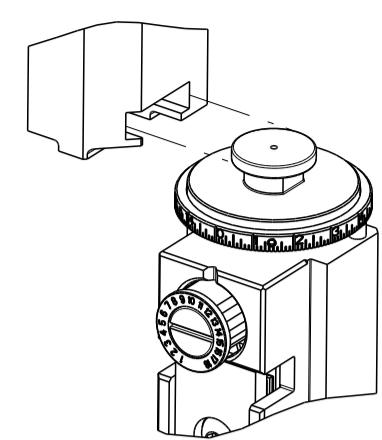


ATLANTIC VERSION TERMINATOR
INTERFACE ADAPTER



PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
4151250-1	A	FINE CRIMP HEIGHT ADJUST	MECHANICAL
4151250-2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-4151250-1	A	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-4151250-2	A	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-4151250-7	A	CRIMP TOOLING KIT	-

APPLICATOR DATA

CRIMP	SIZE	TYPE
WIRE	1.02 mm [.040]	F
INSUL	1.27 mm [.050]	O

APPLICATOR INSTRUCTIONS

408-35042

TERMINAL DATA: MOLEX TERMINAL MOLEX CRIMP SPECIFICATION

TERMINAL NAME: CTX50 UNSEALED BLADE TERMINAL

WIRE STRIP LENGTH TERMINAL INSULATION DIAMETER RANGE
3.50-3.50 mm [.138-.138 IN] Ø1.20-1.40 mm [.047-.055 IN]

TERMINAL 2043710001-AS Rev A10

APPLICATION SPECIFICATION - - AT9106

TERMINALS APPLIED

TE TERMINAL	MOLEX TERMINAL	TE TERMINAL	MOLEX TERMINAL
3311942-1	2043714329		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.35mm ²	0.72+/-0.02 [.028+/-0.001]	4.7



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 TERMINAL LUBRICANT IS RECOMMENDED.

6. 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.

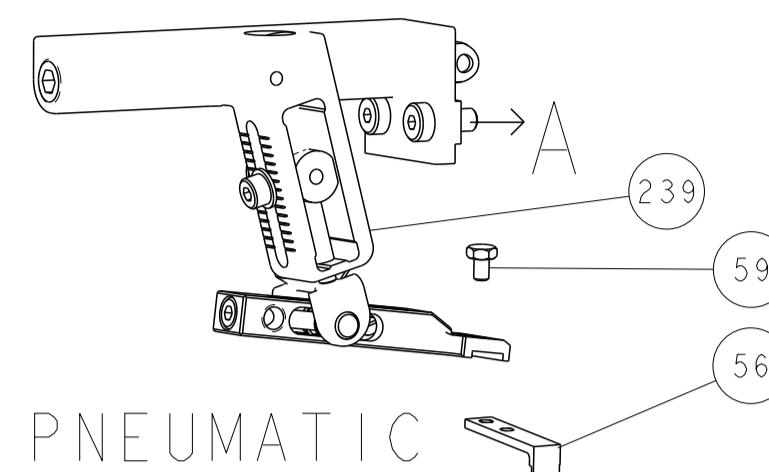
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

LOC	DIST	REVISIONS			
		P	LTR	DESCRIPTION	DATE
A	66	1		PRELIMINARY	25OCT2022 JWC TE
		A		RELEASED FOR PRODUCTION	07DEC2022 JWC JH

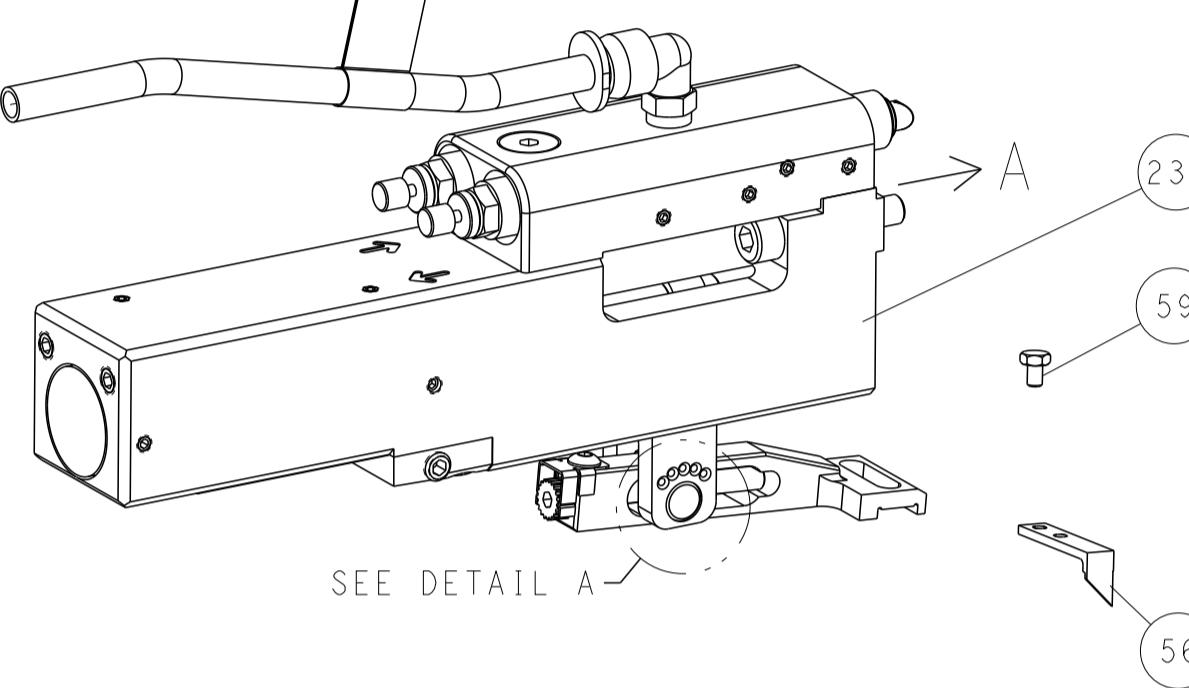
3	-	1	1	1	1	1803945-4	TONKER	1300
	-	1	1	1	1	22278-9	SPRING, COMPRESSION	1299
5	-	2	2	2	2	4-18032-3	SCR, SET, FLT PNT, M3 X 6.0	1298
	-	1	1	1	1	1803944-1	SPACER, TONKER	297
6	-	1	1	1	1	2119641-1	FEED CAM, AIR FEED	248
	-	1	1	1	1	2119082-3	CAM, SNAIL, INSULATION ADJUSTMENT	244
7	-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
	-	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
8	-	1	1	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
	-	1	1	1	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
9	-	1	1	1	1	2844940-1	AIR FEED MODULE	238
	-	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
10	-	1	1	1	1	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113
	-	1	1	1	1	2844908-1	SCREW, LOCKING	99
11	-	1	1	1	1	2844907-1	POST, LOCKING	98
	-	1	1	1	1	455888-5	SPACER, CRIMPER	82
12	-	1	1	1	1	1803607-3	DOCUMENTATION PACKAGE	71
	-	1	1	1	1	2119791-5	DEPRESSOR, WIRE	70
13	-	1	1	1	1	2119943-1	WASHER, SPACER	69
	-	1	1	1	1	2119740-1	TAG, IDENTIFICATION	67
14	-	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
15	-	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
16	-	4	4	4	4	2168083-6	SCR, SKT HD CAP, RoHS, M4 X 12.0	54
	-	2	2	2	2	2-2168083-6	SCR, SKT HD CAP, RoHS, M4 X 18	53
17	-	1	2	1	2	18023-9	SCR, SKT HD CAP M4 X 6.0	49
	-	1	1	1	1	2119652-1	FEED CAM, PRE FEED	48
18	-	1	1	1	1	2119653-1	FEED CAM, POST FEED	47
	-	1	1	1	1	1803583-9	APPLICATOR BASIC ASSEMBLY, SF	46
19	-	1	1	1	1	1803515-1	RAM ASSEMBLY, SF ATLANTIC	44
	-	1	1	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
20	-	1	1	1	1	1-1752356-9	SUPPORT, TERMINAL	34
	-	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
21	-	2	2	2	2	2-2844962-4	SPACER, CYLINDRICAL, STRIP GUIDE	30
	-	1	1	1	1	2844992-2	ASSEMBLY, STRIP GUIDE	29
22	-	1	1	1	1	455888-5	SPACER, CRIMPER	28
	-	1	1	1	1	1320928-6	STRIP GUIDE	24
23	-	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
24	-	1	1	1	1	2119533-1	STRIPPER, SIDE FEED	19
	-	1	1	1	1	2119806-1	INSERT, SHEAR	13
25	-	1	1	1	1	3-22280-3	SPRING, COMPRESSION	12
	-	1	1	1	1	1-356885-4	STOP, SHEAR	11
26	-	1	1	1	1	2119805-1	SHEAR HOLDER, FRONT	10
	-	1	2	2	1	1803095-6	FLOATING SHEAR, FRONT	9
27	-	1	2	2	1	2392009-3	ANVIL, COMBINATION	8
	-	1	1	1	1	3-240641-5	SPACER	7
28	-	1	1	1	1	2119757-4	DEPRESSOR, SHEAR	5
	-	1	1	1	1	238011-8	BLOCK, CRIMPER SPACER	4
29	-	1	1	1	1	1803858-8	CRIMPER, INSULATION O	3
	-	1	1	1	1	455888-4	SPACER, CRIMPER	2
30	-	1	2	2	1	9-1633713-0	CRIMPER, WIRE PREMIUM	1
	-	77	72	71	-2	-1	PART NO	ITEM NO
31	-	1	1	1	1	1	DESCRIPTION	ITEM NO
	-	1	1	1	1	1		

LOC		DIST		REVISIONS			
P	LTR	-	SEE SHEET 1	DESCRIPTION	DATE	DNW	APV0

FEED TYPE MECHANICAL

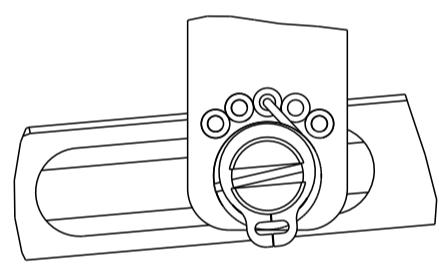


PNEUMATIC

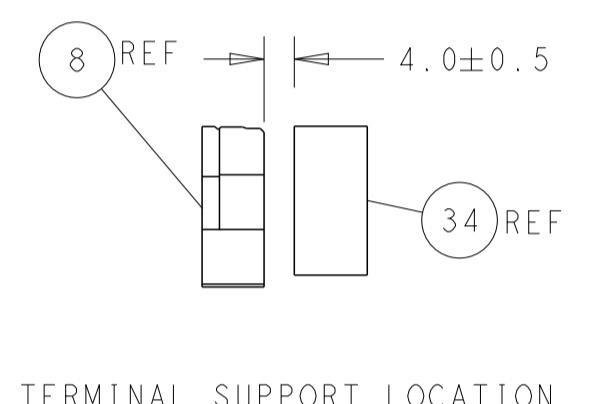
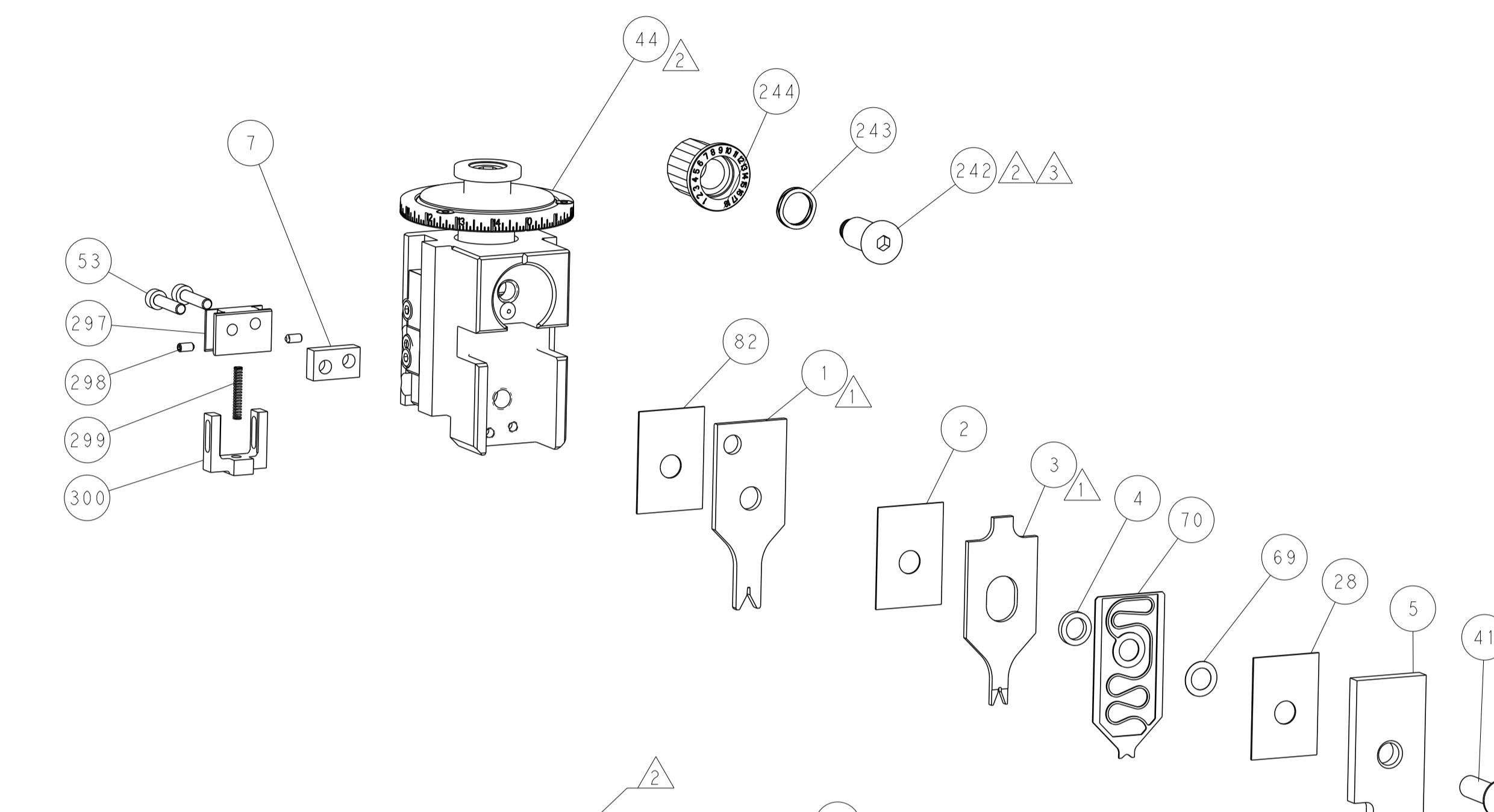


SEE DETAIL A

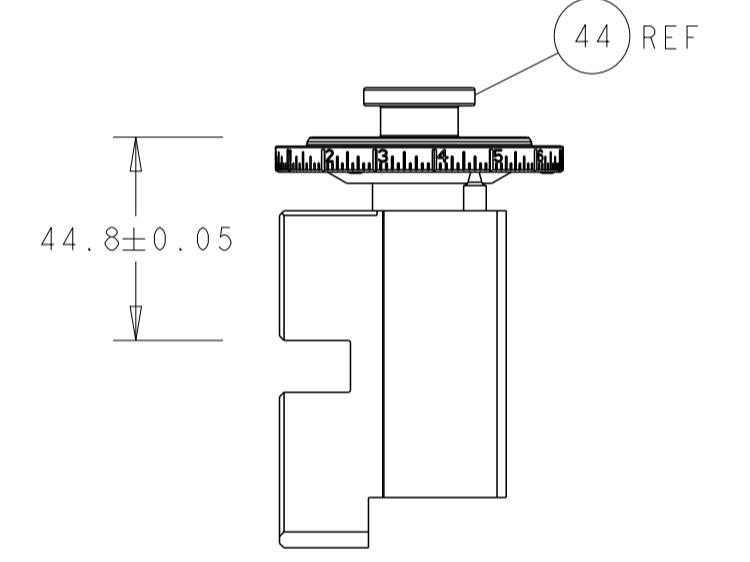
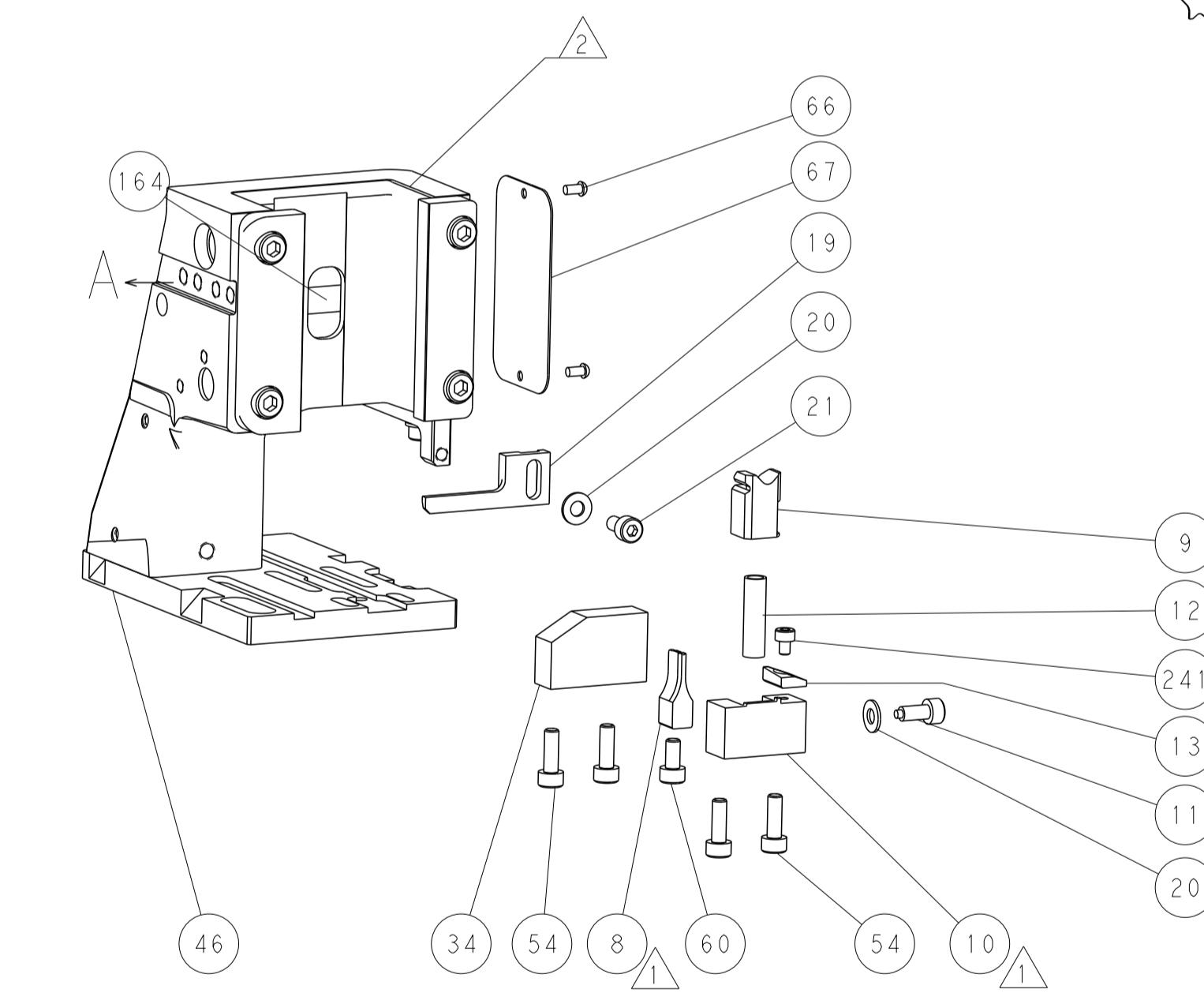
FEED SPRING SETTING POSITION
(SHOWN FROM REAR SIDE)



DETAIL A

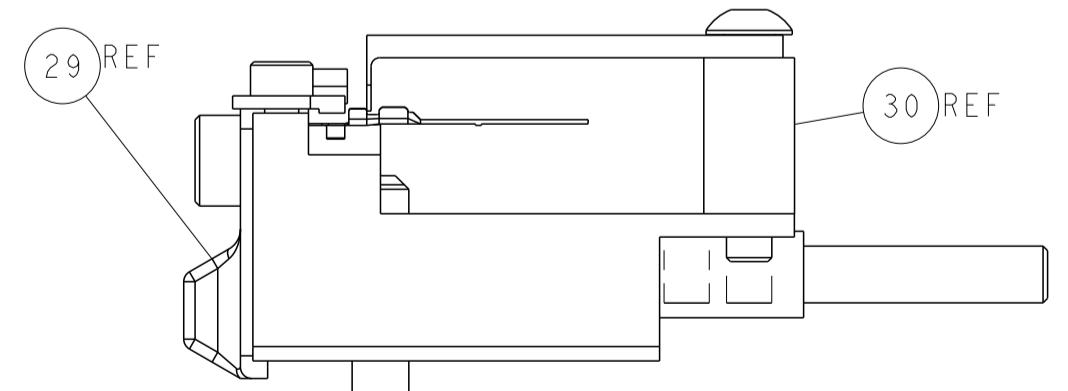


TERMINAL SUPPORT LOCATION



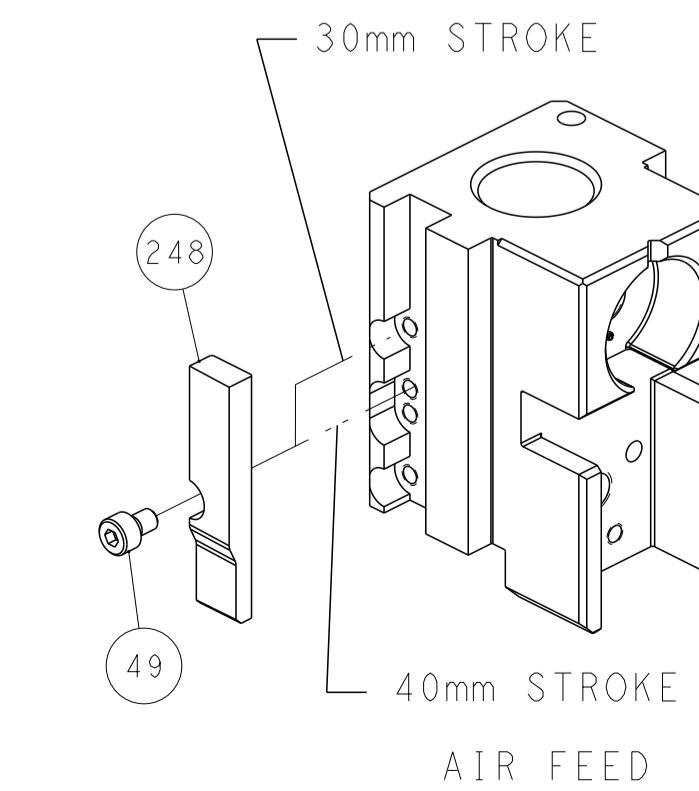
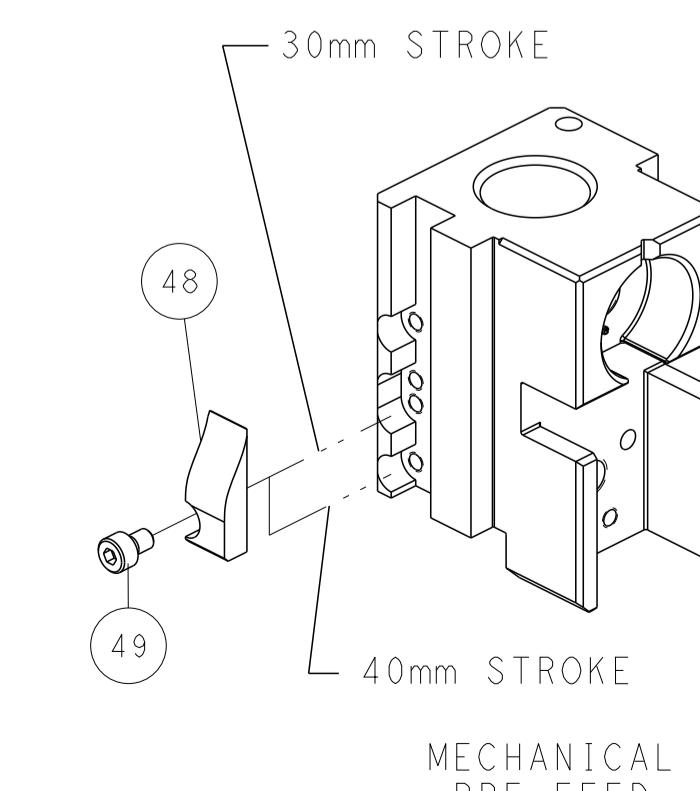
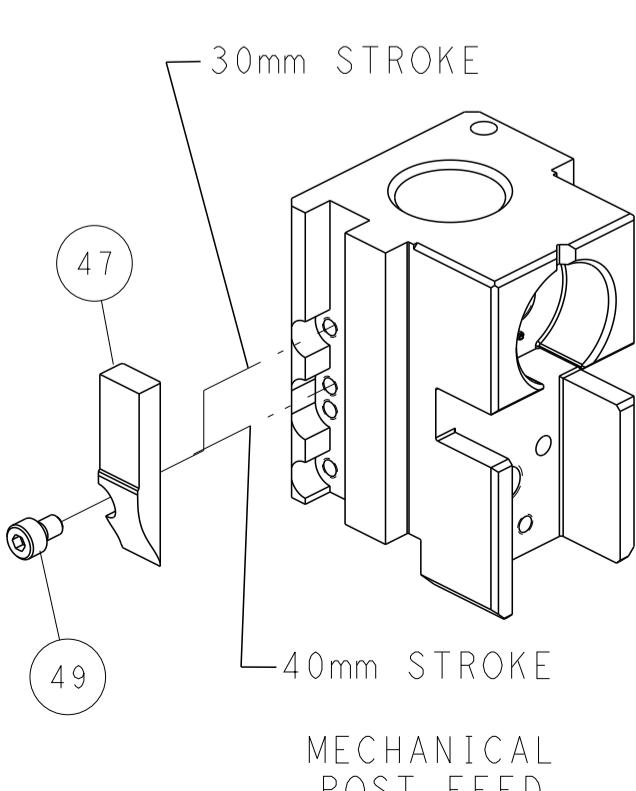
RAM SET-UP

ITEM 30 LOCATED AT
REAR HOLES



FEED TRACK POSITION
GUIDE BY INSULATION BARREL

CAM POSITIONS

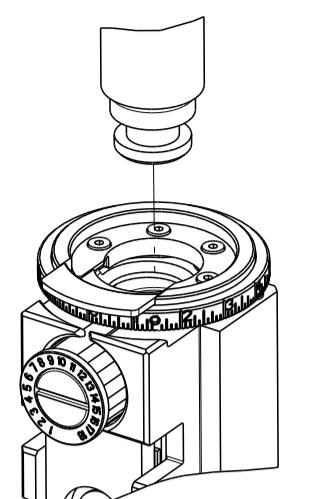


ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		APV0		NAME	
mm	in	0 PLC	1 PLC	2 PLC	3 PLC	4 PLC	TE Connectivity
		±0.05	±0.05	±0.05	±0.05	±0.05	CH-BROOKENS 25OCT2022
							T.ELBIN 25OCT2022
							PRODUCT SPEC
							APPLICATION SPEC
							WEIGHT
							SIZE
							CAGE CODE
							DRAWING NO.
							Customer Accessible Production Drawing
							REV A

SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION 20			
© COPYRIGHT 20 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.			
PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-4151250-1	A	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-4151250-2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-4151250-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER

APPLICATOR DATA

CRIMP	SIZE	TYPE
WIRE	1.02 mm [.040]	F
INSUL	1.27 mm [.050]	O

APPLICATOR INSTRUCTIONS
408-35042

TERMINAL DATA: MOLEX TERMINAL MOLEX CRIMP SPECIFICATION

TERMINAL NAME: CTX50 UNSEALED BLADE TERMINAL

WIRE STRIP LENGTH TERMINAL INSULATION DIAMETER RANGE
3.50-3.50 mm [.138-.138 IN] Ø1.20-1.40 mm [.047-.055 IN]

TERMINAL 2043710001-AS Rev A10

APPLICATION

SPECIFICATION - - -

AT9106

TERMINALS APPLIED

TE TERMINAL	MOLEX TERMINAL	TE TERMINAL	MOLEX TERMINAL
3311942-1	2043714329		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.35mm ²	0.72+/-0.02 [.028+/-0.001]	4.7



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 TERMINAL LUBRICANT IS RECOMMENDED.

6. 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)

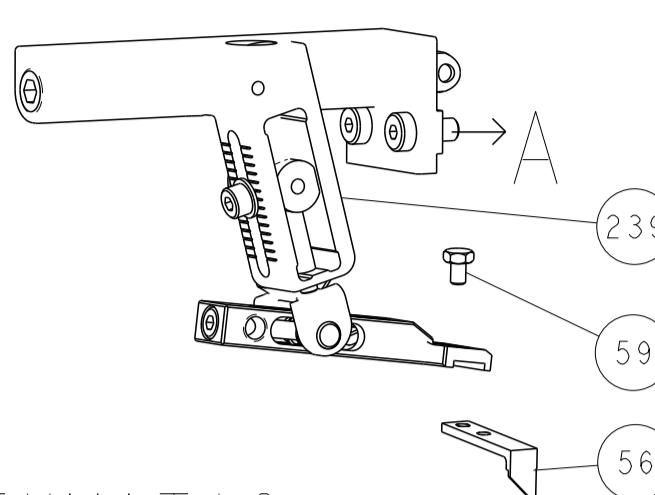
LOC	DIST	REVISIONS			
		P	LTR	DESCRIPTION	DATE
A	66	-	-	SEE SHEET 1	- - -

-	1	1	1803945-4	TONKER	1300
-	1	1	22278-9	SPRING, COMPRESSION	1299
-	2	2	4-18032-3	SCR, SET, FLT PNT, M3 X 6.0	1298
-	1	1	1803944-1	SPACER, TONKER	1297
-	1	1	2119082-3	CAM, SNAIL, INSULATION ADJUSTMENT	1244
-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	1243
-	1	1	2119083-1	RETAINER, INSULATION DIAL	1242
-	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	1241
-	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	1239
-	-	1	2844940-1	AIR FEED MODULE	1238
-	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	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113
-	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	2119791-5	DEPRESSOR, WIRE	70
-	1	1	2119943-1	WASHER, SPACER	69
-	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	2-2168083-6	SCR, SKT HD CAP, RoHS, M4 X 18	53
-	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	1-1752356-9	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	2844992-2	ASSEMBLY, STRIP GUIDE	29
-	1	1	455888-5	SPACER, CRIMPER	28
-	1	1	1320928-6	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	2392009-3	ANVIL, COMBINATION	8
-	1	1	3-240641-5	SPACER	7
-	-	-	-	-	6
-	1	1	2119757-4	DEPRESSOR, SHEAR	5
-	1	1	238011-8	BLOCK, CRIMPER SPACER	4
-	1	1	1803858-8	CRIMPER, INSULATION O	3
-	1	1	455888-4	SPACER, CRIMPER	2
-	1	1	9-1633713-0	CRIMPER, WIRE PREMIUM	1

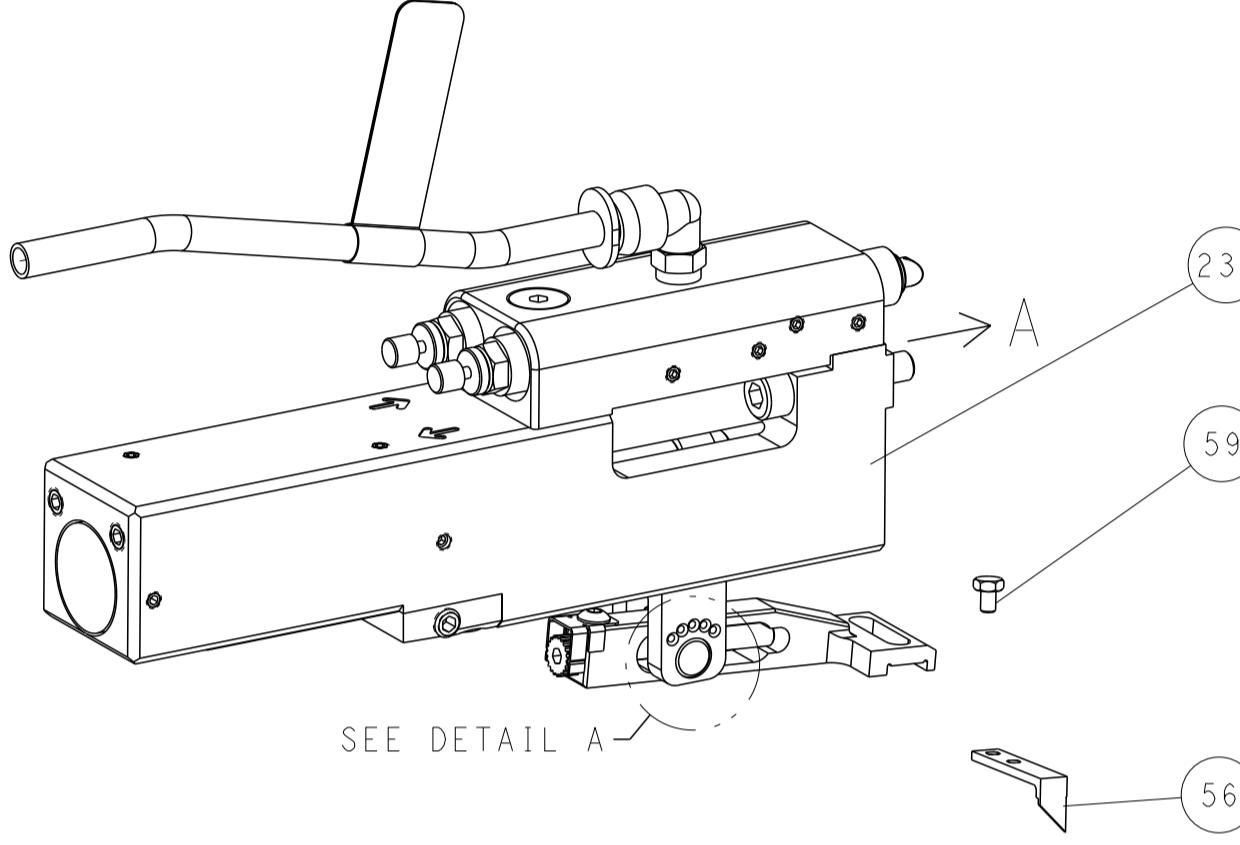
PART NO		DESCRIPTION	ITEM NO
-77	-22	-21	PART NO
			DESCRIPTION
			ITEM NO
THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION. IT IS THE PROPERTY OF TYCO ELECTRONICS CORPORATION AND SHOULD BE CONTACTED FOR THE LATEST REVISION.		DNW J.CALIMER 250CT2022	
		CHM T.BROOKENS 250CT2022	
		NAME OCEAN 2.0 Side Feed Applicator	
DIMENSIONS: mm		APPLICATION SPEC	
0 PLC ±.000			
1 PLC ±.000			
2 PLC ±.000			
3 PLC ±.000			
4 PLC ±.000			
FINISH			
ANGLES			
MATERIAL			
WEIGHT			
CAGE CODE		DRAWING NO	RESTRICTED TO
A1 00779		©-4151250	
Customer Accessible Production Drawing		SCALE 1:2	SHEET 3 OF 4 REV A

LOC		DIST		REVISIONS			
P	LTR	-	SEE SHEET 1	DESCRIPTION	DATE	DNW	APV0

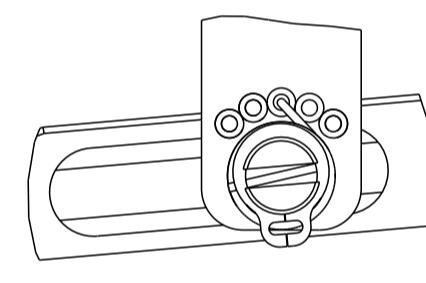
FEED TYPE MECHANICAL



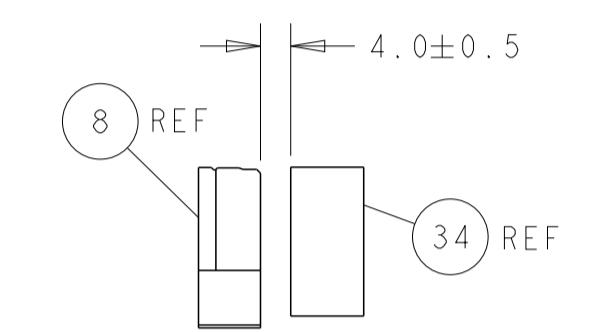
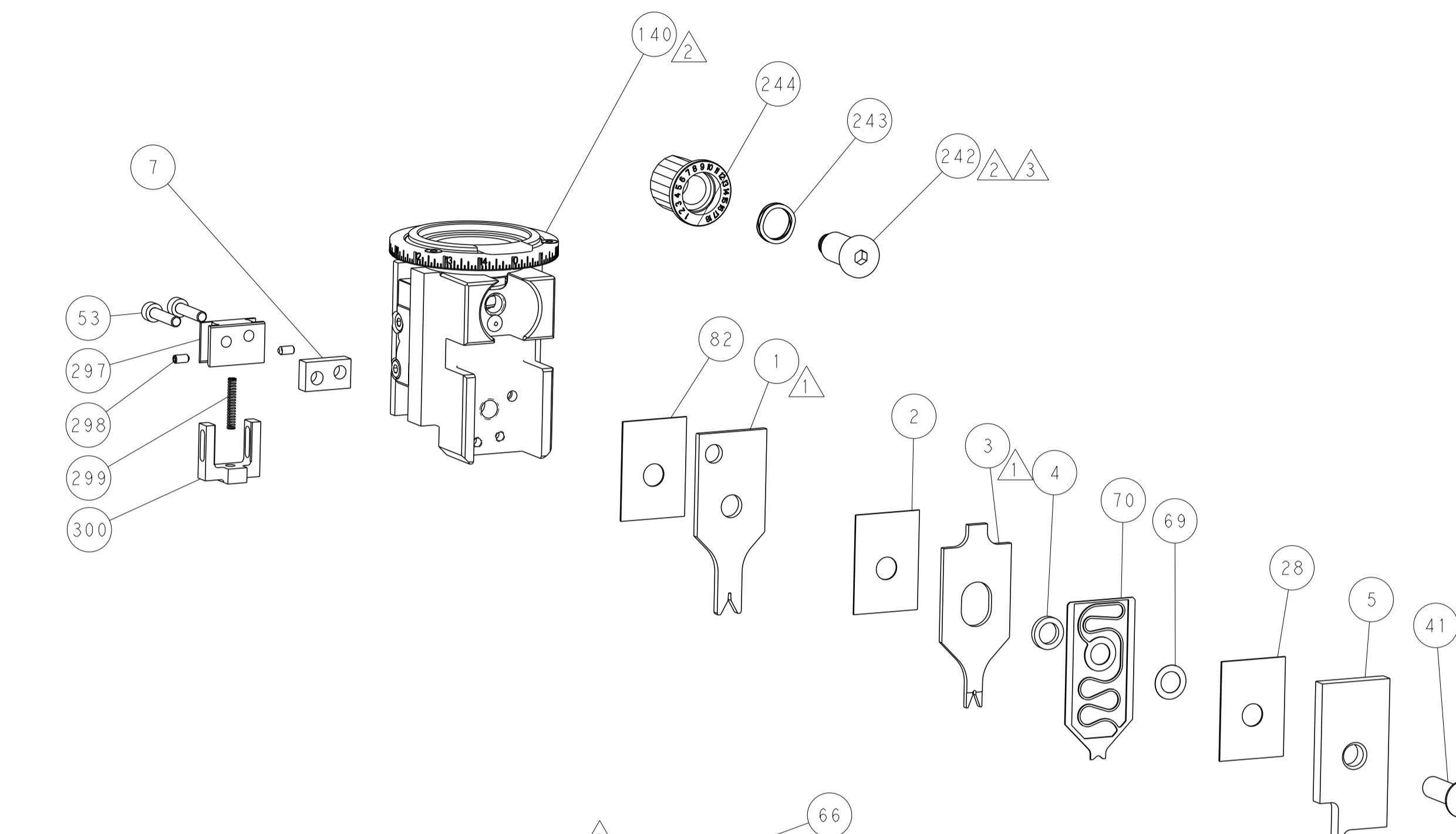
PNEUMATIC



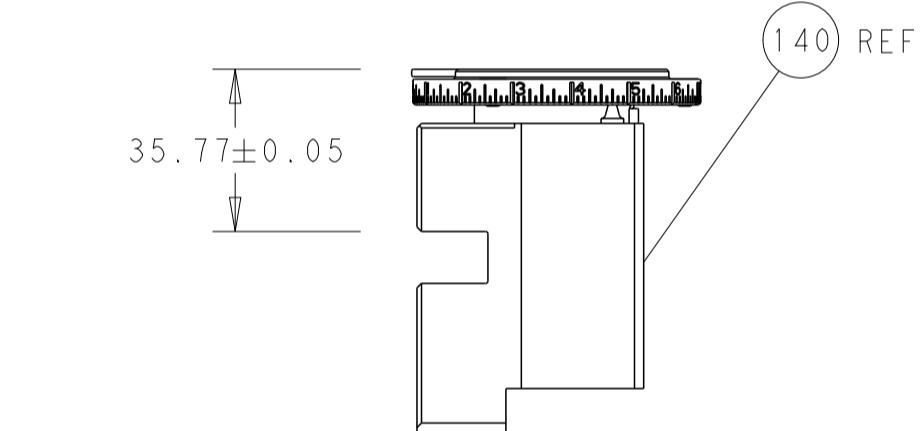
FEED SPRING SETTING POSITION
(SHOWN FROM REAR SIDE)



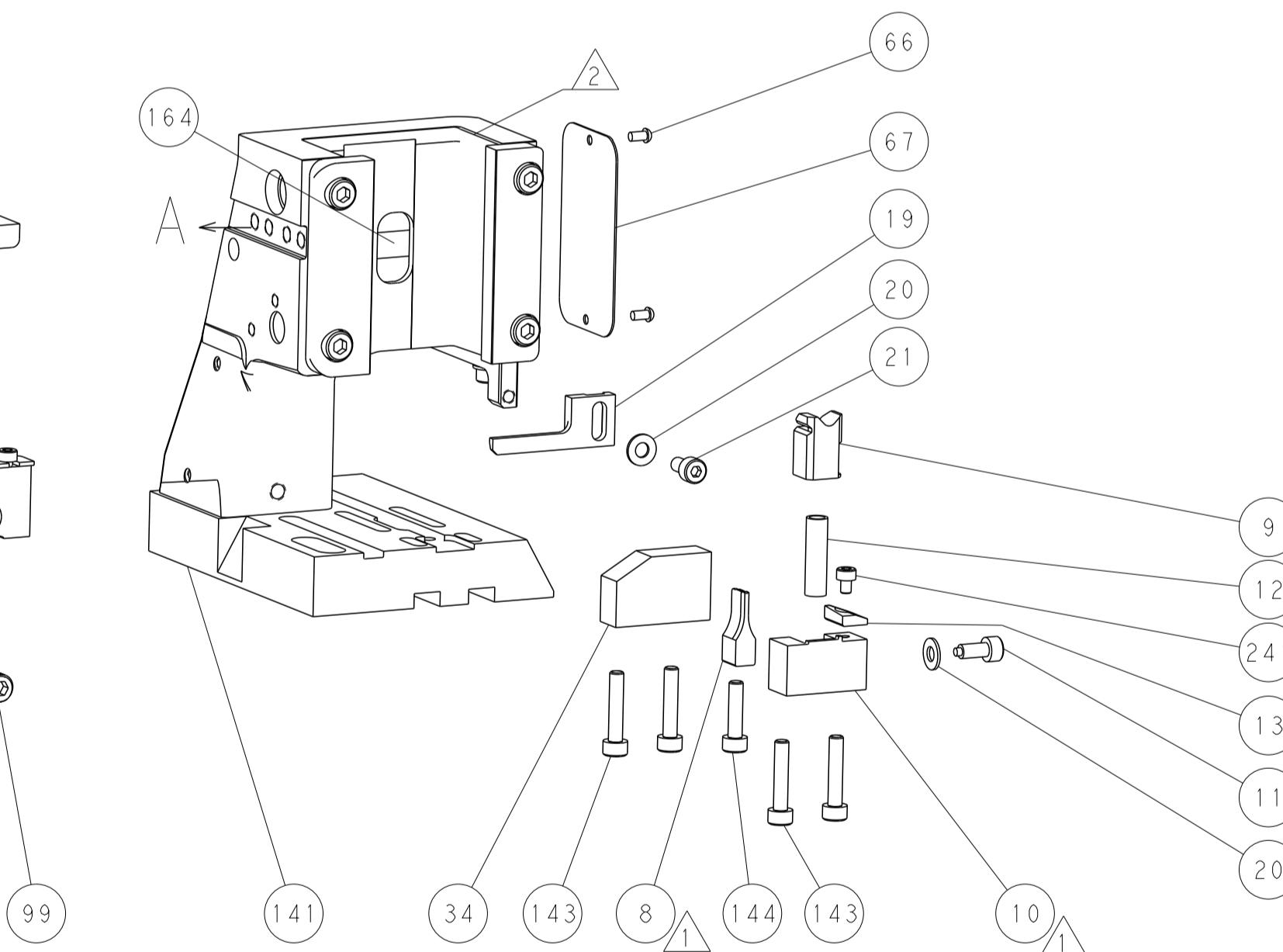
DETAIL A



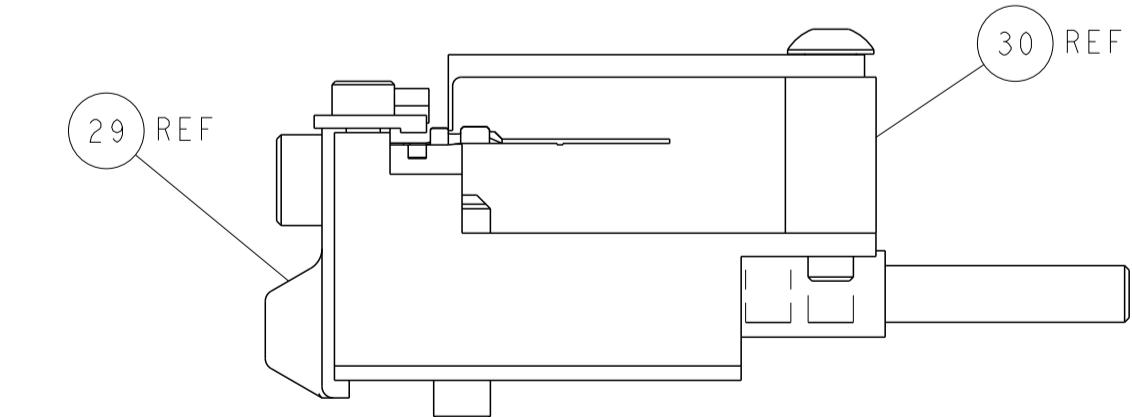
TERMINAL SUPPORT LOCATION



RAM SET-UP

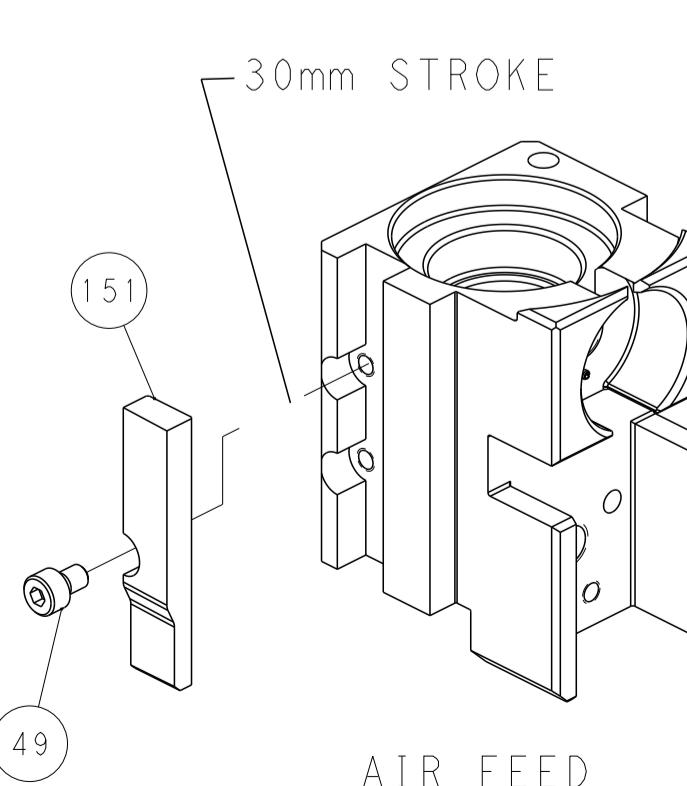
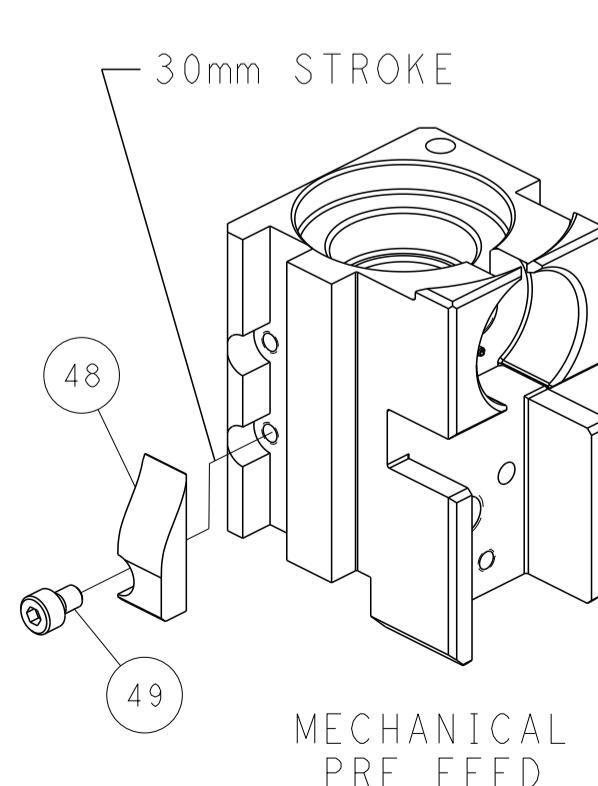
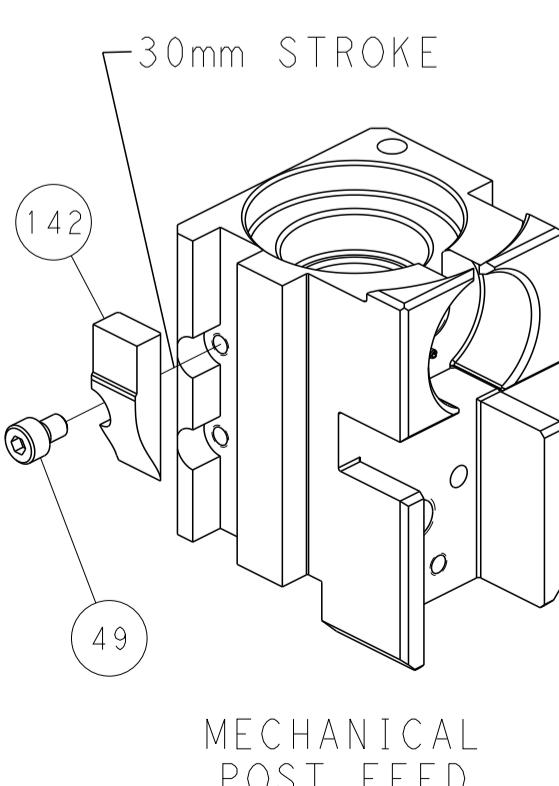


ITEM 30 LOCATED AT
REAR HOLES



FEED TRACK POSITION
GUIDE BY INSULATION BARREL

CAM POSITIONS



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 THE RESPONSIBILITY OF THE USER TO ENSURE THAT IT IS THE LATEST REVISION. FOR REVISION INFORMATION, THE USER SHOULD CONTACT THE LATEST REVISION NUMBER OR THE DATE OF THIS DRAWING.		DWN J.CALIMER 25OCT2022		NAME TE Connectivity	
CH T.BROOKENS 25OCT2022		APV0 T.ELBIN 25OCT2022		NAME OCEAN 2.0 Side Feed	
PRODUCT SPEC		AppliCator		Customer Accessible Production Drawing	
APPLICATION SPEC		DRAWING NO. C-4151250		SCALE 1:2	
MATERIAL		SIZE		SHEET 4 OF 4	
FINISH		REV A			

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION