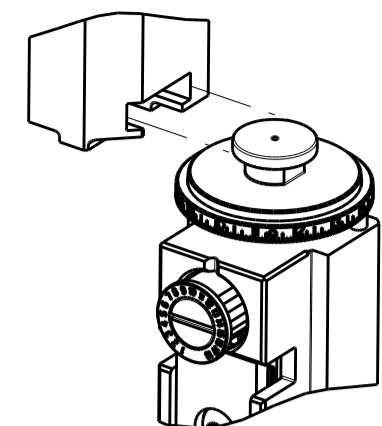


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150471-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150471-2	C	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150471-7	B	CRIMP TOOLING KIT	-

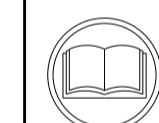
ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	5.46 mm [.215]	F
INSUL	7.62 mm [.300]	F
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION
TERMINAL NAME: TERMINAL		
WIRE STRIP LENGTH 6.00-6.80 mm [.236-.268 IN]	INSULATION DIAMETER RANGE 7.00-8.20 mm [.276-.323 IN]	
TERMINAL APPLICATION SPECIFICATION	CUSTOMER DRAWING 1544453	
TERMINALS APPLIED		
TE TERMINAL 1544453-1	TE TERMINAL	TE TERMINAL

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
10.00mm2	3.58 +/- 0.05 [.141 +/- .002]	5.6
7.00mm2	3.20 +/- 0.05 [.126 +/- .002]	9.6



- △ RECOMMENDED SPARE PARTS
- △ REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- △ APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 180. 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 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.

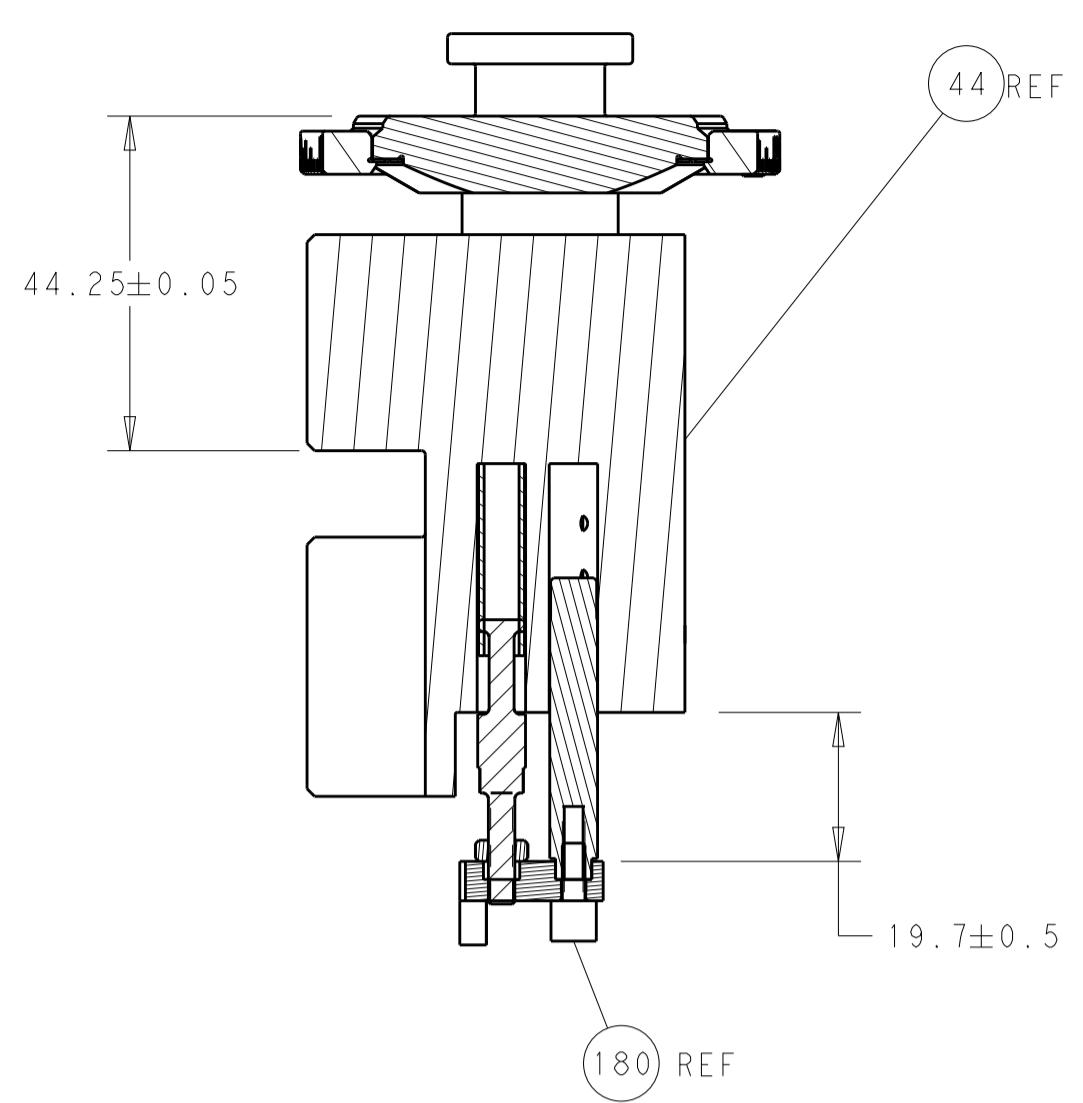
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

LOC	DIST	REVISIONS					
		P	LTN	DESCRIPTION	DATE	OWN	APVD
A	66			RELEASED	13OCT2014	BH	GB
				ECR-14-015484	17OCT2014	YY	GB
				ECR-21-000876	22JAN2021	FZ	TE

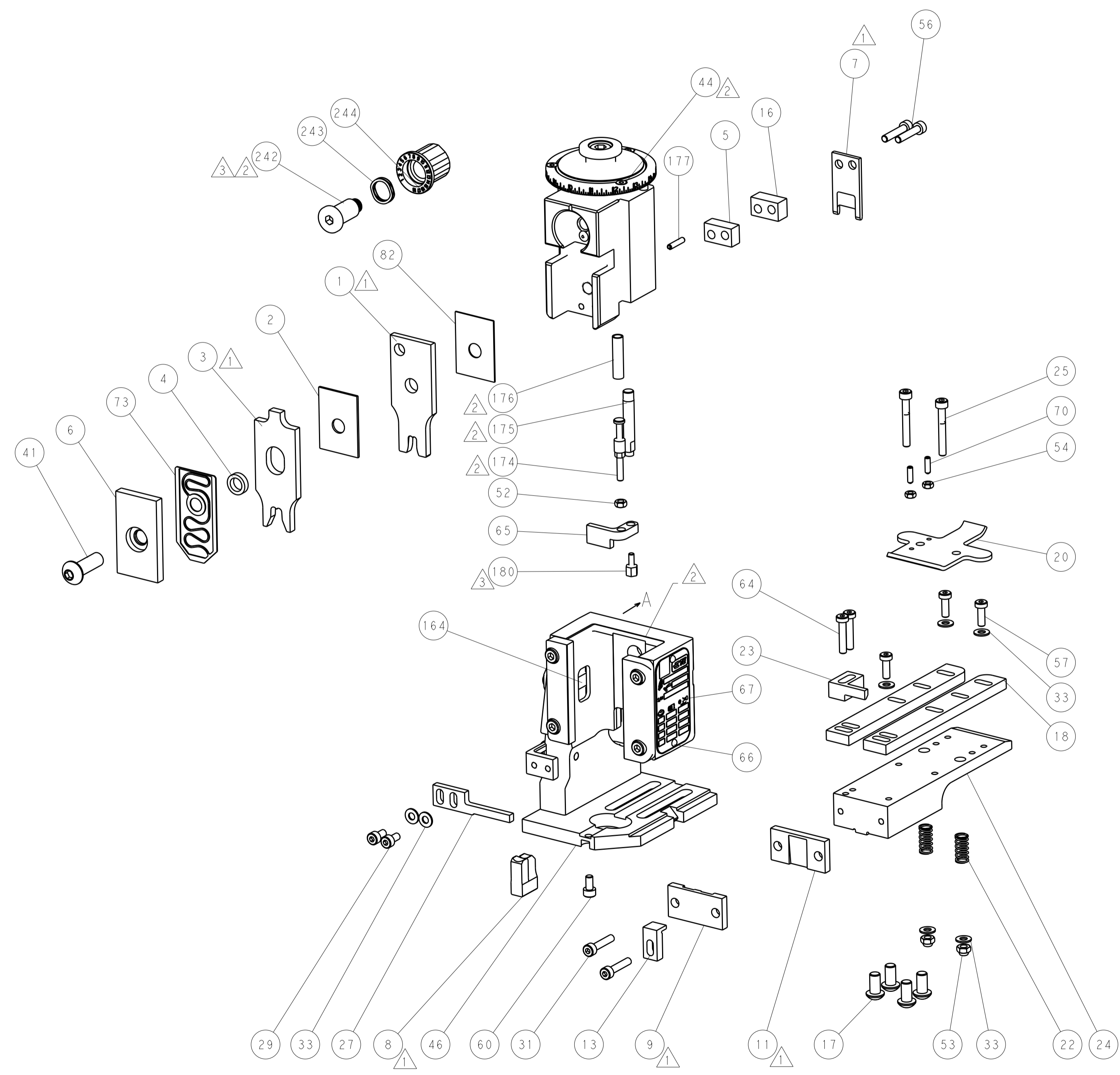
-	1	1	2119641-1	FEED CAM, AIR FEED	248		
-	1	1	2119082-3	CAM, SNAIL, INSULATION ADJUSTMENT	244		
-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243		
△	1	1	2119083-1	RETAINER, INSULATION DIAL	242		
-	1	1	2844940-4	AIR FEED MODULE	238		
△	1	1	1752354-6	STANDOFF,HOLD-DOWN	180		
-	1	1	6-993111-6	PIN, 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		
-	REF	REF	994970-2	COUNTER, MAGNETIC	164		
-	1	1	455888-5	SPACER, CRIMPER	82		
-	1	1	1-2119791-4	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	2119740-1	TAG, IDENTIFICATION	67		
-	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66		
-	1	1	1901681-1	HOLDDOWN, TERMINAL	65		
-	2	2	2168400-5	SHCS, LOW HEAD, RoHS, M4 X 20	64		
-	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		
-	3	3	2168400-1	SHCS, LOW HEAD, RoHS, M4 X 12	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	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		
-	7	7	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	690455-1	STRIPPER, FRONT CASTING	27		
-	2	2	1-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 30	25		
-	1	1	1752371-5	PLATE, STRIP GUIDE	24		
-	1	1	240825-3	PLATE, STRIP HOLD DOWN	23		
-	2	2	2-22281-3	SPRING, COMPRESSION	22		
-	1	1	1803292-4	DRAG	20		
-	2	2	1901259-9	GUIDE, LOWER STRIP	18		
-	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17		
-	1	1	5-240641-1	SPACER	16		
-	1	1	1752360-1	SPACER,HOLD-DOWN	13		
△	1	1	240644-9	PLATE, REAR SHEAR	11		
-	-	-	-	-	10		
△	1	1	6-690482-3	PLATE, FRONT SHEAR	9		
△	1	2	1	5-1803001-7	ANVIL, COMBINATION, END FEED	8	
△	1	1	1	1-2217206-0	BLADE, SLUG	7	
△	1	1	1	1803203-1	BLOCK, FRONT DEPRESSOR	6	
-	1	1	1	2-240641-7	SPACER	5	
-	1	1	1	3-238011-8	BLOCK, CRIMPER SPACER	4	
△	1	2	1	4-1803017-7	CRIMPER, INSULATION F	3	
-	1	1	1	1-455888-0	SPACER, CRIMPER	2	
△	1	2	1	7-1633738-9	CRIMPER, WIRE	1	
-	77	72	2	PART NO			
-				DESCRIPTION			
-				ITEM NO			

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		OWN	31JULY2014	TE Connectivity	
mm		0 PLC ±		CHK	31JULY2014	Harrisburg, PA 17105-3608	
Ø		1 PLC ±		G. BAILEY		NAME	
H		2 PLC ±		APVD	31JULY2014	Ocean End Feed	
A		3 PLC ±		T. ERLIN		Applicator	
4		4 PLC ±				SIZE	
ANGLES		FINISH				CAGE CODE	
						DRAWING NO	
						RESTRICTED TO	
						SCALE	
						SHEET	
						OF	
						REV	
						C	

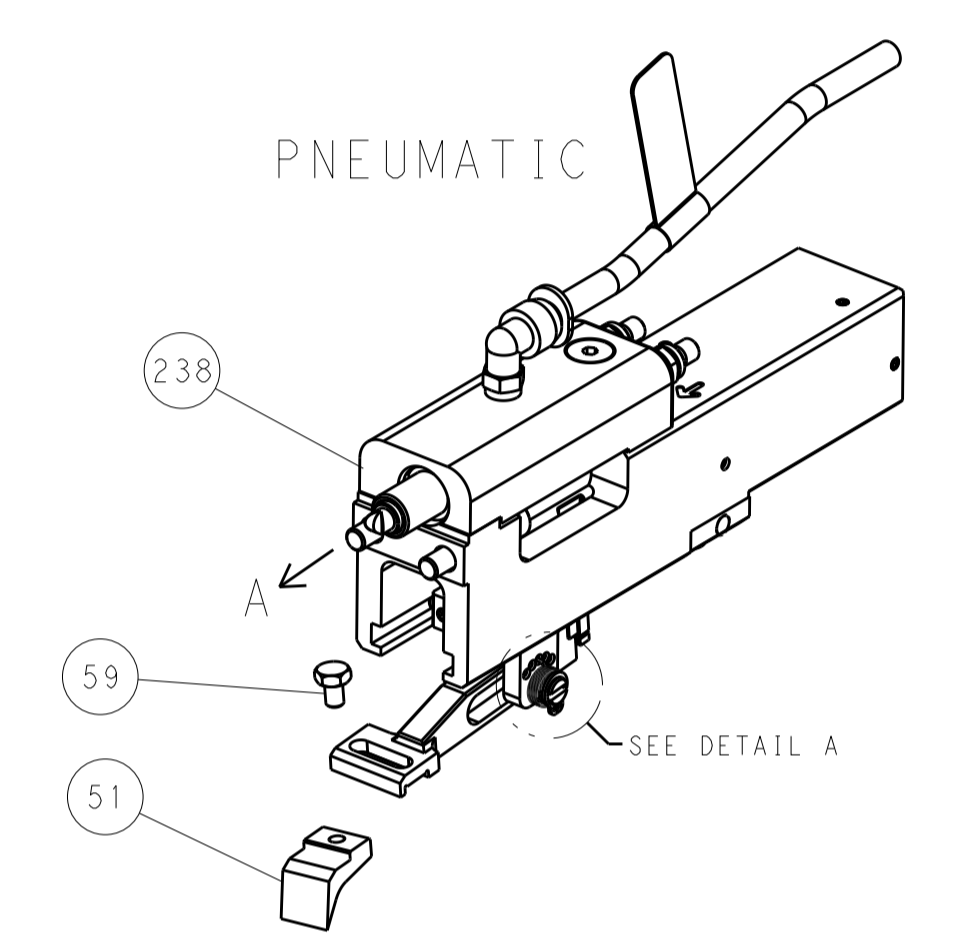
LOC	DIST	REV	DATE	BY	APPV	
A	66					
REVISIONS			DESCRIPTION	DATE	DWN	APPV
			SEE SHEET 1			



RAM AND HOLDDOWN SET-UP

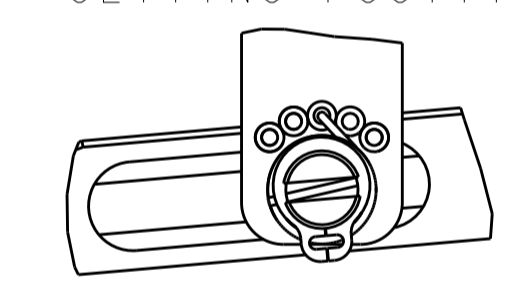


FEED TYPE



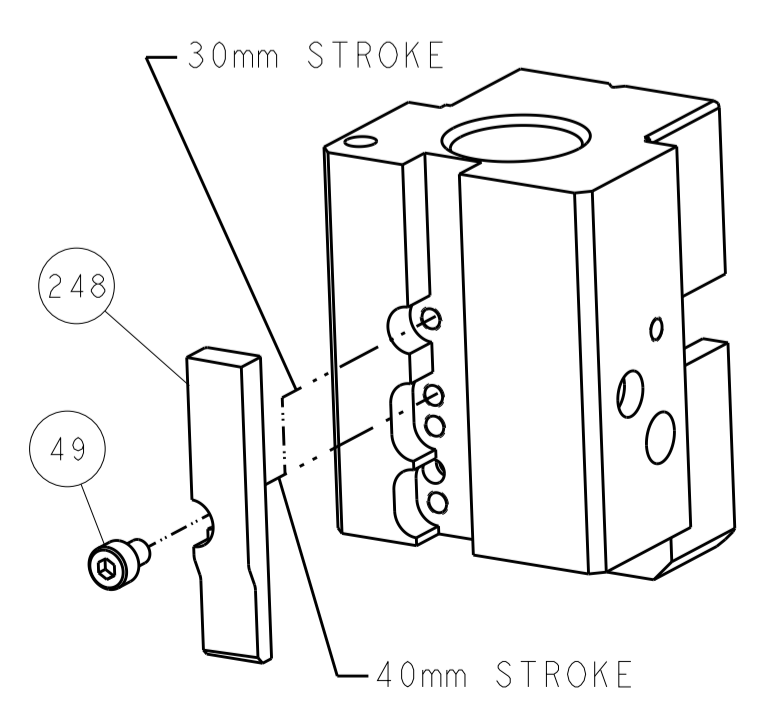
PNEUMATIC

FEED SPRING SETTING POSITION



DETAIL A

CAM POSITION



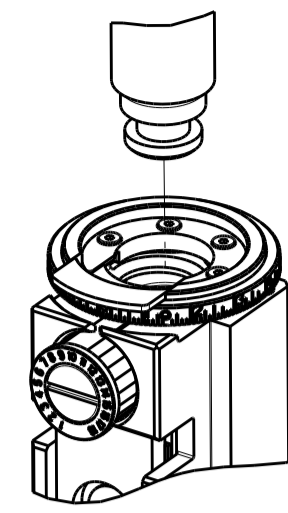
AIR FEED

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 UNPUBLISHED. RELEASED FOR PUBLICATION. IT IS THE PROPERTY OF TYCO ELECTRONICS CORPORATION. IT IS TO BE USED ONLY FOR THE PURPOSES AND IN THE MANNER SPECIFIED BY THE CUSTOMER. IT IS TO BE RETURNED TO TYCO ELECTRONICS CORPORATION UPON THE COMPLETION OF THE PROJECT OR AS OTHERWISE SPECIFIED.</small>		DWN: K. STAKEM 31JULY2014 CHK: G. BAILEY 31JULY2014 APVD: T. ERLIN 31JULY2014	TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		NAME: Ocean End Feed Applicator PRODUCT SPEC: APPLICATION SPEC: SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2150471	RESTRICTED TO:
MATERIAL: FINISH:		WEIGHT: Customer Accessible Production Drawing SCALE: 1:1 SHEET: 2 of 4 REV: C	

THIS DRAWING IS UNPUBLISHED.	RELEASED FOR PUBLICATION		
COPYRIGHT 20 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.			
PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150471-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150471-7	B	CRIMP TOOLING KIT	-

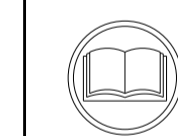
PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	5.46 mm [.215]	F
INSUL	7.62 mm [.300]	F
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION
TERMINAL NAME: TERMINAL		
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE
6.00-6.80 mm [.236-.268 IN]		7.00-8.20 mm [.276-.323 IN]
TERMINAL APPLICATION SPECIFICATION	CUSTOMER DRAWING 1544453	
TERMINALS APPLIED		
TE TERMINAL	TE TERMINAL	TE TERMINAL
1544453-1		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
10.00mm2	3.58 +/- 0.05 [.141 +/- .002]	5.6
7.00mm2	3.20 +/- 0.05 [.126 +/- .002]	9.6



- 1 RECOMMENDED SPARE PARTS
- 2 REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- 3 APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 180. 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. 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.

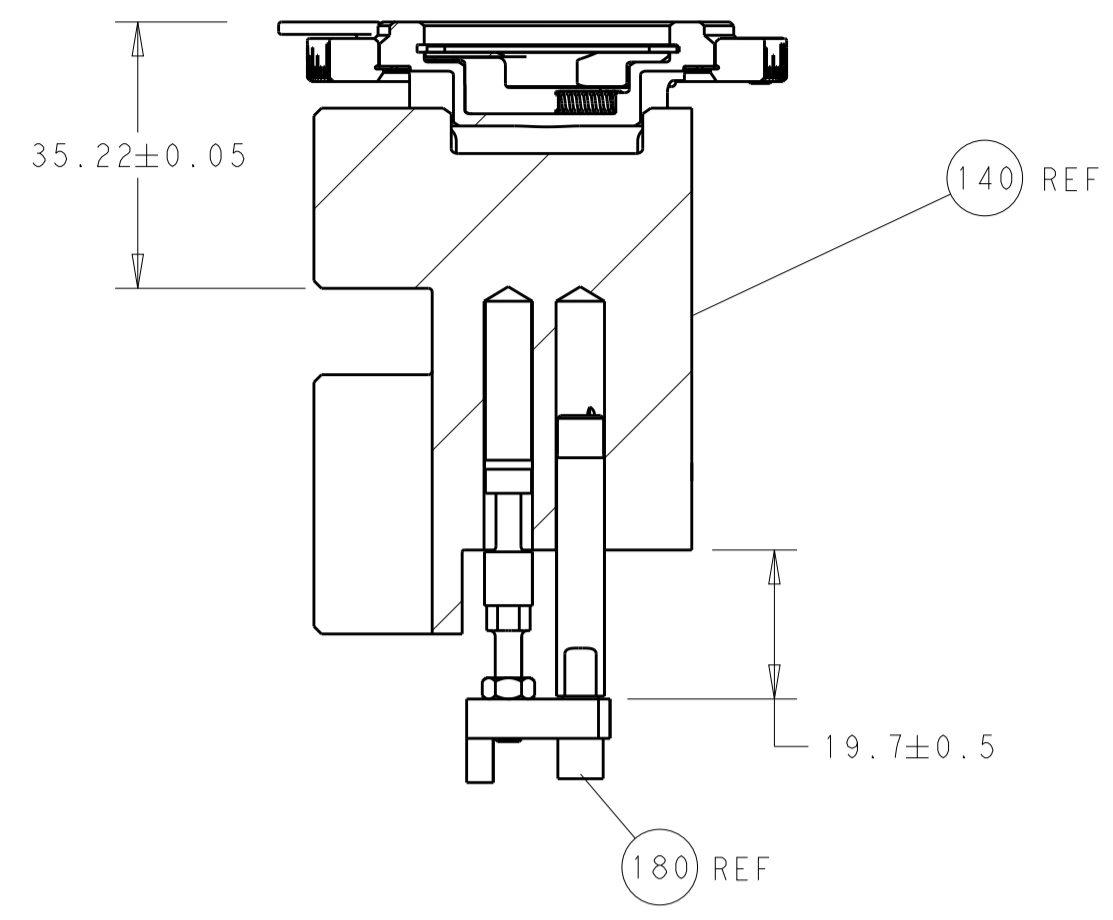
PACIFIC VERSION
Shown on sheets 3 of 4 & 4 of 4
(Atlantic version shown on sheets 1 of 4 & 2 of 4)

LOC	DIST	REV	DATE	BY	APPV
A	66				

		REVISIONS		
REV	DATE	DESCRIPTION	DATE	BY
-	-	SEE SHEET 1	-	-
-	1	2119082-3		244
-	1	2079764-1		243
-	1	2119083-1		242
-	1	2844940-4		238
-	4	2079383-9		186
-	1	1752354-6		180
-	1	6-993111-6		177
-	1	8-22280-7		176
-	1	1752353-2		175
-	1	1901680-2		174
-	REF	994970-2		164
-	1	2119641-2		152
-	1	2168083-8		144
-	1	2119655-6		141
-	1	1803518-1		140
-	1	455888-5		82
-	1	1-2119791-4		73
-	1	1803607-4		71
-	2	2-18032-2		70
-	1	2119740-1		67
-	2	2168078-1		66
-	1	1901681-1		65
-	2	2168400-5		64
-	1	5-18022-5		59
-	3	2168400-1		57
-	2	2168083-9		56
-	2	5018030-1		54
-	2	986965-8		53
-	1	1-5018030-0		52
-	1	2063961-1		51
-	1	18023-9		49
-	1	1803602-1		41
-	7	1-18028-2		33
-	2	2168083-9		31
-	2	2168083-2		29
-	1	690455-1		27
-	2	1-2168083-5		25
-	1	1752371-5		24
-	1	240825-3		23
-	2	2-22281-3		22
-	1	1803292-4		20
-	2	1901259-9		18
-	1	5-240641-1		16
-	1	1752360-1		13
-	1	240644-9		11
-	-	-		10
-	1	6-690482-3		9
1	1	5-1803001-7		8
-	1	1-2217206-0		7
-	1	1803203-1		6
-	1	2-240641-7		5
-	1	3-238011-8		4
1	1	4-1803017-7		3
-	1	1-455888-0		2
1	1	7-1633738-9		1

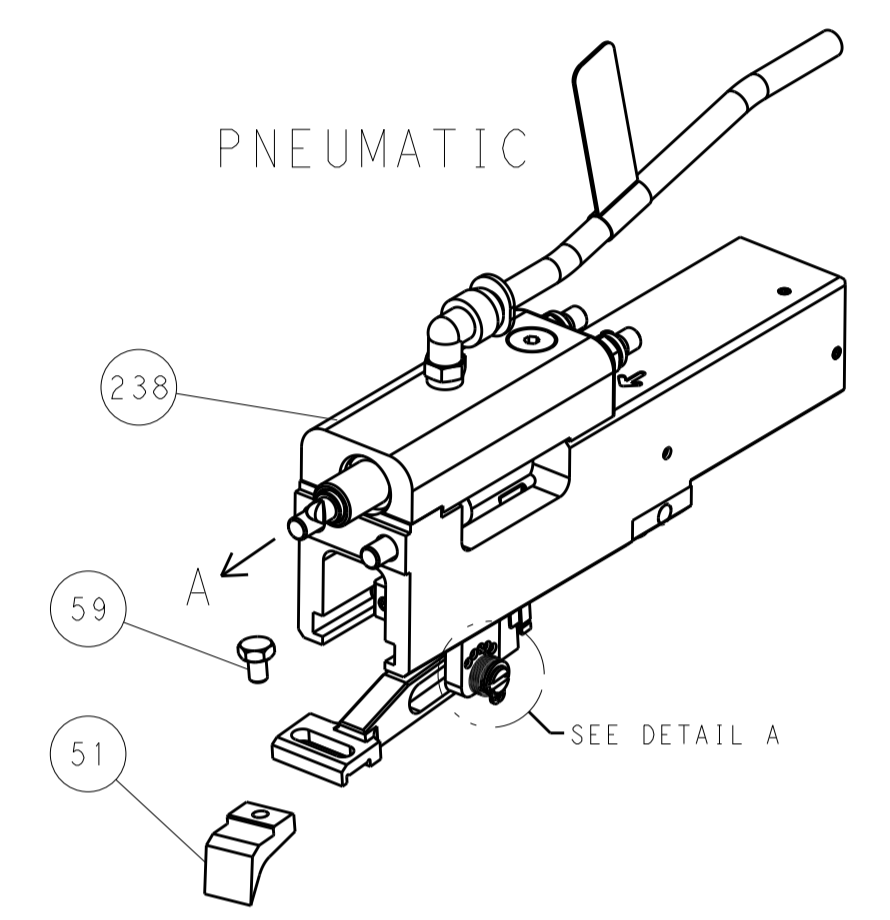
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG		CHK		APPV		NAME	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	31JULY2014	31JULY2014	31JULY2014	31JULY2014	TE Connectivity	TE Connectivity
	ANGLES	FINISH				G. BAILEY	T. ERLIN			Harrisburg, PA 17105-3608	
MATERIAL										Ocean End Feed Applicator	
										SIZE	CAGE CODE
										A1	00779
										SCALE	1:1
										SHEET	3 OF 4
										REV	C

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

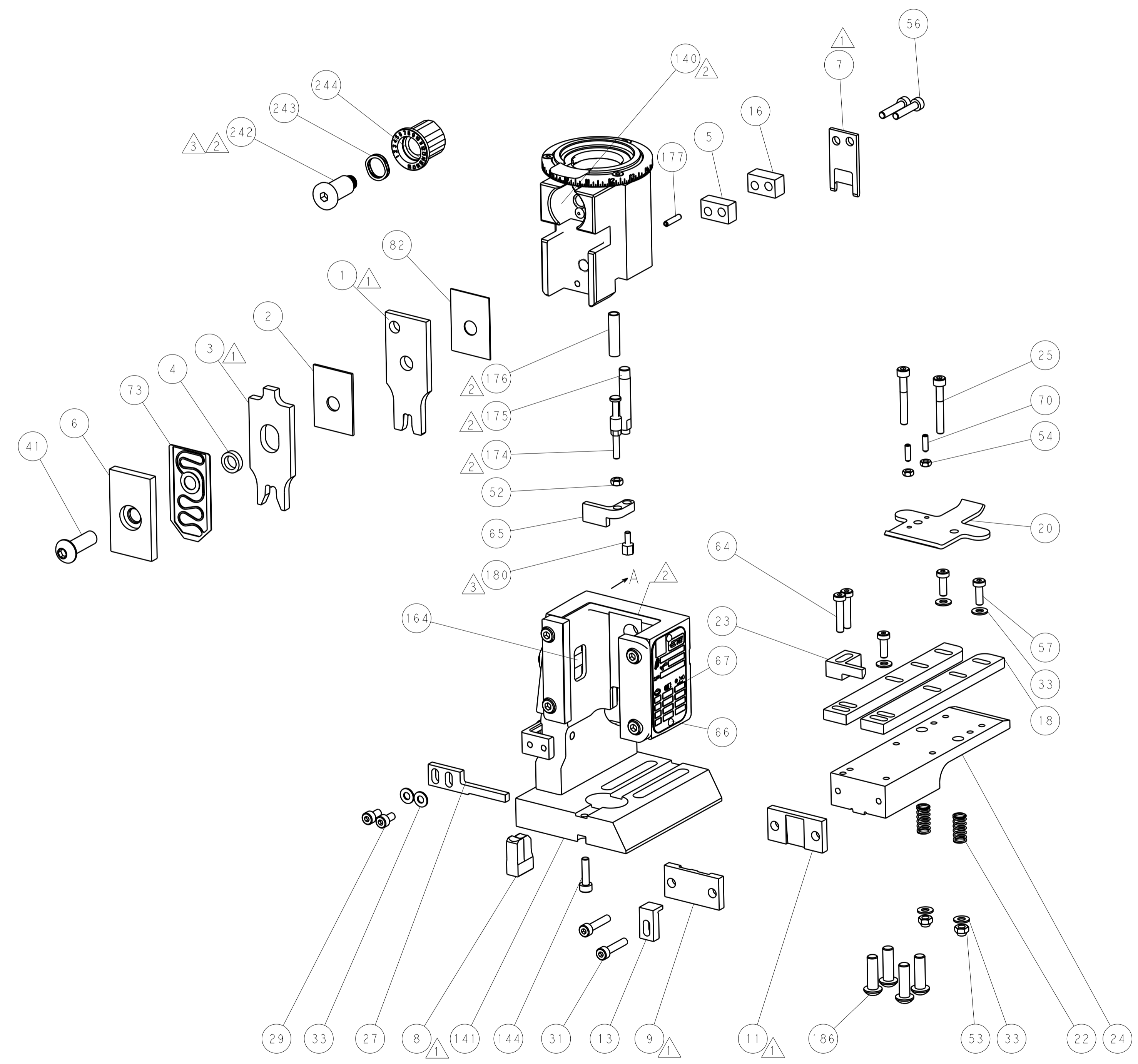
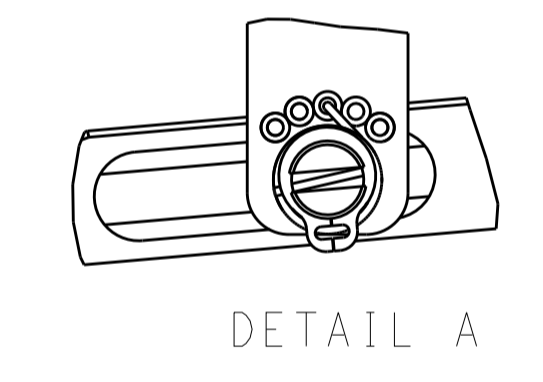


RAM AND HOLDDOWN SET-UP

FEED TYPE

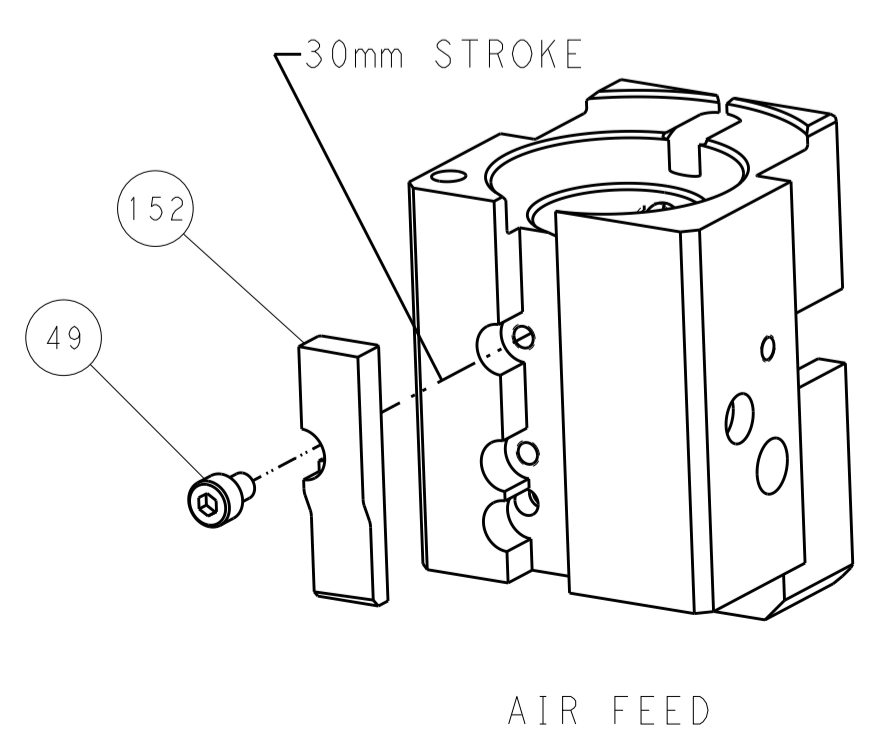


FEED SPRING SETTING POSITION



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

CAM POSITION



AIR FEED

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG: K. STANEM 31JULY2014		TE Connectivity	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	5 PLC ±	Harrisburg, PA 17105-3608
	ANGLES	FINISH		CHK: G. BAILEY 31JULY2014		NAME: Ocean End Feed Applicator	
MATERIAL:				APVD: T. ERLIN 31JULY2014		SIZE: CAGE CODE: DRAWING NO: 00779 ©=2150471	
Customer Accessible Production Drawing				SCALE: 1:1		SHEET 4 OF 4 REV C	