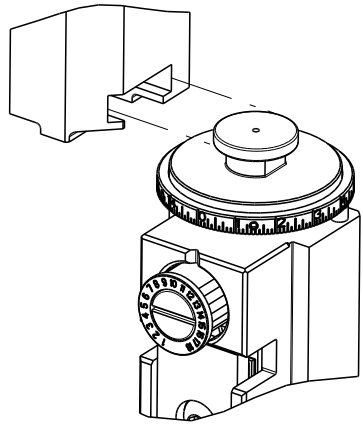
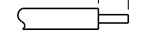


8	7
THIS DRAWING IS UNPUBLISHED.	
RELEASED FOR PUBLICATION 20	
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PART NUMBER	REVISION
2150039-2	D
7-2150039-2	D
7-2150039-7	A
DESCRIPTION	
FINE CRIMP HEIGHT ADJUST	
PNEUMATIC AND CRIMP TOOLING KIT	
CRIMP TOOLING KIT	
FEED TYPE	
PNEUMATIC	
PNEUMATIC	
-	

ATLANTIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.03 mm [.080]	F
INSUL	3.30 mm [.130]	F
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: 110 SERIES POSITIVE LOCK REC CONTACT			
WIRE STRIP LENGTH 3.50-4.50 mm [.138-.177 IN]		 INSULATION DIAMETER RANGE Ø2.10-3.30 mm [.083-.130 IN]	
TERMINAL APPLICATION SPECIFICATION		114-5120	
		-	
-		-	
TERMINALS APPLIED 			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
174777-1	174777-2	1337984-1	

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING	
16 AWG OR 1.25mm2		1.32+/-0.05 [.052+/- .002]		4.9	
18 AWG OR 0.75mm2		1.17+/-0.05 [.046+/- .002]		6.5	
20 AWG OR 0.50mm2		1.02+/-0.05 [.040+/- .002]		8.2	



- 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.
APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 50.
- 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 COMPATIBLE WITH MECHANICAL FEED.
6.
- UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- 7
- THIS CRIMP PARAMETER IS PROVIDED TO MEET A CUSTOM AND UNIQUE CUSTOMER REQUIREMENT. IT HAS BEEN EVALUATED AND IS CONDITIONALLY SPECIFIED BY TE CONNECTIVITY. THIS CUSTOMIZED CRIMP PARAMETER IS NOT LISED AS AN APPROVED APPLICATION WITHIN A TE CONNECTIVITY APPLICATION SPECIFICATION; HOWEVER, IT HAS BEEN VALIEDTED ACCORDING TE CONNECTIVITY SPECIFICATIONS 109-18079(TEST GROUP 1) AND 114-18022. TE CONNECTIVITY EXPRESSLY DISCLAIMS ANY AND ALL WARRANTIES THAT THE PRODUCT WILL PERFORM SIMILARLY TO VALIDATED AND APPROVED APPLICATIONS, AS STATED WITHIN TE CONNECTIVITY APPLICATION SPECIFICATIONS, INCLUDING BUT NOT LIMITED TO IMPLIED WARRANTIES OF MERCHANTABILITY OR FITNESS FOR PARTICULAR PURPOSE. AS SUCH, IT IS HIGHLY RECOMMENDED THAT THE CUSTOMER PERFORM FURTHER DETAILED EVALUATION TO ASSESS PRODUCT PERFORMANCE IN THE SPECIFIC APPLICATION.
- 8
- THIS WIRE COMBINATION IS ONLY TO BE USED WITH NO CONNECTOR HOUSING.

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: 110 SERIES POSITIVE LOCK REC CONTACT			
WIRE STRIP LENGTH 3.50-4.50 mm [.138-.177 IN]		INSULATION DIAMETER RANGE Ø2.10-3.30 mm [.083-.130 IN]	
TERMINAL APPLICATION SPECIFICATION			
TERMINALS APPLIED			
TE TERMINAL 174777-1	TE TERMINAL 174777-2	TE TERMINAL	TE TERMINAL

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING	
Ø 0.35+0.35mm2		1.15+/-0.05 [.045+/- .002]		7.0	

*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.

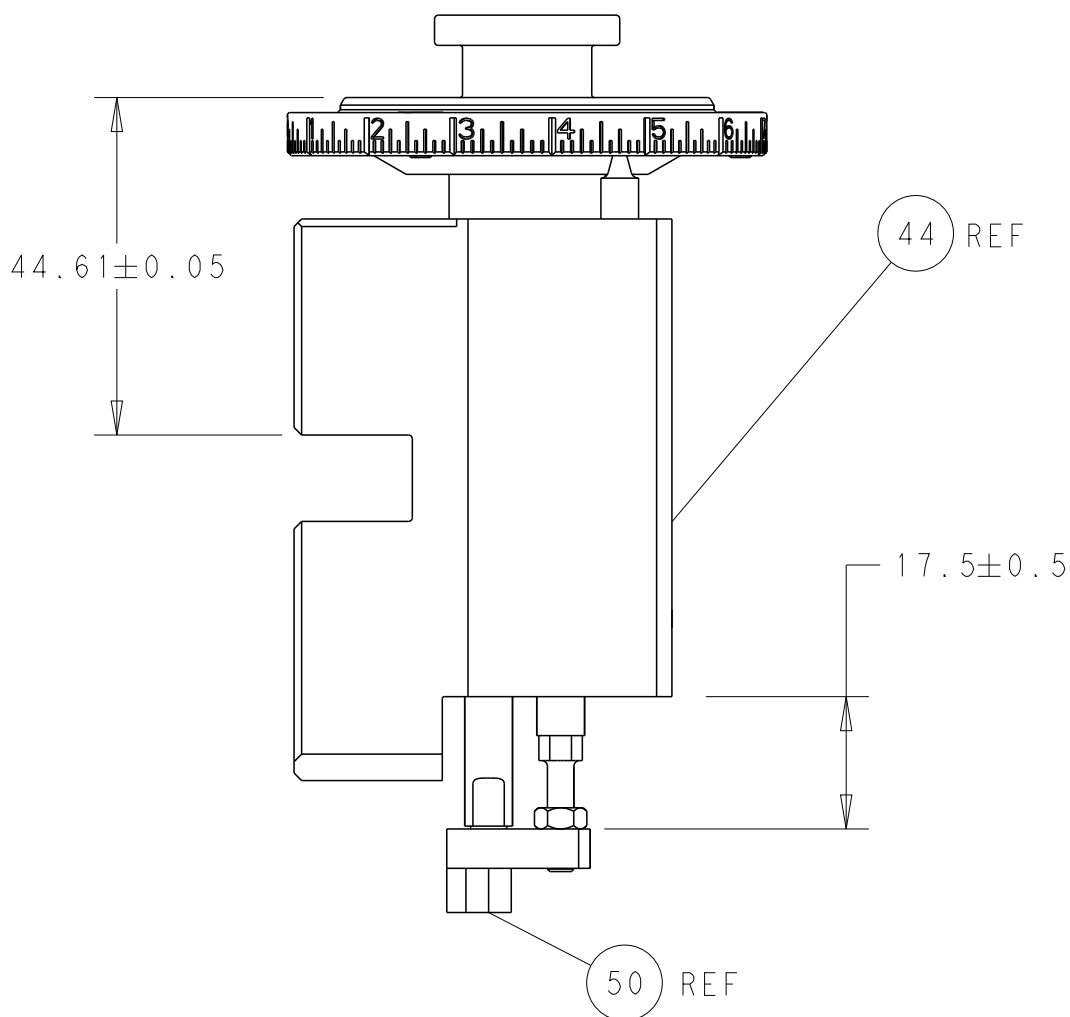
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

LOC	DIST	REVISONS			
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		B		ECR-19-005156	31MAR2019 TB CT
		C		ECR-19-005607	08APR2019 FZ CT
		D		ECR-21-000696	19JAN2021 TB RK
		D1		ECR-21-117347	14OCT2021 JWC TE

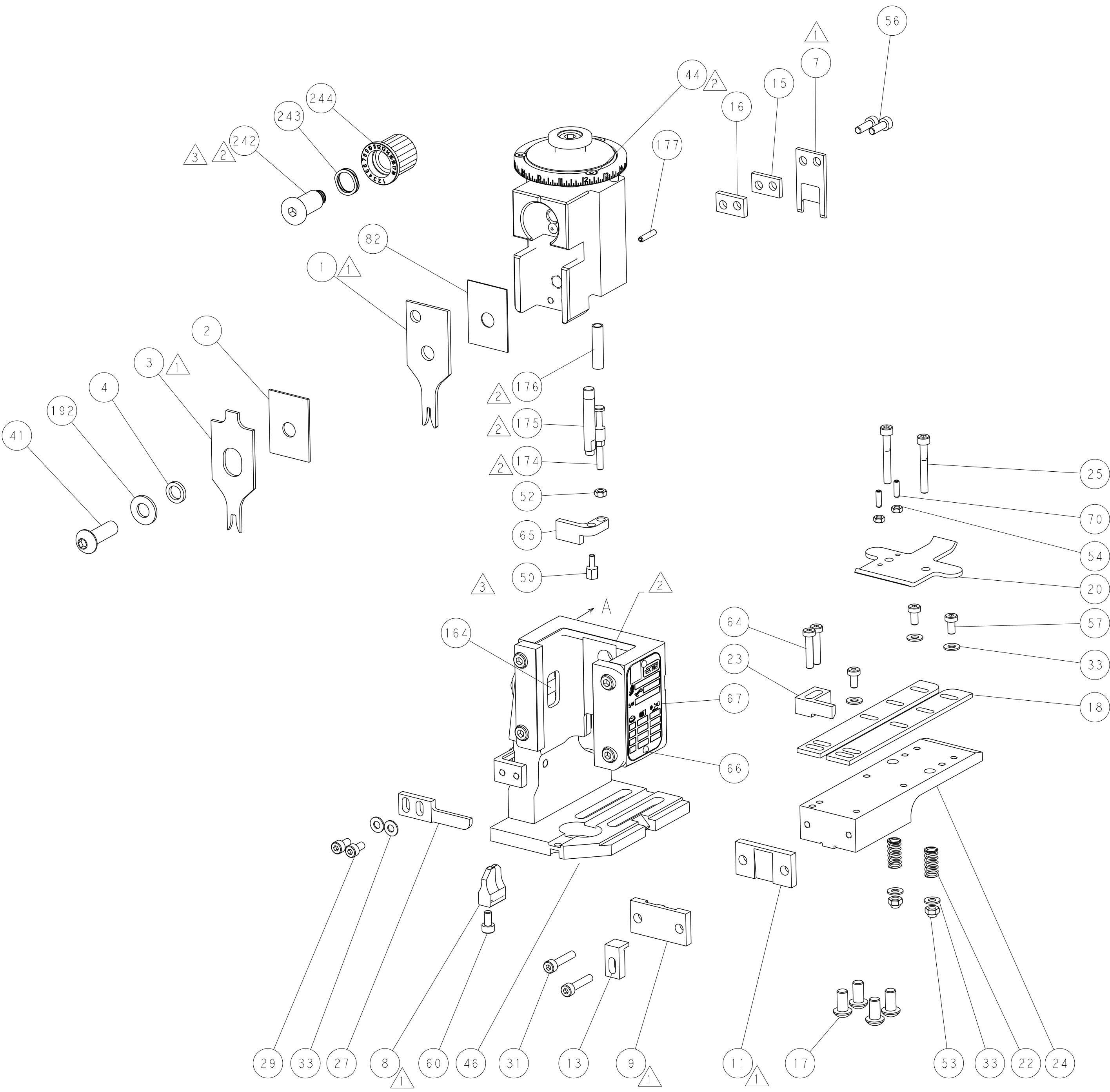
	-	1	1	2119641-1	FEED CAM, AIR FEED	248
	-	1	1	2119082-4	CAM, SNAIL, INSULATION ADJUSTMENT	244
	-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
3	-	1	1	2119083-1	RETAINER, INSULATION DIAL	242
	-	1	1	2844940-3	AIR FEED MODULE	238
	-	1	1	1-18028-0	WASHER, FLAT, REG M8	192
	-	1	1	6-993111-6	PIN, 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	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	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57
	-	2	2	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	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	2063961-9	FEED FINGER	51
3	-	1	1	1752354-8	STANDOFF,HOLD-DOWN	50
	-	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	240639-1	STRIPPER (MACHINING)	27
	-	2	2	1-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 30	25
	-	1	1	1-1752371-2	PLATE, STRIP GUIDE	24
	-	1	1	240825-7	PLATE, STRIP HOLD DOWN	23
	-	2	2	2-22281-3	SPRING, COMPRESSION	22
	-	1	1	1803292-4	DRAG	20
	-	2	2	1901259-5	GUIDE, LOWER STRIP	18
	-	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17
	-	1	1	3-240641-0	SPACER	16
	-	1	1	240641-2	SPACER	15
	-	1	1	1752360-1	SPACER,HOLD-DOWN	13
1	-	1	1	240644-5	PLATE, REAR SHEAR	11
	-	-	-	-	-	10
1	-	1	1	6-690482-0	PLATE, FRONT SHEAR	9
1	1	2	1	1-1333216-2	ANVIL, COMBINATION	8
1	-	1	1	690474-5	BLADE, SLUG	7
	-	-	-	-	-	5
	-	1	1	238011-7	BLOCK, CRIMPER SPACER	4
1	1	2	1	2119582-1	CRIMPER, INSULATION F PREMIUM	3
	-	1	1	1-455888-0	SPACER, CRIMPER	2
1	1	2	1	3-456405-4	CRIMPER, WIRE PREMIUM	1
	-77-72	-2		PART NO	DESCRIPTION	ITEM NO

THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. THE CUSTOMER IS RESPONSIBLE FOR VERIFYING THE ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST EDITION.		DWN L. ZHANG 03JUL2012	 TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS:		CHK L. ZHANG 03JUL2012	NAME	
mm	TOLERANCES UNLESS OTHERWISE SPECIFIED:	APVD S. XI 03JUL2012	Ocean End Feed Applicator	
	0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±	PRODUCT SPEC - APPLICATION SPEC -	SIZE CAGE CODE DRAWING NO RESTRICTED TO	
MATERIAL	FINISH	WEIGHT	A1 00779 C=2150039	
-	-	-	-	
Customer Accessible Production Drawing			SCALE 1:1	SHEET 1 OF 4 REV D1

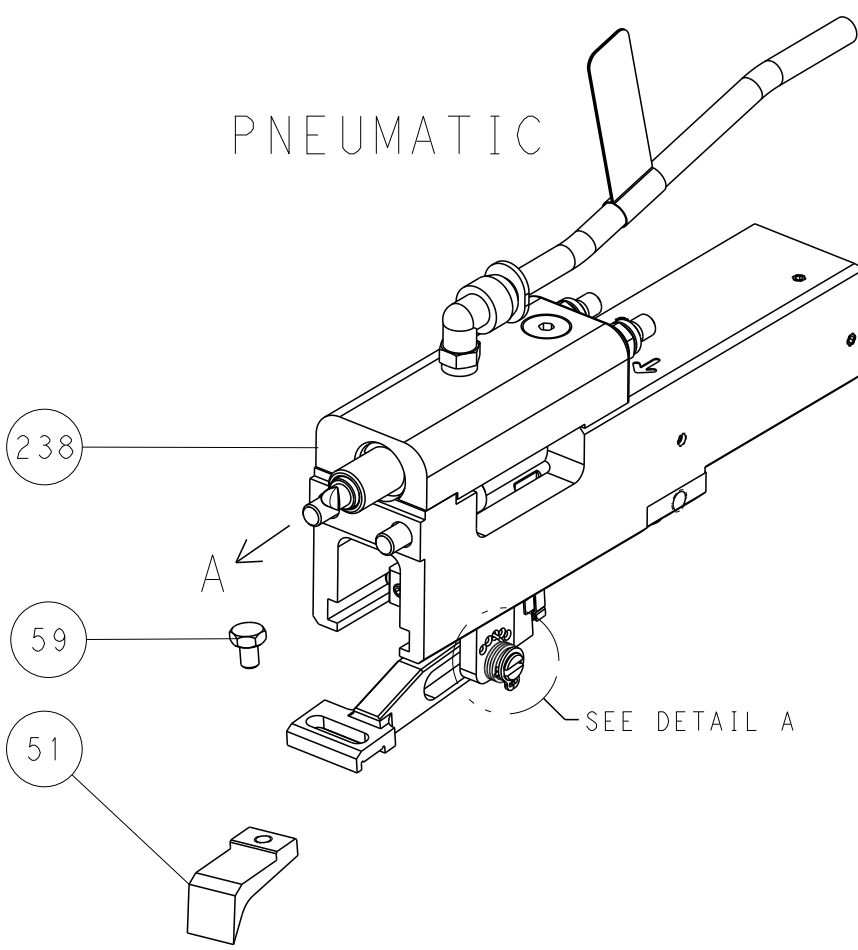
LOC	DIST	REVISIONS					
		P	LTR	DESCRIPTION	DATE	DWN	APVD
A	66		-	SEE SHEET 1	-	-	-



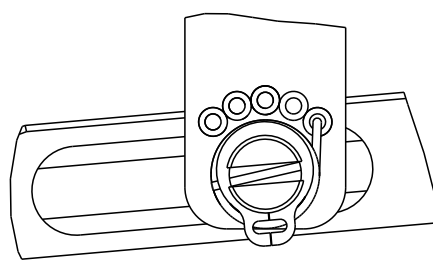
RAM AND HOLDDOWN SET-UP



FEED TYPE

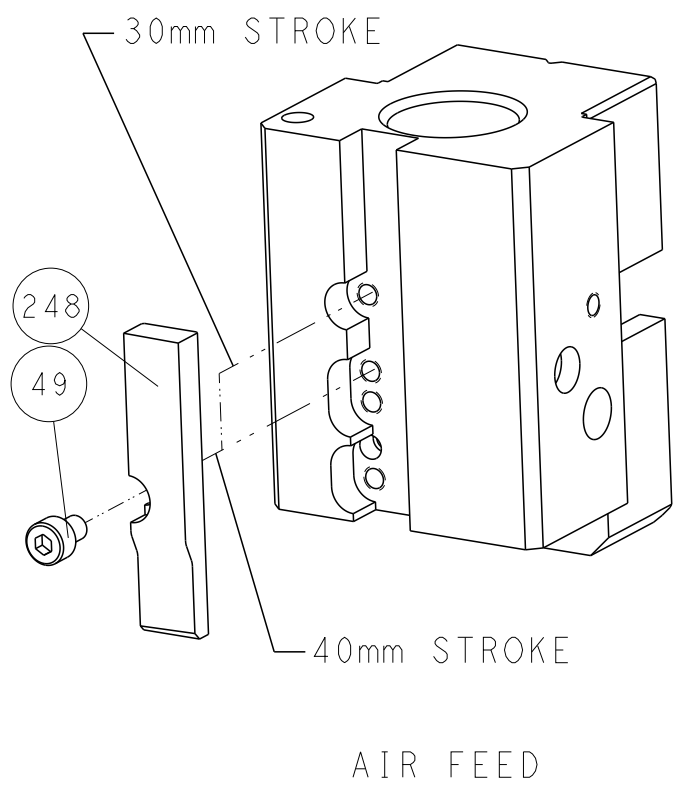


FEED SPRING SETTING POSITION



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)

THIS DRAWING IS CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION IT IS SUBJECT TO COMPANY'S QUALITY CONTROL AND INSPECTION ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST POSITION.				DWN L. ZHANG 03JUL2012	TE Connectivity Harrisburg, PA 17105-3608	
				CHK L. ZHANG 03JUL2012		
				APVD S. XI 03JUL2012	NAME Ocean End Feed Applicator	
DIMENSIONS: mm				PRODUCT SPEC	SIZE A1	
TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.1 1 PLC ±.1 2 PLC ±.1 3 PLC ±.1 4 PLC ±.1 ANGLES ±.1 FINISH				APPLICATION SPEC		
MATERIAL -				WEIGHT -	CAGE CODE 00779	
				Customer Accessible Production Drawing		RESTRICTED TO -
				SCALE 1:1	SHEET 2	REV D1

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150039-2	D	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150039-7	A	CRIMP TOOLING KIT	-

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.03 mm [.080]	F
INSUL	3.30 mm [.130]	F
APPL INSTRUCTIONS 408-35043		

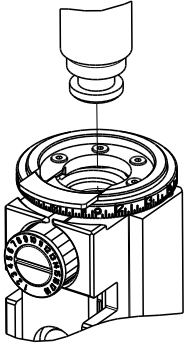
TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: 110 SERIES POSITIVE LOCK REC CONTACT			
WIRE STRIP LENGTH 3.50-4.50 mm [.138-.177 IN]		INSULATION DIAMETER RANGE Ø2.10-3.30 mm [.083-.130 IN]	
TERMINAL APPLICATION SPECIFICATION			
114-5120		-	
-		-	
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
174777-1	174777-2	1337984-1	

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING
16 AWG OR 1.25mm2		1.32+/-0.05 [.052+/- .002]		4.9
18 AWG OR 0.75mm2		1.17+/-0.05 [.046+/- .002]		6.5
20 AWG OR 0.50mm2		1.02+/-0.05 [.040+/- .002]		8.2



- RECOMMENDED SPARE PARTS
- REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242.
APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 50.
- 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 PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
6. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- THIS CRIMP PARAMETER IS PROVIDED TO MEET A CUSTOM AND UNIQUE CUSTOMER REQUIREMENT. IT HAS BEEN EVALUATED AND IS CONDITIONALLY SPECIFIED BY TE CONNECTIVITY. THIS CUSTOMIZED CRIMP PARAMETER IS NOT LISED AS AN APPROVED APPLICATION WITHIN A TE CONNECTIVITY APPLICATION SPECIFICATION; HOWEVER, IT HAS BEEN VALIDETED ACCORDING TE CONNECTIVITY SPECIFICATIONS 109-18079(TEST GROUP 1) AND 114-18022. TE CONNECTIVITY EXPRESSLY DISCLAIMS ANY AND ALL WARRANTIES THAT THE PRODUCT WILL PERFORM SIMILARLY TO VALIDATED AND APPROVED APPLICATIONS, AS STATED WITHIN TE CONNECTIVITY APPLICATION SPECIFICATIONS, INCLUDING BUT NOT LIMITED TO IMPLIED WARRANTIES OF MERCHANTABILITY OR FITNESS FOR PARTICULAR PURPOSE. AS SUCH, IT IS HIGHLY RECOMMEDNED THAT THE CUSTOMER PERFORM FURTHER DETAILED EVALUATION TO ASSESS PRODUCT PERFORMANCE IN THE SPECIFIC APPLICATION.
- THIS WIRE COMBINATION IS ONLY TO BE USED WITH NO CONNECTOR HOUSING.

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: 110 SERIES POSITIVE LOCK REC CONTACT			
WIRE STRIP LENGTH 3.50-4.50 mm [.138-.177 IN]		INSULATION DIAMETER RANGE Ø2.10-3.30 mm [.083-.130 IN]	
TERMINAL APPLICATION SPECIFICATION			-
	-	-	-
TERMINALS APPLIED 			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
174777-1	174777-2		

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING
8 0.35+0.35mm2		1.15+/-0.05 [.045+/- .002]		7.0

*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.

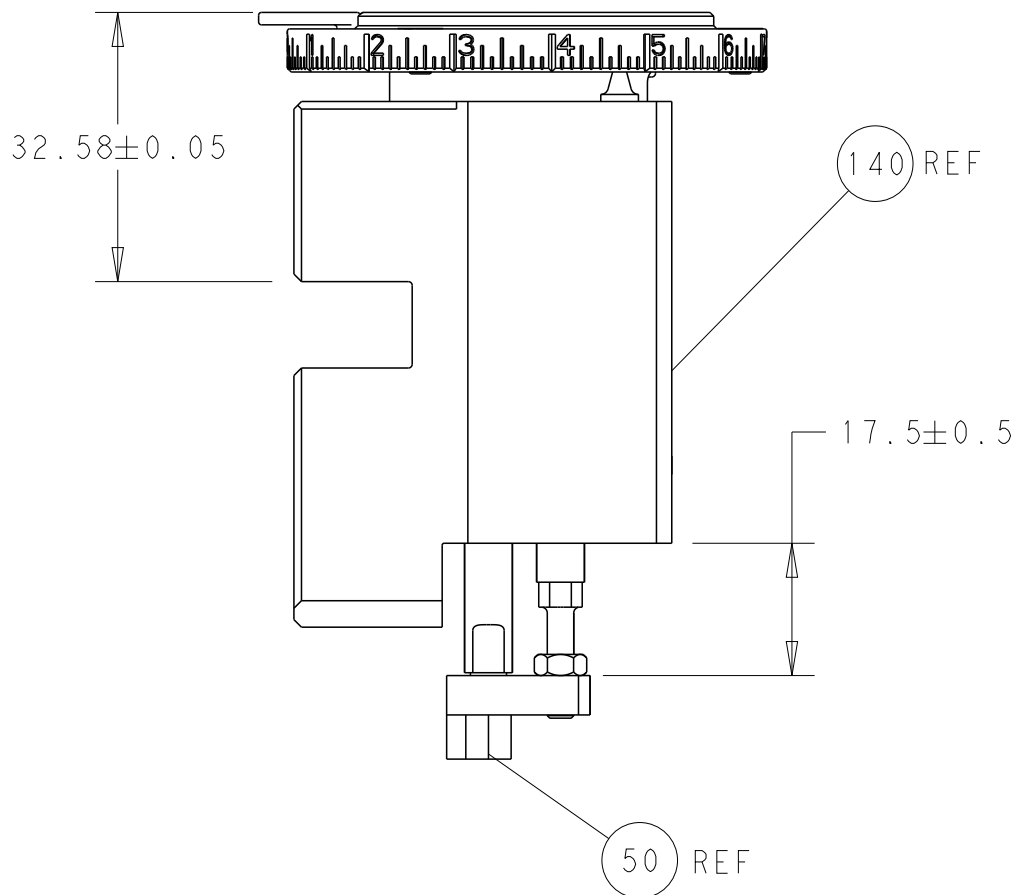
PACIFIC VERSION
Shown on sheets 3 of 4 & 4 of 4
(Atlantic version shown on sheets 1 of 4 & 2 of 4)

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

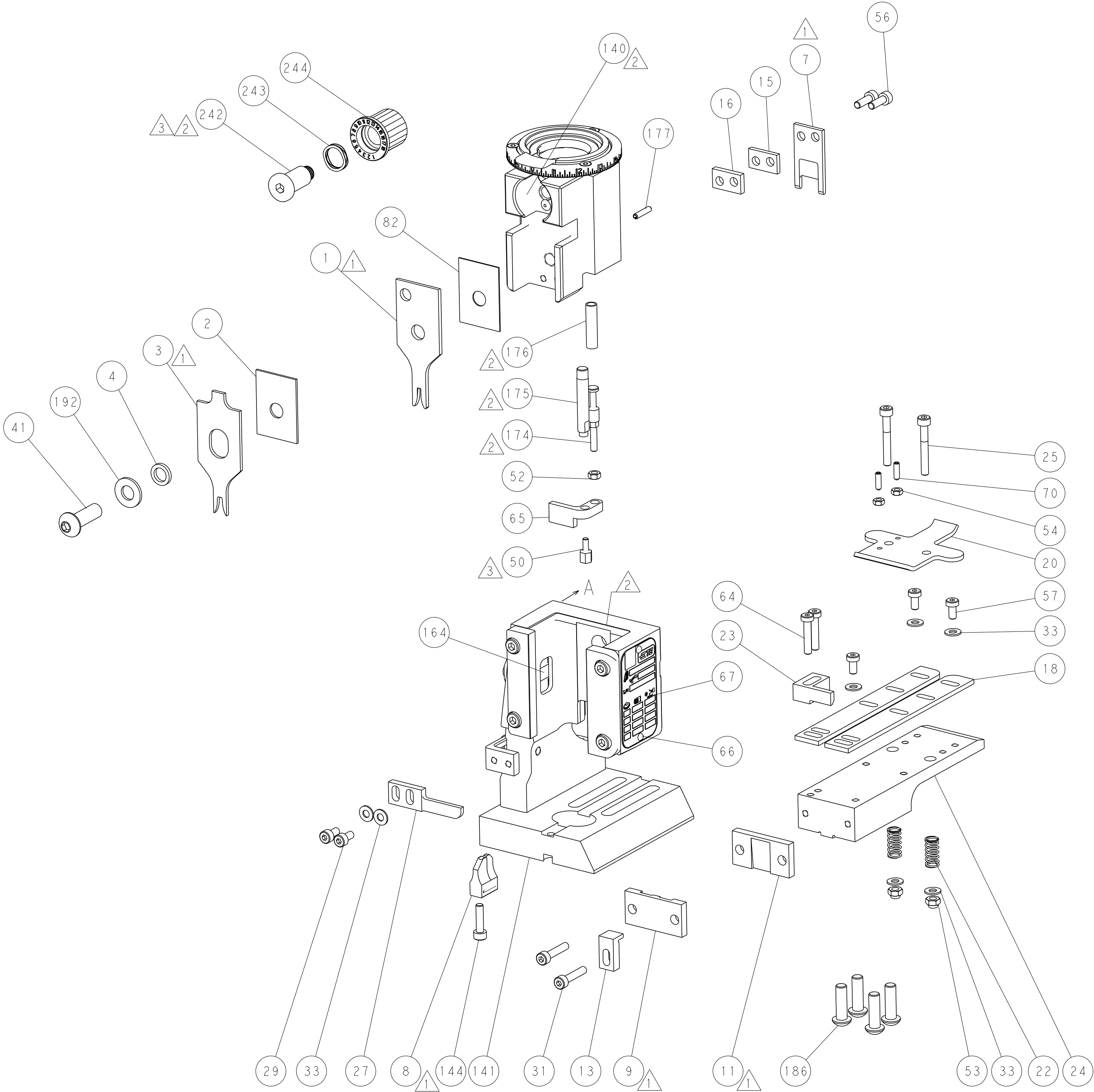
3	-	1	2119082-4	CAM, SNAIL, INSULATION ADJUSTMENT	244
	-	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
	-	1	2119083-1	RETAINER, INSULATION DIAL	242
	-	1	2844940-3	AIR FEED MODULE	238
	-	1	1-18028-0	WASHER, FLAT, REG M8	192
	-	4	2079383-9	SCR, BHSC, RoHS (M6 X 20)	186
	-	1	6-993111-6	PIN, SLOTTED 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	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	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57	
-	2	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	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	2063961-9	FEED FINGER	51	
3	-	1	1752354-8	STANDOFF,HOLD-DOWN	50
-	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	240639-1	STRIPPER (MACHINING)	27	
-	2	1-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 30	25	
-	1	1-1752371-2	PLATE, STRIP GUIDE	24	
-	1	240825-7	PLATE, STRIP HOLD DOWN	23	
-	2	2-22281-3	SPRING, COMPRESSION	22	
-	1	1803292-4	DRAG	20	
-	2	1901259-5	GUIDE, LOWER STRIP	18	
-	1	3-240641-0	SPACER	16	
-	1	240641-2	SPACER	15	
-	1	1752360-1	SPACER,HOLD-DOWN	13	
1	-	1	240644-5	PLATE, REAR SHEAR	11
-	-	-	-	10	
1	-	1	6-690482-0	PLATE, FRONT SHEAR	9
1	1	1	1-1333216-2	ANVIL, COMBINATION	8
1	-	1	690474-5	BLADE, SLUG	7
-	-	-	-	5	
-	1	238011-7	BLOCK, CRIMPER SPACER	4	
1	1	1	2119582-1	CRIMPER, INSULATION F PREMIUM	3
-	1	1	1-455888-0	SPACER, CRIMPER	2
1	1	1	3-456405-4	CRIMPER, WIRE PREMIUM	1

- 77-22		PART NO	DESCRIPTION		ITEM NO
DWN L.ZHANG 03JUL2012		TE Connectivity Harrisburg, PA 17105-3608			
CHK L.ZHANG 03JUL2012		NAME		Ocean End Feed Applicator	
APVD S.XI 03JUL2012		PRODUCT SPEC			
		APPLICATION SPEC			
		SIZE		CAGE CODE	
		DRAWING NO		RESTRICTED TO	
		WEIGHT		A1 00779 ©=2150039	
Customer Accessible Production Drawing		SCALE		1:1 SHEET 3 OF 4	
				REV D1	

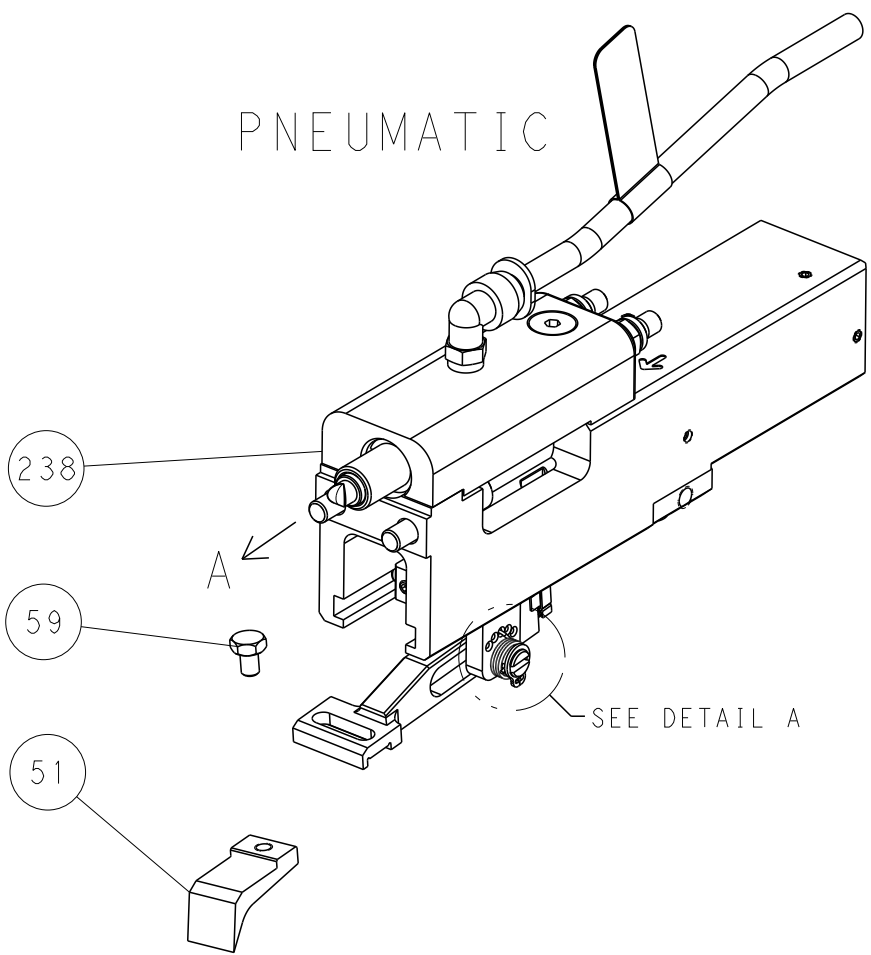
LOC	DIST	REVISIONS					
		P	LTR	DESCRIPTION	DATE	DWN	APVD
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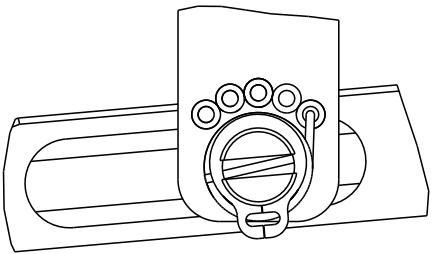
RAM AND HOLDDOWN SET-UP



FEED TYPE

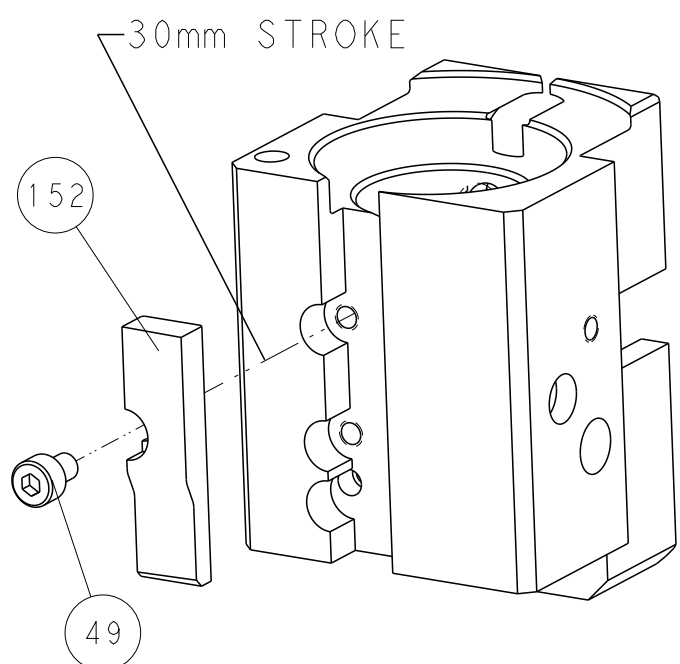


FEED SPRING SETTING POSITION



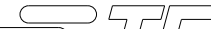
DETAIL A

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)

THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION IT IS SUBJECT TO COMPANY CONTROL AND END-USERING ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST VERSION.				DWN	L. ZHANG	03JUL2012	 TE Connectivity Harrisburg, PA 17105-3608			
				CHK	L. ZHANG	03JUL2012				
				APVD	S. XI	03JUL2012	NAME			
				PRODUCT SPEC			Ocean End Feed Applicator			
				APPLICATION SPEC						
				WEIGHT			RESTRICTED TO			
				Customer Accessible Production Drawing			REV D1			

Mouser Electronics

Authorized Distributor

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[TE Connectivity:](#)

[2-2150039-2](#)