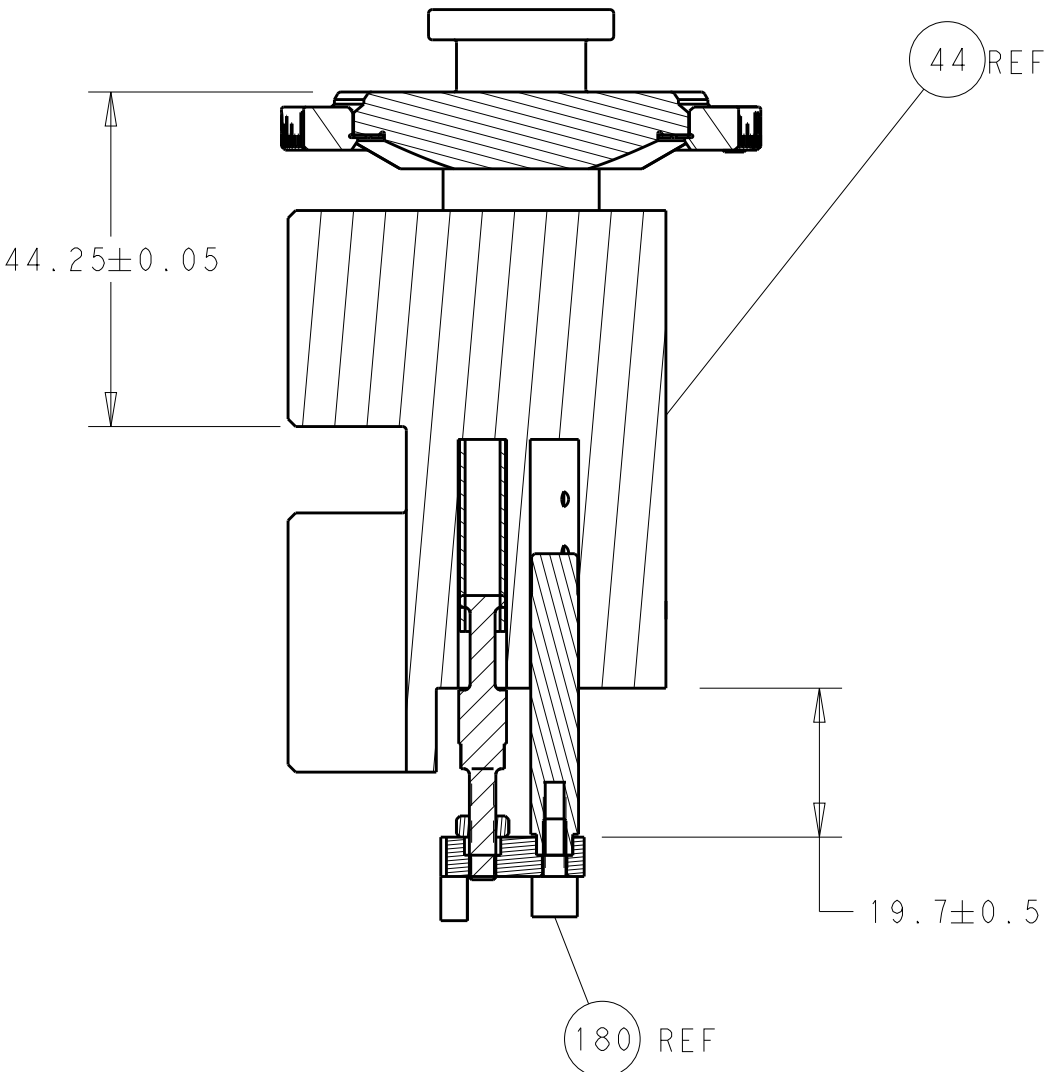


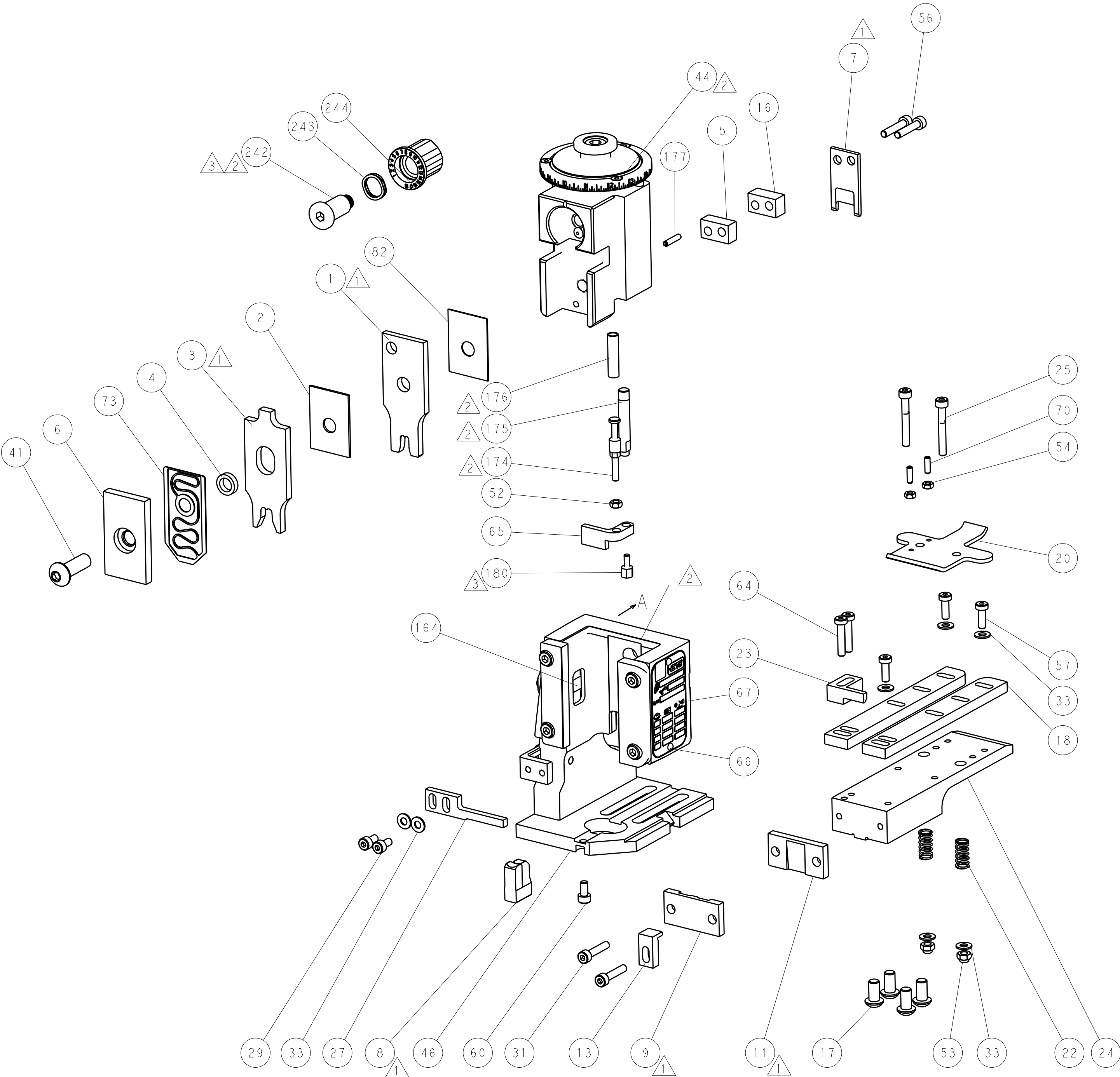
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	-	1	1	2119082-3	CAM, SNAIL, INSULATION ADJUSTMENT	244
	-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
3	-	1	1	2119083-1	RETAINER, INSULATION DIAL	242
	-	1	1	2844940-4	AIR FEED MODULE	238
3	-	1	1	1752354-6	STANDOFF,HOLD-DOWN	180
	-	1	1	6-993111-6	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
	-	REF	REF	994970-2	COUNTER, MAGNETIC	164
	-	1	1	455888-5	SPACER, CRIMPER	82
	-	1	1	1-2119791-4	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	2119740-1	TAG.IDENTIFICATION	67
	-	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
	-	1	1	1901681-1	HOLDDOWN, TERMINAL	65
	-	2	2	2168400-5	SHCS, LOW HEAD, RoHS, M4 X 20	64
	-	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
	-	3	3	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	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52
	-	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
	-	7	7	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	690455-1	STRIPPER, FRONT CASTING	27
	-	2	2	1-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 30	25
	-	1	1	1752371-5	PLATE, STRIP GUIDE	24
	-	1	1	240825-3	PLATE, STRIP HOLD DOWN	23
	-	2	2	2-22281-3	SPRING, COMPRESSION	22
	-	1	1	1803292-4	DRAG	20
	-	2	2	1901259-9	GUIDE, LOWER STRIP	18
	-	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17
	-	1	1	5-240641-1	SPACER	16
	-	1	1	1752360-1	SPACER,HOLD-DOWN	13
1	-	1	1	240644-9	PLATE, REAR SHEAR	11
	-	-	-	-	-	10
1	-	1	1	6-690482-3	PLATE, FRONT SHEAR	9
1	1	2	1	5-1803001-7	ANVIL, COMBINATION, END FEED	8
1	-	1	1	1-2217206-0	BLADE, SLUG	7
	-	1	1	1803203-1	BLOCK, FRONT DEPRESSOR	6
	-	1	1	2-240641-7	SPACER	5
	-	1	1	3-238011-8	BLOCK, CRIMPER SPACER	4
1	1	2	1	4-1803017-7	CRIMPER, INSULATION F	3
	-	1	1	1-455888-0	SPACER, CRIMPER	2
1	1	2	1	7-1633738-9	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)

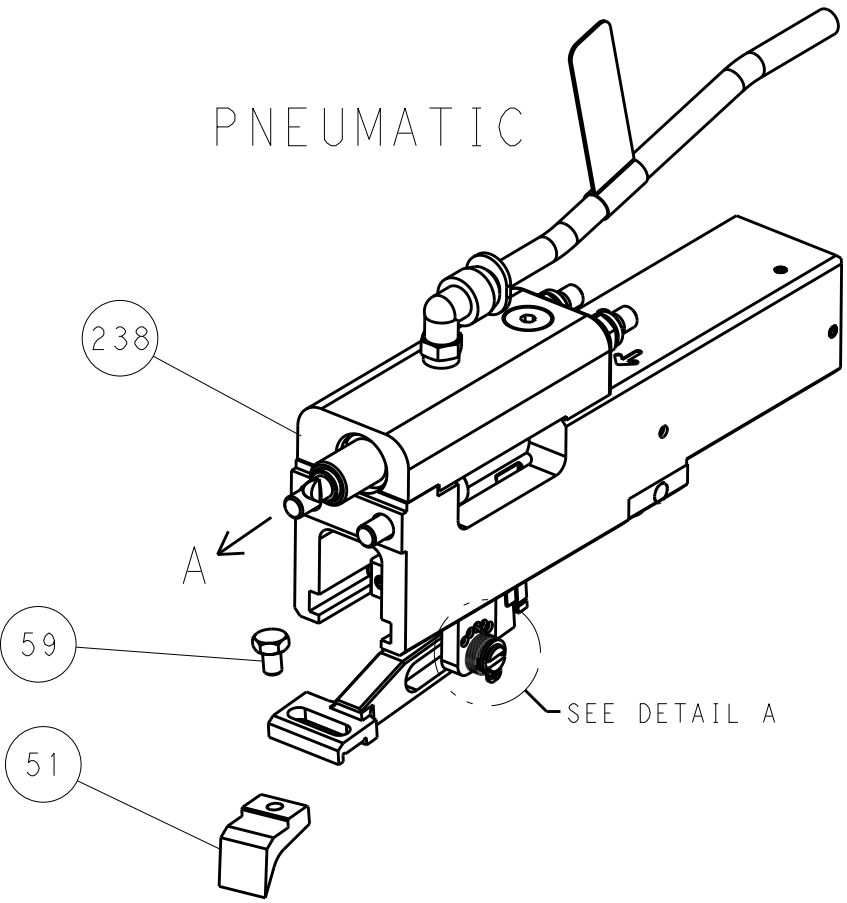
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		P	LTR	DESCRIPTION	DATE	DWN	APVD
A	66	-	-	SEE SHEET 1	-	-	-



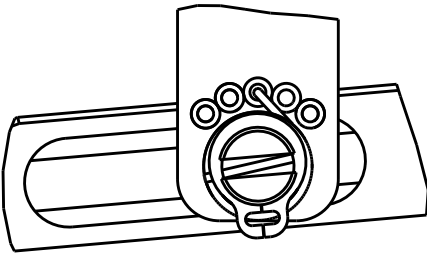
RAM AND HOLDDOWN SET-UP



FEED TYPE

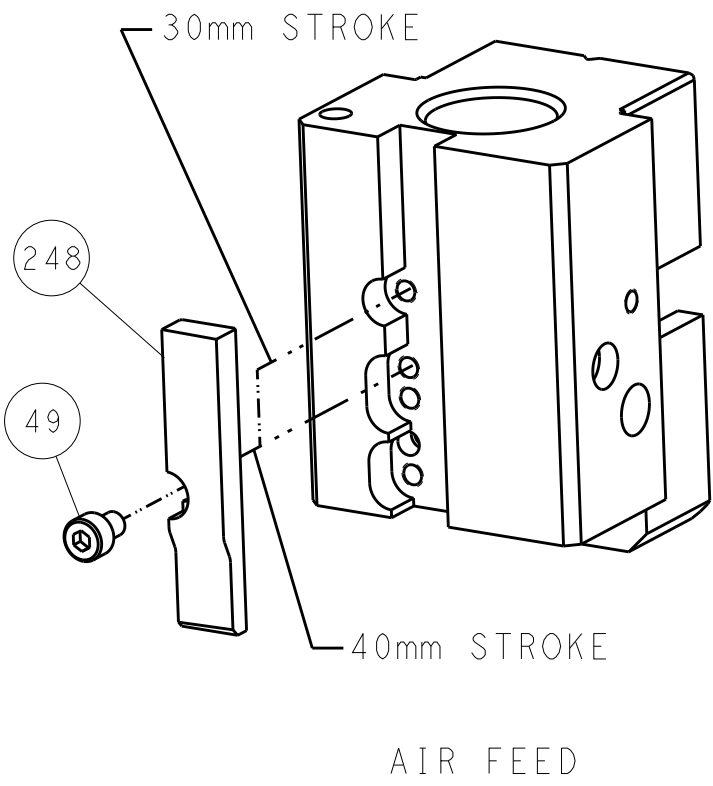


FEED SPRING SETTING POSITION

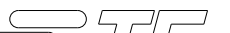


DETAIL A

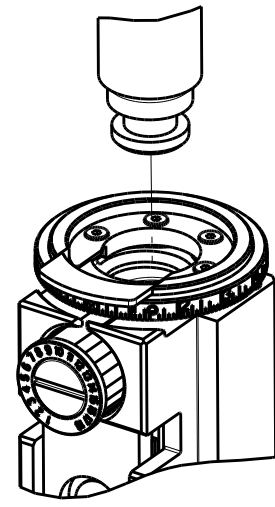
CAM POSITION



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

100% DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE AND WITHOUT NOTICE. ANY CHANGES TO THIS DRAWING SHOULD BE CONTACTED FOR THE LATEST REVISION.		DWN R. STAKEM 31JULY2014	 TE Connectivity Harrisburg, PA 17105-3608			
		CHK G. BAILEY 31JULY2014			APVD T. ELBIN 31JULY2014	
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.005 1 PLC ±.005 2 PLC ±.005 3 PLC ±.005 4 PLC ±.005 ANGLES ±.005 FINISH				
		PRODUCT SPEC				
MATERIAL -		APPLICATION SPEC				
		WEIGHT -				
Customer Accessible Production Drawing		SIZE A			CASE CODE 00779	DRAWING NO C=2150471
		SCALE 1:1		SHEET 2	OF 4	REV C

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150471-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150471-7	B	CRIMP TOOLING KIT	-



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	5.46 mm [.215]	F
INSUL	7.62 mm [.300]	F
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: TERMINAL			
WIRE STRIP LENGTH 6.00-6.80 mm [.236-.268 IN]		INSULATION DIAMETER RANGE Ø7.00-8.20 mm [.276-.323 IN]	
TERMINAL APPLICATION SPECIFICATION	CUSTOMER DRAWING	1544453	-
			-
TERMINALS APPLIED 			
TE TERMINAL 1544453-1	TE TERMINAL	TE TERMINAL	TE TERMINAL

WIRE SIZE			CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING
10.00mm ²			3.58+/-0.05 [.141+/- .002]		5.6
7.00mm ²			3.20+/-0.05 [.126+/- .002]		9.6



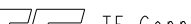
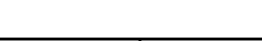
- ① RECOMMENDED SPARE PARTS
- ② REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- ③ APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 180.
APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242.
- ④ CRIMP HEIGHT REFERENCE SETTING WAS THE SETTING USED WHEN THE APPLICATOR WAS QUALIFIED AT THE FACTORY. ADJUSTMENT MAY BE NECESSARY WHEN RUNNING APPLICATOR IN THE FIELD.
5. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- ⑥ TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.

*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.

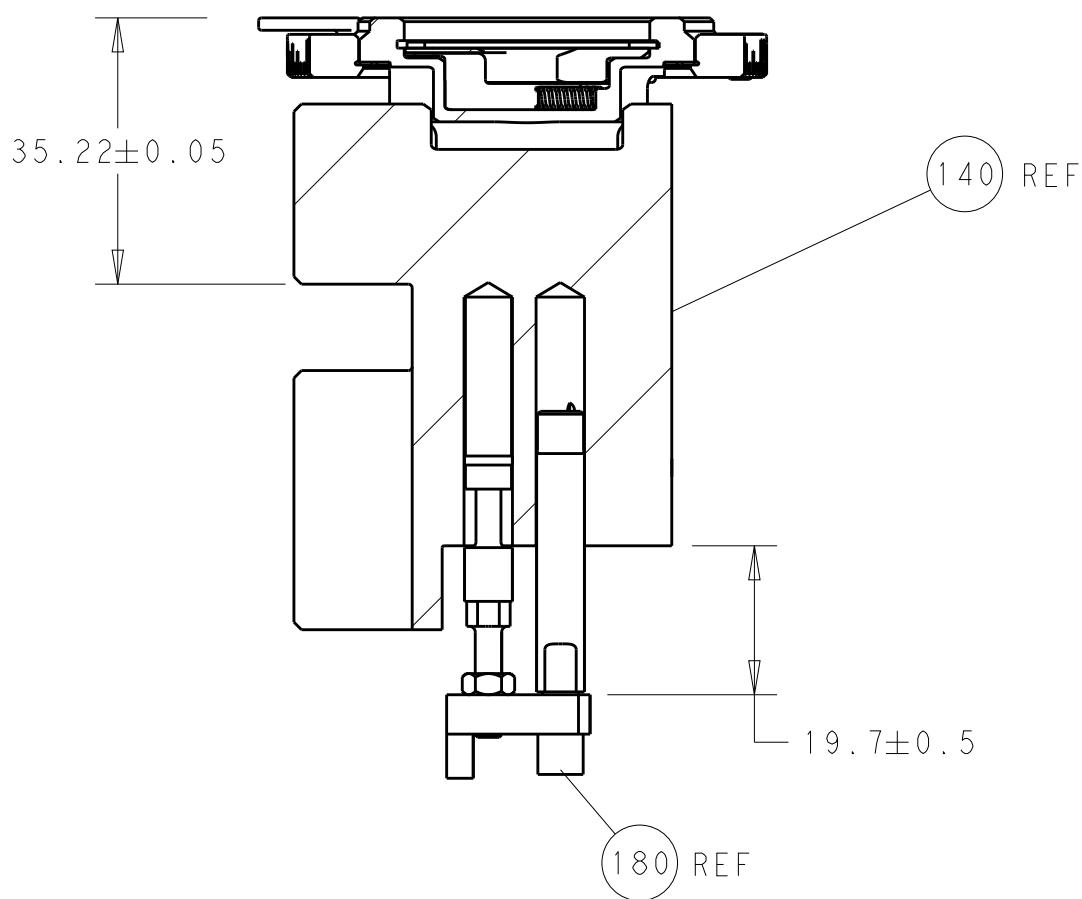
PACIFIC VERSION
Shown on sheets 3 of 4 & 4 of 4
(Atlantic version shown on sheets 1 of 4 & 2 of 4)

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

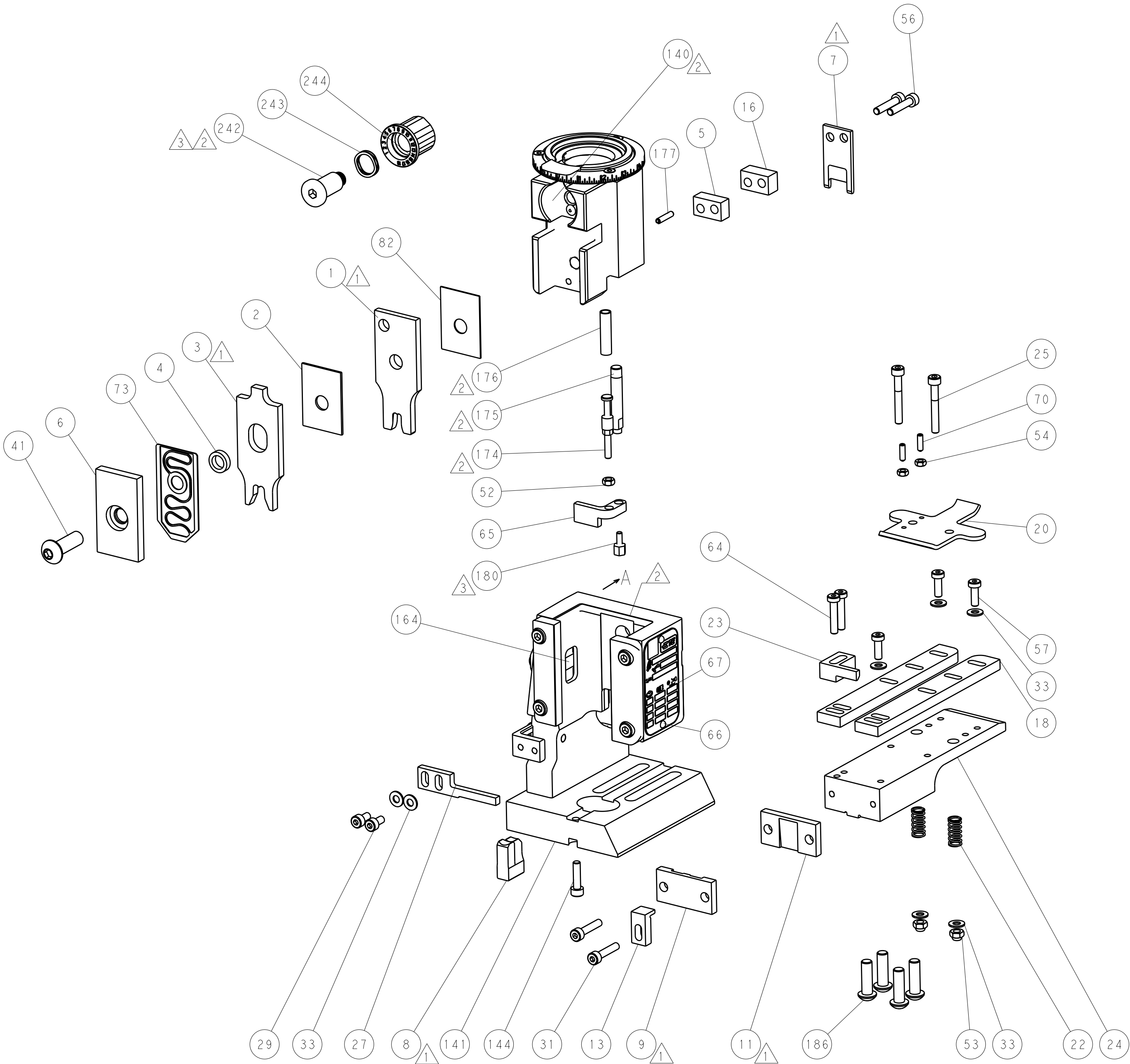
	-	1	2119082-3	CAM, SNAIL, INSULATION ADJUSTMENT	244
	-	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
△	-	1	2119083-1	RETAINER, INSULATION DIAL	242
	-	1	2844940-4	AIR FEED MODULE	238
	-	4	2079383-9	SCR, BHSC, RoHS (M6 X 20)	186
△	-	1	1752354-6	STANDOFF,HOLD-DOWN	180
	-	1	6-993111-6	PIN, SLOTTED SPRING 3.0 X 14.0	177
	-	1	8-22280-7	SPRING, COMPRESSION	176
	-	1	1752353-2	GUIDE PIN,HOLDDOWN	175
	-	1	1901680-2	GUIDE PIN,HOLDDOWN	174
	-	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	455888-5	SPACER, CRIMPER	82
	-	1	1-2119791-4	DEPRESSOR, WIRE	73
	-	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	1901681-1	HOLDDOWN, TERMINAL	65
	-	2	2168400-5	SHCS, LOW HEAD, RoHS, M4 X 20	64
	-	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
	-	3	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	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52
	-	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
	-	7	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	690455-1	STRIPPER, FRONT CASTING	27
	-	2	1-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 30	25
	-	1	1752371-5	PLATE, STRIP GUIDE	24
	-	1	240825-3	PLATE, STRIP HOLD DOWN	23
	-	2	2-22281-3	SPRING, COMPRESSION	22
	-	1	1803292-4	DRAG	20
	-	2	1901259-9	GUIDE, LOWER STRIP	18
	-	1	5-240641-1	SPACER	16
	-	1	1752360-1	SPACER,HOLD-DOWN	13
△	-	1	240644-9	PLATE, REAR SHEAR	11
	-	-	-	-	10
△	-	1	6-690482-3	PLATE, FRONT SHEAR	9
△	1	1	5-1803001-7	ANVIL, COMBINATION, END FEED	8
△	-	1	1-2217206-0	BLADE, SLUG	7
	-	1	1803203-1	BLOCK, FRONT DEPRESSOR	6
	-	1	2-240641-7	SPACER	5
	-	1	3-238011-8	BLOCK, CRIMPER SPACER	4
△	1	1	4-1803017-7	CRIMPER, INSULATION F	3
	-	1	1-455888-0	SPACER, CRIMPER	2
△	1	1	7-1633738-9	CRIMPER, WIRE	1
	-77-22		PART NO	DESCRIPTION	ITEM NO

(THIS DRAWING IS A COMPUTER GENERATED FILE AND THEREFORE NO DIMENSIONAL CHANGES SHOULD BE CONTACTED TO THE USER OR SUPPLIER FOR ANY REASON)				DWN G. STAKEM 31 JULY 2014		 TE Connectivity Harrisburg, PA 17105-3608			
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		CHK G. BAILEY 31 JULY 2014		NAME Ocean End Feed Applicator			
		FINISH		APPR T. FLIN 31 JULY 2014		PRODUCT SPEC APPLICATION SPEC		SIZE CAGE CODE DRAWING NO. A 00779 C=2150471	
MATERIAL -		WEIGHT -		Customer Accessible Production Drawing		SCALE 1:1 SHEET 3 OF 4 REV C		RESTRICTED TO -	

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

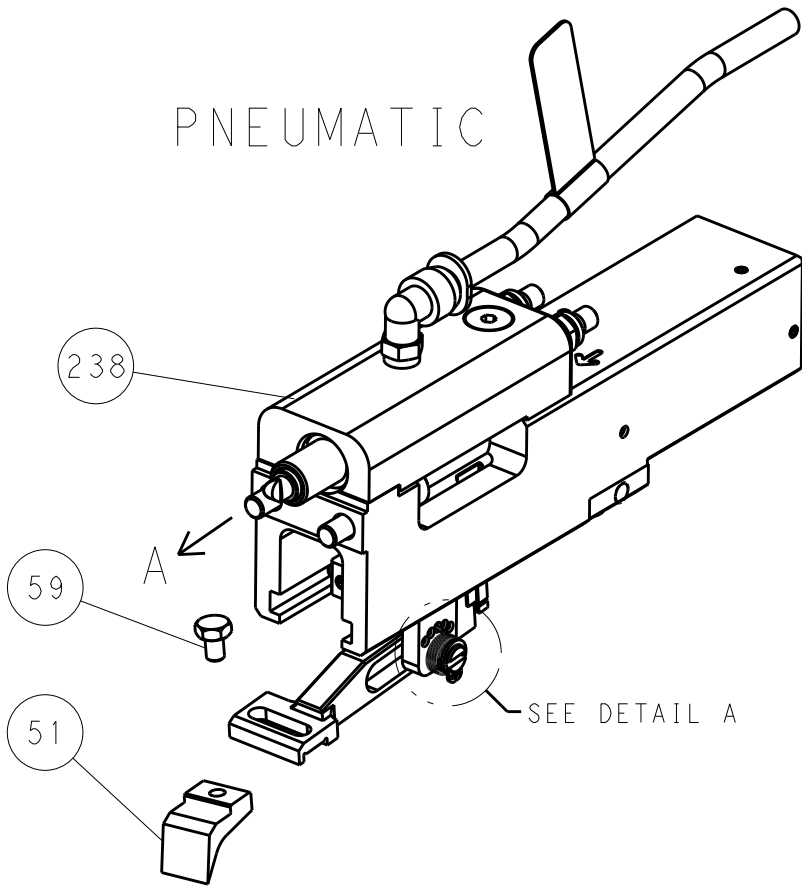


RAM AND HOLDDOWN SET-UP

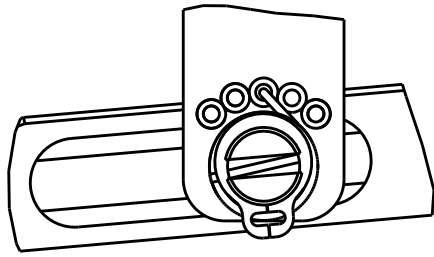


FEED TYPE

PNEUMATIC

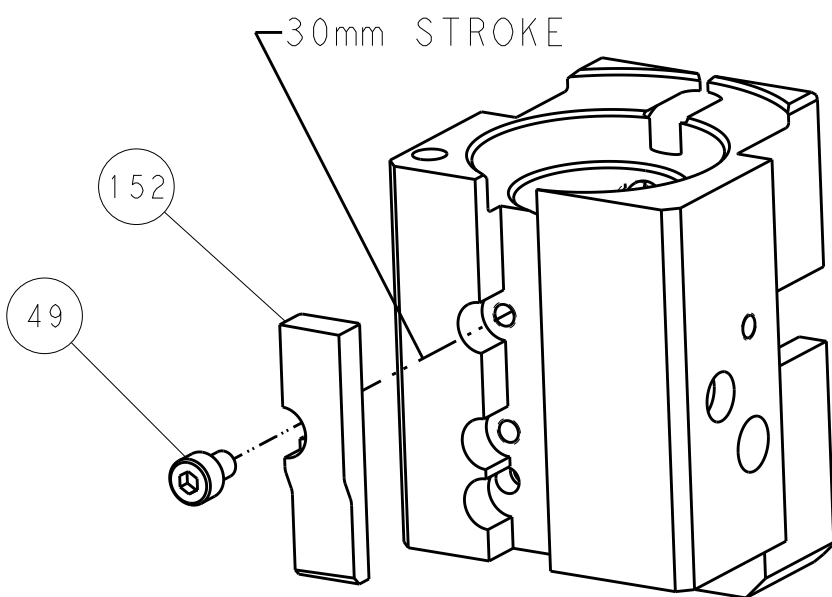


FEED SPRING
SETTING POSITION



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)

1. THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. ANY CHANGES TO THIS DRAWING SHOULD BE CONTACTED FOR THE LATEST REVISION.		DWN R. STANEM 31JULY2014	TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm		CHK G. BAILEY 31JULY2014	NAME Ocean End Feed Applicator	
TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH		APVD T. ELBIN 31JULY2014	SIZE A1	
MATERIAL		PRODUCT SPEC	CAGE CODE 00779	
		APPLICATION SPEC	DRAWING NO C=2150471	
		WEIGHT	RESTRICTED TO	
		Customer Accessible Production Drawing	SCALE 1:1	
			SHEET 4 OF 4	
			REV C	

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