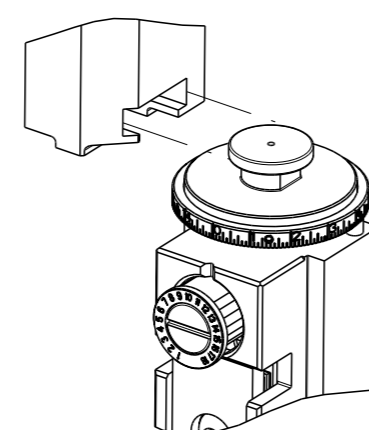


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150515-2	D	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150515-2	D	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150515-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	3.05 mm [.120]	F
INSUL	4.57 mm [.180]	F
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION			
TERMINAL NAME: RING TONGUE			
WIRE STRIP LENGTH 4.48-5.08 mm [.176-.200 IN]	INSULATION DIAMETER RANGE Ø2.29-3.68 mm [.090-.145 IN]		
TERMINAL APPLICATION SPECIFICATION 114-2084			
TERMINALS APPLIED			
TE TERMINAL 62787-1	TE TERMINAL 61777-1	TE TERMINAL 63602-1	TE TERMINAL 62978-1
62787-2	62786-1	63602-2	

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
14 AWG	2.21+/-0.05 [.087+/-0.002]	7.1
2 x 18 AWG	2.08+/-0.05 [.082+/-0.002]	8.3
16 AWG	2.03+/-0.05 [.080+/-0.002]	8.7
18 AWG	1.91+/-0.05 [.075+/-0.002]	10.1

- ⚠ 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.
- 6. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- ⚠ TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- ⚠ CUT TO LENGTH AT ASSEMBLY.

***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.

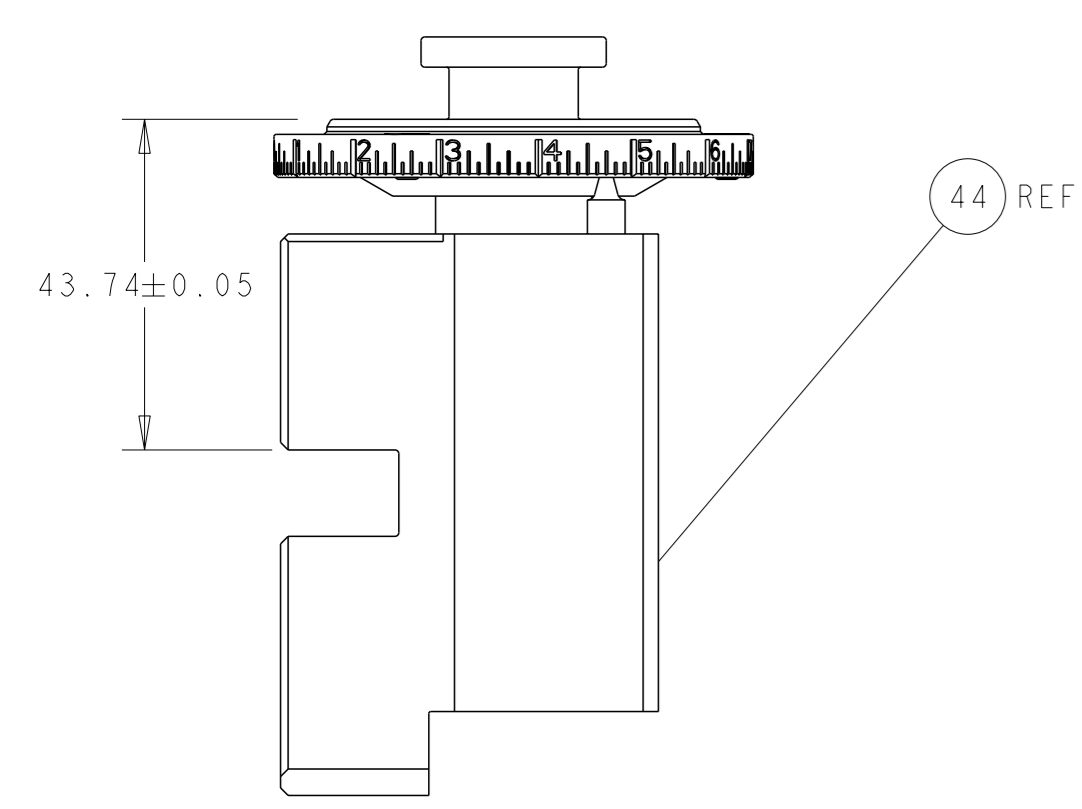
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		B		ECR-16-001129	26 JAN 2016	YY	GB
		C		ECR-19-005983	13 APR 2019	TB	TE
		C1		ECR-19-011726	25 JUL 2019	FZ	TE
		D		ECR-19-012618	09 AUG 2019	JAH	RR

-	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	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	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	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	1-2168083-2	SCR, SKT HD CAP, RoHS, M4 X 25	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	1-2119655-1	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	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	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	2-1901696-5	STRIP GUIDE, REAR	19
-	1	1	2-1901695-5	STRIP GUIDE, FRONT	18
-	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17
-	1	1	240641-6	SPACER	16
⚠	-	1	240644-1	PLATE, REAR SHEAR	11
⚠	-	2	1-240645-1	SPACER, SHEAR PLATE	10
⚠	-	1	240642-1	PLATE, FRONT SHEAR	9
⚠	1	2	1-1803059-5	ANVIL, COMBINATION, END FEED	8
⚠	-	1	240651-9	BLADE, SLUG	7
-	-	-	-	-	6
-	1	1	7-240641-4	SPACER	5
-	1	1	238011-3	BLOCK, CRIMPER SPACER	4
⚠	1	2	1-1633961-2	CRIMPER, INSULATION F PREMIUM	3
-	1	1	1-455888-6	SPACER, CRIMPER	2
⚠	1	2	2-456409-8	CRIMPER, WIRE .120 "F" PREMIUM	1
-	77	72	-2	PART NO	ITEM NO

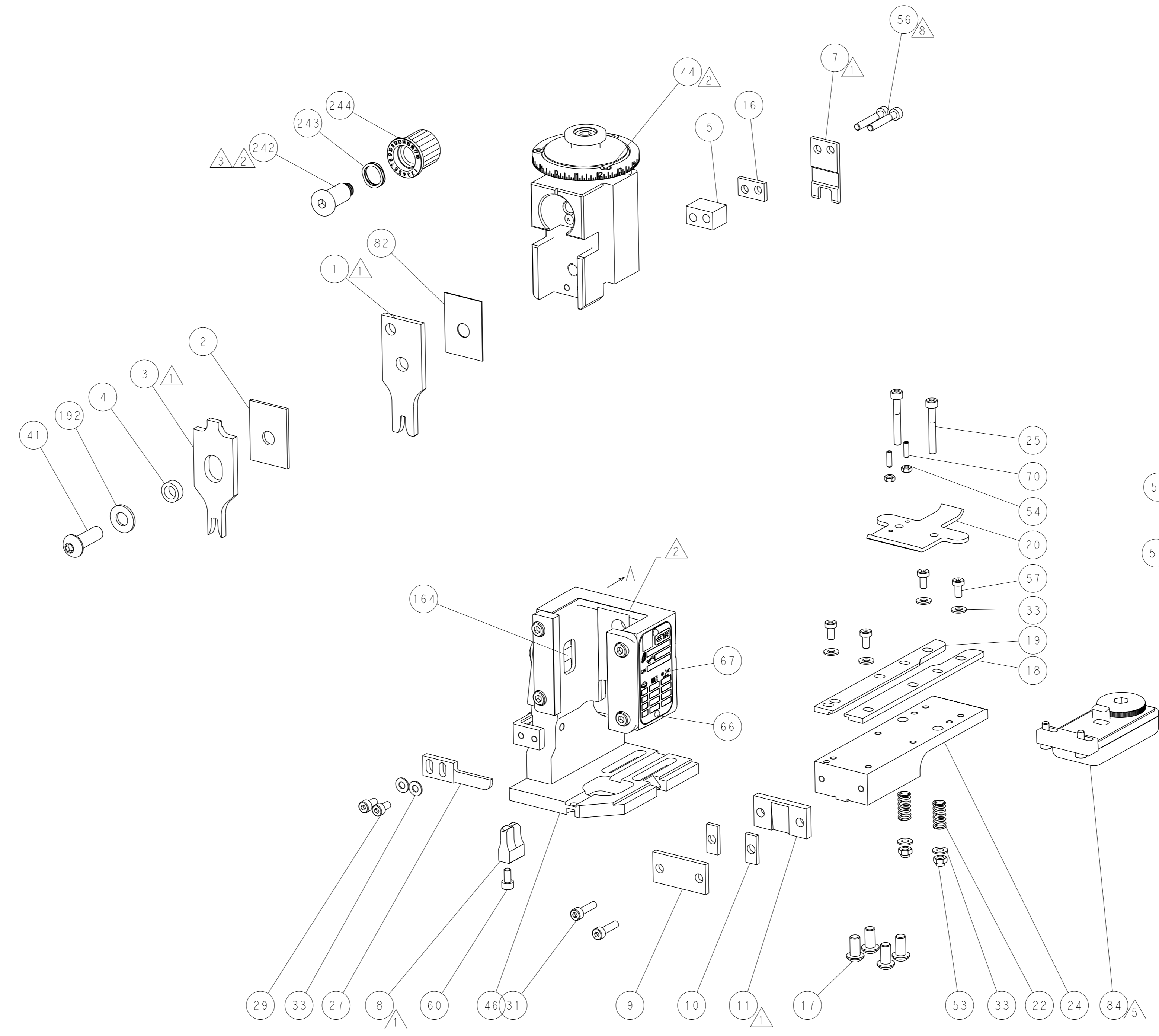
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG Y.YIN 02DEC2014		CHK G.BAILEY 02DEC2014		APVD U.GUO 02DEC2014		NAME		TE Connectivity Harrisburg, PA 17105-3608	
mm		0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ±		PRODUCT SPEC		APPLICATION SPEC		SIZE		CAGE CODE		DRAWING NO	
MATERIAL		FINISH		WEIGHT		A1		00779		©=2150515		RESTRICTED TO	
Customer Accessible Production Drawing										SCALE 1:1		SHEET 1 OF 4	

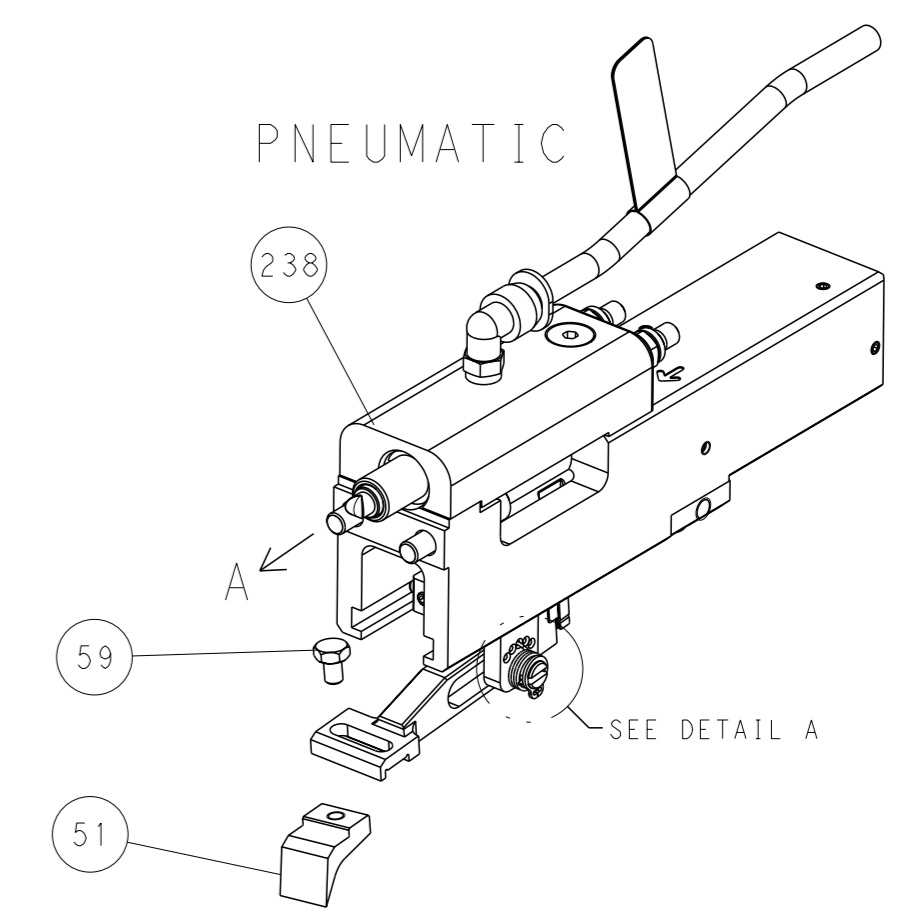
LOC		DIST		REVISIONS			
A	66	P	LYR	DESCRIPTION	DATE	OWN	APVD
		-		SEE SHEET 1			



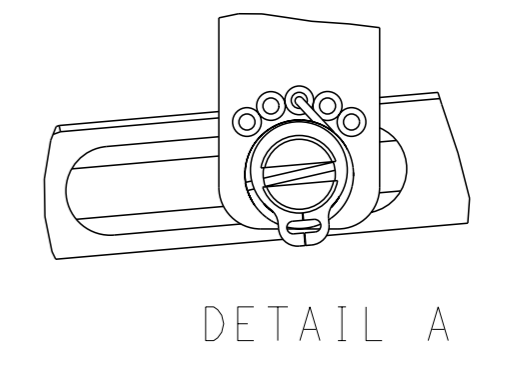
RAM SET-UP



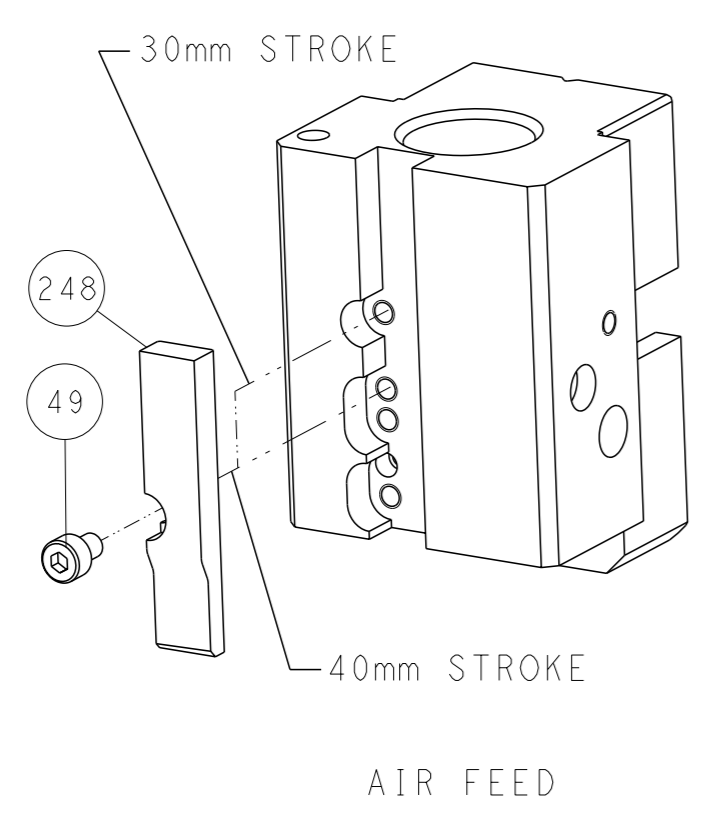
FEED TYPE



FEED SPRING SETTING POSITION



CAM POSITION

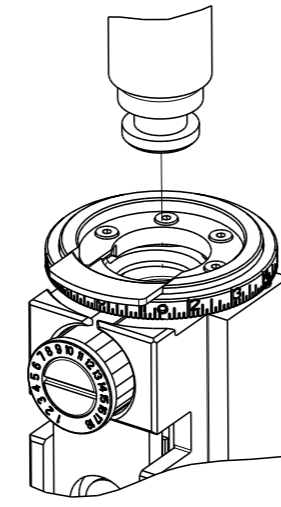


ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

<small>THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE AND TO CONTROLING ENGINEERING DISCRETION. SHOULD BE CONTACTED FOR THE LATEST REVISION.</small>		OWN: Y. YIN CHK: G. BAILEY APVD: H. GUO	02DEC2014 02DEC2014 02DEC2014	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=2150515 RESTRICTED TO:
MATERIAL:		WEIGHT:		SCALE: 1:1 SHEET: 2 of 4 REV: D

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150515-2	D	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150515-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	3.05 mm [.120]	F
INSUL	4.57 mm [.180]	F
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: RING TONGUE			
WIRE STRIP LENGTH 4.48-5.08 mm [.176-.200 IN]		INSULATION DIAMETER RANGE Ø2.29-3.68 mm [.090-.145 IN]	
TERMINAL APPLICATION SPECIFICATION 114-2084			
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
62787-1	61777-1	63602-1	62978-1
62787-2	62786-1	63602-2	

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
14 AWG	2.21+/-0.05 [.087+/-0.002]	7.1
2 x 18 AWG	2.08+/-0.05 [.082+/-0.002]	8.3
16 AWG	2.03+/-0.05 [.080+/-0.002]	8.7
18 AWG	1.91+/-0.05 [.075+/-0.002]	10.1

- 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.
- CUT TO LENGTH AT ASSEMBLY.

***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.

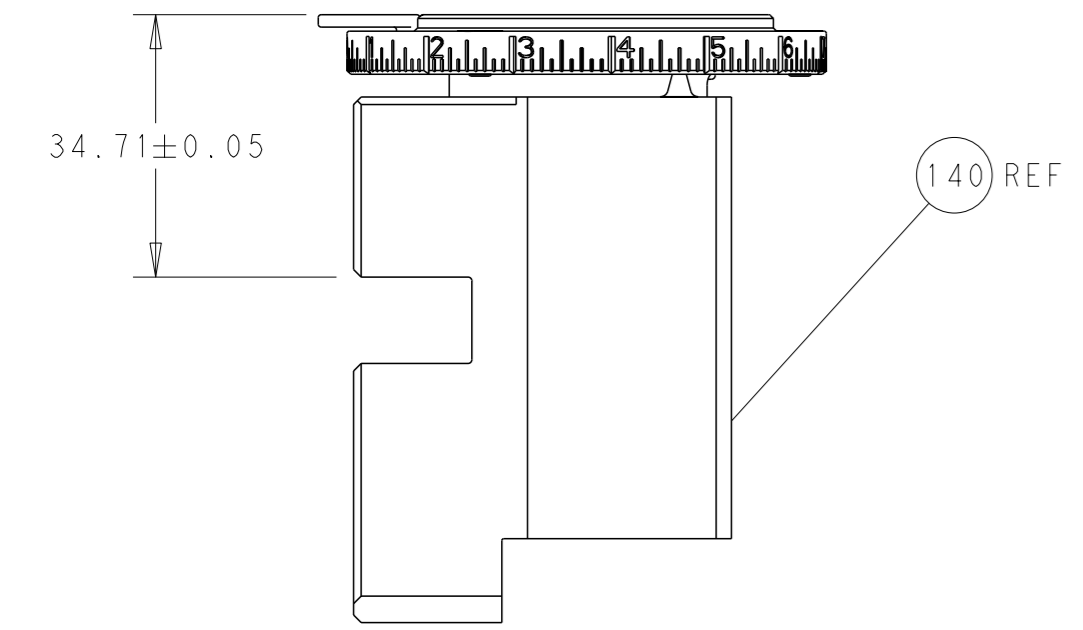
LOC	DIST	REVISIONS					
		P	LY#	DESCRIPTION	DATE	OWN	APVD
A	66	-	-	SEE SHEET 1	-	-	-

-	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	
-	-	2119653-2	FEED CAM, POST FEED	142	
-	1	1-2119655-2	APPLICATOR BASIC ASSEMBLY, EF	141	
-	1	1803518-1	RAM ASSEMBLY, EF PACIFIC	140	
5	-	1	2119955-2	ASSY, LUBRICATOR, END FEED	84
-	1	455888-5	SPACER, CRIMPER	82	
-	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	
-	-	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59	
-	4	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57	
8	-	2	1-2168083-2	SCR, SKT HD CAP, RoHS, M4 X 25	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	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	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	2-1901696-5	STRIP GUIDE, REAR	19	
-	1	2-1901695-5	STRIP GUIDE, FRONT	18	
-	1	240641-6	SPACER	16	
-	1	240644-1	PLATE, REAR SHEAR	11	
-	2	1-240645-1	SPACER, SHEAR PLATE	10	
-	1	240642-1	PLATE, FRONT SHEAR	9	
-	1	1-1803059-5	ANVIL, COMBINATION, END FEED	8	
-	1	240651-9	BLADE, SLUG	7	
-	-	-	-	6	
-	1	7-240641-4	SPACER	5	
-	1	238011-3	BLOCK, CRIMPER SPACER	4	
-	1	7-1633961-2	CRIMPER, INSULATION F PREMIUM	3	
-	1	1-455888-6	SPACER, CRIMPER	2	
-	1	2-456409-8	CRIMPER, WIRE .120 "F" PREMIUM	1	
-	77-22	PART NO	DESCRIPTION	ITEM NO	

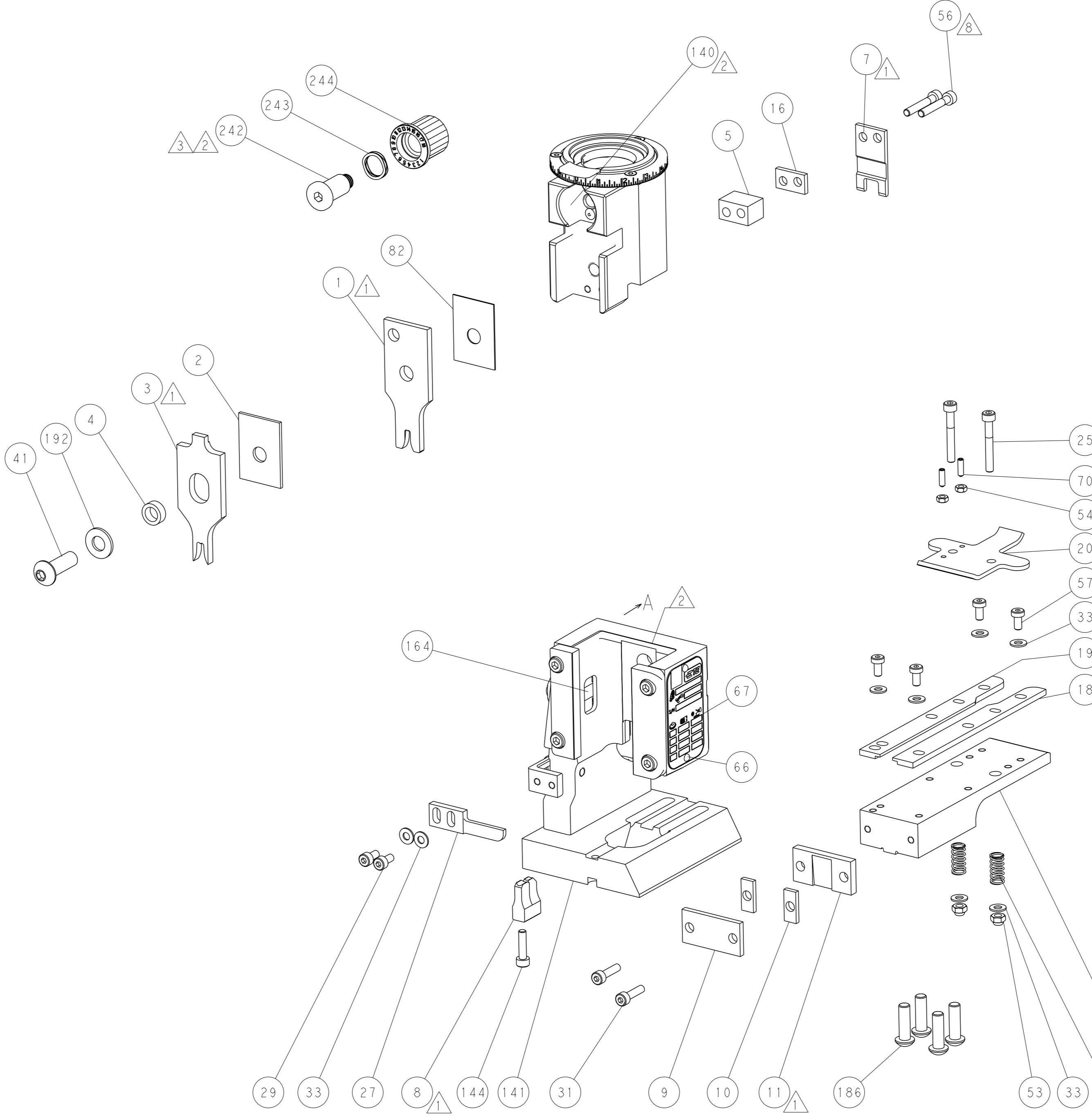
PACIFIC VERSION
Shown on sheets 3 of 4 & 4 of 4
(Atlantic version shown on sheets 1 of 4 & 2 of 4)

<small>THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE AND THE CUSTOMER MUST CONTACT THE SELLING ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST REVISION.</small>		DWN Y. YIN 02DEC2014 CHK G. BAILEY 02DEC2014 APVD U. GUO 02DEC2014	TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH ±		TOLERANCES UNLESS OTHERWISE SPECIFIED: ± ± ± ± ±	NAME Ocean End Feed Applicator SIZE CAGE CODE DRAWING NO A1 00779 C=2150515 RESTRICTED TO
MATERIAL:		WEIGHT:	SCALE 1:1 SHEET 1 OF 4 REV D Customer Accessible Production Drawing

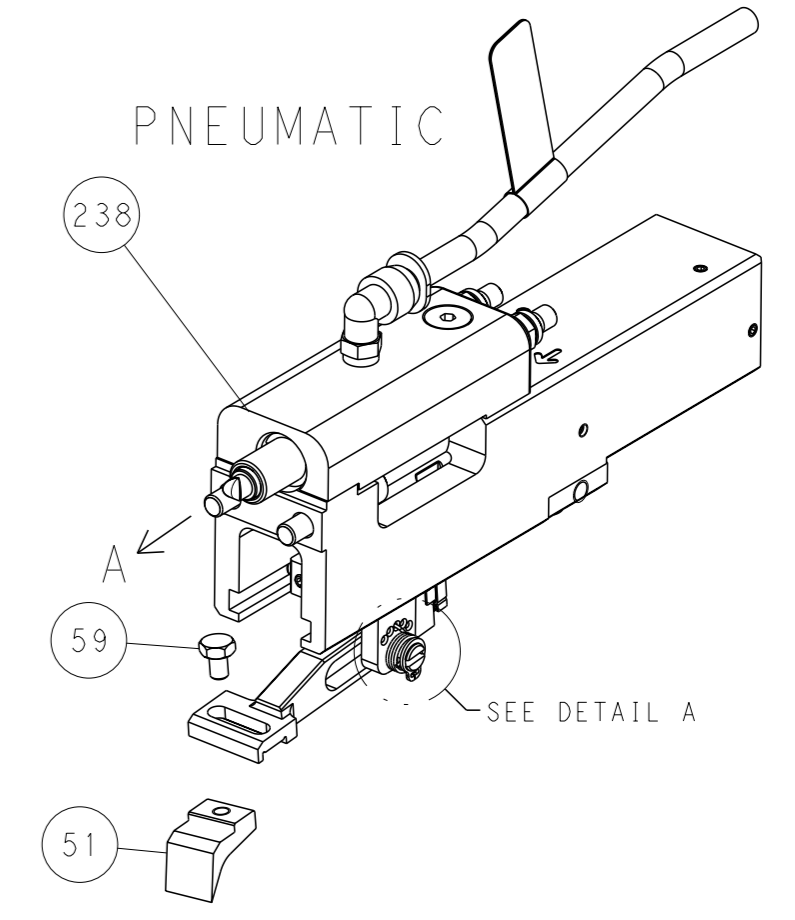
LOC		DIST		REVISIONS			
A	66	P	LYR	DESCRIPTION	DATE	OWN	APVD
		-		SEE SHEET 1			



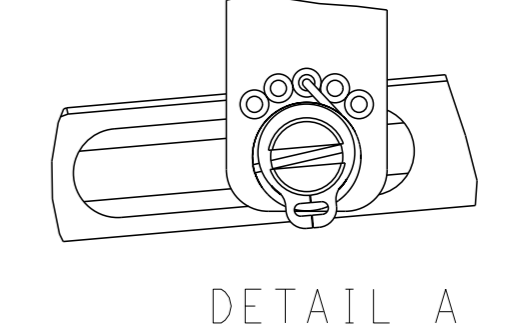
RAM SET-UP



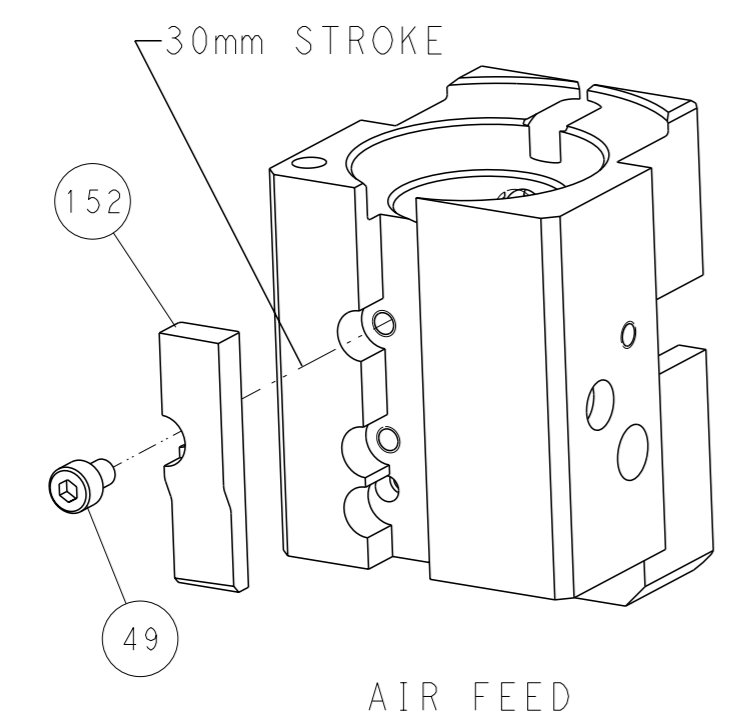
FEED TYPE



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 FOR TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE AND TO CONTROL AND RESTRICTING DISSEMINATION SHOULD BE CONTACTED FOR THE LATEST REVISION.</small>		OWN: Y. YIN CHK: G. BAILEY APVD: U. GUO	02DEC2014 02DEC2014 02DEC2014	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=2150515	RESTRICTED TO: - SCALE: 1:1 SHEET: 4 of 4 REV: D	
MATERIAL: - FINISH: -		WEIGHT: - APPLICATION SPEC: - PRODUCT SPEC: -	CUSTOMER ACCESSIBLE PRODUCTION DRAWING	