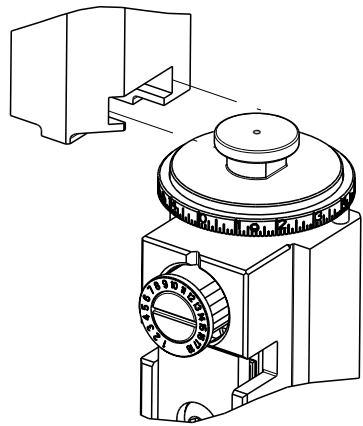


8		7	
THIS DRAWING IS UNPUBLISHED.		RELEASED FOR PUBLICATION	
20		20	
© COPYRIGHT 20 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.			
PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150430-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2150430-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150430-1	C	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2150430-2	C	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150430-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	3.05 mm [.120]	F
INSUL	-	-
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: SPLICE			
WIRE STRIP LENGTH 5.11-6.12 mm [.201-.241 IN]		INSULATION DIAMETER RANGE Ø -	
TERMINAL APPLICATION SPECIFICATION 114-2088		-	-
TERMINALS APPLIED		-	-
TERMINALS APPLIED			
TE TERMINAL 40868	TE TERMINAL 41397	TE TERMINAL 61492-1	TE TERMINAL 61492-3

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING
4700 CMA		1.96+/-0.05 [.077+/- .002]		4.6
2500 CMA		1.70+/-0.05 [.067+/- .002]		7.5



- 1 RECOMMENDED SPARE PARTS
- 2 REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- 3 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.
- 4 THE RECOMMENDED SET-UP FOR END FEED APPLICATORS IS POST-FEED WITH ITEM 2119653-1. THE APPLICATOR CAN BE CONFIGURED FOR PRE-FEED WITH ITEM 2119652-1 BUT MAY ENCOUNTER PROBLEMS WITH SOME APPLICATIONS. FEED ISSUES OR TERMINAL JAMMING MAY OCCUR IN THE PRE-FEED CONFIGURATION.
- 5 REFER TO TERMINAL CUSTOMER DRAWING FOR CRIMP HEIGHT FORMULA TO CALCULATE SPECIFIC CRIMP HEIGHTS.
- 6 POSITION ITEM 27 IN FRONT OF ITEM 1.
7. 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)

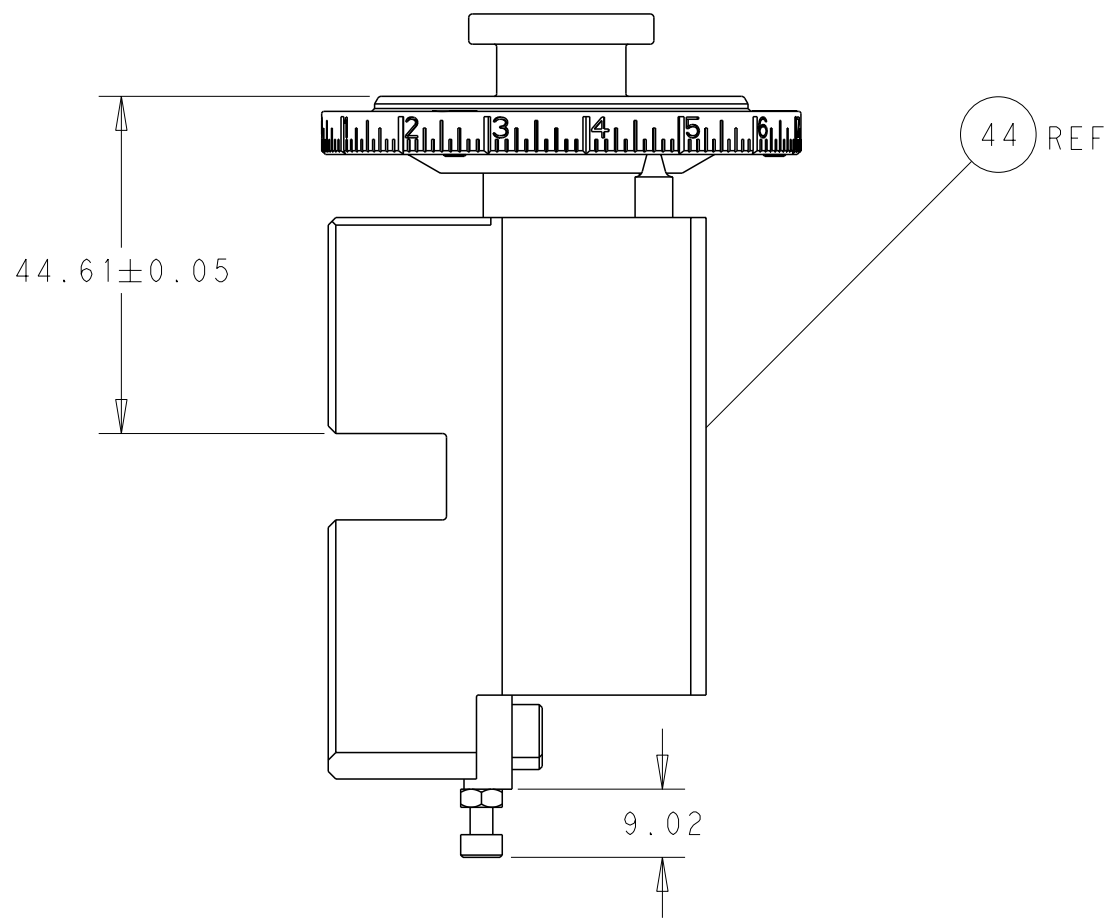
LOC	DIST	REVISONS				
A	66	P	LYR	DESCRIPTION	DATE	DWN
			A1	ECR-18-008220	30MAY2018	YY
			B	ECR-19-017880	19NOV2019	FJ
			B1	ECR-20-001142	23JAN2020	JAH
			C	ECO-20-006459	05MAY2020	MEH

-	1	1	1	1	1803078-2	SPACER, PRECISION	259
-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248
-	-	1	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	1	-	1	-	2844940-3	AIR FEED MODULE	238
-	1	1	1	1	1803163-1	FLOATING SHEAR HOLDER	206
-	2	2	2	2	1-2168083-1	SCR, SKT HD CAP, RoHS, M3 X 6	191
-	2	2	2	2	2-22280-0	SPRING, COMPRESSION	180
-	2	2	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	178
-	1	1	1	1	356885-1	STOP, SHEAR	177
-	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	2	2	2	2	1-18028-2	WASHER, FLAT, REG M4	119
-	1	1	1	1	455888-8	SPACER, CRIMPER	82
-	1	1	1	1	1803607-4	DOCUMENTATION PACKAGE	71
-	2	2	2	2	3-18032-3	SCR, SET, FLT PNT, M3 X 20.0	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	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	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	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	-	1-2063961-0	FEED FINGER	51
-	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	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
-	8	8	8	8	1-18028-2	WASHER, FLAT, REG M4	33
-	2	2	2	2	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	31
-	2	2	2	2	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	29
-	1	1	1	1	690455-1	STRIPPER, FRONT CASTING	27
-	2	2	2	2	1-2168083-6	SCR, SKT HD CAP, RoHS, M4 X 35	25
-	1	1	1	1	1803162-1	PLATE, STRIP GUIDE	24
-	2	2	2	2	22281-8	SPRING, COMPRESSION	22
-	1	1	1	1	1633168-1	ARM, STOCK DRAG	21
-	1	1	1	1	464452-2	DRAG, STOCK	20
-	2	2	2	2	1901259-5	GUIDE, LOWER STRIP	18
-	4	4	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17
-	1	1	1	1	1-2168083-3	SCR, SKT HD CAP, RoHS, M3 X 16	16
-	1	1	1	1	5018030-1	NUT, HEX, REG, RoHS, M3	15
-	-	-	-	-	-	-	11
-	-	-	-	-	-	-	10
-	-	-	-	-	-	-	9
1	2	2	1	1	5-690618-1	ANVIL, SPLICE TYPE	8
-	1	1	1	1	1633722-1	SHEAR BLADE	7
-	-	-	-	-	-	-	6
-	1	1	1	1	690753-6	SPACER, TONKER	5
-	-	-	-	-	-	-	4
-	-	-	-	-	-	-	3
-	-	-	-	-	-	-	2
1	2	2	1	1	459736-5	CRIMPER, WIRE	1
-77-	72-	71-	2-	1-	PART NO	DESCRIPTION	ITEM NO

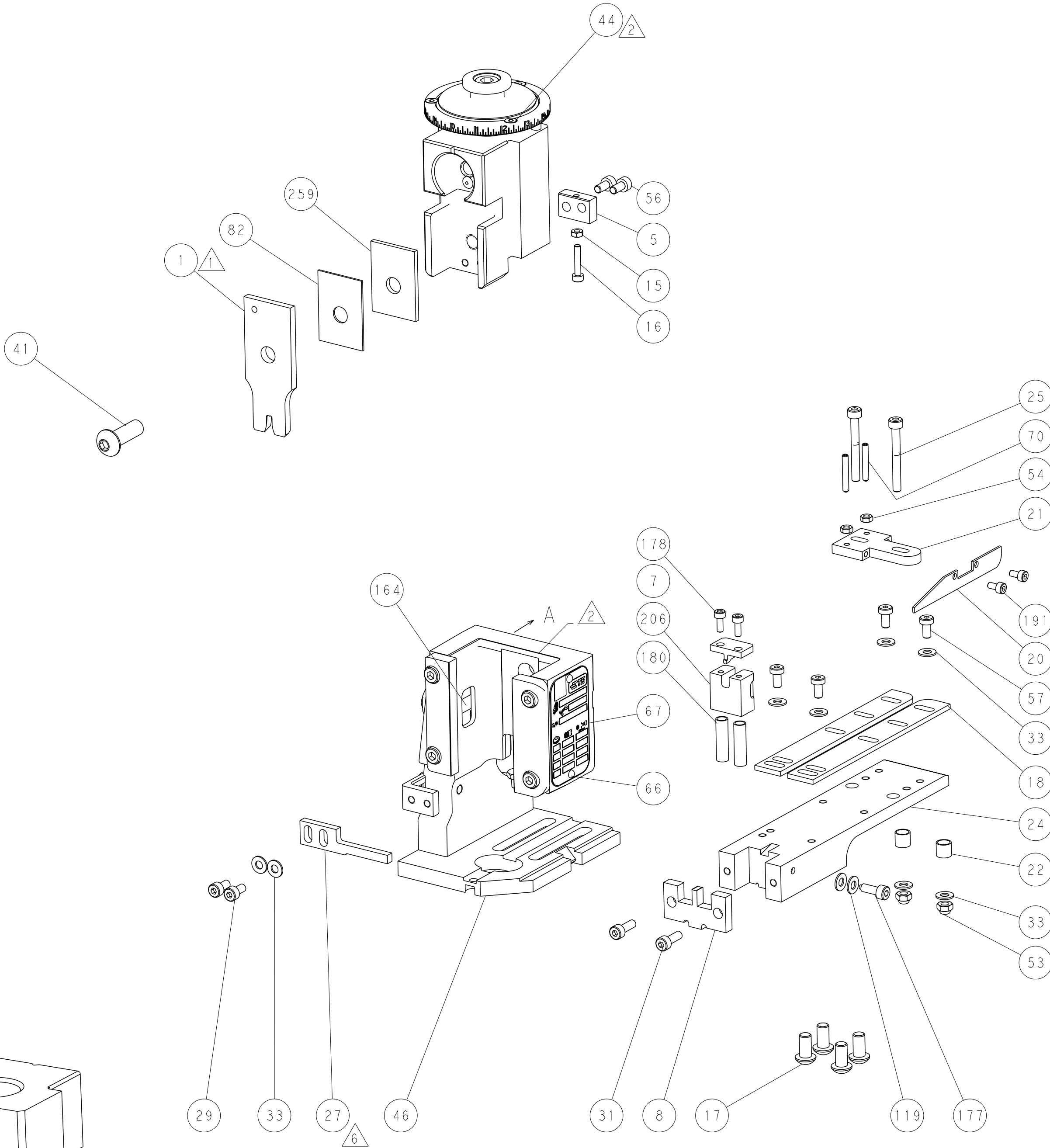
THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE AND TO BE CONTROLLED BY THE DRAWING ORGANIZATION. IT IS SUBJECT TO CHANGE AND TO BE CONTROLLED BY THE DRAWING ORGANIZATION. IT IS SUBJECT TO CHANGE AND TO BE CONTROLLED BY THE DRAWING ORGANIZATION.				OWN L. GROSS CHK T. ELBIN APVD D. STOUGH PRODUCT SPEC APPLICATION SPEC MATERIAL FINISH				DWN 19MAY2014 CHK 19MAY2014 APVD 19MAY2014 NAME SIZE CAGE CODE DRAWING NO RESTRICTED TO SCALE SHEET 1 OF 4 REV C			
DIMENSIONS: mm				TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC 1 PLC 2 PLC 3 PLC 4 PLC ANGLES FINISH				TE Connectivity Harrisburg, PA 17105-3608 Ocean End Feed Applicator 00779 ©=2150430			
Customer Accessible Production Drawing				Customer Accessible Production Drawing				Customer Accessible Production Drawing			

SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

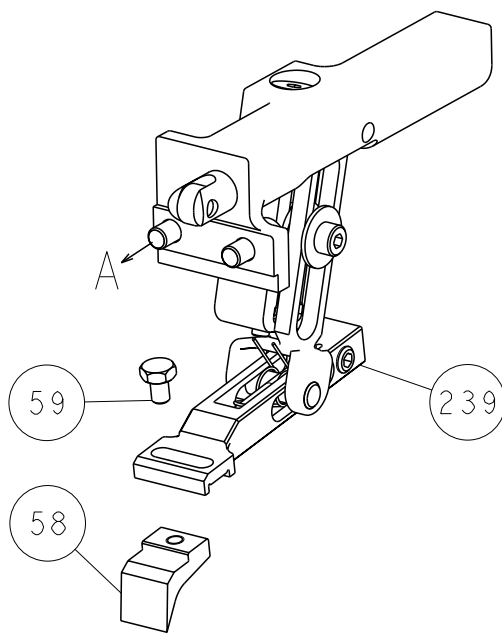
LOC		DIST		REVISIONS			
A		66		REV	DESCRIPTION	DATE	OWN
				-	SEE SHEET 1	-	-



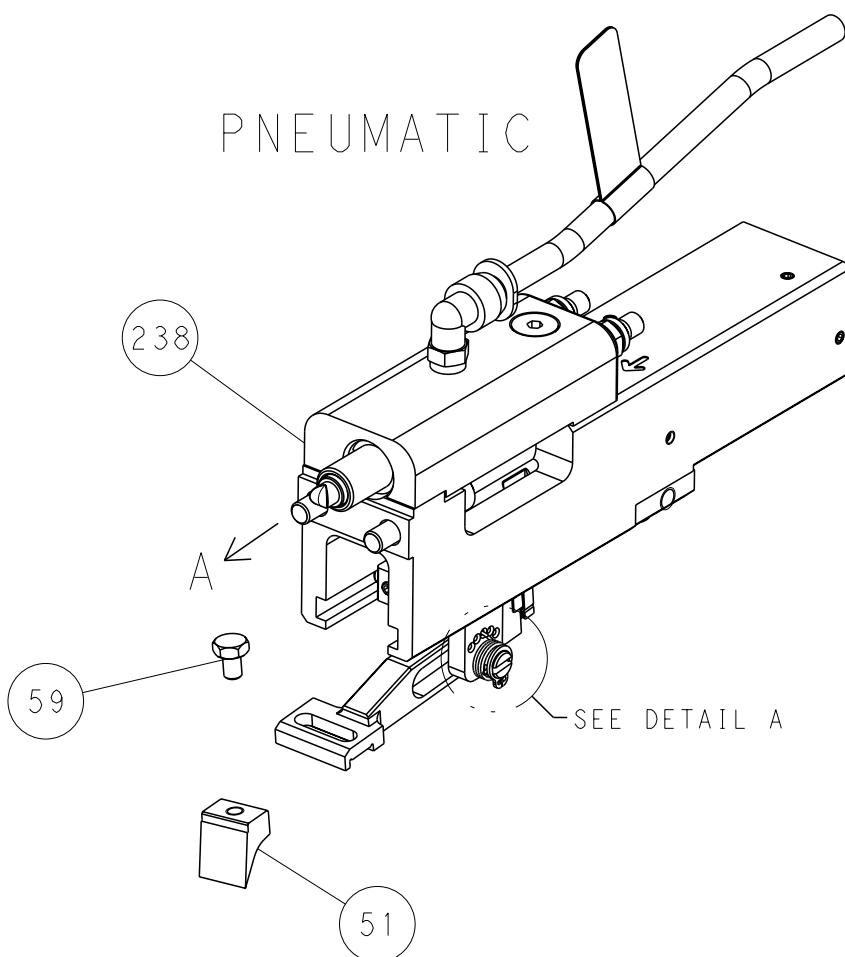
SHEAR TONKER SET UP



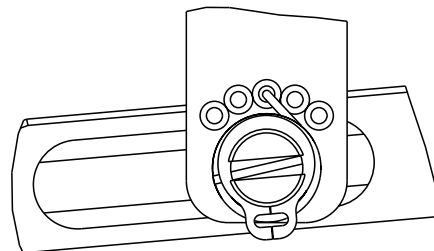
FEED TYPE
MECHANICAL



PNEUMATIC

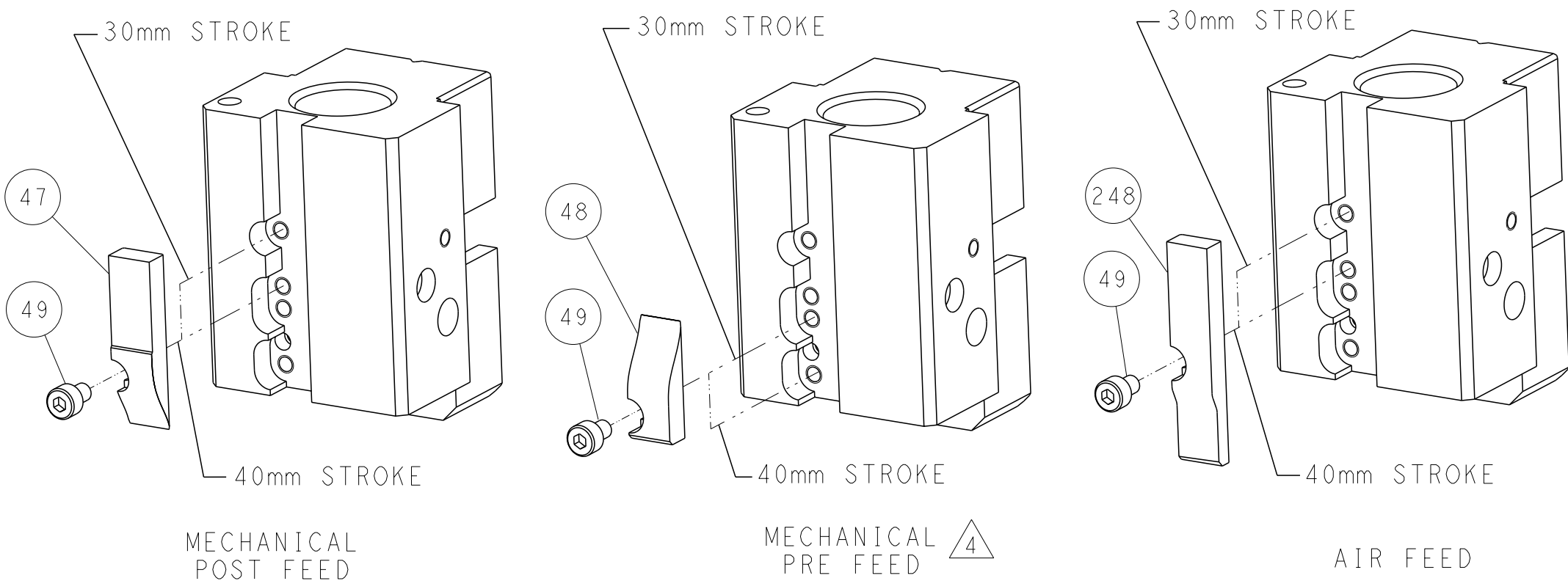


FEED SPRING
SETTING POSITION



DETAIL A

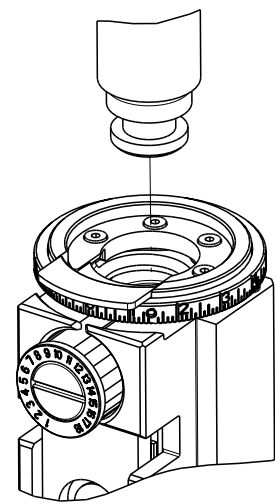
CAM POSITIONS



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 CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE WITHOUT NOTICE AND WITHOUT NOTICE. ANY REVISIONS SHALL BE CONTACTED FOR THE LATEST REVISION.				OWN	19MAY2014	TE Connectivity Harrisburg, PA 17105-3608	
				CHK	19MAY2014		
				APVD	19MAY2014	NAME	
				D. STOUGH		Ocean End Feed Applicator	
				PRODUCT SPEC		SIZE	
				APPLICATION SPEC		CAGE CODE	
				MATERIAL		DRAWING NO	
				FINISH		00779	
				WEIGHT		©=2150430	
				Customer Accessible Production Drawing		SCALE	
						1:1	
						SHEET	
						2	
						OF	
						4	
						REV	
						C	

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	3.05 mm [.120]	F
INSUL	-	-
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: SPLICE			
WIRE STRIP LENGTH 5.11-6.12 mm [.201-.241 IN]		INSULATION DIAMETER RANGE Ø -	
TERMINAL APPLICATION SPECIFICATION 		114-2088 - -	
TERMINALS APPLIED			
TE TERMINAL 40868	TE TERMINAL 41397	TE TERMINAL 61492-1	TE TERMINAL 61492-3

WIRE SIZE			CRIMP HEIGHT mm [INCH]			CRIMP HEIGHT REFERENCE SETTING
4700 CMA			1.96+/-0.05 [0.077+/-0.002]	5		4.6
2500 CMA			1.70+/-0.05 [0.067+/-0.002]		3	7.5



1. RECOMMENDED SPARE PARTS
2. REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
3. 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.
4. THE RECOMMENDED SET-UP FOR END FEED APPLICATORS IS POST-FEED WITH ITEM 2119653-1. THE APPLICATOR CAN BE CONFIGURED FOR PRE-FEED WITH ITEM 2119652-1 BUT MAY ENCOUNTER PROBLEMS WITH SOME APPLICATIONS. FEED ISSUES OR TERMINAL JAMMING MAY OCCUR IN THE PRE-FEED CONFIGURATION.
5. REFER TO TERMINAL CUSTOMER DRAWING FOR CRIMP HEIGHT FORMULA TO CALCULATE SPECIFIC CRIMP HEIGHTS.
6. POSITION ITEM 27 IN FRONT OF ITEM 1.
7. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.

*WARNING

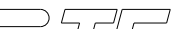
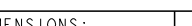
ON INSTALLATION, SET WIRE DISC TO CRIMP HEIGHT REFERENCE SETTING FOR LARGEST WIRE SIZE. CRIMP HEIGHT REFERENCE SETTINGS GREATER THAN THE VALUE SHOWN MAY CAUSE DAMAGE TO THE CRIMP TOOLING, REFER TO THE INSTRUCTION SHEET FOR PROPER SETUP AND ADJUSTMENTS.

PACIFIC VERSION

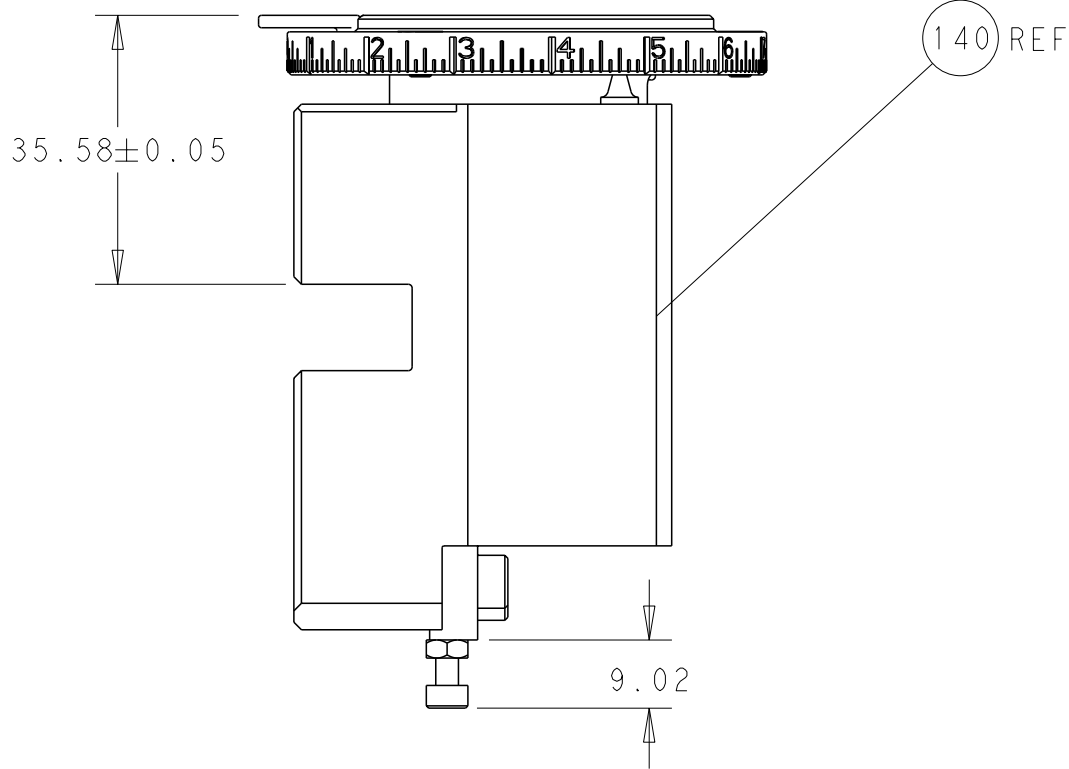
Shown on sheets 3 of 4 & 4 of 4
(Atlantic version shown on sheets 1 of 4 & 2 of 4)

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

-	1	1	1803078-2	SPACER, PRECISION	259
-	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	1	-	2844940-3	AIR FEED MODULE	238
-	1	1	1803163-1	FLOATING SHEAR HOLDER	206
-	2	2	1-2168083-1	SCR, SKT HD CAP, RoHS, M3 X 6	191
-	4	4	2079383-9	SCR, BHSC, RoHS (M6 X 20)	186
-	2	2	2-22280-0	SPRING, COMPRESSION	180
-	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	178
-	1	1	356885-1	STOP, SHEAR	177
-	REFREF		994970-2	COUNTER, MAGNETIC	166
-	1	-	2119641-2	FEED CAM, AIR FEED	152
-	-	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
-	2	2	1-18028-2	WASHER, FLAT, REG M4	119
-	1	1	455888-8	SPACER, CRIMPER	82
-	1	1	1803607-4	DOCUMENTATION PACKAGE	71
-	2	2	3-18032-3	SCR, SET, FLT PNT, M3 X 20.0	70
-	1	1	2119740-1	TAG, IDENTIFICATION	67
-	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	1	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	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	56
-	2	2	5018030-1	NUT, HEX, REG, RoHS, M3	54
-	2	2	986965-8	NUT, LOCK, HEX, TORQUE (M4)	53
-	1	-	1-2063961-0	FEED FINGER	51
-	1	2	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	-	1	2119652-1	FEED CAM, PRE FEED	48
-	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
-	8	8	1-18028-2	WASHER, FLAT, REG M4	33
-	2	2	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	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	1-2168083-6	SCR, SKT HD CAP, RoHS, M4 X 35	25
-	1	1	1803162-1	PLATE, STRIP GUIDE	24
-	2	2	22281-8	SPRING, COMPRESSION	22
-	1	1	1633168-1	ARM, STOCK DRAG	21
-	1	1	464452-2	DRAG, STOCK	20
-	2	2	1901259-5	GUIDE, LOWER STRIP	18
-	1	1	1-2168083-3	SCR, SKT HD CAP, RoHS, M3 X 16	16
-	1	1	5018030-1	NUT, HEX, REG, RoHS, M3	15
-	-	-	-	-	11
-	-	-	-	-	10
-	-	-	-	-	9
1	1	1	5-690618-1	ANVIL, SPLICE TYPE	8
-	1	1	1633722-1	SHEAR BLADE	7
-	-	-	-	-	6
-	1	1	690753-6	SPACER, TONKER	5
-	-	-	-	-	4
-	-	-	-	-	3
-	-	-	-	-	2
1	1	1	459736-5	CRIMPER, WIRE	1
-77-22-21			PART NO	DESCRIPTION	ITEM NO

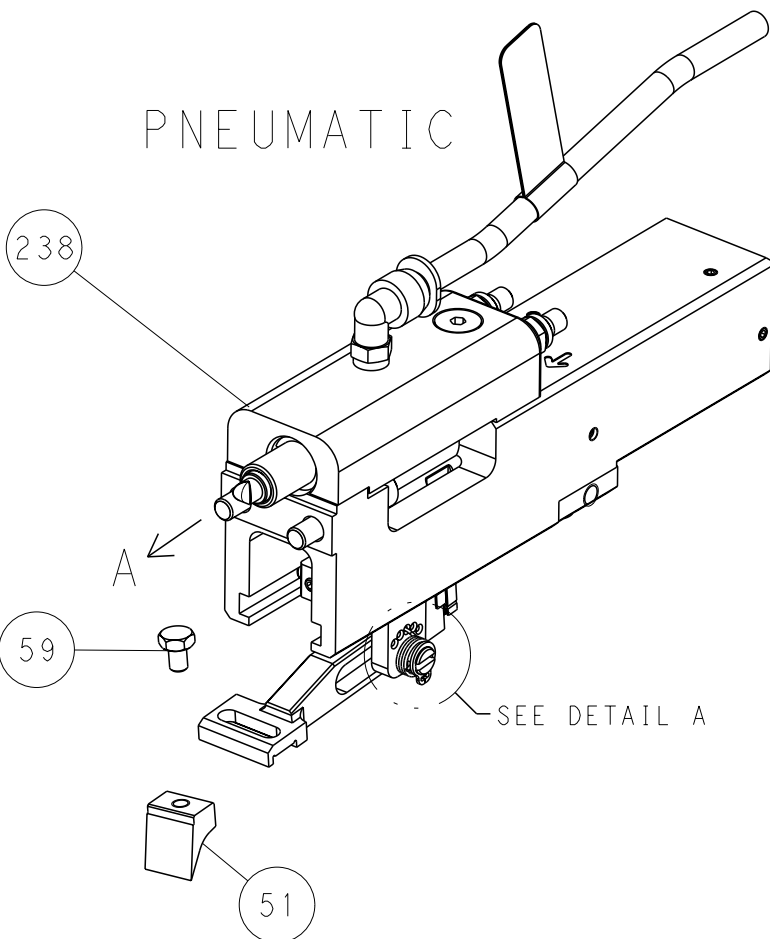
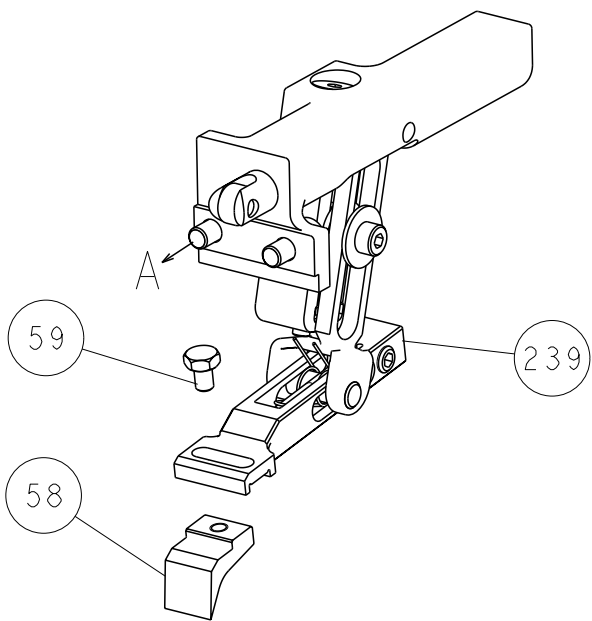
(THIS DRAWING IS A CONTROL DRAWING FOR THE ELBLEN CORPORATION SHOULD BE CONTACTED FOR THE LATEST REVISION INFORMATION.)										DWG. GROSS 19MAY2014		 TE Connectivity Harrisburg, PA 17105-3608											
										CHK. ELBIN 19MAY2014													
DIMENSIONS:										APP'D D. STOUGH 19MAY2014		NAME		Ocean End Feed Applicator									
mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:								PRODUCT SPEC													
		0 PLC ± .000		1 PLC ± .000		2 PLC ± .000		3 PLC ± .000		4 PLC ± .000		APPLICATION SPEC											
		ANGLES ± .000																					
		FINISH																					
MATERIAL										WEIGHT		SIZE		CAGE CODE		DRAWING NO.		RESTRICTED TO					
-										-		A 00779 C=2150430						-					
Customer Accessible Production Drawing																		SCALE 1:1		SHEET 3 OF 4		REV C	

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

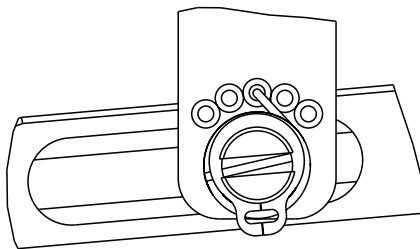


SHEAR TONKER SET UP

FEED TYPE
MECHANICAL

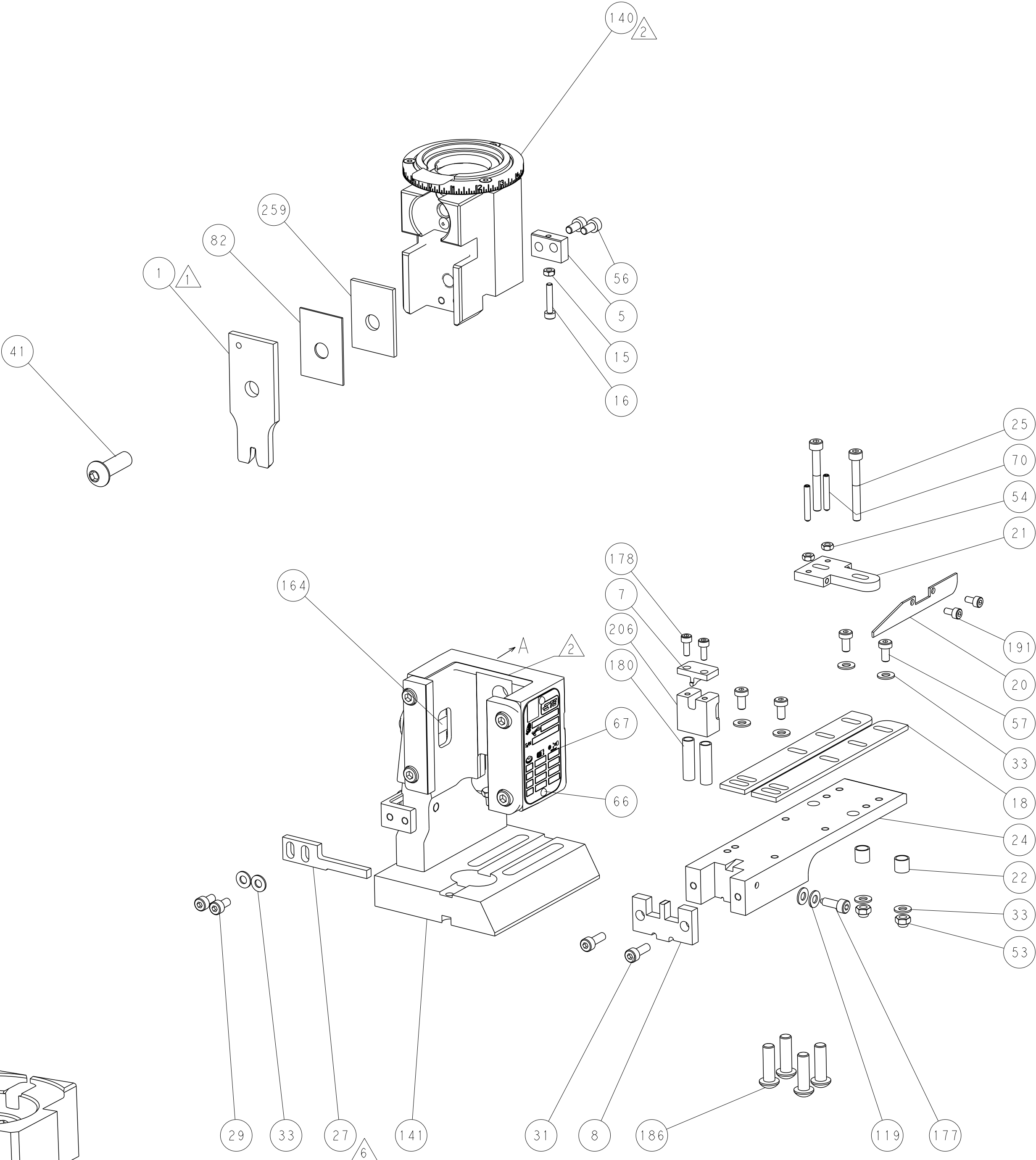
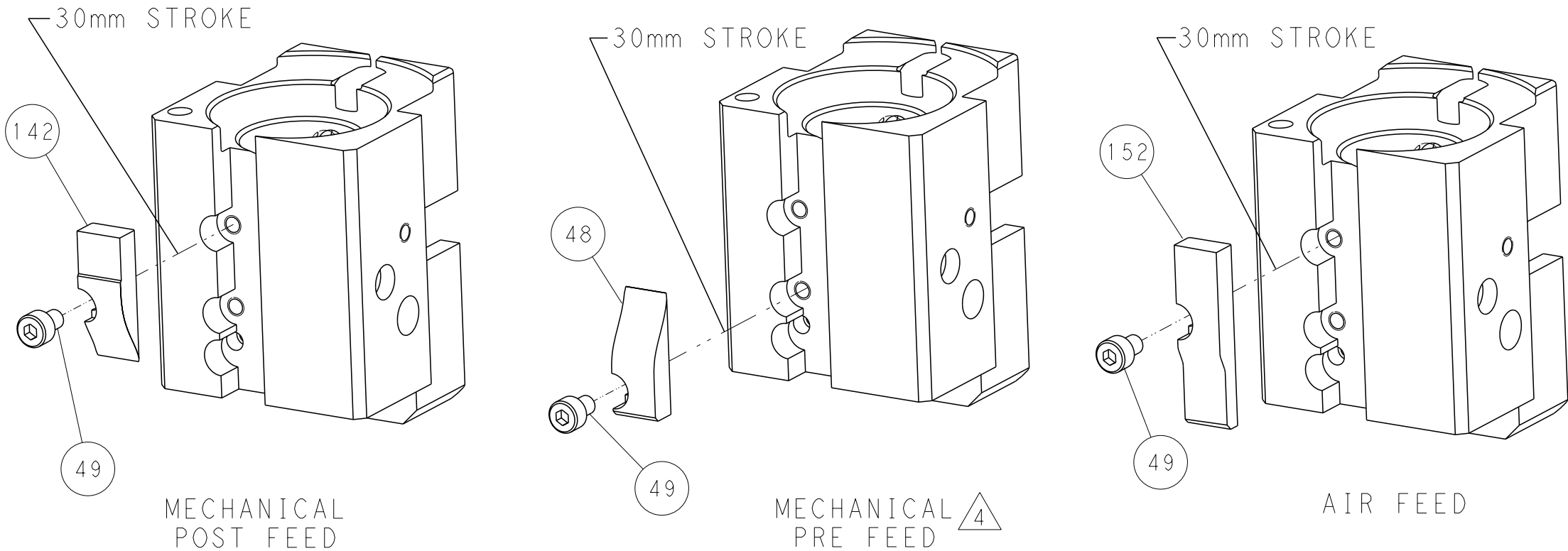


FEED SPRING
SETTING POSITION

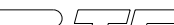


DETAIL A

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 A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION IT IS SUBJECT TO CHANGE AND TO THE CONTROL AND ENGINEERING ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST REVISION				DWN	L. GROSS	19MAY2014	 TE Connectivity Harrisburg, PA 17105-3608			
				CHK	T. ELBIN	19MAY2014				
				APVD	D. STOUGH	19MAY2014	NAME			
				PRODUCT SPEC			Ocean End Feed Applicator			
				APPLICATION SPEC						
DIMENSIONS:				TOLERANCES UNLESS OTHERWISE SPECIFIED:			SIZE			
mm				0 PLC ±			CAGE CODE			
				1 PLC ±			DRAWING NO			
				2 PLC ±			A1 00779 ©=2150430			
				3 PLC ±						
				4 PLC ±			Customer Accessible Production Drawing			
				ANGLES						
FINISH				-			SCALE			
-				-			1:1			
							SHEET			
							4			
							OF			
							4			
							REV			
							C			

Mouser Electronics

Authorized Distributor

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

[TE Connectivity:](#)

[2150430-1](#)