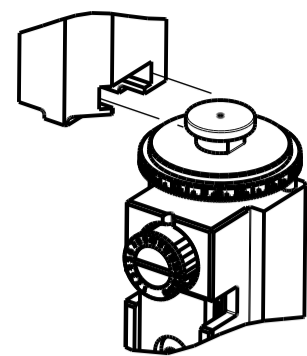


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150223-2	F	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150223-2	F	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150223-7	F	CRIMP TOOLING KIT	-

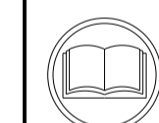
ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	4.57 mm [.180]	F
INSUL	6.35 mm [.250]	F
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: RING TONGUE			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
5.70-6.50 mm [.224-.256 IN]		∅4.00-5.30 mm [1.57-.209 IN]	
TERMINAL APPLICATION SPECIFICATION	114-18022	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
928911-1	928911-2		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
6.00mm2	3.48 +/- 0.05 [.137 +/- .002]	4.7
4.00mm2	3.16 +/- 0.05 [.124 +/- .002]	8.3



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

LOC	DIST	REV	LTN	DESCRIPTION	DATE	OWN	APPV
A	66	E		ECR-19-008970	12JUN2019	LG	TE
		E1		ECR-19-012199	02AUG2019	FJ	TE
		E2		ECR-19-013984	06SEP2019	FJ	TE
		F		ECR-20-012131	27AUG2020	FZ	RK

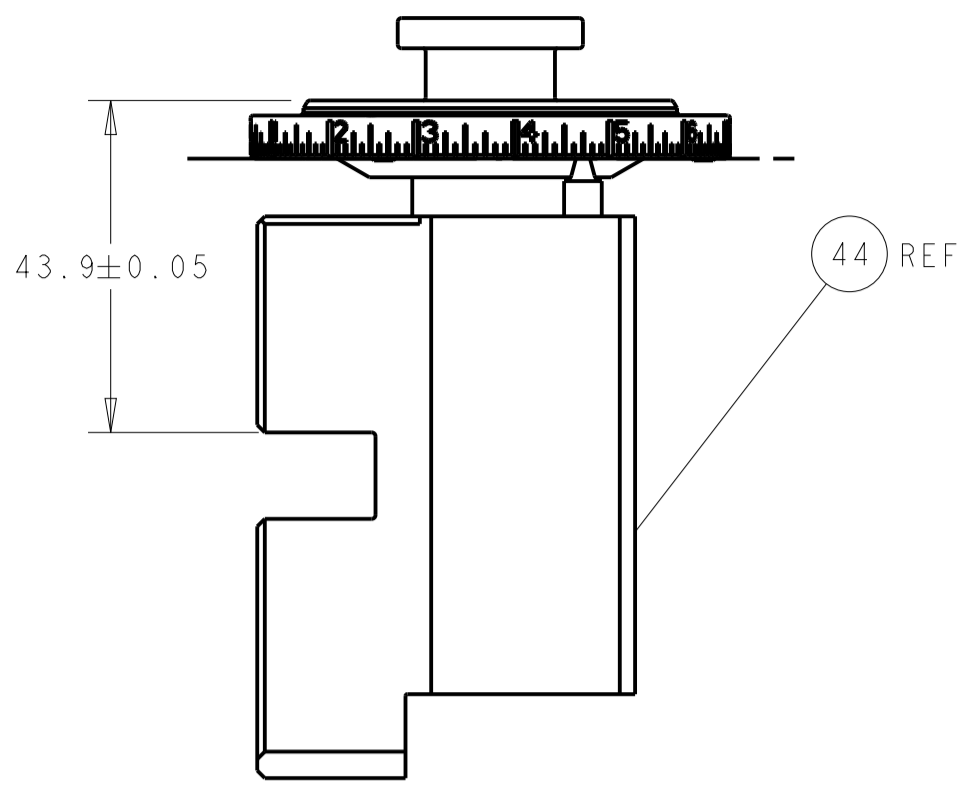
-	1	1	455888-2	SPACER, CRIMPER	26.3
-	1	1	2119641-1	FEED CAM, AIR FEED	24.8
-	1	1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	24.4
-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	24.3
-	1	1	2119083-1	RETAINER, INSULATION DIAL	24.2
-	1	1	2844940-4	AIR FEED MODULE	23.8
-	1	1	1-18028-0	WASHER, FLAT, REG M8	19.2
-	REF	REF	994970-2	COUNTER, MAGNETIC	16.4
-	1	1	455888-4	SPACER, CRIMPER	8.2
-	1	1	2119791-9	DEPRESSOR, WIRE	7.3
-	1	1	1803607-4	DOCUMENTATION PACKAGE	7.1
-	2	2	2-18032-2	SCR, SET, FLT PNT, M3 X 10.0	7.0
-	1	1	2119943-1	WASHER, SPACER	6.9
-	1	1	2119740-1	TAG, IDENTIFICATION	6.7
-	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	6.6
-	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	6.0
-	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	5.9
-	4	4	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	5.7
-	2	2	2-2168083-6	SCR, SKT HD CAP, RoHS, M4 X 18	5.6
-	2	2	5018030-1	NUT, HEX, REG, RoHS, M3	5.4
-	2	2	986965-8	NUT, LOCK, HEX, TORQUE (M4)	5.3
-	1	1	2063961-1	FEED FINGER	5.1
-	1	1	18023-9	SCR, SKT HD CAP M4 X 6.0	4.9
-	1	1	2119655-5	APPLICATOR BASIC ASSEMBLY, EF	4.6
-	1	1	1803517-1	RAM ASSEMBLY, EF ATLANTIC	4.4
-	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	4.1
-	8	8	1-18028-2	WASHER, FLAT, REG M4	3.3
-	2	2	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	3.1
-	2	2	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	2.9
-	1	1	690455-1	STRIPPER, FRONT CASTING	2.7
-	2	2	1-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 30	2.5
-	1	1	1752371-1	PLATE, STRIP GUIDE	2.4
-	2	2	9-22281-7	SPRING, COMPRESSION	2.2
-	1	1	1803292-1	DRAG	2.0
-	1	1	6-1901696-7	STRIP GUIDE, REAR	1.9
-	1	1	4-1901695-9	STRIP GUIDE, FRONT	1.8
-	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	1.7
-	1	1	8-240641-6	SPACER	1.6
-	1	1	3-240641-5	SPACER	1.5
-	1	1	240644-1	PLATE, REAR SHEAR	1.1
-	-	-	-	-	1.0
-	1	1	690482-3	PLATE, FRONT SHEAR	.9
1	2	1	3-1333223-2	ANVIL, COMBINATION	.8
-	1	1	690474-9	BLADE, SLUG	.7
-	1	1	1-240641-2	SPACER	.5
-	1	1	1-238011-2	BLOCK, CRIMPER SPACER	.4
1	2	1	3-2119582-1	CRIMPER, INSULATION F PREMIUM	.3
-	1	1	1-455888-1	SPACER, CRIMPER	.2
1	2	1	3-456412-1	CRIMPER, WIRE .180 F PREMIUM	.1
-	77	-72	-2	PART NO	ITEM NO
-	-	-	-	DESCRIPTION	

***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)

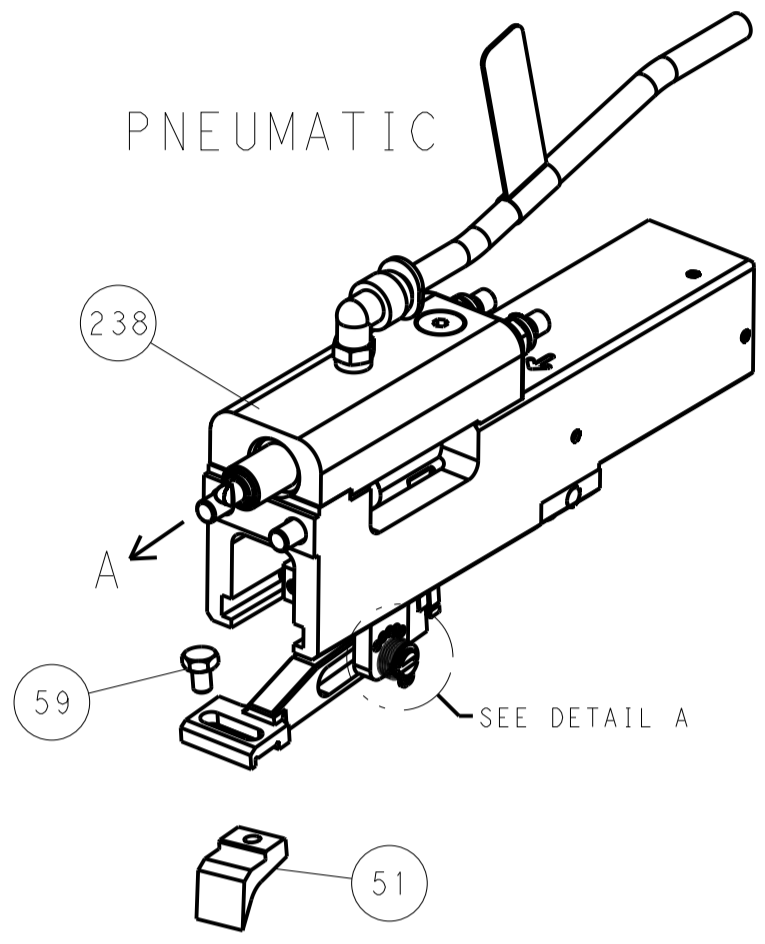
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		OWN: HOFFNER 01DEC2011		TE Connectivity	
mm		0 PLC ±		CHK: T. ELBIN 02DEC2011		Harrisburg, PA 17105-3608	
		1 PLC ±		APPV: T. ELBIN 02DEC2011		NAME: Ocean End Feed Applicator	
		2 PLC ±		PRODUCT SPEC		SIZE: CAGE CODE: DRAWING NO: RESTRICTED TO	
		3 PLC ±		APPLICATION SPEC		A1 00779 C=2150223	
		4 PLC ±		WEIGHT		SCALE: 1:1 SHEET 1 OF 4 REV F	
MATERIAL:		FINISH:		Customer Accessible Production Drawing			

LOC	DIST	REV	DATE	BY	APPV
A	66				
REVISIONS			DESCRIPTION	DATE	BY
			SEE SHEET 1		

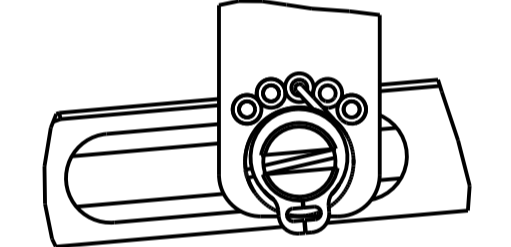


RAM SET-UP

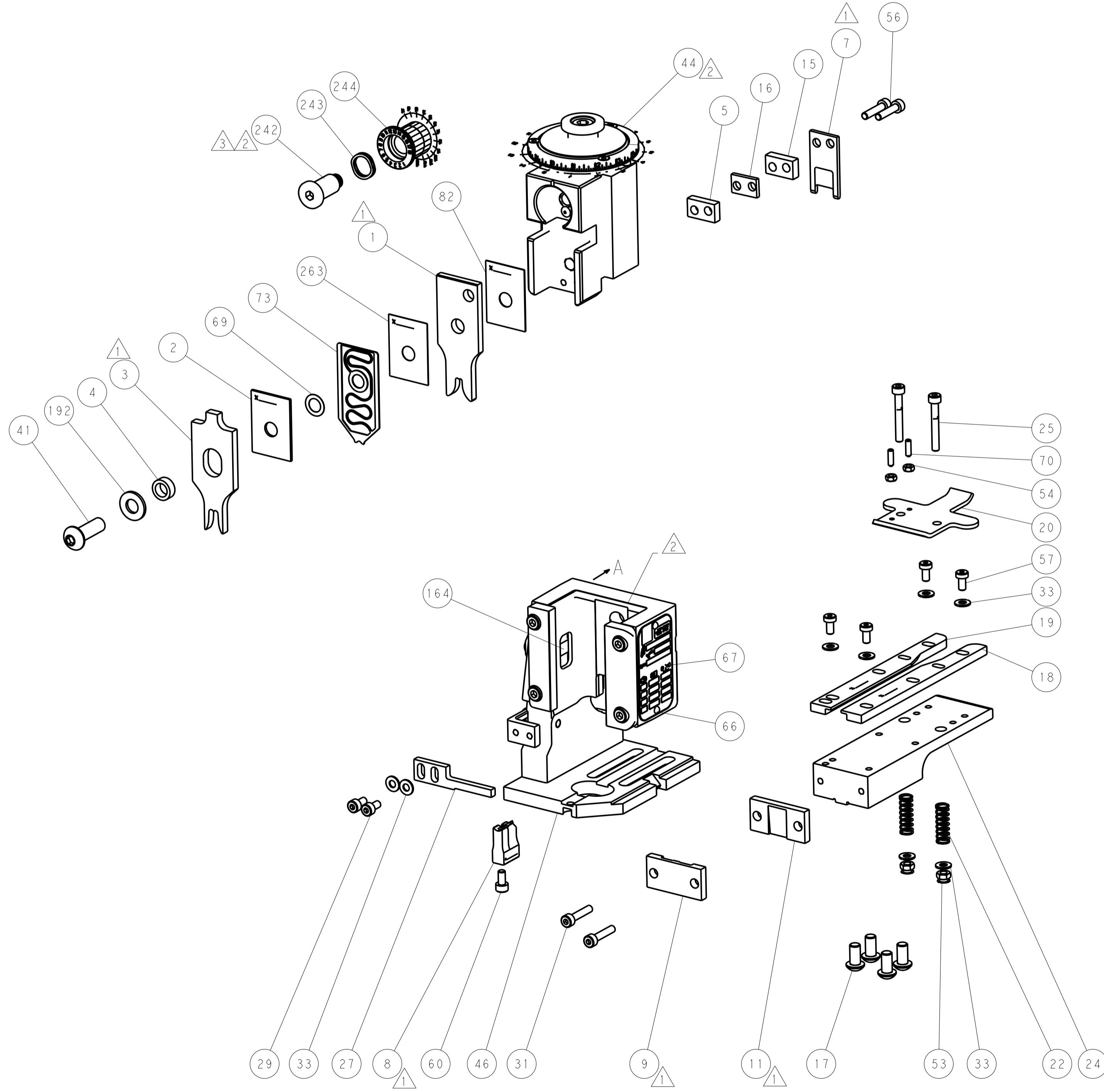
FEED TYPE



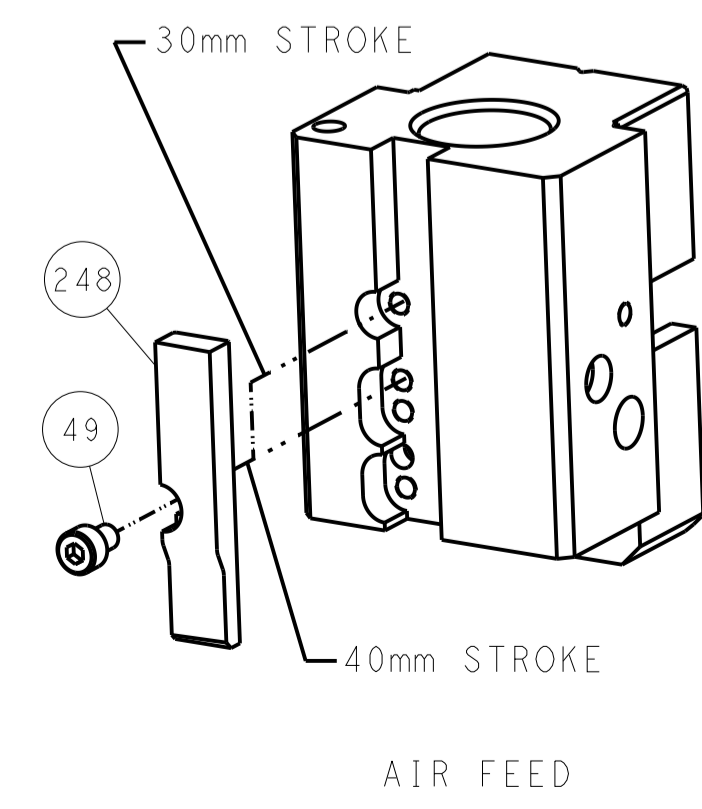
FEED SPRING SETTING POSITION



DETAIL A



CAM POSITION

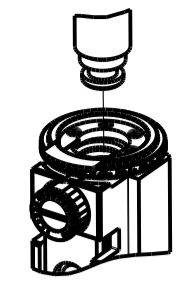


ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

<small>THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.</small>		DWN: HOFFNER 01DEC2011 CHK: T. ELBIN 02DEC2011 APVD: T. ELBIN 02DEC2011	TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±	NAME: Ocean End Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2150223 RESTRICTED TO: F
MATERIAL: - FINISH: -		WEIGHT: - SCALE: 1:1 SHEET: 2 of 4 REV: F	CUSTOMER ACCESSIBLE PRODUCTION DRAWING

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150223-2	F	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150223-7	F	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
 INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	4.57 mm [.180]	F
INSUL	6.35 mm [.250]	F
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: RING TONGUE			
WIRE STRIP LENGTH 5.70-6.50 mm [.224-.256 IN]		INSULATION DIAMETER RANGE 4.00-5.30 mm [.157-.209 IN]	
TERMINAL APPLICATION SPECIFICATION	114-18022	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
928911-1	928911-2		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
6.00mm2	3.48 +/- 0.05 [.137 +/- .002]	4.7
4.00mm2	3.16 +/- 0.05 [.124 +/- .002]	8.3

- 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 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.

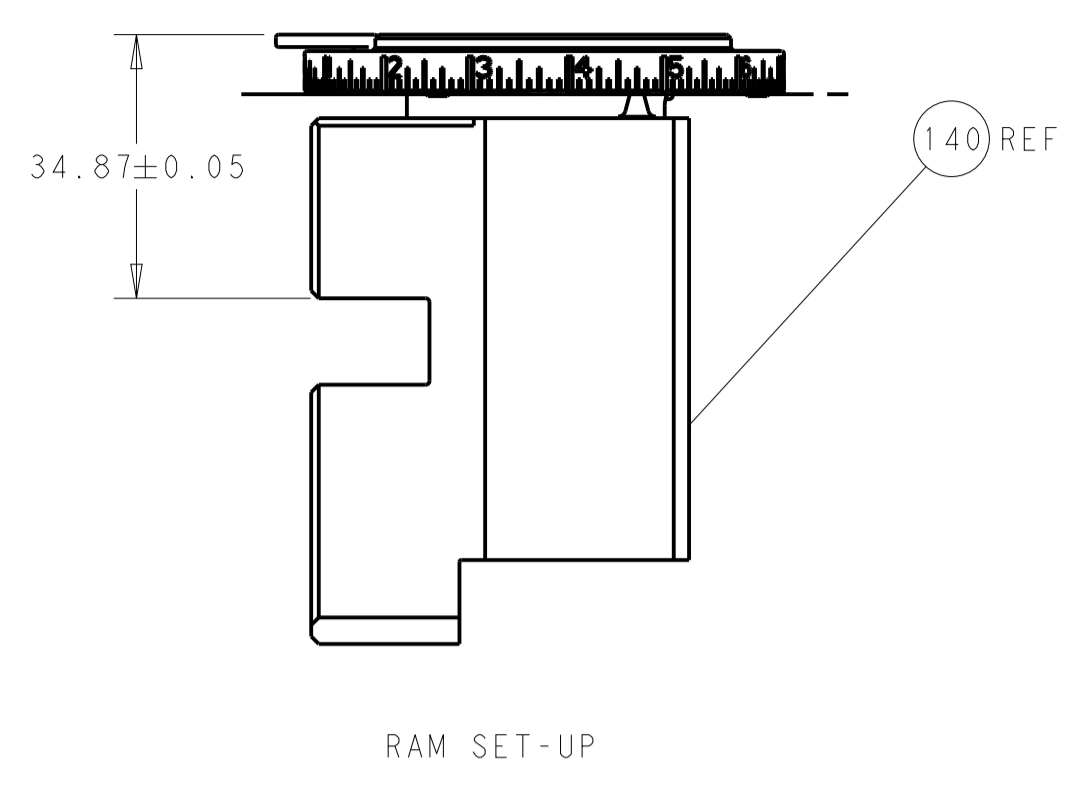
LOC	DIST	REV	LTN	DESCRIPTION	DATE	OWN	APVD
A	66	-	-	SEE SHEET 1	-	-	-

-	1	455888-2	SPACER, CRIMPER	263
-	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
-	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	2119791-9	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	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	690455-1	STRIPPER, FRONT CASTING	27
-	2	1-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 30	25
-	1	1752371-1	PLATE, STRIP GUIDE	24
-	2	9-22281-7	SPRING, COMPRESSION	22
-	1	1803292-1	DRAG	20
-	1	6-1901696-7	STRIP GUIDE, REAR	19
-	1	4-1901695-9	STRIP GUIDE, FRONT	18
-	1	8-240641-6	SPACER	16
-	1	3-240641-5	SPACER	15
-	1	240644-1	PLATE, REAR SHEAR	11
-	-	-	-	10
-	1	690482-3	PLATE, FRONT SHEAR	9
-	1	3-1333223-2	ANVIL, COMBINATION	8
-	1	690474-9	BLADE, SLUG	7
-	1	1-240641-2	SPACER	5
-	1	1-238011-2	BLOCK, CRIMPER SPACER	4
-	1	3-2119582-1	CRIMPER, INSULATION F PREMIUM	3
-	1	1-455888-1	SPACER, CRIMPER	2
-	1	3-456412-1	CRIMPER, WIRE .180 F PREMIUM	1
-	77-22	PART NO	DESCRIPTION	ITEM NO

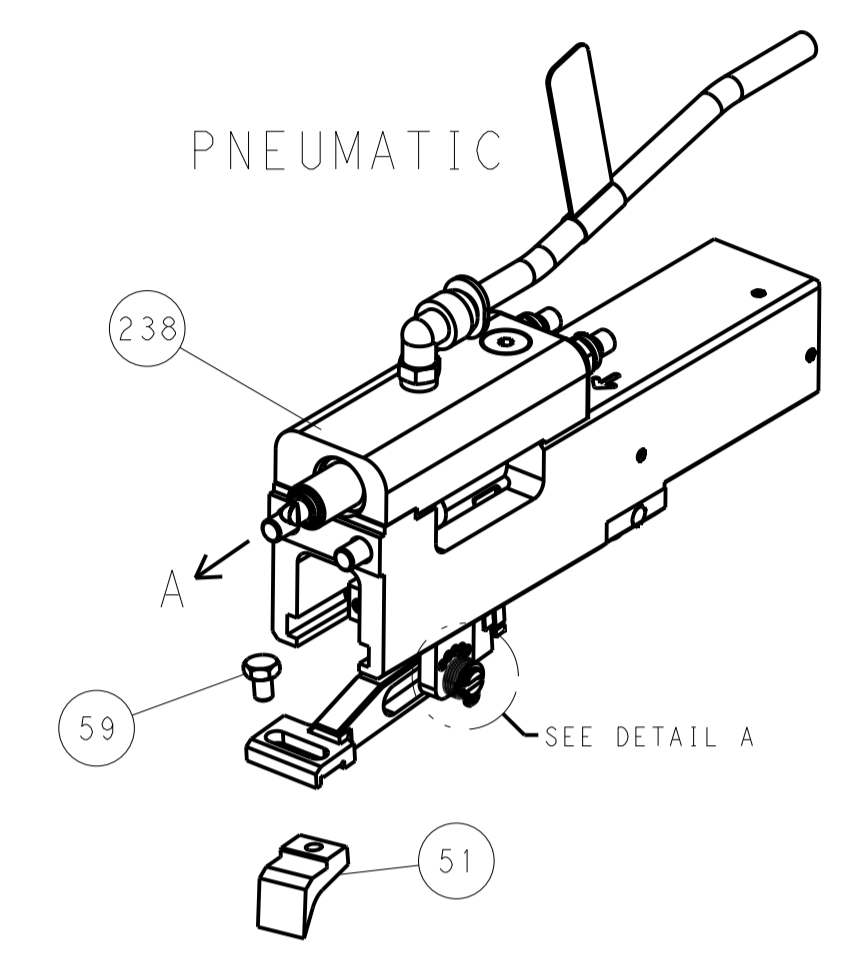
PACIFIC VERSION
 Shown on sheets 3 of 4 & 4 of 4
 (Atlantic version shown on sheets 1 of 4 & 2 of 4)

DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH		DWN: HOFFNER 01DEC2011 CHK: T. ELBIN 02DEC2011 APVD: T. ELBIN 02DEC2011		NAME: TE Connectivity Harrisburg, PA 17105-3608	
MATERIAL:		WEIGHT:		SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2150223		RESTRICTED TO:	
Customer Accessible Production Drawing				SCALE: 1:1		SHEET 3 OF 4 REV F	

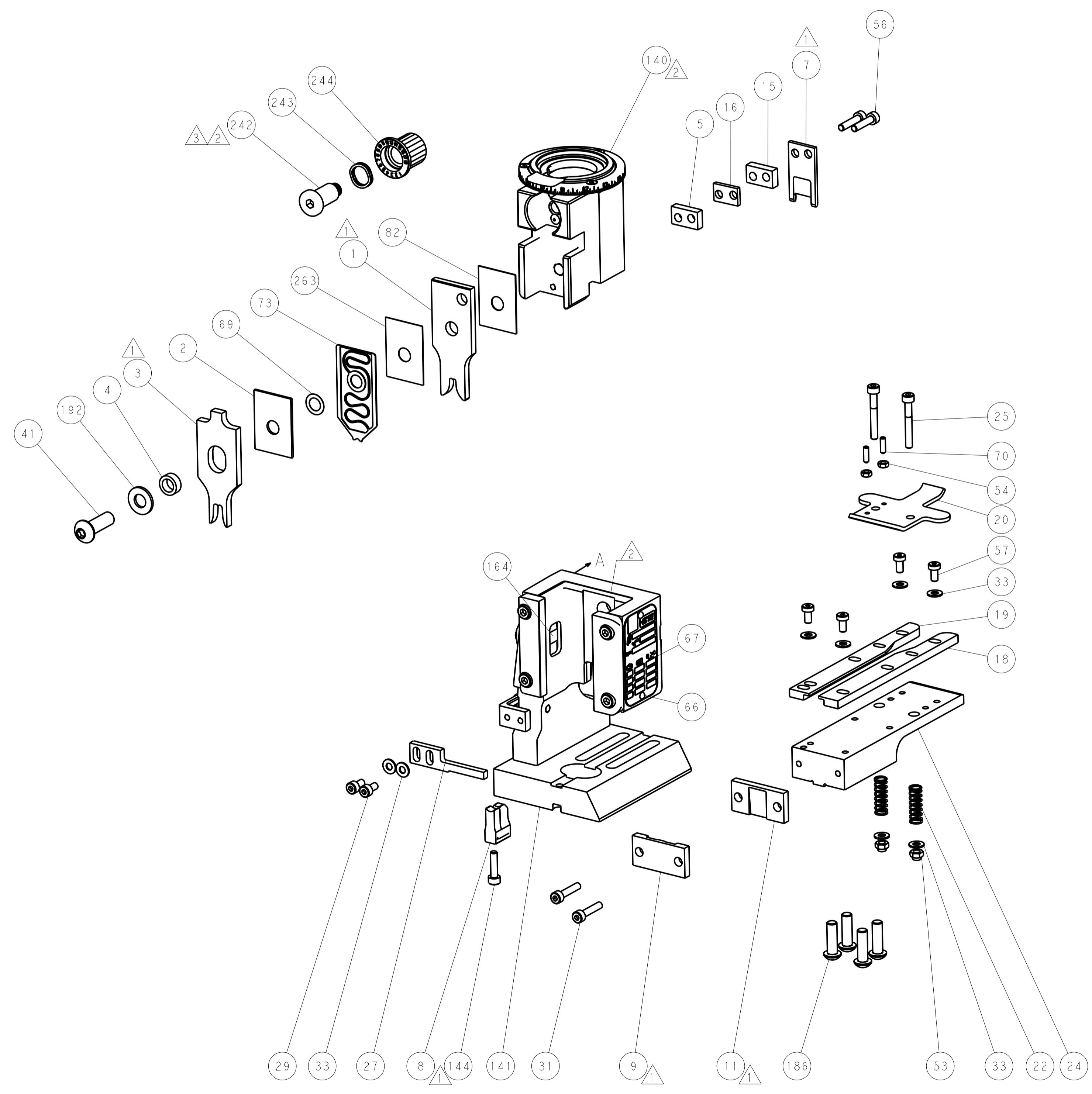
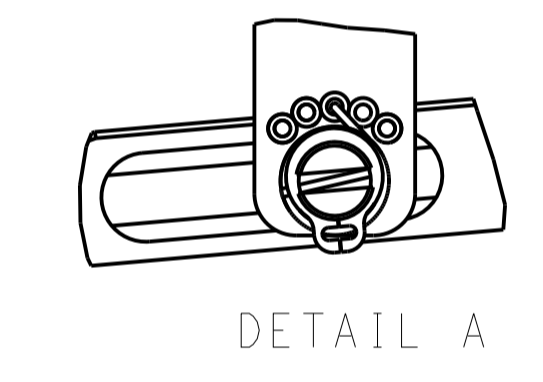
LOC	DIST	REV	DATE	BY	APPV
A	66				
REVISIONS			DESCRIPTION	DATE	BY
			SEE SHEET 1		



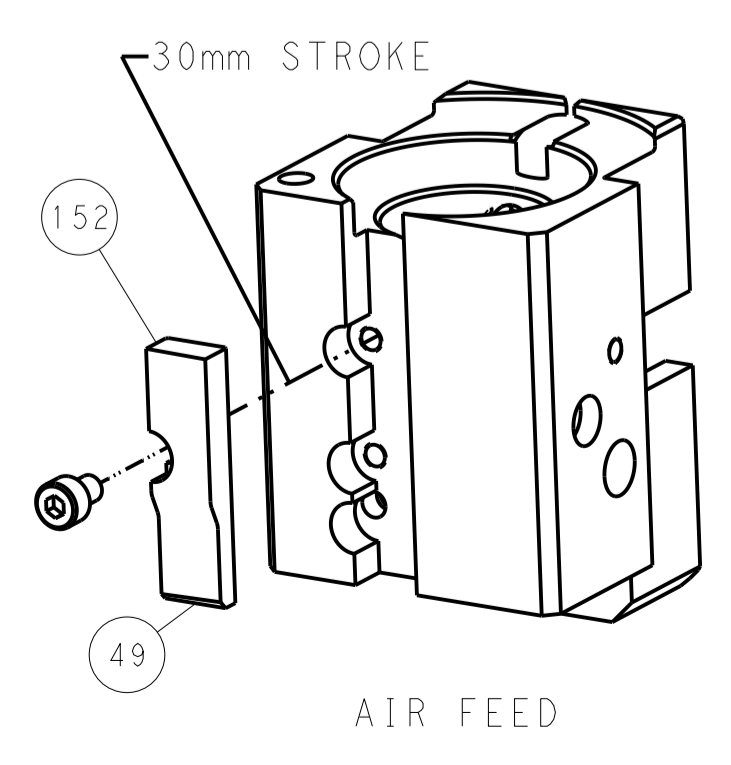
FEED TYPE



FEED SPRING SETTING POSITION



CAM POSITION



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 ±		PRODUCT SPEC APPLICATION SPEC WEIGHT SCALE: 1:1	NAME: Ocean End Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: C-2150223 SHEET 4 OF 4 REV F
MATERIAL: - FINISH: -		RESTRICTED TO: Customer Accessible Production Drawing	