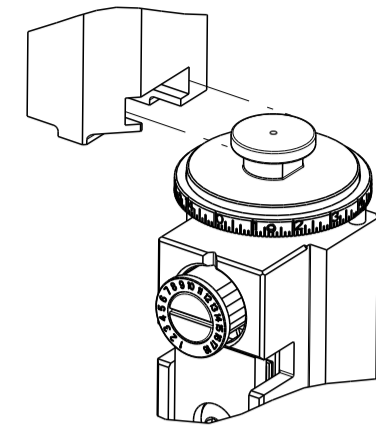


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150356-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2150356-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150356-1	B	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2150356-2	C	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150356-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	3.05 mm [.120]	F
INSUL	4.57 mm [.180]	O
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION			
TERMINAL NAME: RING			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
3.18-3.18 mm [.125-.125 IN]		∅2.54-3.43 mm [.100-.135 IN]	
TERMINAL APPLICATION SPECIFICATION	114-2084		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
61386-1	61386-2		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
16 AWG	1.83+/-0.05 [0.072+/-0.002]	5.0
18 AWG	1.68+/-0.05 [0.066+/-0.002]	6.5
20 AWG	1.60+/-0.05 [0.063+/-0.002]	7.5

- 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.
- 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.

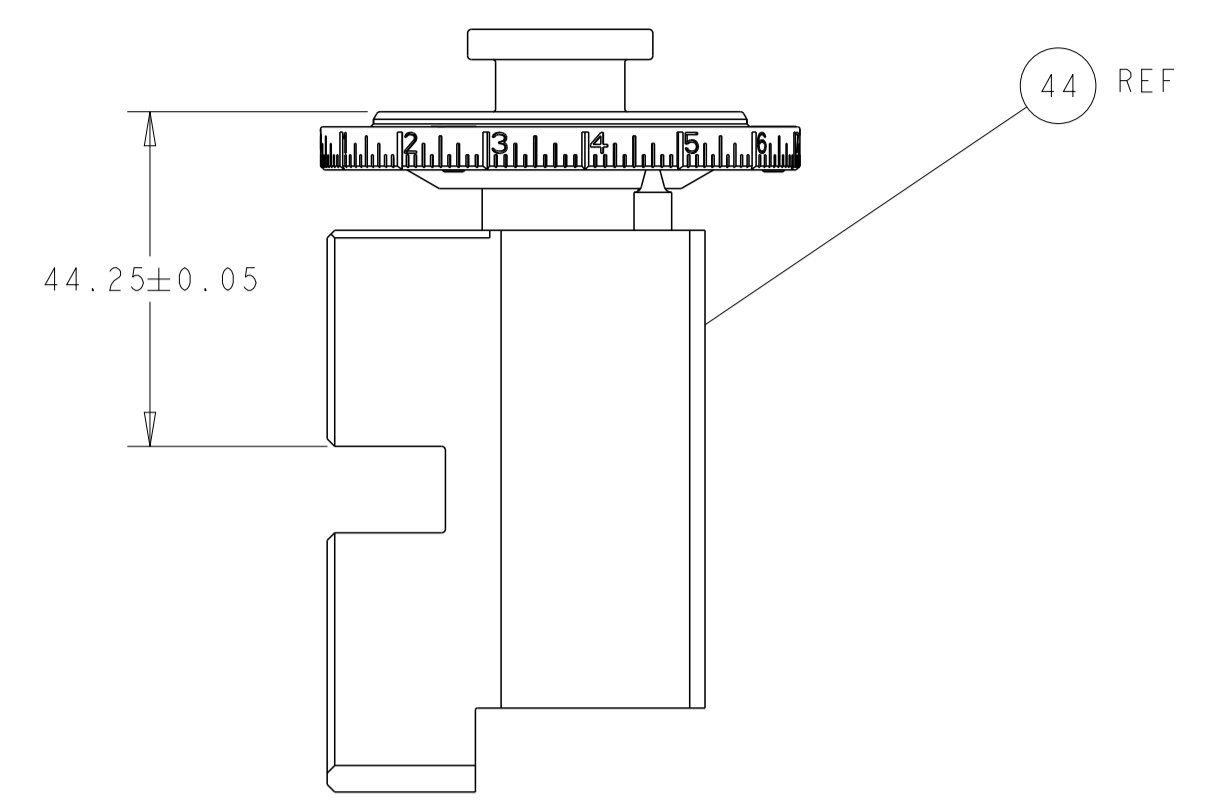
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

LOC	DIST	REVISIONS					
A	66	P	LTN	DESCRIPTION	DATE	DWN	APVD
		1		DEVELOPMENT	31JUL2013	CC	UG
		A		RELEASED	05SEP2013	BH	BH
		B		ECR-19-000718	16JAN2019	MZ	YY
		C		ECR-22-126956	18JAN2022	JWC	TE

-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248	
-	1	1	1	1	2119082-9	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	
-	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164	
-	1	1	1	1	2119955-2	ASSY, LUBRICATOR, END FEED	84	
-	1	1	1	1	455888-4	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	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	2168083-5	SCR, SKT HD CAP, RoHS, M4 X 6.0	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	-	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	1803517-1	RAM ASSEMBLY, EF ATLANTIC	44	
-	1	1	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41	
-	8	8	8	8	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	1752371-5	PLATE, STRIP GUIDE	24	
-	2	2	2	2	2-22281-3	SPRING, COMPRESSION	22	
-	1	1	1	1	1803292-4	DRAG	20	
-	1	1	1	1	1-1901696-2	STRIP GUIDE, REAR	19	
-	1	1	1	1	1-1901695-2	STRIP GUIDE, FRONT	18	
-	4	4	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17	
-	1	1	1	1	240644-1	PLATE, REAR SHEAR	11	
-	-	-	-	-	-	-	10	
-	1	1	1	1	690482-1	PLATE, FRONT SHEAR	9	
-	1	2	2	1	1	7-1633384-5	ANVIL, COMBINATION	8
-	1	1	1	1	2217206-1	BLADE, SLUG	7	
-	-	-	-	-	-	-	6	
-	1	1	1	1	1-240641-9	SPACER	5	
-	1	1	1	1	238011-2	BLOCK, CRIMPER SPACER	4	
-	1	2	2	1	1	6-2119784-0	CRIMPER, INSULATION O PREMIUM	3
-	1	1	1	1	455888-1	SPACER, CRIMPER	2	
-	1	2	2	1	1	456409-2	CRIMPER, WIRE .120 "F" PREMIUM	1
-	77	72	71	2	-1	PART NO	DESCRIPTION	ITEM NO

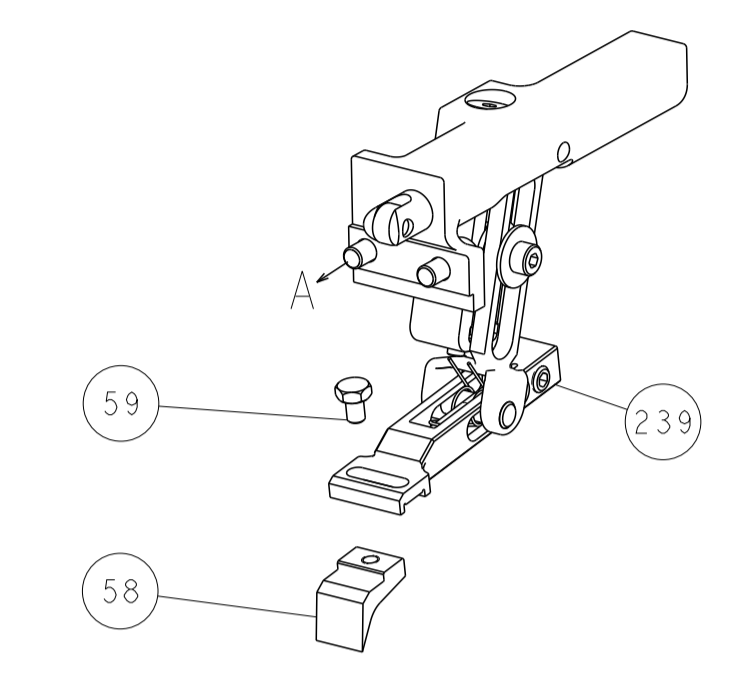
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN		31JUL2013	
mm		0 PLC ±		CHK		C. CHEN	
		1 PLC ±		CHK		31JUL2013	
		2 PLC ±		APVD		U. GUO	
		3 PLC ±		APVD		31JUL2013	
		4 PLC ±		NAME		Ocean End Feed	
		5 PLC ±		PRODUCT SPEC		Applicator	
		FINISH		APPLICATION SPEC		-	
MATERIAL		FINISH		SIZE		CAGE CODE	
-		-		A1		00779	
				DRAWING NO		2150356	
				RESTRICTED TO		-	
				WEIGHT		-	
				SCALE		1:1	
				SHEET		1 of 4	
				REV		C	

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

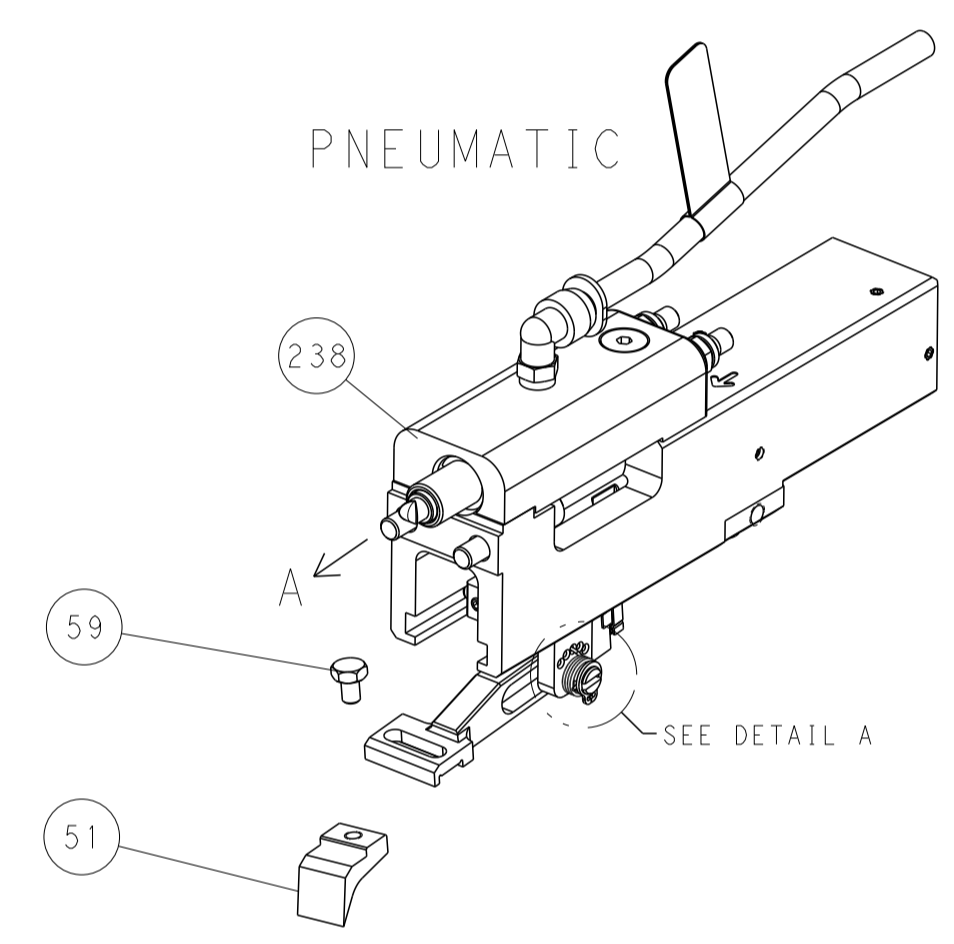


FEED TYPE MECHANICAL

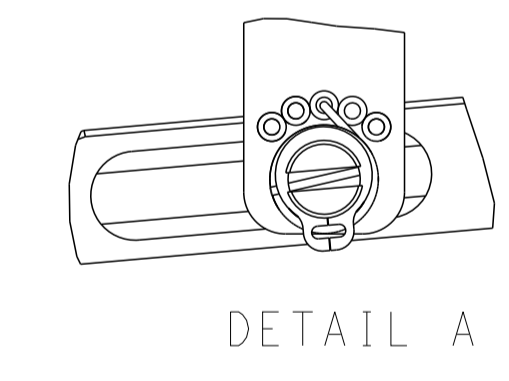
RAM SET-UP



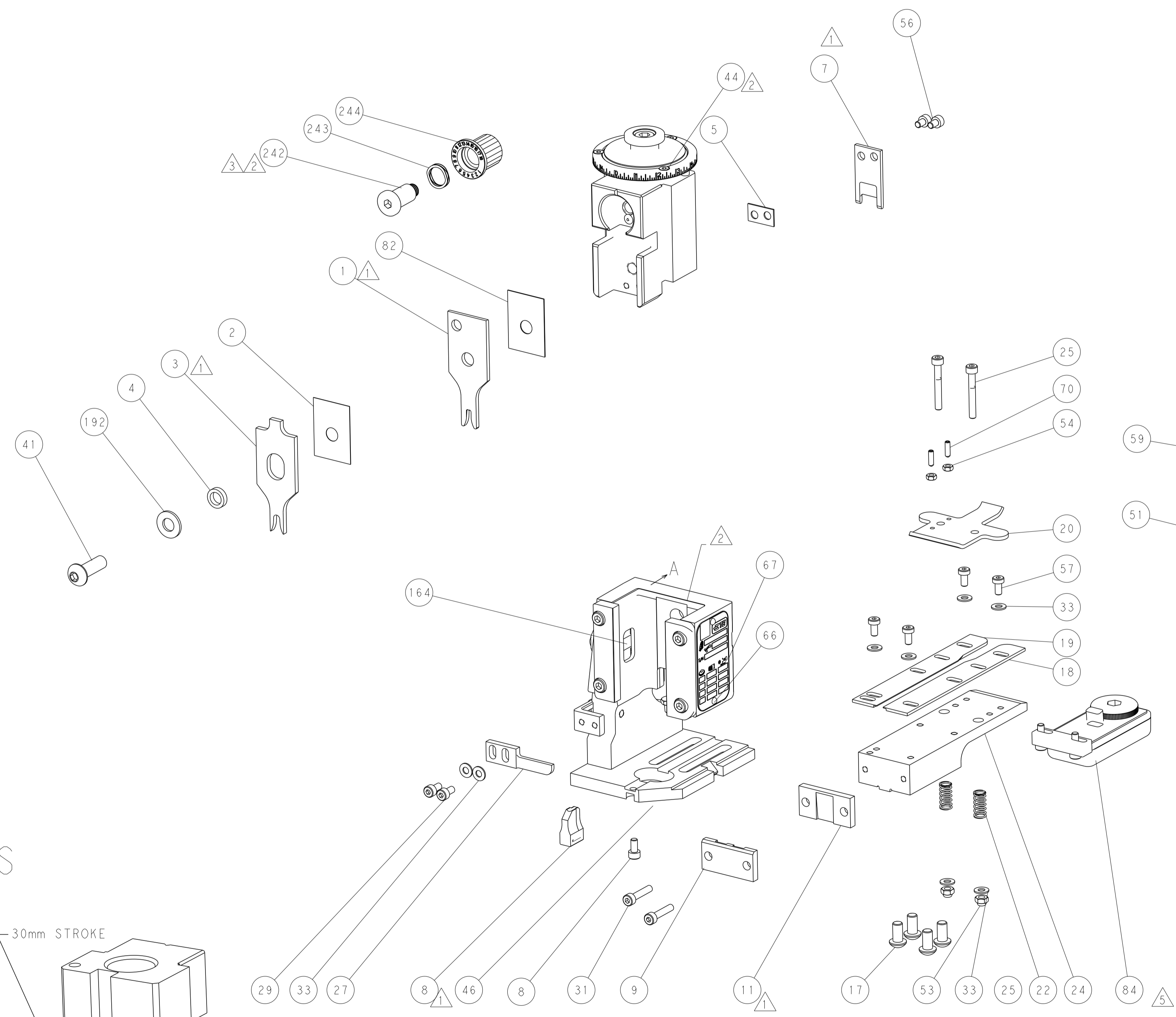
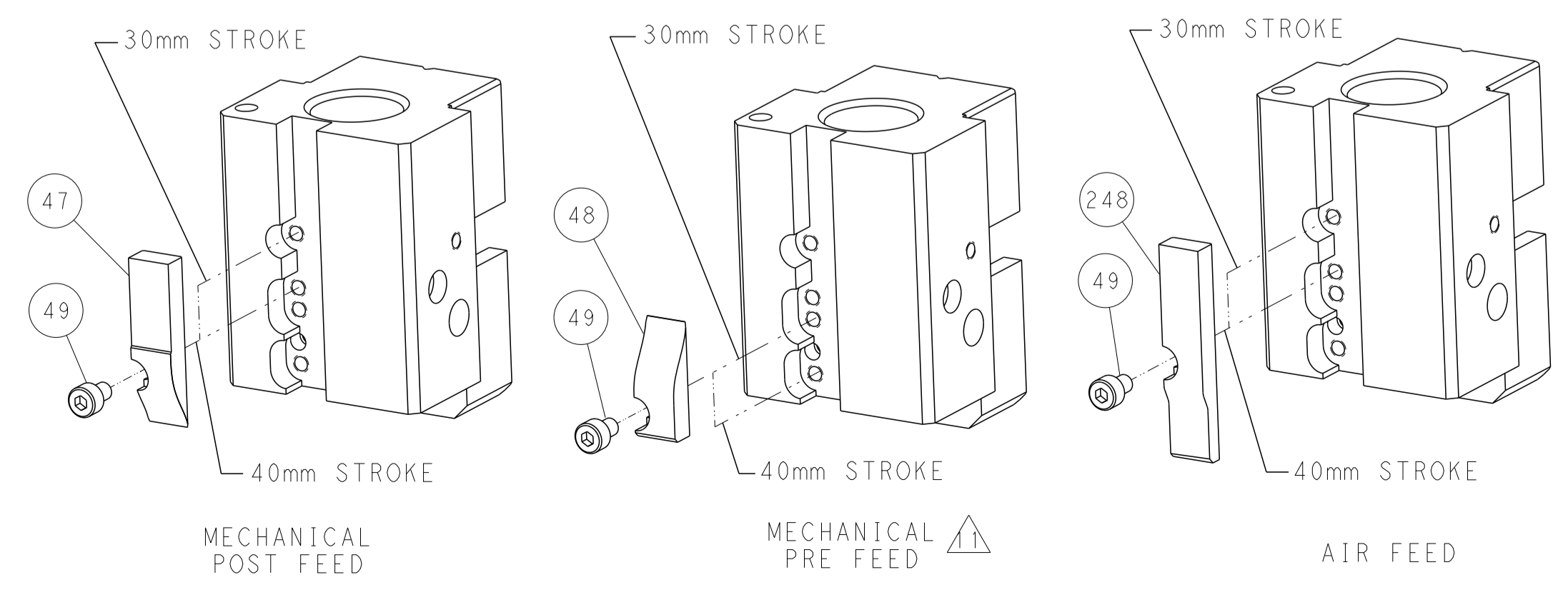
PNEUMATIC



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 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.</small>		DWN: C. CHEN 31 JUL 2013 CHK: U. GUO 31 JUL 2013 APVD: J. CRUZ 31 JUL 2013	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: 2150356 WEIGHT: - SCALE: 1:1	RESTRICTED TO: - SHEET 2 OF 4 REV C

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150356-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2150356-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150356-7	A	CRIMP TOOLING KIT	-

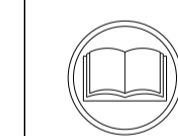
PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	3.05 mm [.120]	F
INSUL	4.57 mm [.180]	Ø
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: RING			
WIRE STRIP LENGTH 3.18-3.18 mm [.125-.125 IN]		INSULATION DIAMETER RANGE Ø2.54-3.43 mm [.100-.135 IN]	
TERMINAL APPLICATION SPECIFICATION 114-2084			
TERMINALS APPLIED			
TE TERMINAL 61386-1	TE TERMINAL 61386-2	TE TERMINAL	TE TERMINAL

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
16 AWG	1.83 +/- 0.05 [0.072 +/- .002]	5.0
18 AWG	1.68 +/- 0.05 [0.066 +/- .002]	6.5
20 AWG	1.60 +/- 0.05 [0.063 +/- .002]	7.5



- 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 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					
A	66	P	LTN	DESCRIPTION	DATE	OWN	APVD
-	-	-	-	SEE SHEET 1	-	-	-

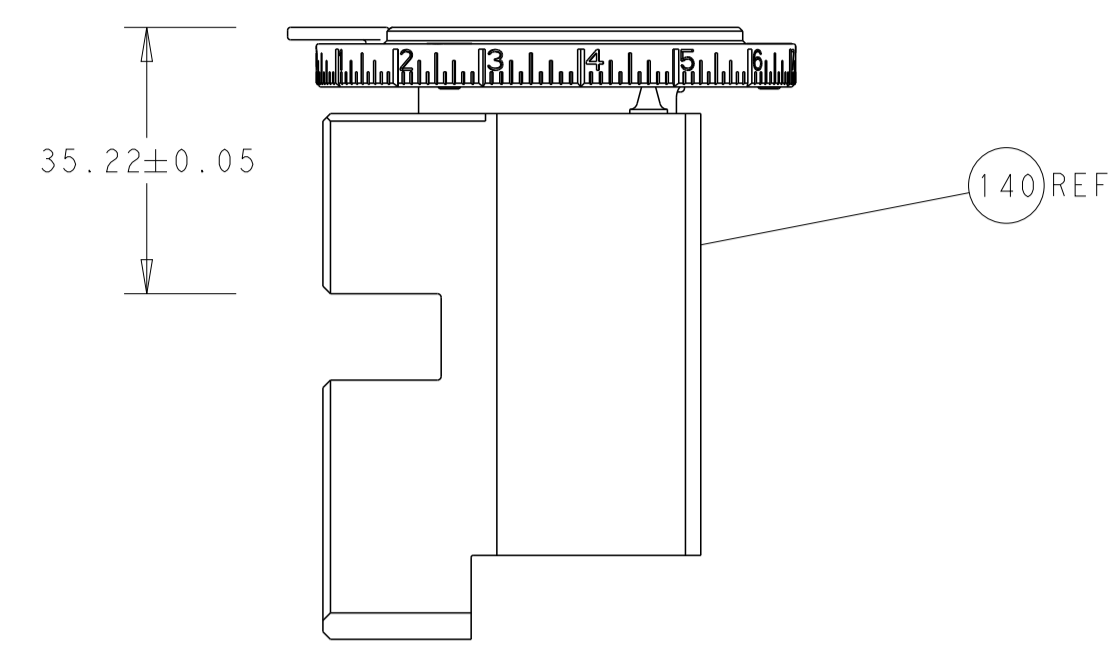
-	1	1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
3	-	1	2119083-1	RETAINER, INSULATION DIAL	242
-	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	1	-	2844940-3	AIR FEED MODULE	238
-	1	1	1-18028-0	WASHER, FLAT, REG M8	192
-	4	4	2079383-9	SCR, BHSC, 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	1803518-1	RAM ASSEMBLY, EF PACIFIC	140
5	-	1	2119955-2	ASSY, LUBRICATOR, END FEED	84
-	1	1	455888-4	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	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	2168083-5	SCR, SKT HD CAP, RoHS, M4 X 6.0	56
-	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	1803602-1	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	1803292-4	DRAG	20
-	1	1	1-1901696-2	STRIP GUIDE, REAR	19
-	1	1	1-1901695-2	STRIP GUIDE, FRONT	18
1	-	1	240644-1	PLATE, REAR SHEAR	11
-	-	-	-	-	10
-	1	1	690482-1	PLATE, FRONT SHEAR	9
1	1	1	7-1633384-5	ANVIL, COMBINATION	8
1	1	1	2217206-1	BLADE, SLUG	7
-	-	-	-	-	6
-	1	1	1-240641-9	SPACER	5
-	1	1	238011-2	BLOCK, CRIMPER SPACER	4
1	1	1	6-2119784-0	CRIMPER, INSULATION O PREMIUM	3
-	1	1	455888-1	SPACER, CRIMPER	2
1	1	1	456409-2	CRIMPER, WIRE .120 "F" 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:		MATERIAL:	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±
	ANGLES	FINISH			

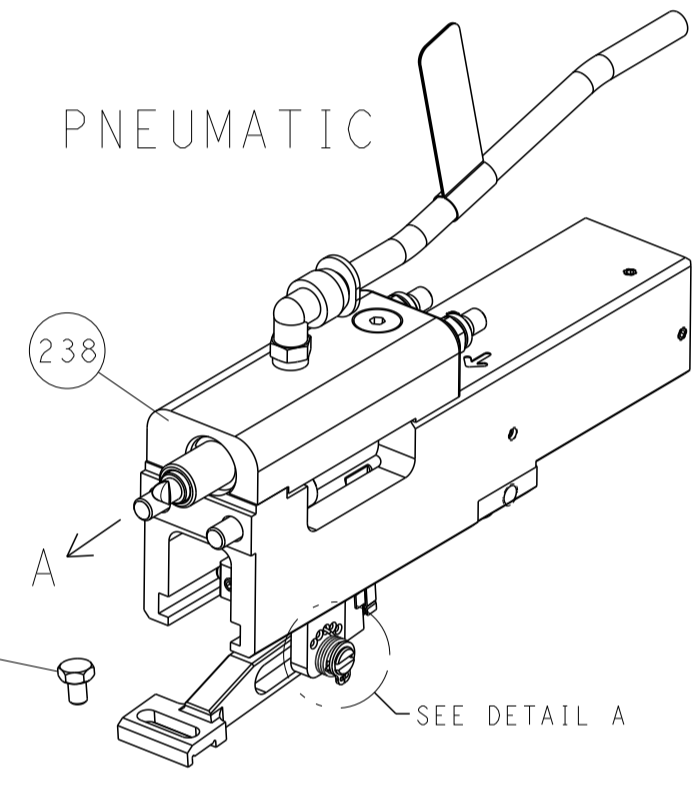
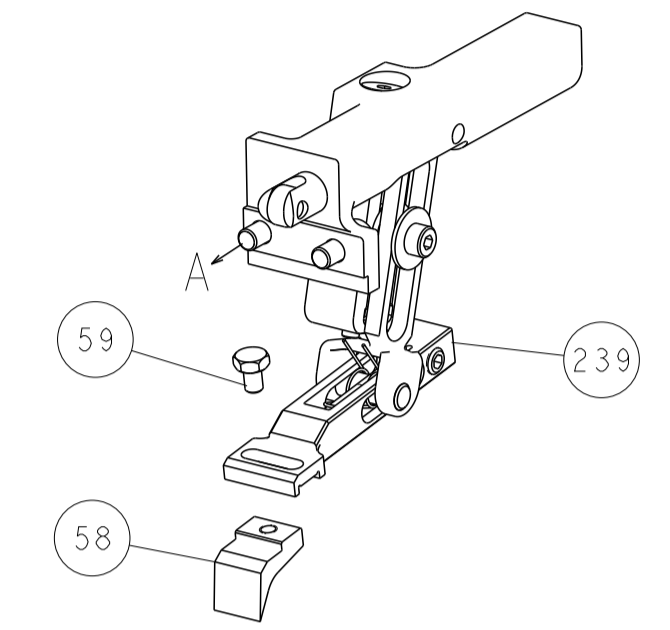
OWN	C. CHEN	31 JUL 2013	 TE Connectivity Harrisburg, PA 17105-3608			
CHK	U. GUO	31 JUL 2013				
APVD	J. CRUZ	31 JUL 2013				
NAME	Ocean End Feed Applicator					
PRODUCT SPEC			SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
APPLICATION SPEC			A1	00779	2150356	-
WEIGHT			SCALE	1:1	SHEET 3 OF 4	REV C
Customer Accessible Production Drawing						

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



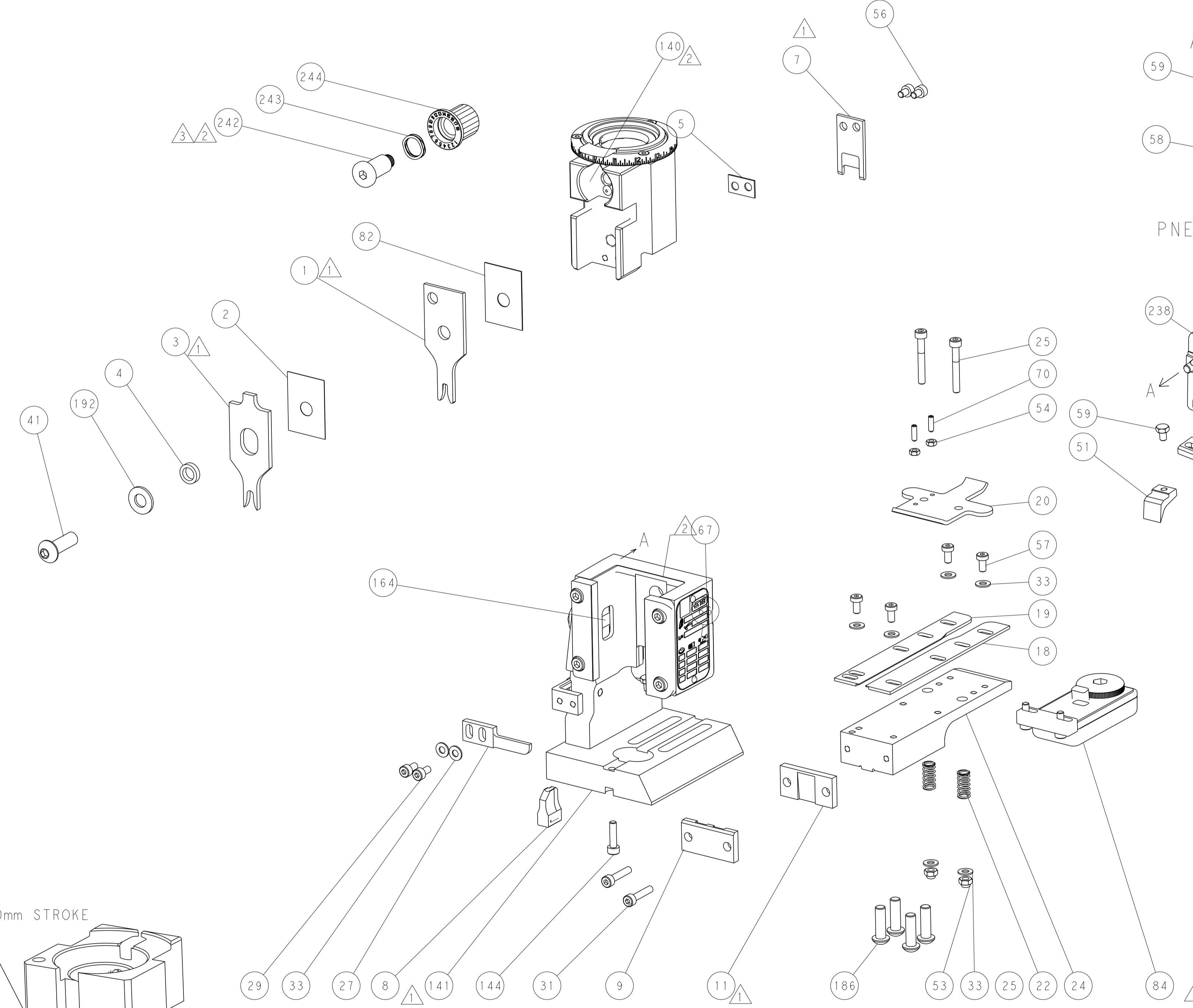
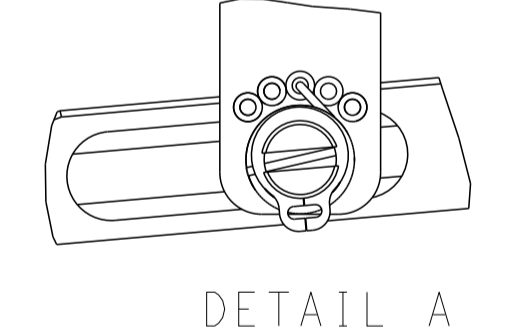
RAM SET-UP

FEED TYPE
 MECHANICAL

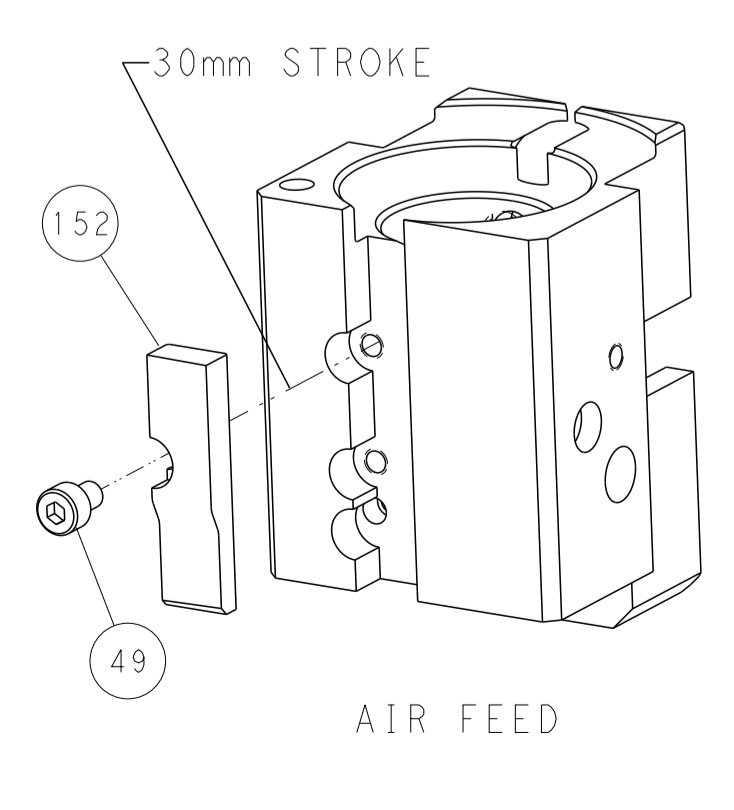
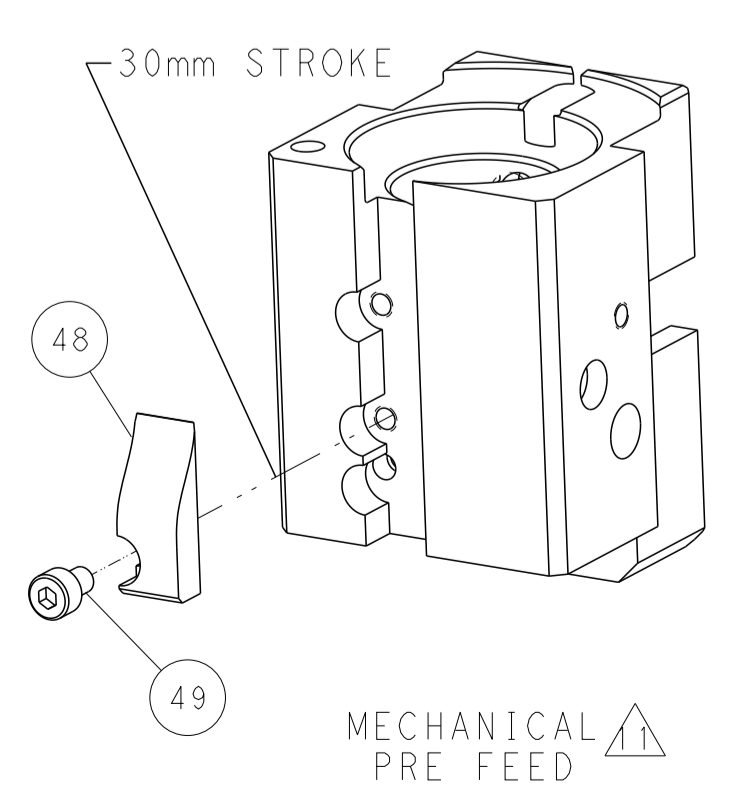
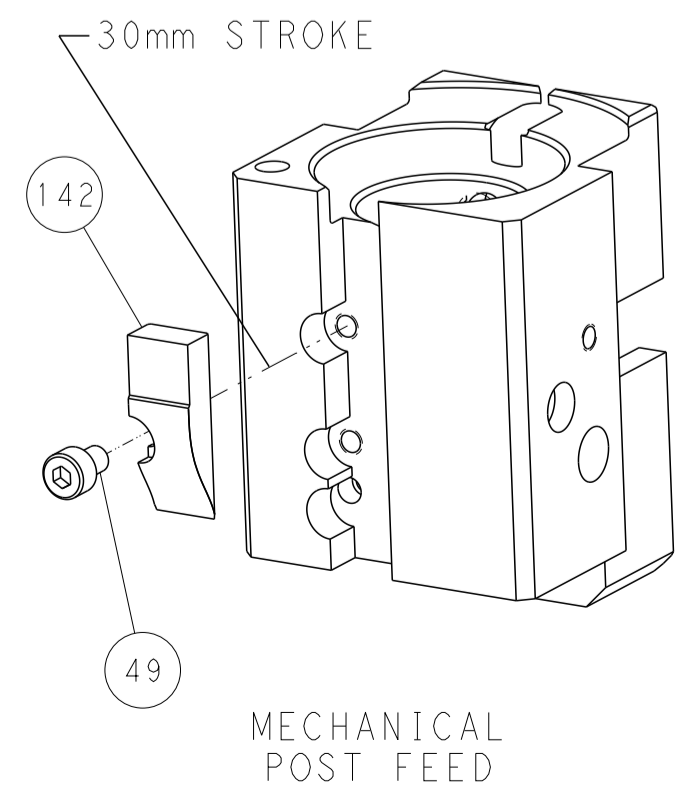


PNEUMATIC

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:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		OWN: C. CHEN 31 JUL 2013		STE TE Connectivity	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	5 PLC ±	Harrisburg, PA 17105-3608
	ANGLES ±	FINISH ±		CHK: U. GUO 31 JUL 2013	NAME: I. CRUZ 31 JUL 2013	Ocean End Feed Applicator	
MATERIAL:				PRODUCT SPEC:	APPLICATION SPEC:	SIZE: A1	CAGE CODE: 00779
				WEIGHT:	SCALE: 1:1	DRAWING NO: C-2150356	RESTRICTED TO: -
Customer Accessible Production Drawing				SHEET 4 OF 4		REV C	