDE, FRONT STRIP	24	
-	1	980371-4	SCR, SKT HD SHLDR 5.0 DIA X 6.0	23	
-	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21	
-	3	1-18028-2	WASHER, FLAT, REG M4	20	
-	1	2119533-2	STRIPPER, SIDE FEED	19	
-	1	1673662-1	FLOATING SHEAR, REAR	17	
-	2	1-2168083-1	SCR, SKT HD CAP, RoHS, M3 X 6	16	
-	1	1673661-1	SHEAR PLATE, REAR	15	
-	1	1803345-1	SHEAR HOLDER, REAR	14	
-	2	3-22280-3	SPRING, COMPRESSION	12	
-	-	-	-	10	
-	-	-	-	9	
-	1	1-5-1633930-6	ANVIL, COMBINATION	8	
-	-	-	-	7	
-	1	1-690468-5	DEPRESSOR SHEAR, REAR	6	
-	-	-	-	5	
-	1	4-238011-5	BLOCK, CRIMPER SPACER	4	
-	1	1-7-1633966-1	CRIMPER, INSULATION O	3	
-	1	1-455888-2	SPACER, CRIMPER	2	
-	1	1-456411-8	CRIMPER, WIRE PREMIUM	1	
-	77	22	PART NO	DESCRIPTION	ITEM NO

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

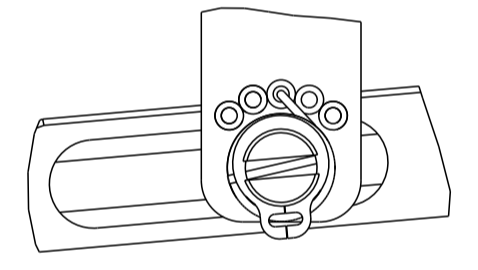
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG: BOB HIGMAN 28DEC2015		TE Connectivity Harrisburg, PA 17105-3608	
0 PLC ±		1 PLC ±		CHK: T. ELBIN 28DEC2015		NAME: Ocean Side Feed Applicator	
2 PLC ±		3 PLC ±		APVD: T. ELBIN 28DEC2015		SIZE: A1	
4 PLC ±		ANGLES FINISH		PRODUCT SPEC		CAGE CODE: 00779	
MATERIAL		FINISH		APPLICATION SPEC		DRAWING NO: 2836131	
				WEIGHT		SCALE: 1:2	
				RESTRICTED TO		SHEET 3 OF 4	
				Customer Accessible Production Drawing		REV D	

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

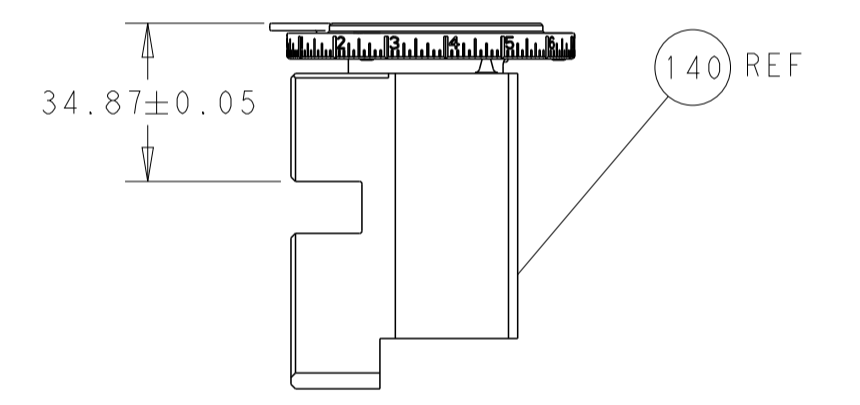
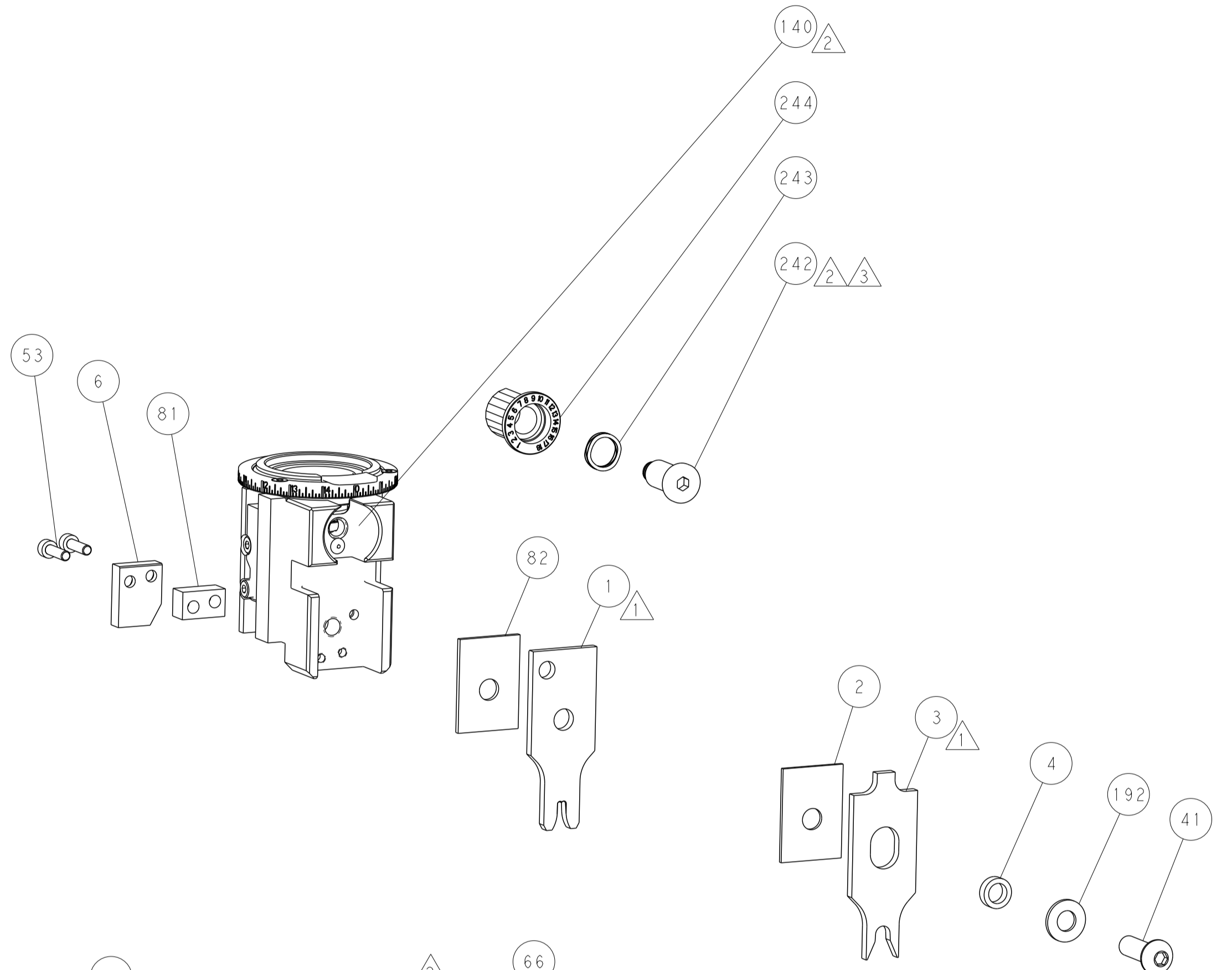
### FEED TYPE PNEUMATIC



### FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)

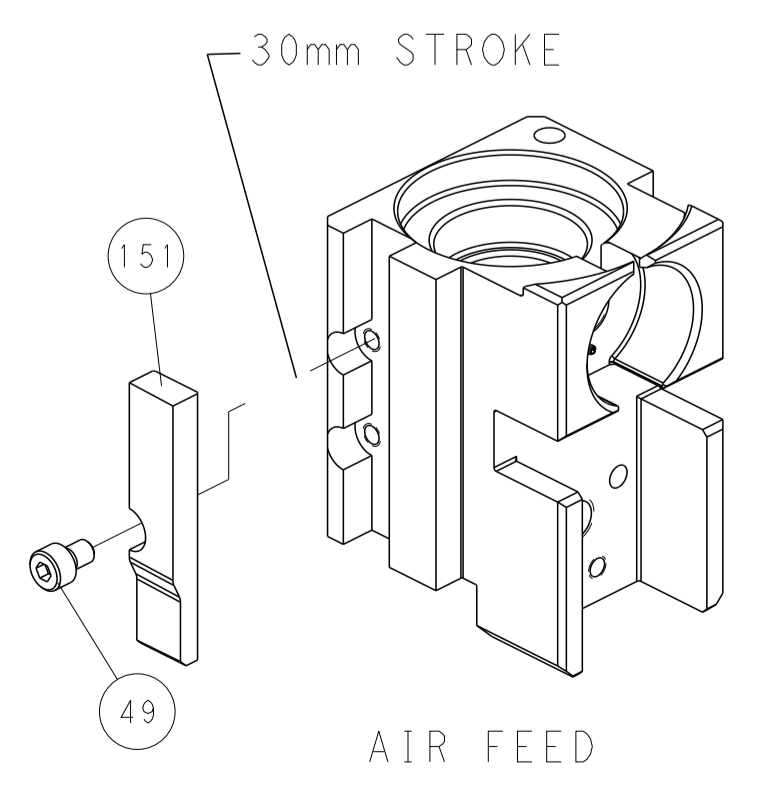


DETAIL A

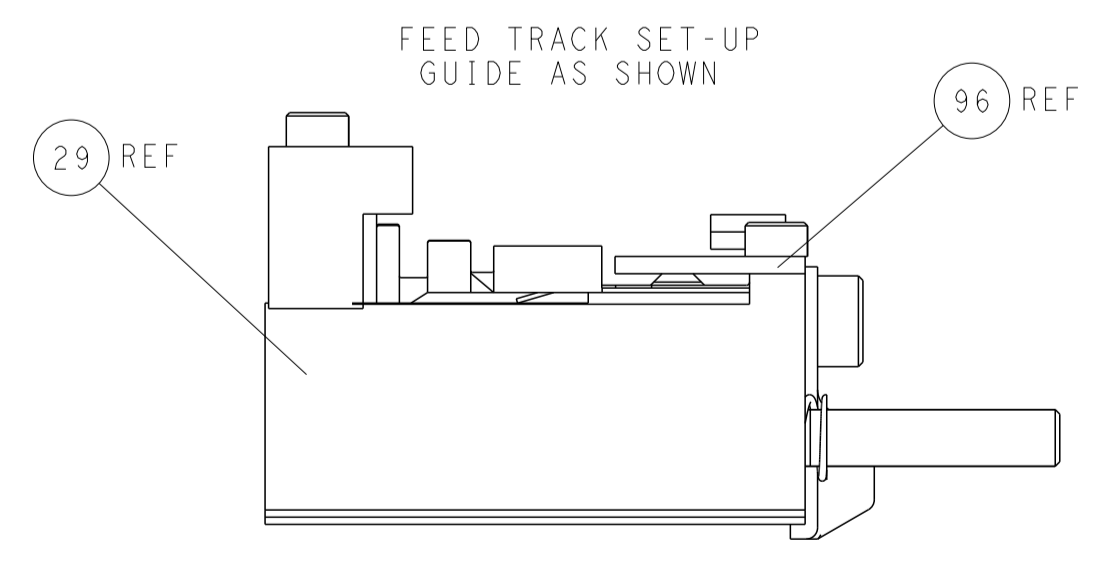
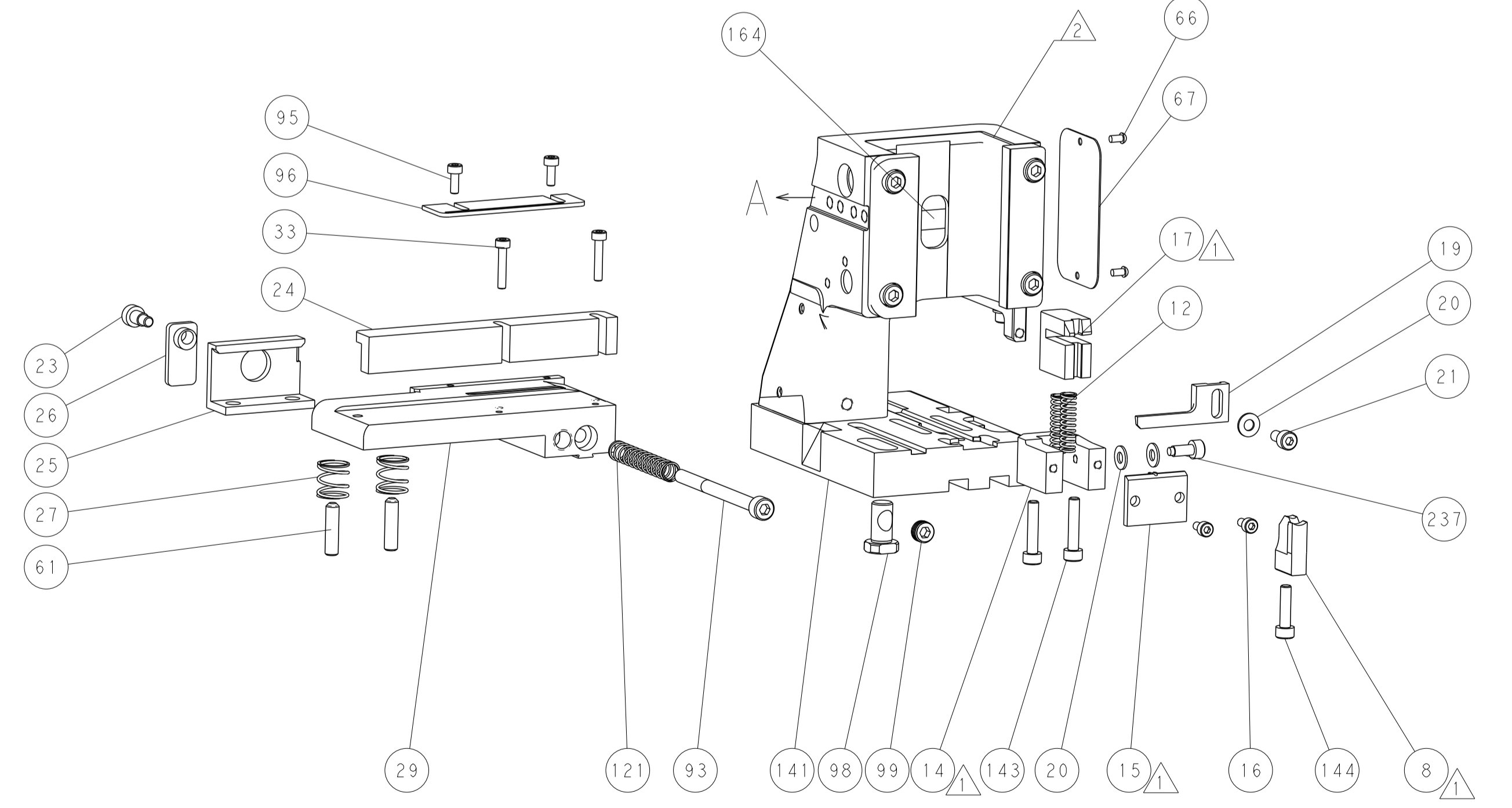


RAM SET-UP

### CAM POSITION



AIR FEED



FEED TRACK 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 UNPUBLISHED. RELEASED FOR PUBLICATION. IT IS THE PROPERTY OF TYCO ELECTRONICS CORPORATION. IT IS TO BE USED ONLY FOR THE PURPOSES AND IN THE QUANTITIES SPECIFIED IN THE ORDER. IT IS TO BE RETURNED TO TYCO ELECTRONICS CORPORATION IF NOT SO USED.</small>		DWN BOB HIGMAN 28DEC2015 CHK T. ELBIN 28DEC2015 APVD T. ELBIN 28DEC2015	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 PRODUCT SPEC APPLICATION SPEC	SIZE A1 CAGE CODE 00779 DRAWING NO. C-2836131 RESTRICTED TO
MATERIAL:		WEIGHT:	SCALE 1:2 SHEET 4 OF 4 REV D