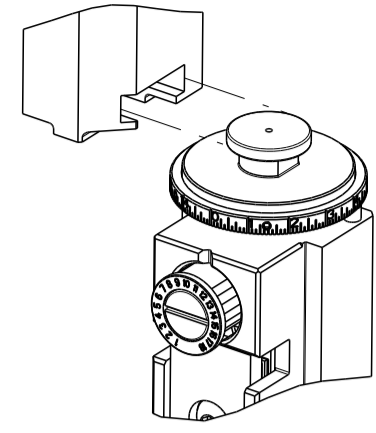


ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



8 7  
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2836389-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2836389-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2836389-1	B	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2836389-2	B	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2836389-7	A	CRIMP TOOLING KIT	-

APPLICATOR DATA

CRIMP	SIZE	TYPE
WIRE	1.60 mm [.063]	F
INSUL	3.10 mm [.122]	O

APPLICATOR INSTRUCTIONS  
408-35042

TERMINAL DATA: DELPHI/FCI TERMINAL DELPHI PACKARD CRIMP SPECIFICATION

TERMINAL NAME: MALE TERMINAL DCS2-1.5 WITH SWS

WIRE STRIP LENGTH	INSULATION DIAMETER RANGE
3.40-4.20 mm [.134-.165 IN]	∅1.20-1.60 mm [.047-.063 IN]

TERMINAL APPLICATION SPECIFICATION 9 084 10 00 Rev K

TERMINALS APPLIED

TE TERMINAL	DELPHI/FCI TERMINAL	TE SEAL	DELPHI/FCI SEAL	SEAL INSULATION DIAMETER RANGE
2303629-1	60102011/14	1949393-1	60993913	1.2-1.6 mm
2303629-2	60100711/14	964971-1		1.2-1.6 mm
2303629-3	60101314			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
22 AWG	1.01±/-0.03 [.040±/- .001]	3.8
0.35mm2	1.01±/-0.03 [.040±/- .001]	3.8

- 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.
- 5. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- 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.

**\*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)

LOC	DIST	REVISIONS			
A	66	REV	DATE	BY	APPV
		1	PRELIMINARY	16AUG2016	MEH TE
		A	RELEASED	16SEP2016	MEH TE
		B	ECR-22-155549	14OCT2022	FZ JAH

-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248
-	1	1	1	1	2119082-8	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	1-22281-8	SPRING, COMPRESSION	121
-	1	1	1	1	2844908-1	SCREW, LOCKING	99
-	1	1	1	1	2844907-1	POST, LOCKING	98
-	1	1	1	1	1-690438-0	FRONT STRIP GUIDE	96
-	2	2	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	95
-	1	1	1	1	2168083-6	SCR, SKT HD CAP, RoHS, M5 X 65	93
-	1	1	1	1	455888-7	SPACER, CRIMPER	82
-	1	1	1	1	1803607-3	DOCUMENTATION PACKAGE	71
-	1	1	1	1	2119740-1	TAG, IDENTIFICATION	67
-	2	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	2	2	2	2	2-18032-5	SCR, SET, FLT PNT, M5 X 20.0	61
-	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	985575-3	SCR, FLT SKT HD CAP M3 X 10.0	57
-	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	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	53
-	1	1	1	1	5018030-1	NUT, HEX, REG, RoHS, M3	52
-	1	1	1	1	811242-5	BUMPER, HOLD DOWN	51
-	1	1	1	1	690753-2	SPACER, TONKER	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	1-1752356-8	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	2844938-6	PLATE, STRIP GUIDE	29
-	1	1	1	1	1-455888-0	SPACER, CRIMPER	28
-	2	2	2	2	22283-1	SPRING, COMPRESSION	27
-	1	1	1	1	356835-1	LEVER, DRAG RELEASE	26
-	1	1	1	1	240792-1	DRAG, TERMINAL	25
-	1	1	1	1	1320928-2	STRIP GUIDE	24
-	1	1	1	1	980371-4	SCR, SKT HD SHLDR 5.0 DIA X 6.0	23
-	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	318707-1	FLOATING SHEAR, FRONT	9
	1	2	2	1	1-1803252-5	ANVIL, COMBINATION	8
-	-	-	-	-	-	-	7
-	-	-	-	-	-	-	6
-	1	1	1	1	2119781-2	DEPRESSOR, SHEAR	5
-	1	1	1	1	3-238011-5	BLOCK, CRIMPER SPACER	4
	1	2	2	1	1-1803018-0	CRIMPER, INSULATION O	3
-	1	1	1	1	455888-5	SPACER, CRIMPER	2
	1	2	2	1	1-1803212-2	CRIMPER, WIRE PREMIUM	1

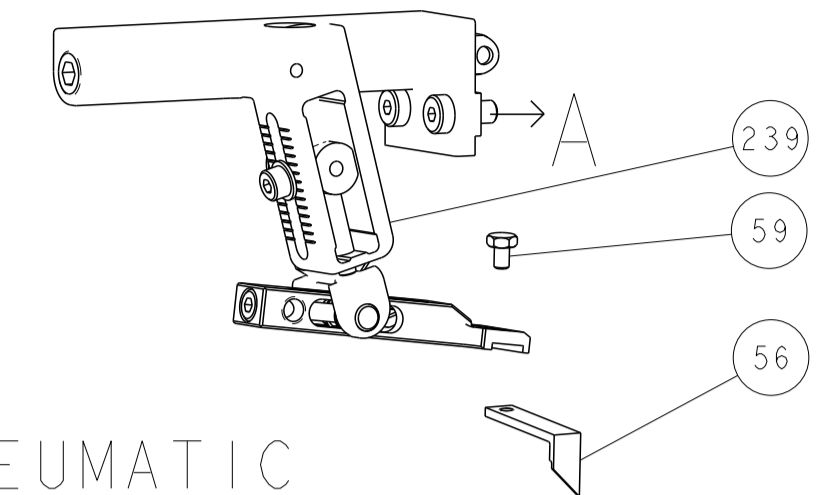
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mm	0 PLC	±	
	1 PLC	±	
	2 PLC	±	
	3 PLC	±	
	4 PLC	±	
	ANGLES	±	
	FINISH	±	

OWN	M. HERR	16AUG2016	NAME	TE Connectivity
CHK	T. ELBIN	16AUG2016	NAME	Harrisburg, PA 17105-3608
APVD	T. ELBIN	16AUG2016	PRODUCT SPEC	
			APPLICATION SPEC	
			SIZE	CAGE CODE
			A1	00779
			DRAWING NO	2836389

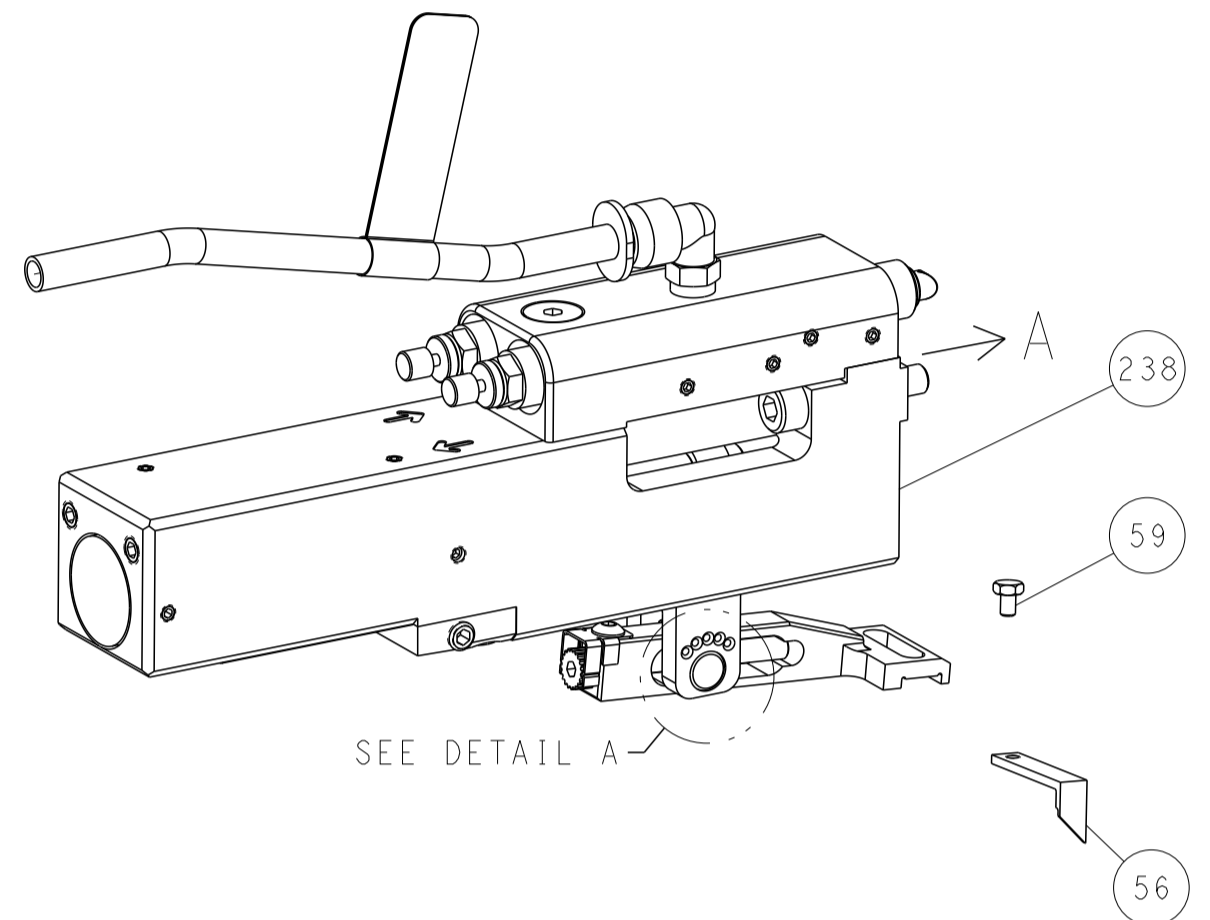
Customer Accessible Production Drawing SCALE: 1:2 SHEET 1 OF 4 REV B

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

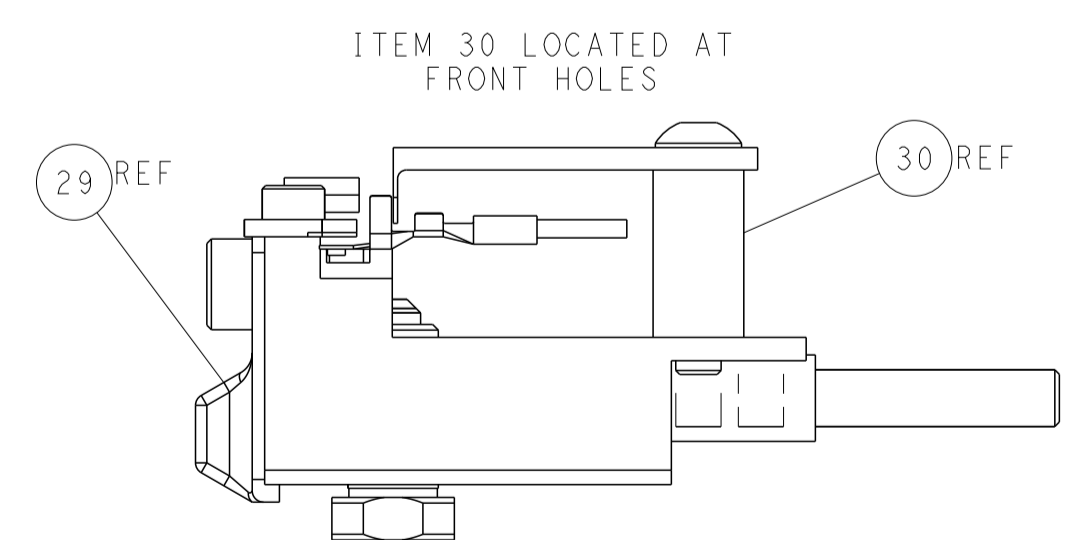
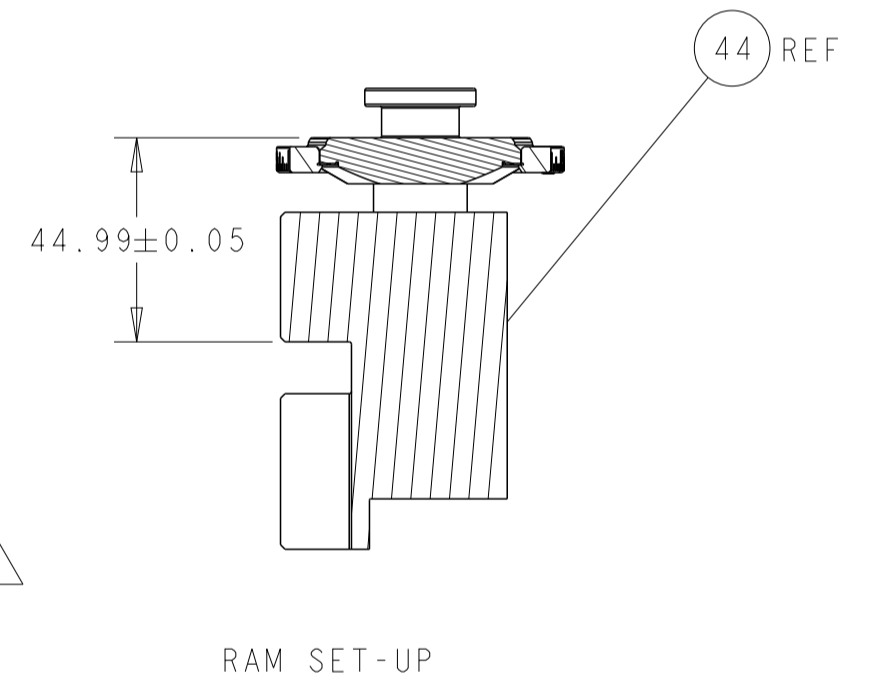
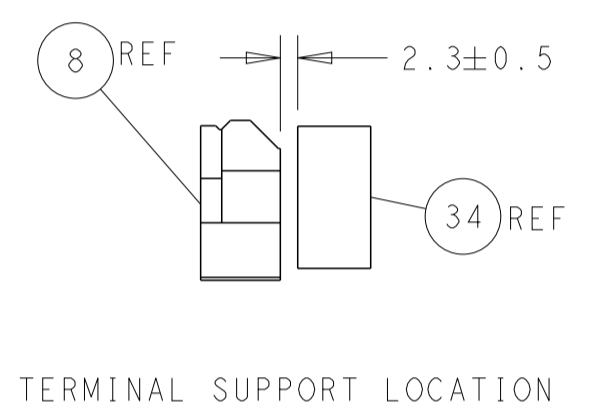
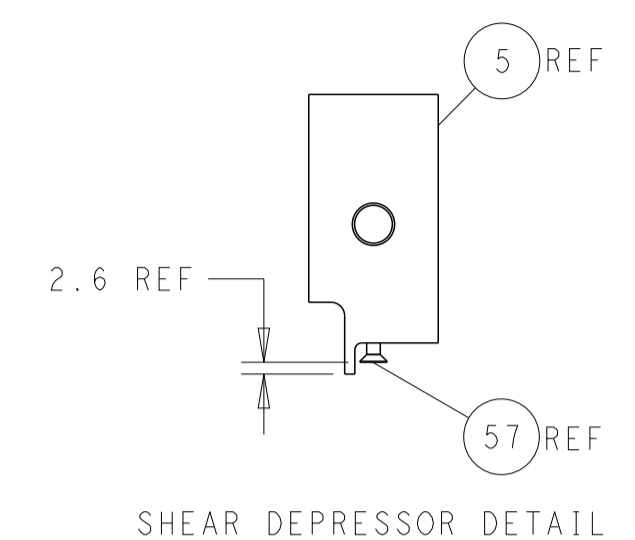
# FEED TYPE MECHANICAL



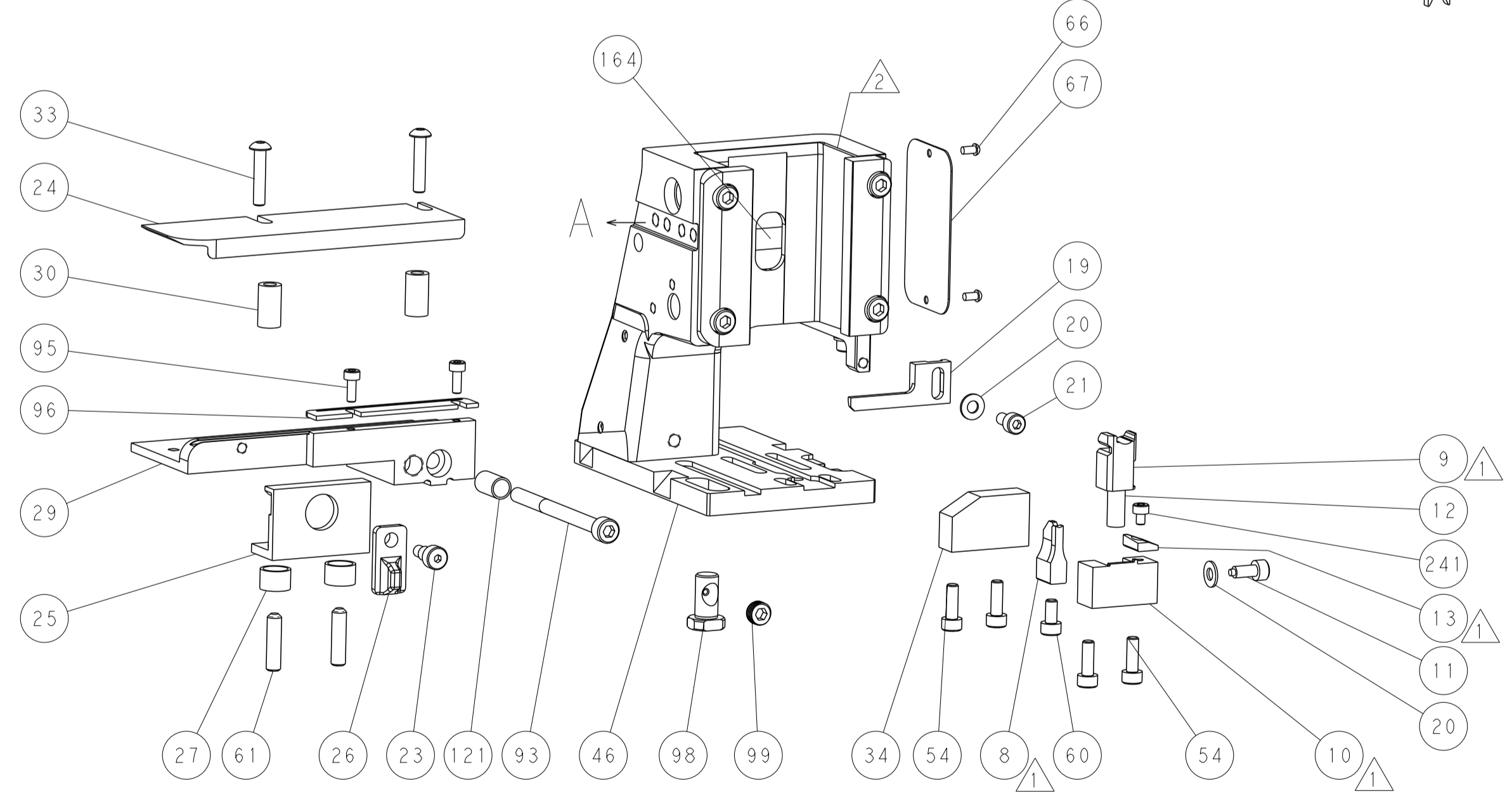
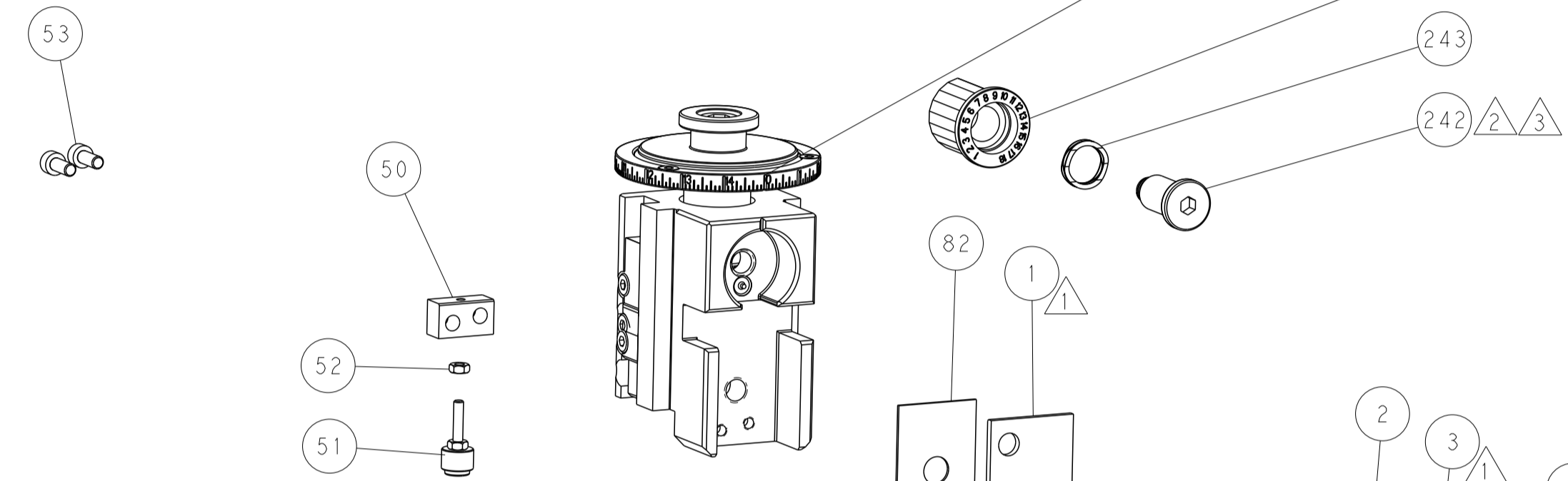
## PNEUMATIC



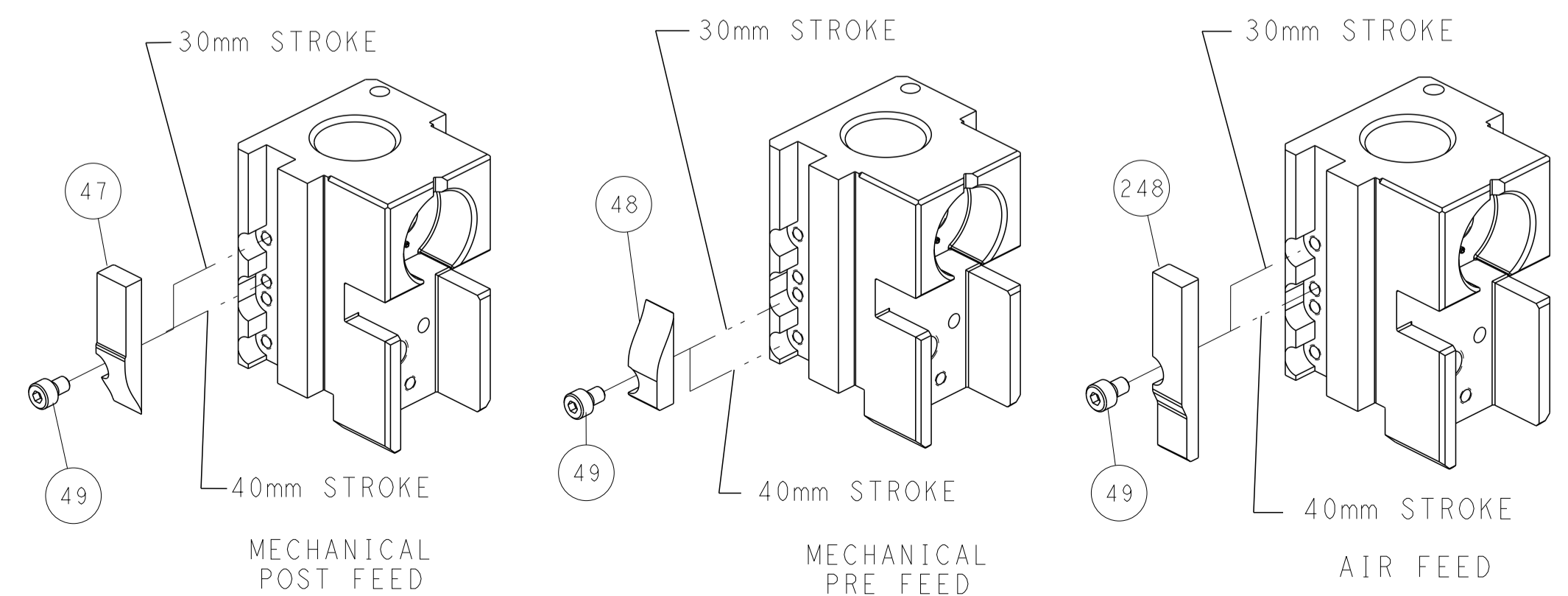
## FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



FEED TRACK POSITION GUIDE BY INSULATION 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)

<small>THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION 2016 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.</small>		DMN: M_HERR 16AUG2016 CHK: T_ELBIN 16AUG2016 APVD: T_ELBIN 16AUG2016	NAME: Ocean Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2836389	TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH	WEIGHT: - SCALE: 1:2 SHEET: 2 OF 4 REV: B	RESTRICTED TO: - Customer Accessible Production Drawing		

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2836389-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2836389-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2836389-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR  
 INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.60 mm [.063]	F
INSUL	3.10 mm [.122]	O
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: DELPHI/FCI TERMINAL	DELPHI PACKARD CRIMP SPECIFICATION
TERMINAL NAME: MALE TERMINAL	DCS2-1.5 WITH SWS
WIRE STRIP LENGTH 3.40-4.20 mm [1.34-.165 IN]	INSULATION DIAMETER RANGE Ø1.20-1.60 mm [.047-.063 IN]
TERMINAL APPLICATION SPECIFICATION 9 084 10 00 Rev K	

TE TERMINAL	DELPHI/FCI TERMINAL	TE SEAL	DELPHI/FCI SEAL	SEAL INSULATION DIAMETER RANGE
2303629-1	60102011/14	1949393-1	60993913	1.2-1.6 mm
2303629-2	60100711/14	964971-1		1.2-1.6 mm
2303629-3	60101314			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
22 AWG	1.01+/-0.03 [.040+/-0.001]	3.8
0.35mm <sup>2</sup>	1.01+/-0.03 [.040+/-0.001]	3.8



- 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. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- 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.

**\*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.

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

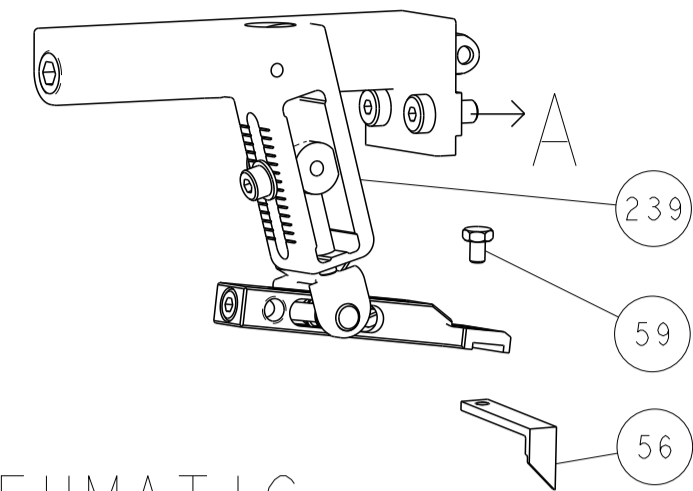
LOC	DIST	REV	DATE	BY	CHKD	DATE	BY
A	66						

REV	DATE	BY	CHKD	DATE	BY	DESCRIPTION	ITEM NO
-	1	1				2119082-8 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				1-22281-8 SPRING, COMPRESSION	121
-	1	1				2844908-1 SCREW, LOCKING	99
-	1	1				2844907-1 POST, LOCKING	98
-	1	1				1-690438-0 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
-	1	1				455888-7 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
-	2	2				2-18032-5 SCR, SET, FLT PNT, M5 X 20.0	61
-	1	1				5-18022-5 SCR, HEX HD CAP, M4 X 6.0	59
-	1	1				985575-3 SCR, FLT SKT HD CAP M3 X 10.0	57
-	1	1				1338683-8 FEED PAWL	56
-	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	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				1-1752356-8 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				2844938-6 PLATE, STRIP GUIDE	29
-	1	1				1-455888-0 SPACER, CRIMPER	28
-	2	2				22283-1 SPRING, COMPRESSION	27
-	1	1				356835-1 LEVER, DRAG RELEASE	26
-	1	1				240792-1 DRAG, TERMINAL	25
-	1	1				1320928-2 STRIP GUIDE	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
-	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	1				3-1803252-5 ANVIL, COMBINATION	8
-	-	-				-	7
-	-	-				-	6
-	1	1				2119781-2 DEPRESSOR, SHEAR	5
-	1	1				3-238011-5 BLOCK, CRIMPER SPACER	4
-	1	1				4-1803018-0 CRIMPER, INSULATION O	3
-	1	1				455888-5 SPACER, CRIMPER	2
-	1	1				1-1803212-2 CRIMPER, WIRE PREMIUM	1

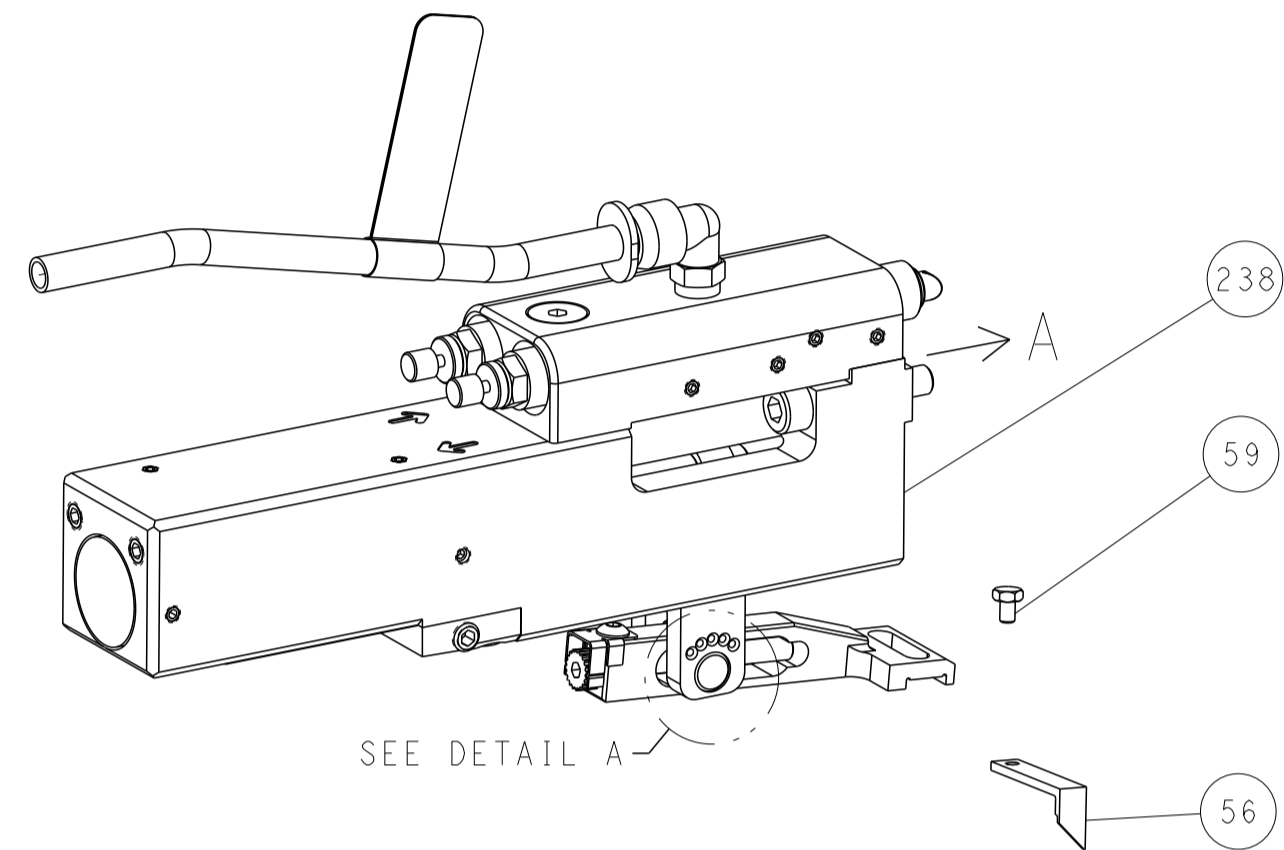
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG: M. HERR 16AUG2016		CHK: T. ELBIN 16AUG2016		APVD: T. ELBIN 16AUG2016		NAME: Ocean Side Feed Applicator	
0 PLC ±		1 PLC ±		2 PLC ±		3 PLC ±		4 PLC ±		RESTRICTED TO	
MATERIAL: -		FINISH: -		WEIGHT: -		SCALE: 1:2		SHEET 3 OF 4		REV B	

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

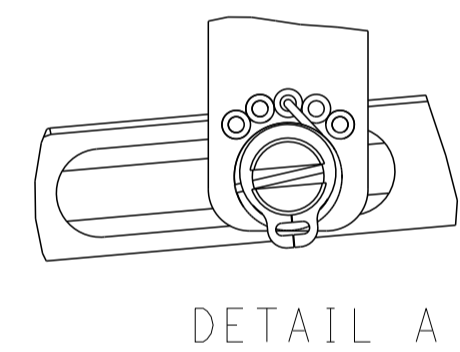
# FEED TYPE MECHANICAL



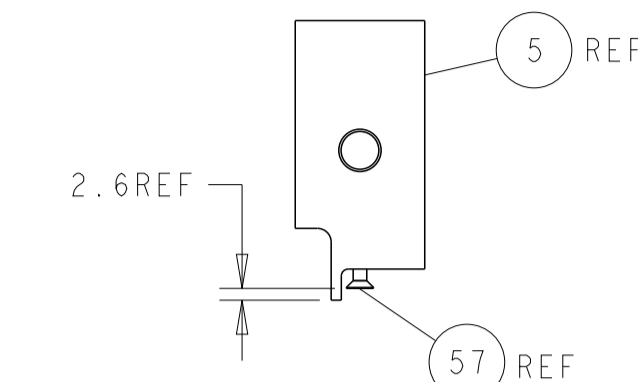
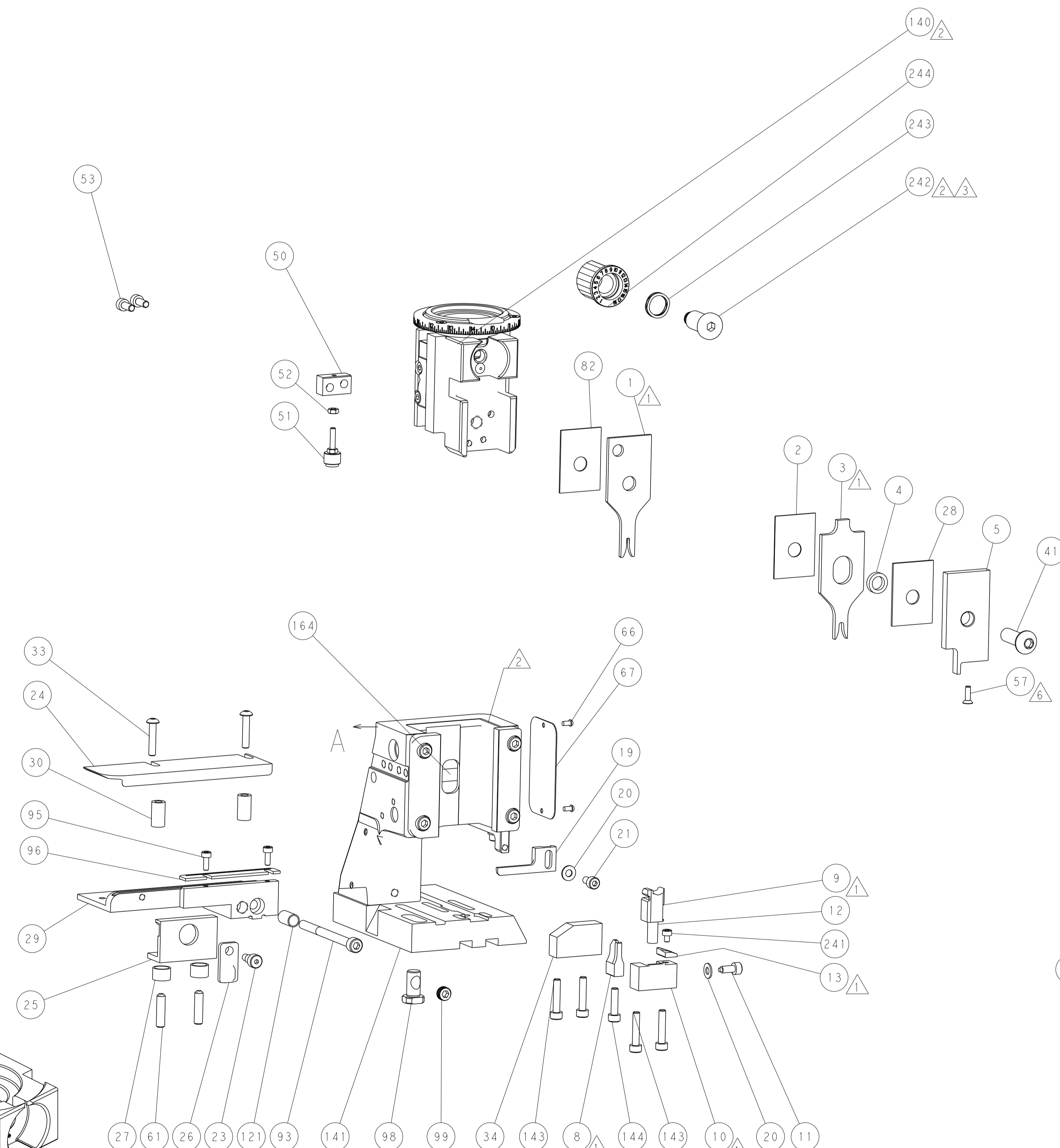
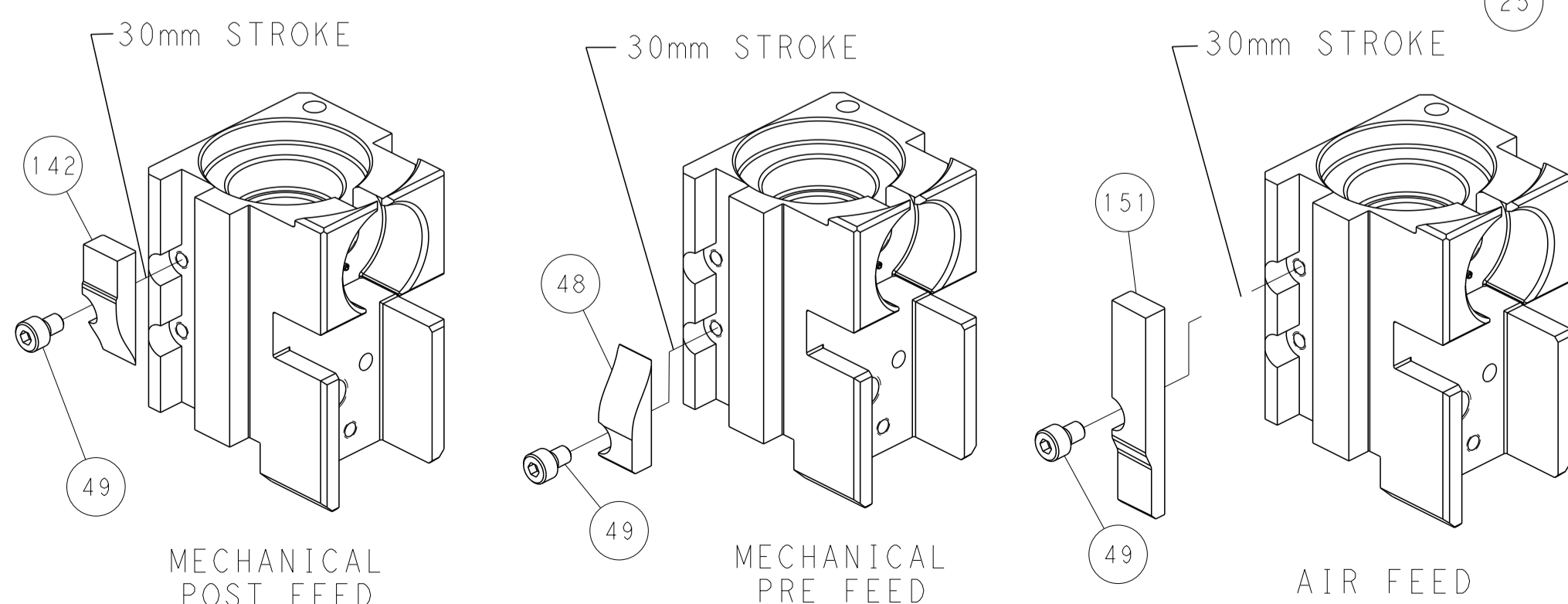
## PNEUMATIC



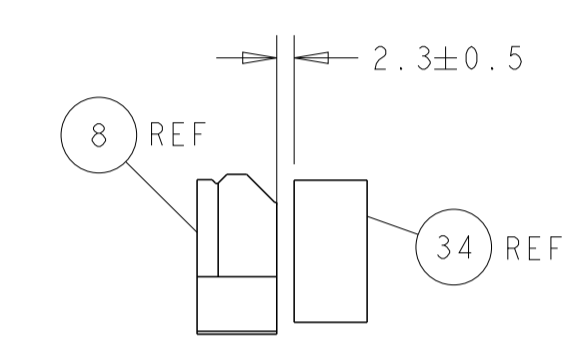
## FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



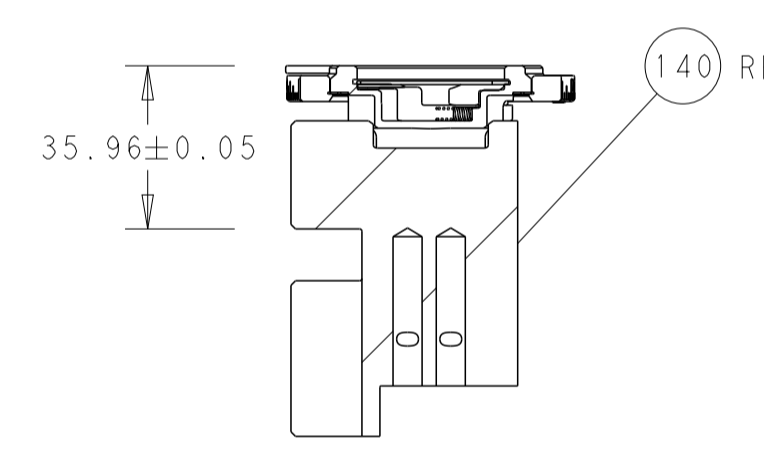
# CAM POSITIONS



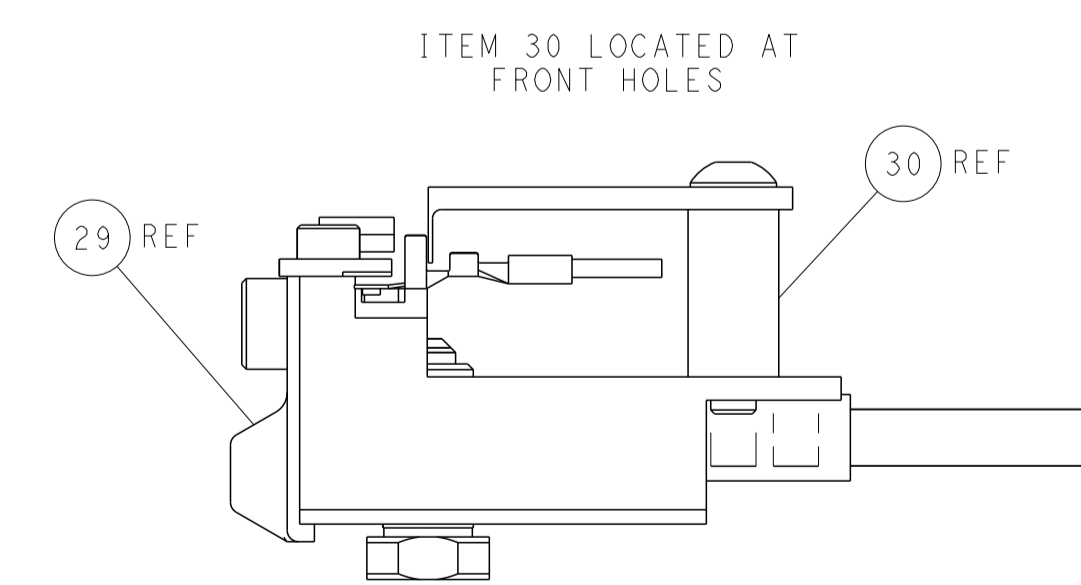
SHEAR DEPRESSOR DETAIL



TERMINAL SUPPORT LOCATION



RAM SET-UP



FEED TRACK POSITION GUIDE BY INSULATION BARREL

**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 2016. COPYRIGHT 2016 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.</small>		DWN: M_HERR 16AUG2016 CHK: T_ELBIN 16AUG2016 APVD: T_ELBIN 16AUG2016	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: 2836389	RESTRICTED TO: - SHEET 4 OF 4 REV B