

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
4151114-1	A	FINE CRIMP HEIGHT ADJUST	MECHANICAL
4151114-2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-4151114-1	A	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-4151114-2	A	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-4151114-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.70 mm [.067]	F
INSUL	2.10 mm [.083]	O

APPLICATOR INSTRUCTIONS
408-35042

TERMINAL DATA: JST TERMINAL		JST CRIMP SPECIFICATION	
TERMINAL NAME: ZRO CONNECTOR			
WIRE STRIP LENGTH		TERMINAL INSULATION DIAMETER RANGE	
3.80-4.20 mm [.150-.165 IN]		Ø1.60-1.90 mm [.063-.075 IN]	
TERMINAL APPLICATION SPECIFICATION	CHM-1-2474 Rev R2		AT9106
TERMINALS APPLIED			
TE TERMINAL	JST TERMINAL	TE TERMINAL	JST TERMINAL
3311846-1	SZRO-A031T-M0.64		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.75mm ² or 0.85mm ²	1.10+/-0.05 [.043+/- .002]	7.4

- 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 UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT 101-35000.
- 6 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)

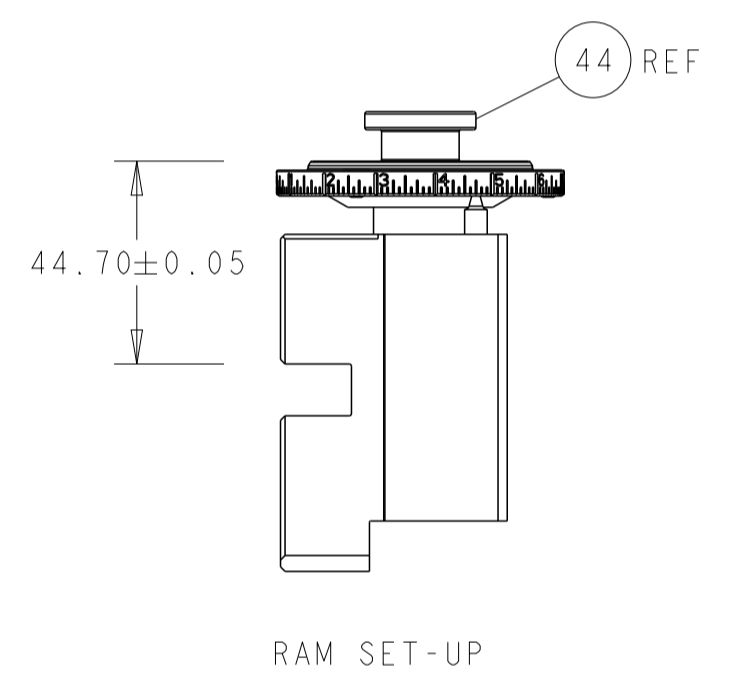
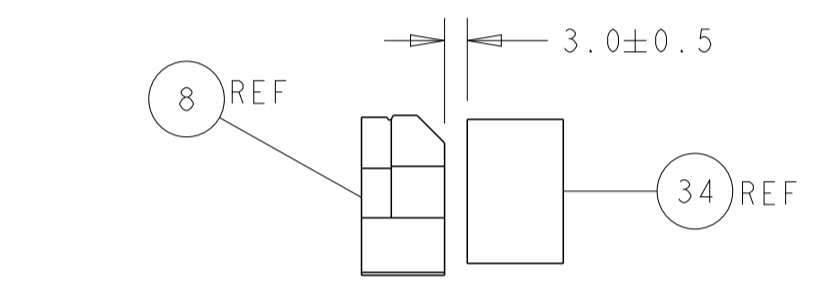
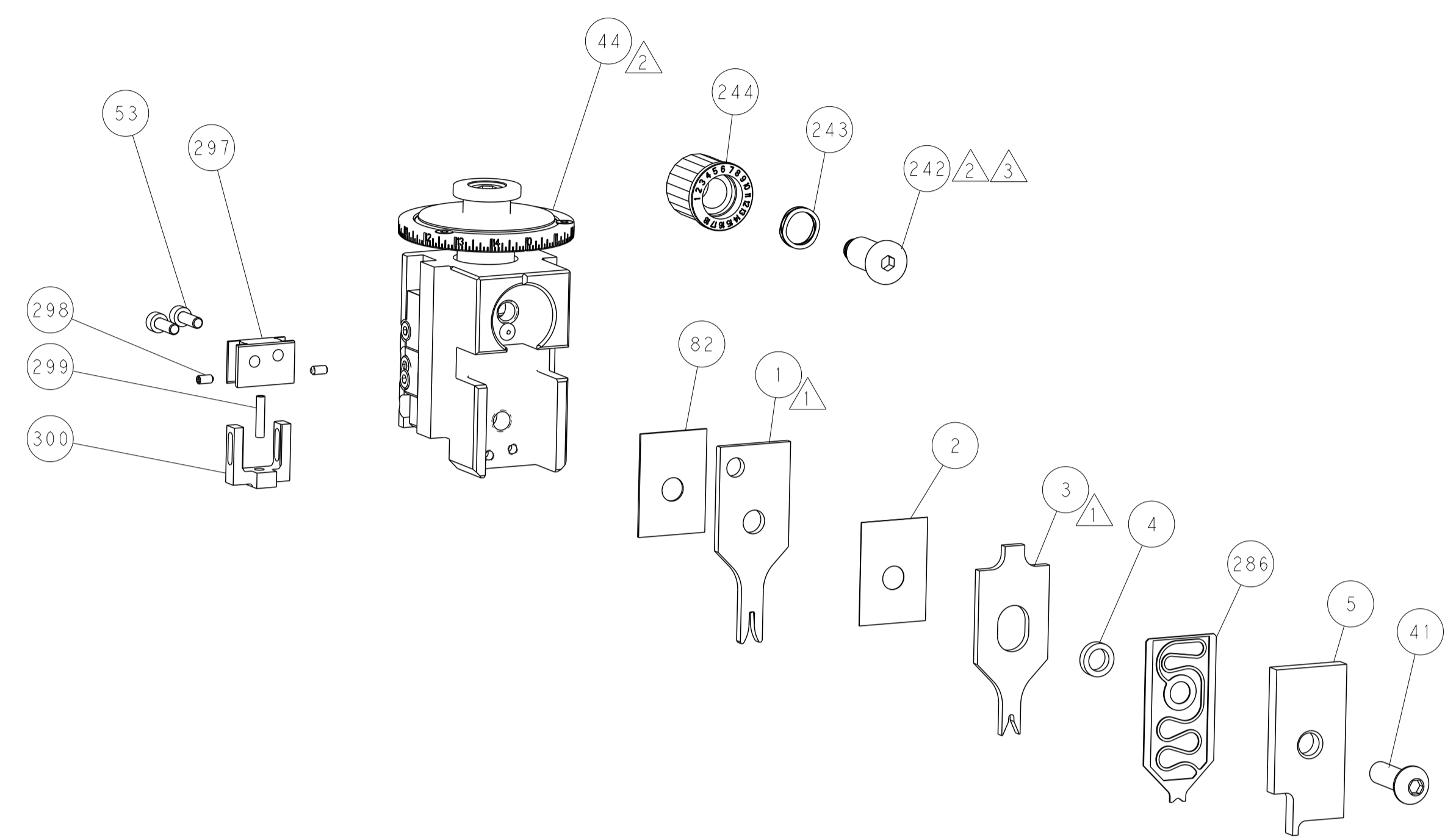
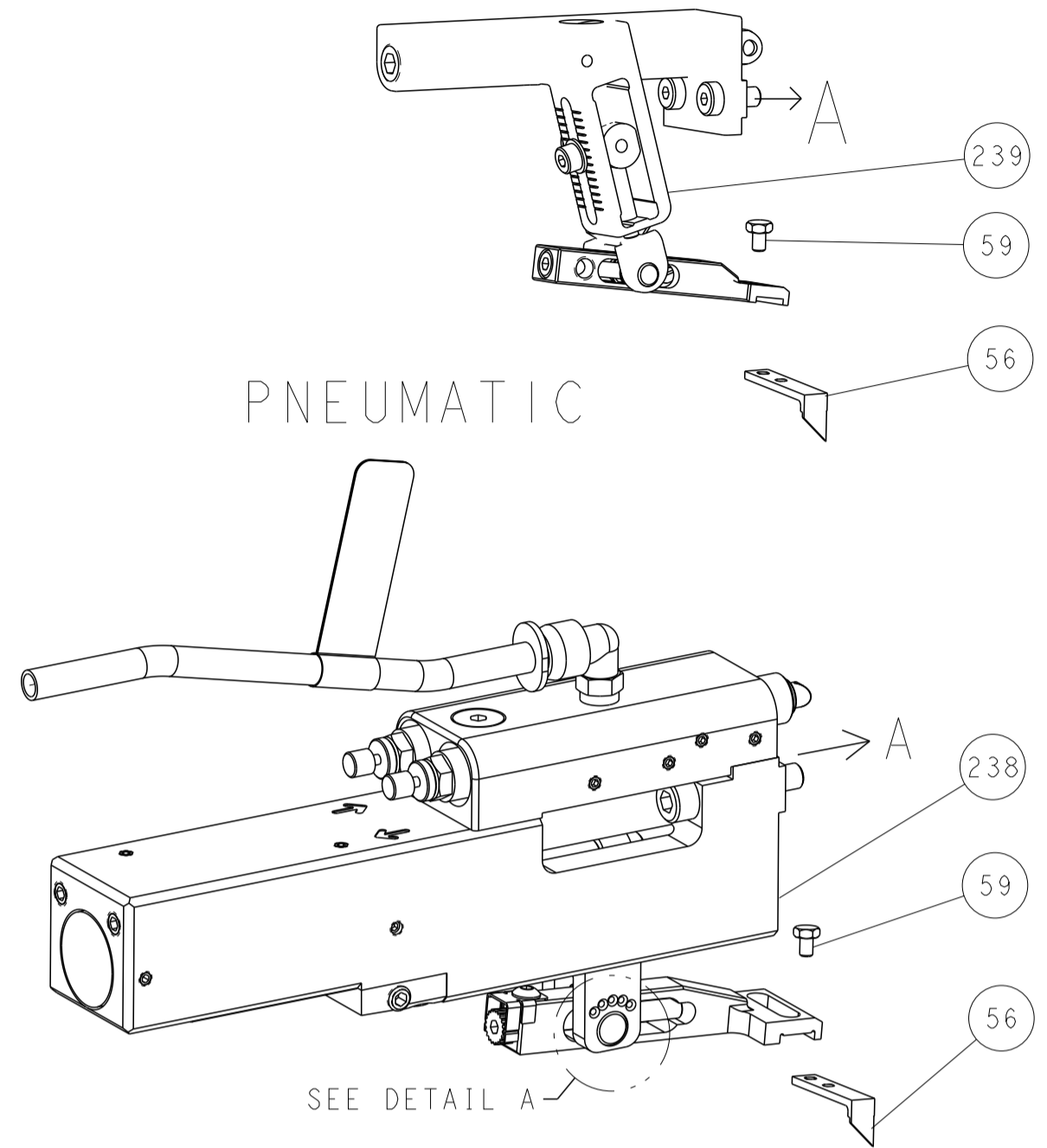
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		1		DEVELOPMENT	02DEC2021	TB	TE
		A		RELEASED	06JAN2022	TB	TE

-	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	1	1	2119791-6	DEPRESSOR, WIRE	286	
-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248	
-	1	1	1	1	2119082-5	CAM, SNAIL, INSULATION ADJUSTMENT	244	
-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243	
3	-	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	
6	-	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	455888-6	SPACER, CRIMPER	82	
-	1	1	1	1	1803607-3	DOCUMENTATION PACKAGE	71	
-	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	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	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	1752356-6	SUPPORT, TERMINAL	34	
-	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33	
-	2	2	2	2	2-2844962-7	SPACER, CYLINDRICAL, STRIP GUIDE	30	
-	1	1	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29	
-	1	1	1	1	1320928-2	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	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	2119805-1	SHEAR HOLDER, FRONT	10	
1	-	1	1	1	1803095-6	FLOATING SHEAR, FRONT	9	
1	1	2	2	1	1	7-1803764-1	ANVIL, COMBINATION	8
-	-	-	-	-	-	-	7	
-	-	-	-	-	-	-	6	
-	1	1	1	1	2119757-3	DEPRESSOR, SHEAR	5	
-	1	1	1	1	4-238011-0	BLOCK, CRIMPER SPACER	4	
1	1	2	2	1	1	8-1633966-3	CRIMPER, INSULATION O	3
-	1	1	1	1	455888-1	SPACER, CRIMPER	2	
1	1	2	2	1	1	7-568176-7	CRIMPER, WIRE	1
-	77	-72	-71	-2	-1	PART NO		
-						DESCRIPTION	ITEM NO	

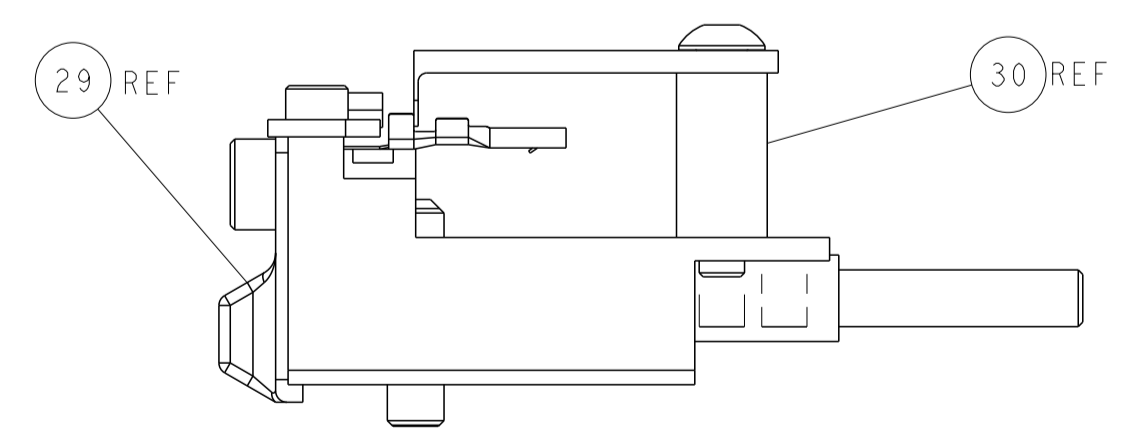
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mm	0 PLC ±	1 PLC ±	2 PLC ±	CHK	M. HERR	02DEC2021	
	3 PLC ±	4 PLC ±	ANGLES ±	APVD	T. ELBIN	02DEC2021	NAME
	FINISH						OCEAN 2.0 Side Feed Applicator
MATERIAL				APPLICATION SPEC			SIZE
							CAGE CODE
				WEIGHT			DRAWING NO
							00779
							DRAWING NO
							4151114
							RESTRICTED TO
							Customer Accessible Production Drawing
							SCALE
							1:2
							SHEET
							1 of 4
							REV
							A

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

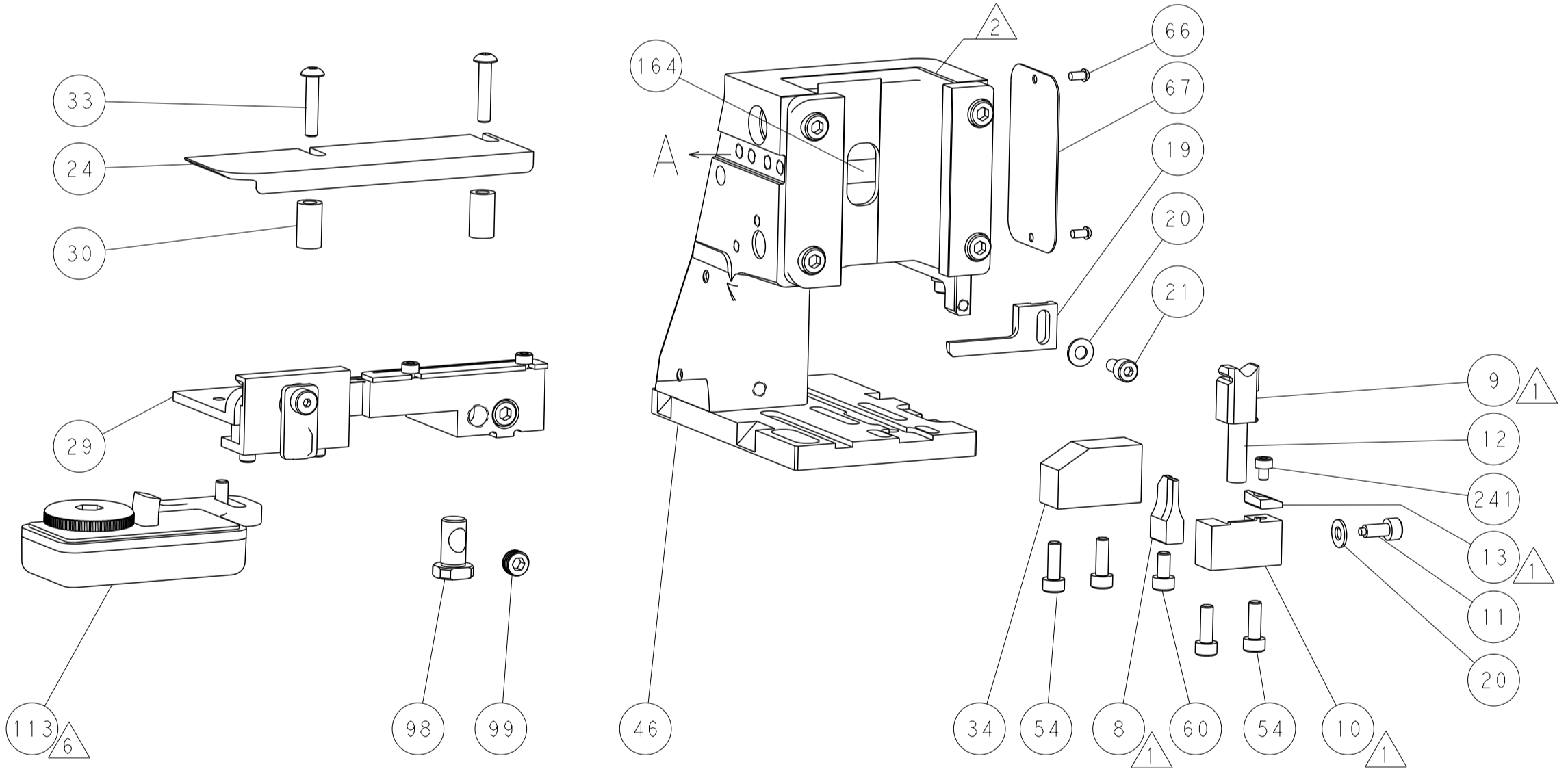
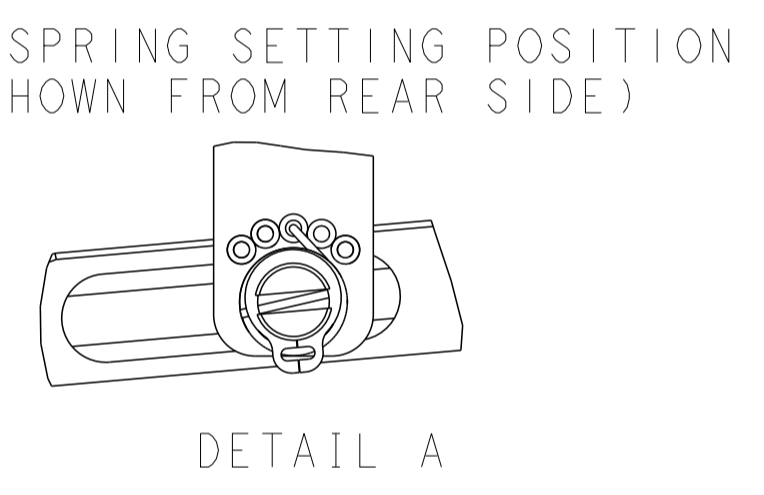
FEED TYPE MECHANICAL



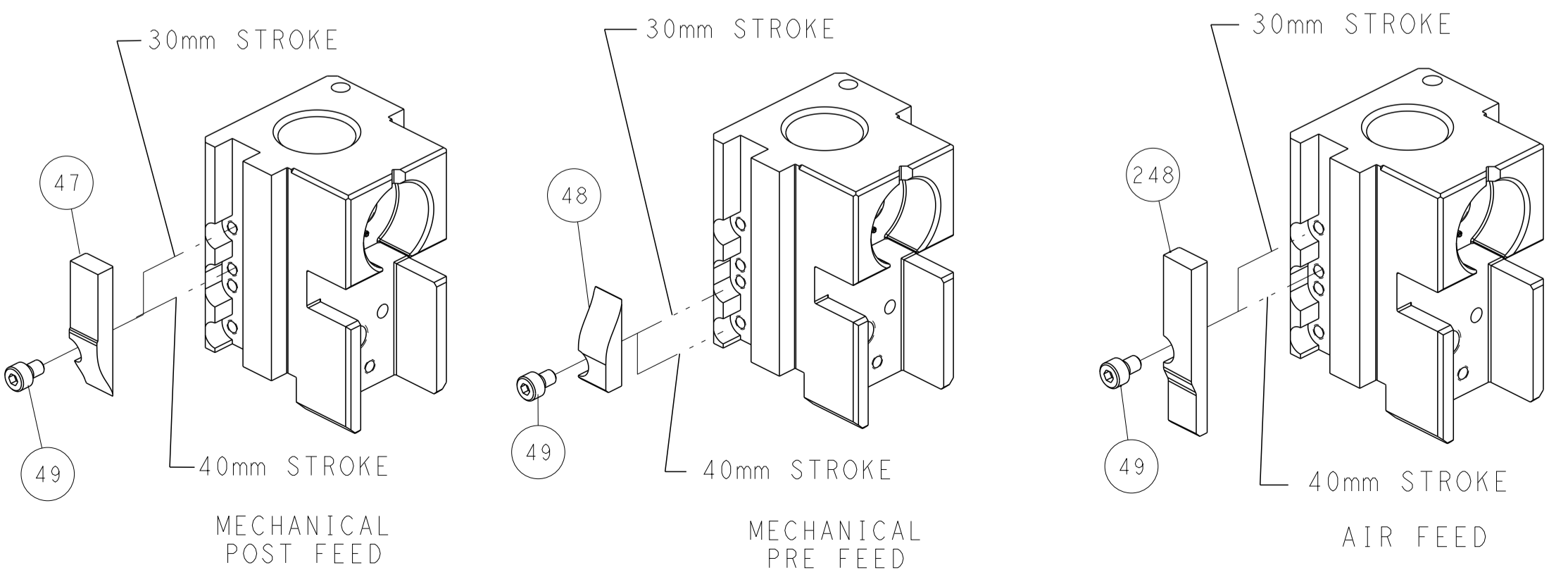
ITEM 30 LOCATED AT FRONT HOLES



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:		DWN T. BROOKS 02DEC2021		TE Connectivity	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	Harrisburg, PA 17105-3608	
MATERIAL:		FINISH:		CHK M. HERR 02DEC2021		NAME	
				APVD T. ELBIN 02DEC2021		OCEAN 2.0 Side Feed Applicator	
				PRODUCT SPEC		SIZE CAGE CODE DRAWING NO	
				APPLICATION SPEC		A1 00779 C=4151114	
				WEIGHT		RESTRICTED TO	
				Customer Accessible Production Drawing		SCALE 1:2 SHEET 2 OF 4 REV A	

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-4151114-1	A	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-4151114-2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-4151114-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
 INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.70 mm [.067]	F
INSUL	2.10 mm [.083]	O
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: JST TERMINAL JST CRIMP SPECIFICATION	
TERMINAL NAME: ZRO CONNECTOR	
WIRE STRIP LENGTH 3.80-4.20 mm [1.50-1.65 IN]	TERMINAL INSULATION DIAMETER RANGE Ø1.60-1.90 mm [.063-.075 IN]
TERMINAL APPLICATION SPECIFICATION CHM-1-2474 Rev R2	AT9106
TERMINALS APPLIED	
TE TERMINAL 3311846-1	JST TERMINAL SZRO-A031T-M0.64

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.75mm ² or 0.85mm ²	1.10 +/- 0.05 [.043 +/- .002]	7.4

- 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. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT 101-35000.
- 6. 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.

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

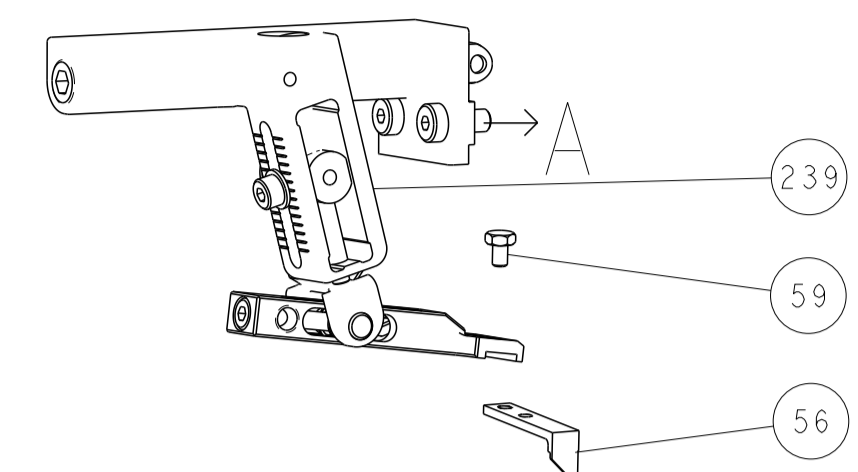
LOC	DIST	REVISIONS					
		P	LTN	DESCRIPTION	DATE	OWN	APVD
A	66	-	-	SEE SHEET 1	-	-	-

-	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	2119791-6	DEPRESSOR, WIRE	286
-	1	1	2119082-5	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	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
-	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	455888-6	SPACER, CRIMPER	82
-	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
-	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	1	1	1338685-1	PAWL, FEED	56
-	2	2	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	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	1752356-6	SUPPORT, TERMINAL	34
-	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	2-2844962-7	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29
-	1	1	1320928-2	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	7-1803764-1	ANVIL, COMBINATION	8
-	-	-	-	-	7
-	-	-	-	-	6
-	1	1	2119757-3	DEPRESSOR, SHEAR	5
-	1	1	4-238011-0	BLOCK, CRIMPER SPACER	4
-	1	1	8-1633966-3	CRIMPER, INSULATION O	3
-	1	1	455888-1	SPACER, CRIMPER	2
-	1	1	7-568176-7	CRIMPER, WIRE	1

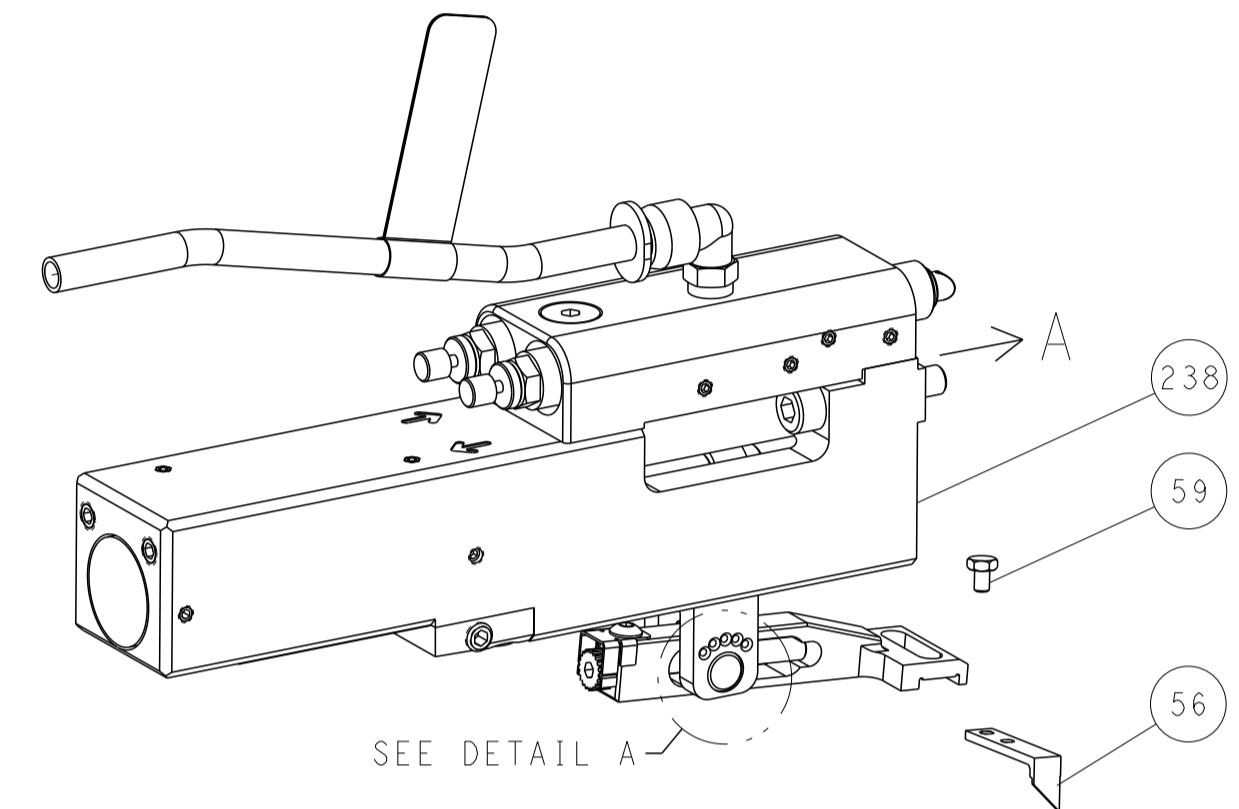
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0 PLC ±		1 PLC ±		2 PLC ±		3 PLC ±		4 PLC ±		RESTRICTED TO	
MATERIAL: -		FINISH: -		WEIGHT: -		SCALE: 1:2		SHEET 3 OF 4		REV A	

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

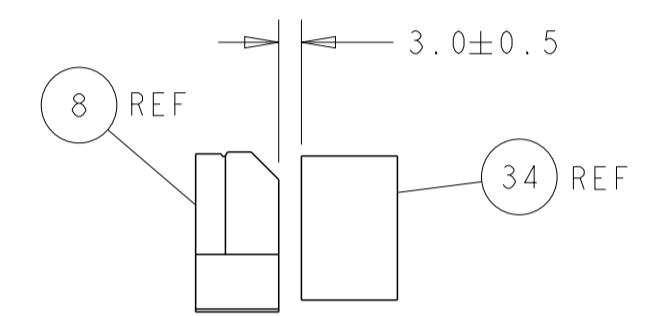
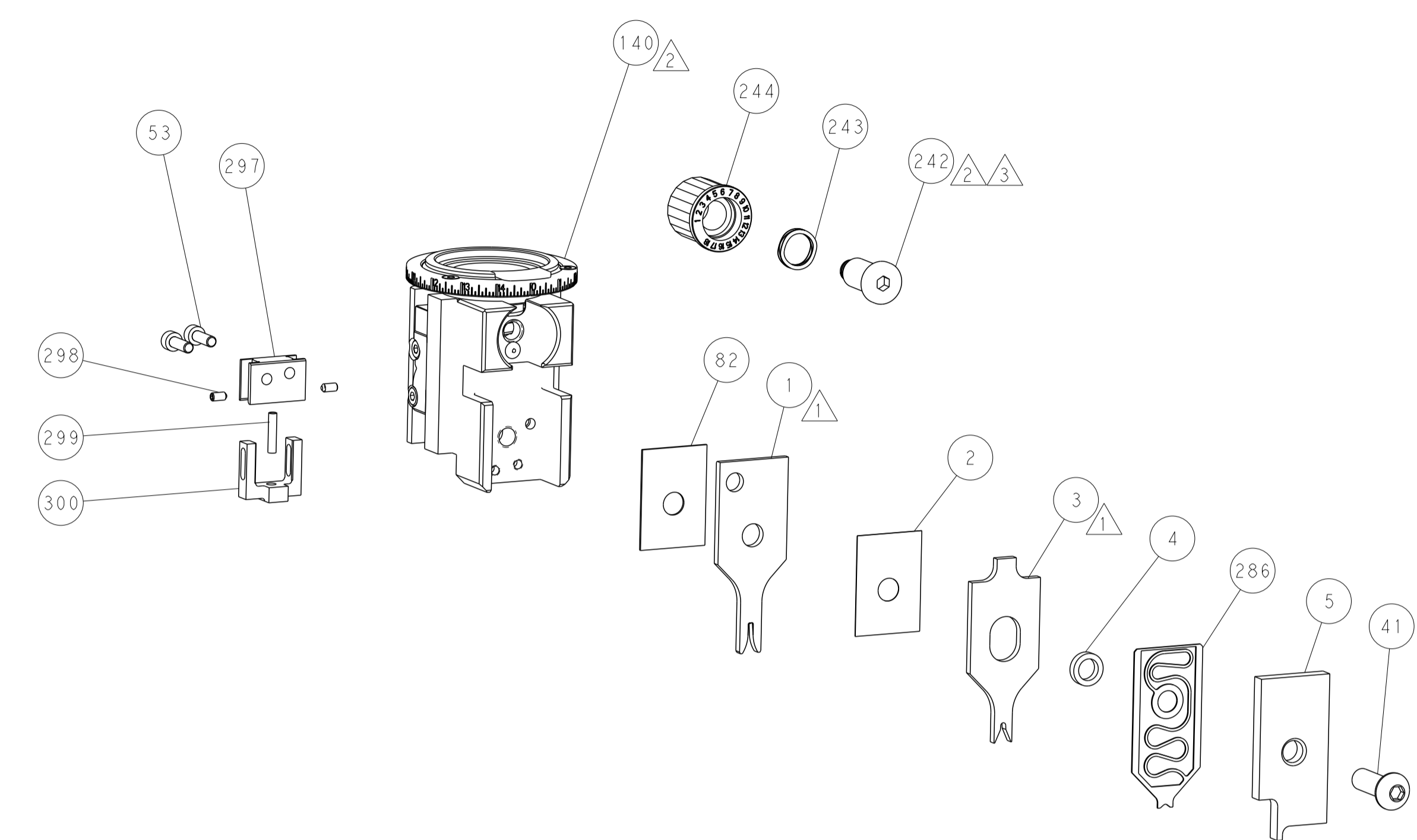
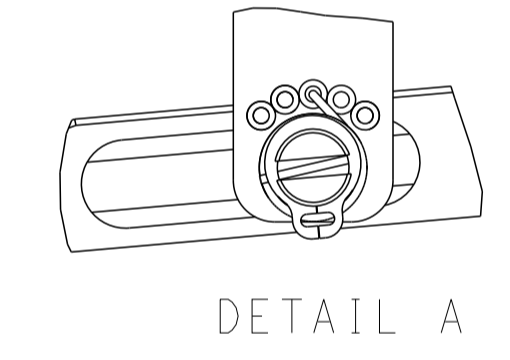
FEED TYPE MECHANICAL



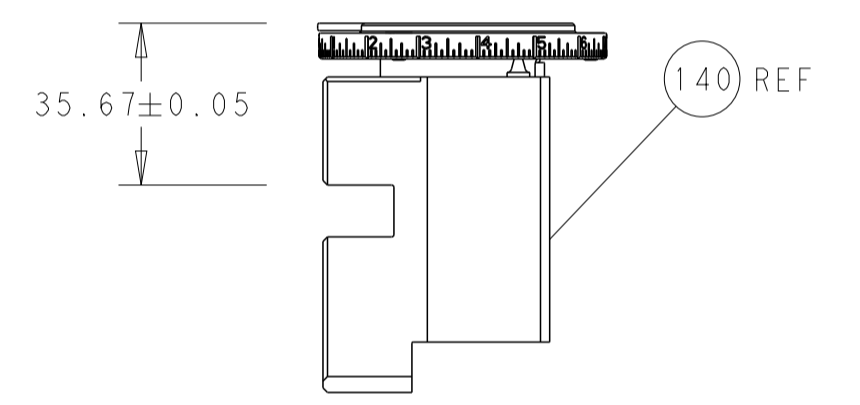
PNEUMATIC



FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)

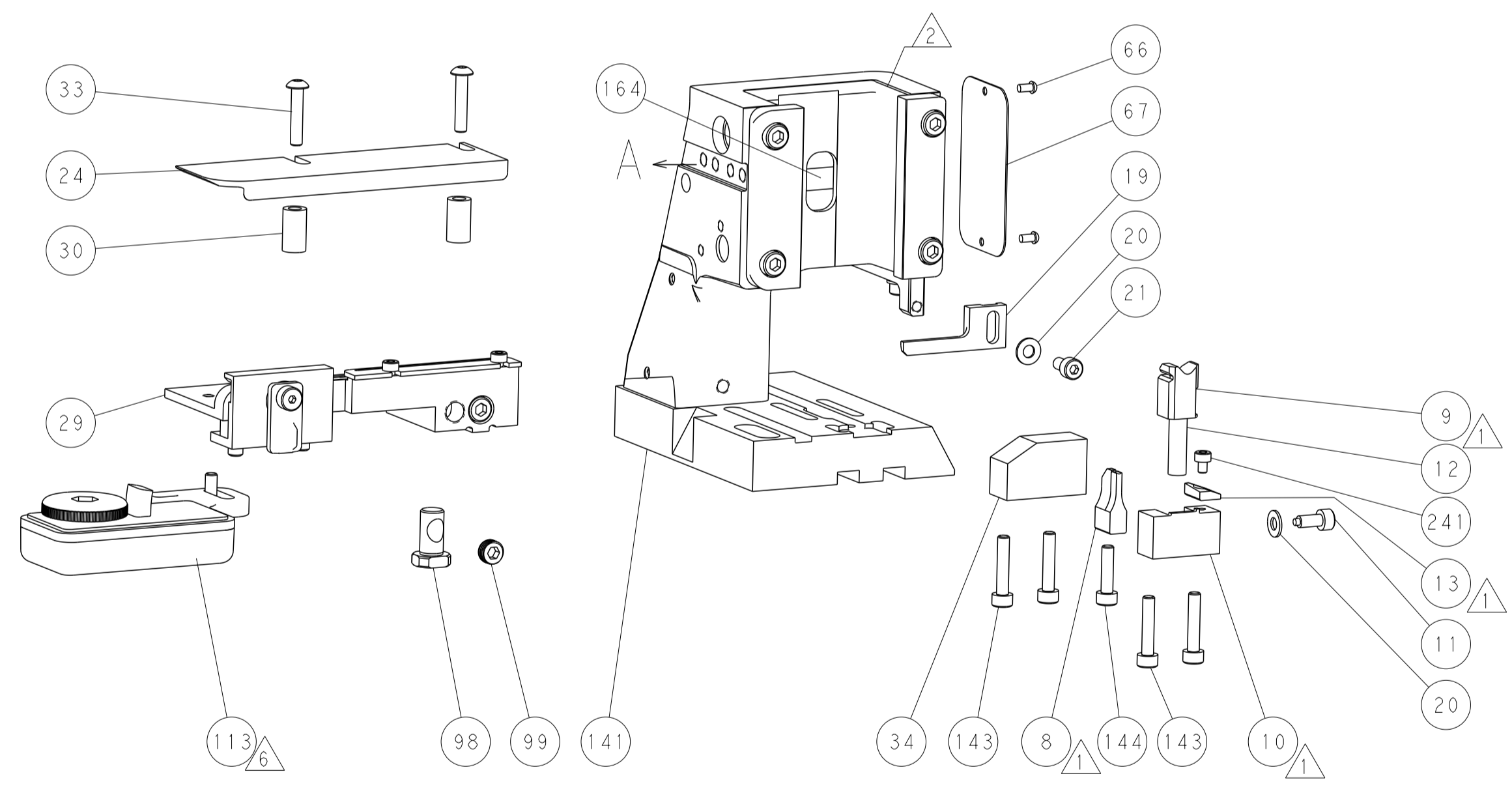


TERMINAL SUPPORT LOCATION

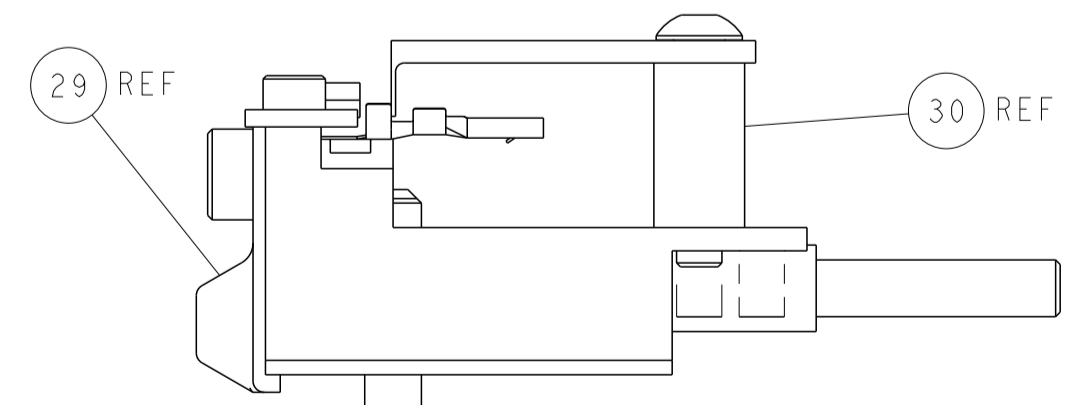


RAM SET-UP

FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)

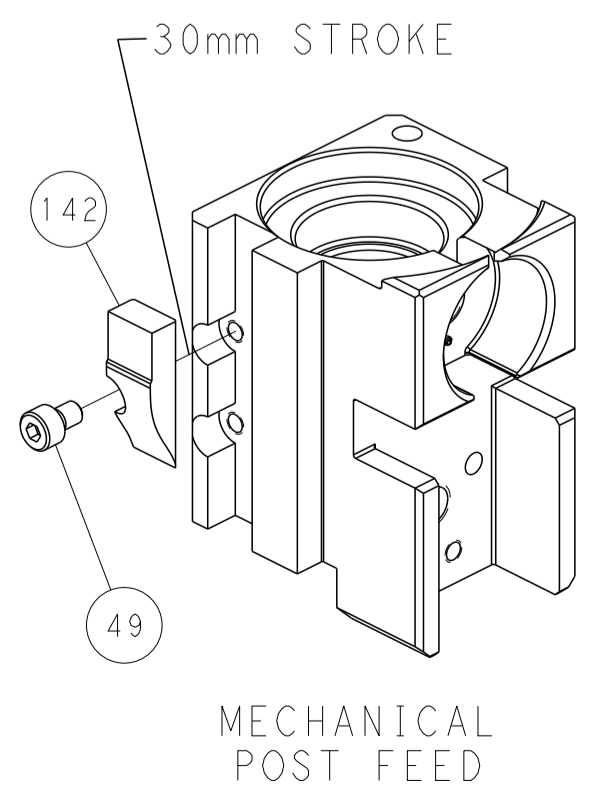


ITEM 30 LOCATED AT
FRONT HOLES

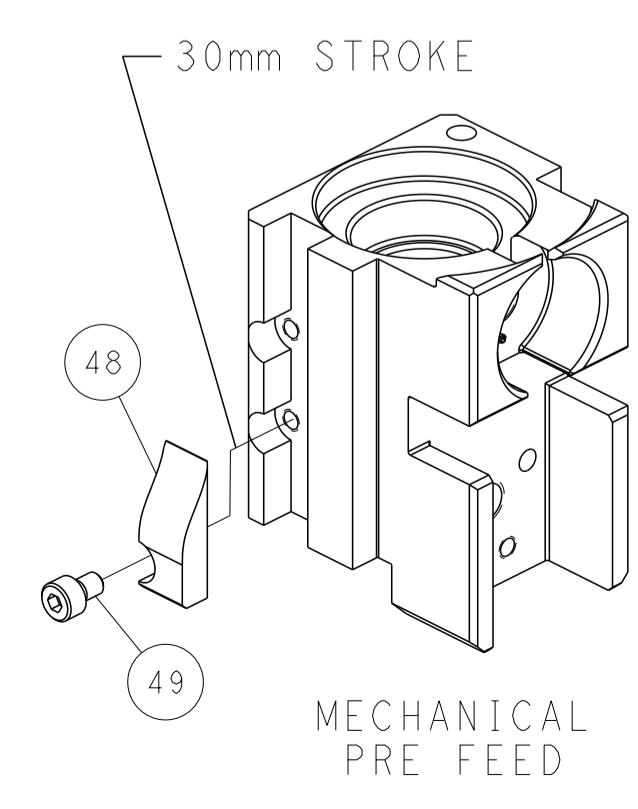


FEED TRACK POSITION
GUIDE BY INSULATION BARREL

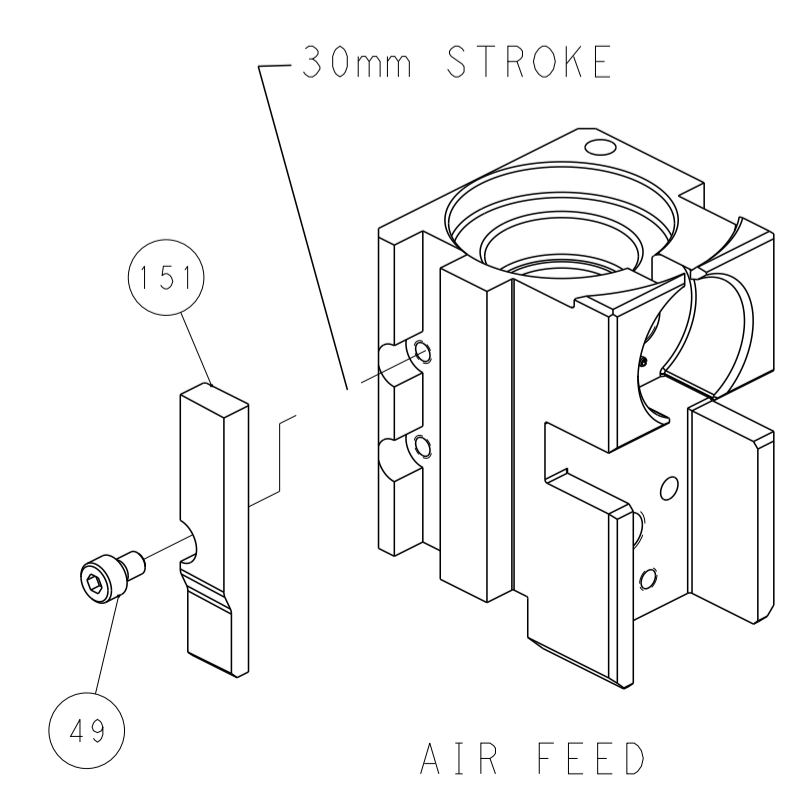
CAM POSITIONS



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)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN T. BROOKENS 02DEC2021		TE Connectivity	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	Harrisburg, PA 17105-3608	
MATERIAL:		FINISH:		APVD M. HERR 02DEC2021		NAME	
				PRODUCT SPEC		OCEAN 2.0 Side Feed Applicator	
				APPLICATION SPEC		SIZE CAGE CODE DRAWING NO	
				WEIGHT		RESTRICTED TO	
				A 00779 C=4151114		Customer Accessible Production Drawing	
				SCALE 1:2		SHEET 4 OF 4 REV A	