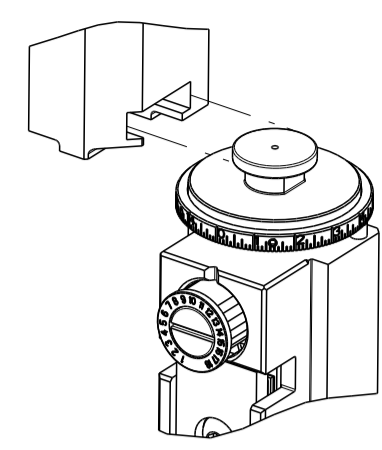


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150455-1	E	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2150455-2	E	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150455-1	E	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2150455-2	E	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150455-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP SIZE	TYPE	
WIRE 3.30 mm [.130]	F	
INSUL 5.08 mm [.200]	F	
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION
TERMINAL NAME: 6.35mm E-SPRING CONTACT RECEPTACLE		
WIRE STRIP LENGTH 4.42-5.18 mm [.174-.204 IN]	INSULATION DIAMETER RANGE Ø3.00-3.60 mm [.118-.142 IN]	
TERMINAL APPLICATION SPECIFICATION 114-22017		
TERMINALS APPLIED		
TE TERMINAL 336076-1	TE TERMINAL 336076-3	

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
2.50mm <sup>2</sup>	1.77+/-0.05 [.070+/-0.002]	5.8
1.00mm <sup>2</sup> + 1.00mm <sup>2</sup>	1.65+/-0.05 [.065+/-0.002]	7.5
0.50mm <sup>2</sup> + 1.5mm <sup>2</sup>	1.65+/-0.05 [.065+/-0.002]	7.5
0.75mm <sup>2</sup> + 1.00mm <sup>2</sup>	1.59+/-0.05 [.063+/-0.002]	8.0
1.50mm <sup>2</sup>	1.53+/-0.05 [.060+/-0.002]	8.7
0.75mm <sup>2</sup> + 0.75mm <sup>2</sup>	1.53+/-0.05 [.060+/-0.002]	8.8
0.50mm <sup>2</sup> + 1.00mm <sup>2</sup>	1.53+/-0.05 [.060+/-0.002]	8.9
0.50mm <sup>2</sup> + 0.75mm <sup>2</sup>	1.53+/-0.05 [.060+/-0.002]	8.8

- 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. APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 180.
- 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 LUBRICANT IS RECOMMENDED.

\*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.

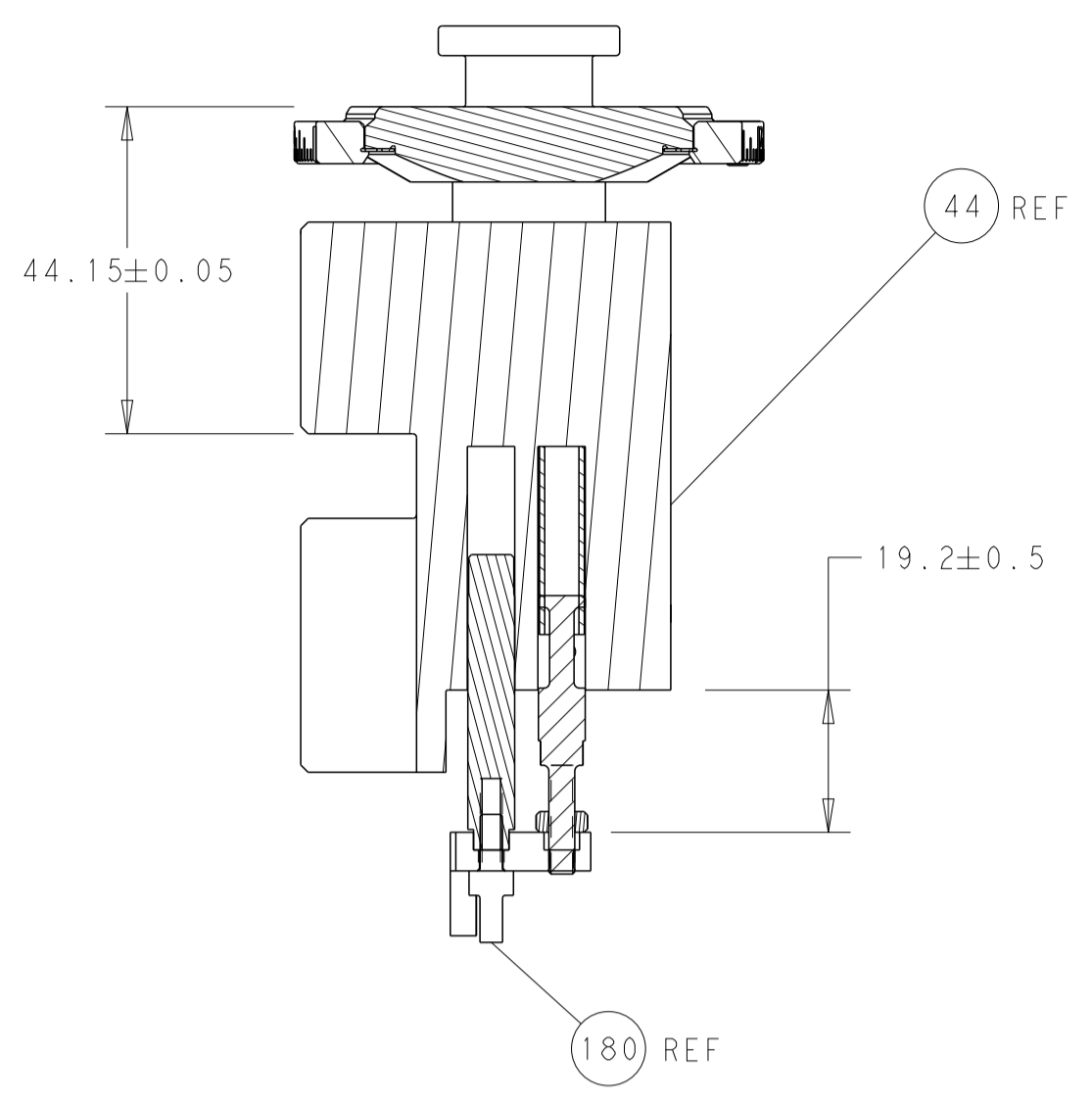
ATLANTIC VERSION  
Shown on sheets 1 of 4 & 2 of 4  
(Pacific version shown on sheets 3 of 4 & 4 of 4)

LOC	DIST	REVISIONS					
A	66	P	LTN	DESCRIPTION	DATE	OWN	APVD
		B		ECR-19-010288	01JUL2019	TB	GB
		C		ECR-20-000130	06JAN2020	TB	TE
		D		ECR-21-006397	30JUN2021	JWC	TE
		E		ECR-21-006981	21JUL2021	JWC	TE

-	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	-	2844940-3	AIR FEED MODULE	238	
-	1	1	1	1	1-18028-0	WASHER, FLAT, REG M8	192	
3	-	1	1	1	2-1976055-3	STANDOFF, HOLD-DOWN	180	
-	1	1	1	1	6-993111-6	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	
6	-	1	1	1	2119955-2	ASSY, LUBRICATOR, END FEED	84	
-	1	1	1	1	455888-5	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	2119740-1	TAG, IDENTIFICATION	67	
-	2	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66	
-	1	1	1	1	2-1901681-4	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	-	2063961-9	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	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	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	
-	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	1-240641-9	SPACER	16	
-	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	690482-6	PLATE, FRONT SHEAR	9	
1	1	2	2	1	1803060-8	ANVIL, COMBINATION, END FEED	8	
1	-	1	1	1	2217206-4	BLADE, SLUG	7	
-	-	-	-	-	-	-	6	
-	1	1	1	1	240641-1	SPACER	5	
-	1	1	1	1	238011-2	BLOCK, CRIMPER SPACER	4	
1	1	2	2	1	1	4-1803017-0	CRIMPER, INSULATION F	3
-	-	-	-	-	-	-	2	
1	1	2	2	1	1	7-1633730-0	CRIMPER, WIRE	1
-	-	-	-	-	-	-	-	
-	77	72	71	2	-1	PART NO	DESCRIPTION	
-	-	-	-	-	-	-	ITEM NO	

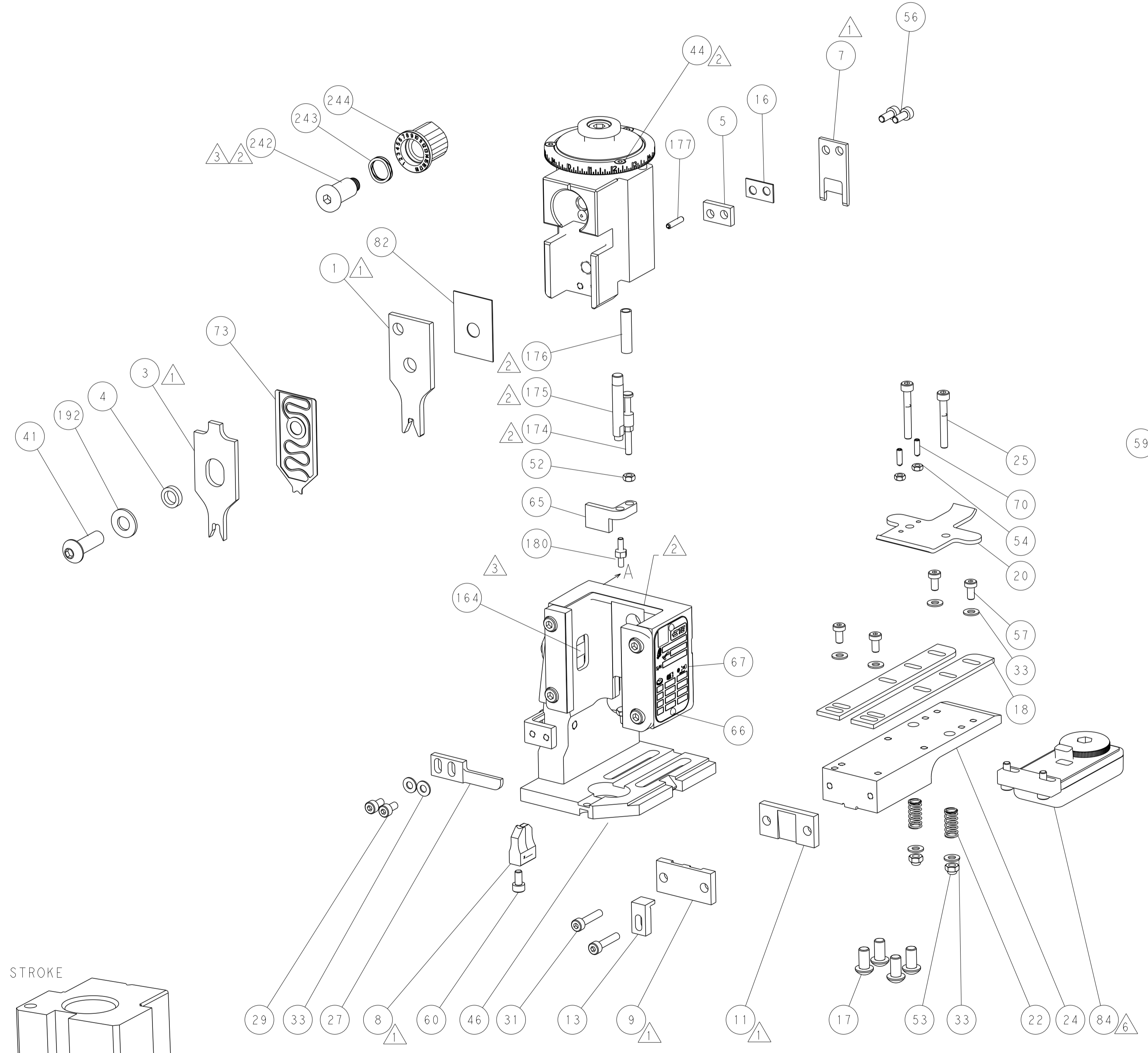
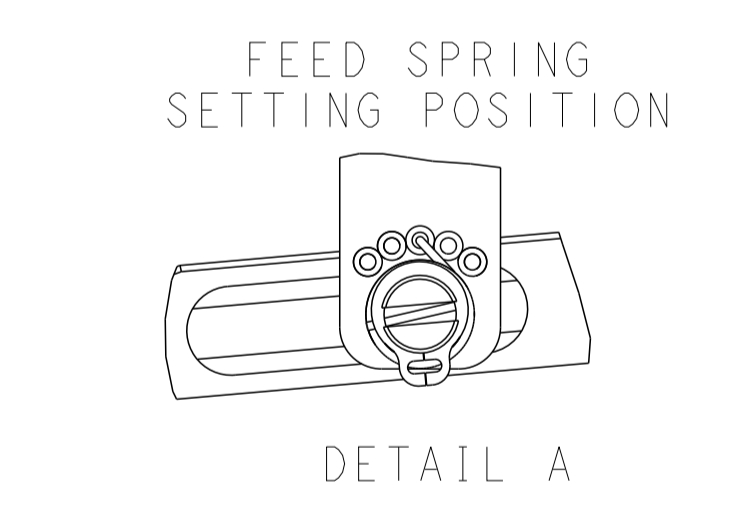
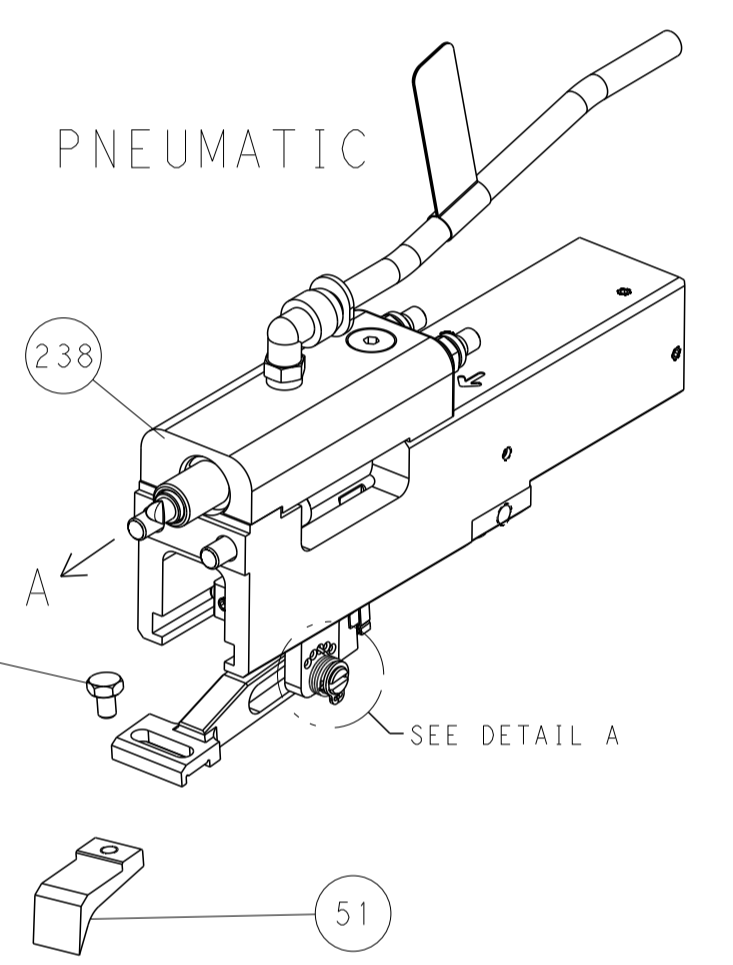
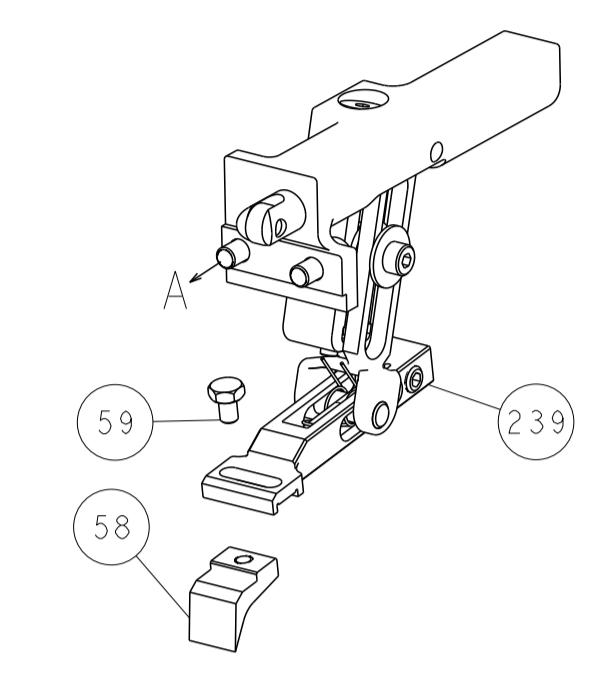
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG		NAME	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	APVD	NAME
	ANGLES	FINISH					
MATERIAL				WEIGHT		SIZE	CAGE CODE
						00779	2150455
						Customer Accessible Production Drawing	SCALE 1:1 SHEET 1 OF 4 REV E

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

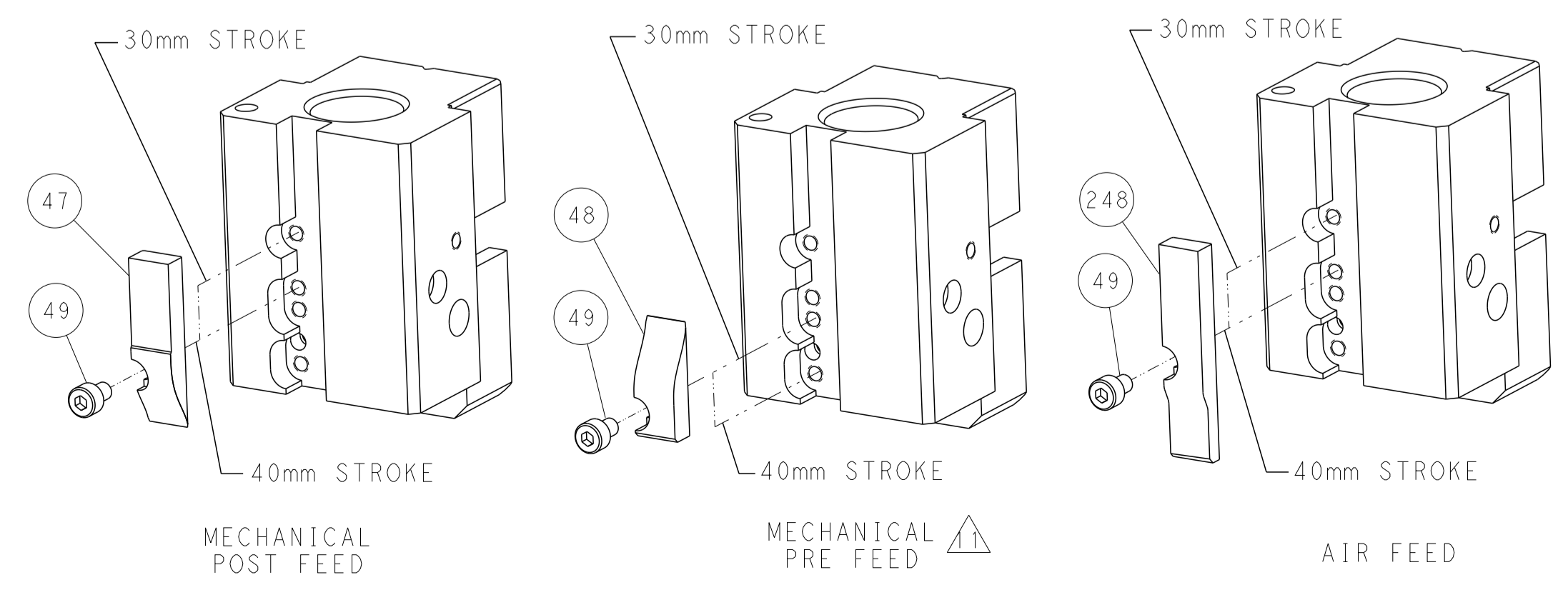


RAM AND HOLDDOWN SET-UP

# FEED TYPE MECHANICAL



# CAM POSITIONS

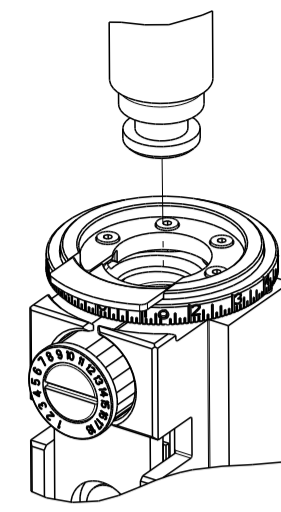


**ATLANTIC VERSION**  
 Shown on sheets 1 of 4 & 2 of 4  
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

<small>THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.</small>		DWN: HOFFNER 25JUNE2014 CHK: T.ELBIN 26JUNE2014 APVD: T.ELBIN 26JUNE2014	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 PRODUCT SPEC: APPLICATION SPEC: WEIGHT:	SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2150455 RESTRICTED TO:
MATERIAL:		SCALE: 1:1 SHEET: 2 of 4 REV: E	Customer Accessible Production Drawing

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150455-1	E	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2150455-2	E	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150455-7	A	CRIMP TOOLING KIT	-

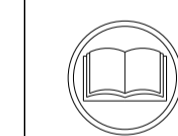
PACIFIC VERSION TERMINATOR  
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	3.30 mm [ .130 ]	F
INSUL	5.08 mm [ .200 ]	F
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: 6.35mm E-SPRING CONTACT RECEPTACLE			
WIRE STRIP LENGTH 4.42-5.18 mm [ .174-.204 IN ]		INSULATION DIAMETER RANGE Ø3.00-3.60 mm [ .118-.142 IN ]	
TERMINAL APPLICATION SPECIFICATION	114-22017	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
336076-1	336076-3		

WIRE SIZE	CRIMP HEIGHT mm [ INCH ]	CRIMP HEIGHT REFERENCE SETTING
2.50mm <sup>2</sup>	1.77+/-0.05 [ .070+/- .002 ]	5.8
1.00mm <sup>2</sup> + 1.00mm <sup>2</sup>	1.65+/-0.05 [ .065+/- .002 ]	7.5
0.50mm <sup>2</sup> + 1.5mm <sup>2</sup>	1.65+/-0.05 [ .065+/- .002 ]	7.5
0.75mm <sup>2</sup> + 1.00mm <sup>2</sup>	1.59+/-0.05 [ .063+/- .002 ]	8.0
1.50mm <sup>2</sup>	1.53+/-0.05 [ .060+/- .002 ]	8.7
0.75mm <sup>2</sup> + 0.75mm <sup>2</sup>	1.53+/-0.05 [ .060+/- .002 ]	8.8
0.50mm <sup>2</sup> + 1.00mm <sup>2</sup>	1.53+/-0.05 [ .060+/- .002 ]	8.9
0.50mm <sup>2</sup> + 0.75mm <sup>2</sup>	1.53+/-0.05 [ .060+/- .002 ]	8.8



- 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. APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 180.
- 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.
- UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- TERMINAL LUBRICANT IS RECOMMENDED.

**\*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	-	-	-

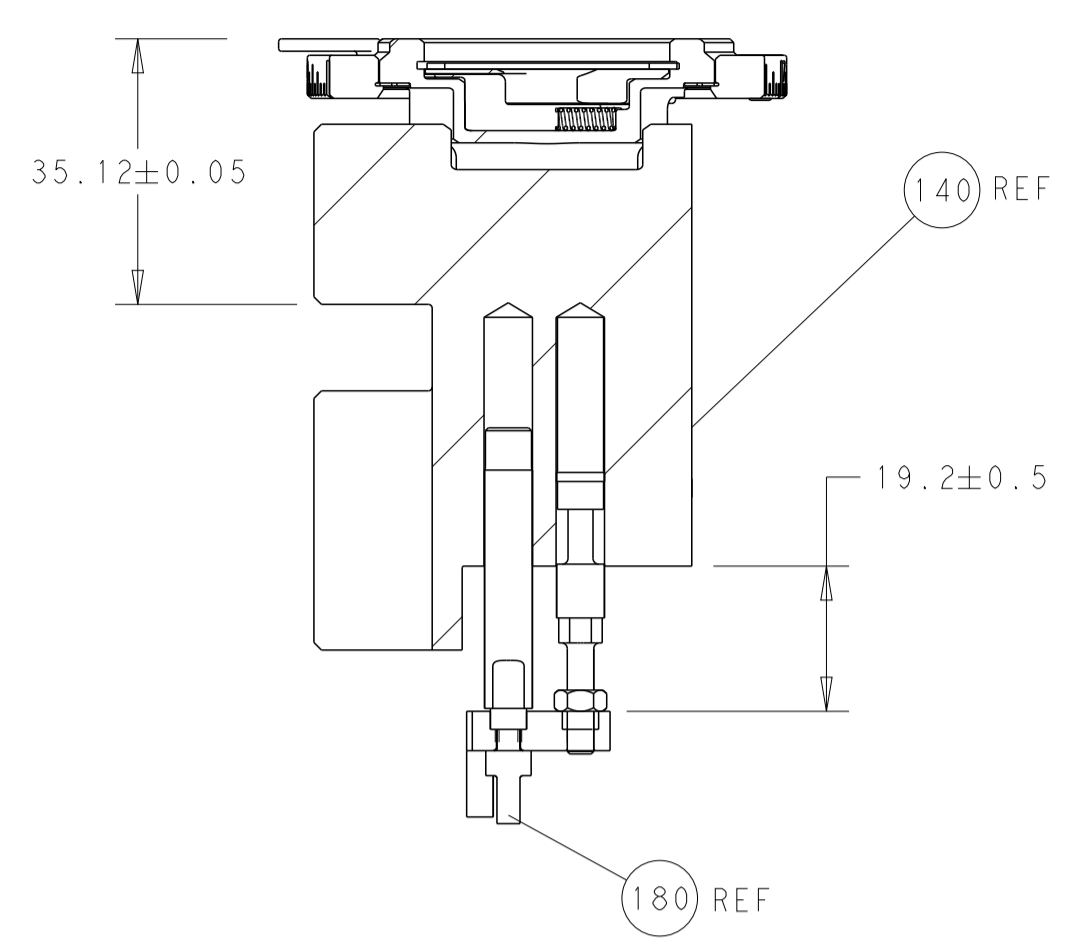
-	1	1	2119082-7	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
3	-	1	2119083-1	RETAINER, INSULATION DIAL	242
-	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	1	-	2844940-3	AIR FEED MODULE	238
-	1	1	1-18028-0	WASHER, FLAT, REG M8	192
-	4	4	2079383-9	SCR, BHSC, RoHS (M6 X 20)	186
3	-	1	2-1976055-3	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
-	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
6	-	1	2119955-2	ASSY, LUBRICATOR, END FEED	84
-	1	1	455888-5	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	2-1901681-4	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	-	2063961-9	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	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	1752371-5	PLATE, STRIP GUIDE	24
-	2	2	2-22281-3	SPRING, COMPRESSION	22
-	1	1	1803292-4	DRAG	20
-	2	2	1901259-5	GUIDE, LOWER STRIP	18
-	1	1	1-240641-9	SPACER	16
-	1	1	1752360-1	SPACER, HOLD-DOWN	13
1	-	1	240644-1	PLATE, REAR SHEAR	11
-	-	-	-	-	10
1	-	1	690482-6	PLATE, FRONT SHEAR	9
1	1	1	1803060-8	ANVIL, COMBINATION, END FEED	8
1	-	1	2217206-4	BLADE, SLUG	7
-	-	-	-	-	6
-	1	1	240641-1	SPACER	5
-	1	1	238011-2	BLOCK, CRIMPER SPACER	4
1	1	1	4-1803017-0	CRIMPER, INSULATION F	3
-	-	-	-	-	2
1	1	1	7-1633730-0	CRIMPER, WIRE	1
-	77	22	21	PART NO	ITEM NO

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DRAWING NO	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±
ANGLES	FINISH		SCALE		
MATERIAL	FINISH		SCALE		
WEIGHT		SCALE		REV	
Customer Accessible Production Drawing		SCALE 1:1		SHEET 3 OF 4	



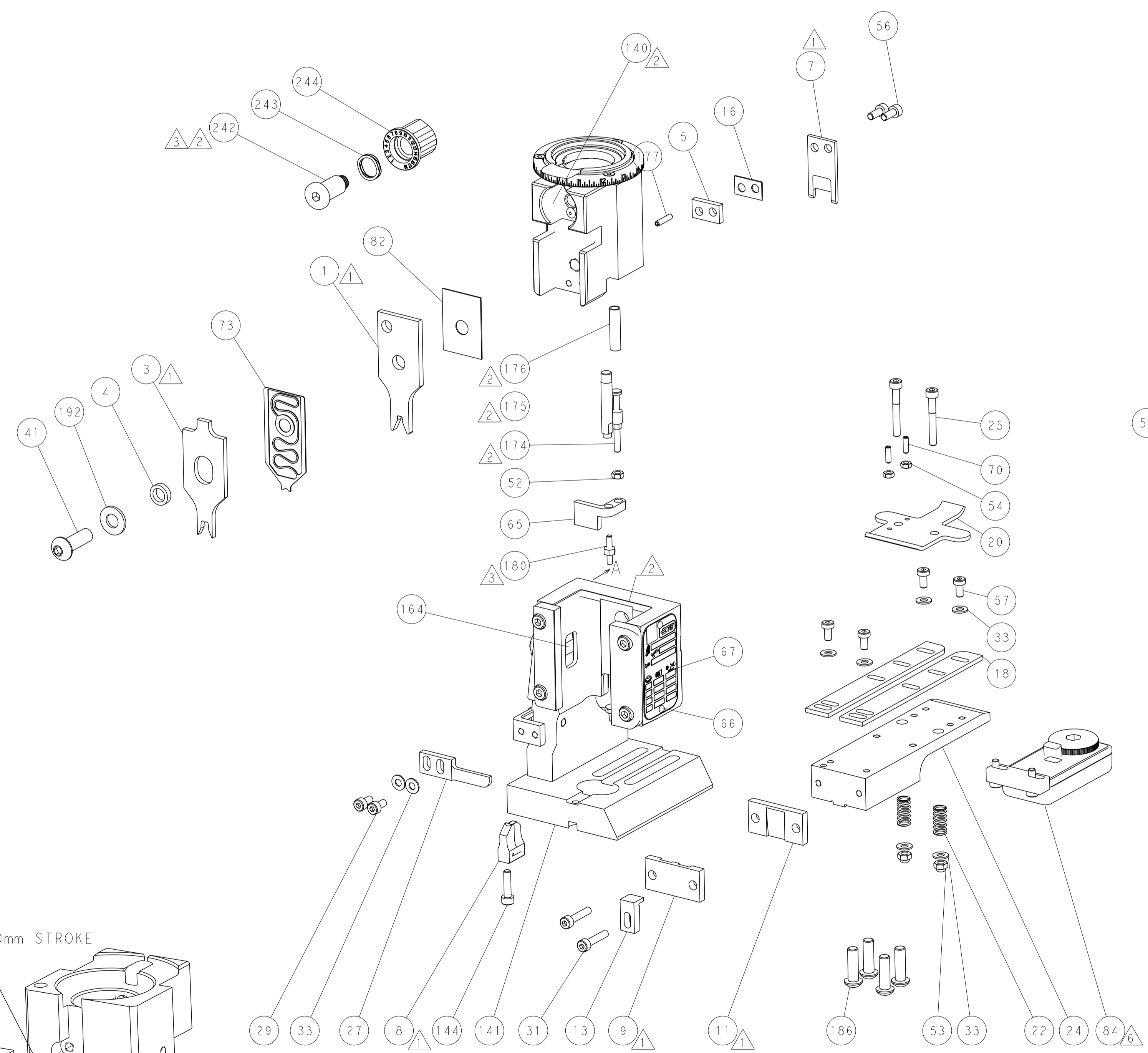
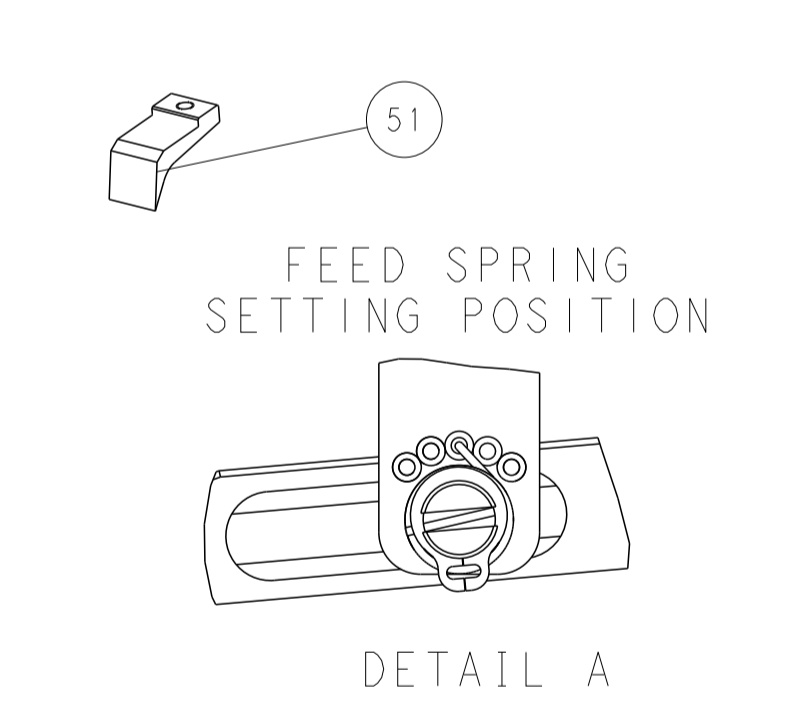
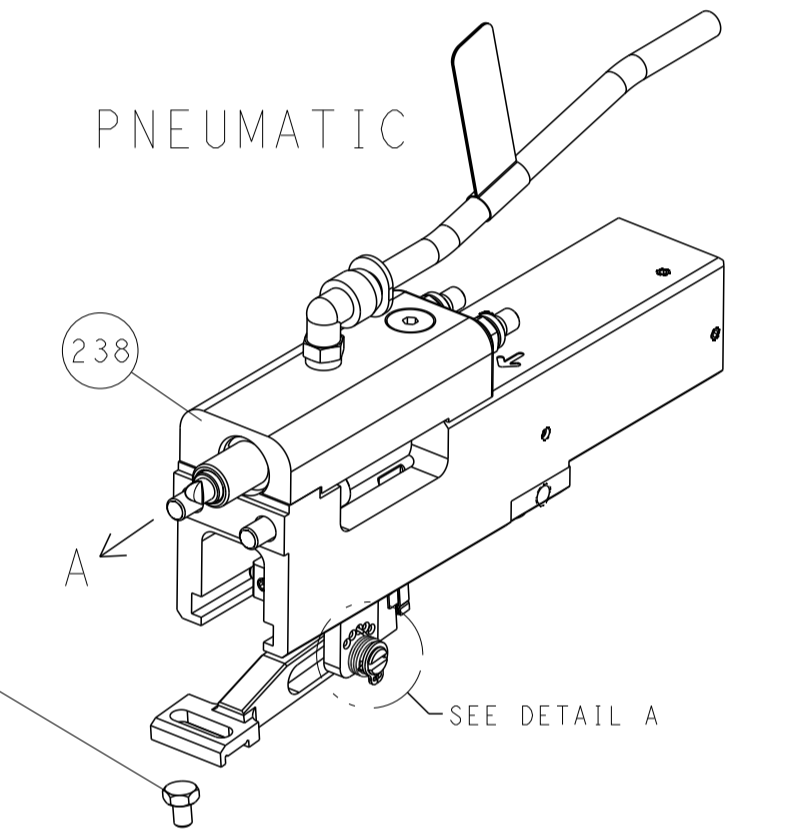
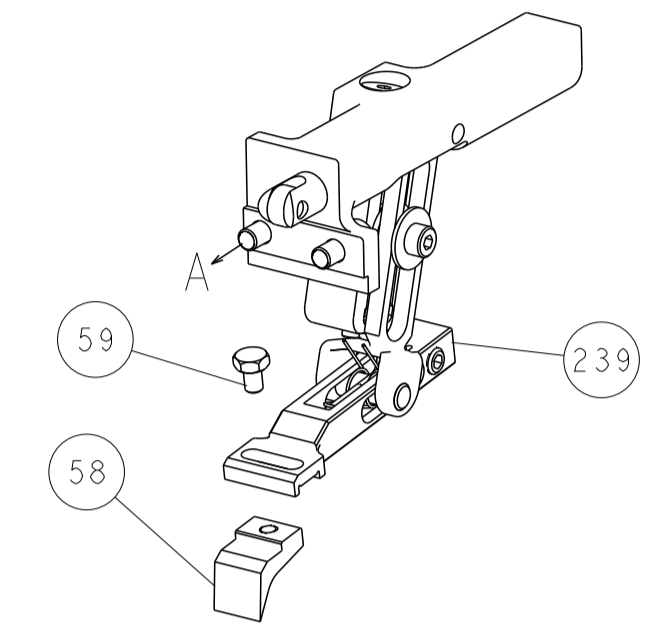
Ocean End Feed  
Applicator

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

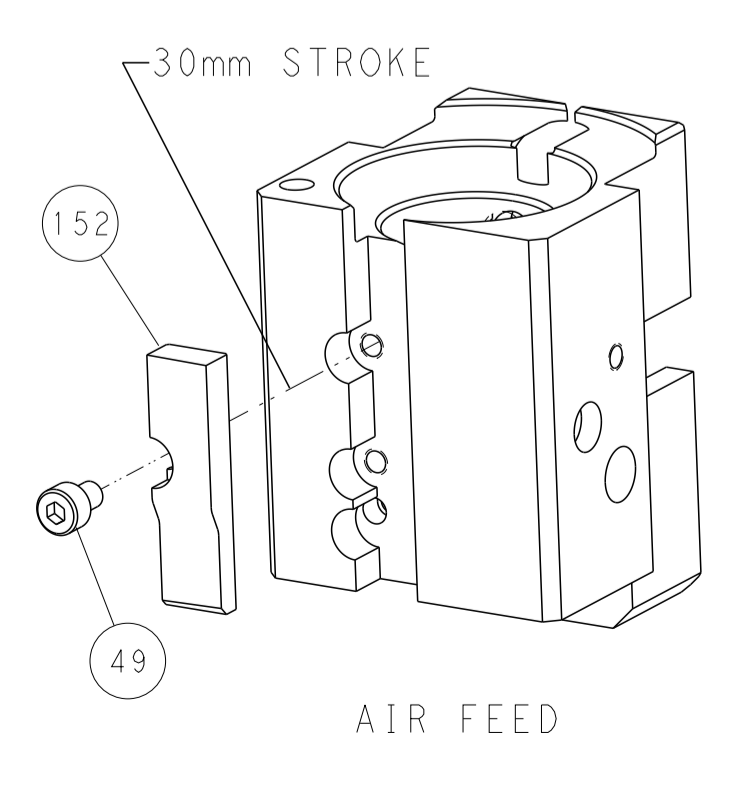
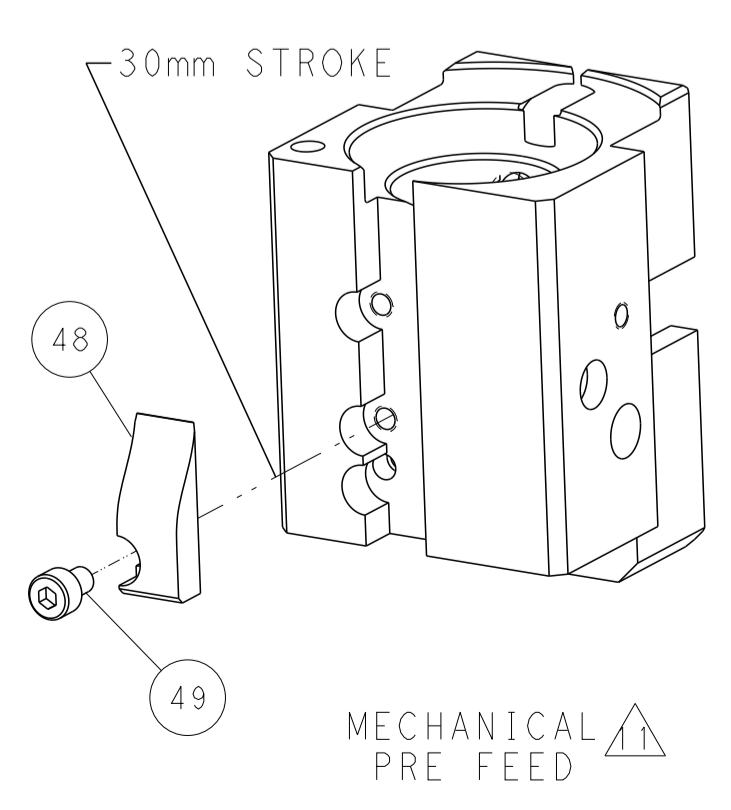
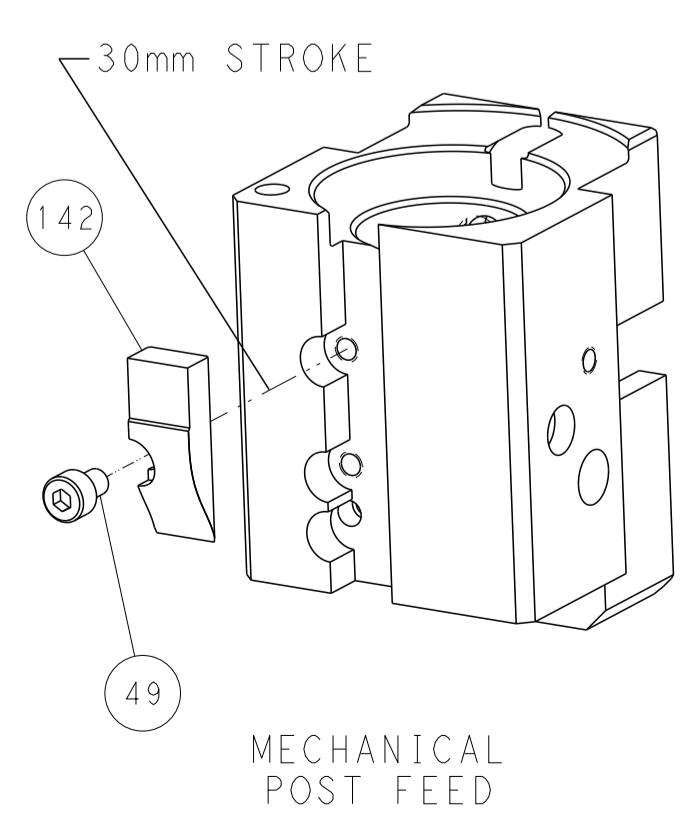


RAM AND HOLDDOWN SET-UP

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: HOFFNER 25 JUNE 2014		TE Connectivity	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	5 PLC ±	Harrisburg, PA 17105-3608
	ANGLES	FINISH		APVD: T. ELBIN 26 JUNE 2014	NAME: Ocean End Feed Applicator		
MATERIAL:				PRODUCT SPEC	SIZE: CAGE CODE: DRAWING NO: RESTRICTED TO		
				APPLICATION SPEC	A1 00779 ©=2150455		
				WEIGHT	Customer Accessible Production Drawing SCALE: 1:1 SHEET 4 OF 4 REV E		