

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
4151136-2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-4151136-2	A	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-4151136-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	0.69 mm [.027]	F
INSUL	0.76 mm [.030]	F

APPLICATOR INSTRUCTIONS  
408-35042

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: 1.0 mm PITCH WIRE TO BOARD CONNECTOR			
WIRE STRIP LENGTH		TERMINAL INSULATION DIAMETER RANGE	
1.00-1.20 mm [.039-.047 IN]		∅0.40-0.80 mm [.016-.031 IN]	
TERMINAL APPLICATION SPECIFICATION	114-57020		AT9106
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
1734597-1			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
28 AWG	0.46 +/- 0.02 [.018 +/- .001]	7.5
30 AWG	0.42 +/- 0.02 [.017 +/- .001]	7.9
32 AWG	0.41 +/- 0.025 [.016 +/- .001]	8.1

- RECOMMENDED SPARE PARTS
- REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION & STORAGE OF APPLICATOR.
- 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 PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- 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					
A	66	P	LTN	DESCRIPTION	DATE	OWN	APVD
		1		DEVELOPMENT	21FEB2022	TB	GB
		A		RELEASED	19SEP2022	ROY	TLE

-	1	1	2-2119791-2	DEPRESSOR, WIRE	286
-	1	1	2079383-1	SCR, BHSC, RoHS (M3 X 8)	284
-	1	1	1633289-4	STABILIZER	283
-	1	1	1803461-1	HOLDER, STABILIZER	282
-	1	1	1-18028-3	WASHER, FLAT, REG M5	281
-	1	1	1803196-1	STUD, ADJUSTMENT SCREW	280
-	1	1	2330046-1	RESIN COLLAR, FLANGED	261
-	1	1	2119641-1	FEED CAM, AIR FEED	248
-	1	1	2119082-1	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	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	1	2844940-1	AIR FEED MODULE	238
-	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	1	1	1-22281-6	SPRING, COMPRESSION	121
-	1	1	455888-3	SPACER, CRIMPER	120
	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	3-690438-2	FRONT STRIP GUIDE	96
-	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	95
-	1	1	1-994962-8	SCR, SKT HD CAP M3 X 45.0	93
-	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
-	2	2	2-18032-5	SCR, SET, FLT PNT, M5 X 20.0	61
-	1	1	2161425-1	SCREW, SHOULDER	60
-	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	1	1	1338685-1	PAWL, FEED	56
-	4	4	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	54
-	1	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	1	1	2-1803583-5	APPLICATOR BASIC ASSEMBLY, SF	46
-	1	1	1803515-1	RAM ASSEMBLY, SF ATLANTIC	44
-	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
-	1	1	2-1752356-5	SUPPORT, TERMINAL	34
-	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	2-2844962-3	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	2-2844938-0	PLATE, STRIP GUIDE	29
-	2	2	22281-8	SPRING, COMPRESSION	27
-	1	1	356835-1	LEVER, DRAG RELEASE	26
-	1	1	240792-5	DRAG, TERMINAL	25
-	1	1	1320928-2	STRIP GUIDE	24
-	1	1	980371-4	SCR, SKT HD SHLDR 5.0 DIA X 6.0	23
-	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	1803213-1	STRIPPER	19
	1	1	2119806-1	INSERT, SHEAR	13
-	1	1	3-22280-3	SPRING, COMPRESSION	12
-	1	1	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	11
	1	1	2119805-1	SHEAR HOLDER, FRONT	10
	1	1	2-1803095-3	FLOATING SHEAR, FRONT	9
	1	2	1-1803395-1	ANVIL, COMBINATION	8
-	-	-	-	-	7
-	-	-	-	-	6
-	1	1	1-2119757-9	DEPRESSOR, SHEAR	5
-	1	1	238011-6	BLOCK, CRIMPER SPACER	4
	1	2	1-1633962-1	CRIMPER, INSULATION F PREMIUM	3
-	-	-	-	-	2
	1	2	1-61803407-7	CRIMPER, WIRE PREMIUM	1

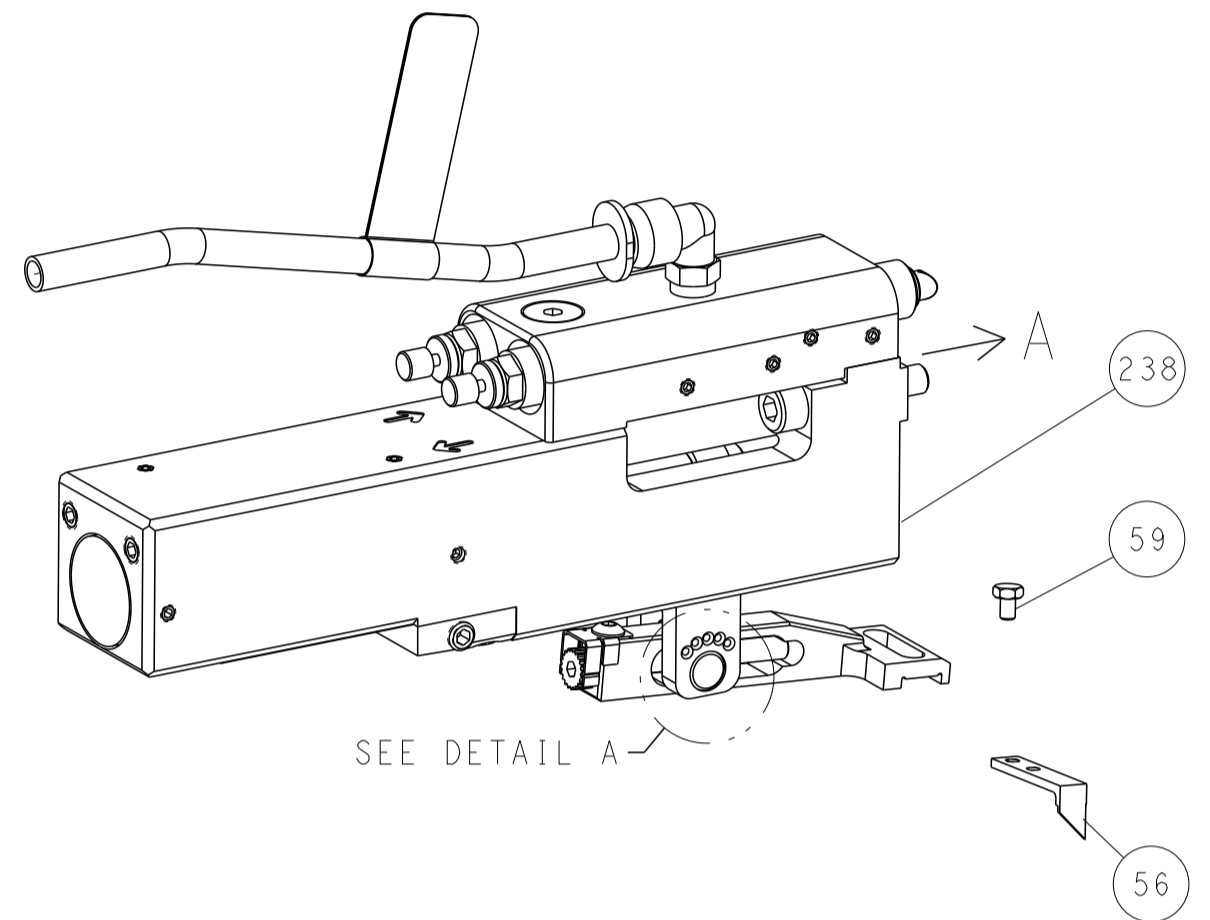
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mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES ±	FINISH ±

OWN	T. BROOKENS	21FEB2022	CHK	R. KNEPPER	21FEB2022	APVD	G. BAILEY	21FEB2022
NAME			OCEAN 2.0 Side Feed Applicator			SIZE		
CAGE CODE			DRAWING NO			RESTRICTED TO		
00779			4151136			Customer Accessible Production Drawing		
SCALE			SHEET			REV		
1:2			1 of 4			A		

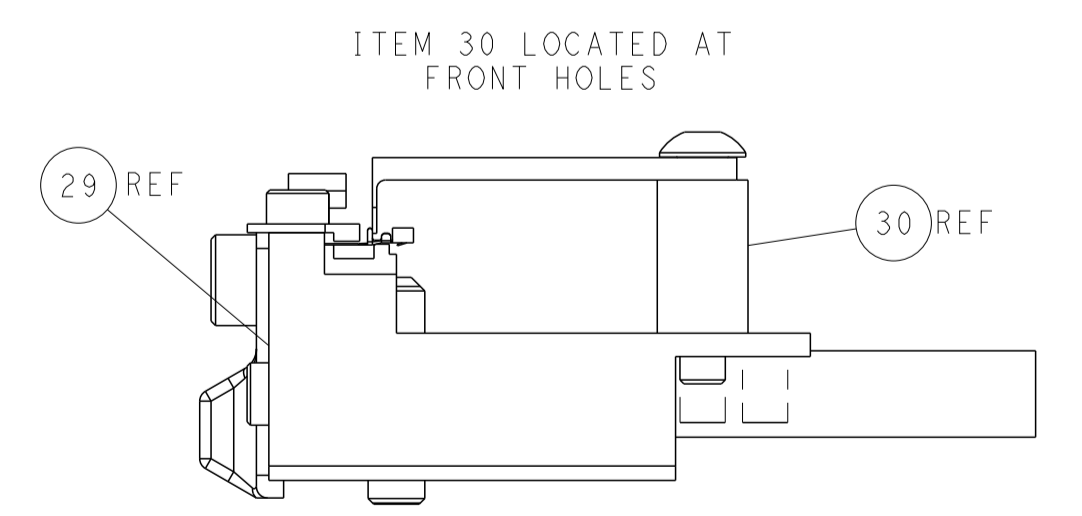
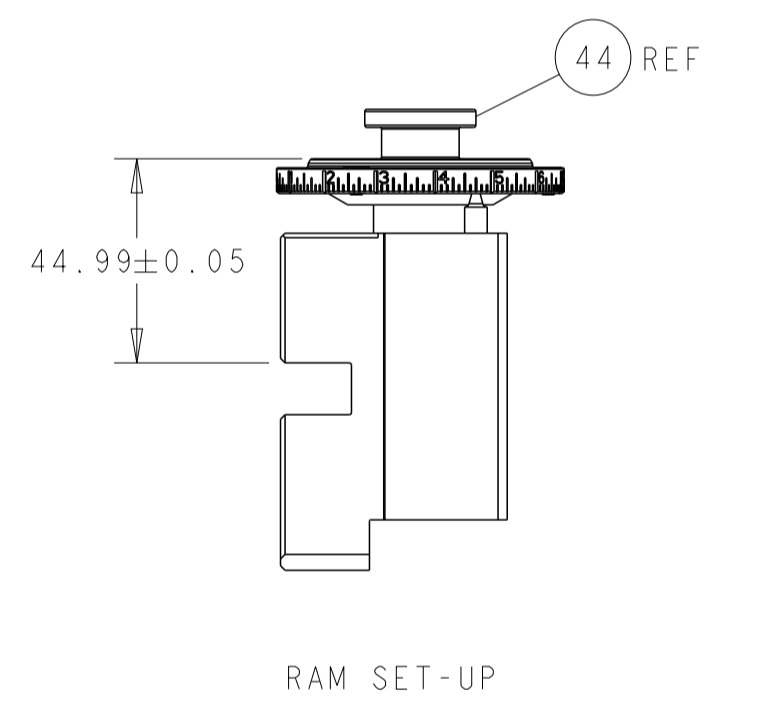
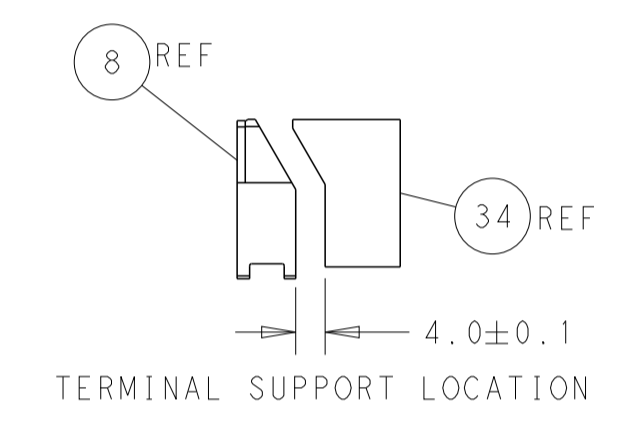
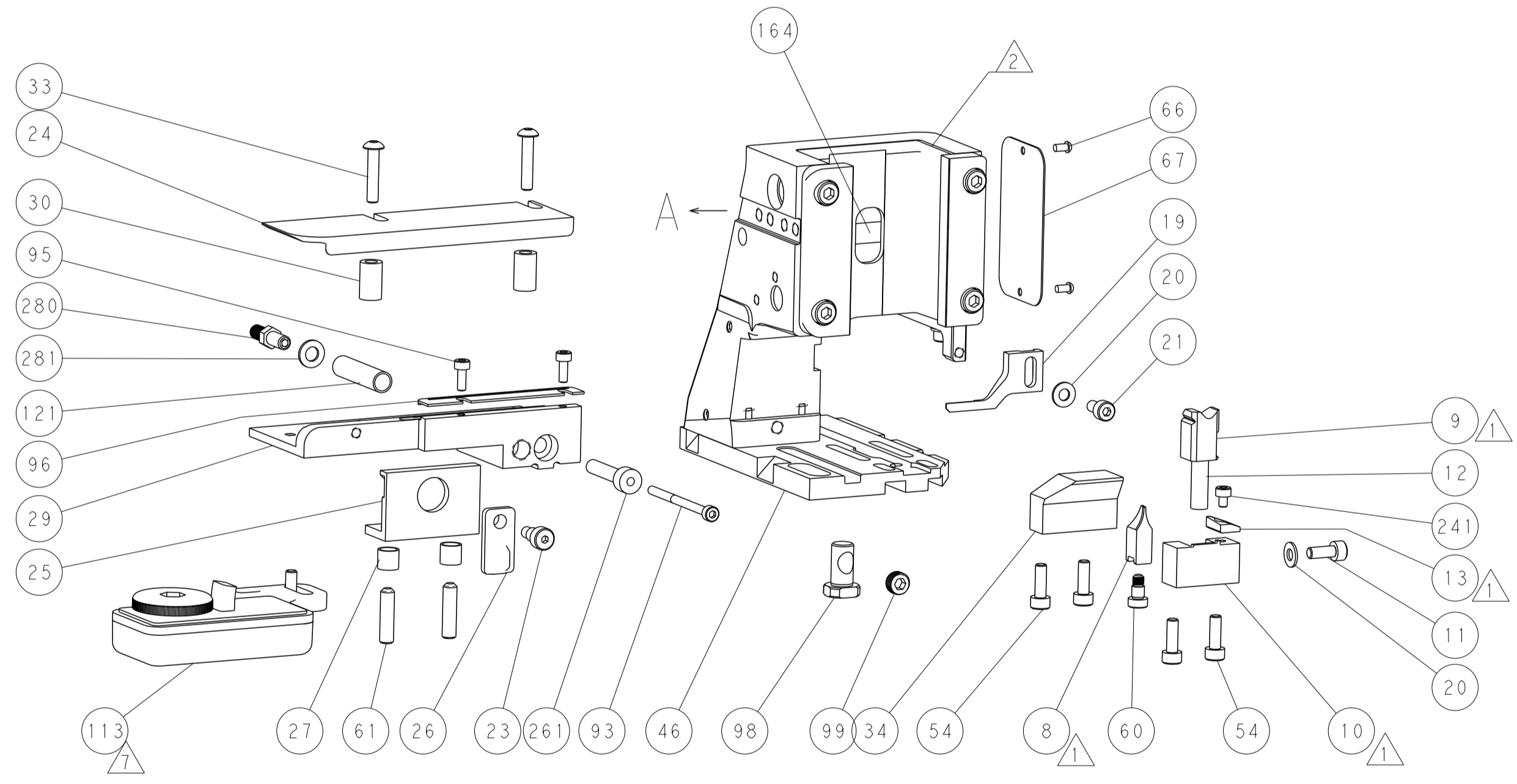
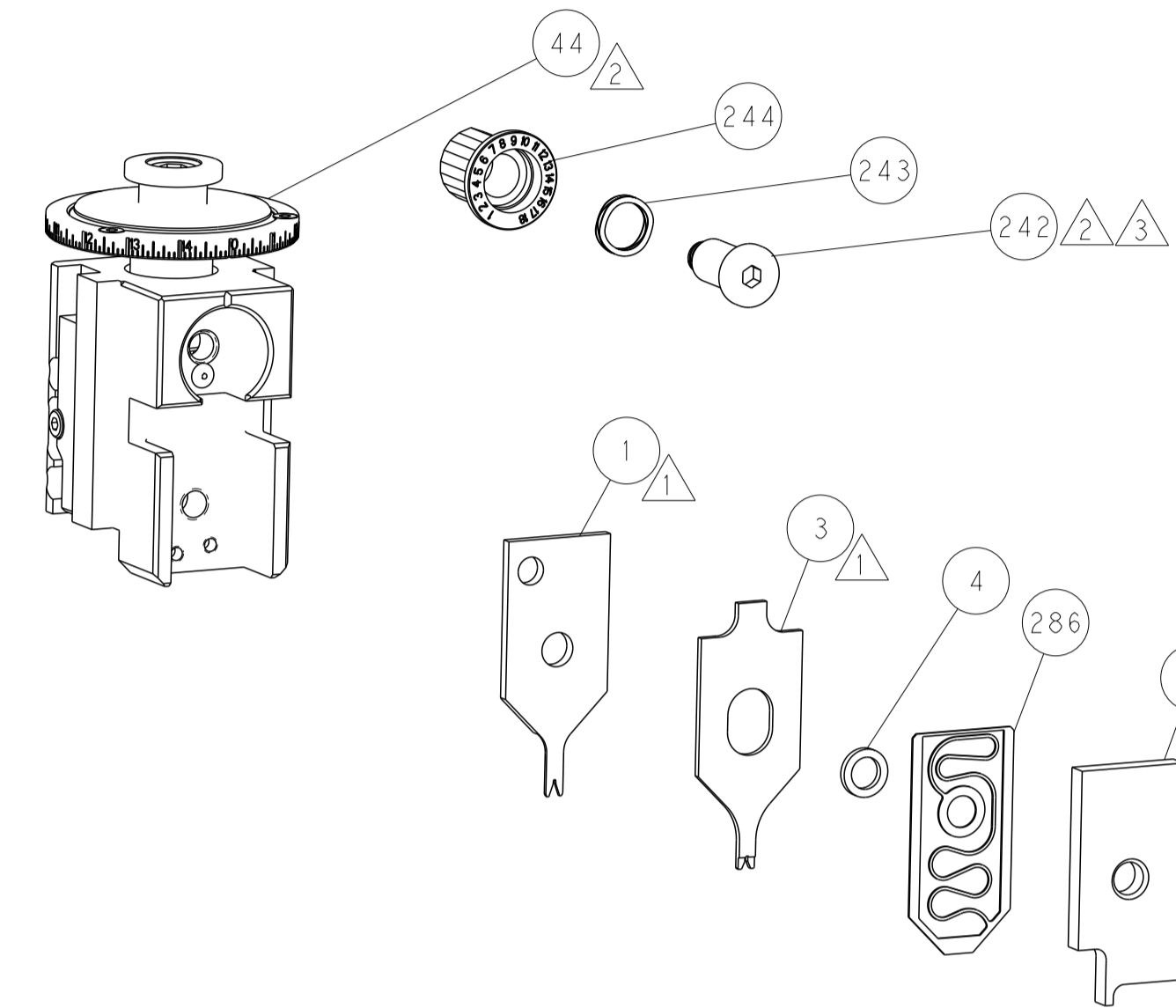
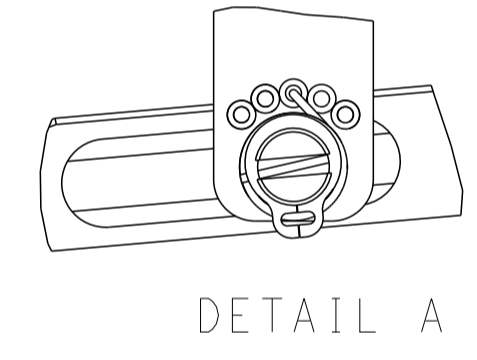
LOC		DIST		REVISIONS					
A		66		P	LTN	DESCRIPTION	DATE	OWN	APVD
				-	-	SEE SHEET 1	-	-	-

# FEED TYPE

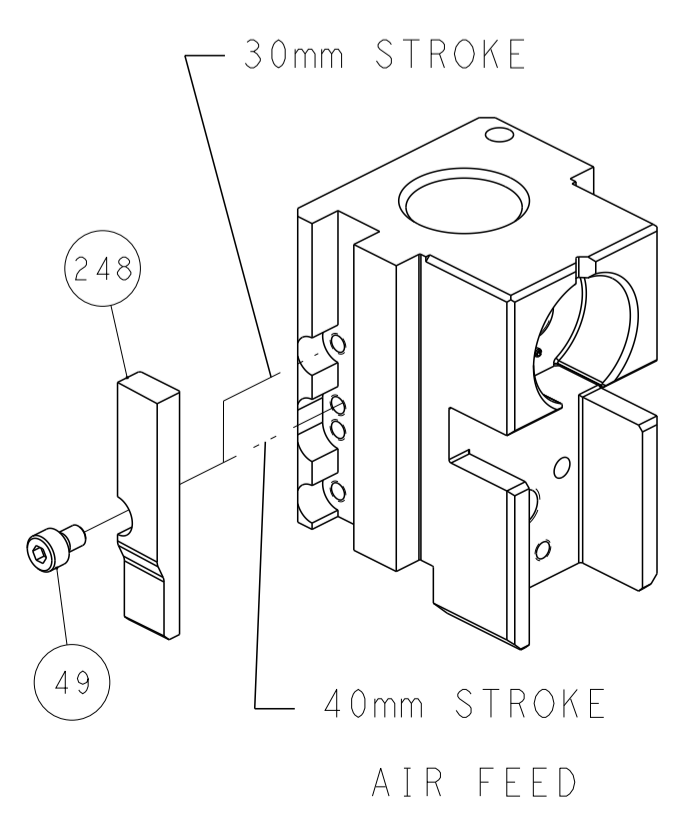
## PNEUMATIC



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



## CAM POSITION

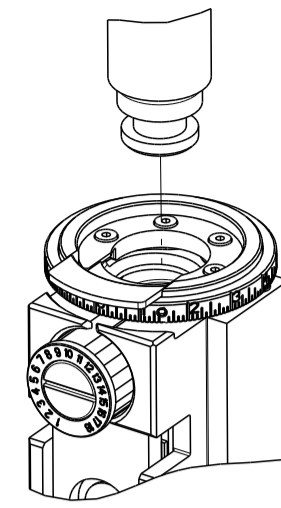


**ATLANTIC VERSION**  
 Shown on sheets 1 of 4 & 2 of 4  
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

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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=4151136 WEIGHT Customer Accessible Production Drawing	RESTRICTED TO SCALE 1:2 SHEET 2 OF 4 REV A

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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-4151136-2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-4151136-7	A	CRIMP TOOLING KIT	-

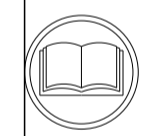
PACIFIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	0.69 mm [.027]	F
INSUL	0.76 mm [.030]	F
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: 1.0 mm PITCH WIRE TO BOARD CONNECTOR			
WIRE STRIP LENGTH 1.00-1.20 mm [.039-.047 IN]		TERMINAL INSULATION DIAMETER RANGE Ø0.40-0.80 mm [.016-.031 IN]	
TERMINAL APPLICATION SPECIFICATION	114-57020	-	-
TERMINALS APPLIED		AT9106	
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
1734597-1			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
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30 AWG	0.42+/-0.02 [.017+/-0.001]	7.9
32 AWG	0.41+/-0.025 [.016+/-0.001]	8.1



- 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.
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**\*WARNING**  
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**PACIFIC VERSION**  
Shown on sheets 3 of 4 & 4 of 4  
(Atlantic version shown on sheets 1 of 4 & 2 of 4)

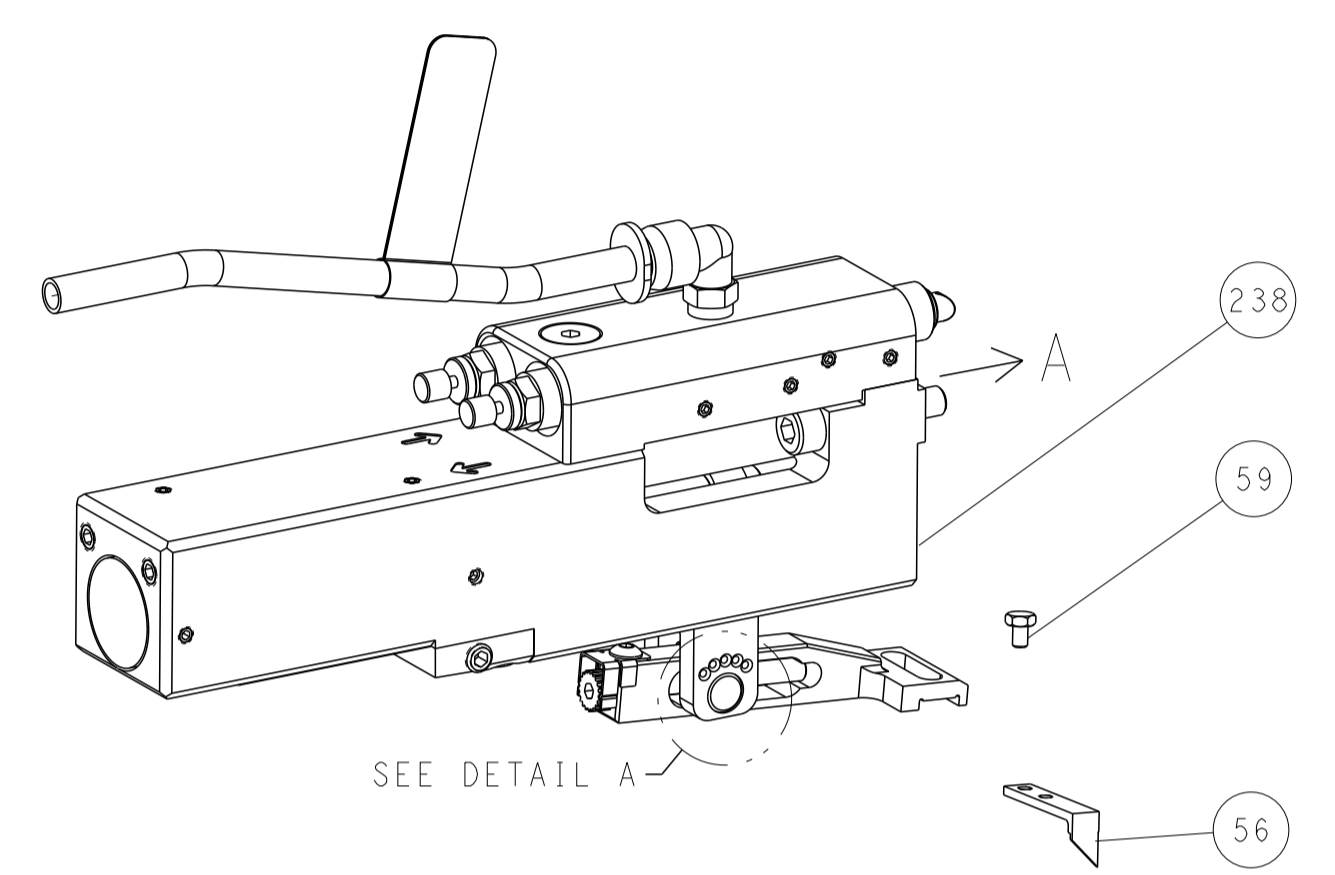
LOC	DIST	REVISIONS					
A	66	P	LTN	DESCRIPTION	DATE	DWN	APVD
		-		SEE SHEET 1	-	-	-

-	1	2-2119791-2	DEPRESSOR, WIRE	286
-	1	2079383-1	SCR, BHSC, RoHS (M3 X 8)	284
-	1	1633289-4	STABILIZER	283
-	1	1803461-1	HOLDER, STABILIZER	282
-	1	1-18028-3	WASHER, FLAT, REG M5	281
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-	1	2330046-1	RESIN COLLAR, FLANGED	261
-	1	2119082-1	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
3	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
-	1	2844940-1	AIR FEED MODULE	238
-	REF	994970-2	COUNTER, MAGNETIC	164
-	1	2119641-2	FEED CAM, AIR FEED	151
-	1	2161425-1	SCREW, SHOULDER	144
-	4	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	143
-	1	3-1803583-0	APPLICATOR BASIC ASSEMBLY, SF	141
-	1	1803516-1	RAM ASSEMBLY, SF PACIFIC	140
-	1	1-22281-6	SPRING, COMPRESSION	121
-	1	455888-3	SPACER, CRIMPER	120
7	1	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113
-	1	2844908-1	SCREW, LOCKING	99
-	1	2844907-1	POST, LOCKING	98
-	1	3-690438-2	FRONT STRIP GUIDE	96
-	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	95
-	1	1-994962-8	SCR, SKT HD CAP M3 X 45.0	93
-	1	1803607-3	DOCUMENTATION PACKAGE	71
-	1	2119740-1	TAG, IDENTIFICATION	67
-	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	2	2-18032-5	SCR, SET, FLT PNT, M5 X 20.0	61
-	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	1	1338685-1	PAWL, FEED	56
-	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
-	1	2-1752356-5	SUPPORT, TERMINAL	34
-	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2-2844962-3	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	2-2844938-0	PLATE, STRIP GUIDE	29
-	2	22281-8	SPRING, COMPRESSION	27
-	1	356835-1	LEVER, DRAG RELEASE	26
-	1	240792-5	DRAG, TERMINAL	25
-	1	1320928-2	STRIP GUIDE	24
-	1	980371-4	SCR, SKT HD SHLDR 5.0 DIA X 6.0	23
-	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
-	2	1-18028-2	WASHER, FLAT, REG M4	20
-	1	1803213-1	STRIPPER	19
1	1	2119806-1	INSERT, SHEAR	13
-	1	3-22280-3	SPRING, COMPRESSION	12
-	1	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	11
1	1	2119805-1	SHEAR HOLDER, FRONT	10
1	1	2-1803095-3	FLOATING SHEAR, FRONT	9
1	1	5-1803395-1	ANVIL, COMBINATION	8
-	-	-	-	7
-	-	-	-	6
-	1	1-2119757-9	DEPRESSOR, SHEAR	5
-	1	238011-6	BLOCK, CRIMPER SPACER	4
1	1	1633962-1	CRIMPER, INSULATION F PREMIUM	3
-	-	-	-	2
1	1	6-1803407-7	CRIMPER, WIRE PREMIUM	1

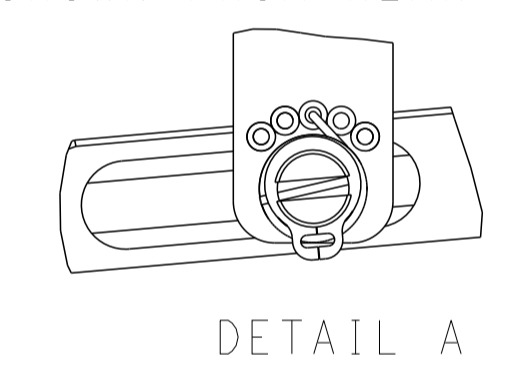
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mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	5 PLC ±	Harrisburg, PA 17105-3608
MATERIAL:		FINISH:		CHK R. KNEPPER 21FEB2022		NAME	
				APVD G. BAILEY 21FEB2022		OCEAN 2.0 Side Feed Applicator	
				PRODUCT SPEC		SIZE CAGE CODE DRAWING NO RESTRICTED TO	
				APPLICATION SPEC		A 00779 C=4151136	
				WEIGHT		SCALE 1:2 SHEET 3 OF 4 REV A	
				Customer Accessible Production Drawing			

LOC	DIST	REV	DATE	BY	APPV
A	66				

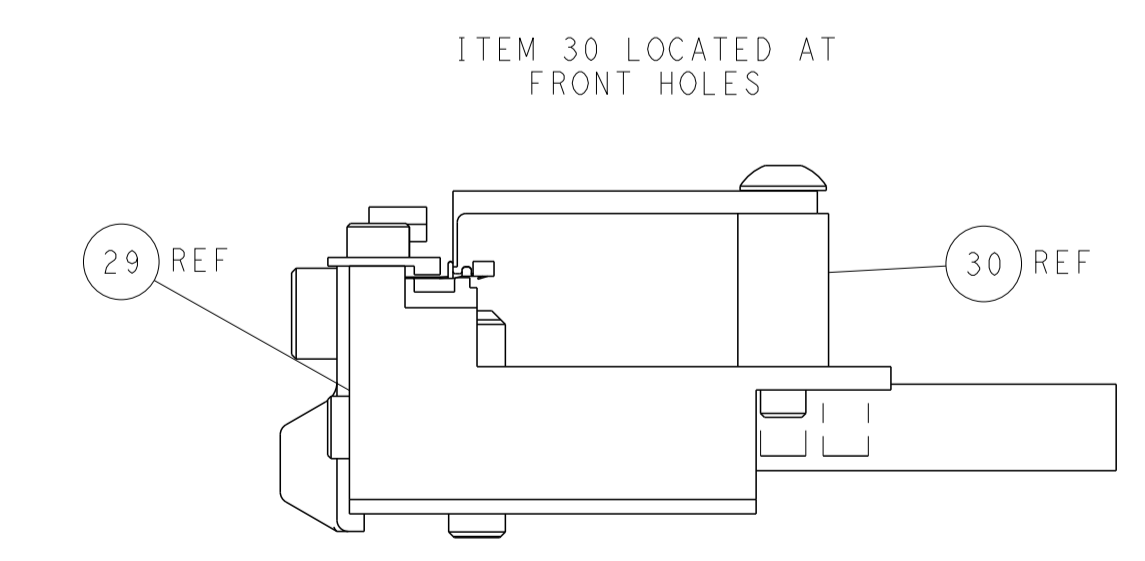
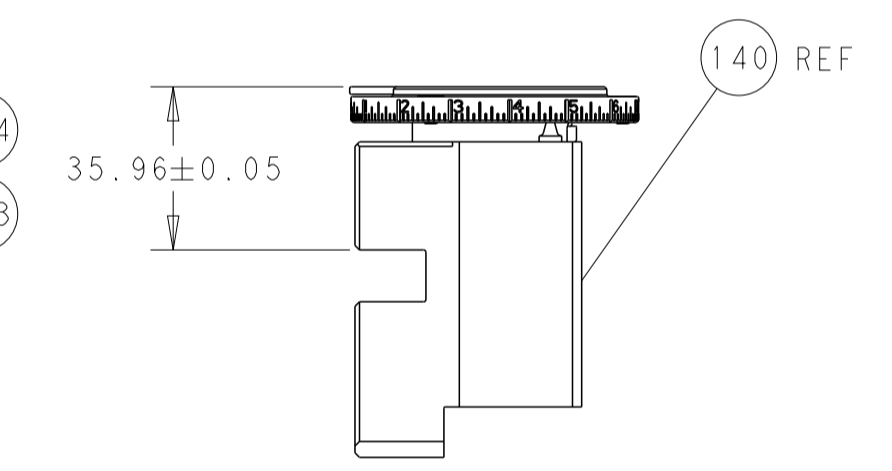
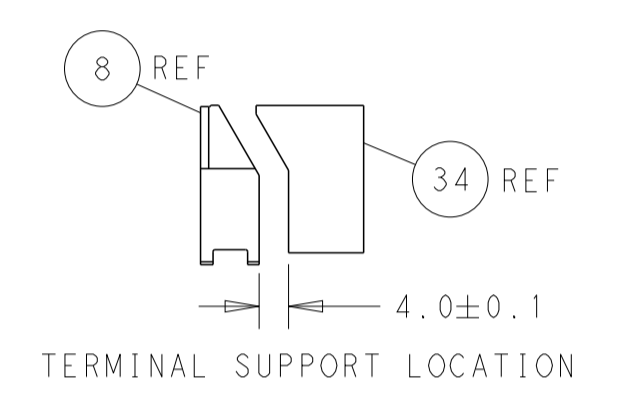
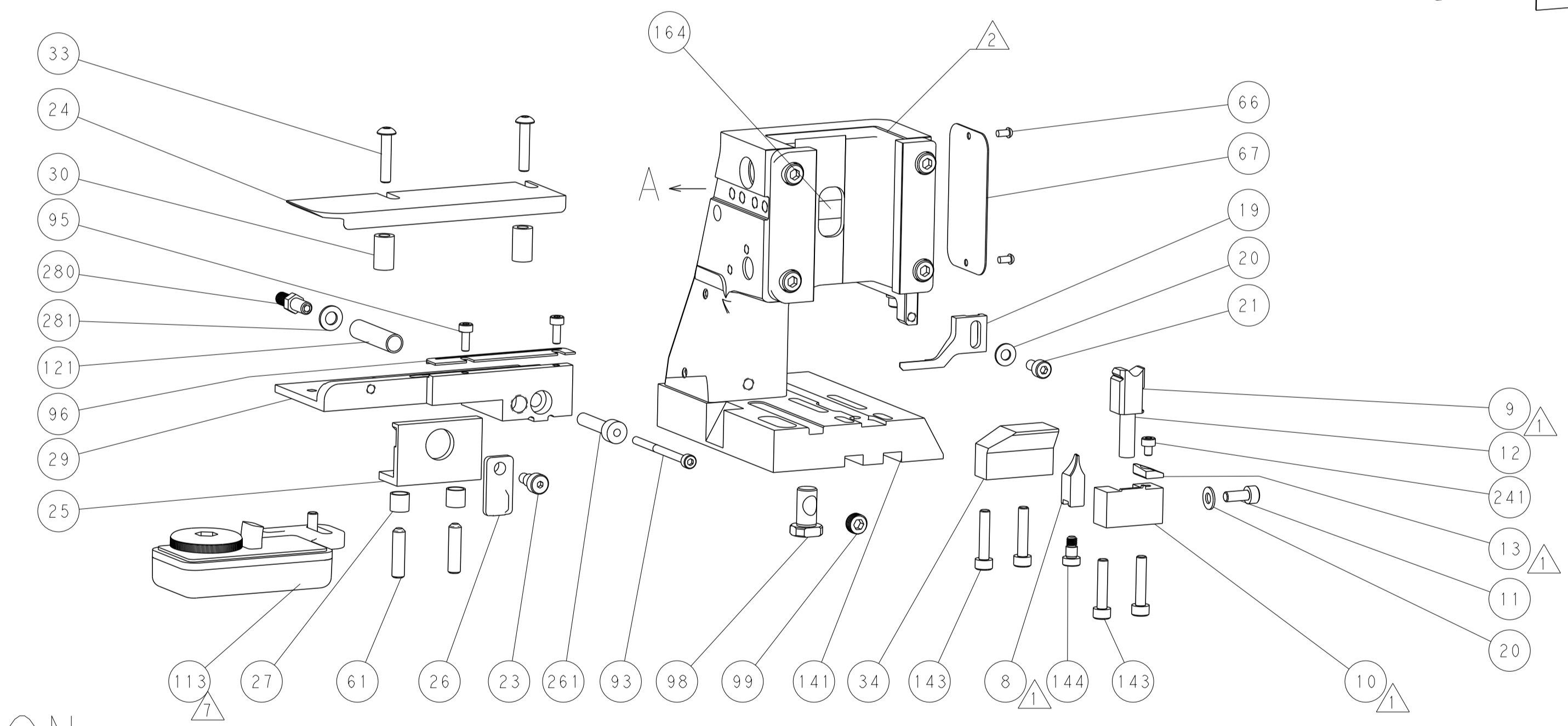
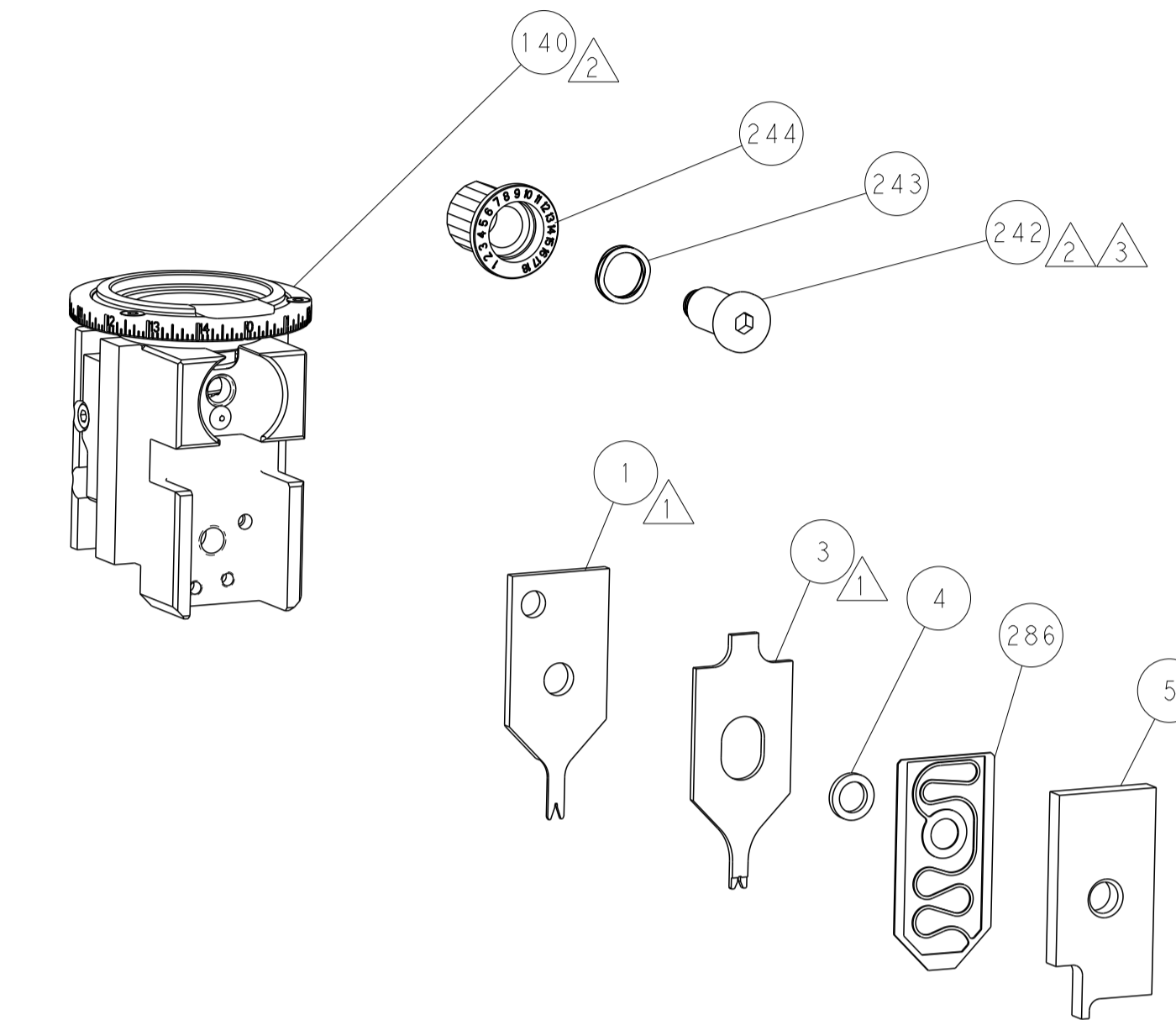
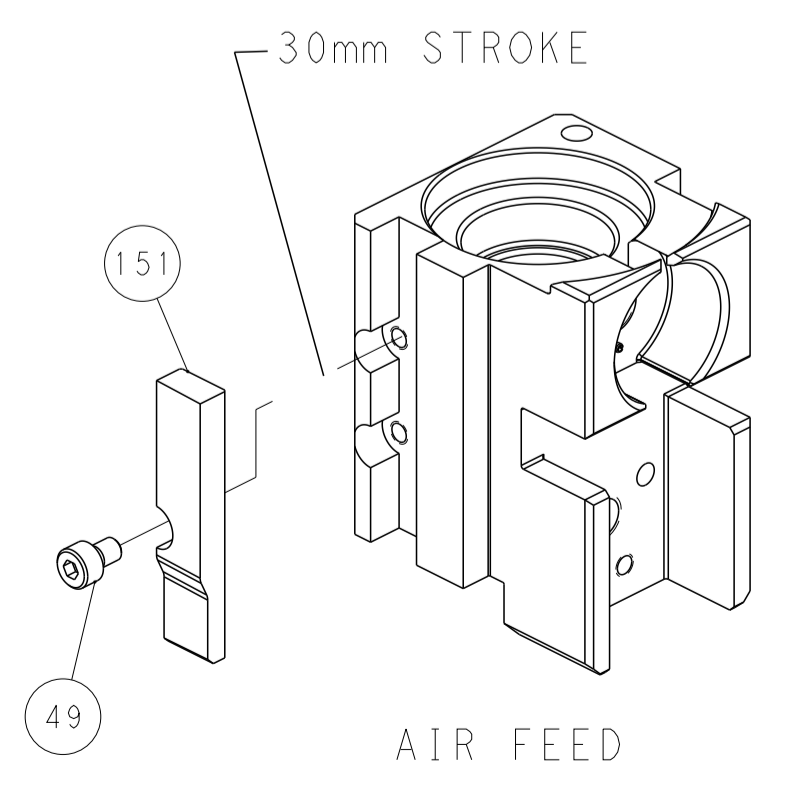
### FEED TYPE PNEUMATIC



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



### CAM POSITION



**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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DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH	PRODUCT SPEC APPLICATION SPEC SIZE CAGE CODE DRAWING NO A 00779 C=4151136
MATERIAL:		WEIGHT:	RESTRICTED TO:
Customer Accessible Production Drawing		SCALE 1:2	SHEET 4 OF 4 REV A