

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150342-1	D	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2150342-2	D	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150342-1	D	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2150342-2	D	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150342-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.78 mm [.070]	F
INSUL	3.30 mm [.130]	F
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: 110 SERIES FASTON RECEPTACLE			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
3.58-4.34 mm [.141-.171 IN]		∅2.00-3.00 mm [.079-.118 IN]	
TERMINAL APPLICATION SPECIFICATION	114-20109	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
160780-1	160780-4	160780-6	
160780-2	160780-5		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.50mm2	1.30 +/- 0.000 [.051 +/- .000]	5.9
1.00mm2	1.17 +/- 0.000 [.046 +/- .000]	7.4
0.75mm2	1.12 +/- 0.000 [.044 +/- .000]	7.9
0.50mm2	1.07 +/- 0.000 [.042 +/- .000]	8.3

- 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 50. 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.

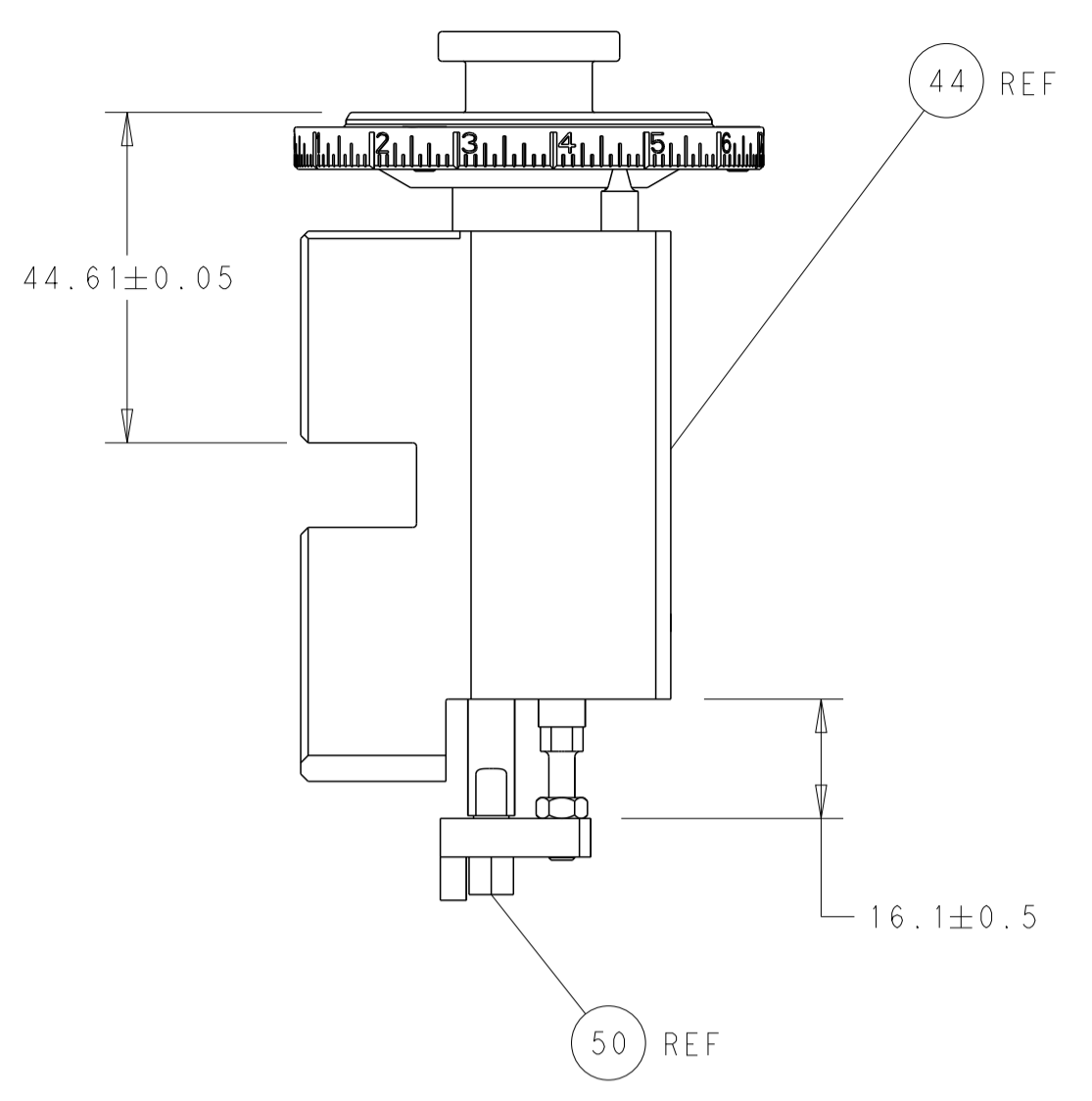
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

LOC	DIST	REVISIONS					
A	66	P	LTN	DESCRIPTION	DATE	OWN	APVD
		A		RELEASED	10JUL2013	GH	TE
		B		ECR-17-003561	18JUL2013	JDG	TE
		C		ECR-19-019845	20DEC2019	FZ	TE
		D		ECR-22-146251	18JUL2022	JWC	GB

-	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	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	2119955-2	ASSY, LUBRICATOR, END FEED	84	
-	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	1901681-5	HOLDDOWN, TERMINAL	65	
-	2	2	2	2	2168400-5	SHCS, LOW HEAD, RoHS, M4 X 20	64	
-	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	
-	3	3	3	3	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57	
-	2	2	2	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	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	-	2063961-9	FEED FINGER	51	
-	1	1	1	1	1752354-5	STANDOFF,HOLD-DOWN	50	
-	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	
-	7	7	7	7	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	
-	1	1	1	1	240825-2	PLATE, STRIP HOLD DOWN	23	
-	2	2	2	2	2-22281-3	SPRING, COMPRESSION	22	
-	1	1	1	1	1803292-4	DRAG	20	
-	1	1	1	1	1803152-3	STRIP GUIDE, REAR	19	
-	1	1	1	1	1803151-3	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	
-	2	2	2	2	1-240645-1	SPACER, SHEAR PLATE	10	
-	1	1	1	1	2-240642-2	PLATE, FRONT SHEAR	9	
-	1	2	2	1	1	2-1803000-9	ANVIL, COMBINATION, END FEED	8
-	1	1	1	1	8-240651-7	BLADE, SLUG	7	
-	-	-	-	-	-	-	6	
-	1	1	1	1	2-240641-0	SPACER	5	
-	1	1	1	1	238011-7	BLOCK, CRIMPER SPACER	4	
-	1	2	2	1	1	2119582-1	CRIMPER, INSULATION F PREMIUM	3
-	-	-	-	-	-	-	2	
-	1	2	2	1	1	3-456404-5	CRIMPER, WIRE PREMIUM	1
-	77	72	71	2	-1	PART NO	DESCRIPTION	ITEM NO

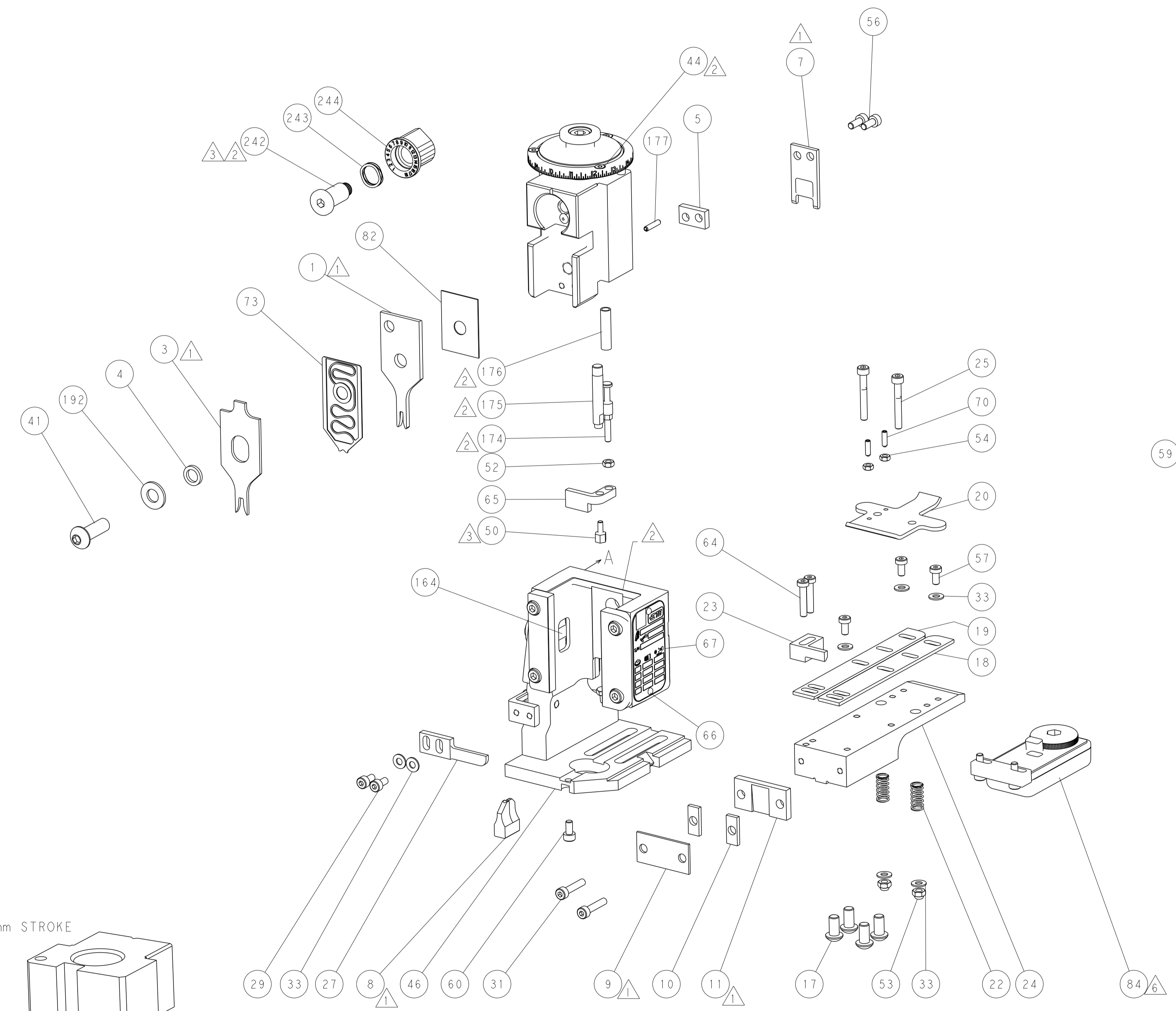
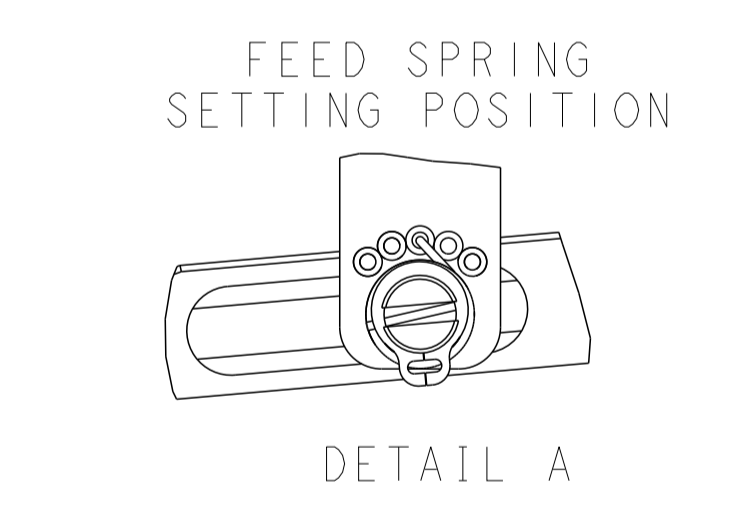
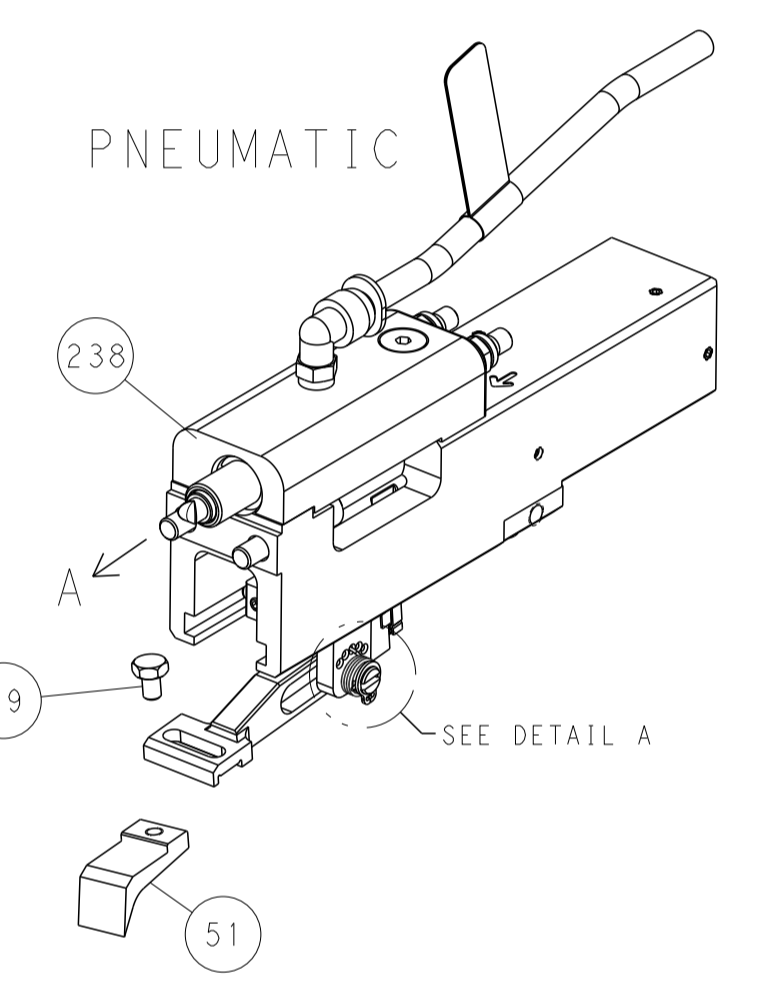
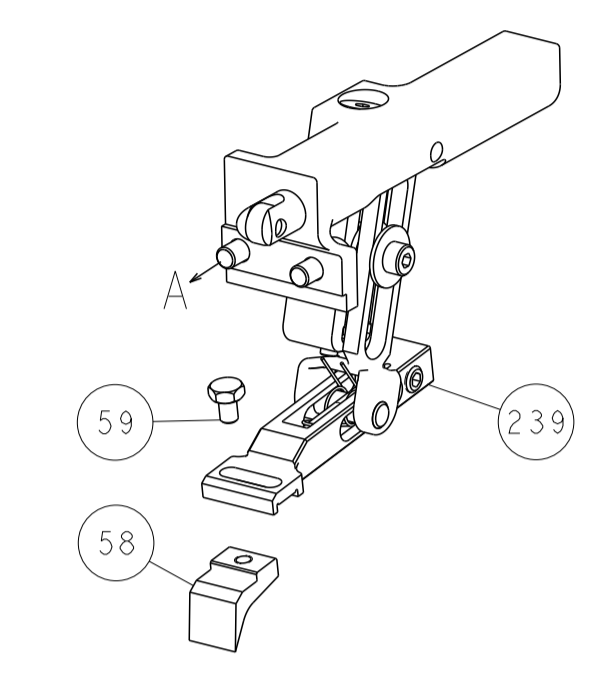
DIMENSIONS: 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH ±		DWG: HOFFNER 10MAY2013 CHK: T.ELBIN 13MAY2013 APVD: T.ELBIN 13MAY2013 PRODUCT SPEC APPLICATION SPEC WEIGHT: - SCALE: A1 00779 ©=2150342 Customer Accessible Production Drawing		TE Connectivity Harrisburg, PA 17105-3608 Ocean End Feed Applicator SIZE: - CAGE CODE: - DRAWING NO: - RESTRICTED TO: - SHEET 1 OF 4 REV D	
-----------------	--	---	--	---	--	---	--

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

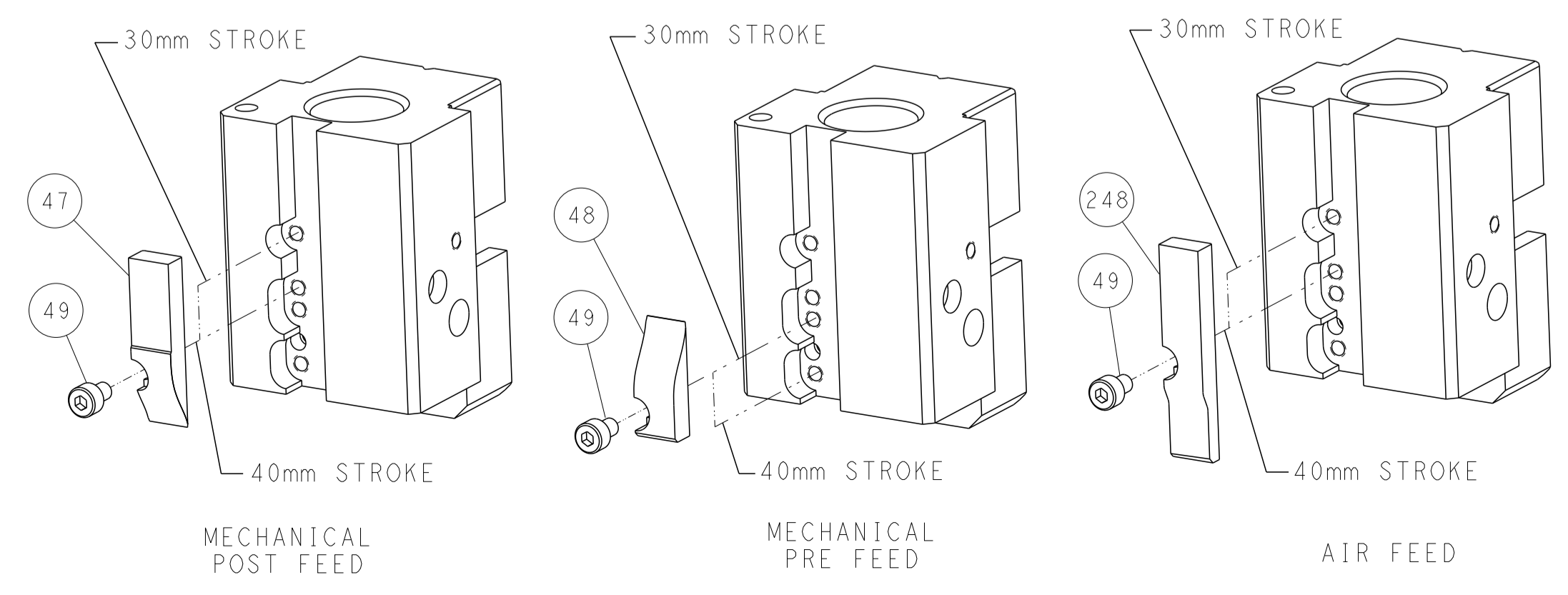


RAM AND HOLDDOWN SET-UP

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 ± FINISH		DWN: HOFFNER 10MAY2013 CHK: T. ELBIN 13MAY2013 APVD: T. ELBIN 13MAY2013 PRODUCT SPEC APPLICATION SPEC WEIGHT Customer Accessible Production Drawing		NAME: Ocean End Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2150342 SCALE: 1:1 SHEET: 2 of 4 REV: D	
--------------------	--	---	--	---	--	---	--

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150342-1	D	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2150342-2	D	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150342-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.78 mm [.070]	F
INSUL	3.30 mm [.130]	F
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: 110 SERIES FASTON RECEPTACLE			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
3.58-4.34 mm [.141-.171 IN]		∅2.00-3.00 mm [.079-.118 IN]	
TERMINAL APPLICATION SPECIFICATION	114-20109		
TERMINALS APPLIED ⁶			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
160780-1	160780-4	160780-6	
160780-2	160780-5		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING ⁴
1.50mm2	1.30+/-0.000 [.051+/- .000]	5.9
1.00mm2	1.17+/-0.000 [.046+/- .000]	7.4
0.75mm2	1.12+/-0.000 [.044+/- .000]	7.9
0.50mm2	1.07+/-0.000 [.042+/- .000]	8.3

- 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 50. 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 LUBRICANT IS RECOMMENDED.

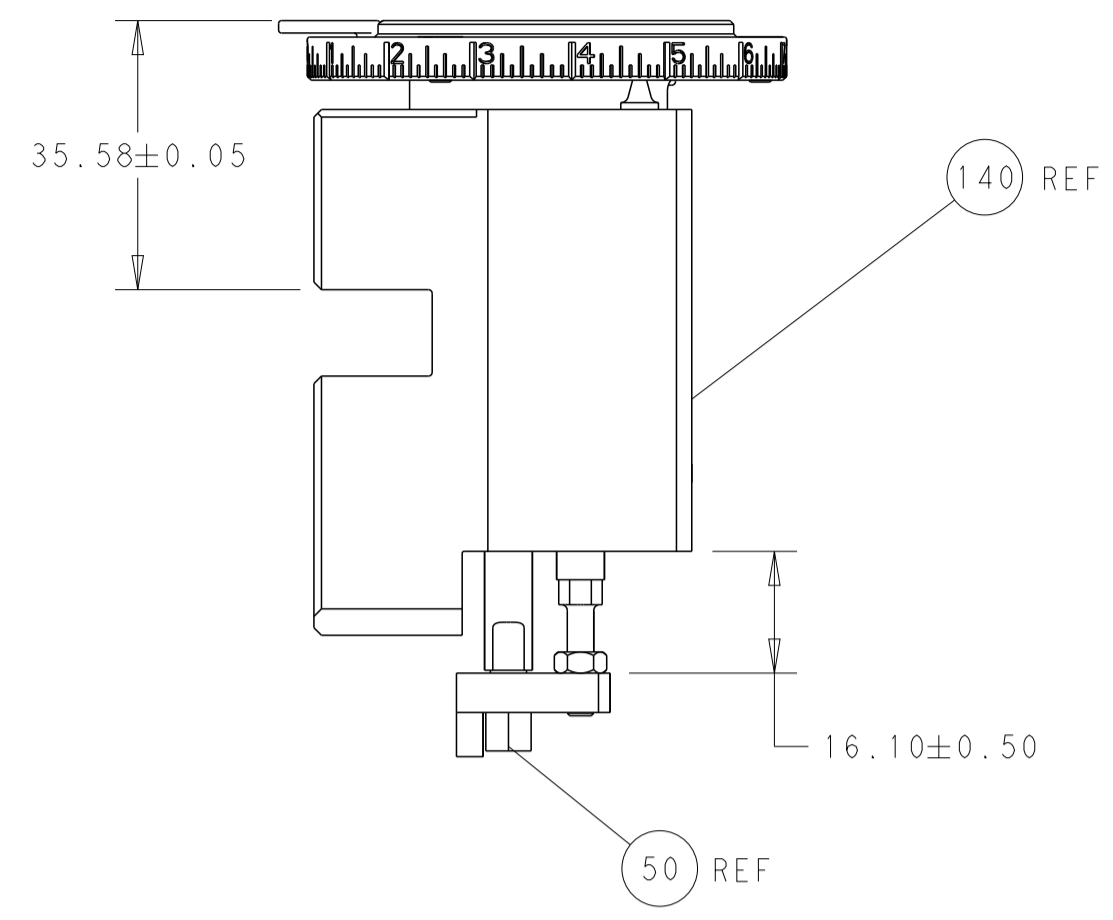
***WARNING**
ON INSTALLATION, SET WIRE DISC TO CRIMP HEIGHT REFERENCE SETTING FOR LARGEST WIRE SIZE. CRIMP HEIGHT REFERENCE SETTINGS GREATER THAN THE VALUE SHOWN MAY CAUSE DAMAGE TO THE CRIMP TOOLING, REFER TO THE INSTRUCTION SHEET FOR PROPER SETUP AND ADJUSTMENTS.

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	LTN	DESCRIPTION	DATE	OWN	APVD	
		-	-	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	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	2119955-2	ASSY, LUBRICATOR, END FEED	84	
		-	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	1901681-5	HOLDDOWN, TERMINAL	65	
		-	2	2	2168400-5	SHCS, LOW HEAD, RoHS, M4 X 20	64	
		-	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59	
		-	-	1	2063961-1	FEED FINGER	58	
		-	3	3	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57	
		-	2	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	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	-	2063961-9	FEED FINGER	51	
		-	1	1	1752354-5	STANDOFF,HOLD-DOWN	50	
		-	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	
		-	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	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	
		-	1	1	240825-2	PLATE, STRIP HOLD DOWN	23	
		-	2	2	2-22281-3	SPRING, COMPRESSION	22	
		-	1	1	1803292-4	DRAG	20	
		-	1	1	1803152-3	STRIP GUIDE, REAR	19	
		-	1	1	1803151-3	STRIP GUIDE, FRONT	18	
		-	1	1	240644-1	PLATE, REAR SHEAR	11	
		-	2	2	1-240645-1	SPACER, SHEAR PLATE	10	
		-	1	1	2-240642-2	PLATE, FRONT SHEAR	9	
		-	1	1	1	2-1803000-9	ANVIL, COMBINATION, END FEED	8
		-	1	1	1	8-240651-7	BLADE, SLUG	7
		-	-	-	-	-	6	
		-	1	1	1	2-240641-0	SPACER	5
		-	1	1	1	238011-7	BLOCK, CRIMPER SPACER	4
		-	1	1	1	2119582-1	CRIMPER, INSULATION F PREMIUM	3
		-	-	-	-	-	2	
		-	1	1	1	3-456404-5	CRIMPER, WIRE PREMIUM	1
		-	77	22	21	PART NO	ITEM NO	

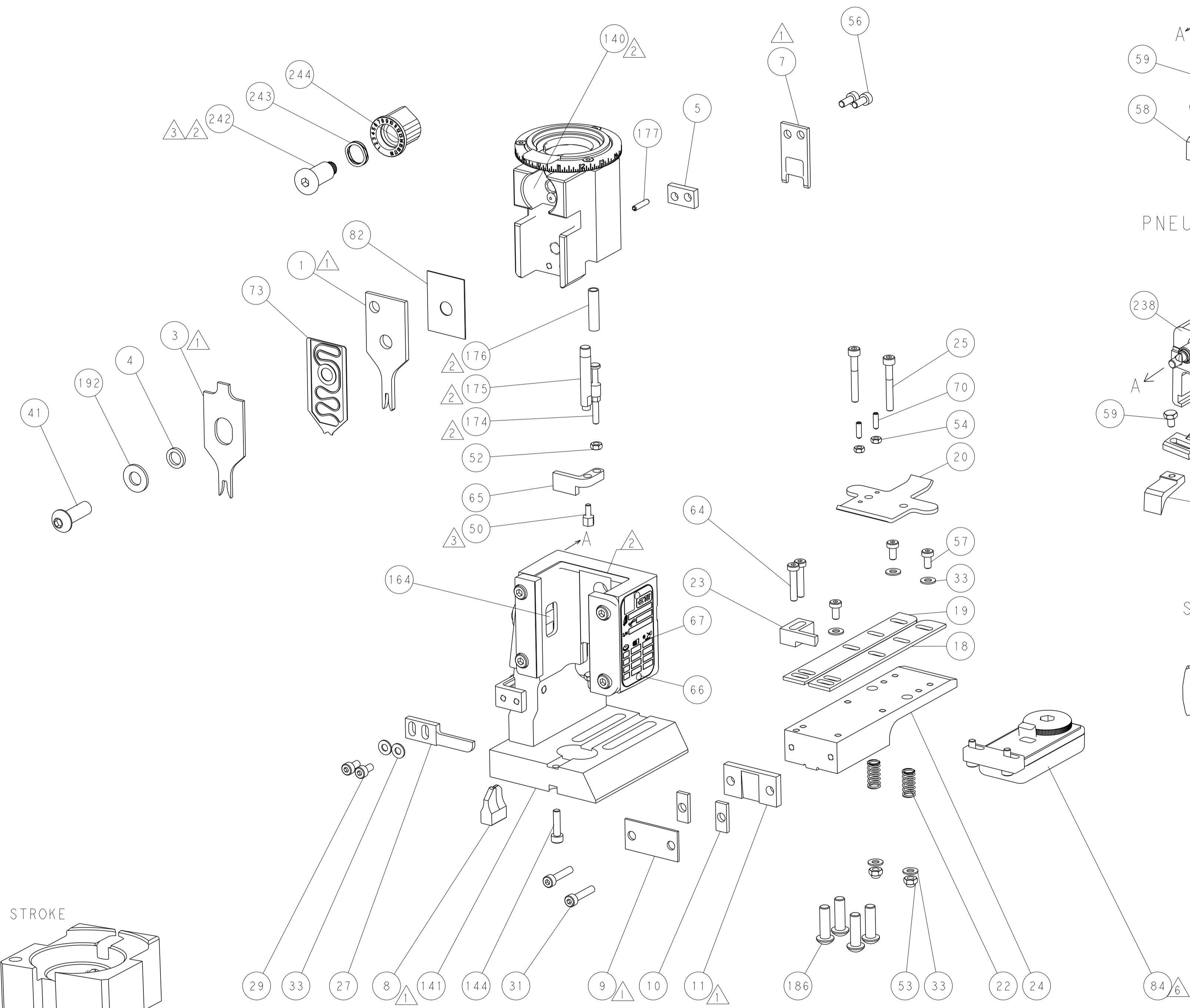
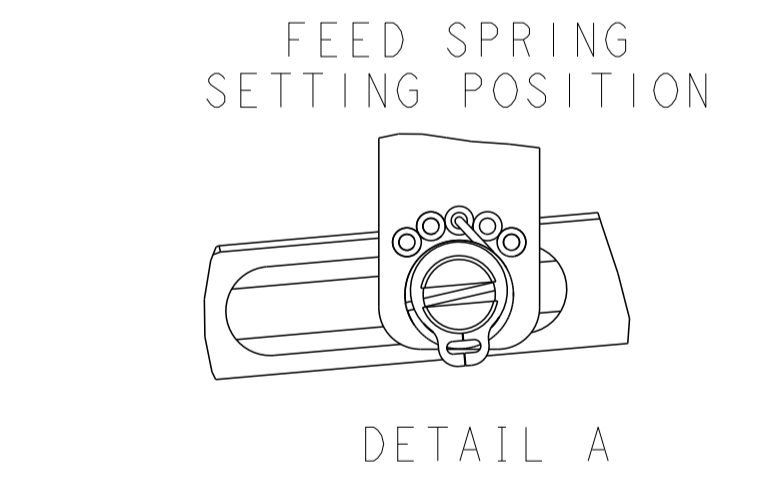
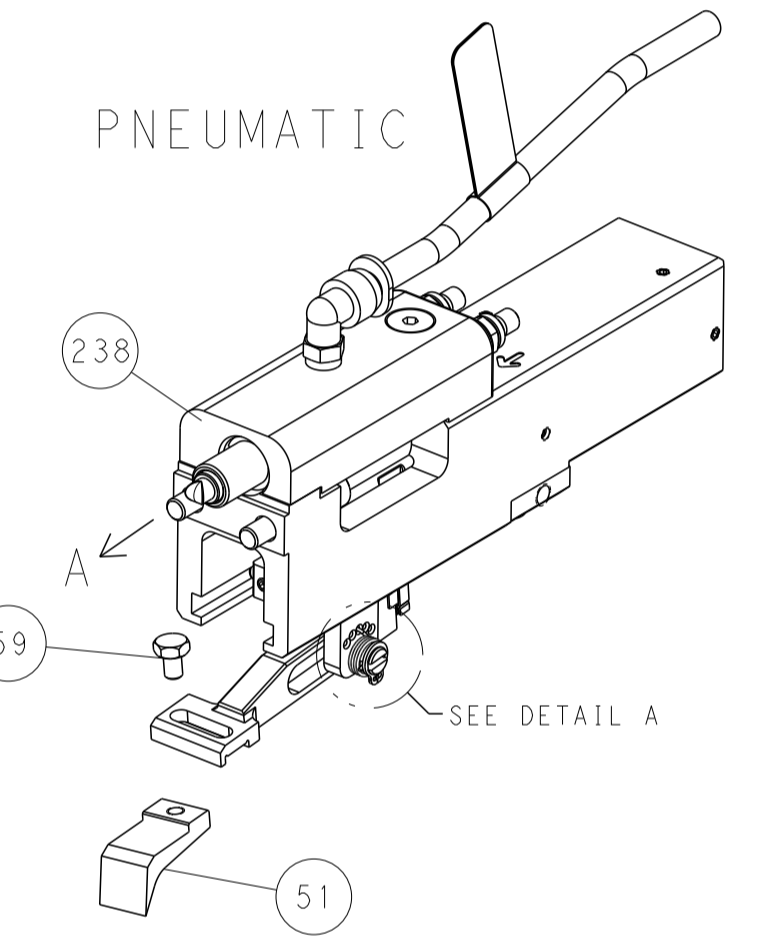
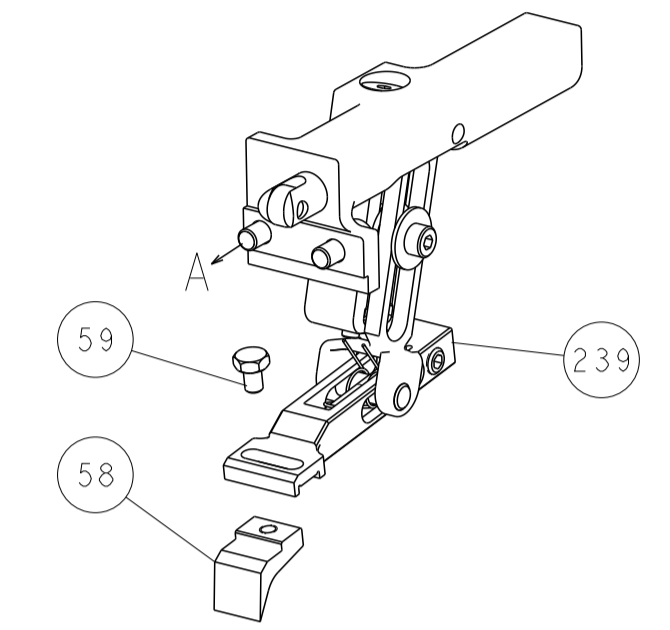
<small>THIS DRAWING IS CONTROLLED DOCUMENT. UNLESS OTHERWISE SPECIFIED, THE DIMENSIONS TO BE USED FOR FABRICATION AND ASSEMBLY SHALL BE THE DIMENSIONS SHOWN ON THIS DRAWING.</small>		DWN: HOFFNER 10MAY2013 CHK: T.ELBIN 13MAY2013 APVD: T.ELBIN 13MAY2013	TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm 	TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH	NAME: Ocean End Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2150342 RESTRICTED TO:	SCALE: 1:1 SHEET: 3 OF 4 REV: D
MATERIAL: -		WEIGHT: -	Customer Accessible Production Drawing

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

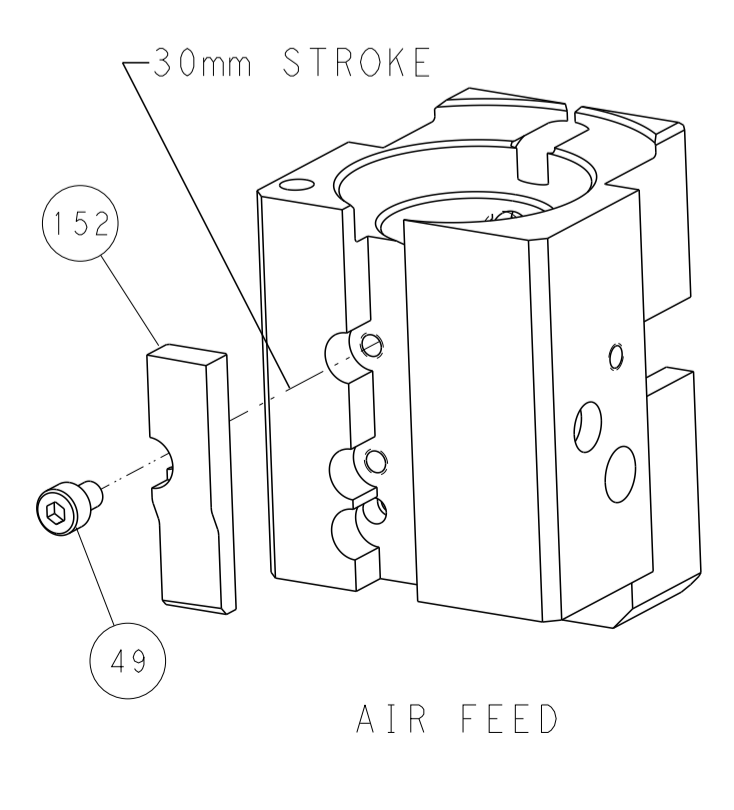
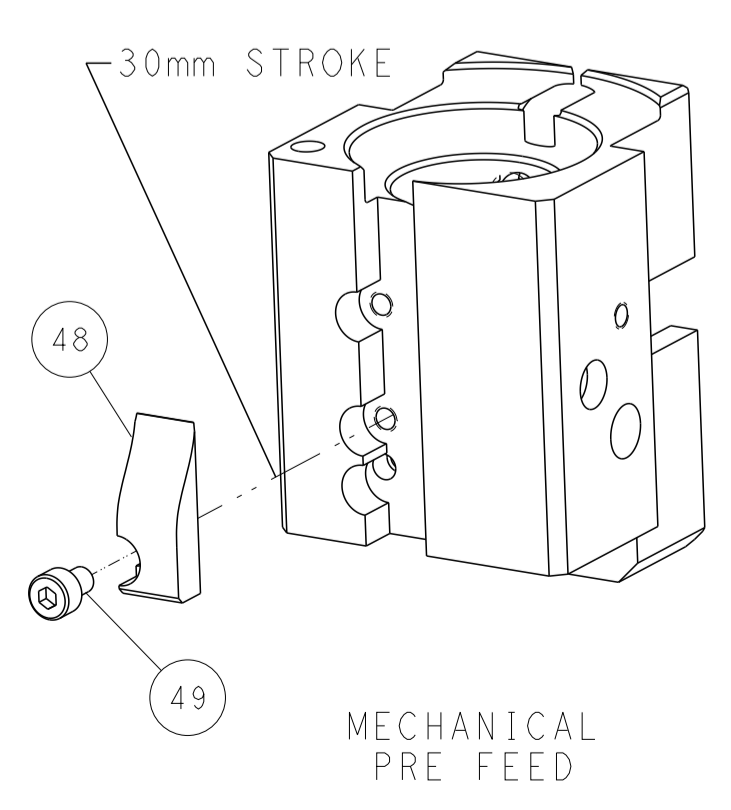
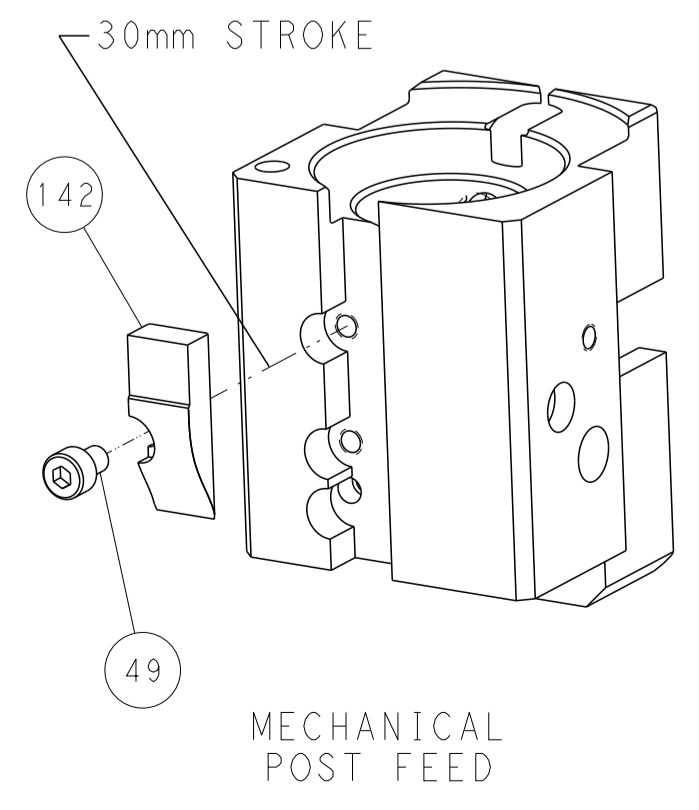


RAM AND HOLDDOWN SET-UP

FEED TYPE
MECHANICAL



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:		OWN: HOFFNER 10MAY2013		TE Connectivity	
mm		0 PLC ±		CHK: T. ELBIN 13MAY2013		Harrisburg, PA 17105-3608	
Ø		1 PLC ±		APVD: T. ELBIN 13MAY2013		NAME: Ocean End Feed Applicator	
MATERIAL:		FINISH:		PRODUCT SPEC:		RESTRICTED TO:	
				APPLICATION SPEC:		SIZE: CAGE CODE: DRAWING NO:	
				WEIGHT:		A 00779 ©=2150342	
				Customer Accessible Production Drawing		SCALE: 1:1 SHEET 4 OF 4 REV D	