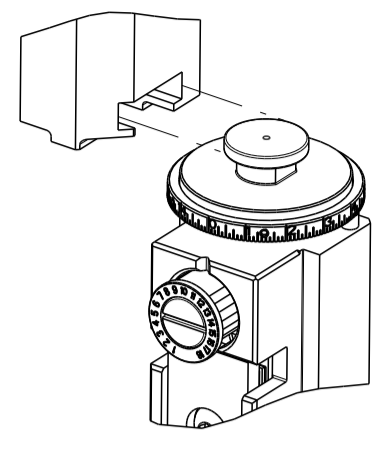


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150494-1	D	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2150494-2	D	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150494-1	D	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2150494-2	D	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150494-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.53 mm [.060]	0
INSUL		-
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: CIRCULAR WIRE PIN TERMINAL			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
5.95-6.33 mm [.234-.249 IN]		∅	
TERMINAL APPLICATION SPECIFICATION	NONE		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
737190-2			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.00mm2	1.65 +/- 0.05 [.065 +/- .002]	5.8
0.75mm2	1.55 +/- 0.05 [.061 +/- .002]	6.3

- 1. RECOMMENDED SPARE PARTS
- 2. REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- 3. POSITION ITEM 27 IN FRONT OF ITEM 1.
- 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.

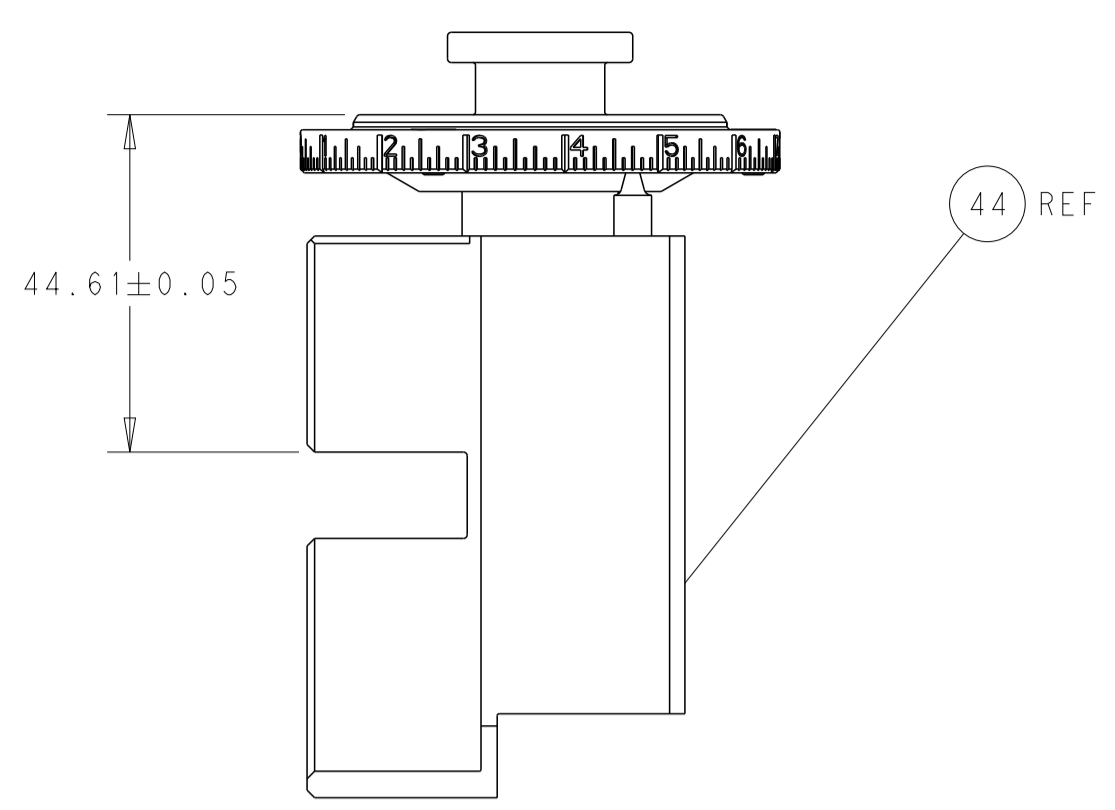
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		B1		ECR-16-007330	23MAY2016	YY	JT
		C		ECR-17-016425	08NOV2017	KH	JDG
		D		ECR-18-016068	10OCT2018	TB	TE

-	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	2119580-1	MECHANICAL FEED ASSEMBLY	239	
-	1	-	1	-	2063440-1	AIR FEED MODULE	238	
-	1	1	1	1	1803071-1	SPACER, REAR SHEAR STRIP GUIDE	196	
-	1	1	1	1	459722-7	BLADE, SHEAR	195	
-	2	2	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	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	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	
-	2	2	2	2	2168400-8	SHCS, LOW HEAD, RoHS, M4 X 16	64	
-	-	1	-	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59	
-	-	1	-	1	2063961-1	FEED FINGER	58	
-	3	3	3	3	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57	
-	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	-	2119792-2	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	1-2119655-7	APPLICATOR BASIC ASSEMBLY, EF	46	
-	1	1	1	1	1803517-2	RAM ASSEMBLY, EF ATLANTIC	44	
-	1	1	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41	
-	7	7	7	7	1-18028-2	WASHER, FLAT, REG M4	33	
-	2	2	2	2	1-2168083-2	SCR, SKT HD CAP, RoHS, M4 X 25	31	
-	2	2	2	2	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	29	
-	1	1	1	1	690455-2	STRIPPER, FRONT CASTING	27	
-	2	2	2	2	1-2168083-6	SCR, SKT HD CAP, RoHS, M4 X 35	25	
-	1	1	1	1	1752371-1	PLATE, STRIP GUIDE	24	
-	1	1	1	1	240825-9	PLATE, STRIP HOLD DOWN	23	
-	2	2	2	2	22281-8	SPRING, COMPRESSION	22	
-	1	1	1	1	1633168-1	ARM, STOCK DRAG	21	
-	1	1	1	1	1-464452-6	DRAG, STOCK	20	
-	2	2	2	2	1-1901259-3	GUIDE, LOWER STRIP	18	
-	4	4	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17	
-	1	1	1	1	240644-1	PLATE, REAR SHEAR	11	
-	2	2	2	2	6-240645-5	SPACER, SHEAR PLATE	10	
-	1	2	2	1	1633342-7	ANVIL, WIRE	8	
-	-	-	-	-	-	-	5	
-	-	-	-	-	-	-	4	
-	-	-	-	-	-	-	3	
-	-	-	-	-	-	-	2	
-	1	2	2	1	1	7-459492-8	CRIMPER, WIRE 0	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)

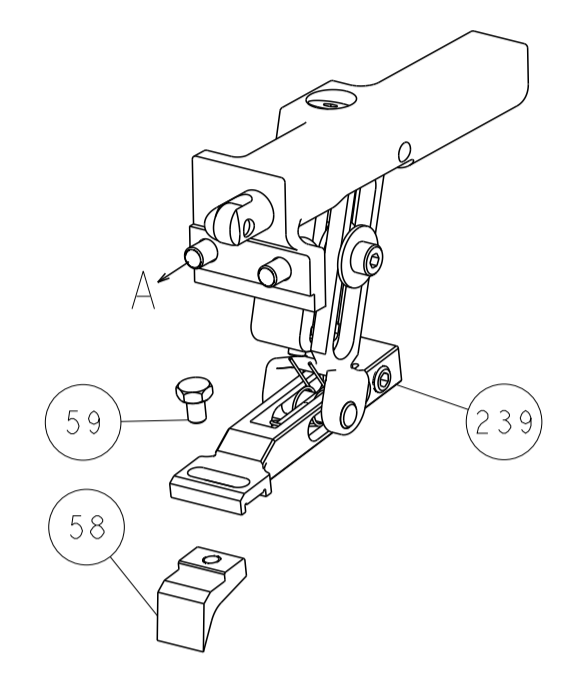
<small>THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION. COPYRIGHT 20 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.</small>		DWN: HOFFNER 26SEPT2014 CHK: TELBIN 29SEPT2014 APVD: TELBIN 29SEPT2014	TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 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=2150494 RESTRICTED TO: -
MATERIAL: -		WEIGHT: -	SCALE: 1:1 SHEET: 1 of 4 REV: D

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

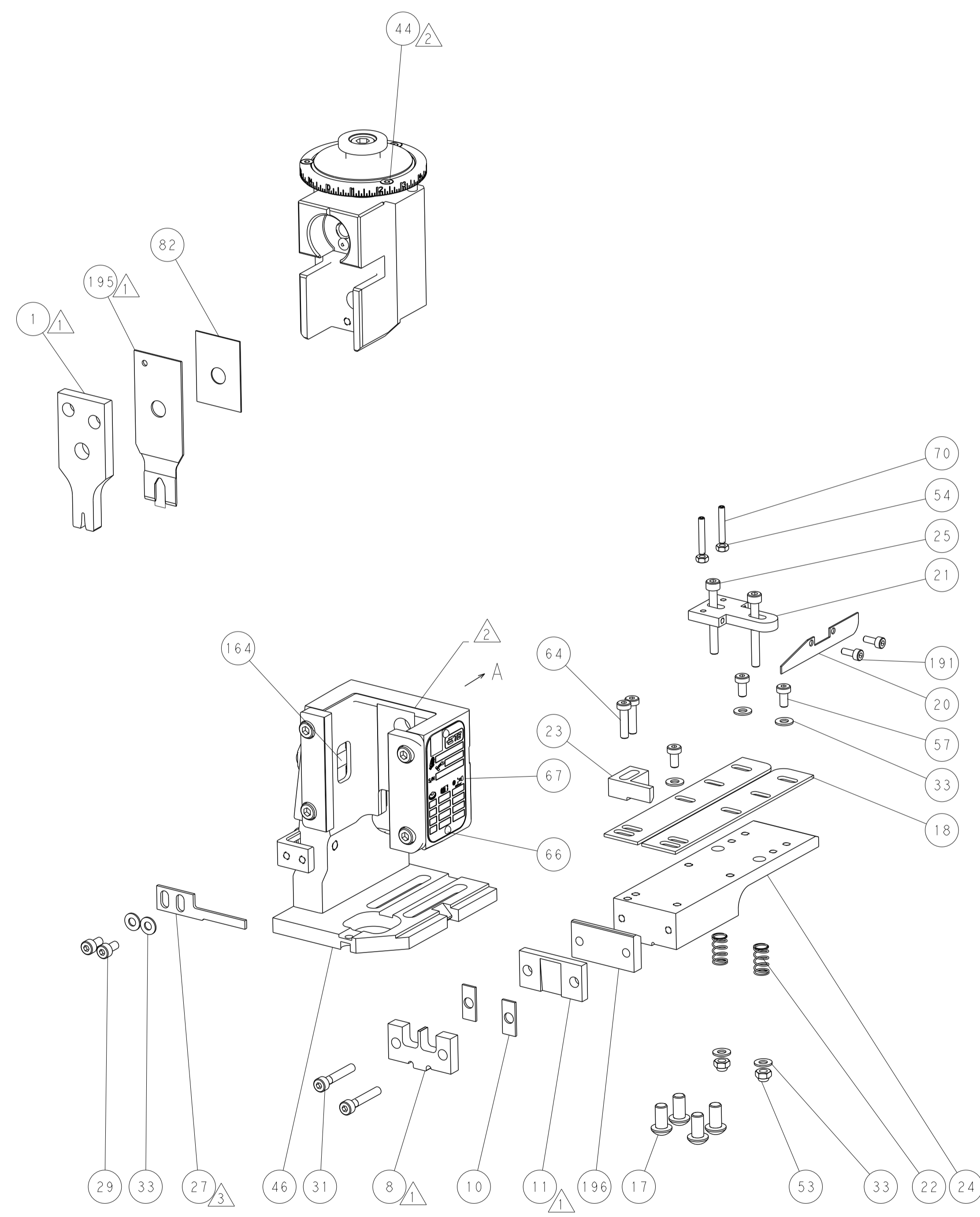
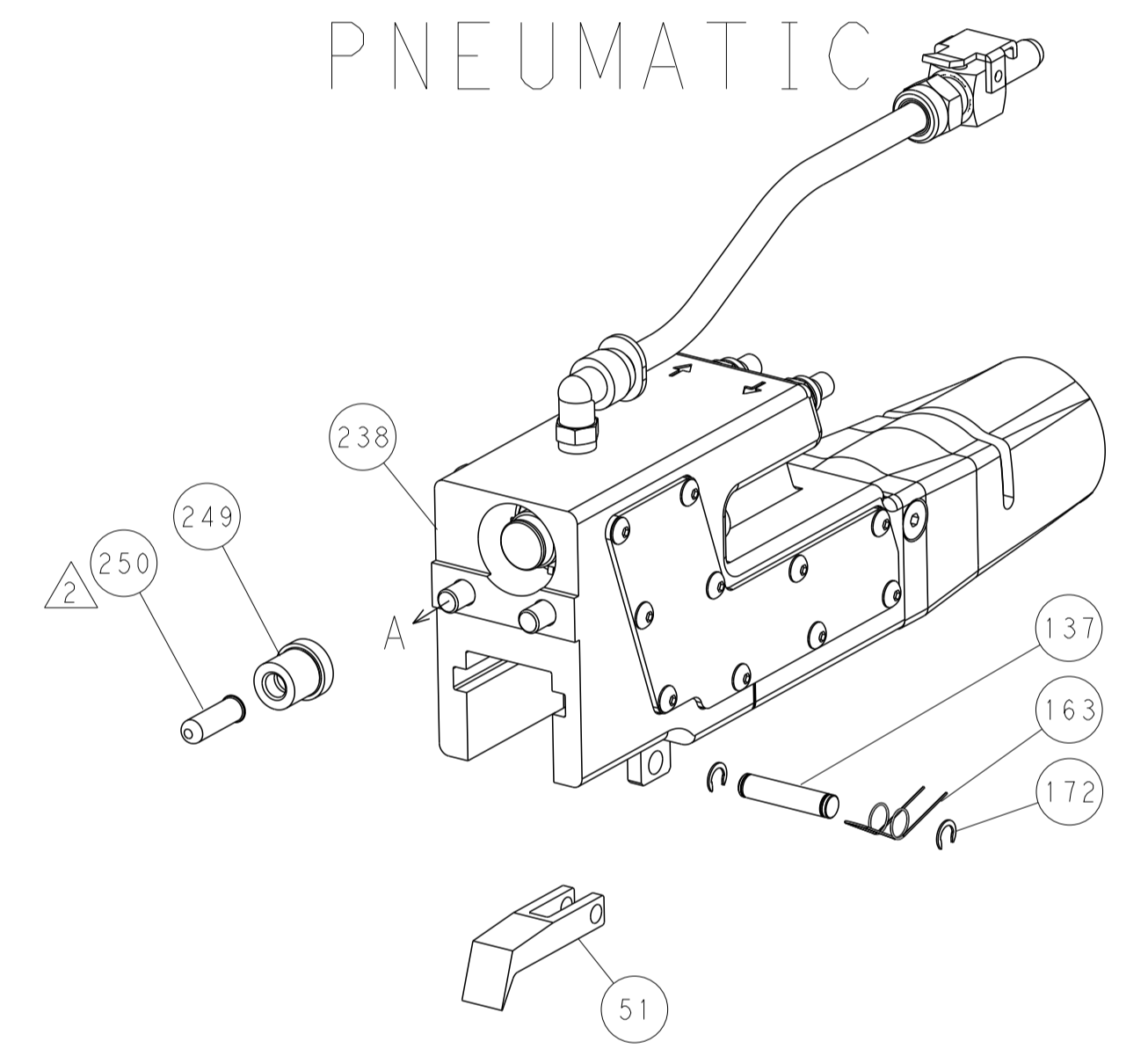


RAM SET-UP

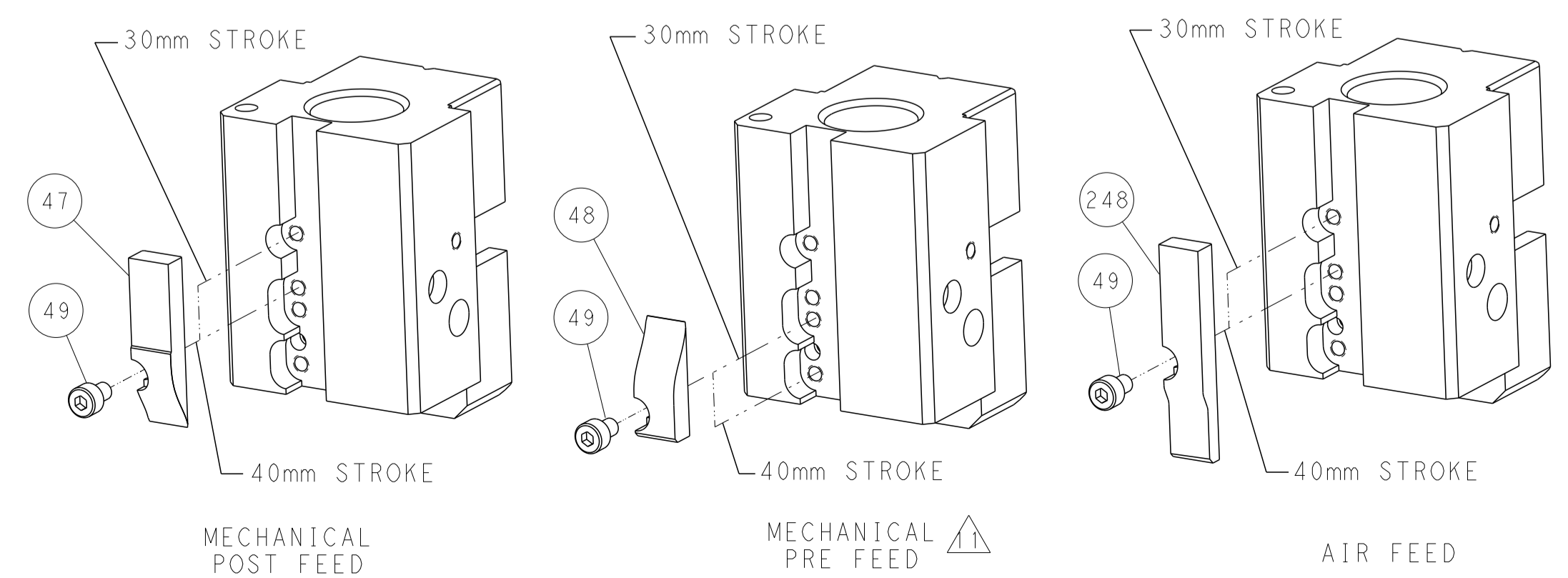
FEED TYPE
MECHANICAL



PNEUMATIC



CAM POSITIONS

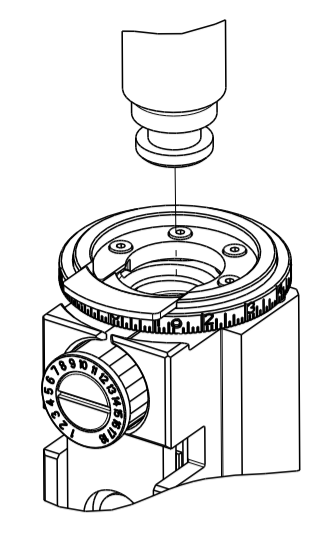


ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

<small>THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.</small>		DWN: HOFFNER 26SEPT2014 CHK: T. ELBIN 29SEPT2014 APVD: T. ELBIN 29SEPT2014	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 APPLICATION SPEC: PRODUCT SPEC: SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2150494	RESTRICTED TO: SCALE: 1:1 SHEET: 2 of 4 REV: D
MATERIAL:		WEIGHT:	Customer Accessible Production Drawing

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150494-1	D	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2150494-2	D	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150494-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
 INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.53 mm [.060]	○
INSUL		-
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: CIRCULAR WIRE PIN TERMINAL			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
5.95-6.33 mm [.234-.249 IN]		∅	
TERMINAL APPLICATION SPECIFICATION	NONE	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
737190-2			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.00mm2	1.65+/-0.05 [.065+/-0.002]	5.8
0.75mm2	1.55+/-0.05 [.061+/-0.002]	6.3

- RECOMMENDED SPARE PARTS
- REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- POSITION ITEM 27 IN FRONT OF ITEM 1.
- 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.

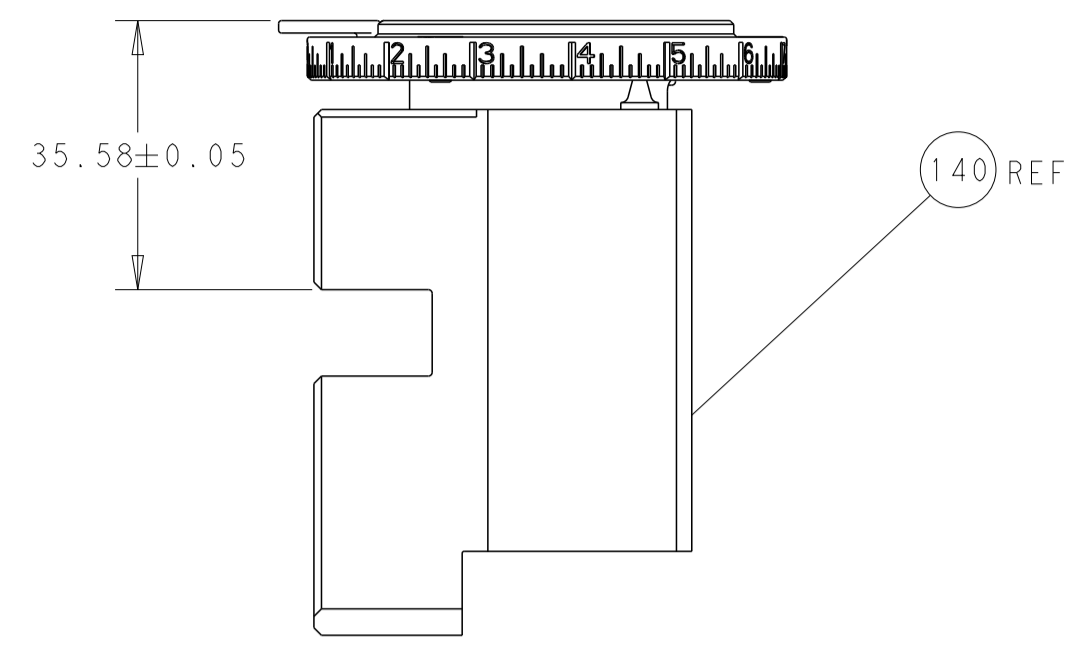
LOC	DIST	REVISIONS					
A	66	P	LTN	DESCRIPTION	DATE	OWN	APVD
-	-	-	-	SEE SHEET 1	-	-	-

-	1	1	2119640-1	PUSH ROD, AIR FEED	250	
-	1	1	1803259-1	BUSHING, FLANGED	249	
-	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239	
-	1	-	2063440-1	AIR FEED MODULE	238	
-	1	1	1803071-1	SPACER, REAR SHEAR STRIP GUIDE	196	
-	1	1	459722-7	BLADE, SHEAR	195	
-	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	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	2119653-2	FEED CAM, POST FEED	142	
-	1	1	1-2119655-8	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	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	
-	2	2	2168400-8	SHCS, LOW HEAD, RoHS, M4 X 16	64	
-	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59	
-	-	1	2063961-1	FEED FINGER	58	
-	3	3	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57	
-	2	2	5018030-1	NUT, HEX, REG, RoHS, M3	54	
-	2	2	986965-8	NUT, LOCK, HEX, TORQUE (M4)	53	
-	1	-	2119792-2	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	
-	7	7	1-18028-2	WASHER, FLAT, REG M4	33	
-	2	2	1-2168083-2	SCR, SKT HD CAP, RoHS, M4 X 25	31	
-	2	2	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	29	
-	1	1	690455-2	STRIPPER, FRONT CASTING	27	
-	2	2	1-2168083-6	SCR, SKT HD CAP, RoHS, M4 X 35	25	
-	1	1	1752371-1	PLATE, STRIP GUIDE	24	
-	1	1	240825-9	PLATE, STRIP HOLD DOWN	23	
-	2	2	22281-8	SPRING, COMPRESSION	22	
-	1	1	1633168-1	ARM, STOCK DRAG	21	
-	1	1	1-464452-6	DRAG, STOCK	20	
-	2	2	1-1901259-3	GUIDE, LOWER STRIP	18	
-	1	1	240644-1	PLATE, REAR SHEAR	11	
-	2	2	6-240645-5	SPACER, SHEAR PLATE	10	
-	1	1	1633342-7	ANVIL, WIRE	8	
-	-	-	-	-	5	
-	-	-	-	-	4	
-	-	-	-	-	3	
-	-	-	-	-	2	
-	1	1	1	7-459492-8	CRIMPER, WIRE 0	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)

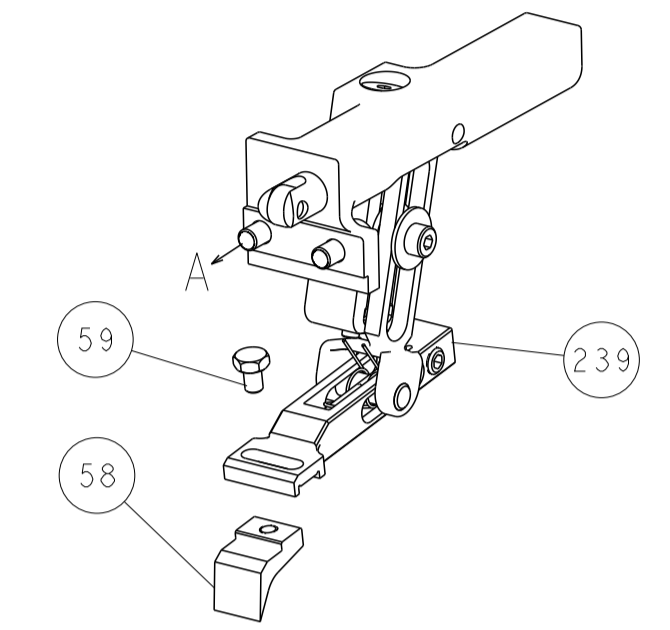
DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH ±		DWN: 26SEPT2014 CHK: 29SEPT2014 T. ELBIN APVD: 29SEPT2014 PRODUCT SPEC APPLICATION SPEC		NAME: Ocean End Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2150494 SCALE: 1:1 SHEET: 3 OF 4 REV: D	
MATERIAL: -		WEIGHT: -		Customer Accessible Production Drawing		RESTRICTED TO: -	

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

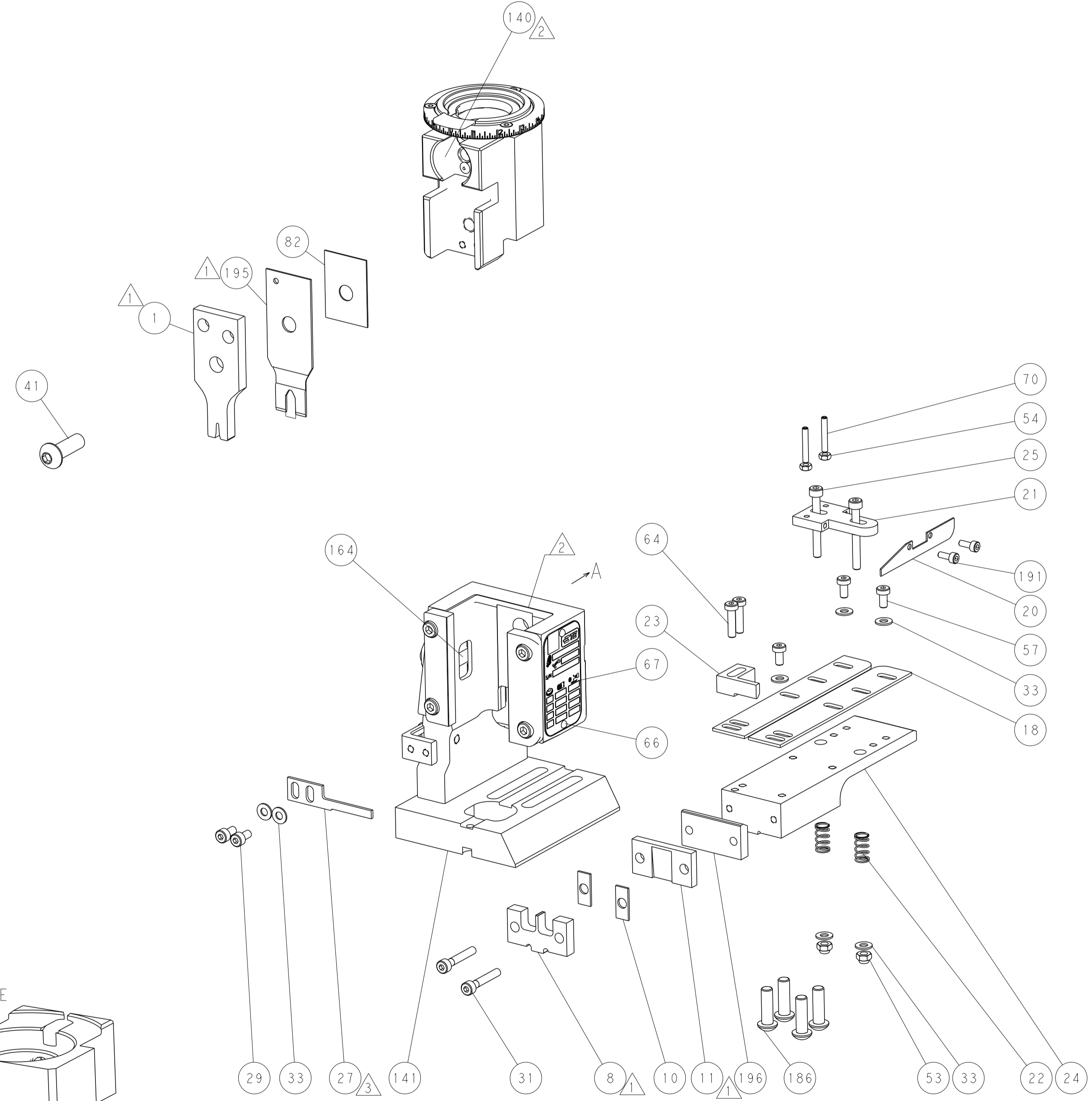
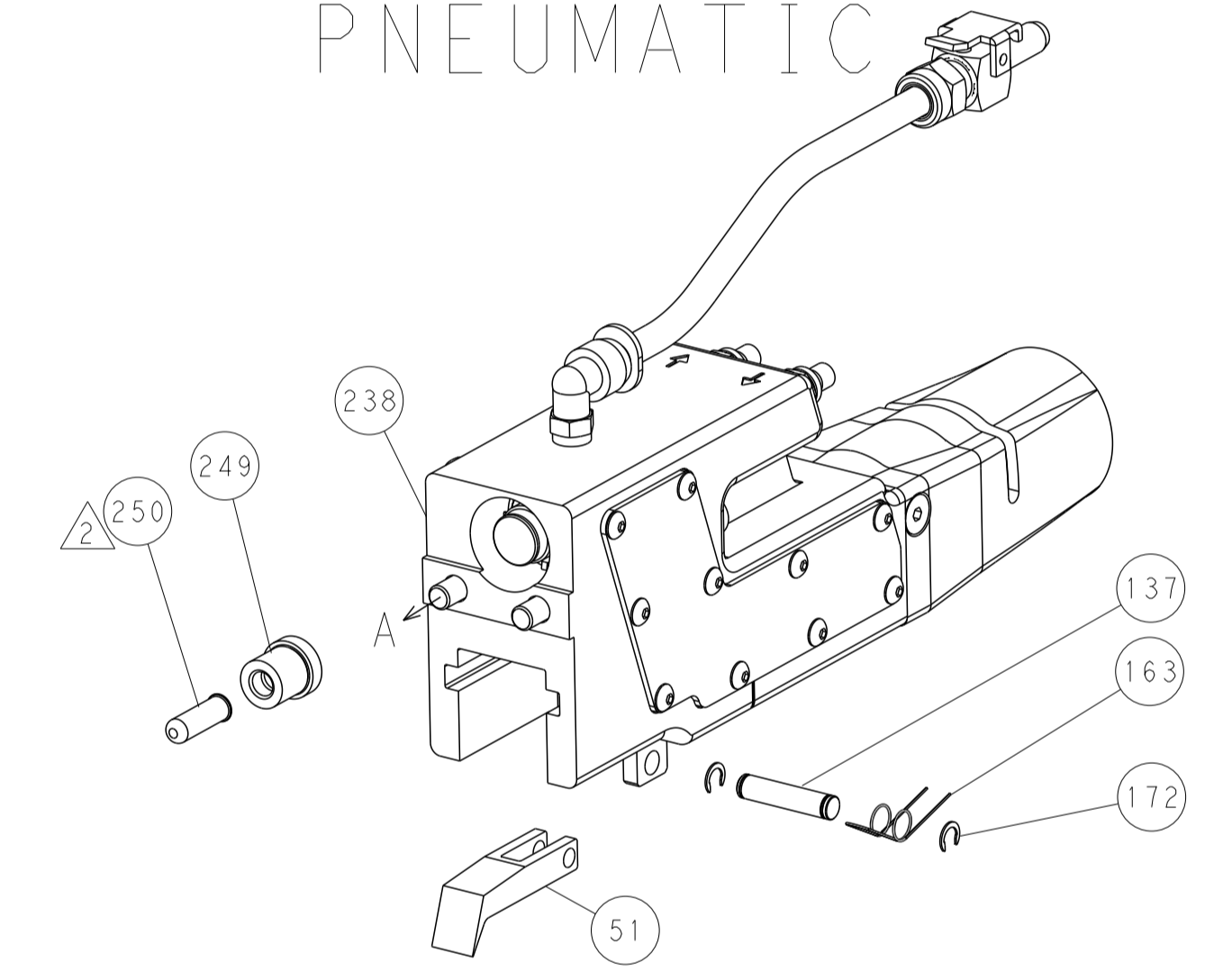


RAM SET-UP

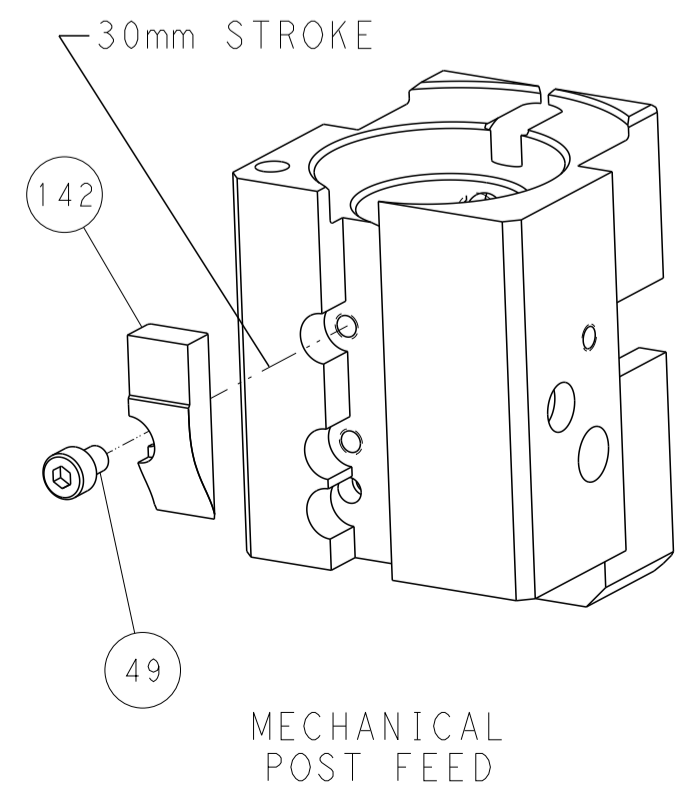
FEED TYPE
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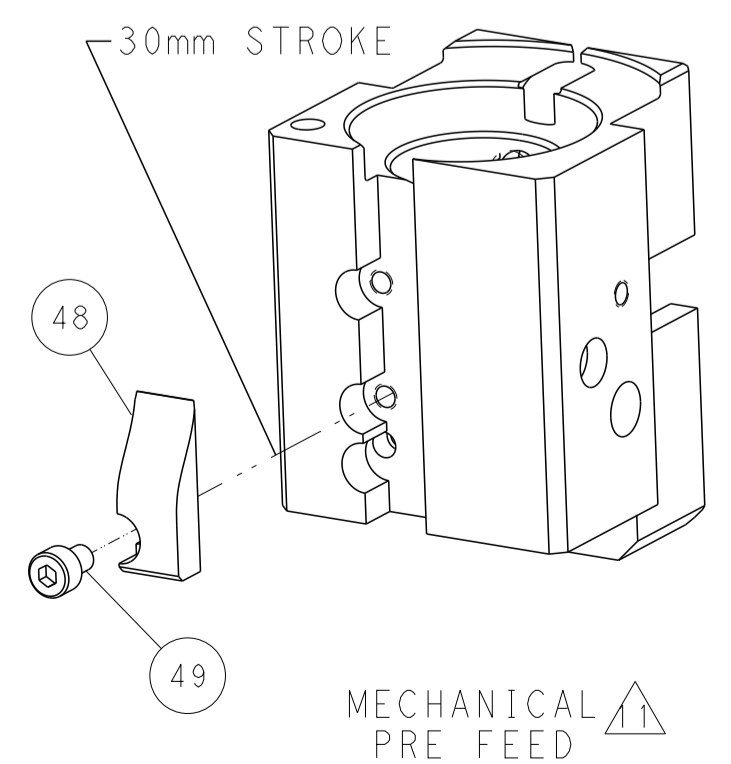
PNEUMATIC



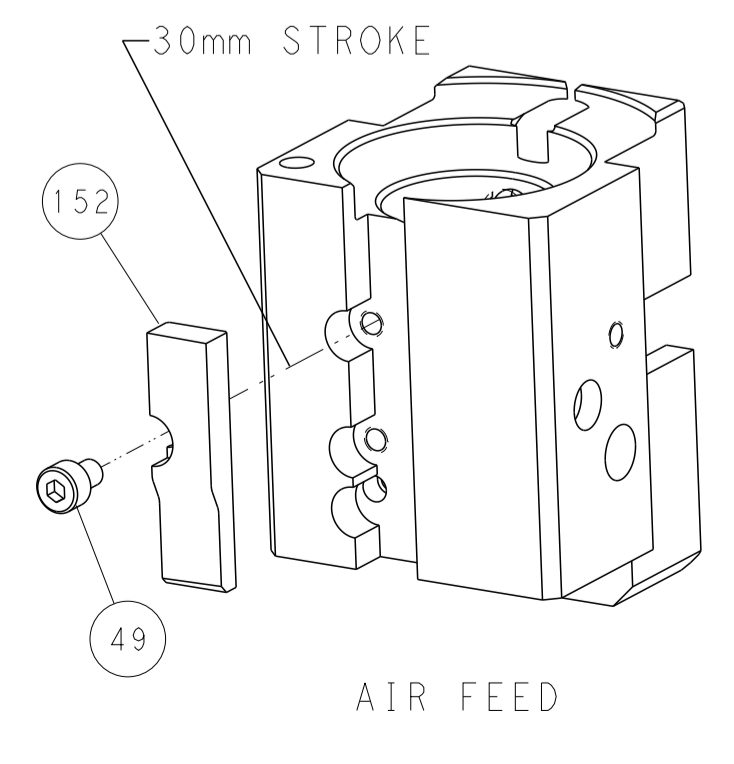
CAM POSITIONS



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)

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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 WEIGHT SCALE: 1:1	NAME: Ocean End Feed Applier SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2150494 SHEET 4 OF 4	RESTRICTED TO: D