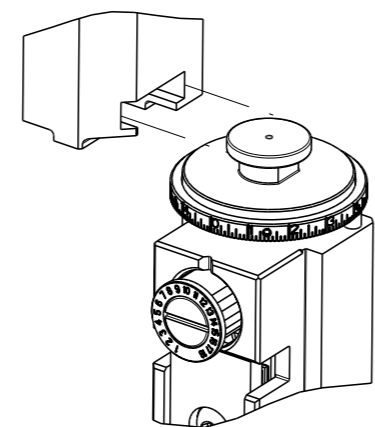


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2837941-1	A	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2837941-2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2837941-1	A	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2837941-2	A	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2837941-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER

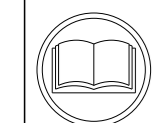


APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	3.94 mm [.155]	F
INSUL	4.83 mm [.190]	F

APPLICATOR INSTRUCTIONS 408-35042

TERMINAL DATA: HU LANE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: 312 TYPE MALE TERMINAL			
WIRE STRIP LENGTH		TERMINAL INSULATION DIAMETER RANGE	
5.24-6.00 mm [.206-.236 IN]		Ø3.70-4.00 mm [.146-.157 IN]	
TERMINAL APPLICATION SPECIFICATION	NONE		AT9106
TERMINALS APPLIED			
TE TERMINAL	HU LANE TERMINAL	TE TERMINAL	HU LANE TERMINAL
3311753-1	6605701BS2	3311753-2	6605701BS0
3311753-3	331-0256-524		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
5.00mm2	2.50+/-0.05 [.098+/-0.002]	7.0



- 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 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)

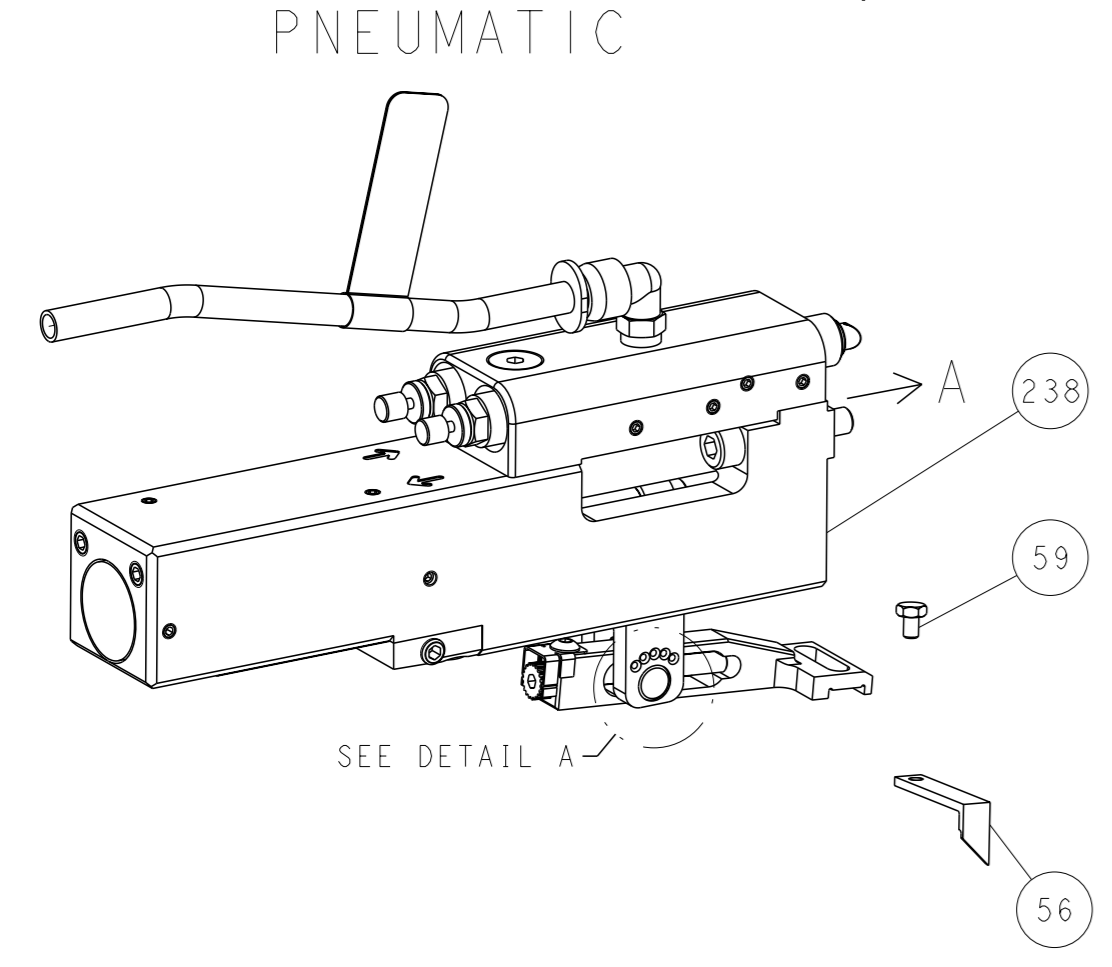
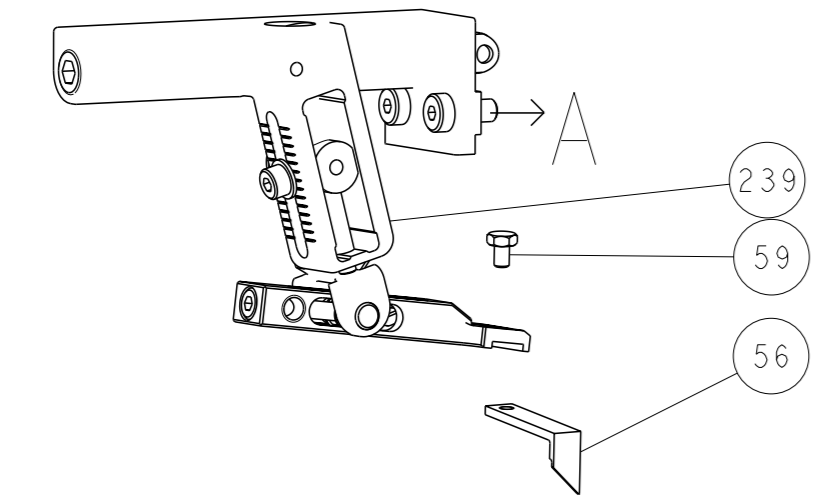
LOC	DIST	REVISIONS					
		#	LY#	DESCRIPTION	DATE	OWN	APVD
A	66	1		PRELIMINARY	27JAN2021	FZ	YY
		A		RELEASED	03MAR2021	JAH	TE

-	1	1	1	1	2119791-6	DEPRESSOR, WIRE	286	
-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248	
-	1	1	1	1	2119082-7	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	-	-	2119580-1	MECHANICAL FEED ASSEMBLY	239	
-	1	-	1	-	2844940-1	AIR FEED MODULE	238	
-	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164	
	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	455888-5	SPACER, CRIMPER	82	
-	2	2	2	2	2079383-4	SCR, BHSC, RoHS (M4 X 8)	79	
-	1	1	1	1	1803096-1	EXTENSION PLATE	78	
-	1	1	1	1	1803607-3	DOCUMENTATION PACKAGE	71	
-	1	1	1	1	2119943-1	WASHER, SPACER	69	
-	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	1338683-8	FEED PAWL	56	
-	4	4	4	4	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	54	
-	2	2	2	2	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	53	
-	1	1	1	1	1803382-1	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	3-1752356-3	SUPPORT, TERMINAL	34	
-	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33	
-	2	2	2	2	1-2844962-7	SPACER, CYLINDRICAL, STRIP GUIDE	30	
-	1	1	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29	
-	1	1	1	1	455888-3	SPACER, CRIMPER	28	
-	1	1	1	1	1320928-4	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	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	1803095-6	FLOATING SHEAR, FRONT	9	
	1	2	2	1	1	9-1803512-6	ANVIL, COMBINATION	8
-	1	1	1	1	2-240641-2	SPACER	7	
-	-	-	-	-	-	-	6	
-	1	1	1	1	1-2119757-4	DEPRESSOR, SHEAR	5	
-	1	1	1	1	7-238011-5	BLOCK, CRIMPER SPACER	4	
	1	2	2	1	1	4-1803187-0	CRIMPER, INSULATION F	3
-	1	1	1	1	455888-3	SPACER, CRIMPER	2	
	1	2	2	1	1	1-456415-0	CRIMPER, WIRE .155 F PREMIUM	1
-	77	-72	-71	-2	-1	PART NO	ITEM NO	

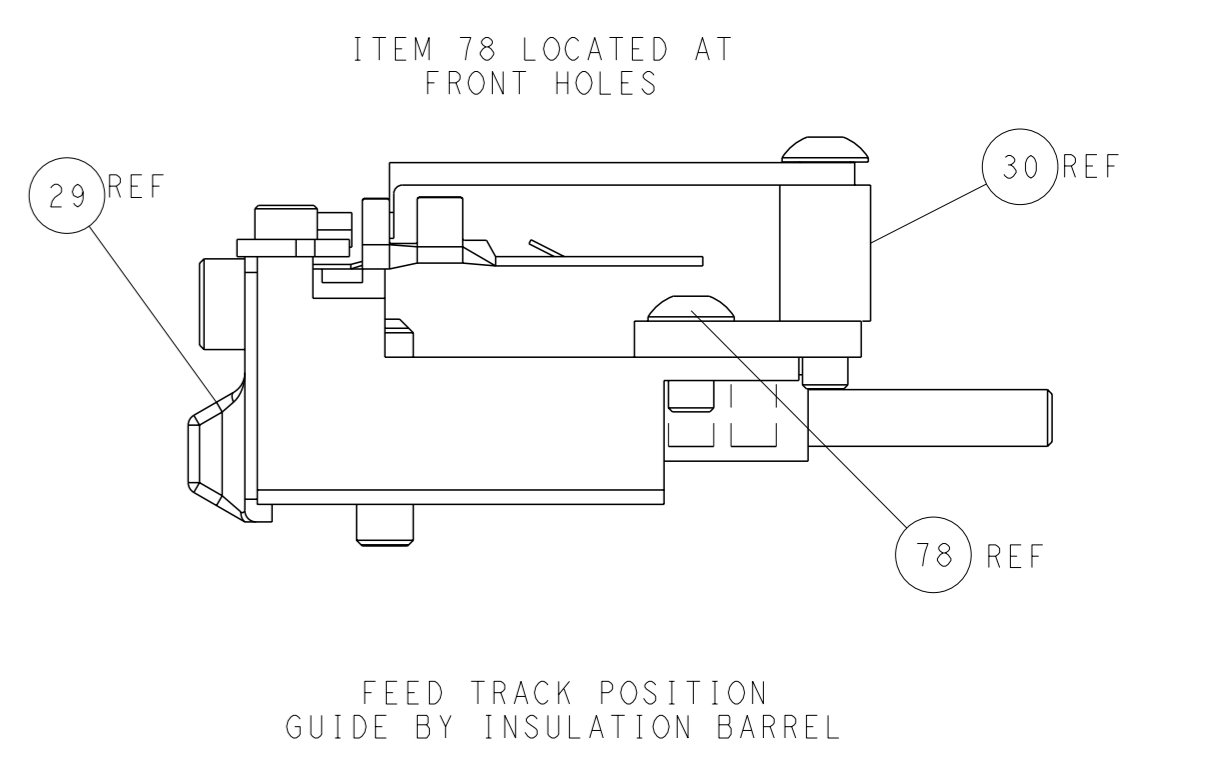
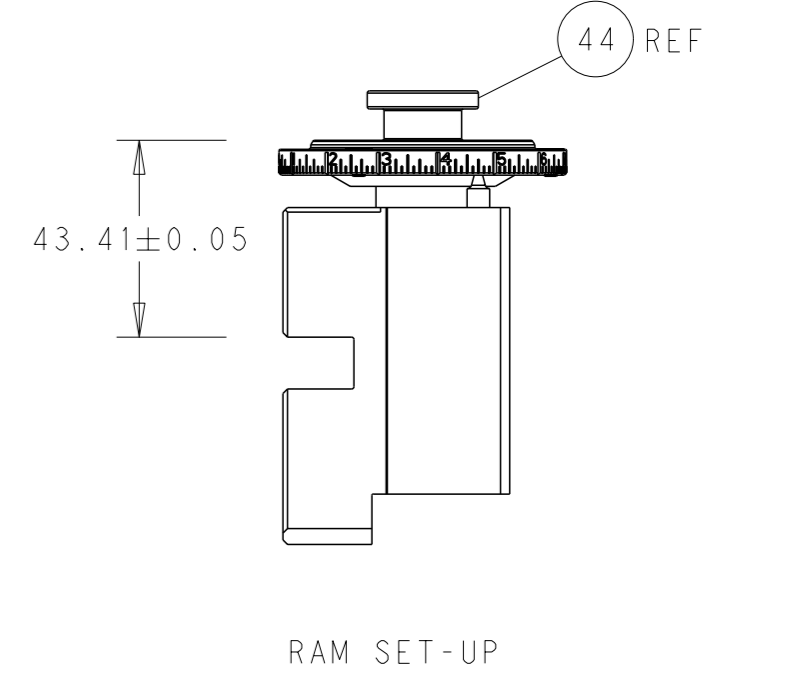
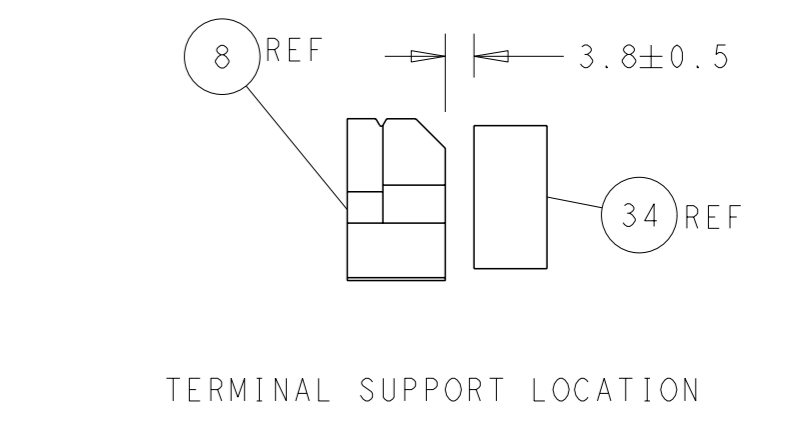
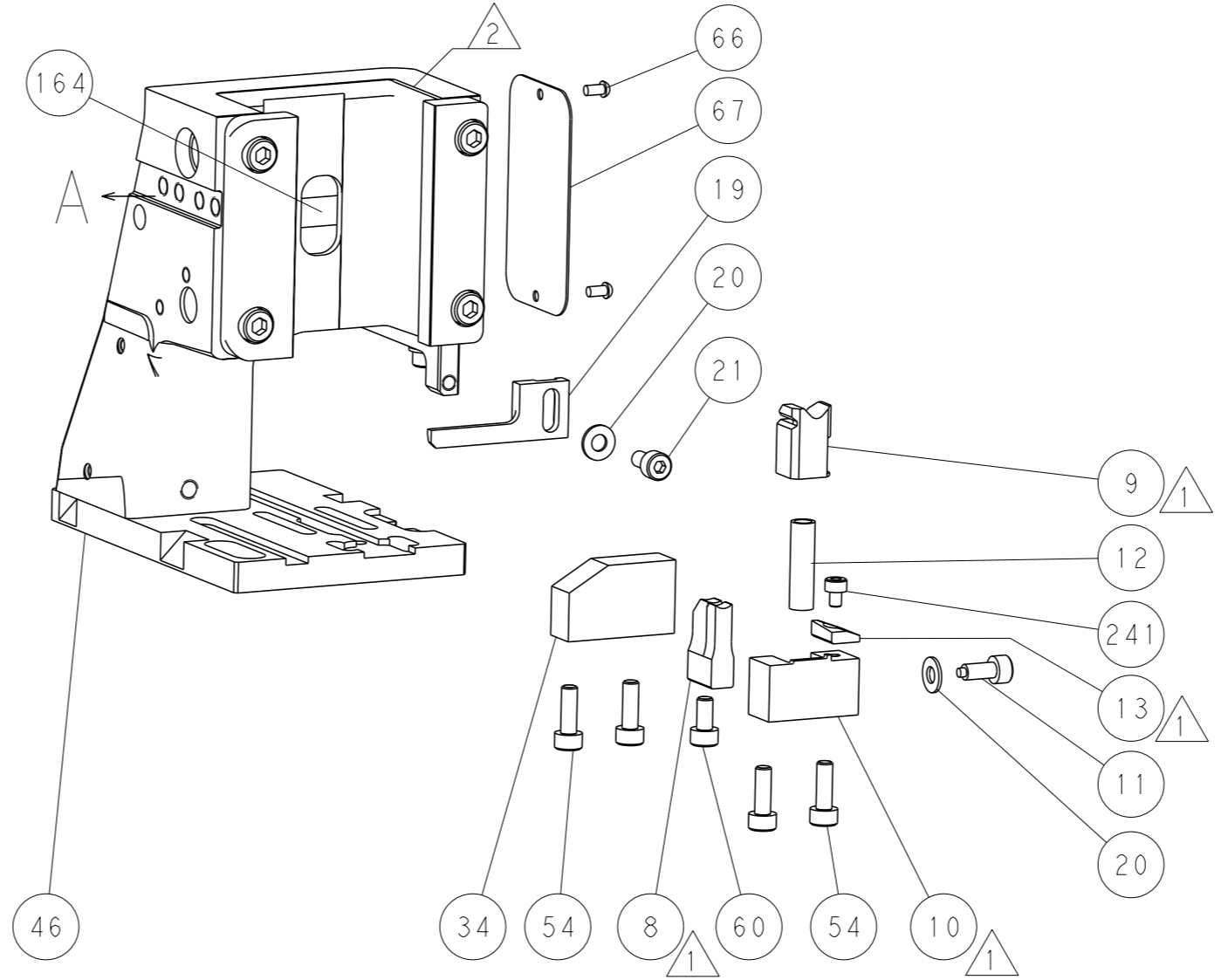
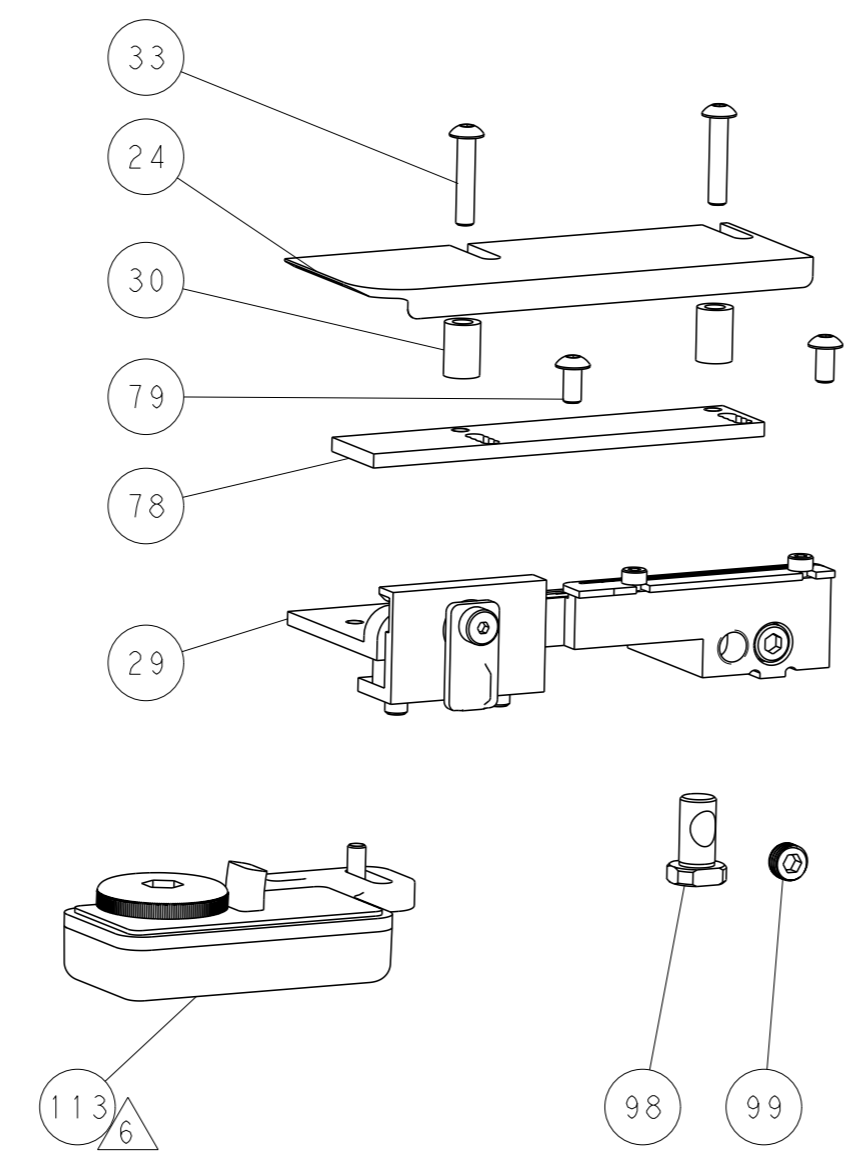
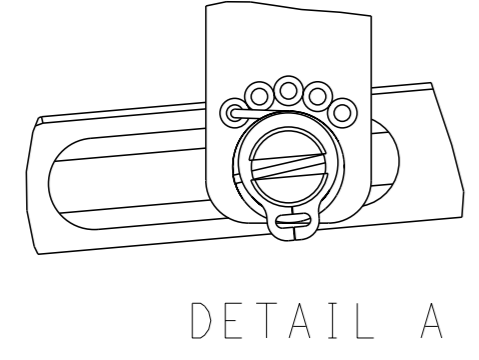
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		OWN		DATE	
mm	0 PLC ±	1 PLC ±	2 PLC ±	F. ZHANG	27JAN2021	TE Connectivity	
	3 PLC ±	4 PLC ±	ANGLES ±	Y. YIN	27JAN2021	Harrisburg, PA 17105-3608	
MATERIAL	FINISH	WEIGHT	SCALE	NAME		RESTRICTED TO	
			1:2	OCEAN 2.0 Side Feed Applicator		-	
Customer Accessible Production Drawing				SCALE 1:2		SHEET 1 OF 4 REV A	

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

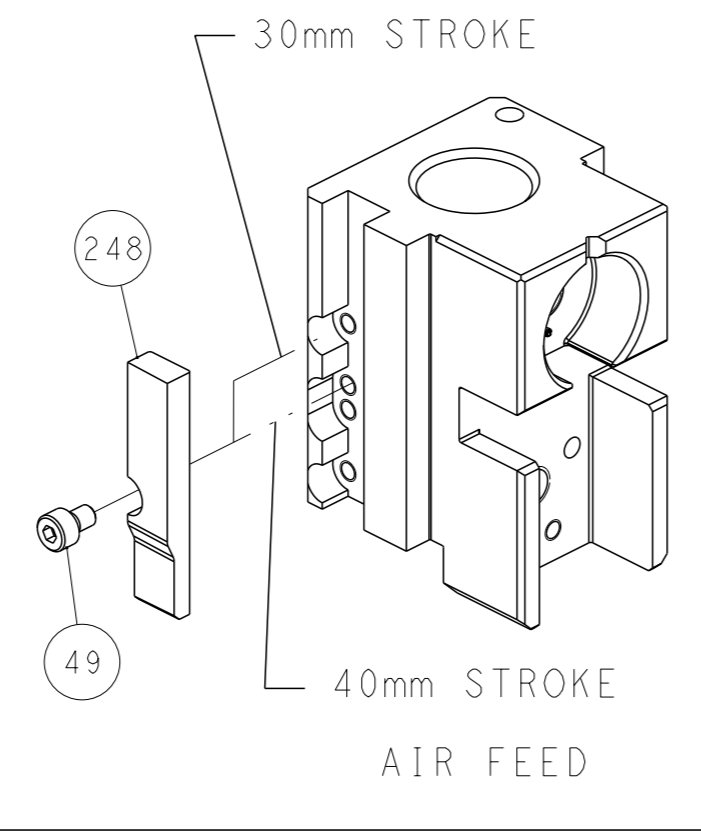
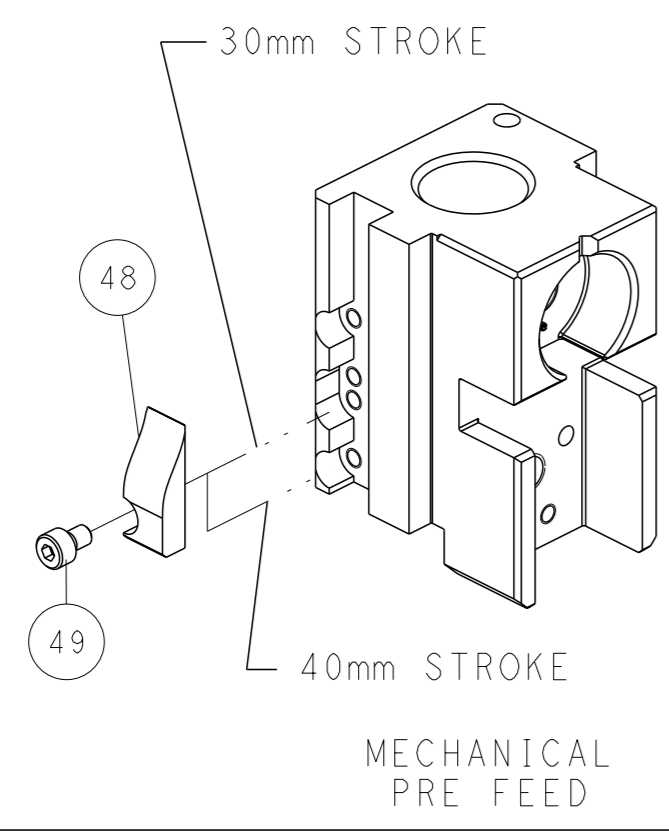
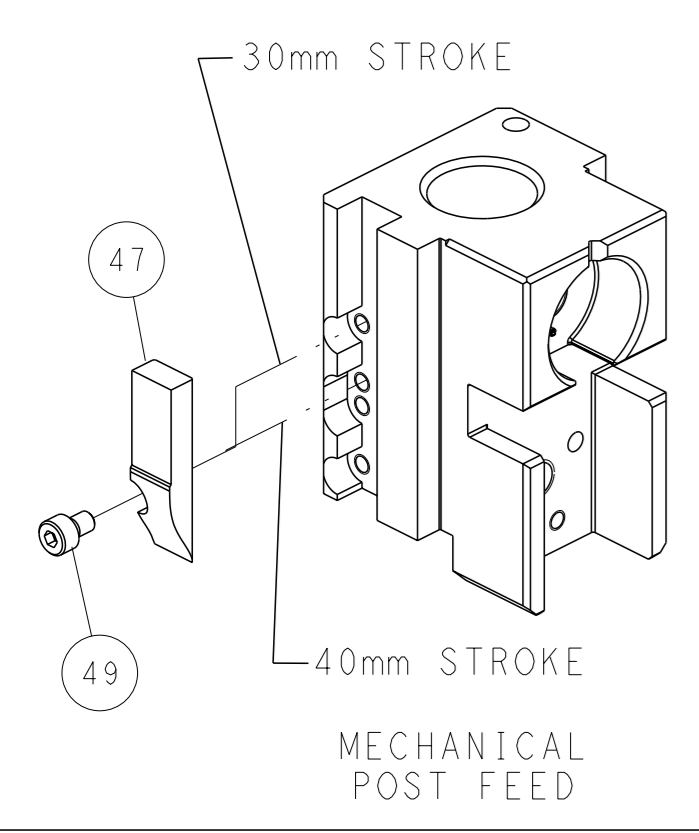
# FEED TYPE MECHANICAL



## 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 A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE AND TO CONTROLING ENGINEERING DISCRETION SHOULD BE CONTACTED FOR THE LATEST REVISION.</small>		OWN: F. ZHANG CHK: Y. YIN APVD: Y. YIN DATE: 27JAN2021 PRODUCT SPEC: - APPLICATION SPEC: - WEIGHT: - MATERIAL: -	NAME: OCEAN 2.0 Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2837941 SCALE: 1:2 SHEET: 2 of 4 REV: A	TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH: -		Customer Accessible Production Drawing		

THIS DRAWING IS UNPUBLISHED.	RELEASED FOR PUBLICATION		
© COPYRIGHT 20 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.	20		
PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2837941-1	A	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2837941-2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2837941-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR  
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	3.94 mm (.155)	F
INSUL	4.83 mm (.190)	F
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: HU LANE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: 312 TYPE MALE TERMINAL			
WIRE STRIP LENGTH		TERMINAL INSULATION DIAMETER RANGE	
5.24-6.00 mm (.206-.236 IN)		Ø3.70-4.00 mm (.146-.157 IN)	
TERMINAL APPLICATION SPECIFICATION	NONE		AT9106
TERMINALS APPLIED			
TE TERMINAL	HU LANE TERMINAL	TE TERMINAL	HU LANE TERMINAL
3311753-1	6605701BS2	3311753-2	6605701BS0
3311753-3	331-0256-524		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
5.00mm2	2.50+/-0.05 [.098+/-0.002]	7.0

- 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 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)

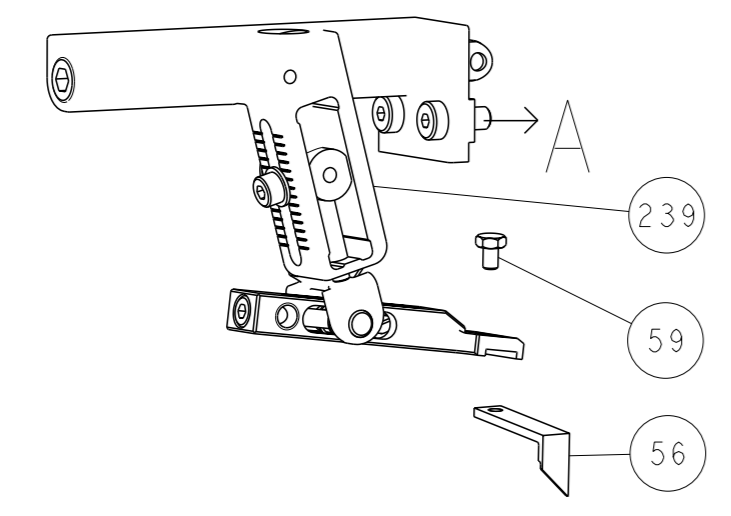
LOC	DIST	REVISIONS					
A	66	REV	LYR	DESCRIPTION	DATE	OWN	APVD
		-	-	SEE SHEET 1	-	-	-

-	1	1	2119791-6	DEPRESSOR, WIRE	286
-	1	1	2119082-7	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
-	2	2	2079383-4	SCR, BHSC, RoHS (M4 X 8)	79
-	1	1	1803096-1	EXTENSION PLATE	78
-	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
-	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	1	1	1338683-8	FEED PAWL	56
-	2	2	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	53
-	1	1	1803382-1	HOLD DOWN, SPRING LOADED	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	3-1752356-3	SUPPORT, TERMINAL	34
-	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	1-2844962-7	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29
-	1	1	455888-3	SPACER, CRIMPER	28
-	1	1	1320928-4	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	1-1803512-6	ANVIL, COMBINATION	8
-	1	1	2-240641-2	SPACER	7
-	-	-	-	-	6
-	1	1	1-2119757-4	DEPRESSOR, SHEAR	5
-	1	1	7-238011-5	BLOCK, CRIMPER SPACER	4
-	1	1	4-1803187-0	CRIMPER, INSULATION F	3
-	1	1	455888-3	SPACER, CRIMPER	2
-	1	1	1-456415-0	CRIMPER, WIRE .155 F PREMIUM	1
-	77	-22	-21	PART NO	ITEM NO

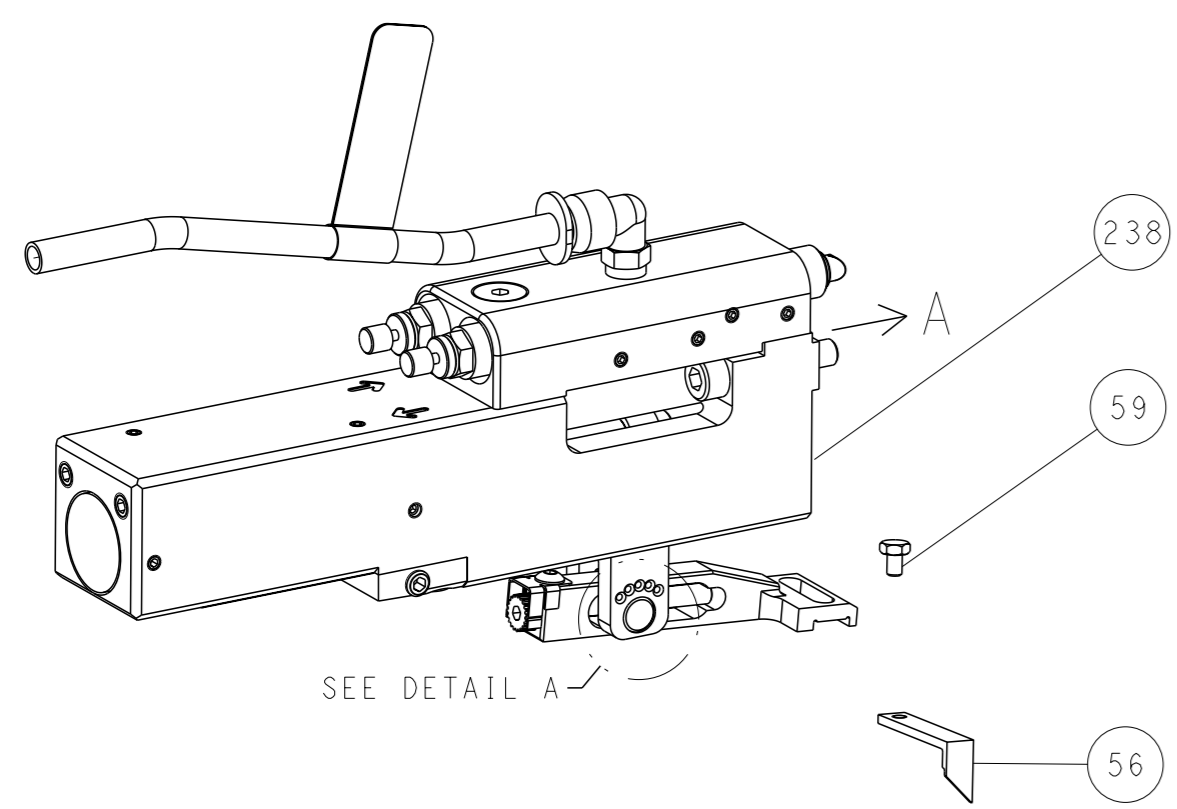
<small>THE DRAWING IS CONTROLLED DOCUMENT FROM THE REVISIONS INFORMATION SHEET. IF SUBJECT TO CHANGE AND THE DRAWING INFORMATION SHOULD BE CONTACTED FOR THE LATEST REVISION.</small>		OWN F. ZHANG 27JAN2021 CHK Y. YIN 27JAN2021 APVD Y. YIN 27JAN2021	<b>TE</b> TE Connectivity Harrisburg, PA 17105-3608
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	SIZE CAGE CODE DRAWING NO A1 00779 C=2837941
MATERIAL		APPLICATION SPEC WEIGHT SCALE 1:2 SHEET 3 OF 4 REV A	RESTRICTED TO Customer Accessible Production Drawing

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

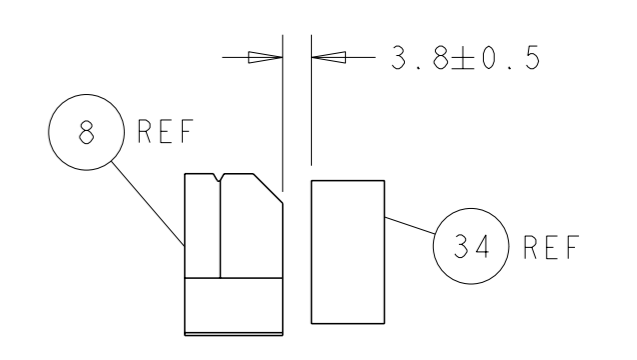
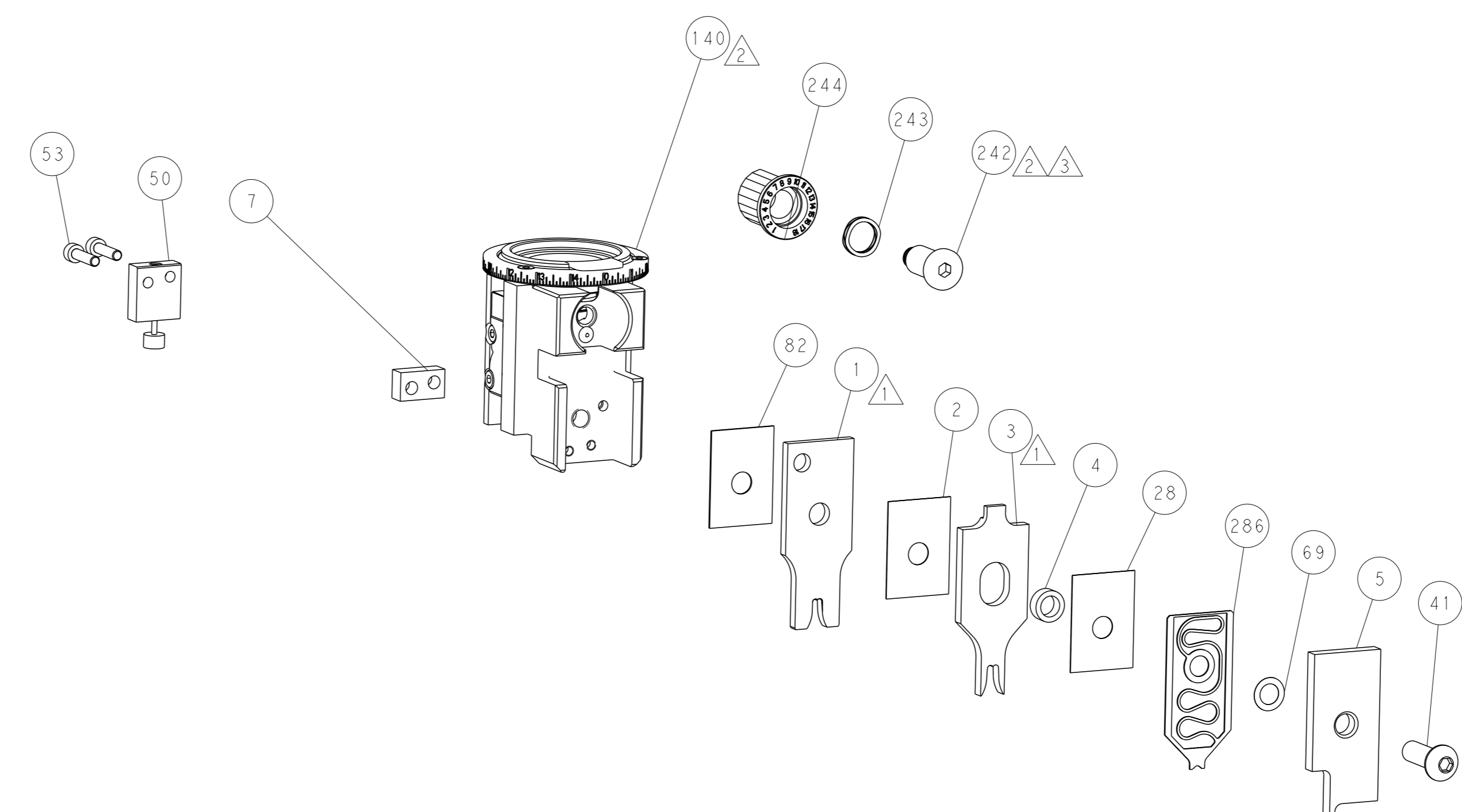
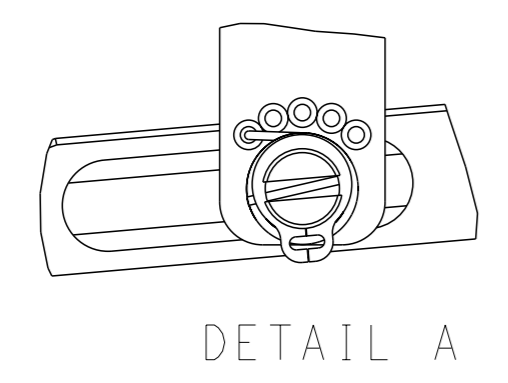
# FEED TYPE MECHANICAL



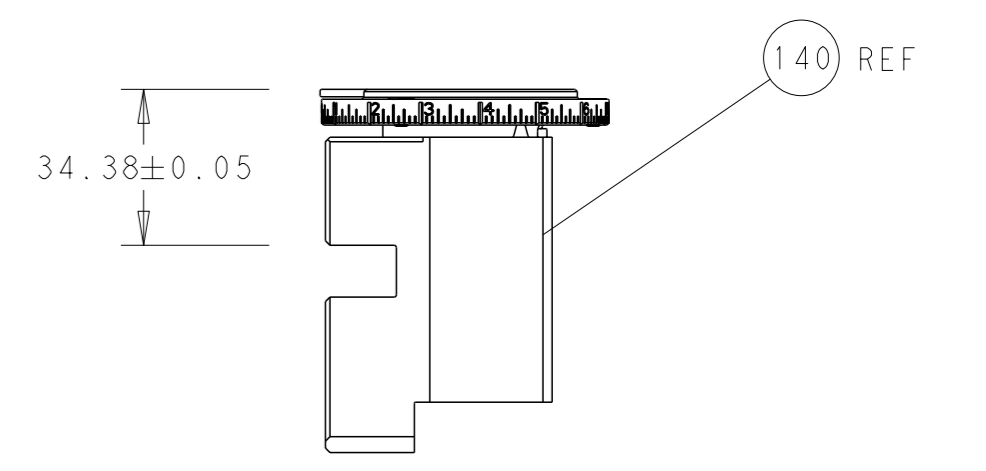
## PNEUMATIC



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

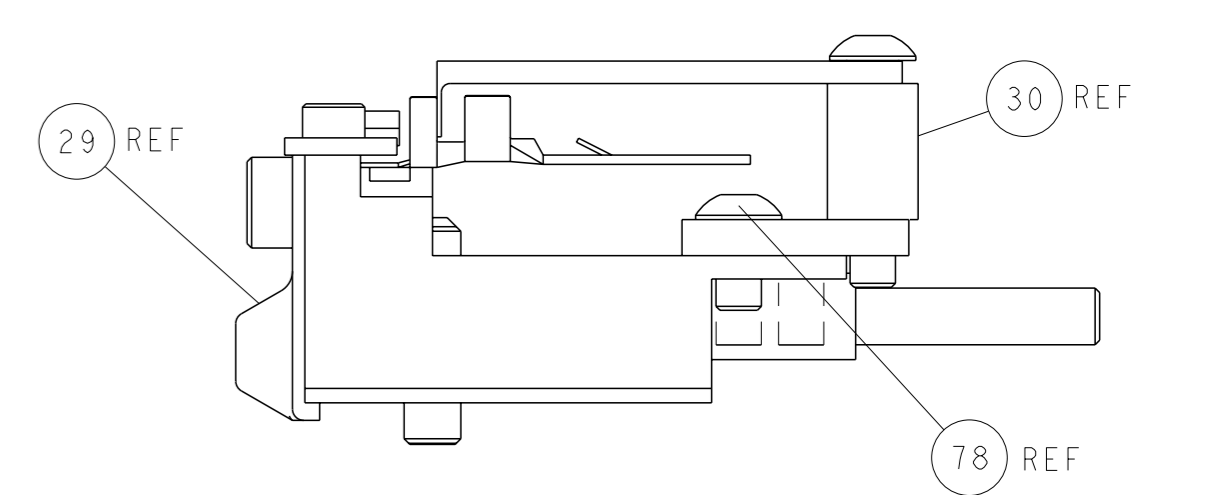


TERMINAL SUPPORT LOCATION



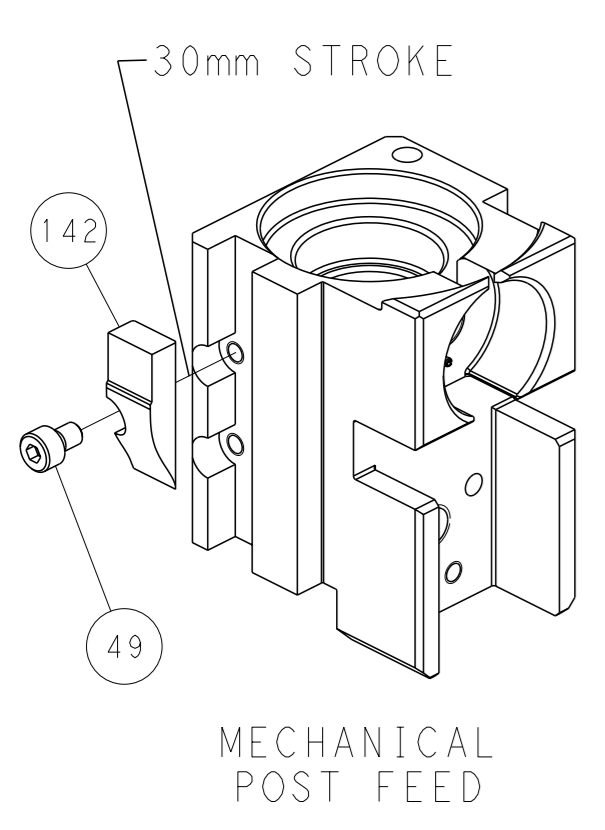
RAM SET-UP

ITEM 78 LOCATED AT FRONT HOLES

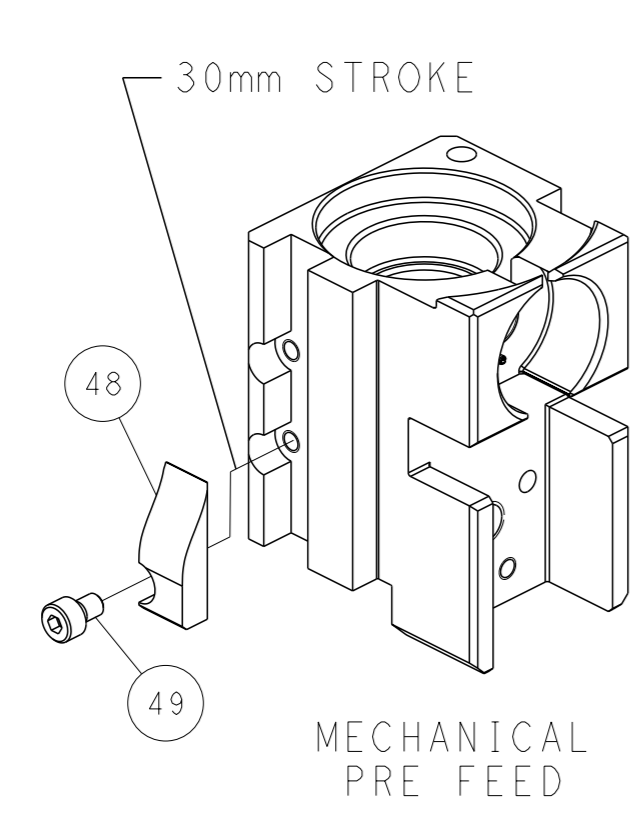


FEED TRACK POSITION GUIDE BY INSULATION BARREL

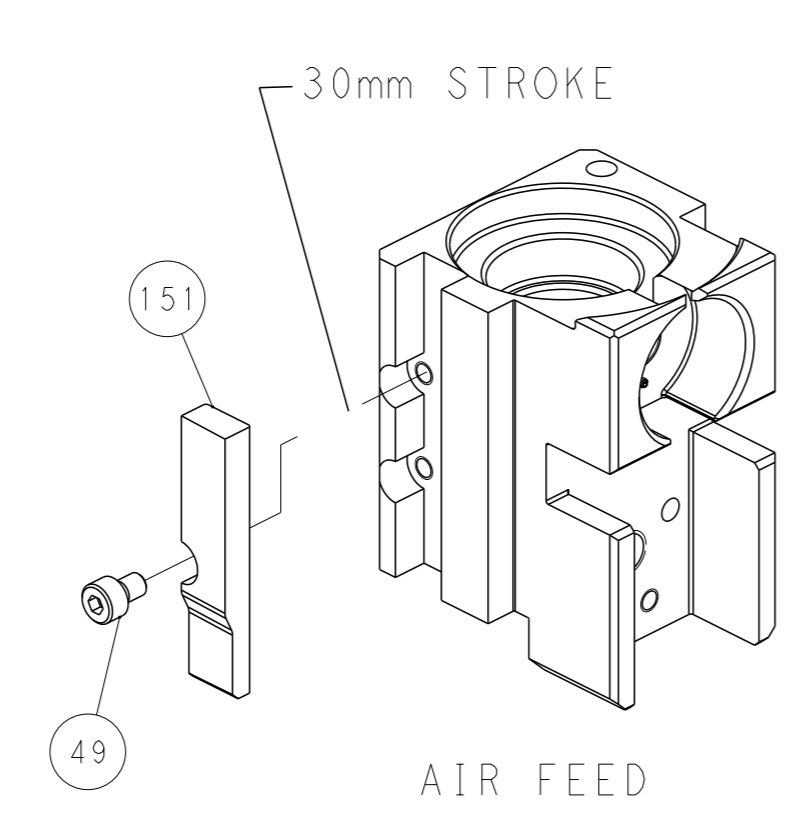
# CAM POSITIONS



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 CONTROL AND REVISIONS ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST REVISION.</small>		OWN: F. ZHANG CHK: Y. YIN APVD: Y. YIN PRODUCT SPEC: - APPLICATION SPEC: - WEIGHT: - MATERIAL: -	DATE: 27JAN2021 DATE: 27JAN2021 DATE: 27JAN2021 SCALE: 1:2 SHEET: 4 of 4 REV: A	NAME: OCEAN 2.0 Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2837941 RESTRICTED TO: -
--	--	--	--	---