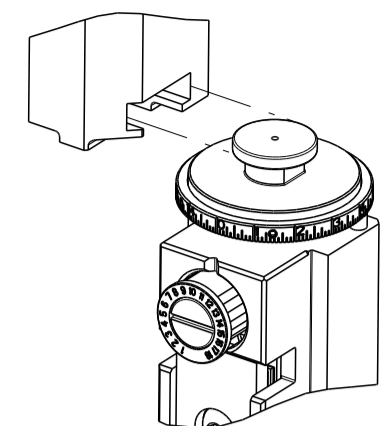


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150085-2	E	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150085-2	E	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150085-7	E	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.57 mm [.062]	F
INSUL	2.29 mm [.090]	F

APPLICATOR INSTRUCTIONS 408-35043

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: 110 SERIES POSITIVE LOCK REC CONTACT			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
3.50-4.50 mm [.138-.177 IN]		∅1.02-1.78 mm [.040-.070 IN]	
TERMINAL APPLICATION SPECIFICATION	(B)114-5120		
	(A)114-5378-1		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
(B) 175411-1	(B) 1-175411-1	(B) 175411-5	(A) 1-1746231-1

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.50mm2	1.02 +/- 0.05 [.040 +/- .002]	4.7
0.30mm2	0.91 +/- 0.05 [.036 +/- .002]	5.5
0.20mm2	0.84 +/- 0.05 [.033 +/- .002]	6.4



- 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 180.
- 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 USED PER DOCUMENT, 101-35000.
- TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.

**\*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	LTN	DESCRIPTION	DATE	OWN	APVD
A	66	B		ECR-14-011699	04AUG2014	KH	TE
		C		ECR-19-011275	17JUL2019	TB	TE
		D		ECR-20-013200	16SEP2020	JWC	GB
		E		ECR-20-017838	16DEC2020	TB	RK

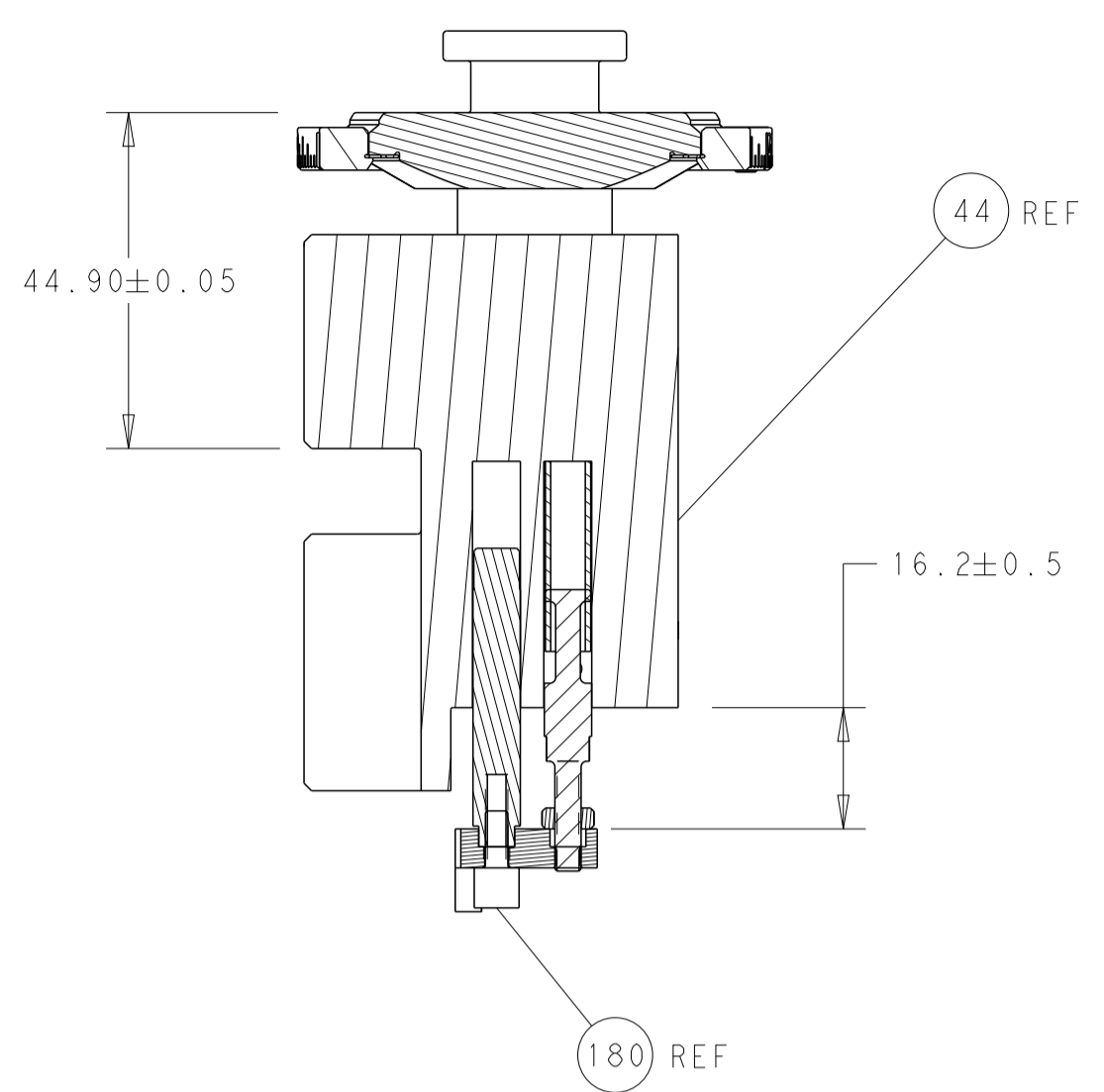
-	1	1	2119641-1	FEED CAM, AIR FEED	248	
-	1	1	2119082-6	CAM, SNAIL, INSULATION ADJUSTMENT	244	
-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243	
-	1	1	2119083-1	RETAINER, INSULATION DIAL	242	
-	1	1	2844940-3	AIR FEED MODULE	238	
-	1	1	1-18028-0	WASHER, FLAT, REG M8	192	
-	1	1	1752354-6	STANDOFF, 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	
-	2	2	2168400-5	SHCS, LOW HEAD, RoHS, M4 X 20	64	
-	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	
-	3	3	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57	
-	2	2	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	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	2063961-1	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	
-	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	1752371-5	PLATE, STRIP GUIDE	24	
-	1	1	240825-7	PLATE, STRIP HOLD DOWN	23	
-	2	2	2-22281-3	SPRING, COMPRESSION	22	
-	1	1	1803292-4	DRAG	20	
-	2	2	1901259-2	GUIDE, LOWER STRIP	18	
-	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17	
-	1	1	240641-9	SPACER	16	
-	1	1	1752360-1	SPACER, HOLD-DOWN	13	
-	1	1	240644-1	PLATE, REAR SHEAR	11	
-	-	-	-	-	10	
-	1	1	690482-6	PLATE, FRONT SHEAR	9	
-	1	2	1	4-1803000-8	ANVIL, COMBINATION, END FEED	8
-	1	1	1	2217206-4	BLADE, SLUG	7
-	-	-	-	-	6	
-	1	1	1	240641-1	SPACER	5
-	1	1	1	6-238011-7	BLOCK, CRIMPER SPACER	4
-	1	2	1	3-2119582-7	CRIMPER, INSULATION F PREMIUM	3
-	1	1	1	455888-7	SPACER, CRIMPER	2
-	1	2	1	2-1633730-4	CRIMPER, WIRE	1
-	77	72	2	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)

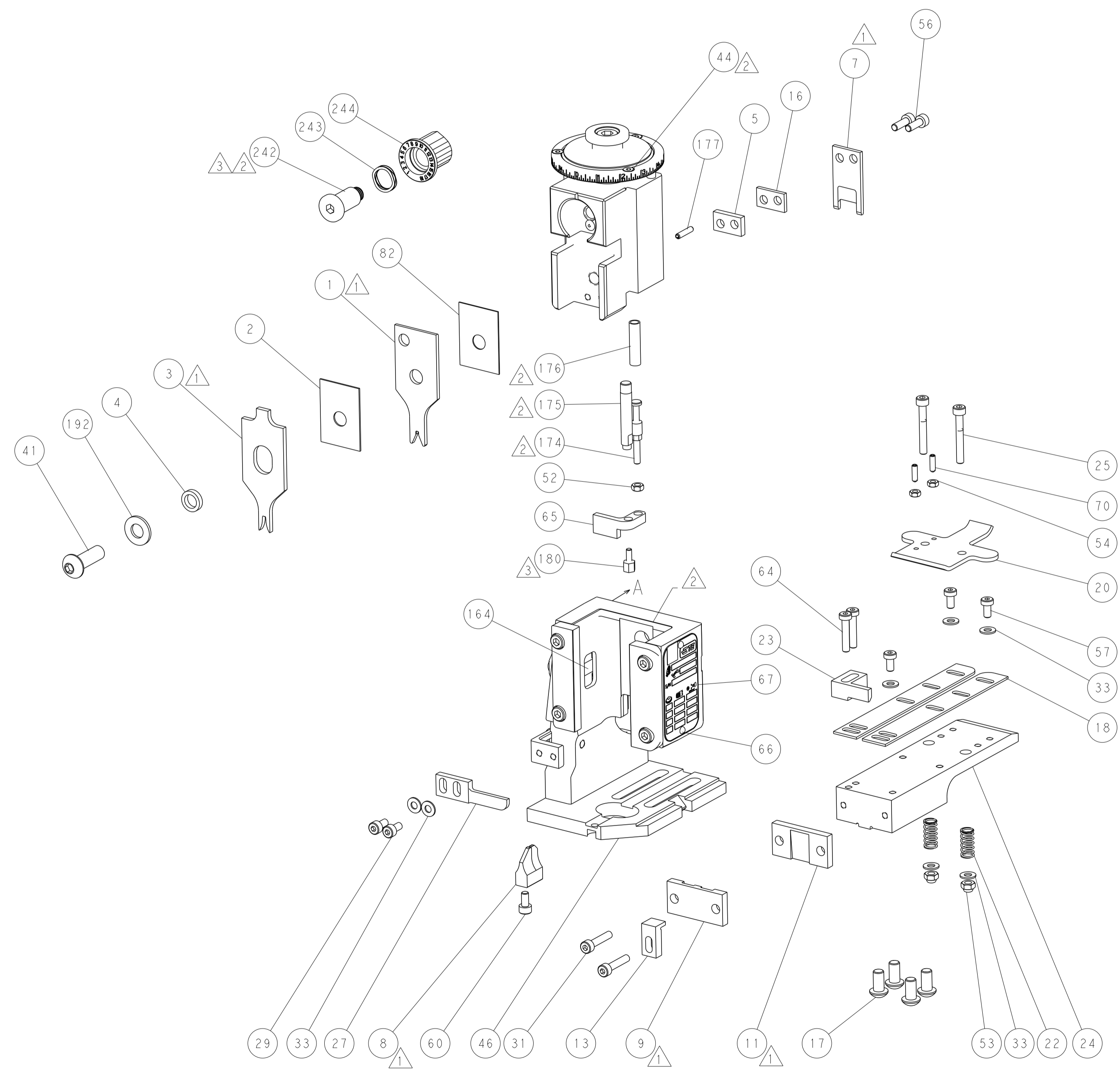
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	2 PLC	±					
	3 PLC	±					
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	ANGLES	±					
	FINISH	±					

Customer Accessible Production Drawing

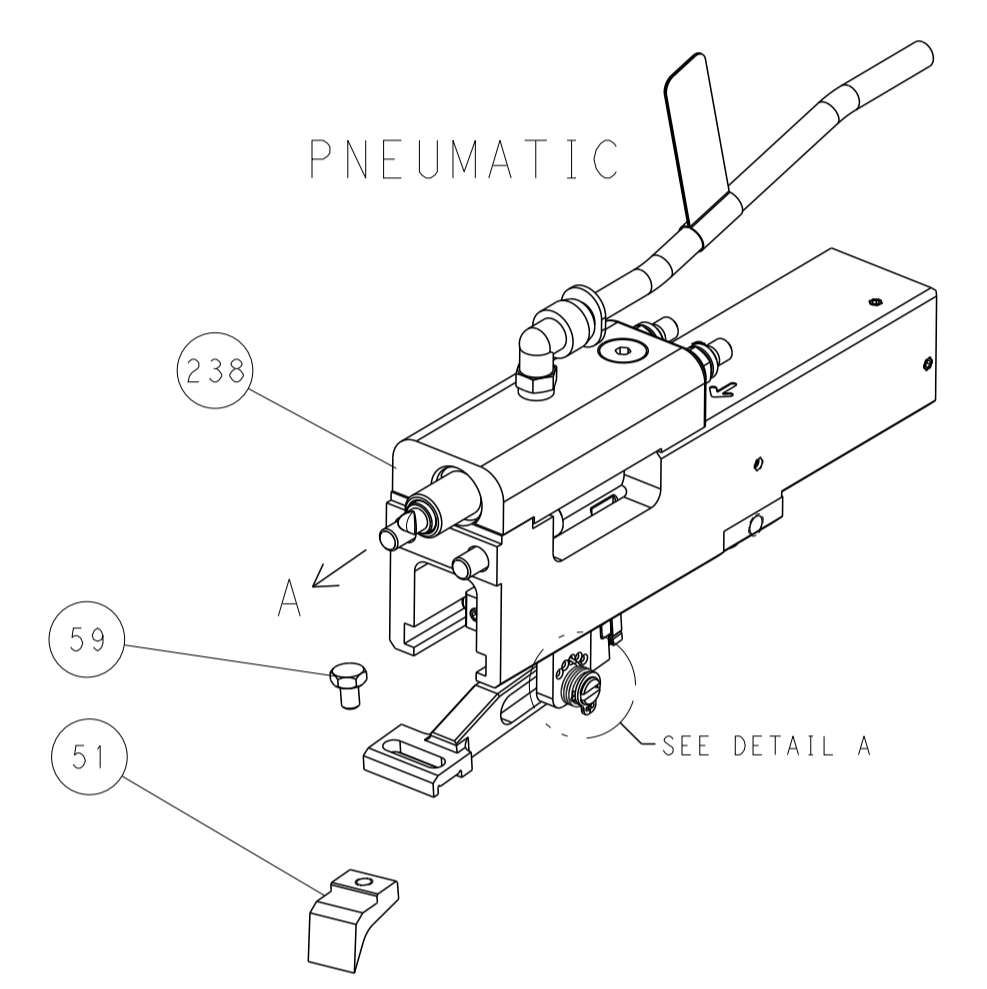
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A	66				
REVISIONS			DATE	BY	APPV
DESCRIPTION					
SEE SHEET 1					



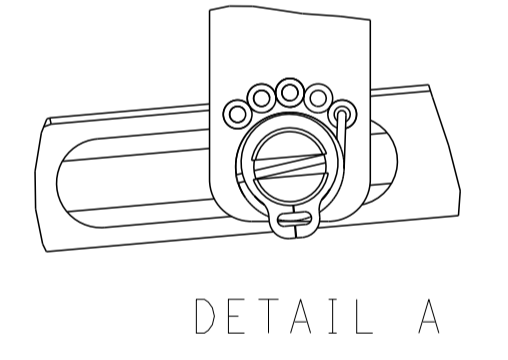
RAM AND HOLDDOWN SET-UP



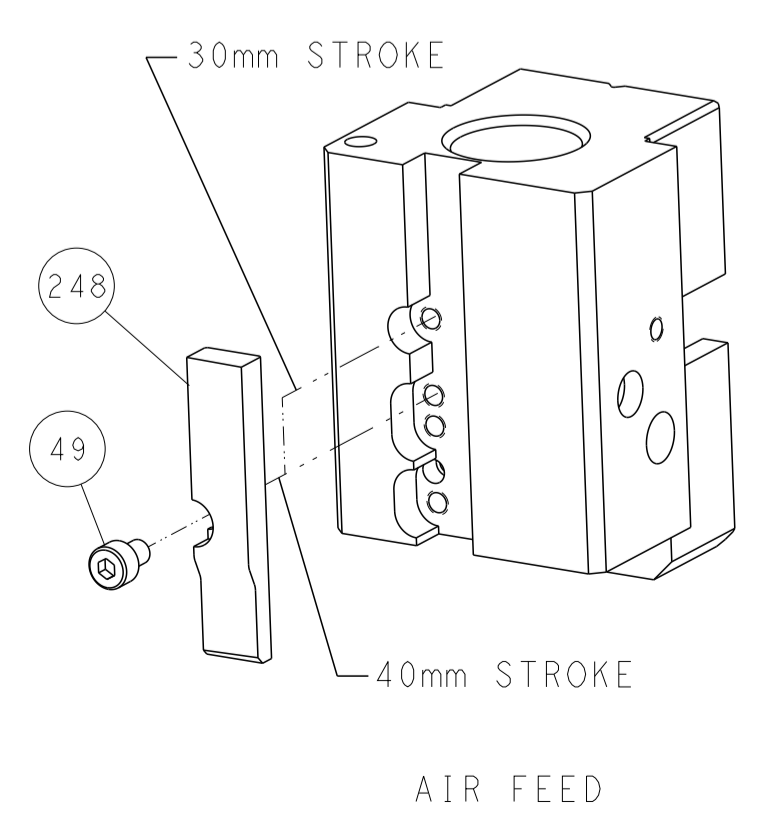
FEED TYPE



FEED SPRING SETTING POSITION



CAM POSITION

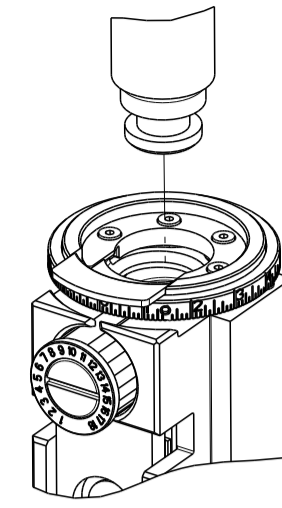


ATLANTIC VERSION  
 Shown on sheets 1 of 4 & 2 of 4  
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

<small>THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.</small>		DWN: HOFFNER 20MAR2014 CHK: T.ELBIN 21MAR2014 APVD: T.ELBIN 21MAR2014	NAME: Ocean End Feed Applicator PRODUCT SPEC: - APPLICATION SPEC: -
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH ±	TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH ±	SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2150085 WEIGHT: - SCALE: 1:1	RESTRICTED TO: - SHEET 2 OF 4 REV E

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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150085-2	E	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150085-7	E	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR  
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.57 mm [ .062 ]	F
INSUL	2.29 mm [ .090 ]	F
APPLICATOR INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: 110 SERIES POSITIVE LOCK REC CONTACT			
WIRE STRIP LENGTH 3.50-4.50 mm [ .138-.177 IN ]		INSULATION DIAMETER RANGE Ø1.02-1.78 mm [ .040-.070 IN ]	
TERMINAL APPLICATION SPECIFICATION (B)114-5120		-	
TERMINALS APPLIED		-	
TERMINALS APPLIED			
TE TERMINAL (B) 175411-1	TE TERMINAL (B) 1-175411-1	TE TERMINAL (B) 175411-5	TE TERMINAL (A) 1-1746231-1

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.50mm2	1.02 +/- 0.05 [ .040 +/- .002 ]	4.7
0.30mm2	0.91 +/- 0.05 [ .036 +/- .002 ]	5.5
0.20mm2	0.84 +/- 0.05 [ .033 +/- .002 ]	6.4



- 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 180.
- 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 USED PER DOCUMENT, 101-35000.
- TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.

**\*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.

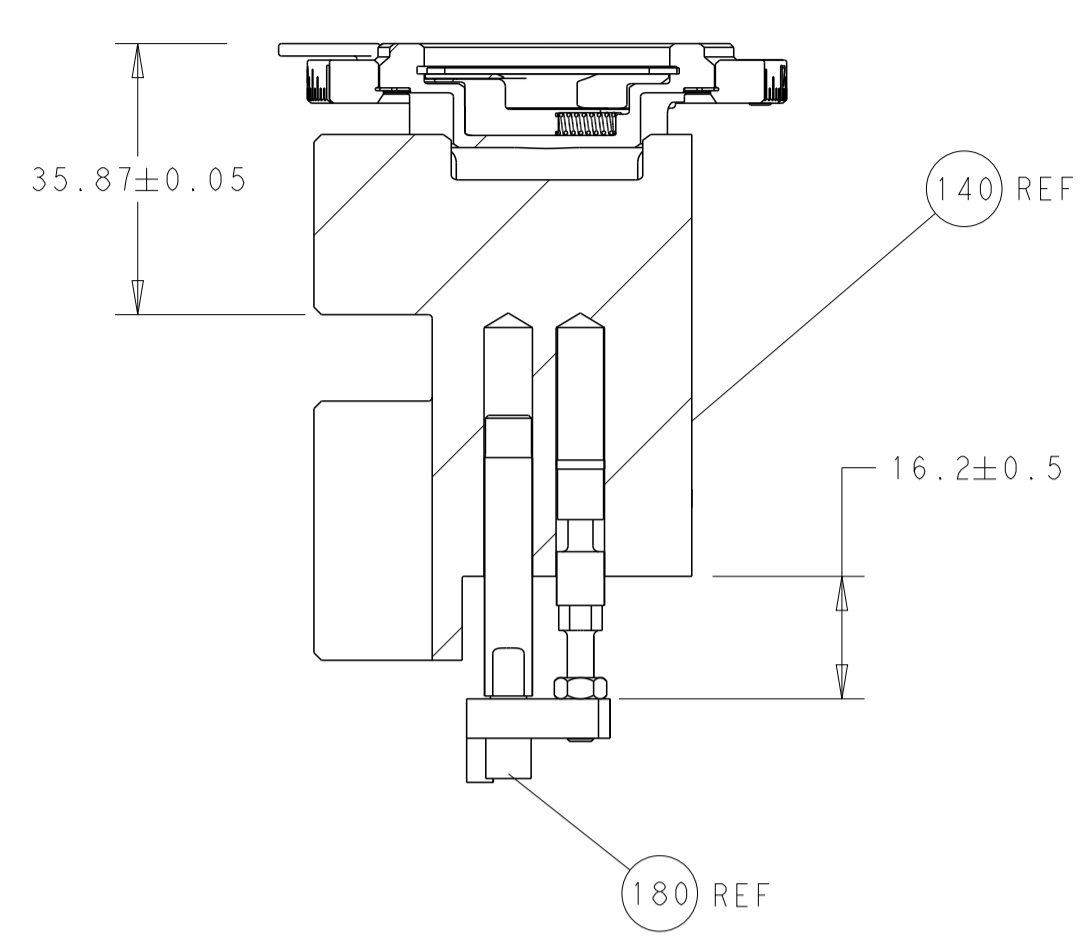
LOC		DIST		REVISIONS					
A		66		P	LTN	DESCRIPTION	DATE	OWN	APVD
				-	-	SEE SHEET 1	-	-	-

	-	1	2119082-6	CAM, SNAIL, INSULATION ADJUSTMENT	244
	-	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
	-	1	2119083-1	RETAINER, INSULATION DIAL	242
	-	1	2844940-3	AIR FEED MODULE	238
	-	1	1-18028-0	WASHER, FLAT, REG M8	192
	-	4	2079383-9	SCR, BHSC, RoHS (M6 X 20)	186
	-	1	1752354-6	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
	-	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
	-	2	2168400-5	SHCS, LOW HEAD, RoHS, M4 X 20	64
	-	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
	-	3	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57
	-	2	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	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	2063961-1	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
	-	7	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	1752371-5	PLATE, STRIP GUIDE	24
	-	1	240825-7	PLATE, STRIP HOLD DOWN	23
	-	2	2-22281-3	SPRING, COMPRESSION	22
	-	1	1803292-4	DRAG	20
	-	2	1901259-2	GUIDE, LOWER STRIP	18
	-	1	240641-9	SPACER	16
	-	1	1752360-1	SPACER, HOLD-DOWN	13
	-	1	240644-1	PLATE, REAR SHEAR	11
	-	-	-	-	10
	-	1	690482-6	PLATE, FRONT SHEAR	9
	1	1	4-1803000-8	ANVIL, COMBINATION, END FEED	8
	-	1	2217206-4	BLADE, SLUG	7
	-	-	-	-	6
	-	1	240641-1	SPACER	5
	-	1	6-238011-7	BLOCK, CRIMPER SPACER	4
	1	1	3-2119582-7	CRIMPER, INSULATION F PREMIUM	3
	-	1	455888-7	SPACER, CRIMPER	2
	1	1	2-1633730-4	CRIMPER, WIRE	1

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DIMENSIONS: mm		CHK	T. ELBIN	Z1MAR2014	
TOLERANCES UNLESS OTHERWISE SPECIFIED:		APVD	T. ELBIN	Z1MAR2014	
0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH ±		NAME	Ocean End Feed Applicator		
MATERIAL		SIZE	CAGE CODE DRAWING NO		RESTRICTED TO
		A1	00779 2150085		-
		Customer Accessible Production Drawing			SCALE 1:1 SHEET 3 OF 4 REV E

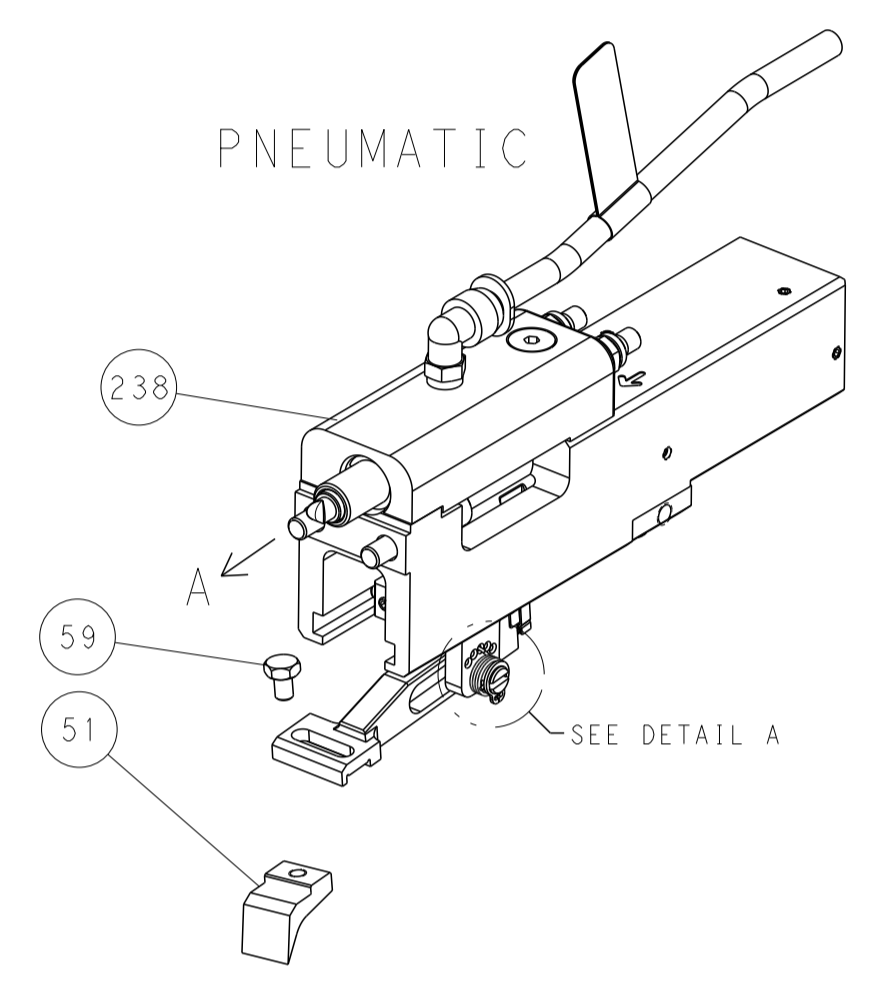
PACIFIC VERSION  
Shown on sheets 3 of 4 & 4 of 4  
(Atlantic version shown on sheets 1 of 4 & 2 of 4)

LOC	DIST	REVISIONS			
P	LTN	DESCRIPTION	DATE	DMN	APVD
A	66	SEE SHEET 1			

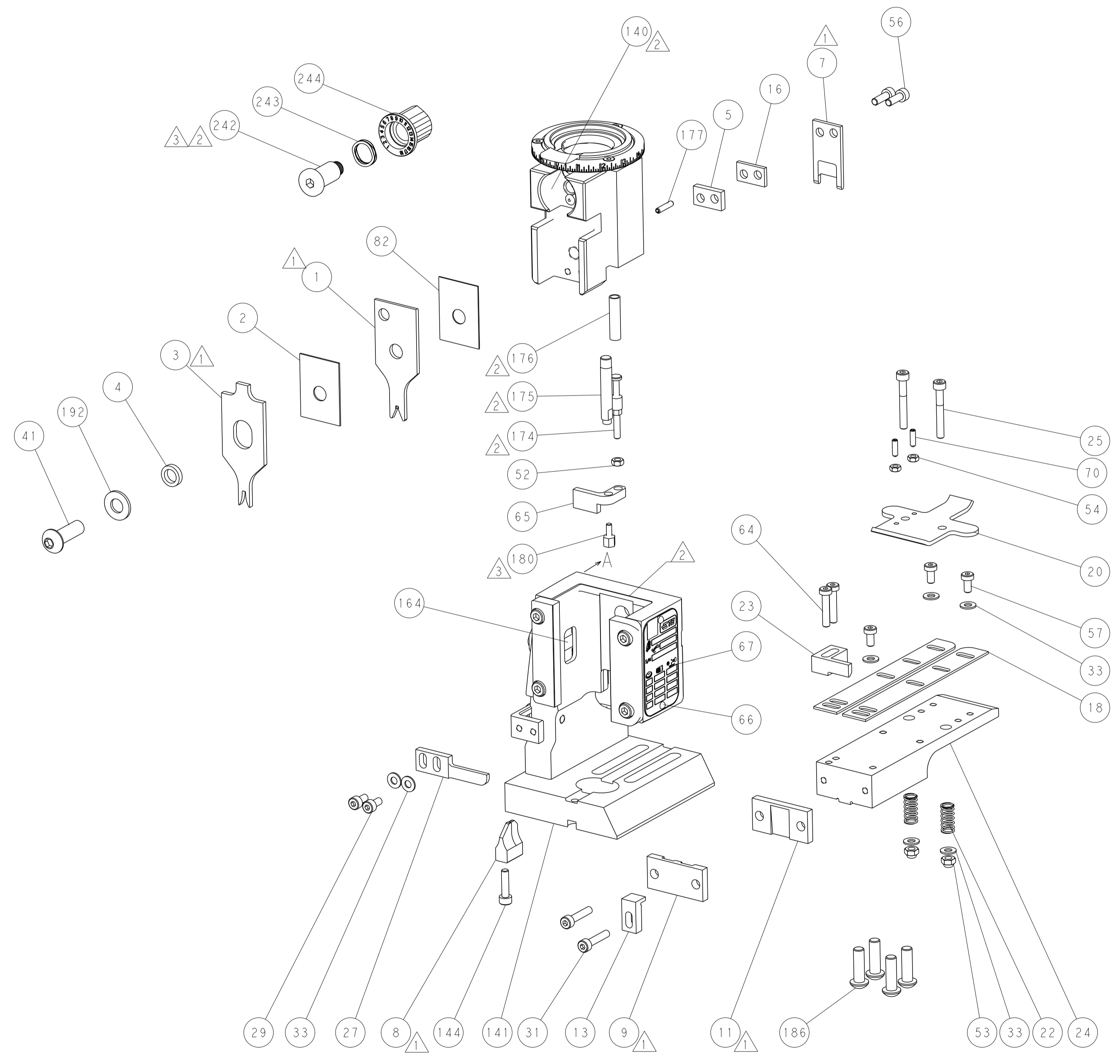
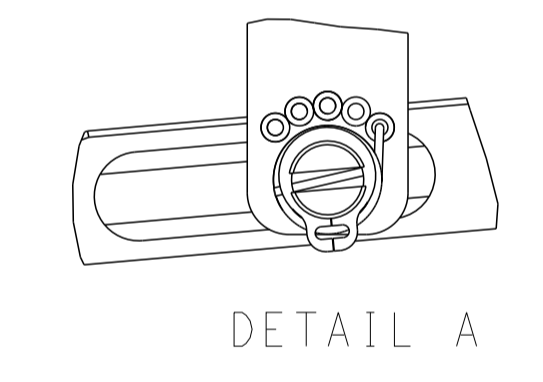


RAM AND HOLDDOWN SET-UP

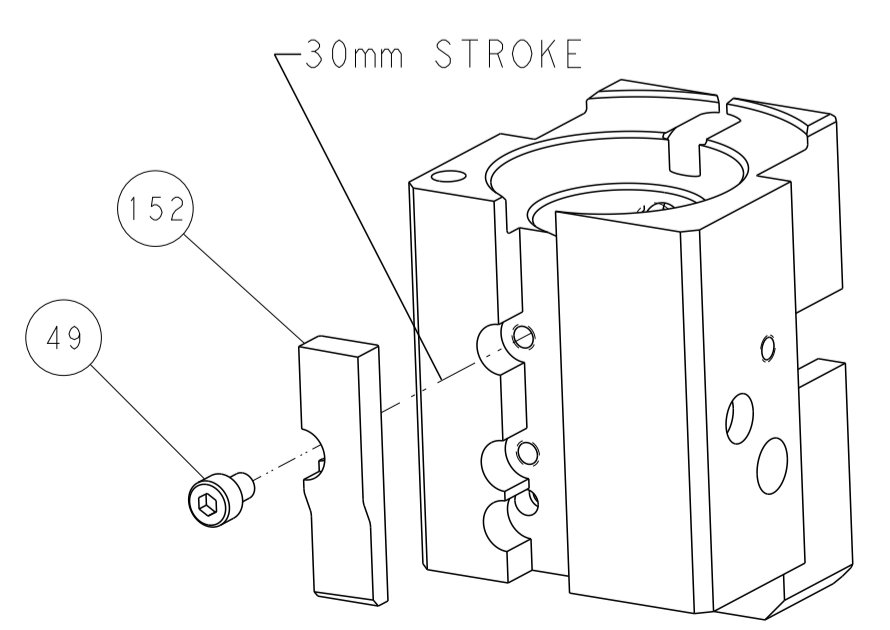
FEED TYPE



FEED SPRING SETTING POSITION



CAM POSITION



AIR FEED

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

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DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± MATERIAL: - FINISH: -		NAME: Ocean End Feed Applicator APPLICATION SPEC: - WEIGHT: - SCALE: 1:1	SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2150085 SHEET 4 OF 4 REV E	RESTRICTED TO: -