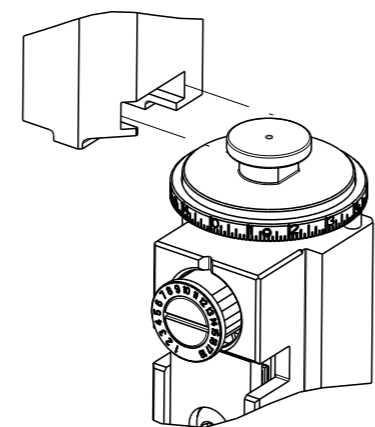


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2837654-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2837654-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2837654-1	B	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2837654-2	B	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2837654-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER

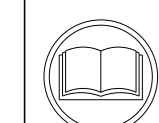


APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.36 mm [.093]	F
INSUL	2.54 mm [.100]	F

APPLICATOR INSTRUCTIONS 408-35042

TERMINAL DATA: DELPHI TERMINAL DELPHI CRIMP SPECIFICATION			
TERMINAL NAME: TAXI TERM M/P 280.1			
WIRE STRIP LENGTH	TERMINAL INSULATION DIAMETER RANGE		
4.70-5.50 mm [.185-.217 IN]	Ø2.00-2.70 mm [.079-.106 IN]		
TERMINAL APPLICATION SPECIFICATION	12077939 PG 4 Rev 2014-03-04	AT9106	
TERMINALS APPLIED			
TE TERMINAL	DELPHI TERMINAL	TE TERMINAL	DELPHI TERMINAL
286993-1	12077939		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.00mm2	1.20 +/- 0.05 [0.047 +/- .002]	6.4
0.80mm2	1.10 +/- 0.05 [0.043 +/- .002]	7.7
0.50mm2	1.05 +/- 0.05 [0.041 +/- .002]	8.0



- 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.

**\*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		DEVELOPMENT	14AUG2019	TB	TE
		A		RELEASED	10SEP2019	LG	TE
		B		ECR-20-010853	30JUL2020	JWC	GB

-	1	1	1	1	2119791-9	DEPRESSOR, WIRE	286
-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248
-	1	1	1	1	2119082-4	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	455888-5	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	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	53
-	1	1	1	1	1803382-2	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	3-1752356-4	SUPPORT, TERMINAL	34
-	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	2	2	2-2844962-4	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29
-	1	1	1	1	455888-5	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	5-1803250-7	ANVIL, COMBINATION	8
-	1	1	1	1	240641-9	SPACER	7
-	-	-	-	-	-	-	6
-	1	1	1	1	2119757-8	DEPRESSOR, SHEAR	5
-	1	1	1	1	3-238011-5	BLOCK, CRIMPER SPACER	4
1	2	2	1	1	1803223-1	CRIMPER, INSULATION F PREMIUM	3
-	1	1	1	1	455888-1	SPACER, CRIMPER	2
1	2	2	1	1	1633664-1	CRIMPER, WIRE	1
-	77	72	71	-2	-1	PART NO	ITEM NO

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		APPLICATOR DATA	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±
	ANGLES	FINISH	MATERIAL		
WEIGHT		SCALE		SHEET	
Customer Accessible Production Drawing		1:2		1 of 4	



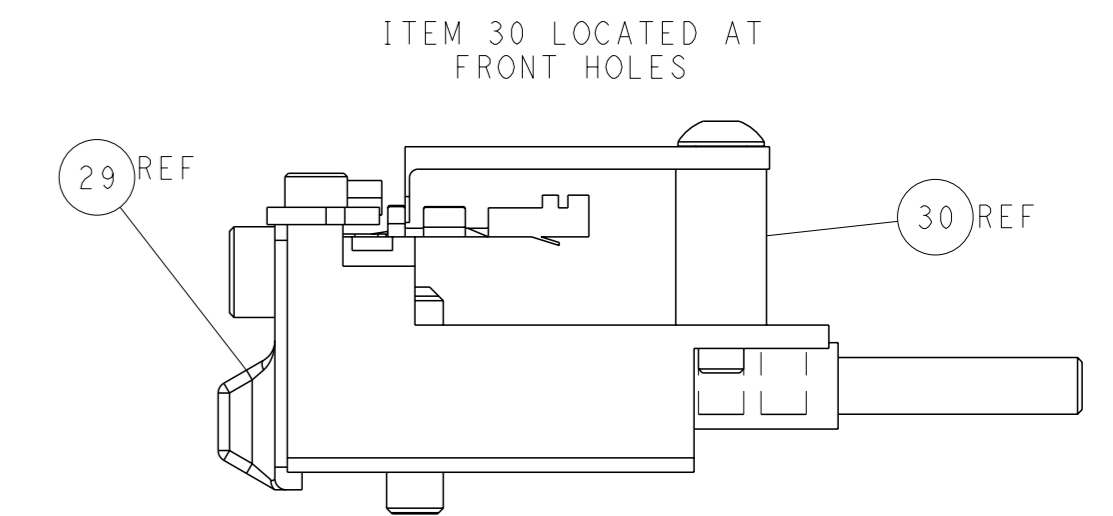
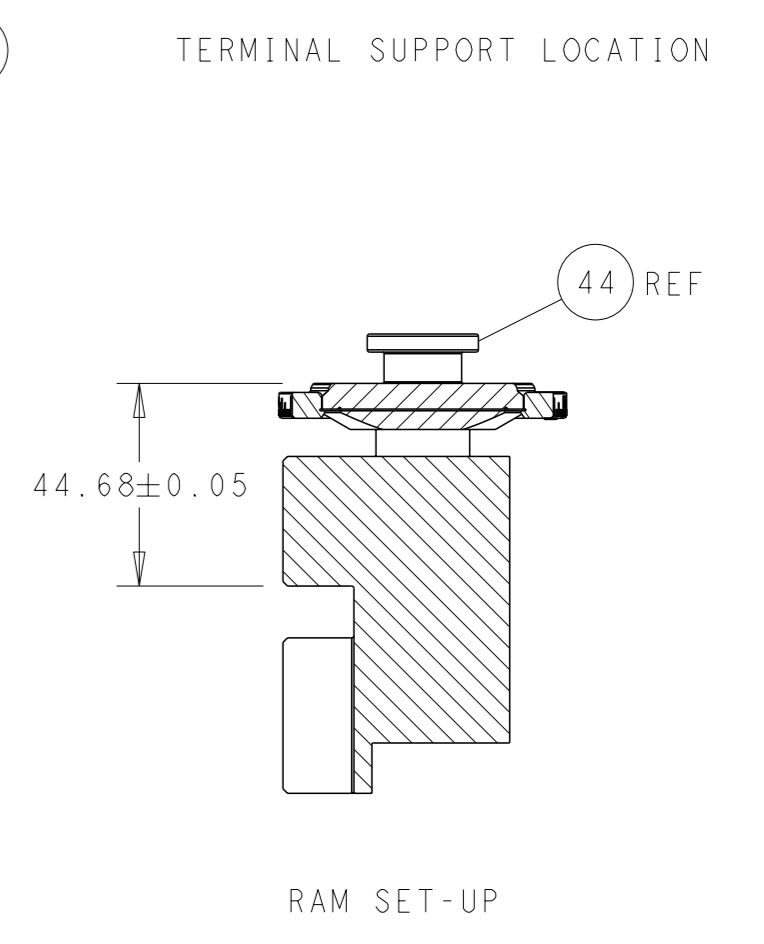
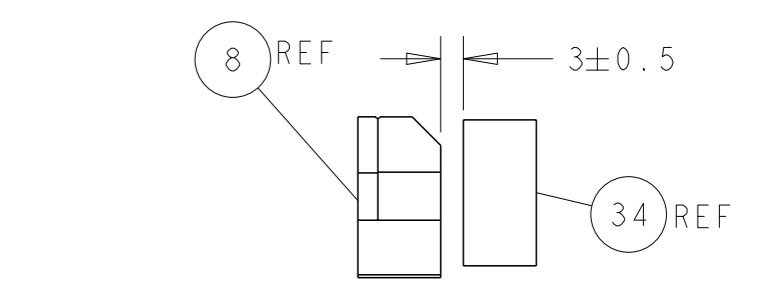
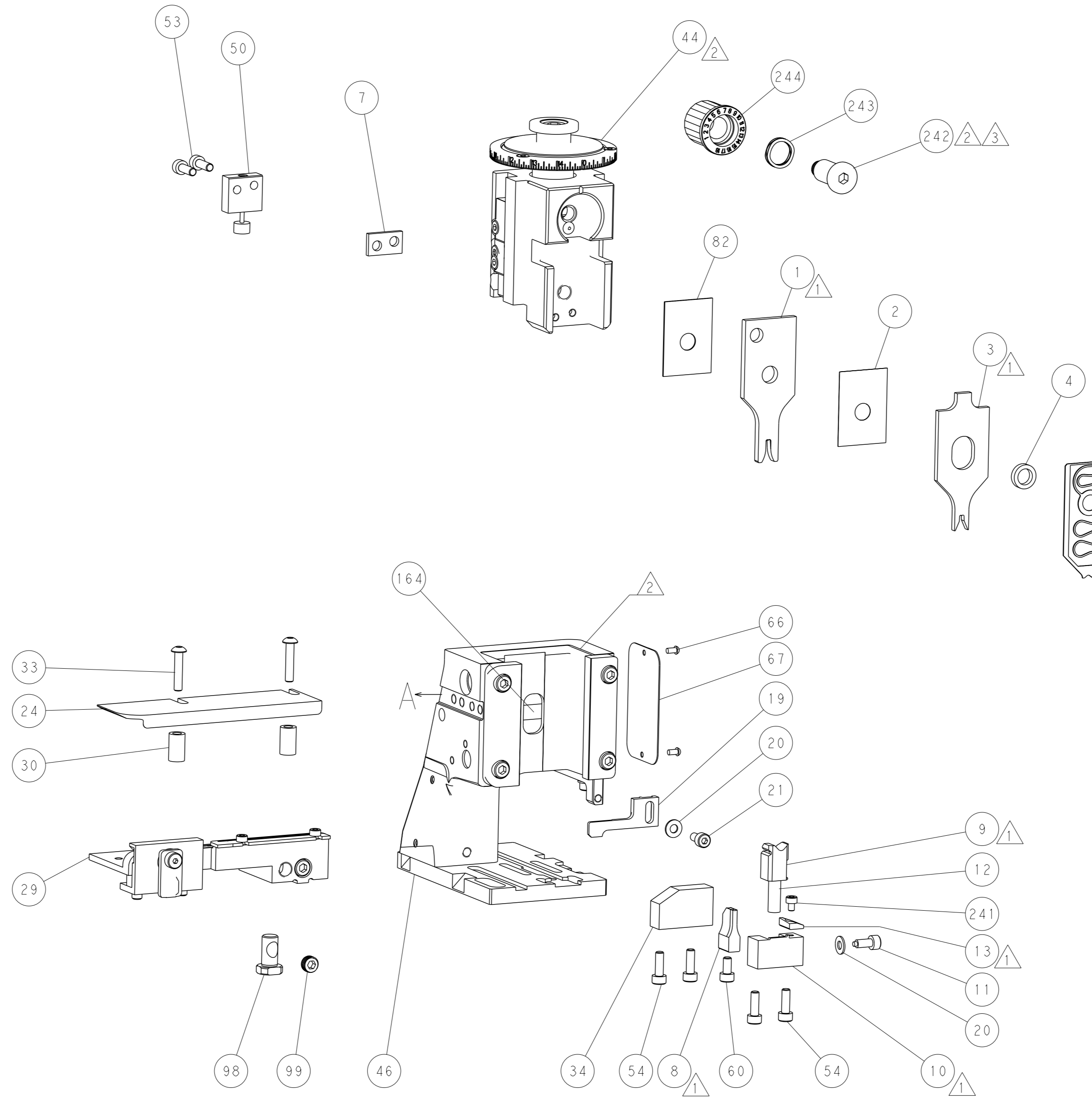
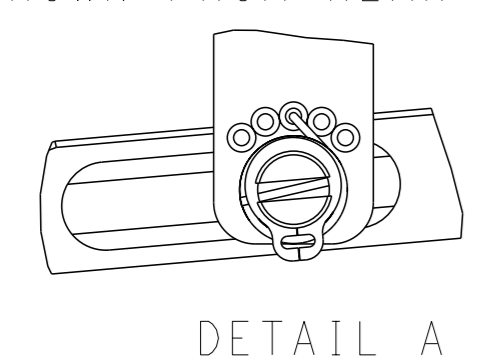
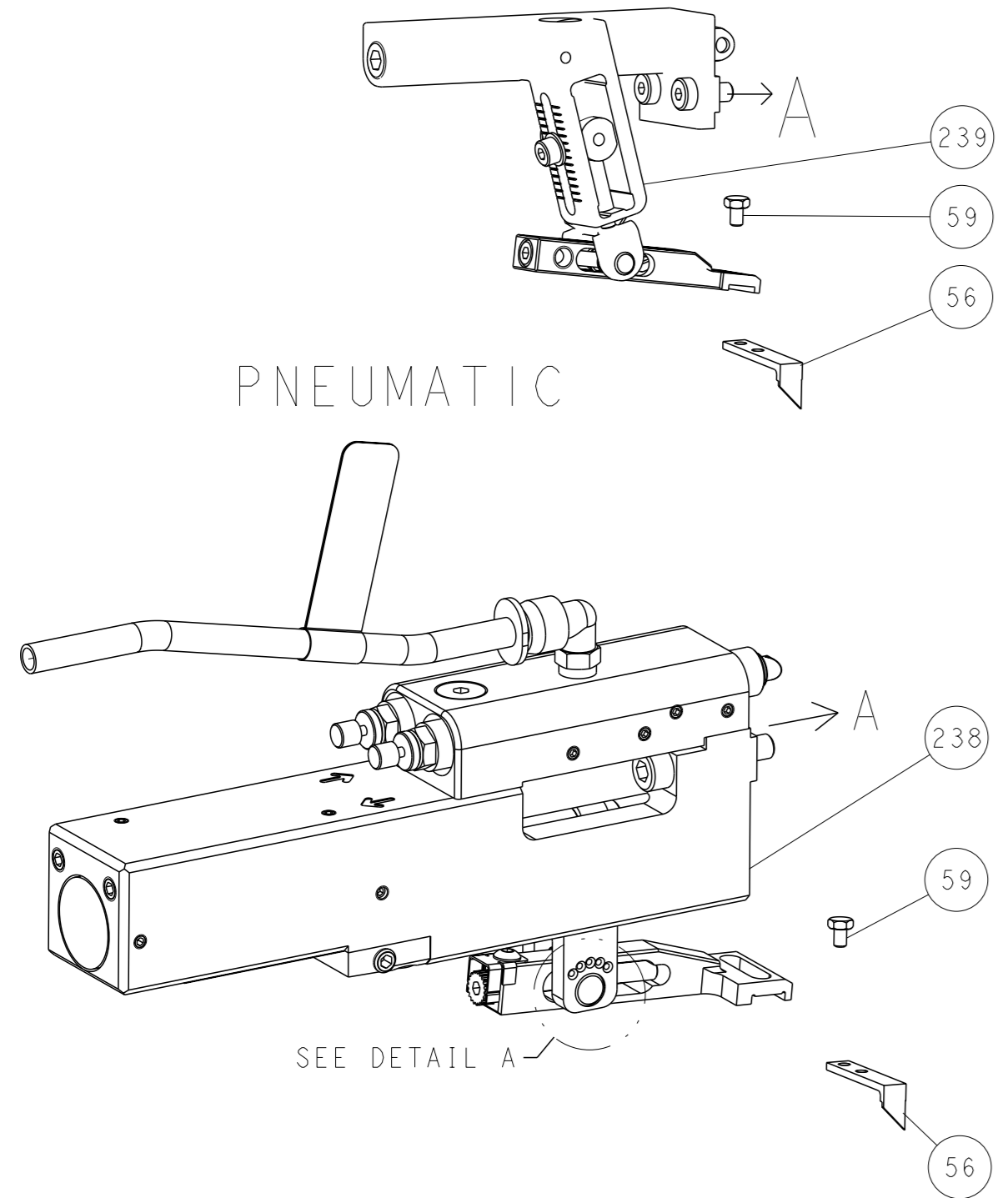
OCEAN 2.0 Side Feed Applicator

SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2837654

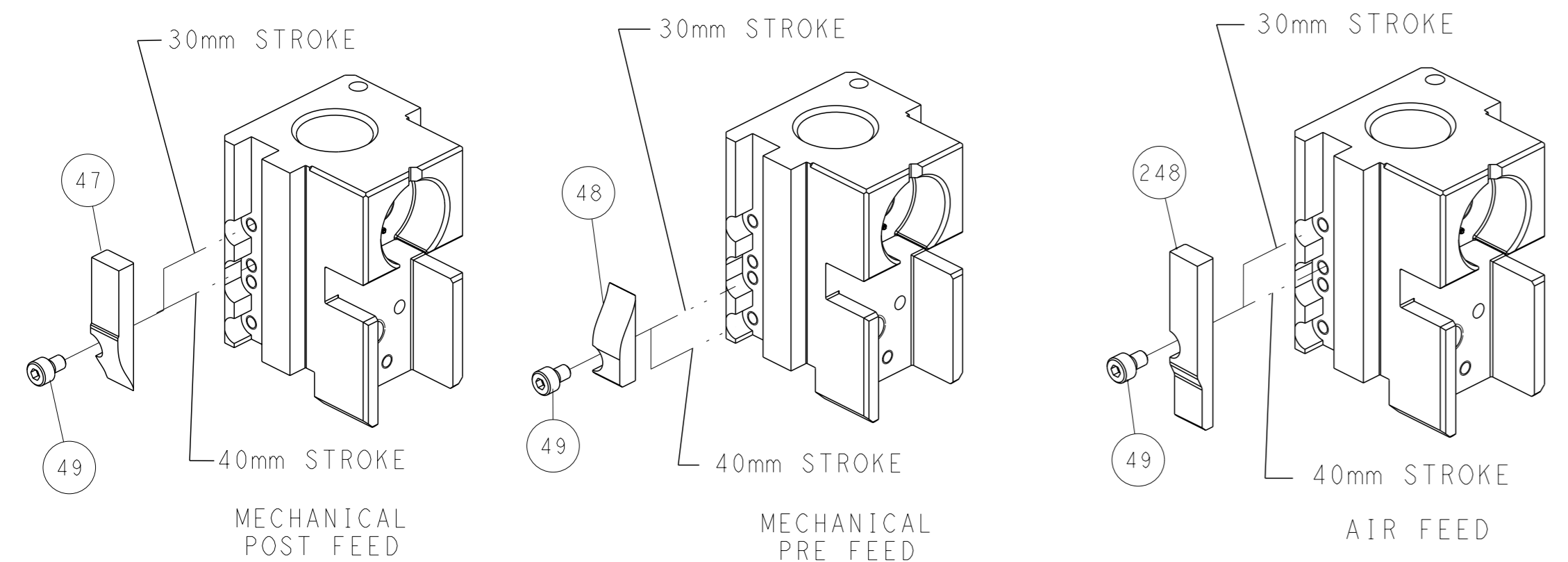
Customer Accessible Production Drawing SCALE: 1:2 SHEET: 1 of 4 REV: B

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

# FEED TYPE MECHANICAL



# CAM POSITIONS

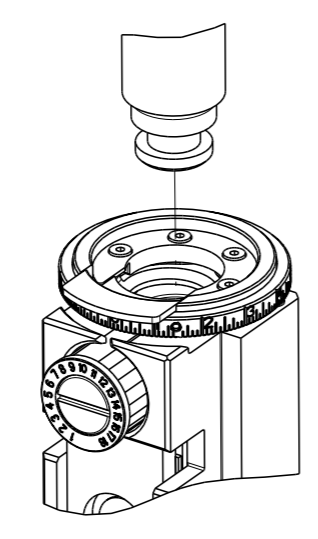


**ATLANTIC VERSION**  
 Shown on sheets 1 of 4 & 2 of 4  
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

<small>THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE AND THE CONTROLLER ENGINEERING ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST REVISION.</small>		DWN T. BROOKS 14AUG2019 CHK M. HERR 14AUG2019 APVD J. ELBIN 14AUG2019	<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 ±	NAME OCEAN 2.0 Side Feed Applicator APPLICATION SPEC SIZE CAGE CODE DRAWING NO. A1 00779 C=2837654 WEIGHT Customer Accessible Production Drawing	RESTRICTED TO SCALE 1:2 SHEET 2 of 4 REV B	

THIS DRAWING IS UNPUBLISHED.	RELEASED FOR PUBLICATION		
COPYRIGHT 20 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.			
PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2837654-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2837654-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2837654-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR  
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.36 mm [.093]	F
INSUL	2.54 mm [.100]	F
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: DELPHI TERMINAL DELPHI CRIMP SPECIFICATION	
TERMINAL NAME: TAXI TERM M/P 280.1	
WIRE STRIP LENGTH 4.70-5.50 mm [.185-.217 IN]	TERMINAL INSULATION DIAMETER RANGE Ø2.00-2.70 mm [.079-.106 IN]
TERMINAL APPLICATION SPECIFICATION 12077939 PG 4 Rev 2014-03-04	AT9106
TERMINALS APPLIED	
TE TERMINAL 286993-1	DELPHI TERMINAL 12077939

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.00mm2	1.20 +/- 0.05 [.047 +/- .002]	6.4
0.80mm2	1.10 +/- 0.05 [.043 +/- .002]	7.7
0.50mm2	1.05 +/- 0.05 [.041 +/- .002]	8.0

- 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.

**\*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)

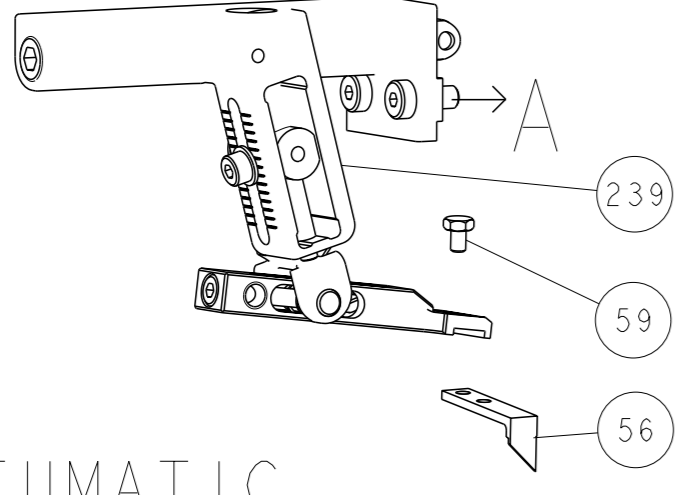
LOC	DIST	REV	DESCRIPTION	DATE	OWN	APVD
A	66	-	SEE SHEET 1	-	-	-

-	1	1	2119791-9	DEPRESSOR, WIRE	286
-	1	1	2119082-4	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
-	-	-	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	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	455888-5	SPACER, CRIMPER	82
-	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	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	1	1	1338685-1	PAWL, FEED	56
-	2	2	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	53
-	1	1	1803382-2	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	3-1752356-4	SUPPORT, TERMINAL	34
-	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	2-2844962-4	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29
-	1	1	455888-5	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	1-356885-4	STOP, SHEAR	11
-	1	1	2119805-1	SHEAR HOLDER, FRONT	10
-	1	1	1803095-6	FLOATING SHEAR, FRONT	9
1	1	1	5-1803250-7	ANVIL, COMBINATION	8
-	1	1	240641-9	SPACER	7
-	-	-	-	-	6
-	1	1	2119757-8	DEPRESSOR, SHEAR	5
-	1	1	3-238011-5	BLOCK, CRIMPER SPACER	4
1	1	1	1803223-1	CRIMPER, INSULATION F PREMIUM	3
-	1	1	455888-1	SPACER, CRIMPER	2
1	1	1	1633664-1	CRIMPER, WIRE	1
-	77	-22	-21	PART NO	ITEM NO

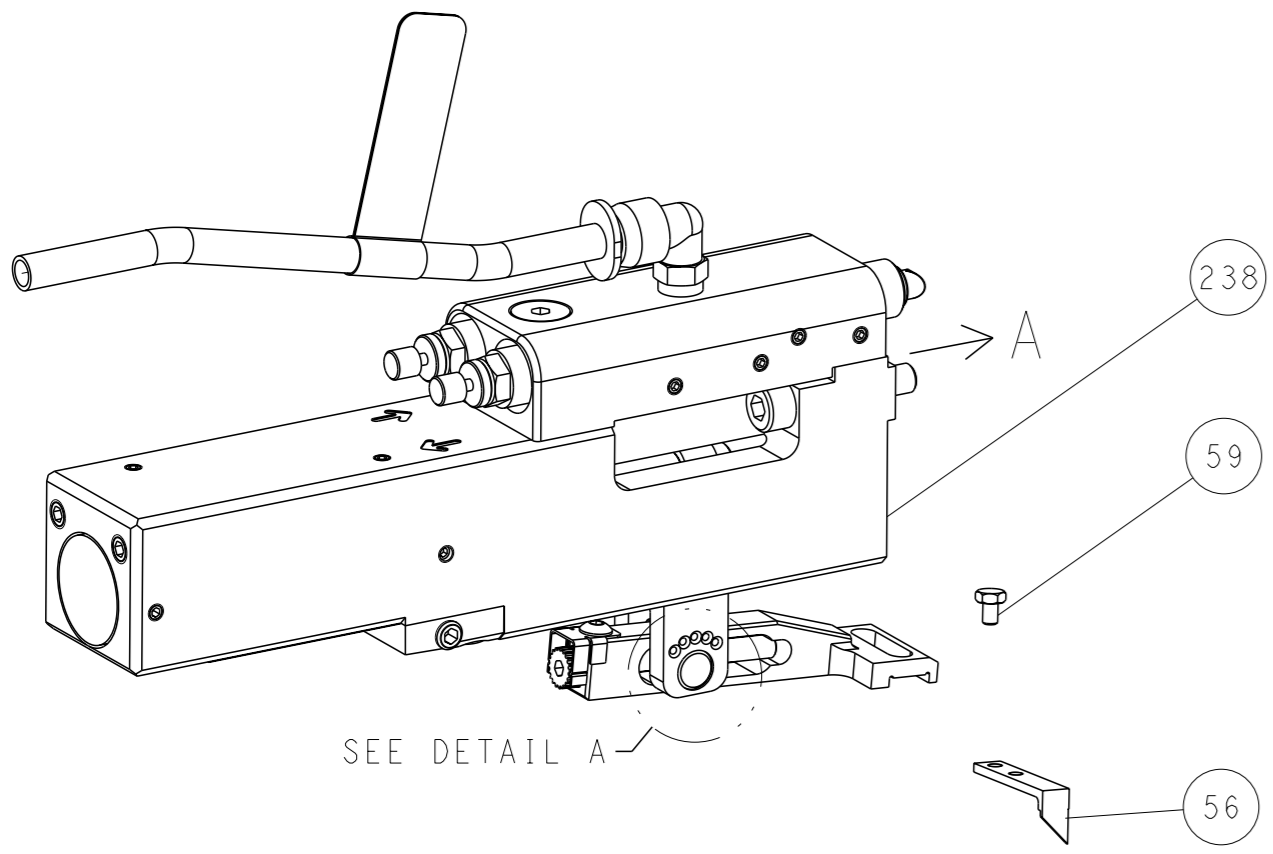
<small>THE DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE AND THE CUSTOMER MUST CONTACT THE SELLING ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST REVISION.</small>		DWN T. BROOKENS 14AUG2019 CHK M. HERR 14AUG2019 APVD J. ELBIN 14AUG2019	
DIMENSIONS: mm 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH ±		TOLERANCES UNLESS OTHERWISE SPECIFIED: ±	NAME: OCEAN 2.0 Side Feed Applicator SIZE: A1 CASE CODE: 00779 DRAWING NO: 2837654 RESTRICTED TO: -
MATERIAL: -		WEIGHT: -	SCALE: 1:2 SHEET: 3 of 4 REV: B

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

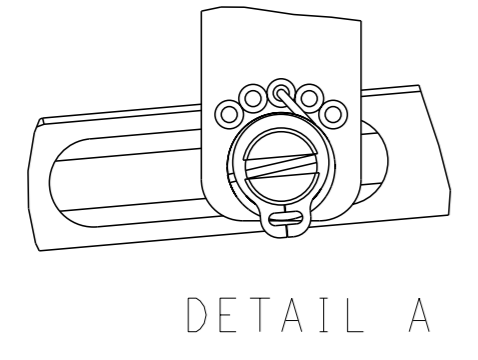
# FEED TYPE MECHANICAL



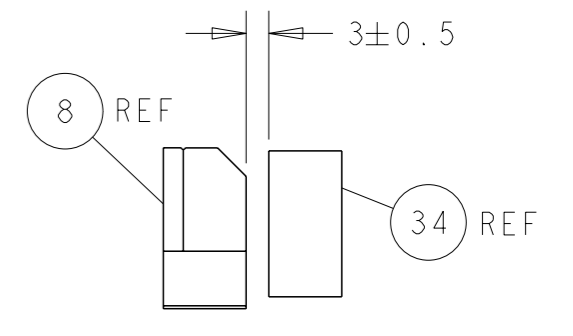
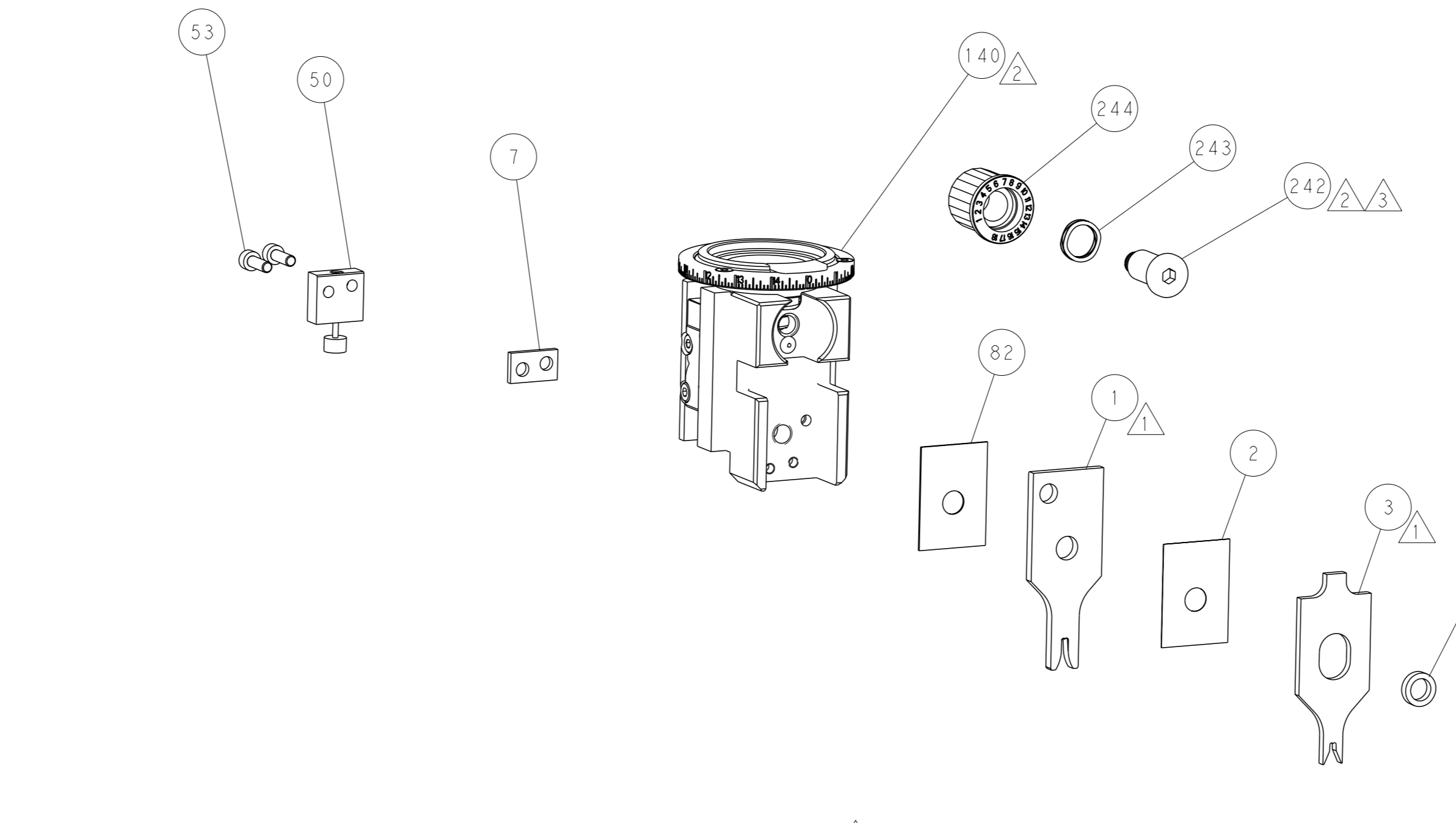
## PNEUMATIC



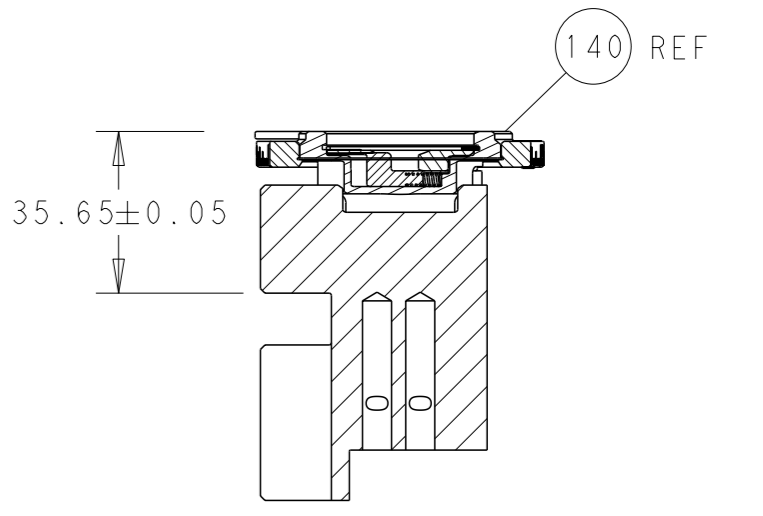
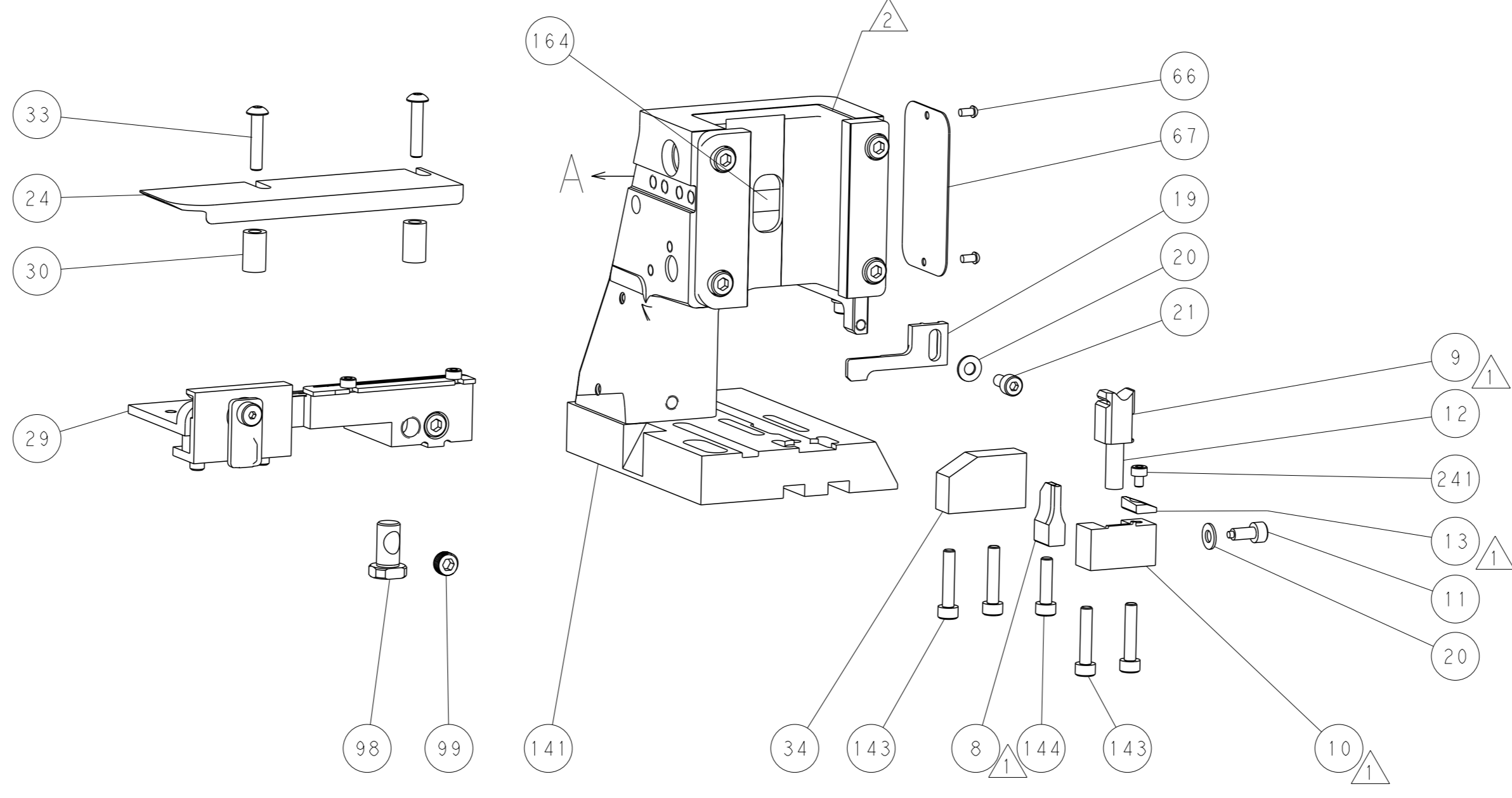
## FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



DETAIL A

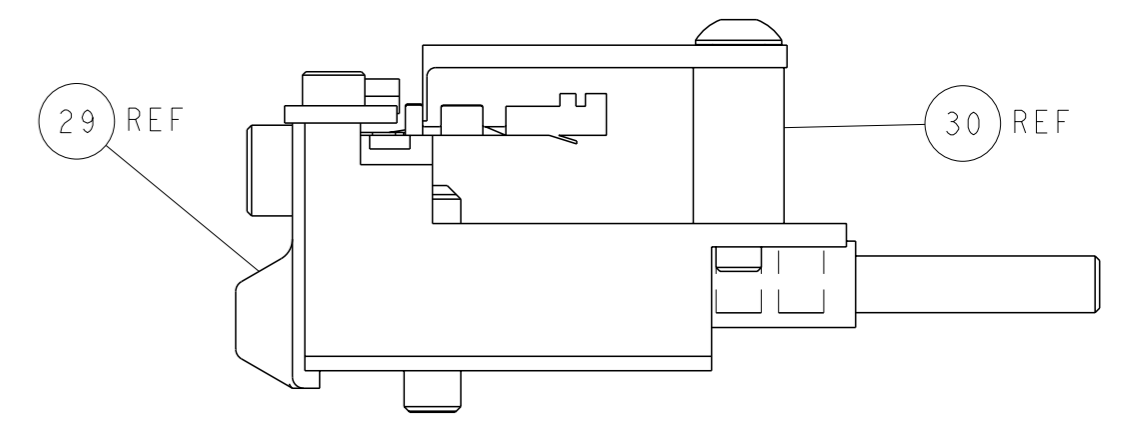


TERMINAL SUPPORT LOCATION



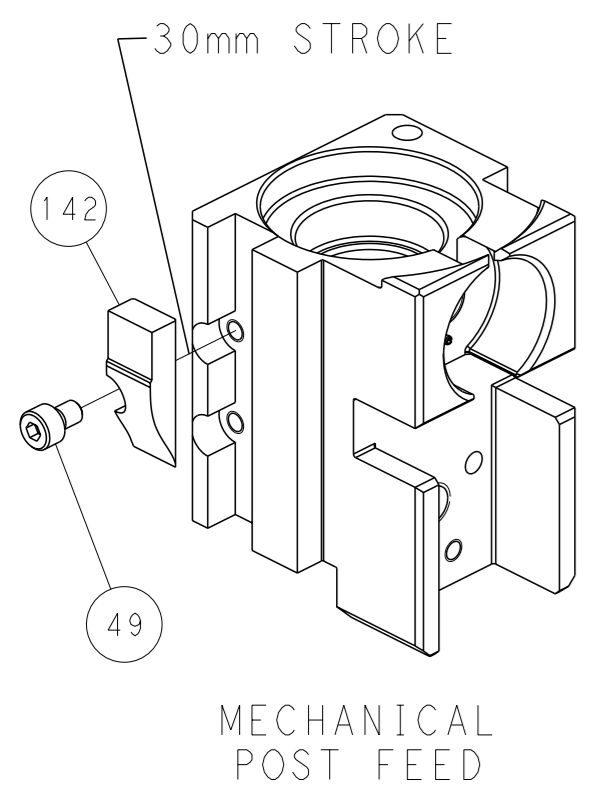
RAM SET-UP

ITEM 30 LOCATED AT  
FRONT HOLES

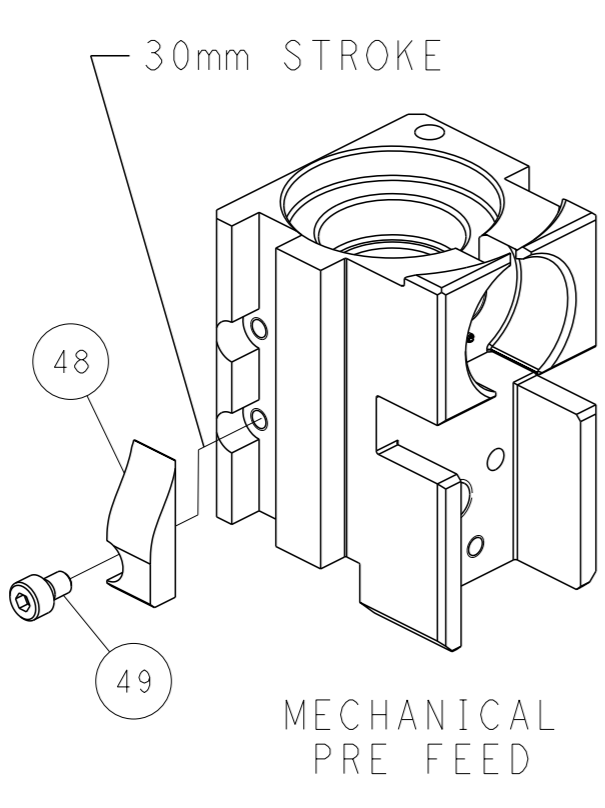


FEED TRACK POSITION  
GUIDE BY INSULATION BARREL

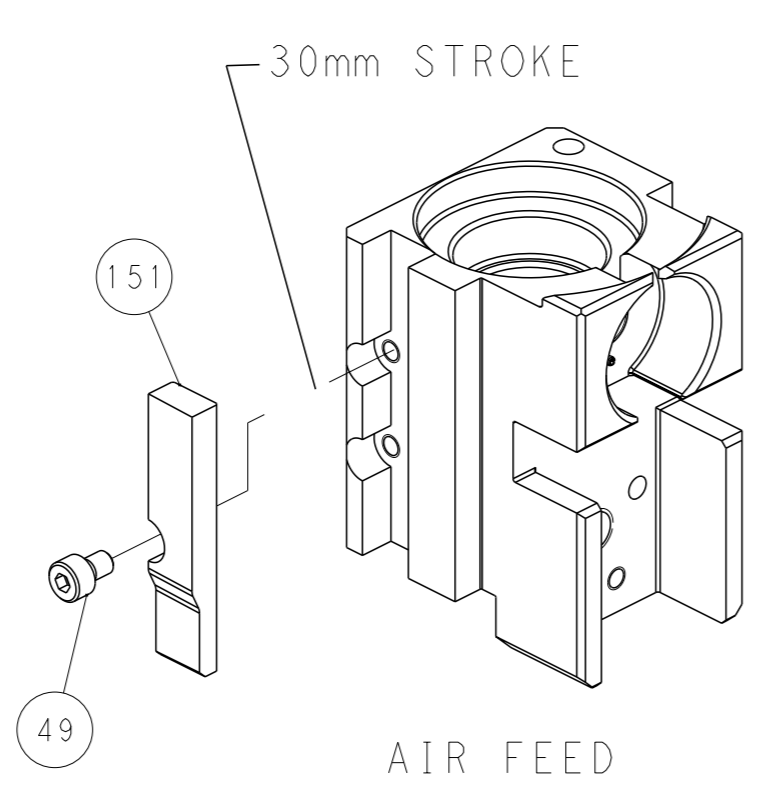
# CAM POSITIONS



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)

<small>THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE AND THE USER'S RESPONSIBILITY TO OBTAIN THE LATEST REVISION SHOULD BE CONTACTED FOR THE LATEST REVISION.</small>		DWN T. BROOKS 14AUG2019 CHK M. HERR 14AUG2019 APVD J. ELBIN 14AUG2019	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 ±	PRODUCT SPEC APPLICATION SPEC WEIGHT SCALE 1:2	SIZE CAGE CODE DRAWING NO A1 00779 C=2837654 RESTRICTED TO SHEET 4 OF 4 REV B
MATERIAL:		Customer Accessible Production Drawing	