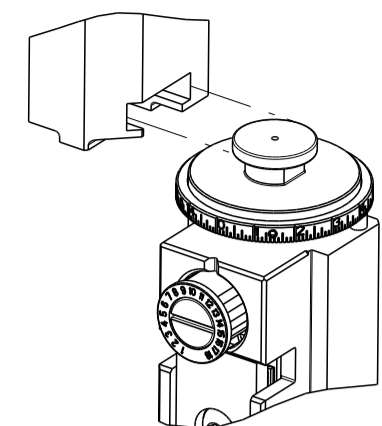


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150435-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150435-2	B	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150435-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.29 mm [.090]	F
INSUL	3.30 mm [.130]	F
APPLICATOR INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: .312 FASTIN-FASTON			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
5.15-5.91 mm [.203-.233 IN]		∅2.29-3.30 mm [.090-.130 IN]	
TERMINAL APPLICATION SPECIFICATION	114-20021	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
160557-1	160557-2	160557-4	

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.50mm2	1.57 +/- 0.05 [.062 +/- .002]	6.7
1.00mm2	1.52 +/- 0.05 [.060 +/- .002]	7.3
0.75mm2	1.47 +/- 0.05 [.058 +/- .002]	7.9
0.50mm2	1.42 +/- 0.05 [.056 +/- .002]	8.3

- 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. APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 180.
- 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.
- 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.

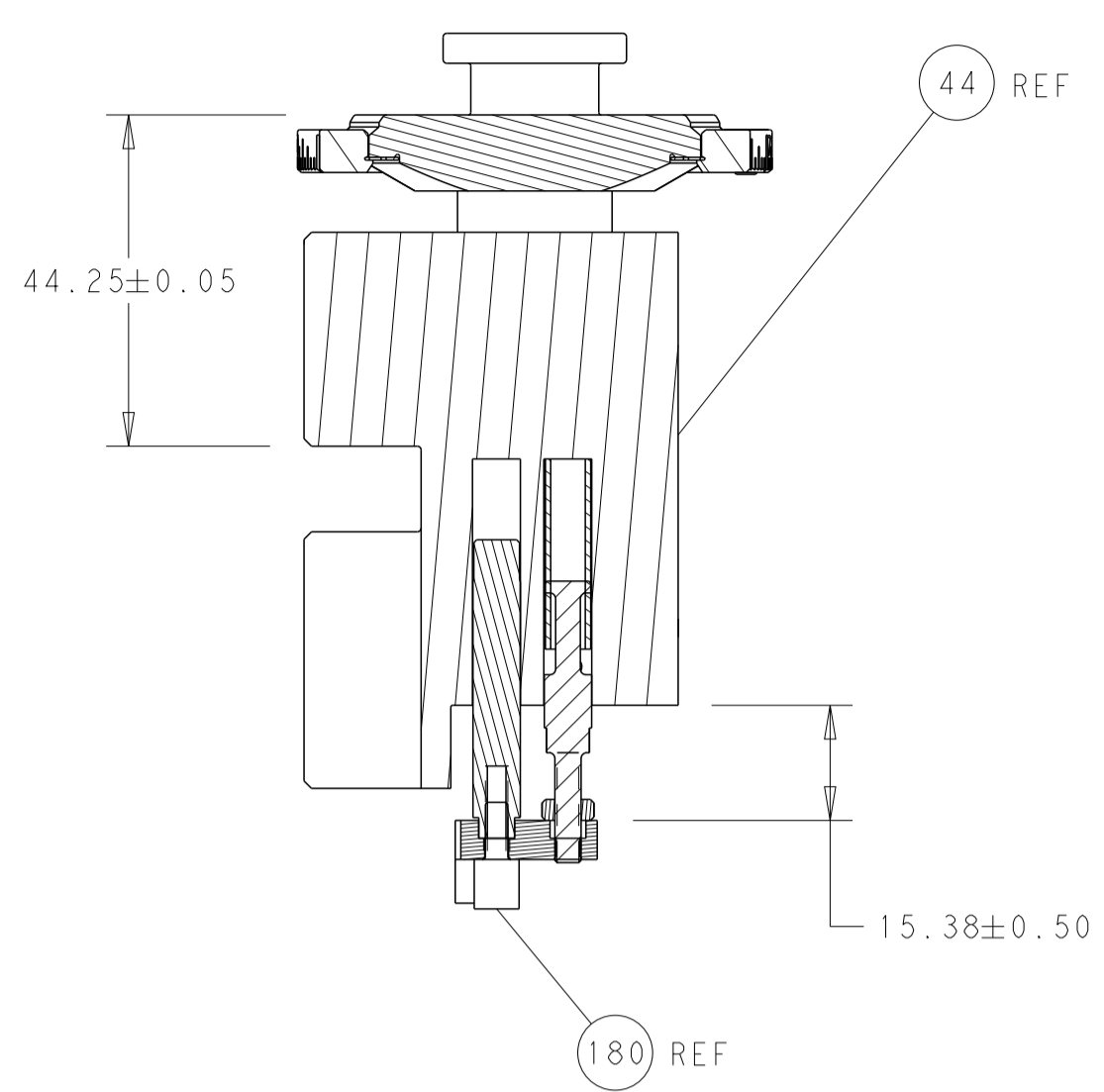
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		P	LTN	DESCRIPTION	DATE	OWN	APVD
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		A		RELEASED	12JUN2014	YY	UG
		B		ECR-22-137735	02MAY2022	JWC	ROY

-	1	1	2119641-1	FEED CAM, AIR FEED	248	
-	1	1	2119082-3	CAM, SNAIL, INSULATION ADJUSTMENT	244	
3	-	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	
3	-	1	1	1-1752354-1	STANDOFF, HOLD-DOWN	180
-	1	1	6-9931111-6	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	455888-4	SPACER, CRIMPER	82	
-	1	1	2119791-9	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	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57	
-	2	2	2-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 14	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	240639-1	STRIPPER (MACHINING)	27	
-	2	2	1-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 30	25	
-	1	1	1-1752371-4	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	1901259-4	GUIDE, LOWER STRIP	18	
-	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17	
-	1	1	240641-4	SPACER	16	
-	1	1	1752360-1	SPACER, HOLD-DOWN	13	
1	-	1	1	240833-4	PLATE, REAR SHEAR	11
-	-	-	-	-	10	
1	-	1	1	6-690482-0	PLATE, FRONT SHEAR	9
1	1	2	1	5-1803000-0	ANVIL, COMBINATION, END FEED	8
1	-	1	1	2217206-8	BLADE, SLUG	7
-	-	-	-	-	6	
-	1	1	1	6-240641-9	SPACER	5
-	1	1	1	238011-3	BLOCK, CRIMPER SPACER	4
1	1	2	1	8-1633961-1	CRIMPER, INSULATION F PREMIUM	3
-	1	1	1	455888-1	SPACER, CRIMPER	2
1	1	2	1	1-456406-6	CRIMPER, WIRE PREMIUM	1
-	77	72	-2	PART NO	DESCRIPTION	ITEM NO

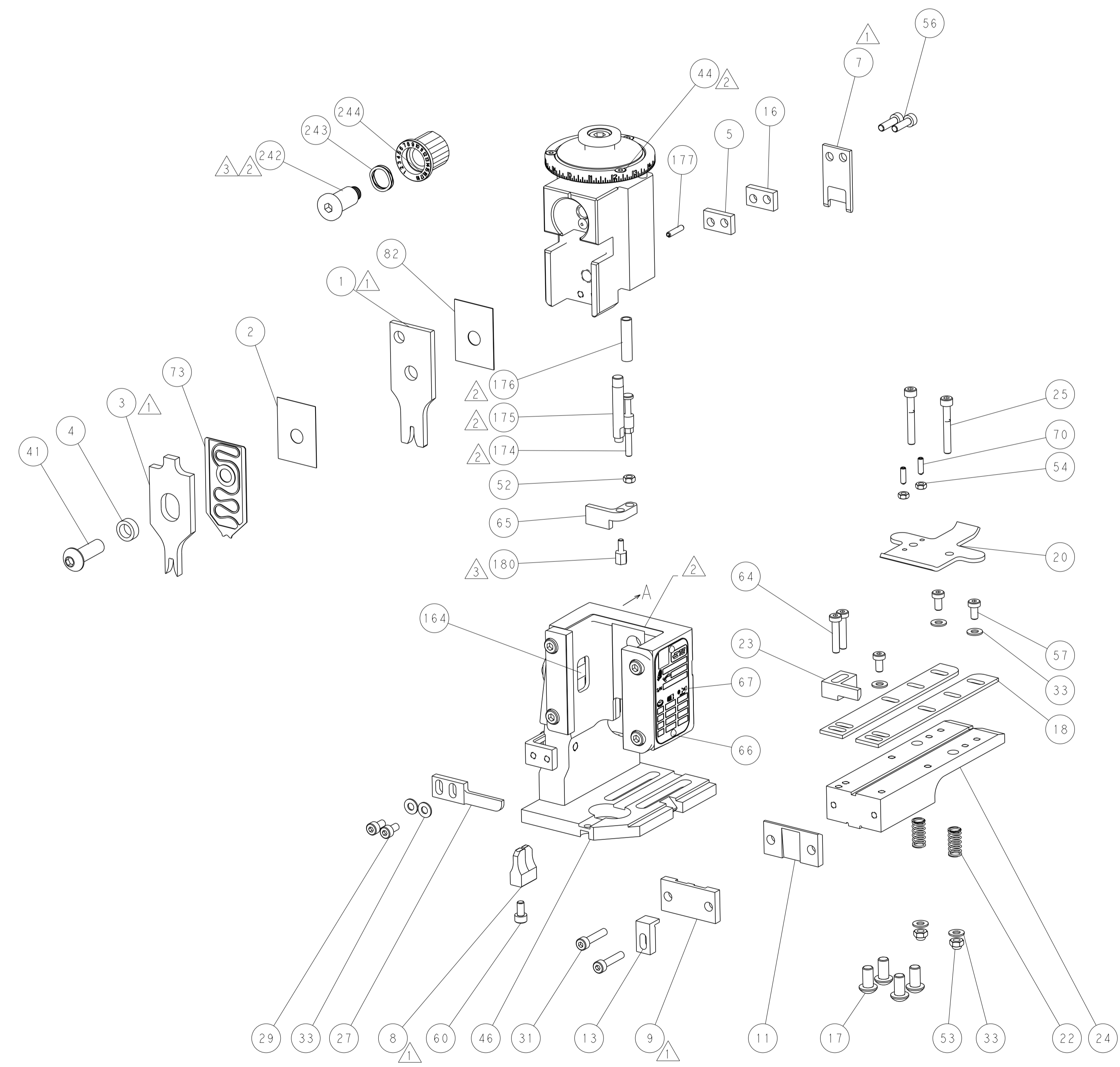
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		OWN	Y. YIN	17APR2014	TE Connectivity Harrisburg, PA 17105-3608
mm		0 PLC ± 1 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH ±		CHK	G. BAILEY	17APR2014	
MATERIAL		FINISH		APVD	J. GUO	17APR2014	NAME
				PRODUCT SPEC		Ocean End Feed Applicator	
				APPLICATION SPEC		SIZE	
				WEIGHT		CAGE CODE DRAWING NO	
				A		00779 C=2150435	
				Customer Accessible Production Drawing		SCALE 1:1 SHEET 1 OF 4 REV B	

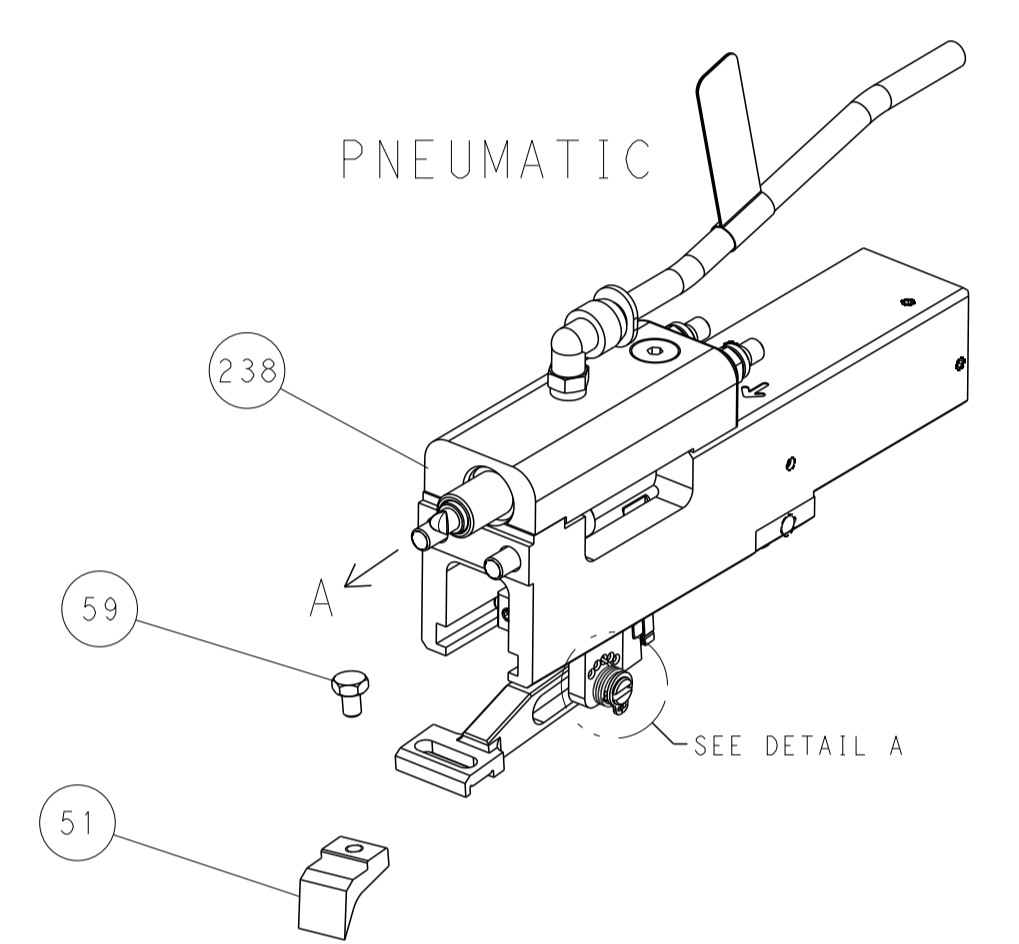
LOC	DIST	REVISIONS			
P	LTN	DESCRIPTION	DATE	OWN	APVD
A	66	SEE SHEET 1	-	-	-



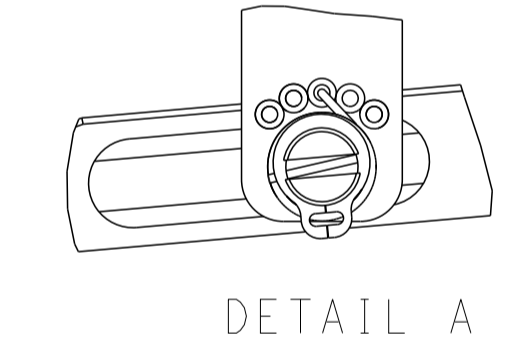
RAM AND HOLDDOWN SET-UP



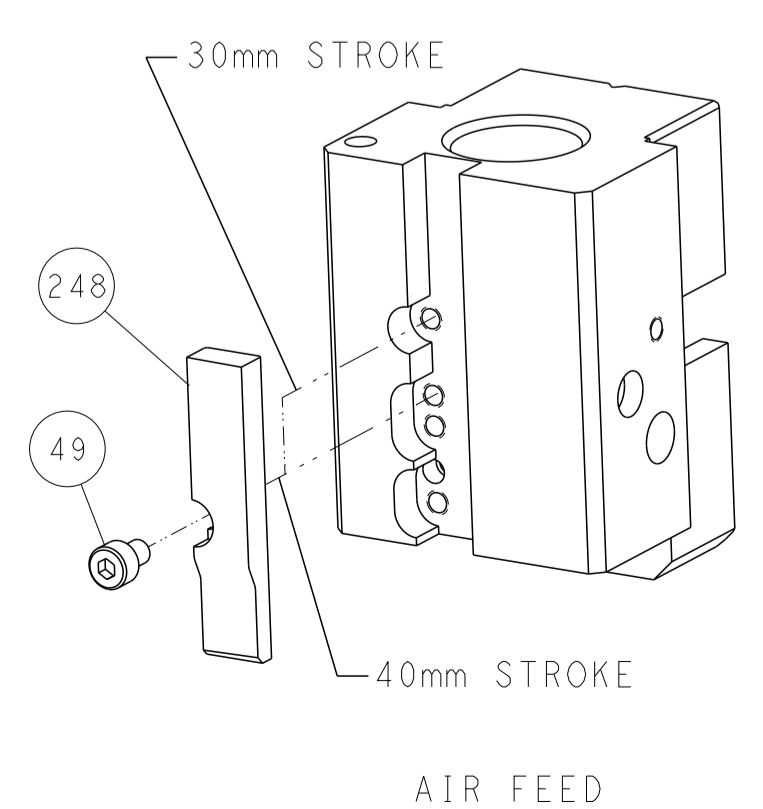
FEED TYPE



FEED SPRING SETTING POSITION



CAM POSITION

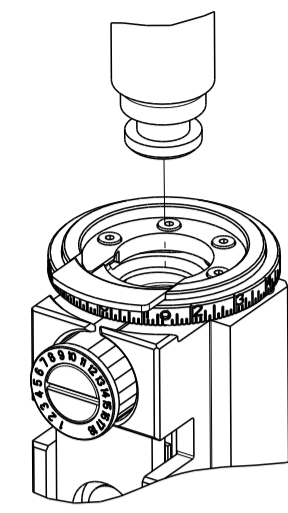


ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		OWN	17APR2014	TE Connectivity Harrisburg, PA 17105-3608
mm	0 PLC	±		CHK	17APR2014	
	1 PLC	±		APVD	17APR2014	
	2 PLC	±		NAME		
	3 PLC	±		PRODUCT SPEC		Ocean End Feed Applicator
	4 PLC	±		APPLICATION SPEC		
	ANGLES	±		SIZE		RESTRICTED TO
MATERIAL	FINISH	±		WEIGHT	SCALE	
				Customer Accessible Production Drawing	1:1	

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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150435-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150435-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



CRIMP	SIZE	TYPE
WIRE	2.29 mm (.090)	F
INSUL	3.30 mm (.130)	F
APPLICATOR INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: .312 FASTIN-FASTON			
WIRE STRIP LENGTH 5.15-5.91 mm (.203-.233 IN)		INSULATION DIAMETER RANGE Ø2.29-3.30 mm (.090-.130 IN)	
TERMINAL APPLICATION SPECIFICATION	114-20021	-	-
TERMINALS APPLIED			
TE TERMINAL 160557-1	TE TERMINAL 160557-2	TE TERMINAL 160557-4	TE TERMINAL

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.50mm2	1.57 +/- 0.05 [.062 +/- .002]	6.7
1.00mm2	1.52 +/- 0.05 [.060 +/- .002]	7.3
0.75mm2	1.47 +/- 0.05 [.058 +/- .002]	7.9
0.50mm2	1.42 +/- 0.05 [.056 +/- .002]	8.3

- 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. APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 180.
- 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.
- 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.

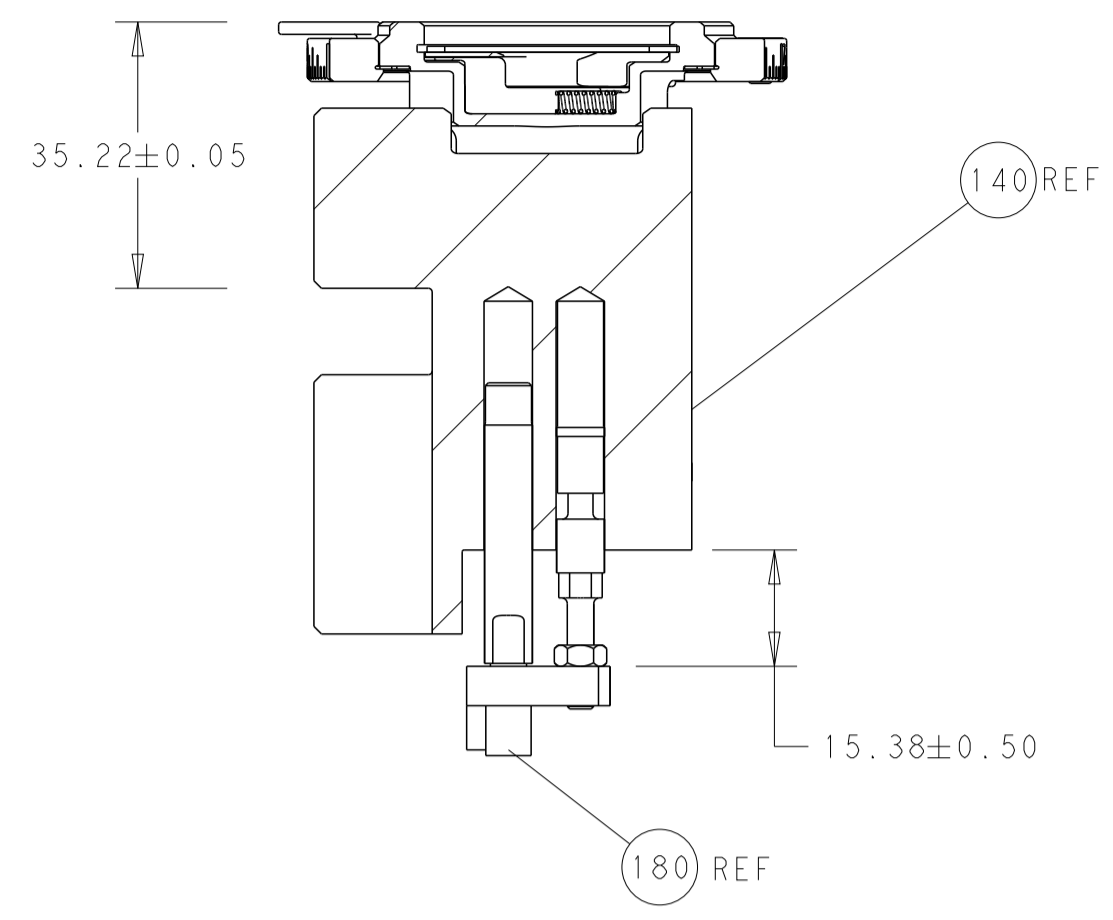
PACIFIC VERSION
Shown on sheets 3 of 4 & 4 of 4
(Atlantic version shown on sheets 1 of 4 & 2 of 4)

LOC	DIST	REV	DATE	BY	APPV
A	66				

REVISIONS					
REV	DATE	DESCRIPTION	DATE	BY	APPV
-	-	SEE SHEET 1	-	-	-
-	1	2119082-3			244
-	1	2079764-1			243
-	1	2119083-1			242
-	1	2844940-4			238
-	4	2079383-9			186
-	1	1-1752354-1			180
-	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	455888-4			82
-	1	2119791-9			73
-	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	2-2168083-5			56
-	2	5018030-1			54
-	2	986965-8			53
-	1	1-5018030-0			52
-	1	2063961-1			51
-	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	1-1752371-4			24
-	1	240825-1			23
-	2	2-22281-3			22
-	1	1803292-4			20
-	2	1901259-4			18
-	1	240641-4			16
-	1	1752360-1			13
-	1	240833-4			11
-	-	-			10
-	1	6-690482-0			9
1	1	5-1803000-0			8
-	1	2217206-8			7
-	-	-			6
-	1	6-240641-9			5
-	1	238011-3			4
1	1	8-1633961-1			3
-	1	455888-1			2
1	1	1-456406-6			1
-	77-22	PART NO			ITEM NO

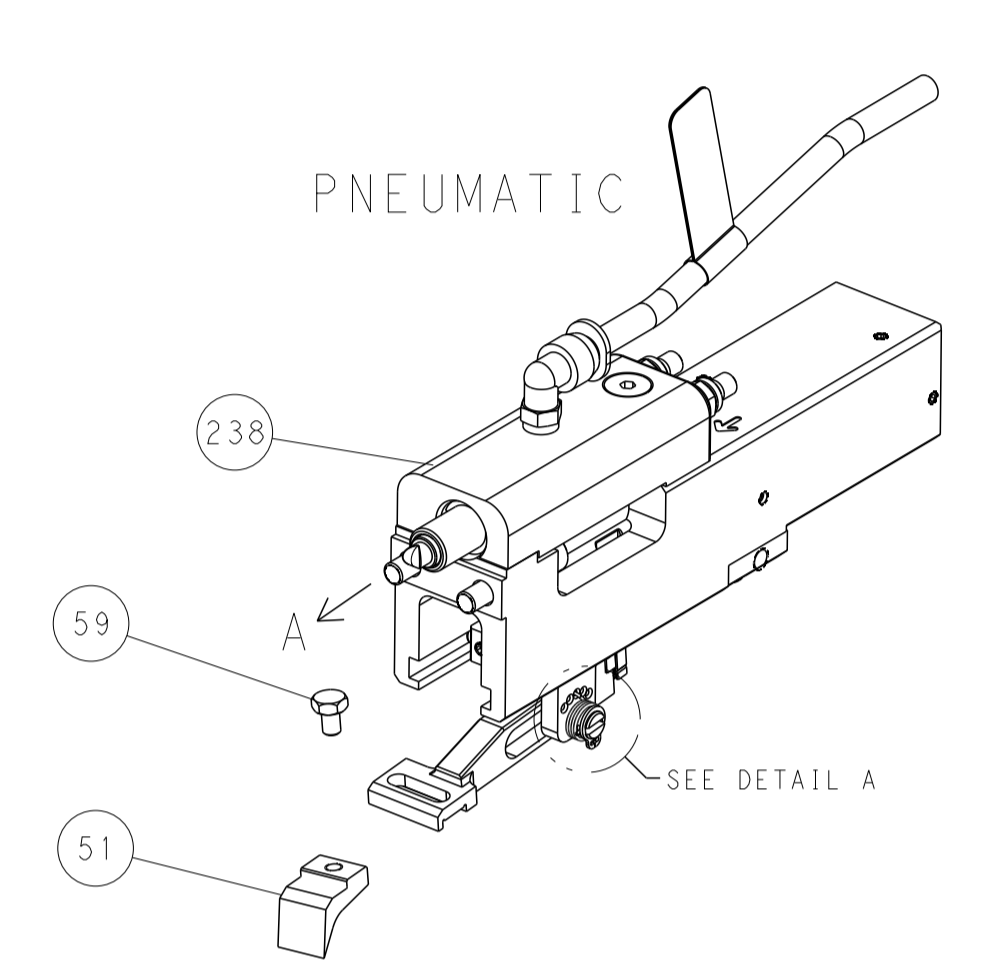
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG Y. YIN 17APR2014	
mm		0 PLC ±		CHK G. BAILEY 17APR2014	
1 PLC ±		1 PLC ±		APVD J. GUO 17APR2014	
2 PLC ±		2 PLC ±		NAME	
3 PLC ±		3 PLC ±		Ocean End Feed	
4 PLC ±		4 PLC ±		Applicator	
ANGLES		FINISH		SIZE CAGE CODE DRAWING NO RESTRICTED TO	
-		-		A1 00779 C=2150435	
MATERIAL		WEIGHT		SCALE 1:1 SHEET 3 OF 4 REV B	
-		-		Customer Accessible Production Drawing	

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

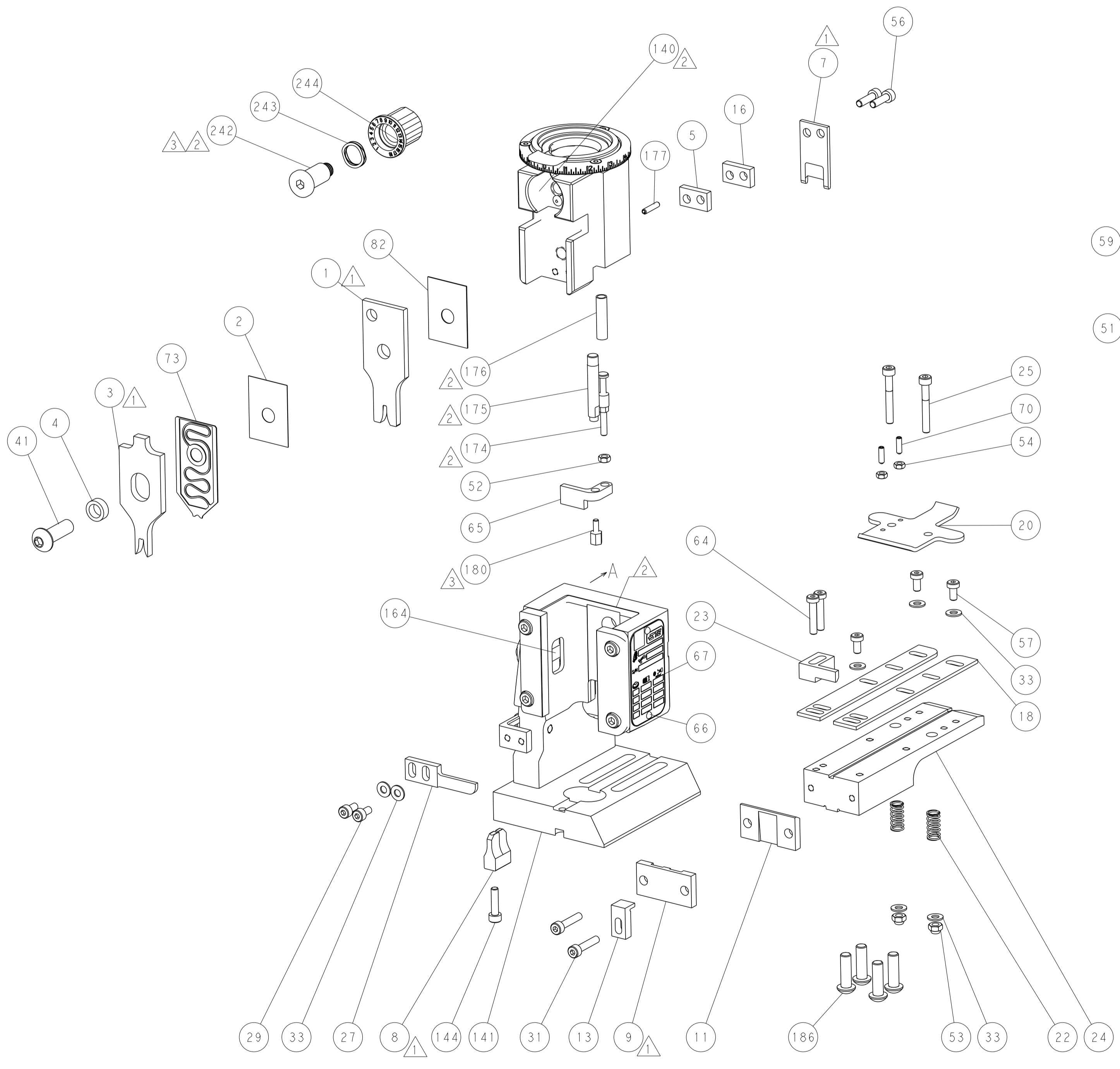
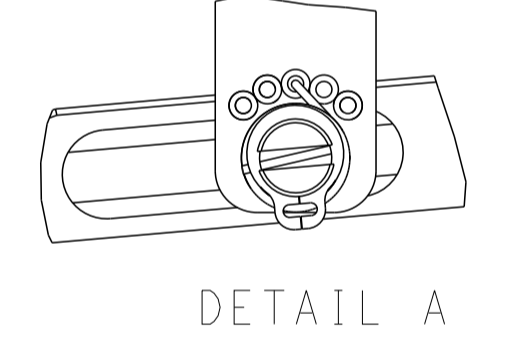


RAM AND HOLDDOWN SET-UP

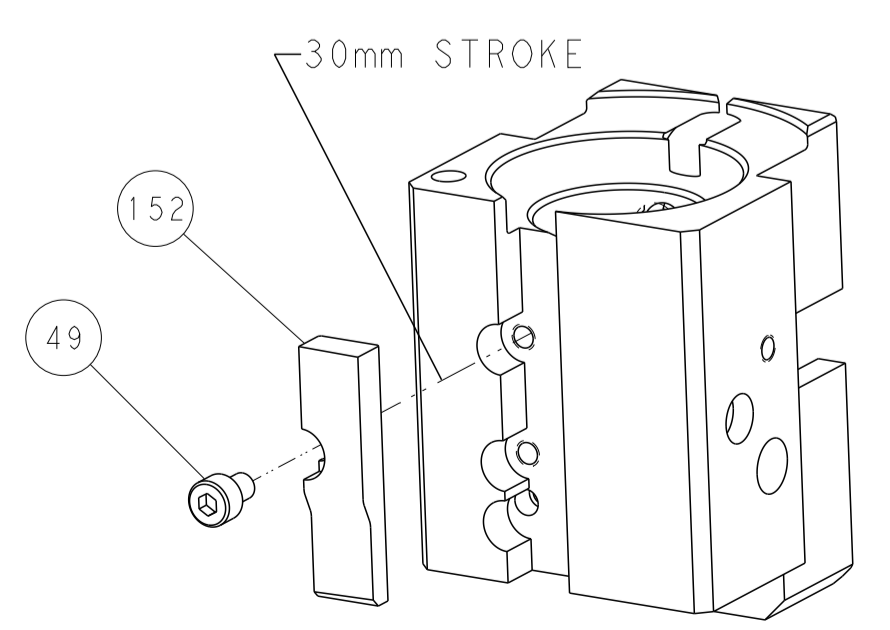
FEED TYPE



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:		DWG: Y. YIN 17APR2014		CHK: G. BAILEY 17APR2014		APVD: J. GUO 17APR2014		NAME: Ocean End Feed Applicator	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES ±	FINISH ±	SIZE: A1	CAGE CODE: 00779	DRAWING NO: C=2150435	RESTRICTED TO: -
MATERIAL: -	WEIGHT: -		SCALE: 1:1		SHEET: 4 OF 4		REV: B		Customer Accessible Production Drawing		