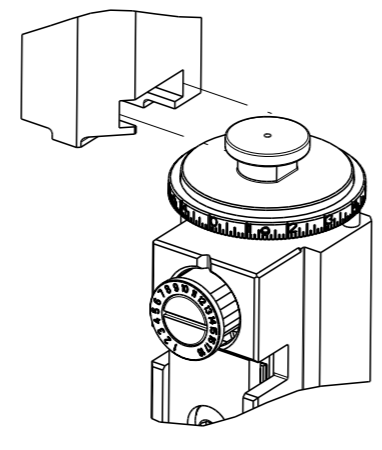


8 7 20

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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150203-1	G	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2150203-2	G	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150203-1	G	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2150203-2	G	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150203-7	G	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA

CRIMP	SIZE	TYPE
WIRE	1.78 mm [.070]	F
INSUL	3.05 mm [.120]	F

APPLICATOR INSTRUCTIONS 408-35043

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION

TERMINAL NAME: .110 SERIES FASTON RECEPTACLE

WIRE STRIP LENGTH	INSULATION DIAMETER RANGE
.125-.156 IN [3.18-3.96 mm]	Ø.063-.120 IN [1.60-3.05 mm]

TERMINAL APPLICATION SPECIFICATION 114-20109

TERMINALS APPLIED

TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
160415-1	160528-1	160533-9	1-160534-0
160415-2	160528-2	1-160533-0	5-160555-1
160424-3	160528-3	160534-1	5-160555-2
160484-1	160528-4	160534-2	5-160555-5
160484-4	160528-5	160534-3	5-160555-7
160484-5	160533-1	160534-4	5-160555-8
160484-7	160533-2	160534-5	6-160555-1
160484-9	160533-5	160534-9	

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.00mm2	1.04+/-0.05 [.041+/-0.002]	8.0
18 AWG OR 0.75mm2	0.99+/-0.05 [.039+/-0.002]	8.5
0.70mm2	0.99+/-0.05 [.039+/-0.002]	8.6
20 AWG OR 0.50mm2	0.94+/-0.05 [.037+/-0.002]	9.1

- 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. APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 50.
- 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.

***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	LYR	DESCRIPTION	DATE	OWN	APVD				
		D	ECR-18-015909	08OCT2018	TB	TE			
		E	ECR-20-002563	21FEB2020	TB	RR			
		F	ECR-20-014467	13OCT2020	FZ	TE			
		G	ECR-20-014839	19OCT2020	JWC	GB			

-	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	
-	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	455888-6	SPACER, CRIMPER	82	
-	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	2063961-6	FEED FINGER	58	
-	3	3	3	3	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57	
-	2	2	2	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	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	-	2063961-6	FEED FINGER	51	
-	1	1	1	1	1752354-6	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	1752371-1	PLATE, STRIP GUIDE	24	
-	1	1	1	1	240825-6	PLATE, STRIP HOLD DOWN	23	
-	2	2	2	2	2-22281-3	SPRING, COMPRESSION	22	
-	1	1	1	1	1803292-1	DRAG	20	
-	1	1	1	1	1803152-3	STRIP GUIDE, REAR	19	
-	1	1	1	1	1803151-3	STRIP GUIDE, FRONT	18	
-	4	4	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17	
-	1	1	1	1	2-240644-6	PLATE, REAR SHEAR	11	
-	2	2	2	2	1-240645-0	SPACER, SHEAR PLATE	10	
-	1	1	1	1	240642-1	PLATE, FRONT SHEAR	9	
-	1	2	2	1	1333215-6	ANVIL, COMBINATION	8	
-	1	1	1	1	240651-4	BLADE, SLUG	7	
-	1	1	1	1	2-240641-4	SPACER	5	
-	1	1	1	1	238011-2	BLOCK, CRIMPER SPACER	4	
-	1	2	2	1	1-1633961-9	CRIMPER, INSULATION F PREMIUM	3	
-	-	-	-	-	-	-	2	
-	1	2	2	1	1	3-456404-8	CRIMPER, WIRE PREMIUM	1
-	77	72	71	2	1	PART NO	DESCRIPTION	ITEM NO

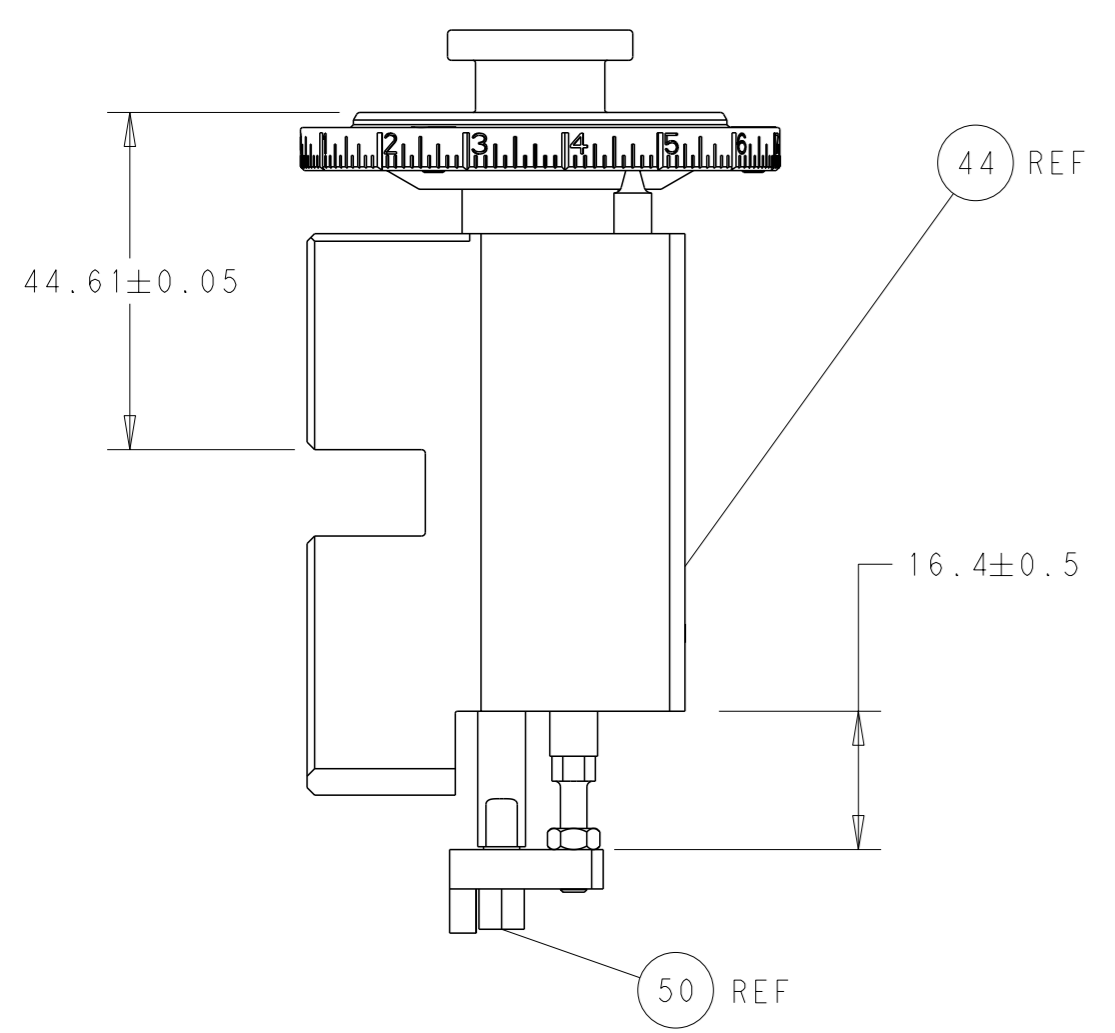
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

TE Connectivity
Harrisburg, PA 17105-3608

Ocean End Feed Applicator

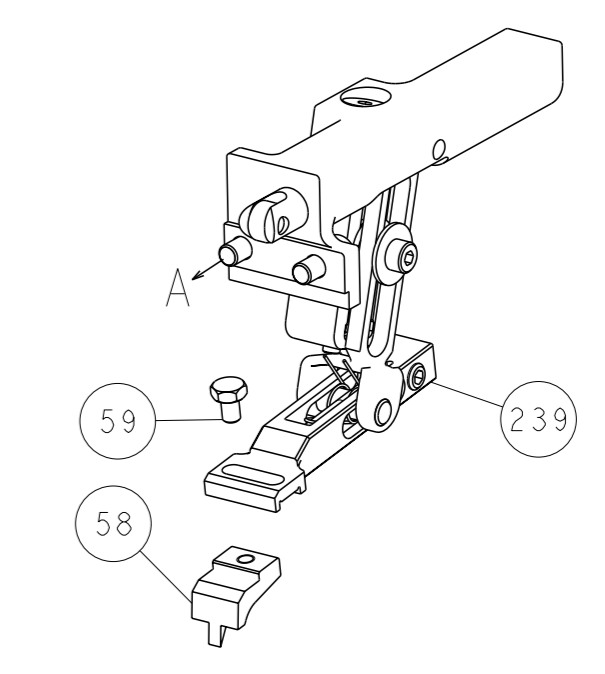
Customer Accessible Production Drawing SCALE 1:1 SHEET 1 OF 4 REV G

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

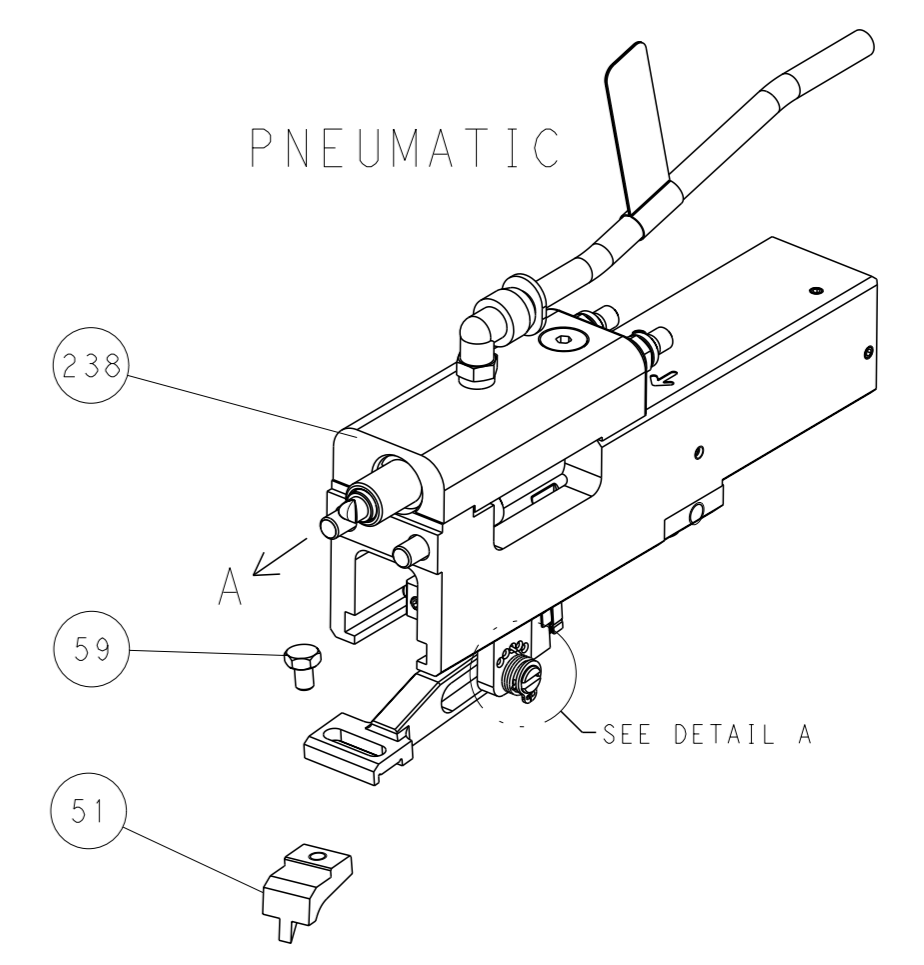


RAM AND HOLDDOWN SET-UP

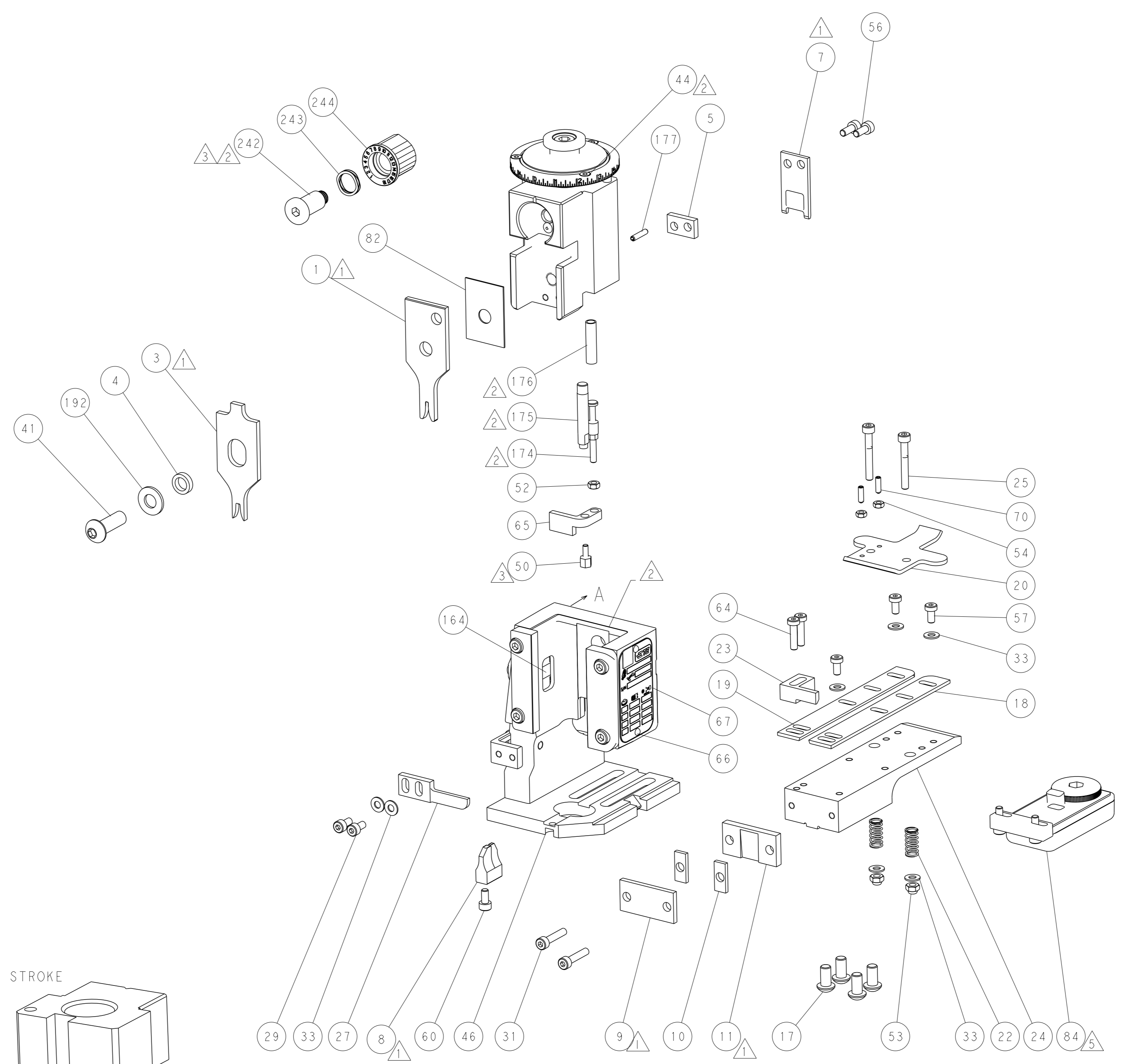
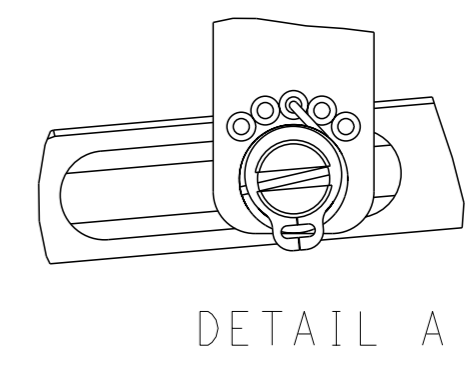
FEED TYPE
MECHANICAL



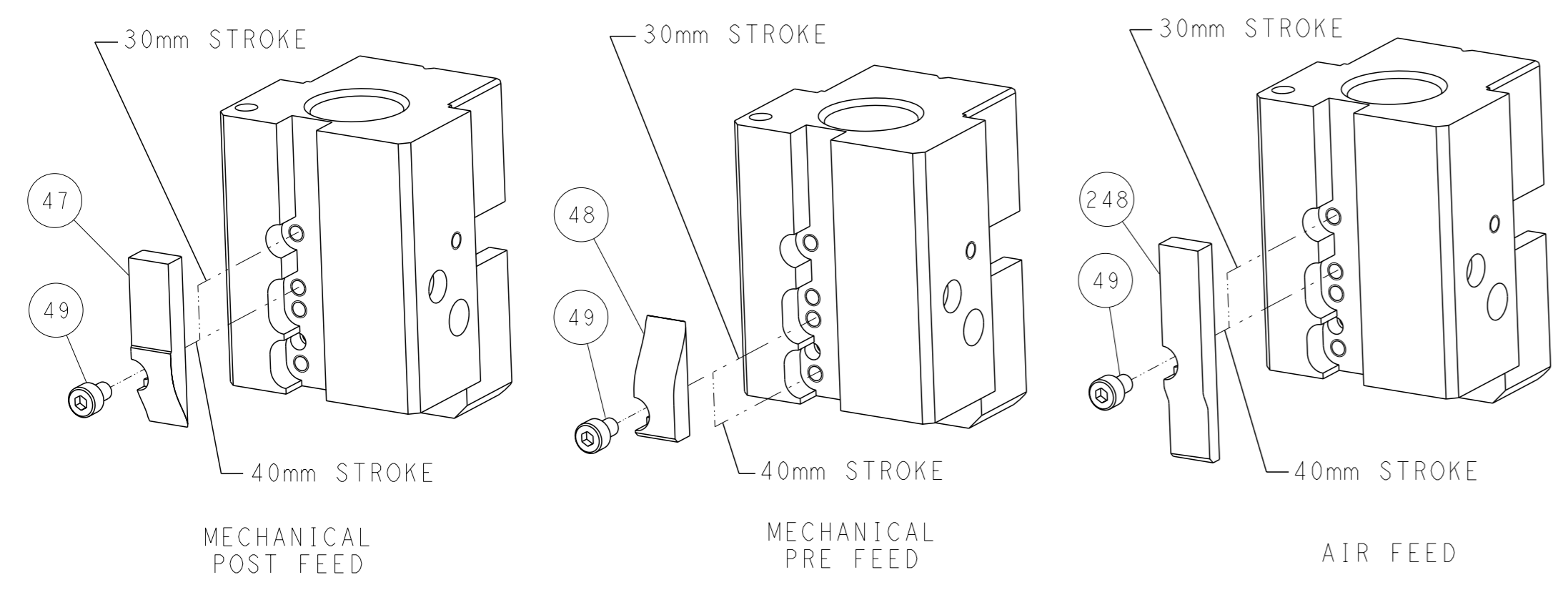
PNEUMATIC



FEED SPRING
SETTING POSITION



CAM POSITIONS

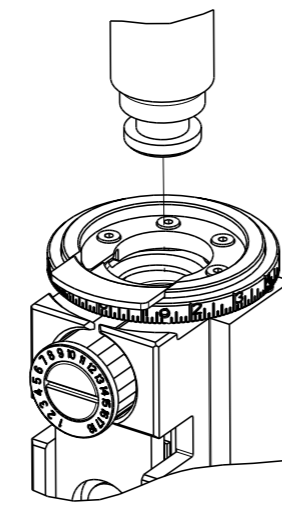


ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

<small>THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION. 20 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.</small>		OWN: C. CHEN 02MAR2012 CHK: S. XI 02MAR2012 APVD: J. CRUZ 02MAR2012	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: C=2150203	RESTRICTED TO: - SCALE: 1:1 SHEET: 2 of 4 REV: G
MATERIAL: - FINISH: -		WEIGHT: - Customer Accessible Production Drawing	SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150203-1	G	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2150203-2	G	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150203-7	G	CRIMP TOOLING KIT	-

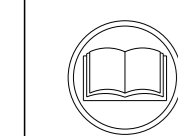
PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.78 mm [.070]	F
INSUL	3.05 mm [1.20]	F
APPLICATOR INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: .110 SERIES FASTON RECEPTACLE			
WIRE STRIP LENGTH .125-.156 IN [3.18-3.96 mm]		INSULATION DIAMETER RANGE Ø.063-.120 IN [1.60-3.05 mm]	
TERMINAL APPLICATION SPECIFICATION	114-20109	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
160415-1	160528-1	160533-9	1-160534-0
160415-2	160528-2	1-160533-0	5-160555-1
160424-3	160528-3	160534-1	5-160555-2
160484-1	160528-4	160534-2	5-160555-5
160484-4	160528-5	160534-3	5-160555-7
160484-5	160533-1	160534-4	5-160555-8
160484-7	160533-2	160534-5	6-160555-1
160484-9	160533-5	160534-9	

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.00mm2	1.04 +/- 0.05 [1.041 +/- .002]	8.0
18 AWG OR 0.75mm2	0.99 +/- 0.05 [1.039 +/- .002]	8.5
0.70mm2	0.99 +/- 0.05 [1.039 +/- .002]	8.6
20 AWG OR 0.50mm2	0.94 +/- 0.05 [1.037 +/- .002]	9.1



- 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. APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 50.
- 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.

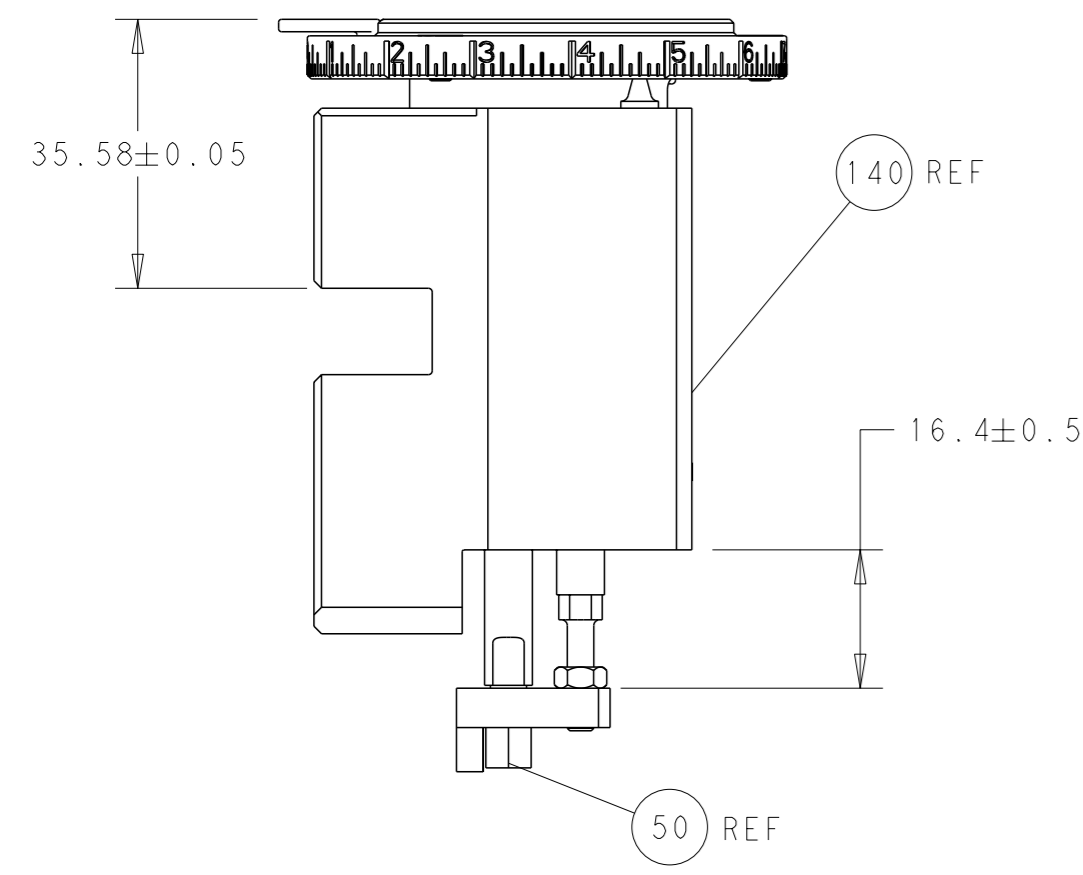
LOC	DIST	REVISIONS					
		P	LY#	DESCRIPTION	DATE	OWN	APVD
A	66	-	-	SEE SHEET 1	-	-	-

-	1	1	2119082-8	CAM, SNAIL, INSULATION ADJUSTMENT	244	
-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243	
-	1	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	
-	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	1803518-1	RAM ASSEMBLY, EF PACIFIC	140	
-	1	1	2119955-2	ASSY, LUBRICATOR, END FEED	84	
-	1	1	455888-6	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	1901681-5	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	2063961-6	FEED FINGER	58	
-	3	3	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57	
-	2	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	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	-	2063961-6	FEED FINGER	51	
-	1	1	1752354-6	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	1752371-1	PLATE, STRIP GUIDE	24	
-	1	1	240825-6	PLATE, STRIP HOLD DOWN	23	
-	2	2	2-22281-3	SPRING, COMPRESSION	22	
-	1	1	1803292-1	DRAG	20	
-	1	1	1803152-3	STRIP GUIDE, REAR	19	
-	1	1	1803151-3	STRIP GUIDE, FRONT	18	
-	1	1	2-240644-6	PLATE, REAR SHEAR	11	
-	2	2	1-240645-0	SPACER, SHEAR PLATE	10	
-	1	1	240642-1	PLATE, FRONT SHEAR	9	
-	1	1	1333215-6	ANVIL, COMBINATION	8	
-	1	1	240651-4	BLADE, SLUG	7	
-	1	1	2-240641-4	SPACER	5	
-	1	1	238011-2	BLOCK, CRIMPER SPACER	4	
-	1	1	1-1633961-9	CRIMPER, INSULATION F PREMIUM	3	
-	-	-	-	-	2	
-	1	1	1	3-456404-8	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)

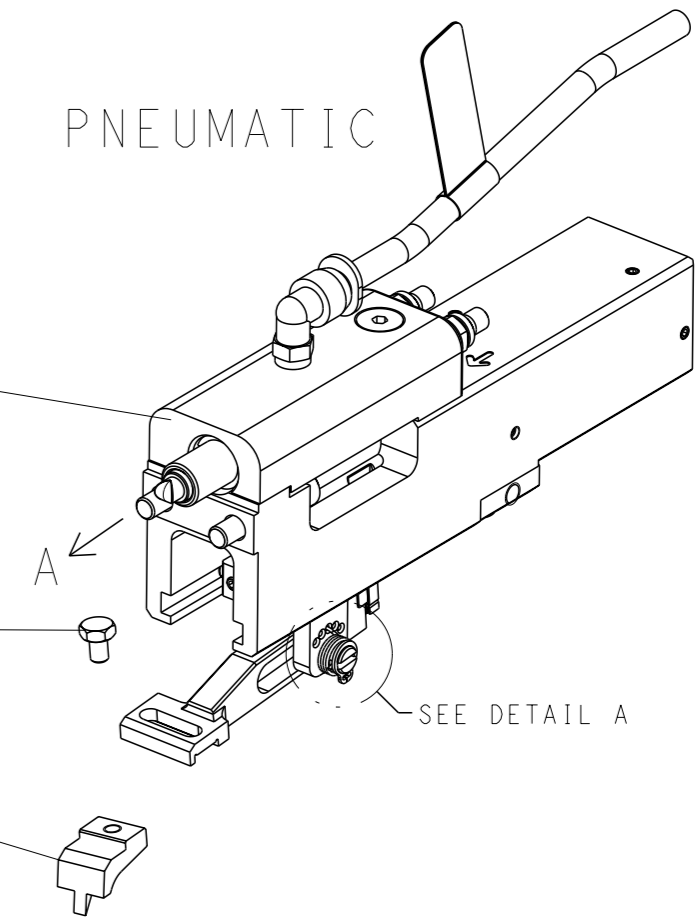
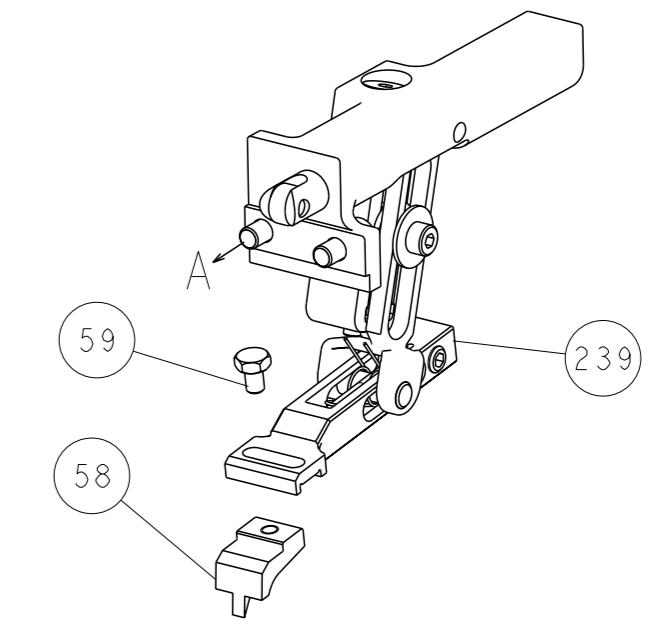
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN S. CHEN CHK S. XI APVD J. CRUZ		02MAR2012 02MAR2012 02MAR2012		NAME Ocean End Feed Applicator	
mm	0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ±	mm	± ± ± ± ±	PRODUCT SPEC		APPLICATION SPEC		SIZE A1	
MATERIAL	FINISH	WEIGHT		SCALE		SHEET		REV	
				1:1		3 of 4		G	

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

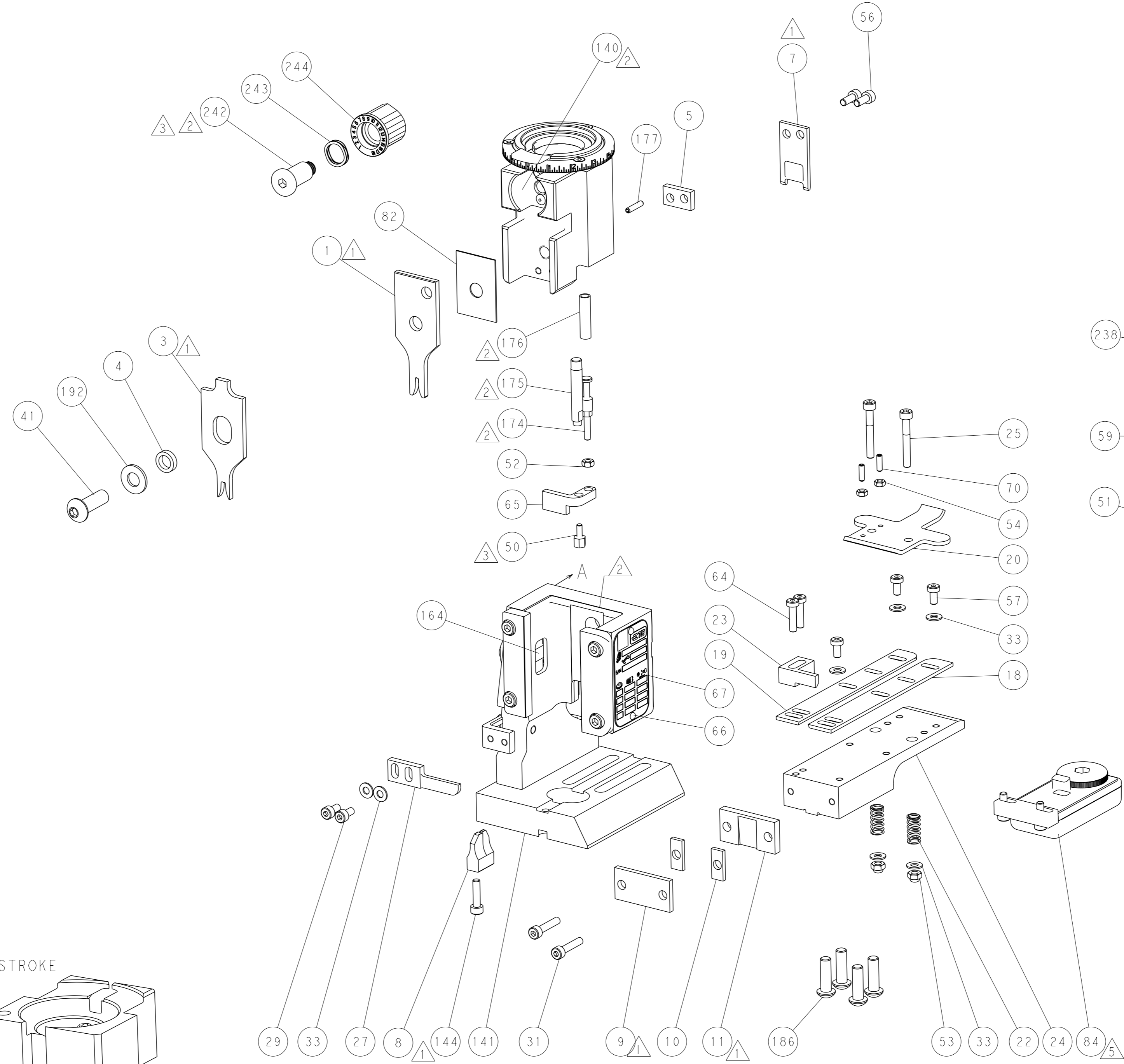
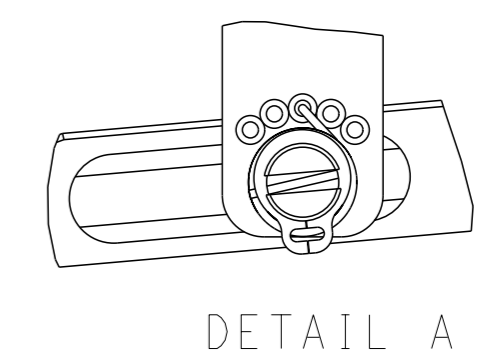


RAM AND HOLDDOWN SET-UP

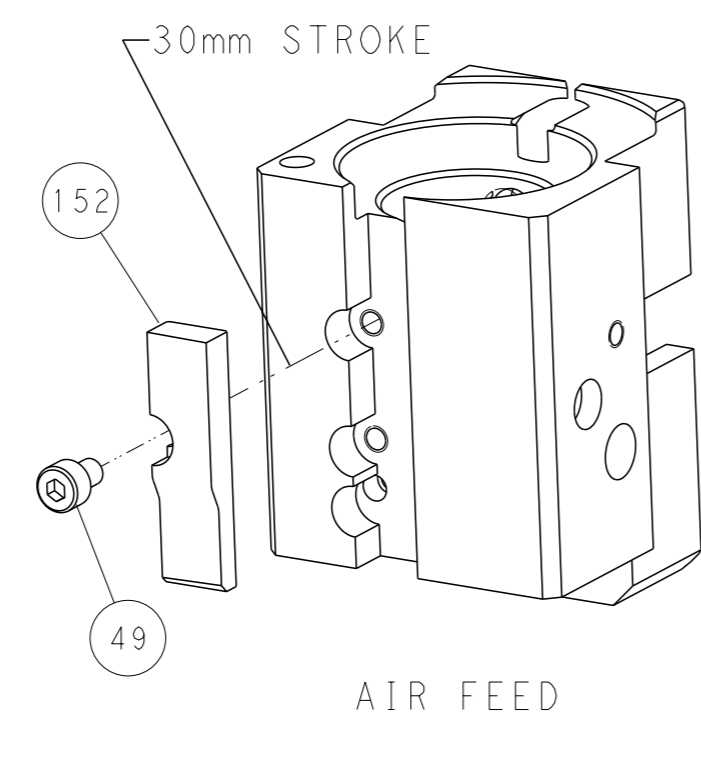
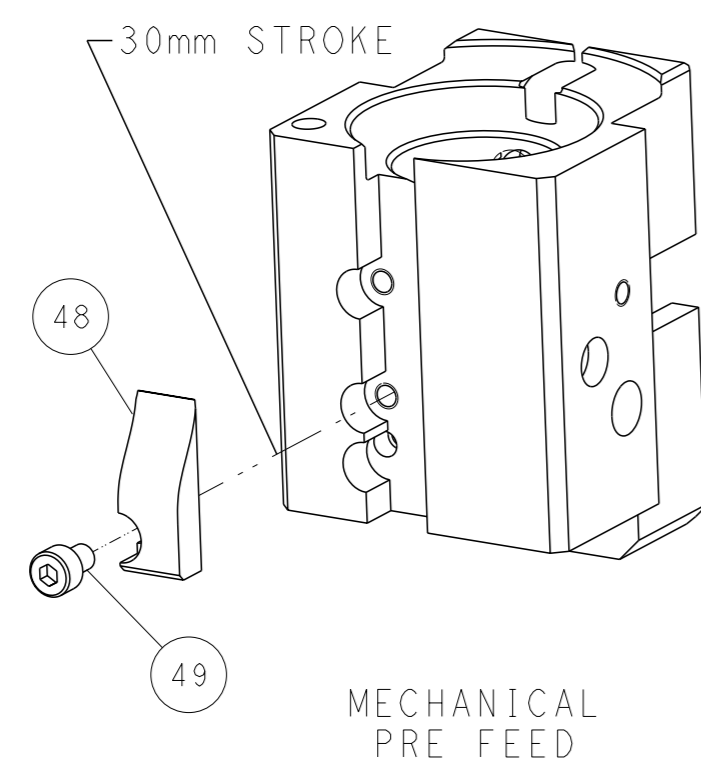
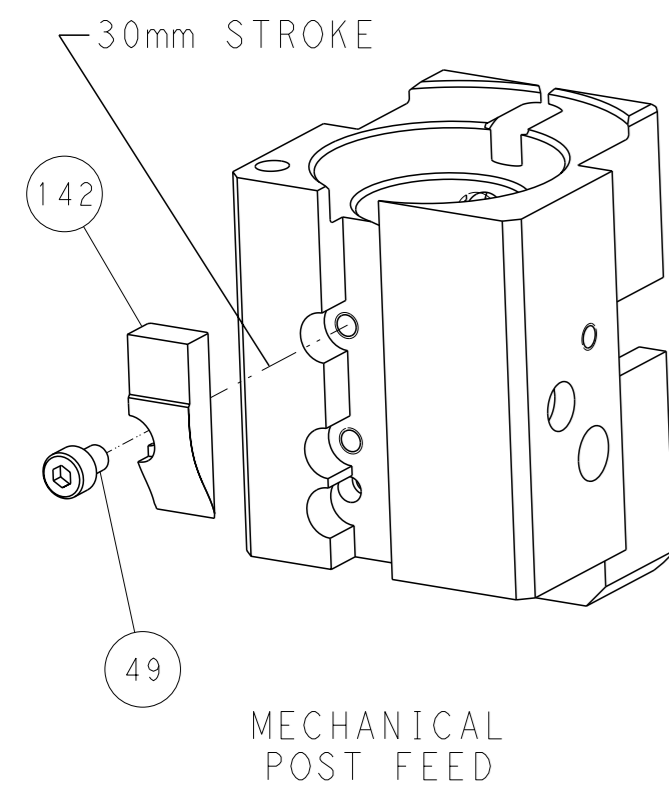
FEED TYPE
MECHANICAL



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:		OWN: C. CHEN 02MAR2012		STE TE Connectivity	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	Harrisburg, PA 17105-3608	
MATERIAL:	FINISH:	APVD: J. CRUZ 02MAR2012	NAME: Ocean End Feed Applicator	SIZE: A1	CAGE CODE: 00779	DRAWING NO: C=2150203	RESTRICTED TO:
Customer Accessible Production Drawing				SCALE: 1:1	SHEET: 4	OF: 4	REV: G