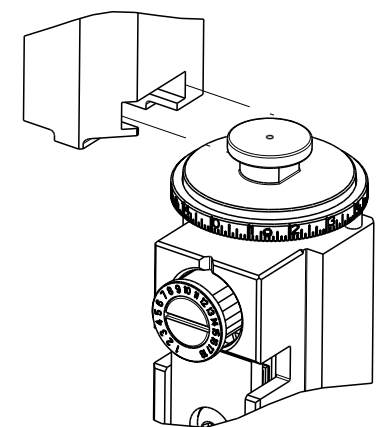


| PART NUMBER | REVISION | DESCRIPTION | FEED TYPE |
|-------------|----------|----------------------------------|------------|
| 2837728-1 | A | FINE CRIMP HEIGHT ADJUST | MECHANICAL |
| 2837728-2 | A | FINE CRIMP HEIGHT ADJUST | PNEUMATIC |
| 7-2837728-1 | A | MECHANICAL AND CRIMP TOOLING KIT | MECHANICAL |
| 7-2837728-2 | A | PNEUMATIC AND CRIMP TOOLING KIT | PNEUMATIC |
| 7-2837728-7 | A | CRIMP TOOLING KIT | - |

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER

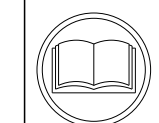


| APPLICATOR DATA | | |
|-----------------|----------------|------|
| CRIMP | SIZE | TYPE |
| WIRE | 1.57 mm [.062] | F |
| INSUL | 2.50 mm [.098] | F |

APPLICATOR INSTRUCTIONS 408-35042

| TERMINAL DATA: DELPHI TERMINAL DELPHI CRIMP SPECIFICATION | | | |
|---|--|-------------|-----------------|
| TERMINAL NAME: TAB TERMINAL | | | |
| WIRE STRIP LENGTH | TERMINAL INSULATION DIAMETER RANGE | | |
| 4.46-5.22 mm [.175-.205 IN] | Ø1.20-1.70 mm [.047-.067 IN] | | |
| TERMINAL APPLICATION SPECIFICATION | 12059894 CRIMP SHT PG 28 OF 37 Rev 7/28/14 | AT9106 | |
| TERMINALS APPLIED | | | |
| TE TERMINAL | DELPHI TERMINAL | TE TERMINAL | DELPHI TERMINAL |
| 1572382-1 | 12059894 | | |

| WIRE SIZE | CRIMP HEIGHT mm [INCH] | CRIMP HEIGHT REFERENCE SETTING |
|-----------|----------------------------|--------------------------------|
| 0.50mm2 | 1.30+/-0.05 [.051+/-0.002] | 5.8 |
| 0.35mm2 | 1.20+/-0.05 [.047+/-0.002] | 6.7 |



- 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.
- UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT 101-35000.
- TERMINAL LUBRICANT IS RECOMMENDED.

***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)

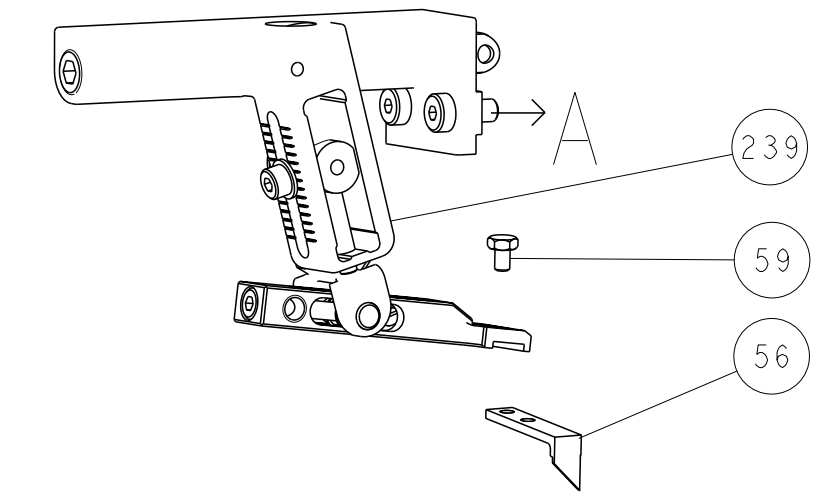
| LOC | DIST | REVISIONS | | | | | |
|-----|------|-----------|-----|-------------|-----------|-----|------|
| | | # | LY# | DESCRIPTION | DATE | OWN | APVD |
| A | 66 | 1 | | PRELIMINARY | 18DEC2019 | MEH | GB |
| | | A | | RELEASED | 07JUL2020 | MEH | GB |

| | | | | | | | | |
|---|-----|-----|-----|-----|-------------|-------------------------------------|-------------------------------|---------|
| - | 1 | - | 1 | - | 2119641-1 | FEED CAM, AIR FEED | 248 | |
| - | 1 | 1 | 1 | 1 | 2119082-8 | 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 | |
| - | 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 | 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 | 2168083-8 | SCR, SKT HD CAP, RoHS, M4 X 16 | 53 | |
| - | 1 | 1 | 1 | 1 | 1803382-1 | HOLD DOWN, SPRING LOADED | 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 | 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 | |
| - | 1 | 1 | 1 | 1 | 7-1752356-2 | 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 | 1-455888-0 | SPACER, CRIMPER | 28 | |
| - | 1 | 1 | 1 | 1 | 1320928-6 | 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 | 1803095-6 | FLOATING SHEAR, FRONT | 9 | |
| - | 1 | 2 | 2 | 1 | 1 | 2-1803763-0 | ANVIL, COMBINATION | 8 |
| - | 1 | 1 | 1 | 1 | 5-240641-3 | SPACER | 7 | |
| - | - | - | - | - | - | - | 6 | |
| - | 1 | 1 | 1 | 1 | 2119757-8 | DEPRESSOR, SHEAR | 5 | |
| - | 1 | 1 | 1 | 1 | 238011-4 | BLOCK, CRIMPER SPACER | 4 | |
| - | 1 | 2 | 2 | 1 | 1 | 4-1633961-5 | CRIMPER, INSULATION F PREMIUM | 3 |
| - | 1 | 1 | 1 | 1 | 455888-3 | SPACER, CRIMPER | 2 | |
| - | 1 | 2 | 2 | 1 | 1 | 7-456403-2 | CRIMPER, WIRE PREMIUM | 1 |
| - | 77 | 72 | 71 | -2 | -1 | PART NO | DESCRIPTION | ITEM NO |

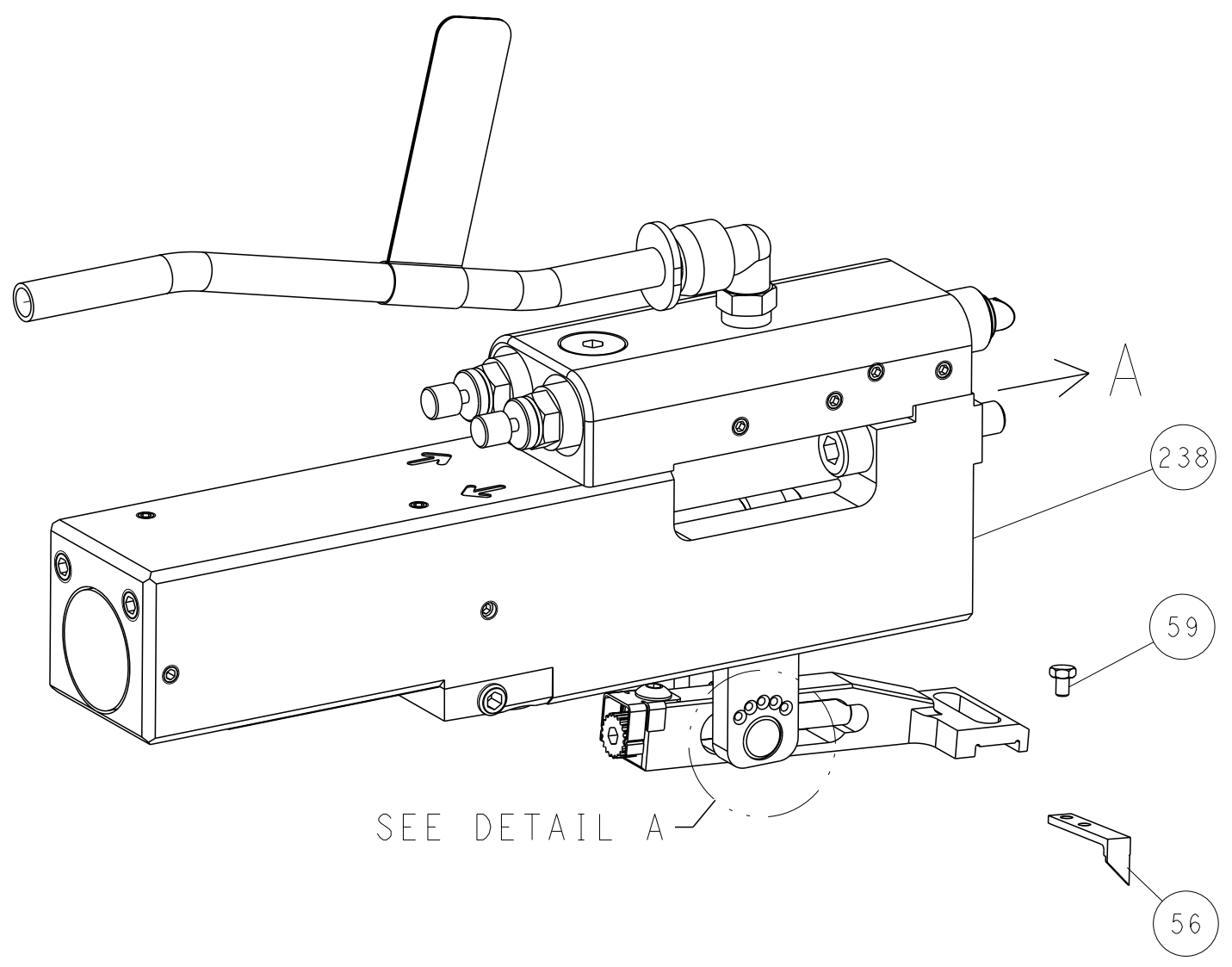
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|-------------|---------|--|---------|---------|------------------|-----------|--------------------------------|-----------|------------|---------------|
| mm | 0 PLC ± | 1 PLC ± | 2 PLC ± | M. HERR | G. BAILEY | 18DEC2019 | Harrisburg, PA 17105-3608 | | | |
| | 3 PLC ± | 4 PLC ± | FINISH | APVD | PRODUCT SPEC | 18DEC2019 | NAME | | | |
| | ANGLES | | | B. BAIR | | | OCEAN 2.0 Side Feed Applicator | | | |
| MATERIAL | | | | | APPLICATION SPEC | | SIZE | CAGE CODE | DRAWING NO | RESTRICTED TO |
| | | | | | | | A1 | 00779 | 2837728 | |
| | | | | | WEIGHT | | SCALE | 1:2 | SHEET | 1 OF 4 |
| | | | | | | | | | REV | A |

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

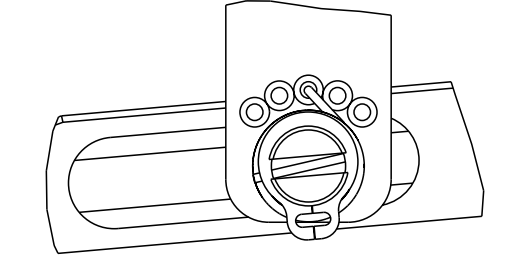
FEED TYPE MECHANICAL



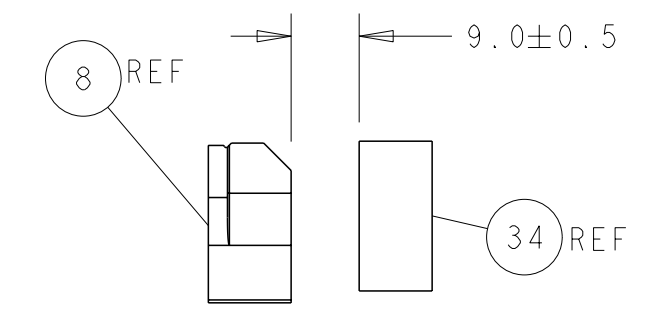
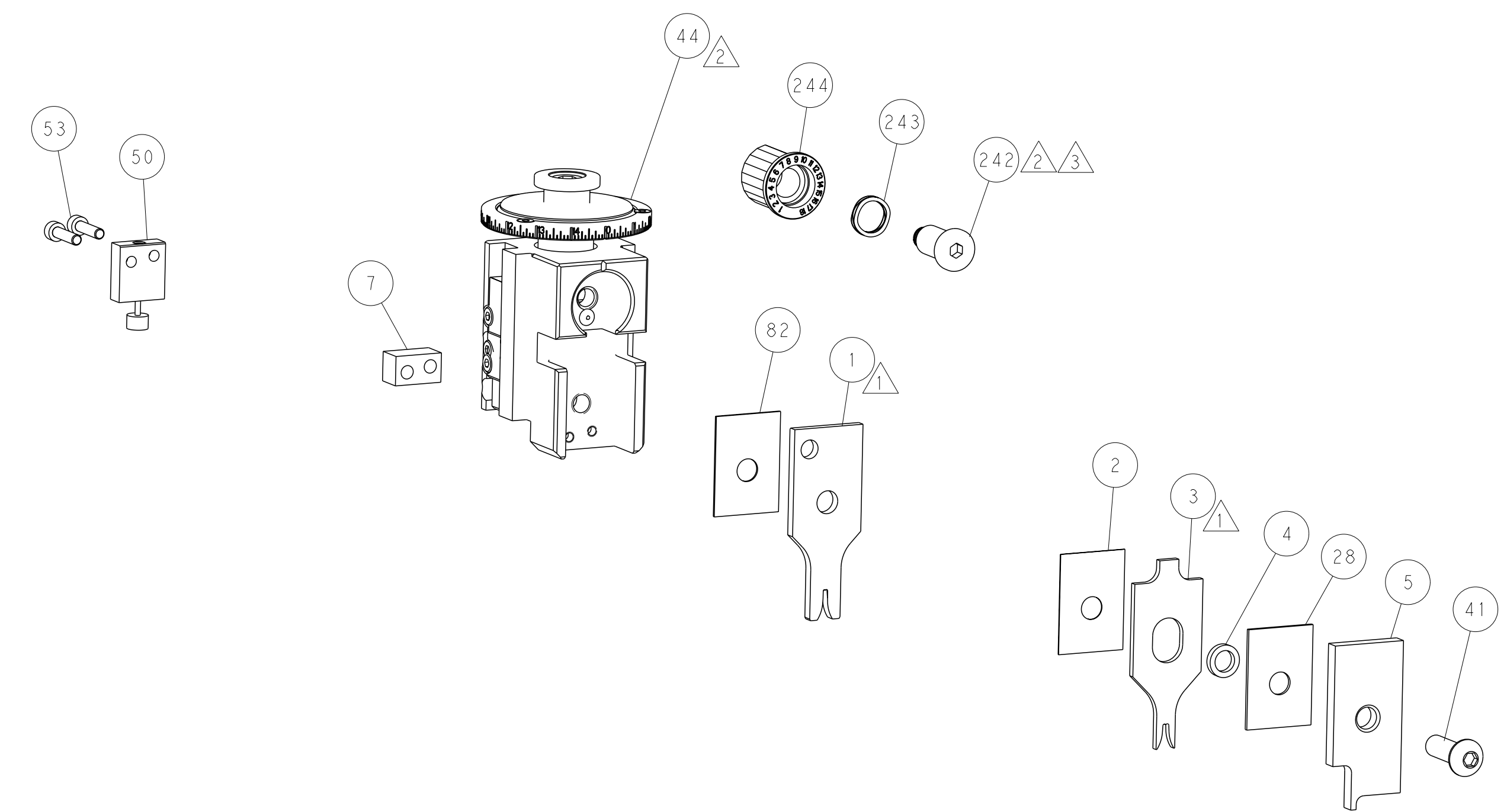
PNEUMATIC



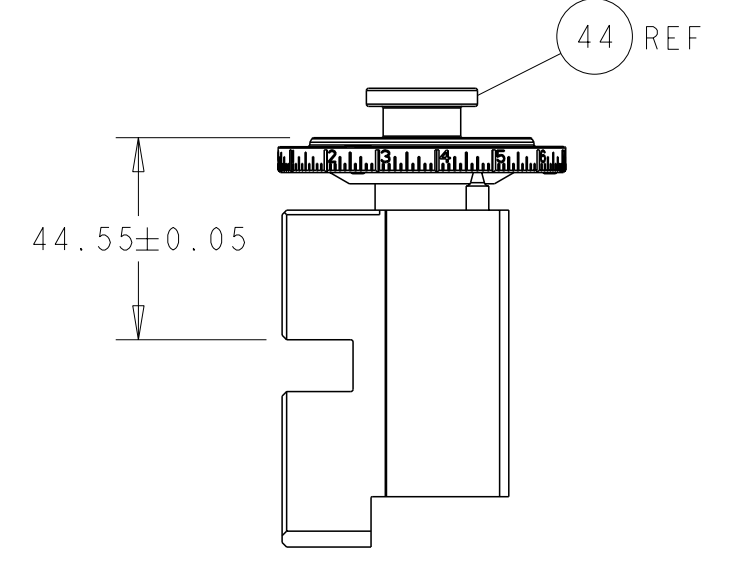
FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



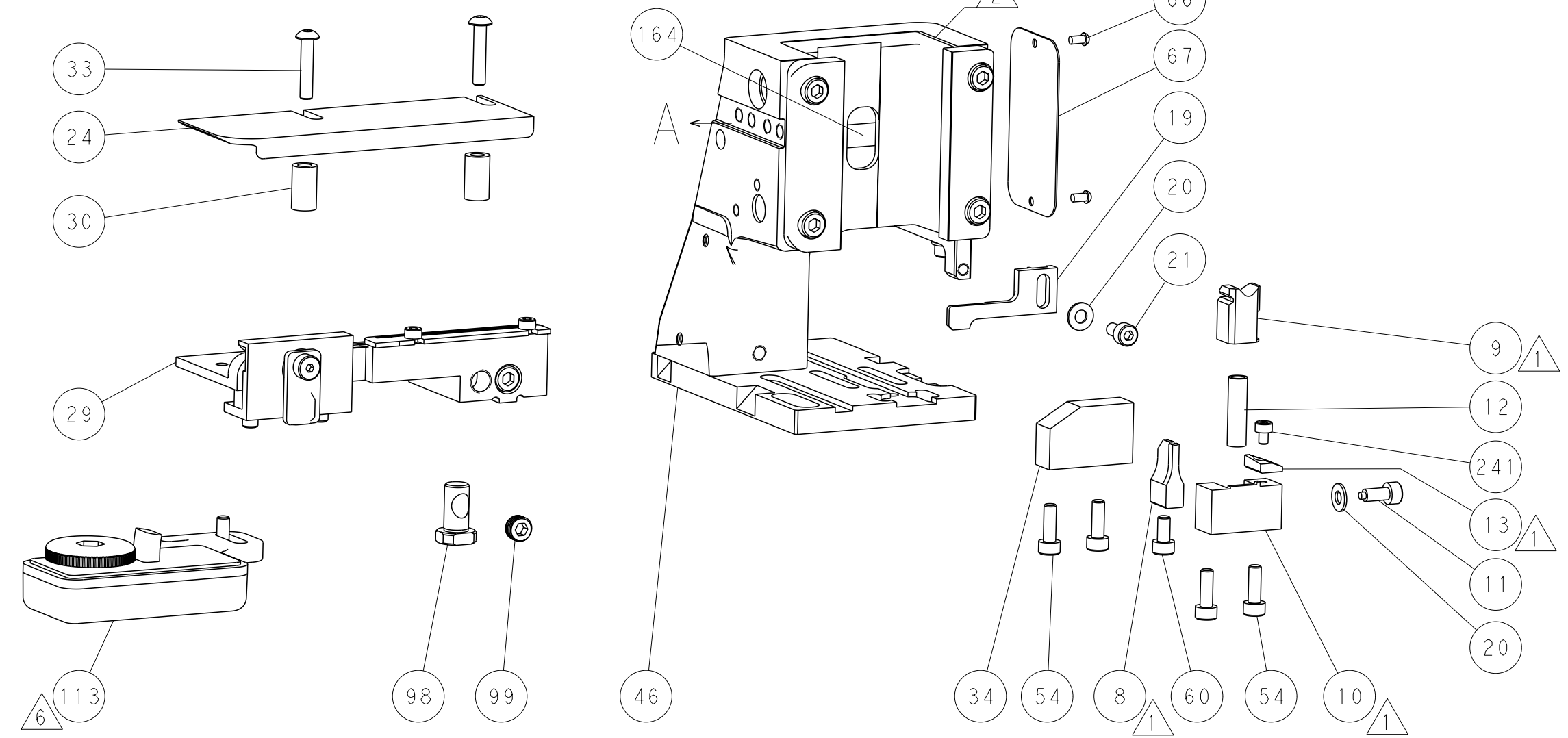
DETAIL A



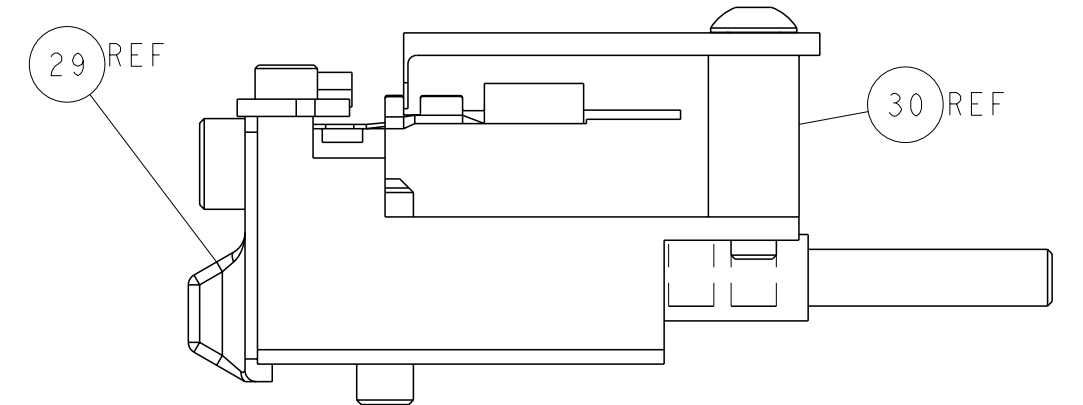
TERMINAL SUPPORT LOCATION



RAM SET-UP

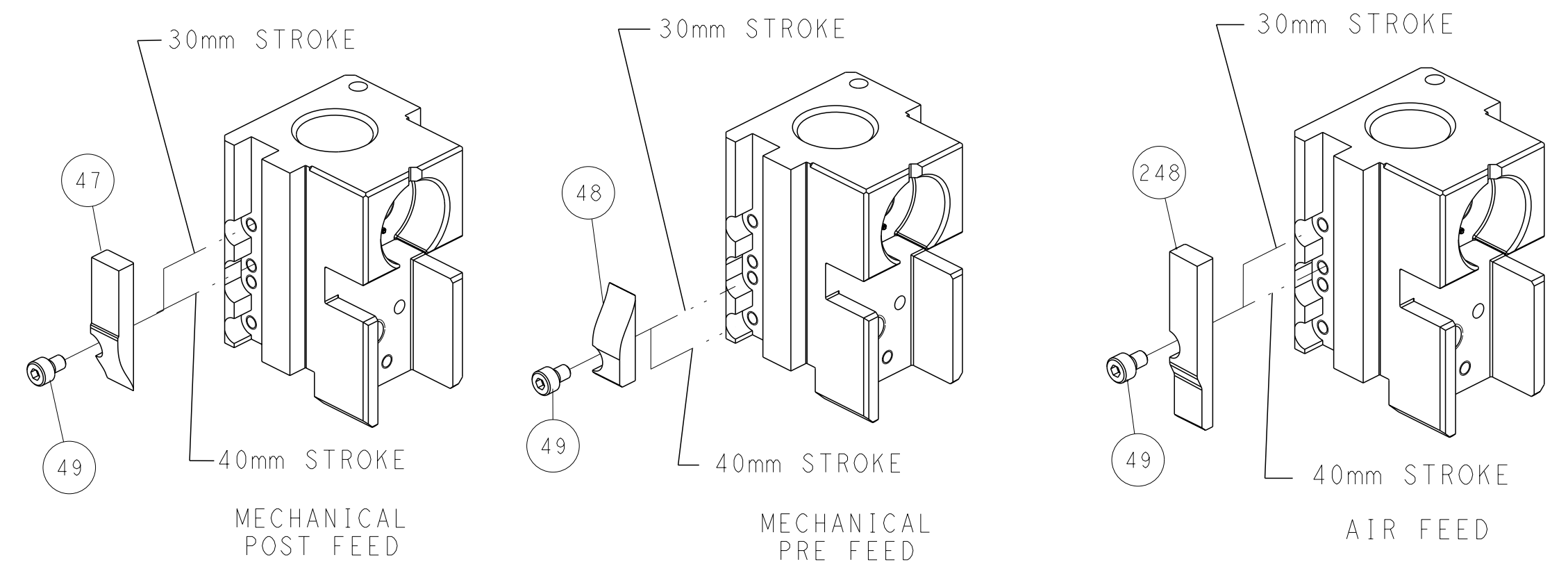


ITEM 30 LOCATED AT REAR HOLES



FEED TRACK POSITION GUIDE BY INSULATION BARREL

CAM POSITIONS

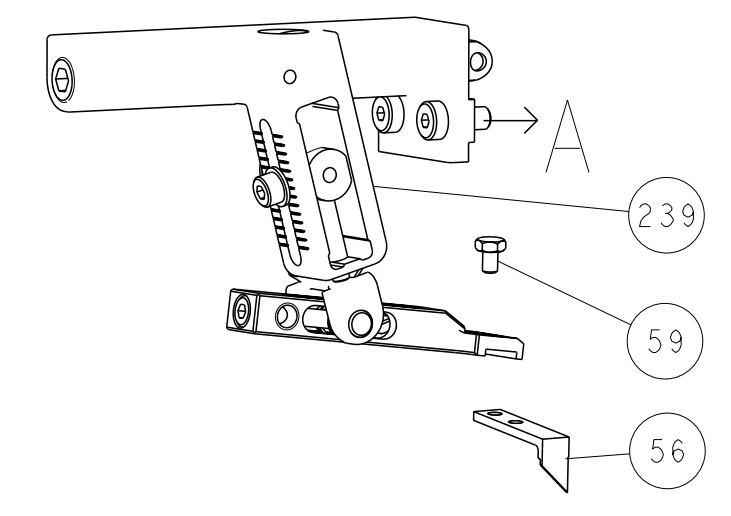


ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

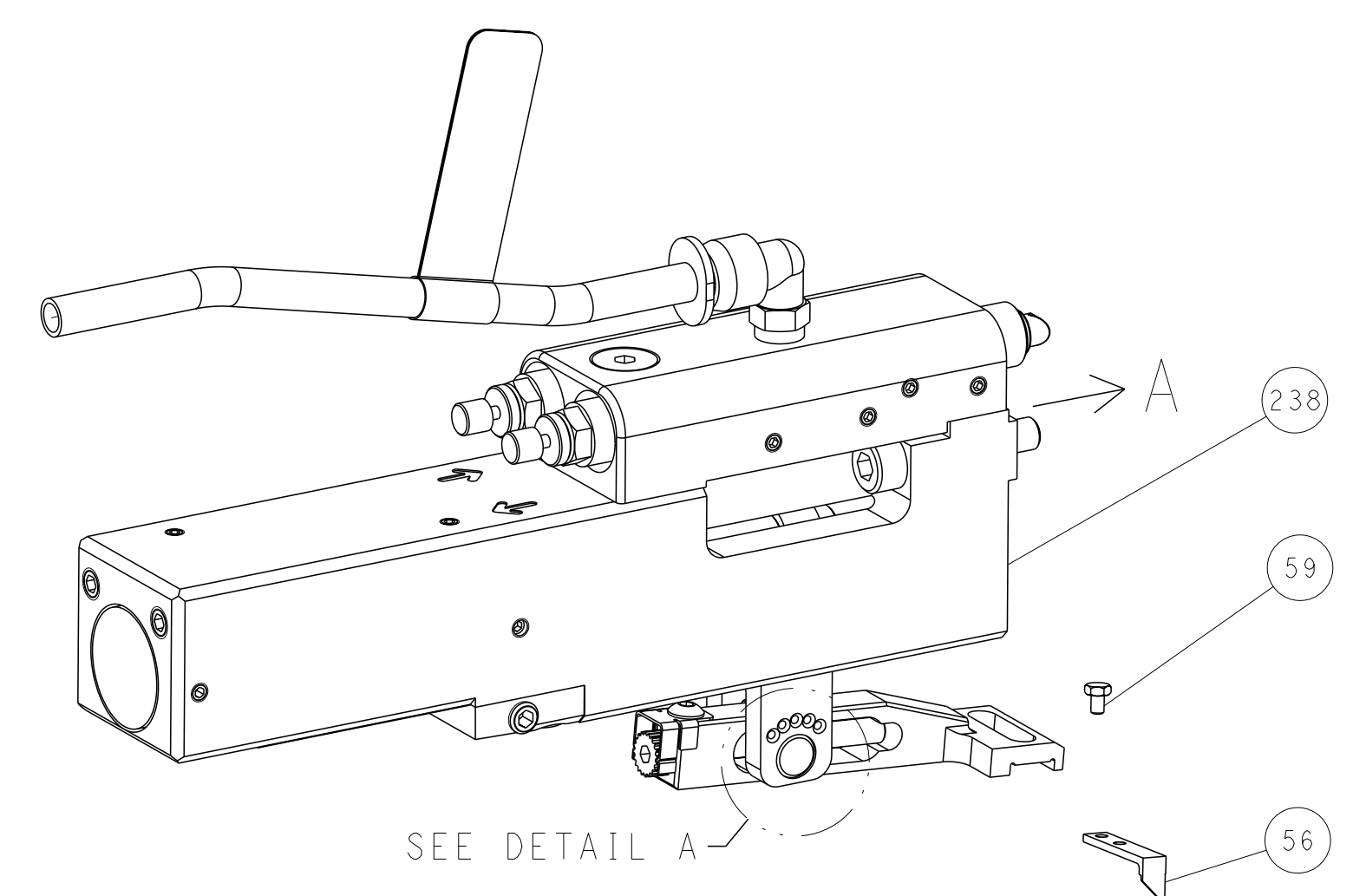
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|---|--|--|--|---|--|
| DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH | | OWN M. HERR 18DEC2019 CHK G. BAILEY 18DEC2019 APVD B. BAIR 18DEC2019 PRODUCT SPEC APPLICATION SPEC WEIGHT Customer Accessible Production Drawing | | NAME STE TE Connectivity Harrisburg, PA 17105-3608 OCEAN 2.0 Side Feed Applicator SIZE CAGE CODE DRAWING NO. RESTRICTED TO A1 00779 ©=2837728 SCALE 1:2 SHEET 2 of 4 REV A | |
|---|--|--|--|---|--|

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

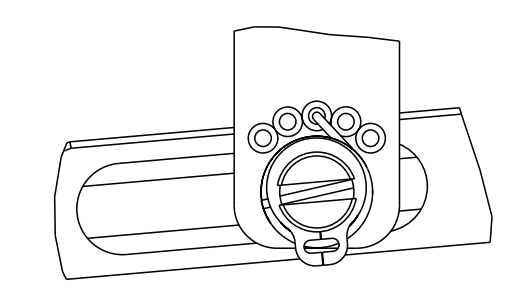
FEED TYPE MECHANICAL



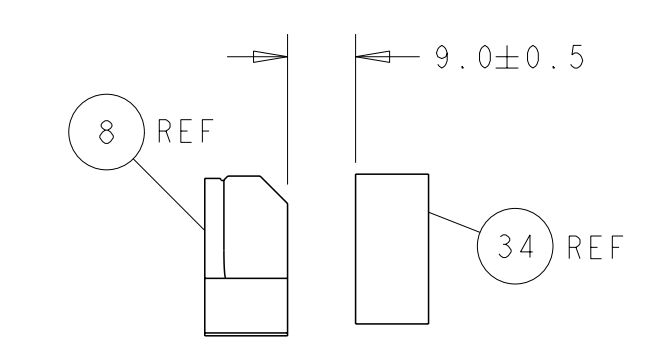
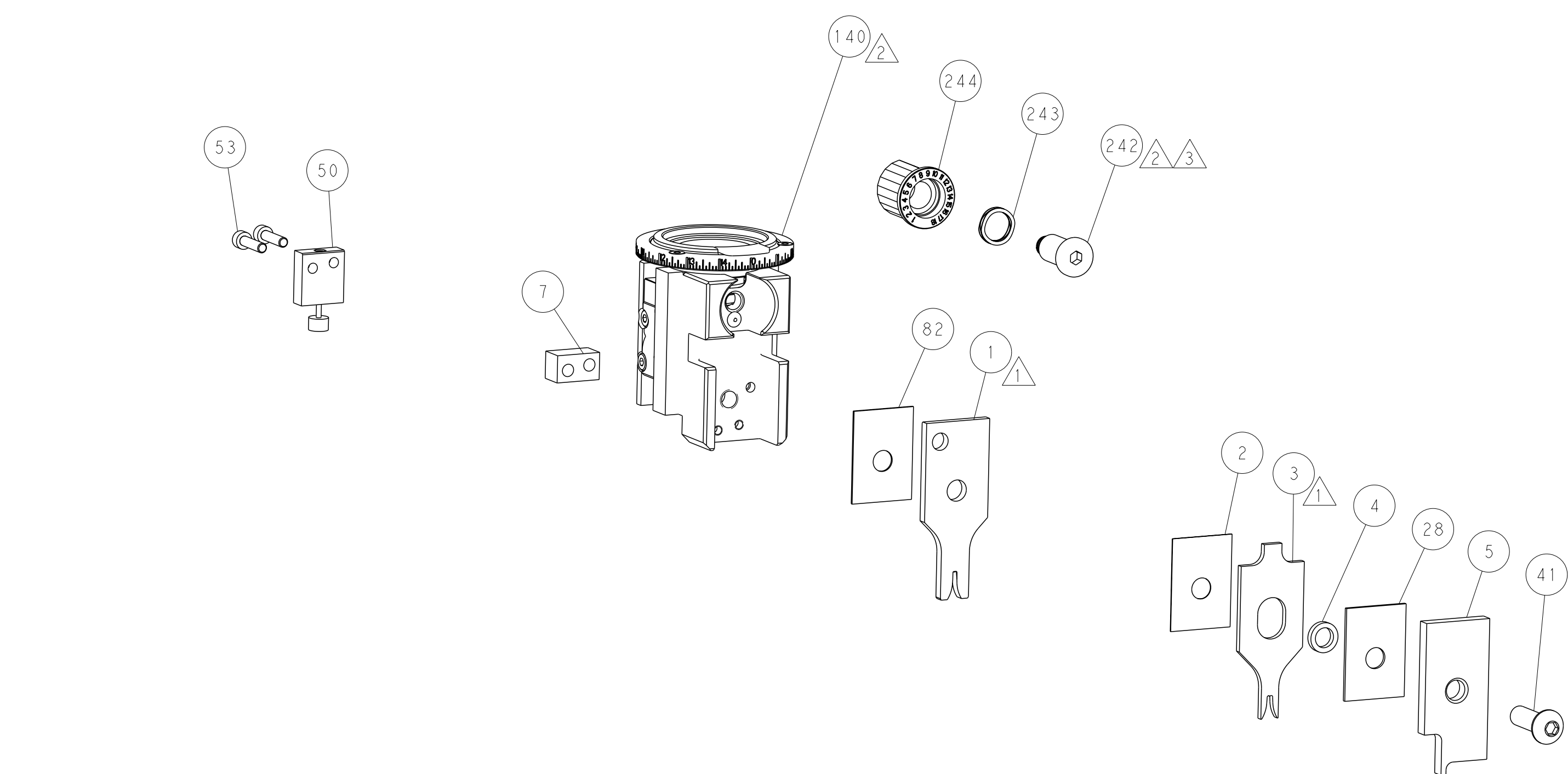
PNEUMATIC



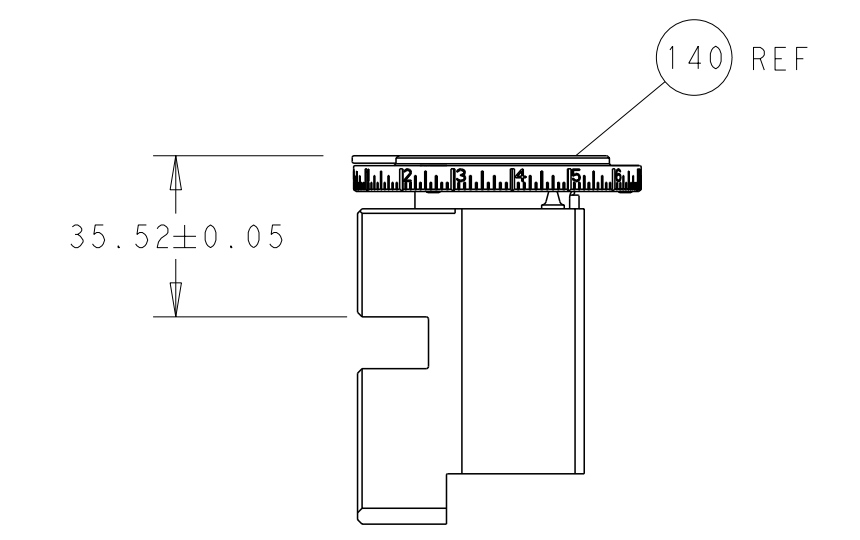
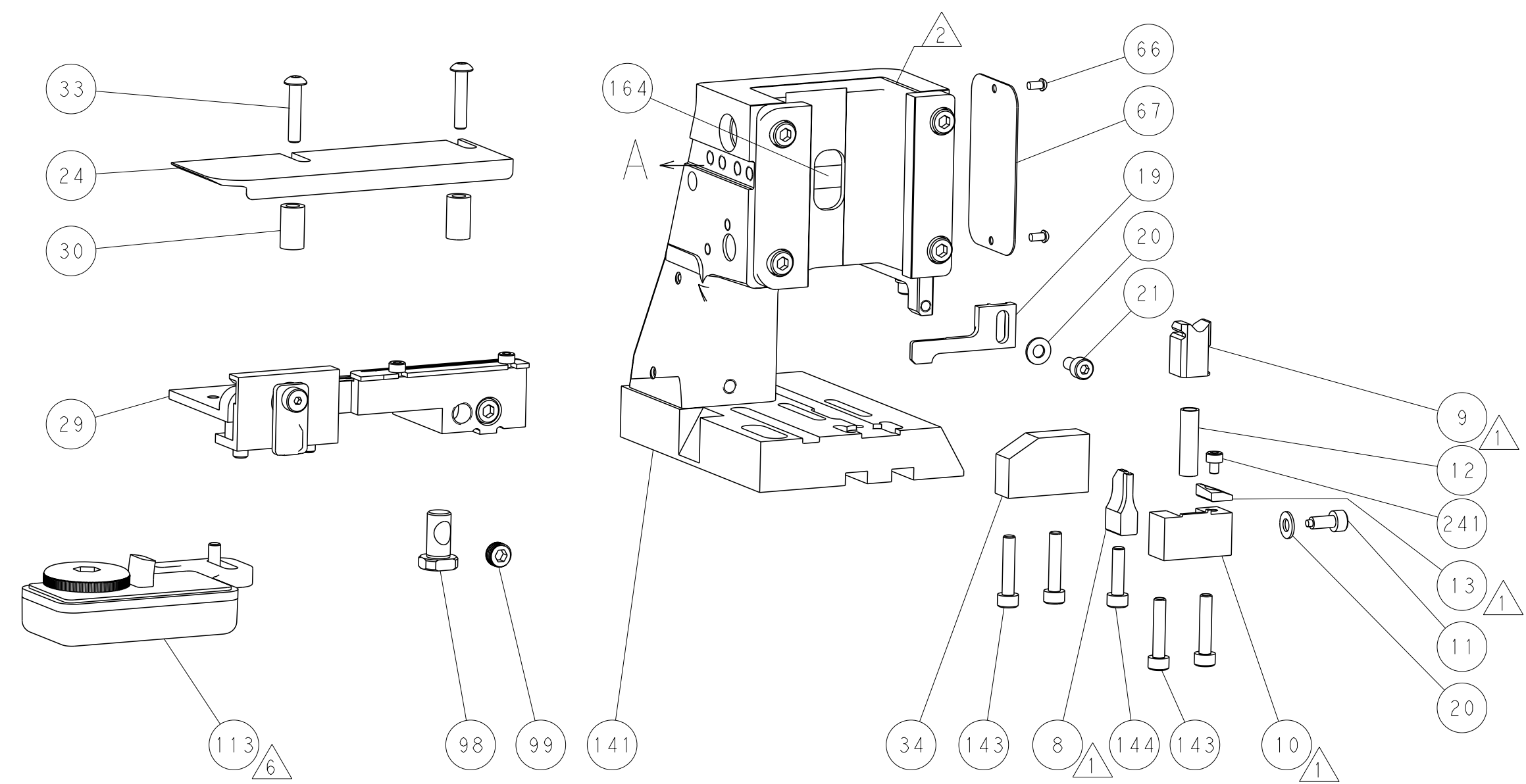
FEED SPRING SETTING POSITION
(SHOWN FROM REAR SIDE)



DETAIL A



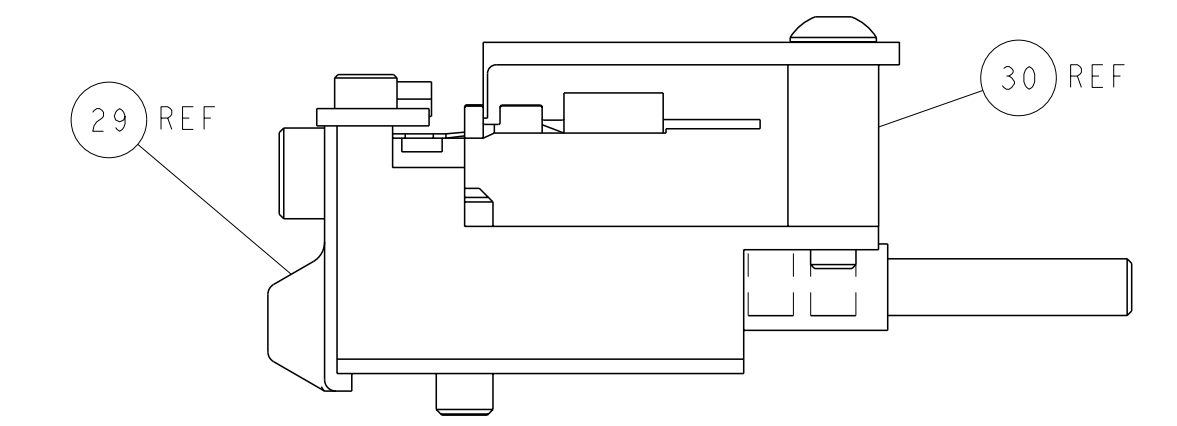
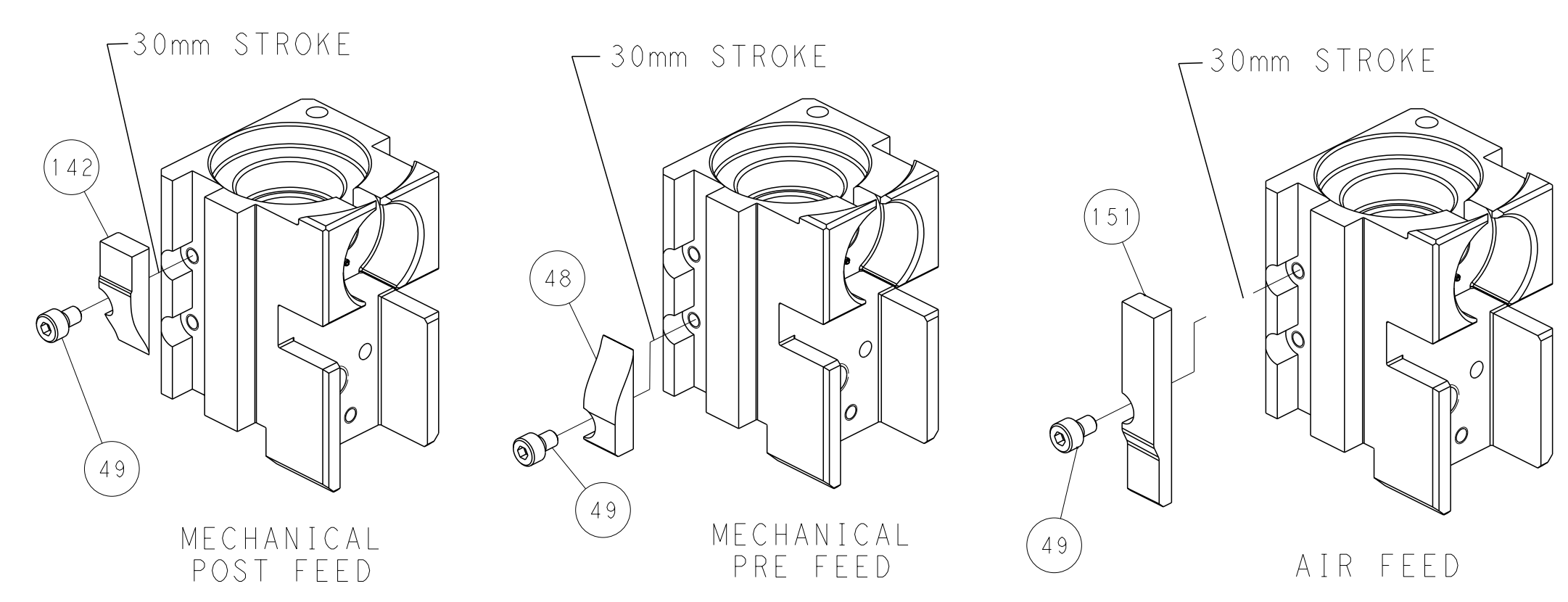
TERMINAL SUPPORT LOCATION



RAM SET-UP

ITEM 30 LOCATED AT
REAR HOLES

CAM POSITIONS



FEED TRACK POSITION
GUIDE BY INSULATION BARREL

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> | | OWN: M. HERR CHK: G. BAILEY APVD: B. BAIR PRODUCT SPEC: - APPLICATION SPEC: - MATERIAL: - FINISH: - | DATE: 18DEC2019 NAME: OCEAN 2.0 Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2837728 SCALE: 1:2 SHEET: 4 of 4 REV: A | TE Connectivity Harrisburg, PA 17105-3608 |
| DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH ± | | WEIGHT: - Customer Accessible Production Drawing | RESTRICTED TO: - | |