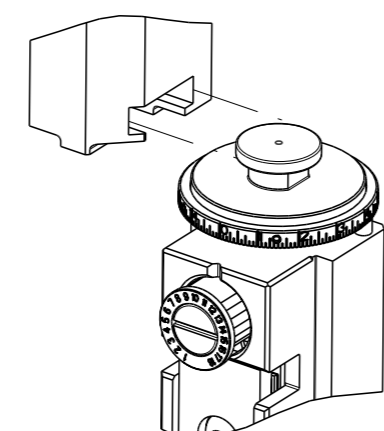


| PART NUMBER | REVISION | DESCRIPTION | FEED TYPE |
|-------------|----------|---------------------------------|-----------|
| 2150382-2 | L | FINE CRIMP HEIGHT ADJUST | PNEUMATIC |
| 7-2150382-2 | L | PNEUMATIC AND CRIMP TOOLING KIT | PNEUMATIC |
| 7-2150382-7 | J | CRIMP TOOLING KIT | - |

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



| APPLICATOR DATA | | |
|--------------------------------|----------------|------|
| CRIMP | SIZE | TYPE |
| WIRE | .110 [2.79 mm] | F |
| INSUL | .180 [4.57 mm] | F |
| APPL INSTRUCTIONS 408-35043 | | |

| TERMINAL DATA: TE TERMINAL | | TE CRIMP SPECIFICATION | |
|---|-------------|------------------------------|-------------|
| TERMINAL NAME: RECEPTACLE, FASTON, FLAG, LIF, .250 SERIES | | | |
| WIRE STRIP LENGTH | | INSULATION DIAMETER RANGE | |
| .198-.213 IN [5.02-5.40 mm] | | ∅.110-.160 IN [2.79-4.06 mm] | |
| TERMINAL APPLICATION SPECIFICATION | 114-2079 | | |
| TERMINALS APPLIED | | | |
| TE TERMINAL | TE TERMINAL | TE TERMINAL | TE TERMINAL |
| 63901-1 | 63010-3 | 63009-1 | 63096-1 |
| 63901-2 | 63012-1 | 63009-2 | 63096-2 |
| 63901-3 | 63012-2 | 63009-3 | |
| 63010-1 | | 63011-1 | |
| 63010-2 | | 63011-2 | |

| WIRE SIZE | CRIMP HEIGHT mm [INCH] | CRIMP HEIGHT REFERENCE SETTING |
|-----------|-----------------------------|--------------------------------|
| 14 AWG | 1.85+/-0.05 [1.073+/-0.002] | 3.6 |
| 16 AWG | 1.62+/-0.05 [1.064+/-0.002] | 6.1 |
| 18 AWG | 1.47+/-0.05 [1.058+/-0.002] | 7.7 |

- 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 IS NOT COMPATIBLE WITH MECHANICAL FEED.
 - TERMINAL LUBRICANT IS RECOMMENDED.
 - RIGHT HAND ORIENTED FLAG TERMINALS - WHEN RUNNING THESE TERMINALS, USE ITEM 1 WIRE CRIMPER WITH ITEM 14 BLOCK SUPPORT LOCATED UNDER THE TERMINAL FLAG.
 - LEFT HAND ORIENTED FLAG TERMINALS - WHEN RUNNING THESE TERMINALS, USE ITEM 178 WIRE CRIMPER WITH ITEM 14 BLOCK SUPPORT FLIPPED OVER AND LOCATED UNDER THE TERMINAL FLAG.
9. 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 | LYH | DESCRIPTION | DATE | OWN | APVD |
| | | H3 | | ECR-17-014067 | 22SEP2017 | RS | LZ |
| | | J | | ECR-17-017211 | 22NOV2017 | TB | TE |
| | | K | | ECR-18-012381 | 08AUG2018 | FZ | KZ |
| | | L | | ECR-19-009342 | 18JUN2019 | LG | TE |

| | | | | | | |
|---|-----|-----|-------------|-------------------------------------|-------------|---------|
| - | 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 | 2844940-3 | AIR FEED MODULE | 238 | |
| - | 1 | 1 | 1-18028-0 | WASHER, FLAT, REG M8 | 192 | |
| 1 | 2 | 1 | 2-1803224-2 | CRIMPER, WIRE | 178 | |
| - | REF | REF | 994970-2 | COUNTER, MAGNETIC | 164 | |
| - | 1 | 1 | 2119955-2 | ASSY, LUBRICATOR, END FEED | 84 | |
| - | 1 | 1 | 455888-7 | SPACER, CRIMPER | 82 | |
| - | 2 | 2 | 1-2168083-1 | SCR, SKT HD CAP, RoHS, M3 X 6 | 73 | |
| - | 1 | 1 | 464452-2 | DRAG, STOCK | 72 | |
| - | 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 | 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 | |
| - | 4 | 4 | 2168400-1 | SHCS, LOW HEAD, RoHS, M4 X 12 | 57 | |
| - | 2 | 2 | 2168083-2 | SCR, SKT HD CAP, RoHS, M4 X 8.0 | 56 | |
| - | 2 | 2 | 5018030-1 | NUT, HEX, REG, RoHS, M3 | 54 | |
| - | 2 | 2 | 986965-8 | NUT, LOCK, HEX, TORQUE (M4) | 53 | |
| - | 1 | 1 | 1-2063961-4 | 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 | |
| - | 8 | 8 | 1-18028-2 | WASHER, FLAT, REG M4 | 33 | |
| - | 2 | 2 | 1-2168083-2 | SCR, SKT HD CAP, RoHS, M4 X 25 | 31 | |
| - | 2 | 2 | 2168083-2 | SCR, SKT HD CAP, RoHS, M4 X 8.0 | 29 | |
| - | 1 | 1 | 468281-1 | STRIPPER | 27 | |
| - | 2 | 2 | 1-2168083-6 | SCR, SKT HD CAP, RoHS, M4 X 35 | 25 | |
| - | 1 | 1 | 2161922-4 | PLATE, STRIP GUIDE | 24 | |
| - | 2 | 2 | 22281-6 | SPRING, COMPRESSION | 22 | |
| - | 1 | 1 | 1633168-2 | ARM, STOCK DRAG | 21 | |
| - | 1 | 1 | 3-1901696-2 | STRIP GUIDE, REAR | 19 | |
| - | 1 | 1 | 3-1901695-2 | STRIP GUIDE, FRONT | 18 | |
| - | 4 | 4 | 1-2079383-1 | SCR, BHSC, RoHS (M6 X 12) | 17 | |
| - | 1 | 1 | 469633-1 | BLOCK, SUPPORT | 14 | |
| - | 1 | 1 | 461160-1 | PLATE, REAR SHEAR | 11 | |
| - | 2 | 2 | 5-240645-2 | SPACER, SHEAR PLATE | 10 | |
| - | 1 | 1 | 455961-3 | PLATE, FRONT SHEAR | 9 | |
| 1 | 1 | 2 | 1-1803000-6 | ANVIL, COMBINATION, END FEED | 8 | |
| - | 1 | 1 | 1-469634-7 | BLADE, SLUG | 7 | |
| - | - | - | - | - | 6 | |
| - | 1 | 1 | 4-240641-8 | SPACER | 5 | |
| - | 1 | 1 | 238011-2 | BLOCK, CRIMPER SPACER | 4 | |
| 1 | 1 | 2 | 1803229-1 | CRIMPER, INSULATION O PREMIUM | 3 | |
| - | 1 | 1 | 2-455888-0 | SPACER, CRIMPER | 2 | |
| 1 | 1 | 2 | 1-1803224-8 | CRIMPER, WIRE | 1 | |
| - | 77 | 72 | 2 | PART NO | DESCRIPTION | ITEM NO |

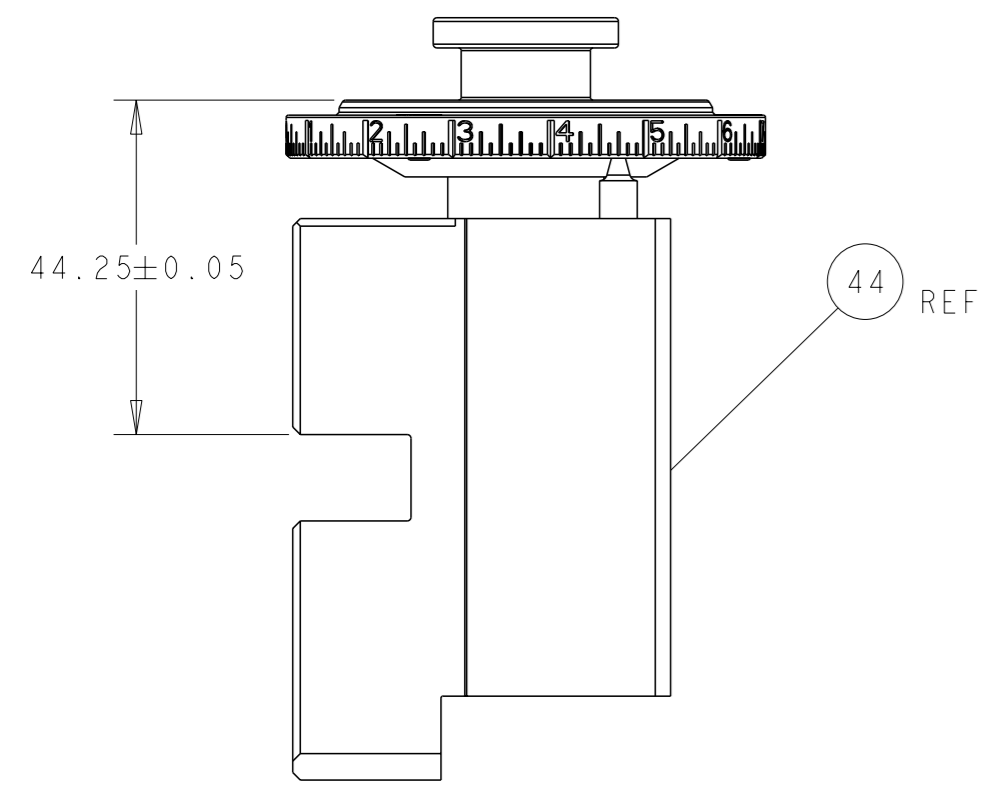
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|-------------|---------|--|---------|-----------|---------|
| mm | 0 PLC ± | 1 PLC ± | 2 PLC ± | 3 PLC ± | 4 PLC ± |
| | FINISH | FINISH | FINISH | FINISH | FINISH |
| WEIGHT | | SCALE | | SHEET | |
| A | | 1:1 | | 1 OF 4 | |

STE TE Connectivity
Harrisburg, PA 17105-3608

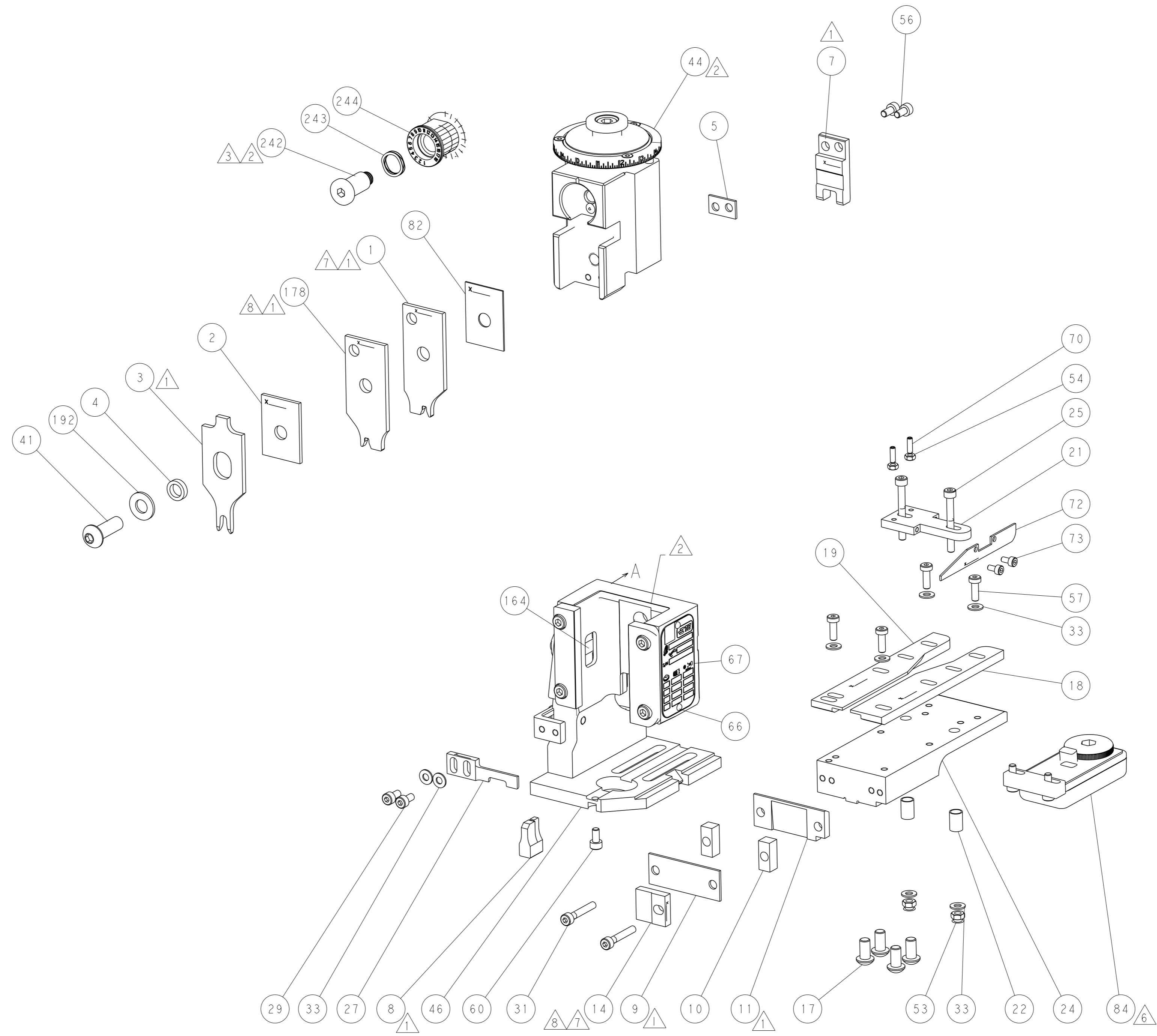
Ocean End Feed Applicator

Customer Accessible Production Drawing

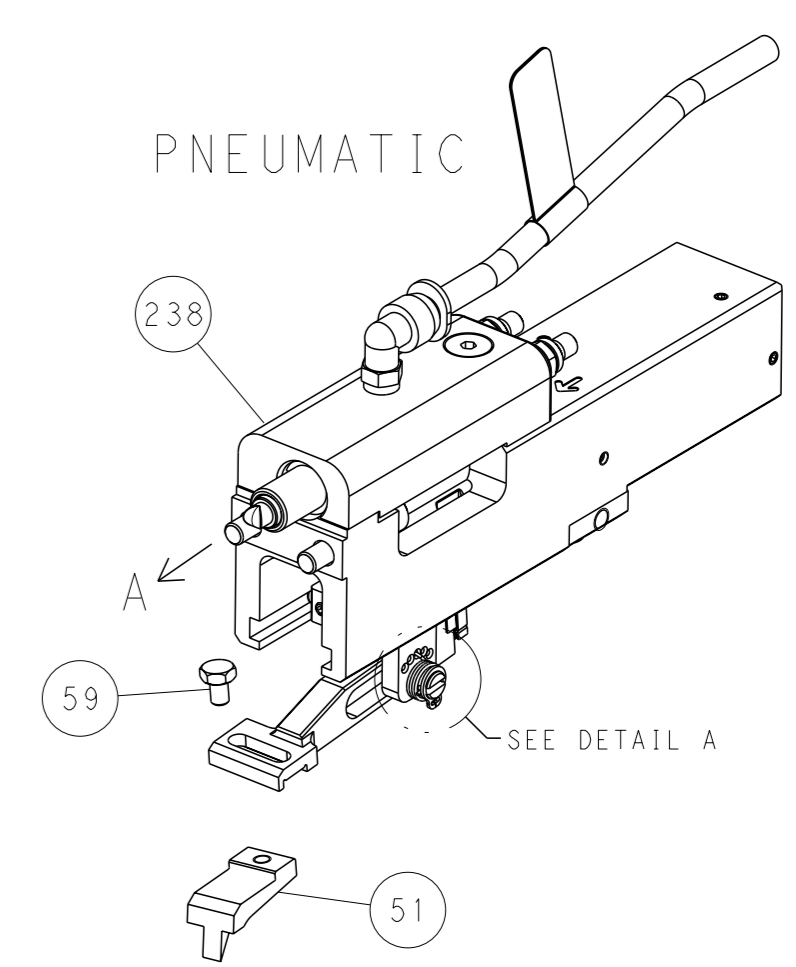
| LOC | DIST | REVISIONS | | | |
|-----|-------------|-----------|------|-----|------|
| A | 66 | REV | DATE | OWN | APVD |
| - | SEE SHEET 1 | - | - | - | - |



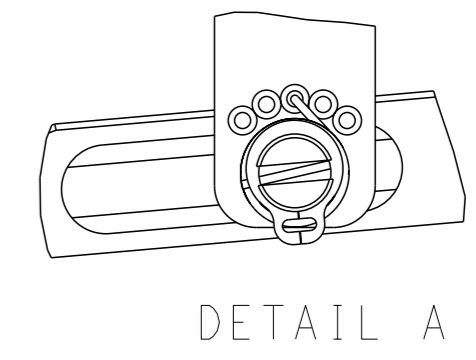
RAM SET-UP



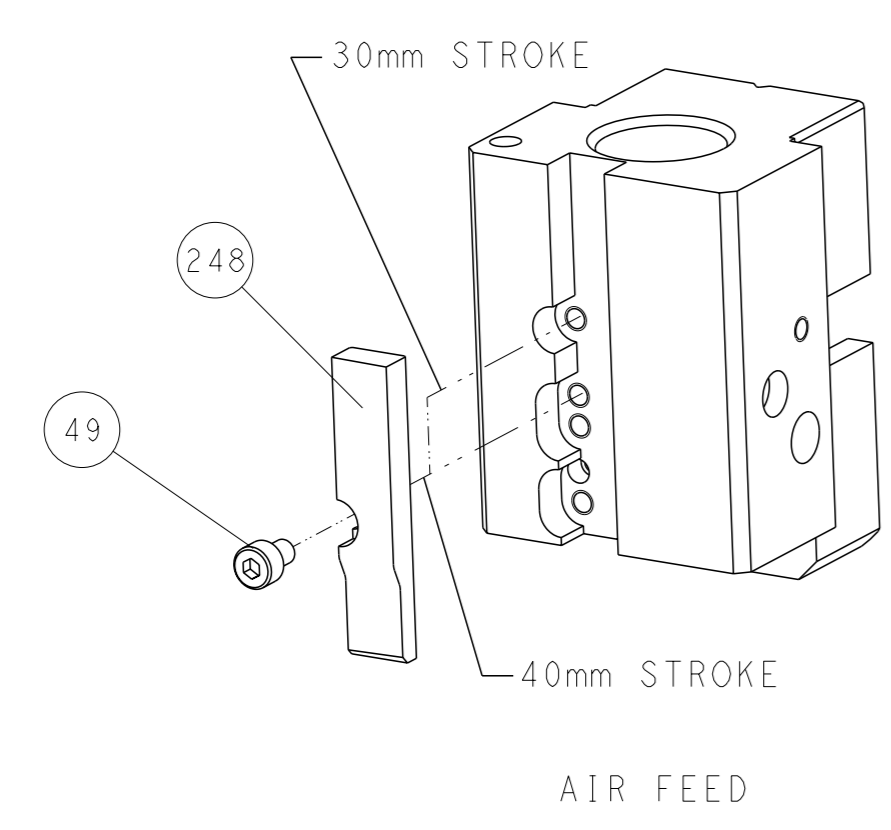
FEED TYPE



FEED SPRING SETTING POSITION



CAM POSITION



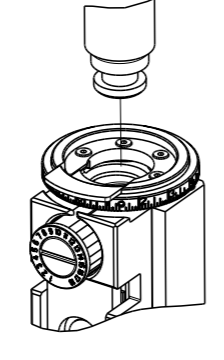
AIR FEED

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 UNPUBLISHED. RELEASED FOR PUBLICATION 20 © COPYRIGHT 20 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.</small> | | DWN: K. STAKEM CHK: G. BAILEY APVD: J. ELBIN | 11OCT2013 11OCT2013 11OCT2013 | 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: 2150382 | RESTRICTED TO: L | SCALE: 1:1 SHEET: 2 of 4 REV: L |
| MATERIAL: | | WEIGHT: | Customer Accessible Production Drawing | SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION |

| PART NUMBER | REVISION | DESCRIPTION | FEED TYPE |
|-------------|----------|--------------------------|-----------|
| 2-2150382-2 | L | FINE CRIMP HEIGHT ADJUST | PNEUMATIC |
| 7-2150382-7 | J | CRIMP TOOLING KIT | - |

PACIFIC VERSION TERMINATOR
 INTERFACE ADAPTER



| APPLICATOR DATA | | |
|--------------------------------|----------------|------|
| CRIMP | SIZE | TYPE |
| WIRE | .110 [2.79 mm] | F |
| INSUL | .180 [4.57 mm] | F |
| APPL INSTRUCTIONS 408-35043 | | |

| TERMINAL DATA: TE TERMINAL | | TE CRIMP SPECIFICATION | |
|---|-------------|---|-------------|
| TERMINAL NAME: RECEPTACLE, FASTON, FLAG, LIF, .250 SERIES | | | |
| WIRE STRIP LENGTH .198-.213 IN [5.02-5.40 mm] | | INSULATION DIAMETER RANGE Ø.110-.160 IN [2.79-4.06 mm] | |
| TERMINAL APPLICATION SPECIFICATION 114-2079 | | | |
| TERMINALS APPLIED | | | |
| TE TERMINAL | TE TERMINAL | TE TERMINAL | TE TERMINAL |
| 63901-1 | 63010-3 | 63009-1 | 63096-1 |
| 63901-2 | 63012-1 | 63009-2 | 63096-2 |
| 63901-3 | 63012-2 | 63009-3 | |
| 63010-1 | | 63011-1 | |
| 63010-2 | | 63011-2 | |

| WIRE SIZE | CRIMP HEIGHT mm [INCH] | CRIMP HEIGHT REFERENCE SETTING |
|-----------|--------------------------------|--------------------------------|
| 14 AWG | 1.85 +/- 0.05 [0.073 +/- .002] | 3.6 |
| 16 AWG | 1.62 +/- 0.05 [0.064 +/- .002] | 6.1 |
| 18 AWG | 1.47 +/- 0.05 [0.058 +/- .002] | 7.7 |

- 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 IS NOT COMPATIBLE WITH MECHANICAL FEED.
 - 6 TERMINAL LUBRICANT IS RECOMMENDED.
 - 7 RIGHT HAND ORIENTED FLAG TERMINALS - WHEN RUNNING THESE TERMINALS, USE ITEM 1 WIRE CRIMPER WITH ITEM 14 BLOCK SUPPORT LOCATED UNDER THE TERMINAL FLAG.
 - 8 LEFT HAND ORIENTED FLAG TERMINALS - WHEN RUNNING THESE TERMINALS, USE ITEM 178 WIRE CRIMPER WITH ITEM 14 BLOCK SUPPORT FLIPPED OVER AND LOCATED UNDER THE TERMINAL FLAG.
9. 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)

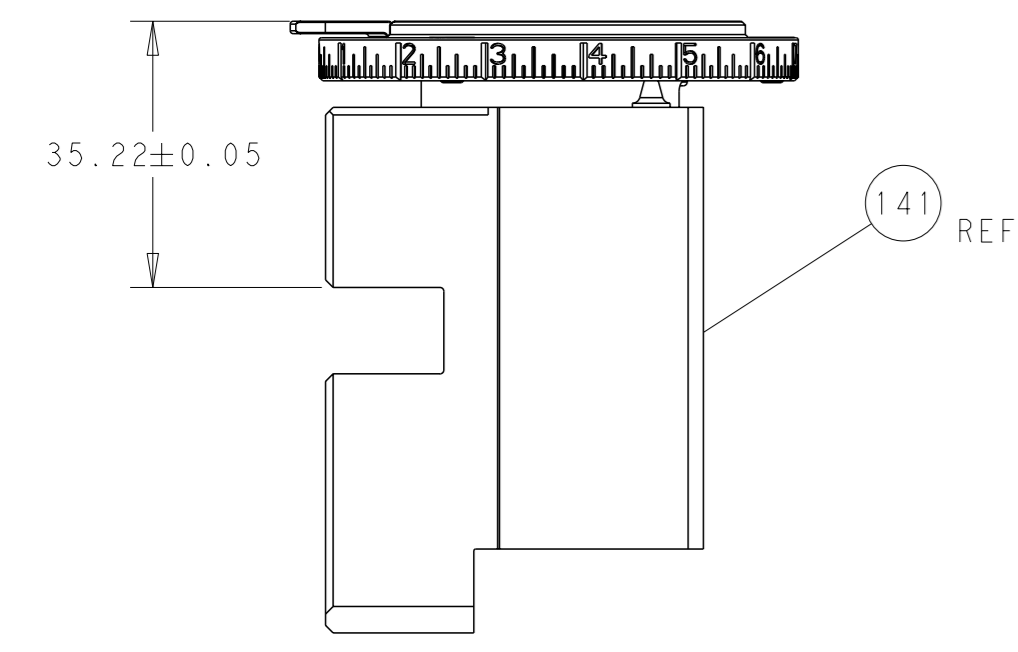
| LOC | DIST | REVISIONS | | | | | |
|-----|------|-----------|-----|-------------|------|-----|------|
| A | 66 | P | LYR | DESCRIPTION | DATE | OWN | APVD |
| | | - | | SEE SHEET 1 | | - | - |

| | | | | | |
|---|-----|-------------|-------------------------------------|----------------------------|-----|
| - | 1 | 2119082-9 | CAM, SNAIL, INSULATION ADJUSTMENT | 244 | |
| - | 1 | 2079764-1 | WASHER, WAVE SPRING, CREST-TO-CREST | 243 | |
| 3 | - | 1 | 2119083-1 | RETAINER, INSULATION DIAL | 242 |
| - | 1 | 2844940-3 | AIR FEED MODULE | 238 | |
| - | 1 | 1-18028-0 | WASHER, FLAT, REG M8 | 192 | |
| 1 | 1 | 2-1803224-2 | CRIMPER, WIRE | 178 | |
| - | 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 | |
| 6 | - | 1 | 2119955-2 | ASSY, LUBRICATOR, END FEED | 84 |
| - | 1 | 455888-7 | SPACER, CRIMPER | 82 | |
| - | 2 | 1-2168083-1 | SCR, SKT HD CAP, RoHS, M3 X 6 | 73 | |
| - | 1 | 464452-2 | DRAG, STOCK | 72 | |
| - | 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 | 5-18022-5 | SCR, HEX HD CAP, M4 X 6.0 | 59 | |
| - | 4 | 2168400-1 | SHCS, LOW HEAD, RoHS, M4 X 12 | 57 | |
| - | 2 | 2168083-2 | SCR, SKT HD CAP, RoHS, M4 X 8.0 | 56 | |
| - | 2 | 5018030-1 | NUT, HEX, REG, RoHS, M3 | 54 | |
| - | 2 | 986965-8 | NUT, LOCK, HEX, TORQUE (M4) | 53 | |
| - | 1 | 1-2063961-4 | 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 | |
| - | 8 | 1-18028-2 | WASHER, FLAT, REG M4 | 33 | |
| - | 2 | 1-2168083-2 | SCR, SKT HD CAP, RoHS, M4 X 25 | 31 | |
| - | 2 | 2168083-2 | SCR, SKT HD CAP, RoHS, M4 X 8.0 | 29 | |
| - | 1 | 468281-1 | STRIPPER | 27 | |
| - | 2 | 1-2168083-6 | SCR, SKT HD CAP, RoHS, M4 X 35 | 25 | |
| - | 1 | 2161922-4 | PLATE, STRIP GUIDE | 24 | |
| - | 2 | 22281-6 | SPRING, COMPRESSION | 22 | |
| - | 1 | 1633168-2 | ARM, STOCK DRAG | 21 | |
| - | 1 | 3-1901696-2 | STRIP GUIDE, REAR | 19 | |
| - | 1 | 3-1901695-2 | STRIP GUIDE, FRONT | 18 | |
| - | 4 | 1-2079383-1 | SCR, BHSC, RoHS (M6 X 12) | 17 | |
| 7 | 8 | - | - | 14 | |
| 1 | - | 1 | 469633-1 | BLOCK, SUPPORT | 14 |
| 1 | - | 1 | 461160-1 | PLATE, REAR SHEAR | 11 |
| - | 2 | 5-240645-2 | SPACER, SHEAR PLATE | 10 | |
| 1 | - | 1 | 455961-3 | PLATE, FRONT SHEAR | 9 |
| 1 | 1 | 3-1803000-6 | ANVIL, COMBINATION, END FEED | 8 | |
| 1 | - | 1 | 1-469634-7 | BLADE, SLUG | 7 |
| - | - | - | - | 6 | |
| - | 1 | 4-240641-8 | SPACER | 5 | |
| - | 1 | 238011-2 | BLOCK, CRIMPER SPACER | 4 | |
| 1 | 1 | 1803229-1 | CRIMPER, INSULATION O PREMIUM | 3 | |
| - | 1 | 2-455888-0 | SPACER, CRIMPER | 2 | |
| 7 | 1 | 1-1803224-8 | CRIMPER, WIRE | 1 | |

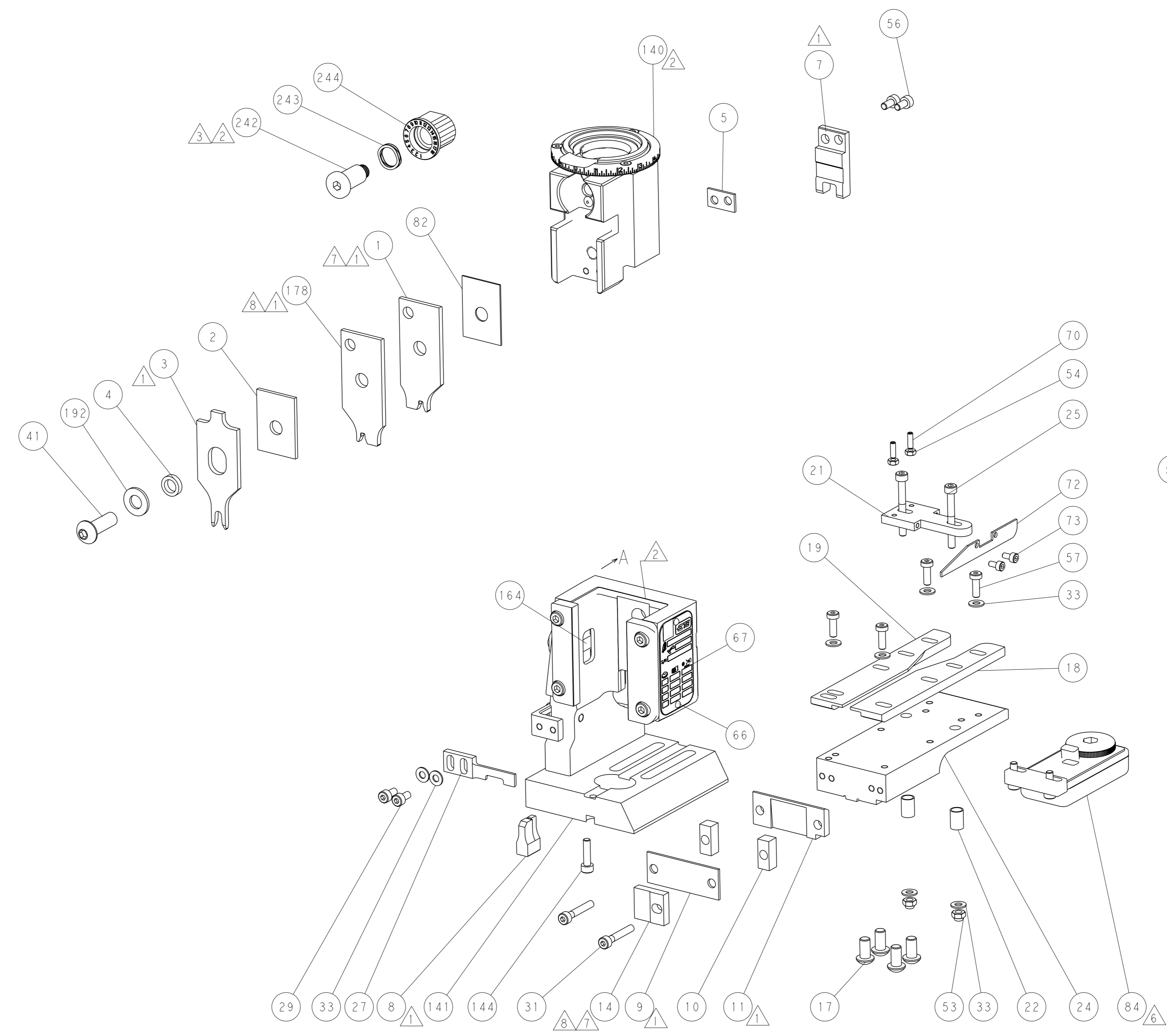
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|-------------|---------------|--|---------|-----------|---------|
| mm | 0 PLC ± | 1 PLC ± | 2 PLC ± | 3 PLC ± | 4 PLC ± |
| | ANGLES FINISH | | | | |

| | | |
|--|---------------------------|--------------|
| OWN | R. STAKEM | 11OCT2013 |
| CHK | G. BAILEY | 11OCT2013 |
| APVD | J. ELBIN | 11OCT2013 |
| NAME | Ocean End Feed Applicator | |
| SIZE | CAGE CODE | DRAWING NO |
| A1 | 00779 | 2150382 |
| Customer Accessible Production Drawing | | |
| SCALE | 1:1 | SHEET 3 of 4 |
| REV | | |

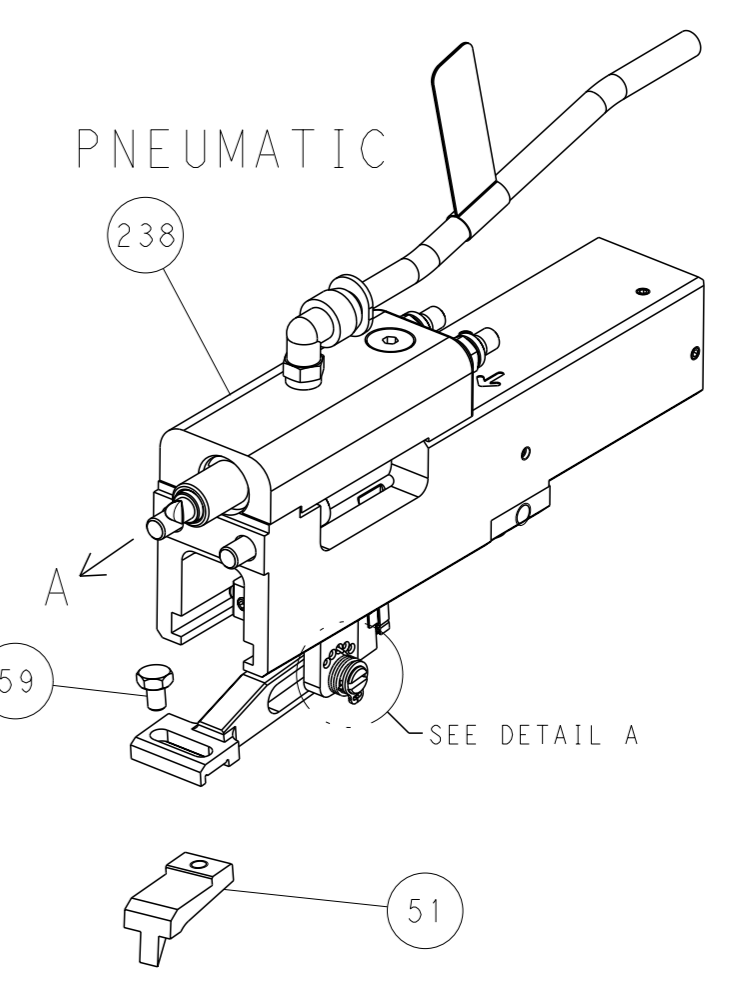
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| A | 66 | P | LYR | DESCRIPTION | DATE | OWN | APVD |
| | | - | | SEE SHEET 1 | | | |
| | | | | | | | |
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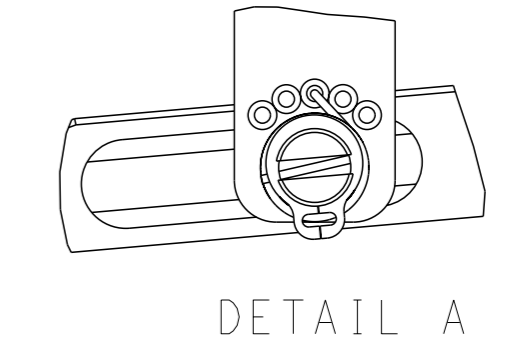
RAM SET-UP



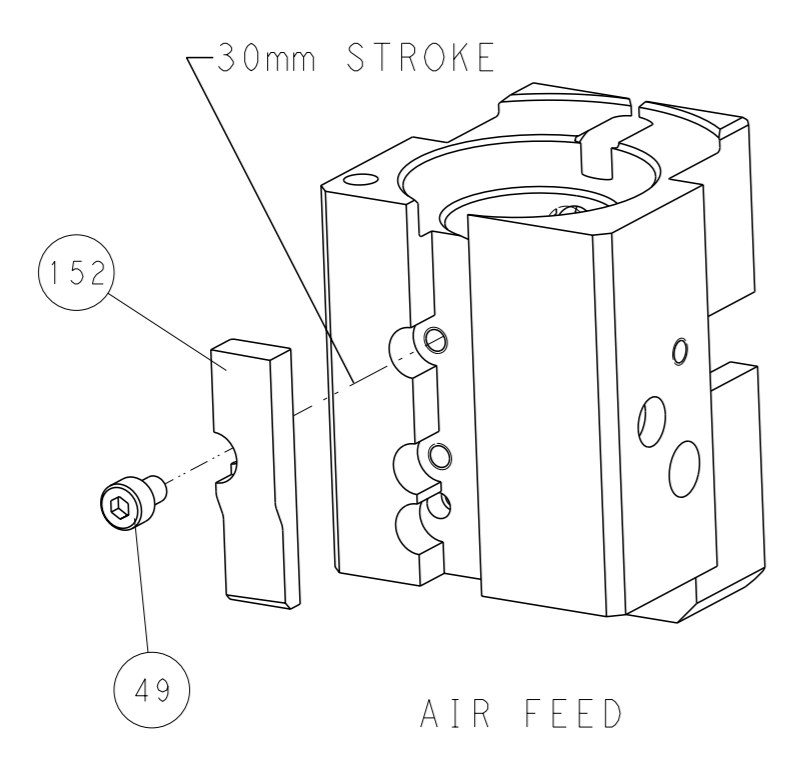
FEED TYPE



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 A CONTROLLED DOCUMENT FROM TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE AND FOR CONTROL AND ENGINEERING DISCRETION SHOULD BE CONTACTED FOR THE LATEST REVISION.</small> | | DWN: K. STAKEM 11OCT2013 CHK: G. BAILEY 11OCT2013 APVD: J. ELBIN 11OCT2013 | 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: 2150382 SCALE: 1:1 SHEET: 4 of 4 REV: L | RESTRICTED TO: |
| MATERIAL: | | WEIGHT: | Customer Accessible Production Drawing |