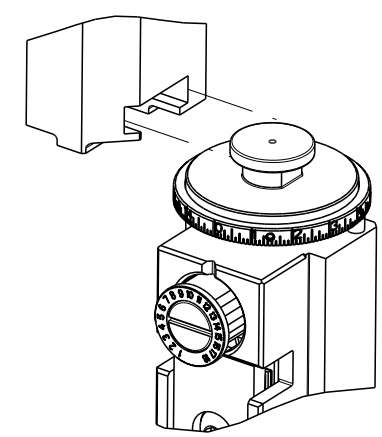


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150544-2	D	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150544-2	D	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150544-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER

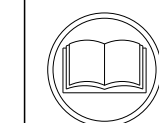


APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	3.56 mm [.140]	F
INSUL	4.32 mm [.170]	F
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: RECEPTACLE, CLUSTER PIN, AMPLIVAR			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
3.58-4.34 mm [.141-.171 IN]		∅2.29-4.32 mm [.090-.170 IN]	
TERMINAL APPLICATION SPECIFICATION	114-2019	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
63455-1			

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: RECEPTACLE, CLUSTER PIN, AMPLIVAR			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
3.58-4.34 mm [.141-.171 IN]		∅ 3.81 mm [.150 IN] MAX	
TERMINAL APPLICATION SPECIFICATION	114-2019	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
1217173-1	1217173-3		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
7600-8500 CMA	2.36 +/- 0.05 [.093 +/- .002]	5.6
4000-4800 CMA	1.98 +/- 0.05 [.078 +/- .002]	9.3



- 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 ITEMS 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.
 - TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
 - TERMINAL LUBRICANT IS RECOMMENDED.
7. 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.

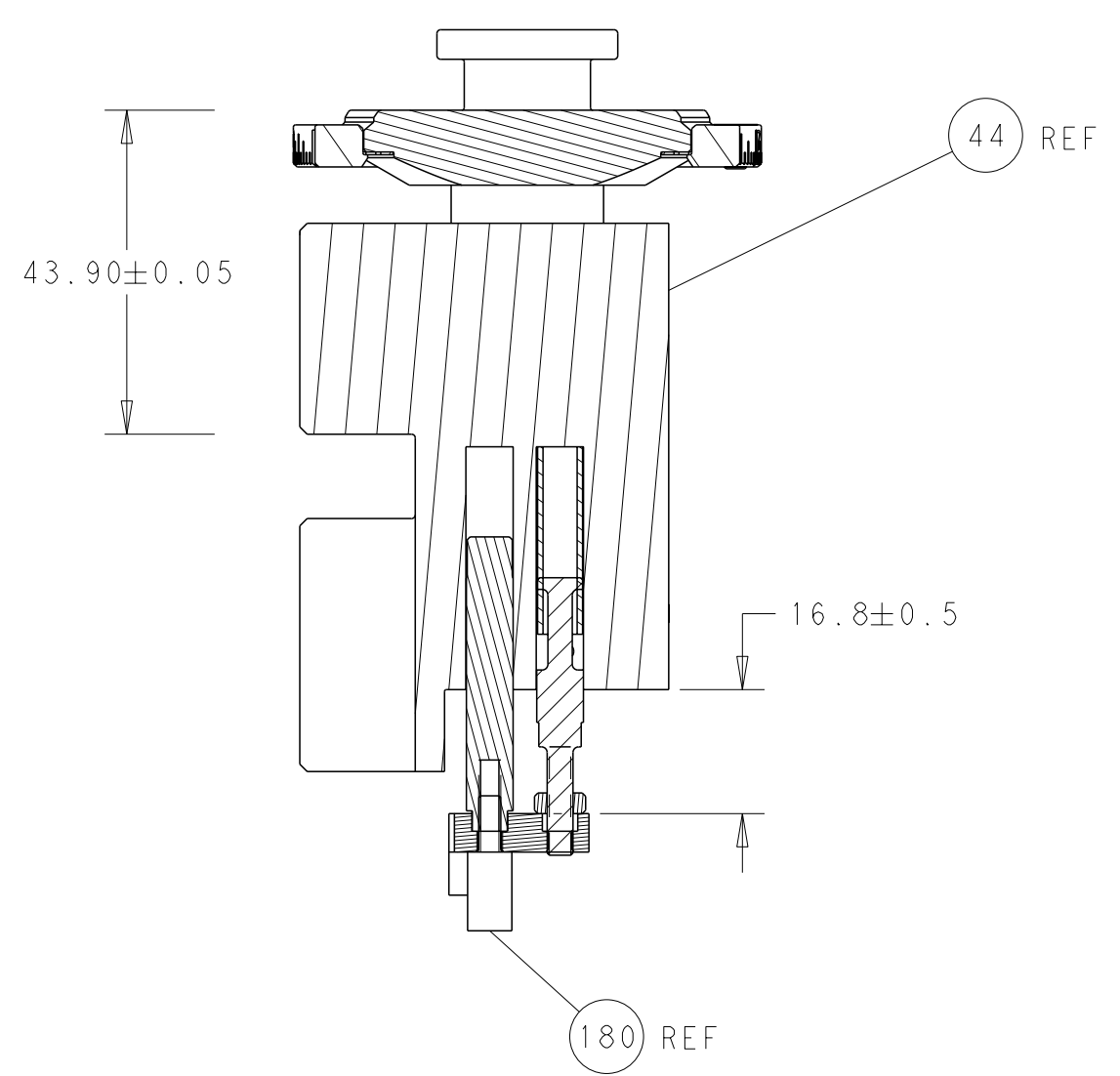
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

LOC	DIST	REVISIONS					
		#	LY#	DESCRIPTION	DATE	OWN	APVD
A	66	B		ECR-17-001231	27JAN2017	RK	TE
		C		ECR-18-016809	24OCT2018	MZ	KZ
		D		ECR-18-019120	10DEC2018	KH	LZ

-	1	1	2119640-1	PUSH ROD, AIR FEED	250		
-	1	1	1803259-1	BUSHING, FLANGED	249		
-	1	1	2119641-1	FEED CAM, AIR FEED	248		
-	1	1	2119082-4	CAM, SNAIL, INSULATION ADJUSTMENT	244		
-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243		
	-	1	2119083-1	RETAINER, INSULATION DIAL	242		
-	-	-	2119580-1	MECHANICAL FEED ASSEMBLY	239		
-	1	1	2063440-2	AIR FEED MODULE	238		
-	1	1	1-18028-0	WASHER, FLAT, REG M8	192		
	-	1	2-1752354-7	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		
-	2	2	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172		
-	REF	REF	994970-2	COUNTER, MAGNETIC	164		
-	1	1	240638-1	SPRING, FEED FINGER	163		
	-	1	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854	137		
-	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	1803607-2	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		
-	-	-	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59		
-	-	-	2063961-1	FEED FINGER	58		
-	3	3	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	1	2119792-2	PAWL, EF, AIR	51		
-	1	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49		
-	-	-	2119652-1	FEED CAM, PRE FEED	48		
-	-	-	2119653-1	FEED CAM, POST FEED	47		
-	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	2079383-5	SCR, BHSC, RoHS (M4 X 20)	31		
-	2	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	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	240825-1	PLATE, STRIP HOLD DOWN	23		
-	2	2	2-22281-3	SPRING, COMPRESSION	22		
-	1	1	1803292-4	DRAG	20		
-	2	2	1901259-7	GUIDE, LOWER STRIP	18		
-	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17		
	-	1	1752360-1	SPACER, HOLD-DOWN	13		
	-	1	240644-1	PLATE, REAR SHEAR	11		
	-	1	690482-5	PLATE, FRONT SHEAR	9		
	1	2	1	1803064-8	ANVIL, COMBINATION	8	
-	1	1	4-690474-2	BLADE, SLUG	7		
-	1	1	8-240641-8	SPACER	5		
-	1	1	238011-2	BLOCK, CRIMPER SPACER	4		
	1	2	1	7-1633961-5	CRIMPER, INSULATION F PREMIUM	3	
-	1	1	455888-5	SPACER, CRIMPER	2		
	1	2	1	462808-7	CRIMPER, BLUNT F	1	
-	77	72	2	PART NO			
-				DESCRIPTION			
-				ITEM NO			

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		APPROVALS:		CUSTOMER ACCESSIBLE PRODUCTION DRAWING	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	SCALE	1:1
	ANGLES	FINISH		WEIGHT		SHEET	1 of 4
MATERIAL						REV	D

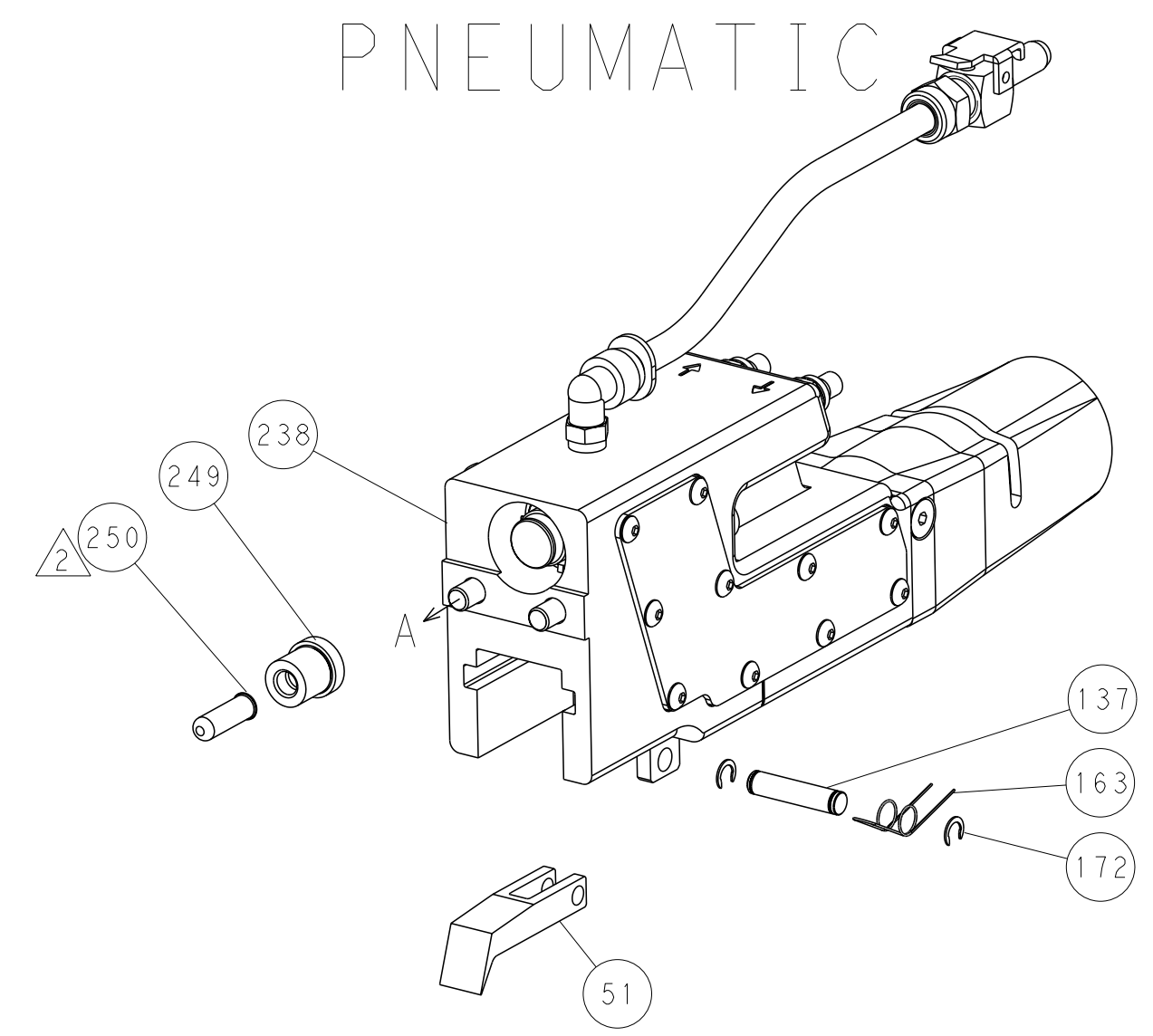
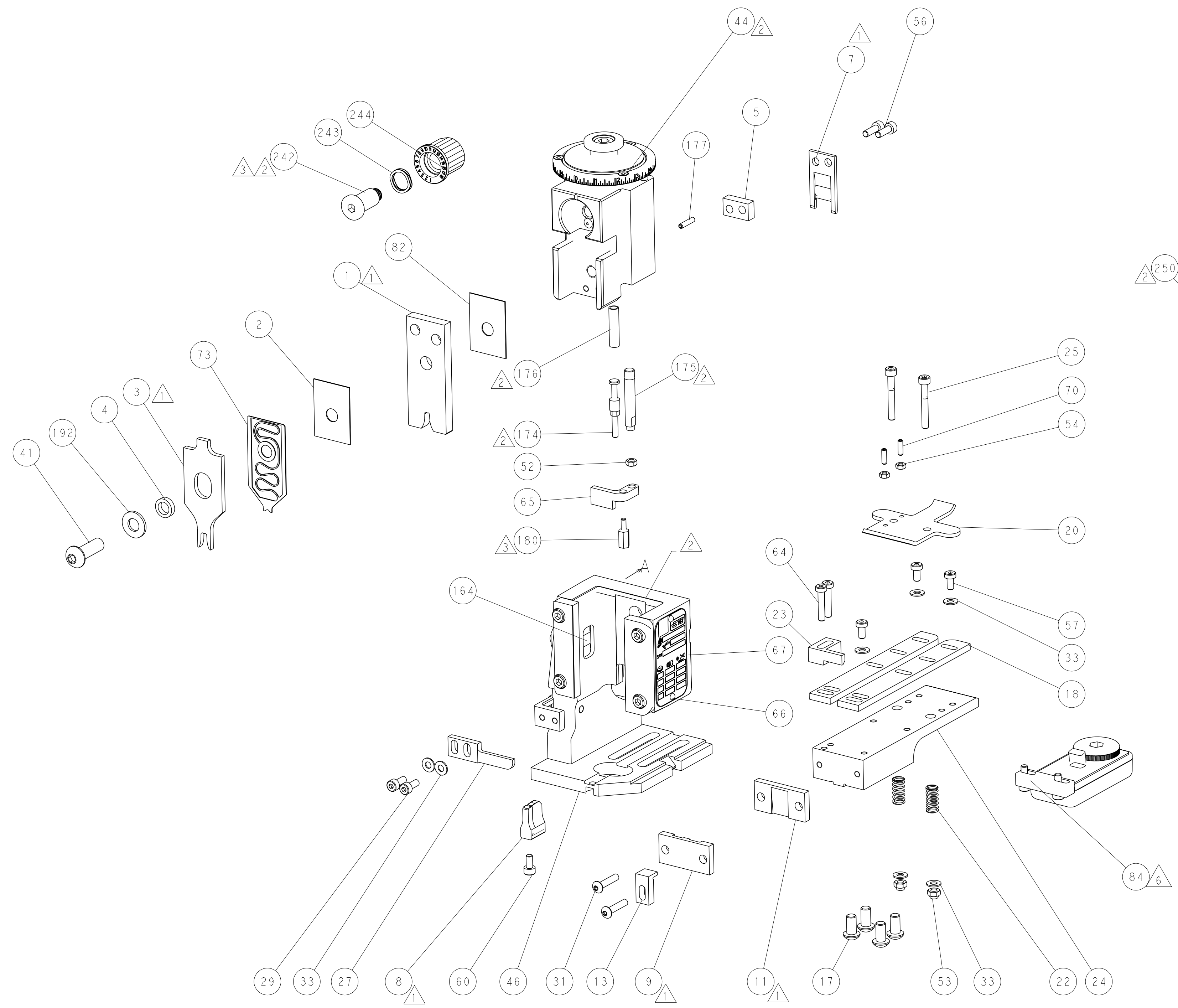
LOC	DIST	REVISIONS					
A	66	P	LYR	DESCRIPTION	DATE	OWN	APVD
		-		SEE SHEET 1	-	-	-



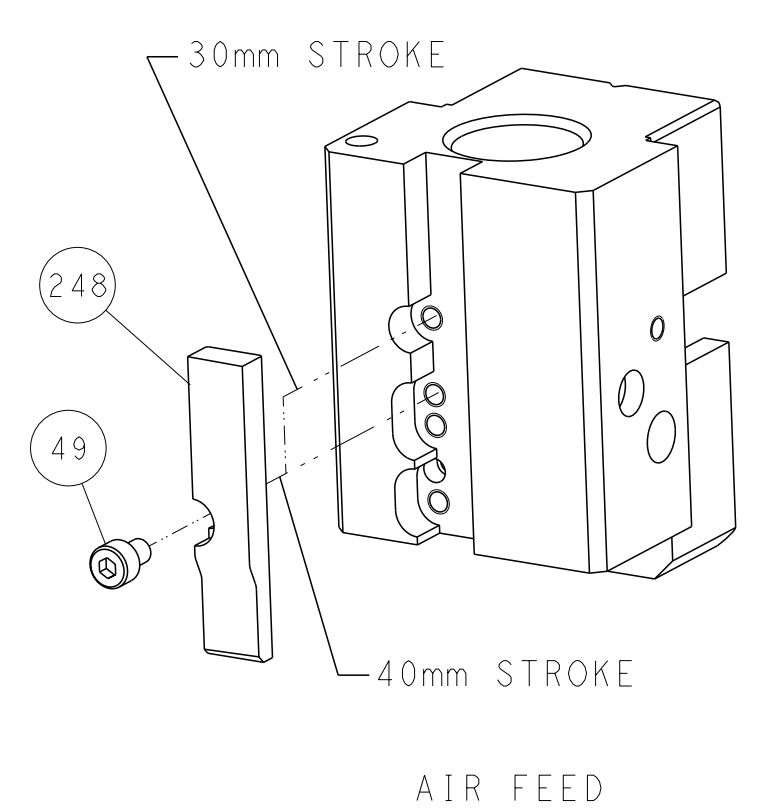
RAM AND HOLDDOWN SET-UP

FEED TYPE

PNEUMATIC



CAM POSITION



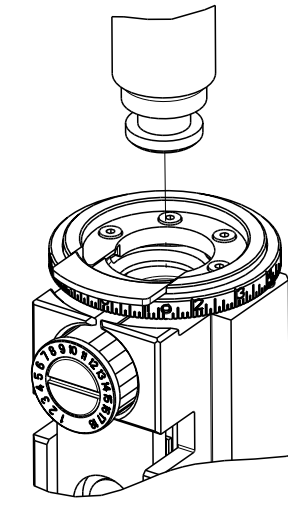
AIR FEED

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 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.</small>		OWN: K. STAKEM CHK: G. BAILEY APVD: T. ELBIN	DATE: 04/2015 DATE: 04/2015 DATE: 04/2015	NAME: Ocean End Feed Applicator	SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2150544	RESTRICTED TO: -
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH ±	TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH ±	WEIGHT: -	SCALE: 1:1	SHEET: 2 of 4	REV: D	CUSTOMER ACCESSIBLE PRODUCTION DRAWING

THIS DRAWING IS UNPUBLISHED.	RELEASED FOR PUBLICATION		
COPYRIGHT 20 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.			
PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150544-2	D	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150544-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	3.56 mm [1.40]	F
INSUL	4.32 mm [1.70]	F
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: RECEPTACLE, CLUSTER PIN, AMPLIVAR			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
3.58-4.34 mm [1.41-.171 IN]		∅2.29-4.32 mm [1.090-.170 IN]	
TERMINAL APPLICATION SPECIFICATION	114-2019	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
63455-1			

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: RECEPTACLE, CLUSTER PIN, AMPLIVAR			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
3.58-4.34 mm [1.41-.171 IN]		∅ 3.81 mm [1.50 IN] MAX	
TERMINAL APPLICATION SPECIFICATION	114-2019	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
1217173-1	1217173-3		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
7600-8500 CMA	2.36 +/- 0.05 [1.093 +/- .002]	5.6
4000-4800 CMA	1.98 +/- 0.05 [1.078 +/- .002]	9.3

- 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 ITEMS 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.
- TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- TERMINAL LUBRICANT IS RECOMMENDED.
- 7. 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.

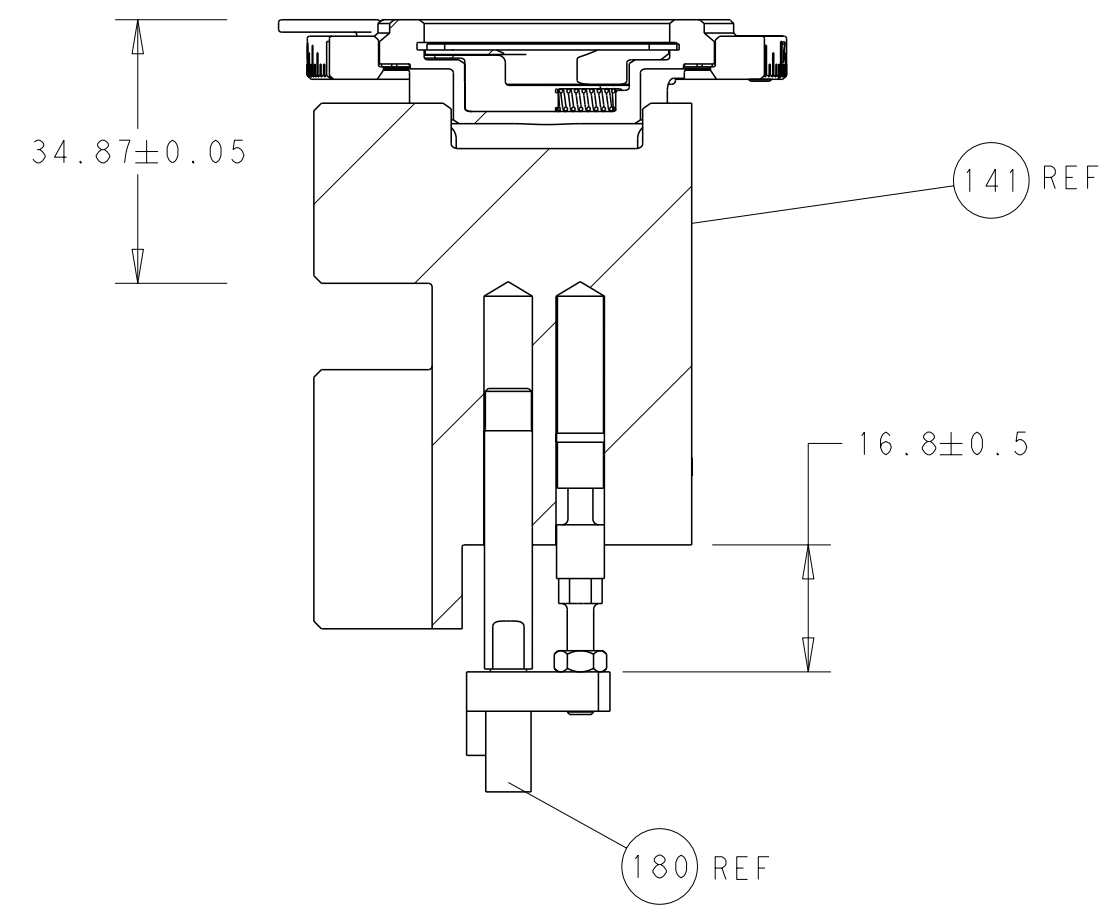
PACIFIC VERSION
Shown on sheets 3 of 4 & 4 of 4
(Atlantic version shown on sheets 1 of 4 & 2 of 4)

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

-	1	2119640-1	PUSH ROD, AIR FEED	250	
-	1	1803259-1	BUSHING, FLANGED	249	
-	1	2119082-4	CAM, SNAIL, INSULATION ADJUSTMENT	244	
-	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243	
	-	2119083-1	RETAINER, INSULATION DIAL	242	
-	-	2119580-1	MECHANICAL FEED ASSEMBLY	239	
-	1	2063440-2	AIR FEED MODULE	238	
-	1	1-18028-0	WASHER, FLAT, REG M8	192	
-	4	2079383-9	SCR, BHSC, RoHS (M6 X 20)	186	
	-	1	2-1752354-7	STANDOFF,HOLD-DOWN	180
-	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	
-	2	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172	
-	REF	994970-2	COUNTER, MAGNETIC	164	
-	1	240638-1	SPRING, FEED FINGER	163	
-	1	2119641-2	FEED CAM, AIR FEED	152	
-	1	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	144	
-	-	2119653-2	FEED CAM, POST FEED	142	
-	1	2119655-6	APPLICATOR BASIC ASSEMBLY, EF	141	
-	1	1803518-1	RAM ASSEMBLY, EF PACIFIC	140	
-	1	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854	137	
	-	1	2119955-2	ASSY, LUBRICATOR, END FEED	84
-	1	455888-5	SPACER, CRIMPER	82	
-	1	2119791-5	DEPRESSOR, WIRE	73	
-	1	1803607-2	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	1901681-1	HOLDDOWN, TERMINAL	65	
-	2	2168400-5	SHCS, LOW HEAD, RoHS, M4 X 20	64	
-	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59	
-	-	2063961-1	FEED FINGER	58	
-	3	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57	
-	2	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	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	2119792-2	PAWL, EF, AIR	51	
-	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49	
-	-	2119652-1	FEED CAM, PRE FEED	48	
-	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41	
-	7	1-18028-2	WASHER, FLAT, REG M4	33	
-	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	31	
-	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	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	
-	1	240825-1	PLATE, STRIP HOLD DOWN	23	
-	2	2-22281-3	SPRING, COMPRESSION	22	
-	1	1803292-4	DRAG	20	
-	2	1901259-7	GUIDE, LOWER STRIP	18	
	-	1	1752360-1	SPACER,HOLD-DOWN	13
	-	1	240644-1	PLATE, REAR SHEAR	11
	-	1	690482-5	PLATE, FRONT SHEAR	9
	1	1	1803064-8	ANVIL, COMBINATION	8
-	1	1	4-690474-2	BLADE, SLUG	7
-	1	1	8-240641-8	SPACER	5
-	1	1	238011-2	BLOCK, CRIMPER SPACER	4
	1	1	7-1633961-5	CRIMPER, INSULATION F PREMIUM	3
-	1	1	455888-5	SPACER, CRIMPER	2
	1	1	462808-7	CRIMPER, BLUNT F	1

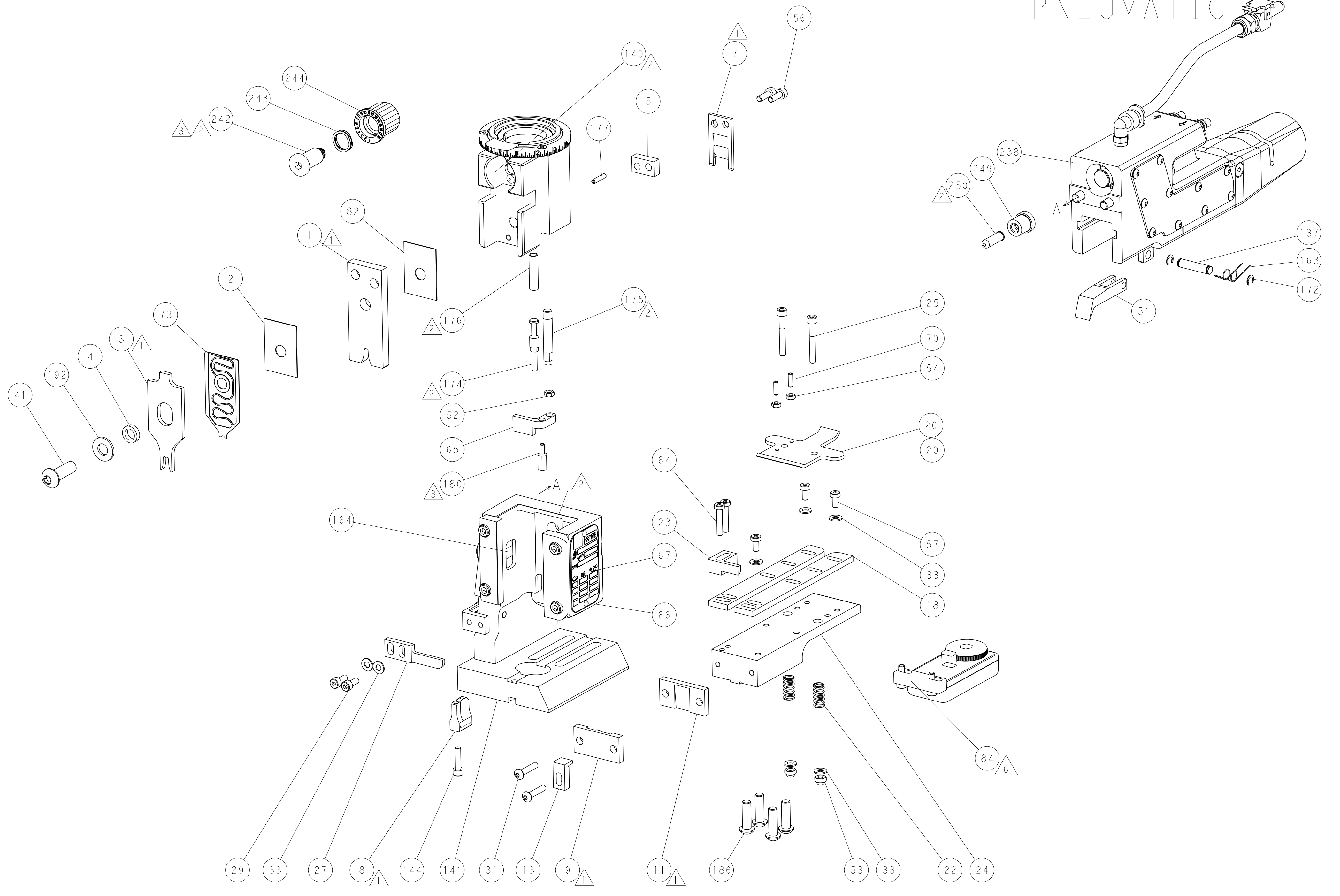
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		OWN: R. STAKEM APRIL 2015		TE Connectivity Harrisburg, PA 17105-3608	
mm		0 PLC ±		CHK: G. BAILEY APRIL 2015		NAME: Ocean End Feed Applicator	
		1 PLC ±		APVD: T. ELBIN APRIL 2015		SIZE: A1	
		2 PLC ±		APPLICATION SPEC		CAGE CODE: 00779	
		3 PLC ±		WEIGHT		DRAWING NO: 2150544	
		4 PLC ±		MATERIAL		SCALE: 1:1	
		ANGLES FINISH		RESTRICTED TO		SHEET 3 OF 4	
				Customer Accessible Production Drawing		REV D	

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

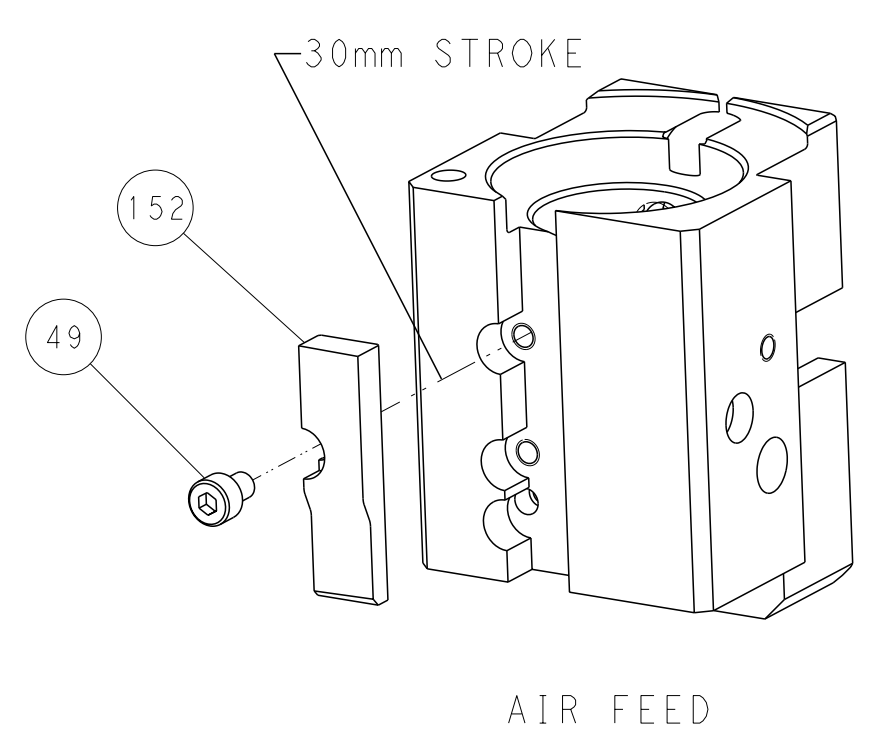


RAM AND HOLDDOWN SET-UP

FEED TYPE
 PNEUMATIC



CAM POSITION



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

<small>THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE AND THE CONTROLLER'S ENGINEERING DEPARTMENT SHOULD BE CONTACTED FOR THE LATEST REVISION.</small>		OWN: K. STAKEM CHK: G. BAILEY APVD: T. ELBIN PRODUCT SPEC:	DATE: 04APRIL2015 DATE: 04APRIL2015 DATE: 10APRIL2015 NAME:	TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm 	TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH *	APPLICATION SPEC: WEIGHT: Customer Accessible Production Drawing	SIZE: A CAGE CODE: 00779 DRAWING NO: C=2150544 SCALE: 1:1 SHEET: 4 of 4 REV: D	RESTRICTED TO: