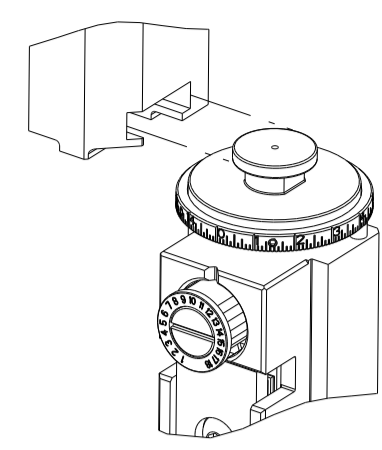


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150307-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2150307-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150307-1	C	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2150307-2	C	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150307-7	B	CRIMP TOOLING KIT	-

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: RING, AMPLIVAR		
WIRE STRIP LENGTH 4.78-4.78 mm [1.88-.188 IN]	INSULATION DIAMETER RANGE Ø3.18-4.19 mm [1.25-.165 IN]	
TERMINAL APPLICATION SPECIFICATION 114-2084		
TERMINALS APPLIED		
TE TERMINAL 60322-2	TE TERMINAL	TE TERMINAL

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
16 MAG	1.47+/-0.05 [1.058+/-0.002]	8.0
18 MAG	1.35+/-0.05 [1.053+/-0.002]	8.8
20 MAG	1.27+/-0.05 [1.050+/-0.002]	9.4

- 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 50. 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.

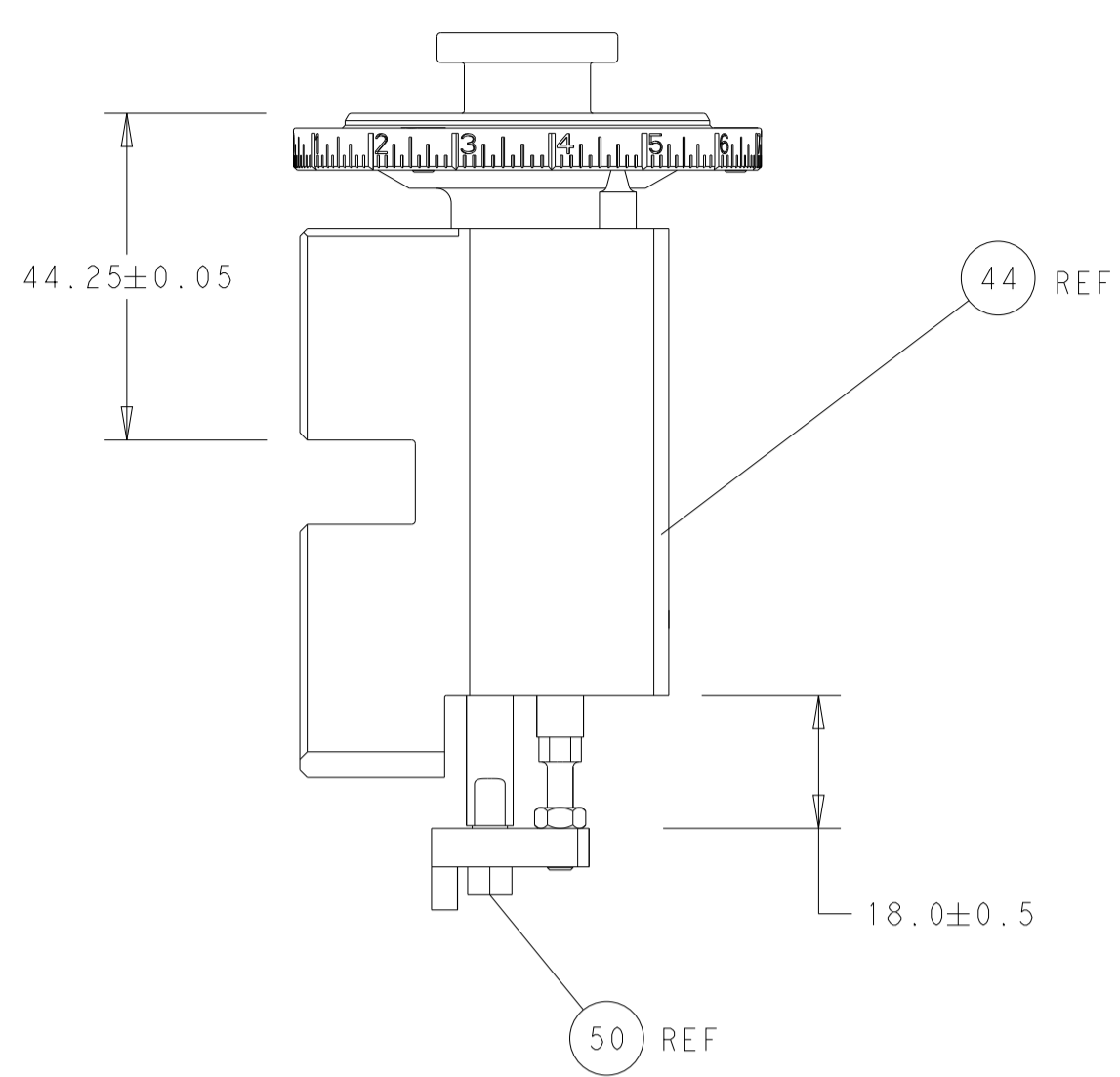
ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

LOC	DIST	REVISIONS					
		P	LTN	DESCRIPTION	DATE	OWN	APVD
A	66	A		RELEASED	03JUL2013	YY	UG
		B		ECR-17-018798	15JAN2018	MZ	KZ
		C		ECR-22-162304	29DEC2022	JWC	GB
		CI		ECR-23-173144	23APR2023	FZ	JAH

-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248	
-	1	1	1	1	2119082-9	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	-	2844940-3	AIR FEED MODULE	238	
-	1	1	1	1	1-18028-0	WASHER, FLAT, REG M8	192	
-	1	1	1	1	6-9931111-6	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	
-	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164	
-	1	1	1	1	455888-6	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	1-1901681-8	HOLDDOWN, TERMINAL	65	
-	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	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	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	-	2063961-1	FEED FINGER	51	
-	1	1	1	1	4-1752354-1	STANDOFF,HOLD-DOWN	50	
-	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	
-	8	8	8	8	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	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	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	1752371-1	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	1752360-1	SPACER,HOLD-DOWN	13	
-	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	1803064-1	ANVIL, COMBINATION	8	
-	1	1	1	1	2217206-7	BLADE, SLUG	7	
-	-	-	-	-	-	-	6	
-	1	1	1	1	4-240641-1	SPACER	5	
-	1	1	1	1	238011-3	BLOCK, CRIMPER SPACER	4	
-	1	2	2	1	1	7-1633961-2	CRIMPER, INSULATION F PREMIUM	3
-	1	1	1	1	455888-6	SPACER, CRIMPER	2	
-	1	2	2	1	1	5-456408-1	CRIMPER, WIRE PREMIUM	1
-	77	72	71	2	-1	PART NO	ITEM NO	

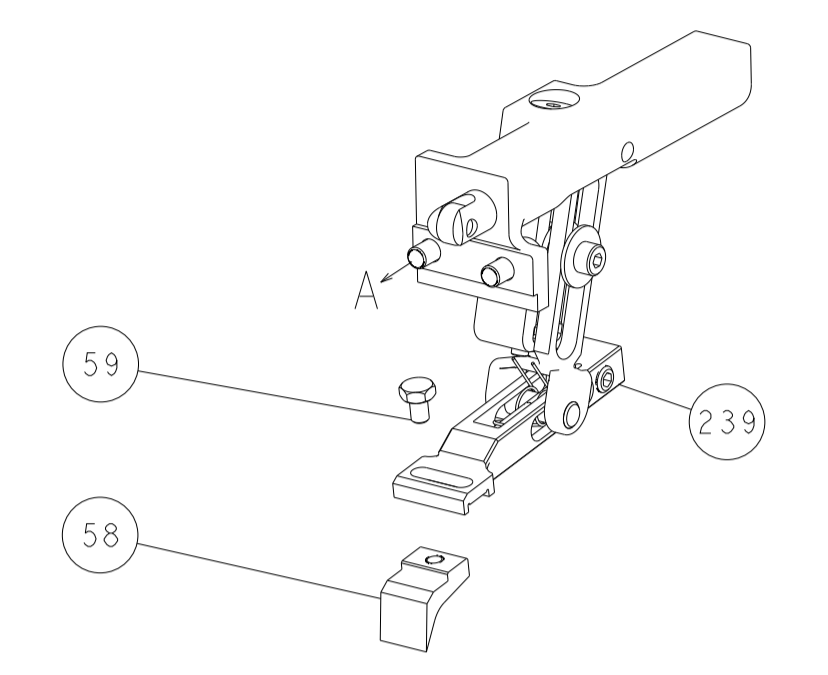
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mm		0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		CHK S. XI 09JAN2013		NAME Ocean End Feed Applicator	
MATERIAL		FINISH		APVD S. XI 09JAN2013		SIZE A1	
				PRODUCT SPEC		CAGE CODE 00779	
				APPLICATION SPEC		DRAWING NO 2150307	
				WEIGHT		RESTRICTED TO	
				Customer Accessible Production Drawing		SCALE 1:1 SHEET 1 OF 4 REV C1	

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

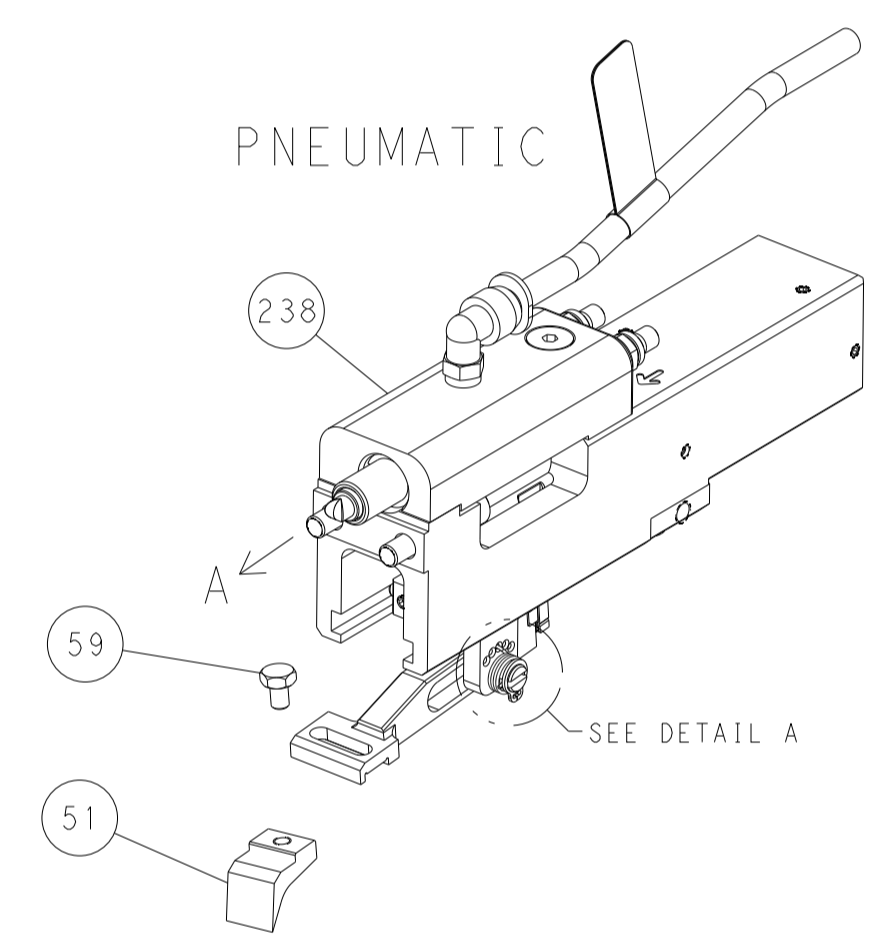


RAM AND HOLDDOWN SET-UP

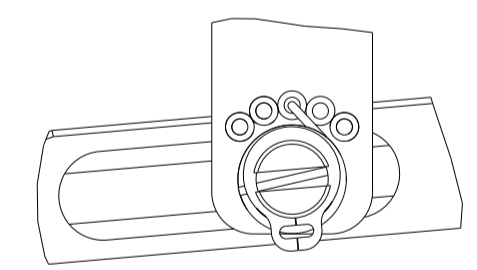
FEED TYPE
MECHANICAL



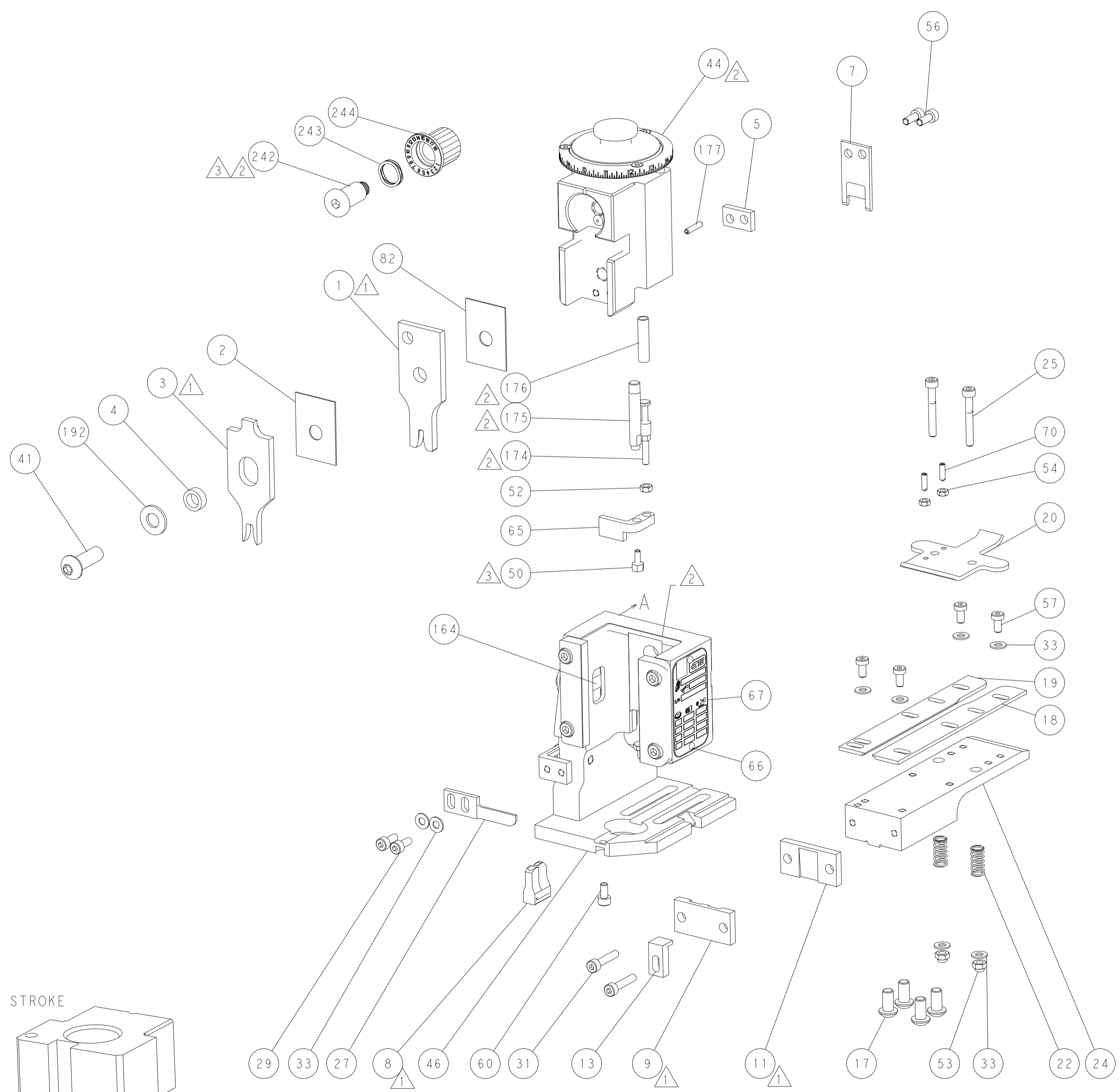
PNEUMATIC



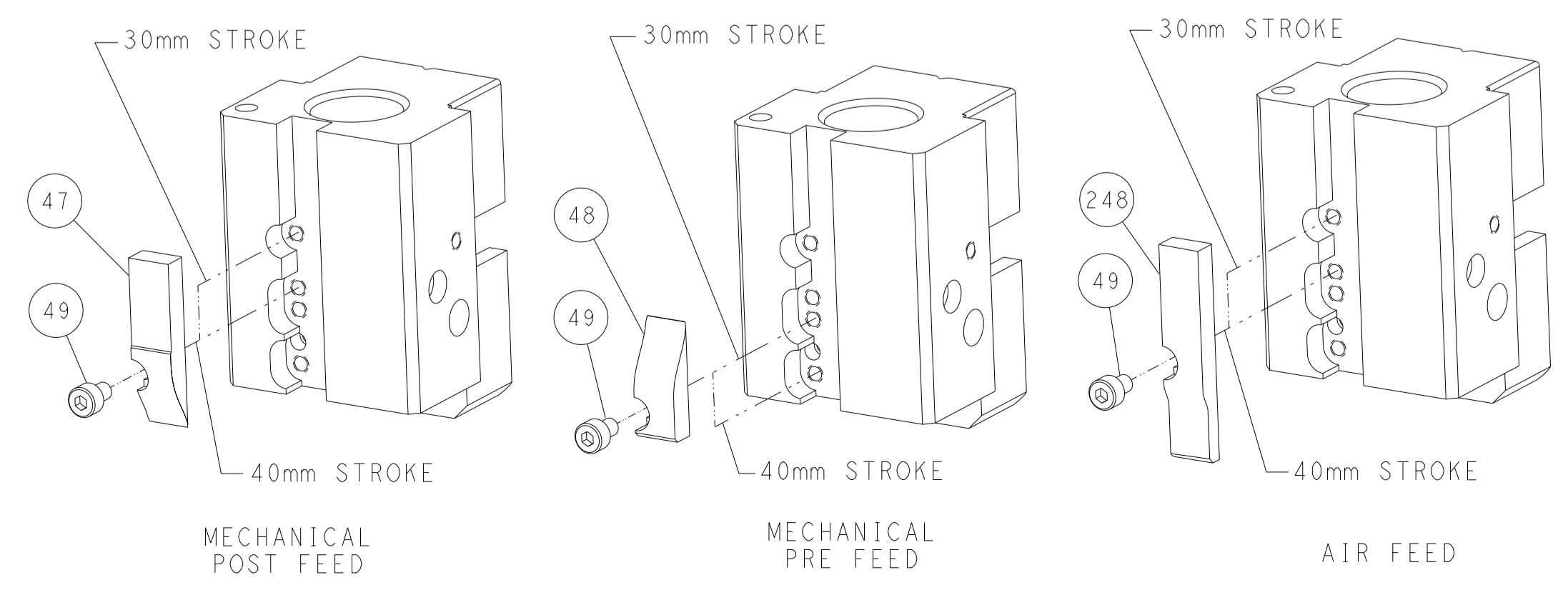
FEED SPRING
SETTING POSITION



DETAIL A



CAM POSITIONS

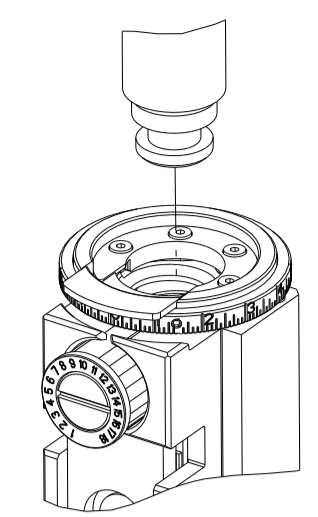


ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH		DWN K. HUANG 09JAN2013 CHK S. XI 09JAN2013 APVD S. XI 09JAN2013 PRODUCT SPEC APPLICATION SPEC WEIGHT Customer Accessible Production Drawing		NAME Ocean End Feed Applicator SIZE CAGE CODE DRAWING NO. A1 00779 ©=2150307 SCALE 1:1 SHEET 2 OF 4 REV C1		RESTRICTED TO TE Connectivity Harrisburg, PA 17105-3608	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150307-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2150307-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150307-7	B	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: RING, AMPLIVAR

WIRE STRIP LENGTH	INSULATION DIAMETER RANGE
4.78-4.78 mm [1.88-.188 IN]	3.18-4.19 mm [1.25-.165 IN]

TERMINAL APPLICATION SPECIFICATION 114-2084

TERMINALS APPLIED

TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
60322-2			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
16 MAG	1.47+/-0.05 [1.058+/-0.002]	8.0
18 MAG	1.35+/-0.05 [1.053+/-0.002]	8.8
20 MAG	1.27+/-0.05 [1.050+/-0.002]	9.4



- 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 50. 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.

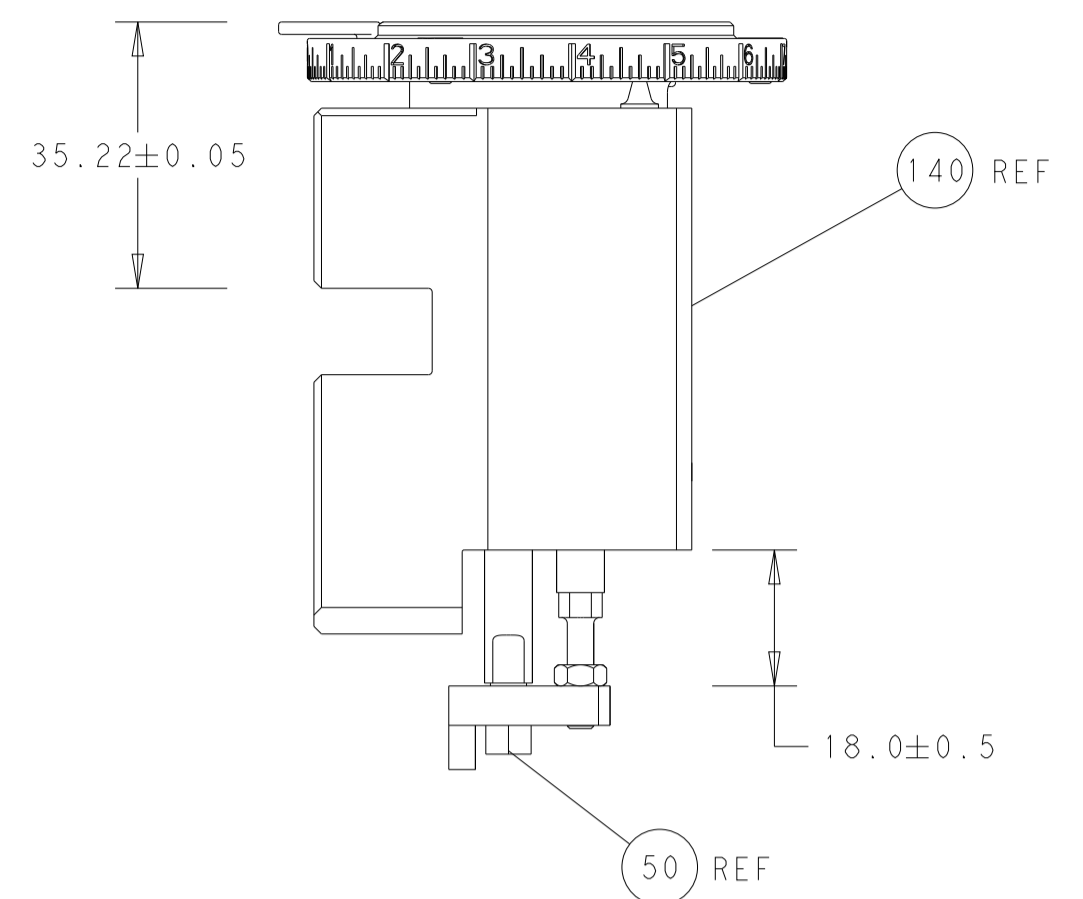
PACIFIC VERSION
 Shown on sheets 3 of 4 & 4 of 4
 (Atlantic version shown on sheets 1 of 4 & 2 of 4)

LOC	DIST	REV	DATE	BY	APPV
A	66				

QTY	REV	ITEM NO	DESCRIPTION	DATE	OWN	APPV
-	1	1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT		244
-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST		243
3	-	1	2119083-1	RETAINER, INSULATION DIAL		242
-	-	1	2119580-1	MECHANICAL FEED ASSEMBLY		239
-	1	-	2844940-3	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	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	-	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	455888-6	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	1-1901681-8	HOLDDOWN, TERMINAL		65
-	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	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10		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	-	2063961-1	FEED FINGER		51
3	-	1	4-1752354-1	STANDOFF,HOLD-DOWN		50
-	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
-	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	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10		29
-	1	1	240639-4	STRIPPER (MACHINING)		27
-	2	2	1-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 30		25
-	1	1	1752371-1	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	1752360-1	SPACER,HOLD-DOWN		13
1	-	1	240644-1	PLATE, REAR SHEAR		11
-	-	-	-	-		10
1	-	1	690482-5	PLATE, FRONT SHEAR		9
1	1	1	1803064-1	ANVIL, COMBINATION		8
1	-	1	2217206-7	BLADE, SLUG		7
-	-	-	-	-		6
-	1	1	4-240641-1	SPACER		5
-	1	1	238011-3	BLOCK, CRIMPER SPACER		4
1	1	1	7-1633961-2	CRIMPER, INSULATION F PREMIUM		3
-	1	1	455888-6	SPACER, CRIMPER		2
1	1	1	5-456408-1	CRIMPER, WIRE PREMIUM		1
-	77-22-21		PART NO	DESCRIPTION		ITEM NO

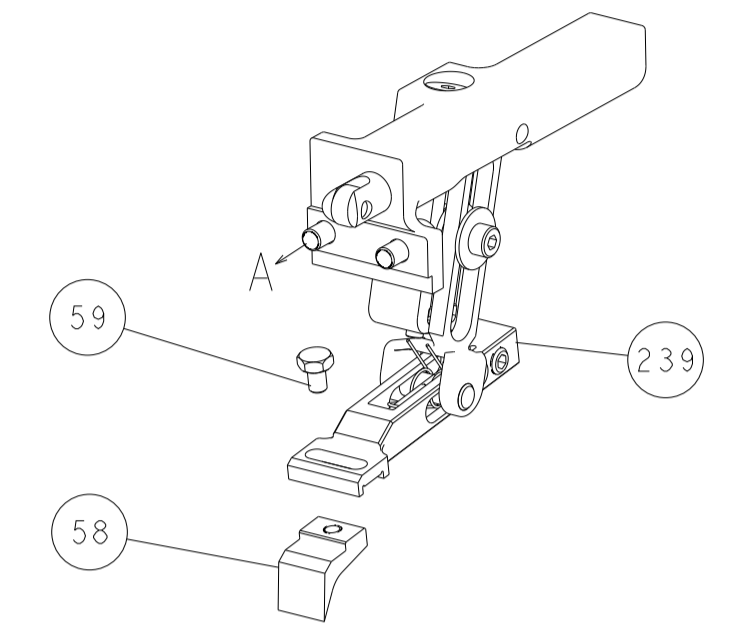
DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH		DWG: H. HUANG 09JAN2013 CHK: S. XI 09JAN2013 APPV: S. XI 09JAN2013 PRODUCT SPEC APPLICATION SPEC WEIGHT: - SCALE: 1:1 SHEET 3 OF 4 REV: C1		NAME: Ocean End Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2150307 RESTRICTED TO: -	
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LOC	DIST	REVISIONS			
P	LTN	DESCRIPTION	DATE	OWN	APVD
A	66	SEE SHEET 1			

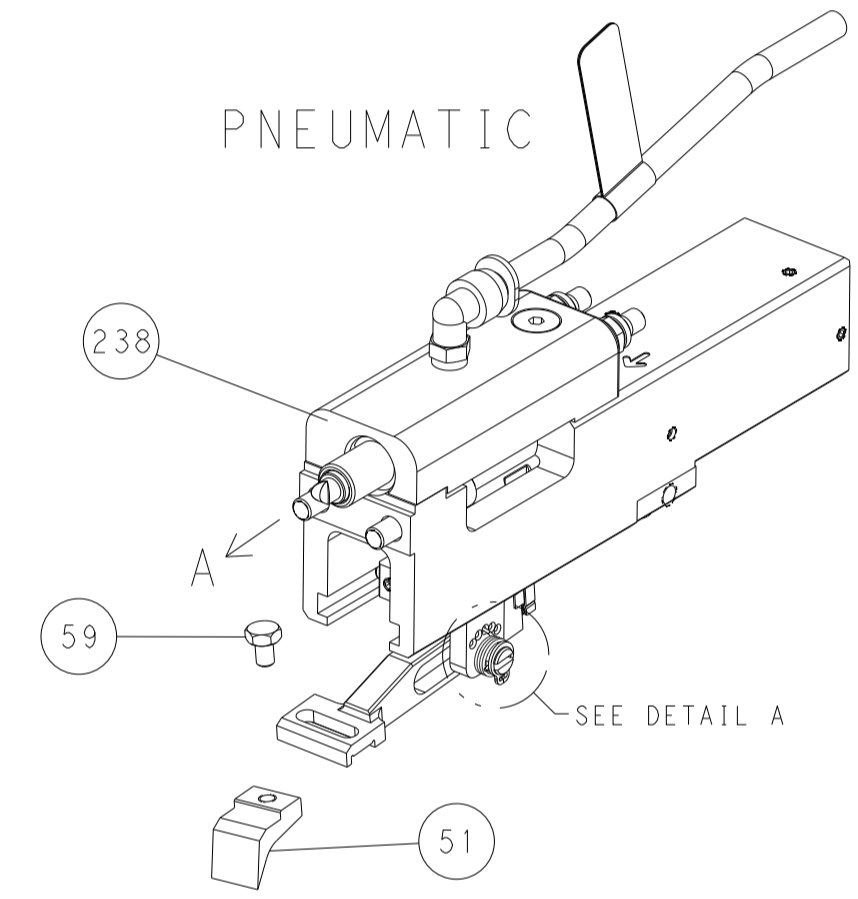


RAM AND HOLDDOWN SET-UP

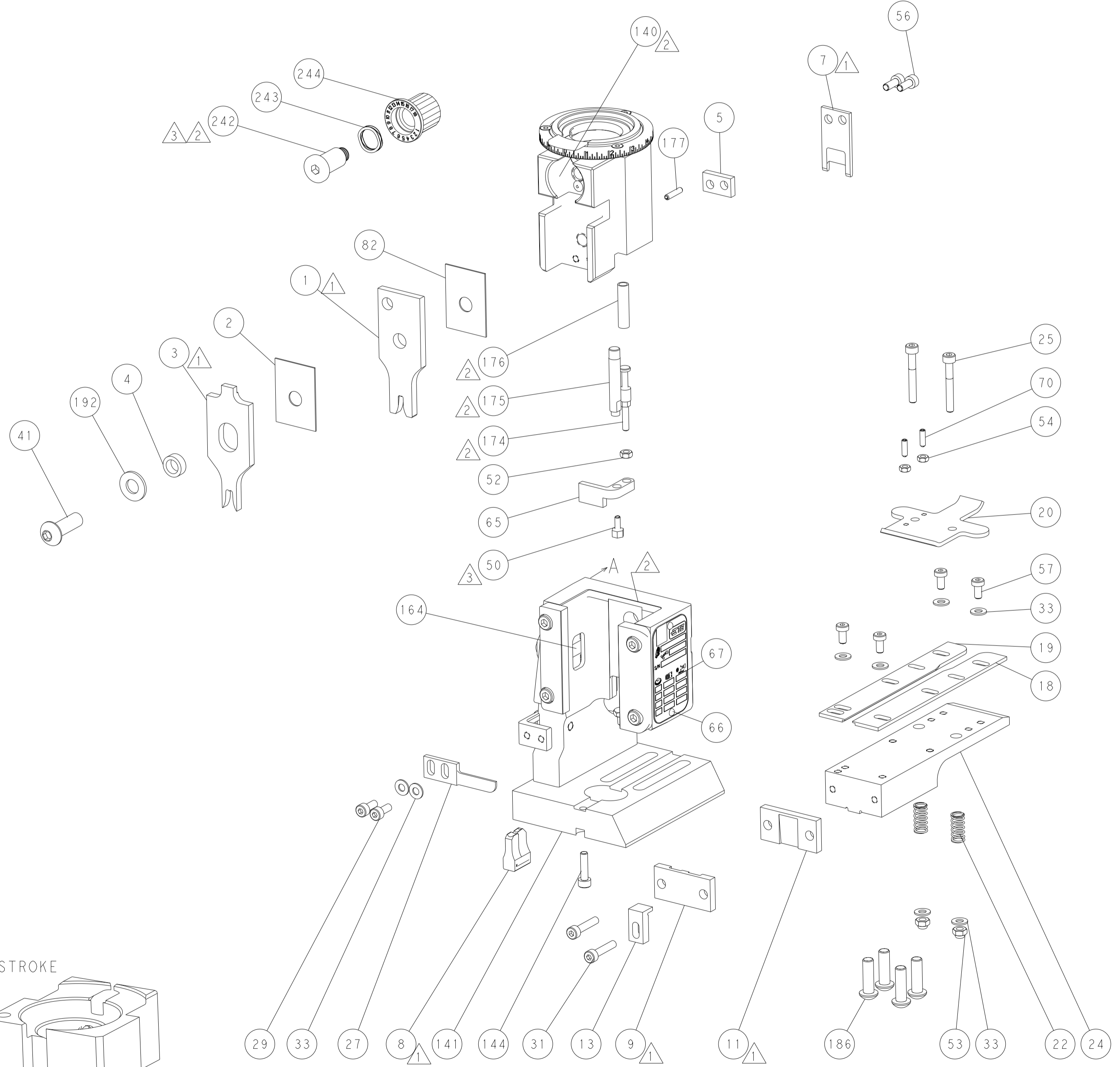
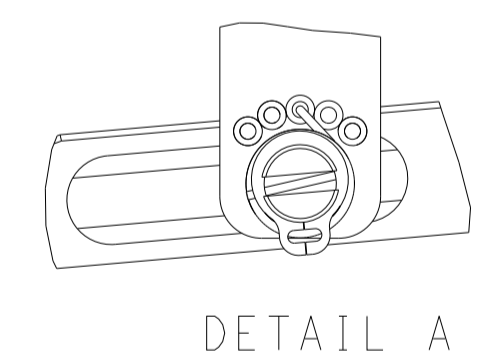
FEED TYPE
MECHANICAL



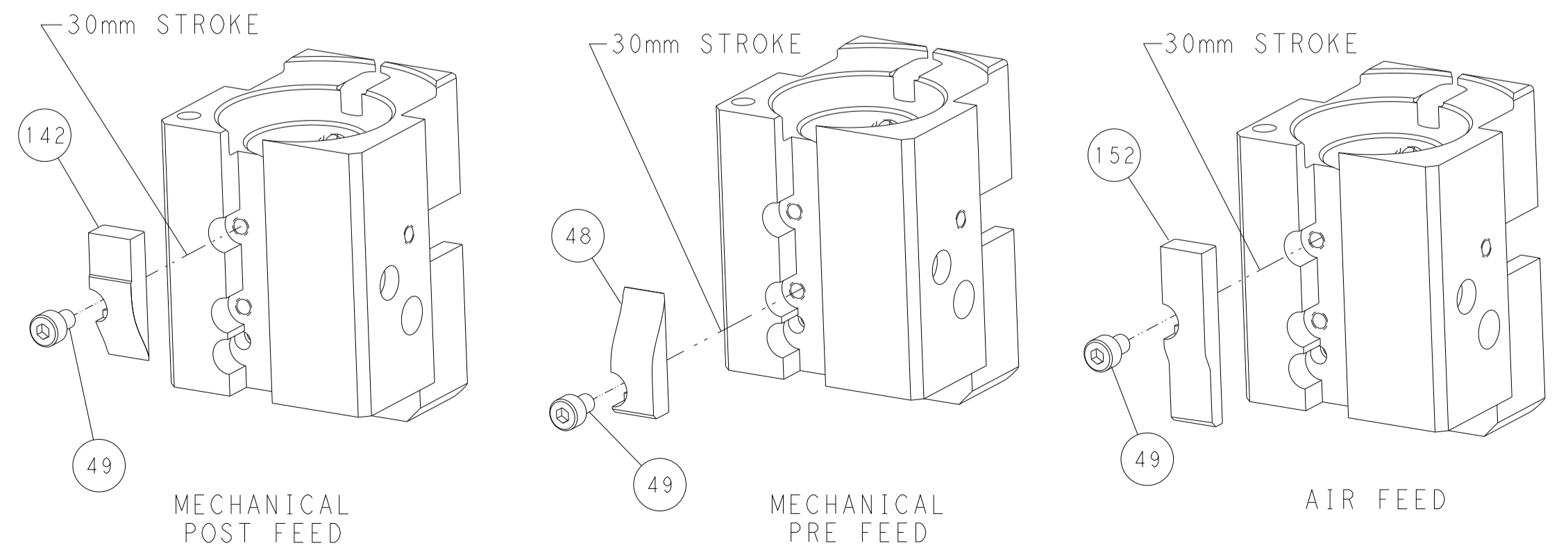
PNEUMATIC



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)

<small>THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.</small>		DWN: K. HUANG 09JAN2013 CHK: S. XI 09JAN2013 APVD: S. XI 09JAN2013	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=2150307 SCALE: 1:1 SHEET: 4 OF 4 REV: C1	RESTRICTED TO:
MATERIAL:		Customer Accessible Production Drawing	