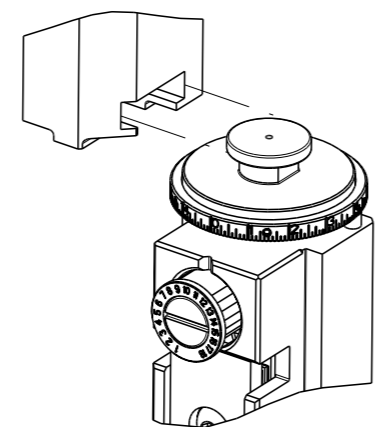


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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150341-2	D	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150341-2	D	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150341-7	B	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	5.40 mm [.213]	F
INSUL	7.31 mm [.288]	F
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL PRONER CRIMP SPECIFICATION	
TERMINAL NAME: CLIP, 8mm, INDENTED SAFETY	
WIRE STRIP LENGTH 5.55-6.31 mm [.219-.248 IN]	INSULATION DIAMETER RANGE Ø3.90-6.30 mm [.154-.248 IN]
TERMINAL APPLICATION SPECIFICATION 10226 Rev B	
TERMINALS APPLIED	
TE TERMINAL	TE TERMINAL
1544142-1	

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
10mm ²	3.95 +/- 0.05 [.156 +/- .002]	2.2
10mm ² FLRY or FLY	3.52 +/- 0.05 [.139 +/- .002]	8.1
7mm ²	3.41 +/- 0.05 [.134 +/- .002]	8.0
3mm ² +3mm ²	3.21 +/- 0.05 [.126 +/- .002]	10.7

- 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.
- UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- CRIMP HEIGHT IS FOR 10mm² FLRY & FLY WIRE ONLY.

***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.

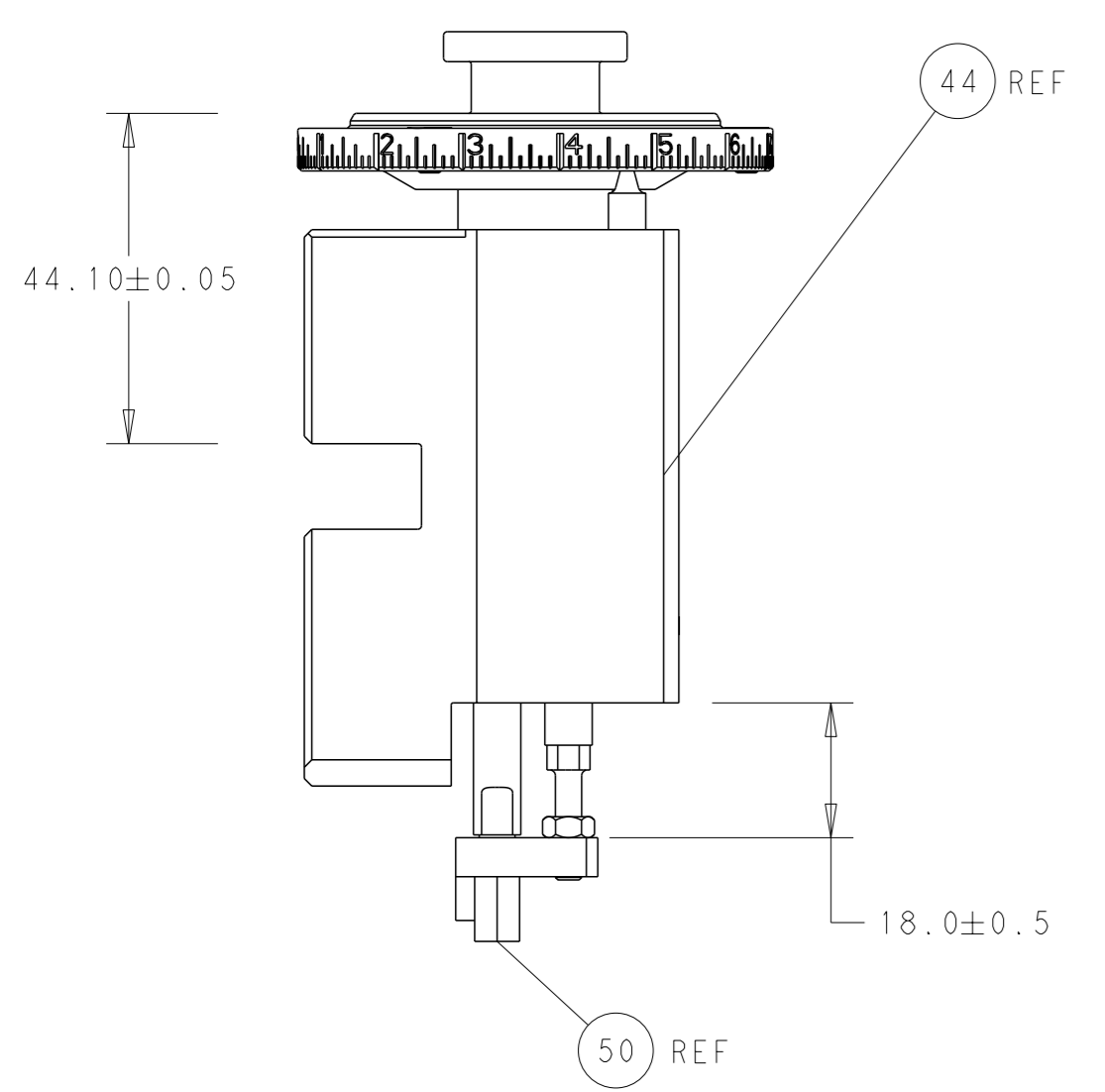
LOC	DIST	REVISIONS					
A	66	P	LYR	DESCRIPTION	DATE	OWN	APVD
		B		ECR-14-000499	25JAN2014	RK	GB
		C		ECR-20-014167	06OCT2020	JAH	RK
		D		ECR-20-016165	12NOV2020	JWC	RK

-	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	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	1	6-9931111-6	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	1	2-1976053-5	LOCATER BLOCK,TERMINAL	86	
-	2	2	1-2079383-0	SCR, BHSC, RoHS (M3 X 6)	85	
-	1	1	455888-4	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	1901681-4	HOLDDOWN, TERMINAL	65	
-	2	2	2168400-5	SHCS, LOW HEAD, RoHS, M4 X 20	64	
-	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	
-	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	1	2063961-9	FEED FINGER	51	
-	1	1	1-1752354-9	STANDOFF,HOLD-DOWN	50	
-	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	
-	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	690455-8	STRIPPER, FRONT CASTING	27	
-	2	2	1-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 30	25	
-	1	1	1752371-8	PLATE, STRIP GUIDE	24	
-	1	1	240825-8	PLATE, STRIP HOLD DOWN	23	
-	2	2	22281-8	SPRING, COMPRESSION	22	
-	1	1	1803292-4	DRAG	20	
-	2	2	1901259-9	GUIDE, LOWER STRIP	18	
-	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17	
-	1	1	1752360-1	SPACER,HOLD-DOWN	13	
-	1	1	240833-4	PLATE, REAR SHEAR	11	
-	-	-	-	-	10	
-	1	1	4-690495-8	PLATE, FRONT SHEAR	9	
-	1	2	1	2-1803001-2	ANVIL, COMBINATION, END FEED	8
-	1	1	2217206-8	BLADE, SLUG	7	
-	-	-	-	-	6	
-	1	1	7-240641-7	SPACER	5	
-	1	1	238011-3	BLOCK, CRIMPER SPACER	4	
-	1	2	1	2-1803017-0	CRIMPER, INSULATION F	3
-	1	1	1-455888-3	SPACER, CRIMPER	2	
-	1	2	1	2-1633860-0	CRIMPER, WIRE	1
-	77	72	2	PART NO	DESCRIPTION	ITEM NO

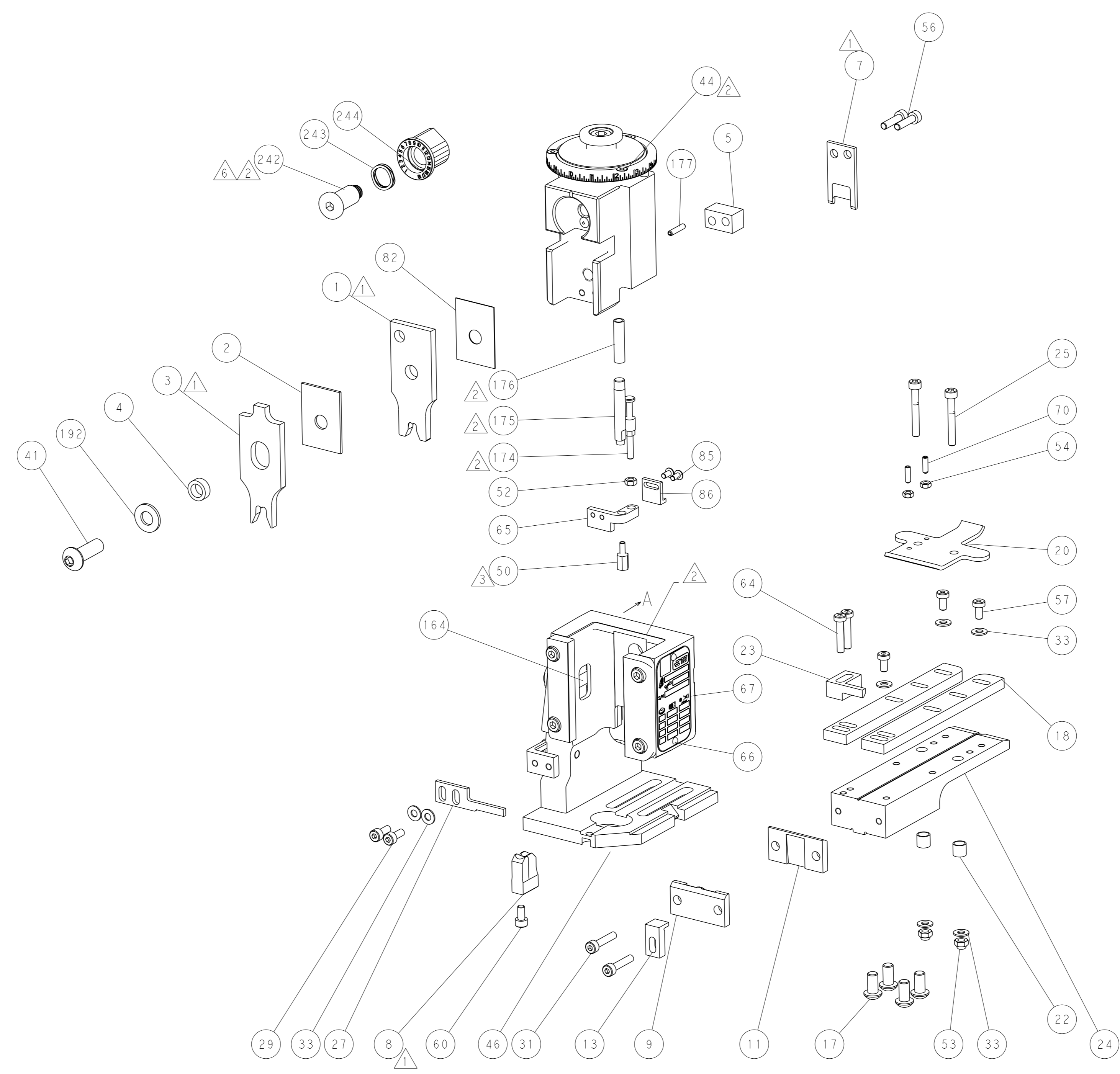
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN BOB HIGMAN 12JUN2013		TE Connectivity	
0 PLC	±	1 PLC	±	CHK T. ELBIN 12JUN2013	Harrisburg, PA 17105-3608		
2 PLC	±	3 PLC	±	APVD M. CLIFFORD 12JUN2013	NAME		
4 PLC	±	FINISH	±	PRODUCT SPEC	OCEAN END FEED APPLICATOR		
MATERIAL				WEIGHT		RESTRICTED TO	
Customer Accessible Production Drawing				SCALE 1:1		SHEET 1 OF 4	

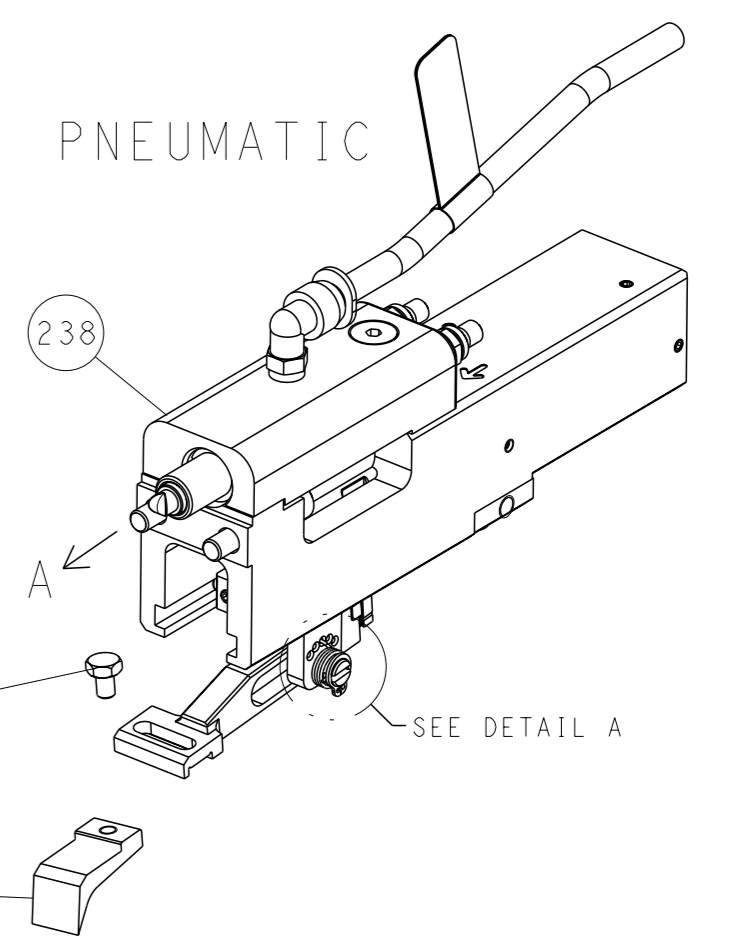
LOC	DIST	REVISIONS				
A	66	REV	DESCRIPTION	DATE	OWN	APVD
		-	SEE SHEET 1	-	-	-



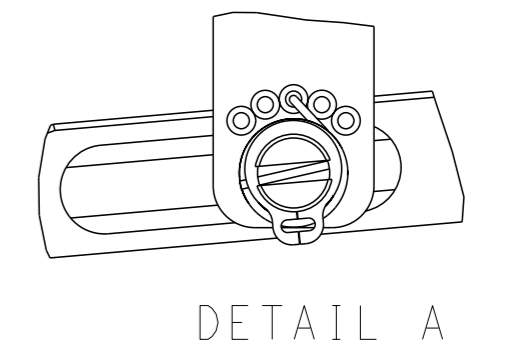
RAM AND HOLDDOWN SET-UP



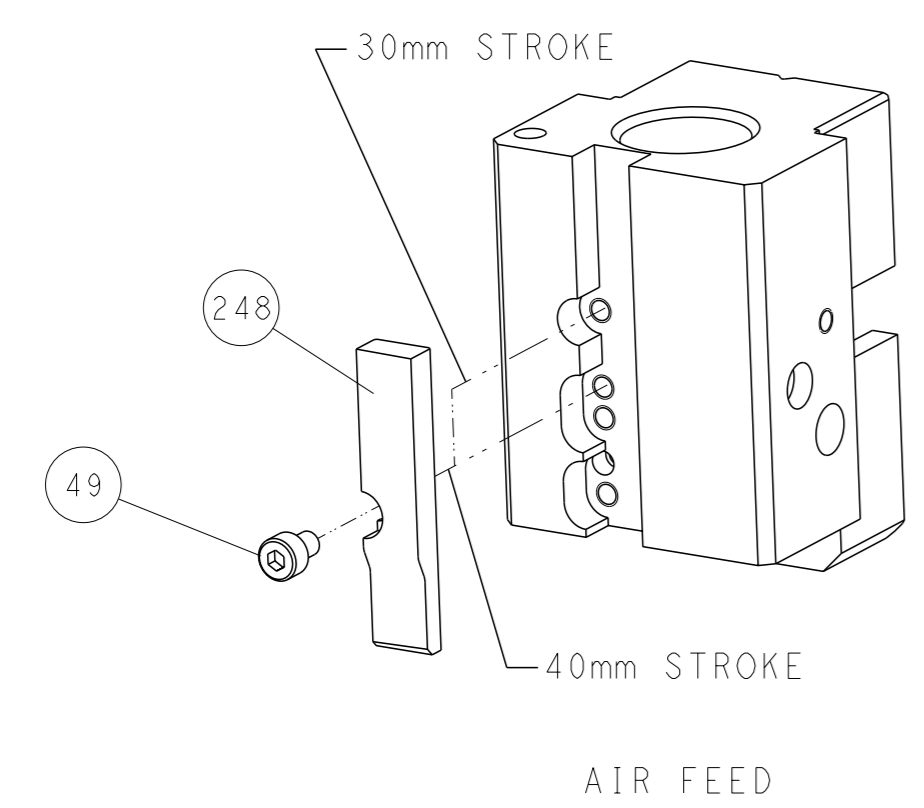
FEED TYPE



FEED SPRING SETTING POSITION



CAM POSITION



AIR FEED

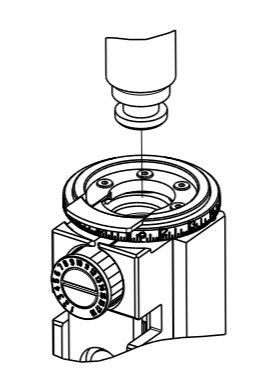
ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

<small>THIS DRAWING IS A CONTROLLED DOCUMENT FROM TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE AND ITS CONTENTS AND EXISTING DESIGNATION SHOULD BE CONTACTED FOR THE LATEST REVISION.</small>		DWN BOB HIGMAN 12JUN2013 CHK T. ELBIN 12JUN2013 APVD M. CLIFFORD 12JUN2013 PRODUCT SPEC APPLICATION SPEC	NAME OCEAN END FEED APPLICATOR
DIMENSIONS: mm 	TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH ±	SIZE CAGE CODE DRAWING NO A1 00779 C=2150341	RESTRICTED TO -
MATERIAL	FINISH	WEIGHT	SCALE 1:1 SHEET 2 OF 4 REV D

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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150341-2	D	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150341-7	B	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
 INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	5.40 mm [.213]	F
INSUL	7.31 mm [.288]	F
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL PRONER CRIMP SPECIFICATION			
TERMINAL NAME: CLIP, 8mm, INDENTED SAFETY			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
5.55-6.31 mm [.219-.248 IN]		Ø3.90-6.30 mm [1.154-.248 IN]	
TERMINAL APPLICATION SPECIFICATION	10226 Rev B	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
1544142-1			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
10mm ²	3.95 +/- 0.05 [1.156 +/- .002]	2.2
10mm ² FLY or FLY	3.52 +/- 0.05 [1.139 +/- .002]	8.1
7mm ²	3.41 +/- 0.05 [1.134 +/- .002]	8.0
3mm ² +3mm ²	3.21 +/- 0.05 [1.126 +/- .002]	10.7

- 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.
- 5. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- CRIMP HEIGHT IS FOR 10mm² FLY & FLY WIRE ONLY.

***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	LY#	DESCRIPTION	DATE	OWN	APVD
A	66	-	-	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	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	2-1976053-5	LOCATER BLOCK, TERMINAL	86
-	2	1-2079383-0	SCR, BHSC, RoHS (M3 X 6)	85
-	1	455888-4	SPACER, CRIMPER	82
-	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	1901681-4	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	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	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	1-1752354-9	STANDOFF, HOLD-DOWN	50
-	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	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	31
-	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	29
-	1	690455-8	STRIPPER, FRONT CASTING	27
-	2	1-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 30	25
-	1	1752371-8	PLATE, STRIP GUIDE	24
-	1	240825-8	PLATE, STRIP HOLD DOWN	23
-	2	22281-8	SPRING, COMPRESSION	22
-	1	1803292-4	DRAG	20
-	2	1901259-9	GUIDE, LOWER STRIP	18
-	1	1752360-1	SPACER, HOLD-DOWN	13
-	1	240833-4	PLATE, REAR SHEAR	11
-	-	-	-	10
-	1	4-690495-8	PLATE, FRONT SHEAR	9
-	1	2-1803001-2	ANVIL, COMBINATION, END FEED	8
-	1	2217206-8	BLADE, SLUG	7
-	-	-	-	6
-	1	7-240641-7	SPACER	5
-	1	238011-3	BLOCK, CRIMPER SPACER	4
-	1	2-1803017-0	CRIMPER, INSULATION F	3
-	1	1-455888-3	SPACER, CRIMPER	2
-	1	2-1633860-0	CRIMPER, WIRE	1

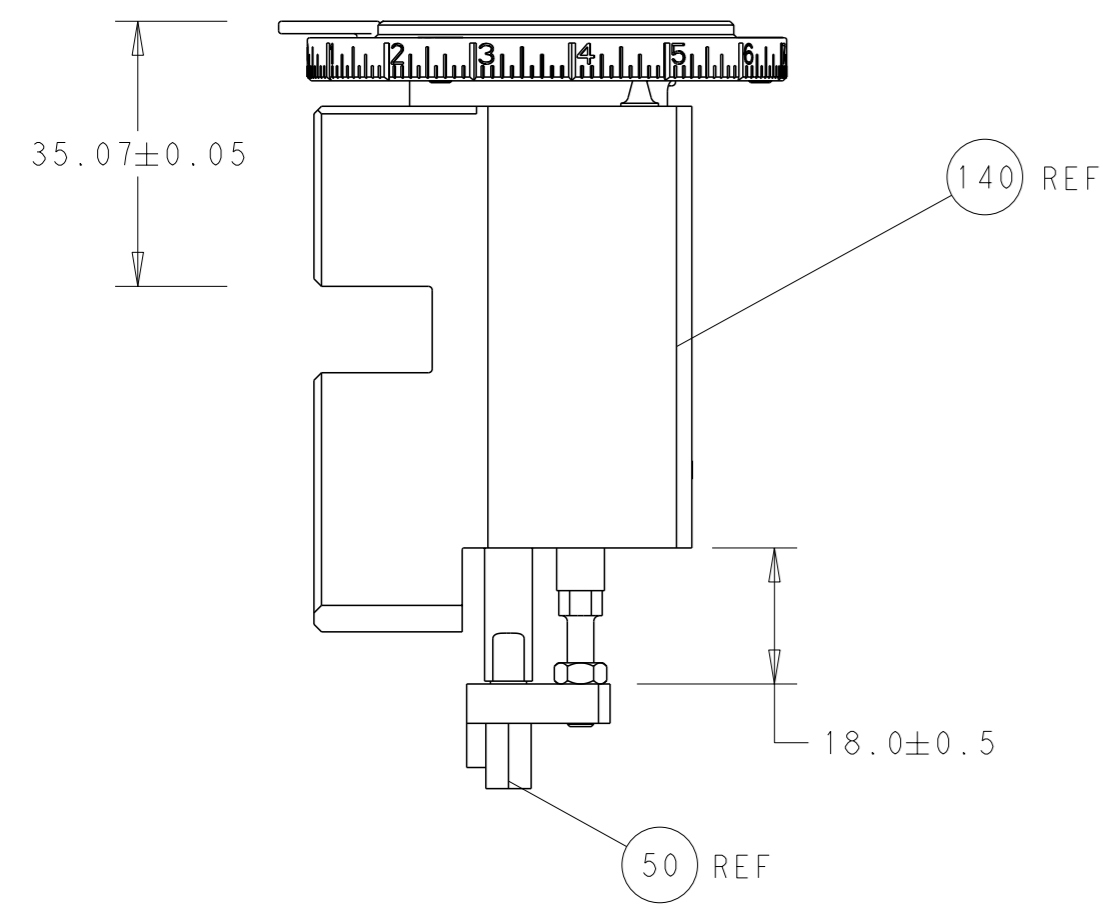
PACIFIC VERSION
 Shown on sheets 3 of 4 & 4 of 4
 (Atlantic version shown on sheets 1 of 4 & 2 of 4)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		APPROVED:		NAME:	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	FINISH	ANGLES
MATERIAL		FINISH		WEIGHT		SCALE	
-		-		-		-	

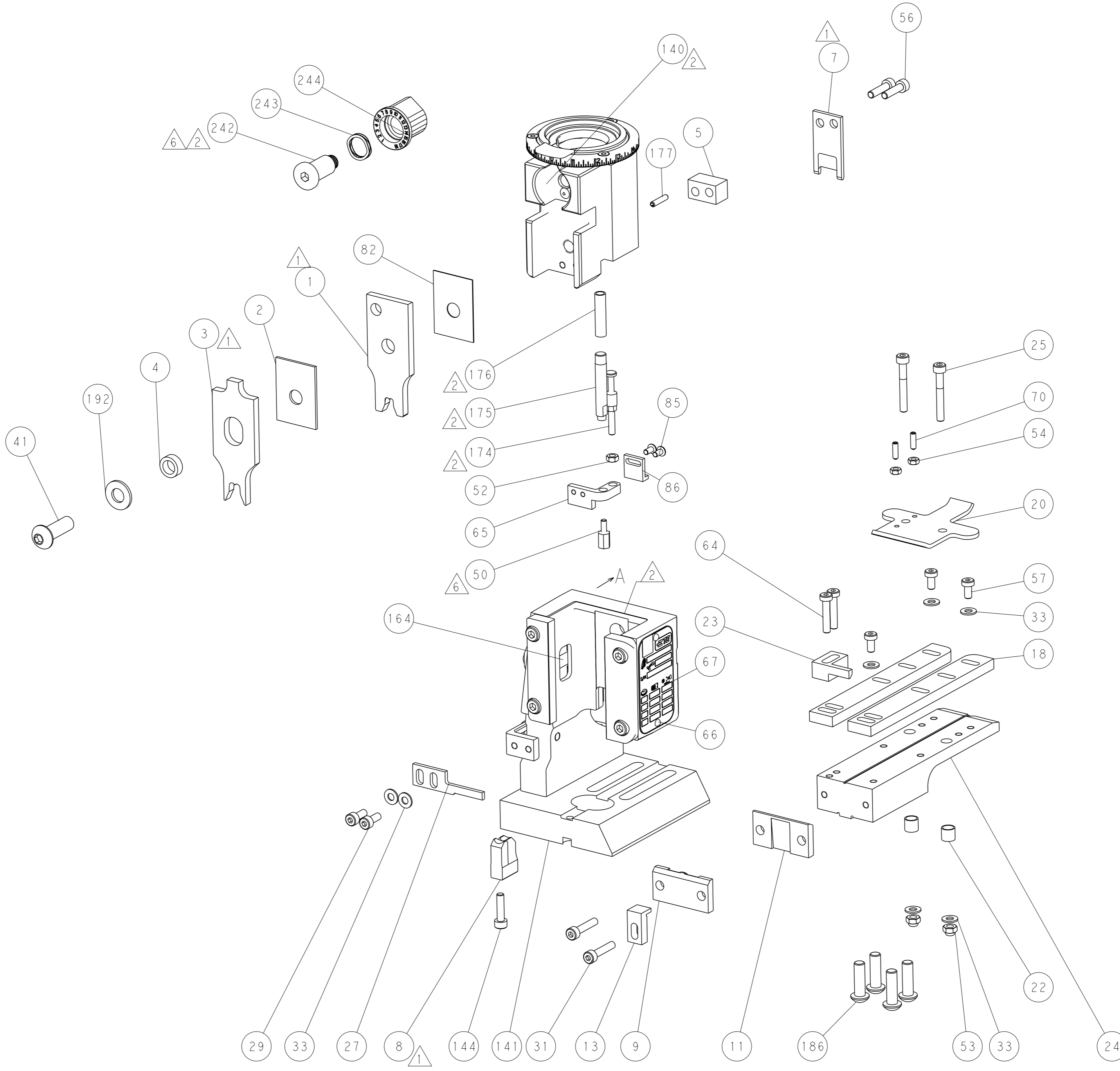
OWN	CHK	DATE	APVD	DATE	NAME	SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
BOB HIGMAN	T. ELBIN	12JUN2013	M. CLIFFORD	12JUN2013	TE Connectivity	A1	00779	2150341	-

Customer Accessible Production Drawing SCALE 1:1 SHEET 3 OF 4 REV D

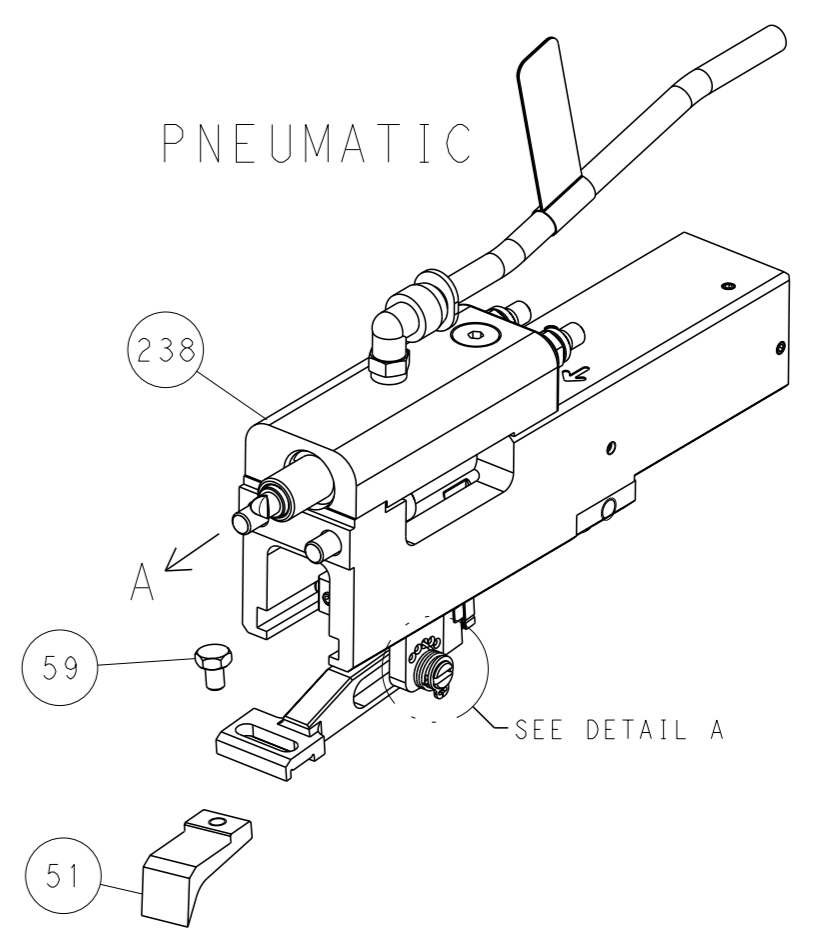
LOC	DIST	REVISIONS			
A	66	REV	DATE	OWN	APVD
		-	SEE SHEET 1	-	-



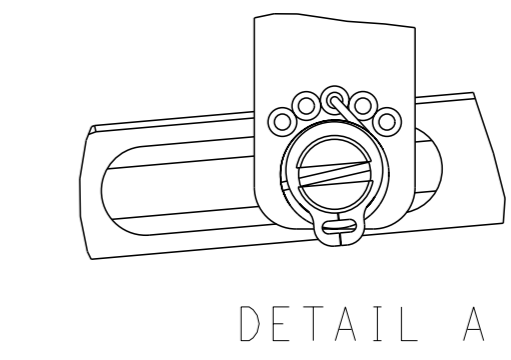
RAM AND HOLDDOWN SET-UP



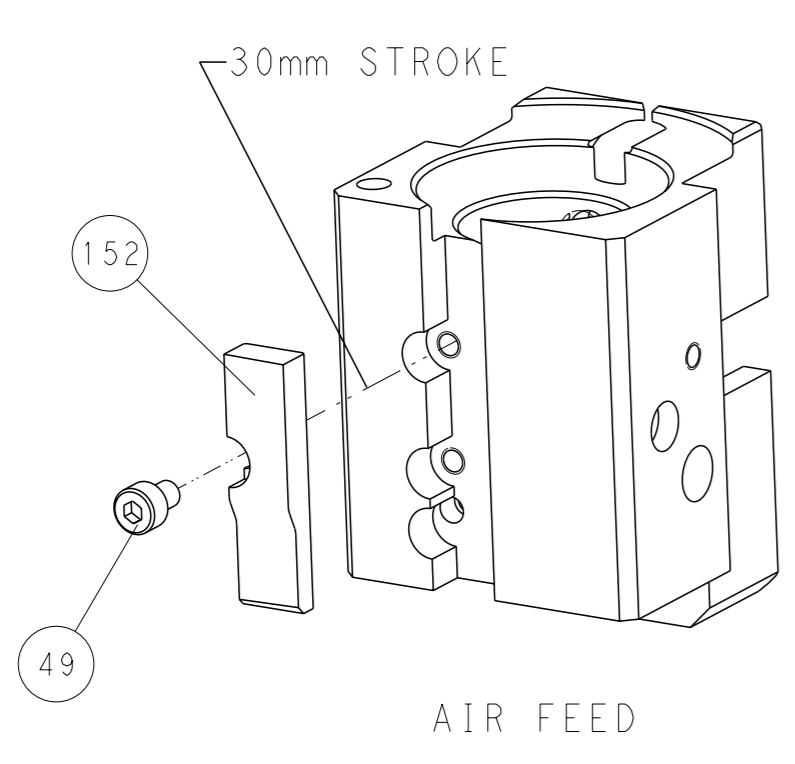
FEED TYPE



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 FINISH ±	PRODUCT SPEC APPLICATION SPEC WEIGHT SCALE 1:1	RESTRICTED TO A 00779 C=2150341 Customer Accessible Production Drawing
MATERIAL:		SHEET 4 OF 4	REV D