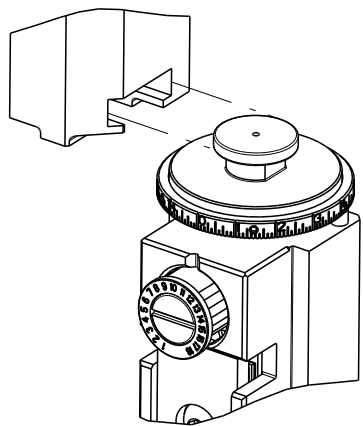


8		7	
THIS DRAWING IS UNPUBLISHED.		RELEASED FOR PUBLICATION 20	
(C) COPYRIGHT 20 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.			
PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150644-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2150644-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150644-1	B	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2150644-2	B	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150644-7	A	CRIMP TOOLING KIT	-



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

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: TERMINAL, RING			
WIRE STRIP LENGTH 5.34-6.10 mm [.210-.240 IN]		INSULATION DIAMETER RANGE Ø	
TERMINAL APPLICATION SPECIFICATION	114-2084	-	-
TERMINALS APPLIED 			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
40977	40517	40521	40796
60505-1			

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING 
14 AWG		2.51+/-0.05 [1.099+/- .002]		5.0
16 AWG		2.36+/-0.05 [1.093+/- .002]		6.5
18 AWG		2.21+/-0.05 [1.087+/- .002]		8.3



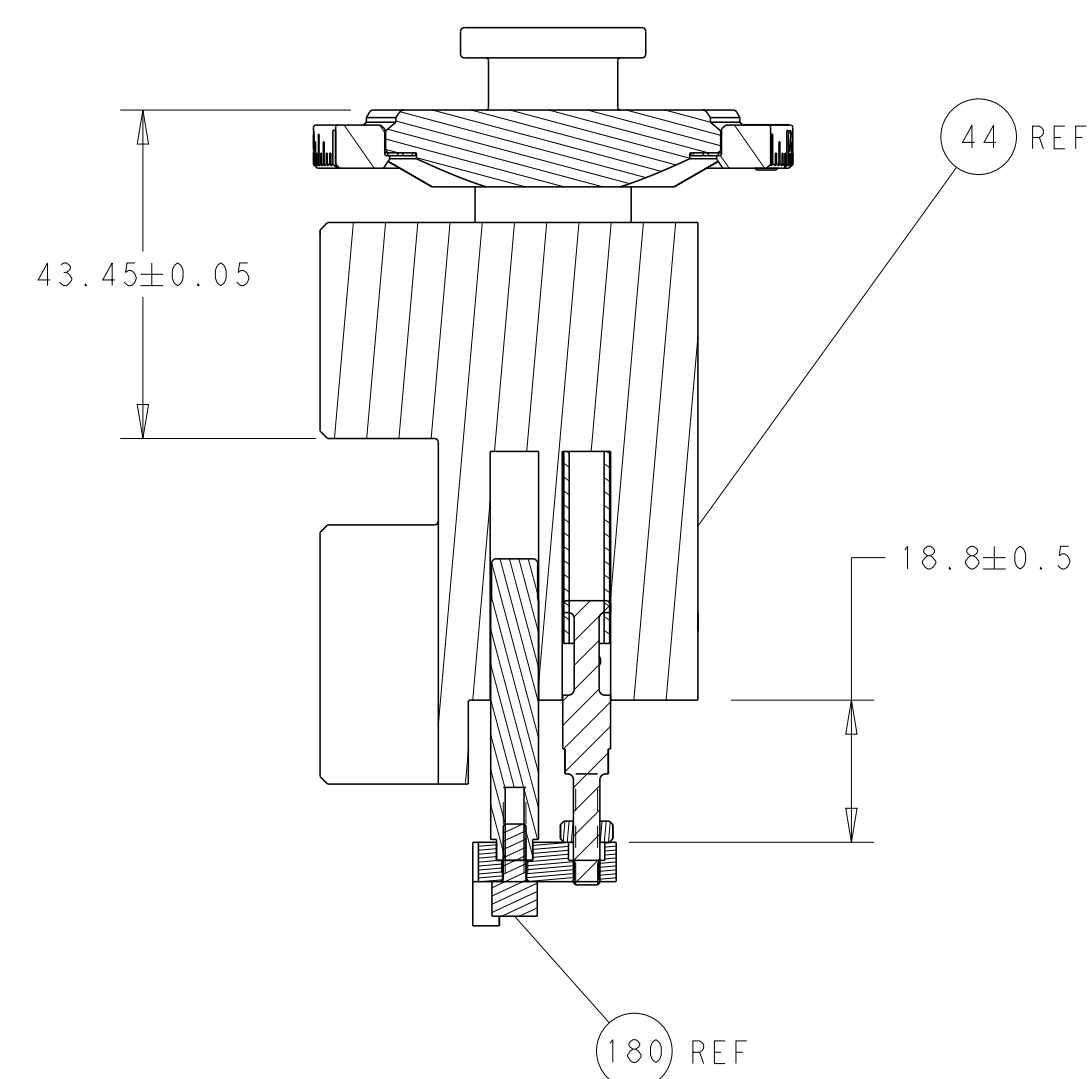
- △ RECOMMENDED SPARE PARTS
 - △ REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
 - △ APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 180.
 - △ CRIMP HEIGHT REFERENCE SETTING WAS THE SETTING USED WHEN THE APPLICATOR WAS QUALIFIED AT THE FACTORY. ADJUSTMENT MAY BE NECESSARY WHEN RUNNING APPLICATOR IN THE FIELD.
 - △ TERMINAL LUBRICANT IS RECOMMENDED.
6. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.

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	OWN	APPROV
			A	RELEASED	10MAR2016	KH	TE
			B	ECR-19-003693	07MAR2019	TB	CT

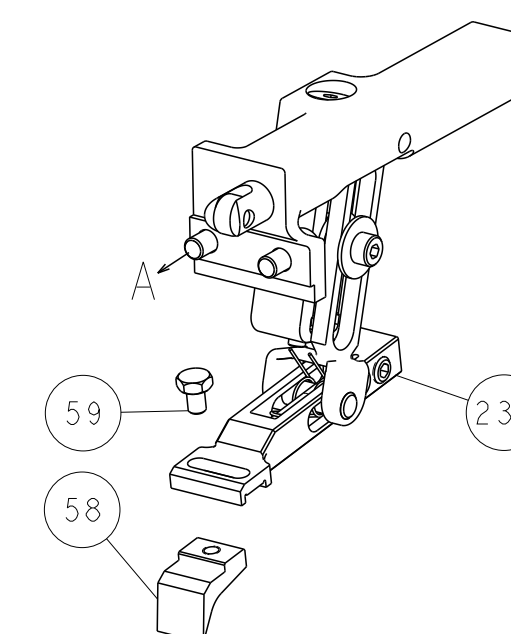
3	-	1	-	1	-	2119640-1	PUSH ROD, AIR FEED	250
	-	1	-	1	-	1803259-1	BUSHING, FLANGED	249
	-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248
	-	-	1	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
	-	1	-	1	-	2063440-1	AIR FEED MODULE	238
	-	1	1	1	1	1752354-3	STANDOFF,HOLD-DOWN	180
	-	1	1	1	1	6-993111-6	PIN, SLOTTED 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
5	-	2	-	2	-	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	17
	-	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
	-	1	-	1	-	240638-1	SPRING, FEED FINGER	163
	-	1	-	1	-	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854	137
	-	1	1	1	1	2119955-2	ASSY, LUBRICATOR, END FEED	84
	-	1	1	1	1	455888-6	SPACER, CRIMPER	82
	-	1	1	1	1	1803607-2	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	1	1901681-1	HOLDDOWN, TERMINAL	65
	-	1	1	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
	-	-	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	-	2119792-2	PAWL, EF, AIR	51
1	-	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	1803602-3	SCR, BHSC, RoHS (M8 X 12)	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
1	-	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	1803292-4	DRAG	20
	-	1	1	1	1	1901696-3	STRIP GUIDE, REAR	19
	-	1	1	1	1	1901695-3	STRIP GUIDE, FRONT	18
	-	4	4	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17
	-	1	1	1	1	1752360-1	SPACER,HOLD-DOWN	13
	-	1	1	1	1	240644-1	PLATE, REAR SHEAR	11
	-	2	2	2	2	240645-8	SPACER, SHEAR PLATE	10
1	-	1	1	1	1	240642-1	PLATE, FRONT SHEAR	9
	1	2	2	1	1	1-1333224-4	ANVIL, COMBINATION (E.F. WIRE/B ONLY)	8
	-	1	1	1	1	1803366-1	BLADE, SLUG -	7
	-	-	-	-	-	-	-	6
	-	1	1	1	1	2-240641-5	SPACER	5
	-	-	-	-	-	-	-	4
	-	-	-	-	-	-	-	3
	-	-	-	-	-	-	-	2
	1	2	2	1	1	456411-9	CRIMPER, WIRE PREMIUM	1
	-77-72-71	-2	-1	PART NO	DESCRIPTION	ITEM NO		

TE CONNECTIVITY IS A REGISTERED TRADEMARK OF TE CONNECTIVITY CORPORATION TE CONNECTIVITY IS A REGISTERED TRADEMARK OF TE CONNECTIVITY CORPORATION ALL RIGHTS RESERVED.										DWN	25JAN2016			TE Connectivity	
										CHE	25JAN2016			Harrisburg PA 17105-3608	
DIMENSIONS:										APR	25JAN2016	NAME	Ocean End Feed Applicator		
TOLERANCES UNLESS OTHERWISE SPECIFIED:										PRODUCT SPEC					
mm										APPLICATION SPEC					
										SIZE CAGE CODE DRAWING NO RESTRICTED TO					
MATERIAL										WEIGHT					
-										A 00779 © 2150644					
Customer Accessible Production Drawing										SCALE 1:1 SHEET 1 OF 4 REV B					

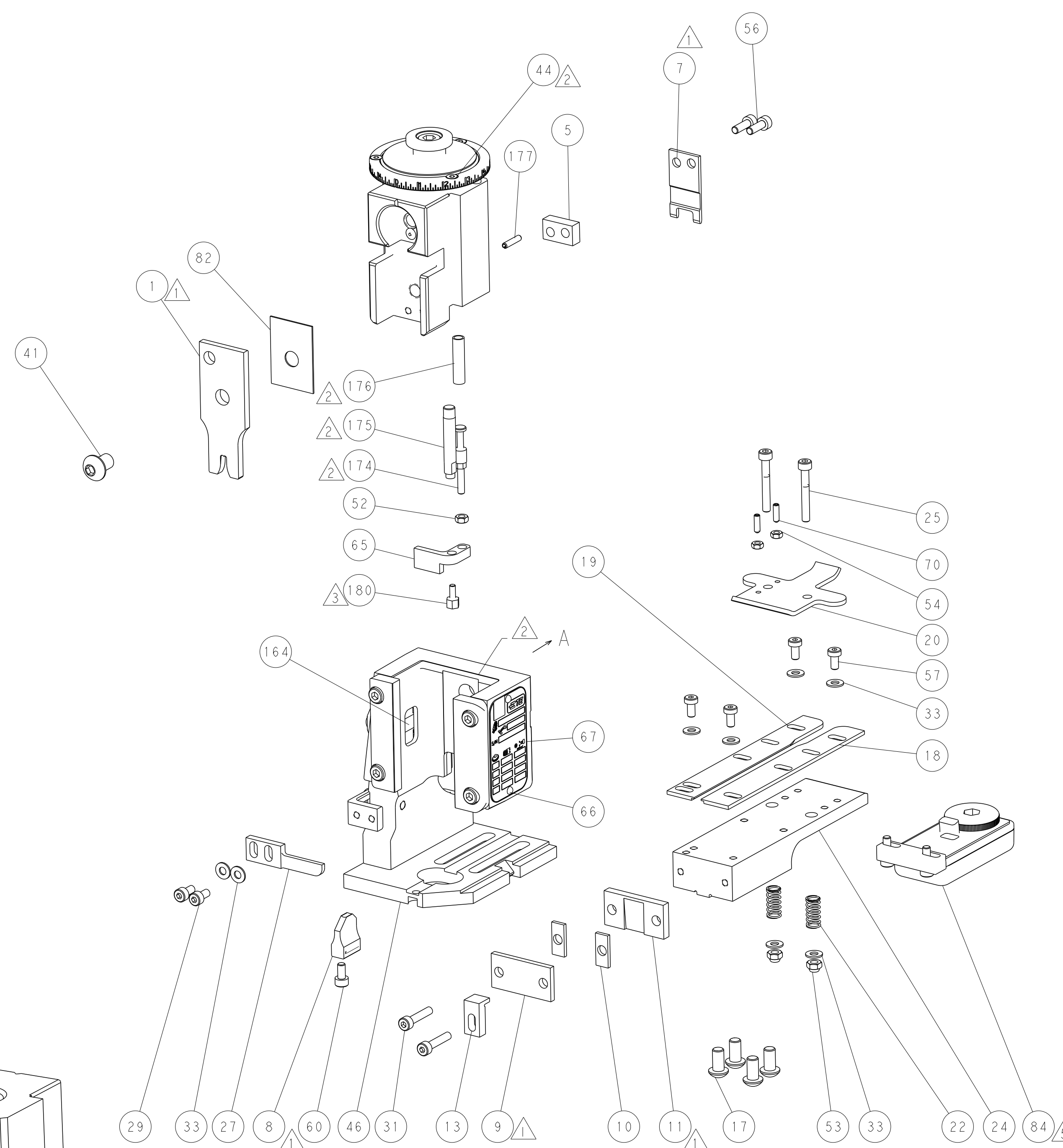
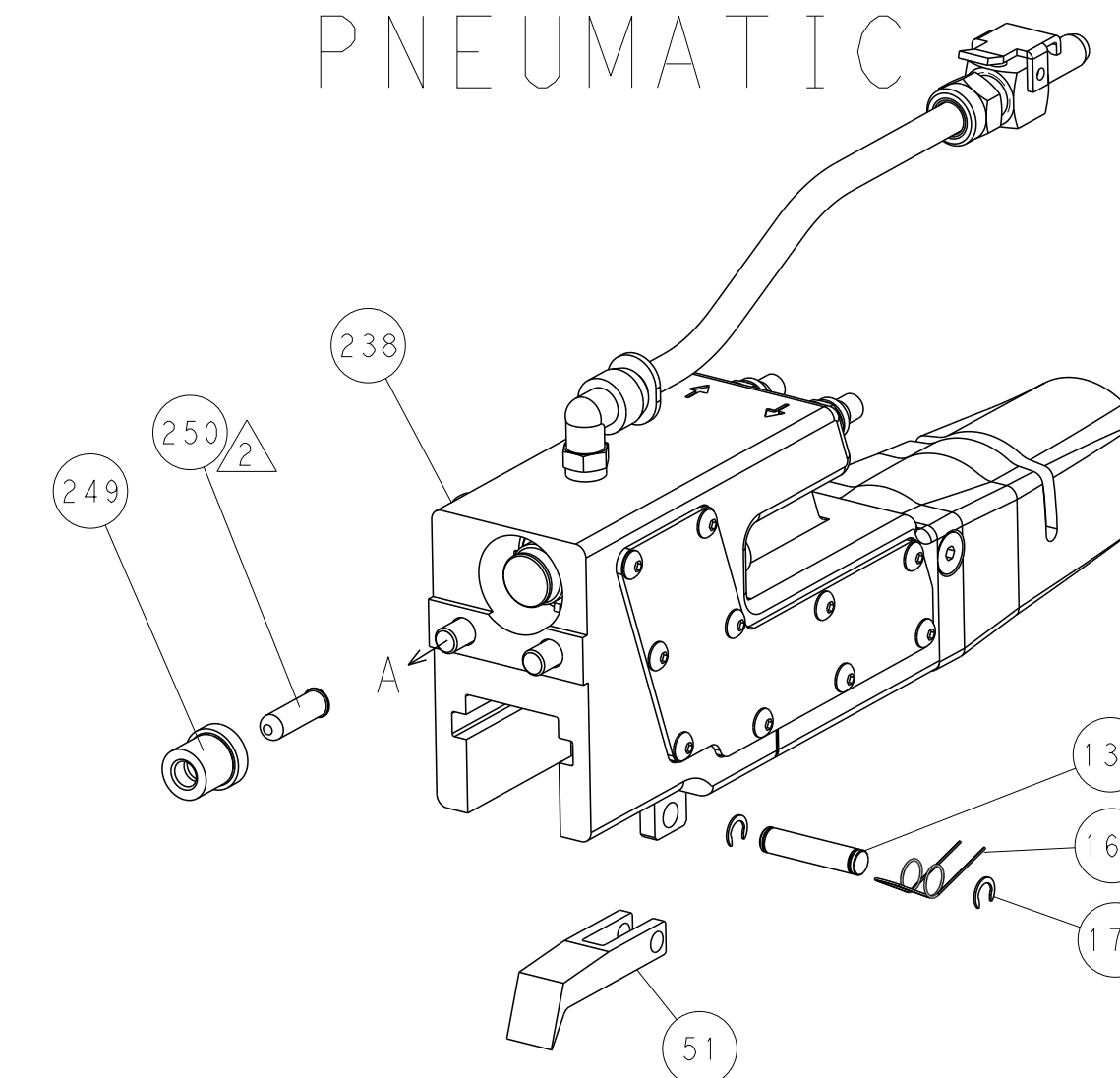


RAM AND HOLDDOWN SET-UP

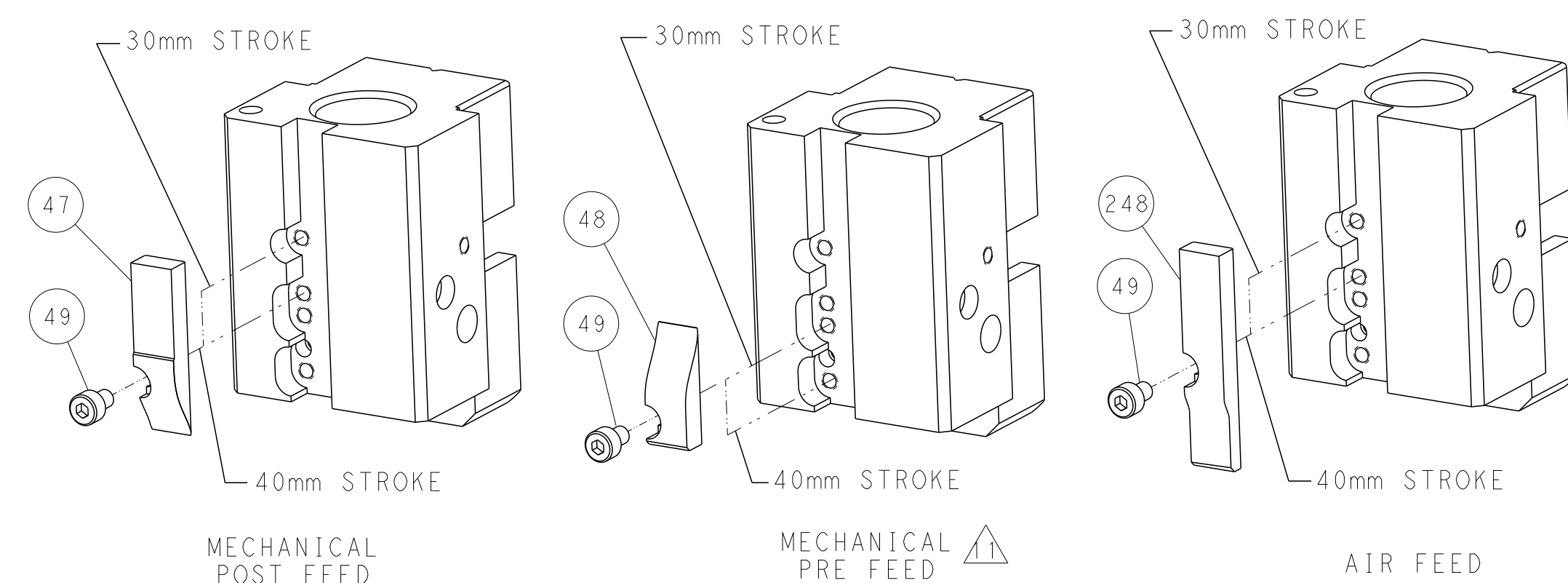
FEED TYPE
MECHANICAL



PNEUMATIC



CAM POSITIONS



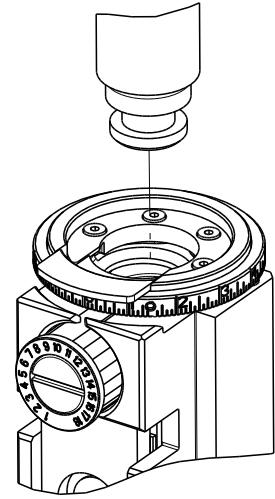
ATLANTIC VERSION

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

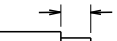
THIS DRAWING IS A CONFIDENTIAL DOCUMENT FOR TFCO. ANY REPRODUCTION OR DISSEMINATION OF THIS DOCUMENT WITHOUT THE WRITTEN PERMISSION OF TFCO IS PROHIBITED. TFCO IS SUBJECT TO CHANGE AND THE CONTROLLING ENGINEERING ORGANIZATION SHALL BE NOTIFIED FOR THE LATEST VERSION.		DWN # HUANG 25JAN2016 CHK ZHANG 25JAN2016 APVD U GUO 25JAN2016		 TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.1 1 PLC ±.1 2 PLC ±.1 3 PLC ±.1 4 PLC ±.1 ANGLES ±.1		NAME Ocean End Feed Applicator	
		PRODUCT SPEC - APPLICATION SPEC -		SIZE A 00779 C=2150644	
MATERIAL -		FINISH -		RESTRICTED TO -	
WEIGHT -		SCALE 1:1		SHEET 2 OF 4 REV A	
Customer Accessible Production Drawing					

8		7	
THIS DRAWING IS UNPUBLISHED.		RELEASED FOR PUBLICATION	
20		20	
© COPYRIGHT 20 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.			
PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150644-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2150644-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150644-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



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

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: TERMINAL, RING			
WIRE STRIP LENGTH 5.34-6.10 mm [.210-.240 IN]			INSULATION DIAMETER RANGE Ø
TERMINAL APPLICATION SPECIFICATION	114-2084	-	-
TERMINALS APPLIED 			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
40977	40517	40521	40796
60505-1			

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING
14 AWG		2.51+/-0.05 [.099+/- .002]		5.0
16 AWG		2.36+/-0.05 [.093+/- .002]		6.5
18 AWG		2.21+/-0.05 [.087+/- .002]		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 180.
- 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 LUBRICANT IS RECOMMENDED.
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.

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

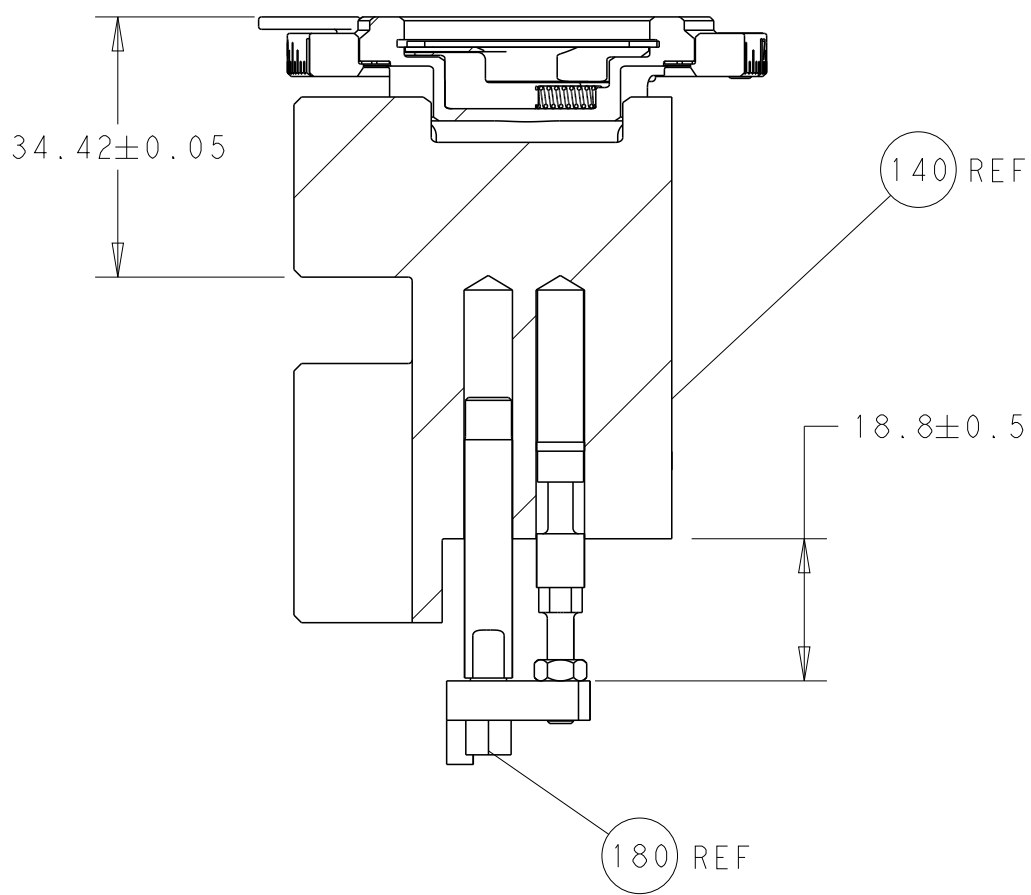
2		1						
LOC	DIST	REVISIONS						
A	66	P	LTR	DESCRIPTION	DATE	DWN	APVD	
		-		SEE SHEET 1	-	-	-	

	-	1	-	2119640-1	PUSH ROD, AIR FEED	250
	-	1	-	1803259-1	BUSHING, FLANGED	249
	-	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
	-	1	-	2063440-1	AIR FEED MODULE	238
	-	4	4	2079383-9	SCR, BHSC, RoHS (M6 X 20)	186
5	-	1	1	1752354-3	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	-	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172
	-	REF	REF	994970-2	COUNTER, MAGNETIC	164
	-	1	-	240638-1	SPRING, FEED FINGER	163
	-	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	-	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854	137
5	-	1	1	2119955-2	ASSY, LUBRICATOR, END FEED	84
	-	1	1	455888-6	SPACER, CRIMPER	82
	-	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
	-	-	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	-	2119792-2	PAWL, EF, AIR	51
	-	1	2	18023-9	SCR, SKT HD CAP M4 X 6.0	49
	-	-	1	2119652-1	FEED CAM, PRE FEED	48
	-	1	1	1803602-3	SCR, BHSC, RoHS (M8 X 12)	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	1803292-4	DRAG	20
	-	1	1	1901696-3	STRIP GUIDE, REAR	19
	-	1	1	1901695-3	STRIP GUIDE, FRONT	18
	-	1	1	1752360-1	SPACER,HOLD-DOWN	13
1	-	1	1	240644-1	PLATE, REAR SHEAR	11
1	-	2	2	240645-8	SPACER, SHEAR PLATE	10
1	-	1	1	240642-1	PLATE, FRONT SHEAR	9
1	1	1	1	1-1333224-4	ANVIL, COMBINATION (E.F. WIRE/B ONLY)	8
1	-	1	1	1803366-1	BLADE, SLUG -	7
	-	-	-	-	-	6
	-	1	1	2-240641-5	SPACER	5
	-	-	-	-	-	4
	-	-	-	-	-	3
	-	-	-	-	-	2
1	1	1	1	456411-9	CRIMPER, WIRE PREMIUM	1
	-77-	-22-	-21	PART NO	DESCRIPTION	ITEM NO

THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. THE USER SHALL BE RESPONSIBLE FOR OBTAINING THE LATEST EDITION.				DWN R. HUANG 25JAN2016	TE Connectivity Harrisburg, PA 17105-3608						
CHK L. ZHANG 25JAN2016				APVD J. GUO 25JAN2016	NAME Ocean End Feed Applicator - SIZE A 00779 C=2150644 SCALE 1:1						
DIMENSIONS: mm				PRODUCT SPEC							
				APPLICATION SPEC							
MATERIAL -				WEIGHT -							
TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH -				RESTRICTED TO - SHEET 3 OF 4							
Customer Accessible Production Drawing				REV B							
SHEET											

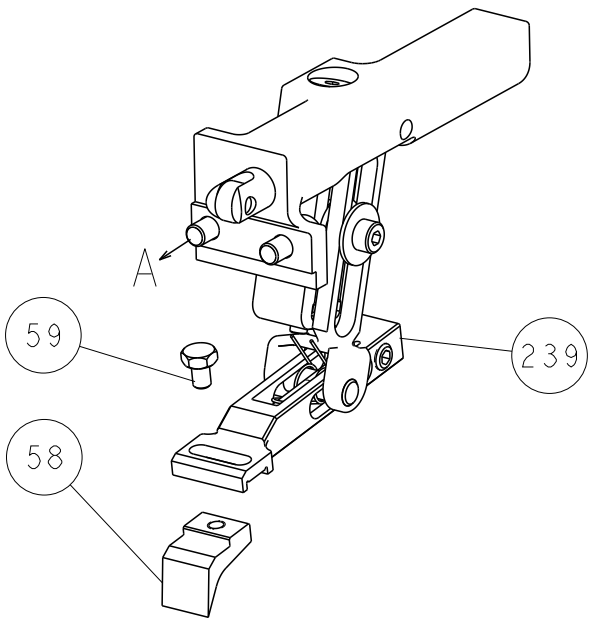
SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

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

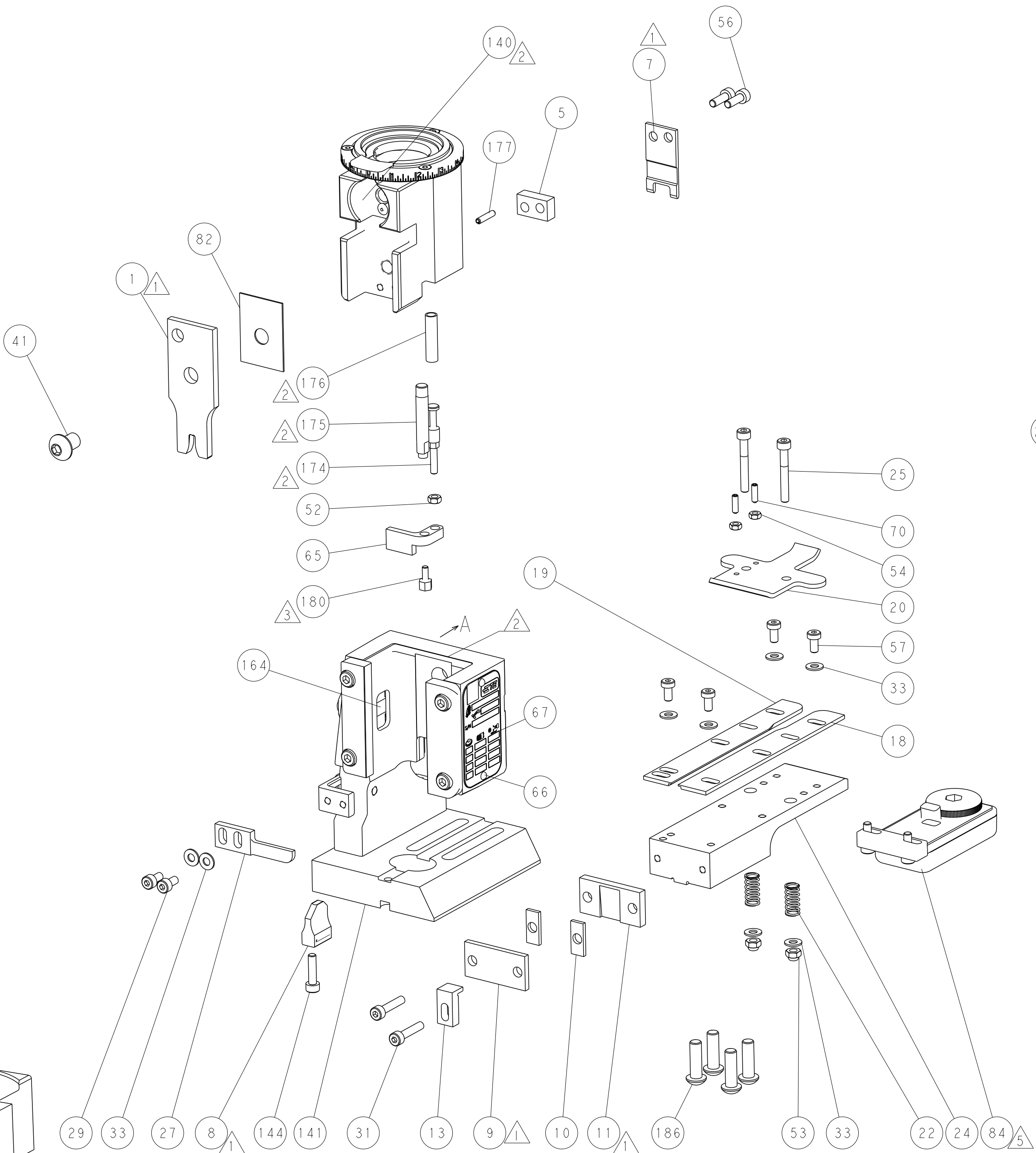
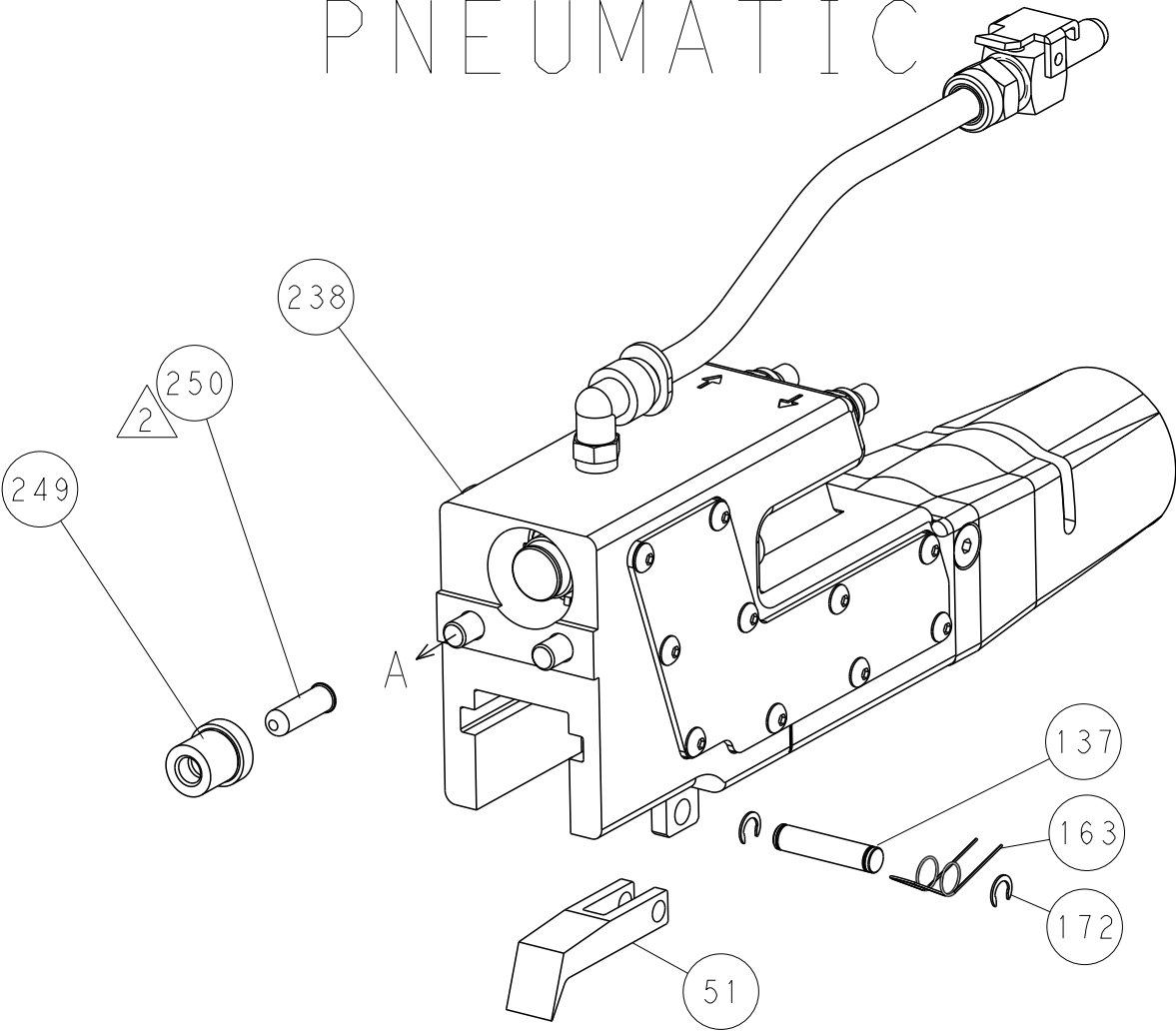


RAM AND HOLDDOWN SET-UP

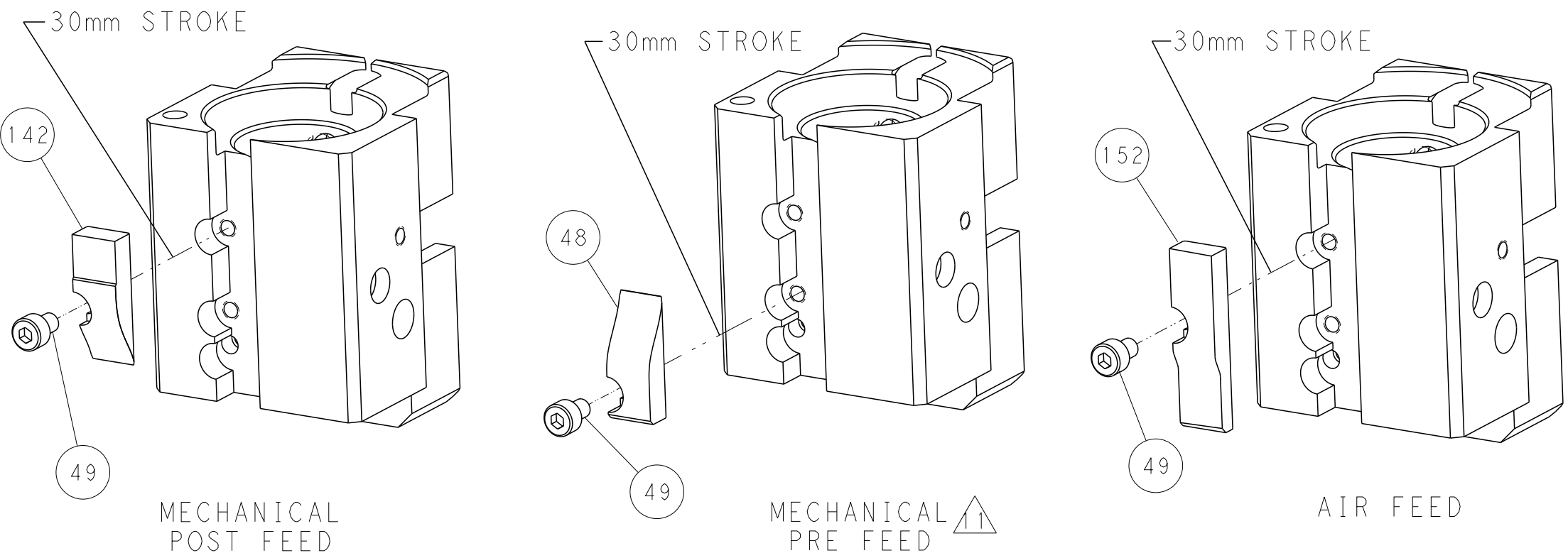
FEED TYPE
MECHANICAL



PNEUMATIC



CAM POSITIONS



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

THIS DRAWING IS UNPUBLISHED. IT IS THE PROPERTY OF TYCO ELECTRONICS CORPORATION. IT IS LOANED TO YOUR COMPANY FOR YOUR COMPANY'S USE ONLY. IT IS NOT TO BE REPRODUCED OR COPIED IN ANY MANNER WITHOUT THE WRITTEN PERMISSION OF TYCO ELECTRONICS CORPORATION. IT IS THE PROPERTY OF TYCO ELECTRONICS CORPORATION. IT IS LOANED TO YOUR COMPANY FOR YOUR COMPANY'S USE ONLY. IT IS NOT TO BE REPRODUCED OR COPIED IN ANY MANNER WITHOUT THE WRITTEN PERMISSION OF TYCO ELECTRONICS CORPORATION.				DWN K. HUANG 25JAN2016	STE TE Connectivity Harrisburg, PA 17105-3608		
DIMENSIONS: mm				CHK L. ZHANG 25JAN2016			
TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.1 1 PLC ±.1 2 PLC ±.1 3 PLC ±.1 4 PLC ±.1 ANGLES ±.1 FINISH				APVD J. GUO 25JAN2016	NAME Ocean End Feed Applicator		
MATERIAL -				PRODUCT SPEC	SIZE A		
				APPLICATION SPEC	CAGE CODE 00779		
				WEIGHT -	DRAWING NO C=2150644		
				Customer Accessible Production Drawing	SCALE 1:1		
					SHEET 4		
					OF 4		
					REV B		

Mouser Electronics

Authorized Distributor

Click to View Pricing, Inventory, Delivery & Lifecycle Information:

[TE Connectivity:](#)

[2150644-1](#)