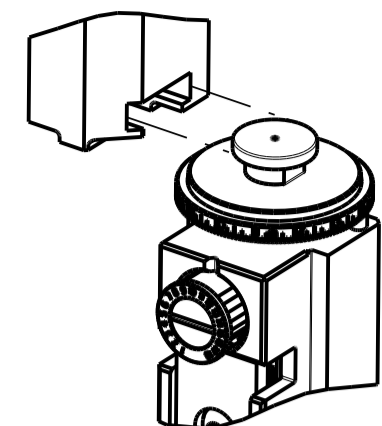


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150366-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150366-2	C	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150366-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.79 mm [.110]	F
INSUL	3.56 mm [.140]	O
APPLICATOR INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: RING			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
4.37-5.16 mm [.172-.203 IN]		∅2.03-3.05 mm [.080-.120 IN]	
TERMINAL APPLICATION SPECIFICATION	114-2084		
TERMINALS APPLIED Δ			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
60700-2	60700-3		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
16 AWG	1.57 +/- 0.05 [.062 +/- .002]	4.6
18 AWG	1.42 +/- 0.05 [.056 +/- .002]	6.4
20 AWG	1.32 +/- 0.05 [.052 +/- .002]	7.4



- Δ RECOMMENDED SPARE PARTS
 - Δ REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
 - Δ APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242. APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 180.
 - Δ 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.
 - Δ TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
6. 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.

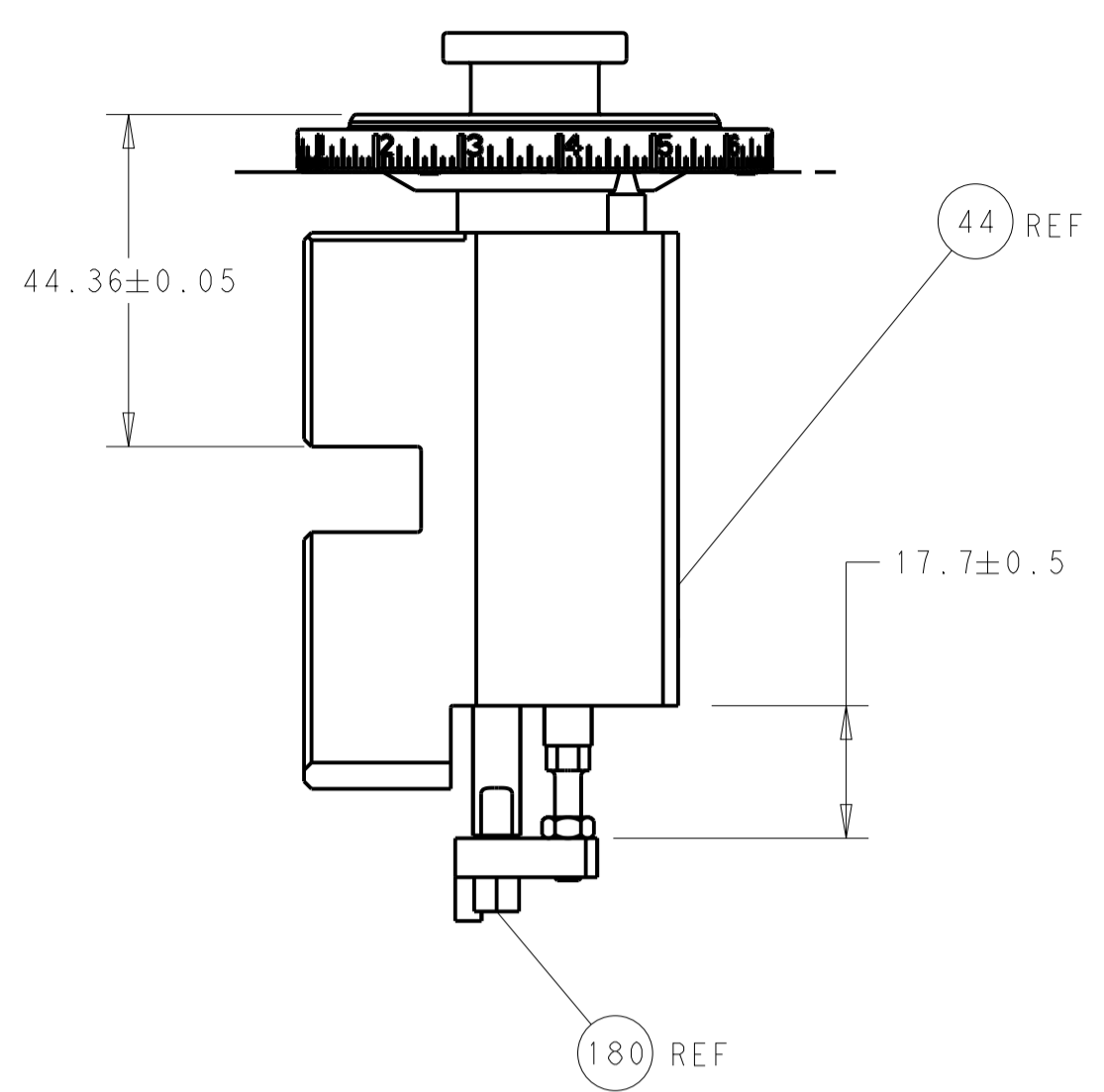
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		REV	LTN	DESCRIPTION	DATE	OWN	APP'D
A	66	1		DEVELOPMENT	11SEP2013	KH	UG
		A		RELEASED	08OCT2013	BH	GB
		B		ECR-19-005147	30MAR2019	TB	CT
		C		ECR-20-016924	02DEC2020	FZ	RK

-	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	
Δ	1	1	2119083-1	RETAINER, INSULATION DIAL	242	
-	1	1	2844940-4	AIR FEED MODULE	238	
-	1	1	1-18028-0	WASHER, FLAT, REG M8	192	
Δ	1	1	1752354-3	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	
-	REFREF		994970-2	COUNTER, MAGNETIC	164	
-	1	1	455888-6	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	
-	1	1	1901681-1	HOLDDOWN, TERMINAL	65	
-	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	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57	
-	2	2	2-2168083-6	SCR, SKT HD CAP, RoHS, M4 X 18	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	2063961-9	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	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	1752371-5	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	
-	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17	
-	1	1	2-240641-9	SPACER	16	
-	1	1	1752360-1	SPACER, HOLD-DOWN	13	
Δ	1	1	240644-1	PLATE, REAR SHEAR	11	
-	-	-	-	-	10	
Δ	1	1	690482-7	PLATE, FRONT SHEAR	9	
Δ	1	2	1	2-1803001-8	ANVIL, COMBINATION, END FEED	8
Δ	1	1	1	1-2217206-7	BLADE, SLUG	7
-	-	-	-	-	6	
-	1	1	1	2-240641-2	SPACER	5
-	1	1	1	3-238011-1	BLOCK, CRIMPER SPACER	4
Δ	1	2	1	1633965-9	CRIMPER, INSULATION O PREMIUM	3
-	-	-	-	-	2	
Δ	1	2	1	3-456408-3	CRIMPER, WIRE PREMIUM	1
-	77	72	2	PART NO	DESCRIPTION	ITEM NO

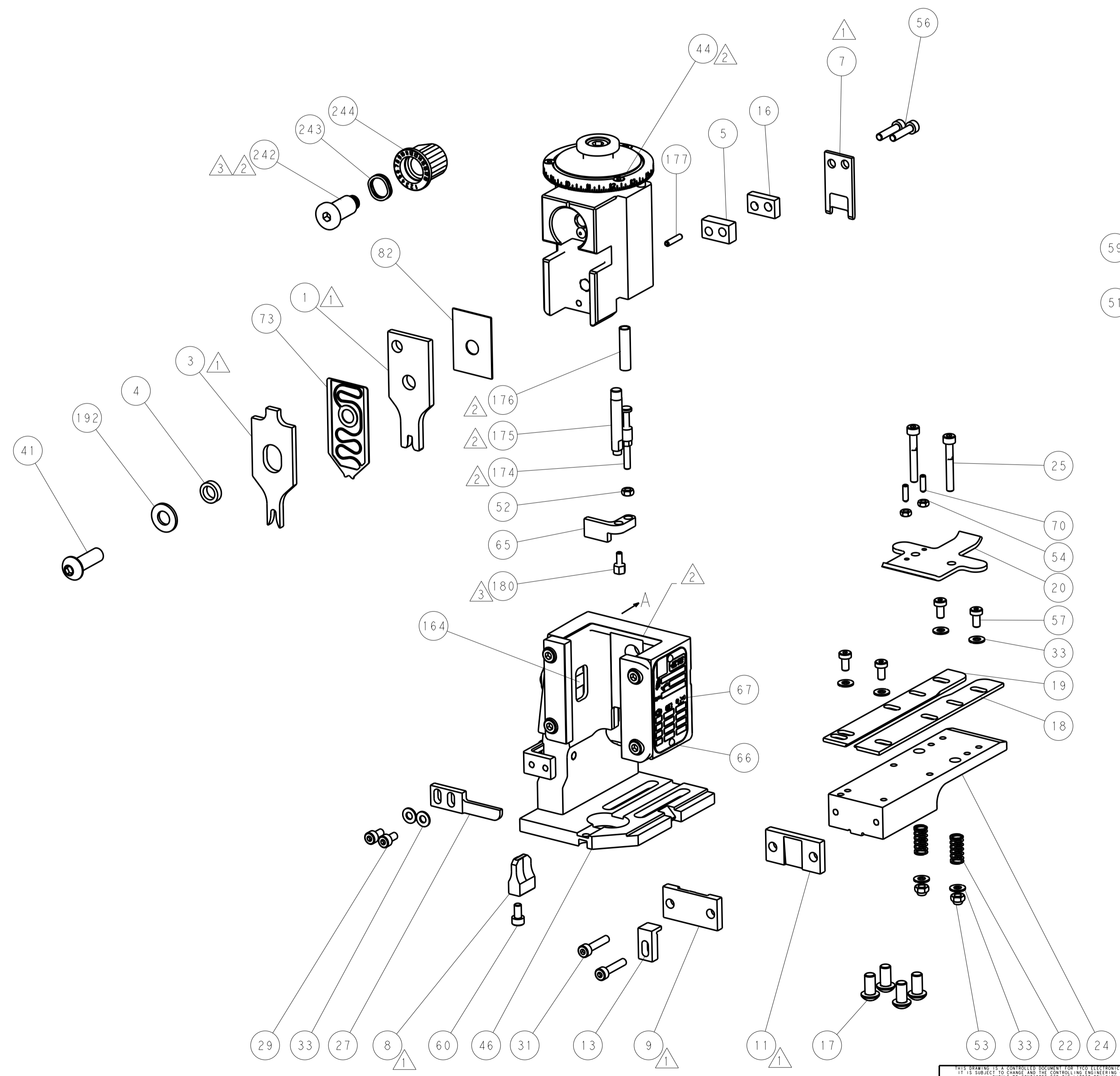
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG: H. HUANG 11SEP2013		CHK: L. ZHANG 11SEP2013		APVD: H. GUO 11SEP2013		NAME: Ocean End Feed Applicator	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES ±	FINISH	SIZE: A	CAGE CODE: 00779	DRAWING NO: 2150366	RESTRICTED TO: -
MATERIAL: -		FINISH: -		WEIGHT: -		SCALE: 1:1		SHEET: 1 OF 4		REV: C	
Customer Accessible Production Drawing										Customer Accessible Production Drawing	

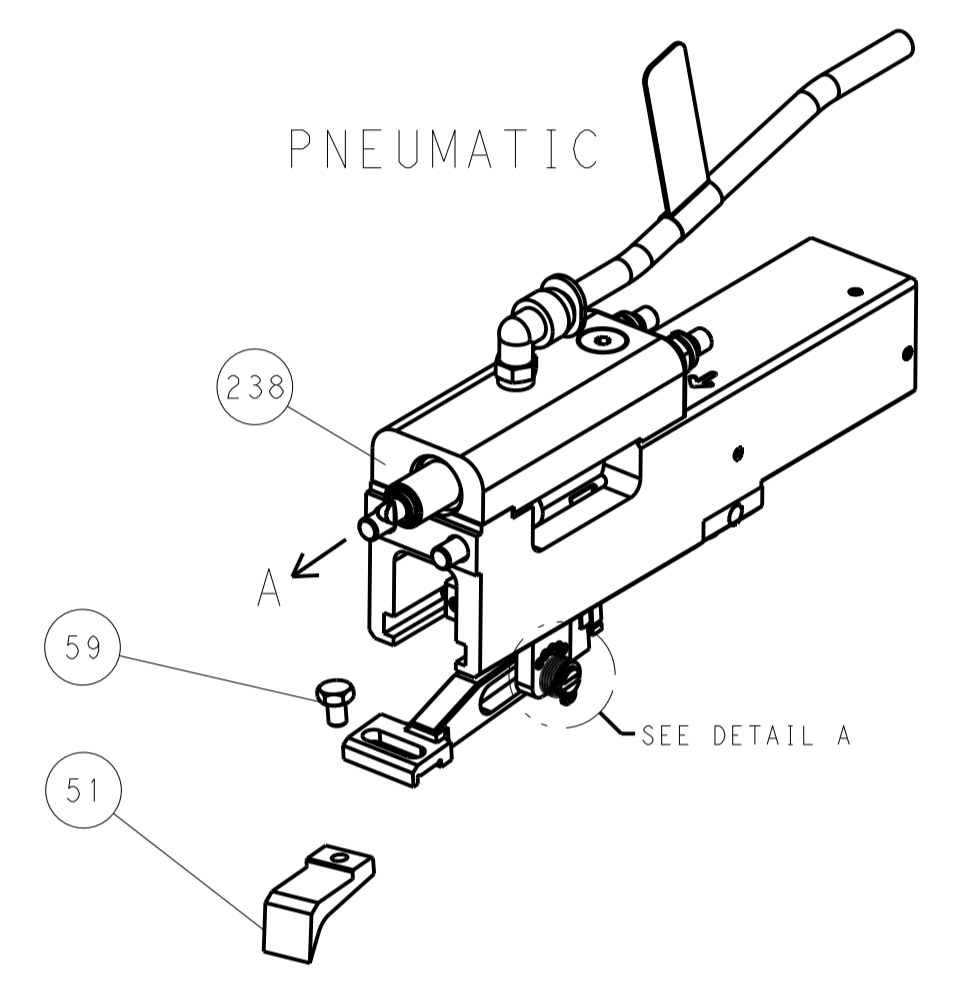
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A	66				
		DESCRIPTION	DATE	BY	APPV
		SEE SHEET 1			



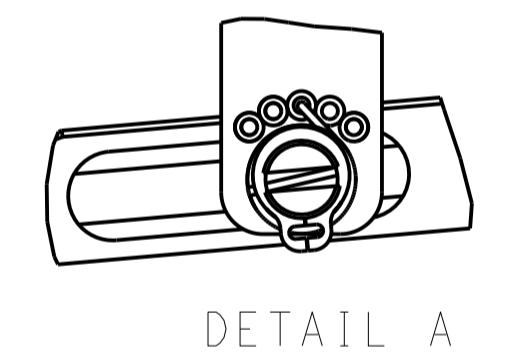
RAM AND HOLDDOWN SET-UP



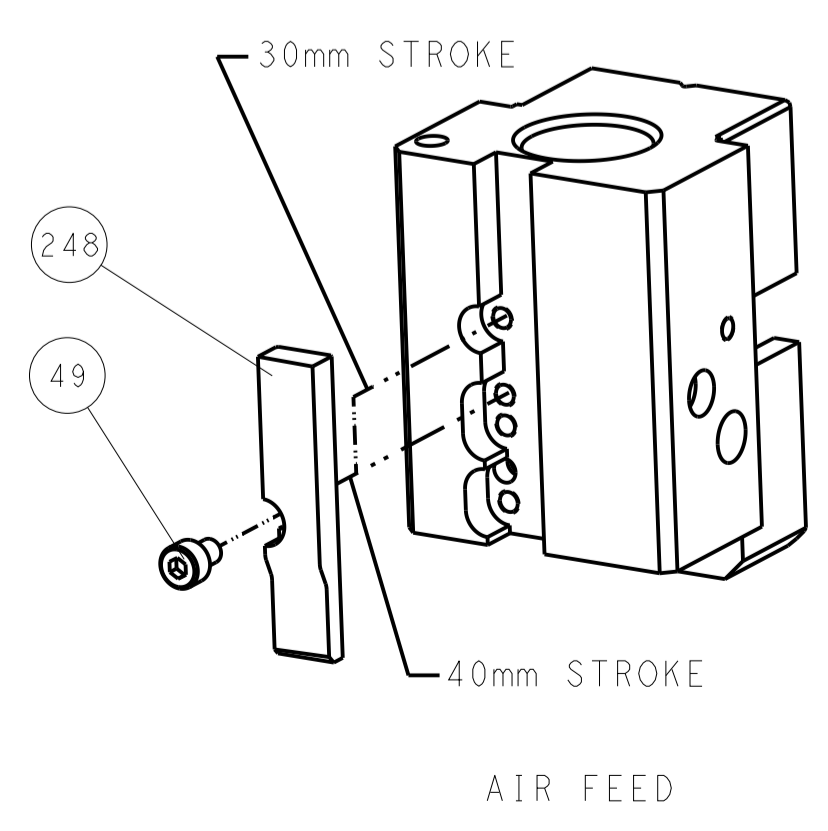
FEED TYPE



FEED SPRING SETTING POSITION



CAM POSITION

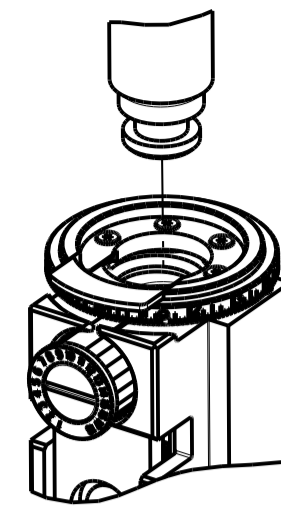


ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN: H. HUANG 11SEP2013		TE Connectivity	
mm	0 PLC	±		CHK: L. ZHANG 11SEP2013	NAME: Ocean End Feed Applicator		TE Connectivity Harrisburg, PA 17105-3608
	1 PLC	±		APPV: H. GUO 11SEP2013	RESTRICTED TO:		
	2 PLC	±			SIZE: A1		
	3 PLC	±			CAGE CODE: 00779		
	4 PLC	±			DRAWING NO: C=2150366		
	ANGLES	±			SCALE: 1:1		
MATERIAL:	FINISH:	WEIGHT:			SHEET 2 OF 4		REV C
Customer Accessible Production Drawing				Customer Accessible Production Drawing			

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150366-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150366-7	A	CRIMP TOOLING KIT	-

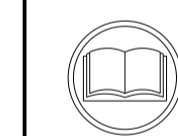
PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.79 mm (.110)	F
INSUL	3.56 mm (.140)	O
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: RING			
WIRE STRIP LENGTH 4.37-5.16 mm (.172-.203 IN)		INSULATION DIAMETER RANGE Ø2.03-3.05 mm (.080-.120 IN)	
TERMINAL APPLICATION SPECIFICATION 114-2084			
TERMINALS APPLIED			
TE TERMINAL 60700-2	TE TERMINAL 60700-3	TE TERMINAL	TE TERMINAL

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
16 AWG	1.57+/-0.05 [.062+/-0.002]	4.6
18 AWG	1.42+/-0.05 [.056+/-0.002]	6.4
20 AWG	1.32+/-0.05 [.052+/-0.002]	7.4



- 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. APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 180.
- 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. 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)

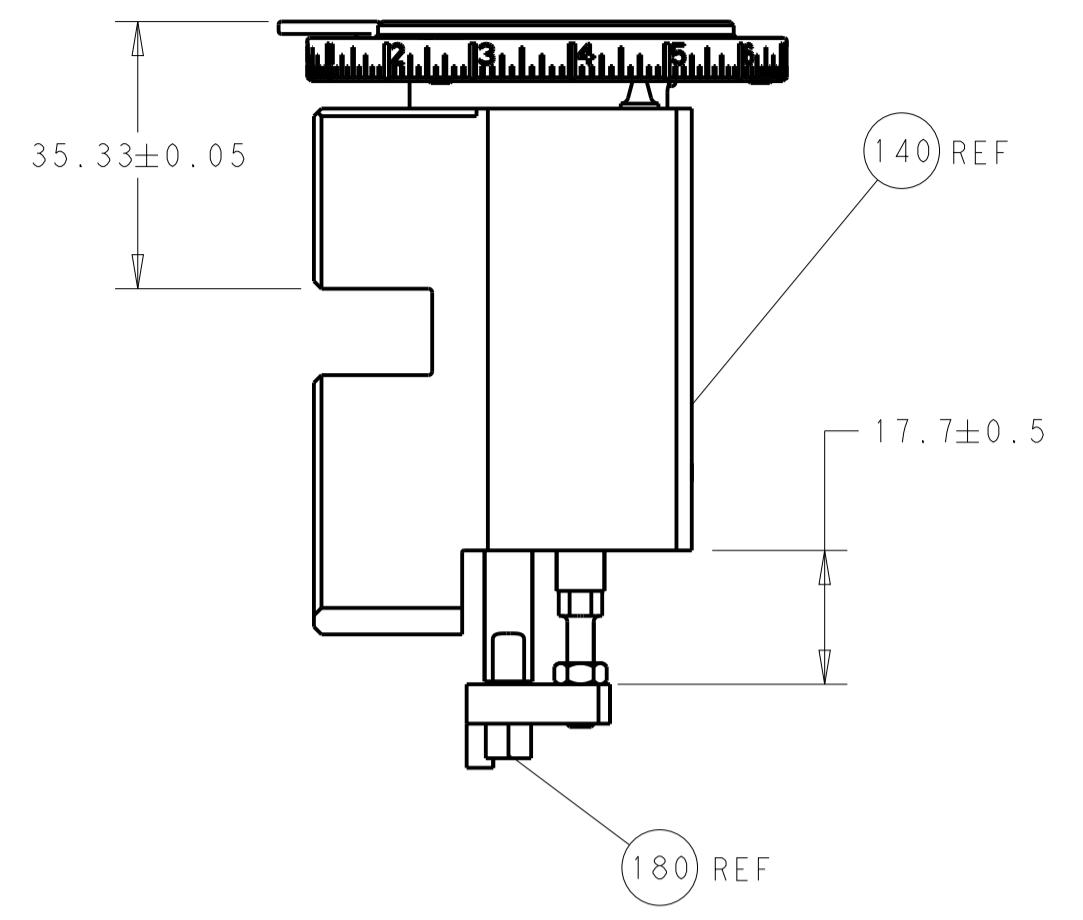
LOC	DIST	REV	DATE	BY	APPV
A	66				

REVISIONS				
REV	DATE	DESCRIPTION	DATE	BY
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-	1	2079764-1		243
-	1	2119083-1		242
-	1	2844940-4		238
-	1	1-18028-0		192
-	4	2079383-9		186
-	1	1752354-3		180
-	1	6-993111-6		177
-	1	8-22280-7		176
-	1	1752353-2		175
-	1	1901680-2		174
-	REF	994970-2		164
-	1	2119641-2		152
-	1	2168083-8		144
-	1	2119655-6		141
-	1	1803518-1		140
-	1	455888-6		82
-	1	2119791-9		73
-	1	1803607-4		71
-	2	2-18032-2		70
-	1	2119740-1		67
-	2	2168078-1		66
-	1	1901681-1		65
-	1	5-18022-5		59
-	4	2168400-4		57
-	2	2-2168083-6		56
-	2	5018030-1		54
-	2	986965-8		53
-	1	1-5018030-0		52
-	1	2063961-9		51
-	1	18023-9		49
-	1	1803602-1		41
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-	2	2168083-9		31
-	2	2168083-2		29
-	1	240639-1		27
-	2	1-2168083-5		25
-	1	1752371-5		24
-	2	2-22281-3		22
-	1	1803292-4		20
-	1	1901696-3		19
-	1	1901695-3		18
-	1	2-240641-9		16
-	1	1752360-1		13
-	1	240644-1		11
-	-	-		10
-	1	690482-7		9
1	1	2-1803001-8		8
-	1	1-2217206-7		7
-	-	-		6
-	1	2-240641-2		5
-	1	3-238011-1		4
1	1	1633965-9		3
-	-	-		2
1	1	3-456408-3		1
-	-	-		0

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		MATERIAL:	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±
	ANGLES	FINISH			

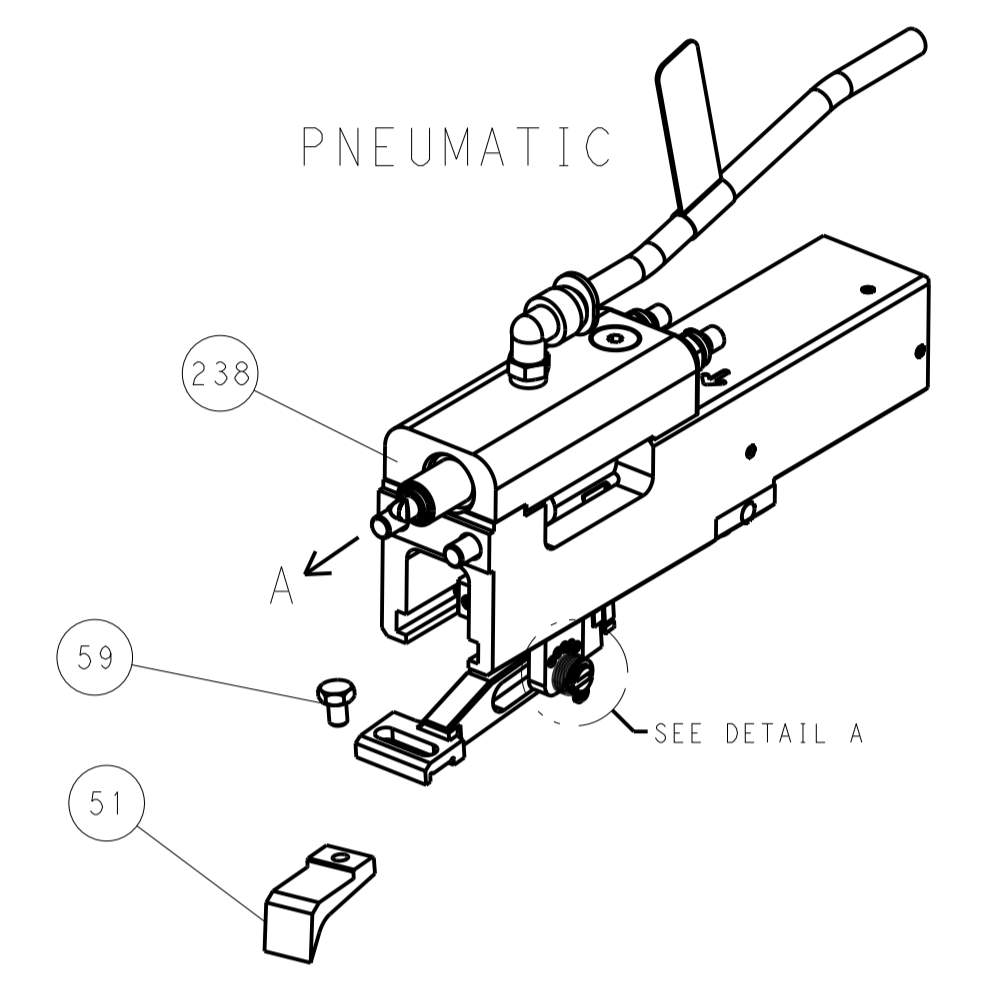
OWN	H. HUANG	11SEP2013
CHK	L. ZHANG	11SEP2013
APPV	J. GUO	11SEP2013
NAME	Ocean End Feed Applicator	
SIZE	CAGE CODE	DRAWING NO
A1	00779	2150366
Customer Accessible Production Drawing		
SCALE	1:1	SHEET 3 OF 4

LOC	DIST	REV	DATE	BY	APPV
A	66				

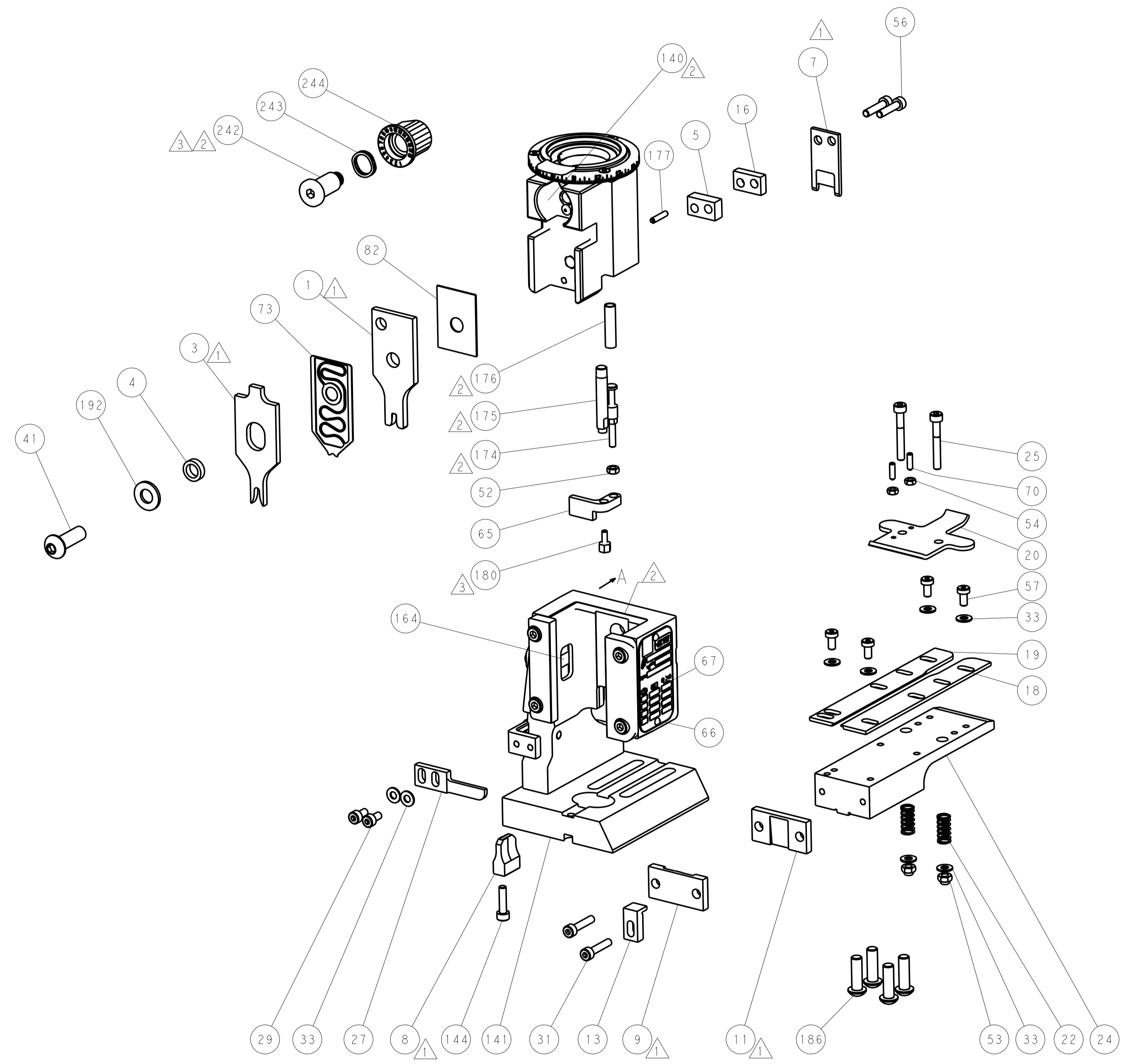
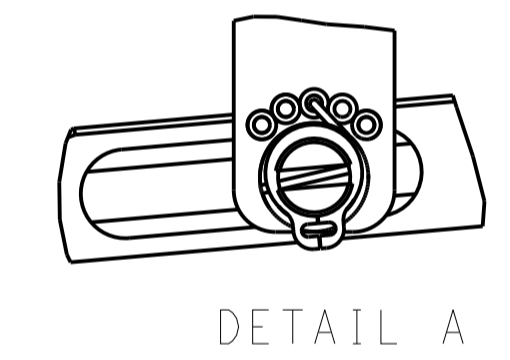


RAM AND HOLDDOWN SET-UP

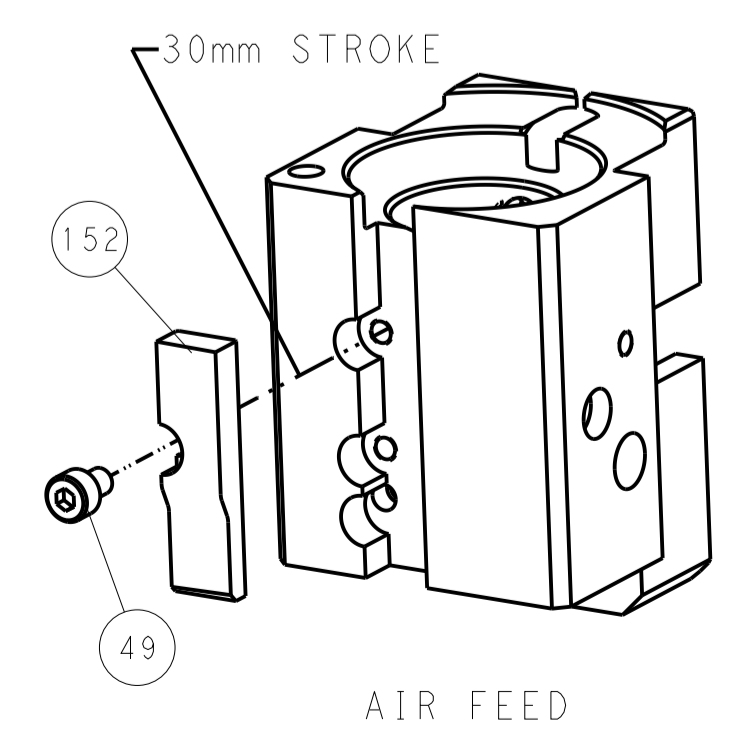
FEED TYPE



FEED SPRING SETTING POSITION



CAM POSITION



AIR FEED

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 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.</small>		DWN: H. HUANG CHK: L. ZHANG APVD: H. GUO	DATE: 11SEP2013 NAME: Ocean End Feed Applicator
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±	MATERIAL: - FINISH: -	PRODUCT SPEC: - APPLICATION SPEC: - WEIGHT: - SCALE: 1:1	SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2150366 SHEET: 4 OF 4 REV: C