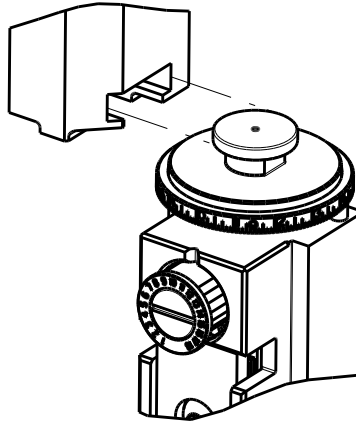
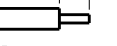
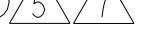


8		7	
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20		20	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150198-2	F	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150198-2	F	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150198-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	5.33 mm [.210]	F
INSUL	6.35 mm [.250]	O
APPLICATOR INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: TERMINAL, RING			
WIRE STRIP LENGTH 4.78-5.54 mm [.188-.218 IN]			INSULATION DIAMETER RANGE Ø3.81-5.33 mm [.150-.210 IN]
TERMINAL APPLICATION SPECIFICATION	114-2084	-	-
TERMINALS APPLIED 			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
41124	41125	42722-1	62691-1
41124-1	41125-1	42724-1	62691-2
41124-2	41126		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
10 AWG	3.07+/-0.05 [.121+/- .002]	6.0
12 AWG	2.77+/-0.05 [.109+/- .002]	10.0



- 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 MACHANICAL FEED.
6. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- TERMINAL LUBRUCANT 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.

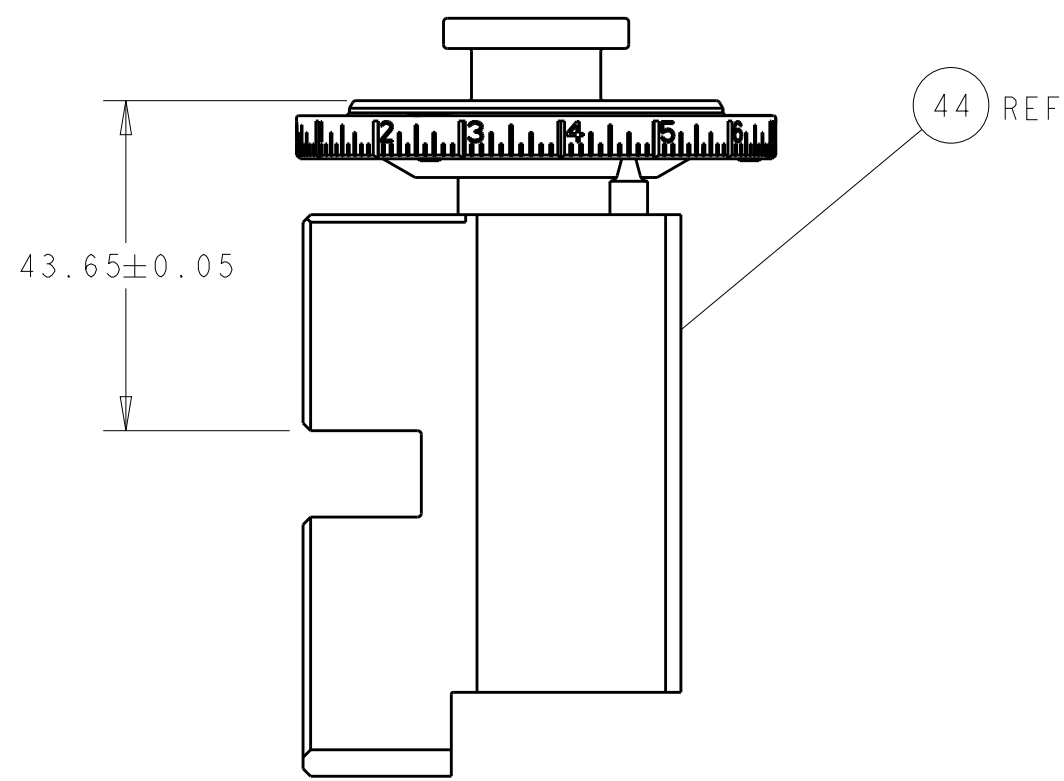
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

LOC		DIST		REVISONS			
A		66		P	LTR	DESCRIPTION	DATE
							DWN
							APVD
				C		ECR-18-014305	11SEP2018
				D		ECR-20-001030	21JAN2020
				E		ECR-20-003424	06MAR2020
				F		ECR-20-014469	13OCT2020

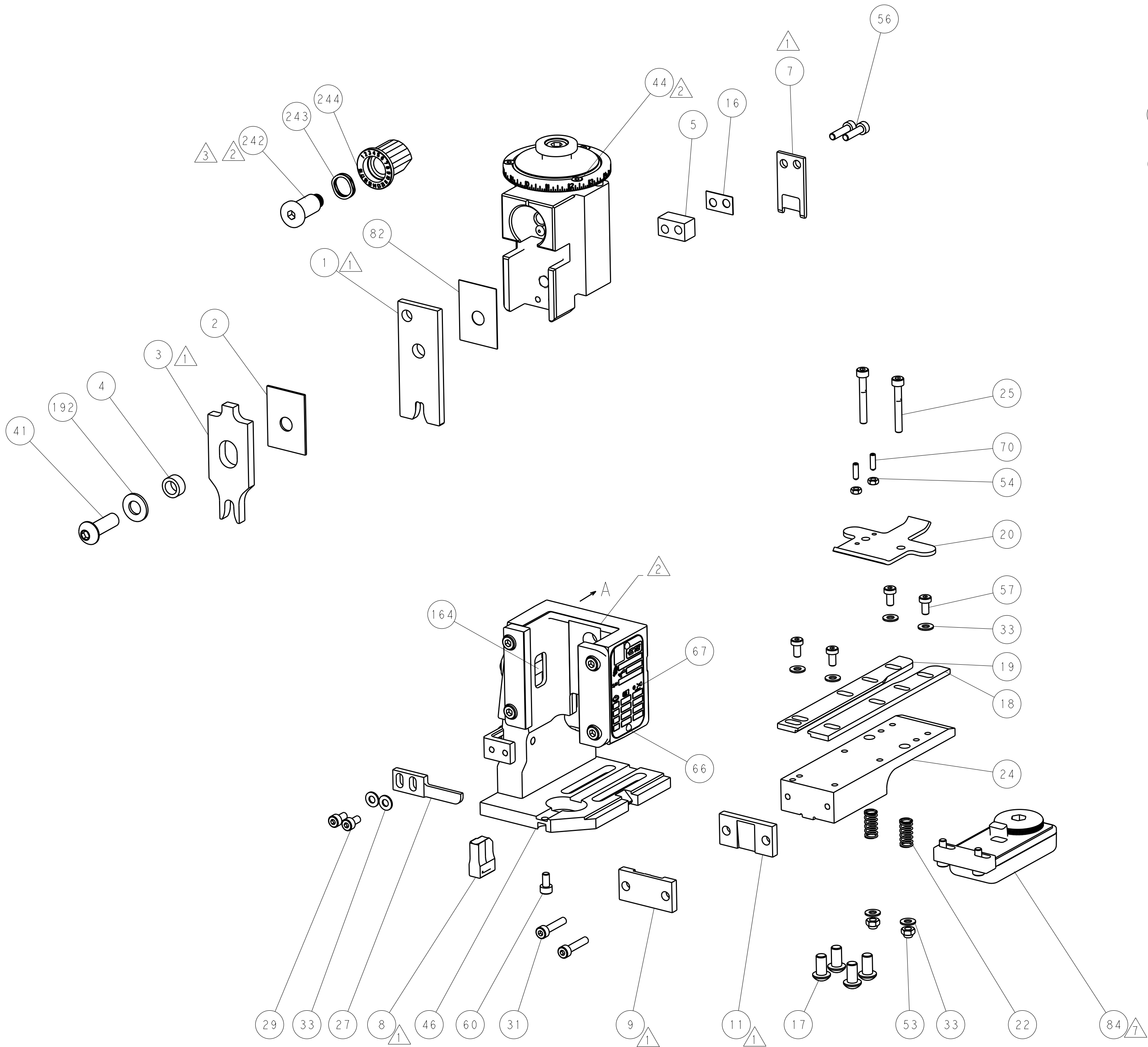
-	1	1	2119641-1	FEED CAM, AIR FEED	248
-	1	1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	1	2844940-4	AIR FEED MODULE	238
-	1	1	1-18028-0	WASHER, FLAT, REG M8	192
-	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	1	1	2119955-2	ASSY, LUBRICATOR, END FEED	84
-	1	1	455888-3	SPACER, CRIMPER	82
-	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	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	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	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	240639-1	STRIPPER (MACHINING)	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	2-22281-3	SPRING, COMPRESSION	22
-	1	1	1803292-4	DRAG	20
-	1	1	1-1901696-0	STRIP GUIDE, REAR	19
-	1	1	1-1901695-0	STRIP GUIDE, FRONT	18
-	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17
-	1	1	5-240641-8	SPACER	16
-	1	1	240644-1	PLATE, REAR SHEAR	11
-	1	1	690482-7	PLATE, FRONT SHEAR	9
-	1	2	1-1633384-9	ANVIL, COMBINATION	8
-	1	1	1-2217206-8	BLADE, SLUG	7
-	1	1	5-240641-3	SPACER	5
-	1	1	6-238011-1	BLOCK, CRIMPER SPACER	4
-	1	2	1803018-9	CRIMPER, INSULATION O	3
-	1	1	1-455888-0	SPACER, CRIMPER	2
-	1	2	456430-1	CRIMPER, WIRE	1
-	77	72	-2	PART NO	DESCRIPTION
-	77	72	-2	PART NO	DESCRIPTION

THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE AND SHOULD BE CONTACTED FOR THE LATEST REVISION.		DWN	29FEB2012	TE Connectivity Harrisburg, PA 17105-3608	
CHK		L. ZHANG	29FEB2012	NAME	
APVD		S. XI	29FEB2012	PRODUCT SPEC	
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		APPLICATION SPEC	
mm		0 PLC ±		SIZE	
mm		1 PLC ±		CAGE CODE	
mm		2 PLC ±		DRAWING NO	
mm		3 PLC ±		RESTRICTED TO	
mm		4 PLC ±		MATERIAL	
mm		FINISH		WEIGHT	
mm		-		CUSTOMER ACCESSIBLE PRODUCTION DRAWING	
mm		-		SCALE	
mm		-		SHEET	
mm		-		OF	
mm		-		REV	
mm		-		F	

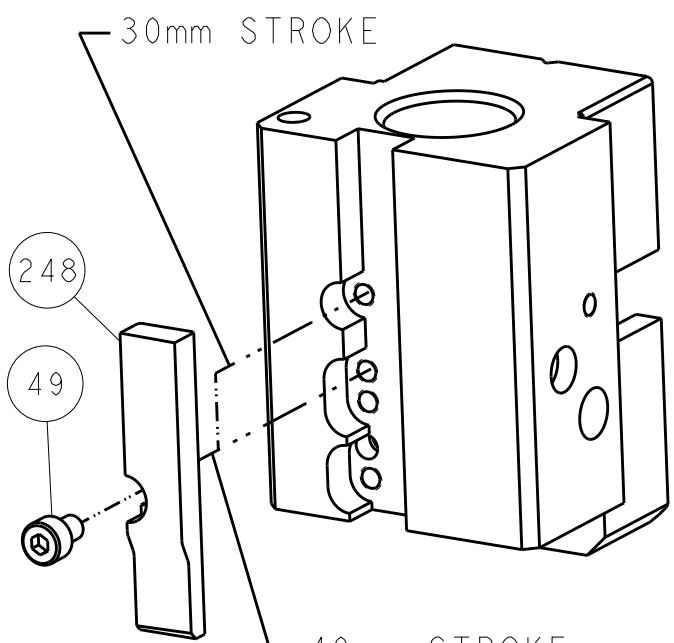
LOC		DIST		REVISONS			
A	66	P	LTR	DESCRIPTION	DATE	DWN	APVD
		-		SEE SHEET 1	-	-	-



RAM SET-UP

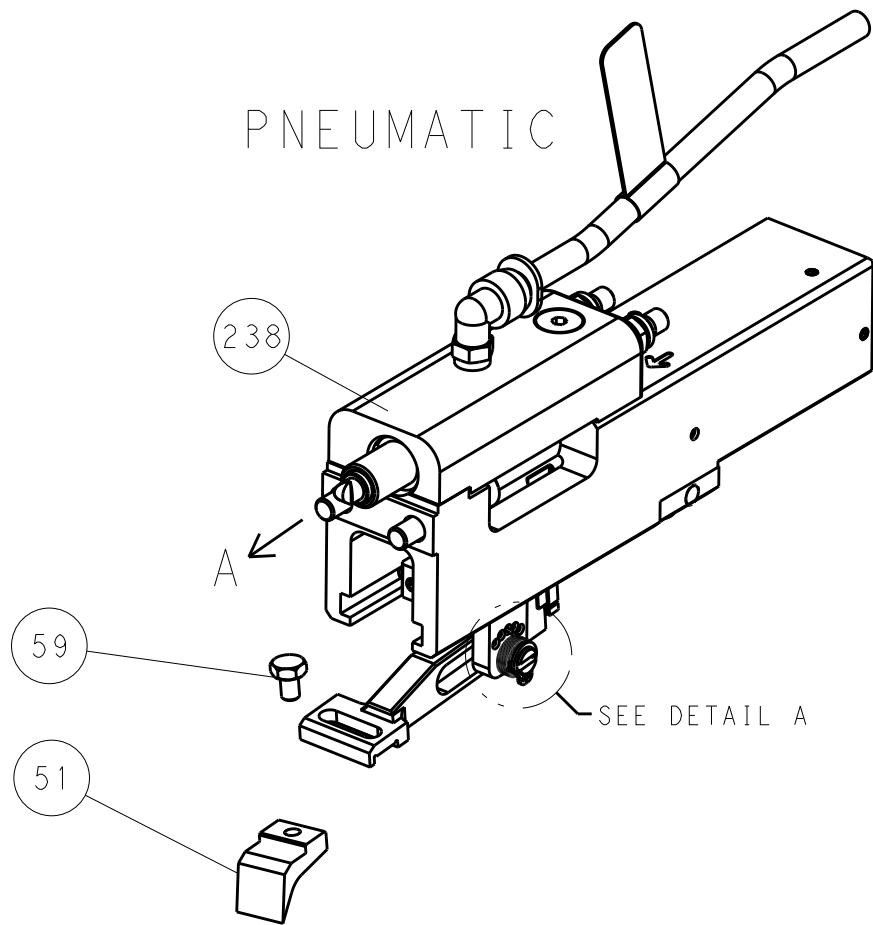


CAM POSITION

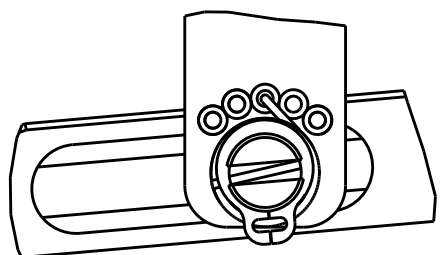


AIR FEED

FEED TYPE



FEED SPRING
SETTING POSITION



DETAIL A

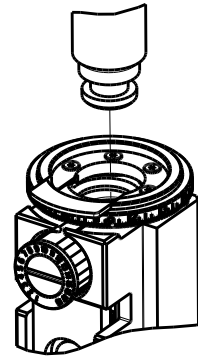
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

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CHK L. ZHANG 29FEB2012				NAME		Ocean End Feed Applicator	
APVD S. XI 29FEB2012				PRODUCT SPEC		SIZE CAGE CODE DRAWING NO	
APPLICATION SPEC				WEIGHT		A1 00779 C=2150198	
MATERIAL				CUSTOMER ACCESSIBLE PRODUCTION DRAWING		SCALE 1:1 SHEET 2 OF 4 REV F	

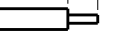
SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

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20		20	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150198-2	F	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150198-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	5.33 mm [.210]	F
INSUL	6.35 mm [.250]	O
APPLICATOR INSTRUCTIONS		
408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: TERMINAL, RING			
WIRE STRIP LENGTH 4.78-5.54 mm [.188-.218 IN]			INSULATION DIAMETER RANGE Ø3.81-5.33 mm [.150-.210 IN]
TERMINAL APPLICATION SPECIFICATION	114-2084	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
41124	41125	42722-1	62691-1
41124-1	41125-1	42724-1	62691-2
41124-2	41126		

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING
10 AWG		3.07+/-0.05 [.121+/-0.002]		6.0
12 AWG		2.77+/-0.05 [.109+/-0.002]		10.0



- 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 MACHANICAL FEED.
- UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- TERMINAL LUBRUCANT IS RECONMENDED

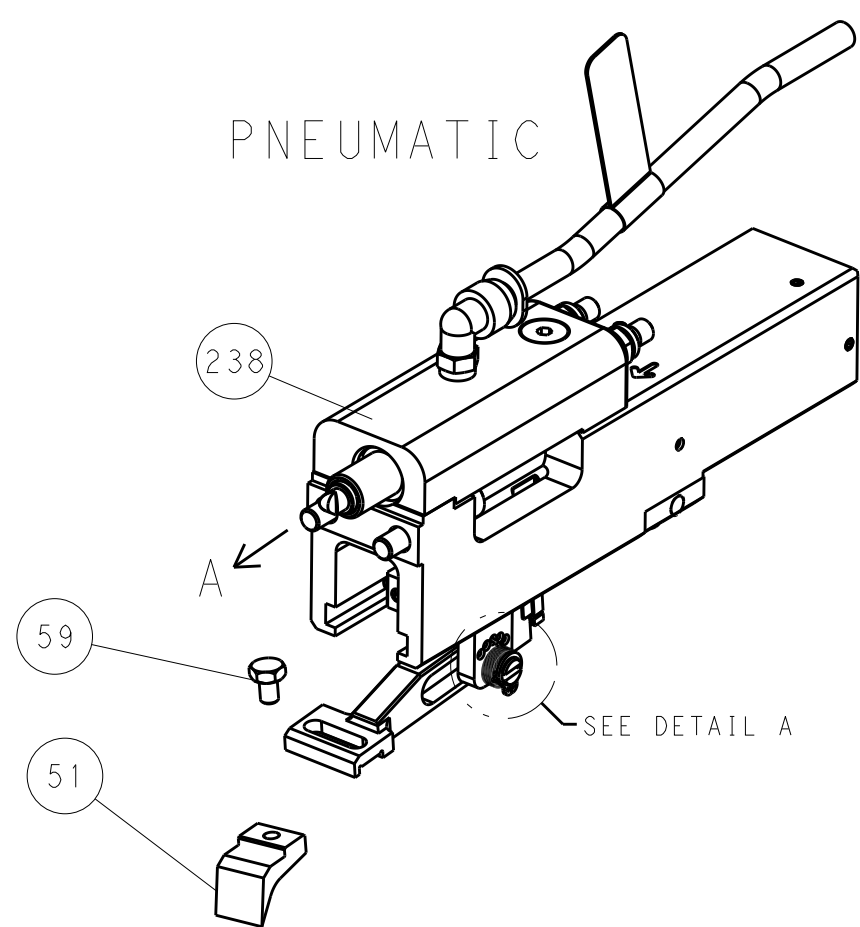
*WARNING
ON INSTALLATION, SET WIRE DISC TO CRIMP HEIGHT REFERENCE SETTING FOR LARGEST WIRE SIZE. CRIMP HEIGHT REFERENCE SETTINGS GREATER THAN THE VALUE SHOWN MAY CAUSE DAMAGE TO THE CRIMP TOOLING, REFER TO THE INSTRUCTION SHEET FOR PROPER SETUP AND ADJUSTMENTS.

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

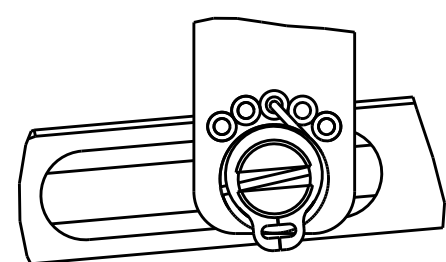
LOC	DIST	REVISIONS				
		P	LTR	DESCRIPTION	DATE	OWN
A	66	-	-	SEE SHEET 1	-	-

-	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	2119955-2	ASSY, LUBRICATOR, END FEED	84
-	1	455888-3	SPACER, CRIMPER	82
-	1	1803607-4	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	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	4	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57
-	2	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	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	240639-1	STRIPPER (MACHINING)	27
-	2	1-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 30	25
-	1	1752371-1	PLATE, STRIP GUIDE	24
-	2	2-22281-3	SPRING, COMPRESSION	22
-	1	1803292-4	DRAG	20
-	1	1-1901696-0	STRIP GUIDE, REAR	19
-	1	1-1901695-0	STRIP GUIDE, FRONT	18
-	1	5-240641-8	SPACER	16
-	1	240644-1	PLATE, REAR SHEAR	11
-	1	690482-7	PLATE, FRONT SHEAR	9
1	1	1-1633384-9	ANVIL, COMBINATION	8
-	1	1-2217206-8	BLADE, SLUG	7
-	1	5-240641-3	SPACER	5
-	1	6-238011-1	BLOCK, CRIMPER SPACER	4
1	1	1803018-9	CRIMPER, INSULATION O	3
-	1	1-455888-0	SPACER, CRIMPER	2
1	1	456430-1	CRIMPER, WIRE	1
-77-22		PART NO	DESCRIPTION	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	
		DRAWING NO 00779		SHEET 3 OF 4	
		REV F			



FEED SPRING
SETTING POSITION



DETAIL A

30mm STROKE

(152)

AIR FEED

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

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		CHG L. ZHANG 29FEB2012		Harrisburg, PA 17105-3608	
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED: APVD S XI 29FEB2012		NAME Ocean End Feed Appliator	
		PRODUCT SPEC - APPLICATION SPEC -		SIZE CAGE CODE DRAWING NO	
MATERIAL FINISH		WEIGHT -		A 00779 C=2150198	
		CUSTOMER ACCESSIBLE PRODUCTION DRAWING		SCALE 1:1 SHEET 4 OF 4 REV F	

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