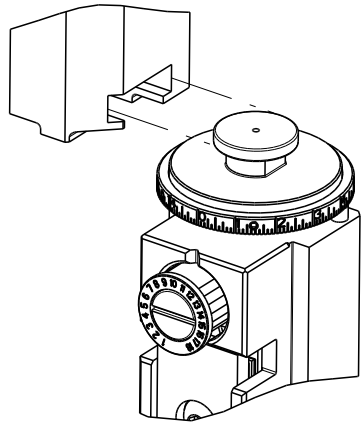


8		7	
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20		20	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150393-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150393-2	B	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150393-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	4.32 mm [.170]	F
INSUL	5.70 mm [.224]	F
APPLICATOR INSTRUCTIONS 408-35043		

TERMINAL DATA: YAZAKI TERMINAL YAZAKI CRIMP SPECIFICATION			
TERMINAL NAME: TERMINAL			
WIRE STRIP LENGTH 5.00-6.00 mm [.197-.236 IN]		INSULATION DIAMETER RANGE Ø 6.02mm MAX [.237 IN MAX]	
TERMINAL APPLICATION SPECIFICATION	WA1881	-	-
TERMINALS APPLIED			
TE TERMINAL	YAZAKI TERMINAL	TE TERMINAL	YAZAKI TERMINAL
1949285-1	7114-3030	1949285-2	7114-3030-02

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING
5.00mm2		2.25+/-0.05 [.089+/-0.002]		5.5
3.00mm2		1.95+/-0.05 [.077+/-0.002]		8.6



- 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 COMPATABLE 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	REVISONS				
A	66	P	LTR	DESCRIPTION	DATE	DWN
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			B	ECR-19-007869	16MAY2019	TB

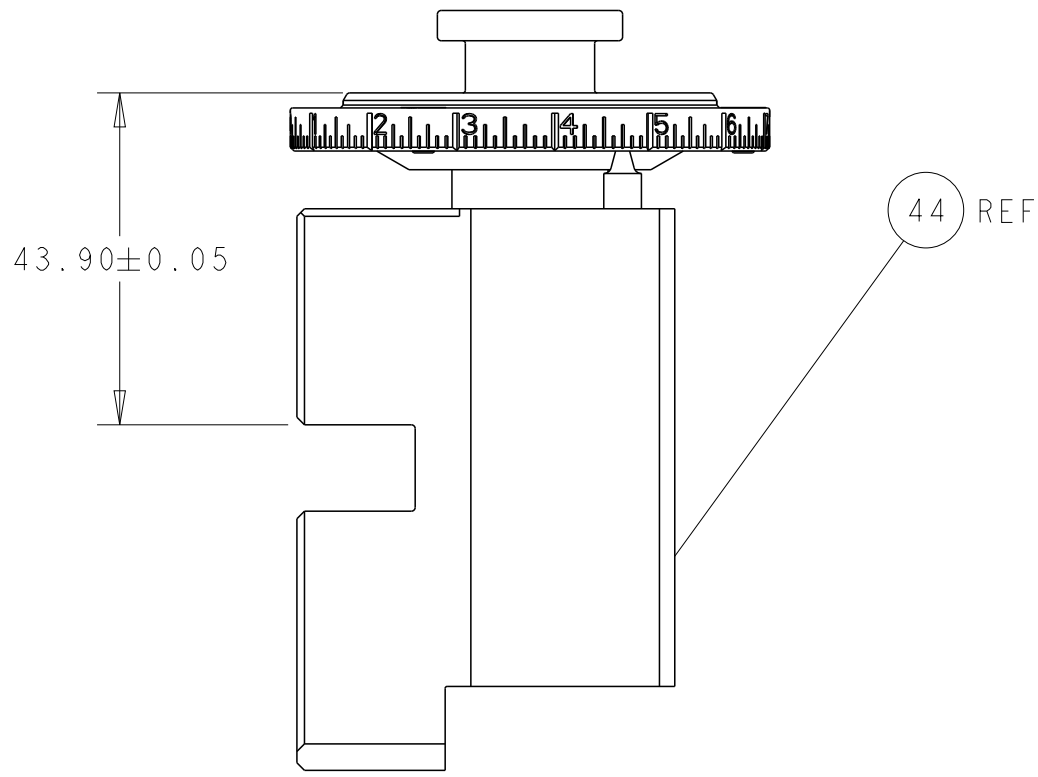
	-	1	1	2119640-1	PUSH ROD, AIR FEED	250
	-	1	1	1803259-1	BUSHING, FLANGED	249
	-	1	1	2119641-1	FEED CAM, AIR FEED	248
	-	1	1	2119082-7	CAM, SNAIL, INSULATION ADJUSTMENT	244
	-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
3	-	1	1	2119083-1	RETAINER, INSULATION DIAL	242
	-	1	1	2063440-2	AIR FEED MODULE	238
	-	1	1	1-18028-0	WASHER, FLAT, REG M8	192
	-	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	1	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854	137
	-	1	1	455888-5	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	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	60
	-	4	4	2168400-1	SHCS, LOW HEAD, RoHS, M4 X 12	57
	-	2	2	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	56
	-	2	2	5018030-1	NUT, HEX, REG, RoHS, M3	54
	-	2	2	986965-8	NUT, LOCK, HEX, TORQUE (M4)	53
	-	1	1	2119792-2	PAWL, EF, AIR	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	1-2168083-6	SCR, SKT HD CAP, RoHS, M4 X 35	25
	-	1	1	1-1752371-2	PLATE, STRIP GUIDE	24
	-	2	2	22281-9	SPRING, COMPRESSION	22
	-	1	1	1803292-4	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	1	7-240641-2	SPACER	16
	-	1	1	240644-5	PLATE, REAR SHEAR	11
	-	-	-	-	-	10
1	-	1	1	7-690482-1	PLATE, FRONT SHEAR	9
1	1	2	1	3-1803000-8	ANVIL, COMBINATION, END FEED	8
1	-	1	1	1-2217206-3	BLADE, SLUG	7
	-	-	-	-	-	6
	-	1	1	2-240641-2	SPACER	5
	-	1	1	4-238011-5	BLOCK, CRIMPER SPACER	4
1	1	2	1	4-1633962-7	CRIMPER, INSULATION F PREMIUM	3
	-	1	1	1-455888-2	SPACER, CRIMPER	2
1	1	2	1	6-1673600-2	CRIMPER, WIRE	1
	-77-72	-2		PART NO	DESCRIPTION	ITEM NO

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 UNPUBLISHED. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. THE USER SHALL BE RESPONSIBLE FOR OBTAINING THE LATEST EDITION.		DWN R. HUANG CHK L. ZHANG APVD J. GUO	31OCT2013 31OCT2013 31OCT2013	TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		NAME Ocean End Feed Applicator	
		0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH ±		PRODUCT SPEC APPLICATION SPEC	
MATERIAL -		WEIGHT -		SIZE A	
Customer Accessible Production Drawing		SCALE 1:1		SHEET 1 OF 4	
REV B		DRAWING NO 00779		RESTRICTED TO -	

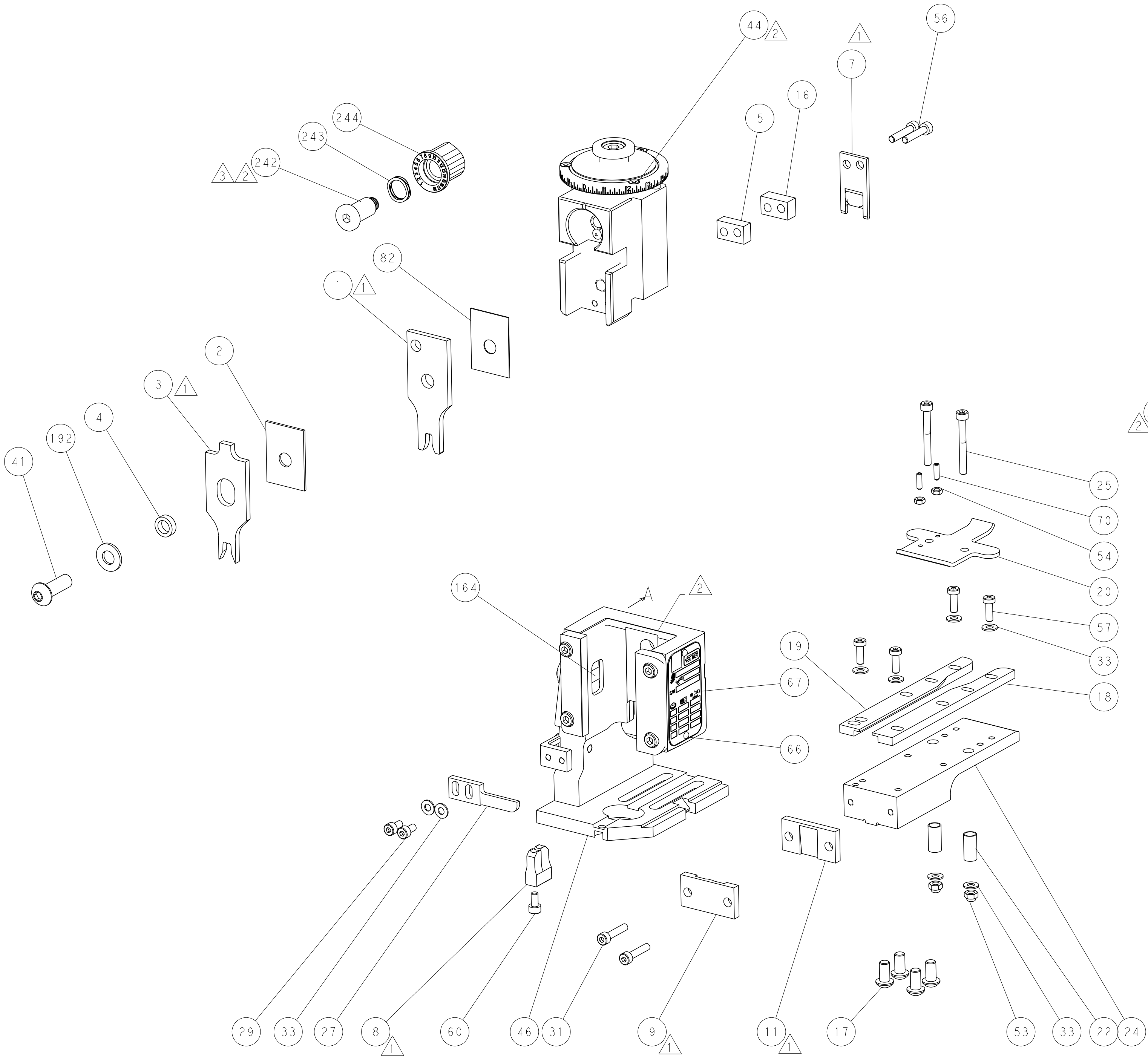
SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

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

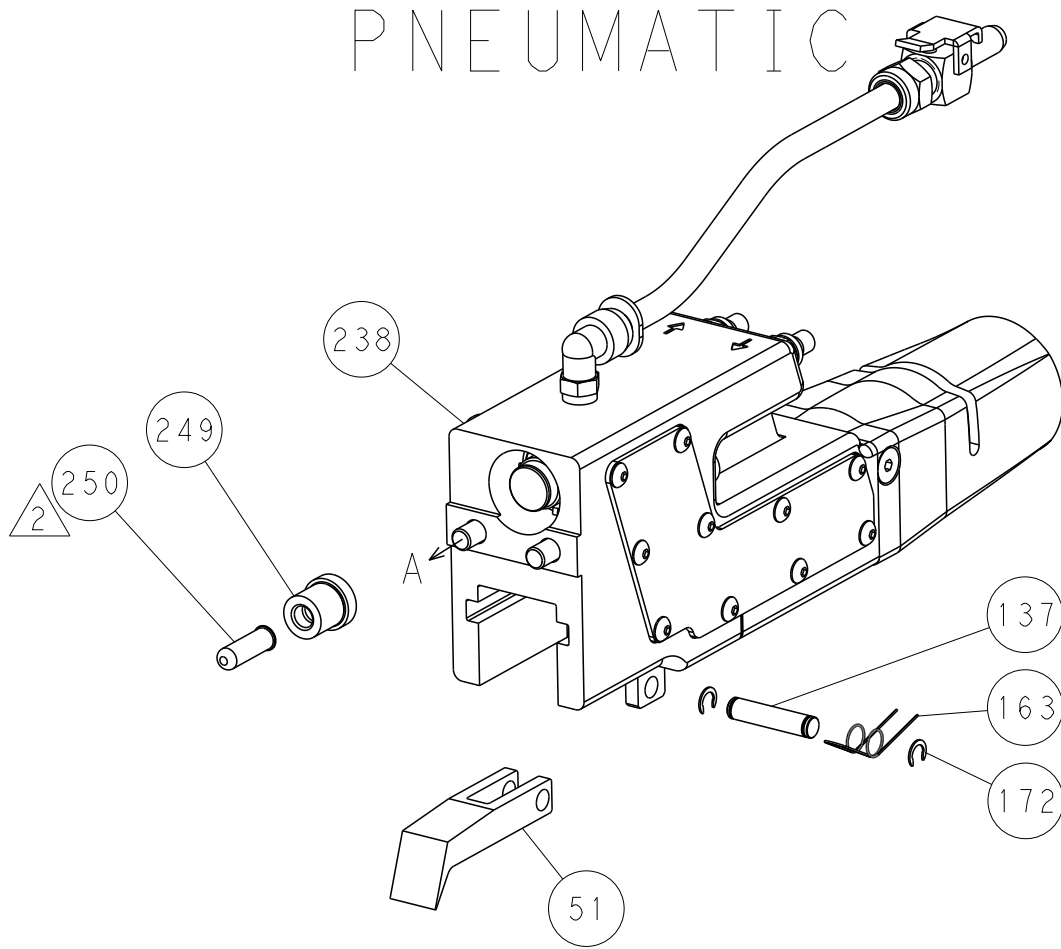


RAM SET-UP

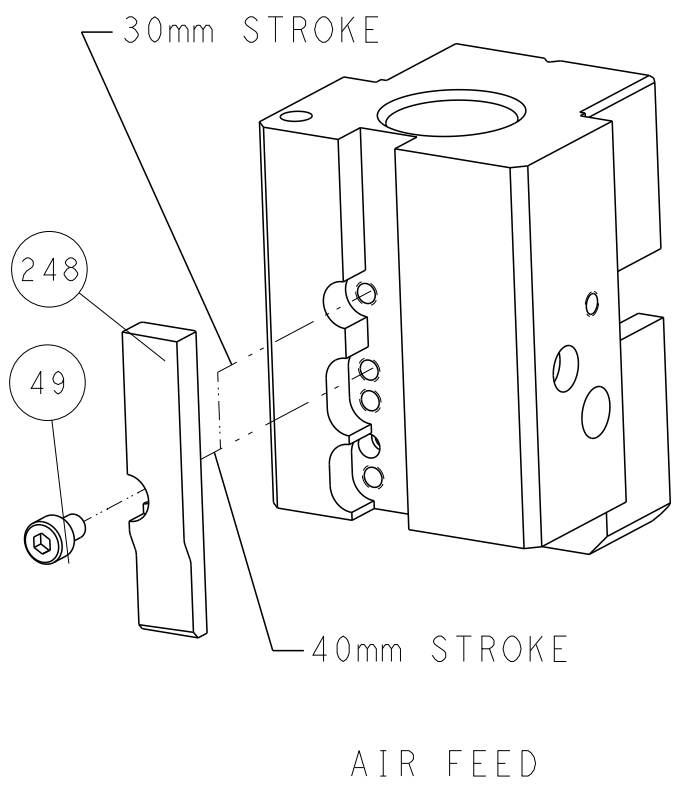
FEED TYPE



PNEUMATIC

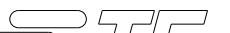


CAM POSITION



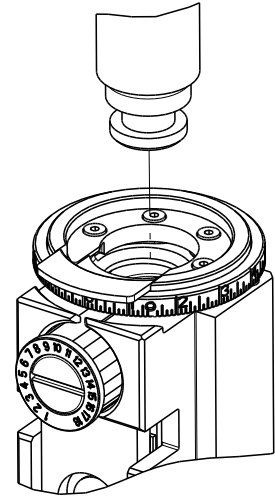
AIR FEED

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

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				CHK L. ZHANG	31OCT2013							
				APVD J. GUO	31OCT2013	NAME Ocean End Feed Applicator						
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		PRODUCT SPEC		RESTRICTED TO						
				APPLICATION SPEC								
		0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH		-		SIZE		CAGE CODE	DRAWING NO	-		
MATERIAL		-		WEIGHT		A		00779	C=2150393			
Customer Accessible Production Drawing						SCALE		1:1	SHEET	2 of 4	REV	B

8		7	
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20		20	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150393-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150393-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	4.32 mm [.170]	F
INSUL	5.70 mm [.224]	F
APPLICATOR INSTRUCTIONS 408-35043		

TERMINAL DATA: YAZAKI TERMINAL YAZAKI CRIMP SPECIFICATION			
TERMINAL NAME: TERMINAL			
WIRE STRIP LENGTH 5.00-6.00 mm [.197-.236 IN]		INSULATION DIAMETER RANGE Ø 6.02mm MAX [.237 IN MAX]	
TERMINAL APPLICATION SPECIFICATION	WA1881	-	-
TERMINALS APPLIED			
TE TERMINAL	YAZAKI TERMINAL	TE TERMINAL	YAZAKI TERMINAL
1949285-1	7114-3030	1949285-2	7114-3030-02

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING
5.00mm2		2.25+/-0.05 [.089+/- .002]		5.5
3.00mm2		1.95+/-0.05 [.077+/- .002]		8.6



- 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 COMPATABLE 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.

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

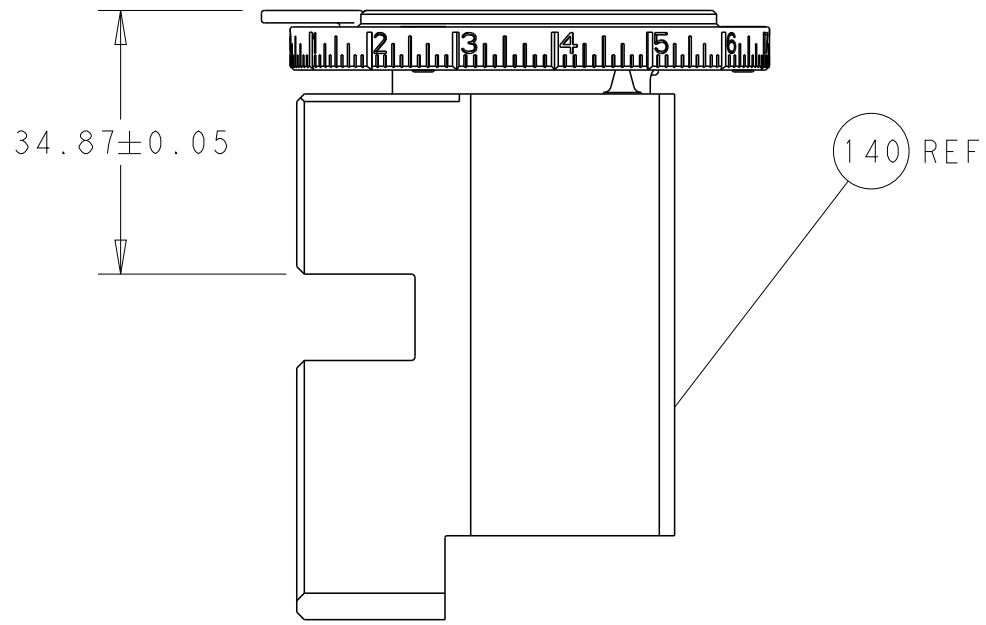
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LOC	DIST	REVISIONS						
A	66	P	LTR	DESCRIPTION	DATE	DWN	APVD	
		-		SEE SHEET 1	-	-	-	

3	-	1	2119640-1	PUSH ROD, AIR FEED	250
	-	1	1803259-1	BUSHING, FLANGED	249
	-	1	2119082-7	CAM, SNAIL, INSULATION ADJUSTMENT	244
	-	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
	-	1	2119083-1	RETAINER, INSULATION DIAL	242
	-	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
	-	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
	-	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	455888-5	SPACER, CRIMPER	82
	-	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
	-	4	2168400-1	SHCS, LOW HEAD, RoHS, M4 X 12	57
	-	2	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	56
	-	2	5018030-1	NUT, HEX, REG, RoHS, M3	54
	-	2	986965-8	NUT, LOCK, HEX, TORQUE (M4)	53
-	1	2119792-2	PAWL, EF, AIR	51	
1	-	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	1-2168083-6	SCR, SKT HD CAP, RoHS, M4 X 35	25
	-	1	1-1752371-2	PLATE, STRIP GUIDE	24
	-	2	22281-9	SPRING, COMPRESSION	22
	-	1	1803292-4	DRAG	20
	-	1	6-1901696-7	STRIP GUIDE, REAR	19
	-	1	4-1901695-9	STRIP GUIDE, FRONT	18
	-	1	7-240641-2	SPACER	16
	-	1	240644-5	PLATE, REAR SHEAR	11
	-	-	-	-	10
	-	1	7-690482-1	PLATE, FRONT SHEAR	9
	1	1	3-1803000-8	ANVIL, COMBINATION, END FEED	8
	1	-	1-2217206-3	BLADE, SLUG	7
	-	-	-	-	6
	-	1	2-240641-2	SPACER	5
	-	1	4-238011-5	BLOCK, CRIMPER SPACER	4
	1	1	4-1633962-7	CRIMPER, INSULATION F PREMIUM	3
	-	1	1-455888-2	SPACER, CRIMPER	2
	1	1	6-1673600-2	CRIMPER, WIRE	1
	-	77-22	PART NO	DESCRIPTION	ITEM NO

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DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		NAME		Oceon End Feed Appliator					
mm		0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		PRODUCT SPEC - APPLICATION SPEC -		SIZE		CAGE CODE	DRAWING NO	RESTRICTED TO	
		FINISH		WEIGHT		A 00779		C=2150393		-	
MATERIAL		-		-		Customer Accessible Production Drawing		SCALE 1:1		SHEET 3 of 4	REV B

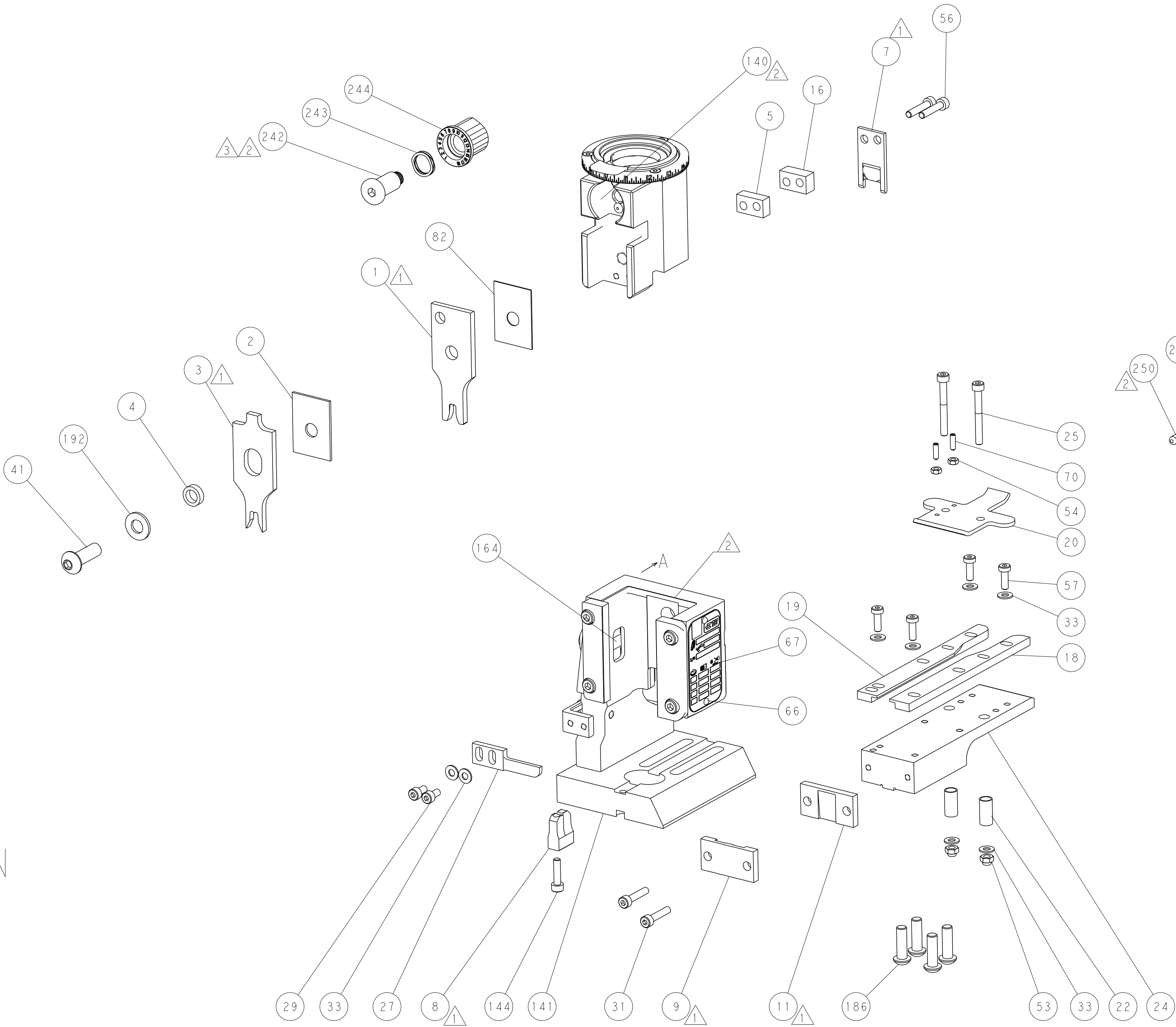
SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

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

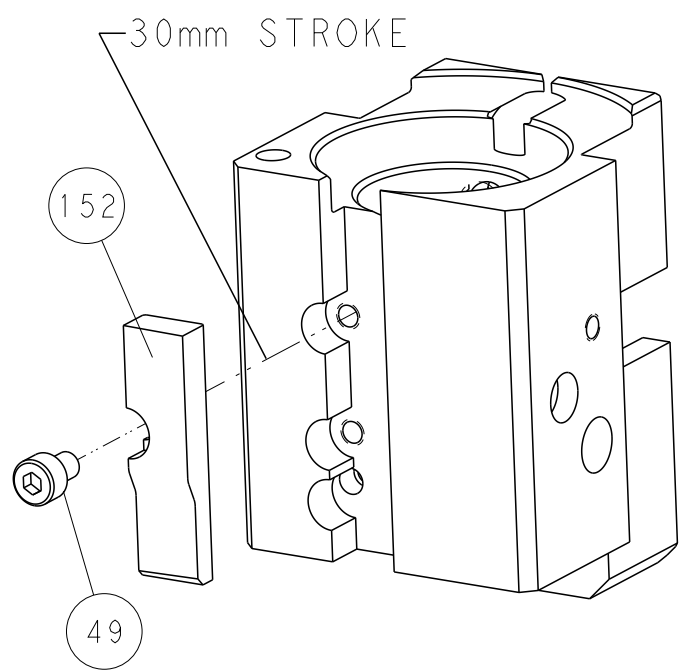


RAM SET-UP

FEED TYPE

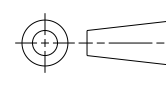


CAM POSITION



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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				CHK	31OCT2013						
				APVD	31OCT2013						
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		PRODUCT SPEC		NAME Ocean End Feed Applicator -					
mm		0 PLC ±.1		APPLICATION SPEC							
		1 PLC ±.1									
MATERIAL		FINISH		WEIGHT		SIZE		CAGE CODE	DRAWING NO	RESTRICTED TO	
-		-		-		A1		00779	C=2150393	-	
Customer Accessible Production Drawing						SCALE		SHEET		4 OF 4	REV B

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