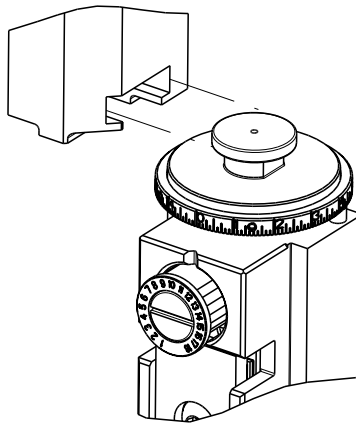


8		7	
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20		20	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150283-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2150283-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150283-1	B	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2150283-2	B	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150283-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.03 mm [.080]	F
INSUL	3.30 mm [.130]	F
APPL INSTRUCTIONS 408-35042		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: TERMINAL RING			
WIRE STRIP LENGTH 3.58-3.96 mm [.141-.156 IN]		INSULATION DIAMETER RANGE Ø2.03-2.54 mm [.080-.100 IN]	
TERMINAL APPLICATION SPECIFICATION	114-2084	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
41582	41580	41589	41579
41581	41590		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
20 AWG	1.45+/-0.05 [1.057+/- .002]	9.6
(2)24	1.37+/-0.05 [1.054+/- .002]	10.4
22 AWG	1.37+/-0.05 [1.054+/- .002]	10.4
24 AWG	1.32+/-0.05 [1.052+/- .002]	10.9

- 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 180. 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. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.

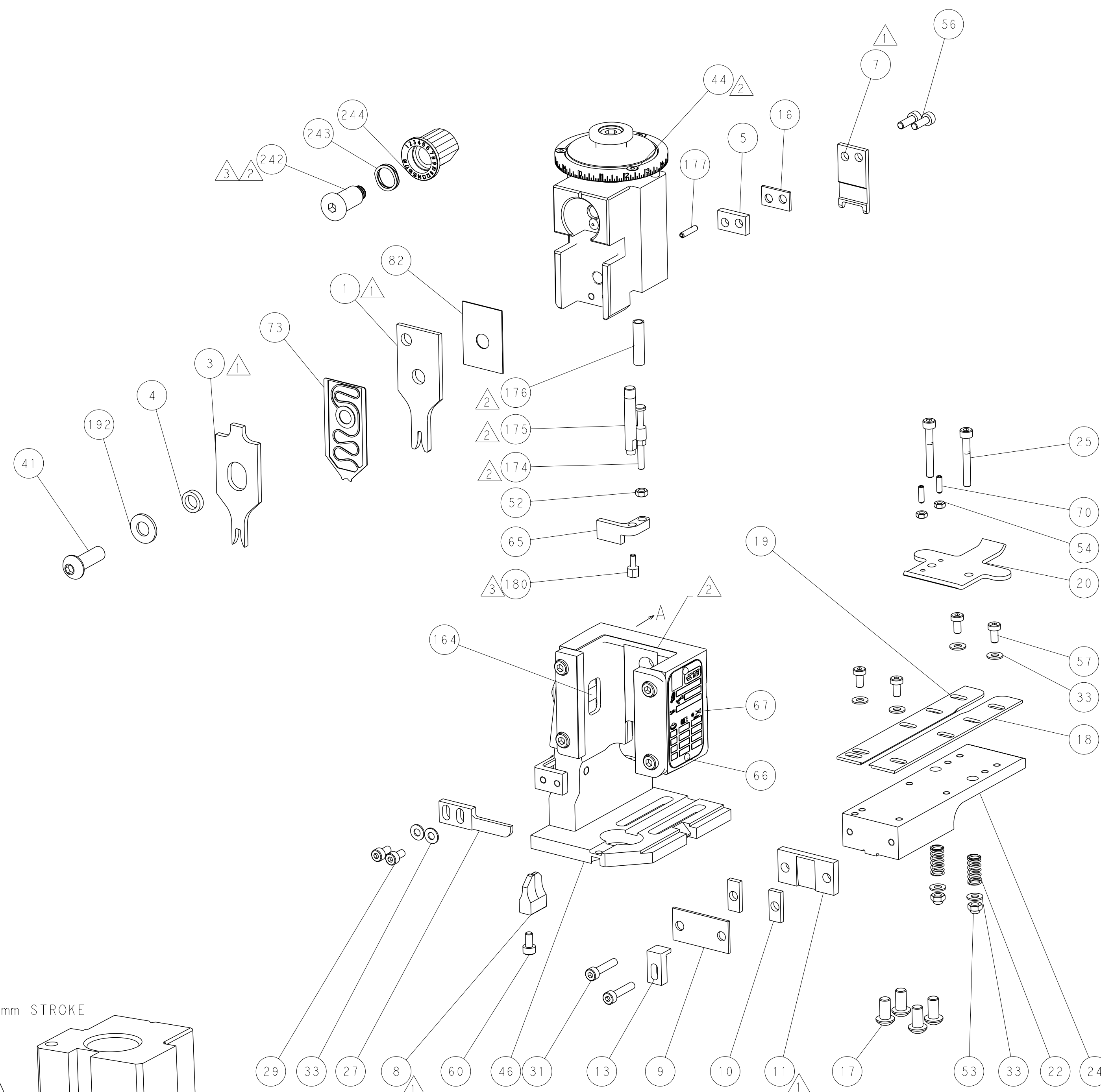
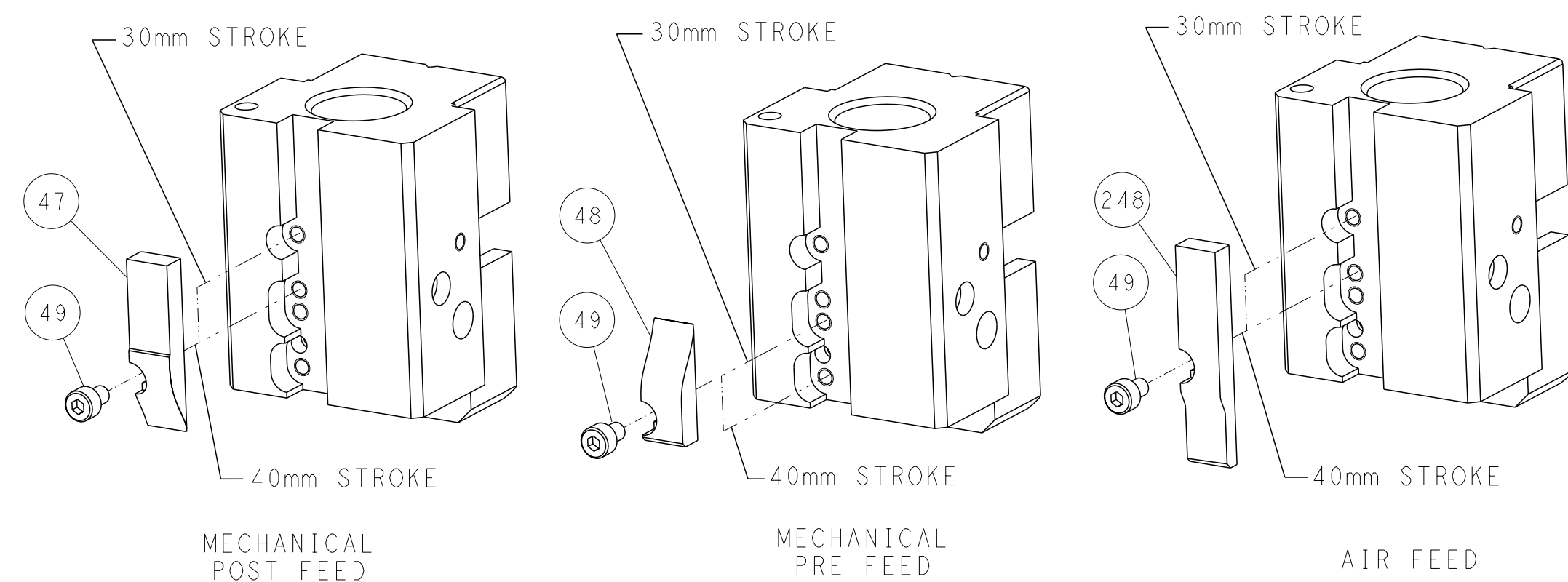
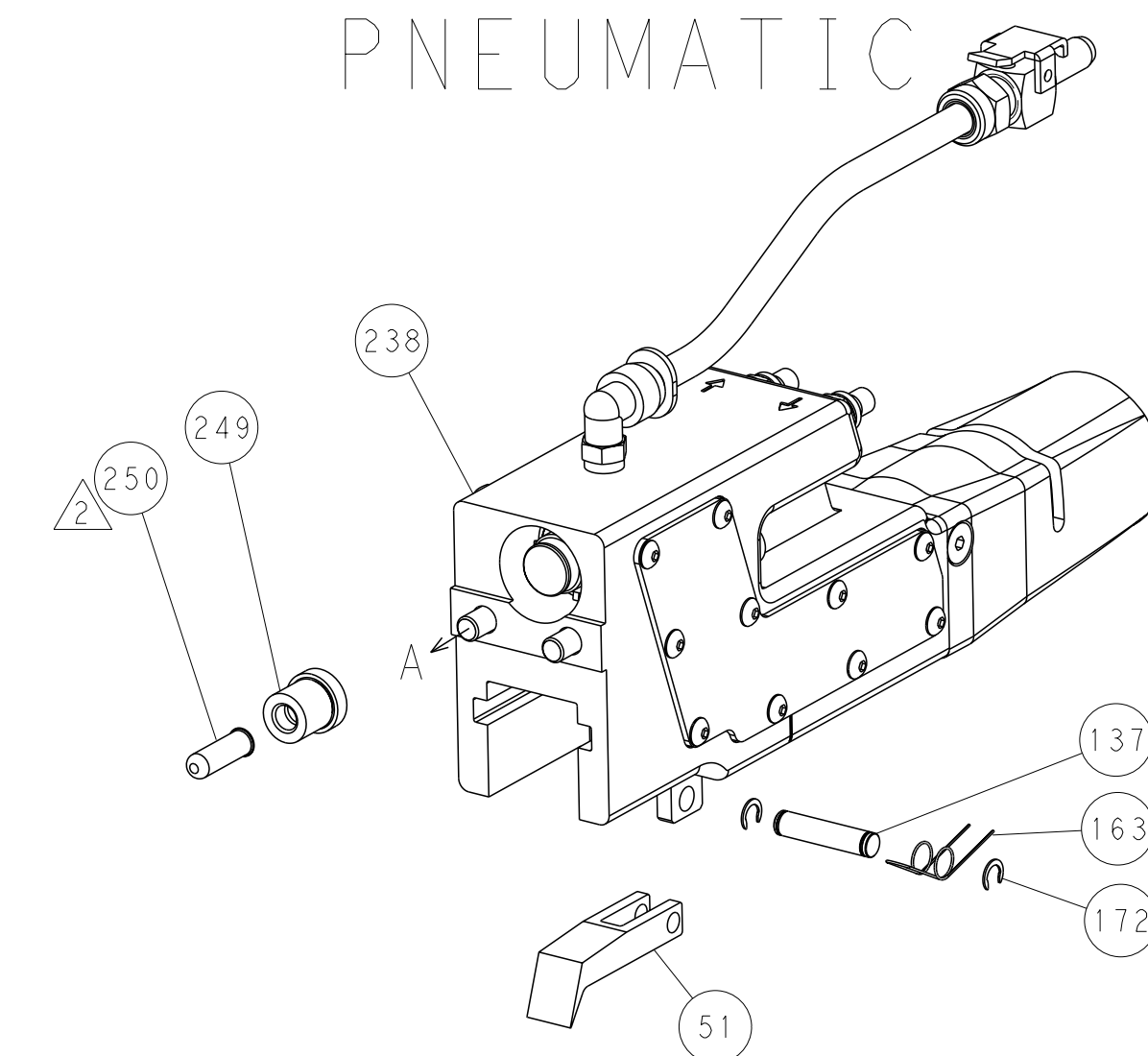
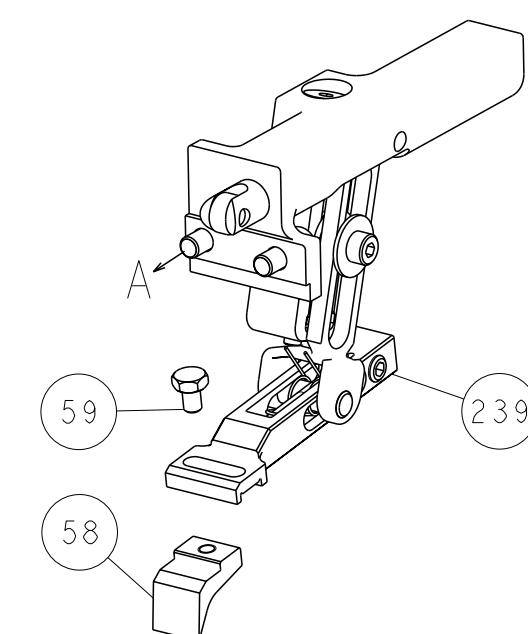
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

LOC	DIST	REVISIONS				
		P	LYR	DESCRIPTION	DATE	OWN
A	66	B		ECR-19-000292	08JAN2019	JAH

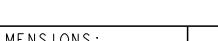
-	1	-	1	-	2119640-1	PUSH ROD, AIR FEED	250
-	1	-	1	-	1803259-1	BUSHING, FLANGED	249
-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248
-	1	1	1	1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	-	1	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	1	-	1	-	2063440-1	AIR FEED MODULE	238
-	1	1	1	1	1-18028-0	WASHER, FLAT, REG M8	192
-	1	1	1	1	1752354-4	STANDOFF,HOLD-DOWN	180
-	1	1	1	1	6-9931111-6	PIN, SLOTTED SPRING 3.0 X 14.0	177
-	1	1	1	1	8-22280-7	SPRING, COMPRESSION	176
-	1	1	1	1	1752353-2	GUIDE PIN,HOLDDOWN	175
-	1	1	1	1	1901680-2	GUIDE PIN,HOLDDOWN	174
-	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
-	1	1	1	1	455888-5	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	1901681-1	HOLDDOWN, TERMINAL	65
-	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	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	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	1	1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52
-	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	1752371-5	PLATE, STRIP GUIDE	24
-	2	2	2	2	2-22281-3	SPRING, COMPRESSION	22
-	1	1	1	1	1803292-1	DRAG	20
-	1	1	1	1	1901696-2	STRIP GUIDE, REAR	19
-	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	6-240641-4	SPACER	16
-	1	1	1	1	1752360-1	SPACER,HOLD-DOWN	13
-	1	1	1	1	240644-9	PLATE, REAR SHEAR	11
-	2	2	2	2	1-240645-2	SPACER, SHEAR PLATE	10
-	1	1	1	1	2-240642-2	PLATE, FRONT SHEAR	9
1	2	2	1	1	1-1803001-0	ANVIL, COMBINATION, END FEED	8
-	1	1	1	1	2-240651-0	BLADE, SLUG	7
-	-	-	-	-	-	-	6
-	1	1	1	1	4-240641-1	SPACER	5
-	1	1	1	1	238011-2	BLOCK, CRIMPER SPACER	4
1	2	2	1	1	2-1633961-6	CRIMPER, INSULATION F PREMIUM	3
-	-	-	-	-	-	-	2
1	2	2	1	1	1-456405-5	CRIMPER, WIRE PREMIUM	1
-77-72-71-2-1	PART NO					DESCRIPTION	ITEM NO

THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE AND TO BE CONTROLLED BY THE DRAWING ENGINEERING DEPARTMENT. IT SHOULD BE CONTACTED FOR THE LATEST REVISION.				OWN J. HAYNES CHK R. KNEPPER APVD C. TOPPER	8JAN2019 8JAN2019 8JAN2019	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 ±		PRODUCT SPEC		SIZE A1	
MATERIAL :		FINISH :		APPLICATION SPEC		CAGE CODE 00779	
				WEIGHT :		DRAWING NO C=2150283	
				Customer Accessible Production Drawing		RESTRICTED TO -	
				SCALE 1:1		SHEET 1 OF 4	
						REV B	

SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

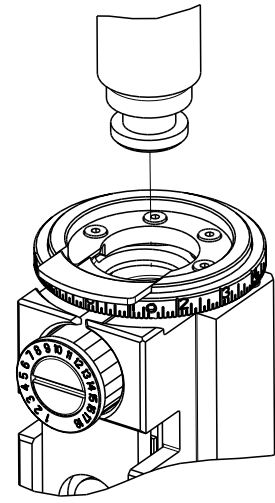


ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

THIS DRAWING IS A CONTROLLED DOCUMENT. FOR TECHNICAL SERVICES CORPORATION IT IS SUBJECT TO CHANGE AND THE CONTROLLING ENGINEERING ORGANIZATION MUST BE NOTIFIED OF ANY CHANGES FOR THE LATEST VERSION.		DWN 8JAN2019 CHK HAYNES 8JAN2019 R KNEPPER 8JAN2019 C TOPPER 8JAN2019		 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	
		PRODUCT SPEC - APPLICATION SPEC -		SIZE A 00779	
MATERIAL -		WEIGHT -		DRAWING NO C=2150283	
				RESTRICTED TO -	
Customer Accessible Production Drawing				SCALE 1:1 SHEET 2 OF 4 REV A	

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20		20	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150283-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2150283-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150283-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.03 mm [.080]	F
INSUL	3.30 mm [.130]	F
APPL INSTRUCTIONS 408-35042		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: TERMINAL RING			
WIRE STRIP LENGTH 3.58-3.96 mm [.141-.156 IN]		INSULATION DIAMETER RANGE Ø2.03-2.54 mm [.080-.100 IN]	
TERMINAL APPLICATION SPECIFICATION	114-2084	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
41582	41580	41589	41579
41581	41590		

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING
20 AWG		1.45+/-0.05 [.057+/- .002]		9.6
(2)24		1.37+/-0.05 [.054+/- .002]		10.4
22 AWG		1.37+/-0.05 [.054+/- .002]		10.4
24 AWG		1.32+/-0.05 [.052+/- .002]		10.9



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 180. 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. 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)

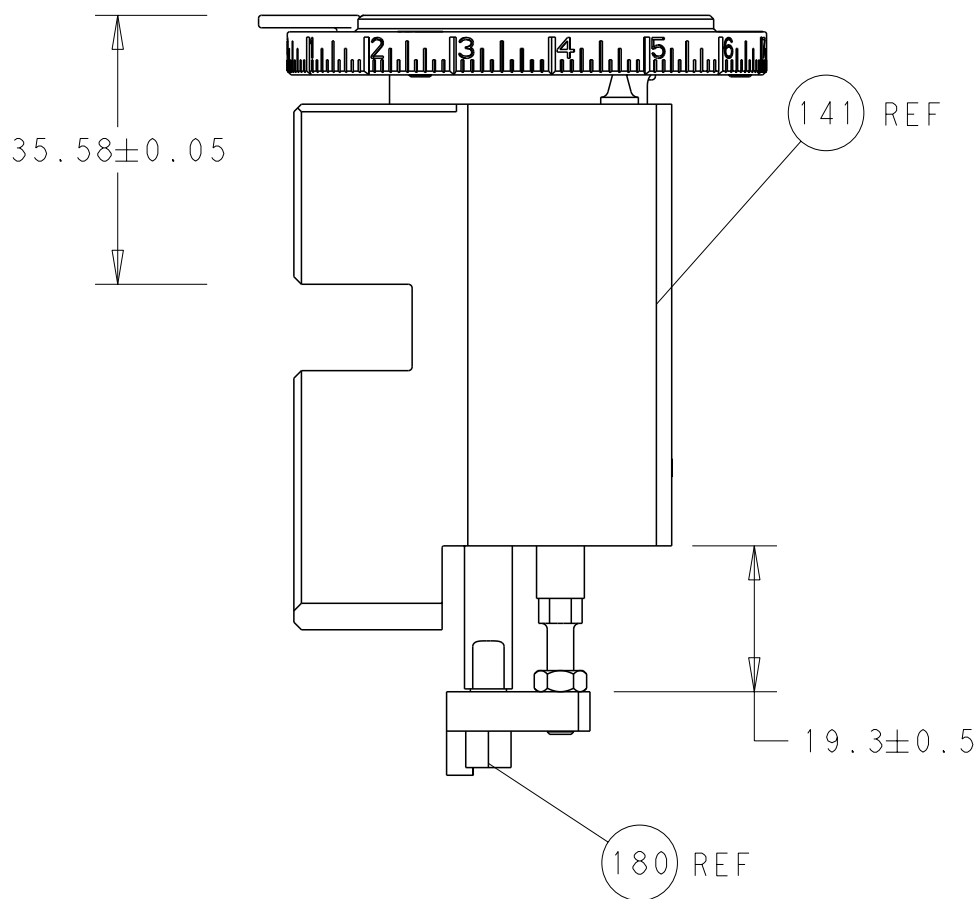
2		1						
LOC	DIST	REVISIONS						
A	66	DESCRIPTION				DATE	DWN	APVD
		P	LTR					
			-	SEE SHEET 1		-	-	-

-	1	1	2119640-1	PUSH ROD, AIR FEED	250
-	1	1	1803259-1	BUSHING, FLANGED	249
-	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	-	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
3	-	1	1752354-4	STANDOFF,HOLD-DOWN	180
-	1	1	6-9931111-6	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
-	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
-	1	1	455888-5	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	1901681-1	HOLDDOWN, TERMINAL	65
-	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	2168083-3	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	-	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	1752371-5	PLATE, STRIP GUIDE	24
-	2	2	2-22281-3	SPRING, COMPRESSION	22
-	1	1	1803292-1	DRAG	20
-	1	1	1901696-2	STRIP GUIDE, REAR	19
-	1	1	1901695-2	STRIP GUIDE, FRONT	18
-	1	1	6-240641-4	SPACER	16
-	1	1	1752360-1	SPACER,HOLD-DOWN	13
1	-	1	240644-9	PLATE, REAR SHEAR	11
1	-	2	2-240645-2	SPACER, SHEAR PLATE	10
1	-	1	2-240642-2	PLATE, FRONT SHEAR	9
1	1	1	1-1803001-0	ANVIL, COMBINATION, END FEED	8
1	-	1	2-240651-0	BLADE, SLUG	7
-	-	-	-	-	6
-	1	1	4-240641-1	SPACER	5
-	1	1	238011-2	BLOCK, CRIMPER SPACER	4
1	1	1	2-1633961-6	CRIMPER, INSULATION F PREMIUM	3
-	-	-	-	-	2
1	1	1	1-456405-5	CRIMPER, WIRE PREMIUM	1
-	77-22	-21	PART NO	DESCRIPTION	ITEM NO

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CHK R. KNEPPER 8JAN2019				NAME	Ocean End Feed Applicator	
APVD C. TOPPER 8JAN2019				PRODUCT SPEC	-	
APPLICATION SPEC				SIZE	CAGE CODE	DRAWING NO
MATERIAL				WEIGHT	A1 00779 ©=2150283	
FINISH				Customer Accessible Production Drawing	SCALE	1:1
				SHEET	3	OF 4
				REV	B	

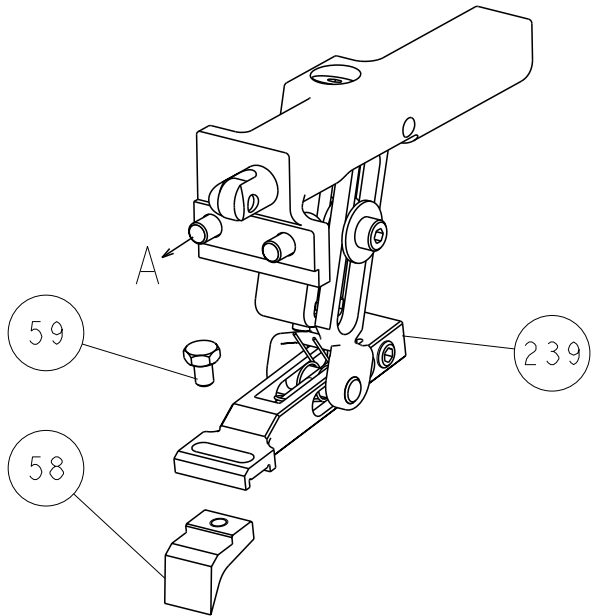
SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

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

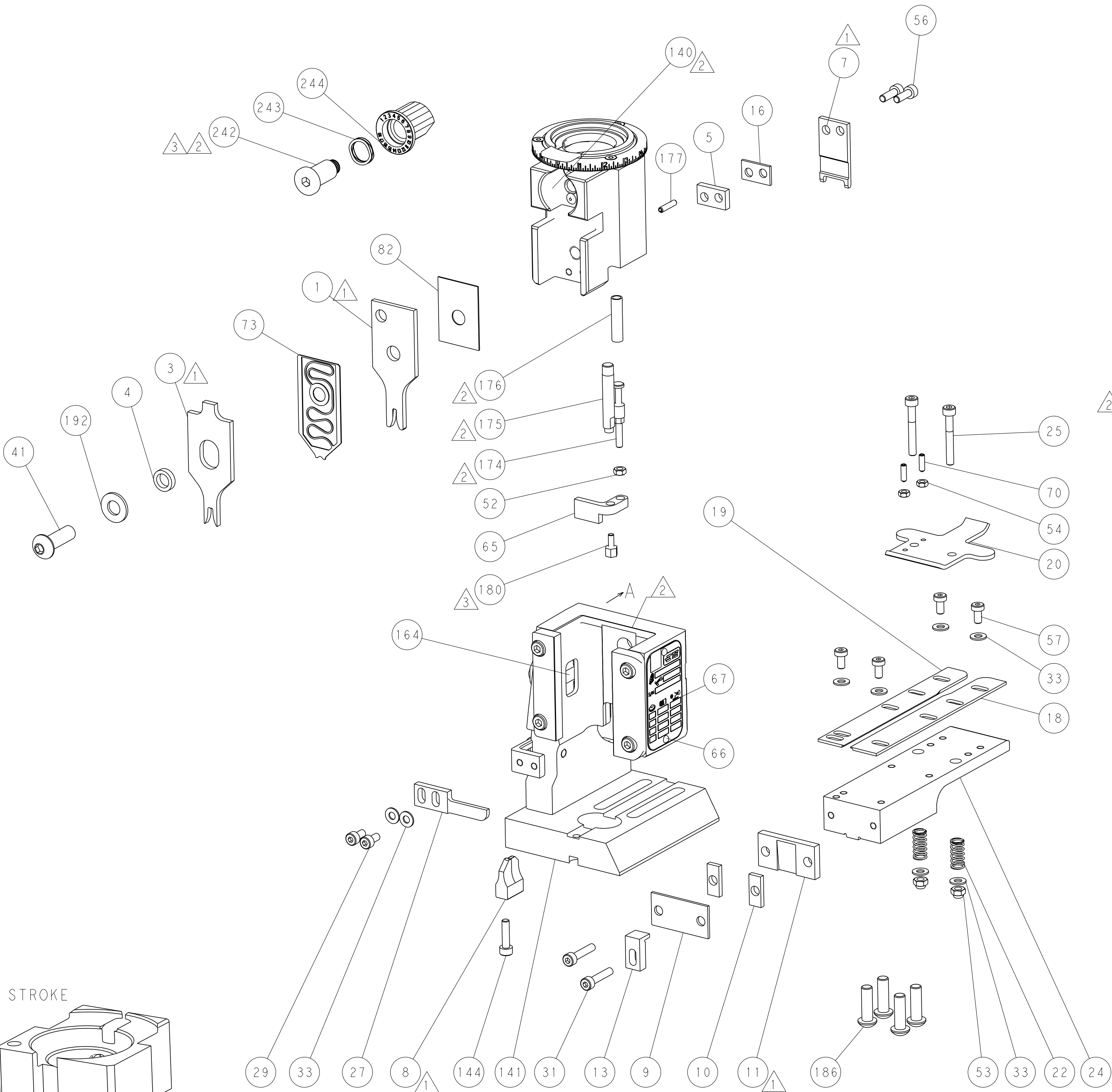
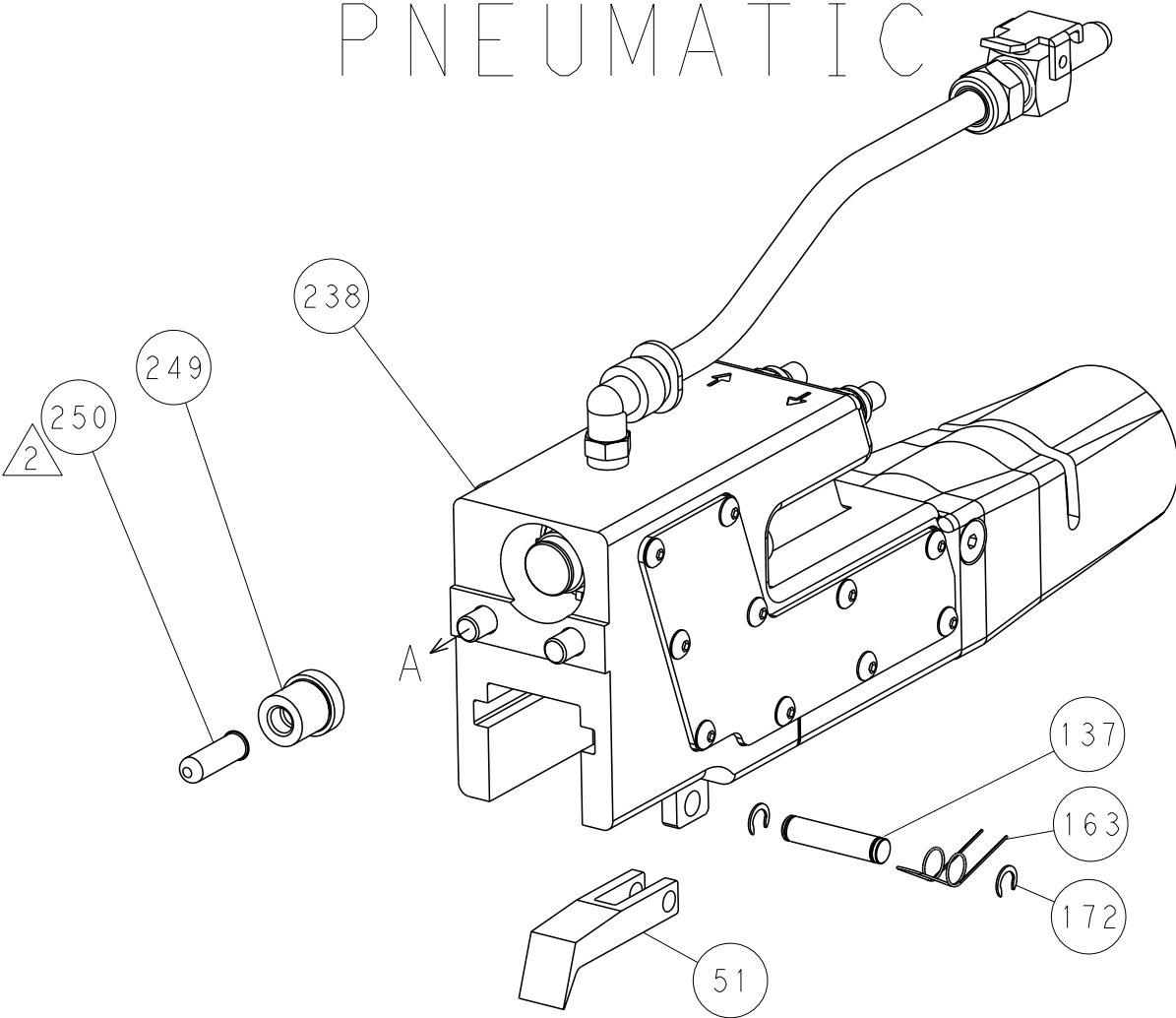


RAM AND HOLDDOWN SET-UP

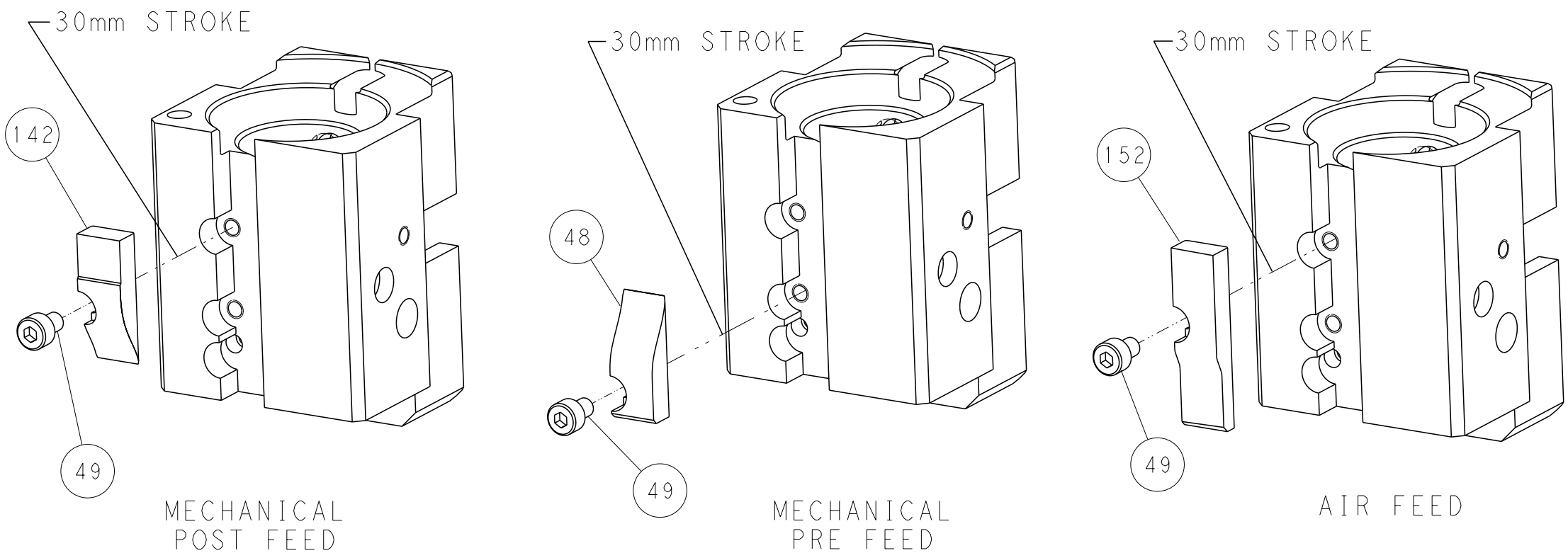
FEED TYPE
MECHANICAL



PNEUMATIC



CAM POSITIONS



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 A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION IT IS SUBJECT TO CHANGE AND TO CONTROL AND ENGINEERING ORGANIZATION SHALL BE CONTACTED FOR THE LATEST REVISION				DWN J. HAYNES 8JAN2019	TE Connectivity Harrisburg, PA 17105-3608		
				CHK R. KNEPPER 8JAN2019			
				APVD C. TOPPER 8JAN2019	NAME Ocean End Feed Applicator		
				PRODUCT SPEC			
				APPLICATION SPEC			
				WEIGHT			
				Customer Accessible Production Drawing			
				SCALE			
				SHEET			
				OF			
				REV			