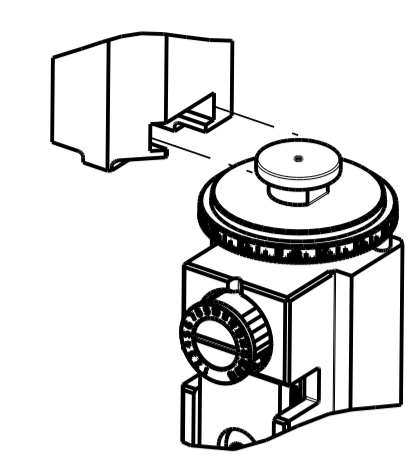


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150283-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2150283-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150283-1	B	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2150283-2	C	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150283-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.03 mm [.080]	F
INSUL	3.30 mm [.130]	F
APPL INSTRUCTIONS 408-35042		

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION			
TERMINAL NAME: TERMINAL RING			
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE		
3.58-3.96 mm [.141-.156 IN]	∅2.03-2.54 mm [.080-.100 IN]		
TERMINAL APPLICATION SPECIFICATION	114-2084		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
41582	41580	41589	41579
41581	41590		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
20 AWG	1.45 +/- 0.05 [.057 +/- .002]	9.6
(2)24	1.37 +/- 0.05 [.054 +/- .002]	10.4
22 AWG	1.37 +/- 0.05 [.054 +/- .002]	10.4
24 AWG	1.32 +/- 0.05 [.052 +/- .002]	10.9

- 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 ITEMS 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.

**\*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.

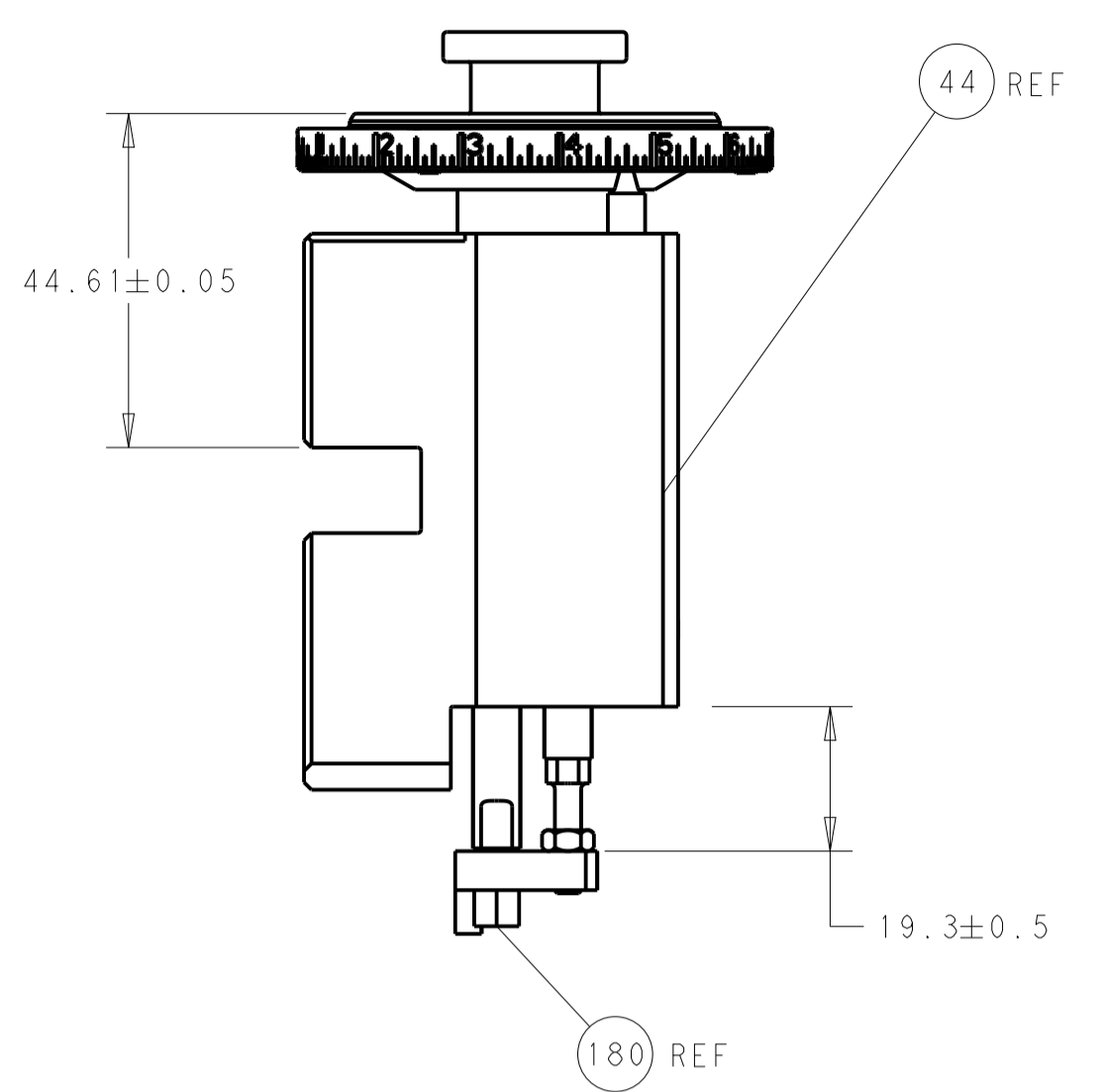
LOC	DIST	REVISIONS			
A	66	REV	DATE	BY	APP'D
		B	ECR-19-000292	08JAN2019	JAH CT
		C	ECR-21-003095	11MAR2021	FJ TE

-	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	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
-	1	1	1	1	1752354-4	STANDOFF, HOLD-DOWN	180
-	1	1	1	1	6-993111-6	PIN, SLOTTED SPRING 3.0 X 14.0	177
-	1	1	1	1	8-22280-7	SPRING, COMPRESSION	176
-	1	1	1	1	1752353-2	GUIDE PIN, HOLDDOWN	175
-	1	1	1	1	1901680-2	GUIDE PIN, HOLDDOWN	174
-	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	1	1	1	1	455888-5	SPACER, CRIMPER	82
-	1	1	1	1	2119791-9	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	2119740-1	TAG, IDENTIFICATION	67
-	2	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	1	1	1	1	1901681-1	HOLDDOWN, TERMINAL	65
-	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	1	1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52
-	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	1803292-1	DRAG	20
-	1	1	1	1	1901696-2	STRIP GUIDE, REAR	19
-	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	6-240641-4	SPACER	16
-	1	1	1	1	1752360-1	SPACER, HOLD-DOWN	13
-	1	1	1	1	240644-9	PLATE, REAR SHEAR	11
-	2	2	2	2	1-240645-2	SPACER, SHEAR PLATE	10
-	1	1	1	1	2-240642-2	PLATE, FRONT SHEAR	9
-	1	2	2	1	1-1803001-0	ANVIL, COMBINATION, END FEED	8
-	1	1	1	1	2-240651-0	BLADE, SLUG	7
-	-	-	-	-	-	-	6
-	1	1	1	1	4-240641-1	SPACER	5
-	1	1	1	1	238011-2	BLOCK, CRIMPER SPACER	4
-	1	2	2	1	2-1633961-6	CRIMPER, INSULATION F PREMIUM	3
-	-	-	-	-	-	-	2
-	1	2	2	1	1-456405-5	CRIMPER, WIRE PREMIUM	1
-	77	72	71	2	-1	PART NO	ITEM NO

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

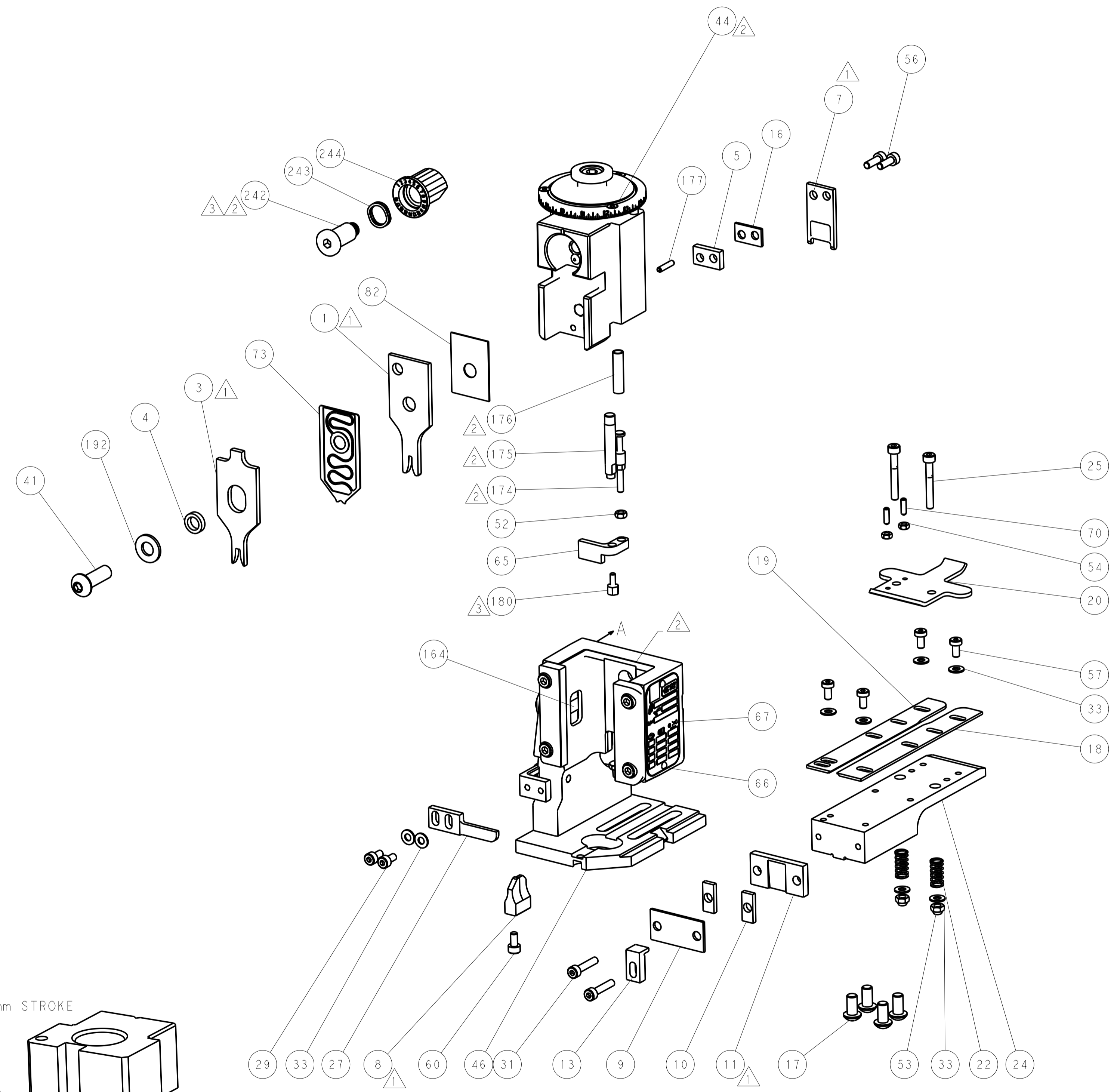
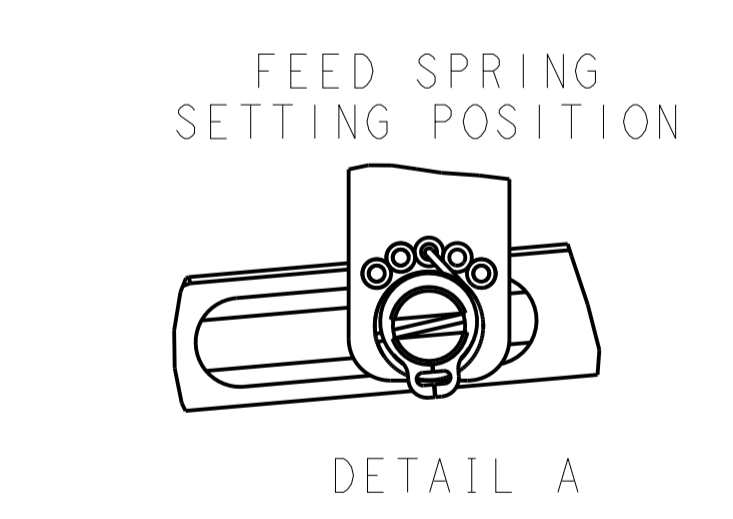
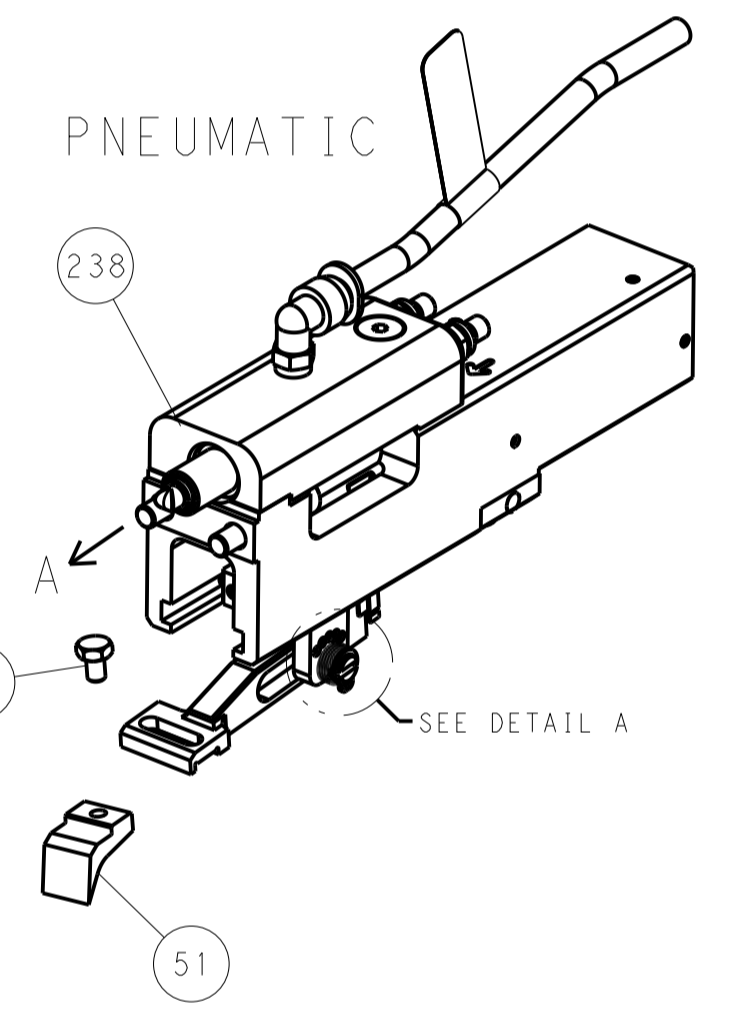
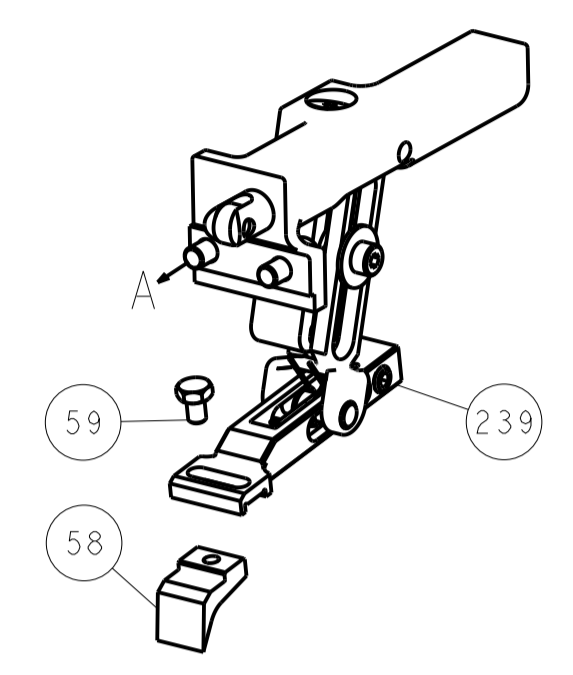
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG		CHK		APVD		NAME	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	J. HAYNES	R. KNEPPER	J. HAYNES	R. KNEPPER	TE Connectivity	Ocean End Feed Applicator
MATERIAL:		FINISH:		WEIGHT:		SCALE:		SHEET:		REV:	
						1:1		1 OF 4		C	

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

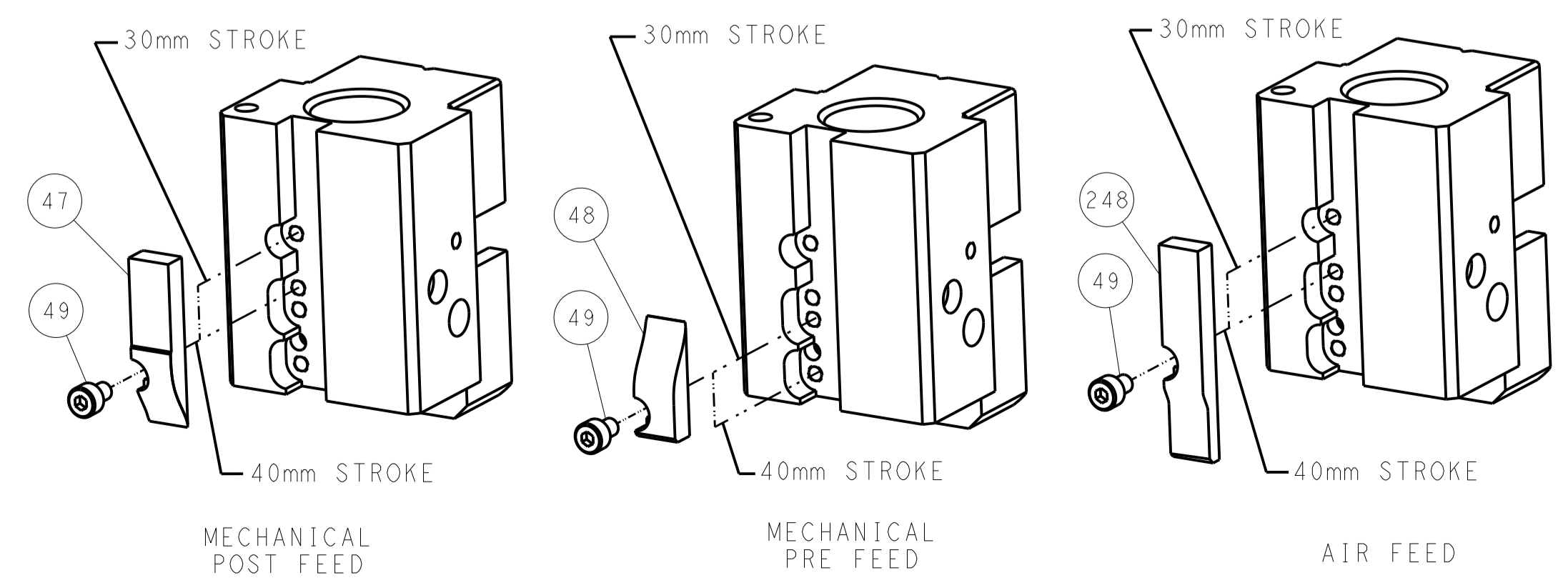


RAM AND HOLDDOWN SET-UP

FEED TYPE  
MECHANICAL



CAM POSITIONS

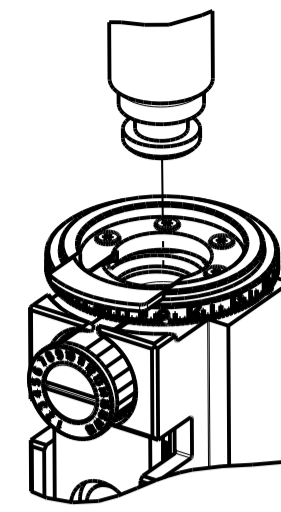


ATLANTIC VERSION  
 Shown on sheets 1 of 4 & 2 of 4  
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		DWN J. HAYNES 8JAN2019 CHK R. KNEPPER 8JAN2019 APPV C. TOPPER 8JAN2019		TE Connectivity Harrisburg, PA 17105-3608	
MATERIAL:		FINISH:		PRODUCT SPEC: APPLICATION SPEC:		NAME: Ocean End Feed Applicator	
WEIGHT:		SCALE: 1:1		SIZE: A11 00779 ©=2150283		RESTRICTED TO:	
Customer Accessible Production Drawing		SHEET 2 OF 4		REV C		SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION	

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150283-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2150283-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150283-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR  
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.03 mm [.080]	F
INSUL	3.30 mm [.130]	F
APPL INSTRUCTIONS 408-35042		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: TERMINAL RING			
WIRE STRIP LENGTH 3.58-3.96 mm [.141-.156 IN]		INSULATION DIAMETER RANGE Ø2.03-2.54 mm [.080-.100 IN]	
TERMINAL APPLICATION SPECIFICATION 114-2084			
TERMINALS APPLIED			
TE TERMINAL 41582	TE TERMINAL 41580	TE TERMINAL 41589	TE TERMINAL 41579
41581	41590		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
20 AWG	1.45+/-0.05 [.057+/-0.002]	9.6
(2)24	1.37+/-0.05 [.054+/-0.002]	10.4
22 AWG	1.37+/-0.05 [.054+/-0.002]	10.4
24 AWG	1.32+/-0.05 [.052+/-0.002]	10.9

- 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 ITEMS 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.

**\*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.

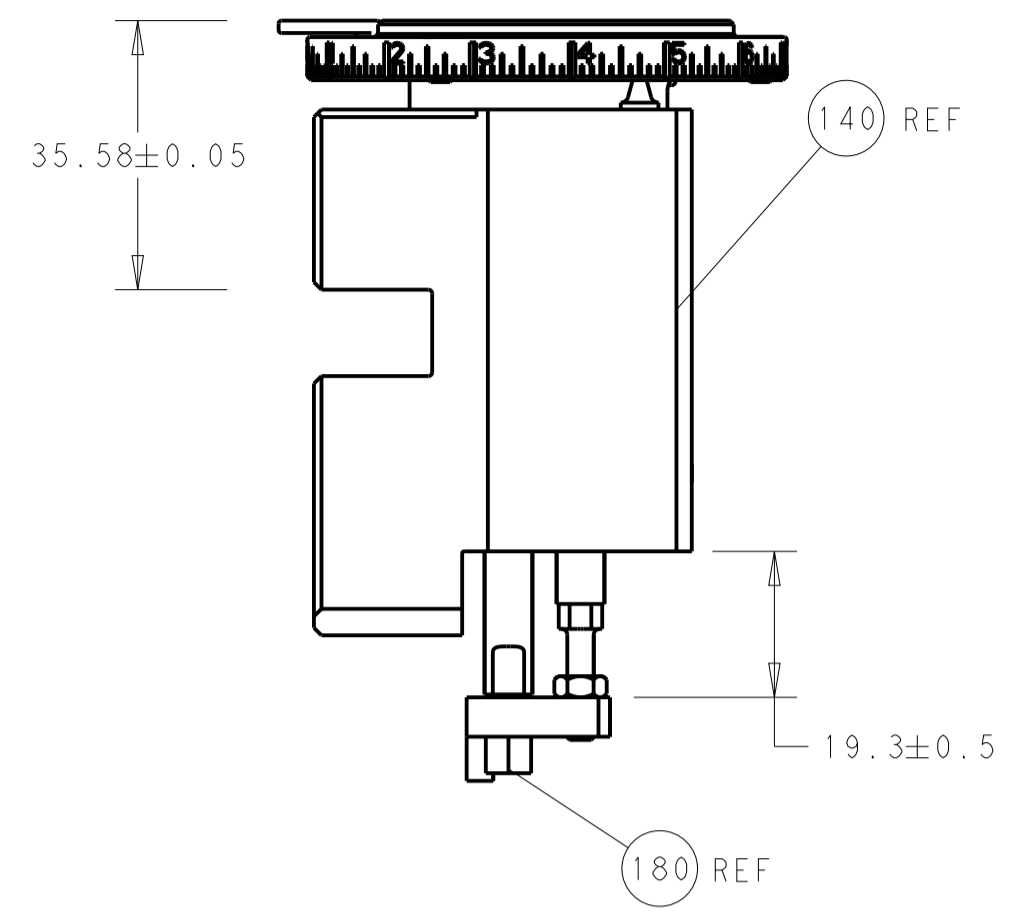
LOC	DIST	REVISIONS			
A	66	REV	DATE	BY	APPD
-	-	SEE SHEET 1	-	-	-

-	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	
-	1	1	1752354-4	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	-	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	1	455888-5	SPACER, CRIMPER	82	
-	1	1	2119791-9	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	
-	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	1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52	
-	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	1803292-1	DRAG	20	
-	1	1	1901696-2	STRIP GUIDE, REAR	19	
-	1	1	1901695-2	STRIP GUIDE, FRONT	18	
-	1	1	6-240641-4	SPACER	16	
-	1	1	1752360-1	SPACER, HOLD-DOWN	13	
-	1	1	240644-9	PLATE, REAR SHEAR	11	
-	2	2	1-240645-2	SPACER, SHEAR PLATE	10	
-	1	1	2-240642-2	PLATE, FRONT SHEAR	9	
-	1	1	1-1803001-0	ANVIL, COMBINATION, END FEED	8	
-	1	1	2-240651-0	BLADE, SLUG	7	
-	-	-	-	-	6	
-	1	1	4-240641-1	SPACER	5	
-	1	1	238011-2	BLOCK, CRIMPER SPACER	4	
-	1	1	2-1633961-6	CRIMPER, INSULATION F PREMIUM	3	
-	-	-	-	-	2	
-	1	1	1-456405-5	CRIMPER, WIRE PREMIUM	1	
-	77	22	21	PART NO	DESCRIPTION	ITEM NO

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

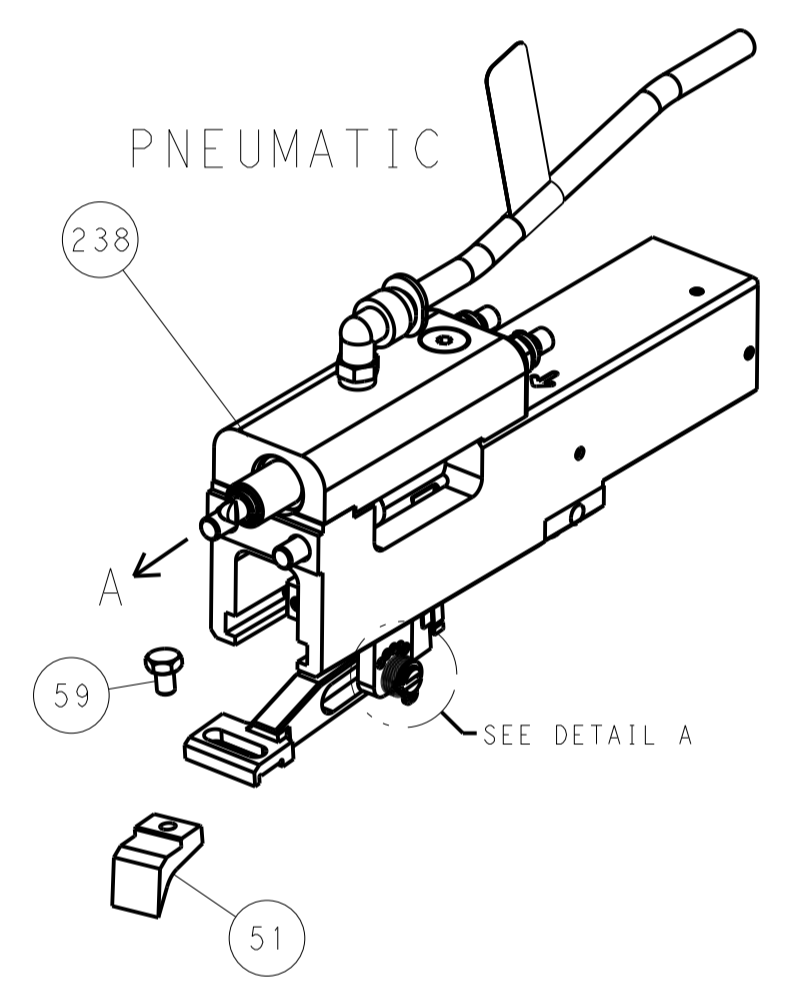
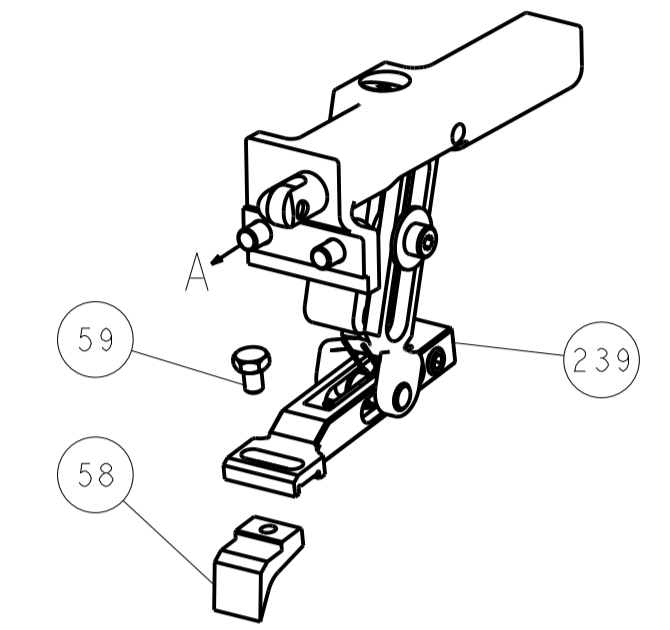
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DRAWN: J. HAYNES 8JAN2019		CHK: R. KNEPPER 8JAN2019		APPD: C. TOPPER 8JAN2019		NAME: TE Connectivity Harrisburg, PA 17105-3608	
mm		0 PLC ±		PRODUCT SPEC		APPLICATION SPEC		SIZE: A1		CAGE CODE: 00779	
FINISH:		ANGLES:		WEIGHT:		SCALE: 1:1		SHEET: 3 OF 4		REV: C	
MATERIAL:		FINISH:		WEIGHT:		SCALE: 1:1		SHEET: 3 OF 4		REV: C	

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

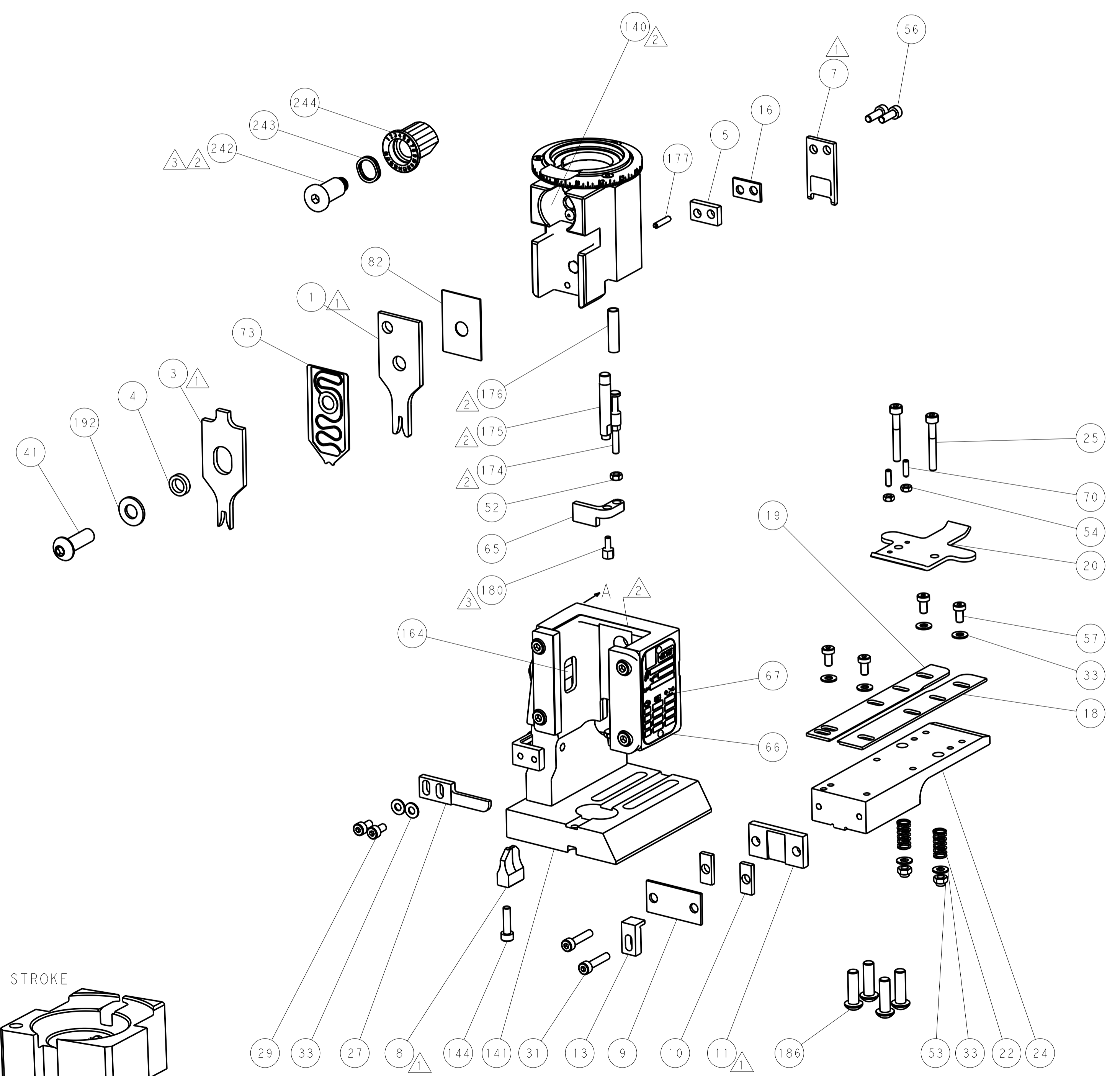
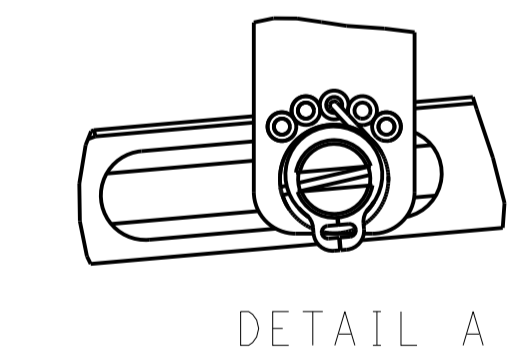


RAM AND HOLDDOWN SET-UP

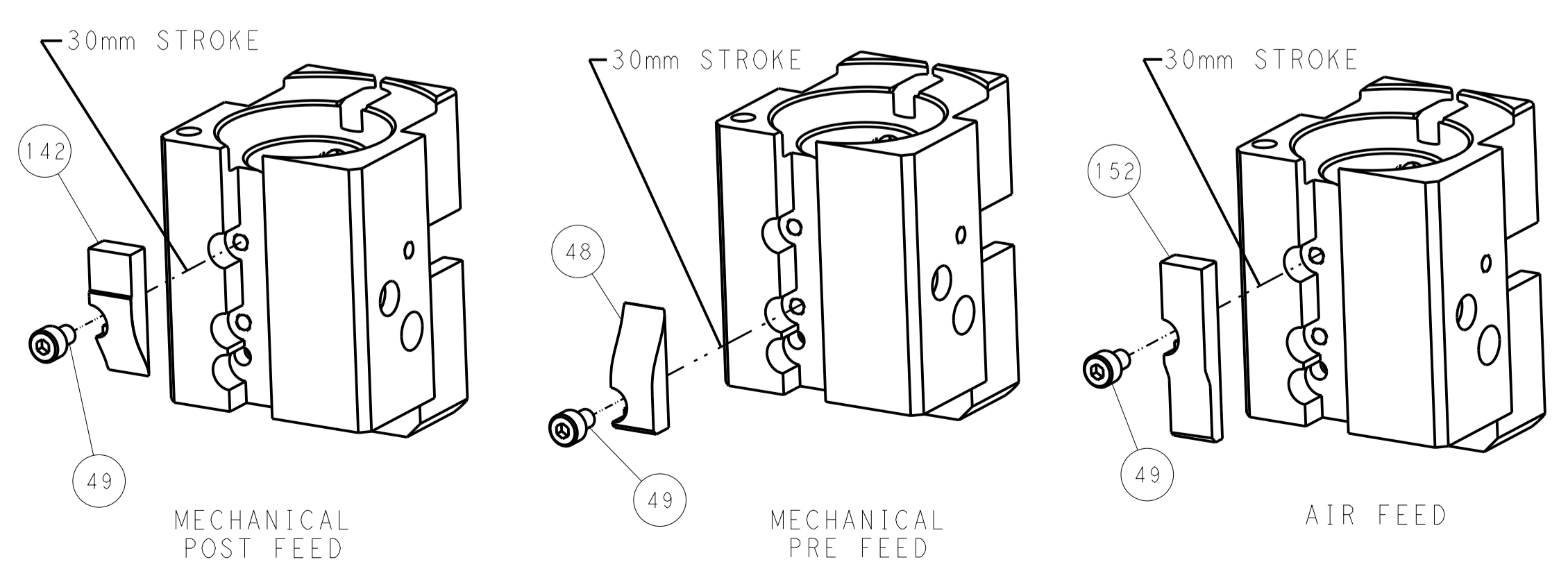
FEED TYPE  
MECHANICAL



FEED SPRING  
SETTING POSITION



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:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN J. HAYNES 8JAN2019		STE TE Connectivity	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	Harrisburg, PA 17105-3608	
MATERIAL:	FINISH:	OTHERWISE SPECIFIED:		CHK R. KNEPPER 8JAN2019		NAME Ocean End Feed Applicator	
				APVD C. TOPPER 8JAN2019		SIZE CAGE CODE DRAWING NO. RESTRICTED TO	
				PRODUCT SPEC		A 00779 ©=2150283	
				APPLICATION SPEC		Customer Accessible Production Drawing	
				WEIGHT		SCALE 1:1 SHEET 4 OF 4 REV C	
				ANGLES			