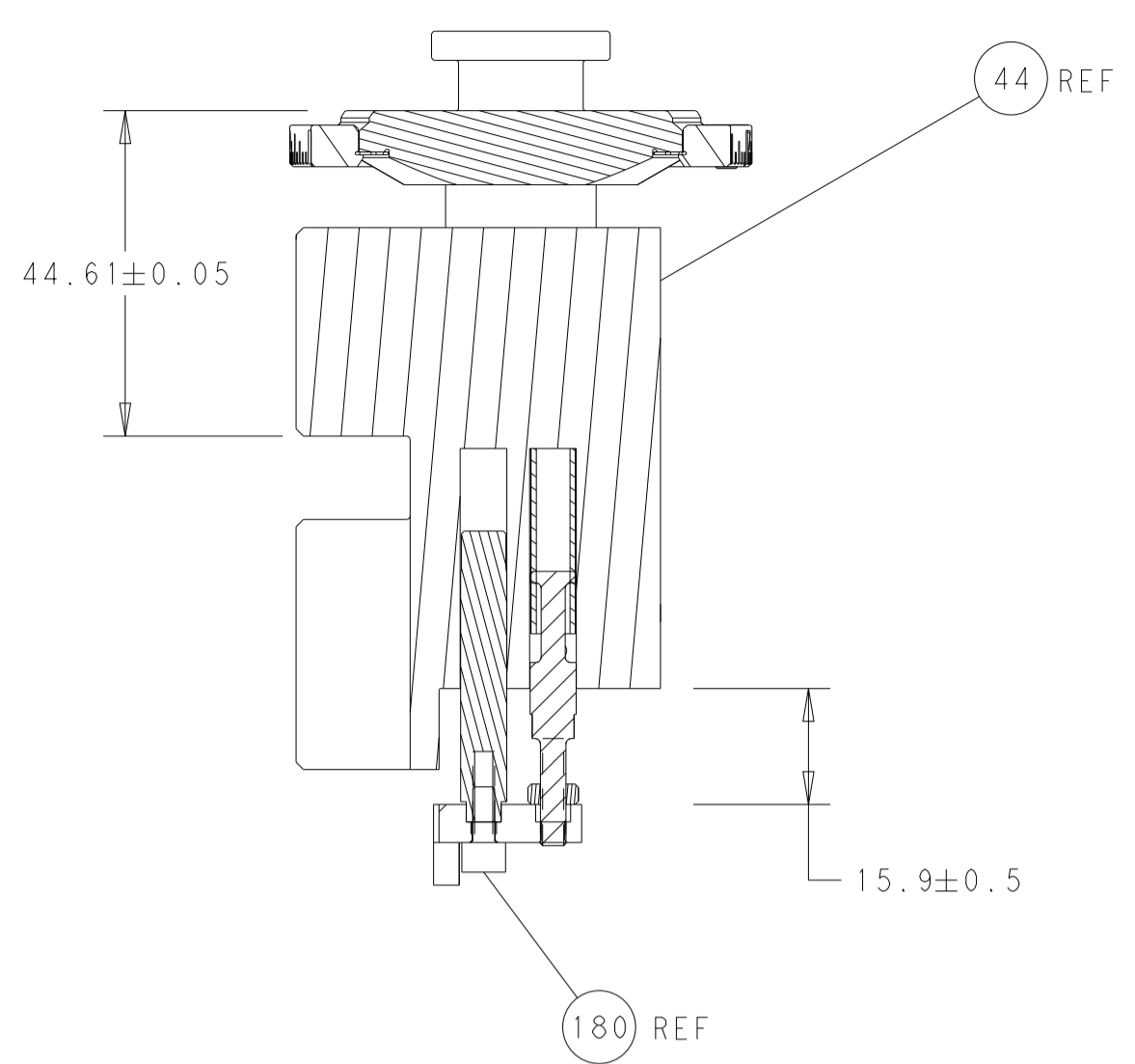


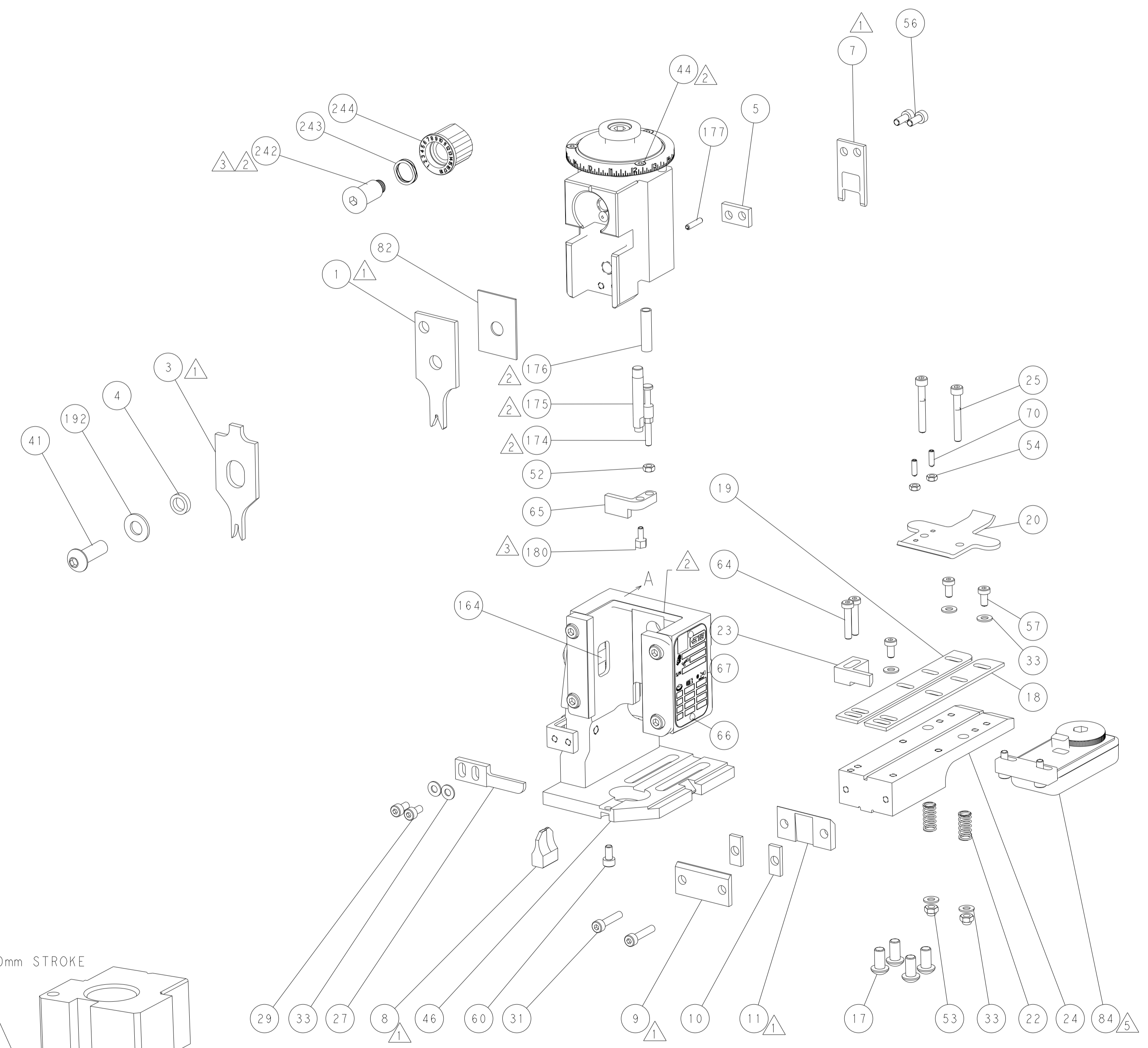
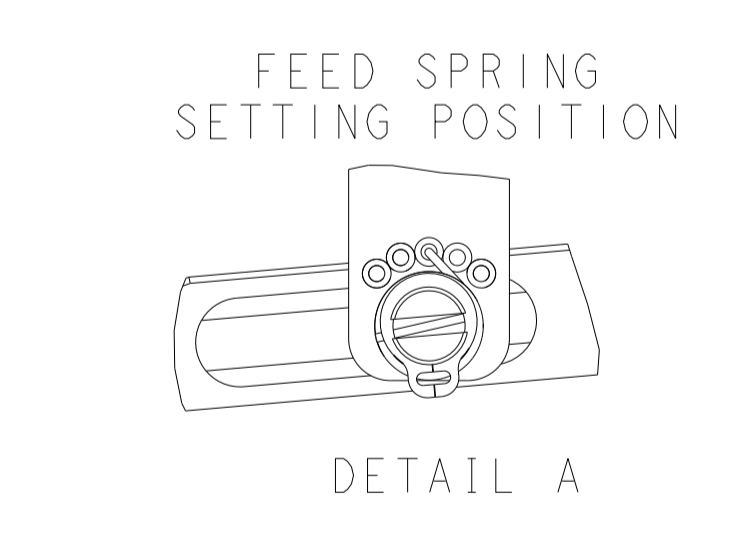
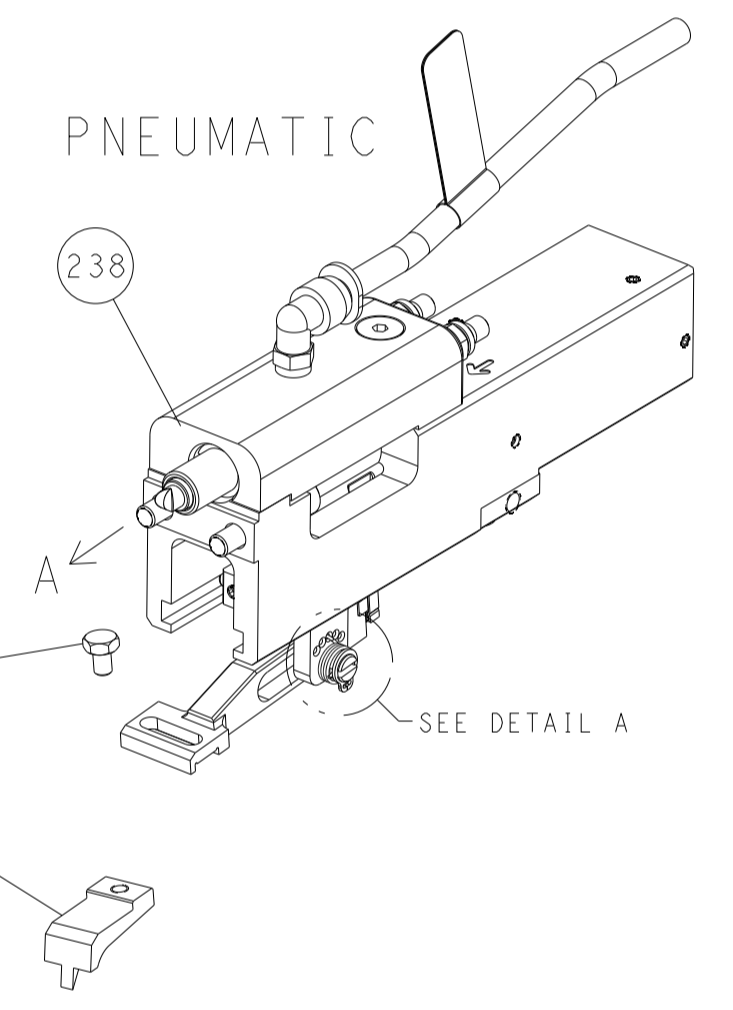
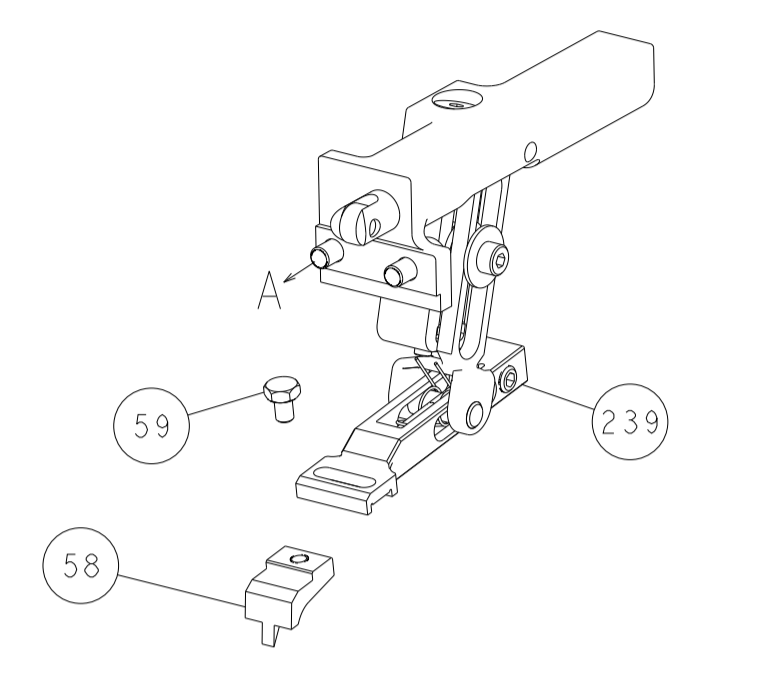


LOC	DIST	REVISIONS					
A	66	P	LTM	DESCRIPTION	DATE	OWN	APVD
		-		SEE SHEET 1			

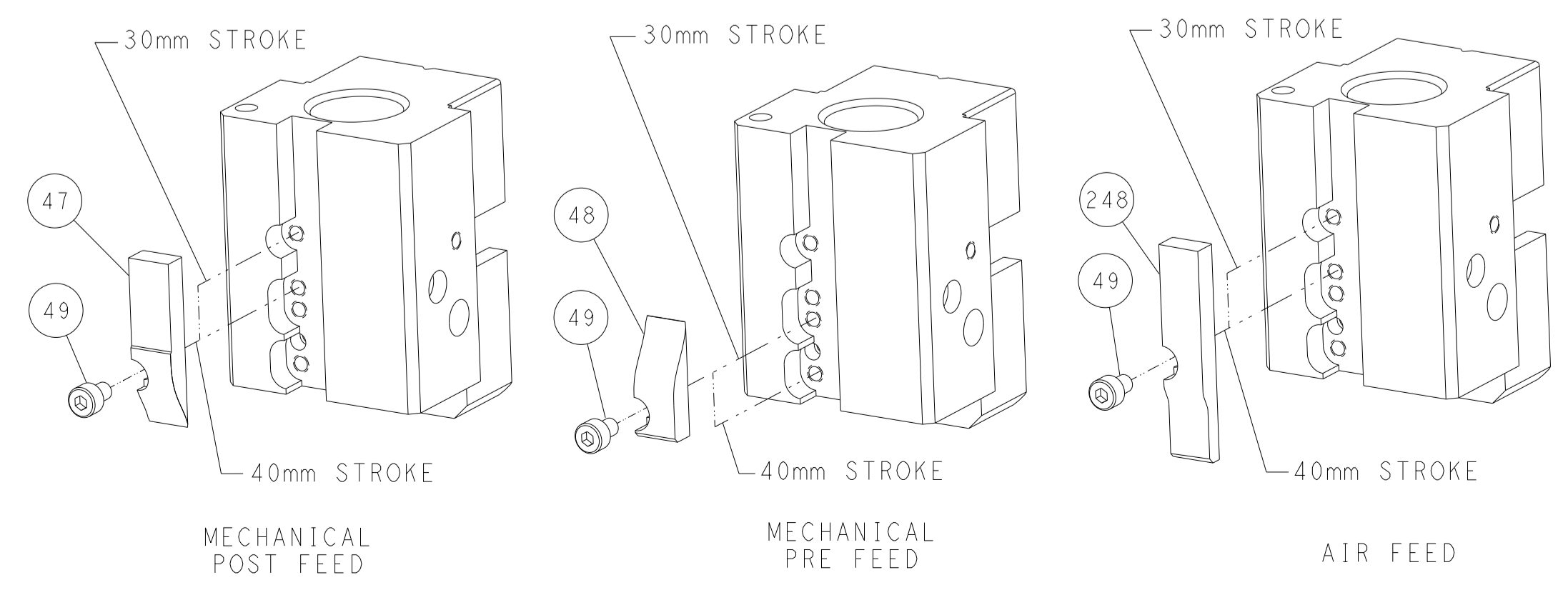


RAM AND HOLDDOWN SET-UP

FEED TYPE  
MECHANICAL



CAM POSITIONS

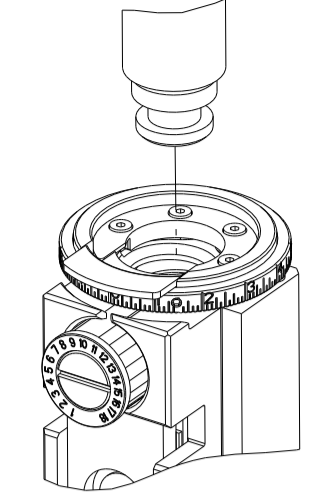


ATLANTIC VERSION  
 Shown on sheets 1 of 4 & 2 of 4  
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

<small>THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.</small>		DWN: K. HUANG 29FEB2012 CHK: S. XI 29FEB2012 APVD: S. XI 29FEB2012	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: 2150182 SCALE: 1:1 SHEET: 2 of 4 REV: H
MATERIAL:		WEIGHT:	RESTRICTED TO:

8	7	6	5	4	3	2	1
THIS DRAWING IS UNPUBLISHED.		RELEASED FOR PUBLICATION		20			
COPYRIGHT © BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.							
PART NUMBER	REVISION	DESCRIPTION	FEED TYPE				
2-2150182-1	H	FINE CRIMP HEIGHT ADJUST	MECHANICAL				
2-2150182-2	H	FINE CRIMP HEIGHT ADJUST	PNEUMATIC				
7-2150182-7	C	CRIMP TOOLING KIT	-				

PACIFIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.40 mm [.055]	F
INSUL	2.29 mm [.090]	F
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: .110 SER.FASTON REC.			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
3.90-4.70 mm [.154-.185 IN]		∅1.30-2.00 mm [.051-.079 IN]	
TERMINAL APPLICATION SPECIFICATION	(A)114-3118		
	(B)114-20109		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
(A) 160724-1	(B) 5-160303-1	(B) 6-160303-2	(A) 160366-1
(A) 160724-2	(B) 5-160303-2	(B) 6-160303-4	(A) 160366-2
(B) 5-160315-2	(B) 5-160303-3	(B) 5-160316-1	(A) 160366-4
(A) 881505-1	(B) 5-160303-6	(B) 5-160316-2	(A) 160366-6
(A) 881505-5	(B) 5-160303-7	(B) 5-160316-3	(A) 881504-1
	(B) 5-160303-9	(B) 6-160316-4	(A) 881504-5

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: .110 SER.FASTON REC.			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
3.90-4.70 mm [.154-.185 IN]		∅1.30-2.00 mm [.051-.079 IN]	
TERMINAL APPLICATION SPECIFICATION	(A)114-3118		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
(A) 160173-1	(A) 160173-2	(A) 160173-4	(A) 160173-6
(A) 160173-7			

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: .110 SER.FASTON REC.			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
3.90-4.70 mm [.154-.185 IN]		∅1.30-2.00 mm [.051-.079 IN]	
TERMINAL APPLICATION SPECIFICATION			
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
(C) 5-160303-2			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.50mm2	1.09+/-0.05 [.043+/- .002]	5.2
0.40mm2	0.97+/-0.05 [.038+/- .002]	6.3
0.30mm2	0.91+/-0.05 [.036+/- .002]	7.0

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.50mm2	1.09+/-0.05 [.043+/- .002]	5.2
0.40mm2	0.97+/-0.05 [.038+/- .002]	6.3
0.35mm2	0.94+/-0.05 [.037+/- .002]	6.6
0.30mm2	0.91+/-0.05 [.036+/- .002]	7.0

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.35mm2	0.95+/-0.03 [.037+/- .001]	6.7

- 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 ITEMS 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 LUBRICANT IS RECOMMENDED.
- THIS CRIMP PARAMETER IS PROVIDED TO MEET A CUSTOM AND UNIQUE CUSTOMER REQUIREMENT. IT HAS BEEN EVALUATED AND IS CONDITIONALLY SPECIFIED BY TE CONNECTIVITY. THIS CUSTOMIZED CRIMP PARAMETER IS NOT LISTED AS AN APPROVED APPLICATION WITHIN A TE CONNECTIVITY APPLICATION SPECIFICATION; HOWEVER, IT HAS BEEN VALIDATED ACCORDING TO TE CONNECTIVITY SPECIFICATIONS 109-18079 (TEST GROUP 1) AND 114-18022. **TE CONNECTIVITY EXPRESSLY DISCLAIMS ANY AND ALL WARRANTIES THAT THE PRODUCT WILL PERFORM SIMILARLY TO VALIDATED AND APPROVED APPLICATIONS, AS STATED WITHIN TE CONNECTIVITY APPLICATION SPECIFICATIONS, INCLUDING BUT NOT LIMITED TO IMPLIED WARRANTIES OF MERCHANTABILITY OR FITNESS FOR PARTICULAR PURPOSE.** AS SUCH, IT IS HIGHLY RECOMMENDED THAT THE CUSTOMER PERFORM FURTHER DETAILED EVALUATION TO ASSESS PRODUCT PERFORMANCE IN THE SPECIFIC APPLICATION.

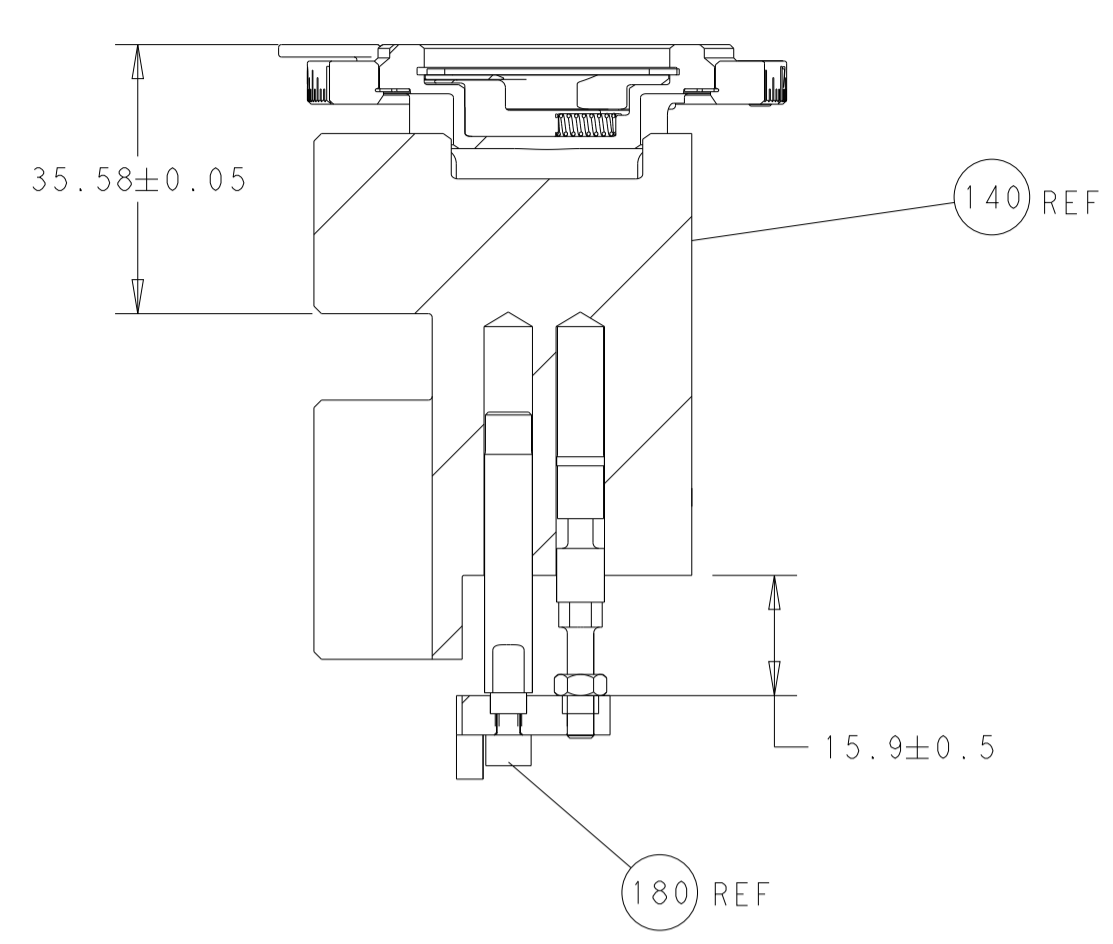
**\*WARNING**  
ON INSTALLATION, SET WIRE DISC TO CRIMP HEIGHT REFERENCE SETTING FOR LARGEST WIRE SIZE. CRIMP HEIGHT REFERENCE SETTINGS GREATER THAN THE VALUE SHOWN MAY CAUSE DAMAGE TO THE CRIMP TOOLING. REFER TO THE INSTRUCTION SHEET FOR PROPER SETUP AND ADJUSTMENTS.

QTY	REV	LOC	DIST	PART NO	DESCRIPTION	ITEM NO
-	1	1	2119082-8	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	2119580-1	MECHANICAL FEED ASSEMBLY	239	
-	1	-	2844940-3	AIR FEED MODULE	238	
-	1	1	1-18028-0	WASHER, FLAT, REG M8	192	
-	4	4	2079383-9	SCR, BHSC, RoHS (M6 X 20)	186	
-	1	1	1752354-1	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	
-	REF	REF	994970-2	COUNTER, MAGNETIC	164	
-	1	-	2119641-2	FEED CAM, AIR FEED	152	
-	1	1	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	144	
-	-	1	2119653-2	FEED CAM, POST FEED	142	
-	1	1	2119655-6	APPLICATOR BASIC ASSEMBLY, EF	141	
-	1	1	1803518-1	RAM ASSEMBLY, EF PACIFIC	140	
-	1	1	2119955-2	ASSY, LUBRICATOR, END FEED	84	
-	1	1	455888-9	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	1901681-5	HOLDDOWN, TERMINAL	65	
-	2	2	2168400-5	SHCS, LOW HEAD, RoHS, M4 X 20	64	
-	2	2	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59	
-	-	1	2063961-6	FEED FINGER	58	
-	3	3	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57	
-	2	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	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	2	18023-9	SCR, SKT HD CAP M4 X 6.0	49	
-	-	1	2119652-1	FEED CAM, PRE FEED	48	
-	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	1752371-9	PLATE, STRIP GUIDE	24	
-	1	1	240825-6	PLATE, STRIP HOLD DOWN	23	
-	2	2	2-22281-3	SPRING, COMPRESSION	22	
-	1	1	1803292-1	DRAG	20	
-	1	1	1803152-3	STRIP GUIDE, REAR	19	
-	1	1	1803151-3	STRIP GUIDE, FRONT	18	
-	1	1	240833-6	PLATE, REAR SHEAR	11	
-	2	2	1-240645-1	SPACER, SHEAR PLATE	10	
-	1	1	690796-2	PLATE-FRONT SHEAR MINI APPLICATOR	9	
1	1	1	1333213-1	ANVIL, COMBINATION	8	
-	1	1	240651-9	BLADE, SLUG	7	
-	-	-	-	-	6	
-	1	1	240641-8	SPACER	5	
-	1	1	238011-2	BLOCK, CRIMPER SPACER	4	
1	1	1	3-1633961-2	CRIMPER, INSULATION F PREMIUM	3	
-	-	-	-	-	2	
1	1	1	3-1633730-2	CRIMPER, WIRE	1	
-	77	22	21	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)

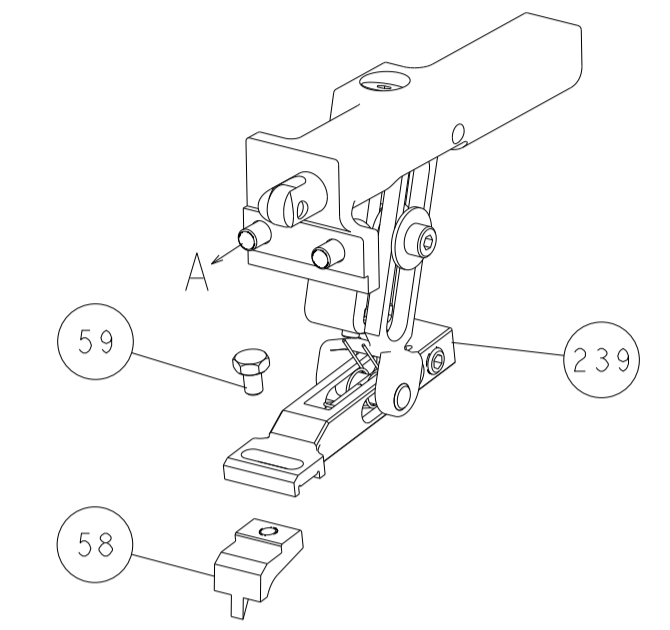
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mm		0 PLC ±		CHK S. XI 29FEB2012		Ocean End Feed Applicator	
		1 PLC ±		APVD S. XI 29FEB2012		SIZE CAGE CODE DRAWING NO RESTRICTED TO	
		2 PLC ±		NAME		A1 00779 C=2150182	
		3 PLC ±		APPLICATION SPEC		Customer Accessible Production Drawing	
		4 PLC ±		WEIGHT		SCALE 1:1 SHEET 3 OF 4 REV H	
		ANGLES FINISH		MATERIAL		Customer Accessible Production Drawing	

LOC	DIST	REV	DESCRIPTION	DATE	OWN	APVD
A	66		SEE SHEET 1			

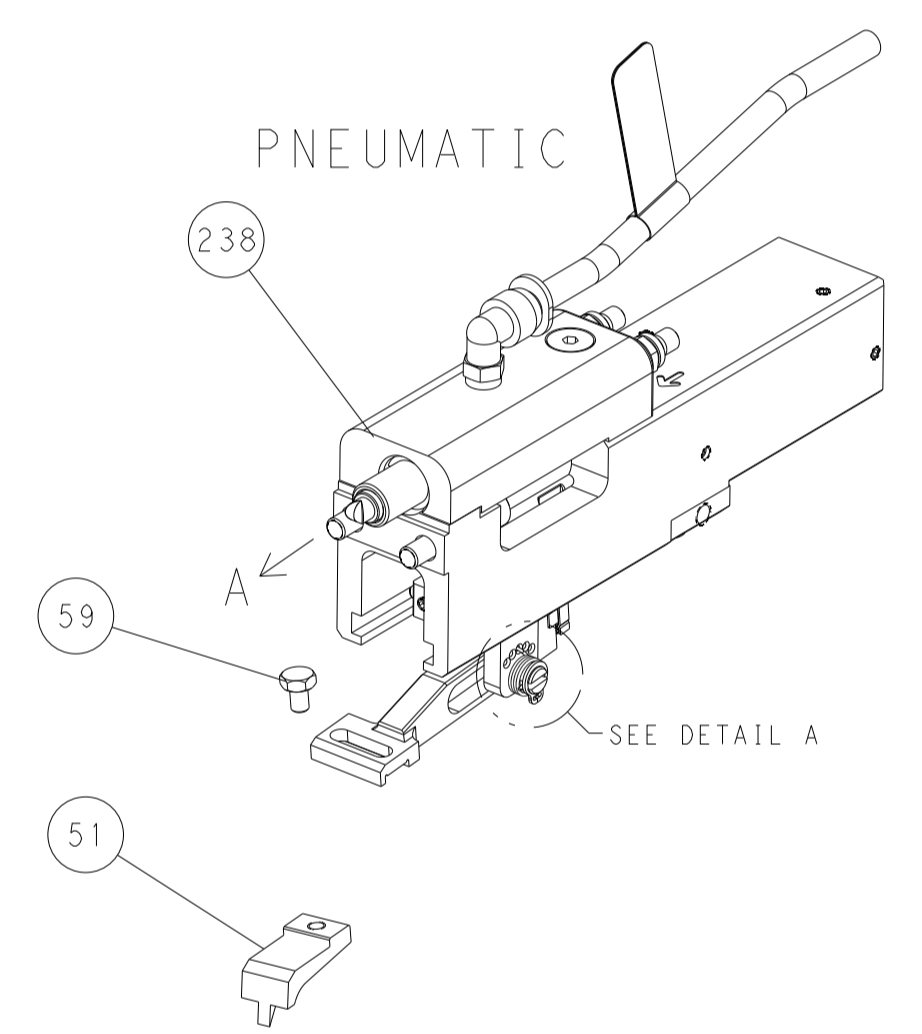


RAM AND HOLDDOWN SET-UP

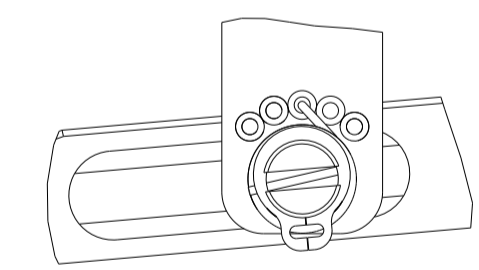
FEED TYPE  
MECHANICAL



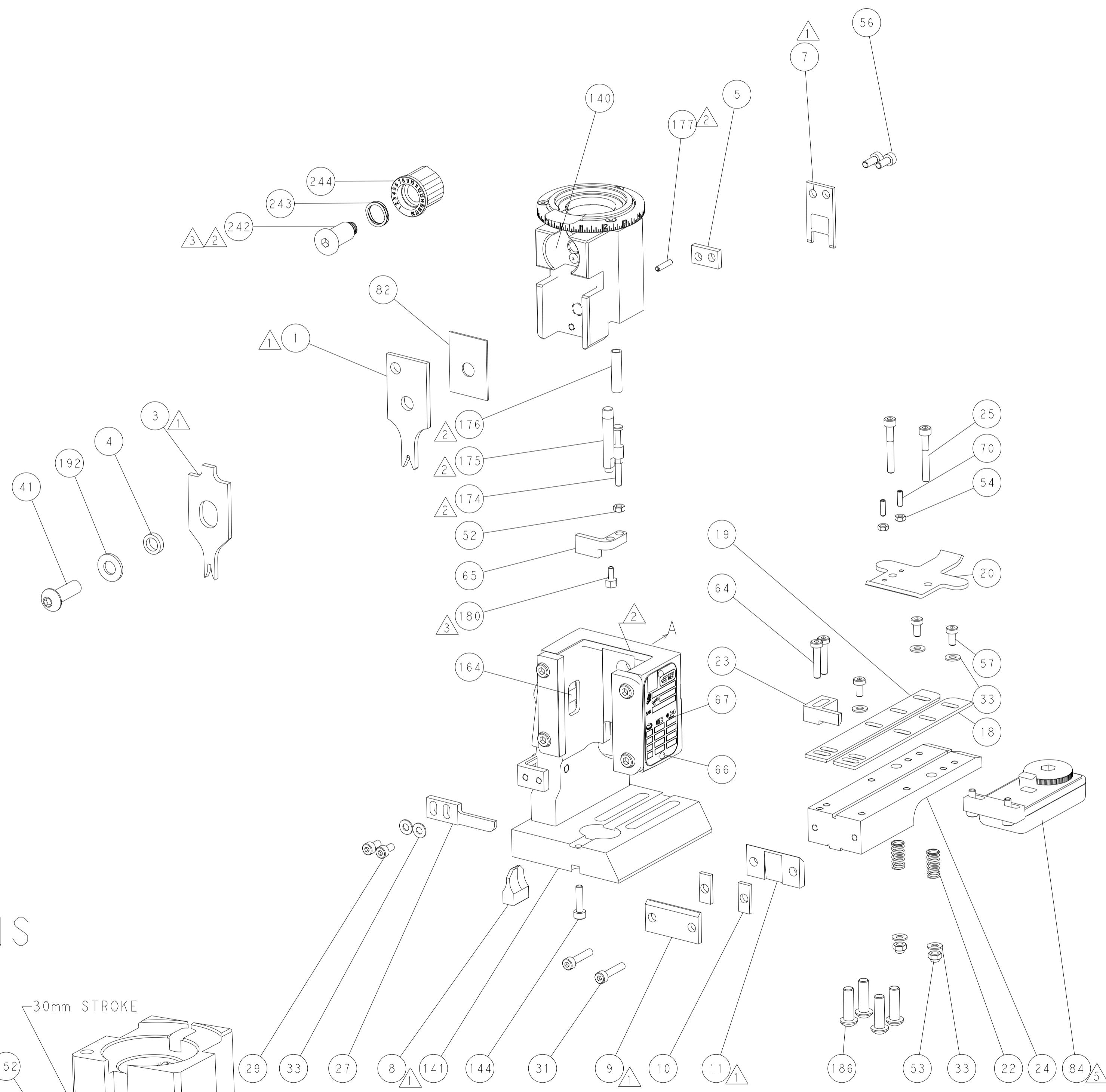
PNEUMATIC



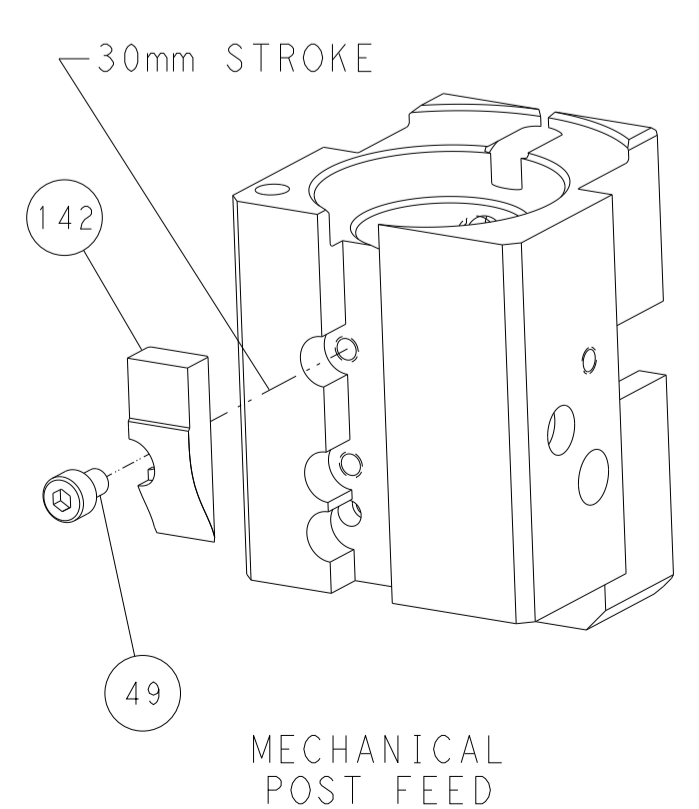
FEED SPRING  
SETTING POSITION



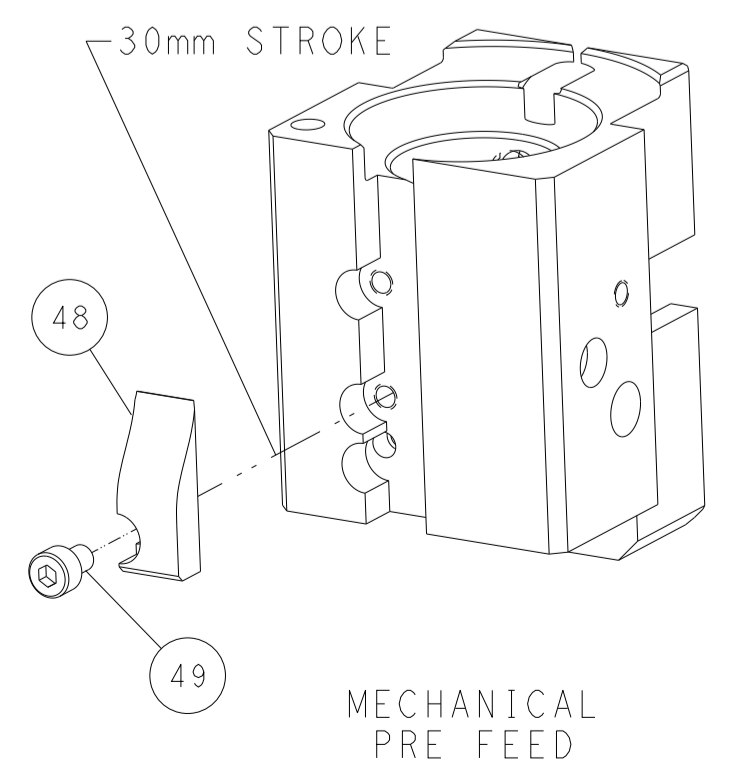
DETAIL A



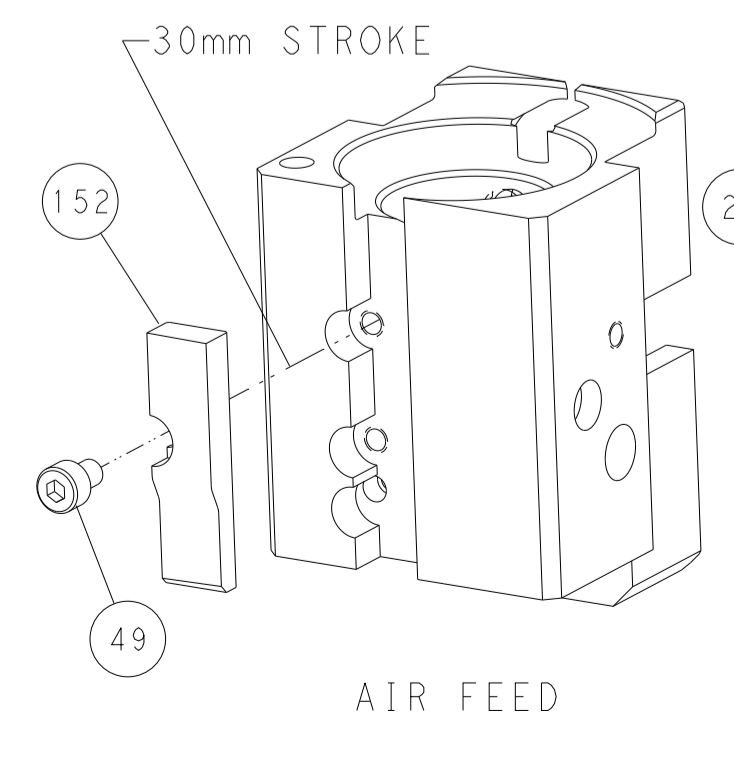
CAM POSITIONS



MECHANICAL POST FEED



MECHANICAL PRE FEED



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:		OWN: K. HUANG	29FEB2012	STE TE Connectivity Harrisburg, PA 17105-3608
mm	0 PLC ±	1 PLC ±	2 PLC ±	CHK: S. XI	29FEB2012	
MATERIAL:		FINISH:		APVD: S. XI	29FEB2012	NAME: Ocean End Feed Applicator
				PRODUCT SPEC:		SIZE: A1
				APPLICATION SPEC:		CAGE CODE: 00779
				WEIGHT:		DRAWING NO: C=2150182
				Customer Accessible Production Drawing		RESTRICTED TO: -
				SCALE: 1:1	SHEET 4 OF 4	REV H