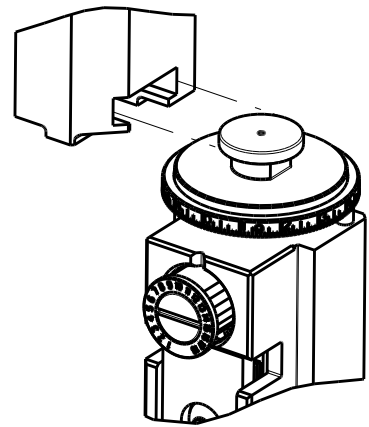


8		7	
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20		20	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150408-2	D	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150408-2	D	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150408-7	A	CRIMP TOOLING KIT	-



ATLANTIC VERSION TERMINATOR
INTERFACE ADAPTER

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.79 mm [.110]	F
INSUL	5.00 mm [.197]	F
APPLICATOR INSTRUCTIONS		
408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: 3.2Ø CLUSTER REC. "L" TYPE			
WIRE STRIP LENGTH 7.70-8.70 mm [1.303"-1.343 IN]		INSULATION DIAMETER RANGE Ø2.20-3.20 mm [0.087"-0.126 IN]	
TERMINAL APPLICATION 		114-5215	
SPECIFICATION		-	
TERMINALS APPLIED 			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
316292-1			

WIRE SIZE 	CRIMP HEIGHT mm [INCH] 	CRIMP HEIGHT REFERENCE SETTING 
1.104±1.104±0.97±	2.12+/-0.05 [.083+/- .002]	6.2
0.97±0.97±0.87±	1.97+/-0.05 [.078+/- .002]	8.2
1.02±1.02±	1.84+/-0.05 [.072+/- .002]	9.7
0.92±0.72±	1.70+/-0.05 [.067+/- .002]	11.0



- △ 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 ITEM 180.
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.
- △ TERMINAL LUBRICANT IS RECOMMENDED.
7. 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

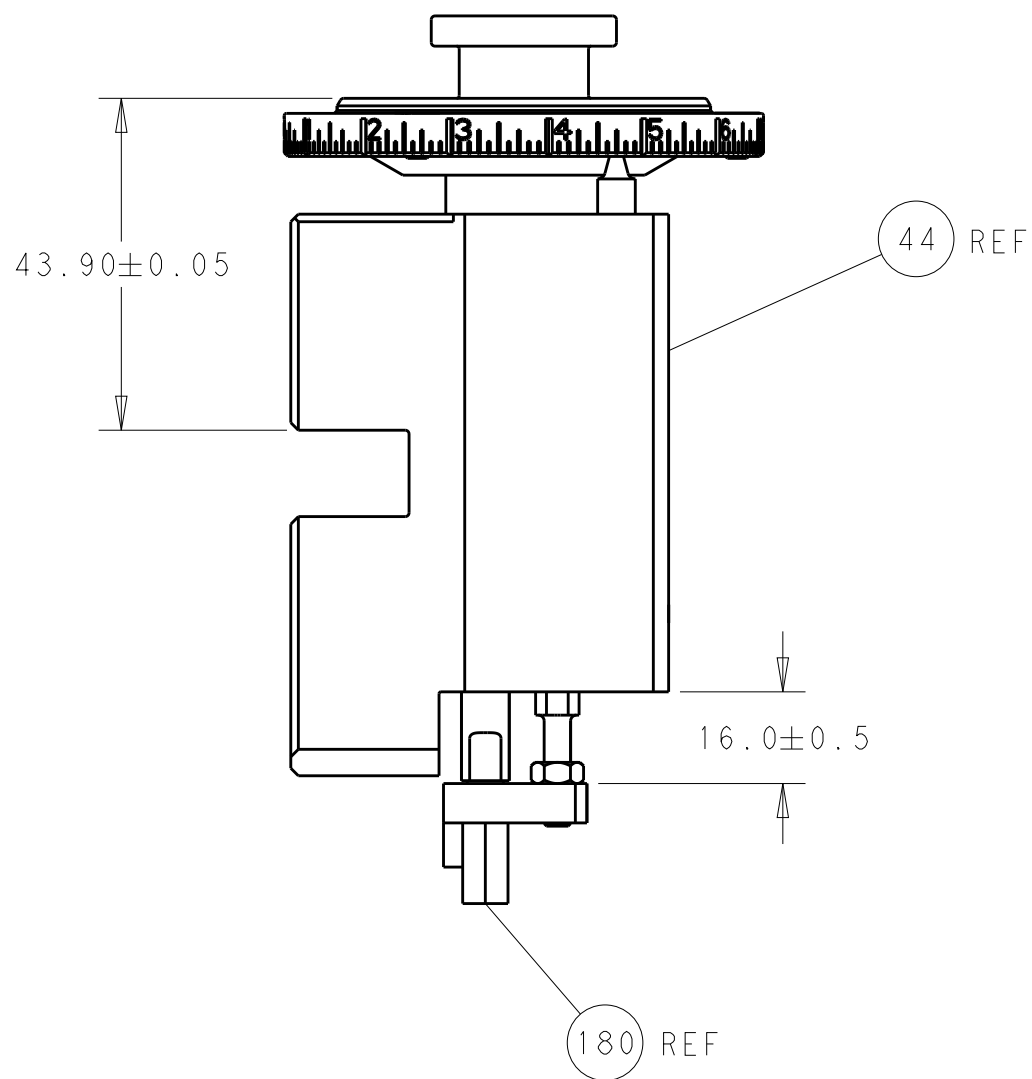
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LOC	DIST	REVISIONS					
A	66	P	LTB	DESCRIPTION	DATE	DWN	APVD
			A	RELEASE	03MAR2014	XZ	TE
			B	ECR-18-014766	19SEP2018	FZ	KZ
			C	ECR-19-008970	11JUN2019	LG	TE
			D	ECR-19-016940	01NOV2019	MZ	YY

	2119641-1	FEED CAM, AIR FEED	248
	2119082-7	CAM, SNAIL, INSULATION ADJUSTMENT	244
	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
	2119083-1	RETAINER, INSULATION DIAL	242
	2844940-4	AIR FEED MODULE	238
	1-18028-0	WASHER, FLAT, REG M8	192
	2-1752354-7	STANDOFF, HOLD-DOWN	180
	6-9931111-6	PIN, SLOTTED SPRING 3.0 X 14.0	177
	8-22280-7	SPRING, COMPRESSION	176
	1752353-2	GUIDE PIN, HOLDDOWN	175
	1901680-2	GUIDE PIN, HOLDDOWN	174
F	994970-2	COUNTER, MAGNETIC	164
	2119955-2	ASSY, LUBRICATOR, END FEED	84
	455888-5	SPACER, CRIMPER	82
	1803607-4	DOCUMENTATION PACKAGE	71
	2-18032-2	SCR, SET, FLT PNT, M3 X 10.0	70
	2119740-1	TAG, IDENTIFICATION	67
	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
	1901681-1	HOLDDOWN, TERMINAL	65
	2168400-5	SHCS, LOW HEAD, RoHS, M4 X 20	64
	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	60
	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57
	2-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 14	56
	5018030-1	NUT, HEX, REG, RoHS, M3	54
	986965-8	NUT, LOCK, HEX, TORQUE (M4)	53
	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52
	2063961-1	FEED FINGER	51
	18023-9	SCR, SKT HD CAP M4 X 6.0	49
	2119655-5	APPLICATOR BASIC ASSEMBLY, EF	46
	1803517-1	RAM ASSEMBLY, EF ATLANTIC	44
	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
	1-18028-2	WASHER, FLAT, REG M4	33
	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	31
	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	29
	690455-3	STRIPPER, FRONT CASTING	27
	1-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 30	25
	2-1752371-0	PLATE, STRIP GUIDE	24
	240825-3	PLATE, STRIP HOLD DOWN	23
	22281-8	SPRING, COMPRESSION	22
	1803292-4	DRAG	20
	1901259-7	GUIDE, LOWER STRIP	18
	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17
	2-240641-4	SPACER	16
	1752360-1	SPACER, HOLD-DOWN	13
	240833-6	PLATE, REAR SHEAR	11
	7-240645-4	SPACER, SHEAR PLATE	10
	240642-1	PLATE, FRONT SHEAR	9
	3-1803001-9	ANVIL, COMBINATION, END FEED	8
	9-240651-2	BLADE, SLUG	7
	-	-	6
	1-240641-0	SPACER	5
	238011-4	BLOCK, CRIMPER SPACER	4
	2-1803016-9	CRIMPER, INSULATION F	3
	1-455888-0	SPACER, CRIMPER	2
	409414-3	CRIMPER, WIRE	1
	PART NO	DESCRIPTION	ITEM NO

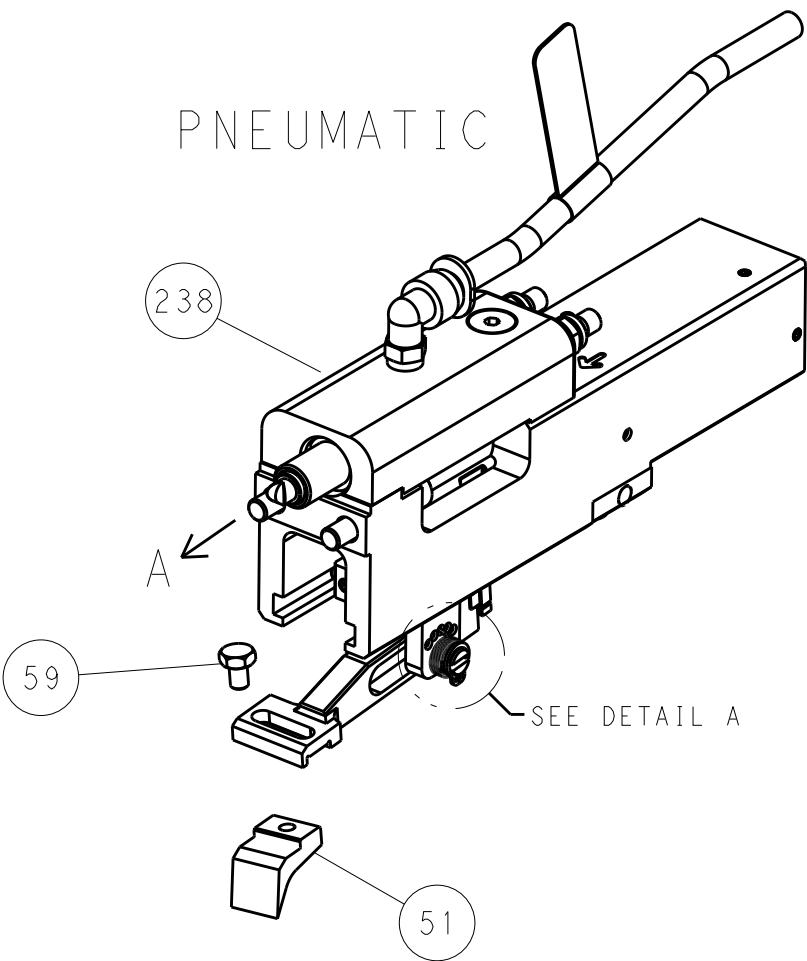
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						CHK L.ZHANG 14JAN2014		Harrisburg, PA 17105-3608	
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		APP'D L.FLEIN 14JAN2014		NAME		Ocean End Feed Applicator	
		Ø PLC ±. PLC ±. 2 PLC ±. 2 PLC ±. PLC ±.		PRODUCT SPEC					
		ANGLES ±.		APPLICATION SPEC					
MATERIAL		FINISH		WEIGHT		SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
-		-		-		A	00779	C=2150408	-
Customer Accessible Production Drawing						SCALE	1:1	SHEET 1 OF 4	REV D

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

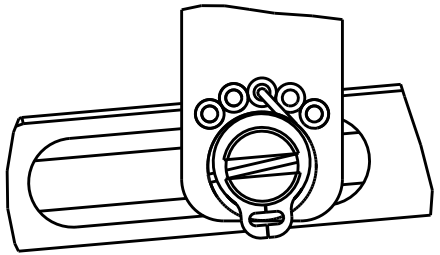


RAM AND HOLDDOWN SET-UP

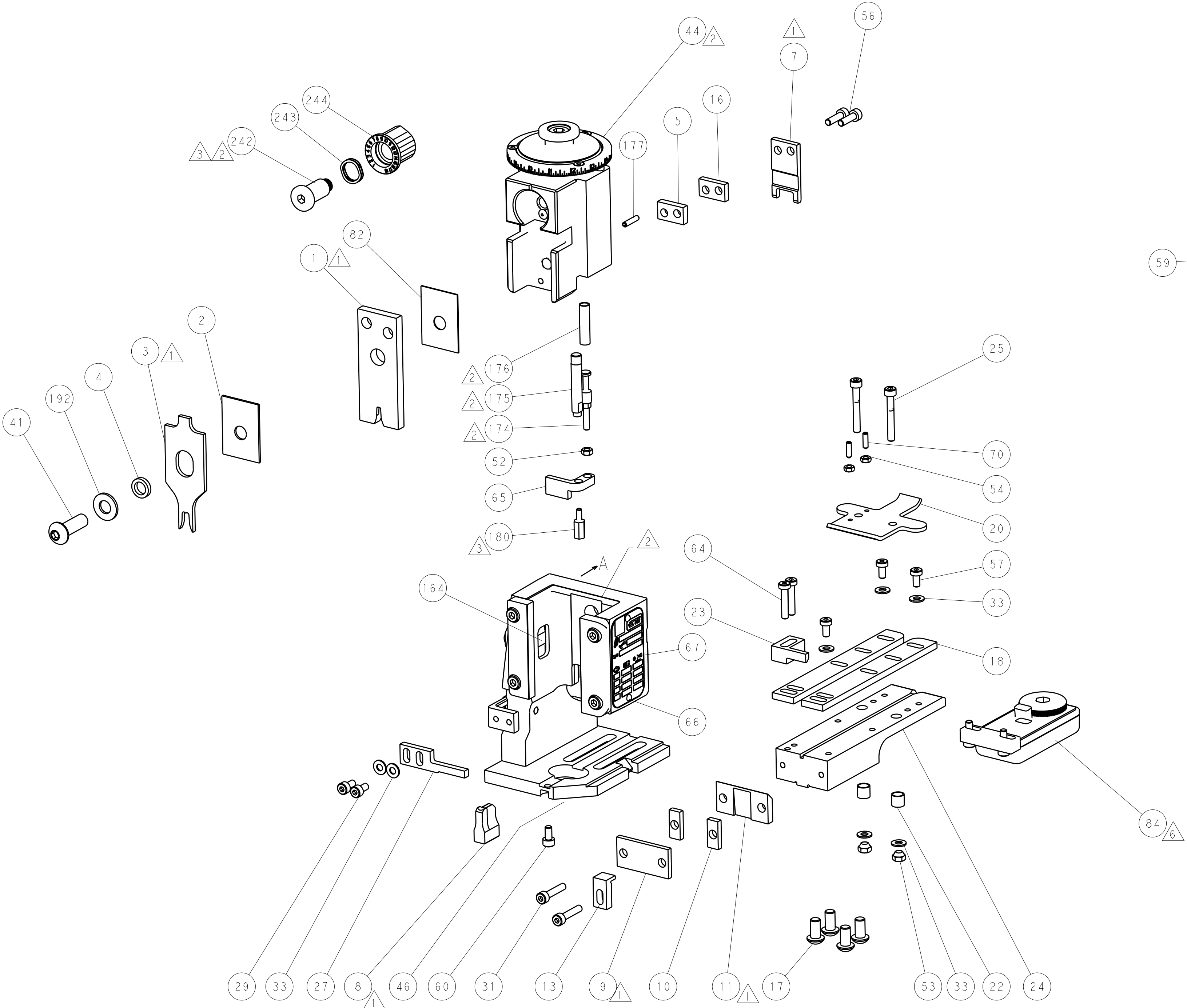
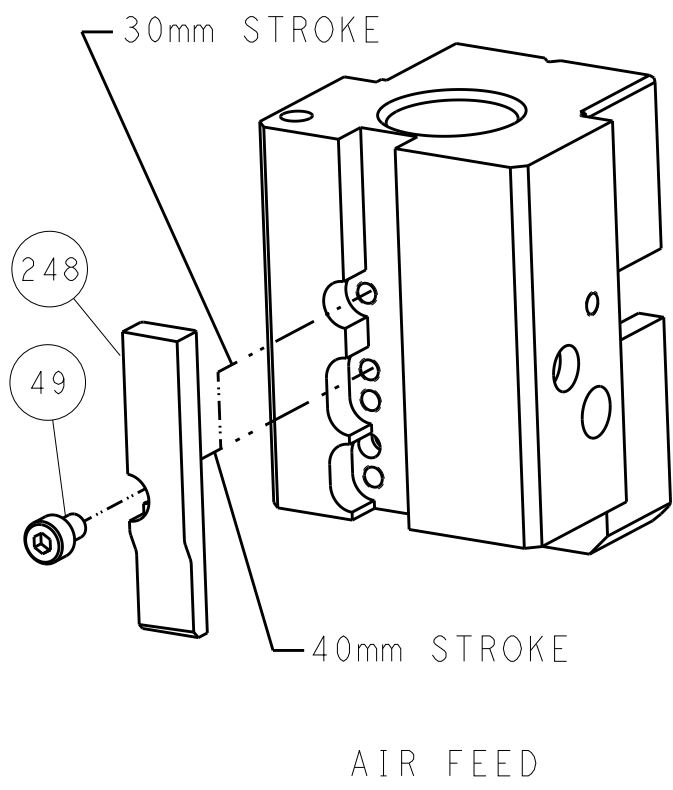
FEED TYPE



FEED SPRING SETTING POSITION



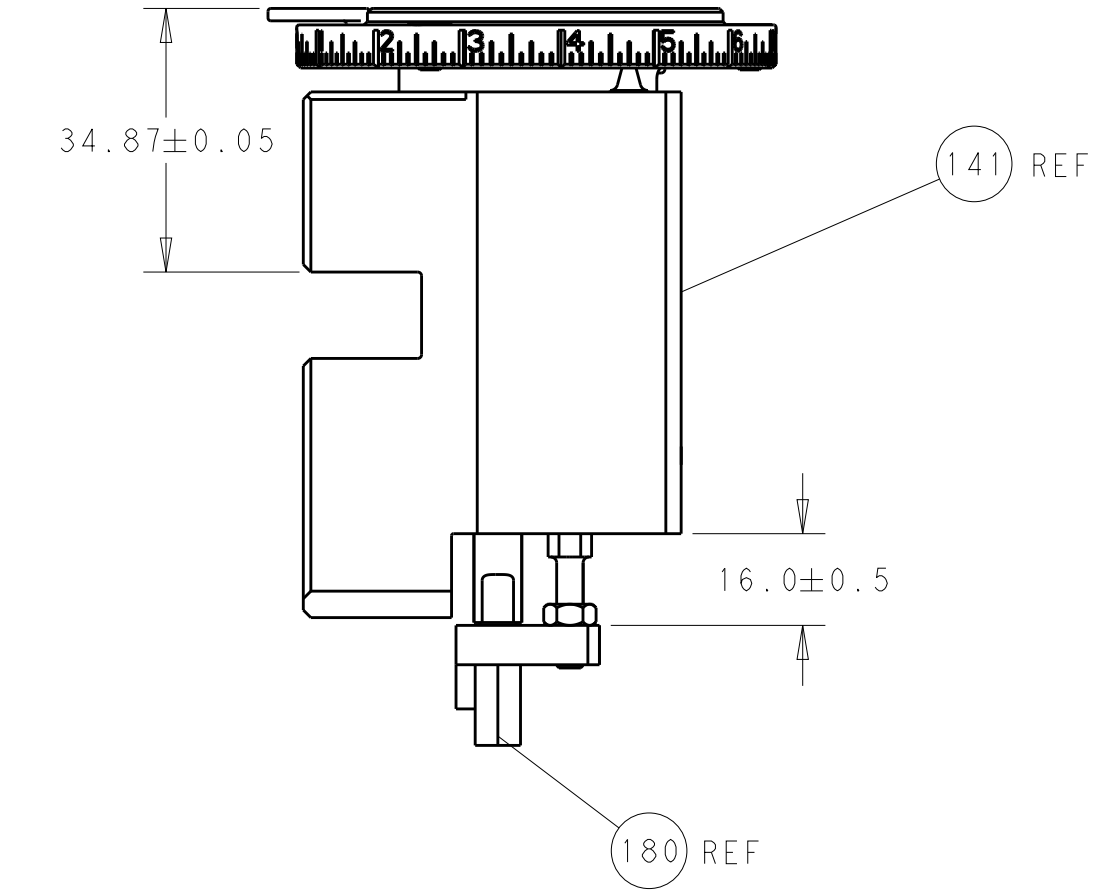
CAM POSITION



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

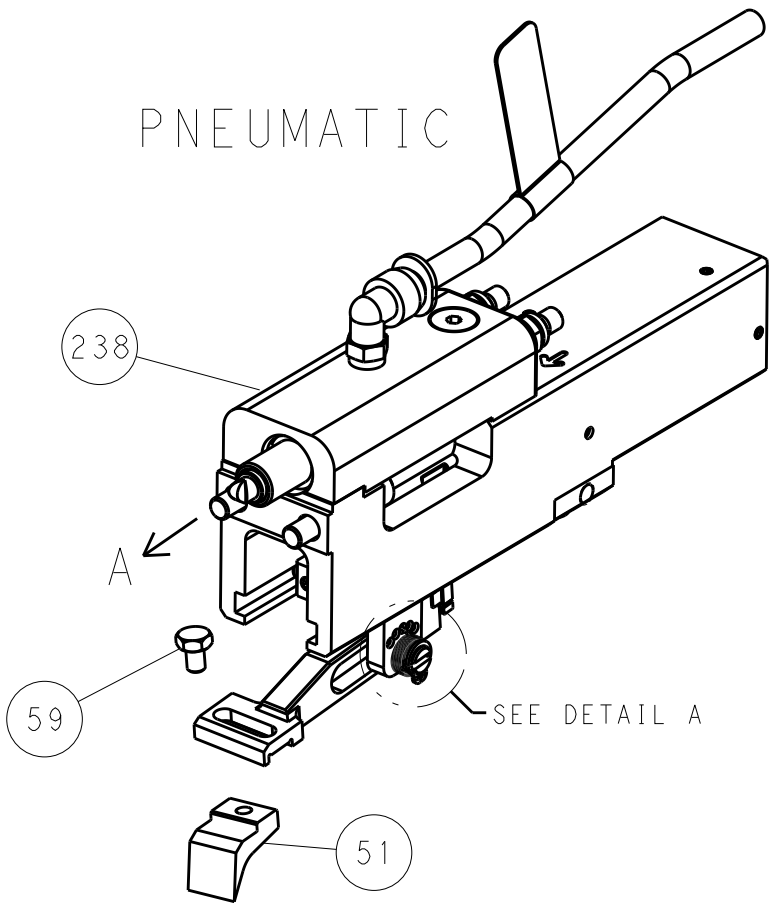
1ST PUBLISHED BY: COMPANY'S TOOLING FOR THE ELECTRONIC CONNECTION IT IS SUBJECT TO CHANGE AND SHOULD BE CONTACTED FOR THE LATEST VERSION.		DWN X. ZHAO CHK L. ZHANG APVD T. ELBIN	14JAN2014 14JAN2014 14JAN2014	TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH		NAME Ocean End Feed Applicator	
MATERIAL		WEIGHT		RESTRICTED TO	
-		-		-	
Customer Accessible Production Drawing		SCALE 1:1		SHEET 2 OF 4	
				REV D	

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

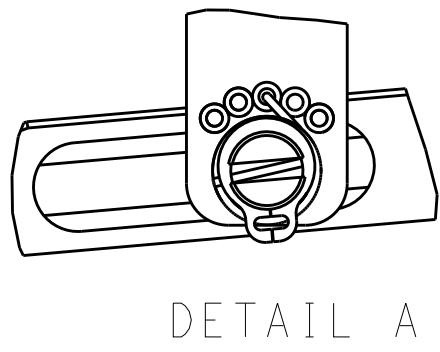


RAM AND HOLDDOWN SET-UP

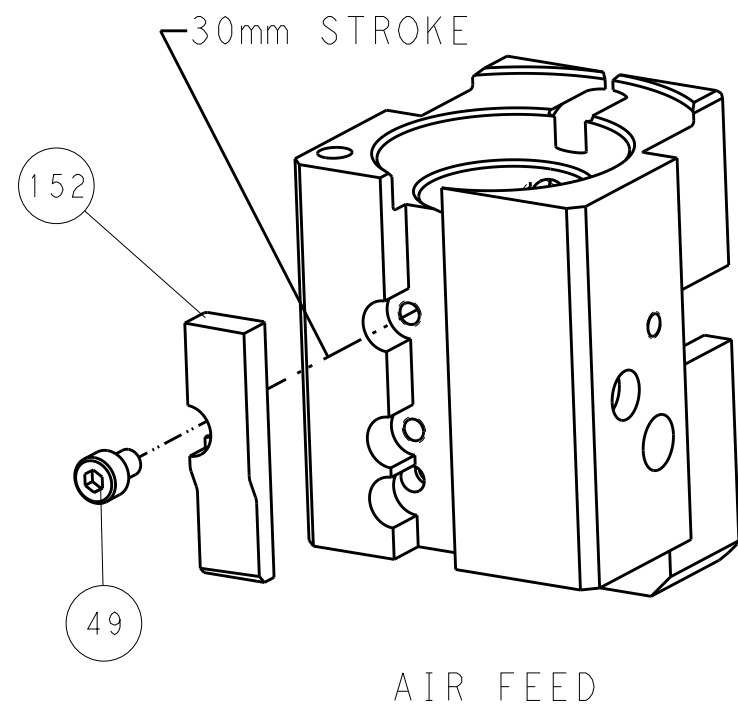
FEED TYPE



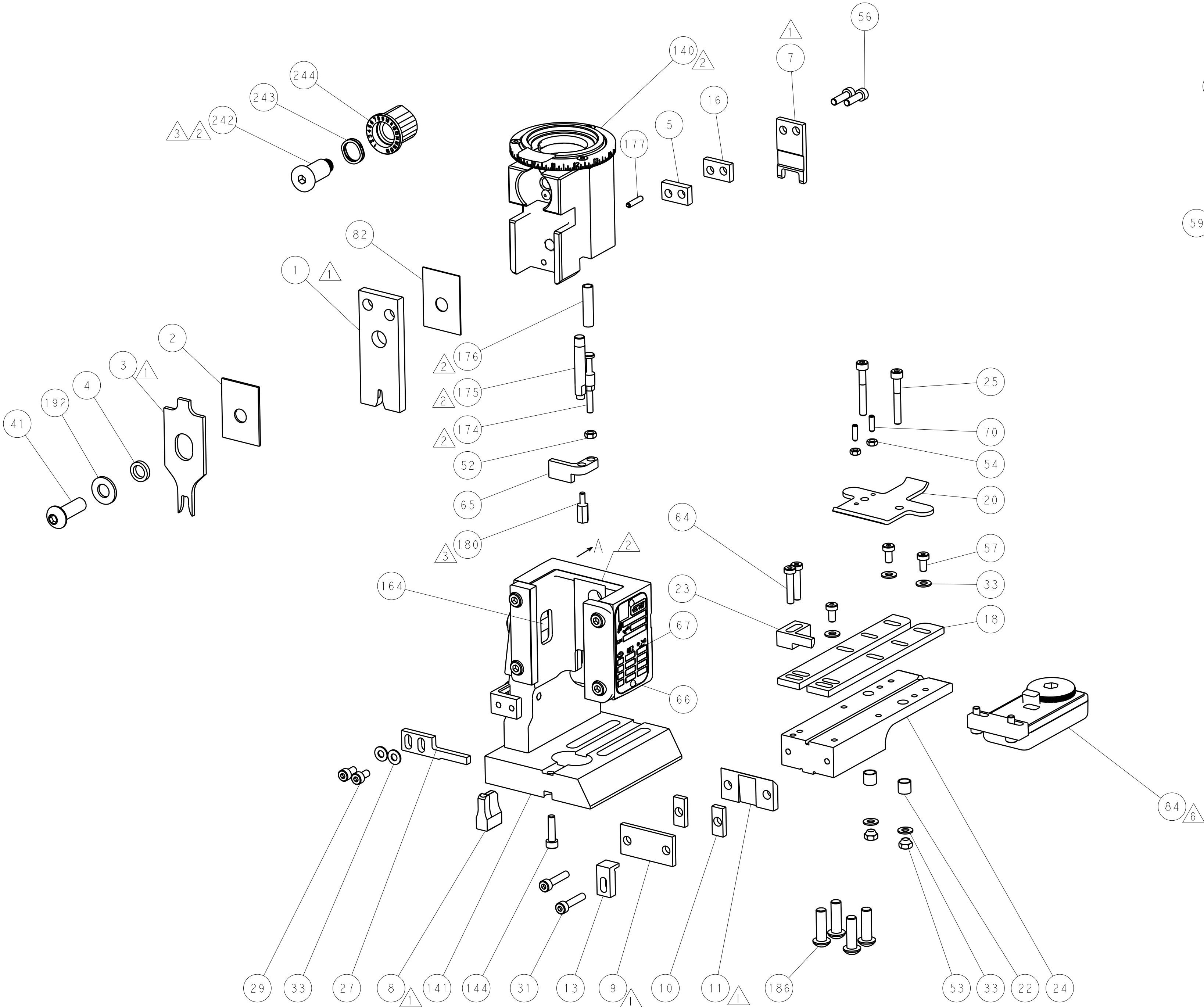
FEED SPRING SETTING POSITION



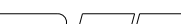
CAM POSITION



AIR FEED



PACIFIC VERSION
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										CHK		L. ZHANG	14JAN2014		
										APVD		T. ELBIN	14JAN2014		
DIMENSIONS:				TOLERANCES UNLESS OTHERWISE SPECIFIED:						NAME		Ocean End Feed Applicator -			
mm										PRODUCT SPEC					