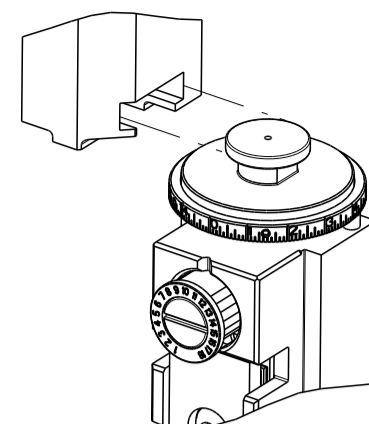


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150442-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150442-2	B	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150442-7	A	CRIMP TOOLING KIT	-

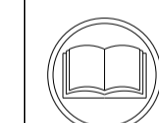
ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	4.32 mm [.170]	F
INSUL	5.72 mm [.225]	F
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: HS TERMINAL HS CRIMP SPECIFICATION			
TERMINAL NAME: RING TERMINAL			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
6.02-6.78 mm [.237-.267 IN]		∅ 4.75 mm MAX [.187 IN MAX]	
TERMINAL APPLICATION SPECIFICATION	HS	-	-
TERMINALS APPLIED			
TE TERMINAL	HS TERMINAL	TE TERMINAL	HS TERMINAL
2113468-1	24.359.110	2113468-3	24.359.310
2113468-2	24.359.120	2113468-4	24.359.320

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
6.00mm2	3.55 +/- 0.05 [.140 +/- .002]	6.0
4.00mm2	3.25 +/- 0.05 [.128 +/- .002]	9.0



- 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 TERMINAL LUBRICANT IS RECOMMENDED.
- 6 UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- 7 TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.

**\*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.

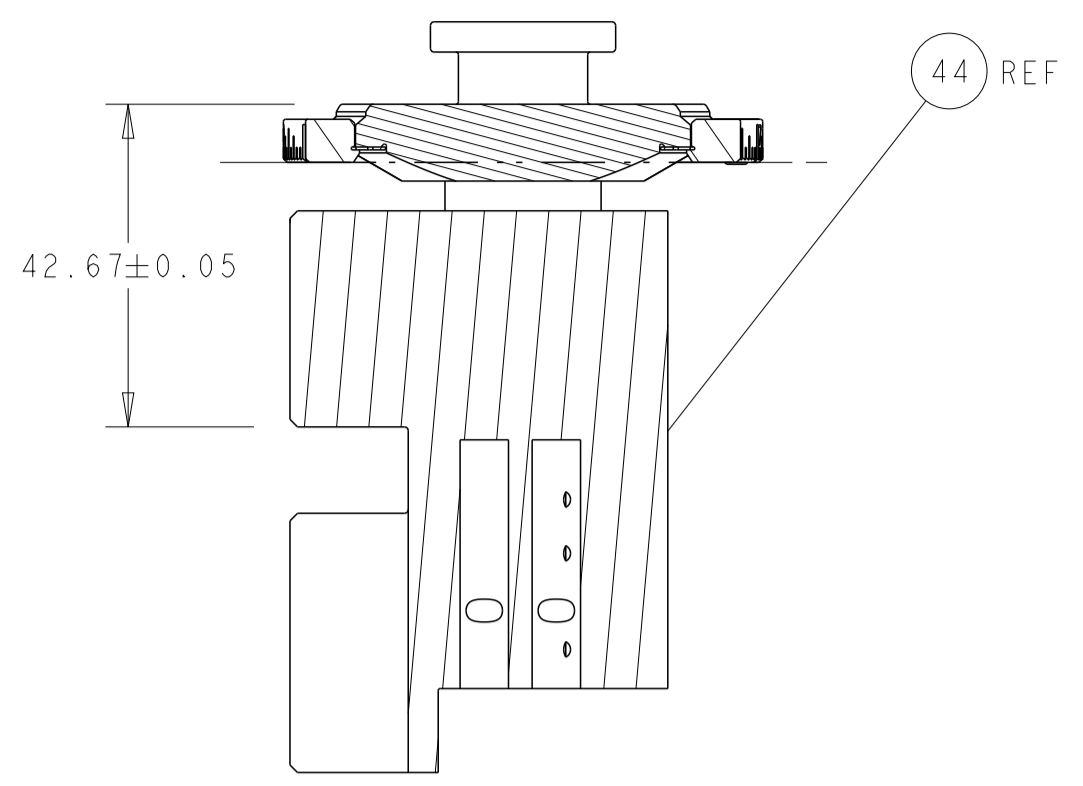
LOC	DIST	REVISIONS					
A	66	P	LTN	DESCRIPTION	DATE	OWN	APVD
		A		RELEASED	19JUN2014	LG	TE
		B		ECR-23-163140	09JAN2023	TB	RK

-	1	1	2119641-1	FEED CAM, AIR FEED	248
-	1	1	2119082-4	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
-	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	1	1	2119955-2	ASSY, LUBRICATOR, END FEED	84
-	1	1	455888-6	SPACER, CRIMPER	82
-	1	1	2119791-5	DEPRESSOR, WIRE	73
-	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	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	2-2168083-5	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	2063961-9	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	690455-7	STRIPPER, FRONT CASTING	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	4-1901696-6	STRIP GUIDE, REAR	19
-	1	1	4-1901695-6	STRIP GUIDE, FRONT	18
-	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17
-	1	1	2-240641-4	SPACER	16
-	1	1	240644-9	PLATE, REAR SHEAR	11
-	-	-	-	-	10
-	1	1	690482-3	PLATE, FRONT SHEAR	9
1	2	1	1-1803059-2	ANVIL, COMBINATION, END FEED	8
-	1	1	1-2217206-4	BLADE, SLUG	7
-	-	-	-	-	6
-	1	1	2-240641-9	SPACER	5
-	1	1	4-238011-4	BLOCK, CRIMPER SPACER	4
1	2	1	3-1803017-2	CRIMPER, INSULATION F	3
-	1	1	455888-4	SPACER, CRIMPER	2
1	2	1	6-1633730-2	CRIMPER, WIRE	1
-	77	72	-2	PART NO	ITEM NO

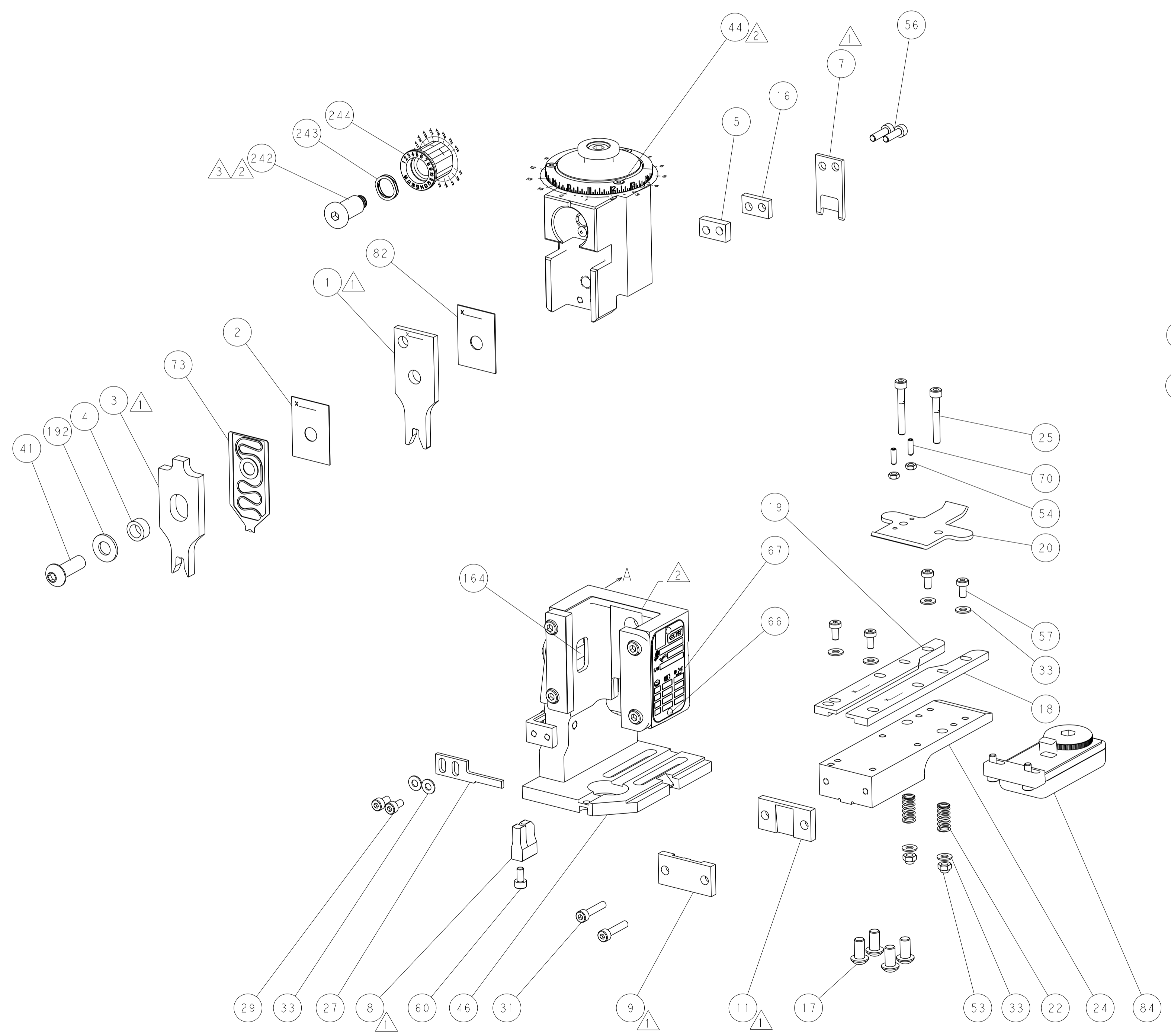
ATLANTIC VERSION  
Shown on sheets 1 of 4 & 2 of 4  
(Pacific version shown on sheets 3 of 4 & 4 of 4)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		MATERIAL:		FINISH:		WEIGHT:		SCALE:		SHEET:		REV:		
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES	FINISH			Customer Accessible Production Drawing	SCALE	1:1	SHEET	1 of 4	REV	B

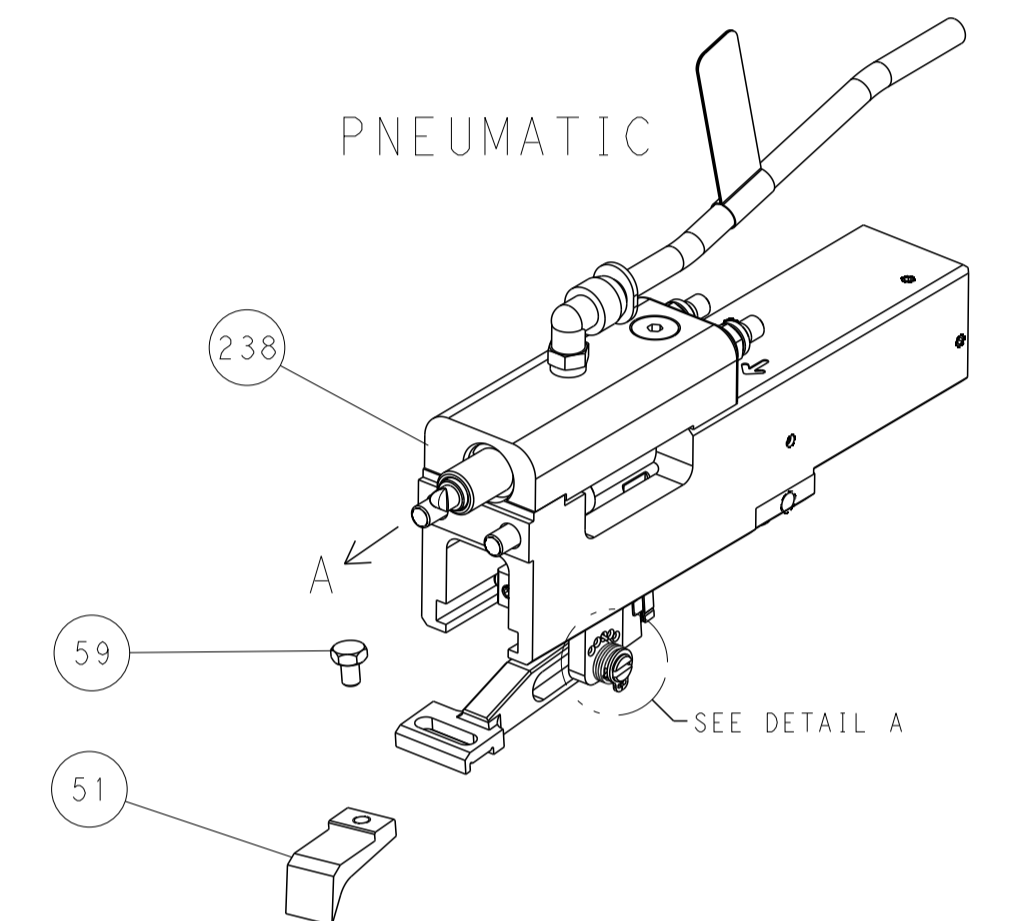
LOC	DIST	REVISIONS					
A	66	P	LTN	DESCRIPTION	DATE	DWN	APVD
		-		SEE SHEET 1	-	-	-



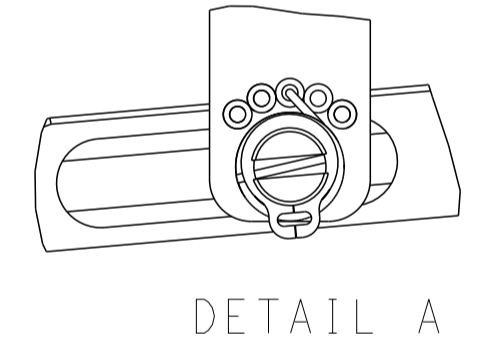
RAM SET-UP



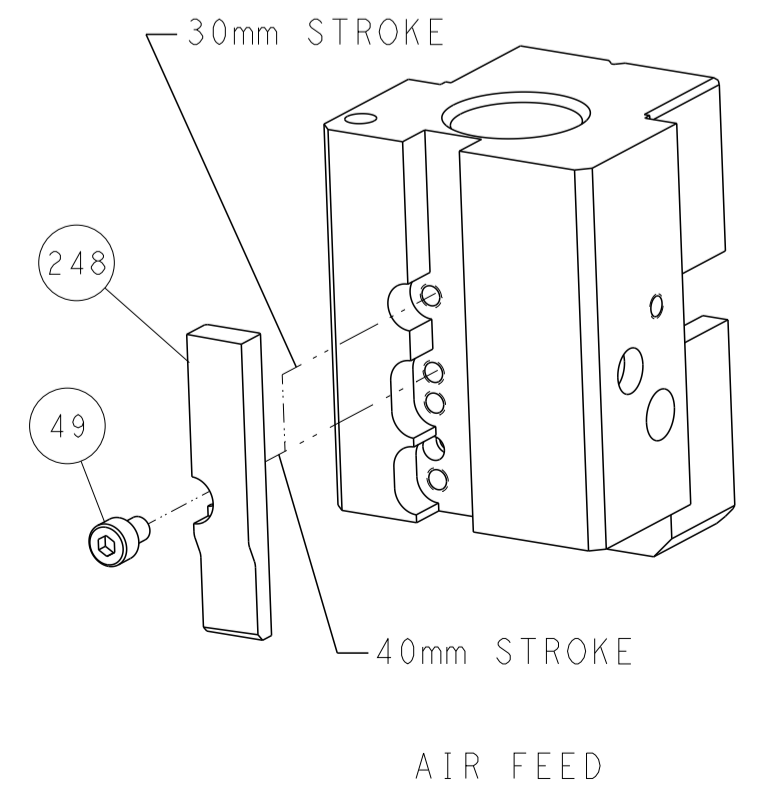
FEED TYPE



FEED SPRING SETTING POSITION



CAM POSITION

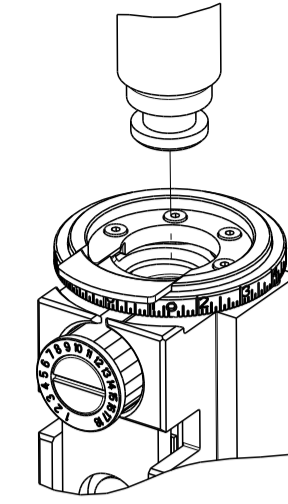


ATLANTIC VERSION  
 Shown on sheets 1 of 4 & 2 of 4  
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

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DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± MATERIAL: - FINISH: -		NAME: Ocean End Feed Applier PRODUCT SPEC: - APPLICATION SPEC: - WEIGHT: - SCALE: 1:1	SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2150442 SHEET 2 OF 4 REV B
Customer Accessible Production Drawing			

THIS DRAWING IS UNPUBLISHED.	RELEASED FOR PUBLICATION		
COPYRIGHT 20 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.			
PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150442-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150442-7	A	CRIMP TOOLING KIT	-

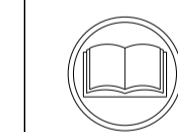
PACIFIC VERSION TERMINATOR  
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	4.32 mm [ .170 ]	F
INSUL	5.72 mm [ .225 ]	F
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: HS TERMINAL		HS CRIMP SPECIFICATION	
TERMINAL NAME: RING TERMINAL			
WIRE STRIP LENGTH 6.02-6.78 mm [ .237-.267 IN ]		INSULATION DIAMETER RANGE Ø 4.75 mm MAX [ 1.187 IN MAX ]	
TERMINAL APPLICATION SPECIFICATION	HS	-	-
TERMINALS APPLIED			
TE TERMINAL	HS TERMINAL	TE TERMINAL	HS TERMINAL
2113468-1	24.359.110	2113468-3	24.359.310
2113468-2	24.359.120	2113468-4	24.359.320

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
6.00mm2	3.55 +/- 0.05 [ .140 +/- .002 ]	6.0
4.00mm2	3.25 +/- 0.05 [ .128 +/- .002 ]	9.0



- 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.
- TERMINAL LUBRICANT IS RECOMMENDED.
- UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.

**\*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.

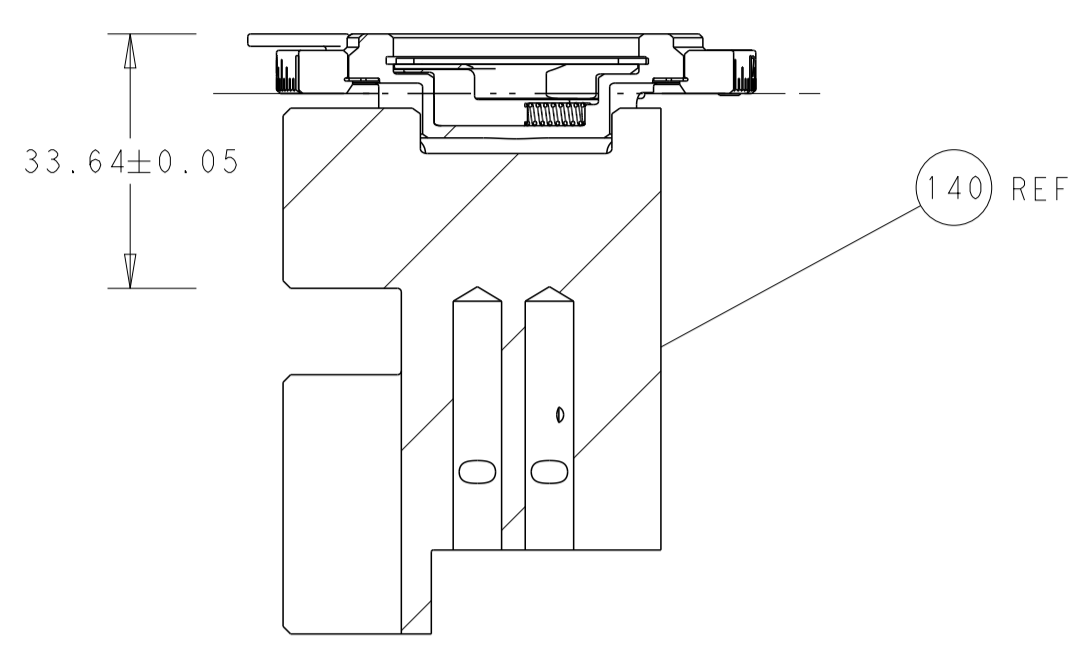
LOC	DIST	REVISIONS					
A	66	P	LTN	DESCRIPTION	DATE	OWN	APVD
-	-	-	-	SEE SHEET 1	-	-	-

-	1	2119082-4	CAM, SNAIL, INSULATION ADJUSTMENT	244	
-	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243	
3	-	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	
-	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	
5	-	1	2119955-2	ASSY, LUBRICATOR, END FEED	84
-	1	455888-6	SPACER, CRIMPER	82	
-	1	2119791-5	DEPRESSOR, WIRE	73	
-	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	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59	
-	4	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57	
-	2	2-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 14	56	
-	2	5018030-1	NUT, HEX, REG, RoHS, M3	54	
-	2	986965-8	NUT, LOCK, HEX, TORQUE (M4)	53	
-	1	2063961-9	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	690455-7	STRIPPER, FRONT CASTING	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	4-1901696-6	STRIP GUIDE, REAR	19	
-	1	4-1901695-6	STRIP GUIDE, FRONT	18	
-	1	2-240641-4	SPACER	16	
1	-	1	240644-9	PLATE, REAR SHEAR	11
-	-	-	-	10	
1	-	1	690482-3	PLATE, FRONT SHEAR	9
1	1	1	1-1803059-2	ANVIL, COMBINATION, END FEED	8
1	-	1	1-2217206-4	BLADE, SLUG	7
-	-	-	-	6	
-	1	1	2-240641-9	SPACER	5
-	1	1	4-238011-4	BLOCK, CRIMPER SPACER	4
1	1	1	3-1803017-2	CRIMPER, INSULATION F	3
-	1	1	455888-4	SPACER, CRIMPER	2
1	1	1	6-1633730-2	CRIMPER, WIRE	1

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:		DWN: L. GROSS 06JUN2014		CHK: T. ELBIN 06JUN2014		NAME: D. STOUGH 06JUN2014		APVD: PRODUCT SPEC	
MATERIAL:		FINISH:		WEIGHT:		SCALE: 1:1		SHEET 3 OF 4		REV B	
Customer Accessible Production Drawing				Customer Accessible Production Drawing		SCALE: 1:1		SHEET 3 OF 4		REV B	

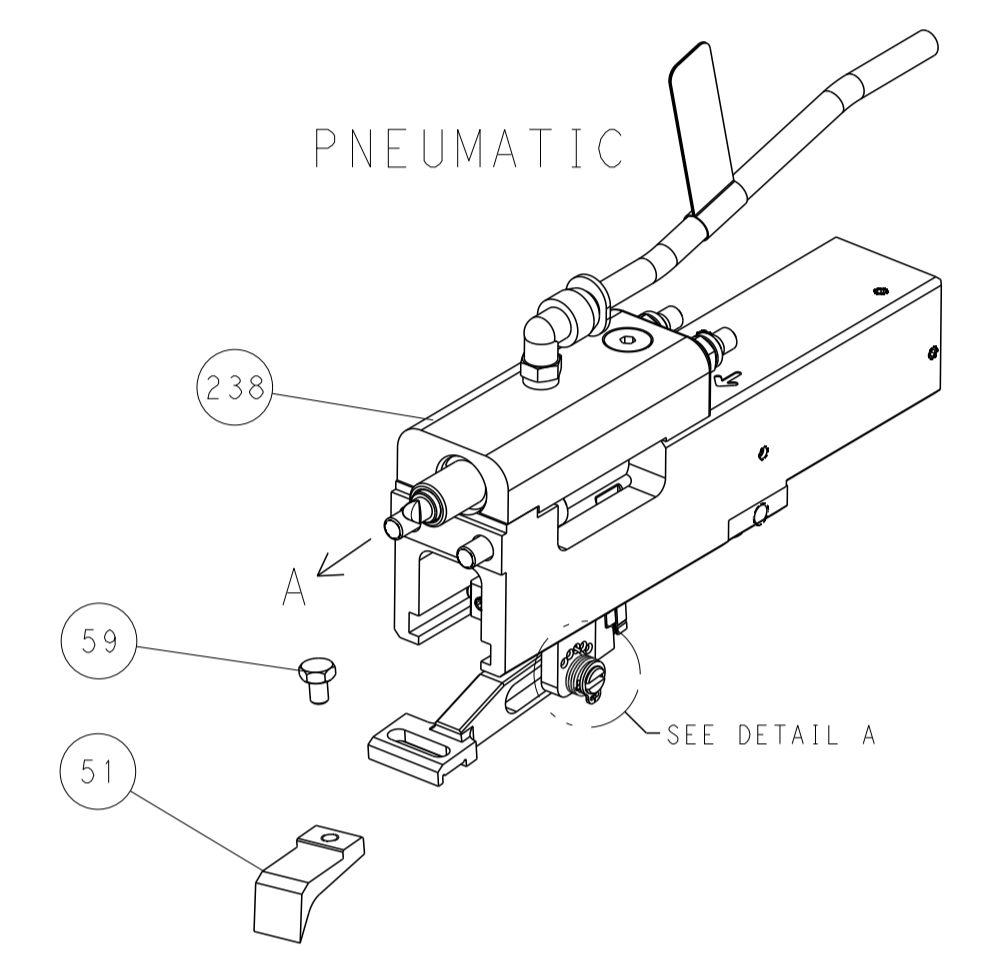
LOC		DIST		REVISONS			
A	66	P	LTN	DESCRIPTION	DATE	OWN	APVD
		-		SEE SHEET 1	-	-	-



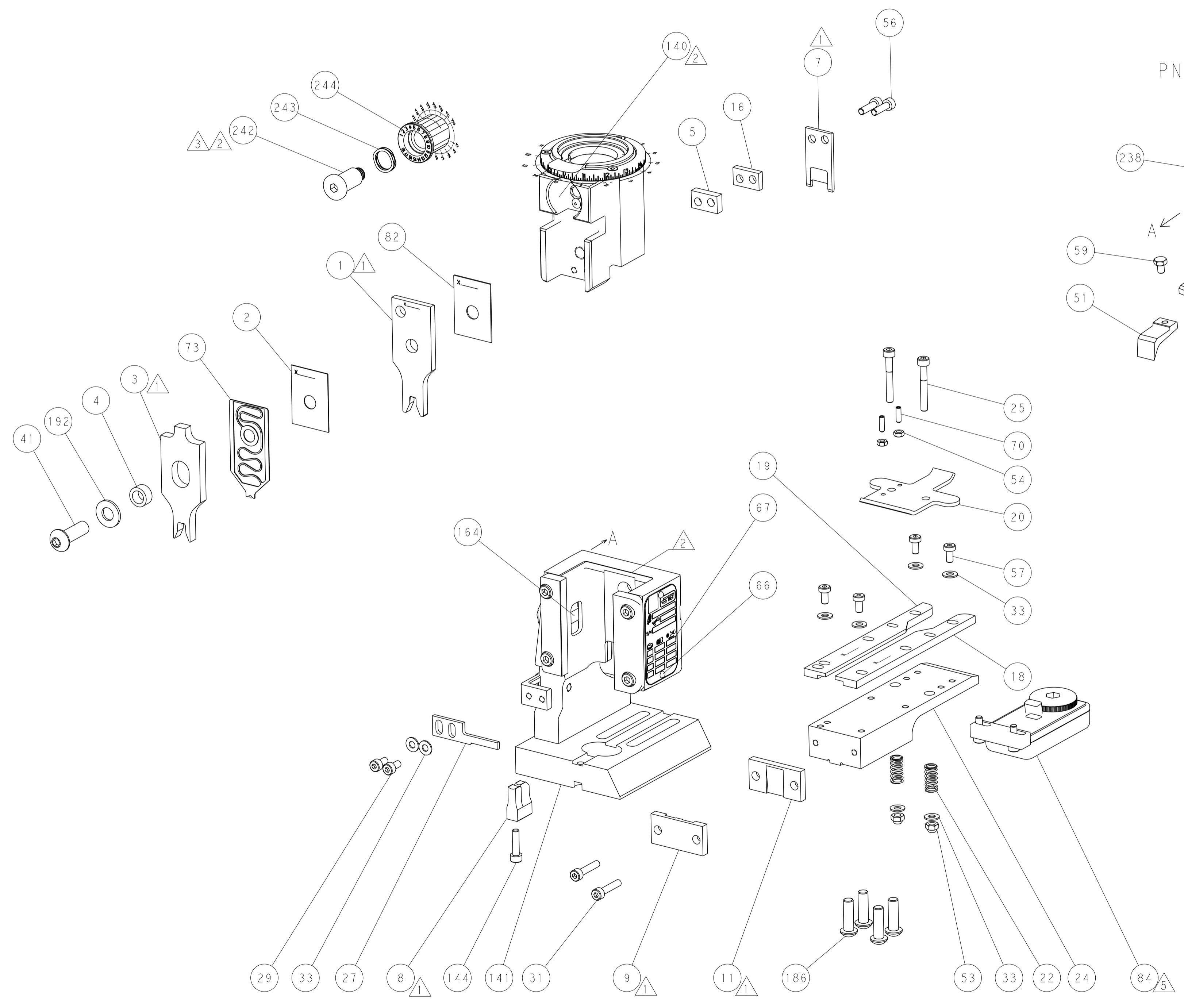
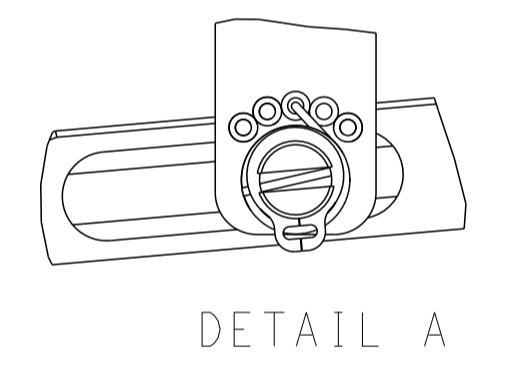
RAM SET-UP

FEED TYPE

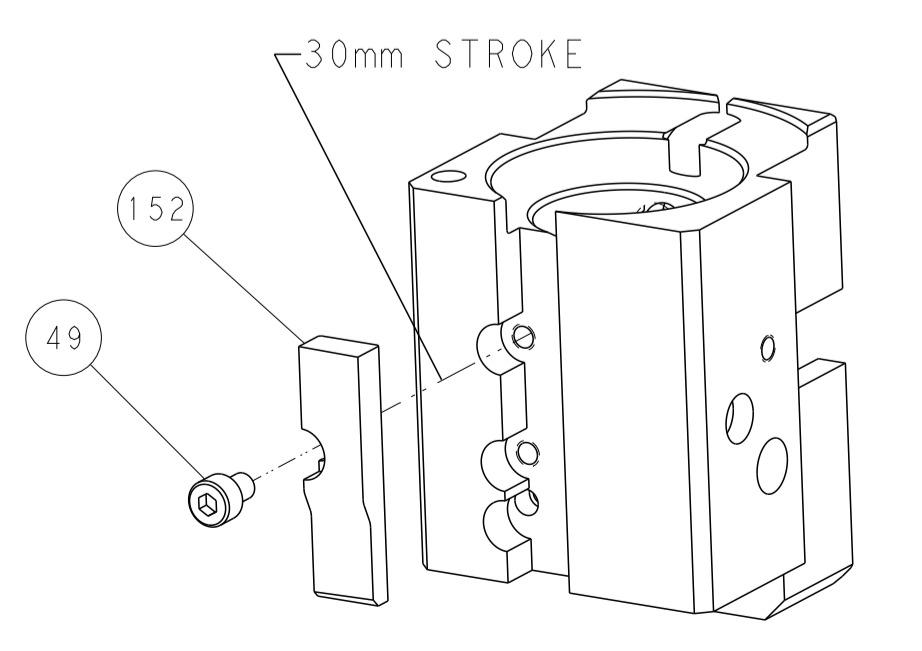
PNEUMATIC



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)

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DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± MATERIAL: - FINISH: -	WEIGHT: - SCALE: 1:1 SHEET: 4 of 4 REV: B	STE TE Connectivity Harrisburg, PA 17105-3608 Customer Accessible Production Drawing		