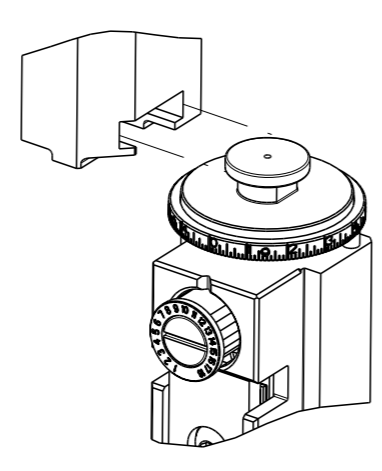


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150005-2	P	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150005-2	P	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150005-7	K	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	4.06 mm [1.160]	F
INSUL	5.33 mm [1.210]	OV
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION			
TERMINAL NAME: RINGTONGUE			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
5.00-5.50 mm [1.97-.217 IN]		∅3.40-4.70 mm [1.34-.185 IN]	
TERMINAL APPLICATION SPECIFICATION	114-18022		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
928927-4			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
4.00mm2	2.86 +/- 0.05 [1.113 +/- .002]	7.0
3.50mm2	2.78 +/- 0.05 [1.109 +/- .002]	8.0
3.00mm2	2.70 +/- 0.05 [1.106 +/- .002]	8.9

- 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.
- 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.
- TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- 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.

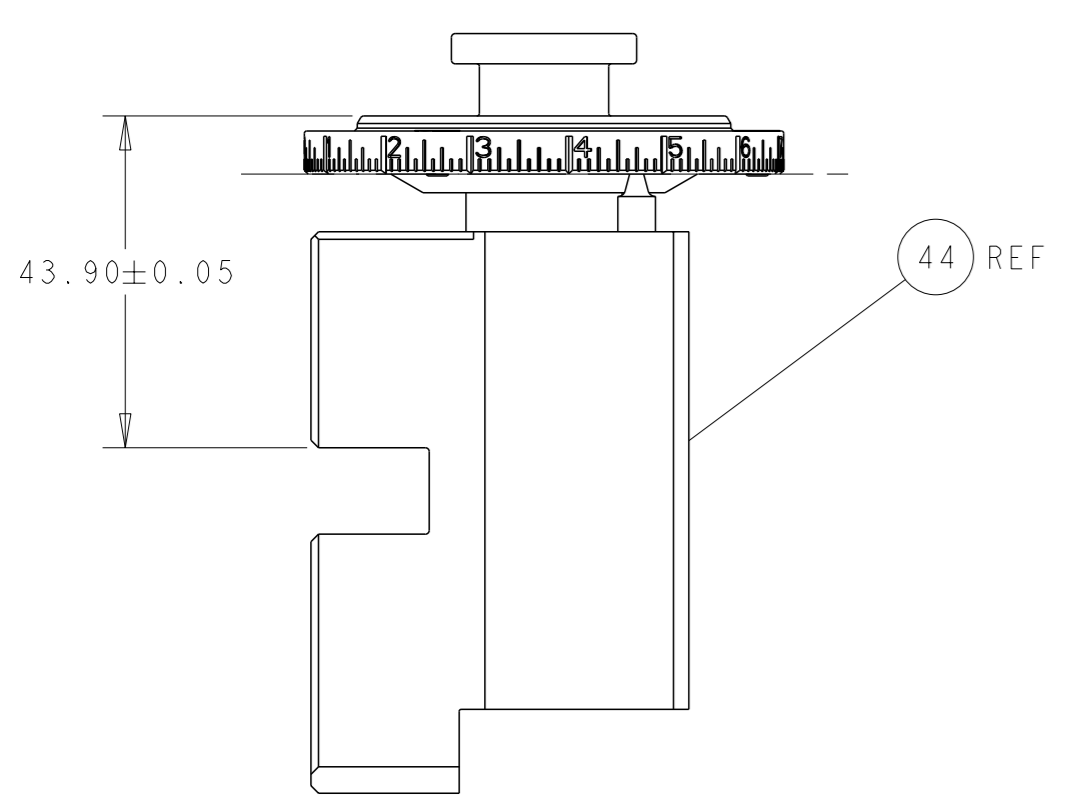
ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

LOC	DIST	REVISIONS					
A	66	P	LYH	DESCRIPTION	DATE	OWN	APVD
		M		ECR-19-013113	21AUG2019	MZ	YY
		N		ECR-20-016388	18NOV2020	FZ	TE
		N1		ECR-21-001531	04FEB2021	JWC	GB
		P		ECR-23-163493	12JAN2023	FZ	GB

-	1	1	2119641-1	FEED CAM, AIR FEED	248	
-	1	1	2119082-9	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	
-	REF	REF	994970-2	COUNTER, MAGNETIC	164	
-	1	1	2119955-2	ASSY, LUBRICATOR, END FEED	84	
-	1	1	455888-5	SPACER, CRIMPER	82	
-	1	1	1803203-1	BLOCK, FRONT DEPRESSOR	74	
-	1	1	2119791-9	DEPRESSOR, WIRE	73	
-	2	2	2-18032-2	SCR, SET, FLT PNT, M3 X 10.0	72	
-	1	1	1803607-4	DOCUMENTATION PACKAGE	71	
-	1	1	2119791-5	DEPRESSOR, WIRE	70	
-	1	1	2119943-1	WASHER, SPACER	69	
-	1	1	2119740-1	TAG, IDENTIFICATION	67	
-	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66	
-	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	
-	4	4	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57	
-	2	2	2-2168083-6	SCR, SKT HD CAP, RoHS, M4 X 18	56	
-	2	2	5018030-1	NUT, HEX, REG, RoHS, M3	54	
-	2	2	986965-8	NUT, LOCK, HEX, TORQUE (M4)	53	
-	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	
-	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	
-	1	1	1-1901696-0	STRIP GUIDE, REAR	19	
-	1	1	1-1901695-0	STRIP GUIDE, FRONT	18	
-	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17	
-	1	1	4-240641-6	SPACER	16	
-	1	1	240644-1	PLATE, REAR SHEAR	11	
-	-	-	-	-	10	
-	1	1	8-690482-9	PLATE, FRONT SHEAR	9	
1	2	1	1333223-5	ANVIL, COMBINATION	8	
-	1	1	1-2217206-5	BLADE, SLUG	7	
-	1	1	6-240641-0	SPACER	5	
-	1	1	5-238011-4	BLOCK, CRIMPER SPACER	4	
1	2	1	1803139-3	CRIMPER, INSULATION OVERLAP PREMIUM	3	
-	1	1	1-455888-0	SPACER, CRIMPER	2	
1	2	1	456414-9	CRIMPER, WIRE	1	
-	77	72	2	PART NO	DESCRIPTION	ITEM NO

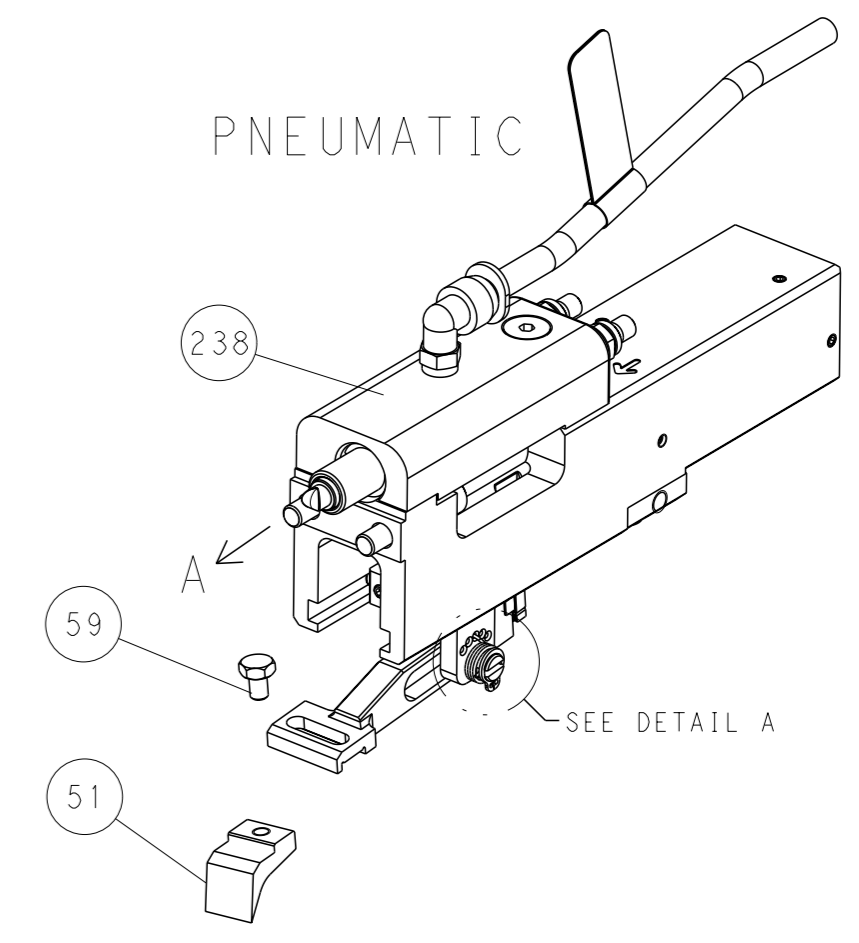
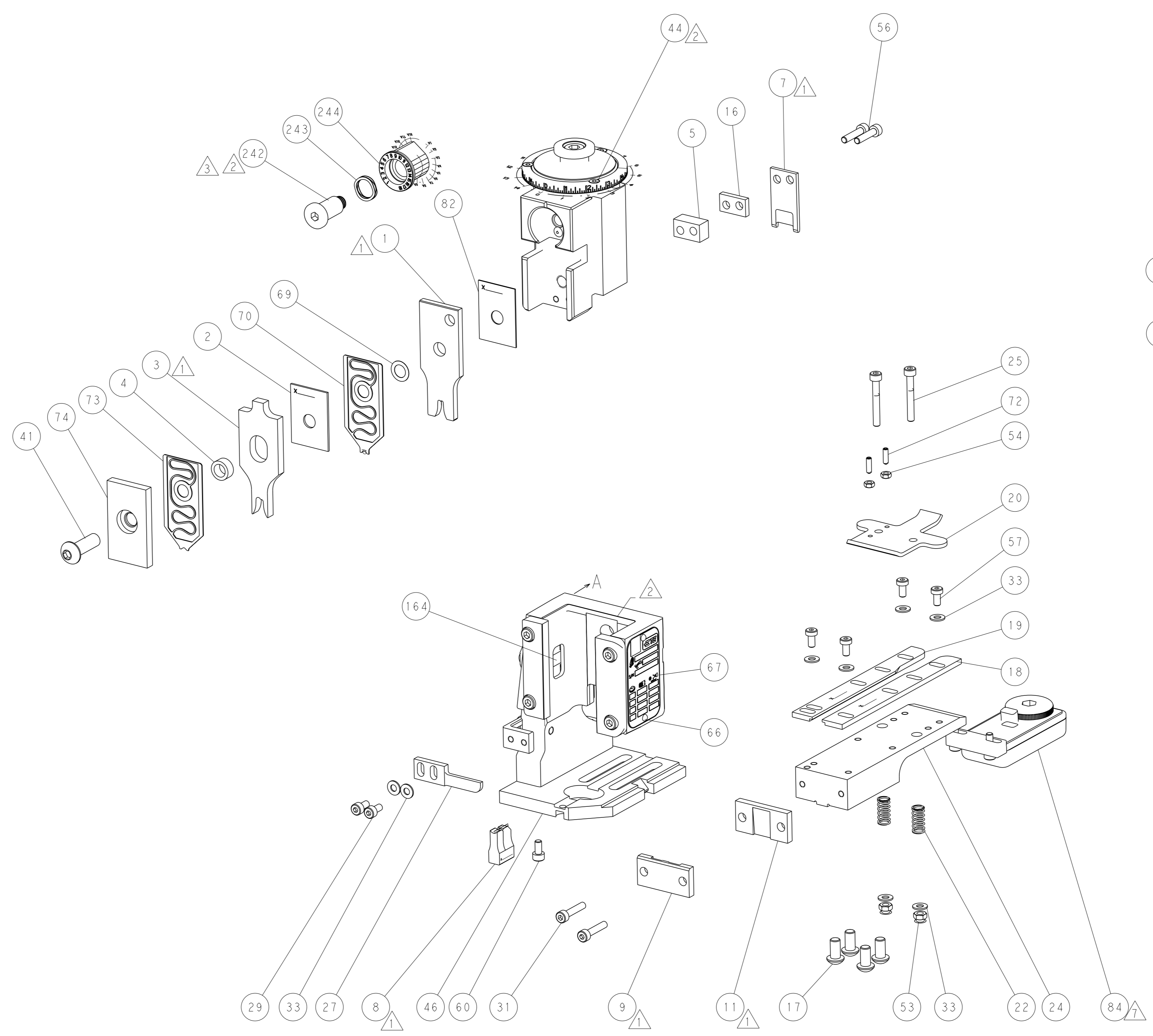
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG Y. YIN 01FEB2012		TE Connectivity	
mm		0 PLC ±		CHK G. BAILEY 01FEB2012		Harrisburg, PA 17105-3608	
		1 PLC ±		APVD S. XI 01FEB2012		NAME	
		2 PLC ±		PRODUCT SPEC		Ocean End Feed	
		3 PLC ±		APPLICATION SPEC		Applicator	
		4 PLC ±		SIZE		A1	
		ANGLES FINISH		CAGE CODE		00779	
				DRAWING NO		C=2150005	
				RESTRICTED TO			
				WEIGHT		-	
				SCALE		1:1	
				SHEET		1 of 4	
				REV		P	
				Customer Accessible Production Drawing			

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

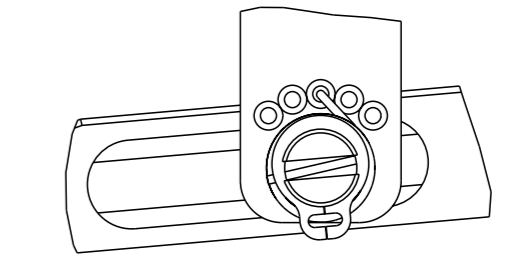


RAM SET-UP

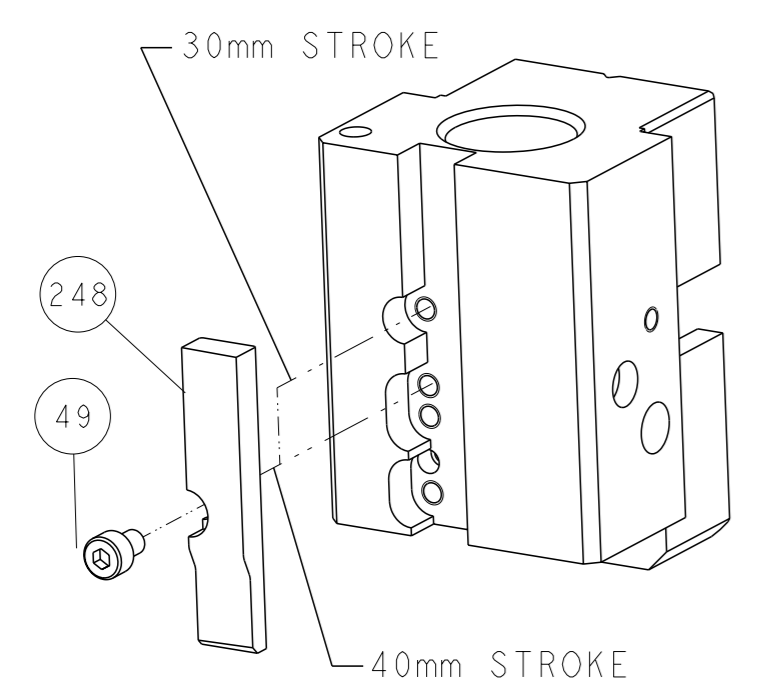
FEED TYPE



FEED SPRING SETTING POSITION



CAM POSITION

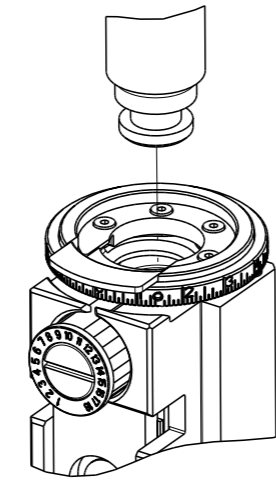


ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

<small>THIS DRAWING IS A CONTROLLED DOCUMENT FROM TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE AND TO CONTROL AND ENGINEERING DISCRETION SHOULD BE CONTACTED FOR THE LATEST REVISION.</small>		DWN Y. YIN 01FEB2012 CHK G. BAILEY 01FEB2012 APVD S. XI 01FEB2012	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 SCALE 1:1	SIZE CAGE CODE DRAWING NO. RESTRICTED TO A1 00779 ©=2150005 Customer Accessible Production Drawing SHEET 2 OF 4 REV P

THIS DRAWING IS UNPUBLISHED.	RELEASED FOR PUBLICATION		
COPYRIGHT 20 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.			
PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150005-2	P	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150005-7	K	CRIMP TOOLING KIT	-

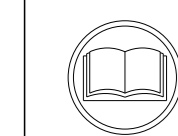
PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	4.06 mm [.160]	F
INSUL	5.33 mm [.210]	OV
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: RINGTONGUE			
WIRE STRIP LENGTH 5.00-5.50 mm [.197-.217 IN]		INSULATION DIAMETER RANGE Ø3.40-4.70 mm [.134-.185 IN]	
TERMINAL APPLICATION SPECIFICATION	114-18022	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
928927-4			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
4.00mm2	2.86 +/- 0.05 [.113 +/- .002]	7.0
3.50mm2	2.78 +/- 0.05 [.109 +/- .002]	8.0
3.00mm2	2.70 +/- 0.05 [.106 +/- .002]	8.9



- 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.
- 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 PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- 7 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.

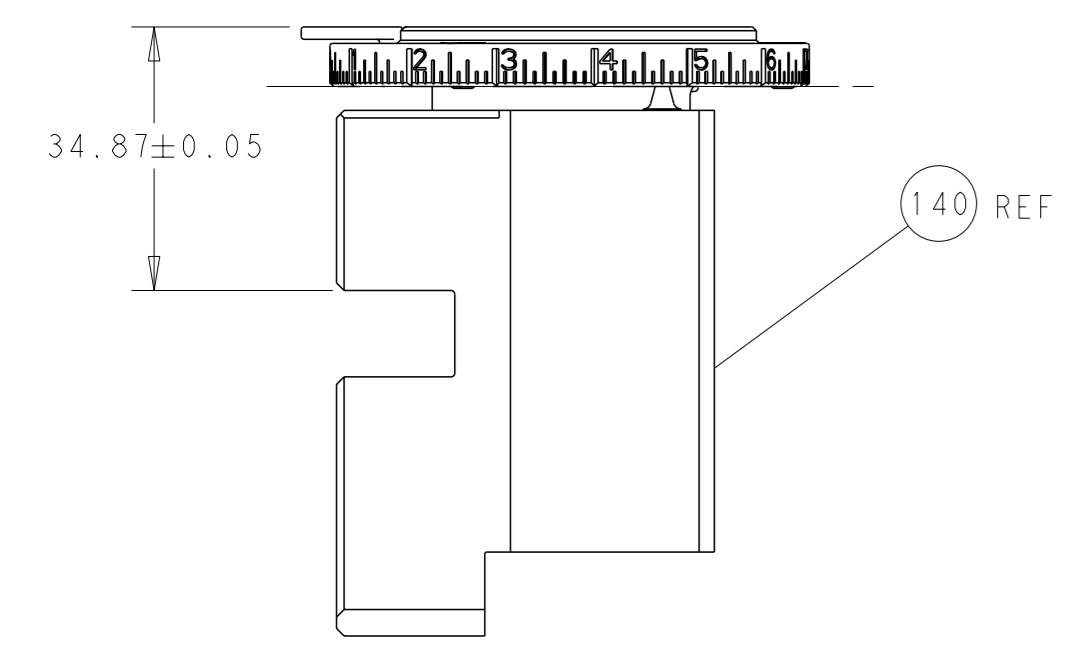
PACIFIC VERSION
Shown on sheets 3 of 4 & 4 of 4
(Atlantic version shown on sheets 1 of 4 & 2 of 4)

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

-	1	2119082-9	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
-	4	2079383-9	SCR, BHSC, RoHS (M6 X 20)	186
-	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	2119655-6	APPLICATOR BASIC ASSEMBLY, EF	141
-	1	1803518-1	RAM ASSEMBLY, EF PACIFIC	140
-	1	2119955-2	ASSY, LUBRICATOR, END FEED	84
-	1	455888-5	SPACER, CRIMPER	82
-	1	1803203-1	BLOCK, FRONT DEPRESSOR	74
-	1	2119791-9	DEPRESSOR, WIRE	73
-	2	2-18032-2	SCR, SET, FLT PNT, M3 X 10.0	72
-	1	1803607-4	DOCUMENTATION PACKAGE	71
-	1	2119791-5	DEPRESSOR, WIRE	70
-	1	2119943-1	WASHER, SPACER	69
-	1	2119740-1	TAG, IDENTIFICATION	67
-	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	4	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57
-	2	2-2168083-6	SCR, SKT HD CAP, RoHS, M4 X 18	56
-	2	5018030-1	NUT, HEX, REG, RoHS, M3	54
-	2	986965-8	NUT, LOCK, HEX, TORQUE (M4)	53
-	1	2063961-1	FEED FINGER	51
-	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
-	8	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	1752371-5	PLATE, STRIP GUIDE	24
-	2	2-22281-3	SPRING, COMPRESSION	22
-	1	1803292-4	DRAG	20
-	1	1-1901696-0	STRIP GUIDE, REAR	19
-	1	1-1901695-0	STRIP GUIDE, FRONT	18
-	1	4-240641-6	SPACER	16
-	1	240644-1	PLATE, REAR SHEAR	11
-	-	-	-	10
-	1	8-690482-9	PLATE, FRONT SHEAR	9
1	1	1333223-5	ANVIL, COMBINATION	8
-	1	1-2217206-5	BLADE, SLUG	7
-	1	6-240641-0	SPACER	5
-	1	5-238011-4	BLOCK, CRIMPER SPACER	4
1	1	1803139-3	CRIMPER, INSULATION OVERLAP PREMIUM	3
-	1	1-455888-0	SPACER, CRIMPER	2
1	1	456414-9	CRIMPER, WIRE	1
-	77-22	PART NO	DESCRIPTION	ITEM NO

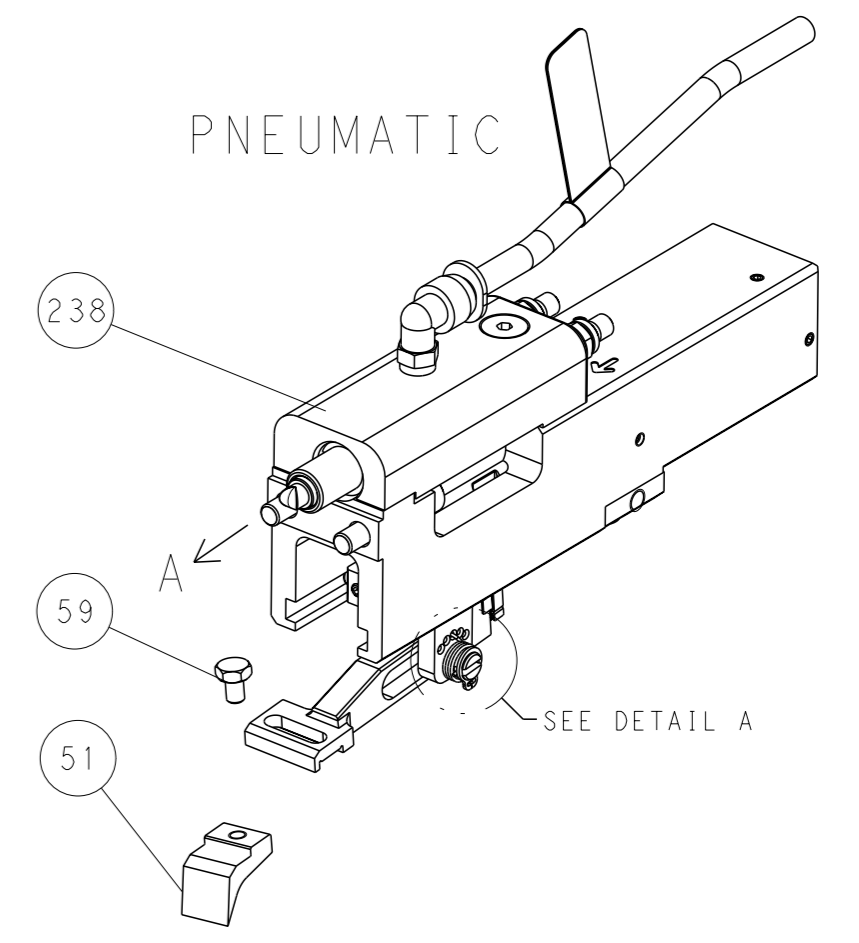
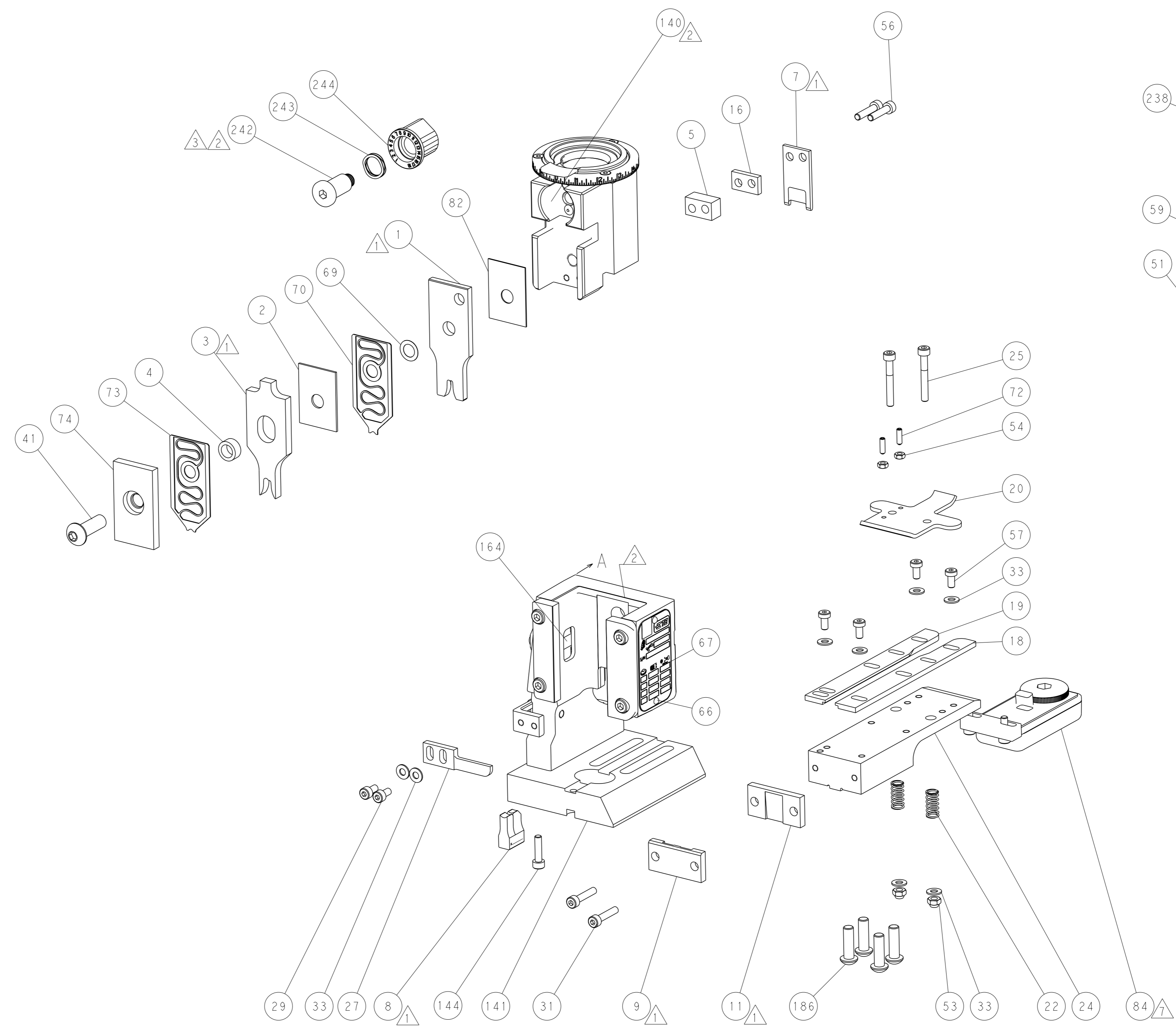
<small>THE DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE AND THE CUSTOMER'S RESPONSIBILITY TO VERIFY THE DIMENSIONS AND TOLERANCES SHOWN ON THE DRAWING BEFORE PROCEEDING WITH PRODUCTION.</small>		OWN: Y. YIN 01FEB2012 CHK: G. BAILEY 01FEB2012 APVD: S. YI 01FEB2012	TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH ±		NAME: Ocean End Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2150005 SCALE: 1:1 SHEET: 3 of 4 REV: P	
MATERIAL:		WEIGHT:	
CUSTOMER ACCESSIBLE PRODUCTION DRAWING		RESTRICTED TO:	

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

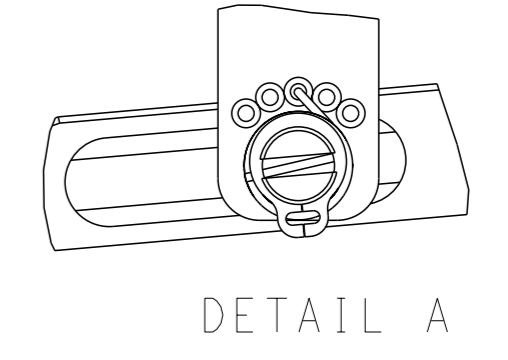


RAM SET-UP

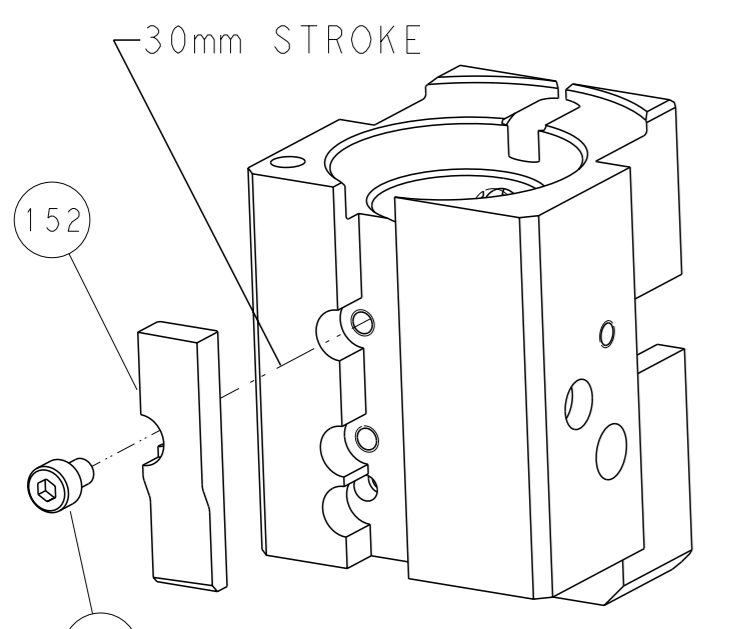
FEED TYPE



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)

<small>THIS DRAWING IS A CONTROLLED DOCUMENT FROM TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE AND THE CONTROLLER'S ENGINEERING DEPARTMENT SHOULD BE CONTACTED FOR THE LATEST REVISION.</small>		DWN Y.YIN 01FEB2012 CHK G.BAILEY 01FEB2012 APVD S.XI 01FEB2012	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 WEIGHT SCALE 1:1	SIZE A1 CAGE CODE 00779 DRAWING NO. C=2150005 SHEET 4 OF 4 REV P
MATERIAL:		Customer Accessible Production Drawing	