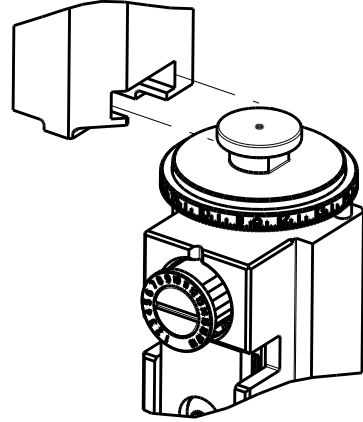


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20		20	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150282-2	D	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150282-2	D	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150282-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.79 mm [.110]	F
INSUL	3.56 mm [.140]	Ø

APPLICATOR INSTRUCTIONS
408-35043

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: TERMINAL, RING			
WIRE STRIP LENGTH .204-.234 IN [5.18-5.94 mm]		INSULATION DIAMETER RANGE Ø.070-.100 IN [1.78-2.54 mm]	
TERMINAL APPLICATION SPECIFICATION		114-2084	
TERMINALS APPLIED		5	
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
41711	41013	140517	

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
18 AWG OR 0.75mm2	1.96+/-0.05 [.077+/- .002]	8.7
20 AWG OR 0.50mm2	1.88+/-0.05 [.074+/- .002]	9.5
22 AWG OR 0.35mm2	1.83+/-0.05 [.072+/- .002]	10.0



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 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. 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.

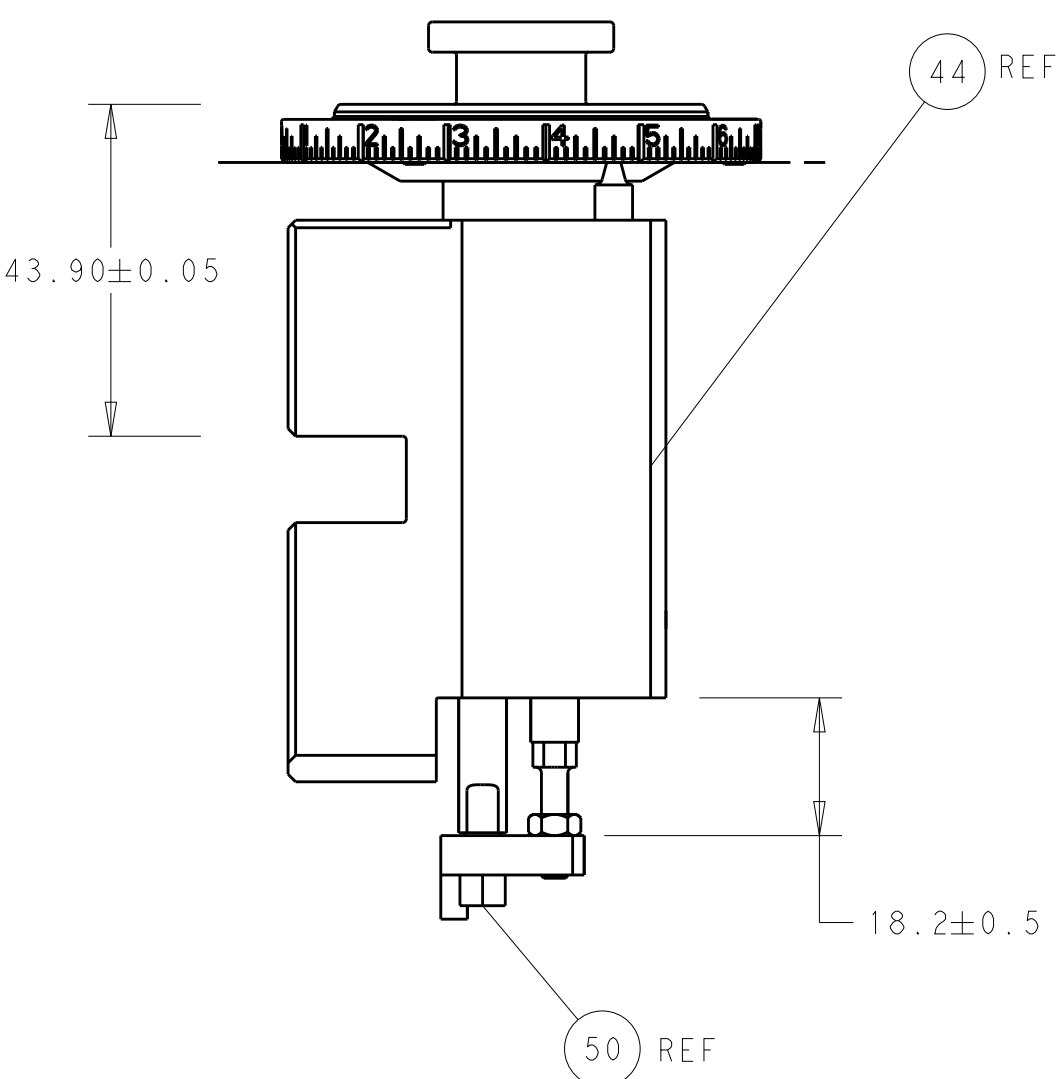
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

LOC		DIST		REVISONS			
A		66		P	LTR	DESCRIPTION	DATE
							DWN
							APVD
				A		RELEASED	04OCT2012
				B		REVISED ECR-13-013665	29AUG2013
				C		ECR-18-019965	21DEC2018
				D		ECR-20-017710	15DEC2020

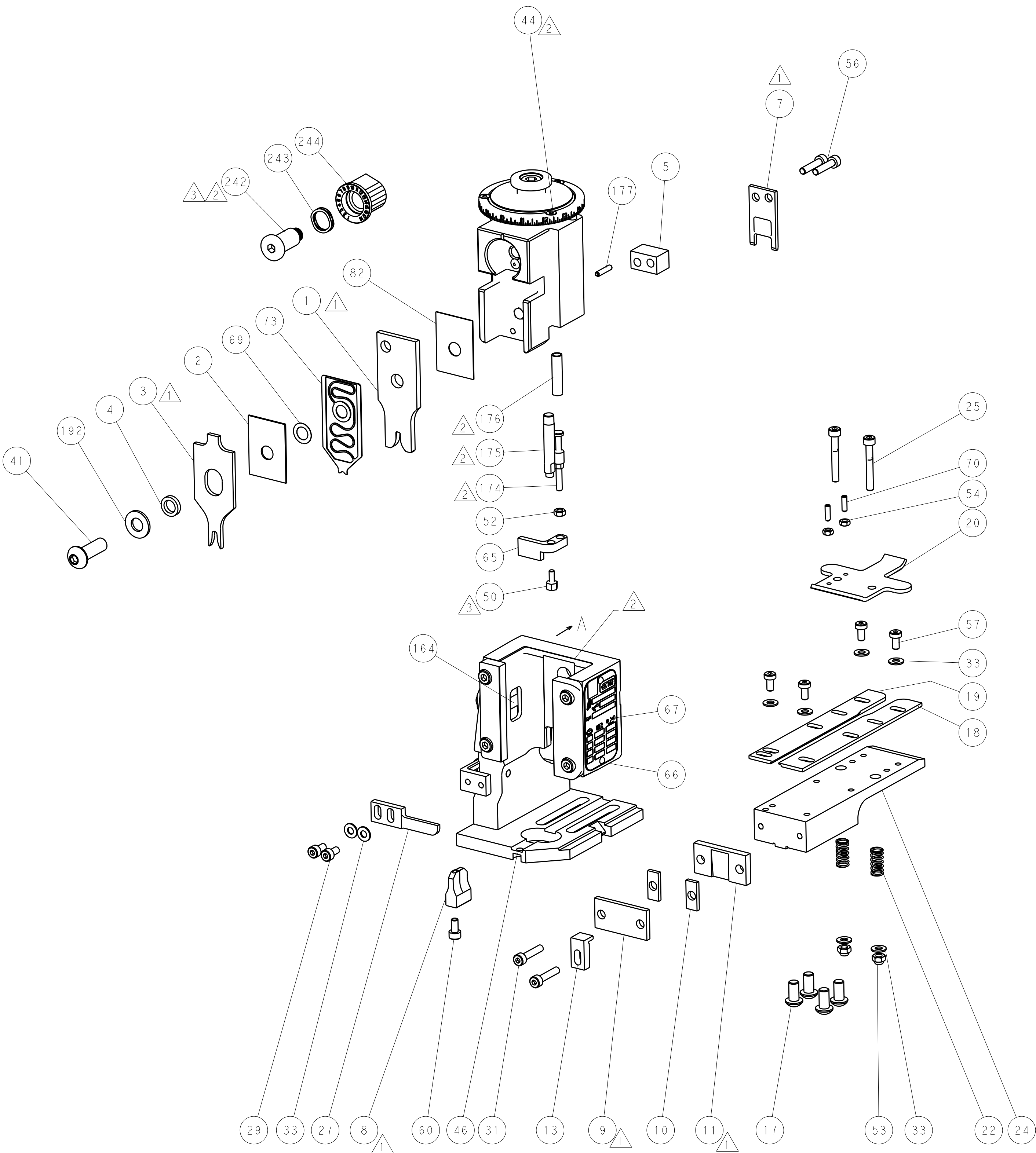
-	1	1	2119641-1	FEED CAM, AIR FEED	248
-	1	1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	1	2844940-4	AIR FEED MODULE	238
-	1	1	1-18028-0	WASHER, FLAT, REG M8	192
-	1	1	6-993111-6	PIN, SLOTTED 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	455888-4	SPACER, CRIMPER	82
-	1	1	2119791-5	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	1901681-1	HOLDDOWN, TERMINAL	65
-	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	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52
-	1	1	2063961-9	FEED FINGER	51
-	1	1	1752354-1	STANDOFF,HOLD-DOWN	50
-	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	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	1901696-3	STRIP GUIDE, REAR	19
-	1	1	1901695-3	STRIP GUIDE, FRONT	18
-	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17
-	1	1	1752360-1	SPACER,HOLD-DOWN	13
-	1	1	240644-1	PLATE, REAR SHEAR	11
-	2	2	1-240645-0	SPACER, SHEAR PLATE	10
-	1	1	240642-1	PLATE, FRONT SHEAR	9
-	1	2	1-1333219-1	ANVIL, COMBINATION	8
-	1	1	1-240651-6	BLADE, SLUG	7
-	1	1	2-240641-6	SPACER	5
-	1	1	238011-4	BLOCK, CRIMPER SPACER	4
-	1	2	1803018-8	CRIMPER, INSULATION O	3
-	1	1	455888-7	SPACER, CRIMPER	2
-	1	2	1-456408-8	CRIMPER, WIRE PREMIUM	1
-	77	72	-2	PART NO	ITEM NO

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DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH ±		NAME Ocean End Feed Applicator	
MATERIAL -		WEIGHT -		SIZE A	
		Customer Accessible Production Drawing		SCALE 1:1	
		SHEET 1		REV D	

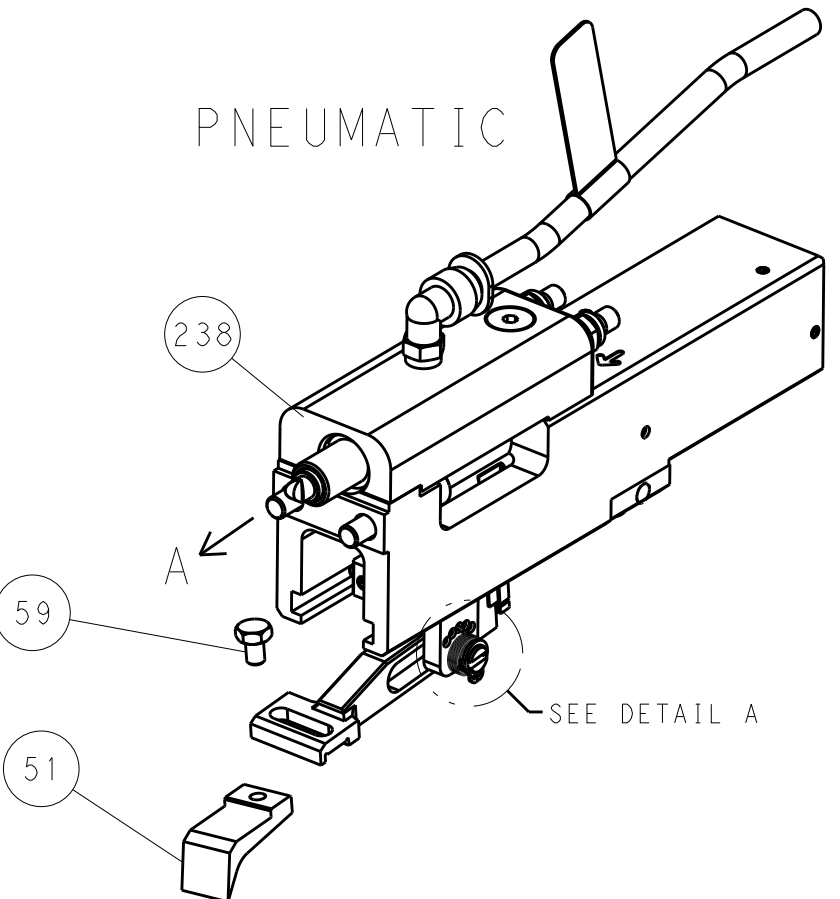
LOC	DIST	REVISIONS					
		P	LTR	DESCRIPTION	DATE	DWN	APVD
A	66	-	-	SEE SHEET 1	-	-	-



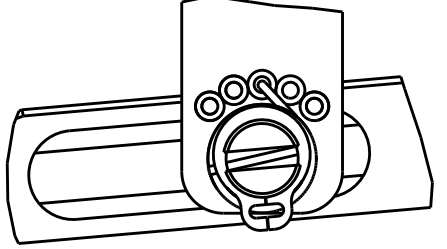
RAM AND HOLDDOWN SET-UP



FEED TYPE

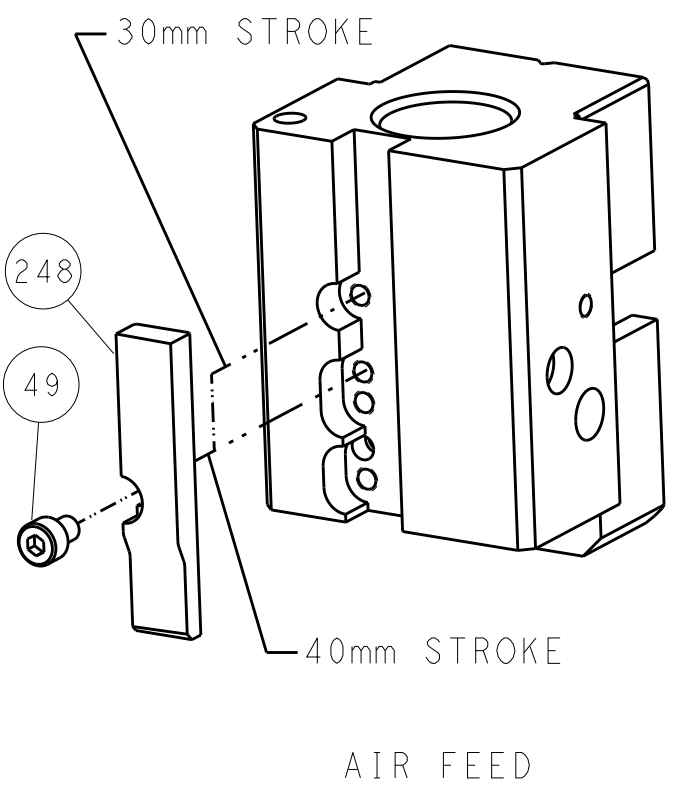


FEED SPRING SETTING POSITION



DETAIL A

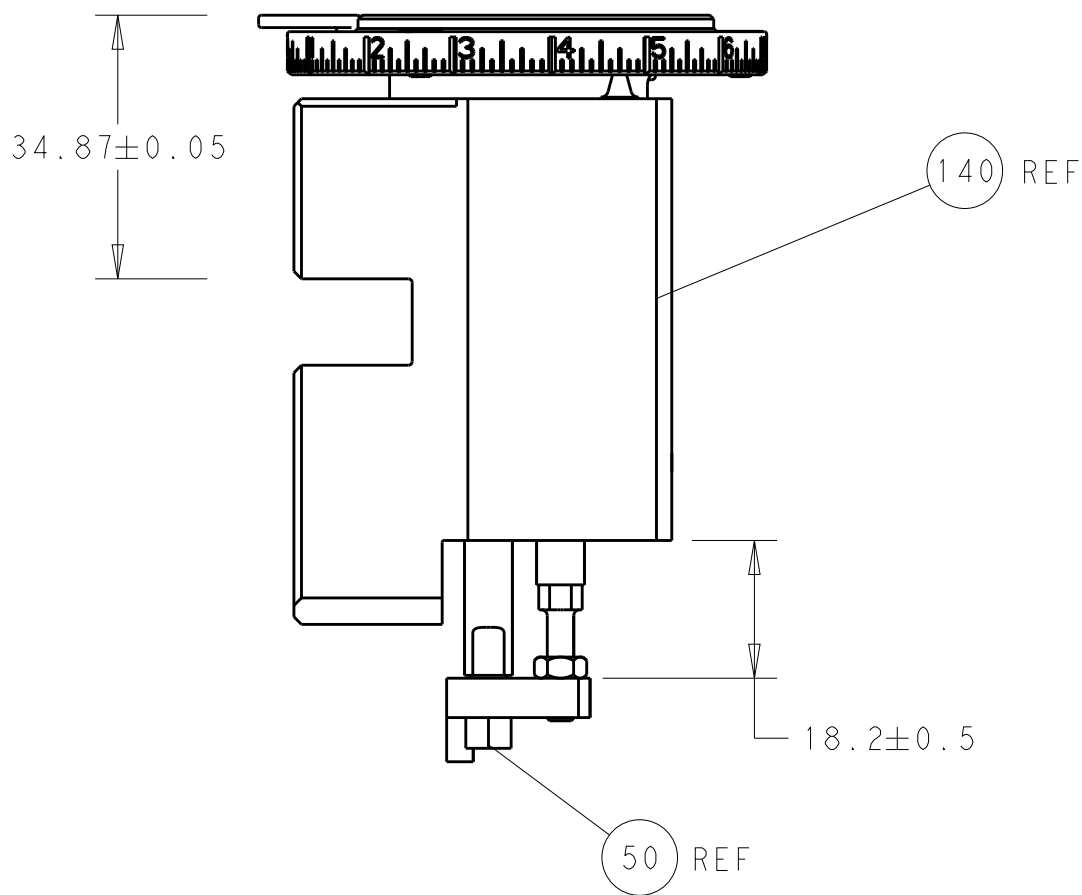
CAM POSITION



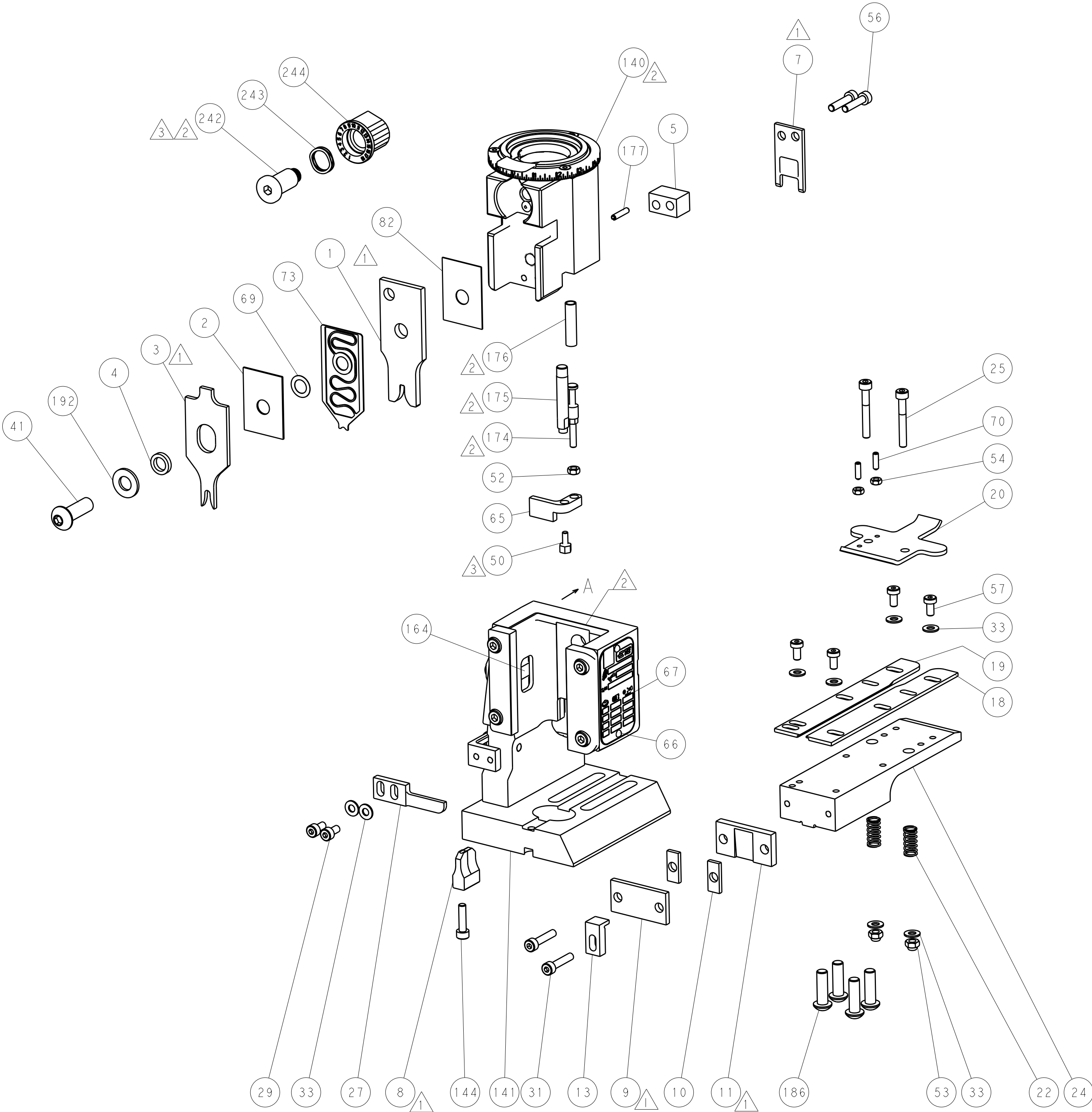
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN R. STANEM 21AUG2012		TE Connectivity	
mm		0 PLC ±.1		CHK G. BAILEY 21AUG2012		Harrisburg, PA 17105-3608	
		1 PLC ±.1		APVD T. ELBIN 21AUG2012		NAME	
MATERIAL		2 PLC ±.1		PRODUCT SPEC		Ocean End Feed Applicator	
		3 PLC ±.1		APPLICATION SPEC		SIZE	
		4 PLC ±.1		WEIGHT		CAGE CODE	
		ANGLES FINISH		Customer Accessible Production Drawing		DRAWING NO	
				SCALE 1:1		00779 ©=2150282	
				SHEET 2 OF 4		REV D	

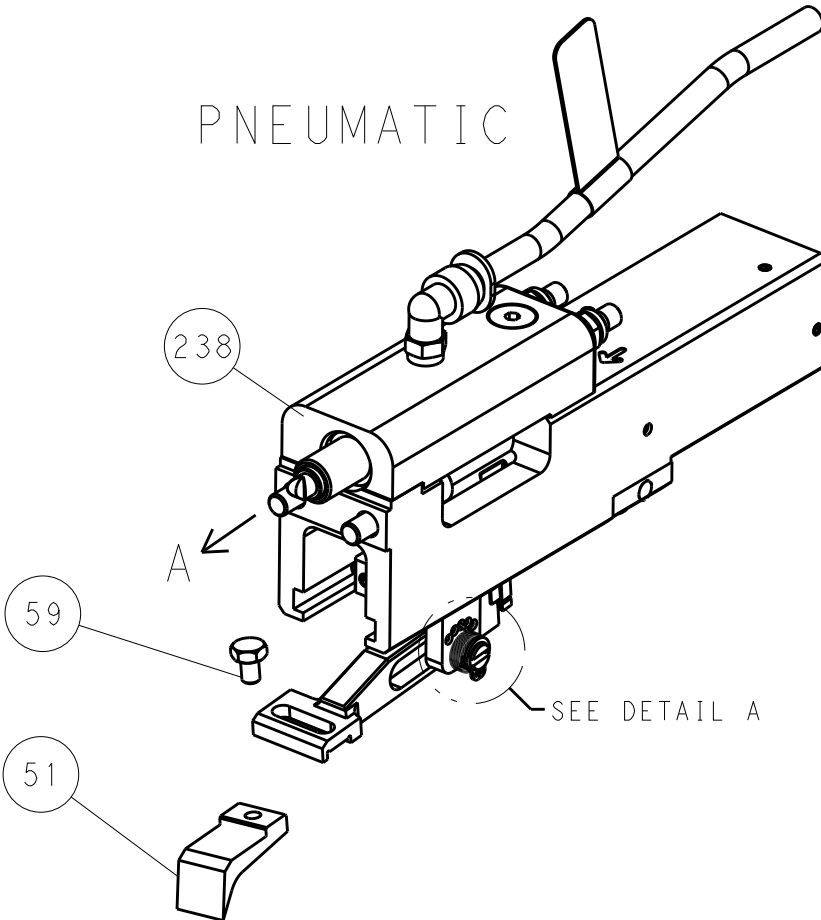
LOC		DIST		REVISIONS			
A	66	P	LTR	DESCRIPTION	DATE	DWN	APVD
		-	-	SEE SHEET 1	-	-	-



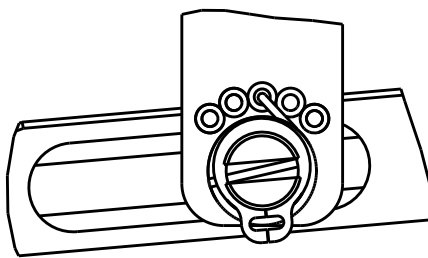
RAM AND HOLDDOWN SET-UP



FEED TYPE

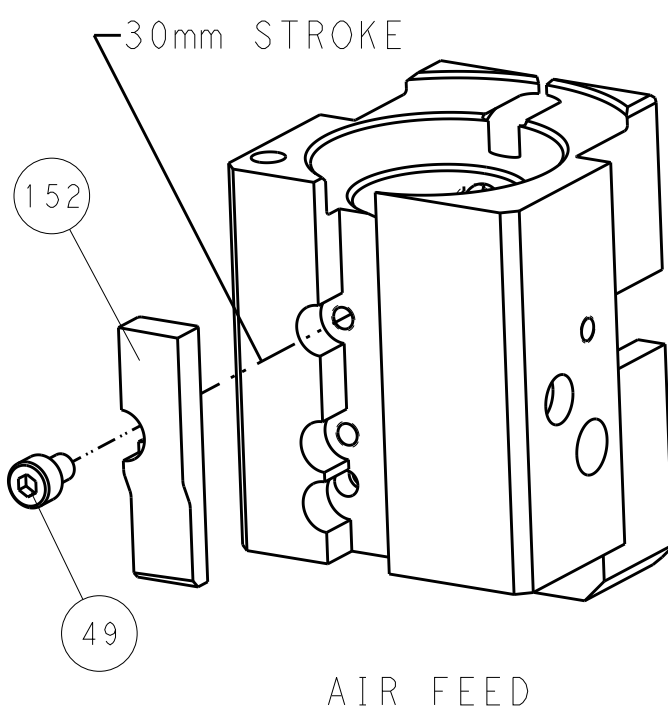


FEED SPRING SETTING POSITION



DETAIL A

CAM POSITION



AIR FEED

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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DIMENSIONS: mm		CHK G. BAILEY 21AUG2012		
TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.1 1 PLC ±.1 2 PLC ±.1 3 PLC ±.1 4 PLC ±.1 ANGLES ±.1 FINISH -		APVD T. ELBIN 21AUG2012	NAME Ocean End Feed Applicator	
MATERIAL -		PRODUCT SPEC -	SIZE A1	
		APPLICATION SPEC -	CAGE CODE 00779	
		WEIGHT -	DRAWING NO C=2150282	
		Customer Accessible Production Drawing	RESTRICTED TO -	
		SCALE 1:1	SHEET 4 OF 4	
			REV D	

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