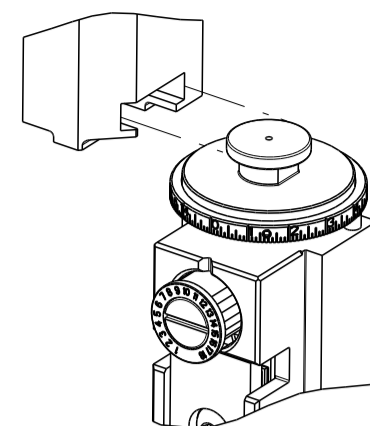


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2837869-2	D	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
3-2837869-2	D	FINE CRIMP HEIGHT ADJUST	DOUBLE ACTING PNEUMATIC WITH SENSORS
7-2837869-2	D	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2837869-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER

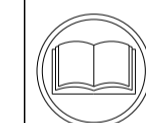


APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.17 mm [.046]	F
INSUL	-	-

APPLICATOR INSTRUCTIONS
408-35042

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: CENTER CONTACT, SOCKET, 180 DEG MINI COAX			
WIRE STRIP LENGTH		TERMINAL INSULATION DIAMETER RANGE	
2.35-2.65 mm [.093-.104 IN]		∅	
TERMINAL APPLICATION SPECIFICATION	114-94413		AT9106
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
2298121-1			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
RTK044	0.88+/-0.02 [.035+/- .001]	6.2



- RECOMMENDED SPARE PARTS
- REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION & STORAGE OF APPLICATOR.
- TERMINAL LUBRICANT IS RECOMMENDED.
- 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.
- TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- THIS APPLICATOR IS EQUIPPED WITH THE DOUBLE ACTING FEED WITH SENSORS AND IS APPLICATION SPECIFIC. IT DOES NOT REQUIRE ITEMS 49 & 248.

***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	REVISIONS					
A	66	P	LTN	DESCRIPTION	DATE	OWN	APVD
		A		RELEASED	04FEB2021	MEH	GB
		B		ECR-21-004956	28APR2021	TB	RR
		C		ECR-21-006466	23JUN2021	TB	GB
		D		ECR-23-174141	03MAY2023	TB	GB

-	1	1	1	2392024-4	TONKER		300
-	1	1	1	22278-9	SPRING, COMPRESSION		299
-	4	4	4	4-18032-3	SCR, SET, FLT PNT, M3 X 6.0		298
-	1	1	1	1803944-1	SPACER, TONKER		297
-	-	1	-	2844950-1	AIR FEED MODULE		290
-	1	1	1	1-2079383-0	SCR, BHSC, RoHS (M3 X 6)		284
-	1	1	1	1-1633289-0	STABILIZER		283
-	1	1	1	1803461-1	HOLDER, STABILIZER		282
-	1	1	1	2-1722335-1	Thread bolt Gewindebolzen		261
-	1	-	1	2119641-1	FEED CAM, AIR FEED		248
-	1	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0		241
-	1	-	1	2844940-1	AIR FEED MODULE		238
-	REF	REF	REF	994970-2	COUNTER, MAGNETIC		164
-	1	1	1	1-22281-8	SPRING, COMPRESSION		121
-	1	1	1	2119955-1	ASSY, LUBRICATOR, SIDE FEED		113
-	1	1	1	2844908-1	SCREW, LOCKING		99
-	1	1	1	2844907-1	POST, LOCKING		98
-	1	1	1	3-690438-1	FRONT STRIP GUIDE		96
-	2	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0		95
-	1	1	1	2168083-6	SCR, SKT HD CAP, RoHS, M5 X 65		93
-	1	1	1	455888-9	SPACER, CRIMPER		82
-	1	1	1	5-547505-2	SPRING, COMPRESSION		77
-	1	1	1	854769-4	HOLDER, INS		74
-	1	1	1	1803607-3	DOCUMENTATION PACKAGE		71
-	1	1	1	2119740-1	TAG, IDENTIFICATION		67
-	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188		66
-	1	1	1	2-18032-5	SCR, SET, FLT PNT, M5 X 20.0		61
-	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0		60
-	1	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0		59
-	1	1	1	21028-2	PIN, SLOTTED SPRING .062 X .250		58
-	1	1	1	1338685-1	PAWL, FEED		56
-	4	4	4	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0		54
-	2	2	2	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0		53
-	1	-	1	18023-9	SCR, SKT HD CAP M4 X 6.0		49
-	1	1	1	1803583-9	APPLICATOR BASIC ASSEMBLY, SF		46
-	1	1	1	1803515-1	RAM ASSEMBLY, SF ATLANTIC		44
-	1	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)		41
-	1	1	1	2-1752356-6	SUPPORT, TERMINAL		34
-	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)		33
-	2	2	2	2-2844962-3	SPACER, CYLINDRICAL, STRIP GUIDE		30
-	1	1	1	2844938-1	PLATE, STRIP GUIDE		29
-	1	1	1	3-455888-7	SPACER, CRIMPER		28
-	2	2	2	22281-8	SPRING, COMPRESSION		27
-	1	1	1	356835-1	LEVER, DRAG RELEASE		26
-	1	1	1	1803142-1	DRAG, TERMINAL		25
-	1	1	1	1320928-2	STRIP GUIDE		24
-	1	1	1	980371-4	SCR, SKT HD SHLDR 5.0 DIA X 6.0		23
-	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0		21
-	2	2	2	1-18028-2	WASHER, FLAT, REG M4		20
-	1	1	1	1803213-1	STRIPPER		19
-	1	1	1	2119806-1	INSERT, SHEAR		13
-	1	1	1	3-22280-3	SPRING, COMPRESSION		12
-	1	1	1	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10		11
-	1	1	1	2119805-1	SHEAR HOLDER, FRONT		10
-	1	1	1	2-1803095-1	FLOATING SHEAR, FRONT		9
-	1	2	1	4-1803412-3	ANVIL, COMBINATION		8
-	-	-	-	-	-		7
-	-	-	-	-	-		6
-	1	1	1	2119780-9	DEPRESSOR, SHEAR		5
-	-	-	-	-	-		4
-	-	-	-	-	-		3
-	-	-	-	-	-		2
-	1	2	1	3-1803125-3	CRIMPER, WIRE		1

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

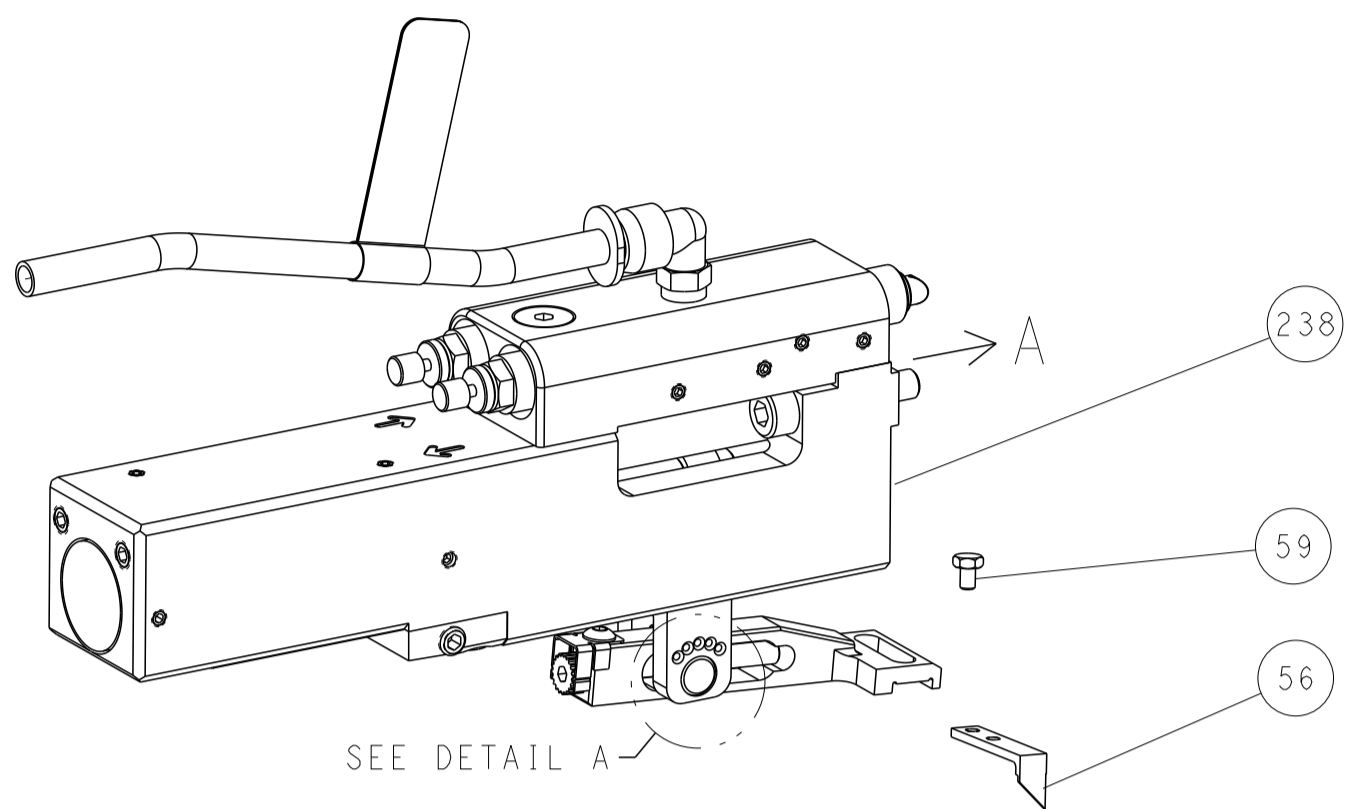
OWN	T. BROOKENS	17AUG2020	
CHK	M. HERR	17AUG2020	
APVD	G. BAILEY	17AUG2020	
NAME	OCEAN 2.0 Side Feed Applicator		
SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
A1	00779	2837869	
Customer Accessible Production Drawing		SCALE	1:2 SHEET 1 OF 4 REV D

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

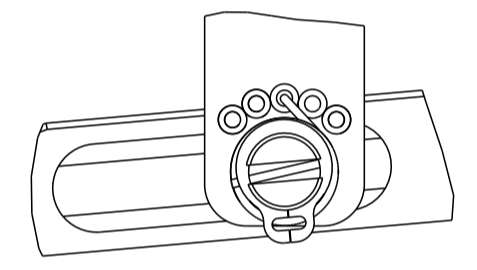
LOC	DIST	REVISIONS					
A	66	P	LTN	DESCRIPTION	DATE	OWN	APVD
		-		SEE SHEET 1	-	-	-

FEED TYPE

PNEUMATIC

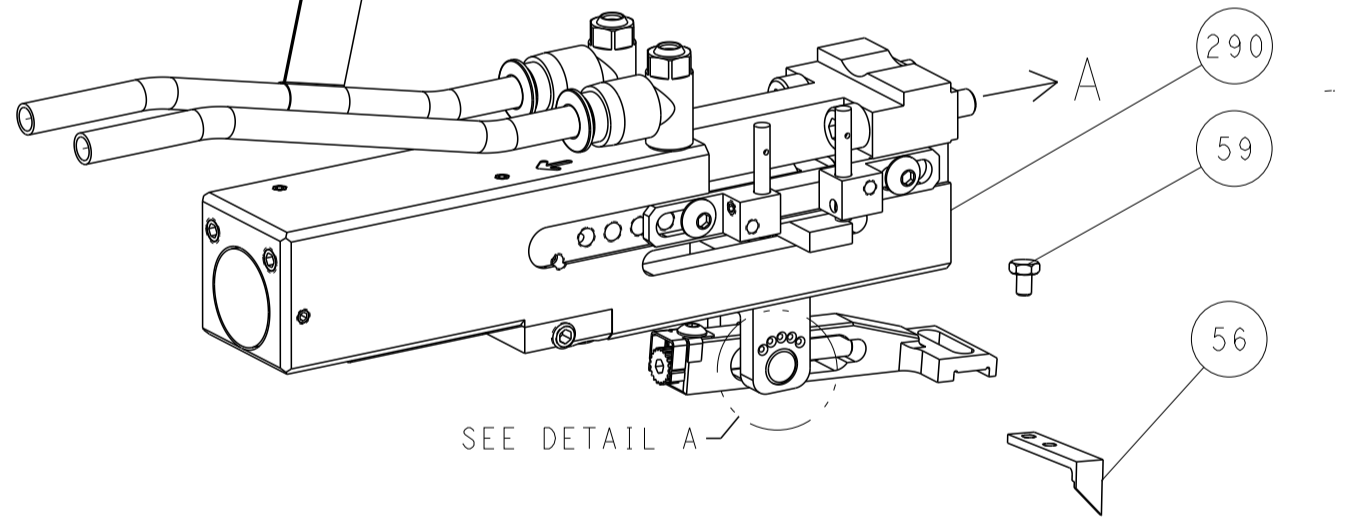


FEED SPRING SETTING POSITION
(SHOWN FROM REAR SIDE)



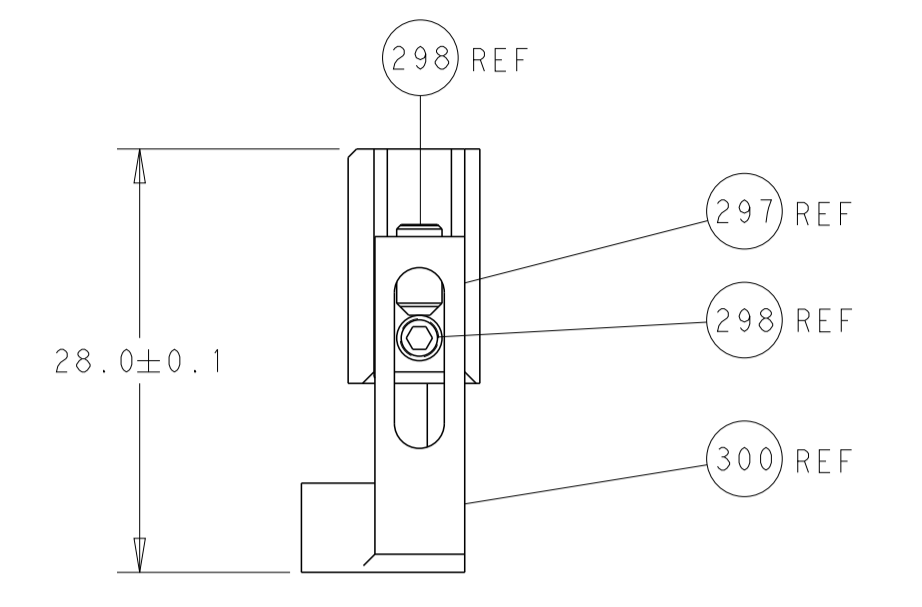
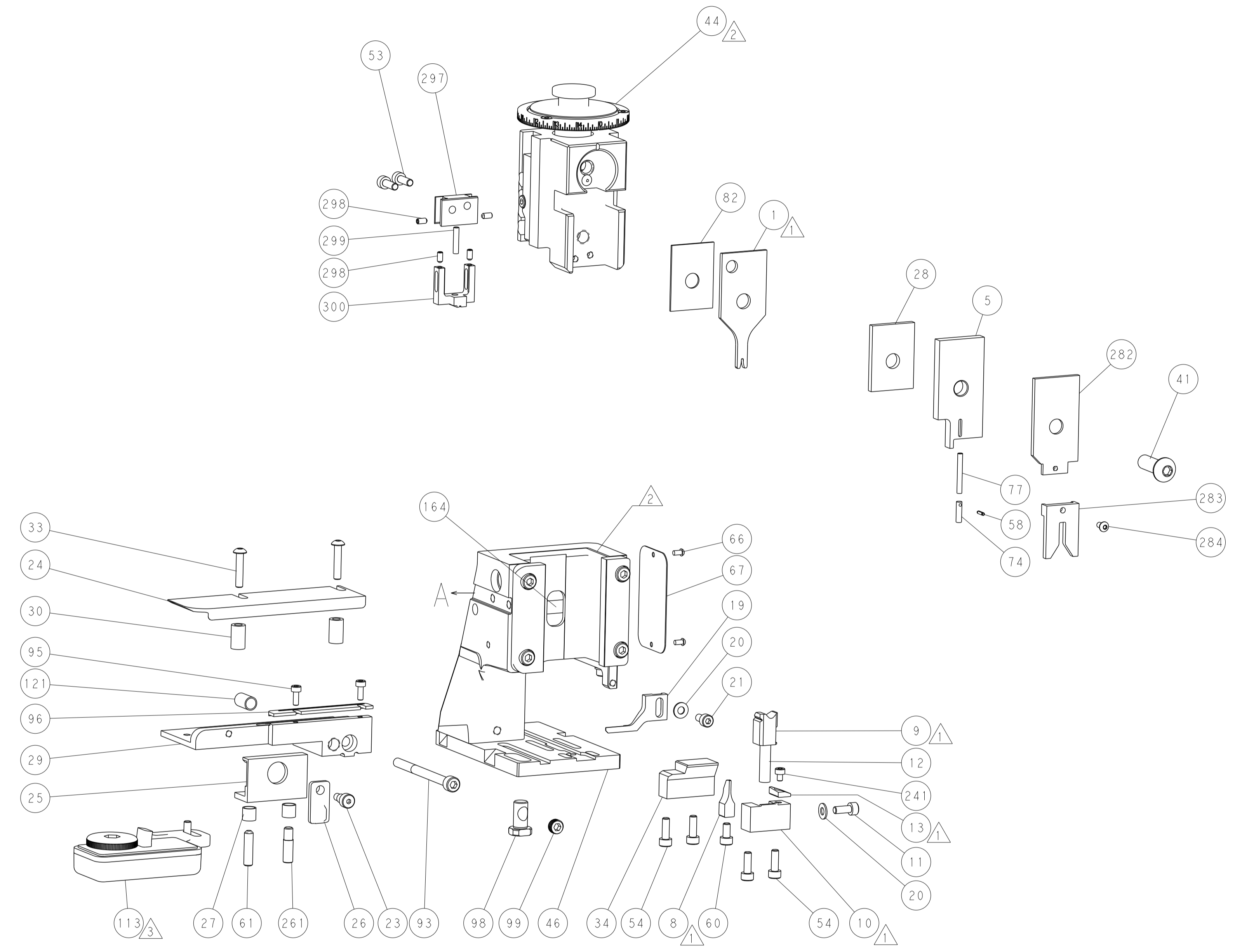
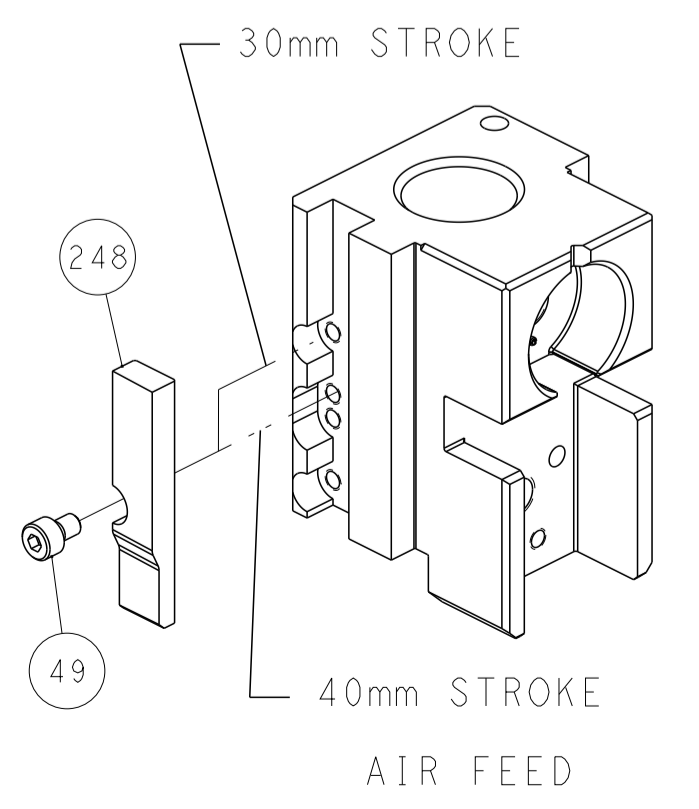
DETAIL A

DOUBLE ACTING PNEUMATIC WITH SENSORS

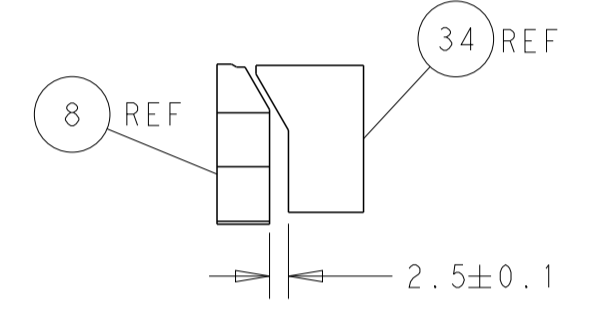


SEE DETAIL A

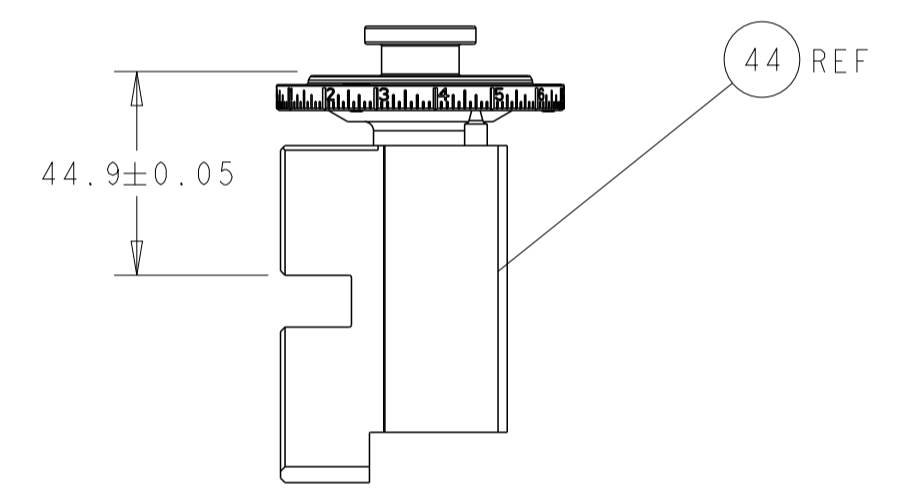
CAM POSITION



HOLD DOWN SET-UP

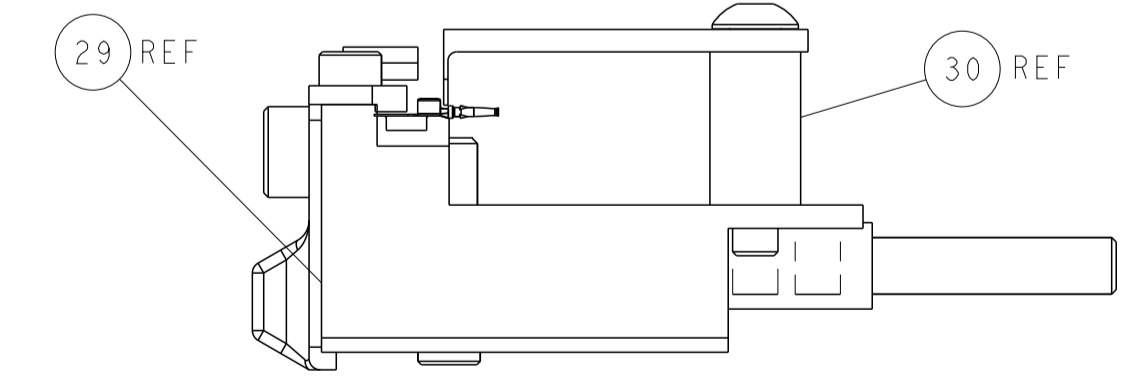


TERMINAL SUPPORT LOCATION



RAM SET-UP

ITEM 30 LOCATED AT FRONT HOLES



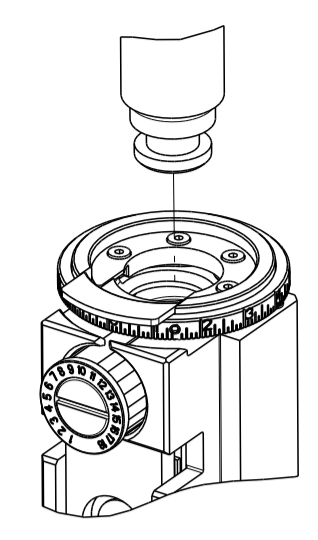
FEED TRACK POSITION GUIDE BY WIRE BARREL

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

<small>THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION. ALL RIGHTS RESERVED.</small> <small>IT IS THE POLICY OF TYCO ELECTRONICS CORPORATION TO CONTINUE TO IMPROVE OUR PRODUCTS. THEREFORE, THIS DRAWING IS SUBJECT TO CHANGE WITHOUT NOTICE AND WITHOUT OBLIGATION TO BE NOTIFIED OF SUCH CHANGE.</small>		DWN T. BROOKS 17AUG2020 CHK M. HERR 17AUG2020 APVD G. BAILEY 17AUG2020	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 RESTRICTED TO A1 00779 C=2837869
MATERIAL:		WEIGHT:	SCALE 1:2 SHEET 2 OF 4 REV D Customer Accessible Production Drawing

THIS DRAWING IS UNPUBLISHED.	RELEASED FOR PUBLICATION		
COPYRIGHT 20 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.			
PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2837869-2	D	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
4-2837869-2	D	FINE CRIMP HEIGHT ADJUST	DOUBLE ACTING PNEUMATIC WITH SENSORS
7-2837869-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.17 mm [.046]	F
INSUL	-	-
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: CENTER CONTACT, SOCKET, 180 DEG MINI COAX			
WIRE STRIP LENGTH 2.35-2.65 mm [.093-.104 IN]		TERMINAL INSULATION DIAMETER RANGE Ø	
TERMINAL APPLICATION SPECIFICATION	114-94413	-	-
TERMINALS APPLIED		AT9106	
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
2298121-1			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
RTK044	0.88 +/- 0.02 [.035 +/- .001]	6.2

- 1 RECOMMENDED SPARE PARTS
- 2 REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- 3 TERMINAL LUBRICANT IS RECOMMENDED
- 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 TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- 7 THIS APPLICATOR IS EQUIPPED WITH THE DOUBLE ACTING FEED WITH SENSORS AND IS APPLICATION SPECIFIC. IT DOES NOT REQUIRE ITEMS 49 & 151

***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	APPD
A	66	-	-	-	-

REVISIONS						
REV	DATE	BY	APPD	DESCRIPTION	ITEM NO	
-	-	-	-	SEE SHEET 1	-	
-	1	1		2392024-4	TONKER	300
-	1	1		22278-9	SPRING, COMPRESSION	299
-	4	4		4-18032-3	SCR, SET, FLT PNT, M3 X 6.0	298
-	1	1		1803944-1	SPACER, TONKER	297
-	1	-		2844950-1	AIR FEED MODULE	290
-	1	1		1-2079383-0	SCR, BHSC, RoHS (M3 X 6)	284
-	1	1		1-1633289-0	STABILIZER	283
-	1	1		1803461-1	HOLDER, STABILIZER	282
-	1	1		2-1722335-1	Thread bolt Gewindebolzen	261
-	1	1		7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
-	-	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	1		1-1803583-0	APPLICATOR BASIC ASSEMBLY, SF	141
-	1	1		1803516-1	RAM ASSEMBLY, SF PACIFIC	140
-	1	1		1-22281-8	SPRING, COMPRESSION	121
-	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		3-690438-1	FRONT STRIP GUIDE	96
-	2	2		2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	95
-	1	1		2168083-6	SCR, SKT HD CAP, RoHS, M5 X 65	93
-	1	1		455888-9	SPACER, CRIMPER	82
-	1	1		5-547505-2	SPRING, COMPRESSION	77
-	1	1		854769-4	HOLDER, INS	74
-	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		2-18032-5	SCR, SET, FLT PNT, M5 X 20.0	61
-	1	1		5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	1	1		21028-2	PIN, SLOTTED SPRING .062 X .250	58
-	1	1		1338685-1	PAWL, FEED	56
-	2	2		2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	53
-	-	1		18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	1	1		1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
-	1	1		2-1752356-6	SUPPORT, TERMINAL	34
-	2	2		2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2		2-2844962-3	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1		2844938-1	PLATE, STRIP GUIDE	29
-	1	1		3-455888-7	SPACER, CRIMPER	28
-	2	2		22281-8	SPRING, COMPRESSION	27
-	1	1		356835-1	LEVER, DRAG RELEASE	26
-	1	1		1803142-1	DRAG, TERMINAL	25
-	1	1		1320928-2	STRIP GUIDE	24
-	1	1		980371-4	SCR, SKT HD SHLDR 5.0 DIA X 6.0	23
-	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		1803213-1	STRIPPER	19
-	1	1		2119806-1	INSERT, SHEAR	13
-	1	1		3-22280-3	SPRING, COMPRESSION	12
-	1	1		1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	11
-	1	1		2119805-1	SHEAR HOLDER, FRONT	10
-	1	1		2-1803095-1	FLOATING SHEAR, FRONT	9
-	1	1		4-1803412-3	ANVIL, COMBINATION	8
-	-	-		-	-	7
-	-	-		-	-	6
-	1	1		2119780-9	DEPRESSOR, SHEAR	5
-	-	-		-	-	4
-	-	-		-	-	3
-	-	-		-	-	2
-	1	1		3-1803125-3	CRIMPER, WIRE	1

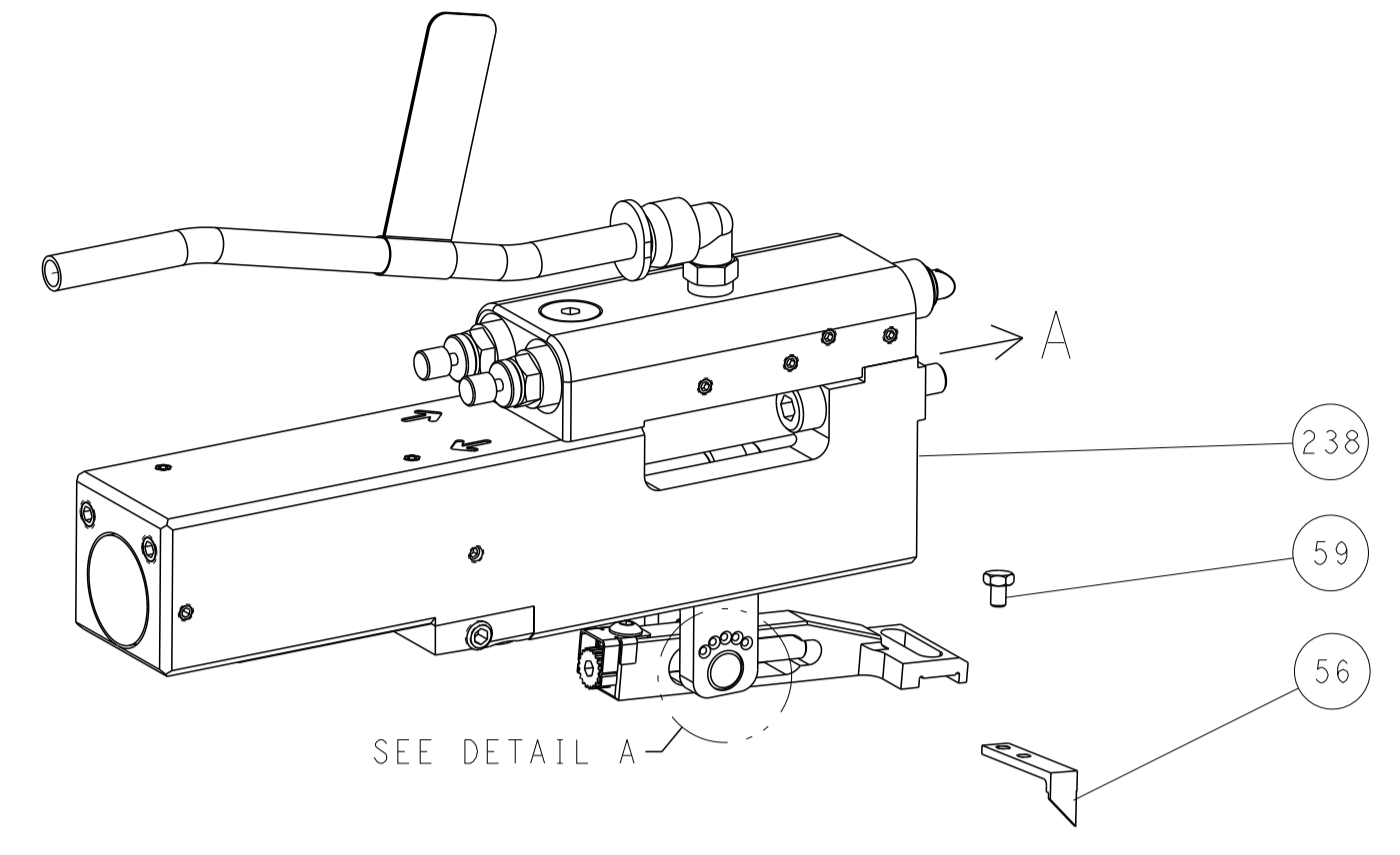
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG		CHK		APPD		DATE	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	5 PLC ±	6 PLC ±	7 PLC ±	8 PLC ±	T. BROOKENS	17AUG2020
	ANGLES	FINISH								M. HERR	17AUG2020
										G. BAILEY	17AUG2020
MATERIAL		FINISH		WEIGHT		SCALE		SHEET		REV	
						A 00779		3 OF 4		D	



OCEAN 2.0 Side Feed Applicator

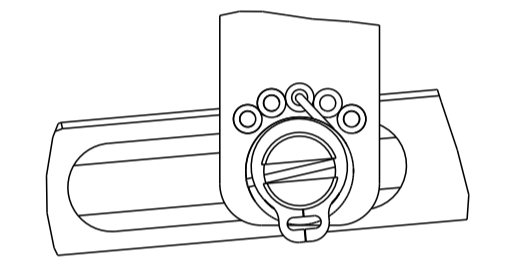
LOC	DIST	REV	DESCRIPTION	DATE	OWN	APVD
A	66		SEE SHEET 1			

FEED TYPE PNEUMATIC



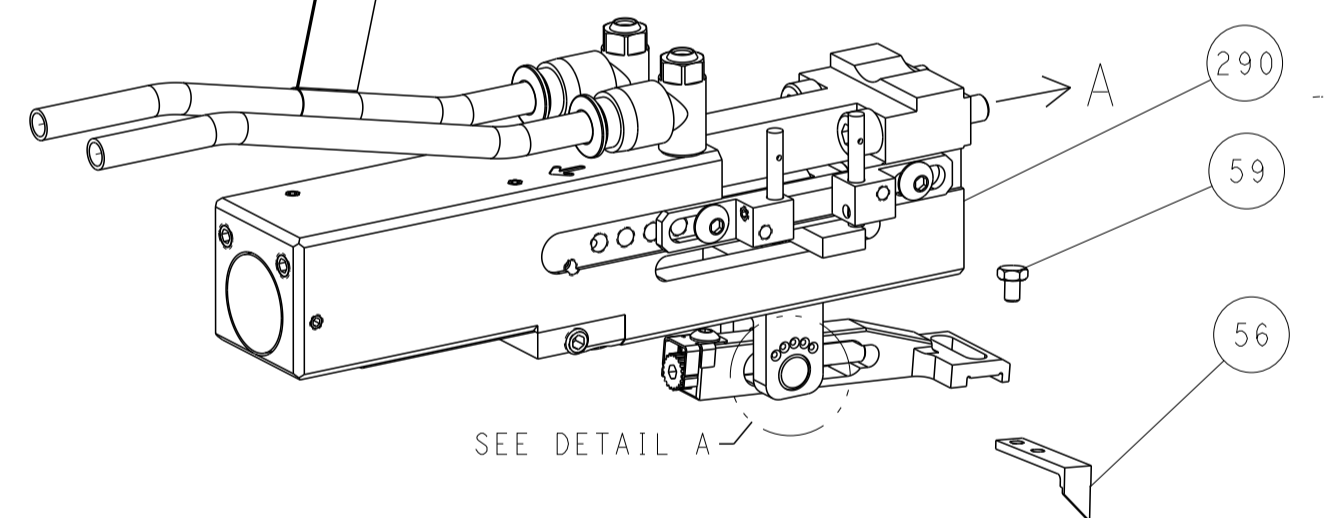
SEE DETAIL A

FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



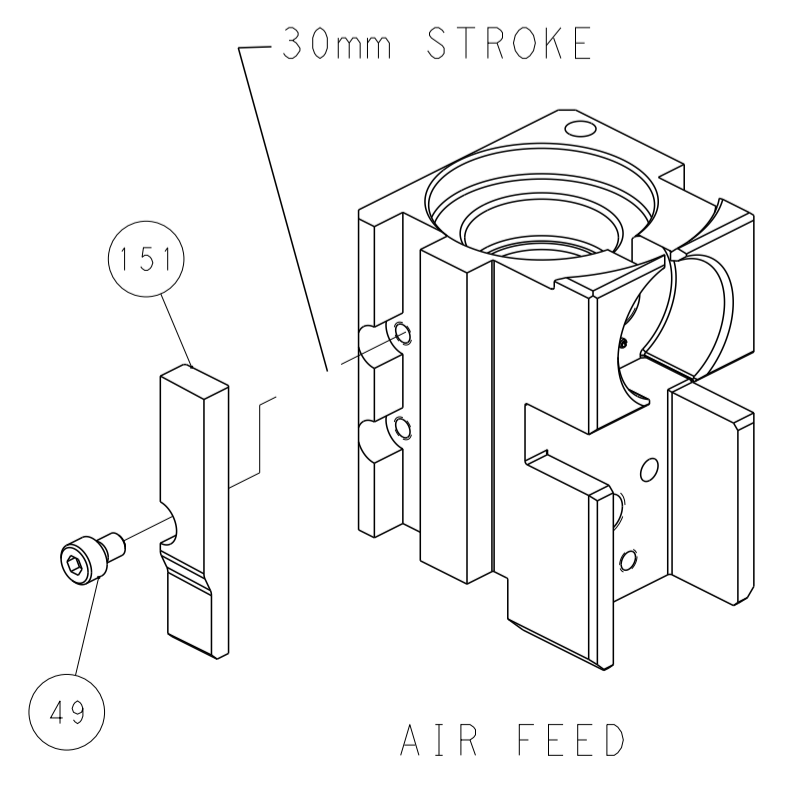
DETAIL A

DOUBLE ACTING PNEUMATIC WITH SENSORS

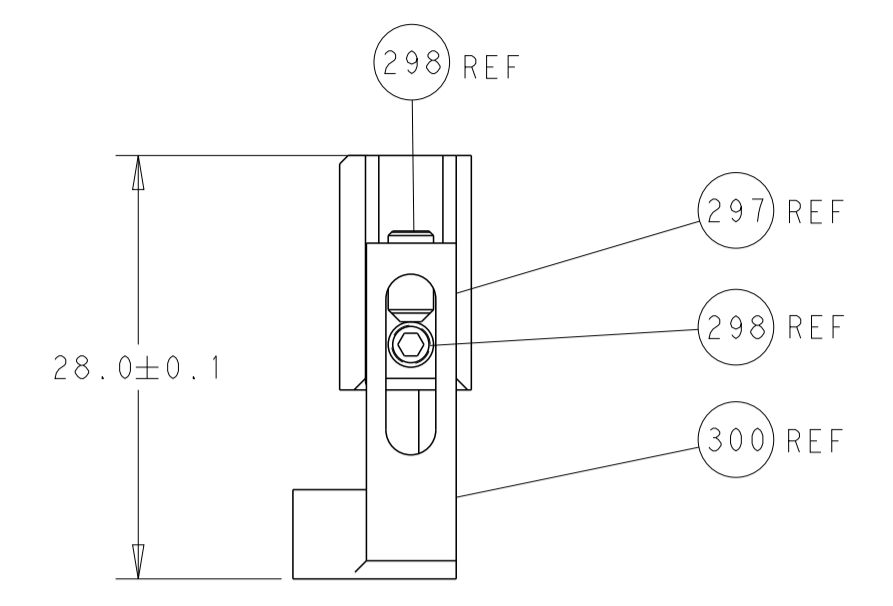
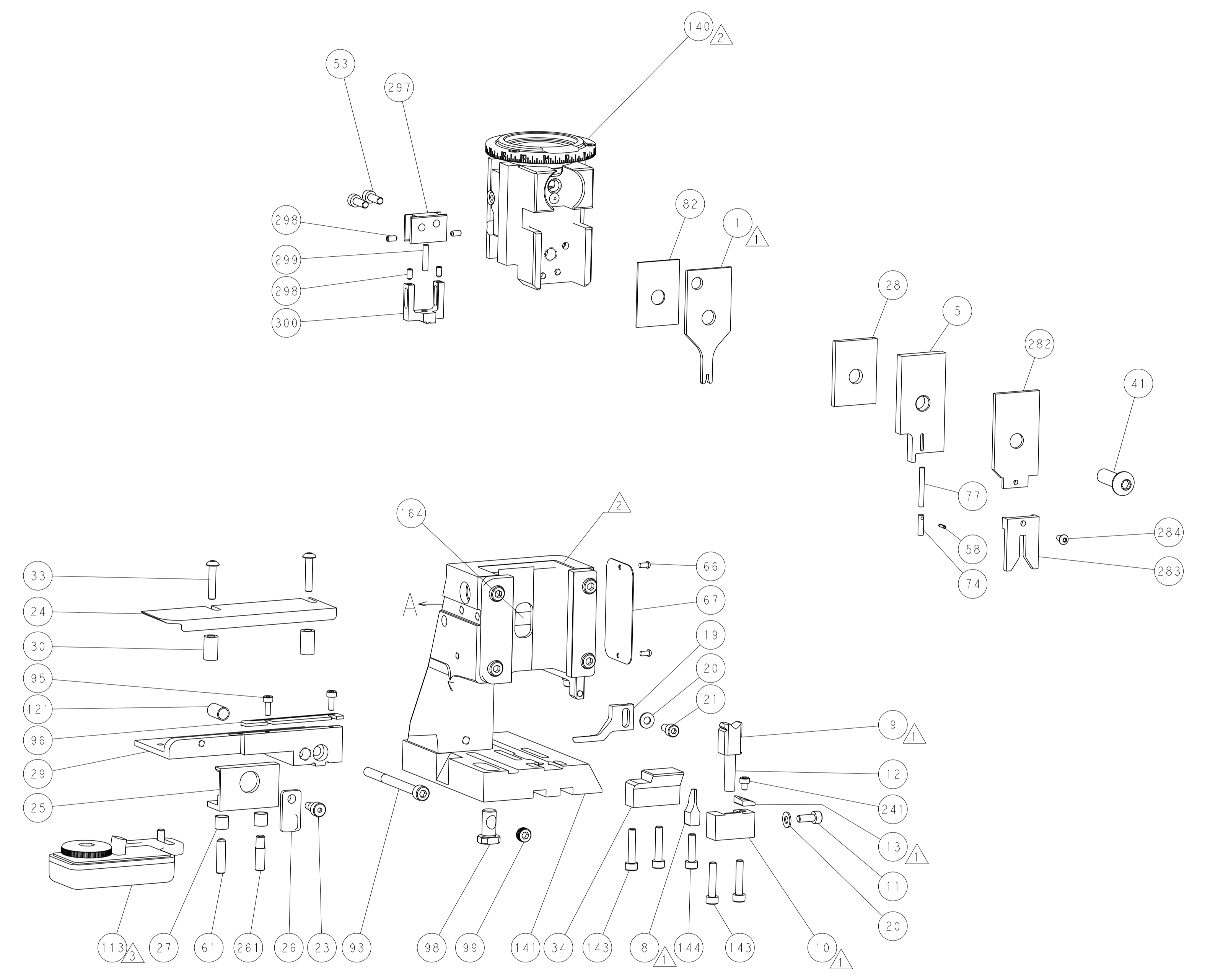


SEE DETAIL A

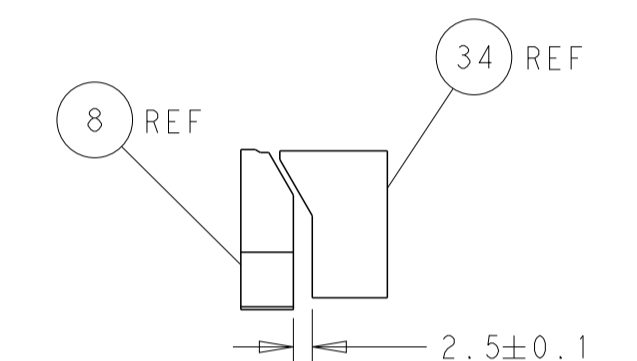
CAM POSITION



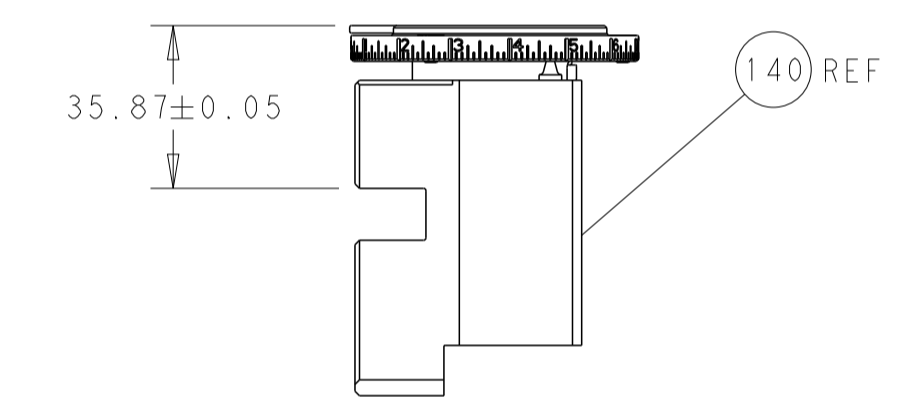
AIR FEED



HOLD DOWN SET-UP

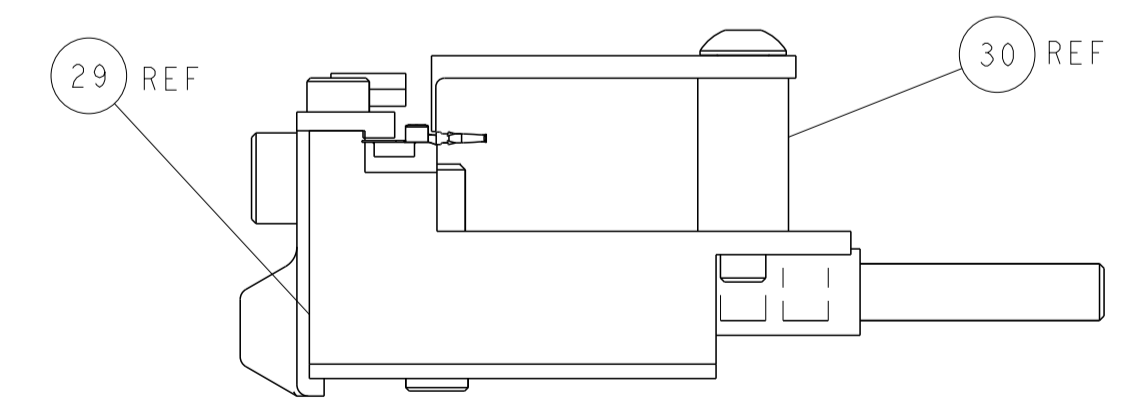


TERMINAL SUPPORT LOCATION



RAM SET-UP

ITEM 30 LOCATED AT FRONT HOLES



FEED TRACK POSITION GUIDE BY WIRE BARREL

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

DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH		DWN T. BROOKENS 17AUG2020 CHK M. HERR 17AUG2020 APVD G. BAILEY 17AUG2020 PRODUCT SPEC APPLICATION SPEC SIZE CAGE CODE DRAWING NO A1 00779 C=2837869 RESTRICTED TO	
MATERIAL:		WEIGHT:		NAME: OCEAN 2.0 Side Feed Applicator SCALE: 1:2 SHEET 4 OF 4 REV D Customer Accessible Production Drawing	