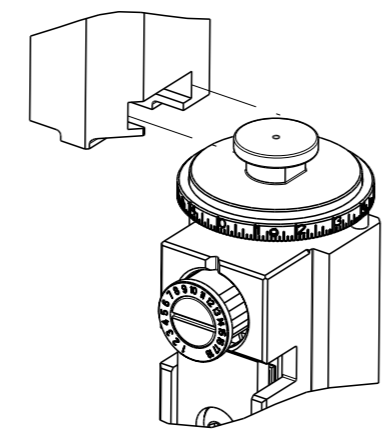


THIS DRAWING IS UNPUBLISHED.	RELEASED FOR PUBLICATION	2019	
COPYRIGHT 2019 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.			
PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2837652-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2837652-2	B	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2837652-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



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

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: MCON 1.2 TAB-CB			
WIRE STRIP LENGTH		TERMINAL INSULATION DIAMETER RANGE	
3.00-3.60 mm [.118-.142 IN]		Ø1.10-1.75 mm [.043-.069 IN]	
TERMINAL APPLICATION SPECIFICATION	114-18464		AT9106
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
1718348-1	1718348-2	1718348-3	7-1718348-1
7-1718348-2	7-1718348-3		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: MCON 1.2 CB			
WIRE STRIP LENGTH		TERMINAL INSULATION DIAMETER RANGE	
3.00-3.60 mm [.118-.142 IN]		Ø1.10-1.75 mm [.043-.069 IN]	
TERMINAL APPLICATION SPECIFICATION	114-18464		AT9106
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
1534594-1	1534594-2	1534594-3	

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.35mm2	0.84 +/- 0.03 [.033 +/- .001]	4.6
22 AWG	0.83 +/- 0.03 [.033 +/- .001]	4.8
24 AWG	0.75 +/- 0.03 [.030 +/- .001]	5.8

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
22 AWG	0.86 +/- 0.03 [.034 +/- .001]	4.3
0.35mm2	0.81 +/- 0.03 [.032 +/- .001]	5.1
24 AWG	0.80 +/- 0.03 [.031 +/- .001]	5.2

- RECOMMENDED SPARE PARTS
- REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION & 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.
- 5. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT 101-35000.
- TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- 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)

LOC	DIST	REVISIONS					
A	66	#	LY#	DESCRIPTION	DATE	OWN	APVD
		1		PRELIMINARY	21AUG2019	MEH	TE
		A		RELEASED	01NOV2019	MEH	TE
		A1		ECR-21-007050	27JUL2021	TB	TE
		B		ECR-22-134496	31MAR2022	FJ	TE

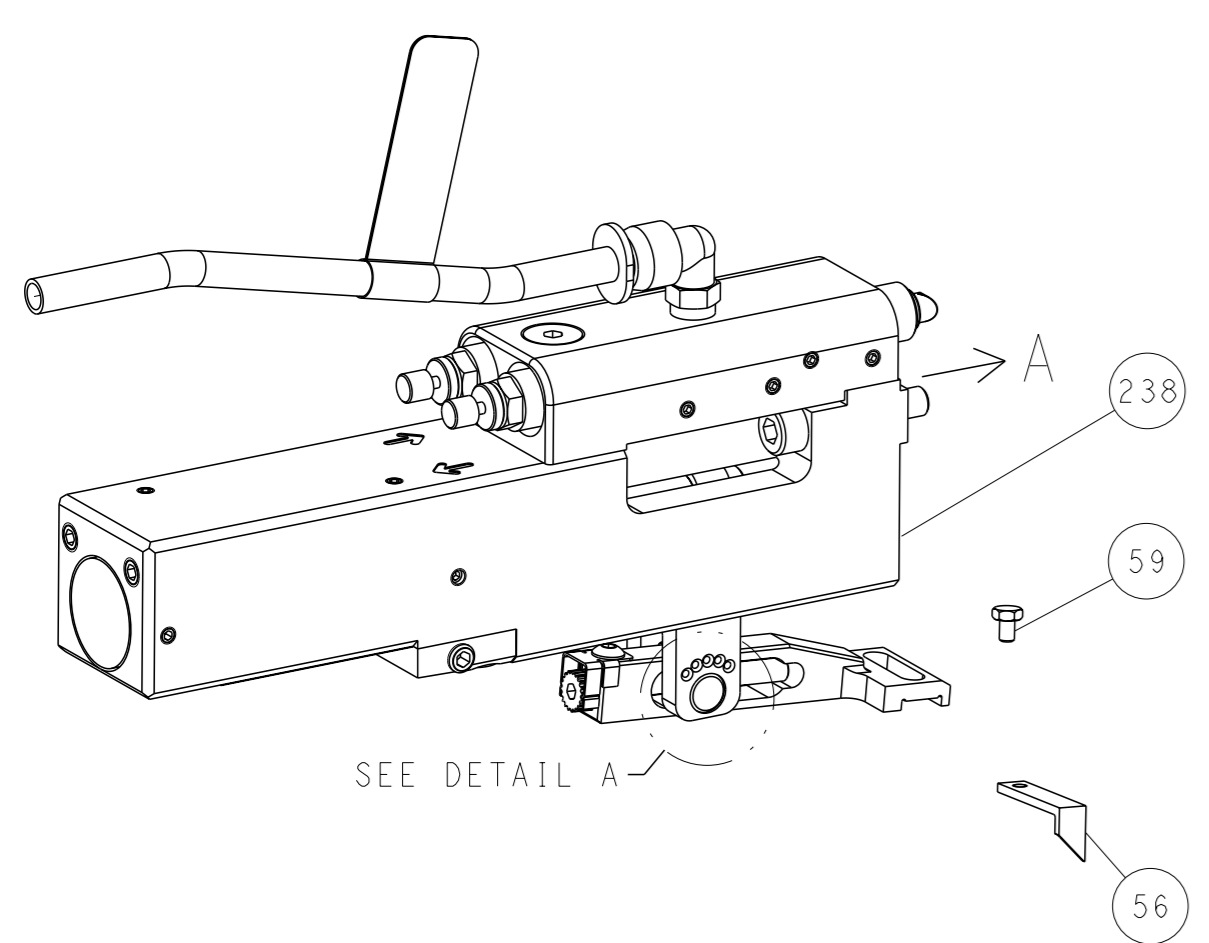
-	1	1	2-1803945-0	TONKER	300
-	1	1	4-22278-3	SPRING, COMPRESSION	299
-	2	2	4-18032-3	SCR, SET, FLT PNT, M3 X 6.0	298
-	1	1	1803944-1	SPACER, TONKER	297
-	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	269
-	1	1	1633782-8	FENCE	267
-	1	1	2119641-1	FEED CAM, AIR FEED	248
-	1	1	2119082-4	CAM, SNAIL, INSULATION 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	1	2844940-1	AIR FEED MODULE	238
1	2	1	8-1633918-6	ANVIL, COMBINATION	187
-	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	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	1-690438-0	FRONT STRIP GUIDE	96
-	1	1	455888-7	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	2079383-4	SCR, BHSC, RoHS (M4 X 8)	60
-	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	1	1	1338683-6	FEED PAWL	56
-	4	4	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	54
-	2	2	2-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 14	53
-	1	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	1	1	3-1803583-1	APPLICATOR BASIC ASSEMBLY, SF	46
-	1	1	1803515-1	RAM ASSEMBLY, SF ATLANTIC	44
-	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
-	1	1	5-1752356-5	SUPPORT, TERMINAL	34
-	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	2-2844962-5	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	2844992-5	ASSEMBLY, STRIP GUIDE	29
-	1	1	1803159-4	DEPRESSOR, DUAL WIRE	28
-	2	2	22283-1	SPRING, COMPRESSION	27
-	1	1	240792-1	DRAG, TERMINAL	25
-	1	1	1320928-6	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	2119533-7	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	2119805-7	SHEAR HOLDER, FRONT	10
-	1	1	318059-9	FLOATING SHEAR, FRONT	9
1	2	1	8-1633918-5	ANVIL, COMBINATION	8
-	1	1	240641-9	SPACER	7
-	-	-	-	-	6
-	1	1	2-1803080-1	DEPRESSOR, SHEAR	5
-	1	1	238011-4	BLOCK, CRIMPER SPACER	4
1	2	1	1803354-7	CRIMPER, DUAL INSULATION O	3
-	1	1	455888-5	SPACER, CRIMPER	2
1	2	1	5-458209-1	CRIMPER, WIRE F	1
-	77	-72	-2	PART NO	ITEM NO

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		OWN	M. HERR	21AUG2019		TE Connectivity
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES ±		Harrisburg, PA 17105-3608
MATERIAL	FINISH	WEIGHT	SCALE	APVD	B. BAIR	21AUG2019	NAME	OCEAN 2.0 Side Feed Applicator
			1:2	SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO	
				Customer Accessible Production Drawing	SCALE	1:2	SHEET	1 OF 4
							REV	B

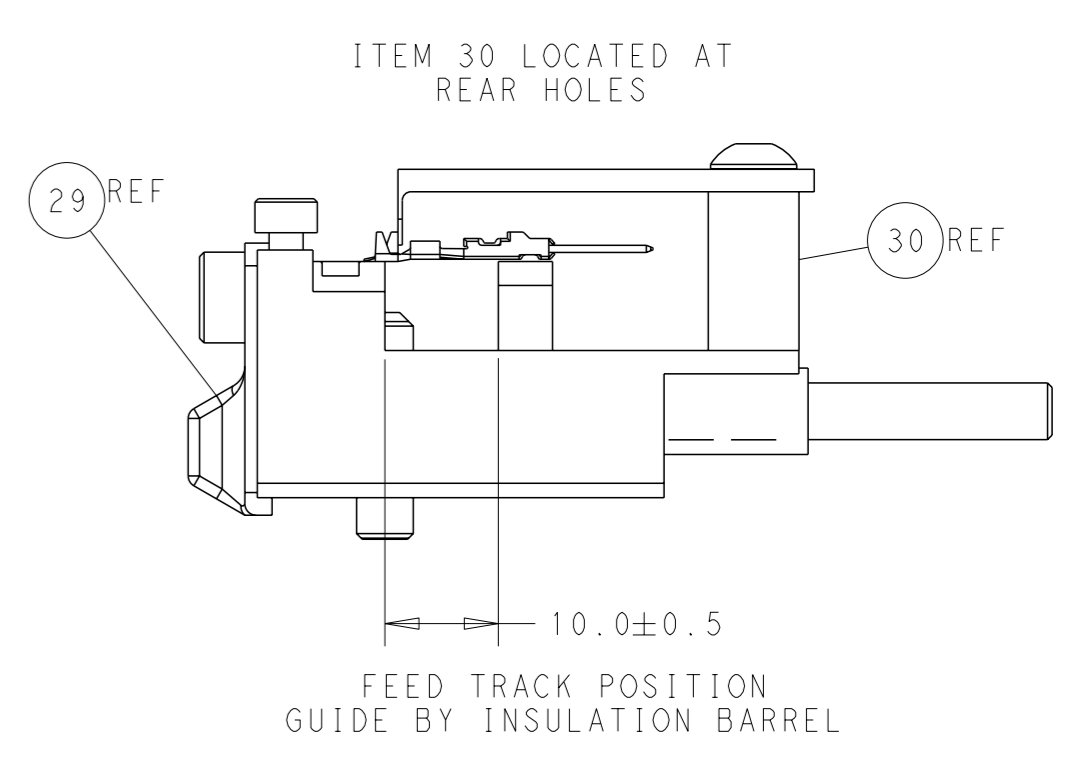
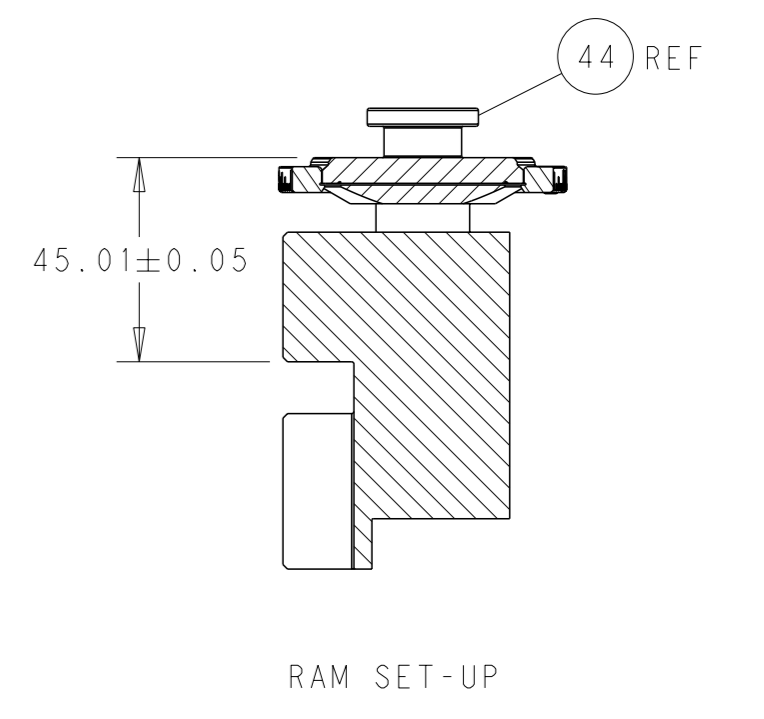
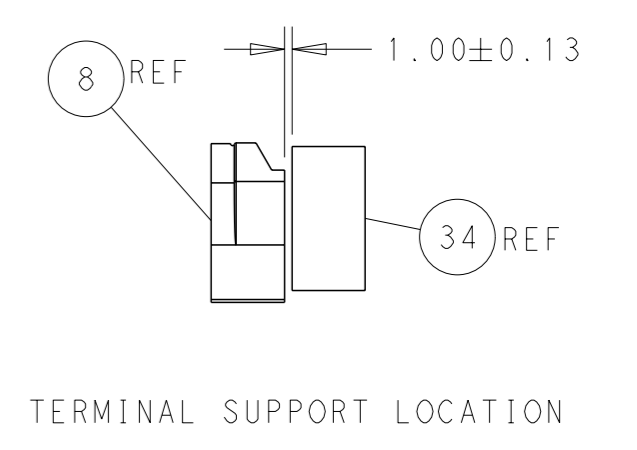
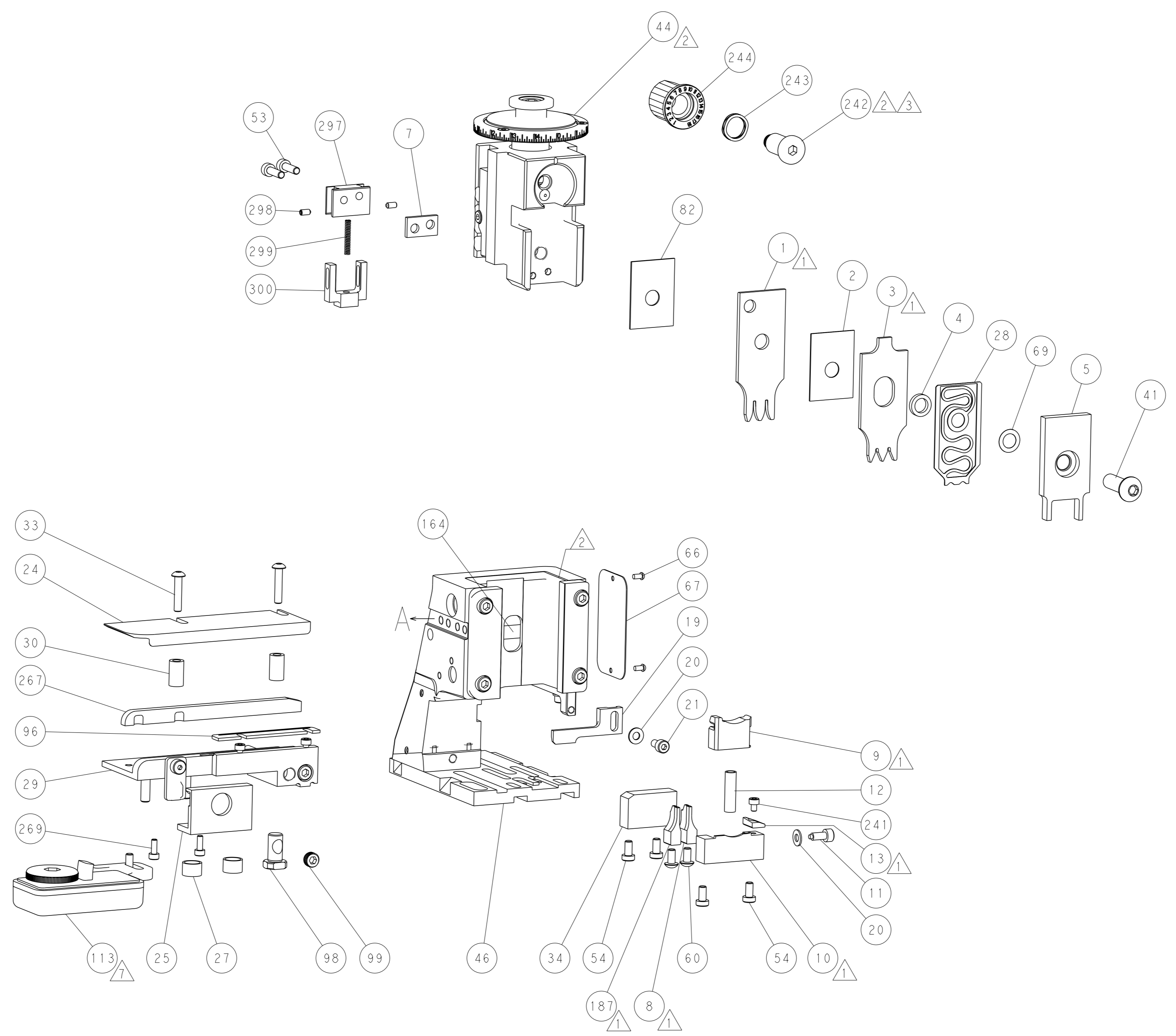
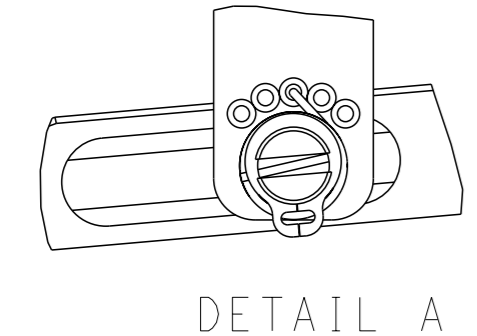
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		REV	DATE	OWN	APVD
A	66	1	SEE SHEET 1	-	-

FEED TYPE

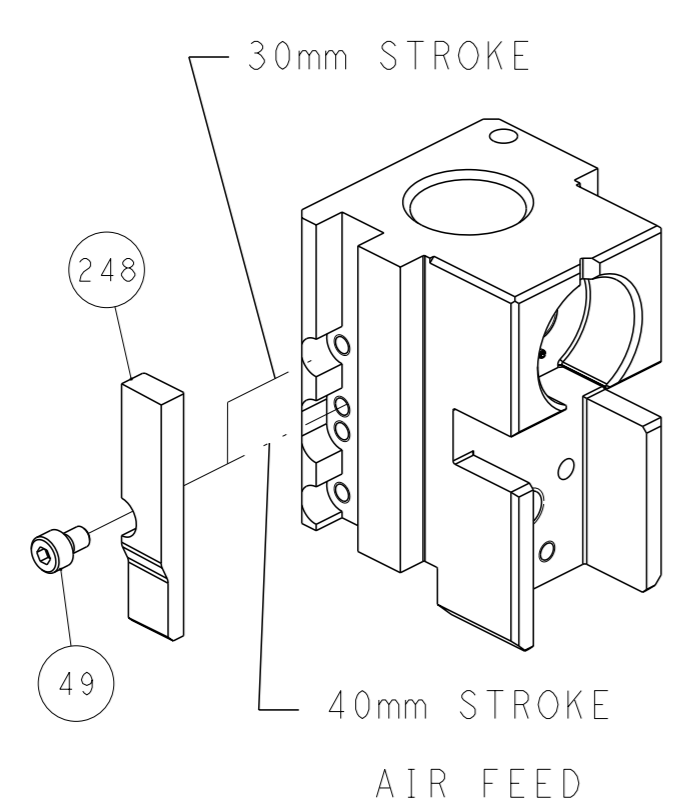
PNEUMATIC



FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



CAM POSITION

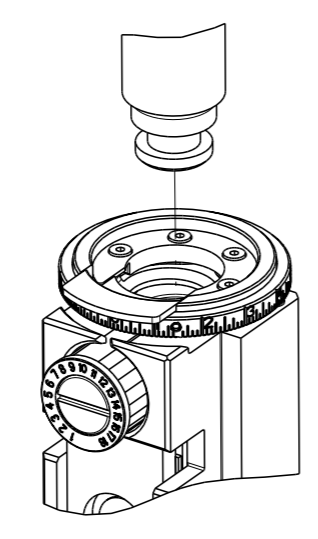


ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

<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>		OWN: M. HERR CHK: T. ELBIN APVD: B. BAIR PRODUCT SPEC: - APPLICATION SPEC: - WEIGHT: - MATERIAL: -	DATE: 21AUG2019 DATE: 21AUG2019 DATE: 21AUG2019 SCALE: 1:2 SHEET: 2 of 4 REV: B	STE TE Connectivity Harrisburg, PA 17105-3608 NAME: OCEAN 2.0 Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2837652 RESTRICTED TO: -
---	--	--	--	--

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2837652-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2837652-7	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]	O
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: MCON 1.2 TAB-CB			
WIRE STRIP LENGTH		TERMINAL INSULATION DIAMETER RANGE	
3.00-3.60 mm [.118-.142 IN]		Ø1.10-1.75 mm [.043-.069 IN]	
TERMINAL APPLICATION SPECIFICATION	114-18464		AT9106
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
1718348-1	1718348-2	1718348-3	7-1718348-1
7-1718348-2	7-1718348-3		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: MCON 1.2 CB			
WIRE STRIP LENGTH		TERMINAL INSULATION DIAMETER RANGE	
3.00-3.60 mm [.118-.142 IN]		Ø1.10-1.75 mm [.043-.069 IN]	
TERMINAL APPLICATION SPECIFICATION	114-18464		AT9106
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
1534594-1	1534594-2	1534594-3	

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.35mm2	0.84 +/- 0.03 [.033 +/- .001]	4.6
22 AWG	0.83 +/- 0.03 [.033 +/- .001]	4.8
24 AWG	0.75 +/- 0.03 [.030 +/- .001]	5.8

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
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0.35mm2	0.81 +/- 0.03 [.032 +/- .001]	5.1
24 AWG	0.80 +/- 0.03 [.031 +/- .001]	5.2

- 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.
- 5. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT 101-35000.
- TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- 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)

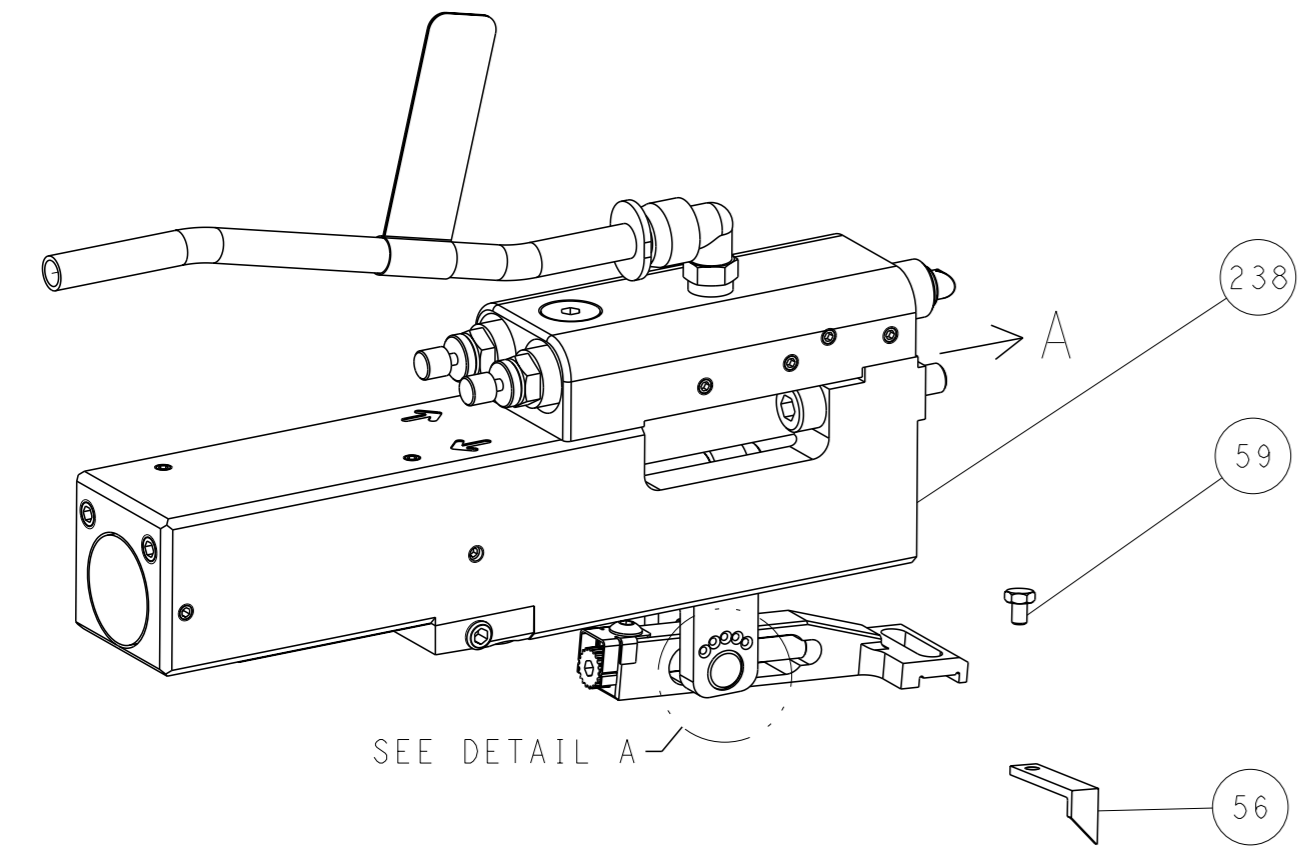
LOC	DIST	REV	DATE	BY	APPV
A	66				

REVISIONS					
REV	DATE	BY	DESCRIPTION	DATE	APPV
-	1		SEE SHEET 1	-	-
-	1		2-1803945-0 TONKER		300
-	1		4-22278-3 SPRING, COMPRESSION		299
-	2		4-18032-3 SCR, SET, FLT PNT, M3 X 6.0		298
-	1		1803944-1 SPACER, TONKER		297
-	2		2168083-1 SCR, SKT HD CAP, RoHS, M3 X 8.0		269
-	1		1633782-8 FENCE		267
-	1		2119082-4 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		2844940-1 AIR FEED MODULE		238
1	1		8-1633918-6 ANVIL, COMBINATION		187
-	REF		994970-2 COUNTER, MAGNETIC		164
-	1		2119641-2 FEED CAM, AIR FEED		151
-	2		2079383-8 SCR, BHSC, RoHS (M4 X 16)		144
-	4		2168400-5 SHCS, LOW HEAD, RoHS, M4 X 20		143
-	1		3-1803583-2 APPLICATOR BASIC ASSEMBLY, SF		141
-	1		1803516-1 RAM ASSEMBLY, SF PACIFIC		140
-	1		2119955-1 ASSY, LUBRICATOR, SIDE FEED		113
-	1		2844908-1 SCREW, LOCKING		99
-	1		2844907-1 POST, LOCKING		98
-	1		1-690438-0 FRONT STRIP GUIDE		96
-	1		455888-7 SPACER, CRIMPER		82
-	1		1803607-3 DOCUMENTATION PACKAGE		71
-	1		2119943-1 WASHER, SPACER		69
-	1		2119740-1 TAG, IDENTIFICATION		67
-	2		2168078-1 SCREW, DRIVE, RH, RoHS, 2 x .188		66
-	1		5-18022-5 SCR, HEX HD CAP, M4 X 6.0		59
-	1		1338683-6 FEED PAWL		56
-	2		2-2168083-5 SCR, SKT HD CAP, RoHS, M4 X 14		53
-	1		18023-9 SCR, SKT HD CAP M4 X 6.0		49
-	1		1803602-1 SCR, BHSC, RoHS (M8 X 25)		41
-	1		5-1752356-5 SUPPORT, TERMINAL		34
-	2		2079383-5 SCR, BHSC, RoHS (M4 X 20)		33
-	2		2-2844962-5 SPACER, CYLINDRICAL, STRIP GUIDE		30
-	1		2844992-5 ASSEMBLY, STRIP GUIDE		29
-	1		1803159-4 DEPRESSOR, DUAL WIRE		28
-	2		22283-1 SPRING, COMPRESSION		27
-	1		240792-1 DRAG, TERMINAL		25
-	1		1320928-6 STRIP GUIDE		24
-	1		2168083-2 SCR, SKT HD CAP, RoHS, M4 X 8.0		21
-	2		1-18028-2 WASHER, FLAT, REG M4		20
-	1		2119533-7 STRIPPER, SIDE FEED		19
-	1		2119806-1 INSERT, SHEAR		13
-	1		3-22280-3 SPRING, COMPRESSION		12
-	1		1-356885-4 STOP, SHEAR		11
-	1		2119805-7 SHEAR HOLDER, FRONT		10
-	1		318059-9 FLOATING SHEAR, FRONT		9
1	1		8-1633918-5 ANVIL, COMBINATION		8
-	1		240641-9 SPACER		7
-	-		-		6
-	1		2-1803080-1 DEPRESSOR, SHEAR		5
-	1		238011-4 BLOCK, CRIMPER SPACER		4
1	1		1803354-7 CRIMPER, DUAL INSULATION O		3
-	1		455888-5 SPACER, CRIMPER		2
1	1		5-458209-1 CRIMPER, WIRE F		1
-	-		-		-
-	77	-22	PART NO	DESCRIPTION	ITEM NO

DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH ±		OWN M. HERR 21AUG2019 CHK T. ELBIN 21AUG2019 APVD B. BAIR 21AUG2019 PRODUCT SPEC APPLICATION SPEC		NAME TE TE Connectivity Harrisburg, PA 17105-3608	
MATERIAL:		WEIGHT:		SIZE: A1 CASE CODE: 00779 DRAWING NO: C=2837652		RESTRICTED TO:	
Customer Accessible Production Drawing				SCALE: 1:2		SHEET 3 OF 4 REV B	

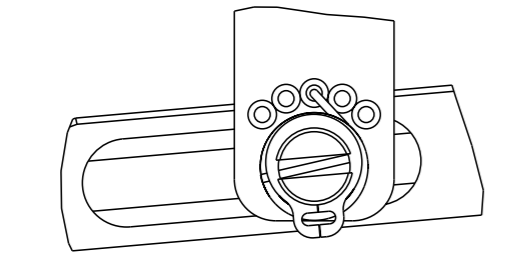
LOC	DIST	REVISIONS			
A	66	REV	DATE	OWN	APVD
		-	SEE SHEET 1	-	-

FEED TYPE PNEUMATIC



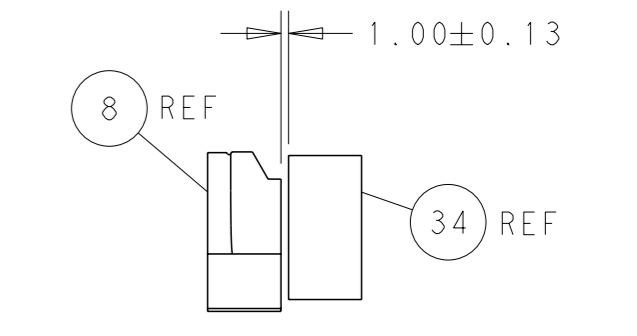
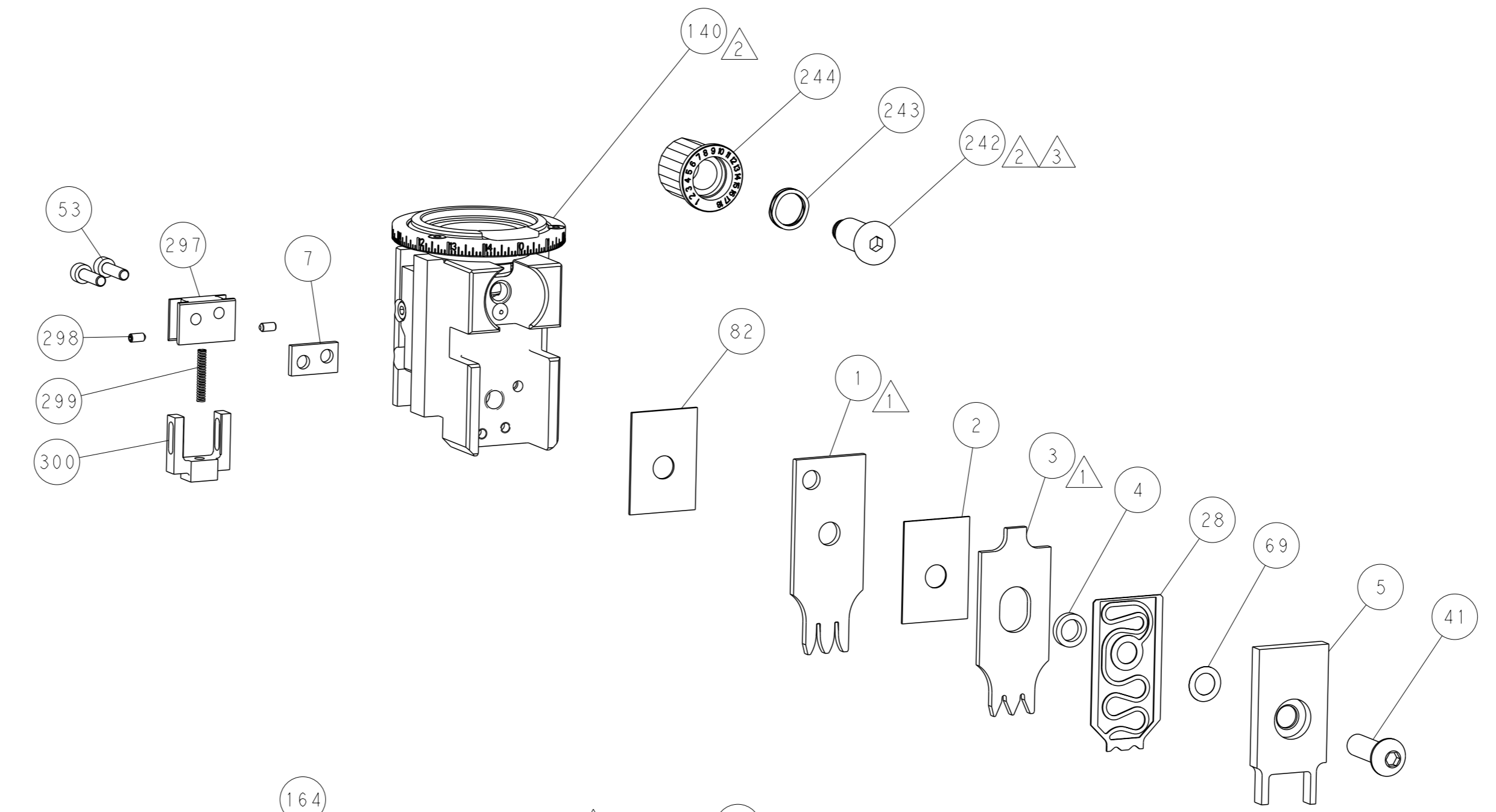
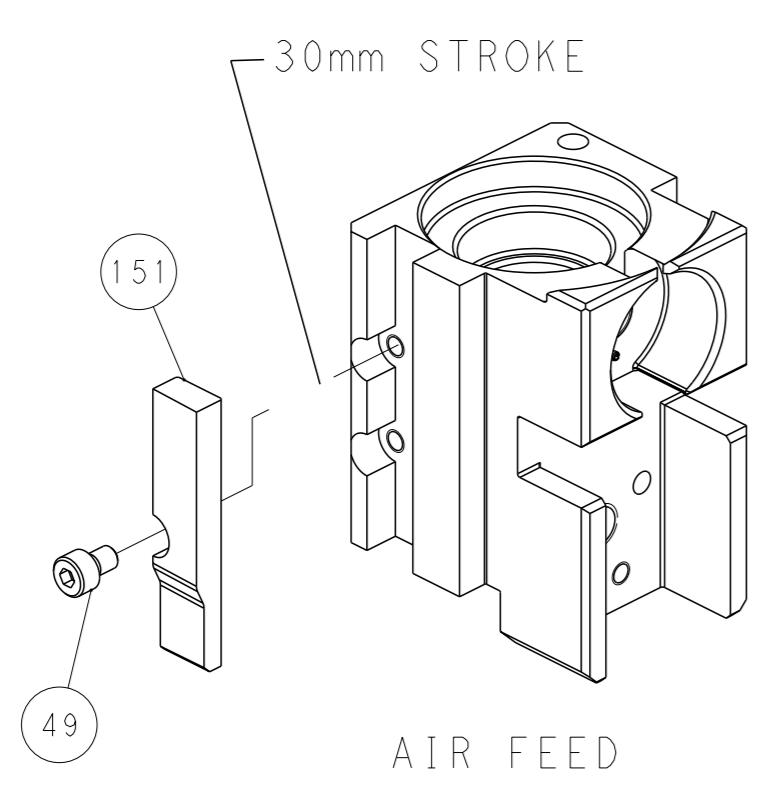
SEE DETAIL A

FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)

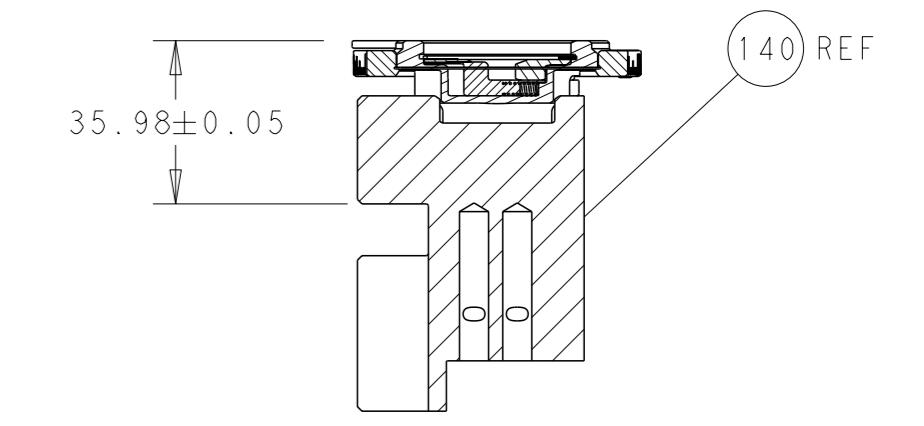
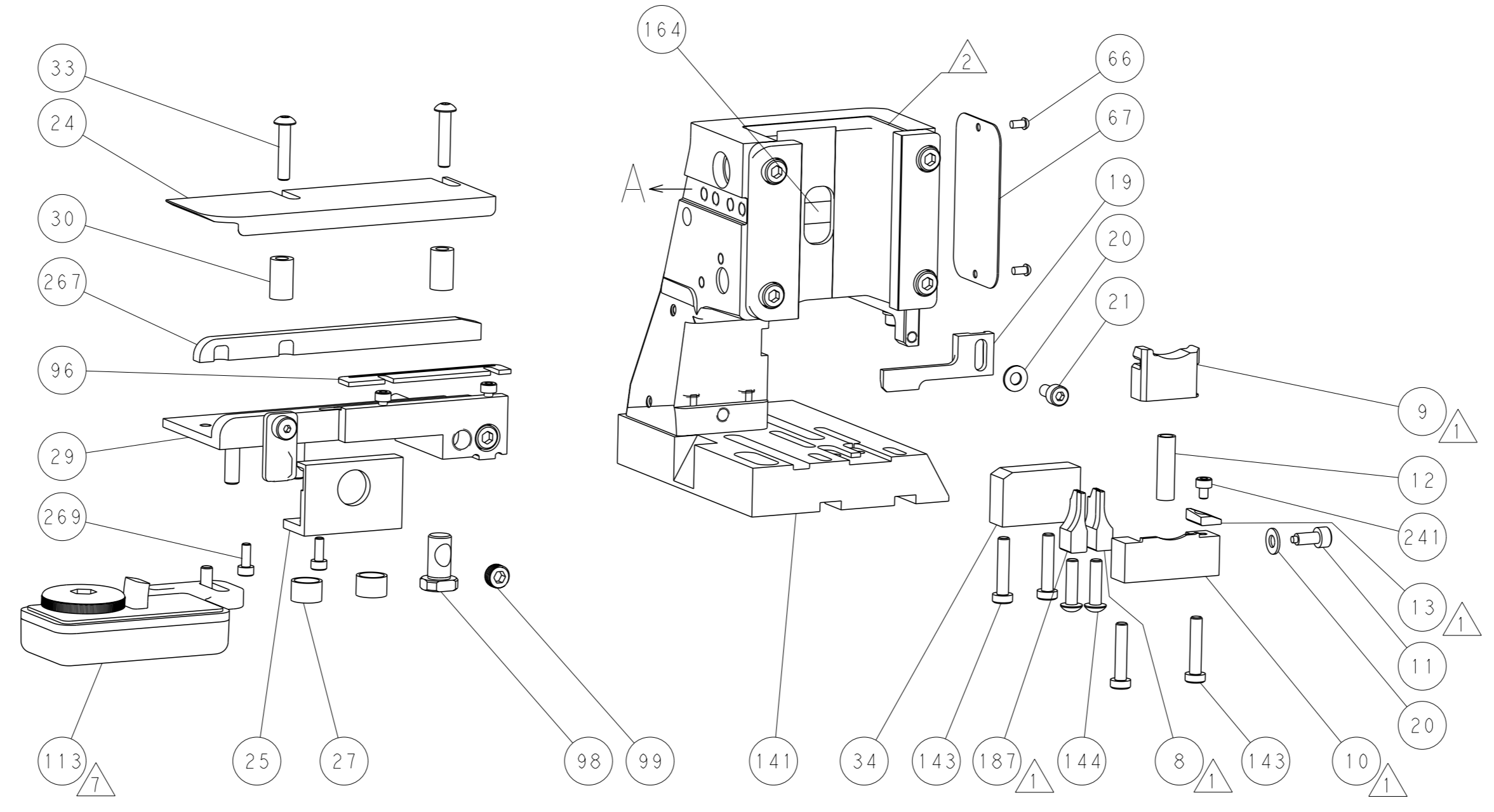


DETAIL A

CAM POSITION

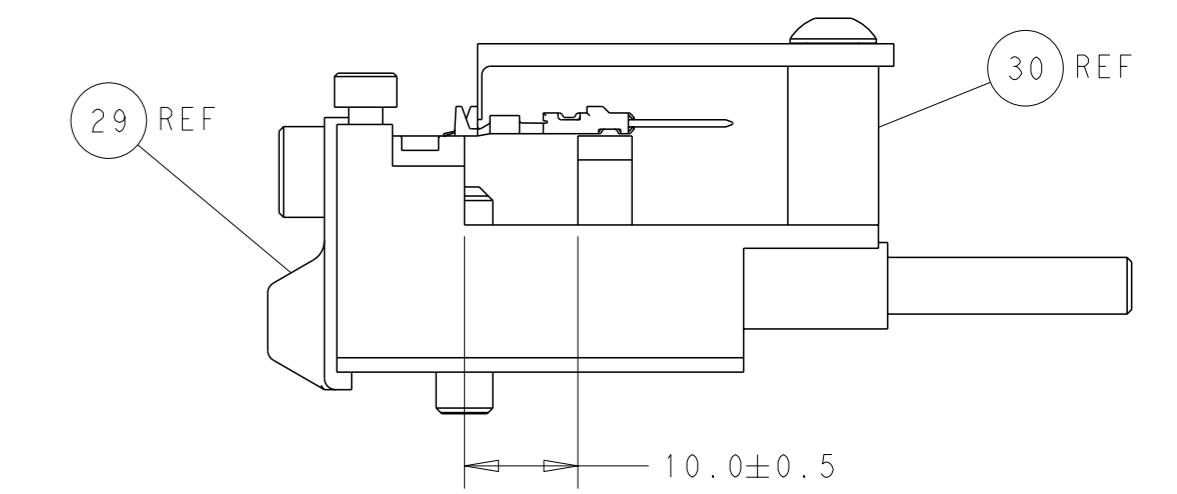


TERMINAL SUPPORT LOCATION



RAM SET-UP

ITEM 30 LOCATED AT REAR HOLES



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'S RESPONSIBILITY TO VERIFY THE LATEST REVISION SHOULD BE CONTACTED FOR THE LATEST REVISION.</small>		OWN: M. HERR CHK: T. ELBIN APVD: B. BAIR PRODUCT SPEC: OCEAN 2.0 Side Feed Applicator
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH ±	DATE: 21AUG2019 NAME: OCEAN 2.0 Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2837652 SCALE: 1:2	DATE: 21AUG2019 NAME: OCEAN 2.0 Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2837652 SCALE: 1:2 SHEET 4 OF 4 REV B
MATERIAL: - WEIGHT: -		RESTRICTED TO: - Customer Accessible Production Drawing