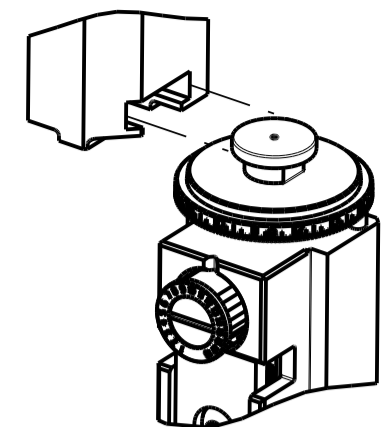


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150408-2	E	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150408-2	E	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150408-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.79 mm [.110]	F
INSUL	5.00 mm [.197]	F

APPLICATOR INSTRUCTIONS 408-35043

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: 3.2Ø CLUSTER REC. "L" TYPE			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
7.70-8.70 mm [.303-.343 IN]		Ø2.20-3.20 mm [.087-.126 IN]	
TERMINAL APPLICATION SPECIFICATION	114-5215		
TERMINALS APPLIED ⁵ / ₆			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
316292-1			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING ⁴
1.104 ⁺ +1.104 ⁺ +0.97 ⁺	2.12 ⁺ -0.05 [.083 ⁺ -0.002]	6.2
0.97 ⁺ +0.97 ⁺ +0.87 ⁺	1.97 ⁺ -0.05 [.078 ⁺ -0.002]	8.2
1.02 ⁺ +1.02 ⁺	1.84 ⁺ -0.05 [.072 ⁺ -0.002]	9.7
0.92 ⁺ +0.72 ⁺	1.70 ⁺ -0.05 [.067 ⁺ -0.002]	11.0

- RECOMMENDED SPARE PARTS**
- REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 180. 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 PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- 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.

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	CHK
B		ECR-18-014766	19SEP2018	FZ	KZ
C		ECR-19-008970	11JUN2019	LG	TE
D		ECR-19-016940	01NOV2019	MZ	YY
E		ECR-21-005584	20MAY2021	FZ	RK

-	1	1	2119641-1	FEED CAM, AIR FEED	248
-	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	1	2844940-4	AIR FEED MODULE	238
-	1	1	1-18028-0	WASHER, FLAT, REG M8	192
³	-	1	2-1752354-3	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
⁶	-	1	2119955-2	ASSY, LUBRICATOR, END FEED	84
-	1	1	455888-5	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	4-1901681-5	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	2-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 14	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	2063961-1	FEED FINGER	51
-	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	690455-3	STRIPPER, FRONT CASTING	27
-	2	2	1-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 30	25
-	1	1	2-1752371-0	PLATE, STRIP GUIDE	24
-	1	1	240825-3	PLATE, STRIP HOLD DOWN	23
-	2	2	22281-8	SPRING, COMPRESSION	22
-	1	1	1803292-4	DRAG	20
-	2	2	1901259-7	GUIDE, LOWER STRIP	18
-	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17
-	1	1	2-240641-4	SPACER	16
-	1	1	1752360-1	SPACER, HOLD-DOWN	13
¹	-	1	240833-6	PLATE, REAR SHEAR	11
¹	-	2	7-240645-4	SPACER, SHEAR PLATE	10
¹	-	1	240642-1	PLATE, FRONT SHEAR	9
¹	1	2	1-3-1803001-9	ANVIL, COMBINATION, END FEED	8
¹	-	1	9-240651-2	BLADE, SLUG	7
-	-	-	-	-	6
-	1	1	1-240641-0	SPACER	5
-	1	1	238011-4	BLOCK, CRIMPER SPACER	4
¹	1	2	1-2-1803016-9	CRIMPER, INSULATION F	3
-	1	1	1-455888-0	SPACER, CRIMPER	2
¹	1	2	1-409414-3	CRIMPER, WIRE	1
-	77	72	-2	PART NO	ITEM NO

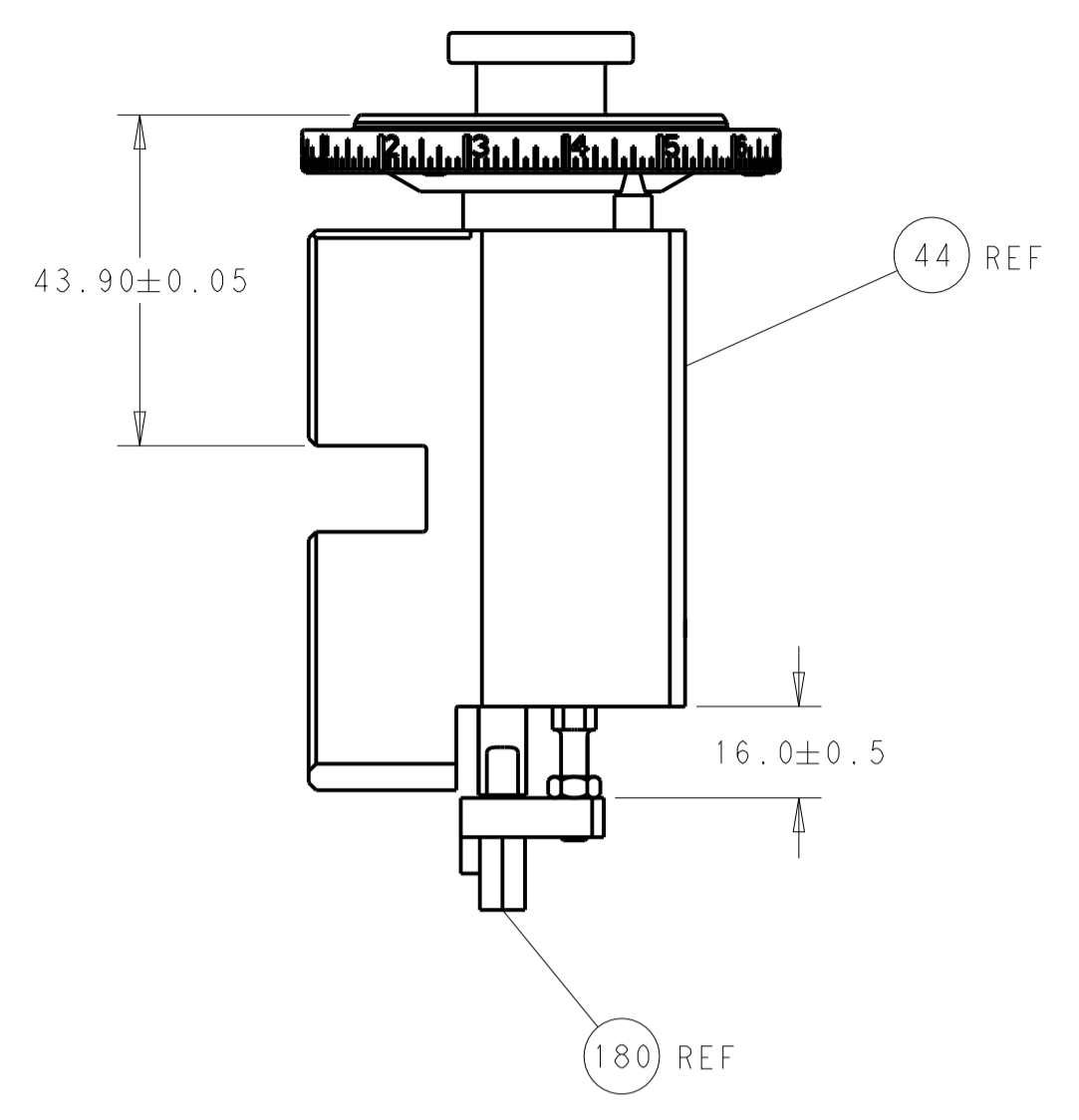
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		MATERIAL:		FINISH:		WEIGHT:		SCALE:	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES	FINISH	WEIGHT	SCALE	SHEET	REV
										1	E



Ocean End Feed Applicator

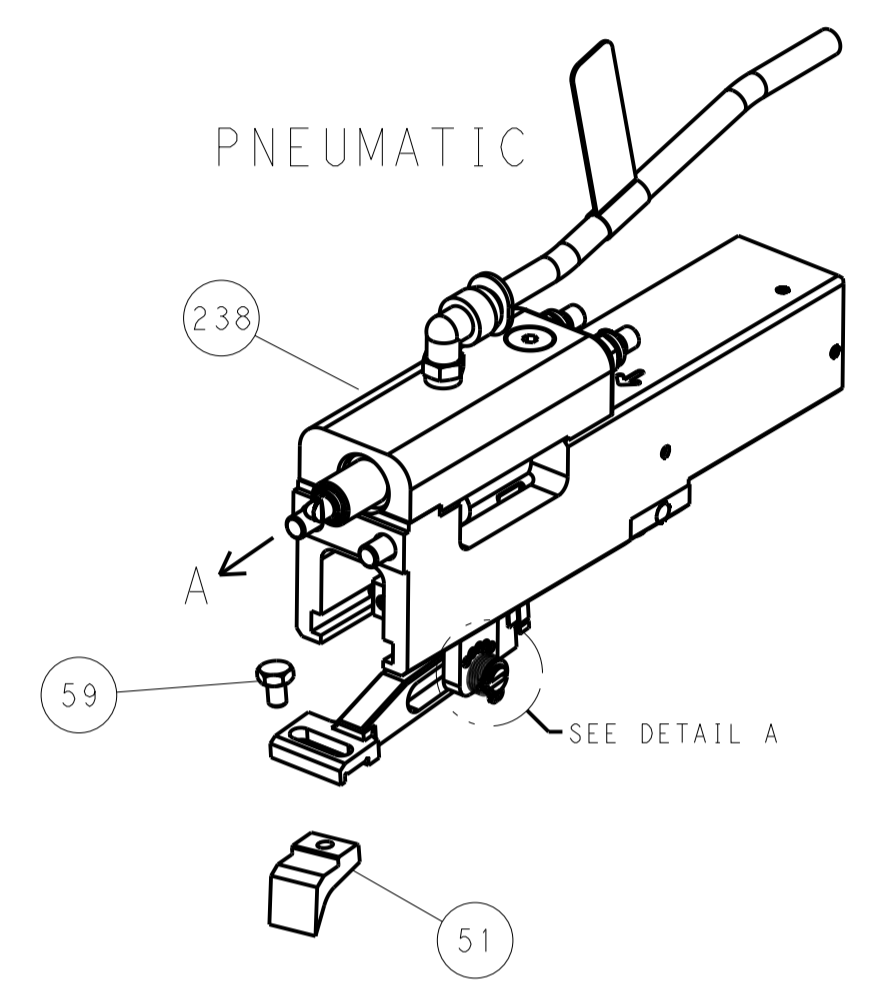
Customer Accessible Production Drawing

LOC	DIST	REV	DATE	BY	APPV
A	66				
REVISIONS			DESCRIPTION	DATE	BY
			SEE SHEET 1		

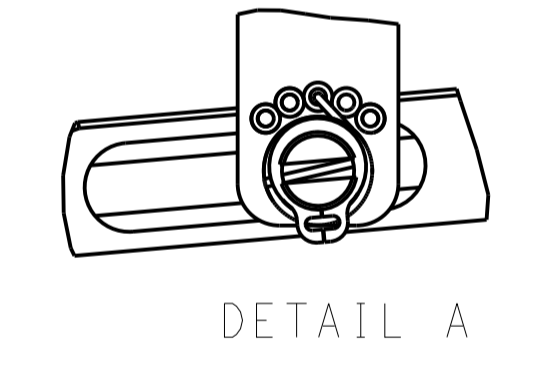


RAM AND HOLDDOWN SET-UP

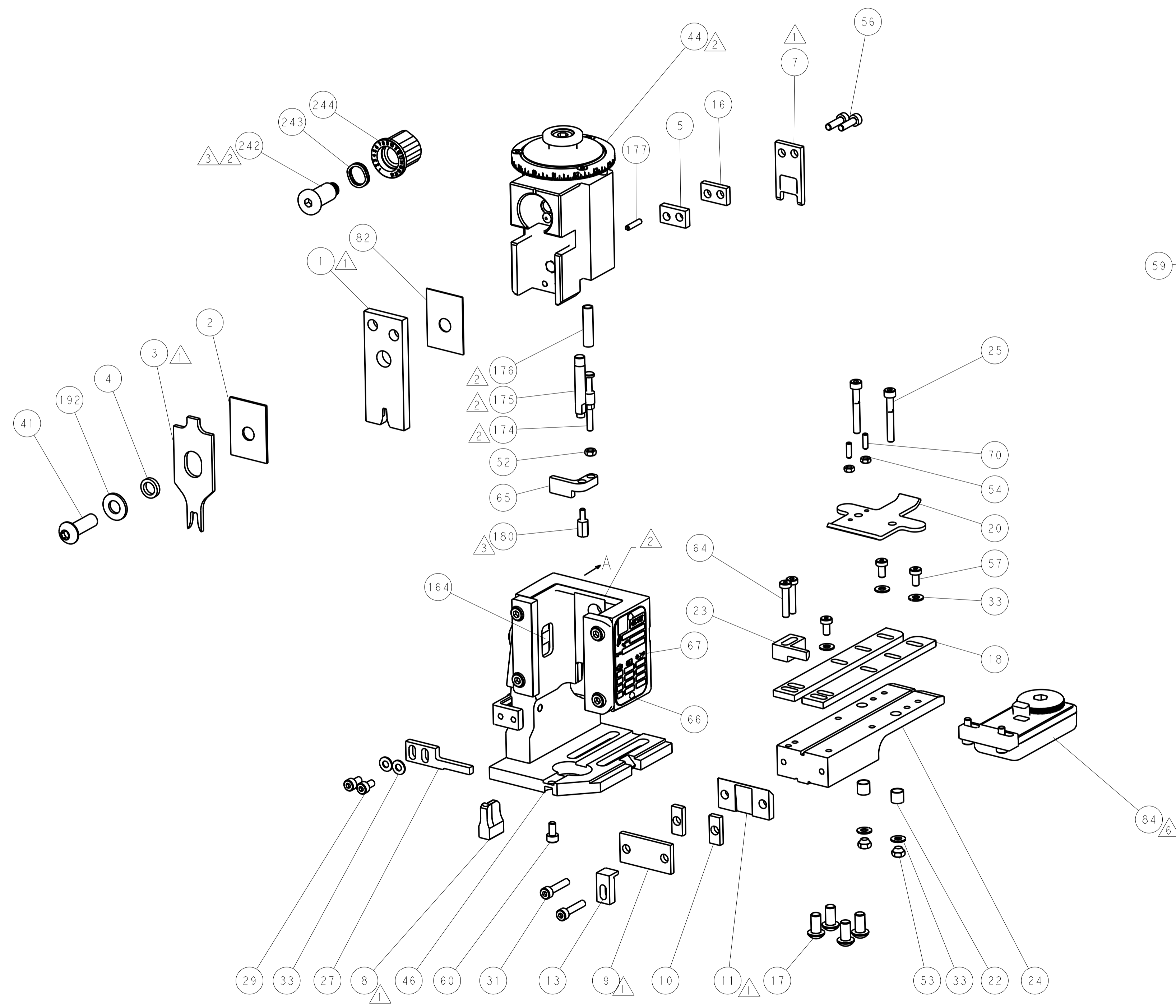
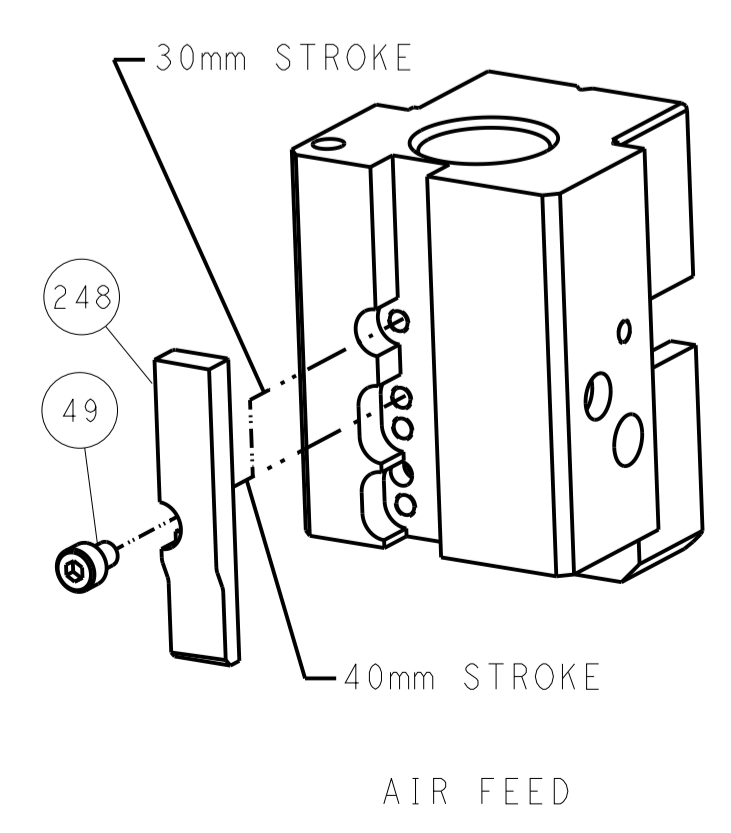
FEED TYPE



FEED SPRING SETTING POSITION



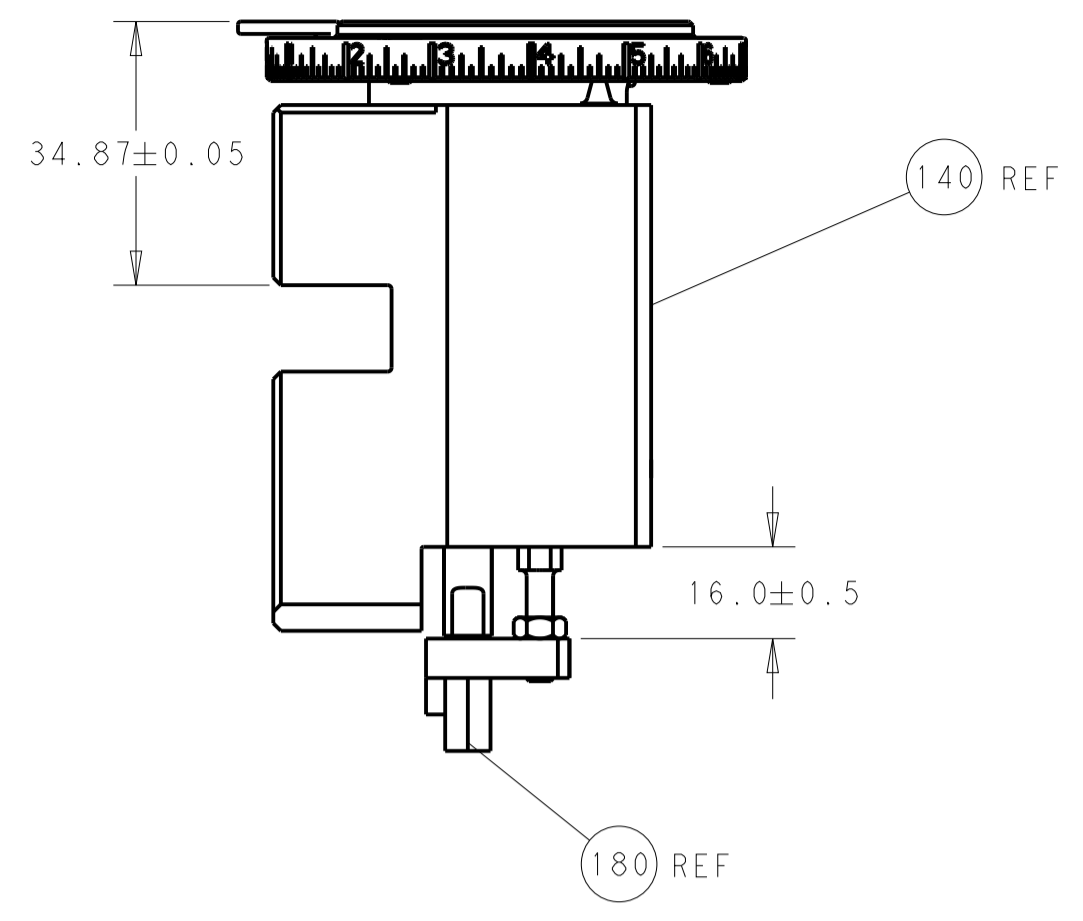
CAM POSITION



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

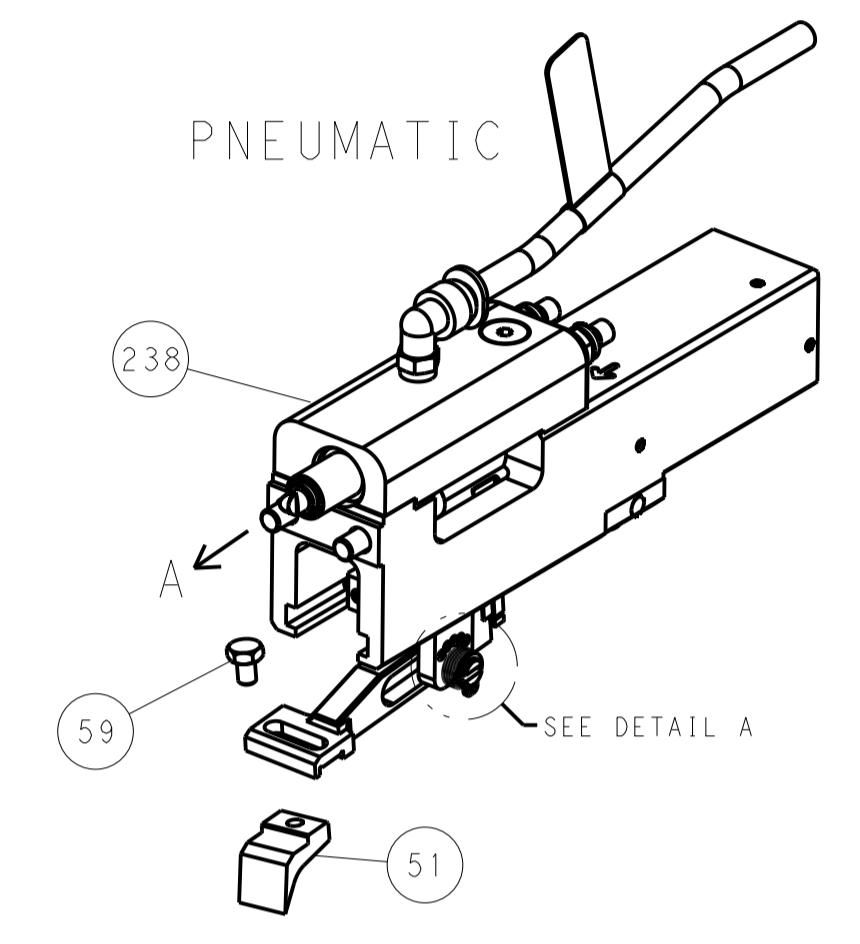
<small>THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.</small>		DWN: X.ZHAO 14JAN2014 CHK: L.ZHANG 14JAN2014 APVD: T.FLRIN 14JAN2014	TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		NAME: Ocean End Feed Applicator PRODUCT SPEC: APPLICATION SPEC: WEIGHT: SCALE: 1:1	RESTRICTED TO: SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2150408 SHEET 2 OF 4 REV E

LOC	DIST	REV	DATE	BY	APPV
A	66				

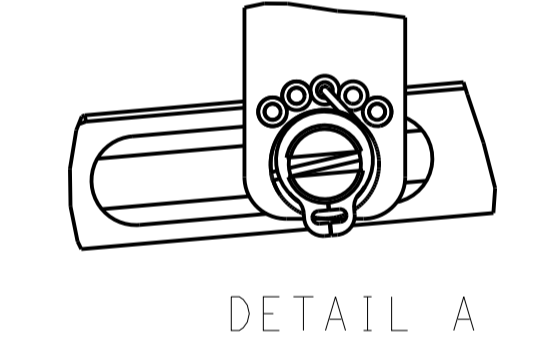


RAM AND HOLDDOWN SET-UP

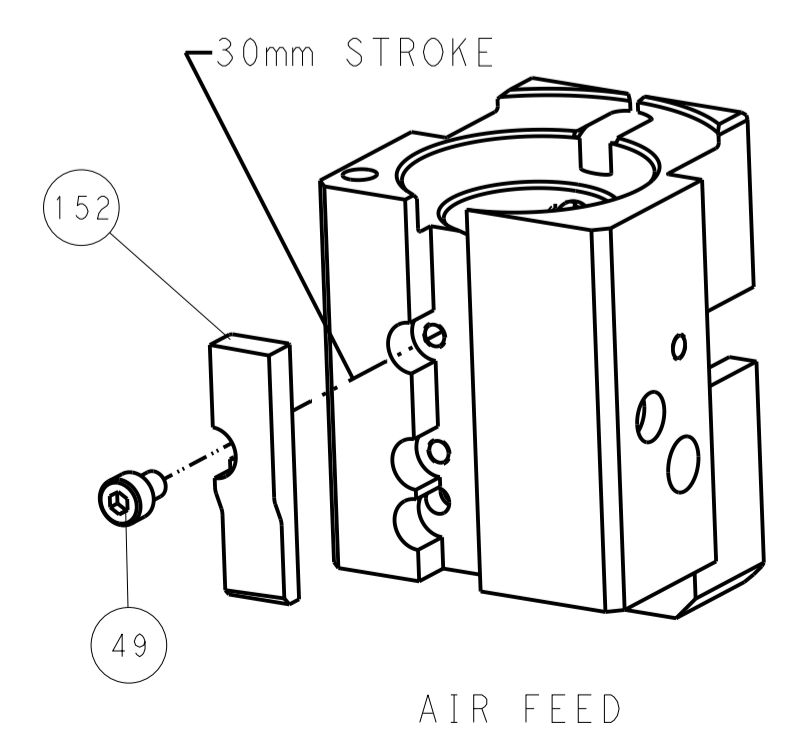
FEED TYPE



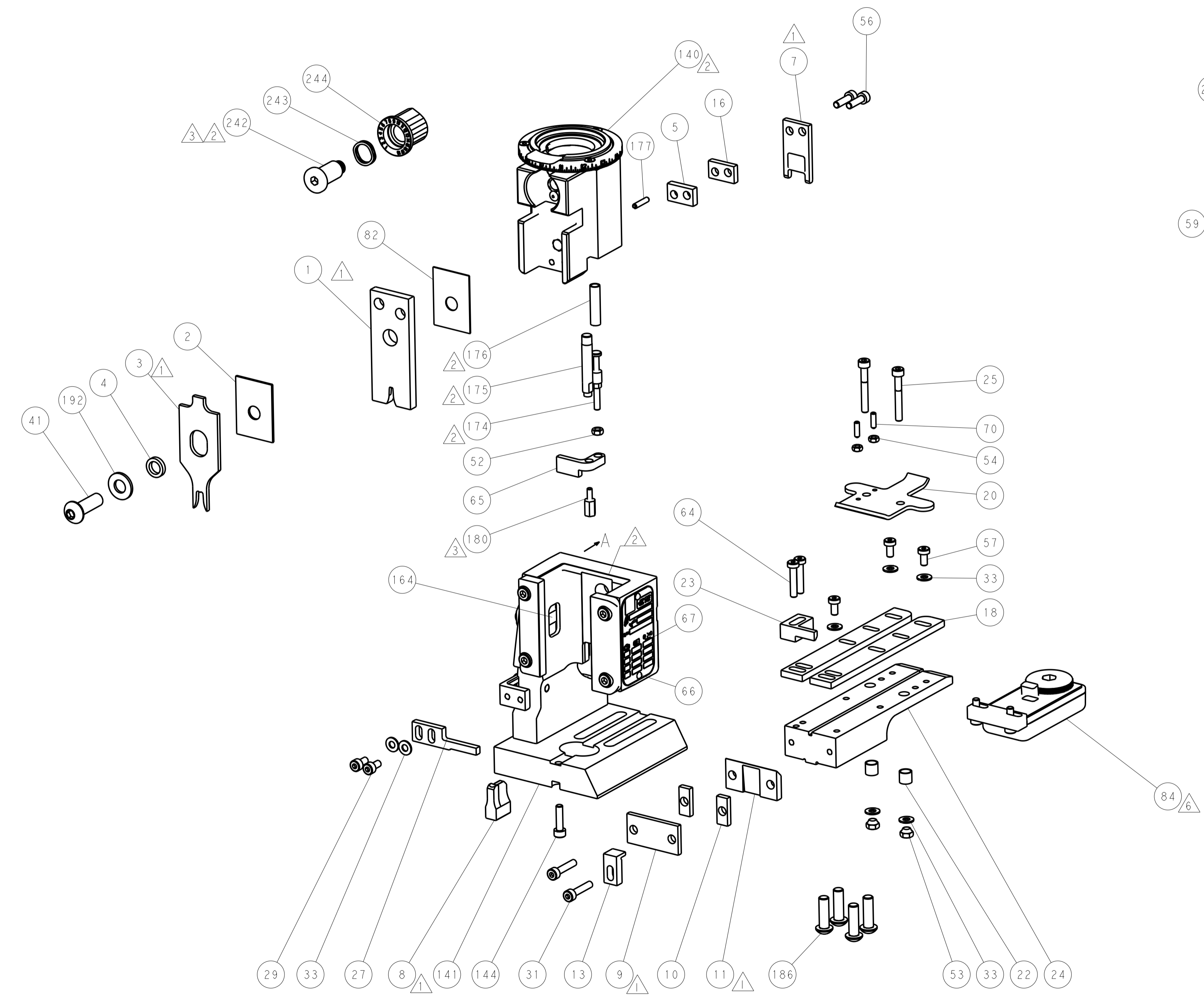
FEED SPRING SETTING POSITION



CAM POSITION



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:		DWG: X.ZHAO 14JAN2014		TE Connectivity	
mm		0 PLC ±		CHK: L.ZHANG 14JAN2014		Harrisburg, PA 17105-3608	
Ø		1 PLC ±		APPV: T.FLRIN 14JAN2014		NAME	
FINISH		2 PLC ±		PRODUCT SPEC		Ocean End Feed Applier	
MATERIAL		3 PLC ±		APPLICATION SPEC		SIZE CAGE CODE DRAWING NO	
		4 PLC ±		WEIGHT		A1 00779 C=2150408	
		5 PLC ±		Customer Accessible Production Drawing		RESTRICTED TO	
		6 PLC ±		SCALE 1:1		SHEET 4 OF 4 REV E	