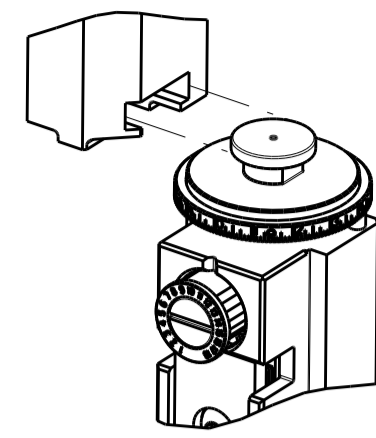


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150325-1	D	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2150325-2	D	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150325-1	D	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2150325-2	D	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150325-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.57 mm [.062]	F
INSUL	3.56 mm [.140]	F
APPLICATOR INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION
TERMINAL NAME: RECEPTACLE, POSITIVE LOCK, 110 SERIES		
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE
3.62-4.00 mm [.143-.157 IN]		∅2.03-3.05 mm [.080-.120 IN]
TERMINAL APPLICATION SPECIFICATION	114-2074	
TERMINALS APPLIED		
TE TERMINAL	TE TERMINAL	TE TERMINAL
1742975-1		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
18 AWG	1.24 +/- 0.05 [.049 +/- .002]	4.7
20 AWG	1.09 +/- 0.05 [.043 +/- .002]	6.3
22 AWG	0.99 +/- 0.05 [.039 +/- .002]	7.3

- 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 ITEM 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. 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.

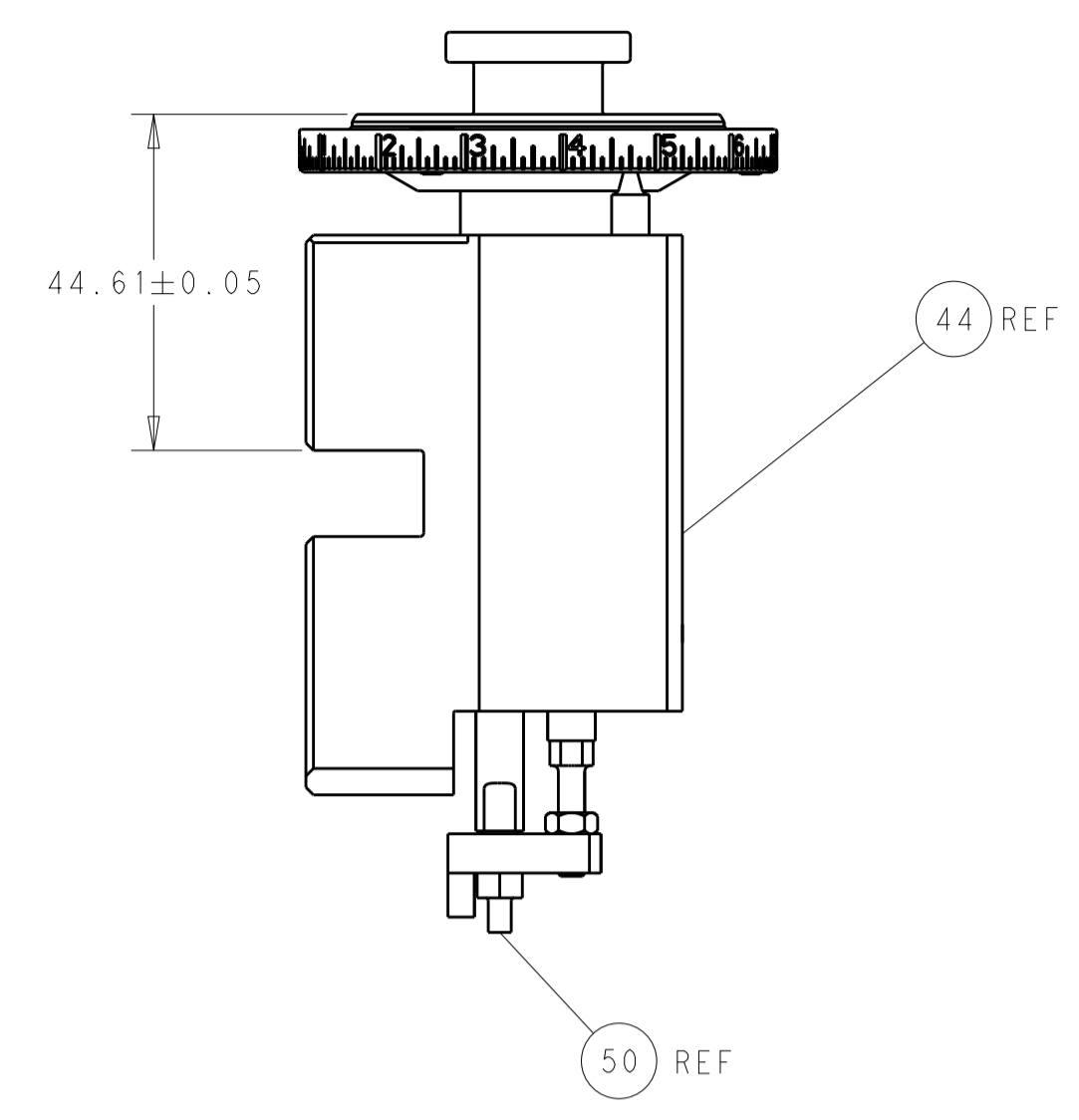
ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

LOC	DIST	REVISIONS			
A	66	REV	DATE	BY	APPV
		B	ECR-14-006200	25APR2014	LG TE
		C	ECR-17-011879	16AUG2017	TB GB
		D	ECR-18-018661	29NOV2018	FZ KZ

-	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	2119082-9	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	-	2063440-1	AIR FEED MODULE	238	
-	1	1	1	1	1-18028-0	WASHER, FLAT, REG M8	192	
-	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	
-	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	455888-6	SPACER, CRIMPER	82	
-	1	1	1	1	1803607-2	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	1901681-5	HOLDDOWN, TERMINAL	65	
-	2	2	2	2	2168400-5	SHCS, LOW HEAD, RoHS, M4 X 20	64	
-	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	2063961-1	FEED FINGER	58	
-	3	3	3	3	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57	
-	2	2	2	2	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	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	1	1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52	
-	1	-	1	-	2119792-2	PAWL, EF, AIR	51	
-	1	1	1	1	1-1976055-6	STANDOFF, HOLD-DOWN	50	
-	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	
-	7	7	7	7	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	
-	1	1	1	1	240825-1	PLATE, STRIP HOLD DOWN	23	
-	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	240644-1	PLATE, REAR SHEAR	11	
-	1	1	1	1	1338016-3	TAB, LATCHING	10	
-	1	1	1	1	690482-6	PLATE, FRONT SHEAR	9	
-	1	2	2	1	1803059-2	ANVIL, COMBINATION, END FEED	8	
-	1	1	1	1	2217206-6	BLADE, SLUG	7	
-	-	-	-	-	-	-	6	
-	1	1	1	1	2-240641-0	SPACER	5	
-	1	1	1	1	238011-8	BLOCK, CRIMPER SPACER	4	
-	1	2	2	1	2-2119582-4	CRIMPER, INSULATION F PREMIUM	3	
-	1	1	1	1	455888-7	SPACER, CRIMPER	2	
-	1	2	2	1	2-456403-1	CRIMPER, WIRE PREMIUM	1	
-	77-72-71	-	2	-	1	PART NO	DESCRIPTION	ITEM NO

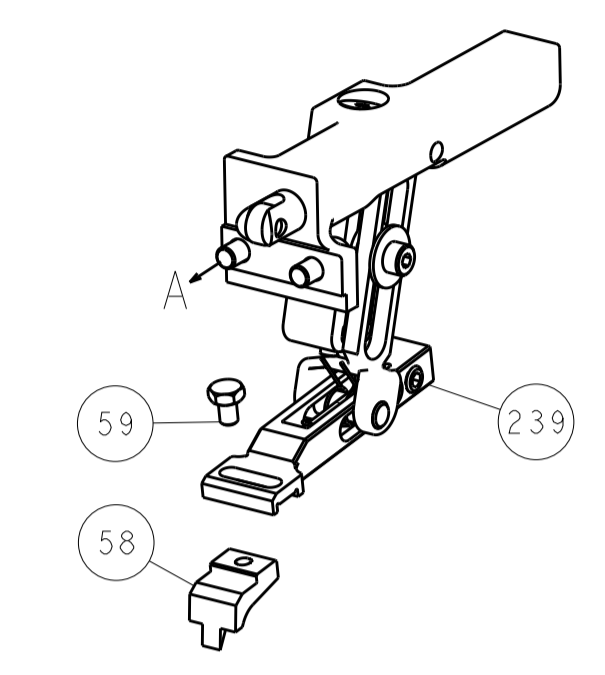
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mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES	FINISH	WT	SCALE	SHEET	REV

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

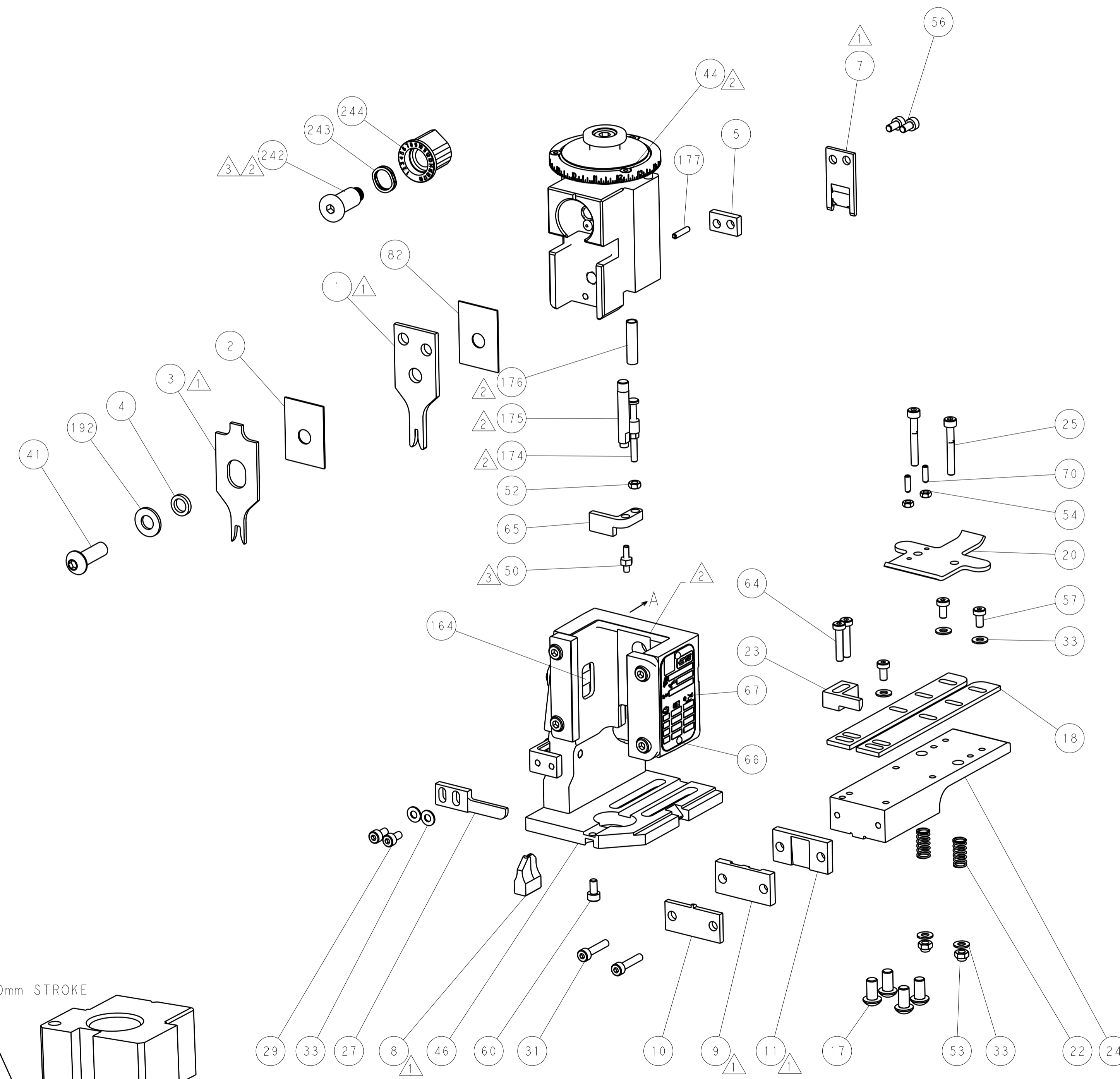
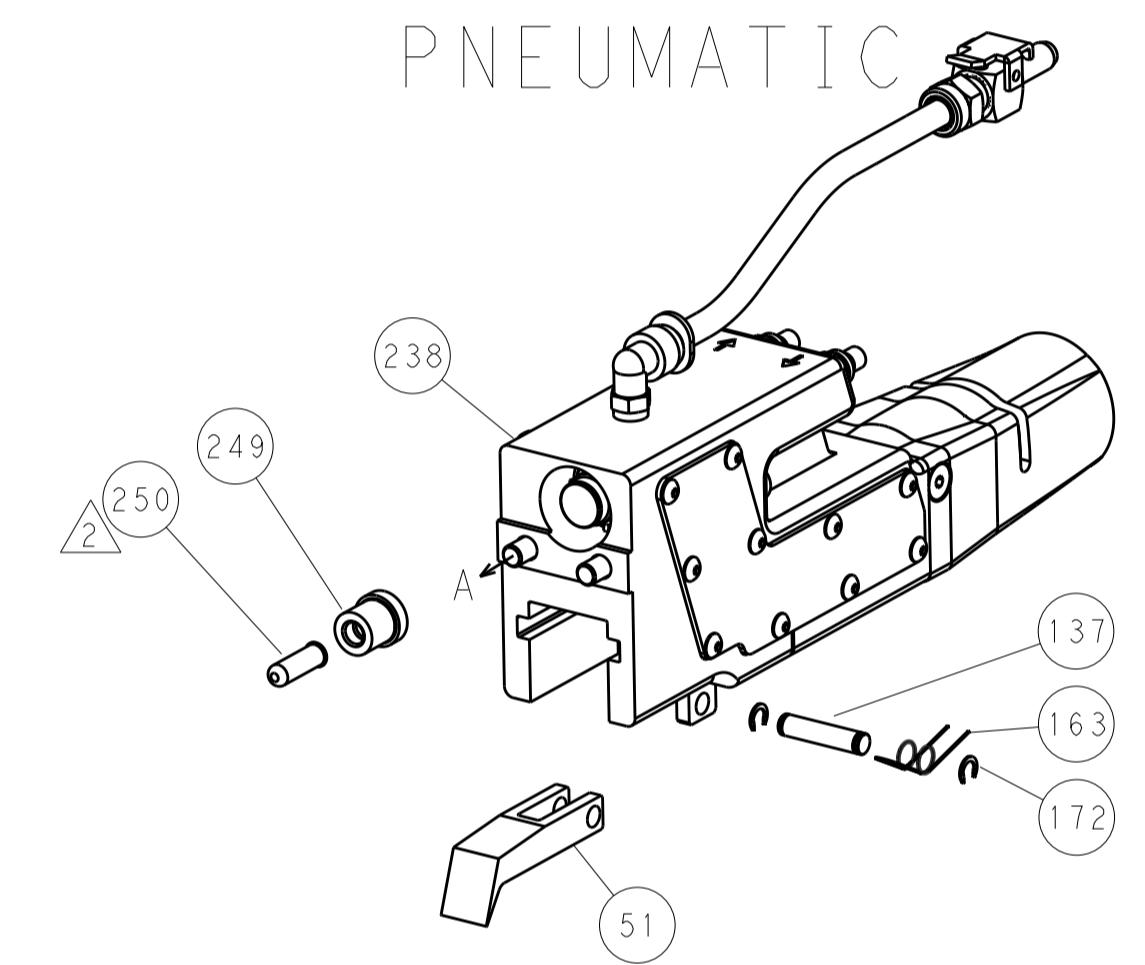


HOLDDOWN SET-UP

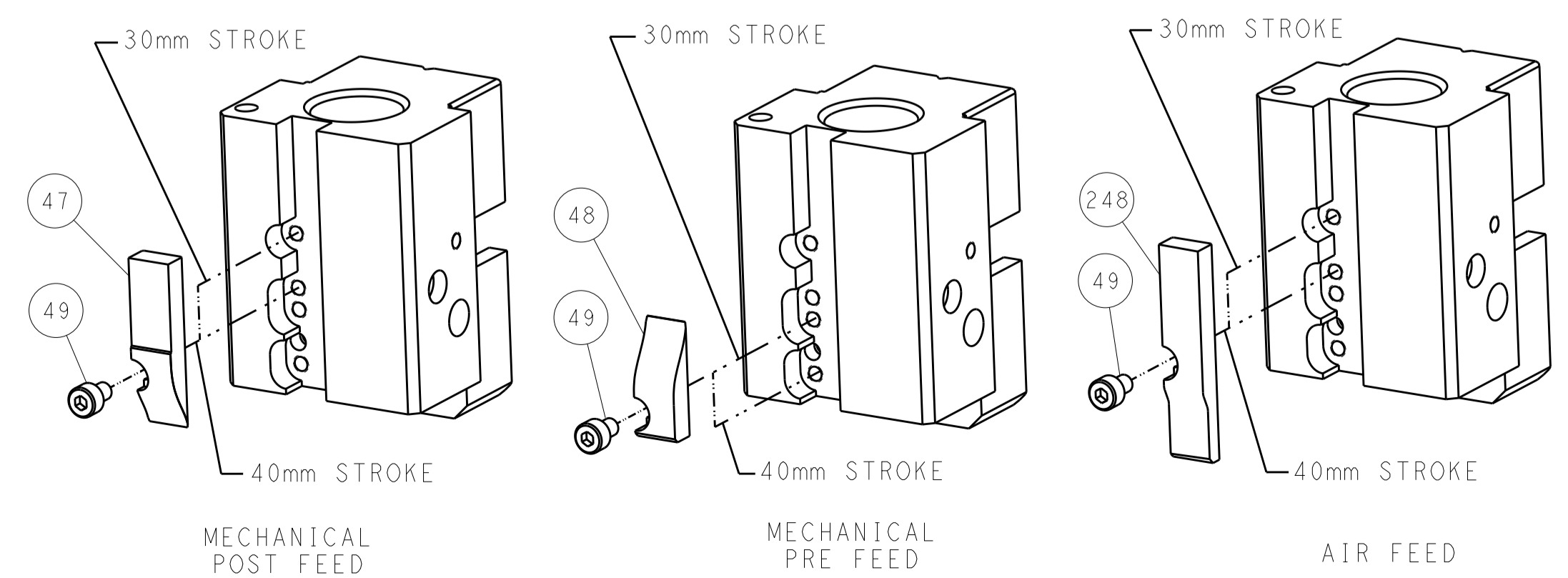
FEED TYPE
MECHANICAL



PNEUMATIC



CAM POSITIONS

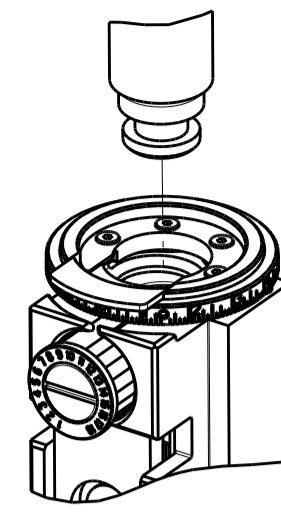


ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

<small>THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION. 20 COPYRIGHT 20 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.</small>		DWN: R. STAKEM 2MARCH2013 CHK: G. BAILEY 12MARCH2013 APVD: T. ERLIN 12MARCH2013	TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		NAME: Ocean End Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2150325	RESTRICTED TO: - SCALE: 1:1 SHEET: 2 of 4 REV: D
MATERIAL: - FINISH: -		WEIGHT: - Customer Accessible Production Drawing	SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

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COPYRIGHT © BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.			
PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150325-1	D	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2150325-2	D	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150325-7	A	CRIMP TOOLING KIT	-

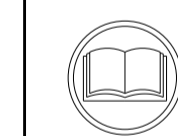
PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.57 mm (.062)	F
INSUL	3.56 mm (.140)	F
APPLICATOR INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: RECEPTACLE, POSITIVE LOCK, 110 SERIES			
WIRE STRIP LENGTH 3.62-4.00 mm (.143-.157 IN)		INSULATION DIAMETER RANGE Ø2.03-3.05 mm (.080-.120 IN)	
TERMINAL APPLICATION SPECIFICATION 114-2074			
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
1742975-1			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
18 AWG	1.24 +/- 0.05 [.049 +/- .002]	4.7
20 AWG	1.09 +/- 0.05 [.043 +/- .002]	6.3
22 AWG	0.99 +/- 0.05 [.039 +/- .002]	7.3



- 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 ITEM 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. 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.

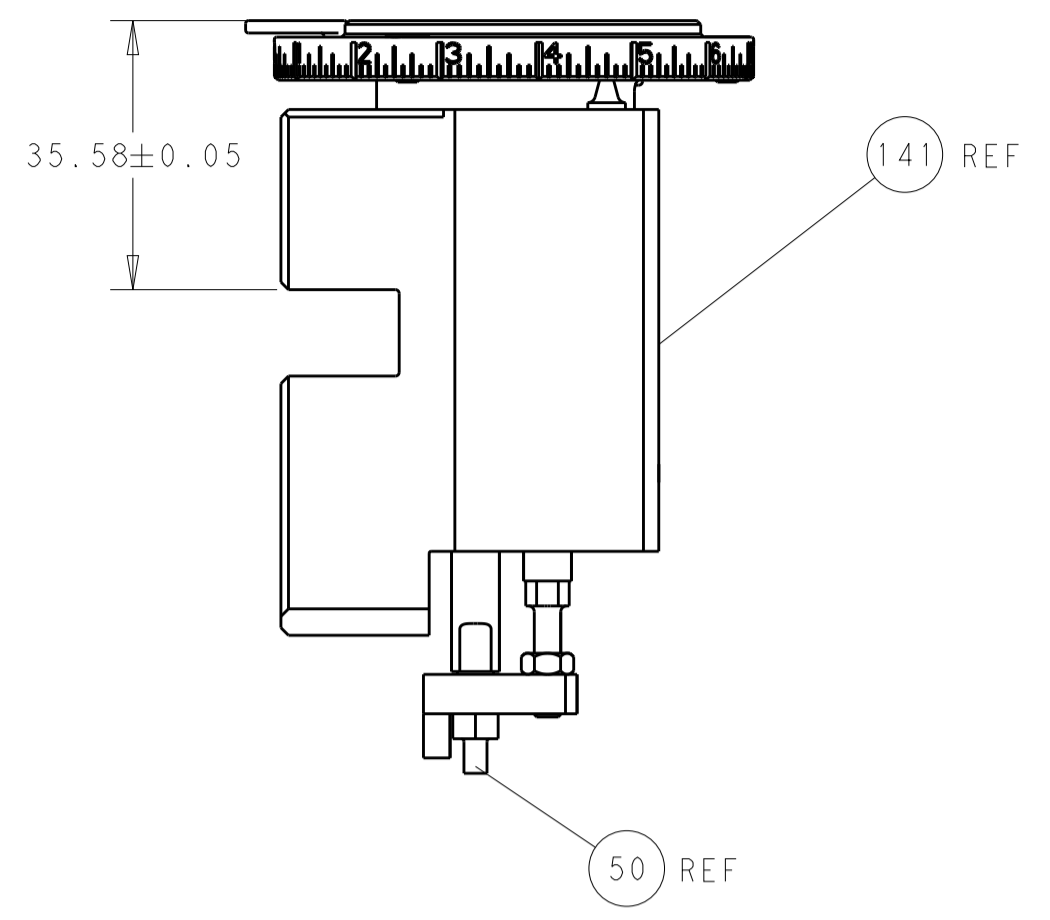
PACIFIC VERSION
Shown on sheets 3 of 4 & 4 of 4
(Atlantic version shown on sheets 1 of 4 & 2 of 4)

LOC	DIST	REV	DATE	BY	CHK	APPD
A	66					

REVISIONS							
REV	DATE	BY	CHK	APPD	DESCRIPTION	ITEM NO	
-	-	-	-	-	SEE SHEET 1	-	
-	1	1			2119640-1	PUSH ROD, AIR FEED	250
-	1	1			1803259-1	BUSHING, FLANGED	249
-	1	1			2119082-9	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	-			2063440-1	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
-	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
-	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			455888-6	SPACER, CRIMPER	82
-	1	1			1803607-2	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			1901681-5	HOLDDOWN, TERMINAL	65
-	2	2			2168400-5	SHCS, LOW HEAD, RoHS, M4 X 20	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			2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	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	-			2119792-2	PAWL, EF, AIR	51
3	-	1			1-1976055-6	STANDOFF, HOLD-DOWN	50
-	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			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
-	1	1			240825-1	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
1	-	1			240644-1	PLATE, REAR SHEAR	11
-	1	1			1338016-3	TAB, LATCHING	10
1	-	1			690482-6	PLATE, FRONT SHEAR	9
1	1	1			1803059-2	ANVIL, COMBINATION, END FEED	8
1	-	1			2217206-6	BLADE, SLUG	7
-	-	-			-	-	6
-	1	1			2-240641-0	SPACER	5
-	1	1			238011-8	BLOCK, CRIMPER SPACER	4
1	1	1			2-2119582-4	CRIMPER, INSULATION F PREMIUM	3
-	1	1			455888-7	SPACER, CRIMPER	2
1	1	1			2-456403-1	CRIMPER, WIRE PREMIUM	1
-	77	22	21		PART NO	DESCRIPTION	ITEM NO

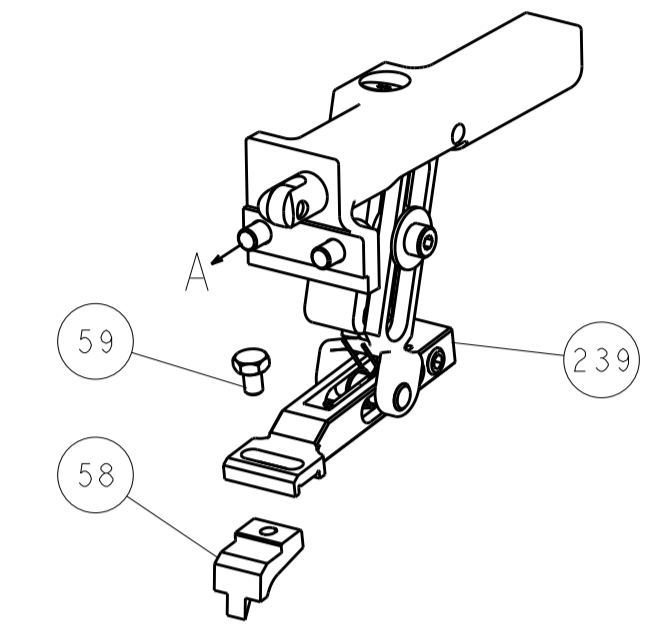
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DATE: 2 MARCH 2013	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±
ANGLES	±	±	±	±	±
MATERIAL:	FINISH:	WEIGHT:	SCALE:	SHEET:	REV:
			1:1	3 OF 4	D

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

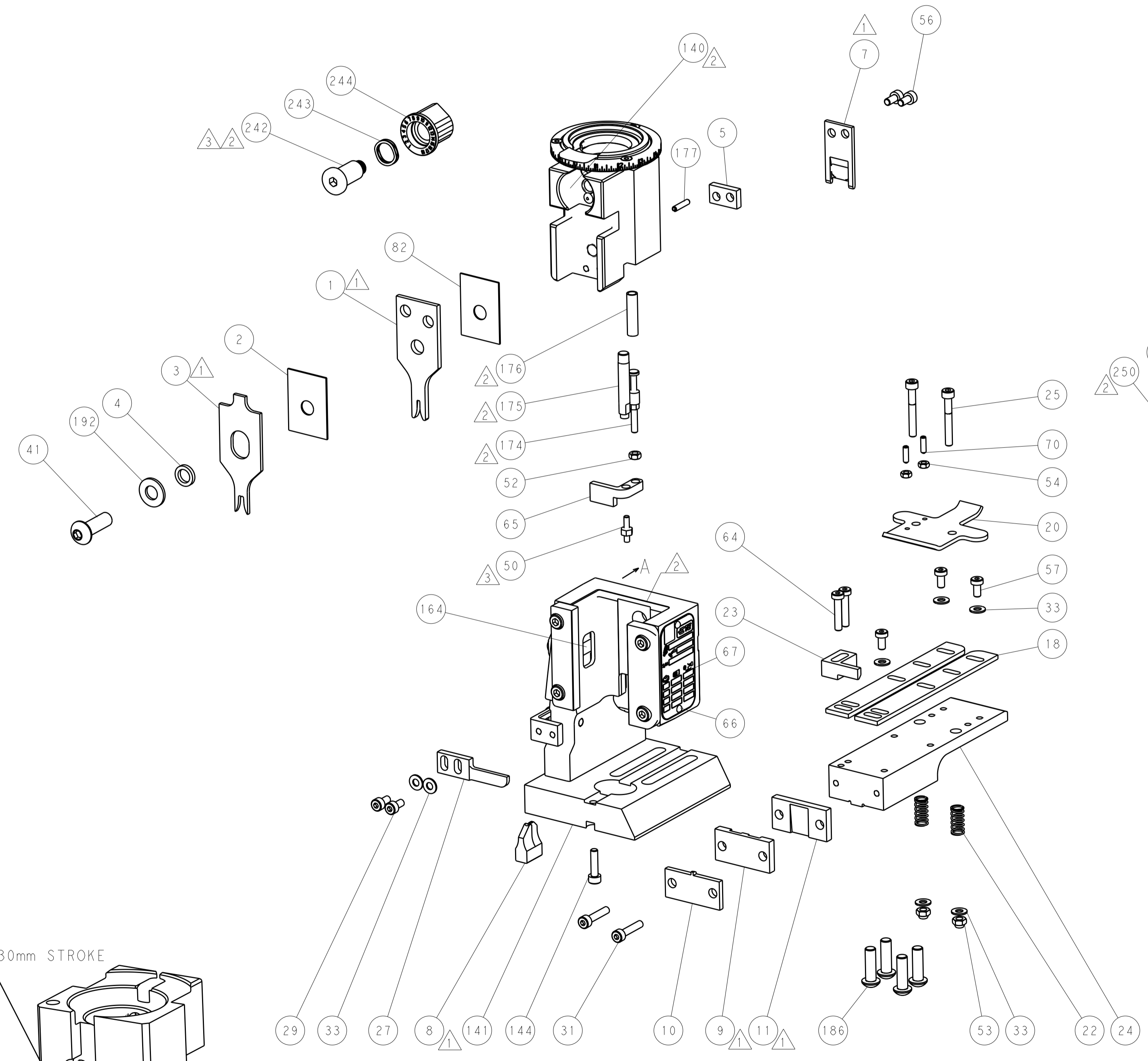
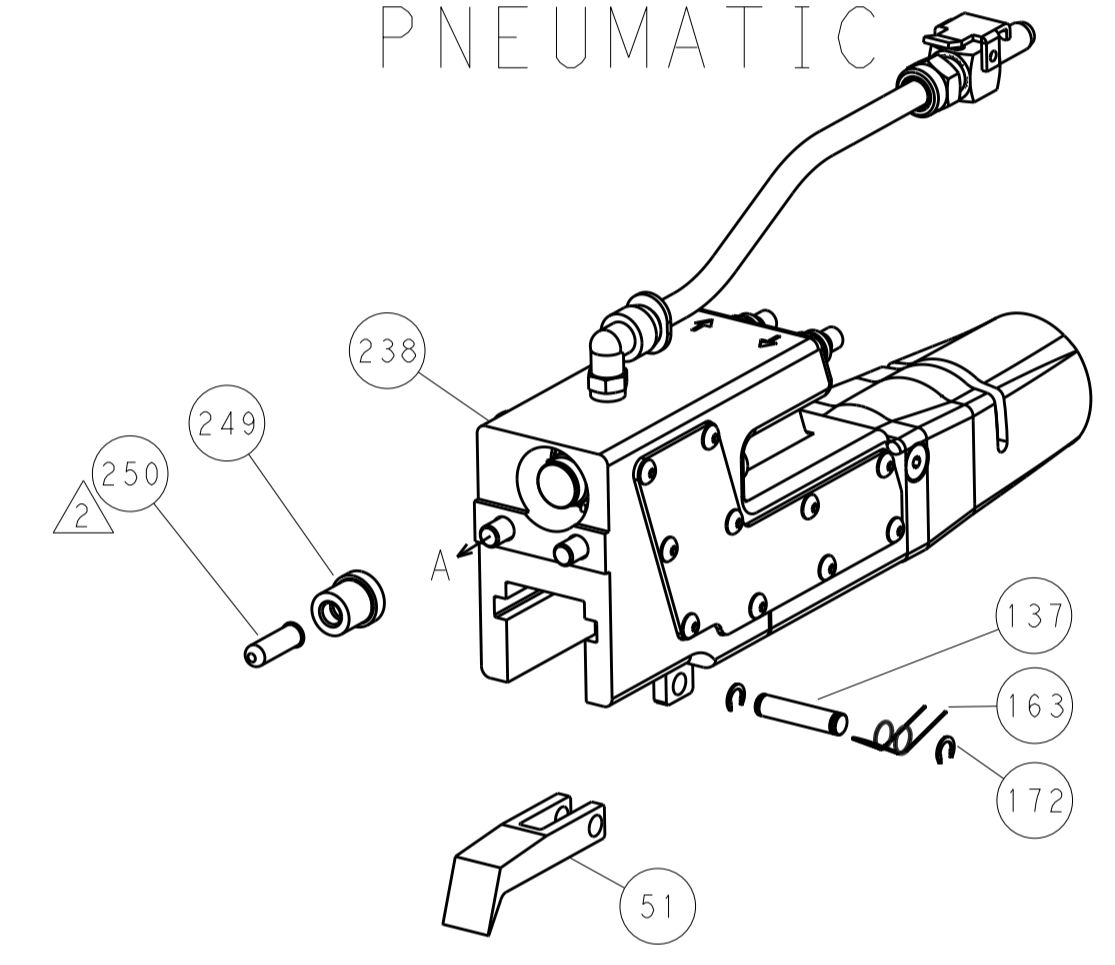


HOLDDOWN SET-UP

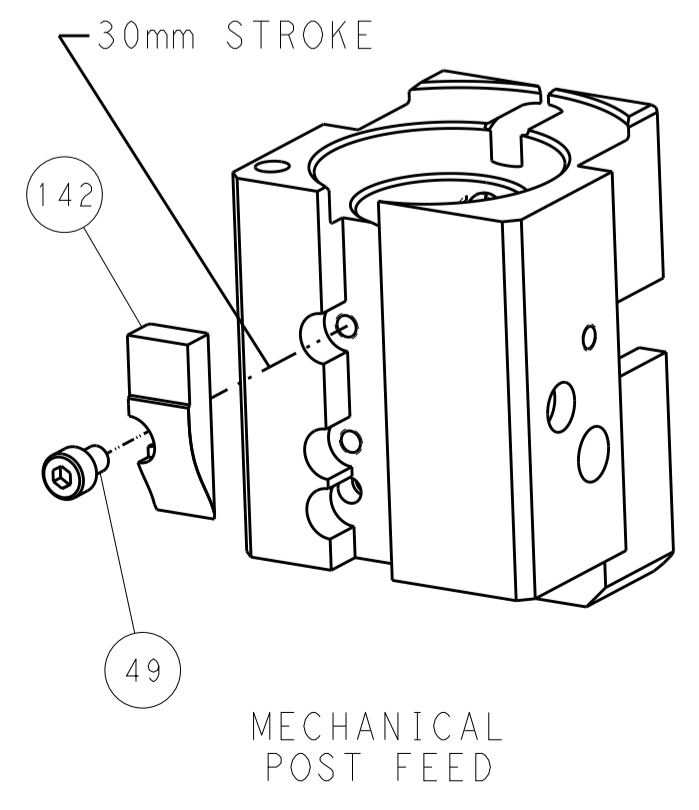
FEED TYPE
MECHANICAL



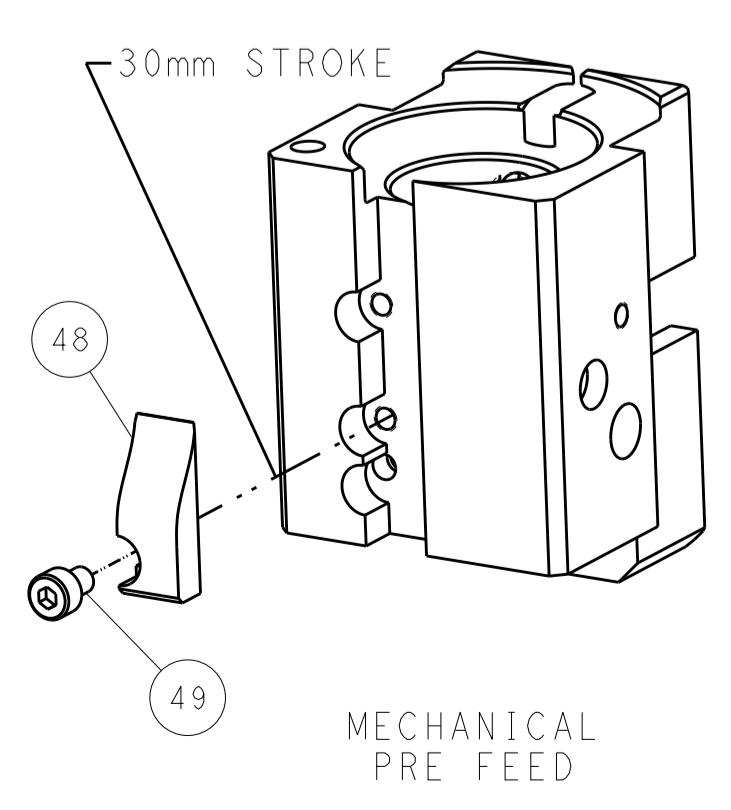
PNEUMATIC



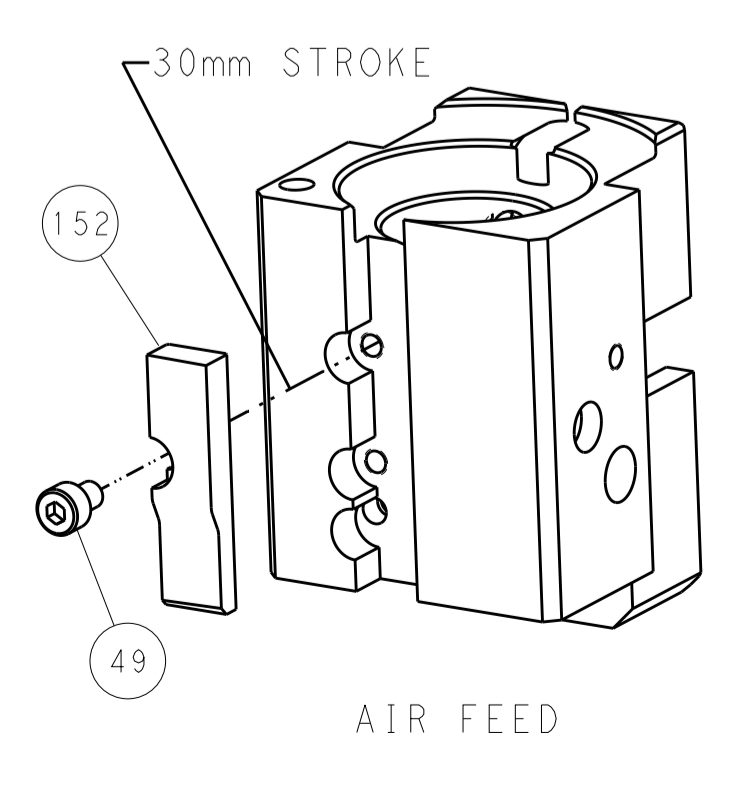
CAM POSITIONS



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)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN: R. STAKEM 2 MARCH 2013		STE TE Connectivity	
mm	0 PLC	±		CHK: G. BAILEY 12 MARCH 2013	Harrisburg, PA 17105-3608		
	1 PLC	±		APVD: T. ERLIN 12 MARCH 2013	NAME: Ocean End Feed		
	2 PLC	±			Applicator		
	3 PLC	±			SIZE: CAGE CODE: DRAWING NO:		RESTRICTED TO
	4 PLC	±			A11 00779 C=2150325		
	ANGLES	±			Customer Accessible Production Drawing		
MATERIAL:	FINISH:	WEIGHT:	SCALE:	SHEET:	OF:	REV:	
			1:1	4	4	D	