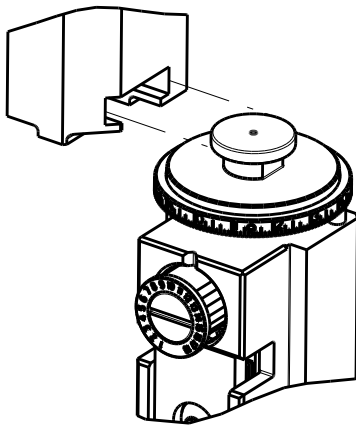
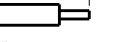


8		7	
THIS DRAWING IS UNPUBLISHED.		RELEASED FOR PUBLICATION	
20		20	
© COPYRIGHT 20 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.			
PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150356-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2150356-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150356-1	B	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2150356-2	B	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150356-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	3.05 mm [.120]	F
INSUL	4.57 mm [.180]	Ø
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: RING			
WIRE STRIP LENGTH 3.18-3.18 mm [.125-.125 IN]		 INSULATION DIAMETER RANGE Ø2.54-3.43 mm [.100-.135 IN]	
TERMINAL APPLICATION SPECIFICATION	114-2084	-	-
	-	-	-
TERMINALS APPLIED 			
TE TERMINAL 61386-1	TE TERMINAL 61386-2	TE TERMINAL	TE TERMINAL

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING
16 AWG		1.83+/-0.05 [.072+/- .002]		5.0
18 AWG		1.68+/-0.05 [.066+/- .002]		6.5
20 AWG		1.60+/-0.05 [.063+/- .002]		7.5



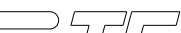
- 1 RECOMMENDED SPARE PARTS
- 2 REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- 3 APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242.
- 4 CRIMP HEIGHT REFERENCE SETTING WAS THE SETTING USED WHEN THE APPLICATOR WAS QUALIFIED AT THE FACTORY. ADJUSTMENT 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.

*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)

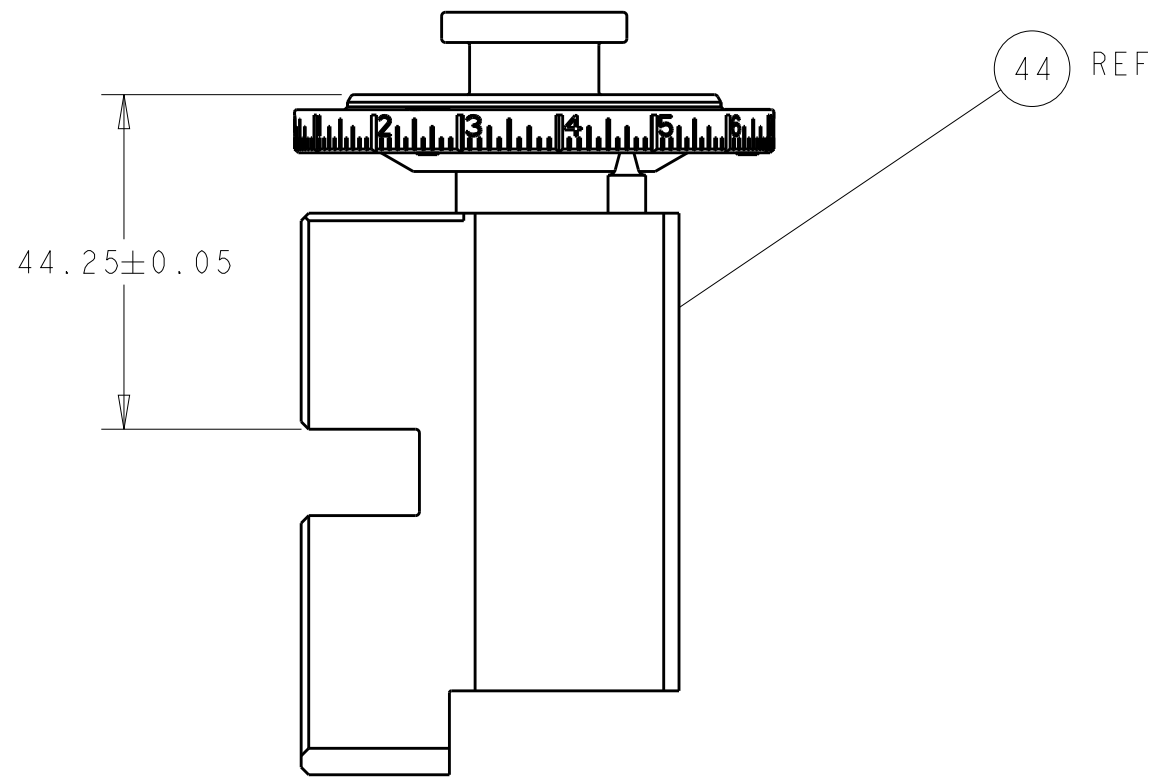
LOC	DIST	REVISONS			
A	66	P	LTR	DESCRIPTION	DATE DWN APVD
		I		DEVELOPMENT	31JUL2013 CC UG
		A		RELEASED	05SEP2013 BH BH
		B		ECR-19-000718	16JAN2019 MZ YY

-	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
-	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	2119955-2	ASSY, LUBRICATOR, END FEED	84
-	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	2168083-5	SCR, SKT HD CAP, RoHS, M4 X 6.0	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	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	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	1-1901696-2	STRIP GUIDE, REAR	19
-	1	1	1	1	1-1901695-2	STRIP GUIDE, FRONT	18
-	4	4	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17
-	1	1	1	1	240644-1	PLATE, REAR SHEAR	11
-	-	-	-	-	-	-	10
-	1	1	1	1	690482-1	PLATE, FRONT SHEAR	9
-	1	2	2	1	7-1633384-5	ANVIL, COMBINATION	8
-	1	1	1	1	2217206-1	BLADE, SLUG	7
-	-	-	-	-	-	-	6
-	1	1	1	1	1-240641-9	SPACER	5
-	1	1	1	1	238011-2	BLOCK, CRIMPER SPACER	4
-	1	2	2	1	6-2119784-0	CRIMPER, INSULATION O PREMIUM	3
-	1	1	1	1	455888-1	SPACER, CRIMPER	2
-	1	2	2	1	456409-2	CRIMPER, WIRE .120 "F" PREMIUM	1
-	77-72-71	-	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 EDITION. SHOULD BE CONTACTED FOR THE LATEST EDITION.				DWN C. CHEN 31JUL2013	 TE Connectivity Harrisburg, PA 17105-3608				
				CHK U. GUO 31JUL2013					
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		APVD J. CRUZ 31JUL2013	NAME	Ocean End Feed Applicator -			
		0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH ±		PRODUCT SPEC -					
				APPLICATION SPEC -	SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO	
MATERIAL -				WEIGHT -	A1	00779	C=2150356	-	
Customer Accessible Production Drawing						SCALE	1:1	SHEET 1 OF 4	REV B

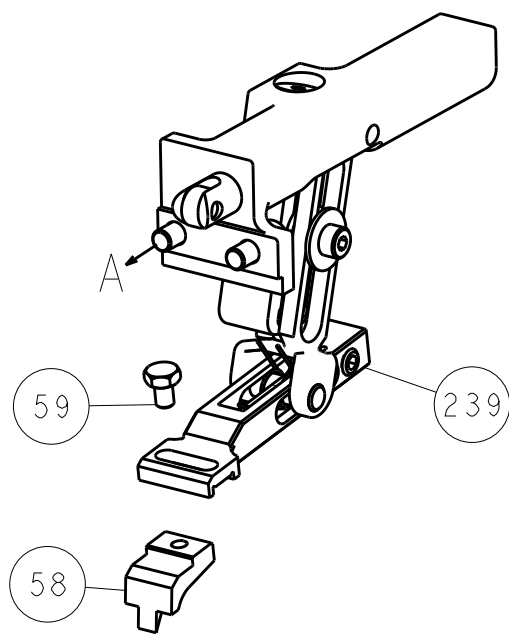
SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

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

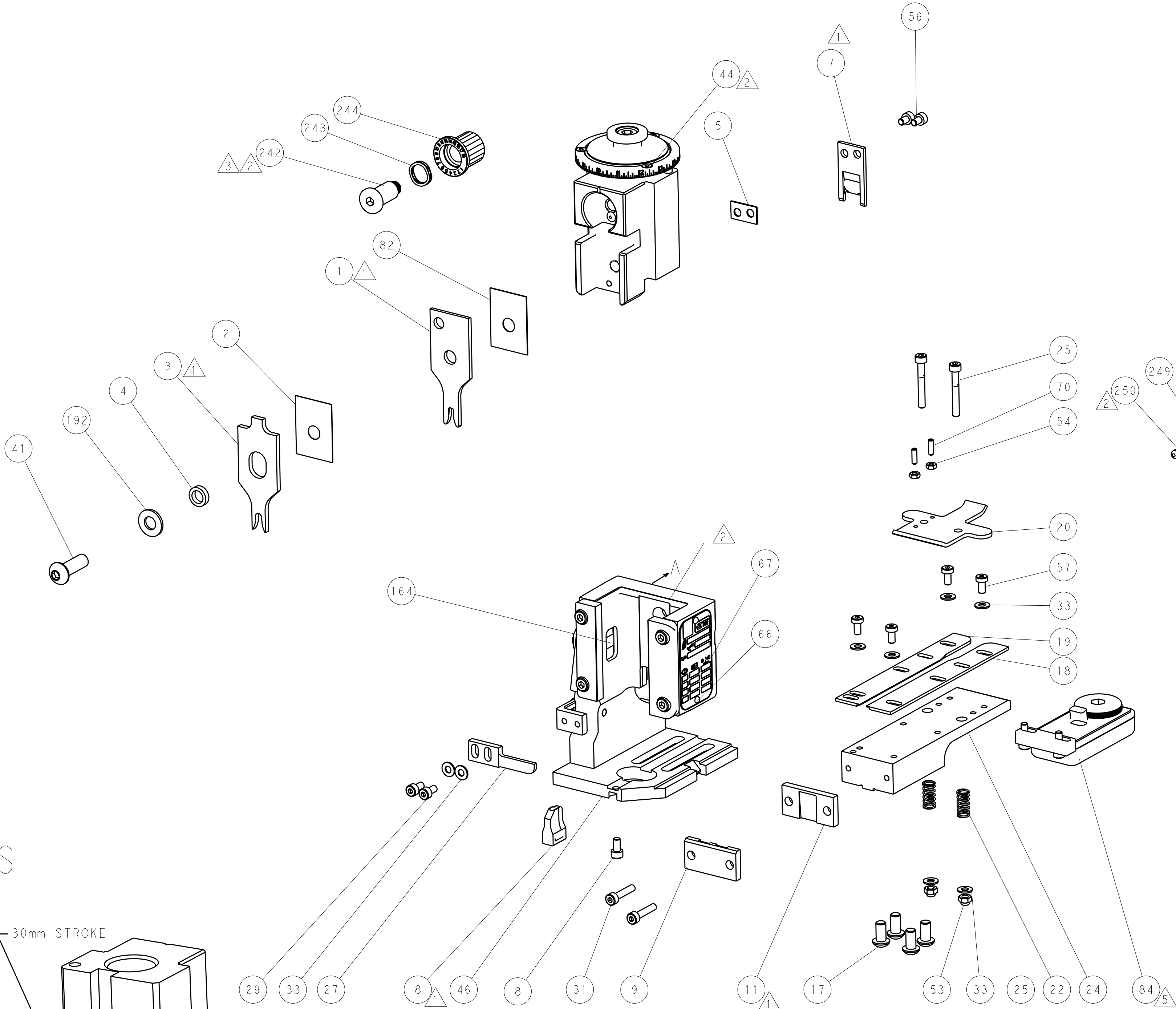
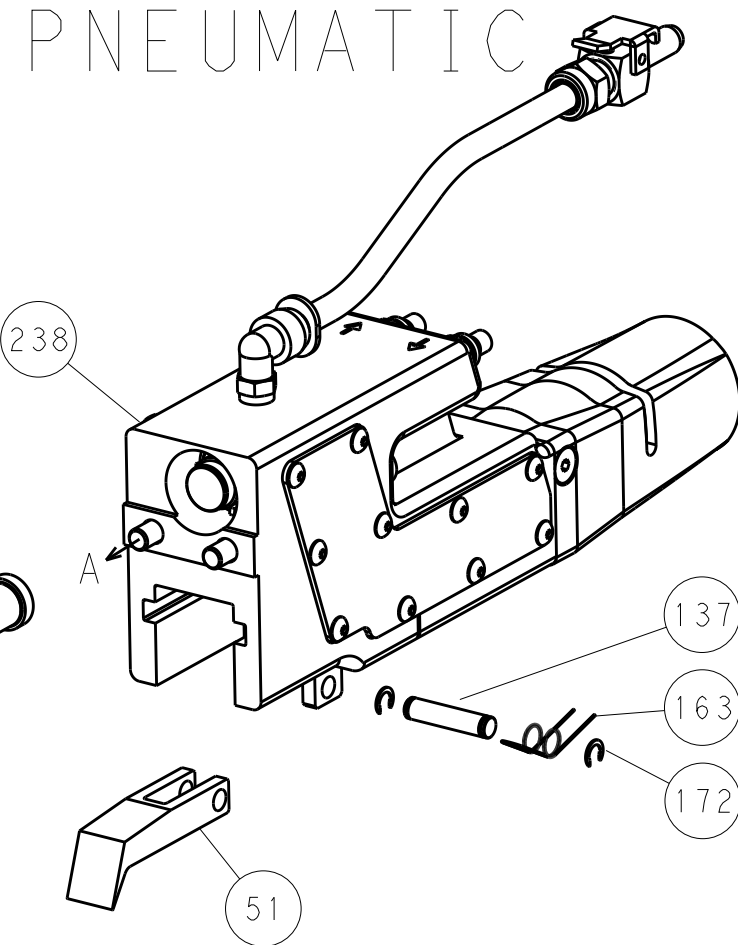


RAM SET-UP

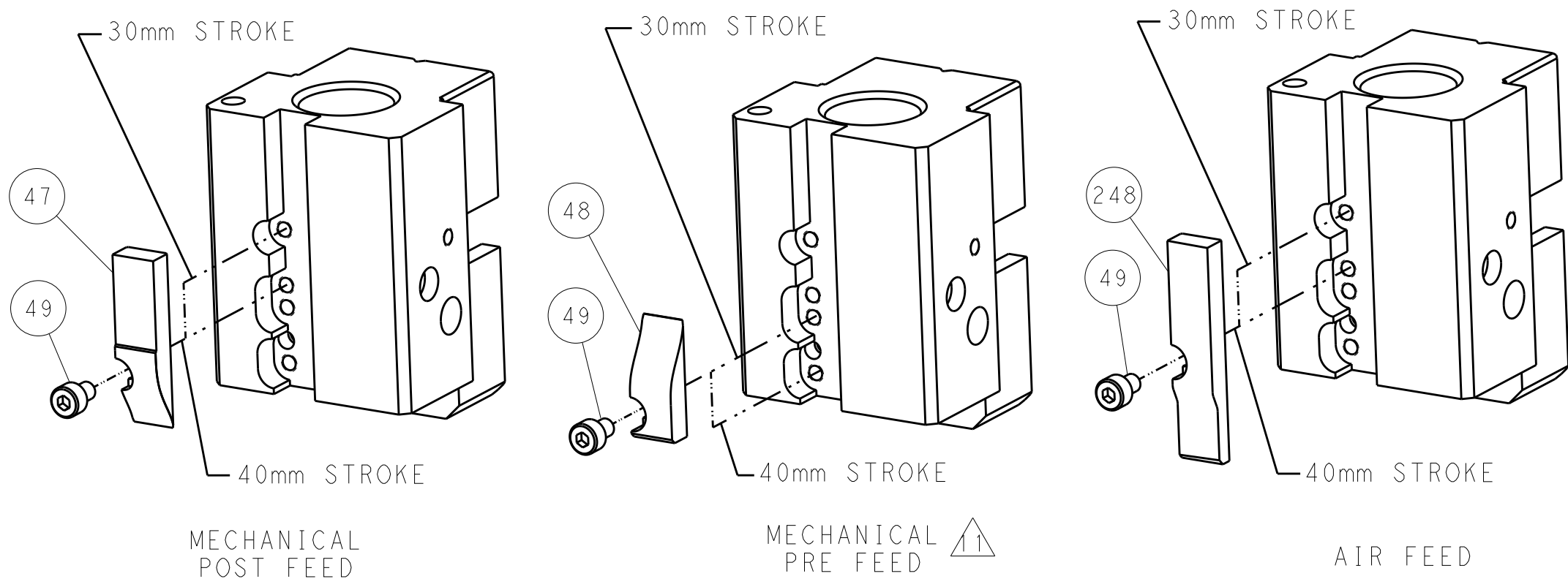
FEED TYPE
MECHANICAL



PNEUMATIC



CAM POSITIONS

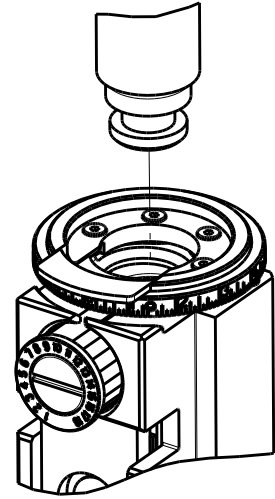


ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

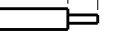
THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. IT IS SUBJECT TO CHANGE WITHOUT NOTICE.				OWN				TE Connectivity			
DIMENSIONS:				C. CHEN				Harrisburg, PA 17105-3608			
mm				U. GUO				NAME			
TOLERANCES UNLESS OTHERWISE SPECIFIED:				I. CRUZ				Ocean End Feed Applicator			
0 PLC ±				PRODUCT SPEC				SIZE			
1 PLC ±				APPLICATION SPEC				CAGE CODE			
2 PLC ±				WEIGHT				DRAWING NO			
3 PLC ±				Customer Accessible Production Drawing				©=2150356			
4 PLC ±				SCALE				SHEET			
ANGLES				1:1				2 of 4			
FINISH				REV				B			

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
2-2150356-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2150356-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150356-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	3.05 mm [.120]	F
INSUL	4.57 mm [.180]	O
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: RING			
WIRE STRIP LENGTH 3.18-3.18 mm [.125-.125 IN]		 INSULATION DIAMETER RANGE Ø2.54-3.43 mm [.100-.135 IN]	
TERMINAL APPLICATION SPECIFICATION	114-2084	-	-
		-	-
TERMINALS APPLIED 			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
61386-1	61386-2		

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING
16 AWG		1.83+/-0.05 [.072+/- .002]		5.0
18 AWG		1.68+/-0.05 [.066+/- .002]		6.5
20 AWG		1.60+/-0.05 [.063+/- .002]		7.5



- 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.

*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.

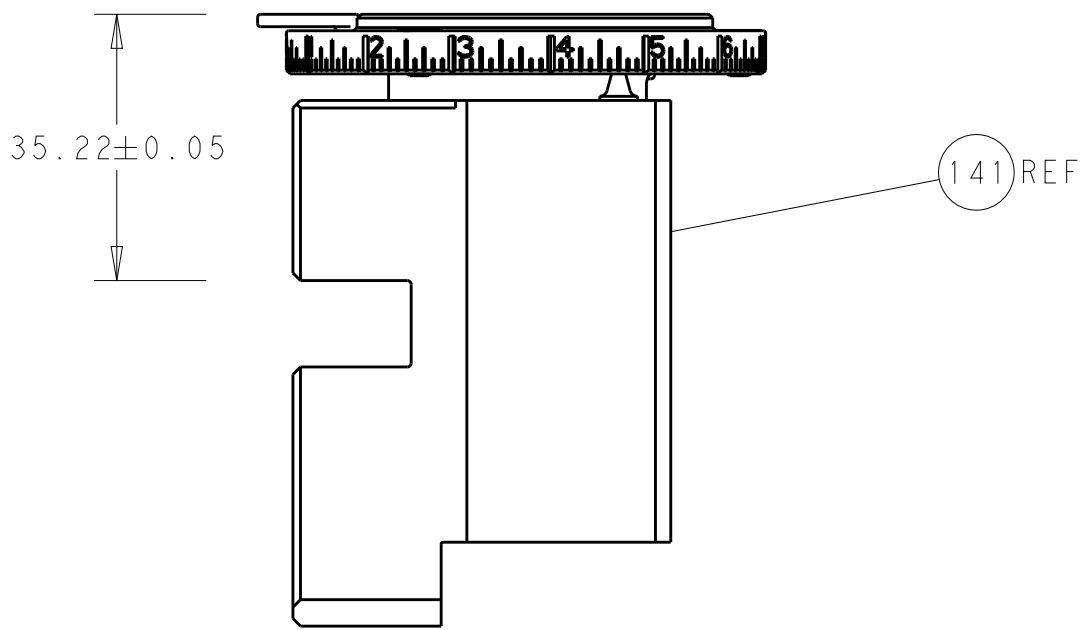
PACIFIC VERSION
Shown on sheets 3 of 4 & 4 of 4
(Atlantic version shown on sheets 1 of 4 & 2 of 4)

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

-	1	-	2119640-1	PUSH ROD, AIR FEED	250
-	1	-	1803259-1	BUSHING, FLANGED	249
-	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	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	-	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172
-	REFREF		994970-2	COUNTER, MAGNETIC	164
-	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	-	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854	137
-	1	1	2119955-2	ASSY, LUBRICATOR, END FEED	84
-	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	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	2168083-5	SCR, SKT HD CAP, RoHS, M4 X 6.0	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	2168083-9	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	1803292-4	DRAG	20
-	1	1	1-1901696-2	STRIP GUIDE, REAR	19
-	1	1	1-1901695-2	STRIP GUIDE, FRONT	18
-	1	1	240644-1	PLATE, REAR SHEAR	11
-	-	-	-	-	10
-	1	1	690482-1	PLATE, FRONT SHEAR	9
1	1	1	7-1633384-5	ANVIL, COMBINATION	8
-	1	1	2217206-1	BLADE, SLUG	7
-	-	-	-	-	6
-	1	1	1-240641-9	SPACER	5
-	1	1	238011-2	BLOCK, CRIMPER SPACER	4
1	1	1	6-2119784-0	CRIMPER, INSULATION O PREMIUM	3
-	1	1	455888-1	SPACER, CRIMPER	2
1	1	1	456409-2	CRIMPER, WIRE .120 "F" PREMIUM	1
-	77-22-21		PART NO	DESCRIPTION	ITEM NO

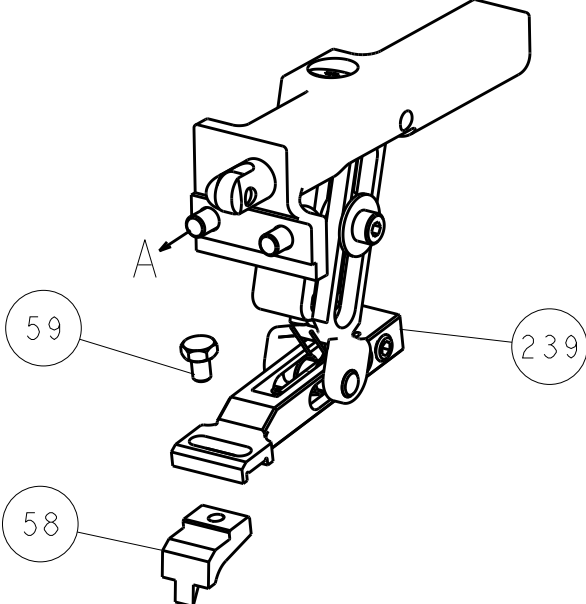
THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. ANY CHANGES TO THIS DRAWING SHOULD BE CONTACTED FOR THE LATEST REVISION.				DWN C. CHEN CHK U. GUO APVD J. CRUZ	31JUL2013 31JUL2013 31JUL2013	 TE Connectivity Harrisburg, PA 17105-3608					
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		NAME		Ocean End Feed Applicator					
		0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		PRODUCT SPEC		SIZE					
MATERIAL		FINISH		APPLICATION SPEC		CAGE CODE		DRAWING NO		RESTRICTED TO	
-		-		WEIGHT		A 00779		C=2150356		-	
Customer Accessible Production Drawing						SCALE		1:1		SHEET 3 OF 4	REV B

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

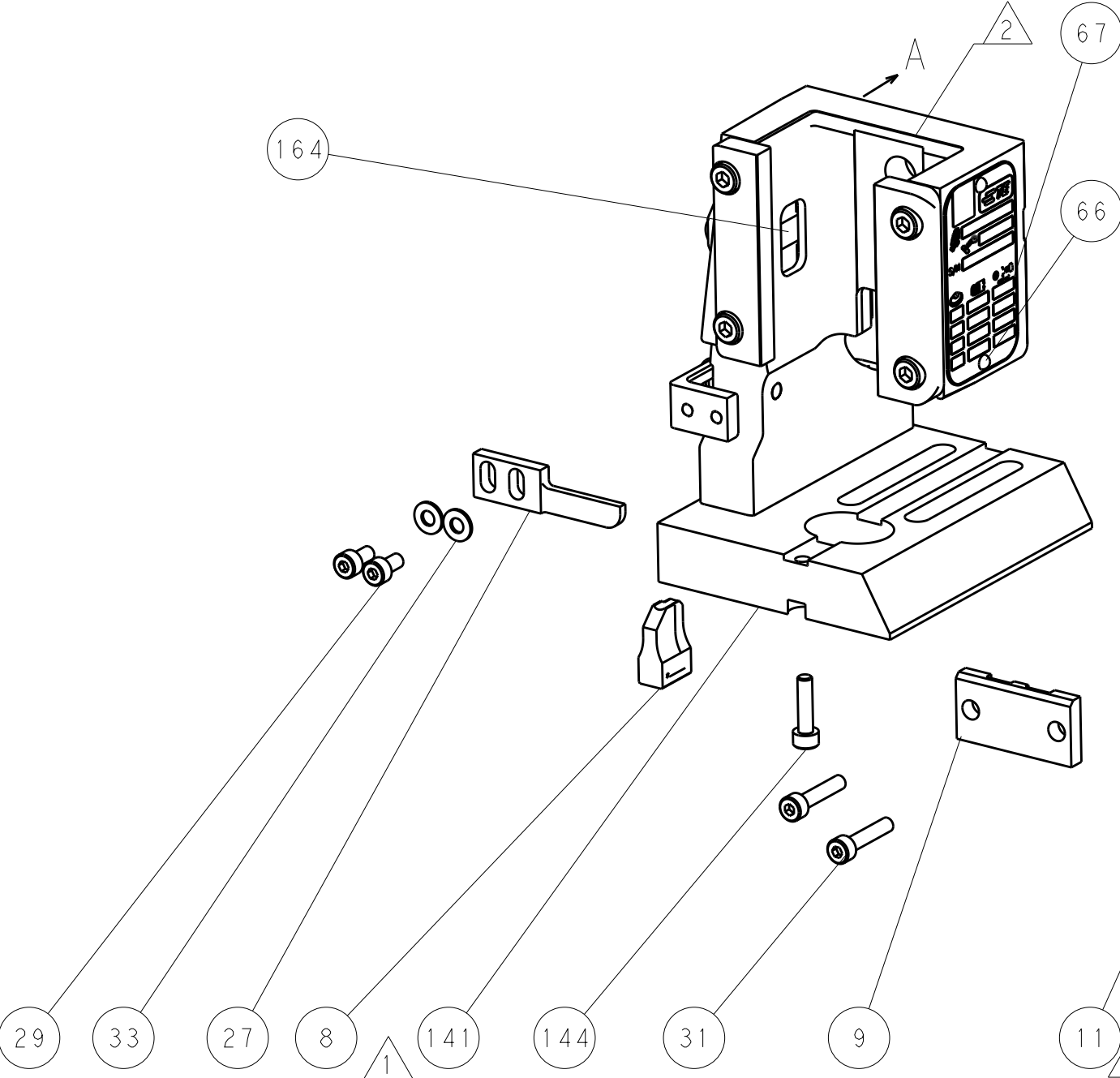
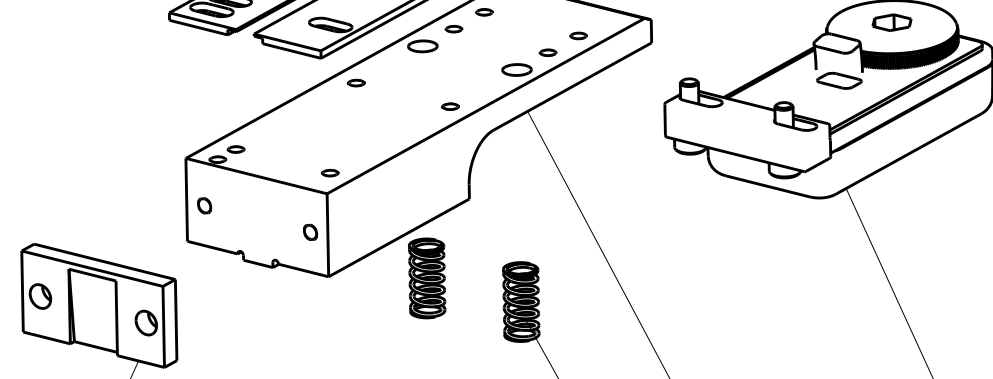
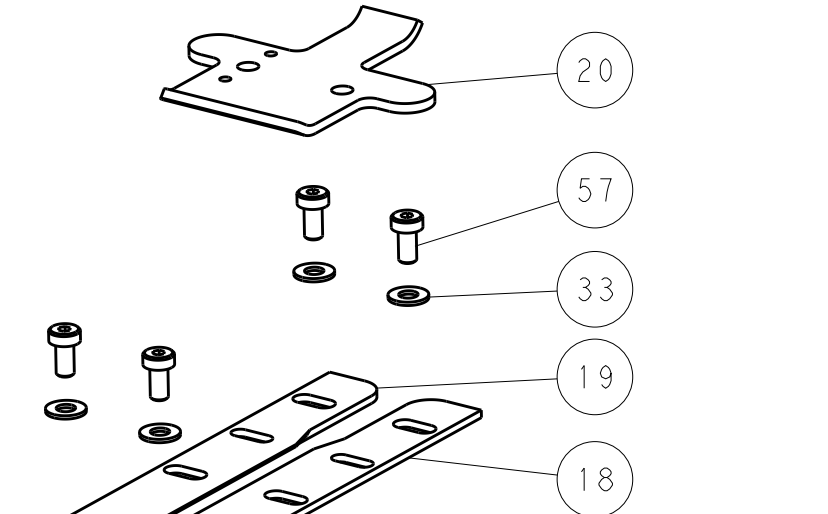
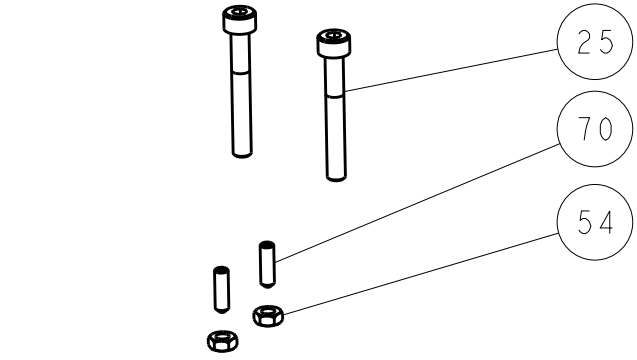
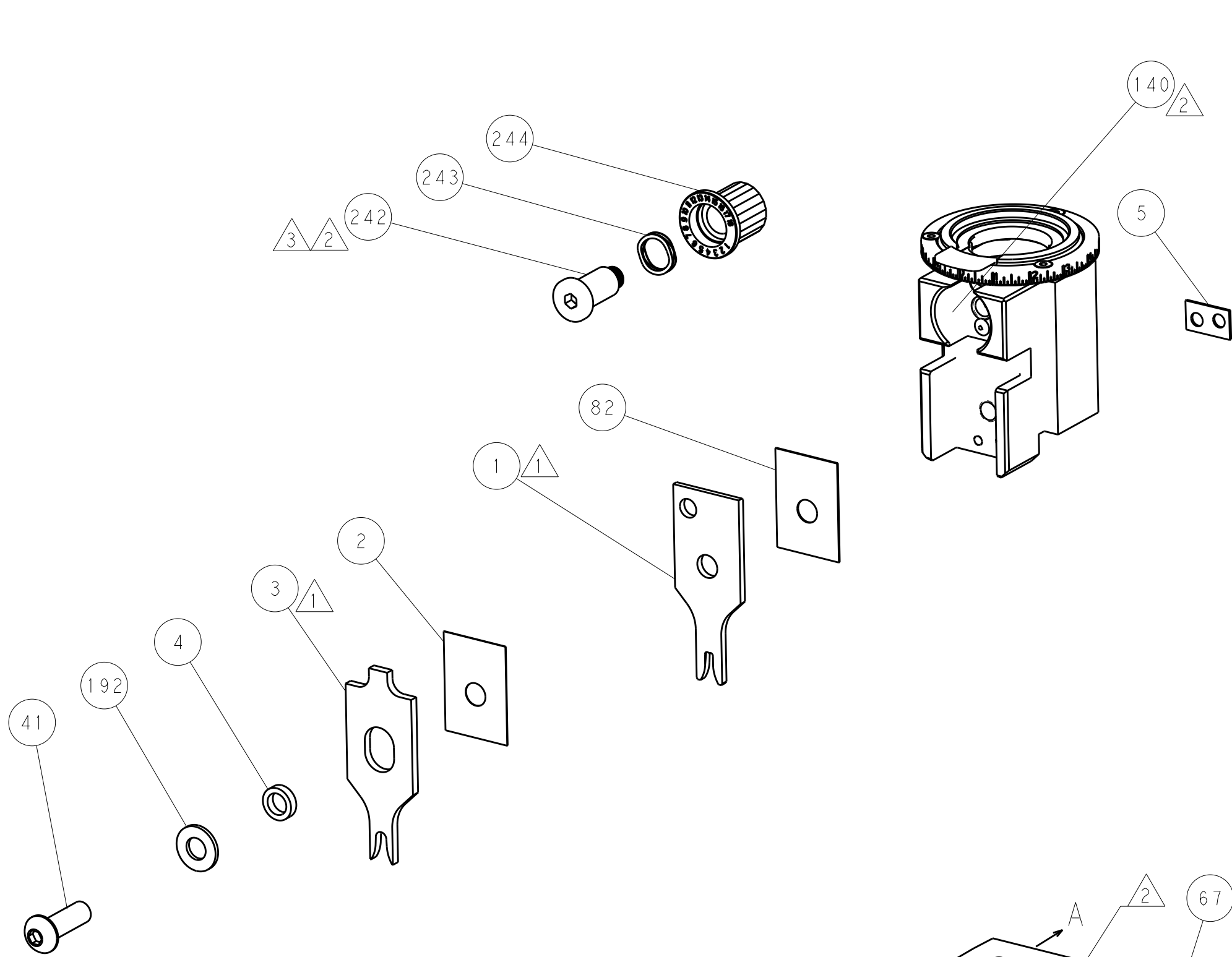
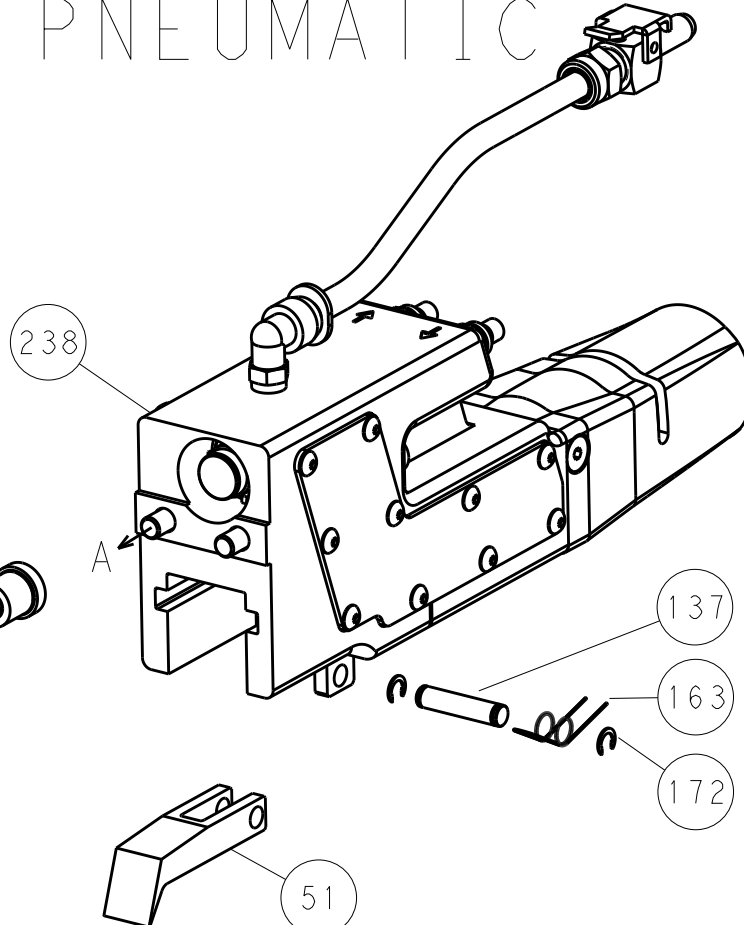


RAM SET-UP

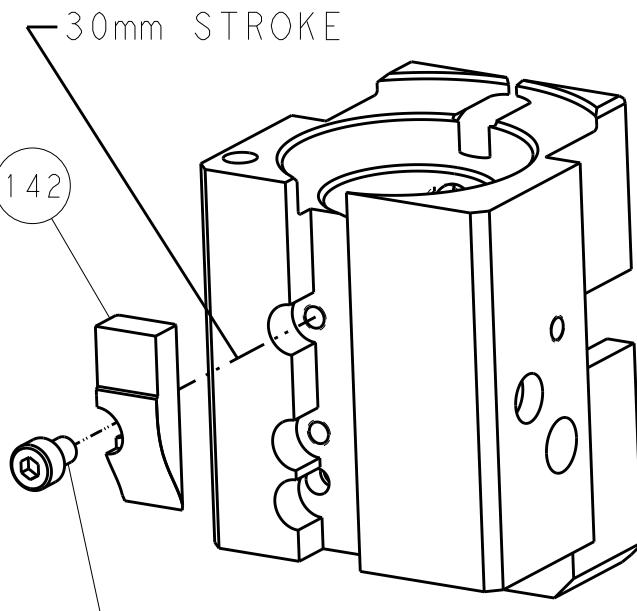
FEED TYPE
MECHANICAL



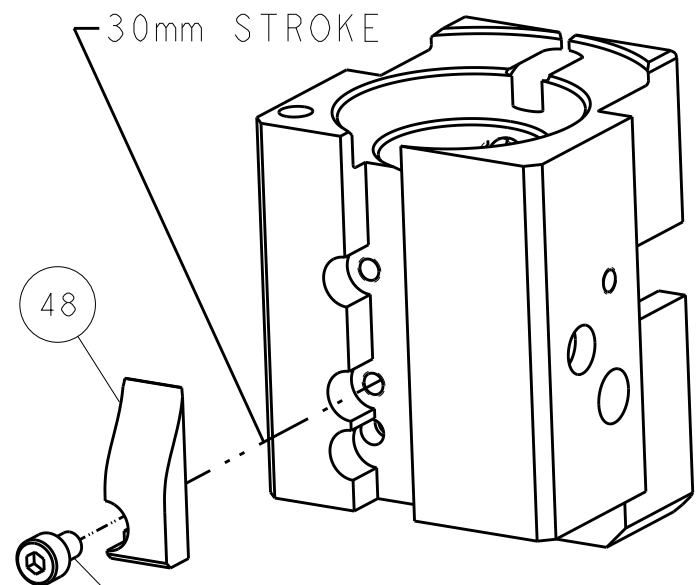
PNEUMATIC



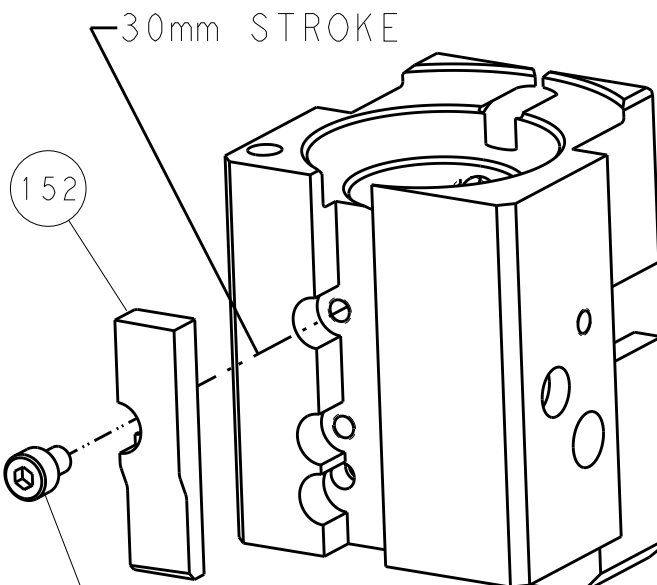
CAM POSITIONS



MECHANICAL
POST FEED



MECHANICAL
PRE FEED



AIR FEED

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

1. THIS DRAWING IS UNPUBLISHED. IT IS THE PROPERTY OF TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. NO PARTS OR SUBASSEMBLIES SHOULD BE CONTACTED FOR THE LATEST NOTATION.				DWN C. CHEN 31 JUL 2013	STE TE Connectivity Harrisburg, PA 17105-3608		
				CHK U. GUO 31 JUL 2013			
				APVD J. CRUZ 31 JUL 2013	NAME Ocean End Feed Applicator		
				PRODUCT SPEC			
				APPLICATION SPEC			
				WEIGHT			
				Customer Accessible Production Drawing			
				SCALE 1:1			
				SHEET 4			
				OF 4			
				REV B			