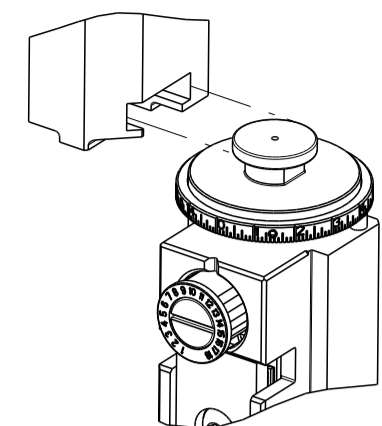


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150403-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150403-2	B	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150403-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.29 mm [.090]	F
INSUL	3.05 mm [.120]	F

APPLICATOR INSTRUCTIONS 408-35043

TERMINAL DATA: STOCKO/LNX TERMINAL TE CRIMP SPECIFICATION			
TERMINAL NAME: TERMINAL, TAB 6.3			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
5.80-6.60 mm [.228-.260 IN]		∅1.52-2.54 mm [.060-.100 IN]	
TERMINAL APPLICATION SPECIFICATION	NONE	-	-
TERMINALS APPLIED			
TE TERMINAL	STOCKO/LNX TERMINAL	TE TERMINAL	STOCKO/LNX TERMINAL
1572348-1	7831.010.76.3-1		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.50mm2	1.75+/-0.03 [.069+/- .001]	5.4
1.00mm2	1.55+/-0.03 [.061+/- .001]	7.5
0.75mm2	1.45+/-0.03 [.057+/- .001]	8.7
0.50mm2	1.37+/-0.03 [.054+/- .001]	9.4



- 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. APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 180.
- 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.
- 6. 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.

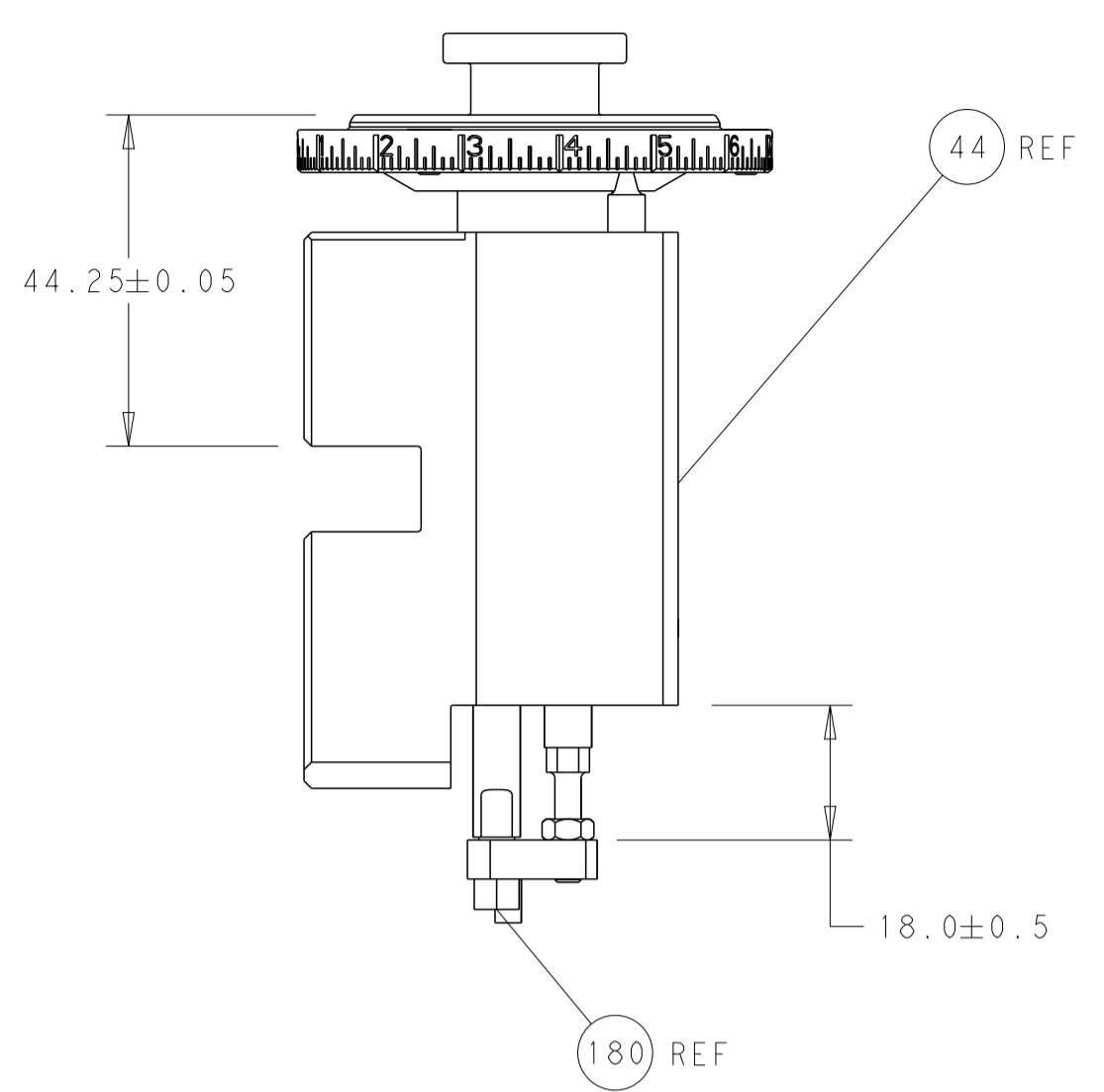
LOC	DIST	REVISIONS					
		P	LTN	DESCRIPTION	DATE	OWN	APVD
A	66	A		RELEASED	17JAN2014	KH	UG
		B		ECR-21-000502	16JAN2021	TB	RK

-	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	2119083-1	RETAINER, INSULATION DIAL	242	
-	1	1	2844940-4	AIR FEED MODULE	238	
-	1	1	1-18028-0	WASHER, FLAT, REG M8	192	
	-	1	1752354-1	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	
-	REFREF		994970-2	COUNTER, MAGNETIC	164	
-	1	1	455888-4	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	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	1976052-1	HOLDDOWN, TERMINAL	65	
-	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	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	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	
-	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	1-1752371-2	PLATE, STRIP GUIDE	24	
-	2	2	2-22281-3	SPRING, COMPRESSION	22	
-	1	1	1803292-4	DRAG	20	
-	1	1	1-1901696-8	STRIP GUIDE, REAR	19	
-	1	1	1-1901695-8	STRIP GUIDE, FRONT	18	
-	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17	
-	1	1	4-240641-7	SPACER	16	
-	1	1	1752360-1	SPACER, HOLD-DOWN	13	
	-	1	240644-5	PLATE, REAR SHEAR	11	
-	-	-	-	-	10	
	-	1	1	3-690482-2	PLATE, FRONT SHEAR	9
	1	2	1	3-1333217-2	ANVIL, EF .090	8
	-	1	1	1-2217206-0	BLADE, SLUG	7
-	-	-	-	-	6	
-	1	1	1-240641-8	SPACER	5	
-	1	1	238011-2	BLOCK, CRIMPER SPACER	4	
	1	2	1	1-1633961-9	CRIMPER, INSULATION F PREMIUM	3
-	2	2	455888-3	SPACER, CRIMPER	2	
	1	2	1	5-456406-7	CRIMPER, WIRE PREMIUM	1
-	77	72	-2	PART NO	DESCRIPTION	ITEM NO

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

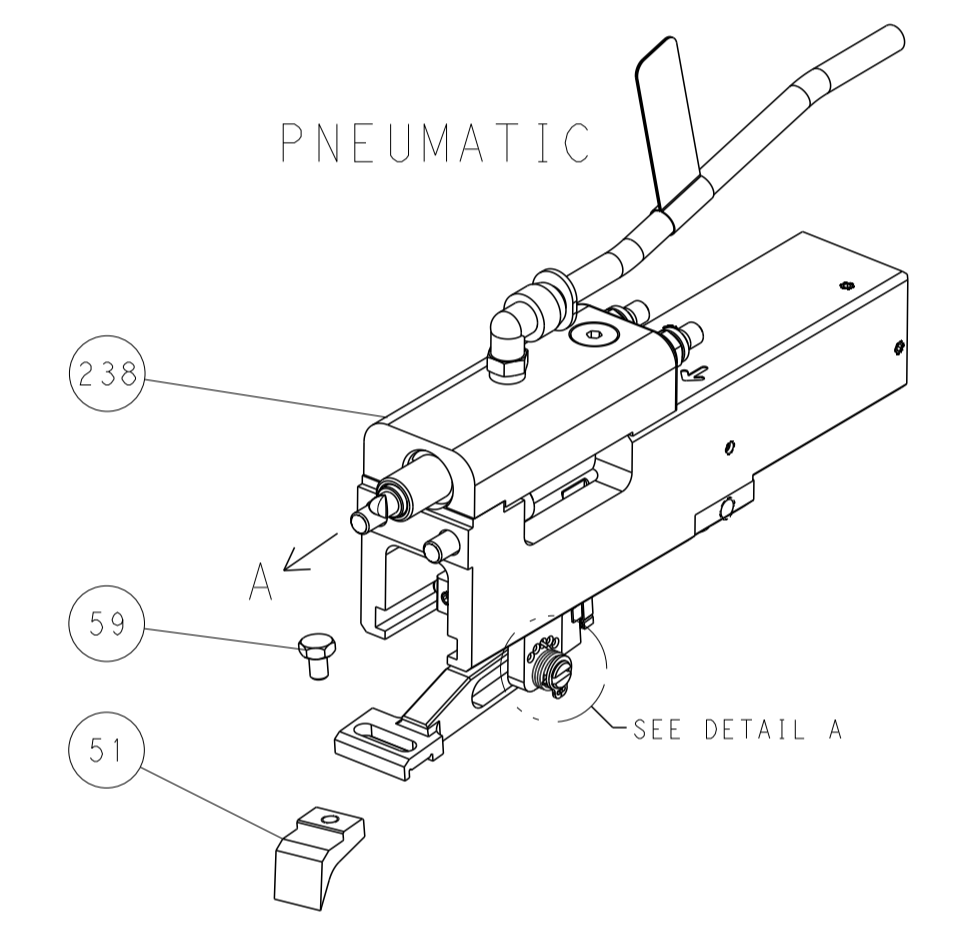
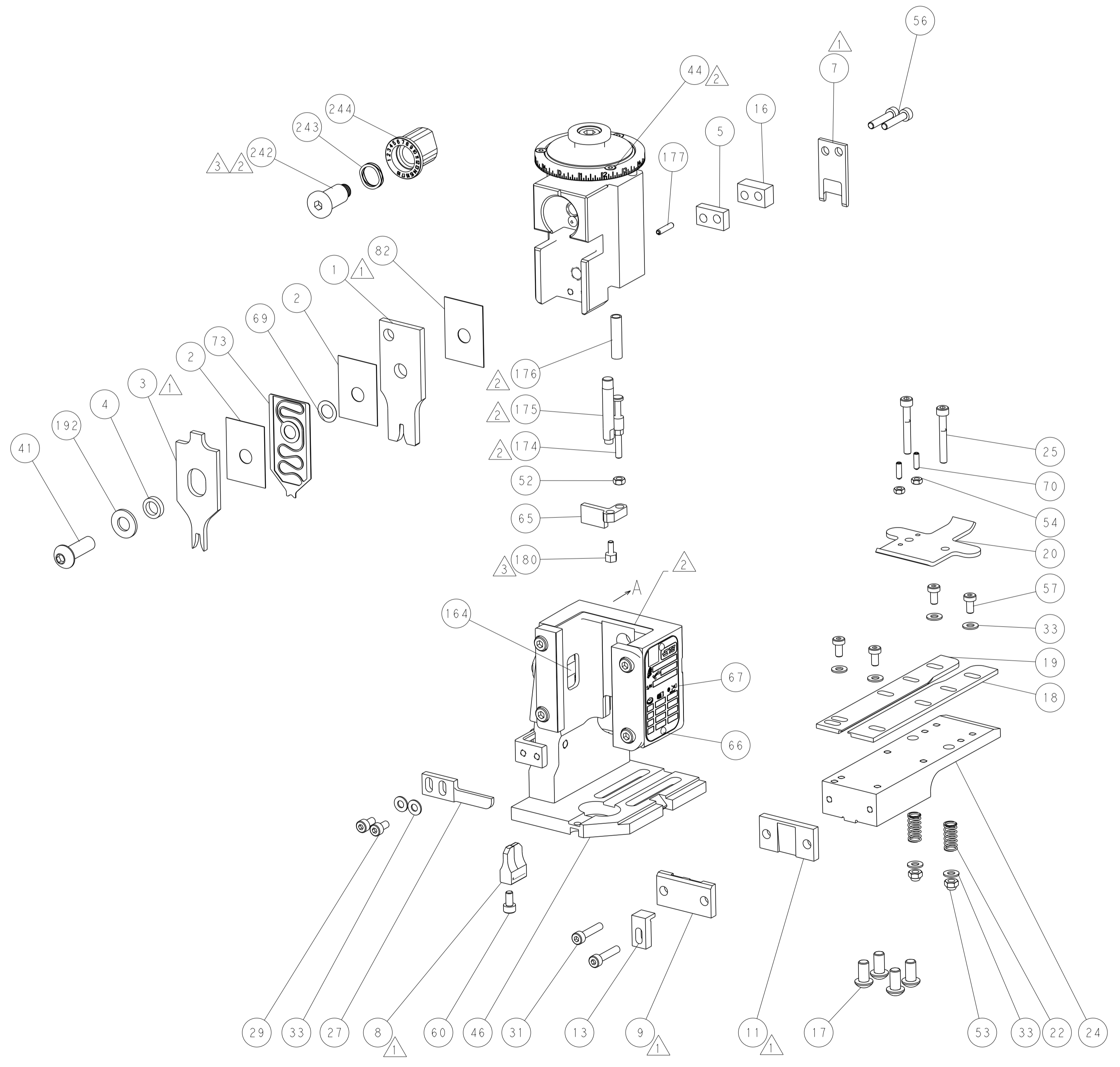
<small>THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION. COPYRIGHT 20 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.</small>		DWN: H. HUANG 11DEC2013 CHK: L. ZHANG 11DEC2013 APVD: J. GUO 11DEC2013	TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH ±	NAME: Ocean End Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2150403 RESTRICTED TO: -
MATERIAL: -		WEIGHT: -	SCALE: 1:1 SHEET: 1 of 4 REV: B

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

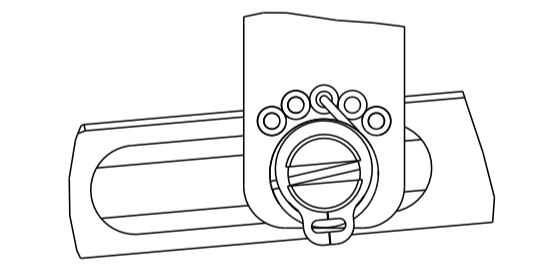


RAM AND HOLDDOWN SET-UP

FEED TYPE

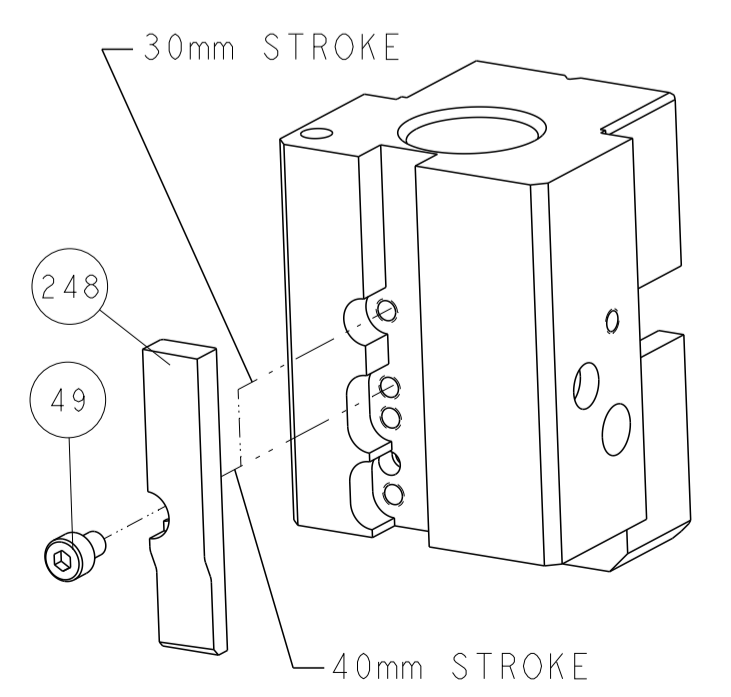


FEED SPRING SETTING POSITION



DETAIL A

CAM POSITION



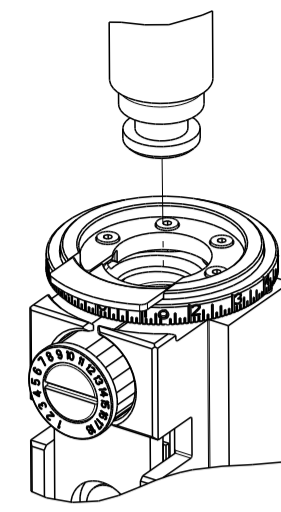
AIR FEED

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

DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH		DWN K. HUANG 11DEC2013 CHK L. ZHANG 11DEC2013 APVD J. GUO 11DEC2013 NAME PRODUCT SPEC APPLICATION SPEC WEIGHT Customer Accessible Production Drawing		NAME Ocean End Feed Applicator SIZE CAGE CODE DRAWING NO A1 00779 C=2150403 SCALE 1:1 SHEET 2 OF 4 REV B		RESTRICTED TO - SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150403-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150403-7	A	CRIMP TOOLING KIT	-

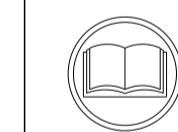
PACIFIC VERSION TERMINATOR  
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.29 mm (.090)	F
INSUL	3.05 mm (.120)	F
APPLICATOR INSTRUCTIONS 408-35043		

TERMINAL DATA: STOCKO/LNX TERMINAL TE CRIMP SPECIFICATION			
TERMINAL NAME: TERMINAL, TAB 6.3			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
5.80-6.60 mm (.228-.260 IN)		1.52-2.54 mm (.060-.100 IN)	
TERMINAL APPLICATION SPECIFICATION	NONE	-	-
TERMINALS APPLIED			
TE TERMINAL	STOCKO/LNX TERMINAL	TE TERMINAL	STOCKO/LNX TERMINAL
1572348-1	7831.010.Z6.3-1		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.50mm2	1.75+/-0.03 [.069+/-0.001]	5.4
1.00mm2	1.55+/-0.03 [.061+/-0.001]	7.5
0.75mm2	1.45+/-0.03 [.057+/-0.001]	8.7
0.50mm2	1.37+/-0.03 [.054+/-0.001]	9.4



- 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. APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 180.
  - 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.
6. 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.

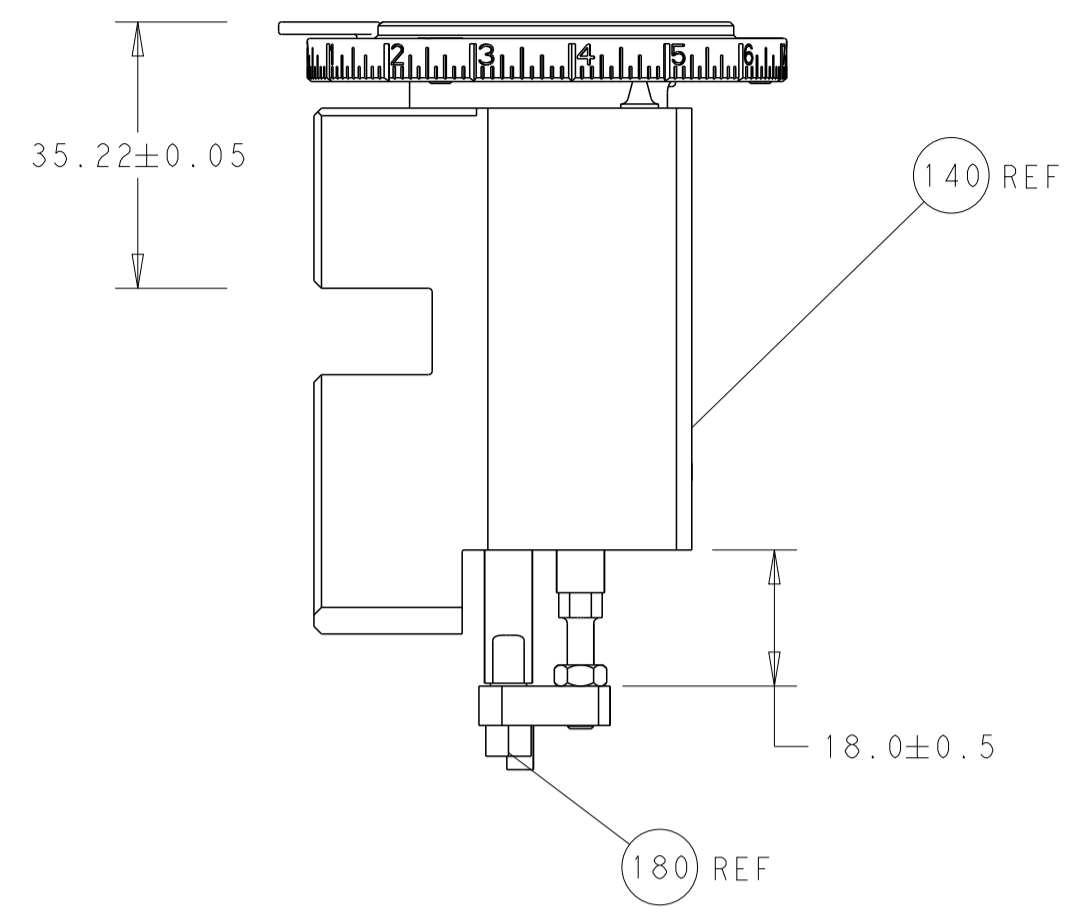
PACIFIC VERSION  
Shown on sheets 3 of 4 & 4 of 4  
(Atlantic version shown on sheets 1 of 4 & 2 of 4)

LOC	DIST	REVISIONS					
A	66	P	LTN	DESCRIPTION	DATE	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	
-	1	1-18028-0	WASHER, FLAT, REG M8	192	
-	4	2079383-9	SCR, BHSC, RoHS (M6 X 20)	186	
	-	1	1752354-1	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	455888-4	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	2119943-1	WASHER, SPACER	69	
-	1	2119740-1	TAG, IDENTIFICATION	67	
-	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66	
-	1	1976052-1	HOLDDOWN, TERMINAL	65	
-	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59	
-	-	2063961-1	FEED FINGER	58	
-	4	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57	
-	2	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	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	2063961-1	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	1-1752371-2	PLATE, STRIP GUIDE	24	
-	2	2-22281-3	SPRING, COMPRESSION	22	
-	1	1803292-4	DRAG	20	
-	1	1-1901696-8	STRIP GUIDE, REAR	19	
-	1	1-1901695-8	STRIP GUIDE, FRONT	18	
-	1	4-240641-7	SPACER	16	
-	1	1752360-1	SPACER, HOLD-DOWN	13	
	-	1	240644-5	PLATE, REAR SHEAR	11
-	-	-	-	10	
	-	1	3-690482-2	PLATE, FRONT SHEAR	9
	1	1	3-1333217-2	ANVIL, EF .090	8
	-	1	1-2217206-0	BLADE, SLUG	7
-	-	-	-	6	
-	1	1	1-240641-8	SPACER	5
-	1	1	238011-2	BLOCK, CRIMPER SPACER	4
	1	1	1-1633961-9	CRIMPER, INSULATION F PREMIUM	3
-	2	2	455888-3	SPACER, CRIMPER	2
	1	1	5-456406-7	CRIMPER, WIRE PREMIUM	1

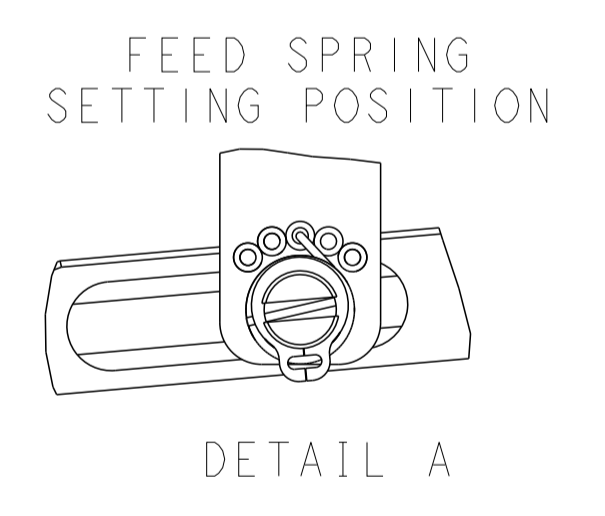
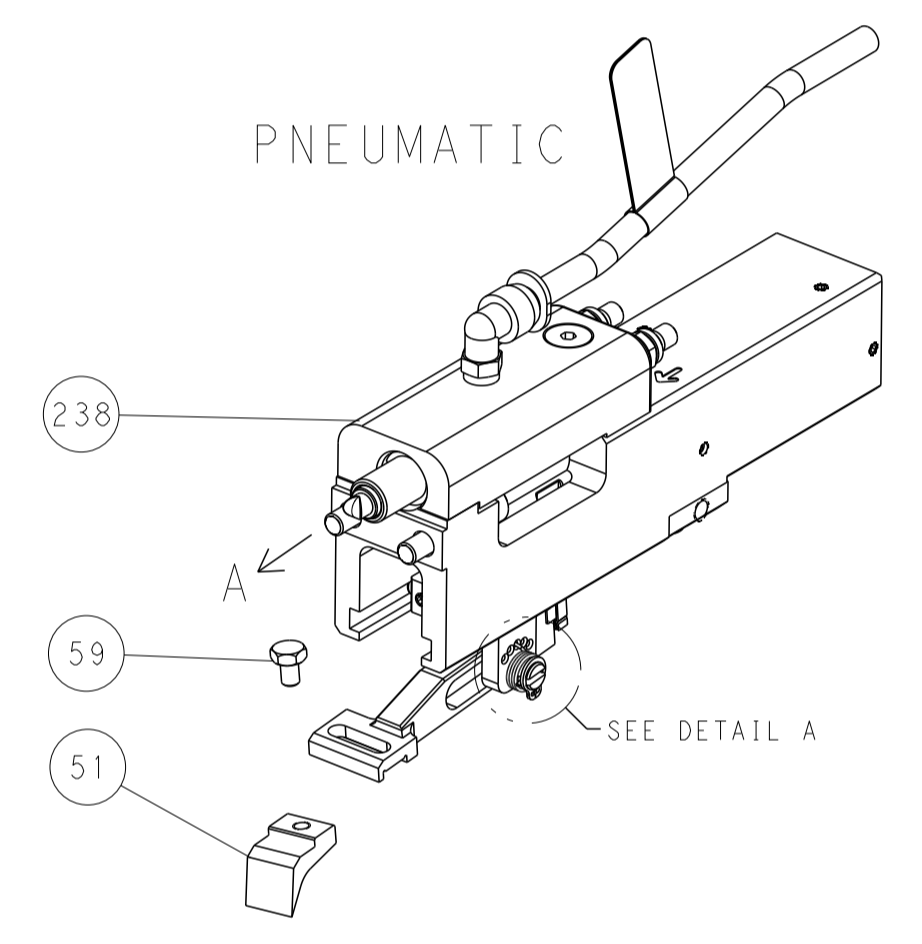
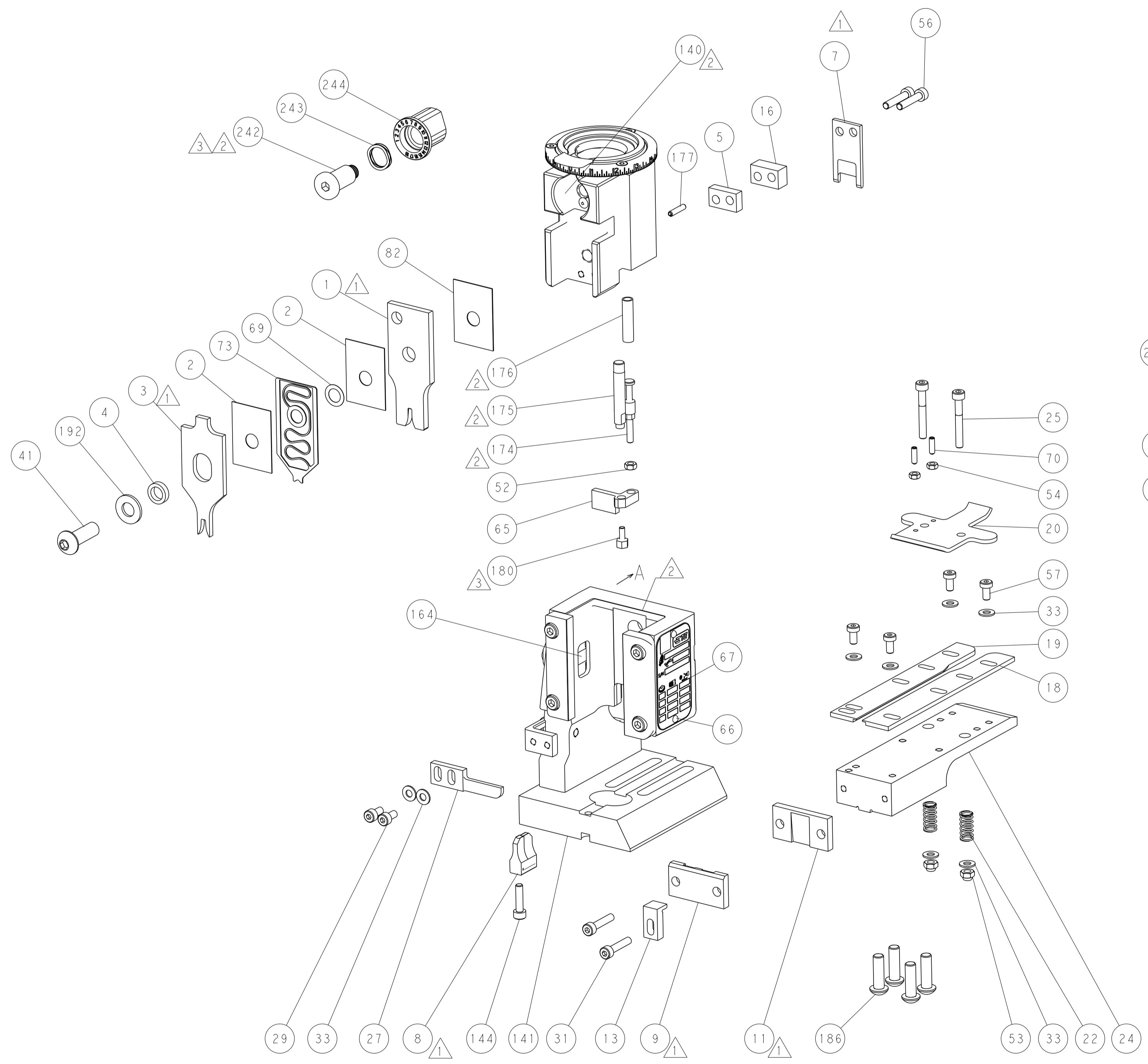
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DIMENSIONS: mm 	TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH	PRODUCT SPEC APPLICATION SPEC SIZE CAGE CODE DRAWING NO RESTRICTED TO	Ocean End Feed Applicator SCALE 1:1 SHEET 3 OF 4 REV B
MATERIAL	WEIGHT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

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

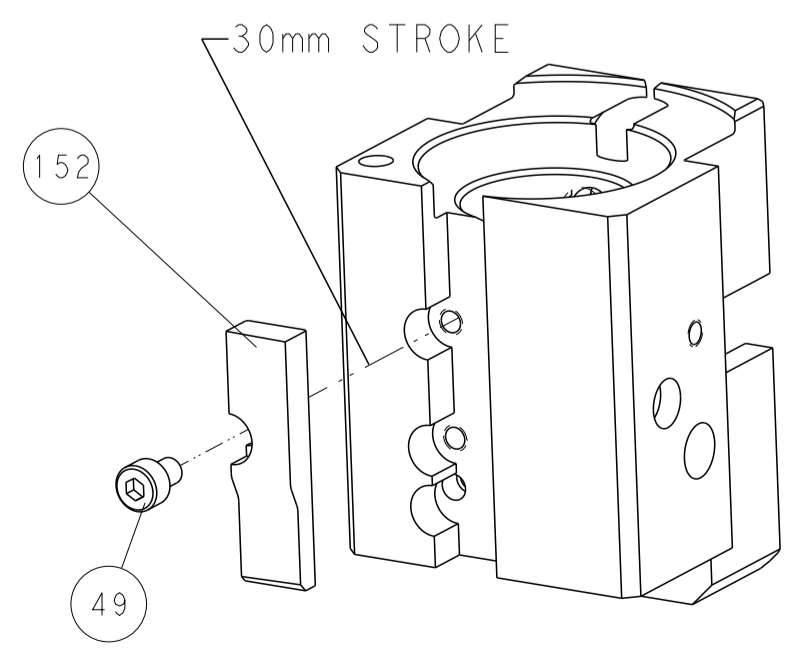


RAM AND HOLDDOWN SET-UP

FEED TYPE



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 ± FINISH		NAME: Ocean End Feed Applier PRODUCT SPEC: APPLICATION SPEC: WEIGHT:	SIZE: A1 CAGE CODE: 00779 DRAWING NO: C-2150403 RESTRICTED TO: B
MATERIAL:		SCALE: 1:1 SHEET: 4 OF 4 REV: B	Customer Accessible Production Drawing