

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2837240-1	A	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2837240-2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
5-2837240-1	A	SEAL STRIPPER CRIMPER TERMINATING UNIT	MECHANICAL
5-2837240-2	A	SEAL STRIPPER CRIMPER TERMINATING UNIT	PNEUMATIC
7-2837240-1	A	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2837240-2	A	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2837240-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.60 mm [.102]	F
INSUL	4.06 mm [.160]	O

APPLICATOR INSTRUCTIONS 408-35042

TERMINAL DATA: LEAR TERMINAL		LEAR CRIMP SPECIFICATION	
TERMINAL NAME: MKS-Plus ROUND PIN PLUG 1.5			
WIRE STRIP LENGTH	4.80-5.20 mm [.189-.205 IN]	TERMINAL INSULATION DIAMETER RANGE	Ø
TERMINAL APPLICATION SPECIFICATION	LEAR 25719 Rev 3		AT9106

TERMINALS APPLIED				SEAL INSULATION DIAMETER RANGE
TE TERMINAL	LEAR TERMINAL	TE SEAL	LEAR SEAL	
2113391-1	25719.201.184	1572316-1	16695.627.642	2.20-3.00
		1572316-2	16695.627.619	2.20-3.00
		1572316-3	7814140	2.20-3.00
		1572316-4	1533994	2.20-3.00
		1572316-5	16276.627.642	2.20-3.00
		1572316-6	801DL2	2.20-3.00

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
2.50mm2	1.55+/-0.05 [.061+/-0.002]	7.1
1.50mm2	1.40+/-0.05 [.055+/-0.002]	8.7

- 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.
- 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.
- CUT TO LENGTH AT ASSEMBLY.

**\*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					
		P	LTN	DESCRIPTION	DATE	OWN	APVD
A	66			RELEASED	23FEB2023	TB	TE

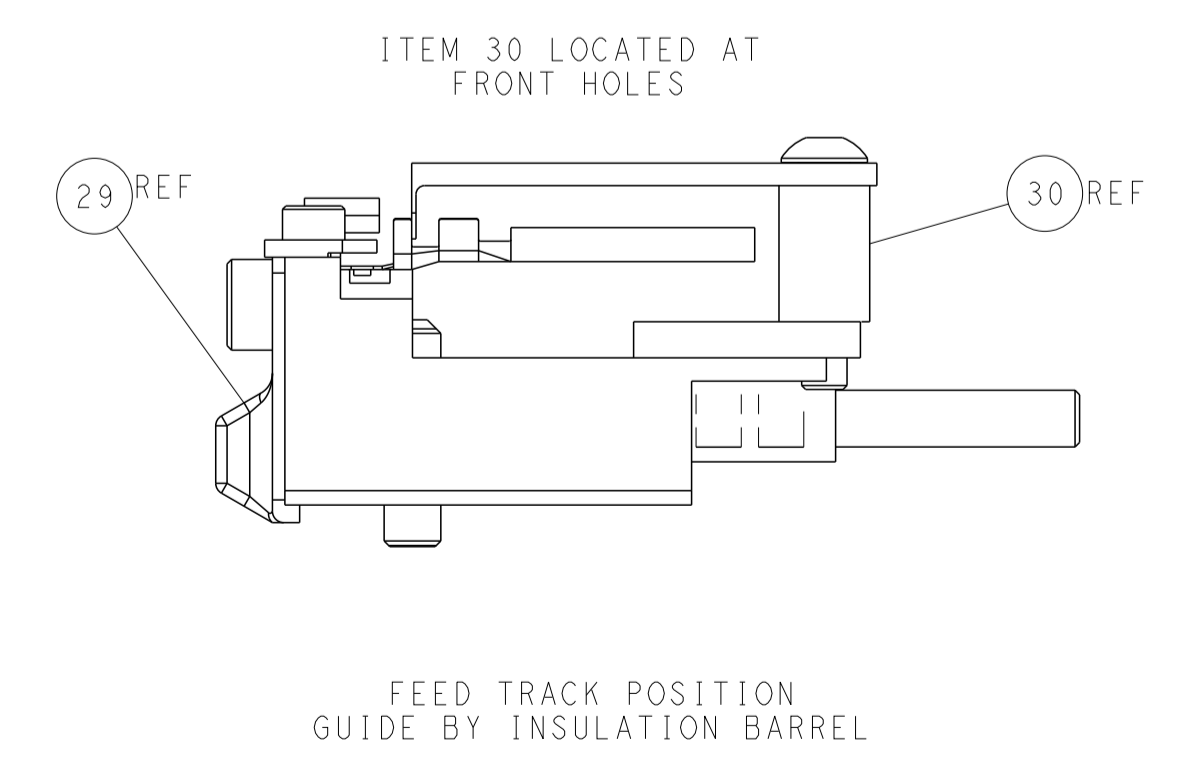
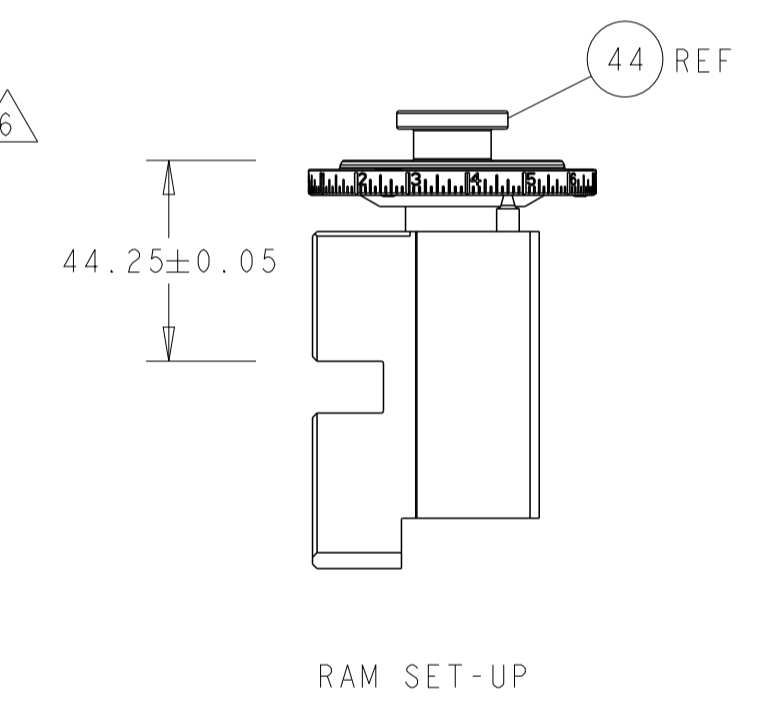
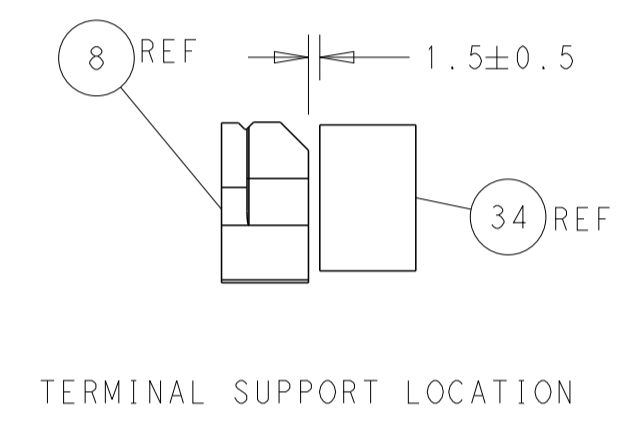
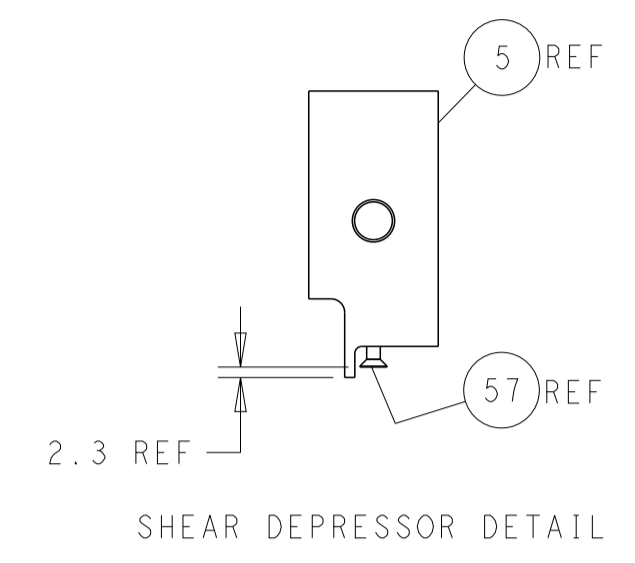
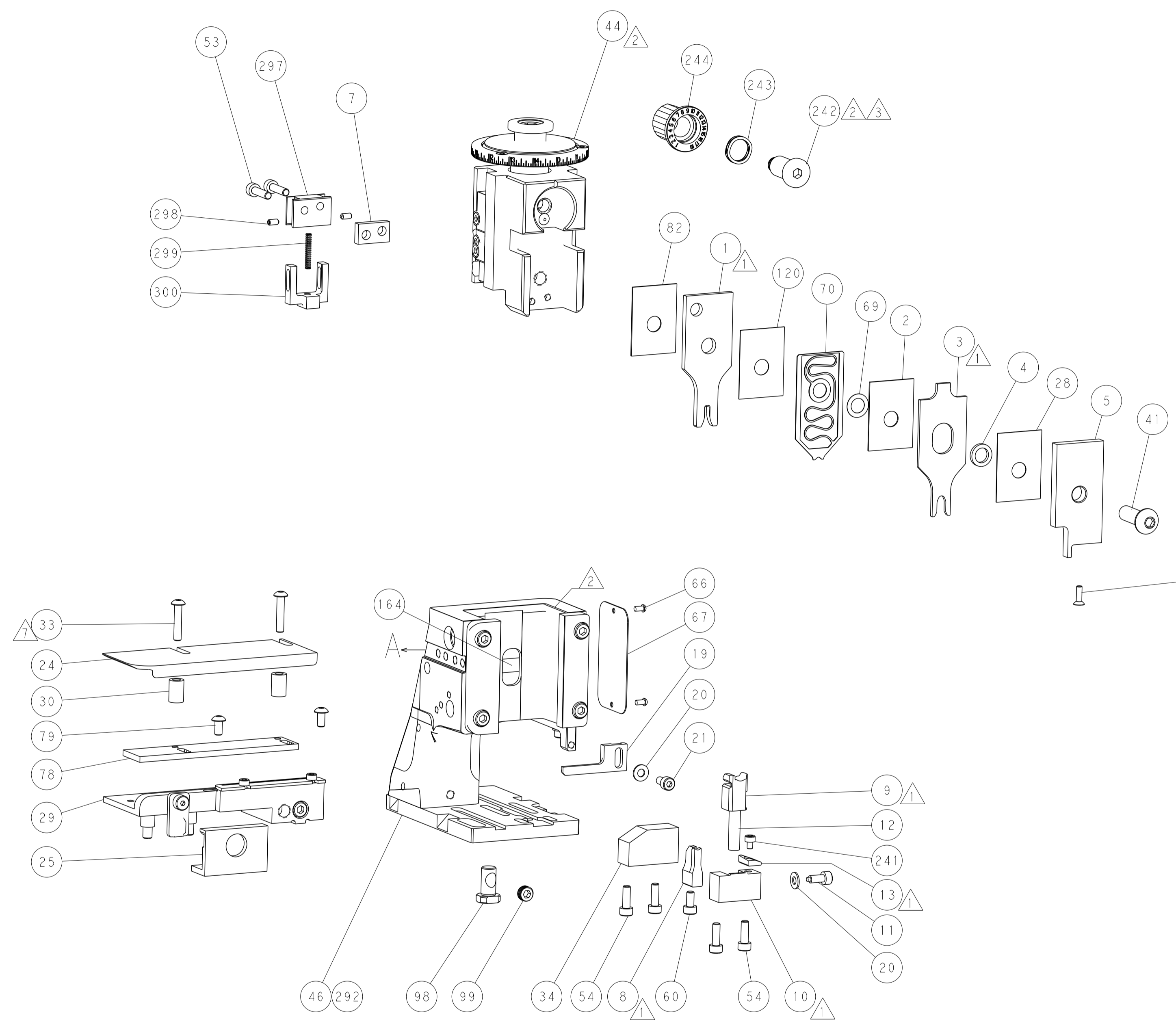
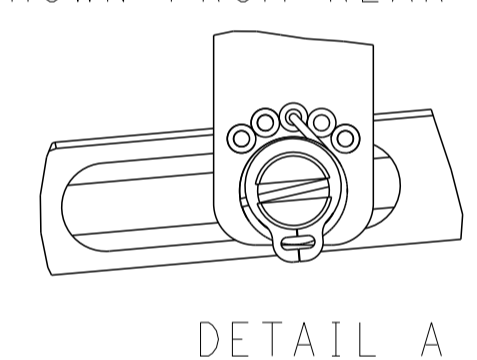
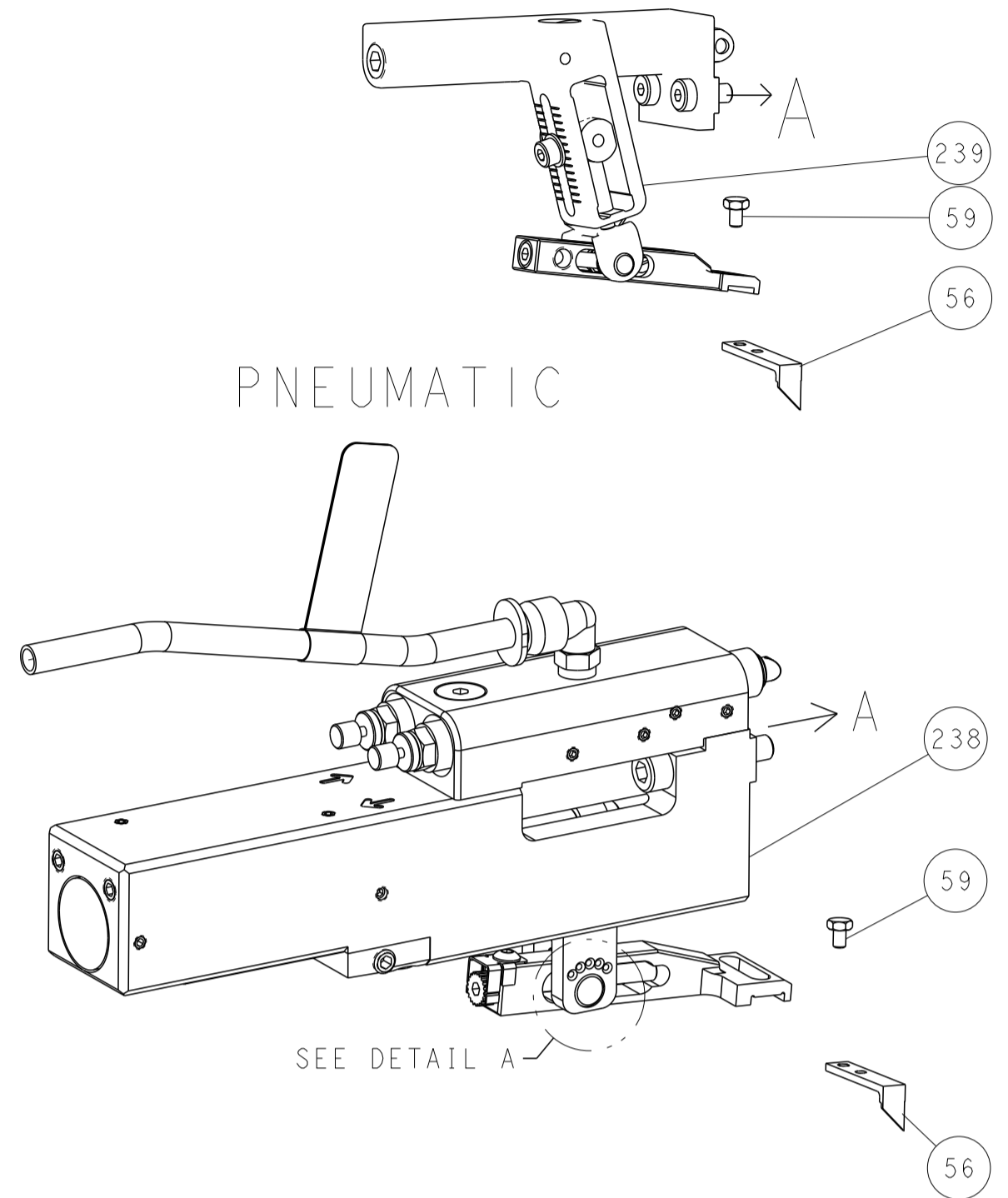
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-	1	1	1	1	1	1	1	22278-9	SPRING, COMPRESSION	299
-	2	2	2	2	2	2	2	4-18032-3	SCR, SET, FLT PNT, M3 X 6.0	298
-	1	1	1	1	1	1	1	1803944-1	SPACER, TONKER	297
-	-	-	-	-	-	-	-	2-1803583-1	APPLICATOR BASIC ASSEMBLY, SF	292
-	1	-	-	-	-	-	-	2119641-1	FEED CAM, AIR FEED	248
-	1	1	1	1	1	1	1	2119082-2	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1	1	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	1	1	1	1	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
-	-	-	-	-	-	-	-	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	1	-	-	-	-	-	-	2844940-1	AIR FEED MODULE	238
-	REF	REF	REF	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	1	1	1	1	1	1	1	455888-3	SPACER, CRIMPER	120
-	1	1	1	1	1	1	1	2844908-1	SCREW, LOCKING	99
-	1	1	1	1	1	1	1	2844907-1	POST, LOCKING	98
-	1	1	1	1	1	1	1	455888-6	SPACER, CRIMPER	82
-	2	2	2	2	2	2	2	2079383-4	SCR, BHSC, RoHS (M4 X 8)	79
-	1	1	1	1	1	1	1	1803096-1	EXTENSION PLATE	78
-	1	1	1	1	1	1	1	1803607-3	DOCUMENTATION PACKAGE	71
-	1	1	1	1	1	1	1	2119791-9	DEPRESSOR, WIRE	70
-	1	1	1	1	1	1	1	2119943-1	WASHER, SPACER	69
-	1	1	1	1	1	1	1	2119740-1	TAG, IDENTIFICATION	67
-	2	2	2	2	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	1	1	1	1	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	60
-	1	1	1	1	1	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	1	1	1	1	1	1	1	985575-3	SCR, FLT SKT HD CAP M3 X 10.0	57
-	1	1	1	1	1	1	1	1338685-1	PAWL, FEED	56
-	4	4	4	4	4	4	4	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	54
-	2	2	2	2	2	2	2	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	53
-	1	2	1	2	1	2	2	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	-	-	-	-	-	-	-	2119652-1	FEED CAM, PRE FEED	48
-	-	-	-	-	-	-	-	2119653-1	FEED CAM, POST FEED	47
-	1	1	-	-	-	-	-	1803583-9	APPLICATOR BASIC ASSEMBLY, SF	46
-	1	1	1	1	1	1	1	1803515-1	RAM ASSEMBLY, SF ATLANTIC	44
-	1	1	1	1	1	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
-	1	1	1	1	1	1	1	1752356-3	SUPPORT, TERMINAL	34
-	2	2	2	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	2	2	2	2	2	1-2844962-7	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	1	1	1	1	1	2844992-4	ASSEMBLY, STRIP GUIDE	29
-	1	1	1	1	1	1	1	455888-4	SPACER, CRIMPER	28
-	1	1	1	1	1	1	1	240792-1	DRAG, TERMINAL	25
-	1	1	1	1	1	1	1	1320928-4	STRIP GUIDE	24
-	1	1	-	-	-	-	-	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
-	2	2	1	1	2	2	2	1-18028-2	WASHER, FLAT, REG M4	20
-	1	1	-	-	-	-	-	2119533-1	STRIPPER, SIDE FEED	19
-	1	1	1	1	1	1	1	2119806-1	INSERT, SHEAR	13
-	1	1	1	1	1	1	1	3-22280-3	SPRING, COMPRESSION	12
-	1	1	1	1	1	1	1	1-356885-4	STOP, SHEAR	11
-	1	1	1	1	1	1	1	2119805-1	SHEAR HOLDER, FRONT	10
-	1	1	1	1	1	1	1	318707-1	FLOATING SHEAR, FRONT	9
-	1	2	2	1	1	1	1	3-1803054-9	ANVIL, COMBINATION	8
-	1	1	1	1	1	1	1	6-240641-9	SPACER	7
-	-	-	-	-	-	-	-	-	-	6
-	1	1	1	1	1	1	1	2119781-5	DEPRESSOR, SHEAR	5
-	1	1	1	1	1	1	1	238011-7	BLOCK, CRIMPER SPACER	4
-	1	2	2	1	1	1	1	3-1633996-0	CRIMPER, INSULATION SPECIAL	3
-	1	1	1	1	1	1	1	455888-6	SPACER, CRIMPER	2
-	1	2	2	1	1	1	1	1633588-6	CRIMPER, WIRE	1

ITEM NO	PART NO	DESCRIPTION	ITEM NO
-77	-72	-71	-52
-51	-2	-1	

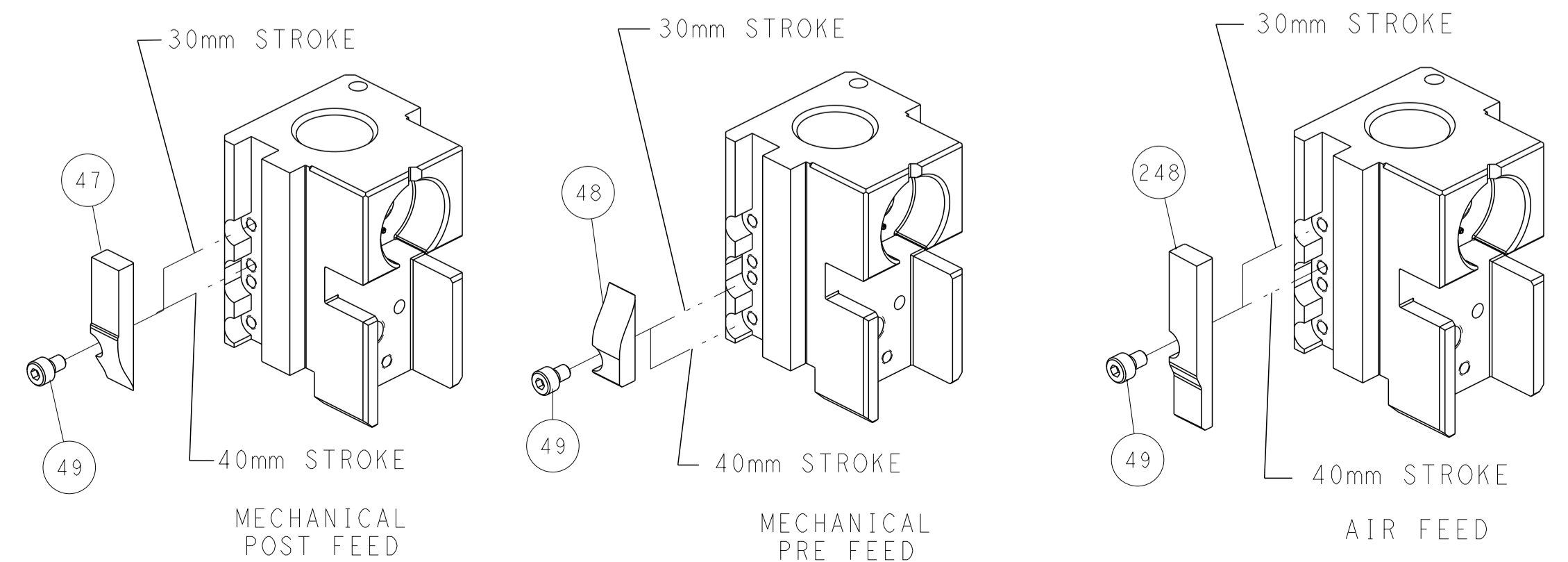
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LOC	DIST	REVISIONS			
P	LTN	DESCRIPTION	DATE	OWN	APVD
A	66	SEE SHEET 1	-	-	-

# FEED TYPE MECHANICAL



# 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		DWN T. BROOKS 23FEB2023 CHK M. HERR 23FEB2023 APVD T. ELBIN 23FEB2023		<b>STE</b> TE Connectivity Harrisburg, PA 17105-3608	
MATERIAL		WEIGHT		NAME		RESTRICTED TO	
				OCEAN 2.0 Side Feed Applicator		-	
				SIZE CAGE CODE DRAWING NO		-	
				A1 00779 C=2837240		-	
		Customer Accessible Production Drawing		SCALE 1:2		SHEET 2 OF 4 REV A	

THIS DRAWING IS UNPUBLISHED.	RELEASED FOR PUBLICATION		
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2837240-1	A	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2837240-2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2837240-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.60 mm [ .102 ]	F
INSUL	4.06 mm [ .160 ]	O
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: LEAR TERMINAL		LEAR CRIMP SPECIFICATION	
TERMINAL NAME: MKS-Plus ROUND PIN PLUG 1.5			
WIRE STRIP LENGTH	TERMINAL INSULATION DIAMETER RANGE		
4.80-5.20 mm [ .189-.205 IN ]	Ø		
TERMINAL APPLICATION SPECIFICATION	LEAR 25719 Rev 3	AT9106	

TERMINALS APPLIED				
TE TERMINAL	LEAR TERMINAL	TE SEAL	LEAR SEAL	SEAL INSULATION DIAMETER RANGE
2113391-1	25719.201.184	1572316-1	16695.627.642	2.20-3.00
		1572316-2	16695.627.619	2.20-3.00
		1572316-3	7814140	2.20-3.00
		1572316-4	1533994	2.20-3.00
		1572316-5	16276.627.642	2.20-3.00
		1572316-6	801DL2	2.20-3.00

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
2.50mm2	1.55+/-0.05 [ .061+/- .002 ]	7.1
1.50mm2	1.40+/-0.05 [ .055+/- .002 ]	8.7

- 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. CUT TO LENGTH AT ASSEMBLY.

**\*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)

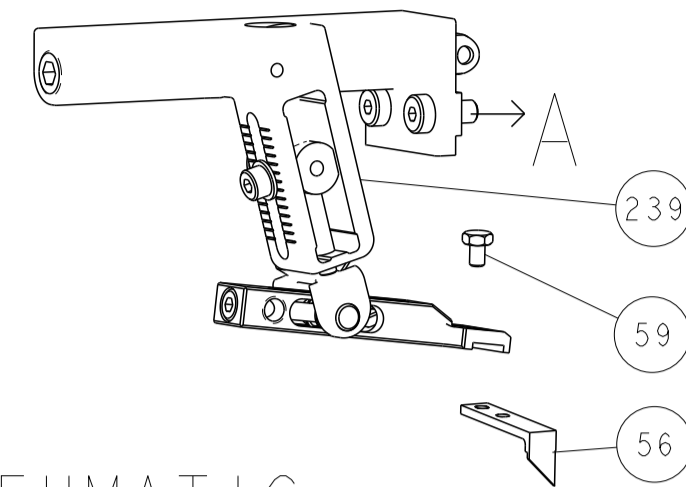
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A	66				

REV	DATE	BY	APPD	DESCRIPTION	ITEM NO
-	1	1		1-1803945-3 TONKER	300
-	1	1		22278-9 SPRING, COMPRESSION	299
-	2	2		4-18032-3 SCR, SET, FLT PNT, M3 X 6.0	298
-	1	1		1803944-1 SPACER, TONKER	297
-	1	1		2119082-2 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		455888-3 SPACER, CRIMPER	120
-	1	1		2844908-1 SCREW, LOCKING	99
-	1	1		2844907-1 POST, LOCKING	98
-	1	1		455888-6 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		2119791-9 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		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		1338685-1 PAWL, FEED	56
-	2	2		2168083-8 SCR, SKT HD CAP, RoHS, M4 X 16	53
-	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		1752356-3 SUPPORT, TERMINAL	34
-	2	2		2079383-5 SCR, BHSC, RoHS (M4 X 20)	33
-	2	2		1-2844962-7 SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1		2844992-4 ASSEMBLY, STRIP GUIDE	29
-	1	1		455888-4 SPACER, CRIMPER	28
-	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		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		3-1803054-9 ANVIL, COMBINATION	8
-	1	1		6-240641-9 SPACER	7
-	-	-		-	6
-	1	1		2119781-5 DEPRESSOR, SHEAR	5
-	1	1		238011-7 BLOCK, CRIMPER SPACER	4
-	1	1		3-1633996-0 CRIMPER, INSULATION SPECIAL	3
-	1	1		455888-6 SPACER, CRIMPER	2
-	1	1		1633588-6 CRIMPER, WIRE	1

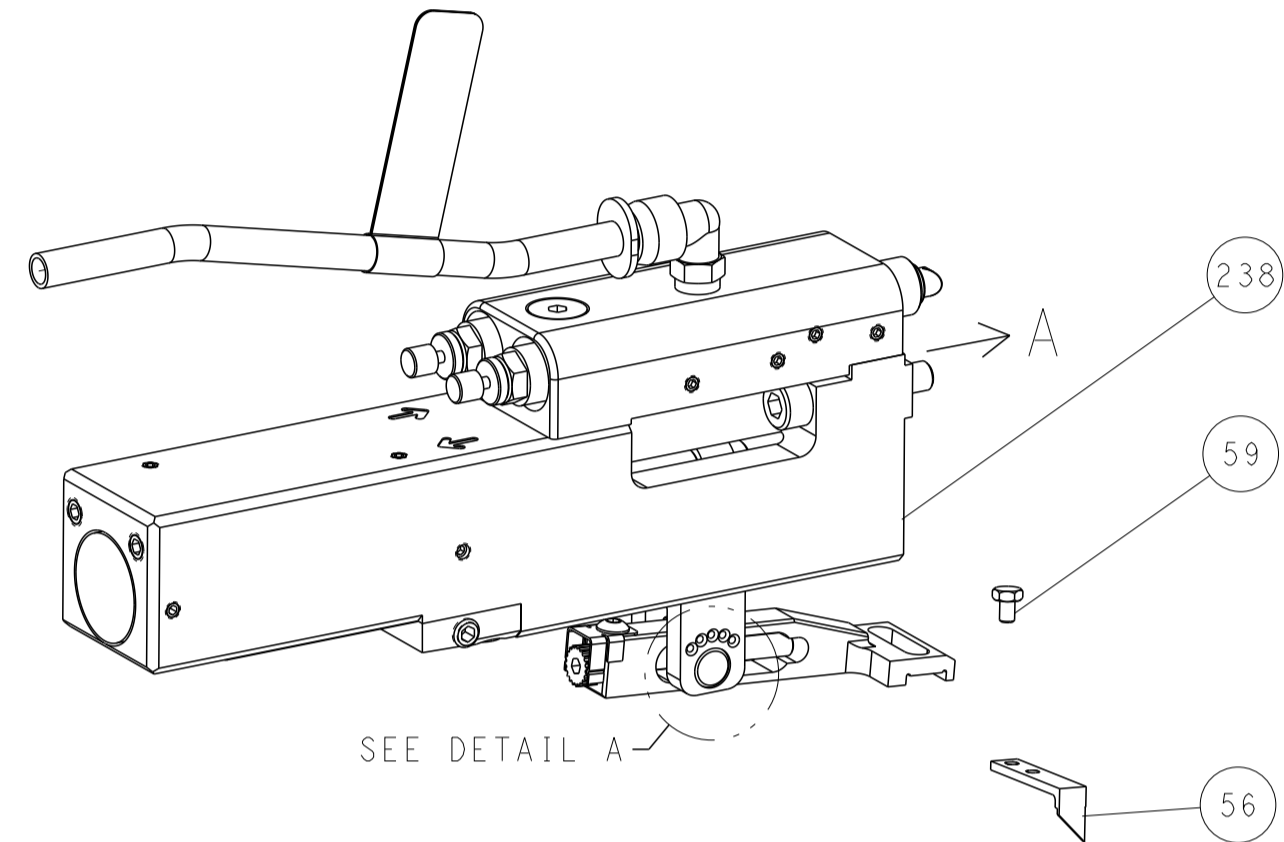
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0 PLC	±	1 PLC	±	OCEAN 2.0 Side Feed		APPLICATOR		SIZE		CAGE CODE DRAWING NO	
2 PLC	±	3 PLC	±	RESTRICTED TO		APPLICATION SPEC		A1		00779 ©=2837240	
4 PLC	±	5 PLC	±	Customer Accessible Production Drawing		SCALE		1:2		SHEET 3 OF 4	
ANGLES	±	FINISH		WEIGHT		SCALE		1:2		REV A	

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

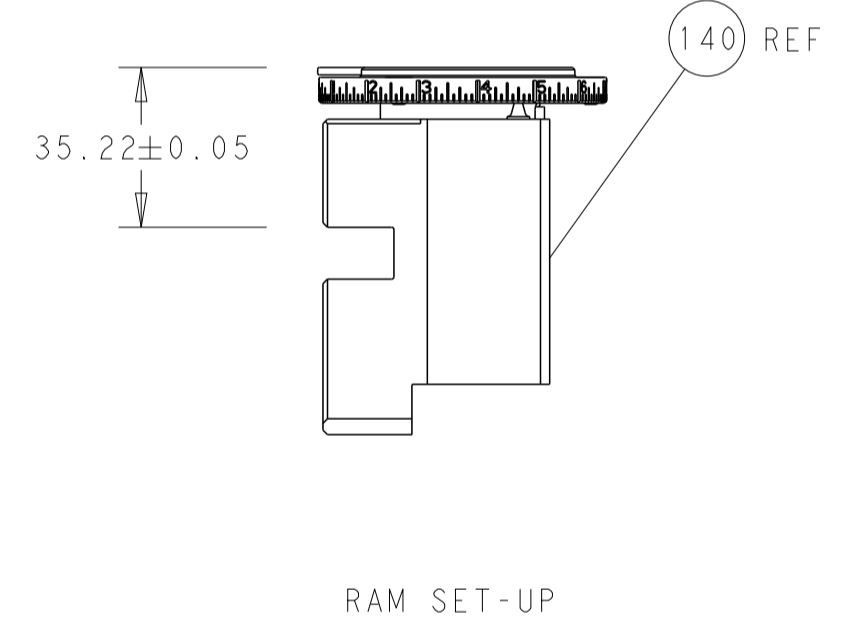
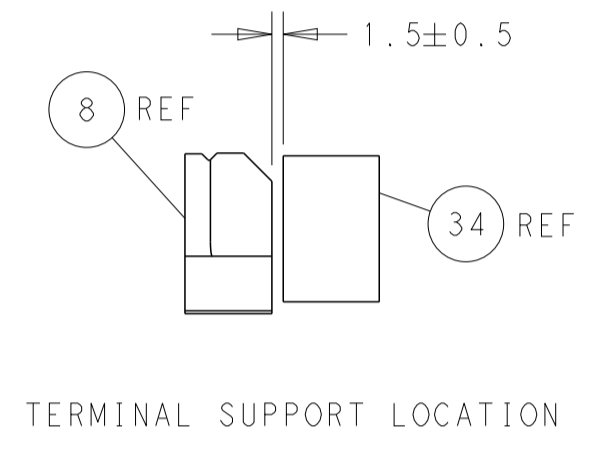
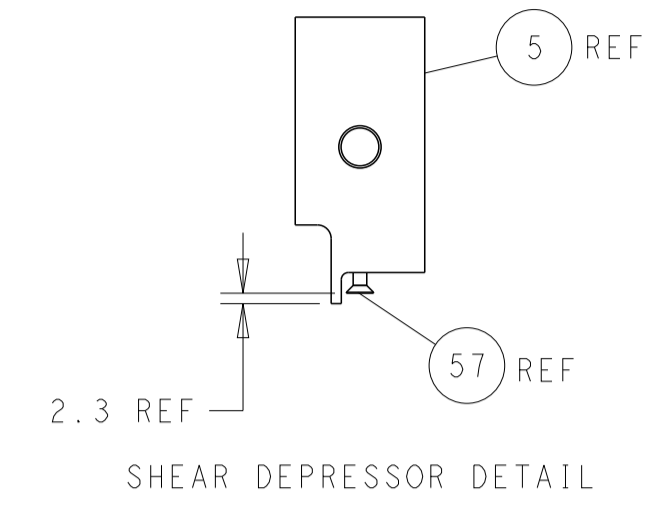
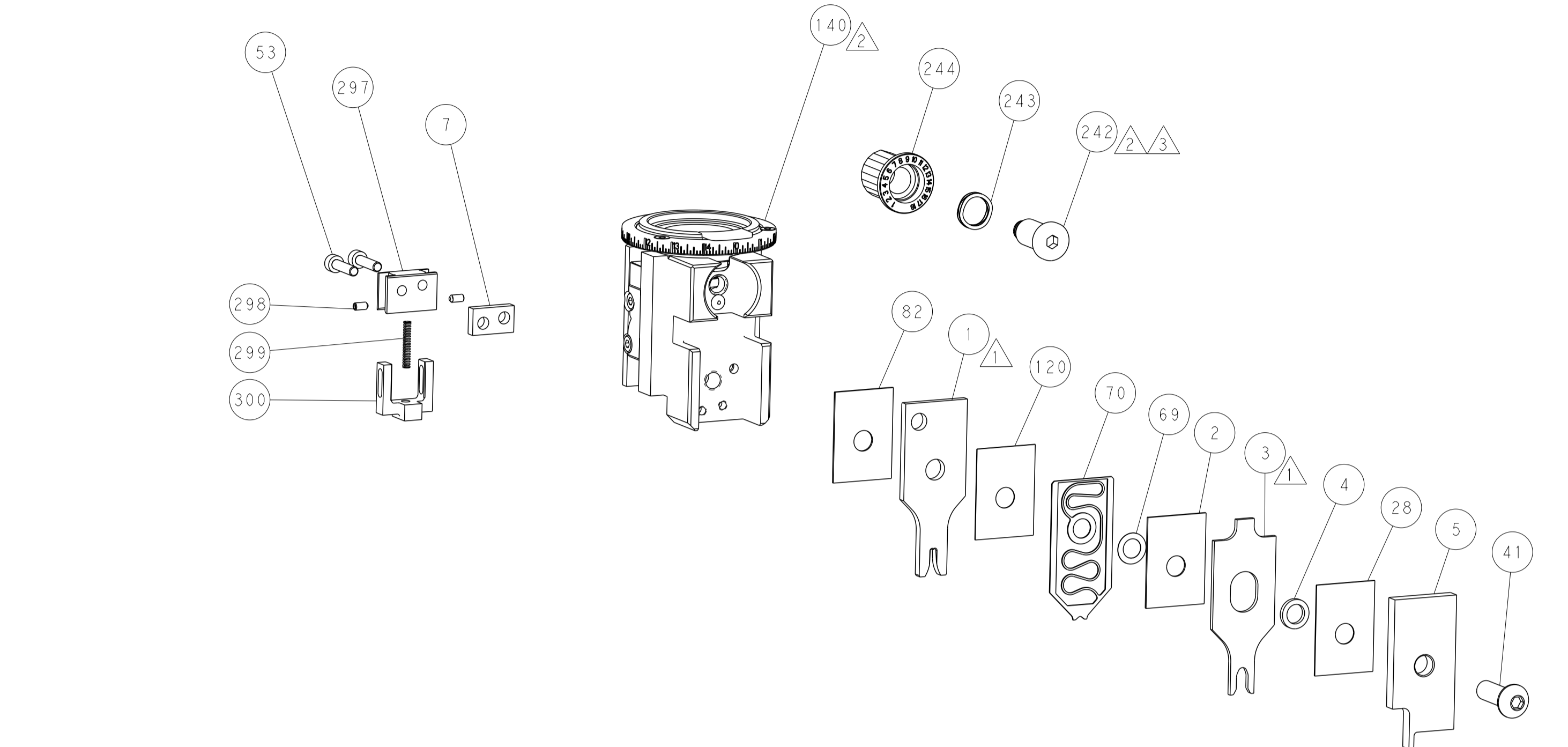
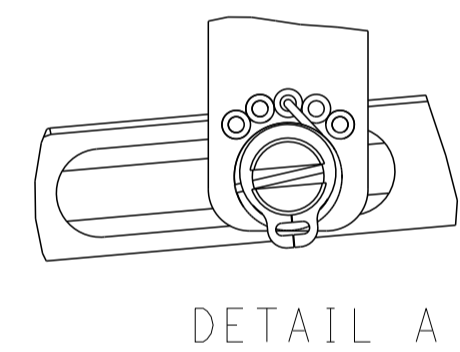
# FEED TYPE MECHANICAL



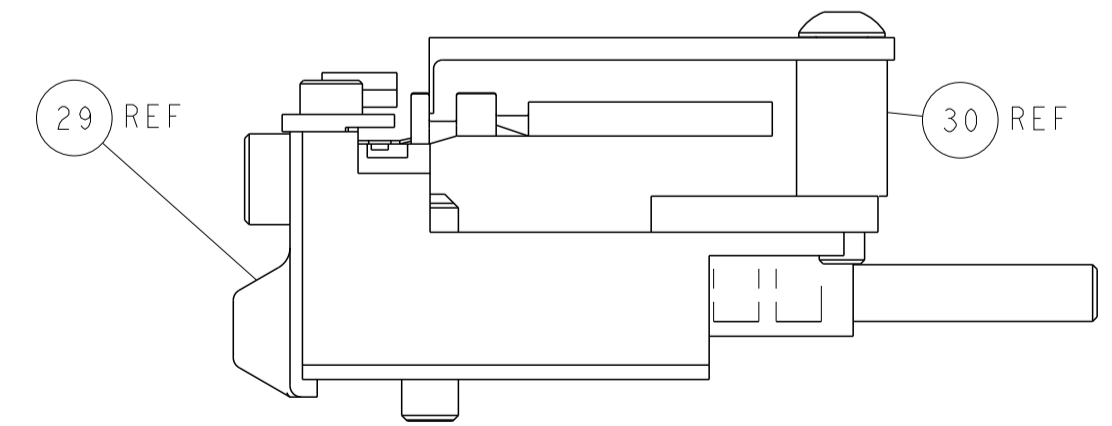
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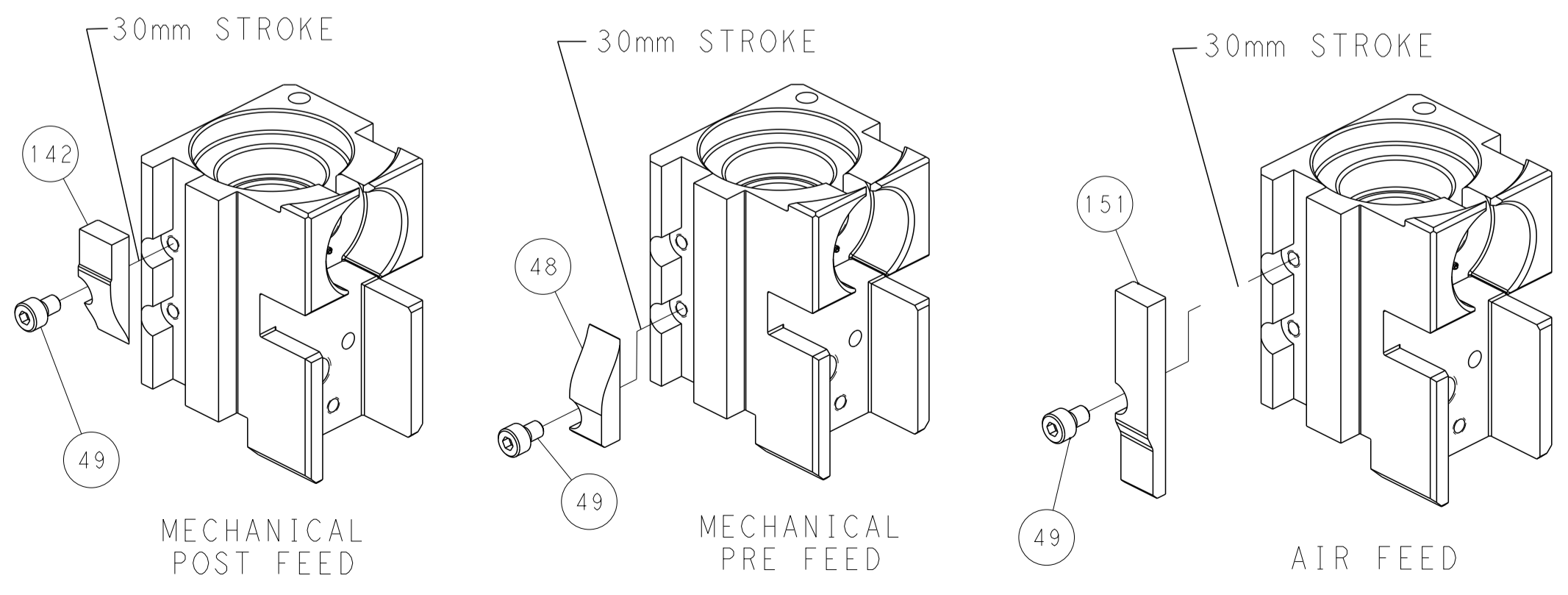
### FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



ITEM 30 LOCATED AT FRONT HOLES



## CAM POSITIONS



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

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN T. BROOKS 23FEB2023		TE Connectivity	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	Harrisburg, PA 17105-3608	
MATERIAL:		FINISH:		APVD M. HERR 23FEB2023		NAME	
				PRODUCT SPEC		OCEAN 2.0 Side Feed Applicator	
				APPLICATION SPEC		SIZE CAGE CODE DRAWING NO	
				WEIGHT		RESTRICTED TO	
				A 00779 C=2837240		Customer Accessible Production Drawing	
				SCALE 1:2		SHEET 4 OF 4 REV A	