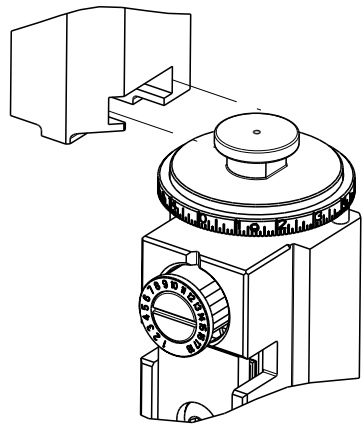


8		7	
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20		20	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2374711-1	A	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2374711-2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2374711-1	A	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2374711-2	A	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2374711-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.20 mm [.087]	F
INSUL	3.35 mm [.132]	O
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: KOSTAL TERMINAL		VW CRIMP SPECIFICATION			
TERMINAL NAME: LKS 1.5 TERMINAL					
WIRE STRIP LENGTH 4.45-5.21 mm [.175-.205 IN]		TERMINAL INSULATION DIAMETER RANGE Ø1.90-2.10 mm [.075-.083 IN]			
TERMINAL APPLICATION SPECIFICATION N.912.718 Rev 1		- -			
TERMINALS APPLIED					
TE TERMINAL		KOSTAL TERMINAL	TE SEAL	KOSTAL SEAL	SEAL INSULATION DIAMETER RANGE
2371300-1		10097307	1572751-1	10800444521	1.8-2.2
2371300-2		10097309			
2371300-3		10097359			
2371300-4		10097356			
WIRE SIZE 1.00mm2		CRIMP HEIGHT mm [INCH] 1.35+/-0.03 [.053+/- .001]		CRIMP HEIGHT REFERENCE SETTING 7.5	



- 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 APPLY TORO-SEAL IN ALLEN SOCKET TO FILL HOLE AFTER FLAT HD HAS BEEN ADJUSTED TO CORRECT HEIGHT AT QUALIFICATION. APPLY #1-23419-5 LOC-TITE TO THREADS.

*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	REVISONS				
A	66	P	LYR	DESCRIPTION	DATE	DWN
			I	DEVELOPMENT	10JUN2020	TB
			A	RELEASED	23JUL2020	JWC

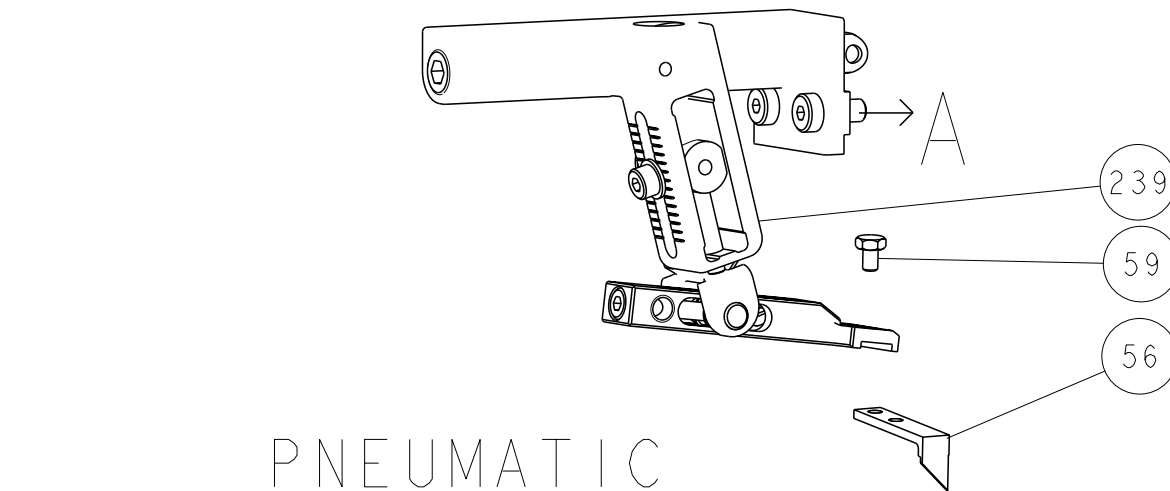
-	2	2	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	269
-	1	1	1	1	1633782-2	FENCE	267
-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248
-	1	1	1	1	2119082-3	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	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	2844908-1	SCREW, LOCKING	99
-	1	1	1	1	2844907-1	POST, LOCKING	98
-	1	1	1	1	455888-4	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	985575-3	SCR, FLT SKT HD CAP M3 X 10.0	57
-	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	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	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	3-1752356-3	SUPPORT, TERMINAL	34
-	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	2	2	2-2844962-7	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	1	1	1-2844992-0	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	318707-1	FLOATING SHEAR, FRONT	9
-	1	2	2	1	7-1803751-6	ANVIL, COMBINATION	8
-	1	1	1	1	6-240641-3	SPACER	7
-	-	-	-	-	-	-	6
-	1	1	1	1	2-2119781-4	DEPRESSOR, SHEAR	5
-	1	1	1	1	7-238011-0	BLOCK, CRIMPER SPACER	4
-	1	2	2	1	8-1633966-1	CRIMPER, INSULATION O	3
-	1	1	1	1	455888-8	SPACER, CRIMPER	2
-	1	2	2	1	3-1803241-7	CRIMPER, WIRE F	1
-77-72-71	-2	-1	PART NO		DESCRIPTION		ITEM NO

TIT: DRAWING IS TO BE USED FOR THE PURPOSES OF THE CONTRACT ONLY. IT IS SUBJECT TO CHANGE AND TO BE USED FOR THE PURPOSES OF THE CONTRACT ONLY. IT IS SUBJECT TO CHANGE AND TO BE USED FOR THE PURPOSES OF THE CONTRACT ONLY. IT IS SUBJECT TO CHANGE AND TO BE USED FOR THE PURPOSES OF THE CONTRACT ONLY.		DWN T. BROOKS	10JUN2020	TE Connectivity Harrisburg, PA 17105-3608	
CHK M. HERR		APVD R. KNEPPER	10JUN2020	NAME OCEAN 2.0 Side Feed Applicator	
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		SIZE A1	
0 PLC 1 PLC 2 PLC 3 PLC 4 PLC		± ± ± ± ±		CAGE CODE 00779	
MATERIAL -		FINISH -		DRAWING NO 2374711	
				RESTRICTED TO -	
				Customer Accessible Production Drawing	
				SCALE 1:2	
				SHEET 1 of 4	
				REV A	

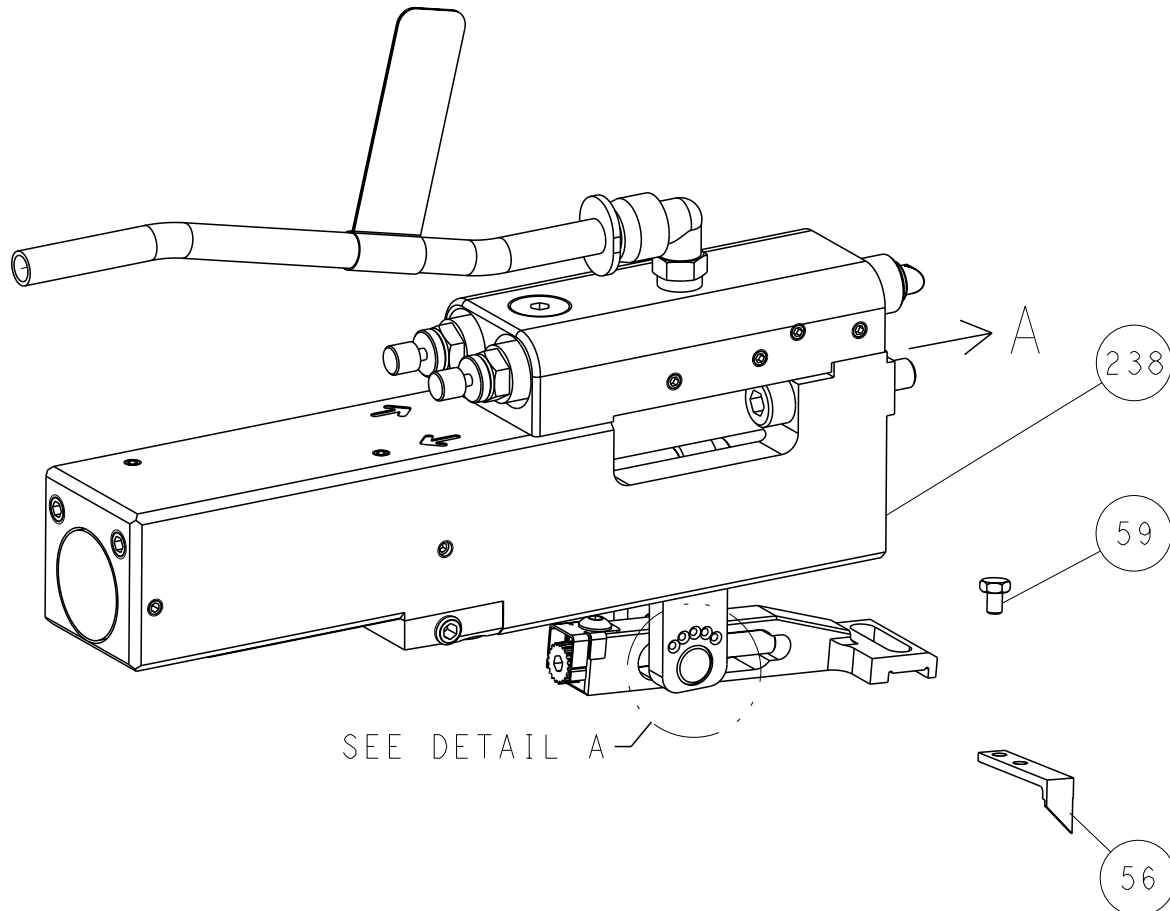
SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

LOC		DIST		REVISIONS					
A		66		P	LTR	DESCRIPTION	DATE	DWN	APVD
					-	SEE SHEET 1	-	-	-

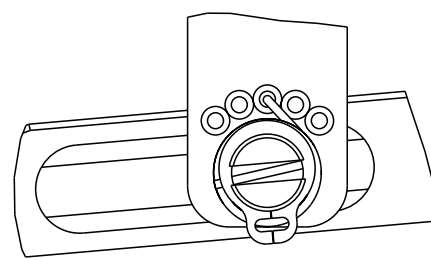
FEED TYPE MECHANICAL



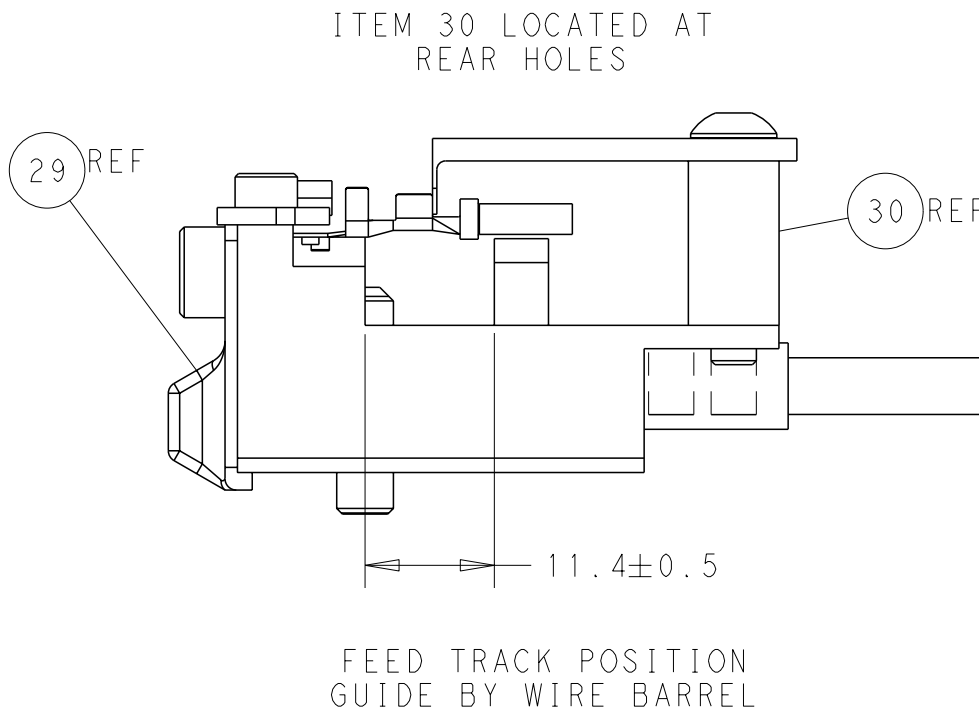
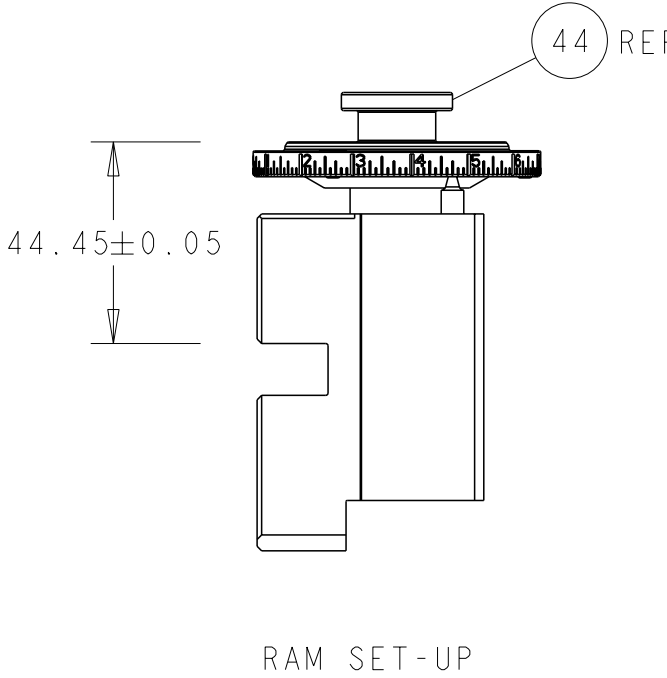
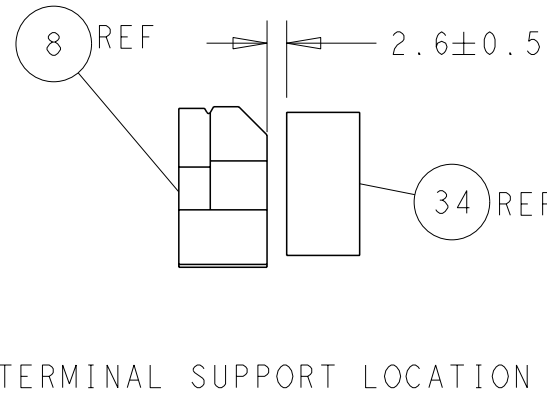
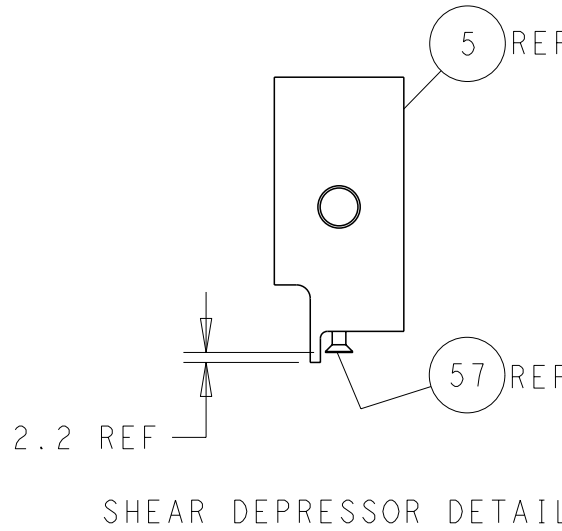
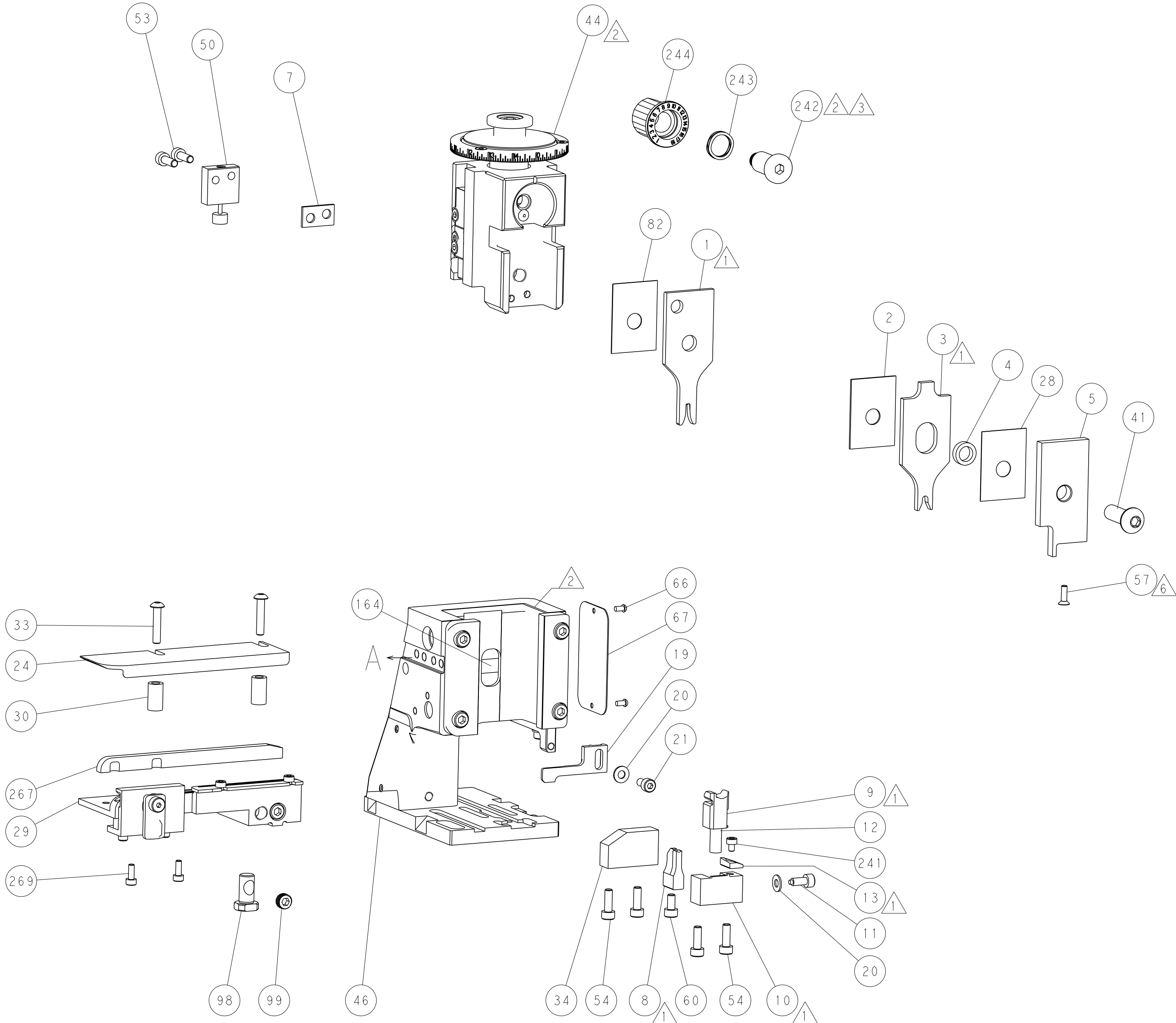
PNEUMATIC



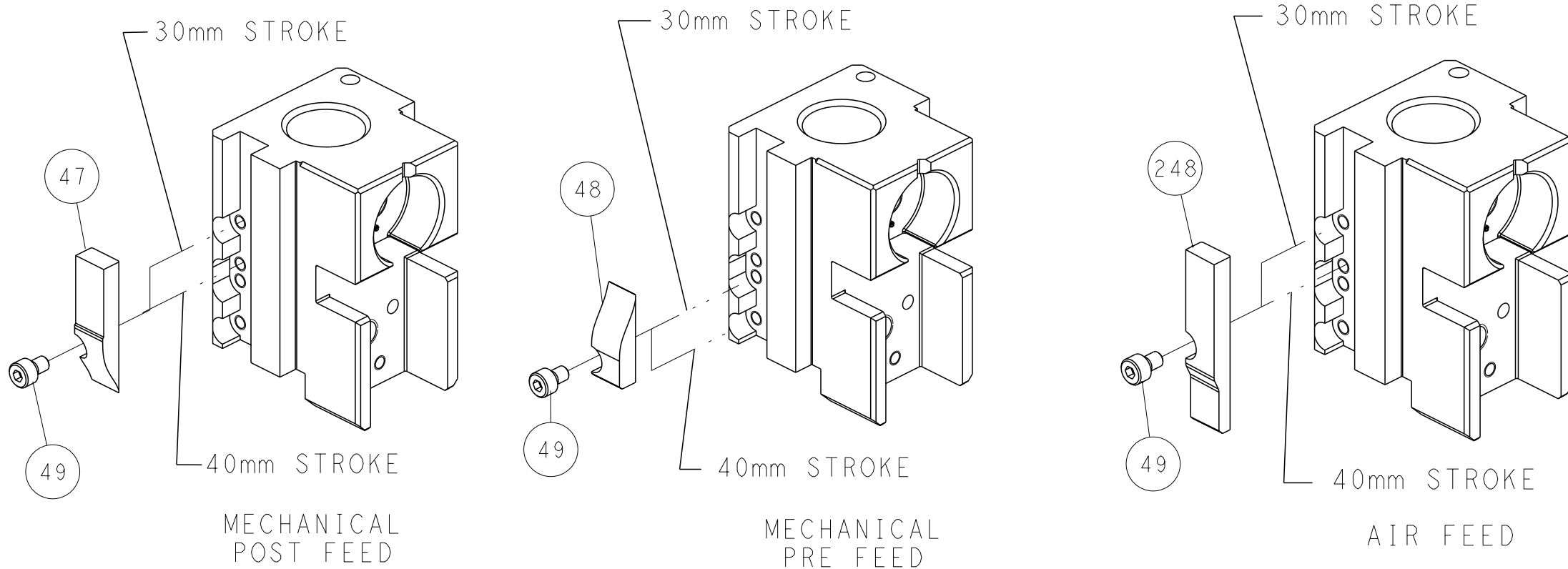
FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



DETAIL A



CAM POSITIONS

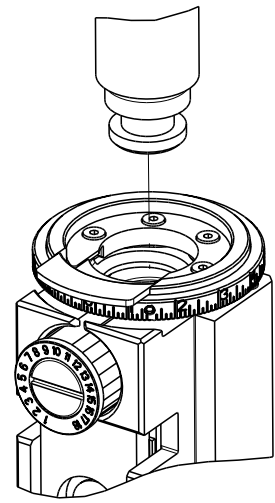


ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

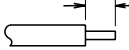
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN T. BROOKENS 10JUN2020		TE Connectivity	
mm		0 PLC ±		CHK M. HERR 10JUN2020		Harrisburg, PA 17105-3608	
		1 PLC ±		APVD R. KNEPPER 10JUN2020		NAME OCEAN 2.0 Side Feed Applicator	
		2 PLC ±		PRODUCT SPEC		SIZE CAGE CODE DRAWING NO	
		3 PLC ±		APPLICATION SPEC		RESTRICTED TO	
		4 PLC ±		WEIGHT		A 00779 C=2374711	
MATERIAL		FINISH		Customer Accessible Production Drawing		SCALE 1:2 SHEET 2 of 4 REV A	

8		7	
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20		20	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2374711-1	A	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2374711-2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2374711-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.20 mm [.087]	F
INSUL	3.35 mm [.132]	O
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: KOSTAL TERMINAL				VW CRIMP SPECIFICATION	
TERMINAL NAME: LKS 1.5 TERMINAL					
WIRE STRIP LENGTH			TERMINAL INSULATION DIAMETER RANGE		
4.45-5.21 mm [.175-.205 IN]			Ø1.90-2.10 mm [.075-.083 IN]		
TERMINAL APPLICATION SPECIFICATION			N.912.718 Rev 1		
			AT9106		
TERMINALS APPLIED					
TE TERMINAL		KOSTAL TERMINAL		SEAL INSULATION DIAMETER RANGE	
2371300-1		10097307		1.8-2.2	
2371300-2		10097309			
2371300-3		10097359			
2371300-4		10097356			
WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING	
					
1.00mm2		1.35+/-0.03 [.053+/-0.001]		7.5	



- 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 APPLY TORQ-SEAL IN ALLEN SOCKET TO FILL HOLE AFTER FLAT HD HAS BEEN ADJUSTED TO CORRECT HEIGHT AT QUALIFICATION. APPLY #1-23419-5 LOC-TITE TO THREADS.

*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)

2		1					
LOC	DIST	REVISIONS					
A	66	P	LTR	DESCRIPTION	DATE	DWN	APVD
		-		SEE SHEET 1	-	-	-

3	-	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	269
	-	1	1	1633782-2	FENCE	267
	-	1	1	2119082-3	CAM, SNAIL, INSULATION ADJUSTMENT	244
	-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
	-	1	1	2119083-1	RETAINER, INSULATION DIAL	242
	-	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	-	2119641-2	FEED CAM, AIR FEED	151
6	-	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	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	2844908-1	SCREW, LOCKING	99
	-	1	1	2844907-1	POST, LOCKING	98
	-	1	1	455888-4	SPACER, CRIMPER	82
	-	1	1	1803607-3	DOCUMENTATION PACKAGE	71
	-	1	1	2119740-1	TAG,IDENTIFICATION	67
1	-	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	985575-3	SCR, FLT SKT HD CAP M3 X 10.0	57
	-	1	1	1338685-1	PAWL, FEED	56
	-	2	2	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	53
	-	1	1	1803382-6	HOLD DOWN, SPRING LOADED	50
	-	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
	-	1	1	3-1752356-3	SUPPORT, TERMINAL	34
1	-	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
	-	2	2	2-2844962-7	SPACER, CYLINDRICAL, STRIP GUIDE	30
	-	1	1	1-2844992-0	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
	-	1	1	2119806-1	INSERT, SHEAR	13
	-	1	1	3-22280-3	SPRING, COMPRESSION	12
1	-	1	1	1-356885-4	STOP, SHEAR	11
	-	1	1	2119805-1	SHEAR HOLDER, FRONT	10
	-	1	1	318707-1	FLOATING SHEAR, FRONT	9
	1	1	1	7-1803751-6	ANVIL, COMBINATION	8
	-	1	1	6-240641-3	SPACER	7
	-	-	-	-	-	6
	-	1	1	2-2119781-4	DEPRESSOR, SHEAR	5
	-	1	1	7-238011-0	BLOCK, CRIMPER SPACER	4
	1	1	1	8-1633966-1	CRIMPER, INSULATION O	3
	-	1	1	455888-8	SPACER, CRIMPER	2
1	1	1	3-1803241-7	CRIMPER, WIRE F	1	

1

1

1

1

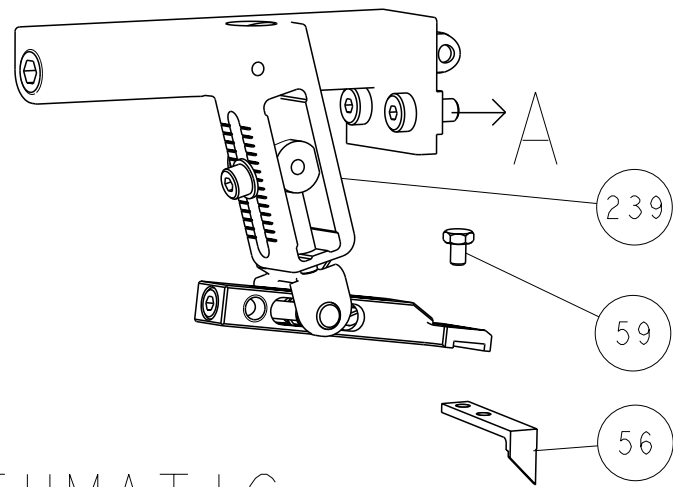
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THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE AND TO BE CONTROLLED BY THE ENGINEERING ORGANIZATION. IT SHOULD BE CONTACTED FOR THE LATEST REVISION.		OWN T. BROOKENS CHK M. HERR APVD R. KNEPPER	10JUN2020 10JUN2020 10JUN2020	TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		NAME OCEAN 2.0 Side Feed Applicator	
MATERIAL -		APPLICATION SPEC -		SIZE A1	
FINISH -		WEIGHT -		CAGE CODE 00779	
-		-		DRAWING NO 2374711	
-		-		RESTRICTED TO -	
-		-		Customer Accessible Production Drawing	
-		-		SCALE 1:2	
-		-		SHEET 3	
-		-		OF 4	
-		-		REV A	

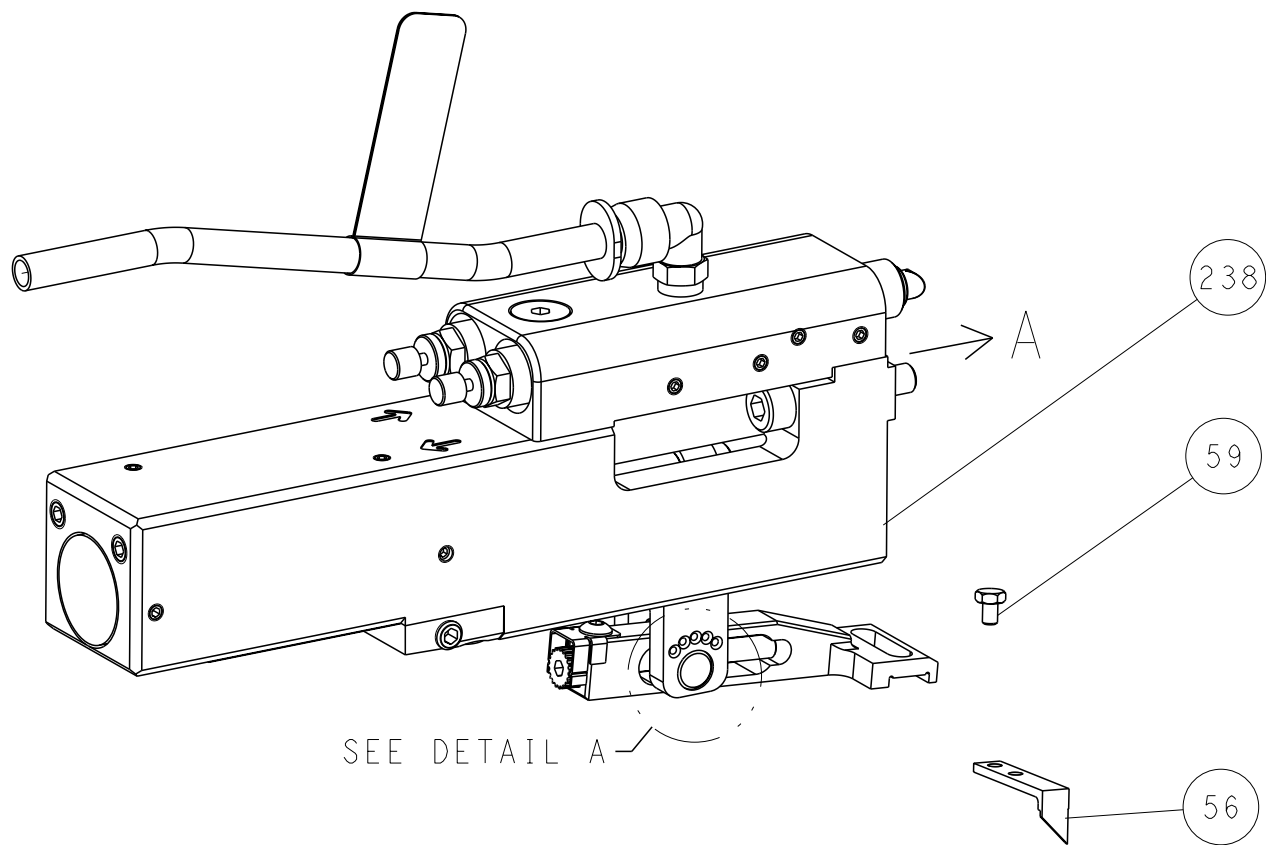
SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

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

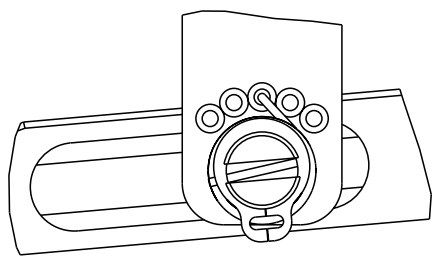
FEED TYPE MECHANICAL



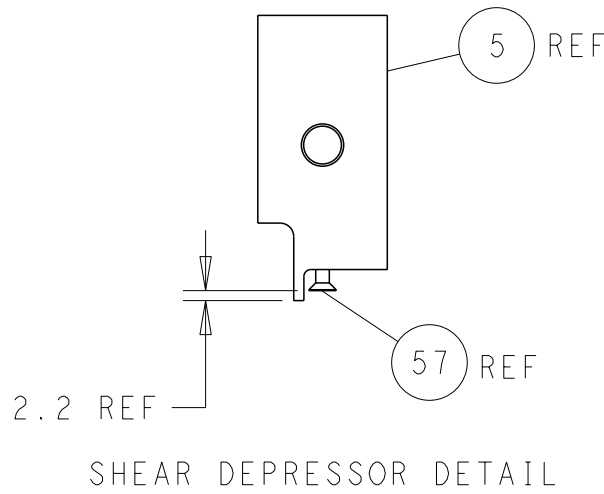
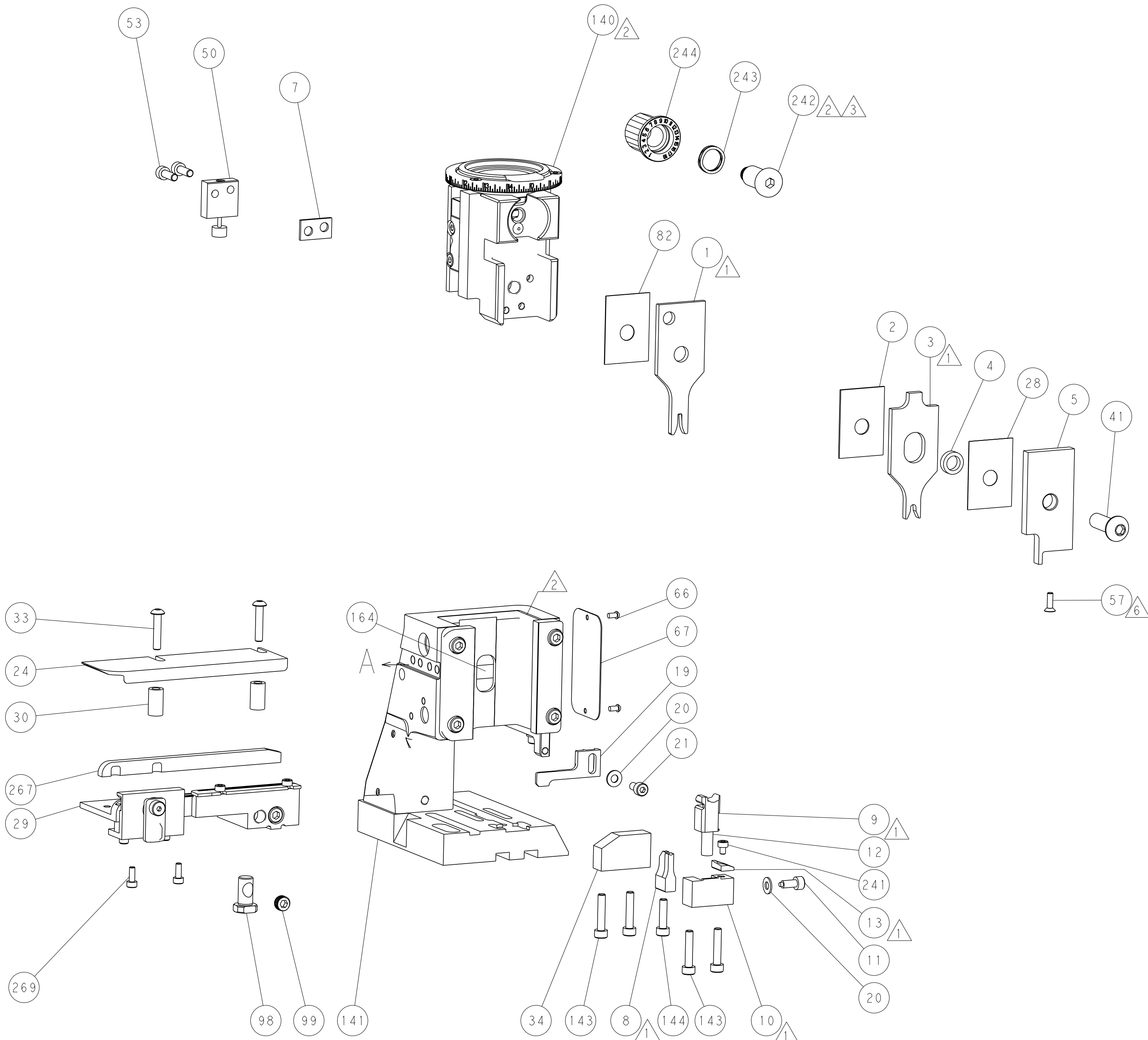
PNEUMATIC



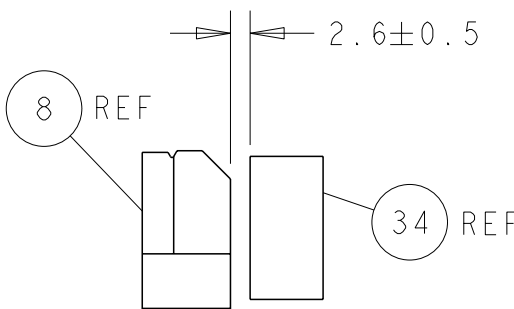
FEED SPRING SETTING POSITION
(SHOWN FROM REAR SIDE)



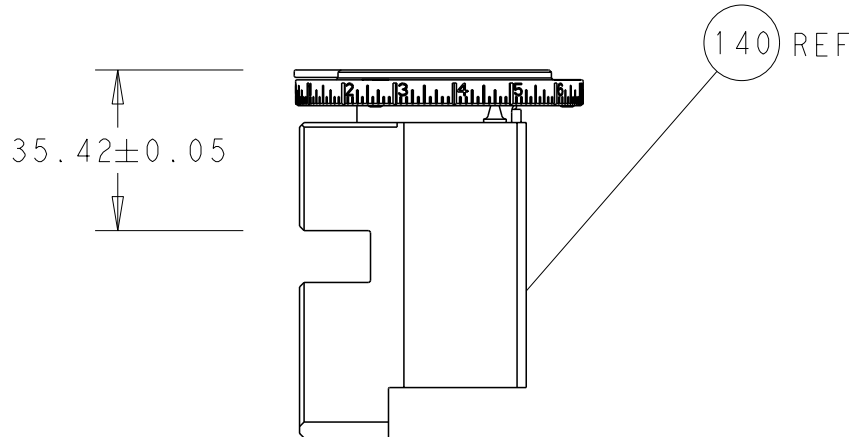
DETAIL A



SHEAR DEPRESSOR DETAIL

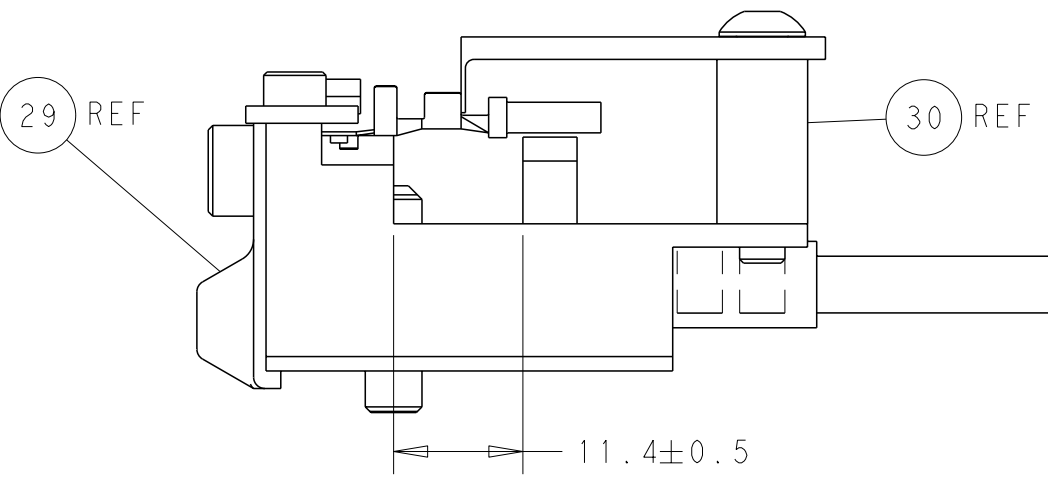


TERMINAL SUPPORT LOCATION



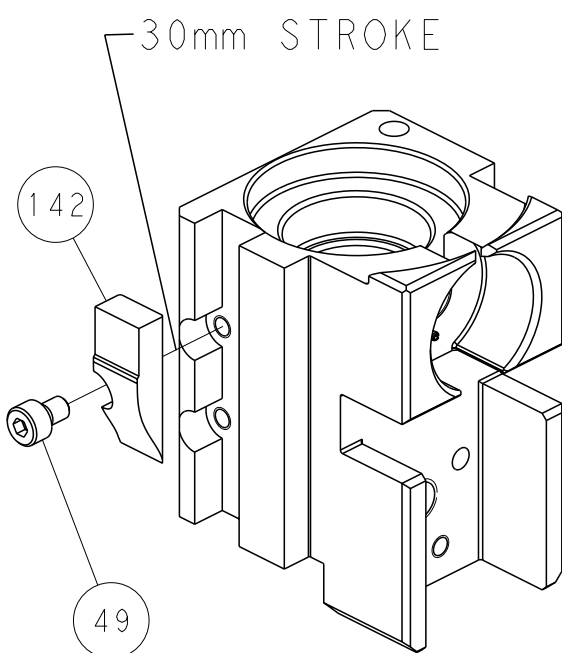
RAM SET-UP

ITEM 30 LOCATED AT
REAR HOLES

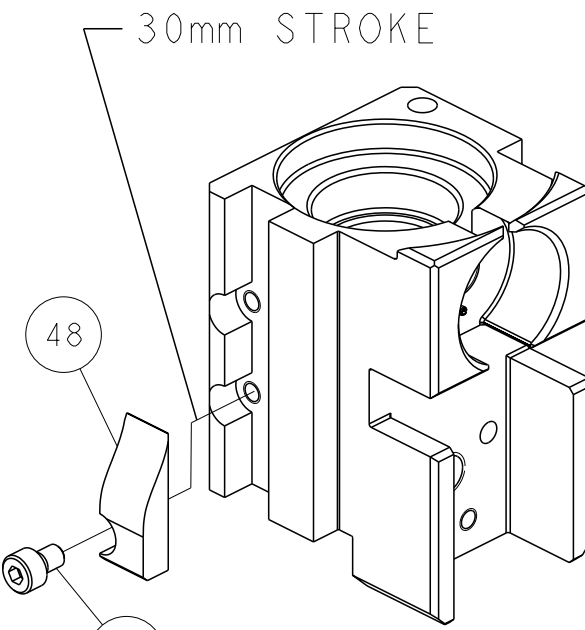


FEED TRACK POSITION
GUIDE BY WIRE BARREL

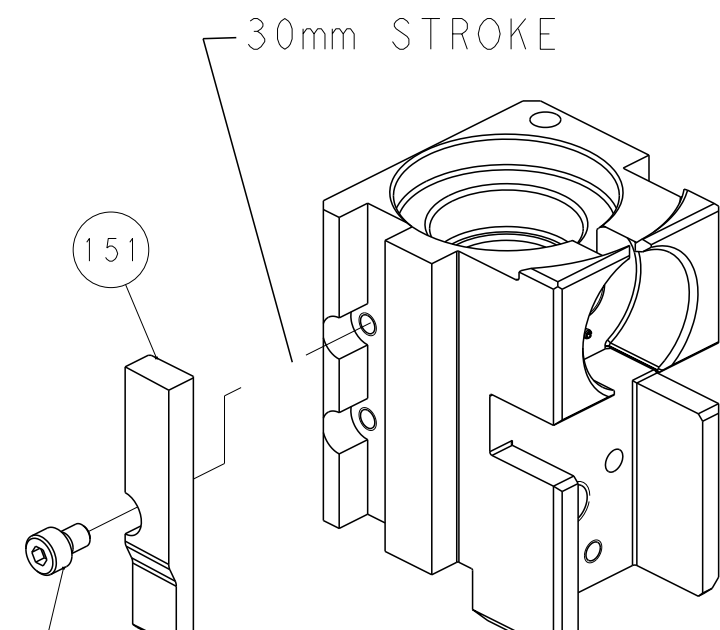
CAM POSITIONS



MECHANICAL
POST FEED



MECHANICAL
PRE FEED



AIR FEED

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

THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION IT IS SUBJECT TO CHANGE AND TO CONTROL AND ENGINEERING DISCRETION SHOULD BE CONTACTED FOR THE LATEST REVISION				DWN T. BROOKS	10JUN2020	 TE Connectivity Harrisburg, PA 17105-3608		
				CHK M. HERR	10JUN2020			
				APVD R. KNEPPER	10JUN2020	NAME OCEAN 2.0 Side Feed Applicator		
				PRODUCT SPEC				
				APPLICATION SPEC				
				WEIGHT				
				SCALE				
				SHEET				
				REV				