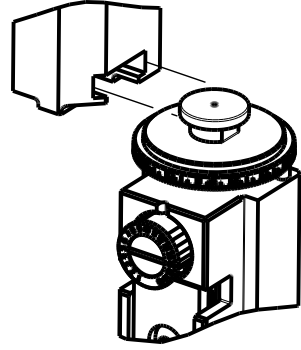


8		7	
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20		20	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150223-2	F	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150223-2	F	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150223-7	F	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	4.57 mm [.180]	F
INSUL	6.35 mm [.250]	F
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: RING TONGUE			
WIRE STRIP LENGTH 5.70-6.50 mm [.224-.256 IN]		INSULATION DIAMETER RANGE Ø4.00-5.30 mm [.157-.209 IN]	
TERMINAL APPLICATION SPECIFICATION	114-18022	-	-
TERMINALS APPLIED 			
TE TERMINAL 928911-1	TE TERMINAL 928911-2	TE TERMINAL	TE TERMINAL

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING 4
6.00mm2		3.48+/-0.05 [.137+/-0.002]		4.7
4.00mm2		3.16+/-0.05 [.124+/-0.002]		8.3



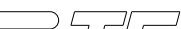
- 1 RECOMMENDED SPARE PARTS
- 2 REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- 3 APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242.
- 4 CRIMP HEIGHT REFERENCE SETTING WAS THE SETTING USED WHEN THE APPLICATOR WAS QUALIFIED AT THE FACTORY. ADJUSTMENT MAY BE NECESSARY WHEN RUNNING APPLICATOR IN THE FIELD.
- 5 TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
6. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.

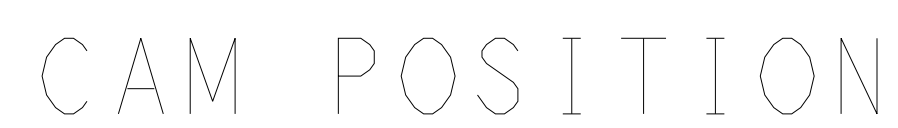
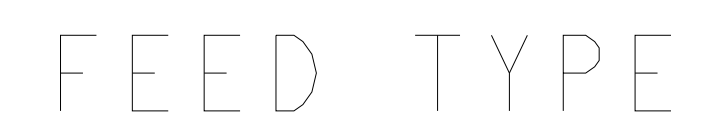
*WARNING
ON INSTALLATION, SET WIRE DISC TO CRIMP HEIGHT REFERENCE SETTING FOR LARGEST WIRE SIZE. CRIMP HEIGHT REFERENCE SETTINGS GREATER THAN THE VALUE SHOWN MAY CAUSE DAMAGE TO THE CRIMP TOOLING. REFER TO THE INSTRUCTION SHEET FOR PROPER SETUP AND ADJUSTMENTS.

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

2		1					
LOC	DIST	REVISIONS					
A	66	P	LTR	DESCRIPTION	DATE	DWN	APVD
		E		ECR-19-008970	12JUN2019	LG	TE
		E1		ECR-19-012199	02AUG2019	FJ	TE
		E2		ECR-19-013984	06SEP2019	FJ	TE
		F		ECR-20-012131	27AUG2020	FZ	RK

3	-	1	1	455888-2	SPACER, CRIMPER	263
	-	1	1	2119641-1	FEED CAM, AIR FEED	248
	-	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	1	2844940-4	AIR FEED MODULE	238
	-	1	1	1-18028-0	WASHER, FLAT, REG M8	192
	-	REF	REF	994970-2	COUNTER, MAGNETIC	164
	-	1	1	455888-4	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	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	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
	-	4	4	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57
	-	2	2	2-2168083-6	SCR, SKT HD CAP, RoHS, M4 X 18	56
	-	2	2	5018030-1	NUT, HEX, REG, RoHS, M3	54
-	2	2	986965-8	NUT, LOCK, HEX, TORQUE (M4)	53	
-	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	
-	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	690455-1	STRIPPER, FRONT CASTING	27	
-	2	2	1-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 30	25	
-	1	1	1752371-1	PLATE, STRIP GUIDE	24	
-	2	2	9-22281-7	SPRING, COMPRESSION	22	
-	1	1	1803292-1	DRAG	20	
-	1	1	6-1901696-7	STRIP GUIDE, REAR	19	
-	1	1	4-1901695-9	STRIP GUIDE, FRONT	18	
-	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17	
-	1	1	8-240641-6	SPACER	16	
-	1	1	3-240641-5	SPACER	15	
1	-	1	1	240644-1	PLATE, REAR SHEAR	11
-	-	-	-	-	-	10
1	-	1	1	690482-3	PLATE, FRONT SHEAR	9
1	1	2	1	3-1333223-2	ANVIL, COMBINATION	8
1	-	1	1	690474-9	BLADE, SLUG	7
-	1	1	1	1-240641-2	SPACER	5
-	1	1	1	1-238011-2	BLOCK, CRIMPER SPACER	4
1	1	2	1	3-2119582-1	CRIMPER, INSULATION F PREMIUM	3
-	1	1	1	1-455888-1	SPACER, CRIMPER	2
1	1	2	1	3-456412-1	CRIMPER, WIRE .180 F PREMIUM	1
-	77-72	-2		PART NO	DESCRIPTION	ITEM NO

THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE AND THE USER SHALL BE RESPONSIBLE FOR VERIFYING THE LATEST REVISION.		DWN	HOFFNER	01DEC2011	 TE Connectivity Harrisburg, PA 17105-3608			
		CHK	T.ELBIN	02DEC2011				
		APVD	T.ELBIN	02DEC2011				
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:			NAME			
mm					Ocean End Feed Applicator			
		0 PLC ±			PRODUCT SPEC			
		1 PLC ±			APPLICATION SPEC			
		2 PLC ±			SIZE			
		3 PLC ±			CAGE CODE			
		4 PLC ±			DRAWING NO			
MATERIAL		FINISH			RESTRICTED TO			
-		-			A1 00779 ©=2150223			
					Customer Accessible Production Drawing			
					SCALE 1:1			
					SHEET 1 of 4			
					REV F			



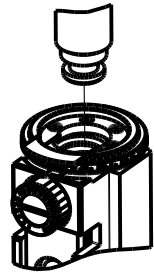
AIR FEED

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

THIS DRAWING IS A PATENTED DOCUMENT FOR THE TE CONNECTIVITY CORPORATION IT IS SUBJECT TO CLAIMS AND THE CONTROLLING U.S. PATENTING ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST REVISION		DWG HOFNER 01DEC2011		 TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS:		CHK TELBIN 02DEC2011			
TOLERANCES UNLESS OTHERWISE SPECIFIED:		APVD TELBIN 02DEC2011		NAME	
mm		PRODUCT SPEC		Ocean End Feed Applicator	
		APPLICATION SPEC		SIZE	
0 PLC ±.0 1 PLC ±.0 2 PLC ±.0 3 PLC ±.0 4 PLC ±.0 ANGLES ±.0		WEIGHT		CAGE CODE	
MATERIAL		FINISH		DRAWING NO	
-		-		A 00779 C=2150223	
				RESTRICTED TO	
				SCALE 1:1 SHEET 2 OF 4 REV F	
Customer Accessible Production Drawing					

8				7							
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PART NUMBER		REVISION		DESCRIPTION				FEED TYPE			
2-2150223-2		F		FINE CRIMP HEIGHT ADJUST				PNEUMATIC			
7-2150223-7		F		CRIMP TOOLING KIT				-			

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	4.57 mm [.180]	F
INSUL	6.35 mm [.250]	F
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: RING TONGUE			
WIRE STRIP LENGTH 5.70-6.50 mm [.224-.256 IN]			INSULATION DIAMETER RANGE Ø4.00-5.30 mm [.157-.209 IN]
TERMINAL APPLICATION SPECIFICATION		114-18022	-
		-	-
TERMINALS APPLIED 			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
928911-1	928911-2		

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING	
6.00mm2		3.48+/-0.05 [.137+/- .002]		4.7	
4.00mm2		3.16+/-0.05 [.124+/- .002]		8.3	



- 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.
- TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- 6. 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.

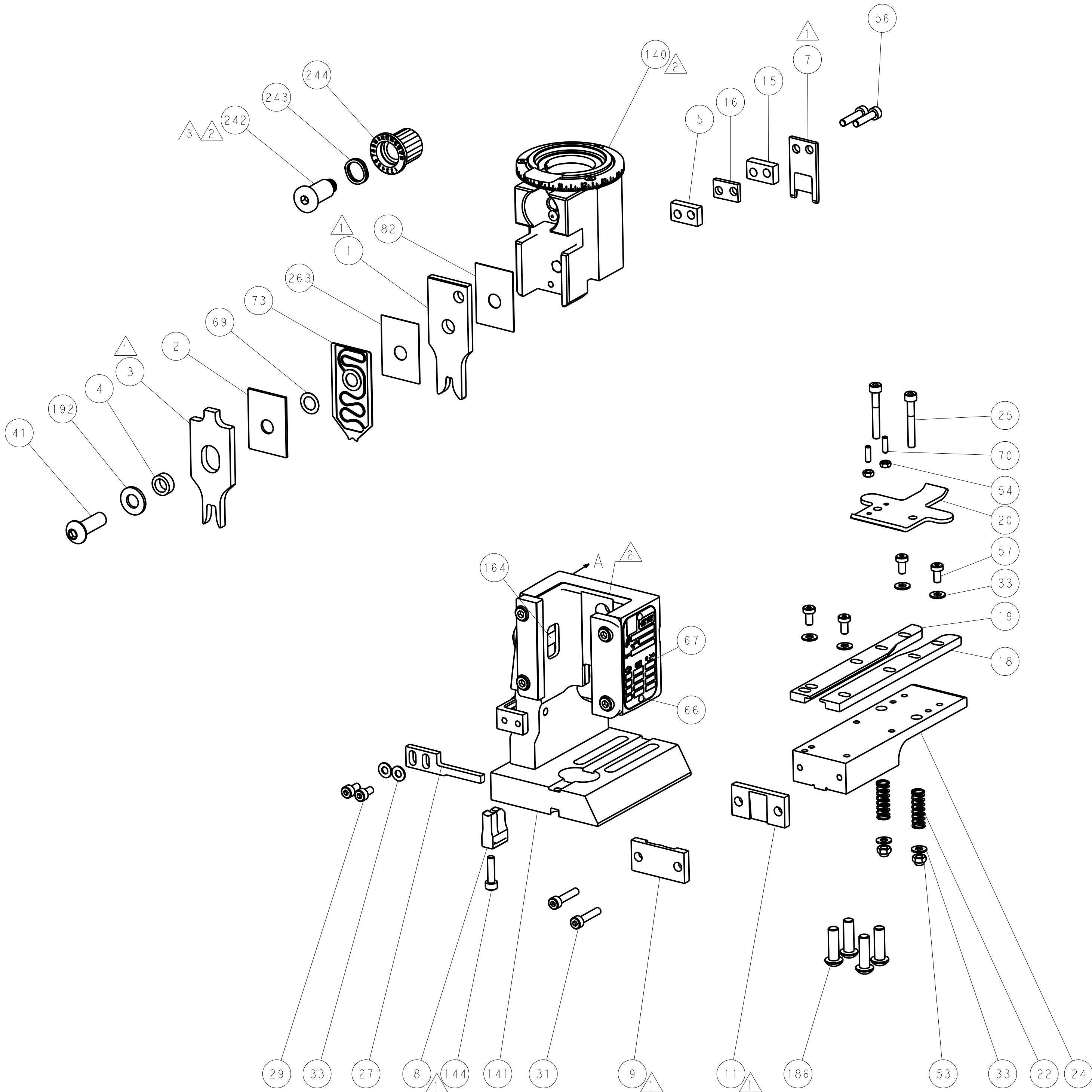
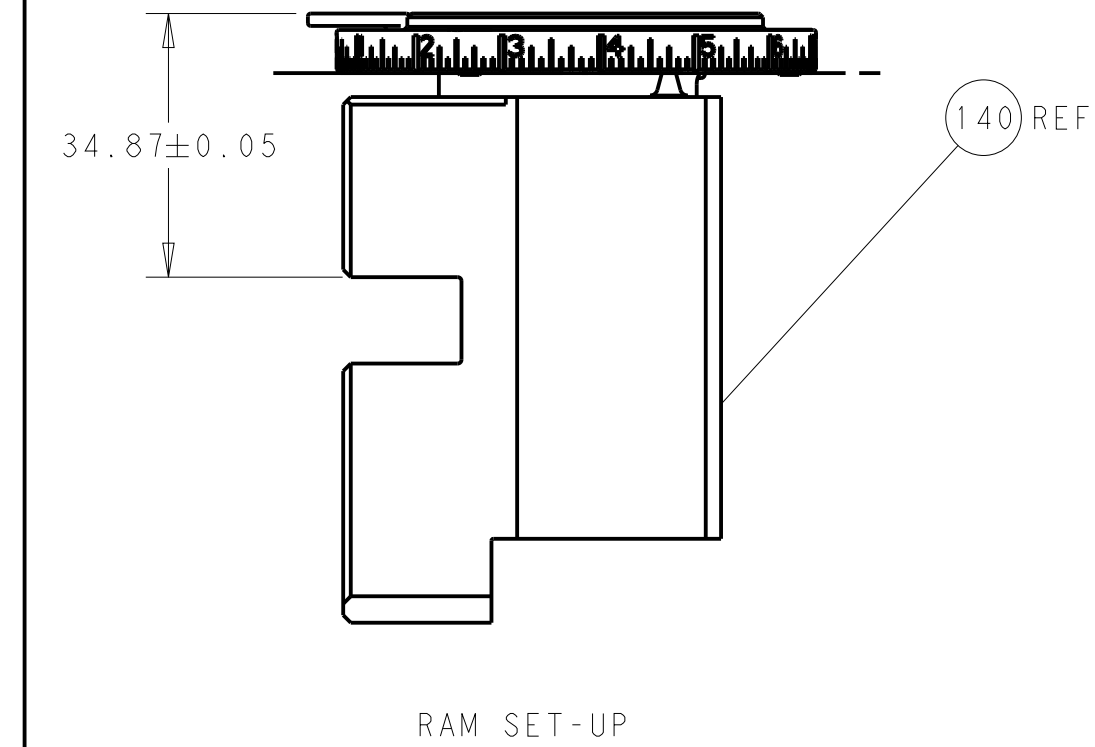
LOC	DIST	REVISIONS					
		P	LTR	DESCRIPTION	DATE	DWN	APVD
A	66	-	-	SEE SHEET 1	-	-	-

-	1	455888-2	SPACER, CRIMPER	263
-	1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	2844940-4	AIR FEED MODULE	238
-	1	1-18028-0	WASHER, FLAT, REG M8	192
-	4	2079383-9	SCR, BHSC, RoHS (M6 X 20)	186
-	REF	994970-2	COUNTER, MAGNETIC	164
-	1	2119641-2	FEED CAM, AIR FEED	152
-	1	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	144
-	1	2119655-6	APPLICATOR BASIC ASSEMBLY, EF	141
-	1	1803518-1	RAM ASSEMBLY, EF PACIFIC	140
-	1	455888-4	SPACER, CRIMPER	82
-	1	2119791-9	DEPRESSOR, WIRE	73
-	1	1803607-4	DOCUMENTATION PACKAGE	71
-	2	2-18032-2	SCR, SET, FLT PNT, M3 X 10.0	70
-	1	2119943-1	WASHER, SPACER	69
-	1	2119740-1	TAG, IDENTIFICATION	67
-	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	4	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57
-	2	2-2168083-6	SCR, SKT HD CAP, RoHS, M4 X 18	56
-	2	5018030-1	NUT, HEX, REG, RoHS, M3	54
-	2	986965-8	NUT, LOCK, HEX, TORQUE (M4)	53
-	1	2063961-1	FEED FINGER	51
-	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
-	8	1-18028-2	WASHER, FLAT, REG M4	33
-	2	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	31
-	2	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	29
-	1	690455-1	STRIPPER, FRONT CASTING	27
-	2	1-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 30	25
-	1	1752371-1	PLATE, STRIP GUIDE	24
-	2	9-22281-7	SPRING, COMPRESSION	22
-	1	1803292-1	DRAG	20
-	1	6-1901696-7	STRIP GUIDE, REAR	19
-	1	4-1901695-9	STRIP GUIDE, FRONT	18
-	1	8-240641-6	SPACER	16
-	1	3-240641-5	SPACER	15
	1	240644-1	PLATE, REAR SHEAR	11
-	-	-	-	10
	1	690482-3	PLATE, FRONT SHEAR	9
	1	3-1333223-2	ANVIL, COMBINATION	8
	1	690474-9	BLADE, SLUG	7
-	1	1-240641-2	SPACER	5
-	1	1-238011-2	BLOCK, CRIMPER SPACER	4
	1	3-2119582-1	CRIMPER, INSULATION F PREMIUM	3
-	1	1-455888-1	SPACER, CRIMPER	2
	1	3-456412-1	CRIMPER, WIRE .180 F PREMIUM	1
-	77-22	PART NO	DESCRIPTION	ITEM NO

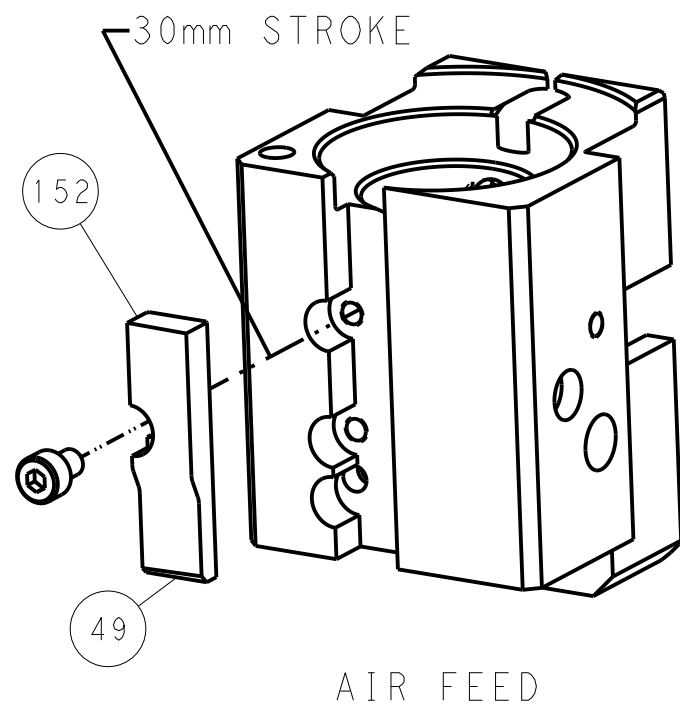
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				CHK	T.ELBIN	02DEC2011				
				APVD	T.ELBIN	02DEC2011	NAME			
DIMENSIONS:				TOLERANCES UNLESS OTHERWISE SPECIFIED:				PRODUCT SPEC		
mm				0 PLC ±				APPLICATION SPEC		
				1 PLC ±				SIZE		
				2 PLC ±				CAGE CODE		
				3 PLC ±				DRAWING NO		
				4 PLC ±				RESTRICTED TO		
MATERIAL				FINISH				00779 ©=2150223		
								Customer Accessible Production Drawing		
								SCALE 1:1		
								SHEET 3 OF 4		
								REV F		

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

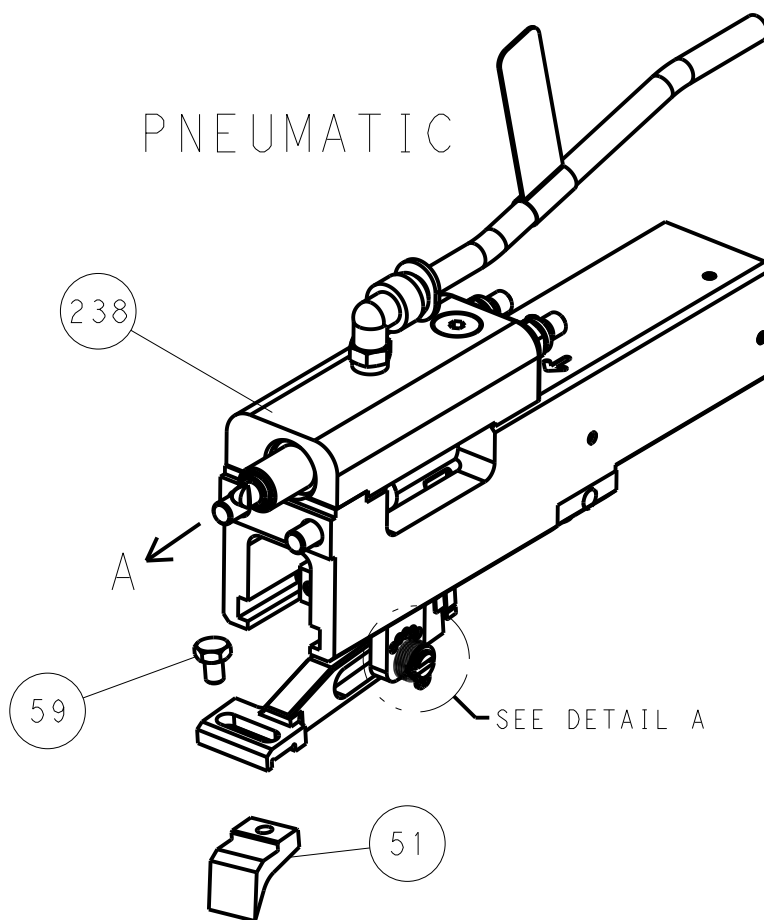
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A	66	P	LTR	DESCRIPTION	DATE	DWN	APVD
		-	-	SEE SHEET 1	-	-	-



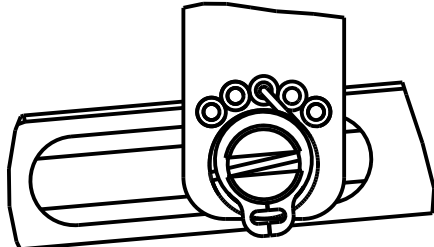
CAM POSITION



FEED TYPE



FEED SPRING
SETTING POSITION



DETAIL A

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

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				CHK: T. ELBIN 02DEC2011		Harrisburg, PA 17105-3608	
				APVD: T. ELBIN 02DEC2011		NAME: Ocean End Feed Applicator	
				PRODUCT SPEC		SIZE: CAGE CODE: DRAWING NO: 00779 ©=2150223	
				APPLICATION SPEC		RESTRICTED TO	
				WEIGHT		SCALE: 1:1 SHEET 4 OF 4 REV F	
				Customer Accessible Production Drawing			

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