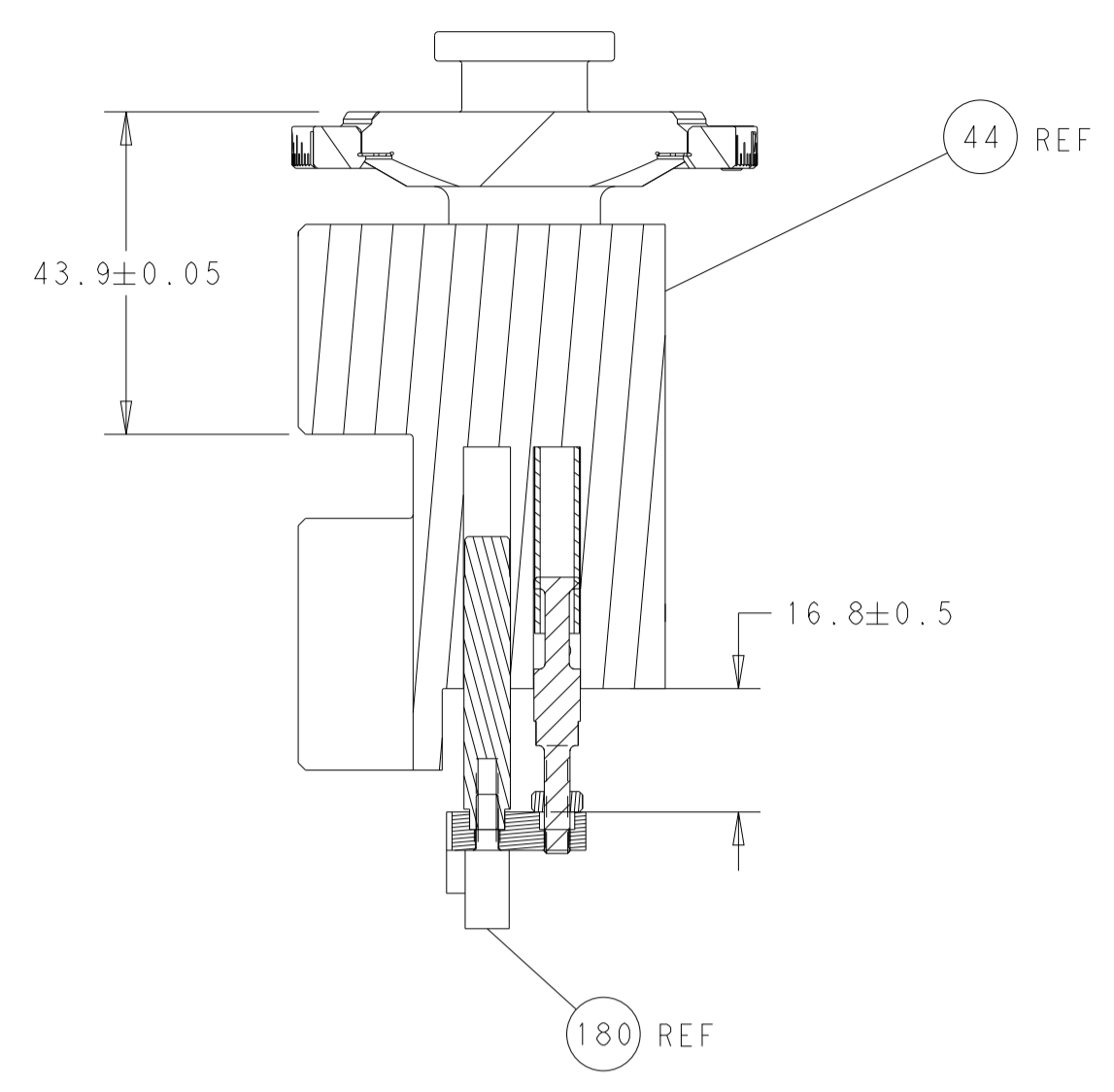
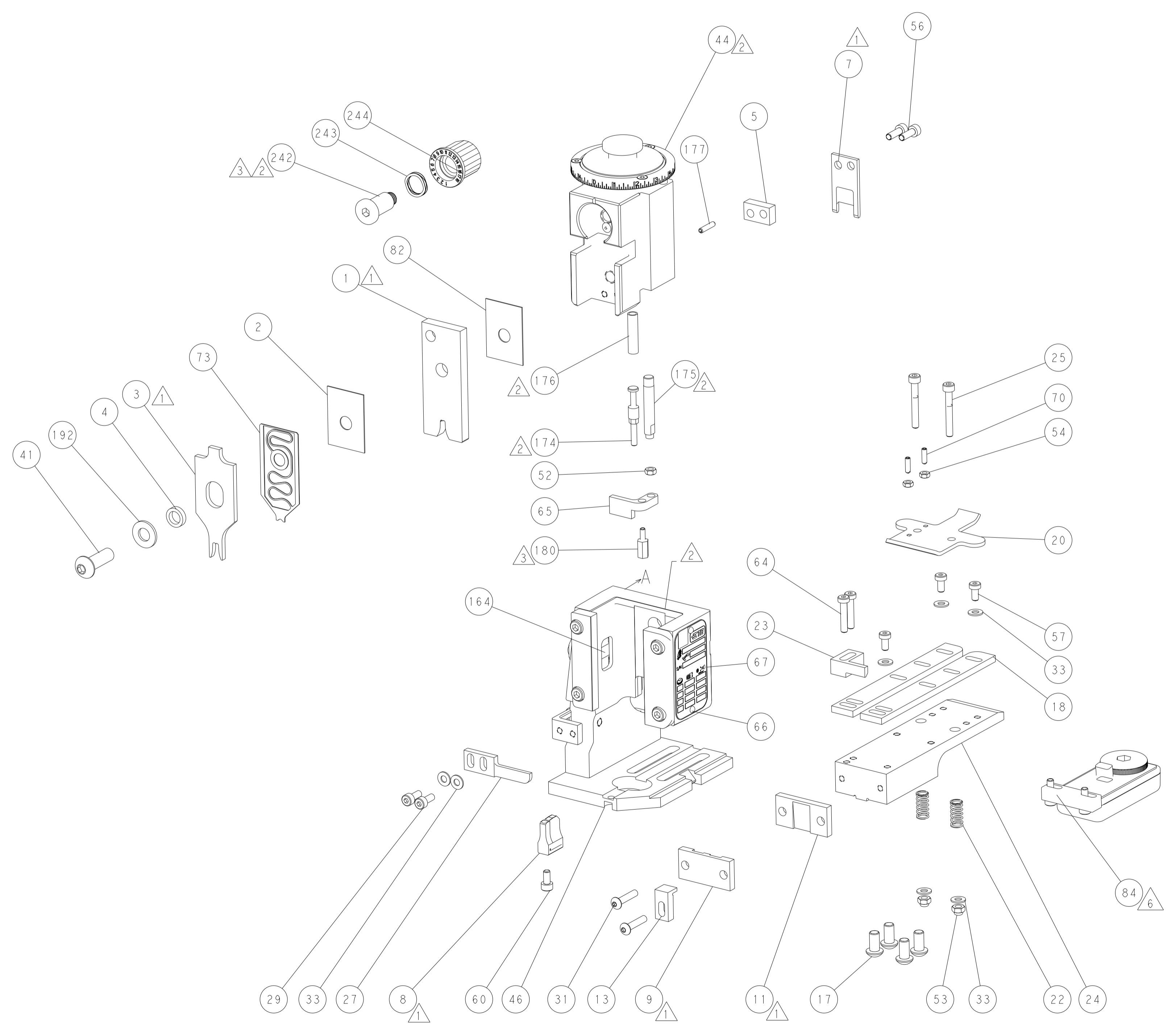




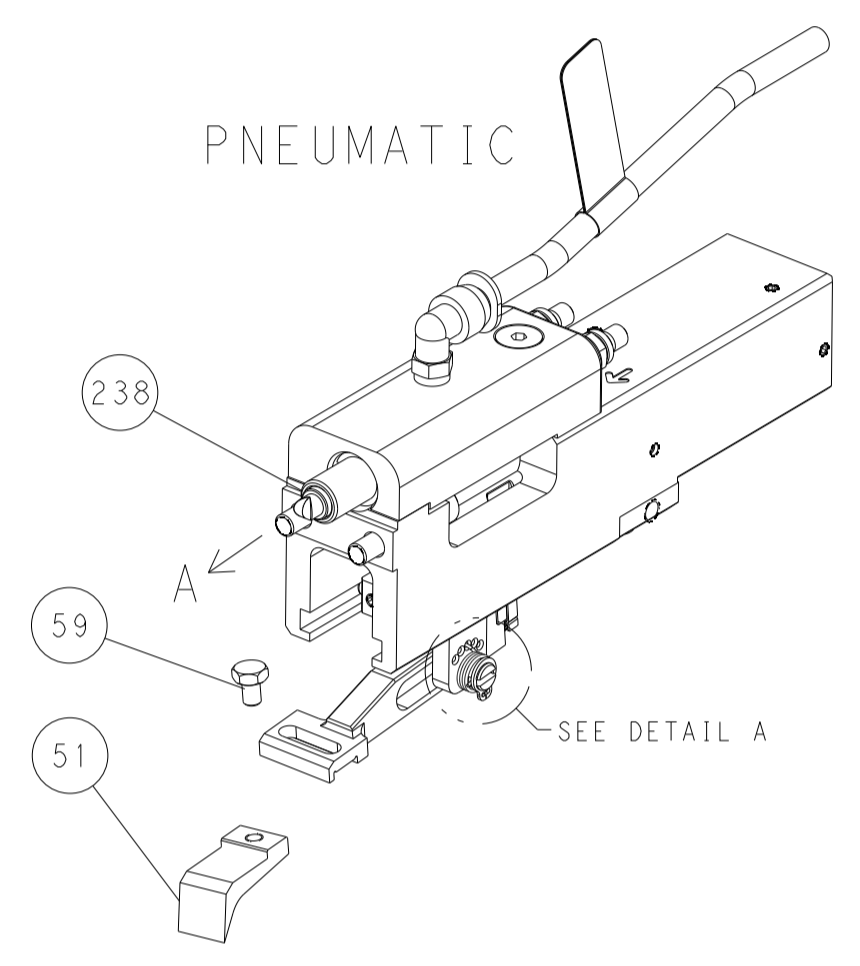
LOC	DIST	REVISIONS			
P	LTN	DESCRIPTION	DATE	OWN	APVD
A	66	SEE SHEET 1			



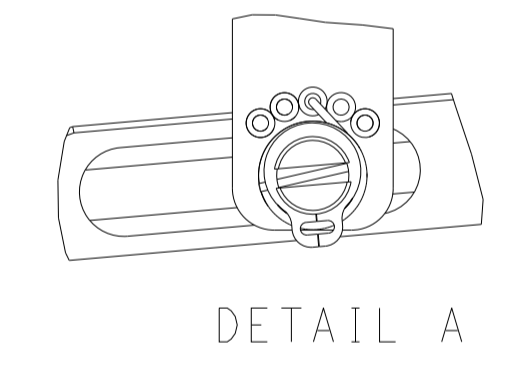
RAM AND HOLDDOWN SET-UP



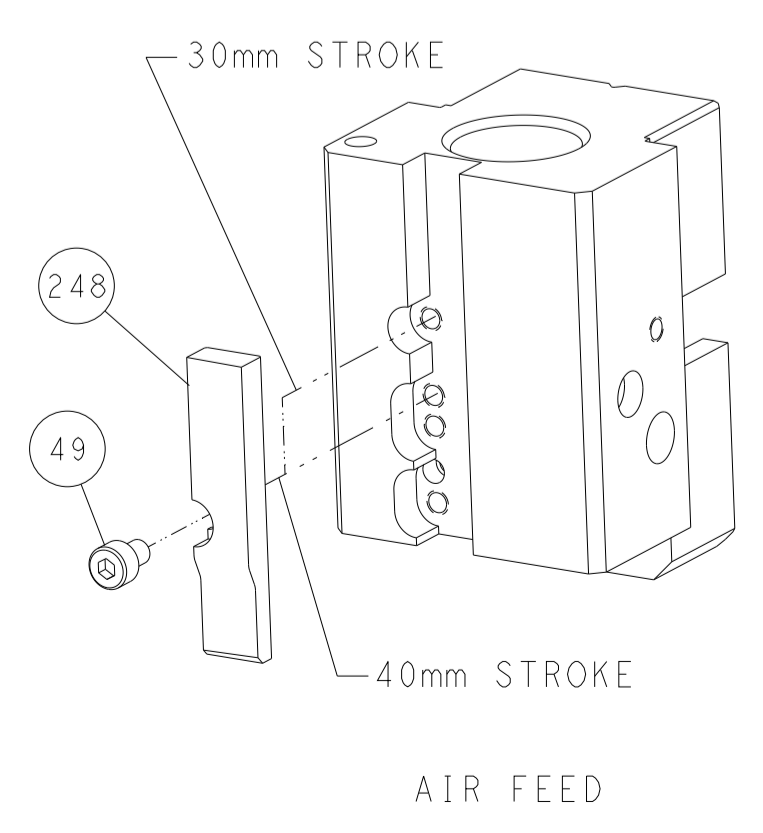
FEED TYPE



FEED SPRING SETTING POSITION



CAM POSITION

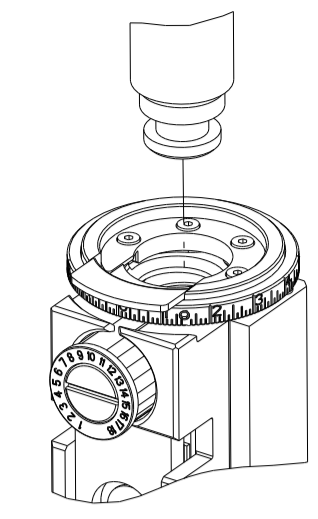


**ATLANTIC VERSION**  
 Shown on sheets 1 of 4 & 2 of 4  
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

<small>THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.</small>		DWN: K. STAKEM CHK: G. BAILEY APVD: T. ELBIN	DATE: 10APRIL2015 DATE: 10APRIL2015 DATE: 10APRIL2015	NAME: Ocean End Feed Applicator	SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2150544	RESTRICTED TO:
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± MATERIAL: - FINISH: -	TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± MATERIAL: - FINISH: -	WEIGHT: -	SCALE: 1:1	SHEET: 2 OF 4	REV: E	CUSTOMER ACCESSIBLE PRODUCTION DRAWING

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150544-2	E	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150544-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR  
 INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	3.56 mm [ .140 ]	F
INSUL	4.32 mm [ .170 ]	F
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL				TE CRIMP SPECIFICATION			
TERMINAL NAME: RECEPTACLE, CLUSTER PIN, AMPLIVAR							
WIRE STRIP LENGTH				INSULATION DIAMETER RANGE			
3.58-4.34 mm [ .141-.171 IN ]				Ø 2.29-4.32 mm [ .090-.170 IN ]			
TERMINAL APPLICATION SPECIFICATION				114-2019			
TERMINALS APPLIED							
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
63455-1							

TERMINAL DATA: TE TERMINAL				TE CRIMP SPECIFICATION			
TERMINAL NAME: RECEPTACLE, CLUSTER PIN, AMPLIVAR							
WIRE STRIP LENGTH				INSULATION DIAMETER RANGE			
3.58-4.34 mm [ .141-.171 IN ]				Ø 3.81 mm [ .150 IN ] MAX			
TERMINAL APPLICATION SPECIFICATION				114-2019			
TERMINALS APPLIED							
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
1217173-1	1217173-3						

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
7600-8500 CMA	2.36 +/- 0.05 [ .093 +/- .002 ]	5.6
4000-4800 CMA	1.98 +/- 0.05 [ .078 +/- .002 ]	9.3



- 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 ITEMS 180. 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 PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- 6 TERMINAL LUBRICANT IS RECOMMENDED.
- 7. 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)

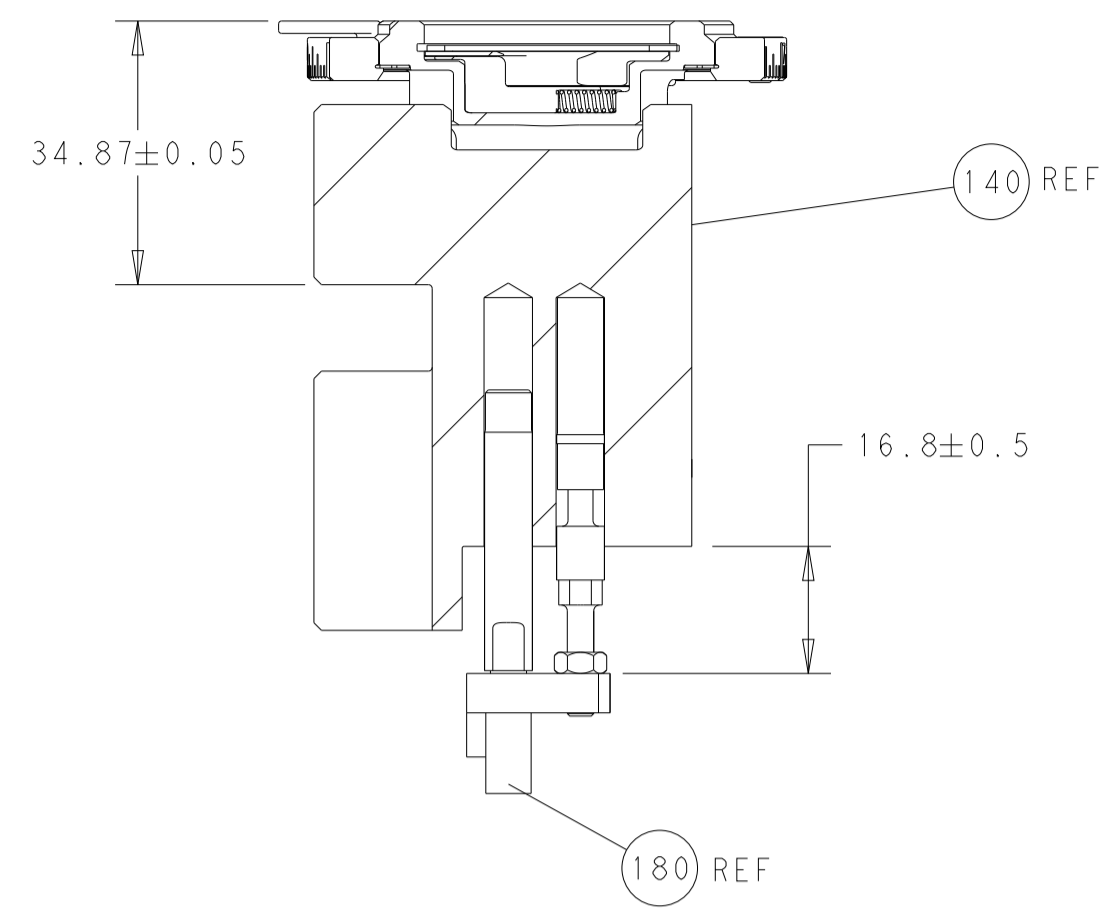
LOC	DIST	REVISIONS					
A	66	P	LTN	DESCRIPTION	DATE	DWN	APVD
		-		SEE SHEET 1	-	-	-

-	1	2119082-4	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
-	1	1-18028-0	WASHER, FLAT, REG M8	192
-	4	2079383-9	SCR, BHSC, RoHS (M6 X 20)	186
-	1	2-1752354-7	STANDOFF, HOLD-DOWN	180
-	1	6-993111-6	PIN, SLOTTED SPRING 3.0 X 14.0	177
-	1	8-22280-7	SPRING, COMPRESSION	176
-	1	1752353-2	GUIDE PIN, HOLDDOWN	175
-	1	1901680-2	GUIDE PIN, HOLDDOWN	174
-	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	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	1901681-1	HOLDDOWN, TERMINAL	65
-	2	2168400-5	SHCS, LOW HEAD, RoHS, M4 X 20	64
-	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	3	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57
-	2	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	56
-	2	5018030-1	NUT, HEX, REG, RoHS, M3	54
-	2	986965-8	NUT, LOCK, HEX, TORQUE (M4)	53
-	1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52
-	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
-	7	1-18028-2	WASHER, FLAT, REG M4	33
-	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	31
-	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	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
-	1	240825-1	PLATE, STRIP HOLD DOWN	23
-	2	2-22281-3	SPRING, COMPRESSION	22
-	1	1803292-4	DRAG	20
-	2	1901259-7	GUIDE, LOWER STRIP	18
-	1	1752360-1	SPACER, HOLD-DOWN	13
-	1	240644-1	PLATE, REAR SHEAR	11
-	1	690482-5	PLATE, FRONT SHEAR	9
1	1	1803064-8	ANVIL, COMBINATION	8
-	1	4-690474-2	BLADE, SLUG	7
-	1	8-240641-8	SPACER	5
-	1	238011-2	BLOCK, CRIMPER SPACER	4
1	1	7-1633961-5	CRIMPER, INSULATION F PREMIUM	3
-	1	455888-5	SPACER, CRIMPER	2
1	1	462808-7	CRIMPER, BLUNT F	1
-	77-22	PART NO	DESCRIPTION	ITEM NO

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		MATERIAL:	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±
	ANGLES ±	FINISH			

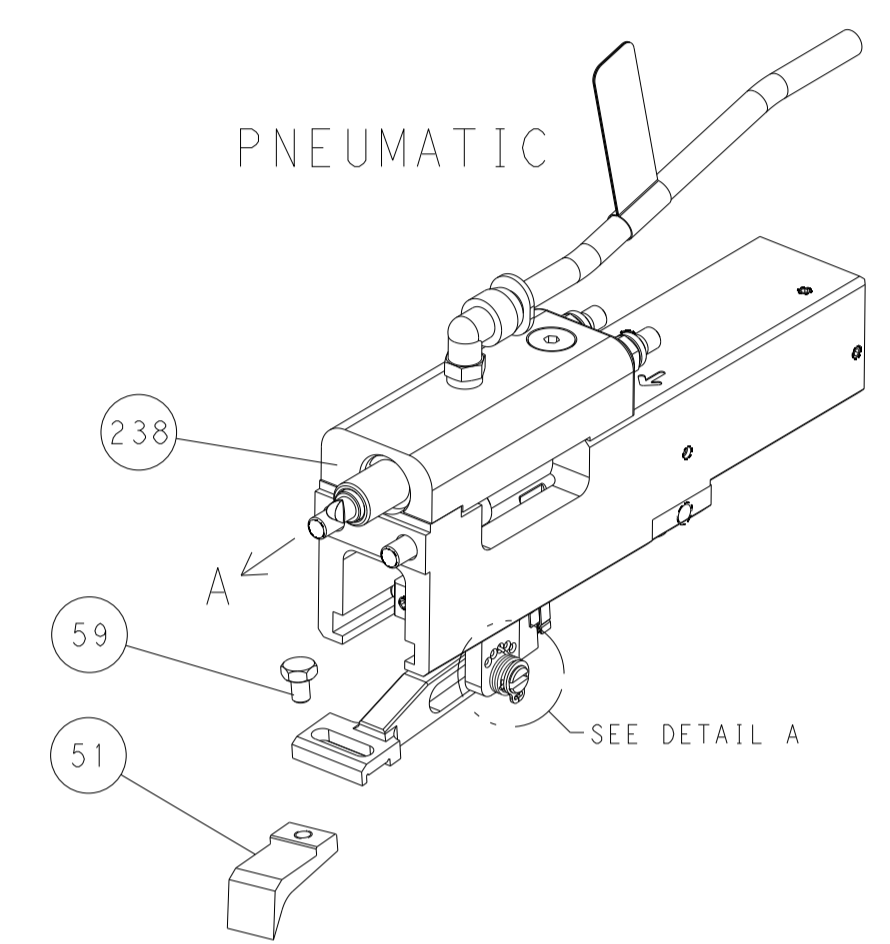
CHK	APRIL 2015	STAKEM
CHK	APRIL 2015	G. BAILEY
APVD	APRIL 2015	T. ELBIN
NAME		
PRODUCT SPEC		
APPLICATION SPEC		
SIZE	CAGE CODE	DRAWING NO
A1	00779	2150544
Customer Accessible Production Drawing		
SCALE	1:1	SHEET 3 OF 4
REV	E	

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

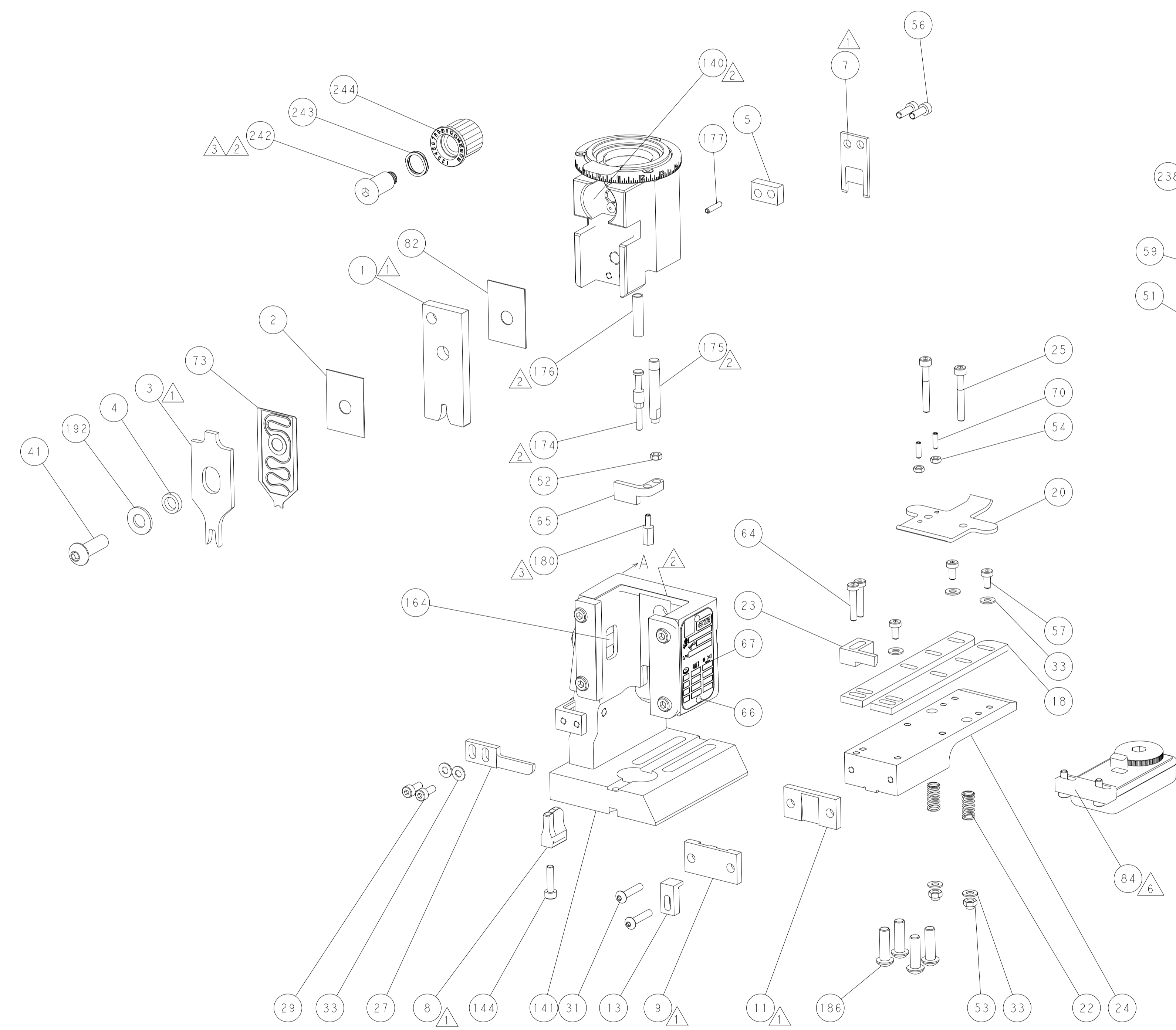
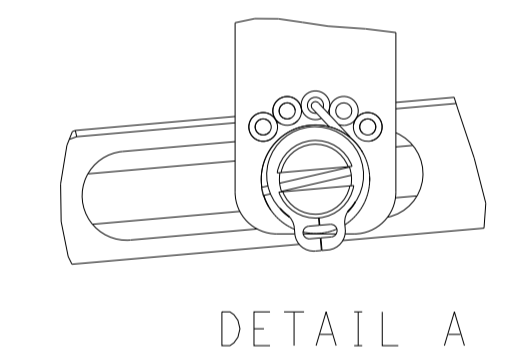


RAM AND HOLDDOWN SET-UP

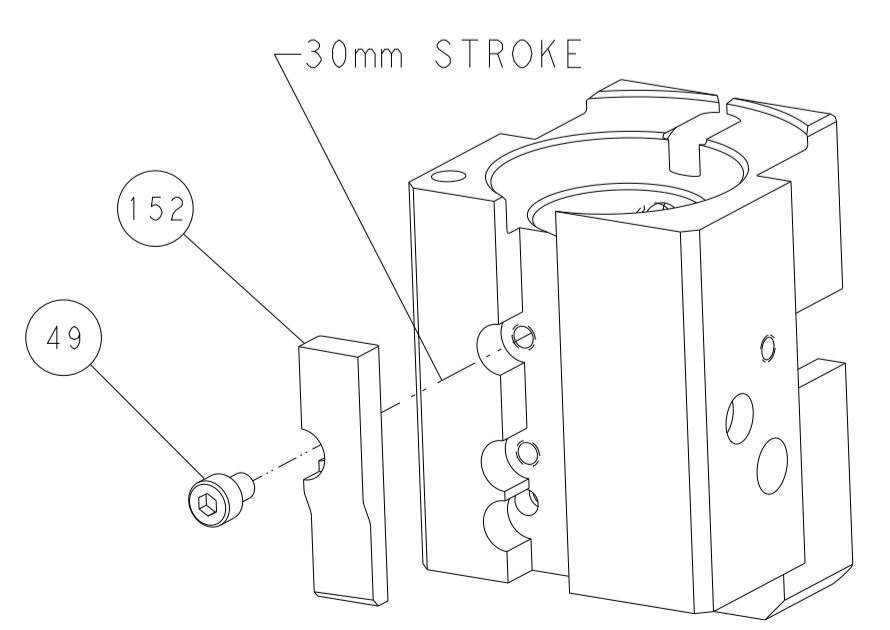
FEED TYPE



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)

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DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± MATERIAL:	TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± MATERIAL:	WEIGHT:	SCALE: 1:1	SHEET: 4 OF 4	REV: E	CUSTOMER ACCESSIBLE PRODUCTION DRAWING