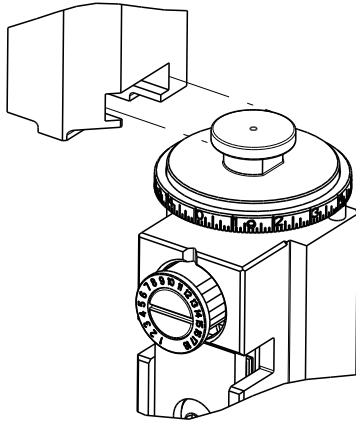
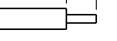


8		7	
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20		20	
COPYRIGHT 20 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.			
PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150069-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2150069-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150069-1	C	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2150069-2	C	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150069-7	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]	F
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: RING			
WIRE STRIP LENGTH 2.79-3.56 mm [.110-.140 IN]			INSULATION DIAMETER RANGE Ø3.05-4.32 mm [.120-.170 IN]
TERMINAL APPLICATION SPECIFICATION	114-2084	-	-
TERMINALS APPLIED 			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
41330	41332	41333	41333-2
41333-4	41558	41558-1	41559
41560	1217160-1		

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING 4
14 AWG		1.96+/-0.05 [.077+/- .002]		6.9
16 AWG		1.73+/-0.05 [.068+/- .002]		9.4
18 AWG		1.60+/-0.05 [.063+/- .002]		10.7



- 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.

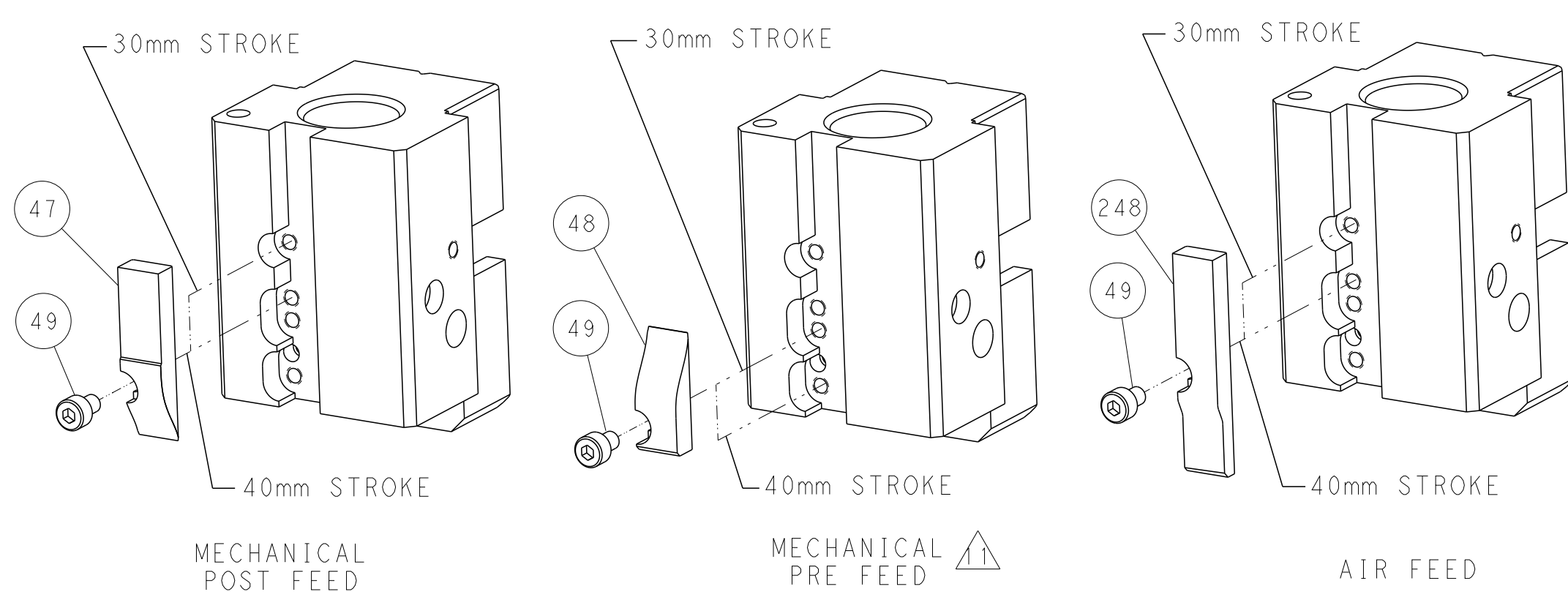
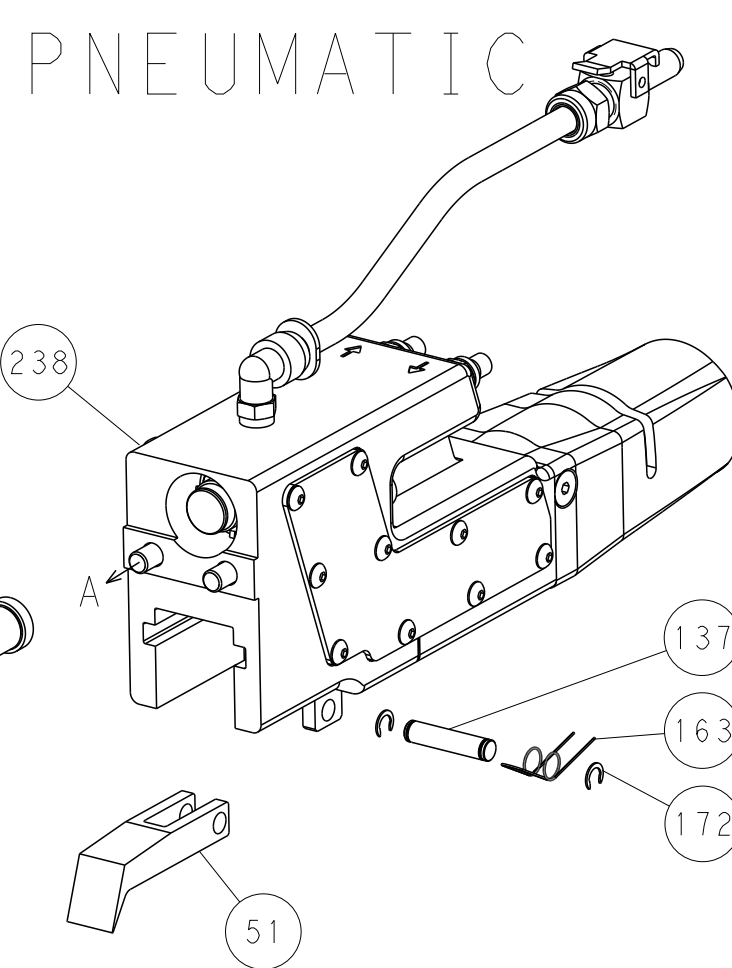
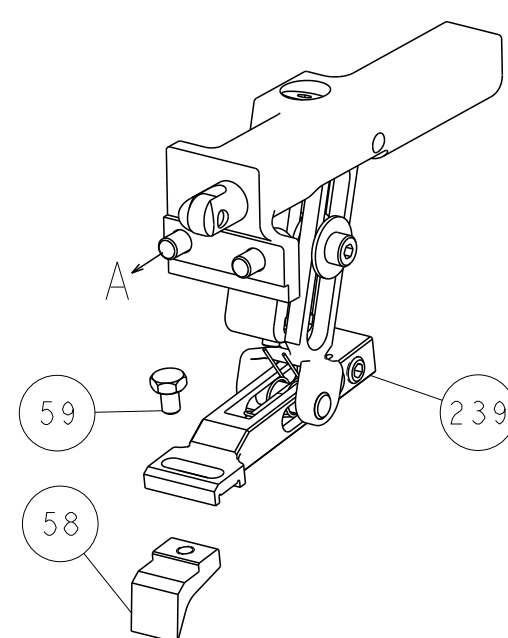
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

2		1						
LOC	DIST	REVISIONS						
A	66	P	LTR	DESCRIPTION	DATE	DWN	APVD	
		I		DEVELOPMENT	22JUL2013	KH	UG	
		A		RELEASED	13SEP2013	BH	GB	
		B		ECR-17-008859	19JUNE2017	TB	TE	
		C		ECR-18-016631	20OCT2018	TB	TE	

	-	1	-	1	-	2119640-1	PUSH ROD, AIR FEED	250
	-	1	-	1	-	1803259-1	BUSHING, FLANGED	249
	-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248
	-	1	1	1	1	2119082-6	CAM, SNAIL, INSULATION ADJUSTMENT	244
	-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
3	-	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
	-	-	1	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
	-	1	-	1	-	2063440-1	AIR FEED MODULE	238
	-	1	1	1	1	1-18028-0	WASHER, FLAT, REG M8	192
	-	2	-	2	-	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172
	-	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
	-	1	-	1	-	240638-1	SPRING, FEED FINGER	163
	-	1	-	1	-	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854	137
5	-	1	1	1	1	2119955-2	ASSY, LUBRICATOR, END FEED	84
	-	1	1	1	1	455888-7	SPACER, CRIMPER	82
	-	1	1	1	1	2119791-9	DEPRESSOR, WIRE	73
	-	1	1	1	1	1803607-2	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	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	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	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	-	2119792-2	PAWL, EF, AIR	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	1752371-2	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	1901696-3	STRIP GUIDE, REAR	19
	-	1	1	1	1	1901695-3	STRIP GUIDE, FRONT	18
	-	4	4	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17
	-	1	1	1	1	2-240641-8	SPACER	16
1	-	1	1	1	1	1-240644-1	PLATE, REAR SHEAR	11
1	-	2	2	2	2	1-240645-6	SPACER, SHEAR PLATE	10
1	-	1	1	1	1	240642-1	PLATE, FRONT SHEAR	9
1	1	2	2	1	1	5-1633384-2	ANVIL, COMBINATION	8
1	-	1	1	1	1	2-691157-6	BLADE, SHEAR -	7
	-	-	-	-	-	-	-	6
	-	1	1	1	1	4-240641-8	SPACER	5
	-	1	1	1	1	238011-3	BLOCK, CRIMPER SPACER	4
1	1	2	2	1	1	4-1633962-0	CRIMPER, INSULATION F PREMIUM	3
	-	-	-	-	-	-	-	2
1	1	2	2	1	1	5-1633730-0	CRIMPER, WIRE	1
	-77-72-71	-2	-1			PART NO	DESCRIPTION	ITEM NO

THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE WITHOUT NOTICE AND WITHOUT LIABILITY. THE USER SHALL BE RESPONSIBLE FOR THE LATEST EDITION.				DWN R. HUANG CHK L. ZHANG APVD J. GUO	22JUL2013 22JUL2013 22JUL2013	TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		NAME		Ocean End Feed Applicator	
		0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH ±		PRODUCT SPEC		SIZE	
MATERIAL		-		APPLICATION SPEC		CAGE CODE	
-		-		WEIGHT		DRAWING NO	
-		-		Customer Accessible Production Drawing		RESTRICTED TO	
-		-		SCALE		SHEET 1 OF 4	
-		-		REV		C	

SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

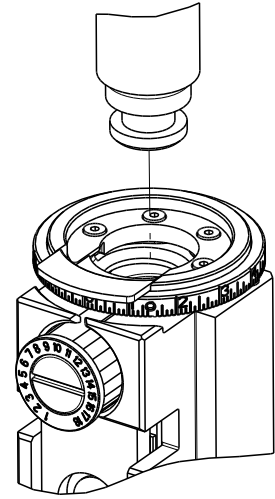


ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

[illegible]

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20		20	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150069-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2150069-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150069-7	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]	F
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: RING			
WIRE STRIP LENGTH 2.79-3.56 mm [.110-.140 IN]		INSULATION DIAMETER RANGE Ø3.05-4.32 mm [.120-.170 IN]	
TERMINAL APPLICATION SPECIFICATION	114-2084	-	-
TERMINALS APPLIED 			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
41330	41332	41333	41333-2
41333-4	41558	41558-1	41559
41560	1217160-1		

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING
14 AWG		1.96+/-0.05 [.077+/- .002]		6.9
16 AWG		1.73+/-0.05 [.068+/- .002]		9.4
18 AWG		1.60+/-0.05 [.063+/- .002]		10.7



- 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.

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

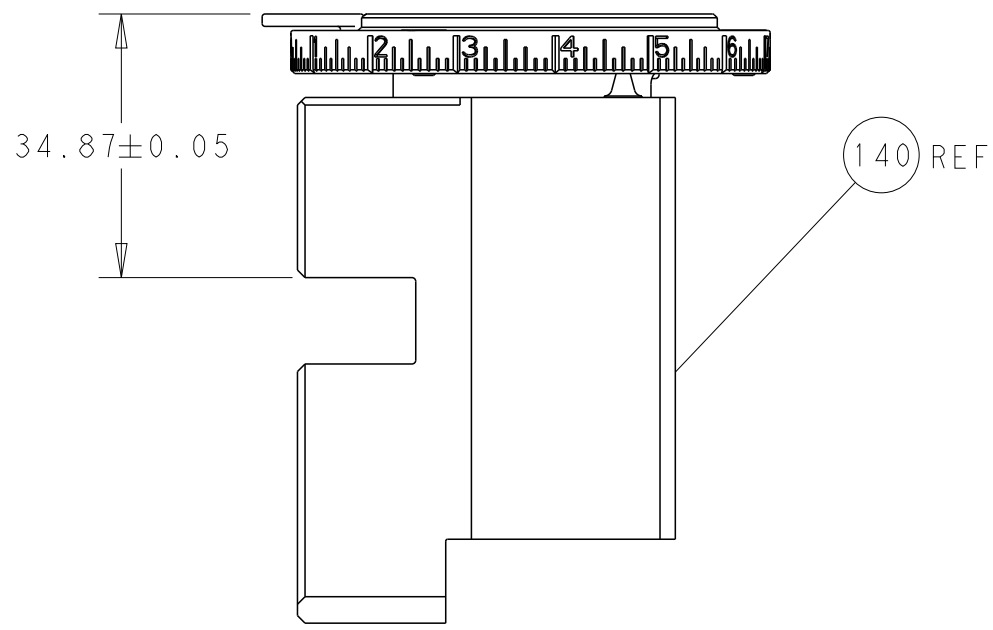
2		1					
LOC	DIST	REVISIONS					
A	66	P	LTR	DESCRIPTION	DATE	DWN	APVD
		-		SEE SHEET 1	-	-	-

	-	1	1	2119640-1	PUSH ROD, AIR FEED	250
	-	1	1	1803259-1	BUSHING, FLANGED	249
	-	1	1	2119082-6	CAM, SNAIL, INSULATION ADJUSTMENT	244
3	-	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	-	2063440-1	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
	-	2	2	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172
	-	REF	REF	994970-2	COUNTER, MAGNETIC	164
	-	1	1	240638-1	SPRING, FEED FINGER	163
	-	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	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854	137
5	-	1	1	2119955-2	ASSY, LUBRICATOR, END FEED	84
	-	1	1	455888-7	SPACER, CRIMPER	82
	-	1	1	2119791-9	DEPRESSOR, WIRE	73
	-	1	1	1803607-2	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	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	56
	-	2	2	5018030-1	NUT, HEX, REG, RoHS, M3	54
	-	2	2	986965-8	NUT, LOCK, HEX, TORQUE (M4)	53
	-	1	-	2119792-2	PAWL, EF, AIR	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	1752371-2	PLATE, STRIP GUIDE	24
	-	2	2	2-22281-3	SPRING, COMPRESSION	22
	-	1	1	1803292-4	DRAG	20
	-	1	1	1901696-3	STRIP GUIDE, REAR	19
	-	1	1	1901695-3	STRIP GUIDE, FRONT	18
	-	1	1	2-240641-8	SPACER	16
1	-	1	1	1-240644-1	PLATE, REAR SHEAR	11
	-	2	2	1-240645-6	SPACER, SHEAR PLATE	10
1	-	1	1	240642-1	PLATE, FRONT SHEAR	9
	1	1	1	5-1633384-2	ANVIL, COMBINATION	8
1	-	1	1	2-691157-6	BLADE, SHEAR -	7
	-	-	-	-	-	6
	-	1	1	4-240641-8	SPACER	5
	-	1	1	238011-3	BLOCK, CRIMPER SPACER	4
1	1	1	1	4-1633962-0	CRIMPER, INSULATION F PREMIUM	3
	-	-	-	-	-	2
1	1	1	1	5-1633730-0	CRIMPER, WIRE	1
	-	77	22	21	PART NO	DESCRIPTION

THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. THE USER SHALL BE RESPONSIBLE FOR OBTAINING THE LATEST EDITION.		DWN R. HUANG 22JUL2013	TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm		CHK L. ZHANG 22JUL2013	NAME Ocean End Feed Applicator	
		APVD J. GUO 22JUL2013	SIZE CAGE CODE DRAWING NO 00779 C=2150069	
MATERIAL -		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH -	RESTRICTED TO -	
Customer Accessible Production Drawing		SCALE 1:1	SHEET 3 OF 4	
			REV C	

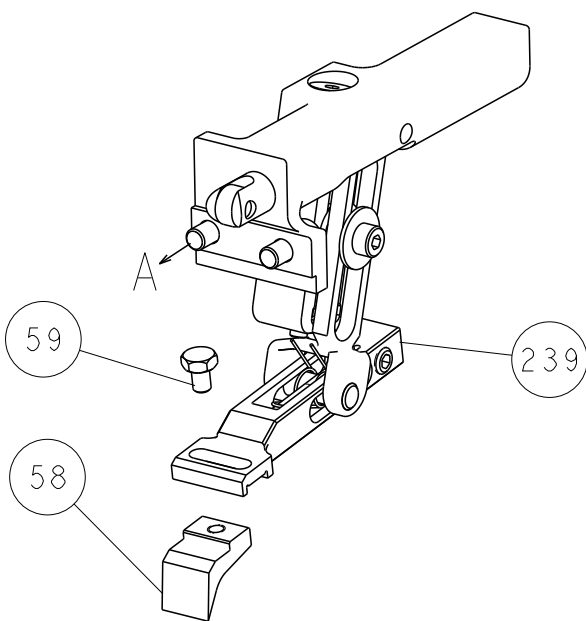
SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

LOC		DIST		REVISONS			
A	66	P	LTR	DESCRIPTION	DATE	DWN	APVD
		-		SEE SHEET 1	-	-	-

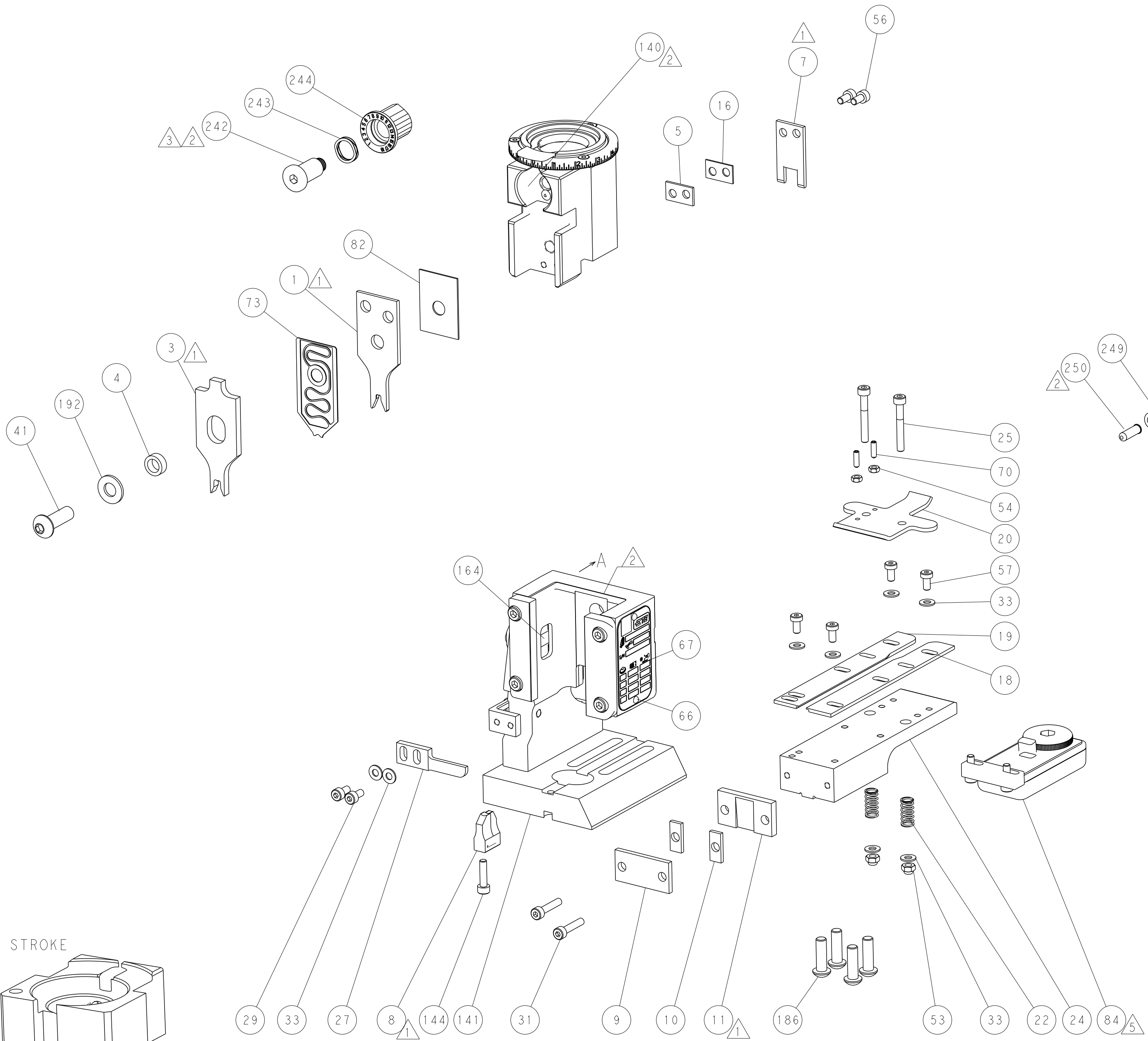
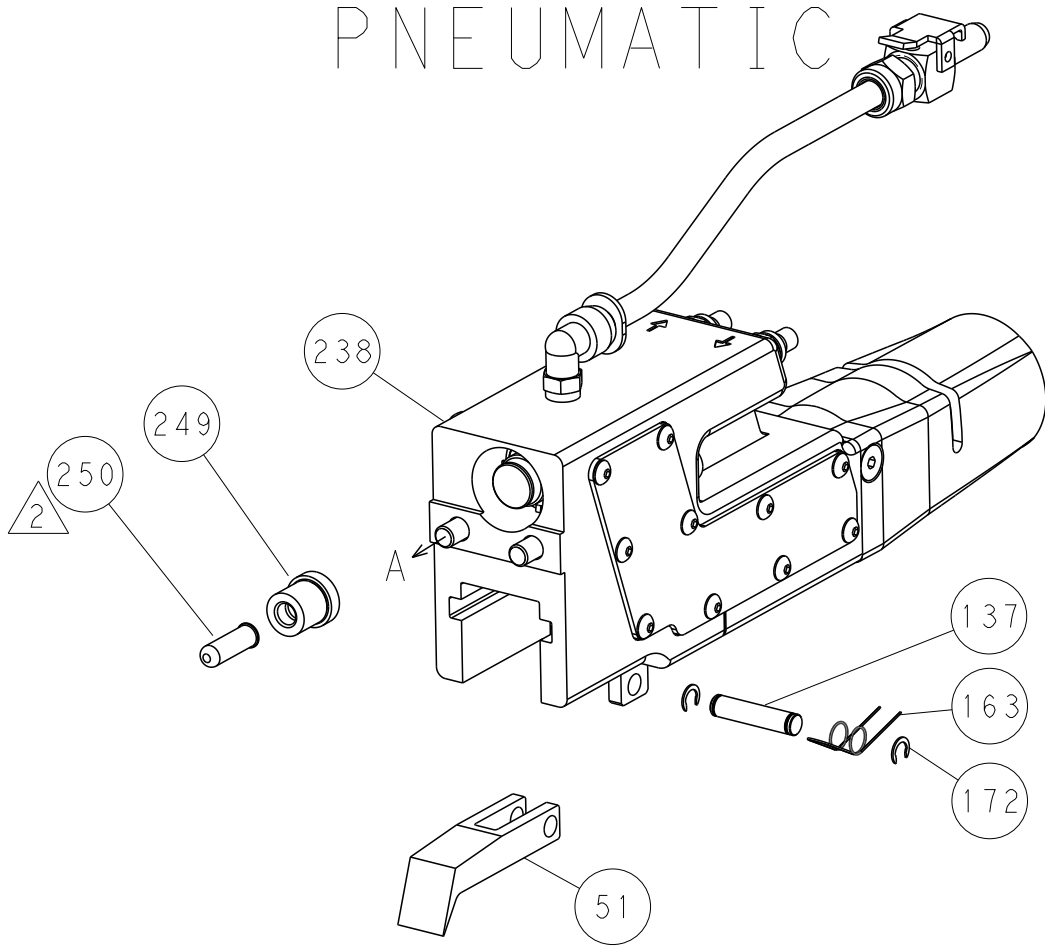


RAM SET-UP

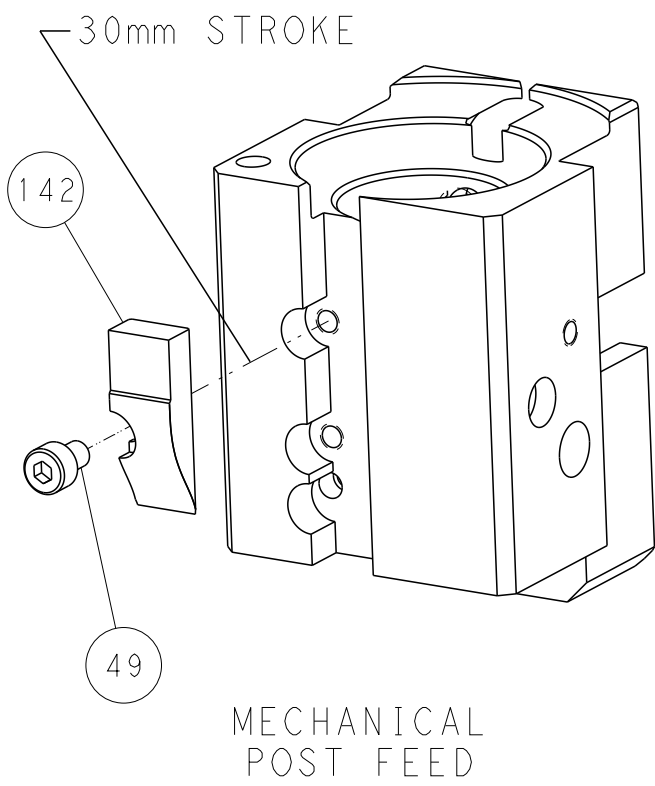
FEED TYPE
MECHANICAL



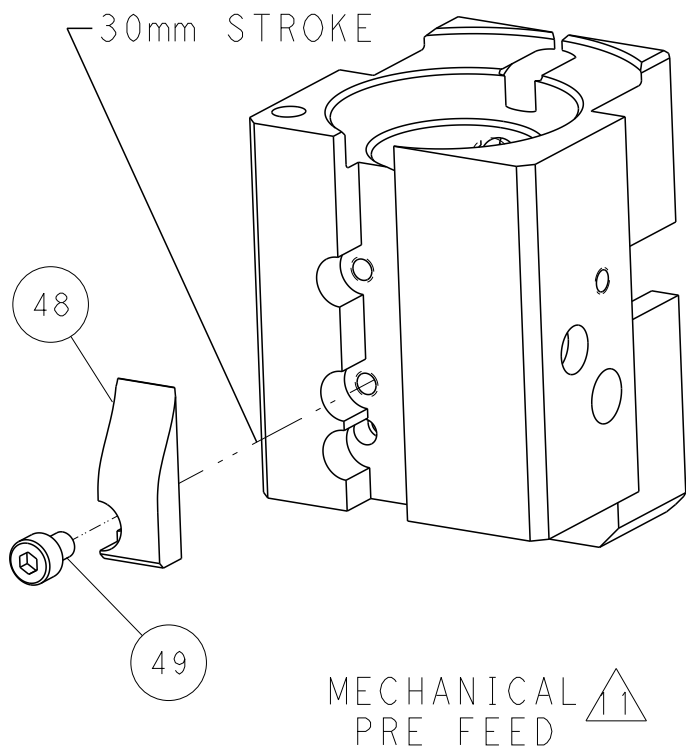
PNEUMATIC



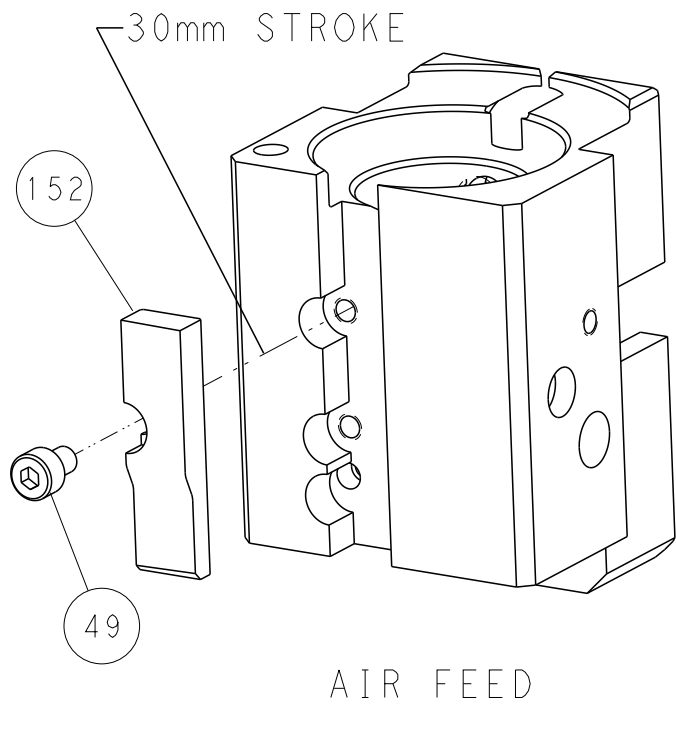
CAM POSITIONS



MECHANICAL
POST FEED



MECHANICAL
PRE FEED



AIR FEED

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

THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. THE USER SHALL BE RESPONSIBLE FOR THE LATEST VERSION.				DWN	K. HUANG	22JUL2013	STE TE Connectivity Harrisburg, PA 17105-3608	
				CHK	L. ZHANG	22JUL2013		
				APVD	J. GUO	22JUL2013	NAME	
				PRODUCT SPEC			APPLICATION SPEC	
				WEIGHT			SIZE	
				Customer Accessible Production Drawing			CAGE CODE	
				SCALE			DRAWING NO	
				1:1			00779	
				SHEET			REV	
				4			C	