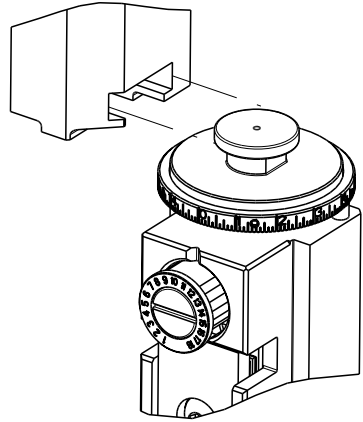
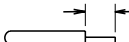


8		7	
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20		20	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150524-2	D	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150524-2	D	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150524-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	5.33 mm [.210]	F
INSUL	7.62 mm [.300]	Ø
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: RING TERMINAL			
WIRE STRIP LENGTH 4.39-5.16 mm [.173-.203 IN]		 INSULATION DIAMETER RANGE Ø3.81-5.59 mm [.150-.220 IN]	
TERMINAL APPLICATION SPECIFICATION	114-2084	-	-
			
TERMINALS APPLIED		5	6
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
61289-1	42947-2	42947-4	
42946-2	42947-3	640012-2	

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING
8 AWG		4.04+/-0.05 [.159+/- .002]		2.3
10 AWG		3.53+/-0.05 [.139+/- .002]		8.4
12 AWG		3.23+/-0.05 [.127+/- .002]		11.9



- 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 ITEMS 180.
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 LUBRICANT IS RECOMMENDED.
- TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
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.

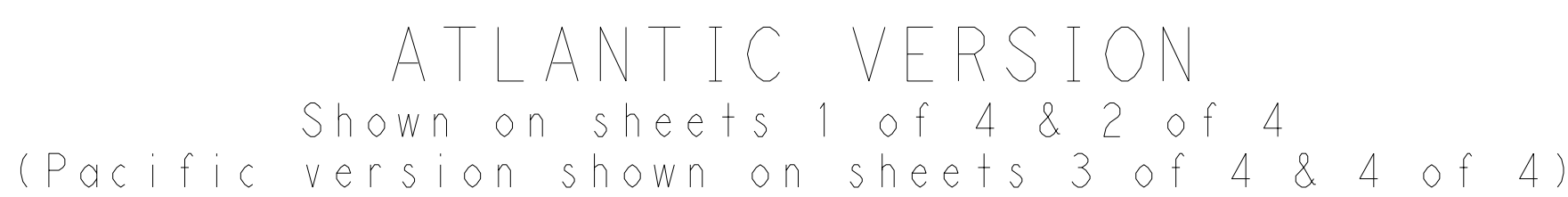
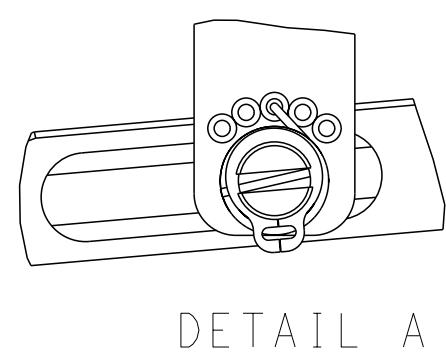
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

2		1					
LOC	DIST	REVISIONS					
A	66	P	LTR	DESCRIPTION	DATE	DWN	APVD
		B		ECR-16-006093	26APR2016	MR	GB
		C		ECR-20-007917	03JUN2020	FJ	TE
		D		ECR-20-008693	17JUN2020	JAH	RK

	-	1	1	2119641-1	FEED CAM, AIR FEED	248
	-	1	1	2119082-5	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	1-18028-0	WASHER, FLAT, REG M8	192
	-	1	1	1752354-2	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
5	-	1	1	2119955-2	ASSY, LUBRICATOR, END FEED	84
	-	1	1	455888-7	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	1901681-1	HOLDDOWN, TERMINAL	65
	-	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	2168400-1	SHCS, LOW HEAD, RoHS, M4 X 12	57
	-	2	2	1-2168083-2	SCR, SKT HD CAP, RoHS, M4 X 25	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	1-2119655-1	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	690455-1	STRIPPER, FRONT CASTING	27
	-	2	2	1-2168083-6	SCR, SKT HD CAP, RoHS, M4 X 35	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	4-1901696-1	STRIP GUIDE, REAR	19
	-	1	1	4-1901695-1	STRIP GUIDE, FRONT	18
	-	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17
	-	1	1	3-240641-0	SPACER	16
	-	1	1	1752360-1	SPACER,HOLD-DOWN	13
1	-	1	1	240644-1	PLATE, REAR SHEAR	11
	-	2	2	1-240645-1	SPACER, SHEAR PLATE	10
1	-	1	1	240642-1	PLATE, FRONT SHEAR	9
1	1	2	1	1-1803059-9	ANVIL, COMBINATION, END FEED	8
1	-	1	1	8-240651-2	BLADE, SLUG	7
	-	-	-	-	-	6
	-	1	1	7-240641-3	SPACER	5
	-	1	1	1-238011-4	BLOCK, CRIMPER SPACER	4
1	1	2	1	8-1633965-4	CRIMPER, INSULATION O PREMIUM	3
	-	1	1	1-455888-4	SPACER, CRIMPER	2
1	1	2	1	1-456430-6	CRIMPER, WIRE	1
	-77-72	-2		PART NO	DESCRIPTION	ITEM NO

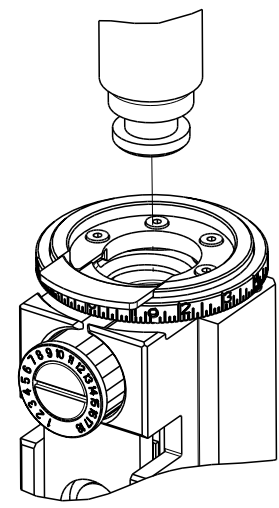
THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE AND TO BE CONTROLLED BY THE DRAWING ORGANIZATION. IT SHOULD BE CONTACTED FOR THE LATEST REVISION.				DWN J. HOU 12JAN2015	TE Connectivity Harrisburg, PA 17105-3608		
DIMENSIONS: mm				CHK L. ZHANG 12JAN2015	NAME Ocean End Feed Applicator		
				APVD J. GUO 12JAN2015	PRODUCT SPEC		
					APPLICATION SPEC		
					FINISH		
MATERIAL -					SIZE A1	CAGE CODE 00779	DRAWING NO 2150524
					WEIGHT -	RESTRICTED TO -	
					Customer Accessible Production Drawing	SCALE 1:1	SHEET 1 of 4
						REV D	

SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION



THIS DRAWING IS CONTROLLED DOCUMENT AND ANY REPLICATED INFORMATION SHALL BE CONTROLLED BY THE LATEST REVISION		DWN 12JAN2015 CHG 12JAN2015 CHG 12JAN2015 W GUO 12JAN2015		 TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		NAME Ocean End Feed Applicator	

8		7	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150524-2	D	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150524-7	A	CRIMP TOOLING KIT	-



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	5.33 mm [.210]	F
INSUL	7.62 mm [.300]	O
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: RING TERMINAL			
WIRE STRIP LENGTH 4.39-5.16 mm [.173-.203 IN]		INSULATION DIAMETER RANGE Ø3.81-5.59 mm [.150-.220 IN]	
TERMINAL APPLICATION  114-2084		-	-
SPECIFICATION -		-	-
TERMINALS APPLIED  			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
61289-1	42947-2	42947-4	
42946-2	42947-3	640012-2	

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING
8 AWG		4.04+/-0.05 [.159+/- .002]		2.3
10 AWG		3.53+/-0.05 [.139+/- .002]		8.4
12 AWG		3.23+/-0.05 [.127+/- .002]		11.9



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 ITEMS 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. TERMINAL LUBRICANT IS RECOMMENDED.
6. TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
7. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.

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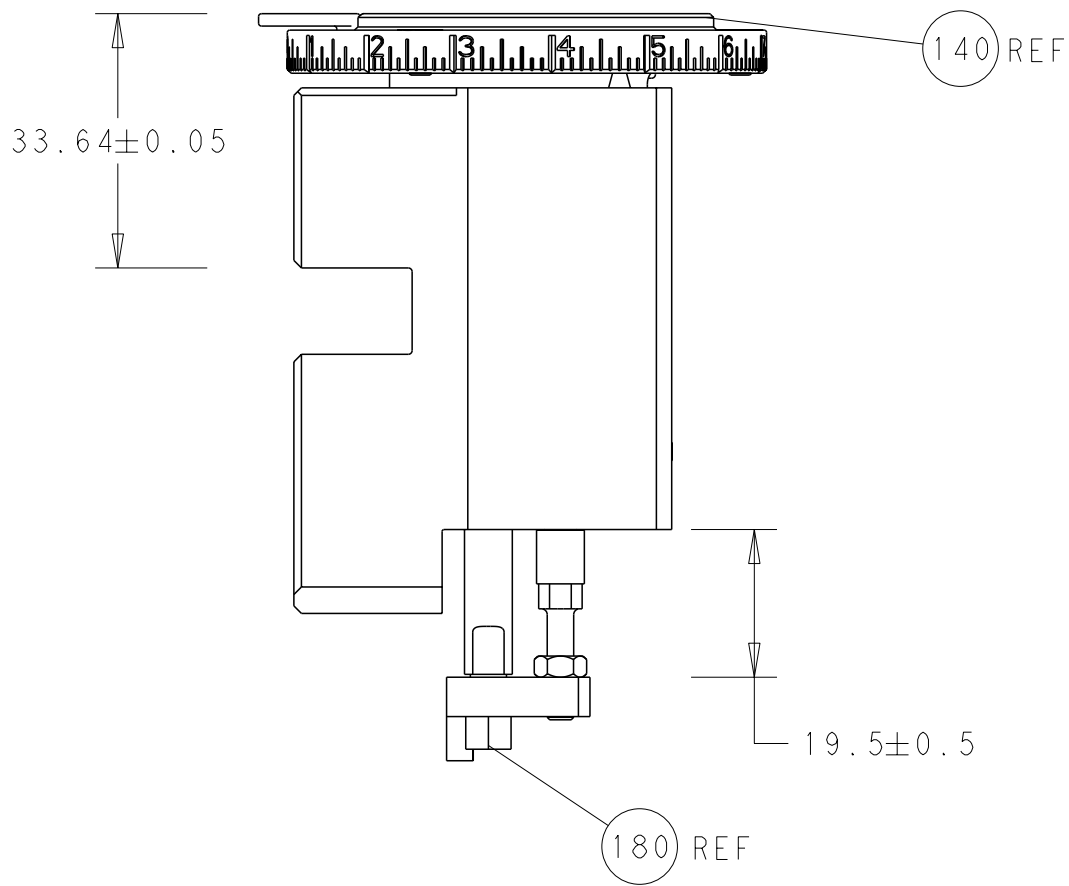
PACIFIC VERSION
Shown on sheets 3 of 4 & 4 of 4
(Atlantic version shown on sheets 1 of 4 & 2 of 4)

[illegible]

	-	1	2119082-5	CAM, SNAIL, INSULATION ADJUSTMENT	244
	-	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
3	-	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
3	-	1	1752354-2	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	1-2119655-2	APPLICATOR BASIC ASSEMBLY, EF	141
	-	1	1803518-1	RAM ASSEMBLY, EF PACIFIC	140
5	-	1	2119955-2	ASSY, LUBRICATOR, END FEED	84
	-	1	455888-7	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	1901681-1	HOLDDOWN, TERMINAL	65
	-	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
	-	4	2168400-1	SHCS, LOW HEAD, RoHS, M4 X 12	57
	-	2	1-2168083-2	SCR, SKT HD CAP, RoHS, M4 X 25	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
	-	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	690455-1	STRIPPER, FRONT CASTING	27
	-	2	1-2168083-6	SCR, SKT HD CAP, RoHS, M4 X 35	25
	-	1	1752371-5	PLATE, STRIP GUIDE	24
	-	2	2-22281-3	SPRING, COMPRESSION	22
	-	1	1803292-4	DRAW	20
	-	1	4-1901696-1	STRIP GUIDE, REAR	19
	-	1	4-1901695-1	STRIP GUIDE, FRONT	18
	-	1	3-240641-0	SPACER	16
	-	1	1752360-1	SPACER,HOLD-DOWN	13
1	-	1	240644-1	PLATE, REAR SHEAR	11
	-	2	1-240645-1	SPACER, SHEAR PLATE	10
1	-	1	240642-1	PLATE, FRONT SHEAR	9
1	1	1	1-1803059-9	ANVIL, COMBINATION, END FEED	8
1	-	1	8-240651-2	BLADE, SLUG	7
	-	-	-	-	6
	-	1	7-240641-3	SPACER	5
	-	1	1-238011-4	BLOCK, CRIMPER SPACER	4
1	1	1	8-1633965-4	CRIMPER, INSULATION O PREMIUM	3
	-	1	1-455888-4	SPACER, CRIMPER	2
1	1	1	1-456430-6	CRIMPER, WIRE	1
-77-22			PART NO	DESCRIPTION	ITEM NO

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CHG J. ZHANG 12JAN2015		APP W. GUO 12JAN2015			
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 CAGE CODE DRAWING NO A 00779 C=2150524	
				RESTRICTED TO -	
Customer Accessible Production Procedure					
				SCALE 1:1 SHEET 3 OF 4 REV D	

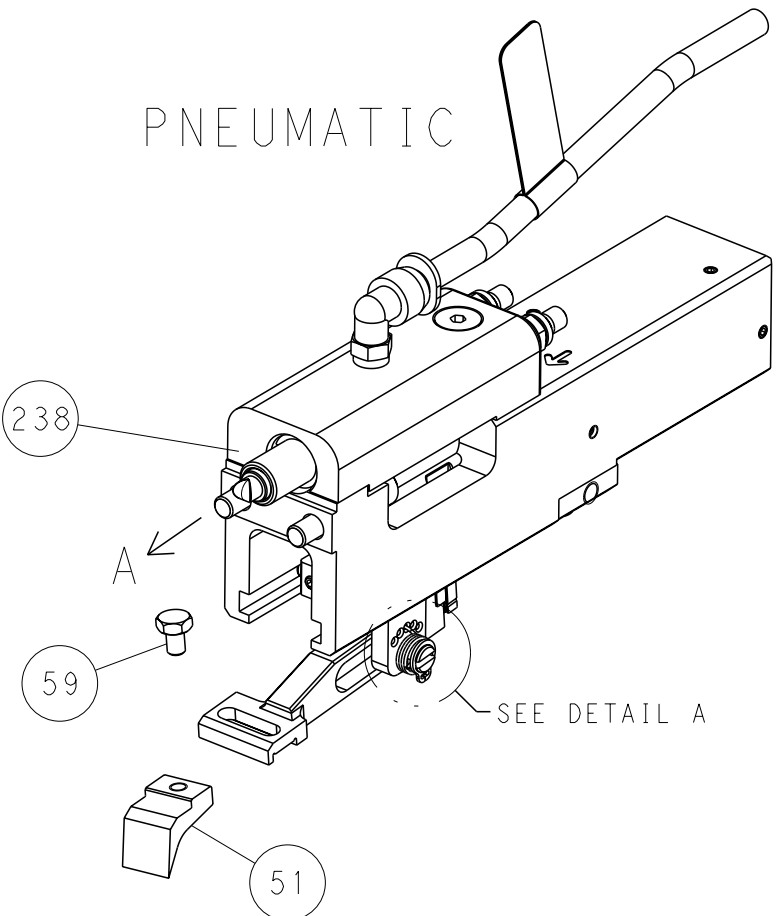
LOC		DIST		REVISIONS					
A		66		P	LTR	DESCRIPTION	DATE	DWN	APVD
					-	SEE SHEET 1	-	-	-



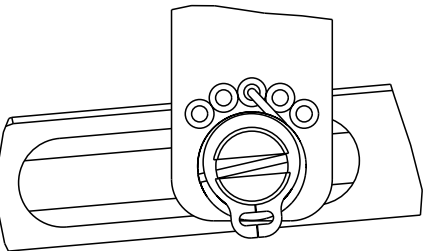
RAM AND HOLDDOWN SET-UP

FEED TYPE

PNEUMATIC

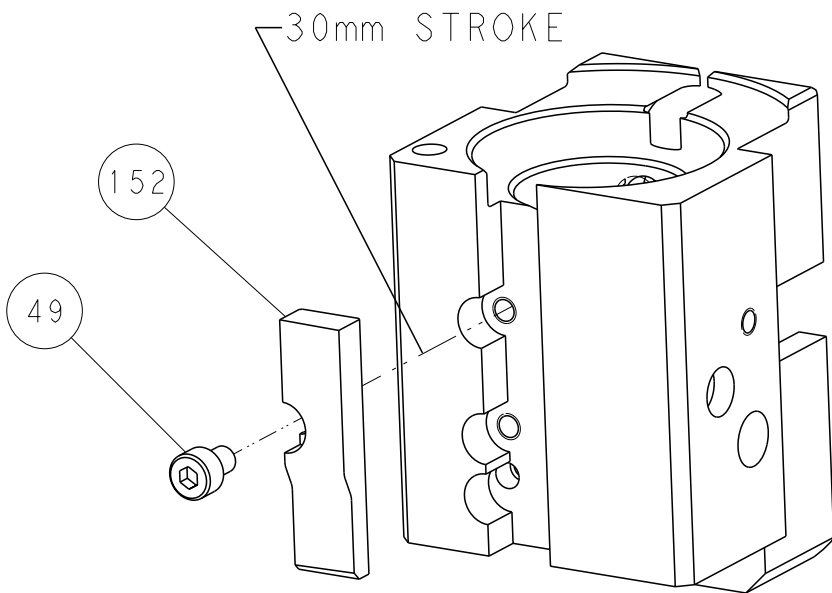


FEED SPRING SETTING POSITION

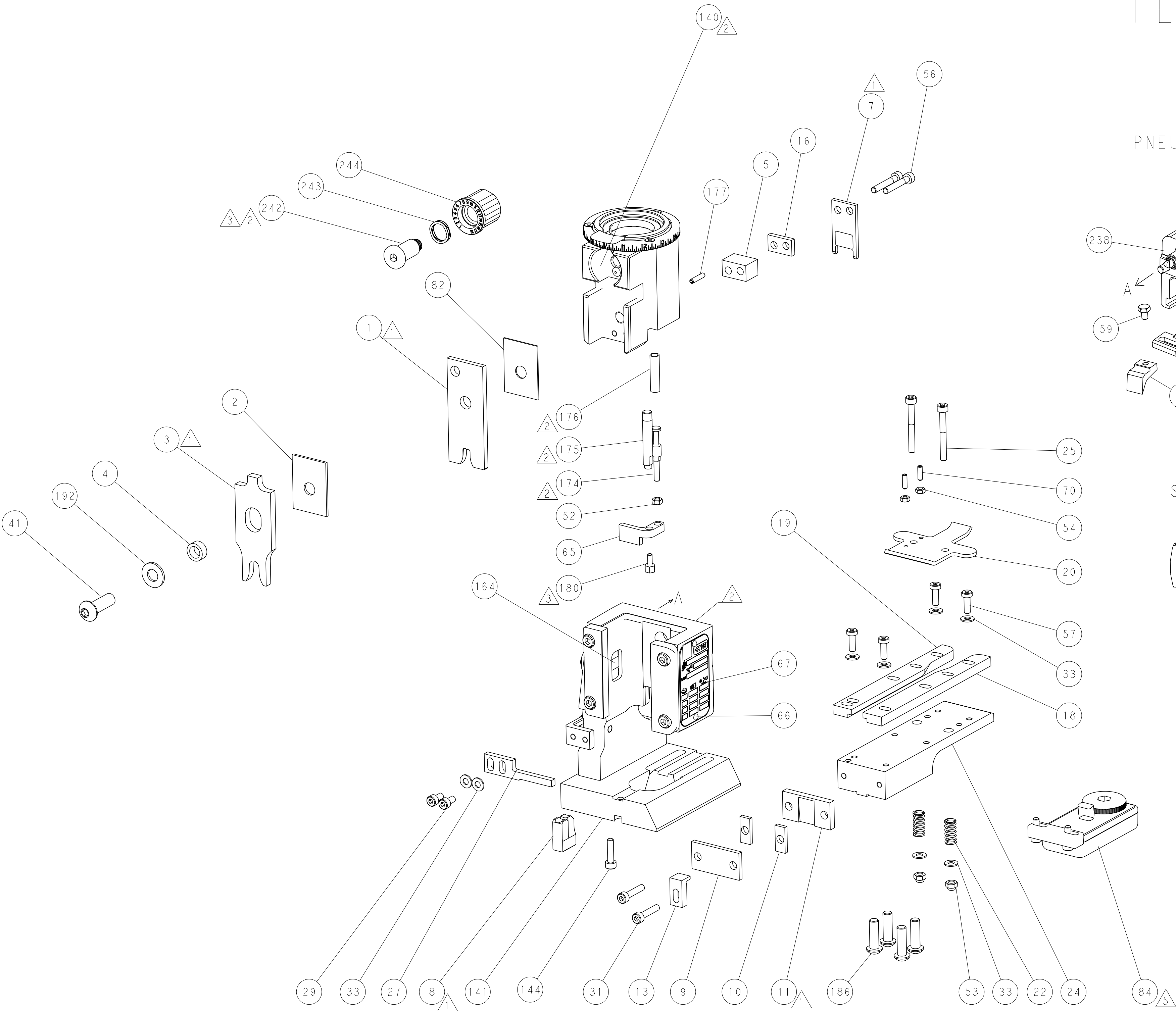


DETAIL A

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)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN		J. HOW		12JAN2015		STE		TE Connectivity	
mm		0 PLC ±		CHK		L. ZHANG		12JAN2015		Harrisburg, PA 17105-3608			
		1 PLC ±		APVD		U. GUO		12JAN2015		NAME		Ocean End Feed	
		2 PLC ±								APPLICATOR			
		3 PLC ±								SIZE		CAGE CODE	
		4 PLC ±								DRAWING NO		RESTRICTED TO	
		FINISH								A1		00779	
										C=2150524			
										Customer Accessible Production Drawing		SCALE	
										1:1		SHEET	
										4		OF	
										4		REV	
										D			

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[7-2150524-7](#)