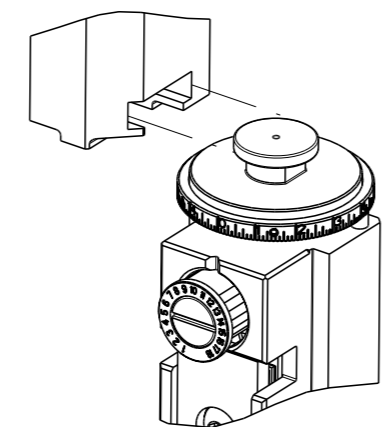


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150319-2	D	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150319-2	D	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150319-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER

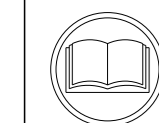


APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.03 mm [.080]	F
INSUL	2.79 mm [.110]	OV

APPLICATOR INSTRUCTIONS 408-35043

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION			
TERMINAL NAME: .110 SRS FAST-IN-ON TAB.			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
.154-.185 IN [3.90-4.70 mm]		∅.055-.091 IN [1.40-2.30 mm]	
TERMINAL APPLICATION SPECIFICATION	114-20021		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
160887-1	160887-3	160887-4	

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.00mm2	1.60 +/- 0.05 [1.063 +/- .002]	8.9
0.85mm2	1.55 +/- 0.05 [1.061 +/- .002]	9.4
0.75mm2	1.52 +/- 0.05 [1.060 +/- .002]	9.8
0.70mm2	1.50 +/- 0.05 [1.059 +/- .002]	10.0
0.50mm2	1.42 +/- 0.05 [1.056 +/- .002]	10.9



- 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 50.
- 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.

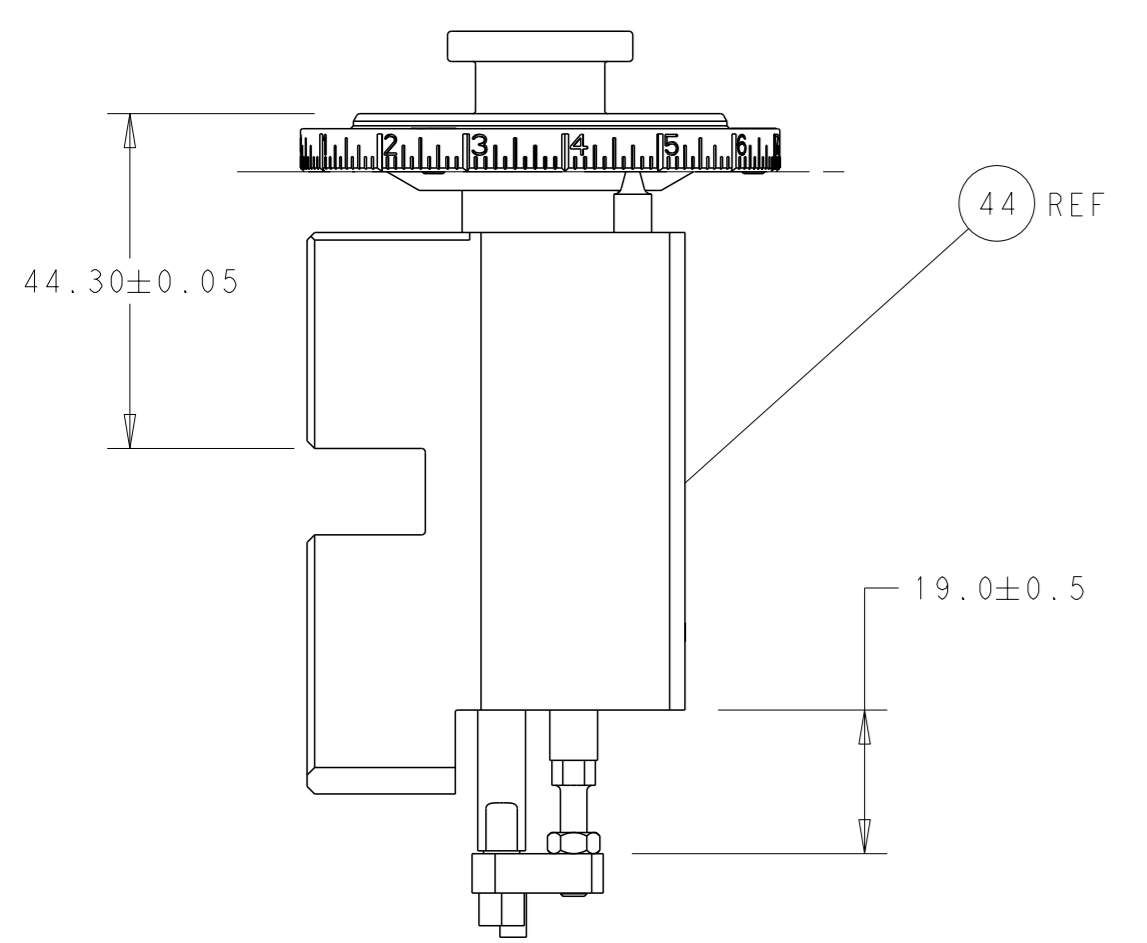
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

LOC	DIST	REVISIONS					
		P	LY#	DESCRIPTION	DATE	OWN	APVD
A	66	A		RELEASED	29MAR2013	KH	UG
		B		ECR-19-010226	29JUN2019	TB	GB
		C		ECR-19-011109	15JUL2019	TB	TE
		D		ECR-19-011536	22JUL2019	JAH	GB

-	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	2119083-1	RETAINER, INSULATION DIAL	242		
-	1	1	2844940-4	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	1976052-1	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	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	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	2063961-9	FEED FINGER	51		
	-	1	1752354-2	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	240825-4	PLATE, STRIP HOLD DOWN	23		
-	2	2	2-22281-3	SPRING, COMPRESSION	22		
-	1	1	1803292-4	DRAG	20		
-	1	1	1803152-5	STRIP GUIDE, REAR	19		
-	1	1	1803151-5	STRIP GUIDE, FRONT	18		
-	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17		
-	1	1	5-240641-9	SPACER	16		
-	1	1	1752360-1	SPACER, HOLD-DOWN	13		
	-	1	240644-1	PLATE, REAR SHEAR	11		
-	-	-	-	-	10		
	-	1	690482-5	PLATE, FRONT SHEAR	9		
	1	2	1333216-1	ANVIL, COMBINATION	8		
	-	1	2217206-7	BLADE, SLUG	7		
-	-	-	-	-	6		
-	1	1	5-240641-1	SPACER	5		
-	1	1	238011-2	BLOCK, CRIMPER SPACER	4		
	1	2	1633963-1	CRIMPER, INSULATION OVERLAP PREMIUM	3		
-	1	1	455888-5	SPACER, CRIMPER	2		
	1	2	1-456405-5	CRIMPER, WIRE PREMIUM	1		
-	-	-	-	-	0		
			-77-72-2	PART NO			
				DESCRIPTION			ITEM NO

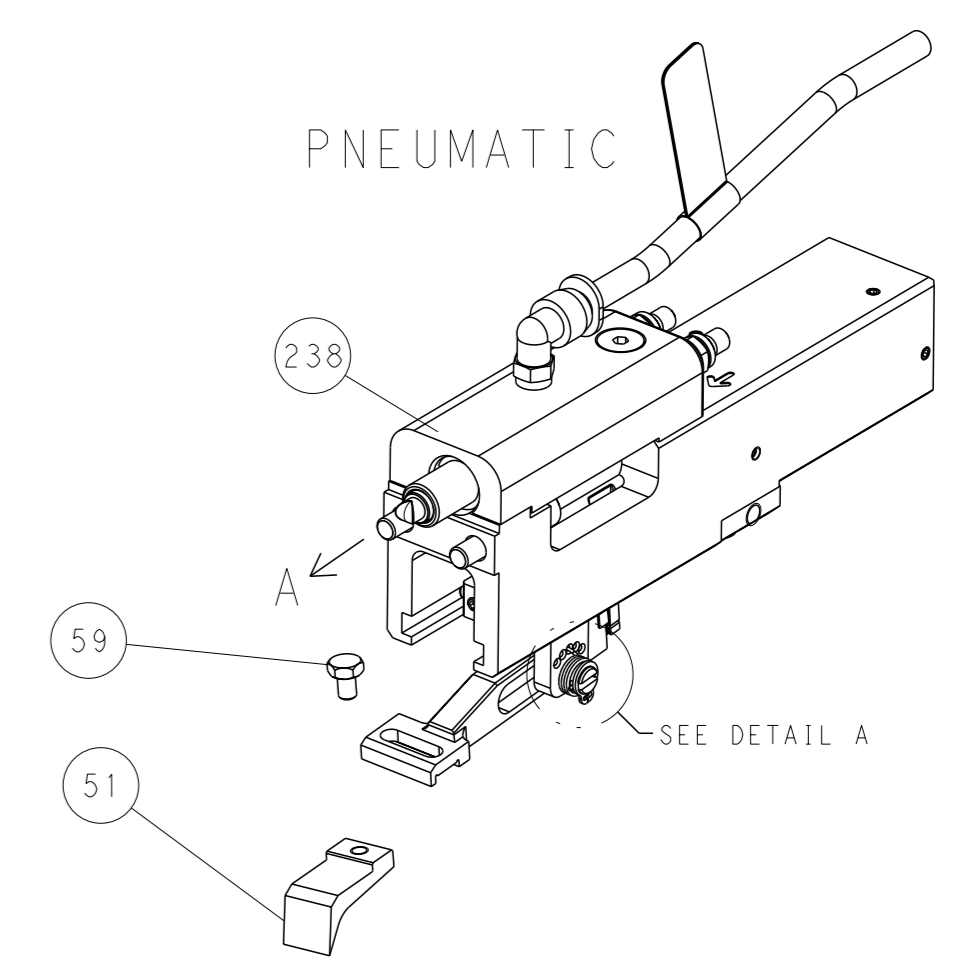
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DRAWING NO		RESTRICTED TO	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES FINISH	
MATERIAL							
Customer Accessible Production Drawing				SCALE	1:1	SHEET	1 OF 4

LOC	DIST	REVISIONS			
A	66	REV	DATE	OWN	APVD
		-	SEE SHEET 1	-	-

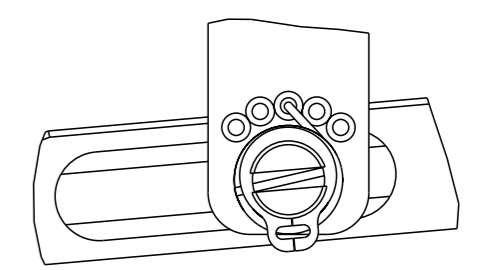


RAM SET-UP

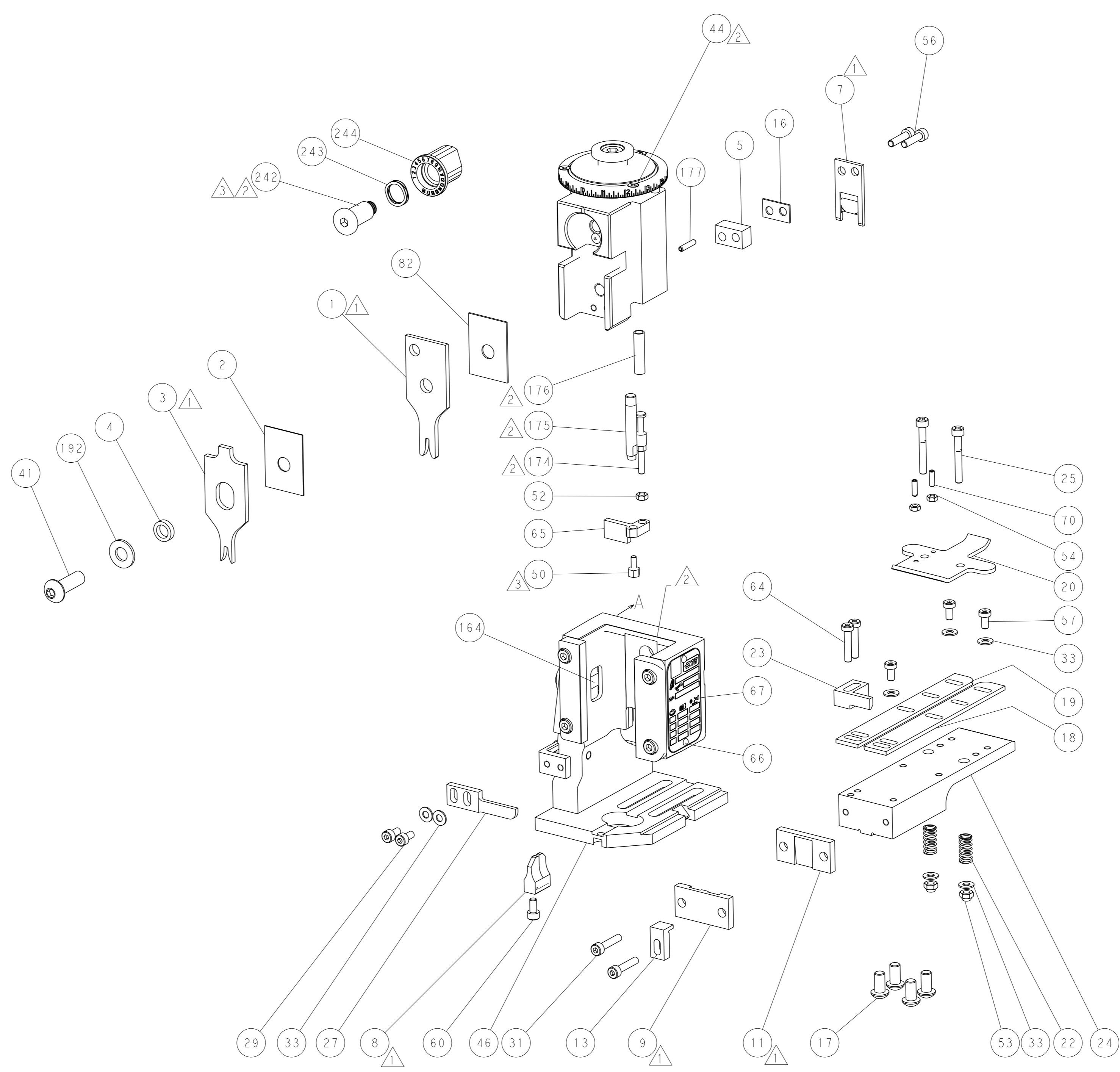
FEED TYPE



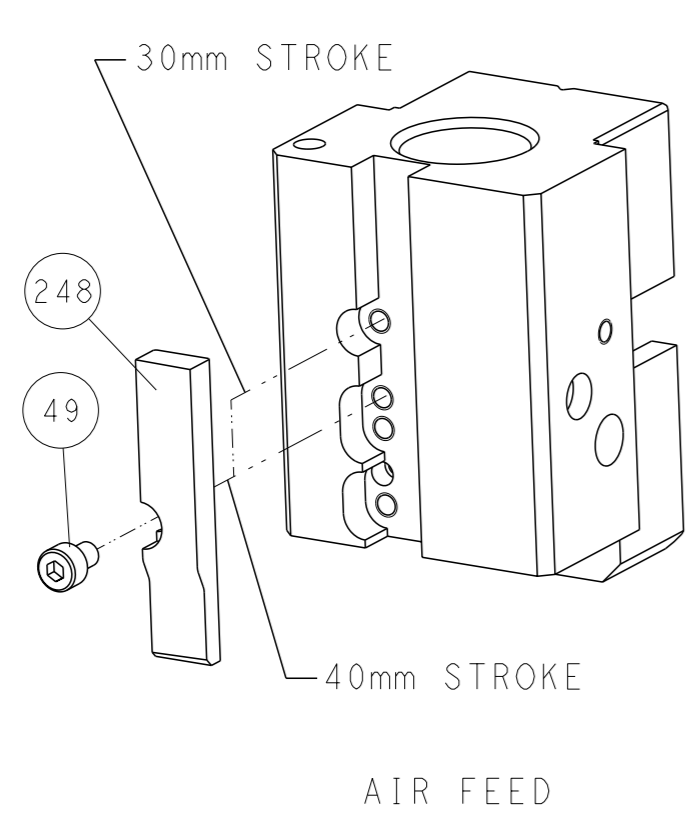
FEED SPRING SETTING POSITION



DETAIL A



CAM POSITION



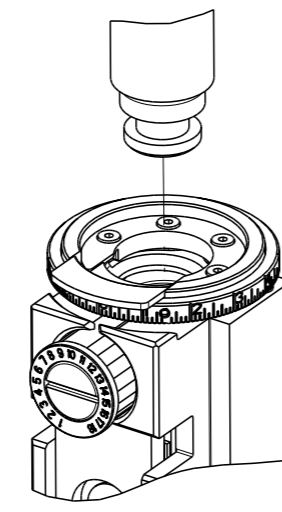
AIR FEED

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

<small>THIS DRAWING IS A CONTROLLED DOCUMENT FROM TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE AND TO CONTROLING ENGINEERING DISCRETION. SHOULD BE CONTACTED FOR THE LATEST REVISION.</small>		OWN: K. HUANG 12MAR2013 CHK: L. ZHANG 12MAR2013 APVD: J. GUO 12MAR2013	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 SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2150319 WEIGHT: - SCALE: 1:1	RESTRICTED TO: - SHEET 2 of 4 REV D
Customer Accessible Production Drawing			

THIS DRAWING IS UNPUBLISHED.	RELEASED FOR PUBLICATION	20	
COPYRIGHT © BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.			
PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150319-2	D	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150319-7	A	CRIMP TOOLING KIT	-

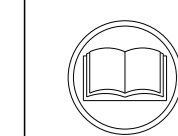
PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.03 mm [.080]	F
INSUL	2.79 mm [.110]	OV
APPLICATOR INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: .110 SRS FAST-IN-ON TAB.			
WIRE STRIP LENGTH .154-.185 IN [3.90-4.70 mm]		INSULATION DIAMETER RANGE Ø.055-.091 IN [1.40-2.30 mm]	
TERMINAL APPLICATION SPECIFICATION	114-20021	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
160887-1	160887-3	160887-4	

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.00mm2	1.60+/-0.05 [.063+/-0.002]	8.9
0.85mm2	1.55+/-0.05 [.061+/-0.002]	9.4
0.75mm2	1.52+/-0.05 [.060+/-0.002]	9.8
0.70mm2	1.50+/-0.05 [.059+/-0.002]	10.0
0.50mm2	1.42+/-0.05 [.056+/-0.002]	10.9



- 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 50.
- 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.
- 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.

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

-	1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	2844940-4	AIR FEED MODULE	238
-	1	1-18028-0	WASHER, FLAT, REG M8	192
-	4	2079383-9	SCR, BHSC, RoHS (M6 X 20)	186
-	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	455888-8	SPACER, CRIMPER	82
-	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	1976052-1	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	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57
-	2	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	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	2063961-9	FEED FINGER	51
-	1	1752354-2	STANDOFF, HOLD-DOWN	50
-	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	240639-1	STRIPPER (MACHINING)	27
-	2	1-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 30	25
-	1	1752371-5	PLATE, STRIP GUIDE	24
-	1	240825-4	PLATE, STRIP HOLD DOWN	23
-	2	2-22281-3	SPRING, COMPRESSION	22
-	1	1803292-4	DRAG	20
-	1	1803152-5	STRIP GUIDE, REAR	19
-	1	1803151-5	STRIP GUIDE, FRONT	18
-	1	5-240641-9	SPACER	16
-	1	1752360-1	SPACER, HOLD-DOWN	13
-	1	240644-1	PLATE, REAR SHEAR	11
-	-	-	-	10
-	1	690482-5	PLATE, FRONT SHEAR	9
1	1	1333216-1	ANVIL, COMBINATION	8
-	1	2217206-7	BLADE, SLUG	7
-	-	-	-	6
-	1	5-240641-1	SPACER	5
-	1	238011-2	BLOCK, CRIMPER SPACER	4
1	1	1633963-1	CRIMPER, INSULATION OVERLAP PREMIUM	3
-	1	455888-5	SPACER, CRIMPER	2
1	1	1-456405-5	CRIMPER, WIRE PREMIUM	1
-	77-22	PART NO	DESCRIPTION	ITEM NO

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

DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		OWN: K. HUANG 12MAR2013		CHK: L. ZHANG 12MAR2013		APVD: J. GUO 12MAR2013		NAME: Ocean End Feed Applicator	
0 PLC ±		1 PLC ±		2 PLC ±		3 PLC ±		4 PLC ±		RESTRICTED TO	
MATERIAL: .		FINISH: .		WEIGHT: .		SIZE: A1		CAGE CODE: 00779		DRAWING NO: ©=2150319	
Customer Accessible Production Drawing				SCALE: 1:1		SHEET: 3 of 4		REV: D			

