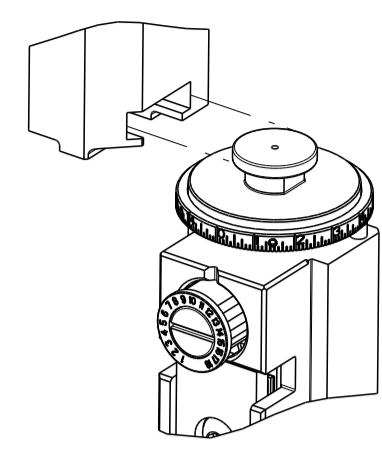


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2836672-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2836672-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2836672-1	B	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2836672-2	B	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2836672-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.03 mm [.080]	F
INSUL	2.29 mm [.090]	O

APPLICATOR INSTRUCTIONS
408-35042

TERMINAL DATA: FCI TERMINAL		DELPHI CRIMP SPECIFICATION	
TERMINAL NAME: DCS-2 1.5MM TERMINAL			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
3.90-4.70 mm [.154-.185 IN]		Ø1.40-2.10 mm [.055-.083 IN]	
TERMINAL APPLICATION SPECIFICATION	9 084 10 00 Rev K		

TE TERMINAL	FCI TERMINAL	TE TERMINAL	FCI TERMINAL	TE TERMINAL	FCI TERMINAL
1572788-1	60000331	1-1572788-3	33511724	1-1949766-1	10863773
1572788-2	60000531	1-1572788-4	33504751	1-1949766-2	33504726
1572788-3	60000334	1949766-1	60100231	1-1949766-3	33504725
1572788-4	60000534	1949766-2	60100234		
1572788-5	60001334	1949766-3	60100631		
1572788-6	F388000	1949766-4	60100634		
1572788-7	F488000	1949766-5	60101931		
1572788-8	F588000	1949766-6	60101934		
1572788-9	15380673	1949766-7	60101434		
1-1572788-0	10751587	1949766-8	10864947		
1-1572788-1	33504752	1949766-9	10756897		
1-1572788-2	33504750	1-1949766-0	10751589		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.00mm ²	1.25+/-0.04 [.049+/-0.002]	8.5
0.75mm ²	1.20+/-0.04 [.047+/-0.002]	9.0
20 AWG	1.17+/-0.04 [.046+/-0.002]	9.2
0.50mm ²	1.17+/-0.04 [.046+/-0.002]	9.2

- △ 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 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)

LOC	DIST	REVISIONS					
A	66	P	LTN	DESCRIPTION	DATE	OWN	APVD
		1		PRELIMINARY	15MAR2017	MEH	TE
		A		RELEASED	24APR2017	TB	CT
		B		ECR-19-015541	05OCT2019	TB	RK

-	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	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	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	455888-4	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	1338685-1	PAWL, FEED	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	1803382-1	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	2-2844962-4	SPACER, CYLINDRICAL, STRIP GUIDE	30	
-	1	1	1	1	2844938-2	PLATE, STRIP GUIDE	29	
-	1	1	1	1	455888-3	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	1803095-5	FLOATING SHEAR, FRONT	9	
△	1	2	2	1	1	7-1633920-5	ANVIL, COMBINATION	8
-	-	-	-	-	-	-	7	
-	-	-	-	-	-	-	6	
-	1	1	1	1	2119757-4	DEPRESSOR, SHEAR	5	
-	1	1	1	1	238011-9	BLOCK, CRIMPER SPACER	4	
△	1	2	2	1	1	4-1803019-0	CRIMPER, INSULATION O	3
-	1	1	1	1	455888-5	SPACER, CRIMPER	2	
△	1	2	2	1	1	4-456405-0	CRIMPER, WIRE PREMIUM	1

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		MATERIAL:		FINISH:	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES ±	

ITEM NO	PART NO	DESCRIPTION			
-77	-72	-71	-2	-1	

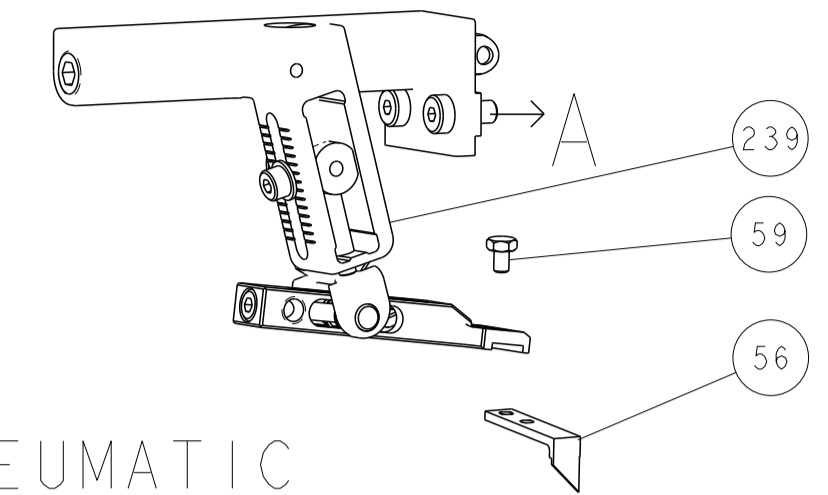
OWN	M. HERR	15MAR2017
CHK	T. ELBIN	15MAR2017
APVD	T. ELBIN	15MAR2017

NAME	Ocean Side Feed Applicator		
SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
A1	00779	2836672	

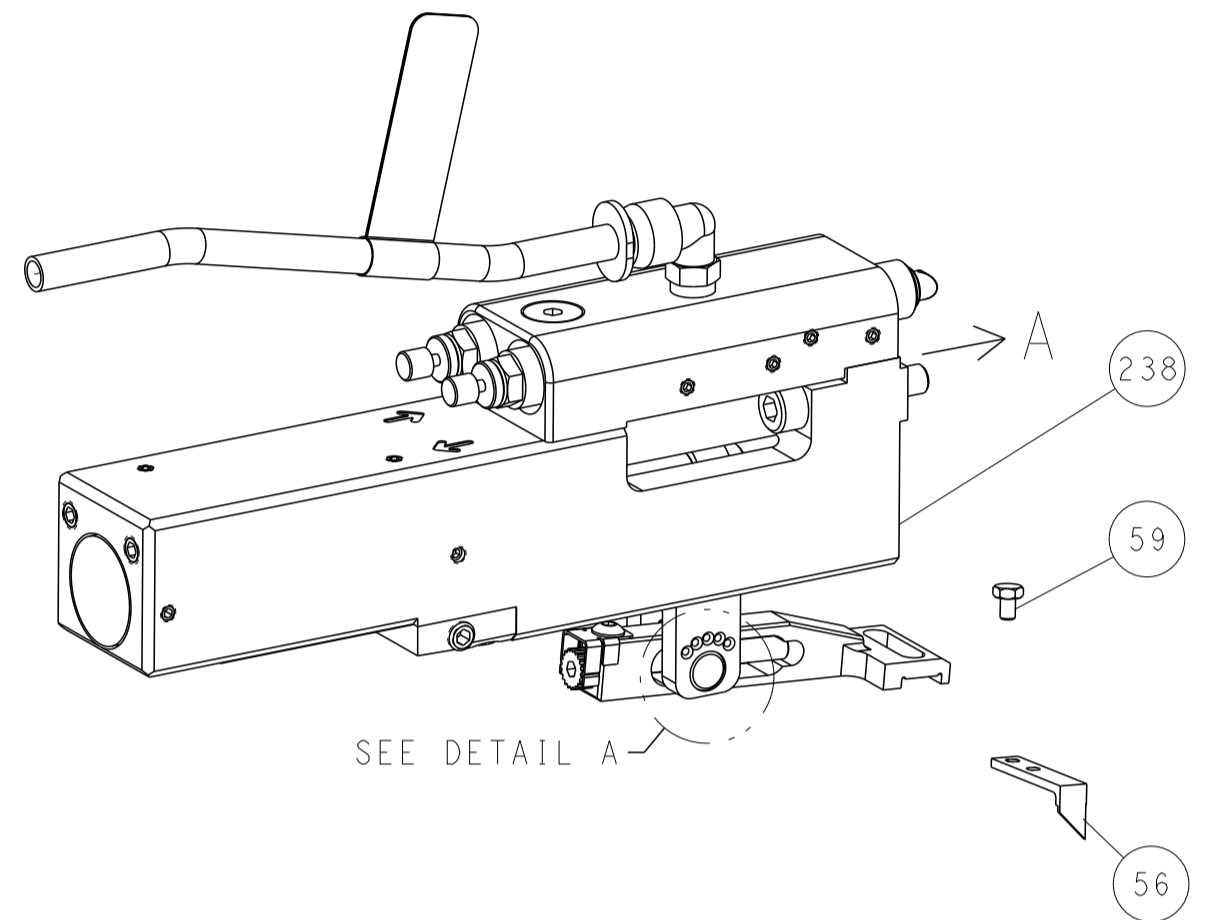
Customer Accessible Production Drawing SCALE 1:2 SHEET 1 OF 4 REV B

LOC	DIST	REV	DATE	BY	APPV
A	66				

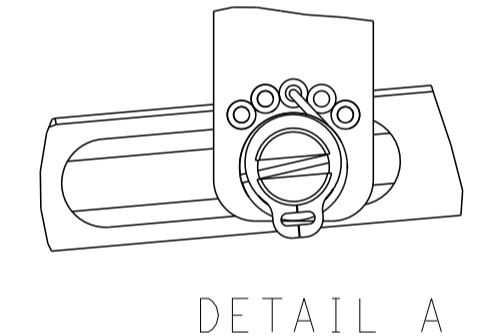
FEED TYPE MECHANICAL



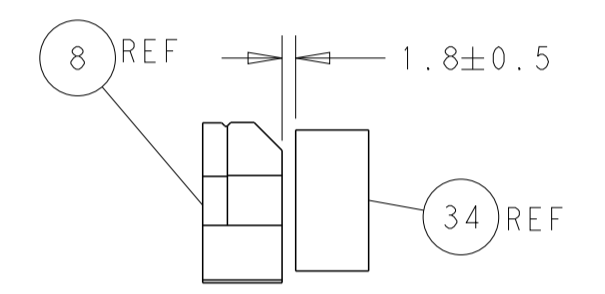
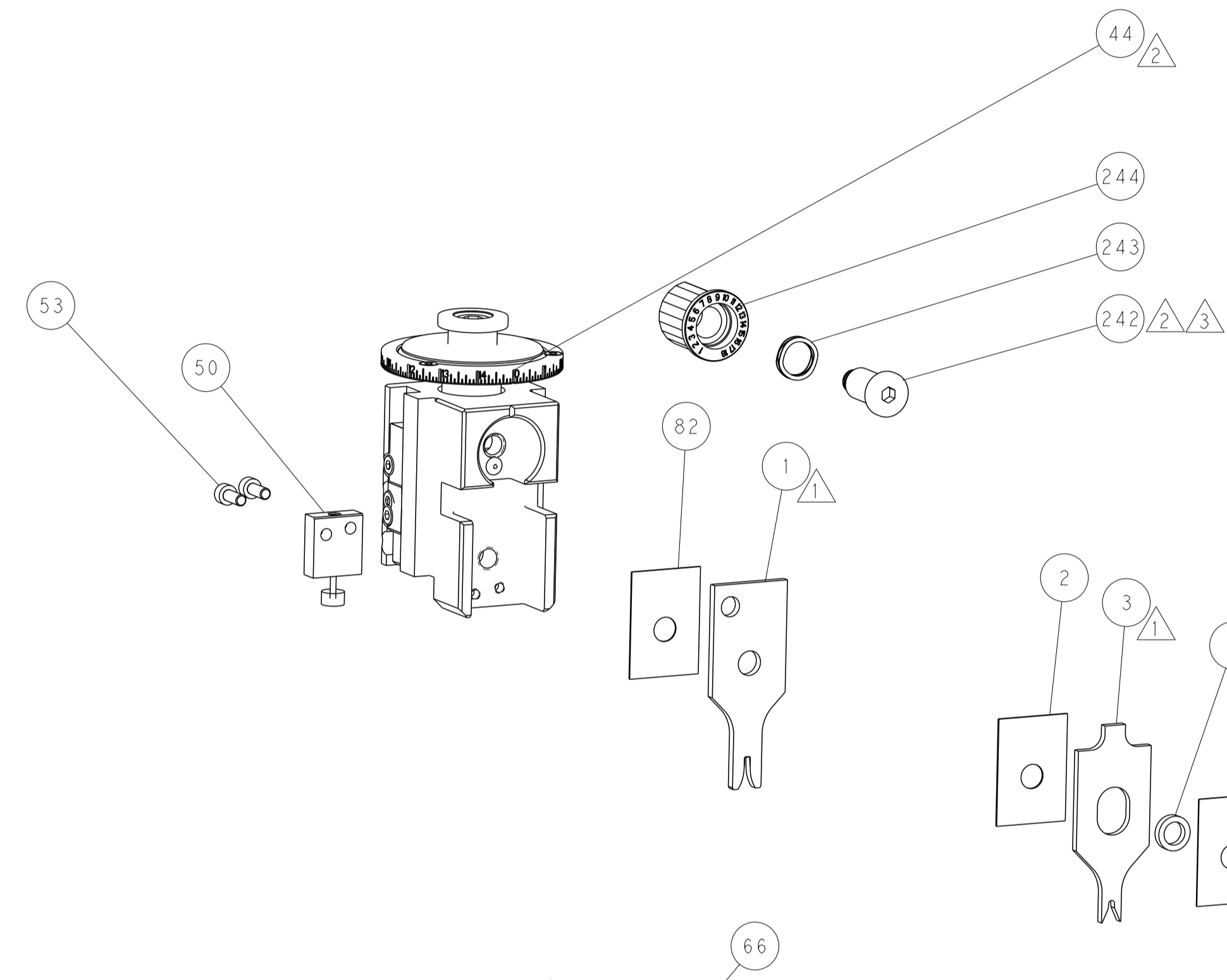
PNEUMATIC



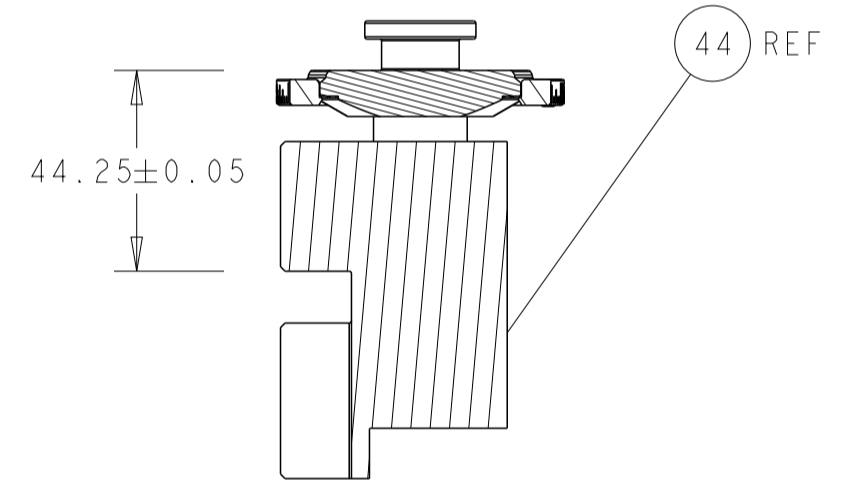
FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



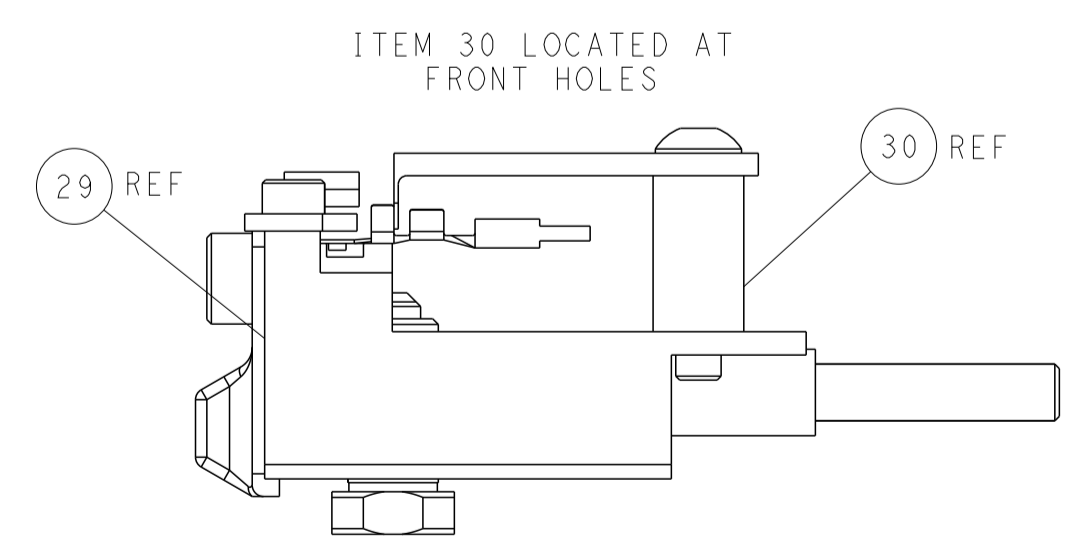
DETAIL A



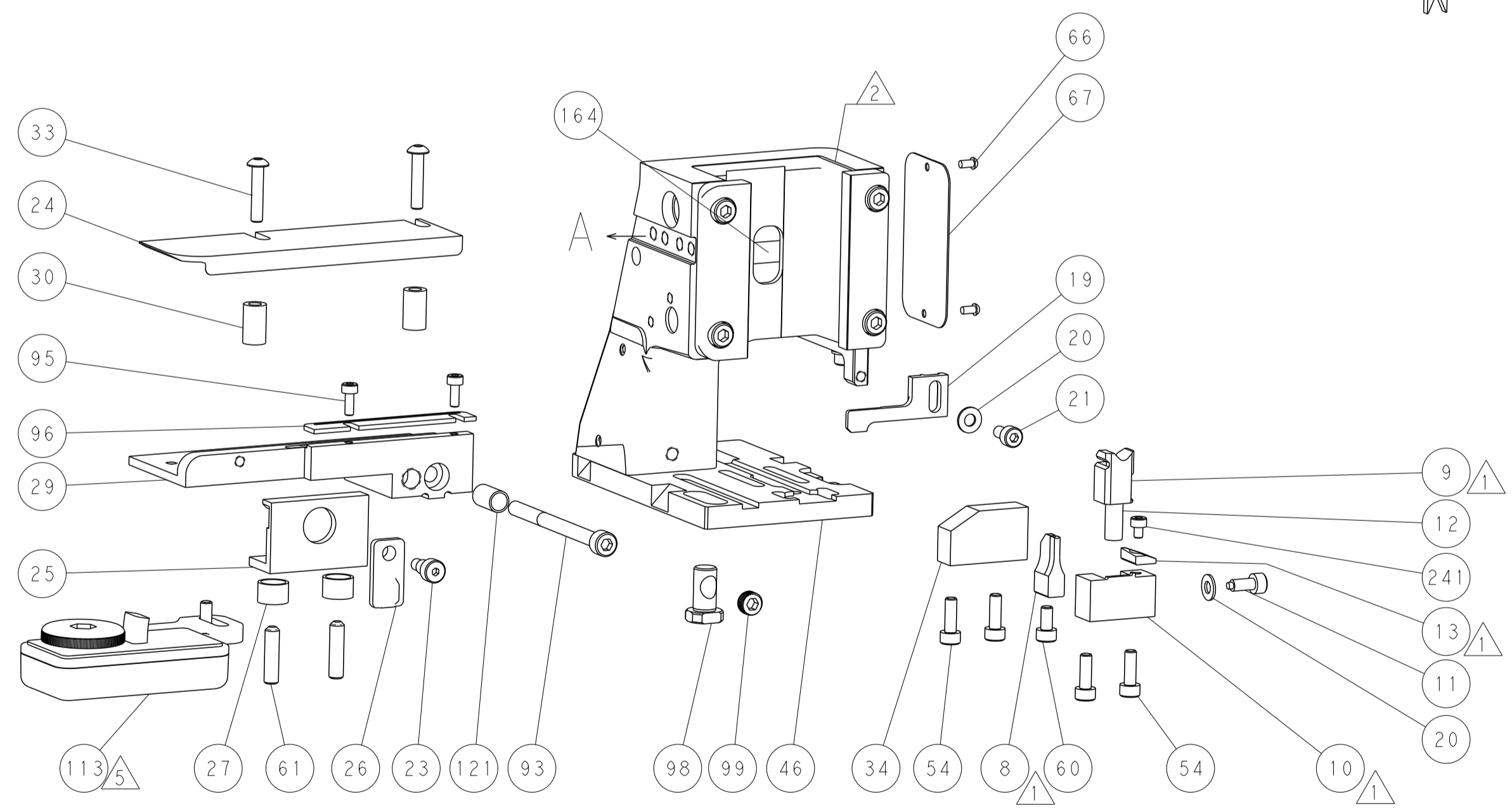
TERMINAL SUPPORT LOCATION



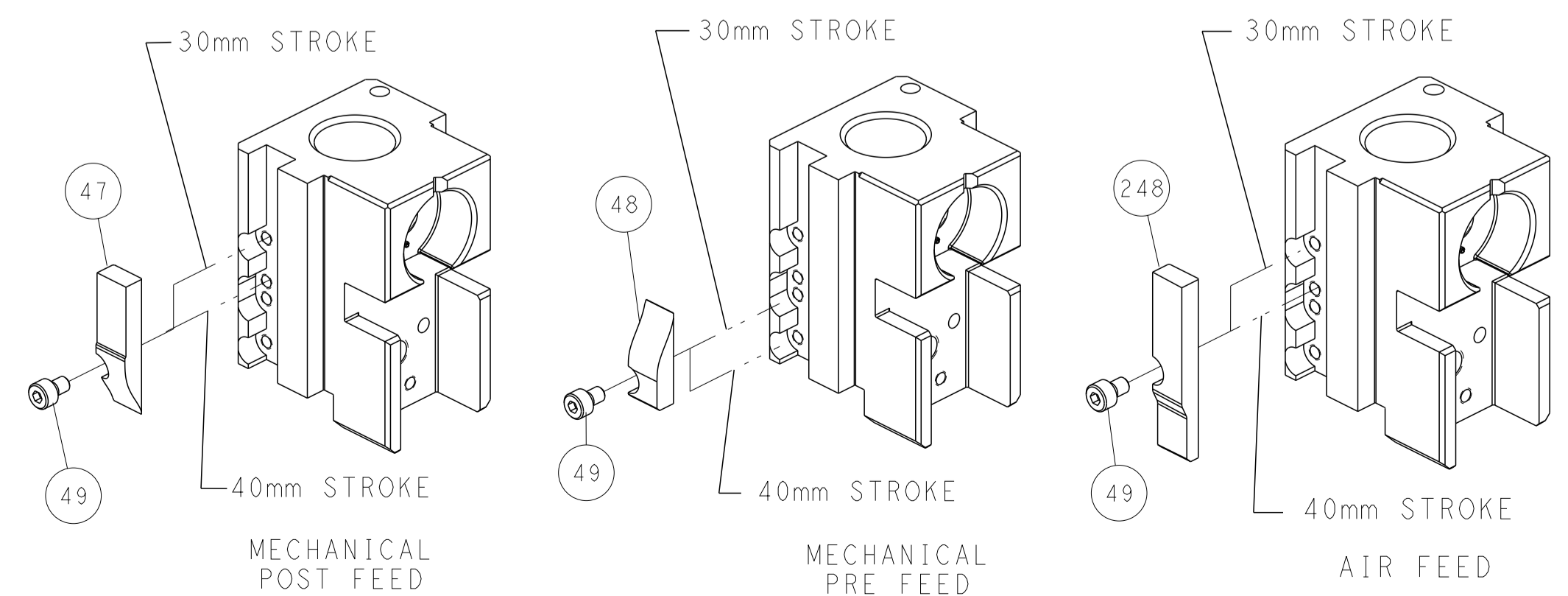
RAM SET-UP



FEED TRACK POSITION GUIDE BY 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)

DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH		DWG: M_HERR 15MAR2017 CHK: T_ELBIN 15MAR2017 APVD: T_ELBIN 15MAR2017 PRODUCT SPEC APPLICATION SPEC WEIGHT Customer Accessible Production Drawing	NAME: Ocean Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2836672 SCALE: 1:2 SHEET: 2 of 4 REV: B	RESTRICTED TO:
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2836672-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2836672-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2836672-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
 INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.03 mm [.080]	F
INSUL	2.29 mm [.090]	O

APPLICATOR INSTRUCTIONS
 408-35042

TERMINAL DATA: FCI TERMINAL DELPHI CRIMP SPECIFICATION

TERMINAL NAME: DCS-2 1.5MM TERMINAL

WIRE STRIP LENGTH 3.90-4.70 mm [1.54-.185 IN]	INSULATION DIAMETER RANGE Ø1.40-2.10 mm [.055-.083 IN]
--	---

TERMINAL APPLICATION SPECIFICATION 9 084 10 00 Rev K

TERMINALS APPLIED

TE TERMINAL	FCI TERMINAL	TE TERMINAL	FCI TERMINAL	TE TERMINAL	FCI TERMINAL
1572788-1	60000331	1-1572788-3	33511724	1-1949766-1	10863773
1572788-2	60000531	1-1572788-4	33504751	1-1949766-2	33504726
1572788-3	60000334	1949766-1	60100231	1-1949766-3	33504725
1572788-4	60000534	1949766-2	60100234		
1572788-5	60001334	1949766-3	60100631		
1572788-6	F388000	1949766-4	60100634		
1572788-7	F488000	1949766-5	60101931		
1572788-8	F588000	1949766-6	60101934		
1572788-9	15380673	1949766-7	60101434		
1-1572788-0	10751587	1949766-8	10864947		
1-1572788-1	33504752	1949766-9	10756897		
1-1572788-2	33504750	1-1949766-0	10751589		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.00mm2	1.25+/-0.04 [.049+/-0.002]	8.5
0.75mm2	1.20+/-0.04 [.047+/-0.002]	9.0
20 AWG	1.17+/-0.04 [.046+/-0.002]	9.2
0.50mm2	1.17+/-0.04 [.046+/-0.002]	9.2

- 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 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.

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
-	-	-	-	SEE SHEET 1	-	-	-

-	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	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113
-	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	455888-4	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	1338685-1	PAWL, FEED	56
-	2	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	53
-	1	1	1803382-1	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	1-1752356-3	SUPPORT, TERMINAL	34
-	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	2-2844962-4	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	2844938-2	PLATE, STRIP GUIDE	29
-	1	1	455888-3	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	1803095-5	FLOATING SHEAR, FRONT	9
-	1	1	7-1633920-5	ANVIL, COMBINATION	8
-	-	-	-	-	7
-	-	-	-	-	6
-	1	1	2119757-4	DEPRESSOR, SHEAR	5
-	1	1	238011-9	BLOCK, CRIMPER SPACER	4
-	1	1	4-1803019-0	CRIMPER, INSULATION O	3
-	1	1	455888-5	SPACER, CRIMPER	2
-	1	1	4-456405-0	CRIMPER, WIRE PREMIUM	1

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		MATERIAL:		FINISH:	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES	FINISH

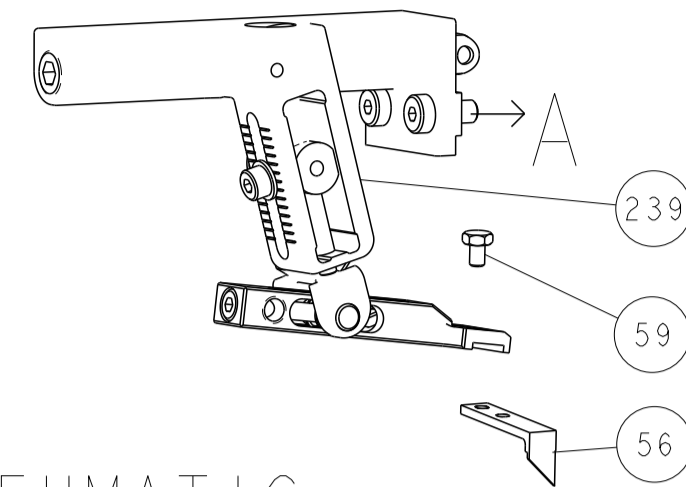
OWN	M. HERR	15MAR2017
CHK	T. ELBIN	15MAR2017
APVD	T. ELBIN	15MAR2017

NAME	Ocean Side Feed Applicator	
SIZE	CAGE CODE	DRAWING NO
A1	00779	2836672

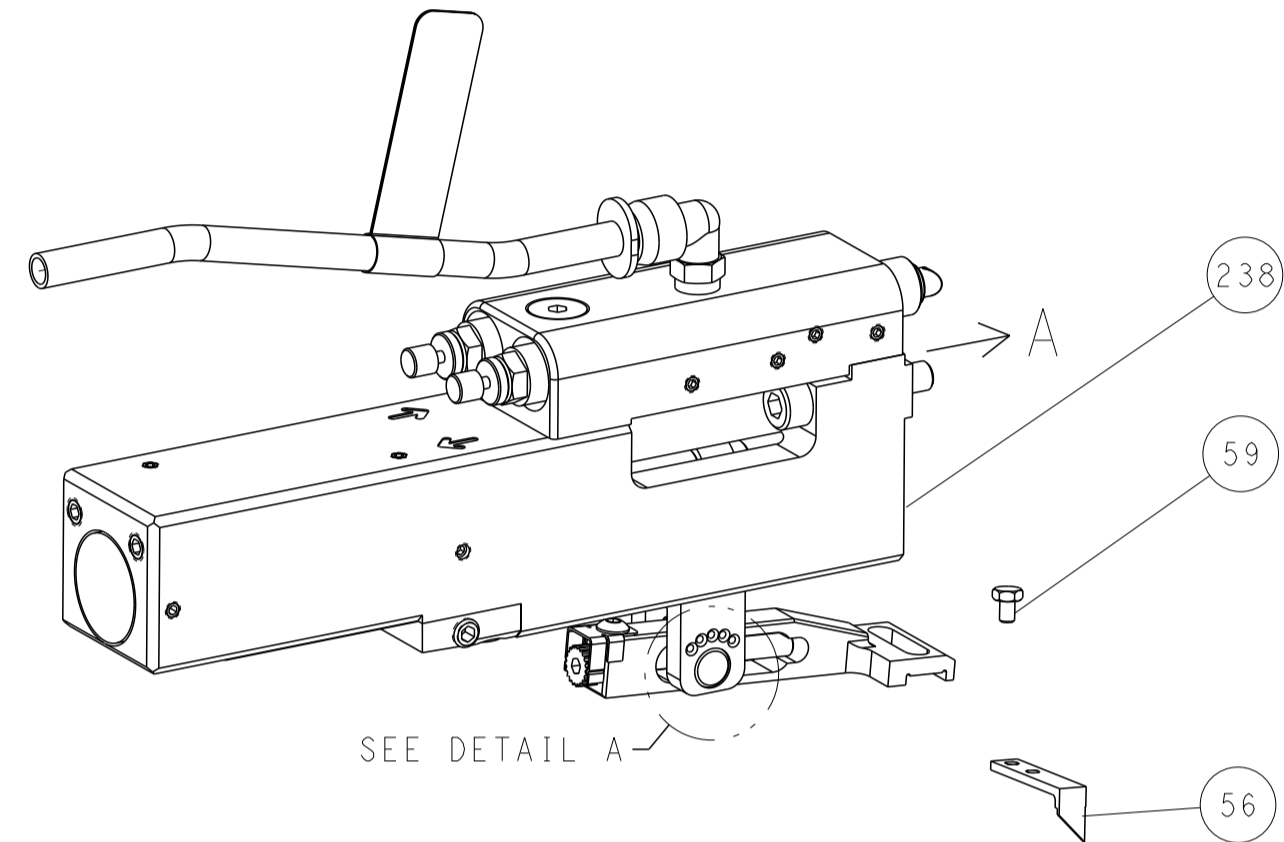
Customer Accessible Production Drawing SCALE 1:2 SHEET 3 OF 4 REV B

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

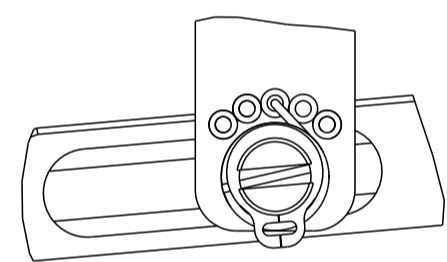
FEED TYPE MECHANICAL



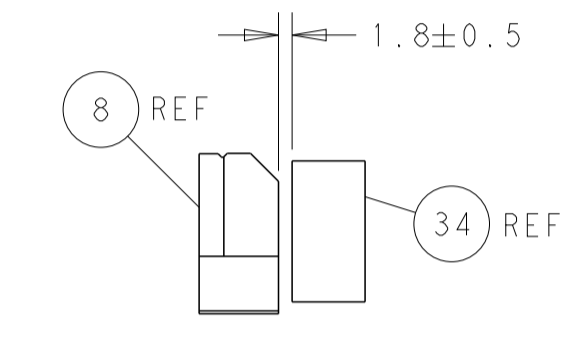
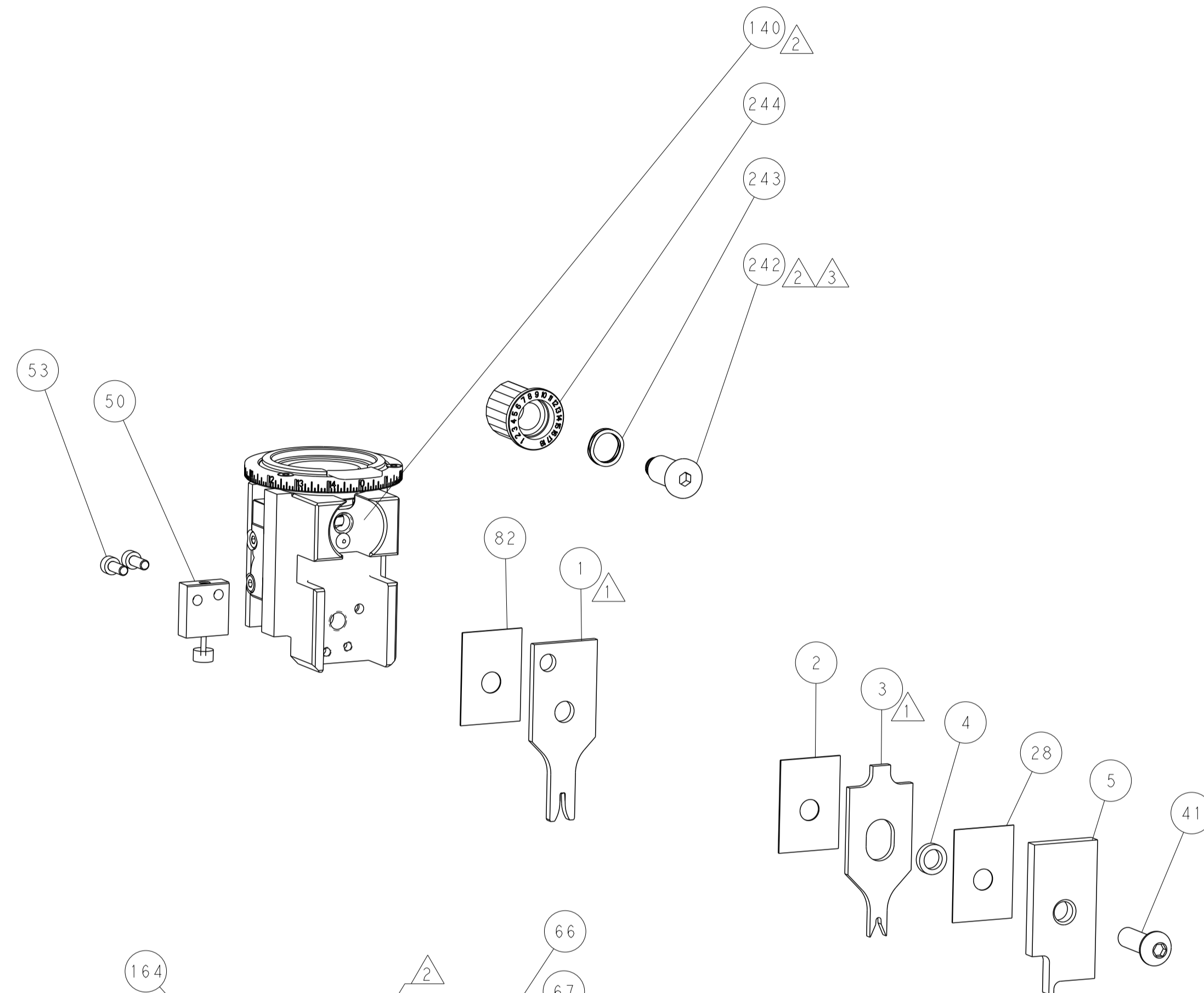
PNEUMATIC



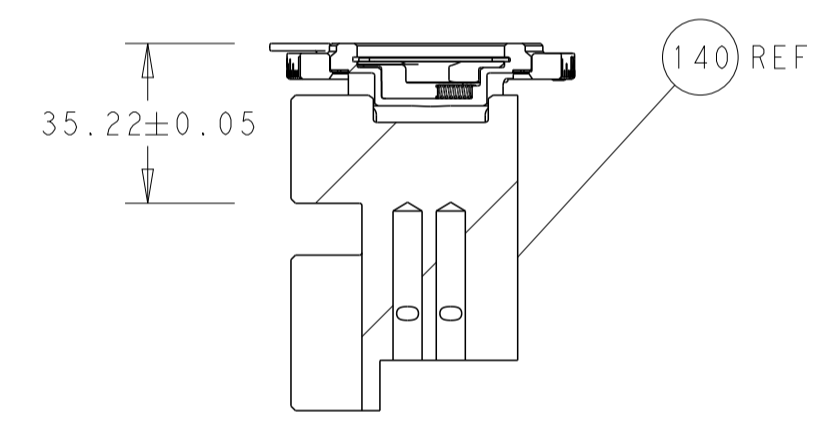
FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



DETAIL A

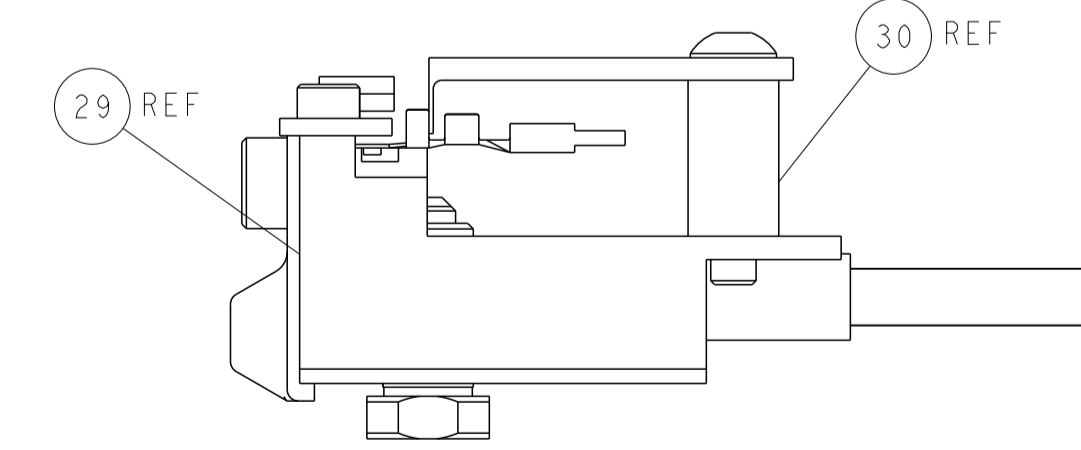


TERMINAL SUPPORT LOCATION



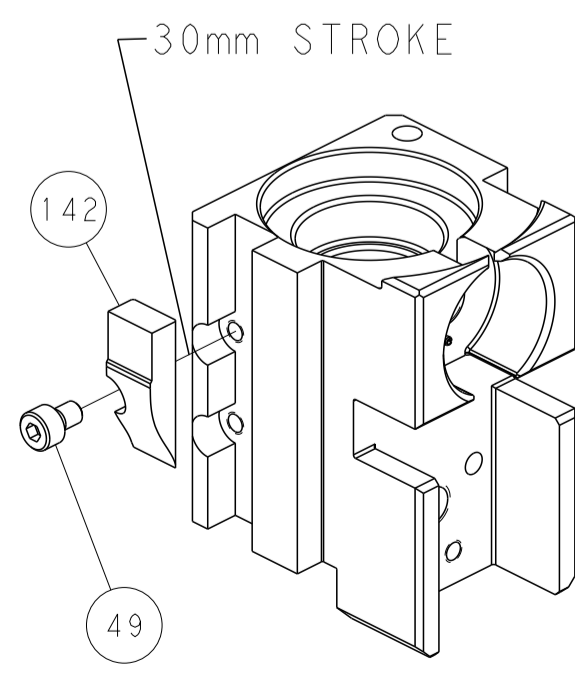
RAM SET-UP

ITEM 30 LOCATED AT
FRONT HOLES

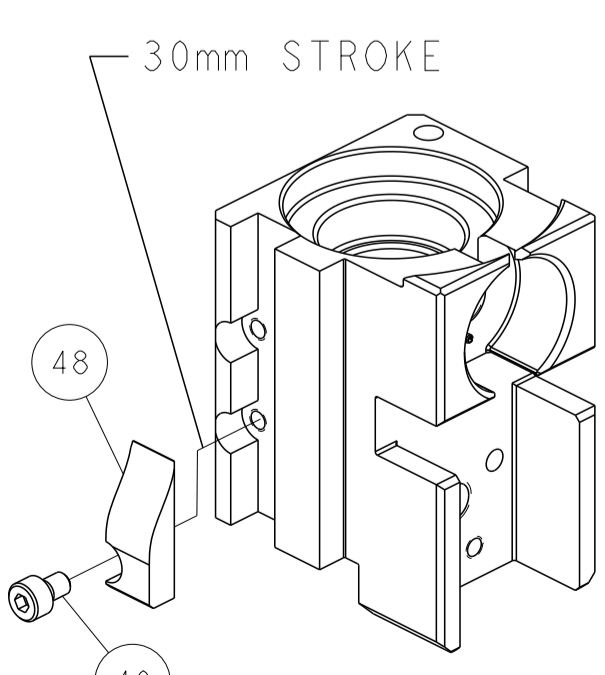


FEED TRACK POSITION
GUIDE BY INSULATION BARREL

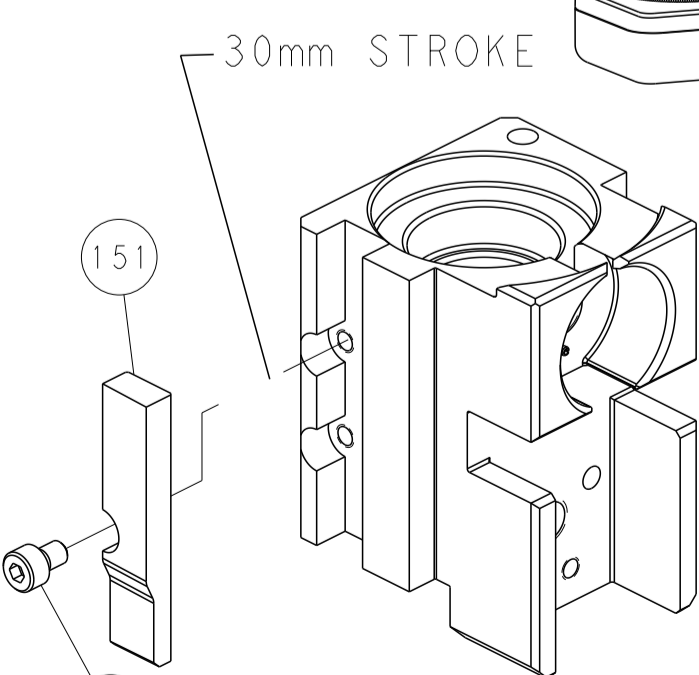
CAM POSITIONS



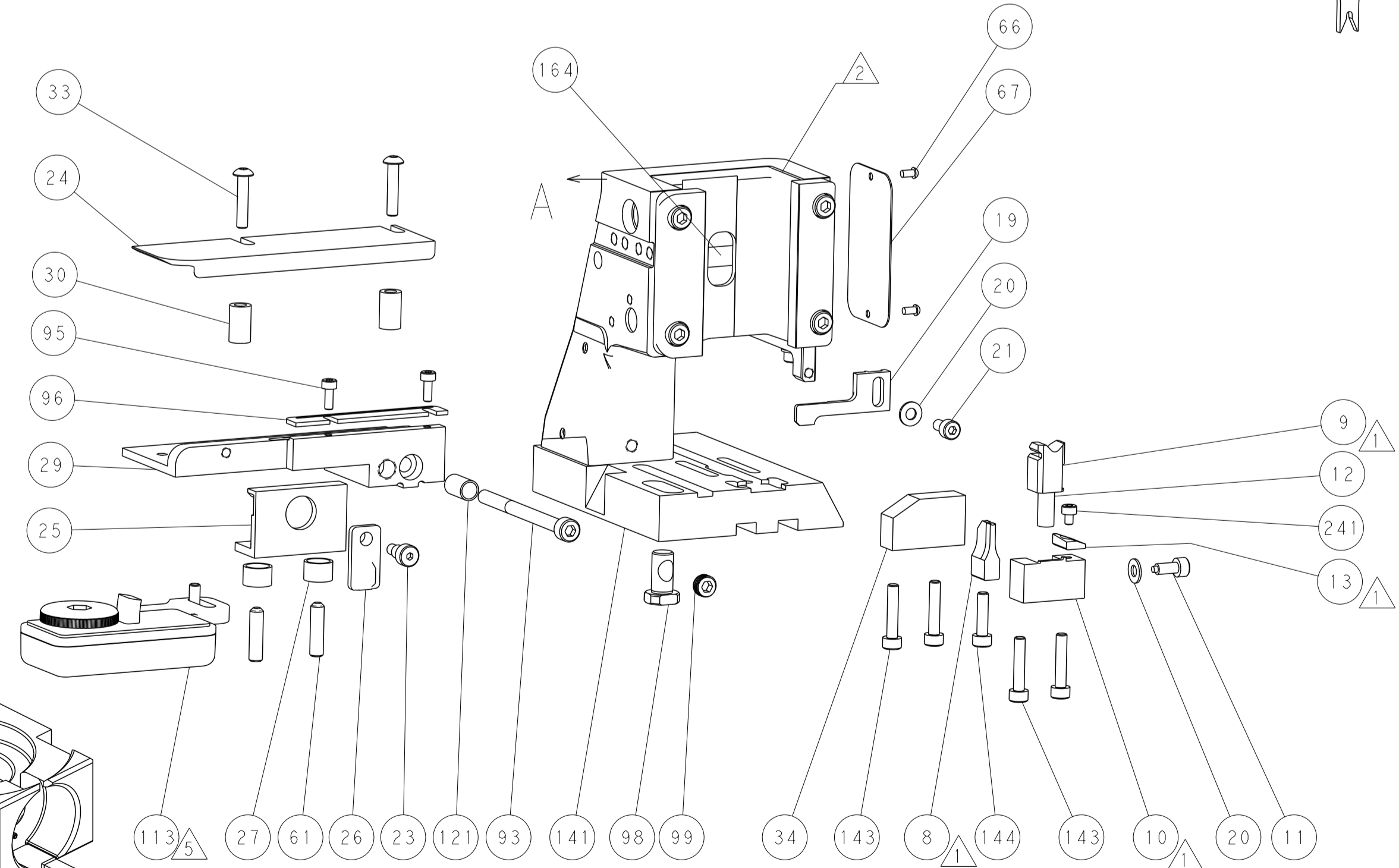
MECHANICAL
POST FEED



MECHANICAL
PRE FEED



AIR FEED



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 2017. ALL RIGHTS RESERVED. THIS DRAWING IS CONTROLLED DOCUMENT FOR THE ELECTRONICS CORPORATION. IT IS THE POLICY OF THE CORPORATION TO CONTROL THE DISTRIBUTION OF THIS DRAWING TO THE LARGEST EXTENT POSSIBLE.</small>		DWN: M_HERR 15MAR2017 CHK: T_EBLIN 15MAR2017 APVD: T_EBLIN 15MAR2017	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 APPLICATION SPEC: - SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2836672	RESTRICTED TO: - SCALE: 1:2 SHEET: 4 OF 4 REV: B
MATERIAL: - FINISH: -		WEIGHT: - Customer Accessible Production Drawing	SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION