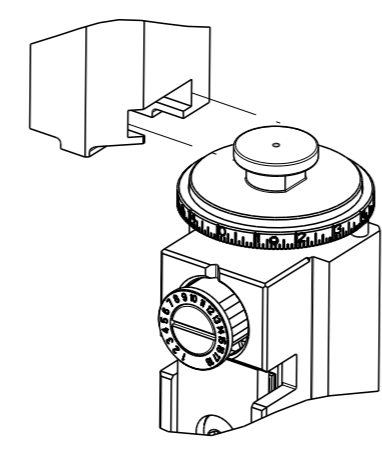


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150352-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150352-2	C	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150352-7	C	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.29 mm [.090]	F
INSUL	3.30 mm [.130]	F
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: ESCUBEDO TERMINAL ESCUBEDO CRIMP SPECIFICATION			
TERMINAL NAME: AMP MCP 2.8K FLAT TYPE RECEPTACLE			
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE		
4.00-5.00 mm [.157-.197 IN]	∅ 1.80-2.50 mm [.071-.098 IN]		
TERMINAL APPLICATION SPECIFICATION	7500/8500 Rev -	-	-
TERMINALS APPLIED			
TE TERMINAL	ESCUBEDO TERMINAL	TE TERMINAL	ESCUBEDO TERMINAL
2113359-1	7500.02	2113359-3	7500.00
2113359-2	7500.01	2113359-4	3514752001

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.00mm2	1.35 +/- 0.05 [1.053 +/- .002]	6.0
0.75mm2	1.25 +/- 0.05 [1.049 +/- .002]	7.0
0.50mm2	1.15 +/- 0.05 [1.045 +/- .002]	8.0

- 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 ITEMS 50. 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 PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- 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.

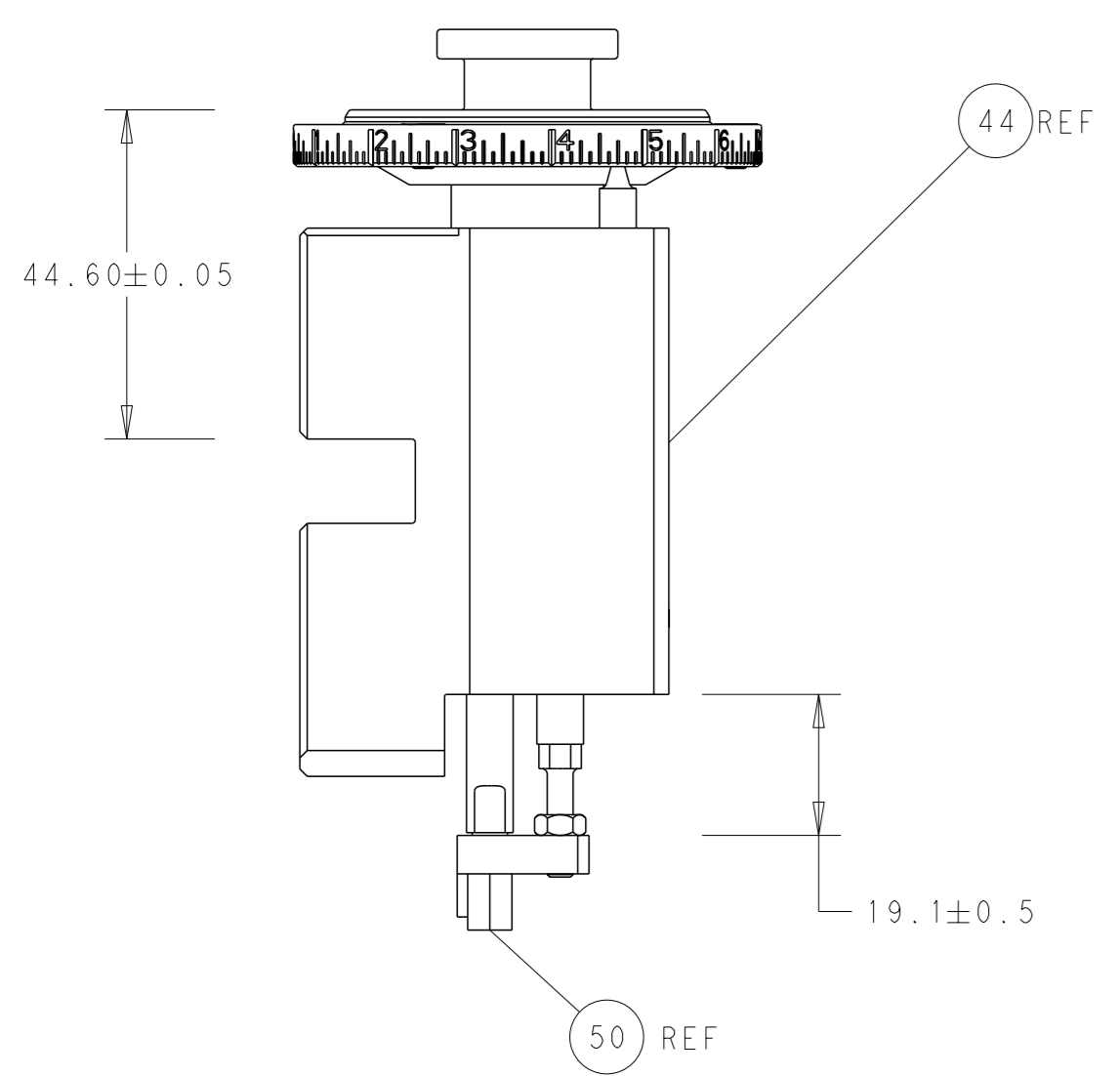
ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

LOC	DIST	REVISIONS					
A	66	P	LYR	DESCRIPTION	DATE	OWN	APVD
		A		RELEASED	20NOV2013	RK	GB
		B		ECR-20-010199	17JUL2020	FJ	TE
		C		ECR-20-013851	28SEP2020	JWC	GB

-	1	1	2119641-1	FEED CAM, AIR FEED	248
-	1	1	2119082-3	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	6-9931111-6	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	1	455888-6	SPACER, CRIMPER	82
-	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	1901681-9	HOLDDOWN, TERMINAL	65
-	2	2	2168400-5	SHCS, LOW HEAD, RoHS, M4 X 20	64
-	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
-	3	3	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57
-	2	2	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	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	1-2063961-0	FEED FINGER	51
-	1	1	1-1752354-5	STANDOFF,HOLD-DOWN	50
-	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
-	7	7	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	1752371-3	PLATE, STRIP GUIDE	24
-	1	1	240825-7	PLATE, STRIP HOLD DOWN	23
-	2	2	2-22281-3	SPRING, COMPRESSION	22
-	1	1	1803292-4	DRAG	20
-	2	2	1901259-5	GUIDE, LOWER STRIP	18
-	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17
-	1	1	3-240641-2	SPACER	16
-	1	1	1752360-1	SPACER,HOLD-DOWN	13
-	1	1	240833-1	PLATE, REAR SHEAR	11
-	2	2	1-240645-6	SPACER, SHEAR PLATE	10
-	1	1	1803322-2	PLATE, FRONT SHEAR	9
1	2	1	3-1803001-0	ANVIL, COMBINATION, END FEED	8
-	1	1	9-240651-0	BLADE, SLUG	7
-	-	-	-	-	6
-	1	1	4-240641-5	SPACER	5
-	1	1	3-238011-5	BLOCK, CRIMPER SPACER	4
1	2	1	1-1803016-4	CRIMPER, INSULATION F	3
-	1	1	455888-6	SPACER, CRIMPER	2
1	2	1	2-456406-3	CRIMPER, WIRE PREMIUM	1
-	77	72	2	PART NO	ITEM NO

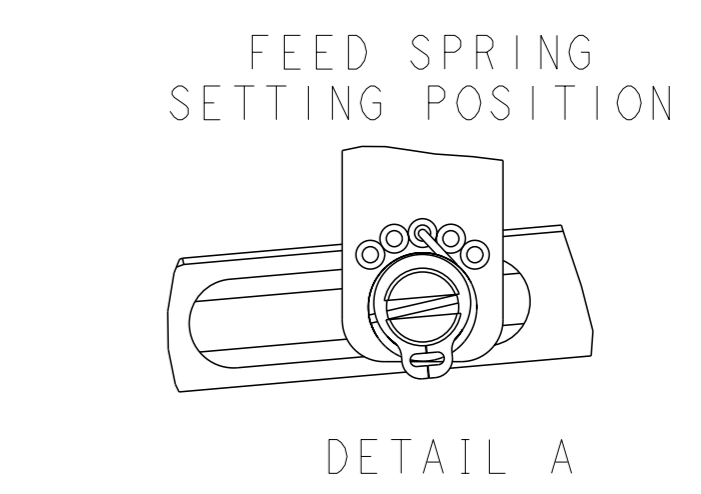
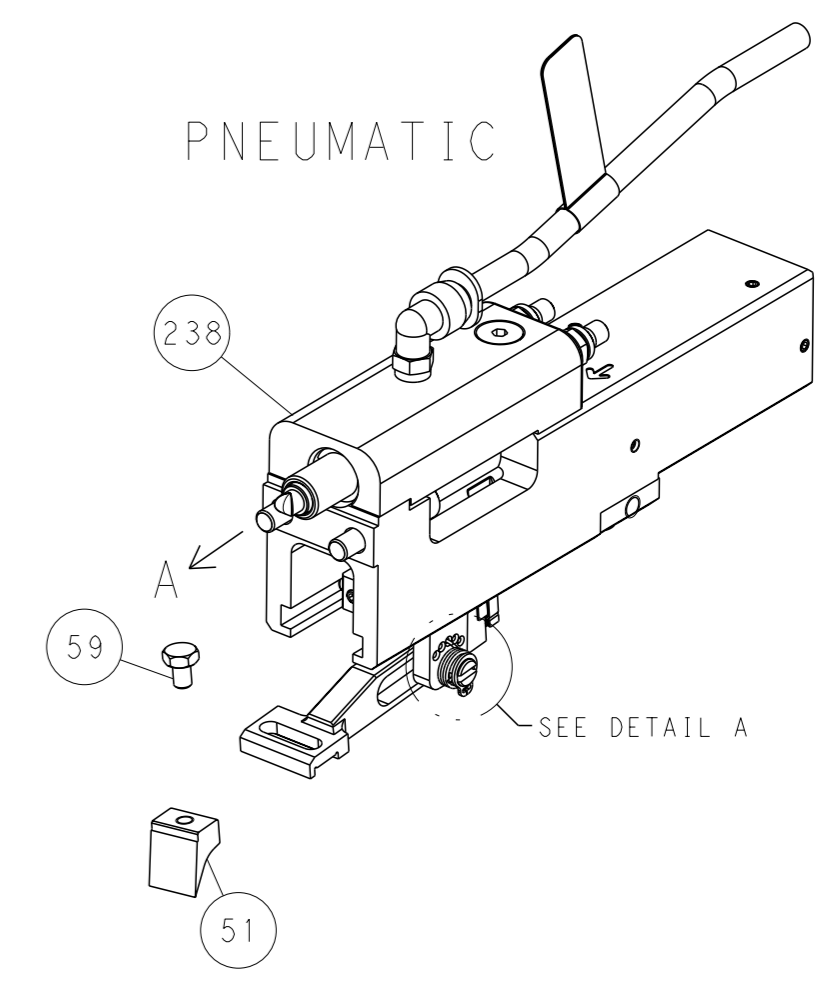
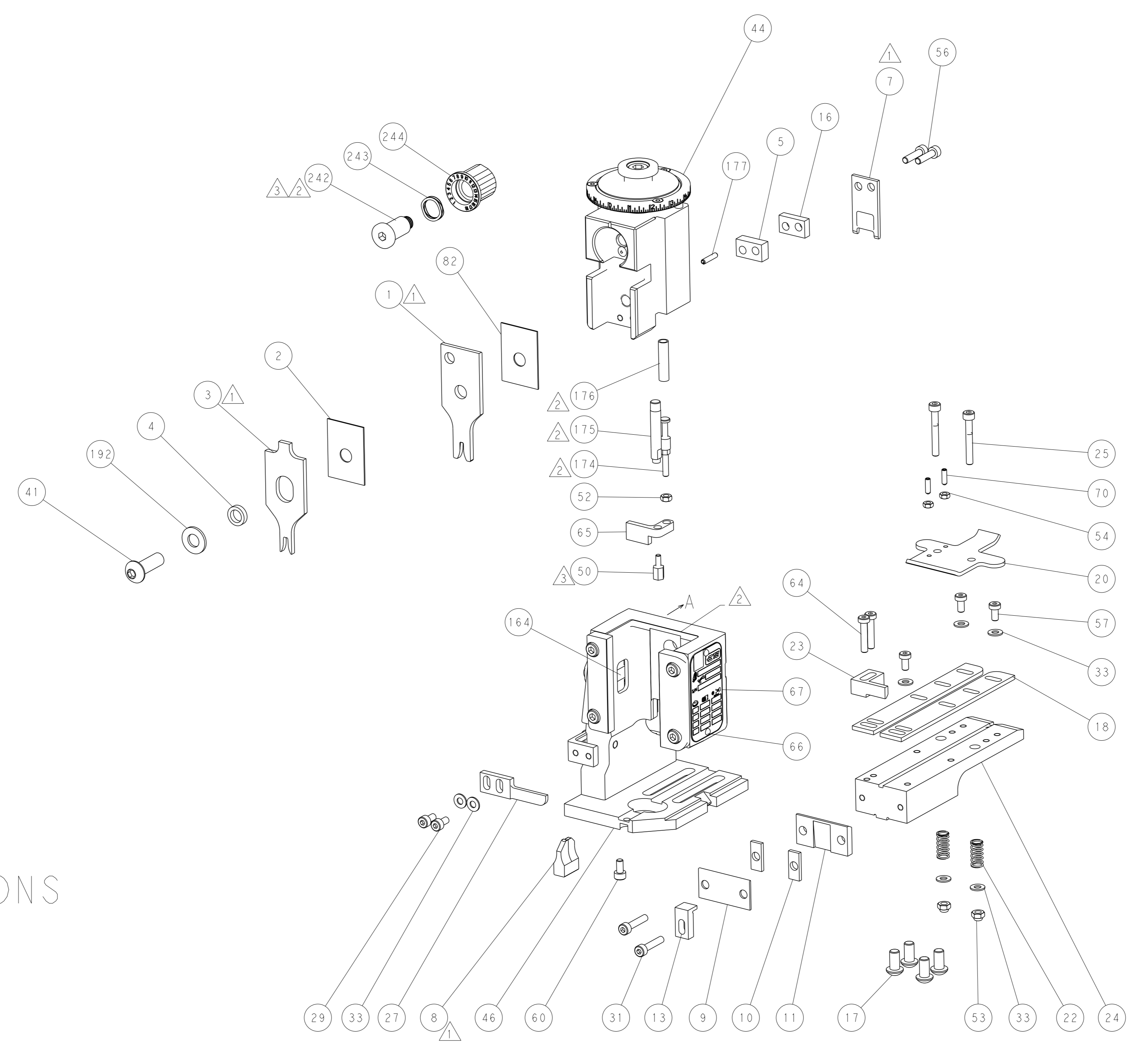
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		OWN: BOB HIGMAN 24SEPT2013		TE Connectivity Harrisburg, PA 17105-3608	
mm		0 PLC ±		CHK: T. ELBIN 242013		NAME: Ocean End Feed Applicator	
1 PLC ±		2 PLC ±		APVD: M. CLIFFORD 24SEPT2013		SIZE: A1	
3 PLC ±		4 PLC ±		PRODUCT SPEC		CAGE CODE: 00779	
5 PLC ±		FINISH: *		APPLICATION SPEC		DRAWING NO: 2150352	
MATERIAL:		WEIGHT:		RESTRICTED TO:		SCALE: 1:1	
:		:		Customer Accessible Production Drawing		SHEET 1 OF 4	

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

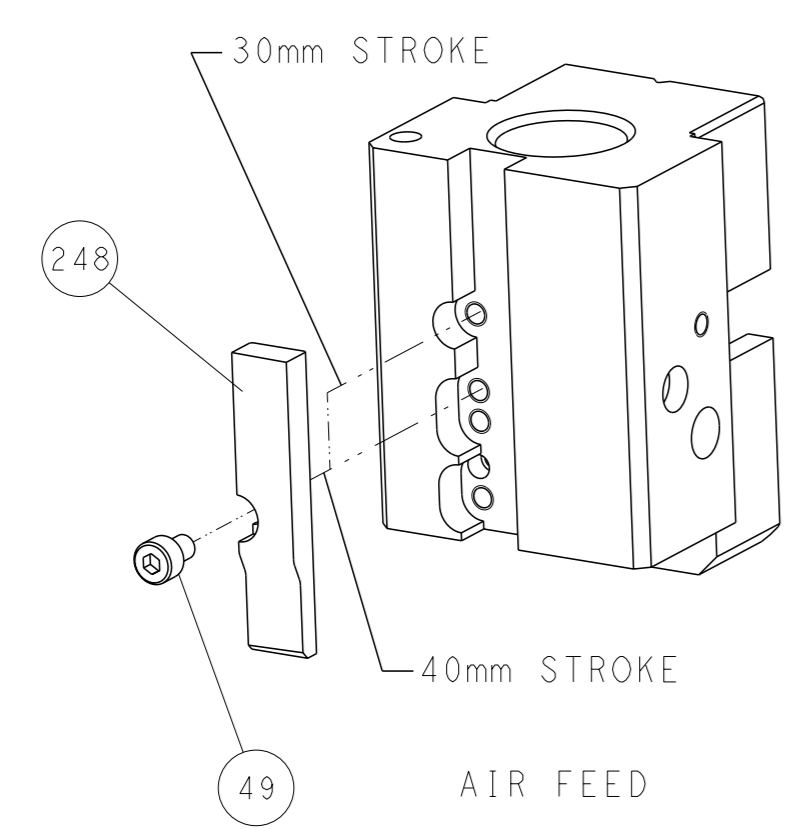


RAM AND HOLDDOWN SET-UP

FEED TYPE



CAM POSITIONS

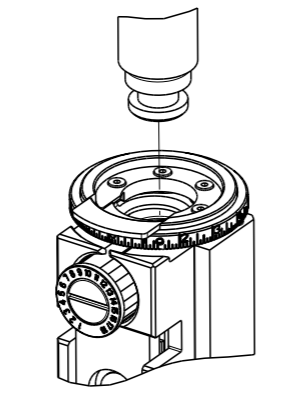


ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

<small>THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION 20 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.</small>		OWN: BOB HIGMAN CDR: T. ELBIN APVD: M. CLIFFORD	24SEPT2013 242013 24SEPT2013	NAME: Ocean End Feed Applicator
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH *	WEIGHT: - SCALE: 1:1	SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2150352	RESTRICTED TO: - SHEET: 2 of 4 REV: C	CUSTOMER ACCESSIBLE PRODUCTION DRAWING

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150352-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150352-7	C	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
 INTERFACE ADAPTER



APPLICATOR DATA

CRIMP	SIZE	TYPE
WIRE	2.29 mm [.090]	F
INSUL	3.30 mm [.130]	F

APPLICATOR INSTRUCTIONS
 408-35042

TERMINAL DATA: ESCUBEDO TERMINAL ESCUBEDO CRIMP SPECIFICATION

TERMINAL NAME: AMP MCP 2.8K FLAT TYPE RECEPTACLE

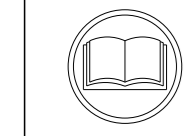
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE
4.00-5.00 mm [.157-.197 IN]	∅ 1.80-2.50 mm [.071-.098 IN]

TERMINAL APPLICATION SPECIFICATION 7500/8500 Rev -

TERMINALS APPLIED 5

TE TERMINAL	ESCUBEDO TERMINAL	TE TERMINAL	ESCUBEDO TERMINAL
2113359-1	7500.02	2113359-3	7500.00
2113359-2	7500.01	2113359-4	3514752001

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.00mm2	1.35+/-0.05 [.053+/-0.002]	6.0
0.75mm2	1.25+/-0.05 [.049+/-0.002]	7.0
0.50mm2	1.15+/-0.05 [.045+/-0.002]	8.0



- 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 ITEMS 50. 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 PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- 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.

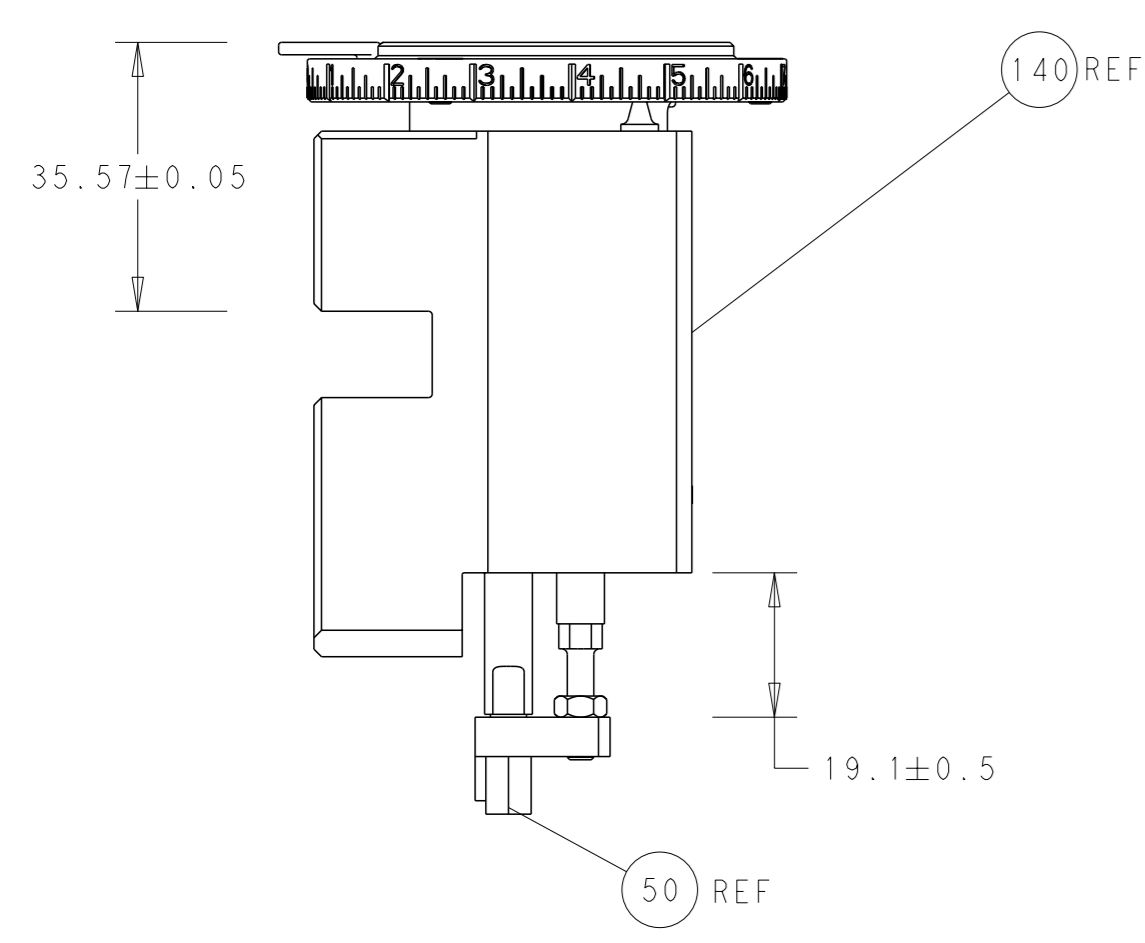
PACIFIC VERSION
 Shown on sheets 3 of 4 & 4 of 4
 (Atlantic version shown on sheets 1 of 4 & 2 of 4)

LOC	DIST	REV	DATE	BY	APPV
A	66	-	-	-	-

REV	DATE	DESCRIPTION	ITEM NO	
-	1	2119082-3	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	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
-	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	2119656-6	APPLICATOR BASIC ASSEMBLY, EF	141
-	1	1803518-1	RAM ASSEMBLY, EF PACIFIC	140
-	1	455888-6	SPACER, CRIMPER	82
-	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	1901681-9	HOLDDOWN, TERMINAL	65
-	2	2168400-5	SHCS, LOW HEAD, RoHS, M4 X 20	64
-	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	3	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57
-	2	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	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	1-2063961-0	FEED FINGER	51
-	1	1-1752354-5	STANDOFF, HOLD-DOWN	50
-	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
-	7	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	1752371-3	PLATE, STRIP GUIDE	24
-	1	240825-7	PLATE, STRIP HOLD DOWN	23
-	2	2-22281-3	SPRING, COMPRESSION	22
-	1	1803292-4	DRAG	20
-	2	1901259-5	GUIDE, LOWER STRIP	18
-	1	3-240641-2	SPACER	16
-	1	1752360-1	SPACER, HOLD-DOWN	13
-	1	240833-1	PLATE, REAR SHEAR	11
-	2	1-240645-6	SPACER, SHEAR PLATE	10
-	1	1803322-2	PLATE, FRONT SHEAR	9
1	1	3-1803001-0	ANVIL, COMBINATION, END FEED	8
-	1	9-240651-0	BLADE, SLUG	7
-	-	-	-	6
-	1	4-240641-5	SPACER	5
-	1	3-238011-5	BLOCK, CRIMPER SPACER	4
1	1	1-1803016-4	CRIMPER, INSULATION F	3
-	1	455888-6	SPACER, CRIMPER	2
1	1	2-456406-3	CRIMPER, WIRE PREMIUM	1
-	77-22	PART NO	DESCRIPTION	ITEM NO

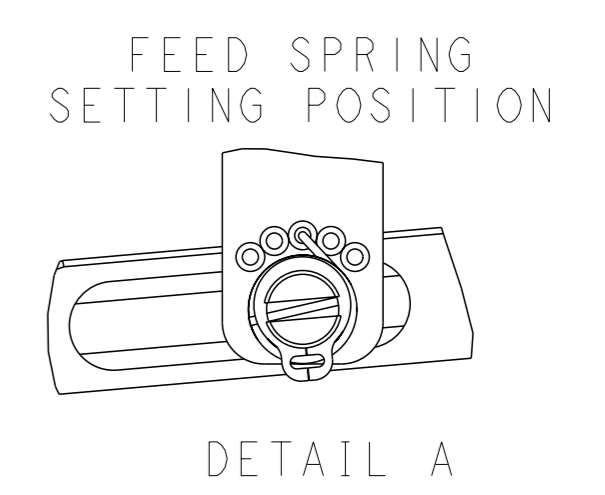
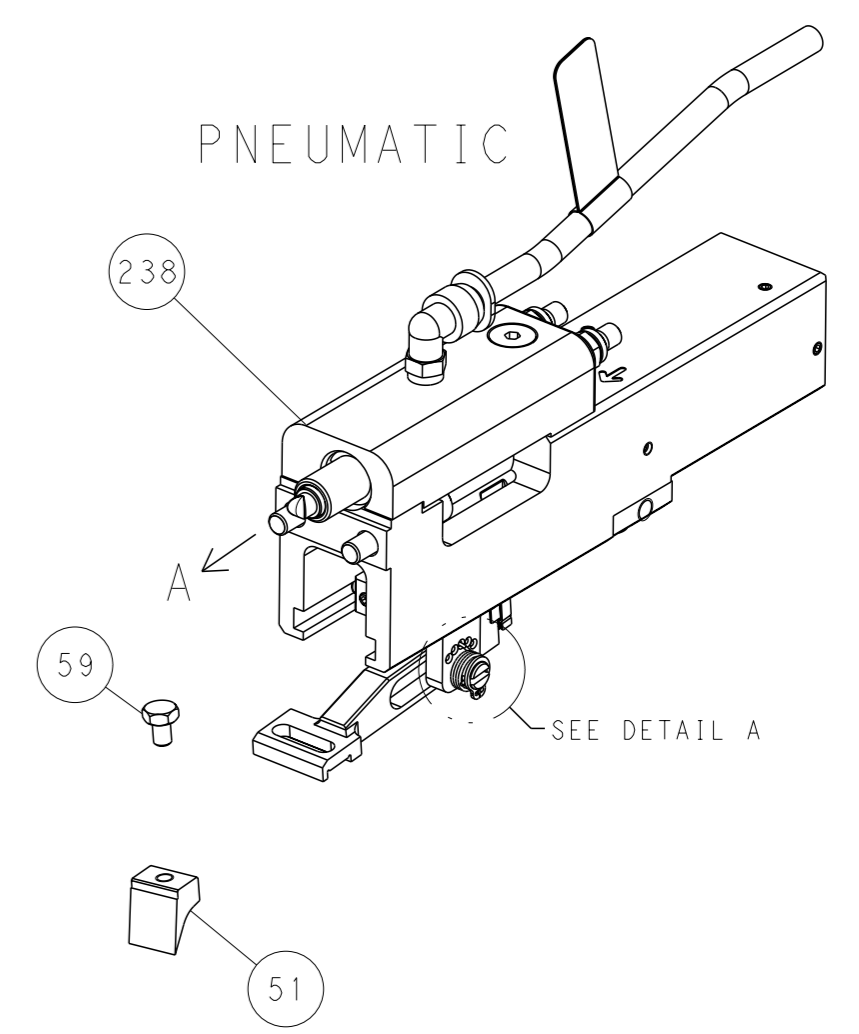
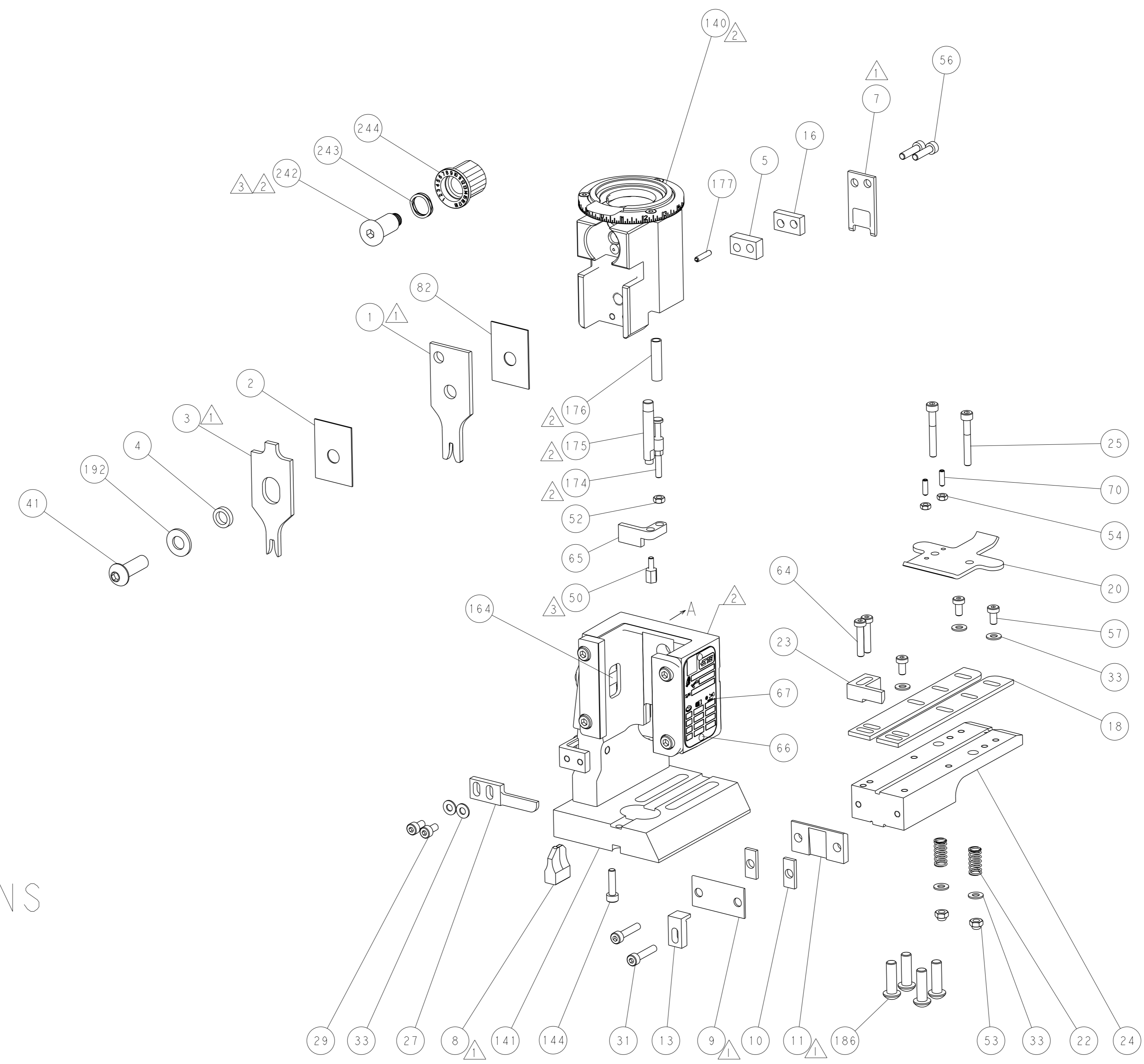
DIMENSIONS: mm 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH ±		TOLERANCES UNLESS OTHERWISE SPECIFIED: ± ± ± ± ±		DWN BOB HIGMAN 24SEPT2013 CHK T. ELBIN 242013 APVD M. CLIFFORD 24SEPT2013 PRODUCT SPEC APPLICATION SPEC WEIGHT SCALE 1:1 SHEET 3 OF 4 REV C		NAME Ocean End Feed Applicator SIZE CAGE CODE DRAWING NO 00779 C=2150352 RESTRICTED TO Customer Accessible Production Drawing	
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LOC	DIST	REVISIONS			
A	66	REV	DATE	OWN	APVD
		-			
		SEE SHEET 1			

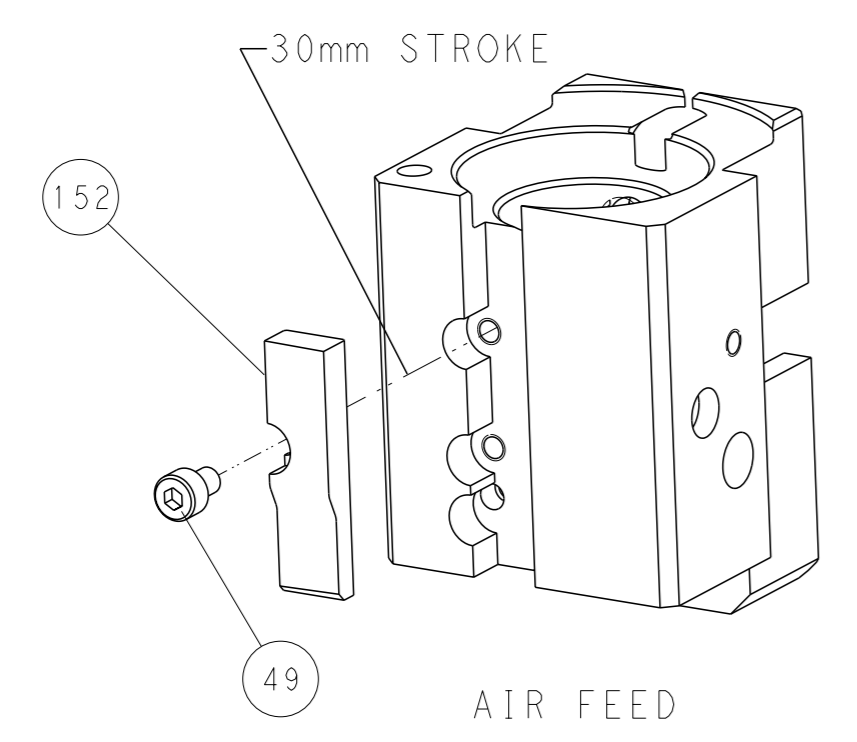


RAM AND HOLDDOWN SET-UP

FEED TYPE



CAM POSITIONS



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 A CONTROLLED DOCUMENT FROM TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE AND THE USER'S RESPONSIBILITY TO VERIFY THE LATEST REVISION SHOULD BE CONTACTED FOR THE LATEST REVISION.</small>		OWN: BOB HIGMAN CDR: T. ELBIN APVD: M. CLIFFORD	24SEPT2013 242013 24SEPT2013	NAME: Ocean End Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2150352	RESTRICTED TO: - SCALE: 1:1 SHEET: 4 of 4 REV: C
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH *		MATERIAL: - WEIGHT: - APPLICATION SPEC: - PRODUCT SPEC: -			