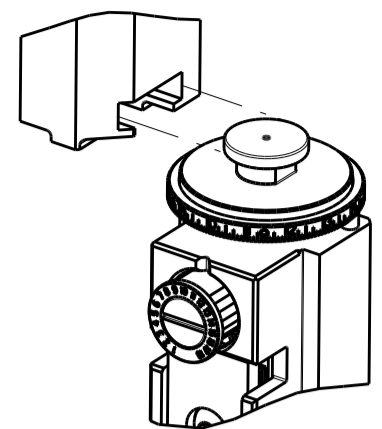


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150415-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2150415-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150415-1	C	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2150415-2	C	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150415-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA

CRIMP	SIZE	TYPE
WIRE	1.40 mm [.055]	F
INSUL	2.29 mm [.090]	F

APPLICATOR INSTRUCTIONS  
408-35043

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION

TERMINAL NAME: RECEPTACLE, FASTIN-FASTON, .110 SERIES

WIRE STRIP LENGTH: 3.60-4.40 mm [.142-.173 IN] INSULATION DIAMETER RANGE: Ø1.27-2.03 mm [.050-.080 IN]

TERMINAL APPLICATION SPECIFICATION: 114-2065

TERMINALS APPLIED

TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
1217281-2	1217281-3		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
20 AWG	1.02 +/- 0.05 [.040 +/- .002]	8.0
22 AWG	0.91 +/- 0.05 [.036 +/- .002]	9.1
24 AWG	0.84 +/- 0.05 [.033 +/- .002]	9.8

- 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 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.
- 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.

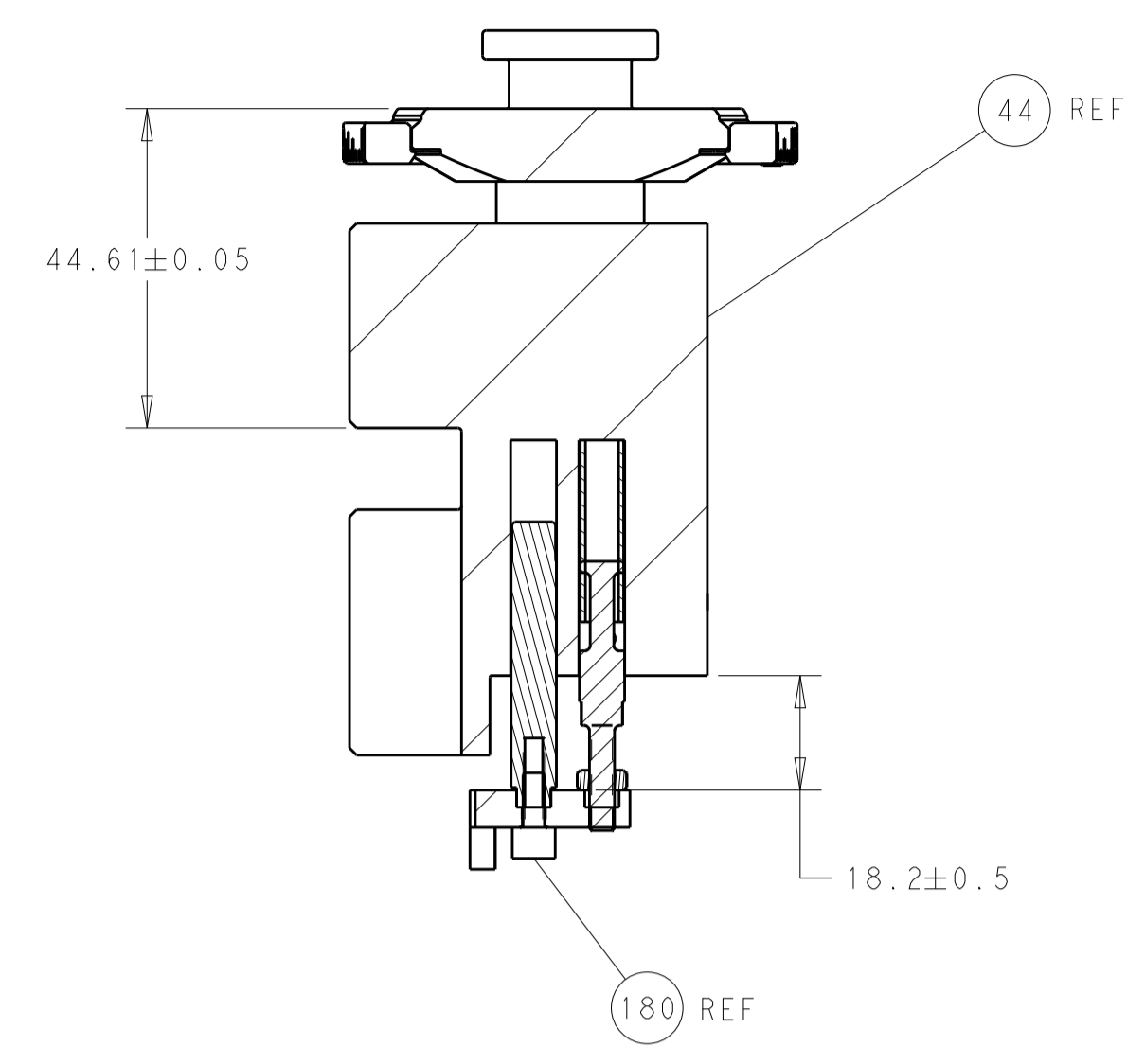
ATLANTIC VERSION  
 Shown on sheets 1 of 4 & 2 of 4  
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

LOC	DIST	REV	LTN	DESCRIPTION	DATE	DWN	APVD
A	66						
		A		RELEASED	18APR2014	KH	UG
		B		ECR-18-001525	31JAN2018	MZ	KZ
		C		ECR-18-015962	09OCT2018	MZ	KZ

-	1	-	1	-	2119640-1	PUSH ROD, AIR FEED	250	
-	1	-	1	-	1803259-1	BUSHING, FLANGED	249	
-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248	
-	1	1	1	1	2119082-8	CAM, SNAIL, INSULATION ADJUSTMENT	244	
-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243	
-	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242	
-	-	1	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239	
-	1	-	1	-	2063440-1	AIR FEED MODULE	238	
-	1	1	1	1	1-18028-0	WASHER, FLAT, REG M8	192	
-	1	1	1	1	1752354-2	STANDOFF, HOLD-DOWN	180	
-	1	1	1	1	6-993111-6	PIN, SLOTTED SPRING 3.0 X 14.0	177	
-	1	1	1	1	8-22280-7	SPRING, COMPRESSION	176	
-	1	1	1	1	1752353-2	GUIDE PIN, HOLDDOWN	175	
-	1	1	1	1	1901680-2	GUIDE PIN, HOLDDOWN	174	
-	2	-	2	-	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172	
-	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164	
-	1	-	1	-	240638-1	SPRING, FEED FINGER	163	
-	1	-	1	-	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854	137	
-	1	1	1	1	455888-5	SPACER, CRIMPER	82	
-	1	1	1	1	1803607-2	DOCUMENTATION PACKAGE	71	
-	2	2	2	2	2-18032-2	SCR, SET, FLT PNT, M3 X 10.0	70	
-	1	1	1	1	2119740-1	TAG, IDENTIFICATION	67	
-	2	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66	
-	1	1	1	1	1-1901681-3	HOLDDOWN, TERMINAL	65	
-	2	2	2	2	2168400-8	SHCS, LOW HEAD, RoHS, M4 X 16	64	
-	1	1	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	
-	-	1	-	1	2063961-1	FEED FINGER	58	
-	3	3	3	3	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57	
-	2	2	2	2	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	56	
-	2	2	2	2	5018030-1	NUT, HEX, REG, RoHS, M3	54	
-	2	2	2	2	986965-8	NUT, LOCK, HEX, TORQUE (M4)	53	
-	1	1	1	1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52	
-	1	-	1	-	2119792-2	PAWL, EF, AIR	51	
-	1	2	1	2	18023-9	SCR, SKT HD CAP M4 X 6.0	49	
-	-	1	-	1	2119652-1	FEED CAM, PRE FEED	48	
-	-	1	-	1	2119653-1	FEED CAM, POST FEED	47	
-	1	1	1	1	2119655-5	APPLICATOR BASIC ASSEMBLY, EF	46	
-	1	1	1	1	1803517-1	RAM ASSEMBLY, EF ATLANTIC	44	
-	1	1	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41	
-	7	7	7	7	1-18028-2	WASHER, FLAT, REG M4	33	
-	2	2	2	2	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	31	
-	2	2	2	2	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	29	
-	1	1	1	1	240639-4	STRIPPER (MACHINING)	27	
-	2	2	2	2	1-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 30	25	
-	1	1	1	1	1752371-9	PLATE, STRIP GUIDE	24	
-	1	1	1	1	240825-9	PLATE, STRIP HOLD DOWN	23	
-	2	2	2	2	2-22281-3	SPRING, COMPRESSION	22	
-	1	1	1	1	1803292-4	DRAG	20	
-	2	2	2	2	1901259-3	GUIDE, LOWER STRIP	18	
-	4	4	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17	
-	1	1	1	1	240644-1	PLATE, REAR SHEAR	11	
-	-	-	-	-	-	-	10	
-	1	1	1	1	690482-5	PLATE, FRONT SHEAR	9	
-	1	2	2	1	1803059-8	ANVIL, COMBINATION, END FEED	8	
-	1	1	1	1	2217206-7	BLADE, SLUG	7	
-	-	-	-	-	-	-	6	
-	1	1	1	1	240641-7	SPACER	5	
-	1	1	1	1	2-238011-2	BLOCK, CRIMPER SPACER	4	
-	1	2	2	1	1-2119582-1	CRIMPER, INSULATION F PREMIUM	3	
-	1	1	1	1	455888-7	SPACER, CRIMPER	2	
-	1	2	2	1	1-456402-7	CRIMPER, WIRE PREMIUM	1	
-	77	72	71	2	-1	PART NO	DESCRIPTION	ITEM NO

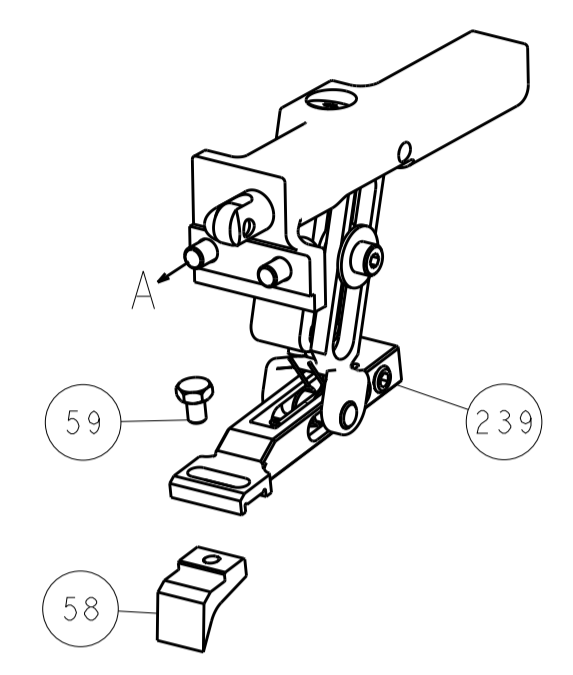
DIMENSIONS: mm 	TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH	DWN: H. HUANG 27MAR2014 CHK: L. ZHANG 27MAR2014 APVD: H. GUO 27MAR2014	NAME: Ocean End Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2150415 SCALE: 1:1 SHEET: 1 of 4 REV: C
MATERIAL: -		Customer Accessible Production Drawing	

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

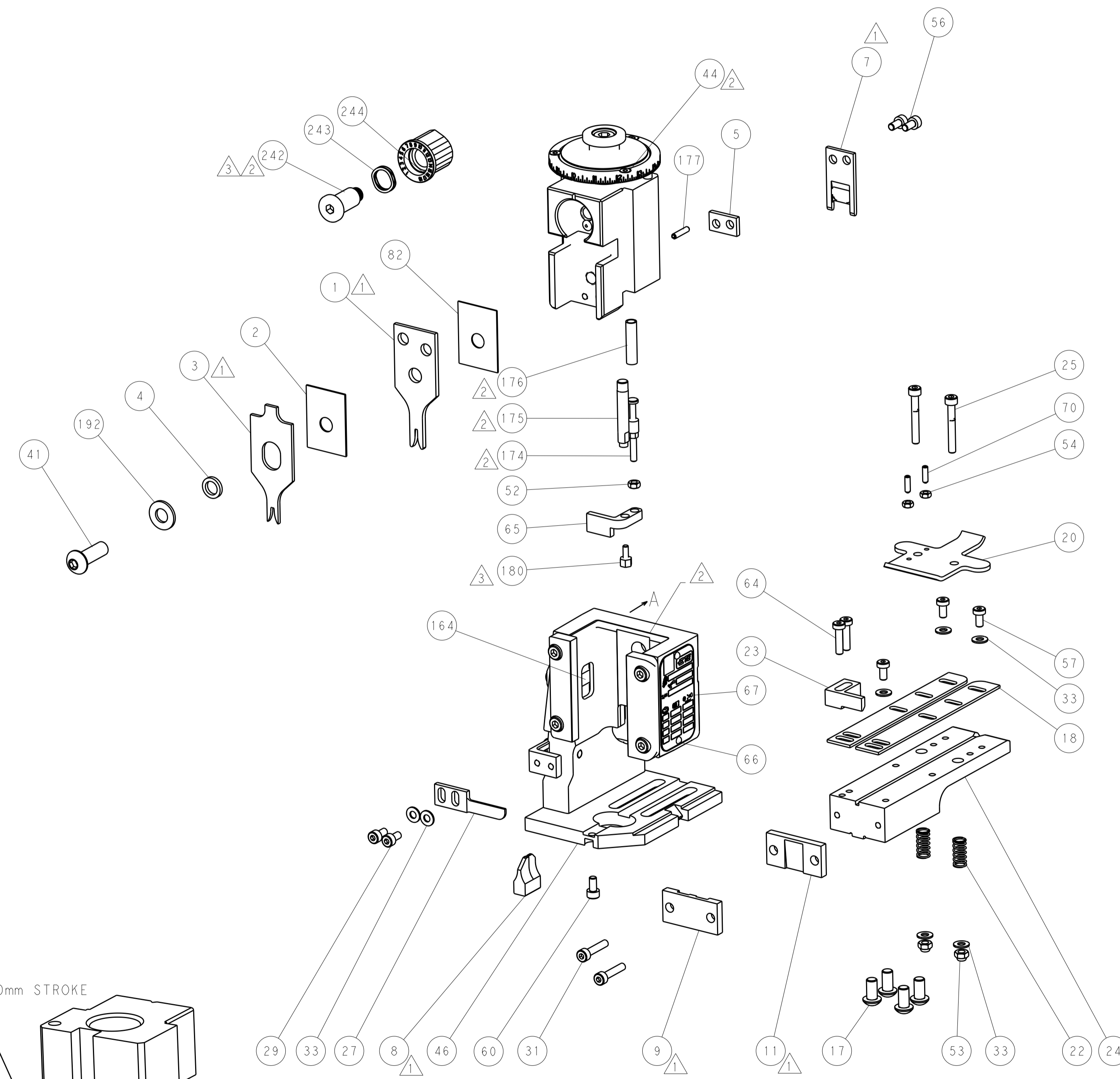
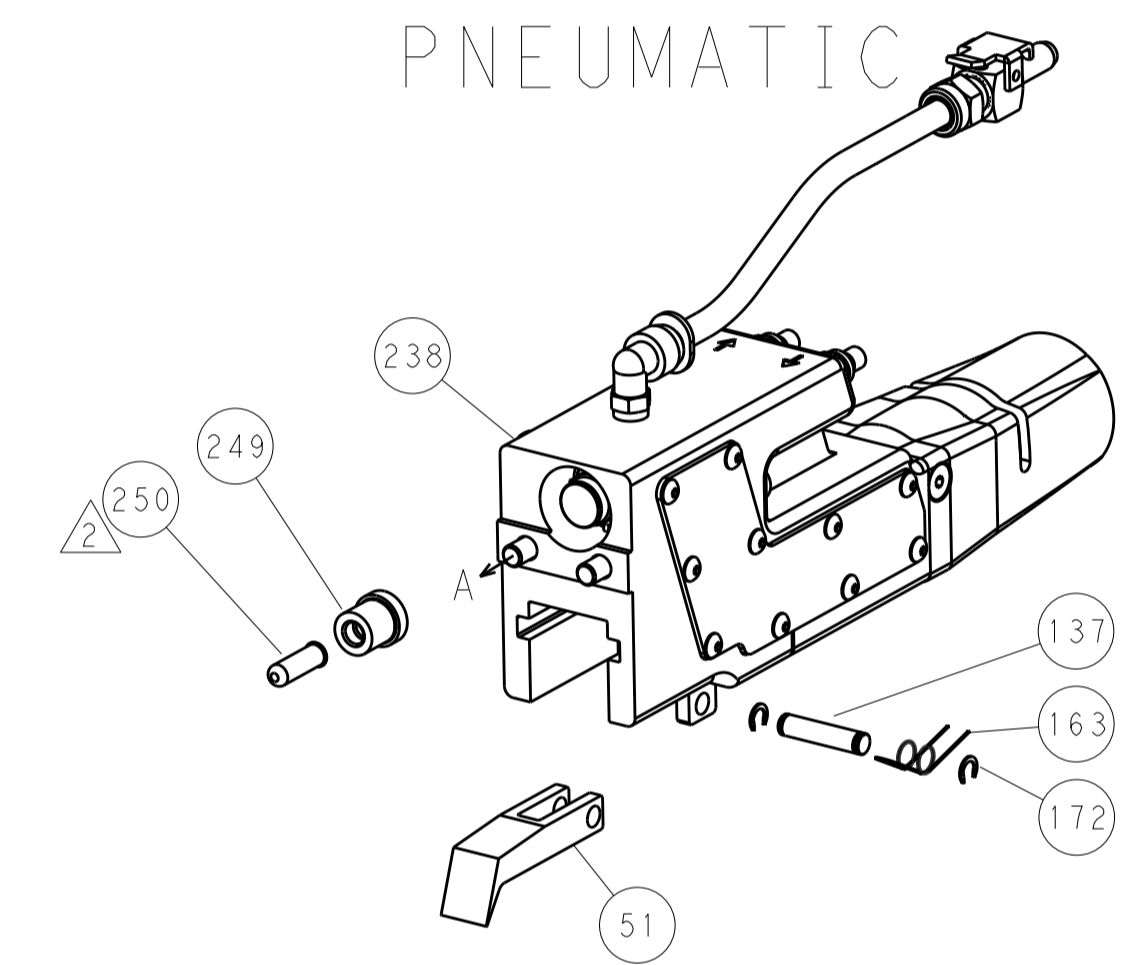


RAM AND HOLDDOWN SET-UP

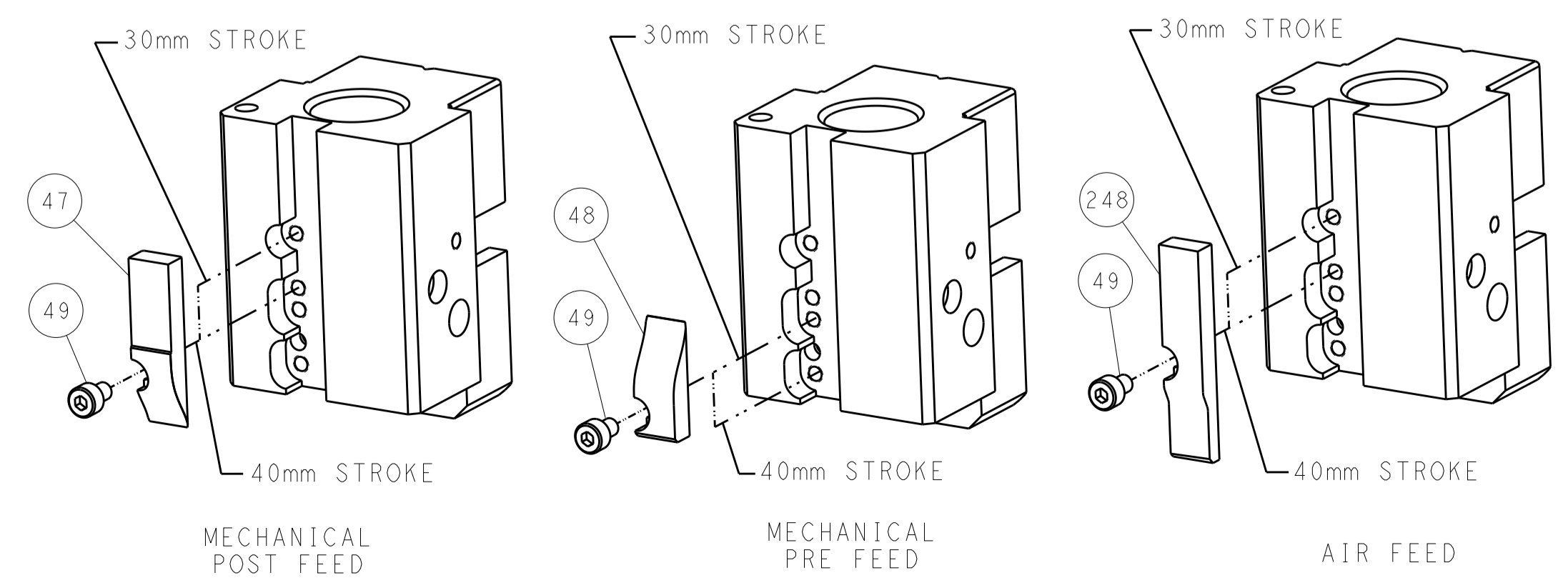
FEED TYPE  
MECHANICAL



PNEUMATIC



CAM POSITIONS

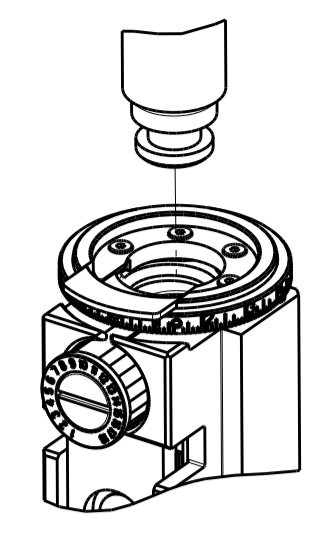


ATLANTIC VERSION  
 Shown on sheets 1 of 4 & 2 of 4  
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		OWN: K. HUANG 27MAR2014		TE Connectivity	
mm		0 PLC ±		CHK: L. ZHANG 27MAR2014		Harrisburg, PA 17105-3608	
Ø		1 PLC ±		APVD: H. GUO 27MAR2014		NAME: Ocean End Feed Applicator	
H		2 PLC ±		PRODUCT SPEC		SIZE: CAGE CODE DRAWING NO	
D		3 PLC ±		APPLICATION SPEC		RESTRICTED TO	
R		4 PLC ±		WEIGHT		A1 00779 ©=2150415	
ANGLES		FINISH		Customer Accessible Production Drawing		SCALE: 1:1 SHEET 2 OF 4 REV C	

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150415-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2150415-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150415-7	A	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

APPLICATOR INSTRUCTIONS  
 408-35043

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION

TERMINAL NAME: RECEPTACLE, FASTIN-FASTON, .110 SERIES

WIRE STRIP LENGTH	INSULATION DIAMETER RANGE
3.60-4.40 mm (.142-.173 IN)	1.27-2.03 mm (.050-.080 IN)

TERMINAL APPLICATION SPECIFICATION 114-2065

TERMINALS APPLIED

TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
1217281-2	1217281-3		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
20 AWG	1.02 +/- 0.05 [.040 +/- .002]	8.0
22 AWG	0.91 +/- 0.05 [.036 +/- .002]	9.1
24 AWG	0.84 +/- 0.05 [.033 +/- .002]	9.8

- 1 RECOMMENDED SPARE PARTS
- 2 REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- 3 APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 180. 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. 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.

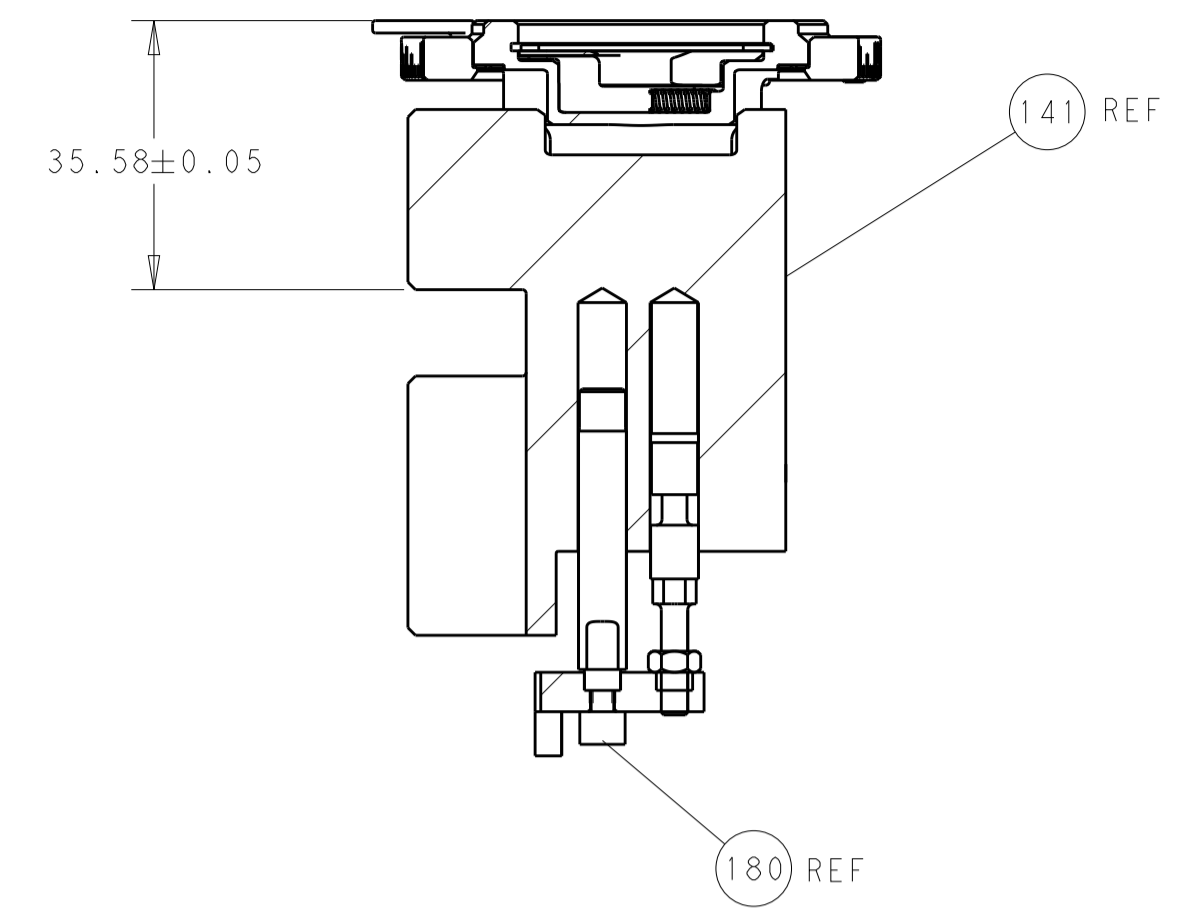
LOC	DIST	REV	DATE	BY	APPV
A	66				

REV	DATE	BY	APPV	DESCRIPTION	QTY
-	-	-	-	SEE SHEET 1	-
-	1	1		2119640-1 PUSH ROD, AIR FEED	250
-	1	1		1803259-1 BUSHING, FLANGED	249
-	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	-		2063440-1 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		1752354-2 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
-	2	2		21045-3 RING, RETAIN, EXTERN, 3/16 CRESCENT	172
-	REF REF			994970-2 COUNTER, MAGNETIC	164
-	1	1		240638-1 SPRING, FEED FINGER	163
-	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		3-23627-7 PIN, RETAIN, GRVD, 3/16 X .854	137
-	1	1		455888-5 SPACER, CRIMPER	82
-	1	1		1803607-2 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		1-1901681-3 HOLDDOWN, TERMINAL	65
-	2	2		2168400-8 SHCS, LOW HEAD, RoHS, M4 X 16	64
-	1	1		5-18022-5 SCR, HEX HD CAP, M4 X 6.0	59
-	-	1		2063961-1 FEED FINGER	58
-	3	3		2168400-4 SHCS, LOW HEAD, RoHS, M4 X 8	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		1-5018030-0 NUT, HEX, REG, RoHS, M3.5	52
-	1	-		2119792-2 PAWL, EF, AIR	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		240639-4 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		240825-9 PLATE, STRIP HOLD DOWN	23
-	2	2		2-22281-3 SPRING, COMPRESSION	22
-	1	1		1803292-4 DRAG	20
-	2	2		1901259-3 GUIDE, LOWER STRIP	18
-	1	1		240644-1 PLATE, REAR SHEAR	11
-	-	-		-	10
-	1	1		690482-5 PLATE, FRONT SHEAR	9
1	1	1		1803059-8 ANVIL, COMBINATION, END FEED	8
-	1	1		2217206-7 BLADE, SLUG	7
-	-	-		-	6
-	1	1		240641-7 SPACER	5
-	1	1		2-238011-2 BLOCK, CRIMPER SPACER	4
1	1	1		1-2119582-1 CRIMPER, INSULATION F PREMIUM	3
-	1	1		455888-7 SPACER, CRIMPER	2
1	1	1		1-456402-7 CRIMPER, WIRE PREMIUM	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)

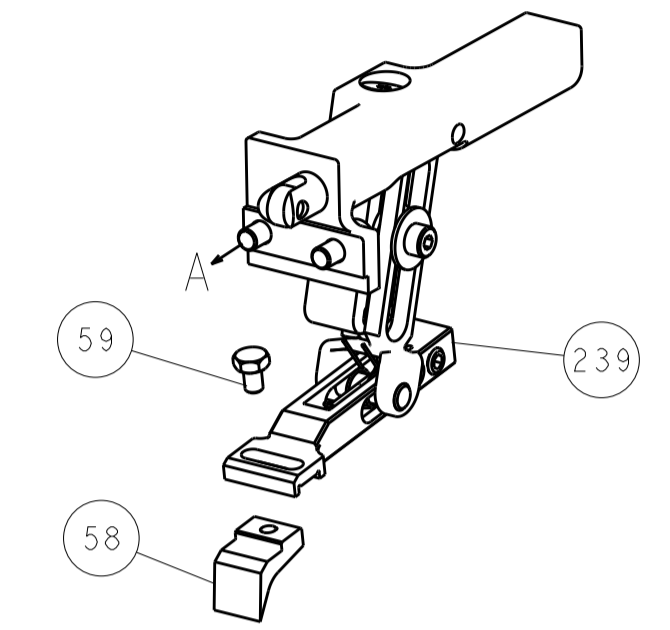
DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH		DWN H. HUANG 27MAR2014 CHK L. ZHANG 27MAR2014 APVD J. GUO 27MAR2014		TE Connectivity Harrisburg, PA 17105-3608	
MATERIAL:		FINISH:		PRODUCT SPEC:		NAME: Ocean End Feed Applicator	
WEIGHT:		CAGE CODE: A100779		DRAWING NO: C=2150415		RESTRICTED TO:	
Customer Accessible Production Drawing				SCALE: 1:1		SHEET 3 OF 4	

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

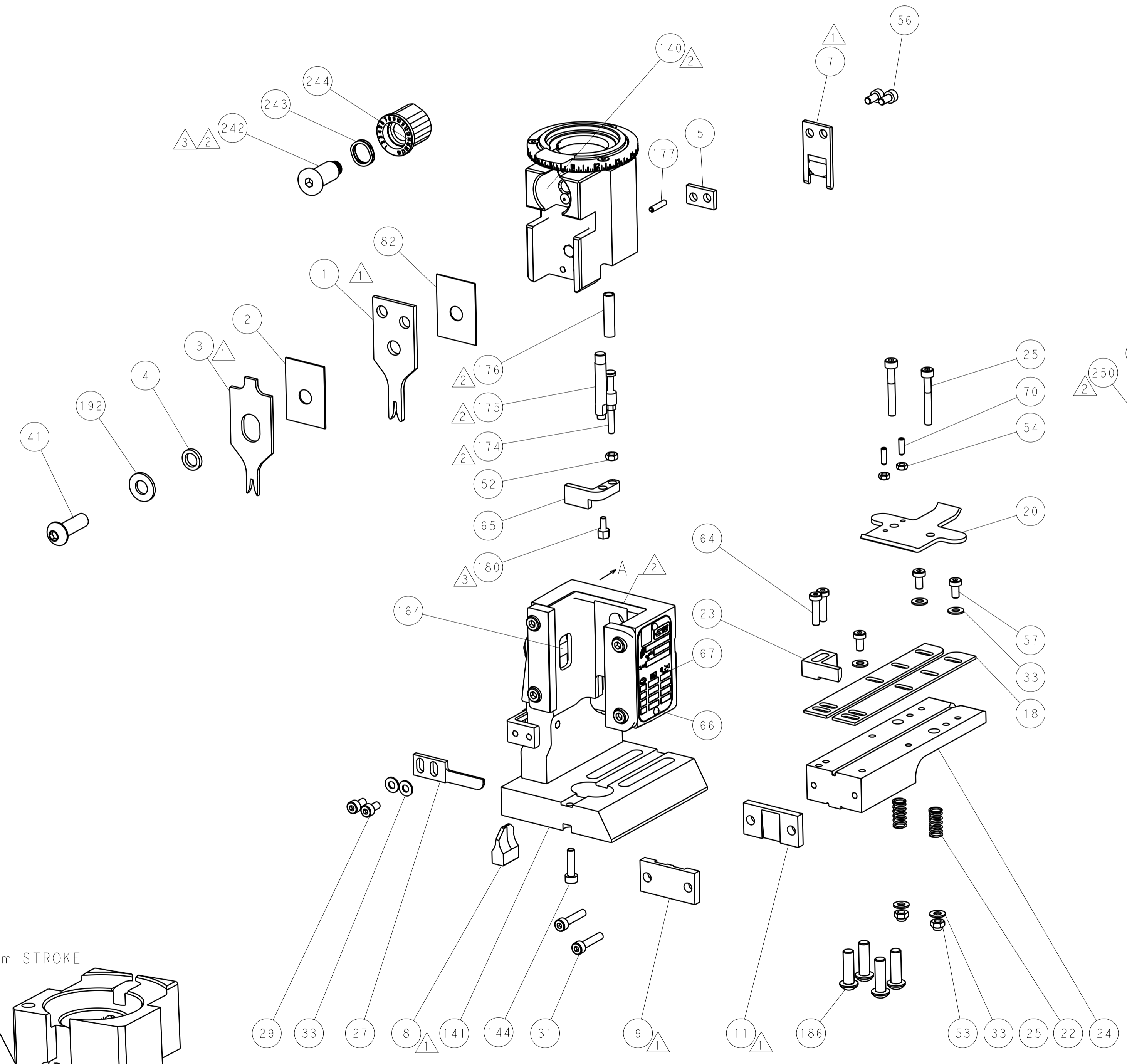
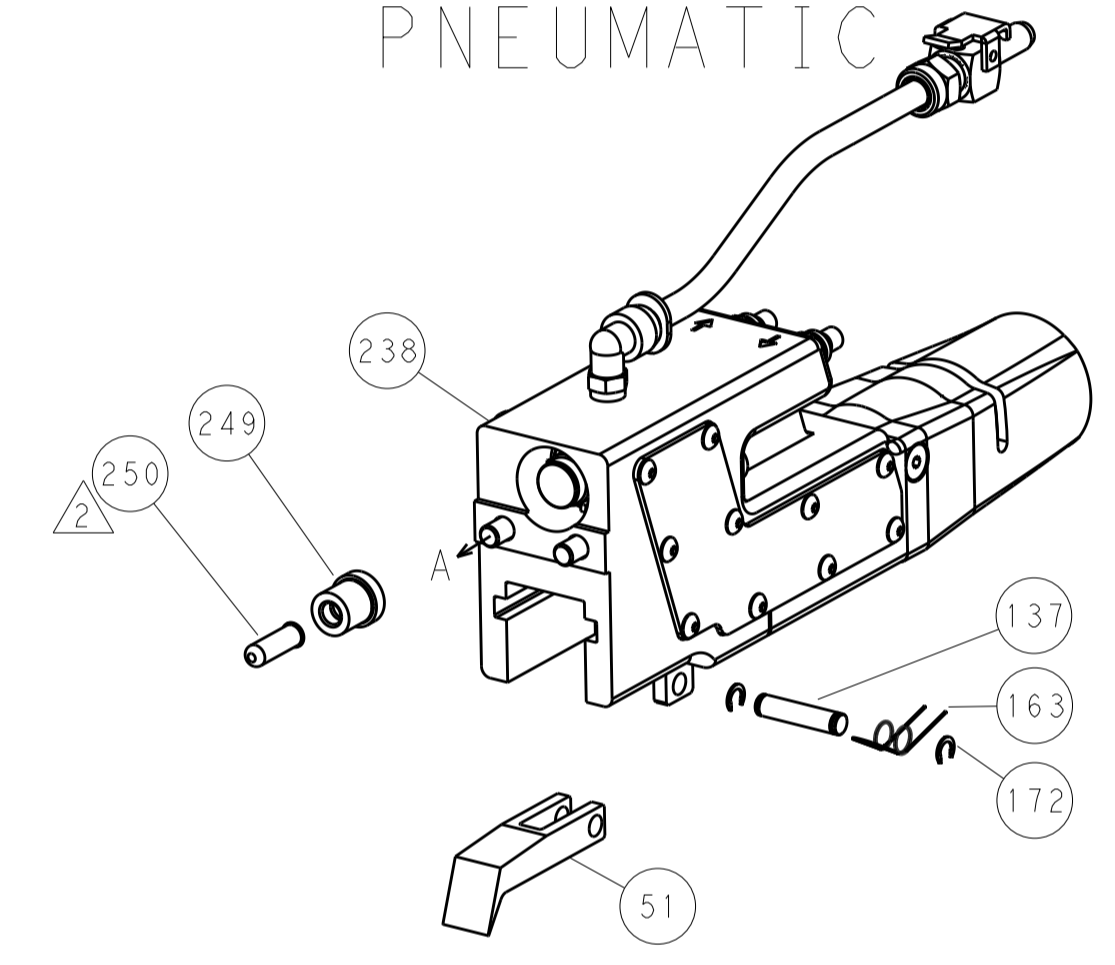


RAM AND HOLDDOWN SET-UP

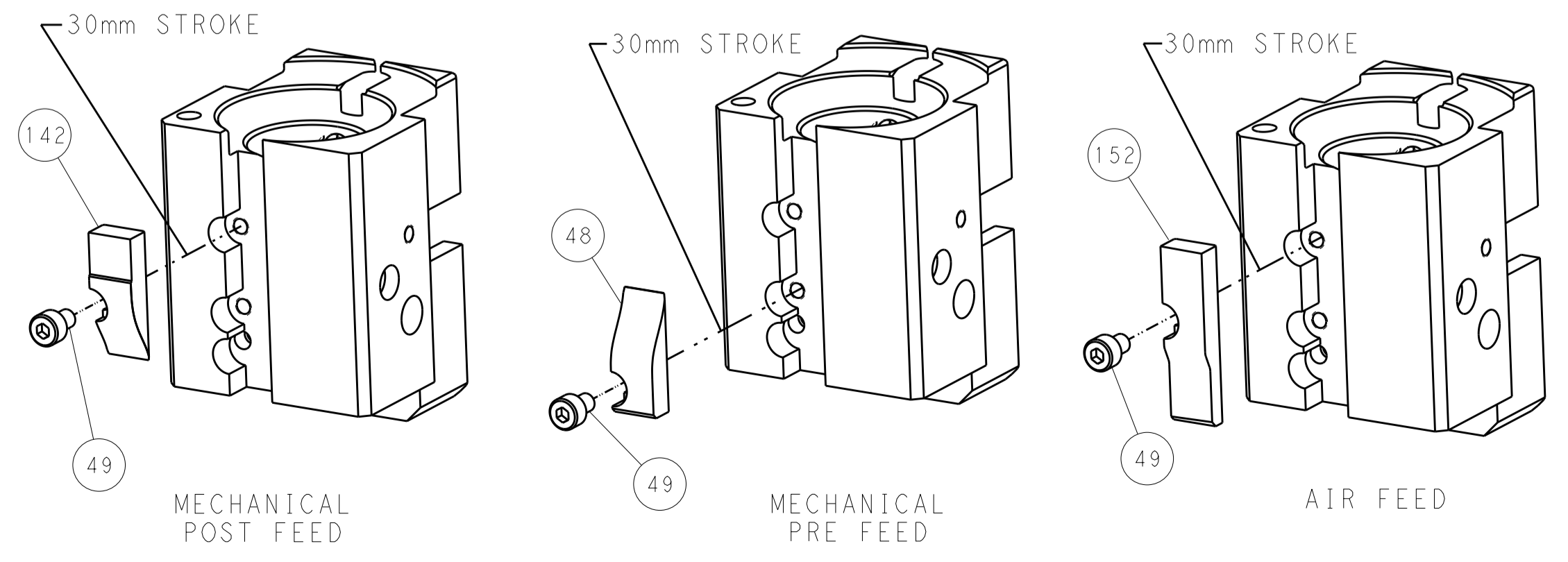
FEED TYPE  
MECHANICAL



PNEUMATIC



CAM POSITIONS



**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: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH		DWN K. HUANG 27MAR2014 CHK L. ZHANG 27MAR2014 APVD JJ. GUO 27MAR2014 PRODUCT SPEC APPLICATION SPEC WEIGHT Customer Accessible Production Drawing		NAME Ocean End Feed Applicator SIZE CAGE CODE DRAWING NO A1 00779 C=2150415 SCALE 1:1 SHEET 4 OF 4 REV C		RESTRICTED TO TE Connectivity Harrisburg, PA 17105-3608	
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