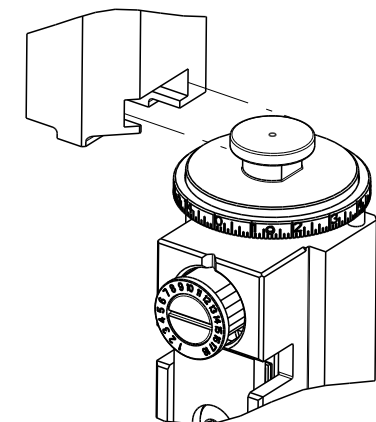


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2836619-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2836619-2	B	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2836619-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	3.94 mm [.155]	F
INSUL	5.59 mm [.220]	O

APPLICATOR INSTRUCTIONS 408-35042

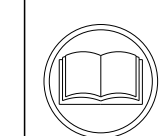
TERMINAL DATA: FCI TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: 9.5 BOX TERMINAL, DCS-1			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
7.19-7.95 mm [.283-.313 IN]		Ø3.23-4.30 mm [.127-.169 IN]	
TERMINAL APPLICATION SPECIFICATION	NONE		

TERMINAL DATA: FCI TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: 9.5 BOX TERMINAL, DCS-1			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
7.19-7.95 mm [.283-.313 IN]		Ø3.23-4.30 mm [.127-.169 IN]	
TERMINAL APPLICATION SPECIFICATION	NONE		

TE TERMINAL	FCI TERMINAL	TE SEAL	FCI SEAL	CABLE DIAMETER
2113176-2	F582210	1572474-1	60993301	4.3mm MAX [.169 IN MAX]
2113176-3	F192210	1572474-2	15327788	4.3mm MAX [.169 IN MAX]
2113176-6	33517391	2113173-1	60993308	4.2mm MAX [.165 IN MAX]
2113176-7	33517389	2113173-2	13546490	4.2mm MAX [.165 IN MAX]

TE TERMINAL	FCI TERMINAL	TE SEAL	FCI SEAL	CABLE DIAMETER
2113176-1	60070461	1572474-1	60993301	4.3mm MAX [.169 IN MAX]
2113176-4	60070462	1572474-2	15327788	4.3mm MAX [.169 IN MAX]
2113176-5	10780235	2113173-1	60993308	4.2mm MAX [.165 IN MAX]
2113176-8	13960627	2113173-2	13546490	4.2mm MAX [.165 IN MAX]

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
6.00mm2	2.88+/-0.05 [.113+/- .002]	5.6
5.00mm2	2.67+/-0.05 [.105+/- .002]	8.1
4.50mm2	2.57+/-0.05 [.101+/- .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.
- △ THIS APPLICATOR APPLIES TERMINAL WITH A SEAL.
- △ GRIND AT ASSEMBLY.
- △ FEED ADJUSTMENT WILL BE REQUIRED WHEN SWITCHING TERMINALS.
- △ APPLY TORQ-SEAL IN ALLEN SOCKET TO FILL HOLE AFTER FLAT HD HAD BEEN ADJUSTED TO CORRECT HEIGHT AT QUALIFICATION.

***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
		A		RELEASED	21FEB2017	BW	TE
		B		ECR-22-138646	10MAY2022	JWC	ROY

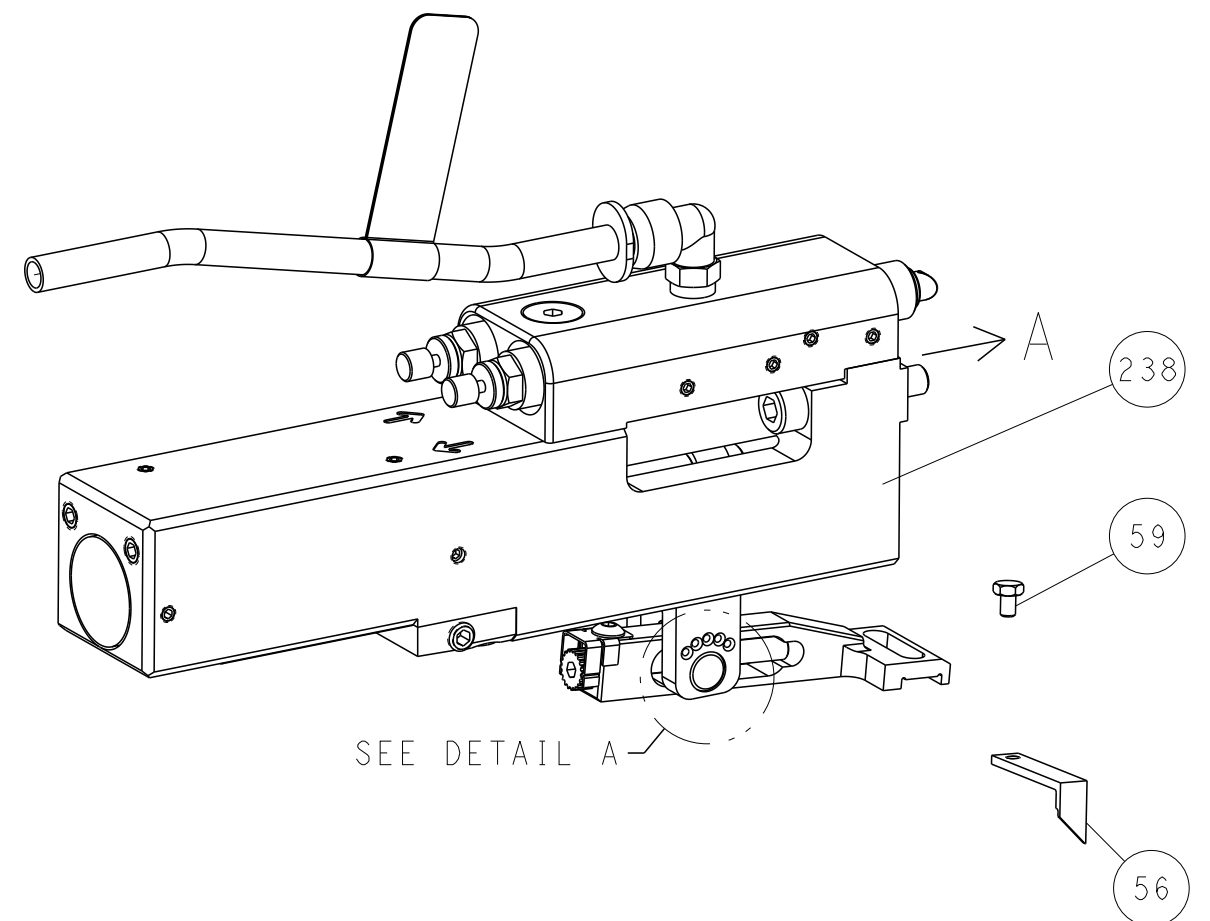
-	1	1	5018030-1	NUT, HEX, REG, RoHS, M3	270	
-	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	269	
-	1	1	1633782-3	FENCE	267	
-	1	1	1803078-2	SPACER, PRECISION	259	
-	1	1	2119641-1	FEED CAM, AIR FEED	248	
-	1	1	2119082-5	CAM, SNAIL, INSULATION ADJUSTMENT	244	
-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243	
-	1	1	2119083-1	RETAINER, INSULATION DIAL	242	
-	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241	
-	1	1	2844940-2	AIR FEED MODULE	238	
-	REF	REF	994970-2	COUNTER, MAGNETIC	164	
-	1	1	455888-6	SPACER, CRIMPER	120	
-	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	
-	1	1	1-455888-8	SPACER, CRIMPER	82	
-	2	2	2079383-4	SCR, BHSC, RoHS (M4 X 8)	79	
-	1	1	1803096-1	EXTENSION PLATE	78	
-	1	1	1803607-3	DOCUMENTATION PACKAGE	71	
-	1	1	2119791-7	DEPRESSOR, WIRE	70	
-	1	1	2119943-1	WASHER, SPACER	69	
-	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	
-	1	1	1-2168083-3	SCR, SKT HD CAP, RoHS, M3 X 16	57	
-	1	1	1338683-8	FEED PAWL	56	
-	4	4	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	54	
-	2	2	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	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	1-1803583-7	APPLICATOR BASIC ASSEMBLY, SF	46	
-	1	1	1803515-2	RAM ASSEMBLY, SF ATLANTIC	44	
-	1	1	1803602-2	SCR, BHSC, RoHS (M8 X 40)	41	
-	1	1	3-1752356-3	SUPPORT, TERMINAL	34	
-	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33	
-	2	2	2-2844962-1	SPACER, CYLINDRICAL, STRIP GUIDE	30	
-	1	1	2844992-6	ASSEMBLY, STRIP GUIDE	29	
-	1	1	1-455888-0	SPACER, CRIMPER	28	
-	2	2	22283-1	SPRING, COMPRESSION	27	
-	1	1	240792-1	DRAG, TERMINAL	25	
-	1	1	1320928-4	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	1803013-1	STRIPPER, SIDE FEED	19	
-	1	1	2119806-1	INSERT, SHEAR	13	
-	1	1	4-22280-7	SPRING, COMPRESSION	12	
-	1	1	1-356885-3	STOP, SHEAR	11	
-	1	1	2119805-7	SHEAR HOLDER, FRONT	10	
-	1	1	318059-9	FLOATING SHEAR, FRONT	9	
-	1	2	1	5-1803252-7	ANVIL, COMBINATION	8
-	1	1	4-240641-7	SPACER	7	
-	-	-	-	-	6	
-	1	1	1803080-9	DEPRESSOR, SHEAR	5	
-	1	1	2-238011-1	BLOCK, CRIMPER SPACER	4	
-	1	2	1	7-1803018-1	CRIMPER, INSULATION O	3
-	1	1	455888-6	SPACER, CRIMPER	2	
-	1	2	1	4-1803224-0	CRIMPER, WIRE	1

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		MATERIAL:		FINISH:		WEIGHT:		SCALE:		SHEET:		REV:	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES	FINISH			A	00779	1	4	B	

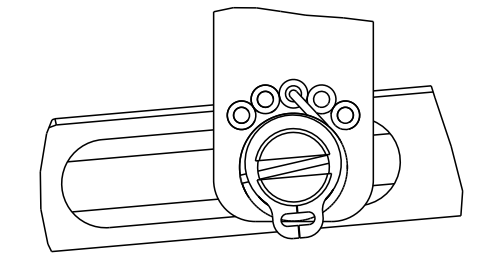
LOC	DIST	REVISIONS					
A	66	P	LTN	DESCRIPTION	DATE	OWN	APVD
		-		SEE SHEET 1	-	-	-

FEED TYPE

PNEUMATIC

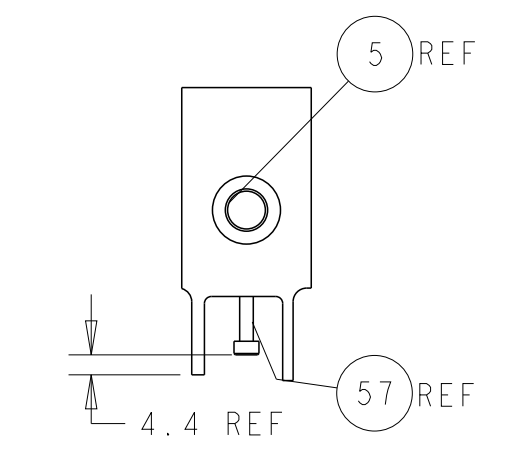
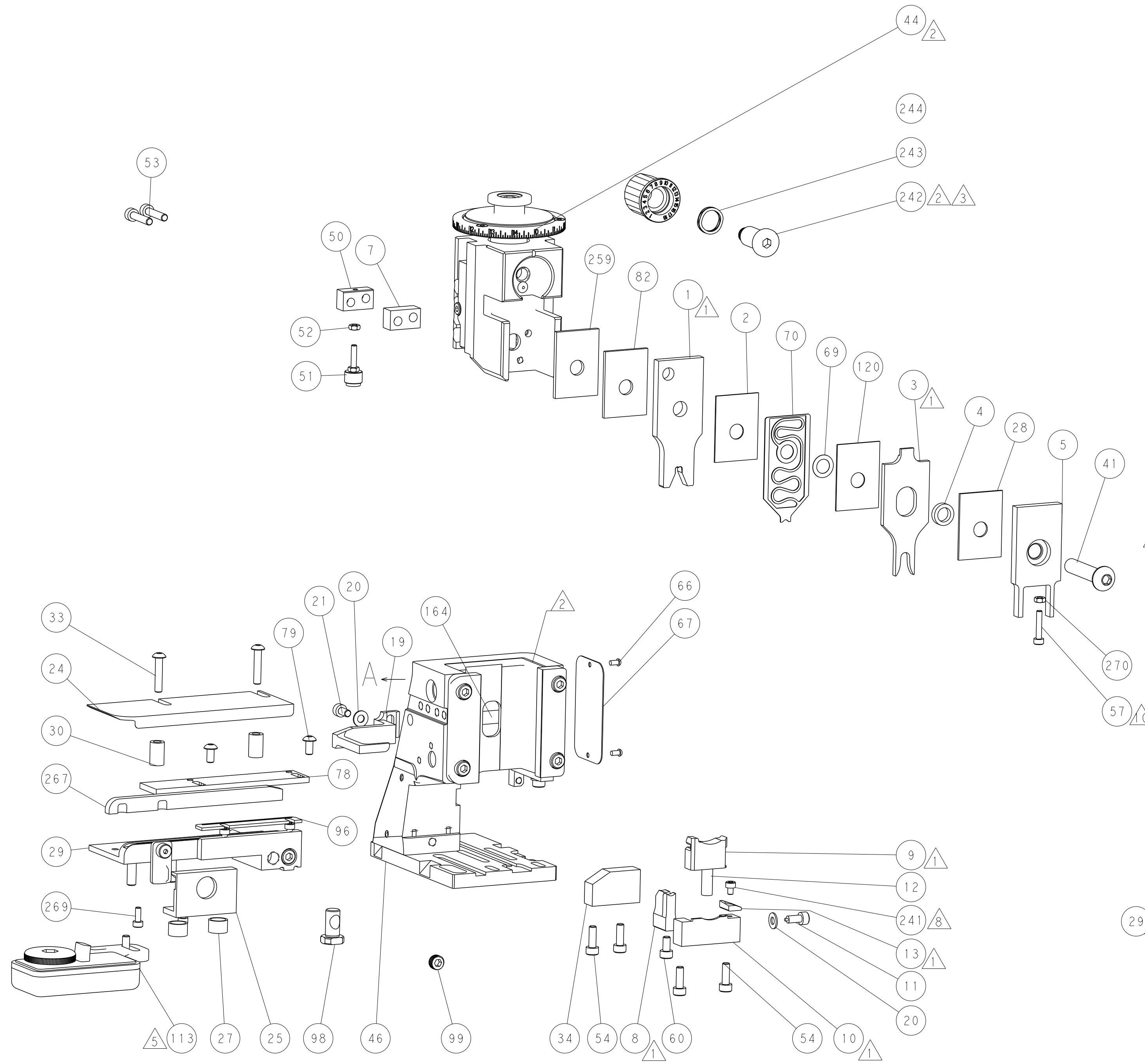
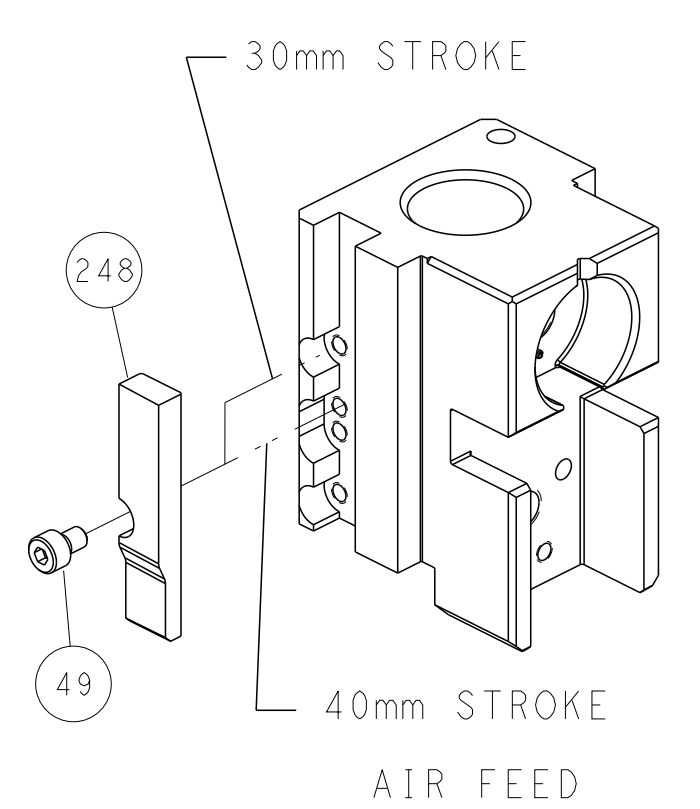


FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)

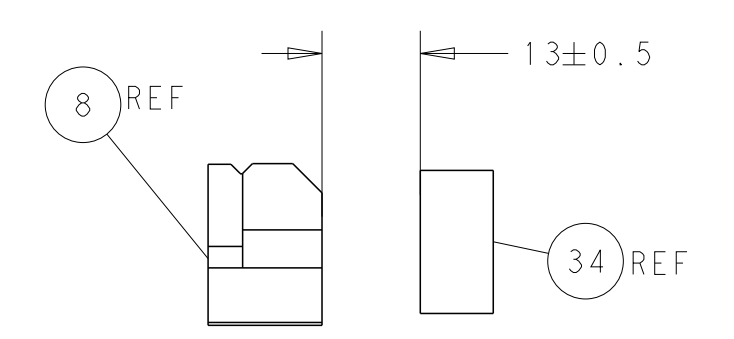


DETAIL A

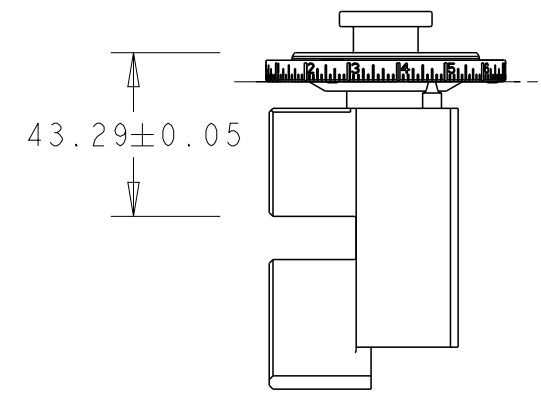
CAM POSITION



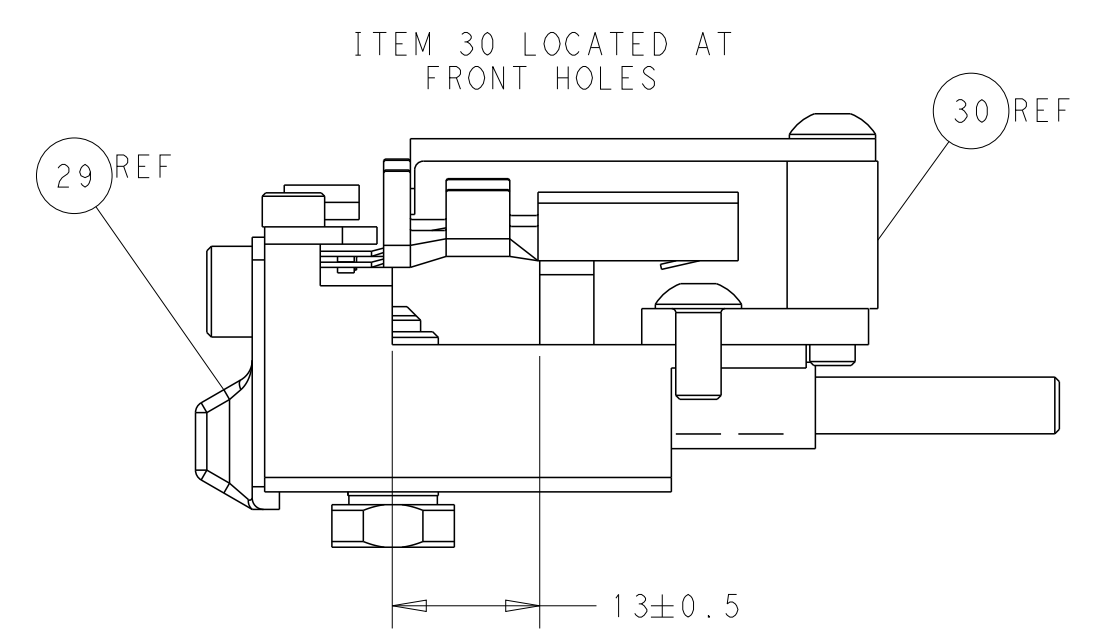
SHEAR DEPRESSOR DETAIL



TERMINAL SUPPORT LOCATION



RAM SETUP



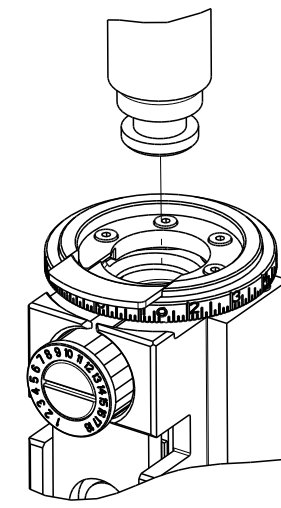
FEED TRACK POSITION GUIDE BY INSULATION BARREL

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

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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: 2836619	RESTRICTED TO: SCALE: 1:2 SHEET: 2 OF 4 REV: B
MATERIAL:		WEIGHT:	Customer Accessible Production Drawing

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2836619-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2836619-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	3.94 mm [1.55]	F
INSUL	5.59 mm [2.20]	O
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: FCI TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: 9.5 BOX TERMINAL, DCS-1			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
7.19-7.95 mm [1.283-.313 IN]		Ø3.23-4.30 mm [1.127-.169 IN]	
TERMINAL APPLICATION SPECIFICATION	NONE		

TERMINAL DATA: FCI TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: 9.5 BOX TERMINAL, DCS-1			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
7.19-7.95 mm [1.283-.313 IN]		Ø3.23-4.30 mm [1.127-.169 IN]	
TERMINAL APPLICATION SPECIFICATION	NONE		

TERMINALS APPLIED				
TE TERMINAL	FCI TERMINAL	TE SEAL	FCI SEAL	CABLE DIAMETER
2113176-2	F582210	1572474-1	60993301	4.3mm MAX [1.169 IN MAX]
2113176-3	F192210	1572474-2	15327788	4.3mm MAX [1.169 IN MAX]
2113176-6	33517391	2113173-1	60993308	4.2mm MAX [1.165 IN MAX]
2113176-7	33517389	2113173-2	13546490	4.2mm MAX [1.165 IN MAX]

TERMINALS APPLIED				
TE TERMINAL	FCI TERMINAL	TE SEAL	FCI SEAL	CABLE DIAMETER
2113176-1	60070461	1572474-1	60993301	4.3mm MAX [1.169 IN MAX]
2113176-4	60070462	1572474-2	15327788	4.3mm MAX [1.169 IN MAX]
2113176-5	10780235	2113173-1	60993308	4.2mm MAX [1.165 IN MAX]
2113176-8	13960627	2113173-2	13546490	4.2mm MAX [1.165 IN MAX]

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
6.00mm2	2.88+/-0.05 [1.113+/-0.02]	5.6
5.00mm2	2.67+/-0.05 [1.05+/-0.02]	8.1
4.50mm2	2.57+/-0.05 [1.01+/-0.02]	9.2

- 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 THIS APPLICATOR APPLIES TERMINAL WITH A SEAL.
- 8 GRIND AT ASSEMBLY.
- 9 FEED ADJUSTMENT WILL BE REQUIRED WHEN SWITCHING TERMINALS.
- 10 APPLY TORO-SEAL IN ALLEN SOCKET TO FILL HOLE AFTER FLAT HD HAD BEEN ADJUSTED TO CORRECT HEIGHT AT QUALIFICATION.

***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)

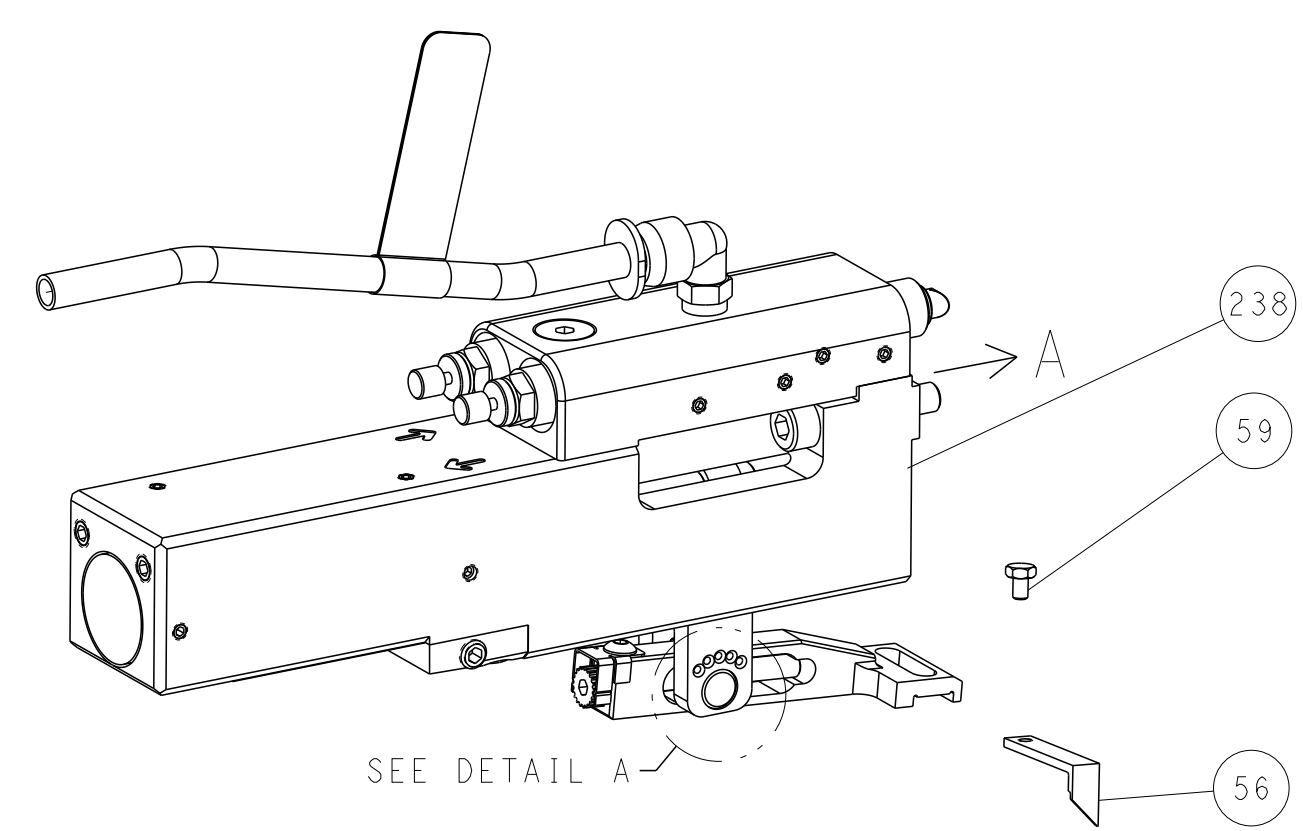
LOC	DIST	REV	DATE	BY	APPV
A	66				

REV	DATE	DESCRIPTION	DATE	BY	APPV
-	-	SEE SHEET 1	-	-	-
-	1	5018030-1 NUT, HEX, REG, RoHS, M3			270
-	2	2168083-1 SCR, SKT HD CAP, RoHS, M3 X 8.0			269
-	1	1633782-3 FENCE			267
-	1	1803078-2 SPACER, PRECISION			259
-	1	2119082-5 CAM, SNAIL, INSULATION ADJUSTMENT			244
-	1	2079764-1 WASHER, WAVE SPRING, CREST-TO-CREST			243
-	1	2119083-1 RETAINER, INSULATION DIAL			242
-	1	7-18023-7 SCR, SKT HD CAP M3 X 4.0			241
-	1	2844940-2 AIR FEED MODULE			238
-	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
-	4	2168083-9 SCR, SKT HD CAP, RoHS, M4 X 20			143
-	1	1-1803583-8 APPLICATOR BASIC ASSEMBLY, SF			141
-	1	1803516-2 RAM ASSEMBLY, SF PACIFIC			140
-	1	455888-6 SPACER, CRIMPER			120
-	1	2119955-1 ASSY, LUBRICATOR, SIDE FEED			113
-	1	2844908-1 SCREW, LOCKING			99
-	1	2844907-1 POST, LOCKING			98
-	1	1-690438-0 FRONT STRIP GUIDE			96
-	1	1-455888-8 SPACER, CRIMPER			82
-	2	2079383-4 SCR, BHSC, RoHS (M4 X 8)			79
-	1	1803096-1 EXTENSION PLATE			78
-	1	1803607-3 DOCUMENTATION PACKAGE			71
-	1	2119791-7 DEPRESSOR, WIRE			70
-	1	2119943-1 WASHER, SPACER			69
-	1	2119740-1 TAG, IDENTIFICATION			67
-	2	2168078-1 SCREW, DRIVE, RH, RoHS, 2 x .188			66
-	1	5-18022-5 SCR, HEX HD CAP, M4 X 6.0			59
-	1	1-2168083-3 SCR, SKT HD CAP, RoHS, M3 X 16			57
-	1	1338683-8 FEED PAWL			56
-	2	2168083-9 SCR, SKT HD CAP, RoHS, M4 X 20			53
-	1	5018030-1 NUT, HEX, REG, RoHS, M3			52
-	1	811242-5 BUMPER, HOLD DOWN			51
-	1	690753-2 SPACER, TONKER			50
-	1	18023-9 SCR, SKT HD CAP M4 X 6.0			49
-	1	1803602-2 SCR, BHSC, RoHS (M8 X 40)			41
-	1	3-1752356-3 SUPPORT, TERMINAL			34
-	2	2079383-5 SCR, BHSC, RoHS (M4 X 20)			33
-	2	2-2844962-1 SPACER, CYLINDRICAL, STRIP GUIDE			30
-	1	2844992-6 ASSEMBLY, STRIP GUIDE			29
-	1	1-455888-0 SPACER, CRIMPER			28
-	2	22283-1 SPRING, COMPRESSION			27
-	1	240792-1 DRAG, TERMINAL			25
-	1	1320928-4 STRIP GUIDE			24
-	1	2168083-2 SCR, SKT HD CAP, RoHS, M4 X 8.0			21
-	2	1-18028-2 WASHER, FLAT, REG M4			20
-	1	1803013-1 STRIPPER, SIDE FEED			19
-	1	2119806-1 INSERT, SHEAR			13
-	1	4-22280-7 SPRING, COMPRESSION			12
-	1	1-356885-3 STOP, SHEAR			11
-	1	2119805-7 SHEAR HOLDER, FRONT			10
-	1	318059-9 FLOATING SHEAR, FRONT			9
-	1	5-1803252-7 ANVIL, COMBINATION			8
-	1	4-240641-7 SPACER			7
-	-	-			6
-	1	1803080-9 DEPRESSOR, SHEAR			5
-	1	2-238011-1 BLOCK, CRIMPER SPACER			4
-	1	7-1803018-1 CRIMPER, INSULATION O			3
-	1	455888-6 SPACER, CRIMPER			2
-	1	4-1803224-0 CRIMPER, WIRE			1

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG: B. WEAVER 01FEB2017		REV: 1	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	APVD: T. ELBIN 01FEB2017	NAME: T. ELBIN
	ANGLES ±	FINISH ±				PRODUCT SPEC	APPLICATION SPEC
MATERIAL:						WEIGHT	SCALE: 1:2
						Customer Accessible Production Drawing	SHEET 3 OF 4

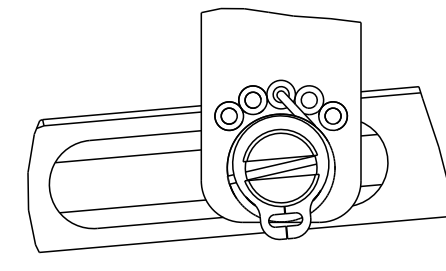
LOC	DIST	REVISIONS					
A	66	P	LTN	DESCRIPTION	DATE	OWN	APVD
		-		SEE SHEET 1	-	-	-

FEED TYPE PNEUMATIC



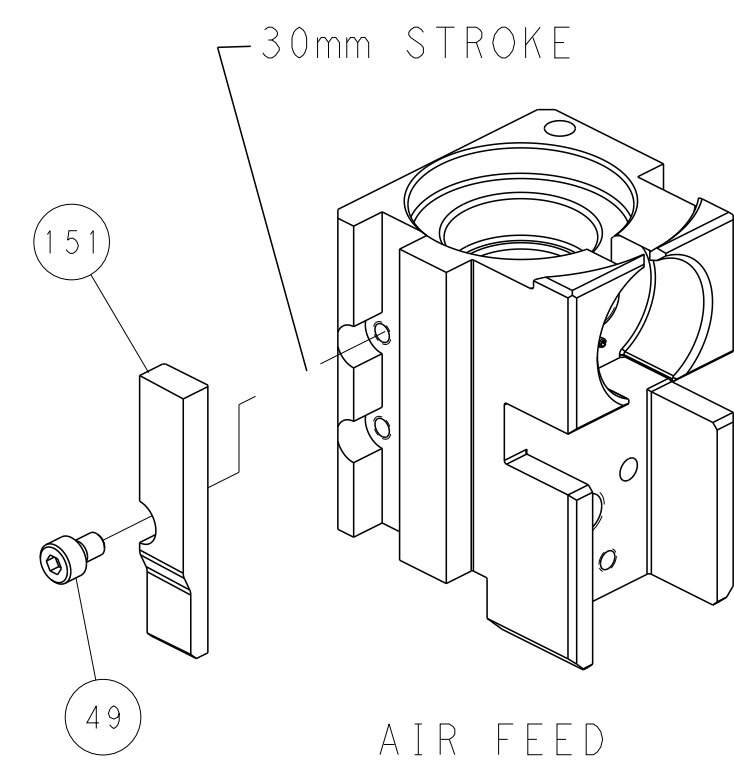
SEE DETAIL A

FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)

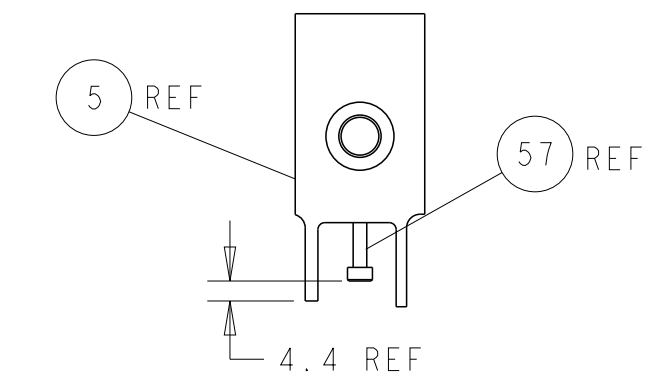
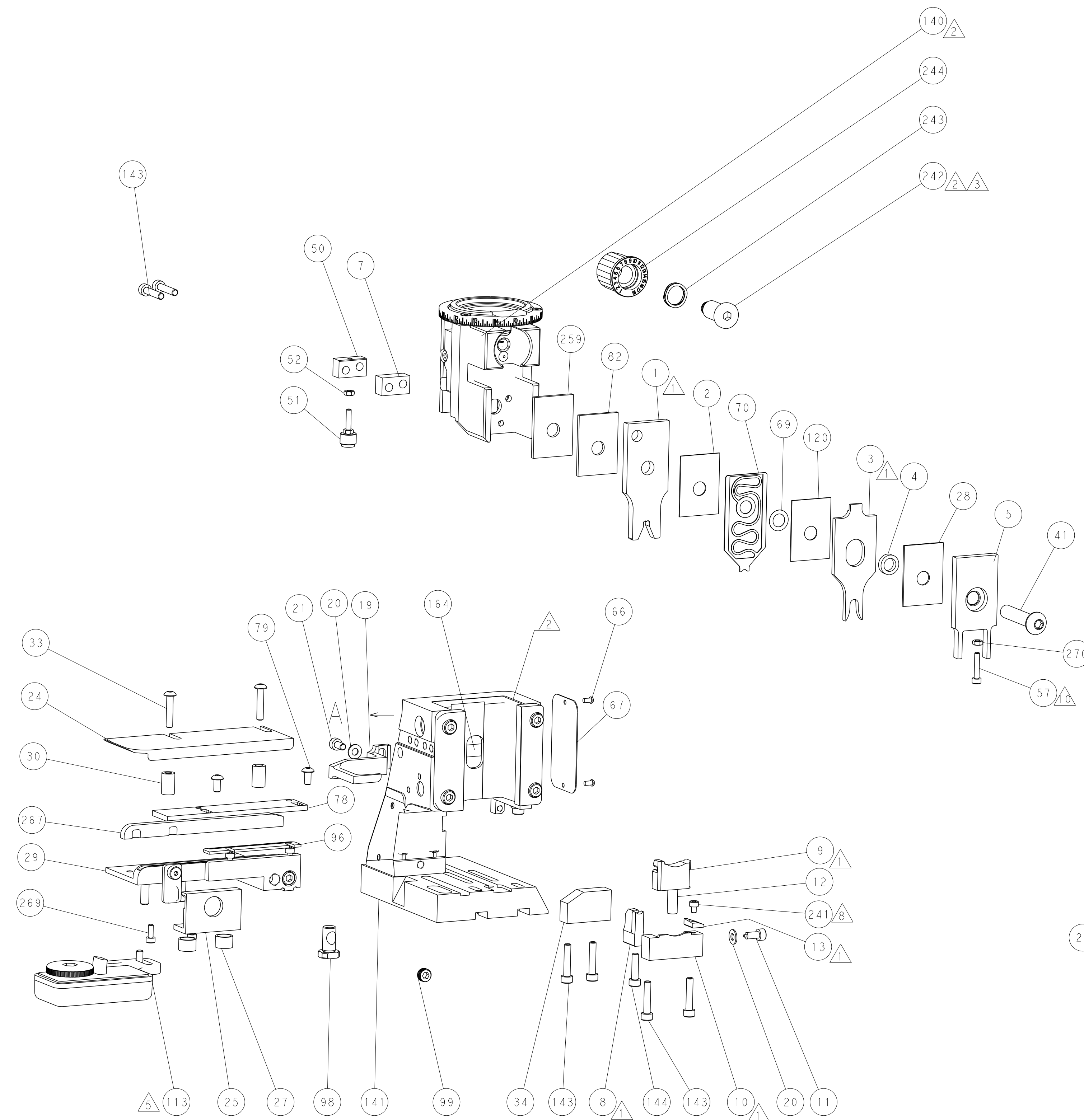


DETAIL A

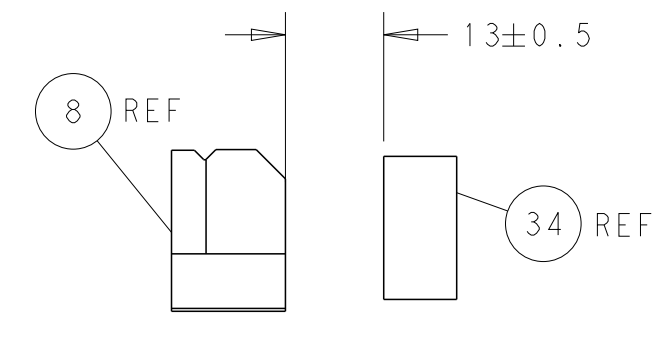
CAM POSITION



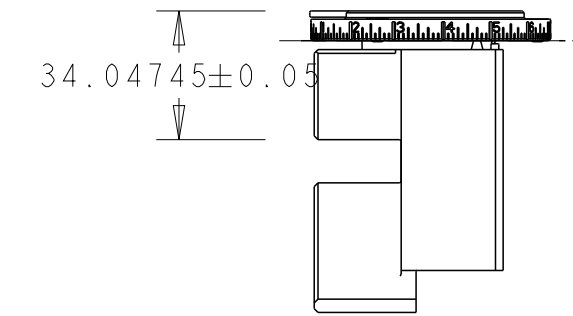
AIR FEED



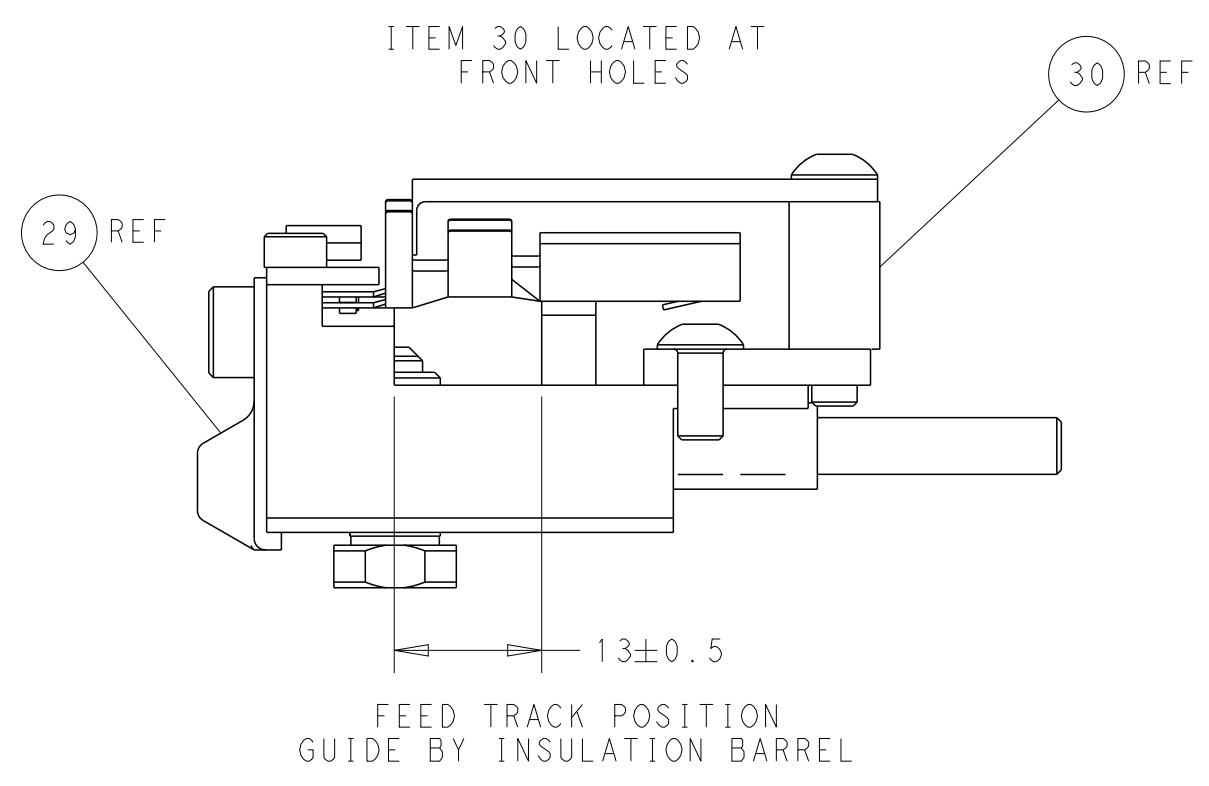
SHEAR DEPRESSOR DETAIL



TERMINAL SUPPORT LOCATION



RAM SETUP



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)

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DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± MATERIAL: - FINISH: -		NAME: Ocean Side Feed Applicator APPLICATION SPEC: - SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2836619 SCALE: 1:2 SHEET: 4 OF 4 REV: B	RESTRICTED TO: - Customer Accessible Production Drawing