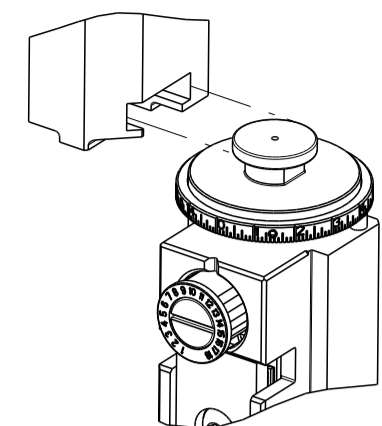


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150584-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150584-2	C	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150584-7	A	CRIMP TOOLING KIT	-

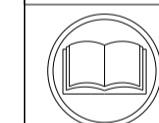
ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.03 mm [.080]	F
INSUL	3.18 mm [.125]	F
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: EURAMTEC CORP TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: TERMINAL			
WIRE STRIP LENGTH 4.34-4.72 mm [.171-.186 IN]		INSULATION DIAMETER RANGE ∅ 1.68-2.54 mm [.066-.100 IN]	
TERMINAL APPLICATION SPECIFICATION	NONE	-	-
TERMINALS APPLIED			
TE TERMINAL 1949348-1	EURAMTEC CORP TERMINAL W-ST-200	TE TERMINAL	EURAMTEC CORP TERMINAL

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
16 AWG	1.49+/-0.05 [.059+/-0.002]	6.3
18 AWG	1.31+/-0.05 [.052+/-0.002]	8.4
20 AWG	1.18+/-0.05 [.046+/-0.002]	9.6



- 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.
- 5. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- CUT TO LENGTH AT ASSEMBLY.

**\*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.

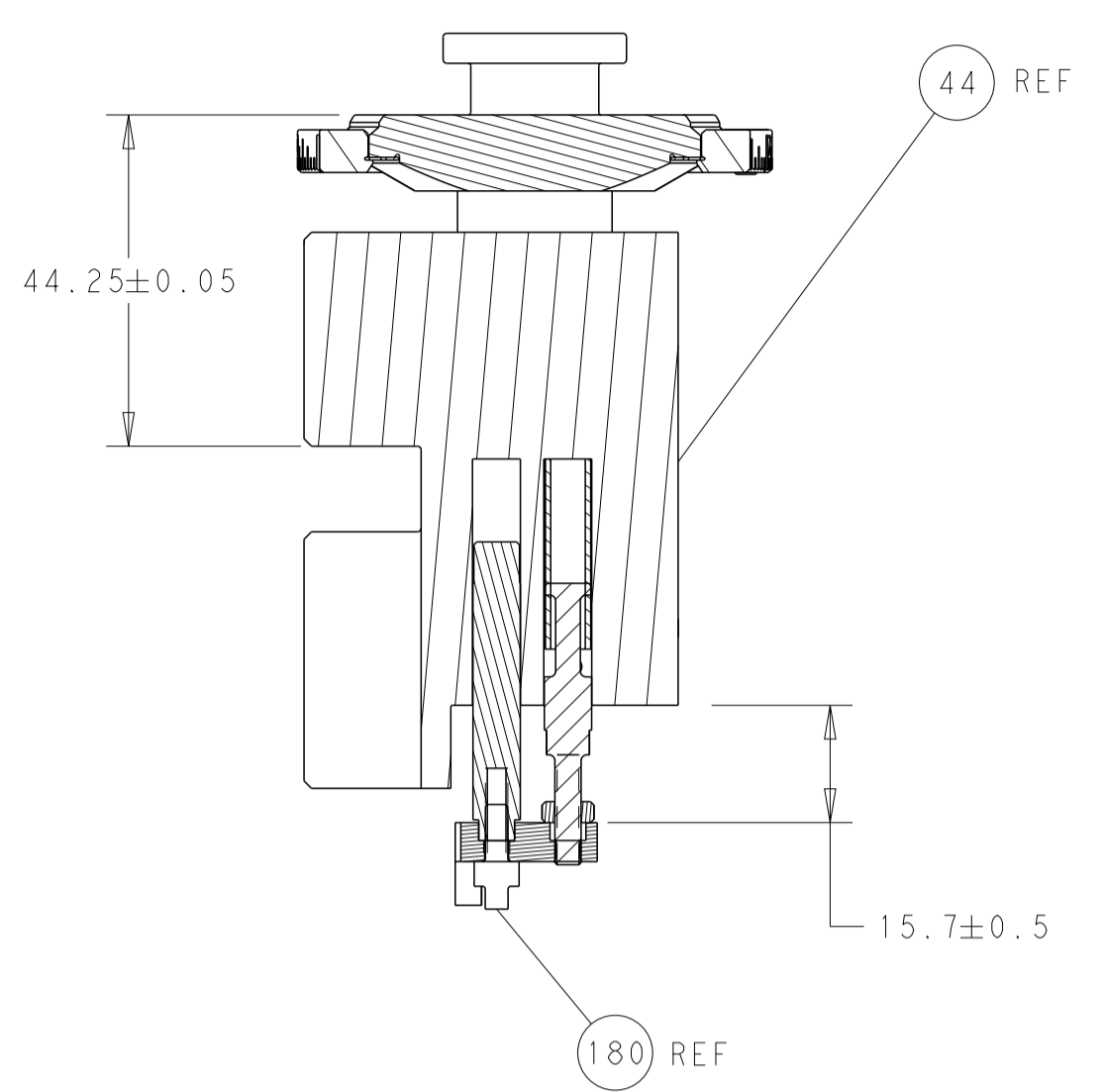
**ATLANTIC VERSION**  
Shown on sheets 1 of 4 & 2 of 4  
(Pacific version shown on sheets 3 of 4 & 4 of 4)

LOC	DIST	REVISIONS					
		P	LTN	DESCRIPTION	DATE	OWN	APPD
A	66			RELEASED	30JUL2015	BW	GB
				ECR-22-148305	03AUG2022	FZ	TE
				ECR-22-162310	29DEC2022	JWC	GB

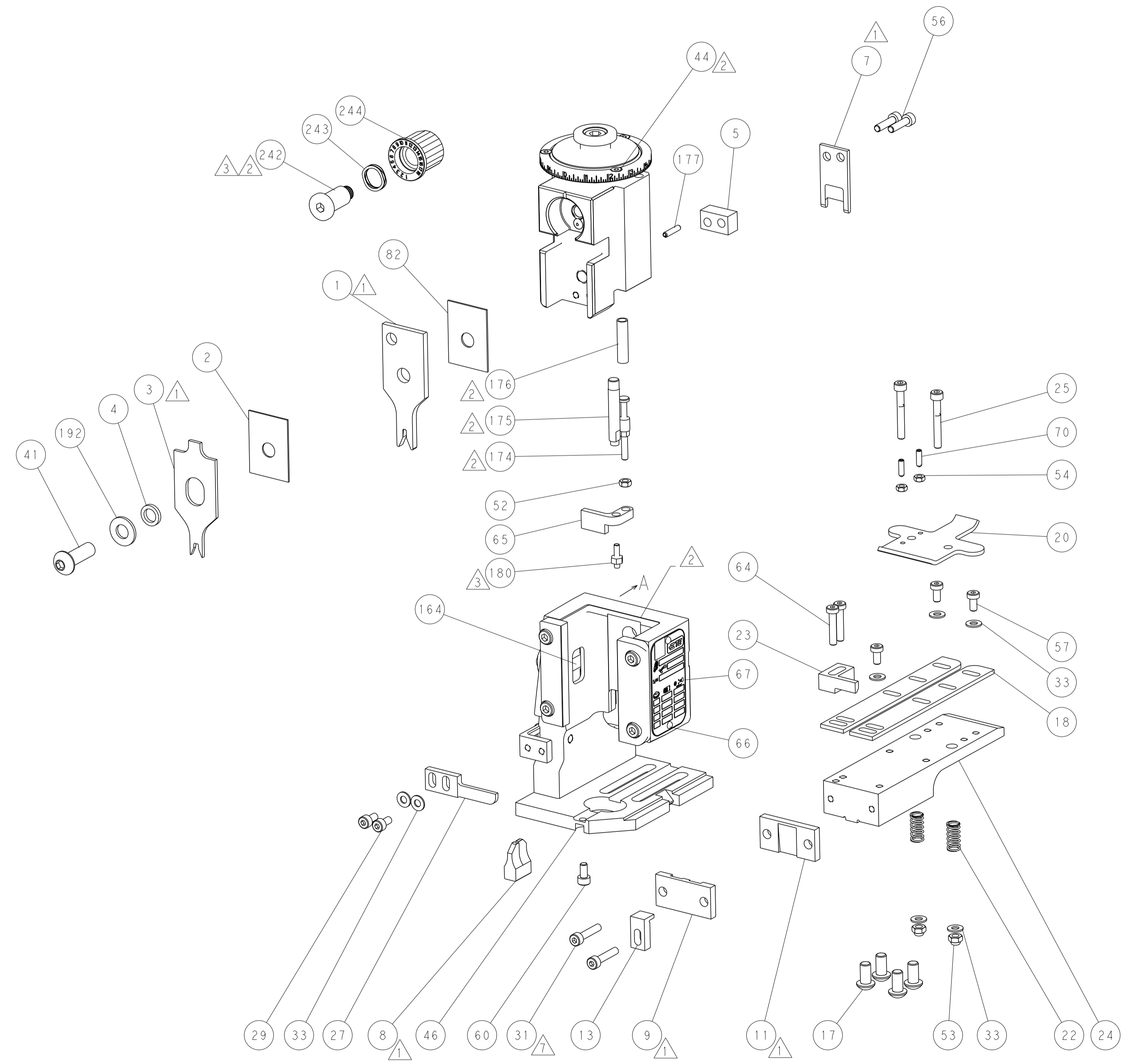
-	1	1	2119641-1	FEED CAM, AIR FEED	248	
-	1	1	2119759-1	RAM, AMP STYLE, END FEED, NON-ADJUST	245	
-	1	1	2119082-4	CAM, SNAIL, INSULATION ADJUSTMENT	244	
-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243	
	1	1	2119083-1	RETAINER, INSULATION DIAL	242	
-	1	1	2844940-4	AIR FEED MODULE	238	
-	1	1	1-18028-0	WASHER, FLAT, REG M8	192	
	1	1	1-1976055-0	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	
-	REF	REF	994970-2	COUNTER, MAGNETIC	164	
-	1	1	455888-8	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	1901681-1	HOLDDOWN, TERMINAL	65	
-	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	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	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	
-	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	240639-1	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	
-	1	1	240825-1	PLATE, STRIP HOLD DOWN	23	
-	2	2	2-22281-3	SPRING, COMPRESSION	22	
-	1	1	1803292-4	DRAG	20	
-	2	2	1-1901259-0	GUIDE, LOWER STRIP	18	
-	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17	
	1	1	1752360-1	SPACER,HOLD-DOWN	13	
-	1	1	240644-1	PLATE, REAR SHEAR	11	
-	-	-	-	-	10	
	1	1	690482-5	PLATE, FRONT SHEAR	9	
	1	2	1	8-1803000-4	ANVIL, COMBINATION, END FEED	8
-	1	1	2217206-7	BLADE, SLUG	7	
-	-	-	-	-	6	
-	1	1	6-240641-0	SPACER	5	
-	1	1	2-238011-2	BLOCK, CRIMPER SPACER	4	
	1	2	1	6-1803017-6	CRIMPER, INSULATION F	3
-	1	1	455888-7	SPACER, CRIMPER	2	
	1	2	1	6-1633860-2	CRIMPER, WIRE	1
-	77	72	-2	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	WT	SCALE	SHEET	REV
										1 of 4	C

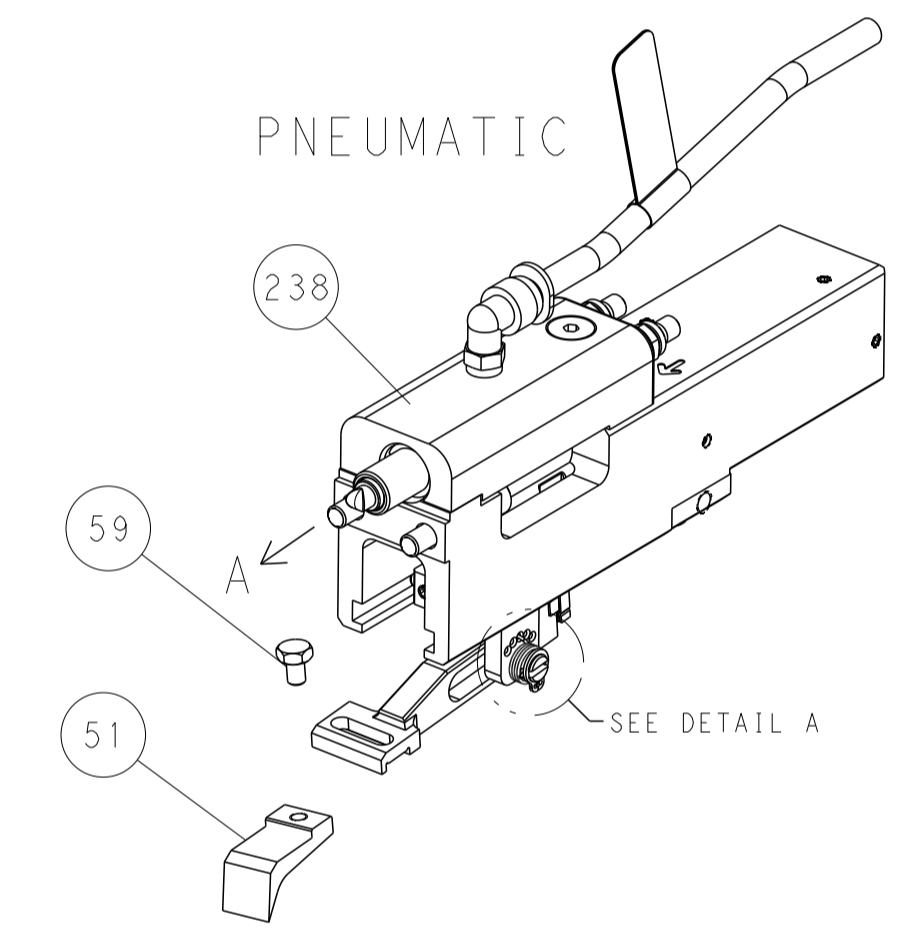
LOC	DIST	REV	DATE	BY	APPV
A	66				
REVISIONS			DESCRIPTION	DATE	BY
			SEE SHEET 1		



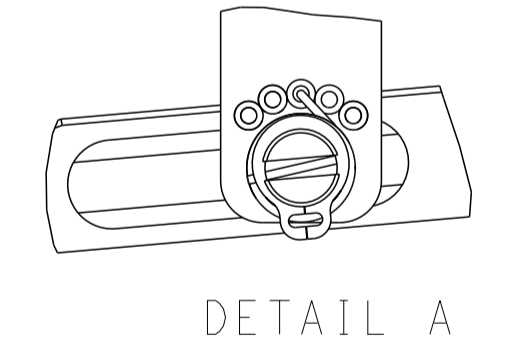
RAM AND HOLDDOWN SET-UP



FEED TYPE

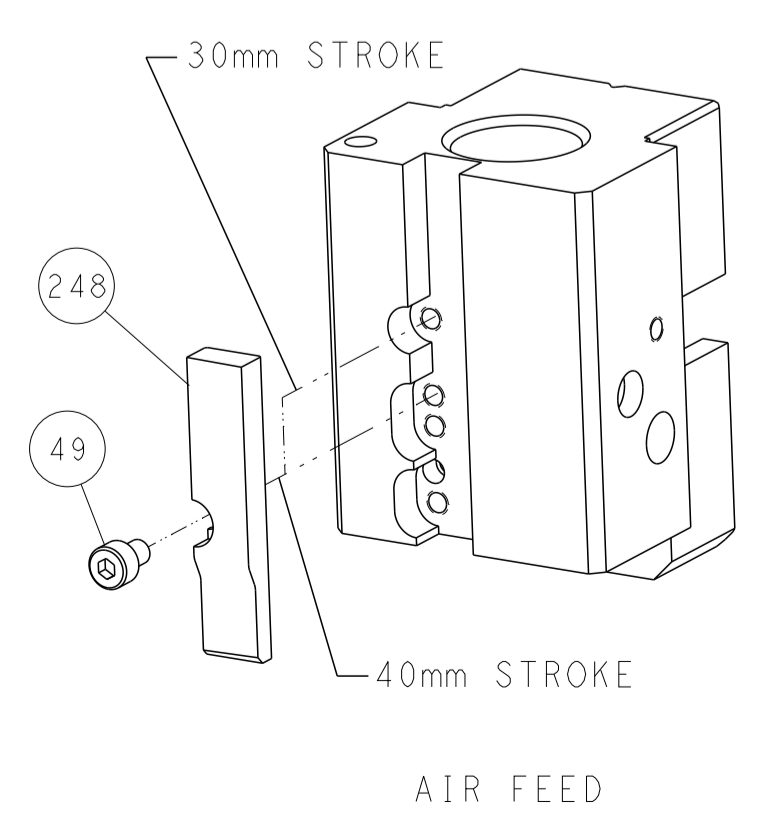


FEED SPRING SETTING POSITION



DETAIL A

CAM POSITION



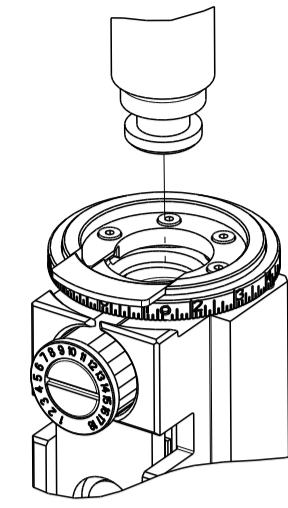
AIR FEED

**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 2015 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.</small>		DWN: B. WEAVER 26 JUN 2015 CHK: G. BAILEY 26 JUN 2015 APVD: G. BAILEY 26 JUN 2015	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:	SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2150584 SCALE: 1:1 SHEET: 2 of 4 REV: C
MATERIAL:		Customer Accessible Production Drawing	

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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150584-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150584-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR  
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.03 mm [.080]	F
INSUL	3.18 mm [.125]	F
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: EURAMTEC CORP TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: TERMINAL			
WIRE STRIP LENGTH 4.34-4.72 mm [.171-.186 IN]		INSULATION DIAMETER RANGE ∅ 1.68-2.54 mm [.066-.100 IN]	
TERMINAL APPLICATION SPECIFICATION	NONE	-	-
TERMINALS APPLIED			
TE TERMINAL	EURAMTEC CORP TERMINAL	TE TERMINAL	EURAMTEC CORP TERMINAL
1949348-1	W-ST-200		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
16 AWG	1.49+/-0.05 [.059+/-0.002]	6.3
18 AWG	1.31+/-0.05 [.052+/-0.002]	8.4
20 AWG	1.18+/-0.05 [.046+/-0.002]	9.6

- 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.
- 6 TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- 7 CUT TO LENGTH AT ASSEMBLY.

**\*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	LTN	DESCRIPTION	DATE	OWN	APVD
-	-	-	-	SEE SHEET 1	-	-	-

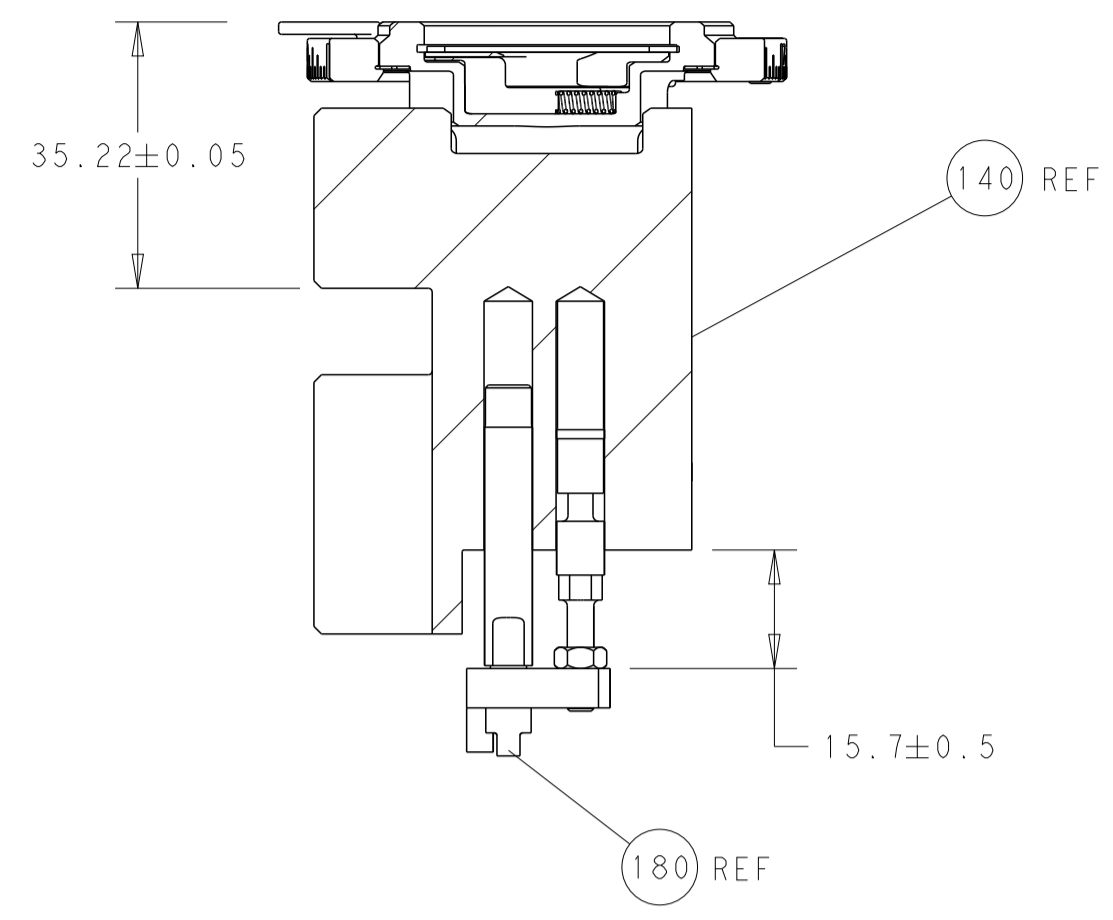
-	1	2119082-4	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
3	-	2119083-1	RETAINER, INSULATION DIAL	242
-	1	2844940-4	AIR FEED MODULE	238
-	1	1-18028-0	WASHER, FLAT, REG M8	192
-	4	2079383-9	SCR, BHSC, RoHS (M6 X 20)	186
3	-	1-1976055-0	STANDOFF, HOLD-DOWN	180
-	1	6-993111-6	PIN, SLOTTED SPRING 3.0 X 14.0	177
-	1	8-22280-7	SPRING, COMPRESSION	176
-	1	1752353-2	GUIDE PIN,HOLDDOWN	175
-	1	1901680-2	GUIDE PIN,HOLDDOWN	174
-	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	455888-8	SPACER, CRIMPER	82
-	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	1901681-1	HOLDDOWN, TERMINAL	65
-	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	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	56
-	2	5018030-1	NUT, HEX, REG, RoHS, M3	54
-	2	986965-8	NUT, LOCK, HEX, TORQUE (M4)	53
-	1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52
-	1	2063961-9	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
7	-	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	31
-	2	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	29
-	1	240639-1	STRIPPER (MACHINING)	27
-	2	1-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 30	25
-	1	1752371-5	PLATE, STRIP GUIDE	24
-	1	240825-1	PLATE, STRIP HOLD DOWN	23
-	2	2-22281-3	SPRING, COMPRESSION	22
-	1	1803292-4	DRAG	20
-	2	1-1901259-0	GUIDE, LOWER STRIP	18
1	-	1752360-1	SPACER,HOLD-DOWN	13
-	1	240644-1	PLATE, REAR SHEAR	11
-	-	-	-	10
-	1	690482-5	PLATE, FRONT SHEAR	9
1	1	8-1803000-4	ANVIL, COMBINATION, END FEED	8
-	1	2217206-7	BLADE, SLUG	7
-	-	-	-	6
-	1	6-240641-0	SPACER	5
-	1	2-238011-2	BLOCK, CRIMPER SPACER	4
1	1	6-1803017-6	CRIMPER, INSULATION F	3
-	1	455888-7	SPACER, CRIMPER	2
1	1	6-1633860-2	CRIMPER, WIRE	1
-	77-22	PART NO	DESCRIPTION	ITEM NO

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:	
mm	0 PLC ±	1 PLC ±	2 PLC ±
	3 PLC ±	4 PLC ±	ANGLES ±
	FINISH		
MATERIAL		WEIGHT	
Customer Accessible Production Drawing		SCALE	1:1
SHEET 3 OF 4		REV	C

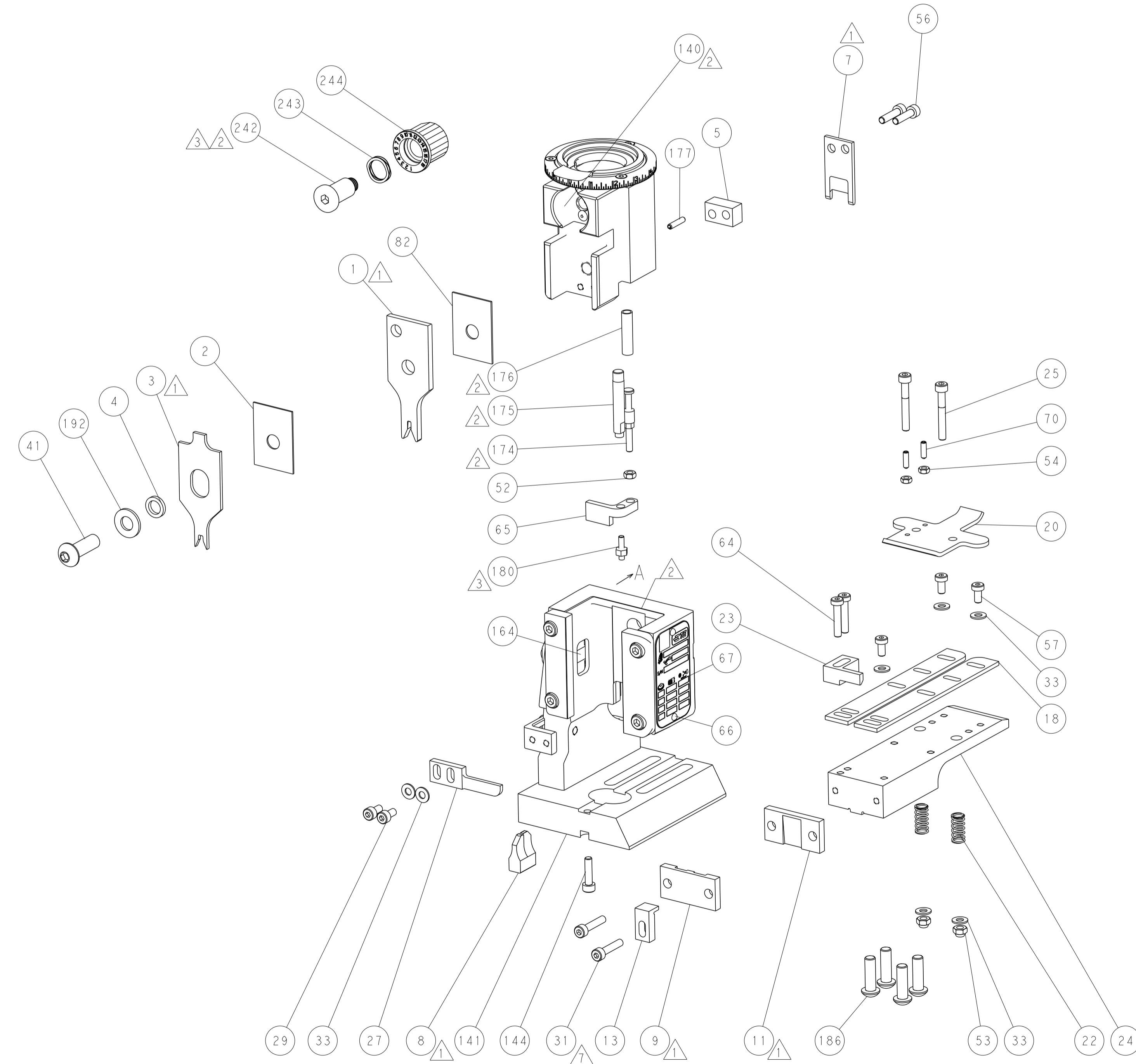
CHK	D. WEAVER	26 JUN 2015
CHK	G. BAILEY	26 JUN 2015
APVD	G. BAILEY	26 JUN 2015
NAME	Ocean End Feed Applicator	
SIZE	CAGE CODE	DRAWING NO
A1	00779	2150584

STE TE Connectivity  
Harrisburg, PA 17105-3608

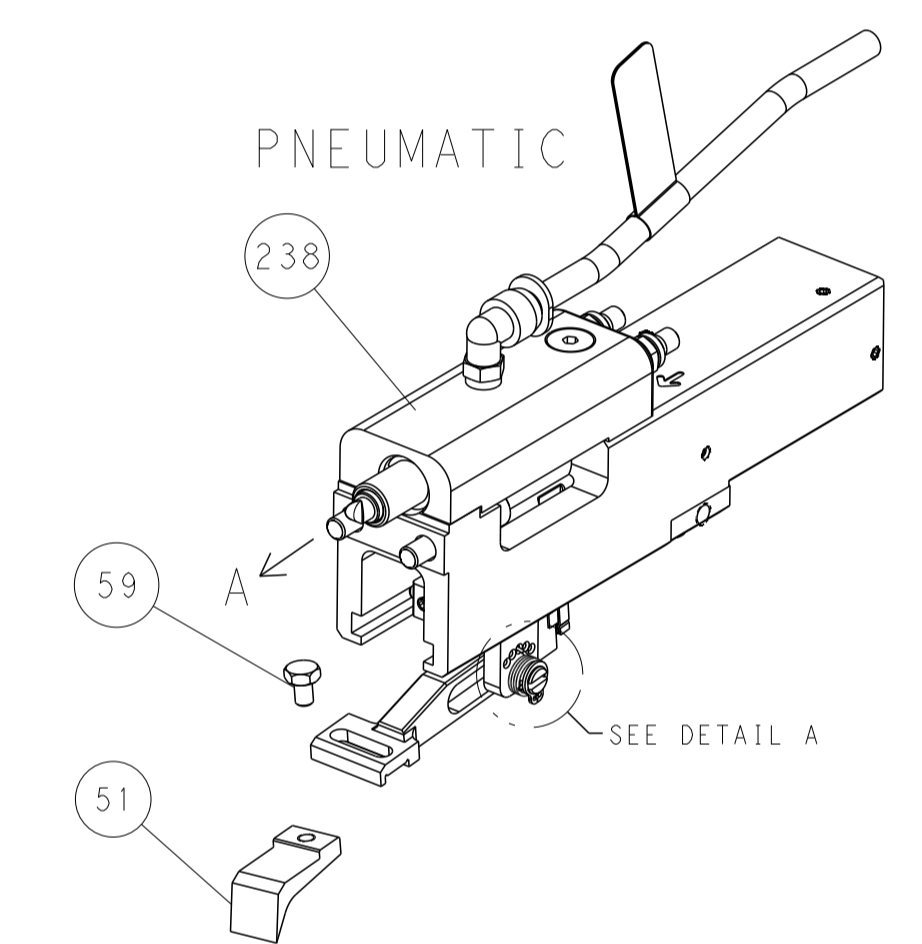
LOC	DIST	REVISIONS			
P	LTN	DESCRIPTION	DATE	DMN	APVD
A	66	SEE SHEET 1	-	-	-



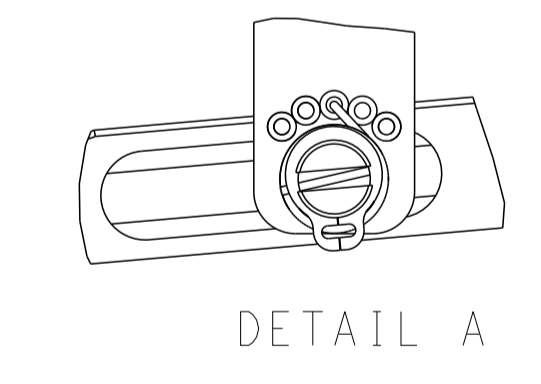
RAM AND HOLDDOWN SET-UP



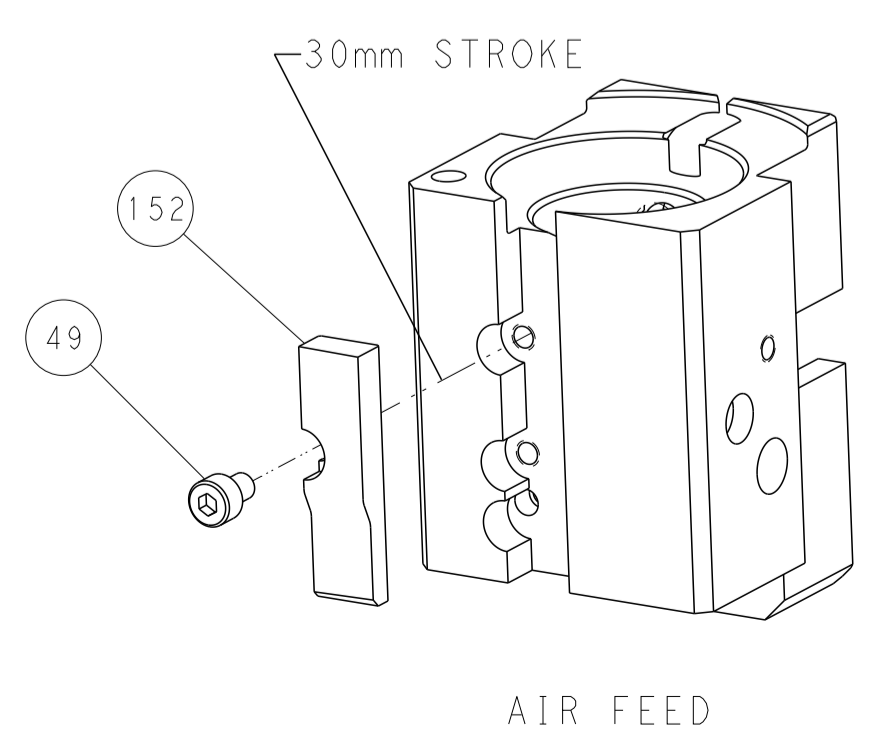
FEED TYPE



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)

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DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH ±	PRODUCT SPEC: APPLICATION SPEC: WEIGHT:	SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2150584	RESTRICTED TO:
MATERIAL:		SCALE: 1:1 SHEET: 4 OF 4 REV: C	Customer Accessible Production Drawing