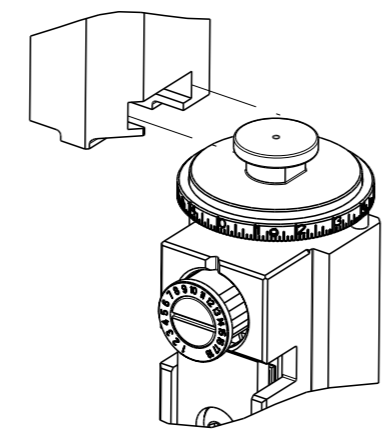


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150631-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2150631-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150631-1	B	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2150631-2	B	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150631-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.54 mm [.100]	F
INSUL	-	-
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION			
TERMINAL NAME: TERMINAL, RING			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
3.66-4.26 mm [.144-.168 IN]		Ø	
TERMINAL APPLICATION SPECIFICATION	114-2084	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
40749	40810	40812	63243-1
40811	40811-1		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
16 AWG	1.75+/-0.05 [1.069+/-0.002]	5.3
18 AWG	1.57+/-0.05 [1.062+/-0.002]	7.1
20 AWG	1.47+/-0.05 [1.058+/-0.002]	8.1

- 1 RECOMMENDED SPARE PARTS
- 2 REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- 3 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.
- 4. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- 5 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.

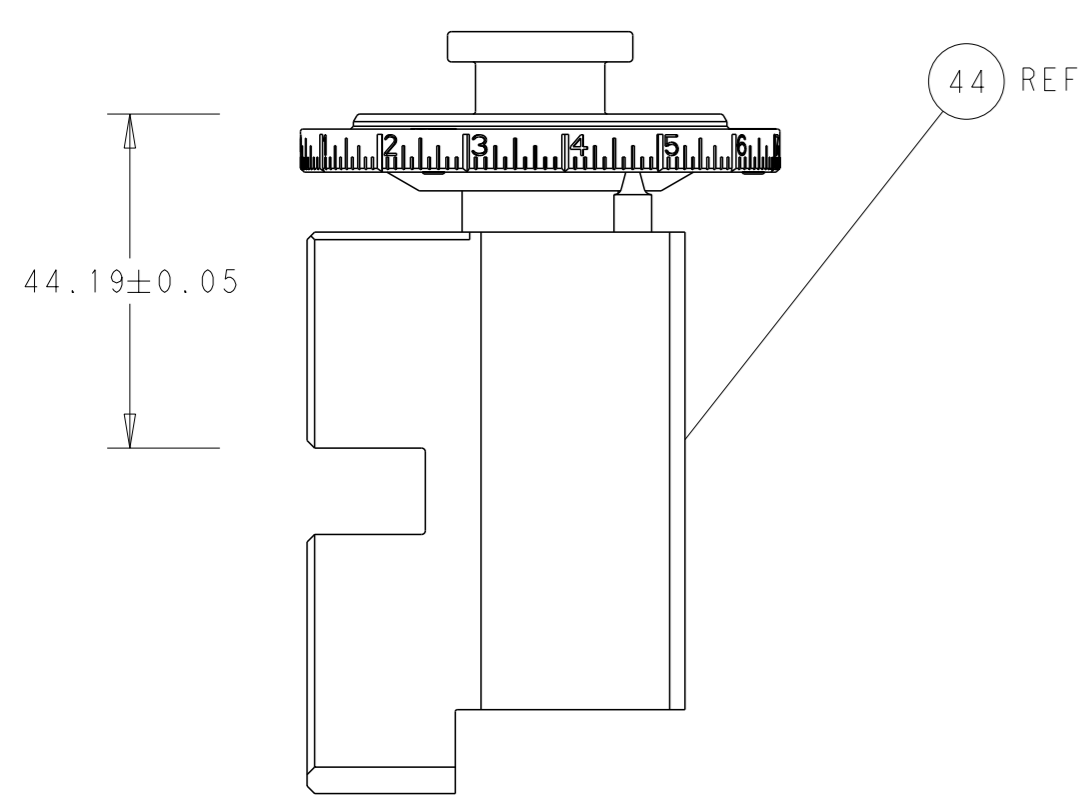
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		B		ECR-20-014685	150C12020	JAH	RK

-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248	
-	-	1	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239	
-	1	-	1	-	2844940-3	AIR FEED MODULE	238	
-	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164	
-	1	1	1	1	2119955-2	ASSY, LUBRICATOR, END FEED	84	
-	1	1	1	1	455888-4	SPACER, CRIMPER	82	
-	1	1	1	1	1803607-4	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	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	60	
-	1	1	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59	
-	-	1	-	1	2063961-1	FEED FINGER	58	
-	4	4	4	4	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57	
-	2	2	2	2	1-2168083-4	SCR, SKT HD CAP, RoHS, M4 X 5	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	-	2063961-1	FEED FINGER	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	1803602-3	SCR, BHSC, RoHS (M8 X 12)	41	
-	8	8	8	8	1-18028-2	WASHER, FLAT, REG M4	33	
-	2	2	2	2	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	31	
-	2	2	2	2	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	29	
-	1	1	1	1	240639-1	STRIPPER (MACHINING)	27	
-	2	2	2	2	1-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 30	25	
-	1	1	1	1	1752371-2	PLATE, STRIP GUIDE	24	
-	2	2	2	2	2-22281-3	SPRING, COMPRESSION	22	
-	1	1	1	1	1803292-4	DRAG	20	
-	1	1	1	1	1901696-3	STRIP GUIDE, REAR	19	
-	1	1	1	1	1901695-3	STRIP GUIDE, FRONT	18	
-	4	4	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17	
-	1	1	1	1	691901-2	REAR SHEAR PLATE, REVERSIBLE	11	
-	2	2	2	2	1-240645-6	SPACER, SHEAR PLATE	10	
-	1	1	1	1	240642-1	PLATE, FRONT SHEAR	9	
-	1	2	2	1	1-1803002-8	ANVIL, COMBINATION, END FEED	8	
-	1	1	1	1	2-691157-6	BLADE, SHEAR	7	
-	-	-	-	-	-	-	6	
-	1	1	1	1	5-240641-8	SPACER	5	
-	-	-	-	-	-	-	4	
-	-	-	-	-	-	-	3	
-	-	-	-	-	-	-	2	
-	1	2	2	1	1	456407-3	CRIMPER, WIRE PREMIUM	1
-	77-72-71	-	2	-	1	PART NO	DESCRIPTION	ITEM NO

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

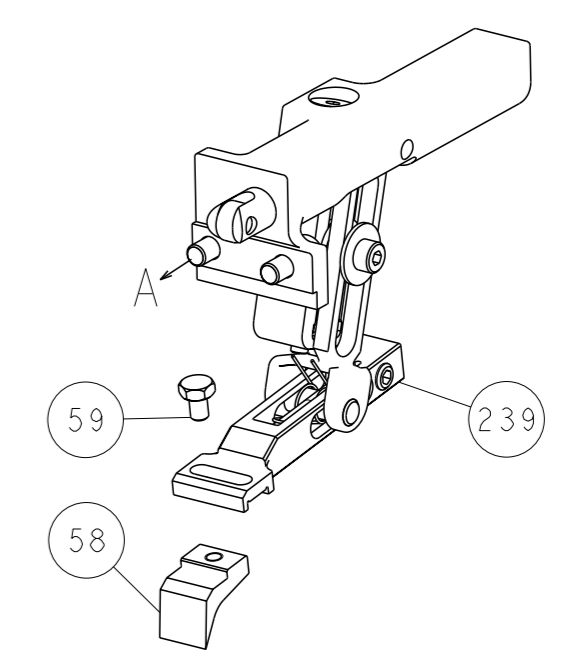
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		OWN: H. HUANG 29OCT2015		TE Connectivity	
mm		0 PLC ±		CHK: L. ZHANG 29OCT2015		Harrisburg, PA 17105-3608	
		1 PLC ±		APVD: J. GUO 29OCT2015		NAME: Ocean End Feed Applicator	
		2 PLC ±		PRODUCT SPEC		SIZE: A   00779   C=2150631	
		3 PLC ±		APPLICATION SPEC		SCALE: 1:1 SHEET 1 OF 4 REV B	
		4 PLC ±		WEIGHT		RESTRICTED TO	
		ANGLES FINISH		MATERIAL		Customer Accessible Production Drawing	

LOC		DIST		REVISONS			
A	66	P	LY#	DESCRIPTION	DATE	OWN	APVD
		-		SEE SHEET 1			

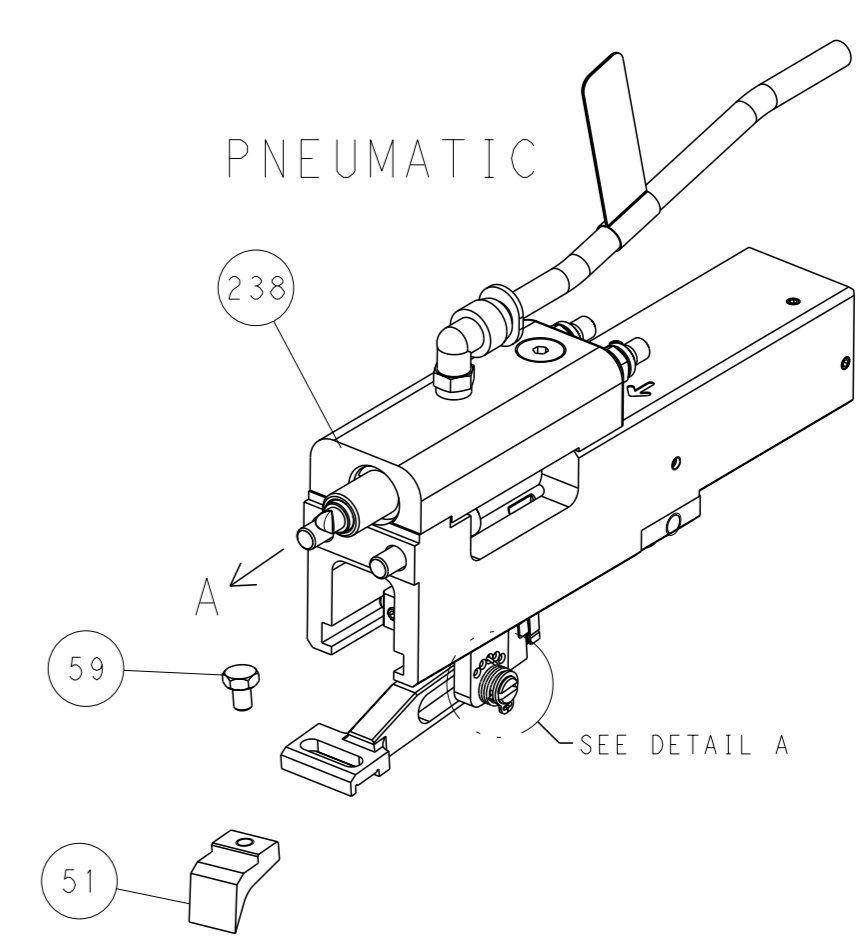


RAM SET-UP

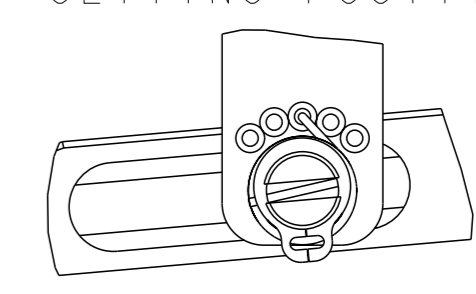
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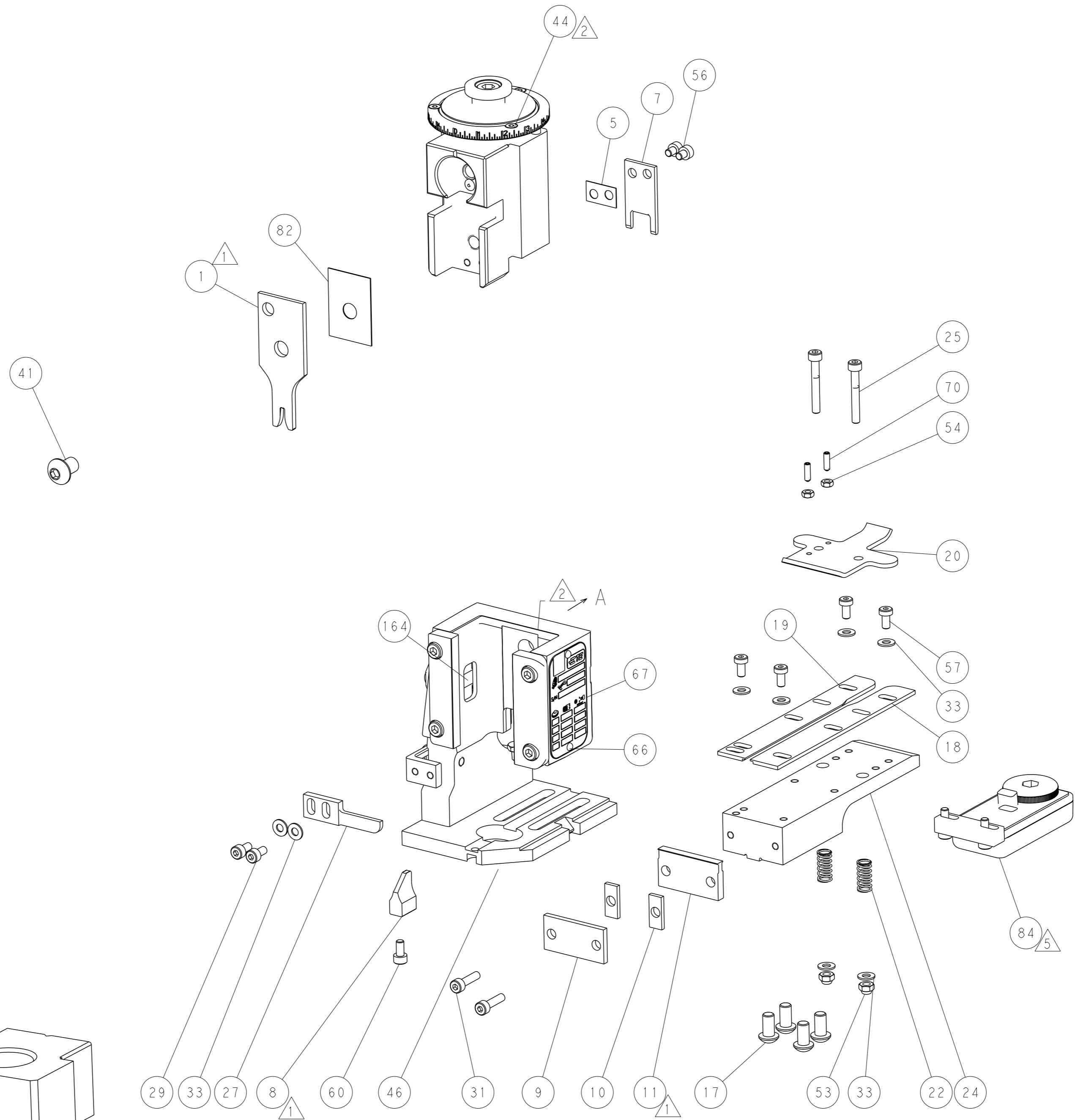
PNEUMATIC



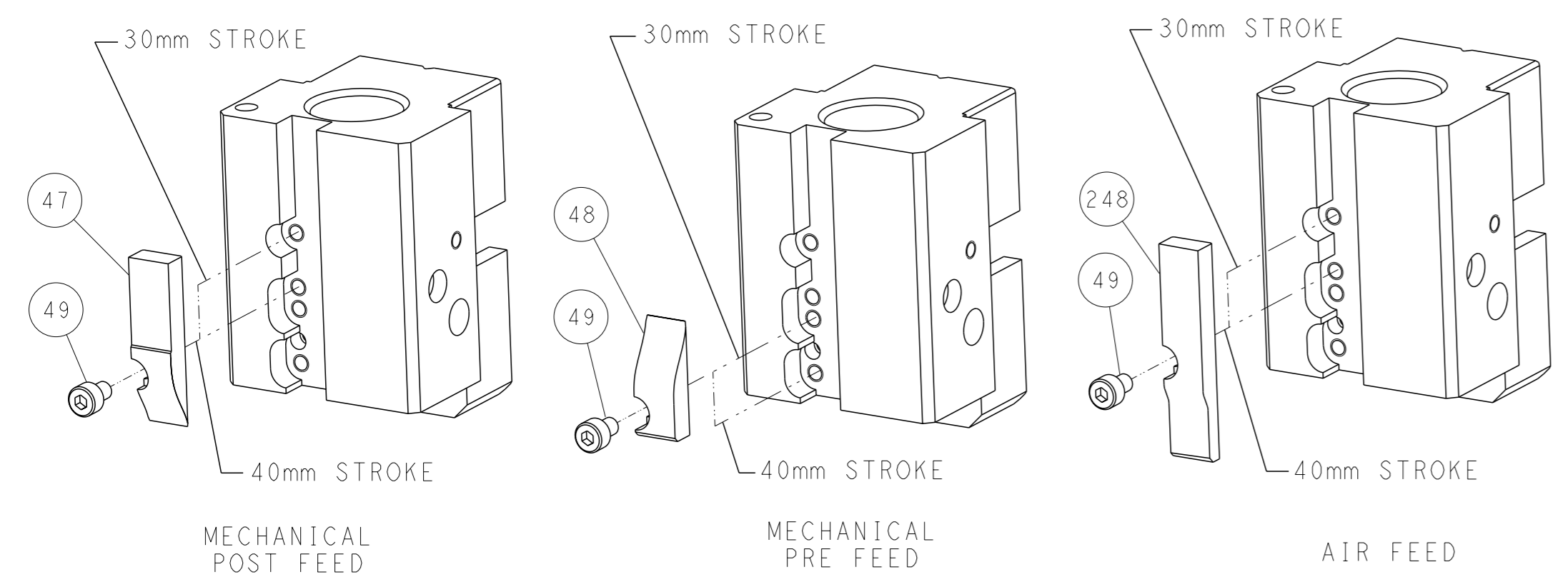
FEED SPRING  
SETTING POSITION



DETAIL A



CAM POSITIONS

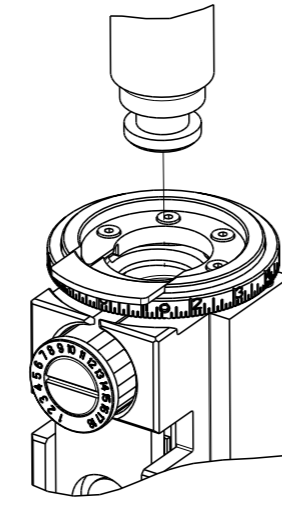


ATLANTIC VERSION  
 Shown on sheets 1 of 4 & 2 of 4  
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

<small>THIS DRAWING IS A CONTROLLED DOCUMENT FROM TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE AND THE CONTROLLER ENGINEERING ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST REVISION.</small>		OWN: K. HUANG CHK: L. ZHANG APVD: H. GUO	29OCT2015 29OCT2015 29OCT2015	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: C=2150631
MATERIAL:		WEIGHT:		RESTRICTED TO:
Customer Accessible Production Drawing		SCALE: 1:1		SHEET 2 of 4 REV B

THIS DRAWING IS UNPUBLISHED.	RELEASED FOR PUBLICATION	20	
COPYRIGHT 20 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.			
PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150631-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2150631-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150631-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.54 mm [.100]	F
INSUL	-	-
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: TERMINAL, RING			
WIRE STRIP LENGTH 3.66-4.26 mm [.144-.168 IN]		INSULATION DIAMETER RANGE Ø	
TERMINAL APPLICATION SPECIFICATION	114-2084	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
40749	40810	40812	63243-1
40811	40811-1		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
16 AWG	1.75 +/- 0.05 [0.069 +/- .002]	5.3
18 AWG	1.57 +/- 0.05 [0.062 +/- .002]	7.1
20 AWG	1.47 +/- 0.05 [0.058 +/- .002]	8.1



- RECOMMENDED SPARE PARTS
- REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- 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.
- 4. 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.

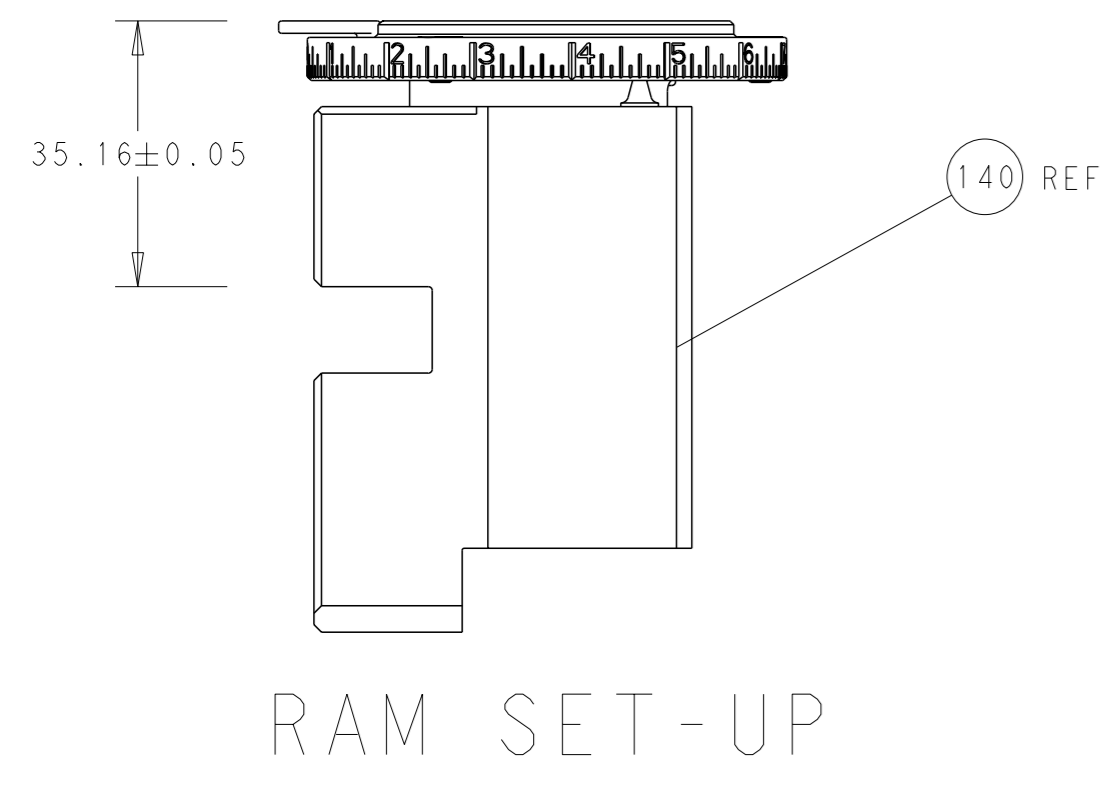
LOC	DIST	REV	LYR	DESCRIPTION	DATE	OWN	APVD
A	66	-	-	SEE SHEET 1	-	-	-

-	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	1	-	2844940-3	AIR FEED MODULE	238
-	4	4	2079383-9	SCR, BHSC, RoHS (M6 X 20)	186
-	REFREF	-	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	455888-4	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	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	-	1	2063961-1	FEED FINGER	58
-	4	4	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57
-	2	2	1-2168083-4	SCR, SKT HD CAP, RoHS, M4 X 5	56
-	2	2	5018030-1	NUT, HEX, REG, RoHS, M3	54
-	2	2	986965-8	NUT, LOCK, HEX, TORQUE (M4)	53
-	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	1803602-3	SCR, BHSC, RoHS (M8 X 12)	41
-	8	8	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
-	1	1	240639-1	STRIPPER (MACHINING)	27
-	2	2	1-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 30	25
-	1	1	1752371-2	PLATE, STRIP GUIDE	24
-	2	2	2-22281-3	SPRING, COMPRESSION	22
-	1	1	1803292-4	DRAG	20
-	1	1	1901696-3	STRIP GUIDE, REAR	19
-	1	1	1901695-3	STRIP GUIDE, FRONT	18
-	1	1	691901-2	REAR SHEAR PLATE, REVERSIBLE	11
-	2	2	1-240645-6	SPACER, SHEAR PLATE	10
-	1	1	240642-1	PLATE, FRONT SHEAR	9
-	1	1	1-1803002-8	ANVIL, COMBINATION, END FEED	8
-	1	1	2-691157-6	BLADE, SHEAR	7
-	-	-	-	-	6
-	1	1	5-240641-8	SPACER	5
-	-	-	-	-	4
-	-	-	-	-	3
-	-	-	-	-	2
-	1	1	456407-3	CRIMPER, WIRE PREMIUM	1
-	77-22-21	-	PART NO	DESCRIPTION	ITEM NO

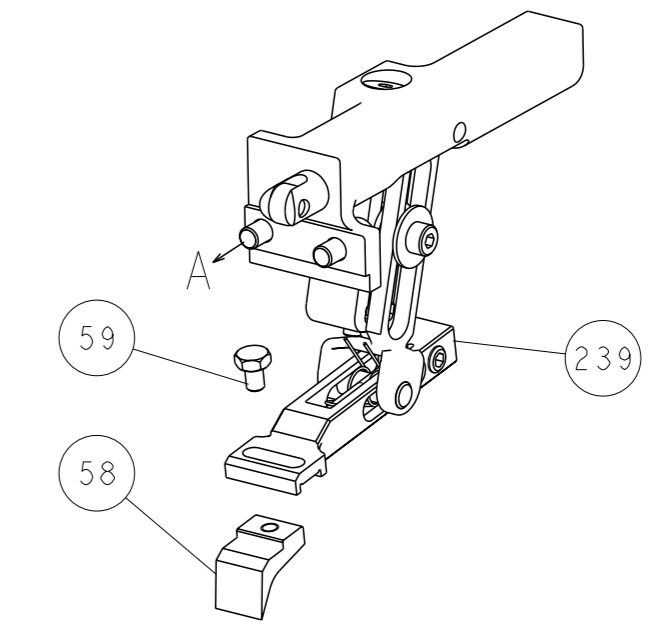
PACIFIC VERSION  
Shown on sheets 3 of 4 & 4 of 4  
(Atlantic version shown on sheets 1 of 4 & 2 of 4)

DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG: H. HUANG 29OCT2015		CHK: L. ZHANG 29OCT2015		APVD: J. GUO 29OCT2015		NAME: Ocean End Feed Applicator	
0 PLC ±		1 PLC ±		2 PLC ±		3 PLC ±		4 PLC ±		RESTRICTED TO	
MATERIAL:		FINISH:		WEIGHT:		SCALE: 1:1		SHEET 3 OF 4		REV B	

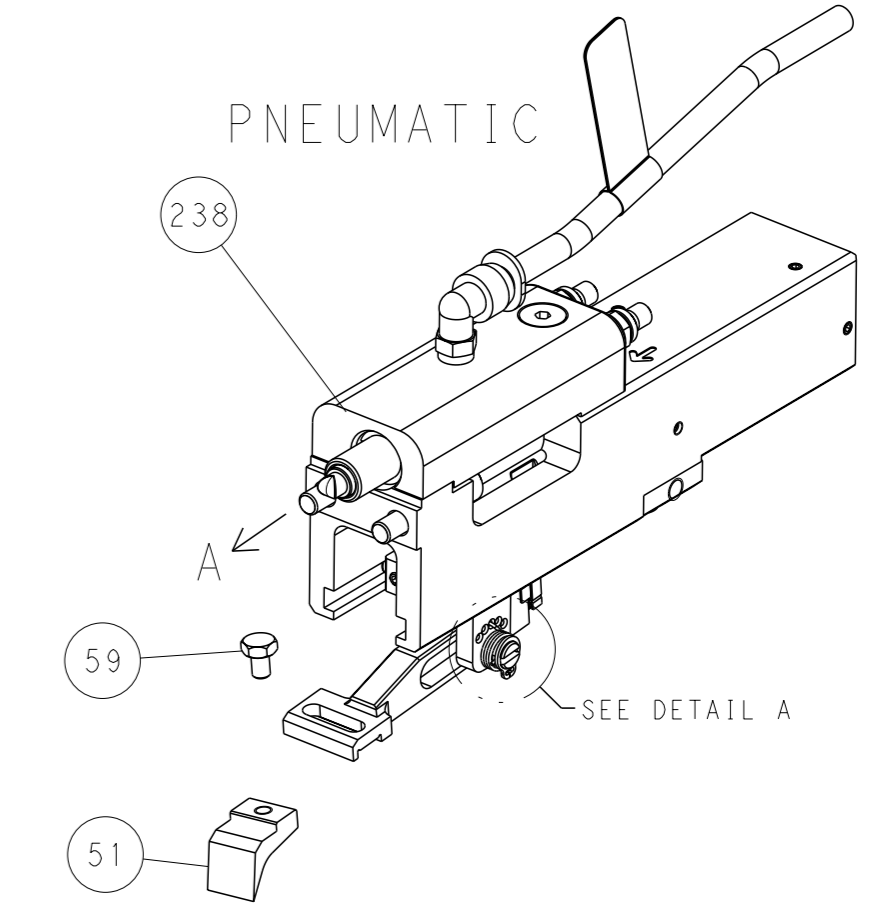
LOC	DIST	REVISIONS			
A	66	REV	DATE	OWN	APVD
		-	SEE SHEET 1	-	-



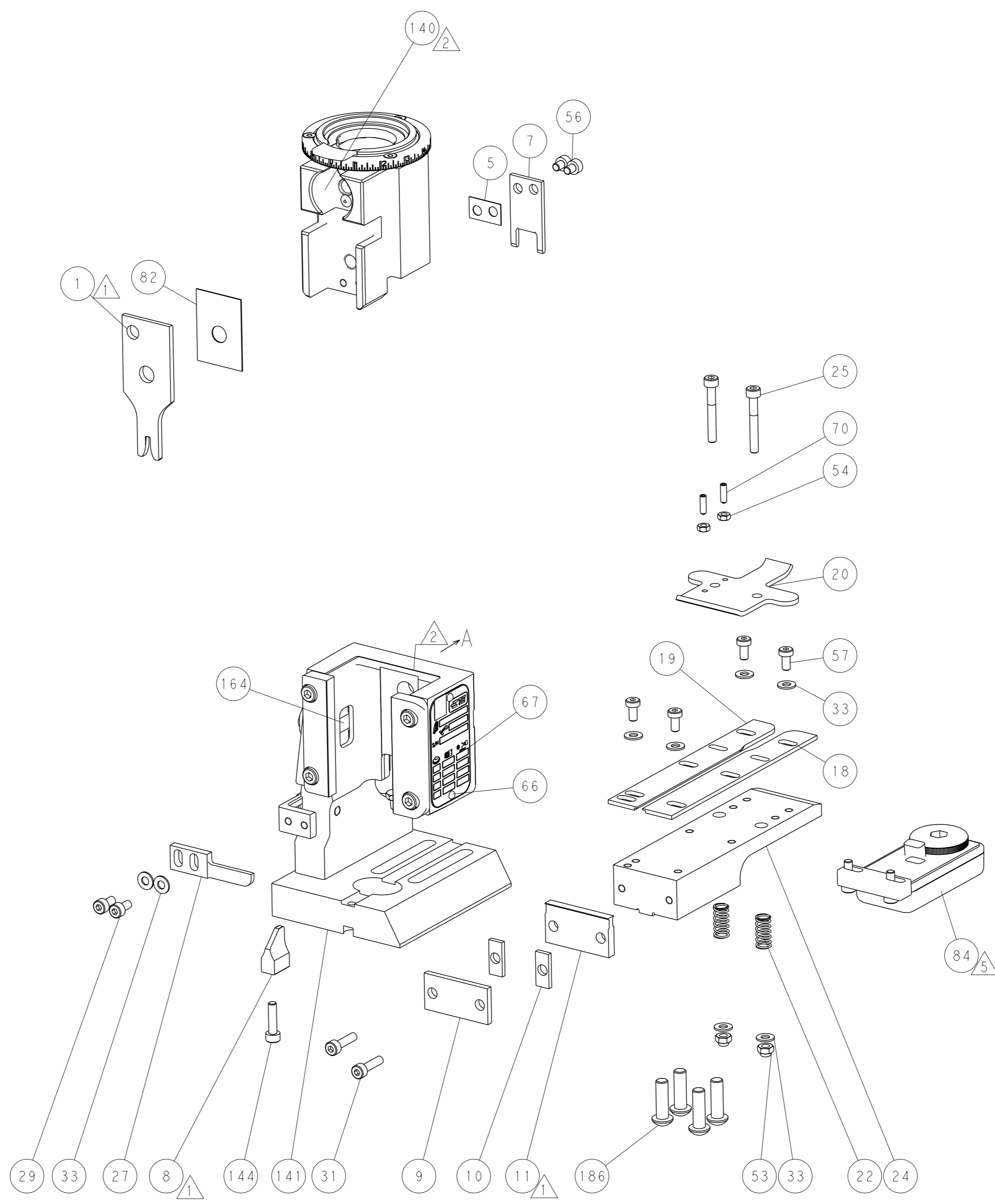
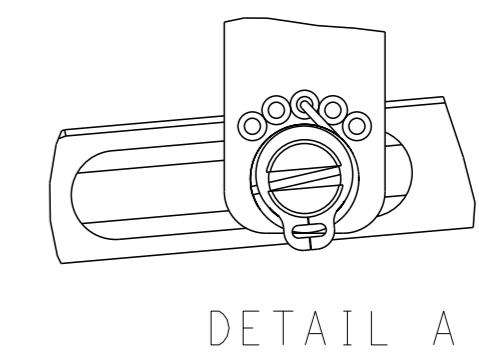
FEED TYPE  
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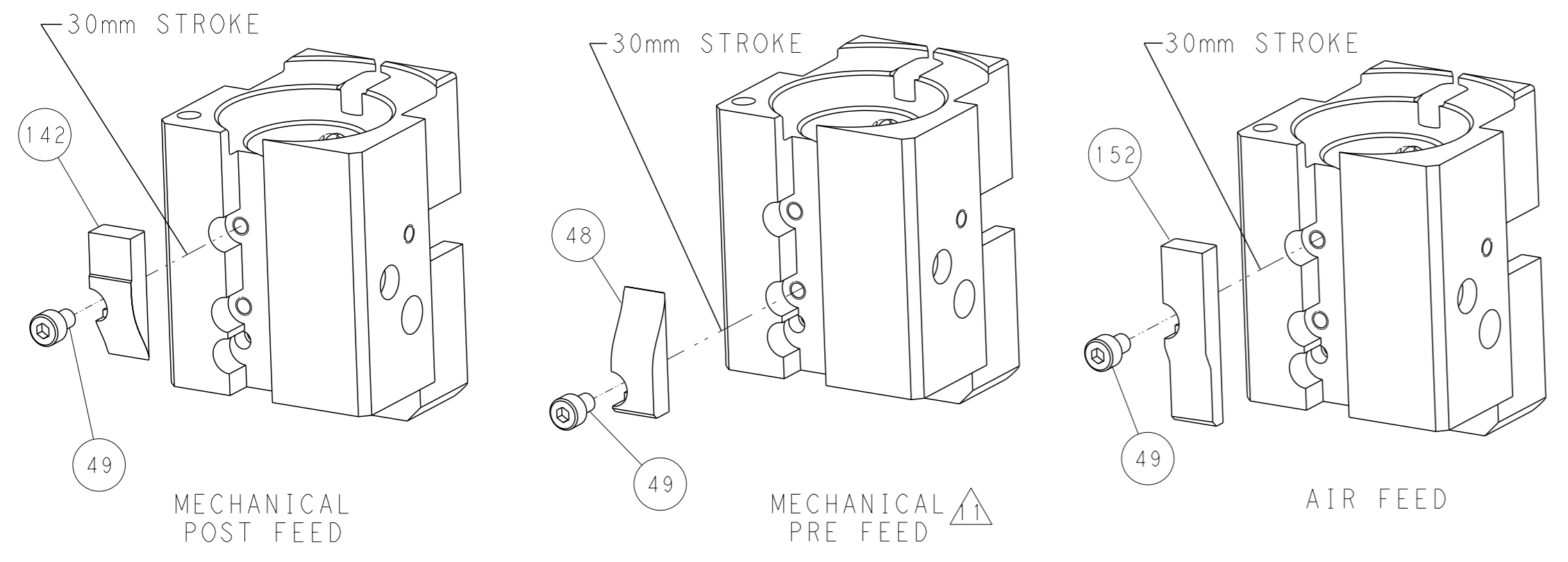
PNEUMATIC



FEED SPRING  
 SETTING POSITION



CAM POSITIONS



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 FINISH *	WEIGHT: - SCALE: 1:1 SHEET: 4 of 4 REV: B	CUSTOMER ACCESSIBLE PRODUCTION DRAWING			