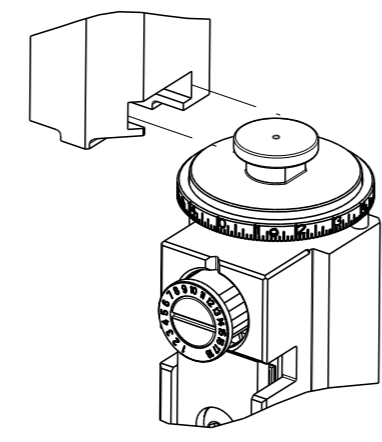


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150280-1	E	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2150280-2	E	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150280-1	E	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2150280-2	E	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150280-7	D	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.79 mm [.110]	F
INSUL	4.06 mm [.160]	F

APPLICATOR INSTRUCTIONS 408-35043

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION			
TERMINAL NAME: RING TONGUE			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
5.20-5.96 mm [.205-.235 IN]		Ø1.78-3.05 mm [.070-.120 IN]	
TERMINAL APPLICATION SPECIFICATION	114-3118	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
626028-1	626028-2	626028-3	626028-4
626029-1	626029-2	626029-5	

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.50mm2	2.03+/-0.05 [.080+/-0.002]	6.6
1.00mm2	1.88+/-0.05 [.074+/-0.002]	8.1
0.75mm2	1.78+/-0.05 [.070+/-0.002]	9.1
0.50mm2	1.73+/-0.05 [.068+/-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 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.

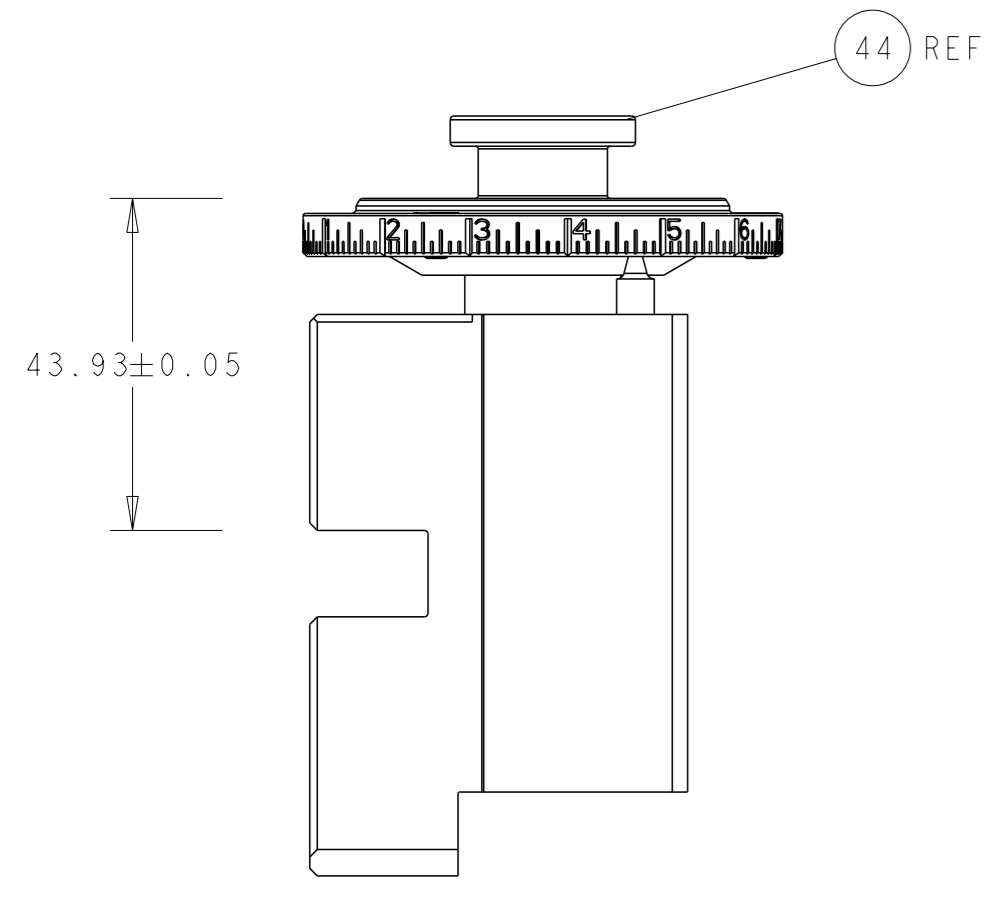
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		D		ECR-13-012299	12AUG2013	KH	TE
		E		ECR-20-006725	11MAY2020	JAH	RK

-	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	
-	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164	
-	1	1	1	1	455888-4	SPACER, CRIMPER	82	
-	1	1	1	1	2119791-5	DEPRESSOR, WIRE	73	
-	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	2119943-1	WASHER, SPACER	69	
-	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	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	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	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	-	2063961-1	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	2168083-9	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	240639-1	STRIPPER (MACHINING)	27	
-	2	2	2	2	1-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 30	25	
-	1	1	1	1	1752371-5	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	2-240641-4	SPACER	16	
-	1	1	1	1	240644-1	PLATE, REAR SHEAR	11	
-	-	-	-	-	-	-	10	
-	1	1	1	1	690482-4	PLATE, FRONT SHEAR	9	
1	2	2	1	1	1-1333219-0	ANVIL, COMBINATION	8	
1	1	1	1	1	1-2217206-1	BLADE, SLUG	7	
-	-	-	-	-	-	-	6	
-	1	1	1	1	240641-2	SPACER	5	
-	1	1	1	1	238011-2	BLOCK, CRIMPER SPACER	4	
1	2	2	1	1	5-1633961-4	CRIMPER, INSULATION F PREMIUM	3	
-	1	1	1	1	455888-4	SPACER, CRIMPER	2	
1	2	2	1	1	2-456408-1	CRIMPER, WIRE PREMIUM	1	
-	77	72	71	2	-1	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)

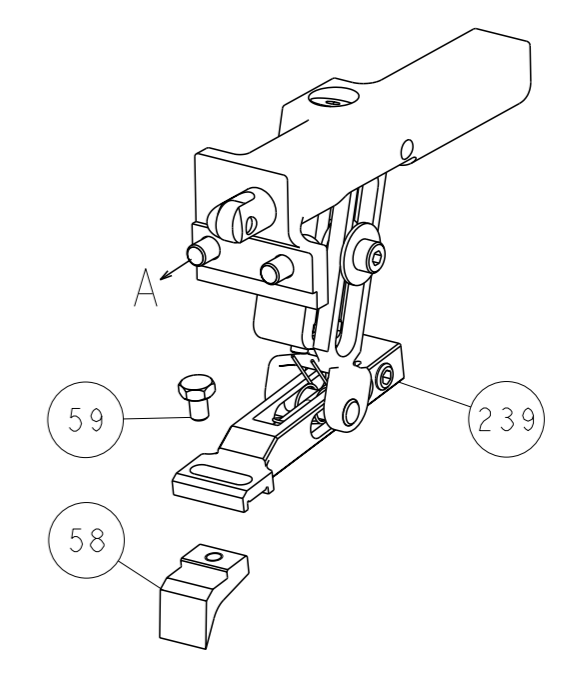
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1 PLC ±		2 PLC ±		C. MENEGHIN		NAME	
3 PLC ±		4 PLC ±		APVD C. LIMA 03AGO2012		Ocean End Feed	
5 PLC ±		FINISH		PRODUCT SPEC		Applicator	
MATERIAL		WEIGHT		APPLICATION SPEC		SIZE CAGE CODE DRAWING NO	
-		-		-		A1 00779 C=2150280	
-		-		RESTRICTED TO		SCALE 1:1 SHEET 1 OF 4 REV E	
-		-		Customer Accessible Production Drawing		SHEET 1 OF 4 REV E	

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

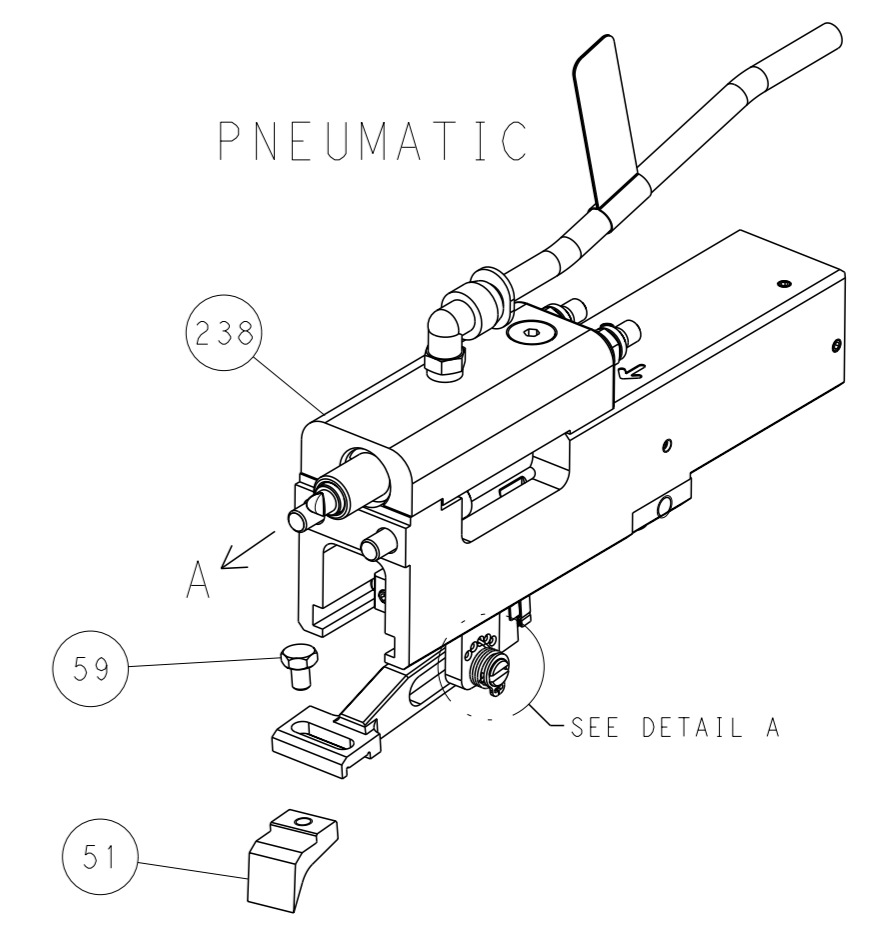


RAM SET-UP

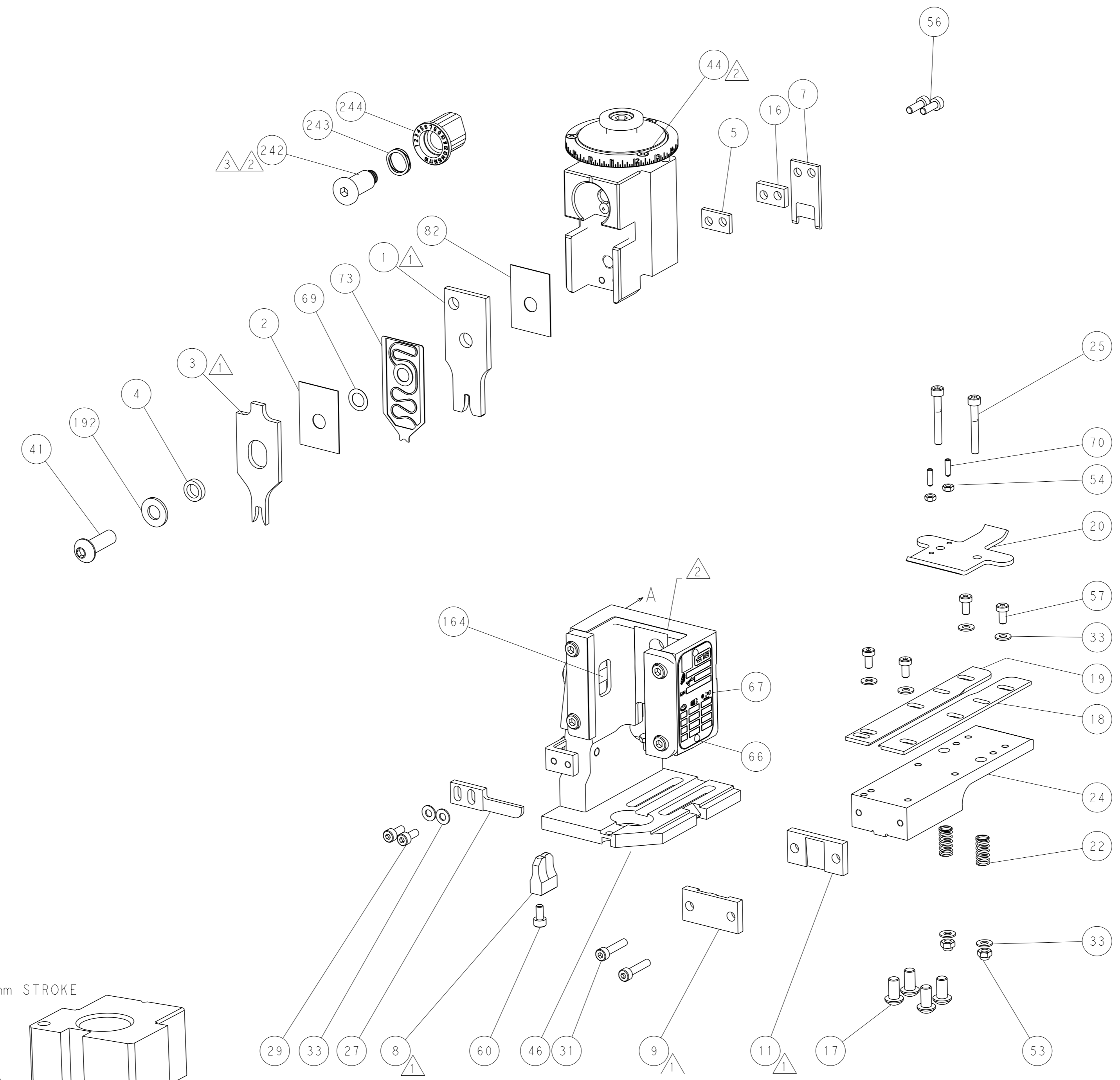
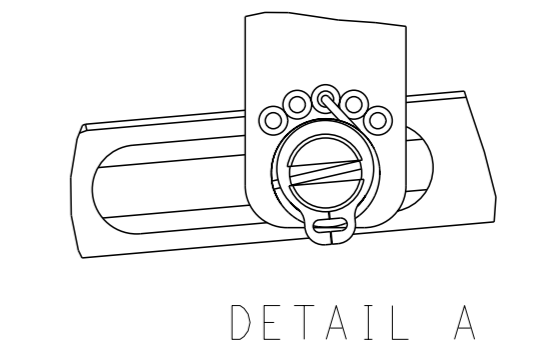
FEED TYPE MECHANICAL



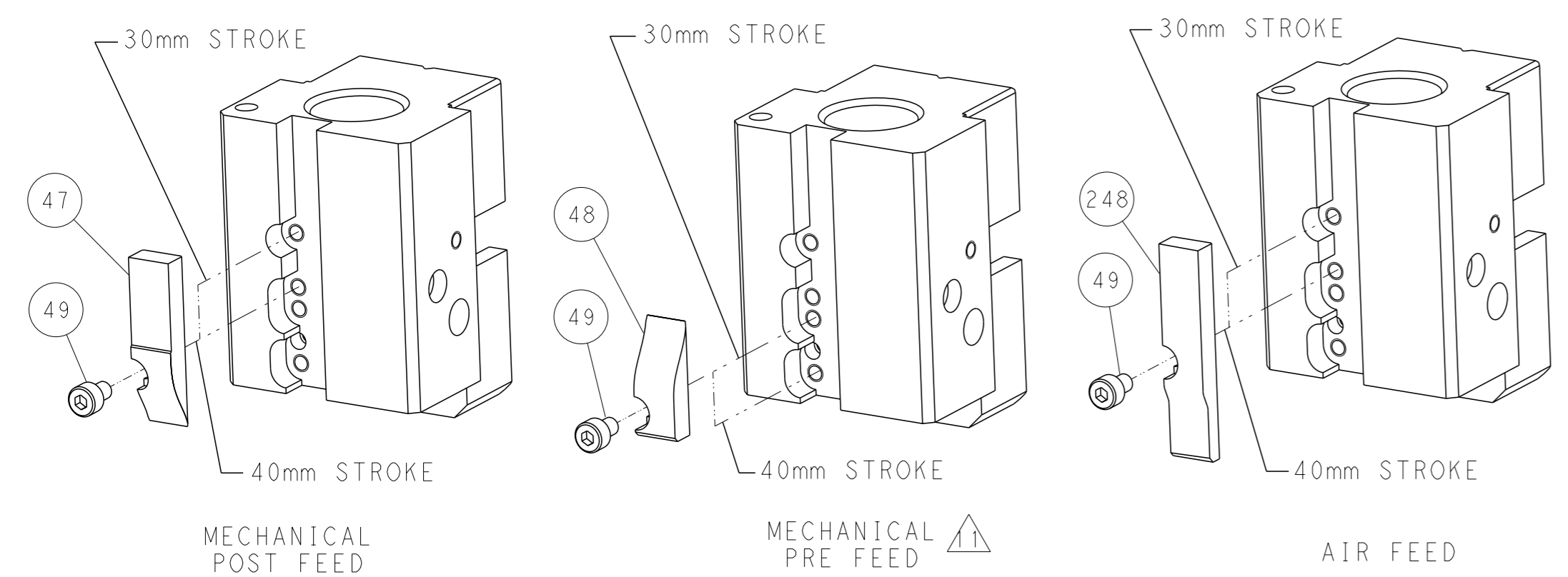
PNEUMATIC



FEED SPRING SETTING POSITION



CAM POSITIONS

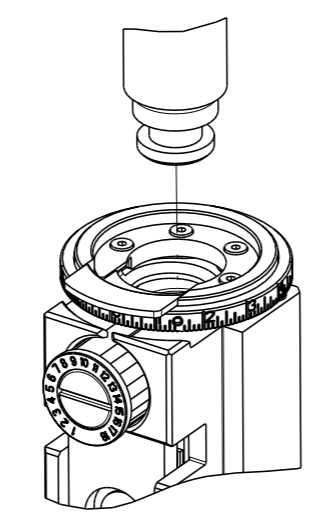


ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

<small>THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE AND TO PATENT AND REGISTERING DISCRETION. SHOULD BE CONTACTED FOR THE LATEST REVISION.</small>		OWN: S. ALVES CHK: C. MENEGHIN APVD: C. LIMA	03AGO2012 03AGO2012 03AGO2012	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: 2150280	RESTRICTED TO: - SCALE: 1:1 SHEET: 2 of 4 REV: E
MATERIAL: - FINISH: -		WEIGHT: - Customer Accessible Production Drawing	SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION	

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150280-1	E	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2150280-2	E	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150280-7	D	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
 INTERFACE ADAPTER



APPLICATOR DATA

CRIMP	SIZE	TYPE
WIRE	2.79 mm [.110]	F
INSUL	4.06 mm [.160]	F

APPLICATOR INSTRUCTIONS
 408-35043

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION

TERMINAL NAME: RING TONGUE

WIRE STRIP LENGTH	INSULATION DIAMETER RANGE
5.20-5.96 mm [.205-.235 IN]	Ø1.78-3.05 mm [.070-.120 IN]

TERMINAL APPLICATION SPECIFICATION

TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
626028-1	626028-2	626028-3	626028-4
626029-1	626029-2	626029-5	

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.50mm2	2.03 +/- 0.05 [.080 +/- .002]	6.6
1.00mm2	1.88 +/- 0.05 [.074 +/- .002]	8.1
0.75mm2	1.78 +/- 0.05 [.070 +/- .002]	9.1
0.50mm2	1.73 +/- 0.05 [.068 +/- .002]	9.6

- 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.
- 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.

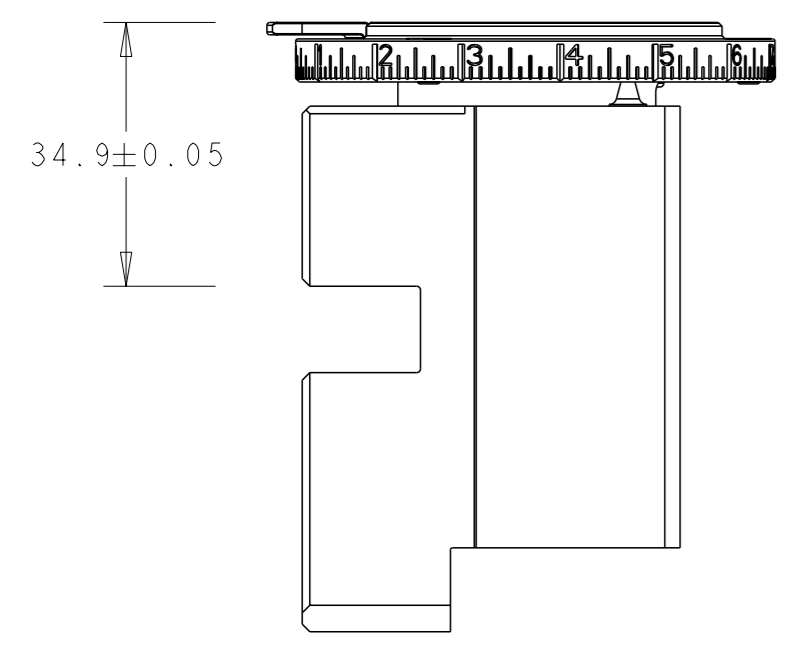
PACIFIC VERSION
 Shown on sheets 3 of 4 & 4 of 4
 (Atlantic version shown on sheets 1 of 4 & 2 of 4)

LOC	DIST	REV	DATE	OWN	APVD
A	66	-	-	-	-

REV	DATE	DESCRIPTION	ITEM NO			
-	1	1	2119082-9	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	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	
-	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	455888-4	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	2119943-1	WASHER, SPACER	69	
-	1	1	2119740-1	TAG, IDENTIFICATION	67	
-	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66	
-	-	2	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	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	56	
-	2	2	5018030-1	NUT, HEX, REG, RoHS, M3	54	
-	2	2	986965-8	NUT, LOCK, HEX, TORQUE (M4)	53	
-	1	-	2063961-1	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	2168083-9	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	240639-1	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	
-	1	1	2-240641-4	SPACER	16	
-	1	1	240644-1	PLATE, REAR SHEAR	11	
-	-	-	-	-	10	
-	1	1	690482-4	PLATE, FRONT SHEAR	9	
1	1	1	1-1333219-0	ANVIL, COMBINATION	8	
-	1	1	1-2217206-1	BLADE, SLUG	7	
-	-	-	-	-	6	
-	1	1	240641-2	SPACER	5	
-	1	1	238011-2	BLOCK, CRIMPER SPACER	4	
1	1	1	5-1633961-4	CRIMPER, INSULATION F PREMIUM	3	
-	1	1	455888-4	SPACER, CRIMPER	2	
1	1	1	2-456408-1	CRIMPER, WIRE PREMIUM	1	
-	77	22	21	PART NO	DESCRIPTION	ITEM NO

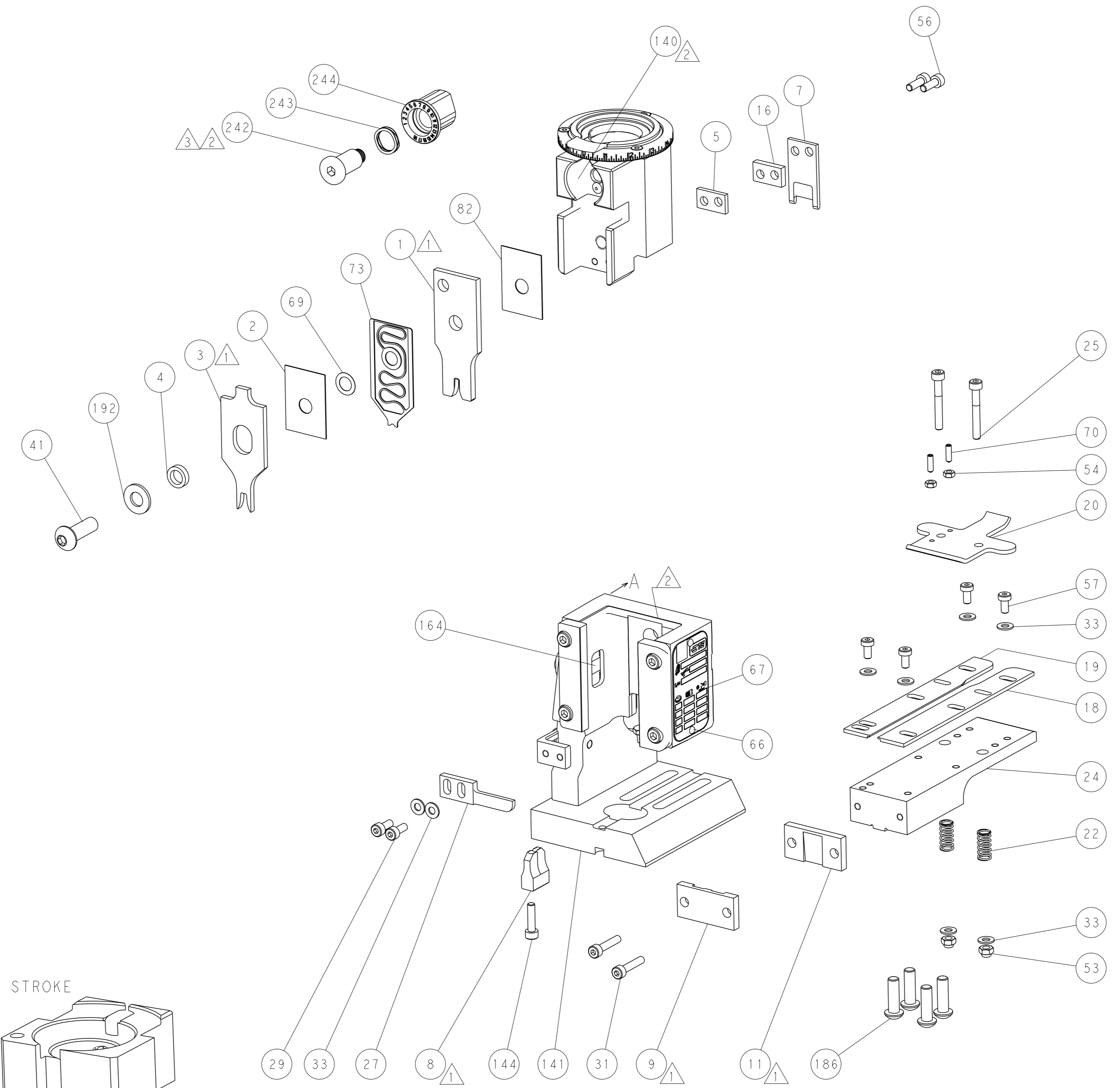
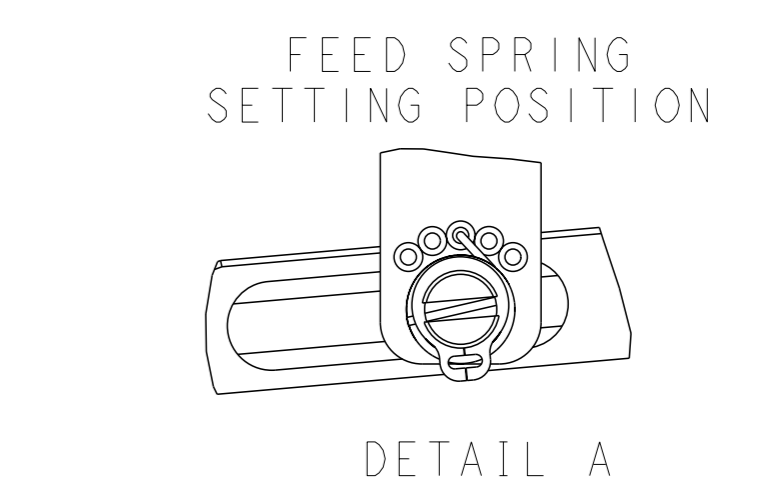
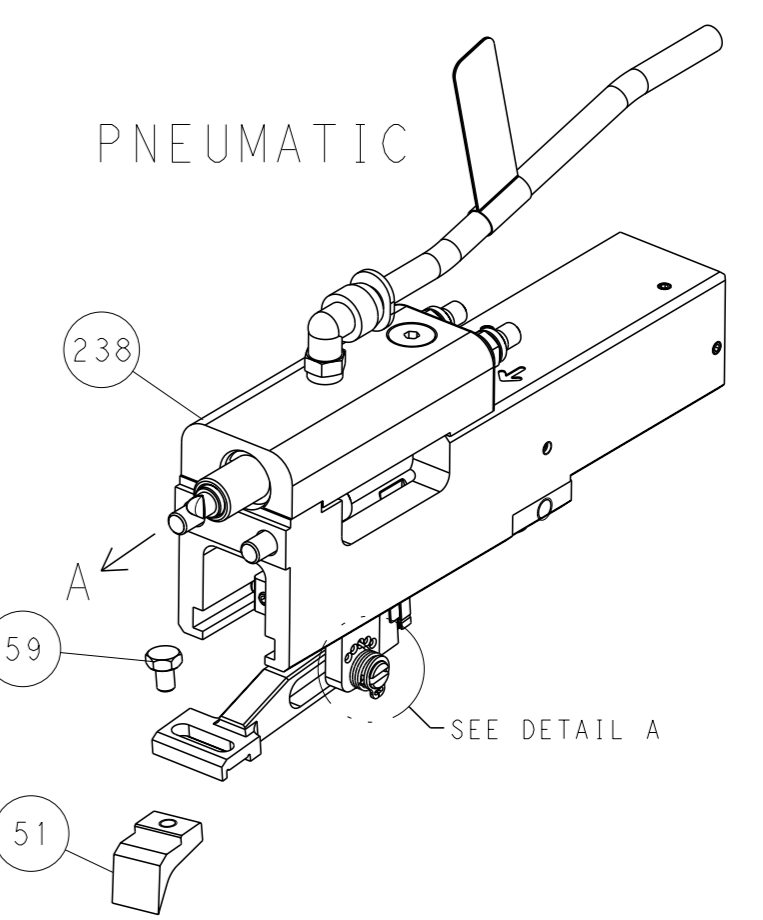
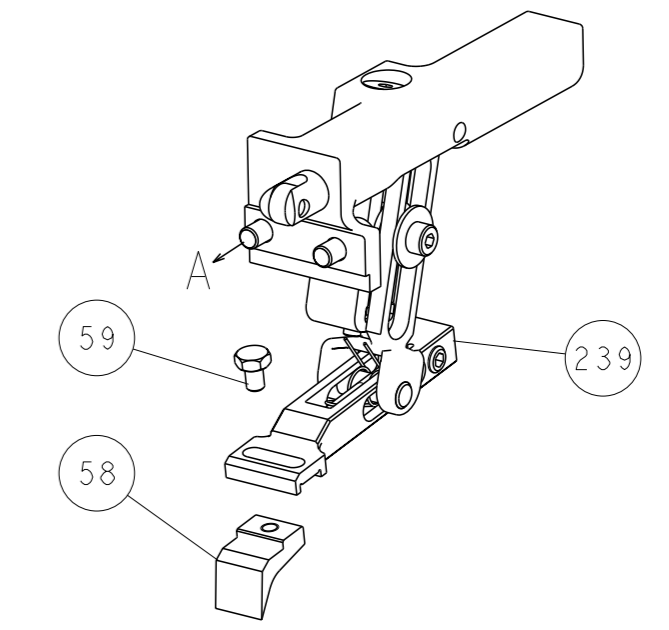
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1 PLC ±		1.00 ±		APVD: C. LIMA 03AGO2012		PRODUCT SPEC	
2 PLC ±		2.00 ±		APPLICATION SPEC		SIZE: A1	
3 PLC ±		3.00 ±		WEIGHT: -		CAGE CODE: 00779	
4 PLC ±		4.00 ±		SCALE: 1:1		DRAWING NO: 2150280	
ANGLES		FINISH		RESTRICTED TO		SHEET 3 OF 4	
MATERIAL: -		FINISH: -		Customer Accessible Production Drawing		REV E	

LOC	DIST	REVISIONS				
A	66	REV	DATE	OWN	APVD	
		-				
		SEE SHEET 1				

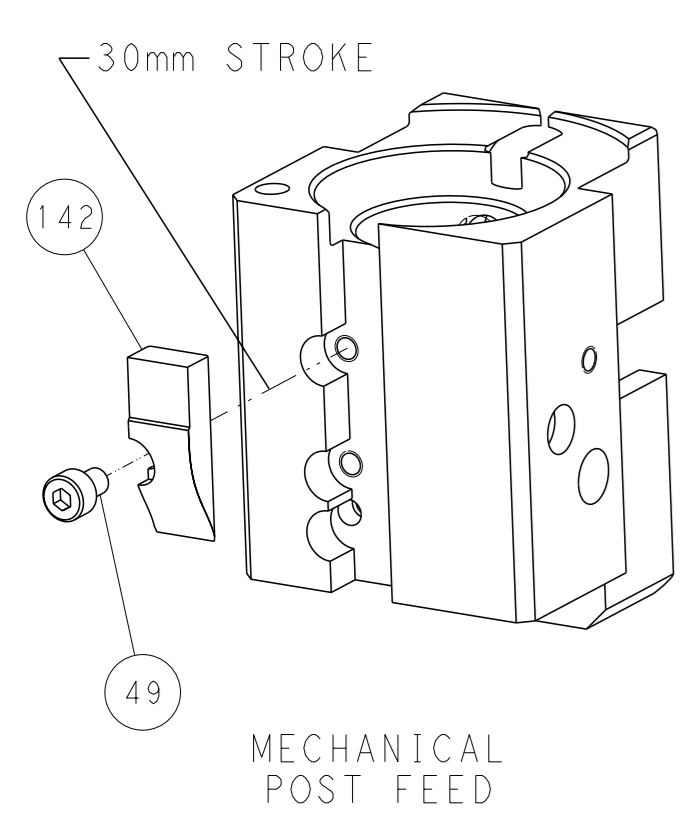


RAM SET-UP

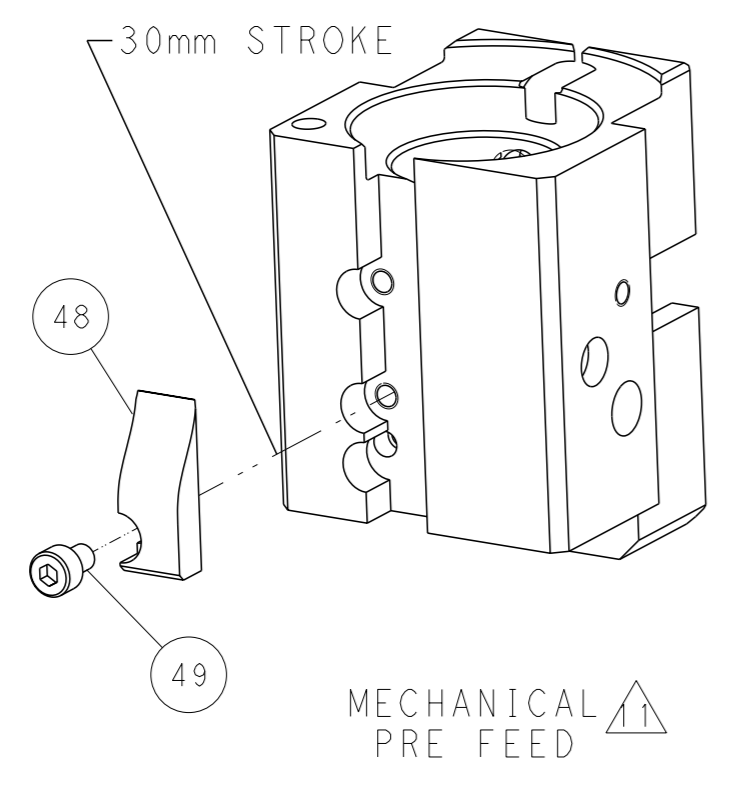
FEED TYPE MECHANICAL



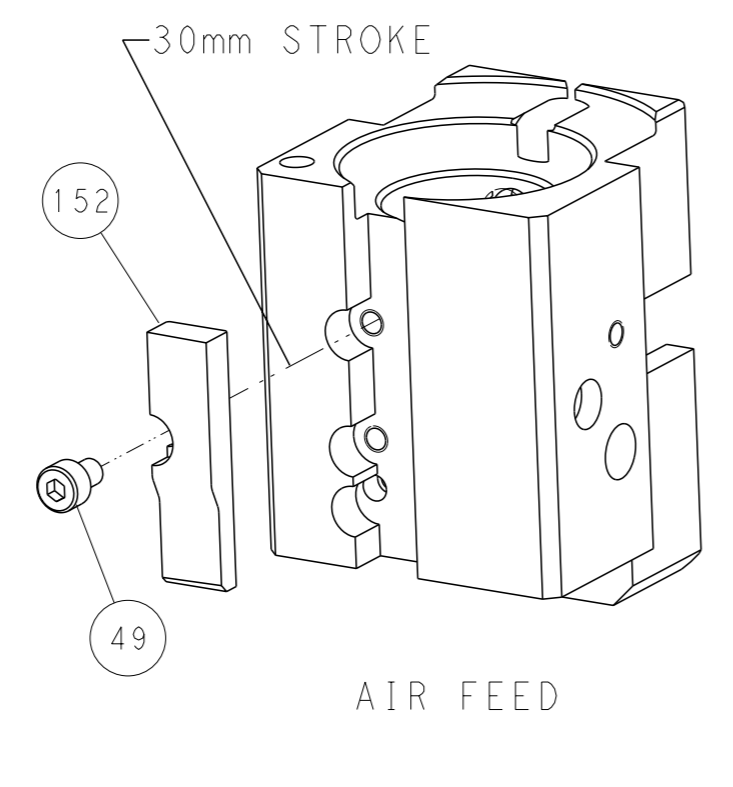
CAM POSITIONS



MECHANICAL POST FEED



MECHANICAL PRE FEED



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 FINISH *	WEIGHT: - SCALE: 1:1	SHEET: 4 OF: 4	REV: E		