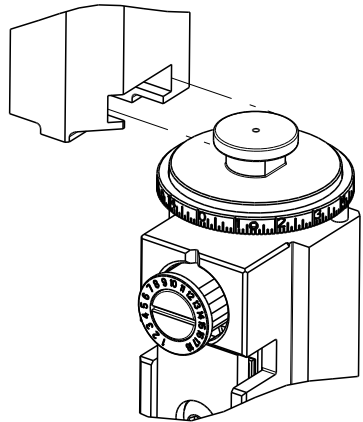
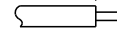


8	7	6	5	4	3	2	1
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE				
4151250-1	A	FINE CRIMP HEIGHT ADJUST	MECHANICAL				
4151250-2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC				
7-4151250-1	A	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL				
7-4151250-2	A	PNEUMATIC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

LOC	DIST	REVISONS				
		P	LTR	DESCRIPTION	DATE	DWN APVD
A	66		I	PRELIMINARY	25OCT2022	JWC TE
			A	RELEASED FOR PRODUCTION	07DEC2022	JWC JH

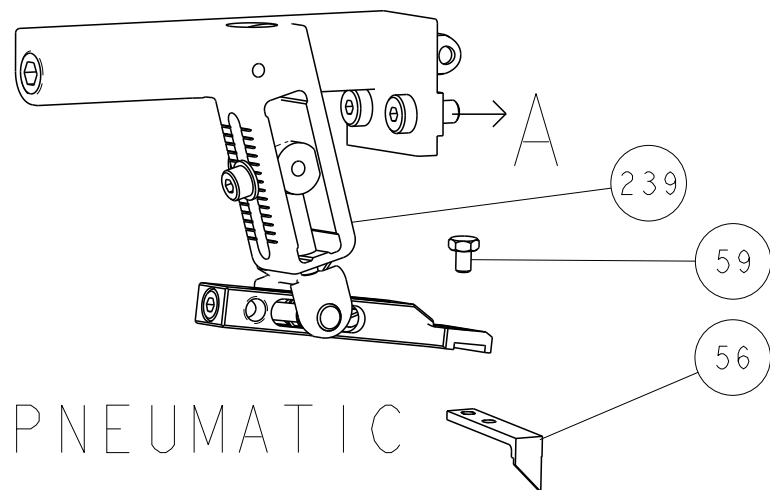
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	-	1	1	1	1	22278-9	SPRING, COMPRESSION	299
	-	2	2	2	2	4-18032-3	SCR, SET, FLT PNT, M3 X 6.0	298
	-	1	1	1	1	1803944-1	SPACER, TONKER	297
	-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248
	-	1	1	1	1	2119082-3	CAM, SNAIL, INSULATION ADJUSTMENT	244
	-	1	1	1	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 UNPUBLISHED. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. THE USER SHALL BE RESPONSIBLE FOR OBTAINING THE LATEST EDITION. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. THE USER SHALL BE RESPONSIBLE FOR OBTAINING THE LATEST EDITION.		DWN J. CALIMER 25OCT2022	TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm		CHK T. BROOKENS 25OCT2022	NAME OCEAN 2.0 Side Feed Applicator	
TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH ±		APVD T. ELBIN 25OCT2022	SIZE CAGE CODE DRAWING NO RESTRICTED TO	
MATERIAL -		PRODUCT SPEC -	00779 4151250	
		APPLICATION SPEC -	Customer Accessible Production Drawing	
		WEIGHT -	SCALE 1:2	
			SHEET 1 OF 4	
			REV A	

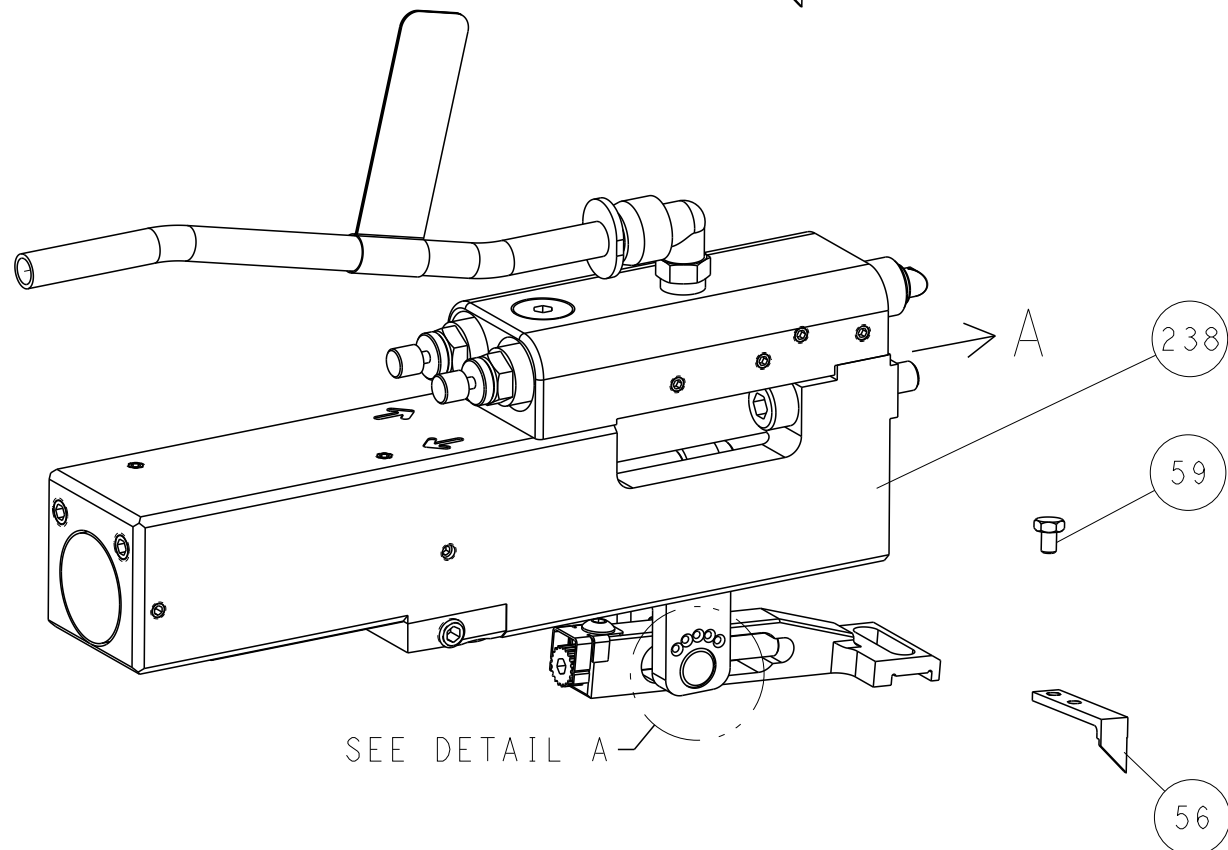
SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

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

FEED TYPE MECHANICAL

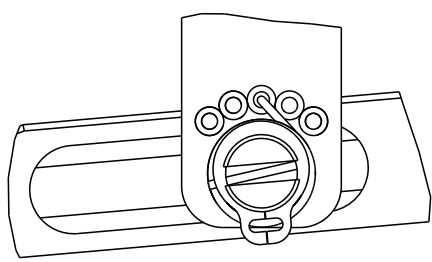


PNEUMATIC

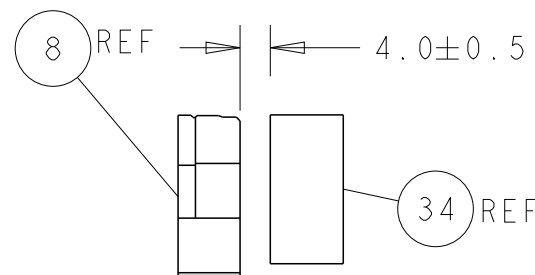
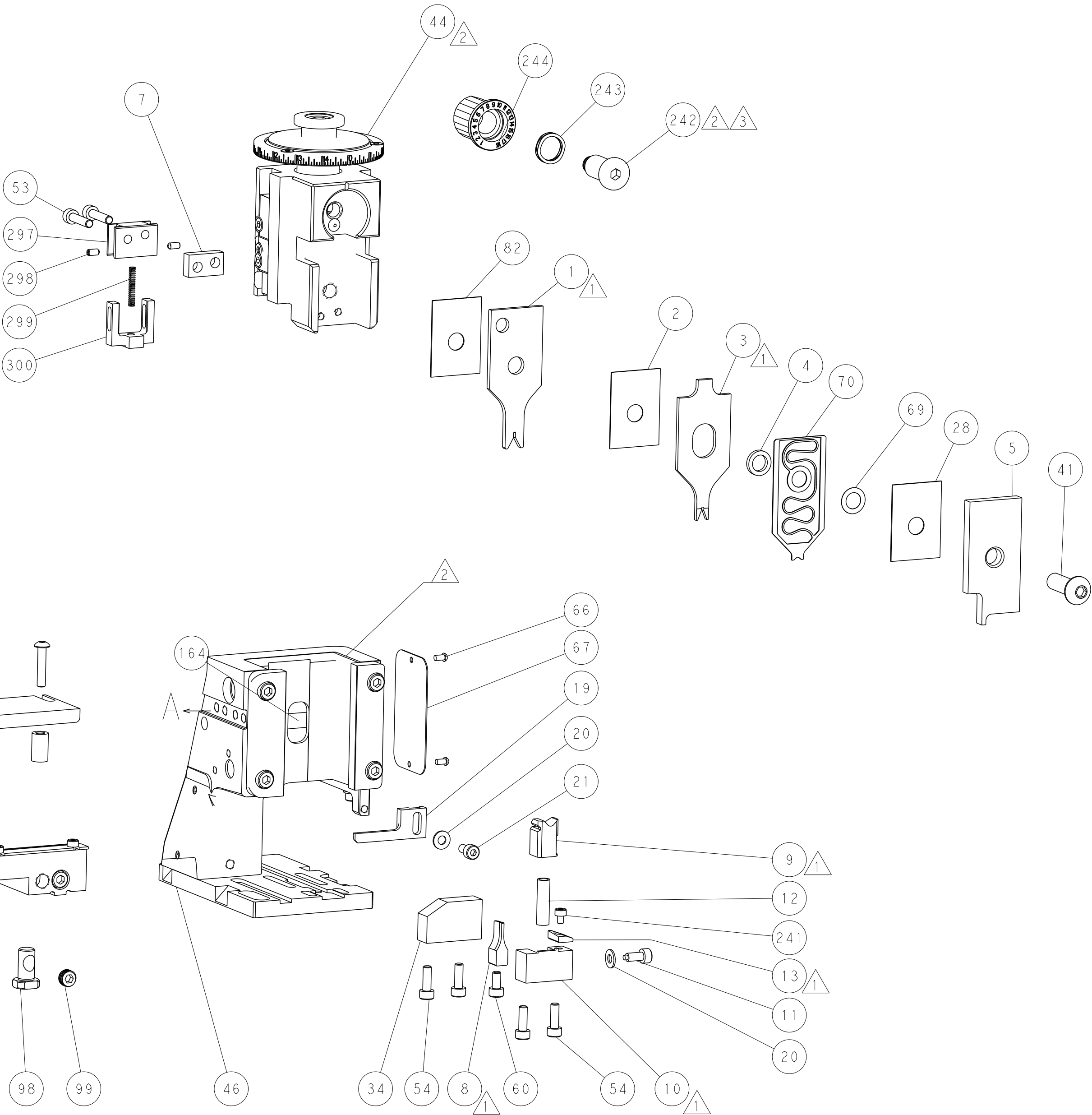


SEE DETAIL A

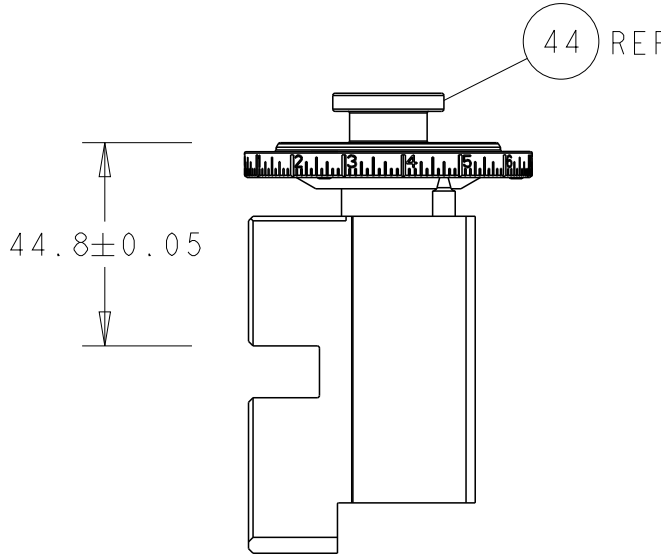
FEED SPRING SETTING POSITION
(SHOWN FROM REAR SIDE)



DETAIL A

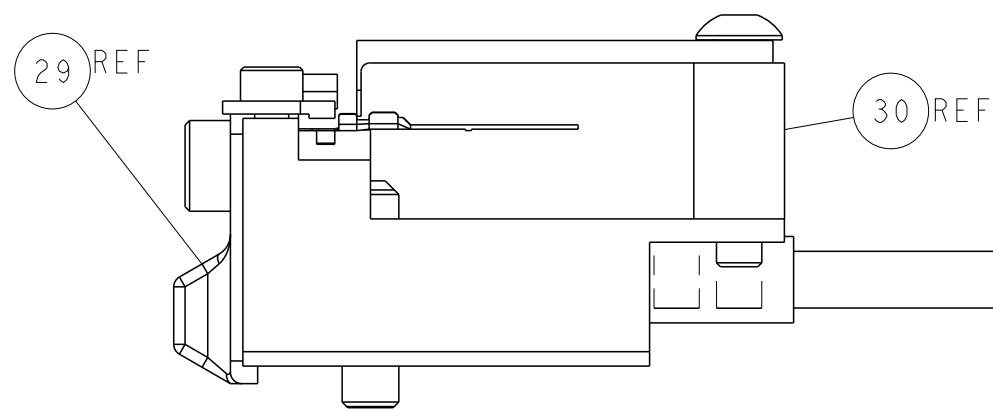


TERMINAL SUPPORT LOCATION



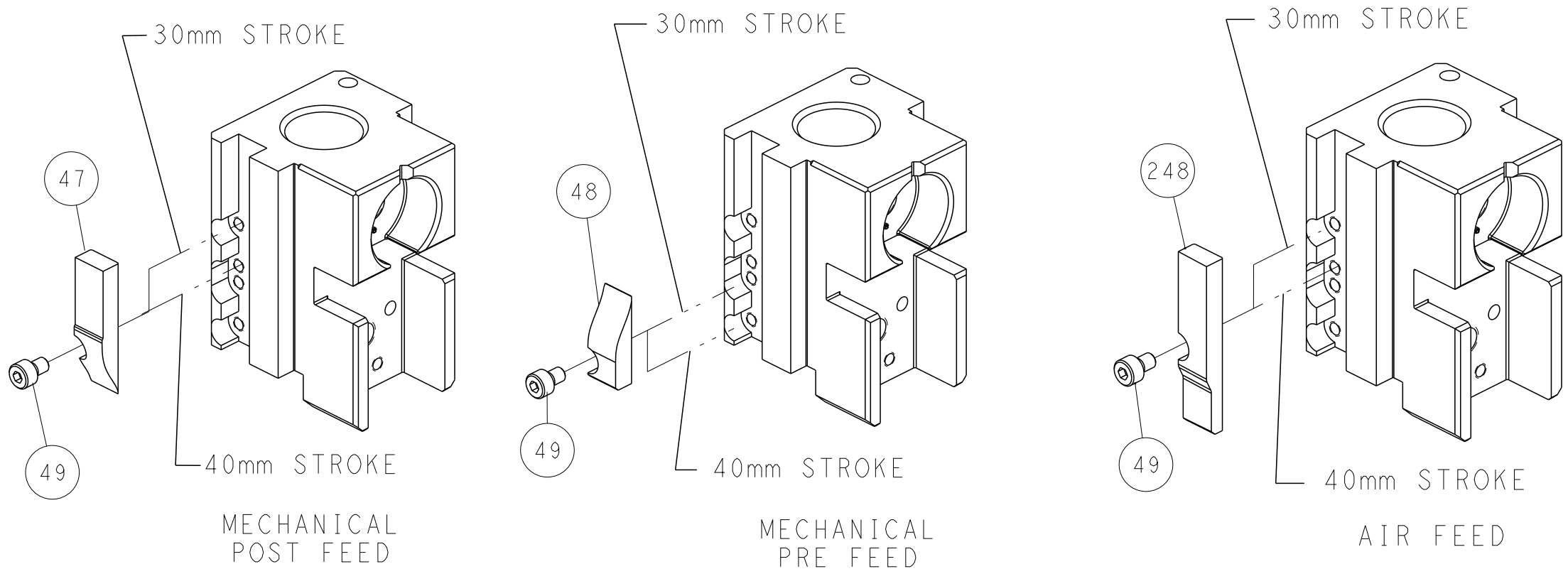
RAM SET-UP

ITEM 30 LOCATED AT
REAR HOLES



FEED TRACK POSITION
GUIDE BY INSULATION BARREL

CAM POSITIONS

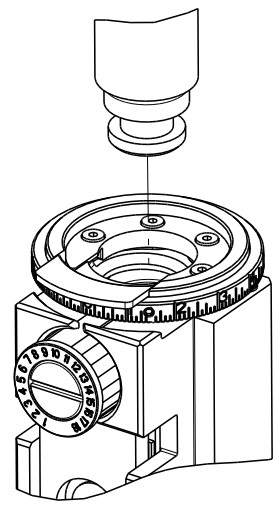


ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

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CHK				CHK	T. BROOKENS	25OCT2022	NAME	
APVD				APVD	T. ELBIN	25OCT2022	OCEAN 2.0 Side Feed Applicator	
PRODUCT SPEC				APPLICATION SPEC		SIZE		RESTRICTED TO
MATERIAL				WEIGHT		A 00779		REV
Customer Accessible Production Drawing				SCALE		1:2		REV
						SHEET 2 OF 4		REV

SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

8		7	
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20		20	
(C) 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	-



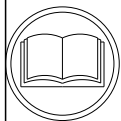
APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.02 mm [.040]	F
INSUL	1.27 mm [.050]	O

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	DRN	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	2119533-1	STRIPPER, SIDE FEED	19
A	-	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
I	1	1	1	1803858-8	CRIMPER, INSULATION O	3
	-	1	1	455888-4	SPACER, CRIMPER	2
I	1	1	1	9-1633713-0	CRIMPER, WIRE PREMIUM	1
	-77	-22	21	PART NO	DESCRIPTION	ITEM NO

THIS DRAWING IS A CONTROLLED DOCUMENT FOR THE APPLICATION OF THE QUALITY MANAGEMENT SYSTEM. IT IS THE PROPERTY OF THE COMPANY AND IS NOT TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, WITHOUT THE WRITTEN PERMISSION OF THE COMPANY.		OWN: 250C12022 CALIMER		 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 Side Feed Applicator -	
		APD: 250C12022 T. ELBIN PRODUCT SPEC APPLICATION SPEC		SIZE: A CAGE CODE: 00779 DRAWING NO: 4151250 RESTRICTED TO: -	
MATERIAL: -		WEIGHT: -		SCALE: 1:2 SHEET: 3 of 4 REV: A	
Customer Accessible Production Drawing					

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

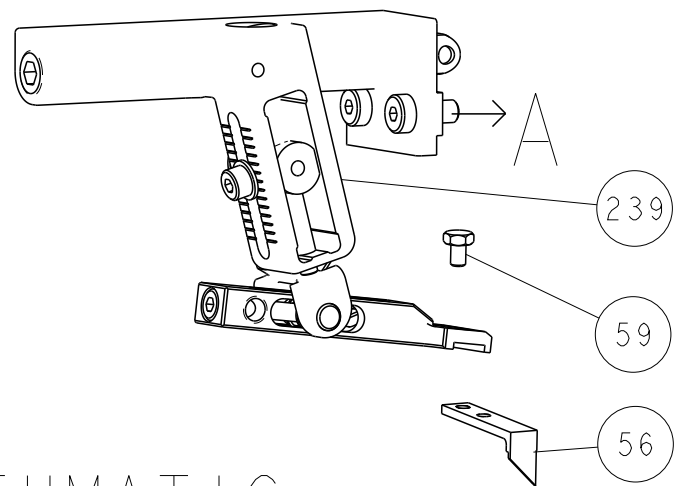
AMP 4805 REV 31MAR2000

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

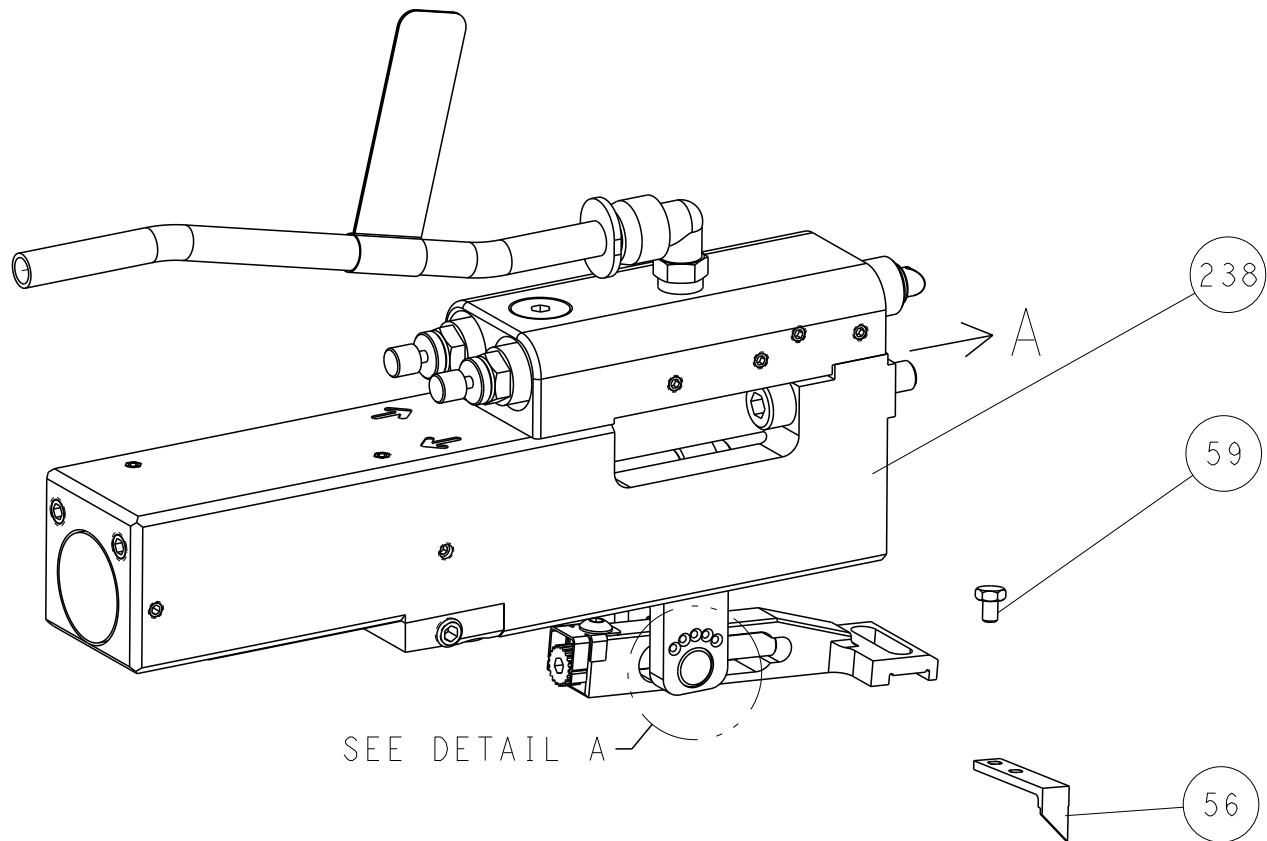
LOC	DIST	REVISIONS					
		P	LTR	DESCRIPTION	DATE	DWN	APVD
A	66	-	-	SEE SHEET 1	-	-	-

FEED TYPE

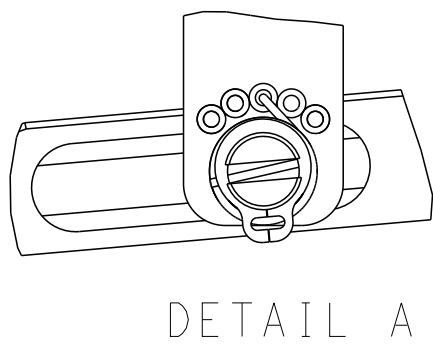
MECHANICAL



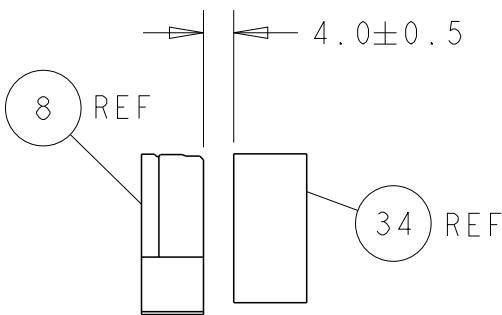
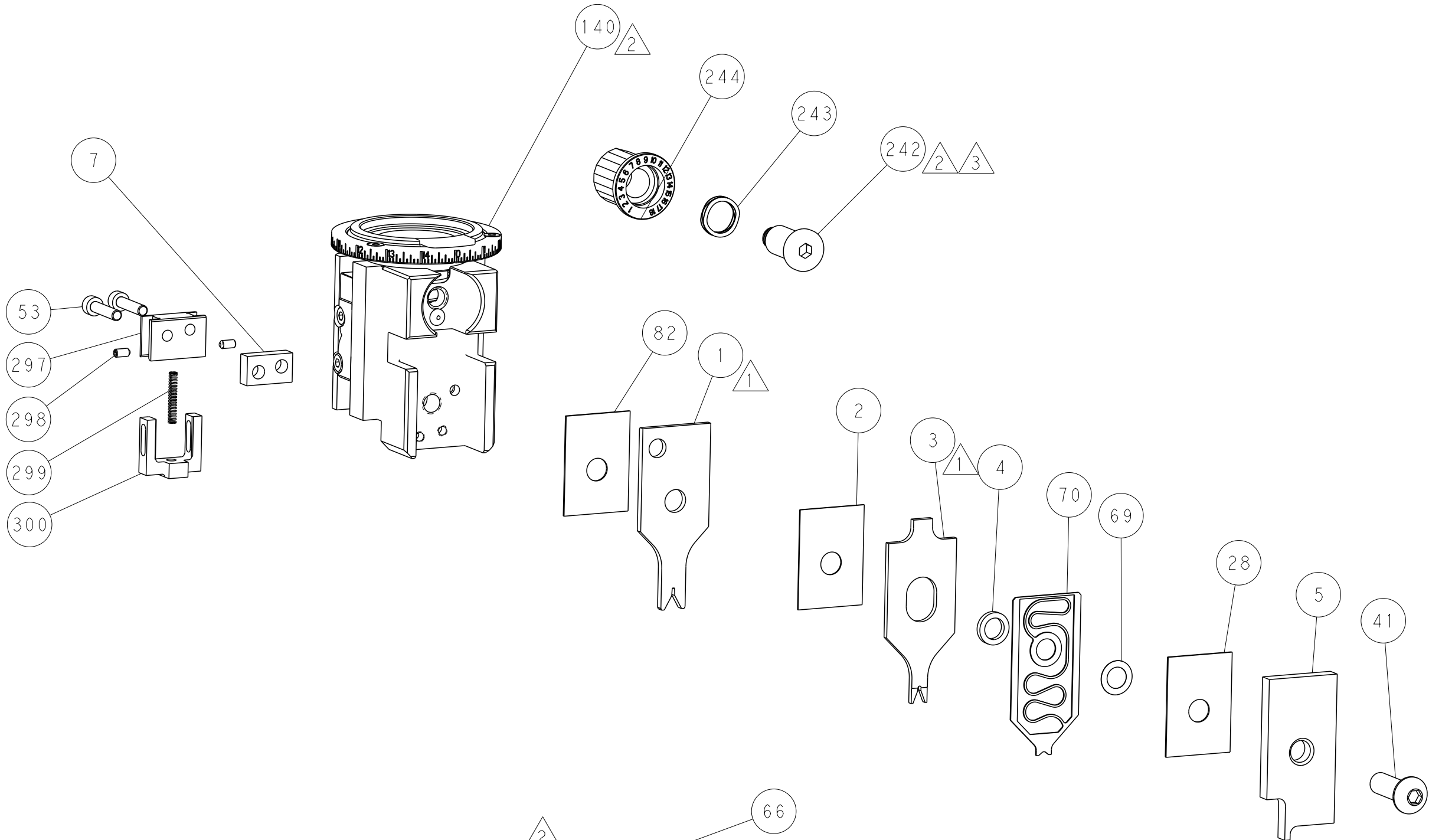
PNEUMATIC



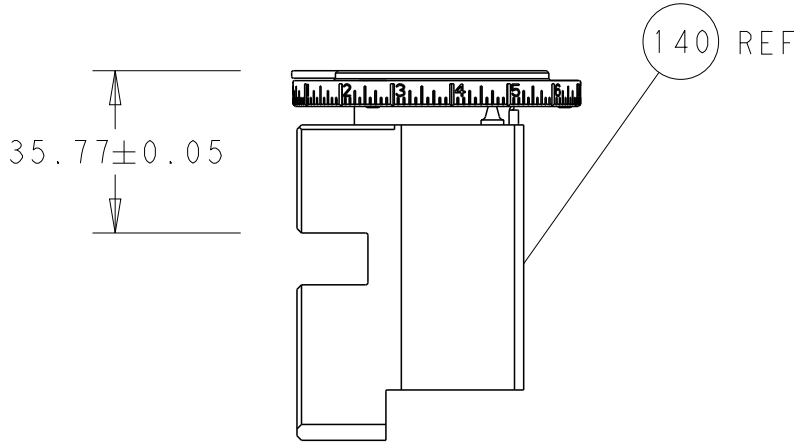
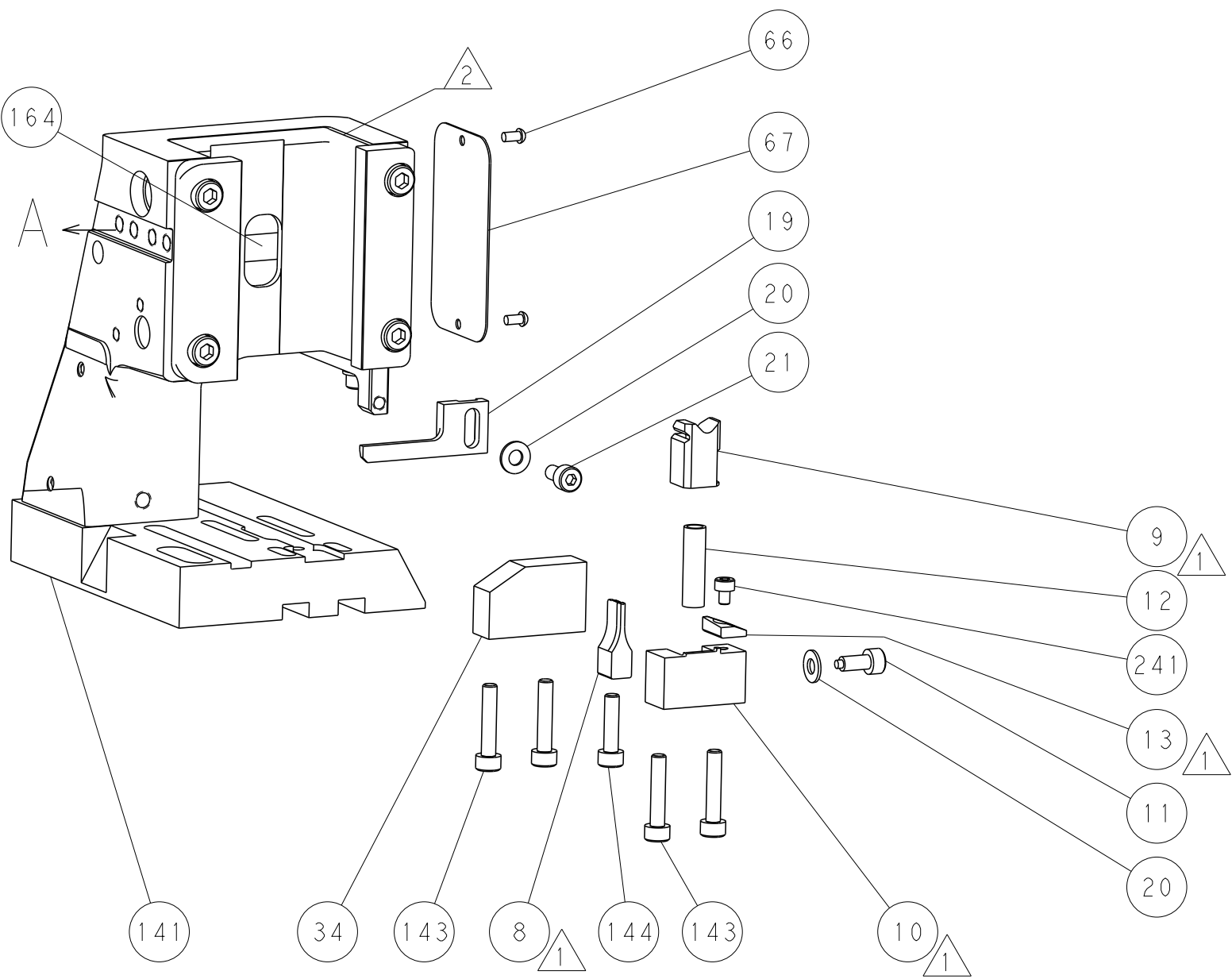
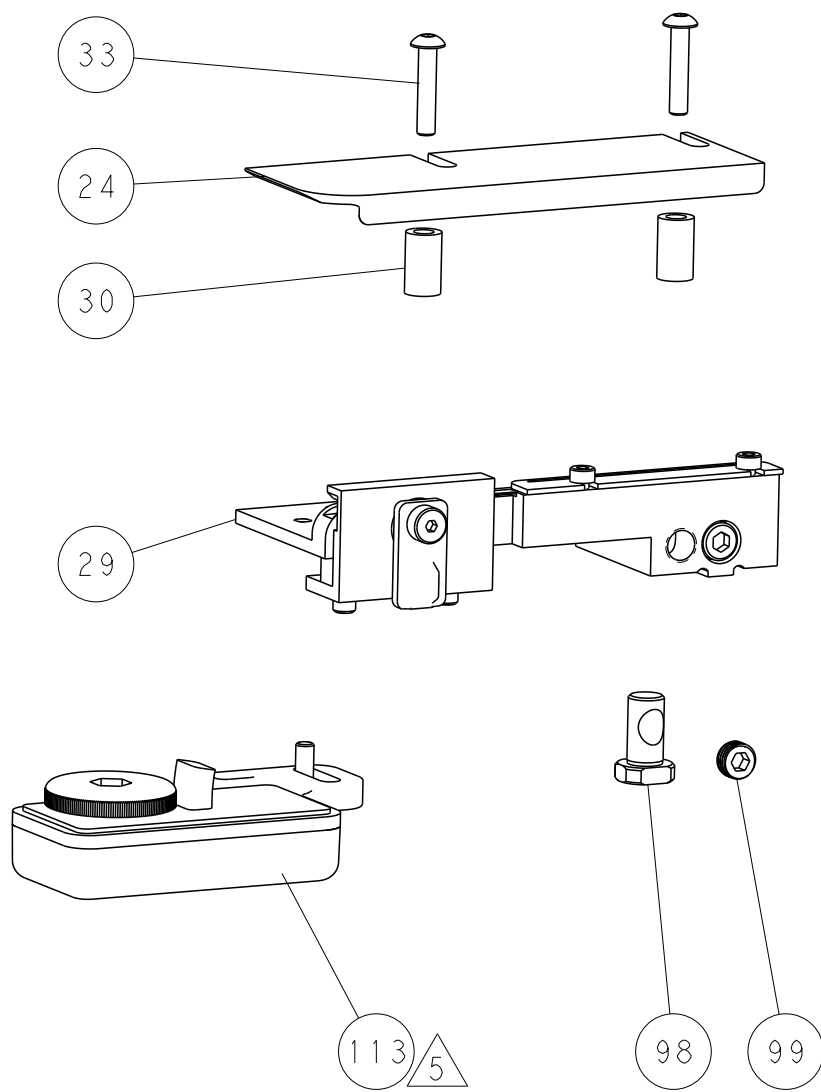
FEED SPRING SETTING POSITION
(SHOWN FROM REAR SIDE)



DETAIL A

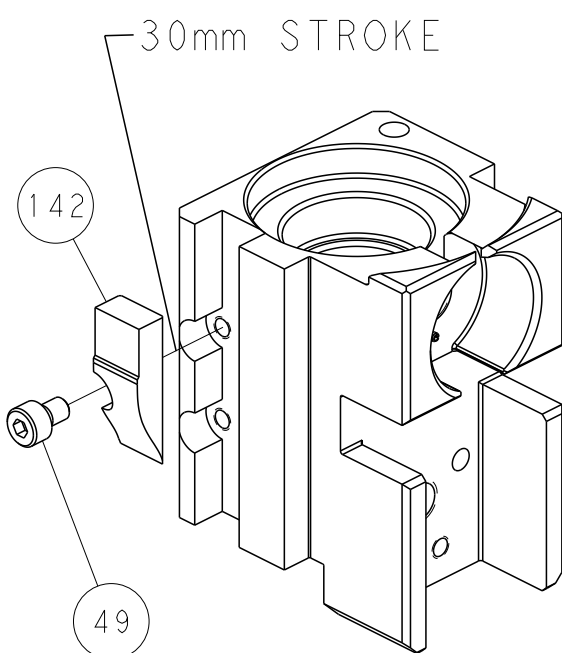


TERMINAL SUPPORT LOCATION

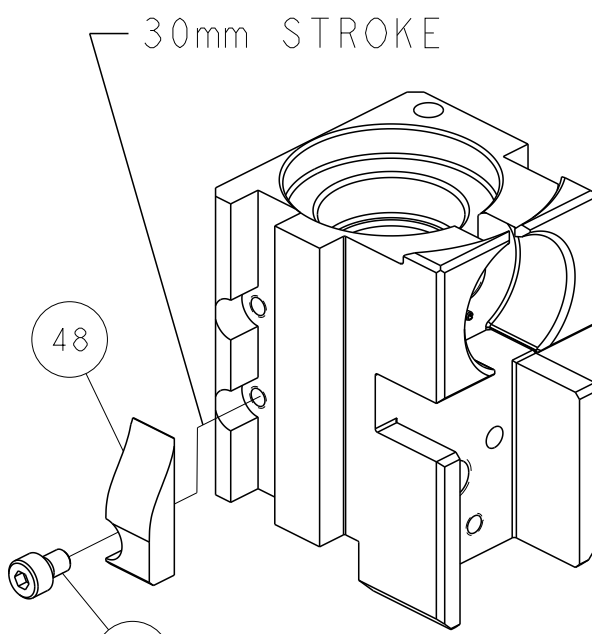


RAM SET-UP

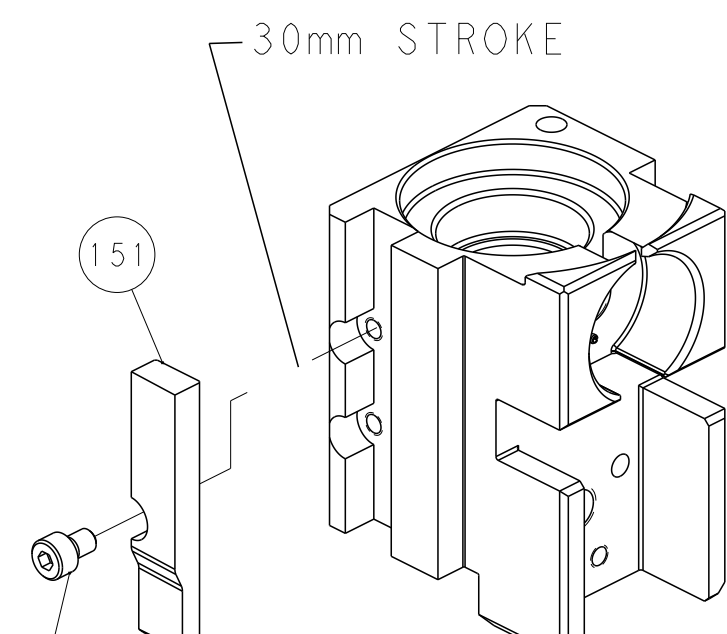
CAM POSITIONS



MECHANICAL
POST FEED

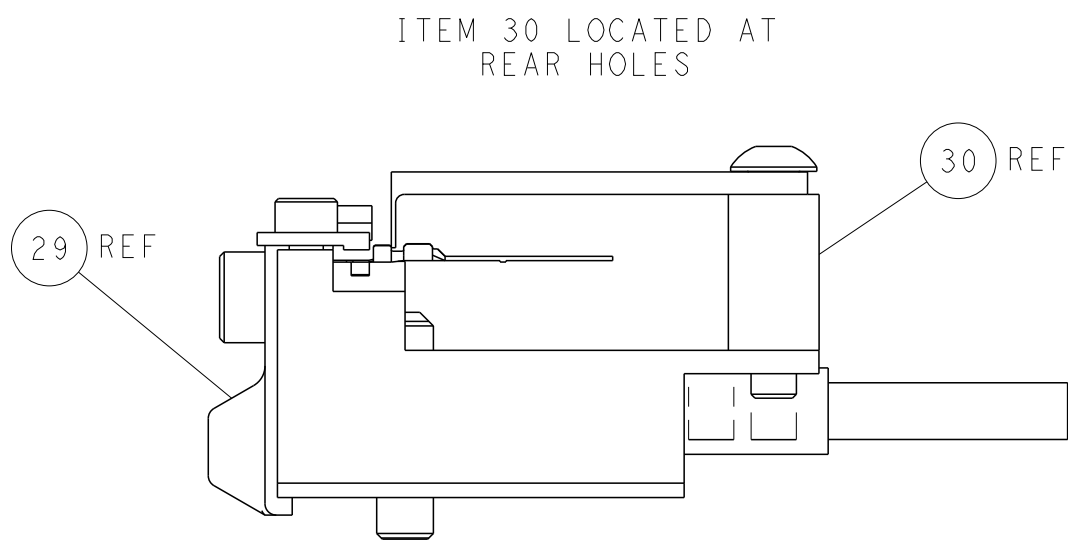


MECHANICAL
PRE FEED



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

THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION IT IS SUBJECT TO COMPANY'S POLICY ON CONTROLLING AND ENGINEERING ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST EDITION.				DWN	J. CALIMER	25OCT2022	 TE Connectivity Harrisburg, PA 17105-3608				
				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		
				A	00779		C=4151250		-		
				Customer Accessible Production Drawing						SCALE	1:2
										SHEET	4 of 4
										REV	A

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

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