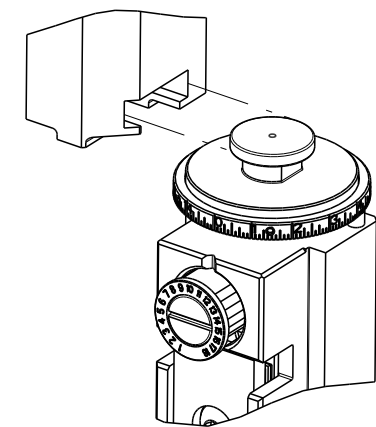


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150282-2	E	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150282-2	E	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150282-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.79 mm [.110]	F
INSUL	3.56 mm [.140]	O

APPLICATOR INSTRUCTIONS 408-35043

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION			
TERMINAL NAME: TERMINAL, RING			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
.204-.234 IN [5.18-5.94 mm]		Ø.070-.100 IN [1.78-2.54 mm]	
TERMINAL APPLICATION SPECIFICATION	114-2084		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
41711	41013	140517	

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
18 AWG OR 0.75mm2	1.96 +/- 0.05 [0.077 +/- .002]	8.7
20 AWG OR 0.50mm2	1.88 +/- 0.05 [0.074 +/- .002]	9.5
22 AWG OR 0.35mm2	1.83 +/- 0.05 [0.072 +/- .002]	10.0

- 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 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.

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

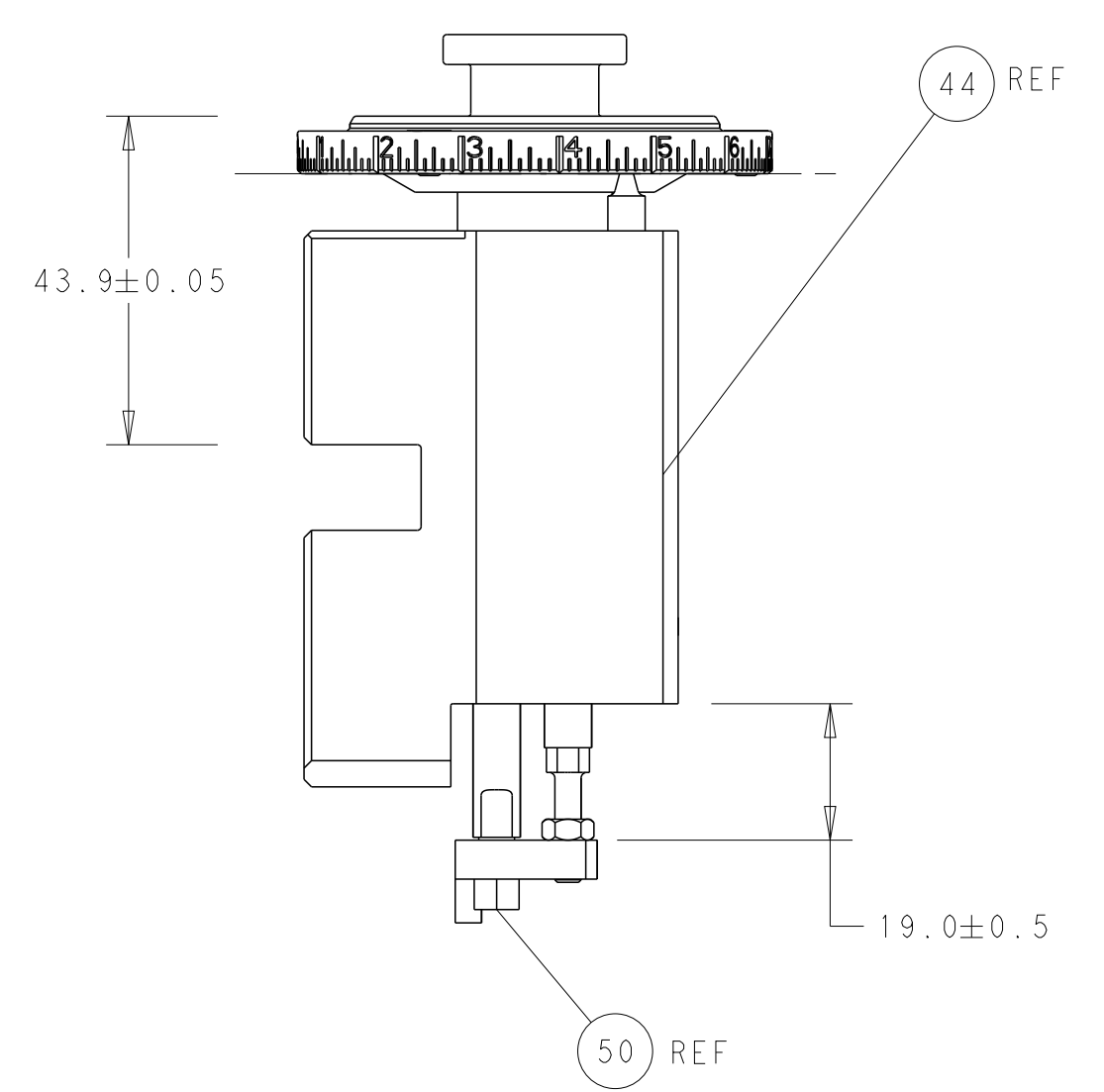
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		C		ECR-18-019965	21DEC2018	JAH	TE
		D		ECR-20-017710	15DEC2020	FZ	TE
		E		ECR-22-144048	28JUN2022	ROY	TLE

-	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	6-993111-6	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	1901681-1	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	2-2168083-6	SCR, SKT HD CAP, RoHS, M4 X 18	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	1752354-1	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		
-	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	1752371-5	PLATE, STRIP GUIDE	24		
-	2	2	2-22281-3	SPRING, COMPRESSION	22		
-	1	1	1803292-1	DRAG	20		
-	1	1	1901696-3	STRIP GUIDE, REAR	19		
-	1	1	1901695-3	STRIP GUIDE, FRONT	18		
-	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17		
-	1	1	1752360-1	SPACER,HOLD-DOWN	13		
-	1	1	240644-1	PLATE, REAR SHEAR	11		
-	2	2	1-240645-0	SPACER, SHEAR PLATE	10		
-	1	1	240642-1	PLATE, FRONT SHEAR	9		
-	1	2	1	2-1333219-1	ANVIL, COMBINATION	8	
-	1	1	1	9-240651-6	BLADE, SLUG	7	
-	1	1	1	2-240641-6	SPACER	5	
-	1	1	1	238011-4	BLOCK, CRIMPER SPACER	4	
-	1	2	1	1803018-8	CRIMPER, INSULATION O	3	
-	1	1	1	455888-7	SPACER, CRIMPER	2	
-	1	2	1	1-456408-8	CRIMPER, WIRE PREMIUM	1	
-	77	72	2	PART NO			
-				DESCRIPTION			ITEM NO

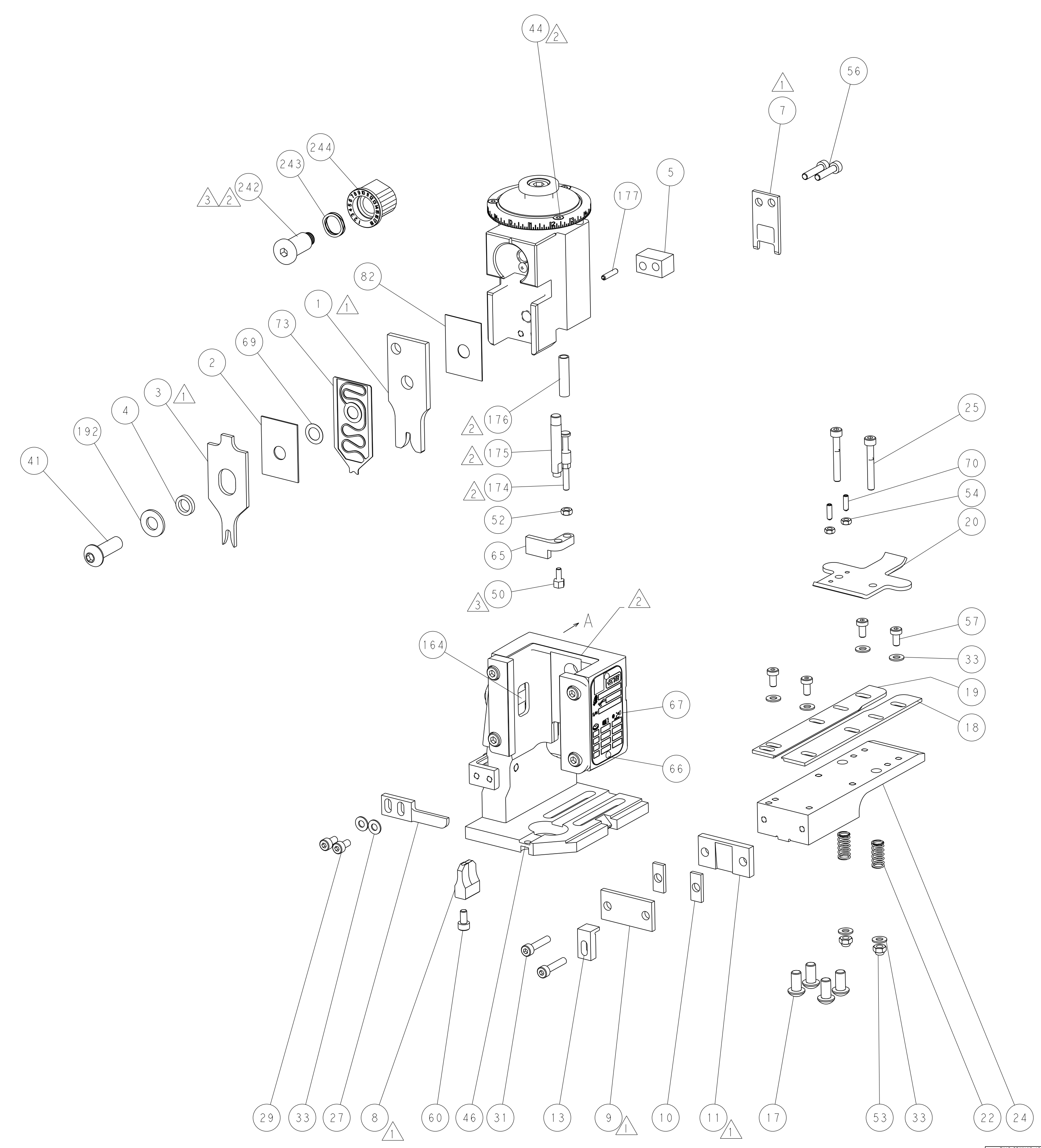
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		MATERIAL:		FINISH:	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES	FINISH

DWN	R. STAKEM	21AUG2012	
CHK	G. BAILEY	21AUG2012	
APVD	T. ELRLN	21AUG2012	
NAME	Ocean End Feed Applicator		
PRODUCT SPEC			
APPLICATION SPEC			
SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
A1	00779	2150282	
Customer Accessible Production Drawing		SCALE	1:1 SHEET 1 OF 4 REV E

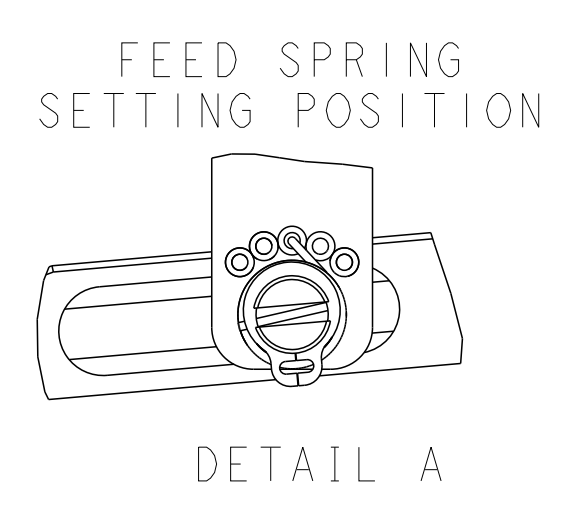
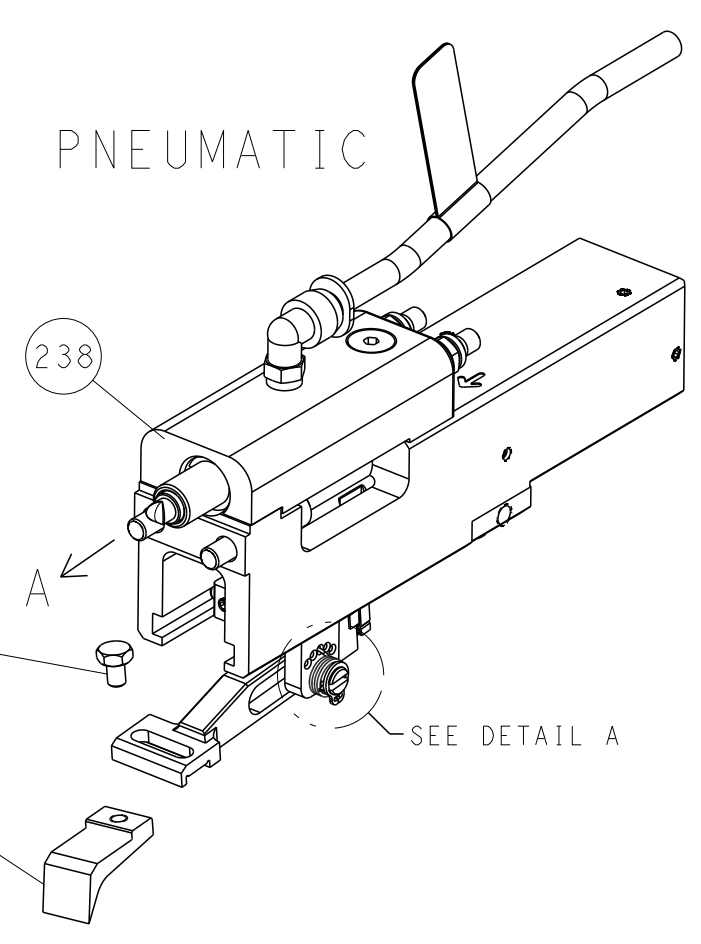
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P	LTN	DESCRIPTION	DATE	DWN	APVD
A	66	SEE SHEET 1			



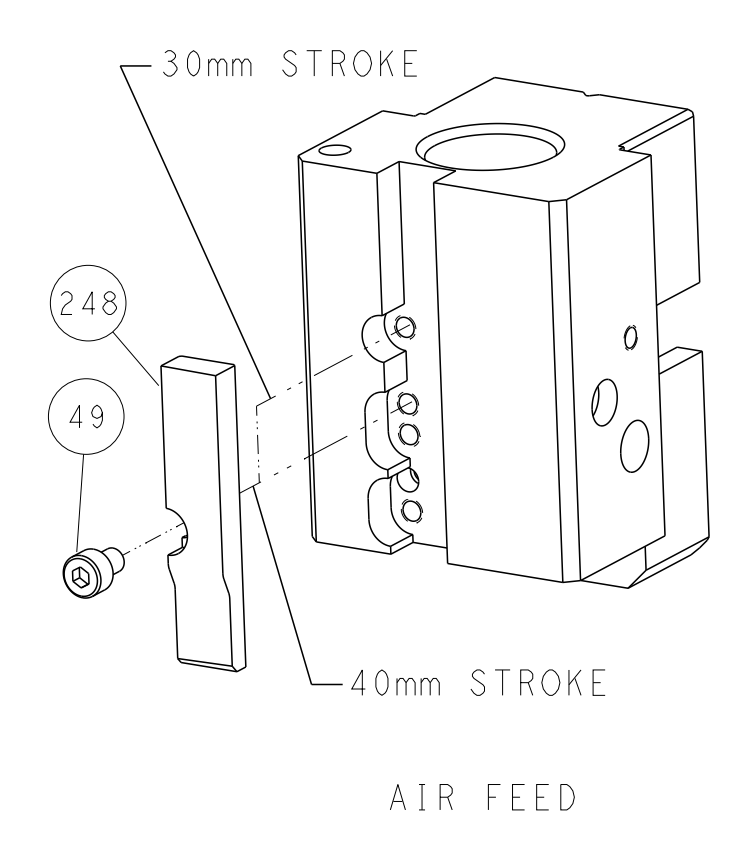
RAM AND HOLDDOWN SET-UP



FEED TYPE



CAM POSITION



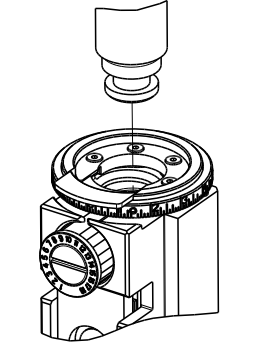
AIR FEED

**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 UNPUBLISHED. RELEASED FOR PUBLICATION BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.</small>		DWN: K. STAKEM 21AUG2012 CHK: G. BAILEY 21AUG2012 APVD: T. ELBIN 21AUG2012	TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±. 1 PLC ±. 2 PLC ±. 3 PLC ±. 4 PLC ±. ANGLES ° ±. MATERIAL: - FINISH: -		NAME: Ocean End Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2150282 WEIGHT: - SCALE: 1:1	RESTRICTED TO: - SHEET 2 OF 4 REV E

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150282-2	E	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150282-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR  
 INTERFACE ADAPTER



APPLICATOR DATA

CRIMP	SIZE	TYPE
WIRE	2.79 mm (.110)	F
INSUL	3.56 mm (.140)	O

APPLICATOR INSTRUCTIONS  
 408-35043

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION

TERMINAL NAME: TERMINAL, RING

WIRE STRIP LENGTH	INSULATION DIAMETER RANGE
.204-.234 IN [5.18-5.94 mm]	Ø.070-.100 IN [1.78-2.54 mm]

TERMINAL APPLICATION SPECIFICATION

TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
41711	41013	140517	

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
18 AWG OR 0.75mm <sup>2</sup>	1.96+/-0.05 [0.77+/-0.02]	8.7
20 AWG OR 0.50mm <sup>2</sup>	1.88+/-0.05 [0.74+/-0.02]	9.5
22 AWG OR 0.35mm <sup>2</sup>	1.83+/-0.05 [0.72+/-0.02]	10.0

- 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 PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- 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.

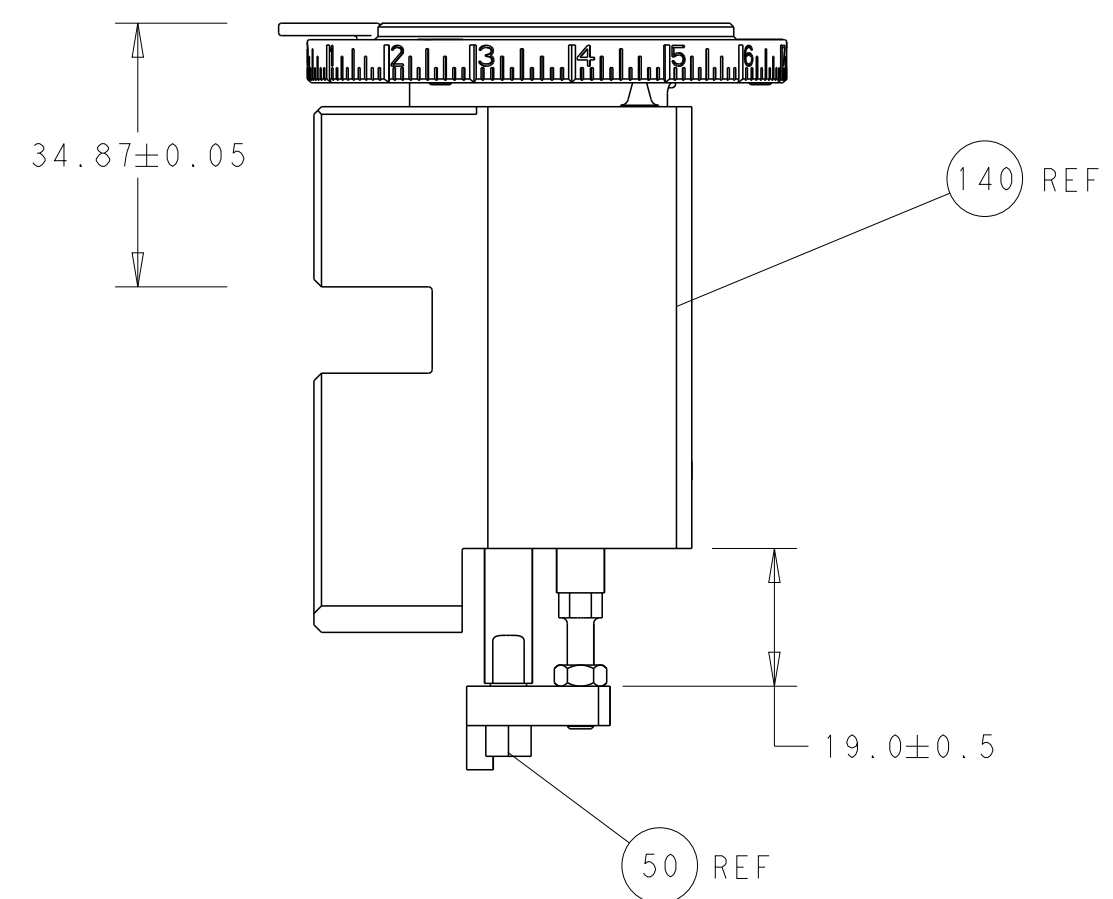
LOC	DIST	REV	DATE	BY	APPV
A	66				

REV	DATE	DESCRIPTION	BY	APPV
- 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	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	1901681-1	HOLDDOWN, TERMINAL		65
- 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	1-5018030-0	NUT, HEX, REG, RoHS, M3.5		52
- 1	2063961-9	FEED FINGER		51
- 1	1752354-1	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
- 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	1752371-5	PLATE, STRIP GUIDE		24
- 2	2-22281-3	SPRING, COMPRESSION		22
- 1	1803292-1	DRAG		20
- 1	1901696-3	STRIP GUIDE, REAR		19
- 1	1901695-3	STRIP GUIDE, FRONT		18
- 1	1752360-1	SPACER,HOLD-DOWN		13
- 1	240644-1	PLATE, REAR SHEAR		11
- 2	1-240645-0	SPACER, SHEAR PLATE		10
- 1	240642-1	PLATE, FRONT SHEAR		9
1 1	2-1333219-1	ANVIL, COMBINATION		8
- 1	9-240651-6	BLADE, SLUG		7
- 1	2-240641-6	SPACER		5
- 1	238011-4	BLOCK, CRIMPER SPACER		4
1 1	1803018-8	CRIMPER, INSULATION O		3
- 1	455888-7	SPACER, CRIMPER		2
1 1	1-456408-8	CRIMPER, WIRE PREMIUM		1

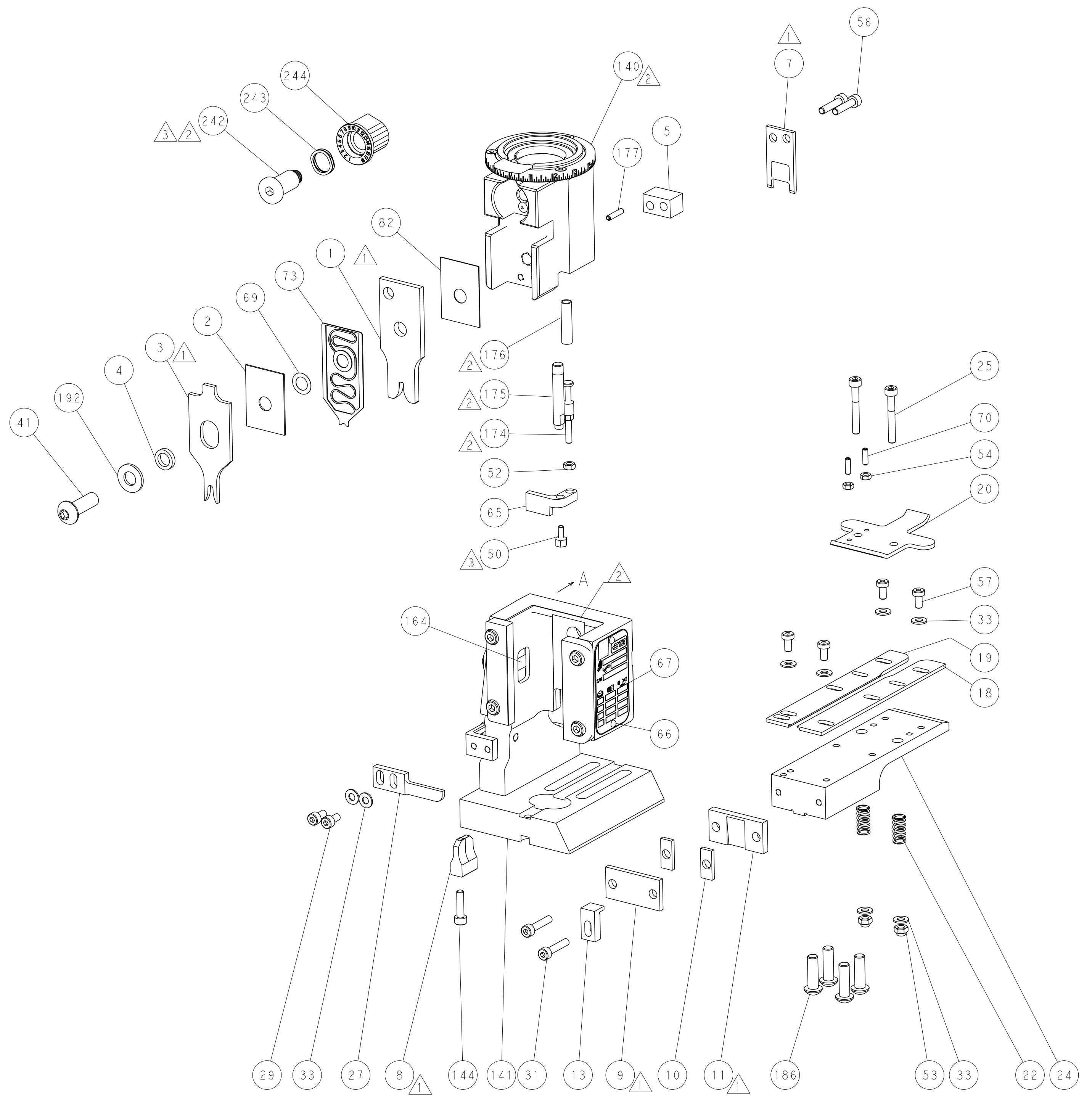
PACIFIC VERSION  
 Shown on sheets 3 of 4 & 4 of 4  
 (Atlantic version shown on sheets 1 of 4 & 2 of 4)

DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH		DWN: STAKEM 21AUG2012 CHK: G. BAILEY 21AUG2012 APVD: T. ELBIN 21AUG2012		NAME: Ocean End Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2150282	
MATERIAL: -		FINISH: -		WEIGHT: -		SCALE: 1:1	
Customer Accessible Production Drawing				SHEET 3 OF 4		REV E	

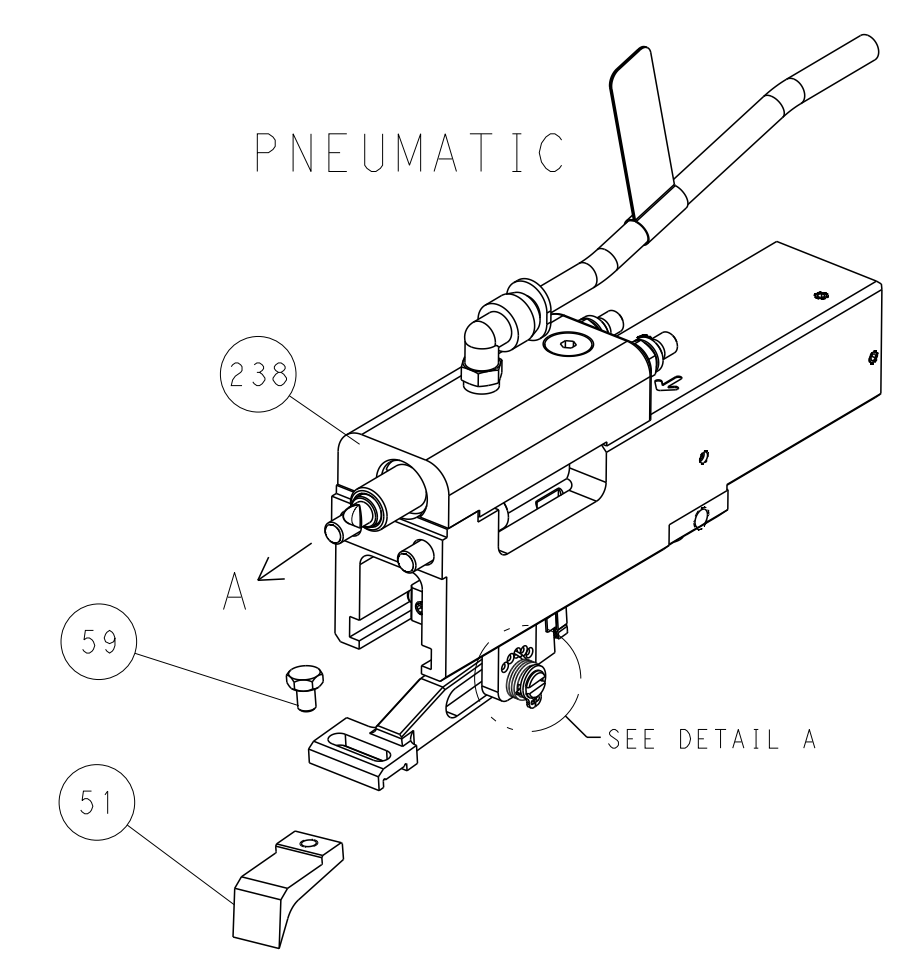
LOC	DIST	REVISIONS			
P	LTN	DESCRIPTION	DATE	DMN	APVD
A	66	SEE SHEET 1	-	-	-



RAM AND HOLDDOWN SET-UP

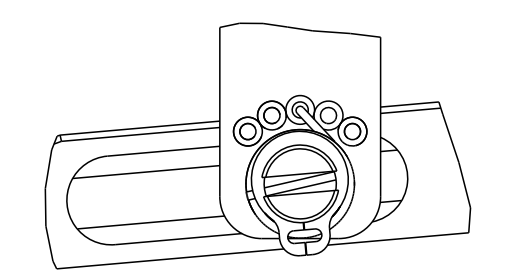


FEED TYPE



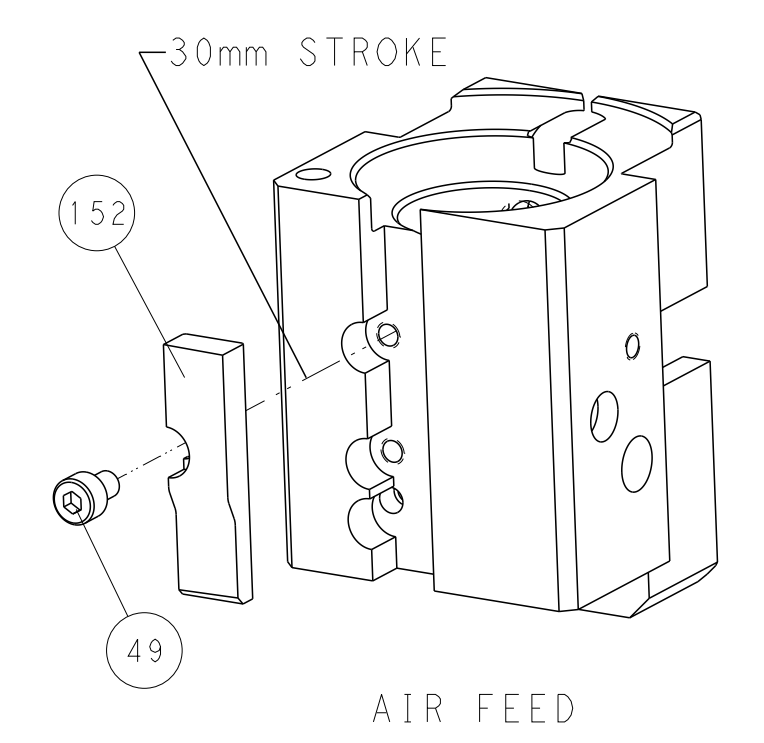
PNEUMATIC

FEED SPRING SETTING POSITION



DETAIL A

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)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG: K. STAKEM 21AUG2012		STE TE Connectivity	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	5 PLC ±	Harrisburg, PA 17105-3608
	ANGLES ±	FINISH ±		CHK: G. BAILEY 21AUG2012	NAME: T. ELBIN 21AUG2012	Ocean End Feed Applier	
MATERIAL:				PRODUCT SPEC:	APPLICATION SPEC:	SIZE: A11	CAGE CODE: 00779
				WEIGHT:	SCALE: 1:1	DRAWING NO: C=2150282	RESTRICTED TO: -
Customer Accessible Production Drawing						SHEET: 4	OF: 4
						REV: E	