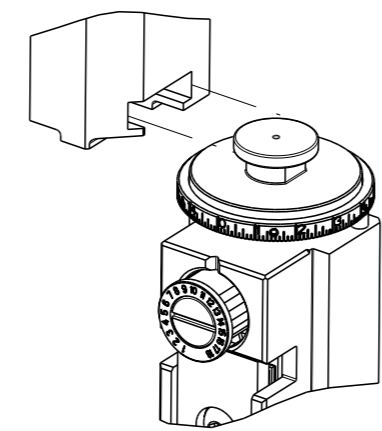


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150020-2	D	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150020-2	D	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150020-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	3.30 mm [.130]	F
INSUL	4.06 mm [.160]	F
APPLICATOR INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: RING TONGUE			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
4.82-5.58 mm [.190-.220 IN]		∅2.16-3.60 mm [.085-.142 IN]	
TERMINAL APPLICATION SPECIFICATION	114-37010	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
626034-1	626034-2	626034-3	626034-4

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
2.50mm2	2.41 +/- 0.05 [1.095 +/- .002]	5.2
2.00mm2	2.29 +/- 0.05 [1.090 +/- .002]	6.4
1.50mm2	2.18 +/- 0.05 [1.086 +/- .002]	7.5
1.00mm2	2.05 +/- 0.05 [1.081 +/- .002]	9.1

- 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 LUBRICANT IS RECOMMENDED.
  - TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FE7D.
7. 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)

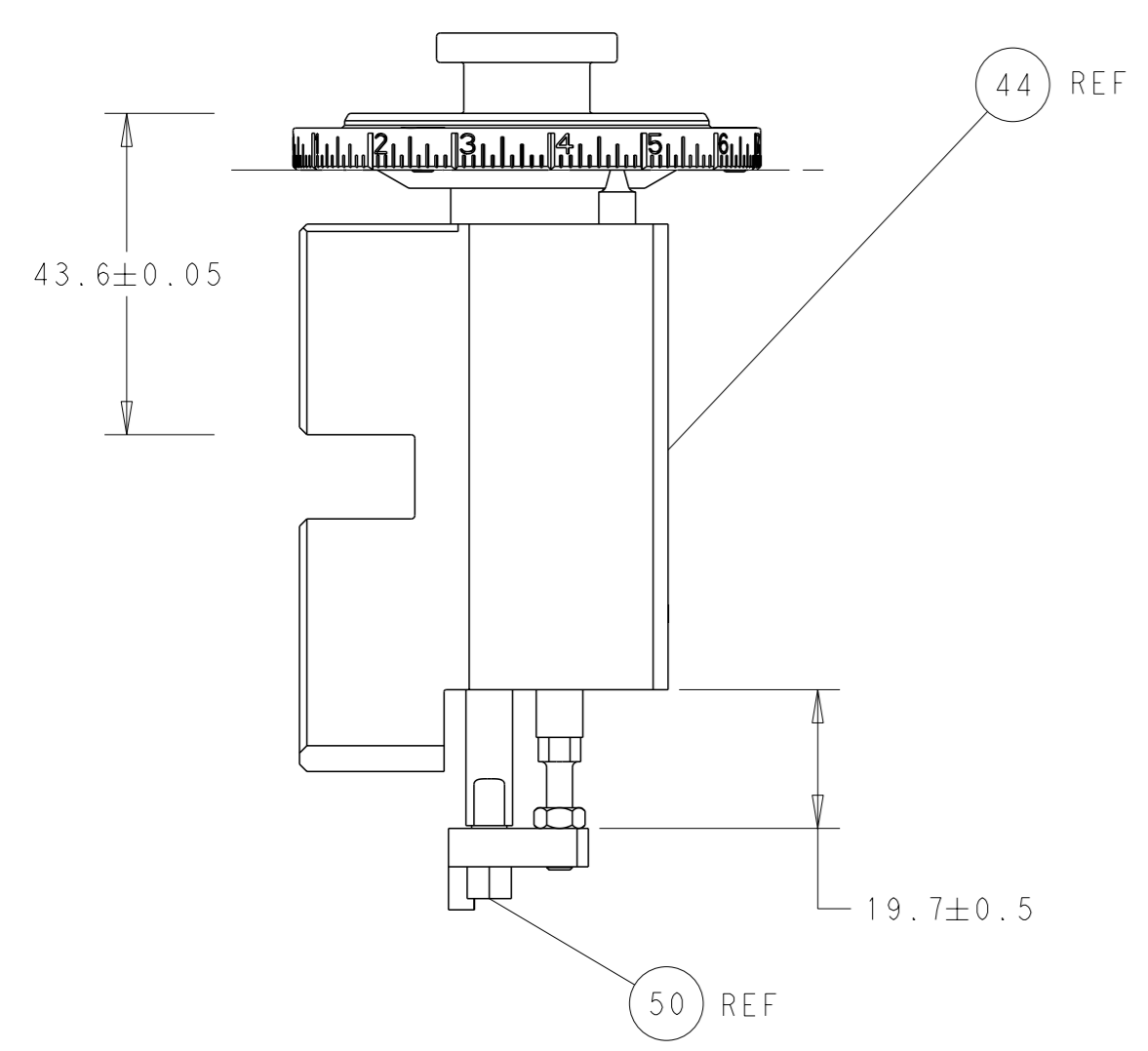
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A	66	P	LYH	DESCRIPTION	DATE	OWN	APVD
		B		ECR-13-015279	29SEP2013	KH	TE
		C		ECR-17-010758	25JUL2017	MZ	KZ
		D		ECR-19-019276	11DEC2019	FJ	TE
		D1		ECR-21-001785	10FEB2021	JWC	GB

-	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	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	
-	REF	REF	994970-2	COUNTER, MAGNETIC	164	
	-	1	2119955-2	ASSY, LUBRICATOR, END FEED	84	
-	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	2063961-9	FEED FINGER	51	
-	1	1	1752354-2	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	1-1752371-2	PLATE, STRIP GUIDE	24	
-	2	2	2-22281-3	SPRING, COMPRESSION	22	
-	1	1	1803292-4	DRAG	20	
-	1	1	1-1901696-0	STRIP GUIDE, REAR	19	
-	1	1	1-1901695-0	STRIP GUIDE, FRONT	18	
-	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17	
-	1	1	1-240641-0	SPACER	16	
-	1	1	1752360-1	SPACER, HOLD-DOWN	13	
	-	1	240644-5	PLATE, REAR SHEAR	11	
-	-	-	-	-	10	
	-	1	3-690482-4	PLATE, FRONT SHEAR	9	
	1	2	1-1333221-3	ANVIL, EF .130	8	
	-	1	2217206-4	BLADE, SLUG	7	
-	1	1	7-240641-5	SPACER	5	
-	1	1	238011-2	BLOCK, CRIMPER SPACER	4	
	1	2	3-2119582-4	CRIMPER, INSULATION F PREMIUM	3	
	-	1	1-455888-1	SPACER, CRIMPER	2	
	1	2	456424-9	CRIMPER, WIRE 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 ±	APVD	NAME
	ANGLES	FINISH		APVD	NAME		
MATERIAL				APVD	NAME		

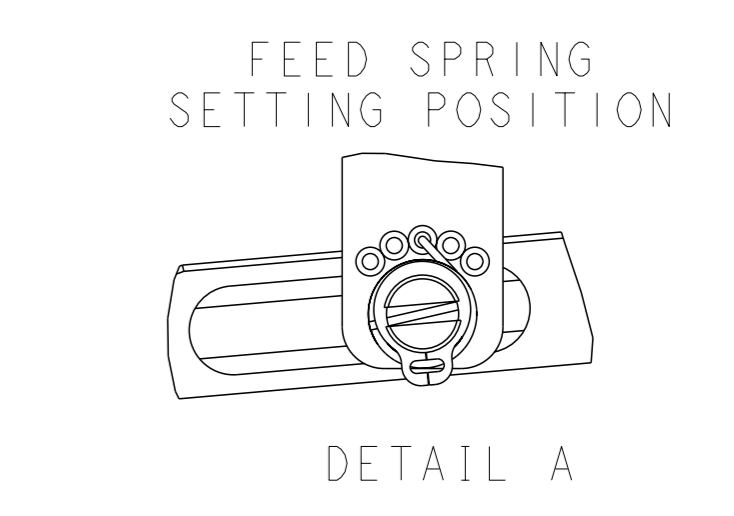
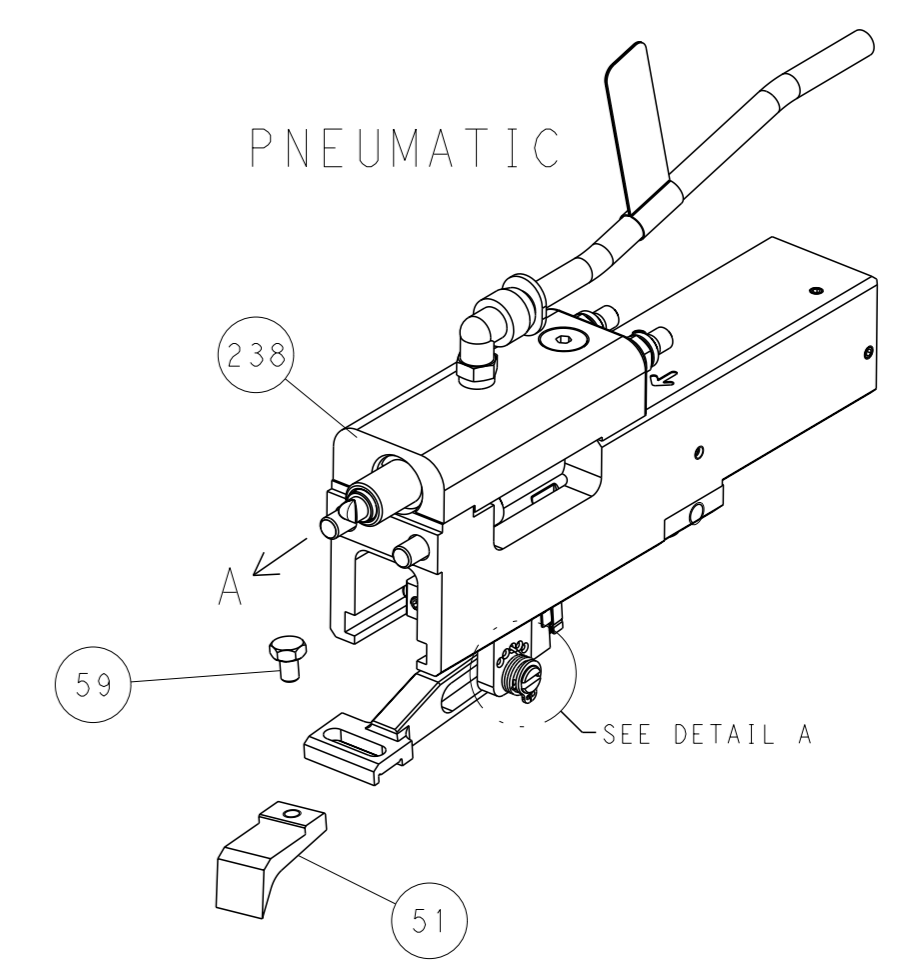
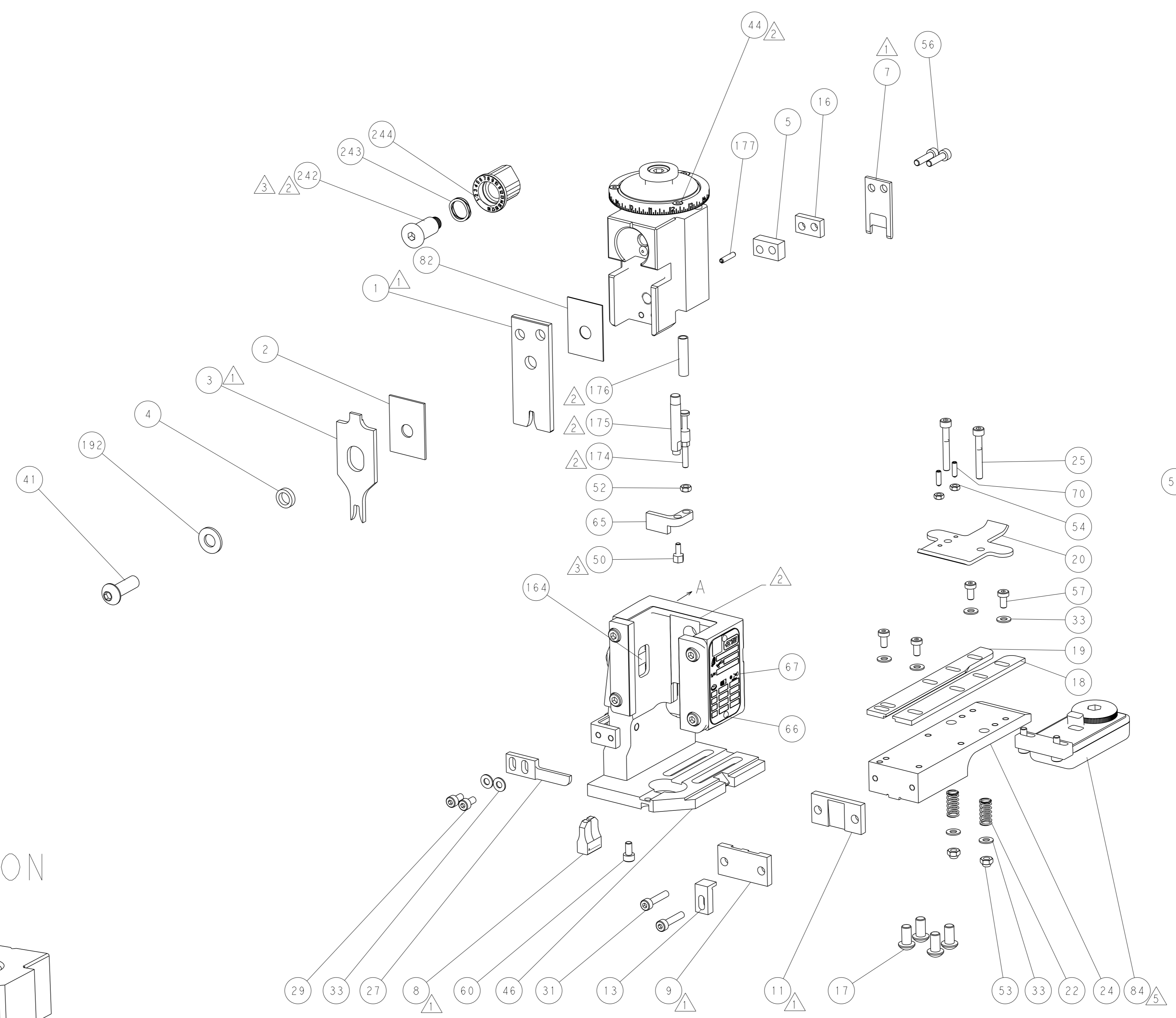
OWN	C. CHEN	23DEC2011		TE Connectivity
CHK	S. XI	23DEC2011		Harrisburg, PA 17105-3608
APVD	J. CRUZ	23DEC2011	Ocean End Feed Applicator	
SIZE	A1	00779	C=2150020	RESTRICTED TO
WEIGHT			Customer Accessible Production Drawing	SCALE 1:1 SHEET 1 of 4 REV D1

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

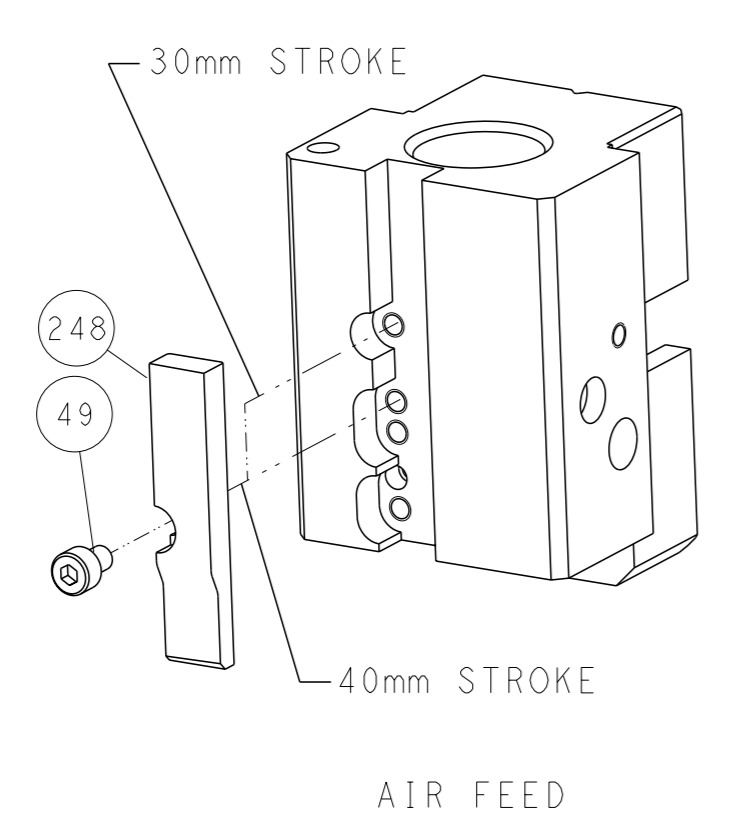


RAM AND HOLDDOWN SET-UP

FEED TYPE



CAM POSITION



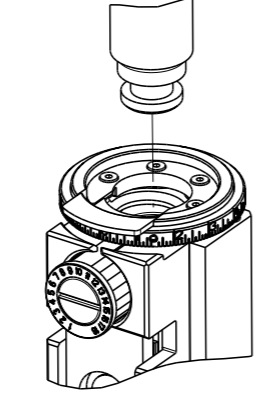
AIR FEED

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 20 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.</small>		DWN: C.CHEN 23DEC2011 CHK: S.XI 23DEC2011 APVD: J.CRUZ 23DEC2011	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=2150020	RESTRICTED TO: - SCALE: 1:1 SHEET: 2 of 4 REV: D1
MATERIAL: - FINISH: -		WEIGHT: - Customer Accessible Production Drawing	SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150020-2	D	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150020-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR  
 INTERFACE ADAPTER



APPLICATOR DATA

CRIMP	SIZE	TYPE
WIRE	3.30 mm [.130]	F
INSUL	4.06 mm [.160]	F

APPLICATOR INSTRUCTIONS  
 408-35043

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION

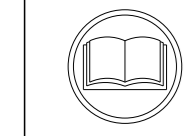
TERMINAL NAME: RING TONGUE

WIRE STRIP LENGTH	INSULATION DIAMETER RANGE
4.82-5.58 mm [.190-.220 IN]	Ø2.16-3.60 mm [.085-.142 IN]

TERMINAL APPLICATION SPECIFICATION

TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
626034-1	626034-2	626034-3	626034-4

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
2.50mm2	2.41 +/- 0.05 [.095 +/- .002]	5.2
2.00mm2	2.29 +/- 0.05 [.090 +/- .002]	6.4
1.50mm2	2.18 +/- 0.05 [.086 +/- .002]	7.5
1.00mm2	2.05 +/- 0.05 [.081 +/- .002]	9.1



- 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 50. 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 LUBRICANT IS RECOMMENDED.
  - 6 TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
7. 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.

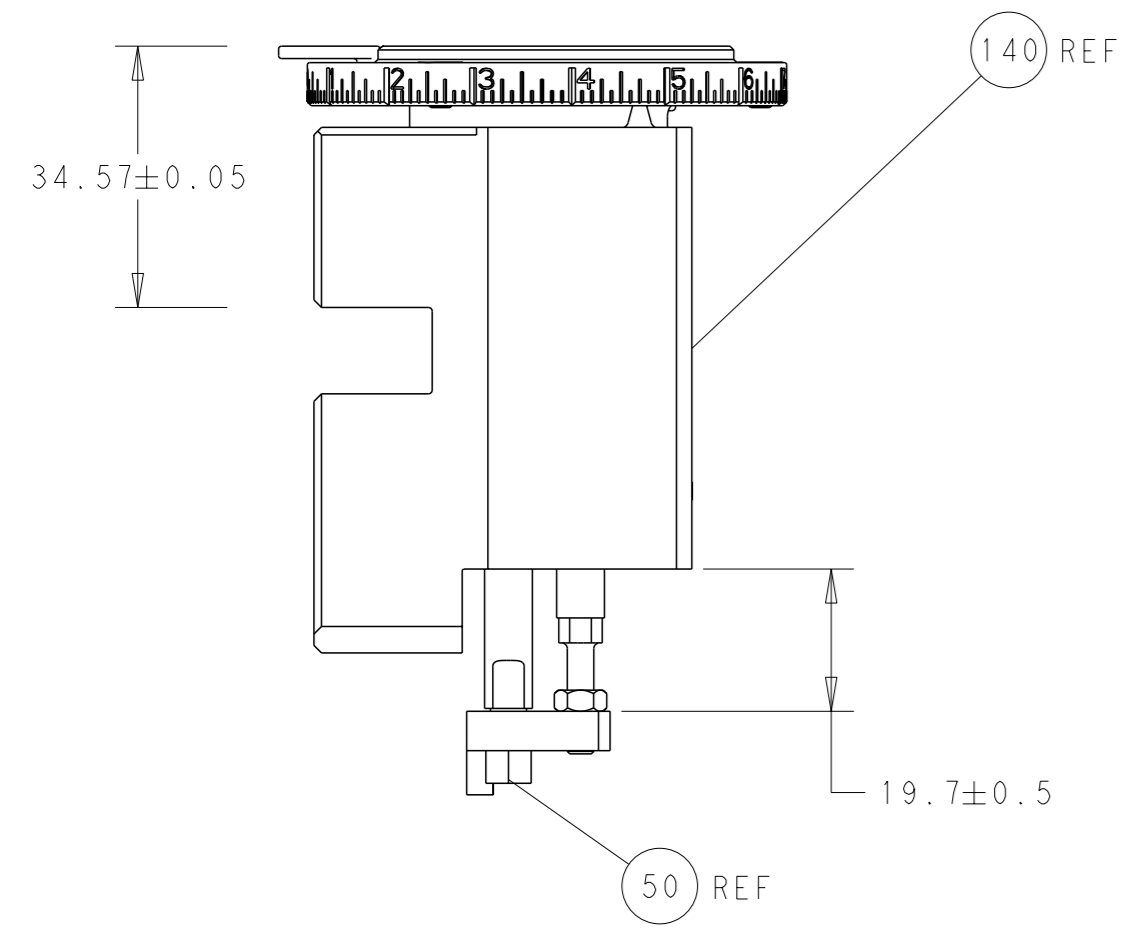
PACIFIC VERSION  
 Shown on sheets 3 of 4 & 4 of 4  
 (Atlantic version shown on sheets 1 of 4 & 2 of 4)

LOC	DIST	REV	DATE	BY	APPV
A	66				

REV	DATE	DESCRIPTION	DATE	OWN	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	2119955-2	ASSY, LUBRICATOR, END FEED		84
-	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	1752354-2	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	1-1752371-2	PLATE, STRIP GUIDE		24
-	2	2-22281-3	SPRING, COMPRESSION		22
-	1	1803292-4	DRAG		20
-	1	1-1901696-0	STRIP GUIDE, REAR		19
-	1	1-1901695-0	STRIP GUIDE, FRONT		18
-	1	1-240641-0	SPACER		16
-	1	1752360-1	SPACER, HOLD-DOWN		13
-	1	240644-5	PLATE, REAR SHEAR		11
-	-	-	-		10
-	1	3-690482-4	PLATE, FRONT SHEAR		9
1	1	1-1333221-3	ANVIL, EF .130		8
-	1	2217206-4	BLADE, SLUG		7
-	1	7-240641-5	SPACER		5
-	1	238011-2	BLOCK, CRIMPER SPACER		4
1	1	3-2119582-4	CRIMPER, INSULATION F PREMIUM		3
-	1	1-455888-1	SPACER, CRIMPER		2
1	1	456424-9	CRIMPER, WIRE PREMIUM		1
-	77-22	PART NO	DESCRIPTION	ITEM NO	

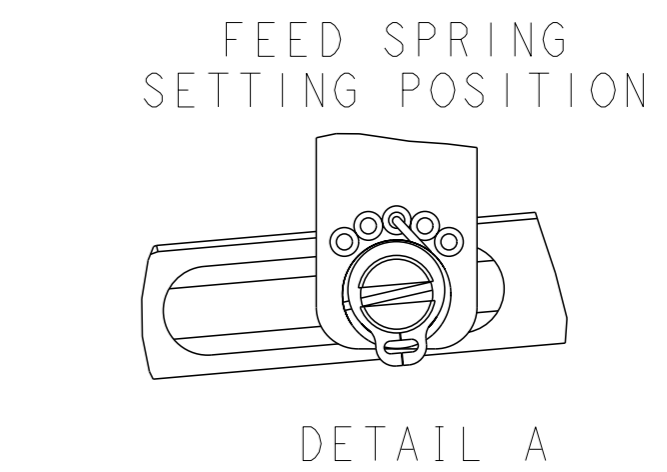
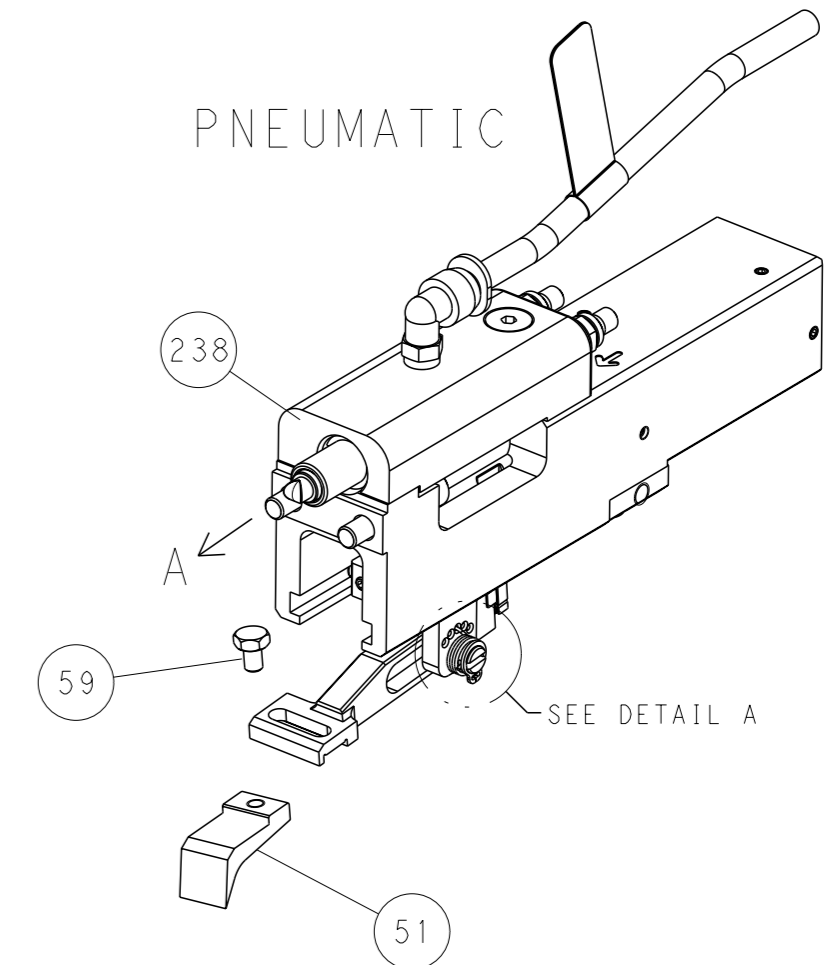
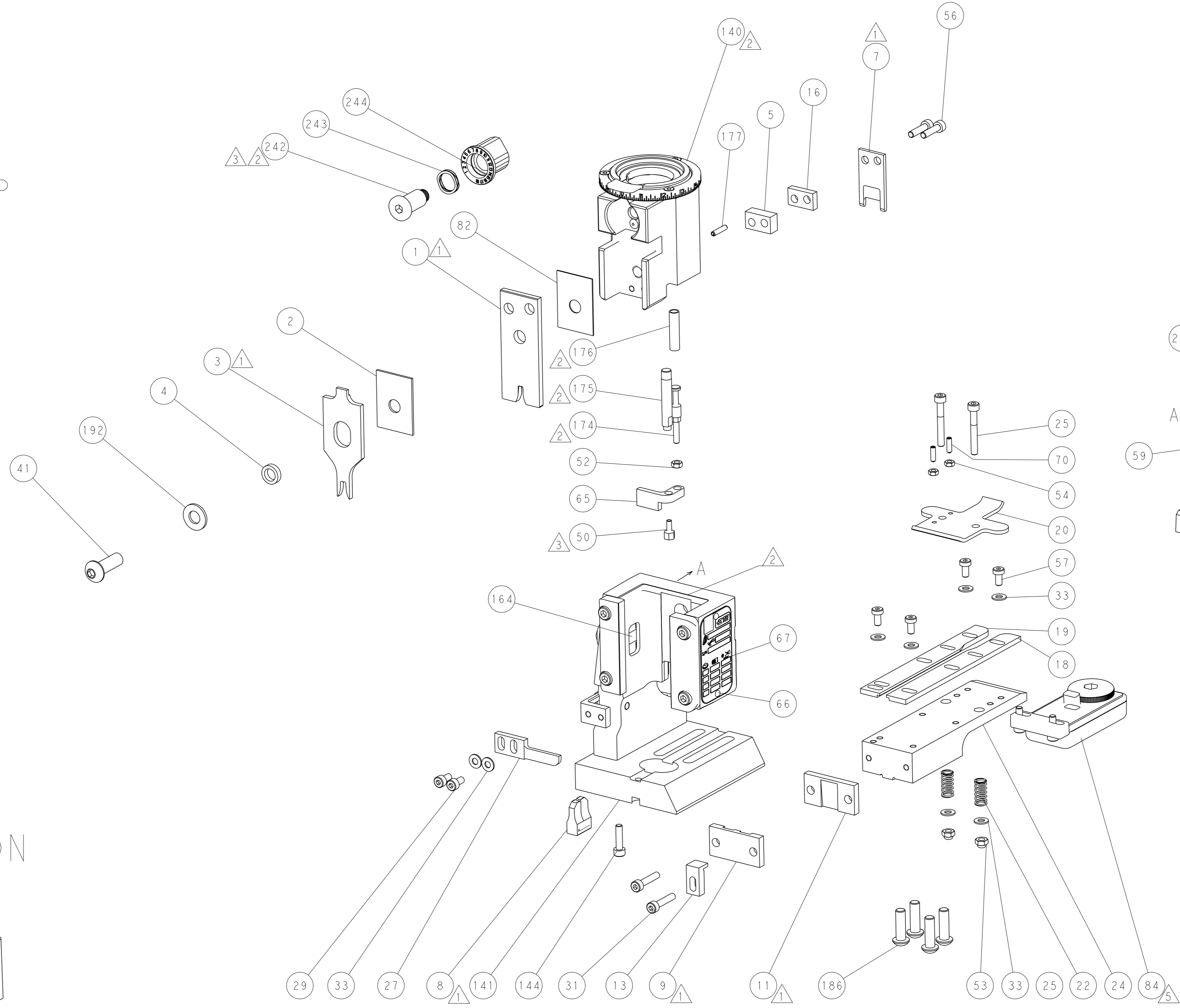
DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH ±		DWN C. CHEN 23DEC2011 CHK S. XI 23DEC2011 APVD J. CRUZ 23DEC2011 PRODUCT SPEC APPLICATION SPEC WEIGHT MATERIAL		NAME Ocean End Feed Applicator SIZE CAGE CODE DRAWING NO A1 00779 C=2150020 RESTRICTED TO	
Customer Accessible Production Drawing				SCALE 1:1		SHEET 3 OF 4 REV D1	

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

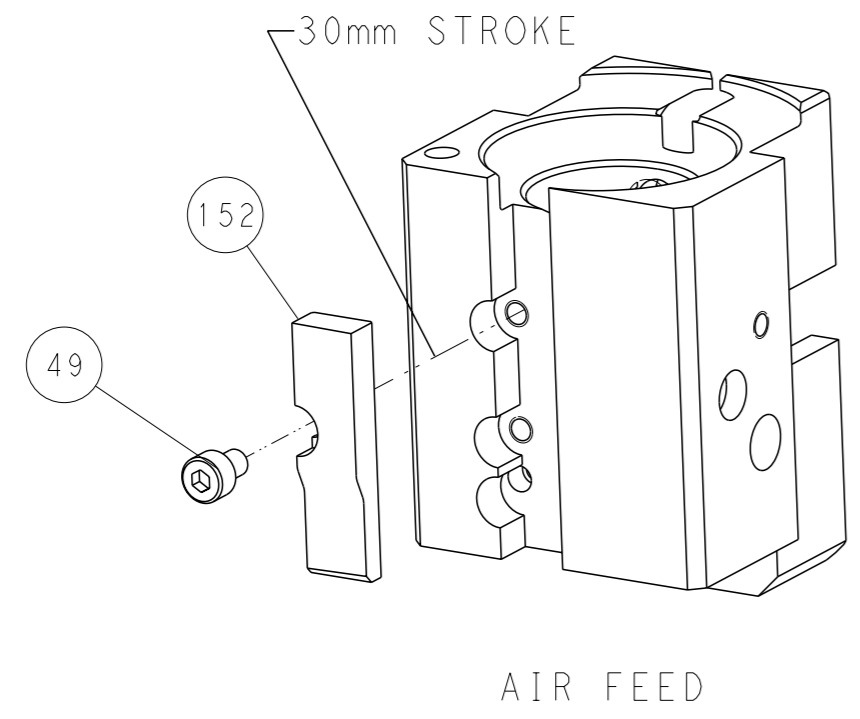


RAM AND HOLDDOWN SET-UP

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)

<small>THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE AND THE USER AND ENGINEERING ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST REVISION.</small>		OWN: C. CHEN CHK: S. XI APVD: J. CRUZ	23DEC2011 23DEC2011 23DEC2011	NAME: Ocean End Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2150020	RESTRICTED TO: - SCALE: 1:1 SHEET: 4 of 4 REV: D1
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH *		STE TE Connectivity Harrisburg, PA 17105-3608			