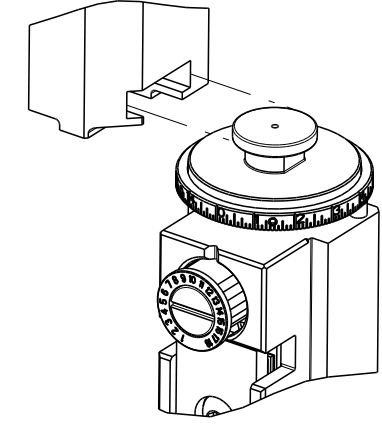


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2837258-1	A	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2837258-2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
5-2837258-1	A	SEAL STRIPPER CRIMPER TERMINATING UNIT	MECHANICAL
5-2837258-2	A	SEAL STRIPPER CRIMPER TERMINATING UNIT	PNEUMATIC
7-2837258-1	A	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2837258-2	A	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2837258-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.78 mm (.070)	F
INSUL	-	-

APPLICATOR INSTRUCTIONS  
408-35042

TERMINAL DATA: HEYCO TERMINAL TE CRIMP SPECIFICATION			
TERMINAL NAME: VE MED PIN NICKEL			
WIRE STRIP LENGTH	TERMINAL INSULATION DIAMETER RANGE		
4.35-5.11 mm (.171-.201 IN)	∅		
TERMINAL APPLICATION SPECIFICATION	NONE	AT9106	
TERMINALS APPLIED			
TE TERMINAL	HEYCO TERMINAL	TE TERMINAL	HEYCO TERMINAL
1572699-1	8033		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
22 AWG	1.14 +/- 0.05 [ .045 +/- .002 ]	7.1
24 AWG	1.09 +/- 0.05 [ .043 +/- .002 ]	7.8
26 AWG	1.05 +/- 0.05 [ .041 +/- .002 ]	8.1

- RECOMMENDED SPARE PARTS
- REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- 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.

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					
A	66	P	LTN	DESCRIPTION	DATE	OWN	APVD
		A		RELEASED	17AUG2023	TB	GB

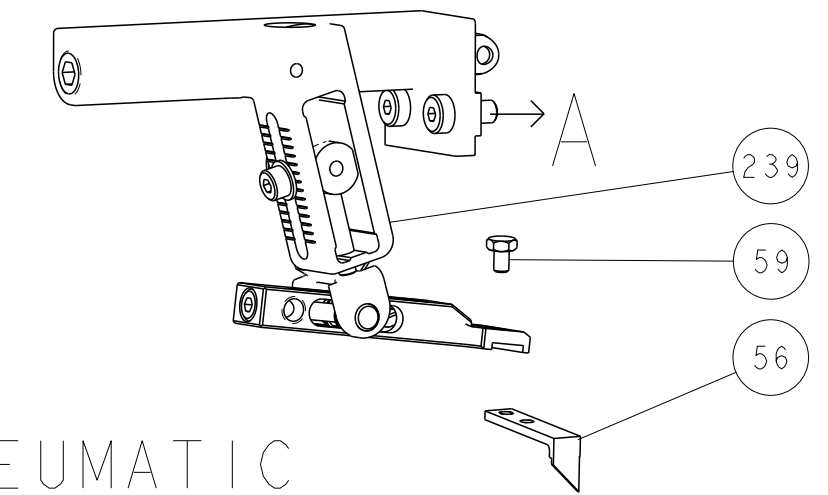
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-	1	1	1	1	1	1	22278-9	SPRING, COMPRESSION	299
-	2	2	2	2	2	2	4-18032-3	SCR, SET, FLT PNT, M3 X 6.0	298
-	1	1	1	1	1	1	1803944-1	SPACER, TONKER	297
-	-	-	1	1	-	-	2-1803583-1	APPLICATOR BASIC ASSEMBLY, SF	292
-	1	1	1	1	1	1	2119791-5	DEPRESSOR, WIRE	286
-	1	-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248
-	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
-	REF	REF	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	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	693855-1	FRONT STRIP GUIDE	96
-	2	2	2	2	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	95
-	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	2119943-1	WASHER, SPACER	69
-	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
-	2	2	2	2	2	2	2-18032-5	SCR, SET, FLT PNT, M5 X 20.0	61
-	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	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	53
-	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	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	2844992-3	ASSEMBLY, STRIP GUIDE	29
-	1	1	1	1	1	1	455888-2	SPACER, CRIMPER	28
-	2	2	2	2	2	2	2-22281-2	SPRING, COMPRESSION	27
-	1	1	1	1	1	1	356835-1	LEVER, DRAG RELEASE	26
-	1	1	1	1	1	1	240792-5	DRAG, TERMINAL	25
-	1	1	1	1	1	1	1320928-6	STRIP GUIDE	24
-	1	1	1	1	1	1	980371-4	SCR, SKT HD SHLDR 5.0 DIA X 6.0	23
-	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	1-1803190-4	ANVIL, WIRE	8
-	1	1	1	1	1	1	6-240641-8	SPACER	7
-	-	-	-	-	-	-	-	-	6
-	1	1	1	1	1	1	2119757-1	DEPRESSOR, SHEAR	5
-	-	-	-	-	-	-	-	-	4
-	-	-	-	-	-	-	-	-	3
-	-	-	-	-	-	-	-	-	2
-	1	2	2	1	1	1	9-1633860-5	CRIMPER, WIRE	1

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

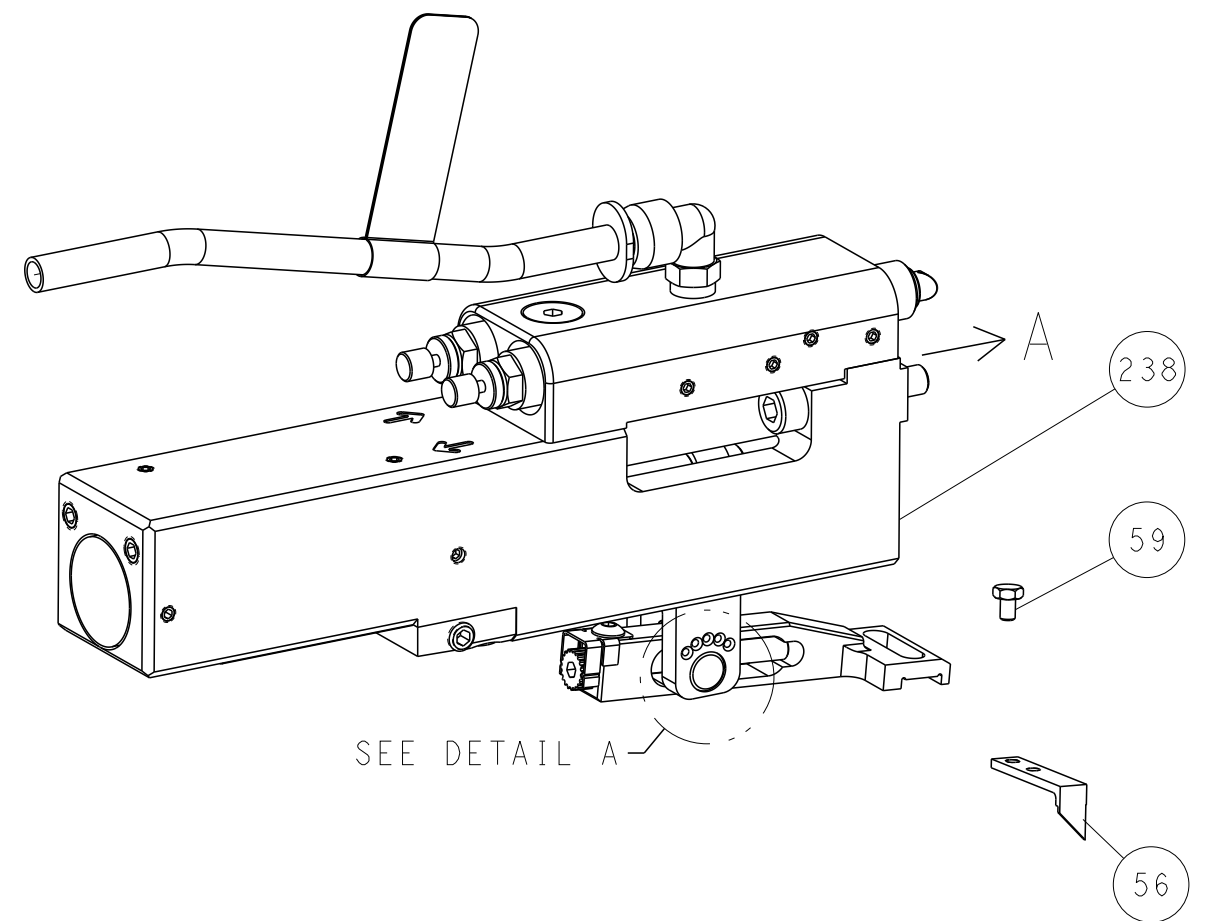
CHK T. BROOKENS 17AUG2023	OWN T. BROOKENS 17AUG2023	TE Connectivity Harrisburg, PA 17105-3608
CHK R. KNEPPER 17AUG2023	APVD G. BAILEY 17AUG2023	NAME OCEAN 2.0 Side Feed Applicator
DIMENSIONS: mm		SIZE CAGE CODE DRAWING NO RESTRICTED TO
TOLERANCES UNLESS OTHERWISE SPECIFIED:		SCALE 1:2 SHEET 1 OF 4 REV A
0 PLC ±	1 PLC ±	00779 ©=2837258
2 PLC ±	3 PLC ±	Customer Accessible Production Drawing
4 PLC ±	ANGLES ±	SCALE 1:2 SHEET 1 OF 4 REV A
FINISH	FINISH	

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

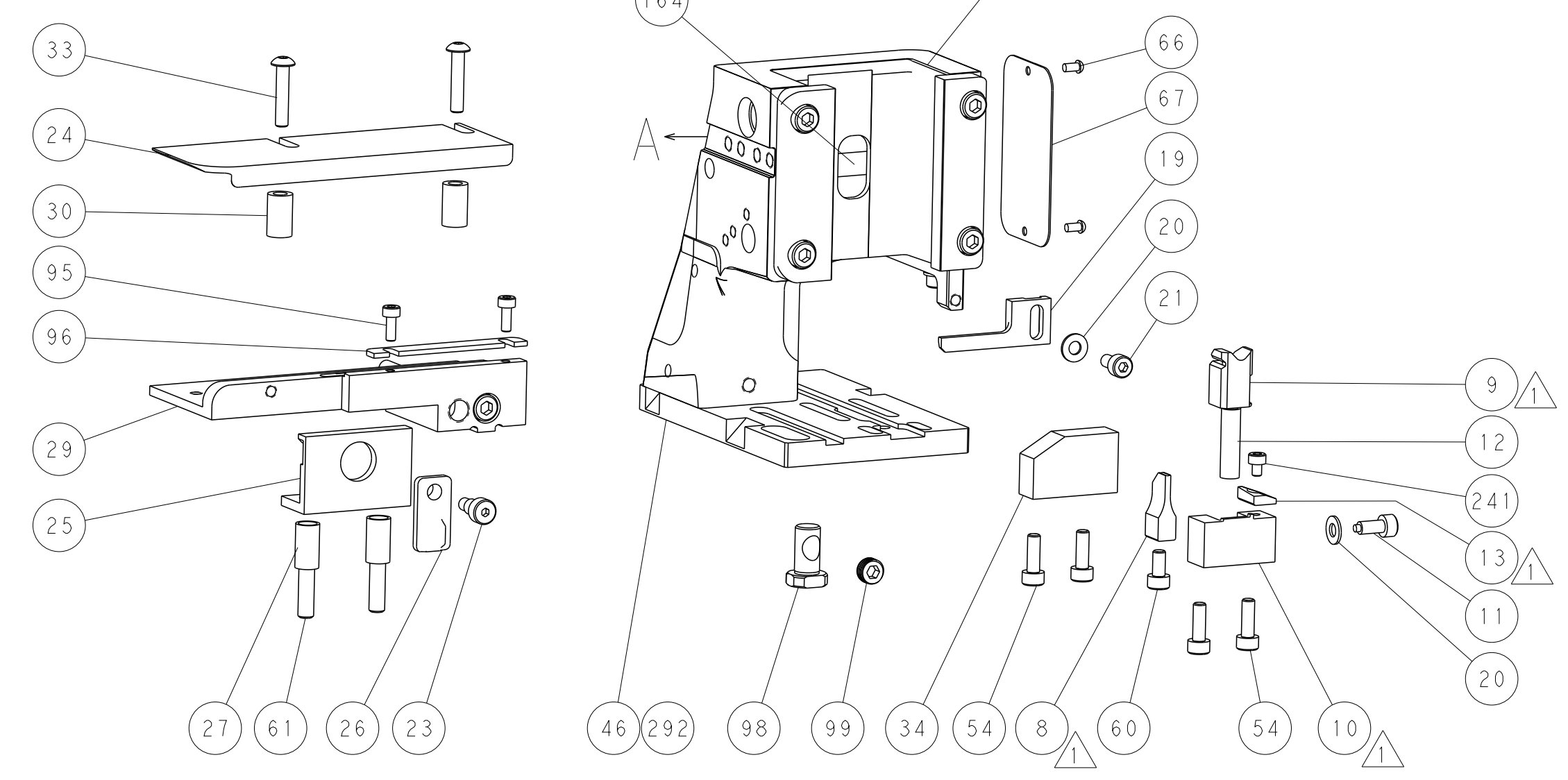
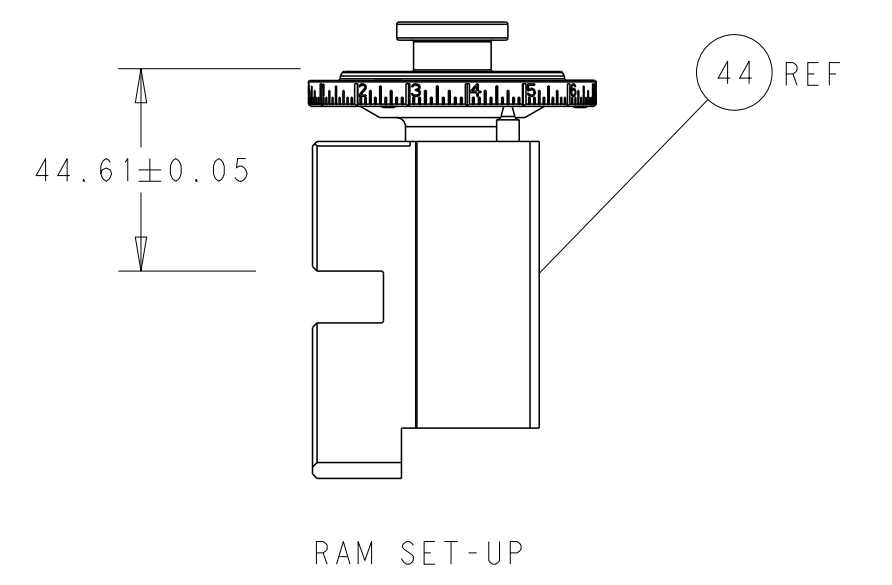
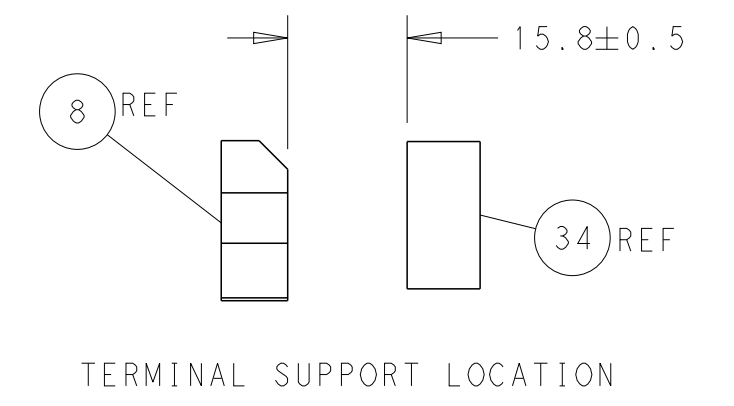
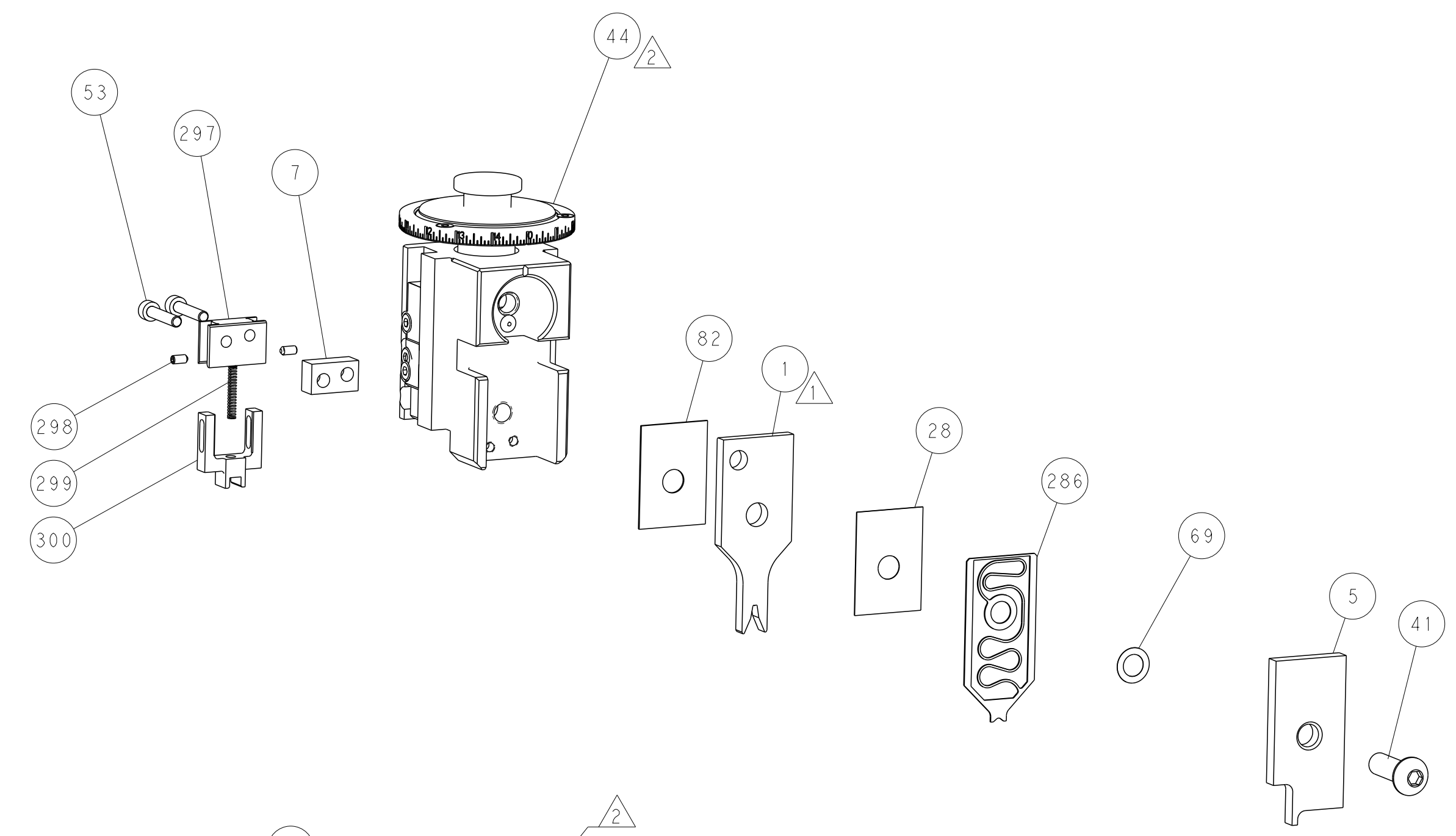
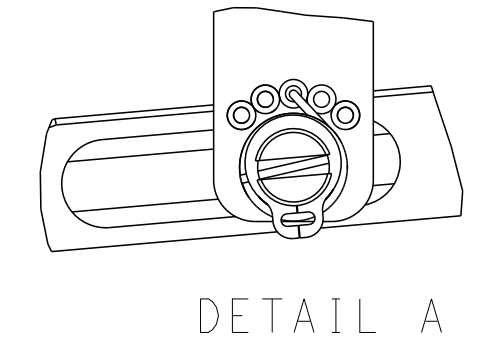
# FEED TYPE MECHANICAL



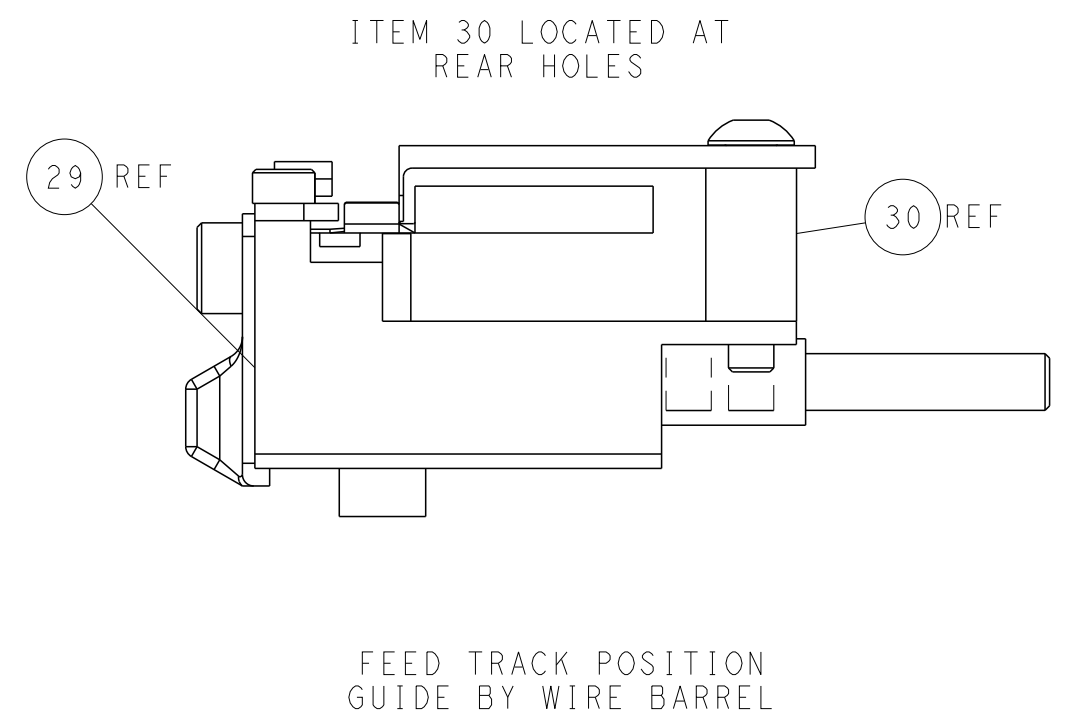
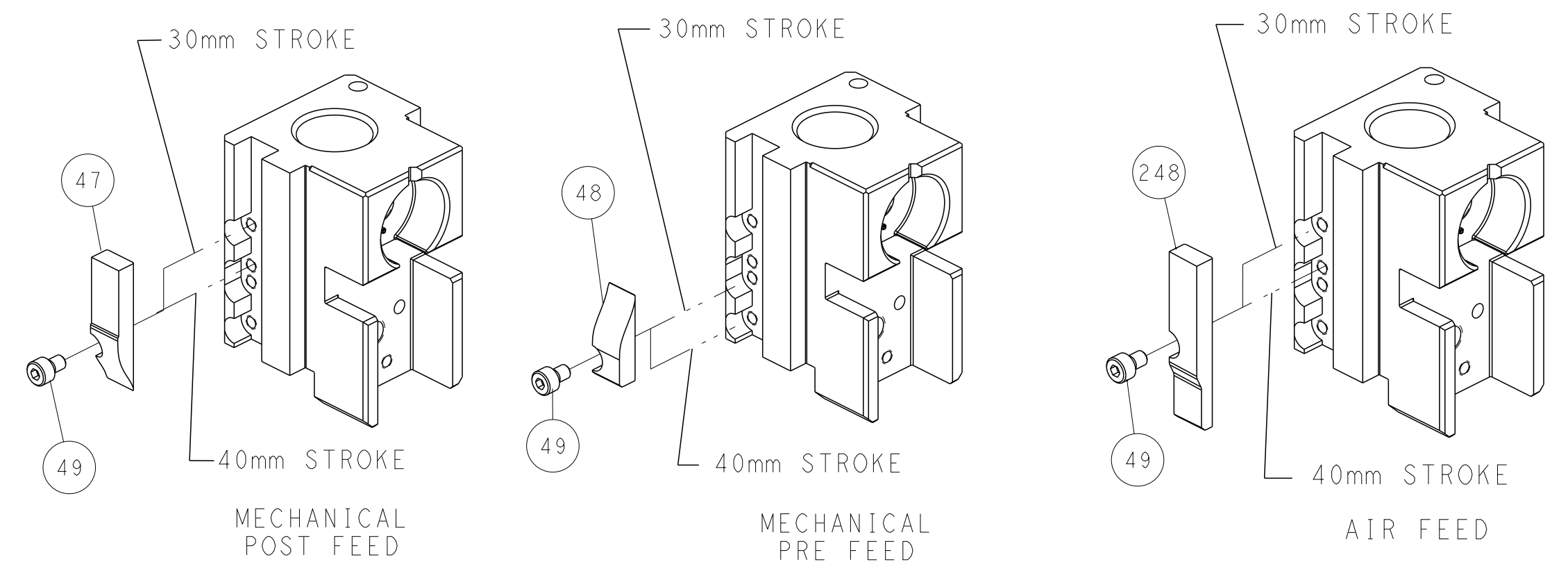
## PNEUMATIC



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



# CAM POSITIONS

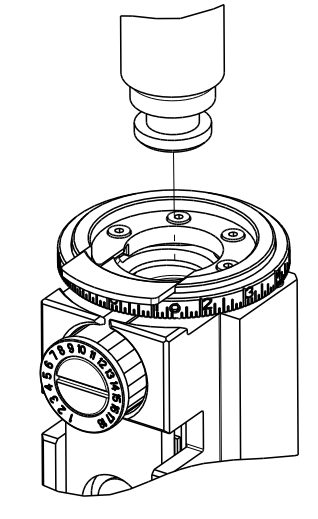


**ATLANTIC VERSION**  
 Shown on sheets 1 of 4 & 2 of 4  
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

<small>THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.</small>		DWN T. BROOKENS 17AUG2023 CHK R. KNEPPER 17AUG2023 APVD G. BAILEY 17AUG2023	<b>STE</b> 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 2.0 Side Feed Applicator APPLICATION SPEC: - PRODUCT SPEC: - SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2837258	RESTRICTED TO: - SCALE: 1:2 SHEET: 2 of 4 REV: A
MATERIAL: - WEIGHT: -		Customer Accessible Production Drawing	

THIS DRAWING IS UNPUBLISHED.	RELEASED FOR PUBLICATION		
COPYRIGHT 20 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.			
PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2837258-1	A	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2837258-2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2837258-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR  
INTERFACE ADAPTER



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

TERMINAL DATA: HEYCO TERMINAL TE CRIMP SPECIFICATION	
TERMINAL NAME: VE MED PIN NICKEL	
WIRE STRIP LENGTH 4.35-5.11 mm [1.71-.201 IN]	TERMINAL INSULATION DIAMETER RANGE Ø
TERMINAL APPLICATION SPECIFICATION NONE	AT9106
TERMINALS APPLIED	
TE TERMINAL 1572699-1	HEYCO TERMINAL 8033

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
22 AWG	1.14 +/- 0.05 [0.045 +/- .002]	7.1
24 AWG	1.09 +/- 0.05 [0.043 +/- .002]	7.8
26 AWG	1.05 +/- 0.05 [0.041 +/- .002]	8.1

- 1. RECOMMENDED SPARE PARTS
- 2. REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- 3. 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.
- 4. 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)

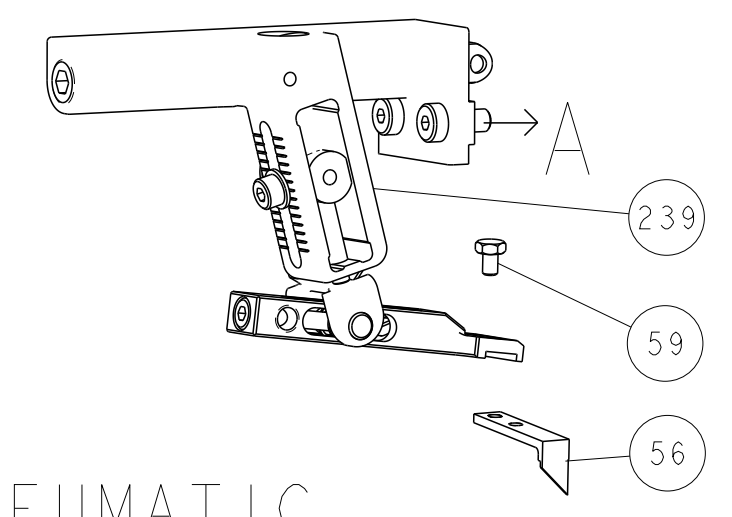
LOC	DIST	REVISIONS					
A	66	P	LTN	DESCRIPTION	DATE	DWN	APVD
-	-	-	-	SEE SHEET 1	-	-	-

-	1	1	4-1803945-2	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	2119791-5	DEPRESSOR, WIRE	286	
-	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	2844908-1	SCREW, LOCKING	99	
-	1	1	2844907-1	POST, LOCKING	98	
-	1	1	693855-1	FRONT STRIP GUIDE	96	
-	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	95	
-	1	1	455888-5	SPACER, CRIMPER	82	
-	1	1	1803607-3	DOCUMENTATION PACKAGE	71	
-	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	
-	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	1338685-1	PAWL, FEED	56	
-	2	2	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	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	1752356-1	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	2844992-3	ASSEMBLY, STRIP GUIDE	29	
-	1	1	455888-2	SPACER, CRIMPER	28	
-	2	2	2-22281-2	SPRING, COMPRESSION	27	
-	1	1	356835-1	LEVER, DRAG RELEASE	26	
-	1	1	240792-5	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	1803095-6	FLOATING SHEAR, FRONT	9	
-	1	1	1-1803190-4	ANVIL, WIRE	8	
-	1	1	6-240641-8	SPACER	7	
-	-	-	-	-	6	
-	1	1	2119757-1	DEPRESSOR, SHEAR	5	
-	-	-	-	-	4	
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-	-	-	-	-	2	
-	1	1	1	9-1633860-5	CRIMPER, WIRE	1

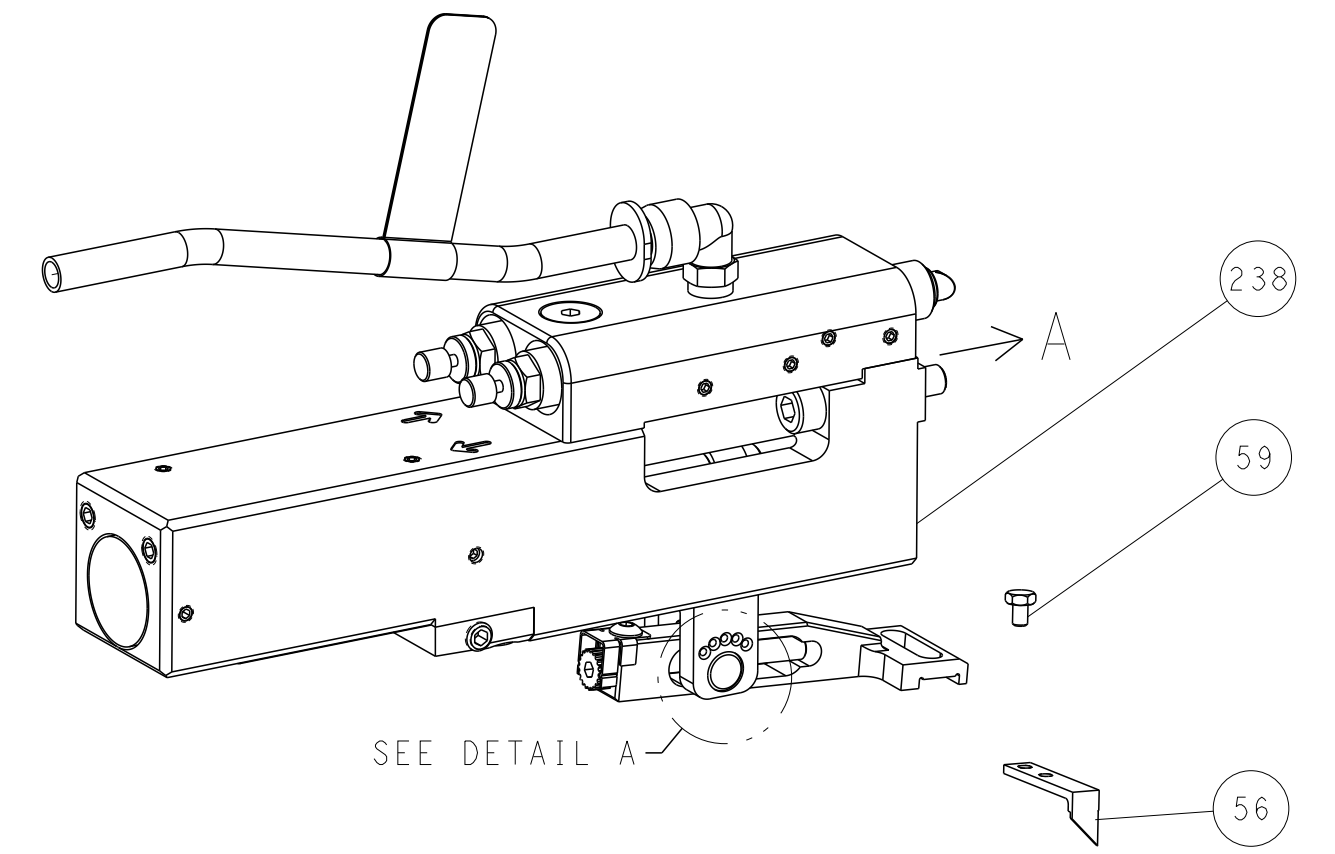
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DRAWN: T. BROOKENS 17AUG2023		CHK: R. KNEPPER 17AUG2023		NAME: OCEAN 2.0 Side Feed Applicator	
0 PLC	±	1 PLC	±	APVD: G. BAILEY 17AUG2023	PRODUCT SPEC		SIZE: A		RESTRICTED TO:
2 PLC	±	3 PLC	±	APPLICATION SPEC		CAGE CODE: 00779		SCALE: 1:2	
4 PLC	±	ANGLES		WEIGHT		DRAWING NO: 2837258		SHEET 3 OF 4	
MATERIAL		FINISH		CUSTOMER ACCESSIBLE PRODUCTION DRAWING		REV: A		REV: A	

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

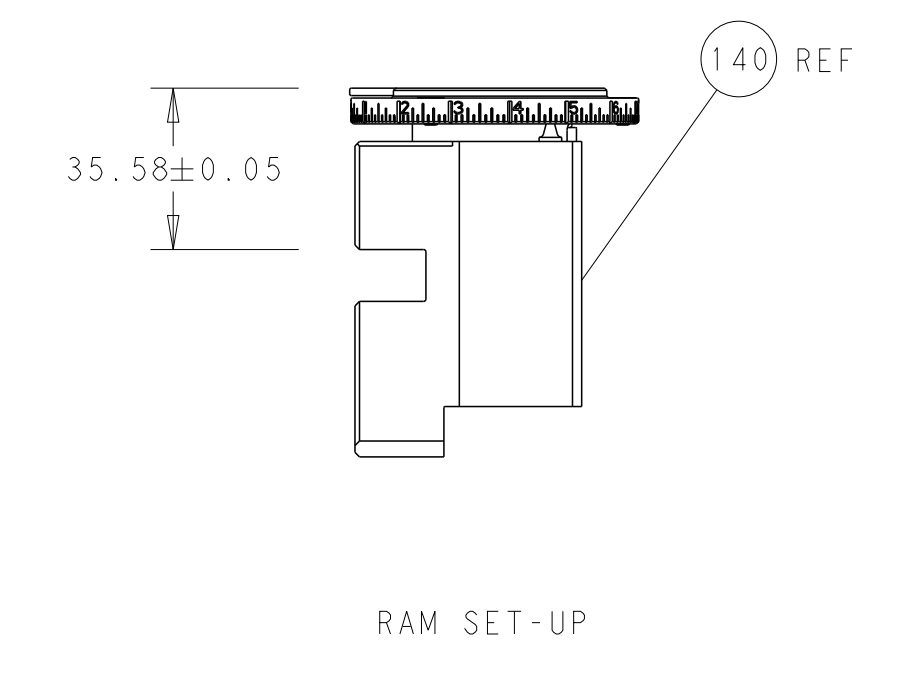
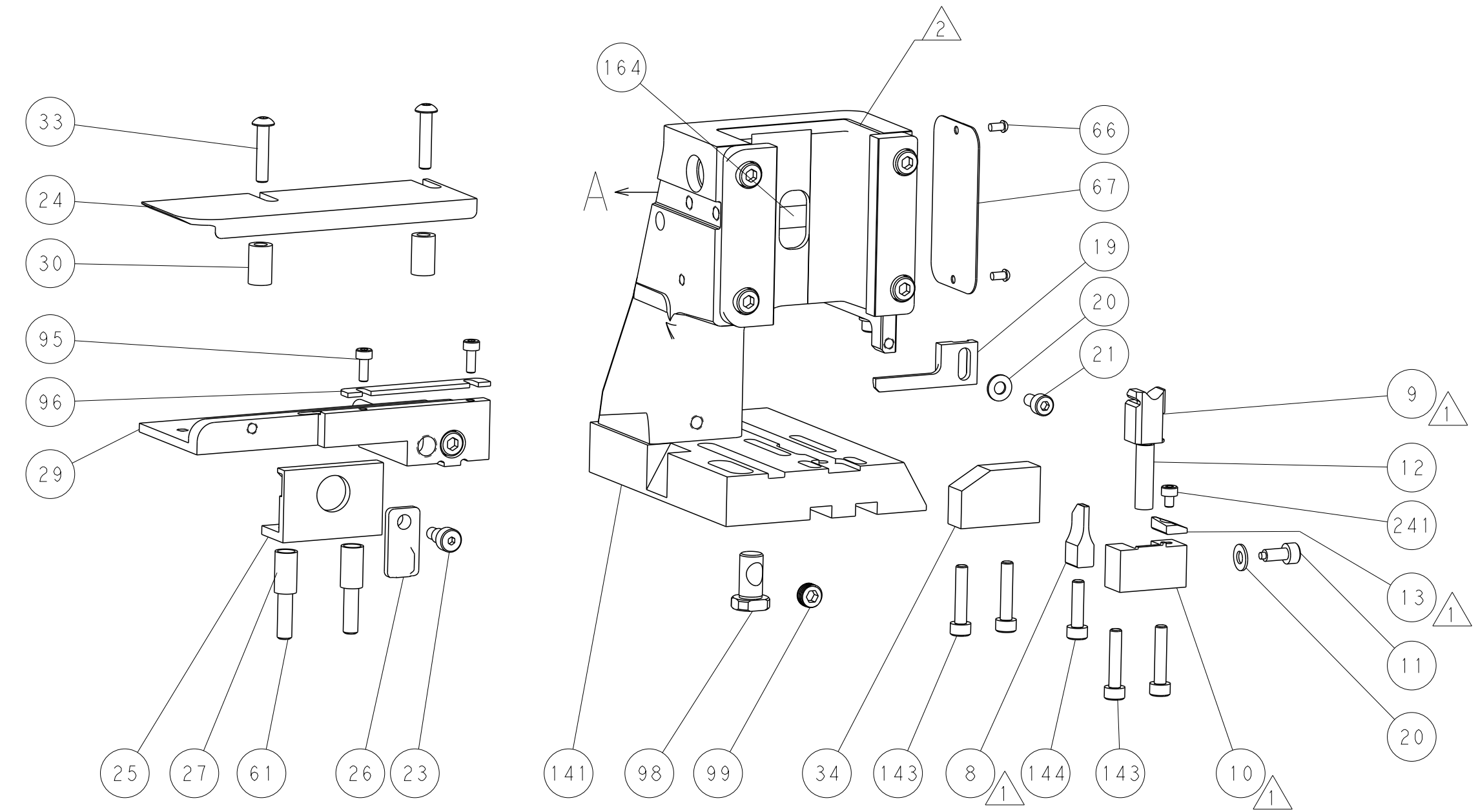
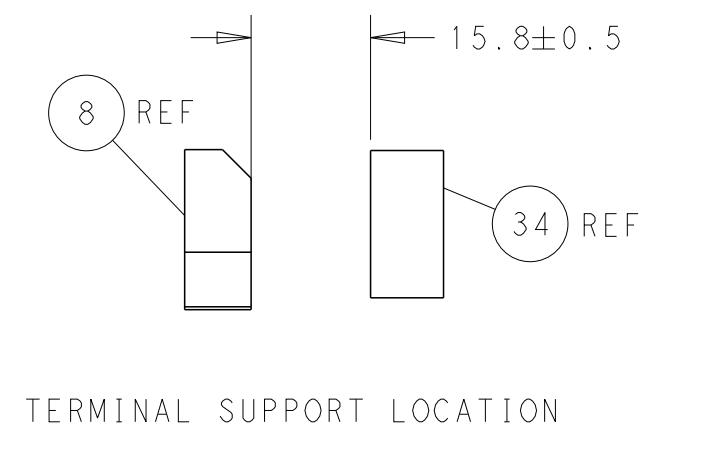
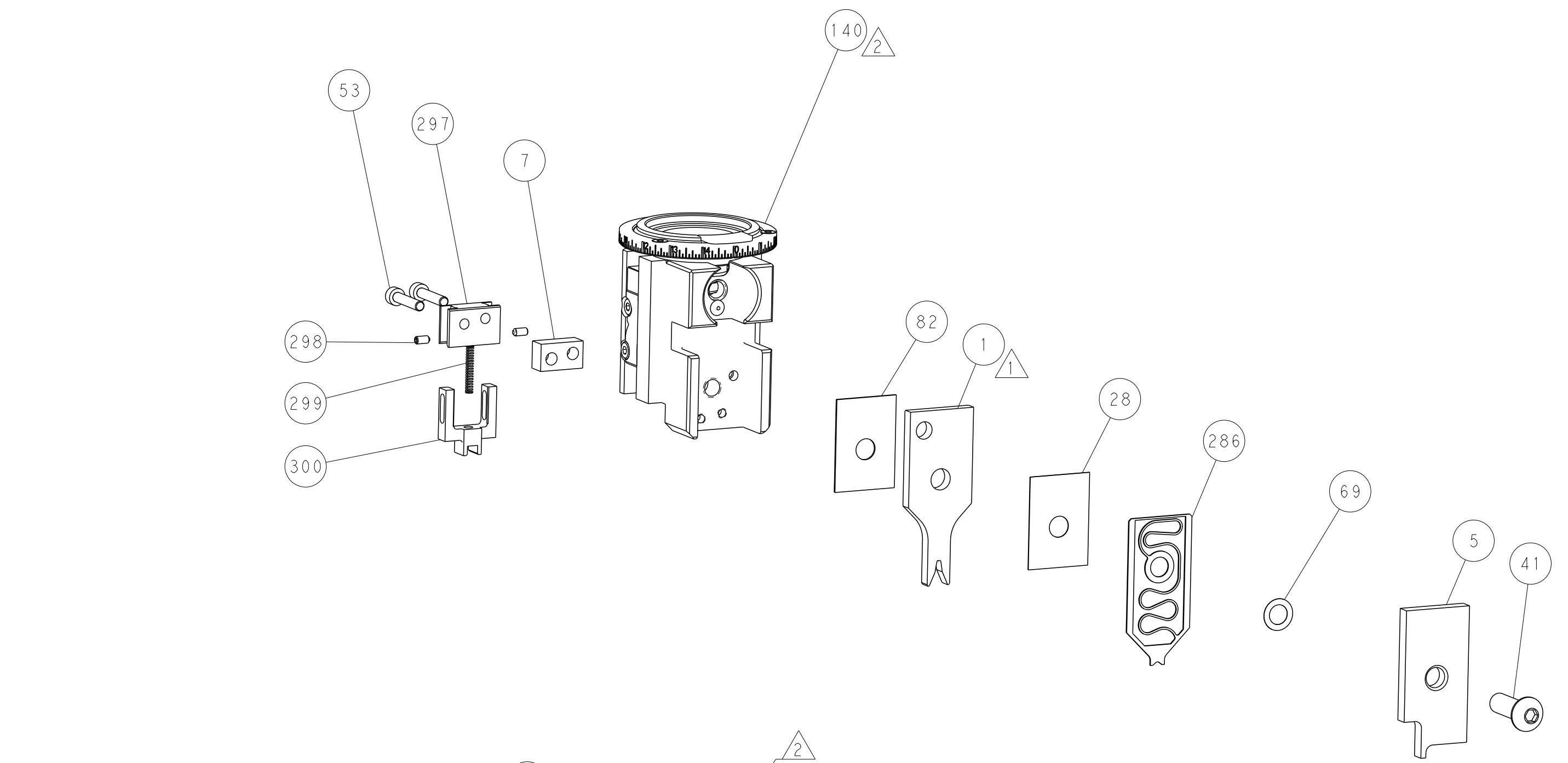
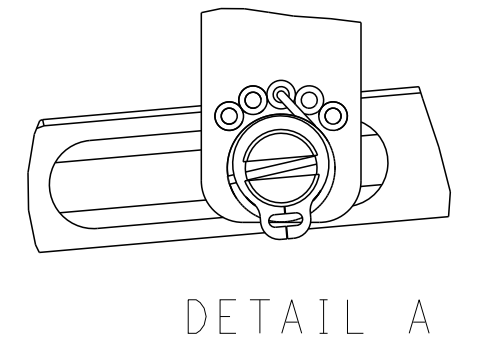
# FEED TYPE MECHANICAL



## PNEUMATIC

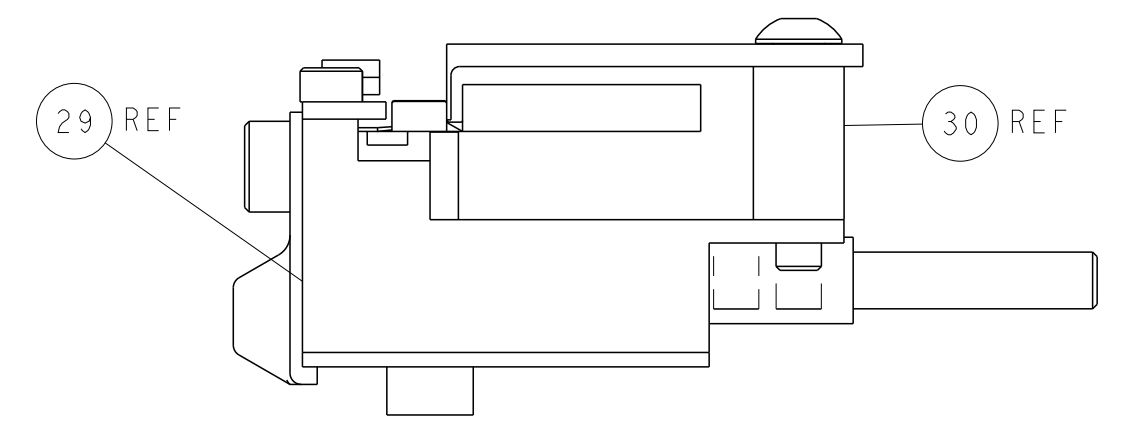
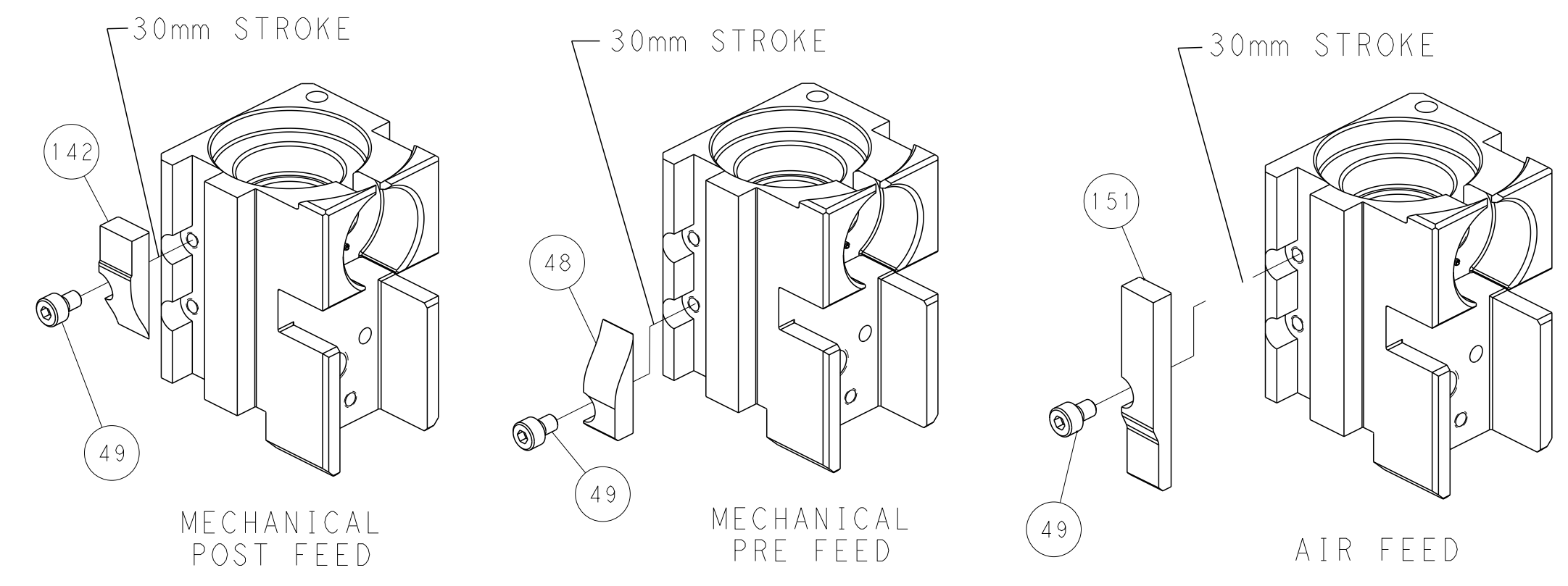


### FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



ITEM 30 LOCATED AT REAR 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:		DWG: T. BROOKENS 17AUG2023		TE Connectivity	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	Harrisburg, PA 17105-3608	
MATERIAL:		FINISH:		CHK: R. KNEPPER 17AUG2023		NAME: OCEAN 2.0 Side Feed Applicator	
				APVD: G. BAILEY 17AUG2023		SIZE: A1	
				PRODUCT SPEC:		CAGE CODE: 00779	
				APPLICATION SPEC:		DRAWING NO: 2837258	
				WEIGHT:		SCALE: 1:2	
				Customer Accessible Production Drawing		SHEET 4 OF 4 REV A	