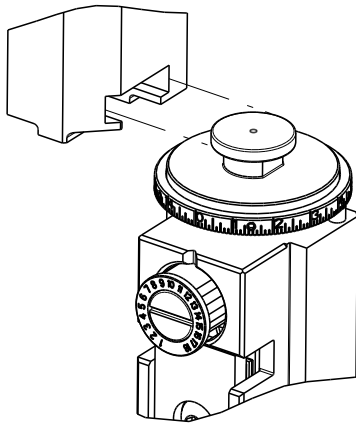


8		7	
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20		20	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150256-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150256-2	B	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150256-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	3.55 mm [.140]	F
INSUL	4.06 mm [.160]	F
APPLICATOR INSTRUCTIONS 408-35043		

TERMINAL DATA: METALLON TERMINAL TE CRIMP SPECIFICATION			
TERMINAL NAME: TERMINAL RING			
WIRE STRIP LENGTH .185-.200 IN [4.70-5.08 mm]		INSULATION DIAMETER RANGE Ø.060-.113 IN [1.52-2.87 mm]	
TERMINAL APPLICATION SPECIFICATION	114-2065	-	-
TERMINALS APPLIED			
TE TERMINAL	METALLON TERMINAL	TE TERMINAL	LEAR TERMINAL
2113265-1	139-6914	2113265-2	101614-K02
2113265-3	139-6913	2113265-4	101617-K02
2113265-5	101614-K01	2113265-6	101614-K17
2113265-7	101620-K01	2113265-8	101620-K02
2113265-9	101620-K17	1-2113265-0	101617-K01
1-2113265-1	101617-K17	1-2113265-2	101619-K01
1-2113265-3	101619-K02	1-2113265-4	101619-K17
1-2113265-5	101625-K01	1-2113265-6	101625-K02
1-2113265-7	101625-K17	1-2113265-8	101626-K01
1-2113265-9	101626-K02	2-2113265-0	101626-K17

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING
18 AWG		1.91+/-0.05 [0.075+/-0.002]		2.6
20 AWG		1.80+/-0.05 [0.071+/-0.002]		4.0



- 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.
- 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.

*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)

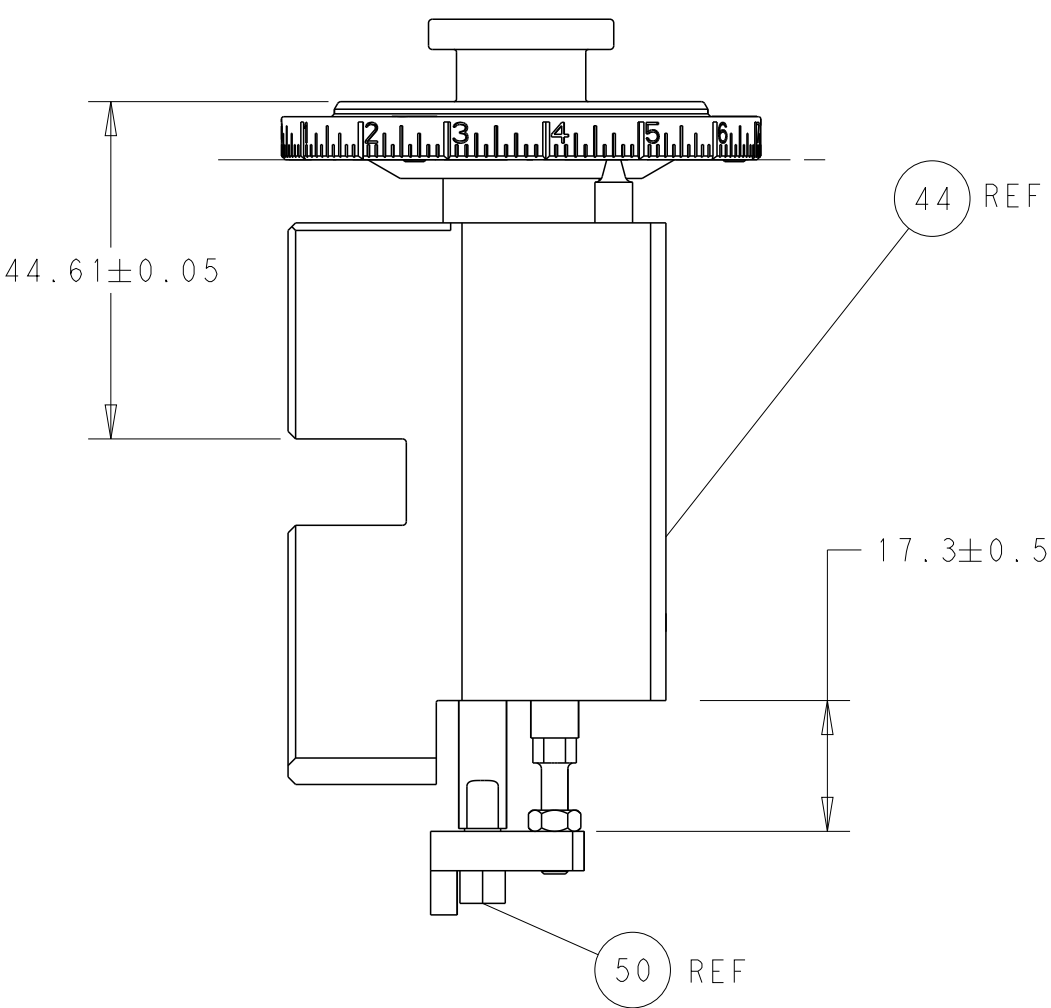
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LOC	DIST	REVISIONS						
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			A1	ECR-15-004154		19MAR2015	KH	UG
			A2	ECR-18-015532		29SEP2018	FZ	KZ
			B	ECR-18-017906		14NOV2018	TB	CT

	-	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
3	-	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	2063440-1	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	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
	-	1	1	1901681-5	HOLDDOWN, TERMINAL	65
	-	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	2-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 14	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	2119792-2	PAWL, EF, AIR	51
3	-	1	1	1752354-2	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
	-	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	1803292-1	DRAG	20
	-	1	1	1901696-3	STRIP GUIDE, REAR	19
	-	1	1	1901695-3	STRIP GUIDE, FRONT	18
	-	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17
	-	1	1	1752360-1	SPACER,HOLD-DOWN	13
1	-	1	1	240644-1	PLATE, REAR SHEAR	11
	-	-	-	-	-	10
1	-	1	1	690482-1	PLATE, FRONT SHEAR	9
1	1	2	1	1803060-1	ANVIL, COMBINATION, END FEED	8
1	-	1	1	690474-2	BLADE, SLUG	7
	-	1	1	7-240641-2	SPACER	5
	-	1	1	238011-2	BLOCK, CRIMPER SPACER	4
1	1	2	1	2-1633961-3	CRIMPER, INSULATION F PREMIUM	3
	-	1	1	455888-3	SPACER, CRIMPER	2
1	1	2	1	456409-3	CRIMPER, WIRE .120 "F" PREMIUM	1
	-77-72	-2		PART NO	DESCRIPTION	ITEM NO

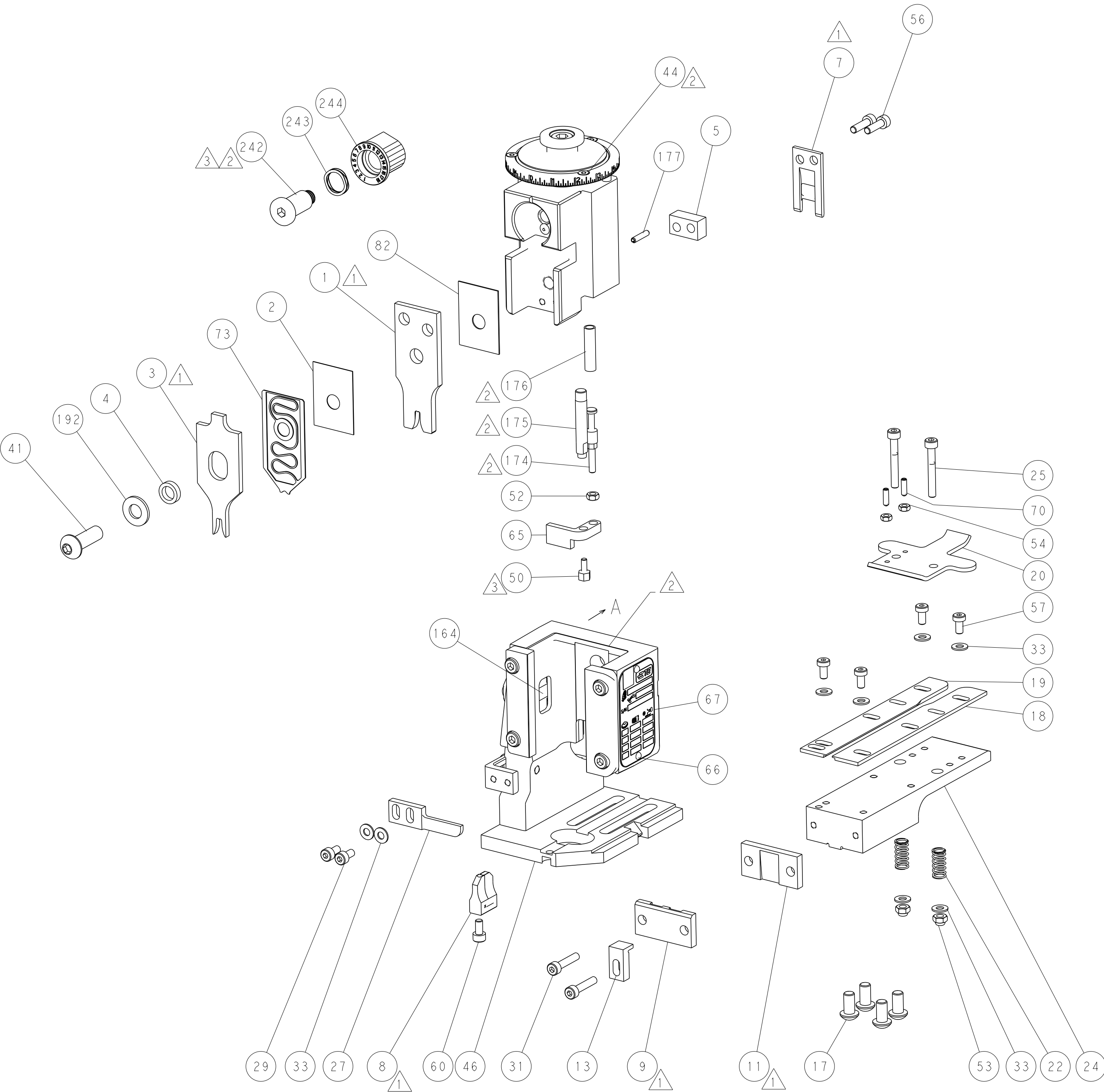
THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. THE USER SHALL BE RESPONSIBLE FOR VERIFYING THE LATEST REVISION. TOLERANCES UNLESS OTHERWISE SPECIFIED:				DWN K. STAKEM CHK G. BAILEY APVD T. ELBIN	03MAY2012 03MAY2012 03MAY2012	TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		NAME		Ocean End Feed Applicator	
		0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH ±		PRODUCT SPEC		SIZE	
MATERIAL		WEIGHT		APPLICATION SPEC		CAGE CODE	
-		-		-		DRAWING NO	
-		-		-		RESTRICTED TO	
-		-		-		A1 00779 ©=2150256	
-		-		Customer Accessible Production Drawing		SCALE 1:1	
-		-		SHEET 1 OF 4		REV B	

SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

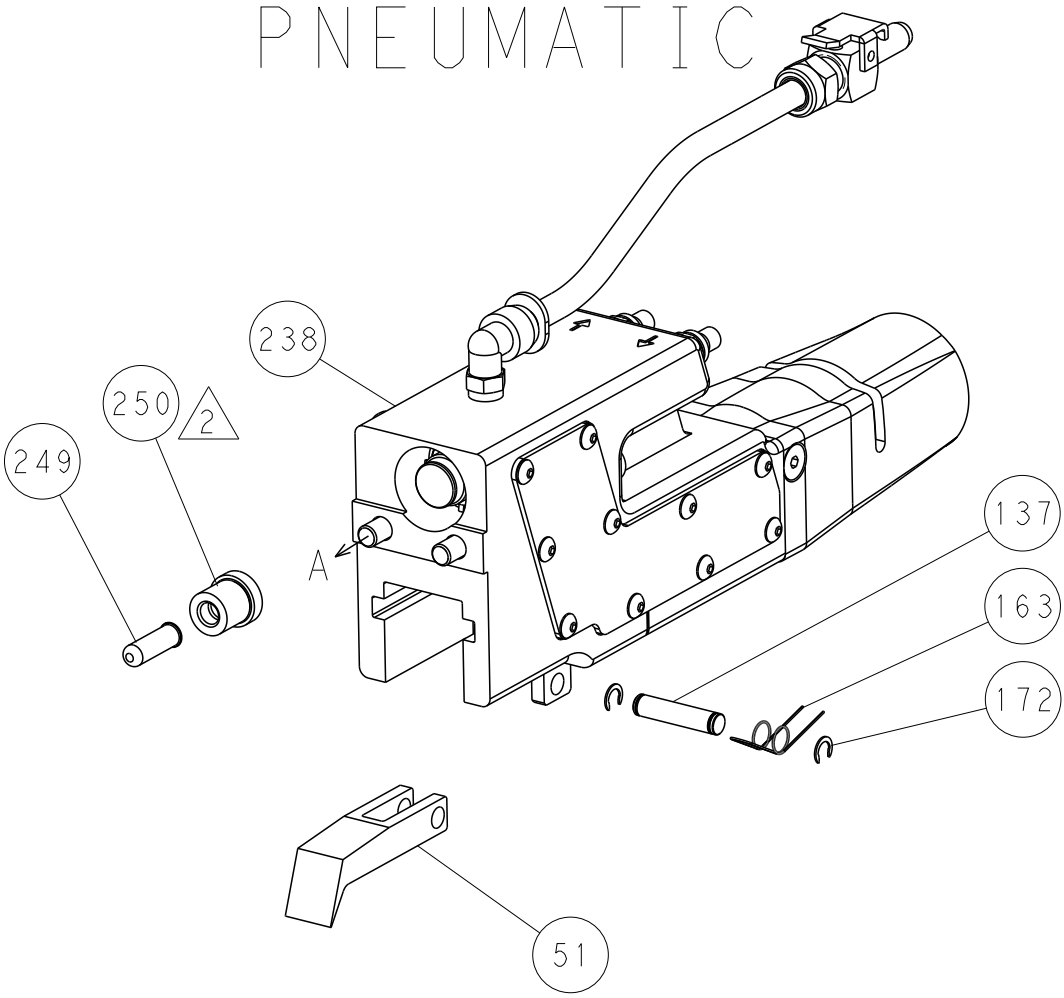
LOC		DIST		REVISIONS					
A		66		P	LTR	DESCRIPTION	DATE	DWN	APVD
				-	-	SEE SHEET 1	-	-	-



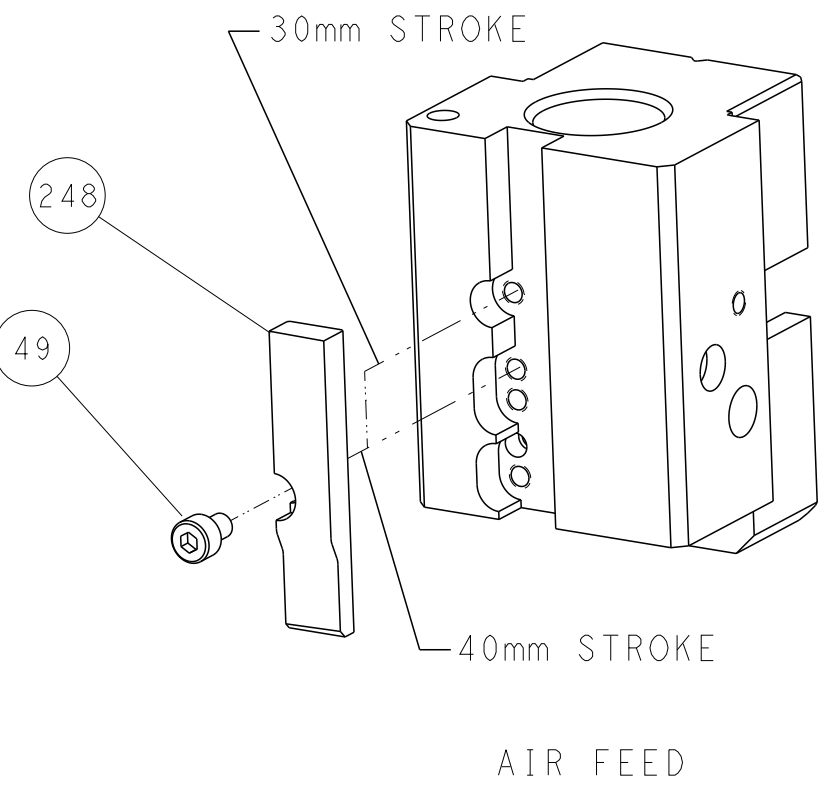
RAM AND HOLDDOWN SET-UP



FEED TYPE
PNEUMATIC



CAM POSITION

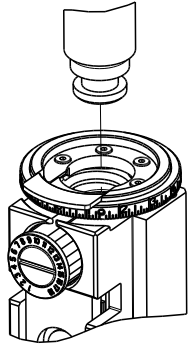


ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE WITHOUT NOTICE AND THE USER ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST REVISION.				DWN K. STAKEM 03MAY2012	TE Connectivity Harrisburg, PA 17105-3608	
				CHK G. BAILEY 03MAY2012		
				APVD T. ELBIN 03MAY2012	NAME Ocean End Feed Applicator	
				PRODUCT SPEC		
				APPLICATION SPEC		
				SIZE	CAGE CODE	DRAWING NO
				A1	00779	C=2150256
				WEIGHT	-	
				Customer Accessible Production Drawing	SCALE	1:1
					SHEET	2 of 4
					REV	B

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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150256-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150256-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	3.55 mm [.140]	F
INSUL	4.06 mm [.160]	F
APPLICATOR INSTRUCTIONS 408-35043		

TERMINAL DATA: METALLON TERMINAL TE CRIMP SPECIFICATION			
TERMINAL NAME: RING TERMINAL			
WIRE STRIP LENGTH 4.70 - 5.08mm [.185-.200 IN]		INSULATION DIAMETER RANGE Ø 1.52-2.87mm [.060 - .113]	
TERMINAL APPLICATION SPECIFICATION	114-2065	-	-
TERMINALS APPLIED			
TE TERMINAL	METALLON TERMINAL	TE TERMINAL	LEAR TERMINAL
2113265-1	139-6914	2113265-2	101614-K02
2113265-3	139-6913	2113265-4	101617-K02
2113265-5	101614-K01	2113265-6	101614-K17
2113265-7	101620-K01	2113265-8	101620-K02
2113265-9	101620-K17	1-2113265-0	101617-K01
1-2113265-1	101617-K17	1-2113265-2	101619-K01
1-2113265-3	101619-K02	1-2113265-4	101619-K17
1-2113265-5	101625-K01	1-2113265-6	101625-K02
1-2113265-7	101625-K17	1-2113265-8	101626-K01
1-2113265-9	101626-K02	2-2113265-0	101626-K17

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
18 AWG	1.91+/-0.05 [.075+/-0.002]	2.6
20 AWG	1.80+/-0.05 [.071+/-0.002]	4.0



- 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.

*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)

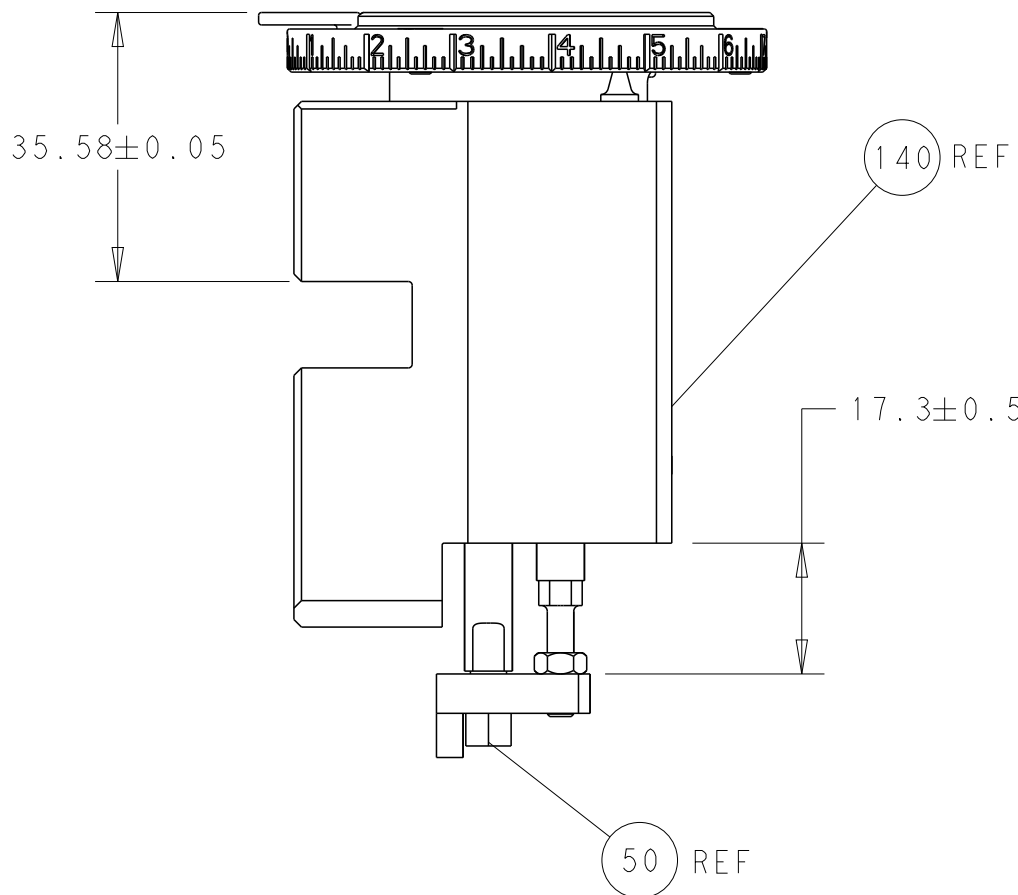
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A		66		P	LTR	DESCRIPTION	DATE
						SEE SHEET 1	-
							-
							-
							-

-	1	2119640-1	PUSH ROD, AIR FEED	250
-	1	1803259-1	BUSHING, FLANGED	249
-	1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	2063440-1	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	2119791-9	DEPRESSOR, WIRE	73
-	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	1901681-5	HOLDDOWN, TERMINAL	65
-	4	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57
-	2	2-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 14	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	2119792-2	PAWL, EF, AIR	51
-	1	1752354-2	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
-	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	1803292-1	DRAG	20
-	1	1901696-3	STRIP GUIDE, REAR	19
-	1	1901695-3	STRIP GUIDE, FRONT	18
-	1	1752360-1	SPACER,HOLD-DOWN	13
-	1	240644-1	PLATE, REAR SHEAR	11
-	-	-	-	10
-	1	690482-1	PLATE, FRONT SHEAR	9
-	1	1803060-1	ANVIL, COMBINATION, END FEED	8
-	1	690474-2	BLADE, SLUG	7
-	1	7-240641-2	SPACER	5
-	1	238011-2	BLOCK, CRIMPER SPACER	4
-	1	2-1633961-3	CRIMPER, INSULATION F PREMIUM	3
-	1	455888-3	SPACER, CRIMPER	2
-	1	456409-3	CRIMPER, WIRE .120 "F" PREMIUM	1

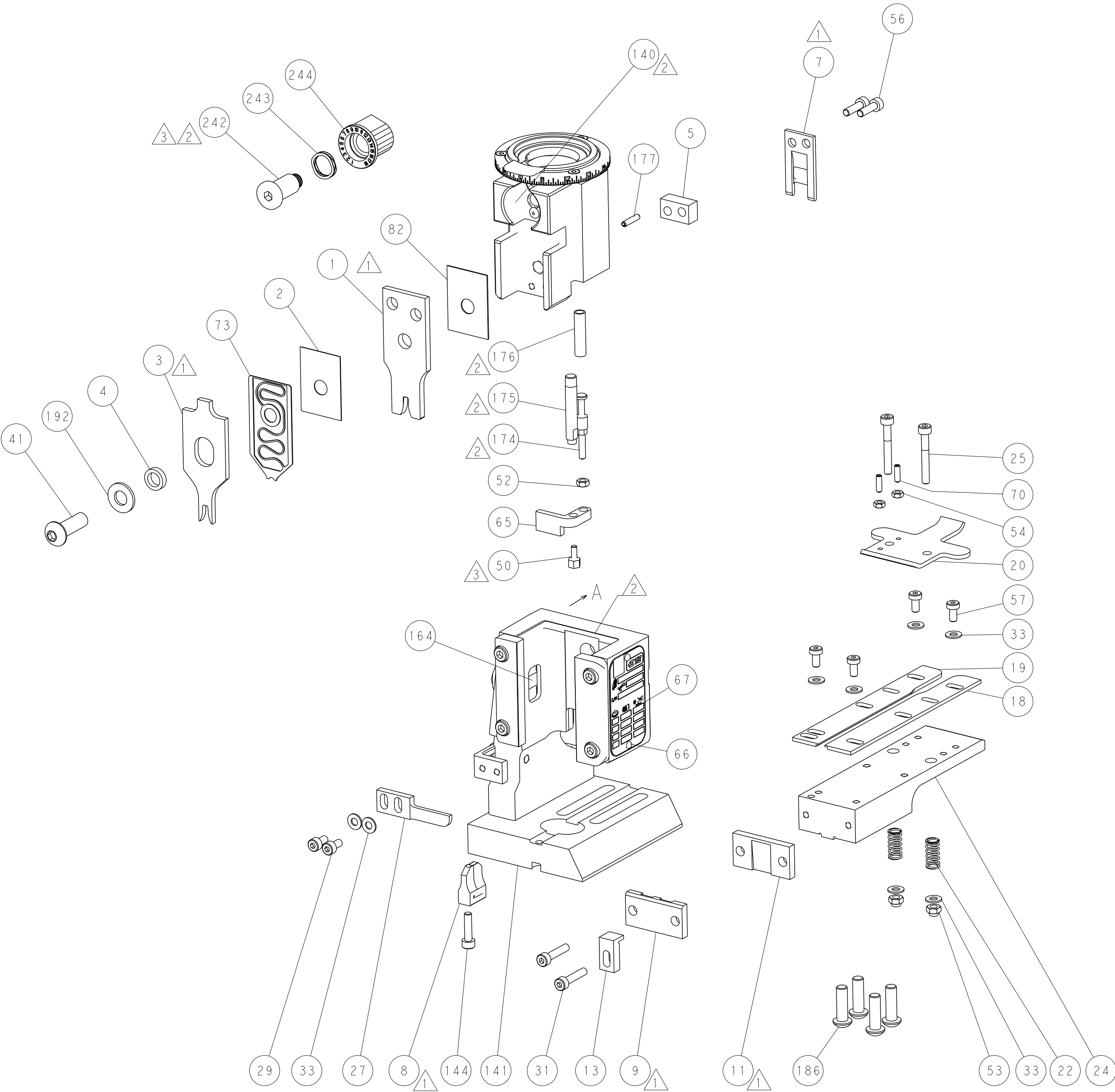
-77-22		PART NO	DESCRIPTION		ITEM NO
DWN R. STAKEM CHK G. BAILEY APVD T. ELBIN		03MAY2012 03MAY2012 03MAY2012	TE Connectivity Harrisburg, PA 17105-3608		
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH	NAME Ocean End Feed Applicator		
MATERIAL -		WEIGHT -	SIZE A	CAGE CODE 00779	DRAWING NO C=2150256
		Customer Accessible Production Drawing		SCALE 1:1	SHEET 3 OF 4
				REV B	

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

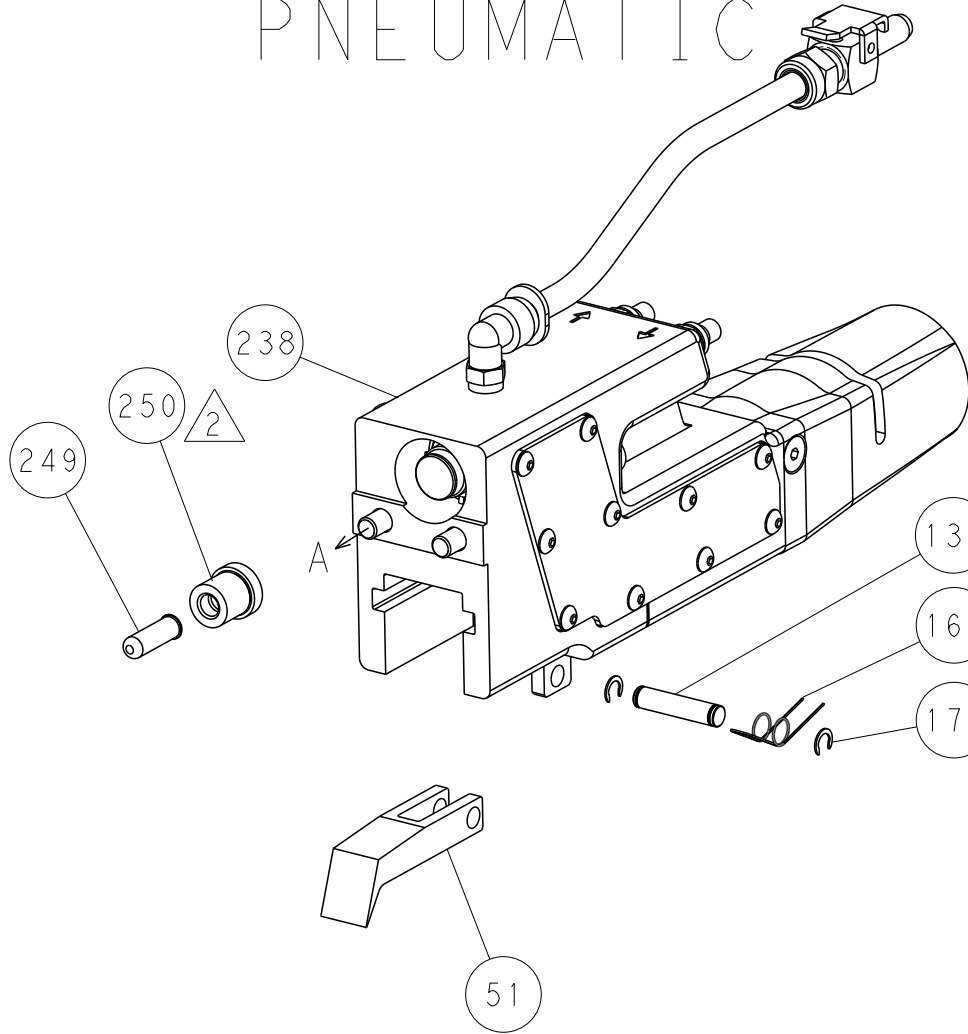
LOC	DIST	REVISIONS					
		P	LTR	DESCRIPTION	DATE	DWN	APVD
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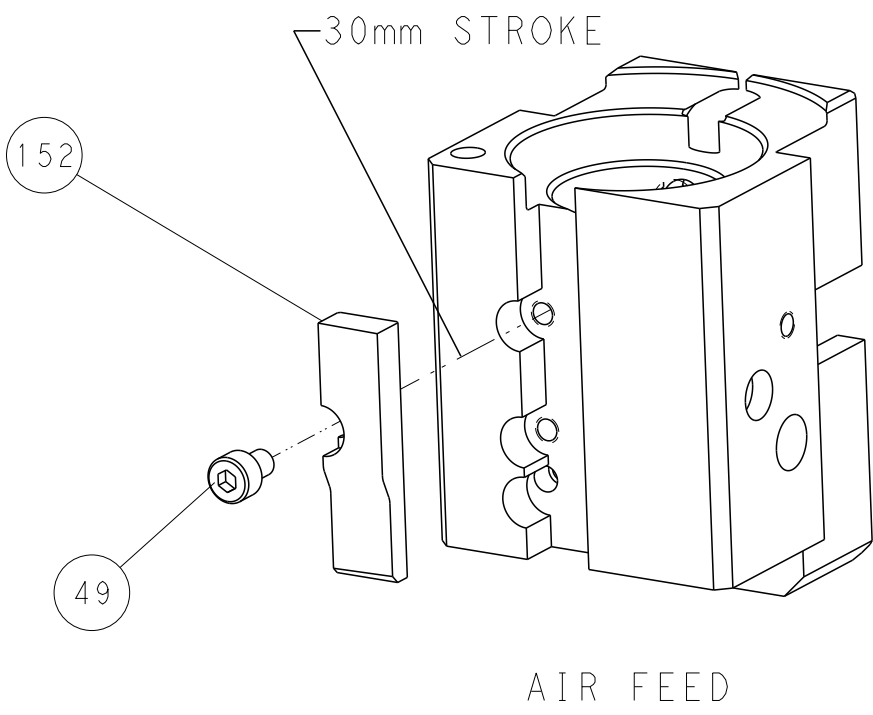
RAM AND HOLDDOWN SET-UP



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)

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				CHK G. BAILEY	03MAY2012		
				APVD T. ELBIN	03MAY2012	NAME Ocean End Feed Applicator	
				PRODUCT SPEC			
				APPLICATION SPEC			
				WEIGHT		RESTRICTED TO	
				Customer Accessible Production Drawing		-	
				SCALE		SHEET	
				1:1		4	
				REV		B	