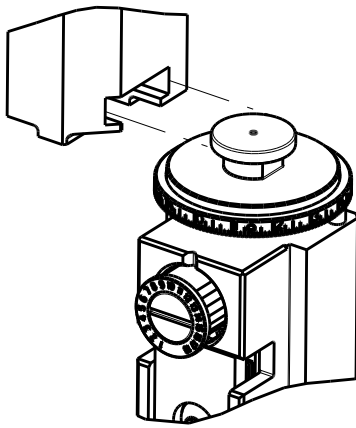


8		7	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150005-2	M	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150005-2	M	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150005-7	K	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	4.06 mm [.160]	F
INSUL	5.33 mm [.210]	OV
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: RINGTONGUE			
WIRE STRIP LENGTH 5.00-5.50 mm [.197-.217 IN]		 INSULATION DIAMETER RANGE Ø3.40-4.70 mm [.134-.185 IN]	
TERMINAL APPLICATION SPECIFICATION	114-18022	-	-
	-	-	-
TERMINALS APPLIED  			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
928927-2	928927-4		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
4.00mm2	2.86+/-0.05 [.113+/- .002]	7.0
3.50mm2	2.78+/-0.05 [.109+/- .002]	8.0
3.00mm2	2.70+/-0.05 [.106+/- .002]	8.9



- 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. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- 6 TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- 7 TERMINAL LUBRICANT IS RECOMMENDED.

*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)

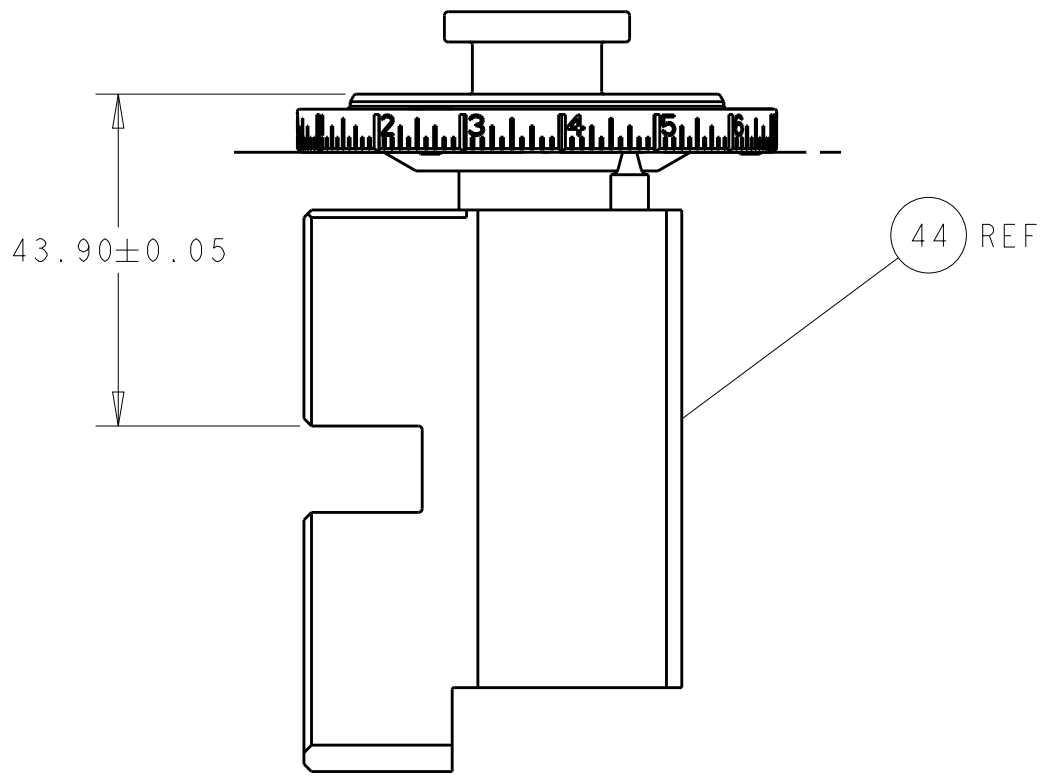
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		K		ECR-18-013051	16AUG2018	MP	GB		
		L		ECR-18-014381	11SEP2018	FL	TE		
		M		ECR-19-013113	21AUG2019	MZ	YY		

-	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	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	2063440-2	AIR FEED MODULE	238
-	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	1	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854	137
-	1	1	2119955-2	ASSY, LUBRICATOR, END FEED	84
-	1	1	455888-5	SPACER, CRIMPER	82
-	1	1	1803203-1	BLOCK, FRONT DEPRESSOR	74
-	1	1	2119791-9	DEPRESSOR, WIRE	73
-	2	2	2-18032-2	SCR, SET, FLT PNT, M3 X 10.0	72
-	1	1	1803607-2	DOCUMENTATION PACKAGE	71
-	1	1	2119791-5	DEPRESSOR, WIRE	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	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	60
-	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	2119792-2	PAWL, EF, AIR	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
-	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	1803292-4	DRAG	20
-	1	1	1-1901696-0	STRIP GUIDE, REAR	19
-	1	1	1-1901695-0	STRIP GUIDE, FRONT	18
-	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17
-	1	1	4-240641-6	SPACER	16
-	1	1	240644-1	PLATE, REAR SHEAR	11
-	-	-	-	-	10
-	1	1	7-690482-0	PLATE, FRONT SHEAR	9
1	2	1	1333223-5	ANVIL, COMBINATION	8
-	1	1	1-2217206-5	BLADE, SLUG	7
-	1	1	6-240641-0	SPACER	5
-	1	1	5-238011-4	BLOCK, CRIMPER SPACER	4
1	2	1	1803139-3	CRIMPER, INSULATION OVERLAP PREMIUM	3
-	1	1	1-455888-0	SPACER, CRIMPER	2
1	2	1	456414-9	CRIMPER, WIRE	1
-	77-72	-2	PART NO	DESCRIPTION	ITEM NO

THIS DRAWING IS A CONTROLLED DOCUMENT FOR THE ELECTRONICS CORPORATION IT IS SUBJECT TO CHANGE WITHOUT NOTICE. ANY CHANGES TO THIS DRAWING SHOULD BE CONTACTED FOR THE LATEST REVISION.		DWN Y. YIN 01FEB2012	 TE Connectivity Harrisburg, PA 17105-3608		
CHK G. BAILEY 01FEB2012		APVD S. XI 01FEB2012	NAME Ocean End Feed Applicator -		
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH ±			
		PRODUCT SPEC -			
MATERIAL -		APPLICATION SPEC -			
Customer Accessible Production Drawing		SIZE CASE CODE DRAWING NO A 00779 C=2150005			
SHEET 1 OF 4		RESTRICTED TO -			
REV M		SCALE 1:1		REV M	

SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

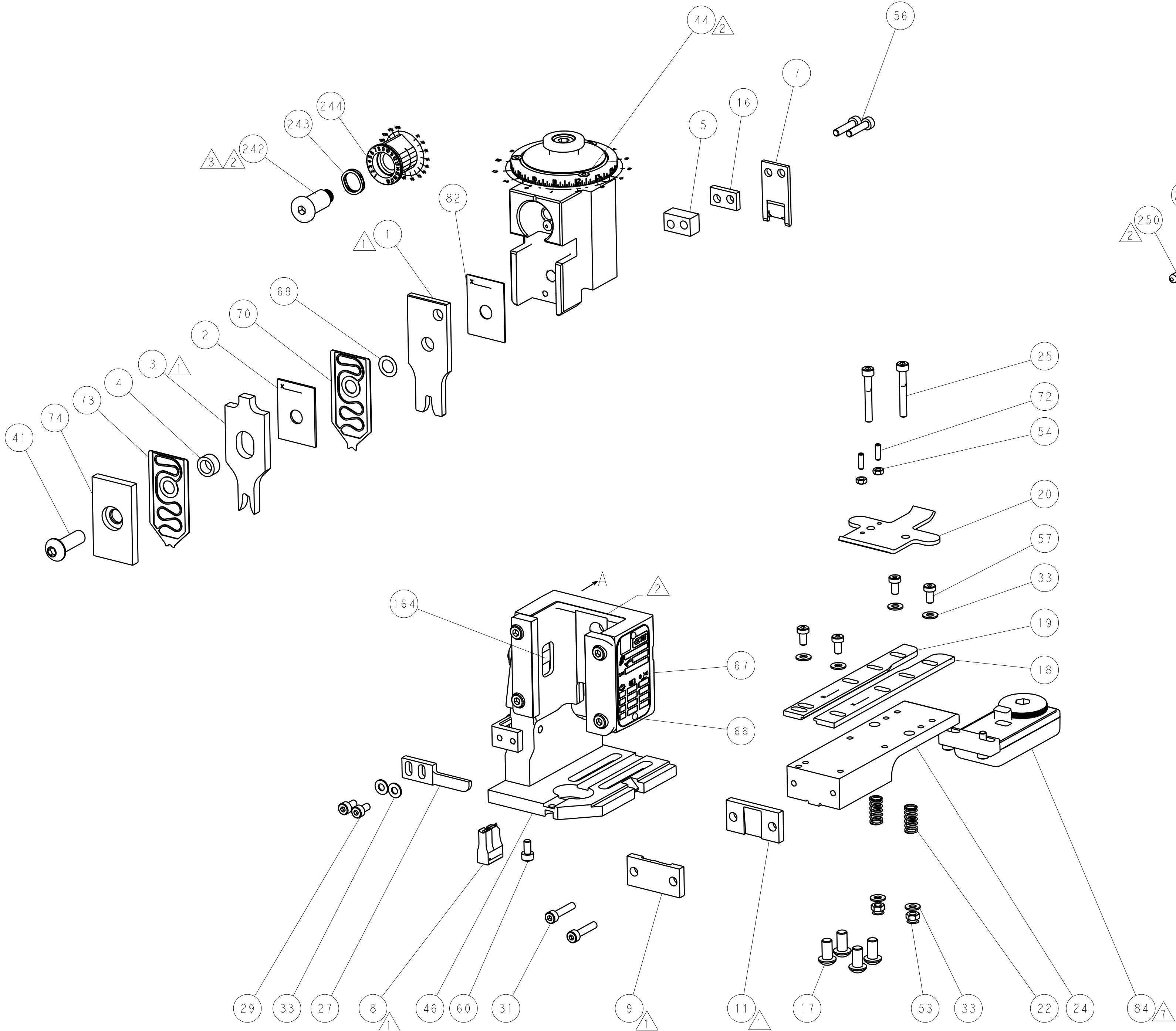
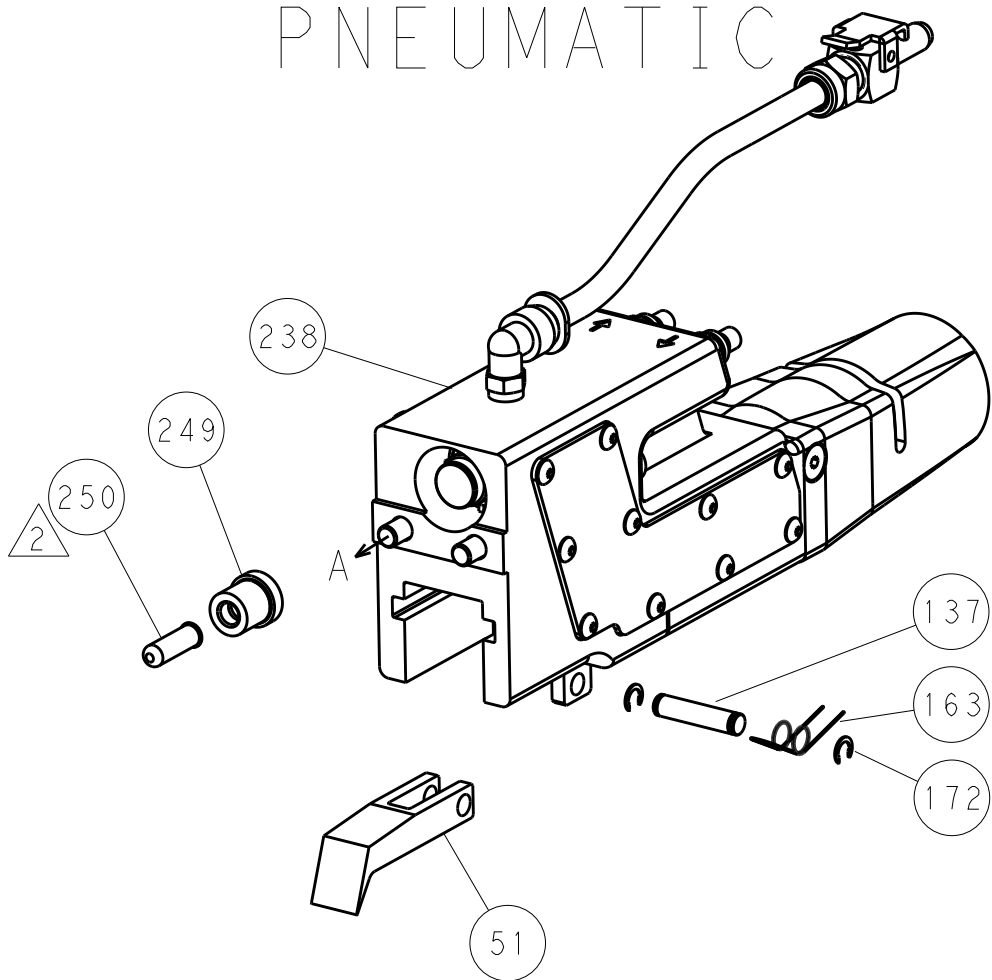
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		P	LTR	DESCRIPTION	DATE	DWN	APVD
A	66	-	-	SEE SHEET 1	-	-	-



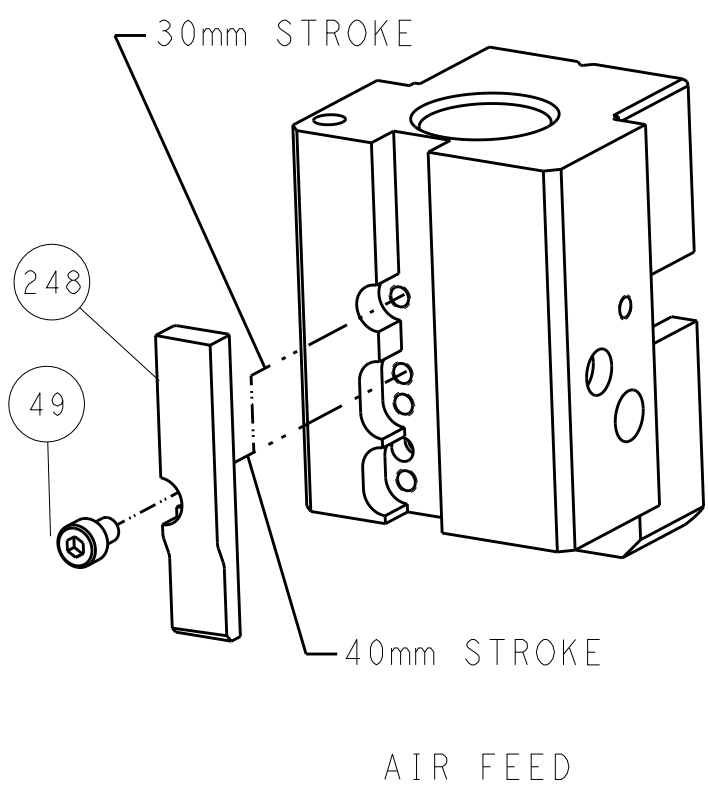
RAM SET-UP

FEED TYPE

PNEUMATIC



CAM POSITION



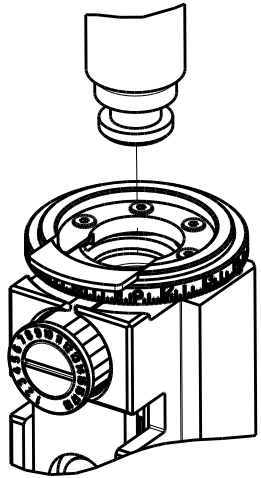
AIR FEED

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

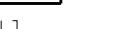
THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. ANY CHANGES TO THIS DRAWING MUST BE APPROVED BY THE DESIGNING ORGANIZATION. ANY CHANGES TO THIS DRAWING MUST BE APPROVED BY THE DESIGNING ORGANIZATION.				DWN Y. YIN 01FEB2012				TE Connectivity Harrisburg, PA 17105-3608			
CHK G. BAILEY 01FEB2012				APVD S. XI 01FEB2012				NAME Ocean End Feed Applicator			
DIMENSIONS: mm				TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.1 1 PLC ±.1 2 PLC ±.1 3 PLC ±.1 4 PLC ±.1 ANGLES ±.1 FINISH				PRODUCT SPEC			
MATERIAL				WEIGHT				APPLICATION SPEC			
Customer Accessible Production Drawing				SCALE 1:1				SHEET 2 OF 4			
								REV M			

8		7	
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20		20	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150005-2	M	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150005-7	K	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	4.06 mm [.160]	F
INSUL	5.33 mm [.210]	OV
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: RINGTONGUE			
WIRE STRIP LENGTH 5.00-5.50 mm [.197-.217 IN]			INSULATION DIAMETER RANGE Ø3.40-4.70 mm [.134-.185 IN]
TERMINAL APPLICATION SPECIFICATION	114-18022	-	-
	-	-	-
TERMINALS APPLIED  			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
928927-2	928927-4		

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING
4.00mm2		2.86+/-0.05 [.113+/- .002]		7.0
3.50mm2		2.78+/-0.05 [.109+/- .002]		8.0
3.00mm2		2.70+/-0.05 [.106+/- .002]		8.9



- 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.
- 5. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- TERMINAL LUBRICANT IS RECOMMENDED.

*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)

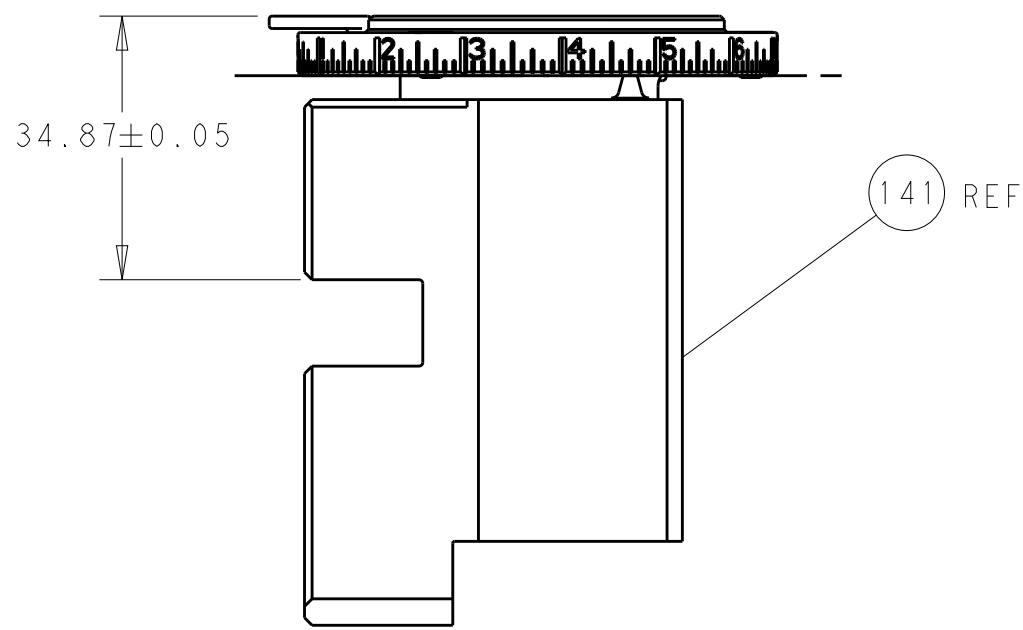
LOC	DIST	REVISIONS					
A	66	P	LTR	DESCRIPTION	DATE	DWN	APVD
		-	SEE SHEET 1	-	-	-	

-	1	2119640-1	PUSH ROD, AIR FEED	250
-	1	1803259-1	BUSHING, FLANGED	249
-	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	2063440-2	AIR FEED MODULE	238
-	4	2079383-9	SCR, BHSC, RoHS (M6 X 20)	186
-	2	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172
-	REF	994970-2	COUNTER, MAGNETIC	164
-	1	240638-1	SPRING, FEED FINGER	163
-	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	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854	137
-	1	2119955-2	ASSY, LUBRICATOR, END FEED	84
-	1	455888-5	SPACER, CRIMPER	82
-	1	1803203-1	BLOCK, FRONT DEPRESSOR	74
-	1	2119791-9	DEPRESSOR, WIRE	73
-	2	2-18032-2	SCR, SET, FLT PNT, M3 X 10.0	72
-	1	1803607-2	DOCUMENTATION PACKAGE	71
-	1	2119791-5	DEPRESSOR, WIRE	70
-	1	2119943-1	WASHER, SPACER	69
-	1	2119740-1	TAG, IDENTIFICATION	67
-	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	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	2119792-2	PAWL, EF, AIR	51
-	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	1803292-4	DRAG	20
-	1	1-1901696-0	STRIP GUIDE, REAR	19
-	1	1-1901695-0	STRIP GUIDE, FRONT	18
-	1	4-240641-6	SPACER	16
-	1	240644-1	PLATE, REAR SHEAR	11
-	-	-	-	10
-	1	7-690482-0	PLATE, FRONT SHEAR	9
-	1	1333223-5	ANVIL, COMBINATION	8
-	1	1-2217206-5	BLADE, SLUG	7
-	1	6-240641-0	SPACER	5
-	1	5-238011-4	BLOCK, CRIMPER SPACER	4
-	1	1803139-3	CRIMPER, INSULATION OVERLAP PREMIUM	3
-	1	1-455888-0	SPACER, CRIMPER	2
-	1	456414-9	CRIMPER, WIRE	1
-	77-22	PART NO	DESCRIPTION	ITEM NO

THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE AND SHOULD BE CONTACTED FOR THE LATEST REVISION.		DWN T. YIN CHK G. BAILEY APVD S. XI	01FEB2012 01FEB2012 01FEB2012	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 -		SIZE A1	
		Customer Accessible Production Drawing		SCALE 1:1	
		SHEET 3		REV M	

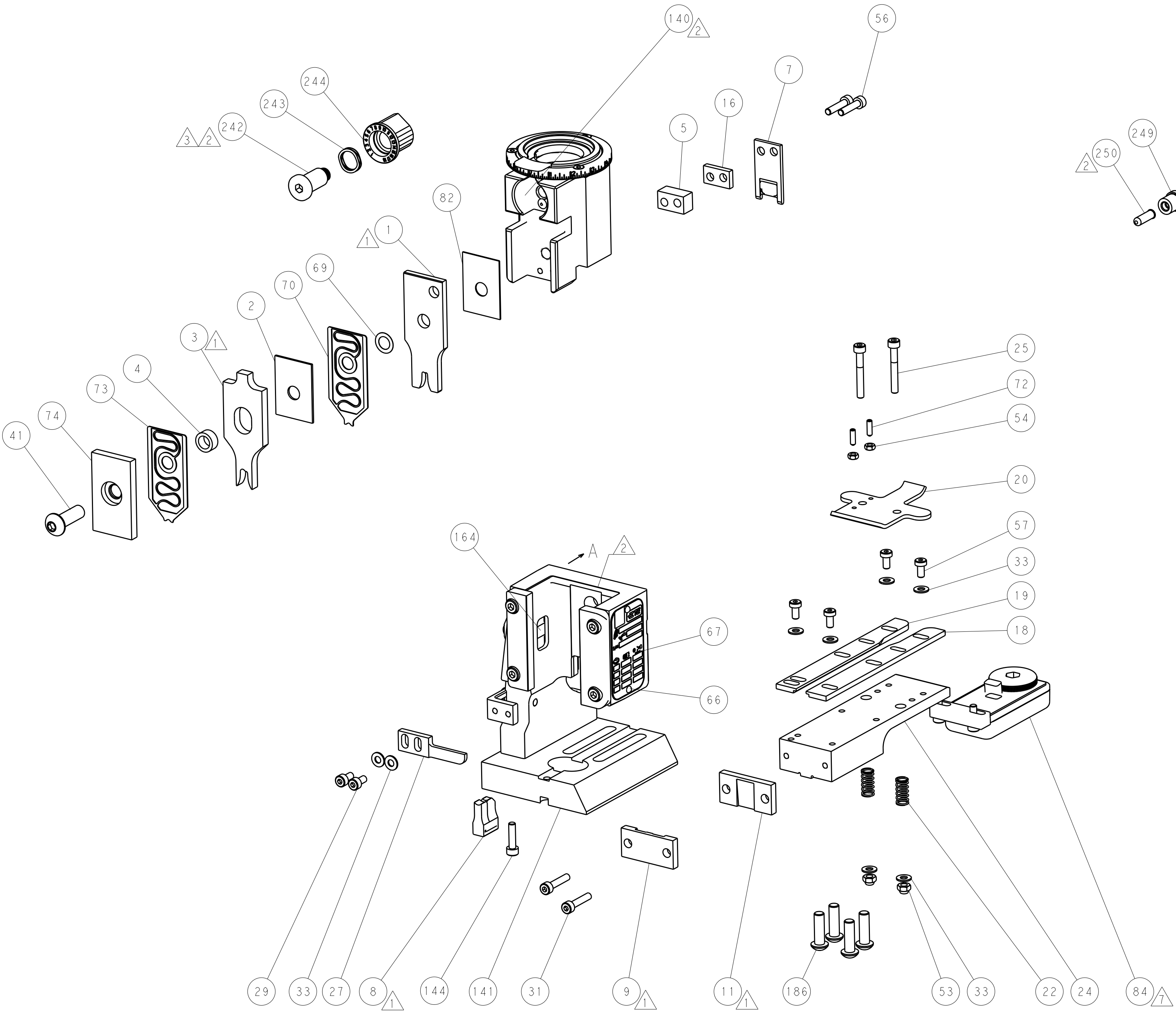
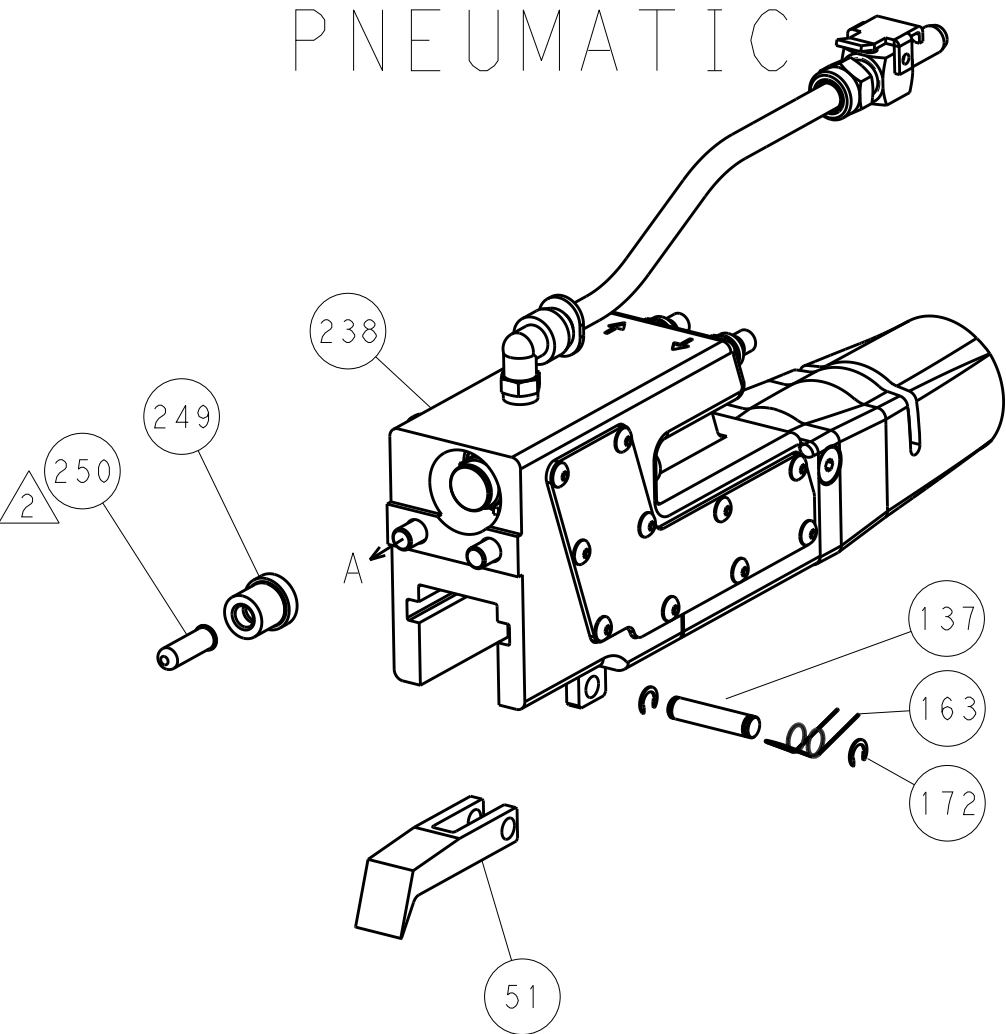
SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

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

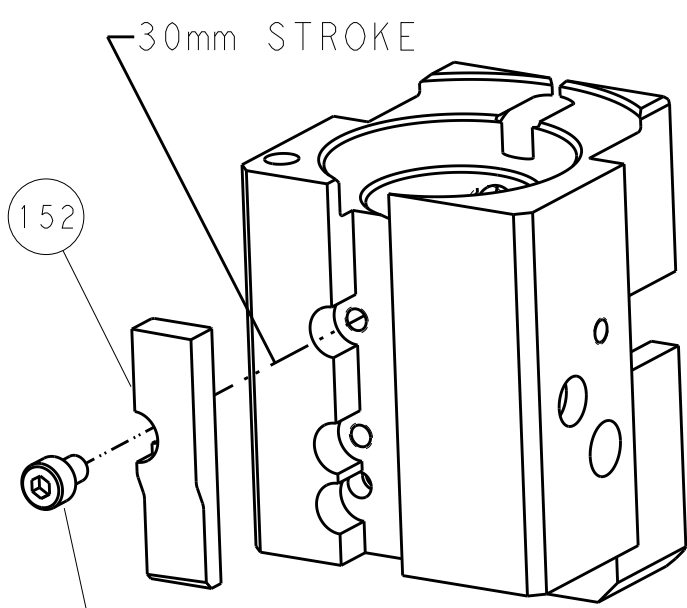


FEED TYPE

PNEUMATIC

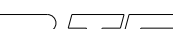


CAM POSITION



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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				CHK	G. BAILEY	01FEB2012				
				APVD	S. XI	01FEB2012	NAME			
				PRODUCT SPEC			Ocean End Feed Applicator			
				APPLICATION SPEC						
				WEIGHT			RESTRICTED TO			
				Customer Accessible Production Drawing			-			
				SCALE			1:1			
				SHEET			4 of 4			
				REV			M			