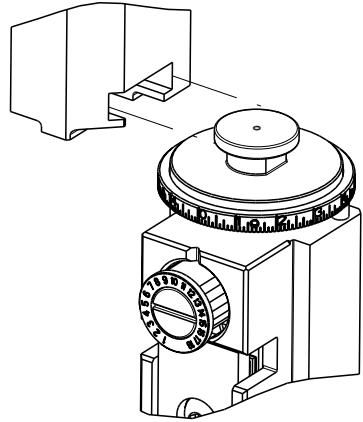
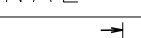
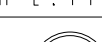


8		7	
THIS DRAWING IS UNPUBLISHED.		RELEASED FOR PUBLICATION	
20		20	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2837939-1	A	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2837939-2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2837939-1	A	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2837939-2	A	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2837939-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.07 mm [.042]	F
INSUL	1.80 mm [.071]	F
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: SUMIKO TERMINAL		SUMIKO CRIMP SPECIFICATION	
TERMINAL NAME: TERMINAL			
WIRE STRIP LENGTH			TERMINAL INSULATION DIAMETER RANGE
3.00-3.50 mm [.118-.138 IN]			Ø1.20-1.70 mm [.047-.067 IN]
TERMINAL APPLICATION SPECIFICATION			510353.303 Rev -
		-	-
		-	AT9106
TERMINALS APPLIED 			
TE TERMINAL	SUMIKO TERMINAL	TE TERMINAL	SUMIKO TERMINAL
3311751-1	510353-2M		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
22 AWG	0.75+/-0.03 [.030+/- .001]	6.4
24 AWG	0.72+/-0.03 [.028+/- .001]	6.7
26 AWG	0.68+/-0.03 [.027+/- .001]	7.1
28 AWG	0.63+/-0.03 [.025+/- .001]	7.6



- △ RECOMMENDED SPARE PARTS
- △ REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- △ APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 180. 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.
- △ TERMINAL LUBRICANT IS RECOMMENDED.

*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)

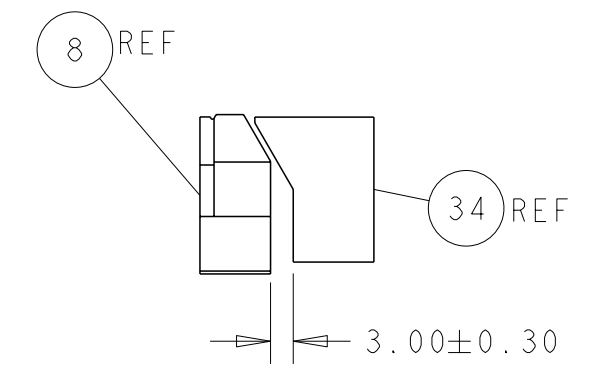
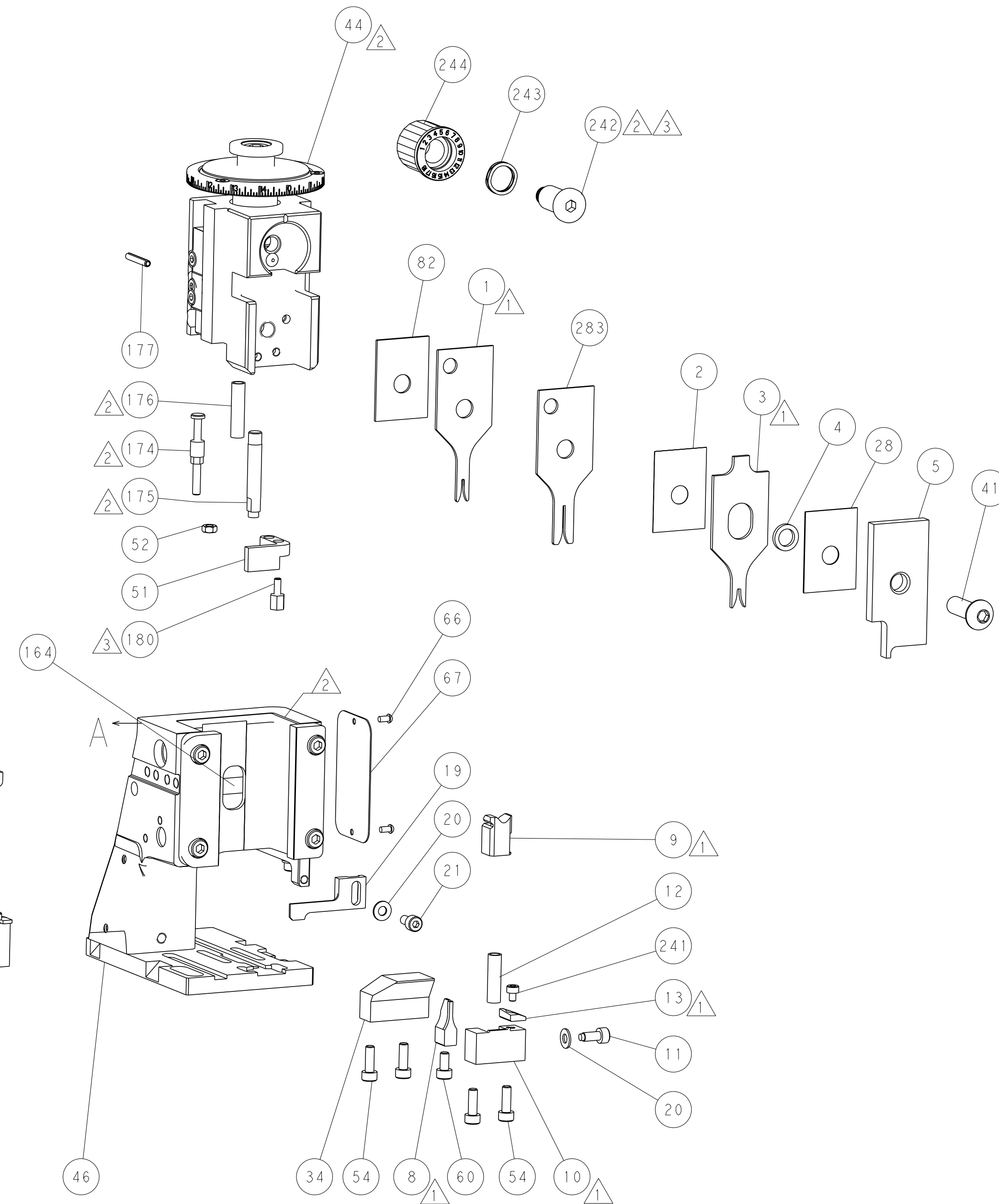
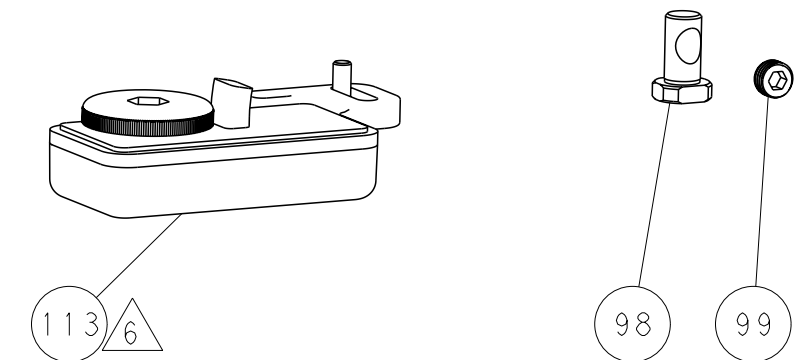
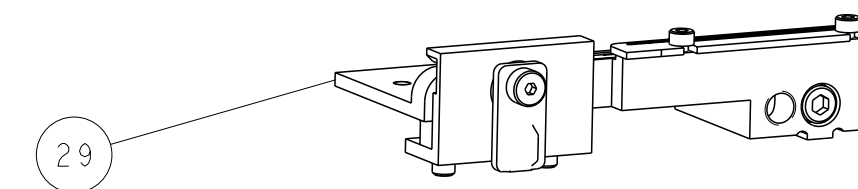
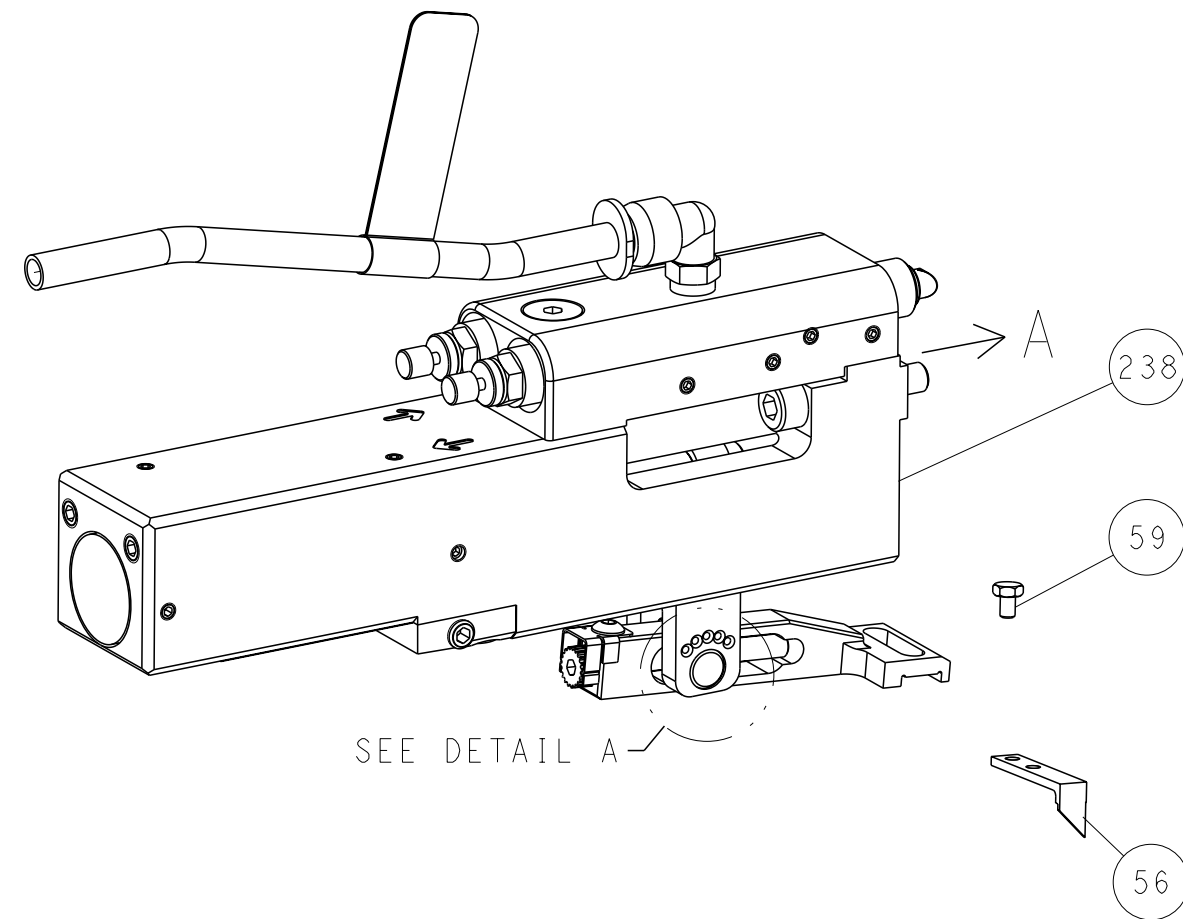
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LOC	DIST	REVISIONS						
A	66	P	LTR	DESCRIPTION	DATE	DWN	APVD	
			1	DEVELOPMENT	14JAN2021	FJ	YY	
			A	RELEASED FOR PRODUCTION	25FEB2021	JWC	GB	

-	1	1	1	1	1-1803511-6	CRIMPER, WIRE LOOSE PIECE	283
-	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
△ 3	-	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
△ 3	-	1	1	1	1-1752354-1	STANDOFF,HOLD-DOWN	180
-	1	1	1	1	9931111-1	PIN, SLOTTED SPRING 3.0 X 20.0	177
-	1	1	1	1	8-22280-7	SPRING, COMPRESSION	176
-	1	1	1	1	1752353-2	GUIDE PIN,HOLDDOWN	175
-	1	1	1	1	1901680-2	GUIDE PIN,HOLDDOWN	174
-	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
△ 6	-	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	1-455888-0	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
-	1	1	1	1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52
-	1	1	1	1	1-1901681-7	HOLDDOWN, TERMINAL	51
-	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	1803515-3	RAM ASSEMBLY, SF ATLANTIC	44
-	1	1	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
-	1	1	1	1	6-1752356-7	SUPPORT, TERMINAL	34
-	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	2	2	2-2844962-6	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	1-2119533-6	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	1-356885-5	STOP, SHEAR	11
△ 1	-	1	1	1	2119805-1	SHEAR HOLDER, FRONT	10
△ 1	-	1	1	1	1803095-6	FLOATING SHEAR, FRONT	9
△ 1	1	2	2	1	1-1803512-4	ANVIL, COMBINATION	8
-	-	-	-	-	-	-	7
-	-	-	-	-	-	-	6
-	1	1	1	1	1-2119757-0	DEPRESSOR, SHEAR	5
-	1	1	1	1	238011-7	BLOCK, CRIMPER SPACER	4
△ 1	1	2	2	1	2-2119582-0	CRIMPER, INSULATION F PREMIUM	3
-	1	1	1	1	455888-1	SPACER, CRIMPER	2
△ 1	1	2	2	1	456401-2	CRIMPER, WIRE .042 F PREMIUM	1
-	77	72	71	-2	-1	PART NO	ITEM NO

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.				DWN	J. FENG	14JAN2021	 TE Connectivity Harrisburg, PA 17105-3608								
DIMENSIONS: mm  TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH				CHK	Y. YIN	14JAN2021	NAME	OCEAN 2.0 Side Feed Applicator							
				APVD	Y. YIN	14JAN2021									
				PRODUCT SPEC											
				APPLICATION SPEC											
MATERIAL FINISH				SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO								
				A1 00779 ©=2837939				-							
				Customer Accessible Production Drawing				SCALE	1:2	SHEET	1	OF	4	REV	A

SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

PNEUMATIC



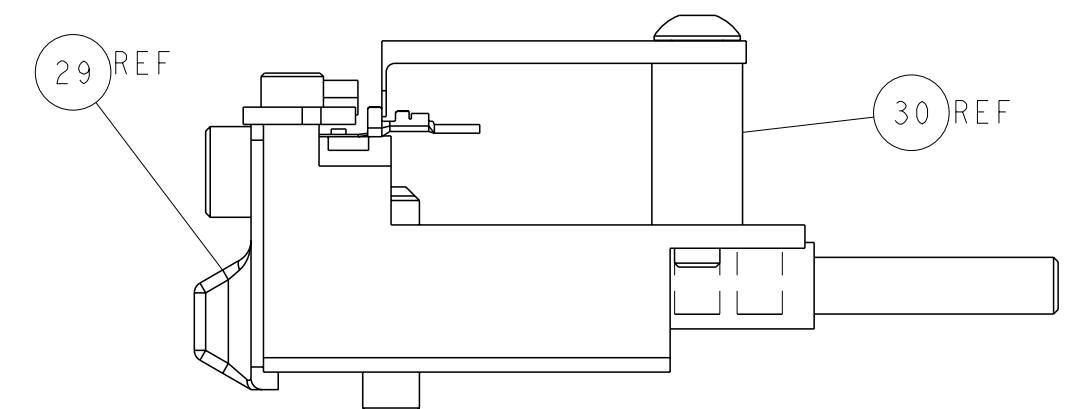
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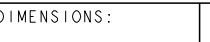
17.0 ± 0.5

44 REF

180 REF

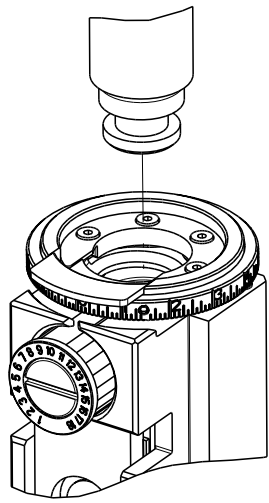
ITEM 30 LOCATED AT
FRONT HOLES



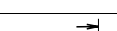
THIS DRAWING IS A CONTROLLED DOCUMENT FROM TFCO INDUSTRIES CORPORATION IT IS SUBJECT TO THE TFCO INDUSTRIES CORPORATION ORGANIZATION IT SHOULD BE CONTACTED FOR THE LATEST REVISION.		DWN 14JAN2021 CRK 14JAN2021 Y.YIN 14JAN2021		 TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		NAME OCEAN 2.0 Side Feed Applicator -	
		APPLICATION SPEC -		SIZE A1	
MATERIAL FINISH		WEIGHT -		CAGE CODE 00779	
- -		DRAWING NO C=2837939		RESTRICTED TO -	
		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
2-2837939-1	A	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2837939-2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2837939-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.07 mm [.042]	F
INSUL	1.80 mm [.071]	F
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: SUMIKO TERMINAL				SUMIKO CRIMP SPECIFICATION			
TERMINAL NAME: TERMINAL							
WIRE STRIP LENGTH				TERMINAL INSULATION DIAMETER RANGE			
3.00-3.50 mm [.118-.138 IN]				Ø1.20-1.70 mm [.047-.067 IN]			
TERMINAL APPLICATION			510353.303 Rev -	-	-	-	
SPECIFICATION			-	-		AT9106	
TERMINALS APPLIED 							
TE TERMINAL		SUMIKO TERMINAL		TE TERMINAL		SUMIKO TERMINAL	
3311751-1		510353-2M					

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING
22 AWG		0.75+/-0.03 [.030+/-0.001]		6.4
24 AWG		0.72+/-0.03 [.028+/-0.001]		6.7
26 AWG		0.68+/-0.03 [.027+/-0.001]		7.1
28 AWG		0.63+/-0.03 [.025+/-0.001]		7.6



- 1 RECOMMENDED SPARE PARTS
- 2 REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- 3 APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 180. 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 LUBRICANT IS RECOMMENDED.

*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	LYR	DESCRIPTION	DATE	DWN	APVD	
		-		SEE SHEET 1	-	-	-	

-	1	1	1-1803511-6	CRIMPER, WIRE LOOSE PIECE	283
-	1	1	2119082-5	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
3	-	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
3	-	1	1-1752354-1	STANDOFF,HOLD-DOWN	180
-	1	1	993111-1	PIN, SLOTTED SPRING 3.0 X 20.0	177
-	1	1	8-22280-7	SPRING, COMPRESSION	176
-	1	1	1752353-2	GUIDE PIN,HOLDDOWN	175
-	1	1	1901680-2	GUIDE PIN,HOLDDOWN	174
-	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
6	-	1	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113
-	1	1	2844908-1	SCREW, LOCKING	99
-	1	1	2844907-1	POST, LOCKING	98
-	1	1	1-455888-0	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
-	1	1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52
-	1	1	1-1901681-7	HOLDDOWN, TERMINAL	51
-	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	6-1752356-7	SUPPORT, TERMINAL	34
-	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	2-2844962-6	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	1-2119533-6	STRIPPER, SIDE FEED	19
1	-	1	2119806-1	INSERT, SHEAR	13
-	1	1	3-22280-3	SPRING, COMPRESSION	12
-	1	1	1-356885-5	STOP, SHEAR	11
1	-	1	2119805-1	SHEAR HOLDER, FRONT	10
1	-	1	1803095-6	FLOATING SHEAR, FRONT	9
1	1	1	9-1803512-4	ANVIL, COMBINATION	8
-	-	-	-	-	7
-	-	-	-	-	6
-	1	1	1-2119757-0	DEPRESSOR, SHEAR	5
-	1	1	238011-7	BLOCK, CRIMPER SPACER	4
1	1	1	2-2119582-0	CRIMPER, INSULATION F PREMIUM	3
-	1	1	455888-1	SPACER, CRIMPER	2
1	1	1	456401-2	CRIMPER, WIRE .042 F PREMIUM	1
-77	-22	-21	PART NO	DESCRIPTION	ITEM NO

THIS DRAWING IS A CONTROLLED DOCUMENT FOR THE ELECTRICAL CONSTRUCTION INDUSTRY. IT IS SUBJECT TO CHANGE AND TO THE EXTENT OF THE CHANGES, THE USER SHALL BE CONTACTED FOR THE LATEST REVISION.				DWN J. FENG 14JAN2021	TE Connectivity Harrisburg, PA 17105-3608			
DIMENSIONS: mm				CHK Y. YIN 14JAN2021	NAME OCEAN 2.0 Side Feed Applicator			
				APVD Y. YIN 14JAN2021	PRODUCT SPEC			
					APPLICATION SPEC			
					SIZE CASE CODE DRAWING NO			
					RESTRICTED TO			
MATERIAL -				FINISH -	WEIGHT -	A1 00779 ©=2837939		
				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					
		P	LYR	DESCRIPTION	DATE	OWN	APVD
A	66	-	-	SEE SHEET 1	-	-	-

D

C

B

A

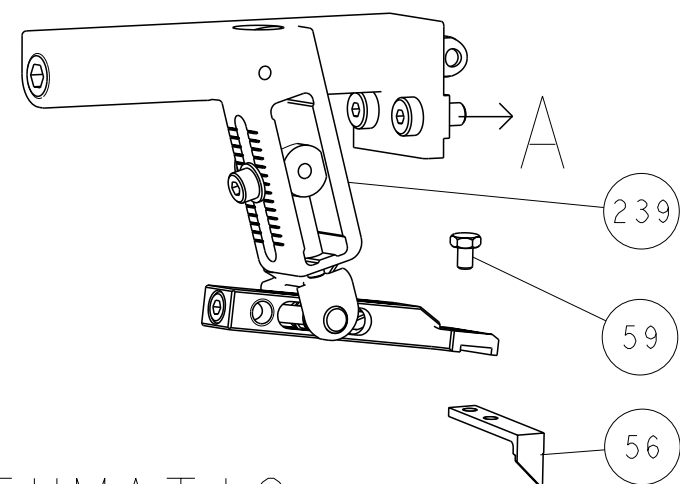
D

C

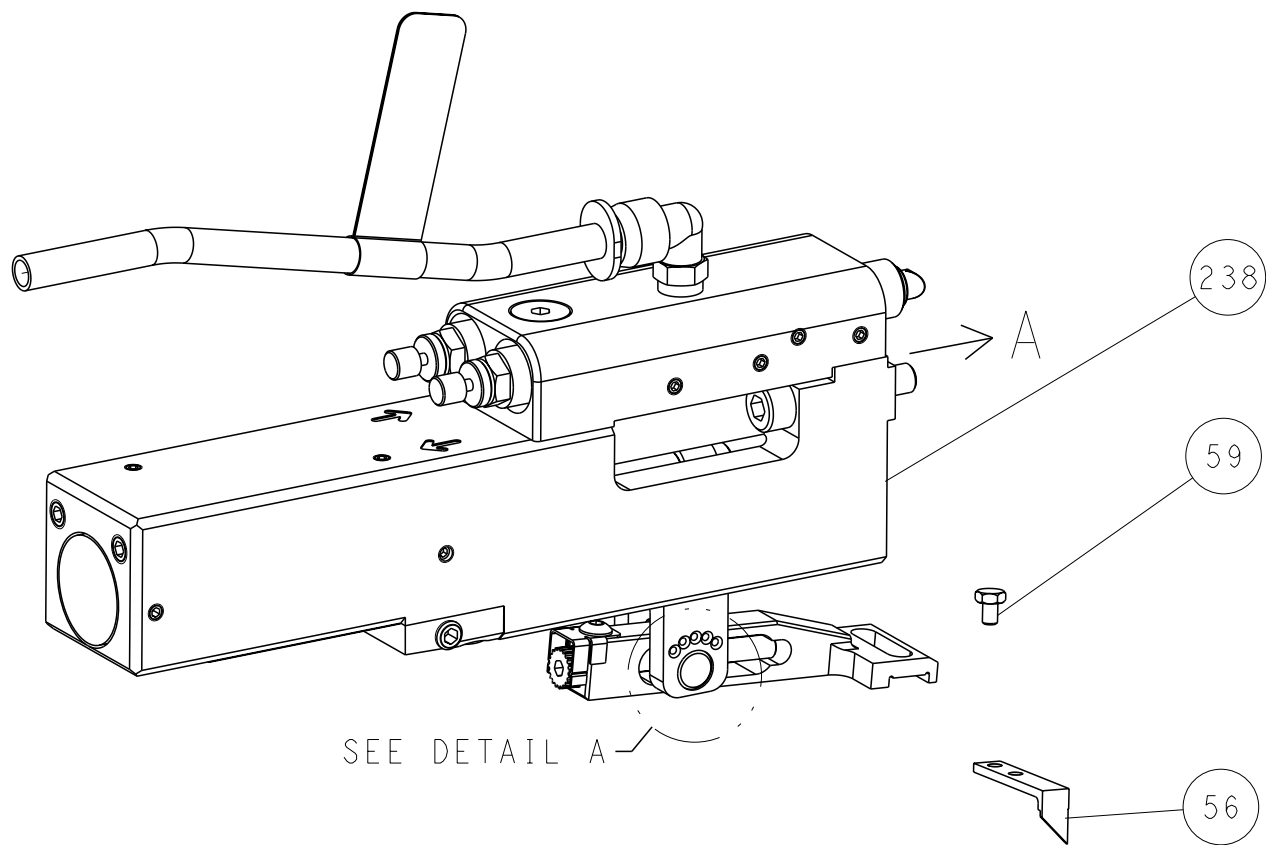
B

A

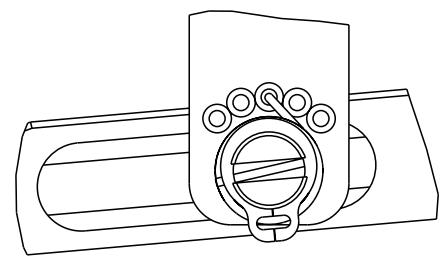
FEED TYPE MECHANICAL



PNEUMATIC

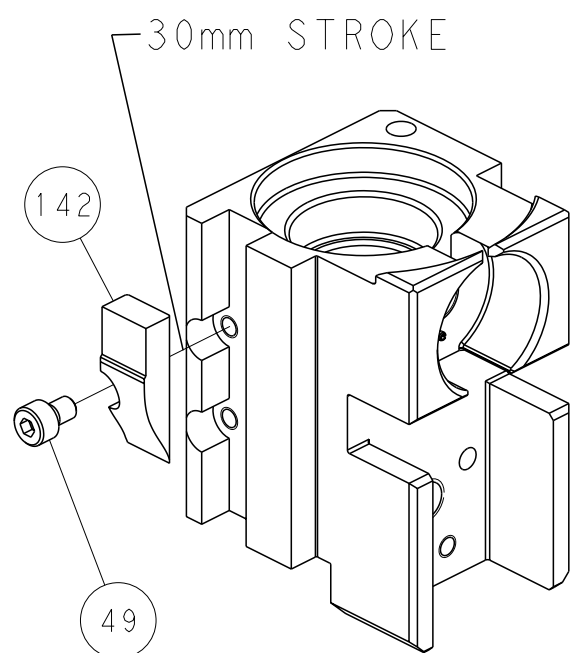


FEED SPRING SETTING POSITION
(SHOWN FROM REAR SIDE)

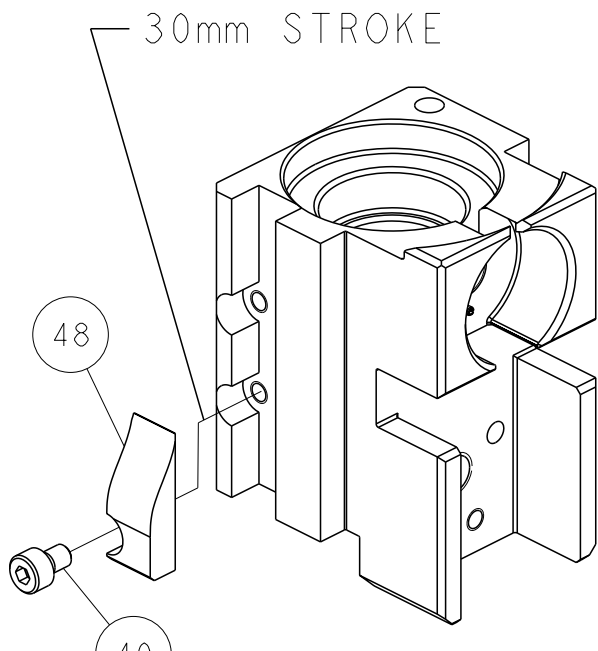


DETAIL A

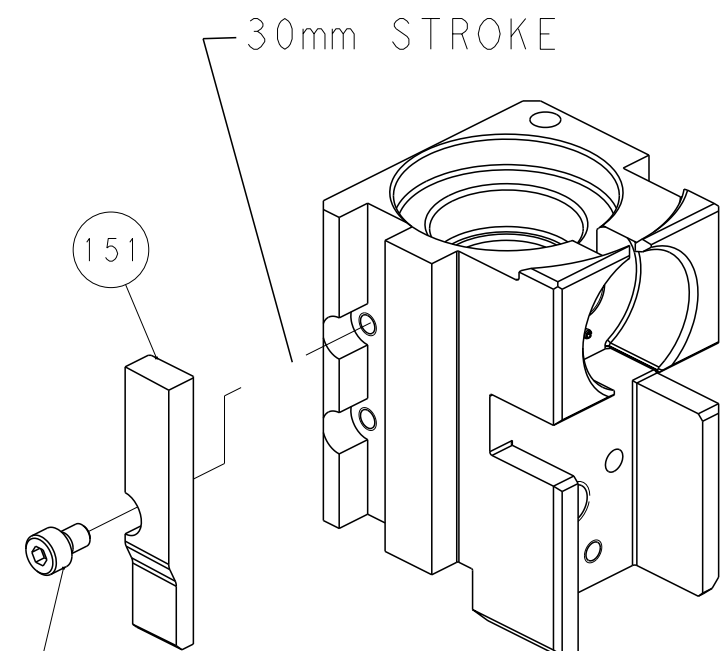
CAM POSITIONS



MECHANICAL
POST FEED

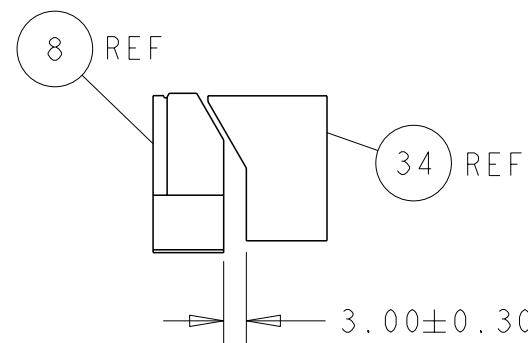
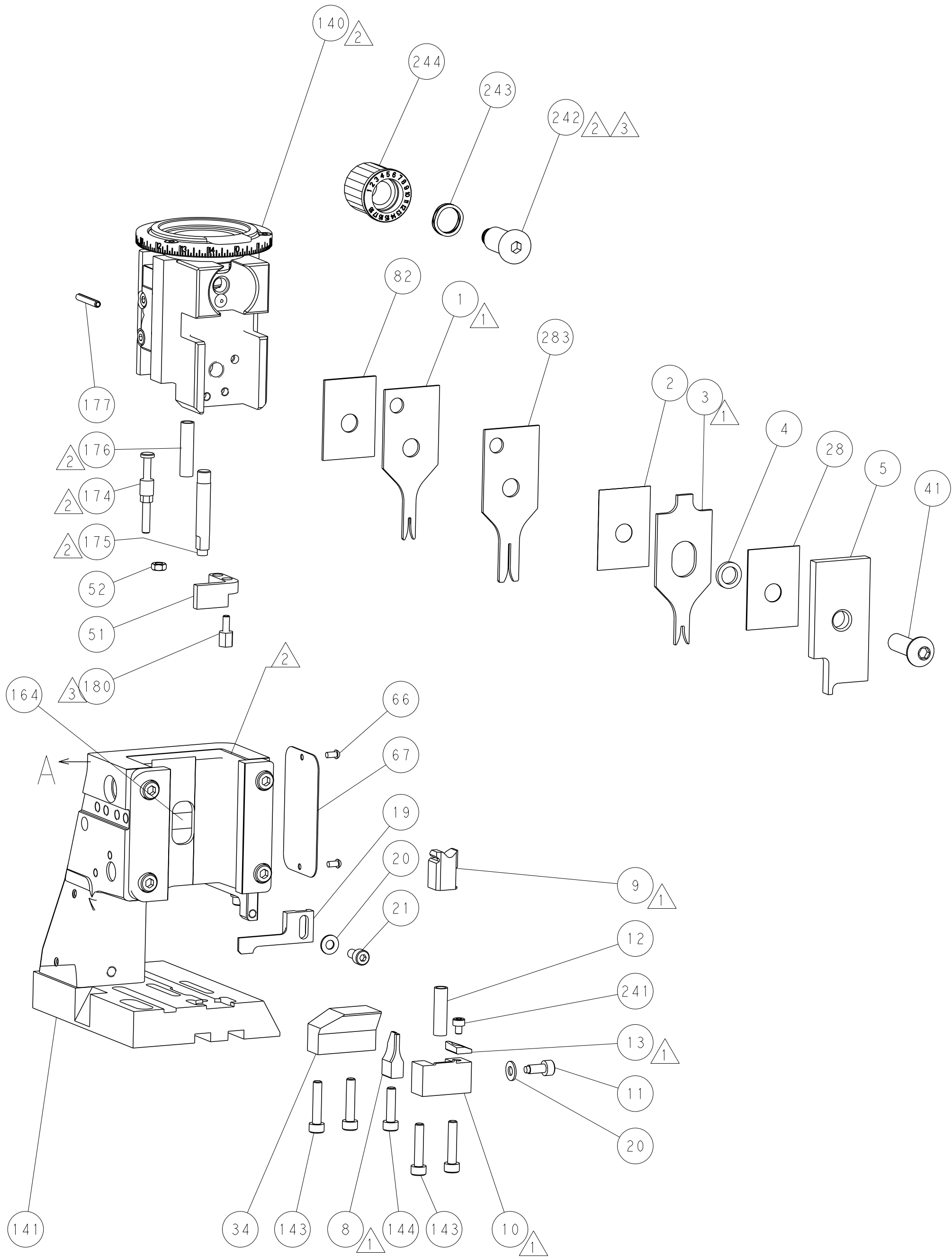


MECHANICAL
PRE FEED

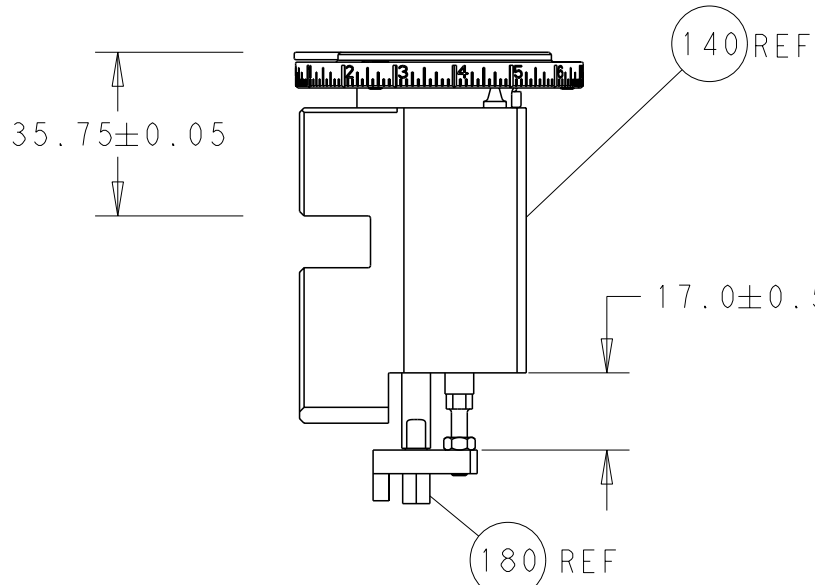


AIR FEED

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

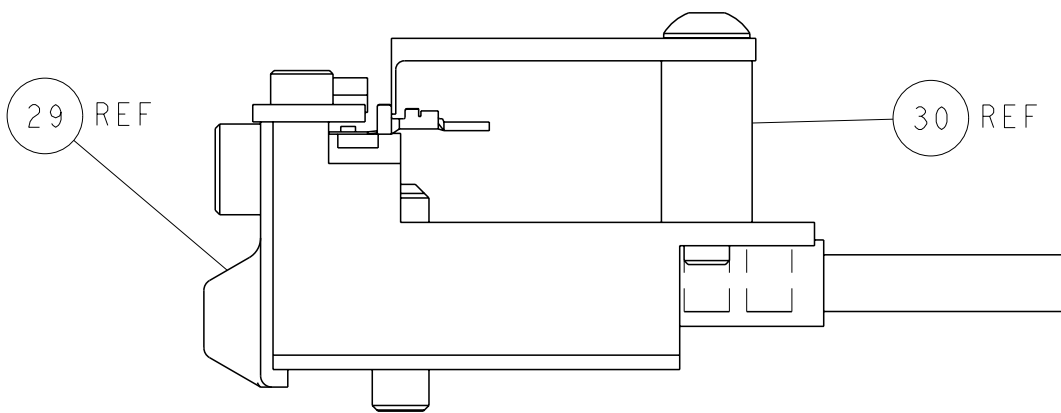


TERMINAL SUPPORT LOCATION



RAM AND HOLD-DOWN SET-UP

ITEM 30 LOCATED AT
FRONT HOLES



FEED TRACK POSITION
GUIDE BY INSULATION BARREL

1:11 DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION IT IS SUBJECT TO CHANGE AND TO CONTROL AND ENGINEERING ORGANIZATION SHALL BE CONTACTED FOR THE LATEST REVISION		OWN J. FENG CHK Y. YIN APVD Y. YIN	14JAN2021 14JAN2021 14JAN2021	NAME OCEAN 2.0 Side Feed Applicator	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	
MATERIAL -		FINISH -		APPLICATION SPEC	
		WEIGHT -	SCALE 1:2	SHEET 4	OF 4
		Customer Accessible Production Drawing	REV A		

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION