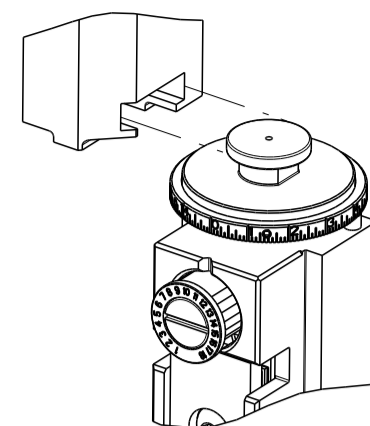


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150519-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150519-2	B	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150519-7	A	CRIMP TOOLING KIT	-

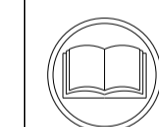
ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.54 mm [.100]	F
INSUL	3.94 mm [.155]	F
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: GMG TERMINAL GMG CRIMP SPECIFICATION			
TERMINAL NAME: FASTIN-ON 6.3 X 0.8			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
5.20-5.96 mm [.205-.235 IN]		Ø 4.00 mm MAX [.157 IN MAX]	
TERMINAL APPLICATION SPECIFICATION	31002.52.08.1 Rev 01	-	-
TERMINALS APPLIED			
TE TERMINAL	GMG TERMINAL	TE TERMINAL	GMG TERMINAL
2113640-1	31002.52.00.1	2113640-3	31002.52.08.1
2113640-2	31002.52.02.1		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
2.50mm2	1.85 +/- 0.05 [.073 +/- .002]	3.9
1.00mm2	1.75 +/- 0.05 [.069 +/- .002]	4.5



- △ 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.

**\*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)

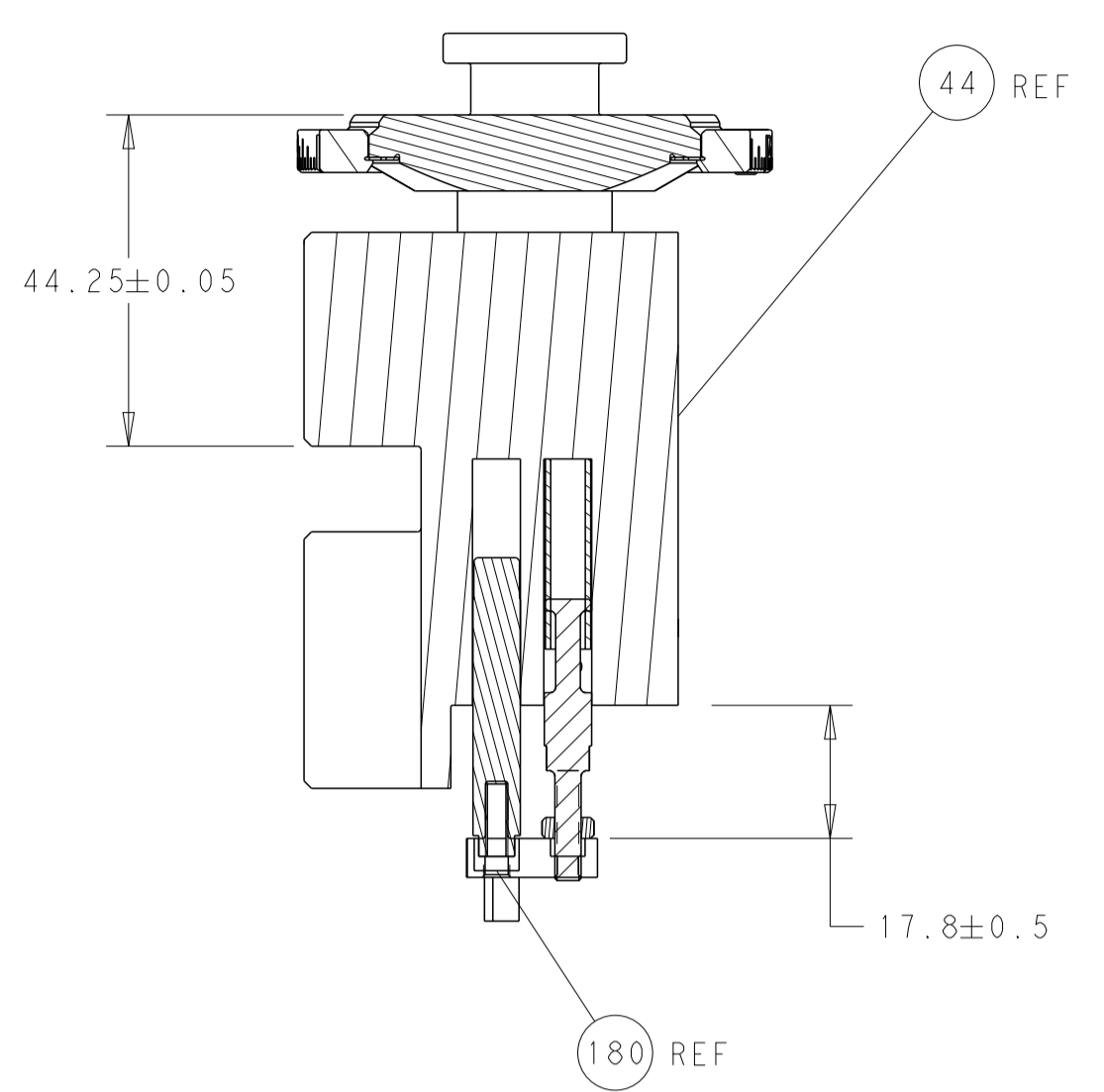
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		A		RELEASED	02FEB2015	MR	GB
		B		ECR-23-165717	08FEB2023	FZ	TE

-	1	1	2119641-1	FEED CAM, AIR FEED	248	
-	1	1	2119082-7	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	1752354-2	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	455888-4	SPACER, CRIMPER	82	
-	1	1	2119791-5	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	1976052-1	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	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	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	2063961-1	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	1752371-2	PLATE, STRIP GUIDE	24	
-	2	2	2-22281-3	SPRING, COMPRESSION	22	
-	1	1	1803292-4	DRAG	20	
-	1	1	1901696-5	STRIP GUIDE, REAR	19	
-	1	1	1901695-5	STRIP GUIDE, FRONT	18	
-	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17	
-	1	1	5-240641-9	SPACER	16	
-	1	1	1752360-1	SPACER, HOLD-DOWN	13	
△	1	1	1-240644-1	PLATE, REAR SHEAR	11	
-	-	-	-	-	10	
△	1	1	5-690482-1	PLATE, FRONT SHEAR	9	
△	1	2	1	6-1803001-9	ANVIL, COMBINATION, END FEED	8
△	1	1	1	1-2217206-0	BLADE, SLUG	7
-	-	-	-	-	6	
-	1	1	1	7-240641-3	SPACER	5
-	1	1	1	6-238011-7	BLOCK, CRIMPER SPACER	4
△	1	2	1	9-1633961-0	CRIMPER, INSULATION F PREMIUM	3
-	1	1	1	455888-6	SPACER, CRIMPER	2
△	1	2	1	3-456407-1	CRIMPER, WIRE PREMIUM	1
-	77	72	-2	PART NO	DESCRIPTION	ITEM NO

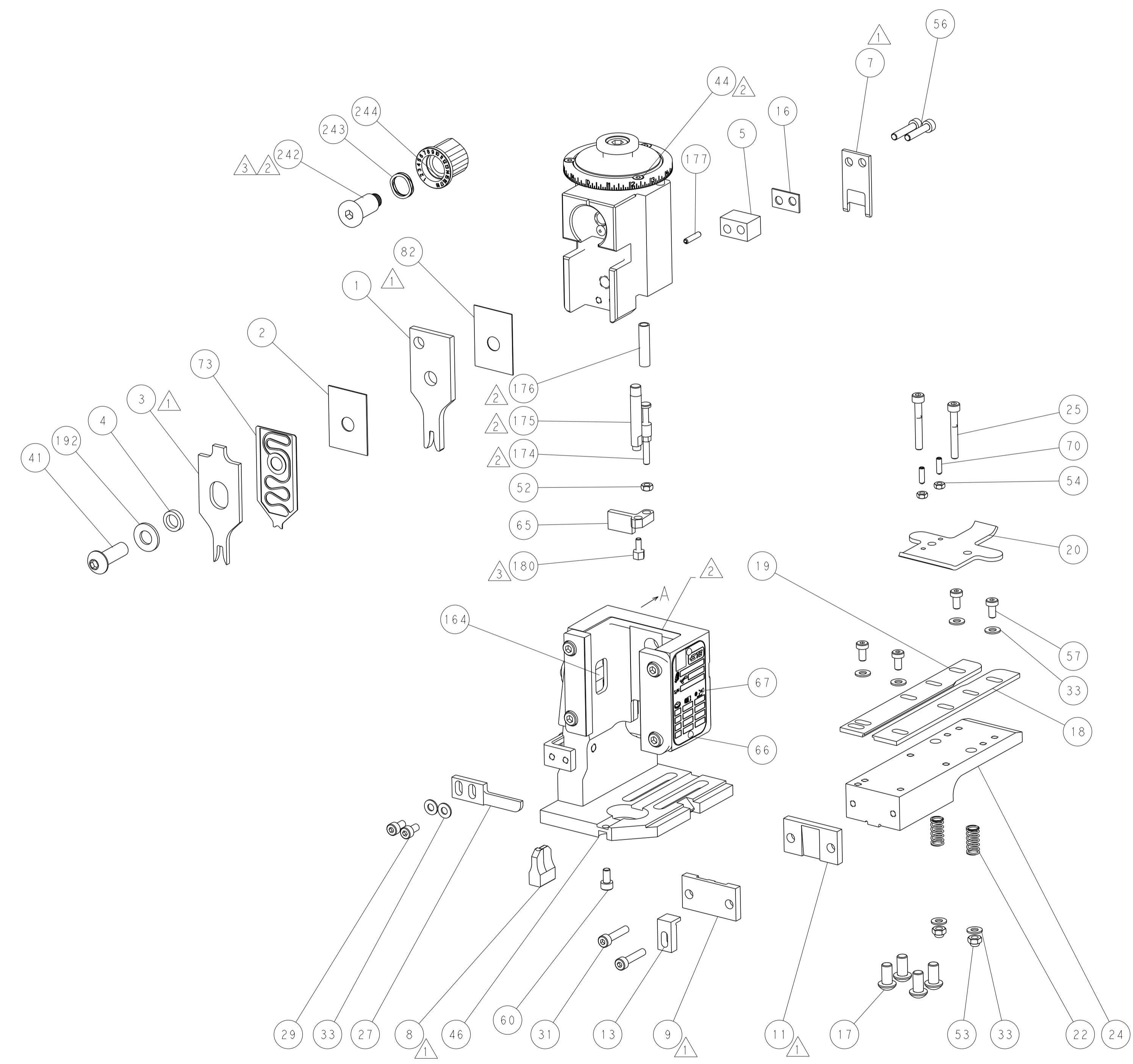
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mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES	FINISH
MATERIAL:		FINISH:		WEIGHT:		SCALE:	
-		-		-		-	

OWN	H. HUANG	07JAN2015	 TE Connectivity Harrisburg, PA 17105-3608
CHK	L. ZHANG	07JAN2015	
APVD	J. GUO	07JAN2015	
PRODUCT SPEC	-		
APPLICATION SPEC	-		
SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
A1	00779	2150519	-
Customer Accessible Production Drawing			SHEET 1 OF 4 REV B

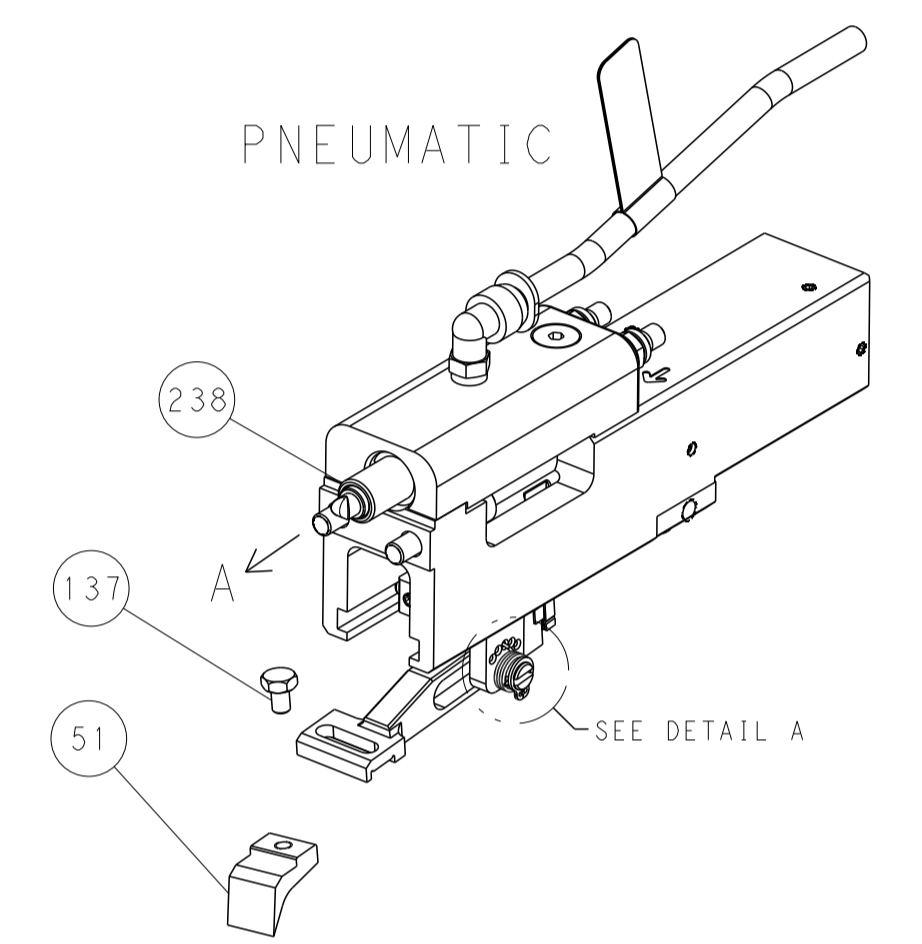
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A	66				
REVISIONS			DESCRIPTION	DATE	DWN
			SEE SHEET 1		



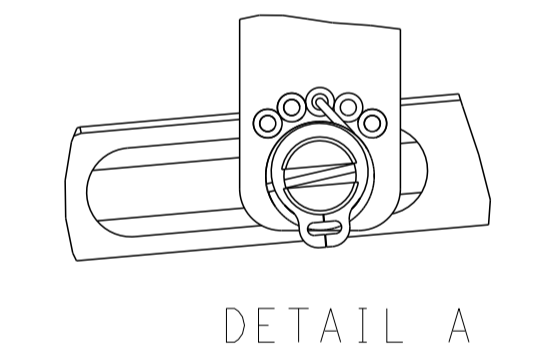
RAM AND HOLDDOWN SET-UP



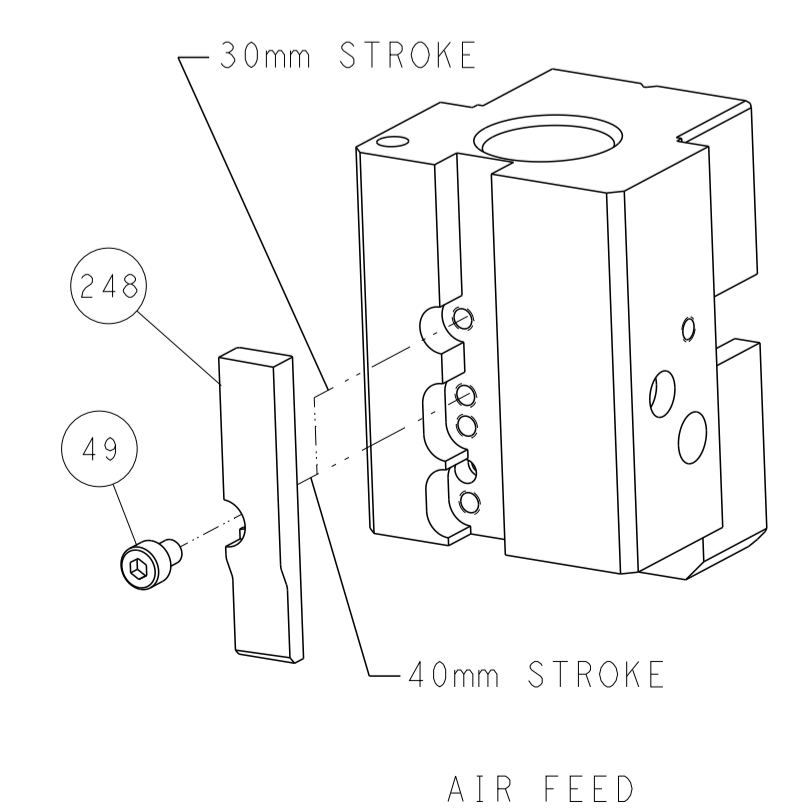
FEED TYPE



FEED SPRING SETTING POSITION



CAM POSITION

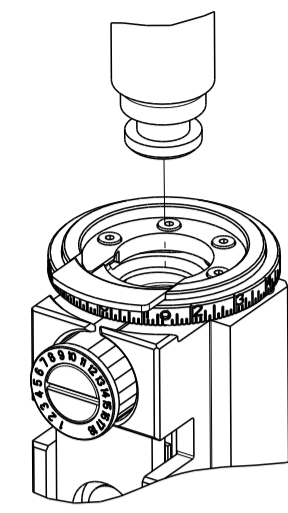


ATLANTIC VERSION  
 Shown on sheets 1 of 4 & 2 of 4  
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

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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: SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2150519	RESTRICTED TO: SCALE: 1:1 SHEET: 2 of 4 REV: B
MATERIAL:		WEIGHT:	Customer Accessible Production Drawing

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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150519-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150519-7	A	CRIMP TOOLING KIT	-

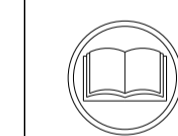
PACIFIC VERSION TERMINATOR  
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.54 mm [ .100 ]	F
INSUL	3.94 mm [ .155 ]	F
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: GMG TERMINAL		GMG CRIMP SPECIFICATION	
TERMINAL NAME: FASTIN-ON 6.3 X 0.8			
WIRE STRIP LENGTH 5.20-5.96 mm [ .205-.235 IN ]		INSULATION DIAMETER RANGE 4.00 mm MAX [ .157 IN MAX ]	
TERMINAL APPLICATION SPECIFICATION 31002.52.08.1 Rev 01			
TERMINALS APPLIED			
TE TERMINAL	GMG TERMINAL	TE TERMINAL	GMG TERMINAL
2113640-1	31002.52.00.1	2113640-3	31002.52.08.1
2113640-2	31002.52.02.1		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
2.50mm2	1.85+/-0.05 [ .073+/- .002 ]	3.9
1.00mm2	1.75+/-0.05 [ .069+/- .002 ]	4.5



- 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.

**\*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.

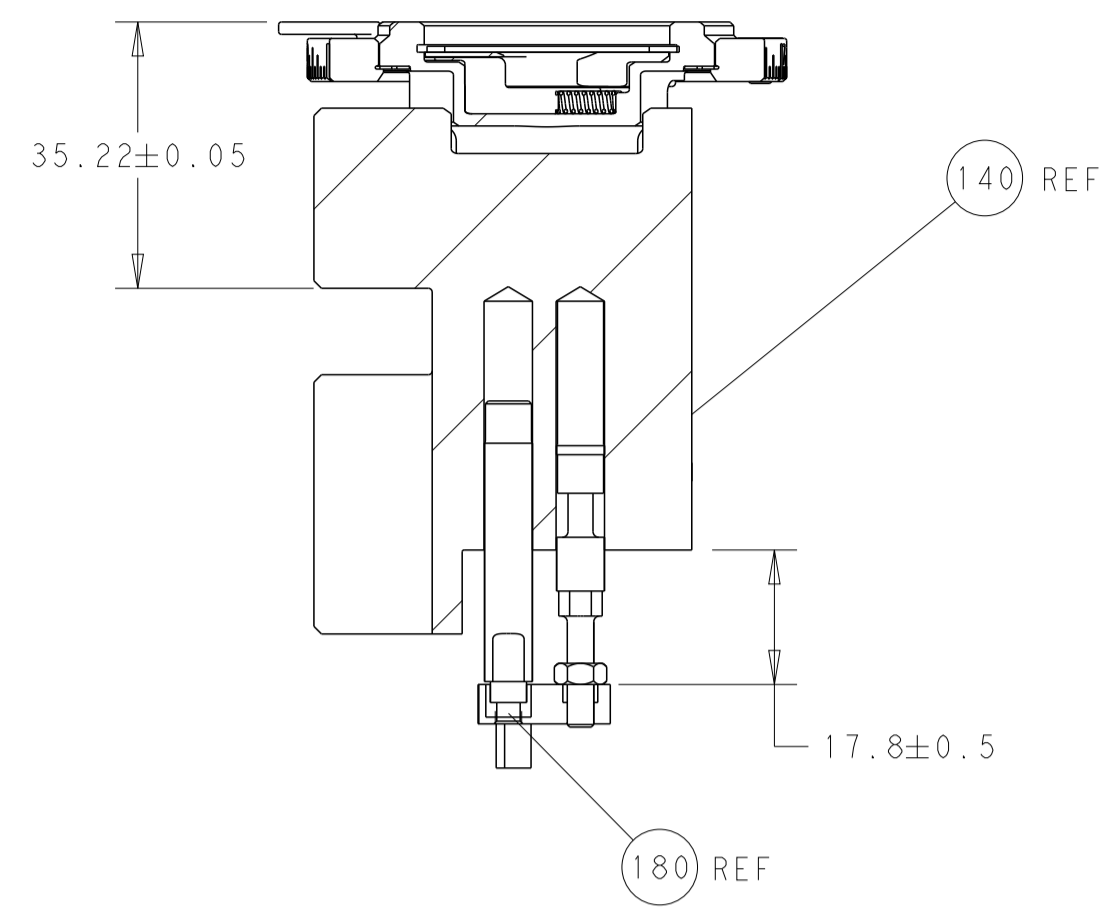
**PACIFIC VERSION**  
Shown on sheets 3 of 4 & 4 of 4  
(Atlantic version shown on sheets 1 of 4 & 2 of 4)

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

-	1	2119082-7	CAM, SNAIL, INSULATION ADJUSTMENT	244	
-	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243	
3	-	1	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	1752354-2	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	455888-4	SPACER, CRIMPER	82	
-	1	2119791-5	DEPRESSOR, WIRE	73	
-	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	1976052-1	HOLDDOWN, TERMINAL	65	
-	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59	
-	4	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57	
-	2	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	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	2063961-1	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	
-	8	1-18028-2	WASHER, FLAT, REG M4	33	
-	2	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	1752371-2	PLATE, STRIP GUIDE	24	
-	2	2-22281-3	SPRING, COMPRESSION	22	
-	1	1803292-4	DRAG	20	
-	1	1901696-5	STRIP GUIDE, REAR	19	
-	1	1901695-5	STRIP GUIDE, FRONT	18	
-	1	5-240641-9	SPACER	16	
-	1	1752360-1	SPACER, HOLD-DOWN	13	
1	-	1	1-240644-1	PLATE, REAR SHEAR	11
-	-	-	-	10	
1	-	1	5-690482-1	PLATE, FRONT SHEAR	9
1	1	1	6-1803001-9	ANVIL, COMBINATION, END FEED	8
1	-	1	1-2217206-0	BLADE, SLUG	7
-	-	-	-	6	
-	1	1	7-240641-3	SPACER	5
-	1	1	6-238011-7	BLOCK, CRIMPER SPACER	4
1	1	1	9-1633961-0	CRIMPER, INSULATION F PREMIUM	3
-	1	1	455888-6	SPACER, CRIMPER	2
1	1	1	3-456407-1	CRIMPER, WIRE PREMIUM	1
-	77-22		PART NO	DESCRIPTION	ITEM NO

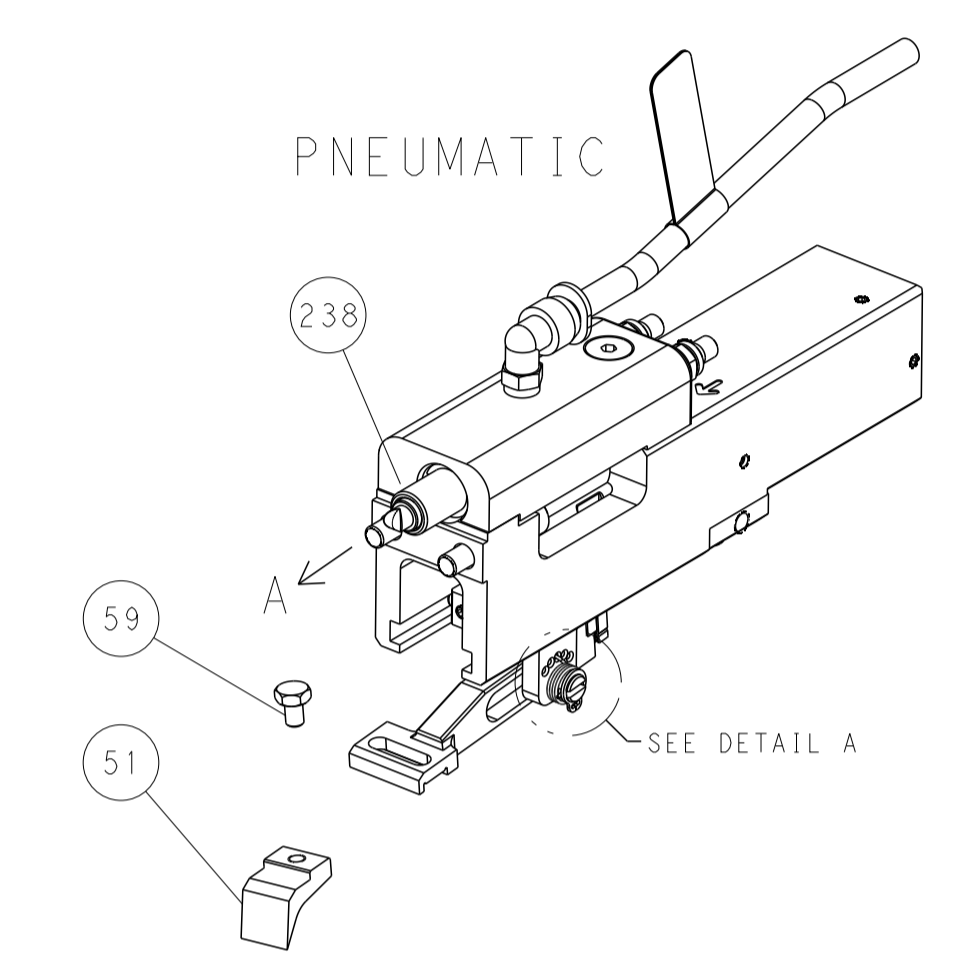
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DIMENSIONS: mm 	TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH	PRODUCT SPEC APPLICATION SPEC SIZE CAGE CODE DRAWING NO RESTRICTED TO	Ocean End Feed Applicator
MATERIAL	WEIGHT	SCALE	Customer Accessible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

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

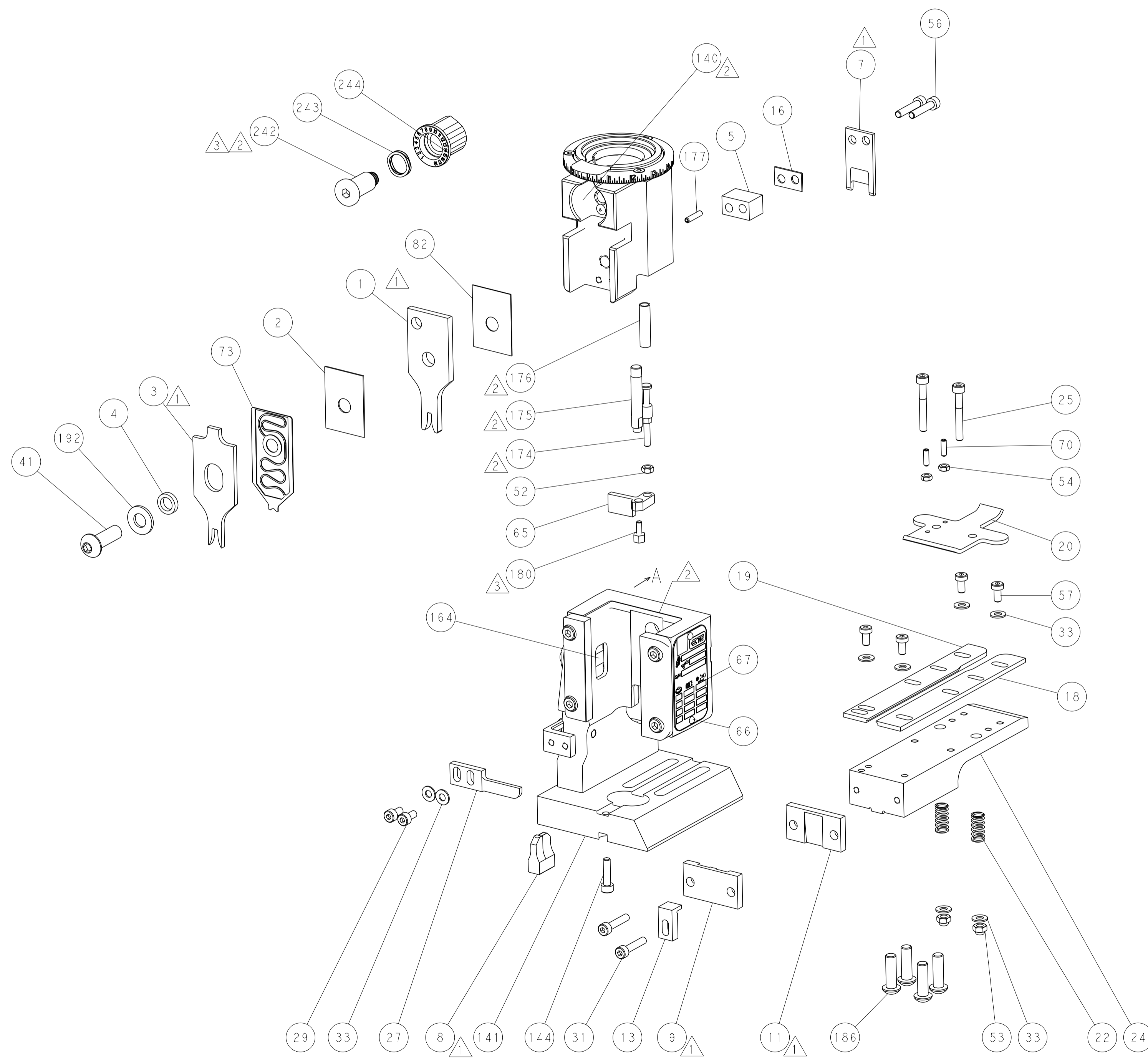
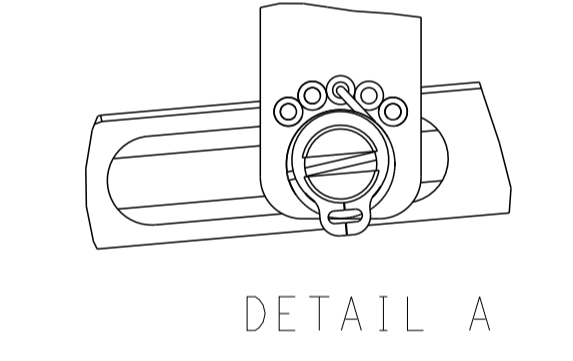


RAM AND HOLDDOWN SET-UP

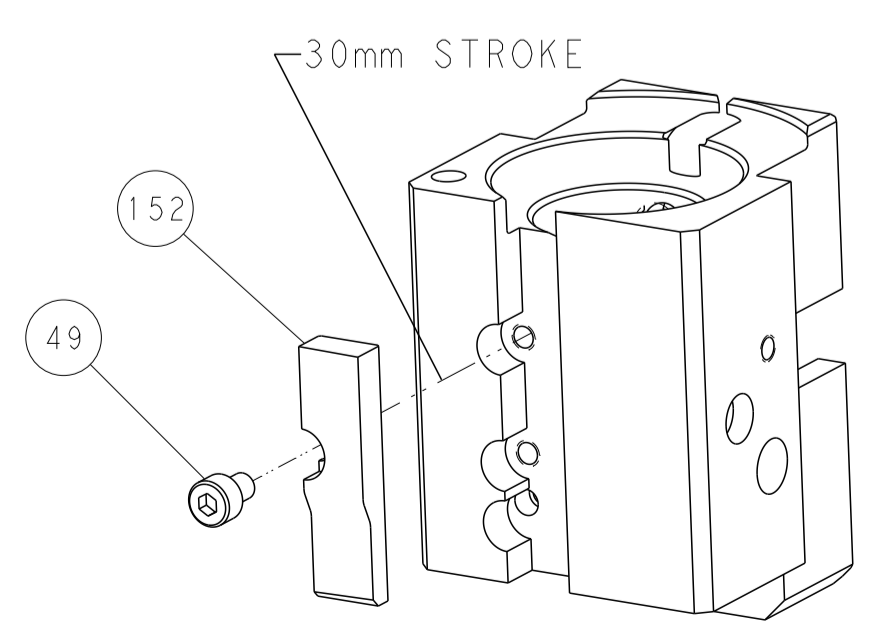
FEED TYPE



FEED SPRING SETTING POSITION



CAM POSITION



AIR FEED

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 ± MATERIAL: - FINISH: -		NAME: Ocean End Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2150519 WEIGHT: - SCALE: 1:1 SHEET: 4 OF 4 REV: B	RESTRICTED TO: -