

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150313-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150313-2	B	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150313-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.79 mm [.110]	F
INSUL	4.06 mm [.160]	F
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: 6.3MM FASTIN-FASTON TAB			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
5.36-5.79 mm [.211-.228 IN]		∅2.40-3.70 mm [.094-.146 IN]	
TERMINAL APPLICATION SPECIFICATION	114-18022	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
928947-1	928947-2	928947-3	928947-4
928947-5	928947-6	928947-7	928947-8

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
2.50mm2	1.97 +/- 0.05 [.078 +/- .002]	6.5
2.00mm2	1.83 +/- 0.05 [.072 +/- .002]	8.2
1.50mm2	1.69 +/- 0.05 [.067 +/- .002]	9.6



- 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. APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 50.
- 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.
- TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.

***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.

LOC	DIST	REVISIONS					
A	66	P	LTN	DESCRIPTION	DATE	OWN	APVD
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		B		ECR-21-117606	18OCT2021	TB	RR

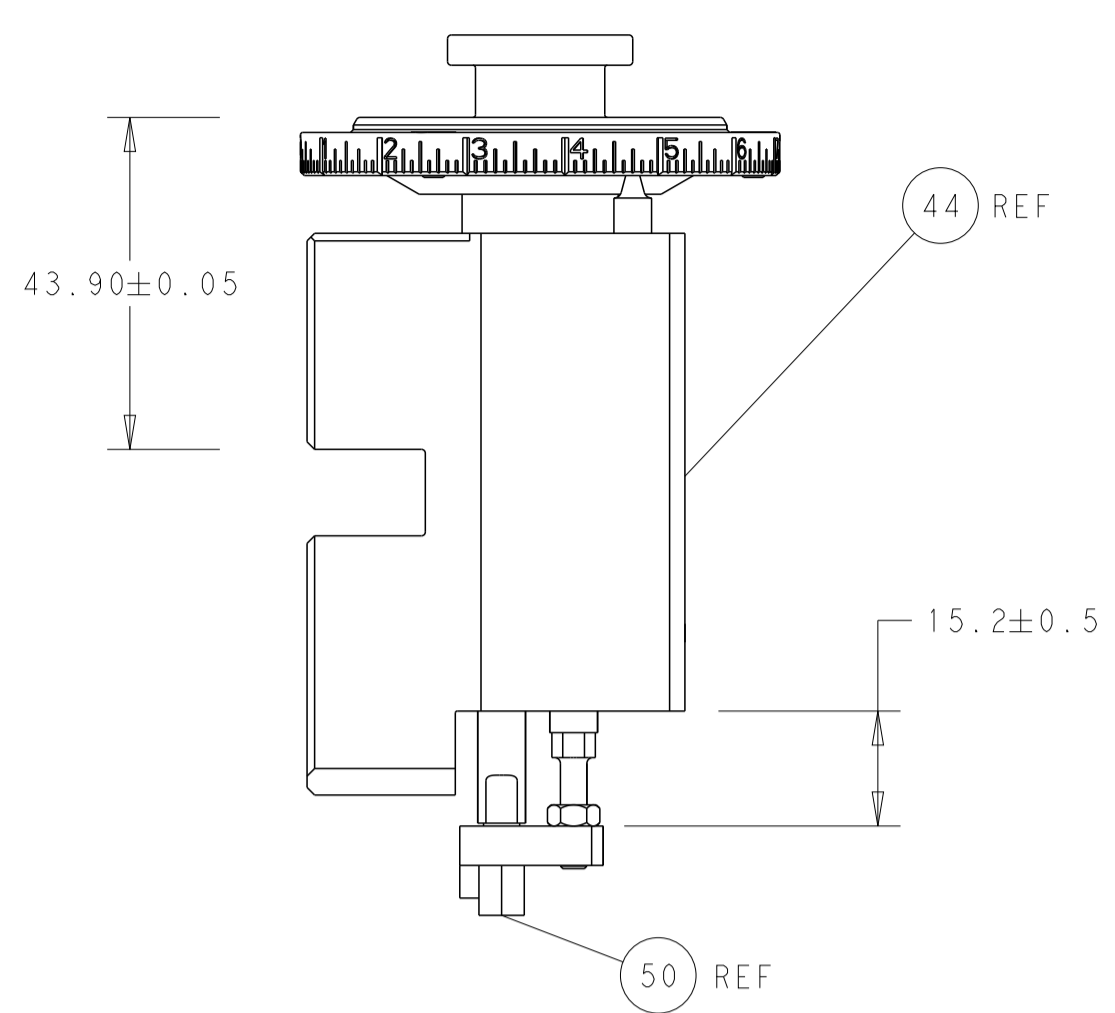
-	2	2	1-2079383-0	SCR, BHSC, RoHS (M3 X 6)	262
-	1	1	1976053-1	LOCATER BLOCK, TERMINAL	261
-	1	1	2119641-1	FEED CAM, AIR FEED	248
-	1	1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	1	2844940-4	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
-	REFREF		994970-2	COUNTER, MAGNETIC	164
-	1	1	455888-7	SPACER, CRIMPER	82
-	1	1	1803607-4	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	1901681-8	HOLDDOWN, TERMINAL	65
-	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
-	4	4	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57
-	2	2	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	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	2063961-1	FEED FINGER	51
-	1	1	1-1752354-1	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	1803292-4	DRAG	20
-	1	1	1-1901696-0	STRIP GUIDE, REAR	19
-	1	1	1-1901695-0	STRIP GUIDE, FRONT	18
-	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17
-	1	1	6-240641-4	SPACER	15
-	1	1	1752360-1	SPACER, HOLD-DOWN	13
-	1	1	240644-9	PLATE, REAR SHEAR	11
-	-	-	-	-	10
-	1	1	3-690482-2	PLATE, FRONT SHEAR	9
-	1	2	1338673-8	ANVIL, COMBINATION	8
-	1	1	1-2217206-0	BLADE, SLUG	7
-	-	-	-	-	6
-	2	2	2-240641-5	SPACER	5
-	1	1	238011-2	BLOCK, CRIMPER SPACER	4
-	1	2	1-1633961-4	CRIMPER, INSULATION F PREMIUM	3
-	1	1	1-455888-3	SPACER, CRIMPER	2
-	1	2	4-1633305-1	CRIMPER, WIRE PREMIUM	1
-	77	72	2	PART NO	ITEM NO
-				DESCRIPTION	

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

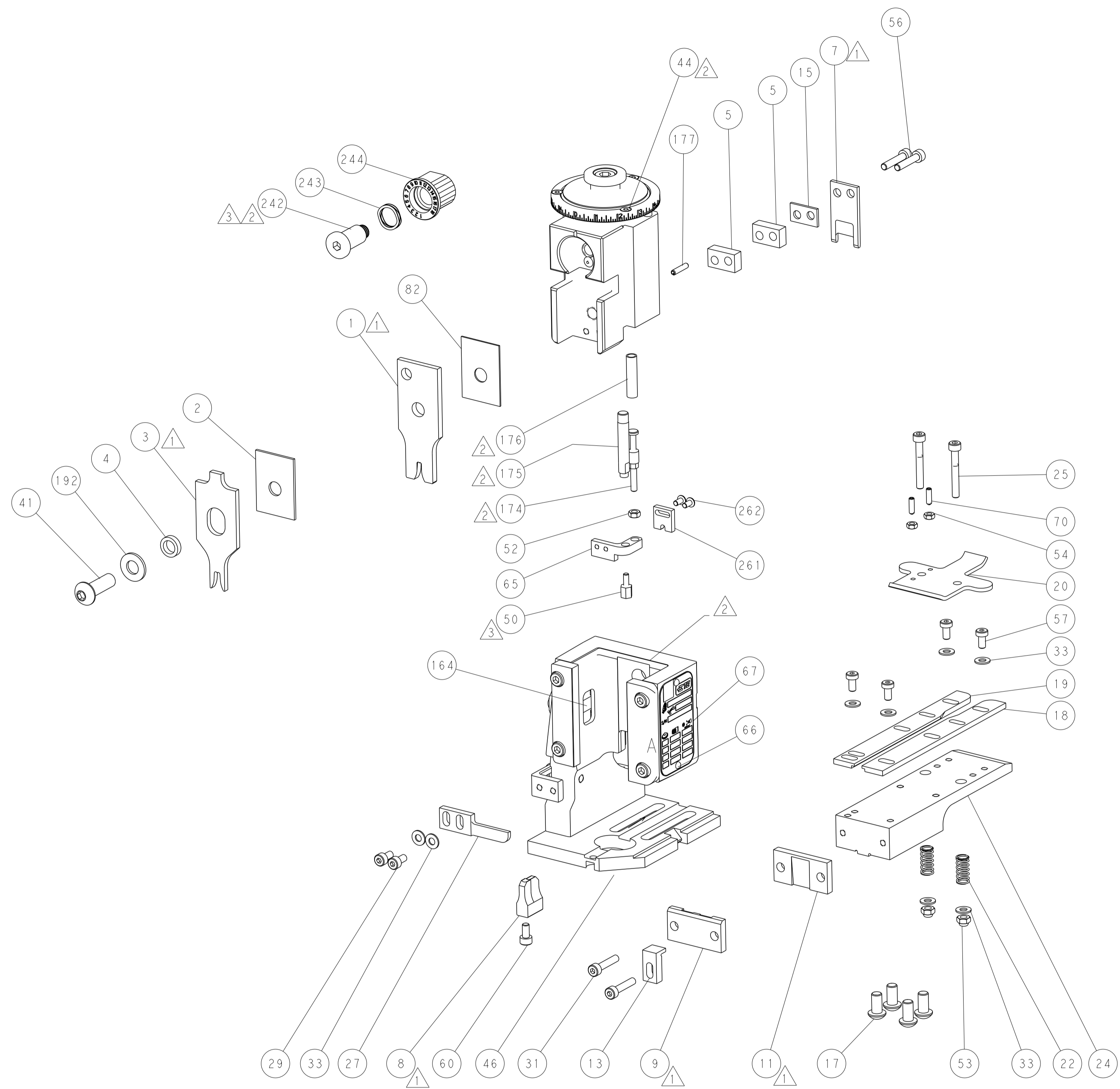
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mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±
	ANGLES	FINISH			

OWN	C. CHEN	24JAN2013	NAME	Ocean End Feed Applicator
CHK	S. XI	24JAN2013	PRODUCT SPEC	
APVD	J. CRUZ	24JAN2013	APPLICATION SPEC	
SIZE	A1	00779	CAGE CODE	2150313
SCALE	1:1	SHEET	1	OF 4
REV	B			

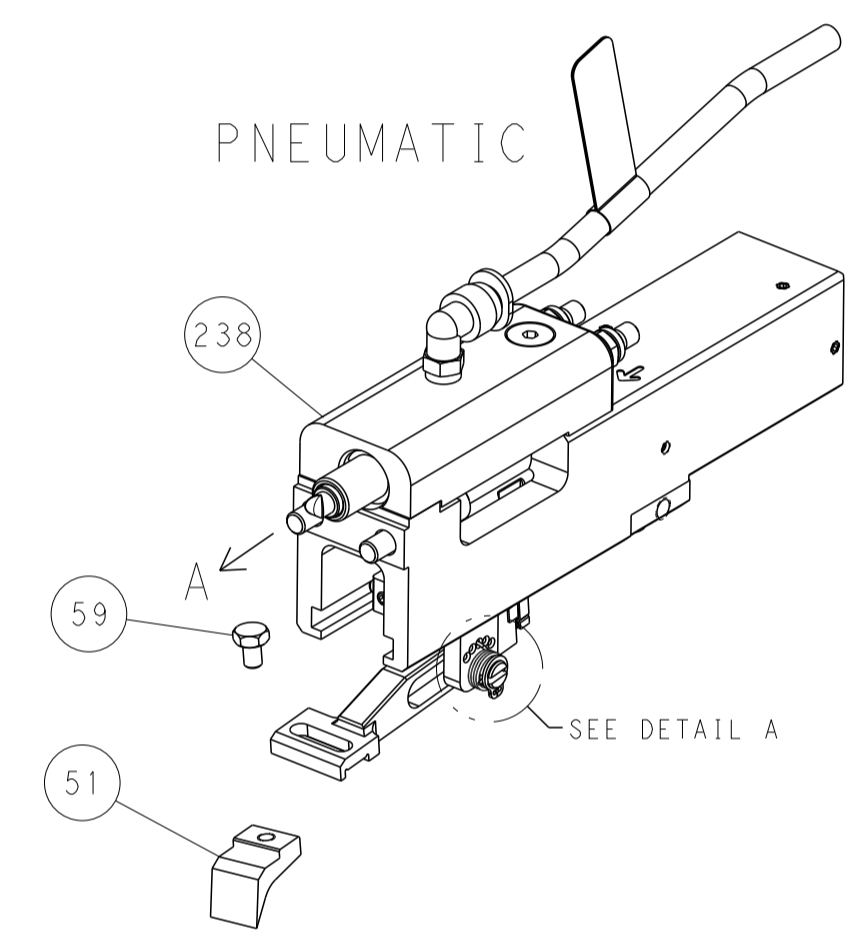
LOC		DIST		REVISIONS			
A	66	P	LTH	DESCRIPTION	DATE	DWN	APVD
		-		SEE SHEET 1			



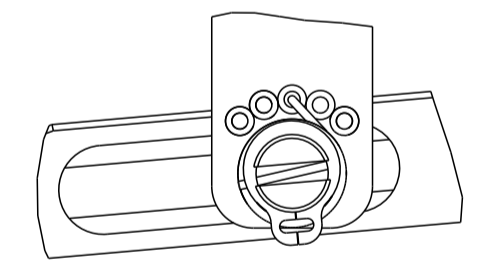
RAM AND HOLDDOWN SET-UP



FEED TYPE

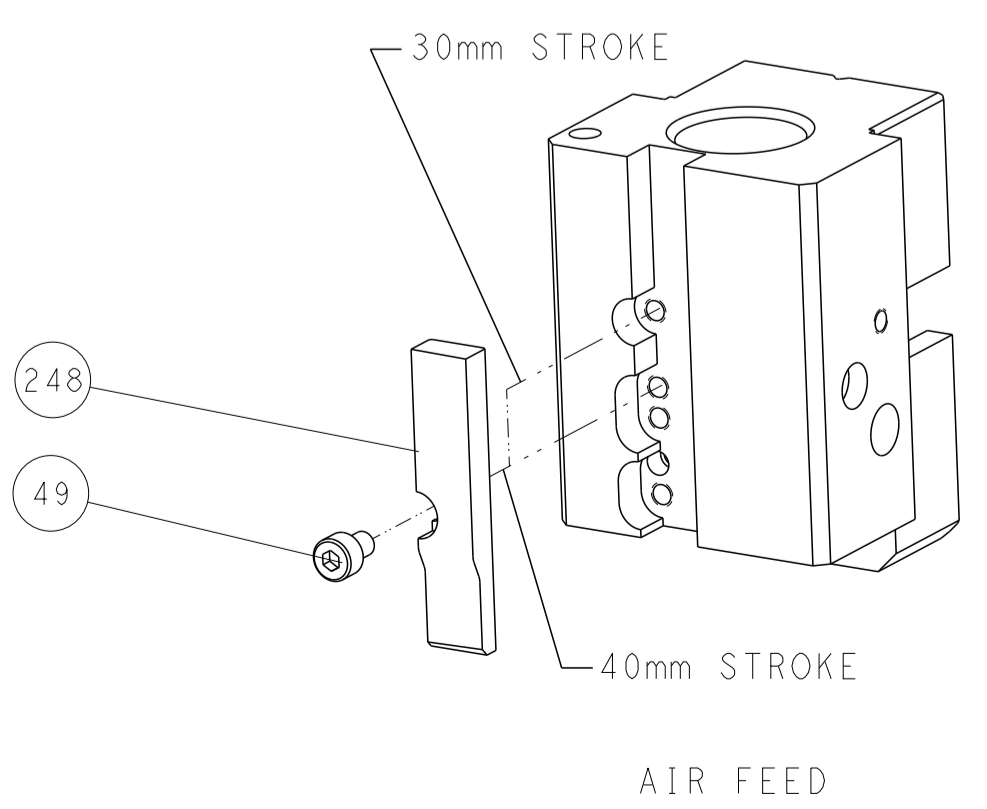


FEED SPRING SETTING POSITION



DETAIL A

CAM POSITION

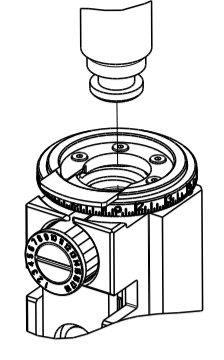


ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN C. CHEN 24JAN2013		TE Connectivity	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	5 PLC ±	Harrisburg, PA 17105-3608
MATERIAL:		FINISH:		CHK S. XI 24JAN2013		NAME	
				APVD J. CRUZ 24JAN2013		Ocean End Feed Applicator	
				PRODUCT SPEC		SIZE CAGE CODE DRAWING NO	
				APPLICATION SPEC		A1 00779 C=2150313	
				WEIGHT		RESTRICTED TO	
				Customer Accessible Production Drawing		SCALE 1:1 SHEET 2 OF 4 REV B	

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150313-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150313-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
 INTERFACE ADAPTER



APPLICATOR DATA

CRIMP	SIZE	TYPE
WIRE	2.79 mm (.110)	F
INSUL	4.06 mm (.160)	F

APPL INSTRUCTIONS
 408-35043

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION

TERMINAL NAME: 6.3MM FASTIN-FASTON TAB

WIRE STRIP LENGTH	INSULATION DIAMETER RANGE
5.36-5.79 mm (.211-.228 IN)	∅2.40-3.70 mm (.094-.146 IN)

TERMINAL APPLICATION SPECIFICATION

TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
928947-1	928947-2	928947-3	928947-4
928947-5	928947-6	928947-7	928947-8

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
2.50mm2	1.97 +/- 0.05 [.078 +/- .002]	6.5
2.00mm2	1.83 +/- 0.05 [.072 +/- .002]	8.2
1.50mm2	1.69 +/- 0.05 [.067 +/- .002]	9.6



- 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. 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. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- 6 TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.

***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.

LOC	DIST	REV	DATE	BY	APPV
A	66				

REV	DATE	DESCRIPTION	DATE	BY	APPV
-	2	1-2079383-0	SCR, BHSC, RoHS (M3 X 6)		262
-	1	1976053-1	LOCATER BLOCK, TERMINAL		261
-	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	2844940-4	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
-	REF	994970-2	COUNTER, MAGNETIC		164
-	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	455888-7	SPACER, CRIMPER		82
-	1	1803607-4	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	1901681-8	HOLDDOWN, TERMINAL		65
-	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0		59
-	4	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8		57
-	2	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20		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	2063961-1	FEED FINGER		51
-	1	1-1752354-1	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	1803292-4	DRAG		20
-	1	1-1901696-0	STRIP GUIDE, REAR		19
-	1	1-1901695-0	STRIP GUIDE, FRONT		18
-	1	6-240641-4	SPACER		15
-	1	1752360-1	SPACER, HOLD-DOWN		13
-	1	240644-9	PLATE, REAR SHEAR		11
-	-	-	-		10
-	1	3-690482-2	PLATE, FRONT SHEAR		9
1	1	1338673-8	ANVIL, COMBINATION		8
-	1	1-2217206-0	BLADE, SLUG		7
-	-	-	-		6
-	2	2-240641-5	SPACER		5
-	1	238011-2	BLOCK, CRIMPER SPACER		4
1	1	6-1633961-4	CRIMPER, INSULATION F PREMIUM		3
-	1	1-455888-3	SPACER, CRIMPER		2
1	1	4-1633305-1	CRIMPER, WIRE PREMIUM		1

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

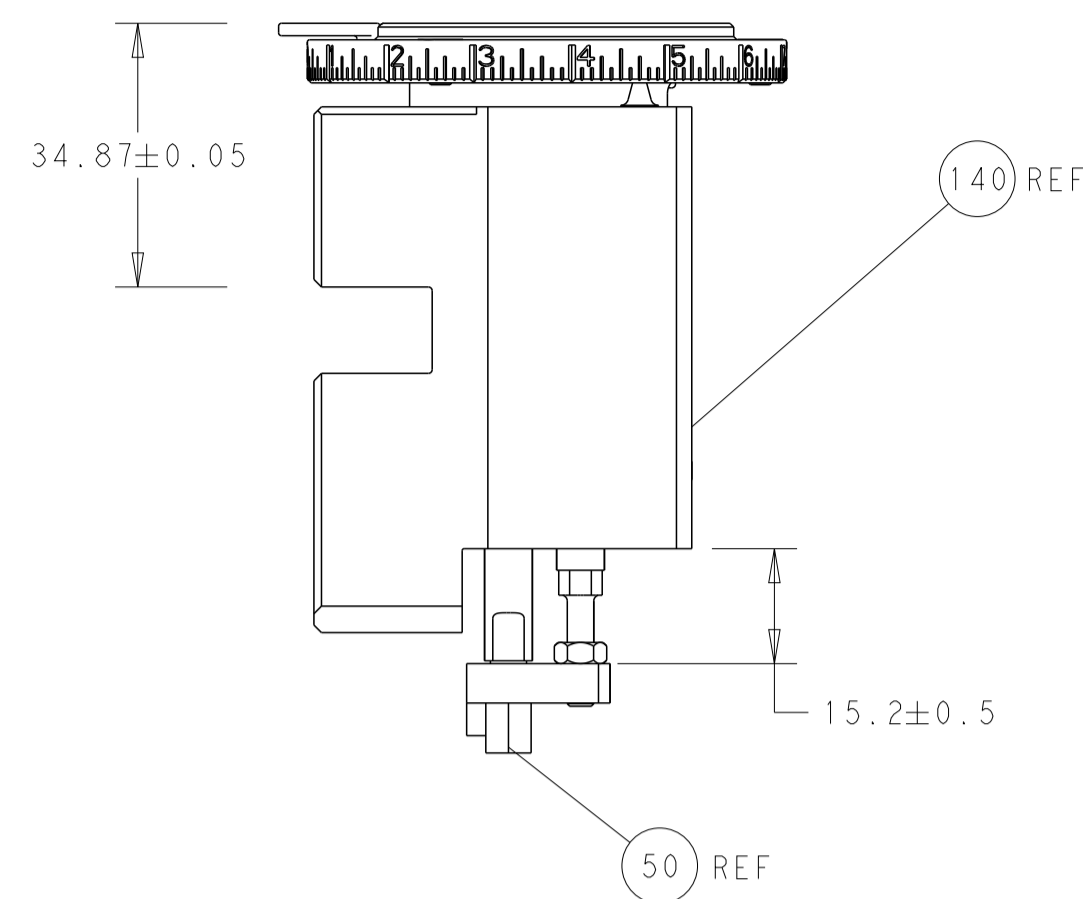
DIMENSIONS:	TOLERANCES UNLESS OTHERWISE SPECIFIED:	DATE	BY	APPV
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MATERIAL:		DATE	BY	APPV
		24JAN2013	I. CRUZ	

ITEM NO	DESCRIPTION	PART NO
77-22		

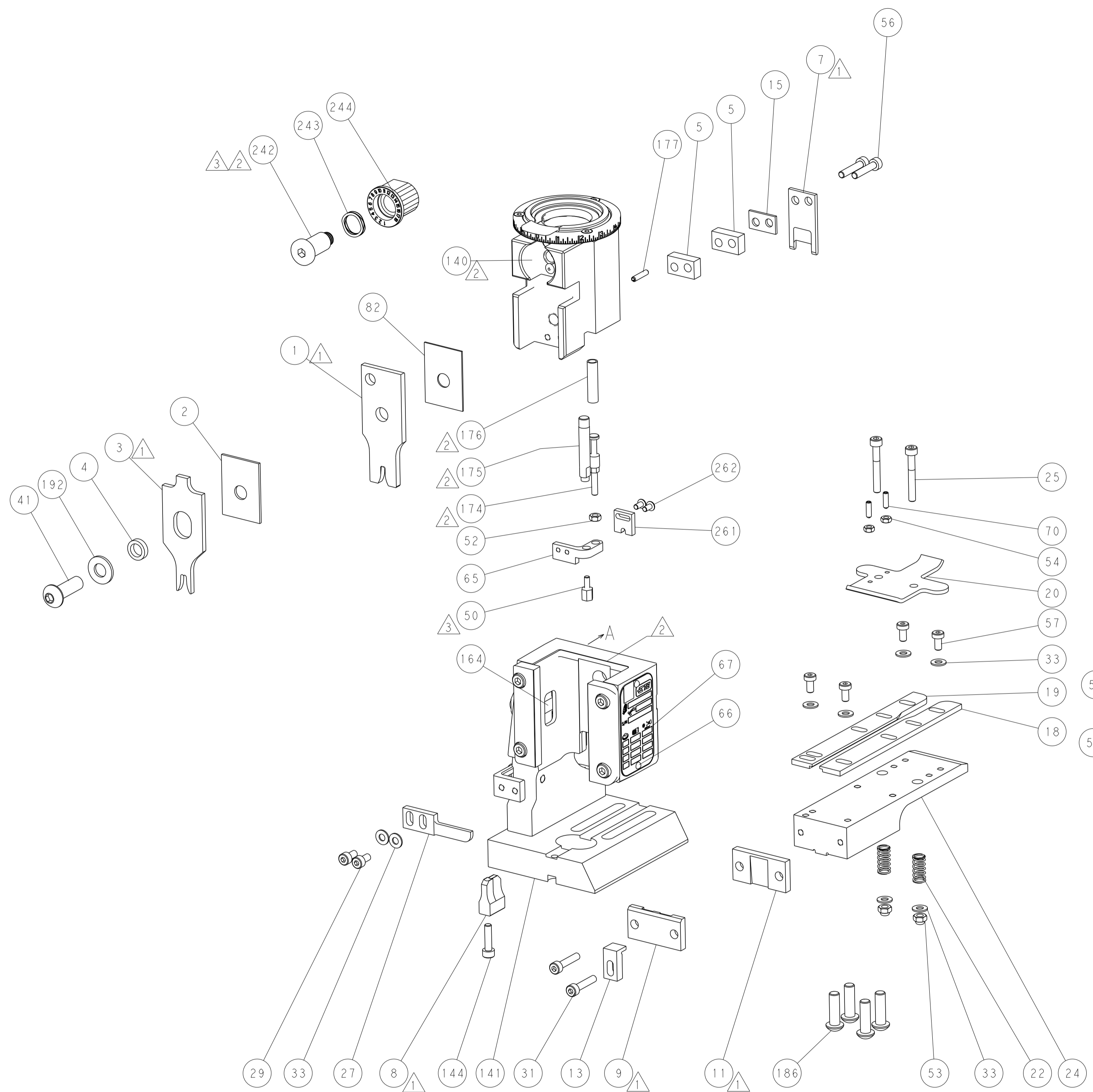
DATE	BY	APPV
24JAN2013	C. CHEN	S. XI

NAME	TE Connectivity		
ADDRESS	Harrisburg, PA 17105-3608		
PRODUCT SPEC			
APPLICATION SPEC			
SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
A1	00779	2150313	
Customer Accessible Production Drawing		SCALE	SHEET 3 OF 4
		1:1	REV B

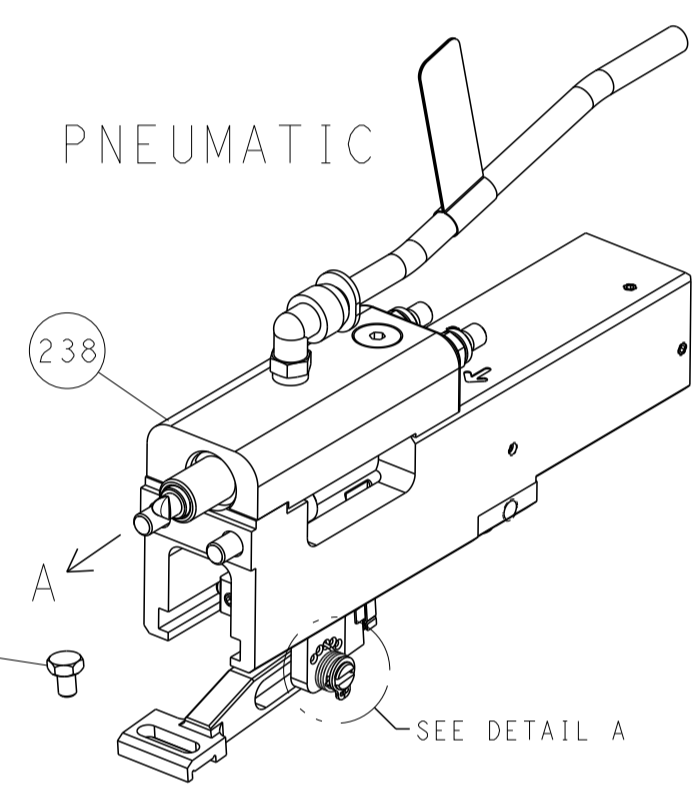
LOC	DIST	REVISIONS			
P	LTN	DESCRIPTION	DATE	OWN	APVD
A	66	SEE SHEET 1			



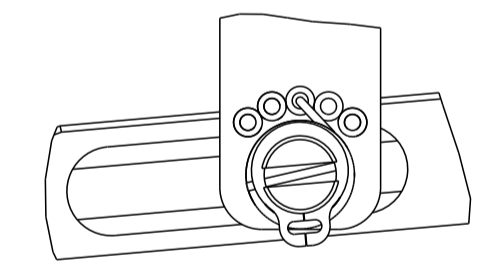
RAM AND HOLDDOWN SET-UP



FEED TYPE

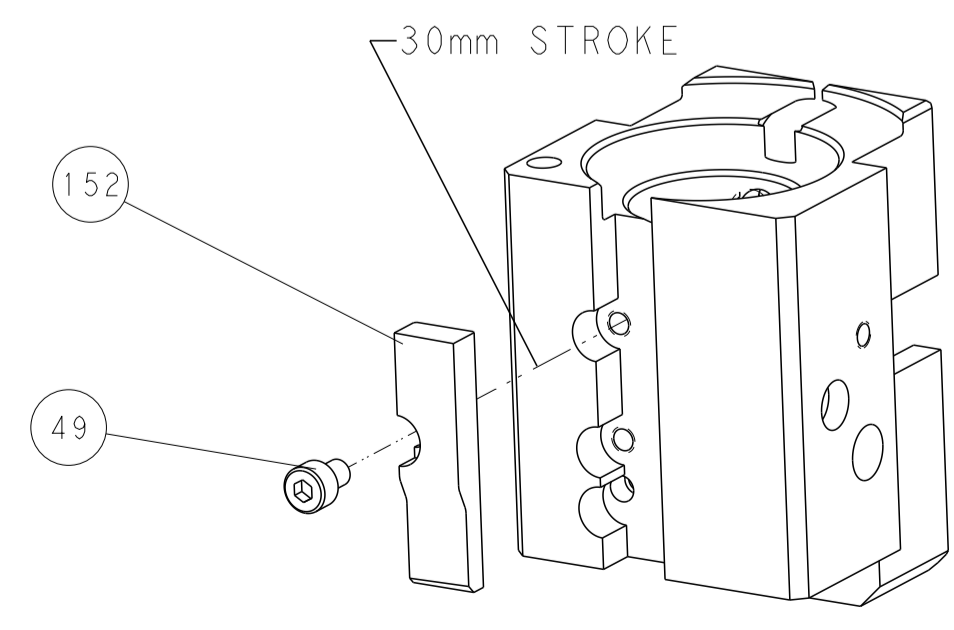


FEED SPRING SETTING POSITION



DETAIL A

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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DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH ±		NAME: Ocean End Feed Applier PRODUCT SPEC: APPLICATION SPEC: SIZE: A CAGE CODE: 00779 DRAWING NO: C-2150313 RESTRICTED TO:	SCALE: 1:1 SHEET: 4 OF 4 REV: B
MATERIAL:		WEIGHT: Customer Accessible Production Drawing	