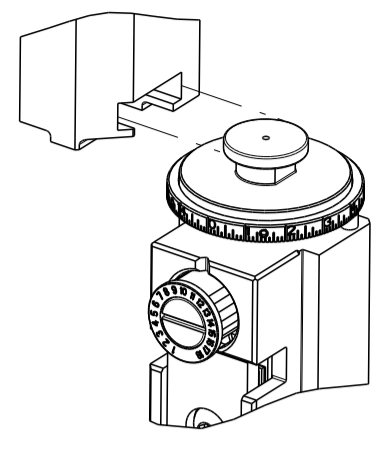


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2836390-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2836390-2	B	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2836390-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.03 mm [.080]	F
INSUL	3.25 mm [.128]	O

APPLICATOR INSTRUCTIONS 408-35042

TERMINAL DATA: DELPHI TERMINAL DELPHI CRIMP SPECIFICATION	
TERMINAL NAME: MALE TERMINAL DCS2-1.5 APPLICATION WITH SWS	
WIRE STRIP LENGTH 3.90-4.70 mm [.154-.185 IN]	INSULATION DIAMETER RANGE Ø1.40-2.15 mm [.055-.085 IN]
TERMINAL APPLICATION SPECIFICATION 9 084 10 00 Rev K	

TERMINALS APPLIED					SEAL INSULATION DIAMETER RANGE
TE TERMINAL	DELPHI TERMINAL	TE SEAL	DELPHI SEAL		
2303630-1	60102031	1949393-1	60993913		Ø1.1-1.6
2303630-2	60102034	1949393-2	60993928		Ø1.6-1.9
2303630-3	60100731	1949393-3	60993934		Ø1.9-2.4
2303630-4	60100734	963530-1			Ø1.4-1.9
2303630-5	60101334	964972-1			Ø1.9-2.4

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.00mm2	1.25+/-0.04 [.049+/-0.002]	7.9
18 AWG	1.25+/-0.04 [.049+/-0.002]	7.8
0.75mm2	1.20+/-0.04 [.047+/-0.002]	8.3
20 AWG	1.20+/-0.04 [.047+/-0.002]	8.3
0.50mm2	1.17+/-0.04 [.046+/-0.002]	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. APPLY TORQ-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.
- 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.

LOC	DIST	REVISIONS					
A	66	P	LTN	DESCRIPTION	DATE	DWN	APVD
		A		RELEASE	27JUL2016	MZ	GB
		B		ECR-22-137477	28APR2022	JWC	RK
		B1		ECR-22-155285	12OCT2022	FZ	JAH

-	1	1	2119641-1	FEED CAM, AIR FEED	248
-	1	1	2119082-4	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
3	-	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
-	1	1	2844940-1	AIR FEED MODULE	238
-	REF	REF	994970-2	COUNTER, MAGNETIC	164
5	-	1	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113
-	1	1	2844908-1	SCREW, LOCKING	99
-	1	1	2844907-1	POST, LOCKING	98
-	1	1	455888-8	SPACER, CRIMPER	82
-	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
-	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
6	-	1	985575-3	SCR, FLT SKT HD CAP M3 X 10.0	57
-	1	1	1338683-8	FEED PAWL	56
-	4	4	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	54
-	2	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	53
-	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	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	1-1752356-7	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	2844992-2	ASSEMBLY, STRIP GUIDE	29
-	1	1	455888-3	SPACER, CRIMPER	28
-	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	318707-1	FLOATING SHEAR, FRONT	9
1	2	1	6-1633920-6	ANVIL, COMBINATION	8
-	-	-	-	-	7
-	-	-	-	-	6
-	1	1	2119781-2	DEPRESSOR, SHEAR	5
-	1	1	2-238011-1	BLOCK, CRIMPER SPACER	4
1	2	1	3-1803018-3	CRIMPER, INSULATION O	3
-	-	-	-	-	2
1	2	1	1-456405-6	CRIMPER, WIRE PREMIUM	1
-	77-72	-2	PART NO	DESCRIPTION	ITEM NO

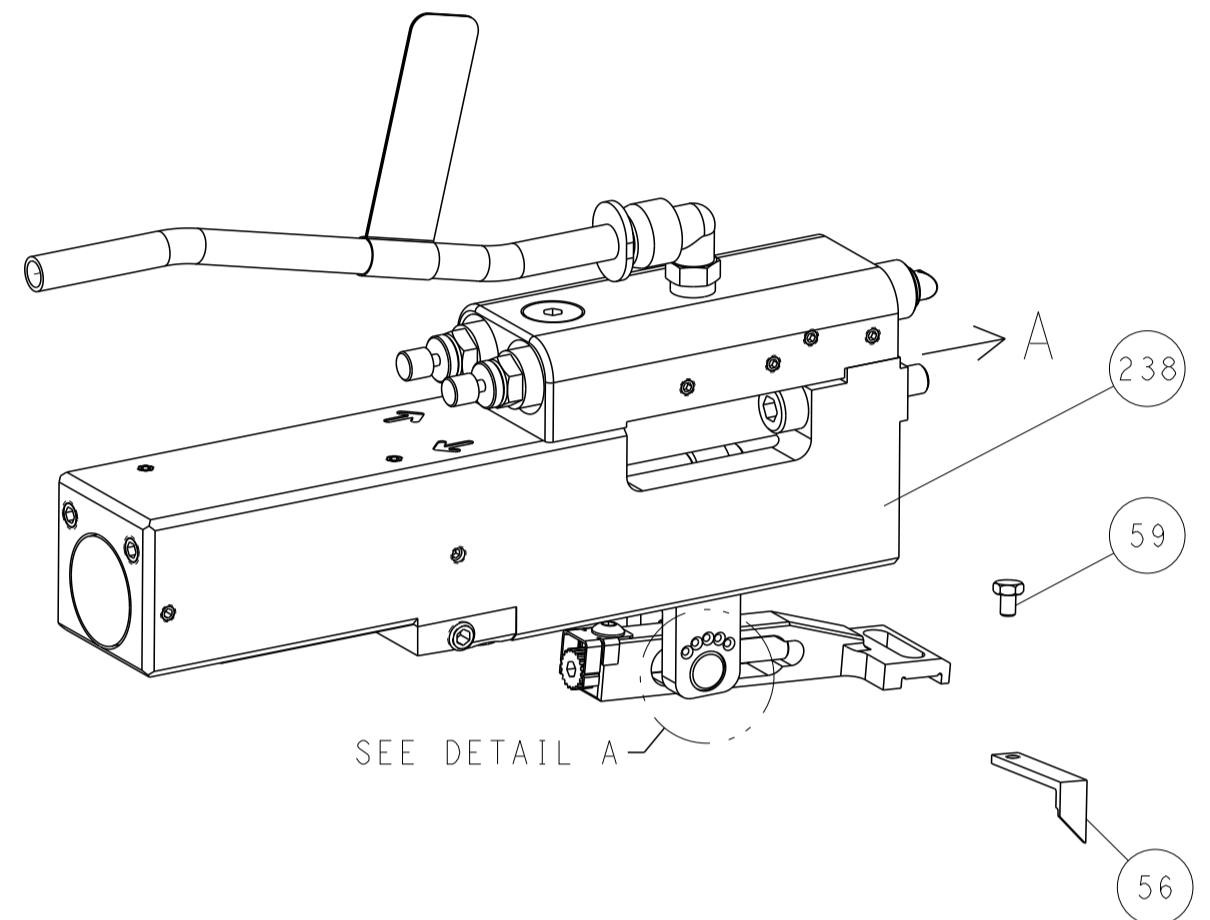
**ATLANTIC VERSION**  
 Shown on sheets 1 of 4 & 2 of 4  
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH		DWN M. ZHAO 27JUL2016 CHK K. ZHANG 27JUL2016 APVD K. ZHANG 27JUL2016		NAME: Ocean Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2836390 RESTRICTED TO:	
MATERIAL: -		FINISH: -		WEIGHT: -		SCALE: 1:2 SHEET 1 OF 4 REV: B1	

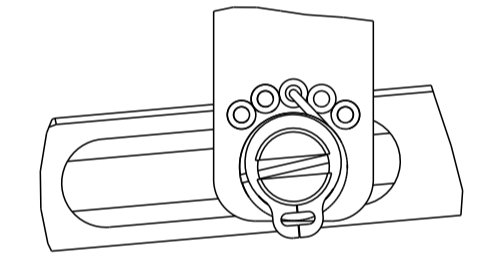
LOC	DIST	REV	DATE	BY	APPV
A	66				

# FEED TYPE

## PNEUMATIC

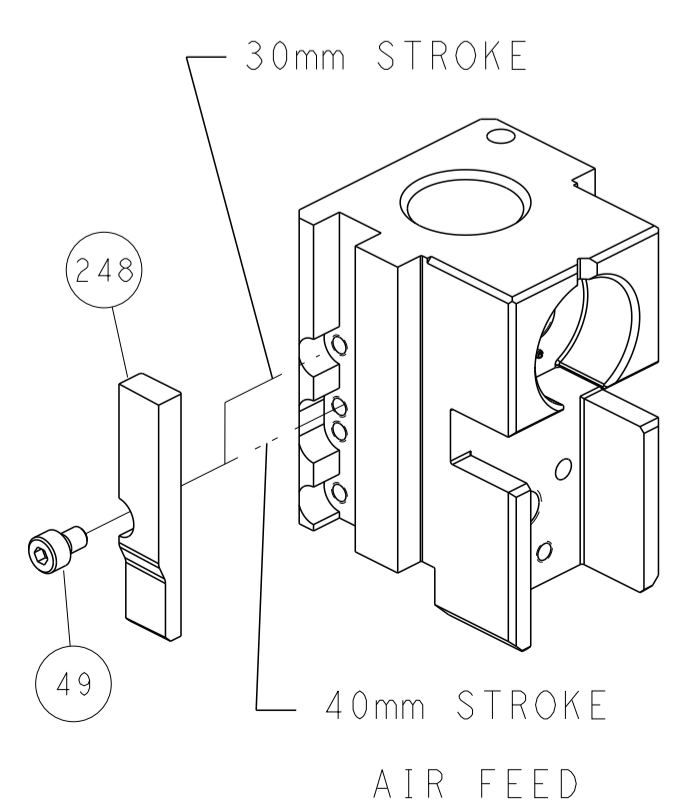


FEED SPRING SETTING POSITION  
(SHOWN FROM REAR SIDE)

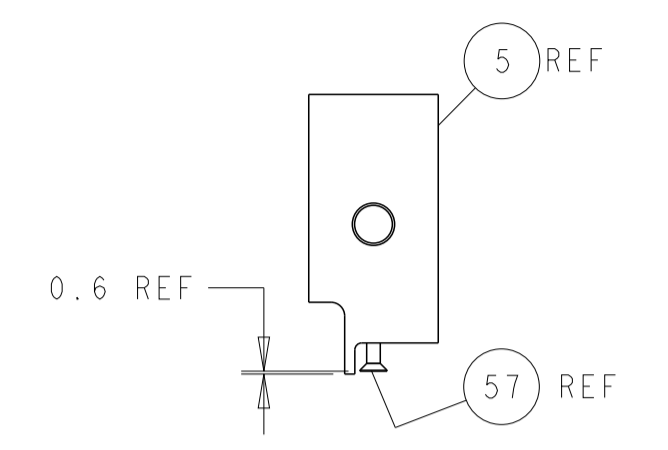
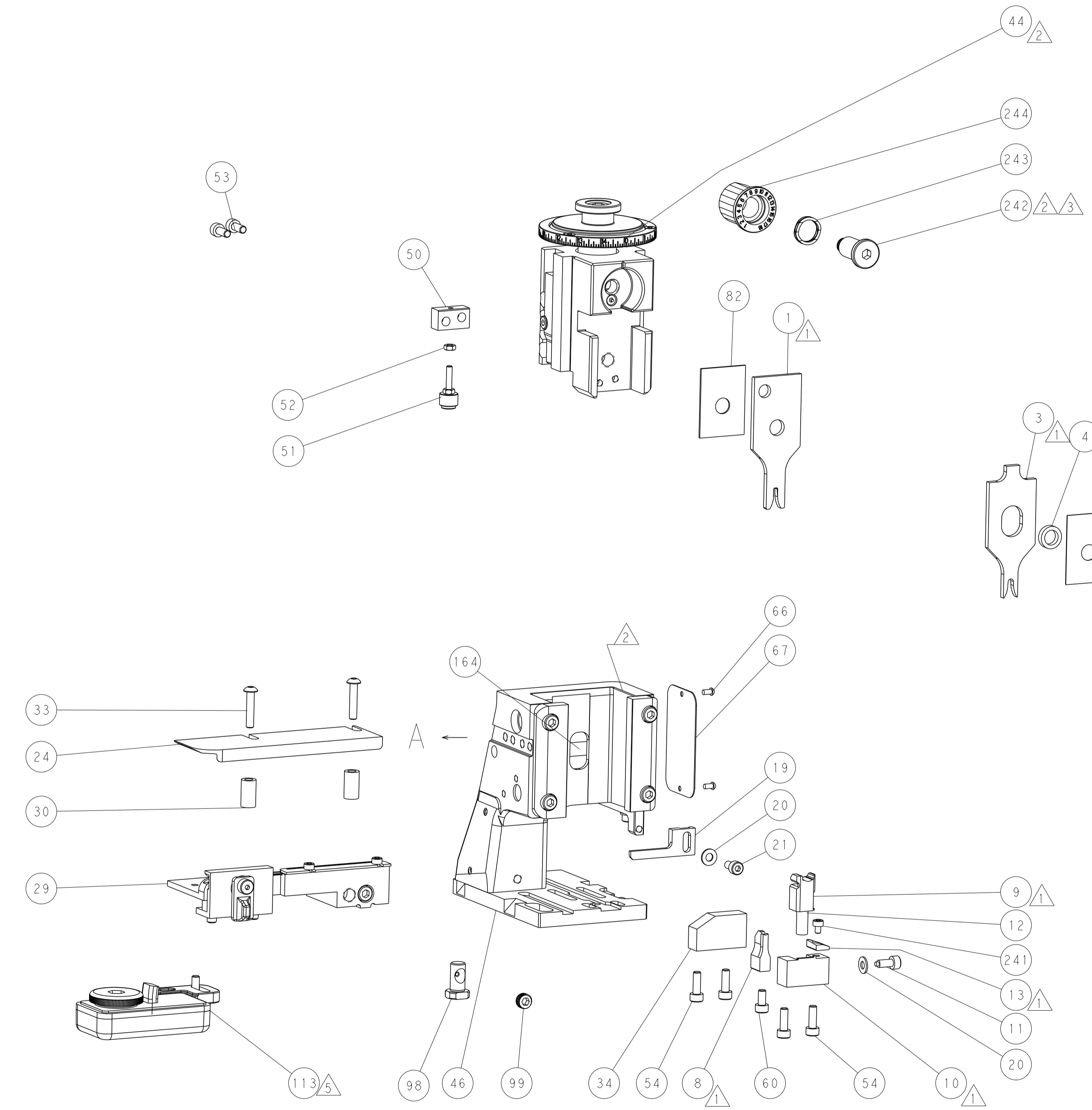


DETAIL A

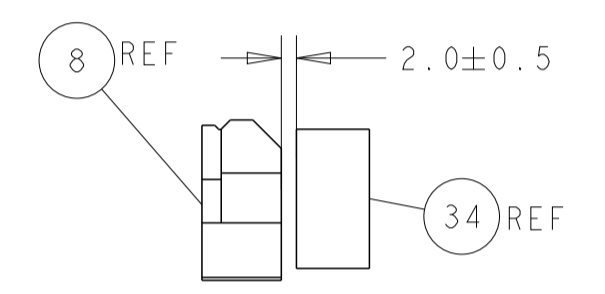
## CAM POSITION



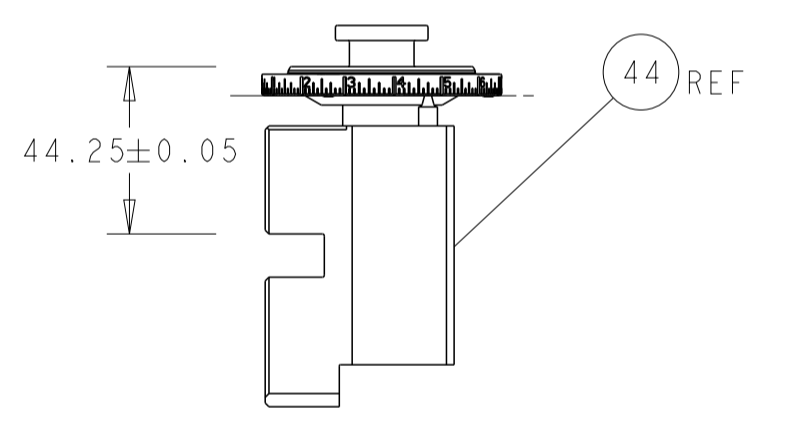
AIR FEED



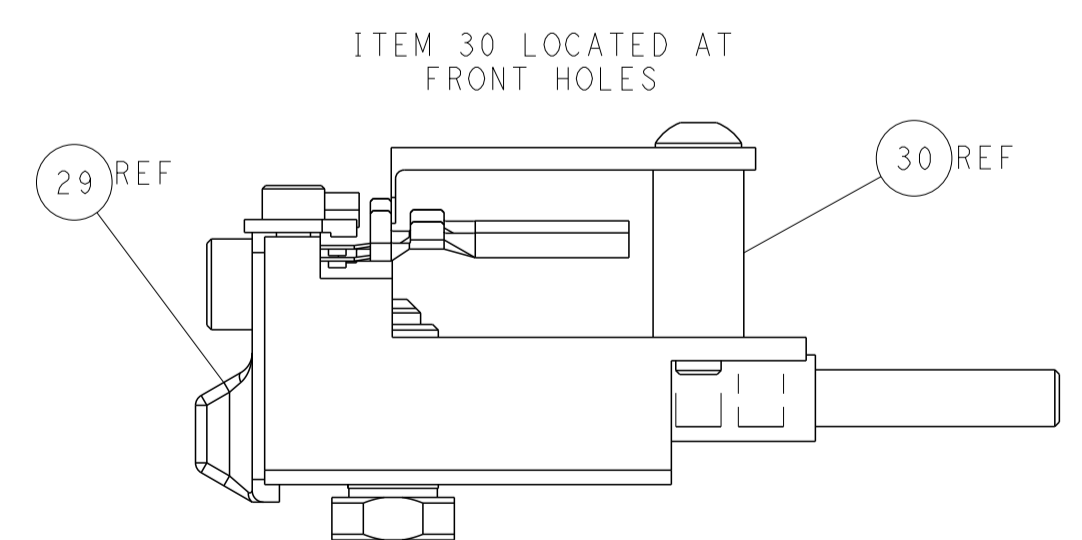
SHEAR DEPRESSOR DETAIL



TERMINAL SUPPORT LOCATION



RAM SET-UP



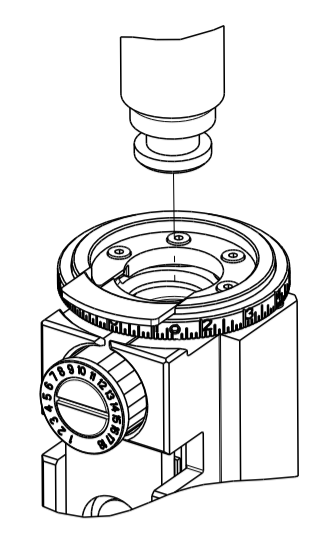
FEED TRACK POSITION  
GUIDE BY INSULATION BARREL

**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:		MATERIAL:		FINISH:		WEIGHT:		SCALE:	
mm	0 PLC	±									
	1 PLC	±									
	2 PLC	±									
	3 PLC	±									
	4 PLC	±									
	ANGLES	±									

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2836390-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2836390-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR  
 INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.03 mm [.080]	F
INSUL	3.25 mm [.128]	O

APPLICATOR INSTRUCTIONS  
 408-35042

TERMINAL DATA: DELPHI TERMINAL DELPHI CRIMP SPECIFICATION  
 TERMINAL NAME: MALE TERMINAL DCS2-1.5 APPLICATION WITH SWS

WIRE STRIP LENGTH	INSULATION DIAMETER RANGE
3.90-4.70 mm [1.54-.185 IN]	∅1.40-2.15 mm [.055-.085 IN]

TERMINAL APPLICATION SPECIFICATION 9 084 10 00 Rev K

TERMINALS APPLIED

TE TERMINAL	DELPHI TERMINAL	TE SEAL	DELPHI SEAL	SEAL INSULATION DIAMETER RANGE
2303630-1	60102031	1949393-1	60993913	∅1.1-1.6
2303630-2	60102034	1949393-2	60993928	∅1.6-1.9
2303630-3	60100731	1949393-3	60993934	∅1.9-2.4
2303630-4	60100734	963530-1		∅1.4-1.9
2303630-5	60101334	964972-1		∅1.9-2.4

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.00mm2	1.25+/-0.04 [.049+/-0.002]	7.9
18 AWG	1.25+/-0.04 [.049+/-0.002]	7.8
0.75mm2	1.20+/-0.04 [.047+/-0.002]	8.3
20 AWG	1.20+/-0.04 [.047+/-0.002]	8.3
0.50mm2	1.17+/-0.04 [.046+/-0.002]	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 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.
7. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.

**\*WARNING**  
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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	REV	DATE	BY	APPV
A	66				

REV	DATE	DESCRIPTION	DATE	BY	APPV
-	1	2119082-4			
-	1	2079764-1			
-	1	2119083-1			
-	1	7-18023-7			
-	1	2844940-1			
-	REF	994970-2			
-	1	2119641-2			
-	1	2168083-8			
-	4	2168083-9			
-	1	1-1803583-0			
-	1	1803516-1			
-	1	2119955-1			
-	1	2844908-1			
-	1	2844907-1			
-	1	455888-8			
-	1	1803607-3			
-	1	2119740-1			
-	2	2168078-1			
-	1	5-18022-5			
-	1	985575-3			
-	1	1338683-8			
-	2	1-2168083-0			
-	1	5018030-1			
-	1	811242-5			
-	1	690753-2			
-	1	18023-9			
-	1	1803602-1			
-	1	1-1752356-7			
-	2	2079383-5			
-	2	2-2844962-8			
-	1	2844992-2			
-	1	455888-3			
-	1	1320928-2			
-	1	2168083-2			
-	2	1-18028-2			
-	1	2119533-1			
-	1	2119806-1			
-	1	3-22280-3			
-	1	1-356885-4			
-	1	2119805-1			
-	1	318707-1			
1	1	6-1633920-6			
-	-	-			
-	-	-			
-	1	2119781-2			
-	1	2-238011-1			
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1	1	1-456405-6			

ITEM NO	PART NO	DESCRIPTION
-77	-22	PART NO

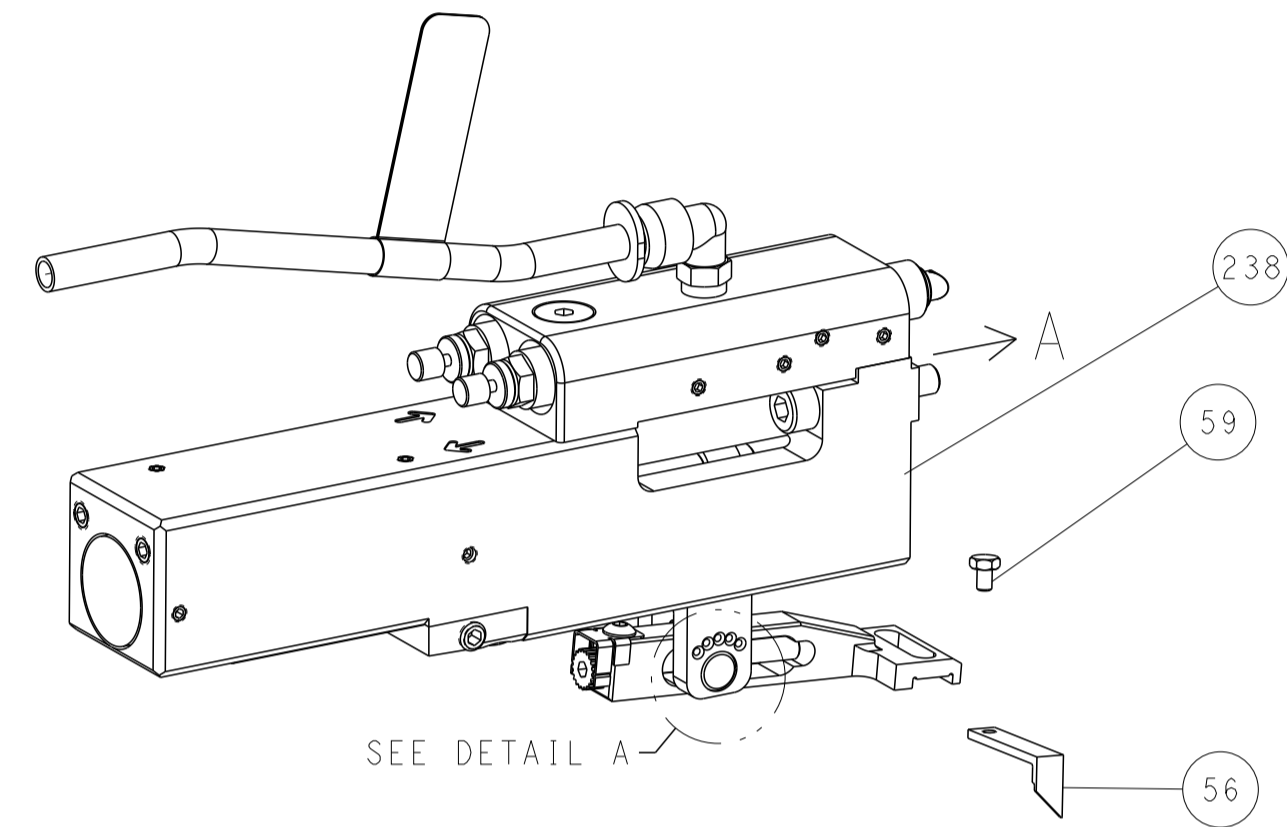
DIMENSIONS: mm 	TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH	DWG: M. ZHAO 27JUL2016 CHK: K. ZHANG 27JUL2016 APVD: K. ZHANG 27JUL2016 PRODUCT SPEC APPLICATION SPEC WEIGHT SCALE: 1:2 SHEET 3 OF 4 REV B1
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Customer Accessible Production Drawing

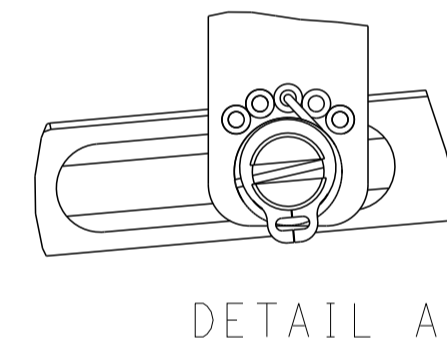
LOC	DIST	REVISIONS					
		P	LTN	DESCRIPTION	DATE	DMN	APVD
A	66	-	-	SEE SHEET 1	-	-	-

### FEED TYPE

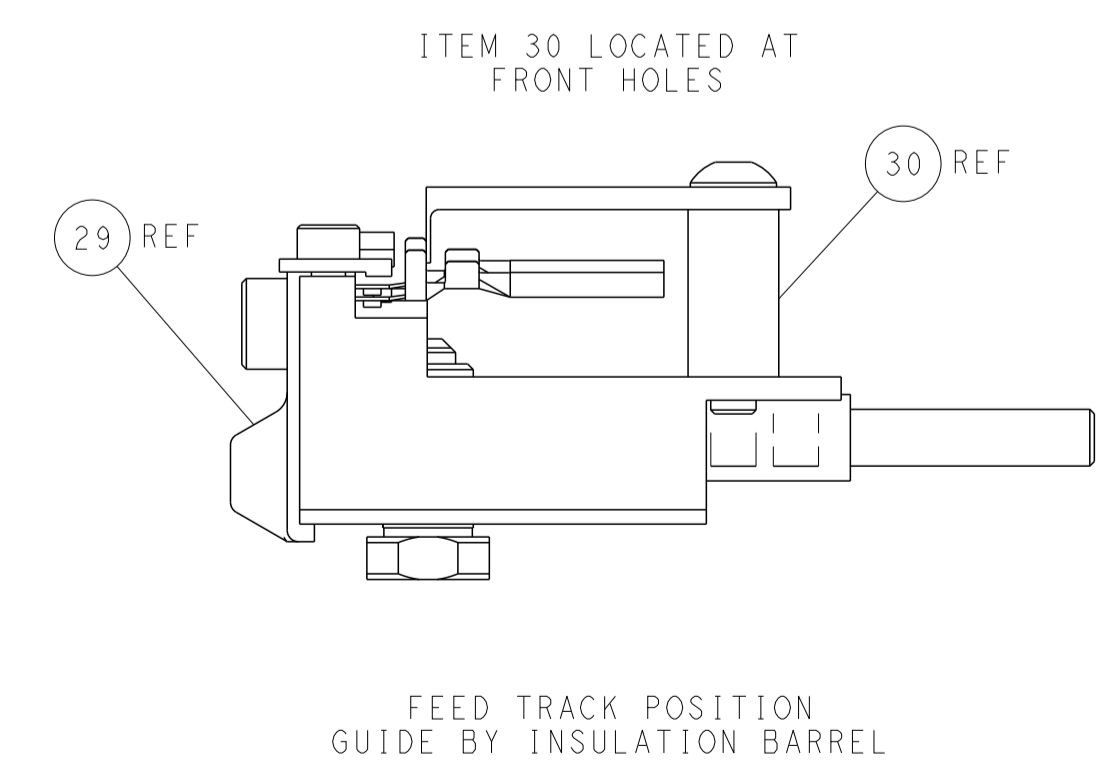
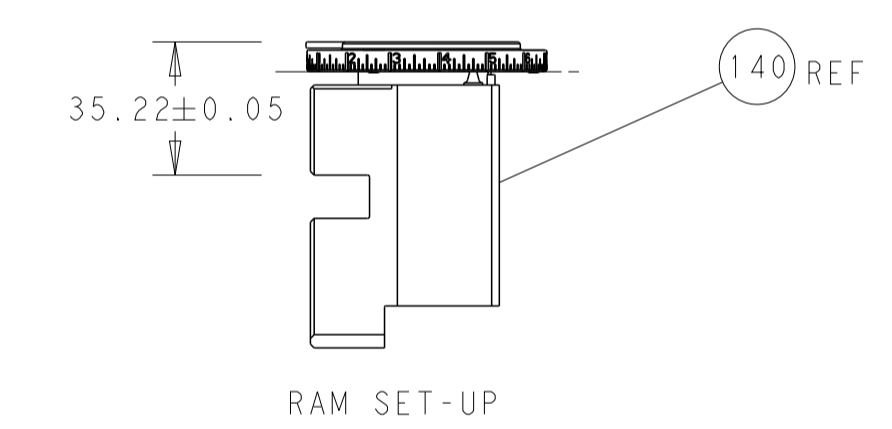
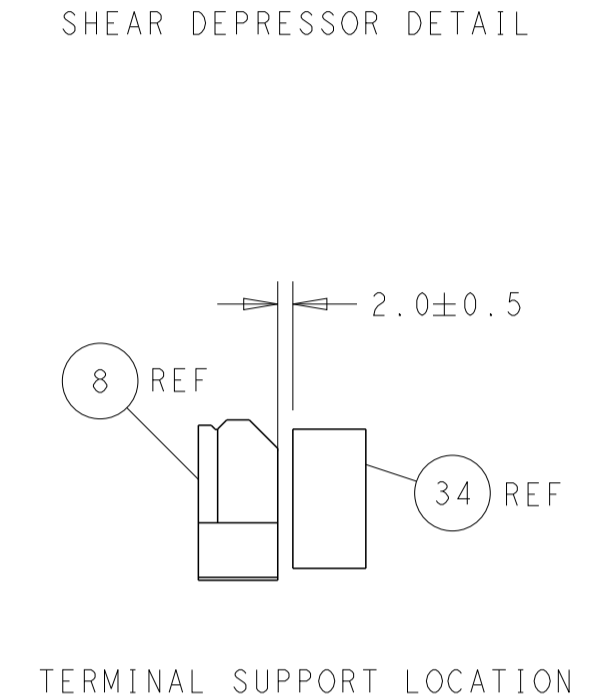
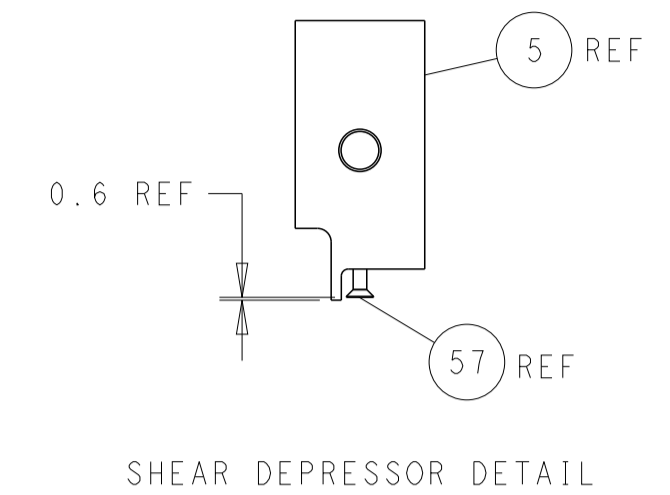
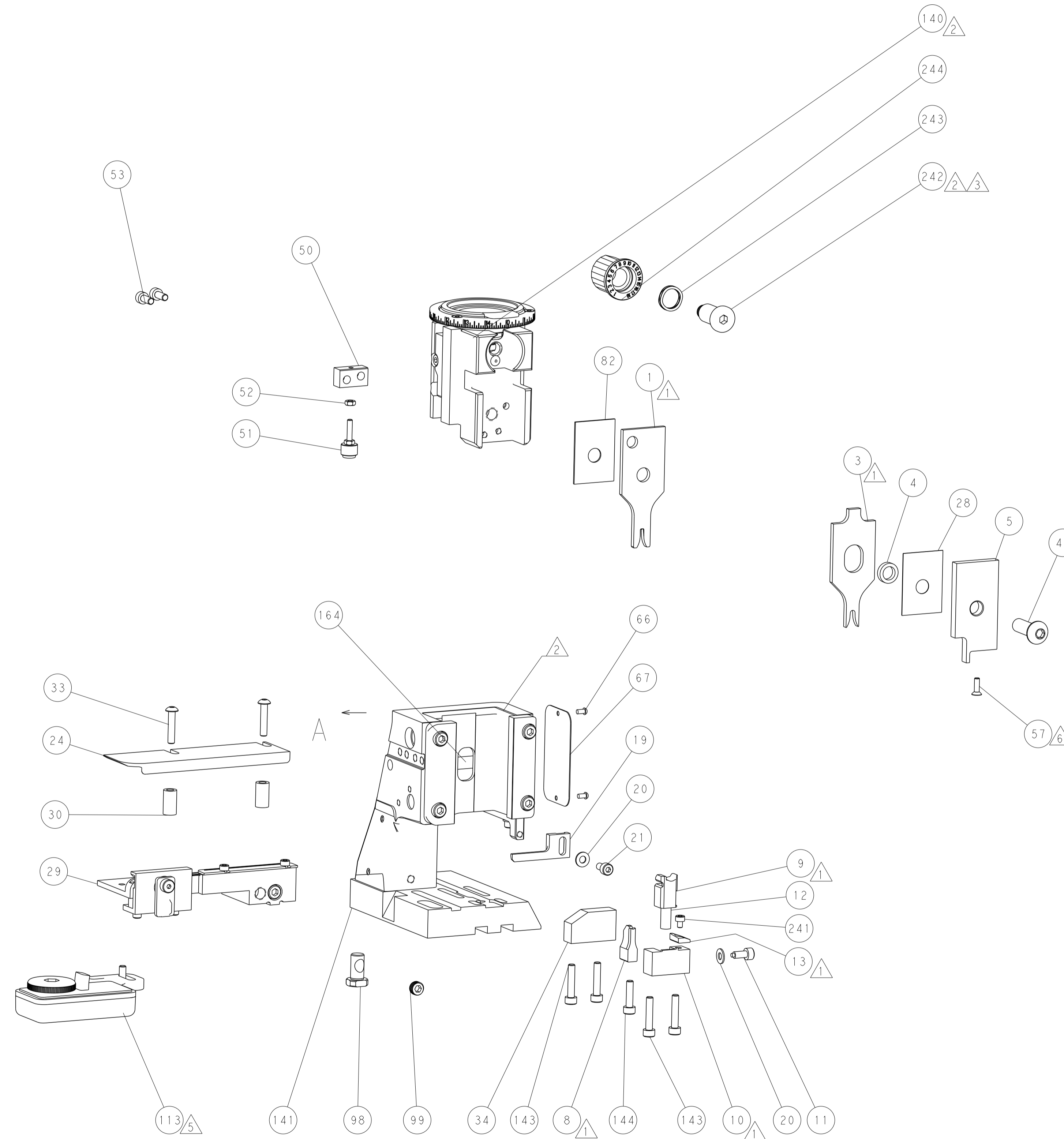
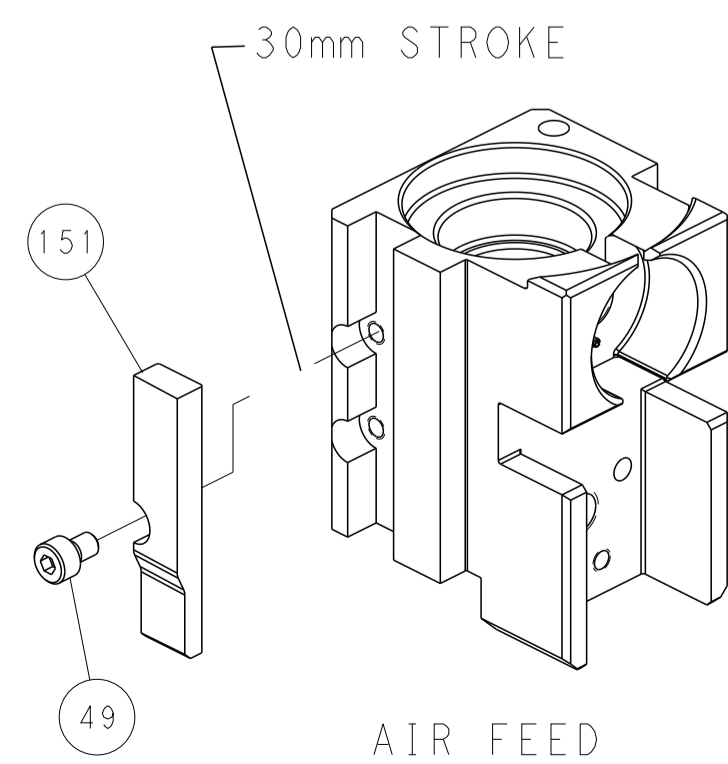
#### PNEUMATIC



#### 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 UNPUBLISHED. RELEASED FOR PUBLICATION. ALL RIGHTS RESERVED. © 2016 BY TYCO ELECTRONICS CORPORATION.</small>		DMN: M. ZHAO 27JUL2016 CHK: K. ZHANG 27JUL2016 APVD: K. ZHANG 27JUL2016	NAME: TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± MATERIAL: - FINISH: -	PRODUCT SPEC: - APPLICATION SPEC: - WEIGHT: - SCALE: 1:2	SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2836390	RESTRICTED TO: - SHEET 4 OF 4 REV B1