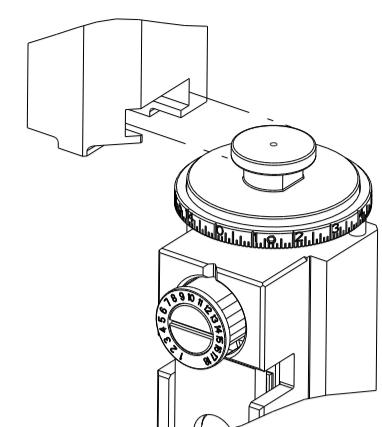


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2266361-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266361-2	C	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2266361-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER

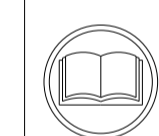


APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	3.30 mm [.130]	F
INSUL	4.70 mm [.185]	OV

APPLICATOR INSTRUCTIONS  
408-35042

TERMINAL DATA: FCI TERMINAL		FCI CRIMP SPECIFICATION	
TERMINAL NAME: DCS-1 9.5 FEMALE TERMINAL			
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE		
7.50-8.50 mm [.295-.335 IN]	Ø2.70-4.40 mm [.106-.173 IN]		
TERMINAL APPLICATION SPECIFICATION	90840500 Rev F		
TERMINALS APPLIED			
TE TERMINAL	FCI TERMINAL	TE TERMINAL	FCI TERMINAL
2113172-1	60070251	1-2113172-6	60070151
1-2113172-2	60070252	1-2113172-7	60070152

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
4.00mm2	2.65 +/- 0.05 [.104 +/- .002]	7.3
2.50mm2	2.40 +/- 0.05 [.094 +/- .002]	9.4



- 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.
- 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					
		P	LTN	DESCRIPTION	DATE	OWN	APPD
A	66			RELEASED	19JUL2014	BH	BH
				ECR-21-005374	20MAY2021	JWC	TE
				ECR-21-112188	03SEP2021	LG	TE

-	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	2844908-1	SCREW, LOCKING	99
-	1	1	2844907-1	POST, LOCKING	98
-	1	1	1-455888-0	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	2119791-5	DEPRESSOR, WIRE	70
-	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	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	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	1803515-2	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
-	4	4	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	31
-	2	2	2-2844962-6	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	2844992-3	ASSEMBLY, STRIP GUIDE	29
-	1	1	980371-4	SCR, SKT HD SHLDR 5.0 DIA X 6.0	28
-	2	2	22281-8	SPRING, COMPRESSION	27
-	1	1	356835-1	LEVER, DRAG RELEASE	26
-	1	1	240792-1	DRAG, TERMINAL	25
-	1	1	1320928-4	STRIP GUIDE	24
-	1	1	2-690438-2	FRONT STRIP GUIDE	23
-	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
-	1	1	1-18028-2	WASHER, FLAT, REG M4	20
-	1	1	2119533-1	STRIPPER, SIDE FEED	19
-	1	1	318563-1	GUARD, FRONT CHIP	15
-	1	1	1633782-4	FENCE	14
-	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	454276-5	FLOATING SHEAR, FRONT	9
-	1	2	1633925-6	ANVIL, COMBINATION	8
-	-	-	-	-	7
-	-	-	-	-	6
-	1	1	1-2119757-2	DEPRESSOR, SHEAR	5
-	1	1	238011-1	BLOCK, CRIMPER SPACER	4
-	1	2	4-2119785-5	CRIMPER, INSULATION OVERLAP PREMIUM	3
-	1	1	1-455888-5	SPACER, CRIMPER	2
-	1	2	456410-5	CRIMPER, WIRE PREMIUM	1
-	77	72	-2	PART NO	ITEM NO
				DESCRIPTION	

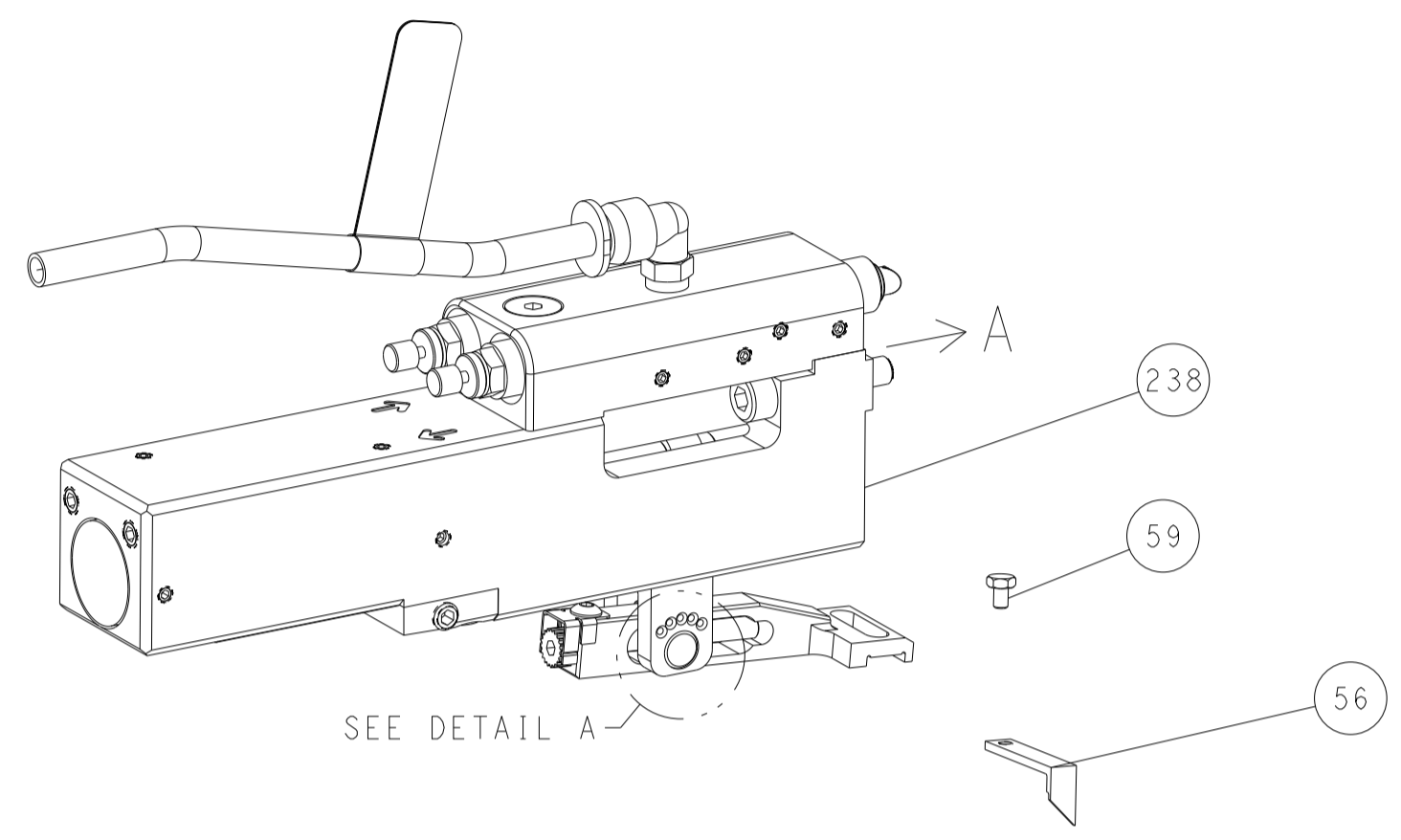
ATLANTIC VERSION  
 Shown on sheets 1 of 4 & 2 of 4  
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		OWN BOB HIGMAN 01JUL2014		TE Connectivity Harrisburg, PA 17105-3608	
0 PLC ±		1 PLC ±		CHK G. BAILEY 01JUL2014		NAME Ocean Side Feed Applicator	
2 PLC ±		3 PLC ±		APPD D. STOUGH 01JUL2014		SIZE CAGE CODE DRAWING NO RESTRICTED TO	
4 PLC ±		ANGLES FINISH		APPLICATION SPEC		A1 00779 C=2266361	
MATERIAL				WEIGHT		Customer Accessible Production Drawing SCALE 1:2 SHEET 1 OF 4 REV C	

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

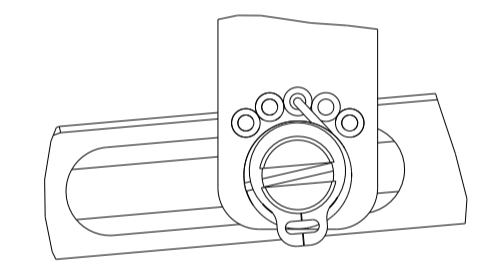
# FEED TYPE

## PNEUMATIC



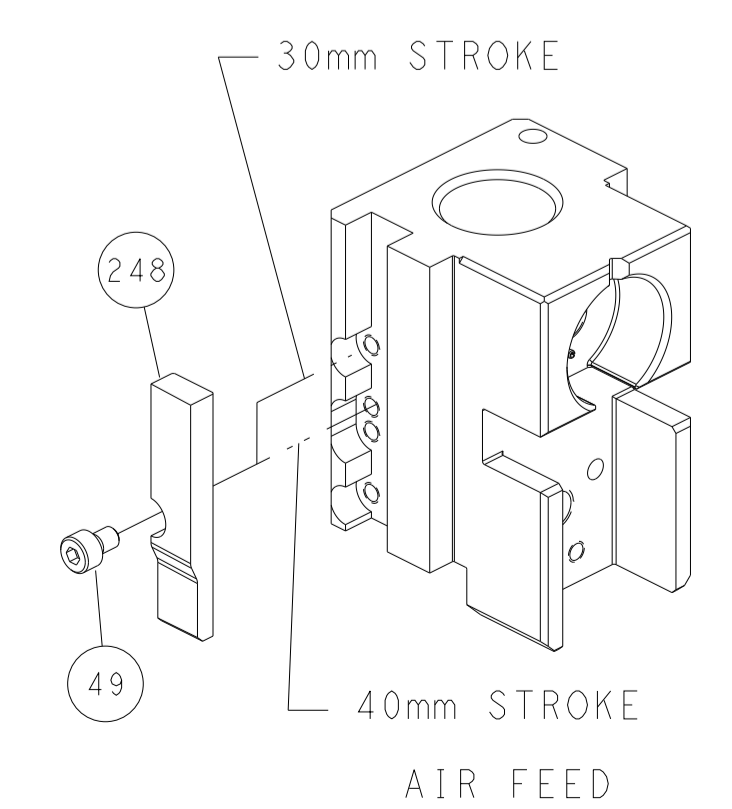
SEE DETAIL A

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

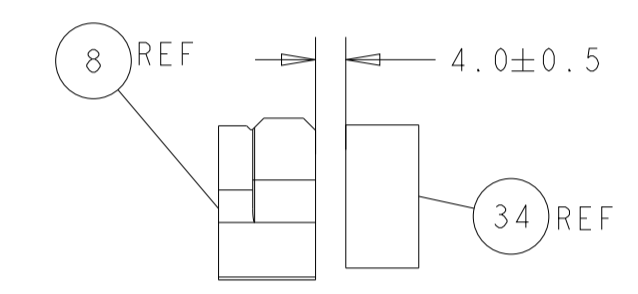
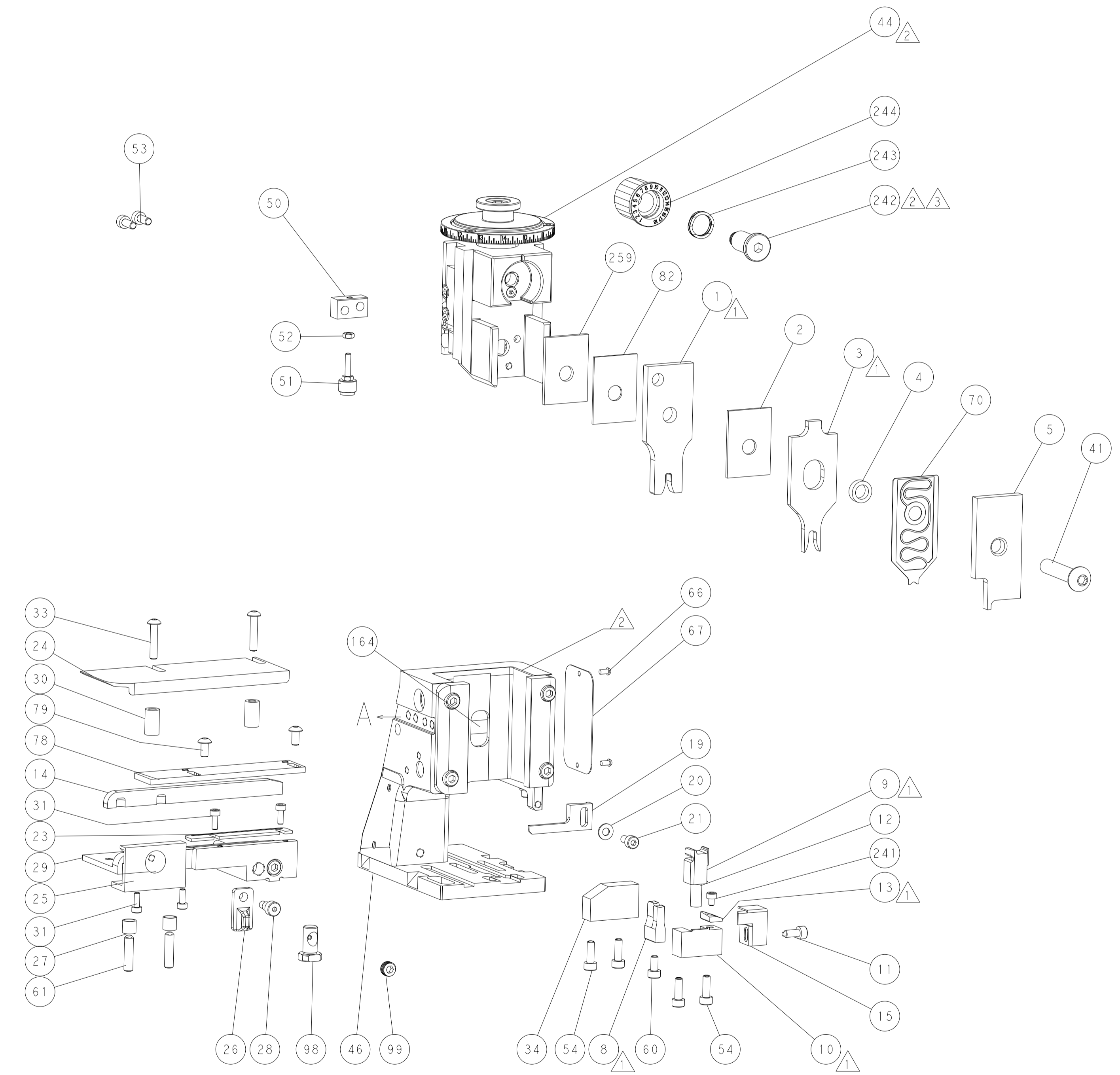


DETAIL A

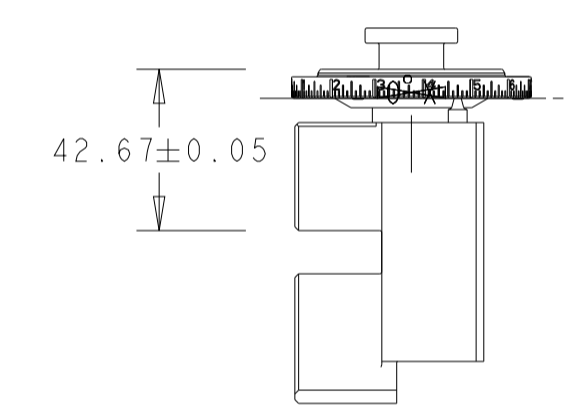
## CAM POSITION



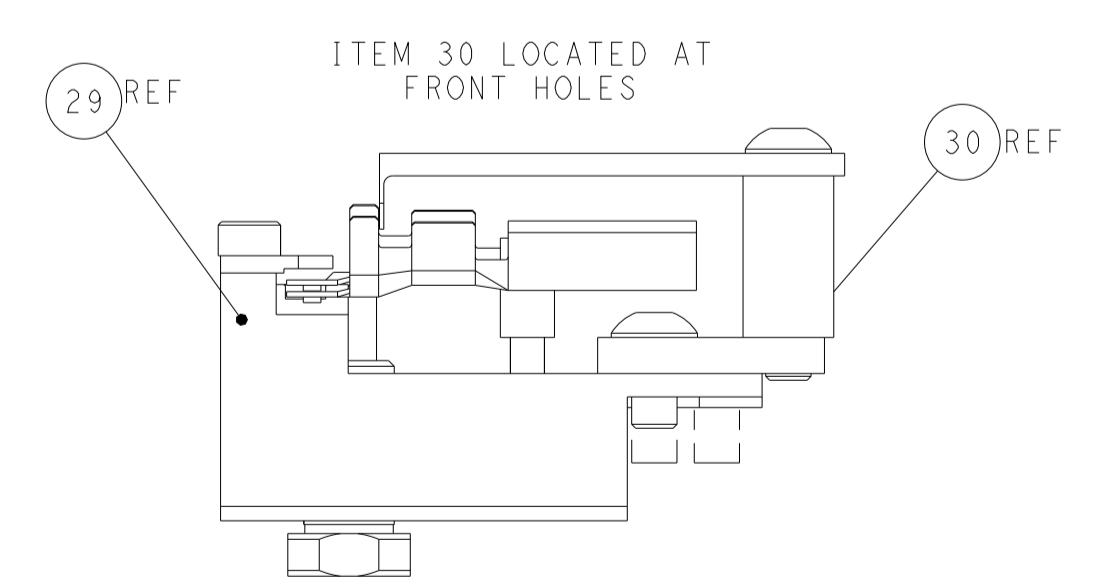
AIR FEED



TERMINAL SUPPORT LOCATION



RAM SETUP VIEW



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:		OWN BOB HIGMAN 01 JUL 2014	TE Connectivity Harrisburg, PA 17105-3608
mm	0 PLC ±	1 PLC ±	2 PLC ±	CHK G. BAILEY 01 JUL 2014	
MATERIAL:	FINISH:	3 PLC ±	4 PLC ±	APVD D. STOUGH 01 JUL 2014	NAME Ocean Side Feed Applicator
		ANGLES:		PRODUCT SPEC	
				APPLICATION SPEC	SIZE CAGE CODE DRAWING NO
				WEIGHT	RESTRICTED TO
				Customer Accessible Production Drawing	SCALE 1:2 SHEET 2 OF 4 REV C

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2266361-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266361-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR  
 INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	3.30 mm [1.130]	F
INSUL	4.70 mm [1.185]	OV
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: FCI TERMINAL		FCI CRIMP SPECIFICATION	
TERMINAL NAME: DCS-1 9.5 FEMALE TERMINAL			
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE		
7.50-8.50 mm [1.295-.335 IN]	Ø2.70-4.40 mm [1.06-.173 IN]		
TERMINAL APPLICATION SPECIFICATION	90840500 Rev F		
TERMINALS APPLIED			
TE TERMINAL	FCI TERMINAL	TE TERMINAL	FCI TERMINAL
2113172-1	60070251	1-2113172-6	60070151
1-2113172-2	60070252	1-2113172-7	60070152

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
4.00mm2	2.65+/-0.05 [1.04+/-0.002]	7.3
2.50mm2	2.40+/-0.05 [1.094+/-0.002]	9.4



- 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.

**\*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	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	1-1803583-0	APPLICATOR BASIC ASSEMBLY, SF	141
-	1	1803516-2	RAM ASSEMBLY, SF PACIFIC	140
-	1	2844908-1	SCREW, LOCKING	99
-	1	2844907-1	POST, LOCKING	98
-	1	1-455888-0	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	2119791-5	DEPRESSOR, WIRE	70
-	1	2119740-1	TAG IDENTIFICATION	67
-	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	2	2-18032-5	SCR, SET, FLT PNT, M5 X 20.0	61
-	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	1	1338683-8	FEED PAWL	56
-	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	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
-	4	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	31
-	2	2-2844962-6	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	2844992-3	ASSEMBLY, STRIP GUIDE	29
-	1	980371-4	SCR, SKT HD SHLDR 5.0 DIA X 6.0	28
-	2	22281-8	SPRING, COMPRESSION	27
-	1	356835-1	LEVER, DRAG RELEASE	26
-	1	240792-1	DRAG, TERMINAL	25
-	1	1320928-4	STRIP GUIDE	24
-	1	2-690438-2	FRONT STRIP GUIDE	23
-	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
-	1	1-18028-2	WASHER, FLAT, REG M4	20
-	1	2119533-1	STRIPPER, SIDE FEED	19
-	1	318563-1	GUARD, FRONT CHIP	15
-	1	1633782-4	FENCE	14
-	1	2119806-1	INSERT, SHEAR	13
-	1	3-22280-3	SPRING, COMPRESSION	12
-	1	1-356885-4	STOP, SHEAR	11
-	1	2119805-1	SHEAR HOLDER, FRONT	10
-	1	454276-5	FLOATING SHEAR, FRONT	9
-	1	1633925-6	ANVIL, COMBINATION	8
-	-	-	-	7
-	-	-	-	6
-	1	1-2119757-2	DEPRESSOR, SHEAR	5
-	1	238011-1	BLOCK, CRIMPER SPACER	4
-	1	4-2119785-5	CRIMPER, INSULATION OVERLAP PREMIUM	3
-	1	1-455888-5	SPACER, CRIMPER	2
-	1	456410-5	CRIMPER, WIRE PREMIUM	1
-	77	-22	PART NO	ITEM NO

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		APVD		NAME	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	APVD	NAME
	ANGLES	FINISH					
MATERIAL				WEIGHT		SCALE	REV

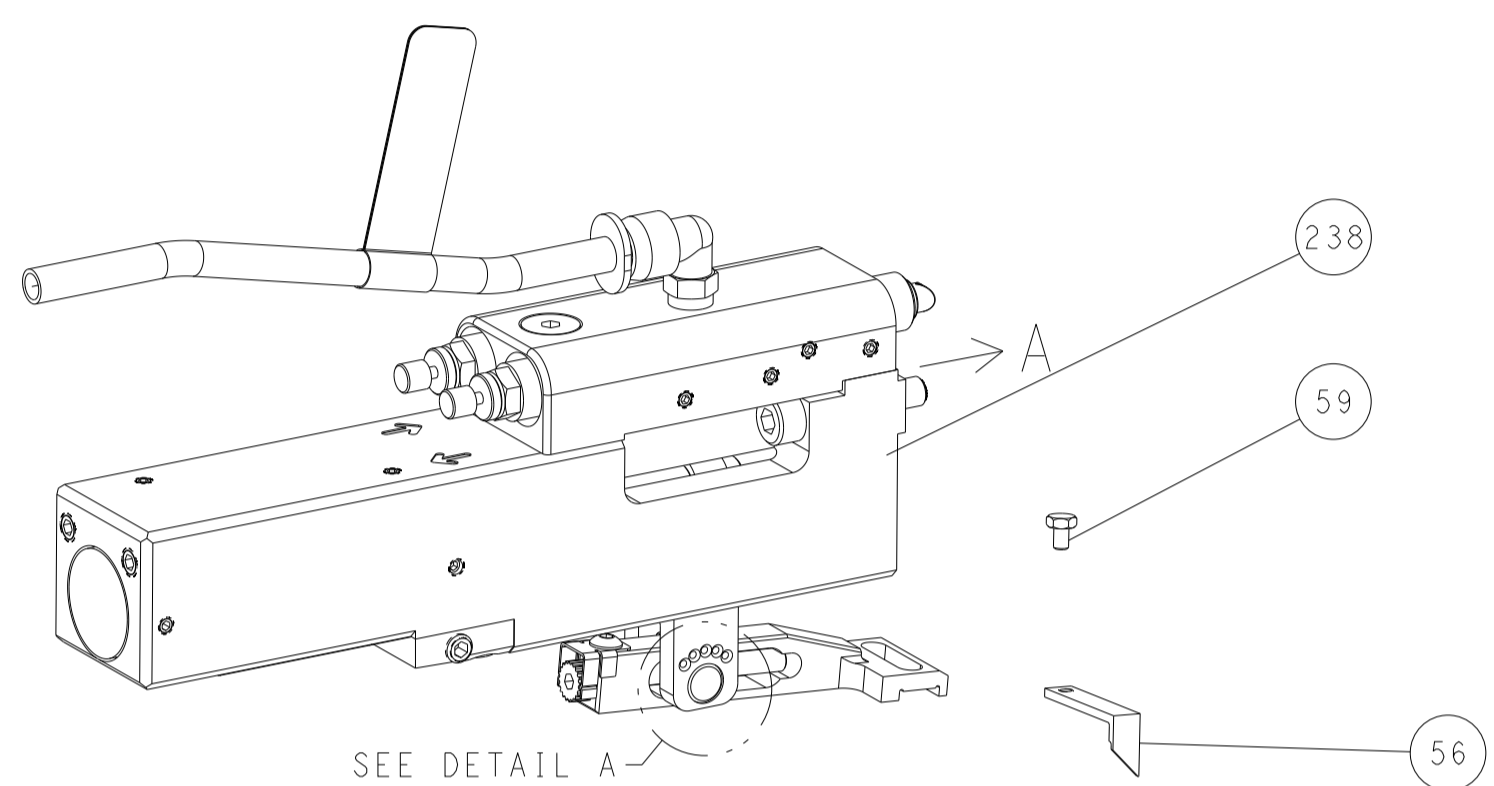


Ocean Side Feed  
 Applicator

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

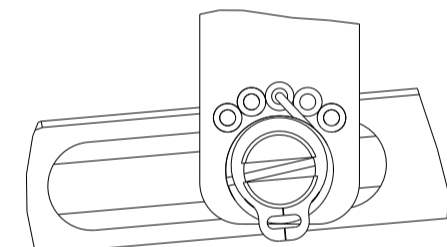
LOC	DIST	REVISIONS			
P	LTN	DESCRIPTION	DATE	DWN	APVD
A	66	SEE SHEET 1	-	-	-

### FEED TYPE PNEUMATIC



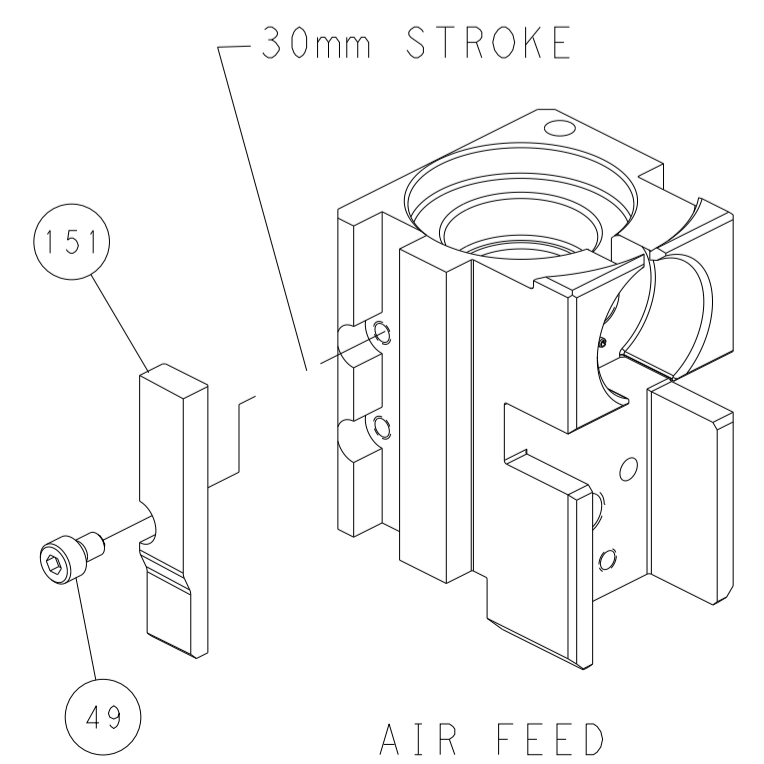
SEE DETAIL A

FEED SPRING SETTING POSITION  
(SHOWN FROM REAR SIDE)

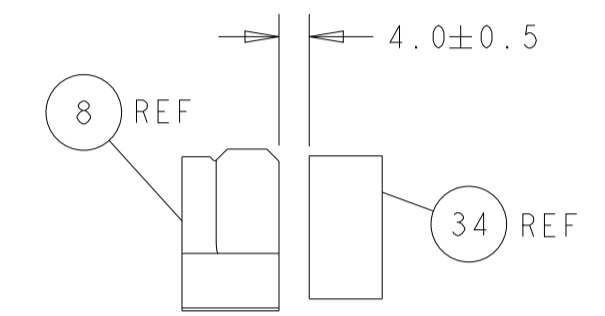
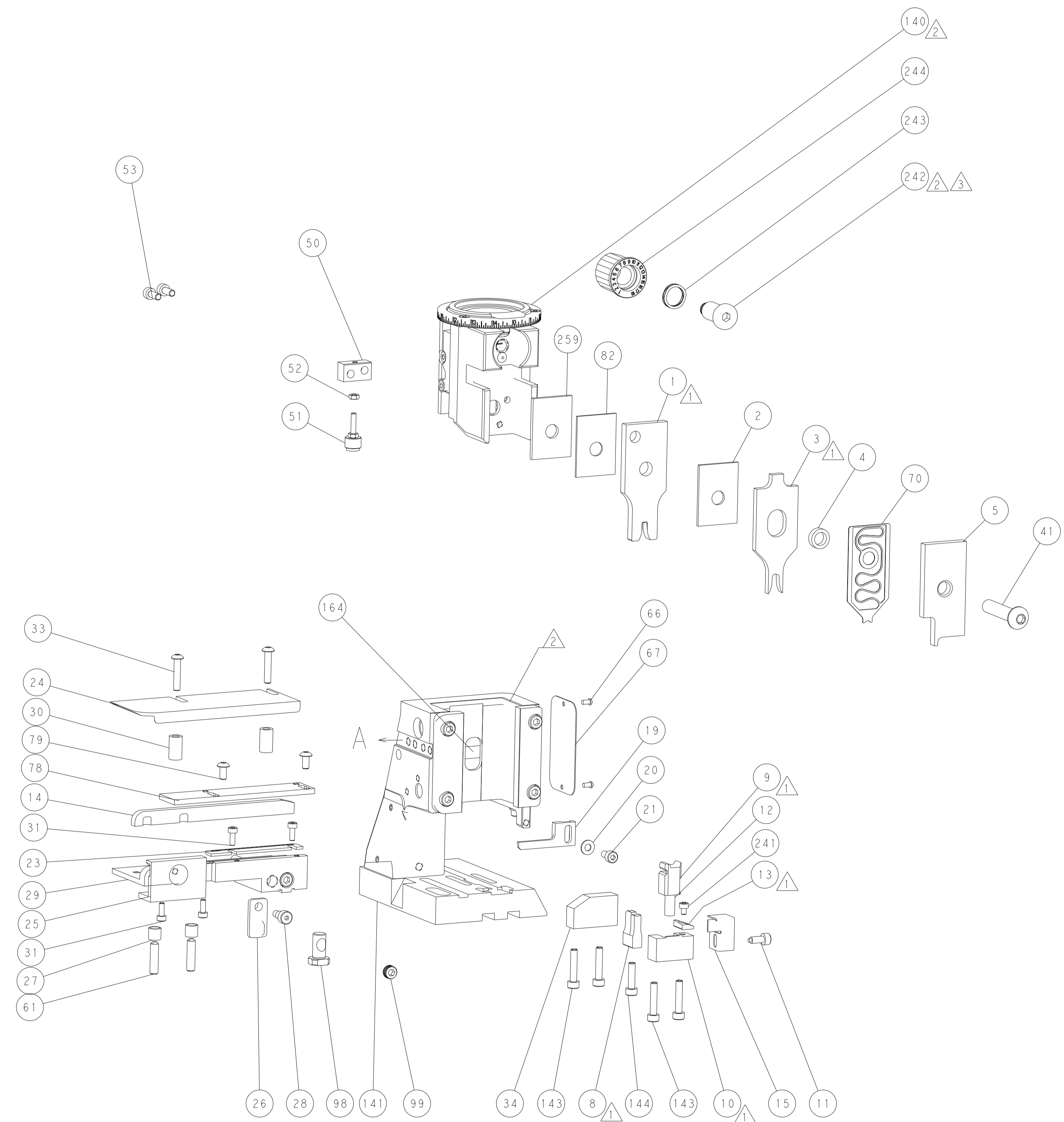


DETAIL A

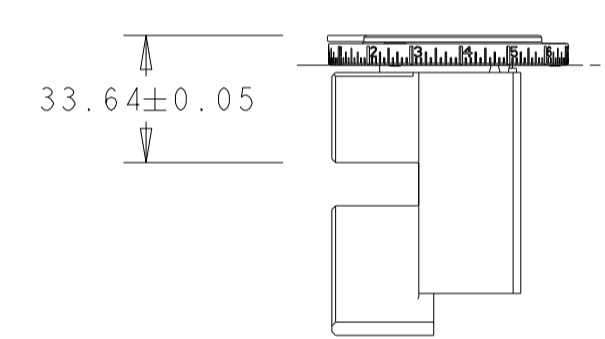
### CAM POSITION



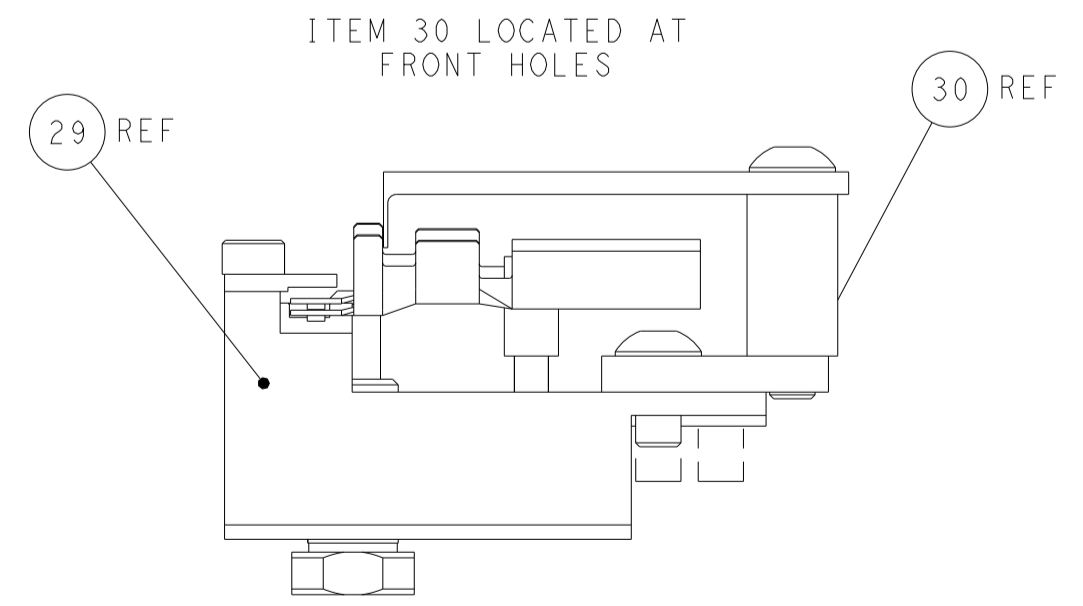
AIR FEED



TERMINAL SUPPORT LOCATION



RAM SETUP VIEW



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. IT IS THE PROPERTY OF TYCO ELECTRONICS CORPORATION. IT IS TO BE USED ONLY FOR THE PURPOSES AND IN THE MANNER SPECIFIED BY THE DRAWING. IT IS NOT TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, INCLUDING PHOTOCOPYING, RECORDING, OR BY ANY INFORMATION STORAGE AND RETRIEVAL SYSTEM, WITHOUT PERMISSION IN WRITING FROM TYCO ELECTRONICS CORPORATION.</small>		DWN BOB HIGMAN 01 JUL 2014 CHK G. BAILEY 01 JUL 2014 APVD D. STOUGH 01 JUL 2014	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 CAGE CODE DRAWING NO. A1 00779 C=2266361 WEIGHT SCALE 1:2 SHEET 4 OF 4 REV C	RESTRICTED TO Customer Accessible Production Drawing