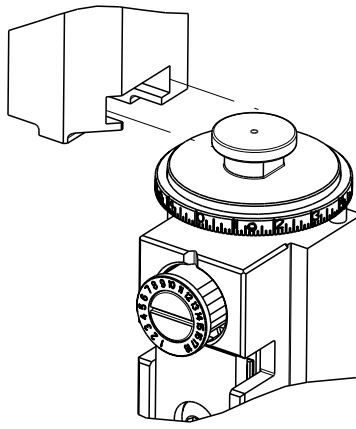


8		7	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150150-1	H	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2150150-2	H	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150150-1	H	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2150150-2	H	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150150-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.57 mm [.062]	○
NOSE	1.57 mm [.062]	○
APPLICATOR INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: CIRCULAR WIRE PIN			
WIRE STRIP LENGTH 7.54-8.33 mm [.297-.328 IN]		INSULATION DIAMETER RANGE -	
TERMINAL APPLICATION SPECIFICATION	NONE	-	-
TERMINALS APPLIED 			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
926933-1	926933-3	926933-6	926933-8
926933-2	926933-4	926933-7	926933-9

WIRE SIZE	WIRE CRIMP HEIGHT mm [INCH]	WIRE CRIMP HEIGHT REFERENCE SETTING	NOSE CRIMP HEIGHT	NOSE CRIMP HEIGHT REFERENCE SETTING
1.00mm2	1.55+/-0.05 [.061+/- .002]	8	1.76+/-0.05 [.069+/- .002]	5.1
0.75mm2	1.45+/-0.05 [.057+/- .002]	7	1.65+/-0.05 [.065+/- .002]	6.2
0.50mm2	1.14+/-0.05 [.045+/- .002]	12	1.55+/-0.05 [.061+/- .002]	7.6



- 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.
- TERMINAL LUBRICANT IS RECOMMENDED.
6. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- CRIMP HEIGHTS FOR WIRE BARRELS ONLY. ADJUST ITEM 244 TO OBTAIN WIRE CRIMP HEIGHT.
- WIRE SIZE APPLIES ONLY FOR HANDBRAKE CONTACT REFER TO BMW DRAWING 6 928 203.
- ITEM 244 ADJUSTS WIRE CRIMP HEIGHT. THE WIRE CRIMP HEIGHT ADJUST DIAL ADJUSTS INSULATION (NOSE) CRIMP HEIGHT.
- POSITION ITEM 27 IN FRONT OF ITEM 77.

*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.

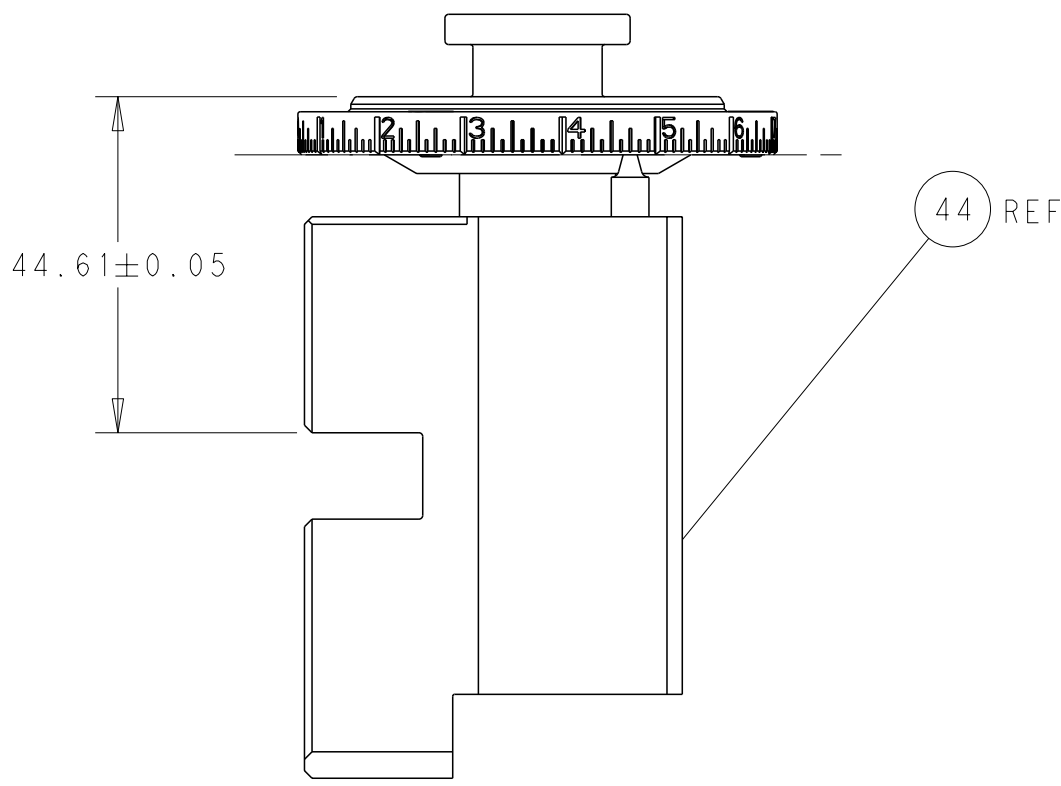
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

LOC	DIST	REVISIONS				
		#	LYR	DESCRIPTION	DATE	DWN
A	66	E		ECR-17-003145	20MAR2017	TB
		F		ECR-18-016007	09OCT2018	TB
		G		ECR-19-007056	02MAY2019	TB
		H		ECR-20-002803	26FEB2020	JWC

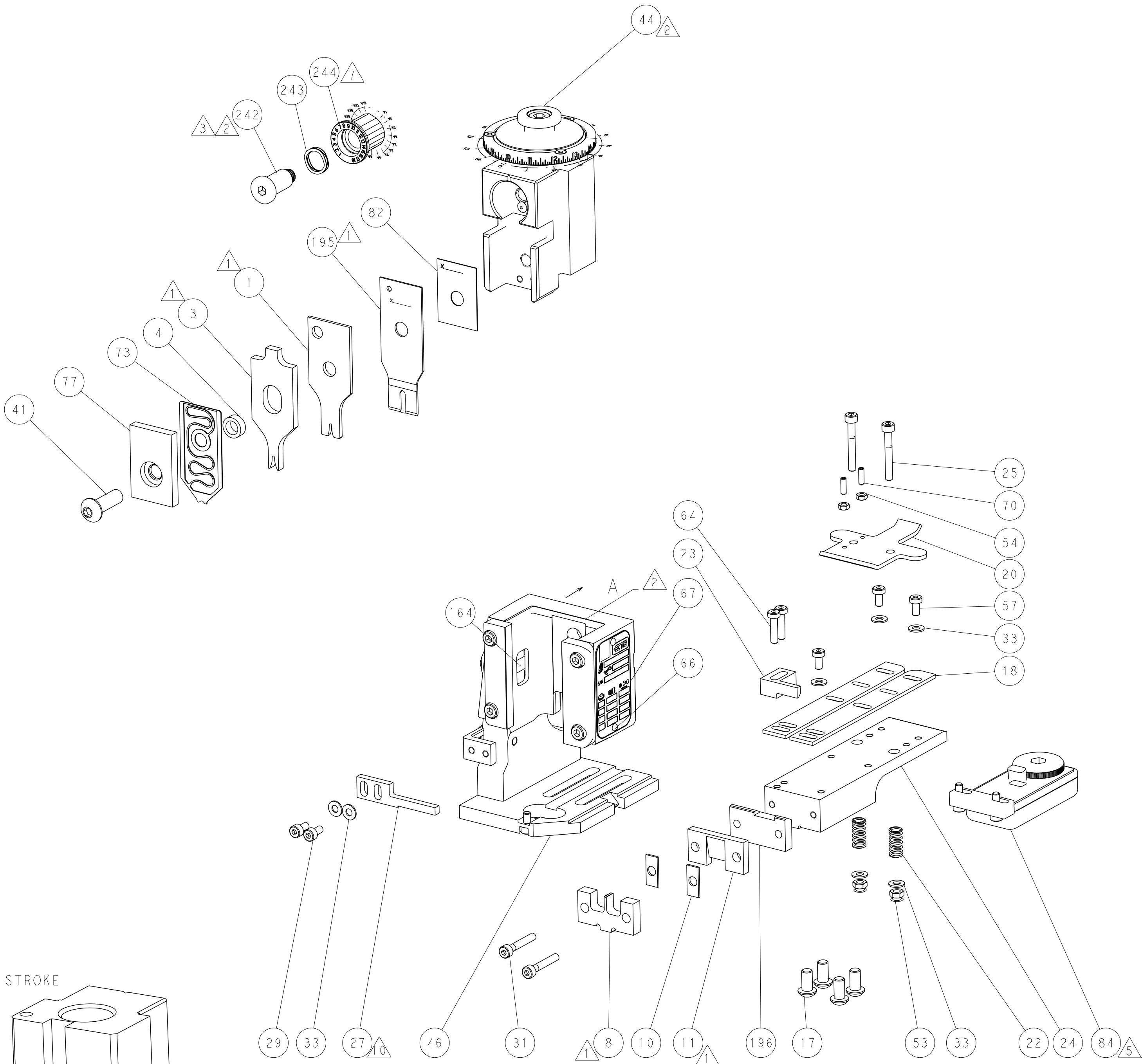
-	1	-	1	-	2119640-1	PUSH ROD, AIR FEED	250
-	1	-	1	-	1803259-1	BUSHING, FLANGED	249
-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248
	-	1	1	1	2119082-2	CAM, SNAIL, INSULATION ADJUSTMENT	244
	-	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
	-	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	-	1	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	1	-	1	-	2063440-1	AIR FEED MODULE	238
	-	1	1	1	1803071-1	SPACER, REAR SHEAR STRIP GUIDE	196
	-	1	1	1	3-459722-7	BLADE, SHEAR	195
-	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	2119955-2	ASSY, LUBRICATOR, END FEED	84
-	1	1	1	1	455888-4	SPACER, CRIMPER	82
-	1	1	1	1	1803203-2	BLOCK, FRONT DEPRESSOR	77
-	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
-	2	2	2	2	2168400-8	SHCS, LOW HEAD, RoHS, M4 X 16	64
-	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
-	3	3	3	3	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57
-	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	-	2119792-1	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	3-2119655-1	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
-	7	7	7	7	1-18028-2	WASHER, FLAT, REG M4	33
-	2	2	2	2	1-2168083-2	SCR, SKT HD CAP, RoHS, M4 X 25	31
-	2	2	2	2	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	29
	-	1	1	1	690455-1	STRIPPER, FRONT CASTING	27
	-	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
-	1	1	1	1	240825-1	PLATE, STRIP HOLD DOWN	23
-	2	2	2	2	2-22281-3	SPRING, COMPRESSION	22
-	1	1	1	1	1803292-4	DRAG	20
-	2	2	2	2	1901259-4	GUIDE, LOWER STRIP	18
-	4	4	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17
	-	1	1	1	2-240644-5	PLATE, REAR SHEAR	11
	-	2	2	2	6-240645-5	SPACER, SHEAR PLATE	10
	1	2	2	1	1633342-5	ANVIL, WIRE	8
-	-	1	1	1	238011-3	BLOCK, CRIMPER SPACER	4
	1	2	2	1	5-2119784-6	CRIMPER, INSULATION O PREMIUM	3
	1	2	2	1	6-459492-8	CRIMPER, WIRE O	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 ISSUING ORGANIZATION. IT SHOULD BE CONTACTED FOR THE LATEST REVISION.				DWN	HOFFNER	12JUN2012	 TE Connectivity Harrisburg, PA 17105-3608			
				CHK	T.ELBIN	13JUN2012				
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		APVD	T.ELBIN	13JUN2012	NAME		Ocean End Feed Applicator	
mm		0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ±		PRODUCT SPEC		APPLICATION SPEC				
		ANGLES FINISH ±°		-		-		-		
MATERIAL		-		WEIGHT		-		-		
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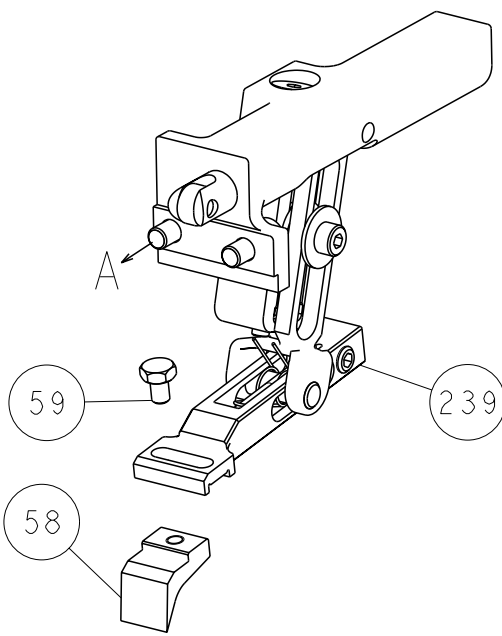
LOC		DIST		REVISONS			
A	66	P	LYR	DESCRIPTION	DATE	DWN	APVD
		-		SEE SHEET 1	-	-	-



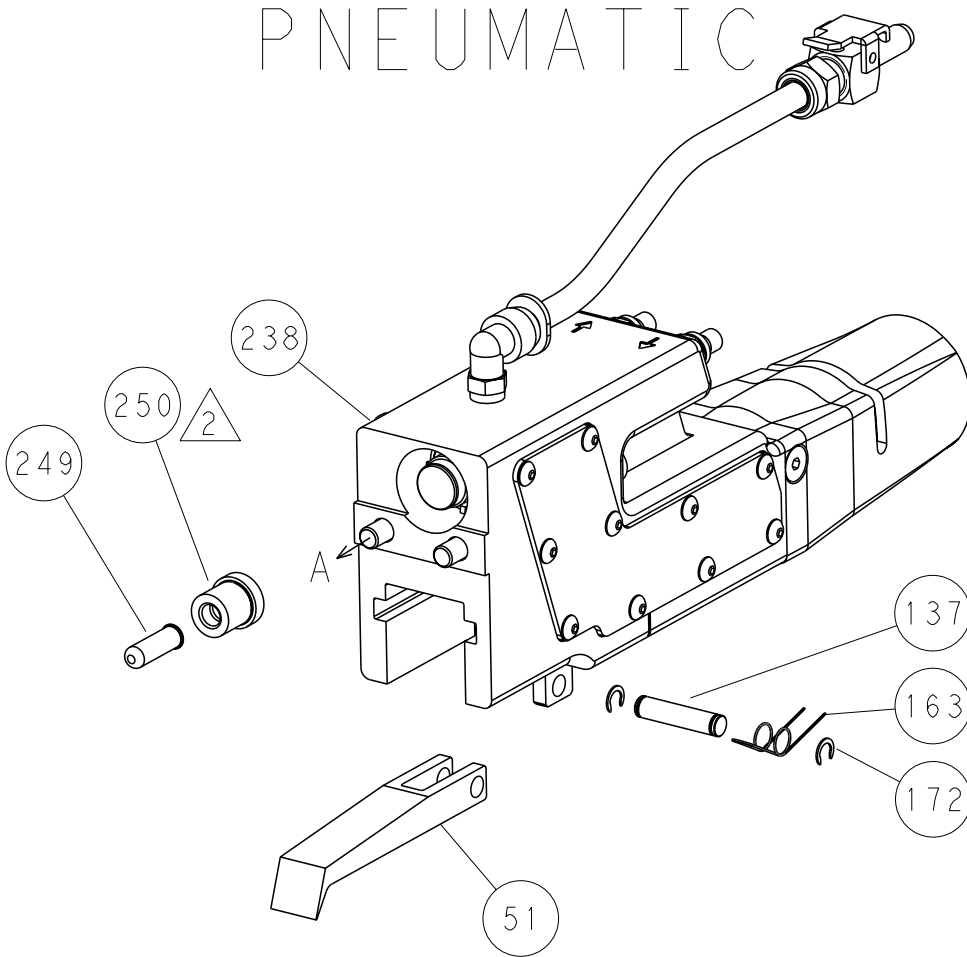
RAM SET-UP



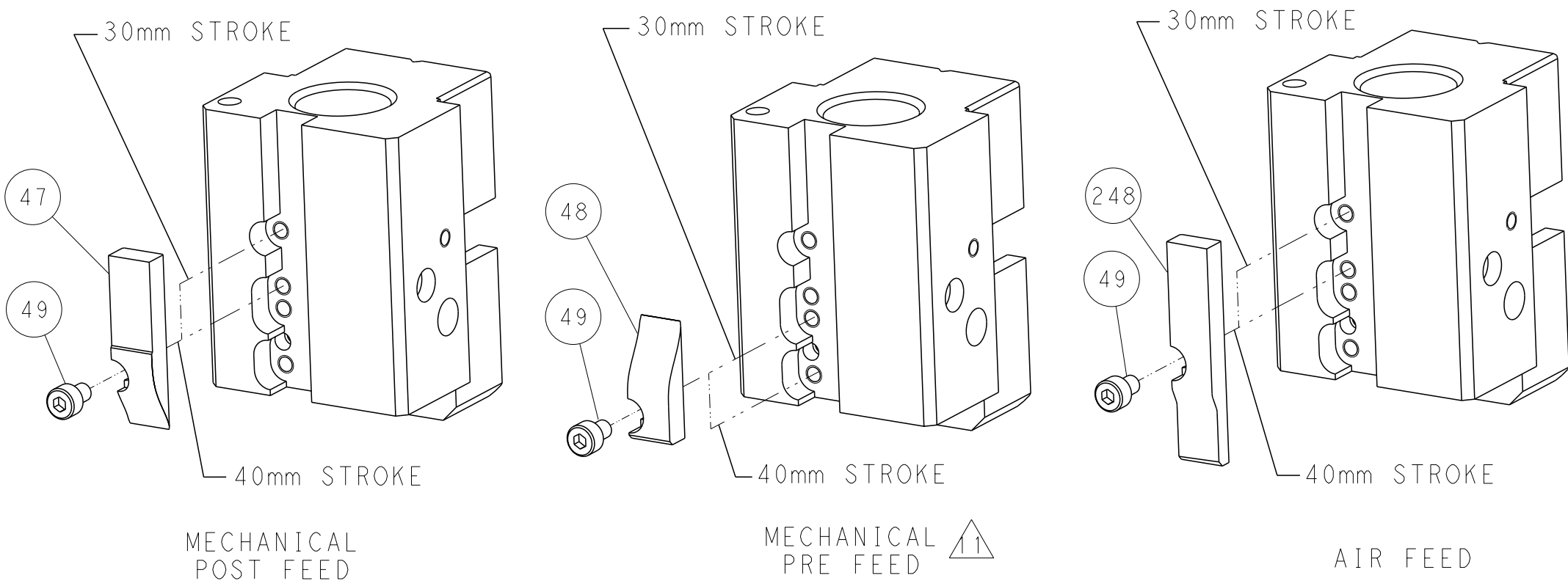
FEED TYPE MECHANICAL



PNEUMATIC



CAM POSITIONS

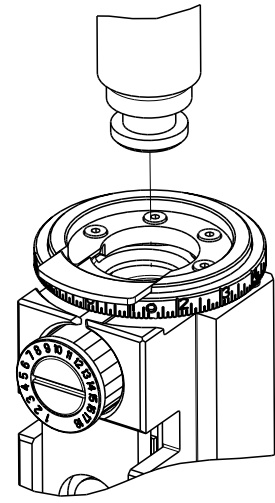


ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION IT IS SUBJECT TO CHANGE AND TO THE CONTROL AND ENGINEERING DEPARTMENT SHOULD BE CONTACTED FOR THE LATEST REVISION				DWN HOFFNER 12JUN2012	TE Connectivity Harrisburg, PA 17105-3608						
DIMENSIONS: mm				CHK T.ELBIN 13JUN2012	NAME Ocean End Feed Applicator	SIZE A1	CAGE CODE 00779	DRAWING NO C=2150150	RESTRICTED TO -		
				APVD T.ELBIN 13JUN2012							
TOLERANCES UNLESS OTHERWISE SPECIFIED:				PRODUCT SPEC -							
MATERIAL -				APPLICATION SPEC -							
FINISH -				WEIGHT -	SCALE 1:1				SHEET 2	OF 4	REV H
Customer Accessible Production Drawing											

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20		20	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150150-1	H	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2150150-2	H	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150150-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.57 mm [.062]	○
NOSE	1.57 mm [.062]	○
APPLICATOR INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: CIRCULAR WIRE PIN			
WIRE STRIP LENGTH 7.54-8.33 mm [.297-.328 IN]		INSULATION DIAMETER RANGE -	
TERMINAL APPLICATION SPECIFICATION	NONE	-	-
TERMINALS APPLIED 			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
926933-1	926933-3	926933-6	926933-8
926933-2	926933-4	926933-7	926933-9

WIRE SIZE		WIRE CRIMP HEIGHT mm [INCH]		WIRE CRIMP HEIGHT REFERENCE SETTING	NOSE CRIMP HEIGHT	NOSE CRIMP HEIGHT REFERENCE SETTING
1.00mm2		1.55+/-0.05 [.061+/- .002]		8	1.76+/-0.05 [.069+/- .002]	5.1
0.75mm2		1.45+/-0.05 [.057+/- .002]		7	1.65+/-0.05 [.065+/- .002]	6.2
0.50mm2		1.14+/-0.05 [.045+/- .002]		12	1.55+/-0.05 [.061+/- .002]	7.6



- 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 TERMINAL LUBRICANT IS RECOMMENDED.
6. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- 7 CRIMP HEIGHTS FOR WIRE BARRELS ONLY. ADJUST ITEM 244 TO OBTAIN WIRE CRIMP HEIGHT.
- 8 WIRE SIZE APPLIES ONLY FOR HANDBRAKE CONTACT REFER TO BMW DRAWING 6 928 203.
- 9 ITEM 244 ADJUSTS WIRE CRIMP HEIGHT.
THE WIRE CRIMP HEIGHT ADJUST DIAL ADJUSTS INSULATION (NOSE) CRIMP HEIGHT.
- 10 POSITION ITEM 27 IN FRONT OF ITEM 77.

*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)

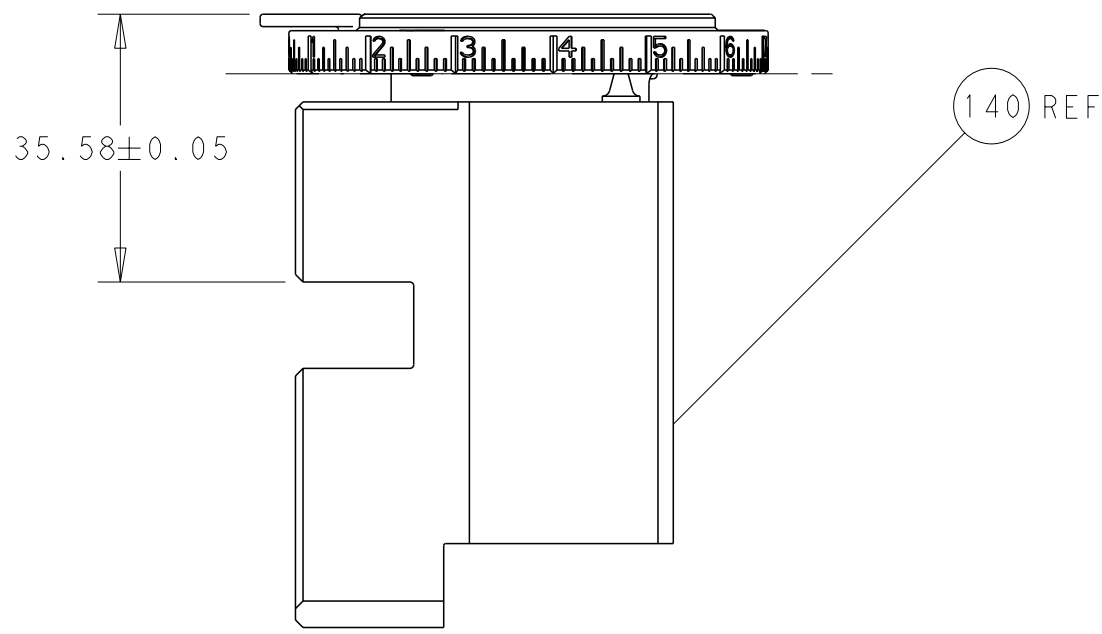
LOC	DIST	REVISIONS				
A	66	P	LYR	DESCRIPTION	DATE	OWN
		-		SEE SHEET 1	-	-

-	1	1	2119640-1	PUSH ROD, AIR FEED	250
-	1	1	1803259-1	BUSHING, FLANGED	249
7	-	1	2119082-2	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	1803071-1	SPACER,REAR SHEAR STRIP GUIDE	196
1	-	1	3-459722-7	BLADE, SHEAR	195
-	4	4	2079383-9	SCR, BHSC, RoHS (M6 X 20)	186
-	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	3-2119655-2	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
5	-	1	2119955-2	ASSY, LUBRICATOR, END FEED	84
-	1	1	455888-4	SPACER, CRIMPER	82
-	1	1	1803203-2	BLOCK, FRONT DEPRESSOR	77
-	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
-	2	2	2168400-8	SHCS, LOW HEAD, RoHS, M4 X 16	64
-	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	-	1	2063961-1	FEED FINGER	58
-	3	3	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57
-	2	2	5018030-1	NUT, HEX, REG, RoHS, M3	54
-	2	2	986965-8	NUT, LOCK, HEX, TORQUE (M4)	53
-	1	-	2119792-1	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
-	7	7	1-18028-2	WASHER, FLAT, REG M4	33
-	2	2	1-2168083-2	SCR, SKT HD CAP, RoHS, M4 X 25	31
-	2	2	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	29
10	-	1	690455-1	STRIPPER, FRONT CASTING	27
-	2	2	1-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 30	25
-	1	1	1752371-5	PLATE, STRIP GUIDE	24
-	1	1	240825-1	PLATE, STRIP HOLD DOWN	23
-	2	2	2-22281-3	SPRING, COMPRESSION	22
-	1	1	1803292-4	DRAG	20
-	2	2	1901259-4	GUIDE, LOWER STRIP	18
1	-	1	2-240644-5	PLATE, REAR SHEAR	11
-	2	2	6-240645-5	SPACER, SHEAR PLATE	10
1	1	1	1633342-5	ANVIL, WIRE	8
-	1	1	238011-3	BLOCK, CRIMPER SPACER	4
1	1	1	5-2119784-6	CRIMPER, INSULATION O PREMIUM	3
1	1	1	6-459492-8	CRIMPER, WIRE O	1
-	77-22-21		PART NO	DESCRIPTION	ITEM NO

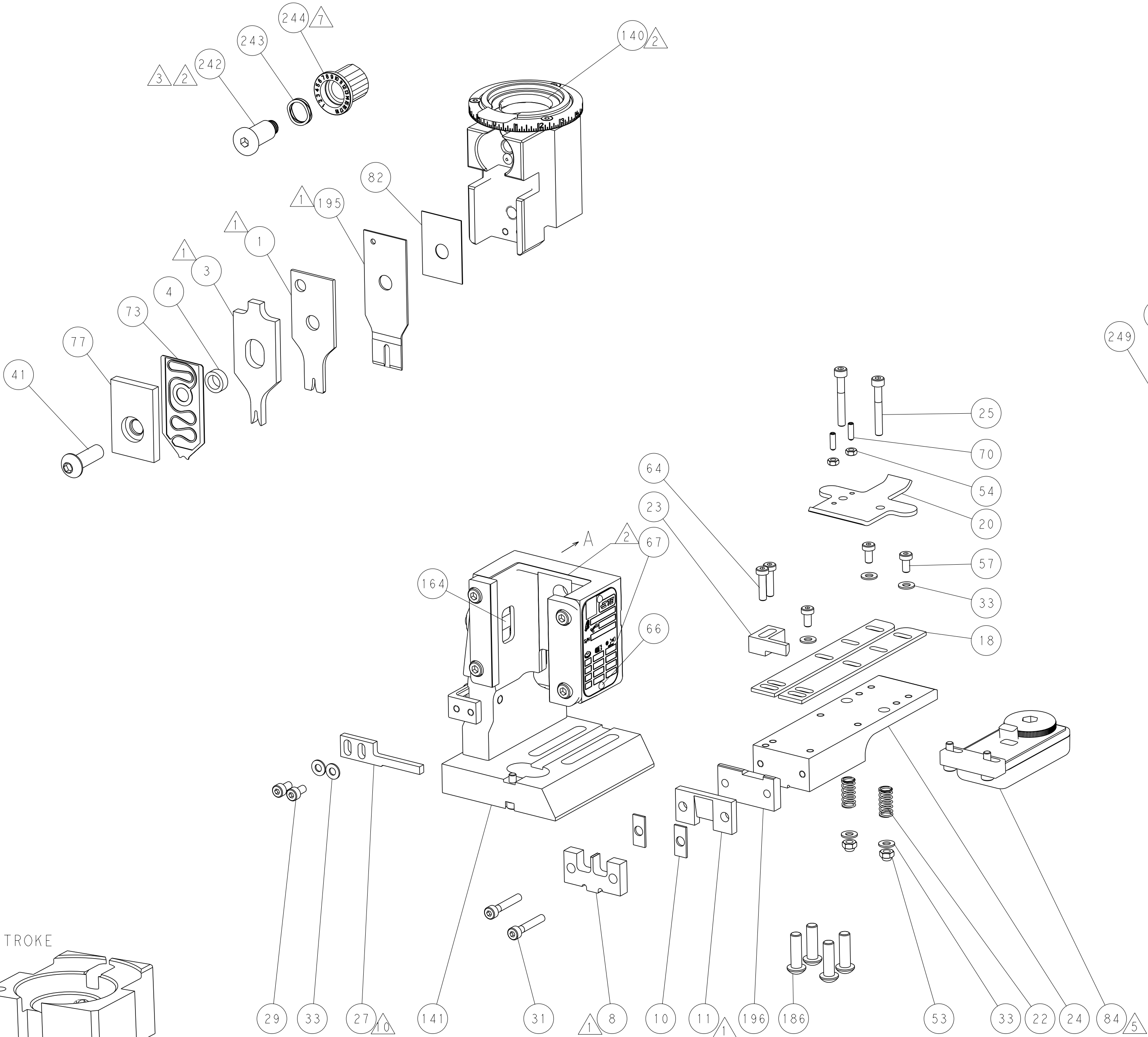
THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE AND TO BE CONTROLLED BY THE DRAWING CONTROLLING ORGANIZATION. IT SHOULD BE CONTACTED FOR THE LATEST REVISION.		OWN CHG T.ELBIN APVD T.ELBIN	12JUN2012 13JUN2012 13JUN2012	TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		NAME Ocean End Feed Applicator	
		APPLICATION SPEC		SIZE A1	
MATERIAL -		WEIGHT -		CAGE CODE 00779	
				DRAWING NO 2150150	
				RESTRICTED TO -	
				Customer Accessible Production Drawing	
				SCALE 1:1	
				SHEET 3	
				OF 4	
				REV H	

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

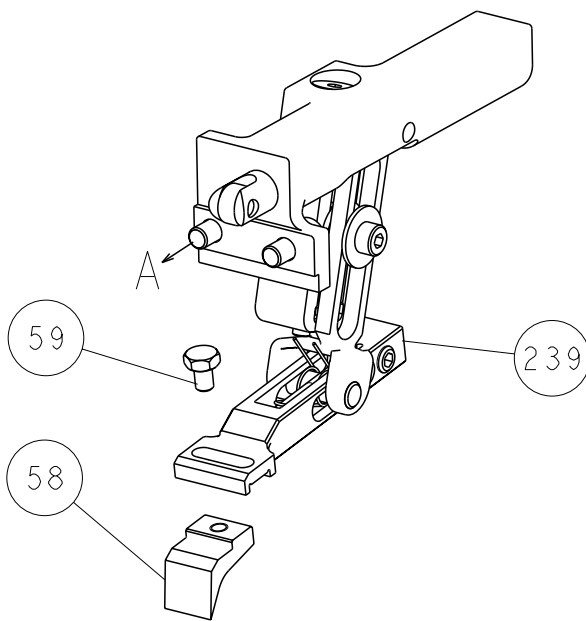
LOC		DIST		REVISIONS			
A	66	P	LYR	DESCRIPTION	DATE	DWN	APVD
		-	-	SEE SHEET 1	-	-	-



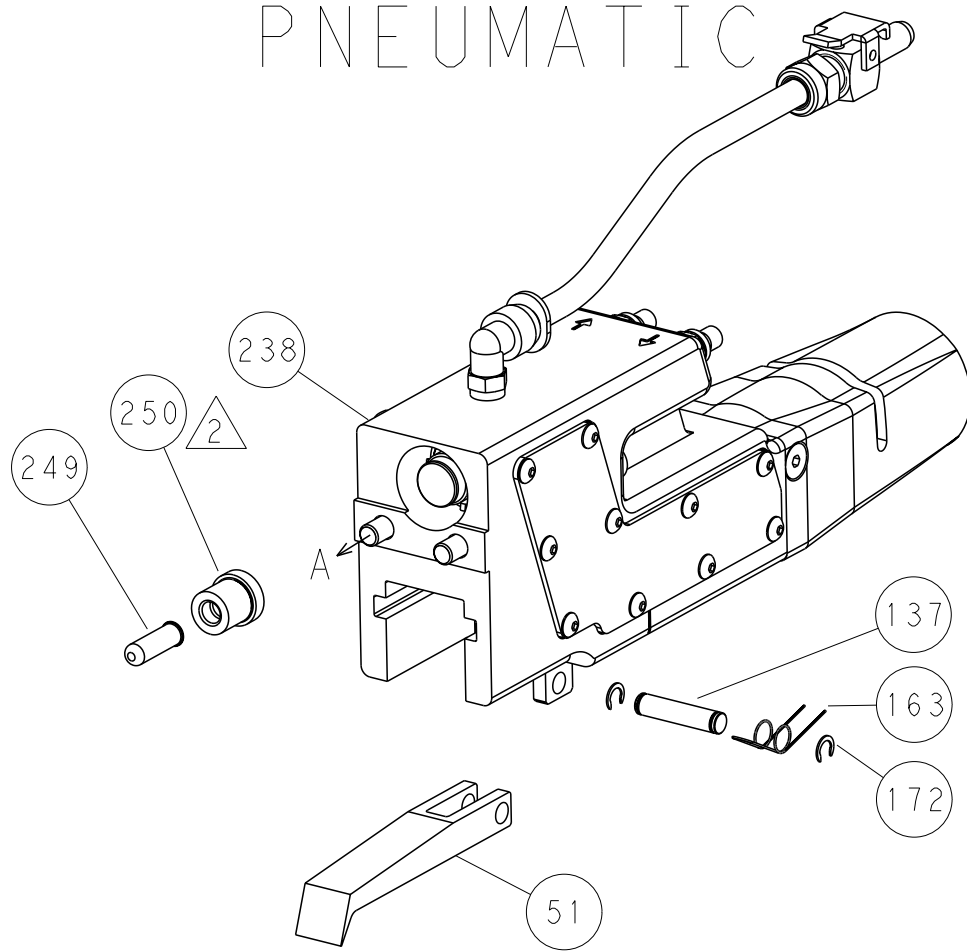
RAM SET-UP



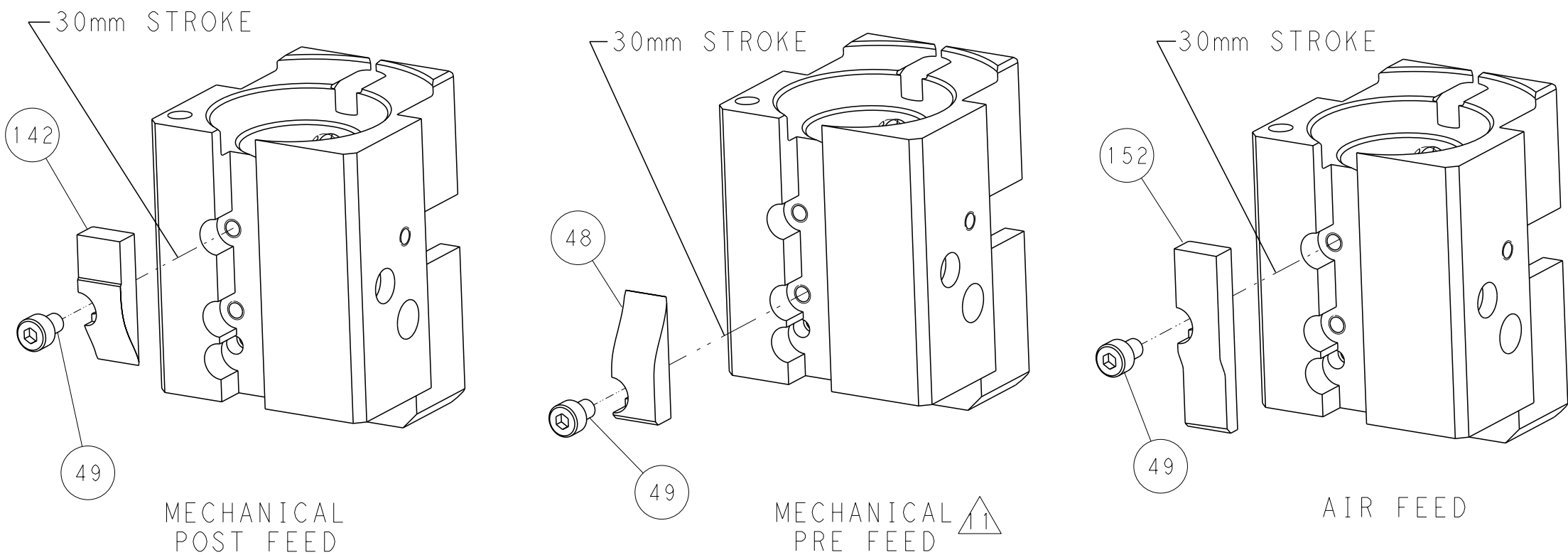
FEED TYPE
MECHANICAL



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)

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										CHK ELBIN		13JUN2012																	
										APVD T.ELBIN		13JUN2012		NAME		Ocean End Feed Applicator													
										PRODUCT SPEC																			
										APPLICATION SPEC																			
										WEIGHT		-		SIZE		A 00779		DRAWING NO		C=2150150		RESTRICTED TO		-					
MATERIAL										-																			
Customer Accessible Production Drawing														SCALE		1:1		SHEET		4		OF		4		REV		H	