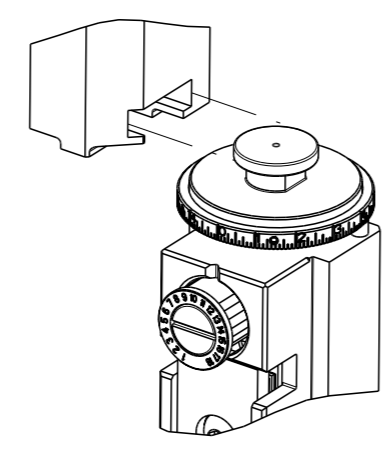


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2837255-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2837255-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
5-2837255-1	B	SEAL STRIPPER CRIMPER TERMINATING UNIT	MECHANICAL
5-2837255-2	B	SEAL STRIPPER CRIMPER TERMINATING UNIT	PNEUMATIC
7-2837255-1	B	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2837255-2	B	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2837255-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.27 mm [.050]	F
INSUL	1.78 mm [.070]	F

APPLICATOR INSTRUCTIONS 408-35042

TERMINAL DATA: PROVERTHA TERMINAL TE CRIMP SPECIFICATION			
TERMINAL NAME: CRIMPKONTAKT STIFT			
WIRE STRIP LENGTH	TERMINAL INSULATION DIAMETER RANGE		
2.29-3.06 mm [.090-.120 IN]	Ø1.13-1.50 mm [.044-.059 IN]		
TERMINAL APPLICATION SPECIFICATION	NONE	AT9106	
TERMINALS APPLIED			
TE TERMINAL	PROVERTHA TERMINAL	TE TERMINAL	PROVERTHA TERMINAL
2113967-1	C1520SLGXT	2113967-2	C1520GLGXT

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
20 AWG	0.87+/-0.05 [.034+/- .002]	5.8
22 AWG	0.73+/-0.05 [.029+/- .002]	7.2
24 AWG	0.65+/-0.05 [.026+/- .002]	8.1

- RECOMMENDED SPARE PARTS
- REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 180. 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.
- TERMINAL LUBRICANT IS RECOMMENDED.

***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)

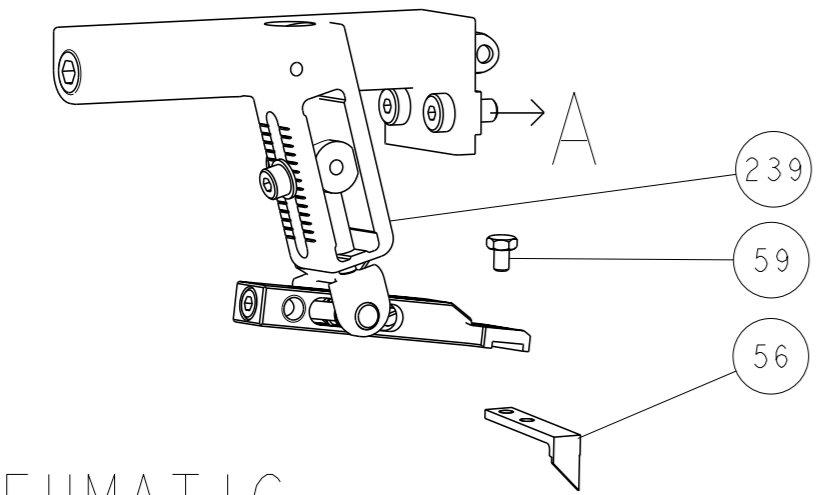
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		B		ECR-21-005076	04MAY2021	JWC	TE

-	-	-	1	1	-	-	1803515-3	RAM ASSEMBLY, SF ATLANTIC	293
-	-	-	1	1	-	-	2-1803583-1	APPLICATOR BASIC ASSEMBLY, SF	292
-	1	-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248
-	1	1	1	1	1	1	2119082-4	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	1	1	1	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
-	-	1	-	1	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	1	-	1	-	1	-	2844940-1	AIR FEED MODULE	238
-	-	-	1	1	-	-	4-1722335-3	STRIPPER, SIDE FEED	182
-	-	-	1	1	-	-	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	181
-	-	-	1	1	-	-	1-1752354-5	STANDOFF, HOLD-DOWN	180
-	-	-	1	1	-	-	6-993111-6	PIN, SLOTTED SPRING 3.0 X 14.0	177
-	-	-	1	1	-	-	5-22280-0	SPRING, COMPRESSION	176
-	-	-	1	1	-	-	1752353-3	GUIDE PIN, HOLDDOWN	175
-	-	-	1	1	-	-	1901680-2	GUIDE PIN, HOLDDOWN	174
-	REF	REF	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	1	1	1	1	1	1	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113
-	1	1	1	1	1	1	2844908-1	SCREW, LOCKING	99
-	1	1	1	1	1	1	2844907-1	POST, LOCKING	98
-	1	1	1	1	1	1	455888-5	SPACER, CRIMPER	82
-	1	1	1	1	1	1	1803607-3	DOCUMENTATION PACKAGE	71
-	1	1	1	1	1	1	2119740-1	TAG, IDENTIFICATION	67
-	2	2	2	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	1	1	1	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	60
-	1	1	1	1	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	1	1	1	1	1	1	1338685-1	PAWL, FEED	56
-	4	4	4	4	4	4	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	54
-	2	2	2	2	2	2	2-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 14	53
-	1	1	1	1	1	1	5018030-1	NUT, HEX, REG, RoHS, M3	52
-	1	1	1	1	1	1	811242-5	BUMPER, HOLD DOWN	51
-	1	1	1	1	1	1	690753-2	SPACER, TONKER	50
-	1	2	1	2	1	2	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	-	1	-	1	-	1	2119652-1	FEED CAM, PRE FEED	48
-	-	1	-	1	-	1	2119653-1	FEED CAM, POST FEED	47
-	1	1	-	-	1	1	1803583-9	APPLICATOR BASIC ASSEMBLY, SF	46
-	1	1	-	-	1	1	1803515-1	RAM ASSEMBLY, SF ATLANTIC	44
-	1	1	1	1	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
-	1	1	1	1	1	1	1752356-1	SUPPORT, TERMINAL	34
-	2	2	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	2	2	2	2	2-2844962-3	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	1	1	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29
-	1	1	1	1	1	1	1320928-2	STRIP GUIDE	24
-	1	1	-	-	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
-	2	2	1	1	2	2	1-18028-2	WASHER, FLAT, REG M4	20
-	1	1	-	-	1	1	2119533-1	STRIPPER, SIDE FEED	19
-	1	1	1	1	1	1	2119806-1	INSERT, SHEAR	13
-	1	1	1	1	1	1	3-22280-3	SPRING, COMPRESSION	12
-	1	1	1	1	1	1	1-356885-4	STOP, SHEAR	11
-	1	1	1	1	1	1	2119805-1	SHEAR HOLDER, FRONT	10
-	1	1	1	1	1	1	1803095-6	FLOATING SHEAR, FRONT	9
1	2	2	1	1	1	1	9-1803171-2	ANVIL, COMBINATION	8
-	1	1	1	1	1	1	240641-5	SPACER	7
-	-	-	-	-	-	-	-	-	6
-	1	1	1	1	1	1	2119757-4	DEPRESSOR, SHEAR	5
-	1	1	1	1	1	1	2-238011-3	BLOCK, CRIMPER SPACER	4
1	2	2	1	1	1	1	1-1803246-0	CRIMPER, INSULATION F PREMIUM	3
-	-	-	-	-	-	-	-	-	2
1	2	2	1	1	1	1	3-1633860-9	CRIMPER, WIRE	1

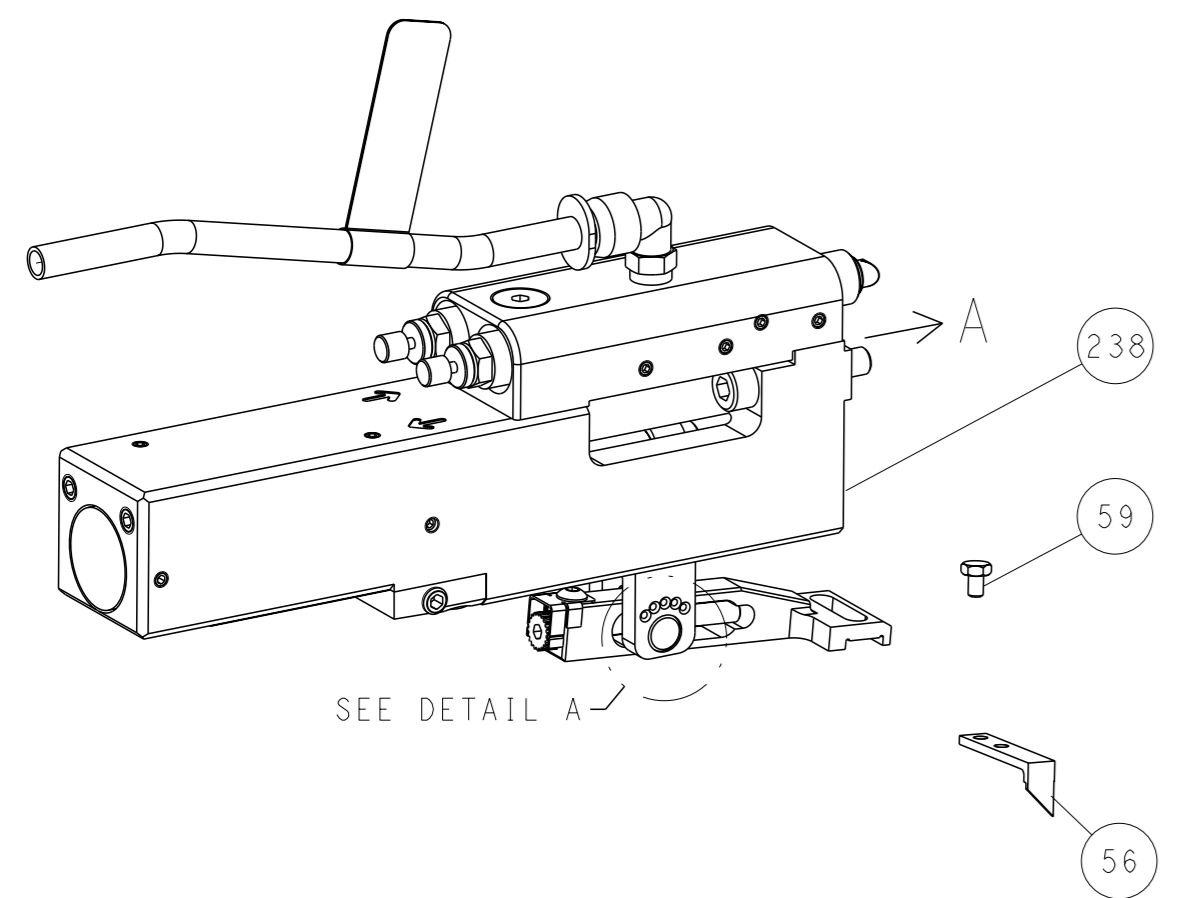
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	3 PLC ±	4 PLC ±	ANGLES ±	CHE T. ELBIN	01APR2021		
MATERIAL	FINISH	WEIGHT		APVD C. TOPPER	01APR2021	NAME	
				PRODUCT SPEC		OCEAN 2.0 Side Feed Applicator	
				APPLICATION SPEC		SIZE	CAGE CODE DRAWING NO
						A1	00779 ©=2837255
						RESTRICTED TO	
						Customer Accessible Production Drawing	SCALE 1:2 SHEET 1 of 4 REV B

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

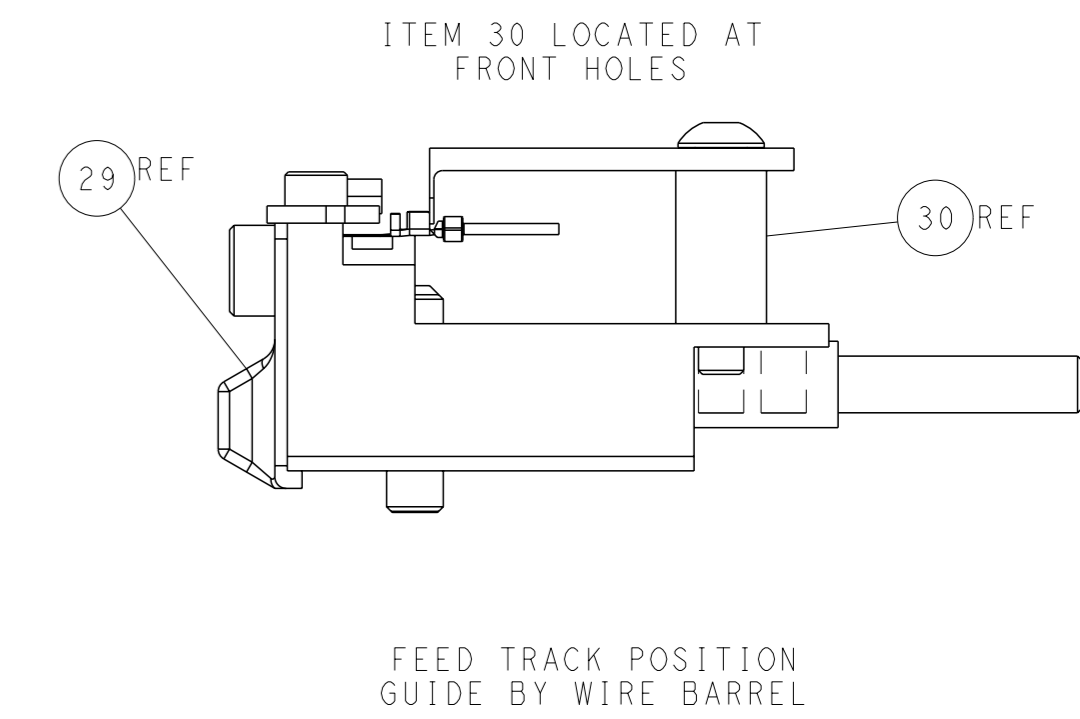
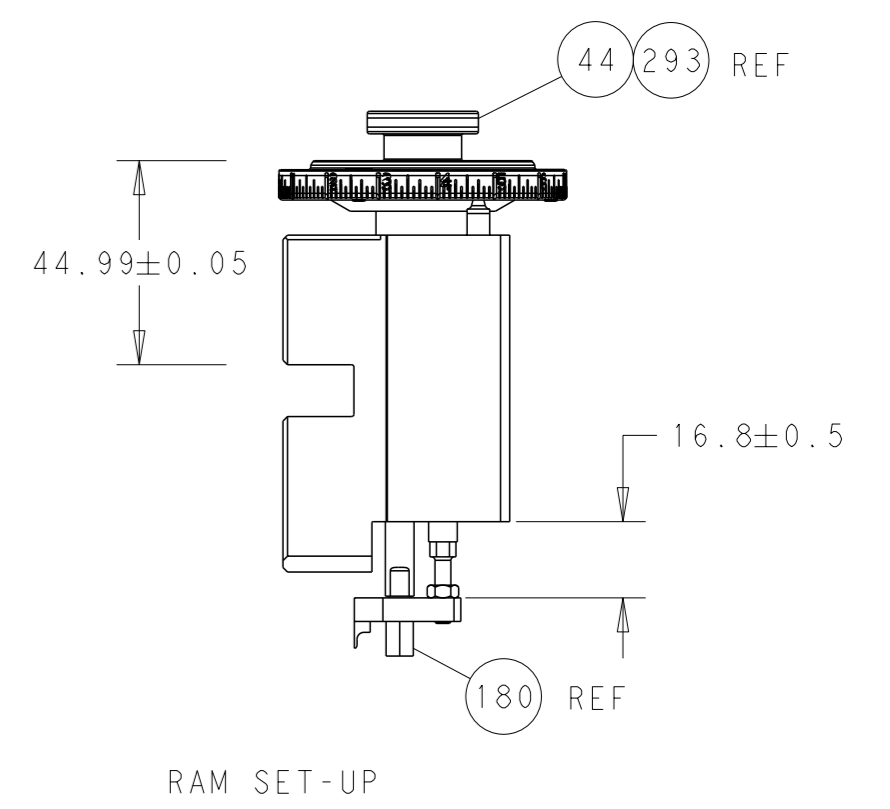
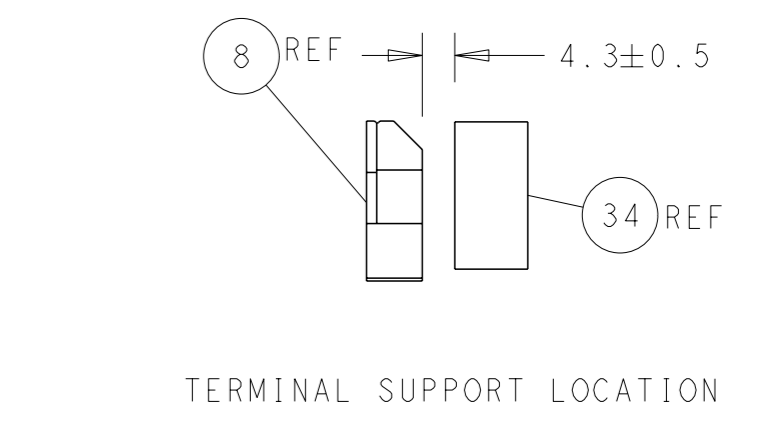
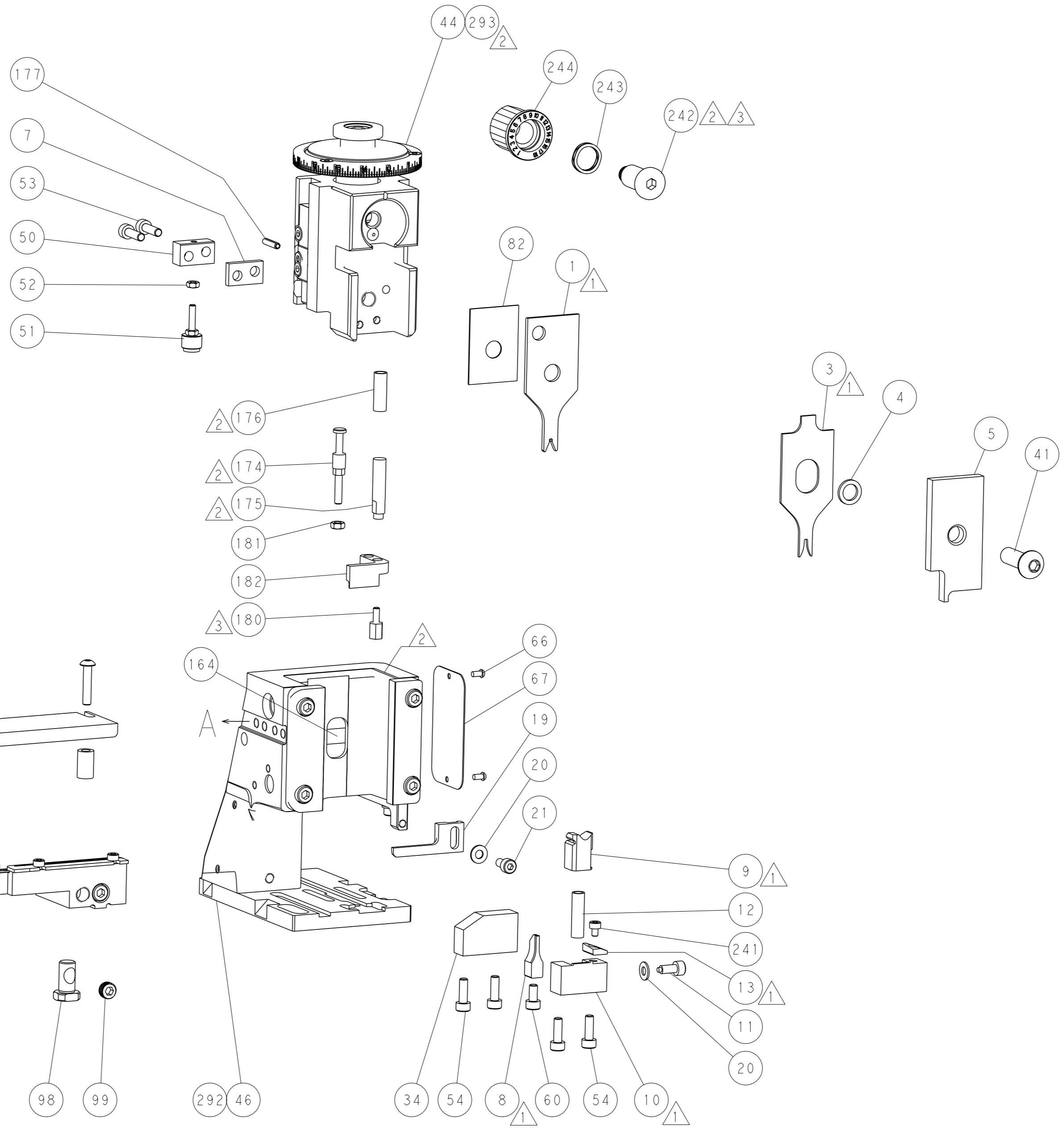
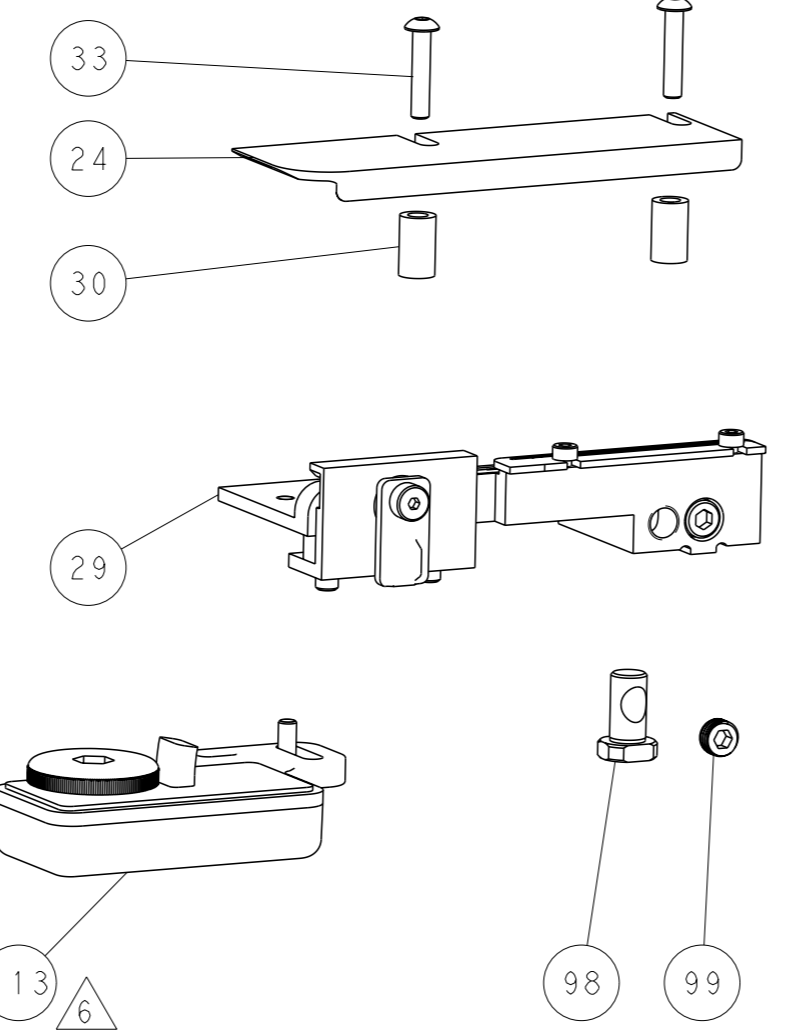
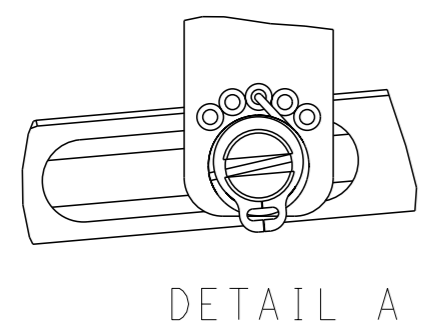
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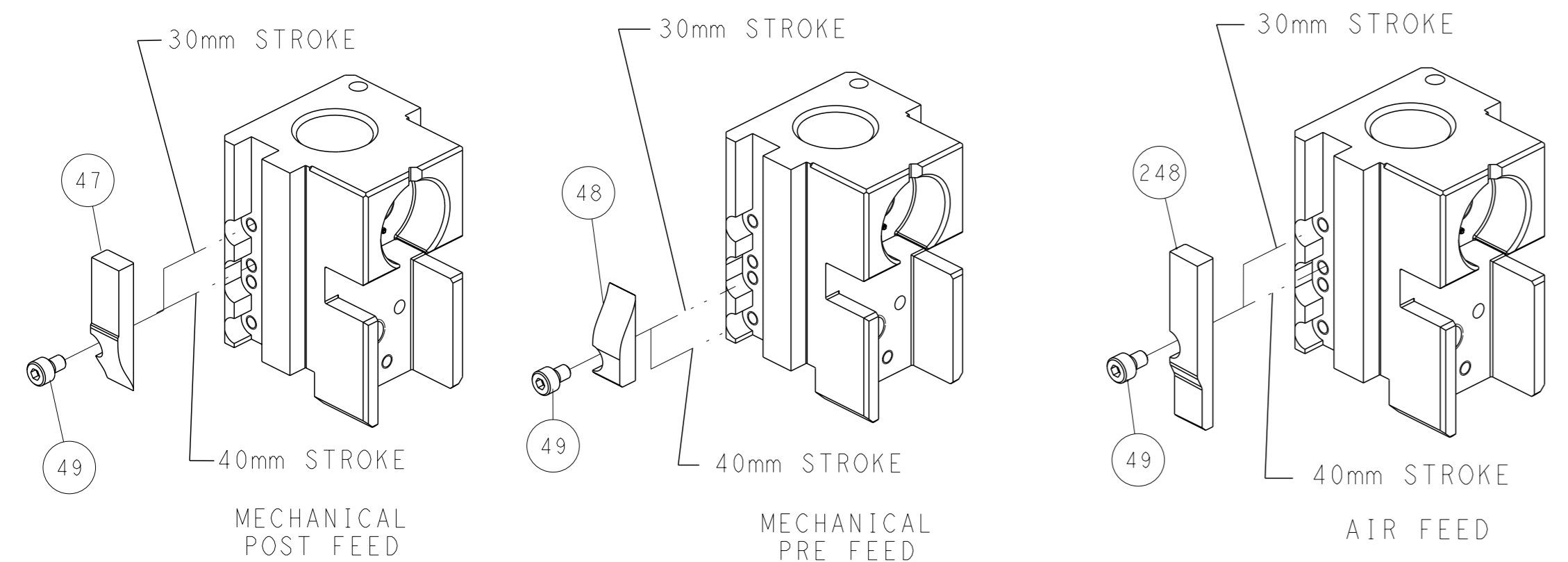
PNEUMATIC



FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



CAM POSITIONS

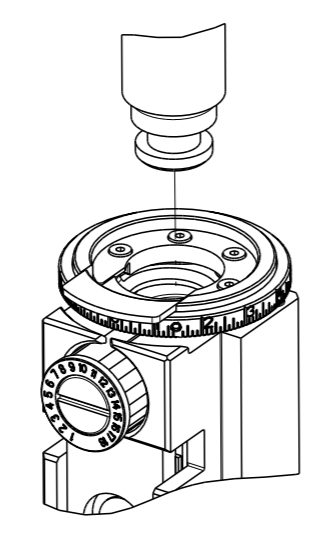


ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		OWN: L. GROSS 01APR2021 CHK: T. ELBIN 01APR2021 APVD: C. TOPPER 01APR2021 PRODUCT SPEC APPLICATION SPEC WEIGHT: - MATERIAL: -		NAME: OCEAN 2.0 Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2837255 SCALE: 1:2 SHEET: 2 of 4 REV: B		RESTRICTED TO: - CUSTOMER ACCESSIBLE PRODUCTION DRAWING	
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THIS DRAWING IS UNPUBLISHED.	RELEASED FOR PUBLICATION	20	
COPYRIGHT 20 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.			
PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2837255-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2837255-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2837255-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.27 mm [.050]	F
INSUL	1.78 mm [.070]	F
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: PROVERTHA TERMINAL TE CRIMP SPECIFICATION			
TERMINAL NAME: CRIMPKONTAKT STIFT			
WIRE STRIP LENGTH 2.29-3.06 mm [.090-.120 IN]		TERMINAL INSULATION DIAMETER RANGE Ø1.13-1.50 mm [.044-.059 IN]	
TERMINAL APPLICATION SPECIFICATION	NONE	-	AT9106
TERMINALS APPLIED			
TE TERMINAL 2113967-1	PROVERTHA TERMINAL C1520SLGXT	TE TERMINAL 2113967-2	PROVERTHA TERMINAL C1520GLGXT

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
20 AWG	0.87+/-0.05 [.034+/-0.002]	5.8
22 AWG	0.73+/-0.05 [.029+/-0.002]	7.2
24 AWG	0.65+/-0.05 [.026+/-0.002]	8.1

- 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. TERMINAL LUBRICANT IS RECOMMENDED.

***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)

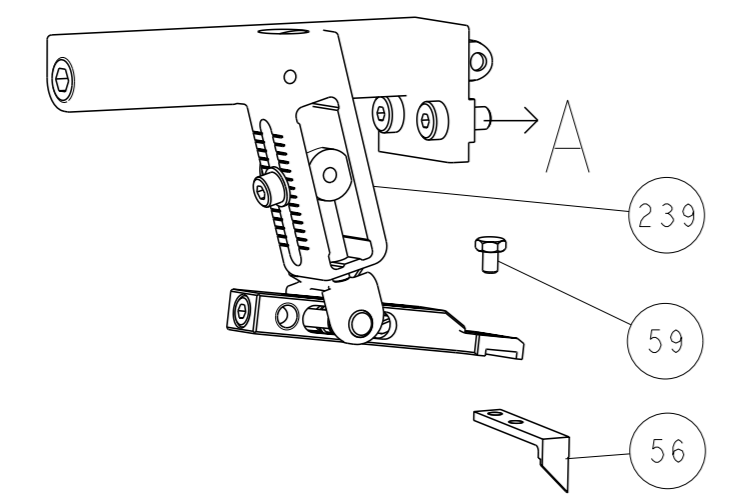
LOC	DIST	REVISIONS					
A	66	P	LYR	DESCRIPTION	DATE	OWN	APVD
-	-	-	-	SEE SHEET 1	-	-	-

-	1	1	2119082-4	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	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113
-	1	1	2844908-1	SCREW, LOCKING	99
-	1	1	2844907-1	POST, LOCKING	98
-	1	1	455888-5	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
-	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	1	1	1338685-1	PAWL, FEED	56
-	2	2	2-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 14	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	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	1752356-1	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	2844992-1	ASSEMBLY, STRIP GUIDE	29
-	1	1	1320928-2	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	1803095-6	FLOATING SHEAR, FRONT	9
-	1	1	9-1803171-2	ANVIL, COMBINATION	8
-	1	1	240641-5	SPACER	7
-	-	-	-	-	6
-	1	1	2119757-4	DEPRESSOR, SHEAR	5
-	1	1	2-238011-3	BLOCK, CRIMPER SPACER	4
-	1	1	1-1803246-0	CRIMPER, INSULATION F PREMIUM	3
-	-	-	-	-	2
-	1	1	3-1633860-9	CRIMPER, WIRE	1

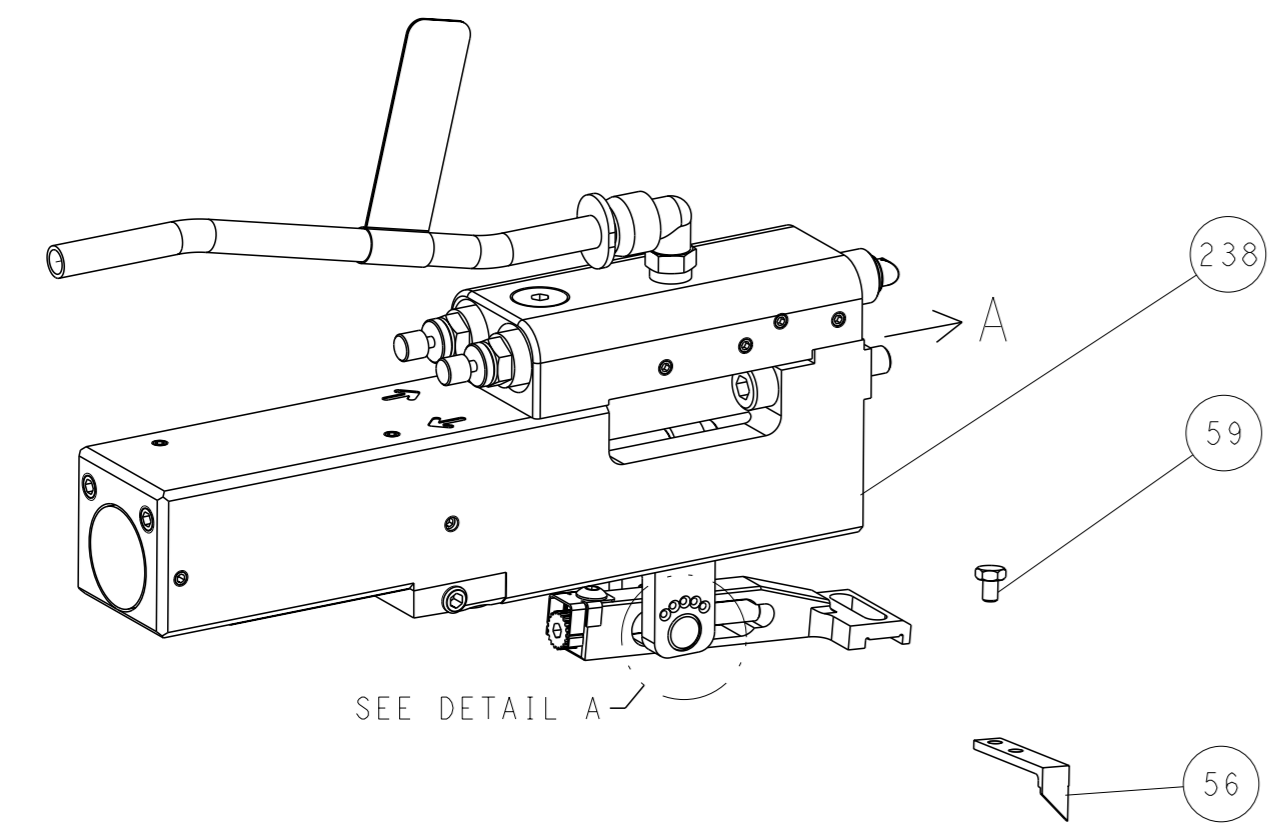
<small>THE DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE AND THE DRAWING INFORMATION SHOULD BE CONTACTED FOR THE LATEST REVISION.</small>		OWN: L. GROSS CHK: T. ELBIN APVD: C. TOPPER PRODUCT SPEC: - APPLICATION SPEC: - MATERIAL: - FINISH: -	DATE: 01APR2021 DATE: 01APR2021 DATE: 01APR2021	TE TE Connectivity Harrisburg, PA 17105-3608 NAME: OCEAN 2.0 Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2837255 SCALE: 1:2 SHEET: 3 OF 4 REV: B
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LOC		DIST		REVISIONS			
A	66	P	LYR	DESCRIPTION	DATE	OWN	APVD
		-		SEE SHEET 1			

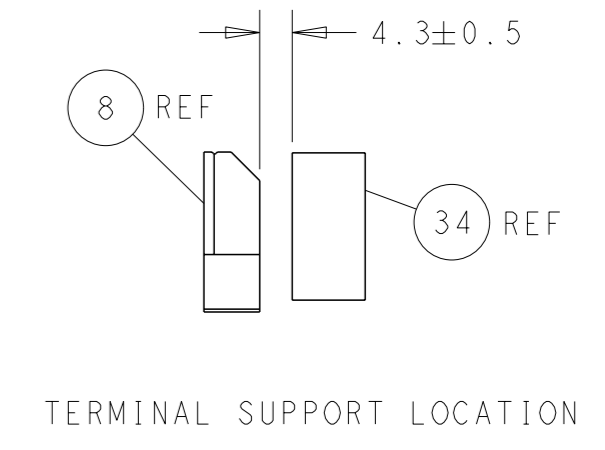
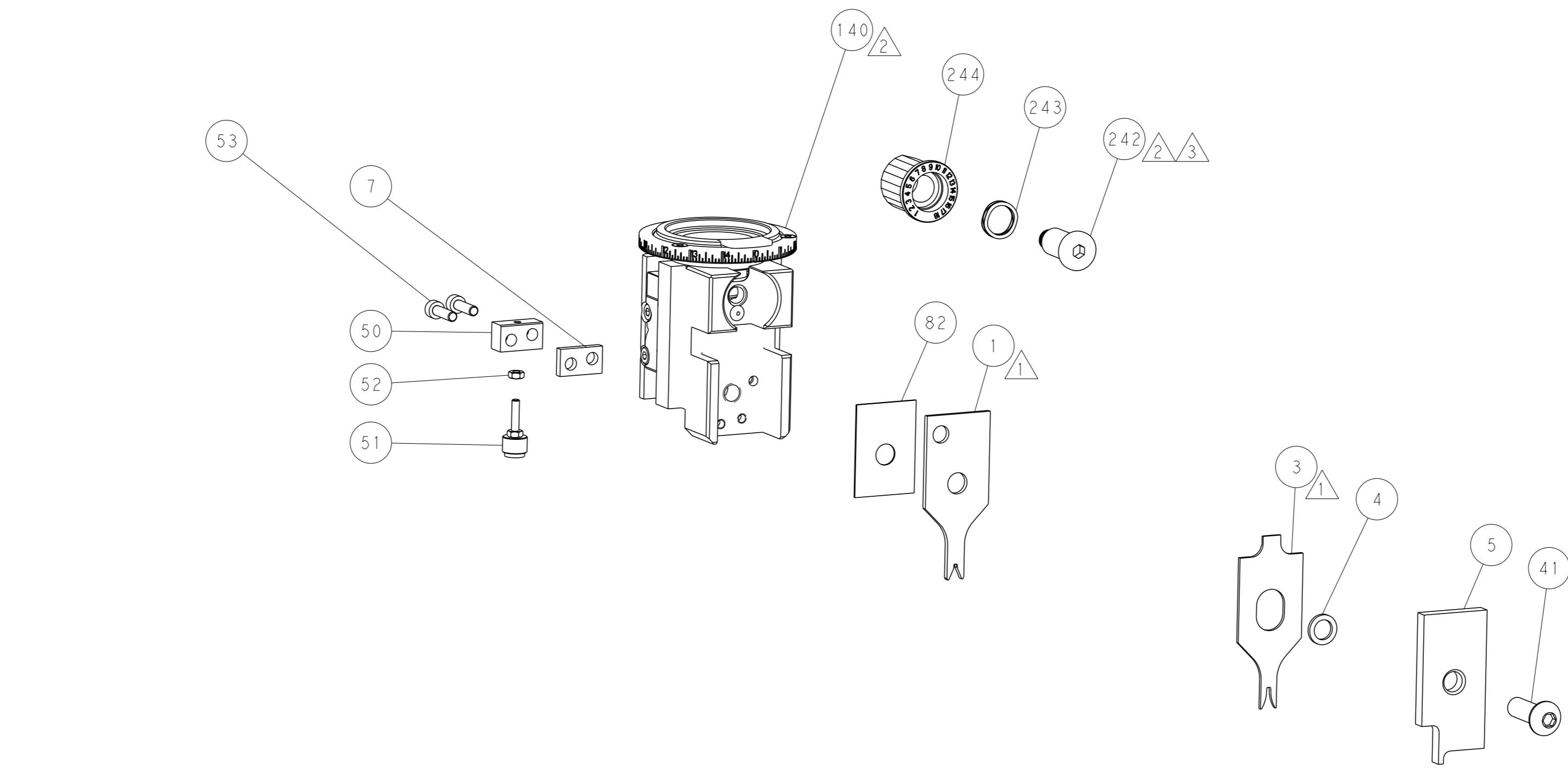
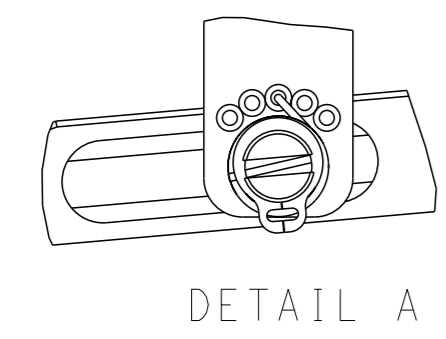
FEED TYPE MECHANICAL



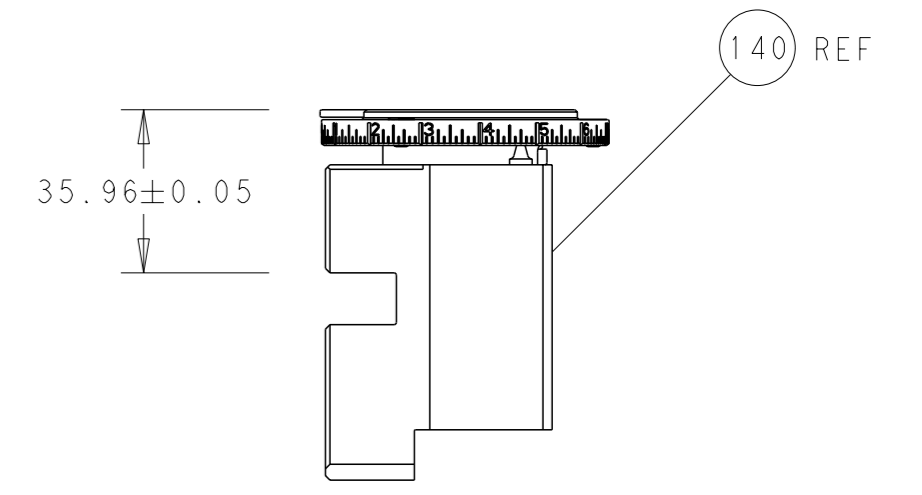
PNEUMATIC



FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)

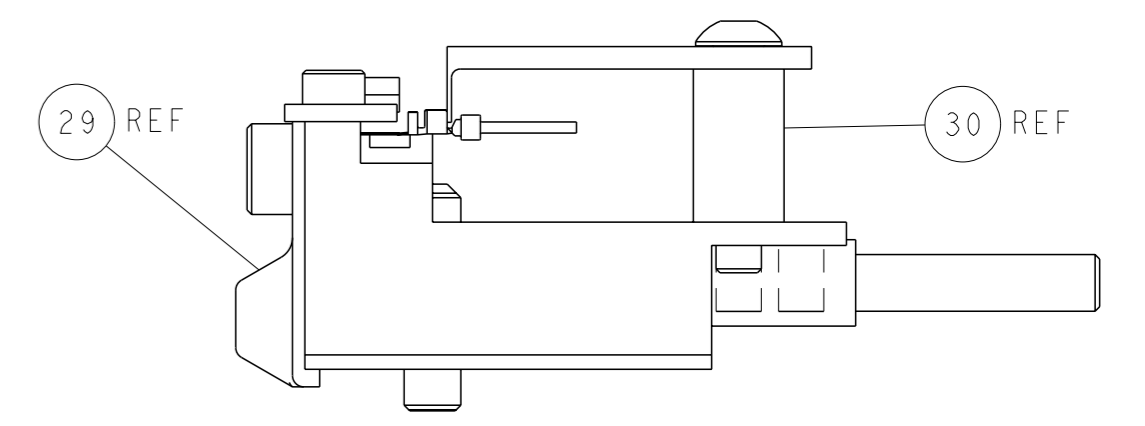


TERMINAL SUPPORT LOCATION



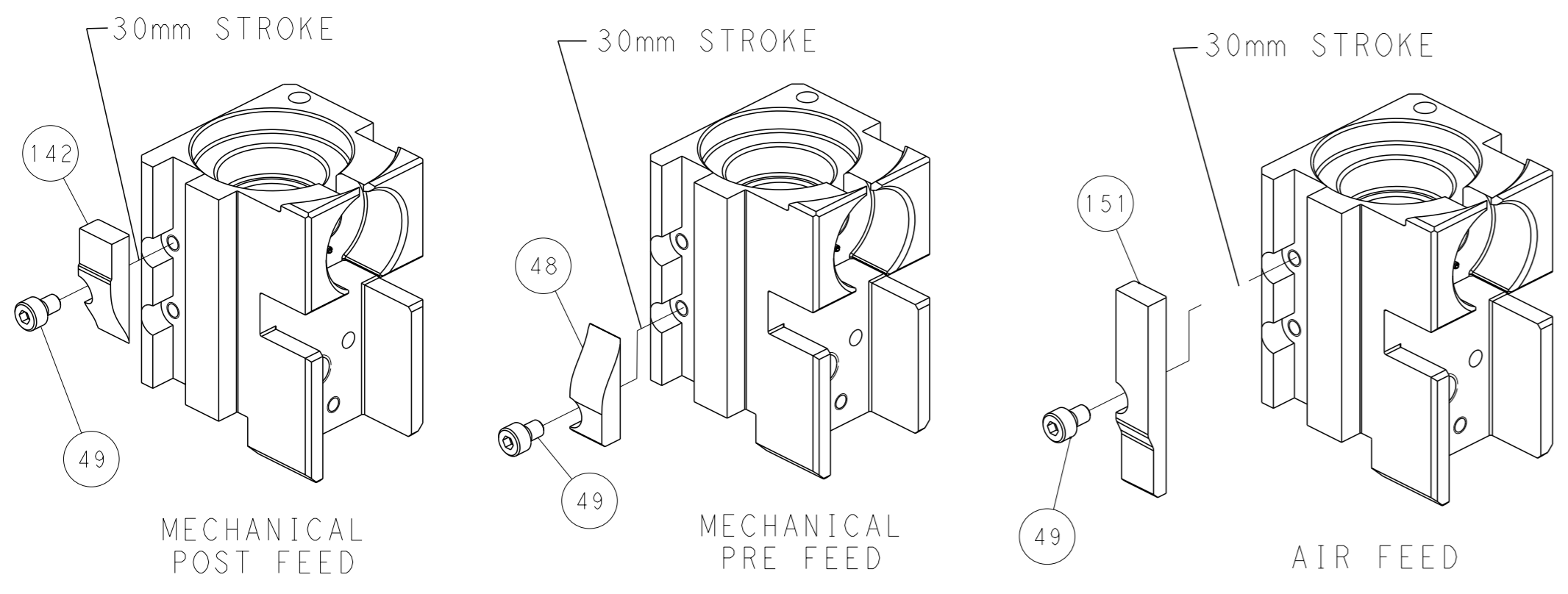
RAM SET-UP

ITEM 30 LOCATED AT
FRONT HOLES



FEED TRACK POSITION
GUIDE BY WIRE BARREL

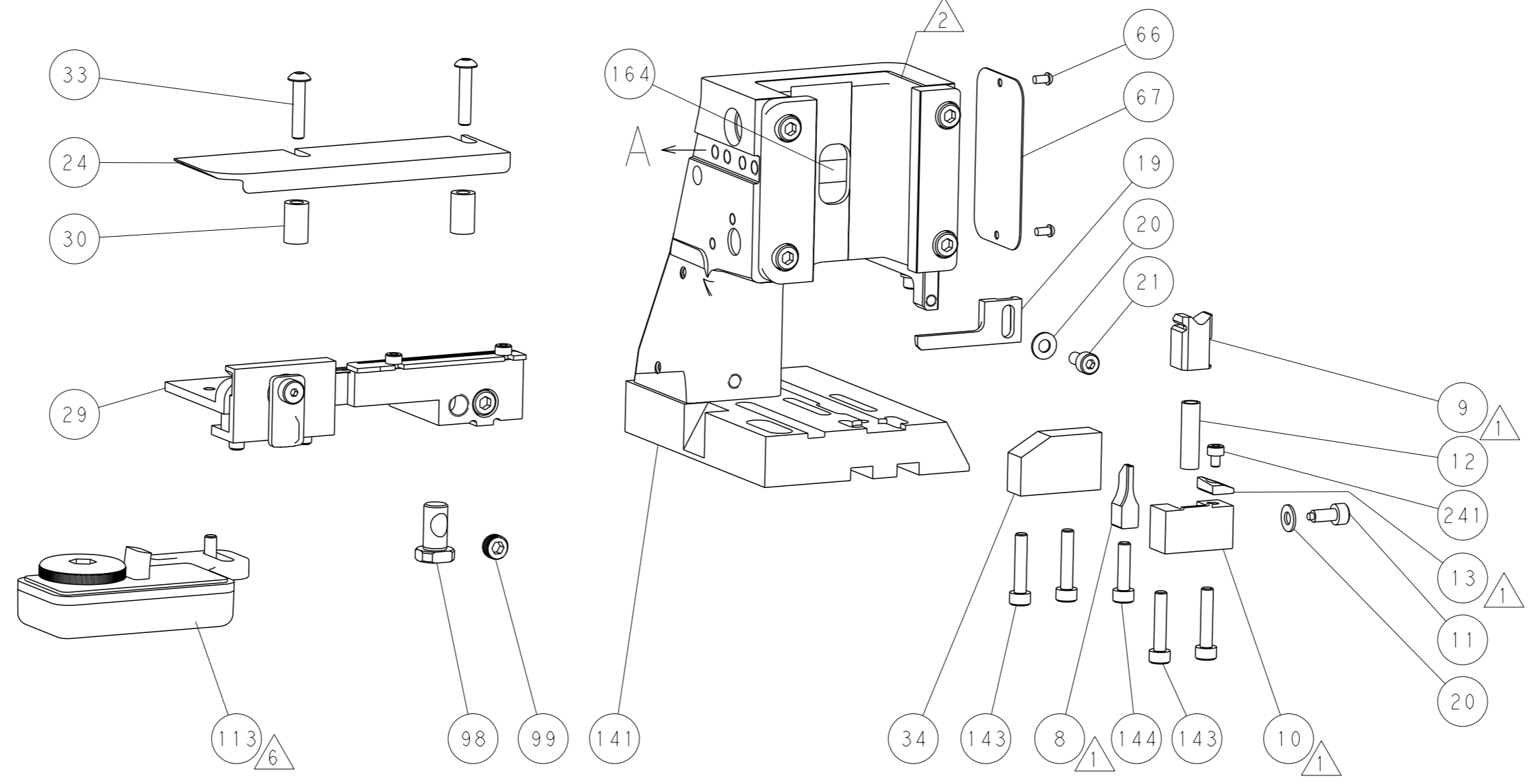
CAM POSITIONS



MECHANICAL
POST FEED

MECHANICAL
PRE FEED

AIR FEED



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 CONTROLLING ENGINEERING ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST REVISION.</small>		DWN T. ELBIN C. TOPPER PRODUCT SPEC APPLICATION SPEC WEIGHT MATERIAL	01APR2021 01APR2021 01APR2021 - - - -	TE Connectivity Harrisburg, PA 17105-3608 OCEAN 2.0 Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2837255 SCALE: 1:2 SHEET: 4 of 4 REV: B	RESTRICTED TO
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