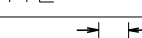


8		7	
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20		20	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2837931-1	A	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2837931-2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2837931-1	A	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2837931-2	A	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2837931-7	A	CRIMP TOOLING KIT	-

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	0.83 mm [.033]	F
INSUL	1.07 mm [.042]	O
APPLICATOR INSTRUCTIONS 408-35042		

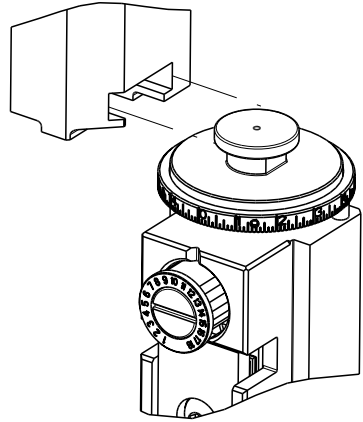
TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: TERMINAL			
WIRE STRIP LENGTH			TERMINAL INSULATION DIAMETER RANGE
3.00-3.50 mm [.118-.138 IN]			Ø0.75-0.85 mm [.030-.033 IN]
TERMINAL APPLICATION SPECIFICATION		114-5379-9	
		-	AT9106
TERMINALS APPLIED  			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
1827855-7			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
28 AWG or 0.089 mm2	0.49+/-0.03 [.019+/- .001]	8.8



- 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 TERMINAL LUBRICANT IS RECOMMENDED.
6. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT 101-35000.
- 7 APPLY FOR CABLE WITH TWO SHORT LENGTH WIRES.

ATLANTIC VERSION TERMINATOR
INTERFACE ADAPTER



*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)

2		1					
LOC	DIST	REVISIONS					
A	66	P	LTR	DESCRIPTION	DATE	DWN	APVD
			1	DEVELOPMENT	18FEB2021	FJ	YY
			A	RELEASED	15JUL2021	FJ	TE
			A1	ECR-22-160908	12DEC2022	FZ	JAH

-	1	1	1	1	4-992946-8	PIN, DOWEL 2 X 6	297
-	1	1	1	1	3-18031-6	SCR, SET, CUP POINT M2.5 X 3.0	296
-	1	1	1	1	2386670-1	ADJUST PLATE	294
-	1	1	1	1	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	293
-	1	1	1	1	18031-1	SCR, SET, CUP POINT M3 X 5.0	292
-	1	1	1	1	2386669-1	STOP PIN	291
-	1	1	1	1	2370284-1	WIRE STOP	289
-	1	1	1	1	2370283-1	GUIDE BLOCK	288
-	1	1	1	1	2370282-1	STOP WIRE BRACKET	287
-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248
-	1	1	1	1	2119082-5	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	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
-	1	1	1	1	4-18032-3	SCR, SET, FLT PNT, M3 X 6.0	185
-	1	1	1	1	455053-2	PLATE, RETAINING	180
-	1	1	1	1	4-21028-0	PIN, SLOTTED SPRING .094 X .750	178
-	2	2	2	2	22278-9	SPRING, COMPRESSION	176
-	1	1	1	1	1803129-1	PLATE, RETAINER	175
-	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	1	1	1	1	1-18028-2	WASHER, FLAT, REG M4	119
-	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
-	2	2	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	95
-	1	1	1	1	455888-8	SPACER, CRIMPER	82
-	1	1	1	1	1803607-3	DOCUMENTATION PACKAGE	71
-	1	1	1	1	2119791-5	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
-	6	6	6	6	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	54
-	2	2	2	2	1-2168083-2	SCR, SKT HD CAP, RoHS, M4 X 25	53
-	1	1	1	1	1803342-9	HOLDER, TERMINAL	51
-	1	1	1	1	455052-3	CARRIER, HOLD DOWN	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	1752356-3	SUPPORT, TERMINAL	34
-	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	2	2	2-2844962-3	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29
-	1	1	1	1	1320928-2	STRIP GUIDE	24
-	1	1	1	1	1-18028-2	WASHER, FLAT, REG M4	20
-	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	2119805-1	SHEAR HOLDER, FRONT	10
-	1	1	1	1	2370280-1	FLOATING, SHEAR, FRONT	9
-	1	2	2	1	2-1803334-0	ANVIL, COMBINATION	8
-	1	1	1	1	2-240641-1	SPACER	7
-	1	1	1	1	2370279-1	GUIDE, SEPARATOR	6
-	1	1	1	1	1-2119757-8	DEPRESSOR, SHEAR	5
-	1	1	1	1	6-238011-5	BLOCK, CRIMPER SPACER	4
-	1	2	2	1	2370278-1	CRIMPER, INSULATION O	3
-	-	-	-	-	-	-	2
-	1	2	2	1	8-1633713-8	CRIMPER, WIRE PREMIUM	1
-	77-72-71	-2	-1		PART NO	DESCRIPTION	ITEM NO

THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE AND TO BE OBSOLETE WITHOUT NOTICE. FOR THE LATEST REVISION, CONTACT THE ENGINEERING ORGANIZATION.				DWN	J. FENG	18FEB2021	 TE Connectivity Harrisburg, PA 17105-3608					
				CHK	Y. YIN	18FEB2021						
				APVD	Y. YIN	18FEB2021						
				PRODUCT SPEC								
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		NAME								
mm		0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ±		OCEAN 2.0 Side Feed Applicator								
		ANGLES ±		APPLICATION SPEC								
MATERIAL		FINISH		WEIGHT			SIZE		CAGE CODE	DRAWING NO	RESTRICTED TO	
-		-		-			A1		00779	©=2837931	-	
Customer Accessible Production Drawing							SCALE		1:2		SHEET 1 of 4	REV A1

SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

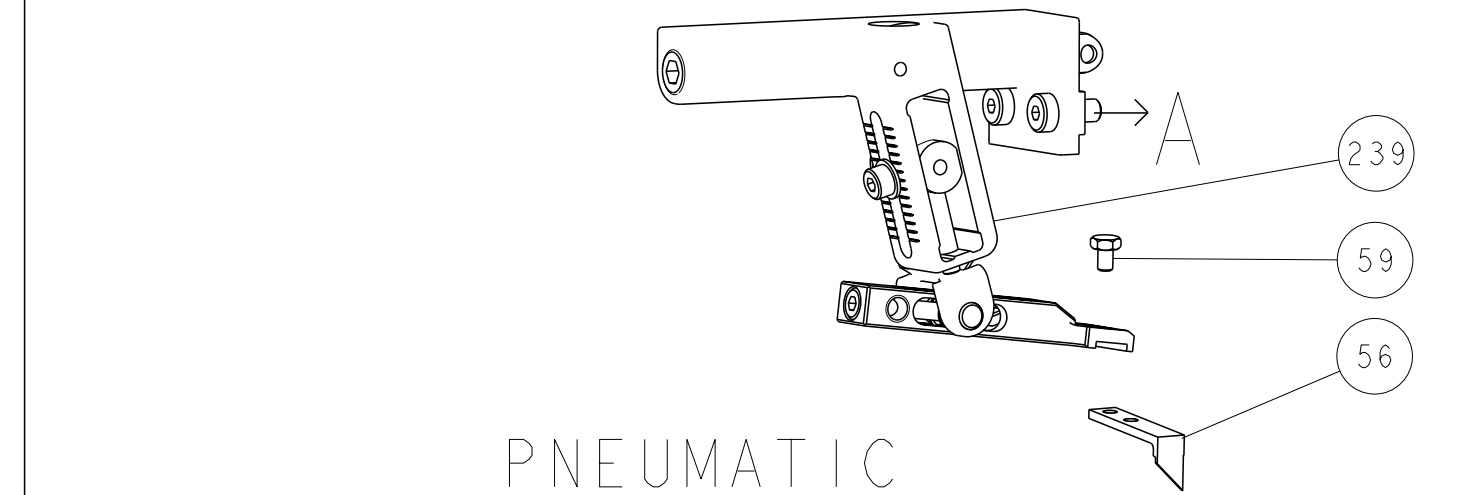
D

C

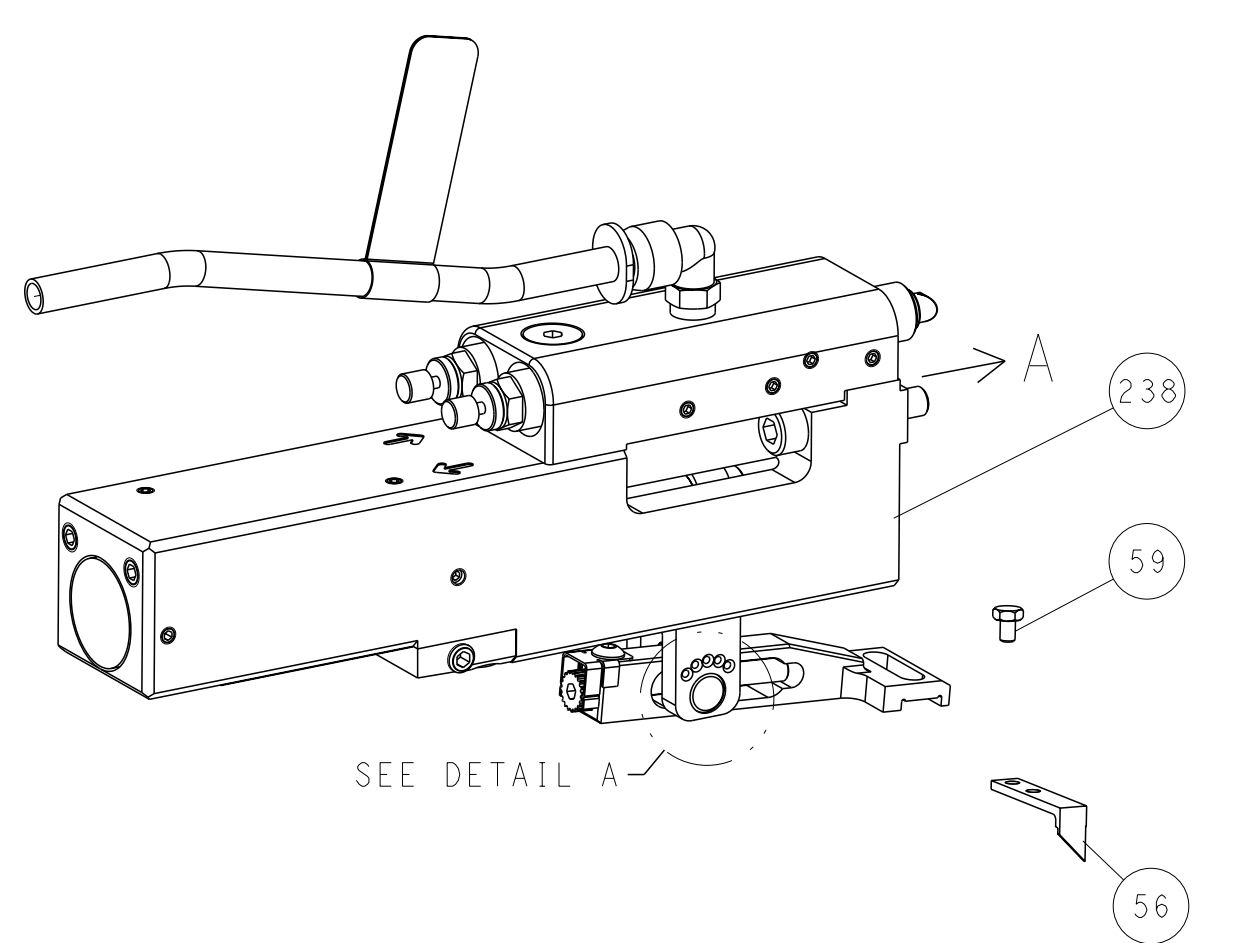
B

A

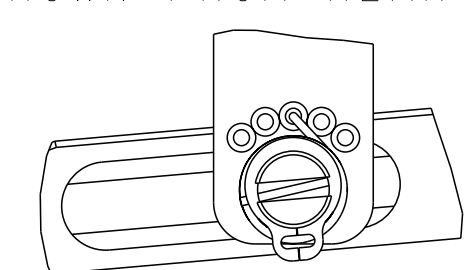
FEED TYPE MECHANICAL



PNEUMATIC

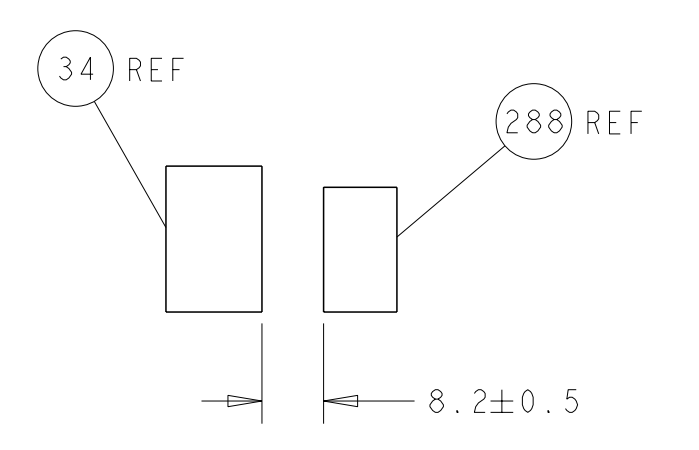
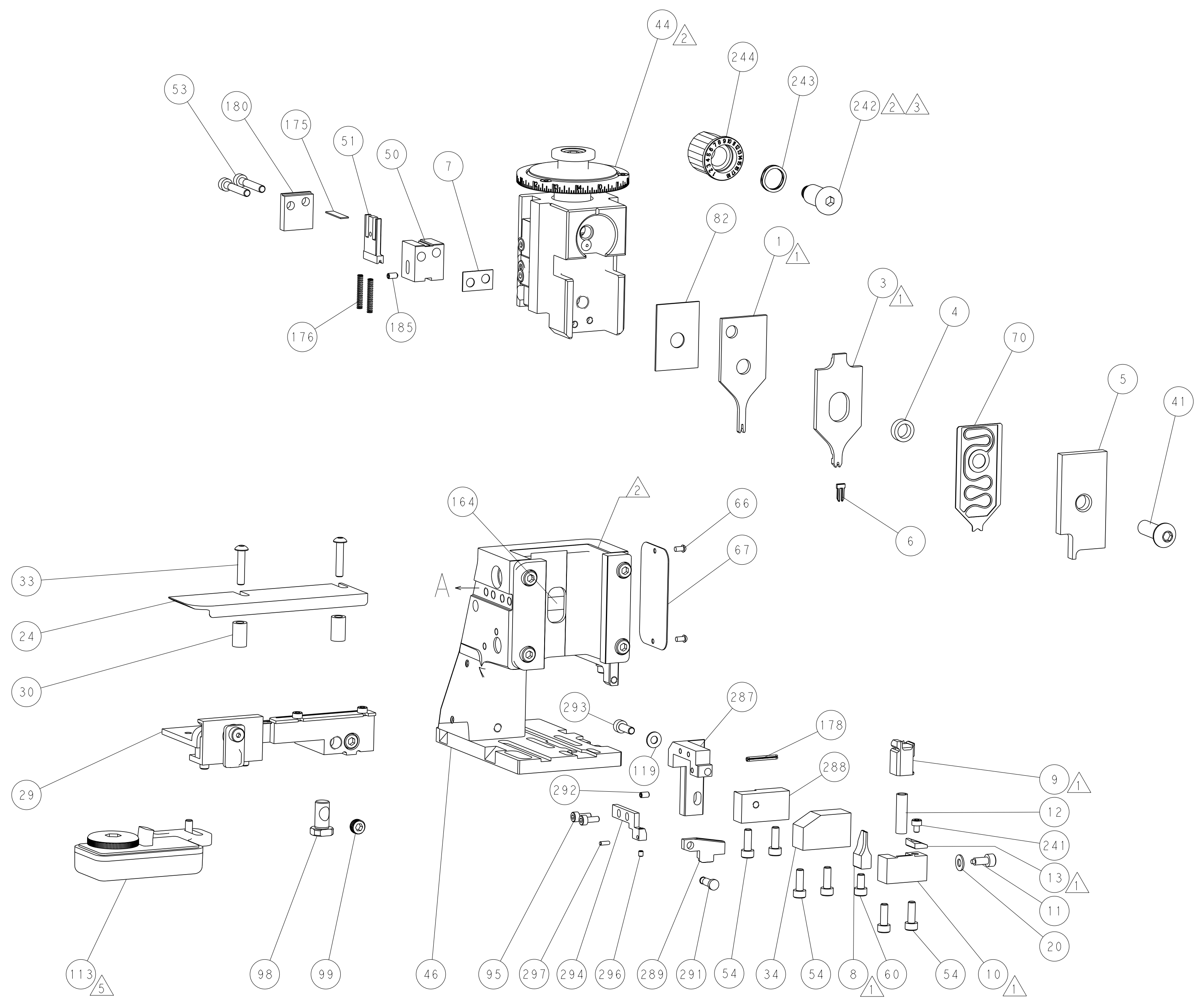
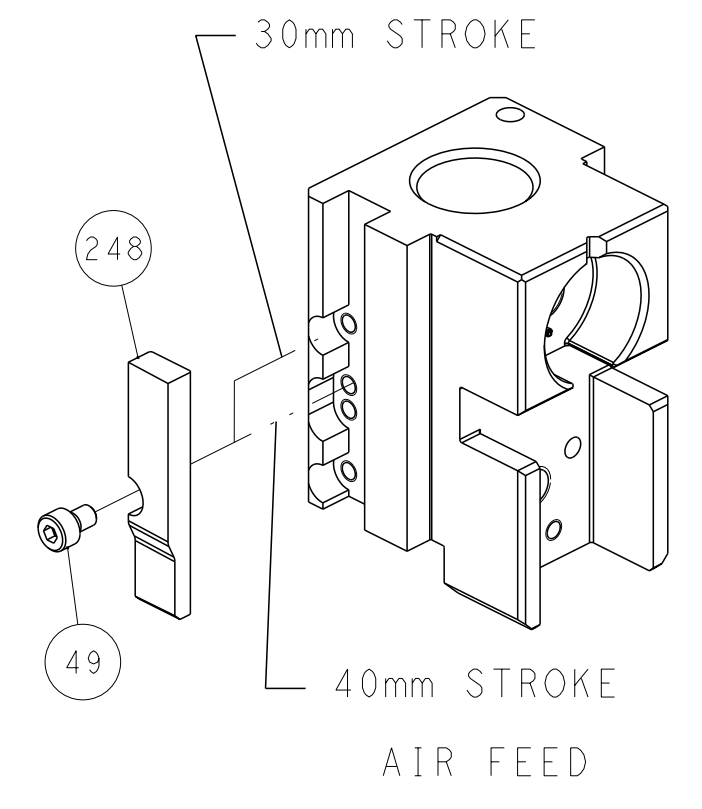
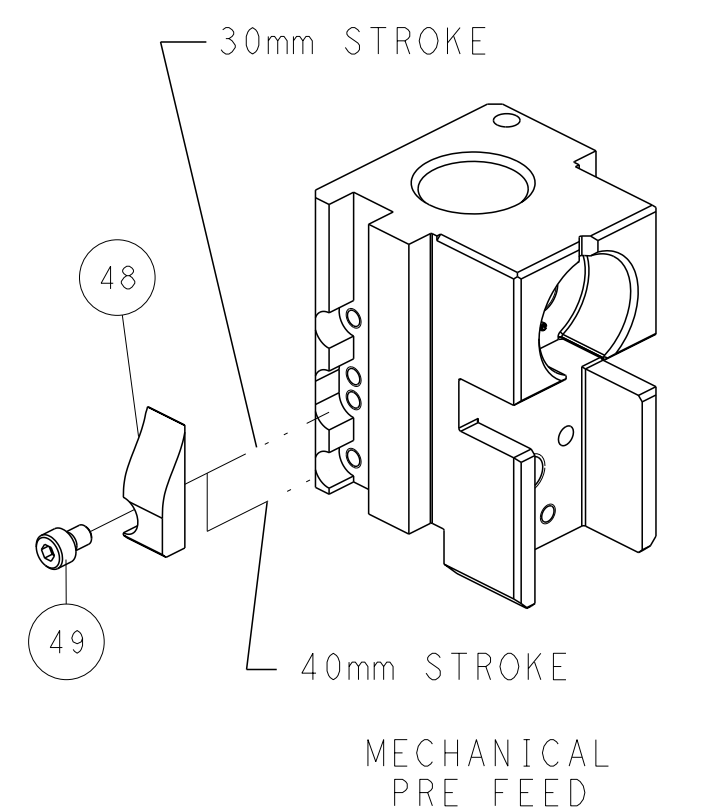
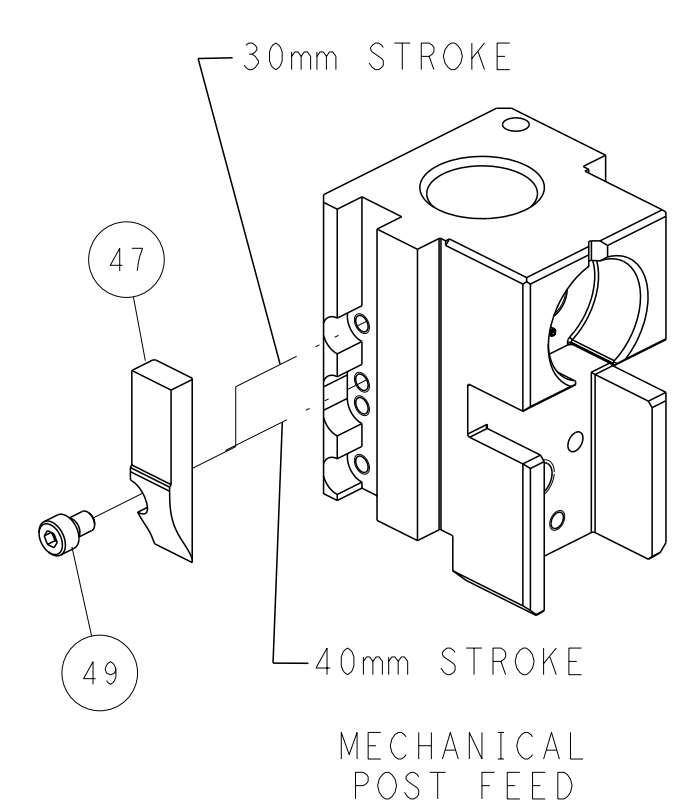


FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)

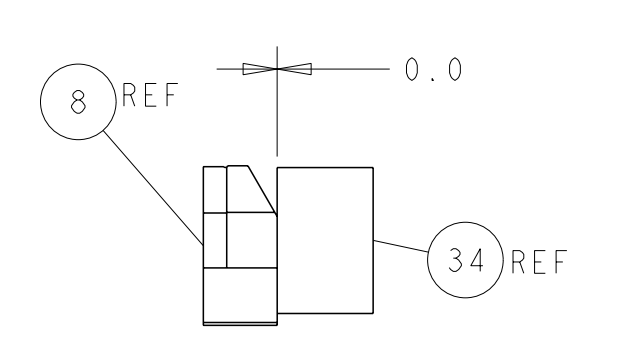


DETAIL A

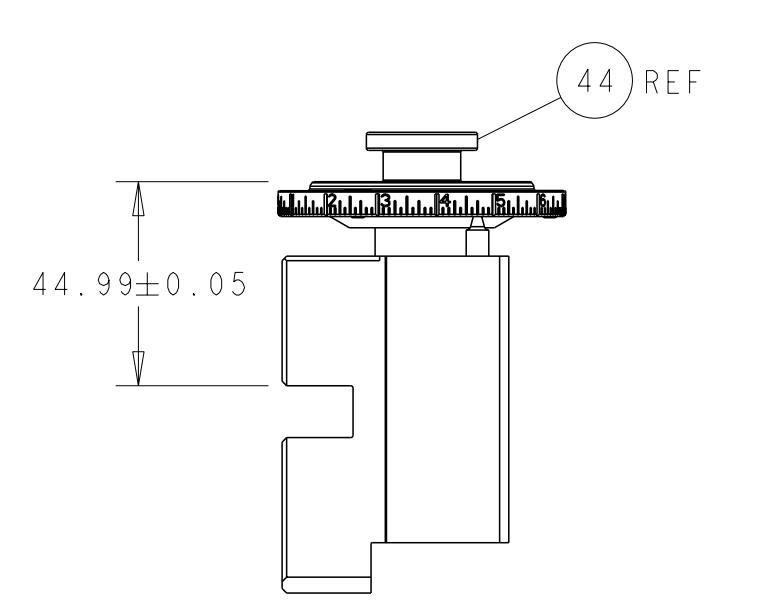
CAM POSITIONS



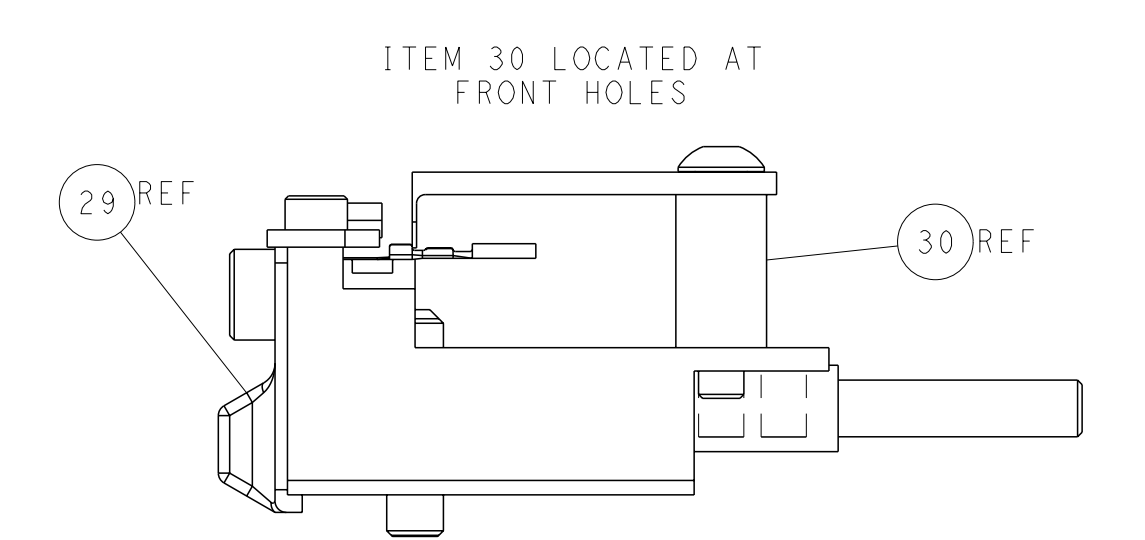
GUIDE BLOCK LOCATION



TERMINAL SUPPORT LOCATION



RAM SET-UP



FEED TRACK POSITION
GUIDE BY INSULATION BARREL

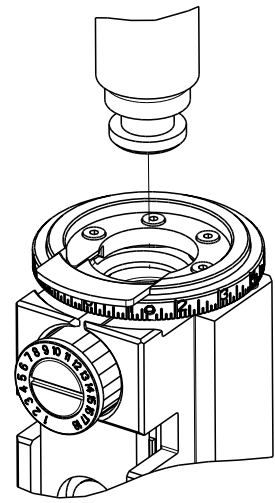
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE AND TO CONTROL AND ENGINEERING ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST REVISION.				OWN J. FENG 18FEB2021	TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm				CHK Y. YIN 18FEB2021	NAME OCEAN 2.0 Side Feed Applicator	
TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±				APVD Y. YIN 18FEB2021	SIZE A1	
FINISH				PRODUCT SPEC	CAGE CODE 00779	
MATERIAL				APPLICATION SPEC	DRAWING NO 2837931	
				WEIGHT	RESTRICTED TO	
				Customer Accessible Production Drawing	SCALE 1:2	
					SHEET 2 of 4	
					REV A1	

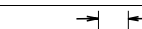
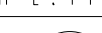
SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

8	7
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RELEASED FOR PUBLICATION	
20	
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PART NUMBER	REVISION
DESCRIPTION	FEED TYPE
2-2837931-1	A
2-2837931-2	A
7-2837931-7	A
CRIMP HEIGHT ADJUST	MECHANICAL
CRIMP HEIGHT ADJUST	PNEUMATIC
CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	0.83 mm [.033]	F
INSUL	1.07 mm [.042]	O
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: TERMINAL			
WIRE STRIP LENGTH			TERMINAL INSULATION DIAMETER RANGE
3.00-3.50 mm [.118-.138 IN]			Ø0.75-0.85 mm [.030-.033 IN]
TERMINAL APPLICATION		114-5379-9	-
		-	-
SPECIFICATION		-	AT9106
TERMINALS APPLIED 			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
1827855-7			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
28 AWG or 0.089 mm2	0.49+/-0.03 [.019+/-0.001]	8.8



- 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
- TERMINAL LUBRICANT IS RECOMMENDED.
6.
- UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT 101-35000.
- 7
- APPLY FOR CABLE WITH TWO SHORT LENGTH WIRES.

*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	REVISONS			
A	66	P	LYR	DESCRIPTION	DATE
			-	SEE SHEET 1	-

	-	1	1	4-992946-8	PIN, DOWEL 2 X 6	297
	-	1	1	3-18031-6	SCR, SET, CUP POINT M2.5 X 3.0	296
	-	1	1	2386670-1	ADJUST PLATE	294
	-	1	1	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	293
	-	1	1	18031-1	SCR, SET, CUP POINT M3 X 5.0	292
	-	1	1	2386669-1	STOP PIN	291
	-	1	1	2370284-1	WIRE STOP	289
	-	1	1	2370283-1	GUIDE BLOCK	288
	-	1	1	2370282-1	STOP WIRE BRACKET	287
	-	1	1	2119082-5	CAM, SNAIL, INSULATION ADJUSTMENT	244
3	-	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
	-	1	1	4-18032-3	SCR, SET, FLT PNT, M3 X 6.0	185
	-	1	1	455053-2	PLATE, RETAINING	180
	-	1	1	4-21028-0	PIN, SLOTTED SPRING .094 X .750	178
	-	2	2	22278-9	SPRING, COMPRESSION	176
	-	1	1	1803129-1	PLATE, RETAINER	175
	-	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
	-	6	6	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
5	-	1	1	1-18028-2	WASHER, FLAT, REG M4	119
	-	1	1	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113
	-	1	1	2844908-1	SCREW, LOCKING	99
	-	1	1	2844907-1	POST, LOCKING	98
	-	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	95
	-	1	1	455888-8	SPACER, CRIMPER	82
	-	1	1	1803607-3	DOCUMENTATION PACKAGE	71
	-	1	1	2119791-5	DEPRESSOR, WIRE	70
	-	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	1-2168083-2	SCR, SKT HD CAP, RoHS, M4 X 25	53
	-	1	1	1803342-9	HOLDER, TERMINAL	51
	-	1	1	455052-3	CARRIER, HOLD DOWN	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	1752356-3	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	1	1-18028-2	WASHER, FLAT, REG M4	20
	-	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	1	2119805-1	SHEAR HOLDER, FRONT	10
1	-	1	1	2370280-1	FLOATING, SHEAR, FRONT	9
1	1	1	1	2-1803334-0	ANVIL, COMBINATION	8
	-	1	1	2-240641-1	SPACER	7
	-	1	1	2370279-1	GUIDE, SEPARATOR	6
	-	1	1	1-2119757-8	DEPRESSOR, SHEAR	5
	-	1	1	6-238011-5	BLOCK, CRIMPER SPACER	4
1	1	1	1	2370278-1	CRIMPER, INSULATION O	3
	-	-	-	-	-	2
1	1	1	1	8-1633713-8	CRIMPER, WIRE PREMIUM	1
	-77	-22	-21	PART NO	DESCRIPTION	ITEM NO

THIS DRAWING IS A CONTROLLED DOCUMENT FOR THE ELECTRICAL CONSTRUCTION INDUSTRY. IT IS SUBJECT TO CHANGE AND TO THE EXTENT OF THE CHANGES, THE USER SHALL BE CONTACTED FOR THE LATEST REVISION.		OWN J. FENG CHK Y. YIN APVD Y. YIN	18FEB2021 18FEB2021 18FEB2021	TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		NAME OCEAN 2.0 Side Feed Applicator	
MATERIAL -		FINISH -		SIZE A1	
		WEIGHT -		CAGE CODE 00779	
				DRAWING NO 2837931	
				RESTRICTED TO -	
				Customer Accessible Production Drawing	
				SCALE 1:2	
				SHEET 3	
				OF 4	
				REV A1	

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

Diagram illustrating the front view of the machine assembly, showing the front plate, handle, and various fasteners. Callouts include 238 for the handle, 59 for a screw, and 56 for a bracket. An arrow points to 'SEE DETAIL A'.

DETAIL A

30mm STROKE

142

49

MECHANICAL POST FEED

30mm STROKE

48

49

MECHANICAL PRE FEED

30mm STROKE

151

49

AIR FEED

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

THIS DRAWING IS A CONTROLLED DOCUMENT FOR TFCO ELECTRONICS CORPORATION IT IS SUBJECT TO THE PROVISIONS OF THE TFCO ELECTRONICS CORPORATION SHOULD BE CONTACTED FOR THE LATEST REVISION		DWN 181EB2021		 TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS:		CHK 181EB2021			
TOLERANCES UNLESS OTHERWISE SPECIFIED:		APVD 181EB2021			
mm		NAME			
		OCEAN 2.0 Side Feed Applicator		SIZE	
0 PLC ±.1 1 PLC ±.1 2 PLC ±.1 3 PLC ±.1 4 PLC ±.1 ANGLES ±.1		PRODUCT SPEC		CAGE CODE	
		APPLICATION SPEC		DRAWING NO	
MATERIAL		WEIGHT		RESTRICTED TO	
FINISH		A 00779		C=2837931	
-		Customer Accessible Production Drawing		SCALE 1:2 SHEET 4 OF 4 REV A	

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION