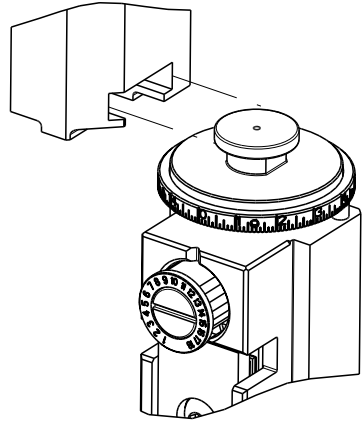
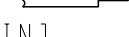
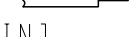


8		7	
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20		20	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
4150018-1	D	FINE CRIMP HEIGHT ADJUST	MECHANICAL
4150018-2	D	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-4150018-1	D	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-4150018-2	D	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-4150018-7	D	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.79 mm [.110]	F
INSUL	4.57 mm [.180]	-
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: SHUR PLUG			
WIRE STRIP LENGTH 4.10-4.86 mm [.161-.191 IN]		TERMINAL INSULATION DIAMETER RANGE	
			
TERMINAL APPLICATION SPECIFICATION 		- AT9106	
TERMINALS APPLIED			
TE TERMINAL 170002-2	TE TERMINAL 170002-7	TE TERMINAL	TE TERMINAL

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
2.00mm2	1.88+/-0.05 [.074+/- .002]	3.9
1.25mm2	1.73+/-0.05 [.068+/- .002]	5.4
0.75mm2	1.63+/-0.05 [.064+/- .002]	6.6
0.50mm2	1.50+/-0.05 [.059+/- .002]	7.9



1. RECOMMENDED SPARE PARTS.
2. REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION & STORAGE OF APPLICATOR.
3. APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 180. 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. FOR INSULATION RANGE 1.60-2.10mm USE OVERLAP INSULATION CRIMPER, P/N 2119785-8 (ITEM 3)
- FOR INSULATION RANGE 2.54-3.68mm USE F INSULATION CRIMPER, P/N 2119582-3 (ITEM 227)
6. 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)

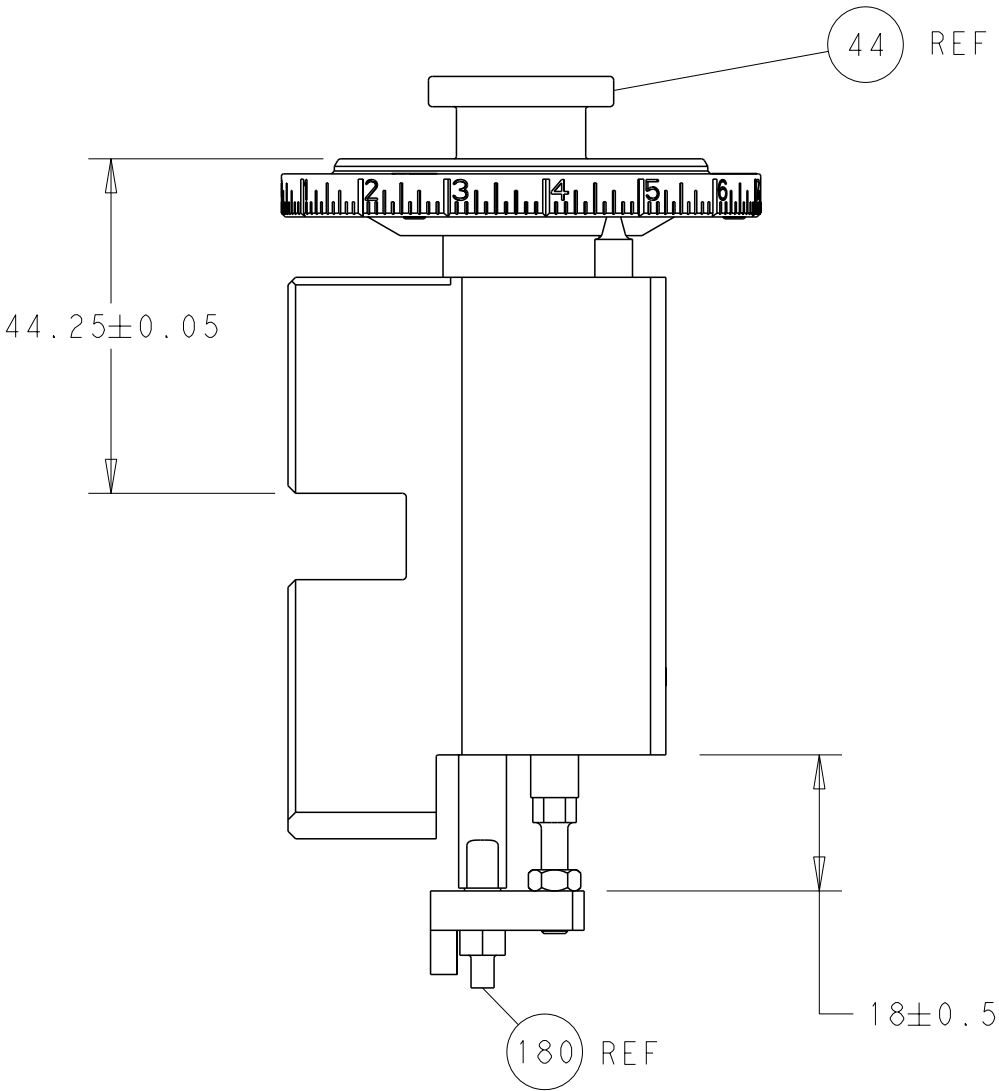
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LOC	DIST	REVISIONS						
A	66	P	LTR	DESCRIPTION	DATE	DWN	APVD	
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		B		ECR-19-012337	05AUG2019	JAH	RK	
		C		ECR-20-014536	14OCT2020	JWC	TE	
		D		ECR-20-017222	03DEC2020	JWC	TE	

-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248
-	1	1	1	1	2119082-3	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	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	1	-	1	-	2844940-3	AIR FEED MODULE	238
1	2	2	1	1	2119582-3	CRIMPER, INSULATION F PREMIUM	227
-	1	1	1	1	1-18028-0	WASHER, FLAT, REG M8	192
-	1	1	1	1	1-1976055-5	STANDOFF, HOLD-DOWN	180
-	1	1	1	1	6-9931111-6	PIN, SLOTTED SPRING 3.0 X 14.0	177
-	1	1	1	1	8-22280-7	SPRING, COMPRESSION	176
-	1	1	1	1	1752353-2	GUIDE PIN,HOLDDOWN	175
-	1	1	1	1	1901680-2	GUIDE PIN,HOLDDOWN	174
-	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	1	1	1	1	455888-5	SPACER, CRIMPER	82
-	1	1	1	1	1803607-4	DOCUMENTATION PACKAGE	71
-	2	2	2	2	2-18032-2	SCR, SET, FLT PNT, M3 X 10.0	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	1901681-5	HOLDDOWN, TERMINAL	65
-	2	2	2	2	2168400-8	SHCS, LOW HEAD, RoHS, M4 X 16	64
-	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	2063961-9	FEED FINGER	58
-	3	3	3	3	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57
-	2	2	2	2	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	56
-	2	2	2	2	5018030-1	NUT, HEX, REG, RoHS, M3	54
-	2	2	2	2	986965-8	NUT, LOCK, HEX, TORQUE (M4)	53
-	1	1	1	1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52
-	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	2119655-5	APPLICATOR BASIC ASSEMBLY, EF	46
-	1	1	1	1	1803517-1	RAM ASSEMBLY, EF ATLANTIC	44
-	1	1	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
-	7	7	7	7	1-18028-2	WASHER, FLAT, REG M4	33
-	2	2	2	2	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	31
-	2	2	2	2	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	29
-	1	1	1	1	240639-1	STRIPPER (MACHINING)	27
-	2	2	2	2	1-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 30	25
-	1	1	1	1	1752371-5	PLATE, STRIP GUIDE	24
-	1	1	1	1	240825-2	PLATE, STRIP HOLD DOWN	23
-	2	2	2	2	2-22281-3	SPRING, COMPRESSION	22
-	1	1	1	1	1803292-4	DRAG	20
-	2	2	2	2	1901259-5	GUIDE, LOWER STRIP	18
-	4	4	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17
-	1	1	1	1	1-240641-1	SPACER	16
-	1	1	1	1	1752360-1	SPACER,HOLD-DOWN	13
-	1	1	1	1	240644-1	PLATE, REAR SHEAR	11
-	2	2	2	2	1-240645-4	SPACER, SHEAR PLATE	10
-	1	1	1	1	240642-1	PLATE, FRONT SHEAR	9
1	2	2	1	1	1803001-4	ANVIL, COMBINATION, END FEED	8
-	1	1	1	1	240651-8	BLADE, SLUG	7
-	-	-	-	-	-	-	6
-	1	1	1	1	8-240641-4	SPACER	5
-	1	1	1	1	238011-2	BLOCK, CRIMPER SPACER	4
1	2	2	1	1	2119785-8	CRIMPER, INSULATION OVERLAP PREMIUM	3
-	1	1	1	1	1-455888-0	SPACER, CRIMPER	2
1	2	2	1	1	456408-2	CRIMPER, WIRE PREMIUM	1
-77-72-71-2-1	PART NO					DESCRIPTION	ITEM NO

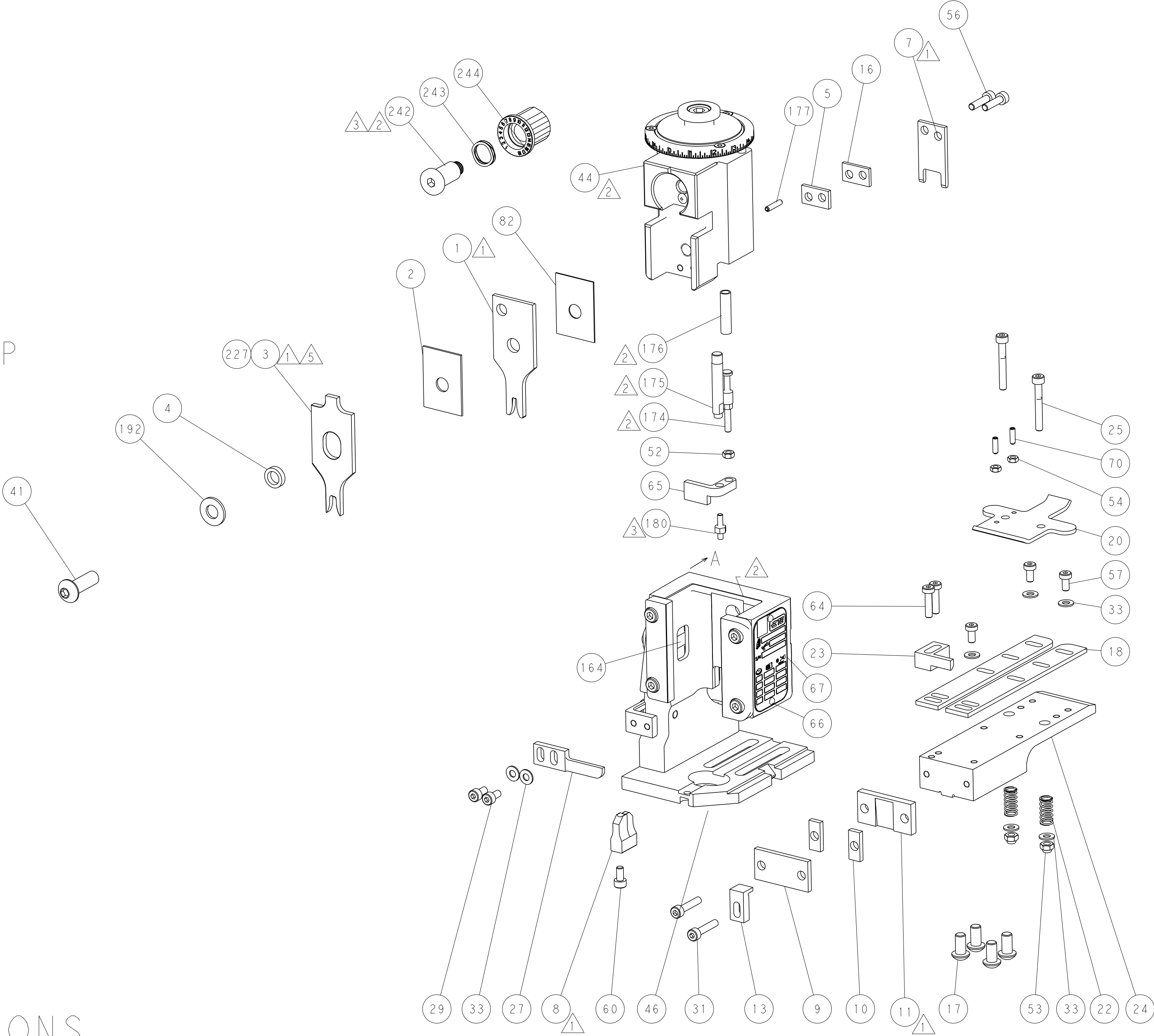
THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE AND TO BE CONTROLLED BY THE ENGINEERING DEPARTMENT. IT SHOULD BE CONTACTED FOR THE LATEST REVISION.		DWN J. HAYNES 24JUL2019	TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm		CHK T. ELBIN 24JUL2019	NAME OCEAN 2.0 End Feed Applicator	
TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		APVD R. KNEPPER 24JUL2019	SIZE A	
MATERIAL -		FINISH -	WEIGHT -	
Customer Accessible Production Drawing		SCALE 1:1	SHEET 1 of 4 REV D1	

SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

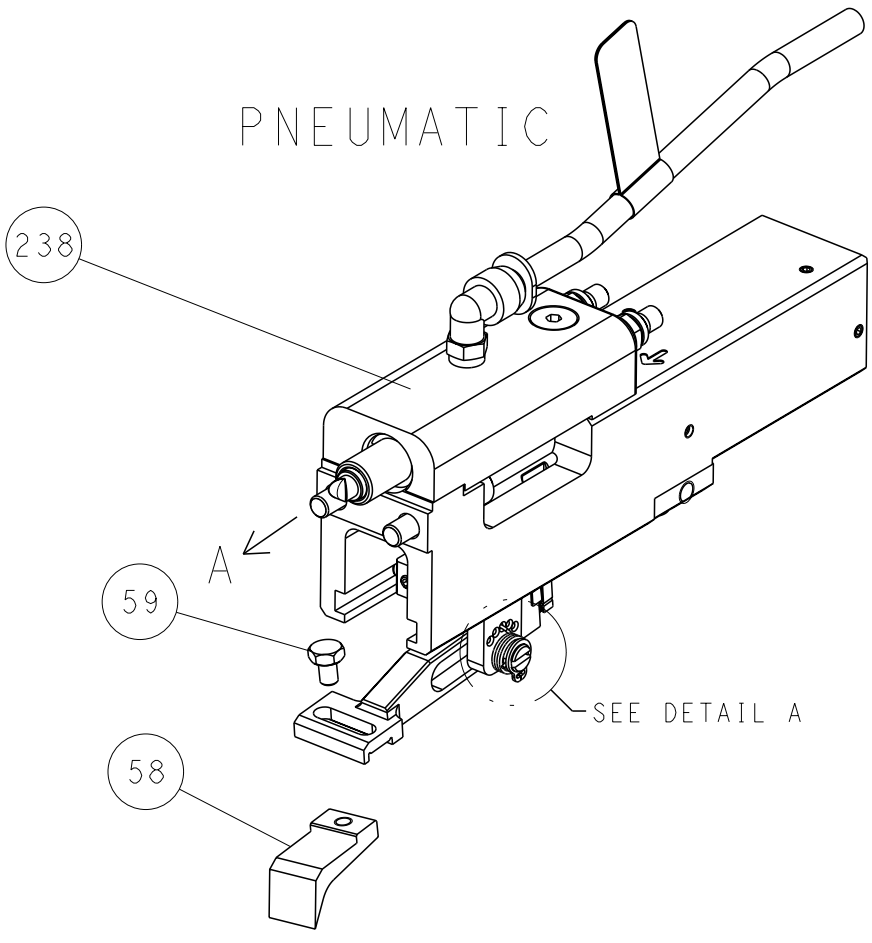
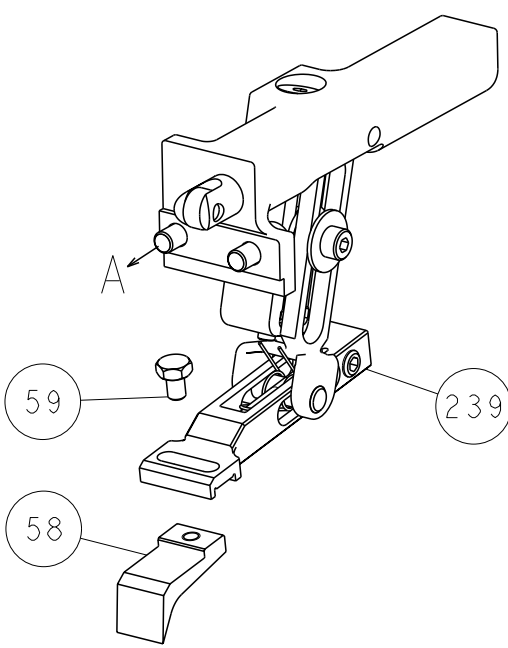
LOC		DIST		REVISIONS			
A		66		REV	DESCRIPTION	DATE	APVD
				-	SEE SHEET 1	-	-



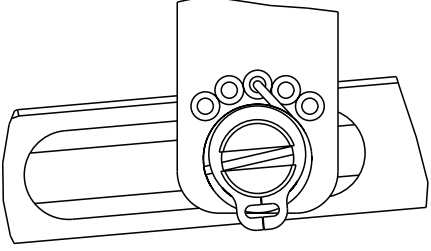
RAM AND HOLDDOWN SET-UP



FEED TYPE
MECHANICAL

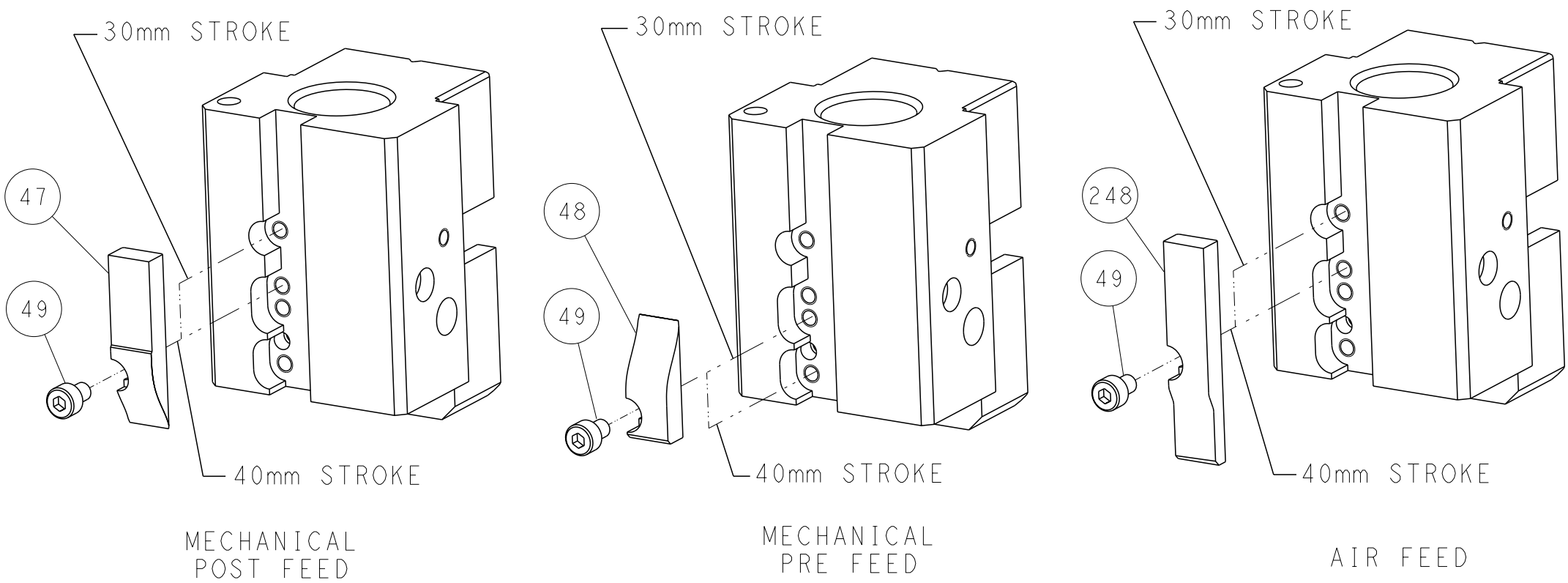


FEED SPRING
SETTING POSITION



DETAIL A

CAM POSITIONS



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

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		OWN J. HAYNES 24JUL2019		TE Connectivity	
mm		0 PLC ±		CMV T. ELBIN 24JUL2019		Harrisburg, PA 17105-3608	
FINISH		1 PLC ±		APVD R. KNEPPER 24JUL2019		NAME	
MATERIAL		2 PLC ±		PRODUCT SPEC		OCEAN 2.0 End Feed	
		3 PLC ±		APPLICATION SPEC		Applicator	
		4 PLC ±		WEIGHT		SIZE	
		ANGLES ±		Customer Accessible Production Drawing		CAGE CODE	
				SCALE 1:1		DRAWING NO	
				SHEET 2 of 4		REV D1	



5

C⁴

- *WARNING

 Δ

B

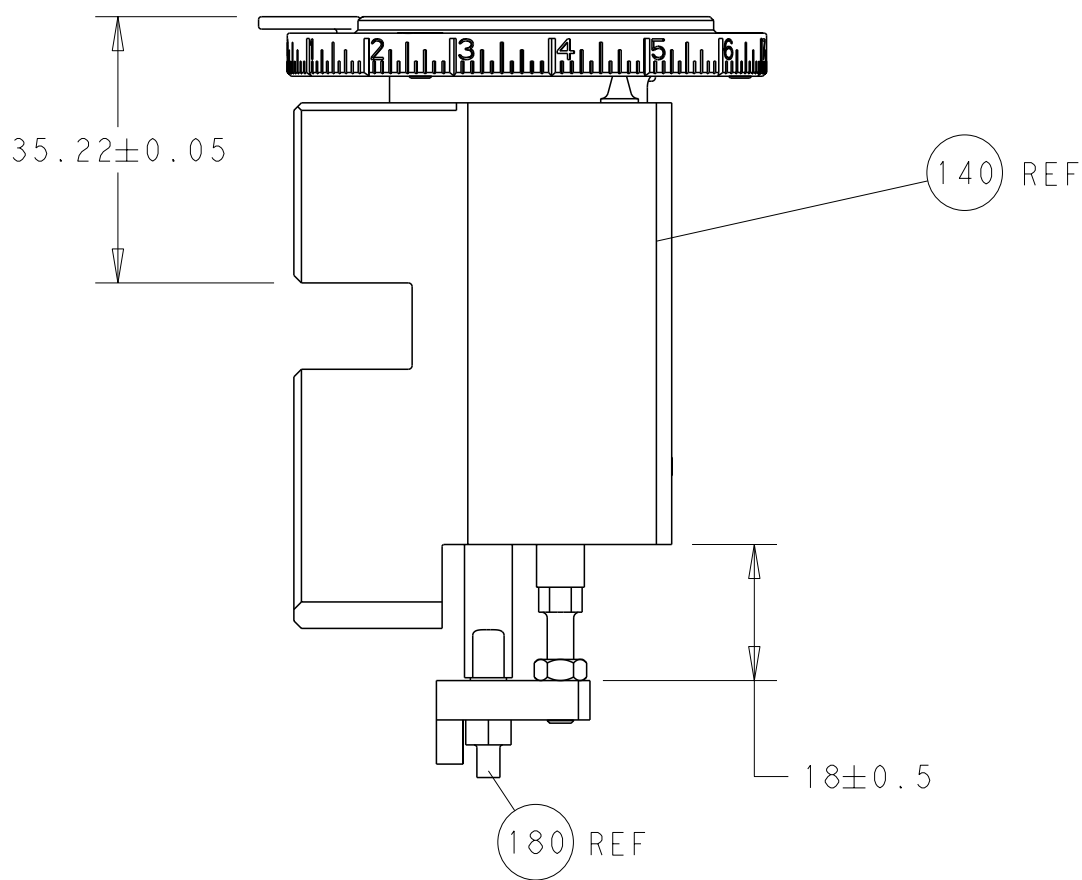
C

A

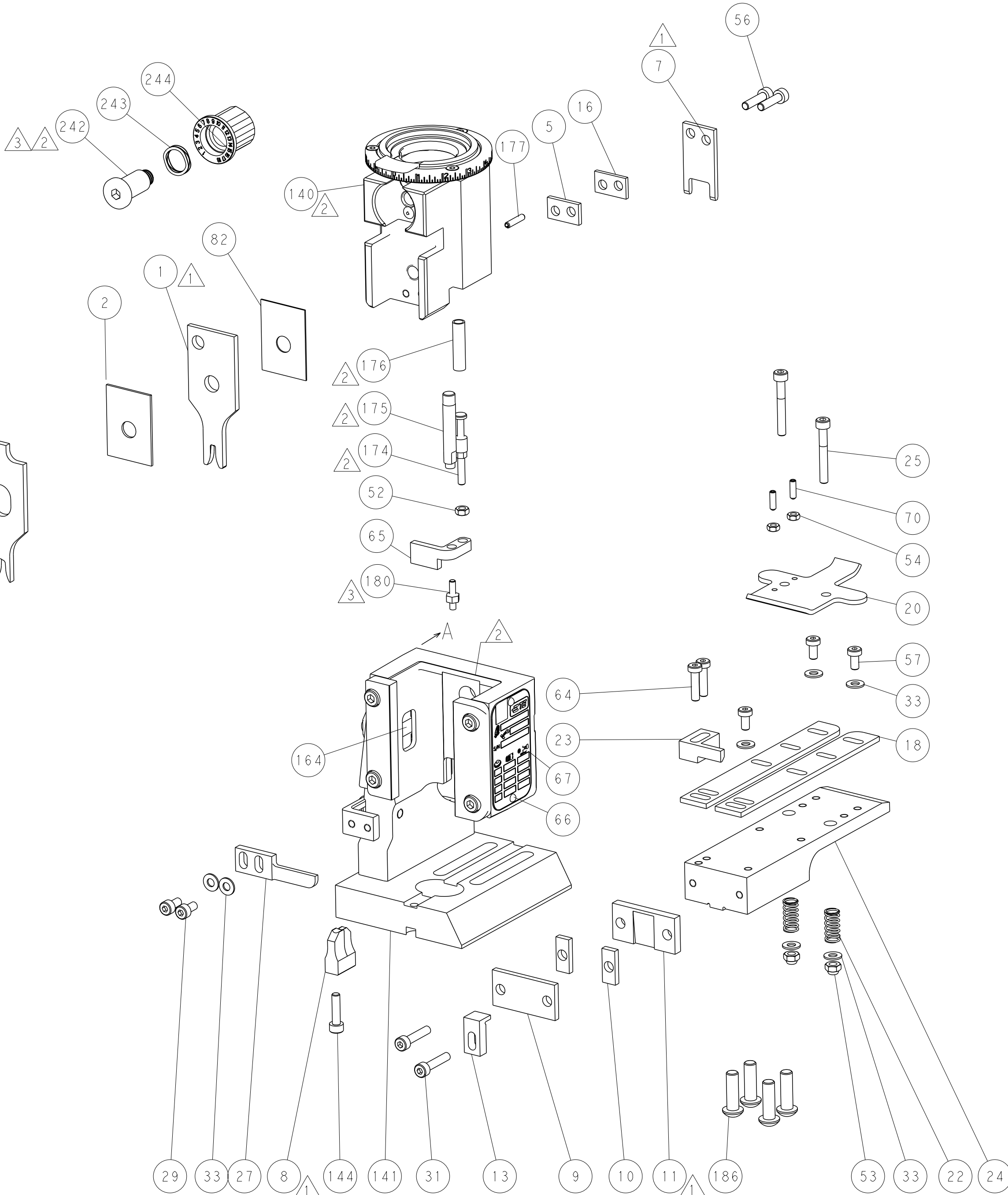
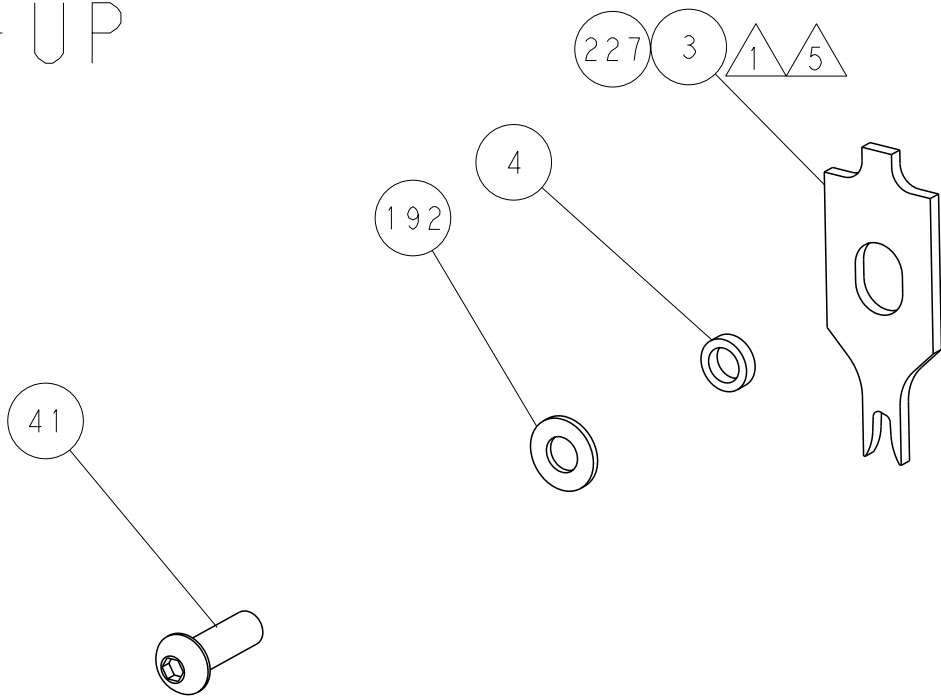
A

THIS DRAWING IS A CONTROLLED DOCUMENT FOR TWO ELECTRONIC ORGANIZATION IT IS SUBJECT TO CHANGE AND THE CONTROL NUMBER ON EACH ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST REVISION.		DWG J. HAYNES 24JUL2019 CHK T. ELBIN 24JUL2019 APVD R. KNEPPER 24JUL2019		 TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		NAME OCEAN 2.0 End Feed Applier	
		PRODUCT SPEC -		SIZE CAGE CODE DRAWING NO A1 00779 C=4150018	
MATERIAL -		FINISH -		RESTRICTED TO -	
Customer Accessible Production Drawing				SCALE 1:1	SHEET 3 OF 4
				REV D1	

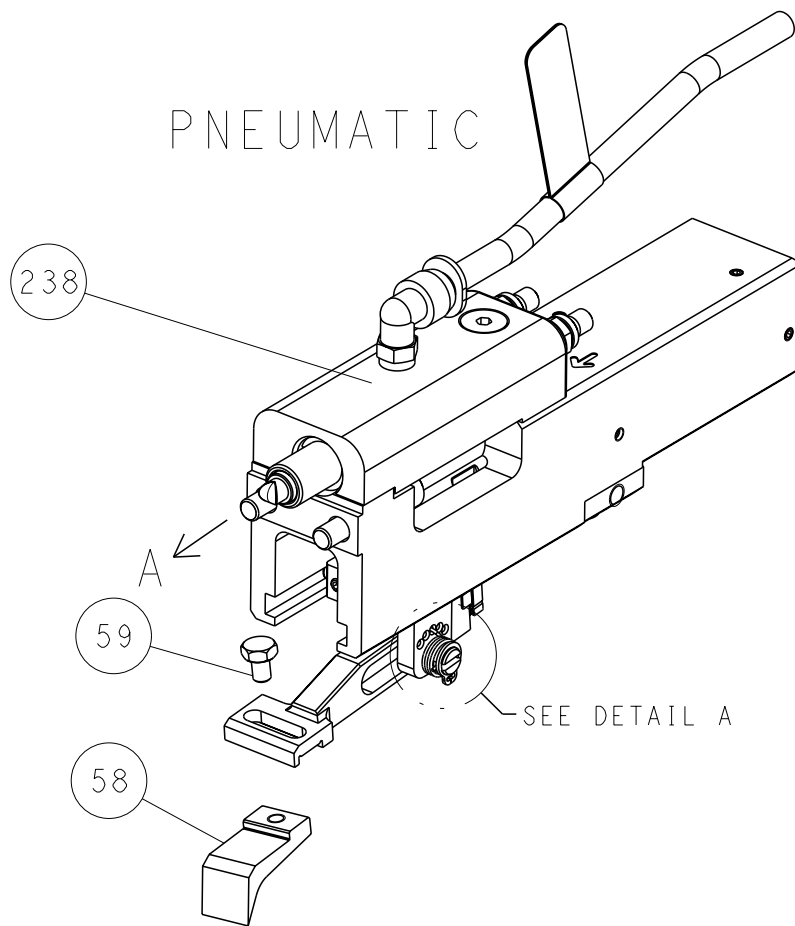
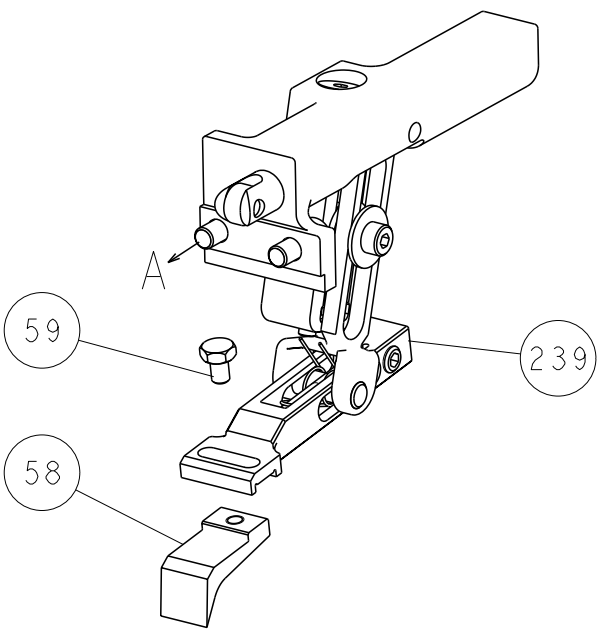
LOC		DIST		REVISIONS			
A	66	P	LYR	DESCRIPTION	DATE	DWN	APVD
		-		SEE SHEET 1	-	-	-



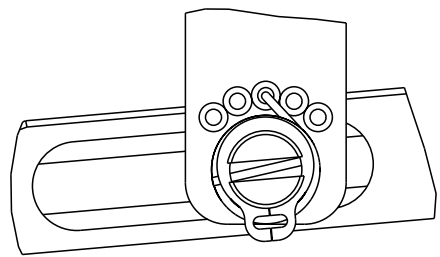
RAM AND HOLDDOWN SET-UP



FEED TYPE
MECHANICAL

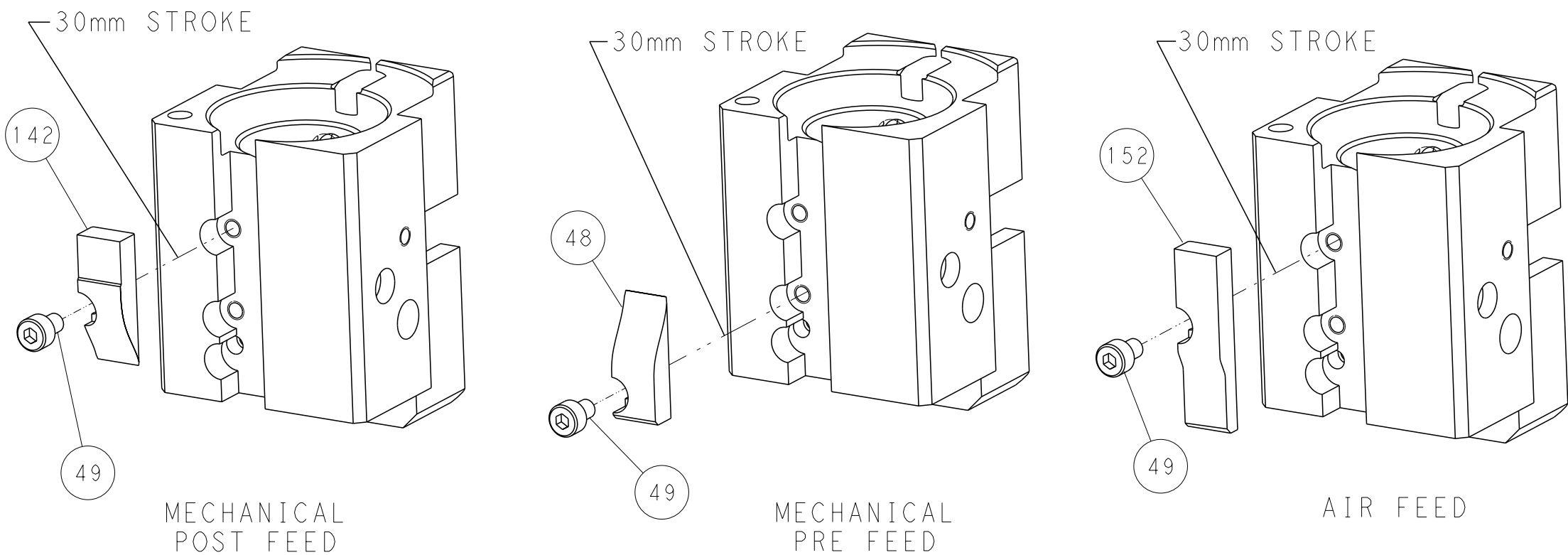


FEED SPRING
SETTING POSITION



DETAIL A

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:		DWN J. HAYNES 24JUL2019		TE Connectivity	
mm		0 PLC ±		CMY T. ELBIN 24JUL2019		Harrisburg, PA 17105-3608	
FINISH		1 PLC ±		APVD R. KNEPPER 24JUL2019		NAME	
MATERIAL		2 PLC ±		PRODUCT SPEC		OCEAN 2.0 End Feed	
		3 PLC ±		APPLICATION SPEC		Applicator	
		4 PLC ±		WEIGHT		SIZE	
		ANGLES		Customer Accessible Production Drawing		CAGE CODE	
				SCALE 1:1		DRAWING NO	
				SHEET 4 of 4		RESTRICTED TO	
				REV D1			