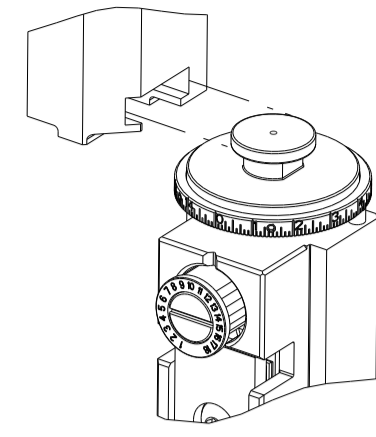


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150017-1	K	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2150017-2	K	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150017-1	K	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2150017-2	K	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150017-7	K	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.78 mm [.070]	F
INSUL	3.30 mm [.130]	OVL
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: .110 SERIES FASTON RECEPTACLE			
WIRE STRIP LENGTH 3.90-4.70 mm [.154-.185 IN]	INSULATION DIAMETER RANGE Ø2.03-3.04 mm [.080-.120 IN]		
TERMINAL APPLICATION SPECIFICATION 114-3118			

TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
160655-1	160729-5	626042-1	881507-1
160655-2	160729-8	626042-2	881507-2
160655-3	626041-1	881506-1	881507-5
160655-4	626041-2	881506-2	881507-6
160655-5		881506-3	881507-7
160655-6		881506-5	
1-160655-1		881506-6	

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: .110 SERIES FASTON RECEPTACLE			
WIRE STRIP LENGTH 3.90-4.70 mm [.154-.185 IN]	INSULATION DIAMETER RANGE Ø2.03-3.04 mm [.080-.120 IN]		
TERMINAL APPLICATION SPECIFICATION 114-3118			

TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
160684-2	160684-4		
160684-3	160684-7		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.50mm2	1.38+/-0.05 [.054+/-0.002]	5.2
1.00mm2	1.30+/-0.05 [.051+/-0.002]	6.0
0.75mm2	1.20+/-0.05 [.047+/-0.002]	7.0
0.50mm2	1.10+/-0.05 [.043+/-0.002]	8.0

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.00mm2	1.30+/-0.05 [.051+/-0.002]	6.0
0.75mm2	1.20+/-0.05 [.047+/-0.002]	7.0
0.50mm2	1.10+/-0.05 [.043+/-0.002]	8.0

- RECOMMENDED SPARE PARTS
- REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 50. 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.

***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.

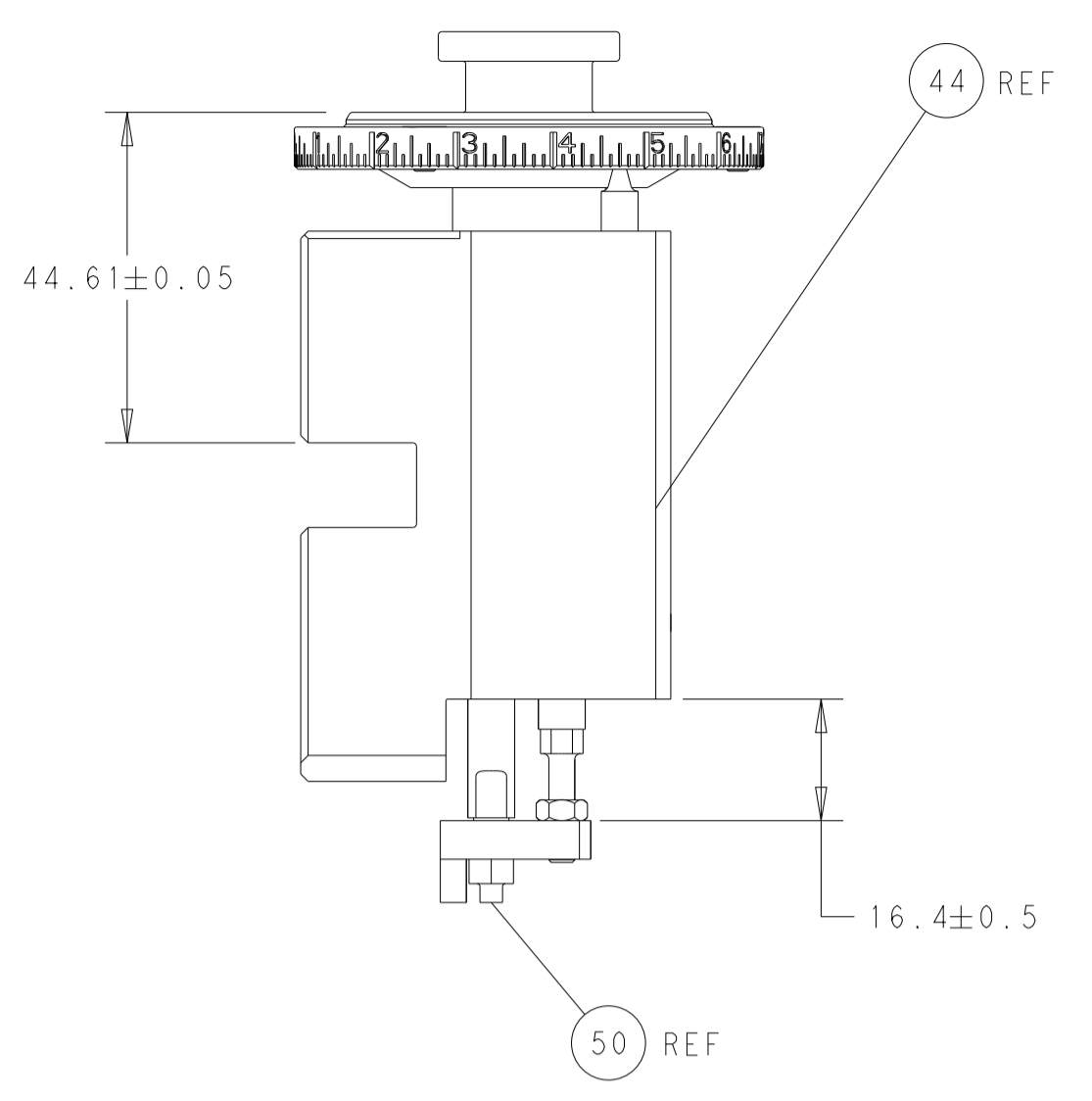
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		H		ECR-20-014401	12OCT2020	FZ	TE
		J		ECR-21-000684	19JAN2021	TB	TE
		K		ECR-22-160901	12DEC2022	FZ	TE

-	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	2119955-2	ASSY, LUBRICATOR, END FEED	84	
-	1	1	1	1	455888-4	SPACER, CRIMPER	82	
-	1	1	1	1	2119791-5	DEPRESSOR, WIRE	73	
-	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	
-	1	1	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59	
-	-	1	-	1	2063961-8	FEED FINGER	58	
-	3	3	3	3	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57	
-	2	2	2	2	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	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	-	2063961-8	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	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	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	1752371-3	PLATE, STRIP GUIDE	24	
-	1	1	1	1	240825-1	PLATE, STRIP HOLD DOWN	23	
-	2	2	2	2	2-22281-3	SPRING, COMPRESSION	22	
-	1	1	1	1	1803292-1	DRAG	20	
-	2	2	2	2	1901259-3	GUIDE, LOWER STRIP	18	
-	4	4	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17	
-	1	1	1	1	3-240641-9	SPACER	16	
-	1	1	1	1	1752360-1	SPACER,HOLD-DOWN	13	
-	1	1	1	1	240833-4	PLATE, REAR SHEAR	11	
-	2	2	2	2	1-240645-0	SPACER, SHEAR PLATE	10	
-	1	1	1	1	240642-2	PLATE, FRONT SHEAR	9	
-	1	2	2	1	1338686-3	ANVIL, COMBINATION	8	
-	1	1	1	1	9-240651-6	BLADE, SLUG	7	
-	1	1	1	1	240641-6	SPACER	5	
-	1	1	1	1	238011-7	BLOCK, CRIMPER SPACER	4	
-	1	2	2	1	9-1633963-0	CRIMPER, INSULATION OVERLAP PREMIUM	3	
-	-	-	-	-	-	-	2	
-	1	2	2	1	1-456404-8	CRIMPER, WIRE PREMIUM	1	
-	77	72	71	2	-1	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)

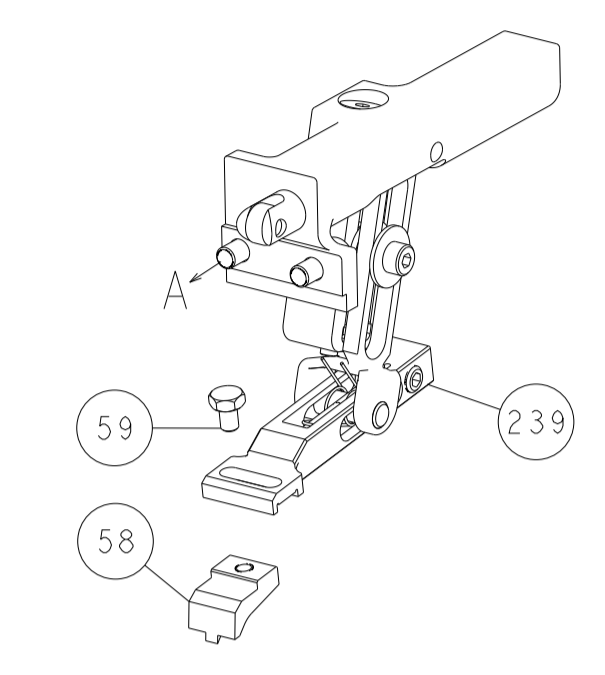
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DRAWING NO	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±
mm	ANGLES ±				
MATERIAL	FINISH	WEIGHT	SCALE	SHEET	REV
			1:1	1 OF 4	K

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

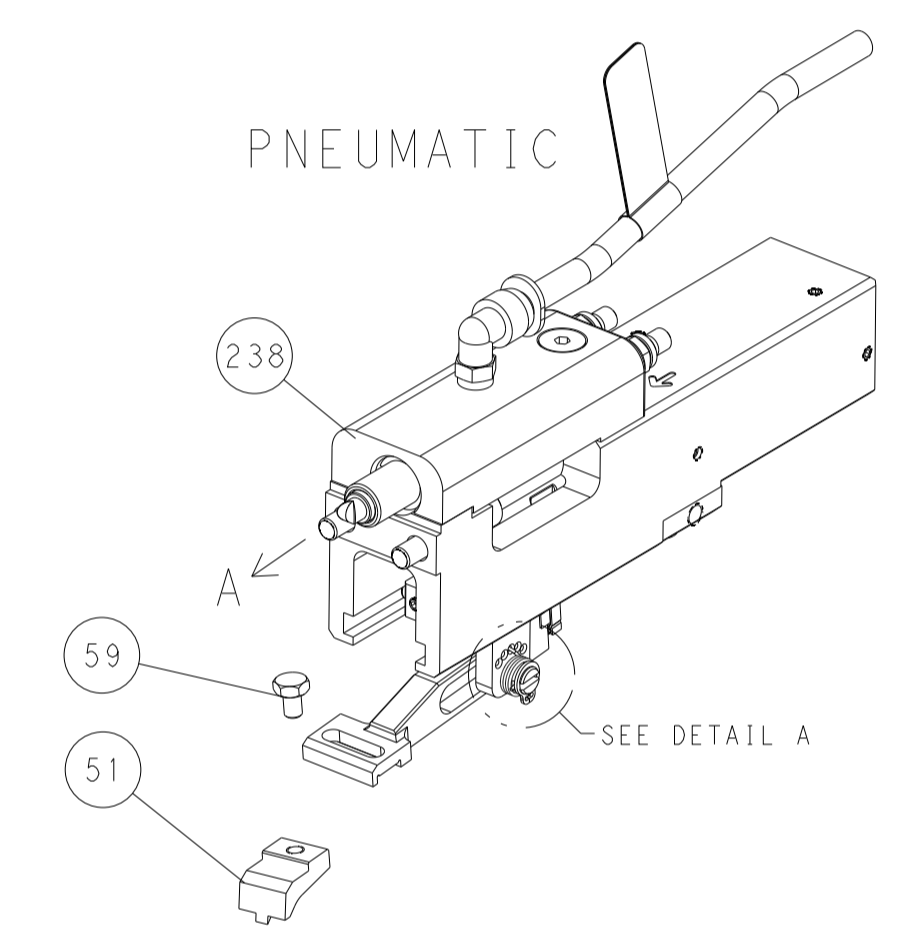


RAM AND HOLDDOWN SET-UP

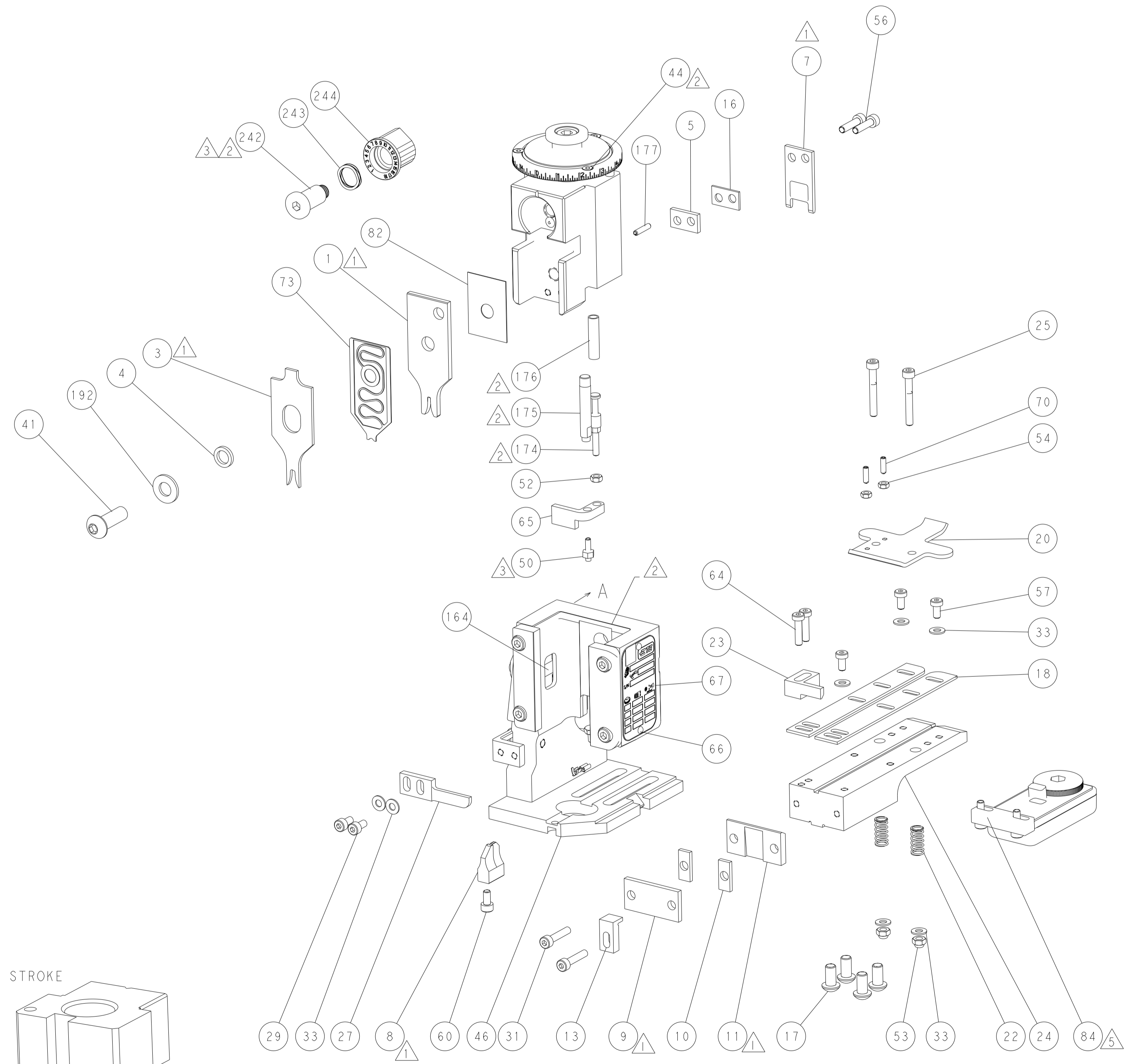
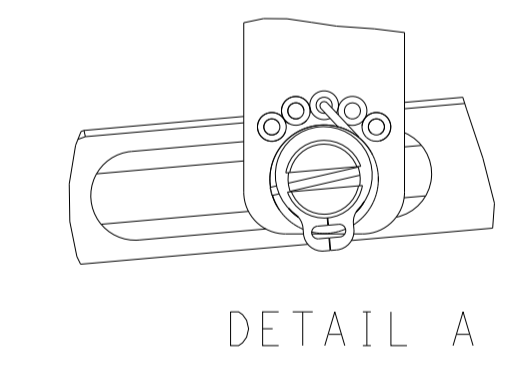
FEED TYPE
MECHANICAL



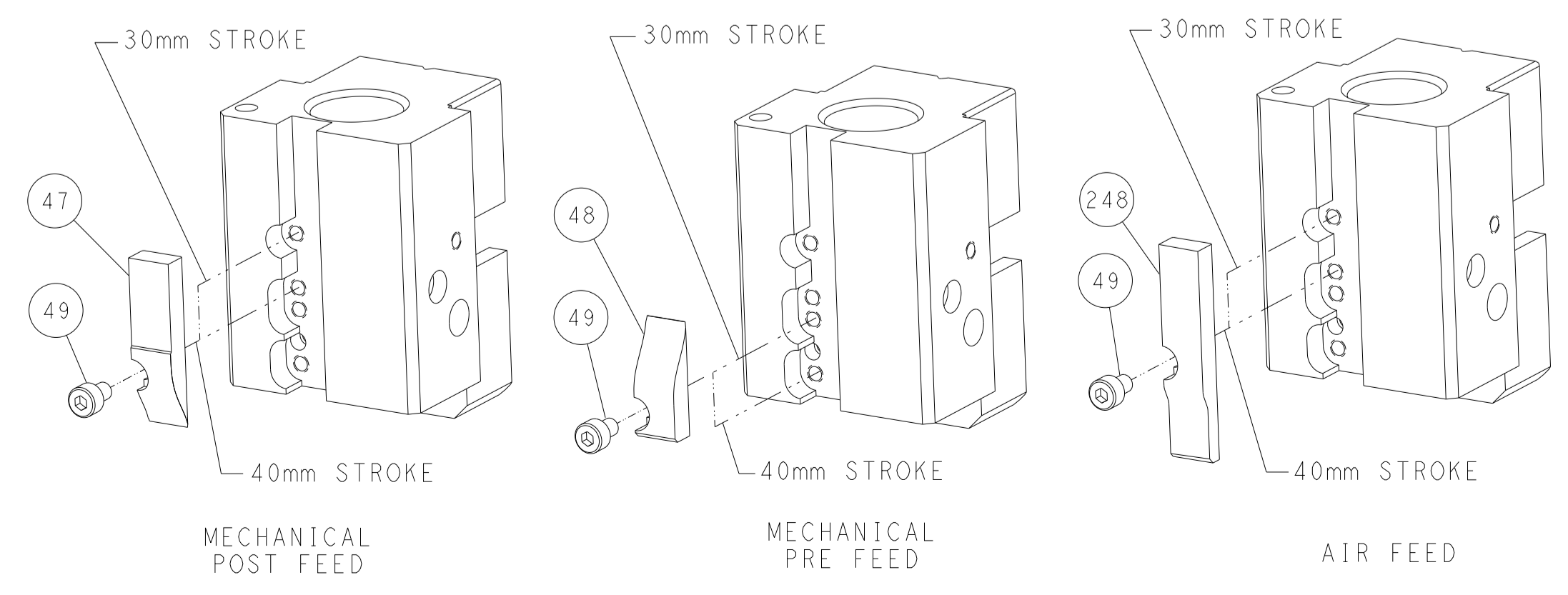
PNEUMATIC



FEED SPRING
SETTING POSITION



CAM POSITIONS

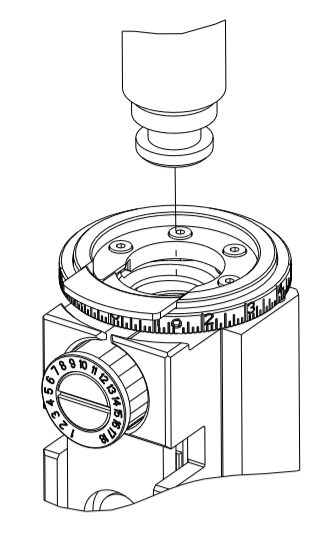


ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH		DWN Y. YIN 30DEC2011 CHK G. BAILEY 30DEC2011 APVD S. XI 30DEC2011 NAME Ocean End Feed Applicator SIZE CAGE CODE DRAWING NO RESTRICTED TO A 00779 ©=2150017 Customer Accessible Production Drawing SCALE 1:1 SHEET 2 of 4 REV K	
THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.				TE Connectivity Harrisburg, PA 17105-3608	

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150017-1	K	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2150017-2	K	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150017-7	K	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
 INTERFACE ADAPTER



APPLICATOR DATA

CRIMP	SIZE	TYPE
WIRE	1.78 mm (.070)	F
INSUL	3.30 mm (.130)	OVL

APPL INSTRUCTIONS
 408-35043

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION

TERMINAL NAME: .110 SERIES FASTON RECEPTACLE

WIRE STRIP LENGTH	INSULATION DIAMETER RANGE
3.90-4.70 mm (.154-.185 IN)	Ø2.03-3.04 mm (.080-.120 IN)

TERMINAL APPLICATION SPECIFICATION 114-3118

TERMINALS APPLIED

TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
160655-1	160729-5	626042-1	881507-1
160655-2	160729-8	626042-2	881507-2
160655-3	626041-1	881506-1	881507-5
160655-4	626041-2	881506-2	881507-6
160655-5		881506-3	881507-7
160655-6		881506-5	
1-160655-1		881506-6	

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION

TERMINAL NAME: .110 SERIES FASTON RECEPTACLE

WIRE STRIP LENGTH	INSULATION DIAMETER RANGE
3.90-4.70 mm (.154-.185 IN)	Ø2.03-3.04 mm (.080-.120 IN)

TERMINAL APPLICATION SPECIFICATION 114-3118

TERMINALS APPLIED

TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
160684-2	160684-4		
160684-3	160684-7		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.50mm2	1.38+/-0.05 [.054+/-0.002]	5.2
1.00mm2	1.30+/-0.05 [.051+/-0.002]	6.0
0.75mm2	1.20+/-0.05 [.047+/-0.002]	7.0
0.50mm2	1.10+/-0.05 [.043+/-0.002]	8.0

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.00mm2	1.30+/-0.05 [.051+/-0.002]	6.0
0.75mm2	1.20+/-0.05 [.047+/-0.002]	7.0
0.50mm2	1.10+/-0.05 [.043+/-0.002]	8.0

***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.

- 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 50. 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 LUBRICANT IS RECOMMENDED.
- 6 UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.

LOC	DIST	REV	DATE	BY	APPD
A	66	-	-	-	-

REV	DATE	BY	APPD	DESCRIPTION	ITEM NO	
-	1	1		2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1		2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
3	-	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
-	REFREF			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
5	-	1		2119955-2	ASSY, LUBRICATOR, END FEED	84
-	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		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
-	1	1		5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	-	1		2063961-8	FEED FINGER	58
-	3	3		2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57
-	2	2		2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	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	-		2063961-8	FEED FINGER	51
3	-	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		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		1752371-3	PLATE, STRIP GUIDE	24
-	1	1		240825-1	PLATE, STRIP HOLD DOWN	23
-	2	2		2-22281-3	SPRING, COMPRESSION	22
-	1	1		1803292-1	DRAG	20
-	2	2		1901259-3	GUIDE, LOWER STRIP	18
-	1	1		3-240641-9	SPACER	16
-	1	1		1752360-1	SPACER,HOLD-DOWN	13
1	-	1		240833-4	PLATE, REAR SHEAR	11
-	2	2		1-240645-0	SPACER, SHEAR PLATE	10
1	-	1		240642-2	PLATE, FRONT SHEAR	9
1	1	1		1338686-3	ANVIL, COMBINATION	8
1	-	1		9-240651-6	BLADE, SLUG	7
-	1	1		240641-6	SPACER	5
-	1	1		238011-7	BLOCK, CRIMPER SPACER	4
1	1	1		9-1633963-0	CRIMPER, INSULATION OVERLAP PREMIUM	3
-	-	-		-	-	2
1	1	1		1-456404-8	CRIMPER, WIRE PREMIUM	1
-	-	-		-	-	-
-	77-22-21			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)

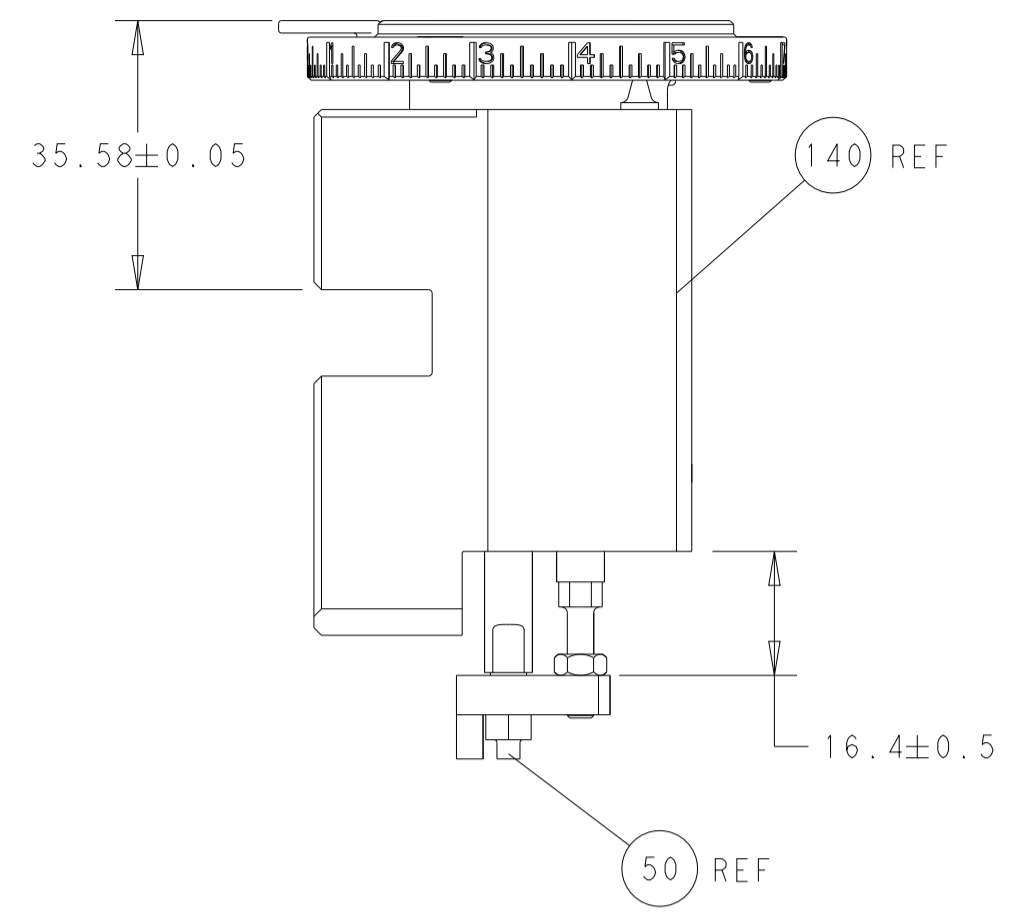
TE Connectivity
 Harrisburg, PA 17105-3608

Ocean End Feed
 Applicator

Customer Accessible Production Drawing

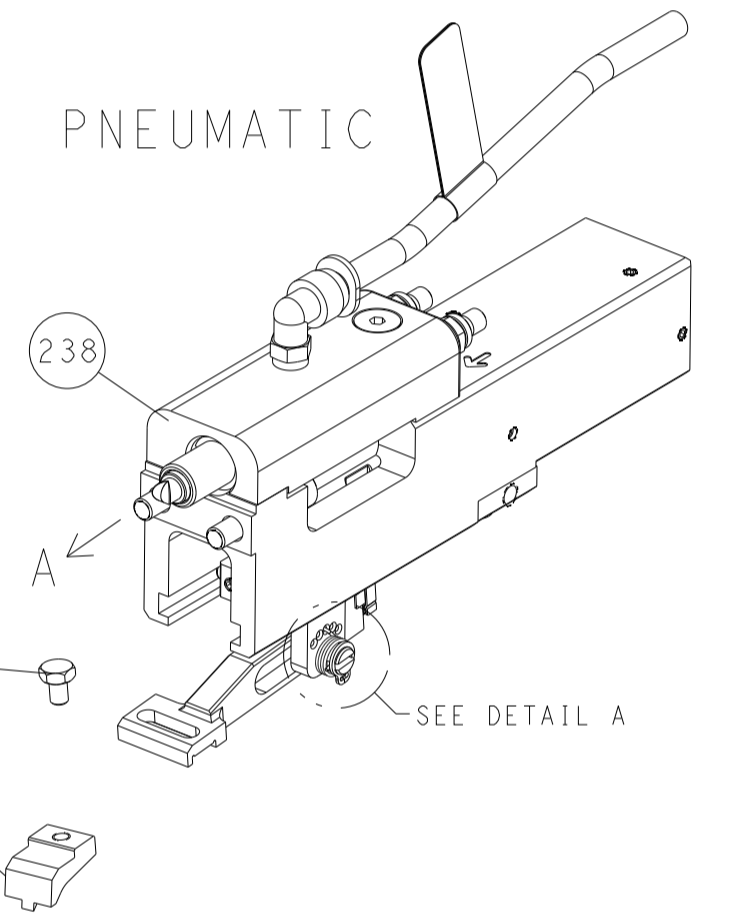
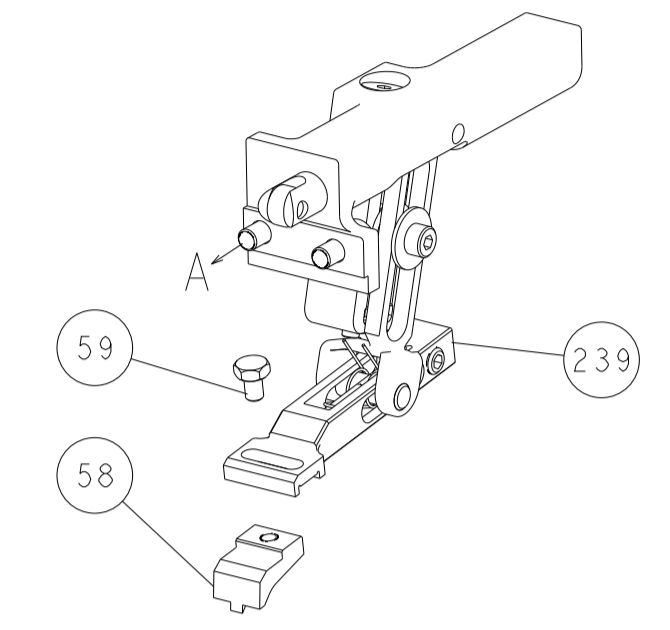
SCALE 1:1 SHEET 3 OF 4 REV K

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

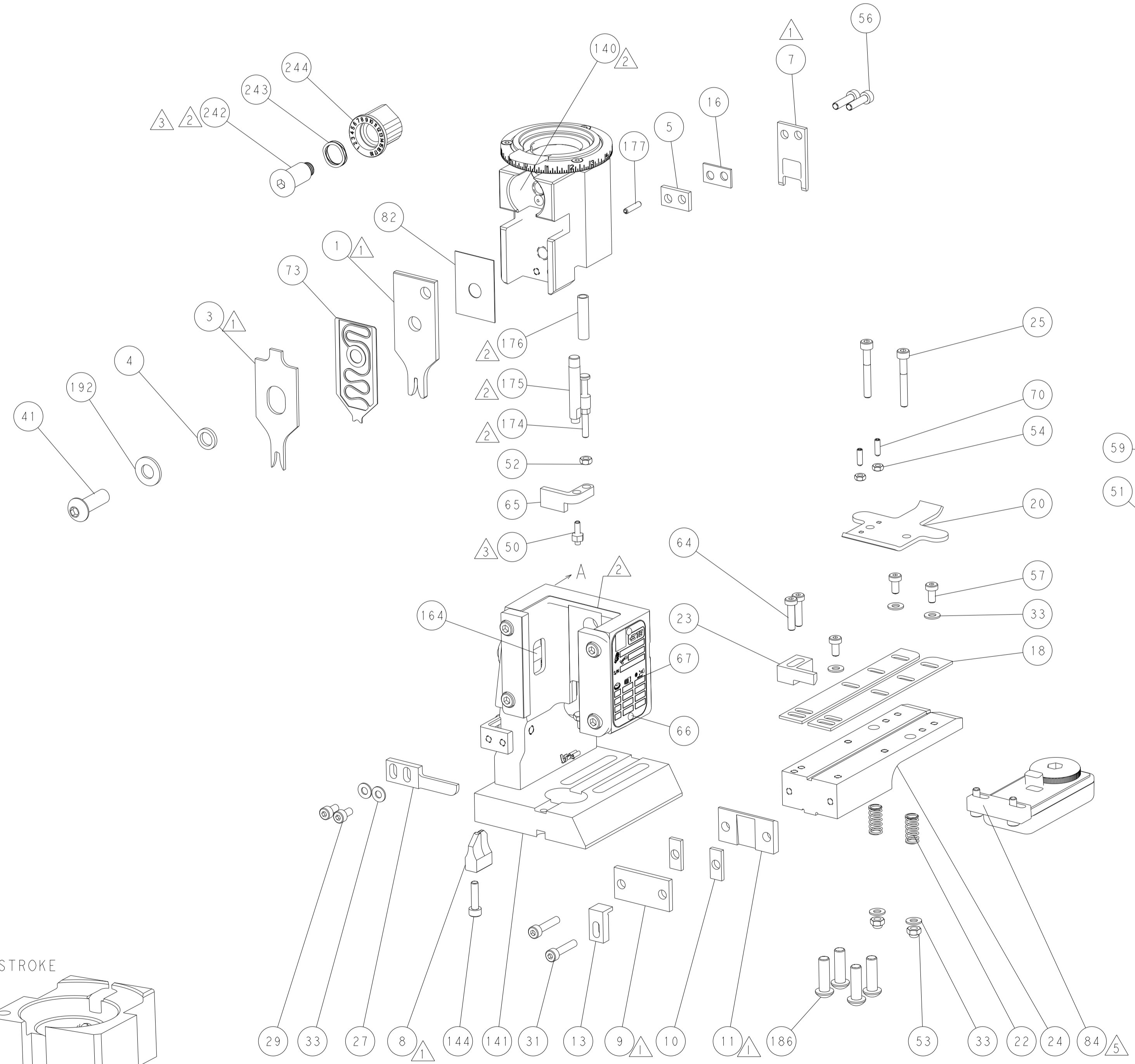
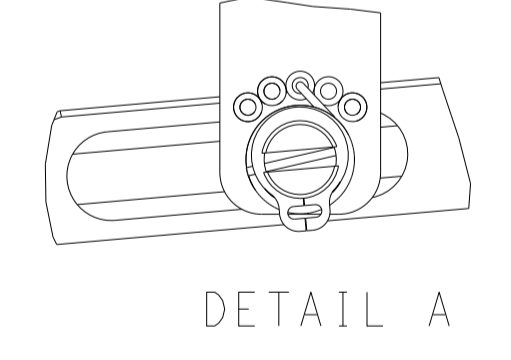


RAM AND HOLDDOWN SET-UP

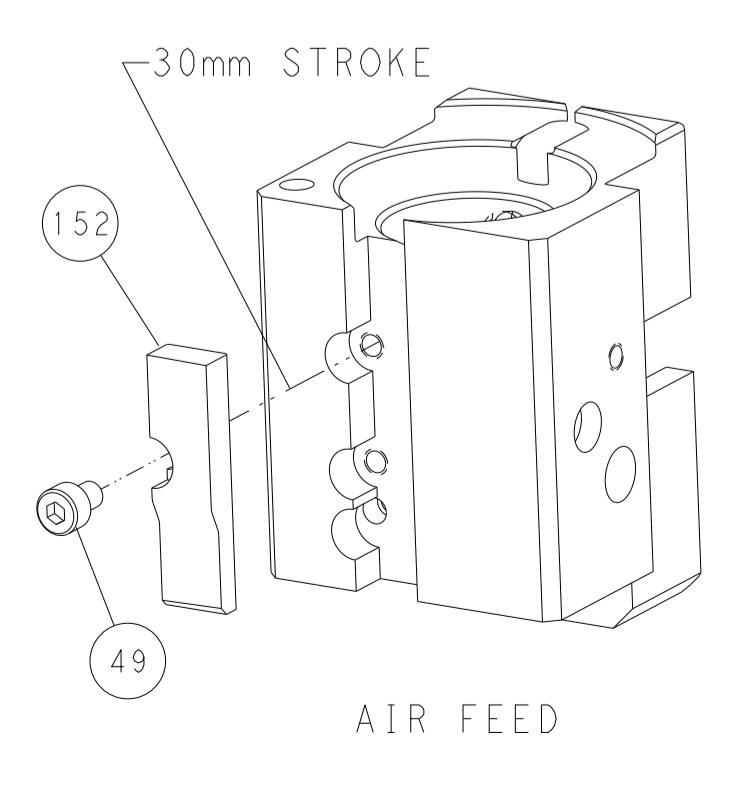
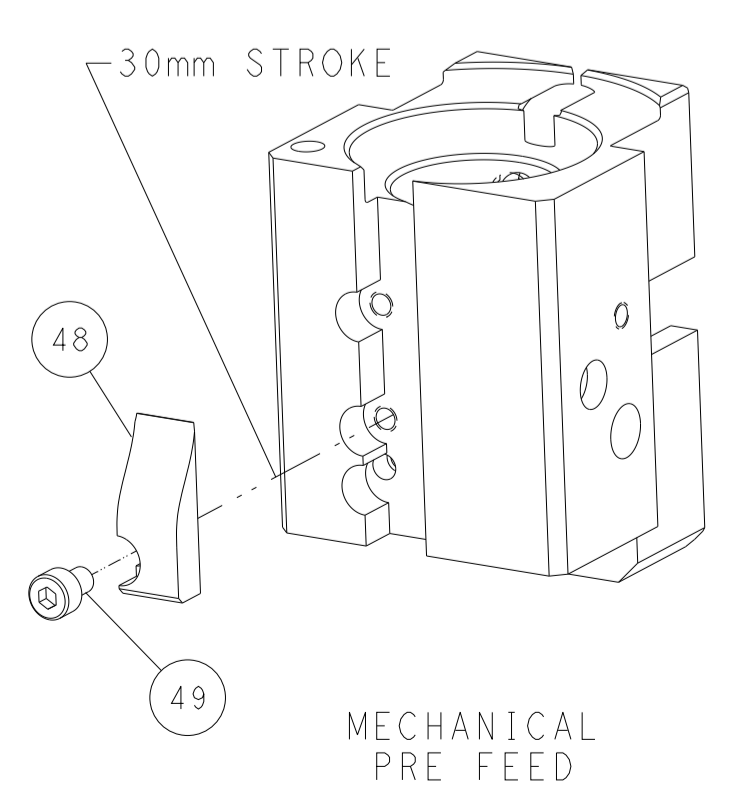
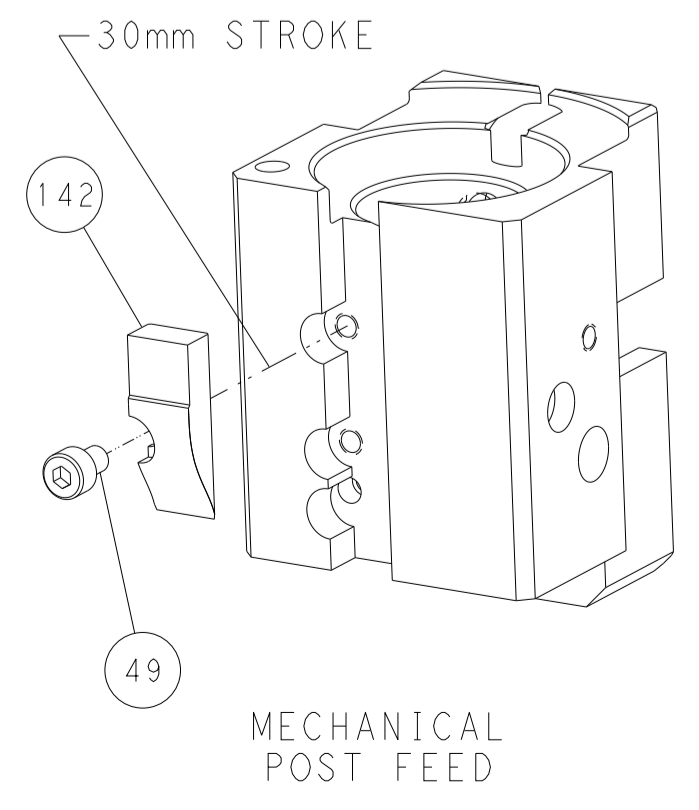
FEED TYPE
MECHANICAL



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:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN Y. YIN 30DEC2011		STE TE Connectivity	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	5 PLC ±	Harrisburg, PA 17105-3608
MATERIAL:	FINISH:	WEIGHT:	SCALE:	APVD: S. XI 30DEC2011	NAME:	RESTRICTED TO:	
			1:1		Ocean End Feed Applicator		
					Customer Accessible Production Drawing		