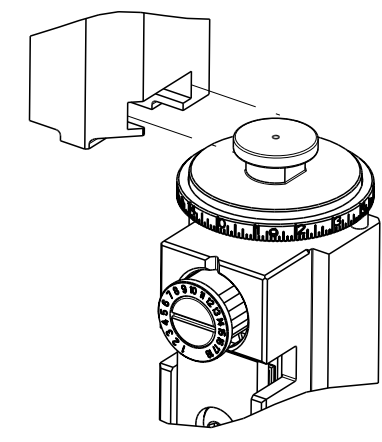


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150430-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2150430-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150430-1	C	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2150430-2	C	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150430-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	3.05 mm [.120]	F
INSUL	-	-
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL				TE CRIMP SPECIFICATION			
TERMINAL NAME: SPLICE							
WIRE STRIP LENGTH 5.11-6.12 mm [.201-.241 IN]				INSULATION DIAMETER RANGE Ø -			
TERMINAL APPLICATION SPECIFICATION 114-2088				-			
TERMINALS APPLIED							
TE TERMINAL 40868	TE TERMINAL 41397	TE TERMINAL 61492-1	TE TERMINAL 61492-3	TE TERMINAL 40504	TE TERMINAL -	TE TERMINAL -	TE TERMINAL -

TERMINAL DATA: TE TERMINAL				TE CRIMP SPECIFICATION			
TERMINAL NAME: SPLICE							
WIRE STRIP LENGTH 5.11-6.12 mm [.201-.241 IN]				INSULATION DIAMETER RANGE Ø -			
TERMINAL APPLICATION SPECIFICATION 114-2088				-			
TERMINALS APPLIED							
TE TERMINAL 40868	TE TERMINAL 41397	TE TERMINAL 61492-1	TE TERMINAL 61492-3	TE TERMINAL 40504	TE TERMINAL -	TE TERMINAL -	TE TERMINAL -

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
5250 AWG	2.02+/-0.05 [.080+/- .002]	3.9
2048 AWG	1.65+/-0.05 [.065+/- .002]	8.0

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
4700 CMA	1.96+/-0.05 [.077+/- .002]	4.6
2500 CMA	1.70+/-0.05 [.067+/- .002]	7.5

- 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 THE RECOMMENDED SET-UP FOR END FEED APPLICATORS IS POST-FEED WITH ITEM 2119653-1. THE APPLICATOR CAN BE CONFIGURED FOR PRE-FEED WITH ITEM 2119652-1 BUT MAY ENCOUNTER PROBLEMS WITH SOME APPLICATIONS. FEED ISSUES OR TERMINAL JAMMING MAY OCCUR IN THE PRE-FEED CONFIGURATION.
 - 5 REFER TO TERMINAL CUSTOMER DRAWING FOR CRIMP HEIGHT FORMULA TO CALCULATE SPECIFIC CRIMP HEIGHTS.
 - 6 POSITION ITEM 27 IN FRONT OF ITEM 1.
7. 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.

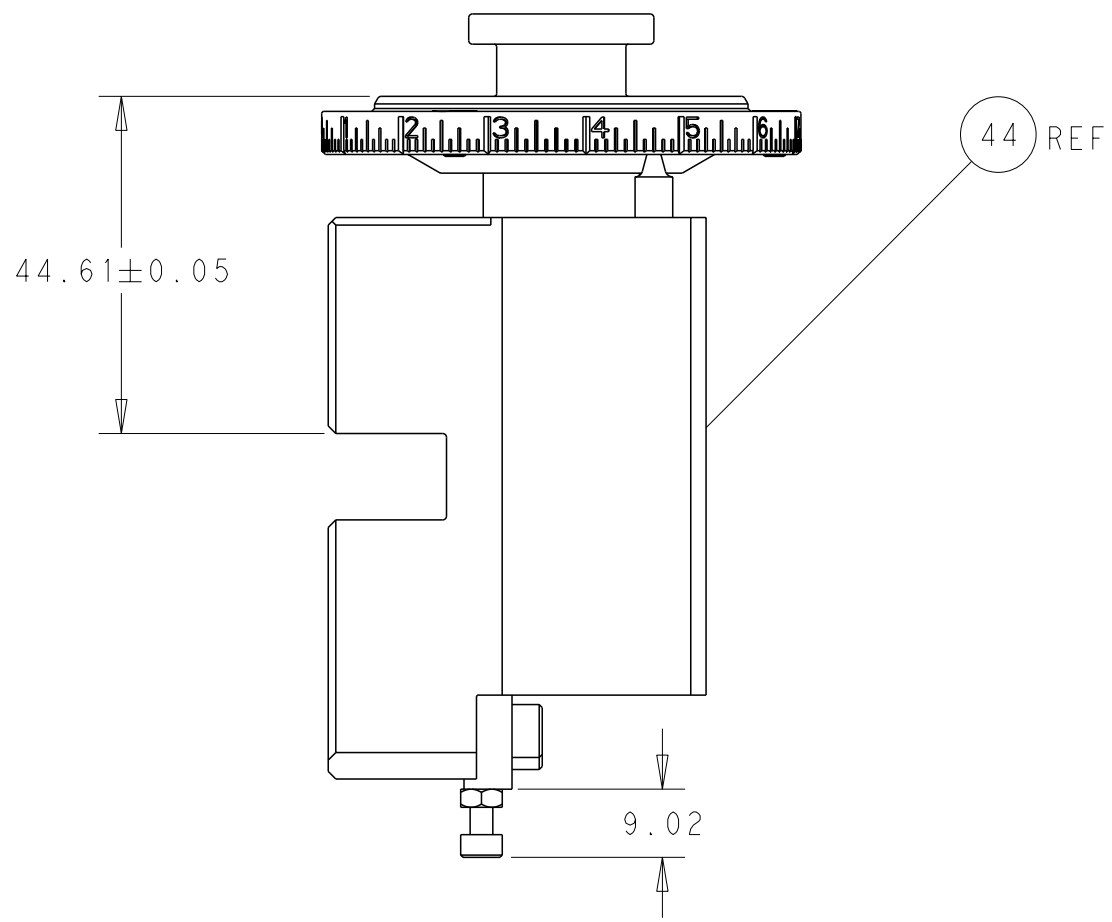
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

LOC	DIST	REVISIONS					
A	66	P	LYR	DESCRIPTION	DATE	OWN	APVD
		A1		ECR-18-008220	30MAY2018	YY	JDG
		B		ECR-19-017880	19NOV2019	FJ	TE
		B1		ECR-20-001142	23JAN2020	JAH	GB
		C		ECO-20-006459	05MAY2020	MEH	TE

-	1	1	1	1	1803078-2	SPACER, PRECISION	259	
-	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	
-	1	1	1	1	1803163-1	FLOATING SHEAR HOLDER	206	
-	2	2	2	2	1-2168083-1	SCR, SKT HD CAP, RoHS, M3 X 6	191	
-	2	2	2	2	2-22280-0	SPRING, COMPRESSION	180	
-	2	2	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	178	
-	1	1	1	1	356885-1	STOP, SHEAR	177	
-	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164	
-	2	2	2	2	1-18028-2	WASHER, FLAT, REG M4	119	
-	1	1	1	1	455888-8	SPACER, CRIMPER	82	
-	1	1	1	1	1803607-4	DOCUMENTATION PACKAGE	71	
-	2	2	2	2	3-18032-3	SCR, SET, FLT PNT, M3 X 20.0	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	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	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	-	1-2063961-0	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	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41	
-	8	8	8	8	1-18028-2	WASHER, FLAT, REG M4	33	
-	2	2	2	2	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	31	
-	2	2	2	2	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	29	
-	1	1	1	1	690455-1	STRIPPER, FRONT CASTING	27	
-	2	2	2	2	1-2168083-6	SCR, SKT HD CAP, RoHS, M4 X 35	25	
-	1	1	1	1	1803162-1	PLATE, STRIP GUIDE	24	
-	2	2	2	2	22281-8	SPRING, COMPRESSION	22	
-	1	1	1	1	1633168-1	ARM, STOCK DRAG	21	
-	1	1	1	1	464452-2	DRAG, STOCK	20	
-	2	2	2	2	1901259-5	GUIDE, LOWER STRIP	18	
-	4	4	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17	
-	1	1	1	1	1-2168083-3	SCR, SKT HD CAP, RoHS, M3 X 16	16	
-	1	1	1	1	5018030-1	NUT, HEX, REG, RoHS, M3	15	
-	-	-	-	-	-	-	11	
-	-	-	-	-	-	-	10	
-	-	-	-	-	-	-	9	
-	1	2	2	1	1	5-690618-1	ANVIL, SPLICE TYPE	8
-	1	1	1	1	1633722-1	SHEAR BLADE	7	
-	-	-	-	-	-	-	6	
-	1	1	1	1	690753-6	SPACER, TONKER	5	
-	-	-	-	-	-	-	4	
-	-	-	-	-	-	-	3	
-	-	-	-	-	-	-	2	
-	1	2	2	1	1	459736-5	CRIMPER, WIRE	1
-	77	72	71	2	1	PART NO	DESCRIPTION	ITEM NO

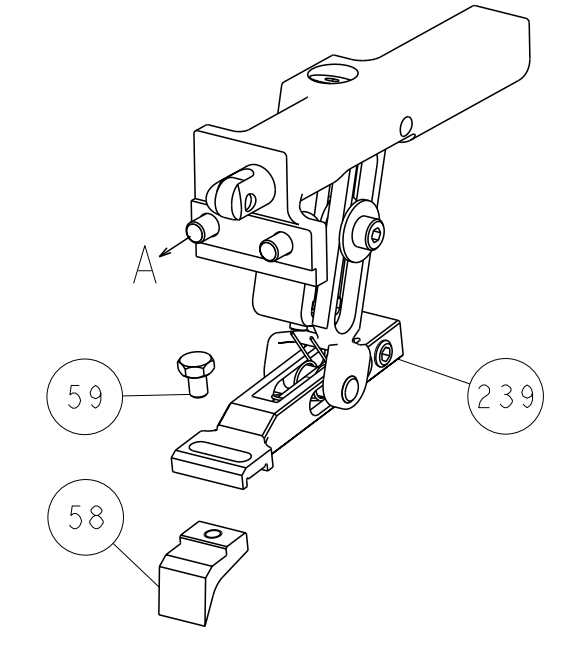
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		OWN		TE Connectivity	
mm		0 PLC ±		L GROSS 19MAY2014		Harrisburg, PA 17105-3608	
Ø		1 PLC ±		CHK 19MAY2014		NAME	
H		2 PLC ±		D STOUGH 19MAY2014		Ocean End Feed	
L		3 PLC ±		APVD T. ELBIN		Applicator	
R		4 PLC ±		PRODUCT SPEC		-	
S		5 PLC ±		APPLICATION SPEC		-	
T		FINISH		SIZE		RESTRICTED TO	
MATERIAL		-		A1		-	
-		-		WEIGHT		-	
-		-		SCALE		1:1	
-		-		SHEET		1 of 4	
-		-		REV		C	

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

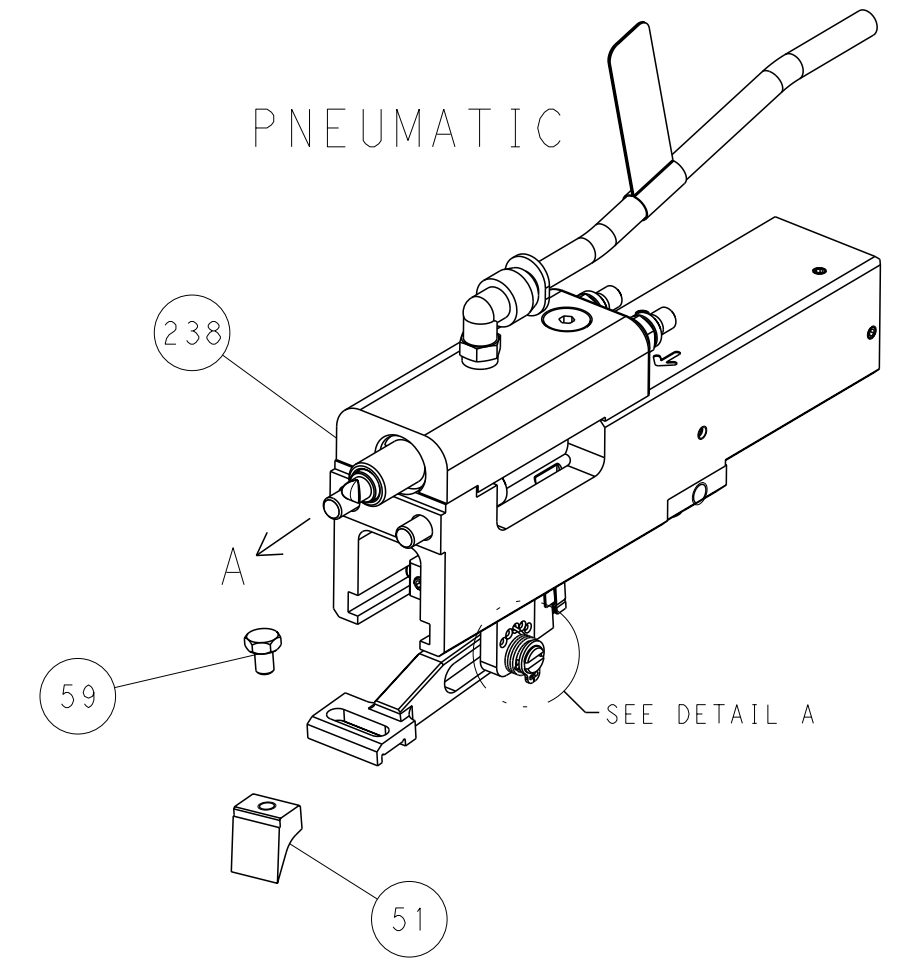


SHEAR TONKER SET UP

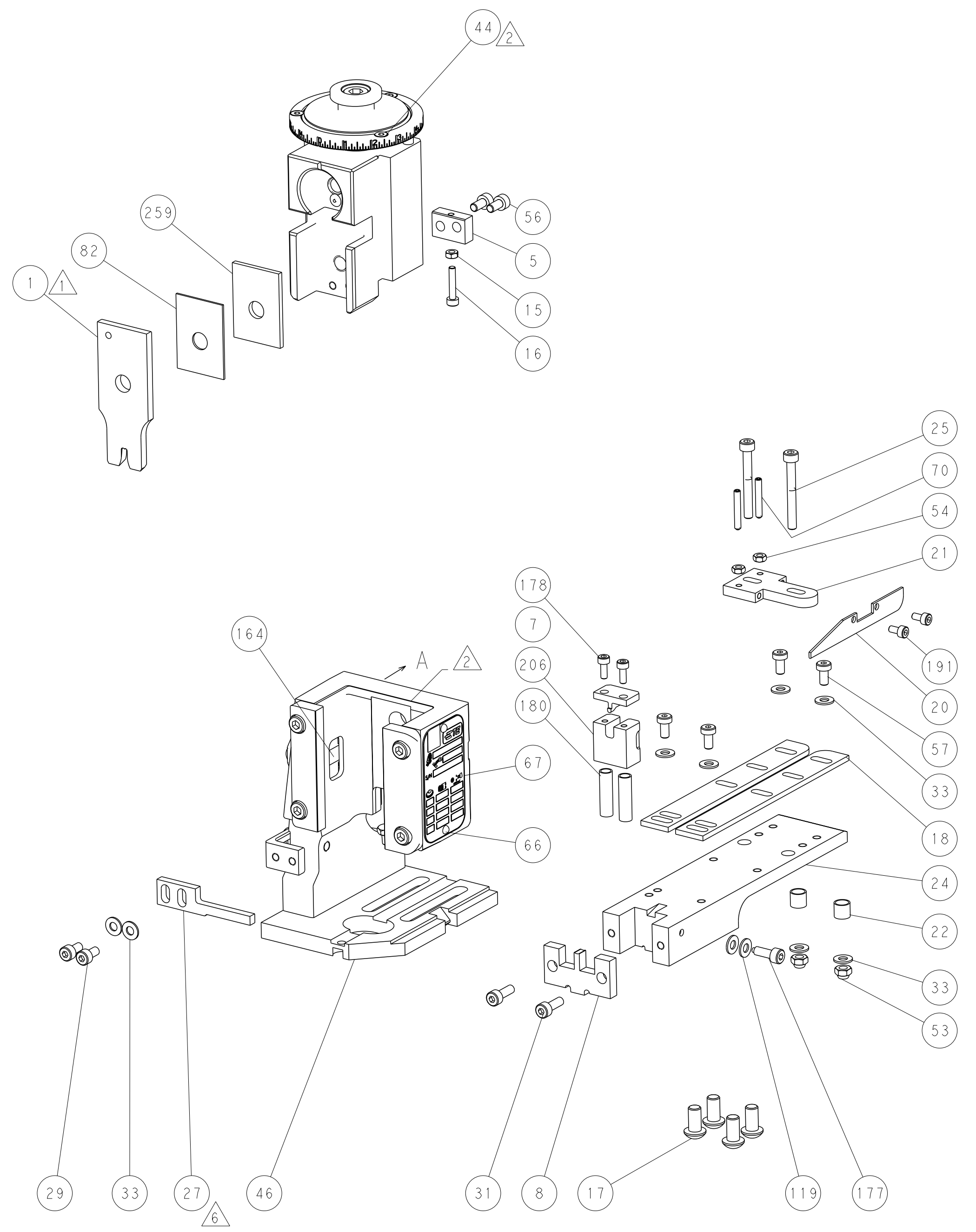
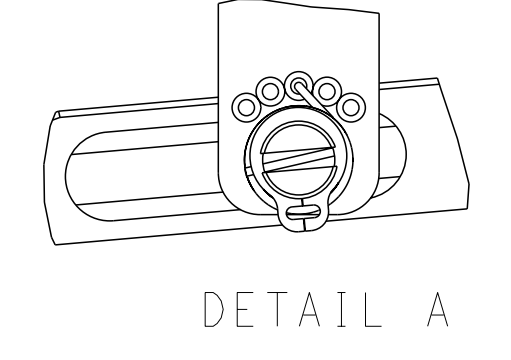
FEED TYPE
MECHANICAL



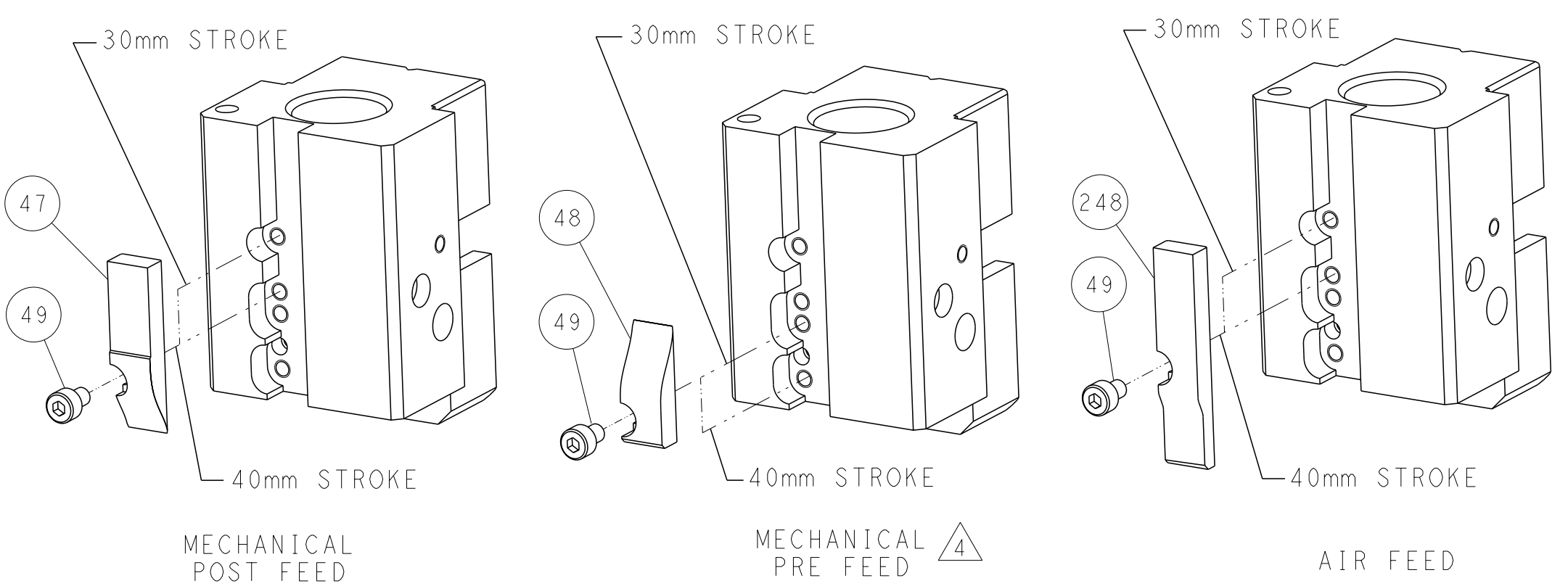
PNEUMATIC



FEED SPRING
SETTING POSITION



CAM POSITIONS

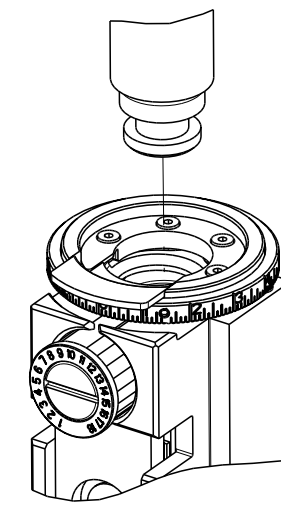


ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

<small>THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE AND TO CONTROL AND ENGINEERING DISCRETION SHOULD BE CONTACTED FOR THE LATEST REVISION.</small>		OWN: L. GROSS CHK: T. ELBIN APVD: D. STOUGH DATE: 19MAY2014 PRODUCT SPEC: 19MAY2014	NAME: Ocean End Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2150430	TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH ±	WEIGHT: - SCALE: 1:1 SHEET: 2 of 4 REV: C	Customer Accessible Production Drawing		

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150430-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2150430-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150430-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	3.05 mm [.120]	F
INSUL	-	-
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: SPLICE			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
5.11-6.12 mm [.201-.241 IN]		∅ -	
TERMINAL APPLICATION SPECIFICATION	114-2088	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
40868	41397	61492-1	61492-3

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: SPLICE			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
5.11-6.12 mm [.201-.241 IN]		∅ -	
TERMINAL APPLICATION SPECIFICATION	114-2088	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
40504	-	-	-

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
4700 CMA	1.96+/-0.05 [.077+/- .002]	4.6
2500 CMA	1.70+/-0.05 [.067+/- .002]	7.5

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
5250 AWG	2.02+/-0.05 [.080+/- .002]	3.9
2048 AWG	1.65+/-0.05 [.065+/- .002]	8.0

- 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 THE RECOMMENDED SET-UP FOR END FEED APPLICATORS IS POST-FEED WITH ITEM 2119653-1. THE APPLICATOR CAN BE CONFIGURED FOR PRE-FEED WITH ITEM 2119652-1 BUT MAY ENCOUNTER PROBLEMS WITH SOME APPLICATIONS. FEED ISSUES OR TERMINAL JAMMING MAY OCCUR IN THE PRE-FEED CONFIGURATION.
 - 5 REFER TO TERMINAL CUSTOMER DRAWING FOR CRIMP HEIGHT FORMULA TO CALCULATE SPECIFIC CRIMP HEIGHTS.
 - 6 POSITION ITEM 27 IN FRONT OF ITEM 1.
7. 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.

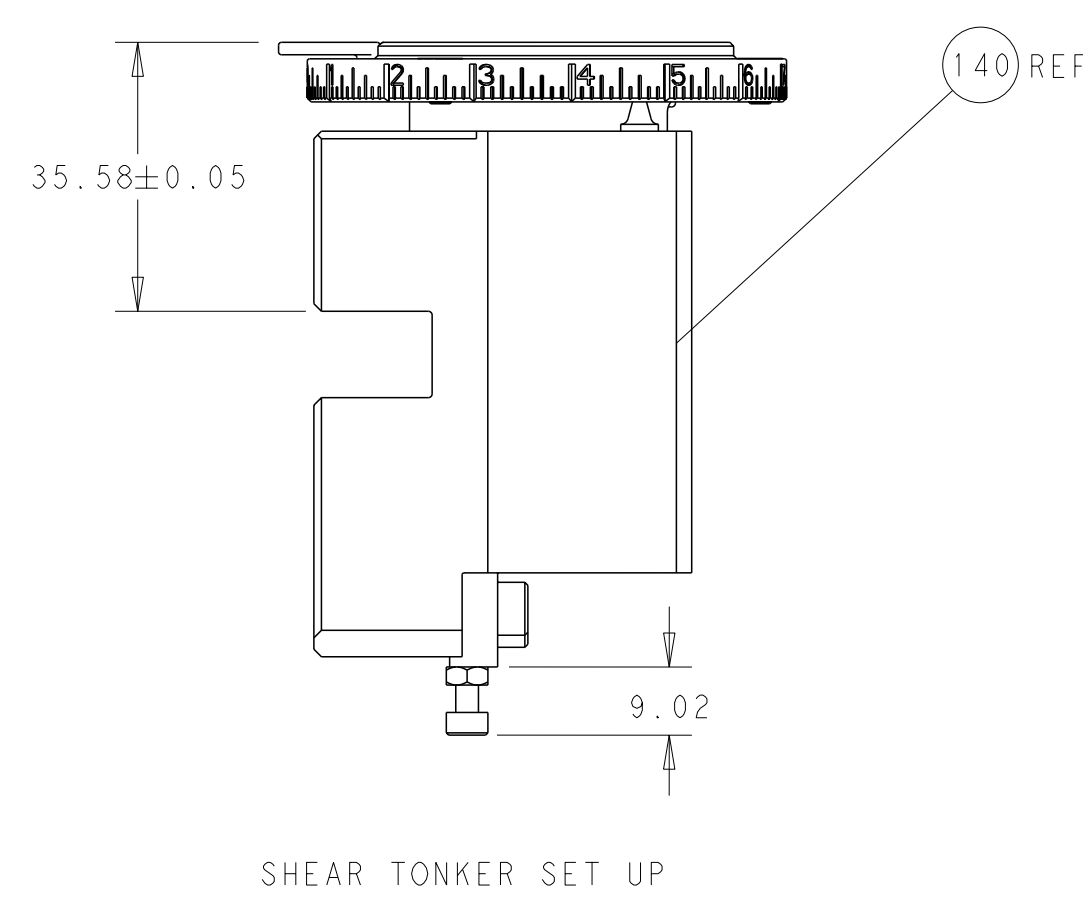
PACIFIC VERSION
Shown on sheets 3 of 4 & 4 of 4
(Atlantic version shown on sheets 1 of 4 & 2 of 4)

LOC	DIST	REVISIONS					
		P	LYR	DESCRIPTION	DATE	OWN	APVD
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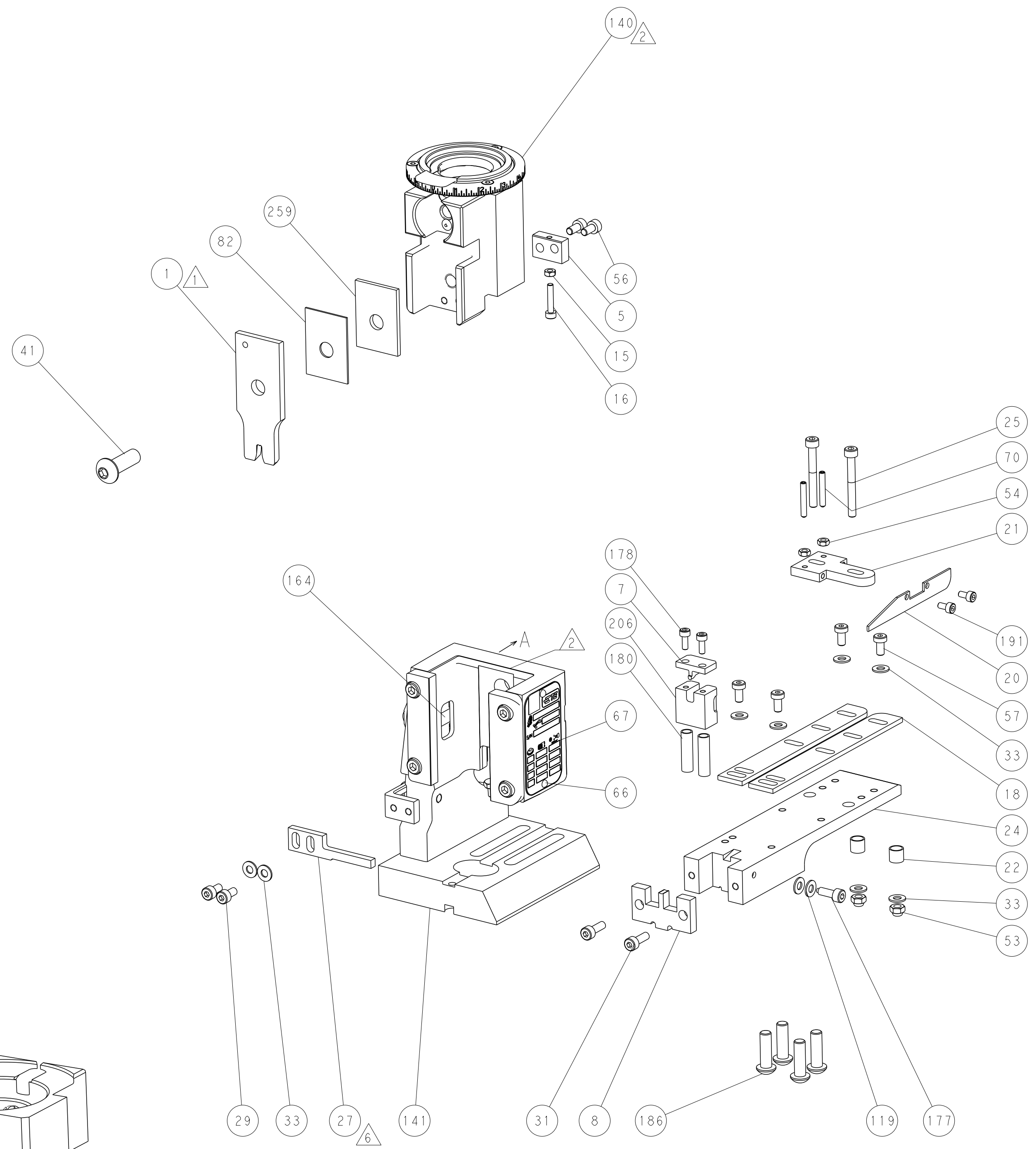
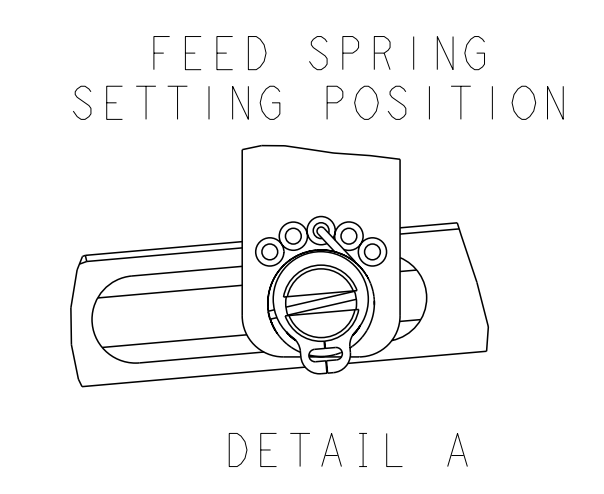
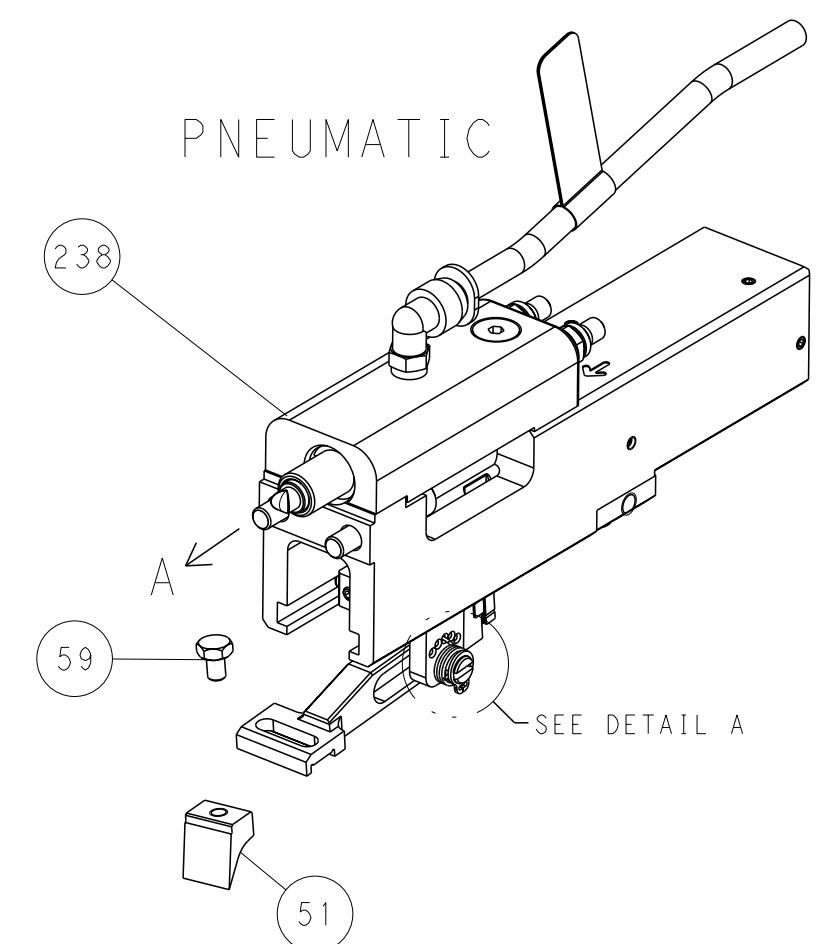
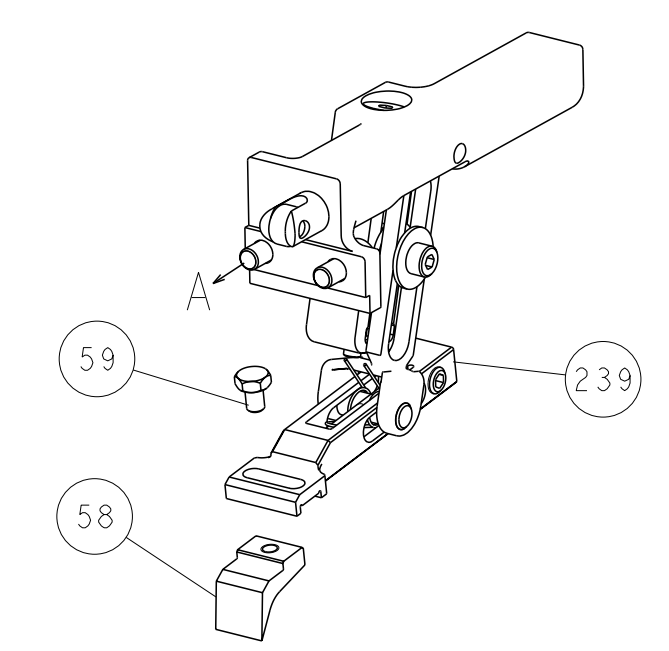
-	1	1	1803078-2	SPACER, PRECISION	259	
-	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239	
-	1	-	2844940-3	AIR FEED MODULE	238	
-	1	1	1803163-1	FLOATING SHEAR HOLDER	206	
-	2	2	1-2168083-1	SCR, SKT HD CAP, RoHS, M3 X 6	191	
-	4	4	2079383-9	SCR, BHSC, RoHS (M6 X 20)	186	
-	2	2	2-22280-0	SPRING, COMPRESSION	180	
-	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	178	
-	1	1	356885-1	STOP, SHEAR	177	
-	REF	REF	994970-2	COUNTER, MAGNETIC	164	
-	1	-	2119641-2	FEED CAM, AIR FEED	152	
-	-	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	
-	2	2	1-18028-2	WASHER, FLAT, REG M4	119	
-	1	1	455888-8	SPACER, CRIMPER	82	
-	1	1	1803607-4	DOCUMENTATION PACKAGE	71	
-	2	2	3-18032-3	SCR, SET, FLT PNT, M3 X 20.0	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	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	-	1-2063961-0	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	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41	
-	8	8	1-18028-2	WASHER, FLAT, REG M4	33	
-	2	2	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	31	
-	2	2	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	29	
-	1	1	690455-1	STRIPPER, FRONT CASTING	27	
-	2	2	1-2168083-6	SCR, SKT HD CAP, RoHS, M4 X 35	25	
-	1	1	1803162-1	PLATE, STRIP GUIDE	24	
-	2	2	22281-8	SPRING, COMPRESSION	22	
-	1	1	1633168-1	ARM, STOCK DRAG	21	
-	1	1	464452-2	DRAG, STOCK	20	
-	2	2	1901259-5	GUIDE, LOWER STRIP	18	
-	1	1	1-2168083-3	SCR, SKT HD CAP, RoHS, M3 X 16	16	
-	1	1	5018030-1	NUT, HEX, REG, RoHS, M3	15	
-	-	-	-	-	11	
-	-	-	-	-	10	
-	-	-	-	-	9	
-	1	1	1	5-690618-1	ANVIL, SPLICE TYPE	8
-	1	1	1	1633722-1	SHEAR BLADE	7
-	-	-	-	-	6	
-	1	1	1	690753-6	SPACER, TONKER	5
-	-	-	-	-	4	
-	-	-	-	-	3	
-	-	-	-	-	2	
-	1	1	1	459736-5	CRIMPER, WIRE	1
-	77-22-21	-	-	PART NO	DESCRIPTION	ITEM NO

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		OWN		TE Connectivity	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	5 PLC ±	Harrisburg, PA 17105-3608
	ANGLES	FINISH	APVD	DATE	NAME	Ocean End Feed Applicator	
MATERIAL			D. STOUGH	19MAY2014		SIZE	CAGE CODE DRAWING NO
			APPLICATION SPEC			A1	00779 ©=2150430
			WEIGHT			SCALE	1:1 SHEET 3 OF 4 REV C
						Customer Accessible Production Drawing	

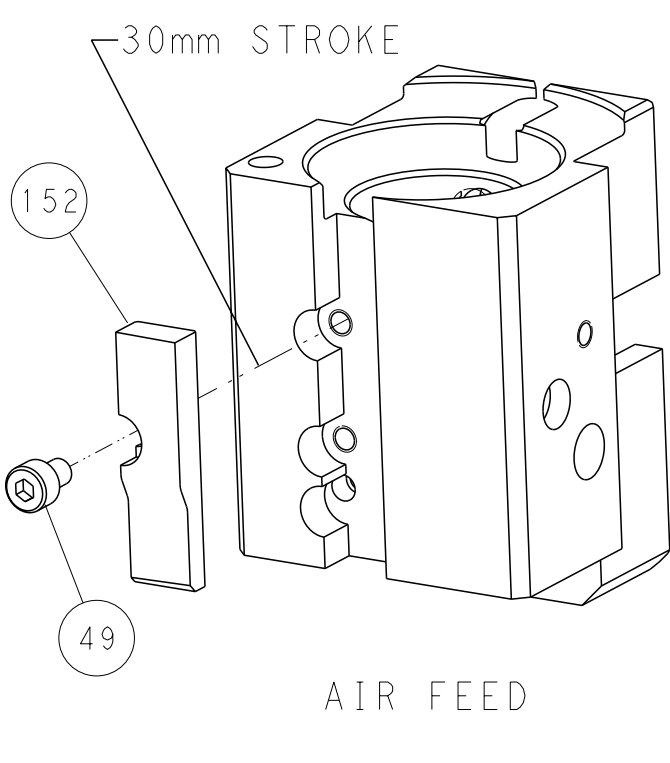
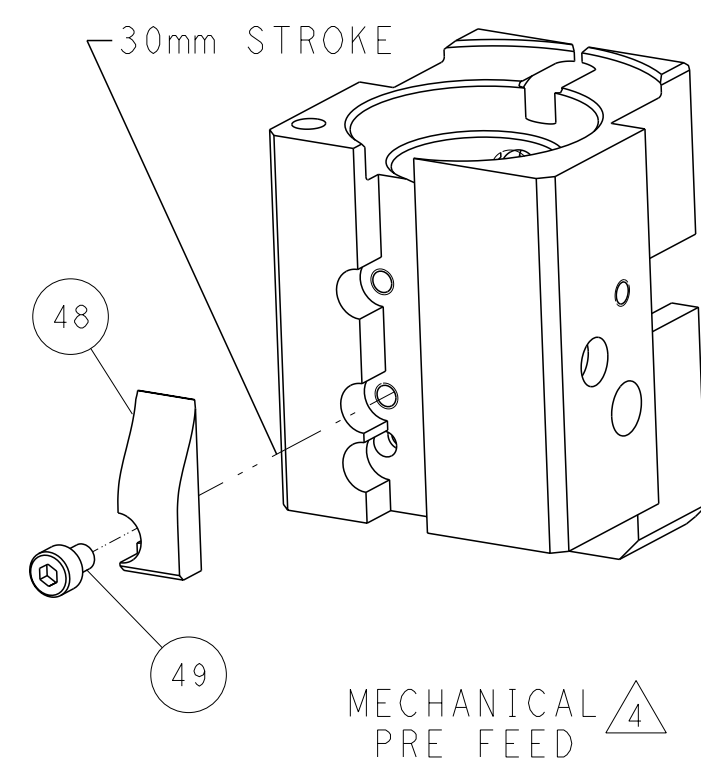
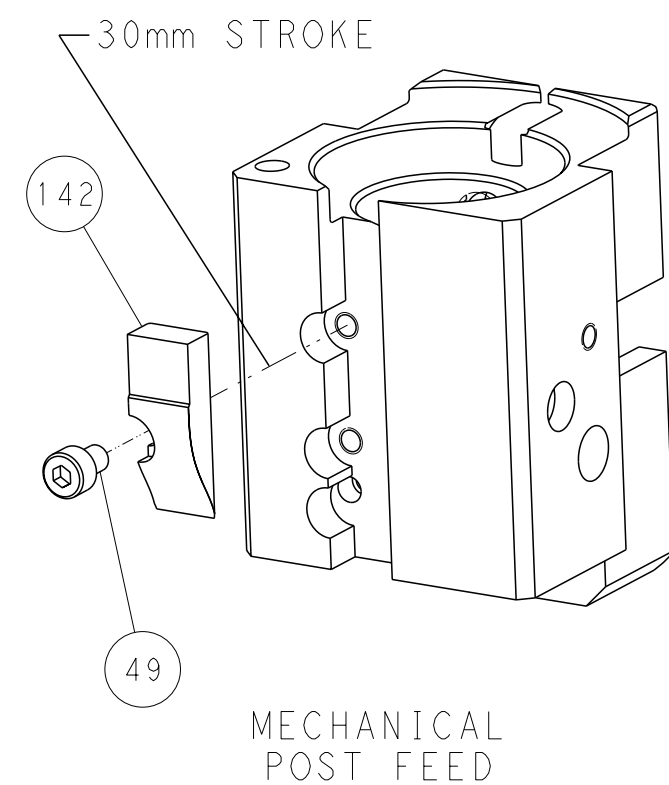
LOC		DIST		REVISIONS			
A	66	P	LYR	DESCRIPTION	DATE	OWN	APVD
		-		SEE SHEET 1	-	-	-



FEED TYPE MECHANICAL



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:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		OWN		TE Connectivity	
mm	0 PLC ±	1 PLC ±	2 PLC ±	EL GROSS	19MAY2014	Harrisburg, PA 17105-3608	
	3 PLC ±	4 PLC ±	ANGLES FINISH *	CHK T. ELBIN	19MAY2014	NAME	
MATERIAL				APVD D. STOUGH	19MAY2014	Ocean End Feed Applicator	
				PRODUCT SPEC		SIZE	RESTRICTED TO
				APPLICATION SPEC		CAGE CODE	DRAWING NO
				WEIGHT		A1 00779	©=2150430
				Customer Accessible Production Drawing	SCALE 1:1	SHEET 4	REV C