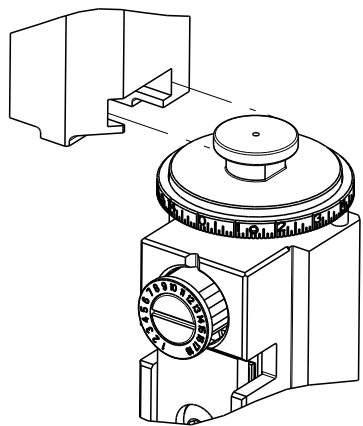


8		7	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150565-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2150565-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150565-1	C	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2150565-2	C	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150565-7	A	CRIMP TOOLING KIT	-



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.78 mm [.070]	F
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: TERMINAL, RECEPTACLE, .110 SERIES-FASTON			
WIRE STRIP LENGTH 5.21-5.97 mm [.205-.235 IN]		INSULATION DIAMETER RANGE Ø1.00-2.00 mm [.039-.079 IN]	
TERMINAL APPLICATION  (A)114-2036		- -	
SPECIFICATION (B)114-35000		- -	
TERMINALS APPLIED 			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
(A) 61457-1	(A) 61457-2	(A) 61457-3	(B) 41500
(B) 63471-1			

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING
16 AWG		1.50+/-0.05 [1.059+/- .002]		4.1
18 AWG		1.24+/-0.05 [1.049+/- .002]		6.9
20 AWG		1.14+/-0.05 [1.045+/- .002]		7.9



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 ITEM 180.
 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.

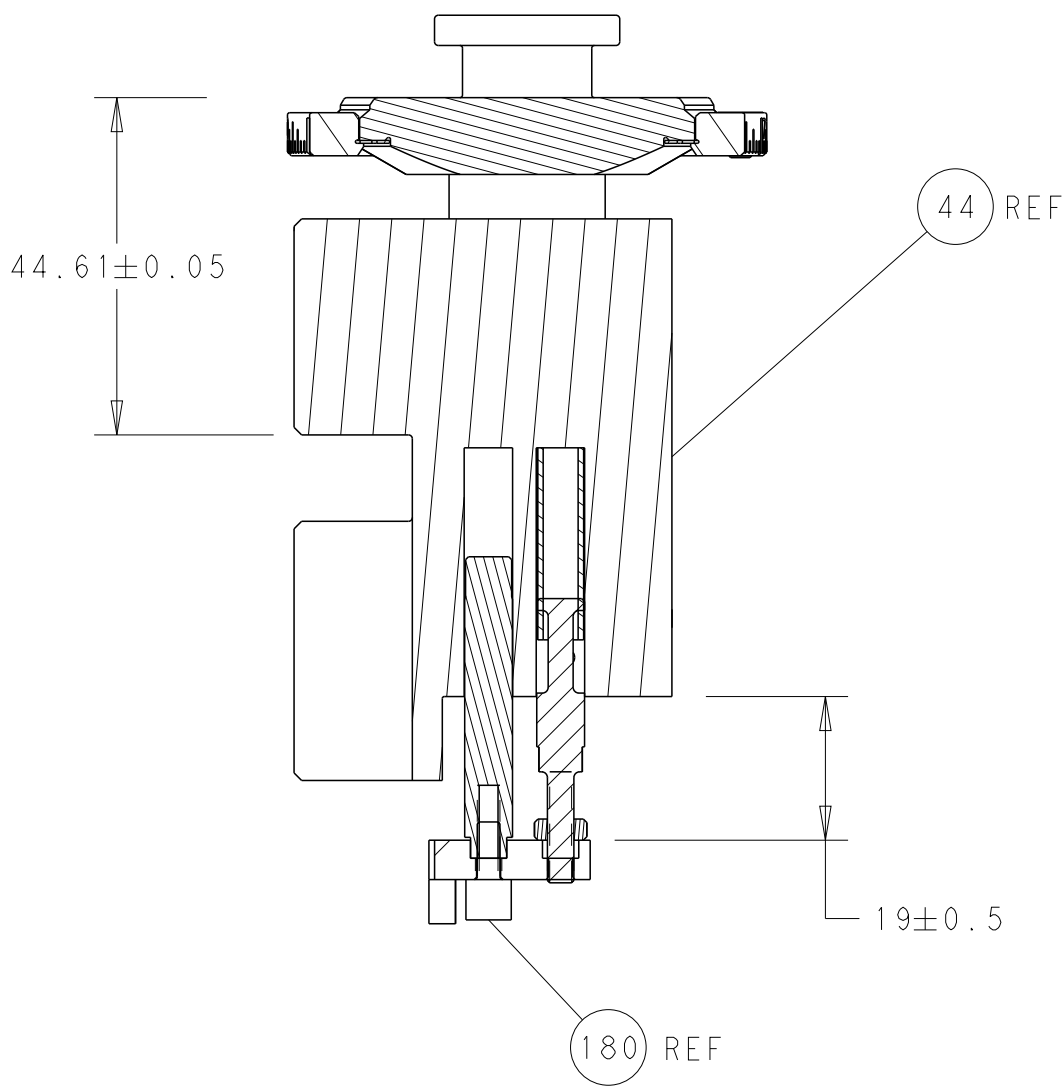
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

2				1			
LOC	DIST	REVISIONS					
A	66	P	LTR	DESCRIPTION	DATE	OWN	APVD
		A		RELEASED	18MAY2017	LG	GB
		B		ECR-18-002107	12FEB2018	TB	GB
		C		ECR-21-003458	21MAR2021	TB	RK

	-	1	-	1	2119641-1	FEED CAM, AIR FEED	248
	-	-	1	-	2119580-1	MECHANICAL FEED ASSEMBLY	239
	-	1	-	1	2844940-3	AIR FEED MODULE	238
3	-	1	1	1	1752354-6	STANDOFF,HOLD-DOWN	180
	-	1	1	1	6-993111-6	PIN, SLOTTED SPRING 3.0 X 14.0	177
	-	1	1	1	8-22280-7	SPRING, COMPRESSION	176
	-	1	1	1	1752353-2	GUIDE PIN,HOLDDOWN	175
	-	1	1	1	1901680-2	GUIDE PIN,HOLDDOWN	174
	-	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
5	-	1	1	1	2119955-2	ASSY, LUBRICATOR, END FEED	84
	-	1	1	1	455888-8	SPACER, CRIMPER	82
	-	1	1	1	2119791-9	DEPRESSOR, WIRE	73
	-	1	1	1	1803607-4	DOCUMENTATION PACKAGE	71
	-	2	2	2	2-18032-2	SCR, SET, FLT PNT, M3 X 10.0	70
	-	1	1	1	2119943-1	WASHER, SPACER	69
	-	1	1	1	2119740-1	TAG,IDENTIFICATION	67
	-	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
	-	1	1	1	1-1901681-8	HOLDDOWN, TERMINAL	65
	-	2	2	2	2168400-5	SHCS, LOW HEAD, RoHS, M4 X 20	64
	-	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	60
	-	1	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
	-	-	1	-	2063961-1	FEED FINGER	58
	-	3	3	3	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57
	-	2	2	2	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	56
	-	2	2	2	5018030-1	NUT, HEX, REG, RoHS, M3	54
	-	2	2	2	986965-8	NUT, LOCK, HEX, TORQUE (M4)	53
	-	1	1	1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52
	-	1	-	1	2063961-9	FEED FINGER	51
	-	1	2	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49
	-	-	1	-	2119652-1	FEED CAM, PRE FEED	48
	-	-	1	-	2119653-1	FEED CAM, POST FEED	47
	-	1	1	1	2119655-5	APPLICATOR BASIC ASSEMBLY, EF	46
	-	1	1	1	1803517-1	RAM ASSEMBLY, EF ATLANTIC	44
	-	1	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
	-	7	7	7	1-18028-2	WASHER, FLAT, REG M4	33
	-	2	2	2	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	31
	-	2	2	2	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	29
	-	1	1	1	240639-4	STRIPPER (MACHINING)	27
	-	2	2	2	1-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 30	25
	-	1	1	1	1752371-1	PLATE, STRIP GUIDE	24
	-	1	1	1	240825-7	PLATE, STRIP HOLD DOWN	23
	-	2	2	2	22281-8	SPRING, COMPRESSION	22
	-	1	1	1	1803292-4	DRAG	20
	-	1	1	1	1803152-3	STRIP GUIDE, REAR	19
	-	1	1	1	1803151-3	STRIP GUIDE, FRONT	18
	-	4	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17
	-	1	1	1	5-240641-4	SPACER	16
1	-	1	1	1	240833-7	PLATE, REAR SHEAR	11
	-	-	-	-	-	-	10
1	-	1	1	1	690482-9	PLATE, FRONT SHEAR	9
1	1	2	2	1	1-1803002-4	ANVIL, COMBINATION, END FEED	8
1	-	1	1	1	2217206-1	BLADE, SLUG	7
	-	1	1	1	1803203-1	BLOCK, FRONT DEPRESSOR	6
	-	1	1	1	5-240641-4	SPACER	5
	-	-	-	-	-	-	4
	-	-	-	-	-	-	3
	-	-	-	-	-	-	2
1	1	2	2	1	1803482-5	CRIMPER, WIRE	1
-77-72	-71	-2	-1	PART NO	DESCRIPTION	ITEM NO	

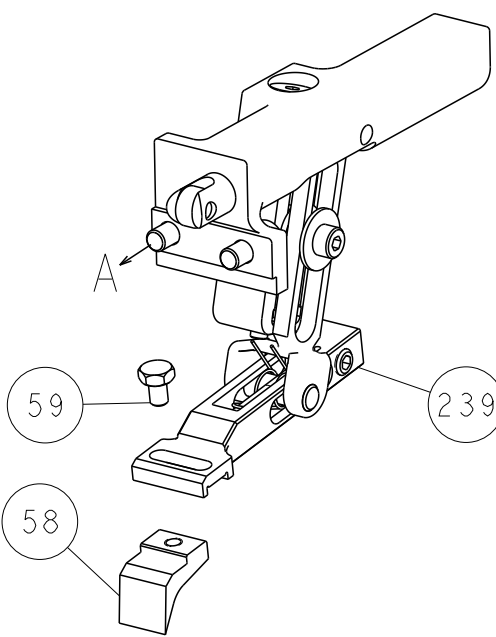
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LOC	DIST	REVISIONS					
		P	LTR	DESCRIPTION	DATE	DWN	APVD
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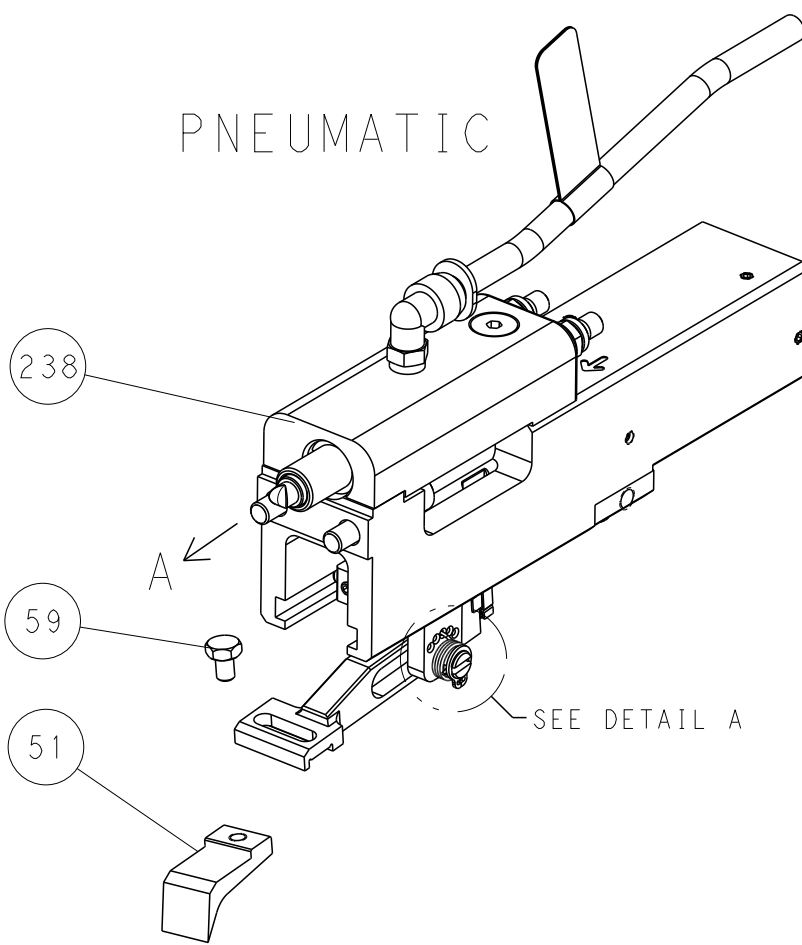


RAM AND HOLDDOWN SET-UP

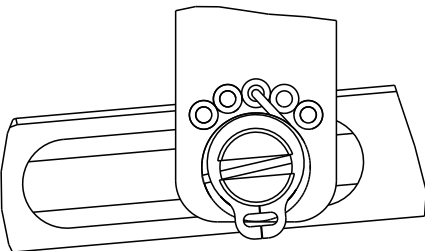
FEED TYPE
MECHANICAL



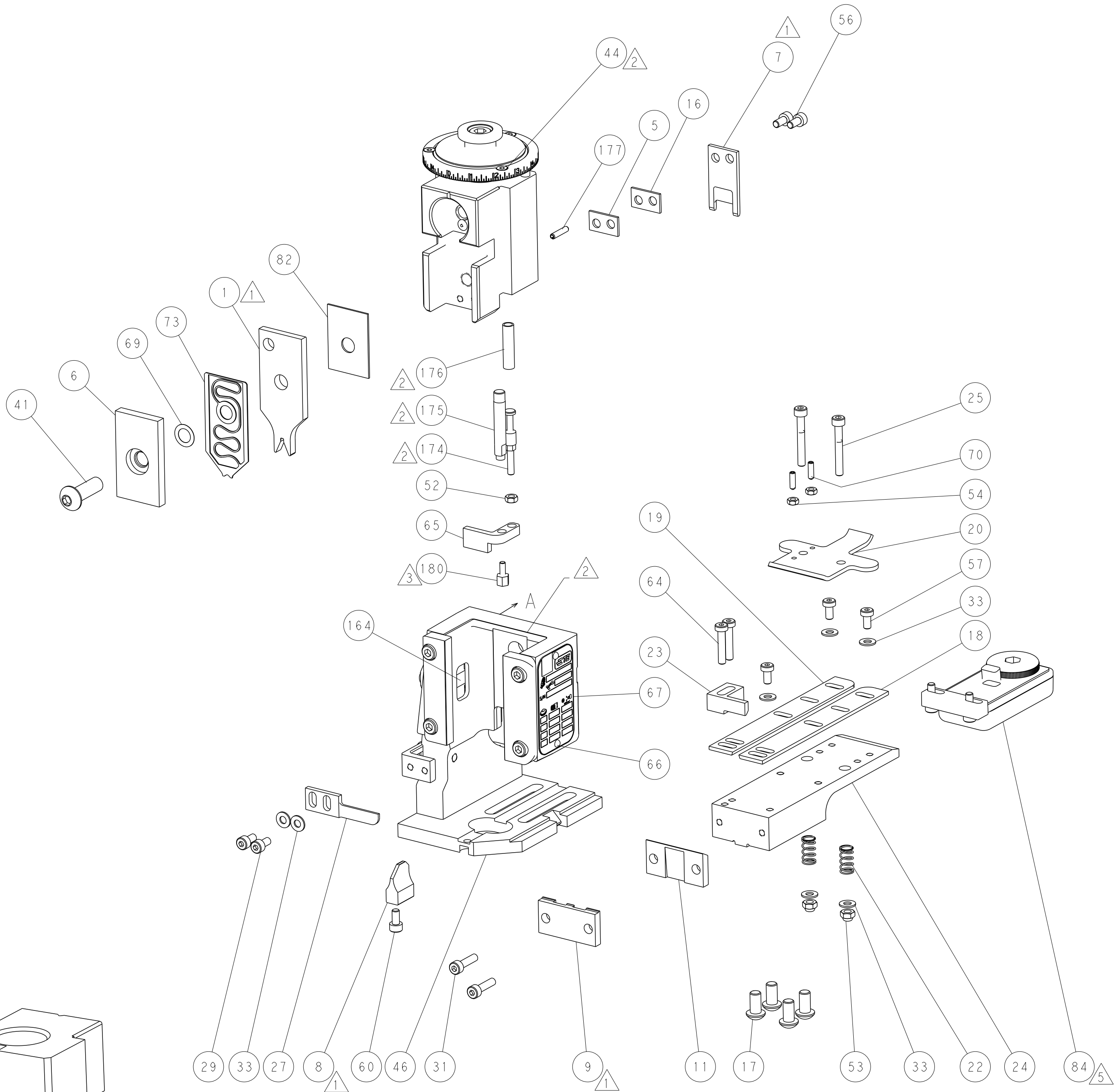
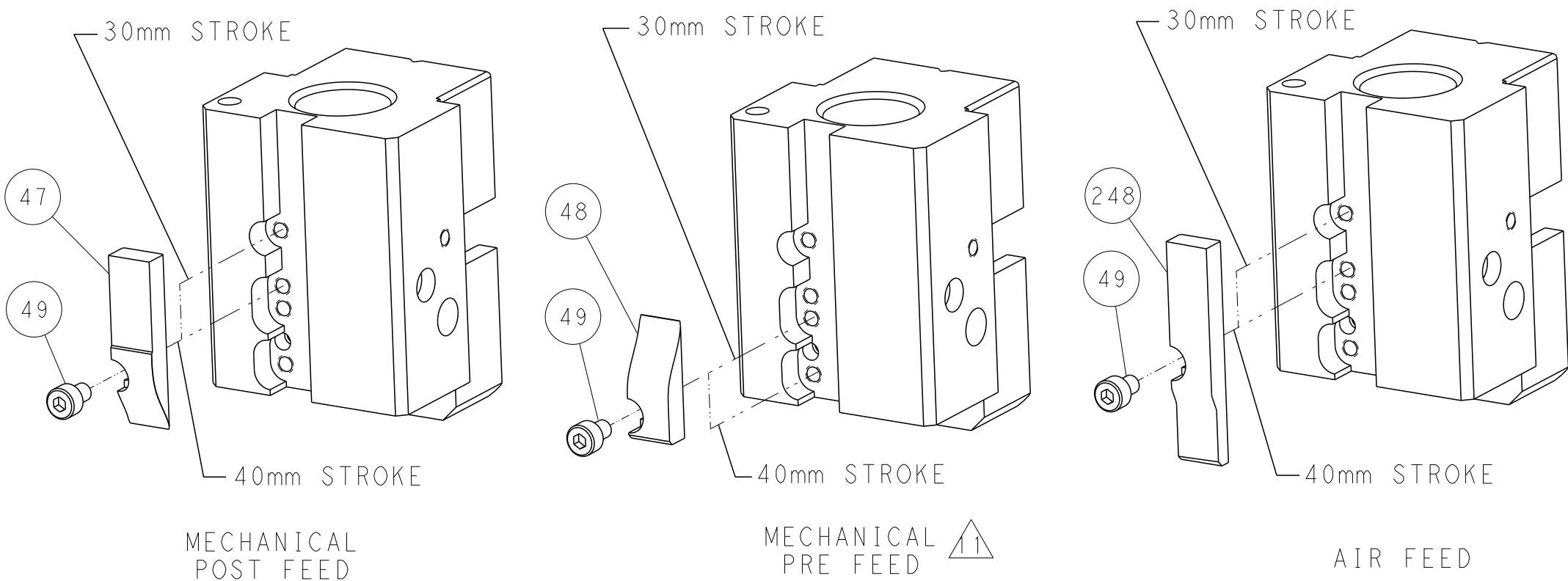
PNEUMATIC



FEED SPRING
SETTING POSITION



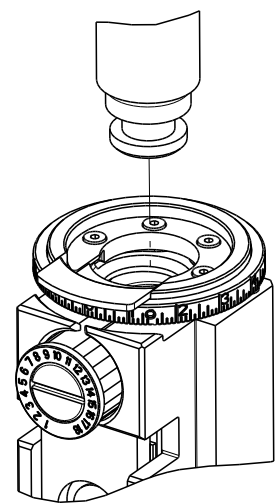
CAM POSITIONS



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 THE RESPONSIBILITY OF THE USER TO VERIFY THE LATEST REVISIONS.				DWN X.ZHAO 18AUG2015				TE Connectivity			
CHK L.ZHANG 18AUG2015				NAME				Ocean End Feed			
APVD J.GUO 18AUG2015				PRODUCT SPEC				Applicator			
APPLICATION SPEC				SIZE				CAGE CODE			
MATERIAL				WEIGHT				DRAWING NO			
Customer Accessible Production Drawing				SCALE				REV			

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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	
2-2150565-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL	
2-2150565-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	
7-2150565-7	A	CRIMP TOOLING KIT	-	



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.78 mm [.070]	F
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: TERMINAL, RECEPTACLE, .110 SERIES-FASTON			
WIRE STRIP LENGTH 5.21-5.97 mm [.205-.235 IN]		INSULATION DIAMETER RANGE Ø1.00-2.00 mm [.039-.079 IN]	
TERMINAL APPLICATION 		(A) 114-2036	
SPECIFICATION		(B) 114-35000	
TERMINALS APPLIED 			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
(A) 61457-1	(A) 61457-2	(A) 61457-3	(B) 41500
(B) 63471-1			

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING
16 AWG		1.50+/-0.05 [0.059+/-0.002]		4.1
18 AWG		1.24+/-0.05 [0.049+/-0.002]		6.9
20 AWG		1.14+/-0.05 [0.045+/-0.002]		7.9



*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.

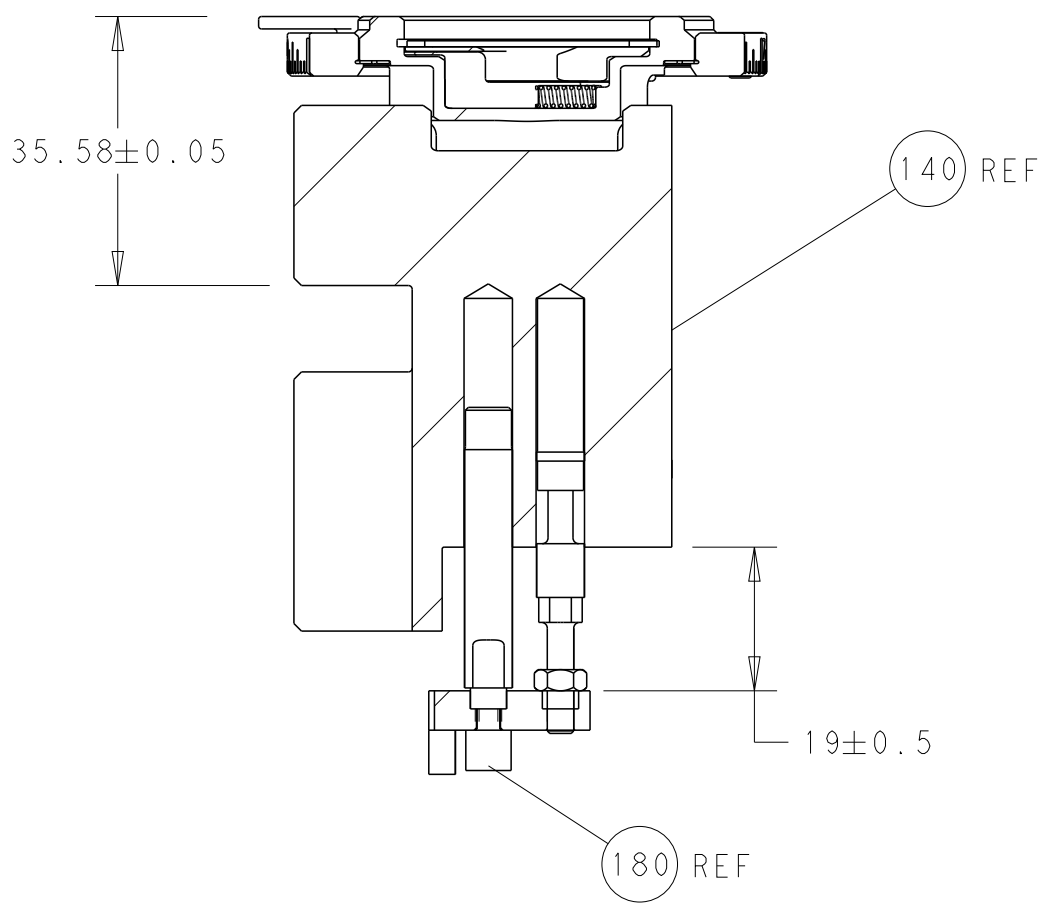
PACIFIC VERSION
(Atlantic version shown on sheets 1 of 4 & 2 of 4)
Shown on sheets 3 of 4 & 4 of 4

[illegible]

	-	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
	-	1	-	2844940-3	AIR FEED MODULE	238
	-	4	4	2079383-9	SCR, BHSC, RoHS (M6 X 20)	186
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
	-	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	1	2119955-2	ASSY, LUBRICATOR, END FEED	84
	-	1	1	455888-8	SPACER, CRIMPER	82
	-	1	1	2119791-9	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	2119943-1	WASHER, SPACER	69
	-	1	1	2119740-1	TAG,IDENTIFICATION	67
	-	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
	-	1	1	1-1901681-8	HOLDDOWN, TERMINAL	65
	-	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	2063961-1	FEED FINGER	58
	-	3	3	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	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52
	-	1	-	2063961-9	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	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	31
	-	2	2	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	29
	-	1	1	240639-4	STRIPPER (MACHINING)	27
	-	2	2	1-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 30	25
	-	1	1	1752371-1	PLATE, STRIP GUIDE	24
	-	1	1	240825-7	PLATE, STRIP HOLD DOWN	23
	-	2	2	22281-8	SPRING, COMPRESSION	22
	-	1	1	1803292-4	DRAG	20
	-	1	1	1803152-3	STRIP GUIDE, REAR	19
	-	1	1	1803151-3	STRIP GUIDE, FRONT	18
	-	1	1	5-240641-4	SPACER	16
△	-	1	1	240833-7	PLATE, REAR SHEAR	11
	-	-	-	-	-	10
△	-	1	1	690482-9	PLATE, FRONT SHEAR	9
△	1	1	1	1-1803002-4	ANVIL, COMBINATION, END FEED	8
△	-	1	1	2217206-1	BLADE, SLUG	7
	-	1	1	1803203-1	BLOCK, FRONT DEPRESSOR	6
	-	1	1	5-240641-4	SPACER	5
	-	-	-	-	-	4
	-	-	-	-	-	3
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i	1	1	1	1803482-5	CRIMPER, WIRE	1
	-77-22-21			PART NO	DESCRIPTION	ITEM NO

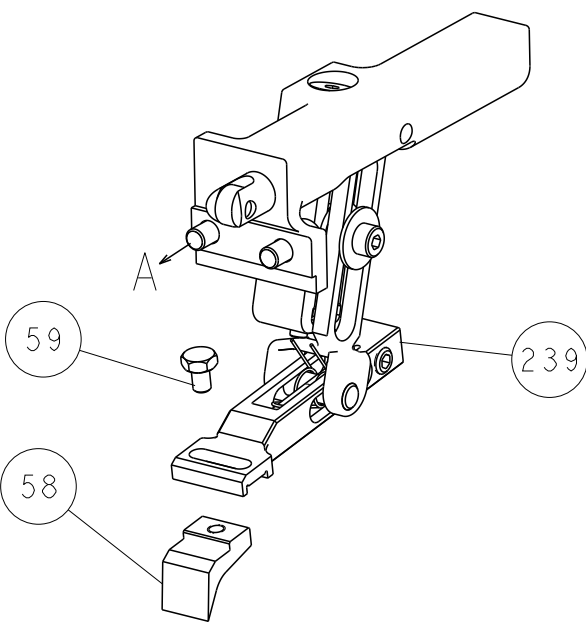
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LOC		DIST		REVISIONS			
A	66	P	LTR	DESCRIPTION	DATE	DWN	APVD
		-		SEE SHEET 1	-	-	-

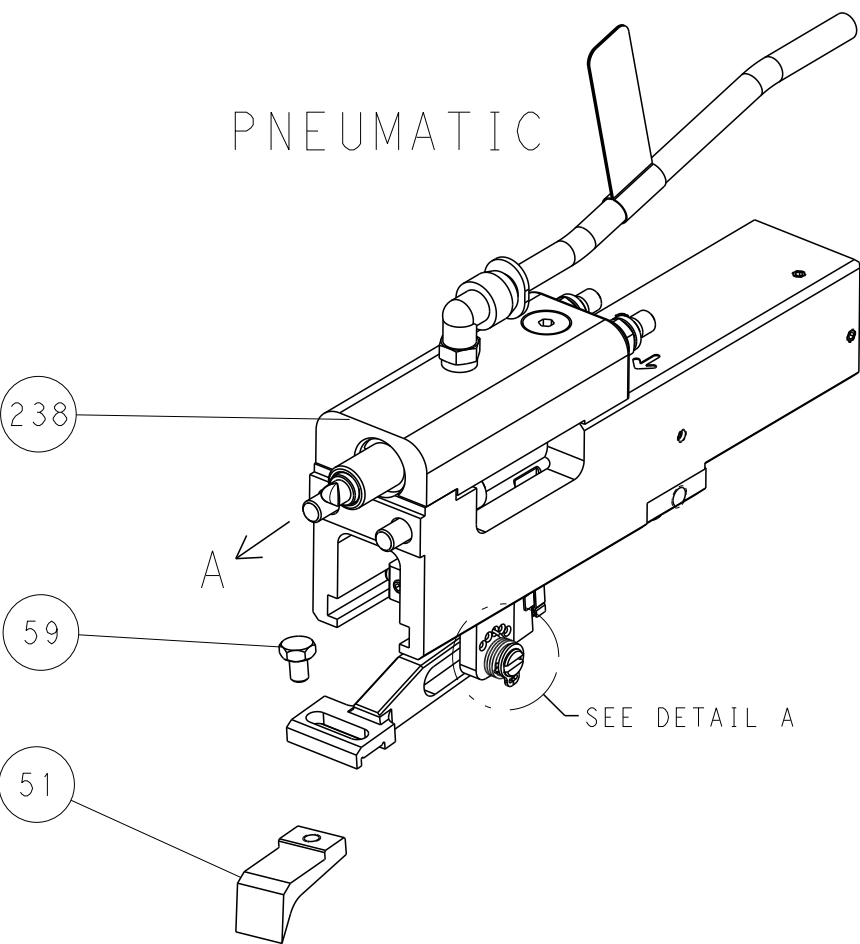


RAM AND HOLDDOWN SET-UP

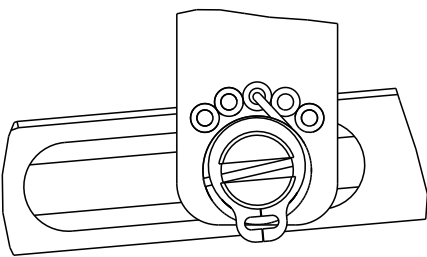
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MECHANICAL



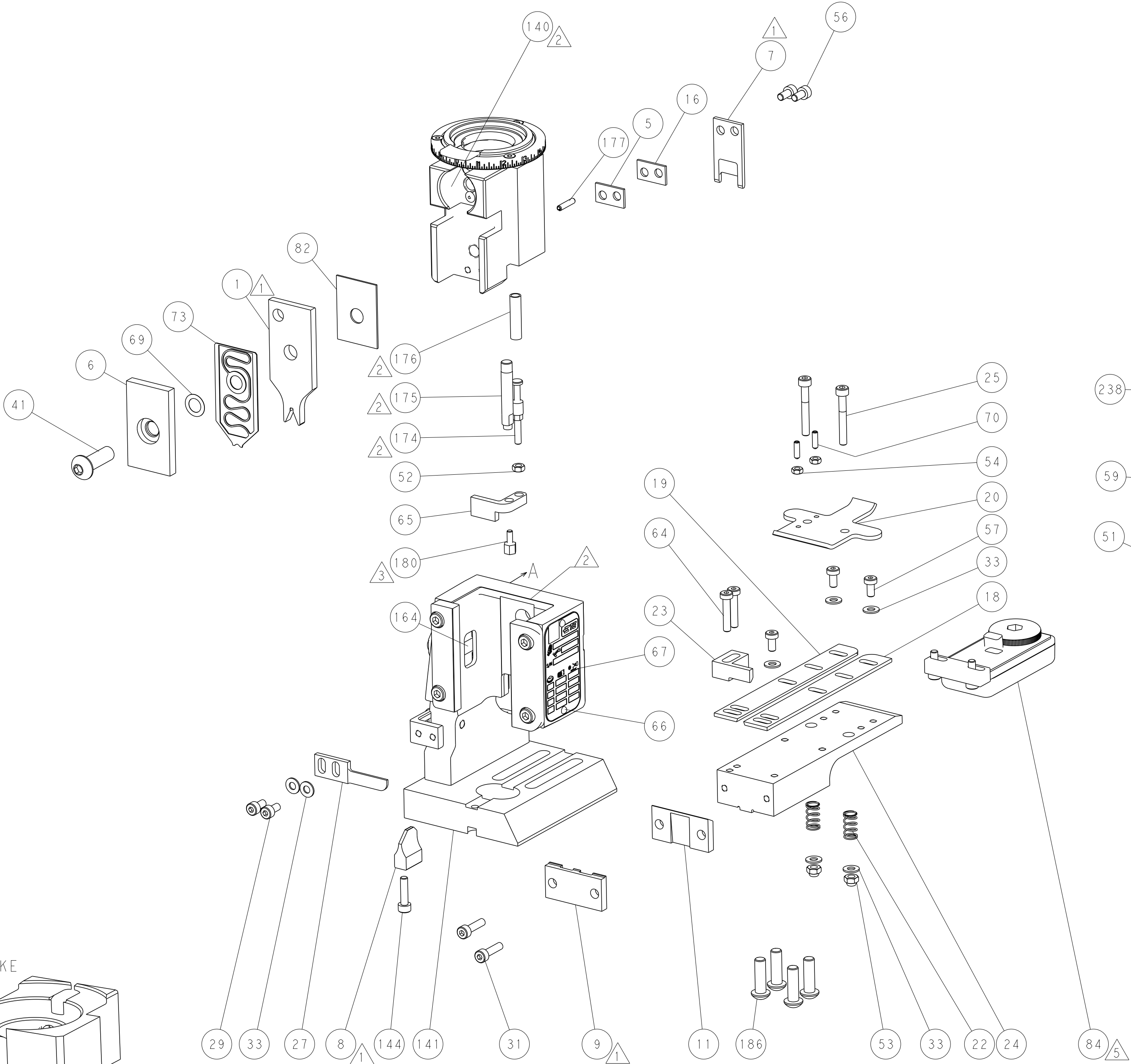
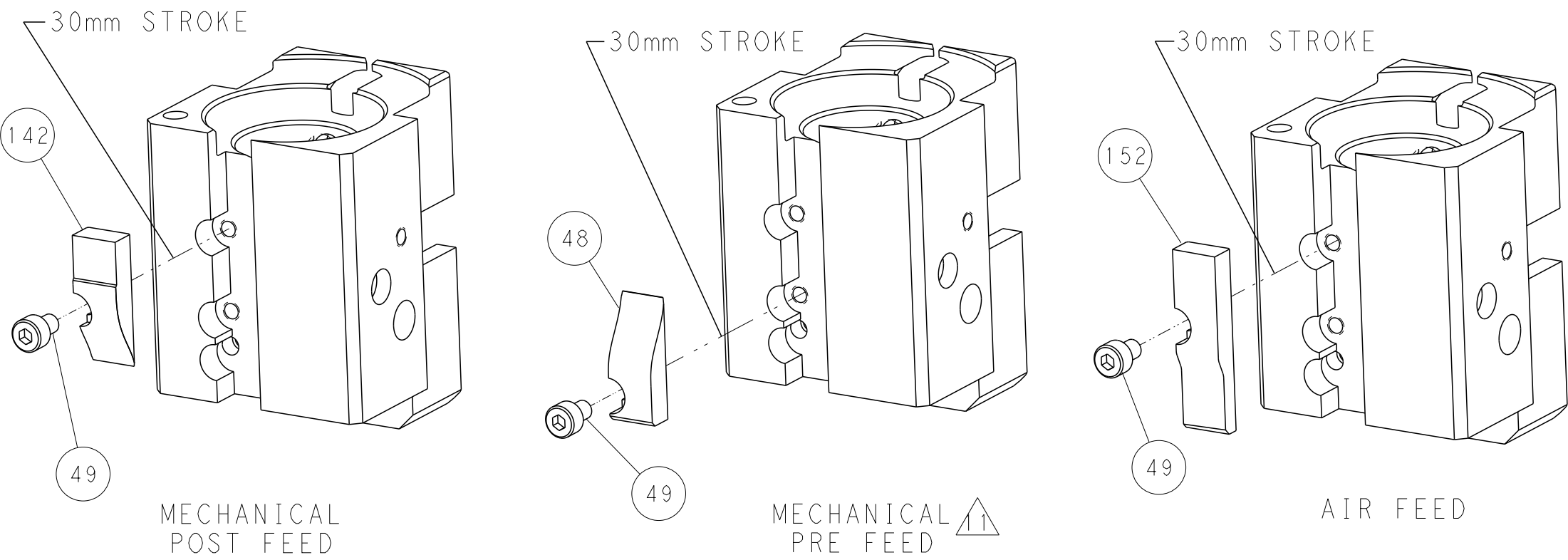
PNEUMATIC



FEED SPRING
SETTING POSITION



CAM POSITIONS



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

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				CHK	L. ZHAGN	18AUG2015		
				APVD	J. GUO	18AUG2015	NAME	
				PRODUCT SPEC			Ocean End Feed Applicator	
				APPLICATION SPEC			-	
				SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO	
				A1	00779	C=2150565	-	
				Customer Accessible Production Drawing			SCALE	1:1
							SHEET	4
							OF	4
							REV	C

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[2150565-1](#)