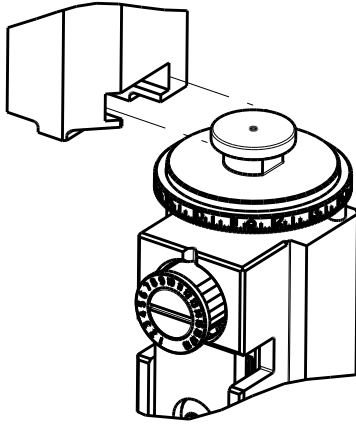


8		7	
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20		20	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150189-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2150189-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150189-1	B	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2150189-2	B	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150189-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR
INTERFACE ADAPTER



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

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: CIRCULAR WIRE PIN TERMINAL			
WIRE STRIP LENGTH 8.18-9.20 mm [.322-.362 IN]			INSULATION DIAMETER RANGE Ø
TERMINAL APPLICATION SPECIFICATION 	NONE	-	-
TERMINALS APPLIED			
TE TERMINAL 925856-1	TE TERMINAL 925856-2	TE TERMINAL	TE TERMINAL

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING
2.50mm2		2.16+/-0.05 [.085+/-0.002]		2.9
1.50mm2		1.80+/-0.05 [.071+/-0.002]		6.5



- 1 RECOMMENDED SPARE PARTS
- 2 REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- 3 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.
4. 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.

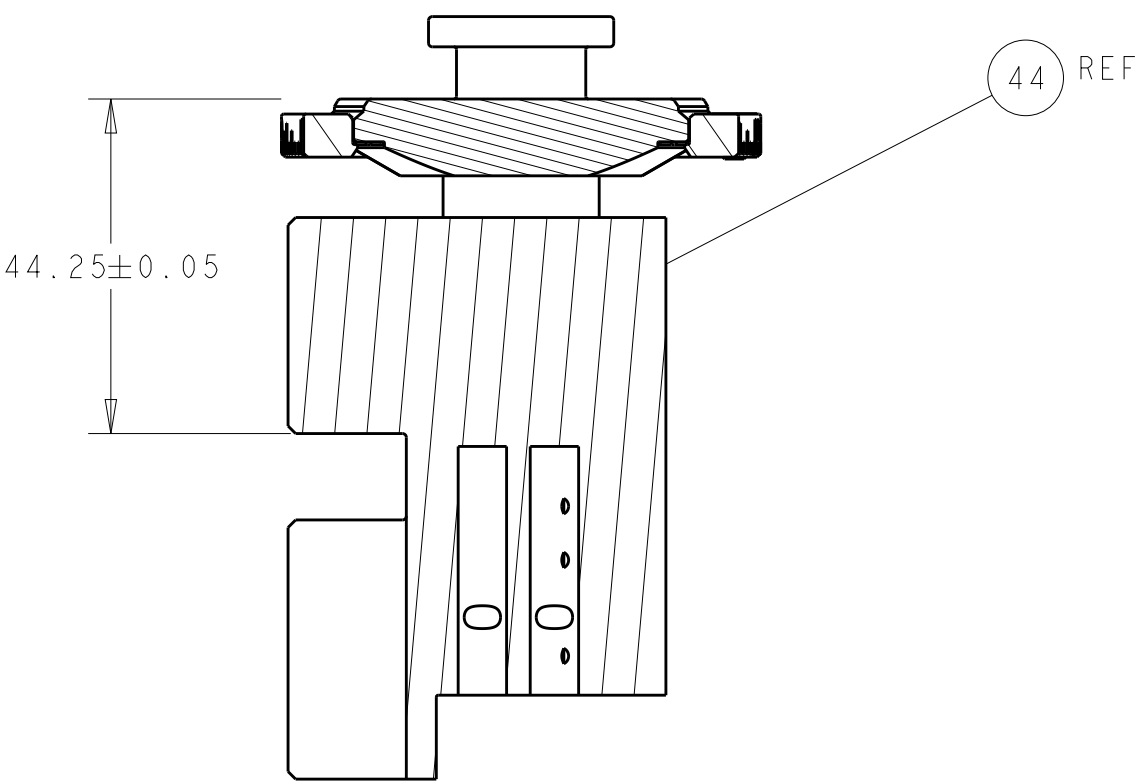
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

2		1					
LOC	DIST	REVISIONS					
A	66	P	LTR	DESCRIPTION	DATE	DWN	APVD
		A		RELEASED	27OCT2015	MR	TE
		B		ECR-18-014320	12SEP2018	MZ	KZ

	-	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	2119580-1	MECHANICAL FEED ASSEMBLY	239
	-	1	-	1	-	2063440-1	AIR FEED MODULE	238
A	-	1	1	1	1	1803071-1	SPACER,REAR SHEAR STRIP GUIDE	196
	-	1	1	1	1	2-459722-2	BLADE, SHEAR	195
	-	2	2	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	191
	-	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	455888-5	SPACER, CRIMPER	82
	-	1	1	1	1	1803607-2	DOCUMENTATION PACKAGE	71
	-	2	2	2	2	3-18032-3	SCR, SET, FLT PNT, M3 X 20.0	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	2168400-5	SHCS, LOW HEAD, RoHS, M4 X 20	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	1-2119655-7	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	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	29
	-	1	1	1	1	690455-1	STRIPPER, FRONT CASTING	27
	-	2	2	2	2	1-2168083-6	SCR, SKT HD CAP, RoHS, M4 X 35	25
	-	1	1	1	1	1752371-1	PLATE, STRIP GUIDE	24
	-	1	1	1	1	240825-1	PLATE, STRIP HOLD DOWN	23
	-	2	2	2	2	22281-8	SPRING, COMPRESSION	22
	-	1	1	1	1	1633168-1	ARM, STOCK DRAG	21
	-	1	1	1	1	1-464452-6	DRAG, STOCK	20
	-	2	2	2	2	1901259-3	GUIDE, LOWER STRIP	18
	-	4	4	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17
A	-	1	1	1	1	240644-1	PLATE, REAR SHEAR	11
	-	2	2	2	2	6-240645-5	SPACER, SHEAR PLATE	10
A	1	2	2	1	1	1633342-6	ANVIL, WIRE	8
	-	-	-	-	-	-	-	5
	-	-	-	-	-	-	-	4
	-	-	-	-	-	-	-	3
	-	-	-	-	-	-	-	2
A	1	2	2	1	1	1-1633723-4	CRIMPER, WIRE O	1
-77-72-71-2-1						PART NO	DESCRIPTION	ITEM NO

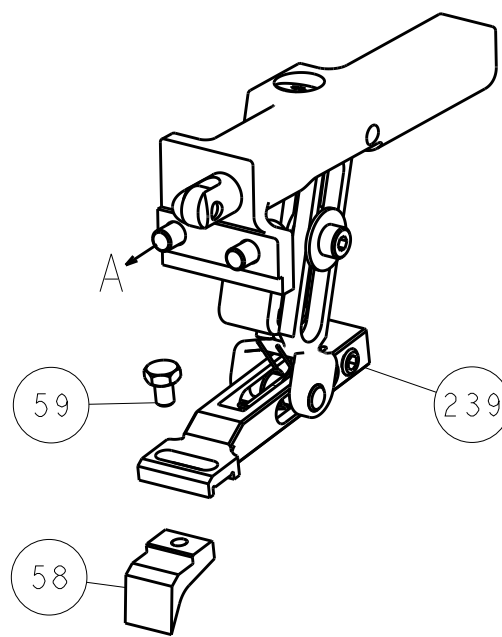
THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE AND TO THE CONTROL OF THE ORGANIZATION THAT IT IS DESIGNED FOR. IT IS SUBJECT TO CHANGE AND TO THE CONTROL OF THE ORGANIZATION THAT IT IS DESIGNED FOR. IT IS SUBJECT TO CHANGE AND TO THE CONTROL OF THE ORGANIZATION THAT IT IS DESIGNED FOR.		DWN HOFFNER 11JUNE2014	TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm		CHK T.ELBIN 12JUNE2014	NAME Ocean End Feed Applicator	
TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.5 1 PLC ±0.13 2 PLC ±0.13 3 PLC ±0.013 4 PLC ±0.0001 ANGLES ±.1		APVD T.ELBIN 12JUNE2014	PRODUCT SPEC APPLICATION SPEC	
MATERIAL -		FINISH -	WEIGHT -	SIZE A
Customer Accessible Production Drawing		SCALE 1:1	DRAWING NO 00779	REV B

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

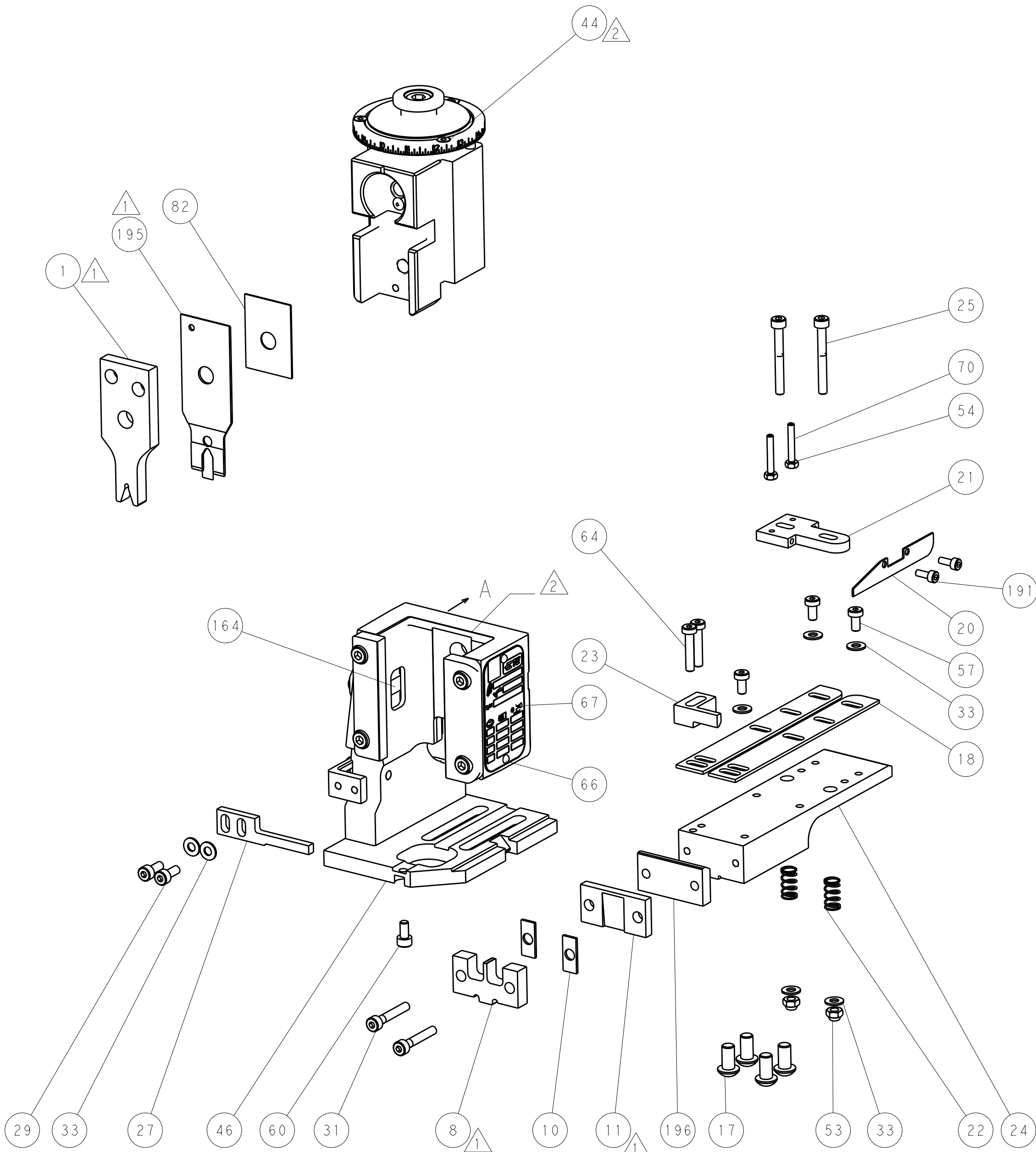
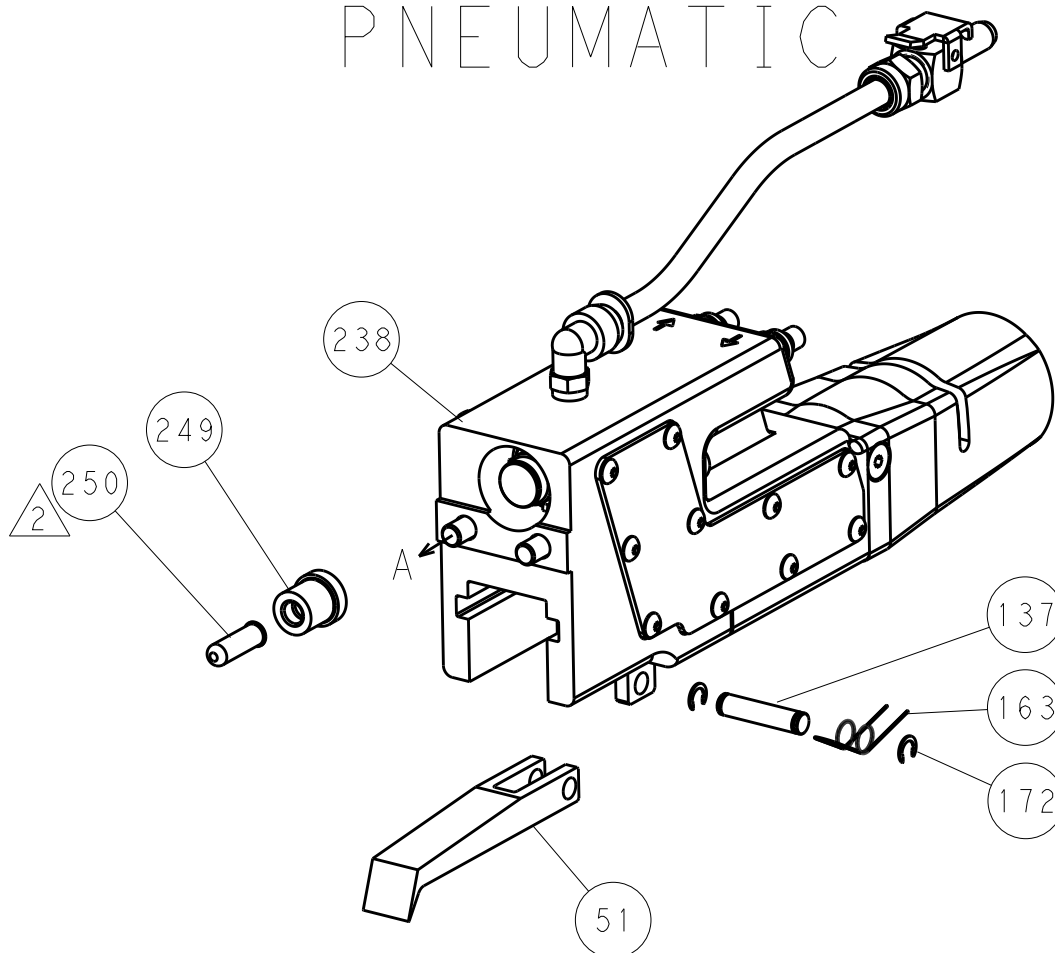


RAM SET-UP

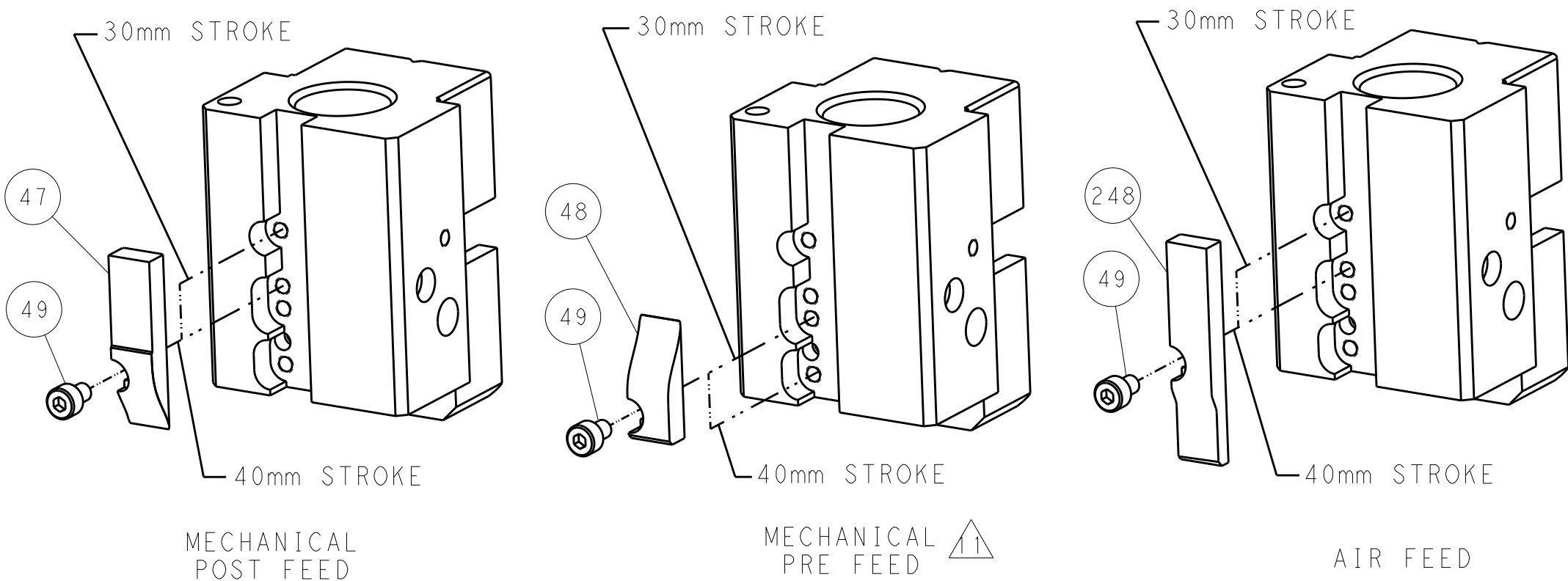
FEED TYPE
MECHANICAL



PNEUMATIC



CAM POSITIONS

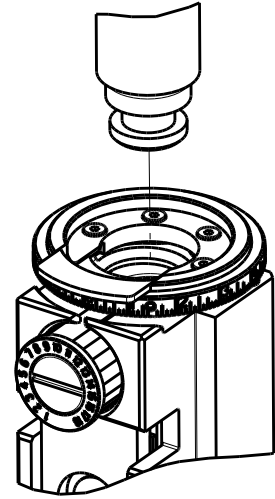


ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

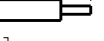
1ST FORMERLY IT-1, CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION IT-1 IS SUBJECT TO CHANGE WITHOUT NOTICE AND ENGINEERING ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST VERSION.		DWN HOFFNER	11JUNE2014	TE Connectivity Harrisburg, PA 17105-3608
		CHK T.ELBIN	12JUNE2014	
		APVD T.ELBIN	12JUNE2014	
		PRODUCT SPEC		
		APPLICATION SPEC		NAME Ocean End Feed Applicator
		SIZE	CAGE CODE	
		DRAWING NO		
		RESTRICTED TO		
MATERIAL		WEIGHT	-	Customer Accessible Production Drawing
		SCALE	1:1	
		SHEET	2 of 4	
		REV	B	

8		7	
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20		20	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150189-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2150189-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150189-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



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

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: CIRCULAR WIRE PIN TERMINAL			
WIRE STRIP LENGTH 8.18-9.20 mm [.322-.362 IN]			INSULATION DIAMETER RANGE Ø
TERMINAL APPLICATION SPECIFICATION	NONE	-	-
	-	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
925856-1	925856-2		

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING
2.50mm2		2.16+/-0.05 [.085+/-0.002]		2.9
1.50mm2		1.80+/-0.05 [.071+/-0.002]		6.5



- 1 RECOMMENDED SPARE PARTS
- 2 REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- 3 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.
4. 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.

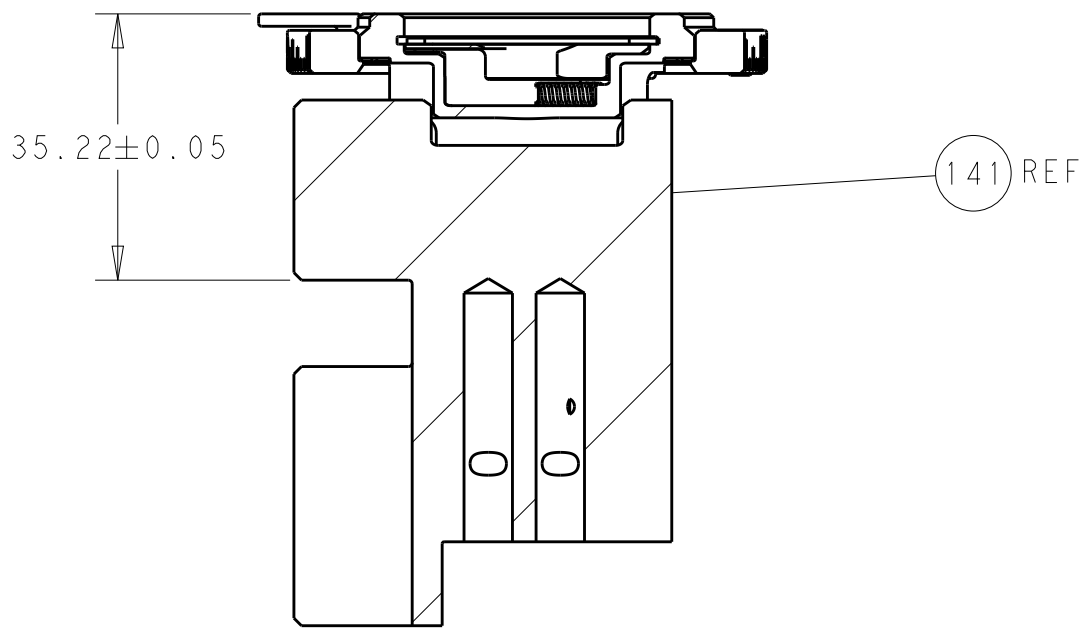
PACIFIC VERSION
Shown on sheets 3 of 4 & 4 of 4
(Atlantic version shown on sheets 1 of 4 & 2 of 4)

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	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	2-459722-2	BLADE, SHEAR	195
-	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	191
-	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	1-2119655-8	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	455888-5	SPACER, CRIMPER	82
-	1	1	1803607-2	DOCUMENTATION PACKAGE	71
-	2	2	3-18032-3	SCR, SET, FLT PNT, M3 X 20.0	70
-	1	1	2119740-1	TAG,IDENTIFICATION	67
-	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	2	2	2168400-5	SHCS, LOW HEAD, RoHS, M4 X 20	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	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	29
-	1	1	690455-1	STRIPPER, FRONT CASTING	27
-	2	2	1-2168083-6	SCR, SKT HD CAP, RoHS, M4 X 35	25
-	1	1	1752371-1	PLATE, STRIP GUIDE	24
-	1	1	240825-1	PLATE, STRIP HOLD DOWN	23
-	2	2	22281-8	SPRING, COMPRESSION	22
-	1	1	1633168-1	ARM, STOCK DRAG	21
-	1	1	1-464452-6	DRAG, STOCK	20
-	2	2	1901259-3	GUIDE, LOWER STRIP	18
-	1	1	240644-1	PLATE, REAR SHEAR	11
-	2	2	6-240645-5	SPACER, SHEAR PLATE	10
1	1	1	1633342-6	ANVIL, WIRE	8
-	-	-	-	-	5
-	-	-	-	-	4
-	-	-	-	-	3
-	-	-	-	-	2
1	1	1	1-1633723-4	CRIMPER, WIRE O	1
-	77	-	22-21	PART NO	ITEM NO

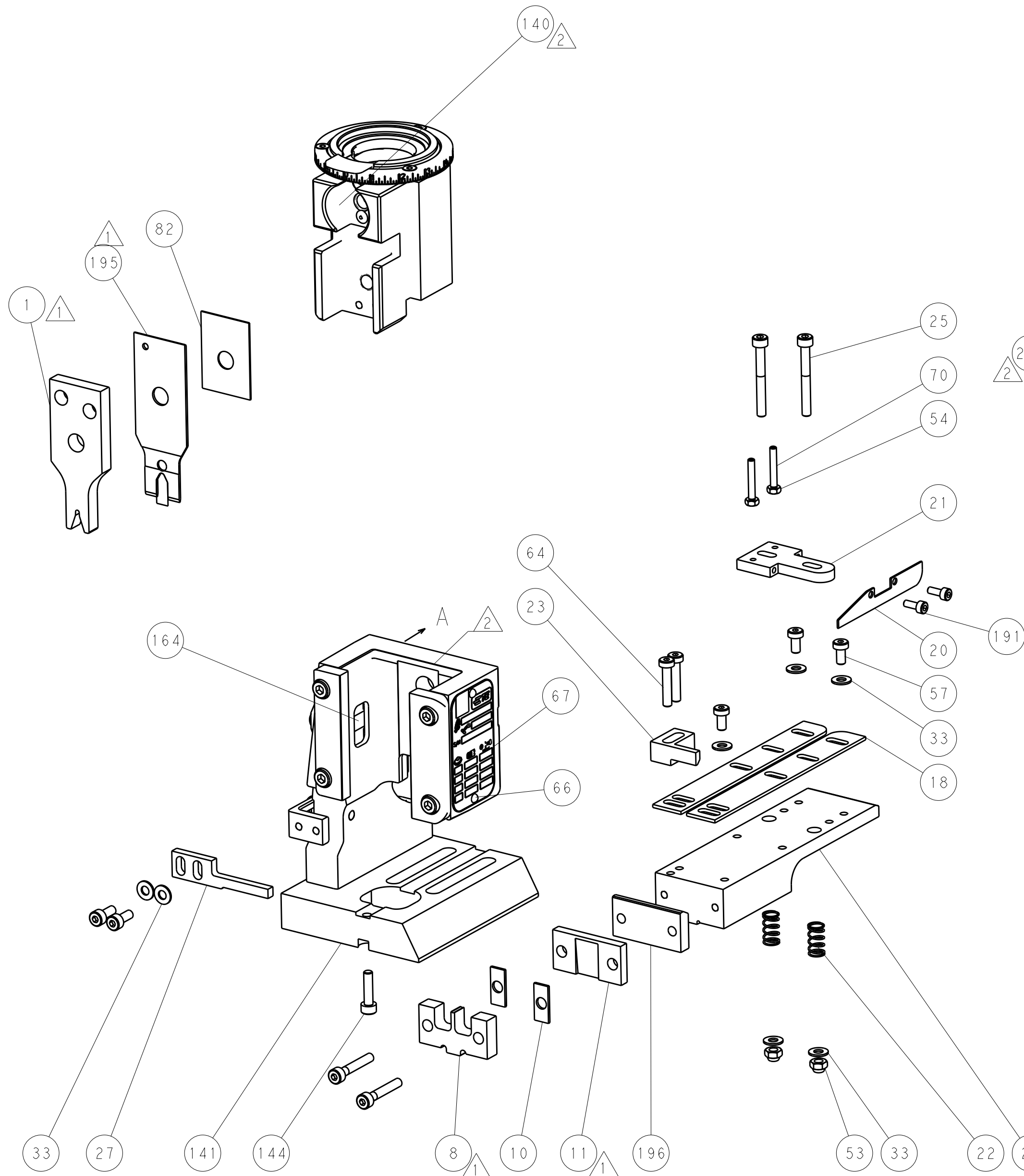
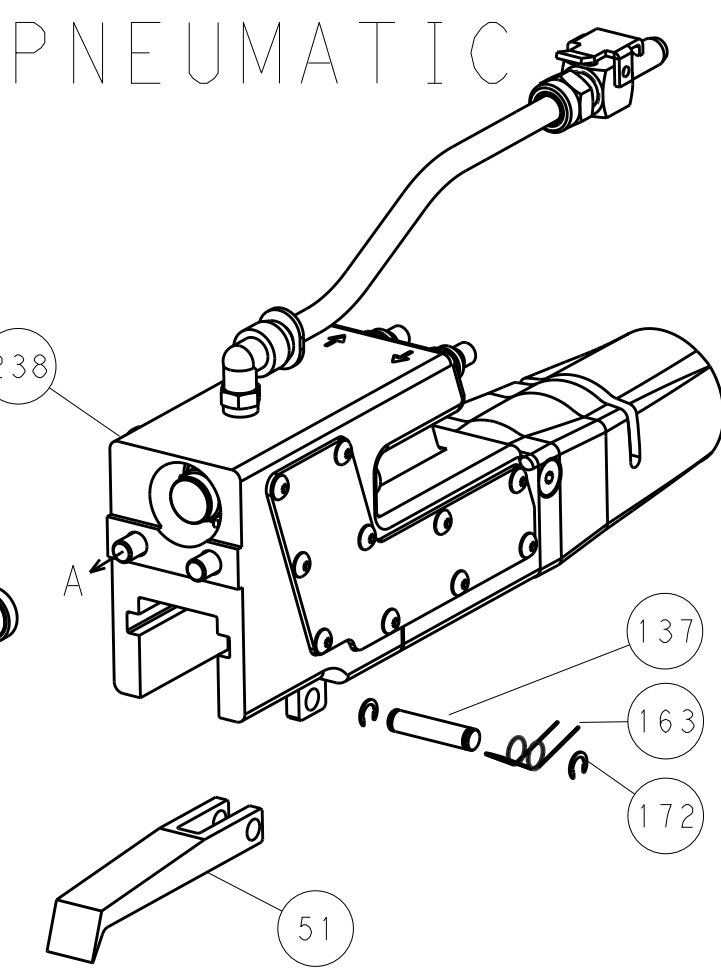
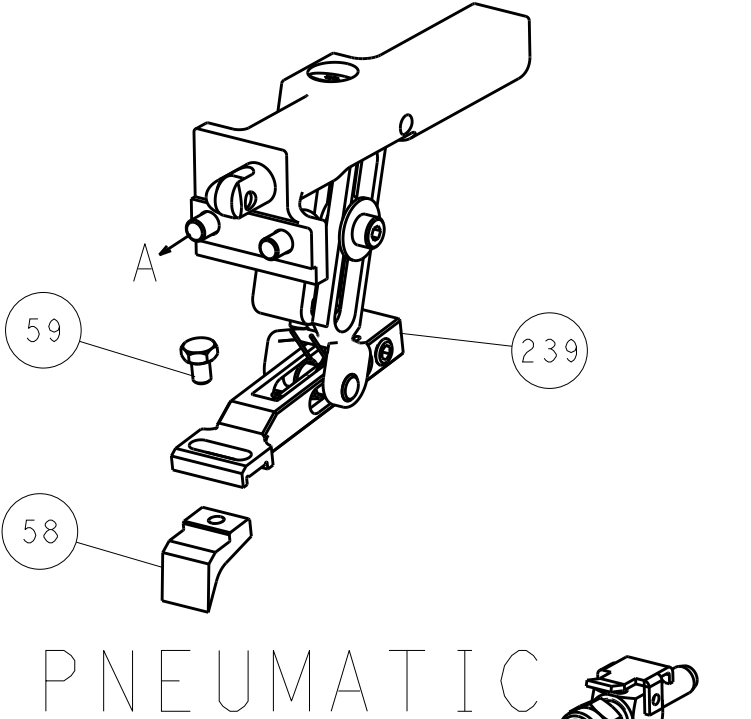
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DIMENSIONS:		CHK	T.ELBIN	12JUNE2014	NAME		
mm		APVD	T.ELBIN	12JUNE2014	PRODUCT SPEC APPLICATION SPEC		
		TOLERANCES UNLESS OTHERWISE SPECIFIED:		Ocean End Feed Appliator			
MATERIAL		FINISH		SIZE			
-		-		CAGE CODE			
Customer Accessible Production Drawing		WEIGHT		DRAWING NO			
		-		A 00779 C=2150189			
				RESTRICTED TO			
				-			
				SCALE			
				1:1			
				SHEET			
				3 of 4			
				REV B			

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

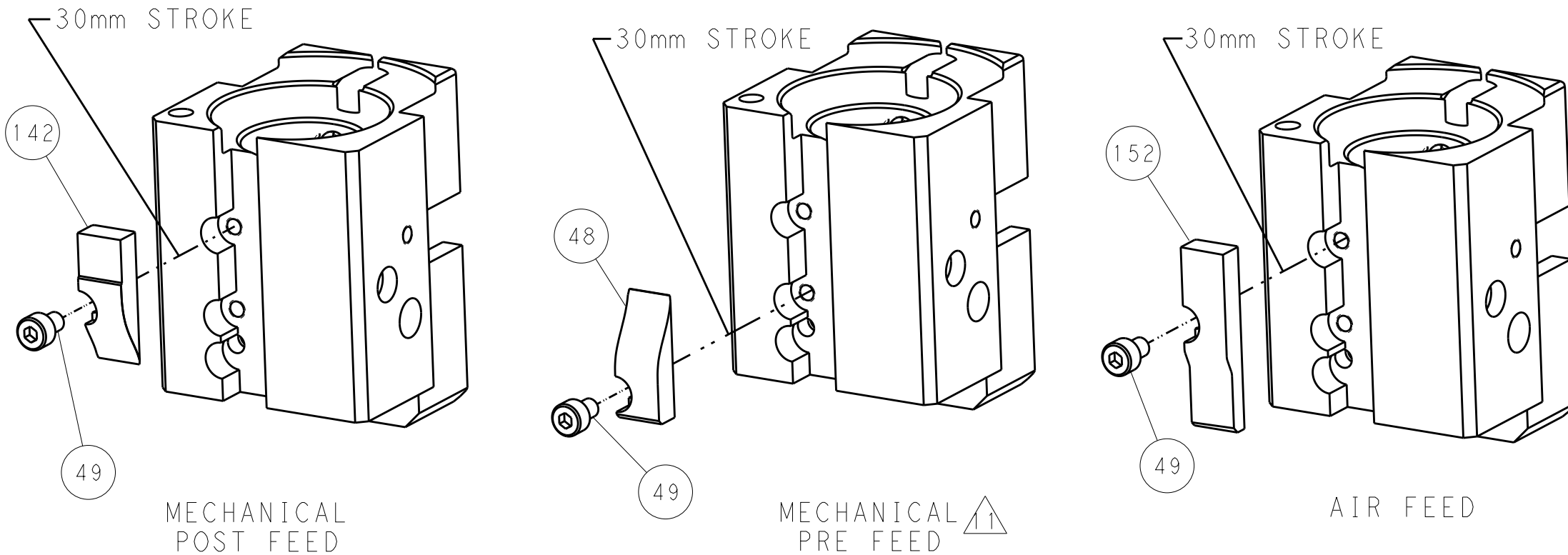


RAM SET-UP

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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DIMENSIONS: mm				TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.5 1 PLC ±.13 2 PLC ±.013 3 PLC ±.001 4 PLC ±.001 ANGLES FINISH				NAME Ocean End Feed Applicator			
MATERIAL				WEIGHT				SIZE A1 00779 C=2150189			
				Customer Accessible Production Drawing				SCALE 1:1 SHEET 4 OF 4 REV B			