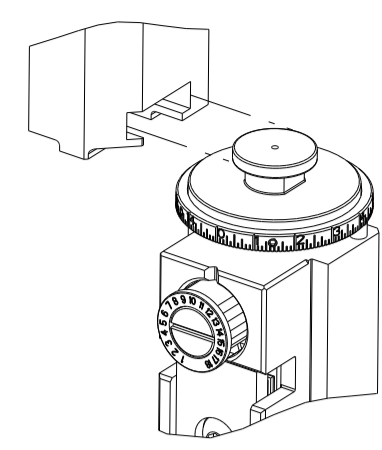


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2837247-1	A	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2837247-2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
5-2837247-1	A	SEAL STRIPPER CRIMPER TERMINATING UNIT	MECHANICAL
5-2837247-2	A	SEAL STRIPPER CRIMPER TERMINATING UNIT	PNEUMATIC
7-2837247-1	A	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2837247-2	A	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2837247-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.40 mm [.055]	F
INSUL	1.78 mm [.070]	F

APPLICATOR INSTRUCTIONS 408-35042

TERMINAL DATA: JST TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: TERMINAL			
WIRE STRIP LENGTH		TERMINAL INSULATION DIAMETER RANGE	
2.63-3.39 mm [.104-.134 IN]		∅0.85-1.43 mm [.033-.056 IN]	
TERMINAL APPLICATION SPECIFICATION	NONE		AT9106
TERMINALS APPLIED			
TE TERMINAL	JST TERMINAL	TE TERMINAL	JST TERMINAL
2113472-1	SF1M-002GC-M0.6A	2113472-2	SF1M-022T-M0.6A

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
24 AWG	0.72 +/- 0.05 [.028 +/- .002]	6.7
26 AWG	0.65 +/- 0.05 [.026 +/- .002]	7.4
28 AWG	0.62 +/- 0.05 [.024 +/- .002]	8.2

- 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.

***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					
A	66	P	LTN	DESCRIPTION	DATE	OWN	APVD
		A		RELEASED	22MAY2023	TB	TE

-	1	1	1	1	1	1	1803945-4	TONKER	300
-	1	1	1	1	1	1	22278-9	SPRING, COMPRESSION	299
-	2	2	2	2	2	2	4-18032-3	SCR, SET, FLT PNT, M3 X 6.0	298
-	1	1	1	1	1	1	1803944-1	SPACER, TONKER	297
-	-	-	-	-	-	-	2-1803583-1	APPLICATOR BASIC ASSEMBLY, SF	292
-	1	1	1	1	1	1	2119791-5	DEPRESSOR, WIRE	286
-	1	-	-	-	-	-	2119641-1	FEED CAM, AIR FEED	248
-	1	1	1	1	1	1	2119082-5	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	1	1	1	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
-	-	-	-	-	-	-	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	1	-	-	-	-	-	2844940-1	AIR FEED MODULE	238
-	REF	REF	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	1	1	1	1	1	1	2844908-1	SCREW, LOCKING	99
-	1	1	1	1	1	1	2844907-1	POST, LOCKING	98
-	1	1	1	1	1	1	455888-4	SPACER, CRIMPER	82
-	1	1	1	1	1	1	1803607-3	DOCUMENTATION PACKAGE	71
-	1	1	1	1	1	1	2119740-1	TAG, IDENTIFICATION	67
-	2	2	2	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	1	1	1	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	60
-	1	1	1	1	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	1	1	1	1	1	1	1338685-1	PAWL, FEED	56
-	4	4	4	4	4	4	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	54
-	2	2	2	2	2	2	2-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 14	53
-	1	2	1	2	1	2	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	-	-	-	-	-	-	2119652-1	FEED CAM, PRE FEED	48
-	-	-	-	-	-	-	2119653-1	FEED CAM, POST FEED	47
-	1	1	-	-	-	-	1803583-9	APPLICATOR BASIC ASSEMBLY, SF	46
-	1	1	1	1	1	1	1803515-1	RAM ASSEMBLY, SF ATLANTIC	44
-	1	1	1	1	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
-	1	1	1	1	1	1	1752356-6	SUPPORT, TERMINAL	34
-	2	2	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	2	2	2	2	2-2844962-4	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	1	1	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29
-	1	1	1	1	1	1	1320928-2	STRIP GUIDE	24
-	1	1	-	-	-	-	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
-	2	2	1	1	2	2	1-18028-2	WASHER, FLAT, REG M4	20
-	1	1	-	-	-	-	2119533-1	STRIPPER, SIDE FEED	19
-	1	1	1	1	1	1	2119806-1	INSERT, SHEAR	13
-	1	1	1	1	1	1	3-22280-3	SPRING, COMPRESSION	12
-	1	1	1	1	1	1	1-356885-4	STOP, SHEAR	11
-	1	1	1	1	1	1	2119805-1	SHEAR HOLDER, FRONT	10
-	1	1	1	1	1	1	1633861-1	SHEAR, FLOATING	9
-	1	2	2	1	1	1	2-1633917-7	ANVIL, COMBINATION	8
-	1	1	1	1	1	1	4-240641-2	SPACER	7
-	-	-	-	-	-	-	-	-	6
-	1	1	1	1	1	1	2119757-4	DEPRESSOR, SHEAR	5
-	1	1	1	1	1	1	2-238011-3	BLOCK, CRIMPER SPACER	4
-	1	2	2	1	1	1	3-1633962-3	CRIMPER, INSULATION F PREMIUM	3
-	1	1	1	1	1	1	455888-7	SPACER, CRIMPER	2
-	1	2	2	1	1	1	3-1633713-4	CRIMPER, WIRE PREMIUM	1

ITEM NO	PART NO	DESCRIPTION	ITEM NO
-77	-72	-71	-52
-51	-2	-1	

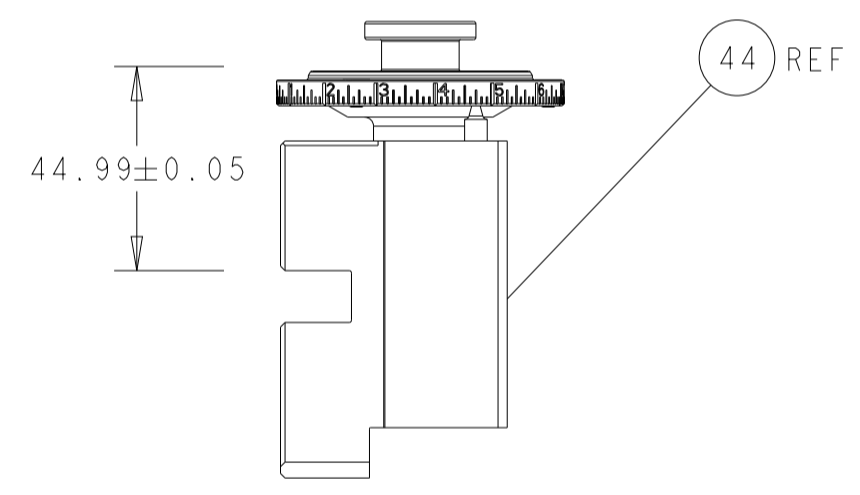
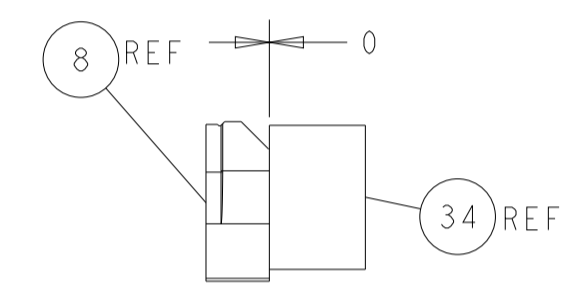
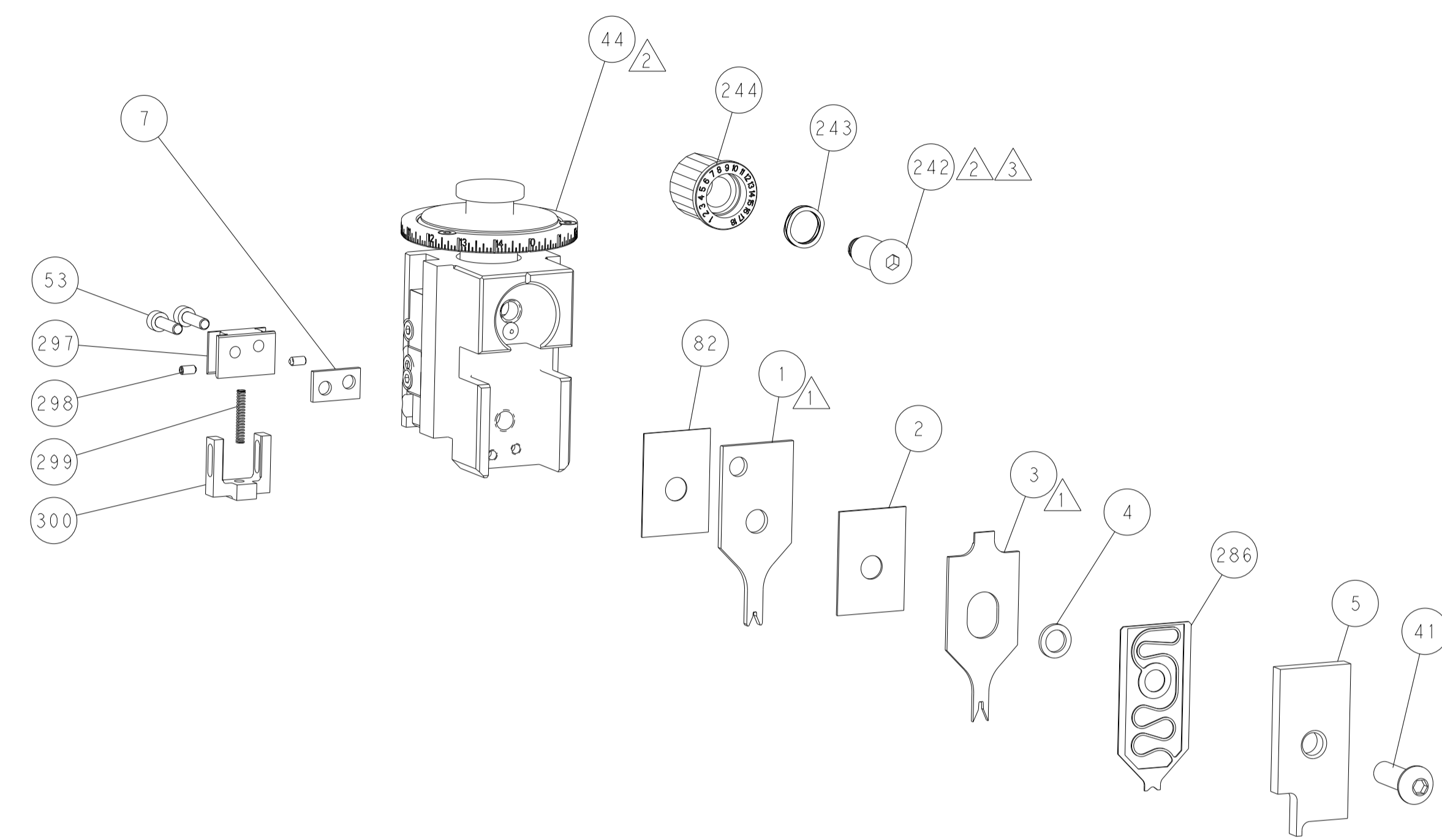
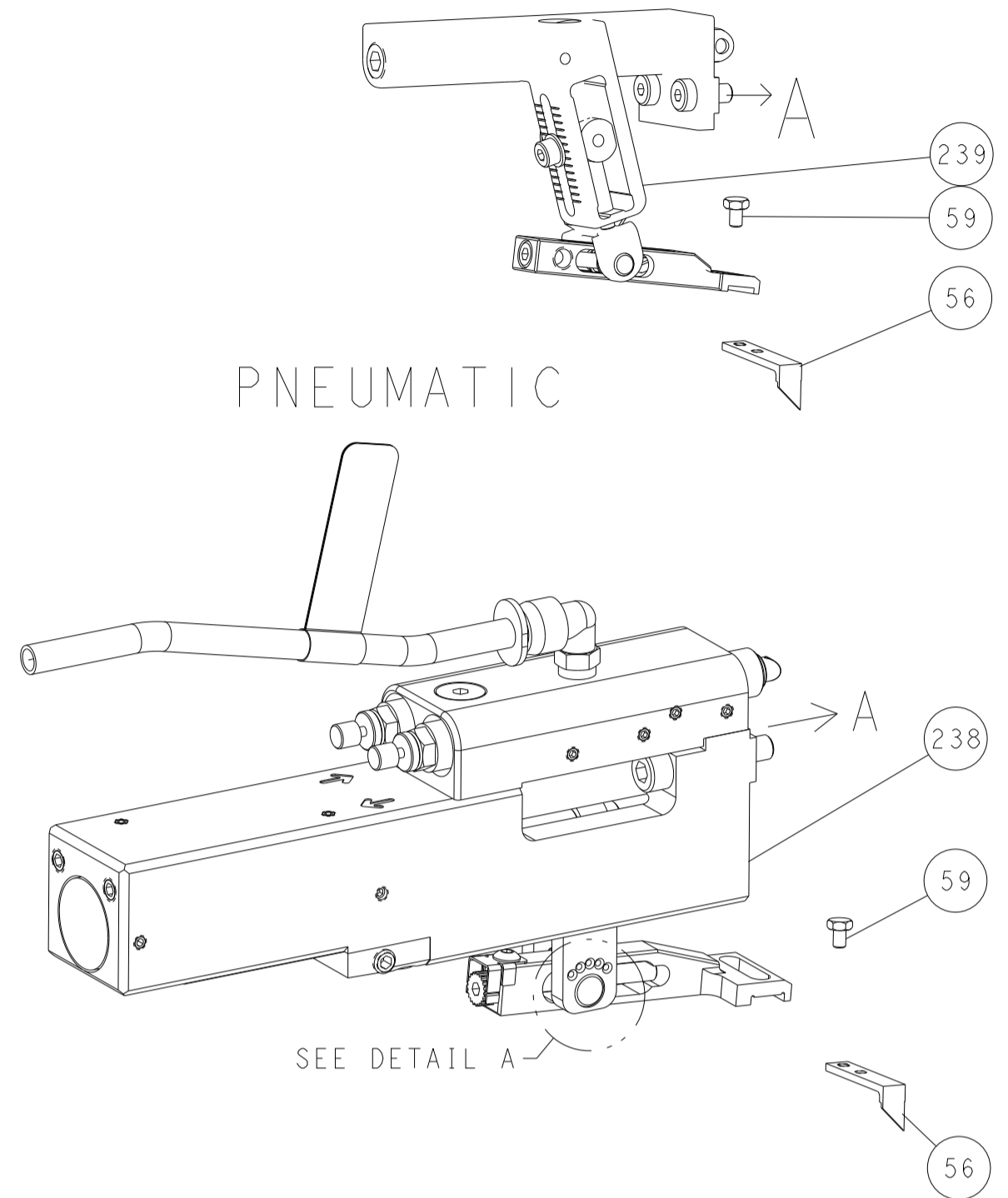
CHK T. BROOKENS	22MAY2023	OWN	T. BROOKENS	22MAY2023
CHK R. KNEPPER	22MAY2023	APVD	T. ELBIN	22MAY2023

TE Connectivity	Harrisburg, PA 17105-3608		
OCEAN 2.0 Side Feed Applicator			
SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
A	00779	2837247	

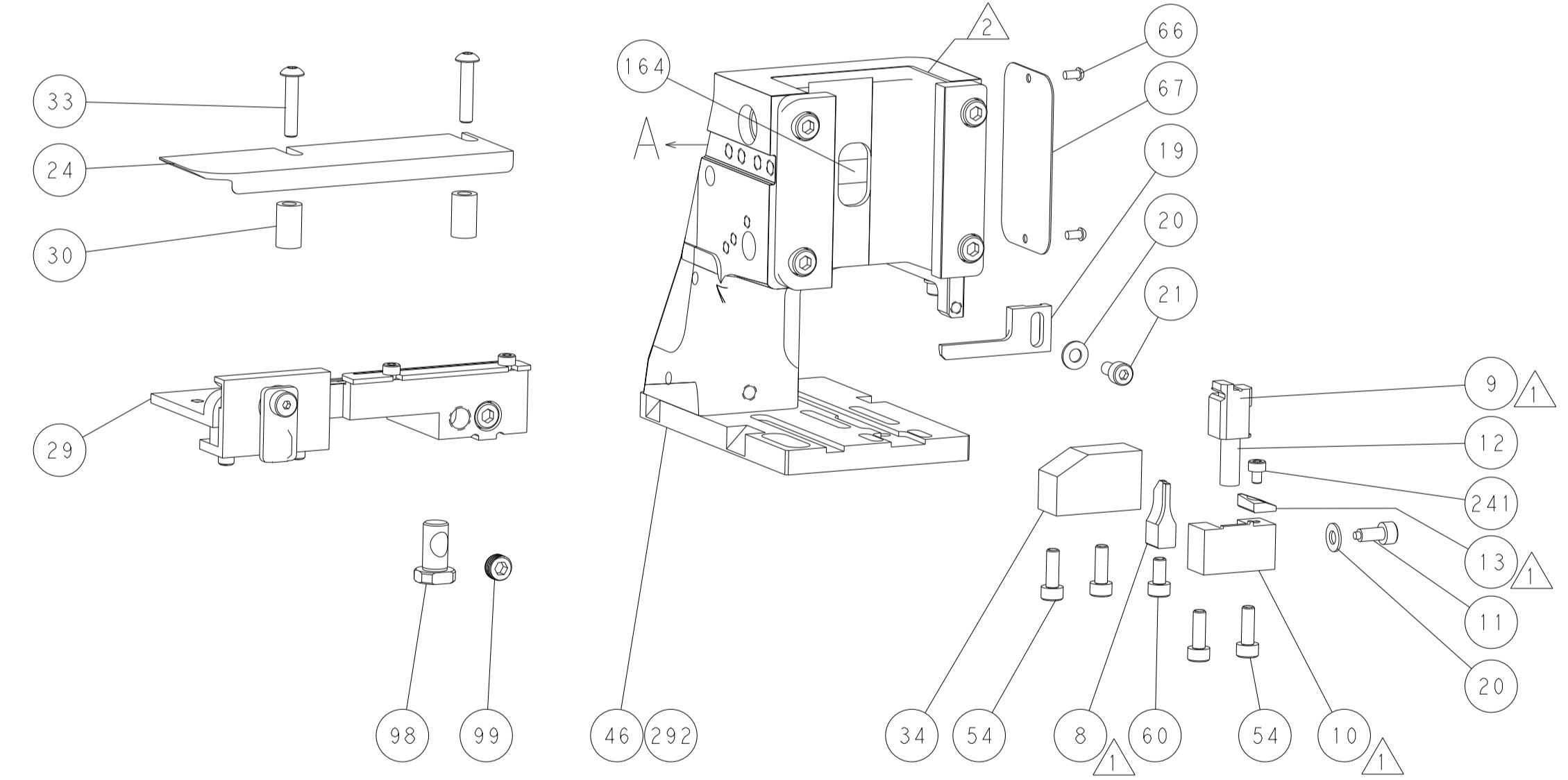
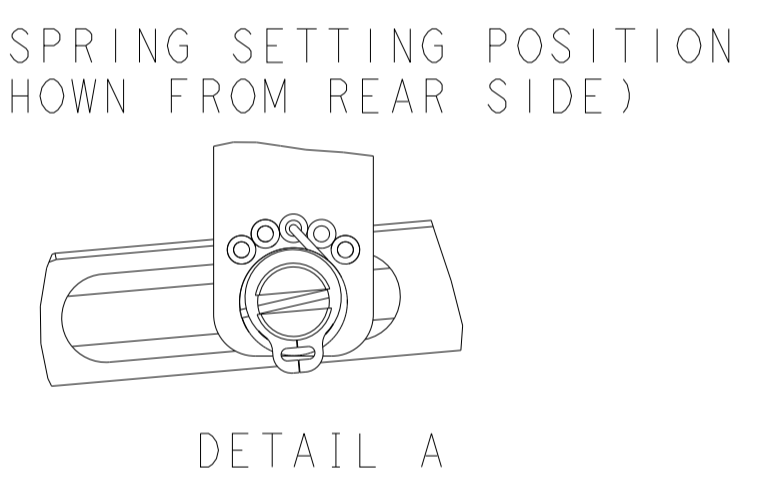
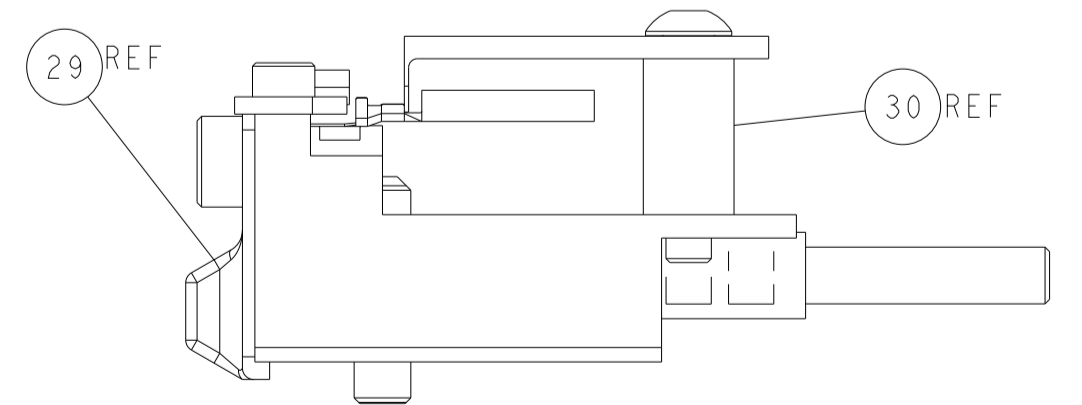
Customer Accessible Production Drawing SCALE 1:2 SHEET 1 OF 4 REV A

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

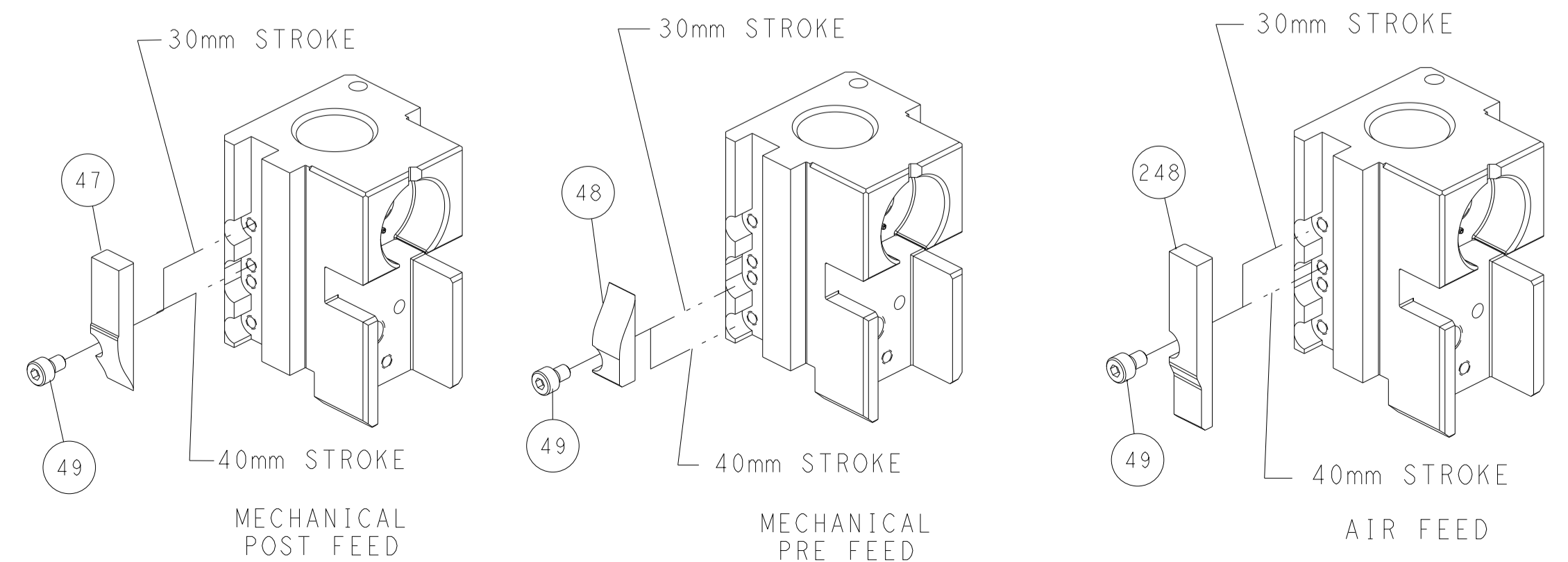
FEED TYPE MECHANICAL



ITEM 30 LOCATED AT FRONT HOLES



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 THE PROPERTY OF TYCO ELECTRONICS CORPORATION AND IS NOT TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, INCLUDING PHOTOCOPYING, RECORDING, OR BY ANY INFORMATION STORAGE AND RETRIEVAL SYSTEM, WITHOUT THE WRITTEN PERMISSION OF TYCO ELECTRONICS CORPORATION.</small>		DWN T. BROOKS 22MAY2023 CHK R. KNEPPER 22MAY2023 APVD T. ELBIN 22MAY2023	STE 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 A 00779 C=2837247	WEIGHT Customer Accessible Production Drawing	RESTRICTED TO SCALE 1:2 SHEET 2 OF 4 REV A

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2837247-1	A	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2837247-2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2837247-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
 INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.40 mm [.055]	F
INSUL	1.78 mm [.070]	F

APPLICATOR INSTRUCTIONS
 408-35042

TERMINAL DATA: JST TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: TERMINAL			
WIRE STRIP LENGTH 2.63-3.39 mm [1.04-.134 IN]		TERMINAL INSULATION DIAMETER RANGE Ø0.85-1.43 mm [.033-.056 IN]	
TERMINAL APPLICATION SPECIFICATION	NONE	AT9106	
TERMINALS APPLIED			
TE TERMINAL	JST TERMINAL	TE TERMINAL	JST TERMINAL
2113472-1	SF1M-002GC-M0.6A	2113472-2	SF1M-022T-M0.6A

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
24 AWG	0.72+/-0.05 [.028+/-0.002]	6.7
26 AWG	0.65+/-0.05 [.026+/-0.002]	7.4
28 AWG	0.62+/-0.05 [.024+/-0.002]	8.2

- 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. 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.

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

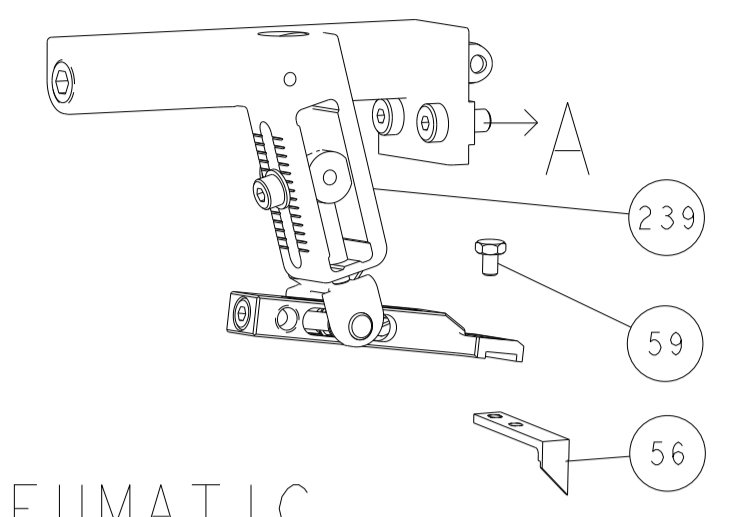
LOC	DIST	REVISIONS					
		P	LTN	DESCRIPTION	DATE	DWN	APVD
A	66	-	-	SEE SHEET 1	-	-	-

-	1	1	1803945-4	TONKER	300	
-	1	1	22278-9	SPRING, COMPRESSION	299	
-	2	2	4-18032-3	SCR, SET, FLT PNT, M3 X 6.0	298	
-	1	1	1803944-1	SPACER, TONKER	297	
-	1	1	2119791-5	DEPRESSOR, WIRE	286	
-	1	1	2119082-5	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	2844908-1	SCREW, LOCKING	99	
-	1	1	2844907-1	POST, LOCKING	98	
-	1	1	455888-4	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	1338685-1	PAWL, FEED	56	
-	2	2	2-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 14	53	
-	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	1752356-6	SUPPORT, TERMINAL	34	
-	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33	
-	2	2	2-2844962-4	SPACER, CYLINDRICAL, STRIP GUIDE	30	
-	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29	
-	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	1633861-1	SHEAR, FLOATING	9	
-	1	1	1	2-1633917-7	ANVIL, COMBINATION	8
-	1	1	4-240641-2	SPACER	7	
-	-	-	-	-	6	
-	1	1	2119757-4	DEPRESSOR, SHEAR	5	
-	1	1	2-238011-3	BLOCK, CRIMPER SPACER	4	
-	1	1	3-1633962-3	CRIMPER, INSULATION F PREMIUM	3	
-	1	1	455888-7	SPACER, CRIMPER	2	
-	1	1	3-1633713-4	CRIMPER, WIRE PREMIUM	1	

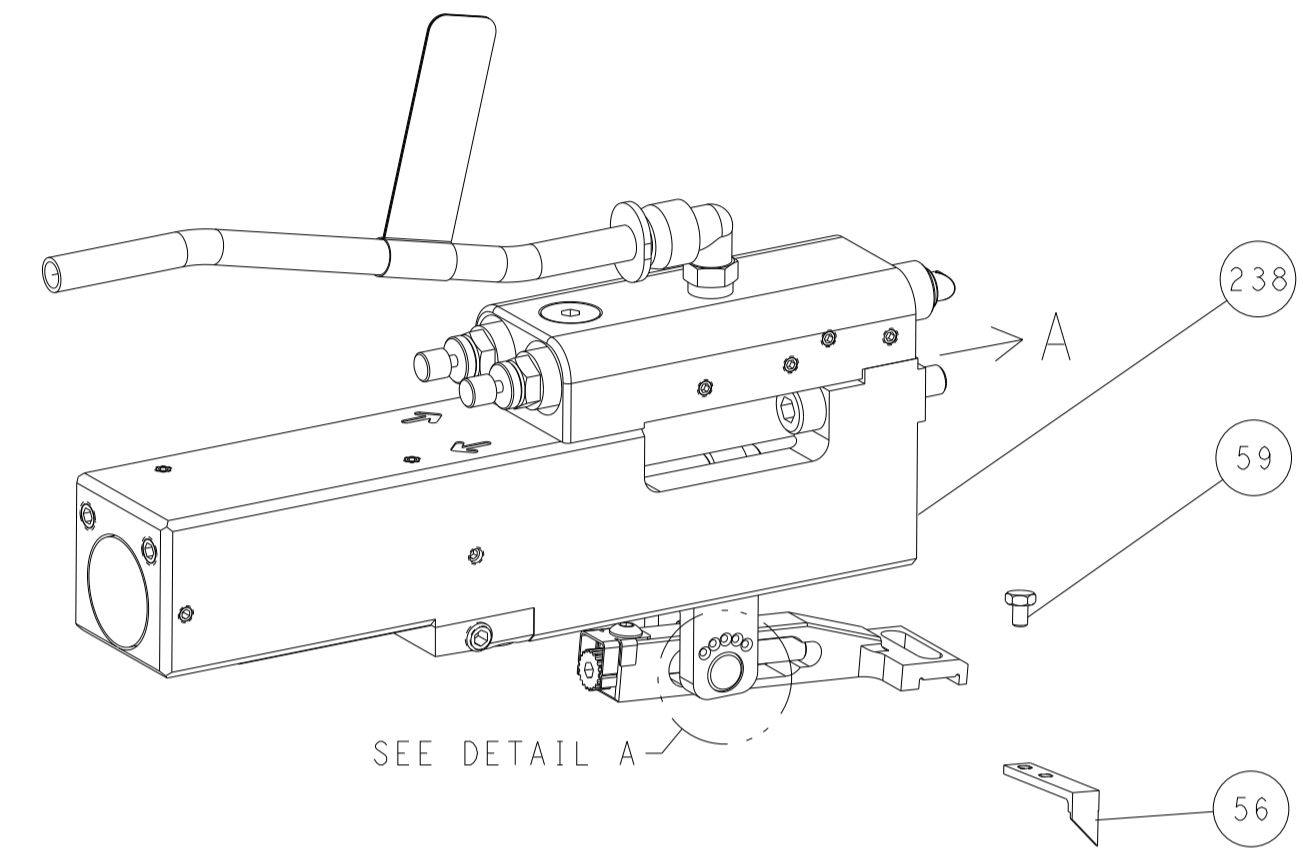
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0 PLC ±		0.15		CHK R. KNEPPER 22MAY2023		Harrisburg, PA 17105-3608	
1 PLC ±		0.25		APVD T. ELBIN 22MAY2023		NAME	
2 PLC ±		0.38		PRODUCT SPEC		OCEAN 2.0 Side Feed	
3 PLC ±		0.51		APPLICATION SPEC		Applicator	
4 PLC ±		0.76		WEIGHT		SIZE CAGE CODE DRAWING NO RESTRICTED TO	
ANGLES		±		A 00779 C=2837247		3 of 4	
FINISH		-		Customer Accessible Production Drawing		SCALE 1:2 SHEET 3 of 4 REV A	

LOC		DIST		REVISIONS			
P	LTN	DESCRIPTION	DATE	OWN	APVD		
-	-	SEE SHEET 1	-	-	-		

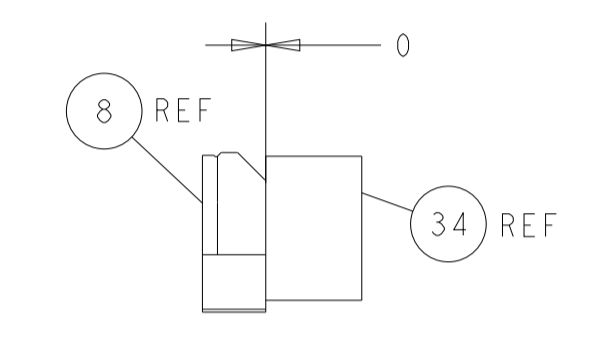
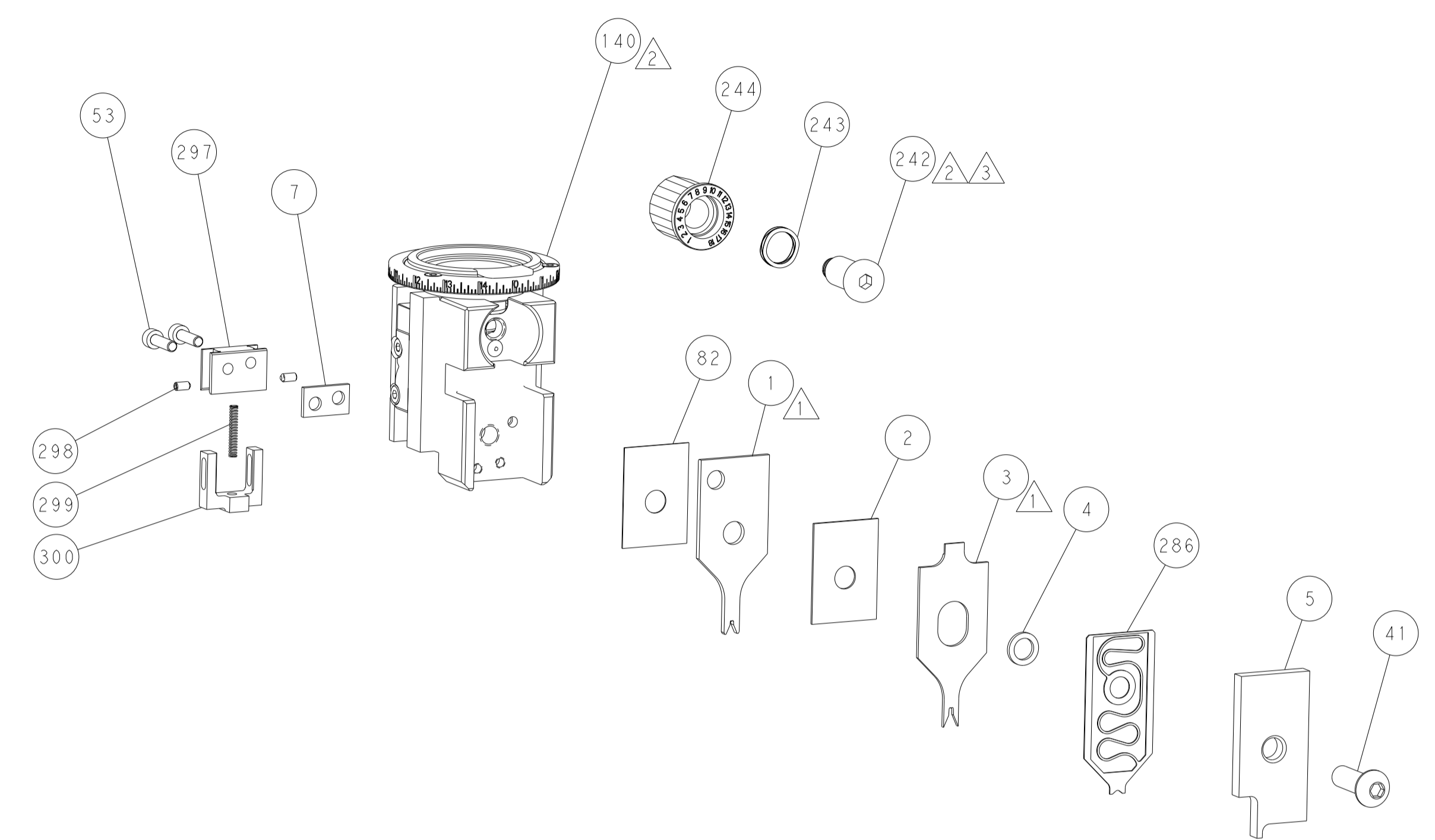
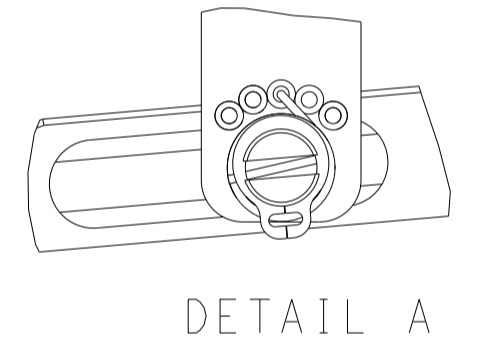
FEED TYPE MECHANICAL



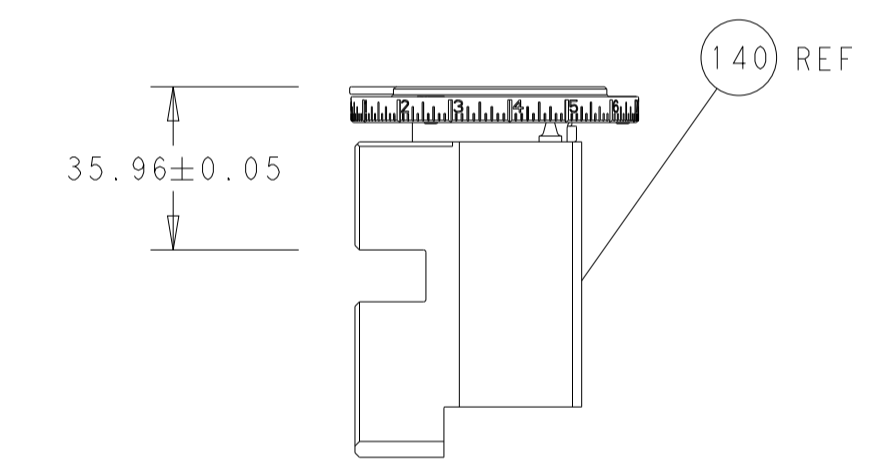
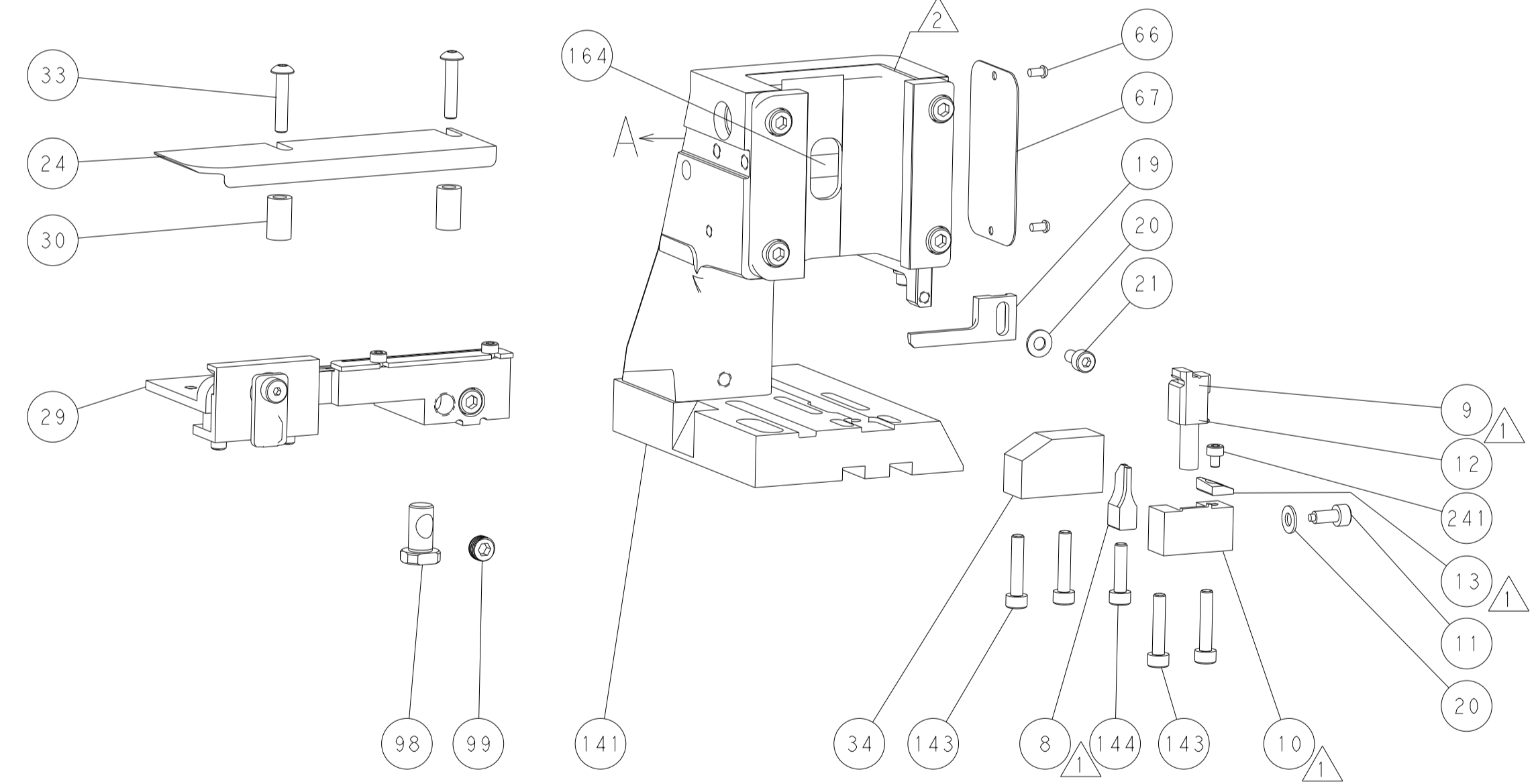
PNEUMATIC



FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)

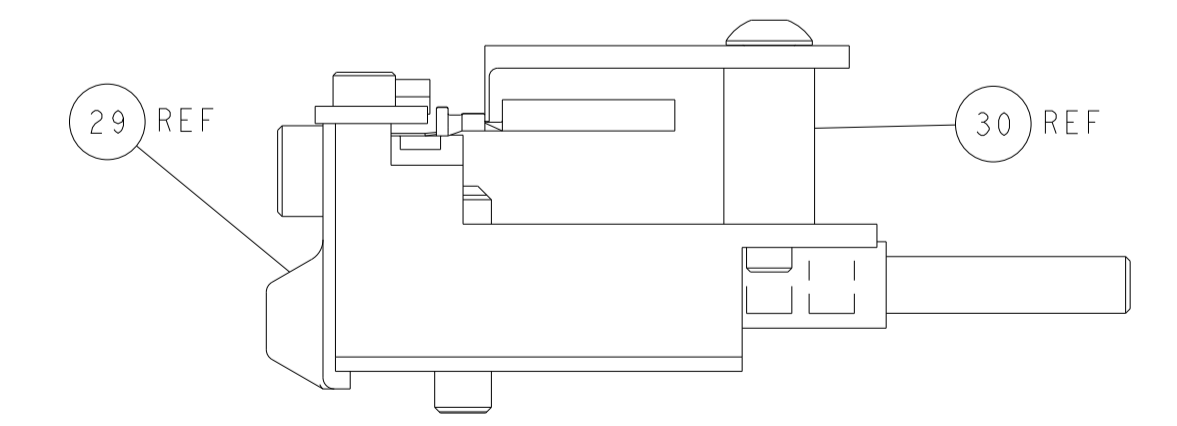


TERMINAL SUPPORT LOCATION



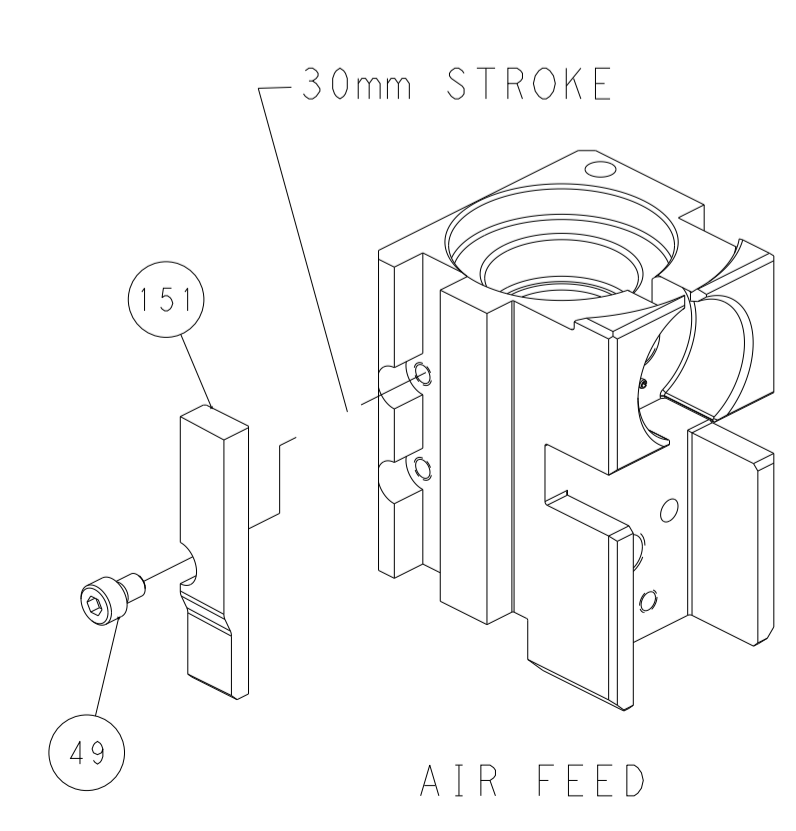
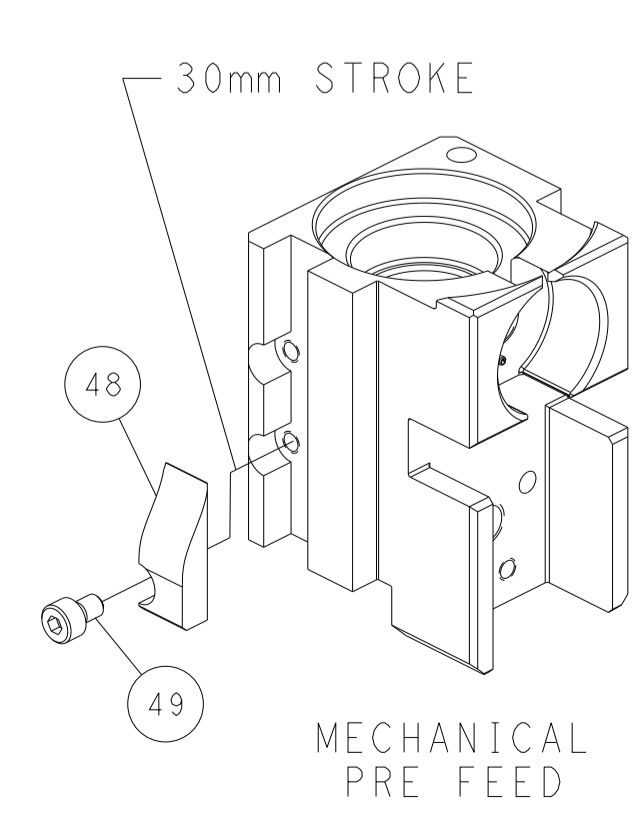
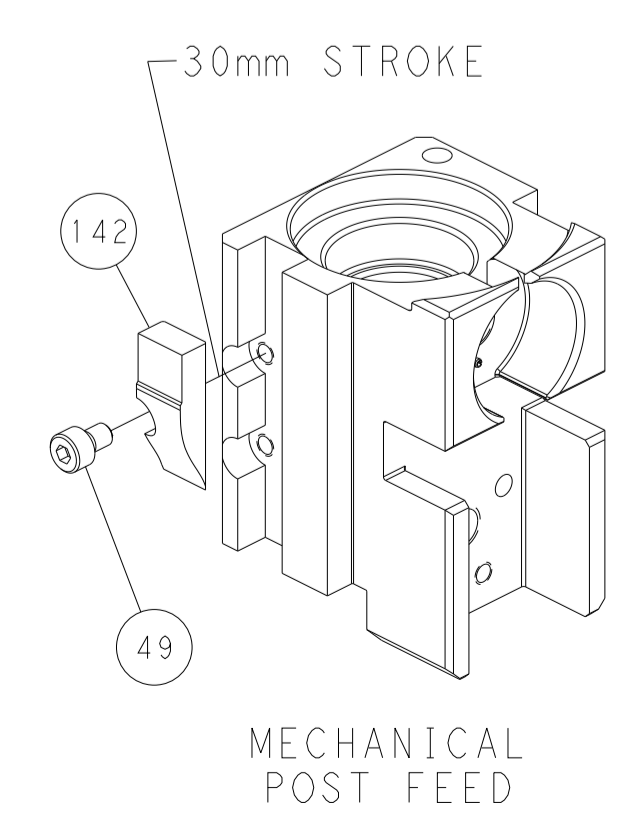
RAM SET-UP

ITEM 30 LOCATED AT FRONT HOLES



FEED TRACK POSITION GUIDE BY WIRE BARREL

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:		DWG T. BROOKS 22MAY2023		TE Connectivity	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	CHK R. KNEPPER 22MAY2023	Harrisburg, PA 17105-3608
MATERIAL:		FINISH:		APVD T. ELBIN 22MAY2023		NAME OCEAN 2.0 Side Feed Applicator	
Customer Accessible Production Drawing		SCALE 1:2		SIZE A 00779 C=2837247		RESTRICTED TO	
				SHEET 4 OF 4		REV A	