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20		20	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150039-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150039-2	C	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150039-7	A	CRIMP TOOLING KIT	-

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.03 mm [.080]	F
INSUL	3.30 mm [.130]	F
APPL INSTRUCTIONS 408-35043		

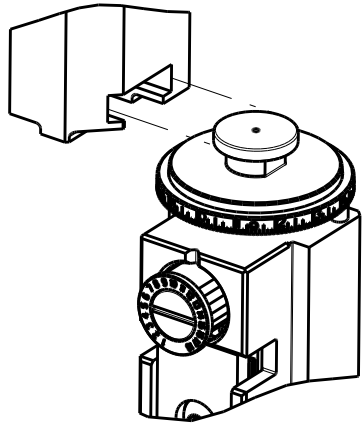
TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: 110 SERIES POSITIVE LOCK REC CONTACT			
WIRE STRIP LENGTH 3.50-4.50 mm [.138-.177 IN]		INSULATION DIAMETER RANGE Ø2.10-3.30 mm [.083-.130 IN]	
TERMINAL APPLICATION SPECIFICATION		-	
114-5120		-	
TERMINAL APPLICATION SPECIFICATION		-	
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
174777-1	174777-2	1337984-1	

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING	
16 AWG OR 1.25mm2		1.32+/-0.05 [.052+/- .002]		4.9	
18 AWG OR 0.75mm2		1.17+/-0.05 [.046+/- .002]		6.5	
20 AWG OR 0.50mm2		1.08+/-0.05 [.043+/- .002]		8.2	



- 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. APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 50.
- 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 PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
6.
- UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- 7
- THIS CRIMP PARAMETER IS PROVIDED TO MEET A CUSTOM AND UNIQUE CUSTOMER REQUIREMENT. IT HAS BEEN EVALUATED AND IS CONDITIONALLY SPECIFIED BY TE CONNECTIVITY. THIS CUSTOMIZED CRIMP PARAMETER IS NOT LISED AS AN APPROVED APPLICATION WITHIN A TE CONNECTIVITY APPLICATION SPECIFICATION; HOWEVER, IT HAS BEEN VALIEDTED ACCORDING TE CONNECTIVITY SPECIFICATIONS 109-18079(TEST GROUP 1) AND 114-18022. TE CONNECTIVITY EXPRESSLY DISCLAIMS ANY AND ALL WARRANTIES THAT THE PRODUCT WILL PERFORM SIMILARLY TO VALIDATED AND APPROVED APPLICATIONS, AS STATED WITHIN TE CONNECTIVITY APPLICATION SPECIFICATIONS, INCLUDING BUT NOT LIMITED TO IMPLIED WARRANTIES OF MERCHANTABILITY OR FITNESS FOR PARTICULAR PURPOSE. AS SUCH, IT IS HIGHLY RECOMMENDED THAT THE CUSTOMER PERFORM FURTHER DETAILED EVALUATION TO ASSESS PRODUCT PERFORMANCE IN THE SPECIFIC APPLICATION.
- 8
- THIS WIRE COMBINATION IS ONLY TO BE USED WITH NO CONNECTOR HOUSING.

ATLANTIC VERSION TERMINATOR
INTERFACE ADAPTER



TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: 110 SERIES POSITIVE LOCK REC CONTACT			
WIRE STRIP LENGTH 3.50-4.50 mm [.138-.177 IN]		INSULATION DIAMETER RANGE Ø2.10-3.30 mm [.083-.130 IN]	
TERMINAL APPLICATION SPECIFICATION	 	-	-
TERMINALS APPLIED 			
TE TERMINAL 174777-1	TE TERMINAL 174777-2	TE TERMINAL	TE TERMINAL

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING	
Ø 0.35+0.35mm2		1.15+/-0.05 [.045+/- .002]		7.0	

*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.

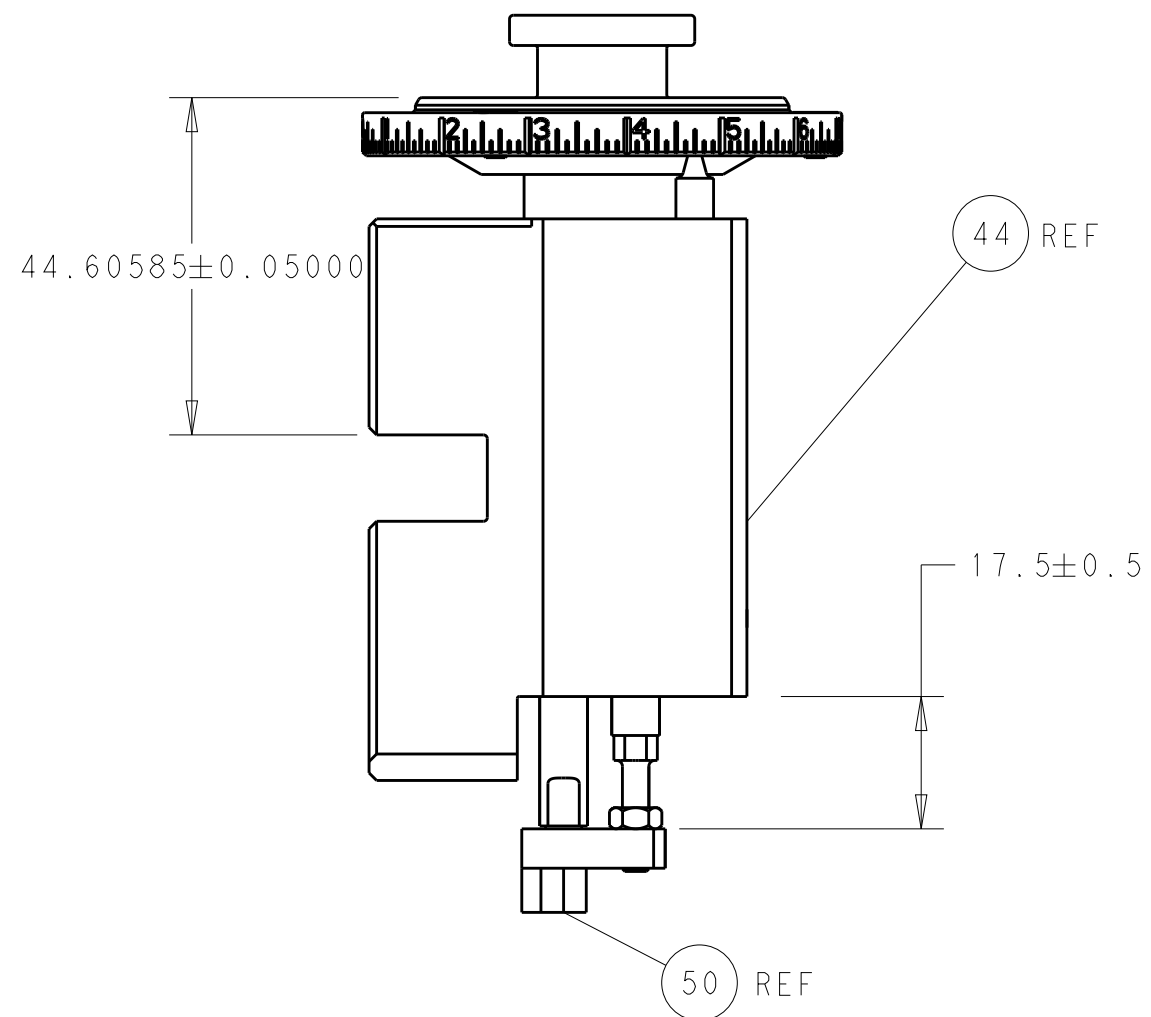
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

LOC	DIST	REVISIONS			
A	66	P	LTR	DESCRIPTION	DATE DWN APVD
		A2		ECR-15-000104	05JAN2015 MR TE
		A3		ECR-15-006459	24APR2015 YY UG
		B		ECR-19-005156	31MAR2019 TB CT
		C		ECR-19-005607	08APR2019 FZ CT

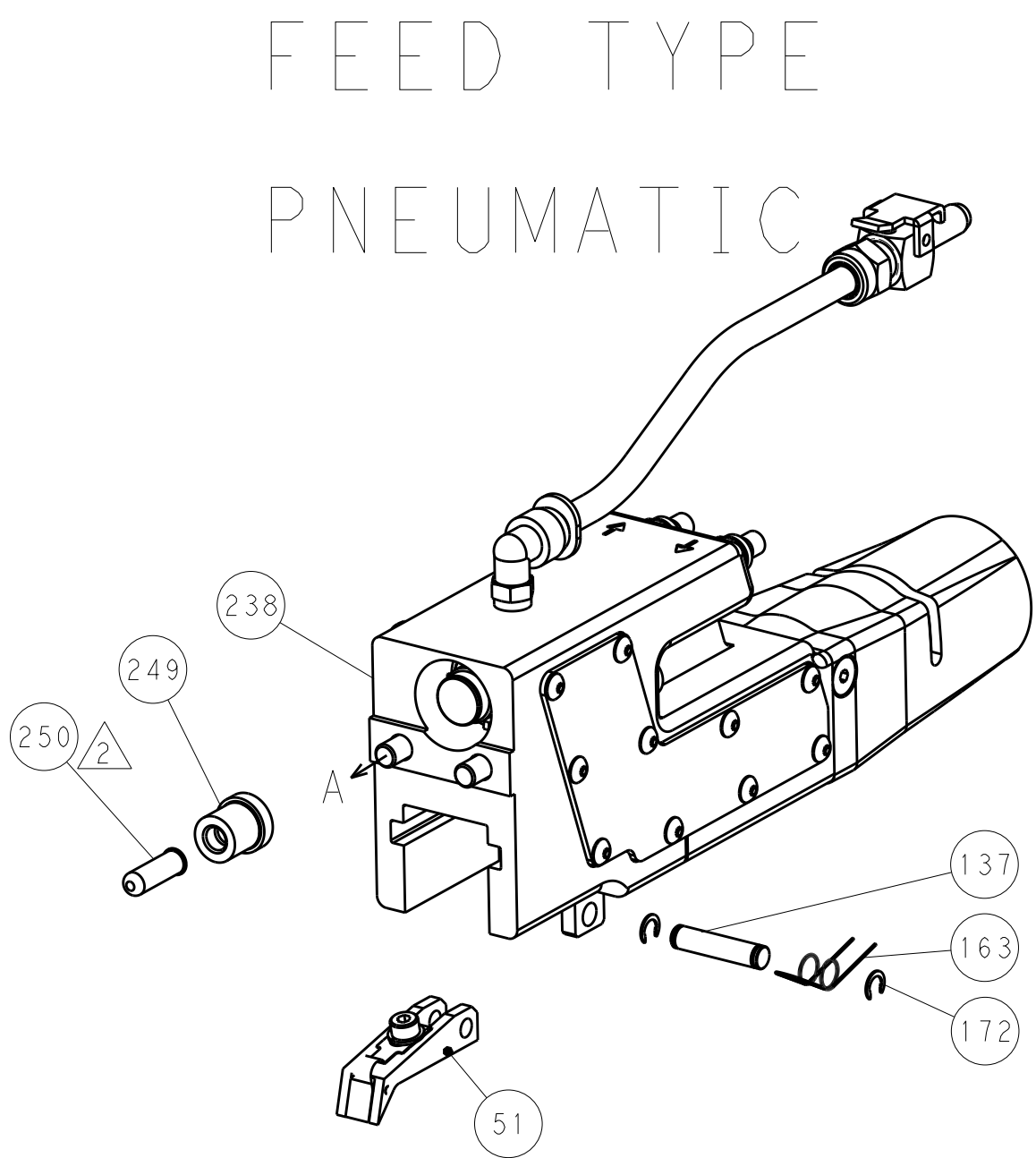
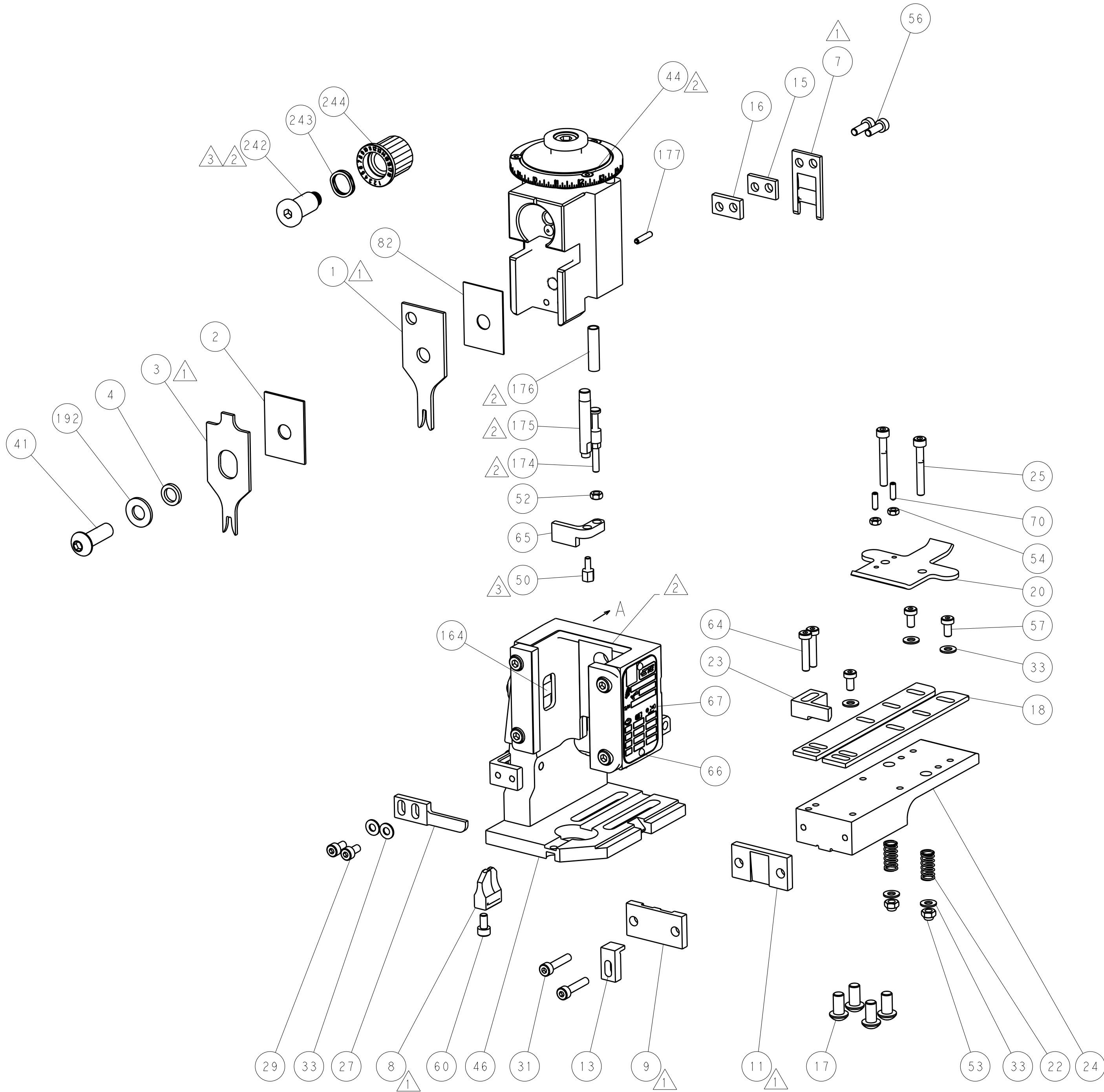
	-	1	1	2119640-1	PUSH ROD, AIR FEED	250
	-	1	1	1803259-1	BUSHING, FLANGED	249
	-	1	1	2119641-1	FEED CAM, AIR FEED	248
	-	1	1	2119082-4	CAM, SNAIL, INSULATION ADJUSTMENT	244
	-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
3	-	1	1	2119083-1	RETAINER, INSULATION DIAL	242
	-	1	1	2063440-1	AIR FEED 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
	-	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	455888-5	SPACER, CRIMPER	82
	-	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
	-	2	2	2168400-5	SHCS, LOW HEAD, RoHS, M4 X 20	64
	-	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	60
	-	3	3	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	1	2031314-1	FEED FINGER SUBASSEMBLY	51
3	-	1	1	1752354-8	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
	-	7	7	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	1-1752371-2	PLATE, STRIP GUIDE	24
	-	1	1	240825-7	PLATE, STRIP HOLD DOWN	23
	-	2	2	2-22281-3	SPRING, COMPRESSION	22
	-	1	1	1803292-4	DRAG	20
	-	2	2	1901259-5	GUIDE, LOWER STRIP	18
	-	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17
	-	1	1	3-240641-0	SPACER	16
	-	1	1	240641-2	SPACER	15
	-	1	1	1752360-1	SPACER,HOLD-DOWN	13
1	-	1	1	240644-5	PLATE, REAR SHEAR	11
	-	-	-	-	-	10
1	-	1	1	6-690482-0	PLATE, FRONT SHEAR	9
1	1	2	1	1-1333216-2	ANVIL, COMBINATION	8
1	-	1	1	690474-5	BLADE, SLUG	7
	-	-	-	-	-	5
	-	1	1	238011-7	BLOCK, CRIMPER SPACER	4
1	1	2	1	2119582-1	CRIMPER, INSULATION F PREMIUM	3
	-	1	1	1-455888-0	SPACER, CRIMPER	2
1	1	2	1	3-456405-4	CRIMPER, WIRE PREMIUM	1
	-77-	72	-2	PART NO	DESCRIPTION	ITEM NO

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				CHK	03JUL2012		
				APVD	03JUL2012	NAME	
DIMENSIONS:				PRODUCT SPEC		Ocean End Feed Applicator	
mm				APPLICATION SPEC			
				WEIGHT		SIZE	
MATERIAL				FINISH		CAGE CODE	
-				-		DRAWING NO	
				Customer Accessible Production Drawing		RESTRICTED TO	
				SCALE		SHEET	
				1:1		1 OF 4	
				REV		C	

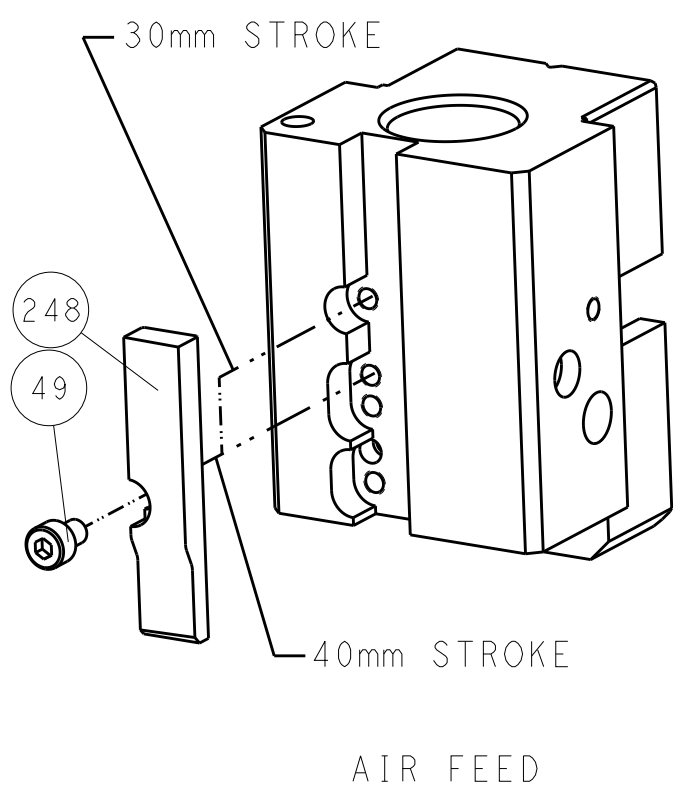
LOC	DIST	REVISIONS					
		P	LTR	DESCRIPTION	DATE	DWN	APVD
A	66	-	-	SEE SHEET 1	-	-	-



RAM AND HOLDDOWN SET-UP



CAM POSITION

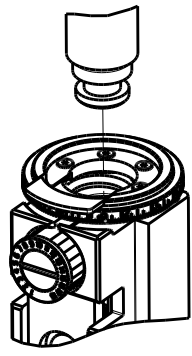


ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

100% DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION IT IS SUBJECT TO CHANGE WITHOUT NOTICE AND THE CONTROLLING ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST REVISION.		DWN L. ZHANG 03JUL2012	TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm		CHK L. ZHANG 03JUL2012	NAME Ocean End Feed Applicator	
TOLERANCES UNLESS OTHERWISE SPECIFIED:		APVD S. XI 03JUL2012	SIZE CAGE CODE DRAWING NO	
0 PLC ±.0005		PRODUCT SPEC	RESTRICTED TO	
1 PLC ±.0005		APPLICATION SPEC	A1 00779 ©=2150039	
2 PLC ±.0005		WEIGHT	Customer Accessible Production Drawing	
3 PLC ±.0005		FINISH	SCALE 1:1 SHEET 2 OF 4 REV C	
4 PLC ±.0005				

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20		20	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150039-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150039-7	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 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: 110 SERIES POSITIVE LOCK REC CONTACT			
WIRE STRIP LENGTH 3.50-4.50 mm [.138-.177 IN]		INSULATION DIAMETER RANGE Ø2.10-3.30 mm [.083-.130 IN]	
TERMINAL APPLICATION SPECIFICATION		TERMINAL APPLICATION SPECIFICATION	
114-5120		-	
-		-	
TERMINALS APPLIED 			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
174777-1	174777-2	1337984-1	

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: 110 SERIES POSITIVE LOCK REC CONTACT			
WIRE STRIP LENGTH 3.50-4.50 mm [.138-.177 IN]		INSULATION DIAMETER RANGE Ø2.10-3.30 mm [.083-.130 IN]	
TERMINAL APPLICATION SPECIFICATION			-
TERMINALS APPLIED			-
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
174777-1	174777-2		

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING
16 AWG OR 1.25mm2		1.32+/-0.05 [.052+/- .002]		4.9
18 AWG OR 0.75mm2		1.17+/-0.05 [.046+/- .002]		6.5
20 AWG OR 0.50mm2		1.08+/-0.05 [.043+/- .002]		8.2

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING
	Ø 0.35+0.35mm2	1.15+/-0.05 [.045+/- .002]		7.0



- 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.
APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 50.
- 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.
- THIS CRIMP PARAMETER IS PROVIDED TO MEET A CUSTOM AND UNIQUE CUSTOMER REQUIREMENT. IT HAS BEEN EVALUATED AND IS CONDITIONALLY SPECIFIED BY TE CONNECTIVITY. THIS CUSTOMIZED CRIMP PARAMETER IS NOT LISED AS AN APPROVED APPLICATION WITHIN A TE CONNECTIVITY APPLICATION SPECIFICATION; HOWEVER, IT HAS BEEN VALIDETED ACCORDING TE CONNECTIVITY SPECIFICATIONS 109-18079(TEST GROUP 1) AND 114-18022. TE CONNECTIVITY EXPRESSLY DISCLAIMS ANY AND ALL WARRANTIES THAT THE PRODUCT WILL PERFORM SIMILARLY TO VALIDATED AND APPROVED APPLICATIONS, AS STATED WITHIN TE CONNECTIVITY APPLICATION SPECIFICATIONS, INCLUDING BUT NOT LIMITED TO IMPLIED WARRANTIES OF MERCHANTABILITY OR FITNESS FOR PARTICULAR PURPOSE. AS SUCH, IT IS HIGHLY RECOMMENDED THAT THE CUSTOMER PERFORM FURTHER DETAILED EVALUATION TO ASSESS PRODUCT PERFORMANCE IN THE SPECIFIC APPLICATION.
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*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)

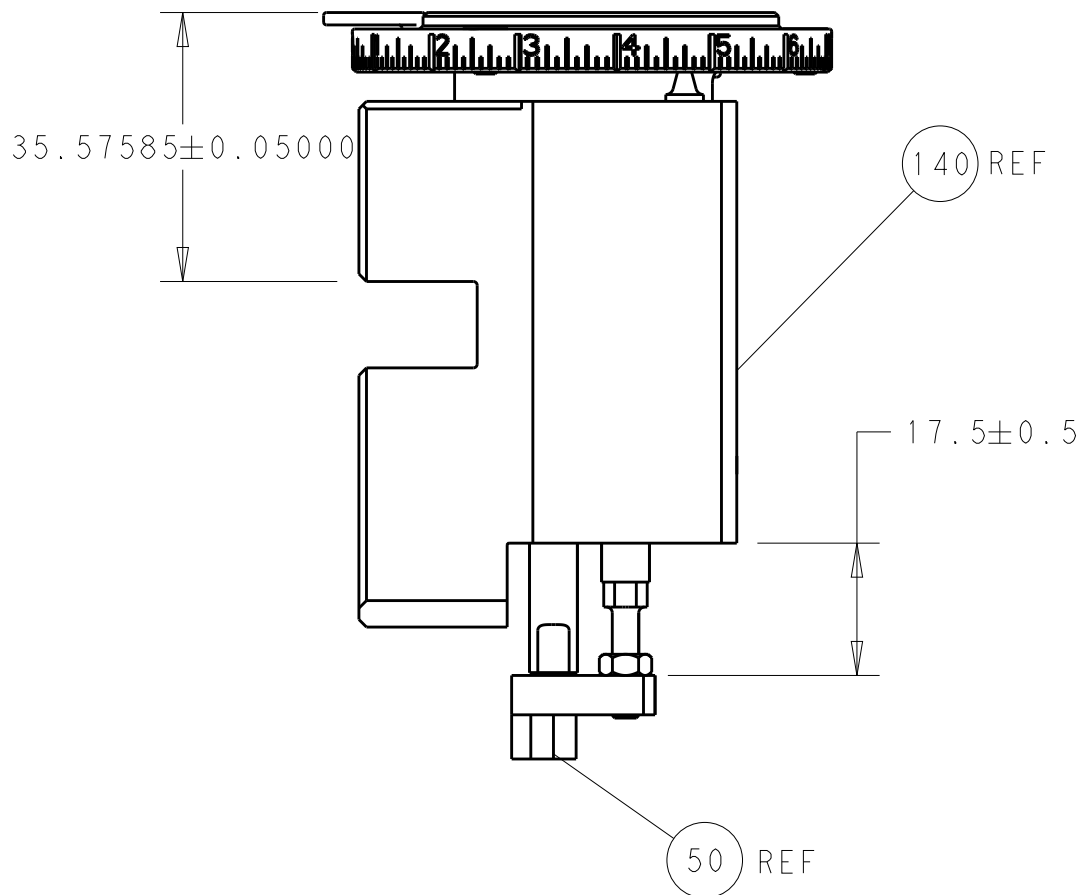
LOC		DIST		REVISIONS			
A		66		P	LTR	DESCRIPTION	DATE
					-	SEE SHEET 1	-

-	1	2119640-1	PUSH ROD, AIR FEED	250
-	1	1803259-1	BUSHING, FLANGED	249
-	1	2119082-4	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	2063440-1	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
-	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	455888-5	SPACER, CRIMPER	82
-	1	1803607-2	DOCUMENTATION PACKAGE	71
-	2	2-18032-2	SCR, SET, FLT PNT, M3 X 10.0	70
-	1	2119740-1	TAG,IDENTIFICATION	67
-	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	1	1901681-1	HOLDDOWN, TERMINAL	65
-	2	2168400-5	SHCS, LOW HEAD, RoHS, M4 X 20	64
-	3	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57
-	2	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	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	2031314-1	FEED FINGER SUBASSEMBLY	51
	1	1752354-8	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
-	7	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	1-1752371-2	PLATE, STRIP GUIDE	24
-	1	240825-7	PLATE, STRIP HOLD DOWN	23
-	2	2-22281-3	SPRING, COMPRESSION	22
-	1	1803292-4	DRAG	20
-	2	1901259-5	GUIDE, LOWER STRIP	18
-	1	3-240641-0	SPACER	16
-	1	240641-2	SPACER	15
-	1	1752360-1	SPACER,HOLD-DOWN	13
	1	240644-5	PLATE, REAR SHEAR	11
-	-	-	-	10
	1	6-690482-0	PLATE, FRONT SHEAR	9
	1	1-1333216-2	ANVIL, COMBINATION	8
	1	690474-5	BLADE, SLUG	7
-	-	-	-	5
-	1	238011-7	BLOCK, CRIMPER SPACER	4
	1	2119582-1	CRIMPER, INSULATION F PREMIUM	3
-	1	1-455888-0	SPACER, CRIMPER	2
	1	3-456405-4	CRIMPER, WIRE PREMIUM	1
-	77-22	PART NO	DESCRIPTION	ITEM NO

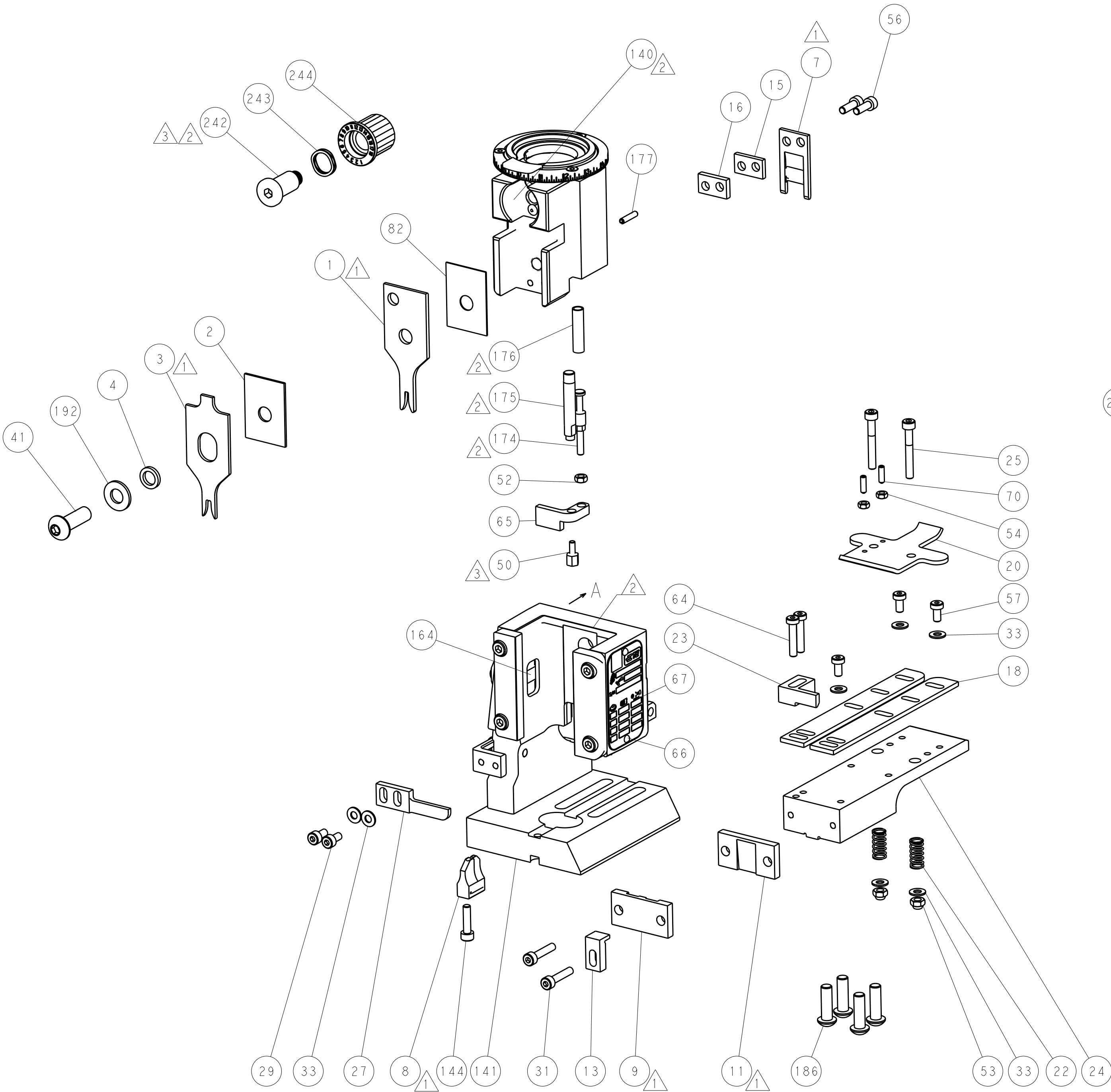
THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE WITHOUT NOTICE AND WITHOUT NOTICE TO THE USER. IT IS SUBJECT TO CHANGE WITHOUT NOTICE AND WITHOUT NOTICE TO THE USER. IT IS SUBJECT TO CHANGE WITHOUT NOTICE AND WITHOUT NOTICE TO THE USER.		DWN L.ZHANG CHK L.ZHANG APVD S.XI	03JUL2012 03JUL2012 03JUL2012	TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		NAME Ocean End Feed Applicator	
		PRODUCT SPEC APPLICATION SPEC		SIZE 00779	
MATERIAL -		FINISH -		SCALE 1:1	
Customer Accessible Production Drawing		SHEET 3 OF 4		REV C	

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

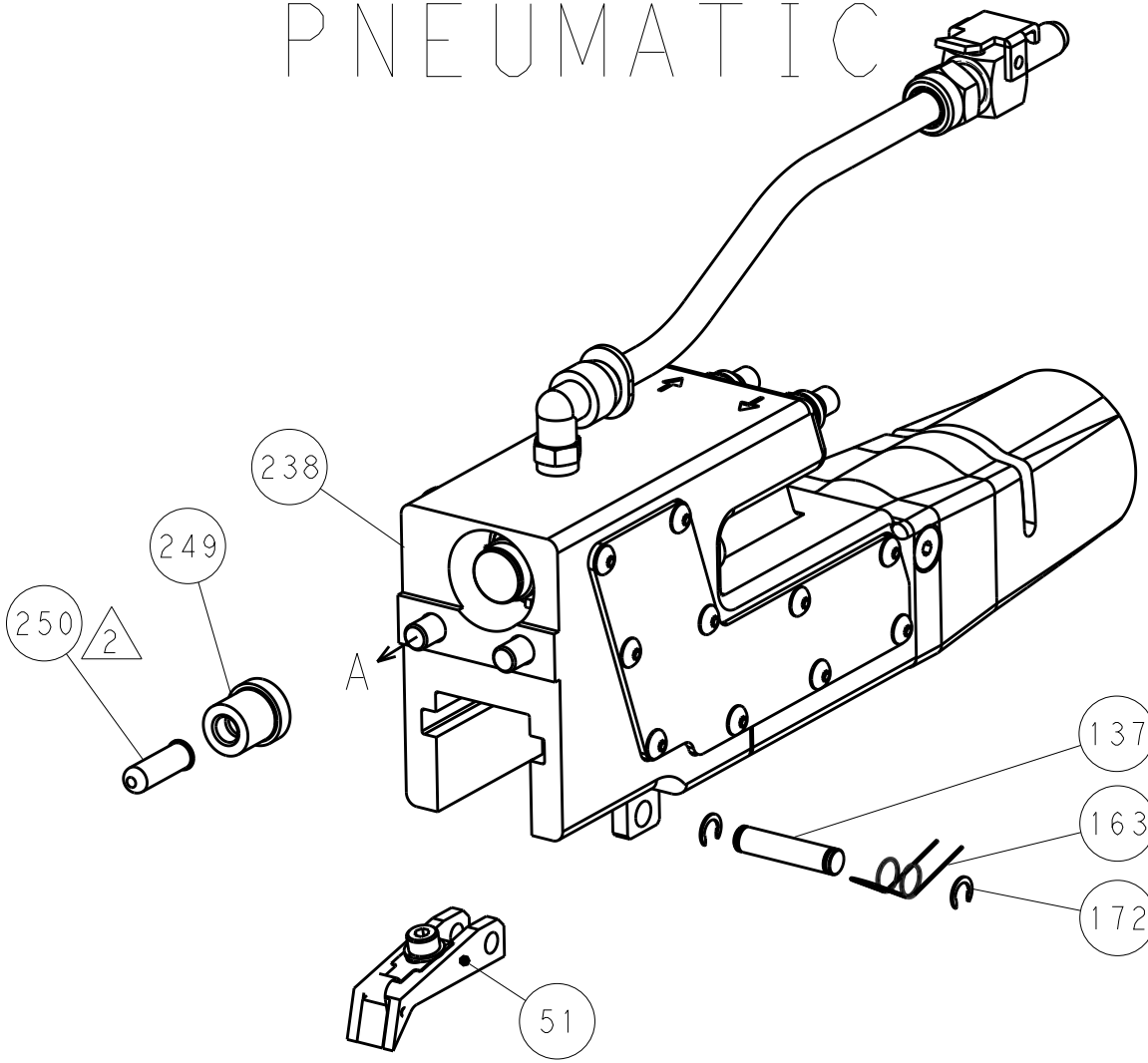
LOC	DIST	REVISIONS				
		P	LTR	DESCRIPTION	DATE	DWN
A	66	-	-	SEE SHEET 1	-	-



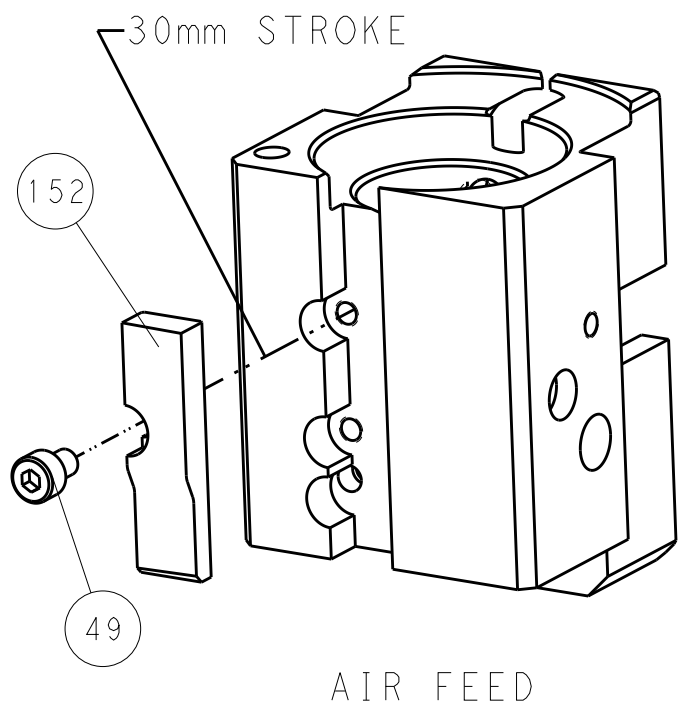
RAM AND HOLDDOWN SET-UP



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)

100% DIMENSIONAL CONTROL REQUIRED FOR THIS ELECTRONIC CONNECTION IT IS SUBJECT TO DIMENSIONAL CONTROL AND EXISTING ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST POSITION.		DWN L. ZHANG 03JUL2012	STE TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm		CHK L. ZHANG 03JUL2012	NAME Ocean End Feed Applicator	
TOLERANCES UNLESS OTHERWISE SPECIFIED:		APVD S. XI 03JUL2012	SIZE CAGE CODE DRAWING NO	
0 PLC 1 PLC 2 PLC 3 PLC 4 PLC ANGLES FINISH		PRODUCT SPEC APPLICATION SPEC WEIGHT Customer Accessible Production Drawing	A1 00779 C=2150039	
MATERIAL -		SCALE 1:1	SHEET 4 OF 4	
		REV C		