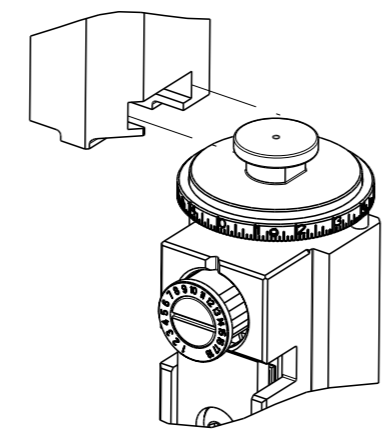


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150531-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150531-2	B	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150531-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	4.57 mm [.180]	F
INSUL	6.35 mm [.250]	F
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: .375 S. FASTIN-ON RECEPTACLE			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
5.60-6.40 mm [.220-.252 IN]		Ø4.00-5.20 mm [.157-.205 IN]	
TERMINAL APPLICATION SPECIFICATION	TE SPEC		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
881606-2	881606-4		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
6.00mm2	2.79 +/- 0.05 [.110 +/- .002]	3.5
5.00mm2	2.62 +/- 0.05 [.103 +/- .002]	5.4
4.00mm2	2.44 +/- 0.05 [.096 +/- .002]	7.6

- 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 180. 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 PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- 6 THE RECOMMENDED SET-UP FOR END FEED APPLICATORS IS POST-FEED WITH ITEM 2119653-1. THE APPLICATOR CAN BE CONFIGURED FOR PRE-FEED WITH ITEM 2119652-1 BUT MAY ENCOUNTER PROBLEMS WITH SOME APPLICATIONS. FEED ISSUES OR TERMINAL JAMMING MAY OCCUR IN THE PRE-FEED CONFIGURATION.

***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	LYH	DESCRIPTION	DATE	OWN	APVD
		1		DEVELOPMENT	03MAR2015	JH	UG
		A		RELEASED	31MAR2015	JH	GB
		B		ECR-20-007540	27MAY2020	FJ	TE

-	1	1	2119641-1	FEED CAM, AIR FEED	248	
-	1	1	2119082-4	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	4-1752354-0	STANDOFF, HOLD-DOWN	180	
-	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	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	1901681-1	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	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	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	1752371-3	PLATE, STRIP GUIDE	24	
-	2	2	2-22281-3	SPRING, COMPRESSION	22	
-	1	1	1803292-4	DRAG	20	
-	2	2	1901259-7	GUIDE, LOWER STRIP	18	
-	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17	
-	1	1	1-240641-2	SPACER	16	
-	1	1	1752360-1	SPACER, HOLD-DOWN	13	
-	1	1	240644-1	PLATE, REAR SHEAR	11	
-	-	-	-	-	10	
-	1	1	2-690482-7	PLATE, FRONT SHEAR	9	
-	1	2	1	6-1803000-9	ANVIL, COMBINATION, END FEED	8
-	1	1	1	1-2217206-1	BLADE, SLUG	7
-	-	-	-	-	6	
-	1	1	1	8-240641-8	SPACER	5
-	1	1	1	1-238011-4	BLOCK, CRIMPER SPACER	4
-	1	2	1	6-2119582-8	CRIMPER, INSULATION F PREMIUM	3
-	1	1	1	455888-7	SPACER, CRIMPER	2
-	1	2	1	2-456412-0	CRIMPER, WIRE .180 F PREMIUM	1
-	77	72	2	PART NO	DESCRIPTION	ITEM NO

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

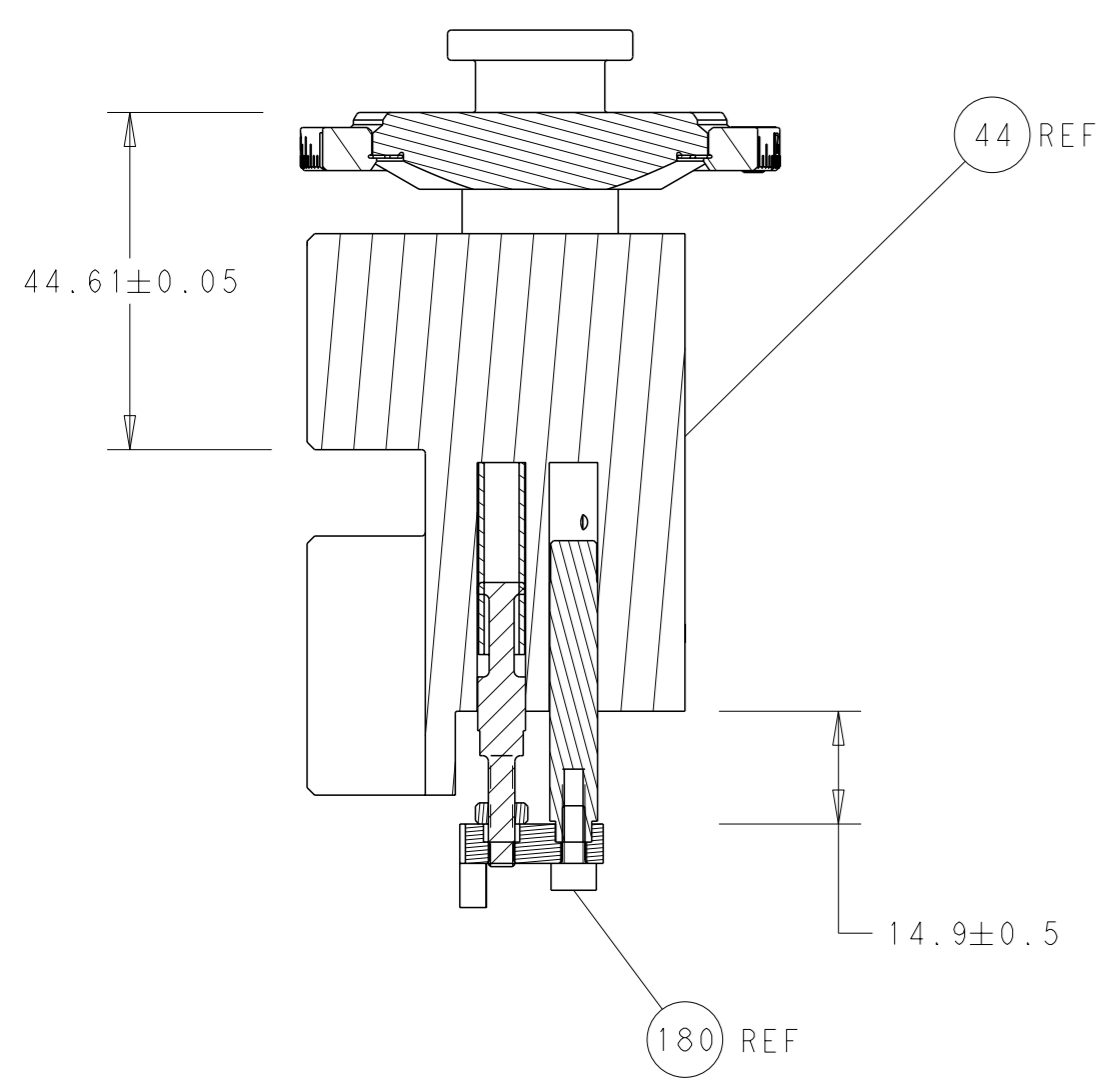
STE TE Connectivity
Harrisburg, PA 17105-3608

Ocean End Feed Applicator

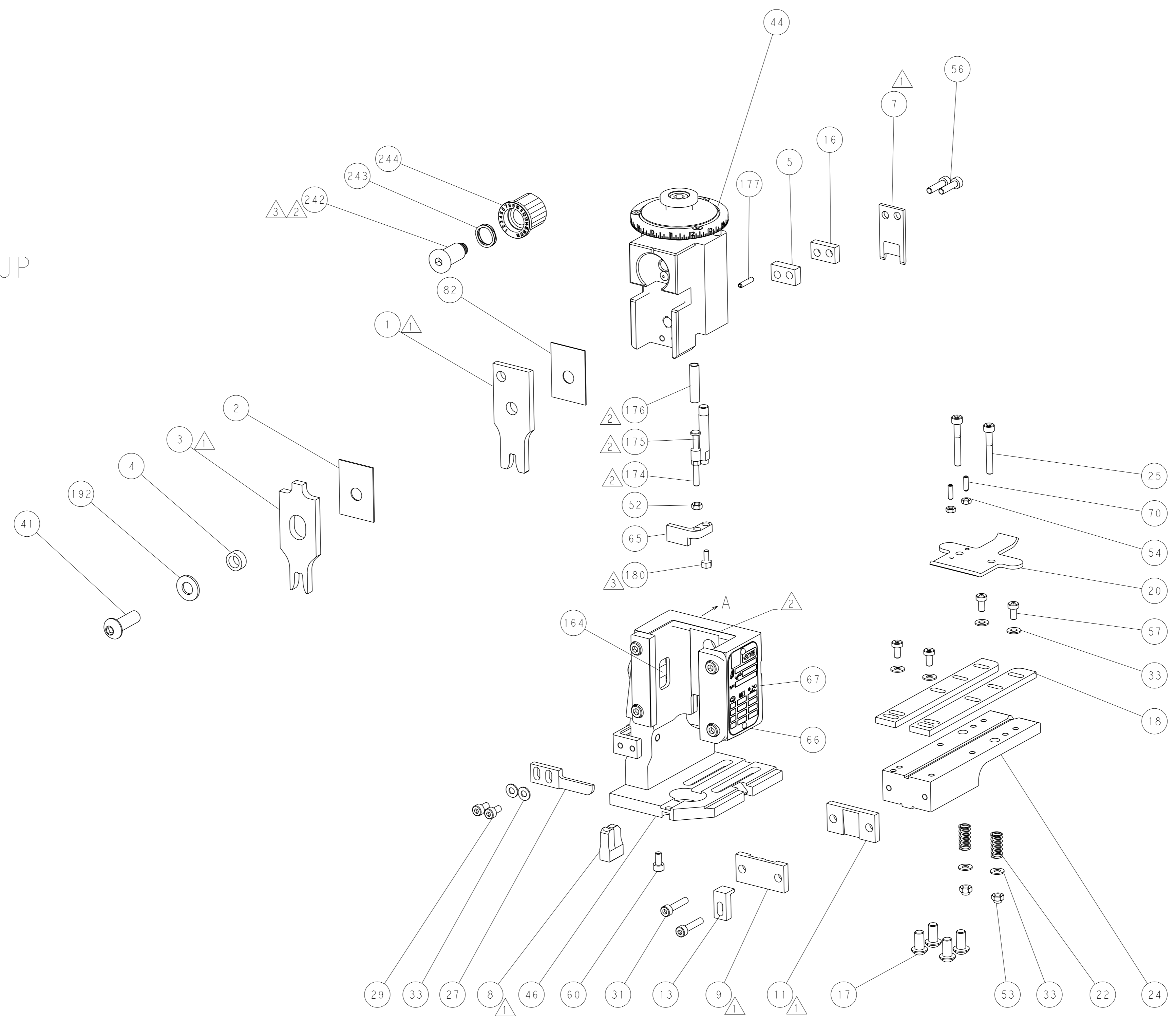
Customer Accessible Production Drawing

SCALE 1:1 SHEET 1 OF 4 REV B

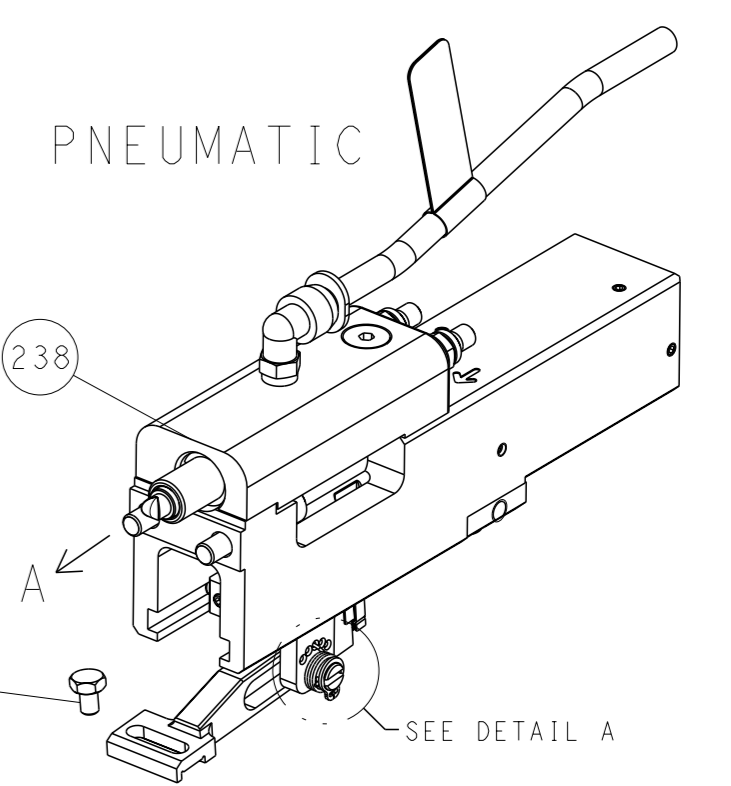
LOC	DIST	REVISIONS				
A	66	REV	DESCRIPTION	DATE	OWN	APVD
-	-	-	SEE SHEET 1	-	-	-



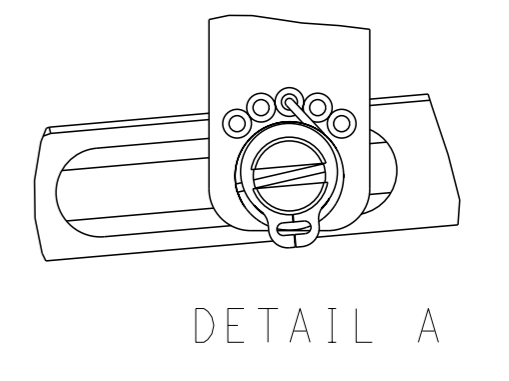
RAM AND HOLDDOWN SET-UP



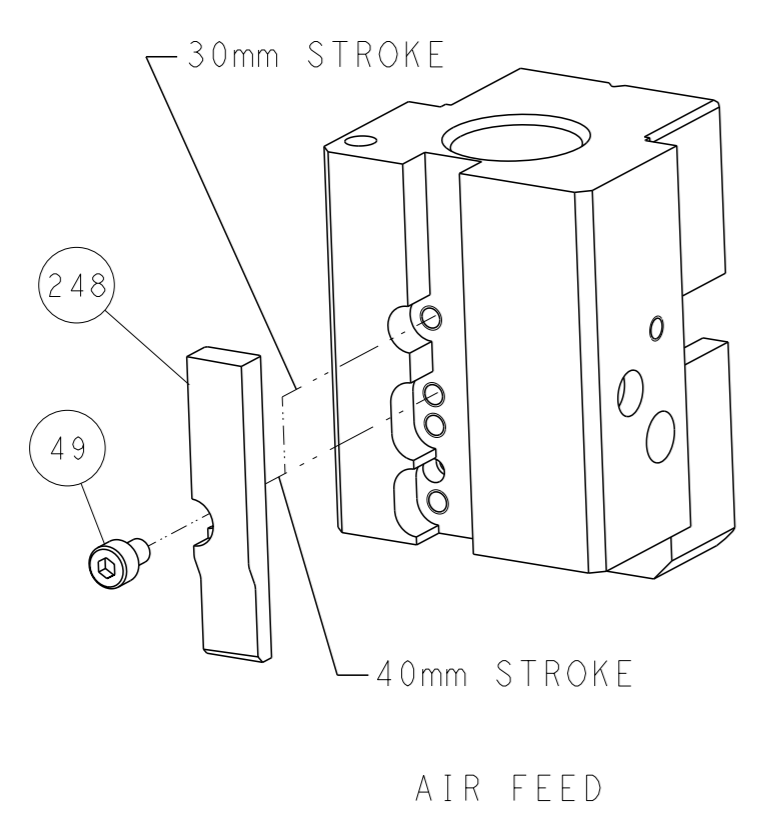
FEED TYPE



FEED SPRING SETTING POSITION



CAM POSITION

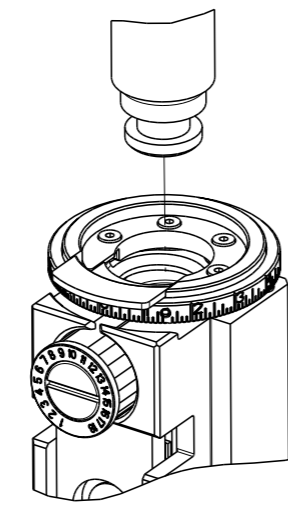


ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

<small>THIS DRAWING IS A CONTROLLED DOCUMENT FROM TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE AND THE CONTROLLING ENGINEERING ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST REVISION.</small>		OWN: J. HOU CHK: L. ZHANG APVD: H. GUO	3MAR2015 3MAR2015 3MAR2015	TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH ±	NAME: Ocean End Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2150531	RESTRICTED TO: - SCALE: 1:1 SHEET: 2 of 4 REV: B
MATERIAL: -		WEIGHT: -	Customer Accessible Production Drawing	

THIS DRAWING IS UNPUBLISHED.	RELEASED FOR PUBLICATION	20	
COPYRIGHT 20 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.			
PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150531-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150531-7	A	CRIMP TOOLING KIT	-

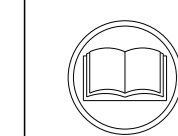
PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	4.57 mm [.180]	F
INSUL	6.35 mm [.250]	F
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: .375 S. FASTIN-ON RECEPTACLE			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
5.60-6.40 mm [.220-.252 IN]		Ø4.00-5.20 mm [1.57-.205 IN]	
TERMINAL APPLICATION SPECIFICATION		TE SPEC	
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
881606-2	881606-4		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
6.00mm2	2.79 +/- 0.05 [.110 +/- .002]	3.5
5.00mm2	2.62 +/- 0.05 [.103 +/- .002]	5.4
4.00mm2	2.44 +/- 0.05 [.096 +/- .002]	7.6



- △ 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 180. 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.
- △ THE RECOMMENDED SET-UP FOR END FEED APPLICATORS IS POST-FEED WITH ITEM 2119653-1. THE APPLICATOR CAN BE CONFIGURED FOR PRE-FEED WITH ITEM 2119652-1 BUT MAY ENCOUNTER PROBLEMS WITH SOME APPLICATIONS. FEED ISSUES OR TERMINAL JAMMING MAY OCCUR IN THE PRE-FEED CONFIGURATION.

***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.

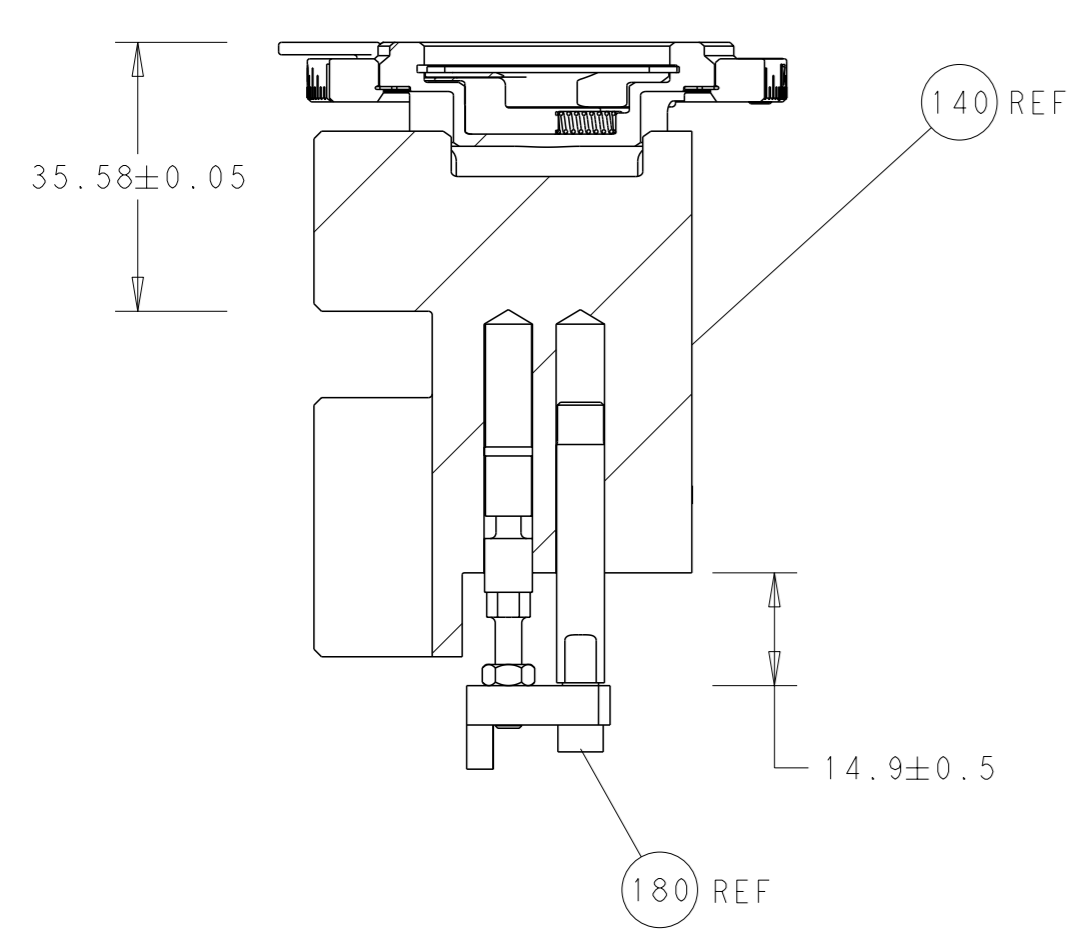
PACIFIC VERSION
Shown on sheets 3 of 4 & 4 of 4
(Atlantic version shown on sheets 1 of 4 & 2 of 4)

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

△	-	1	2119082-4	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	4-1752354-0	STANDOFF, HOLD-DOWN	180
	-	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
	-	-	2119653-2	FEED CAM, POST FEED	142
	-	1	2119655-6	APPLICATOR BASIC ASSEMBLY, EF	141
	-	1	1803518-1	RAM ASSEMBLY, EF PACIFIC	140
	-	1	455888-5	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	1901681-1	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	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	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	1752371-3	PLATE, STRIP GUIDE	24
	-	2	2-22281-3	SPRING, COMPRESSION	22
	-	1	1803292-4	DRAG	20
	-	2	1901259-7	GUIDE, LOWER STRIP	18
	-	1	1-240641-2	SPACER	16
	-	1	1752360-1	SPACER, HOLD-DOWN	13
△	-	1	240644-1	PLATE, REAR SHEAR	11
	-	-	-	-	10
△	-	1	2-690482-7	PLATE, FRONT SHEAR	9
△	1	1	6-1803000-9	ANVIL, COMBINATION, END FEED	8
△	-	1	1-2217206-1	BLADE, SLUG	7
	-	-	-	-	6
	-	1	8-240641-8	SPACER	5
	-	1	1-238011-4	BLOCK, CRIMPER SPACER	4
△	1	1	6-2119582-8	CRIMPER, INSULATION F PREMIUM	3
	-	1	455888-7	SPACER, CRIMPER	2
△	1	1	2-456412-0	CRIMPER, WIRE .180 F PREMIUM	1

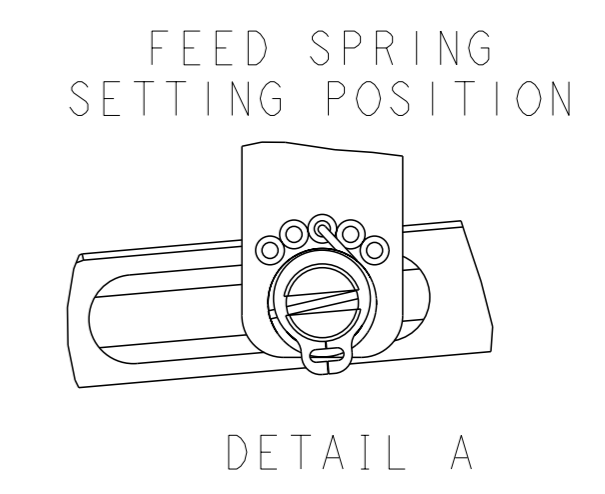
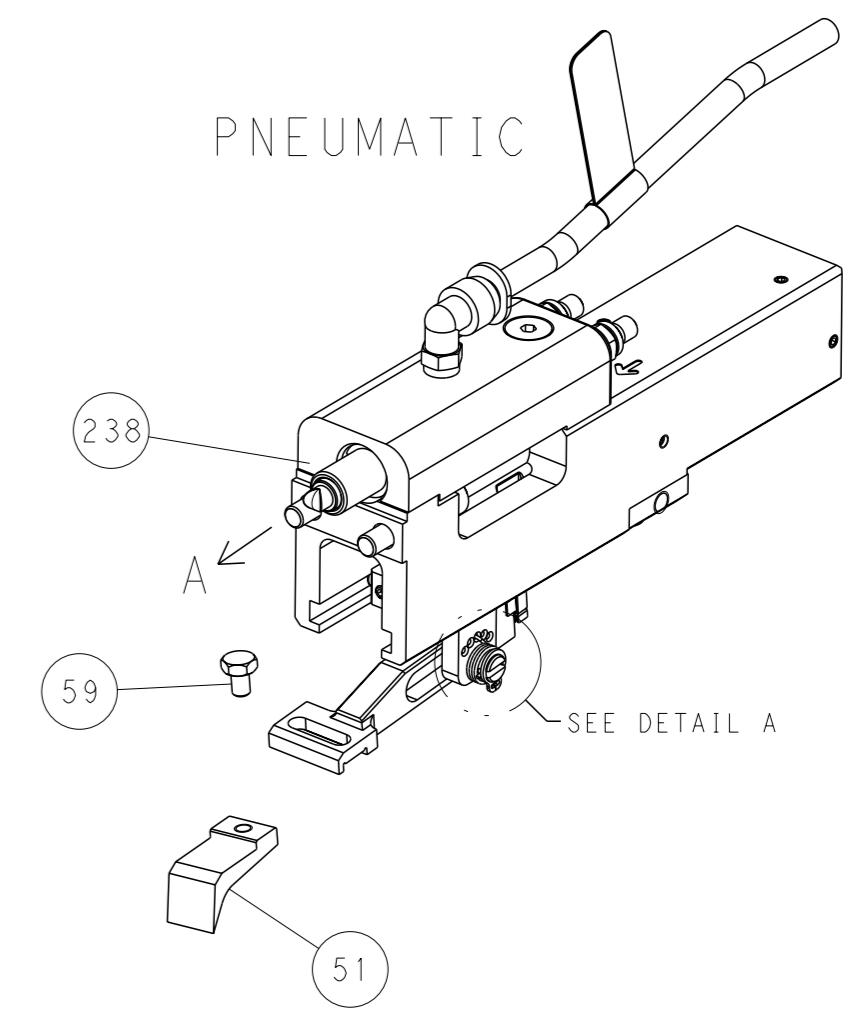
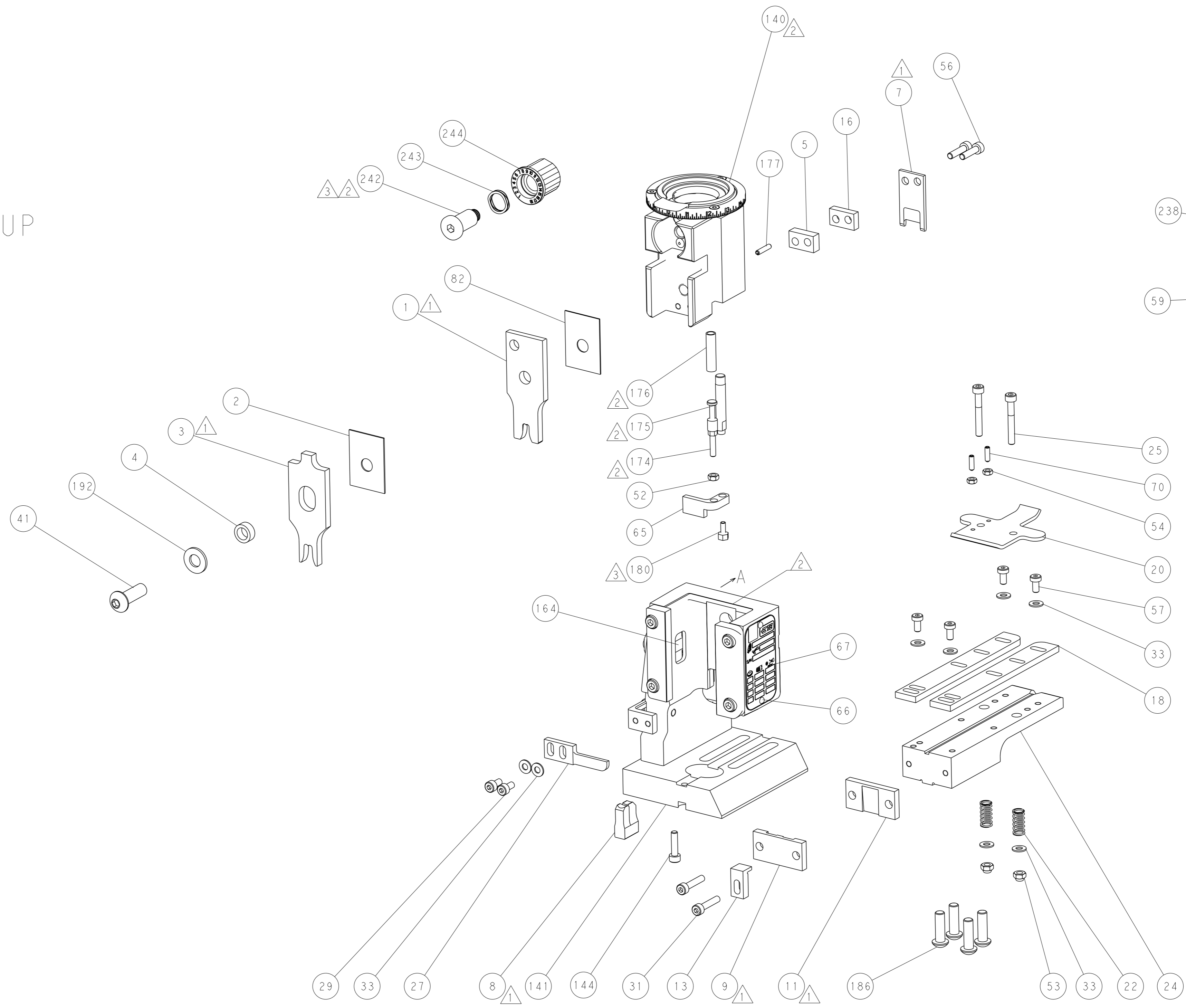
<small>THE DRAWING IS CONTROLLED DOCUMENT FOR THE PRODUCT. ANY CHANGES TO THE DRAWING MUST BE APPROVED BY THE DESIGN ENGINEER AND THE QUALITY CONTROL ENGINEER. THE DRAWING IS SUBJECT TO CHANGE AND THE USER MUST VERIFY THE DRAWING INFORMATION SHOULD BE CONTACTED FOR THE LATEST REVISION.</small>		OWN: J. HOU 3MAR2015 CHK: L. ZHANG 3MAR2015 APVD: U. GUO 3MAR2015	STE TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH ±		NAME: Ocean End Feed Applicator PRODUCT SPEC: - APPLICATION SPEC: - WEIGHT: - MATERIAL: -	SIZE: A1 CAGE CODE: 00779 DRAWING NO: ©=2150531 RESTRICTED TO: - SCALE: 1:1 SHEET 3 OF 4 REV B
Customer Accessible Production Drawing		SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION	

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

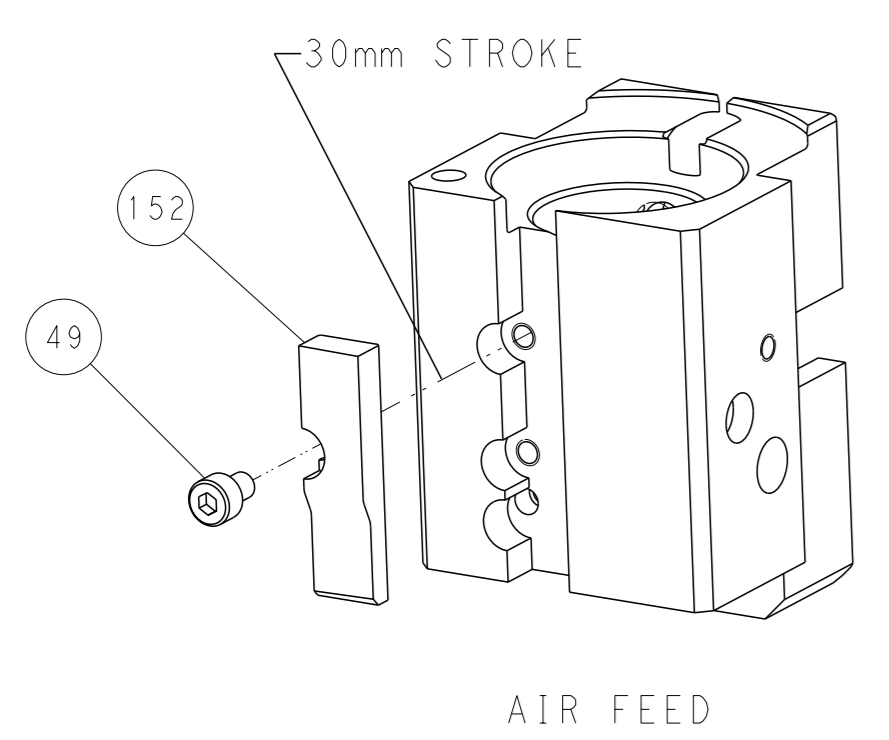


RAM AND HOLDDOWN SET-UP

FEED TYPE



CAM POSITION



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 *		OWN J. HOU 3MAR2015 CHK L. ZHANG 3MAR2015 APVD U. GUO 3MAR2015 PRODUCT SPEC APPLICATION SPEC WEIGHT MATERIAL		NAME SIZE CAGE CODE DRAWING NO RESTRICTED TO	
Customer Accessible Production Drawing		SCALE 1:1		SHEET 4 OF 4 REV B		STE TE Connectivity Harrisburg, PA 17105-3608 Ocean End Feed Applicator A 00779 C=2150531	