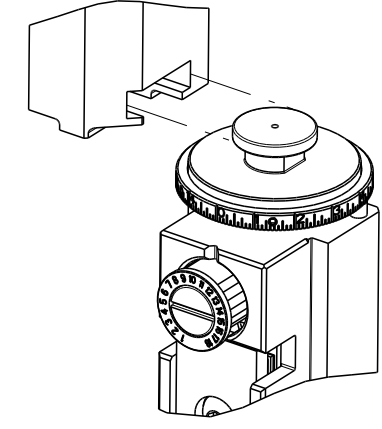


| PART NUMBER | REVISION | DESCRIPTION | FEED TYPE |
|-------------|----------|----------------------------------|------------|
| 2150196-1 | E | FINE CRIMP HEIGHT ADJUST | MECHANICAL |
| 2150196-2 | E | FINE CRIMP HEIGHT ADJUST | PNEUMATIC |
| 7-2150196-1 | E | MECHANICAL AND CRIMP TOOLING KIT | MECHANICAL |
| 7-2150196-2 | E | PNEUMATIC AND CRIMP TOOLING KIT | PNEUMATIC |
| 7-2150196-7 | B | CRIMP TOOLING KIT | - |

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



| APPLICATOR DATA | | |
|-----------------|----------------|------|
| CRIMP | SIZE | TYPE |
| WIRE | 2.03 mm [.080] | F |
| INSUL | 3.94 mm [.155] | OV |

APPLICATOR INSTRUCTIONS 408-35043

| TERMINAL DATA: TE TERMINAL | | TE CRIMP SPECIFICATION | |
|--|-------------|------------------------------|-------------|
| TERMINAL NAME: RECEPTACLE POSITIVE 4.75 SERIES | | | |
| WIRE STRIP LENGTH | | INSULATION DIAMETER RANGE | |
| 3.50-4.50 mm [.138-.177 IN] | | ∅2.30-3.60 mm [.091-.142 IN] | |
| TERMINAL APPLICATION SPECIFICATION | 114-5125 | | |
| TERMINALS APPLIED | | | |
| TE TERMINAL | TE TERMINAL | TE TERMINAL | TE TERMINAL |
| 1742669-1 | | | |

| WIRE SIZE | CRIMP HEIGHT mm [INCH] | CRIMP HEIGHT REFERENCE SETTING |
|-------------|-------------------------------|--------------------------------|
| 1.4mm solid | 1.57 +/- 0.05 [.062 +/- .002] | 3.8 |
| 16 AWG | 1.53 +/- 0.05 [.060 +/- .002] | 3.6 |
| 18 AWG | 1.33 +/- 0.05 [.052 +/- .002] | 5.8 |
| 20 AWG | 1.22 +/- 0.05 [.048 +/- .002] | 6.9 |

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. 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.

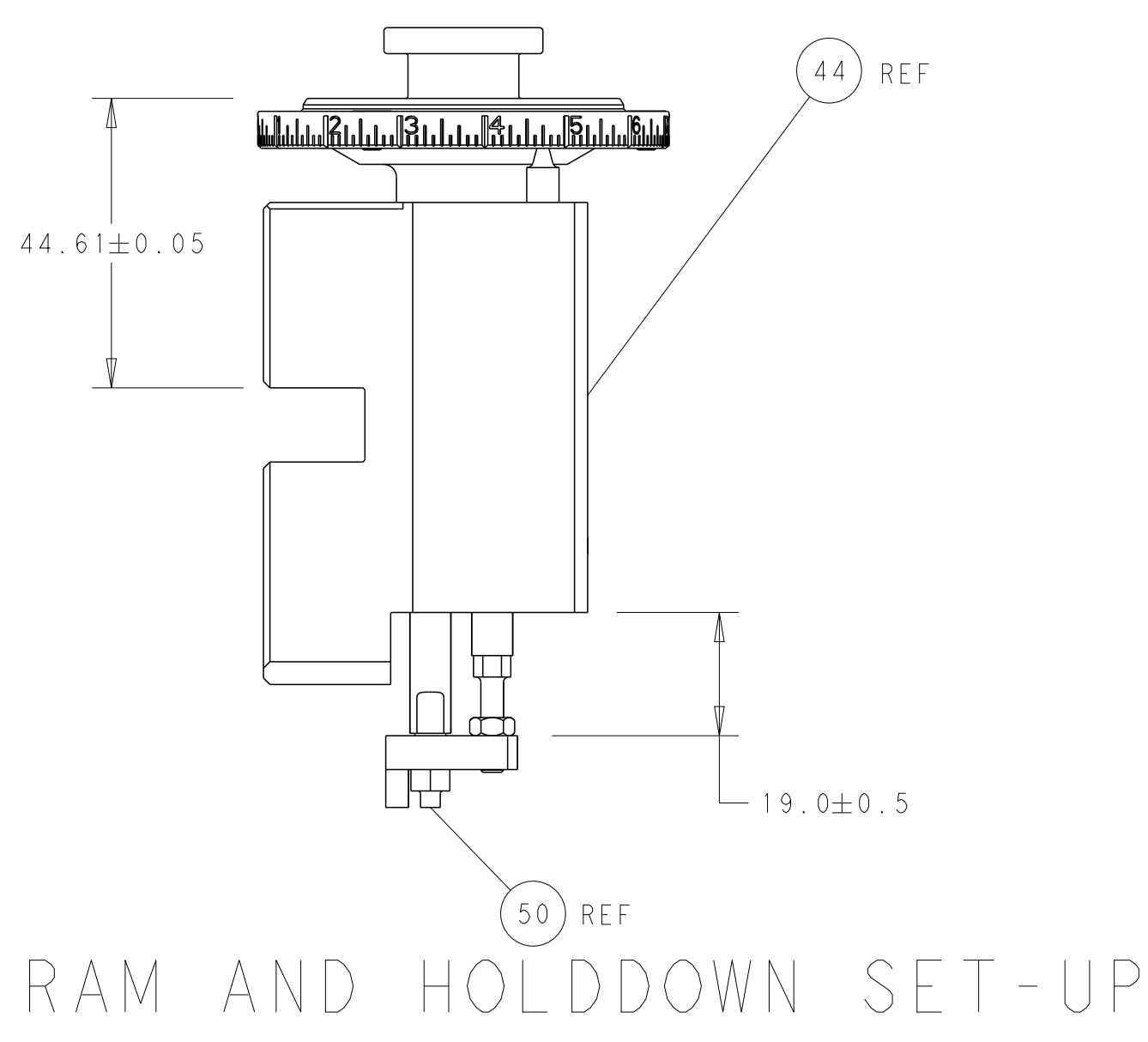
ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

| LOC | DIST | REVISIONS | | | | | |
|-----|------|-----------|-----|---------------|-----------|-----|------|
| A | 66 | P | LTN | DESCRIPTION | DATE | DWN | APVD |
| | | C | | ECR-14-009893 | 01JUL2014 | LG | GB |
| | | D | | ECR-17-017022 | 20NOV2017 | KH | TE |
| | | E | | ECR-23-185040 | 23AUG2023 | JWC | ROY |

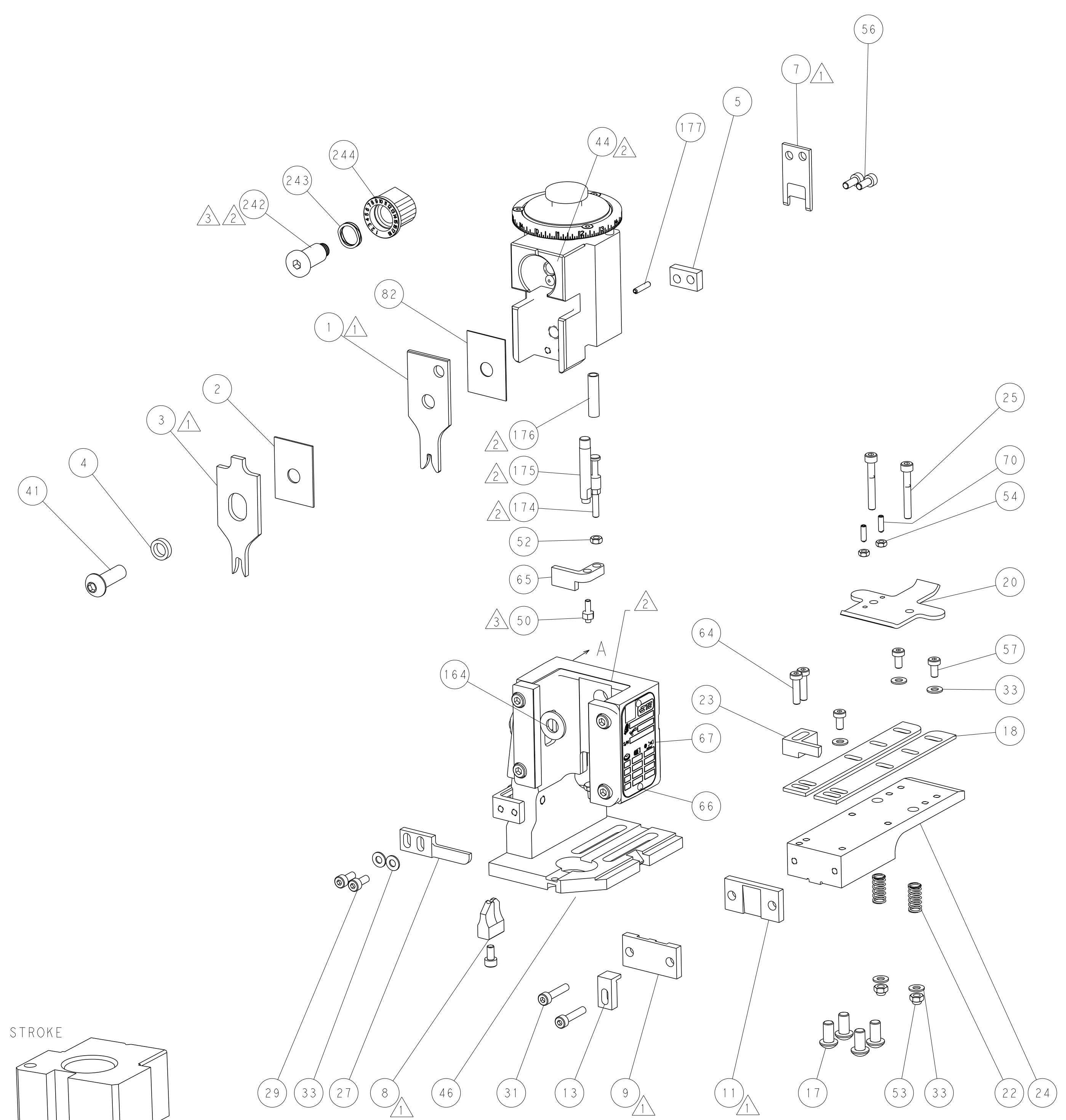
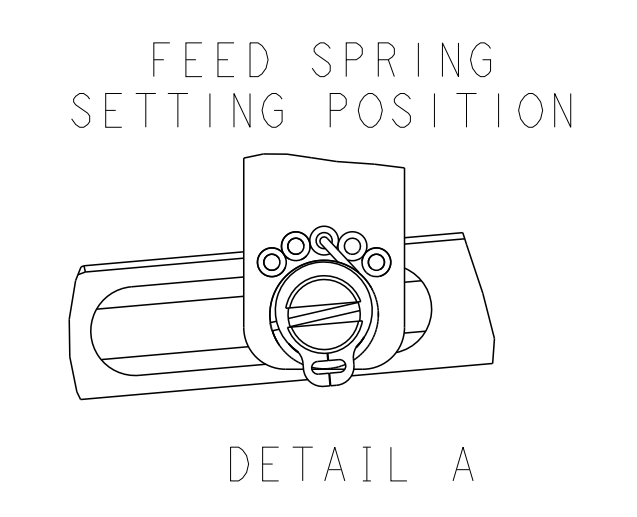
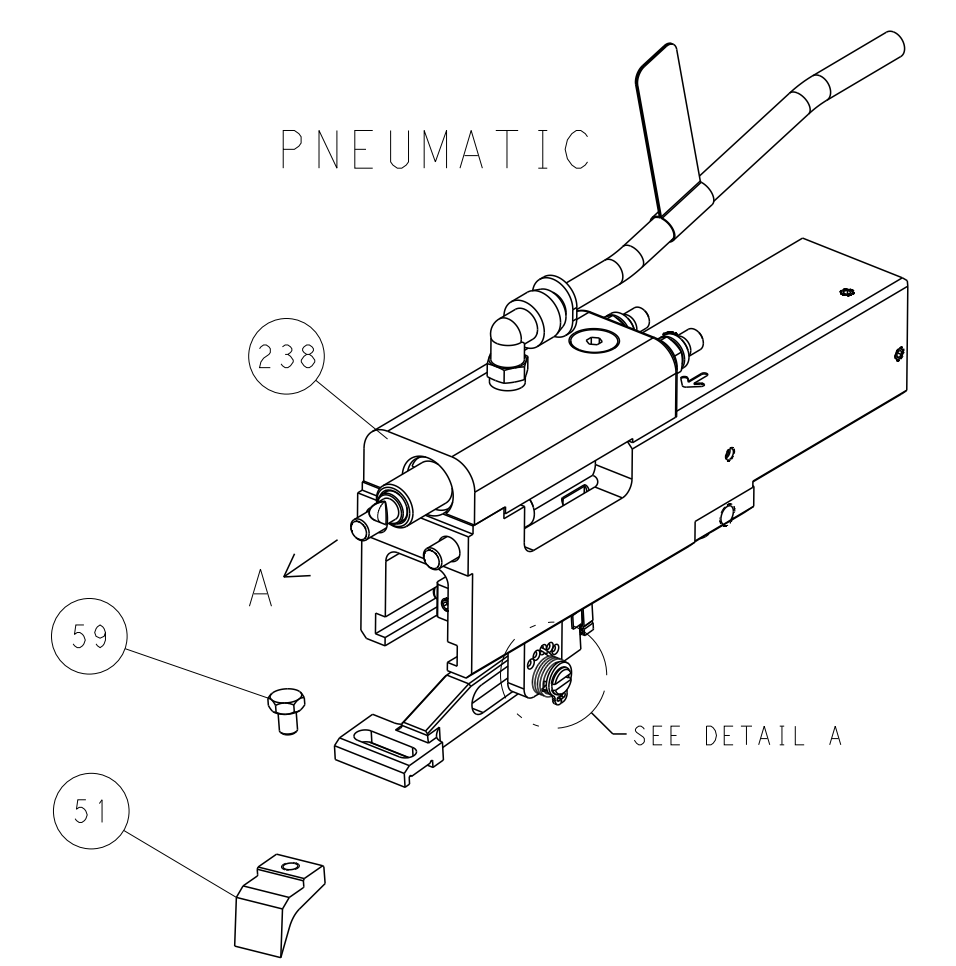
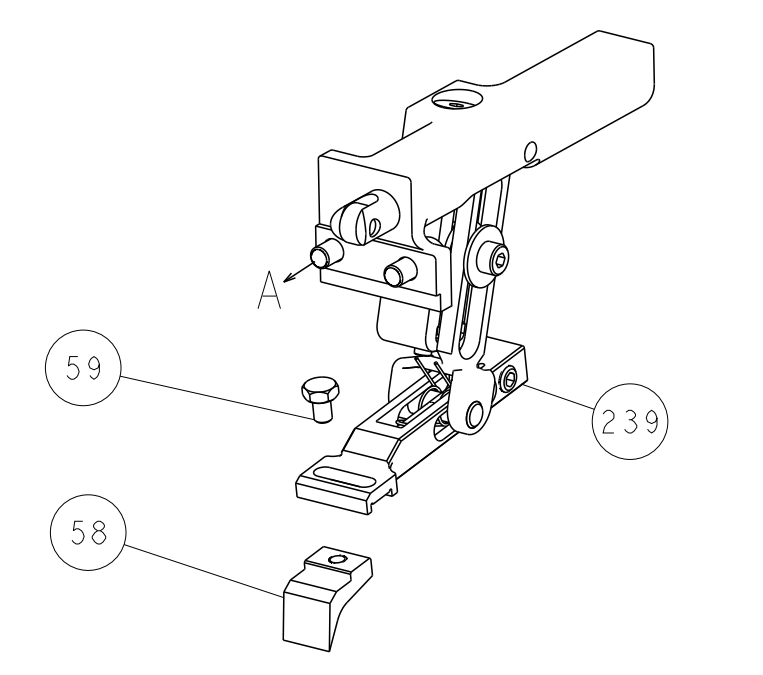
| | | | | | | | |
|---|-----|-----|-----|-----|-------------|-------------------------------------|-----|
| - | 1 | - | 1 | - | 2119641-1 | FEED CAM, AIR FEED | 248 |
| - | 1 | 1 | 1 | 1 | 2119082-9 | CAM, SNAIL, INSULATION ADJUSTMENT | 244 |
| - | 1 | 1 | 1 | 1 | 2079764-1 | WASHER, WAVE SPRING, CREST-TO-CREST | 243 |
| - | 1 | 1 | 1 | 1 | 2119083-1 | RETAINER, INSULATION DIAL | 242 |
| - | - | 1 | - | 1 | 2119580-1 | MECHANICAL FEED ASSEMBLY | 239 |
| - | 1 | - | 1 | - | 2844940-3 | AIR FEED MODULE | 238 |
| - | 1 | 1 | 1 | 1 | 1-18028-0 | WASHER, FLAT, REG M8 | 192 |
| - | 1 | 1 | 1 | 1 | 6-993111-6 | PIN, SLOTTED SPRING 3.0 X 14.0 | 177 |
| - | 1 | 1 | 1 | 1 | 8-22280-7 | SPRING, COMPRESSION | 176 |
| - | 1 | 1 | 1 | 1 | 1752353-2 | GUIDE PIN,HOLDDOWN | 175 |
| - | 1 | 1 | 1 | 1 | 1901680-2 | GUIDE PIN,HOLDDOWN | 174 |
| - | REF | REF | REF | REF | 994970-2 | COUNTER, MAGNETIC | 164 |
| - | 1 | 1 | 1 | 1 | 455888-5 | SPACER, CRIMPER | 82 |
| - | 1 | 1 | 1 | 1 | 1803607-4 | DOCUMENTATION PACKAGE | 71 |
| - | 2 | 2 | 2 | 2 | 2-18032-2 | SCR, SET, FLT PNT, M3 X 10.0 | 70 |
| - | 1 | 1 | 1 | 1 | 2119740-1 | TAG, IDENTIFICATION | 67 |
| - | 2 | 2 | 2 | 2 | 2168078-1 | SCREW, DRIVE, RH, RoHS, 2 x .188 | 66 |
| - | 1 | 1 | 1 | 1 | 1901681-5 | HOLDDOWN, TERMINAL | 65 |
| - | 2 | 2 | 2 | 2 | 2168400-8 | SHCS, LOW HEAD, RoHS, M4 X 16 | 64 |
| - | 1 | 1 | 1 | 1 | 2168083-2 | SCR, SKT HD CAP, RoHS, M4 X 8.0 | 60 |
| - | 2 | 2 | 2 | 2 | 5-18022-5 | SCR, HEX HD CAP, M4 X 6.0 | 59 |
| - | 1 | 1 | 1 | 1 | 2063961-1 | FEED FINGER | 58 |
| - | 3 | 3 | 3 | 3 | 2168400-4 | SHCS, LOW HEAD, RoHS, M4 X 8 | 57 |
| - | 2 | 2 | 2 | 2 | 1-2168083-0 | SCR, SKT HD CAP, RoHS, M4 X 10 | 56 |
| - | 2 | 2 | 2 | 2 | 5018030-1 | NUT, HEX, REG, RoHS, M3 | 54 |
| - | 2 | 2 | 2 | 2 | 986965-8 | NUT, LOCK, HEX, TORQUE (M4) | 53 |
| - | 1 | 1 | 1 | 1 | 1-5018030-0 | NUT, HEX, REG, RoHS, M3.5 | 52 |
| - | 1 | 1 | 1 | 1 | 2063961-1 | FEED FINGER | 51 |
| - | 1 | 1 | 1 | 1 | 1976055-8 | STANDOFF, HOLD-DOWN | 50 |
| - | 1 | 2 | 1 | 2 | 18023-9 | SCR, SKT HD CAP M4 X 6.0 | 49 |
| - | - | 1 | - | 1 | 2119652-1 | FEED CAM, PRE FEED | 48 |
| - | - | 1 | - | 1 | 2119653-1 | FEED CAM, POST FEED | 47 |
| - | 1 | 1 | 1 | 1 | 2119655-5 | APPLICATOR BASIC ASSEMBLY, EF | 46 |
| - | 1 | 1 | 1 | 1 | 1803517-1 | RAM ASSEMBLY, EF ATLANTIC | 44 |
| - | 1 | 1 | 1 | 1 | 1803602-1 | SCR, BHSC, RoHS (M8 X 25) | 41 |
| - | 7 | 7 | 7 | 7 | 1-18028-2 | WASHER, FLAT, REG M4 | 33 |
| - | 2 | 2 | 2 | 2 | 2168083-9 | SCR, SKT HD CAP, RoHS, M4 X 20 | 31 |
| - | 2 | 2 | 2 | 2 | 1-2168083-0 | SCR, SKT HD CAP, RoHS, M4 X 10 | 29 |
| - | 1 | 1 | 1 | 1 | 240639-1 | STRIPPER (MACHINING) | 27 |
| - | 2 | 2 | 2 | 2 | 1-2168083-5 | SCR, SKT HD CAP, RoHS, M4 X 30 | 25 |
| - | 1 | 1 | 1 | 1 | 1752371-5 | PLATE, STRIP GUIDE | 24 |
| - | 1 | 1 | 1 | 1 | 240825-2 | PLATE, STRIP HOLD DOWN | 23 |
| - | 2 | 2 | 2 | 2 | 2-22281-3 | SPRING, COMPRESSION | 22 |
| - | 1 | 1 | 1 | 1 | 1803292-4 | DRAG | 20 |
| - | 2 | 2 | 2 | 2 | 1901259-4 | GUIDE, LOWER STRIP | 18 |
| - | 4 | 4 | 4 | 4 | 1-2079383-1 | SCR, BHSC, RoHS (M6 X 12) | 17 |
| - | 1 | 1 | 1 | 1 | 1752360-1 | SPACER,HOLD-DOWN | 13 |
| - | 1 | 1 | 1 | 1 | 240644-1 | PLATE, REAR SHEAR | 11 |
| - | 1 | 1 | 1 | 1 | 690482-6 | PLATE, FRONT SHEAR | 9 |
| - | 1 | 2 | 2 | 1 | 1-1803000-1 | ANVIL, COMBINATION, END FEED | 8 |
| - | 1 | 1 | 1 | 1 | 2217206-4 | BLADE, SLUG | 7 |
| - | 1 | 1 | 1 | 1 | 3-240641-5 | SPACER | 5 |
| - | 1 | 1 | 1 | 1 | 238011-2 | BLOCK, CRIMPER SPACER | 4 |
| - | 1 | 2 | 2 | 1 | 1-2119785-6 | CRIMPER, INSULATION OVERLAP PREMIUM | 3 |
| - | 1 | 1 | 1 | 1 | 455888-8 | SPACER, CRIMPER | 2 |
| - | 1 | 2 | 2 | 1 | 2-1633738-2 | CRIMPER, WIRE | 1 |

| DIMENSIONS: | | TOLERANCES UNLESS OTHERWISE SPECIFIED: | | DWN | | TE Connectivity | |
|-------------|---------|--|----------|------------------|-----------|---------------------------|-----------|
| mm | 0 PLC ± | 1 PLC ± | 2 PLC ± | C. CHEN | 07MAR2012 | Harrisburg, PA 17105-3608 | |
| | 3 PLC ± | 4 PLC ± | ANGLES ± | S. XI | 07MAR2012 | NAME | |
| | FINISH | | | I. CRUZ | 07MAR2012 | Ocean End Feed Applicator | |
| MATERIAL | | | | PRODUCT SPEC | | SIZE | CAGE CODE |
| | | | | APPLICATION SPEC | | A1 | 00779 |
| | | | | WEIGHT | | SCALE | 1:1 |
| | | | | | | SHEET | 1 OF 4 |
| | | | | | | REV | E |

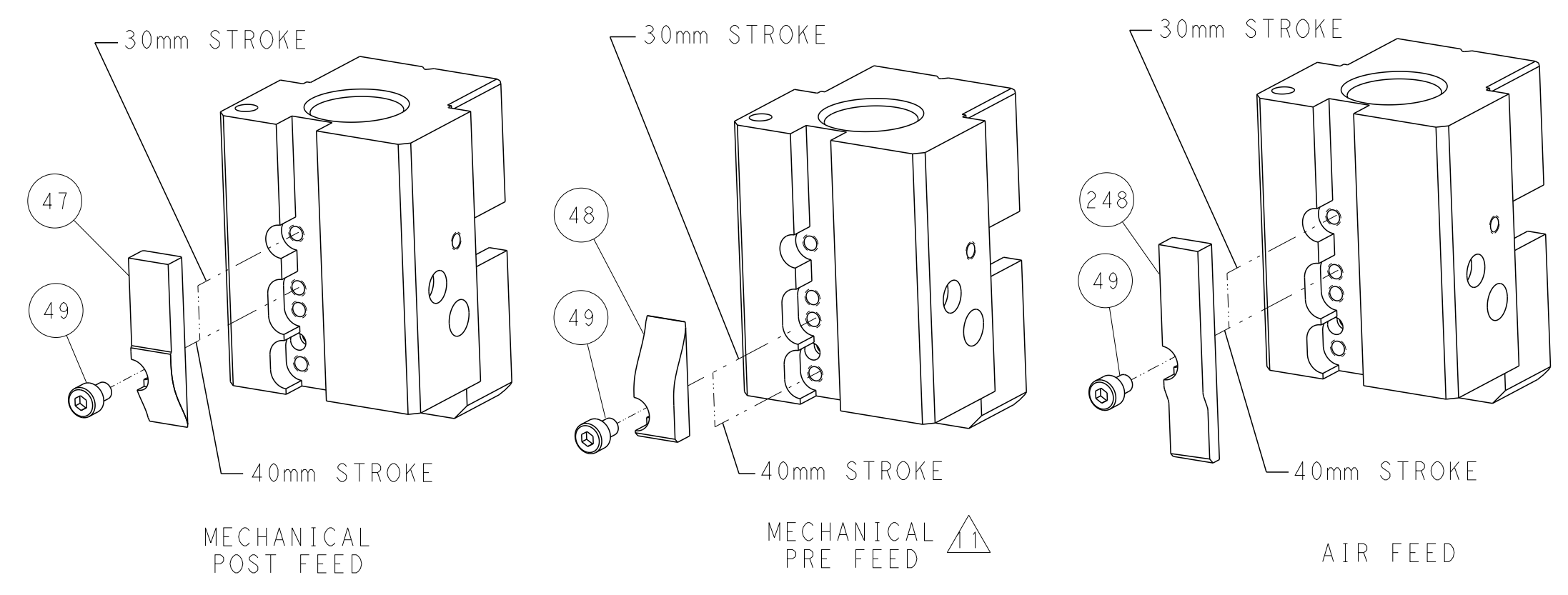
| LOC | DIST | REV | DESCRIPTION | DATE | OWN | APVD |
|-----|------|-----|-------------|------|-----|------|
| A | 66 | | SEE SHEET 1 | | | |



FEED TYPE MECHANICAL



CAM POSITIONS

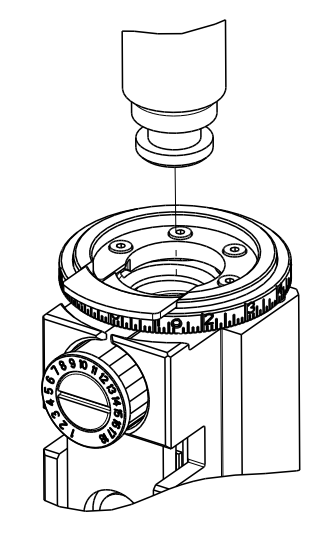


ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

| | | | | | | | | | |
|--|--|---|--|--|--|---|--|---------------|--|
| DIMENSIONS: mm | | TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH | | DWN C. CHEN 07MAR2012 CHK S. XI 07MAR2012 APVD J. CRUZ 07MAR2012 PRODUCT SPEC APPLICATION SPEC WEIGHT Customer Accessible Production Drawing | | NAME Ocean End Feed Applicator SIZE A1 CAGE CODE 00779 DRAWING NO. C=2150196 SCALE 1:1 SHEET 2 OF 4 REV E | | RESTRICTED TO | |
| SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION | | | | | | | | | |

| PART NUMBER | REVISION | DESCRIPTION | FEED TYPE |
|-------------|----------|--------------------------|------------|
| 2-2150196-1 | E | FINE CRIMP HEIGHT ADJUST | MECHANICAL |
| 2-2150196-2 | E | FINE CRIMP HEIGHT ADJUST | PNEUMATIC |
| 7-2150196-7 | B | CRIMP TOOLING KIT | - |

PACIFIC VERSION TERMINATOR
 INTERFACE ADAPTER



APPLICATOR DATA

| CRIMP | SIZE | TYPE |
|-------|----------------|------|
| WIRE | 2.03 mm (.080) | F |
| INSUL | 3.94 mm (.155) | OV |

APPLICATOR INSTRUCTIONS
 408-35043

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION

TERMINAL NAME: RECEPTACLE POSITIVE 4.75 SERIES

| WIRE STRIP LENGTH | INSULATION DIAMETER RANGE |
|-----------------------------|------------------------------|
| 3.50-4.50 mm (.138-.177 IN) | Ø2.30-3.60 mm (.091-.142 IN) |

TERMINAL APPLICATION SPECIFICATION 114-5125

TERMINALS APPLIED

| TE TERMINAL | TE TERMINAL | TE TERMINAL | TE TERMINAL |
|-------------|-------------|-------------|-------------|
| 1742669-1 | | | |

| WIRE SIZE | CRIMP HEIGHT mm [INCH] | CRIMP HEIGHT REFERENCE SETTING |
|-------------|----------------------------|--------------------------------|
| 1.4mm solid | 1.57+/-0.05 [.062+/-0.002] | 3.8 |
| 16 AWG | 1.53+/-0.05 [.060+/-0.002] | 3.6 |
| 18 AWG | 1.33+/-0.05 [.052+/-0.002] | 5.8 |
| 20 AWG | 1.22+/-0.05 [.048+/-0.002] | 6.9 |

- 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. 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 | REV | DATE | BY | APPV |
|-----|------|-----|------|----|------|
| A | 66 | | | | |

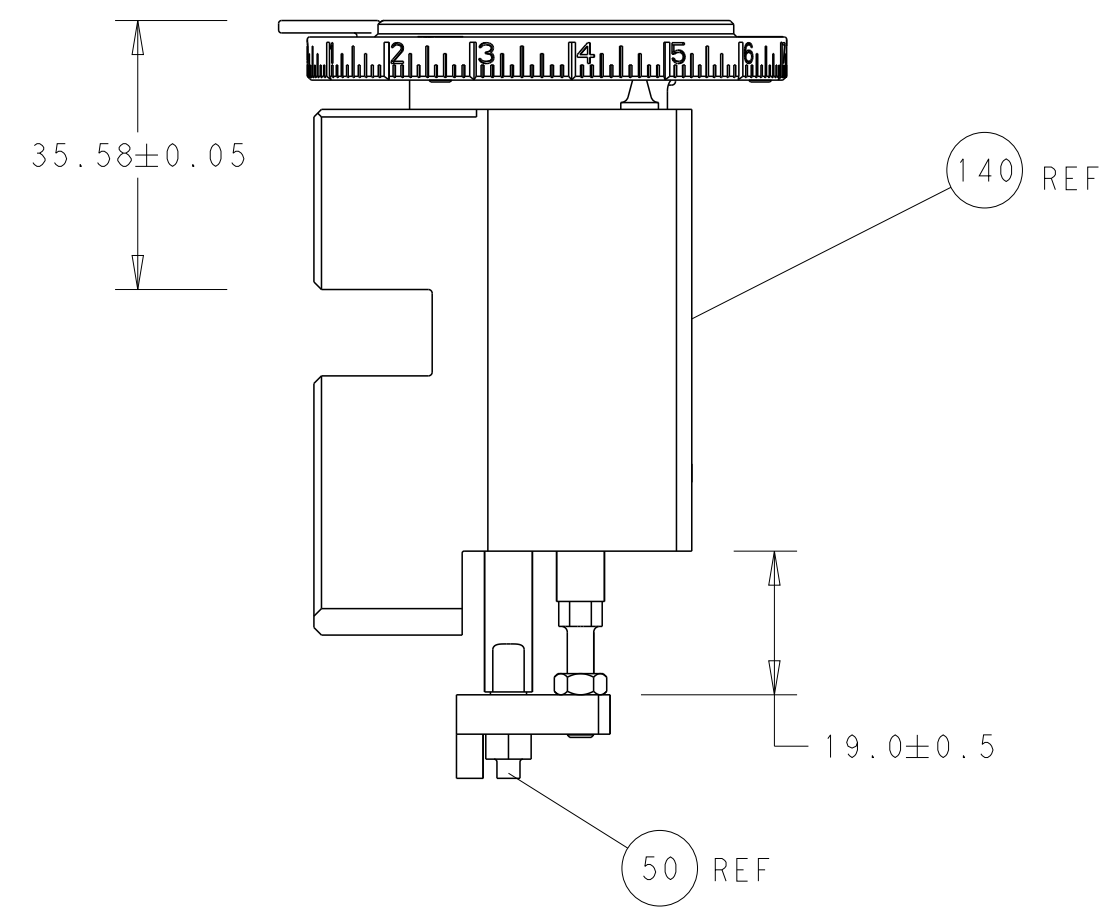
| REV | DATE | DESCRIPTION | DATE | BY | APPV |
|-----|------|-------------|-------------|-------------------------------------|------|
| - | 1 | 1 | 2119082-9 | CAM, SNAIL, INSULATION ADJUSTMENT | 244 |
| - | 1 | 1 | 2079764-1 | WASHER, WAVE SPRING, CREST-TO-CREST | 243 |
| - | 1 | 1 | 2119083-1 | RETAINER, INSULATION DIAL | 242 |
| - | - | 1 | 2119580-1 | MECHANICAL FEED ASSEMBLY | 239 |
| - | 1 | - | 2844940-3 | AIR FEED MODULE | 238 |
| - | 1 | 1 | 1-18028-0 | WASHER, FLAT, REG M8 | 192 |
| - | 4 | 4 | 2079383-9 | SCR, BHSC, RoHS (M6 X 20) | 186 |
| - | 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 |
| - | REF | REF | 994970-2 | COUNTER, MAGNETIC | 164 |
| - | 1 | - | 2119641-2 | FEED CAM, AIR FEED | 152 |
| - | 1 | 1 | 2168083-8 | SCR, SKT HD CAP, RoHS, M4 X 16 | 144 |
| - | - | 1 | 2119653-2 | FEED CAM, POST FEED | 142 |
| - | 1 | 1 | 2119655-6 | APPLICATOR BASIC ASSEMBLY, EF | 141 |
| - | 1 | 1 | 1803518-1 | RAM ASSEMBLY, EF PACIFIC | 140 |
| - | 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 | 1901681-5 | HOLDDOWN, TERMINAL | 65 |
| - | 2 | 2 | 2168400-8 | SHCS, LOW HEAD, RoHS, M4 X 16 | 64 |
| - | - | 2 | 5-18022-5 | SCR, HEX HD CAP, M4 X 6.0 | 59 |
| - | - | 1 | 2063961-1 | FEED FINGER | 58 |
| - | 3 | 3 | 2168400-4 | SHCS, LOW HEAD, RoHS, M4 X 8 | 57 |
| - | 2 | 2 | 1-2168083-0 | SCR, SKT HD CAP, RoHS, M4 X 10 | 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 | - | 2063961-1 | FEED FINGER | 51 |
| - | 1 | 1 | 1976055-8 | STANDOFF, HOLD-DOWN | 50 |
| - | 1 | 2 | 18023-9 | SCR, SKT HD CAP M4 X 6.0 | 49 |
| - | - | 1 | 2119652-1 | FEED CAM, PRE FEED | 48 |
| - | 1 | 1 | 1803602-1 | SCR, BHSC, RoHS (M8 X 25) | 41 |
| - | 7 | 7 | 1-18028-2 | WASHER, FLAT, REG M4 | 33 |
| - | 2 | 2 | 2168083-9 | SCR, SKT HD CAP, RoHS, M4 X 20 | 31 |
| - | 2 | 2 | 1-2168083-0 | SCR, SKT HD CAP, RoHS, M4 X 10 | 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 |
| - | 1 | 1 | 240825-2 | PLATE, STRIP HOLD DOWN | 23 |
| - | 2 | 2 | 2-22281-3 | SPRING, COMPRESSION | 22 |
| - | 1 | 1 | 1803292-4 | DRAG | 20 |
| - | 2 | 2 | 1901259-4 | GUIDE, LOWER STRIP | 18 |
| - | 1 | 1 | 1752360-1 | SPACER,HOLD-DOWN | 13 |
| - | 1 | 1 | 240644-1 | PLATE, REAR SHEAR | 11 |
| - | 1 | 1 | 690482-6 | PLATE, FRONT SHEAR | 9 |
| 1 | 1 | 1 | 1-1803000-1 | ANVIL, COMBINATION, END FEED | 8 |
| - | 1 | 1 | 2217206-4 | BLADE, SLUG | 7 |
| - | 1 | 1 | 3-240641-5 | SPACER | 5 |
| - | 1 | 1 | 238011-2 | BLOCK, CRIMPER SPACER | 4 |
| 1 | 1 | 1 | 1-2119785-6 | CRIMPER, INSULATION OVERLAP PREMIUM | 3 |
| - | 1 | 1 | 455888-8 | SPACER, CRIMPER | 2 |
| 1 | 1 | 1 | 2-1633738-2 | CRIMPER, WIRE | 1 |

| DIMENSIONS: | TOLERANCES UNLESS OTHERWISE SPECIFIED: | DATE | BY | APPV |
|-------------|---|-----------|---------|-------|
| mm | 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH | 07MAR2012 | C. CHEN | S. XI |
| MATERIAL: | | 07MAR2012 | J. CRUZ | |
| FINISH: | | | | |

| ITEM NO | DESCRIPTION | PART NO |
|-----------|-------------|---------|
| -77-22-21 | PART NO | |

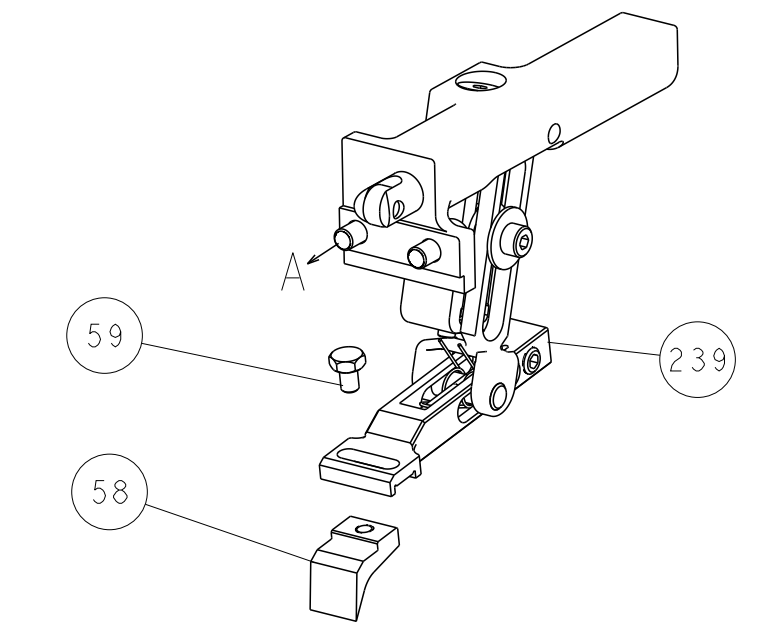
| | | | |
|--|-----------|--------------|-------|
| Customer Accessible Production Drawing | SCALE 1:1 | SHEET 3 OF 4 | REV E |
|--|-----------|--------------|-------|

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

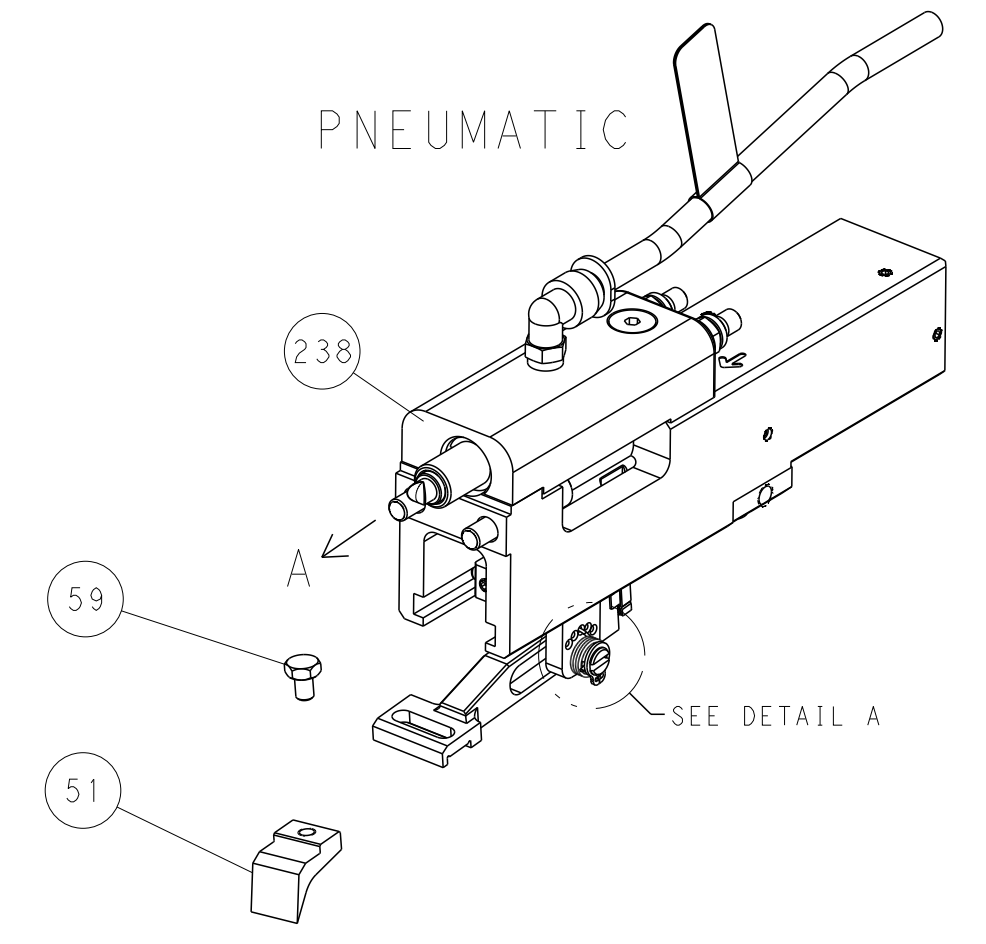


RAM AND HOLDDOWN SET-UP

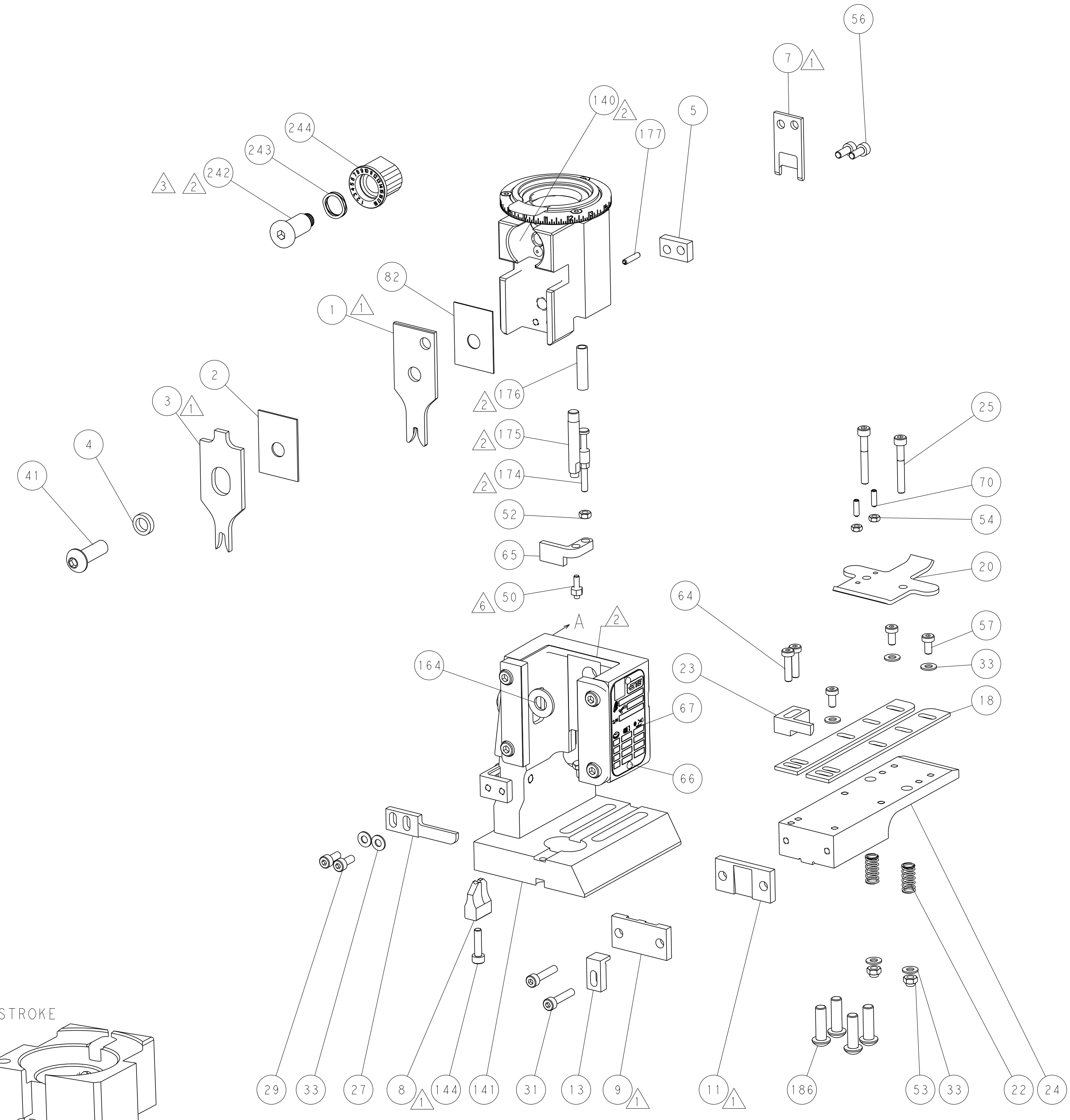
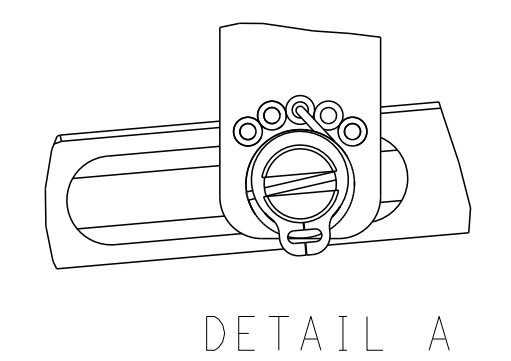
FEED TYPE
MECHANICAL



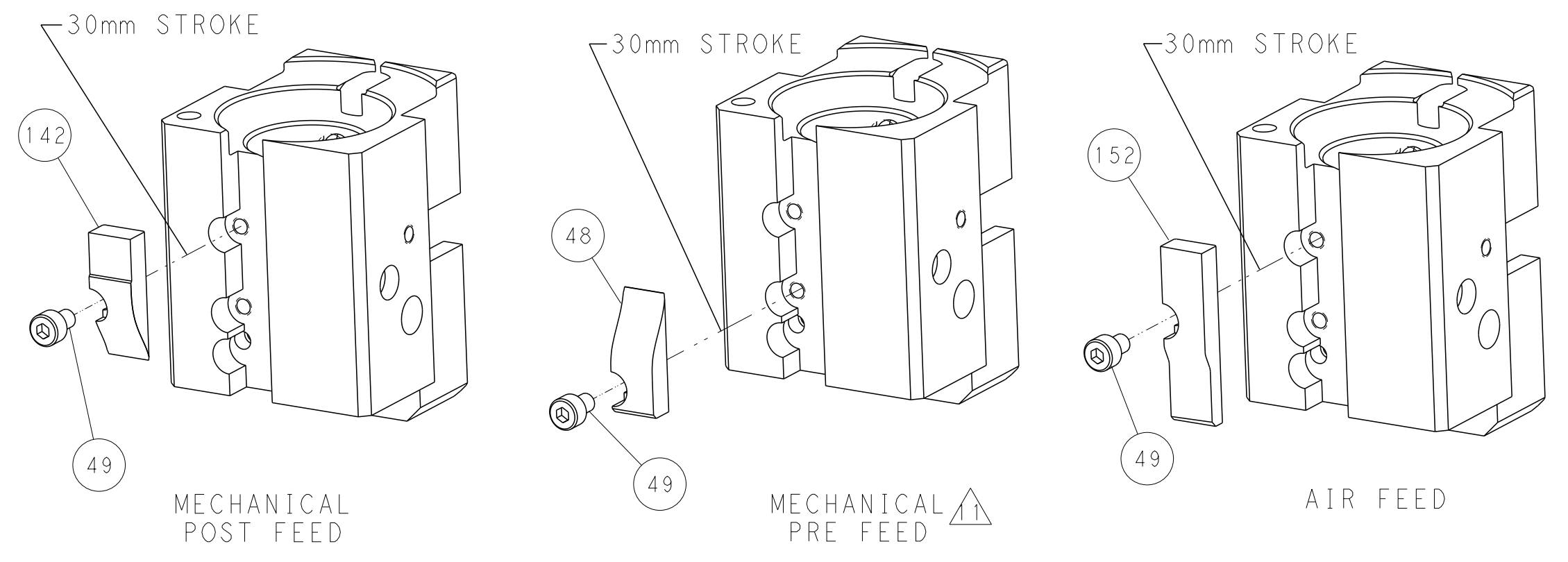
PNEUMATIC



FEED SPRING
SETTING POSITION



CAM POSITIONS



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 C. CHEN 07MAR2012 CHK S. XI 07MAR2012 APVD J. CRUZ 07MAR2012 PRODUCT SPEC APPLICATION SPEC WEIGHT Customer Accessible Production Drawing | | NAME Ocean End Feed Applicator SIZE CAGE CODE DRAWING NO A1 00779 C=2150196 SCALE 1:1 SHEET 4 OF 4 REV E | | STE TE Connectivity Harrisburg, PA 17105-3608 RESTRICTED TO | |
|-----------------------|--|---|--|--|--|--|--|---|--|