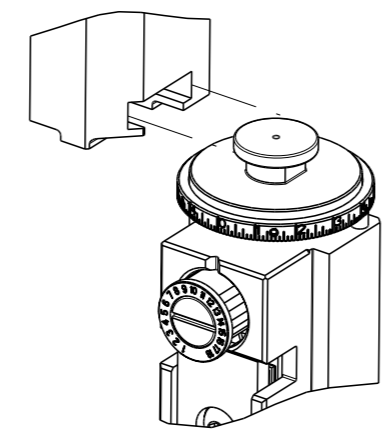


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150448-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2150448-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150448-1	C	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2150448-2	C	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150448-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	3.05 mm [.120]	F
INSUL	3.05 mm [.120]	OV
APPLICATOR INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: RECEPTACLE, FASTON FLAG, AMPLIVAR			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
4.39-5.15 mm [.173-.203 IN]		Ø1.90-3.20 mm [.075-.126 IN]	
TERMINAL APPLICATION SPECIFICATION	114-2152		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
1742977-1			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
4100 CMA	1.57 +/- 0.05 [.062 +/- .002]	3.4
2680 CMA	1.22 +/- 0.05 [.048 +/- .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.
- 5. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USEDER DOCUMENT, 101-35000.
- TERMINAL LUBRICANT IS RECOMMENDED.

***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.

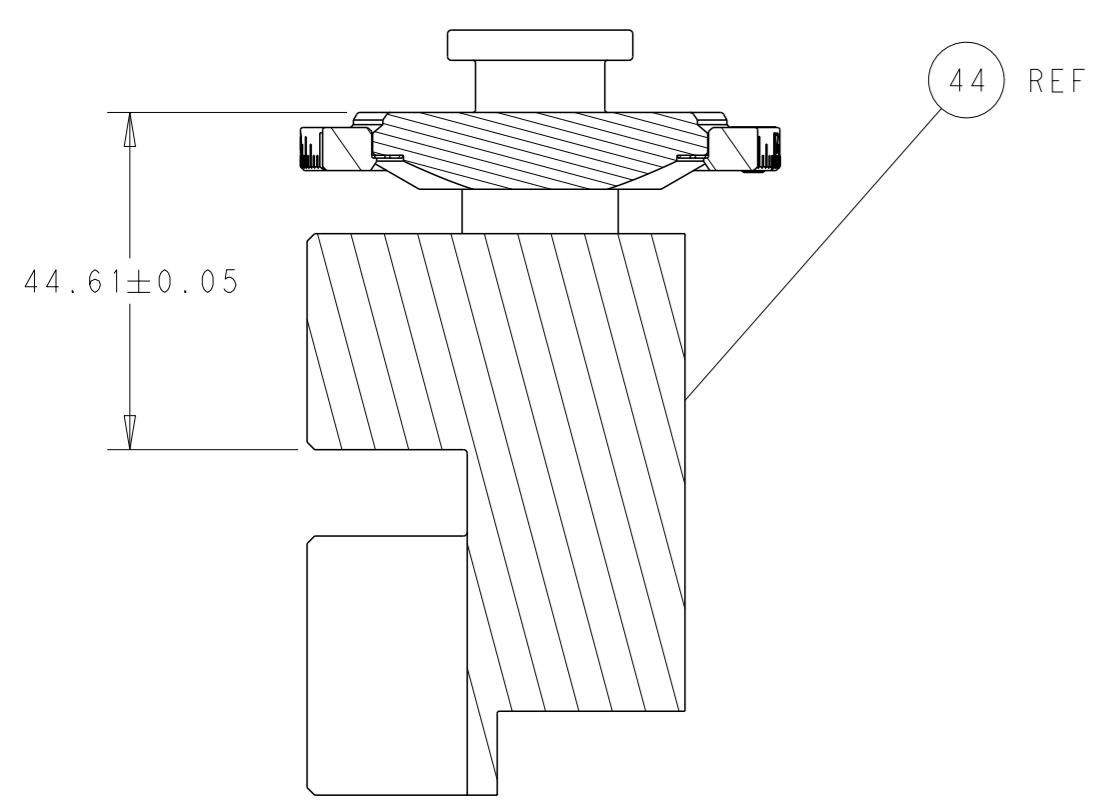
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

LOC	DIST	REVISIONS					
A	66	P	LY#	DESCRIPTION	DATE	OWN	APVD
		A		RELEASED	26APR2010	KS	TE
		B		ECR-17-010662	21JUL2017	LG	CT
		C		ECR-19-014159	10SEP2019	FZ	TE

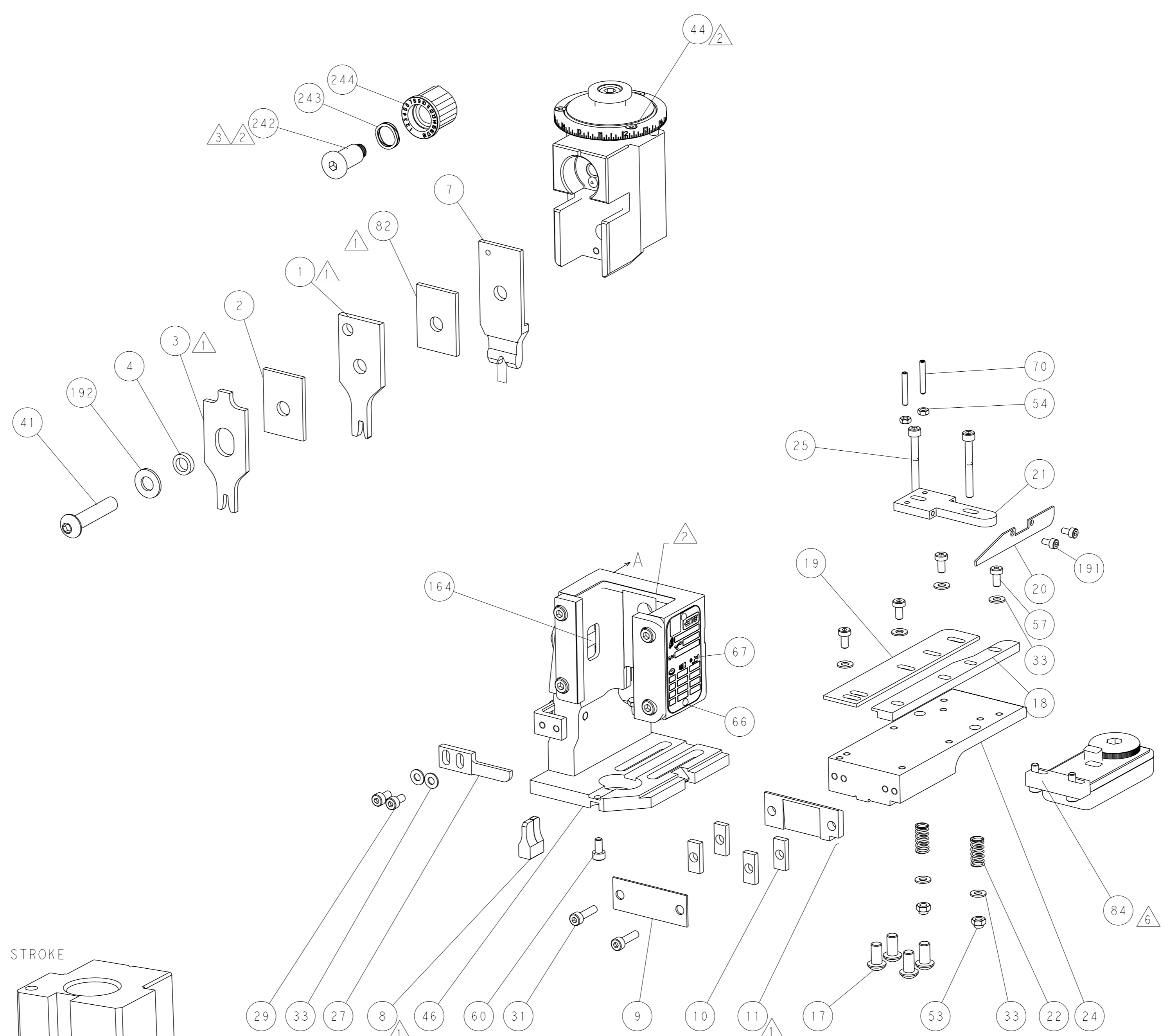
-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248	
-	1	1	1	1	2119082-8	CAM, SNAIL, INSULATION ADJUSTMENT	244	
-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243	
-	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242	
-	-	1	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239	
-	1	-	1	-	2844940-3	AIR FEED MODULE	238	
-	1	1	1	1	1-18028-0	WASHER, FLAT, REG M8	192	
-	2	2	2	2	1-2168083-1	SCR, SKT HD CAP, RoHS, M3 X 6	191	
-	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164	
-	1	1	1	1	2119955-2	ASSY, LUBRICATOR, END FEED	84	
-	1	1	1	1	2-455888-5	SPACER, CRIMPER	82	
-	1	1	1	1	1803607-4	DOCUMENTATION PACKAGE	71	
-	2	2	2	2	3-18032-3	SCR, SET, FLT PNT, M3 X 20.0	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	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	2063961-1	FEED FINGER	58	
-	4	4	4	4	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57	
-	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	-	2063961-1	FEED FINGER	51	
-	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	1803517-2	RAM ASSEMBLY, EF ATLANTIC	44	
-	1	1	1	1	1803602-2	SCR, BHSC, RoHS (M8 X 40)	41	
-	8	8	8	8	1-18028-2	WASHER, FLAT, REG M4	33	
-	2	2	2	2	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	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	1-2168083-6	SCR, SKT HD CAP, RoHS, M4 X 35	25	
-	1	1	1	1	2161922-5	PLATE, STRIP GUIDE	24	
-	2	2	2	2	2-22281-3	SPRING, COMPRESSION	22	
-	1	1	1	1	1-1633168-0	ARM, STOCK DRAG	21	
-	1	1	1	1	464452-2	DRAG, STOCK	20	
-	1	1	1	1	1-1901259-2	GUIDE, LOWER STRIP	19	
-	1	1	1	1	4-1901695-9	STRIP GUIDE, FRONT	18	
-	4	4	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17	
-	1	1	1	1	461160-3	PLATE, REAR SHEAR	11	
-	4	4	4	4	7-240645-4	SPACER, SHEAR PLATE	10	
-	1	1	1	1	455961-5	PLATE, FRONT SHEAR	9	
-	1	2	2	1	1	6-1803001-4	ANVIL, COMBINATION, END FEED	8
-	1	1	1	1	2-459722-8	BLADE, SHEAR	7	
-	-	-	-	-	-	-	6	
-	1	1	1	1	6-238011-9	BLOCK, CRIMPER SPACER	4	
-	1	2	2	1	1	1-2119785-9	CRIMPER, INSULATION OVERLAP PREMIUM	3
-	1	1	1	1	2-455888-4	SPACER, CRIMPER	2	
-	1	2	2	1	1	1803188-4	CRIMPER, WIRE	1
-	77	72	71	2	1	PART NO	ITEM NO	

<small>THE INFORMATION CONTAINED HEREIN IS UNCLASSIFIED EXCEPT WHERE SHOWN OTHERWISE. IT IS SUBJECT TO CHANGE AND IS SUBJECT TO THE RESTRICTIONS DESCRIBED IN THE CONTROLLING DOCUMENTATION SHOULD BE CONTACTED FOR THE LATEST REVISION.</small>		DWN K. STAKEM CHK G. BAILEY APVD T. ELBIN PRODUCT SPEC APPLICATION SPEC MATERIAL FINISH	07JULY2014 07JULY2014 07JULY2014 07JULY2014	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
WEIGHT -		CAGE CODE 00779	DRAWING NO 2150448	RESTRICTED TO -
Customer Accessible Production Drawing		SCALE 1:1	SHEET 1 of 4	REV C

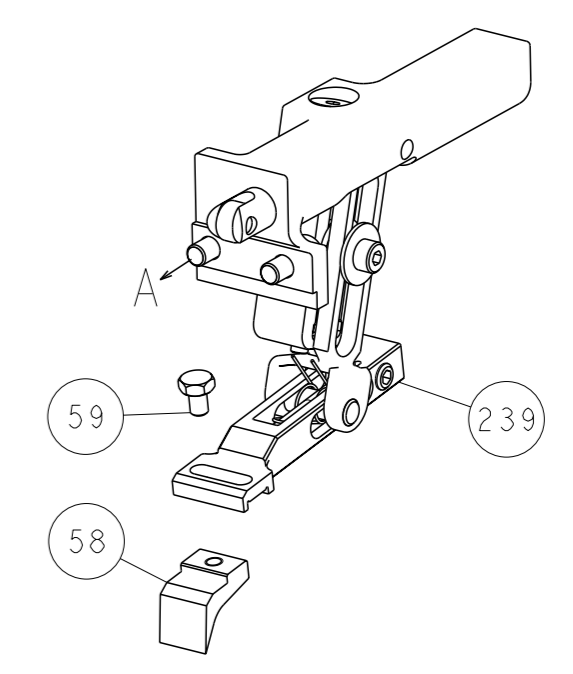
LOC	DIST	REVISIONS					
A	66	P	LYR	DESCRIPTION	DATE	OWN	APVD
		-		SEE SHEET 1	-	-	-



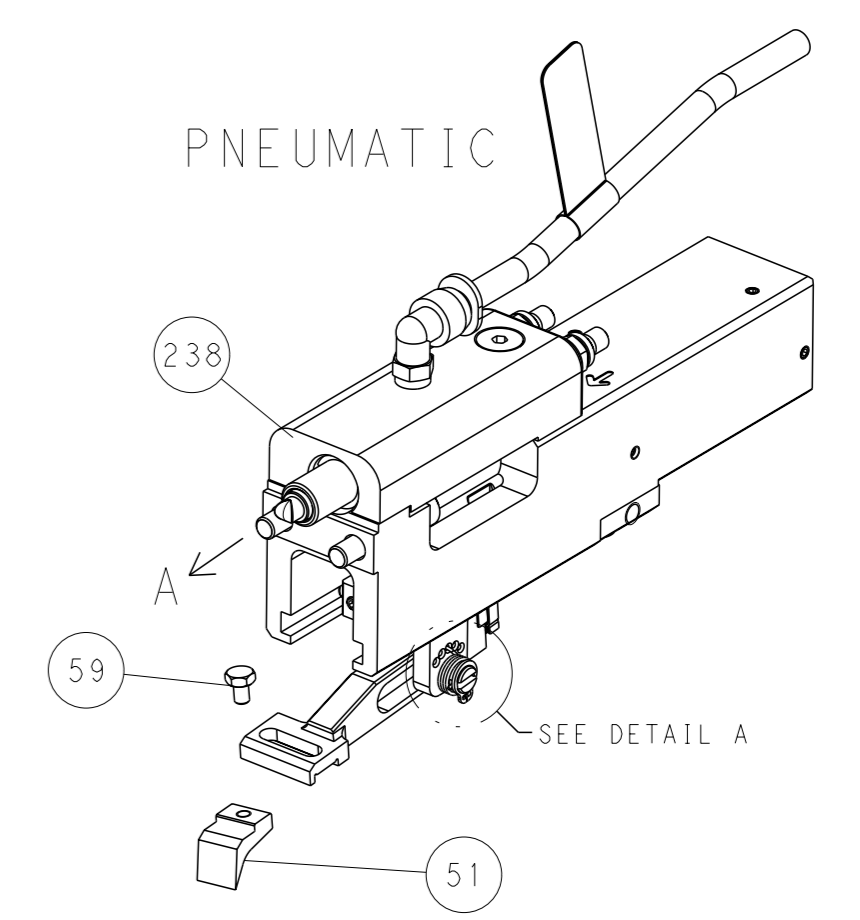
RAM SET-UP



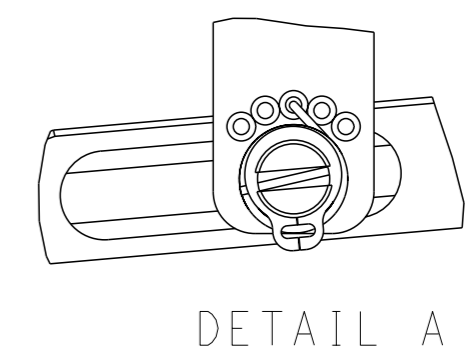
FEED TYPE
MECHANICAL



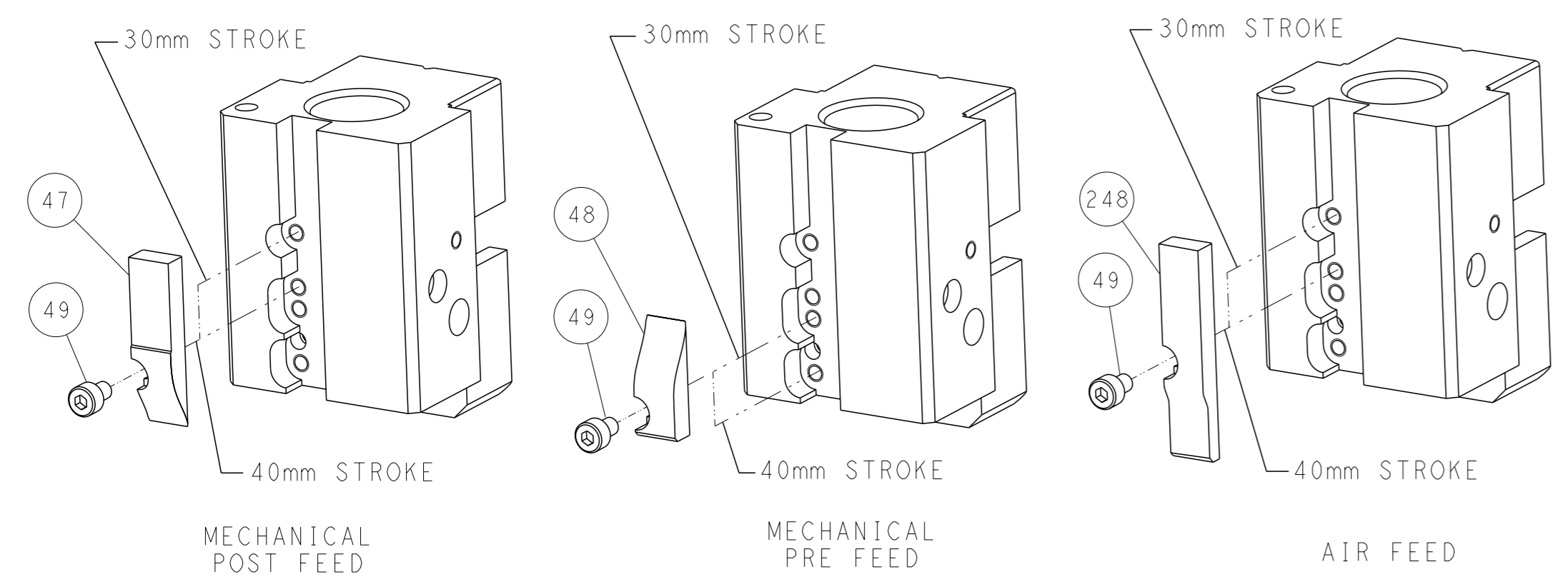
PNEUMATIC



FEED SPRING
SETTING POSITION



CAM POSITIONS

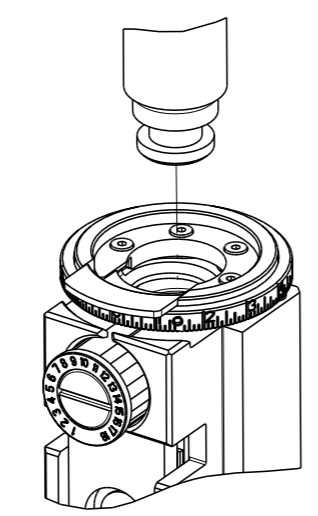


ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		OWN: K. STAKEM 07JULY2014 CHK: G. BAILEY 07JULY2014 APVD: T. ELBIN 07JULY2014 PRODUCT SPEC: APPLICATION SPEC: WEIGHT: MATERIAL:		NAME: Ocean End Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: C-2150448 SCALE: 1:1 SHEET: 2 of 4 REV: C		RESTRICTED TO:	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150448-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2150448-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150448-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
 INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	3.05 mm [.120]	F
INSUL	3.05 mm [.120]	OV
APPLICATOR INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: RECEPTACLE, FASTON FLAG, AMPLIVAR			
WIRE STRIP LENGTH 4.39-5.15 mm [.173-.203 IN]		INSULATION DIAMETER RANGE Ø1.90-3.20 mm [.075-.126 IN]	
TERMINAL APPLICATION SPECIFICATION 114-2152			
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
1742977-1			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
4100 CMA	1.57 +/- 0.05 [0.062 +/- 0.002]	3.4
2680 CMA	1.22 +/- 0.05 [0.048 +/- 0.002]	8.3

- 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 USER DOCUMENT, 101-35000.
- 6 TERMINAL LUBRICANT IS RECOMMENDED.

***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	REVISIONS					
		P	LY#	DESCRIPTION	DATE	OWN	APVD
A	66	-	-	SEE SHEET 1	-	-	-

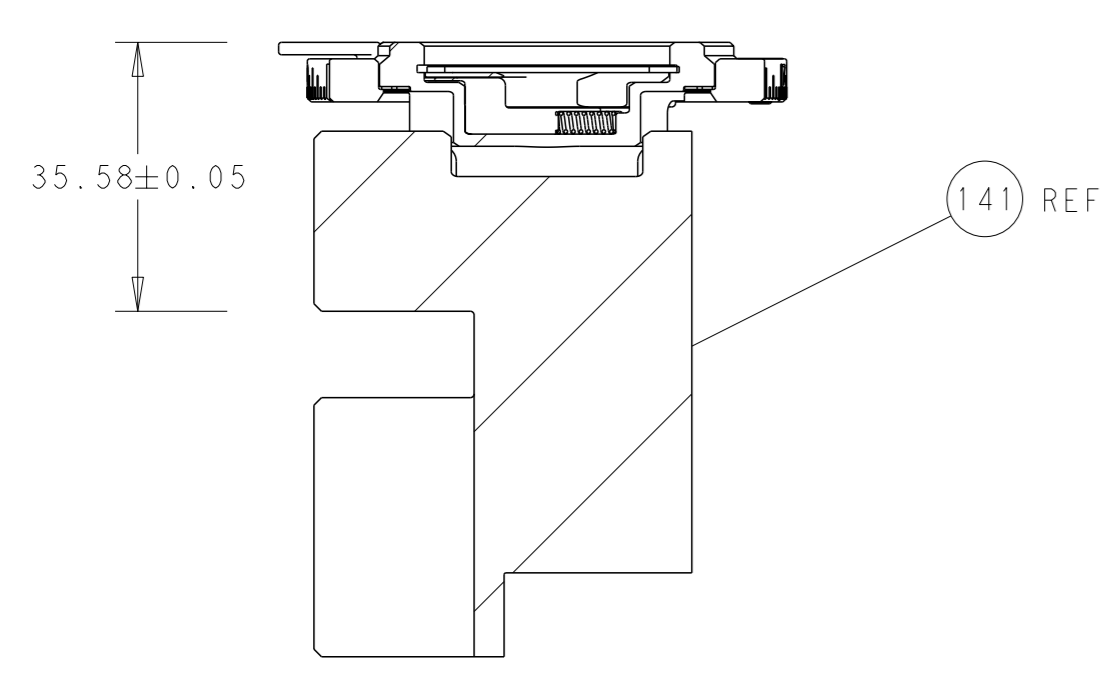
-	1	1	2119082-8	CAM, SNAIL, INSULATION ADJUSTMENT	244	
-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243	
3	-	1	2119083-1	RETAINER, INSULATION DIAL	242	
-	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239	
-	1	-	2844940-3	AIR FEED MODULE	238	
-	1	1	1-18028-0	WASHER, FLAT, REG M8	192	
-	2	2	1-2168083-1	SCR, SKT HD CAP, RoHS, M3 X 6	191	
-	4	4	2079383-9	SCR, BHSC, RoHS (M6 X 20)	186	
-	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	1803518-2	RAM ASSEMBLY, EF PACIFIC	140	
6	-	1	2119955-2	ASSY, LUBRICATOR, END FEED	84	
-	1	1	2-455888-5	SPACER, CRIMPER	82	
-	1	1	1803607-4	DOCUMENTATION PACKAGE	71	
-	2	2	3-18032-3	SCR, SET, FLT PNT, M3 X 20.0	70	
-	1	1	2119740-1	TAG, IDENTIFICATION	67	
-	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66	
-	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59	
-	-	1	2063961-1	FEED FINGER	58	
-	4	4	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57	
-	2	2	5018030-1	NUT, HEX, REG, RoHS, M3	54	
-	2	2	986965-8	NUT, LOCK, HEX, TORQUE (M4)	53	
-	1	-	2063961-1	FEED FINGER	51	
-	1	2	18023-9	SCR, SKT HD CAP M4 X 6.0	49	
-	-	1	2119652-1	FEED CAM, PRE FEED	48	
-	1	1	1803602-2	SCR, BHSC, RoHS (M8 X 40)	41	
-	8	8	1-18028-2	WASHER, FLAT, REG M4	33	
-	2	2	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	31	
-	2	2	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	29	
-	1	1	240639-1	STRIPPER (MACHINING)	27	
-	2	2	1-2168083-6	SCR, SKT HD CAP, RoHS, M4 X 35	25	
-	1	1	2161922-5	PLATE, STRIP GUIDE	24	
-	2	2	2-22281-3	SPRING, COMPRESSION	22	
-	1	1	1-1633168-0	ARM, STOCK DRAG	21	
-	1	1	464452-2	DRAG, STOCK	20	
-	1	1	1-1901259-2	GUIDE, LOWER STRIP	19	
-	1	1	4-1901695-9	STRIP GUIDE, FRONT	18	
1	-	1	461160-3	PLATE, REAR SHEAR	11	
-	4	4	7-240645-4	SPACER, SHEAR PLATE	10	
1	-	1	455961-5	PLATE, FRONT SHEAR	9	
1	1	1	6-1803001-4	ANVIL, COMBINATION, END FEED	8	
1	-	1	2-459722-8	BLADE, SHEAR	7	
-	-	-	-	-	6	
-	1	1	6-238011-9	BLOCK, CRIMPER SPACER	4	
1	1	1	1-2119785-9	CRIMPER, INSULATION OVERLAP PREMIUM	3	
-	1	1	2-455888-4	SPACER, CRIMPER	2	
1	1	1	1803188-4	CRIMPER, WIRE	1	
-	77	22	21	PART NO	DESCRIPTION	ITEM NO

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		MATERIAL:	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±
	FINISH	FINISH	FINISH	FINISH	FINISH
WEIGHT		SCALE		SHEET	
Customer Accessible Production Drawing		SCALE 1:1		SHEET 3 of 4	



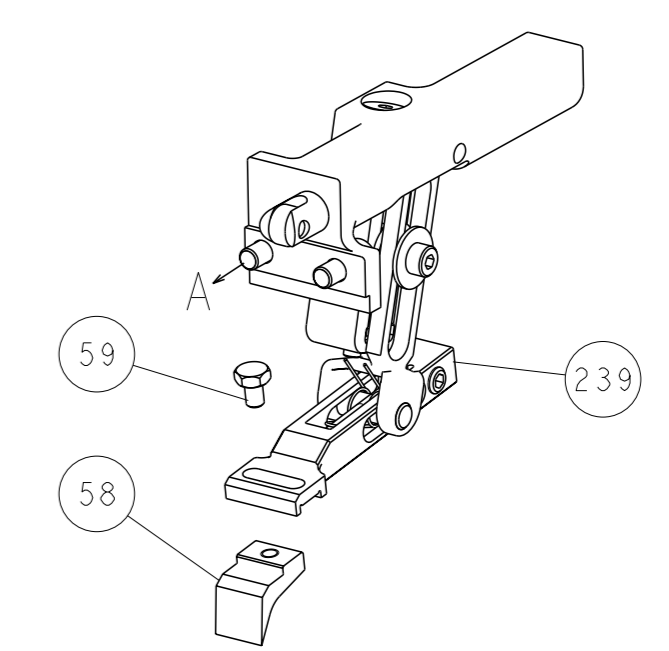
Ocean End Feed
 Applicator

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

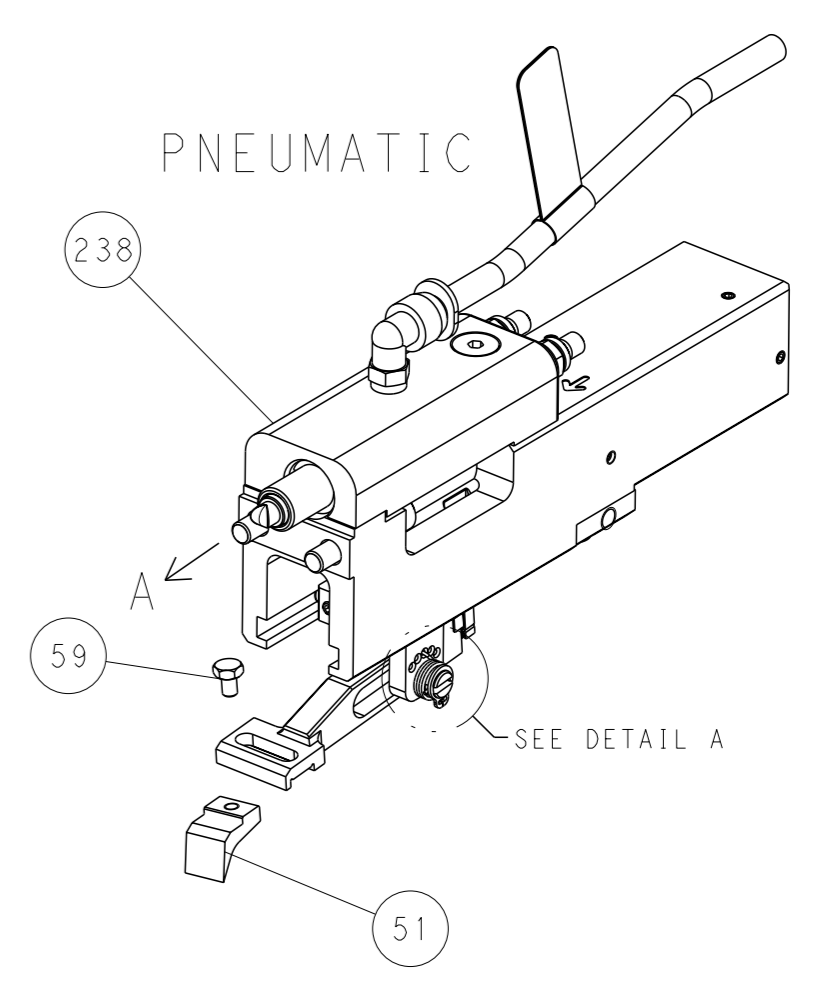


RAM SET-UP

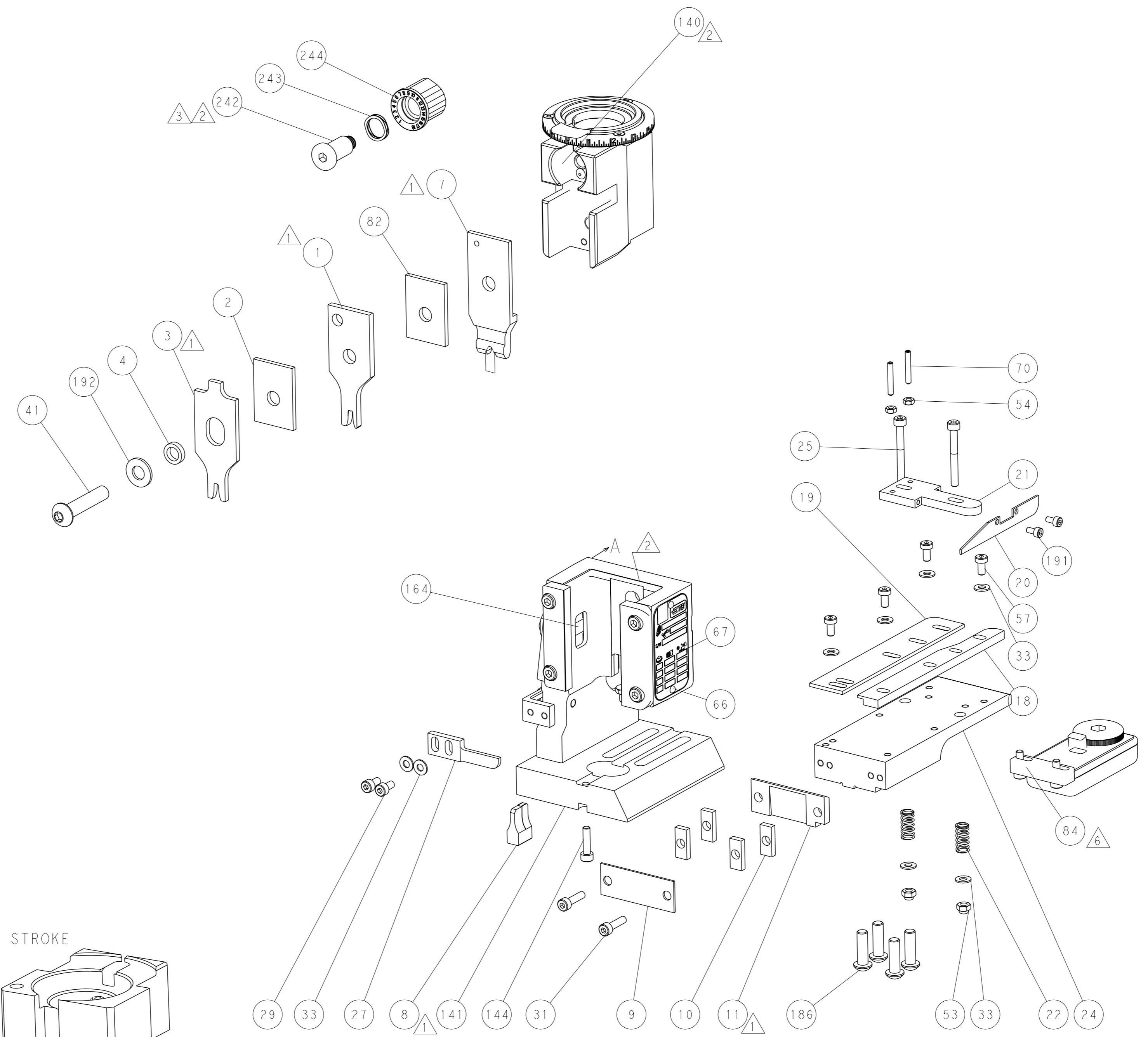
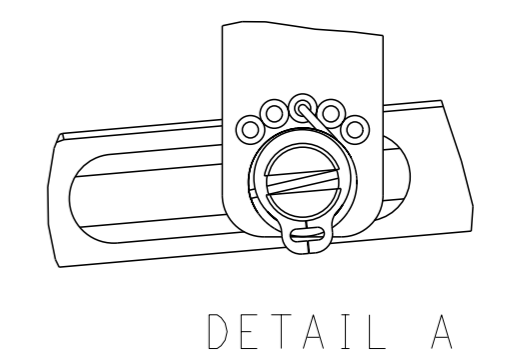
FEED TYPE
 MECHANICAL



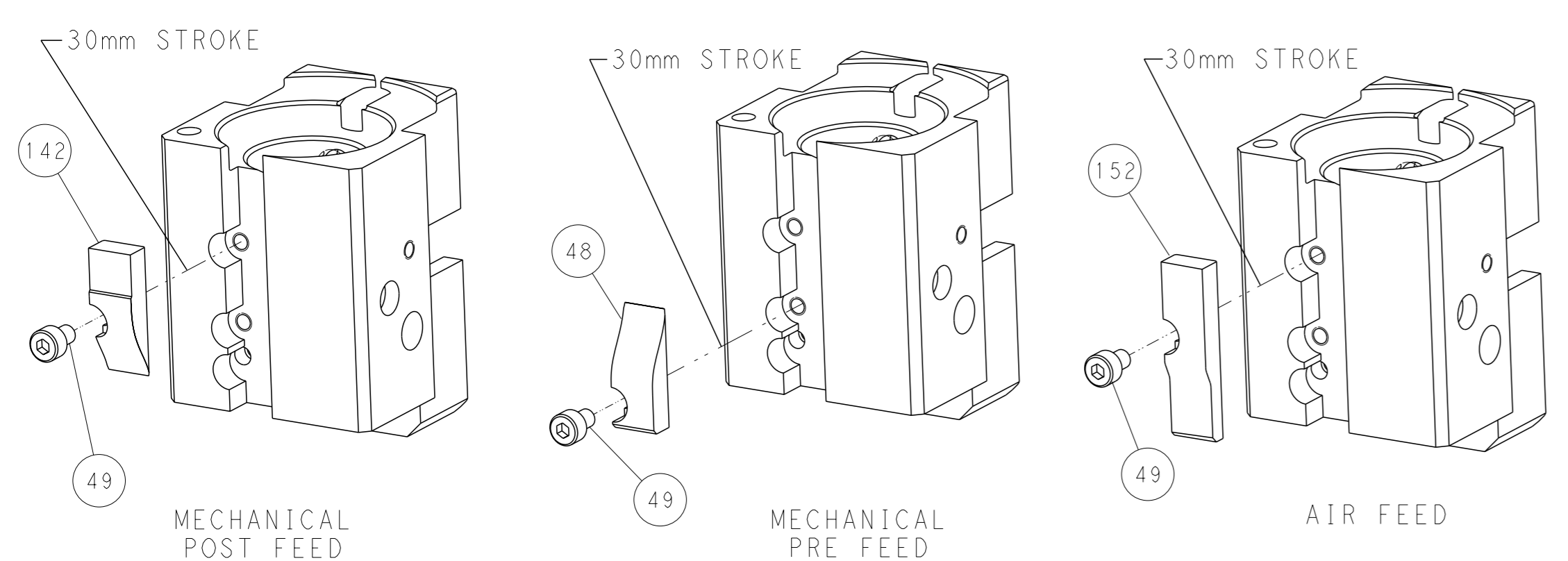
PNEUMATIC



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 ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH *		OWN: K. STAKEM 07JULY2014 CHK: G. BAILEY 07JULY2014 APVD: T. ERLIN 07JULY2014 PRODUCT SPEC APPLICATION SPEC WEIGHT Customer Accessible Production Drawing		NAME: Ocean End Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: C-2150448 SCALE: 1:1 SHEET: 4 of 4 REV: C		RESTRICTED TO	
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