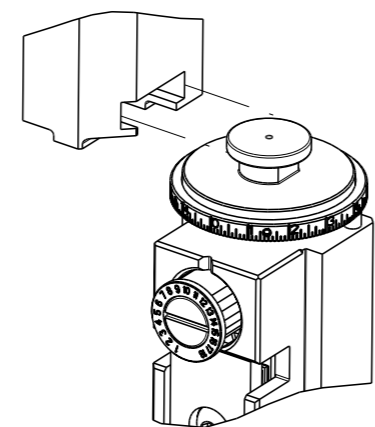


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
4150079-2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-4150079-2	A	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-4150079-7	A	CRIMP TOOLING KIT	-

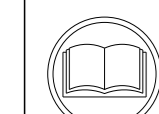
ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.79 mm [.110]	F
INSUL	3.56 mm [.140]	F
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: YAZAKI TERMINAL TE CRIMP SPECIFICATION			
TERMINAL NAME: 250 TERMINAL MALE			
WIRE STRIP LENGTH	TERMINAL INSULATION DIAMETER RANGE		
4.40-5.16 mm [.173-.203 IN]	∅ 2.11-3.10 mm [.083-.122 IN]		
TERMINAL APPLICATION SPECIFICATION	NONESPECIFICATION		
AT9106			
TERMINALS APPLIED			
TE TERMINAL	YAZAKI TERMINAL	TE TERMINAL	YAZAKI TERMINAL
286646-1	7114-2020	286646-2	7114-2020-02

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
14 AWG OR 2.00mm ²	1.80 +/- 0.05 [.071 +/- .002]	5.2
16 AWG OR 1.25mm ²	1.58 +/- 0.05 [.062 +/- .002]	7.3
18 AWG OR 0.85mm ²	1.46 +/- 0.05 [.057 +/- .002]	8.6



- △ RECOMMENDED SPARE PARTS.
- △ REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION & 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.
- △ TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- 6. 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.

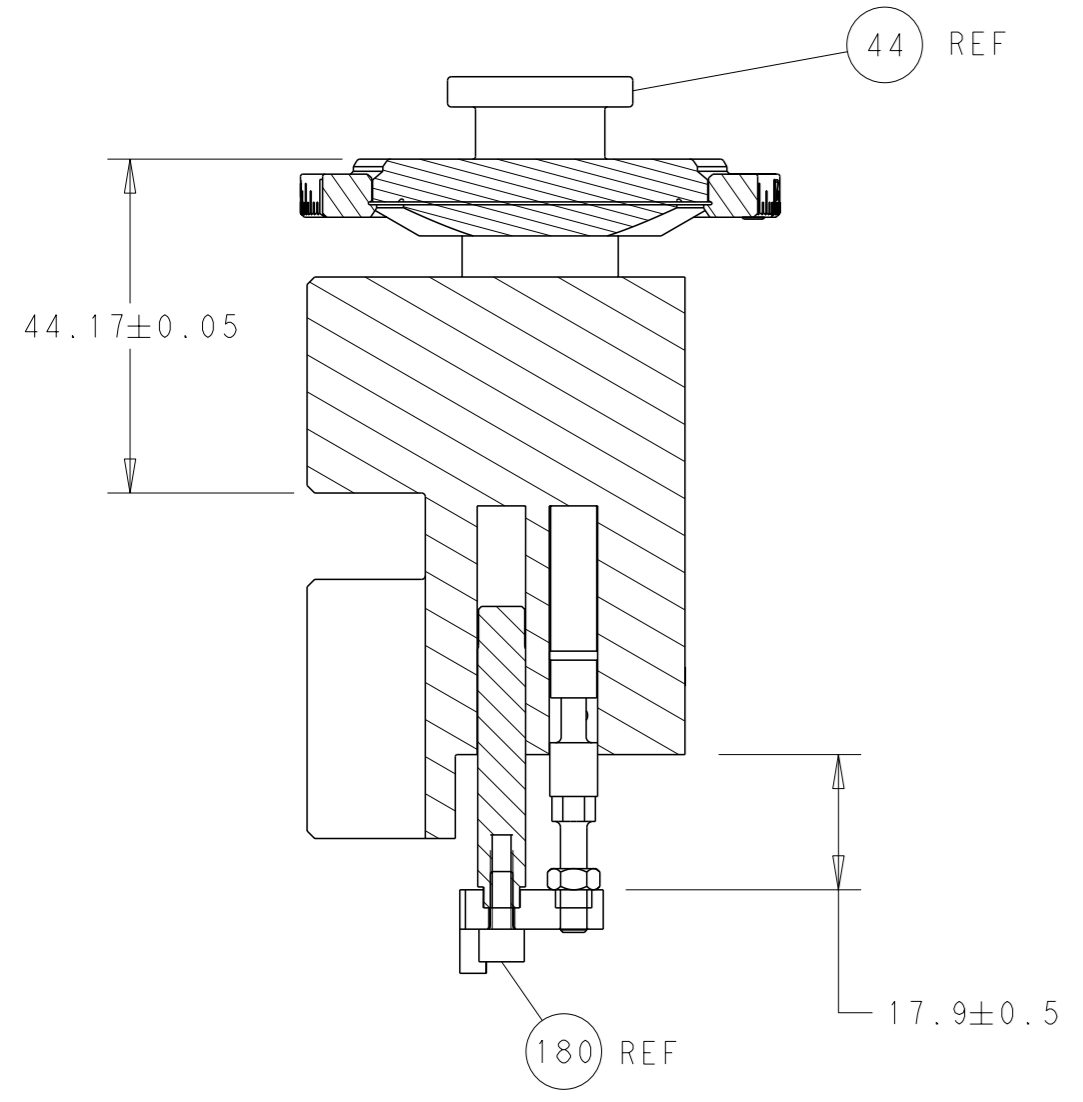
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

LOC	DIST	REVISIONS					
		#	LY#	DESCRIPTION	DATE	OWN	APVD
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		A		RELEASED	28OCT2020	MEH	RR

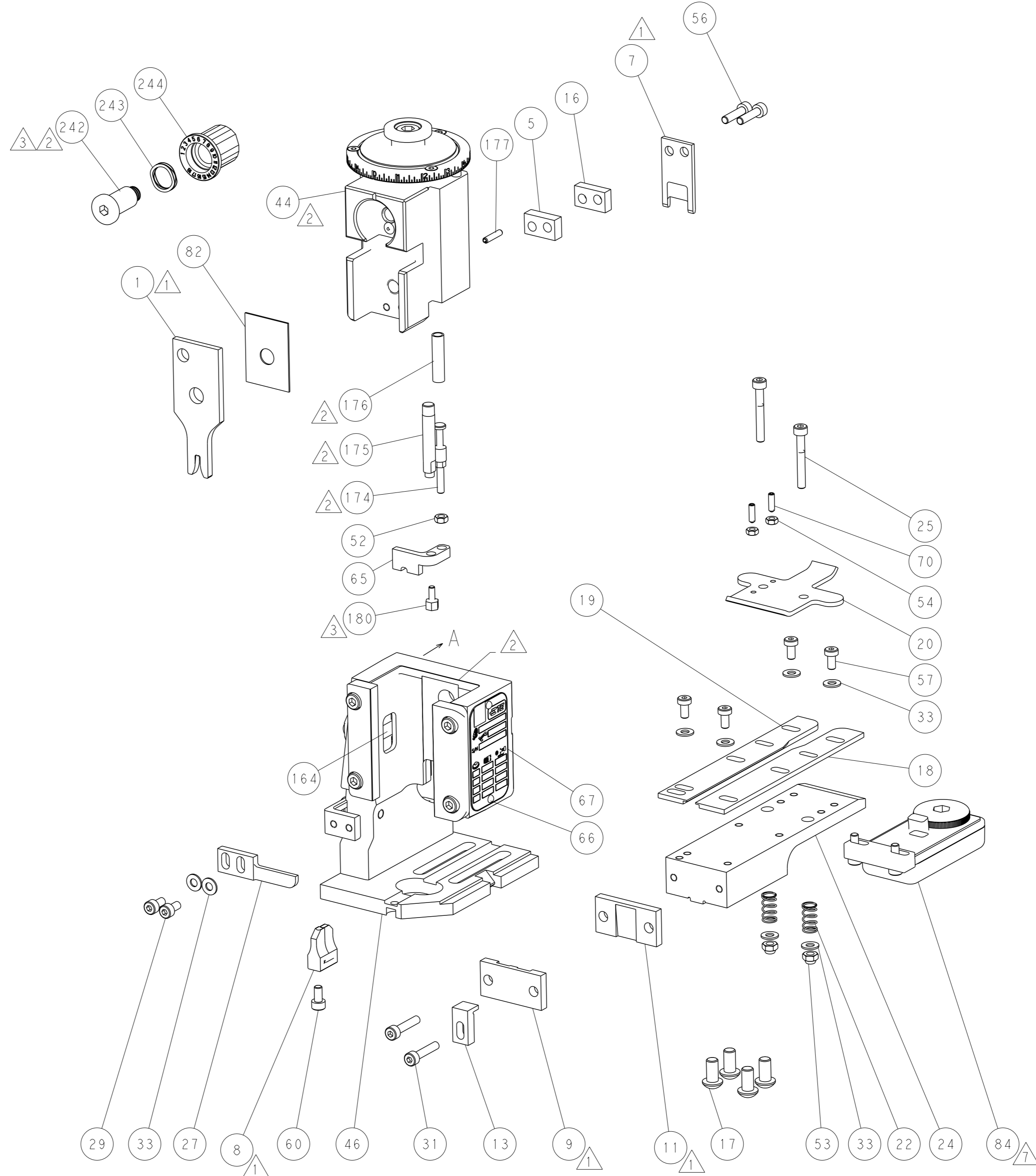
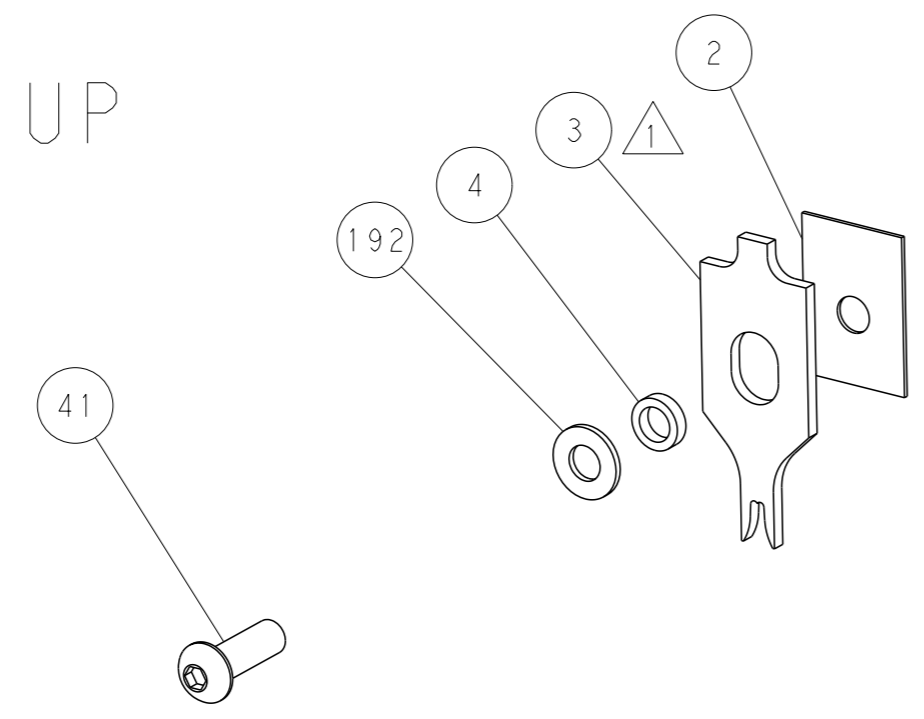
-	1	1	2119641-1	FEED CAM, AIR FEED	248	
-	1	1	2119082-3	CAM, SNAIL, INSULATION ADJUSTMENT	244	
-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243	
3	-	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	1	2844940-4	AIR FEED MODULE	238	
-	1	1	1-18028-0	WASHER, FLAT, REG M8	192	
3	-	1	1	1752354-2	STANDOFF, HOLD-DOWN	180
-	1	1	6-993111-6	PIN, SLOTTED SPRING 3.0 X 14.0	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	
7	-	1	1	2119955-2	ASSY, LUBRICATOR, END FEED	84
-	1	1	455888-6	SPACER, CRIMPER	82	
-	1	1	1803607-4	DOCUMENTATION PACKAGE	71	
-	2	2	2-18032-2	SCR, SET, FLT PNT, M3 X 10.0	70	
-	1	1	2119740-1	TAG, IDENTIFICATION	67	
-	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66	
-	1	1	3-1901681-3	HOLDDOWN, TERMINAL	65	
-	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	60	
-	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59	
-	4	4	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57	
-	2	2	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	56	
-	2	2	5018030-1	NUT, HEX, REG, RoHS, M3	54	
-	2	2	986965-8	NUT, LOCK, HEX, TORQUE (M4)	53	
-	1	1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52	
-	1	1	2063961-1	FEED FINGER	51	
-	1	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49	
-	1	1	2119655-5	APPLICATOR BASIC ASSEMBLY, EF	46	
-	1	1	1803517-1	RAM ASSEMBLY, EF ATLANTIC	44	
-	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41	
-	8	8	1-18028-2	WASHER, FLAT, REG M4	33	
-	2	2	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	31	
-	2	2	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	29	
-	1	1	240639-1	STRIPPER (MACHINING)	27	
-	2	2	1-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 30	25	
-	1	1	1752371-5	PLATE, STRIP GUIDE	24	
-	2	2	22281-8	SPRING, COMPRESSION	22	
-	1	1	1803292-4	DRAG	20	
-	1	1	1-1901696-8	STRIP GUIDE, REAR	19	
-	1	1	1-1901695-8	STRIP GUIDE, FRONT	18	
-	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17	
-	1	1	3-240641-5	SPACER	16	
-	1	1	1752360-1	SPACER, HOLD-DOWN	13	
-	1	1	240644-9	PLATE, REAR SHEAR	11	
-	-	-	-	-	10	
-	1	1	690482-4	PLATE, FRONT SHEAR	9	
1	2	1	3-1803426-9	ANVIL, COMBINATION, END FEED	8	
-	1	1	1-2217206-0	BLADE, SLUG	7	
-	-	-	-	-	6	
-	1	1	6-240641-5	SPACER	5	
-	1	1	238011-2	BLOCK, CRIMPER SPACER	4	
1	2	1	2-1633961-3	CRIMPER, INSULATION F PREMIUM	3	
-	1	1	455888-8	SPACER, CRIMPER	2	
1	2	1	2-456408-8	CRIMPER, WIRE PREMIUM	1	
-	77	72	2	PART NO	DESCRIPTION	ITEM NO

<small>THE DRAWING IS CONTROLLED BY THE REVISIONS CONTROL SYSTEM. ANY CHANGES TO THE DRAWING MUST BE MADE THROUGH THE REVISIONS CONTROL SYSTEM. THE LATEST REVISION SHALL BE CONTACTED FOR THE LATEST REVISION.</small>		OWN: M. HERR CHK: T. ELBIN APVD: B. BAIR PRODUCT SPEC: 15SEP2020	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 End Feed Applicator SIZE: A CAGE CODE: 00779 DRAWING NO: 4150079 WEIGHT: - SCALE: 1:1 SHEET: 1 of 4 REV: A	RESTRICTED TO: - Customer Accessible Production Drawing

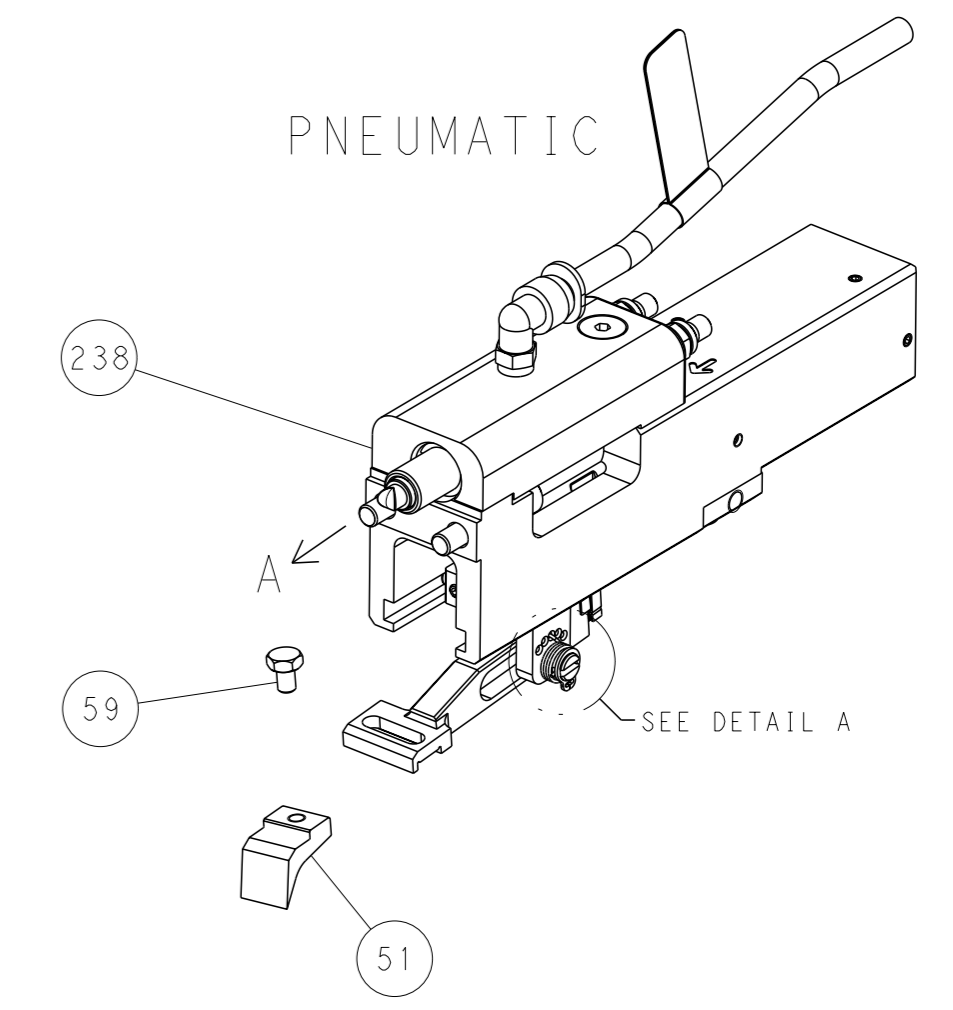
LOC	DIST	REVISIONS					
A	66	P	LYR	DESCRIPTION	DATE	OWN	APVD
		-		SEE SHEET 1			



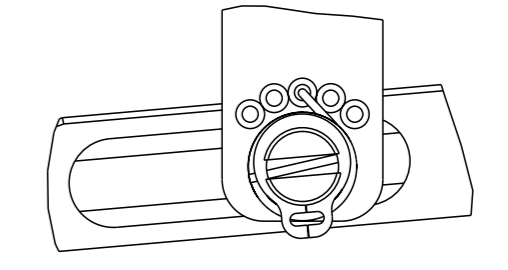
RAM AND HOLDDOWN SET-UP



FEED TYPE

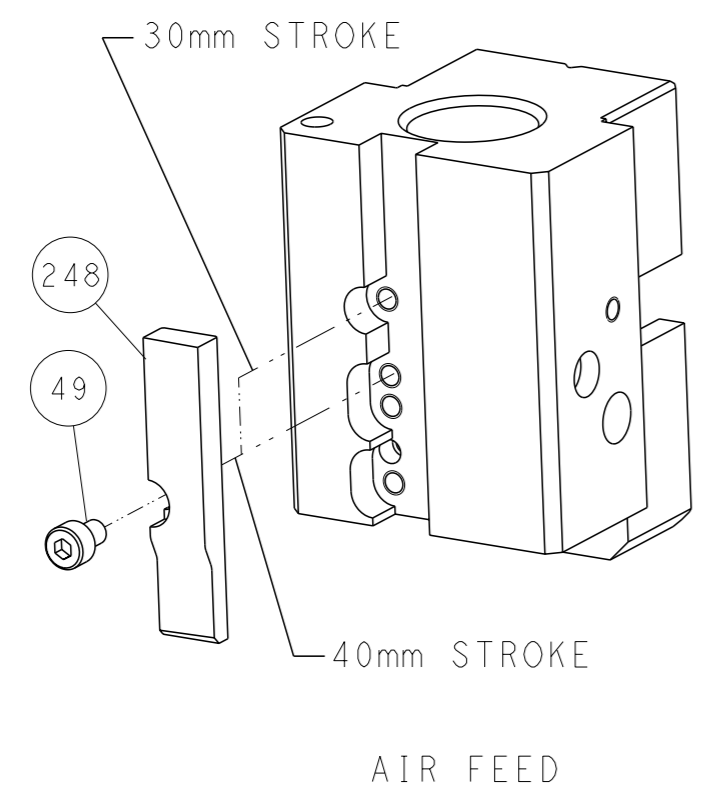


FEED SPRING SETTING POSITION



DETAIL A

CAM POSITION

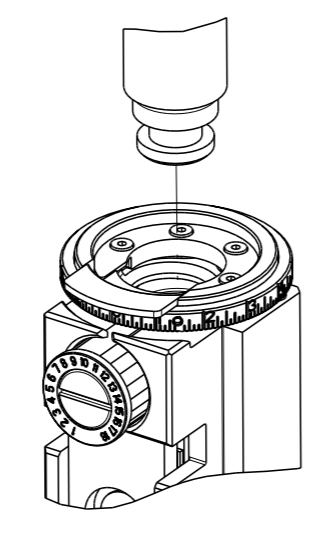


ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

<small>THIS DRAWING IS A CONTROLLED DOCUMENT FROM TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE AND THE CONTROL AND IDENTIFICATION DISPOSITION SHOULD BE CONTACTED FOR THE LATEST REVISION.</small>		OWN: M. HERR CHK: T. ELBIN APVD: B. BAIR PRODUCT SPEC: - APPLICATION SPEC: - WEIGHT: - MATERIAL: -	DATE: 15SEP2020 DATE: 15SEP2020 DATE: 15SEP2020 SCALE: 1:1 SHEET: 2 of 4 REV: A	STE TE Connectivity Harrisburg, PA 17105-3608 NAME: OCEAN 2.0 End Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: 4150079 RESTRICTED TO: -
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-4150079-2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-4150079-7	A	CRIMP TOOLING KIT	-

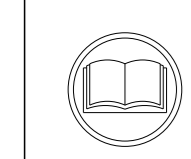
PACIFIC VERSION TERMINATOR
 INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.79 mm [.110]	F
INSUL	3.56 mm [.140]	F
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: YAZAKI TERMINAL TE CRIMP SPECIFICATION			
TERMINAL NAME: 250 TERMINAL MALE			
WIRE STRIP LENGTH 4.40-5.16 mm [.173-.203 IN]	TERMINAL INSULATION DIAMETER RANGE 2.11-3.10 mm [.083-.122 IN]		
TERMINAL APPLICATION SPECIFICATION NONE		AT9106	
TERMINALS APPLIED			
TE TERMINAL 286646-1	YAZAKI TERMINAL 7114-2020	TE TERMINAL 286646-2	YAZAKI TERMINAL 7114-2020-02

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
14 AWG OR 2.00mm2	1.80 +/- 0.05 [.071 +/- .002]	5.2
16 AWG OR 1.25mm2	1.58 +/- 0.05 [.062 +/- .002]	7.3
18 AWG OR 0.85mm2	1.46 +/- 0.05 [.057 +/- .002]	8.6



- △ RECOMMENDED SPARE PARTS.
- △ REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION & 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.
- △ TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- 6. 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.

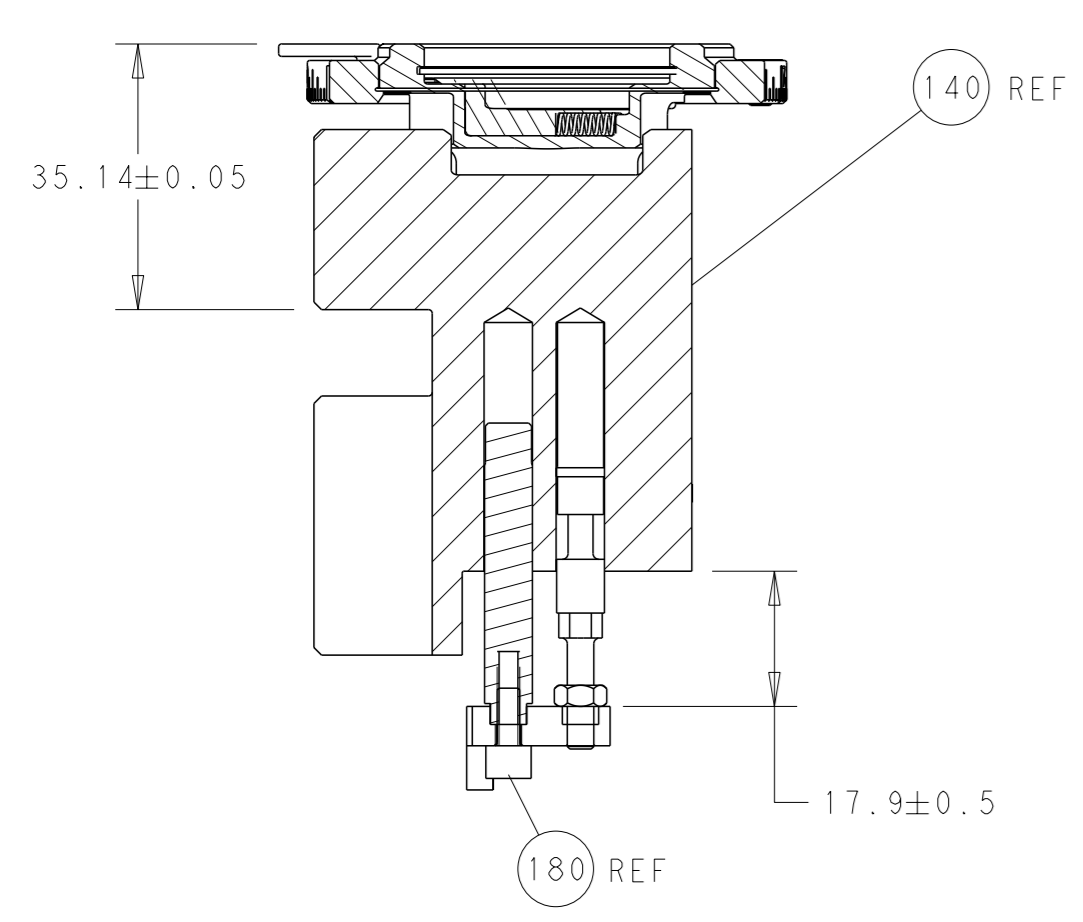
LOC	DIST	REVISIONS					
		P	LY#	DESCRIPTION	DATE	OWN	APVD
A	66	-	-	SEE SHEET 1	-	-	-

-	1	2119082-3	CAM, SNAIL, INSULATION ADJUSTMENT	244	
-	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243	
△	-	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	2844940-4	AIR FEED MODULE	238	
-	1	1-18028-0	WASHER, FLAT, REG M8	192	
-	4	2079383-9	SCR, BHSC, RoHS (M6 X 20)	186	
△	-	1	1752354-2	STANDOFF, HOLD-DOWN	180
-	1	6-993111-6	PIN, SLOTTED SPRING 3.0 X 14.0	177	
-	1	8-22280-7	SPRING, COMPRESSION	176	
-	1	1752353-2	GUIDE PIN, HOLDDOWN	175	
-	1	1901680-2	GUIDE PIN, HOLDDOWN	174	
-	REF	994970-2	COUNTER, MAGNETIC	164	
-	1	2119641-2	FEED CAM, AIR FEED	152	
-	1	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	144	
-	1	2119655-6	APPLICATOR BASIC ASSEMBLY, EF	141	
-	1	1803518-1	RAM ASSEMBLY, EF PACIFIC	140	
△	-	1	2119955-2	ASSY, LUBRICATOR, END FEED	84
-	1	455888-6	SPACER, CRIMPER	82	
-	1	1803607-4	DOCUMENTATION PACKAGE	71	
-	2	2-18032-2	SCR, SET, FLT PNT, M3 X 10.0	70	
-	1	2119740-1	TAG, IDENTIFICATION	67	
-	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66	
-	1	3-1901681-3	HOLDDOWN, TERMINAL	65	
-	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59	
-	4	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57	
-	2	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	56	
-	2	5018030-1	NUT, HEX, REG, RoHS, M3	54	
-	2	986965-8	NUT, LOCK, HEX, TORQUE (M4)	53	
-	1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52	
-	1	2063961-1	FEED FINGER	51	
-	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49	
-	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41	
-	8	1-18028-2	WASHER, FLAT, REG M4	33	
-	2	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	31	
-	2	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	29	
-	1	240639-1	STRIPPER (MACHINING)	27	
-	2	1-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 30	25	
-	1	1752371-5	PLATE, STRIP GUIDE	24	
-	2	22281-8	SPRING, COMPRESSION	22	
-	1	1803292-4	DRAG	20	
-	1	1-1901696-8	STRIP GUIDE, REAR	19	
-	1	1-1901695-8	STRIP GUIDE, FRONT	18	
-	1	3-240641-5	SPACER	16	
-	1	1752360-1	SPACER, HOLD-DOWN	13	
△	-	1	240644-9	PLATE, REAR SHEAR	11
-	-	-	-	10	
-	1	690482-4	PLATE, FRONT SHEAR	9	
△	1	1	3-1803426-9	ANVIL, COMBINATION, END FEED	8
△	-	1	1-2217206-0	BLADE, SLUG	7
-	-	-	-	6	
-	1	6-240641-5	SPACER	5	
-	1	238011-2	BLOCK, CRIMPER SPACER	4	
△	1	1	2-1633961-3	CRIMPER, INSULATION F PREMIUM	3
-	1	455888-8	SPACER, CRIMPER	2	
△	1	1	2-456408-8	CRIMPER, WIRE PREMIUM	1
-	77	22	PART NO	DESCRIPTION	ITEM NO

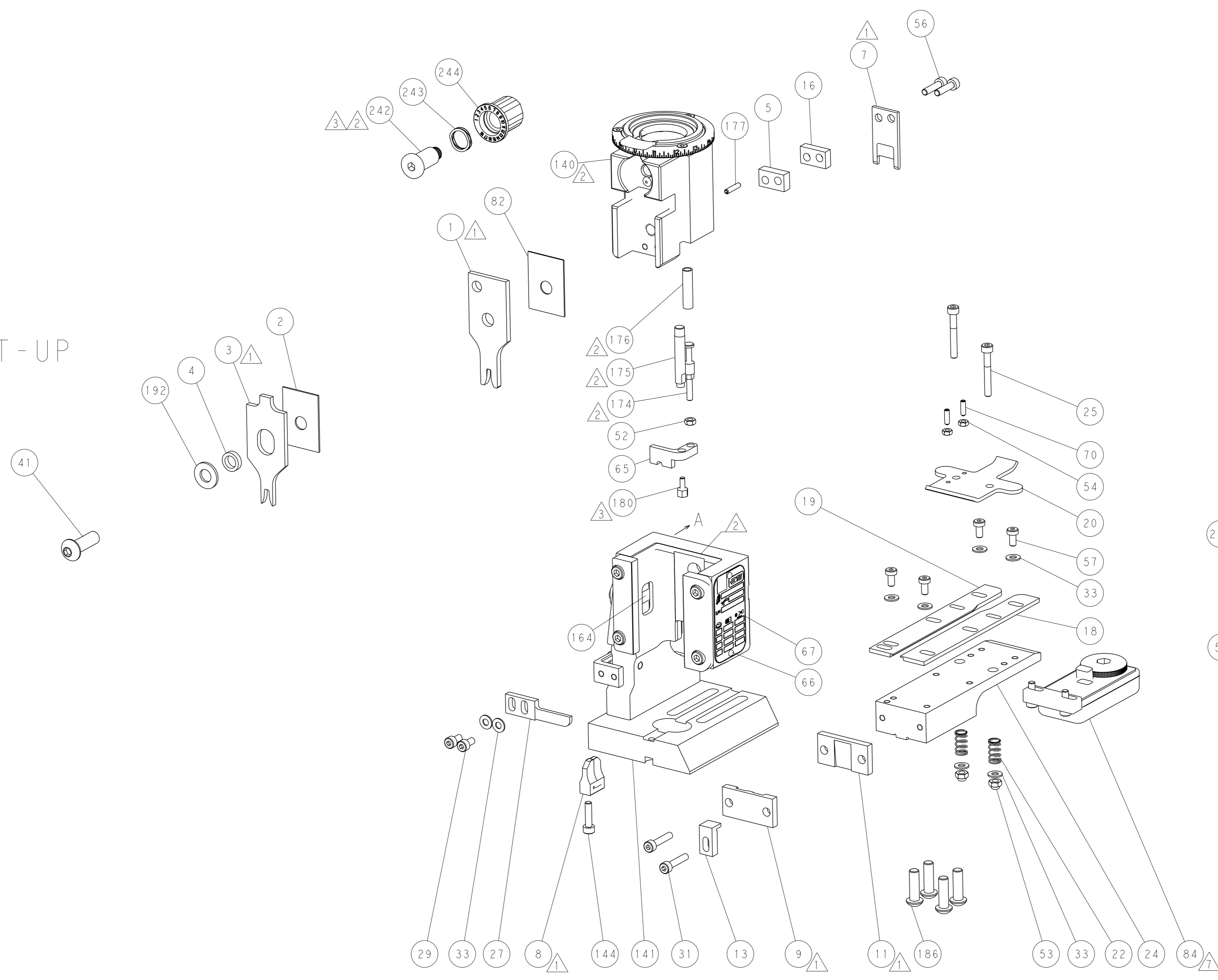
PACIFIC VERSION
 Shown on sheets 3 of 4 & 4 of 4
 (Atlantic version shown on sheets 1 of 4 & 2 of 4)

DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH ±		OWN M_HERR 15SEP2020 CHK T_ELBIN 15SEP2020 APVD B_BAIR 15SEP2020 PRODUCT SPEC APPLICATION SPEC		NAME OCEAN 2.0 End Feed Applicator	
MATERIAL:		WEIGHT:		SIZE: A1 CAGE CODE: 00779 DRAWING NO: 4150079		RESTRICTED TO:	
Customer Accessible Production Drawing				SCALE: 1:1		SHEET 3 of 4 REV A	

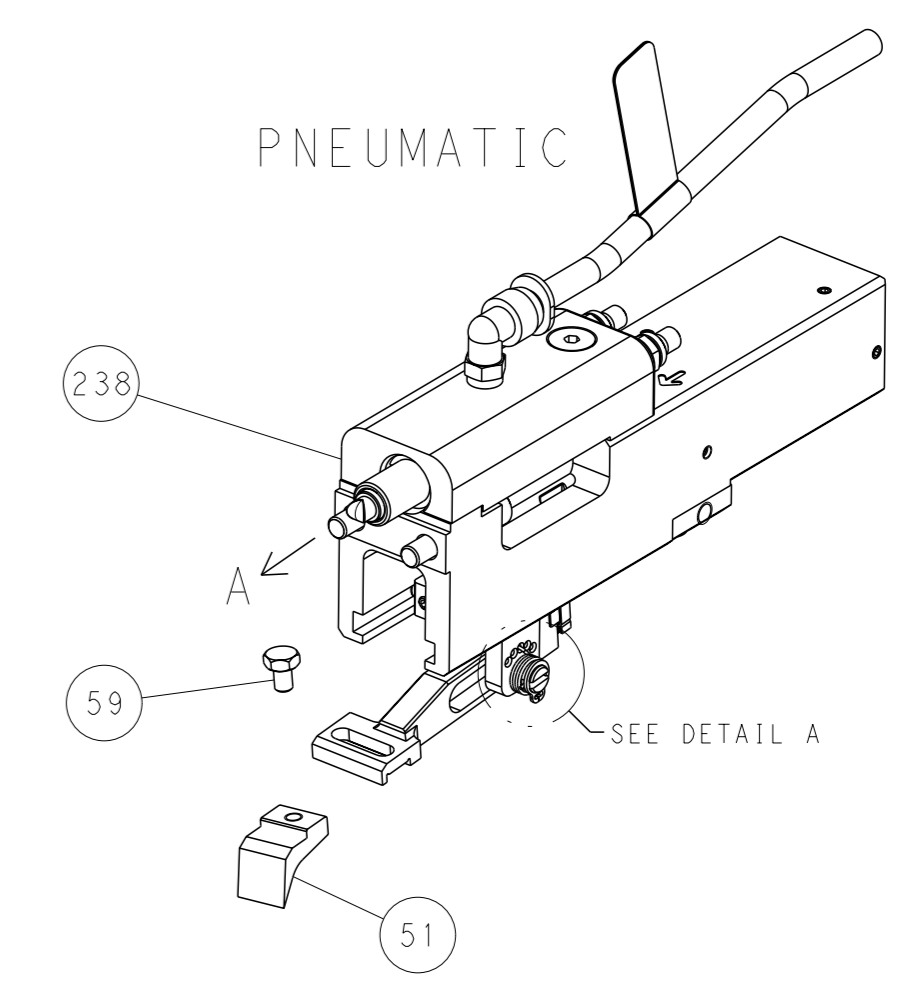
LOC	DIST	REVISIONS			
A	66	REV	DATE	OWN	APVD
		-	SEE SHEET 1	-	-



RAM AND HOLDDOWN SET-UP

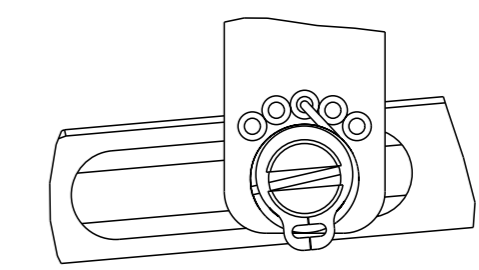


FEED TYPE



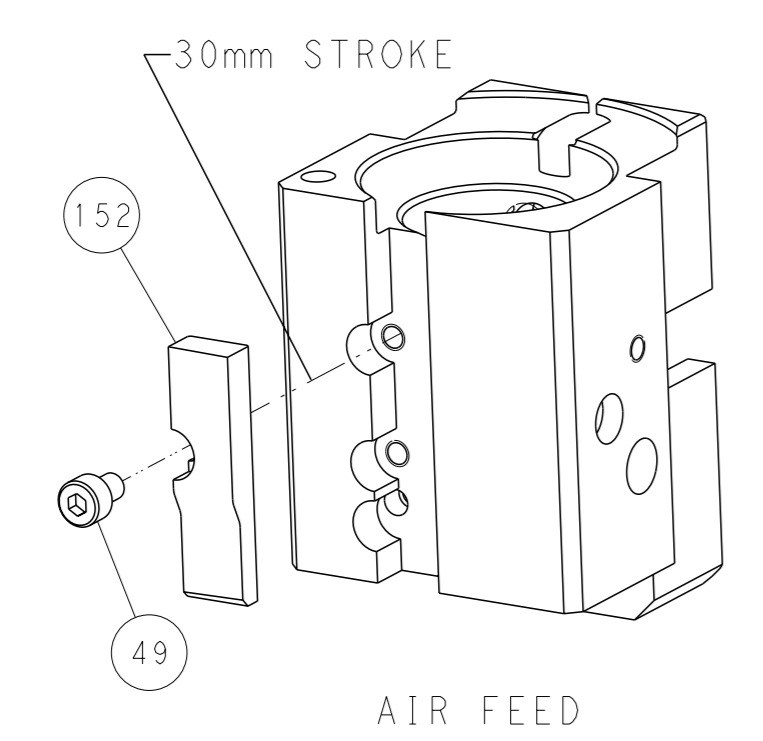
PNEUMATIC

FEED SPRING SETTING POSITION



DETAIL A

CAM POSITION



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 FROM TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE AND THE CONTROLLER'S ENGINEERING DEPARTMENT SHOULD BE CONTACTED FOR THE LATEST REVISION.</small>		OWN: M. HERR CHK: T. ELBIN APVD: B. BAIR PRODUCT SPEC:	DATE: 15SEP2020 DATE: 15SEP2020 DATE: 15SEP2020	NAME: OCEAN 2.0 End Feed Applicator	SIZE: A1 CAGE CODE: 00779 DRAWING NO: 4150079	RESTRICTED TO:
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH *	MATERIAL:	WEIGHT:	SCALE: 1:1	SHEET: 4 of 4	REV: A	CUSTOMER ACCESSIBLE PRODUCTION DRAWING