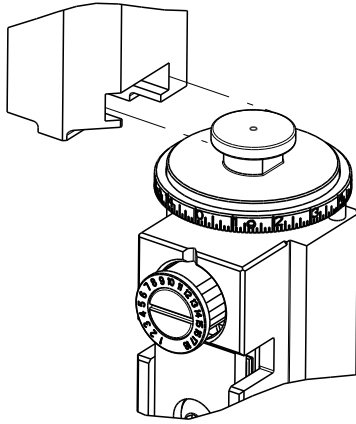
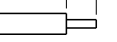


8		7	
THIS DRAWING IS UNPUBLISHED.		RELEASED FOR PUBLICATION	
20		20	
© COPYRIGHT 20 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.			
PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150074-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2150074-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150074-1	B	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2150074-2	B	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150074-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR
INTERFACE ADAPTER



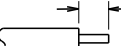
APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.29 mm [.090]	F
INSUL	3.56 mm [.140]	F
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: RING			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
4.39-5.16 mm [.173-.203 IN]		Ø2.03-2.79 mm [.080-.110 IN]	
TERMINAL APPLICATION SPECIFICATION	 114-2084	-	-
	-	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
42037	42037-1	42037-2	42037-8
42037-9	42036-1	42036-2	63797-1
150539	150541	150605-1	1742780-1

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING	
18 AWG		1.65+/-0.05 [.065+/-0.002]		5.5	
20 AWG		1.55+/-0.05 [.061+/-0.002]		6.6	
2 x 0.22mm2		1.52+/-0.05 [.060+/-0.002]		6.9	
22 AWG		1.50+/-0.05 [.059+/-0.002]		7.1	



- 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.
- 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 LISTED AS AN APPROVED APPLICATION WITHIN A TE CONNECTIVITY APPLICATION SPECIFICATION. **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.

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: RING			
WIRE STRIP LENGTH 4.39-5.16 mm [.173-.203 IN]			INSULATION DIAMETER RANGE Ø1.52-2.79 mm [.060-.110 IN]
TERMINAL APPLICATION SPECIFICATION 		114-2084	
TERMINALS APPLIED			
TE TERMINAL 170225-1	TE TERMINAL 170225-2	TE TERMINAL 1-170225-2	TE TERMINAL

*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.

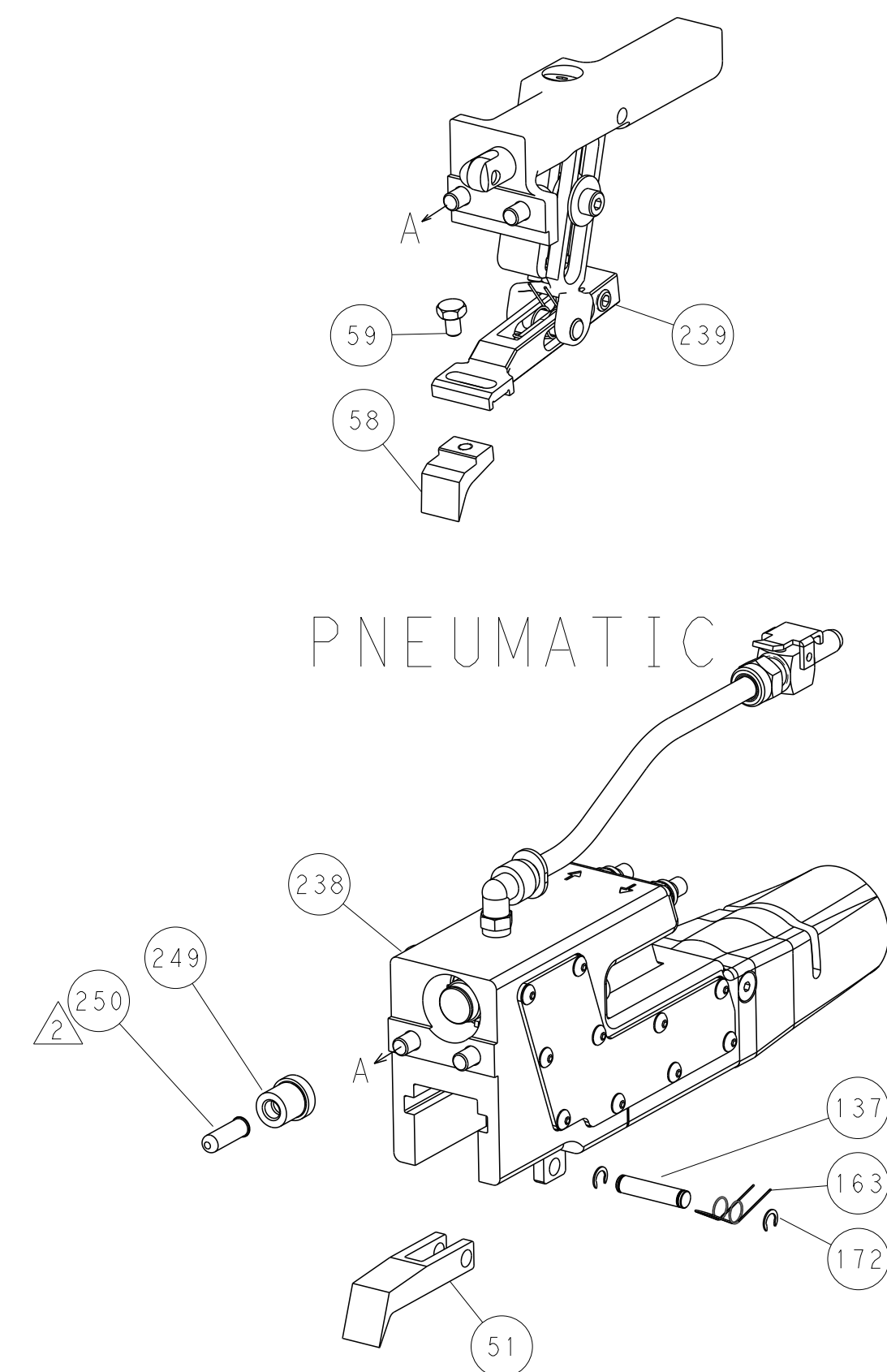
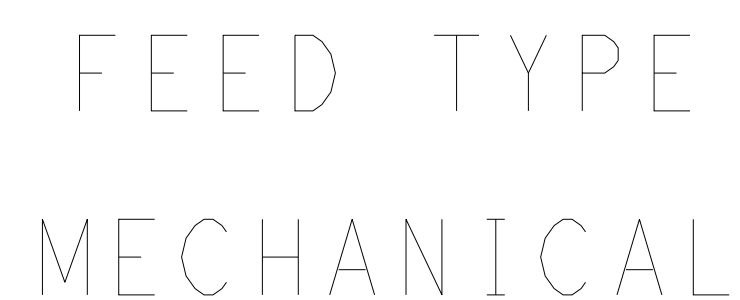
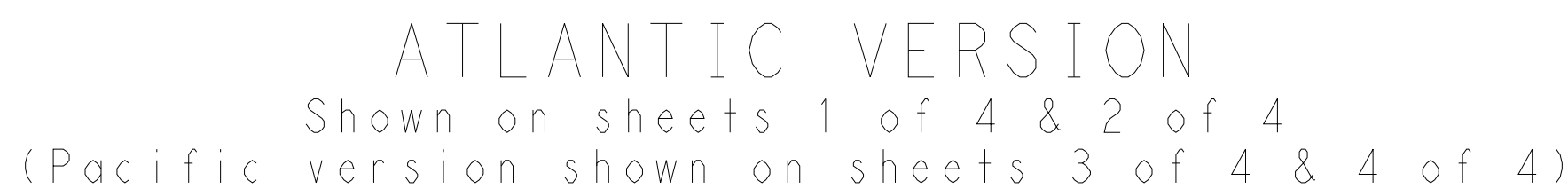
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

2		1								
LOC	DIST	REVISIONS								
A	66	P	LTR	DESCRIPTION				DATE	DWN	APVD
			A	RELEASED				25NOV2013	LG	TE
			A1	ADDED TERMINALS, ECR-15-010820				23JUL2015	JH	LZ
			A2	ECR-17-013521				14SEP2017	JAH	JDG
			B	ECR-18-015548				30SEP2018	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	2119082-9	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	
	-	1	1	1	1	455888-4	SPACER, CRIMPER	82	
	-	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	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	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	1803292-4	DRAG	20	
	-	1	1	1	1	1901696-9	STRIP GUIDE, REAR	19	
	-	1	1	1	1	1901695-9	STRIP GUIDE, FRONT	18	
	-	4	4	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17	
1	-	1	1	1	1	240644-9	PLATE, REAR SHEAR	11	
	-	-	-	-	-	-	-	10	
1	-	1	1	1	1	5-690482-7	PLATE, FRONT SHEAR	9	
1	1	2	2	1	1	2-1333217-6	ANVIL, EF .090	8	
1	-	1	1	1	1	2217206-4	BLADE, SLUG	7	
	-	-	-	-	-	-	-	6	
	-	1	1	1	1	2-240641-4	SPACER	5	
	-	1	1	1	1	238011-2	BLOCK, CRIMPER SPACER	4	
1	1	2	2	1	1	1803017-9	CRIMPER, INSULATION F	3	
	-	1	1	1	1	455888-7	SPACER, CRIMPER	2	
1	1	2	2	1	1	1-456406-6	CRIMPER, WIRE PREMIUM	1	
	-	77	72	71	2	-1	PART NO	DESCRIPTION	ITEM NO

THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. THE CUSTOMER SHALL BE CONTACTED FOR THE LATEST EDITION.				DWN L.GROSS 16OCT2013		 TE Connectivity Harrisburg, PA 17105-3608	
				CHK T.ELBIN 16OCT2013			
				APVD M.CLIFFORD 16OCT2013			
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		NAME		Ocean End Feed Applicator	
mm		0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH ±		PRODUCT SPEC		-	
				APPLICATION SPEC		-	
MATERIAL				WEIGHT		-	
-		-		-		-	
				SIZE		CAGE CODE	
				A 00779		DRAWING NO	
				C=2150074		RESTRICTED TO	
				-		-	
Customer Accessible Production Drawing						SCALE 1:1	
						SHEET 1 OF 4	
						REV B	

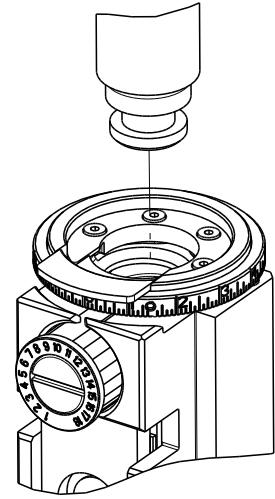
SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION



(THIS DRAWING IS A CONTROLLED DOCUMENT AND ALL ELECTRICAL INFORMATION SHOULD BE CHECKED FOR THE LATEST VERSION.)															DWG GROSS 160C12013		 TE Connectivity Harrisburg PA 17105-3608			
															CHG TELBIN 160C12013					
DIMENSIONS: mm			TOLERANCES UNLESS OTHERWISE SPECIFIED:												NAME					
			APPROVED BY M CLIFFORD 160C12013												Ocean End Feed Applicator -					
			PRODUCT SPEC																	
			APPLICATION SPEC																	
MATERIAL			WEIGHT												SIZE CAGE CODE DRAWING NO		RESTRICTED TO			
-			-												A 00779 C=2150074		-			
Customer Accessible Production Drawing															SCALE 1:1		SHEET 2 OF 4		REV B	

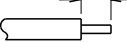
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20		20	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150074-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2150074-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150074-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.29 mm [.090]	F
INSUL	3.56 mm [.140]	F
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: RING			
WIRE STRIP LENGTH 4.39-5.16 mm [.173-.203 IN]		INSULATION DIAMETER RANGE Ø2.03-2.79 mm [.080-.110 IN]	
TERMINAL APPLICATION SPECIFICATION	114-2084	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
42037	42037-1	42037-2	42037-8
42037-9	42036-1	42036-2	63797-1
150539	150541	150605-1	1742780-1

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: RING			
WIRE STRIP LENGTH 4.39-5.16 mm [.173-.203 IN]			INSULATION DIAMETER RANGE Ø1.52-2.79 mm [.060-.110 IN]
TERMINAL APPLICATION SPECIFICATION		114-2084	
			
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
170225-1	170225-2	1-170225-2	

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING
18 AWG		1.65+/-0.05 [.065+/-0.002]		5.5
20 AWG		1.55+/-0.05 [.061+/-0.002]		6.6
2 x 0.22mm2		1.52+/-0.05 [.060+/-0.002]		6.9
22 AWG		1.50+/-0.05 [.059+/-0.002]		7.1

*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.



- 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 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 LISTED AS AN APPROVED APPLICATION WITHIN A TE CONNECTIVITY APPLICATION SPECIFICATION. **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.

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

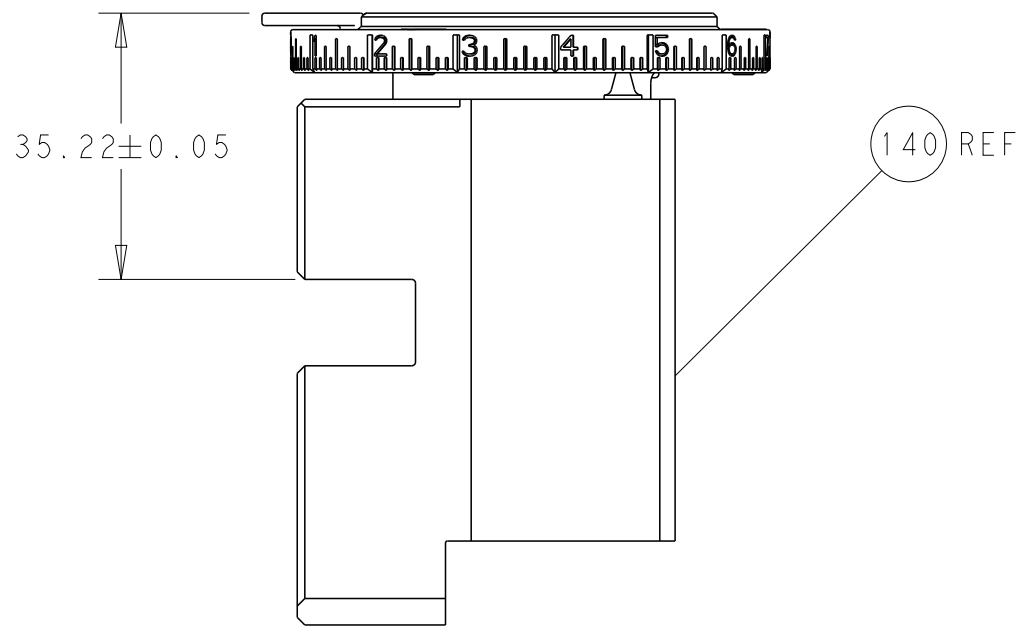
	-	1	1	2119640-1	PUSH ROD, AIR FEED	250
	-	1	1	1803259-1	BUSHING, FLANGED	249
	-	1	1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244
3	-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
	-	1	1	2119083-1	RETAINER, INSULATION DIAL	242
	-	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
	-	1	-	2063440-1	AIR 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	171
	-	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	455888-4	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	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	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	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	1901696-9	STRIP GUIDE, REAR	19
	-	1	1	1901695-9	STRIP GUIDE, FRONT	18
1	-	1	1	240644-9	PLATE, REAR SHEAR	11
	-	-	-	-	-	10
1	-	1	1	5-690482-7	PLATE, FRONT SHEAR	9
	1	1	1	2-1333217-6	ANVIL, EF .090	8
1	-	1	1	2217206-4	BLADE, SLUG	7
	-	-	-	-	-	6
	-	1	1	2-240641-4	SPACER	5
	-	1	1	238011-2	BLOCK, CRIMPER SPACER	4
1	1	1	1	1803017-9	CRIMPER, INSULATION F	3
	-	1	1	455888-7	SPACER, CRIMPER	2
1	1	1	1	1-456406-6	CRIMPER, WIRE PREMIUM	1
	- 77-22-21			PART NO	DESCRIPTION	ITEM NO

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

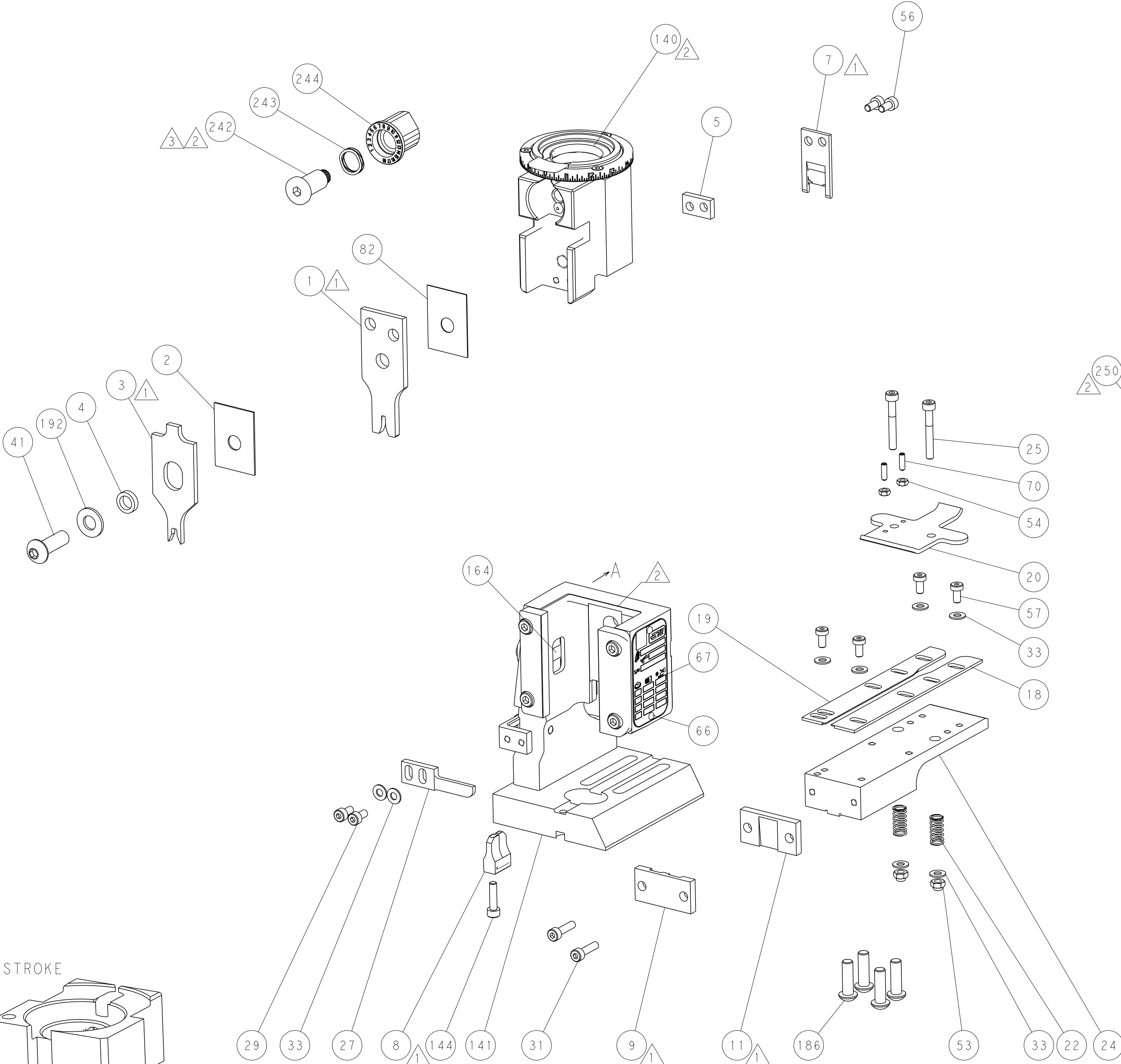
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DIMENSIONS: mm		CHK T. ELBIN	160CT2013	NAME Ocean End Feed Applicator	
		APVD M. CLIFFORD	160CT2013	SIZE CAGE CODE DRAWING NO	
		PRODUCT SPEC		RESTRICTED TO	
		APPLICATION SPEC		A1 00779 ©=2150074	
MATERIAL -		FINISH -		WEIGHT -	
				Customer Accessible Production Drawing	
				SCALE 1:1	
				SHEET 3 of 4	
				REV B	

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

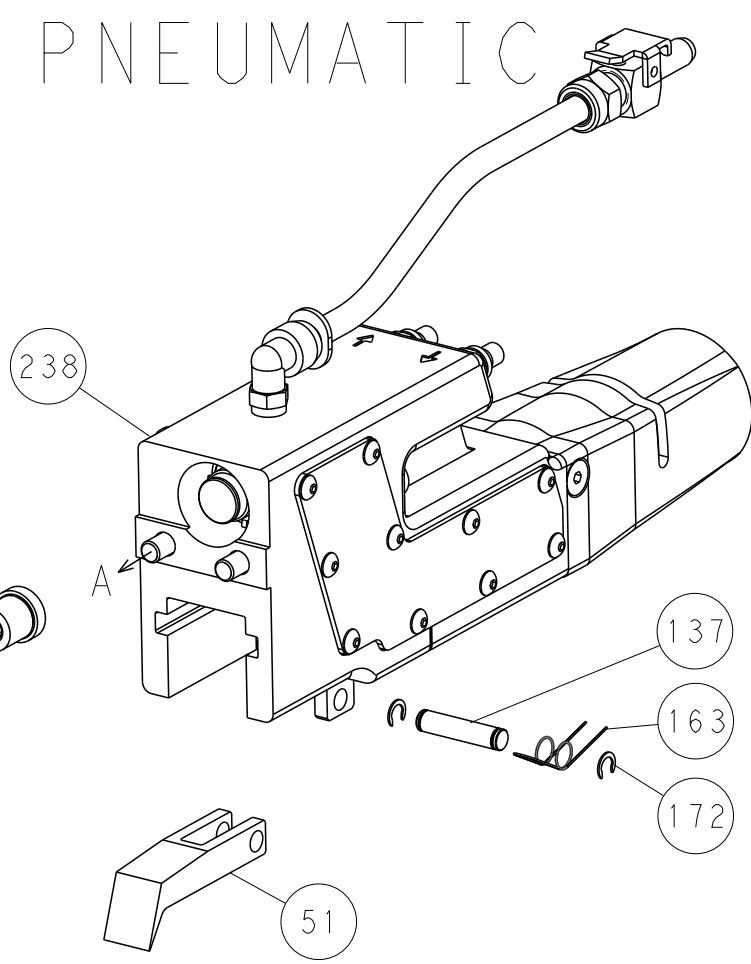
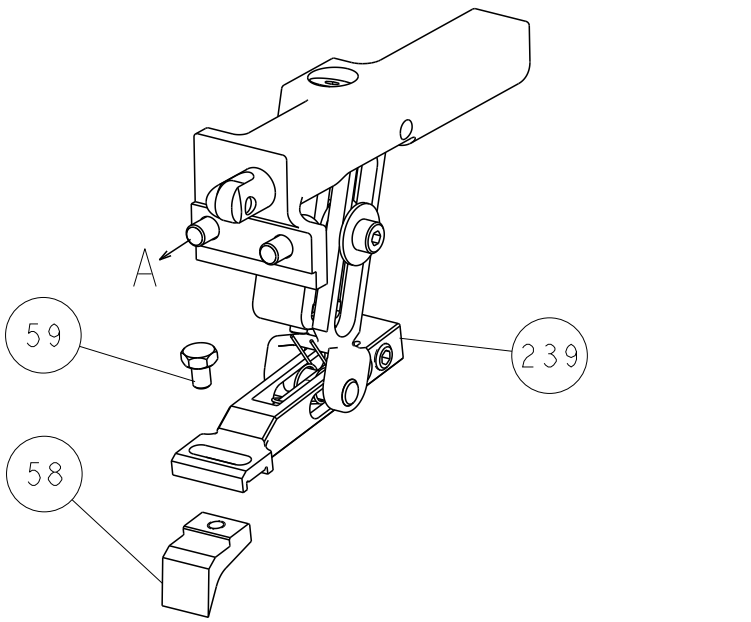
LOC		DIST		REVISIONS			
A	66	P	LTR	DESCRIPTION	DATE	DWN	APVD
		-		SEE SHEET 1	-	-	-



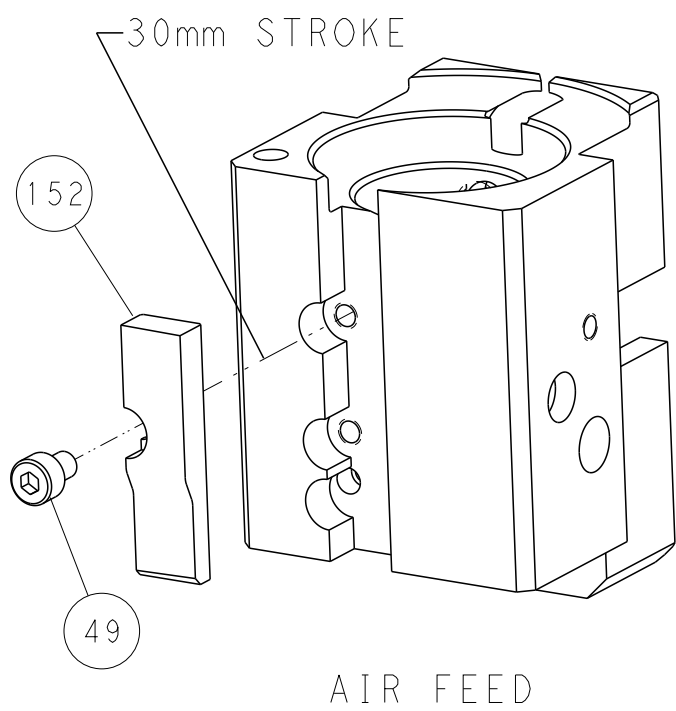
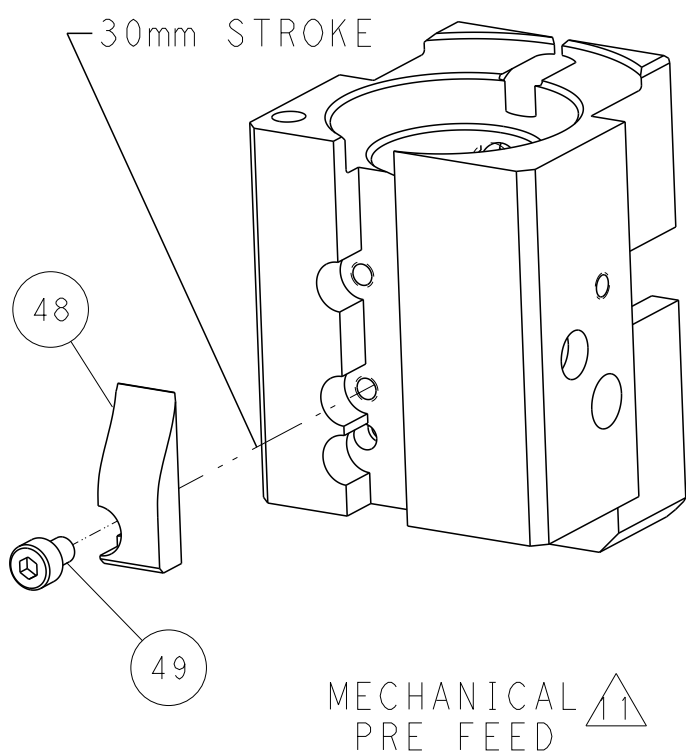
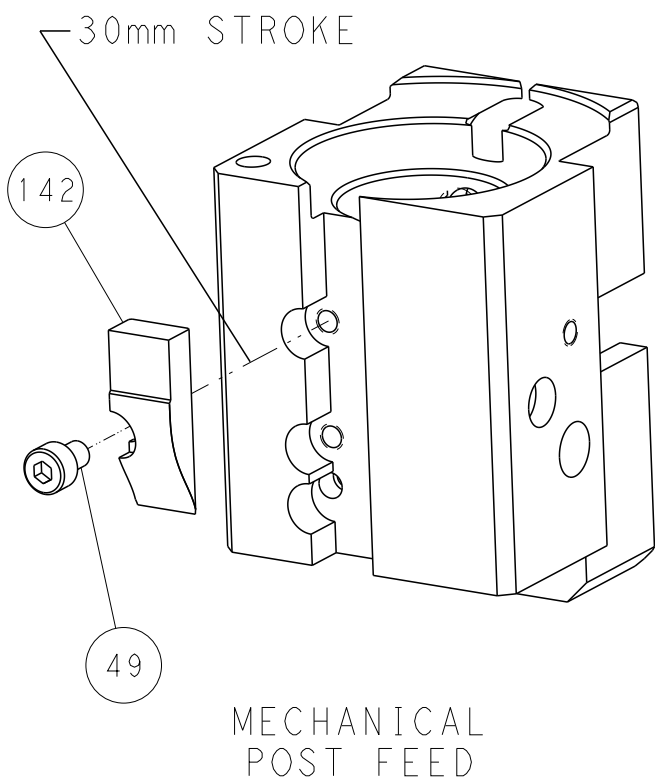
RAM SET-UP



FEED TYPE
MECHANICAL



CAM POSITIONS



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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TOLERANCES UNLESS OTHERWISE SPECIFIED:		CHK	16OCT2013		
DIMENSIONS:		APVD	16OCT2013	NAME Ocean End Feed Applicator	
mm		PRODUCT SPEC			
0 PLC		APPLICATION SPEC		SIZE A1	
1 PLC		WEIGHT			
2 PLC		Customer Accessible Production Drawing		SCALE 1:1	
3 PLC		Customer Accessible Production Drawing			
4 PLC		Customer Accessible Production Drawing		SHEET 4	
ANGLES		Customer Accessible Production Drawing			
FINISH		Customer Accessible Production Drawing		REV B	
MATERIAL		Customer Accessible Production Drawing			