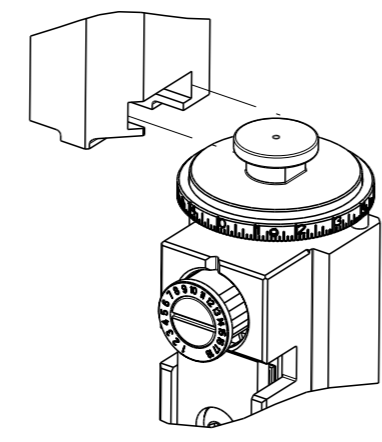


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150260-1	F	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2150260-2	F	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150260-1	F	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2150260-2	F	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150260-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.54 mm [.100]	F
INSUL	4.06 mm [.160]	F
APPLICATOR INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION			
TERMINAL NAME: RING TONGUE			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
4.48-5.08 mm [.176-.200 IN]		∅2.00-3.30 mm [.079-.130 IN]	
TERMINAL APPLICATION SPECIFICATION	114-2084		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
880626-1	880629-1	880629-6	
880626-2	880629-2	880644-1	

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.00mm2	1.75 +/- 0.05 [1.069 +/- .002]	6.7
0.75mm2	1.67 +/- 0.05 [1.066 +/- .002]	7.2
0.50mm2	1.60 +/- 0.05 [1.063 +/- .002]	8.0

- 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.
- 5. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- TERMINAL LUBRICANT IS RECOMMENDED.

***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					
A	66	P	LY#	DESCRIPTION	DATE	OWN	APVD
		C		ECR-19-004439	20MAR2019	FZ	YY
		D		ECR-19-007397	09MAY2019	FZ	TE
		E		ECR-21-004136	08APR2021	FJ	TE
		F		ECR-21-004886	27APR2021	JWC	TE

-	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	2119083-1	RETAINER, INSULATION DIAL	242	
-	-	1	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239	
-	1	-	1	-	2844940-3	AIR FEED MODULE	238	
-	1	1	1	1	1-18028-0	WASHER, FLAT, REG M8	192	
-	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164	
	-	1	1	1	2119955-2	ASSY, LUBRICATOR, END FEED	84	
-	1	1	1	1	455888-5	SPACER, CRIMPER	82	
-	1	1	1	1	2119791-5	DEPRESSOR, WIRE	73	
-	1	1	1	1	1803607-4	DOCUMENTATION PACKAGE	71	
-	2	2	2	2	2-18032-2	SCR, SET, FLT PNT, M3 X 10.0	70	
-	1	1	1	1	2119943-1	WASHER, SPACER	69	
-	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	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	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	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	-	2063961-1	FEED FINGER	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	1901696-3	STRIP GUIDE, REAR	19	
-	1	1	1	1	1901695-3	STRIP GUIDE, FRONT	18	
-	4	4	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17	
-	1	1	1	1	5-240641-2	SPACER	16	
	-	1	1	1	240644-1	PLATE, REAR SHEAR	11	
-	-	-	-	-	-	-	10	
	-	1	1	1	690482-4	PLATE, FRONT SHEAR	9	
	1	2	2	1	1	2-1633383-5	ANVIL, COMBINATION	8
	-	1	1	1	1	1-2217206-0	BLADE, SLUG	7
-	-	1	1	1	1	240641-1	SPACER	5
-	-	1	1	1	1	238011-2	BLOCK, CRIMPER SPACER	4
	1	2	2	1	1	3-2119582-4	CRIMPER, INSULATION F PREMIUM	3
-	-	1	1	1	1	1-455888-0	SPACER, CRIMPER	2
	1	2	2	1	1	456407-6	CRIMPER, WIRE PREMIUM	1
-	77-72-71-2-1	PART NO		DESCRIPTION		ITEM NO		

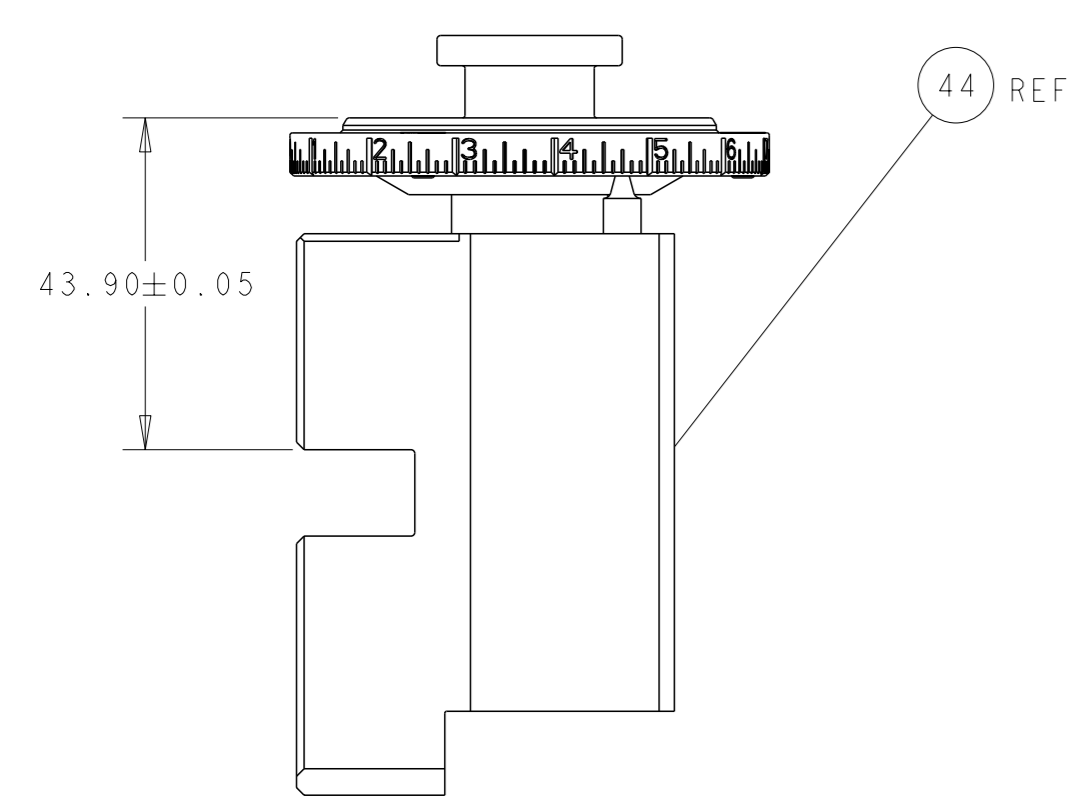
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mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±
	ANGLES	FINISH			
APPROVALS:		DATE:		SCALE:	
CHK G. BAILEY	19JUN2012	SCALE 1:1	SHEET 1 OF 4		
APVD S. XI	19JUN2012	CUSTOMER ACCESSIBLE PRODUCTION DRAWING		REV F	



Ocean End Feed Applicator

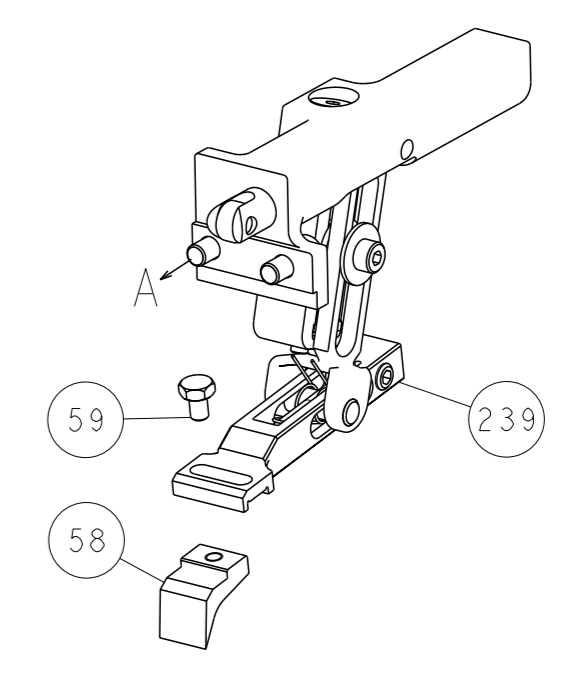
00779 ©=2150260

LOC	DIST	REVISIONS					
A	66	P	LY#	DESCRIPTION	DATE	OWN	APVD
		-		SEE SHEET 1	-	-	-

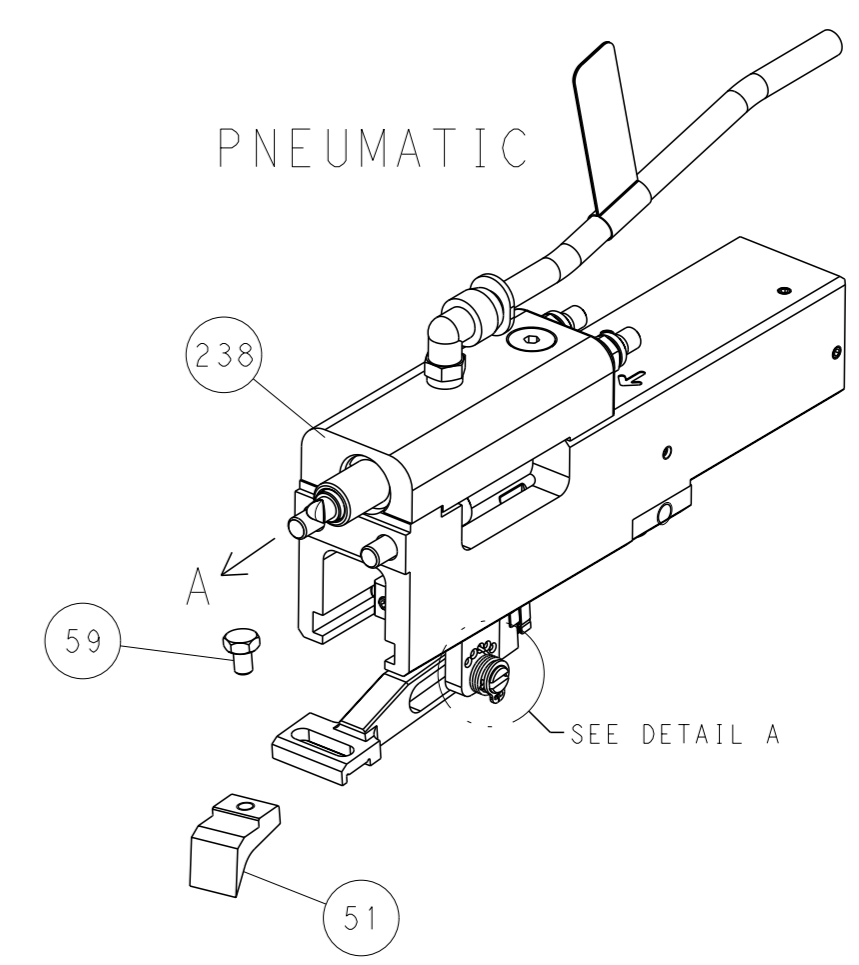


RAM SET-UP

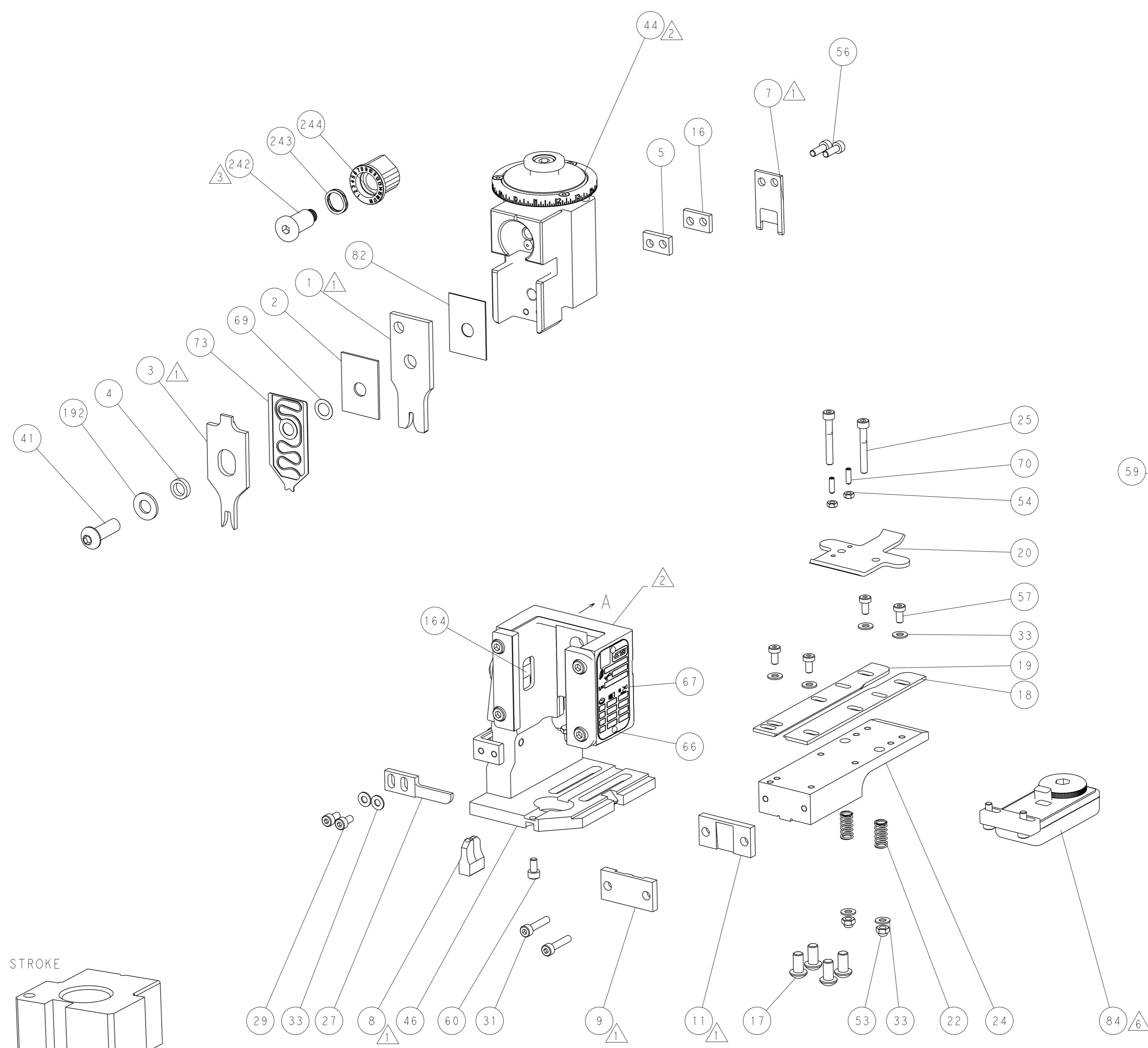
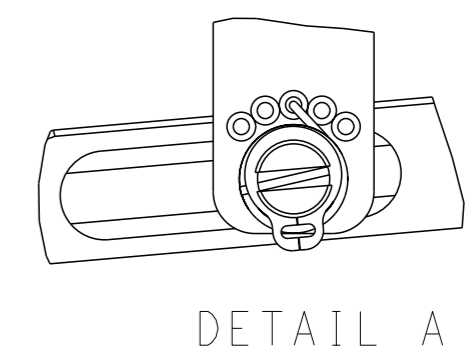
FEED TYPE
MECHANICAL



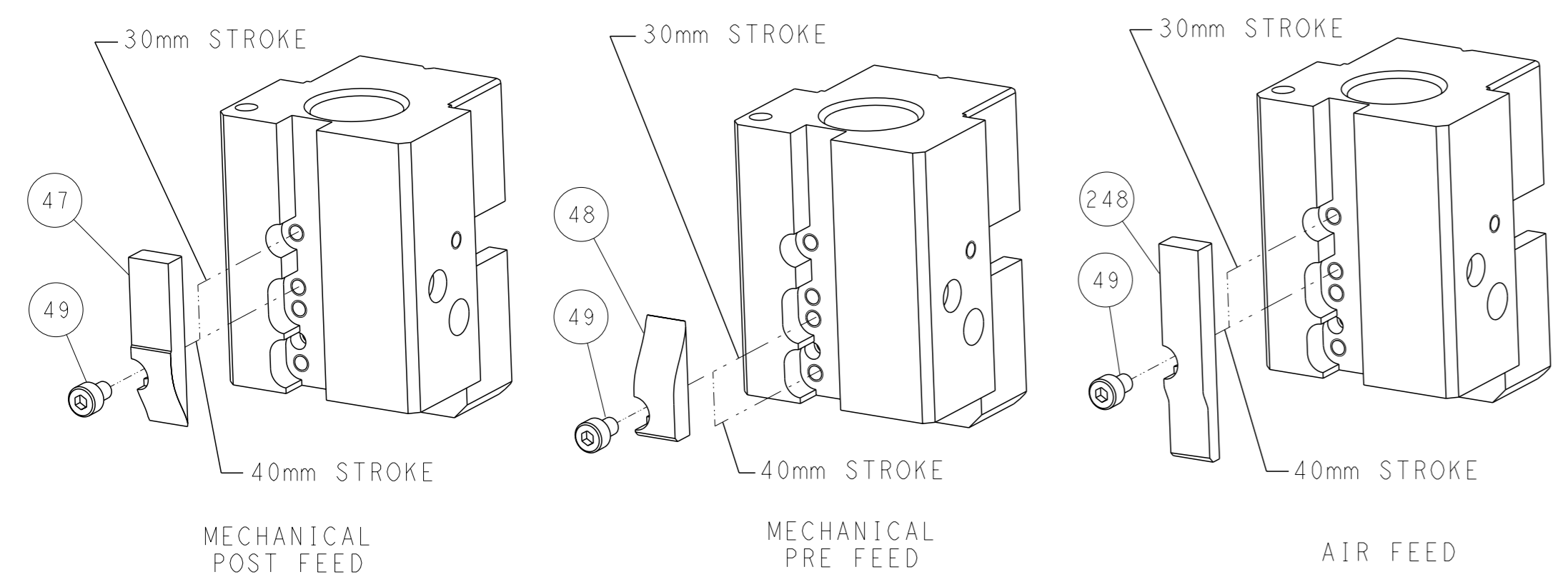
PNEUMATIC



FEED SPRING
SETTING POSITION



CAM POSITIONS

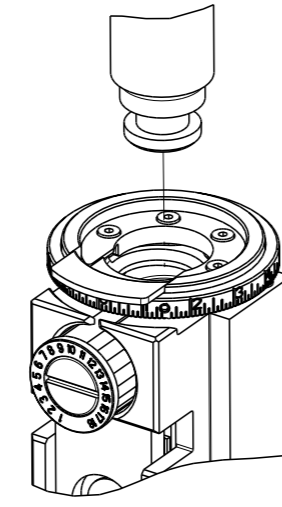


ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

<small>THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE AND THE USER'S RESPONSIBILITY TO VERIFY THE LATEST REVISION SHOULD BE CONTACTED FOR THE LATEST REVISION.</small>		OWN: Y. YIN 19JUN2012 CHK: G. BAILEY 19JUN2012 APVD: S. XI 19JUN2012	NAME: Ocean End Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2150260	RESTRICTED TO: - SCALE: 1:1 SHEET: 2 of 4 REV: F
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH ±	WEIGHT: - MATERIAL: -	APPLICATION SPEC: - PRODUCT SPEC: -	CUSTOMER ACCESSIBLE PRODUCTION DRAWING	

8	7	6	5	4	3	2	1
THIS DRAWING IS UNPUBLISHED.		RELEASED FOR PUBLICATION		20			
COPYRIGHT 20 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.							
PART NUMBER	REVISION	DESCRIPTION	FEED TYPE				
2-2150260-1	F	FINE CRIMP HEIGHT ADJUST	MECHANICAL				
2-2150260-2	F	FINE CRIMP HEIGHT ADJUST	PNEUMATIC				
7-2150260-7	A	CRIMP TOOLING KIT	-				

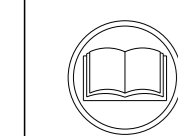
PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.54 mm [.100]	F
INSUL	4.06 mm [.160]	F
APPLICATOR INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: RING TONGUE			
WIRE STRIP LENGTH 4.48-5.08 mm [.176-.200 IN]		INSULATION DIAMETER RANGE Ø2.00-3.30 mm [.079-.130 IN]	
TERMINAL APPLICATION SPECIFICATION	114-2084	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
880626-1	880629-1	880629-6	
880626-2	880629-2	880644-1	

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.00mm2	1.75+/-0.05 [.069+/-0.002]	6.7
0.75mm2	1.67+/-0.05 [.066+/-0.002]	7.2
0.50mm2	1.60+/-0.05 [.063+/-0.002]	8.0



- 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.
- 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.

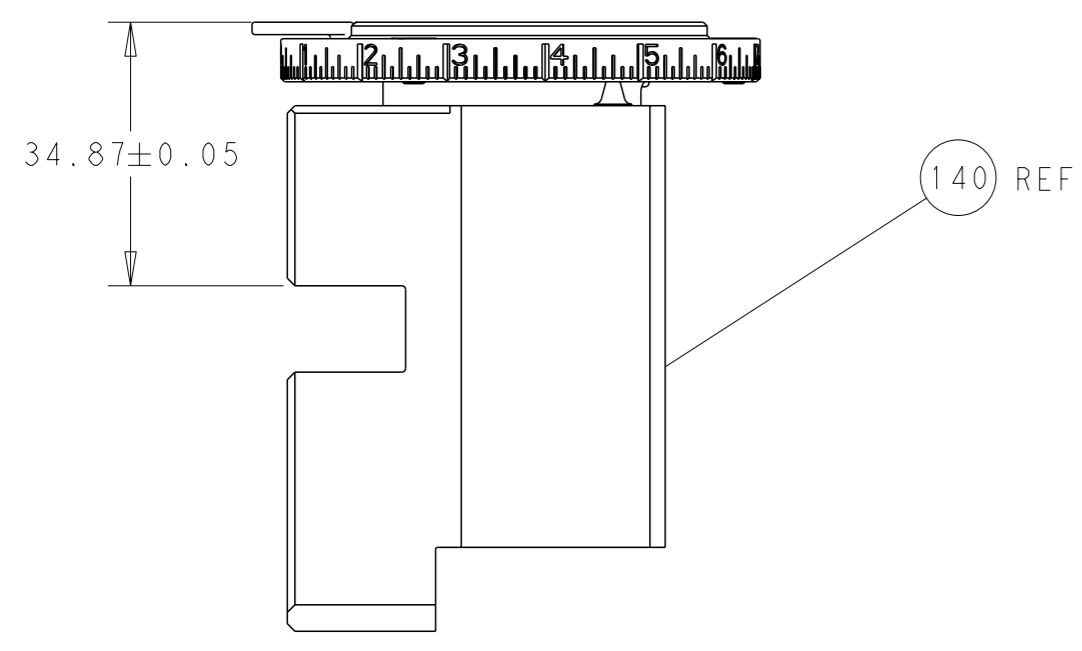
PACIFIC VERSION
Shown on sheets 3 of 4 & 4 of 4
(Atlantic version shown on sheets 1 of 4 & 2 of 4)

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

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	2119580-1	MECHANICAL FEED ASSEMBLY	239
	-	1	-	2844940-3	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
	-	REF	REF	994970-2	COUNTER, MAGNETIC	164
	-	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
6	-	1	1	2119955-2	ASSY, LUBRICATOR, END FEED	84
	-	1	1	455888-5	SPACER, CRIMPER	82
	-	1	1	2119791-5	DEPRESSOR, WIRE	73
	-	1	1	1803607-4	DOCUMENTATION PACKAGE	71
	-	2	2	2-18032-2	SCR, SET, FLT PNT, M3 X 10.0	70
	-	1	1	2119943-1	WASHER, SPACER	69
	-	1	1	2119740-1	TAG, IDENTIFICATION	67
	-	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
	-	1	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	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	56
	-	2	2	5018030-1	NUT, HEX, REG, RoHS, M3	54
	-	2	2	986965-8	NUT, LOCK, HEX, TORQUE (M4)	53
	-	1	-	2063961-1	FEED FINGER	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	1901696-3	STRIP GUIDE, REAR	19
	-	1	1	1901695-3	STRIP GUIDE, FRONT	18
	-	1	1	5-240641-2	SPACER	16
1	-	1	1	240644-1	PLATE, REAR SHEAR	11
	-	-	-	-	-	10
1	-	1	1	690482-4	PLATE, FRONT SHEAR	9
1	1	1	1	2-1633383-5	ANVIL, COMBINATION	8
1	-	1	1	1-2217206-0	BLADE, SLUG	7
	-	1	1	240641-1	SPACER	5
	-	1	1	238011-2	BLOCK, CRIMPER SPACER	4
1	1	1	1	3-2119582-4	CRIMPER, INSULATION F PREMIUM	3
	-	1	1	1-455888-0	SPACER, CRIMPER	2
1	1	1	1	456407-6	CRIMPER, WIRE PREMIUM	1
	-	77-22-21		PART NO	DESCRIPTION	ITEM NO

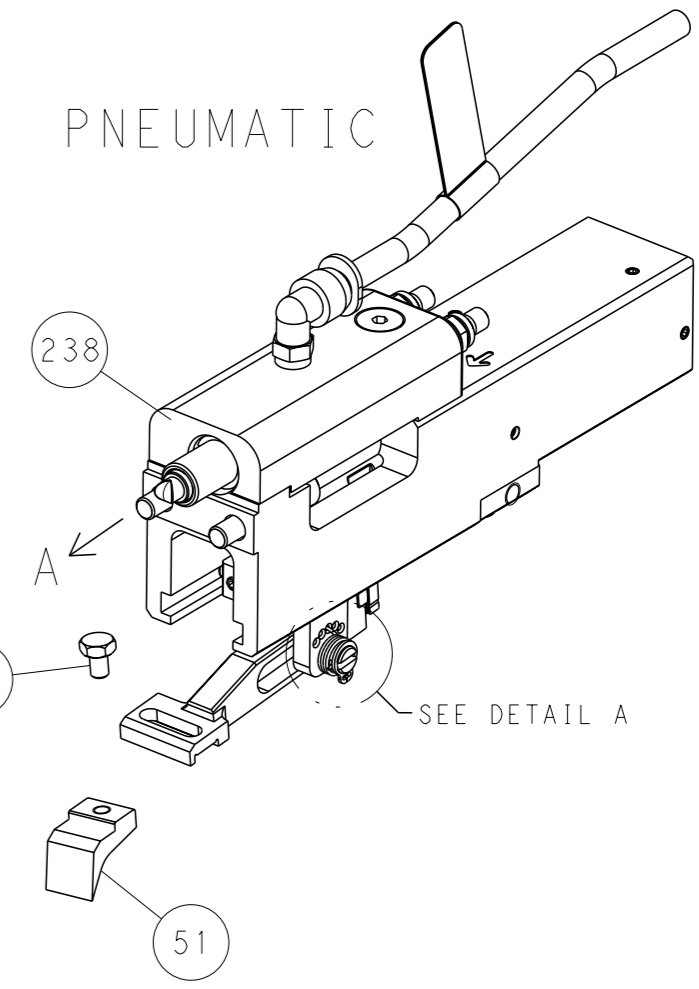
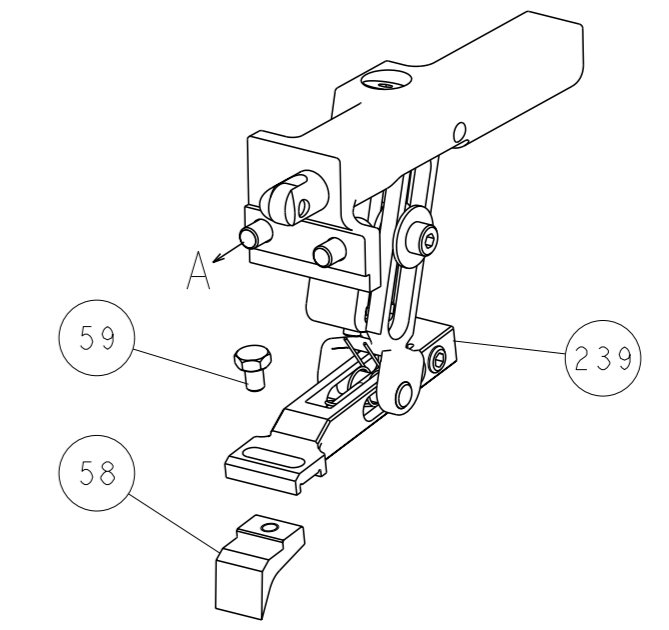
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG Y. YIN 19JUN2012		TE Connectivity	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	5 PLC ±	Harrisburg, PA 17105-3608
	ANGLES	FINISH		CHK G. BAILEY 19JUN2012	NAME		
				APVD S. YI 19JUN2012	Ocean End Feed Applicator		
MATERIAL				PRODUCT SPEC	SIZE	CAGE CODE	DRAWING NO
				APPLICATION SPEC	A1	00779	2150260
				WEIGHT	SCALE	1:1	SHEET 3 OF 4
				RESTRICTED TO	Customer Accessible Production Drawing		

LOC	DIST	REVISIONS			
A	66	REV	DATE	OWN	APVD
		1	SEE SHEET 1		

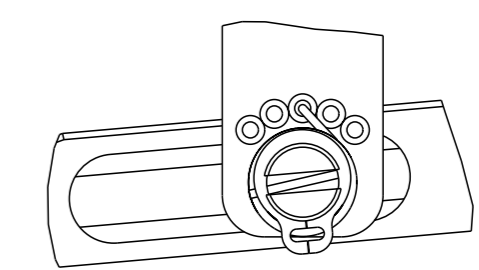


RAM SET-UP

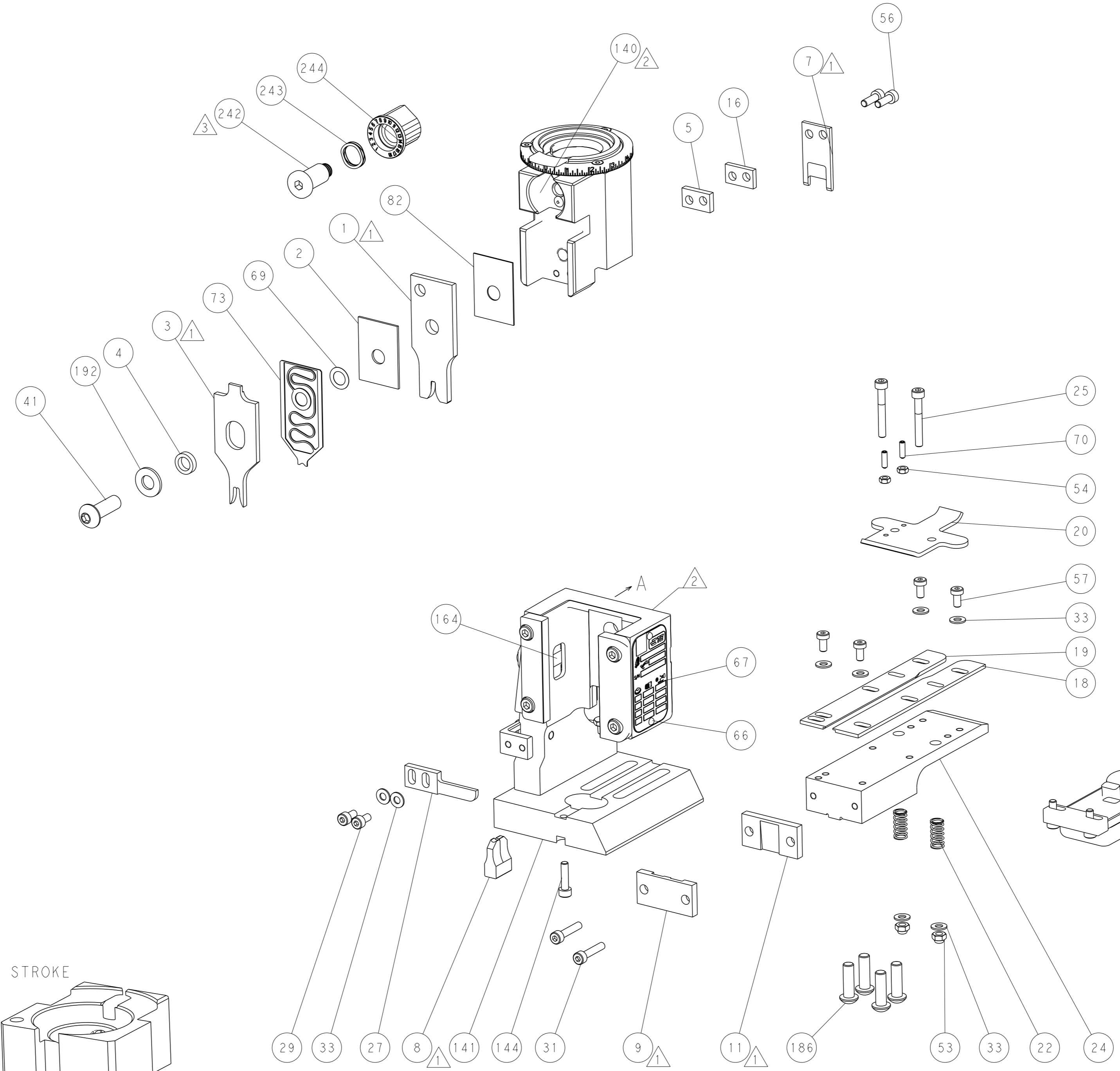
FEED TYPE
MECHANICAL



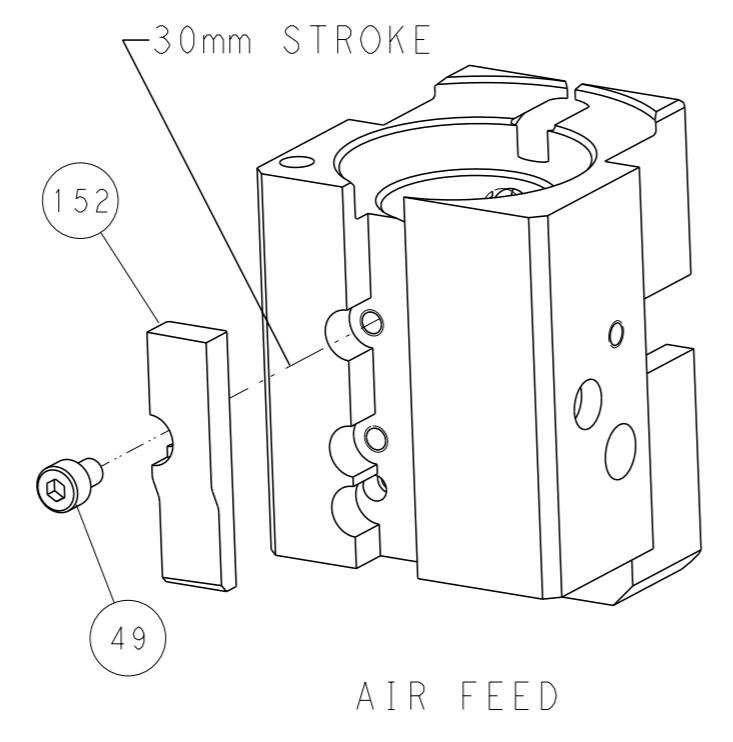
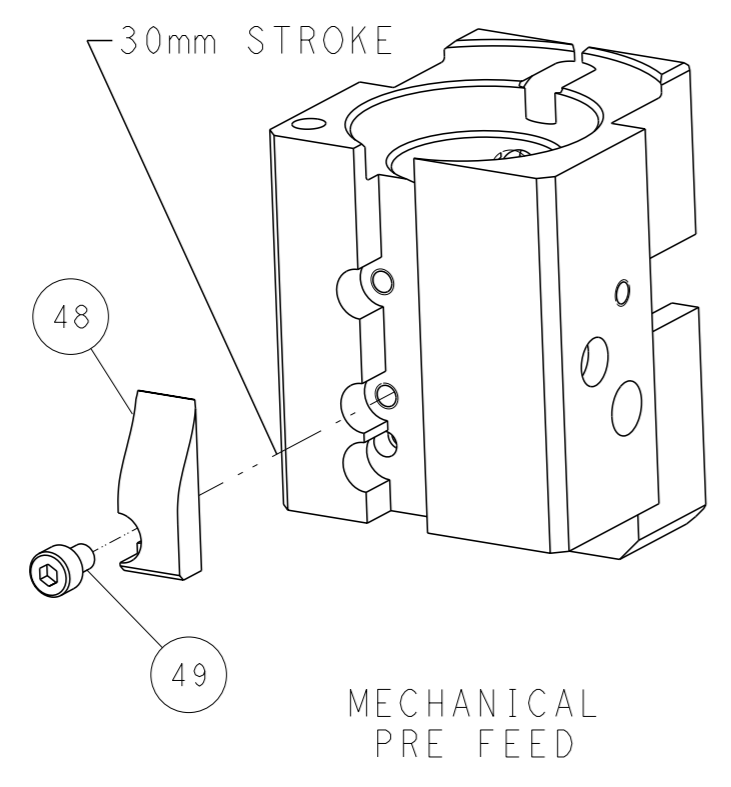
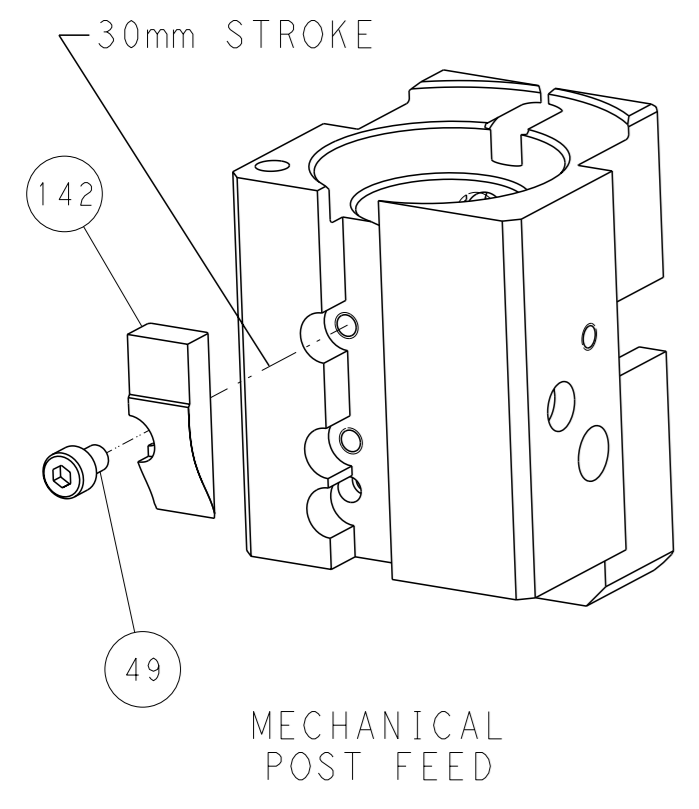
FEED SPRING
SETTING POSITION



DETAIL A



CAM POSITIONS



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

DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH *		OWN: Y. YIN 19JUN2012 CHK: G. BAILEY 19JUN2012 APVD: S. XI 19JUN2012 PRODUCT SPEC APPLICATION SPEC WEIGHT: - SCALE: 1:1		NAME: Ocean End Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2150260 SHEET: 4 of 4 REV: F	
MATERIAL: -				RESTRICTED TO: -		CUSTOMER ACCESSIBLE PRODUCTION DRAWING	