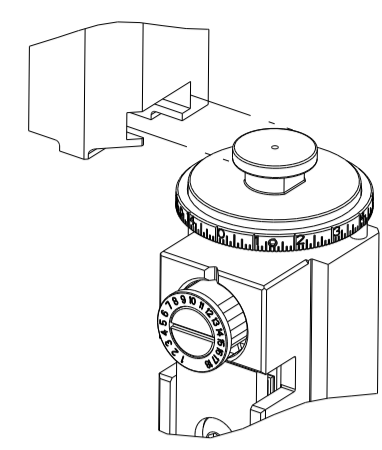


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150473-1	D	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2150473-2	D	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150473-1	D	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2150473-2	D	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150473-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	3.30 mm [.130]	F
INSUL	4.57 mm [.180]	F
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION			
TERMINAL NAME: TERMINAL, RING TONGUE			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
4.39-5.16 mm [.173-.203 IN]		Ø2.50-3.50 mm [.098-.138 IN]	
TERMINAL APPLICATION SPECIFICATION	114-2084	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
140529	140531	140546	737161-1
140530	140545	140854-2	

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION			
TERMINAL NAME: TERMINAL, RING TONGUE			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
4.39-5.16 mm [.173-.203 IN]		Ø2.80-4.00 mm [.110-.157 IN]	
TERMINAL APPLICATION SPECIFICATION	114-2084	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
140663	140663-1	140664	

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
14 AWG OR 2.00mm2	1.90+/-0.05 [.075+/-0.002]	5.8
1.50mm2	1.75+/-0.05 [.069+/-0.002]	7.3
16 AWG	1.70+/-0.05 [.067+/-0.002]	7.8
1.00mm2	1.65+/-0.05 [.065+/-0.002]	8.4
18 AWG OR 0.80mm2	1.57+/-0.05 [.062+/-0.002]	9.5

- RECOMMENDED SPARE PARTS
  - REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND 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.
  - 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.

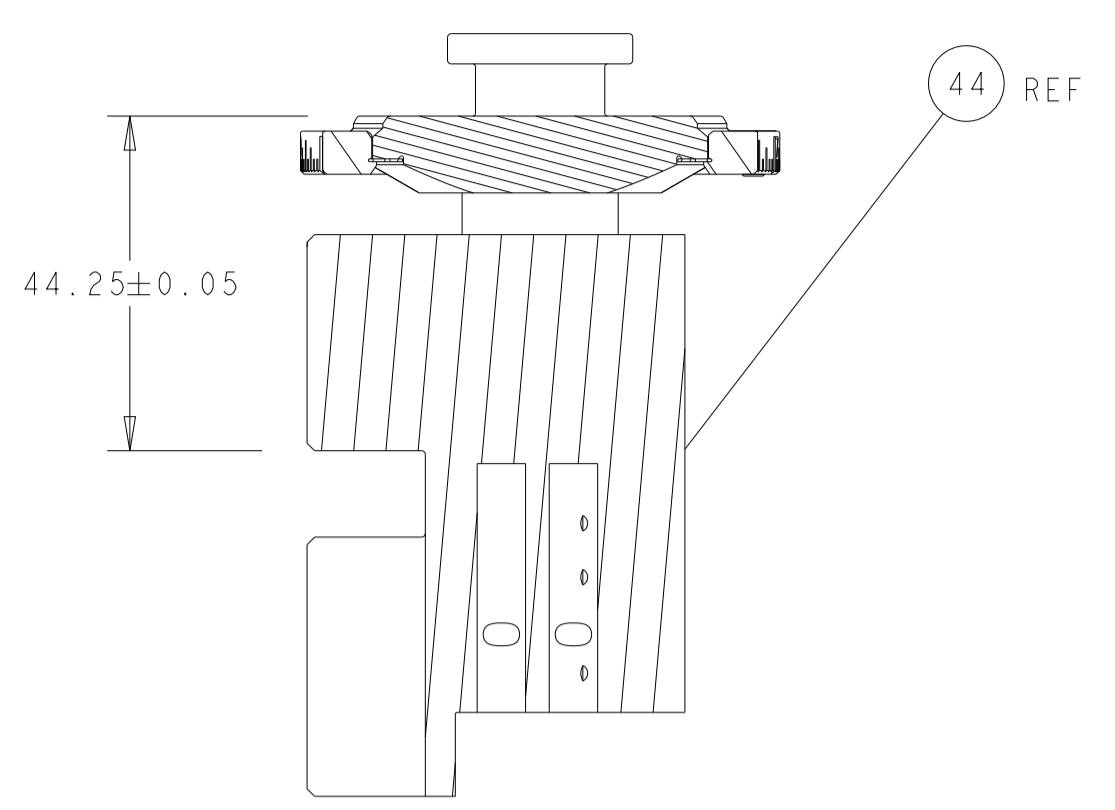
ATLANTIC VERSION  
Shown on sheets 1 of 4 & 2 of 4  
(Pacific version shown on sheets 3 of 4 & 4 of 4)

LOC	DIST	REVISIONS					
A	66	P	LTN	DESCRIPTION	DATE	OWN	APVD
		A		RELEASED	13OCT2014	RW	GB
		B		ECR-17-004787	03APR2017	TB	TE
		C		ECR-22-157416	03NOV2022	JWC	TE
		D		ECR-23-164812	28JAN2023	FZ	TE

-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248	
-	1	1	1	1	2119082-2	CAM, SNAIL, INSULATION ADJUSTMENT	244	
-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243	
-	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242	
-	-	1	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239	
-	1	-	1	-	2844940-3	AIR FEED MODULE	238	
-	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164	
-	1	1	1	1	2119955-2	ASSY, LUBRICATOR, END FEED	84	
-	1	1	1	1	455888-5	SPACER, CRIMPER	82	
-	1	1	1	1	1803203-1	BLOCK, FRONT DEPRESSOR	77	
-	1	1	1	1	1-2119791-1	DEPRESSOR, WIRE	73	
-	1	1	1	1	1803607-4	DOCUMENTATION PACKAGE	71	
-	2	2	2	2	2-18032-2	SCR, SET, FLT PNT, M3 X 10.0	70	
-	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	2063961-1	FEED FINGER	58	
-	4	4	4	4	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57	
-	2	2	2	2	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	56	
-	2	2	2	2	5018030-1	NUT, HEX, REG, RoHS, M3	54	
-	2	2	2	2	986965-8	NUT, LOCK, HEX, TORQUE (M4)	53	
-	1	-	1	-	2063961-1	FEED FINGER	51	
-	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	2119655-5	APPLICATOR BASIC ASSEMBLY, EF	46	
-	1	1	1	1	1803517-1	RAM ASSEMBLY, EF ATLANTIC	44	
-	1	1	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41	
-	8	8	8	8	1-18028-2	WASHER, FLAT, REG M4	33	
-	2	2	2	2	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	31	
-	2	2	2	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	29	
-	1	1	1	1	240639-1	STRIPPER (MACHINING)	27	
-	2	2	2	2	1-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 30	25	
-	1	1	1	1	1752371-1	PLATE, STRIP GUIDE	24	
-	2	2	2	2	2-22281-3	SPRING, COMPRESSION	22	
-	1	1	1	1	1803292-4	DRAG	20	
-	1	1	1	1	4-1901696-4	STRIP GUIDE, REAR	19	
-	1	1	1	1	4-1901695-4	STRIP GUIDE, FRONT	18	
-	4	4	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17	
-	1	1	1	1	240644-1	PLATE, REAR SHEAR	11	
-	-	-	-	-	-	-	10	
-	1	1	1	1	7-690482-2	PLATE, FRONT SHEAR	9	
-	1	2	2	1	1333221-8	ANVIL, EF .130	8	
-	1	1	1	1	2217206-7	BLADE, SLUG	7	
-	2	2	2	2	240641-5	SPACER	5	
-	1	1	1	1	238011-2	BLOCK, CRIMPER SPACER	4	
-	1	2	2	1	1803143-3	CRIMPER, INSULATION 0	3	
-	1	1	1	1	455888-4	SPACER, CRIMPER	2	
-	1	2	2	1	5-1633860-0	CRIMPER, WIRE	1	
-	77	72	71	2	-1	PART NO	DESCRIPTION	ITEM NO

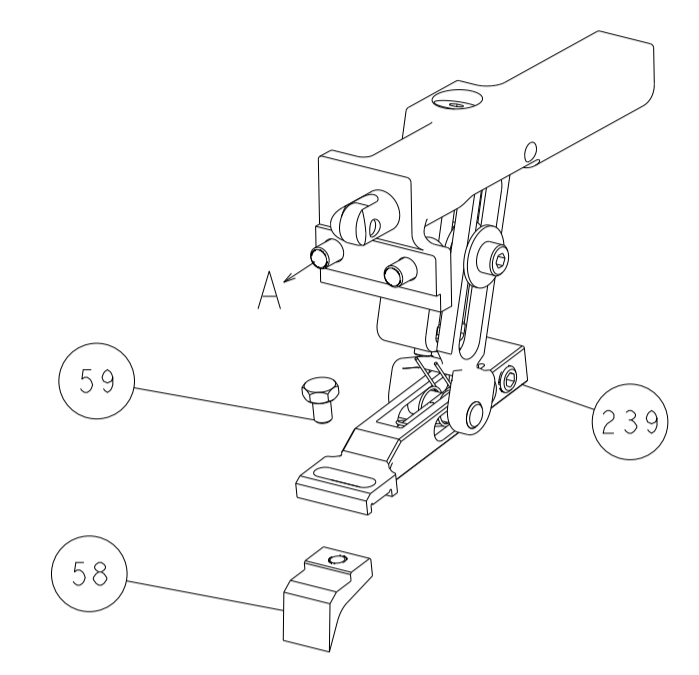
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		MATERIAL:		FINISH:		WEIGHT:		SCALE:		SHEET:		REV:	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES	FINISH			A1	00779	2150473	1	4	D
Customer Accessible Production Drawing										SCALE		SHEET		REV	

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

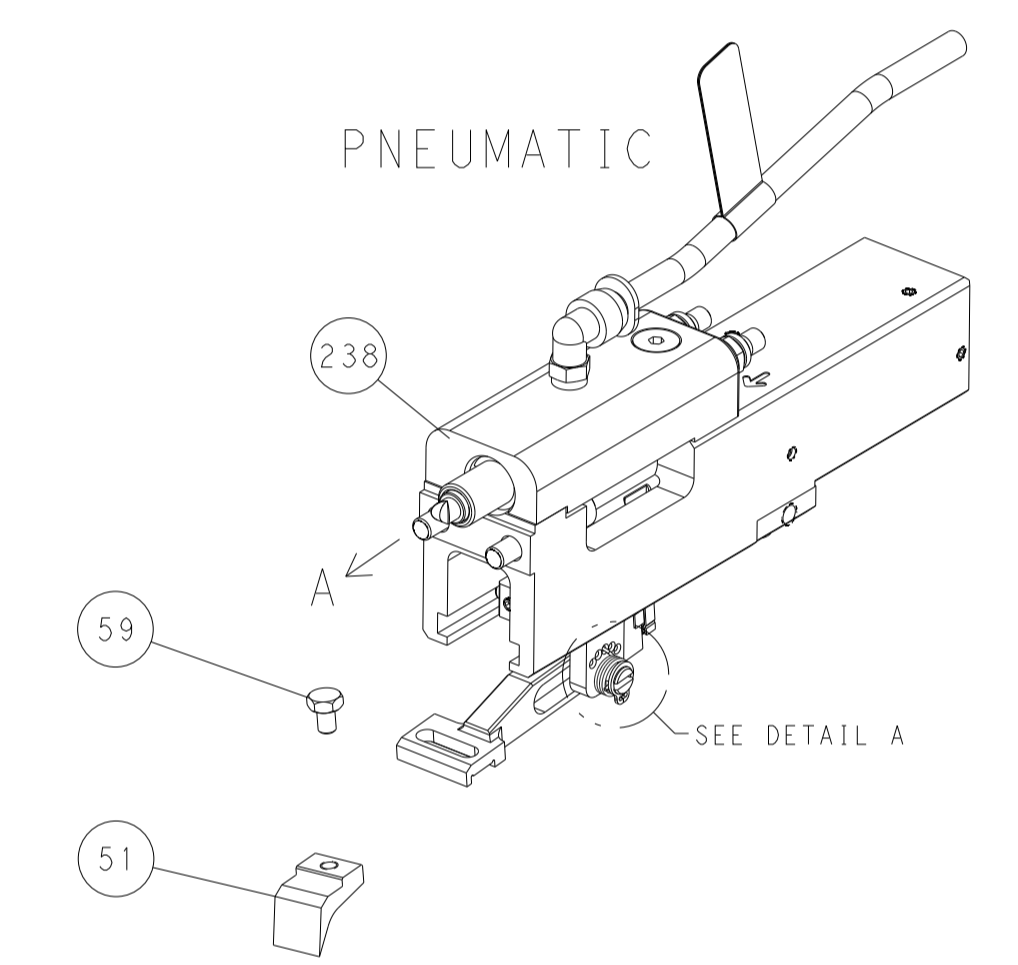


RAM SET-UP

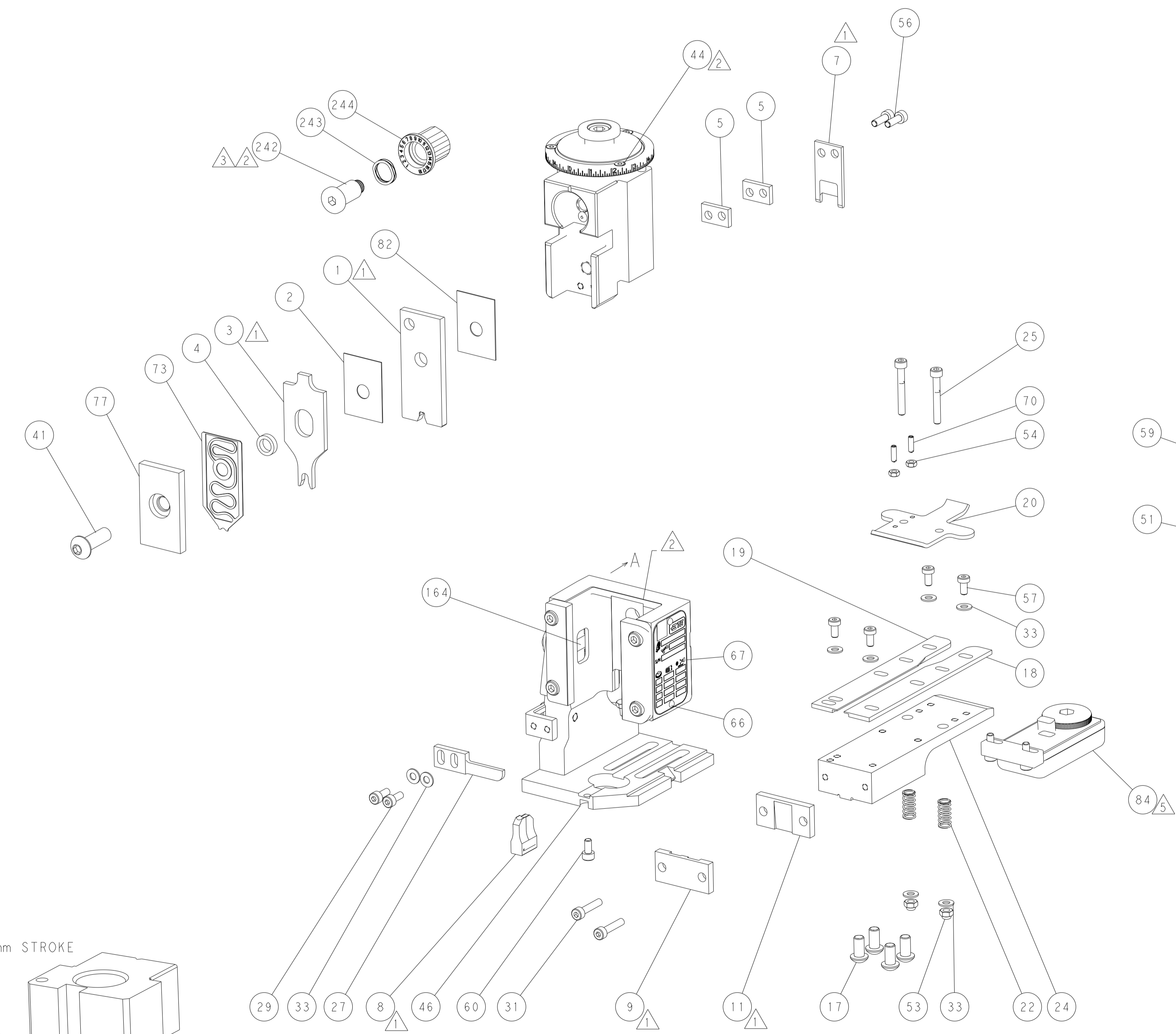
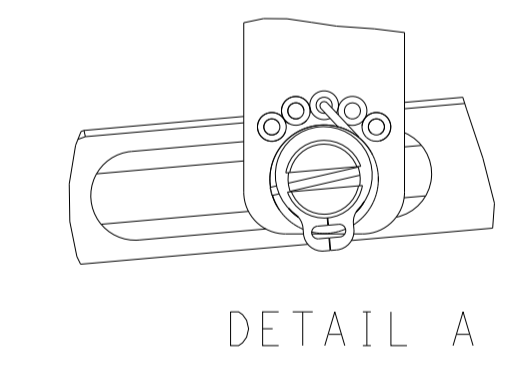
FEED TYPE  
MECHANICAL



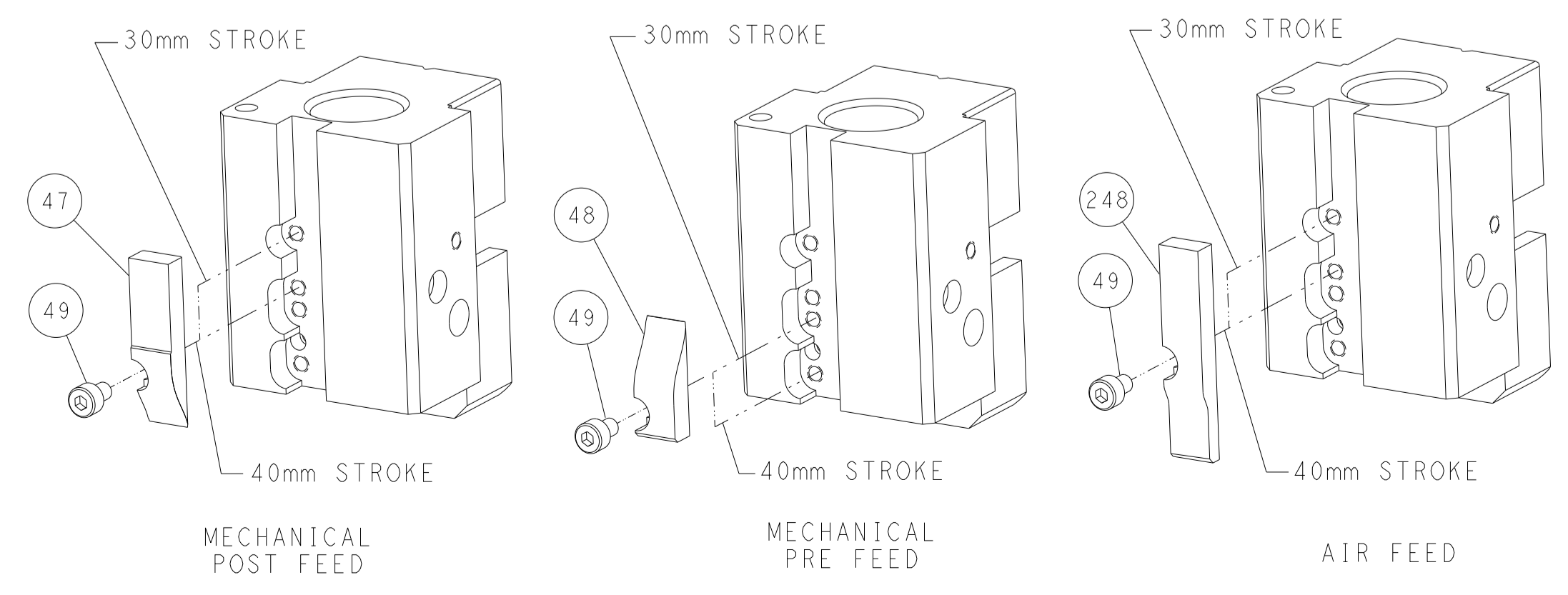
PNEUMATIC



FEED SPRING  
SETTING POSITION



CAM POSITIONS

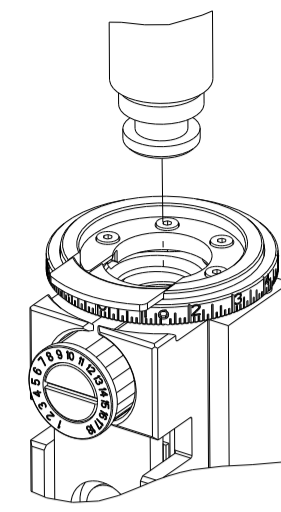


**ATLANTIC VERSION**  
 Shown on sheets 1 of 4 & 2 of 4  
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

<small>THIS DRAWING IS A CONTROLLED DOCUMENT FROM TYCO ELECTRONICS CORPORATION. IT IS THE PROPERTY OF TYCO ELECTRONICS CORPORATION AND IS NOT TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, INCLUDING PHOTOCOPYING, RECORDING, OR BY ANY INFORMATION STORAGE AND RETRIEVAL SYSTEM, WITHOUT THE WRITTEN PERMISSION OF TYCO ELECTRONICS CORPORATION.</small>		DWN: R.O. WILSON 19AUG2014 CHK: K.J. STAKEM 20AUG2014 APVD: T.L. ELBIN 20AUG2014	NAME: TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH	PRODUCT SPEC: APPLICATION SPEC: WEIGHT:	SIZE: A1 CAGE CODE: 00779 DRAWING NO: ©=2150473	RESTRICTED TO:
MATERIAL:		SCALE: 1:1 SHEET: 2 of 4 REV: D	CUSTOMER ACCESSIBLE PRODUCTION DRAWING

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150473-1	D	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2150473-2	D	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150473-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR  
INTERFACE ADAPTER

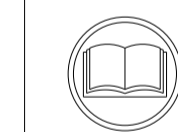


APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	3.30 mm [.130]	F
INSUL	4.57 mm [.180]	F
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL				TE CRIMP SPECIFICATION			
TERMINAL NAME: TERMINAL, RING TONGUE							
WIRE STRIP LENGTH				INSULATION DIAMETER RANGE			
4.39-5.16 mm [.173-.203 IN]				Ø2.50-3.50 mm [.098-.138 IN]			
TERMINAL APPLICATION SPECIFICATION				114-2084			
TERMINALS APPLIED							
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
140529	140531	140546	140530	140545	140854-2	737161-1	

TERMINAL DATA: TE TERMINAL				TE CRIMP SPECIFICATION			
TERMINAL NAME: TERMINAL, RING TONGUE							
WIRE STRIP LENGTH				INSULATION DIAMETER RANGE			
4.39-5.16 mm [.173-.203 IN]				Ø2.80-4.00 mm [.110-.157 IN]			
TERMINAL APPLICATION SPECIFICATION				114-2084			
TERMINALS APPLIED							
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
140663	140663-1	140664					

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
14 AWG OR 2.00mm <sup>2</sup>	1.90 +/- 0.05 [.075 +/- .002]	5.8
1.50mm <sup>2</sup>	1.75 +/- 0.05 [.069 +/- .002]	7.3
16 AWG	1.70 +/- 0.05 [.067 +/- .002]	7.8
1.00mm <sup>2</sup>	1.65 +/- 0.05 [.065 +/- .002]	8.4
18 AWG OR 0.80mm <sup>2</sup>	1.57 +/- 0.05 [.062 +/- .002]	9.5



- RECOMMENDED SPARE PARTS
- REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND 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.
- TERMINAL LUBRICANT IS RECOMMENDED.
- 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)

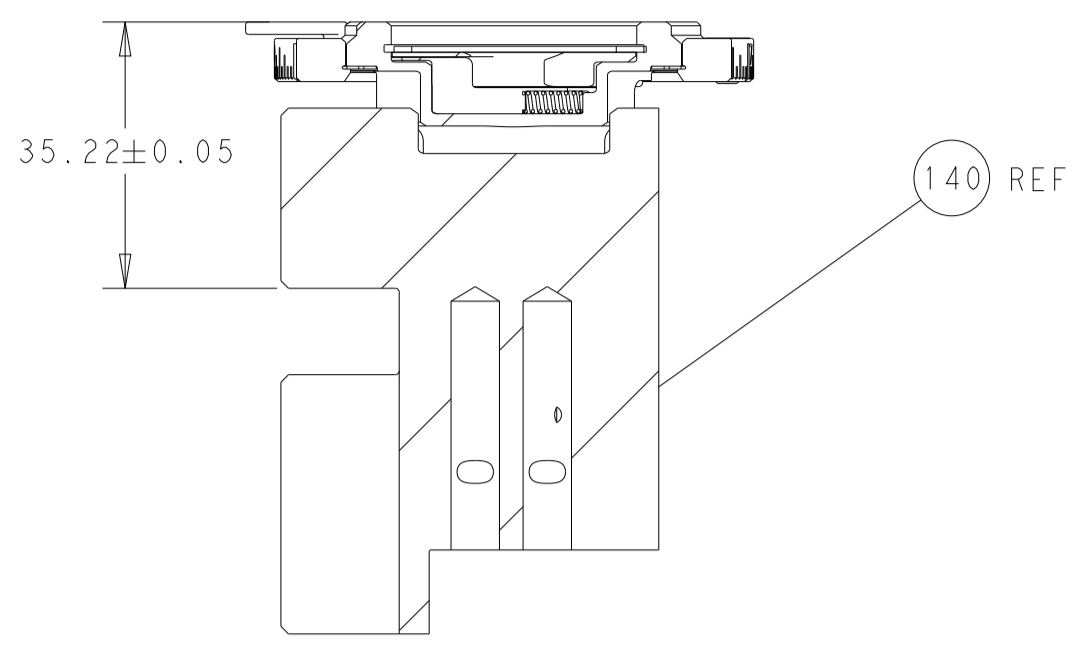
LOC	DIST	REVISIONS					
		P	LTN	DESCRIPTION	DATE	OWN	APVD
A	66	-	-	SEE SHEET 1	-	-	-

-	1	1	2119082-2	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	2119580-1	MECHANICAL FEED ASSEMBLY	239	
-	1	-	2844940-3	AIR FEED MODULE	238	
-	4	4	2079383-9	SCR, BHSC, RoHS (M6 X 20)	186	
-	REF	REF	994970-2	COUNTER, MAGNETIC	164	
-	1	-	2119641-2	FEED CAM, AIR FEED	152	
-	1	1	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	144	
-	-	1	2119653-2	FEED CAM, POST FEED	142	
-	1	1	2119655-6	APPLICATOR BASIC ASSEMBLY, EF	141	
-	1	1	1803518-1	RAM ASSEMBLY, EF PACIFIC	140	
-	1	1	2119955-2	ASSY, LUBRICATOR, END FEED	84	
-	1	1	455888-5	SPACER, CRIMPER	82	
-	1	1	1803203-1	BLOCK, FRONT DEPRESSOR	77	
-	1	1	1-2119791-1	DEPRESSOR, WIRE	73	
-	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	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59	
-	-	1	2063961-1	FEED FINGER	58	
-	4	4	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57	
-	2	2	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	56	
-	2	2	5018030-1	NUT, HEX, REG, RoHS, M3	54	
-	2	2	986965-8	NUT, LOCK, HEX, TORQUE (M4)	53	
-	1	-	2063961-1	FEED FINGER	51	
-	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	
-	8	8	1-18028-2	WASHER, FLAT, REG M4	33	
-	2	2	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	31	
-	2	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	29	
-	1	1	240639-1	STRIPPER (MACHINING)	27	
-	2	2	1-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 30	25	
-	1	1	1752371-1	PLATE, STRIP GUIDE	24	
-	2	2	2-22281-3	SPRING, COMPRESSION	22	
-	1	1	1803292-4	DRAG	20	
-	1	1	4-1901696-4	STRIP GUIDE, REAR	19	
-	1	1	4-1901695-4	STRIP GUIDE, FRONT	18	
-	1	1	240644-1	PLATE, REAR SHEAR	11	
-	-	-	-	-	10	
-	1	1	7-690482-2	PLATE, FRONT SHEAR	9	
-	1	1	1333221-8	ANVIL, EF .130	8	
-	1	1	2217206-7	BLADE, SLUG	7	
-	2	2	240641-5	SPACER	5	
-	1	1	238011-2	BLOCK, CRIMPER SPACER	4	
-	1	1	1803143-3	CRIMPER, INSULATION 0	3	
-	1	1	455888-4	SPACER, CRIMPER	2	
-	1	1	5-1633860-0	CRIMPER, WIRE	1	
-	77	22	21	PART NO	DESCRIPTION	ITEM NO

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DRAWING NO		RESTRICTED TO	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	5 PLC ±	6 PLC ±
	ANGLES	FINISH					
MATERIAL				WEIGHT			

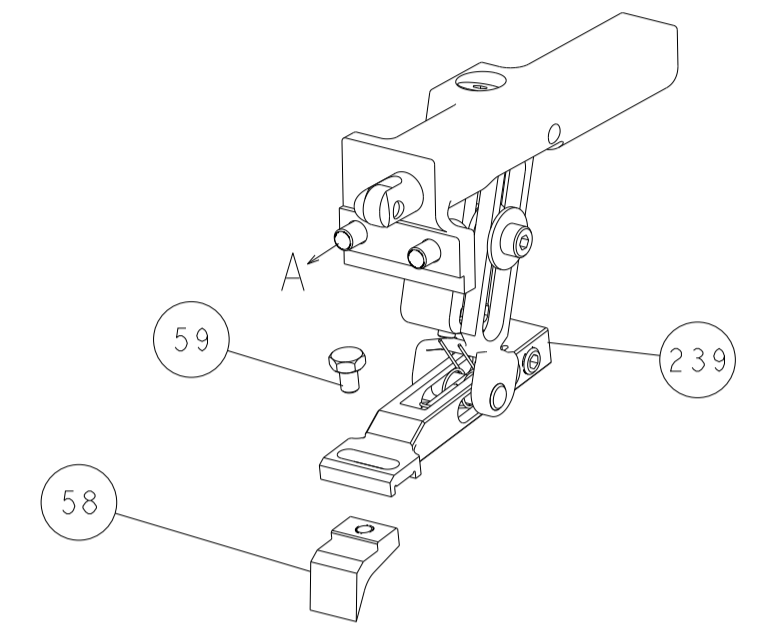
CHK	R. O. WILSON	19AUG2014	OWN	TE Connectivity
CHK	K. J. STARKEM	20AUG2014	CHK	Harrisburg, PA 17105-3608
APVD	T. L. ELBIN	20AUG2014	NAME	Ocean End Feed Applicator
			SIZE	CAGE CODE
			A1	00779
			SCALE	1:1
			SHEET	3 OF 4
			REV	D

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

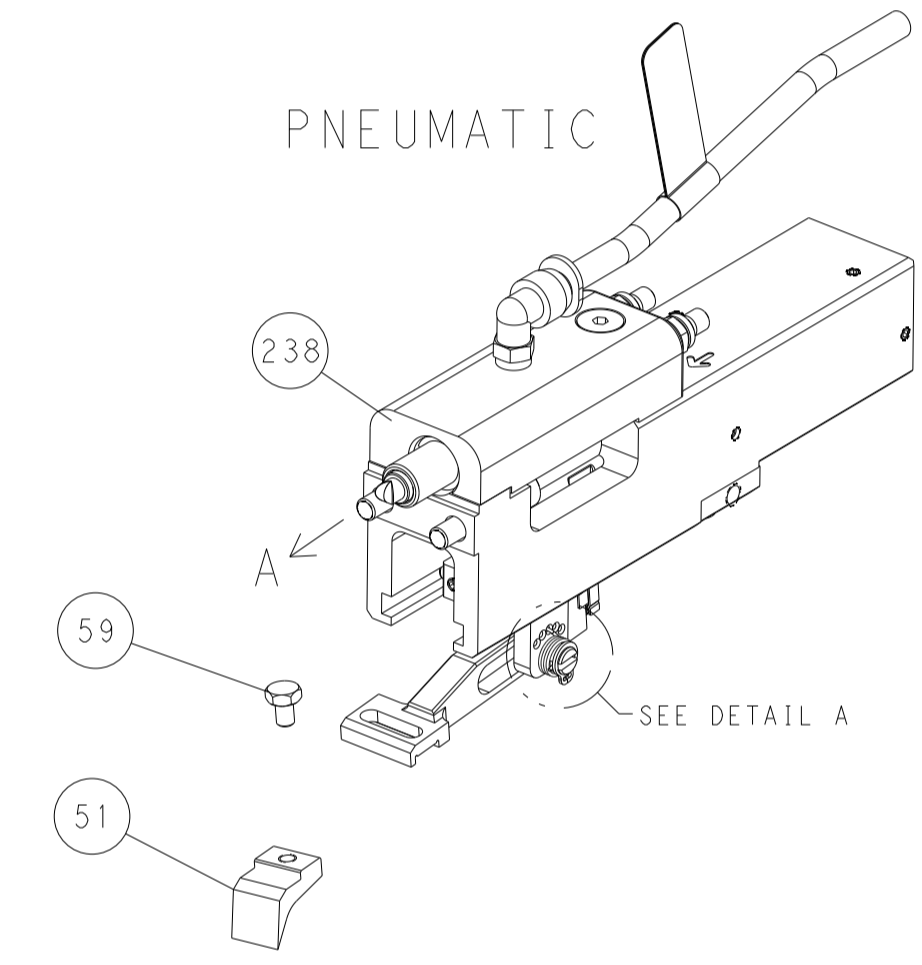


RAM SET-UP

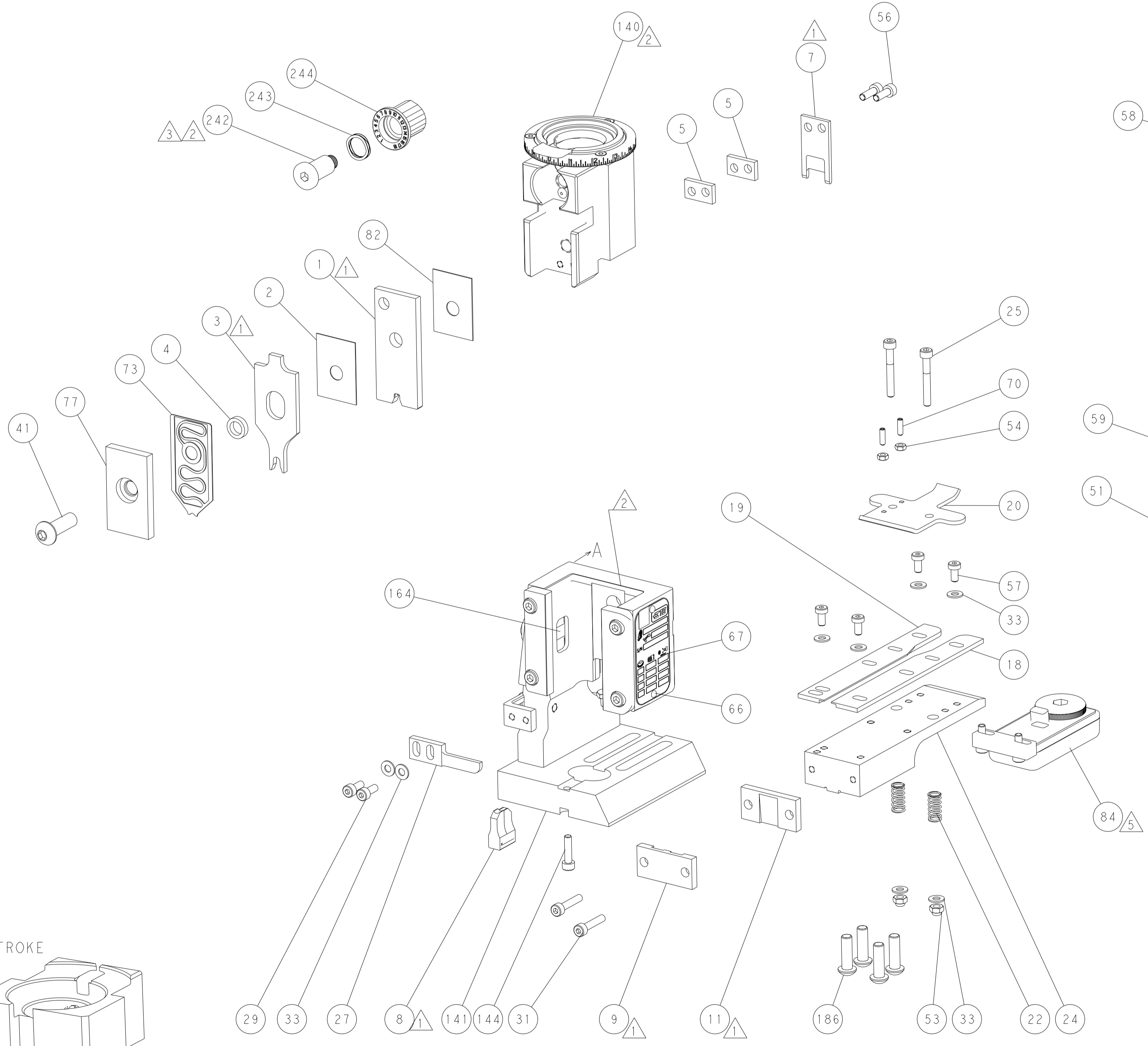
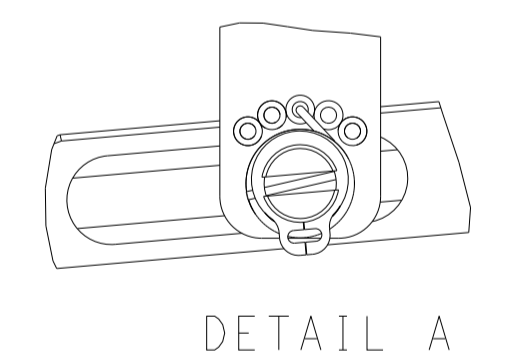
FEED TYPE  
MECHANICAL



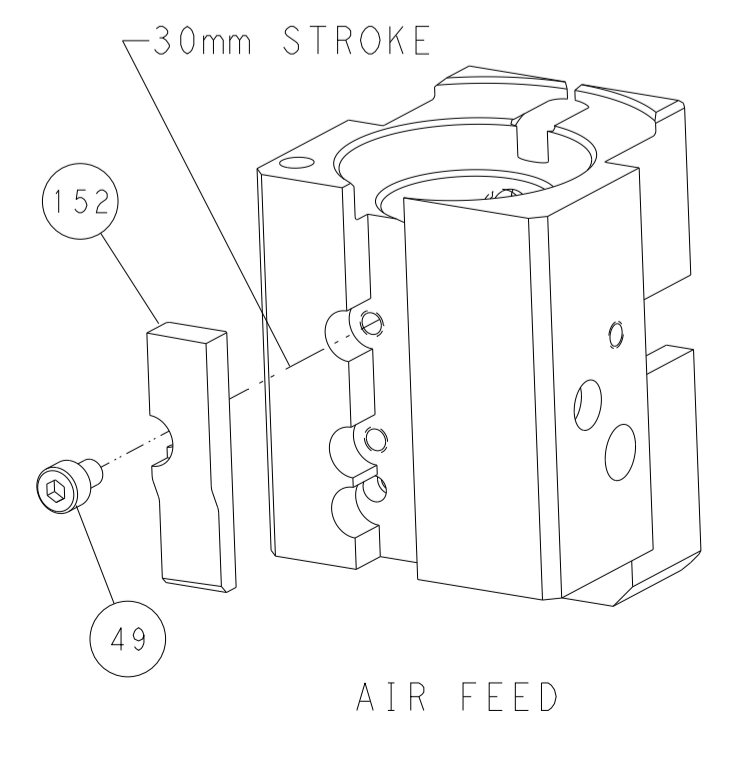
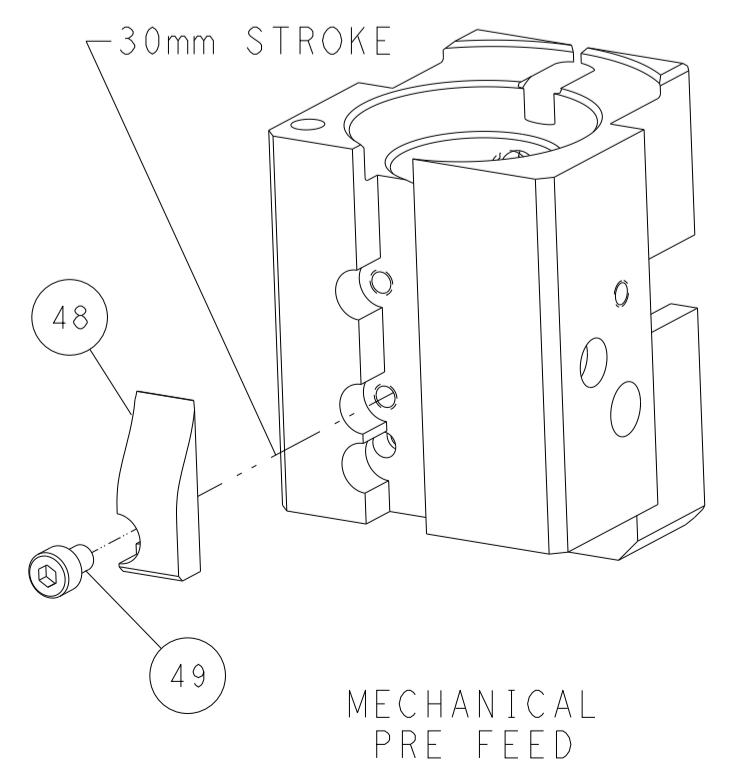
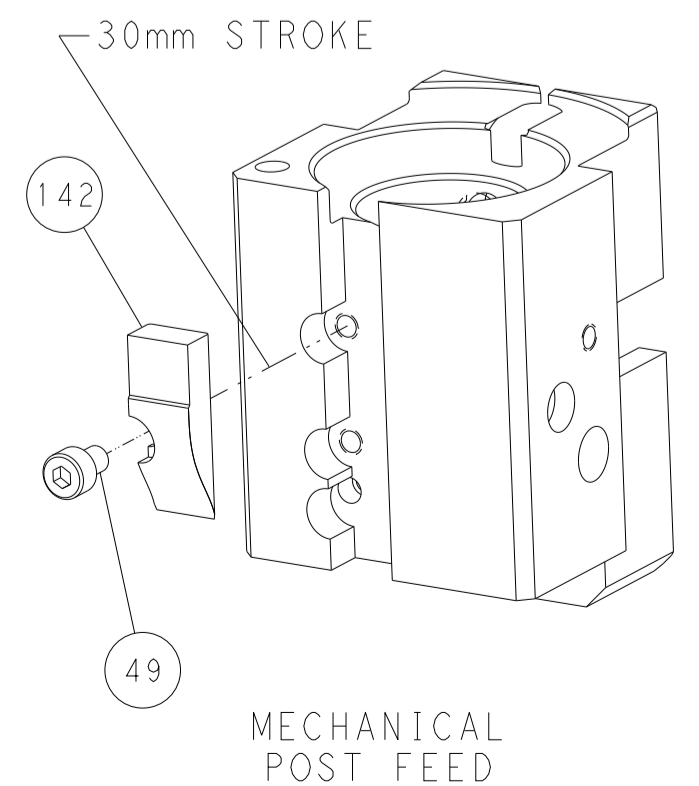
PNEUMATIC



FEED SPRING  
SETTING POSITION



CAM POSITIONS



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:		OWN: R. O. WILSON 19AUG2014		NAME: STE TE Connectivity	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	5 PLC ±	Harrisburg, PA 17105-3608
	ANGLES	FINISH		APVD: T. L. ELBIN 20AUG2014	PRODUCT SPEC	APPLICATION SPEC	RESTRICTED TO
MATERIAL:				WEIGHT:	SCALE: 1:1	SHEET 4 OF 4	REV D