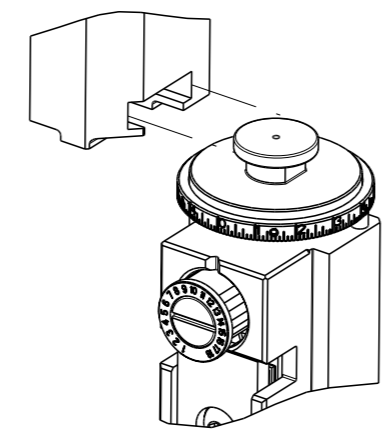


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2836875-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2836875-2	B	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2836875-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	0.66 mm [.026]	F
INSUL	0.64 mm [.025]	F

APPLICATOR INSTRUCTIONS  
408-35042

TERMINAL DATA: HIROSE TERMINAL HIROSE CRIMP SPECIFICATION	
TERMINAL NAME: 1.00mm CONTACT PITCH CONNECTOR	
WIRE STRIP LENGTH	TERMINAL INSULATION DIAMETER RANGE
1.20-1.90 mm [.047-.075 IN]	Ø0.50-0.60 mm [.020-.024 IN]
TERMINAL APPLICATION SPECIFICATION	HIROSE Rev 1
	AT9106
TERMINALS APPLIED	
TE TERMINAL	HIROSE TERMINAL
1949752-1	DF19A-2830-SCFA

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
28 AWG	0.54 +/- 0.05 [.021 +/- .002]	5.8
30 AWG	0.50 +/- 0.05 [.020 +/- .002]	6.1



- 1 RECOMMENDED SPARE PARTS
- 2 REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION & STORAGE OF APPLICATOR.
- 3 APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 180. 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 TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.

**\*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			
		REV	DATE	BY	APPV
A	66	A	RELEASED	09MAY2018	AW CT
		B	ECR-20-011385	12AUG2020	FJ TE

-	1	1	1-2119791-5	DEPRESSOR, WIRE	286
-	1	1	1-18028-3	WASHER, FLAT, REG M5	281
-	1	1	1803196-1	STUD, ADJUSTMENT SCREW	280
-	1	1	1633764-5	HOLD DOWN, TERMINAL	263
-	1	1	1-994962-8	SCR, SKT HD CAP M3 X 45.0	262
-	1	1	2330046-1	RESIN COLLAR, FLANGED	261
-	1	1	2119641-1	FEED CAM, AIR FEED	248
-	1	1	2119082-1	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	2844940-1	AIR FEED MODULE	238
-	1	1	1-1752354-0	STANDOFF,HOLD-DOWN	180
-	2	2	1-2079383-0	SCR, BHSC, RoHS (M3 X 6)	179
-	1	1	6-993111-6	PIN, SLOTTED SPRING 3.0 X 14.0	177
-	1	1	8-22280-7	SPRING, COMPRESSION	176
-	1	1	1752353-2	GUIDE PIN,HOLDDOWN	175
-	1	1	1901680-2	GUIDE PIN,HOLDDOWN	174
-	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	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	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	2161425-1	SCREW, SHOULDER	60
-	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	1	1	1338685-1	PAWL, FEED	56
-	4	4	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	54
-	1	1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52
-	1	1	1901681-8	HOLDDOWN, TERMINAL	51
-	1	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	1	1	2-1803583-5	APPLICATOR BASIC ASSEMBLY, SF	46
-	1	1	1803515-3	RAM ASSEMBLY, SF ATLANTIC	44
-	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
-	1	1	6-1752356-1	SUPPORT, TERMINAL	34
-	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	2-2844962-3	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	2844938-1	PLATE, STRIP GUIDE	29
-	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	2119533-4	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	1803095-3	FLOATING SHEAR, FRONT	9
-	1	2	1-1803395-3	ANVIL, COMBINATION	8
-	-	-	-	-	7
-	-	-	-	-	6
-	1	1	2119757-2	DEPRESSOR, SHEAR	5
-	1	1	2-238011-3	BLOCK, CRIMPER SPACER	4
-	1	2	1803559-2	CRIMPER, INSULATION F PREMIUM	3
-	-	-	-	-	2
-	1	2	2-1803407-3	CRIMPER, WIRE PREMIUM	1
-	77	72	-2	PART NO	ITEM NO

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		OWN	DATE
mm	0 PLC ±	1 PLC ±	2 PLC ±	N. HAHN	7 JUL 2017
	3 PLC ±	4 PLC ±	ANGLES ±	C. HAHN	8 JUL 2017
	FINISH			C. TOPPER	12 MAR 2014
MATERIAL				APVD	
				C. TOPPER	
				PRODUCT SPEC	
				APPLICATION SPEC	
				WEIGHT	
				SCALE	
				SHEET	
				REV	



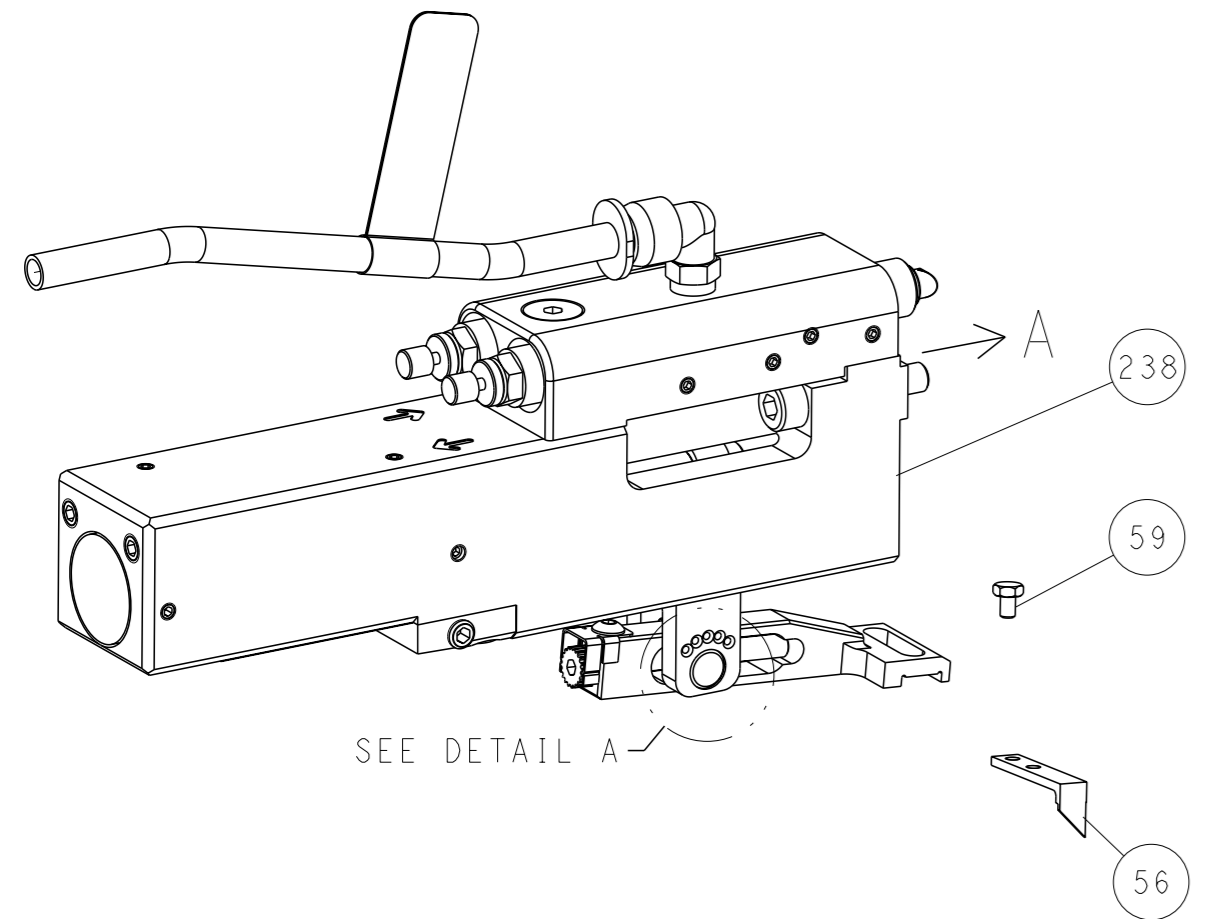
OCEAN 2.0 Side Feed Applicator

Customer Accessible Production Drawing

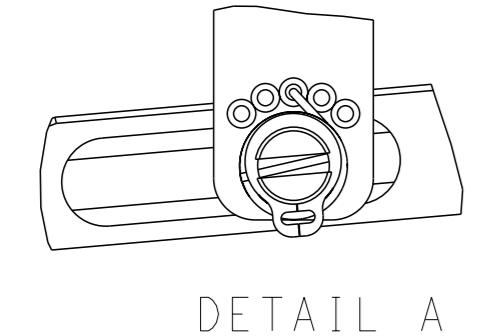
LOC	DIST	REVISIONS			
A	66	REV	DATE	OWN	APVD
-	-	SEE SHEET 1	-	-	-

# FEED TYPE

## PNEUMATIC

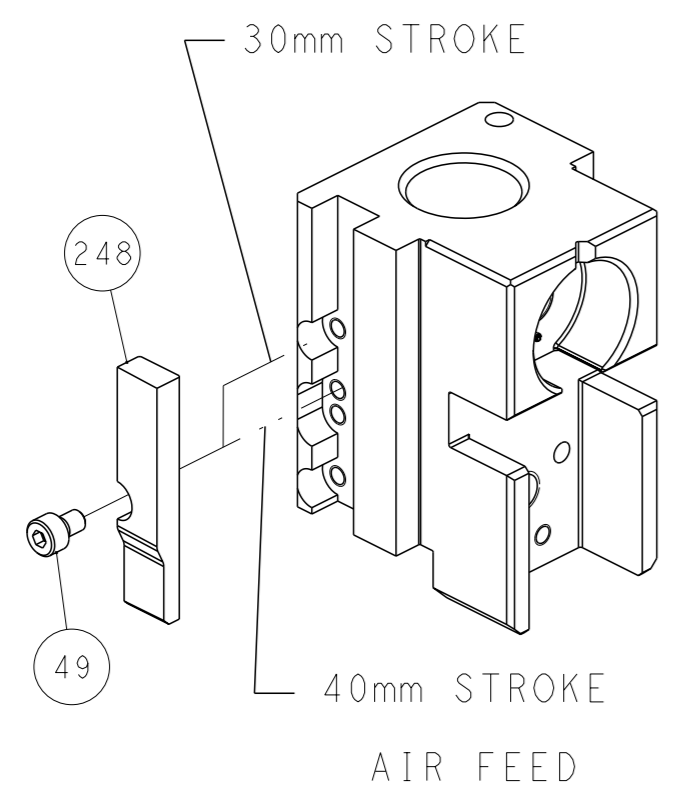


SEE DETAIL A  
 FEED SPRING SETTING POSITION  
 (SHOWN FROM REAR SIDE)

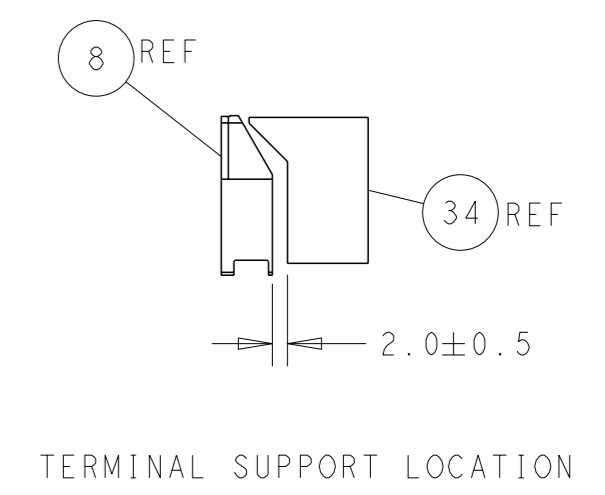
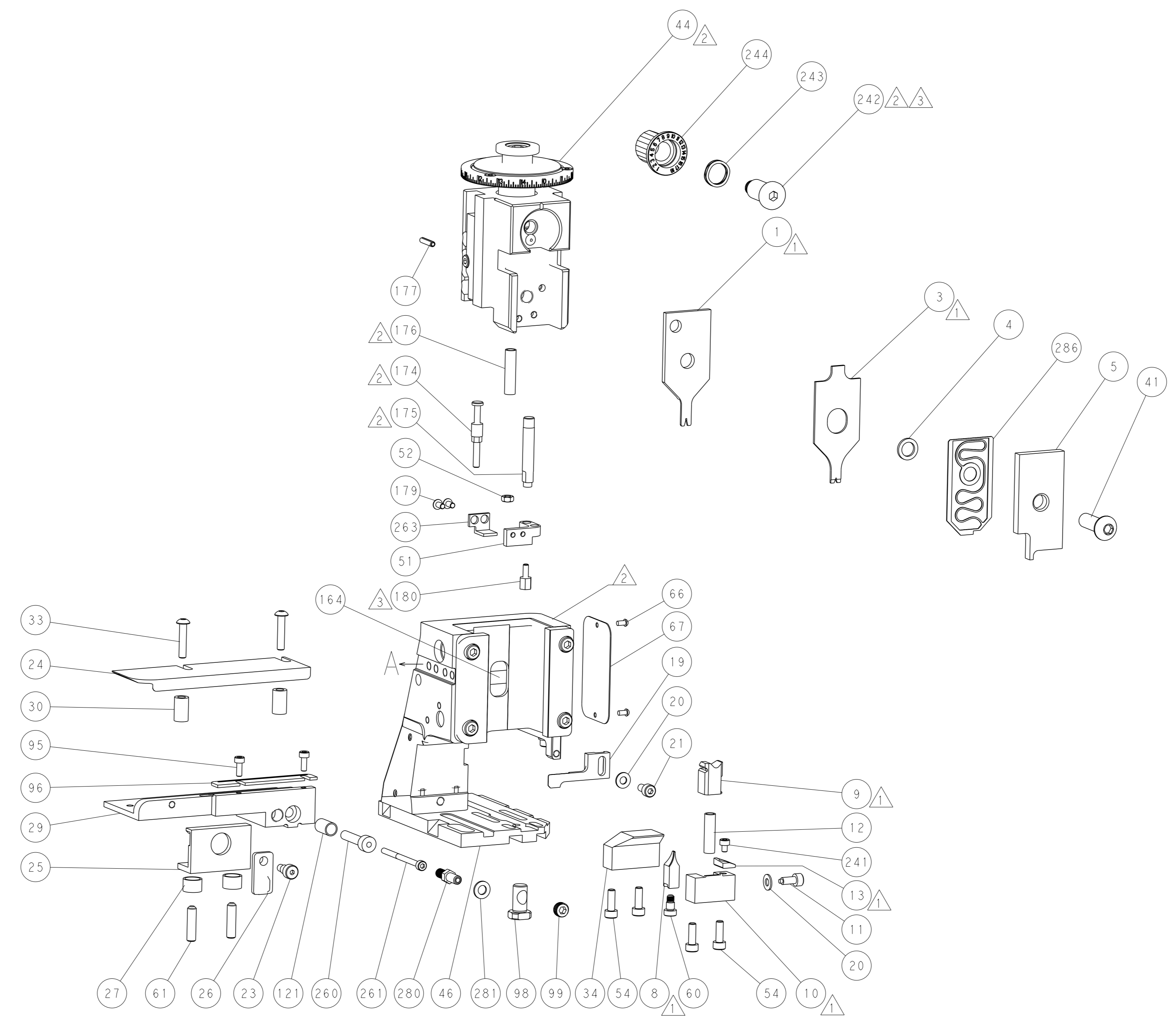


DETAIL A

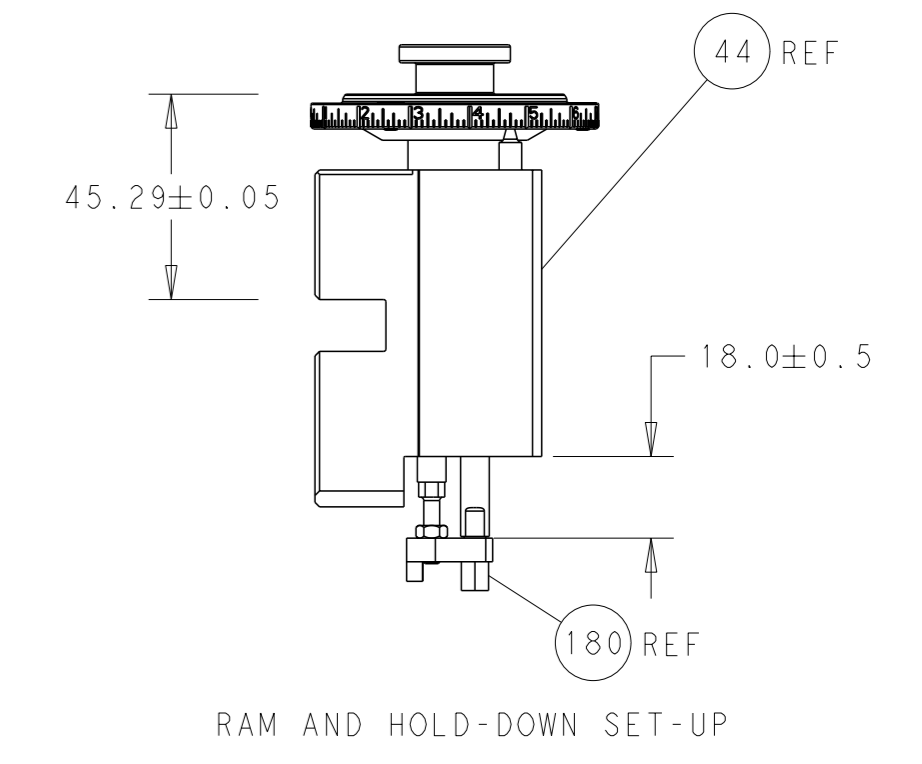
## CAM POSITION



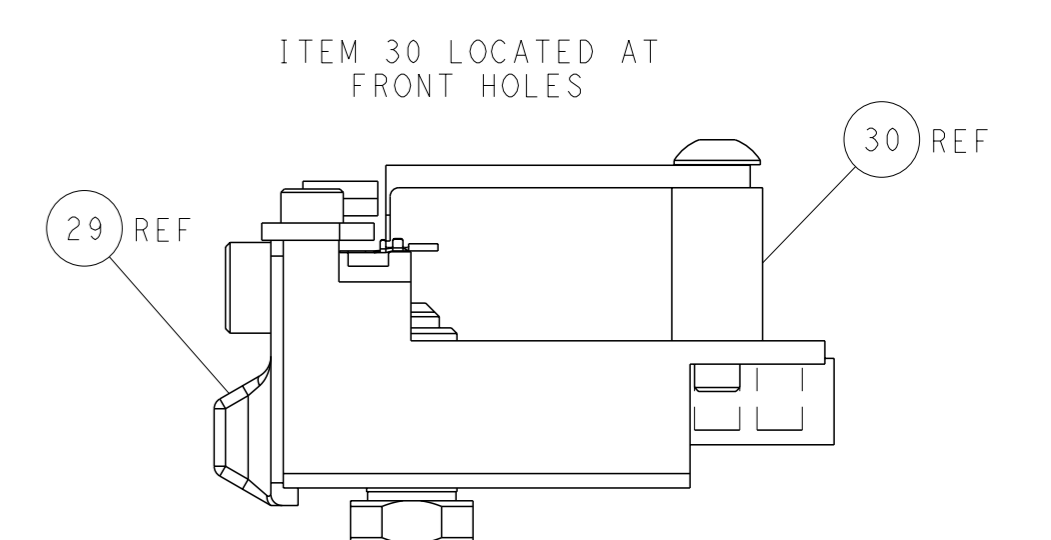
AIR FEED



TERMINAL SUPPORT LOCATION



RAM AND HOLD-DOWN SET-UP



FEED TRACK POSITION  
 GUIDE BY INSULATION BARREL

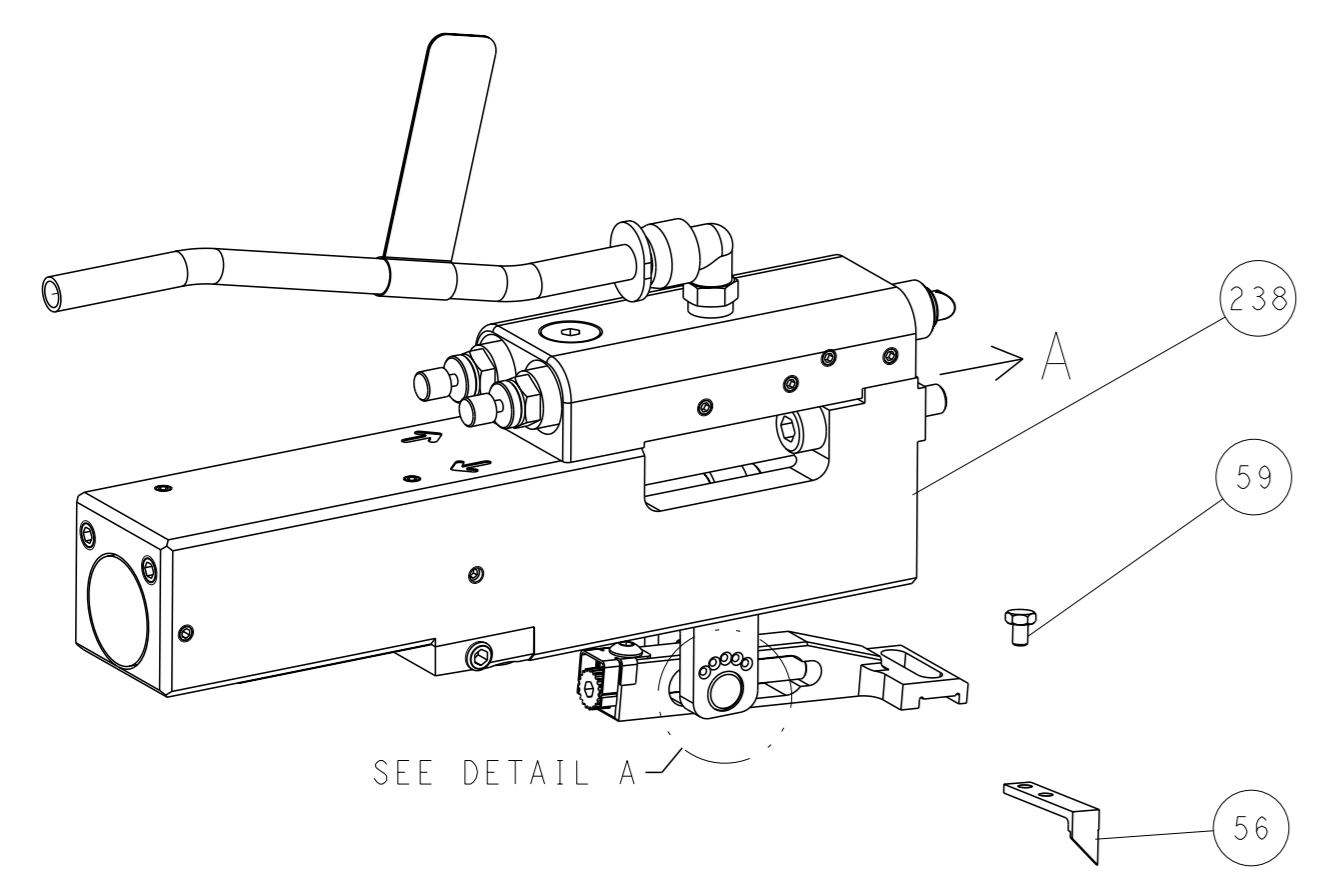
**ATLANTIC VERSION**  
 Shown on sheets 1 of 4 & 2 of 4  
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

<small>THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE AND THE CONTROLLER'S ENGINEERING DEPARTMENT SHOULD BE CONTACTED FOR THE LATEST REVISION.</small>		DWN: N. HAHN CHK: C. TOPPER APVD: C. TOPPER PRODUCT SPEC: 12MAR2014 APPLICATION SPEC: - MATERIAL: - FINISH: -	DATE: 7JUL2017 DATE: 8JUL2017 NAME: OCEAN 2.0 Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2836875 SCALE: 1:2 SHEET: 2 of 4 REV: B	TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		WEIGHT: - Customer Accessible Production Drawing	RESTRICTED TO: -	SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION



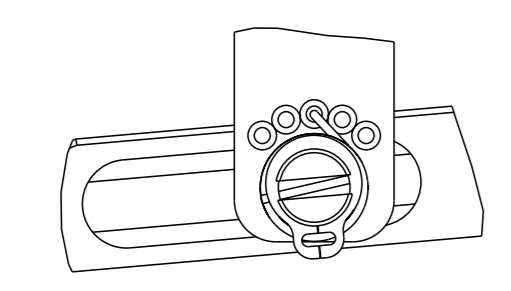
LOC	DIST	REV	DESCRIPTION	DATE	OWN	APVD
A	66		SEE SHEET 1			

### FEED TYPE PNEUMATIC



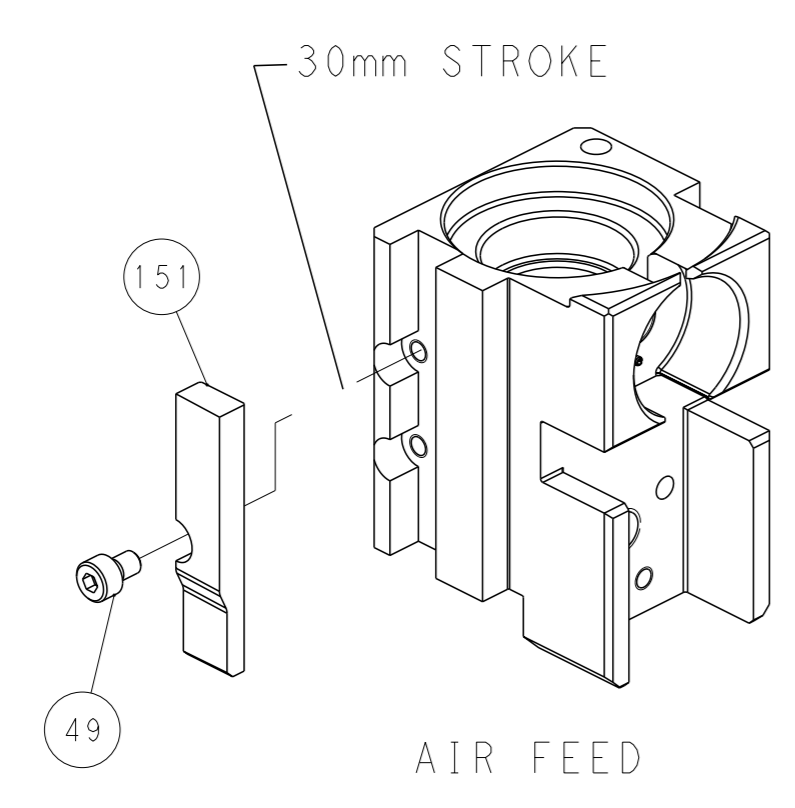
SEE DETAIL A

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

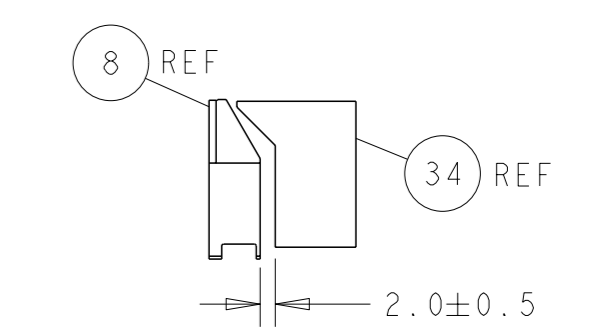
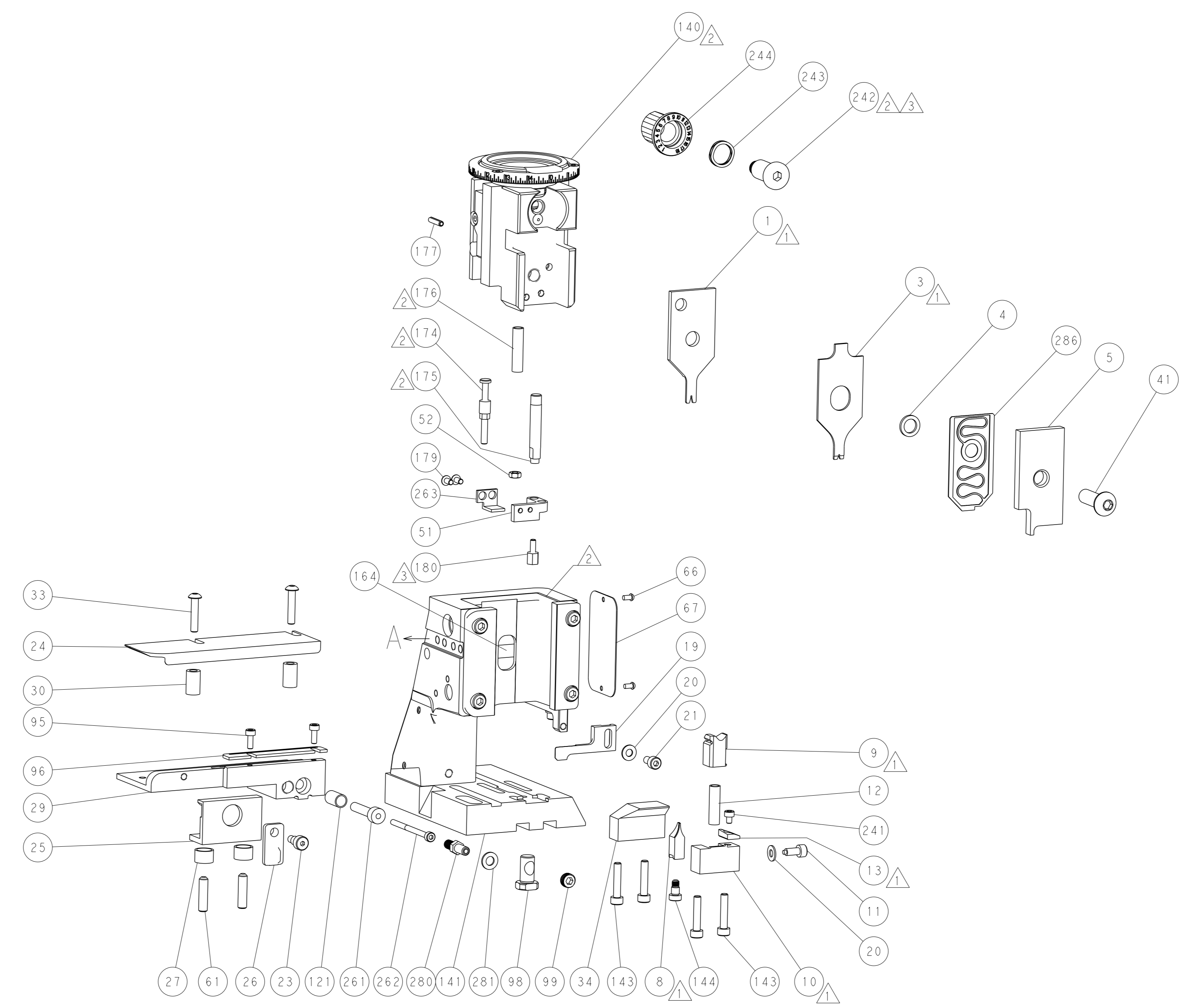


DETAIL A

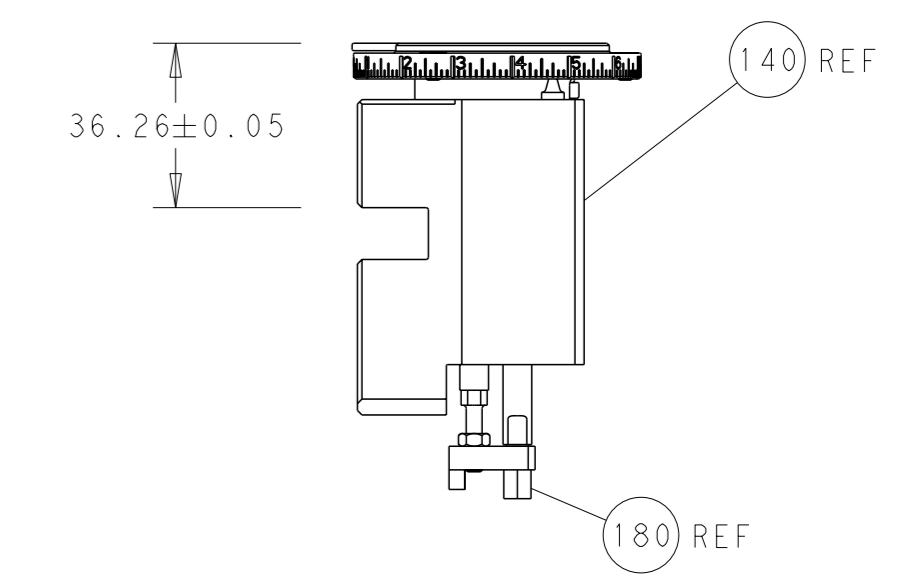
### CAM POSITION



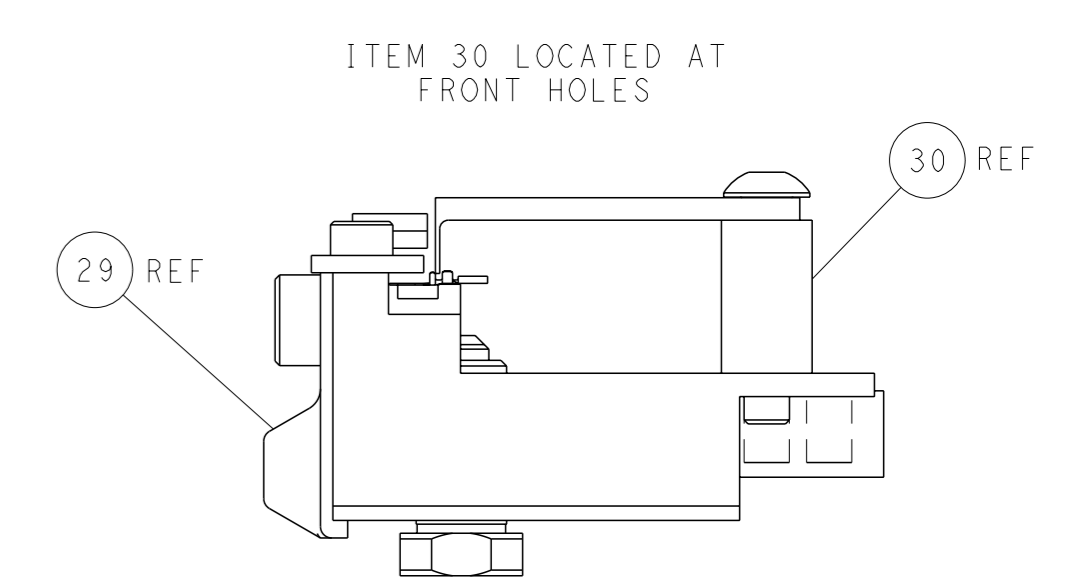
AIR FEED



TERMINAL SUPPORT LOCATION



RAM AND HOLD-DOWN 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 A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE AND THE USER MUST CONTACT THE DESIGNATION GROUP FOR THE LATEST REVISION.</small>		DWN N. HAHN 7JUL2017 CHK C. TOPPER 8JUL2017 APVD C. TOPPER 12MAR2014 PRODUCT SPEC APPLICATION SPEC	<b>STE</b> TE Connectivity Harrisburg, PA 17105-3608 OCEAN 2.0 Side Feed Applicator
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH ±	WEIGHT SCALE 1:2 SHEET 4 OF 4 REV B	SIZE CAGE CODE DRAWING NO A1 00779 C=2836875	RESTRICTED TO
MATERIAL:		Customer Accessible Production Drawing	SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION