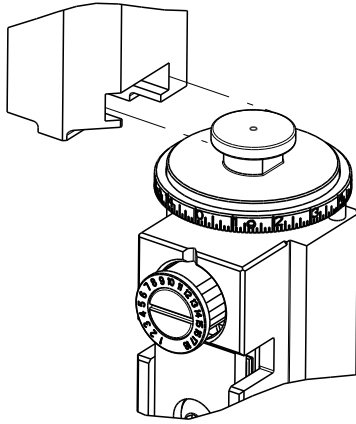


8		7	
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2017		2017	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150771-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2150771-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150771-1	C	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2150771-2	C	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150771-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.79 mm [.110]	F
INSUL	3.56 mm [.140]	F
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: WELD TAB			
WIRE STRIP LENGTH 2.72-3.48 mm [.107-.137 IN]		INSULATION DIAMETER RANGE Ø2.29-3.30 mm [.090-.130 IN]	
TERMINAL APPLICATION SPECIFICATION	114-2093	-	-
TERMINALS APPLIED			
TE TERMINAL 40990 60581-1	TE TERMINAL 40990-1	TE TERMINAL 40990-2	TE TERMINAL 40990-4

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING
16 AWG		1.68+/-0.05 [.066+/- .002]		4.4
18 AWG		1.55+/-0.05 [.061+/- .002]		5.8
20 AWG		1.45+/-0.05 [.057+/- .002]		6.9



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 LUBRICANT IS RECOMMENDED.
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.

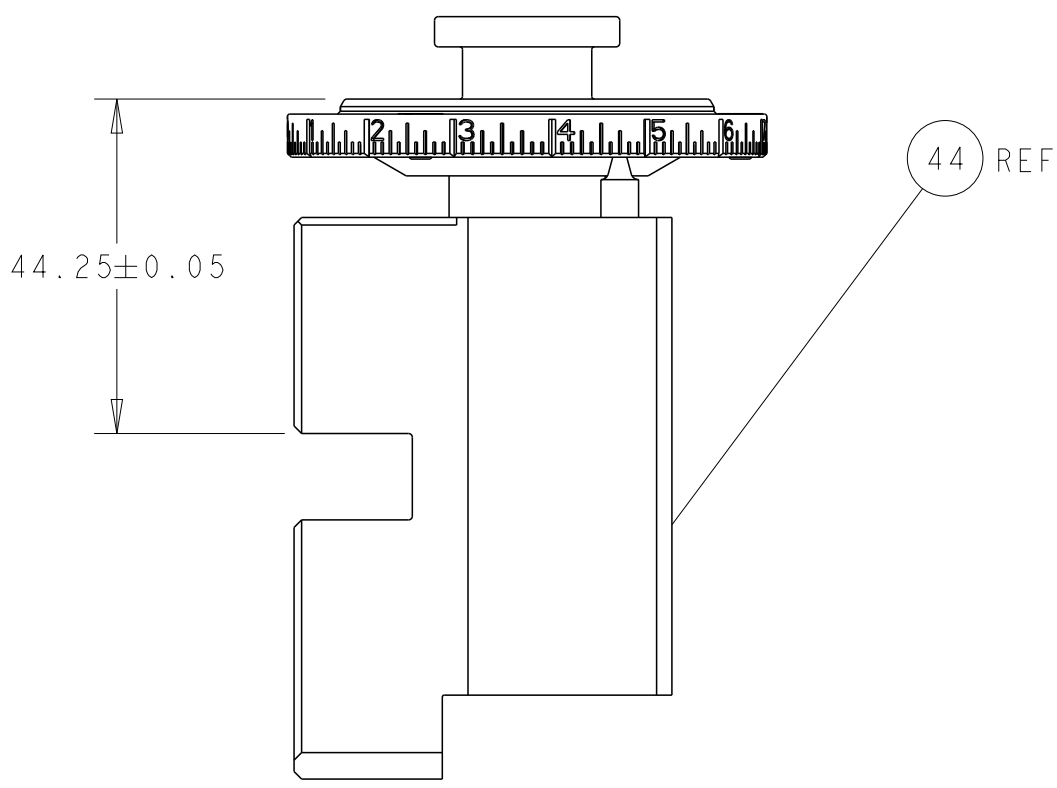
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

2				1					
LOC	DIST	REVISIONS							
A	66	P	LTR	DESCRIPTION			DATE	DWN	APVD
		A		RELEASED			03MAR2017	BW	JD
		B		ECR-19-002147			11FEB2019	TB	CT
		C		ECR-21-001295			01FEB2021	TB	RK

	-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248
	-	1	1	1	1	2119082-3	CAM, SNAIL, INSULATION ADJUSTMENT	244
	-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
3	-	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
	-	-	1	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
	-	1	-	1	-	2844940-3	AIR FEED MODULE	238
	-	1	1	1	1	1-18028-0	WASHER, FLAT, REG M8	192
	-	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
5	-	1	1	1	1	2119955-2	ASSY, LUBRICATOR, END FEED	84
	-	1	1	1	1	455888-5	SPACER, CRIMPER	82
	-	1	1	1	1	1803607-4	DOCUMENTATION PACKAGE	71
	-	2	2	2	2	2-18032-2	SCR, SET, FLT PNT, M3 X 10.0	70
	-	1	1	1	1	2119740-1	TAG, IDENTIFICATION	67
	-	2	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
	-	2	2	2	2	2168400-5	SHCS, LOW HEAD, RoHS, M4 X 20	64
	-	1	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	60
	-	1	1	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
	-	-	1	-	1	2063961-8	FEED FINGER	58
	-	3	3	3	3	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57
	-	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	-	2063961-8	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
	-	7	7	7	7	1-18028-2	WASHER, FLAT, REG M4	33
	-	2	2	2	2	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	31
	-	2	2	2	2	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	29
	-	1	1	1	1	2-455888-0	SPACER, CRIMPER	28
	-	1	1	1	1	690455-2	STRIPPER, FRONT CASTING	27
	-	2	2	2	2	1-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 30	25
	-	1	1	1	1	1752371-5	PLATE, STRIP GUIDE	24
	-	1	1	1	1	240825-1	PLATE, STRIP HOLD DOWN	23
	-	2	2	2	2	22281-8	SPRING, COMPRESSION	22
	-	1	1	1	1	1803292-4	DRAG	20
	-	2	2	2	2	1901259-6	GUIDE, LOWER STRIP	18
1	-	4	4	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17
	-	1	1	1	1	691901-7	REAR SHEAR PLATE, REVERSIBLE	11
	-	2	2	2	2	1-240645-6	SPACER, SHEAR PLATE	10
	-	1	1	1	1	1-690783-0	PLATE, SPACER	9
	1	2	2	1	1	2-1803257-3	ANVIL, COMBINATION, END FEED	8
	-	1	1	1	1	460507-1	BLADE, SHEAR	7
	-	-	-	-	-	-	-	6
	-	1	1	1	1	238011-6	BLOCK, CRIMPER SPACER	4
1	1	2	2	1	1	9-1803187-5	CRIMPER, INSULATION F	3
	-	1	1	1	1	455888-5	SPACER, CRIMPER	2
1	1	2	2	1	1	1633730-3	CRIMPER, WIRE	1
	-77-72-71	-2	-1			PART NO	DESCRIPTION	ITEM NO

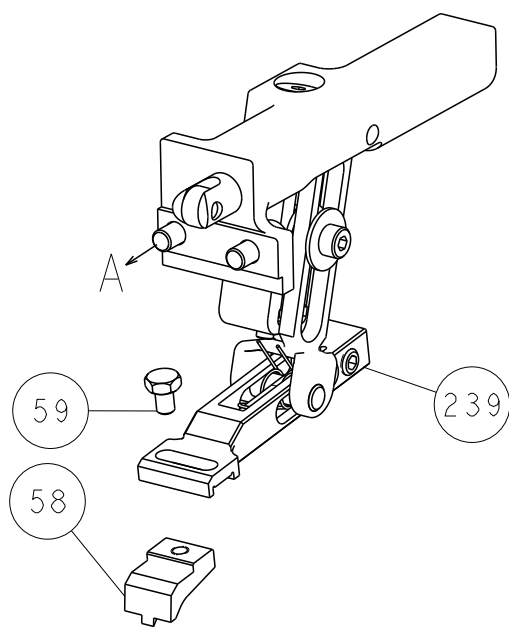
THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. THE USER SHALL BE RESPONSIBLE FOR OBTAINING THE LATEST EDITION.				OWN B. WEAVER CHK J. DEGRANGE APVD J. DEGRANGE				26JAN2017 26JAN2017 26JAN2017			
DIMENSIONS:				TOLERANCES UNLESS OTHERWISE SPECIFIED:				NAME			
mm				0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH ±				PRODUCT SPEC			
				APPLICATION SPEC				SIZE			
MATERIAL				WEIGHT				CAGE CODE			
-				-				DRAWING NO			
-				-				RESTRICTED TO			
-				-				SCALE			
-				-				SHEET			
-				-				OF			
-				-				REV			
-				-				C			

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

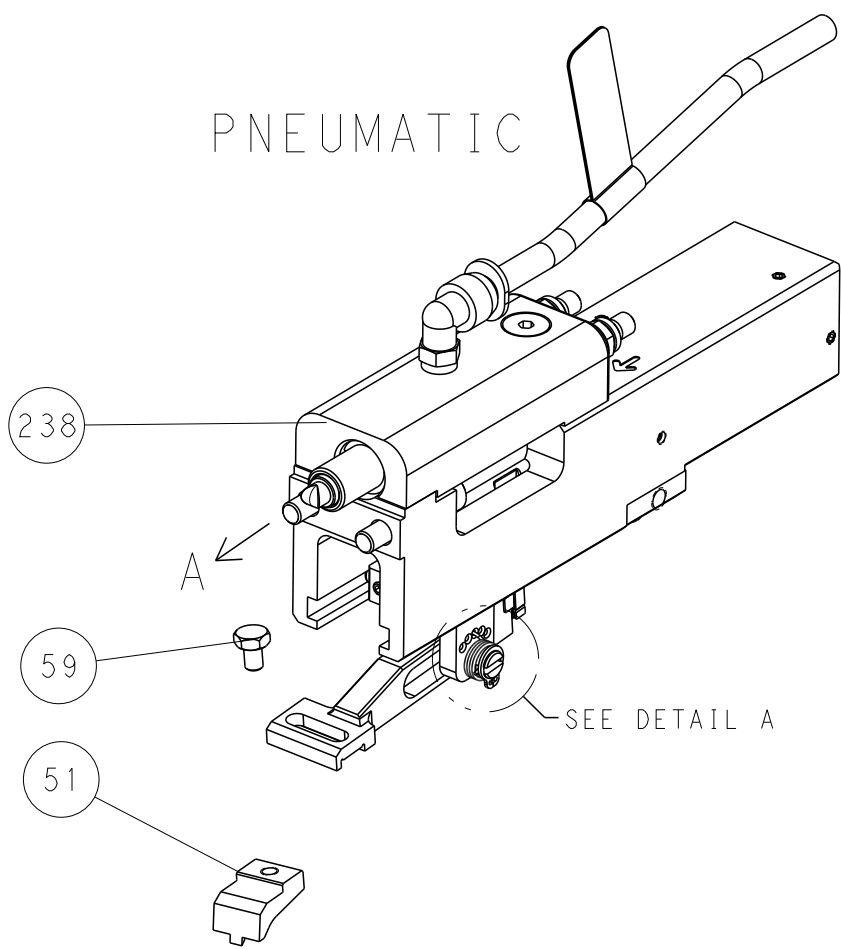


RAM SET-UP

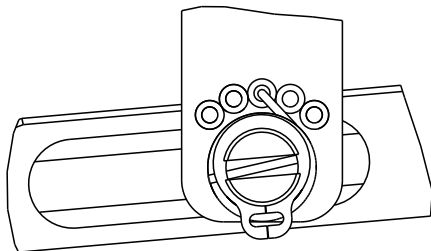
FEED TYPE
MECHANICAL



PNEUMATIC

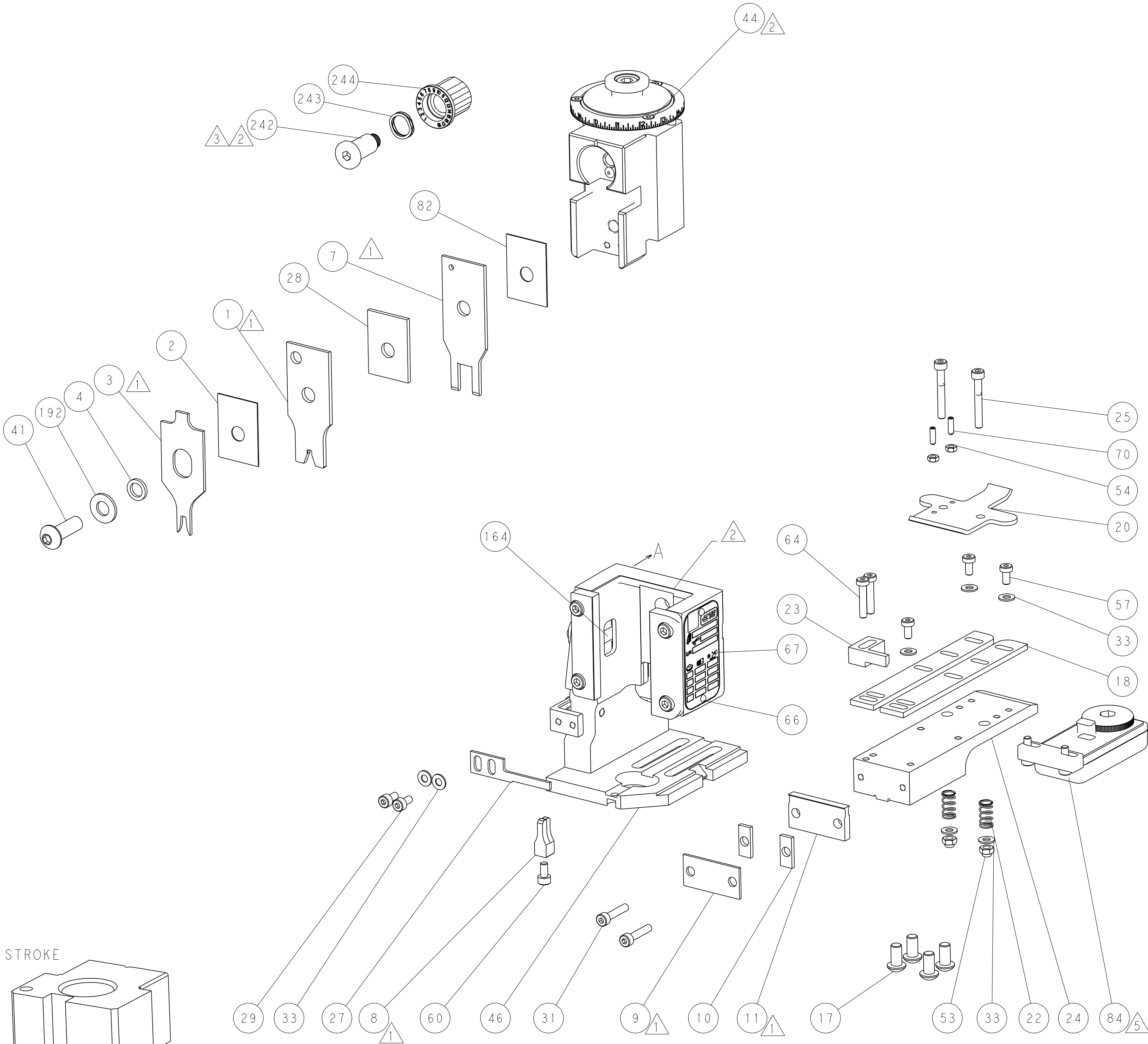
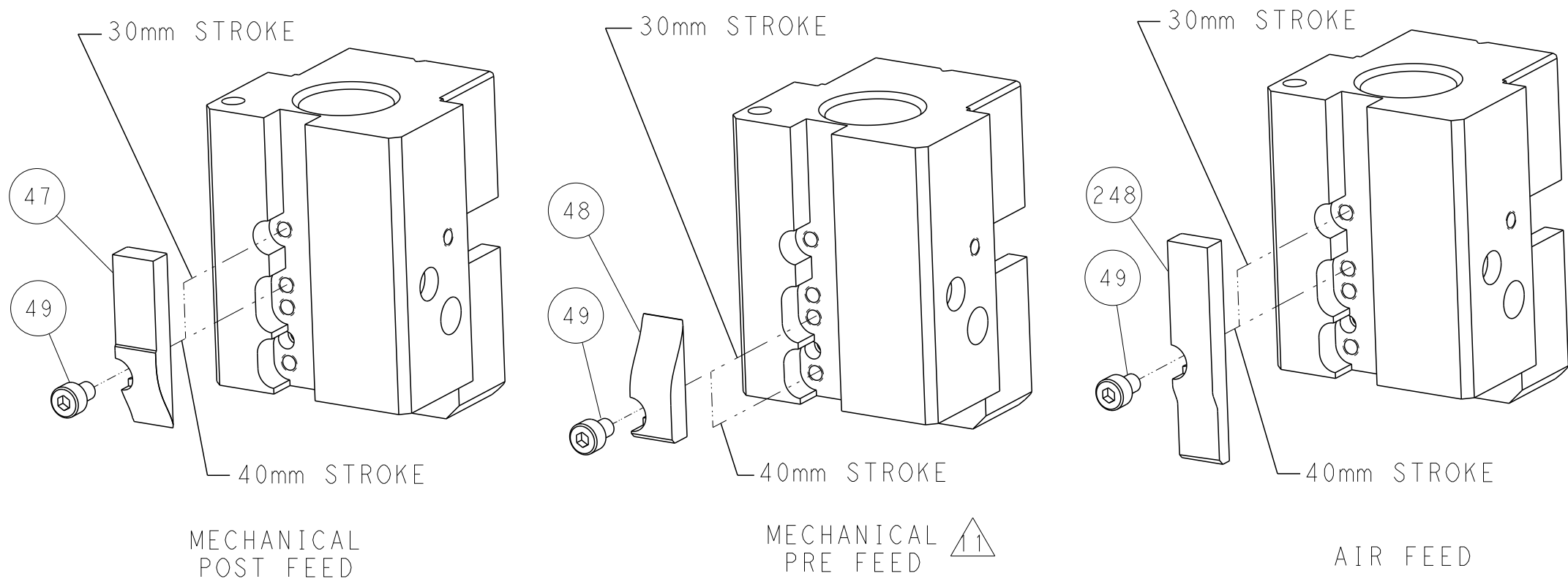


FEED SPRING
SETTING POSITION



DETAIL A

CAM POSITIONS

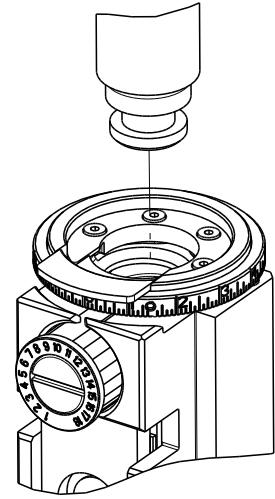


ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. IT IS SUBJECT TO CHANGE WITHOUT NOTICE.				OWN: B. WEAVER 26JAN2017				TE Connectivity			
CM: J. DEGRANGE 26JAN2017				NAME: Ocean End Feed Applicator				Harrisburg, PA 17105-3608			
APVD: J. DEGRANGE 26JAN2017				SIZE: A1				CAGE CODE: 00779			
PRODUCT SPEC: -				DRAWING NO: C-2150771				RESTRICTED TO: -			
APPLICATION SPEC: -				SCALE: 1:1				SHEET 2 OF 4			
WEIGHT: -				REV: C							
MATERIAL: -				Customer Accessible Production Drawing							

8		7	
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2017		2017	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150771-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2150771-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150771-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.79 mm [.110]	F
INSUL	3.56 mm [.140]	F
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL				TE CRIMP SPECIFICATION
TERMINAL NAME: WELD TAB				
WIRE STRIP LENGTH 2.72-3.48 mm [.107-.137 IN]			INSULATION DIAMETER RANGE Ø2.29-3.30 mm [.090-.130 IN]	
TERMINAL APPLICATION SPECIFICATION		114-2093	-	-
TERMINALS APPLIED				
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL	
40990	40990-1	40990-2	40990-4	
60581-1				

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING
16 AWG		1.68+/-0.05 [.066+/- .002]		4.4
18 AWG		1.55+/-0.05 [.061+/- .002]		5.8
20 AWG		1.45+/-0.05 [.057+/- .002]		6.9



- 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 LUBRICANT IS RECOMMENDED.
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)

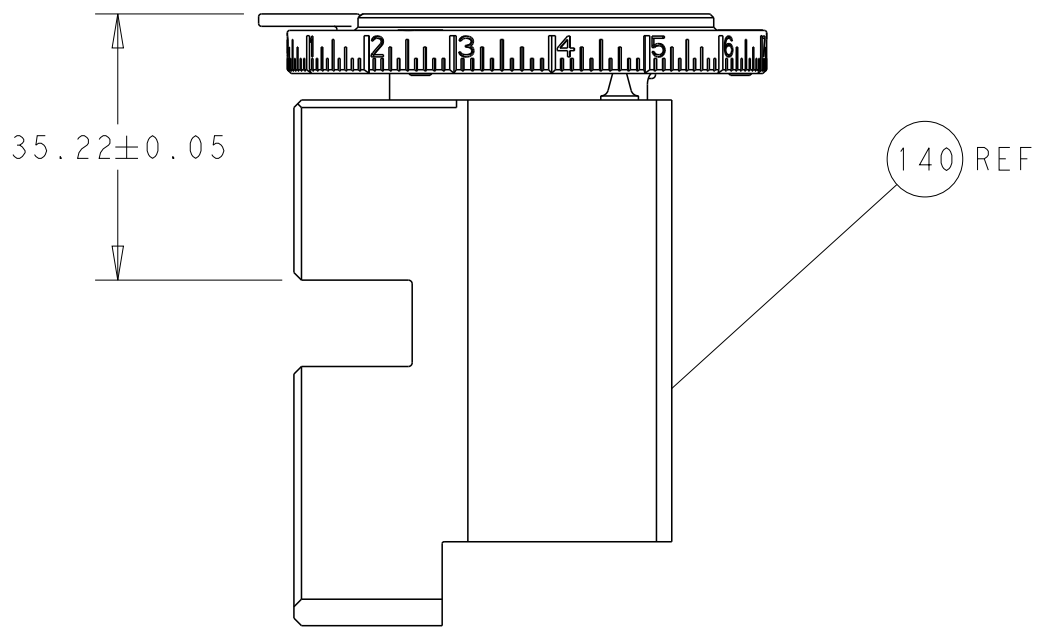
2		1					
LOC	DIST	REVISIONS					
A	66	P	LTR	DESCRIPTION	DATE	DWN	APVD
		-		SEE SHEET 1	-	-	-

-	1	1	2119082-3	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
3	-	1	2119083-1	RETAINER, INSULATION DIAL	242
-	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	1	-	2844940-3	AIR FEED MODULE	238
-	1	1	1-18028-0	WASHER, FLAT, REG M8	192
-	4	4	2079383-9	SCR, BHSC, RoHS (M6 X 20)	186
-	REFREF		994970-2	COUNTER, MAGNETIC	164
-	1	-	2119641-2	FEED CAM, AIR FEED	152
-	1	1	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	144
-	-	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
5	-	1	2119955-2	ASSY, LUBRICATOR, END FEED	84
-	1	1	455888-5	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
-	2	2	2168400-5	SHCS, LOW HEAD, RoHS, M4 X 20	64
-	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	-	1	2063961-8	FEED FINGER	58
-	3	3	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57
-	2	2	5018030-1	NUT, HEX, REG, RoHS, M3	54
-	2	2	986965-8	NUT, LOCK, HEX, TORQUE (M4)	53
-	1	-	2063961-8	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
-	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	2-455888-0	SPACER, CRIMPER	28
-	1	1	690455-2	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	240825-1	PLATE, STRIP HOLD DOWN	23
-	2	2	22281-8	SPRING, COMPRESSION	22
-	1	1	1803292-4	DRAG	20
-	2	2	1901259-6	GUIDE, LOWER STRIP	18
1	-	1	691901-7	REAR SHEAR PLATE, REVERSIBLE	11
-	2	2	1-240645-6	SPACER, SHEAR PLATE	10
1	-	1	1-690783-0	PLATE, SPACER	9
1	1	1	2-1803257-3	ANVIL, COMBINATION, END FEED	8
1	-	1	460507-1	BLADE, SHEAR	7
-	-	-	-	-	6
-	1	1	238011-6	BLOCK, CRIMPER SPACER	4
1	1	1	9-1803187-5	CRIMPER, INSULATION F	3
-	1	1	455888-5	SPACER, CRIMPER	2
1	1	1	1633730-3	CRIMPER, WIRE	1
-	77-22-21		PART NO	DESCRIPTION	ITEM NO

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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		SIZE CAGE CODE DRAWING NO					
MATERIAL		WEIGHT		RESTRICTED TO		A 00779 C=2150771					
-		-		-		-					
Customer Accessible Production Drawing						SCALE 1:1		SHEET 3 OF 4		REV C	

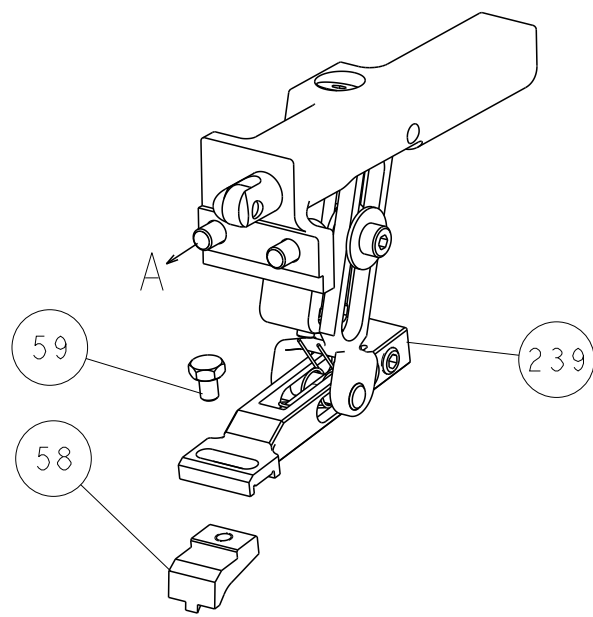
SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

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

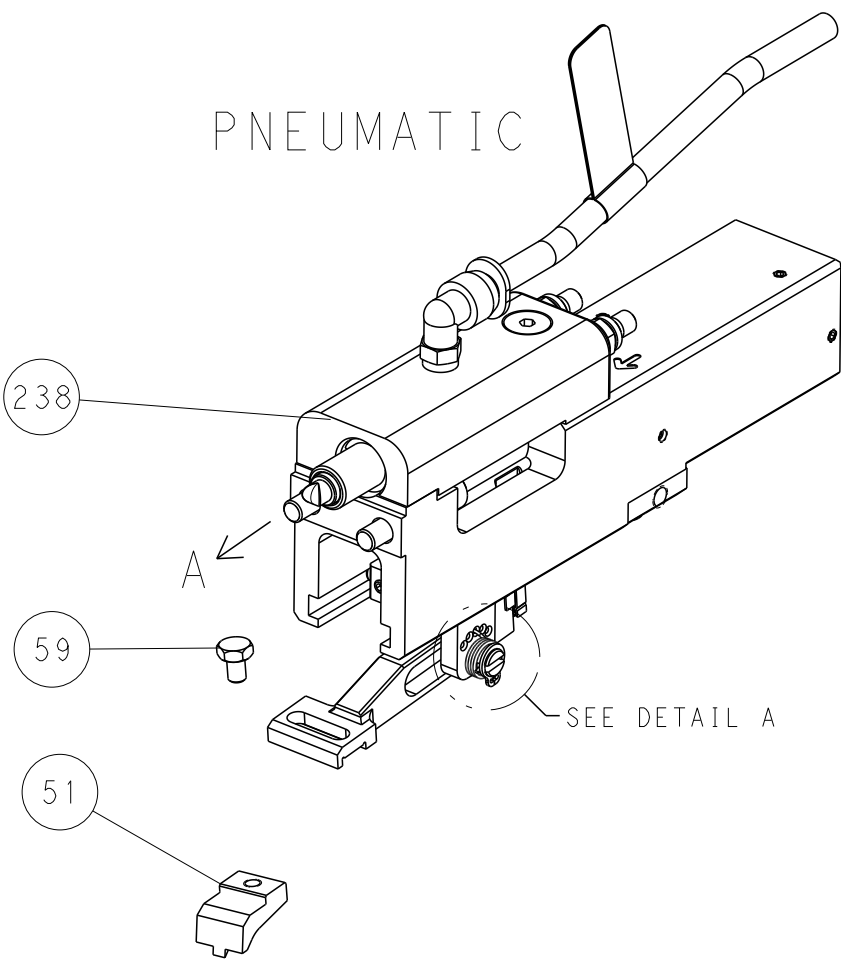


RAM SET-UP

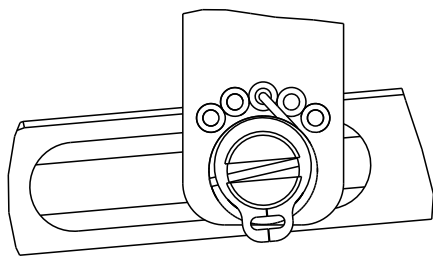
FEED TYPE
MECHANICAL



PNEUMATIC

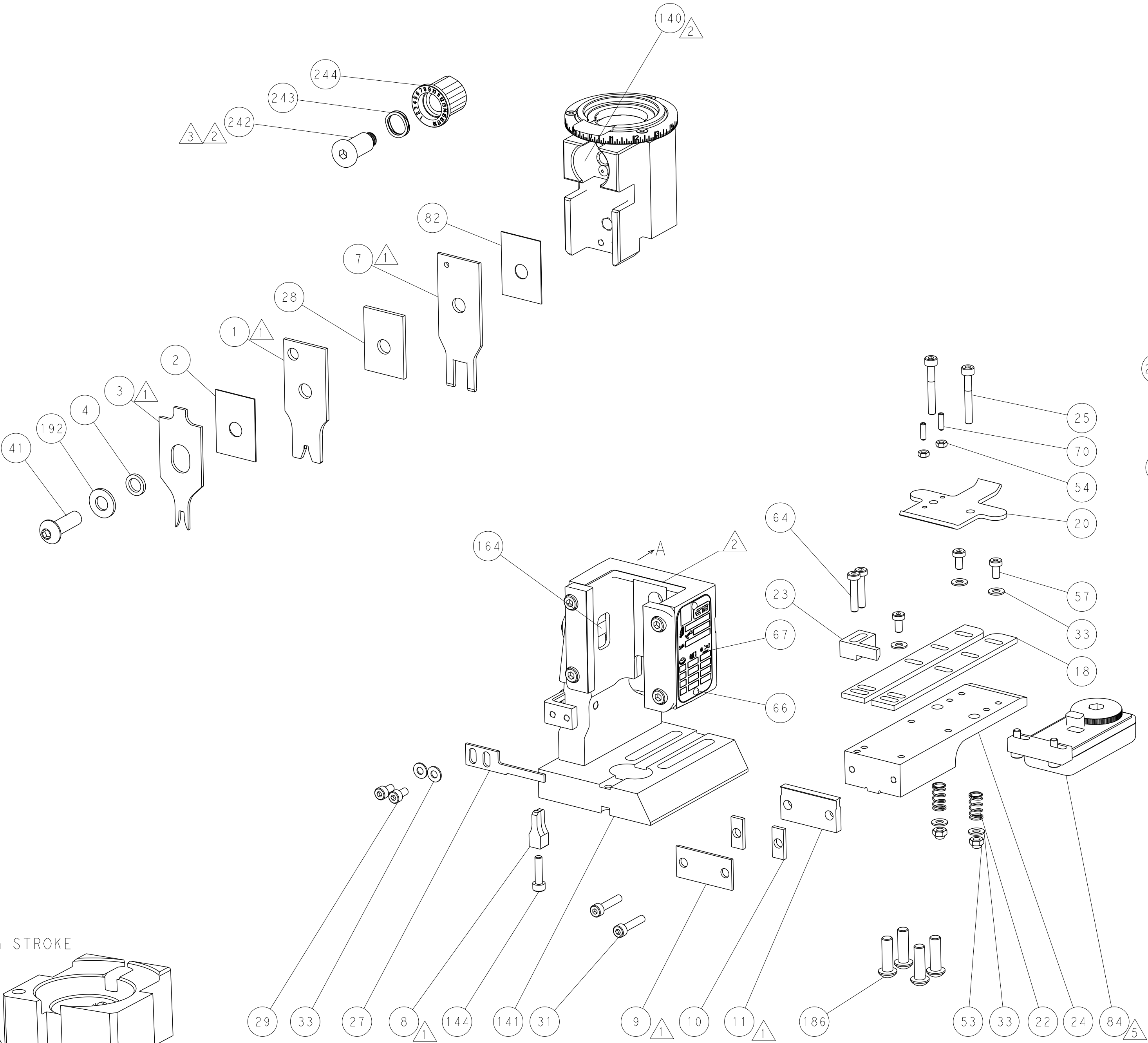
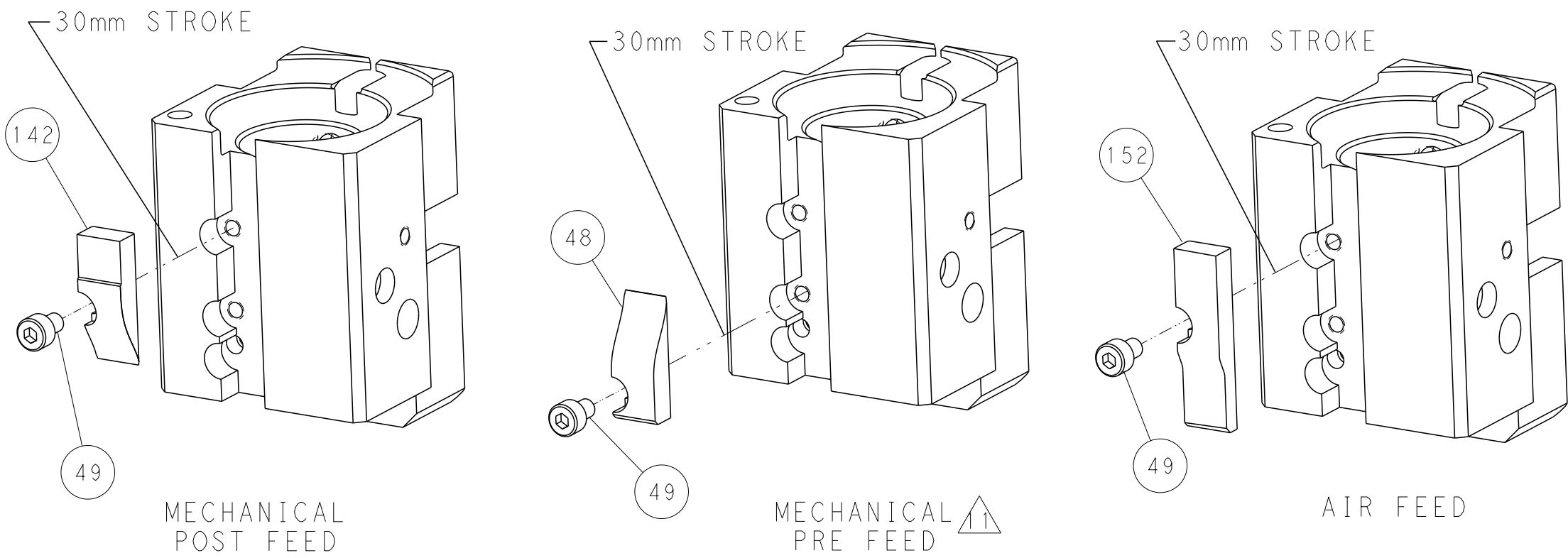


FEED SPRING
SETTING POSITION



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 CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. ANY CHANGES TO THIS DRAWING SHOULD BE CONTACTED FOR THE LATEST VERSION.				DWN B. WEAVER 26JAN2017	 TE Connectivity Harrisburg, PA 17105-3608		
				CHK J. DEGRANGE 26JAN2017			
				APVD J. DEGRANGE 26JAN2017	NAME Ocean End Feed Applicator		
				PRODUCT SPEC			
				APPLICATION SPEC			
				WEIGHT	SIZE A1		
					CAGE CODE 00779		
					DRAWING NO C-2150771		
				Customer Accessible Production Drawing	RESTRICTED TO -		
				SCALE 1:1	SHEET 4		
					OF 4		
					REV C		

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[TE Connectivity:](#)

[7-2150771-7](#)