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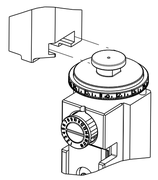
LOC	DIST
A	66

REVISIONS

P	LTR	DESCRIPTION	DATE	DWN	APVD
	A	RELEASED	23FEB2021	MEH	MP
	A1	ECR-22-141477	06JUN2022	JWC	GB
	B	ECR-23-179374	25JUN2023	FZ	JAH
	C	ECR-23-191822	07NOV2023	FZ	JAH

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2837770-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2837770-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2837770-1	C	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2837770-2	C	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2837770-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.03 mm [.080]	F
INSUL	2.29 mm [.090]	O
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: TE TERMINAL			TE CRIMP SPECIFICATION
TERMINAL NAME: SPT CONTACT			
WIRE STRIP LENGTH 2.90-3.50 mm [.114-.138 IN]		TERMINAL INSULATION DIAMETER RANGE ∅1.10-1.60 mm [.043-.063 IN]	
TERMINAL APPLICATION SPECIFICATION	114-18037	-	-
	-	-	AT9106

TERMINALS APPLIED 6

TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
1862029-1	1862029-2	1862029-5	

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING 4
0.50mm2	1.14+/-0.03 [.045+/-.001]	3.1
0.35mm2	1.09+/-0.03 [.043+/-.001]	3.6

1 RECOMMENDED SPARE PARTS

2 REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.

3 APPLY PART NUMBER 2-2341 9-6 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.

					PART NO	DESCRIPTION	ITEM NO
	-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248
	-	1	1	1	1	2119082-8	CAM, SNAIL, INSULATION ADJUSTMENT	244
	-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
3	-	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
	-	1	1	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
	-	-	1	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
	-	1	-	1	-	2844940-1	AIR FEED MODULE	238
	-	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
6	-	1	1	1	1	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113
	-	1	1	1	1	2844908-1	SCREW, LOCKING	99
	-	1	1	1	1	2844907-1	POST, LOCKING	98
	-	1	1	1	1	455888-7	SPACER, CRIMPER -	82
	-	1	1	1	1	1803607-3	DOCUMENTATION PACKAGE	71
	-	1	1	1	1	2119791-9	DEPRESSOR, WIRE	70
	-	1	1	1	1	2119740-1	TAG,IDENTIFICATION	67
	-	2	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
	-	1	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	60
	-	1	1	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
	-	1	1	1	1	1338685-1	PAWL, FEED	56
	-	4	4	4	4	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	54
	-	2	2	2	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	53
	-	1	1	1	1	1803382-2	HOLD DOWN, SPRING LOADED	50
	-	1	2	1	2	18023-9	SCR, SKT HD CAP M4 X 6.0	49
	-	-	1	-	1	2119652-1	FEED CAM, PRE FEED	48
	-	-	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	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
	-	1	1	1	1	1-1752356-5	SUPPORT, TERMINAL	34
	-	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
	-	2	2	2	2	2-2844962-6	SPACER, CYLINDRICAL, STRIP GUIDE	30
	-	1	1	1	1	2844992-1	ASSEMBLY, STRIP GUIDE -	29
	-	1	1	1	1	1-455888-0	SPACER, CRIMPER -	28
	-	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	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	2119806-1	INSERT, SHEAR	13
	-	1	1	1	1	3-22280-3	SPRING, COMPRESSION	12
	-	1	1	1	1	1-356885-4	STOP, SHEAR	11
1	-	1	1	1	1	2119805-1	SHEAR HOLDER, FRONT -	10
1	-	1	1	1	1	1803095-6	FLOATING SHEAR, FRONT -	9
1	1	2	2	1	1	2-1803763-8	COMBINATION, ANVIL -	8
	-	-	-	-	-	-	-	7
	-	-	-	-	-	-	-	6
	-	1	1	1	1	2119757-3	DEPRESSOR, SHEAR	5
	-	1	1	1	1	2-238011-1	BLOCK, CRIMPER SPACER	4
1	1	2	2	1	1	4-1633965-6	CRIMPER, INSULATION O PREMIUM	3
	-	1	1	1	1	455888-3	SPACER, CRIMPER -	2
1	1	2	2	1	1	1-456405-2	CRIMPER, WIRE PREMIUM	1
		-77	-72	-71	-2	-1		

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DIMENSIONS: mm

TOLERANCES UNLESS OTHERWISE SPECIFIED:
0 PLC ±-
1 PLC ±-
2 PLC ±-
3 PLC ±-
4 PLC ±-
ANGLES ±-

MATERIAL - -
FINISH - -

DWN M. HERR 25FEB2020
CHK T. ELBIN 25FEB2020
APVD B. BAIR 25FEB2020
PRODUCT SPEC -
APPLICATION SPEC -
WEIGHT -

TE Connectivity
Harrisburg, PA 17105-3608

NAME OCEAN 2.0 Side Feed Applicator -

SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
A1	00779	C-2837770	-

Customer Accessible Production Drawing | SCALE 1:2 | SHEET 1 OF 4 | REV C

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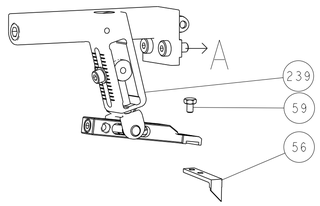
A	66

REVISIONS

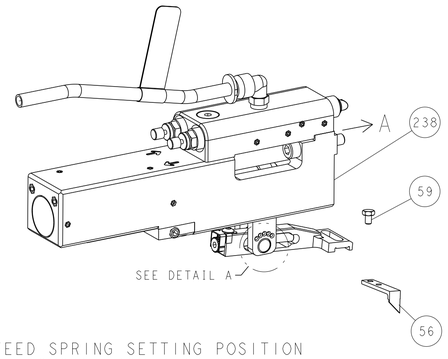
P	LTR	DESCRIPTION	DATE	DWN	APVD
	-	SEE SHEET 1	-	-	-

FEED TYPE

MECHANICAL

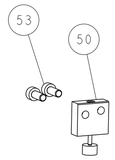


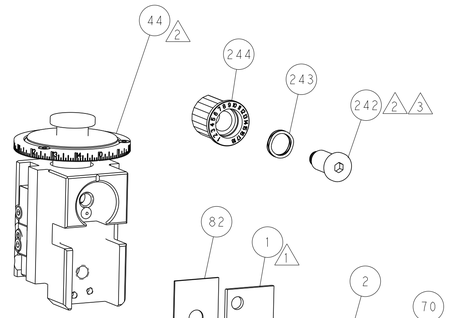
PNEUMATIC

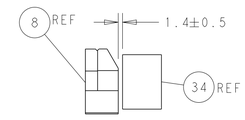


FEED SPRING SETTING POSITION
(SHOWN FROM REAR SIDE)

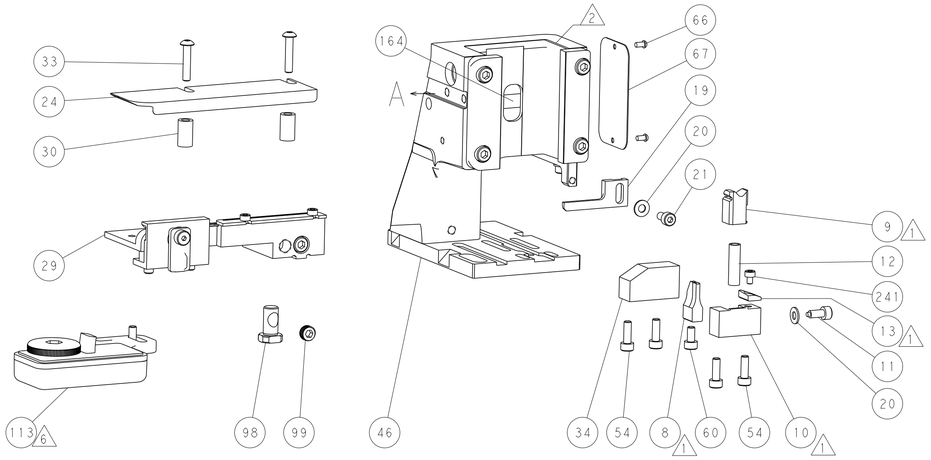
DETAIL A





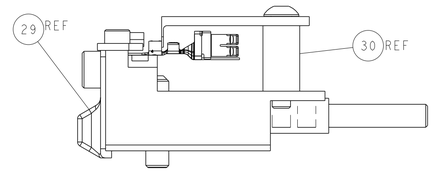


TERMINAL SUPPORT LOCATION



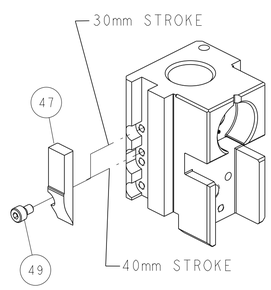
RAM SET-UP

ITEM 30 LOCATED AT
FRONT HOLES

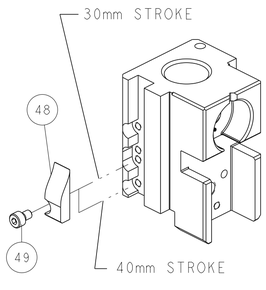


FEED TRACK POSITION
GUIDE BY INSULATION BARREL

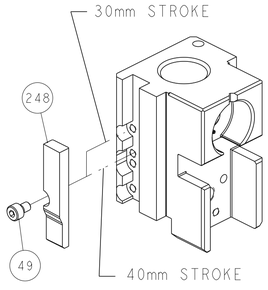
CAM POSITIONS



MECHANICAL
POST FEED



MECHANICAL
PRE FEED



AIR FEED

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ANGLES ±

MATERIAL -
FINISH -

DWN M. HERR	25FEB2020
CHK T. ELBIN	25FEB2020
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PRODUCT SPEC -	
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WEIGHT -	

TE Connectivity
Harrisburg, PA 17105-3608

NAME
OCEAN 2.0 Side Feed
Applicator
-

SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
A1	00779	C-2837770	-

Customer Accessible Production Drawing | SCALE 1:2 | SHEET 2 OF 4 | REV C