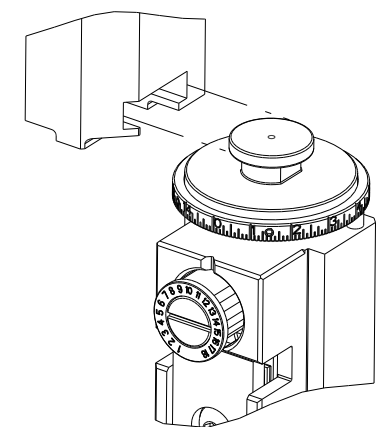


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150386-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150386-2	C	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150386-7	A	CRIMP TOOLING KIT	-

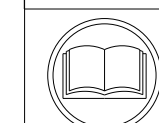
ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.29 mm [.090]	F
INSUL	3.56 mm [.140]	F
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: SHUR PLUG .156 DIA			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
3.66-4.26 mm [.144-.168 IN]		Ø2.41-2.92 mm [.095-.115 IN]	
TERMINAL APPLICATION SPECIFICATION	114-2042		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
61388-1			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
16 AWG	1.68+/-0.05 [.066+/-0.002]	6.2
18 AWG	1.50+/-0.05 [.059+/-0.002]	7.6
20 AWG	1.42+/-0.05 [.056+/-0.002]	8.7



- RECOMMENDED SPARE PARTS
- REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 50. 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.
- TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- 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.

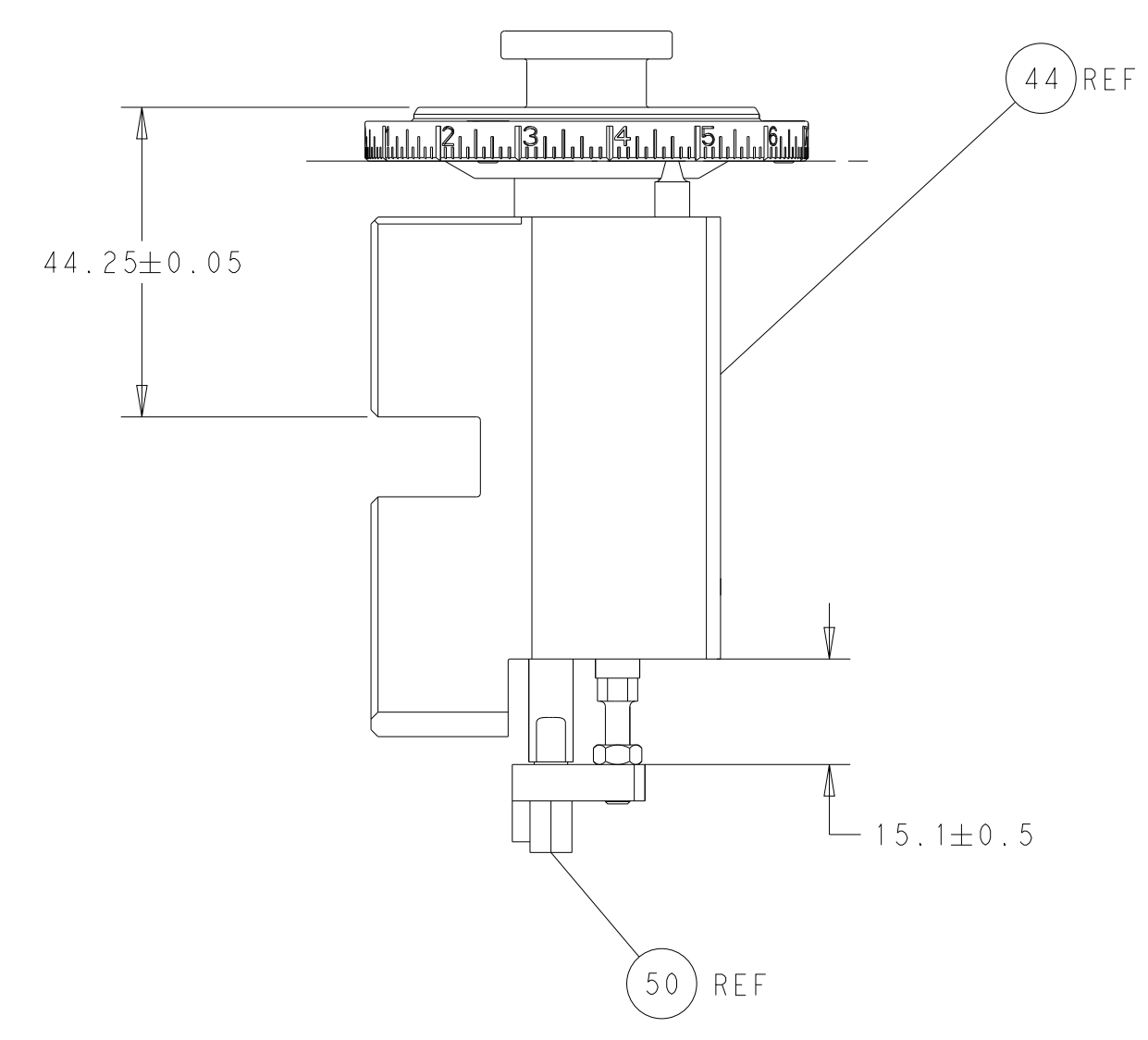
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

LOC	DIST	REVISIONS					
A	66	P	LTN	DESCRIPTION	DATE	DWN	APVD
		1		DEVELOPMENT	17OCT2013	YY	UG
		A		RELEASED	04DEC2013	YY	UG
		B		ECR-20-002611	24FEB2020	FJ	TE
		C		ECR-22-126074	10JAN2022	FJ	TE

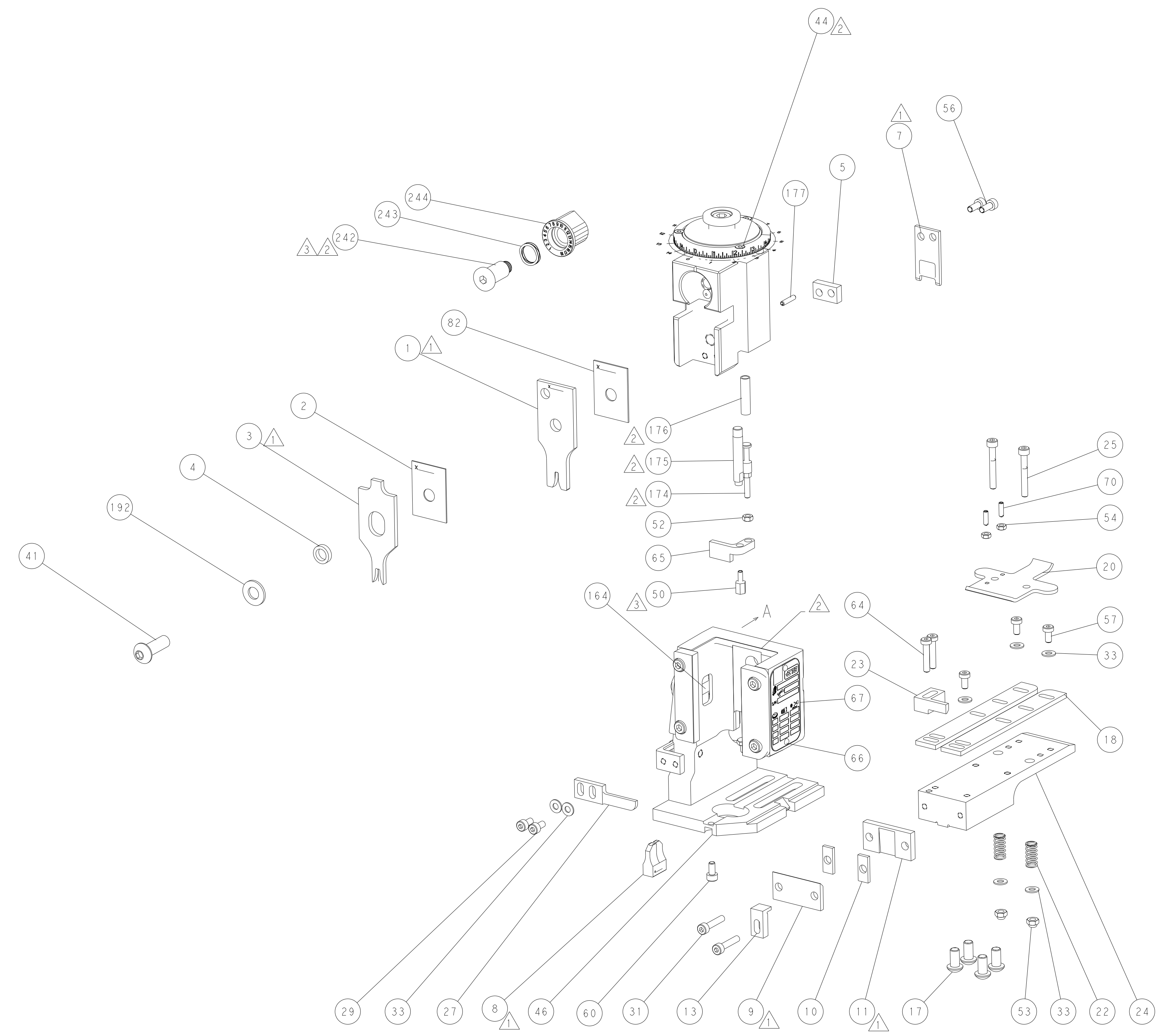
-	1	1	2119641-1	FEED CAM, AIR FEED	248	
-	1	1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244	
-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243	
-	1	1	2119083-1	RETAINER, INSULATION DIAL	242	
-	1	1	2844940-3	AIR FEED MODULE	238	
-	1	1	1-18028-0	WASHER, FLAT, REG M8	192	
-	1	1	6-993111-6	PIN, SLOTTED SPRING 3.0 X 14.0	177	
-	1	1	8-22280-7	SPRING, COMPRESSION	176	
-	1	1	1752353-2	GUIDE PIN,HOLDDOWN	175	
-	1	1	1901680-2	GUIDE PIN,HOLDDOWN	174	
-	REF	REF	994970-2	COUNTER, MAGNETIC	164	
-	1	1	455888-8	SPACER, CRIMPER	82	
-	1	1	1803607-4	DOCUMENTATION PACKAGE	71	
-	2	2	2-18032-2	SCR, SET, FLT PNT, M3 X 10.0	70	
-	1	1	2119740-1	TAG, IDENTIFICATION	67	
-	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66	
-	1	1	1901681-1	HOLDDOWN, TERMINAL	65	
-	2	2	2168400-5	SHCS, LOW HEAD, RoHS, M4 X 20	64	
-	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	60	
-	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59	
-	3	3	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57	
-	2	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	56	
-	2	2	5018030-1	NUT, HEX, REG, RoHS, M3	54	
-	2	2	986965-8	NUT, LOCK, HEX, TORQUE (M4)	53	
-	1	1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52	
-	1	1	1-2063961-0	FEED FINGER	51	
-	1	1	1-1752354-4	STANDOFF,HOLD-DOWN	50	
-	1	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49	
-	1	1	2119655-5	APPLICATOR BASIC ASSEMBLY, EF	46	
-	1	1	1803517-1	RAM ASSEMBLY, EF ATLANTIC	44	
-	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41	
-	7	7	1-18028-2	WASHER, FLAT, REG M4	33	
-	2	2	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	31	
-	2	2	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	29	
-	1	1	240639-1	STRIPPER (MACHINING)	27	
-	2	2	1-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 30	25	
-	1	1	1752371-5	PLATE, STRIP GUIDE	24	
-	1	1	240825-1	PLATE, STRIP HOLD DOWN	23	
-	2	2	2-22281-3	SPRING, COMPRESSION	22	
-	1	1	1803292-4	DRAG	20	
-	2	2	1901259-6	GUIDE, LOWER STRIP	18	
-	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17	
-	1	1	1752360-1	SPACER,HOLD-DOWN	13	
-	1	1	240644-1	PLATE, REAR SHEAR	11	
-	2	2	1-240645-0	SPACER, SHEAR PLATE	10	
-	1	1	690796-1	PLATE-FRONT SHEAR MINI APPLICATOR	9	
-	1	2	1	9-1633383-4	ANVIL, COMBINATION	8
-	1	1	1	240651-4	BLADE, SLUG	7
-	-	-	-	-	6	
-	1	1	1	7-240641-1	SPACER	5
-	1	1	1	238011-2	BLOCK, CRIMPER SPACER	4
-	1	2	1	2-1633961-3	CRIMPER, INSULATION F PREMIUM	3
-	1	1	1	455888-6	SPACER, CRIMPER	2
-	1	2	1	456406-2	CRIMPER, WIRE PREMIUM	1
-	77	72	2	PART NO	DESCRIPTION	ITEM NO

THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION. COPYRIGHT 20 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.		DWN	Y. YIN	17OCT2013	TE Connectivity Harrisburg, PA 17105-3608
		CHK	G. BAILEY	17OCT2013	
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		NAME	
mm	0 PLC ±	1 PLC ±	2 PLC ±	Ocean End Feed	
	3 PLC ±	4 PLC ±	ANGLES ±	Applicator	
	FINISH	FINISH		-	
MATERIAL		WEIGHT		SIZE	CAGE CODE
				A1	00779
Customer Accessible Production Drawing		SCALE	1:1	SHEET	1 OF 4

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

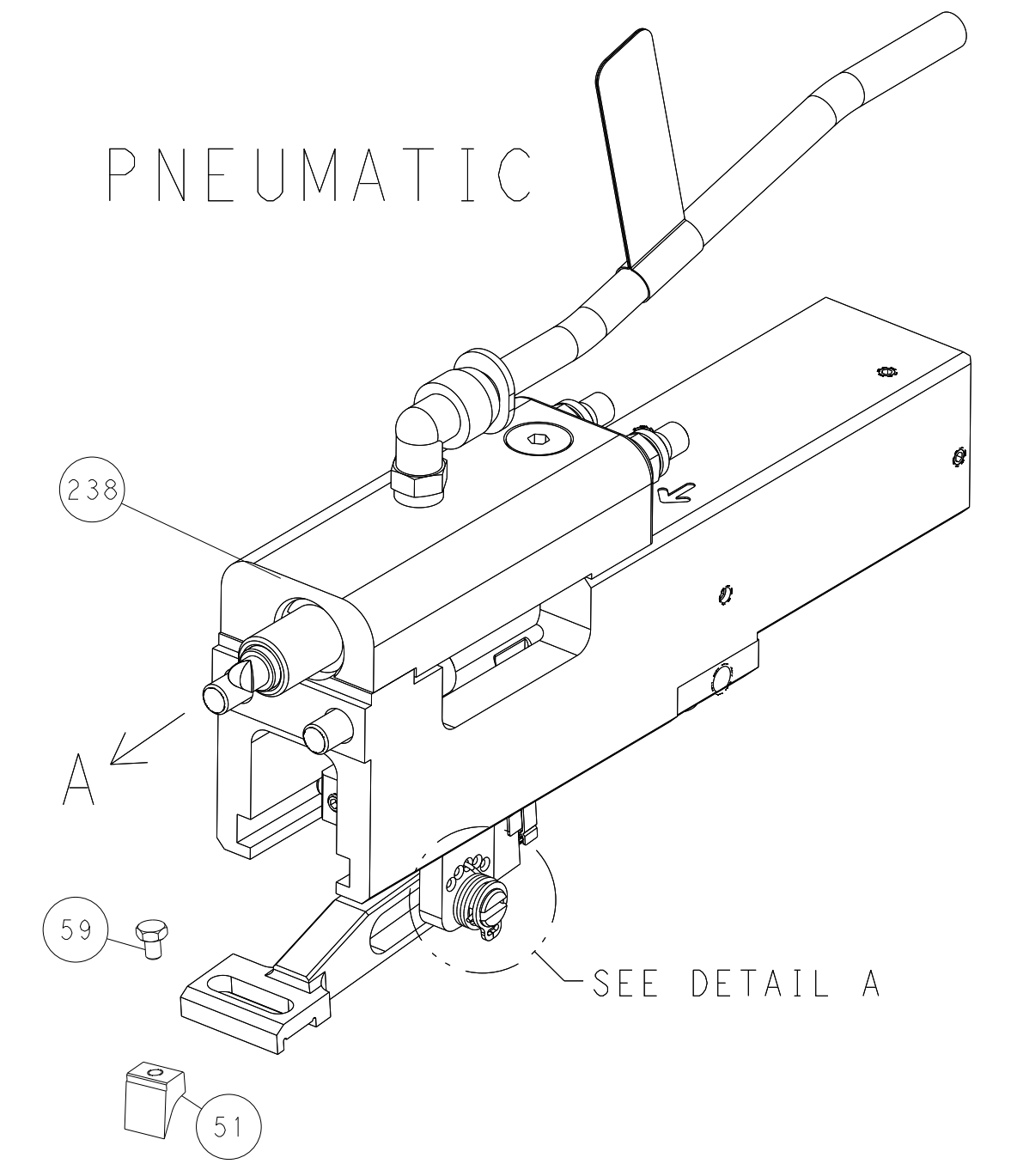


RAM AND HOLDDOWN SET-UP

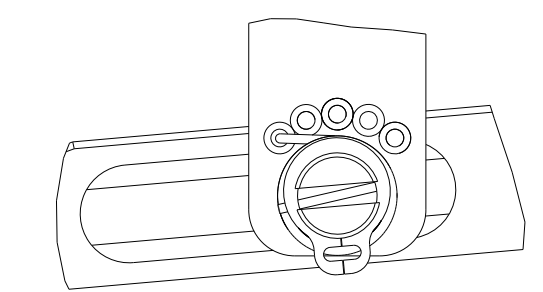


FEED TYPE

PNEUMATIC

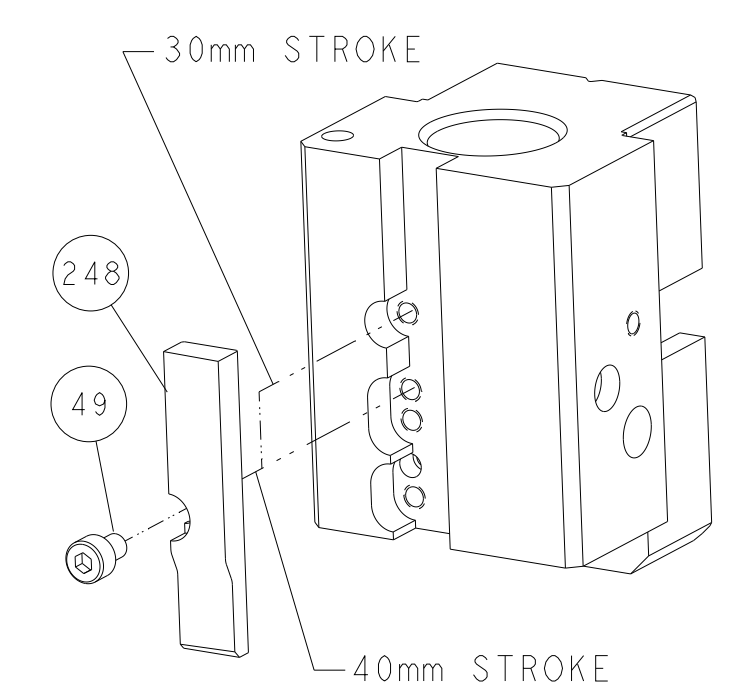


FEED SPRING SETTING POSITION



DETAIL A

CAM POSITION



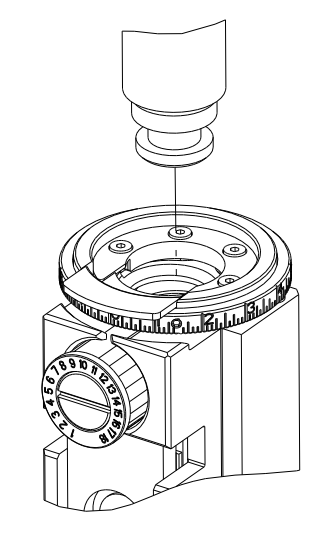
AIR FEED

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 Y. YIN 17OCT2013		TE Connectivity	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	5 PLC ±	Harrisburg, PA 17105-3608
MATERIAL:	FINISH:	APVD U. GUO 17OCT2013	NAME	Ocean End Feed Applicator		RESTRICTED TO	
		WEIGHT	SCALE	1:1	SHEET 2 OF 4	REV C	

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150386-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150386-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
 INTERFACE ADAPTER



APPLICATOR DATA

CRIMP	SIZE	TYPE
WIRE	2.29 mm (.090)	F
INSUL	3.56 mm (.140)	F

APPL INSTRUCTIONS
 408-35043

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION

TERMINAL NAME: SHUR PLUG .156 DIA

WIRE STRIP LENGTH	INSULATION DIAMETER RANGE
3.66-4.26 mm (.144-.168 IN)	Ø2.41-2.92 mm (.095-.115 IN)

TERMINAL APPLICATION SPECIFICATION 114-2042

TERMINALS APPLIED

TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
61388-1			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
16 AWG	1.68+/-0.05 [.066+/-0.002]	6.2
18 AWG	1.50+/-0.05 [.059+/-0.002]	7.6
20 AWG	1.42+/-0.05 [.056+/-0.002]	8.7



- 1 RECOMMENDED SPARE PARTS
- 2 REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- 3 APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 50. 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 PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- 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.

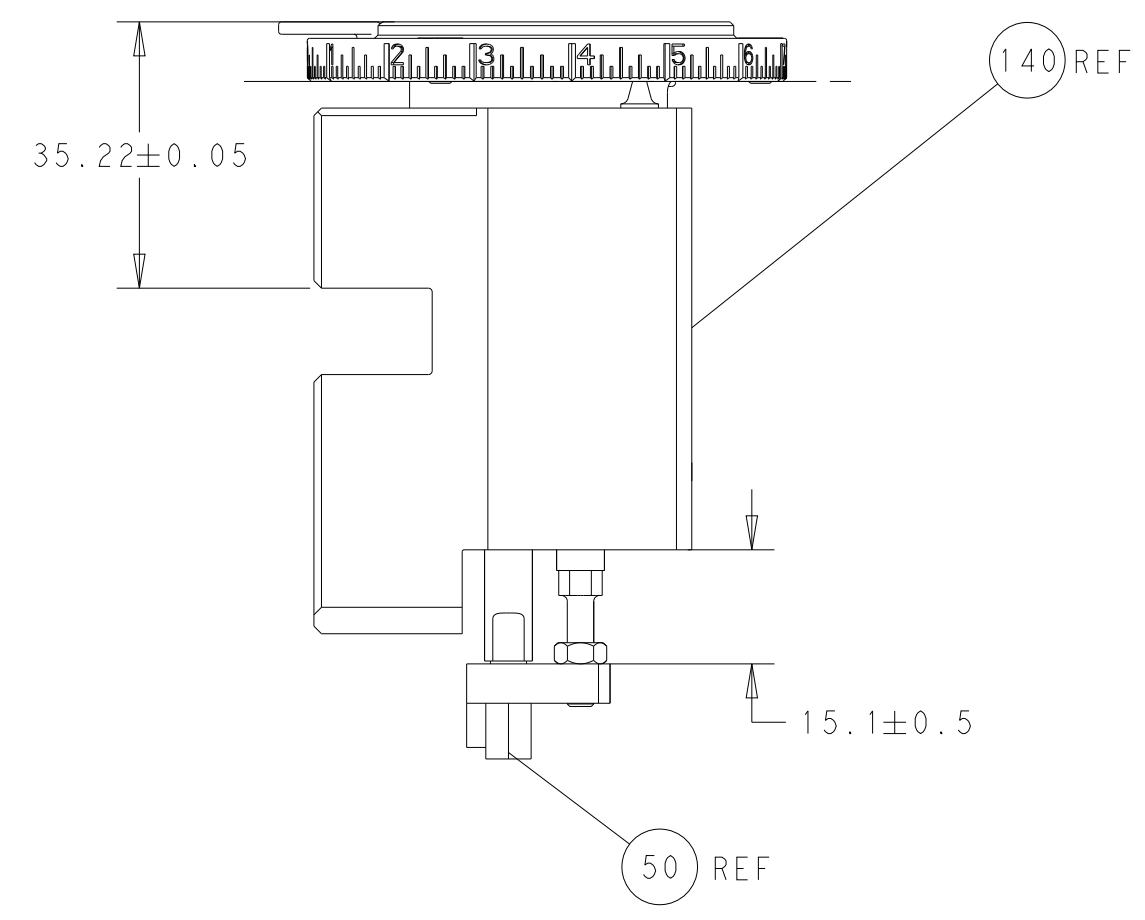
PACIFIC VERSION
 Shown on sheets 3 of 4 & 4 of 4
 (Atlantic version shown on sheets 1 of 4 & 2 of 4)

LOC	DIST	REV	DATE	BY	APPV
A	66				

REV	DATE	DESCRIPTION	DATE	BY	APPV
-	1	2119082-9			244
-	1	2079764-1			243
-	1	2119083-1			242
-	1	2844940-3			238
-	1	1-18028-0			192
-	4	2079383-9			186
-	1	6-993111-6			177
-	1	8-22280-7			176
-	1	1752353-2			175
-	1	1901680-2			174
-	REF	994970-2			164
-	1	2119641-2			152
-	1	2168083-8			144
-	1	2119655-6			141
-	1	1803518-1			140
-	1	455888-8			82
-	1	1803607-4			71
-	2	2-18032-2			70
-	1	2119740-1			67
-	2	2168078-1			66
-	1	1901681-1			65
-	2	2168400-5			64
-	1	5-18022-5			59
-	3	2168400-4			57
-	2	1-2168083-0			56
-	2	5018030-1			54
-	2	986965-8			53
-	1	1-5018030-0			52
-	1	1-2063961-0			51
-	1	1-1752354-4			50
-	1	18023-9			49
-	1	1803602-1			41
-	7	1-18028-2			33
-	2	2168083-9			31
-	2	2168083-2			29
-	1	240639-1			27
-	2	1-2168083-5			25
-	1	1752371-5			24
-	1	240825-1			23
-	2	2-22281-3			22
-	1	1803292-4			20
-	2	1901259-6			18
-	1	1752360-1			13
-	1	240644-1			11
-	2	1-240645-0			10
-	1	690796-1			9
1	1	9-1633383-4			8
-	1	240651-4			7
-	-	-			6
-	1	7-240641-1			5
-	1	238011-2			4
1	1	2-1633961-3			3
-	1	455888-6			2
1	1	456406-2			1
-	77-22	PART NO			ITEM NO

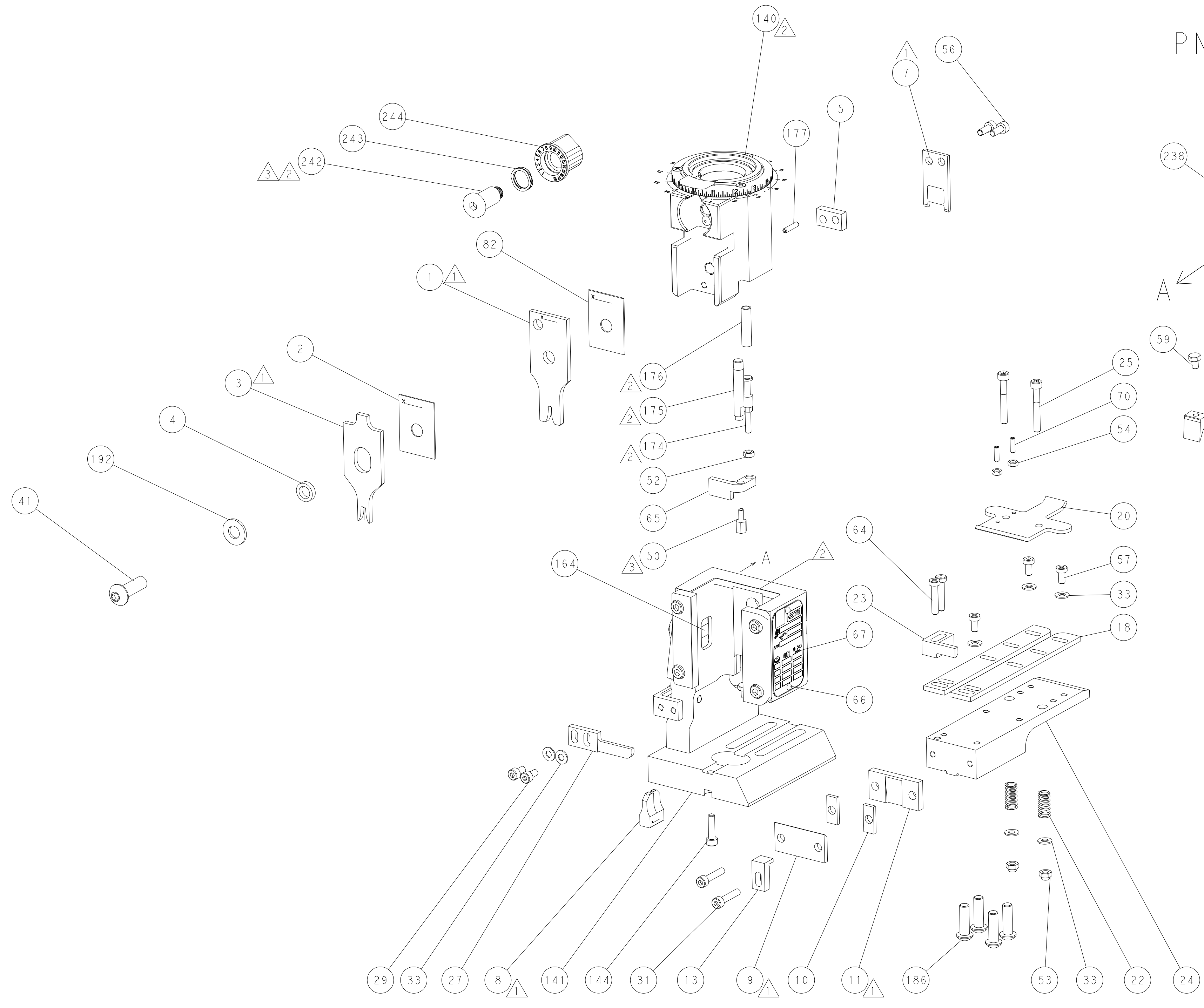
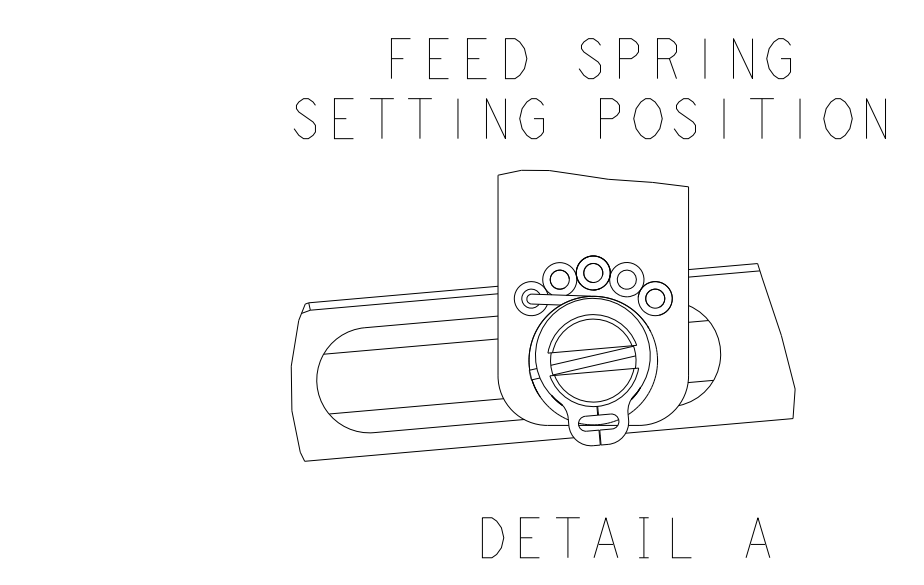
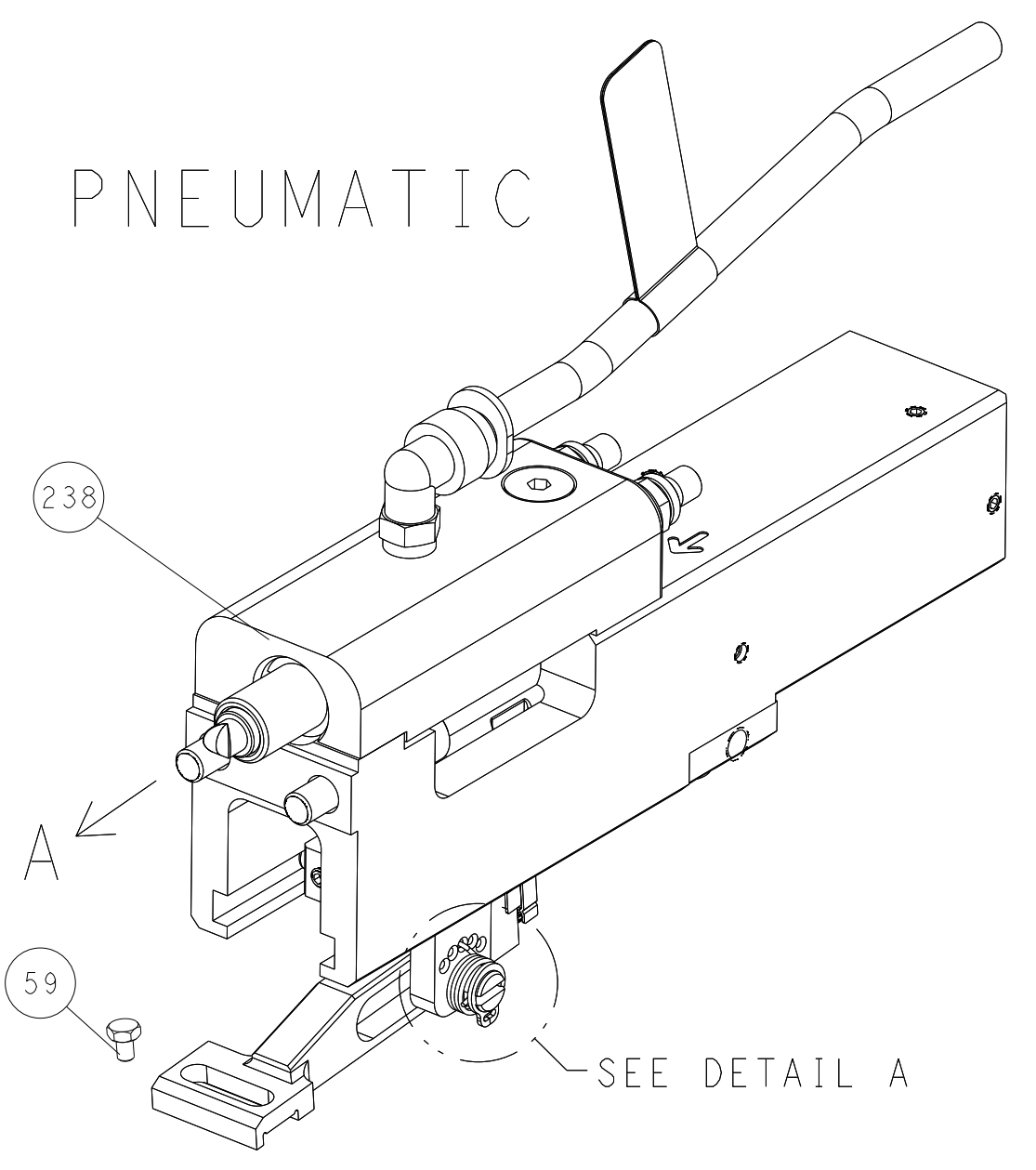
DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH		DWG: Y. YIN 17OCT2013 CHK: G. BAILEY 17OCT2013 APVD: U. GUO 17OCT2013 PRODUCT SPEC APPLICATION SPEC WEIGHT: - SCALE: A1 00779 ©=2150386 Customer Accessible Production Drawing		NAME: Ocean End Feed Applicator SIZE: - CAGE CODE: - DRAWING NO: - RESTRICTED TO: - SCALE: 1:1 SHEET 3 OF 4 REV C	
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LOC		DIST		REVISIONS				
P	LTN	DATE	DMN	APVD	DESCRIPTION	DATE	DMN	APVD
-	-	-	-	-	SEE SHEET 1	-	-	-

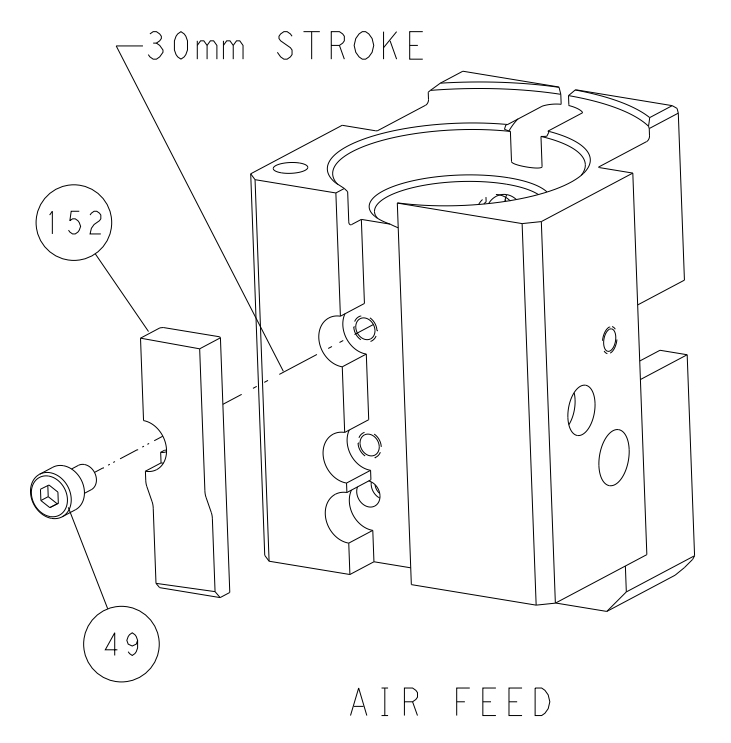


RAM AND HOLDDOWN SET-UP

FEED TYPE



CAM POSITION



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:		DWG Y. YIN 17OCT2013		STE TE Connectivity	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	5 PLC ±	Harrisburg, PA 17105-3608
MATERIAL:	FINISH:	WEIGHT:	SCALE:	APVD: U. GUO 17OCT2013	NAME: Ocean End Feed Applicator	SIZE: A1	RESTRICTED TO:
			1:1	PRODUCT SPEC:		00779	
				APPLICATION SPEC:		©=2150386	
				Customer Accessible Production Drawing		SHEET 4 OF 4	REV C