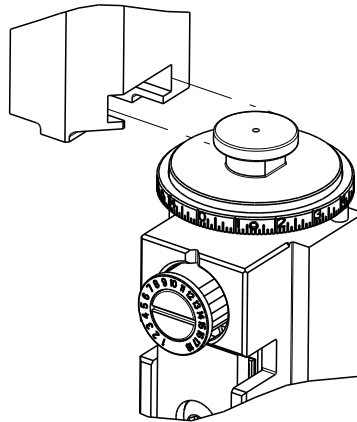





8	7	6	5	4	3	2	1
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE				
4151250-1	A	FINE CRIMP HEIGHT ADJUST	MECHANICAL				
4151250-2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC				
7-4151250-1	A	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL				
7-4151250-2	A	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC				
7-4151250-7	A	CRIMP TOOLING KIT	-				

ATLANTIC 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 APPLICATION SPECIFICATION		2043710001-AS Rev A10	-
		-	AT9106
TERMINALS APPLIED 			
TE TERMINAL	MOLEX TERMINAL	TE TERMINAL	MOLEX TERMINAL
3311942-1	2043714329		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.35mm2	0.72+/-0.02 [.028+/- .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)

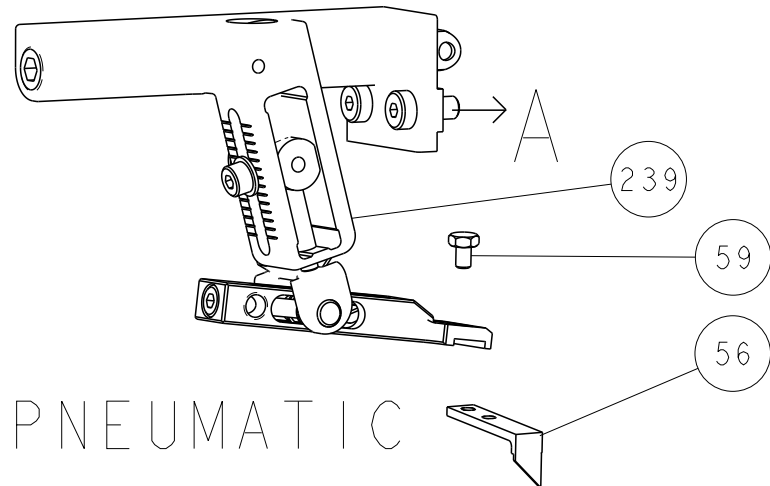
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			A	RELEASED FOR PRODUCTION	07DEC2022	JWC JH

	-	1	1	1	1	1803945-4	TONKER	300
	-	1	1	1	1	22278-9	SPRING, COMPRESSION	299
	-	2	2	2	2	4-18032-3	SCR, SET, FLT PNT, M3 X 6.0	298
	-	1	1	1	1	1803944-1	SPACER, TONKER	297
	-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248
	-	1	1	1	1	2119082-3	CAM, SNAIL, INSULATION ADJUSTMENT	244
	-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
3	-	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
5	-	1	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	455888-5	SPACER, CRIMPER	82
	-	1	1	1	1	1803607-3	DOCUMENTATION PACKAGE	71
	-	1	1	1	1	2119791-5	DEPRESSOR, WIRE	70
	-	1	1	1	1	2119943-1	WASHER, SPACER	69
	-	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	2-2168083-6	SCR, SKT HD CAP, RoHS, M4 X 18	53
	-	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	1-1752356-9	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	2844992-2	ASSEMBLY, STRIP GUIDE	29
	-	1	1	1	1	455888-5	SPACER, CRIMPER	28
	-	1	1	1	1	1320928-6	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	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	1	2119805-1	SHEAR HOLDER, FRONT	10
1	-	1	1	1	1	1803095-6	FLOATING SHEAR, FRONT	9
1	1	2	2	1	1	2392009-3	ANVIL, COMBINATION	8
	-	1	1	1	1	3-240641-5	SPACER	7
	-	-	-	-	-	-	-	6
	-	1	1	1	1	2119757-4	DEPRESSOR, SHEAR	5
	-	1	1	1	1	238011-8	BLOCK, CRIMPER SPACER	4
1	1	2	2	1	1	1803858-8	CRIMPER, INSULATION O	3
	-	1	1	1	1	455888-4	SPACER, CRIMPER	2
1	1	2	2	1	1	9-1633713-0	CRIMPER, WIRE PREMIUM	1
	-77	-72	-71	-2	-1	PART NO	DESCRIPTION	ITEM NO

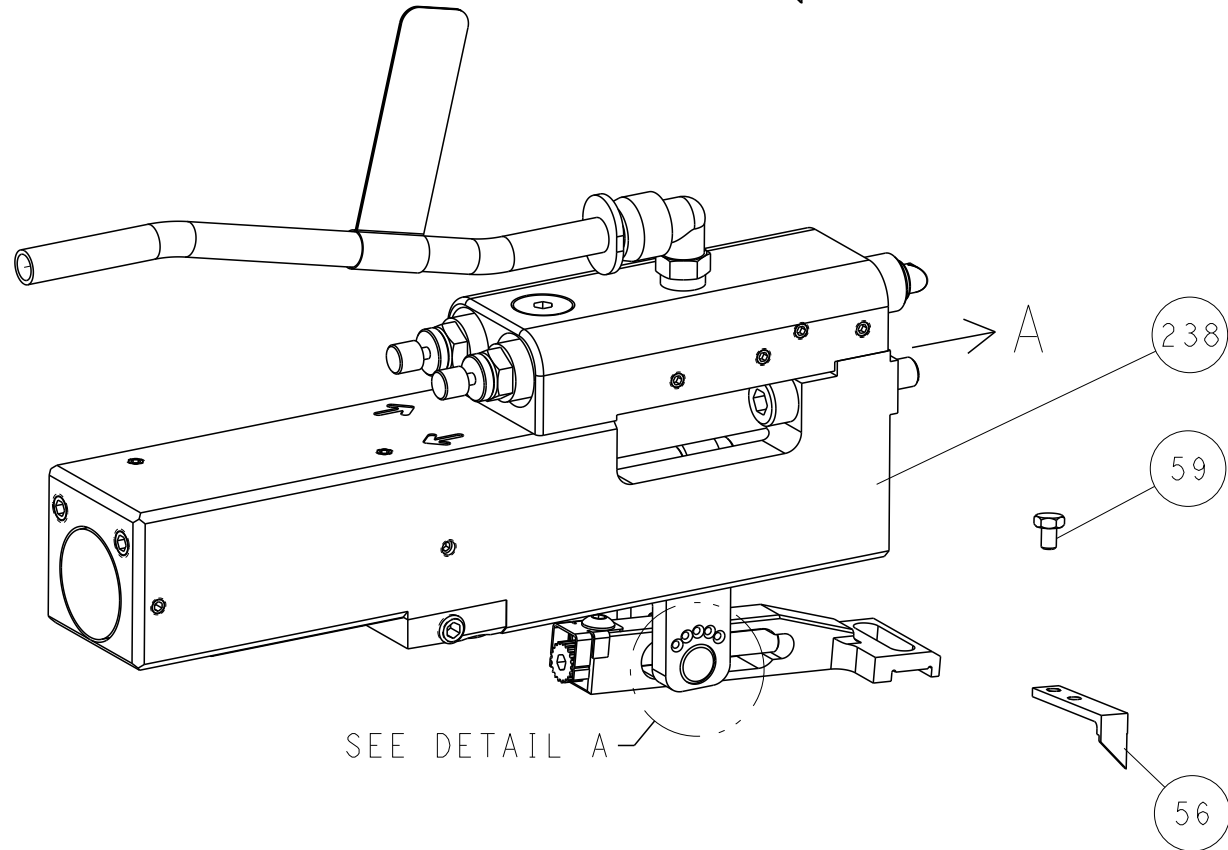
THIS DRAWING IS A CONTROL DRAWING FOR THE ELECTRONICS CORPORATION IT IS UNPUBLISHED. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. THE USER SHOULD BE CONTACTED FOR THE LATEST REVISION.										OWN J. CALIMER 25OCT2022		 TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm 				TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±				CHK T. BROOKENS 25OCT2022		NAME			
								APVD T. ELBIN 25OCT2022		OCEAN 2.0 Side Feed Applicator			
				PRODUCT SPEC -				APPLICATION SPEC		-			
								WEIGHT		-			
MATERIAL				FINISH				SIZE		CAGE CODE			
-				-				A		00779			
-				-				C=4151250		-			
Customer Accessible Production Drawing								SCALE		1:2			
SHEET								1		OF 4			
REV								A		RESTRICTED TO			

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

FEED TYPE MECHANICAL

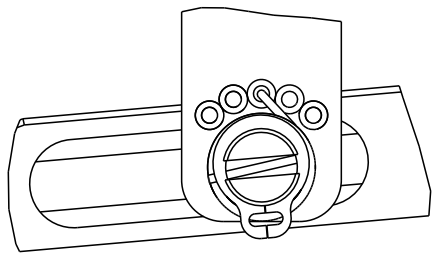


PNEUMATIC

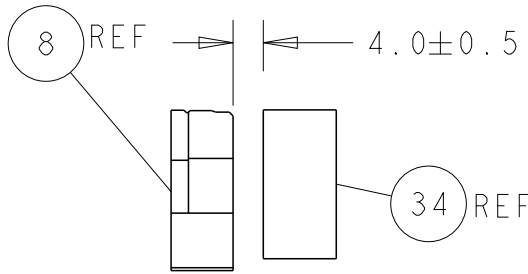
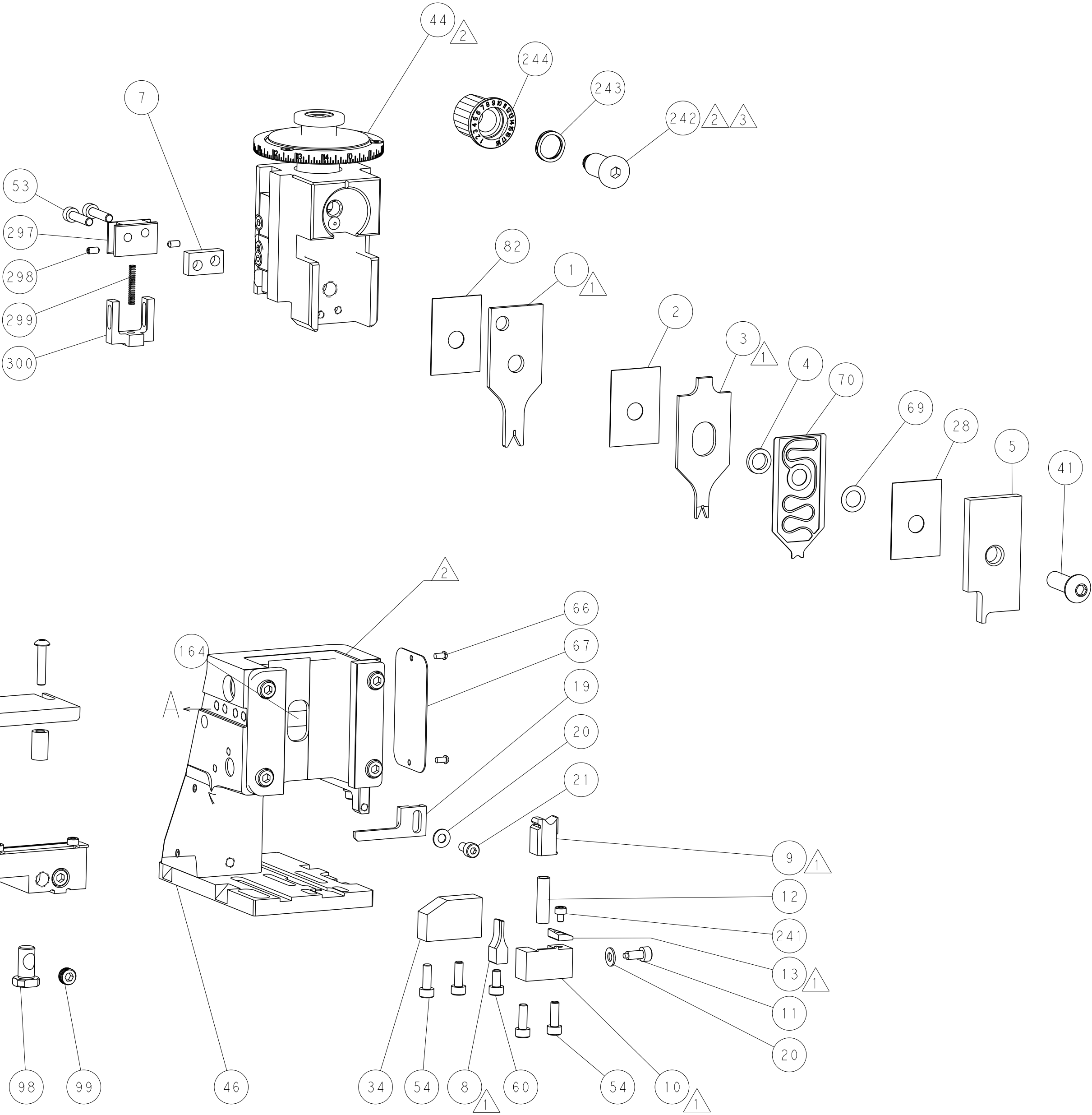


SEE DETAIL A

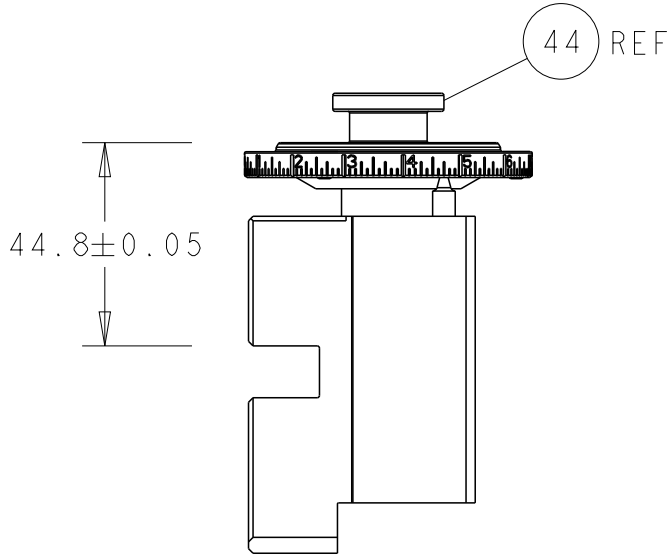
FEED SPRING SETTING POSITION
(SHOWN FROM REAR SIDE)



DETAIL A

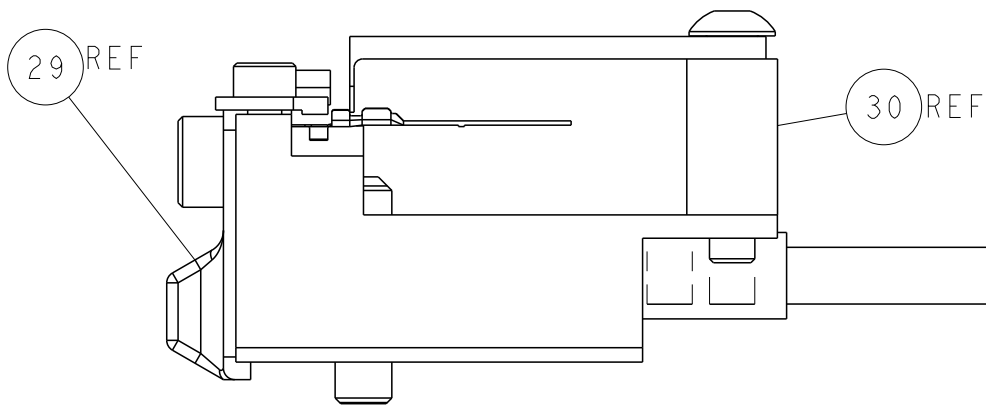


TERMINAL SUPPORT LOCATION



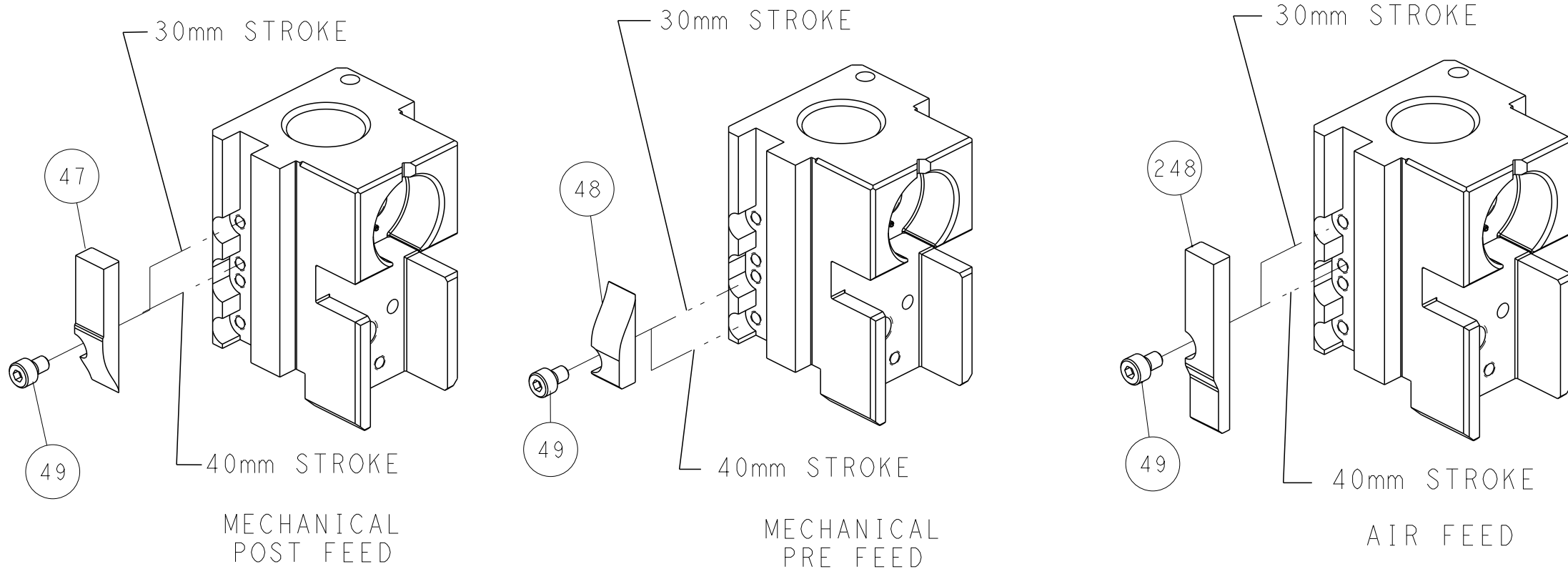
RAM SET-UP

ITEM 30 LOCATED AT
REAR HOLES



FEED TRACK POSITION
GUIDE BY INSULATION BARREL

CAM POSITIONS





MECHANICAL
POST FEED

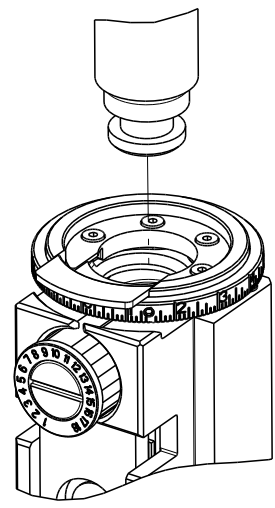
MECHANICAL
PRE FEED

AIR FEED

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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										CHK T. BROOKENS 25OCT2022		NAME OCEAN 2.0 Side Feed Applicator			
										APVD T. ELBIN 25OCT2022					
DIMENSIONS:										TOLERANCES UNLESS OTHERWISE SPECIFIED:		SIZE CAGE CODE DRAWING NO RESTRICTED TO			
mm															
															
0 PLC ±.1															
1 PLC ±.1															
2 PLC ±.1															
3 PLC ±.1															
4 PLC ±.1															
ANGLES ±.1															
FINISH															
MATERIAL										WEIGHT		A 00779 C=4151250		-	
Customer Accessible Production Drawing										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
2-4151250-1	A	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-4151250-2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-4151250-7	A	CRIMP TOOLING KIT	-





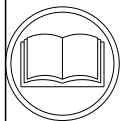
APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.02 mm [.040]	F
INSUL	1.27 mm [.050]	O

APPLICATOR INSTRUCTIONS
408-35042



TERMINAL DATA: MOLEX TERMINAL		MOLEX CRIMP SPECIFICATION	
TERMINAL NAME: CTX50 UNSEALED BLADE TERMINAL			
WIRE STRIP LENGTH 3.50-3.50 mm [.138-.138 IN]		TERMINAL INSULATION DIAMETER RANGE Ø1.20-1.40 mm [.047-.055 IN]	
TERMINAL APPLICATION SPECIFICATION 2043710001-AS Rev A10		- - AT9106	
TERMINALS APPLIED 			
TE TERMINAL 3311942-1	MOLEX TERMINAL 2043714329	TE TERMINAL	MOLEX TERMINAL

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING
0.35mm2		0.72+/-0.02 [0.028+/-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.
```

2				1			
LOC	DIST	REVISIONS					
A	66	P	LTR	DESCRIPTION	DATE	DNB	APVD
		-		SEE SHEET 1	-	-	-

	-	1	1	1803945-4	TONKER	300
	-	1	1	22278-9	SPRING, COMPRESSION	299
	-	2	2	4-18032-3	SCR, SET, FLT PNT, M3 X 6.0	298
	-	1	1	1803944-1	SPACER, TONKER	297
	-	1	1	2119082-3	CAM, SNAIL, INSULATION ADJUSTMENT	244
3	-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
	-	1	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
	-	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
5	-	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	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	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	1	1	1803858-8	CRIMPER, INSULATION O	3
	-	1	1	455888-4	SPACER, CRIMPER	2
1	1	1	1	9-1633713-0	CRIMPER, WIRE PREMIUM	1

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DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		NAME	
		0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± ANGLES ± FINISH		OCEAN 2.0 Side Feed Applicator -	
MATERIAL		WEIGHT		SIZE CAGE CODE DRAWING NO	
-		-		A 00779 C=4151250	
		Customer Accessible Production Drawing		SCALE 1:2 SHEET 3 OF 4 REV A	

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

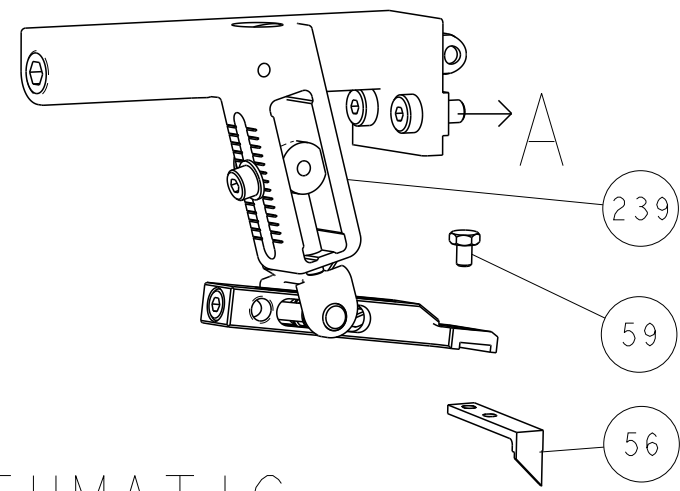
AMP 4805 REV 31MAR2000

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

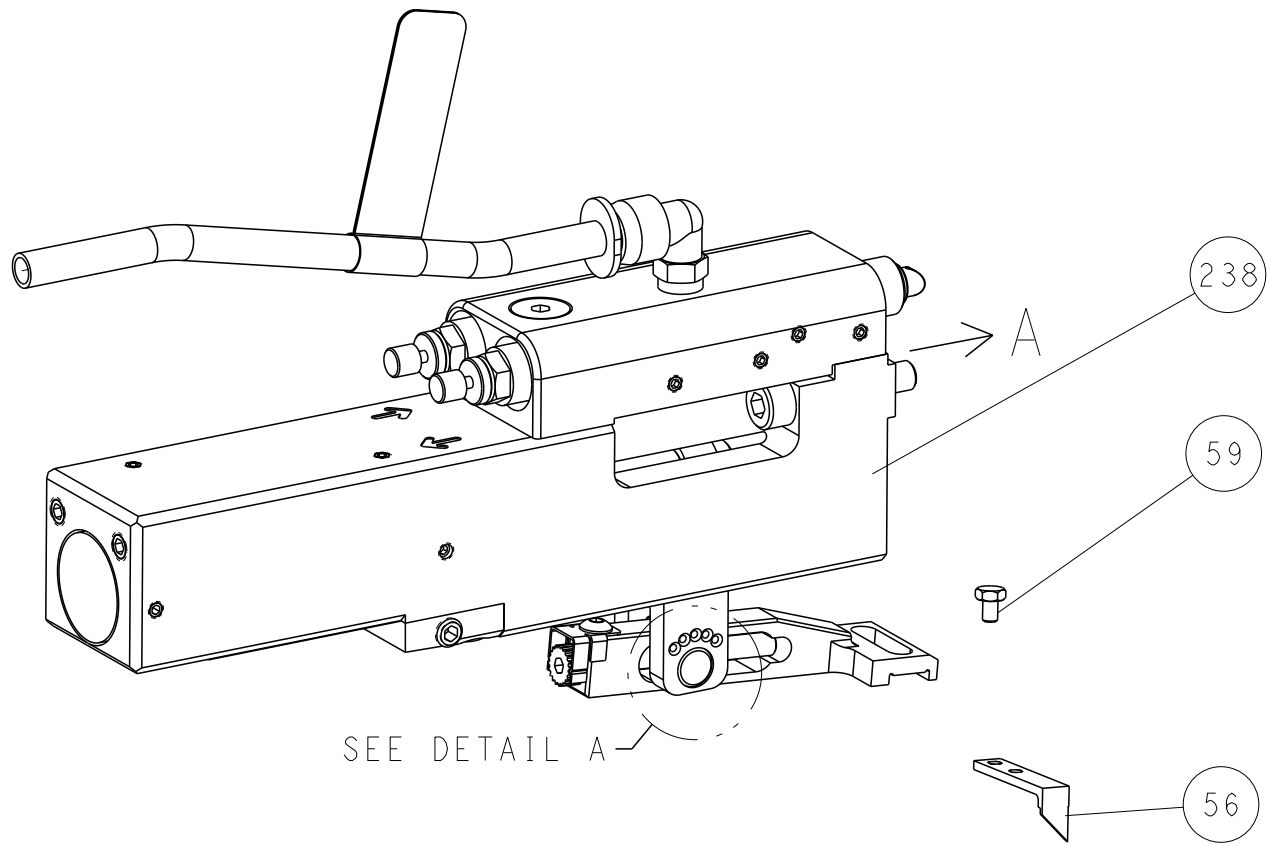
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		P	LTR	DESCRIPTION	DATE	DWN	APVD
A	66	-	SEE SHEET 1		-	-	-

FEED TYPE

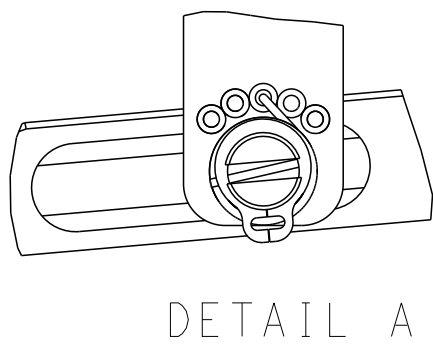
MECHANICAL



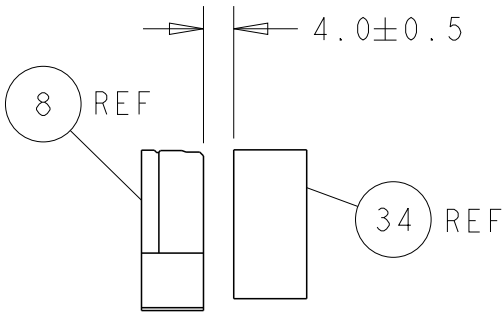
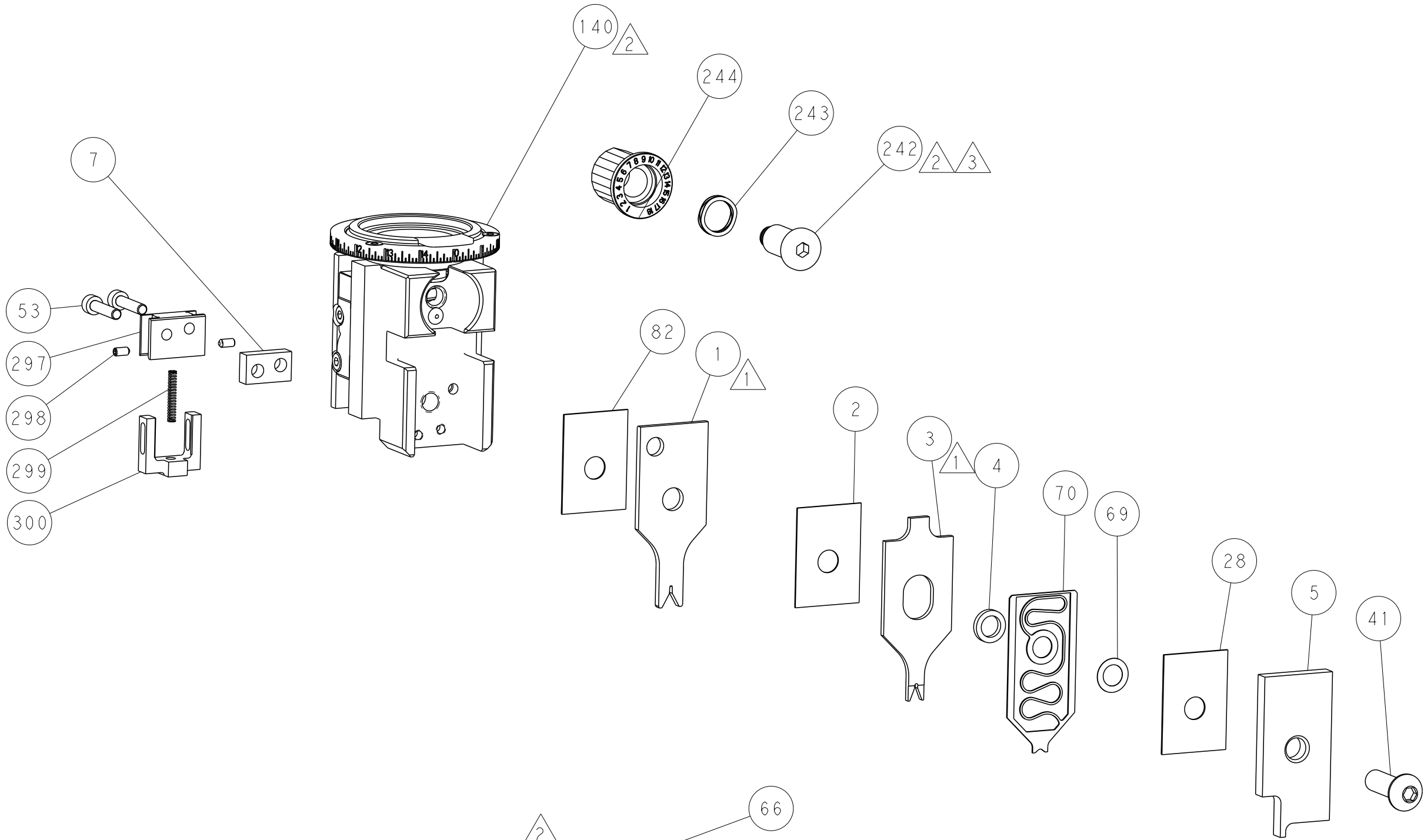
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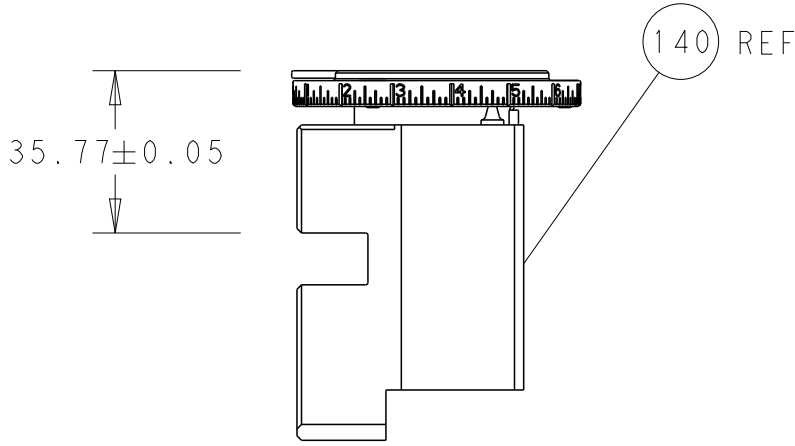
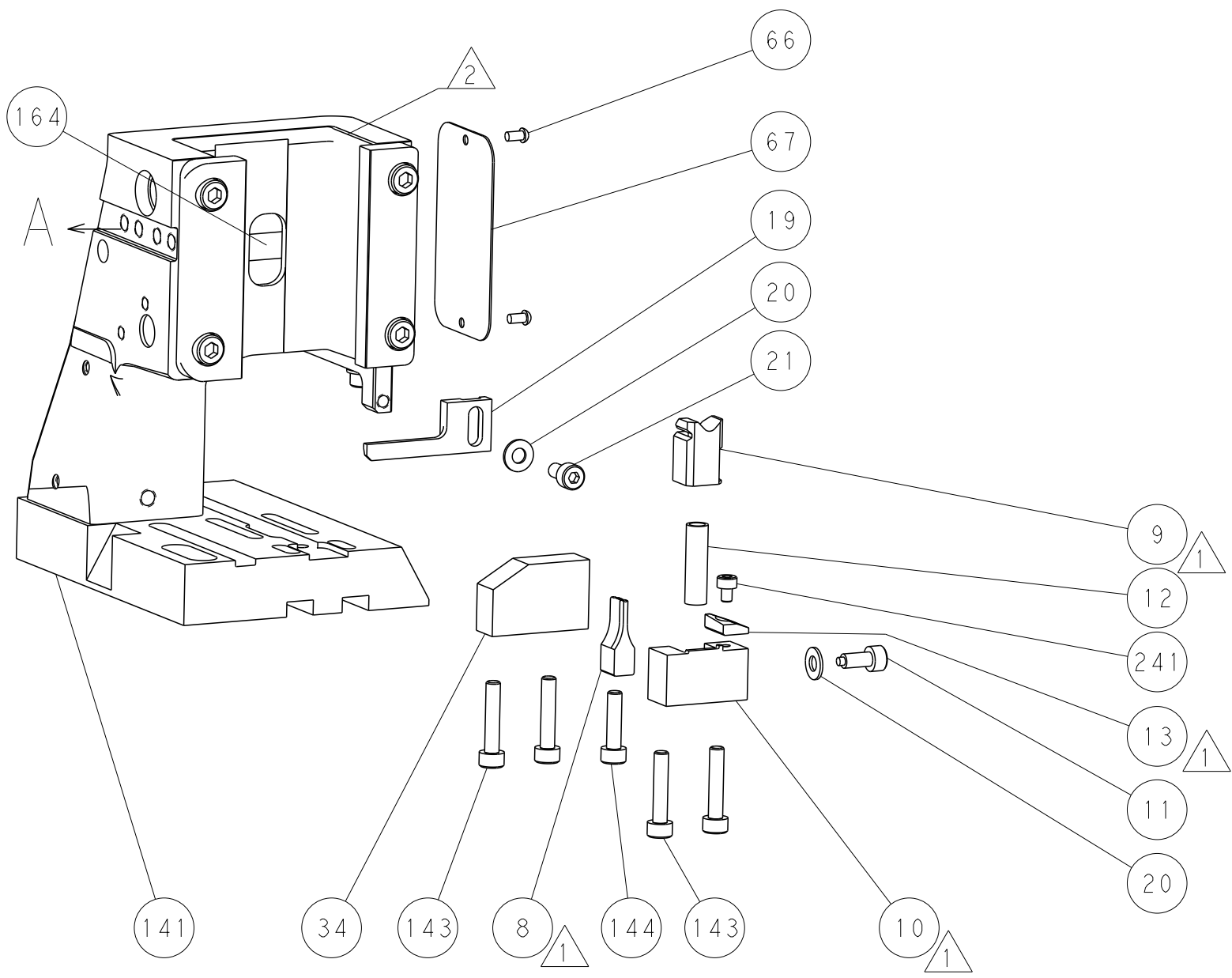
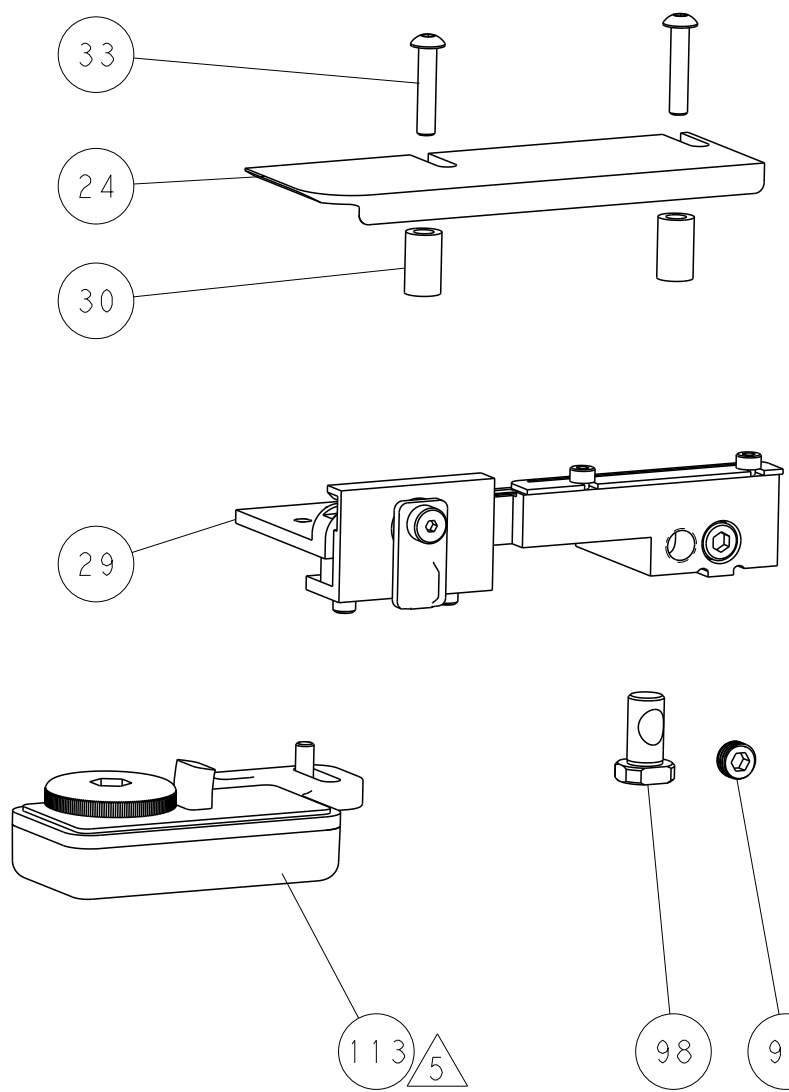
FEED SPRING SETTING POSITION
(SHOWN FROM REAR SIDE)



DETAIL A

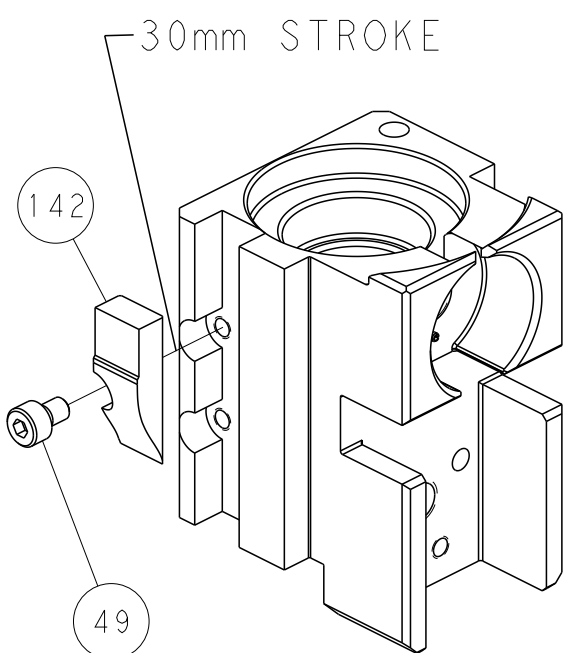


TERMINAL SUPPORT LOCATION

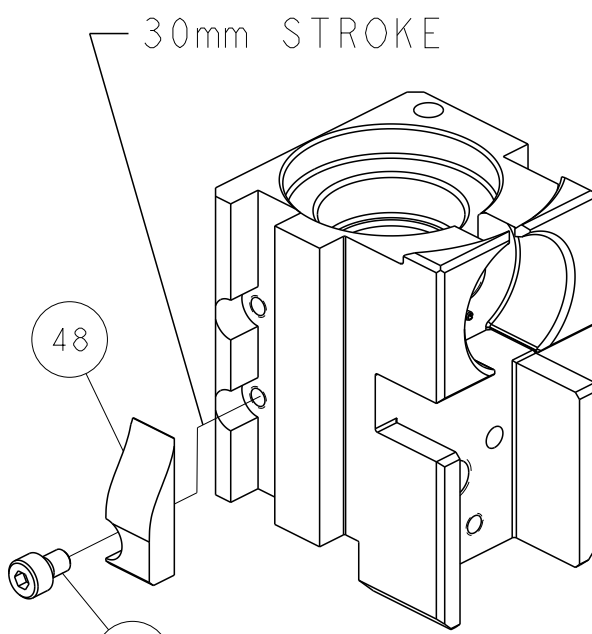


RAM SET-UP

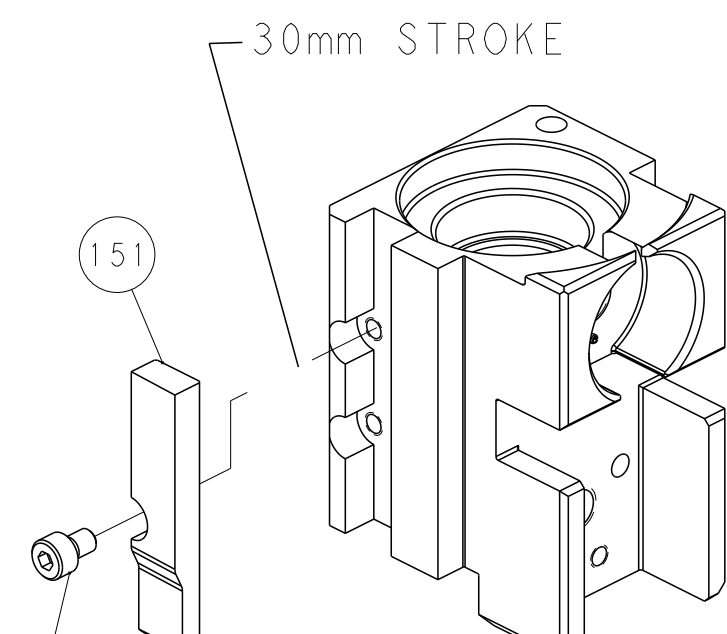
CAM POSITIONS



MECHANICAL
POST FEED

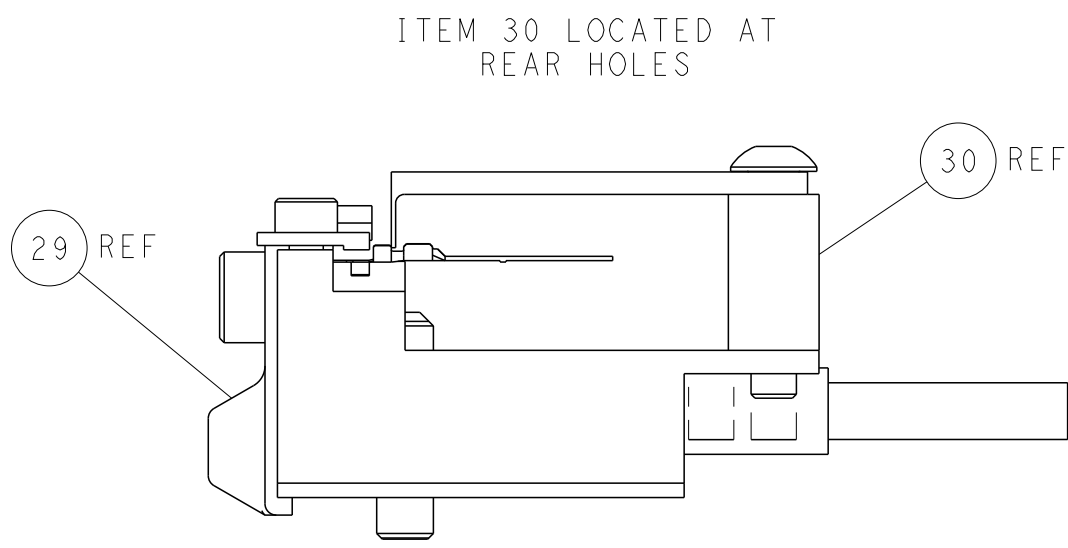


MECHANICAL
PRE FEED



AIR FEED

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



FEED TRACK POSITION
GUIDE BY INSULATION BARREL

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				CHK	T. BROOKENS	25OCT2022		
				APVD	T. ELBIN	25OCT2022	NAME	
				PRODUCT SPEC			OCEAN 2.0 Side Feed Applicator	
				APPLICATION SPEC			-	
				SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO	
				A1	00779	4151250	-	
				Customer Accessible Production Drawing			SCALE	1:2
							SHEET	4 of 4
							REV	A

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION