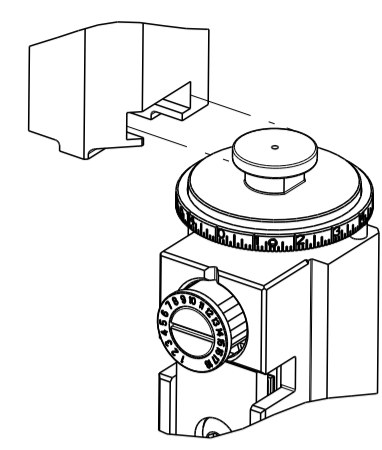


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2837249-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2837249-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
5-2837249-1	C	SEAL STRIPPER CRIMPER TERMINATING UNIT	MECHANICAL
5-2837249-2	C	SEAL STRIPPER CRIMPER TERMINATING UNIT	PNEUMATIC
7-2837249-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA

CRIMP	SIZE	TYPE
WIRE	1.40 mm [.055]	F
INSUL	1.40 mm [.055]	F

APPLICATOR INSTRUCTIONS  
408-35042

TERMINAL DATA: MOLEX TERMINAL MOLEX CRIMP SPECIFICATION

TERMINAL NAME: Mini Fit Pin/Socket

WIRE STRIP LENGTH	TERMINAL INSULATION DIAMETER RANGE
2.60-3.36 mm [.102-.132 IN]	Ø0.94-1.09 mm [.037-.043 IN]

TERMINAL APPLICATION SPECIFICATION 63902-3800 Rev B

TERMINALS APPLIED

TE TERMINAL	MOLEX TERMINAL	TE TERMINAL	MOLEX TERMINAL
1572221-1	39-00-0046	1572222-1	39-00-0048
1572221-2	39-00-0065	1572222-2	39-00-0067
1572221-7	39-00-0183	1572222-4	39-00-0128
1572221-8	39-00-0209	1572222-5	39-00-0221
1572221-9	39-00-0215	1572222-6	39-00-0432
1-1572221-1	39-00-0091	1572222-9	39-00-0145
1-1572221-2	39-00-0139	1-1572222-0	40-01-0854
1-1572221-8	39-00-0434	1-1572222-1	98-00-0175

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
22 AWG OR 0.35mm2	0.80+/-0.035 [.031+/- .001]	5.8
24 AWG OR 0.20mm2	0.73+/-0.035 [.029+/- .001]	6.5
26 AWG OR 0.12mm2	0.69+/-0.035 [.027+/- .001]	6.9
28 AWG OR 0.08mm2	0.66+/-0.035 [.026+/- .001]	7.3

TERMINAL DATA: MOLEX TERMINAL MOLEX CRIMP SPECIFICATION

TERMINAL NAME: Mini Fit Pin/Socket

WIRE STRIP LENGTH	TERMINAL INSULATION DIAMETER RANGE
2.60-3.36 mm [.102-.132 IN]	Ø0.94-1.09 mm [.037-.043 IN]

TERMINAL APPLICATION SPECIFICATION 63902-3800 Rev B

TERMINALS APPLIED

TE TERMINAL	MOLEX TERMINAL	TE TERMINAL	MOLEX TERMINAL
1-1572221-9	46018-2541		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
22 AWG OR 0.35mm2	0.80+/-0.035 [.031+/- .001]	5.8
24 AWG OR 0.20mm2	0.73+/-0.035 [.029+/- .001]	6.5



- 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.

**\*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.

LOC	DIST	REV	DATE	BY	CHK	APPD
A	66					

REV	DATE	BY	CHK	APPD	DESCRIPTION	ITEM NO
A	16MAY2019	T. BROOKENS			RELEASED	293
B	05JUN2019	M. HERR			ECR-19-008853	292
C	08JUL2024				ECR-24-214131	286

-	1	1	-	-	1803515-3	RAM ASSEMBLY, SF ATLANTIC	293
-	1	1	-	-	2-1803583-1	APPLICATOR BASIC ASSEMBLY, SF	292
-	1	1	1	1	2119791-5	DEPRESSOR, WIRE	286
-	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	-	-	4-1722335-3	STRIPPER, SIDE FEED	182
-	1	1	-	-	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	181
-	1	1	-	-	1-1752354-8	STANDOFF,HOLD-DOWN	180
-	1	1	-	-	9931111-1	PIN, SLOTTED SPRING 3.0 X 20.0	177
-	1	1	-	-	5-22280-0	SPRING, COMPRESSION	176
-	1	1	-	-	1752353-3	GUIDE PIN,HOLDDOWN	175
-	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	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	1338685-1	PAWL, FEED	56
-	4	4	4	4	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	54
-	2	2	2	2	2-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 14	53
-	1	1	1	1	5018030-1	NUT, HEX, REG, RoHS, M3	52
-	1	1	1	1	811242-5	BUMPER, HOLD DOWN	51
-	1	1	1	1	690753-2	SPACER, TONKER	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	1803583-9	APPLICATOR BASIC ASSEMBLY, SF	46
-	-	-	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	2-2844962-6	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	1320928-2	STRIP GUIDE -	24
-	-	-	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
-	1	1	2	2	1-18028-2	WASHER, FLAT, REG M4	20
-	-	-	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	1	1	1	3-1633917-8	ANVIL, COMBINATION	8
-	1	1	1	1	3-240641-7	SPACER	7
-	-	-	-	-	-	-	6
-	1	1	1	1	2119757-5	DEPRESSOR, SHEAR	5
-	1	1	1	1	238011-7	BLOCK, CRIMPER SPACER	4
-	1	1	1	1	1633961-2	CRIMPER, INSULATION F PREMIUM	3
-	1	1	1	1	455888-4	SPACER, CRIMPER -	2
-	1	1	1	1	1-456402-0	CRIMPER, WIRE PREMIUM	1

THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION. THIS IS THE PROPERTY OF TYCO ELECTRONICS CORPORATION. IT IS TO BE USED ONLY FOR THE PURPOSES AND IN THE MANNER SPECIFIED HEREIN. IT IS TO BE RETURNED TO TYCO ELECTRONICS CORPORATION IF IT IS NOT TO BE USED IN THE MANNER SPECIFIED HEREIN.

OWNER: T. BROOKENS 16MAY2019  
 CHK: M. HERR 16MAY2019  
 APVD: C. TOPPER 16MAY2019

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

MATERIAL: -  
 FINISH: -

WEIGHT: -  
 SCALE: A | 00779 C=2837249

Customer Accessible Production Drawing

TE Connectivity  
 Harrisburg, PA 17105-3608

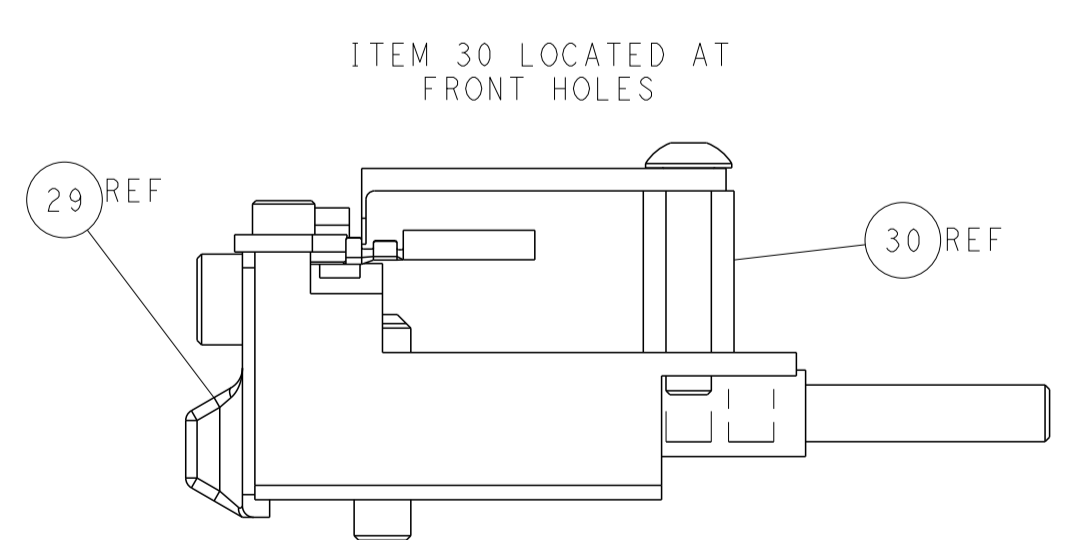
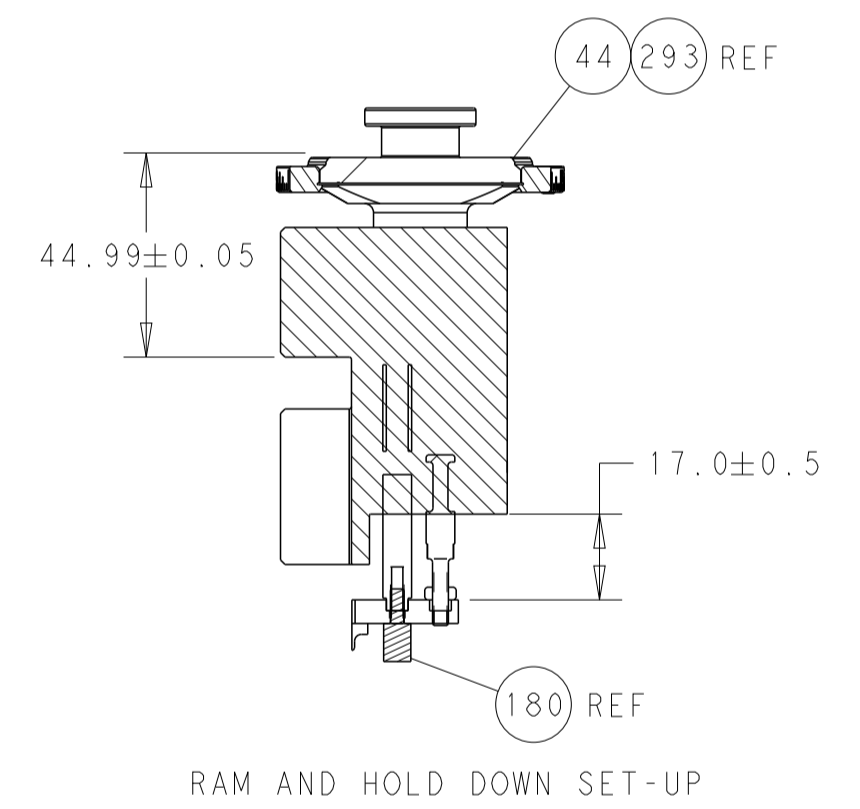
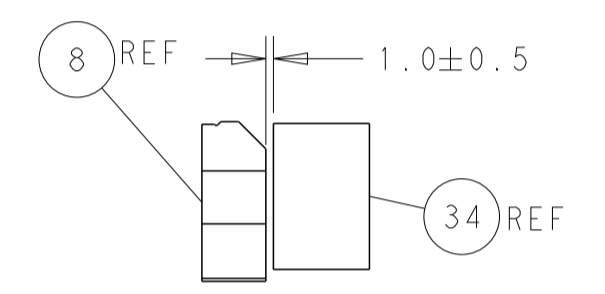
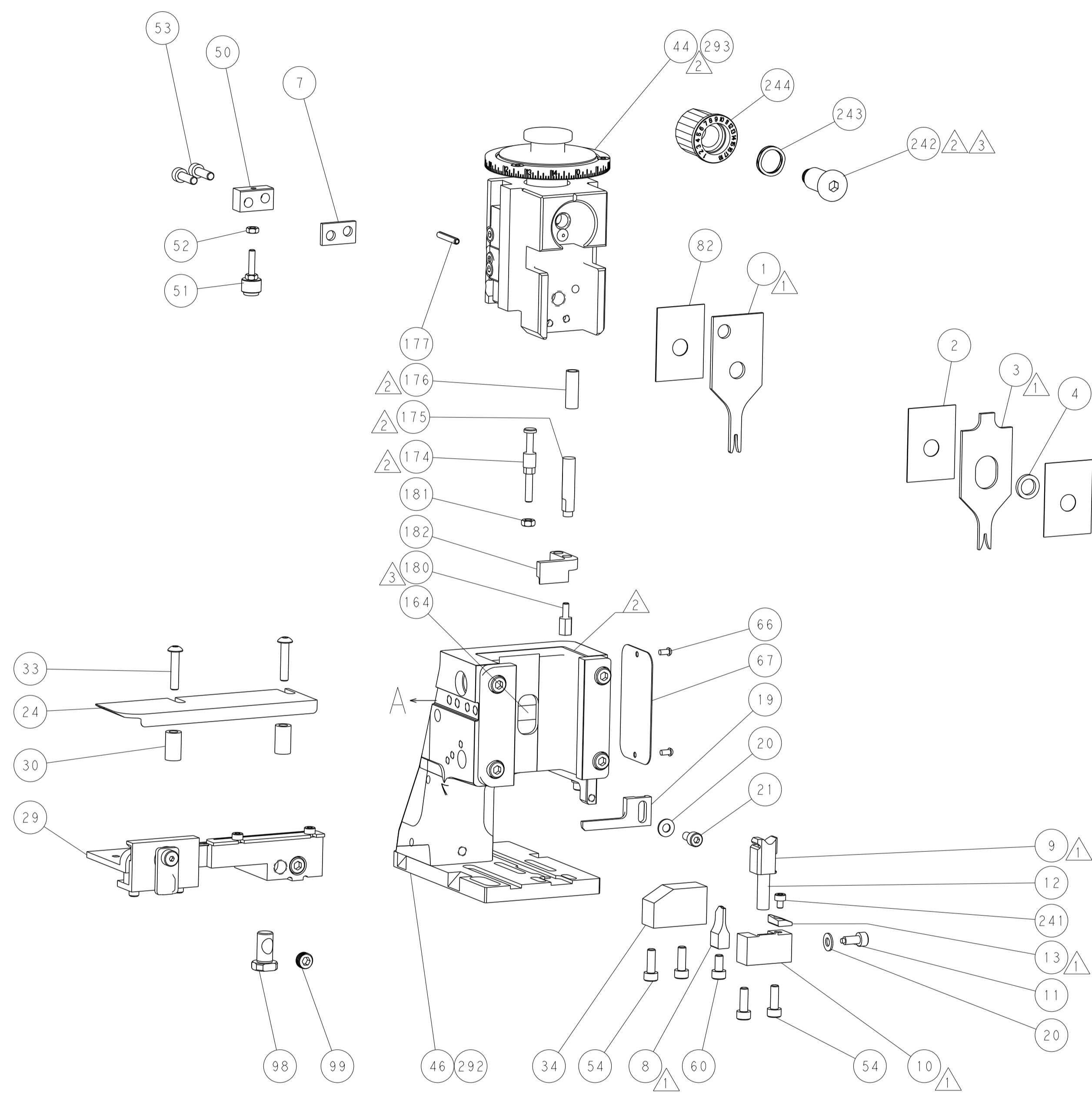
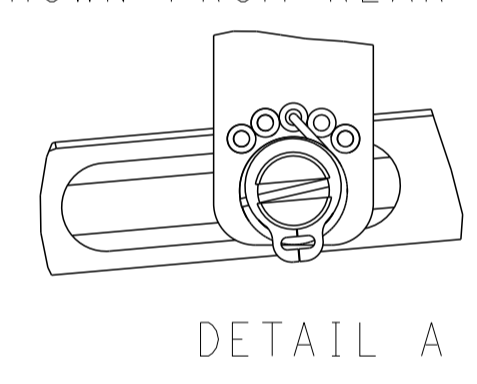
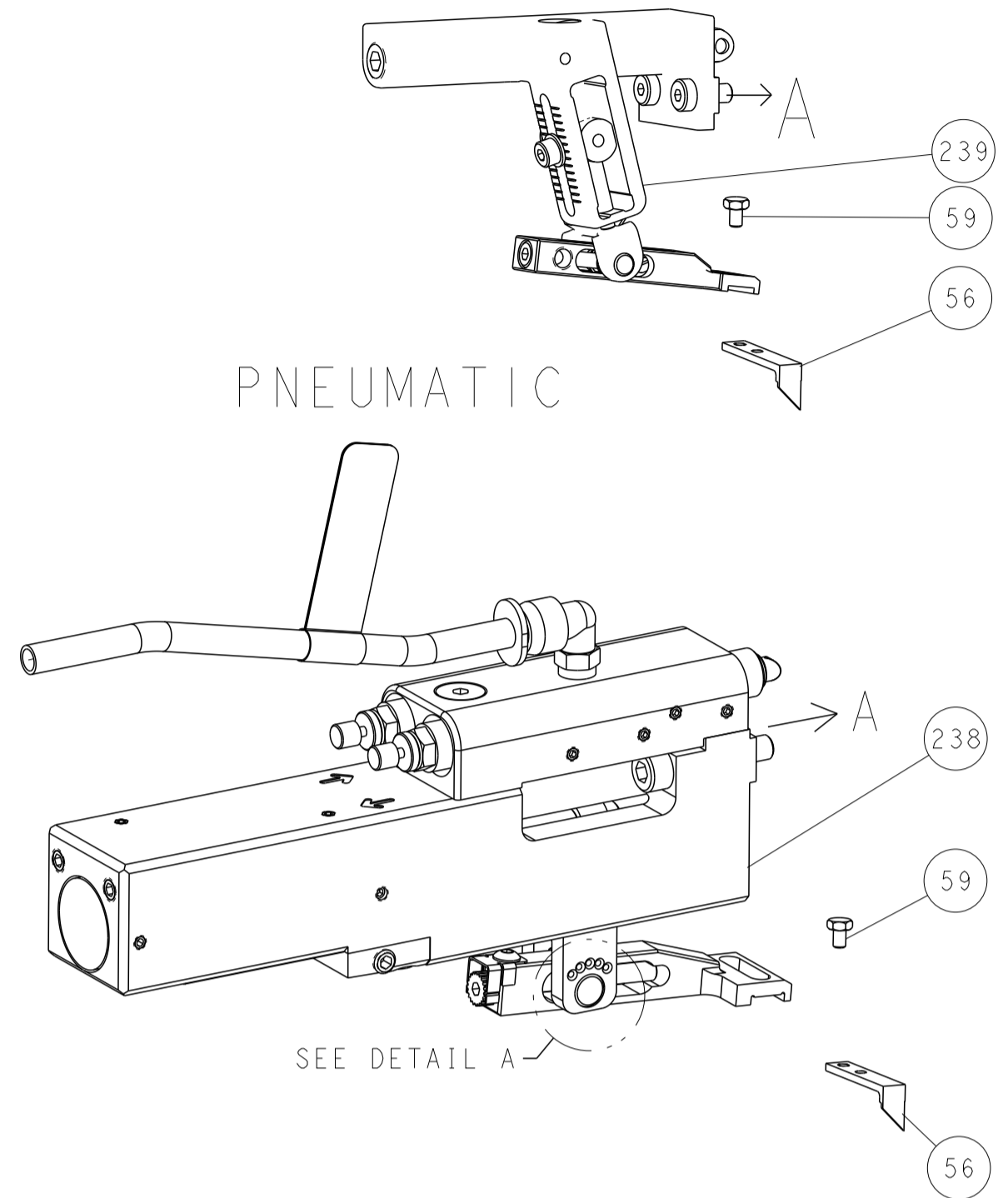
OCEAN 2.0 Side Feed Applicator

SIZE: A | 00779 C=2837249  
 CAGE CODE: -  
 DRAWING NO: -  
 RESTRICTED TO: -

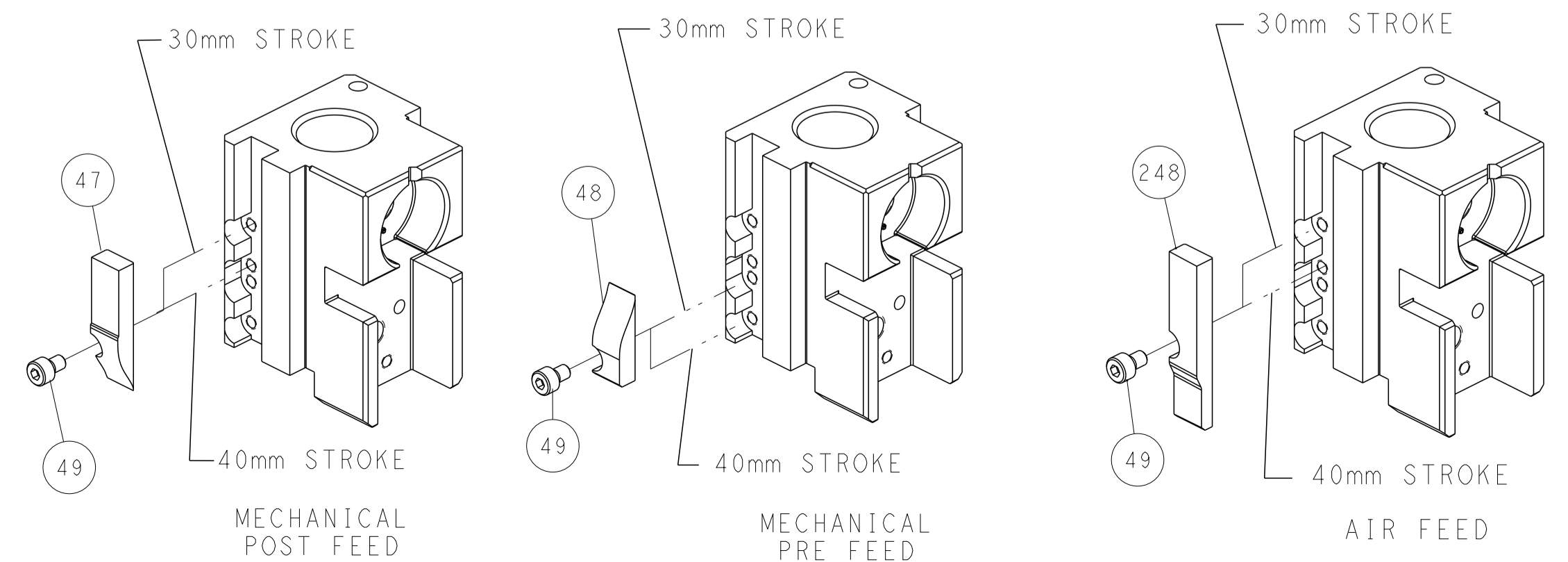
SHEET 1 OF 4 REV C

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

# FEED TYPE MECHANICAL



# CAM POSITIONS



DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH		DWN T. BROOKENS 16MAY2019 CHK M. HERR 16MAY2019 APVD C. TOPPER 16MAY2019 PRODUCT SPEC APPLICATION SPEC WEIGHT Customer Accessible Production Drawing		NAME OCEAN 2.0 Side Feed Applicator SIZE CAGE CODE DRAWING NO A 00779 C=2837249 SCALE 1:2 SHEET 2 OF 4 REV C	
MATERIAL:		FINISH:		DATE: 16MAY2019		REVISIONS:	