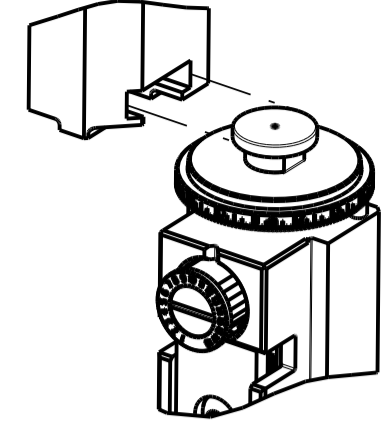


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2837561-1	A	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2837561-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2837561-1	A	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2837561-2	B	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2837561-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.78 mm [1.070]	F
INSUL	-	-

APPLICATOR INSTRUCTIONS
408-35042

TERMINAL DATA: LEAR TERMINAL CUSTOMER CRIMP SPECIFICATION			
TERMINAL NAME: CLIP			
WIRE STRIP LENGTH	TERMINAL INSULATION DIAMETER RANGE		
6.70-7.50 mm [.264-.295 IN]	∅ -		
TERMINAL APPLICATION SPECIFICATION			
-			
TERMINALS APPLIED			
TE TERMINAL	LEAR TERMINAL	TE TERMINAL	LEAR TERMINAL
3311457-1	25758.123.178	3311457-2	25758.123.009

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
20 AWG OR 0.50mm2	1.25 +/- 0.05 [1.049 +/- .002]	7.0
0.35mm2	1.18 +/- 0.05 [1.046 +/- .002]	7.6

- 1. RECOMMENDED SPARE PARTS
- 2. REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- 3. 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.
- 4. TERMINAL LUBRICANT IS RECOMMENDED.
- 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)

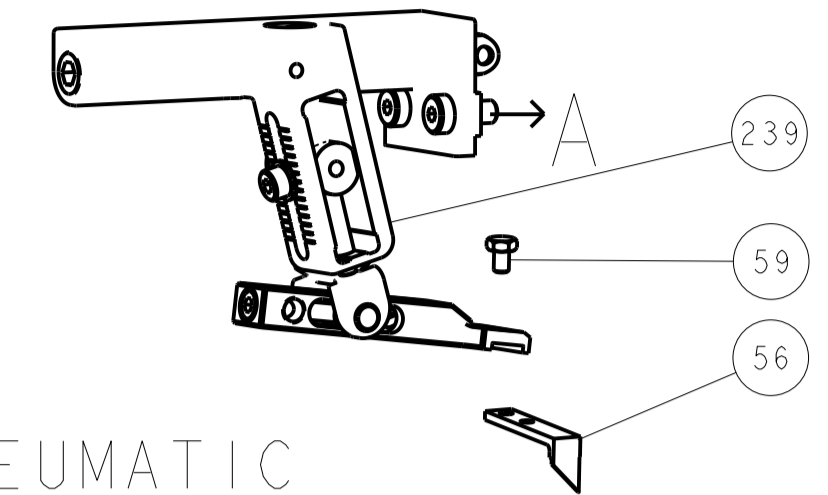
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		REV	DATE	BY	CHKD
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		A	RELEASED	29APR2019	RK CT
		B	ECR-21-001133	28JAN2021	FZ RK

-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248
-	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
-	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	455888-6	SPACER, CRIMPER	82
-	1	1	1	1	1803607-3	DOCUMENTATION PACKAGE	71
-	1	1	1	1	2119791-9	DEPRESSOR, WIRE	70
-	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
-	2	2	2	2	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	54
-	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
-	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	2	2	2-2844962-0	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	1	1	2844992-2	ASSEMBLY, STRIP GUIDE	29
-	1	1	1	1	455888-5	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	1803095-5	FLOATING SHEAR, FRONT	9
1	2	2	1	1	5-1803190-6	ANVIL, WIRE	8
-	-	-	-	-	-	-	7
-	-	-	-	-	-	-	6
-	1	1	1	1	2119757-1	DEPRESSOR, SHEAR	5
-	-	-	-	-	-	-	4
-	-	-	-	-	-	-	3
-	-	-	-	-	-	-	2
1	2	2	1	1	6-456404-1	CRIMPER, WIRE PREMIUM	1
-77	-72	-71	-2	-1	PART NO	DESCRIPTION	ITEM NO

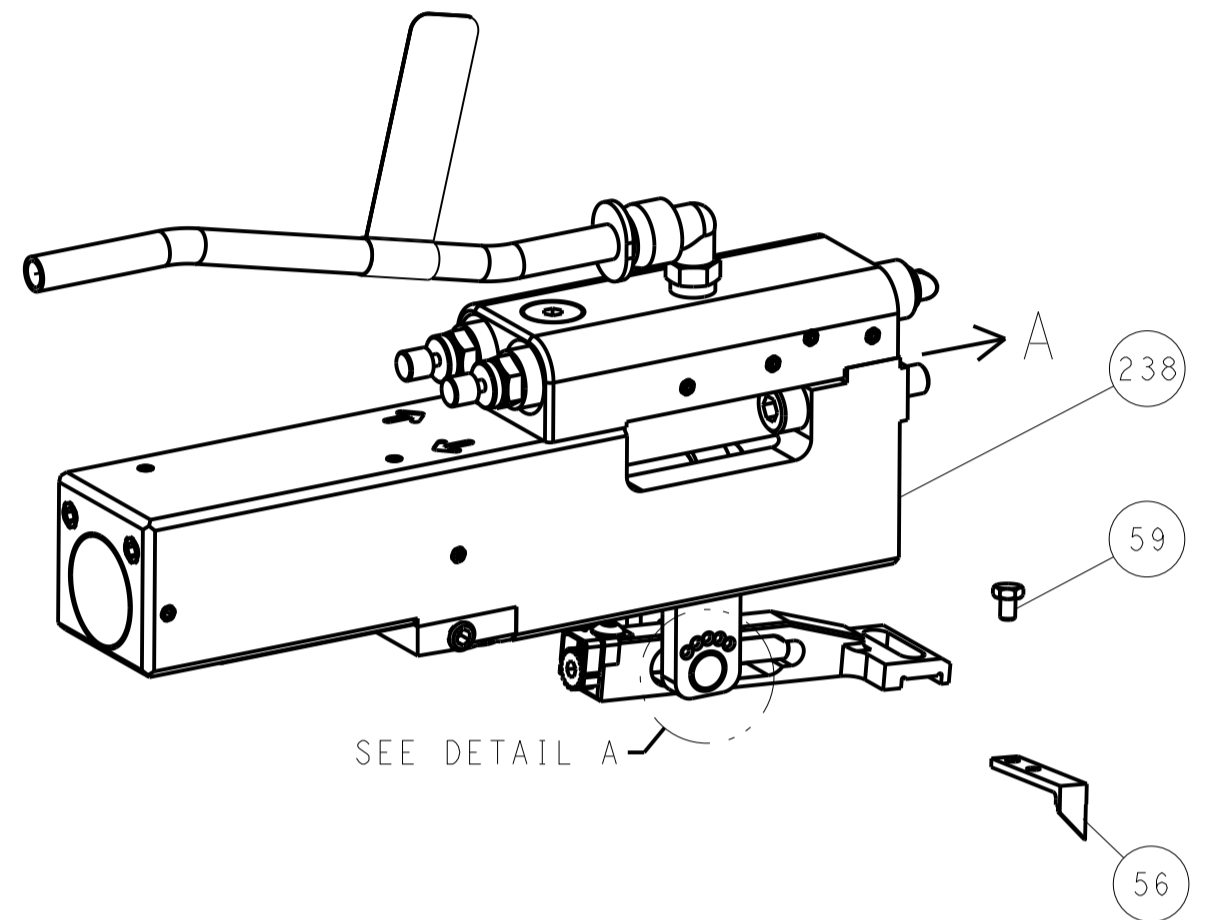
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mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES	FINISH	WT	SCALE	SHEET	REV
										1 of 4	B

LOC	DIST	REV	DATE	BY	APP'D
A	66				

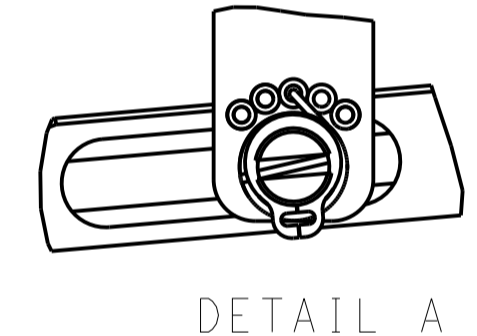
FEED TYPE MECHANICAL



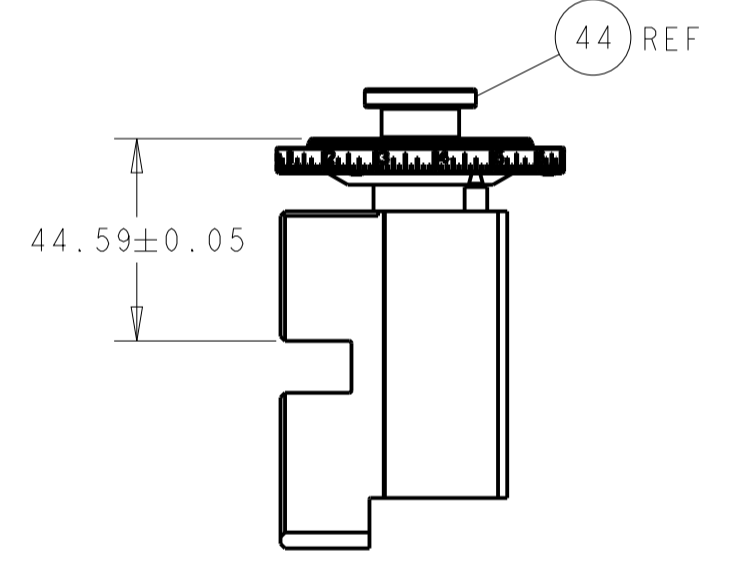
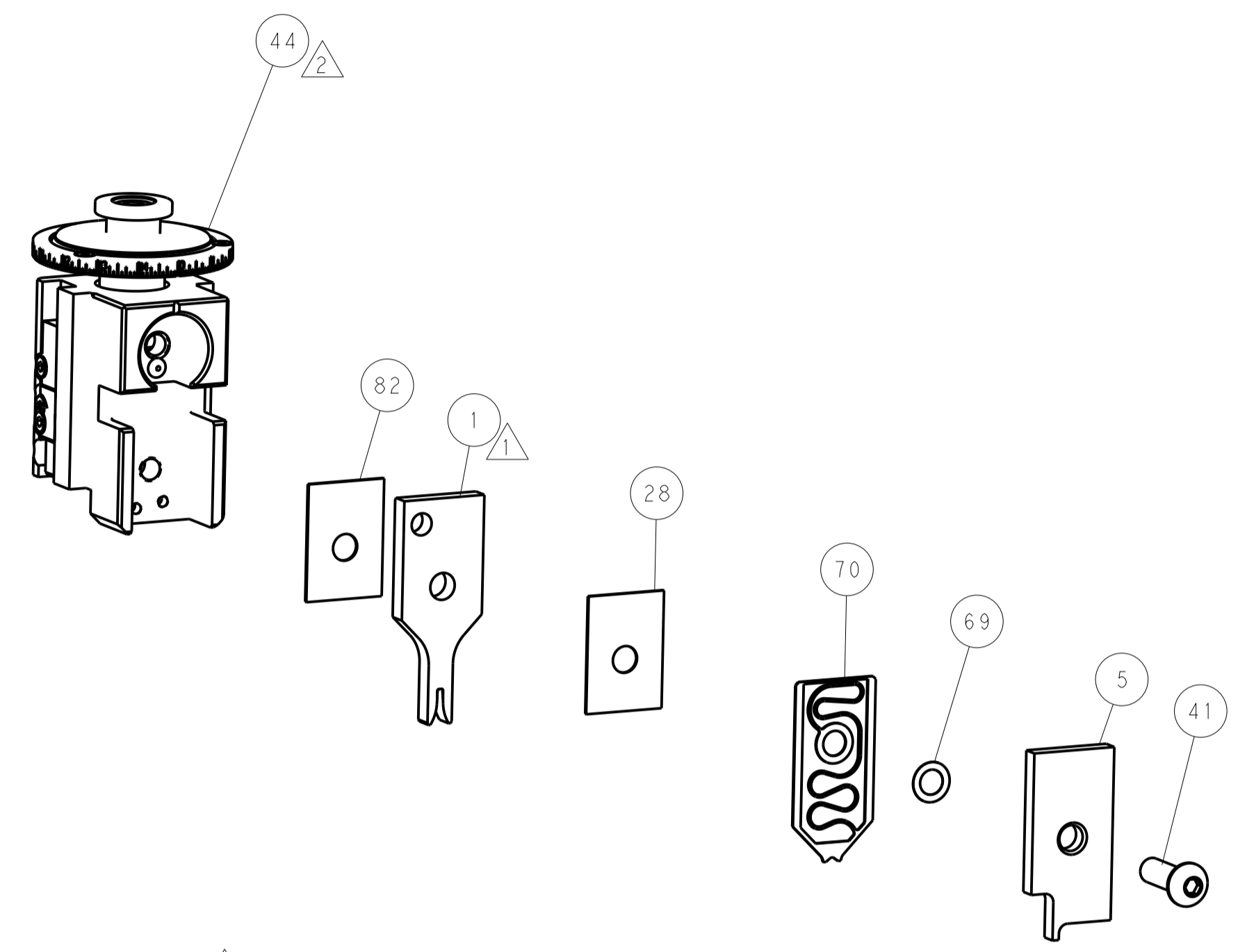
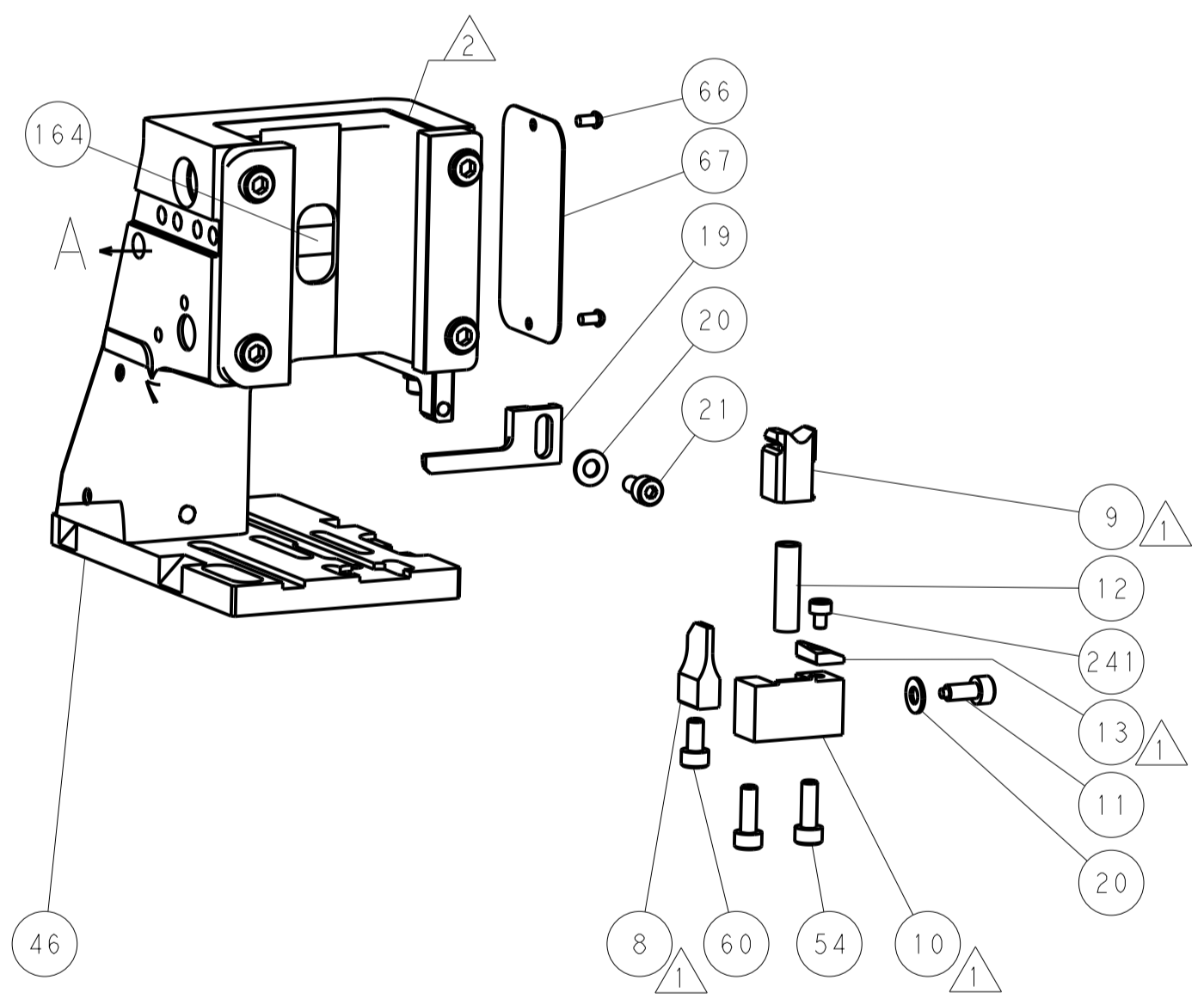
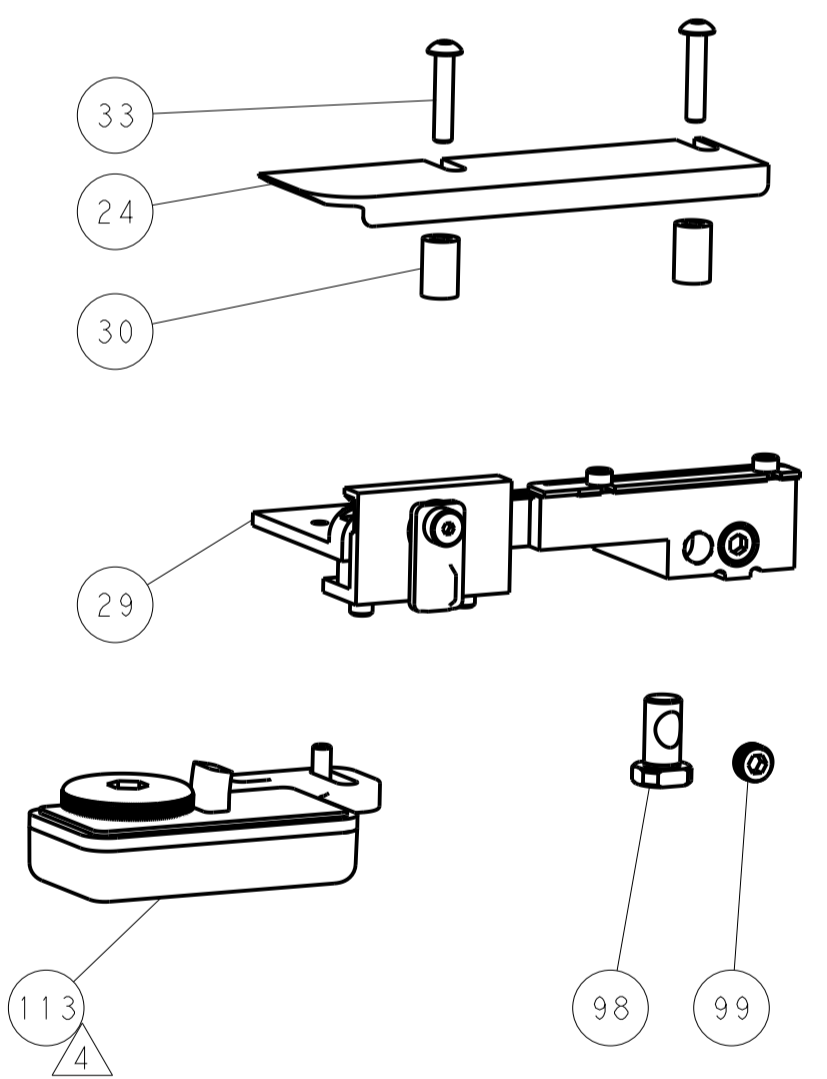
PNEUMATIC



FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)

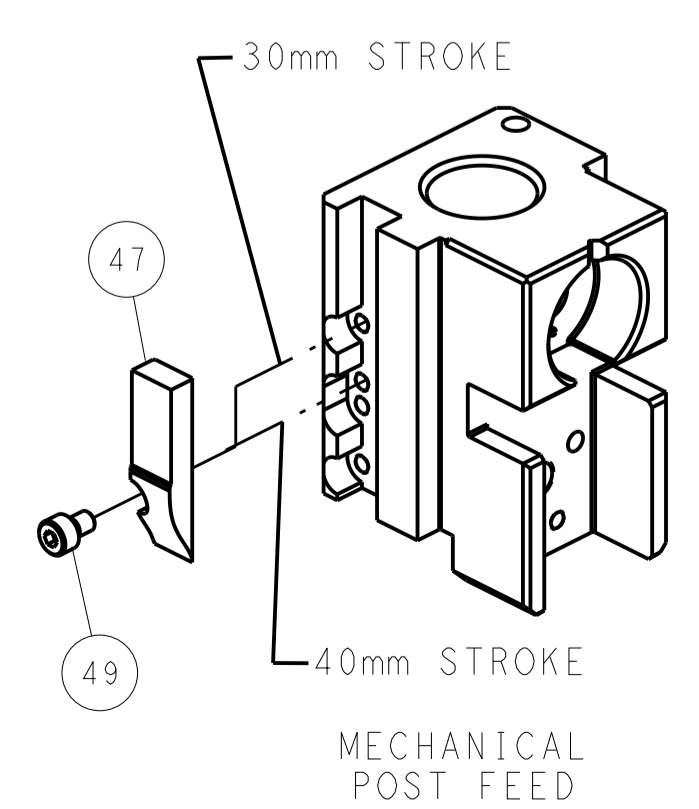


DETAIL A

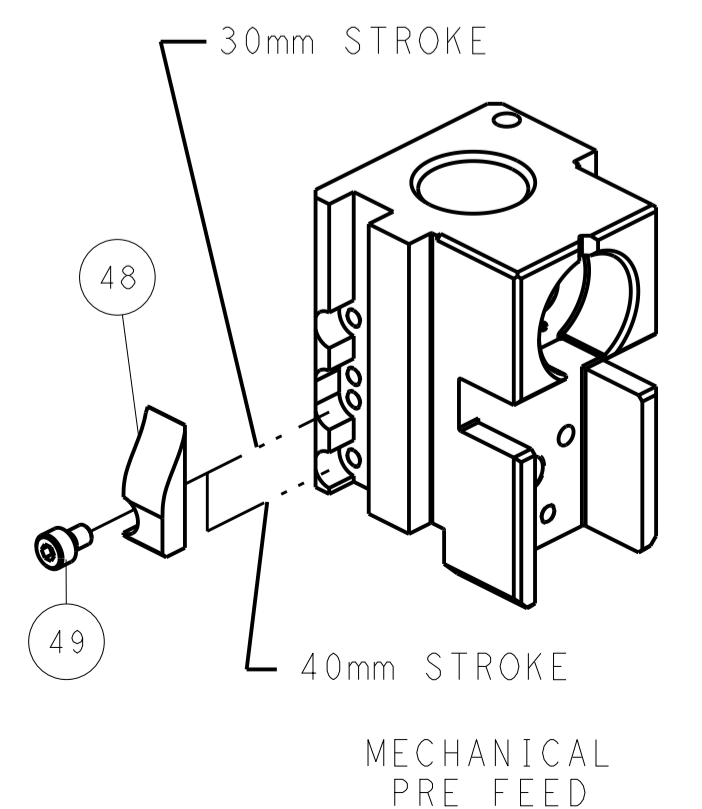


RAM SET-UP

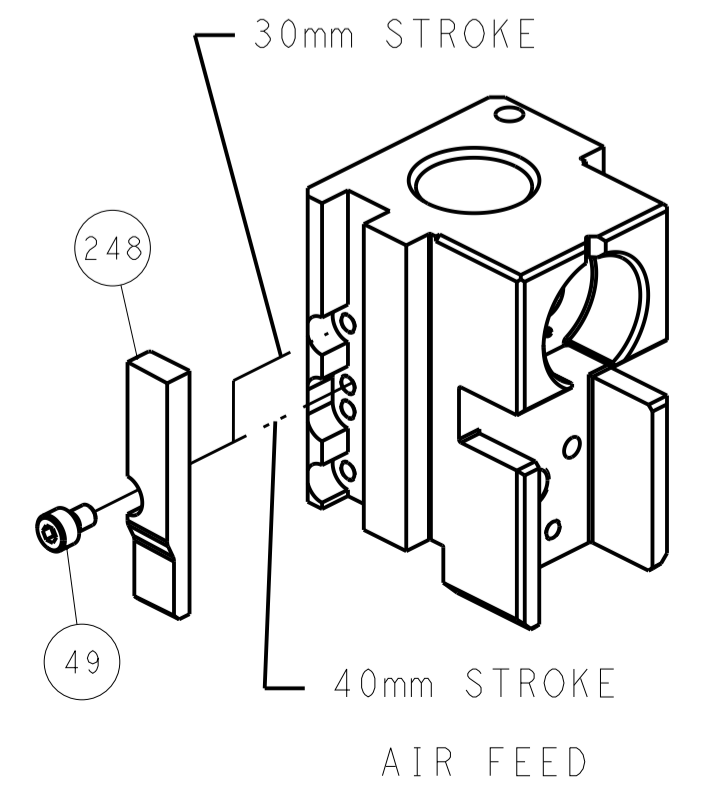
CAM POSITIONS



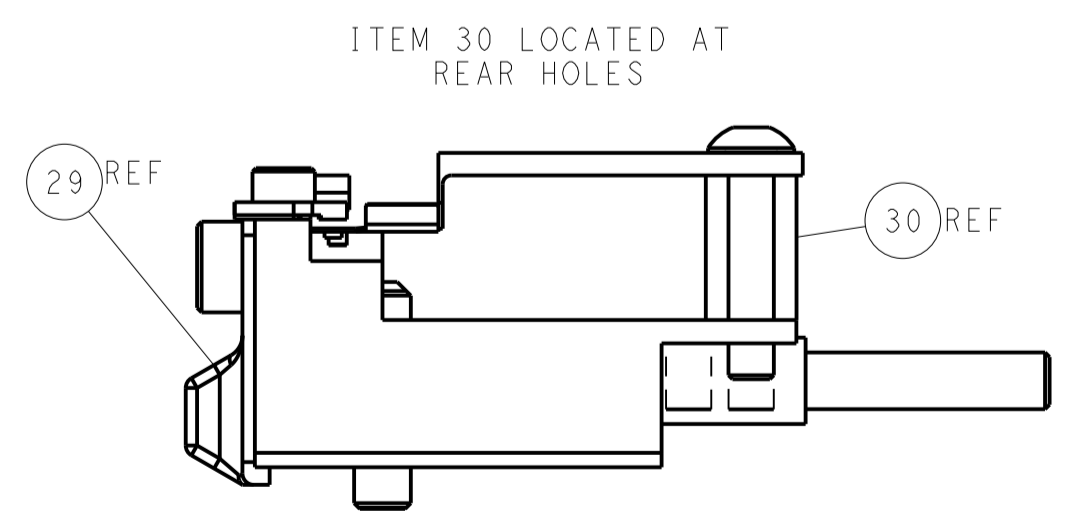
MECHANICAL POST FEED



MECHANICAL PRE FEED



AIR FEED



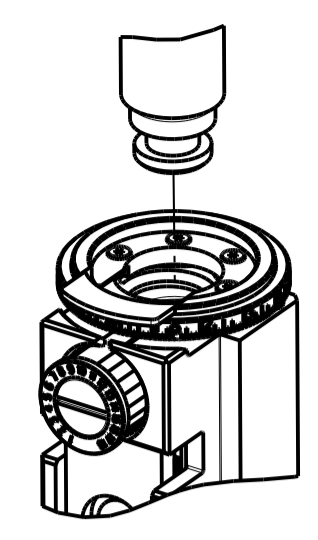
FEED TRACK POSITION GUIDE BY WIRE BARREL

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:		DWG: R. KNEPPER 28-MAR-19		TE Connectivity	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	5 PLC ±	Harrisburg, PA 17105-3608
ANGLES	FINISH	WEIGHT	SCALE	SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
			1:2	A1	00779	2837561	
Customer Accessible Production Drawing				SHEET 2 OF 4 REV B			

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2837561-1	A	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2837561-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2837561-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
 INTERFACE ADAPTER



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

APPLICATOR INSTRUCTIONS
 408-35042

TERMINAL DATA: LEAR TERMINAL CUSTOMER CRIMP SPECIFICATION			
TERMINAL NAME: CLIP			
WIRE STRIP LENGTH	TERMINAL INSULATION DIAMETER RANGE		
6.70-7.50 mm [.264-.295 IN]	∅ -		
TERMINALS APPLIED			
TE TERMINAL	LEAR TERMINAL	TE TERMINAL	LEAR TERMINAL
3311457-1	25758.123.178	3311457-2	25758.123.009

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
20 AWG OR 0.50mm ²	1.25 +/- 0.05 [.049 +/- .002]	7.0
0.35mm ²	1.18 +/- 0.05 [.046 +/- .002]	7.6

- RECOMMENDED SPARE PARTS
 - REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
 - 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.
 - TERMINAL LUBRICANT IS RECOMMENDED.
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)

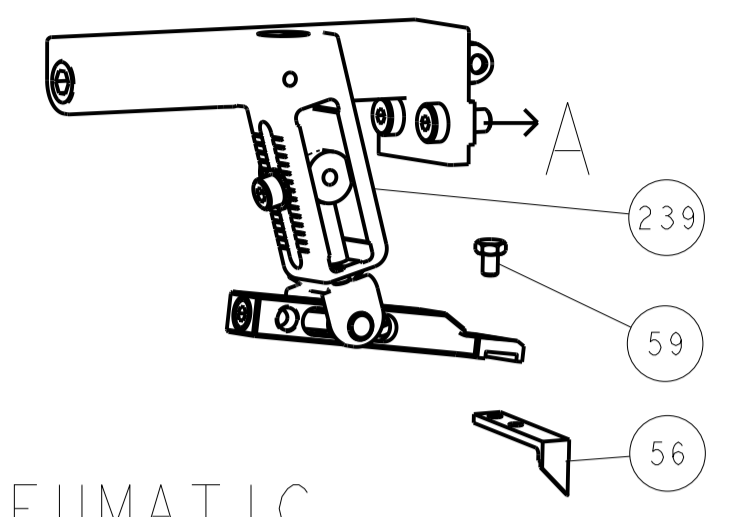
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A	66	-	-	-	-

QTY	REV	DATE	BY	APPV	DESCRIPTION	ITEM NO
-	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	1	2119641-2		FEED CAM, AIR FEED	151
-	1	1	2168083-8		SCR, SKT HD CAP, RoHS, M4 X 16	144
-	2	2	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	455888-6		SPACER, CRIMPER	82
-	1	1	1803607-3		DOCUMENTATION PACKAGE	71
-	1	1	2119791-9		DEPRESSOR, WIRE	70
-	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	5-18022-5		SCR, HEX HD CAP, M4 X 6.0	59
-	1	1	1338685-1		PAWL, FEED	56
-	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
-	2	2	2079383-5		SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	2-2844962-0		SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	2844992-2		ASSEMBLY, STRIP GUIDE	29
-	1	1	455888-5		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	1803095-5		FLOATING SHEAR, FRONT	9
-	1	1	5-1803190-6		ANVIL, WIRE	8
-	-	-	-		-	7
-	-	-	-		-	6
-	1	1	2119757-1		DEPRESSOR, SHEAR	5
-	-	-	-		-	4
-	-	-	-		-	3
-	-	-	-		-	2
-	1	1	6-456404-1		CRIMPER, WIRE PREMIUM	1

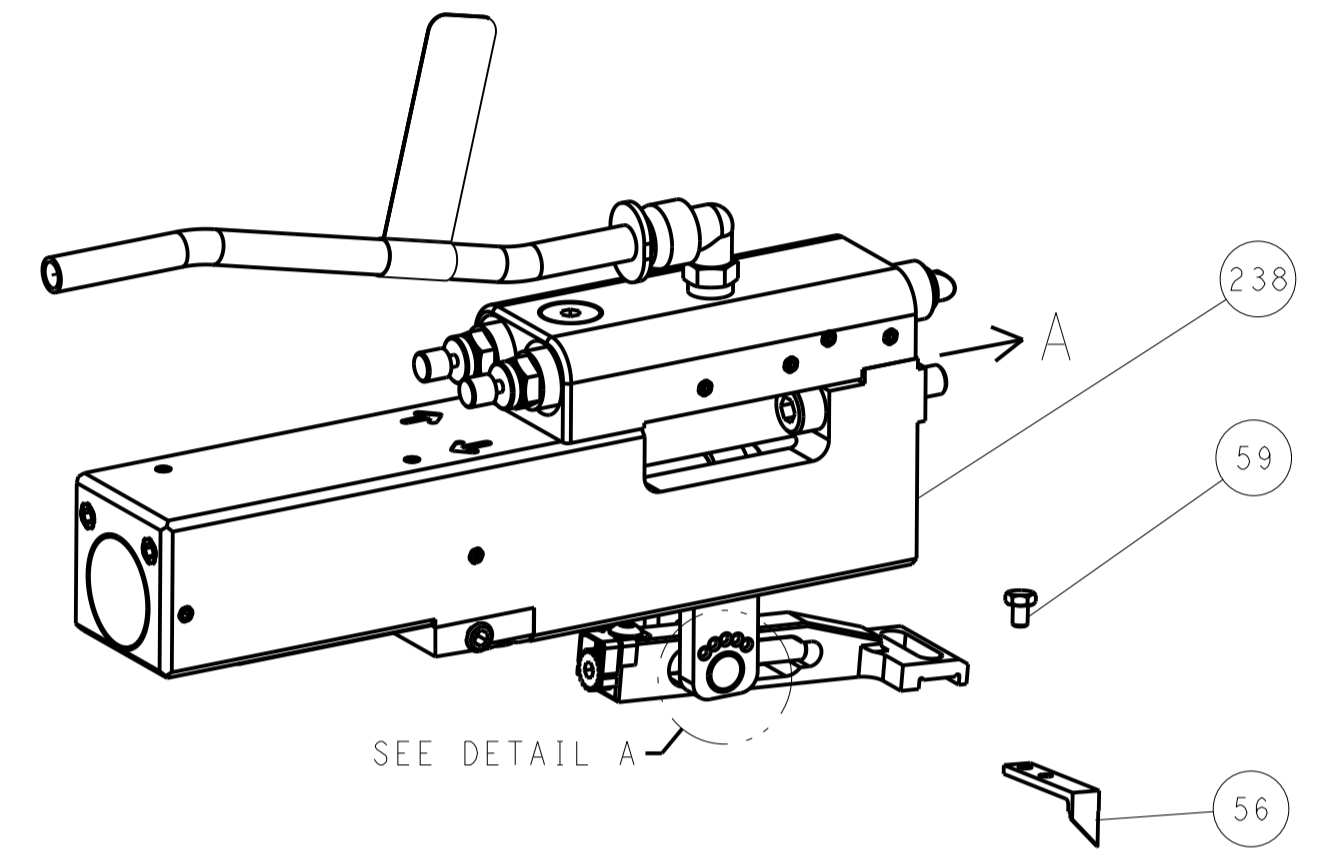
DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		DWN R. KNEPPER 28-MAR-19 CHK M. HERR 28-MAR-19 APVD C. TOPPER 28-MAR-19		TE Connectivity Harrisburg, PA 17105-3608	
MATERIAL: - FINISH: -		WEIGHT: - SCALE: 1:2		NAME: OCEAN 2.0 Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2837561		RESTRICTED TO: - SHEET 3 OF 4 REV B	

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

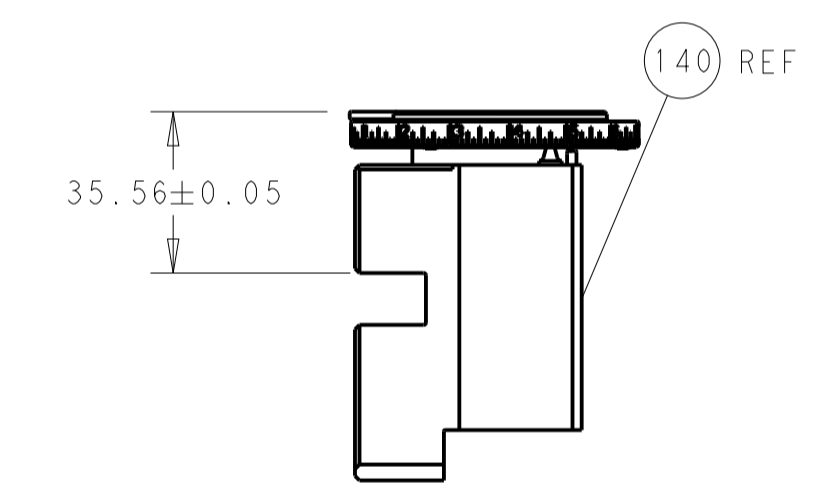
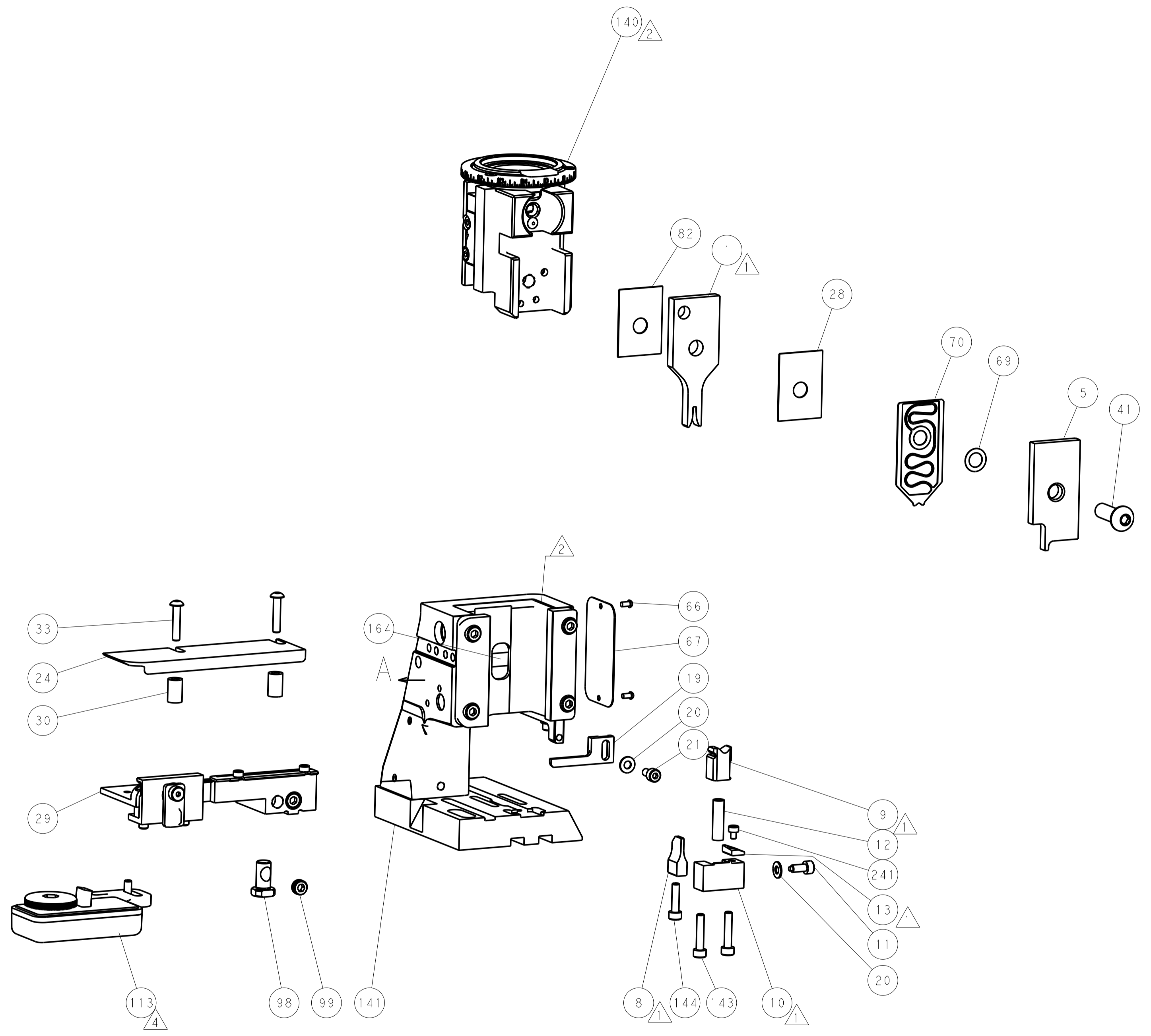
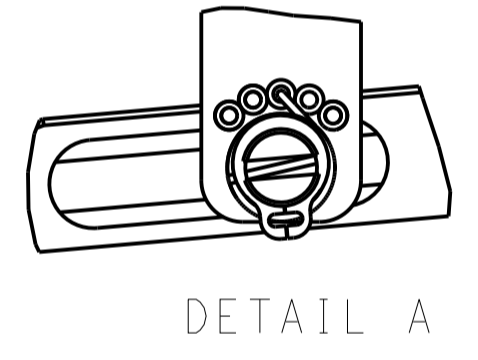
FEED TYPE MECHANICAL



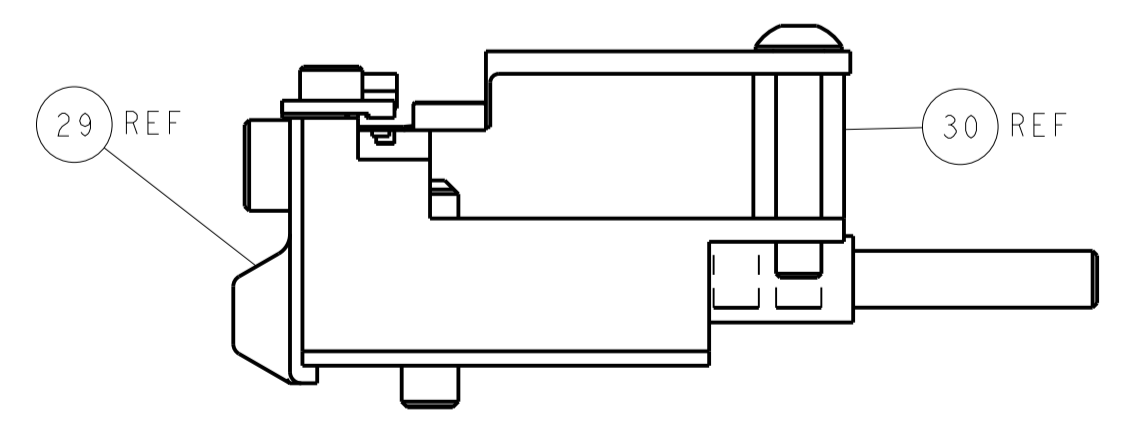
PNEUMATIC



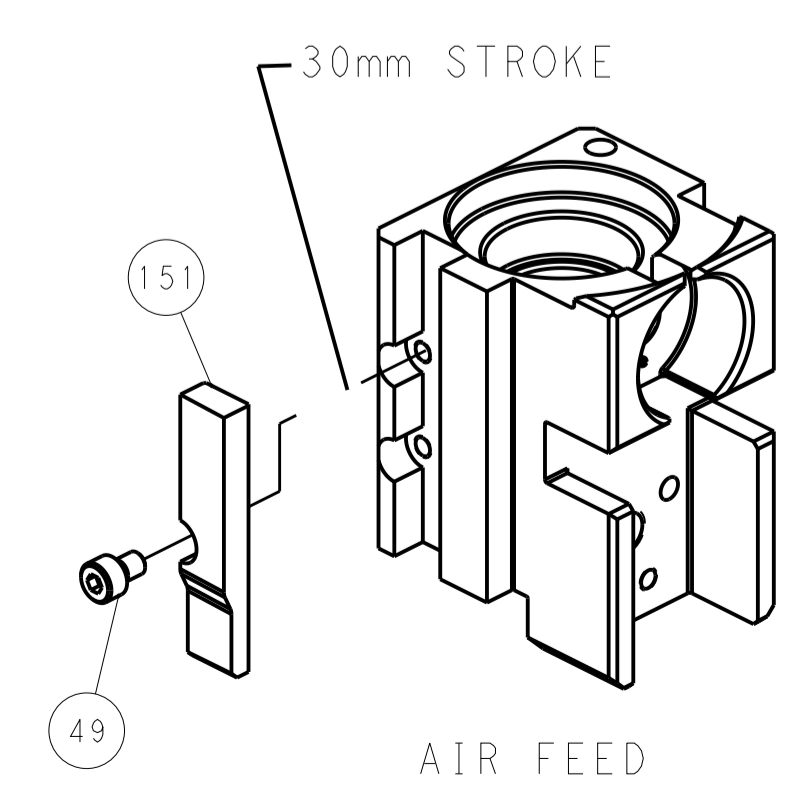
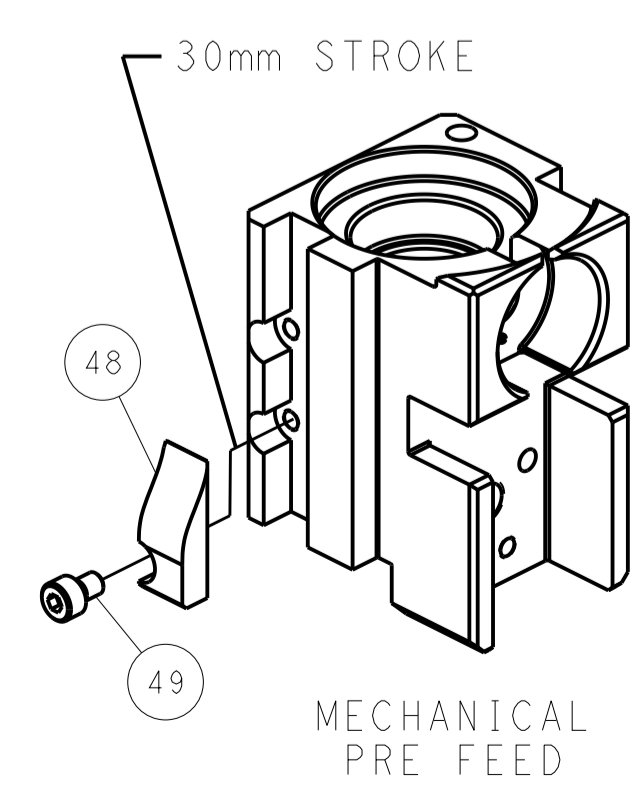
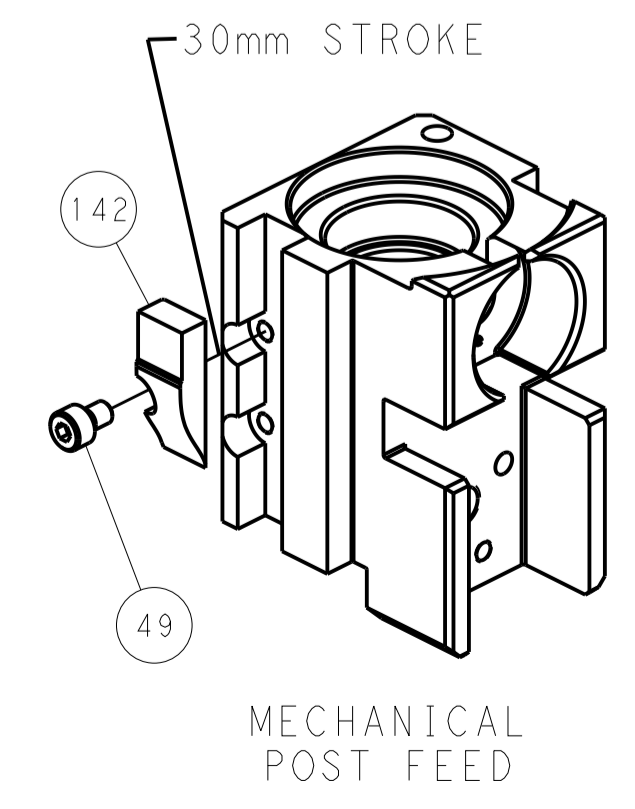
FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



ITEM 30 LOCATED AT REAR HOLES



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: R. KNEPPER 28-MAR-19		TE Connectivity	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	5 PLC ±	Harrisburg, PA 17105-3608
	ANGLES			CHK: M. HERR 28-MAR-19	NAME: OCEAN 2.0 Side Feed Applicator	SIZE: A	CAGE CODE: 00779
MATERIAL:	FINISH:	WEIGHT:	SCALE: 1:2	APVD: C. TOPPER 28-MAR-19	DRAWING NO: 2837561	SHEET: 4	REV: B
Customer Accessible Production Drawing				RESTRICTED TO			