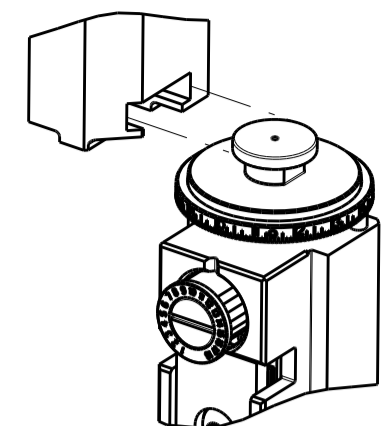


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150471-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150471-2	C	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150471-7	B	CRIMP TOOLING KIT	-

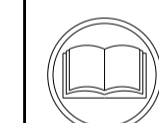
ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	5.46 mm [.215]	F
INSUL	7.62 mm [.300]	F
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION
TERMINAL NAME: TERMINAL		
WIRE STRIP LENGTH 6.00-6.80 mm [.236-.268 IN]	INSULATION DIAMETER RANGE 7.00-8.20 mm [.276-.323 IN]	
TERMINAL APPLICATION SPECIFICATION	CUSTOMER DRAWING 1544453	
TERMINALS APPLIED		
TE TERMINAL 1544453-1	TE TERMINAL	TE TERMINAL

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
10.00mm ²	3.58 +/- 0.05 [.141 +/- .002]	5.6
7.00mm ²	3.20 +/- 0.05 [.126 +/- .002]	9.6



- △ 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 ITEM 180. 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.

***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.

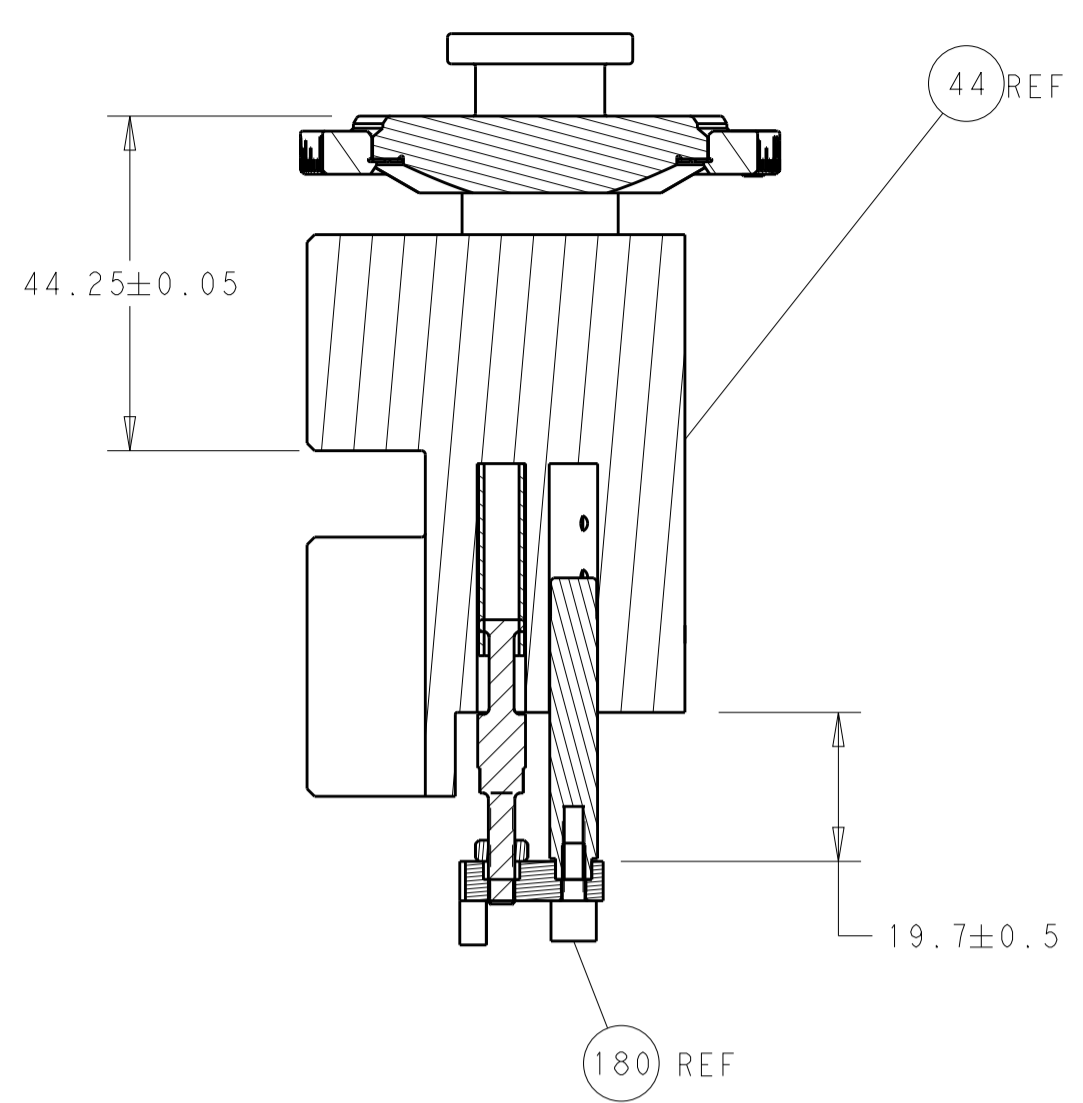
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

LOC	DIST	REVISIONS					
		P	LTN	DESCRIPTION	DATE	OWN	APVD
A	66	A		RELEASED	13OCT2014	BH	GB
		B		ECR-14-015484	17OCT2014	YY	GB
		C		ECR-21-000876	22JAN2021	FZ	TE

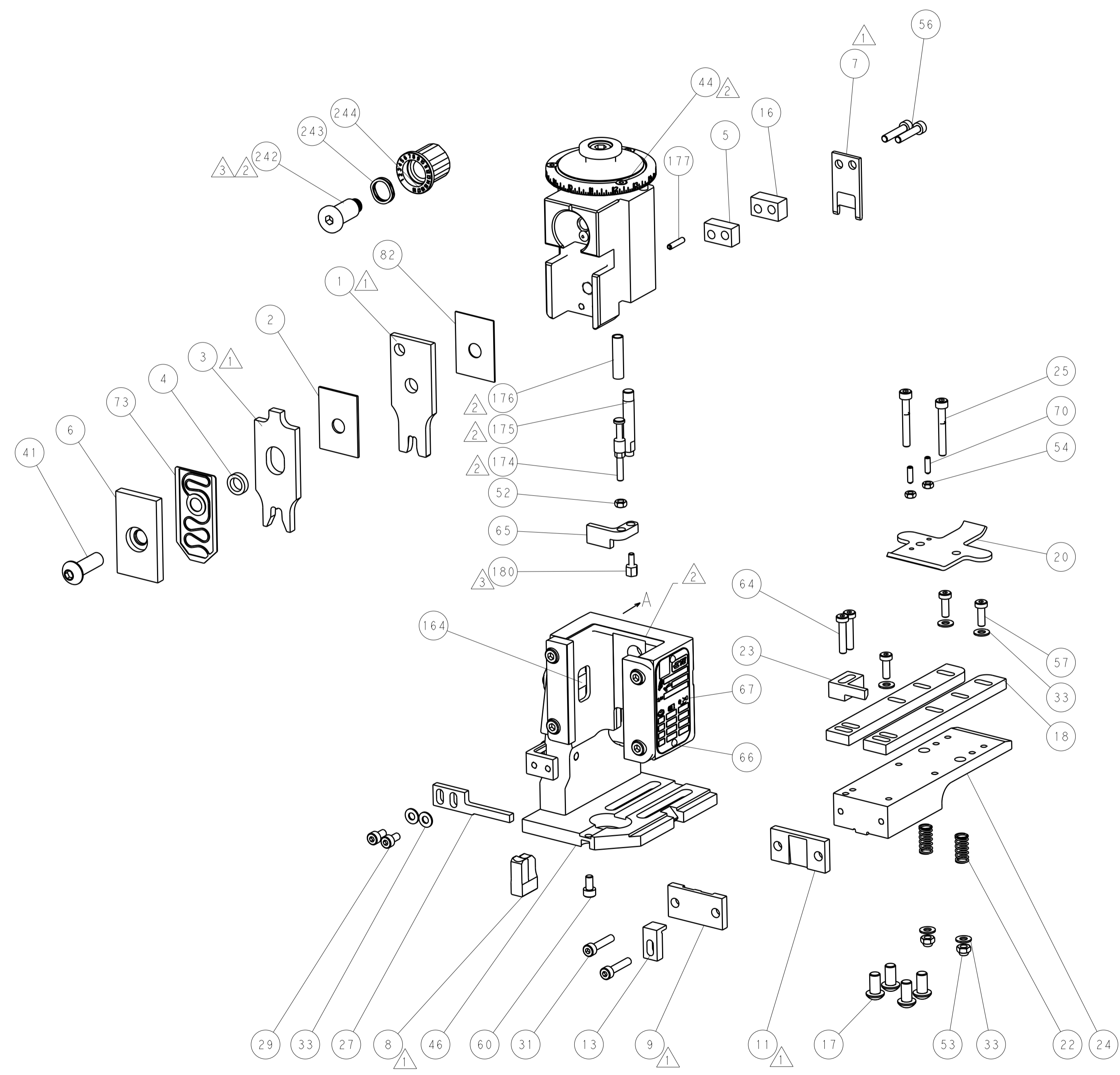
-	1	1	2119641-1	FEED CAM, AIR FEED	248	
-	1	1	2119082-3	CAM, SNAIL, INSULATION ADJUSTMENT	244	
-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243	
△	1	1	2119083-1	RETAINER, INSULATION DIAL	242	
-	1	1	2844940-4	AIR FEED MODULE	238	
△	1	1	1752354-6	STANDOFF, HOLD-DOWN	180	
-	1	1	6-993111-6	PIN, SLOTTED 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	455888-5	SPACER, CRIMPER	82	
-	1	1	1-2119791-4	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	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	2168400-1	SHCS, LOW HEAD, RoHS, M4 X 12	57	
-	2	2	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	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	2063961-1	FEED FINGER	51	
-	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	690455-1	STRIPPER, FRONT CASTING	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	240825-3	PLATE, STRIP HOLD DOWN	23	
-	2	2	2-22281-3	SPRING, COMPRESSION	22	
-	1	1	1803292-4	DRAG	20	
-	2	2	1901259-9	GUIDE, LOWER STRIP	18	
-	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17	
-	1	1	5-240641-1	SPACER	16	
-	1	1	1752360-1	SPACER, HOLD-DOWN	13	
△	1	1	240644-9	PLATE, REAR SHEAR	11	
-	-	-	-	-	10	
△	1	1	6-690482-3	PLATE, FRONT SHEAR	9	
△	1	2	1	5-1803001-7	ANVIL, COMBINATION, END FEED	8
△	1	1	1	1-2217206-0	BLADE, SLUG	7
△	1	1	1	1803203-1	BLOCK, FRONT DEPRESSOR	6
-	1	1	1	2-240641-7	SPACER	5
-	1	1	1	3-238011-8	BLOCK, CRIMPER SPACER	4
△	1	2	1	4-1803017-7	CRIMPER, INSULATION F	3
-	1	1	1	1-455888-0	SPACER, CRIMPER	2
△	1	2	1	7-1633738-9	CRIMPER, WIRE	1
-	77	72	2	PART NO	DESCRIPTION	ITEM NO

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		OWN	31JULY2014	 TE Connectivity Harrisburg, PA 17105-3608
mm		0 PLC ±		CHK	31JULY2014	
		1 PLC ±		G. BAILEY	31JULY2014	
		2 PLC ±		APVD	31JULY2014	
		3 PLC ±		NAME		Ocean End Feed Applicator
		4 PLC ±		PRODUCT SPEC		
		ANGLES ±		APPLICATION SPEC		SIZE
		FINISH ±		WEIGHT		CAGE CODE
				MATERIAL		DRAWING NO
				FINISH		RESTRICTED TO
				CUSTOMER ACCESSIBLE PRODUCTION DRAWING		SCALE
				SCALE		SHEET
				SCALE		OF
				SCALE		REV
				SCALE		C

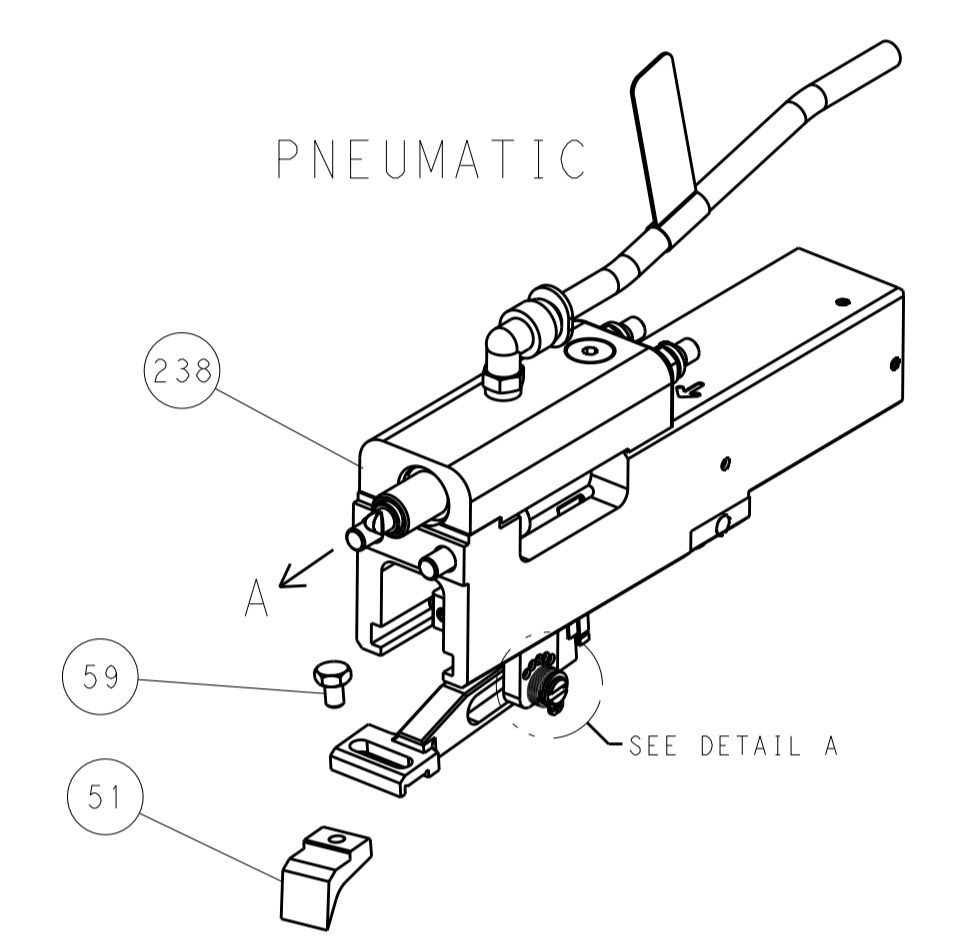
LOC	DIST	REV	DATE	BY	APPV
A	66				
REVISIONS			DESCRIPTION	DATE	DWN
			SEE SHEET 1		



RAM AND HOLDDOWN SET-UP

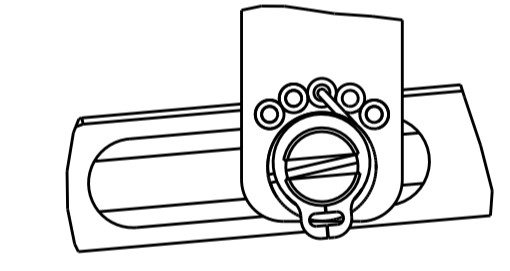


FEED TYPE



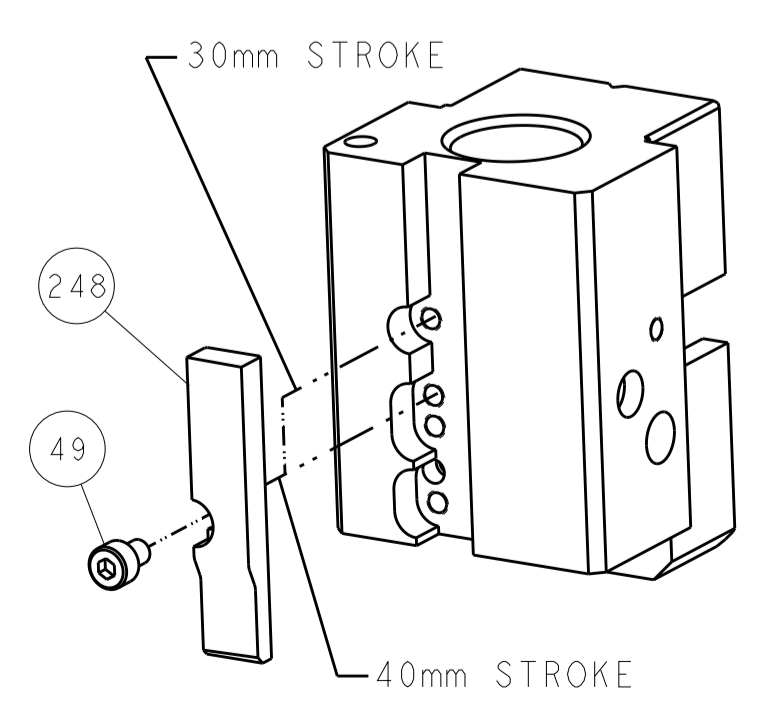
PNEUMATIC

FEED SPRING SETTING POSITION



DETAIL A

CAM POSITION



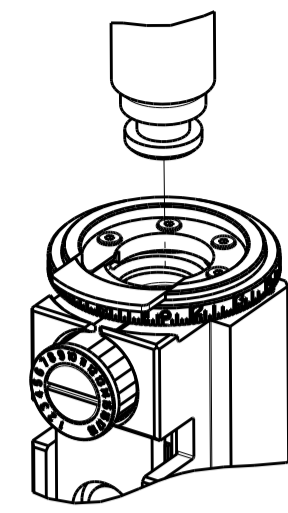
AIR FEED

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

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DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		NAME: Ocean End Feed Applicator PRODUCT SPEC: APPLICATION SPEC: SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2150471	RESTRICTED TO:
MATERIAL:		WEIGHT:	SCALE: 1:1 SHEET: 2 of 4 REV: C

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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150471-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150471-7	B	CRIMP TOOLING KIT	-

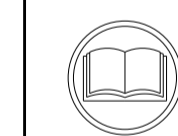
PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	5.46 mm [.215]	F
INSUL	7.62 mm [.300]	F
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: TERMINAL			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
6.00-6.80 mm [.236-.268 IN]		7.00-8.20 mm [.276-.323 IN]	
TERMINAL APPLICATION SPECIFICATION	CUSTOMER DRAWING 1544453		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
1544453-1			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
10.00mm2	3.58+/-0.05 [.141+/-0.002]	5.6
7.00mm2	3.20+/-0.05 [.126+/-0.002]	9.6



- 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 ITEM 180. 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 PITCH NOT COMPATIBLE WITH MECHANICAL FEED.

***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.

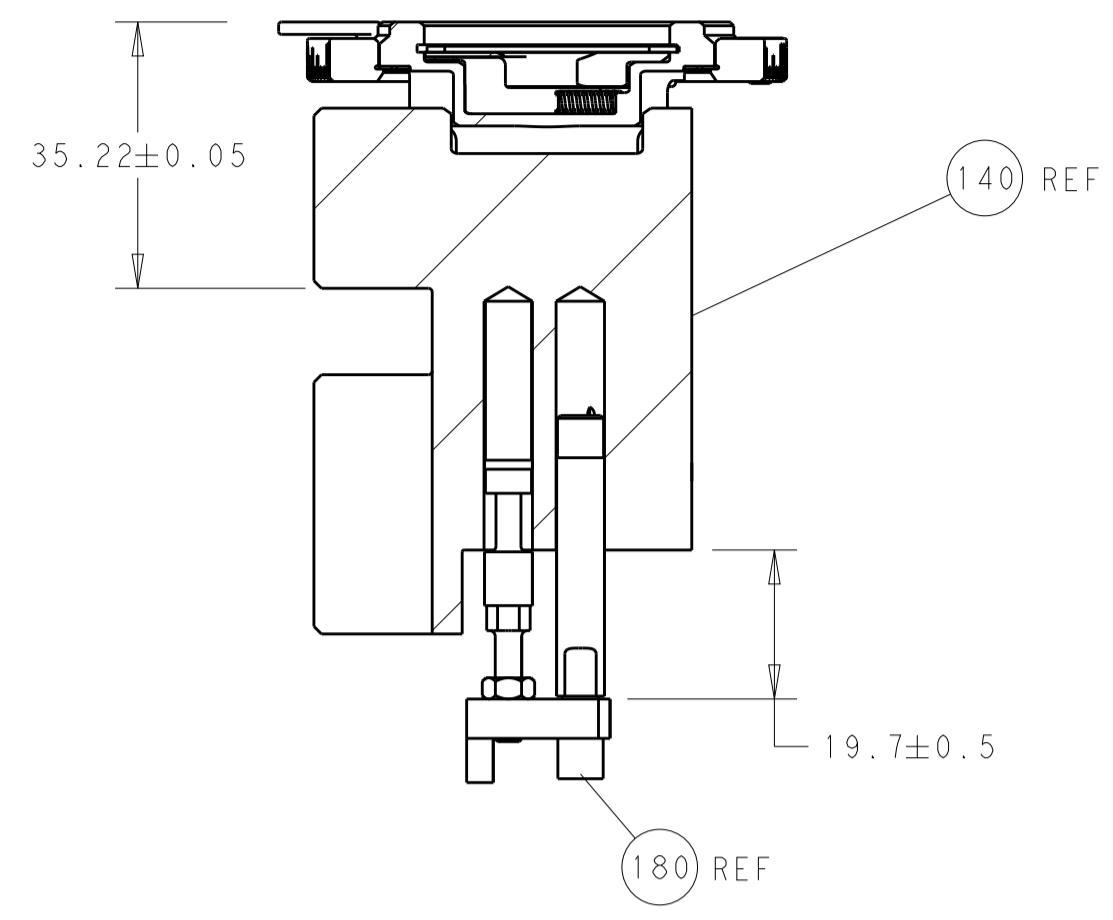
PACIFIC VERSION
Shown on sheets 3 of 4 & 4 of 4
(Atlantic version shown on sheets 1 of 4 & 2 of 4)

LOC	DIST	REVISIONS			
A	66	REV	DATE	BY	APPD
		-			
		-	SEE SHEET 1		

-	1	2119082-3	CAM, SNAIL, INSULATION ADJUSTMENT	244	
-	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243	
3	-	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	2844940-4	AIR FEED MODULE	238	
-	4	2079383-9	SCR, BHSC, RoHS (M6 X 20)	186	
3	-	1	1752354-6	STANDOFF, HOLD-DOWN	180
-	1	6-993111-6	PIN, SLOTTED SPRING 3.0 X 14.0	177	
-	1	8-22280-7	SPRING, COMPRESSION	176	
-	1	1752353-2	GUIDE PIN, HOLDDOWN	175	
-	1	1901680-2	GUIDE PIN, HOLDDOWN	174	
-	REF	994970-2	COUNTER, MAGNETIC	164	
-	1	2119641-2	FEED CAM, AIR FEED	152	
-	1	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	144	
-	1	2119655-6	APPLICATOR BASIC ASSEMBLY, EF	141	
-	1	1803518-1	RAM ASSEMBLY, EF PACIFIC	140	
-	1	455888-5	SPACER, CRIMPER	82	
-	1	1-2119791-4	DEPRESSOR, WIRE	73	
-	1	1803607-4	DOCUMENTATION PACKAGE	71	
-	2	2-18032-2	SCR, SET, FLT PNT, M3 X 10.0	70	
-	1	2119740-1	TAG, IDENTIFICATION	67	
-	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66	
-	1	1901681-1	HOLDDOWN, TERMINAL	65	
-	2	2168400-5	SHCS, LOW HEAD, RoHS, M4 X 20	64	
-	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59	
-	3	2168400-1	SHCS, LOW HEAD, RoHS, M4 X 12	57	
-	2	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	56	
-	2	5018030-1	NUT, HEX, REG, RoHS, M3	54	
-	2	986965-8	NUT, LOCK, HEX, TORQUE (M4)	53	
-	1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52	
-	1	2063961-1	FEED FINGER	51	
-	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49	
-	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41	
-	7	1-18028-2	WASHER, FLAT, REG M4	33	
-	2	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	31	
-	2	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	29	
-	1	690455-1	STRIPPER, FRONT CASTING	27	
-	2	1-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 30	25	
-	1	1752371-5	PLATE, STRIP GUIDE	24	
-	1	240825-3	PLATE, STRIP HOLD DOWN	23	
-	2	2-22281-3	SPRING, COMPRESSION	22	
-	1	1803292-4	DRAG	20	
-	2	1901259-9	GUIDE, LOWER STRIP	18	
-	1	5-240641-1	SPACER	16	
-	1	1752360-1	SPACER, HOLD-DOWN	13	
1	-	1	240644-9	PLATE, REAR SHEAR	11
-	-	-	-	-	10
1	1	6-690482-3	PLATE, FRONT SHEAR	9	
1	1	5-1803001-7	ANVIL, COMBINATION, END FEED	8	
1	1	1-2217206-0	BLADE, SLUG	7	
-	1	1803203-1	BLOCK, FRONT DEPRESSOR	6	
-	1	2-240641-7	SPACER	5	
-	1	3-238011-8	BLOCK, CRIMPER SPACER	4	
1	1	4-1803017-7	CRIMPER, INSULATION F	3	
-	1	1-455888-0	SPACER, CRIMPER	2	
1	1	7-1633738-9	CRIMPER, WIRE	1	
-	77-22	PART NO	DESCRIPTION	ITEM NO	

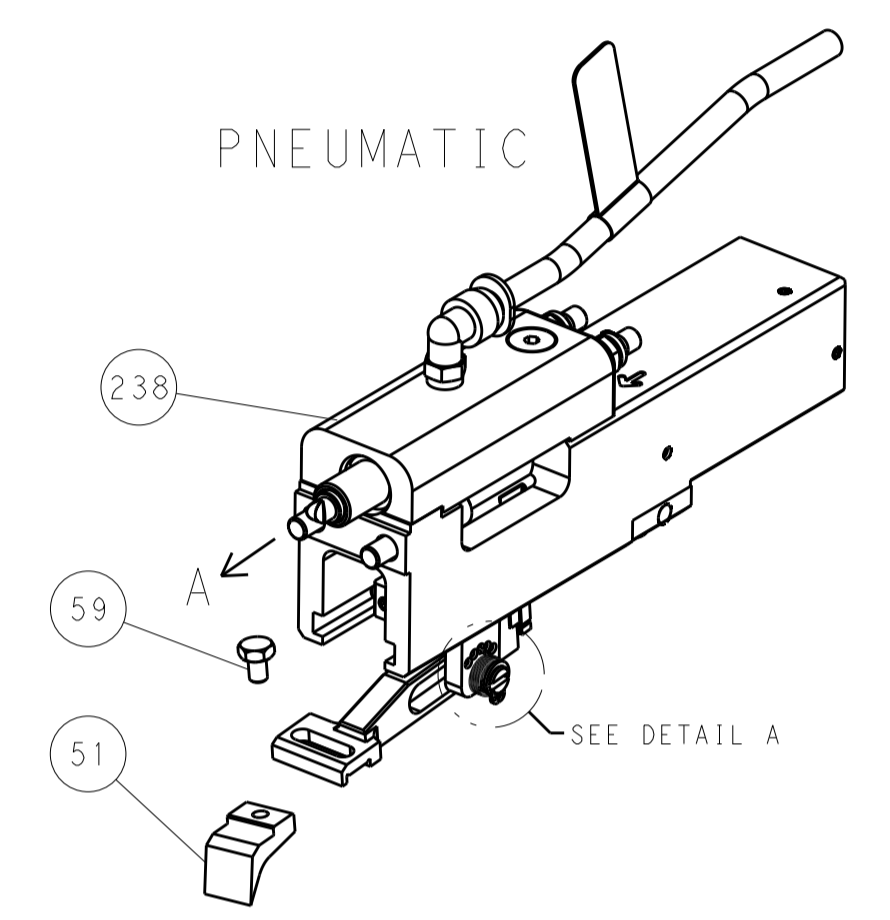
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DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH	PRODUCT SPEC APPLICATION SPEC SIZE CAGE CODE DRAWING NO A1 00779 C=2150471 RESTRICTED TO
MATERIAL:		WEIGHT:	SCALE: 1:1 SHEET 3 OF 4 REV C

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

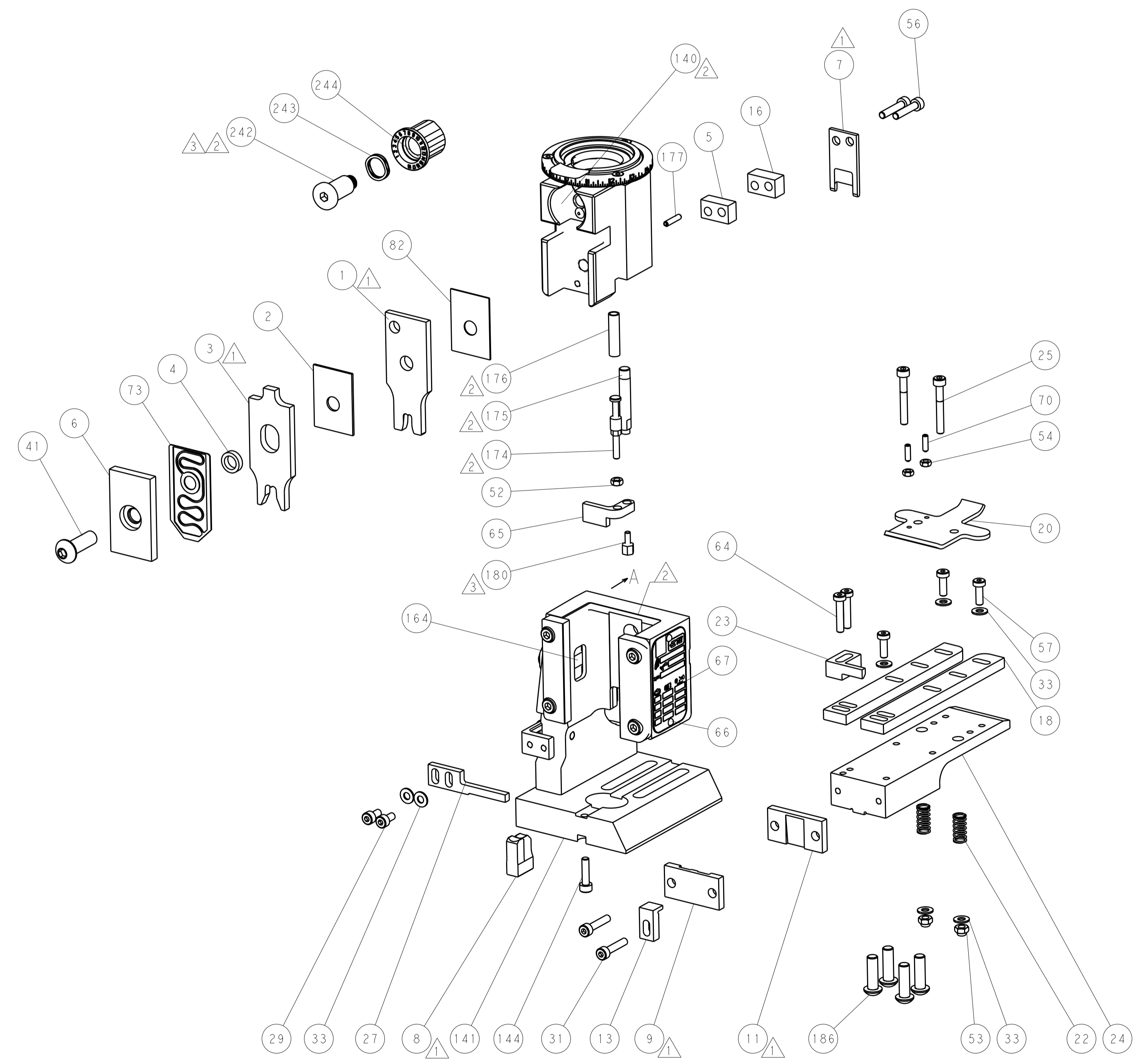
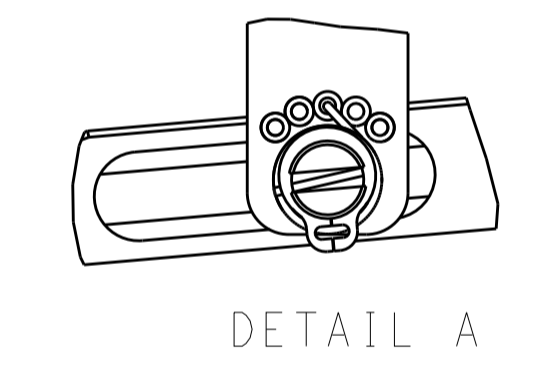


RAM AND HOLDDOWN SET-UP

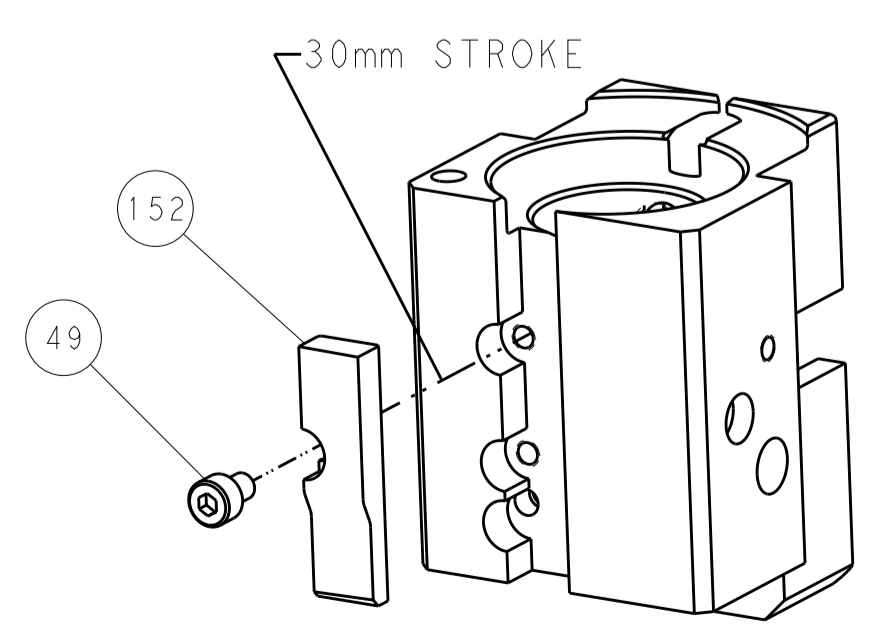
FEED TYPE



FEED SPRING SETTING POSITION



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:		DWN: K. STAKEM 31JULY2014		STE TE Connectivity	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES ±	Harrisburg, PA 17105-3608
MATERIAL:	FINISH:	WEIGHT:	SCALE:	APVD: T. ERLIN 31JULY2014	NAME:	RESTRICTED TO:	
			1:1	PRODUCT SPEC:	Ocean End Feed Applicator		
				APPLICATION SPEC:			
				Customer Accessible Production Drawing	00779 ©=2150471		