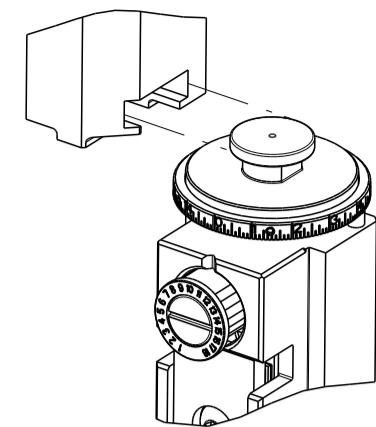


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150282-2	E	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150282-2	E	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150282-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.79 mm [.110]	F
INSUL	3.56 mm [.140]	O

APPLICATOR INSTRUCTIONS 408-35043

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION			
TERMINAL NAME: TERMINAL, RING			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
.204-.234 IN [5.18-5.94 mm]		Ø.070-.100 IN [1.78-2.54 mm]	
TERMINAL APPLICATION SPECIFICATION	114-2084	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
41711	41013	140517	

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
18 AWG OR 0.75mm2	1.96 +/- 0.05 [0.077 +/- .002]	8.7
20 AWG OR 0.50mm2	1.88 +/- 0.05 [0.074 +/- .002]	9.5
22 AWG OR 0.35mm2	1.83 +/- 0.05 [0.072 +/- .002]	10.0

- 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 PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- 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)

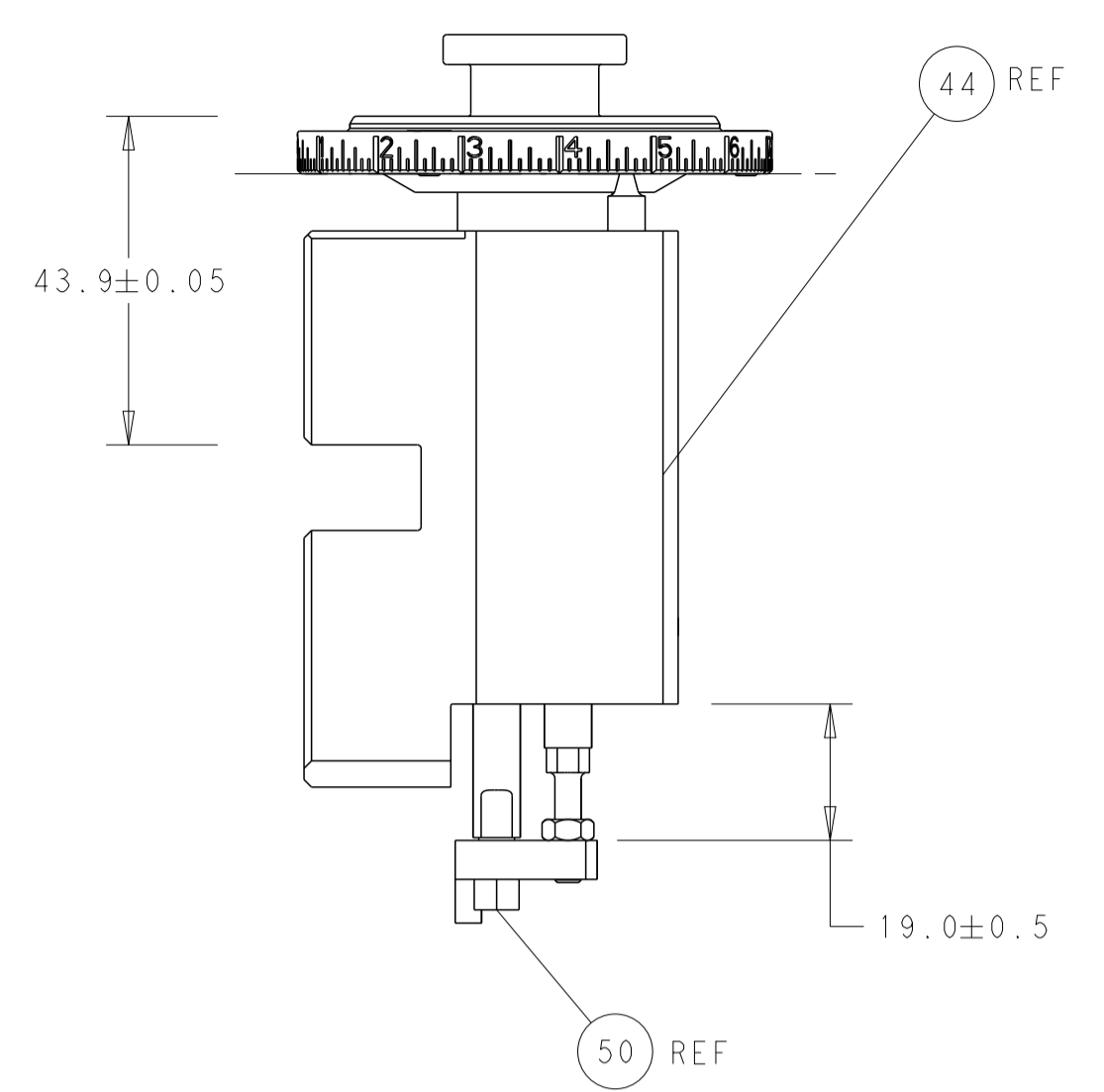
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		C		ECR-18-019965	21DEC2018	JAH	TE
		D		ECR-20-017710	15DEC2020	FZ	TE
		E		ECR-22-144048	28JUN2022	ROY	TLE

-	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	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	
-	REFREF		994970-2	COUNTER, MAGNETIC	164	
-	1	1	455888-4	SPACER, CRIMPER	82	
-	1	1	2119791-5	DEPRESSOR, WIRE	73	
-	1	1	1803607-4	DOCUMENTATION PACKAGE	71	
-	2	2	2-18032-2	SCR, SET, FLT PNT, M3 X 10.0	70	
-	1	1	2119943-1	WASHER, SPACER	69	
-	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	2-2168083-6	SCR, SKT HD CAP, RoHS, M4 X 18	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	1752354-1	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	1752371-5	PLATE, STRIP GUIDE	24	
-	2	2	2-22281-3	SPRING, COMPRESSION	22	
-	1	1	1803292-1	DRAG	20	
-	1	1	1901696-3	STRIP GUIDE, REAR	19	
-	1	1	1901695-3	STRIP GUIDE, FRONT	18	
-	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17	
-	1	1	1752360-1	SPACER,HOLD-DOWN	13	
-	1	1	240644-1	PLATE, REAR SHEAR	11	
-	2	2	1-240645-0	SPACER, SHEAR PLATE	10	
-	1	1	240642-1	PLATE, FRONT SHEAR	9	
-	1	2	1	2-1333219-1	ANVIL, COMBINATION	8
-	1	1	1	9-240651-6	BLADE, SLUG	7
-	1	1	1	2-240641-6	SPACER	5
-	1	1	1	238011-4	BLOCK, CRIMPER SPACER	4
-	1	2	1	1803018-8	CRIMPER, INSULATION O	3
-	1	1	1	455888-7	SPACER, CRIMPER	2
-	1	2	1	1-456408-8	CRIMPER, WIRE PREMIUM	1
-	77	72	2	PART NO	DESCRIPTION	ITEM NO

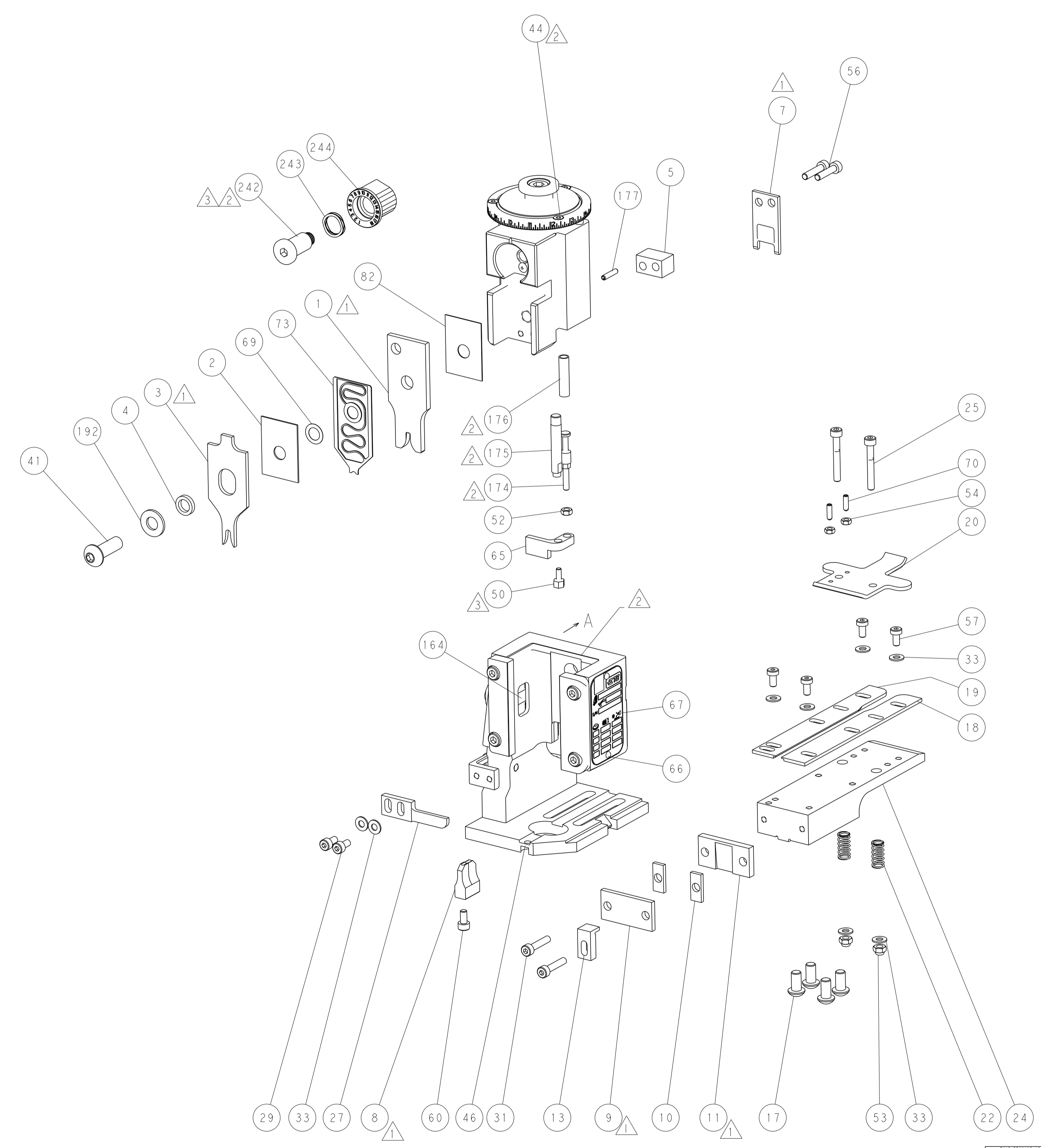
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mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES	FINISH

DWN	R. STAKEM	21AUG2012	NAME	Ocean End Feed Applicator	
CHK	G. BAILEY	21AUG2012	SIZE	CAGE CODE	DRAWING NO
APVD	T. ELRLIN	21AUG2012	WEIGHT	00779	2150282
Customer Accessible Production Drawing			SCALE	1:1	SHEET 1 OF 4

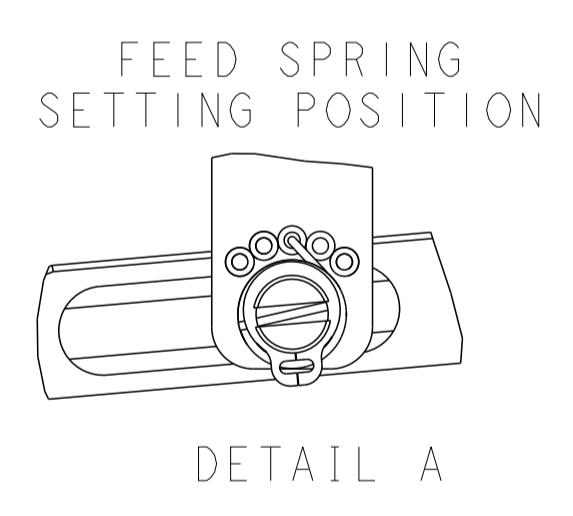
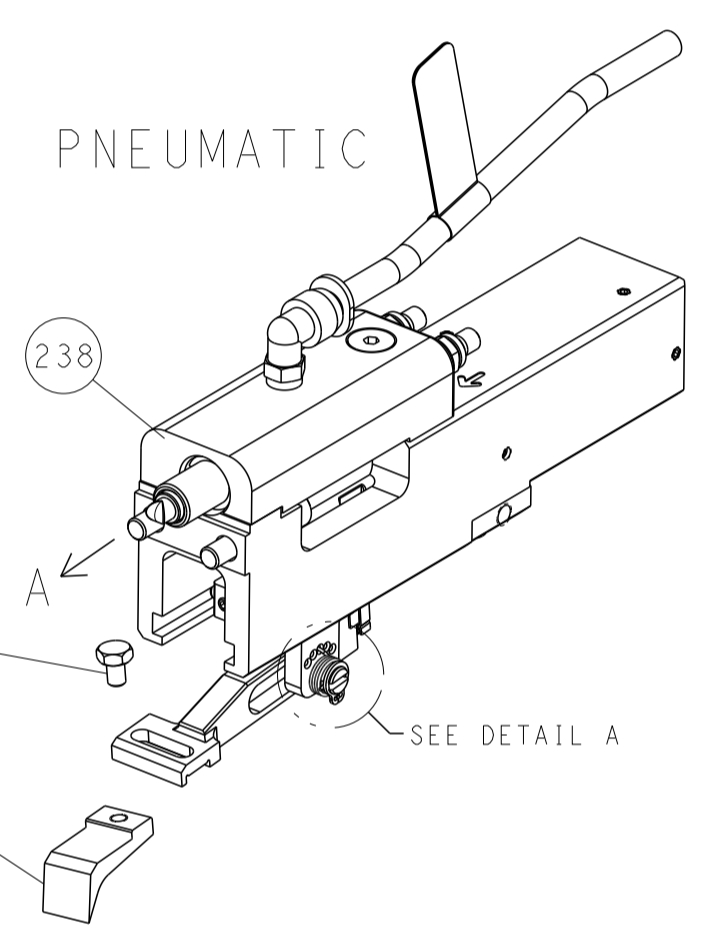
LOC	DIST	REVISIONS			
P	LTN	DESCRIPTION	DATE	DWN	APVD
A	66	SEE SHEET 1			



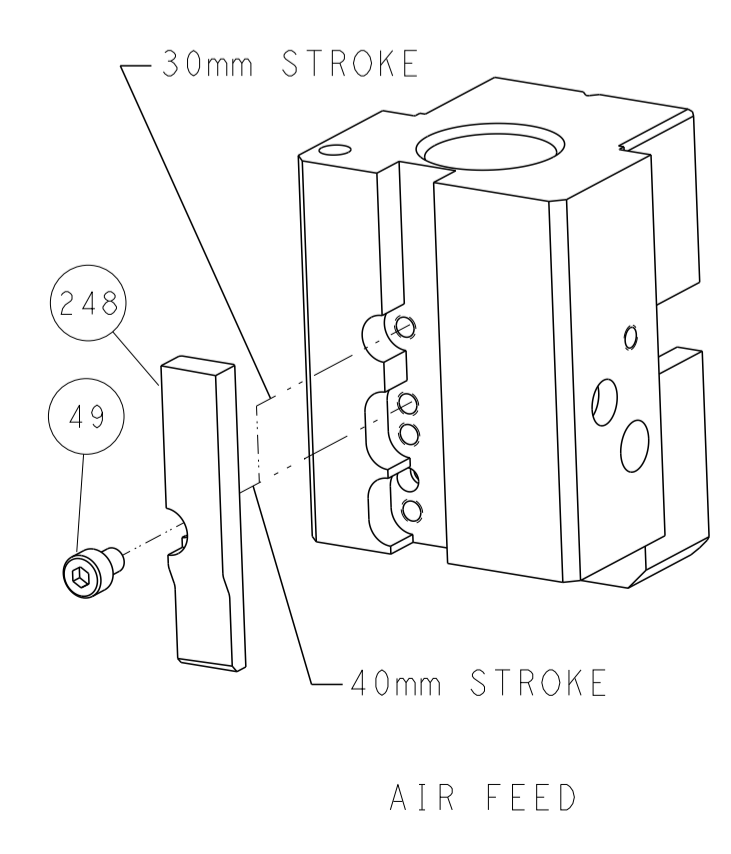
RAM AND HOLDDOWN SET-UP



FEED TYPE



CAM POSITION

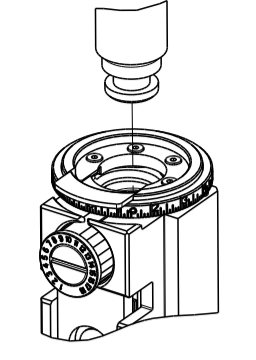


ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH		DWN K. STAKEM 21AUG2012 CHK G. BAILEY 21AUG2012 APVD T. ELBIN 21AUG2012 PRODUCT SPEC APPLICATION SPEC WEIGHT Customer Accessible Production Drawing		NAME Ocean End Feed Applicator SIZE CAGE CODE DRAWING NO. RESTRICTED TO A1 00779 C=2150282 SCALE 1:1 SHEET 2 OF 4 REV E	
THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION. ALL RIGHTS RESERVED.				TE Connectivity Harrisburg, PA 17105-3608			

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150282-2	E	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150282-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
 INTERFACE ADAPTER



APPLICATOR DATA

CRIMP	SIZE	TYPE
WIRE	2.79 mm (.110)	F
INSUL	3.56 mm (.140)	O

APPLICATOR INSTRUCTIONS
 408-35043

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION

TERMINAL NAME: TERMINAL, RING

WIRE STRIP LENGTH	INSULATION DIAMETER RANGE
.204-.234 IN [5.18-5.94 mm]	Ø.070-.100 IN [1.78-2.54 mm]

TERMINAL APPLICATION SPECIFICATION

TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
41711	41013	140517	

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
18 AWG OR 0.75mm ²	1.96+/-0.05 [0.77+/-0.002]	8.7
20 AWG OR 0.50mm ²	1.88+/-0.05 [0.74+/-0.002]	9.5
22 AWG OR 0.35mm ²	1.83+/-0.05 [0.72+/-0.002]	10.0

- 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 PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- 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.

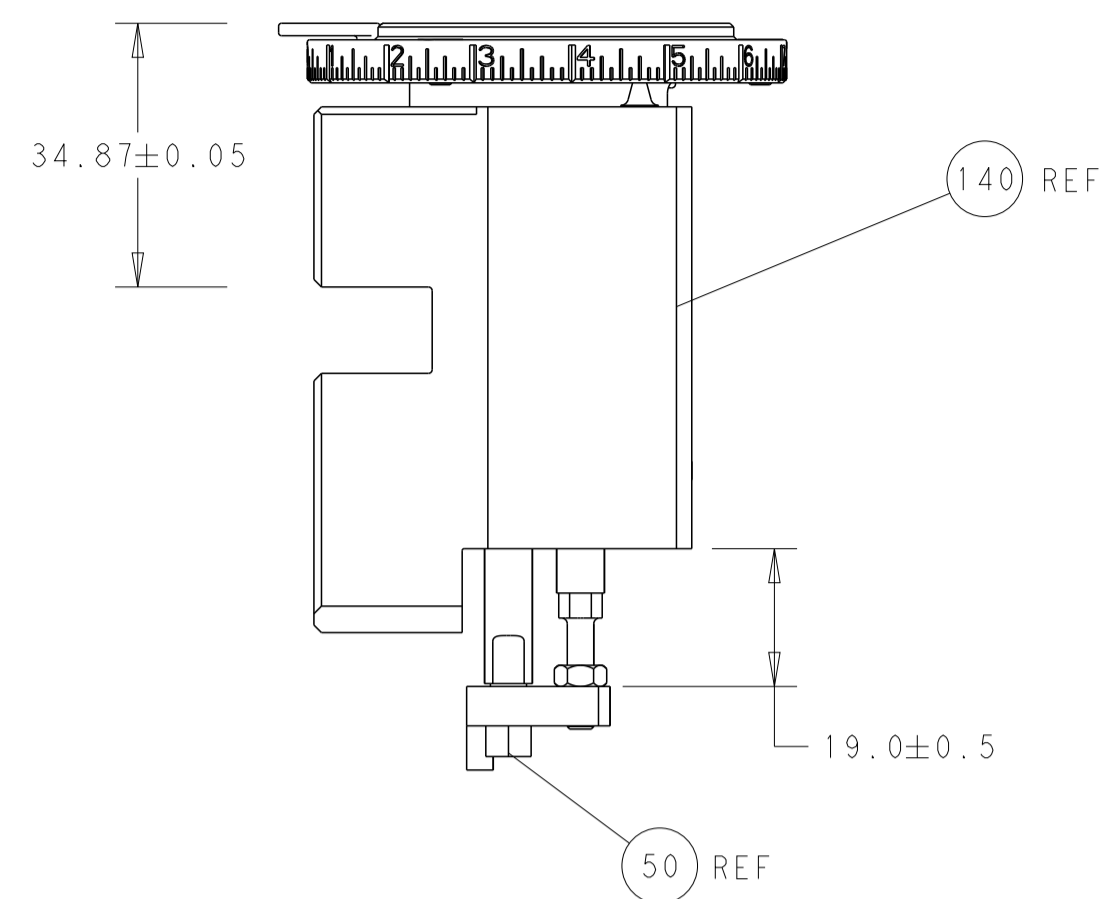
LOC	DIST	REV	DATE	BY	APPV
A	66				

REV	DATE	DESCRIPTION	ITEM NO
- 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	455888-4	SPACER, CRIMPER	82
- 1	2119791-5	DEPRESSOR, WIRE	73
- 1	1803607-4	DOCUMENTATION PACKAGE	71
- 2	2-18032-2	SCR, SET, FLT PNT, M3 X 10.0	70
- 1	2119943-1	WASHER, SPACER	69
- 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	2-2168083-6	SCR, SKT HD CAP, RoHS, M4 X 18	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	1752354-1	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	1752371-5	PLATE, STRIP GUIDE	24
- 2	2-22281-3	SPRING, COMPRESSION	22
- 1	1803292-1	DRAG	20
- 1	1901696-3	STRIP GUIDE, REAR	19
- 1	1901695-3	STRIP GUIDE, FRONT	18
- 1	1752360-1	SPACER,HOLD-DOWN	13
- 1	240644-1	PLATE, REAR SHEAR	11
- 2	1-240645-0	SPACER, SHEAR PLATE	10
- 1	240642-1	PLATE, FRONT SHEAR	9
1 1	2-1333219-1	ANVIL, COMBINATION	8
- 1	9-240651-6	BLADE, SLUG	7
- 1	2-240641-6	SPACER	5
- 1	238011-4	BLOCK, CRIMPER SPACER	4
1 1	1803018-8	CRIMPER, INSULATION O	3
- 1	455888-7	SPACER, CRIMPER	2
1 1	1-456408-8	CRIMPER, WIRE PREMIUM	1
- 77-22	PART NO	DESCRIPTION	ITEM NO

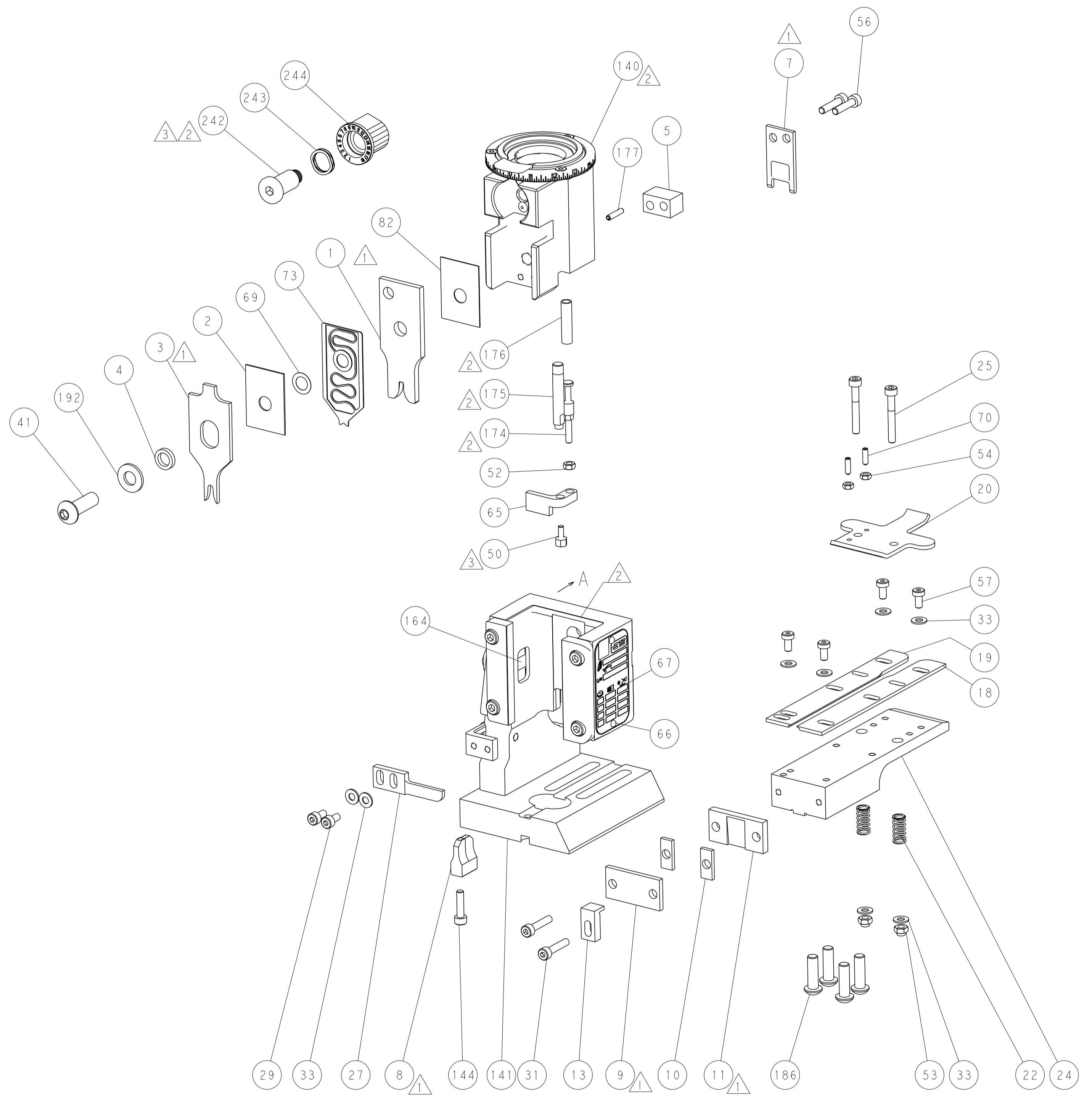
PACIFIC VERSION
 Shown on sheets 3 of 4 & 4 of 4
 (Atlantic version shown on sheets 1 of 4 & 2 of 4)

DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH		DWN: STAKEM 21AUG2012 CHK: G. BAILEY 21AUG2012 APVD: T. ELBIN 21AUG2012		NAME: Ocean End Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2150282	
MATERIAL: -		FINISH: -		WEIGHT: -		SCALE: 1:1	
Customer Accessible Production Drawing				SHEET 3 OF 4		REV E	

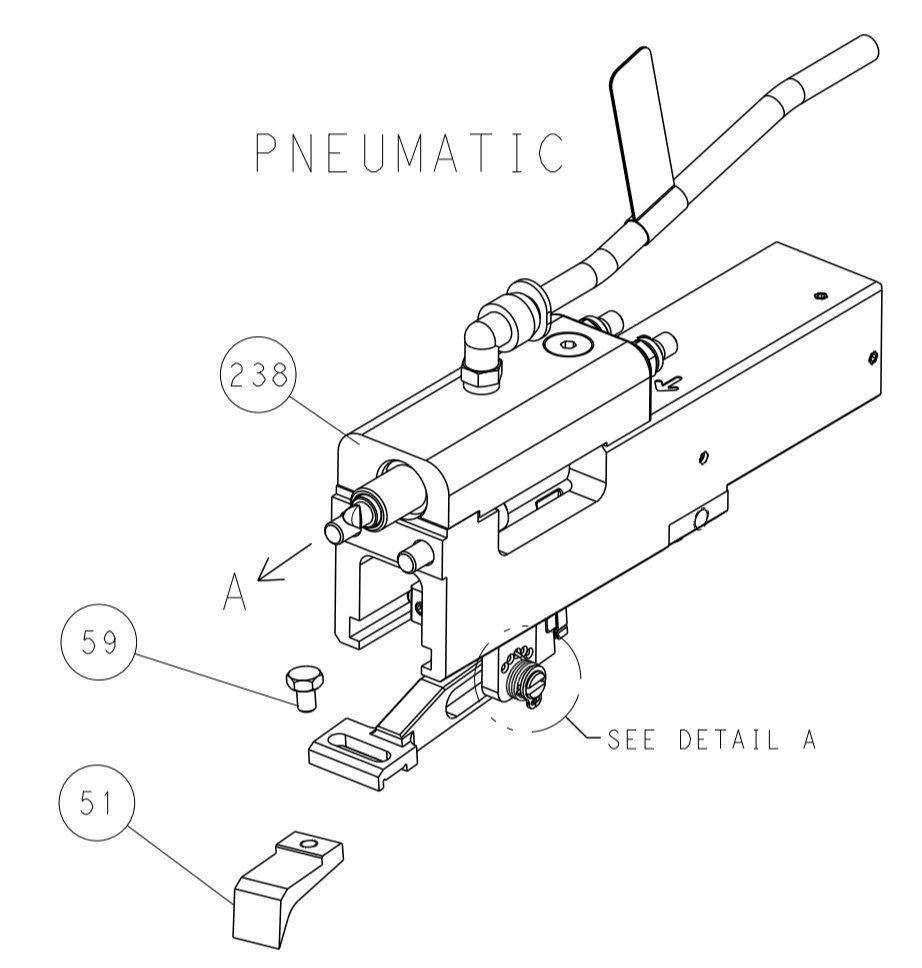
LOC	DIST	REVISIONS			
P	LTN	DESCRIPTION	DATE	DMN	APVD
A	66	SEE SHEET 1	-	-	-



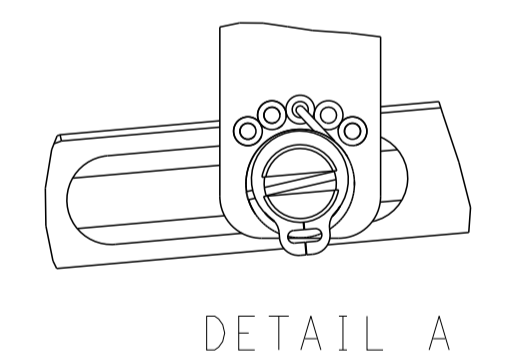
RAM AND HOLDDOWN SET-UP



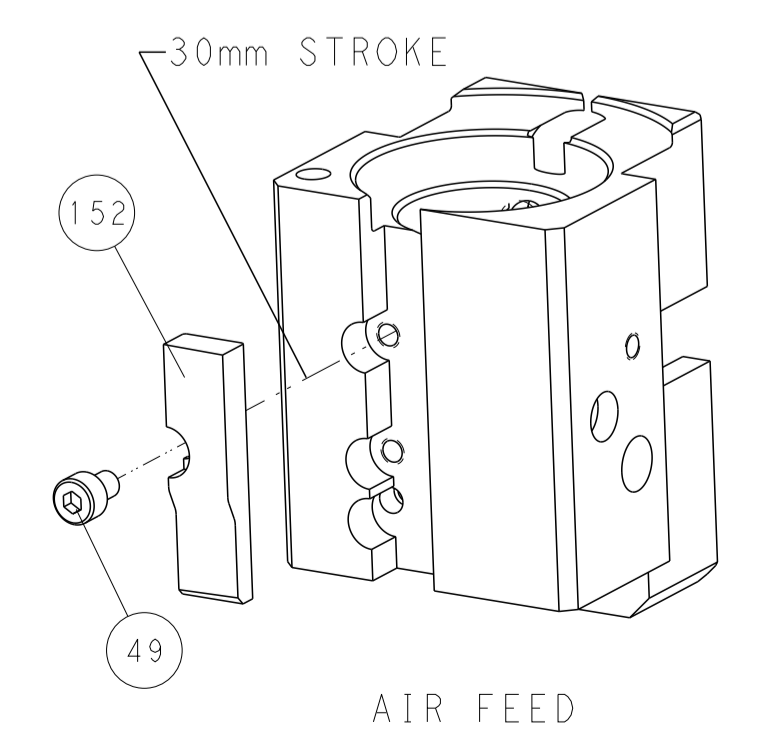
FEED TYPE



FEED SPRING SETTING POSITION



CAM POSITION



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 UNPUBLISHED. RELEASED FOR PUBLICATION BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.</small> DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH ±		DMN: K. STAKEM 21AUG2012 CHK: G. BAILEY 21AUG2012 APVD: T. ELRLIN 21AUG2012 PRODUCT SPEC: APPLICATION SPEC: WEIGHT: Customer Accessible Production Drawing	NAME: Ocean End Feed Applier SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2150282 SCALE: 1:1 SHEET: 4 OF 4 REV: E	STE TE Connectivity Harrisburg, PA 17105-3608
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