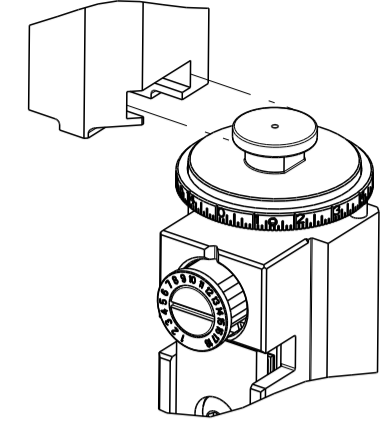


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2837246-2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
5-2837246-2	A	SEAL STRIPPER CRIMPER TERMINATING UNIT	PNEUMATIC
7-2837246-2	A	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2837246-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	0.63 mm [.025]	F
INSUL	0.94 mm [.037]	F

APPLICATOR INSTRUCTIONS  
408-35042

TERMINAL DATA: HIROSE TERMINAL HIROSE CRIMP SPECIFICATION			
TERMINAL NAME: 1.25 PITCH MINIATURE CRIMPING CONNECTOR			
WIRE STRIP LENGTH	TERMINAL INSULATION DIAMETER RANGE	TERMINAL PITCH	TERMINAL DIAMETER
1.24-2.00 mm [.049-.079 IN]	Ø0.50-0.90 mm [.020-.035 IN]	1.25 mm	1.25 mm
TERMINAL APPLICATION SPECIFICATION TAD-P-0506 AT9106			
TERMINALS APPLIED			
TE TERMINAL	HIROSE TERMINAL	TE TERMINAL	HIROSE TERMINAL
2113453-1	DF13-3032-SCFA		

TERMINAL DATA: HIROSE TERMINAL HIROSE CRIMP SPECIFICATION			
TERMINAL NAME: 1.25 PITCH MINIATURE CRIMPING CONNECTOR			
WIRE STRIP LENGTH	TERMINAL INSULATION DIAMETER RANGE	TERMINAL PITCH	TERMINAL DIAMETER
1.24-2.00 mm [.049-.079 IN]	Ø0.50-0.90 mm [.020-.035 IN]	1.25 mm	1.25 mm
TERMINAL APPLICATION SPECIFICATION TAD-P-0506 AT9106			
TERMINALS APPLIED			
TE TERMINAL	HIROSE TERMINAL	TE TERMINAL	HIROSE TERMINAL
2113453-2	DF13-3032-SCF		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
30 AWG	0.45 +/- 0.02 [.018 +/- .001]	8.2
32 AWG	0.43 +/- 0.02 [.017 +/- .001]	8.5

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
30 AWG	0.47 +/- 0.02 [.019 +/- .001]	8.2
32 AWG	0.45 +/- 0.02 [.018 +/- .001]	8.5

- 1 RECOMMENDED SPARE PARTS
- 2 REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION & 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 TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- 7 TERMINAL LUBRICANT IS RECOMMENDED.
- 8 PART OPTIONAL FOR BETTER LEADMAKER PERFORMANCE.

**\*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					
		P	LTN	DESCRIPTION	DATE	OWN	APVD
A	66	A		RELEASED	06MAR2023	TB	TE

-	1	1	1	5-1803945-3	TONKER		300
-	1	1	1	22278-9	SPRING, COMPRESSION		299
-	2	2	2	4-18032-3	SCR, SET, FLT PNT, M3 X 6.0		298
-	1	1	1	1803944-1	SPACER, TONKER		297
-	-	1	-	2-1803583-1	APPLICATOR BASIC ASSEMBLY, SF		292
-	1	1	1	1-2119791-4	DEPRESSOR, WIRE		286
-	1	1	1	2079383-1	SCR, BHSC, RoHS (M3 X 8)		284
-	1	1	1	1633289-4	STABILIZER		283
-	1	1	1	1803461-1	HOLDER, STABILIZER		282
-	1	1	1	1-18028-3	WASHER, FLAT, REG M5		281
-	1	1	1	1803196-1	STUD, ADJUSTMENT SCREW		280
-	1	1	1	2330046-1	RESIN COLLAR, FLANGED		261
-	1	1	1	2119641-1	FEED CAM, AIR FEED		248
-	1	1	1	2119082-1	CAM, SNAIL, INSULATION ADJUSTMENT		244
-	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST		243
-	1	1	1	2119083-1	RETAINER, INSULATION DIAL		242
-	1	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0		241
-	1	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	1-690438-0	FRONT STRIP GUIDE		96
-	2	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0		95
-	1	1	1	994962-9	SCR, SKT HD CAP M3 X 50.0		93
-	1	1	1	1803607-3	DOCUMENTATION PACKAGE		71
-	1	1	1	2119791-9	DEPRESSOR, WIRE		70
-	1	1	1	2119740-1	TAG, IDENTIFICATION		67
-	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188		66
-	2	2	2	2-18032-5	SCR, SET, FLT PNT, M5 X 20.0		61
-	1	1	1	2161425-1	SCREW, SHOULDER		60
-	1	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0		59
-	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	1	18023-9	SCR, SKT HD CAP M4 X 6.0		49
-	1	-	1	2-1803583-5	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	3-1752356-9	SUPPORT, TERMINAL		34
-	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)		33
-	2	2	2	1-2844962-5	SPACER, CYLINDRICAL, STRIP GUIDE		30
-	1	1	1	2-2844938-0	PLATE, STRIP GUIDE		29
-	2	2	2	22283-1	SPRING, COMPRESSION		27
-	1	1	1	356835-1	LEVER, DRAG RELEASE		26
-	1	1	1	240792-3	DRAG, TERMINAL		25
-	1	1	1	1-1320928-9	STRIP GUIDE		24
-	1	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	1	2	1-18028-2	WASHER, FLAT, REG M4		20
-	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	1-356885-5	STOP, SHEAR		11
-	1	1	1	2119805-1	SHEAR HOLDER, FRONT		10
-	1	1	1	1803095-6	FLOATING SHEAR, FRONT		9
-	1	2	1	5-1803395-6	ANVIL, COMBINATION		8
-	1	1	1	4-240641-3	SPACER		7
-	-	-	-	-	-		6
-	1	1	1	2-2119757-2	DEPRESSOR, SHEAR		5
-	1	1	1	4-238011-8	BLOCK, CRIMPER SPACER		4
-	1	2	1	1-1803326-7	CRIMPER, INSULATION F		3
-	-	-	-	-	-		2
-	1	2	1	3-1803396-7	CRIMPER, WIRE PREMIUM		1

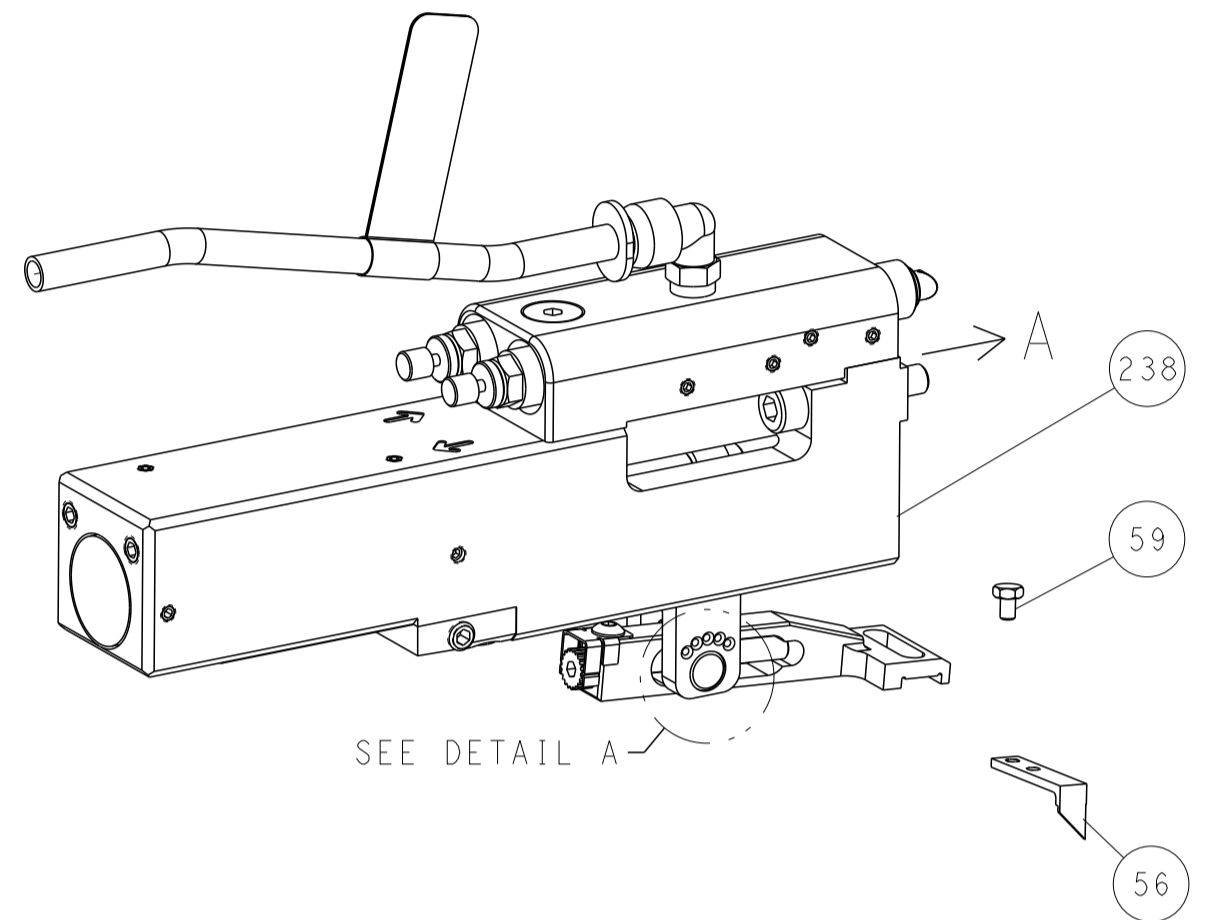
ATLANTIC VERSION  
Shown on sheets 1 of 4 & 2 of 4  
(Pacific version shown on sheets 3 of 4 & 4 of 4)

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

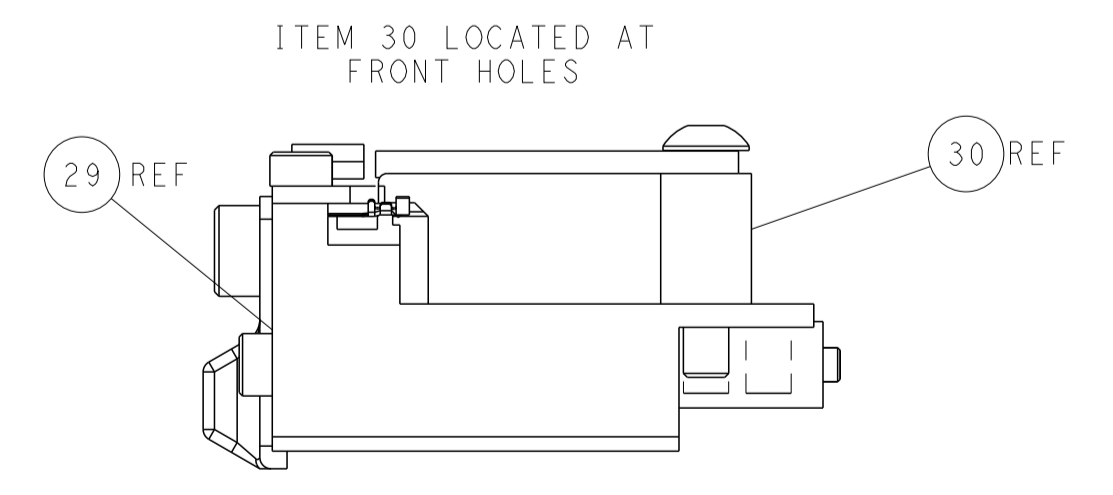
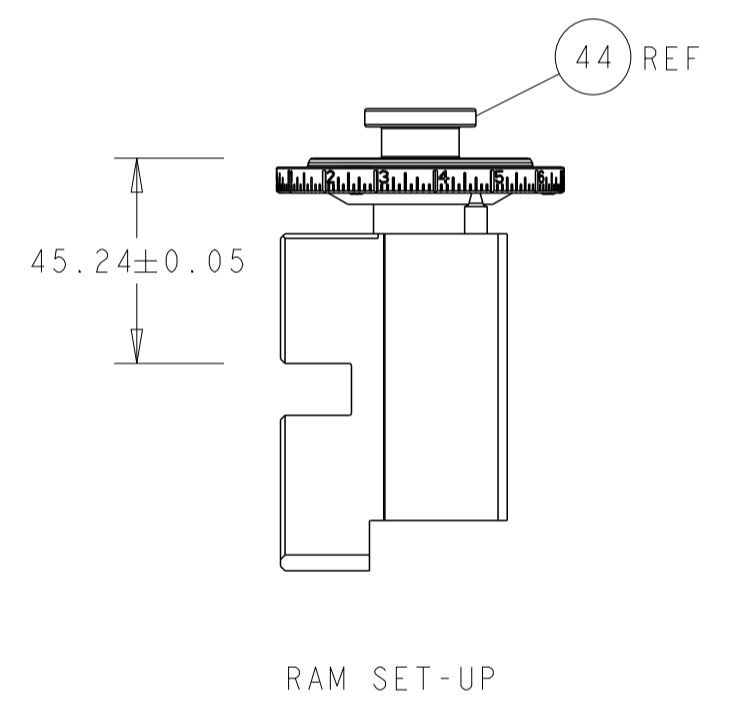
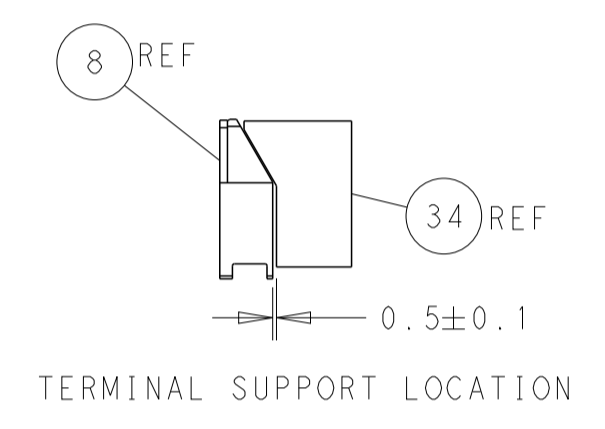
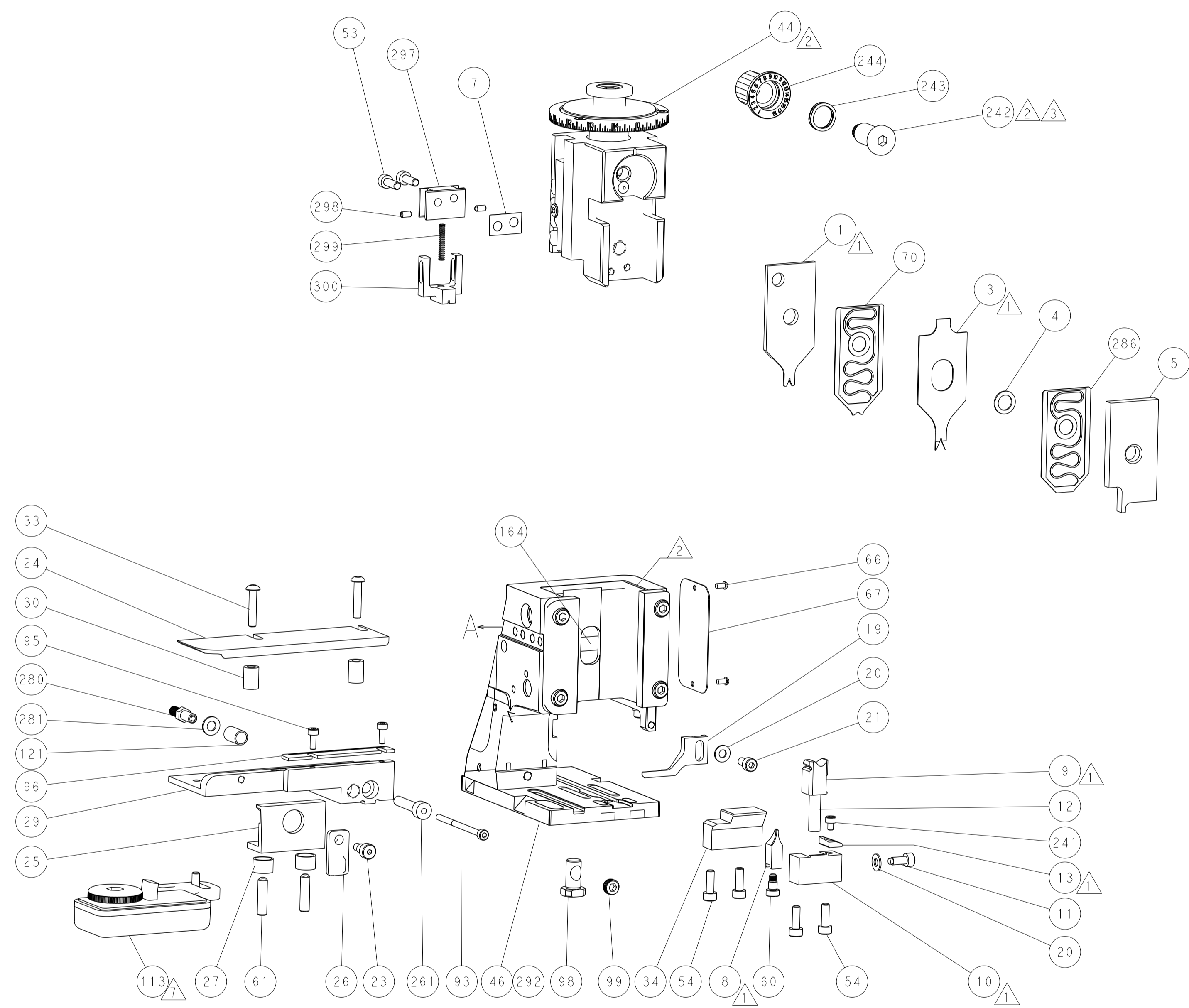
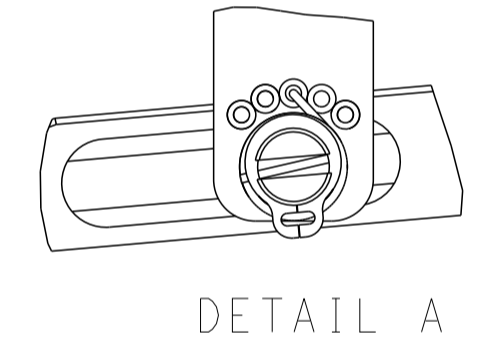
OWN	T. BROOKENS	06MAR2023
CHK	M. HERR	06MAR2023
APVD	T. ELBIN	06MAR2023
NAME	OCEAN 2.0 Side Feed Applicator	
SIZE	CAGE CODE	DRAWING NO
A1	00779	2837246
Customer Accessible Production Drawing		
SCALE	1:2	SHEET 1 OF 4
REV	A	

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

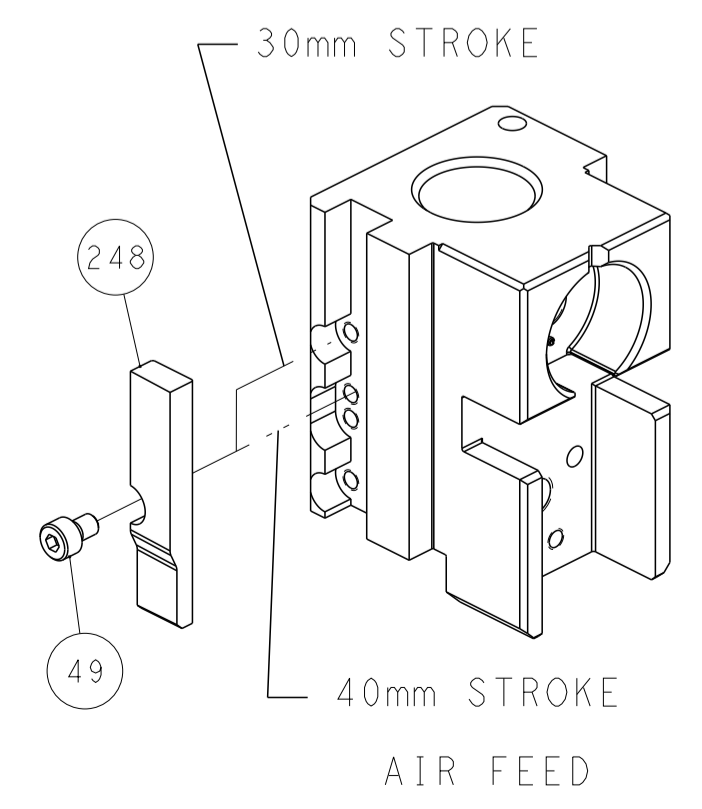
### FEED TYPE PNEUMATIC



FEED SPRING SETTING POSITION  
(SHOWN FROM REAR SIDE)



### CAM POSITION

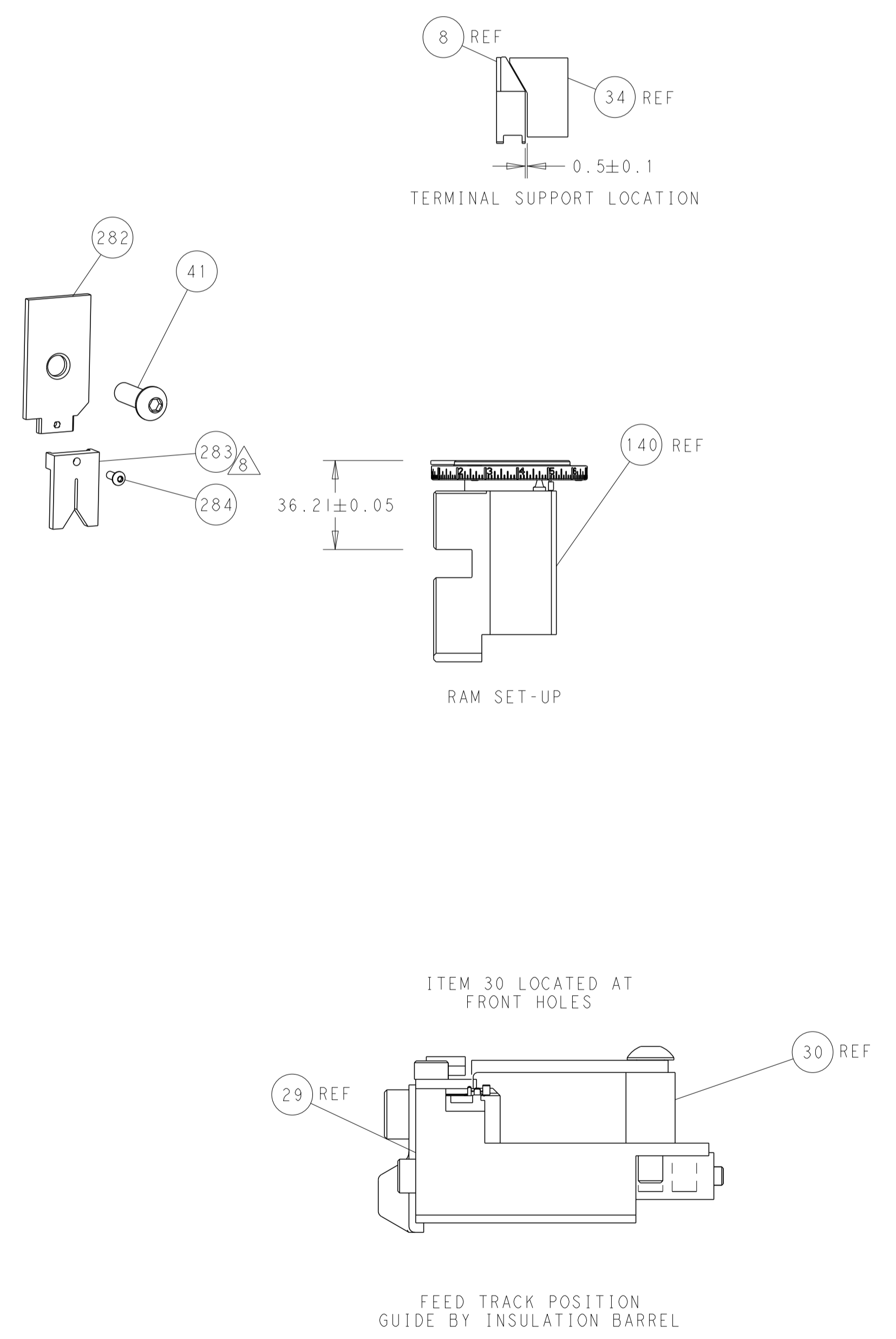
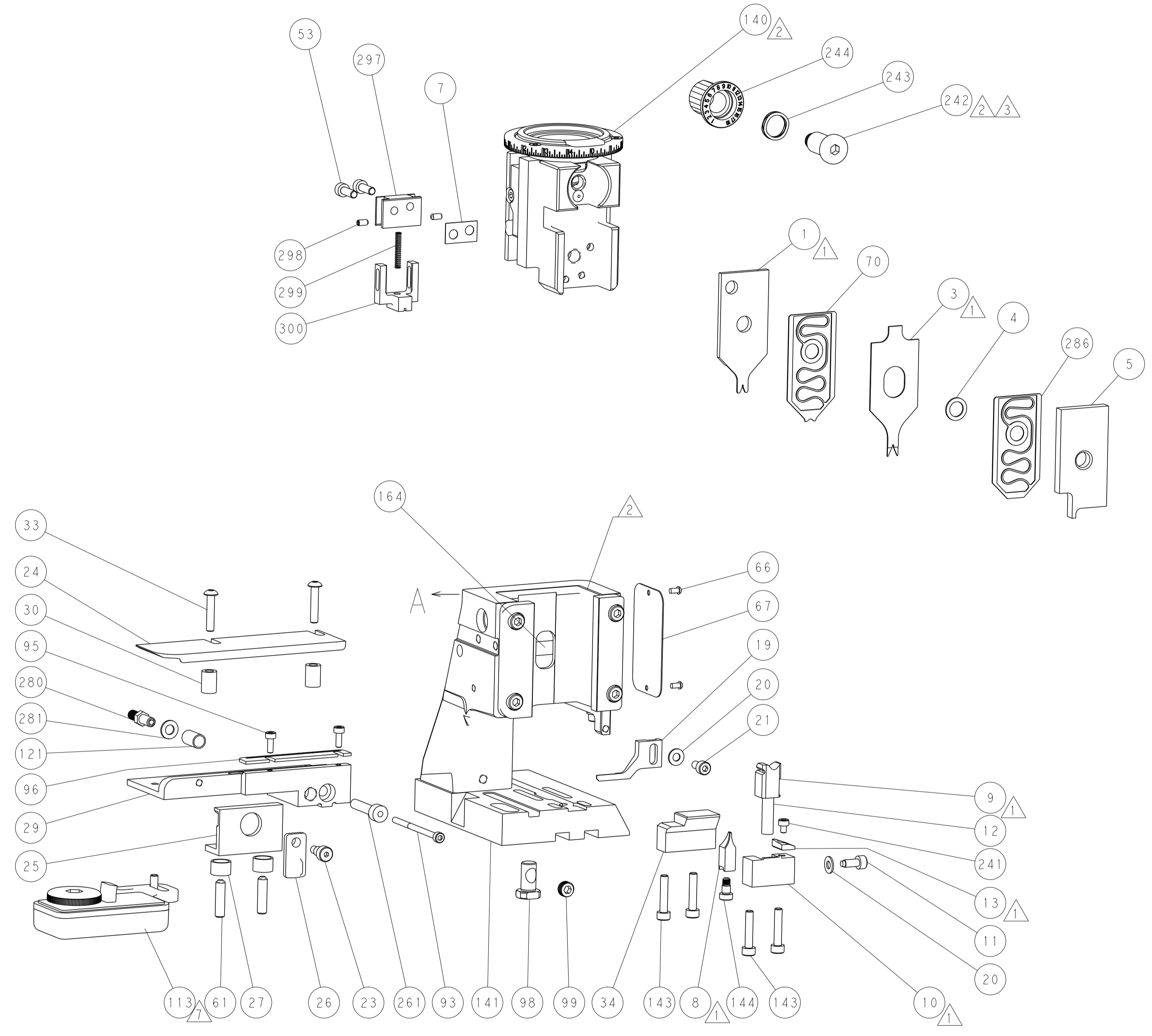
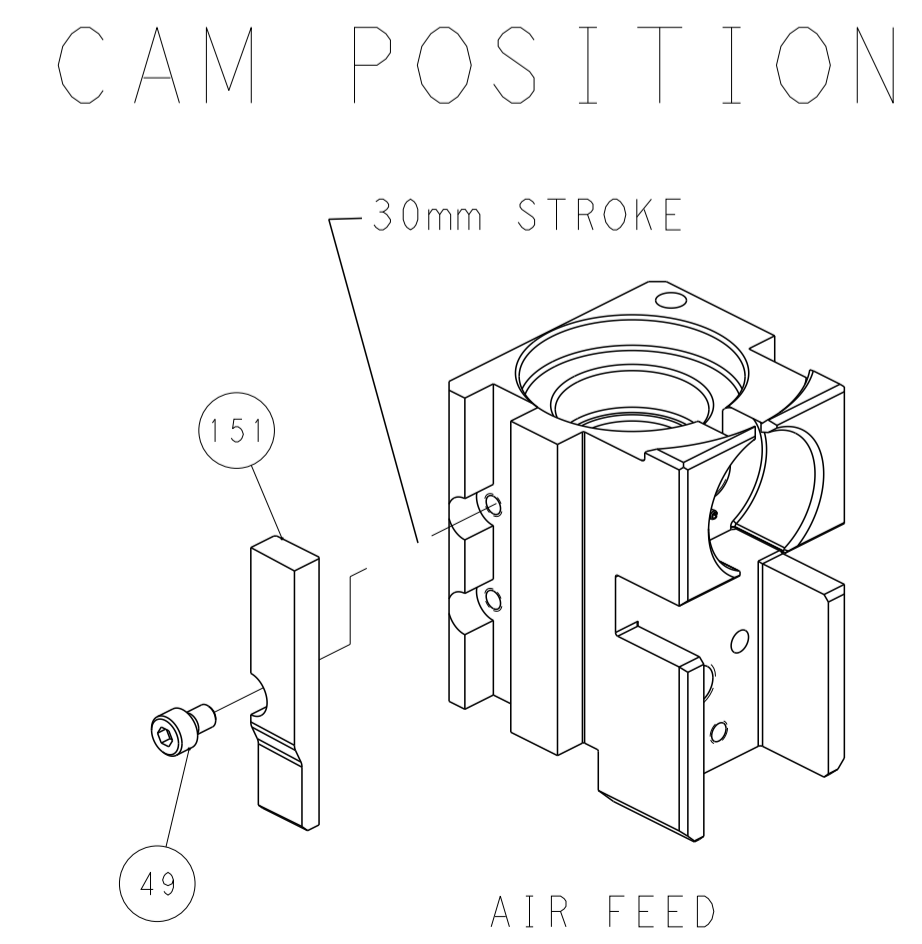
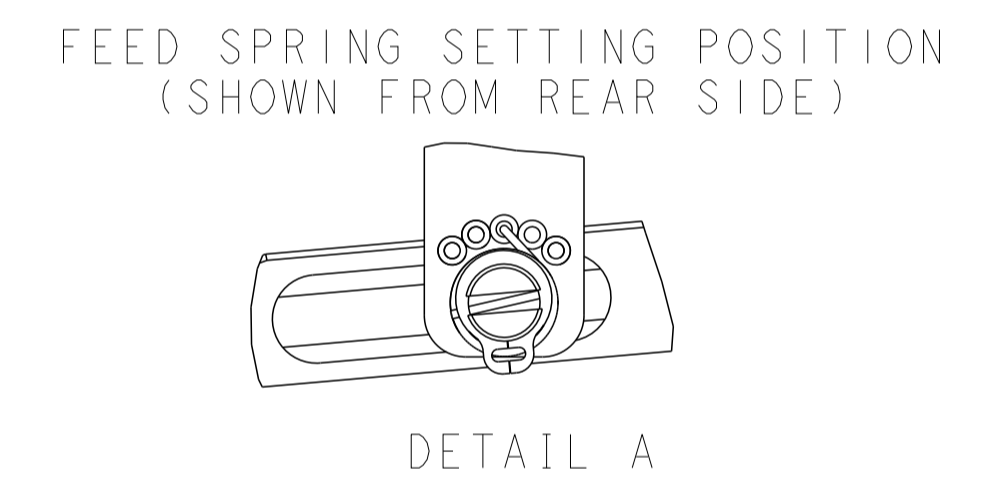
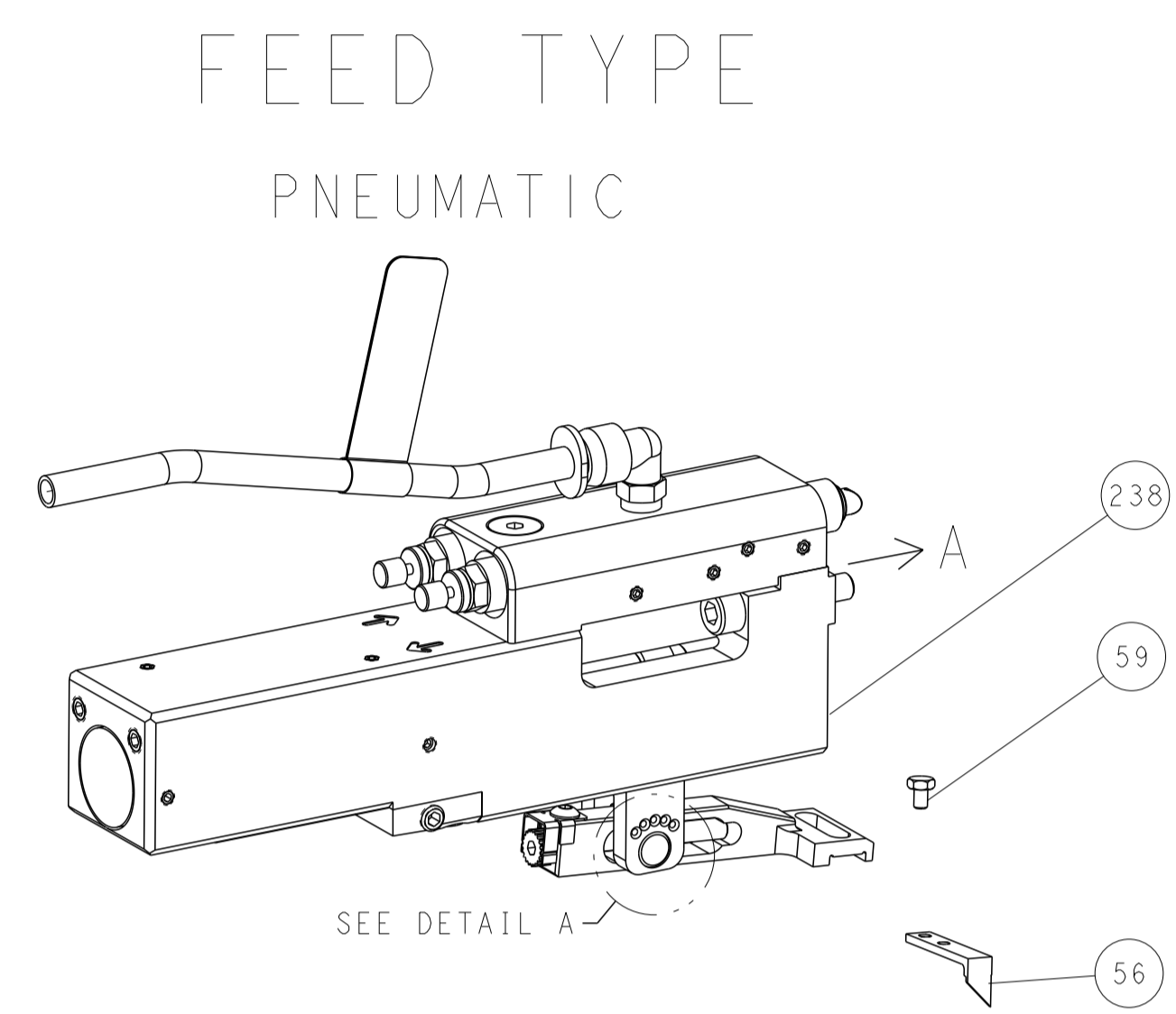


**ATLANTIC VERSION**  
 Shown on sheets 1 of 4 & 2 of 4  
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

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DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± MATERIAL: - FINISH: -		NAME: OCEAN 2.0 Side Feed Applicator APPLICATION SPEC: - SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2837246 WEIGHT: - SCALE: 1:2	RESTRICTED TO: - SHEET 2 OF 4 REV A
Customer Accessible Production Drawing			



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



**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 UNPUBLISHED. RELEASED FOR PUBLICATION 20. COPYRIGHT 20 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.</small>		DWN T. BROOKENS 06MAR2023 CHK M. HERR 06MAR2023 APVD T. ELBIN 06MAR2023	NAME <b>STE</b> TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm 	TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH	PRODUCT SPEC APPLICATION SPEC WEIGHT SCALE 1:2	OCEAN 2.0 Side Feed Applicator SIZE CAGE CODE DRAWING NO A1 00779 C=2837246 SHEET 4 OF 4 REV A
MATERIAL:		RESTRICTED TO:	Customer Accessible Production Drawing