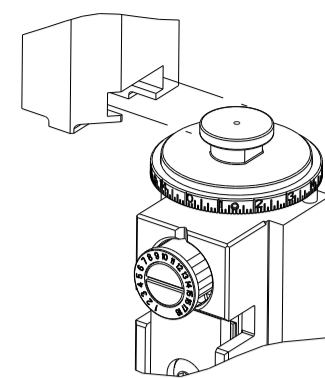


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150268-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150268-2	C	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150268-7	A	CRIMP TOOLING KIT	-

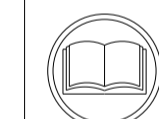
ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



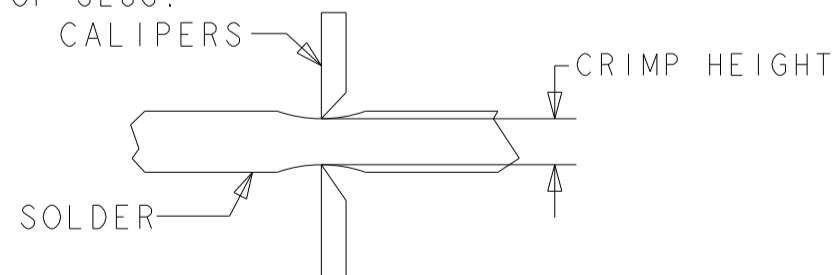
APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	6.02 mm [.237]	D
INSUL	-	-
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPEC
TERMINAL NAME: RECPT, ULTRA-FAST FLAG, .187 SERIES		
WIRE STRIP LENGTH 7.51-8.33 mm [.296-.328 IN]	INSULATION DIAMETER RANGE Ø .185 MAX	
TERMINAL APPLICATION SPECIFICATION 114-2123		
TERMINALS APPLIED Δ 4		
TE TERMINAL	TE TERMINAL	TE TERMINAL
3-520338-2	6-520338-2	9-520340-2
5-520338-2	3-520340-2	

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING	Ø SOLDER
14	1.905+/-0.05 [.075+/- .002]	4.8	.19 in [4.83mm]
16	1.778+/-0.05 [.070+/- .002]	6.0	.19 in [4.83mm]



- Δ 1 RECOMMENDED SPARE PARTS
- Δ 2 REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- Δ 3 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.
- Δ 4 TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- Δ 5 TO CHECK CRIMP HEIGHT, CRIMP SOLDER (Ø .19 IN [4.83mm] 60/40 SOLID CORE) AND MEASURE AT CENTER OF SLUG.



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.

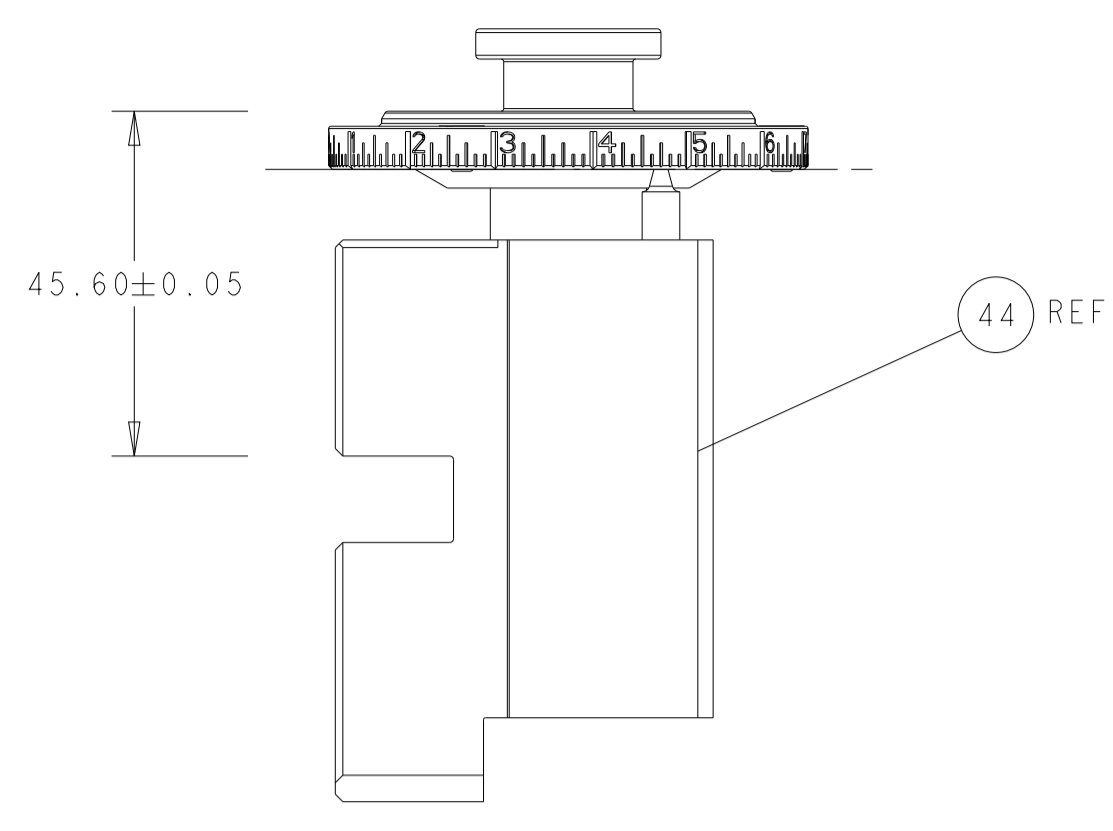
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		A	01OCT2012	BW	TE
		B	15SEP2018	JAH	TE
		C	05AUG2021	FJ	TE

-	1	1	2119641-1	FEED CAM, AIR FEED	248		
-	1	1	2844940-3	AIR FEED MODULE	238		
-	1	1	467281-1	RETAINER, SHEAR, FLOATING	207		
-	1	1	2161936-1	HOLDER, SHEAR, FLOATING	206		
-	1	1	467500-1	SHEAR, FLOATING	205		
-	1	1	1-18028-0	WASHER, FLAT, REG M8	192		
-	REF	REF	994970-2	COUNTER, MAGNETIC	164		
-	1	1	2161937-2	STABILIZER	154		
-	1	1	1803607-4	DOCUMENTATION PACKAGE	71		
-	1	1	3-18032-3	SCR, SET, FLT PNT, M3 X 20.0	70		
-	1	1	2-18032-2	SCR, SET, FLT PNT, M3 X 10.0	69		
-	1	1	2119740-1	TAG, IDENTIFICATION	67		
-	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66		
-	3	3	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	60		
-	-	-	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59		
-	4	4	2168400-1	SHCS, LOW HEAD, RoHS, M4 X 12	57		
-	2	2	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	56		
-	2	2	5018030-1	NUT, HEX, REG, RoHS, M3	54		
-	2	2	986965-8	NUT, LOCK, HEX, TORQUE (M4)	53		
-	1	1	2352966-1	FEED FINGER	51		
-	1	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49		
-	1	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		
-	2	2	5-22278-1	SPRING, COMPRESSION	36		
-	8	8	1-18028-2	WASHER, FLAT, REG M4	33		
-	2	2	2079383-4	SCR, BHSC, RoHS (M4 X 8)	31		
-	2	2	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	29		
-	1	1	690455-3	STRIPPER, FRONT CASTING	27		
-	2	2	1-2168083-6	SCR, SKT HD CAP, RoHS, M4 X 35	25		
-	1	1	2161941-2	PLATE, GUIDE, STRIP	24		
-	2	2	22281-9	SPRING, COMPRESSION	22		
-	1	1	2161948-1	DRAG	20		
-	1	1	683736-1	GUIDE, STRIP, REAR	19		
-	1	1	683737-1	FRONT STRIP GUIDE	18		
-	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17		
-	1	1	4-22280-7	SPRING, COMPRESSION	13		
-	1	2	1	2161935-3	ANVIL, RIGHT HAND	8	
-	1	1	1	2161957-1	DEPRESSOR, SHEAR	5	
-	1	1	1	238011-2	BLOCK, CRIMPER SPACER	4	
-	1	1	1	2161331-1	SPACER, WIRE FUNNEL DEPRESSOR	2	
-	1	2	1	1	467342-4	CRIMPER, RIGHT HAND	1
-	77-72	-2		PART NO	DESCRIPTION	ITEM NO	

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

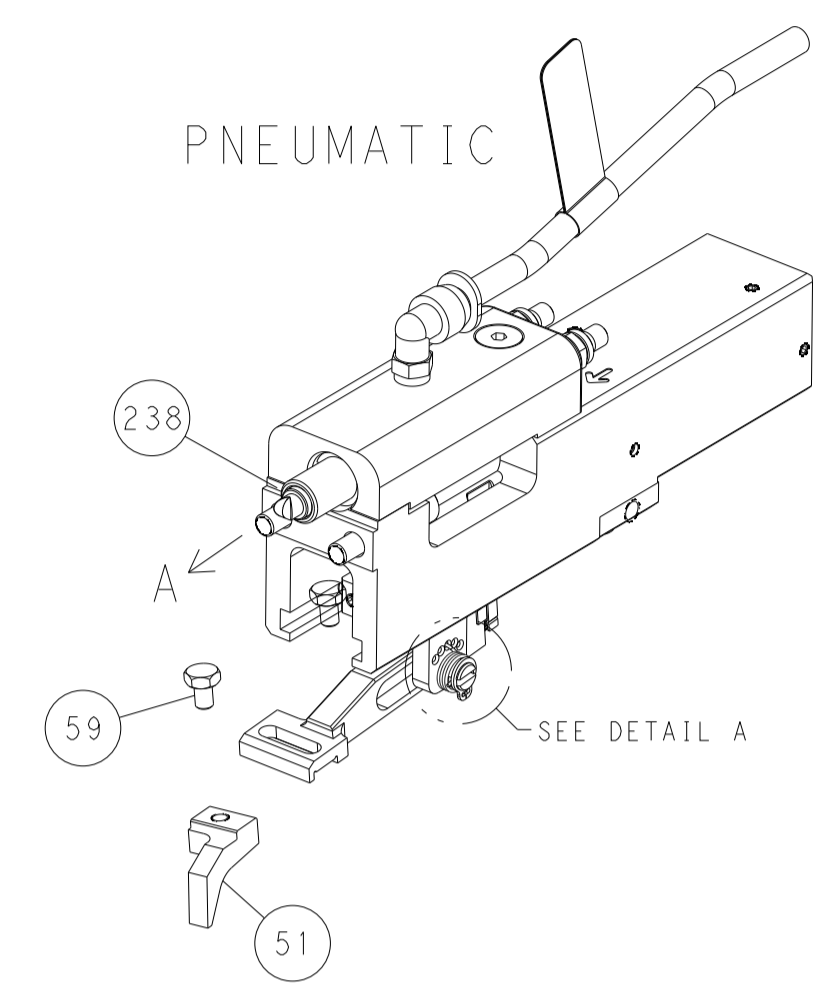
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		MATERIAL:	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±
	ANGLES	FINISH			
APPROVED: B. WEAVER 19JUN2012		APPROVED: T. ELBIN 19JUN2012		APPROVED: T. ELBIN 19JUN2012	
NAME: TE Connectivity		NAME: TE Connectivity		NAME: TE Connectivity	
ADDRESS: Harrisburg, PA 17105-3608		ADDRESS: Harrisburg, PA 17105-3608		ADDRESS: Harrisburg, PA 17105-3608	
SIZE: A1		CAGE CODE: 00779		DRAWING NO: 2150268	
RESTRICTED TO:		SCALE: 1:1		SHEET: 1 OF 4	
Customer Accessible Production Drawing		SCALE: 1:1		SHEET: 1 OF 4	

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

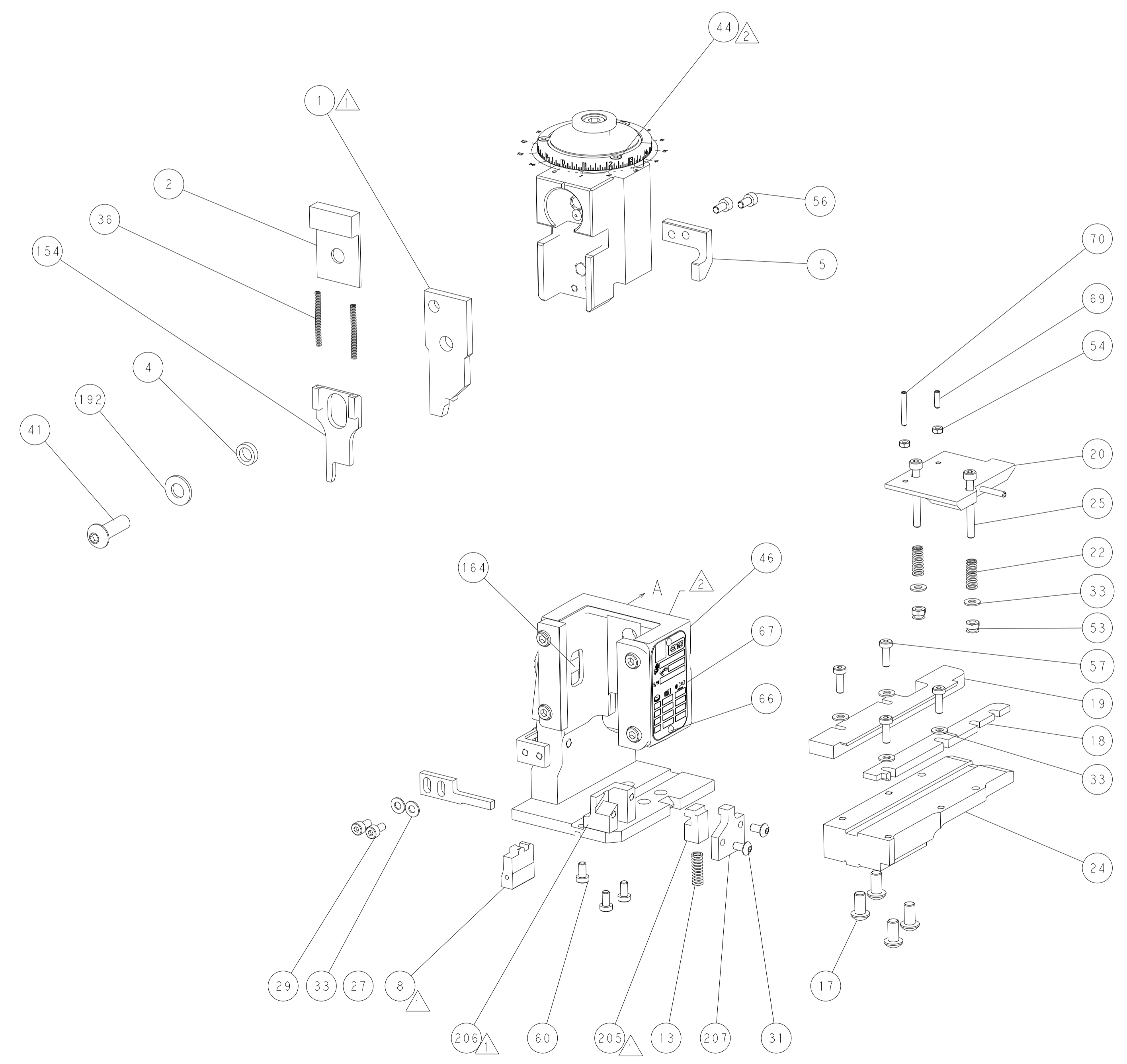
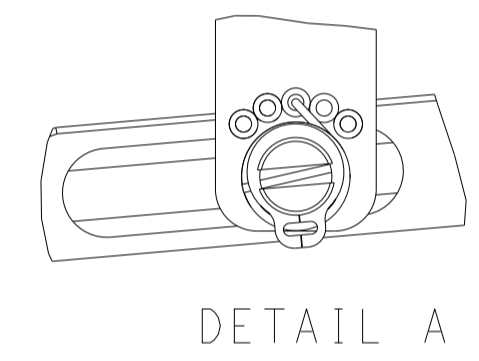


RAM SET-UP

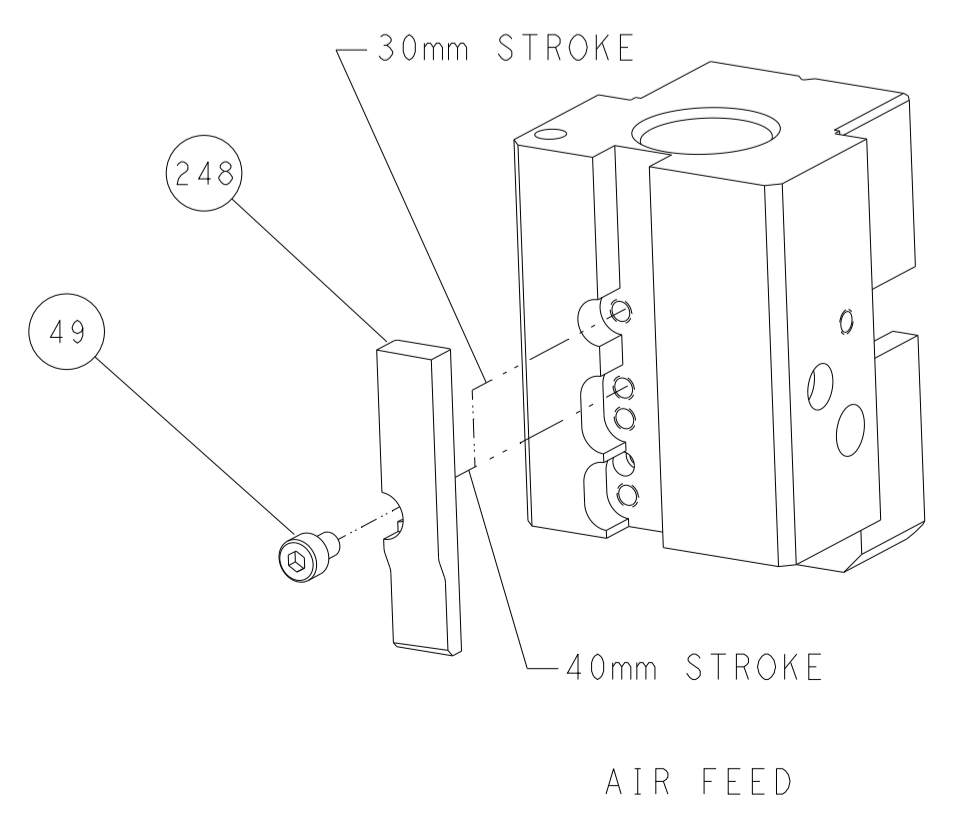
FEED TYPE



FEED SPRING SETTING POSITION



CAM POSITION

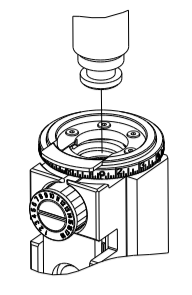


ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

<small>THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION 2012. COPYRIGHT 2012 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.</small>		DMN: B. WEAVER CHK: T. ELBIN APVD: T. ELBIN	19JUN2012 19JUN2012 19JUN2012	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 End Feed Applicator PRODUCT SPEC: APPLICATION SPEC: WEIGHT:	SIZE: A1 CAGE CODE: 00779 DRAWING NO: C-2150268 SCALE: 1:1 SHEET: 2 of 4 REV: C	

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150268-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150268-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR INTERFACE ADAPTER



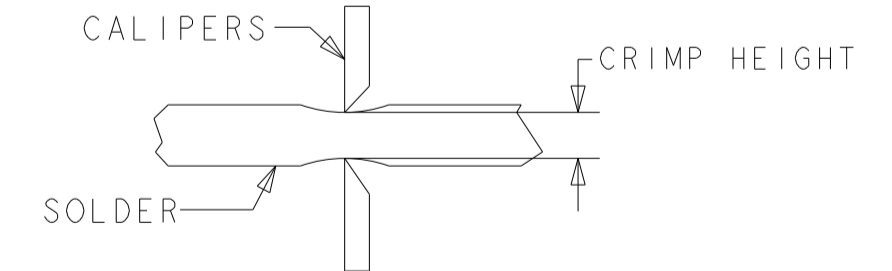
APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	6.02 mm [.237]	D
INSUL	-	-
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPEC
TERMINAL NAME: RECPT, ULTRA-FAST FLAG, .187 SERIES		
WIRE STRIP LENGTH 7.51-8.33 mm [.296-.328 IN]	INSULATION DIAMETER RANGE Ø .185 MAX	
TERMINAL APPLICATION SPECIFICATION 114-2123		
TERMINALS APPLIED 4		
TE TERMINAL	TE TERMINAL	TE TERMINAL
3-520338-2	6-520338-2	9-520340-2
5-520338-2	3-520340-2	

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING	Ø SOLDER
14	1.905+/-0.05 [.075+/- .002]	4.8	.19 in [4.83mm]
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- 1 RECOMMENDED SPARE PARTS
- 2 REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
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- 4 TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- 5 TO CHECK CRIMP HEIGHT, CRIMP SOLDER (Ø.19 IN [4.83mm] 60/40 SOLID CORE) AND MEASURE AT CENTER OF SLUG.



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

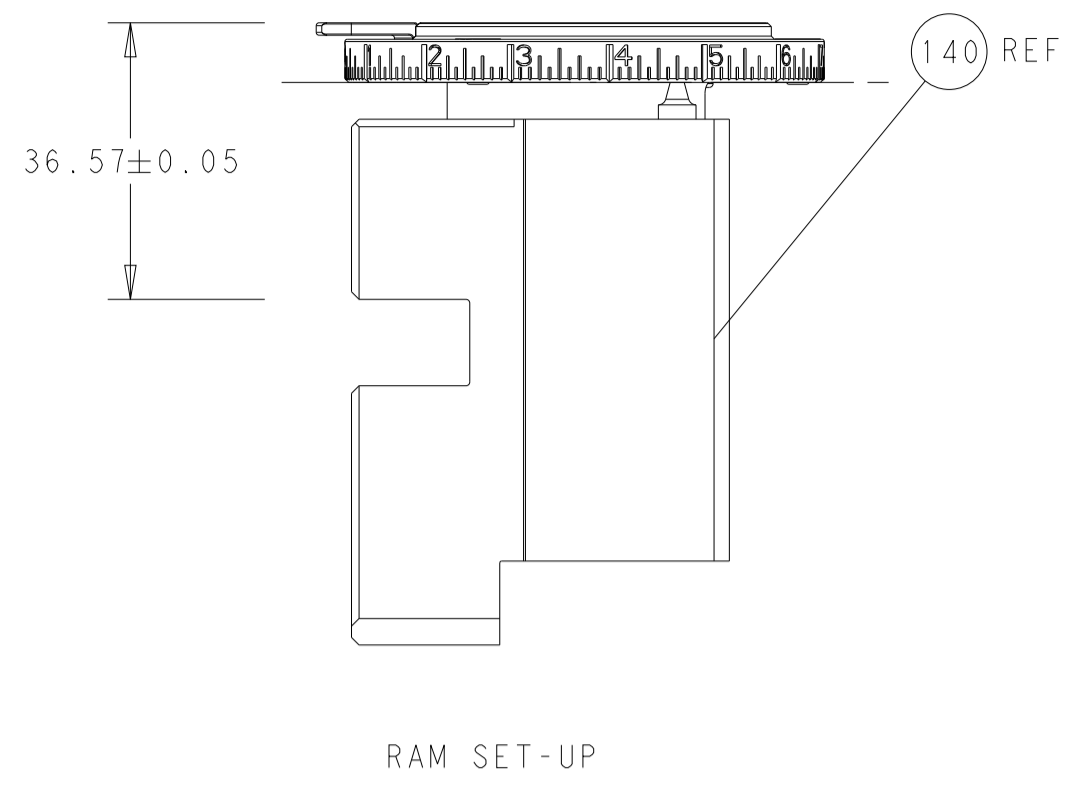
-	1	2844940-3	AIR FEED MODULE	238
-	1	467281-1	RETAINER, SHEAR, FLOATING	207
-	1	2161936-1	HOLDER, SHEAR, FLOATING	206
-	1	467500-1	SHEAR, FLOATING	205
-	1	1-18028-0	WASHER, FLAT, REG M8	192
-	4	2079383-9	SCR, BHSC, RoHS (M6 X 20)	186
-	REF	994970-2	COUNTER, MAGNETIC	164
-	1	2161937-2	STABILIZER	154
-	1	2119641-2	FEED CAM, AIR FEED	152
-	3	2168400-5	SHCS, LOW HEAD, RoHS, M4 X 20	144
-	1	1-2119655-6	APPLICATOR BASIC ASSEMBLY, EF	141
-	1	1803518-1	RAM ASSEMBLY, EF PACIFIC	140
-	1	1803607-4	DOCUMENTATION PACKAGE	71
-	1	3-18032-3	SCR, SET, FLT PNT, M3 X 20.0	70
-	1	2-18032-2	SCR, SET, FLT PNT, M3 X 10.0	69
-	1	2119740-1	TAG, IDENTIFICATION	67
-	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	4	2168400-1	SHCS, LOW HEAD, RoHS, M4 X 12	57
-	2	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	56
-	2	5018030-1	NUT, HEX, REG, RoHS, M3	54
-	2	986965-8	NUT, LOCK, HEX, TORQUE (M4)	53
-	1	2352966-1	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
-	2	5-22278-1	SPRING, COMPRESSION	36
-	8	1-18028-2	WASHER, FLAT, REG M4	33
-	2	2079383-4	SCR, BHSC, RoHS (M4 X 8)	31
-	2	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	29
-	1	690455-3	STRIPPER, FRONT CASTING	27
-	2	1-2168083-6	SCR, SKT HD CAP, RoHS, M4 X 35	25
-	1	2161941-2	PLATE, GUIDE, STRIP	24
-	2	22281-9	SPRING, COMPRESSION	22
-	1	2161948-1	DRAG	20
-	1	683736-1	GUIDE, STRIP, REAR	19
-	1	683737-1	FRONT STRIP GUIDE	18
-	1	4-22280-7	SPRING, COMPRESSION	13
1	1	2161935-3	ANVIL, RIGHT HAND	8
-	1	2161957-1	DEPRESSOR, SHEAR	5
-	1	238011-2	BLOCK, CRIMPER SPACER	4
-	1	2161331-1	SPACER, WIRE FUNNEL DEPRESSOR	2
1	1	467342-4	CRIMPER, RIGHT HAND	1

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

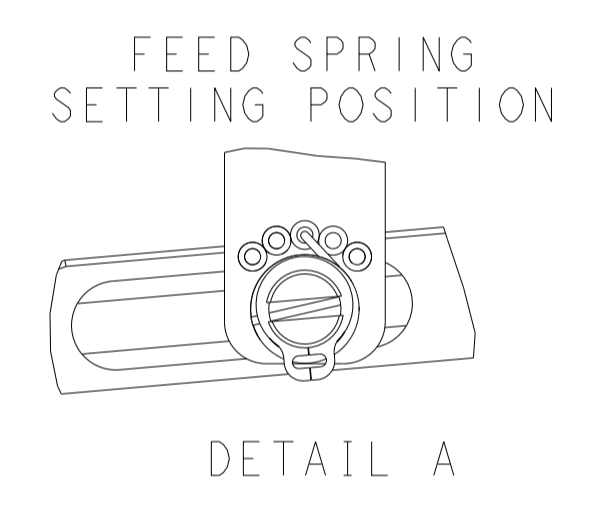
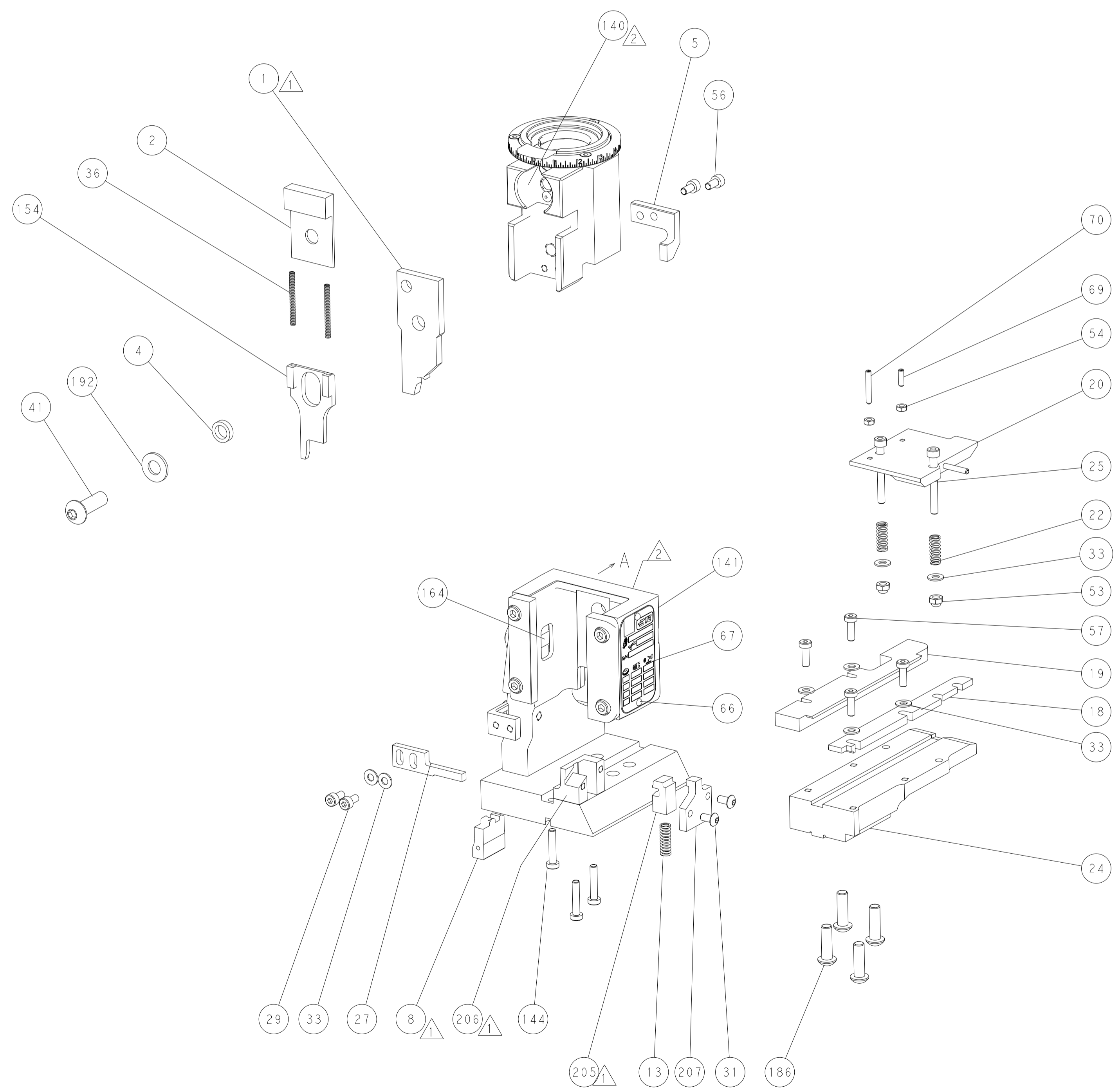
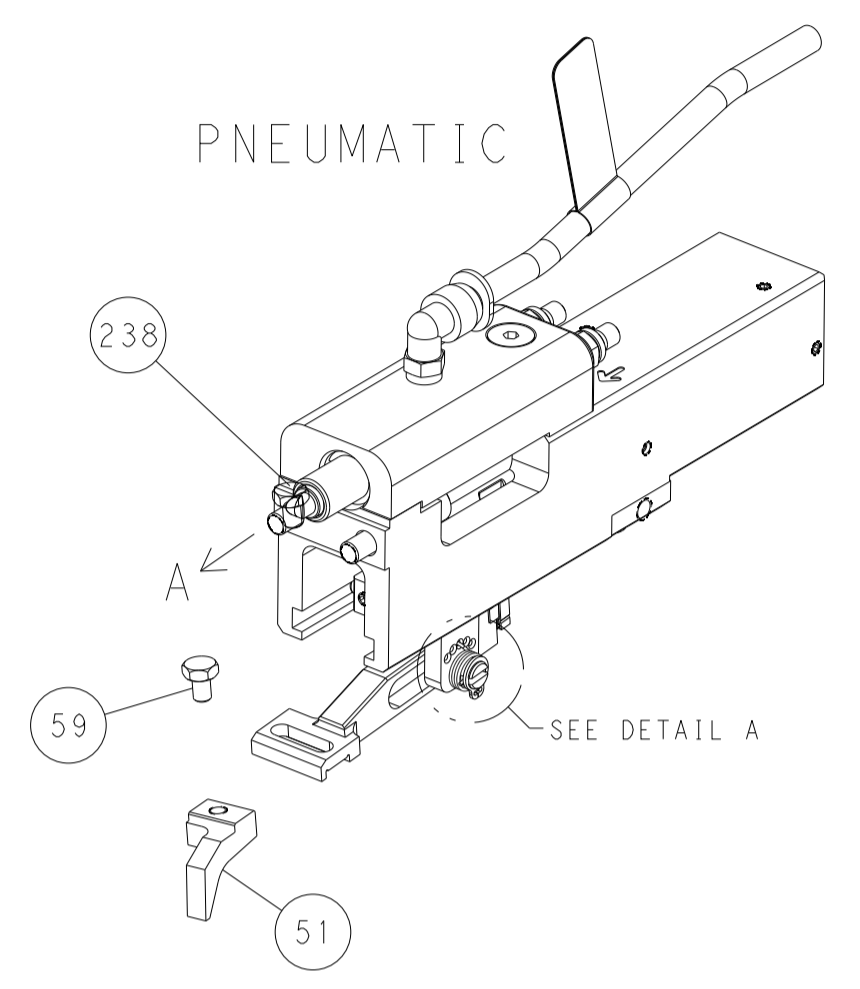
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		APPROVED:		NAME:	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	APVD	NAME
	ANGLES	FINISH					
MATERIAL		WEIGHT		SCALE		SHEET	REV

Customer Accessible Production Drawing

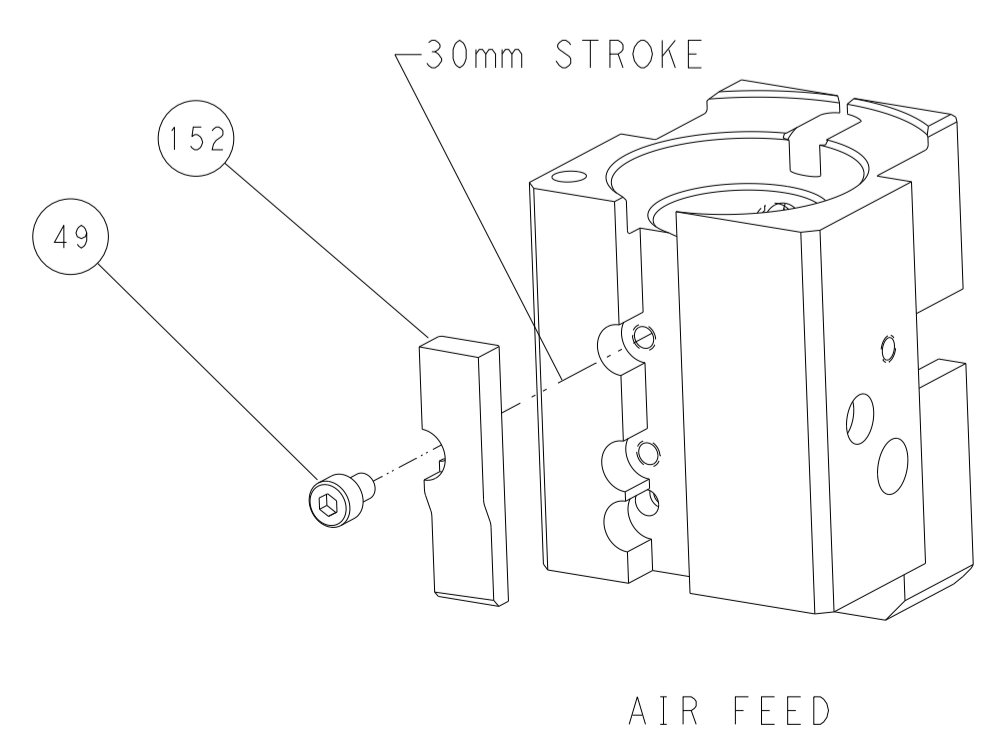
LOC	DIST	REVISIONS			
P	LTN	DESCRIPTION	DATE	OWN	APVD
A	66	SEE SHEET 1	-	-	-



FEED TYPE



CAM POSITION



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

<small>THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION 2012 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.</small>		DWN B. WEAVER 19JUN2012 CHK T. ELBIN 19JUN2012 APVD T. ELBIN 19JUN2012	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 End Feed Applicator PRODUCT SPEC APPLICATION SPEC	
MATERIAL:		WEIGHT:	SIZE: A1 CAGE CODE: 00779 DRAWING NO: C-2150268 SCALE: 1:1 SHEET: 4 OF 4 REV: C