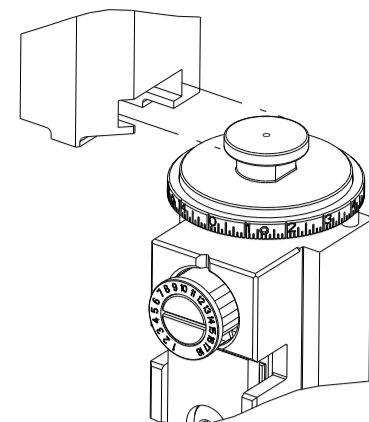


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150377-2	E	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150377-2	E	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150377-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.29 mm [.090]	F
INSUL	4.06 mm [.160]	F
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION			
TERMINAL NAME: TAB MIC MK II			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
3.50-4.50 mm [.138-.177 IN]		∅2.16-3.43 mm [.085-.135 IN]	
TERMINAL APPLICATION SPECIFICATION	114-5072	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
172777-1	172777-2	172777-3	172777-4

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
14 AWG OR 2.00mm ²	1.78+/-0.05 [.070+/- .002]	4.4
16 AWG OR 1.25mm ²	1.50+/-0.05 [.059+/- .002]	7.3
0.5+0.85mm ² OR 20+18 AWG	1.50+/-0.05 [.059+/- .002]	7.4
0.5+0.5mm ² OR 20+20 AWG	1.50+/-0.05 [.059+/- .002]	7.2
18 AWG OR 0.75mm ² OR 0.85mm ²	1.34+/-0.05 [.053+/- .002]	9.2
20 AWG OR 0.50mm ²	1.30+/-0.05 [.051+/- .002]	9.4



- RECOMMENDED SPARE PARTS
- REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION & 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.
- TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- 6. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT 101-35000.
- TERMINAL LUBRICANT IS RECOMMENDED.

***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)

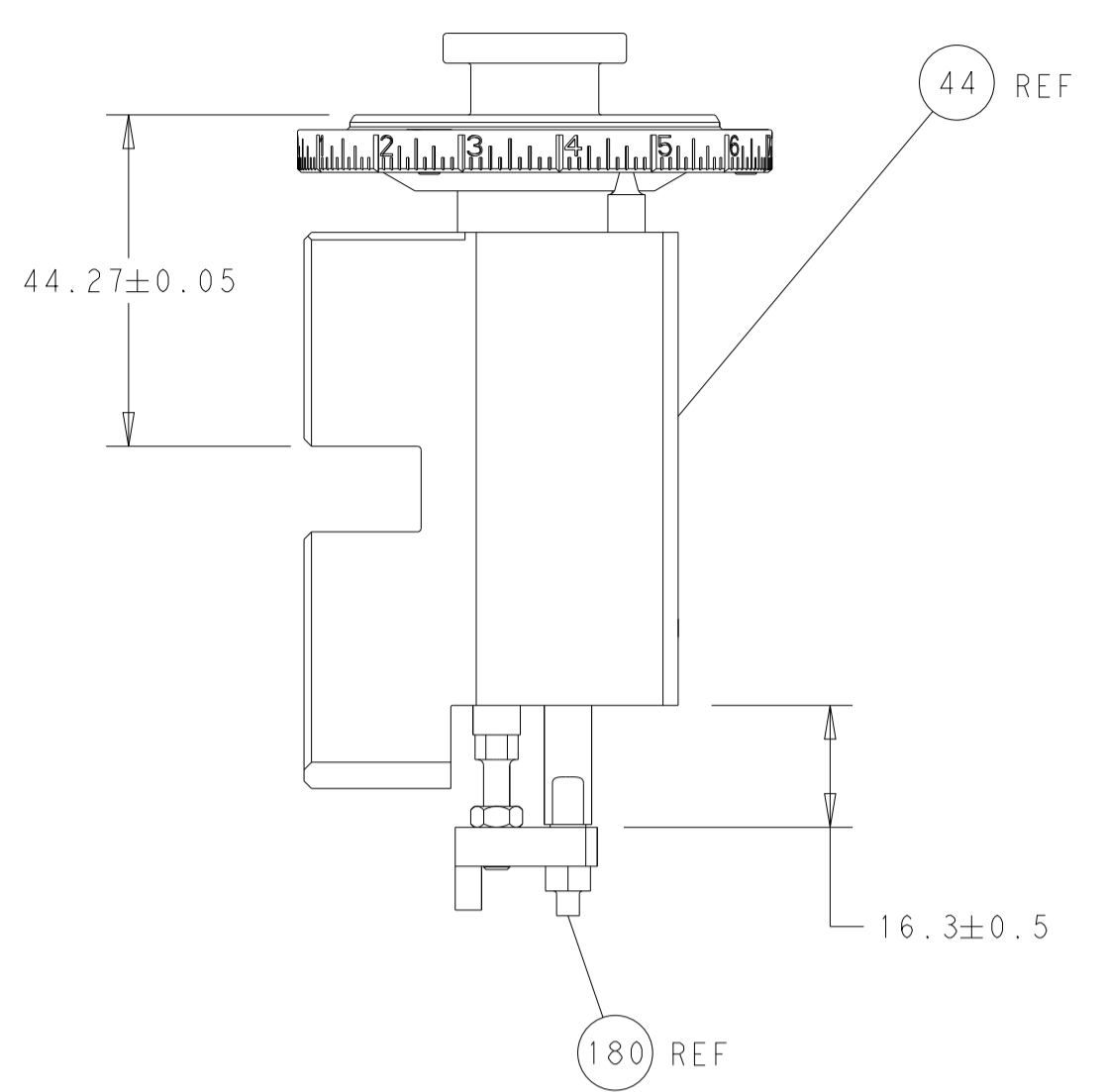
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		D		ECR-19-009276	12JUN2019	LG	TE
		E		ECR-20-003244	04MAR2020	JAH	GB
		E1		ECR-22-159636	28NOV2022	FZ	JAH

-	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	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	1-1976055-1	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
-	REFREF		994970-2	COUNTER, MAGNETIC	164
-	1	1	2119955-2	ASSY, LUBRICATOR, END FEED	84
-	1	1	455888-5	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	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	240639-1	STRIPPER (MACHINING)	27
-	2	2	1-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 30	25
-	1	1	1752371-8	PLATE, STRIP GUIDE	24
-	1	1	240825-6	PLATE, STRIP HOLD DOWN	23
-	2	2	2-22281-3	SPRING, COMPRESSION	22
-	1	1	1803292-4	DRAG	20
-	2	2	1901259-6	GUIDE, LOWER STRIP	18
-	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17
-	1	1	6-240641-8	SPACER	16
-	1	1	1752360-1	SPACER,HOLD-DOWN	13
-	1	1	240833-1	PLATE, REAR SHEAR	11
-	-	-	-	-	10
-	1	1	690482-5	PLATE, FRONT SHEAR	9
-	1	2	1-1333217-3	ANVIL, EF .090	8
-	1	1	2217206-7	BLADE, SLUG	7
-	-	-	-	-	6
-	1	1	6-240641-8	SPACER	5
-	1	1	238011-2	BLOCK, CRIMPER SPACER	4
-	1	2	1-1633961-6	CRIMPER, INSULATION F PREMIUM	3
-	-	-	-	-	2
-	1	2	1-4-456406-7	CRIMPER, WIRE PREMIUM	1
-	77	72	2	PART NO	ITEM NO

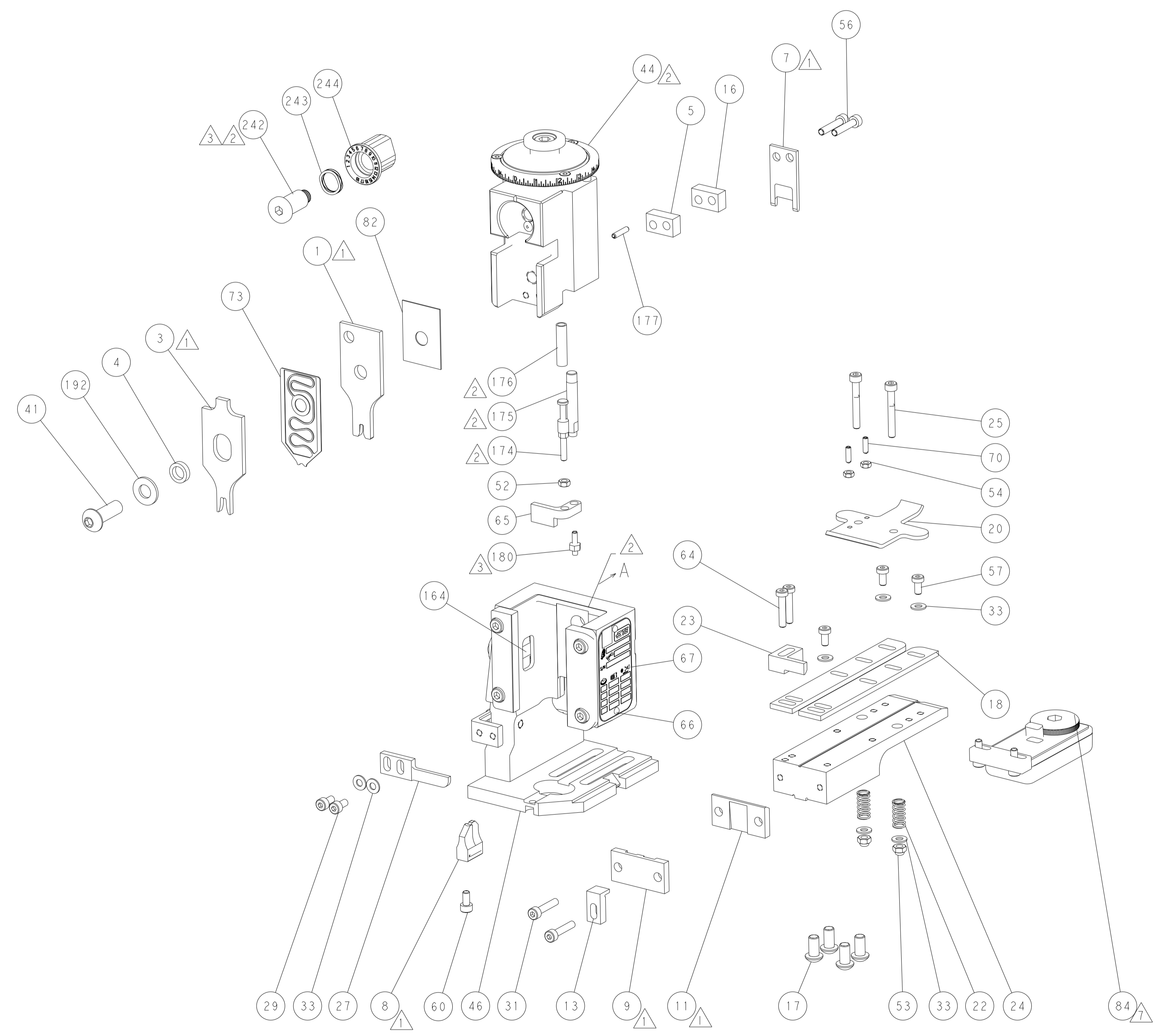
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mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES ±	FINISH ±
MATERIAL		FINISH		WEIGHT		SCALE	
-		-		-		1:1	

DATE	04OCT2013	TE Connectivity
CHK	G. BAILEY	Harrisburg, PA 17105-3608
APVD	M. CLIFFORD	
NAME	Ocean End Feed Applicator	
SIZE	CAGE CODE	DRAWING NO
A1	00779	2150377
Customer Accessible Production Drawing		
SHEET	1	OF 4
REV	E1	

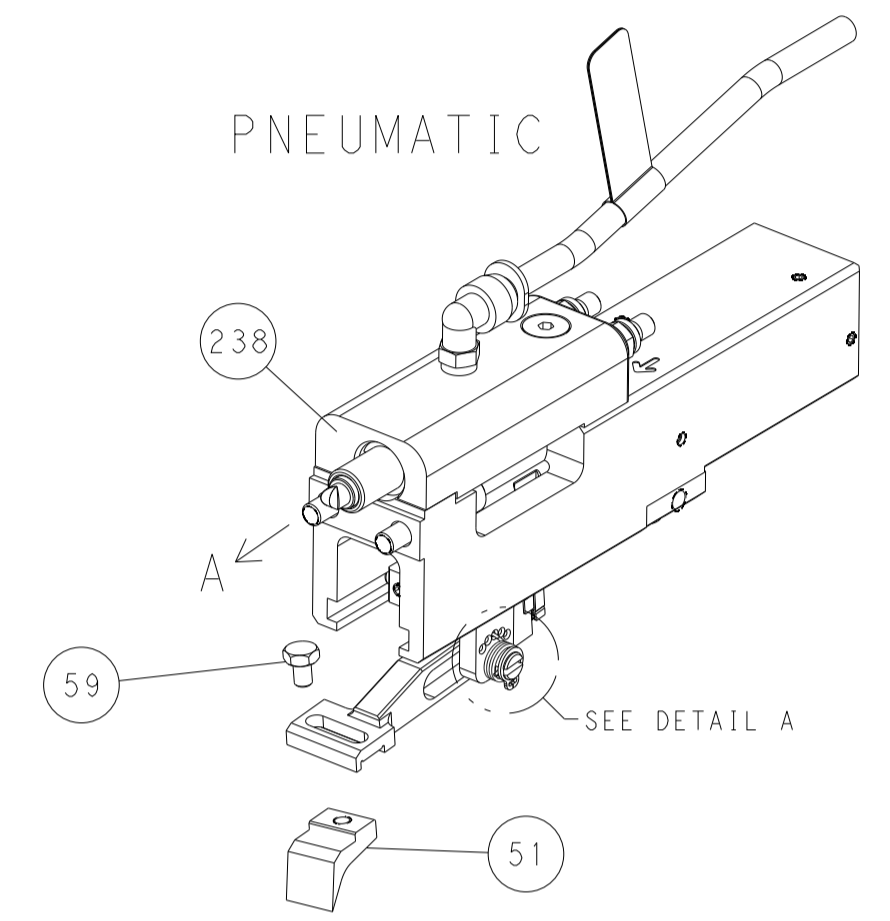
LOC	DIST	REVISIONS			
P	LTN	DESCRIPTION	DATE	OWN	APVD
A	66	SEE SHEET 1	-	-	-



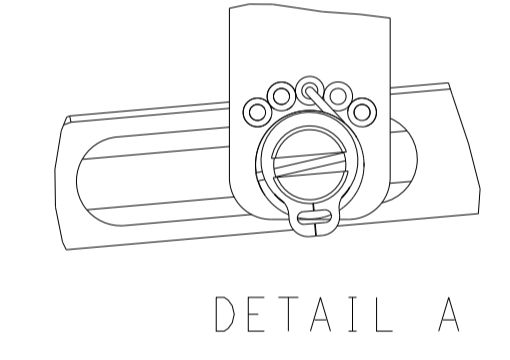
RAM AND HOLDDOWN SET-UP



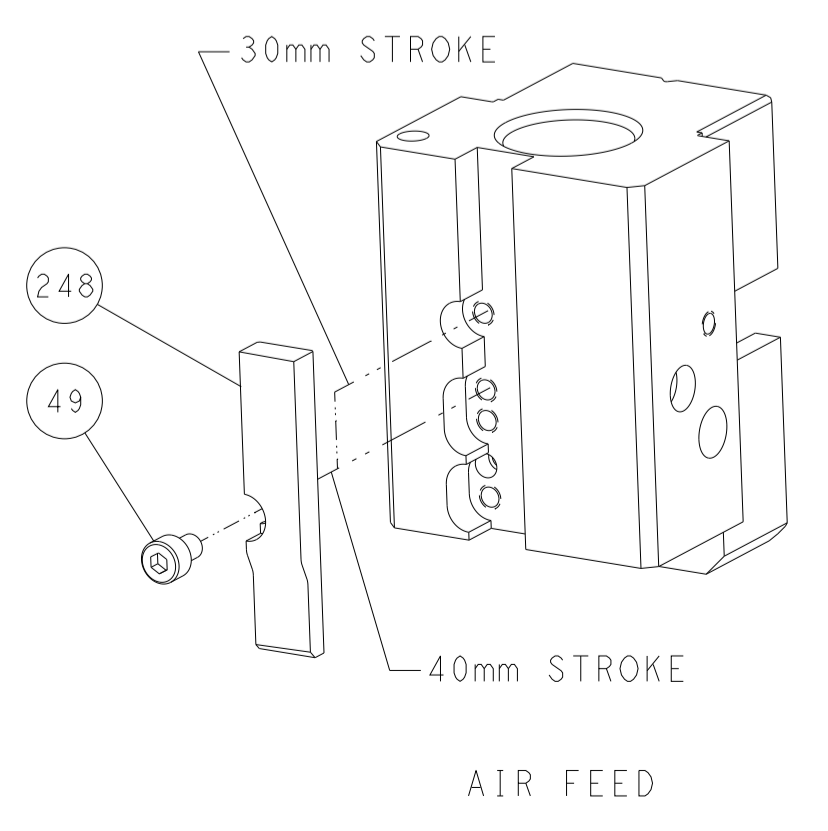
FEED TYPE



FEED SPRING SETTING POSITION



CAM POSITION

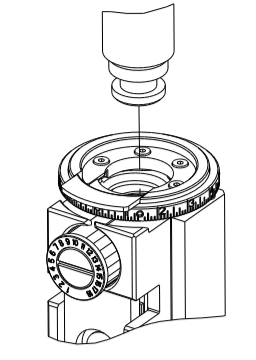


ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

<small>THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION 20. COPYRIGHT 20 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.</small>		DWN L.GROSS 04OCT2013 CHK G.BAILEY 04OCT2013 APVD M.CLIFFORD 04OCT2013	TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± MATERIAL - FINISH -		NAME Ocean End Feed Applicator APPLICATION SPEC - SIZE CAGE CODE DRAWING NO. RESTRICTED TO A1 00779 C=2150377 -	WEIGHT - SCALE 1:1 SHEET 2 OF 4 REV E1
Customer Accessible Production Drawing			

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150377-2	E	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150377-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
 INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.29 mm [.090]	F
INSUL	4.06 mm [.160]	F
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: TAB MIC MK II			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
3.50-4.50 mm [.138-.177 IN]		∅2.16-3.43 mm [.085-.135 IN]	
TERMINAL APPLICATION SPECIFICATION	114-5072	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
172777-1	172777-2	172777-3	172777-4

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
14 AWG OR 2.00mm ²	1.78+/-0.05 [.070+/- .002]	4.4
16 AWG OR 1.25mm ²	1.50+/-0.05 [.059+/- .002]	7.3
0.5+0.85mm ² OR 20+18 AWG	1.50+/-0.05 [.059+/- .002]	7.4
0.5+0.5mm ² OR 20+20 AWG	1.50+/-0.05 [.059+/- .002]	7.2
18 AWG OR 0.75mm ² OR 0.85mm ²	1.34+/-0.05 [.053+/- .002]	9.2
20 AWG OR 0.50mm ²	1.30+/-0.05 [.051+/- .002]	9.4

- RECOMMENDED SPARE PARTS
- REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION & 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.
- TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- 6. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT 101-35000.
- TERMINAL LUBRICANT IS RECOMMENDED.

***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.

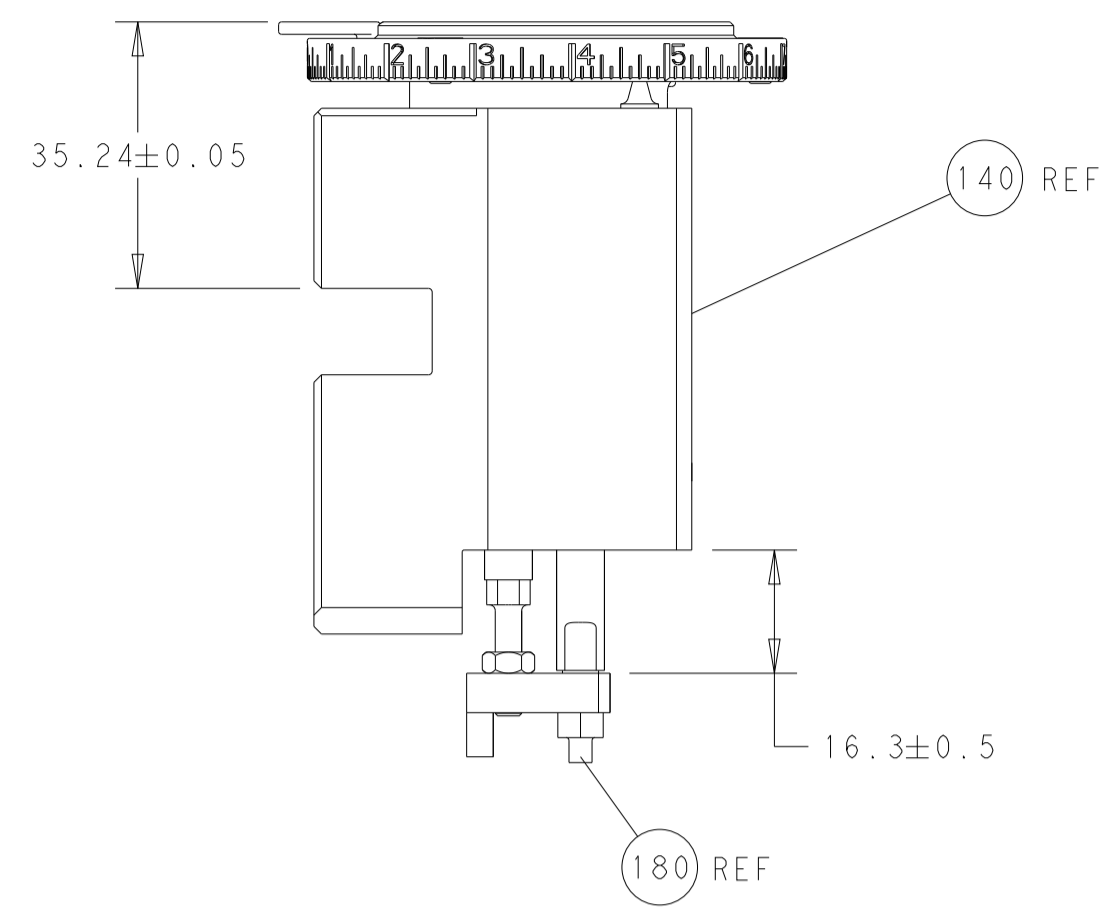
PACIFIC VERSION
 Shown on sheets 3 of 4 & 4 of 4
 (Atlantic version shown on sheets 1 of 4 & 2 of 4)

LOC	DIST	REVISIONS					
A	66	P	LTN	DESCRIPTION	DATE	OWN	APVD
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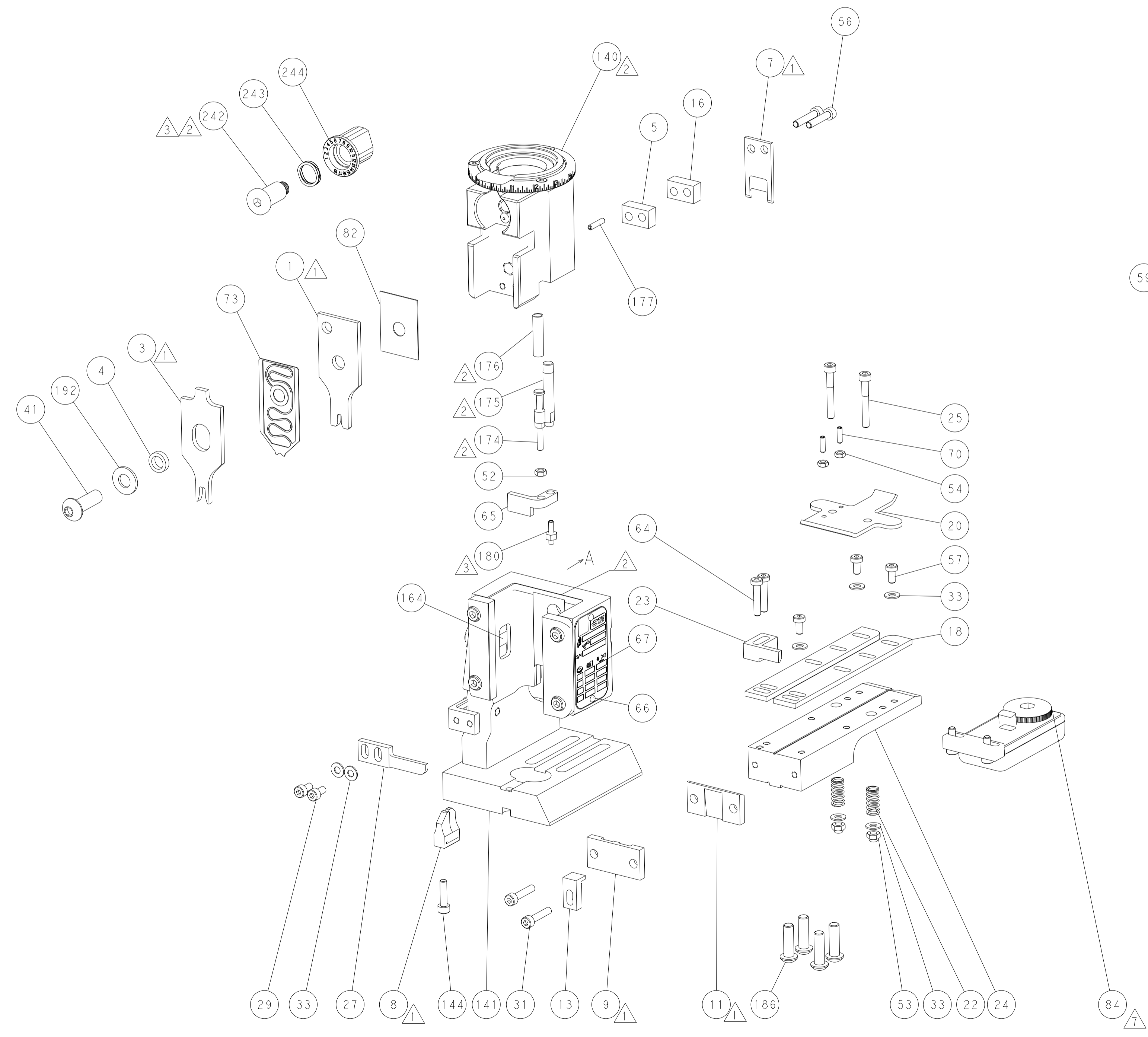
-	1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	2844940-4	AIR FEED MODULE	238
-	1	1-18028-0	WASHER, FLAT, REG M8	192
-	4	2079383-9	SCR, BHSC, RoHS (M6 X 20)	186
-	1	1-1976055-1	STANDOFF, HOLD-DOWN	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	2119955-2	ASSY, LUBRICATOR, END FEED	84
-	1	455888-5	SPACER, CRIMPER	82
-	1	2119791-9	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	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	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	240639-1	STRIPPER (MACHINING)	27
-	2	1-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 30	25
-	1	1752371-8	PLATE, STRIP GUIDE	24
-	1	240825-6	PLATE, STRIP HOLD DOWN	23
-	2	2-22281-3	SPRING, COMPRESSION	22
-	1	1803292-4	DRAG	20
-	2	1901259-6	GUIDE, LOWER STRIP	18
-	1	6-240641-8	SPACER	16
-	1	1752360-1	SPACER,HOLD-DOWN	13
-	1	240833-1	PLATE, REAR SHEAR	11
-	-	-	-	10
-	1	690482-5	PLATE, FRONT SHEAR	9
1	1	1-1333217-3	ANVIL, EF .090	8
-	1	2217206-7	BLADE, SLUG	7
-	-	-	-	6
-	1	6-240641-8	SPACER	5
-	1	238011-2	BLOCK, CRIMPER SPACER	4
1	1	7-1633961-6	CRIMPER, INSULATION F PREMIUM	3
-	-	-	-	2
1	1	4-456406-7	CRIMPER, WIRE PREMIUM	1
-	77-22	PART NO	DESCRIPTION	ITEM NO

DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH		DWN G. GROSS 04OCT2013 G. BAILEY 04OCT2013 M. CLIFFORD 04OCT2013 NAME APPLICATION SPEC		TE Connectivity Harrisburg, PA 17105-3608 Ocean End Feed Applicator	
MATERIAL		WEIGHT		SIZE		RESTRICTED TO	
				A1 00779 C=2150377		Customer Accessible Production Drawing	
				SCALE 1:1		SHEET 3 OF 4 REV E1	

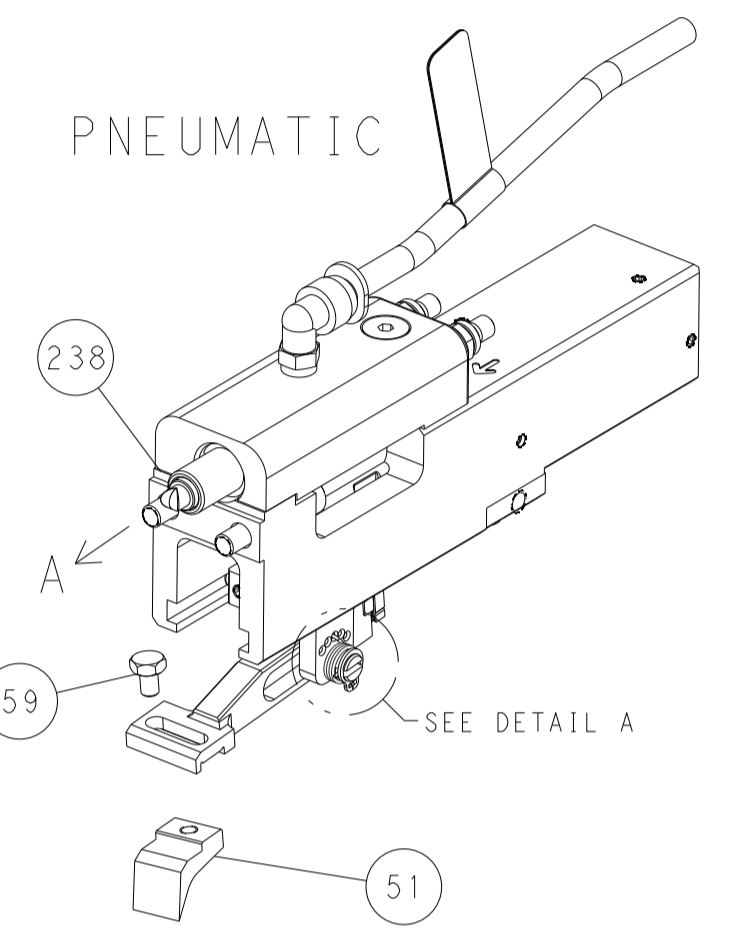
LOC		DIST		REVISIONS				
P	LTN	DATE	DMN	APVD	DESCRIPTION	DATE	DMN	APVD
A	66	-	-	-	SEE SHEET 1	-	-	-



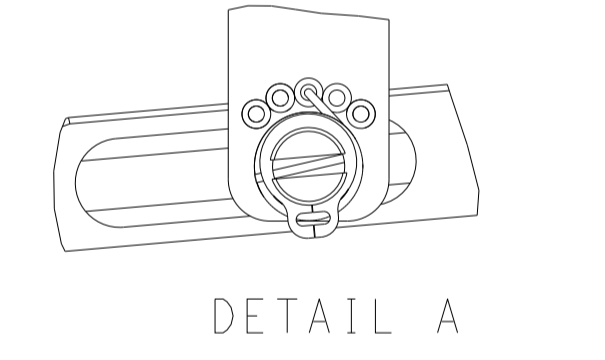
RAM AND HOLDDOWN SET-UP



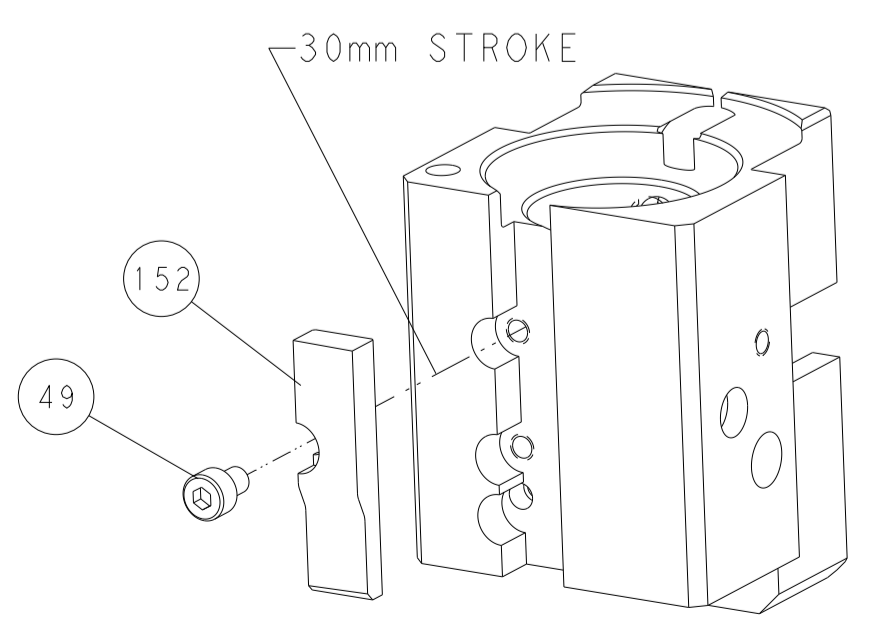
FEED TYPE



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)

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DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± MATERIAL - FINISH -		NAME Ocean End Feed Applicator APPLICATION SPEC - SIZE CAGE CODE DRAWING NO. A 00779 C=2150377 WEIGHT - Customer Accessible Production Drawing	RESTRICTED TO - SCALE 1:1 SHEET 4 OF 4 REV E1