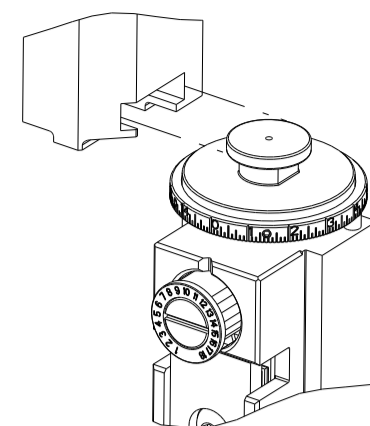


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2837880-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2837880-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2837880-1	B	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2837880-2	B	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2837880-7	B	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.60 mm [.102]	F
INSUL	2.80 mm [.110]	O

APPLICATOR INSTRUCTIONS 408-35042

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: XRC TERMINAL FAMILY			
WIRE STRIP LENGTH		TERMINAL INSULATION DIAMETER RANGE	
3.81-5.08 mm [.150-.200 IN]		Ø1.91-2.41 mm [.075-.095 IN]	
TERMINAL APPLICATION SPECIFICATION	114-160066		AT9106
TERMINALS APPLIED			
TE TERMINAL	MOLEX TERMINAL	TE TERMINAL	MOLEX TERMINAL
2-2600020-2	84524-0008	2-2600021-3	84525-0017
2-2600020-3	84524-0016	2-2600021-5	84525-0039

WIRE SIZE	CRIMP HEIGHT mm [IN]	CRIMP HEIGHT REFERENCE SETTING
14 AWG	1.62 +/- 0.05 [0.064 +/- .002]	5.7
16 AWG	1.37 +/- 0.05 [0.054 +/- .002]	8.0
18 AWG	1.21 +/- 0.05 [0.048 +/- .002]	9.9

- 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.
- WHEN RUNNING SERIES 2600020 TERMINAL, USE ITEM 34 TERMINAL SUPPORT. WHEN RUNNING SERIES 2600021 TERMINAL, USE ITEM 35 TERMINAL SUPPORT.
- TERMINAL LUBRICANT IS RECOMMENDED.
- WHEN SWITCHING BETWEEN TERMINALS, ITEM 29 MAY NEED TO BE ADJUSTED.

***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)

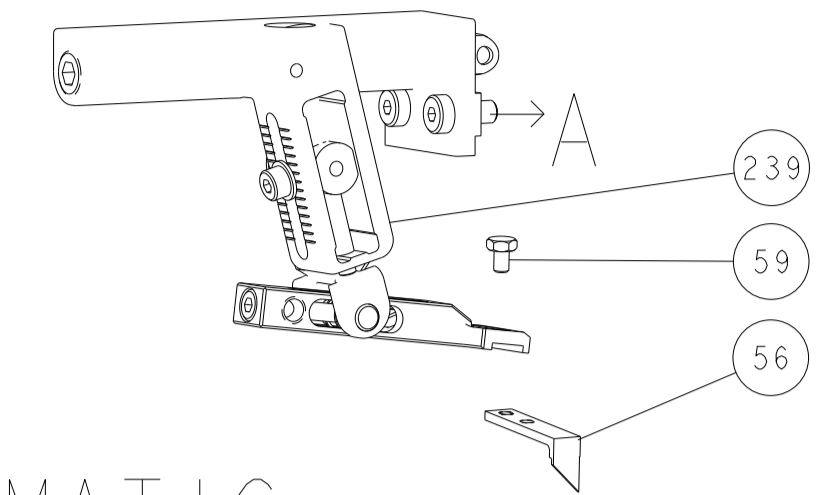
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		B		ECR-22-136743	21APR2022	JWC	TE
		B1		ECR-22-140780	30MAY2022	FZ	JAH

-	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
-	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	1803607-3	DOCUMENTATION PACKAGE	71
-	1	1	1	1	2119791-5	DEPRESSOR, WIRE	70
-	2	2	2	2	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	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	53
-	1	1	1	1	1803382-6	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	2-1752356-0	SUPPORT, TERMINAL	35
-	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	2-2844962-5	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	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	1-1803763-2	COMBINATION, ANVIL	8
-	1	1	1	1	2-240641-1	SPACER	7
-	-	-	-	-	-	-	6
-	1	1	1	1	2119757-8	DEPRESSOR, SHEAR	5
-	1	1	1	1	3-238011-3	BLOCK, CRIMPER SPACER	4
-	1	2	2	1	1-1633965-0	CRIMPER, INSULATION O PREMIUM	3
-	-	-	-	-	-	-	2
-	1	2	2	1	1-1803087-5	CRIMPER, WIRE	1
-	77	72	71	2	-1	PART NO	ITEM NO

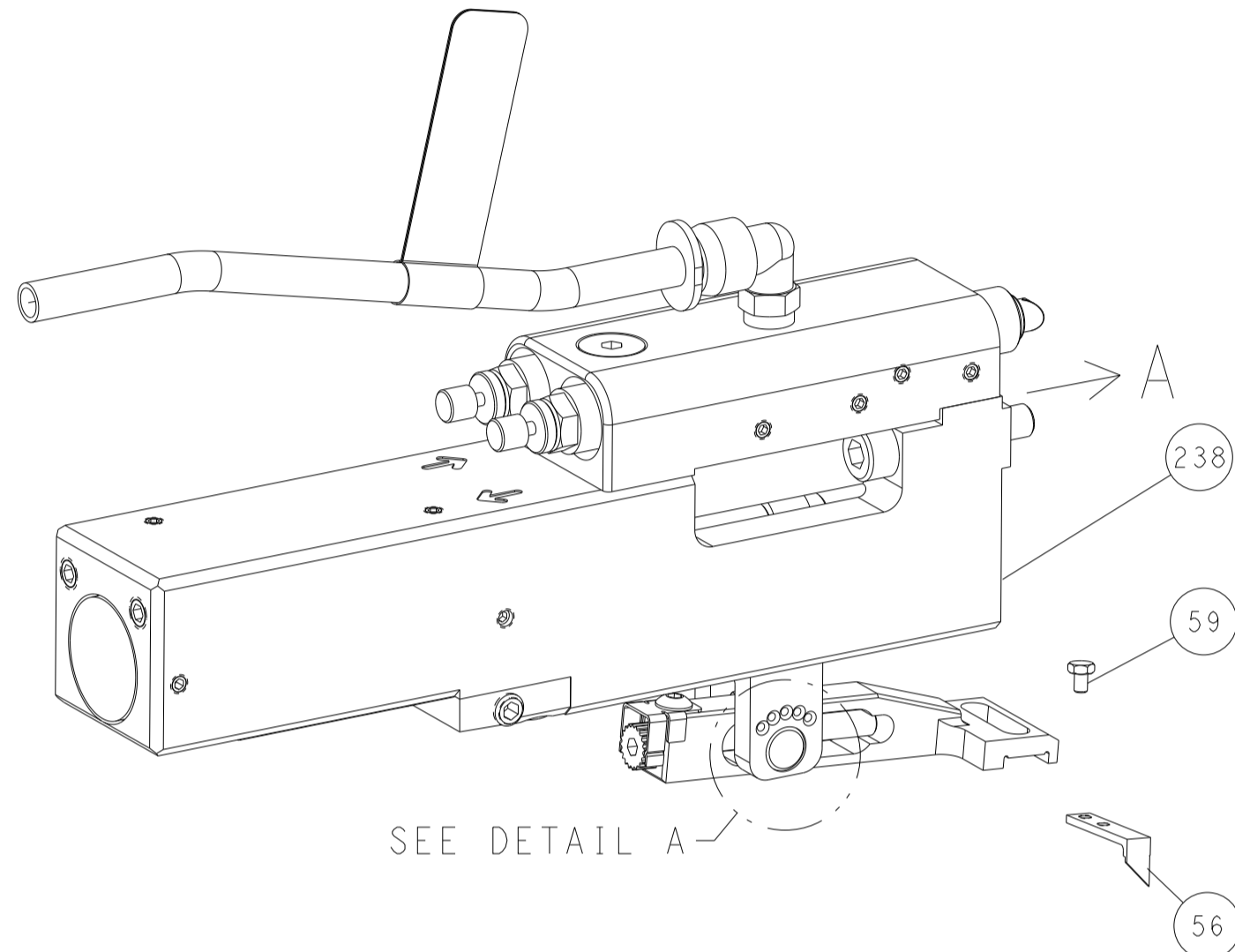
<small>THIS DRAWING IS UNPUBLISHED. IT IS THE PROPERTY OF TYCO ELECTRONICS CORPORATION. IT IS TO BE KEPT IN CONFIDENTIALITY AND NOT TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, INCLUDING PHOTOCOPYING, RECORDING, OR BY ANY INFORMATION STORAGE AND RETRIEVAL SYSTEM. PERMISSION TO COPY OR REPRODUCE THIS DRAWING IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, INCLUDING PHOTOCOPYING, RECORDING, OR BY ANY INFORMATION STORAGE AND RETRIEVAL SYSTEM, MUST BE OBTAINED FROM TYCO ELECTRONICS CORPORATION.</small>		OWN: M. HERR 27AUG2020 CHK: T. ELBIN 27AUG2020 APVD: B. BAIR 27AUG2020	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: A1 CAGE CODE: 00779 DRAWING NO: 2837880 SCALE: 1:2 SHEET: 1 of 4 REV: B1
MATERIAL:		WEIGHT:	RESTRICTED TO:
Customer Accessible Production Drawing		SCALE: 1:2	SHEET: 1 of 4 REV: B1

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

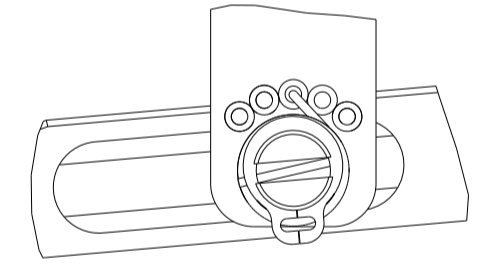
FEED TYPE MECHANICAL



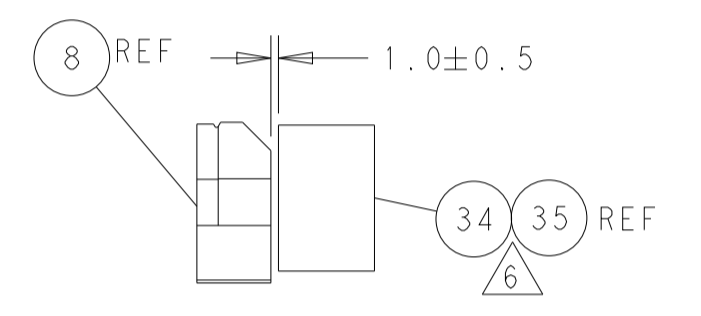
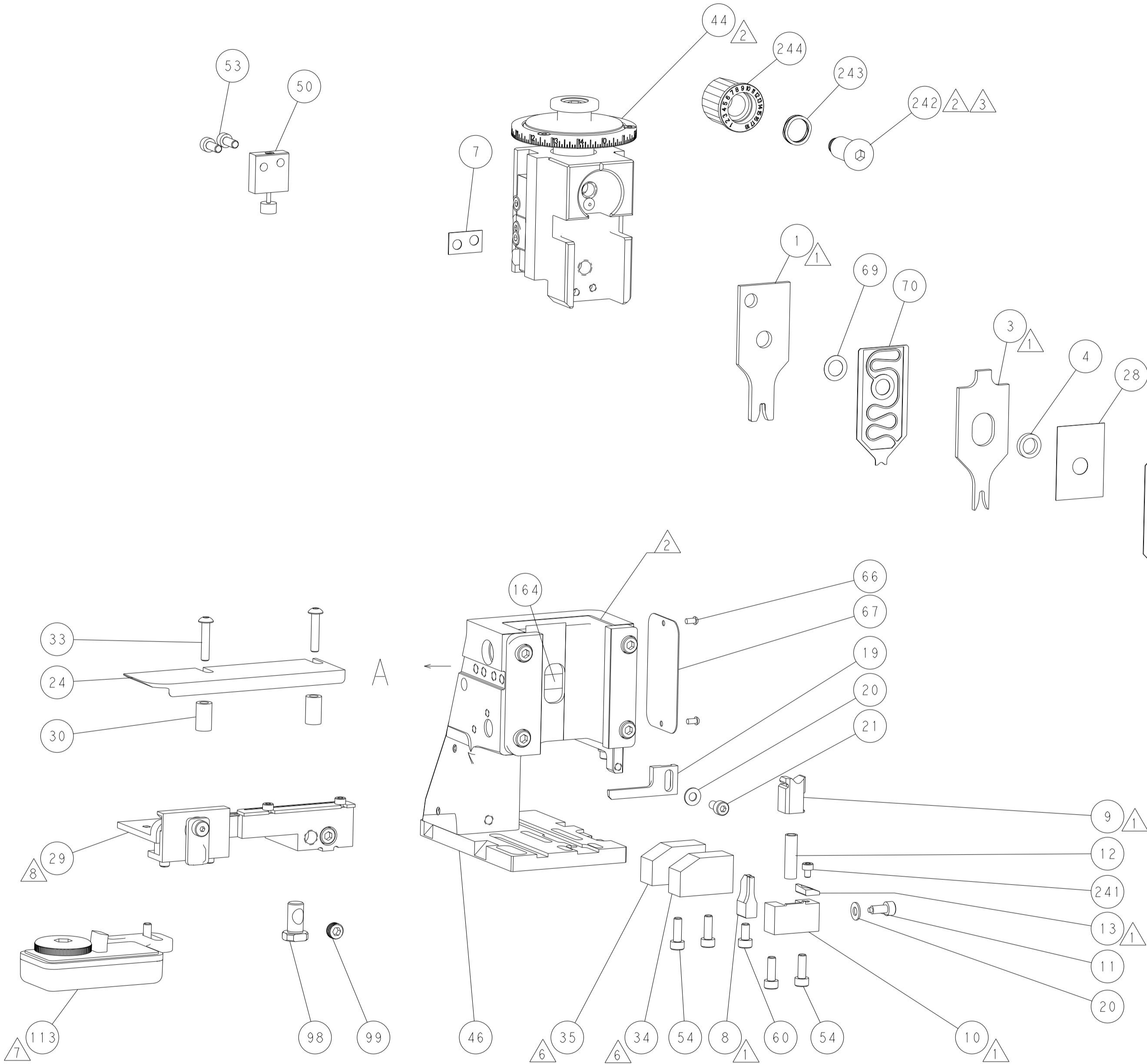
PNEUMATIC



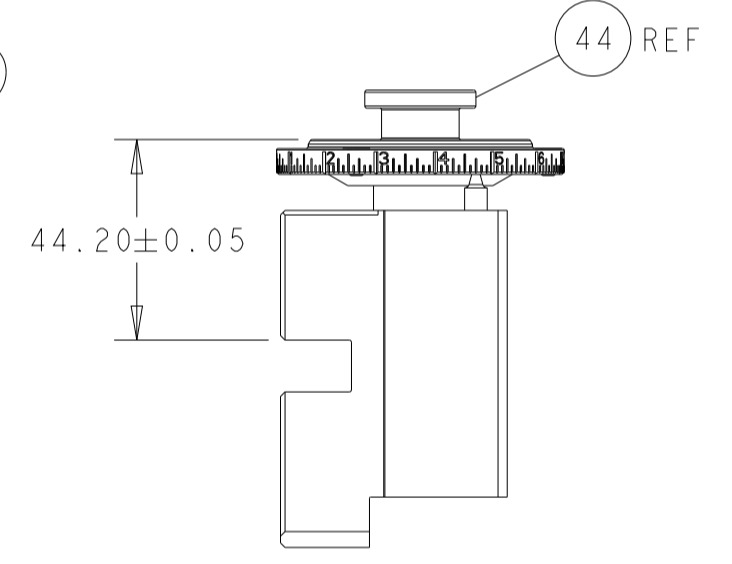
FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



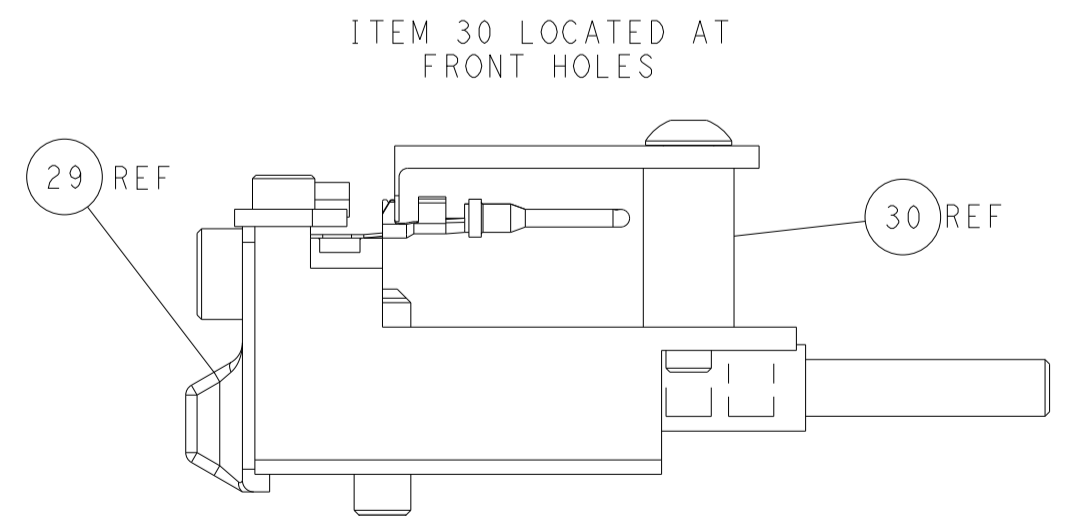
DETAIL A



TERMINAL SUPPORT LOCATION

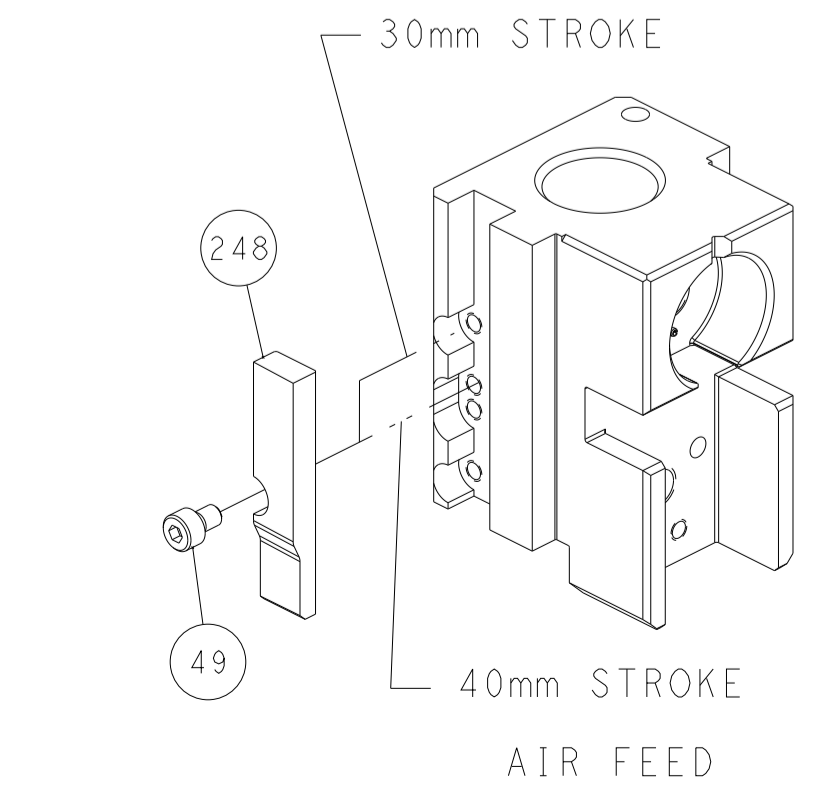
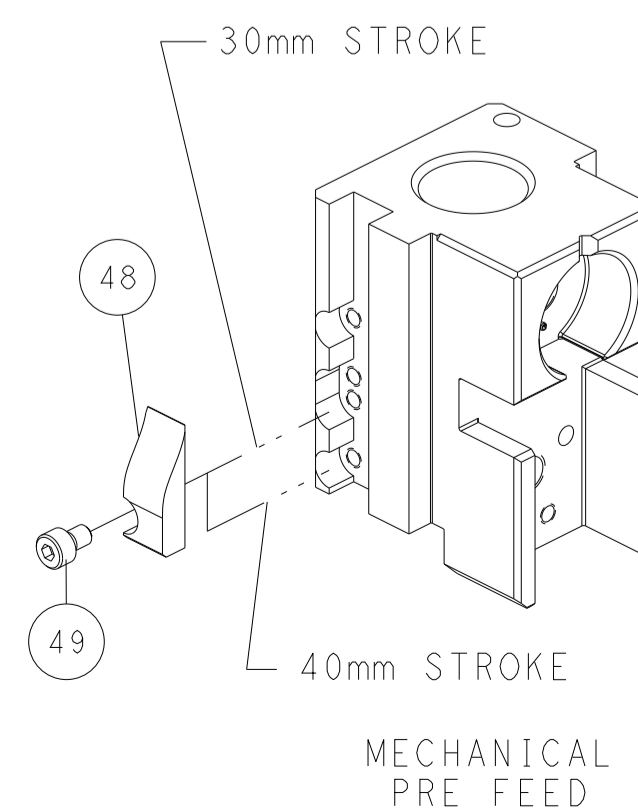
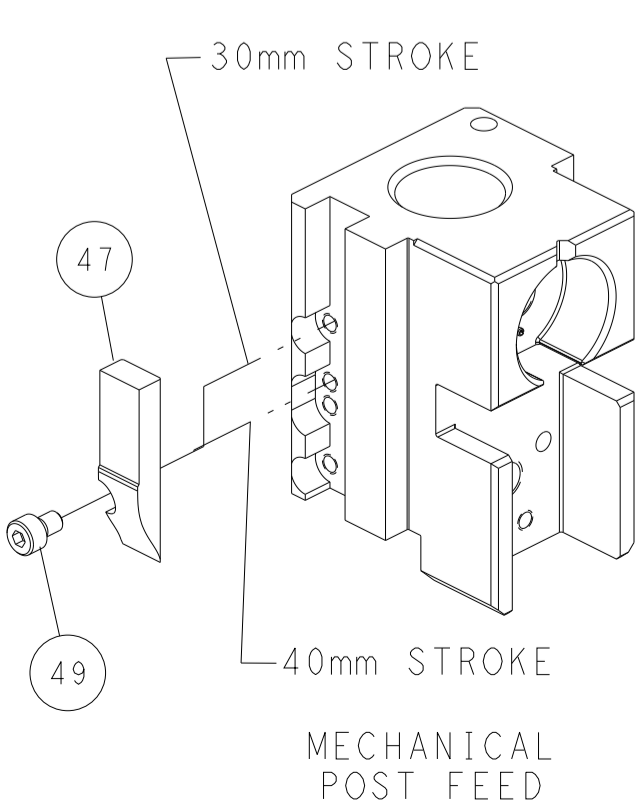


RAM SET-UP



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	WEIGHT: - SCALE: 1:2 SHEET: 2 of 4 REV: B1	Customer Accessible Production Drawing		

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2837880-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2837880-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2837880-7	B	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
 INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.60 mm [.102]	F
INSUL	2.80 mm [.110]	O

APPLICATOR INSTRUCTIONS
 408-35042

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: XRC TERMINAL FAMILY			
WIRE STRIP LENGTH 3.81-5.08 mm [.150-.200 IN]		TERMINAL INSULATION DIAMETER RANGE Ø1.91-2.41 mm [.075-.095 IN]	
TERMINAL APPLICATION SPECIFICATION	114-160066	-	-
TERMINALS APPLIED		AT9106	
TE TERMINAL	MOLEX TERMINAL	TE TERMINAL	MOLEX TERMINAL
2-2600020-2	84524-0008	2-2600021-3	84525-0017
2-2600020-3	84524-0016	2-2600021-5	84525-0039

WIRE SIZE	CRIMP HEIGHT mm [IN]	CRIMP HEIGHT REFERENCE SETTING
14 AWG	1.62 +/- 0.05 [.064 +/- .002]	5.7
16 AWG	1.37 +/- 0.05 [.054 +/- .002]	8.0
18 AWG	1.21 +/- 0.05 [.048 +/- .002]	9.9

- 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.
- 6. WHEN RUNNING SERIES 2600020 TERMINAL, USE ITEM 34 TERMINAL SUPPORT. WHEN RUNNING SERIES 2600021 TERMINAL, USE ITEM 35 TERMINAL SUPPORT.
- 7. TERMINAL LUBRICANT IS RECOMMENDED.
- 8. WHEN SWITCHING BETWEEN TERMINALS, ITEM 29 MAY NEED TO BE ADJUSTED.

***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)

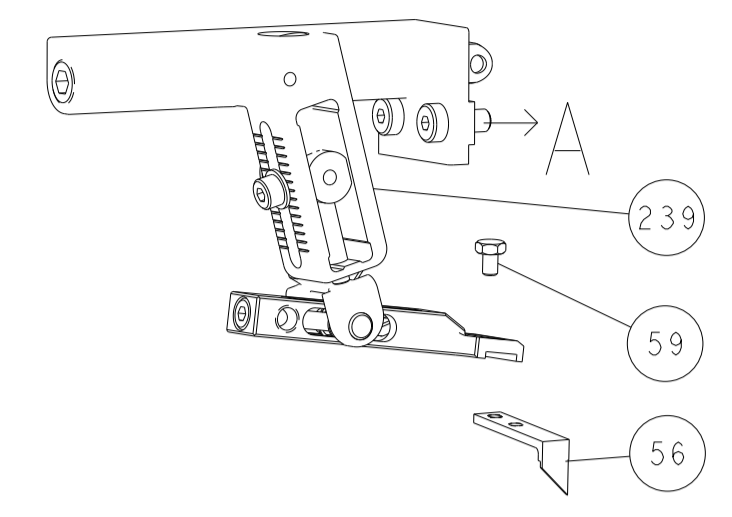
LOC	DIST	REVISIONS					
A	66	P	LTN	DESCRIPTION	DATE	OWN	APVD
-	-	-	-	SEE SHEET 1	-	-	-

-	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	
3	-	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241	
-	-	1	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	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	
7	-	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	1803607-3	DOCUMENTATION PACKAGE	71	
-	1	1	2119791-5	DEPRESSOR, WIRE	70	
-	2	2	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	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59	
-	1	1	1338685-1	PAWL, FEED	56	
-	2	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	53	
-	1	1	1803382-6	HOLD DOWN, SPRING LOADED	50	
-	1	2	18023-9	SCR, SKT HD CAP M4 X 6.0	49	
-	-	1	1	2119652-1	FEED CAM, PRE FEED	48
-	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41	
6	-	1	1	2-1752356-0	SUPPORT, TERMINAL	35
6	-	1	1	1752356-3	SUPPORT, TERMINAL	34
-	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33	
-	2	2	2-2844962-5	SPACER, CYLINDRICAL, STRIP GUIDE	30	
8	-	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29
-	1	1	455888-3	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	
7	-	1	1	2119806-1	INSERT, SHEAR	13
-	1	1	3-22280-3	SPRING, COMPRESSION	12	
-	1	1	1-356885-4	STOP, SHEAR	11	
7	-	1	1	2119805-1	SHEAR HOLDER, FRONT	10
7	-	1	1	1803095-6	FLOATING SHEAR, FRONT	9
7	1	1	1	3-1803763-2	COMBINATION, ANVIL	8
-	1	1	2-240641-1	SPACER	7	
-	-	-	-	-	6	
-	1	1	2119757-8	DEPRESSOR, SHEAR	5	
-	1	1	3-238011-3	BLOCK, CRIMPER SPACER	4	
7	1	1	1	9-1633965-0	CRIMPER, INSULATION O PREMIUM	3
-	-	-	-	-	2	
7	1	1	1	1-1803087-5	CRIMPER, WIRE	1

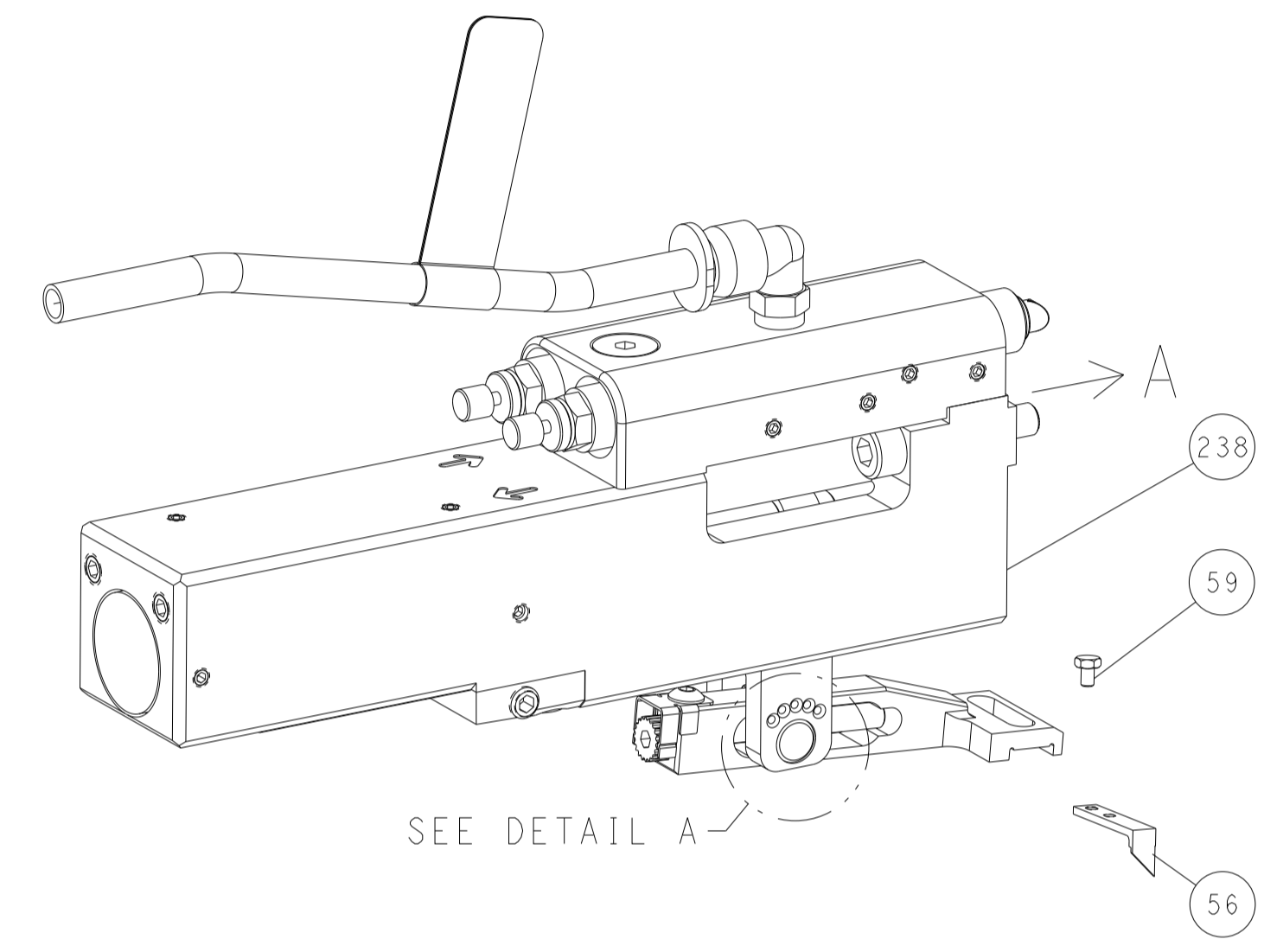
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		OWN	M	HERR	27AUG2020	TE Connectivity Harrisburg, PA 17105-3608	
mm		0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH		CHK	T	ELBIN	27AUG2020		
MATERIAL		APPLICATION SPEC		APVD	B	BAIR	27AUG2020	NAME OCEAN 2.0 Side Feed Applicator	
				SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO		
				WEIGHT	A	00779	SCALE	1:2	
				Customer Accessible Production Drawing		SHEET	3	OF	4
						REV	B1		

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

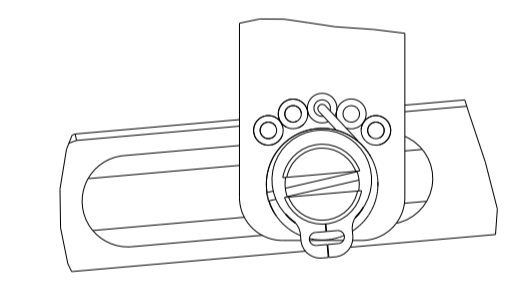
FEED TYPE MECHANICAL



PNEUMATIC

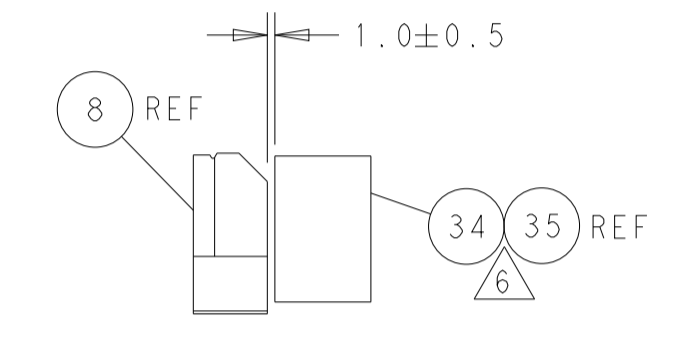
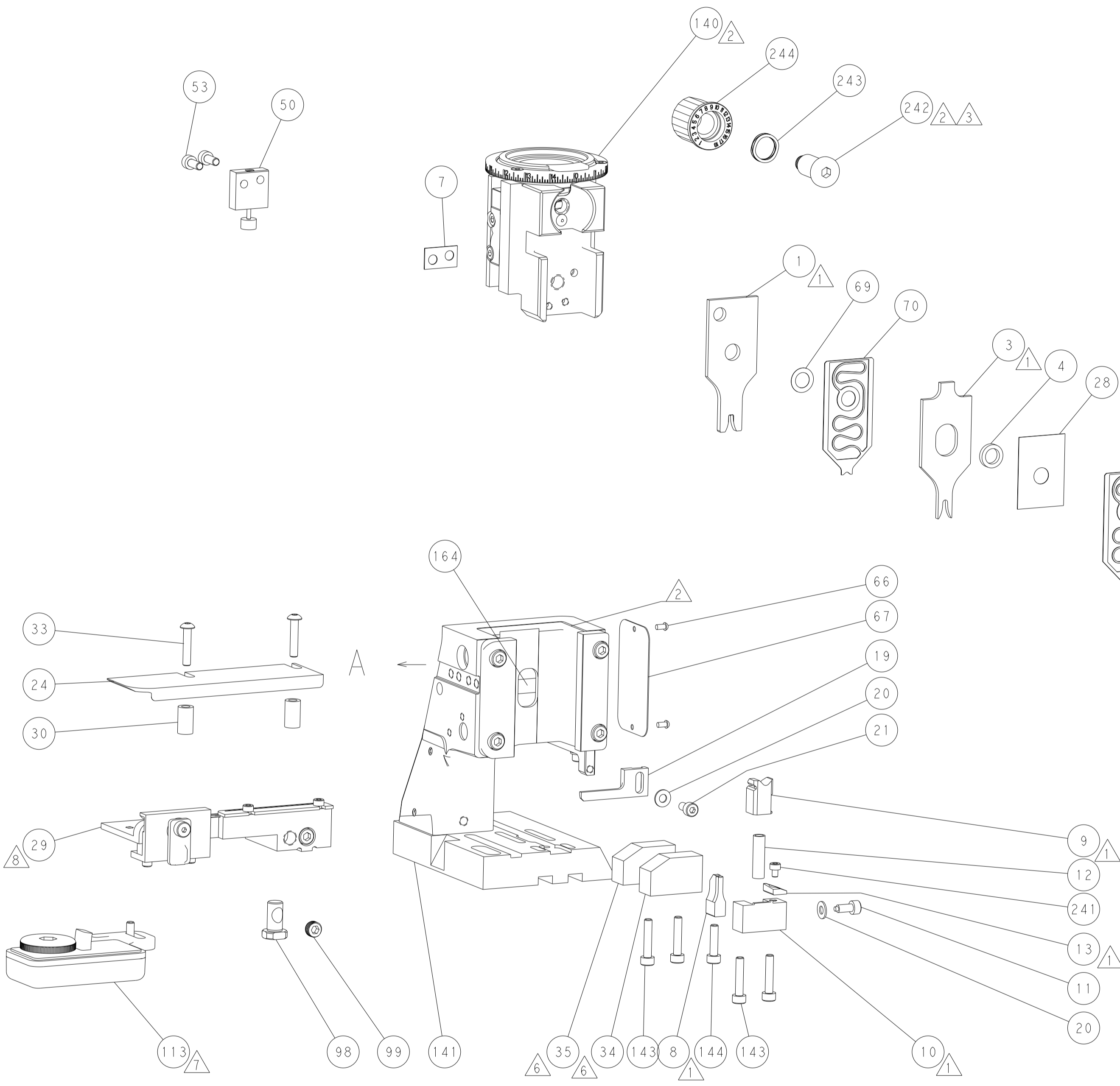
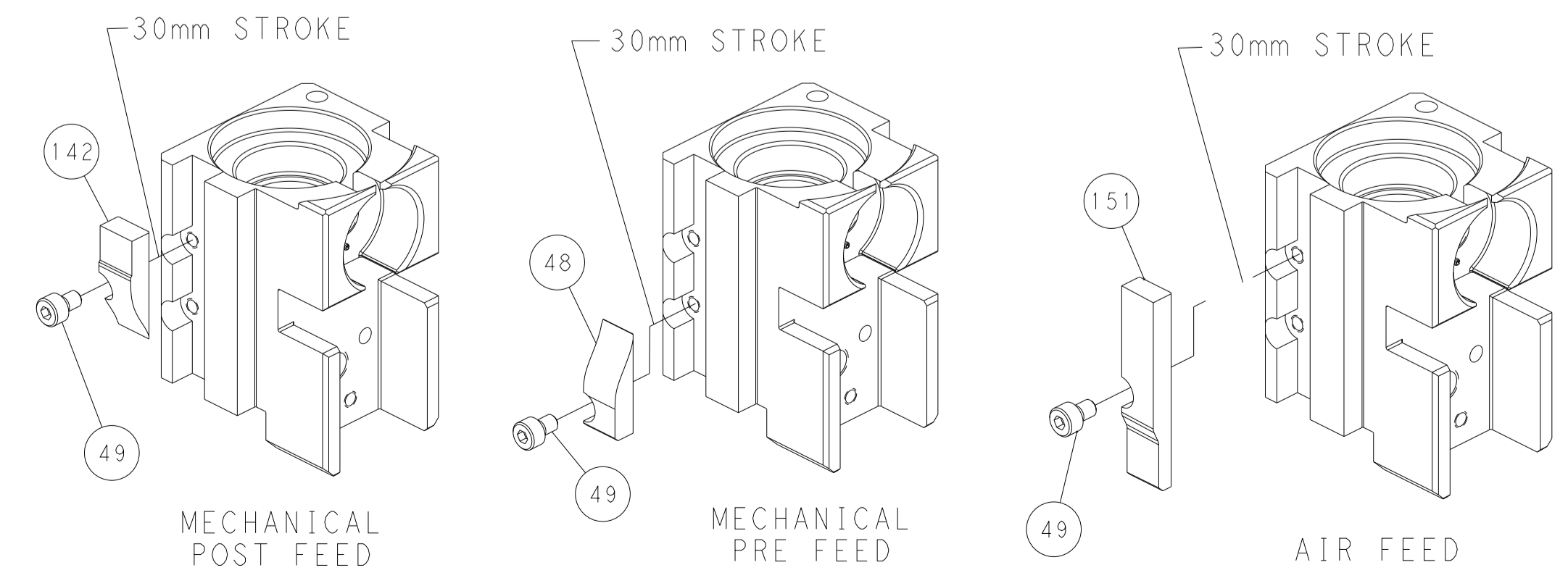


FEED SPRING SETTING POSITION
(SHOWN FROM REAR SIDE)

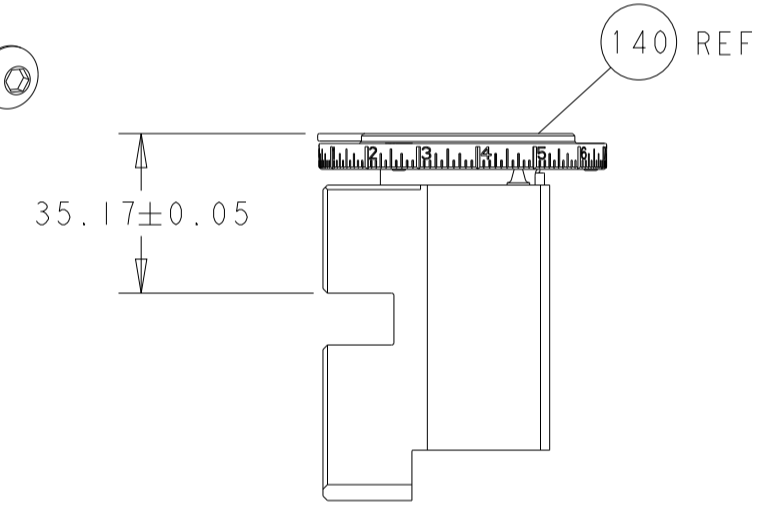


DETAIL A

CAM POSITIONS

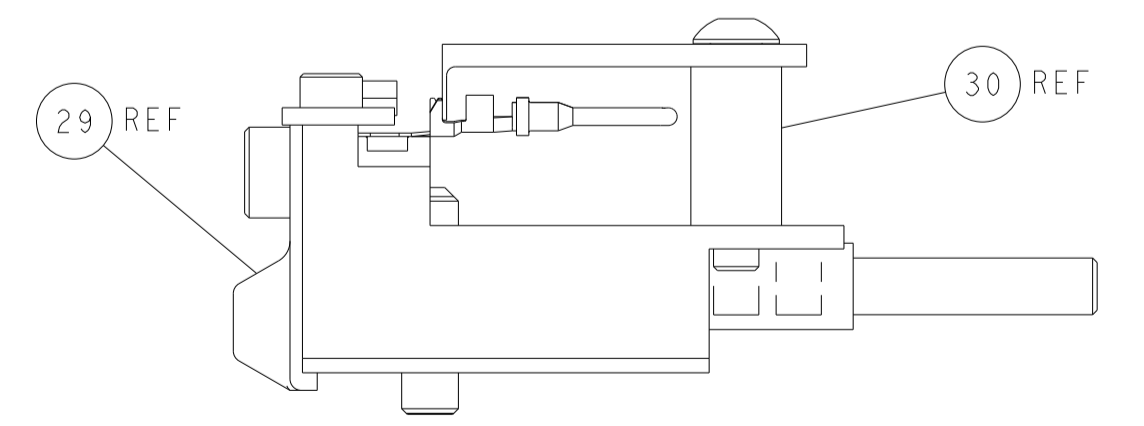


TERMINAL SUPPORT LOCATION



RAM SET-UP

ITEM 30 LOCATED AT
FRONT HOLES



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)

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DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± MATERIAL: - FINISH: -	WEIGHT: - SCALE: 1:2 SHEET: 4 of 4 REV: B1	RESTRICTED TO: -	Customer Accessible Production Drawing	