



APPLICATOR INSTRUCTIONS
408-35042

SEAL INSULATION
DIAMETER RANGE
2.7-3.0 mm
2.7-3.0 mm



- *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.

SEAL INSULATION DIAMETER RANGE
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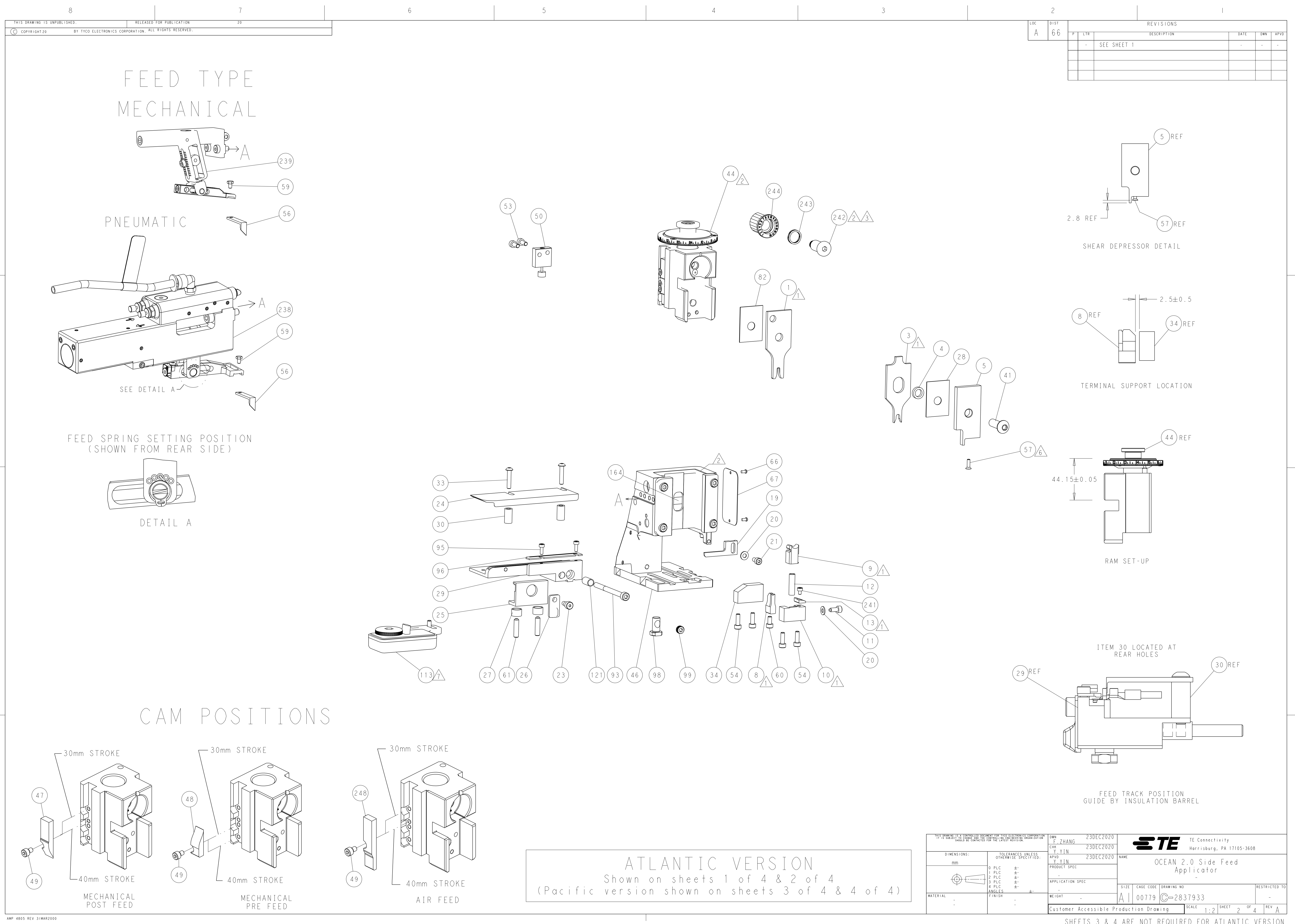
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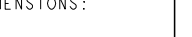
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TE TE Connectivity
Harrisburg, PA 17105-3608

SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

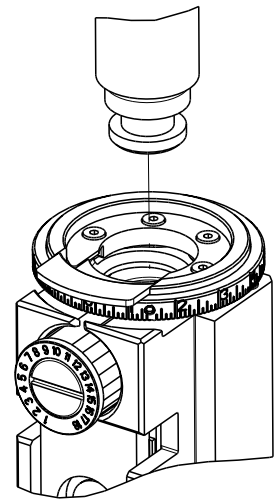


LOC		DIST		REVISONS			
A	66	P	LYR	DESCRIPTION	DATE	DWN	APVD
		-		SEE SHEET 1	-	-	-

1. THIS DRAWING IS CONTROLLED DOCUMENT. ALL REVISIONS MUST BE APPROVED BY THE DESIGN ENGINEER. NO CHANGES OR MODIFICATIONS TO THIS DRAWING ARE TO BE MADE WITHOUT THE WRITTEN AUTHORIZATION OF THE DESIGN ENGINEER.		DWN E. ZHANG 23DEC2020		 TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		NAME	
mm		0 PLC ±		OCEAN 2.0 Side Feed	
		1 PLC ±		Applicator	
		2 PLC ±		-	
		3 PLC ±		-	
		4 PLC ±		-	
		ANGLES ±		-	
FINISH		-		-	
MATERIAL		-		-	
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PART NUMBER	REVISION	DESCRIPTION
2-2837933-1	A	FINE CRIMP HEIGHT ADJUST
2-2837933-2	A	FINE CRIMP HEIGHT ADJUST
7-2837933-7	A	CRIMP TOOLING KIT

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.59 mm [.102]	F
INSUL	4.39 mm [.164]	O
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: APTIV TERMINAL		APTIV CRIMP SPECIFICATION	
TERMINAL NAME: MALE CONTACT DCS2-2.8 APPLICATION WITH SWS			
WIRE STRIP LENGTH 3.90-4.70 mm [.154-.185 IN]		TERMINAL INSULATION DIAMETER RANGE Ø2.20-3.00 mm [.087-.118 IN]	
TERMINAL APPLICATION SPECIFICATION		PAGE 7 OF 90841100 Rev - - - - - - AT9106	

TERMINALS APPLIED			
TE TERMINAL	APTIV TERMINAL	TE SEAL	APTIV SEAL
2113168-1	60110742	2113169-1	60994034
2113168-2	33500683	2113169-1	10779161
2113168-3	60110741		
2113168-4	10756353		
2113168-5	60110744		
2113168-6	33512923		
2113168-7	60110541		
2113168-8	60110544		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
2.50mm2	1.75+/-0.05 [.069+/- .002]	6.2
2.00mm2	1.58+/-0.03 [.062+/- .001]	8.0
1.50mm2	1.55+/-0.05 [.061+/- .002]	8.2



- 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. 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.
- 7 TERMINAL LUBRACANT IS RECOMMENDED.

TERMINAL DATA: APTIV TERMINAL		APTIV CRIMP SPECIFICATION	
TERMINAL NAME: FEMALE CONTACT		DCS2-2.8 APPLICATION WITH SWS	
WIRE STRIP LENGTH 3.90-4.70 mm [.154-.185 IN]		 TERMINAL INSULATION DIAMETER RANGE Ø2.20-3.00 mm [.087-.118 IN]	
TERMINAL APPLICATION SPECIFICATION		PAGE 7 OF 90841100 Rev - - - - AT9106	

TERMINALS APPLIED			
TE TERMINAL	APTIV TERMINAL	TE SEAL	APTIV SEAL
3311743-1	60012141	2113169-1	60994034
3311743-2	60012144	2113169-2	10779161
3311743-3	60012941		
3311743-4	60012944		
3311743-5	60014041		
3311743-6	6001442		
3311743-7	60014244		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
2.50mm2	1.75+/-0.05 [.069+/- .002]	6.2
2.00mm2	1.58+/-0.03 [.062+/- .001]	8.0
1.50mm2	1.55+/-0.05 [.061+/- .002]	8.2

*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	#	LYR	DESCRIPTION	DATE
			-	SEE SHEET 1	-

-	1	1	2119082-7	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	2-690438-8	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	455888-6	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	1803382-6	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	1-1752356-7	SUPPORT, TERMINAL	34
-	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	3-2844962-0	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	1-2844938-8	PLATE, STRIP GUIDE	29
-	1	1	455888-5	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	1320928-6	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	1-1803512-3	ANVIL, COMBINATION	8
-	-	-	-	-	7
-	-	-	-	-	6
-	1	1	2-2119781-4	DEPRESSOR, SHEAR	5
-	1	1	3-238011-5	BLOCK, CRIMPER SPACER	4
-	1	1	2-1803712-6	CRIMPER, INSULATION O	3
-	-	-	-	-	2
-	1	1	1633588-6	CRIMPER, WIRE	1

THIS DRAWING IS CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE AND TO CONTROL THE ENGINEERING ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST REVISION.		OWN F. ZHANG	23DEC2020	TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm		CHK Y. YIN	23DEC2020	NAME OCEAN 2.0 Side Feed Applicator	
TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		APVD Y. YIN	23DEC2020	PRODUCT SPEC	
MATERIAL -		FINISH -	-	APPLICATION SPEC	
-		WEIGHT -	-	SIZE A1	
-		Customer Accessible Production Drawing	SCALE 1:2	SHEET 3	REV A

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

DETAIL A

30mm STROKE

142

49

MECHANICAL POST FEED

30mm STROKE

48

49

MECHANICAL PRE FEED

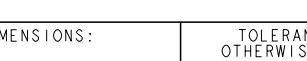
30mm STROKE

151

49

AIR FEED

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

THIS DRAWING IS A COMPUTER GENERATED DRAWING FOR TWO ELECTRONIC COORDINATION IT IS SUBJECT TO THE FOLLOWING CONDITIONS: 1. THE USER SHALL BE RESPONSIBLE FOR THE CORRECTNESS OF THE DATA AND THE INFORMATION SHOULD BE CONTACTED FOR THE LATEST REVISION.		DWN F. ZHANG 23DEC2020		TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:			
		0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		NAME APVD Y.YIN 23DEC2020 PRODUCT SPEC - APPLICATION SPEC -	
MATERIAL -		FINISH -		SIZE A	
WEIGHT -		CAGE CODE 00779		DRAWING NO C=2837933	
RESTRICTED TO -		SCALE 1:2		SHEET 4	
Customer Accessible Production Drawing		SCALE 1:2		SHEET 4	
REV A		SCALE 1:2		SHEET 4	

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION