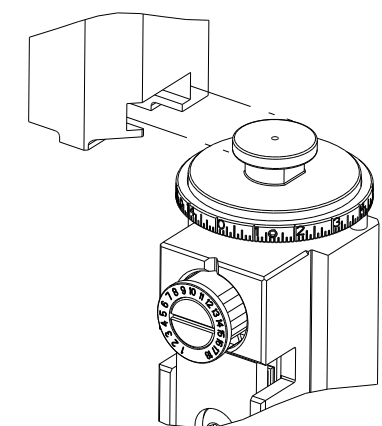


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150368-2	F	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150368-2	F	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150368-7	C	CRIMP TOOLING KIT	-

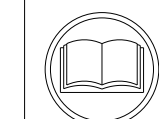
ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	3.56 mm [.140]	F
INSUL	4.57 mm [.180]	F
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION			
TERMINAL NAME: RECEPTACLE, CLUSTER PIN, 3.18(.125) DIA			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
5.84-6.60 mm [.230-.260 IN]		∅3.05-4.32 mm [.120-.170 IN]	
TERMINAL APPLICATION SPECIFICATION	114-2019	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
1217175-1	1217175-4	1217175-5	62243-3
62243-5			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
10 AWG OR 5.20mm2	2.97+/-0.05 [.117+/- .002]	3.0
12 AWG OR 3.30mm2	2.54+/-0.05 [.100+/- .002]	7.6
14 AWG OR 2.00mm2	2.24+/-0.05 [.088+/- .002]	10.5



- 1 RECOMMENDED SPARE PARTS
  - 2 REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
  - 3 APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242.
  - 4 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.
  - 5 TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
  - 6 THE RECOMMENDED SET-UP FOR END FEED APPLICATORS IS POST-FEED WITH ITEM 2119653-1. THE APPLICATOR CAN BE CONFIGURED FOR PRE-FEED WITH ITEM 2119652-1 BUT MAY ENCOUNTER PROBLEMS WITH SOME APPLICATIONS. FEED ISSUES OR TERMINAL JAMMING MAY OCCUR IN THE PRE-FEED CONFIGURATION.
  - 7 FEED TERMINALS FROM RECEPTACLE END.
  - 8 SET ITEM 16 TO DIMENSION SHOWN.
  - 9 TERMINAL LUBRICANT IS RECOMMENDED.
  - 10 ITEM 27 MUST BE POSITIONED CLOSE ITEM 16 TO PROPERLY STRIP TERMINAL
11. 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					
A	66	P	LTN	DESCRIPTION	DATE	DWN	APVD
		C		ECR-16-012215	25AUG2016	JH	CT
		D		ECR-19-013602	29AUG2019	LG	TE
		E		ECR-20-016675	23NOV2020	TB	RK
		F		ECR-22-137565	29APR2022	FJ	YY

-	1	1	1803203-1	BLOCK, FRONT DEPRESSOR	270	
-	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	
3	-	1	2119083-1	RETAINER, INSULATION DIAL	242	
-	1	1	2844940-4	AIR FEED MODULE	238	
-	REF	REF	994970-2	COUNTER, MAGNETIC	164	
9	-	1	2119955-2	ASSY, LUBRICATOR, END FEED	84	
-	1	1	455888-7	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	
-	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	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	56	
-	2	2	5018030-1	NUT, HEX, REG, RoHS, M3	54	
-	2	2	986965-8	NUT, LOCK, HEX, TORQUE (M4)	53	
7	-	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	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	31	
-	2	2	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	29	
10	-	1	240639-4	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	240825-3	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	
8	-	1	1-217573-1	TOOL, SIZING	16	
-	1	1	5-240641-8	SPACER	15	
1	-	1	240644-1	PLATE, REAR SHEAR	11	
-	-	-	-	-	10	
1	-	1	690482-3	PLATE, FRONT SHEAR	9	
1	2	1	1633387-4	ANVIL, COMBINATION	8	
1	-	1	5-690474-4	BLADE, SLUG	7	
-	-	-	-	-	6	
-	1	1	4-240641-2	SPACER	5	
-	1	1	7-238011-3	BLOCK, CRIMPER SPACER	4	
1	2	1	4-1633962-0	CRIMPER, INSULATION F PREMIUM	3	
-	1	1	2-455888-1	SPACER, CRIMPER	2	
1	2	1	1-456425-0	CRIMPER, WIRE .140 F PREMIUM	1	
-	77	-	72	-	2	
				PART NO	DESCRIPTION	ITEM NO

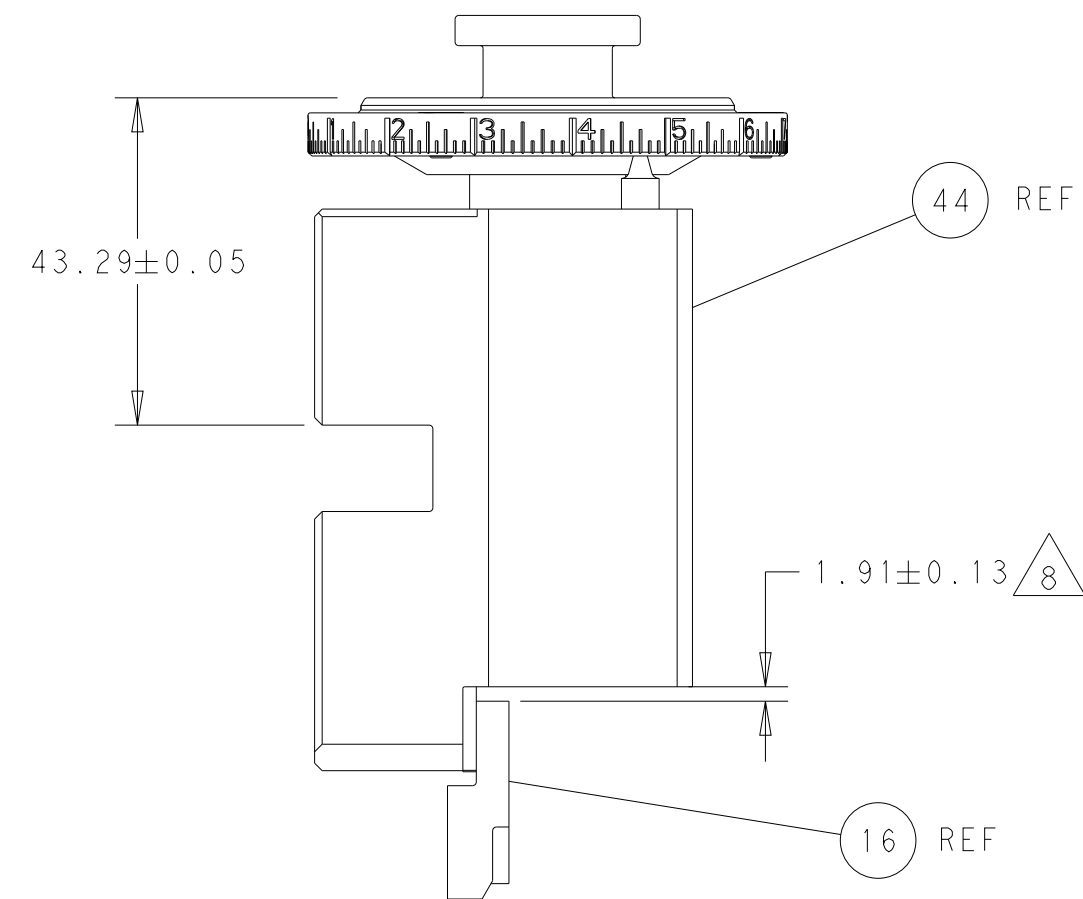
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DRAWING NO		RESTRICTED TO	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES ±	FINISH ±
MATERIAL				WEIGHT	SCALE	SHEET	REV
-				-	1:1	1 OF 4	F



Ocean End Feed Applicator

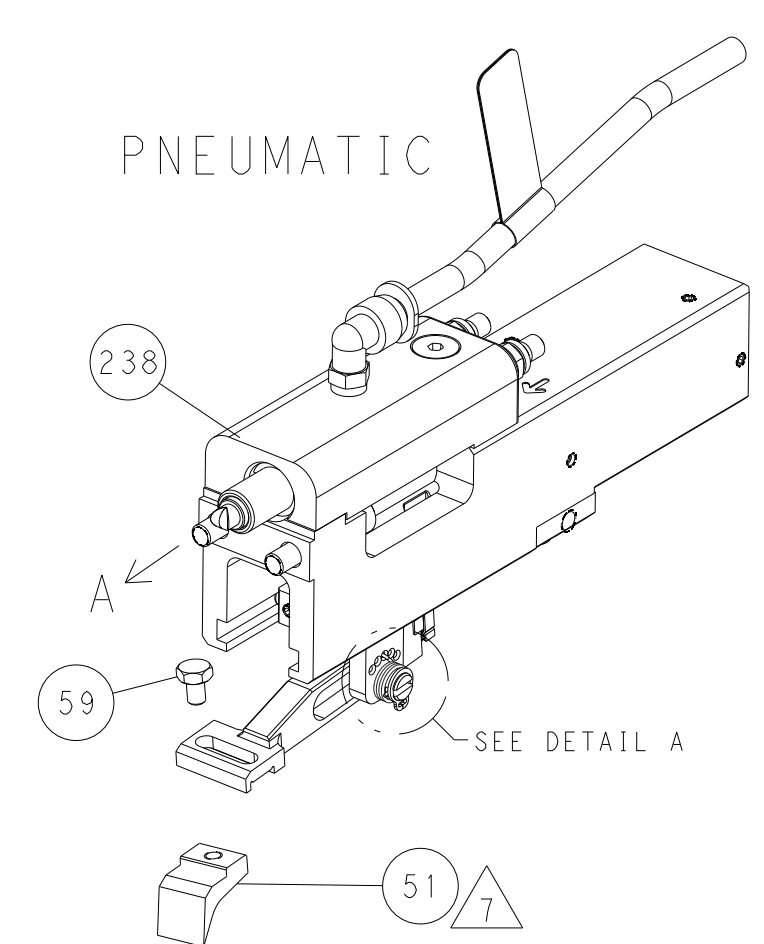
Customer Accessible Production Drawing

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

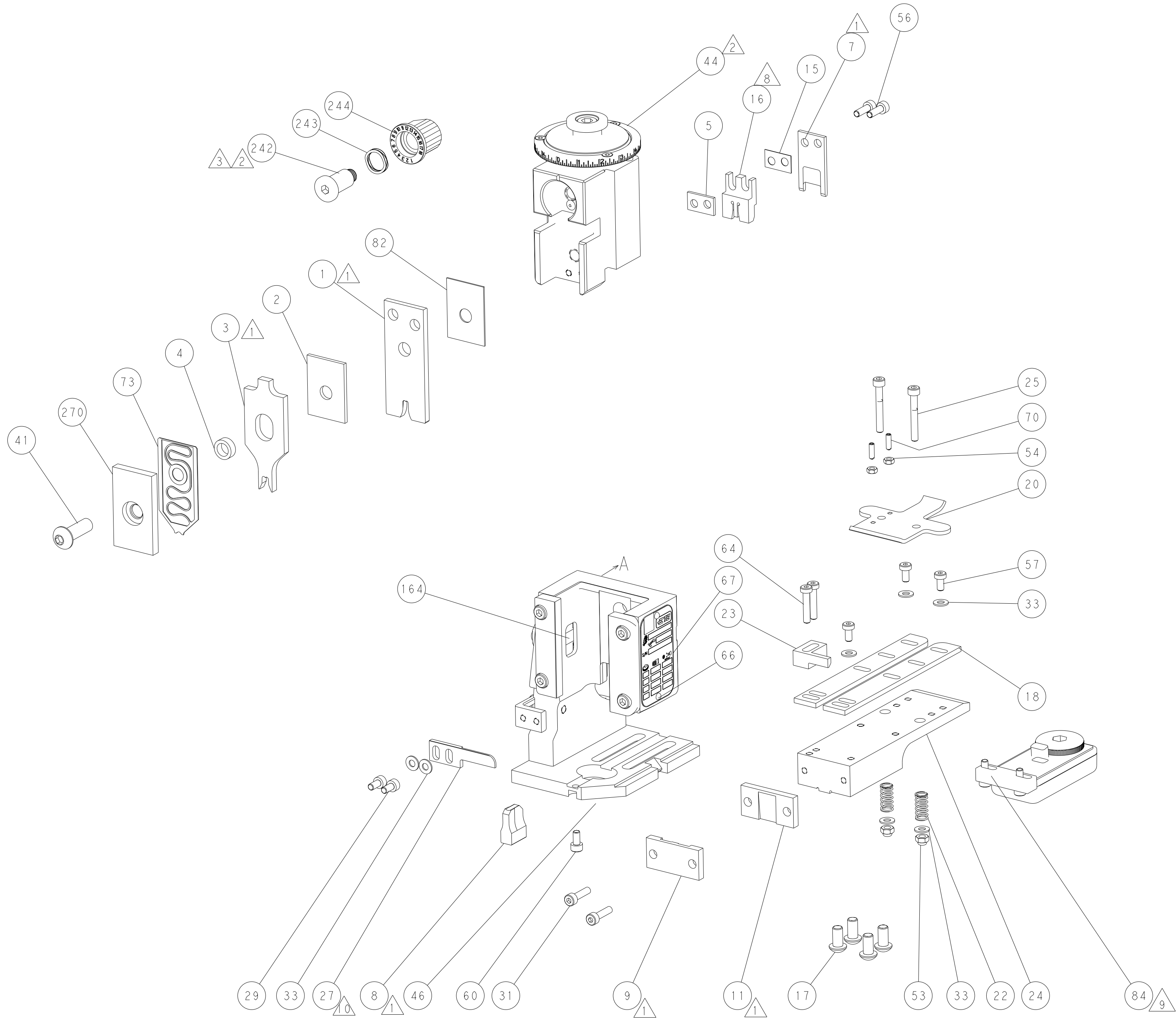
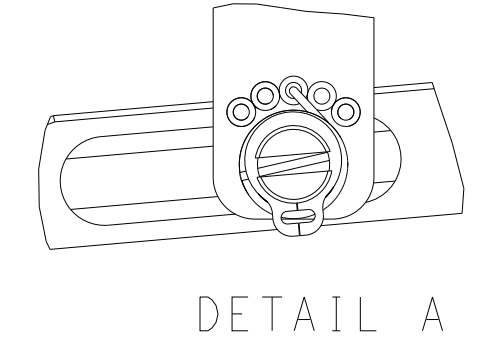


RAM SET-UP AND SIZING TOOL DIMENSION

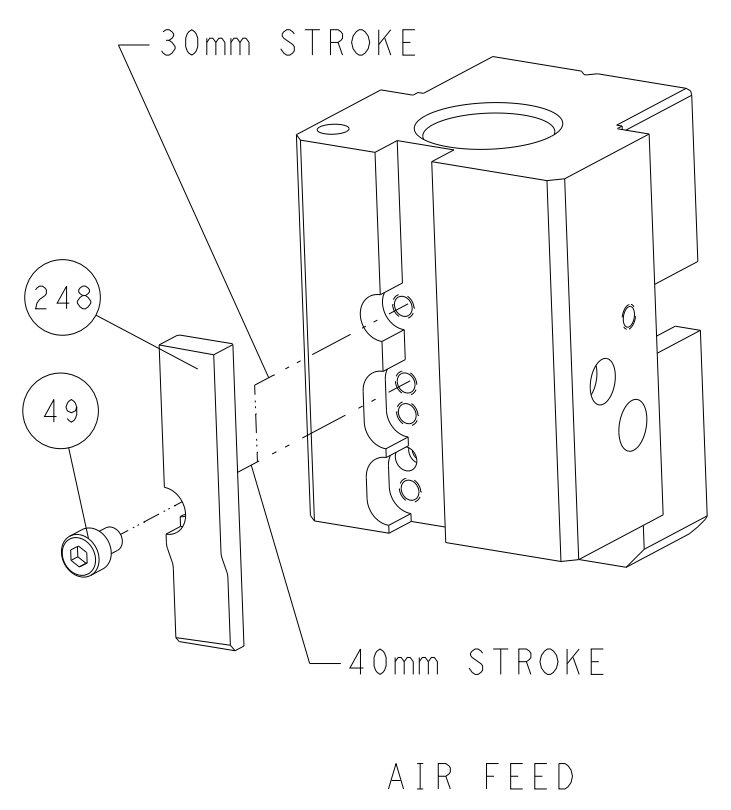
FEED TYPE



FEED SPRING SETTING POSITION



CAM POSITION

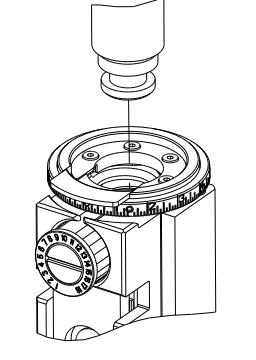


**ATLANTIC VERSION**  
 Shown on sheets 1 of 4 & 2 of 4  
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

<small>THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.</small>		DWN R. KNEPPER 26-Sep-13 CHK G. BAILEY 26-Sep-13 APVD M. CLIFFORD 26-Sep-13	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	RESTRICTED TO SIZE CAGE CODE DRAWING NO. 00779 C=2150368 SCALE 1:1 SHEET 2 OF 4 REV F
MATERIAL:		Customer Accessible Production Drawing	

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150368-2	F	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150368-7	C	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR  
 INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	3.56 mm [.140]	F
INSUL	4.57 mm [.180]	F
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION			
TERMINAL NAME: RECEPTACLE, CLUSTER PIN, 3.18[.125] DIA			
WIRE STRIP LENGTH 5.84-6.60 mm [.230-.260 IN]		INSULATION DIAMETER RANGE 4.32 mm [.170 IN] MAX	
TERMINAL APPLICATION SPECIFICATION 114-2019			
TERMINALS APPLIED 5 9			
TE TERMINAL 1217175-1	TE TERMINAL 1217175-4	TE TERMINAL 1217175-5	TE TERMINAL 62243-3

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
10 AWG OR 5.20mm2	2.97+/-0.05 [.117+/-0.002]	3.0
12 AWG OR 3.30mm2	2.54+/-0.05 [.100+/-0.002]	7.6
14 AWG OR 2.00mm2	2.24+/-0.05 [.088+/-0.002]	10.5



- 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.
  - 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.
  - THE RECOMMENDED SET-UP FOR END FEED APPLICATORS IS POST-FEED WITH ITEM 2119653-1. THE APPLICATOR CAN BE CONFIGURED FOR PRE-FEED WITH ITEM 2119652-1 BUT MAY ENCOUNTER PROBLEMS WITH SOME APPLICATIONS. FEED ISSUES OR TERMINAL JAMMING MAY OCCUR IN THE PRE-FEED CONFIGURATION.
  - FEED TERMINALS FROM RECEPTACLE END.
  - SET ITEM 16 TO DIMENSION SHOWN.
  - TERMINAL LUBRICANT IS RECOMMENDED.
  - ITEM 27 MUST BE POSITIONED CLOSE ITEM 16 TO PROPERLY STRIP TERMINAL
11. 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	REVISIONS					
		P	LTN	DESCRIPTION	DATE	DWN	APVD
A	66	-	-	SEE SHEET 1	-	-	-

-	1	1803203-1	BLOCK, FRONT DEPRESSOR	270
-	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
-	4	2079383-9	SCR, BHSC, RoHS (M6 X 20)	186
-	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	455888-7	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
-	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	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	56
-	2	5018030-1	NUT, HEX, REG, RoHS, M3	54
-	2	986965-8	NUT, LOCK, HEX, TORQUE (M4)	53
-	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	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	31
-	2	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	29
-	1	240639-4	STRIPPER (MACHINING)	27
-	2	1-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 30	25
-	1	1752371-5	PLATE, STRIP GUIDE	24
-	1	240825-3	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	1-217573-1	TOOL, SIZING	16
-	1	5-240641-8	SPACER	15
-	1	240644-1	PLATE, REAR SHEAR	11
-	-	-	-	10
-	1	690482-3	PLATE, FRONT SHEAR	9
-	1	1633387-4	ANVIL, COMBINATION	8
-	1	5-690474-4	BLADE, SLUG	7
-	-	-	-	6
-	1	4-240641-2	SPACER	5
-	1	7-238011-3	BLOCK, CRIMPER SPACER	4
-	1	4-1633962-0	CRIMPER, INSULATION F PREMIUM	3
-	1	2-455888-1	SPACER, CRIMPER	2
-	1	1-456425-0	CRIMPER, WIRE .140 F PREMIUM	1
-	77-22	PART NO	DESCRIPTION	ITEM NO

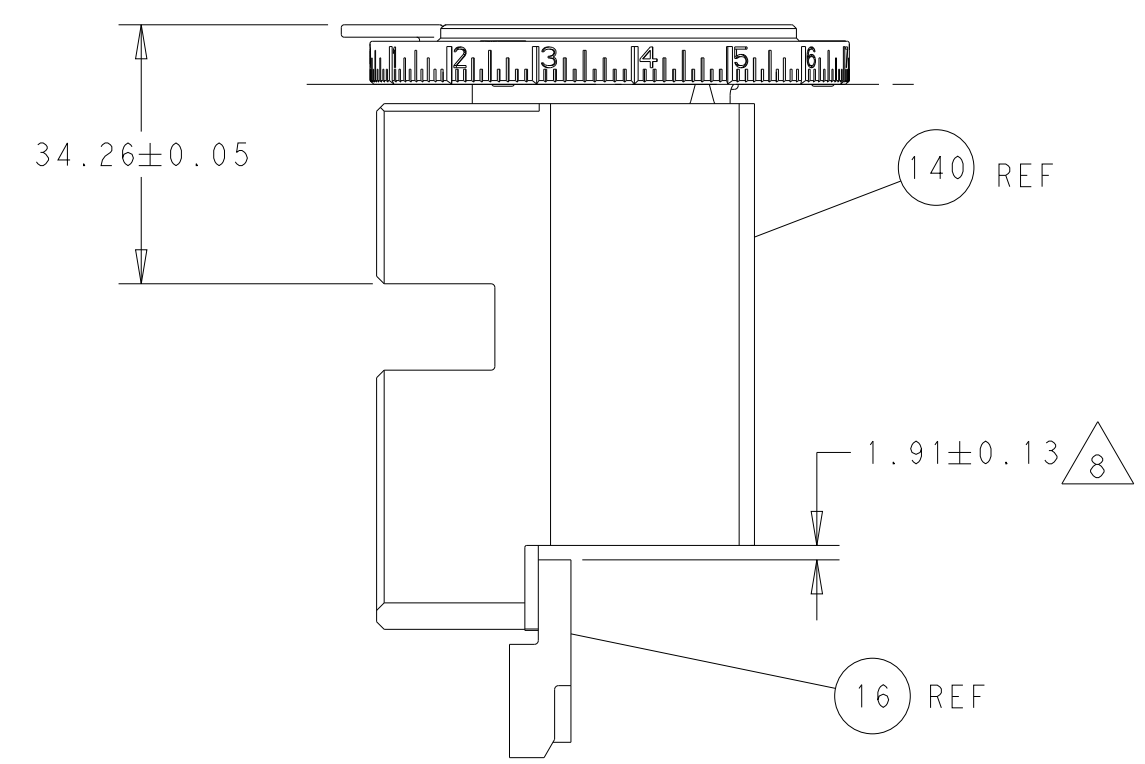
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		MATERIAL:		FINISH:		WEIGHT:		SCALE:	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES	FINISH	-	-	1:1	SHEET 3 OF 4
APPLICATOR DATA		APPLICATOR DATA		APPLICATOR DATA		APPLICATOR DATA		APPLICATOR DATA		APPLICATOR DATA	
APPLICATOR DATA		APPLICATOR DATA		APPLICATOR DATA		APPLICATOR DATA		APPLICATOR DATA		APPLICATOR DATA	



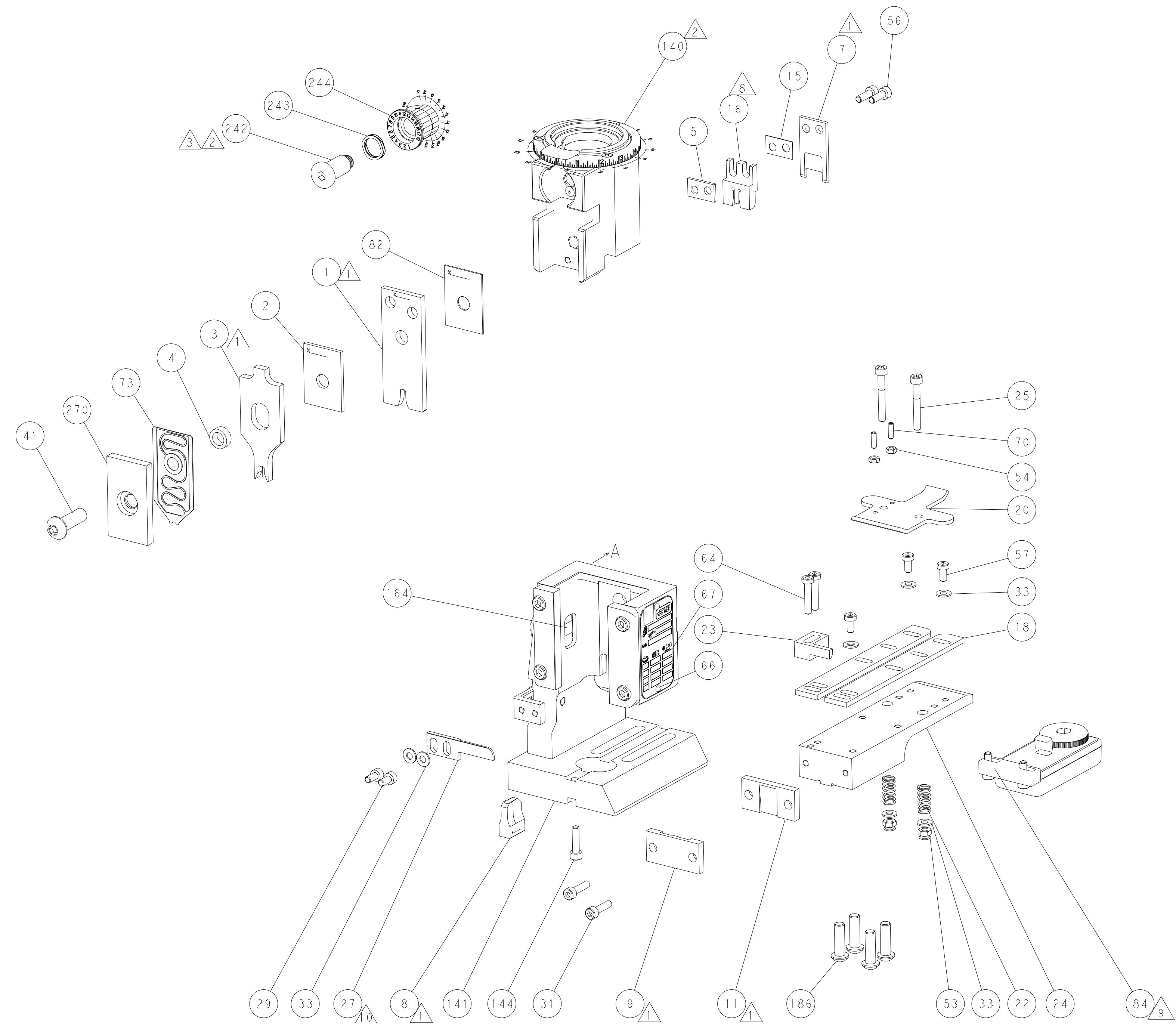
Ocean End Feed  
 Applicator

Customer Accessible Production Drawing

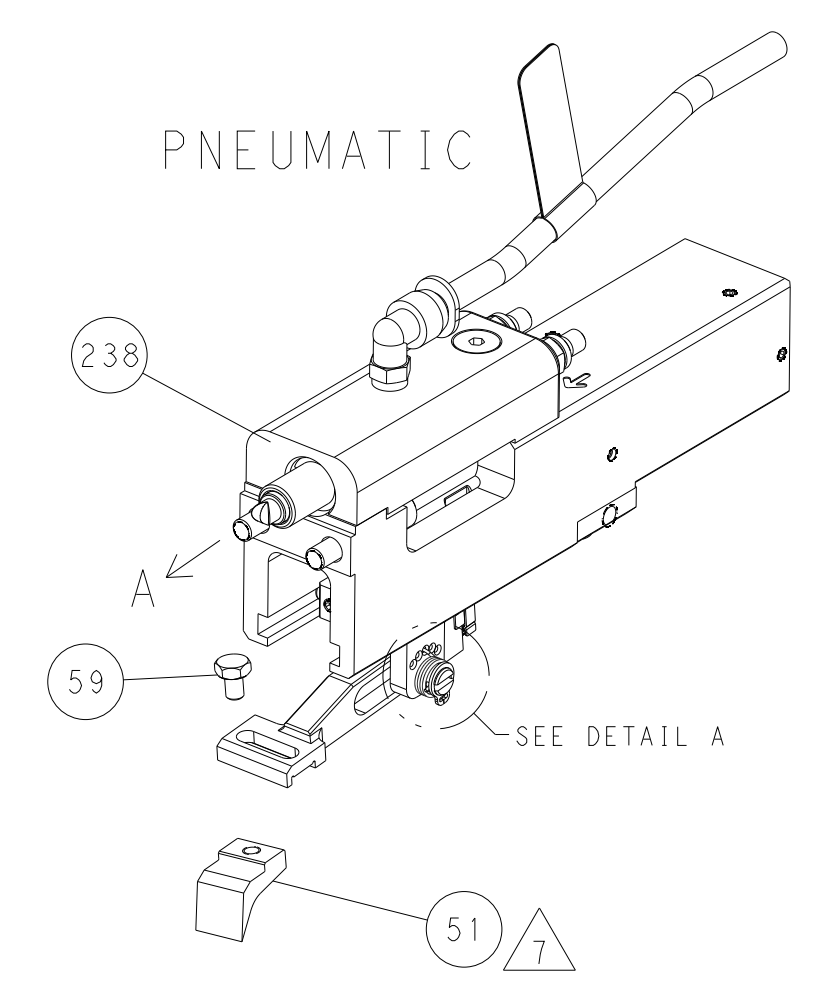
LOC	DIST	REVISIONS			
P	LTM	DESCRIPTION	DATE	OWN	APVD
A	66	SEE SHEET 1	-	-	-



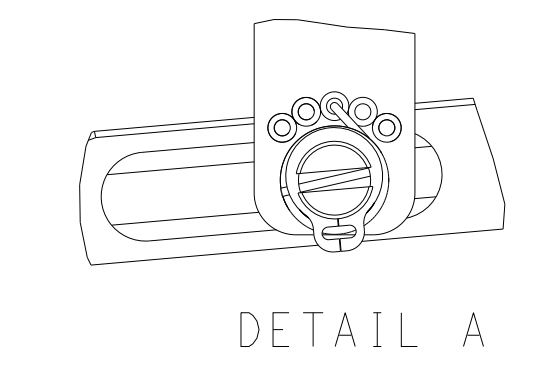
RAM SET-UP AND SIZING TOOL DIMENSION



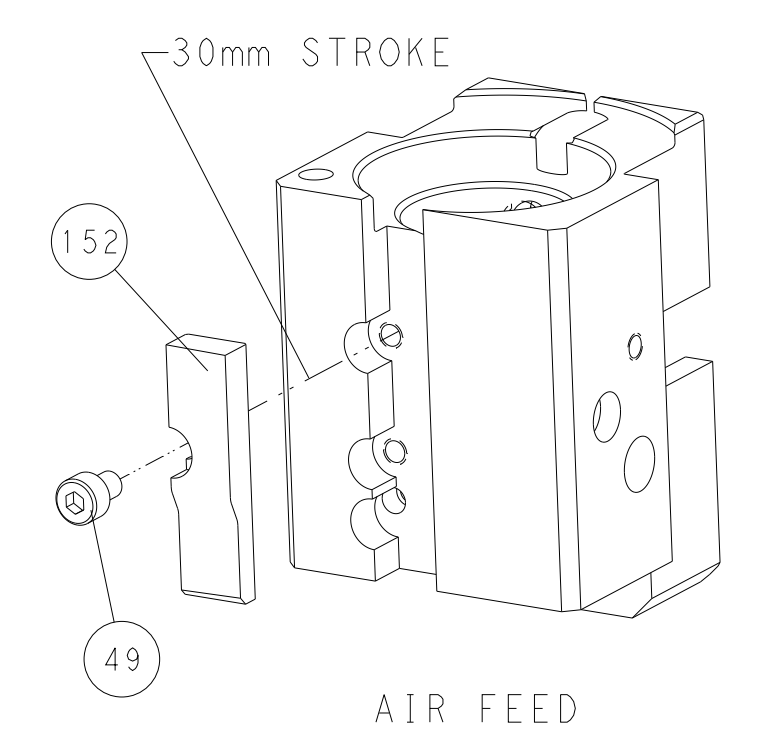
FEED TYPE



FEED SPRING SETTING POSITION



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 20. COPYRIGHT 20 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.</small>		DWN R. KNEPPER 26-Sep-13 CHK G. BAILEY 26-Sep-13 APVD M. CLIFFORD 26-Sep-13	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 APPLICATION SPEC SIZE CAGE CODE DRAWING NO. A1 00779 C=2150368 WEIGHT Customer Accessible Production Drawing	RESTRICTED TO SCALE 1:1 SHEET 4 OF 4 REV F