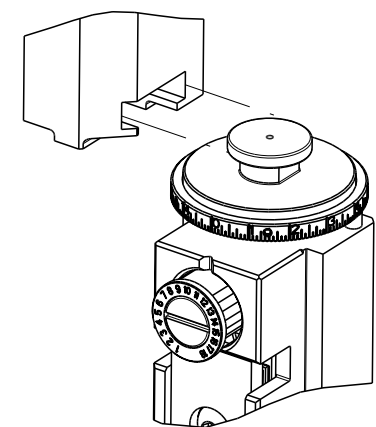


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151995-1	A	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2151995-2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151995-1	A	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2151995-2	A	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2151995-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.03 mm [.080]	F
INSUL	3.56 mm [.140]	O

APPLICATOR INSTRUCTIONS 408-35042

TERMINAL DATA: SUMITOMO TERMINAL		SUMITOMO CRIMP SPECIFICATION	
TERMINAL NAME: MALE TERMINAL			
WIRE STRIP LENGTH		TERMINAL INSULATION DIAMETER RANGE	
3.90-4.10 mm [.154-.161 IN]		Ø1.80-2.20 mm [.071-.087 IN]	
TERMINAL APPLICATION SPECIFICATION	8100-3178 Rev -		AT9106

TERMINALS APPLIED				SEAL INSULATION DIAMETER RANGE
TE TERMINAL	SUMITOMO TERMINAL	TE SEAL	SUMITOMO SEAL	
2113352-1	8100-3178	2113232-1	7165-0622	1.8-2.2

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.25mm2	1.40 +/- 0.05 [0.055 +/- .002]	8.1
1.00mm2	1.25 +/- 0.05 [0.049 +/- .002]	9.7
0.85mm2	1.20 +/- 0.05 [0.047 +/- .002]	10.2
0.75mm2	1.20 +/- 0.05 [0.047 +/- .002]	10.2

- RECOMMENDED SPARE PARTS
- REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 180. 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.
- UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT 101-35000.
- APPLY TORQ-SEAL IN ALLEN SOCKET TO FILL HOLE AFTER FLAT HD HAS BEEN ADJUSTED TO CORRECT HEIGHT AT QUALIFICATION. APPLY #1-23419-5 LOC-TITE TO THREADS.

**\*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					
		P	LY#	DESCRIPTION	DATE	OWN	APVD
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		A1		ECR-20-013103	15SEP2020	JWC	RR

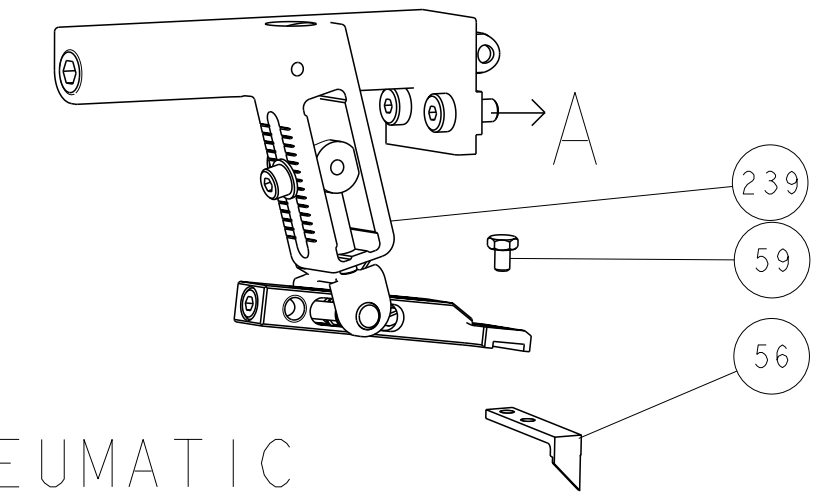
-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248
-	1	1	1	1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
3	-	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	1	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
-	-	1	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	1	-	1	-	2844940-1	AIR FEED MODULE	238
3	-	1	1	1	1-1752354-6	STANDOFF,HOLD-DOWN	180
-	1	1	1	1	6-993111-6	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	2844908-1	SCREW, LOCKING	99
-	1	1	1	1	2844907-1	POST, LOCKING	98
-	1	1	1	1	455888-5	SPACER, CRIMPER	82
-	1	1	1	1	1803607-3	DOCUMENTATION PACKAGE	71
-	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
6	-	1	1	1	985575-3	SCR, FLT SKT HD CAP M3 X 10.0	57
-	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
-	1	1	1	1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52
-	1	1	1	1	1901681-1	HOLDDOWN, TERMINAL	51
-	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	1803515-3	RAM ASSEMBLY, SF ATLANTIC	44
-	1	1	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
-	1	1	1	1	1752356-1	SUPPORT, TERMINAL	34
-	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	2	2	2-2844962-8	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29
-	1	1	1	1	455888-8	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	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	318707-1	FLOATING SHEAR, FRONT	9
1	1	2	2	1	1-1633920-6	ANVIL, COMBINATION	8
-	-	-	-	-	-	-	7
-	-	-	-	-	-	-	6
-	1	1	1	1	2119781-1	DEPRESSOR, SHEAR	5
-	1	1	1	1	238011-4	BLOCK, CRIMPER SPACER	4
1	1	2	2	1	1803018-8	CRIMPER, INSULATION O	3
-	1	1	1	1	1-455888-0	SPACER, CRIMPER	2
1	1	2	2	1	5-456405-6	CRIMPER, WIRE PREMIUM	1

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		APPLICATOR DATA	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±
	ANGLES	FINISH			
MATERIAL					

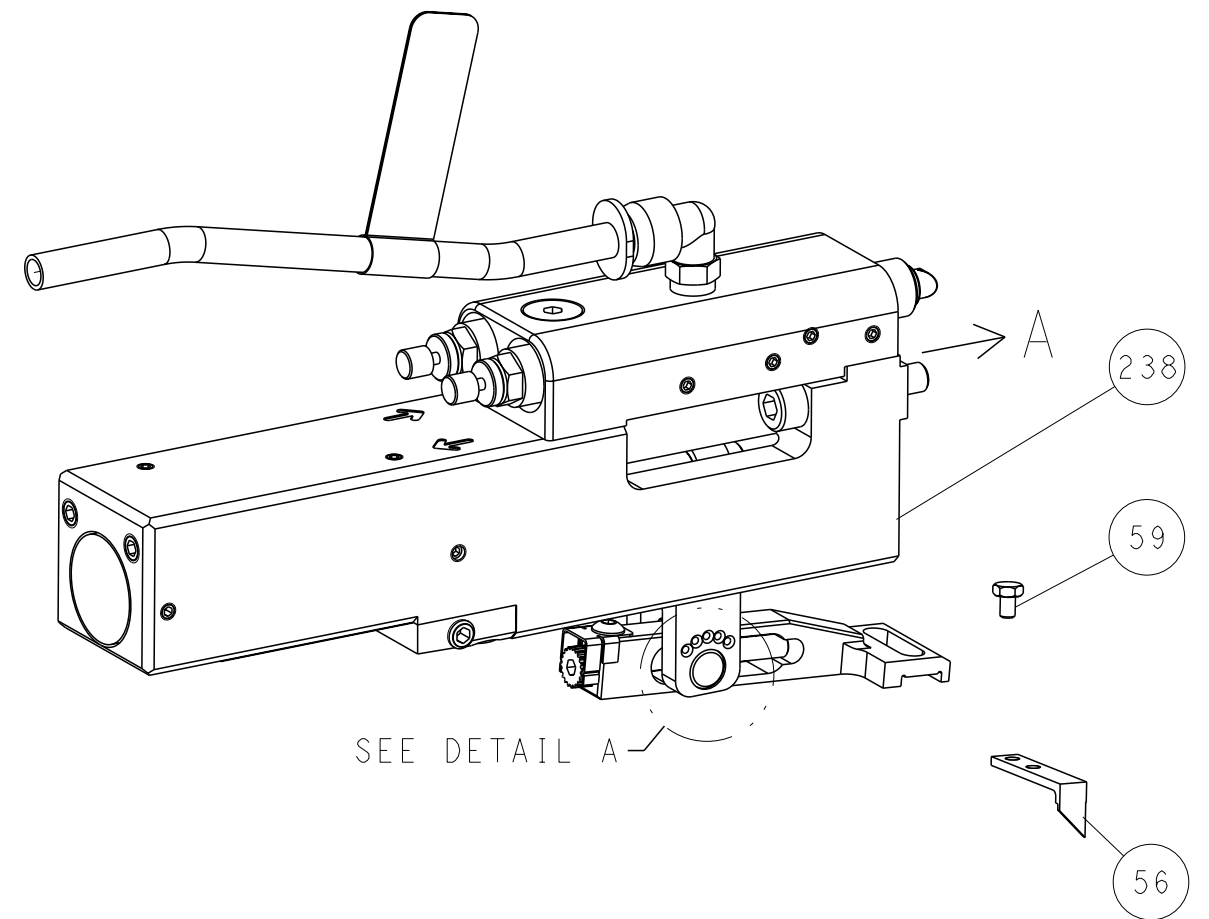
OWN	T. BROOKENS	12MAY2020
CHK	M. HERR	12MAY2020
APVD	R. KNEPPER	12MAY2020
NAME	OCEAN 2.0 Side Feed Applicator	
SIZE	CAGE CODE	DRAWING NO
A1	00779	2151995
Customer Accessible Production Drawing		
SCALE	1:2	SHEET 1 of 4
REV	A1	

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

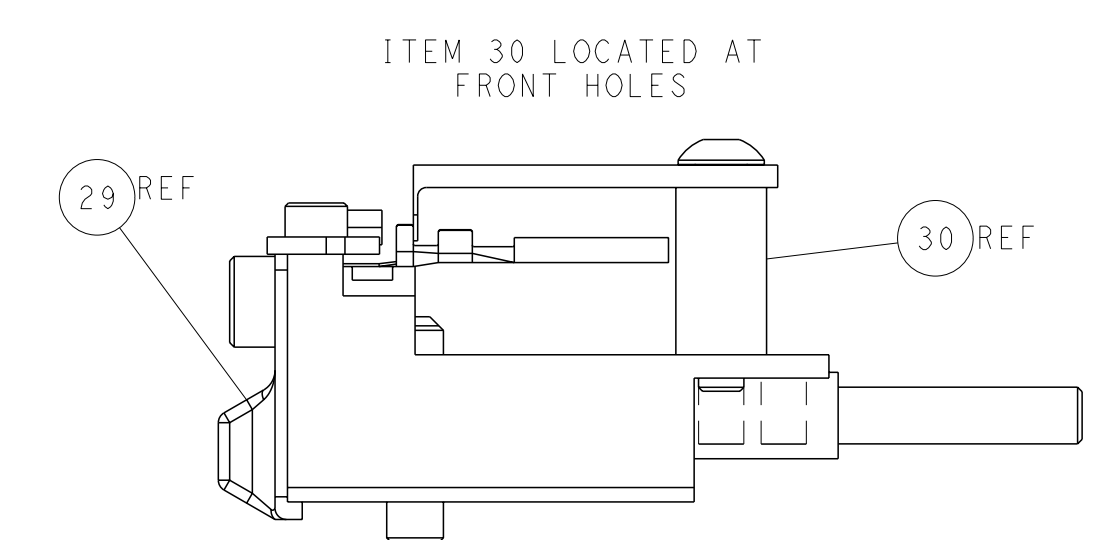
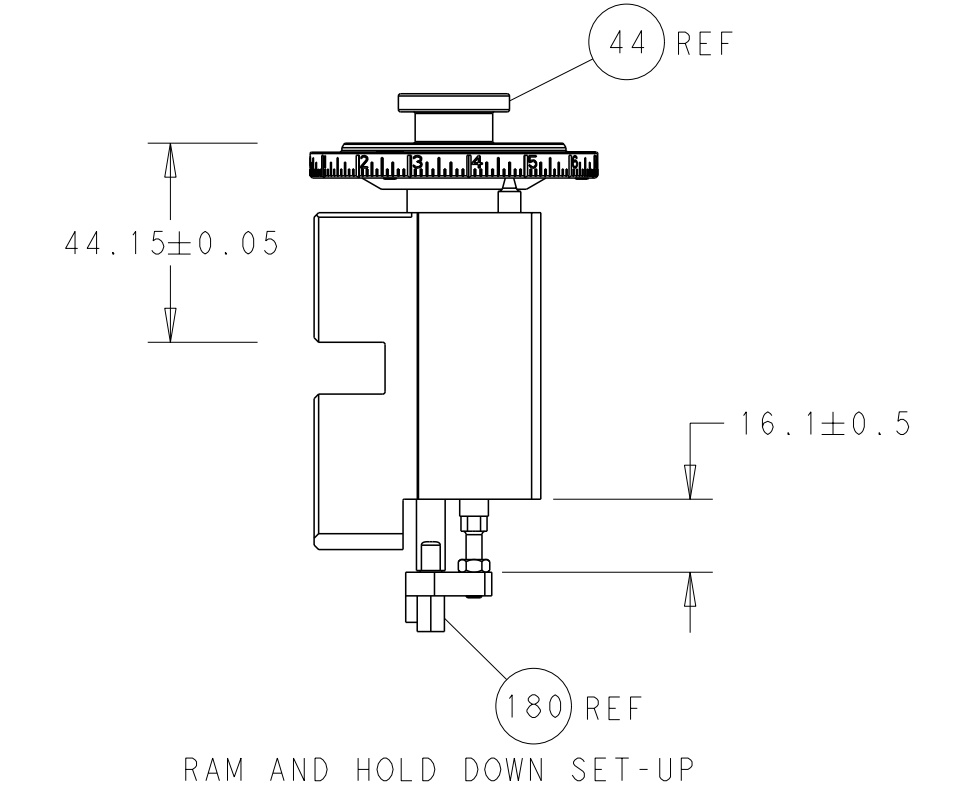
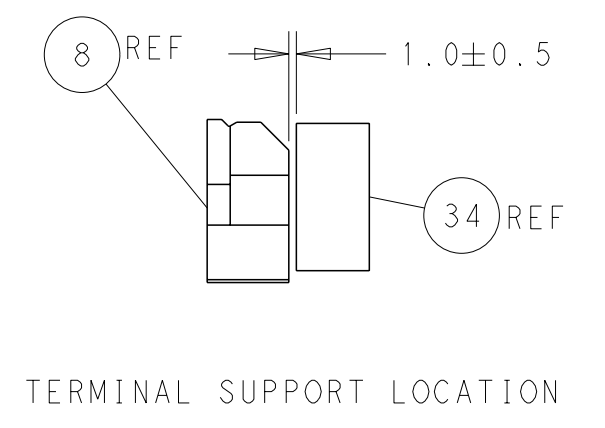
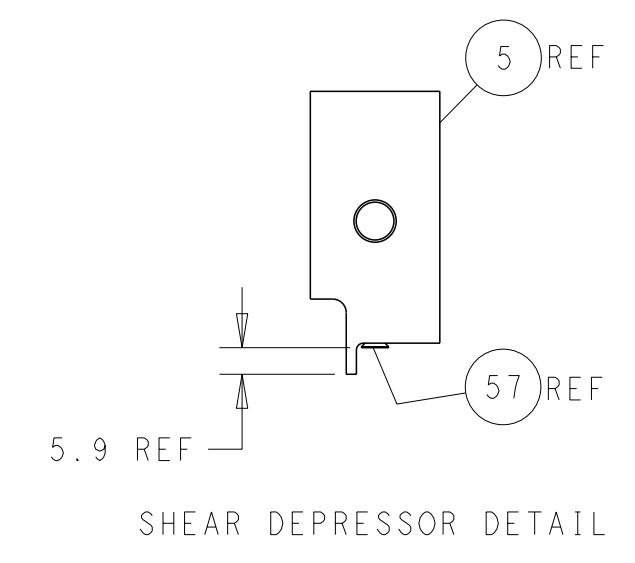
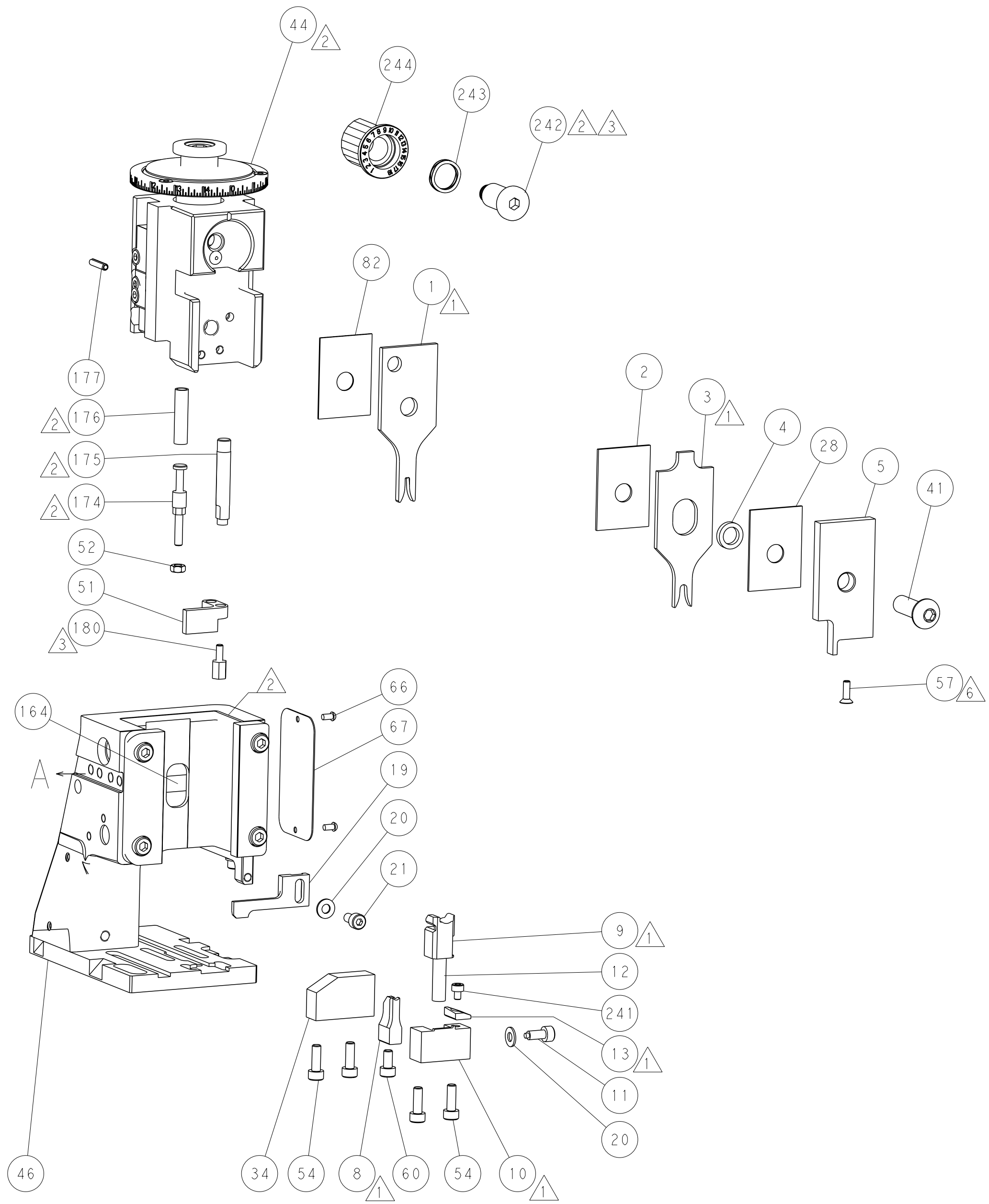
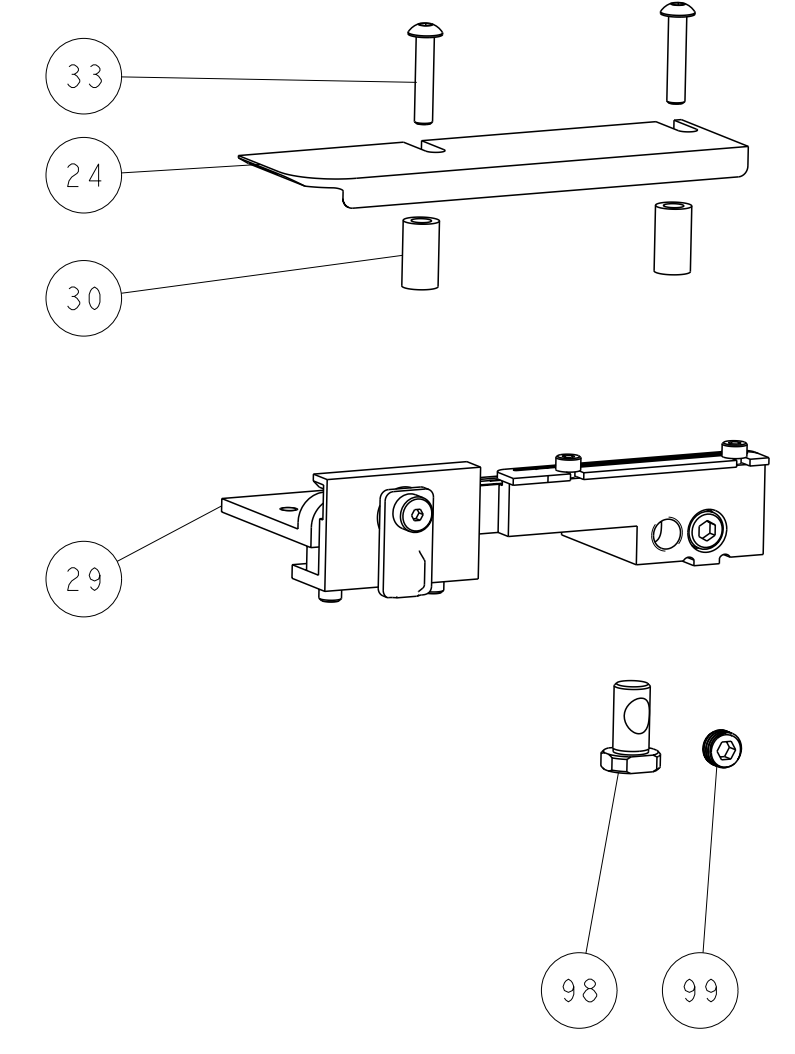
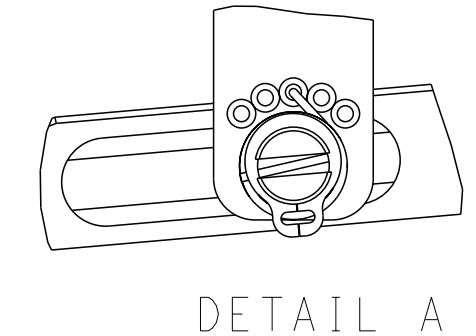
# FEED TYPE MECHANICAL



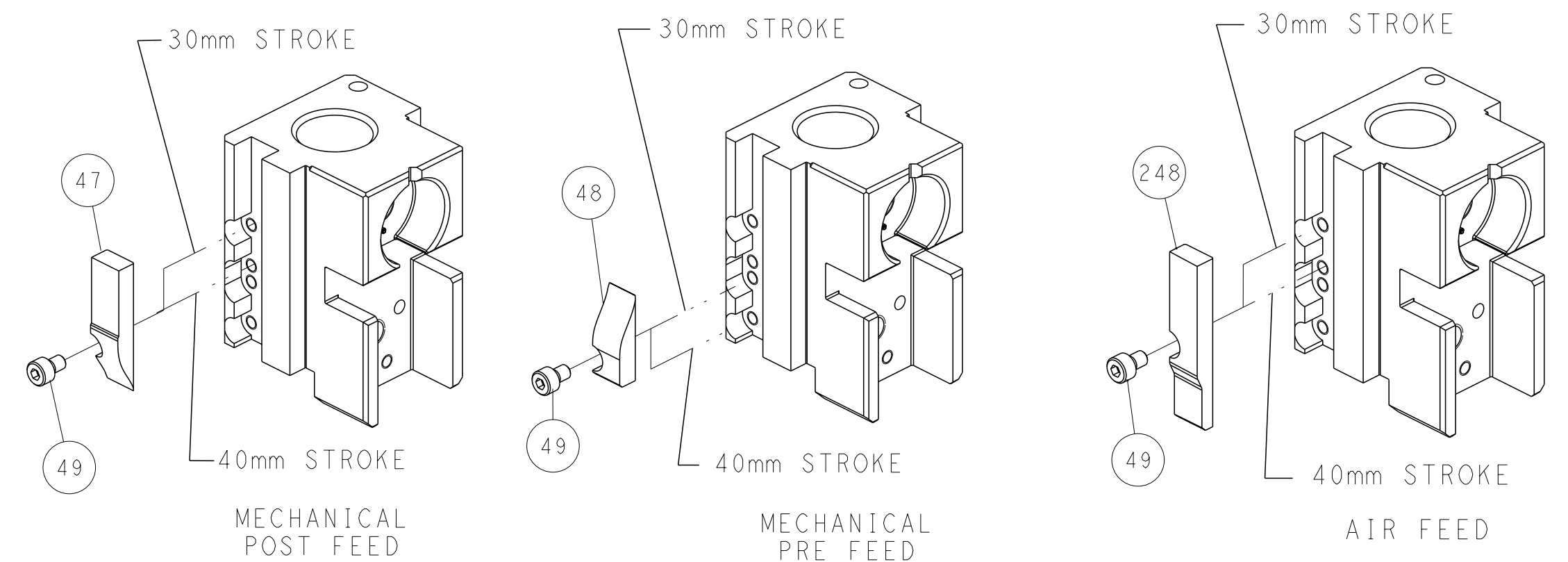
## PNEUMATIC



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



# CAM POSITIONS

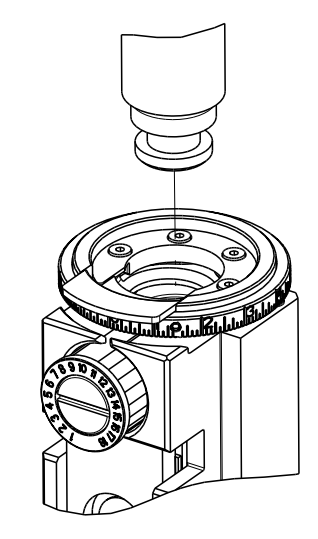


**ATLANTIC VERSION**  
 Shown on sheets 1 of 4 & 2 of 4  
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		OWN: T. BROOKS 12MAY2020 CHK: M. HERR 12MAY2020 APVD: B. KNEPPER 12MAY2020 PRODUCT SPEC APPLICATION SPEC WEIGHT FINISH		NAME: OCEAN 2.0 Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2151995 SCALE: 1:2 SHEET: 2 of 4 REV: A1	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2151995-1	A	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2151995-2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151995-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR  
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.03 mm [.080]	F
INSUL	3.56 mm [.140]	O
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: SUMITOMO TERMINAL SUMITOMO CRIMP SPECIFICATION	
TERMINAL NAME: MALE TERMINAL	
WIRE STRIP LENGTH 3.90-4.10 mm [.154-.161 IN]	TERMINAL INSULATION DIAMETER RANGE Ø1.80-2.20 mm [.071-.087 IN]
TERMINAL APPLICATION SPECIFICATION 8100-3178 Rev -	AT9106

TE TERMINAL	SUMITOMO TERMINAL	TE SEAL	SUMITOMO SEAL	SEAL INSULATION DIAMETER RANGE
2113352-1	8100-3178	2113232-1	7165-0622	1.8-2.2

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.25mm2	1.40 +/- 0.05 [.055 +/- .002]	8.1
1.00mm2	1.25 +/- 0.05 [.049 +/- .002]	9.7
0.85mm2	1.20 +/- 0.05 [.047 +/- .002]	10.2
0.75mm2	1.20 +/- 0.05 [.047 +/- .002]	10.2

- 1. RECOMMENDED SPARE PARTS
- 2. REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND 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. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT 101-35000.
- 6. APPLY TORQ-SEAL IN ALLEN SOCKET TO FILL HOLE AFTER FLAT HD HAS BEEN ADJUSTED TO CORRECT HEIGHT AT QUALIFICATION. APPLY #1-23419-5 LOC-TITE TO THREADS.

**\*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)

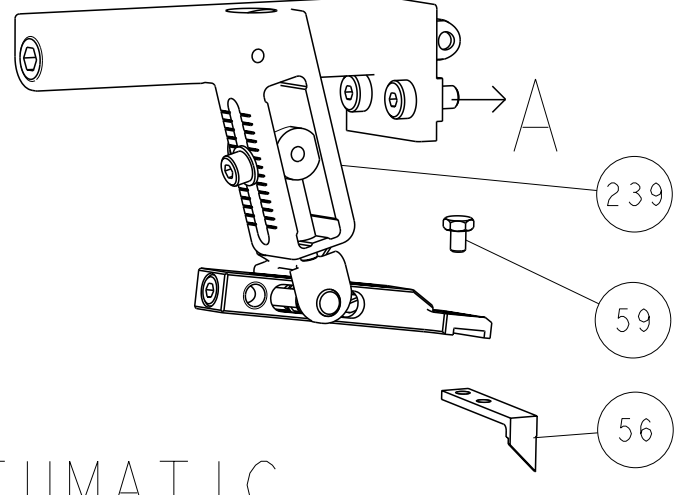
LOC	DIST	REV	DATE	BY	APPV
A	66	-	-	-	-

REV	DATE	BY	APPV	DESCRIPTION	ITEM NO
-	1	1		2119082-9 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
-	1	1		1-1752354-6 STANDOFF, HOLD-DOWN	180
-	1	1		6-993111-6 PIN, SLOTTED SPRING 3.0 X 14.0	177
-	1	1		8-22280-7 SPRING, COMPRESSION	176
-	1	1		1752353-2 GUIDE PIN, HOLDDOWN	175
-	1	1		1901680-2 GUIDE PIN, HOLDDOWN	174
-	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		2844908-1 SCREW, LOCKING	99
-	1	1		2844907-1 POST, LOCKING	98
-	1	1		455888-5 SPACER, CRIMPER	82
-	1	1		1803607-3 DOCUMENTATION PACKAGE	71
-	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		985575-3 SCR, FLT SKT HD CAP M3 X 10.0	57
-	1	1		1338685-1 PAWL, FEED	56
-	1	1		1-5018030-0 NUT, HEX, REG, RoHS, M3.5	52
-	1	1		1901681-1 HOLDDOWN, TERMINAL	51
-	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		1752356-1 SUPPORT, TERMINAL	34
-	2	2		2079383-5 SCR, BHSC, RoHS (M4 X 20)	33
-	2	2		2-2844962-8 SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1		2844992-1 ASSEMBLY, STRIP GUIDE	29
-	1	1		455888-8 SPACER, CRIMPER	28
-	1	1		1320928-2 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		318707-1 FLOATING SHEAR, FRONT	9
-	1	1		1-1633920-6 ANVIL, COMBINATION	8
-	-	-		-	7
-	-	-		-	6
-	1	1		2119781-1 DEPRESSOR, SHEAR	5
-	1	1		238011-4 BLOCK, CRIMPER SPACER	4
-	1	1		1803018-8 CRIMPER, INSULATION O	3
-	1	1		1-455888-0 SPACER, CRIMPER	2
-	1	1		5-456405-6 CRIMPER, WIRE PREMIUM	1

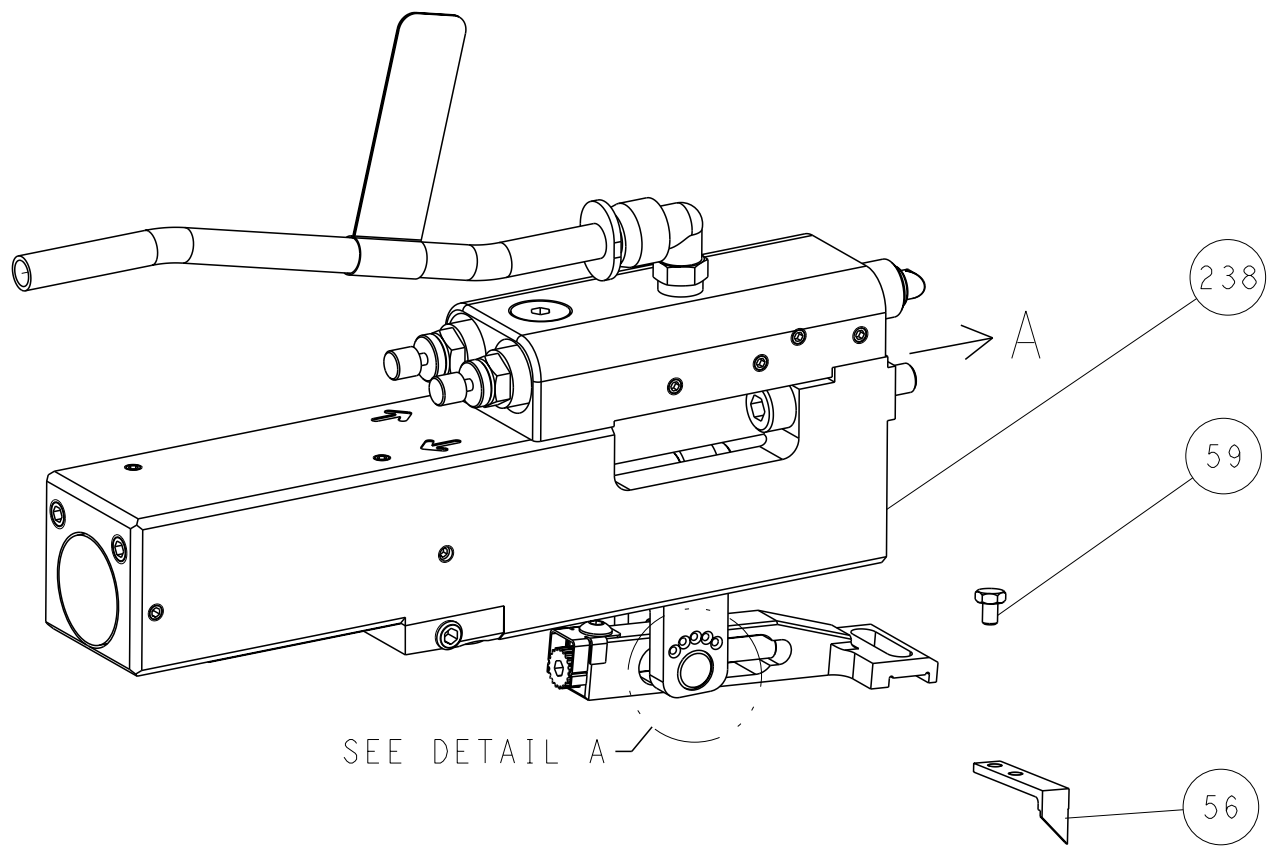
DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH ±		DWN T. BROOKENS 12MAY2020 CHK M. HERR 12MAY2020 APVD B. KNEPPER 12MAY2020 PRODUCT SPEC APPLICATION SPEC		<b>TE</b> TE Connectivity Harrisburg, PA 17105-3608 NAME OCEAN 2.0 Side Feed Applicator	
MATERIAL		WEIGHT		SIZE CAGE CODE DRAWING NO		RESTRICTED TO	
				A1 00779 ©=2151995		Customer Accessible Production Drawing SCALE 1:2 SHEET 3 of 4 REV A1	

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

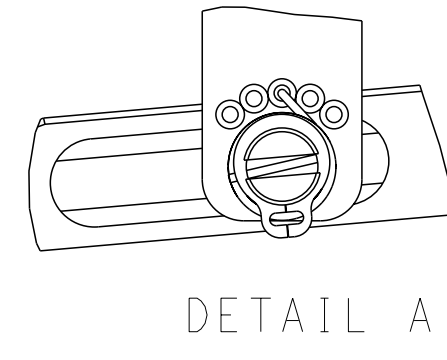
# FEED TYPE MECHANICAL



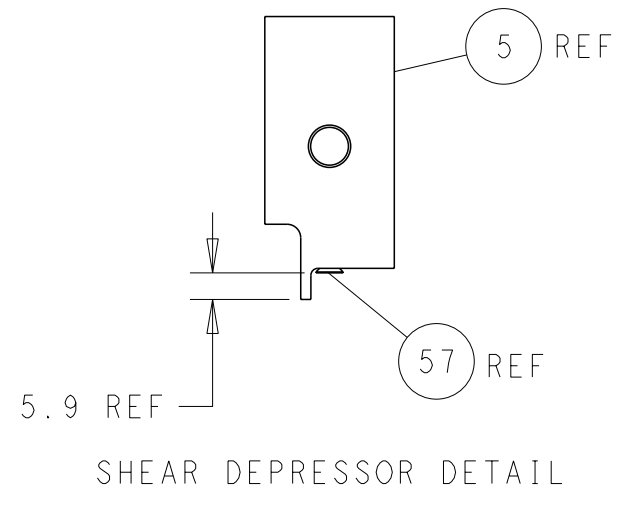
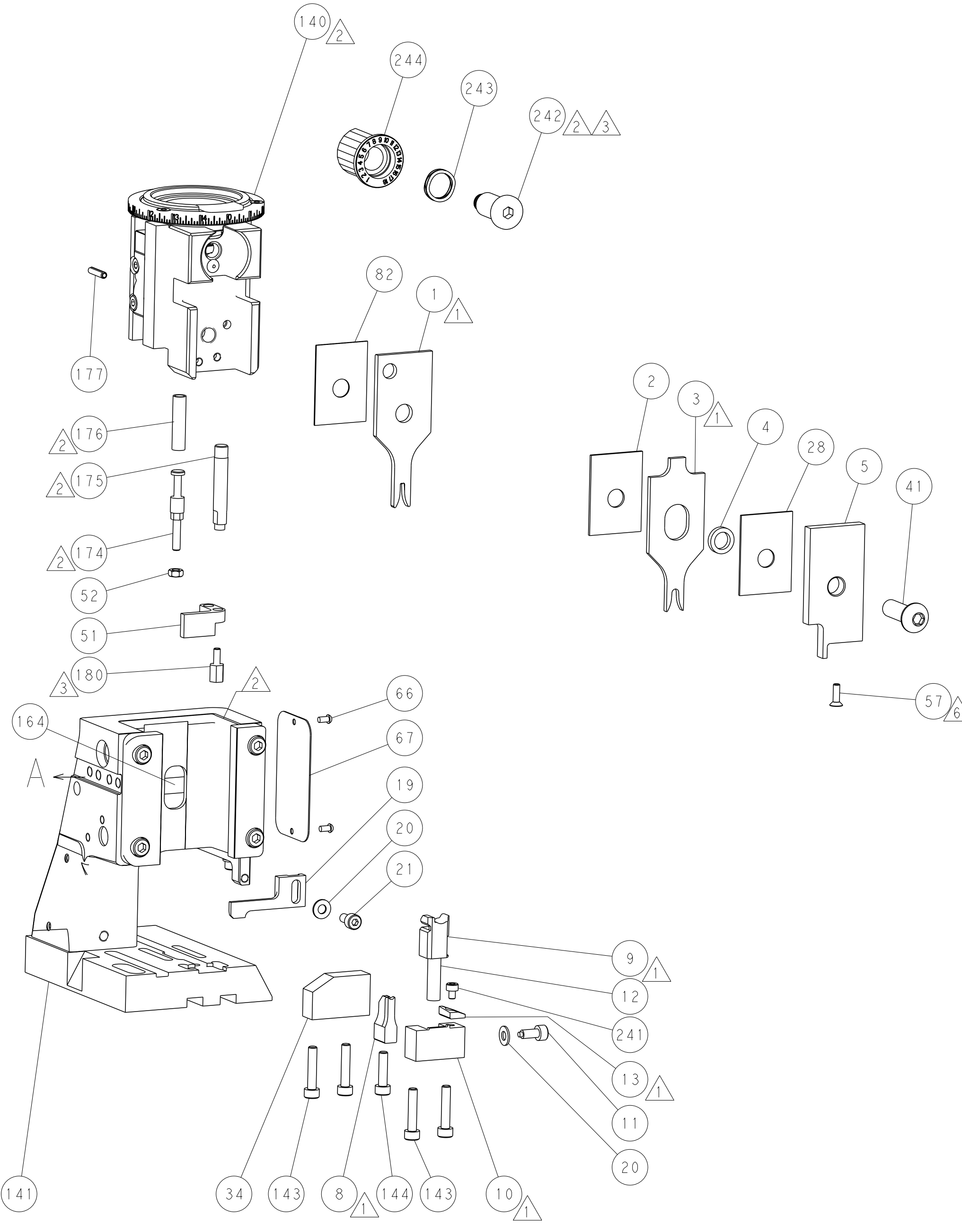
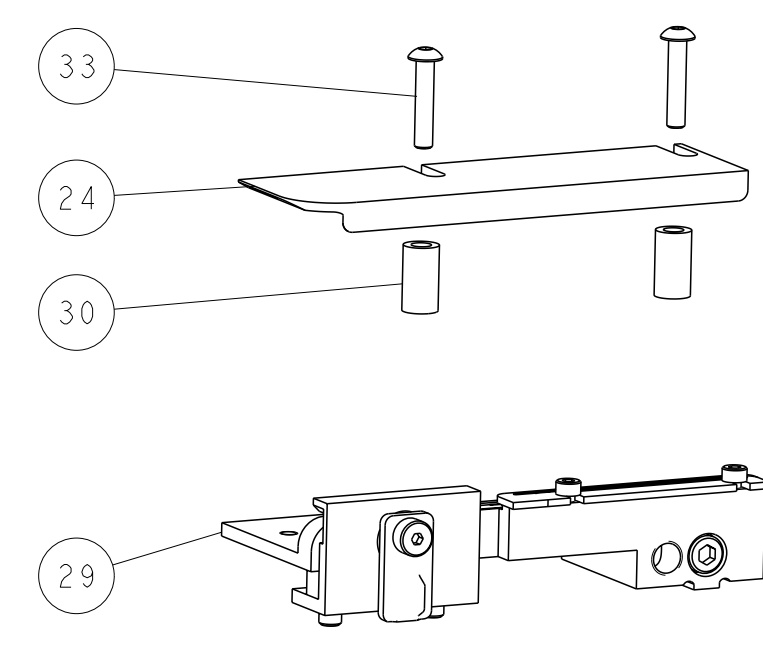
## PNEUMATIC



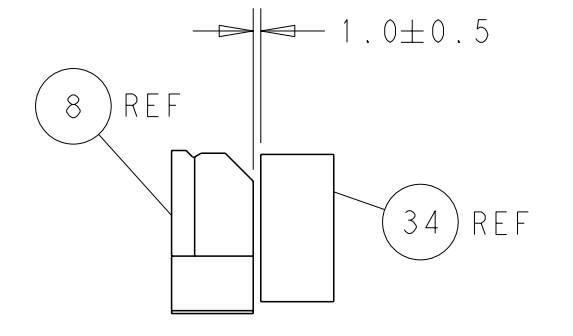
## FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



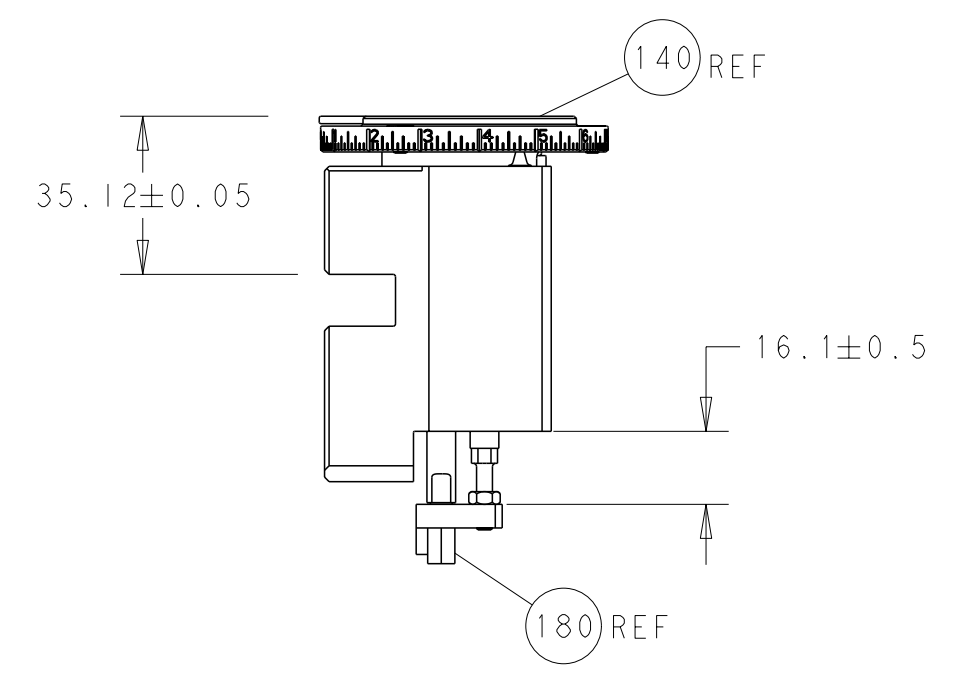
DETAIL A



SHEAR DEPRESSOR DETAIL

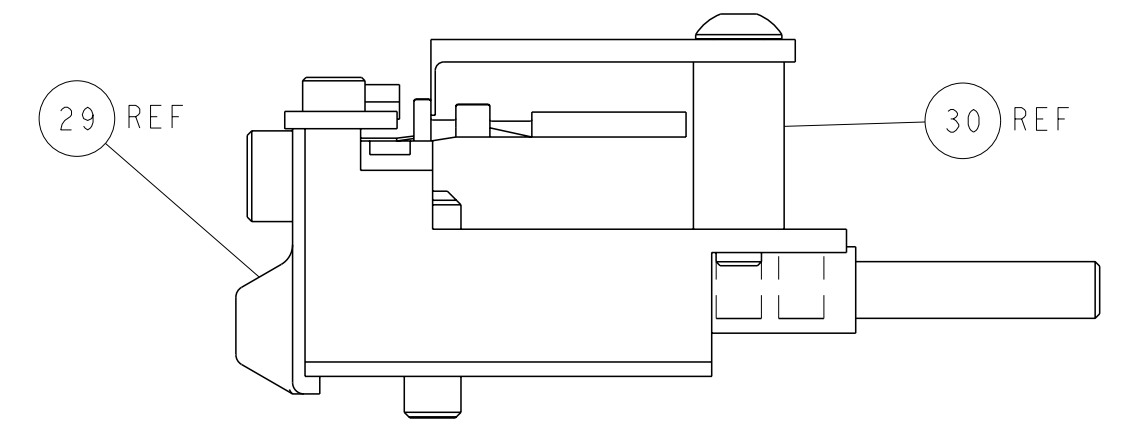


TERMINAL SUPPORT LOCATION



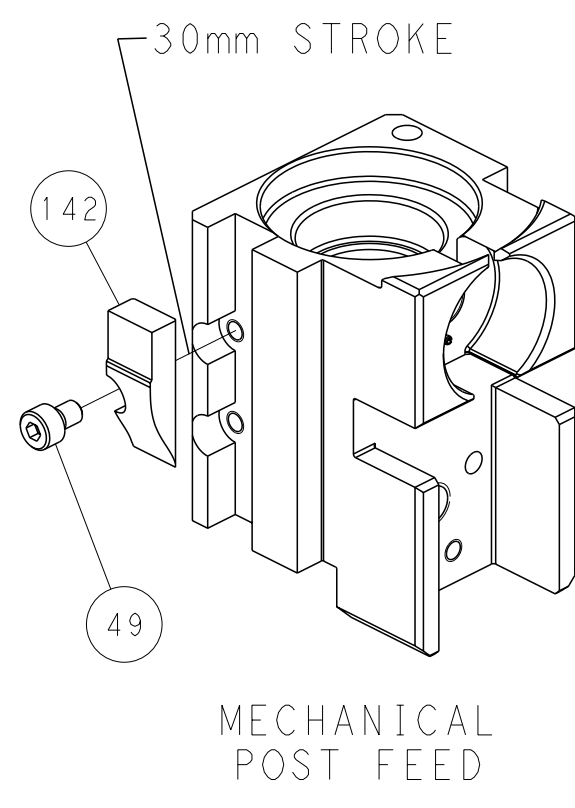
RAM AND HOLD DOWN SET-UP

ITEM 30 LOCATED AT FRONT HOLES

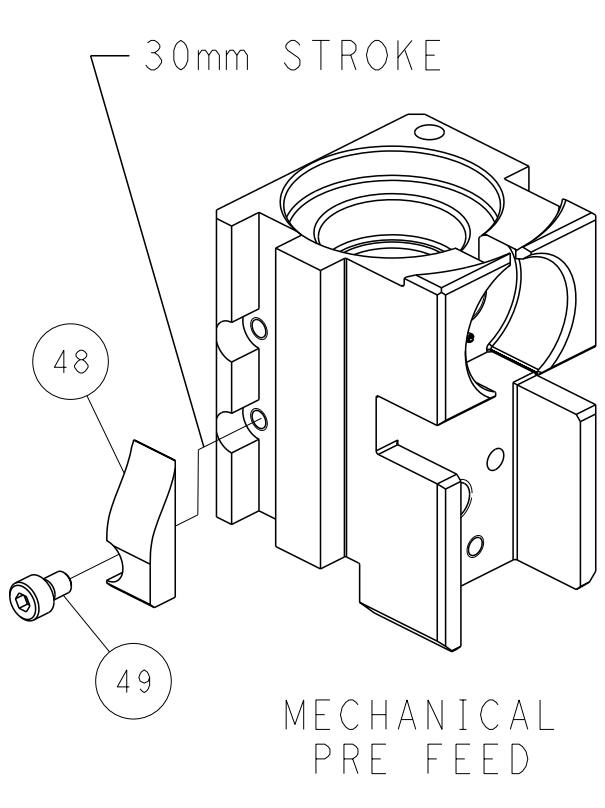


FEED TRACK POSITION GUIDE BY INSULATION BARREL

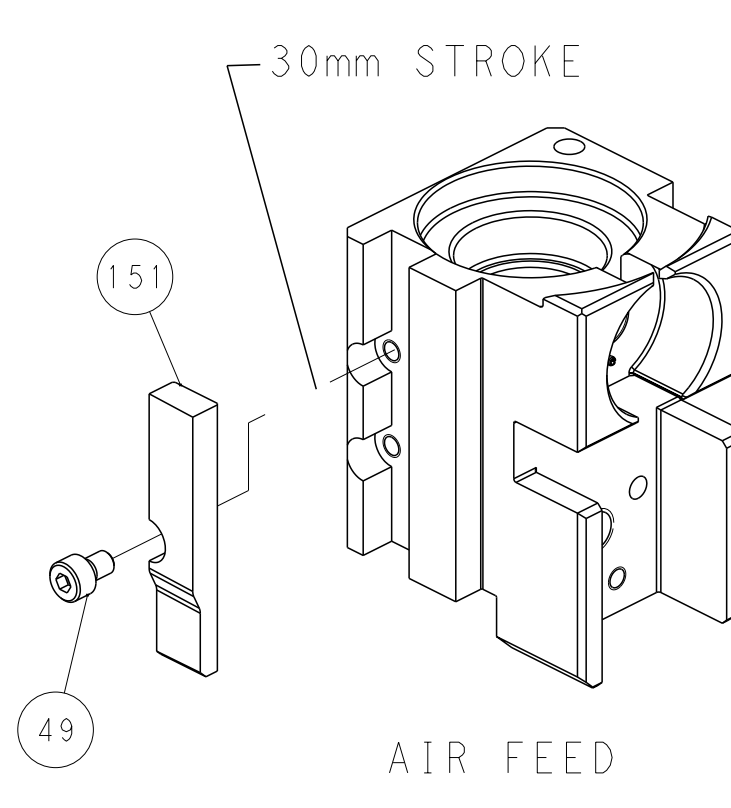
# CAM POSITIONS



MECHANICAL POST FEED



MECHANICAL PRE FEED



AIR FEED

**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 CONTROLLING ENGINEERING ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST REVISION.</small>		DWN T. BROOKS 12MAY2020 CHK M. HERR 12MAY2020 APVD R. KNEPPER 12MAY2020	<b>STE</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 APPLICATION SPEC SIZE CAGE CODE DRAWING NO. A1 00779 ©=2151995 RESTRICTED TO	WEIGHT SCALE 1:2 SHEET 4 OF 4 REV A1	Customer Accessible Production Drawing