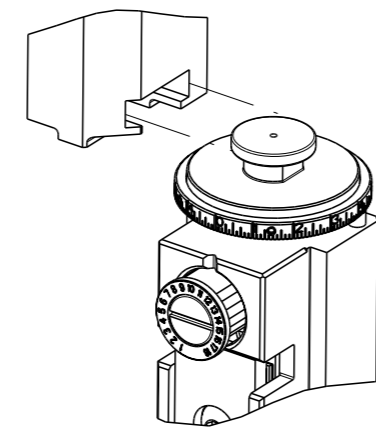


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150532-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2150532-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150532-1	C	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2150532-2	C	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150532-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.40 mm [.094]	F
INSUL	3.00 mm [.118]	F
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: PRONER TERMINAL TE CRIMP SPECIFICATION	
TERMINAL NAME: PRONER TERMINAL	
WIRE STRIP LENGTH 5.63-6.39 mm [.221-.251 IN]	INSULATION DIAMETER RANGE Ø1.30-2.00 mm [.051-.079 IN]
TERMINAL APPLICATION SPECIFICATION NONE	
TERMINALS APPLIED	
TE TERMINAL 1544113-1 1544113-2	PRONER TERMINAL P7410074801 P7410074851

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.00mm ²	1.62+/-0.05 [.064+/-0.002]	6.6
0.75mm ² or 18 AWG	1.55+/-0.05 [.061+/-0.002]	7.3
0.60mm ²	1.48+/-0.05 [.058+/-0.002]	7.9
0.50mm ² or 20 AWG	1.47+/-0.05 [.058+/-0.002]	8.0
0.35mm ² or 22 AWG	1.40+/-0.05 [.055+/-0.002]	8.9

- 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. TERMINAL LUBRICANT IS RECOMMENDED.
- 6. 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.

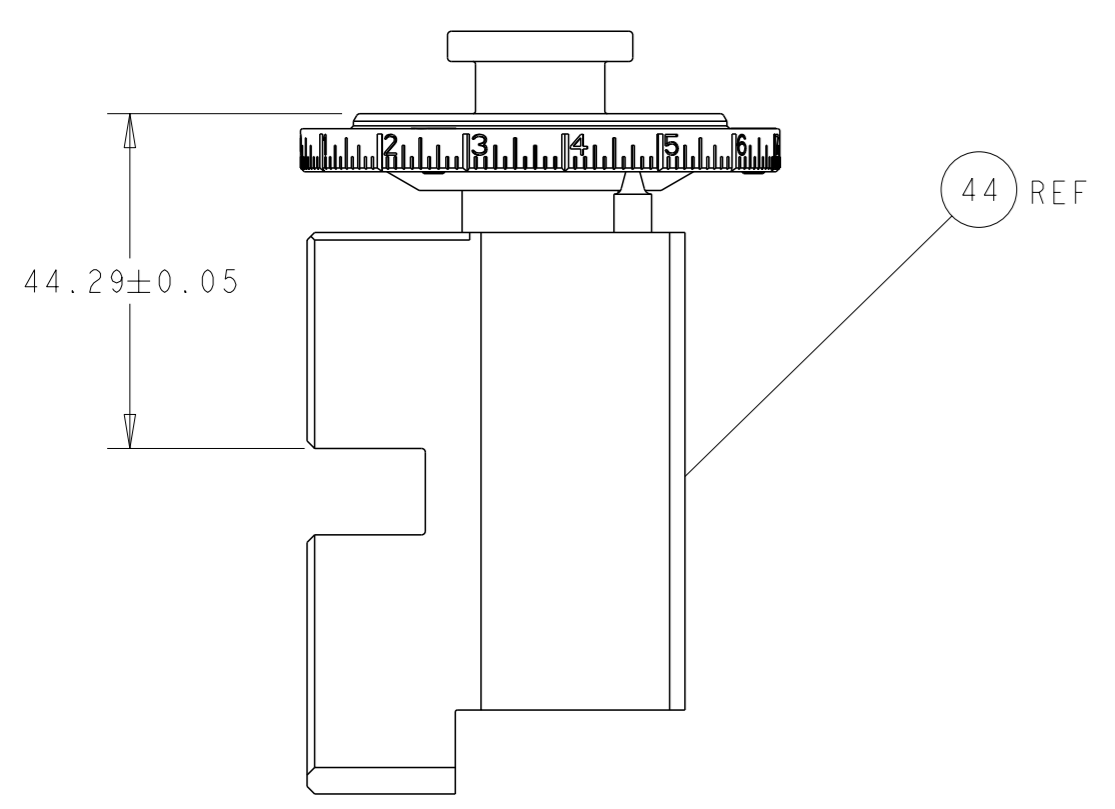
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

LOC	DIST	REVISIONS					
		P	LY#	DESCRIPTION	DATE	OWN	APVD
A	66	A		RELEASED	22APR2015	BW	TE
		B		ECR-18-014355	10SEP2018	TB	TE
		C		ECR-19-016565	23OCT2019	JAH	TE

-	1	-	1	-	2119640-1	PUSH ROD, AIR FEED	250	
-	1	-	1	-	1803259-1	BUSHING, FLANGED	249	
-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248	
-	1	1	1	1	2119082-7	CAM, SNAIL, INSULATION ADJUSTMENT	244	
-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243	
3	-	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242	
-	-	1	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239	
-	1	-	1	-	2063440-1	AIR FEED MODULE	238	
-	1	1	1	1	1-18028-0	WASHER, FLAT, REG M8	192	
-	2	2	2	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M3 X 6	191	
-	2	-	2	-	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172	
-	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164	
-	1	-	1	-	240638-1	SPRING, FEED FINGER	163	
-	1	-	1	-	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854	137	
-	1	1	1	1	1-2168083-2	SCR, SKT HD CAP, RoHS, M4 X 25	92	
-	1	1	1	1	469633-1	BLOCK, SUPPORT	87	
5	-	1	1	1	2119955-2	ASSY, LUBRICATOR, END FEED	84	
-	1	1	1	1	455888-5	SPACER, CRIMPER	82	
-	1	1	1	1	1803607-2	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	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	
-	-	1	-	1	2161924-1	FEED FINGER	58	
-	2	2	2	2	2168400-1	SHCS, LOW HEAD, RoHS, M4 X 12	57	
-	2	2	2	2	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	56	
-	2	2	2	2	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	55	
-	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	-	2161920-1	NARROW PAWL, EF, AIR	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	
-	1	1	1	1	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	31	
-	2	2	2	2	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	29	
-	1	1	1	1	240639-3	STRIPPER (MACHINING)	27	
-	2	2	2	2	1-2168083-6	SCR, SKT HD CAP, RoHS, M4 X 35	25	
-	1	1	1	1	2161922-1	PLATE, STRIP GUIDE	24	
-	2	2	2	2	22281-8	SPRING, COMPRESSION	22	
-	1	1	1	1	1633168-2	ARM, STOCK DRAG	21	
-	1	1	1	1	464452-4	DRAG, STOCK	20	
-	1	1	1	1	1-1901259-2	GUIDE, LOWER STRIP	19	
-	1	1	1	1	7-1901695-5	STRIP GUIDE, FRONT	18	
-	4	4	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17	
1	-	1	1	1	461160-3	PLATE, REAR SHEAR	11	
-	2	2	2	2	6-240645-0	SPACER, SHEAR PLATE	10	
1	-	1	1	1	455961-5	PLATE, FRONT SHEAR	9	
1	1	2	2	1	1	7-1803001-2	ANVIL, COMBINATION, END FEED	8
1	-	1	1	1	1	1-469634-8	BLADE, SLUG	7
-	-	-	-	-	-	-	6	
-	1	1	1	1	4-240641-3	SPACER	5	
-	1	1	1	1	1-238011-0	BLOCK, CRIMPER SPACER	4	
1	1	2	2	1	1	8-1633962-0	CRIMPER, INSULATION F PREMIUM	3
-	2	2	2	2	1-455888-4	SPACER, CRIMPER	2	
1	1	2	2	1	1	1803015-7	CRIMPER, WIRE	1
-	77	72	71	2	-1	PART NO	DESCRIPTION	ITEM NO

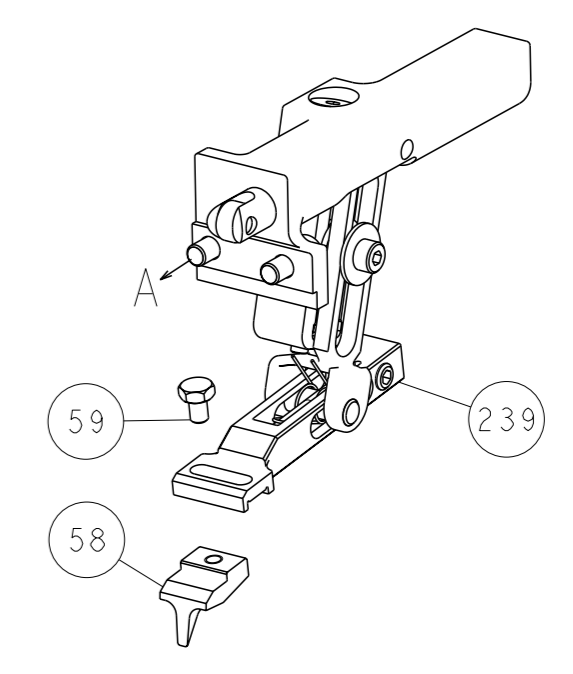
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG: B. WEAVER 27FEB2015		TE Connectivity	
mm		0 PLC ±		CHK: T. ELBIN 27FEB2015		Harrisburg, PA 17105-3608	
1 PLC ±		1 PLC ±		APVD: T. ELBIN 27FEB2015		NAME: Ocean End Feed Applicator	
2 PLC ±		3 PLC ±		PRODUCT SPEC		SIZE: CAGE CODE: DRAWING NO: RESTRICTED TO	
3 PLC ±		4 PLC ±		APPLICATION SPEC		A1 00779 C=2150532	
4 PLC ±		FINISH		WEIGHT		SCALE: 1:1 SHEET 1 OF 4 REV C	
MATERIAL		FINISH		WEIGHT		Customer Accessible Production Drawing	

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

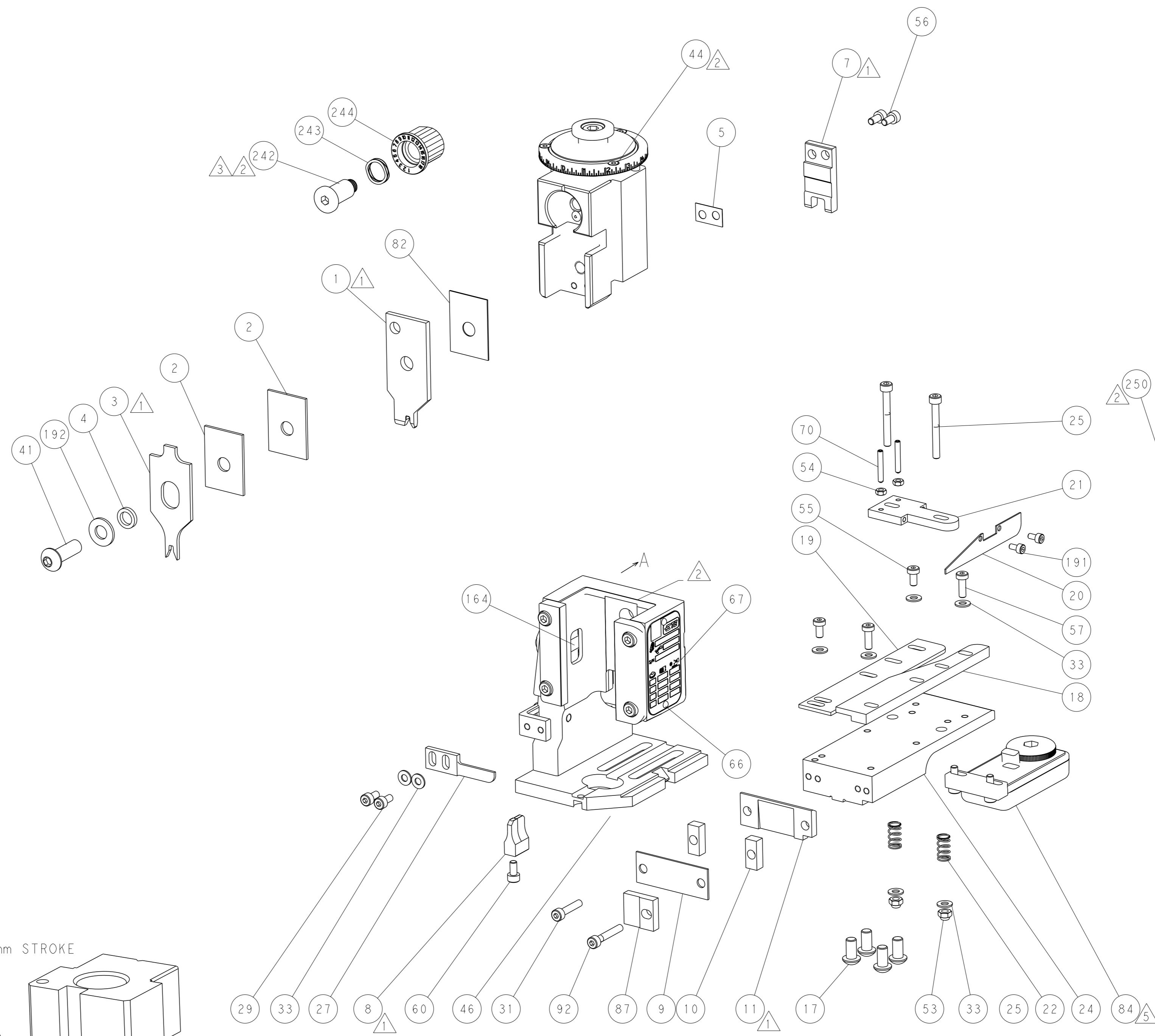
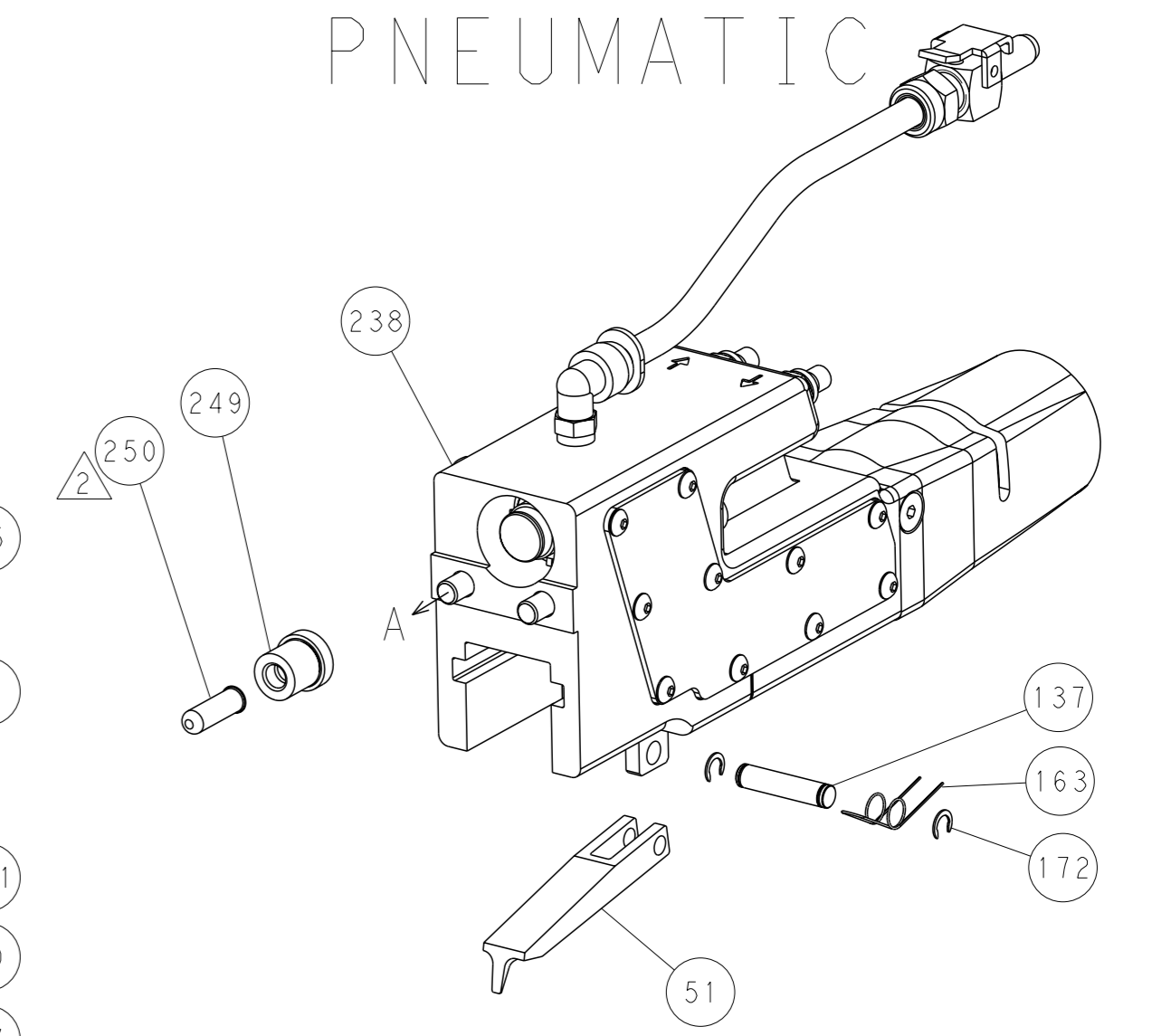


RAM SET-UP

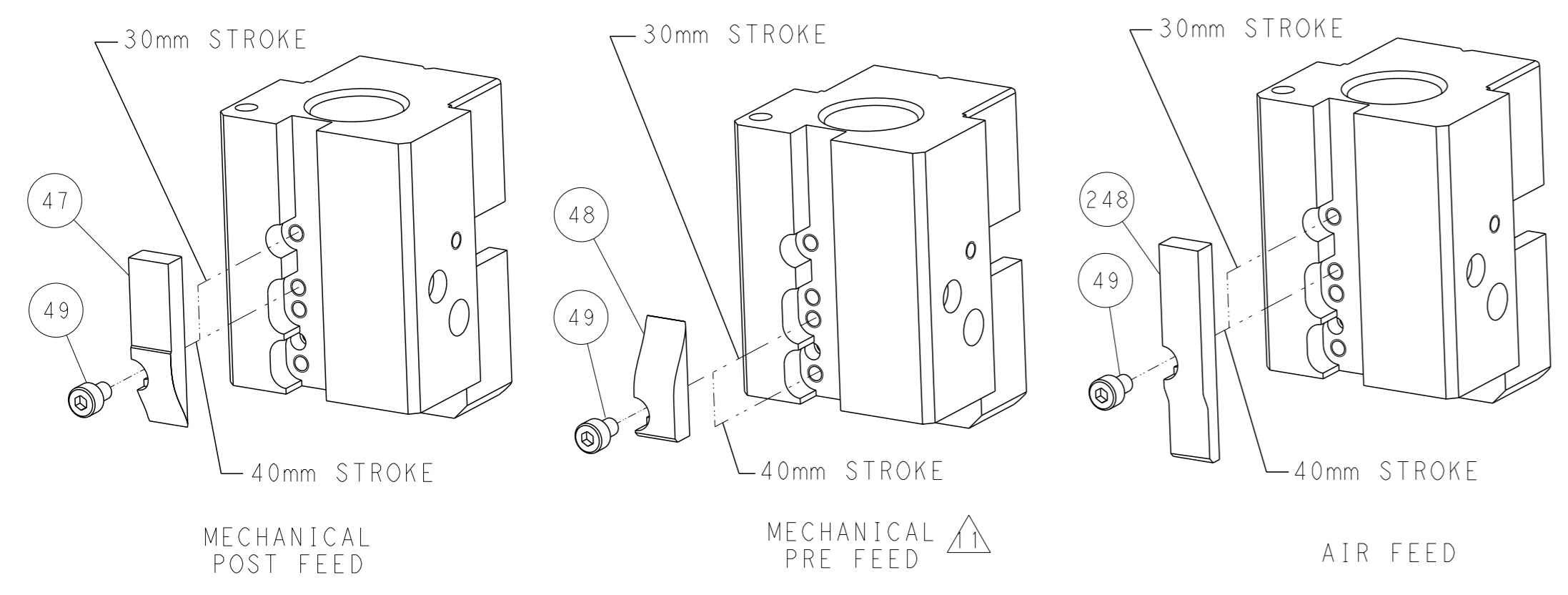
FEED TYPE
MECHANICAL



PNEUMATIC



CAM POSITIONS

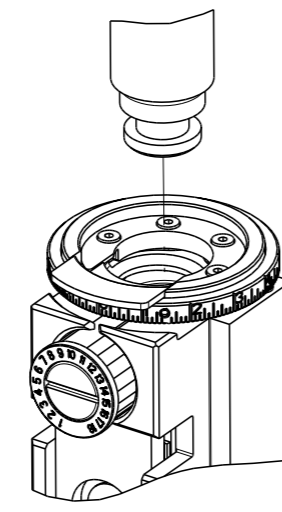


ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

<small>THIS DRAWING IS A CONTROLLED DOCUMENT FROM TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE AND TO CONTROLING ENGINEERING DISCRETION. SHOULD BE CONTACTED FOR THE LATEST REVISION.</small>		OWN: B. WEAVER 27FEB2015 CHK: T. ELBIN 27FEB2015 APVD: T. ELBIN 27FEB2015	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=2150532 WEIGHT: - SCALE: 1:1	RESTRICTED TO: - SHEET 2 of 4 REV C
Customer Accessible Production Drawing			

THIS DRAWING IS UNPUBLISHED.	RELEASED FOR PUBLICATION	2015	
COPYRIGHT 2015 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.			
PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150532-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2150532-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150532-7	A	CRIMP TOOLING KIT	-

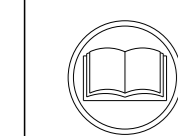
PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.40 mm [.094]	F
INSUL	3.00 mm [.118]	F
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: PRONER TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: PRONER TERMINAL			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
5.63-6.39 mm [.221-.251 IN]		Ø1.30-2.00 mm [.051-.079 IN]	
TERMINAL APPLICATION SPECIFICATION	NONE	-	-
TERMINALS APPLIED			
TE TERMINAL	PRONER TERMINAL	TE TERMINAL	PRONER TERMINAL
1544113-1	P7410074801	1544113-4	P7412274801
1544113-2	P7410074851		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.00mm ²	1.62 +/- 0.05 [.064 +/- .002]	6.6
0.75mm ² or 18 AWG	1.55 +/- 0.05 [.061 +/- .002]	7.3
0.60mm ²	1.48 +/- 0.05 [.058 +/- .002]	7.9
0.50mm ² or 20 AWG	1.47 +/- 0.05 [.058 +/- .002]	8.0
0.35mm ² or 22 AWG	1.40 +/- 0.05 [.055 +/- .002]	8.9



- RECOMMENDED SPARE PARTS
- REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- 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.
- TERMINAL LUBRICANT IS RECOMMENDED.
- 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.

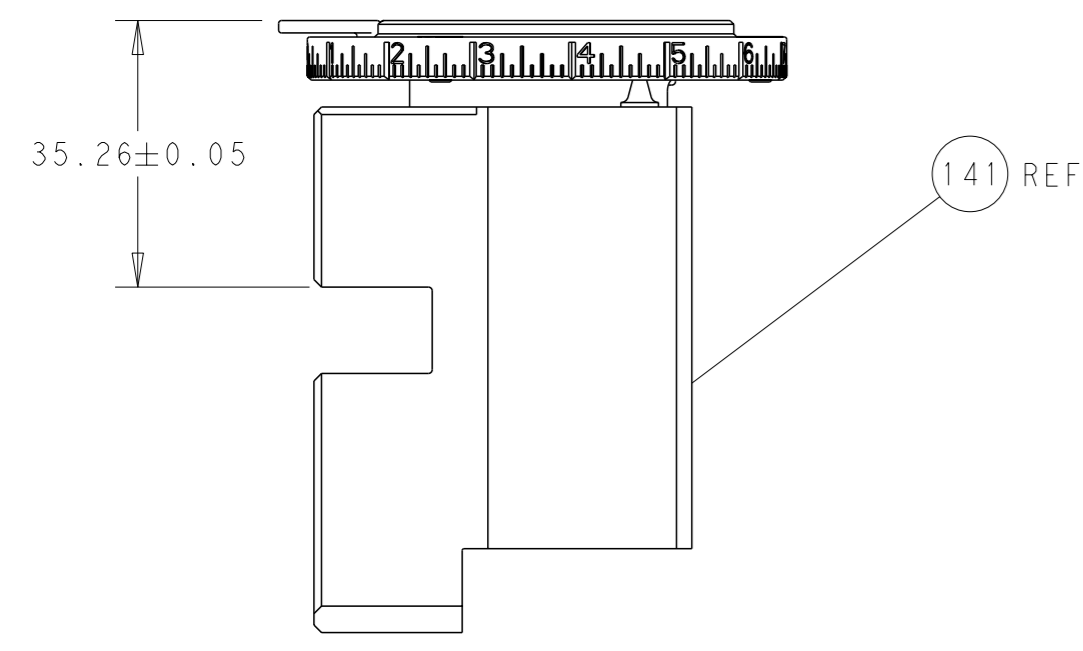
LOC	DIST	REVISIONS					
A	66	P	LY#	DESCRIPTION	DATE	OWN	APVD
		-		SEE SHEET 1	-	-	-

-	1	1	2119640-1	PUSH ROD, AIR FEED	250
-	1	1	1803259-1	BUSHING, FLANGED	249
-	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	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	1	-	2063440-1	AIR FEED MODULE	238
-	1	1	1-18028-0	WASHER, FLAT, REG M8	192
-	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	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172
-	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	1	1	240638-1	SPRING, FEED FINGER	163
-	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	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854	137
-	1	1	1-2168083-2	SCR, SKT HD CAP, RoHS, M4 X 25	92
-	1	1	469633-1	BLOCK, SUPPORT	87
-	1	1	2119955-2	ASSY, LUBRICATOR, END FEED	84
-	1	1	455888-5	SPACER, CRIMPER	82
-	1	1	1803607-2	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	2161924-1	FEED FINGER	58
-	2	2	2168400-1	SHCS, LOW HEAD, RoHS, M4 X 12	57
-	2	2	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	56
-	2	2	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	55
-	2	2	5018030-1	NUT, HEX, REG, RoHS, M3	54
-	2	2	986965-8	NUT, LOCK, HEX, TORQUE (M4)	53
-	1	-	2161920-1	NARROW PAWL, EF, AIR	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
-	1	1	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	240639-3	STRIPPER (MACHINING)	27
-	2	2	1-2168083-6	SCR, SKT HD CAP, RoHS, M4 X 35	25
-	1	1	2161922-1	PLATE, STRIP GUIDE	24
-	2	2	22281-8	SPRING, COMPRESSION	22
-	1	1	1633168-2	ARM, STOCK DRAG	21
-	1	1	464452-4	DRAG, STOCK	20
-	1	1	1-1901259-2	GUIDE, LOWER STRIP	19
-	1	1	7-1901695-5	STRIP GUIDE, FRONT	18
-	1	1	461160-3	PLATE, REAR SHEAR	11
-	2	2	6-240645-0	SPACER, SHEAR PLATE	10
-	1	1	455961-5	PLATE, FRONT SHEAR	9
-	1	1	7-1803001-2	ANVIL, COMBINATION, END FEED	8
-	1	1	1-469634-8	BLADE, SLUG	7
-	-	-	-	-	6
-	1	1	4-240641-3	SPACER	5
-	1	1	1-238011-0	BLOCK, CRIMPER SPACER	4
-	1	1	8-1633962-0	CRIMPER, INSULATION F PREMIUM	3
-	2	2	1-455888-4	SPACER, CRIMPER	2
-	1	1	1803015-7	CRIMPER, WIRE	1
-	77-22-21		PART NO	DESCRIPTION	ITEM NO

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

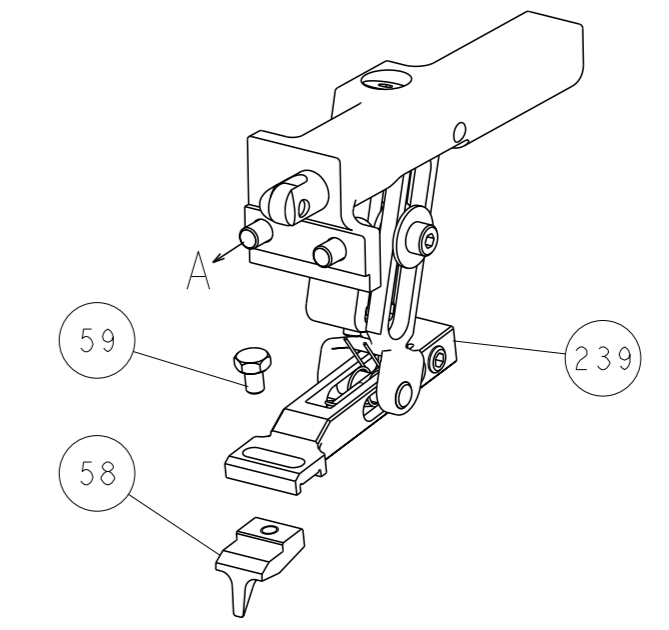
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		OWN	B. WEAVER	27FEB2015	TE Connectivity Harrisburg, PA 17105-3608
mm	0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ±	±	±	CHK	T. ELBIN	27FEB2015	
MATERIAL:		FINISH:		APVD	T. ELBIN	27FEB2015	NAME
				PRODUCT SPEC		Ocean End Feed Applicator	
				APPLICATION SPEC		SIZE	
				WEIGHT		CAGE CODE DRAWING NO	
				SCALE		RESTRICTED TO	
				Customer Accessible Production Drawing		A1 00779 ©=2150532	
				SCALE		SHEET 3 of 4	
				REV		C	

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

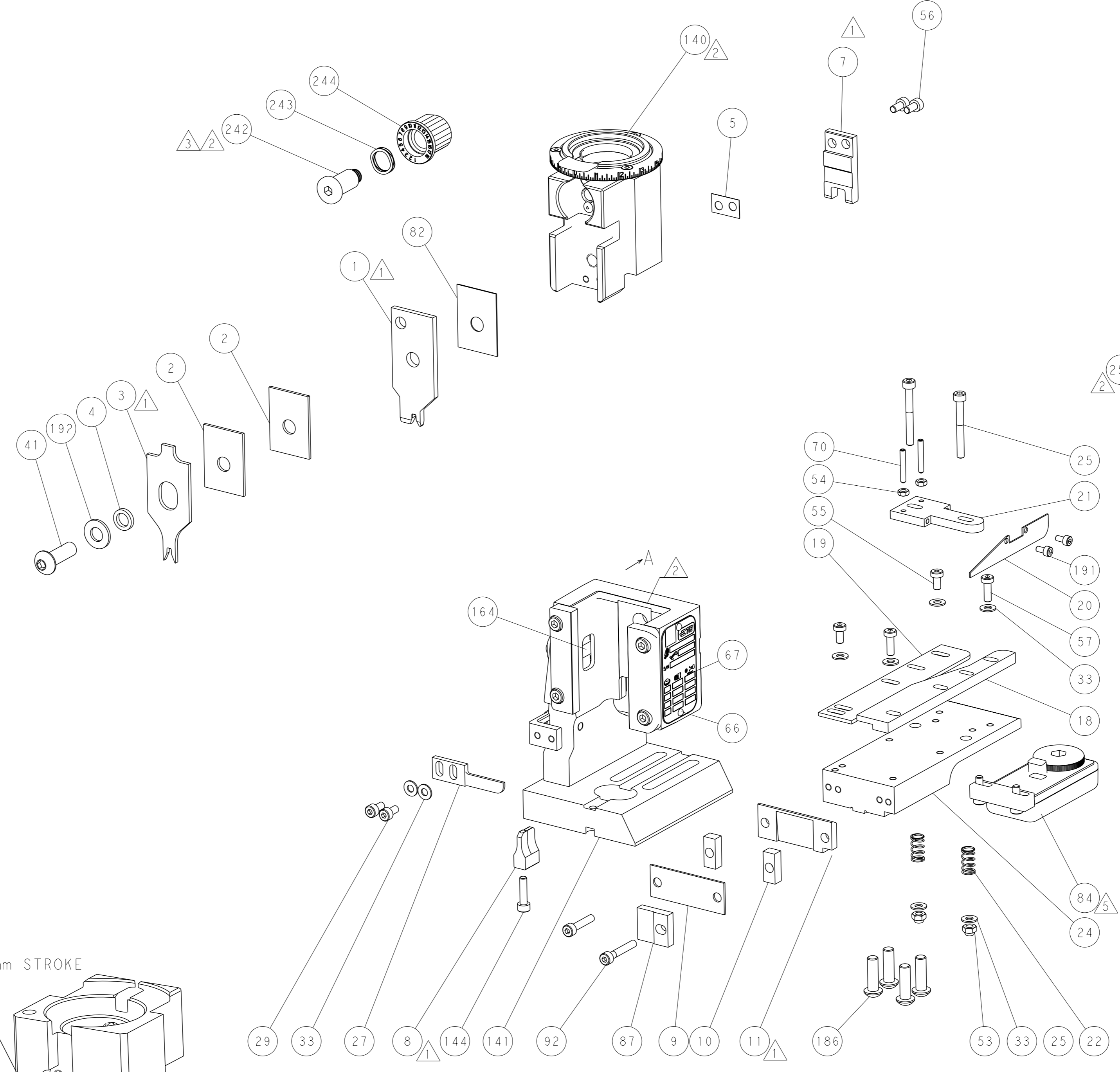
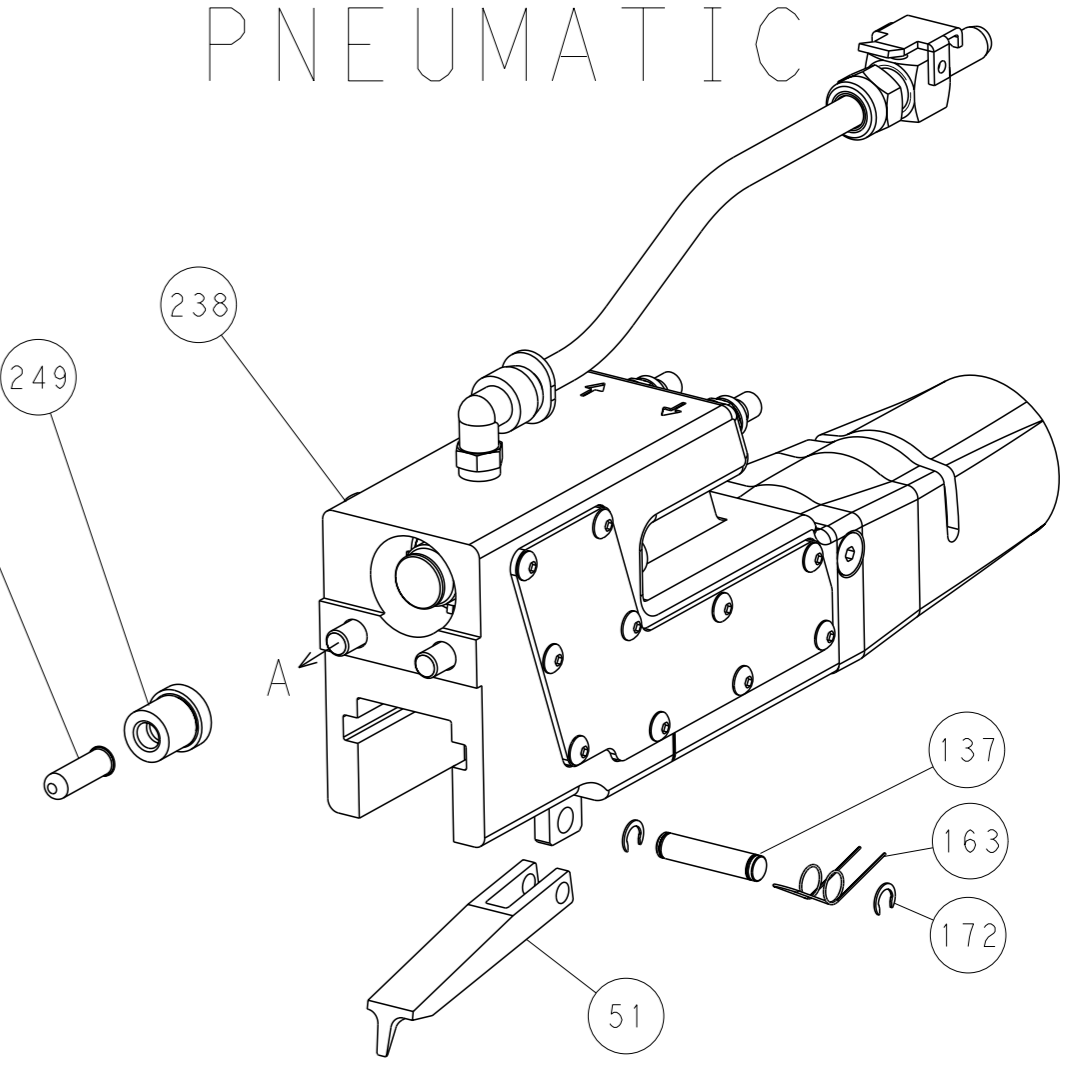


RAM SET-UP

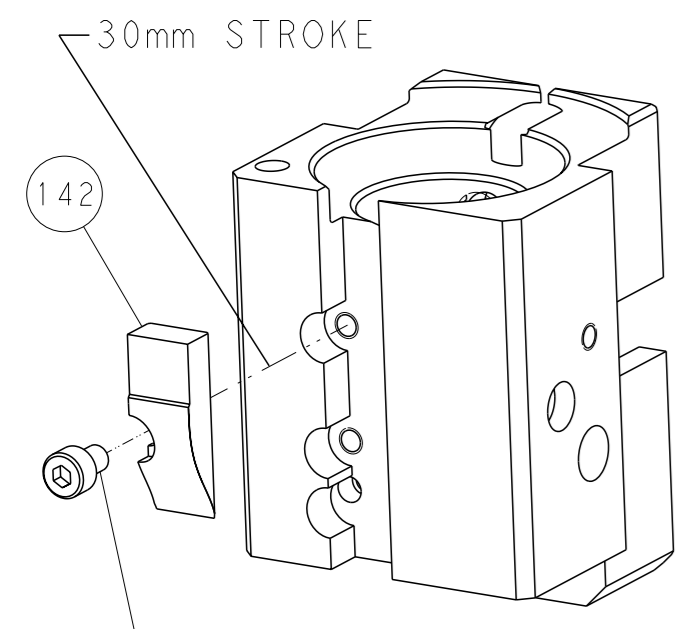
FEED TYPE
MECHANICAL



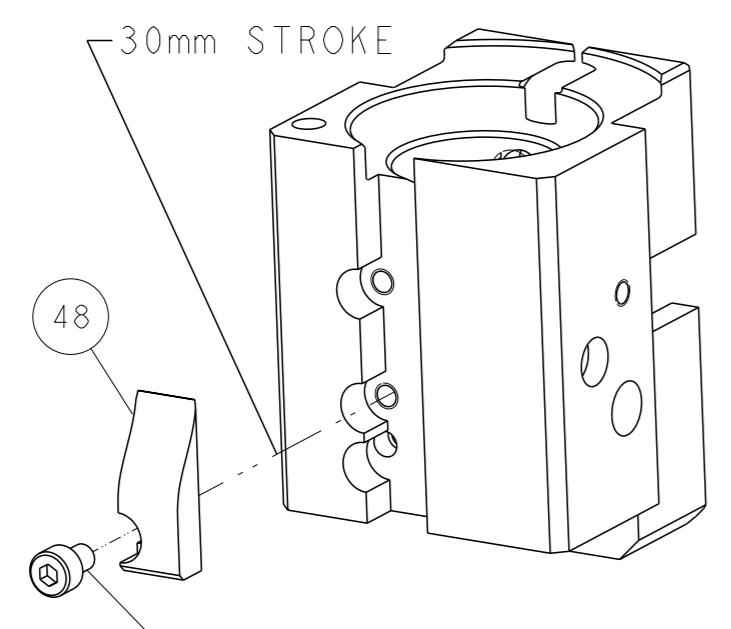
PNEUMATIC



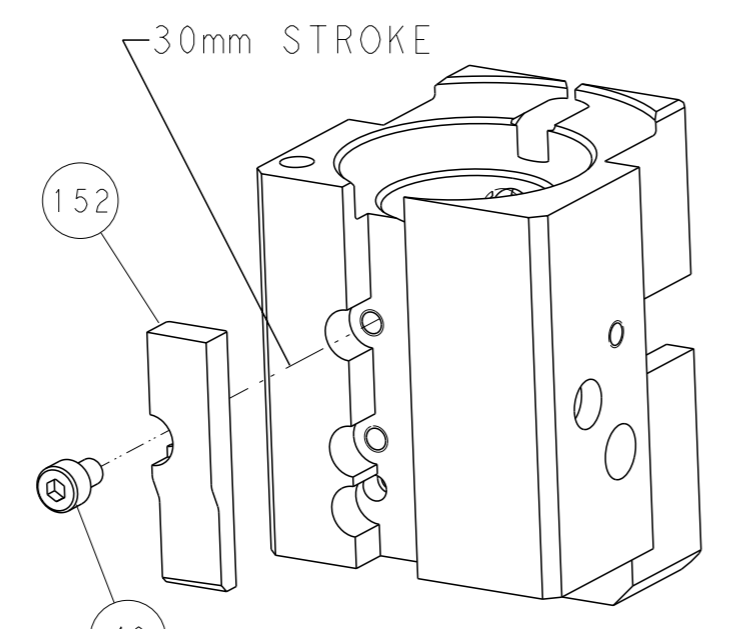
CAM POSITIONS



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)

<small>THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION 2015. IT IS SUBJECT TO CHANGE AND THE USER ASSUMES ALL RESPONSIBILITY FOR THE CORRECTNESS OF THE INFORMATION SHOWN ON THIS DRAWING.</small>		OWN: B. WEAVER 27FEB2015 CHK: T. ELBIN 27FEB2015 APVD: T. ELBIN 27FEB2015	NAME: TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH *	APPLICATION SPEC WEIGHT SCALE: 1:1	PRODUCT SPEC CUSTOMER ACCESSIBLE PRODUCTION DRAWING	SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2150532 SHEET 4 OF 4 REV C