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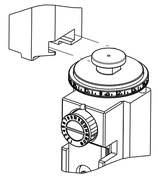
LOC	DIST
A	66

REVISIONS

P	LTR	DESCRIPTION	DATE	DWN	APVD
	A	RELEASED	01MAR2018	BW	TE
	B	ECR-22-133092	18MAR2022	JWC	RK
	C	ECR-23-184142	14AUG2023	JWC	GB

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150878-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2150878-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150878-1	C	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2150878-2	C	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150878-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.54 mm [.100]	F
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION
TERMINAL NAME: BRUSH CONTACT		
WIRE STRIP LENGTH 5.34-6.10 mm [.210-.240 IN]		INSULATION DIAMETER RANGE ∅2.20-3.00 mm [.087-.118 IN]
TERMINAL APPLICATION SPECIFICATION	114-2093	- -
	-	- -

TERMINALS APPLIED 5

TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
60812-1	60812-2		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING 4
14 AWG	2.18+/-0.05 [.086+/-.002]	4.7
16 AWG	1.93+/-0.05 [.076+/-.002]	7.5
18 AWG	1.75+/-0.05 [.069+/-.002]	9.5

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.

*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)

					PART NO	DESCRIPTION	ITEM NO
	-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248
	-	-	1	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
	-	1	-	1	-	2844940-3	AIR FEED MODULE	238
3	-	1	1	1	1	1-1752354-1	STANDOFF,HOLD-DOWN	180
	-	1	1	1	1	6-993111-6	PIN, SLOTTED SPRING 3.0 X 14.0	177
	-	1	1	1	1	8-22280-7	SPRING, COMPRESSION	176
	-	1	1	1	1	1752353-2	GUIDE PIN,HOLDDOWN	175
	-	1	1	1	1	1901680-2	GUIDE PIN,HOLDDOWN	174
	-	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	455888-4	SPACER, CRIMPER	82
	-	1	1	1	1	2119791-6	DEPRESSOR, WIRE	73
	-	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	2119943-1	WASHER, SPACER	69
	-	1	1	1	1	2119740-1	TAG,IDENTIFICATION	67
	-	2	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
	-	1	1	1	1	2-1901681-9	HOLDDOWN, TERMINAL	65
	-	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	2063961-1	FEED FINGER	58
	-	4	4	4	4	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57
	-	2	2	2	2	2168083-5	SCR, SKT HD CAP, RoHS, M4 X 6.0	56
	-	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	1	1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52
	-	1	-	1	-	1-2063961-0	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
	-	8	8	8	8	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	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	29
	-	1	1	1	1	240639-2	STRIPPER (MACHINING)	27
	-	2	2	2	2	1-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 30	25
	-	1	1	1	1	3-1752371-6	PLATE, STRIP GUIDE	24
	-	2	2	2	2	2-22281-3	SPRING, COMPRESSION	22
	-	1	1	1	1	1803292-9	DRAG	20
	-	1	1	1	1	9-1901696-1	STRIP GUIDE, REAR	19
	-	1	1	1	1	9-1901695-4	STRIP GUIDE, FRONT	18
	-	4	4	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17
1	-	1	1	1	1	1752360-1	SPACER,HOLD-DOWN	13
	-	1	1	1	1	240644-1	PLATE, REAR SHEAR	11
1	-	2	2	2	2	240645-3	SPACER, SHEAR PLATE	10
1	-	1	1	1	1	240642-1	PLATE, FRONT SHEAR	9
1	1	2	2	1	1	1803690-1	ANVIL, COMBINATION, END FEED	8
	-	1	1	1	1	1803366-9	BLADE, SLUG -	7
	-	1	1	1	1	1803203-1	BLOCK, FRONT DEPRESSOR	6
	-	1	1	1	1	240641-9	SPACER	5
	-	-	-	-	-	-	-	4
	-	-	-	-	-	-	-	3
	-	1	1	1	1	2-455888-2	SPACER, CRIMPER	2
1	1	2	2	1	1	2-1803482-0	CRIMPER, WIRE	1

THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION IT IS SUBJECT TO CHANGE AND THE CONTACTING ENGINEERING ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST REVISION

DIMENSIONS: mm

TOLERANCES UNLESS OTHERWISE SPECIFIED:
0 PLC ±-
1 PLC ±-
2 PLC ±-
3 PLC ±-
4 PLC ±-
ANGLES ±-

MATERIAL -
FINISH - -

DWN B. WEAVER 09JAN2018
CHK T. ELBIN 09JAN2018
APVD T. ELBIN 09JAN2018
PRODUCT SPEC -
APPLICATION SPEC -
WEIGHT -

TE Connectivity
Harrisburg, PA 17105-3608

NAME Ocean End Feed Applicator -

SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
A1	00779	C-2150878	-

Customer Accessible Production Drawing | SCALE 1:1 | SHEET 1 OF 4 | REV C

SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

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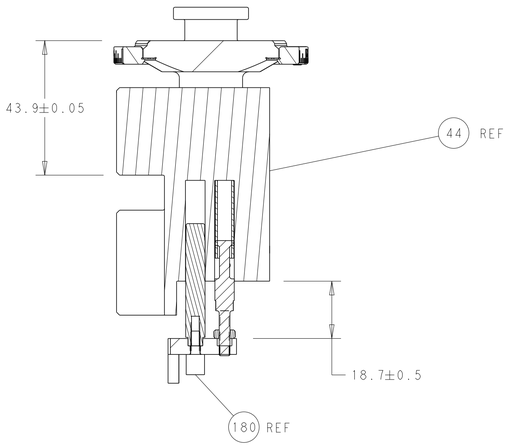
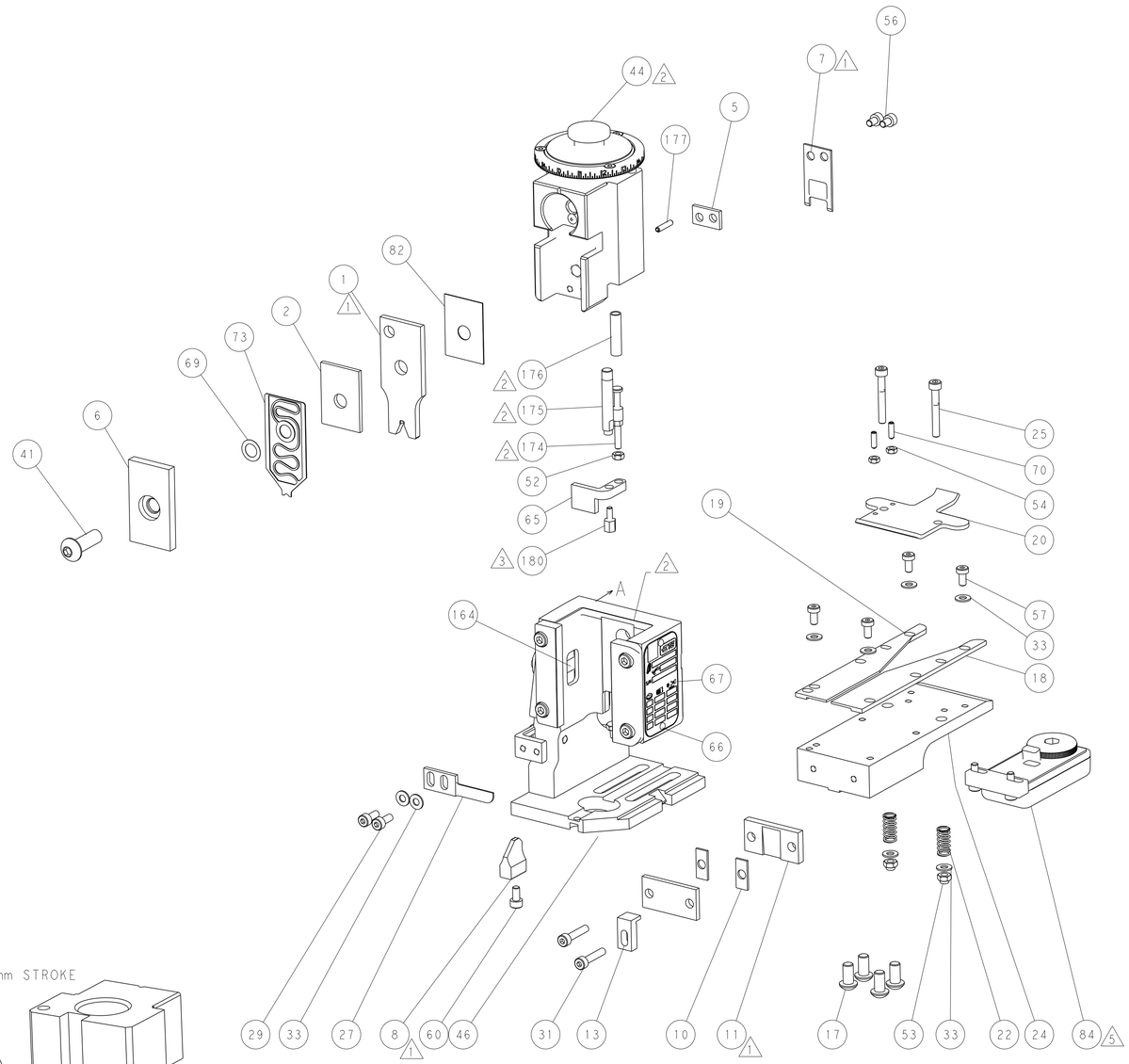
LOC	DIST
A	66

REVISIONS

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

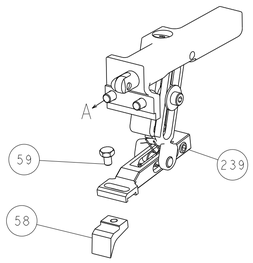


RAM AND HOLDDOWN SET-UP

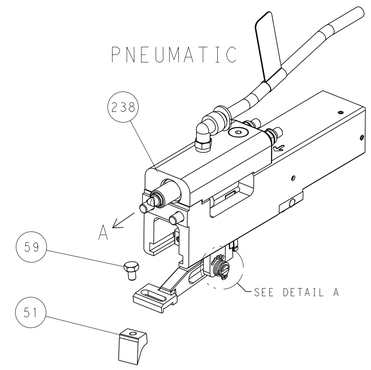


FEED TYPE

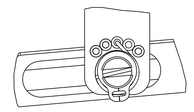
MECHANICAL



PNEUMATIC

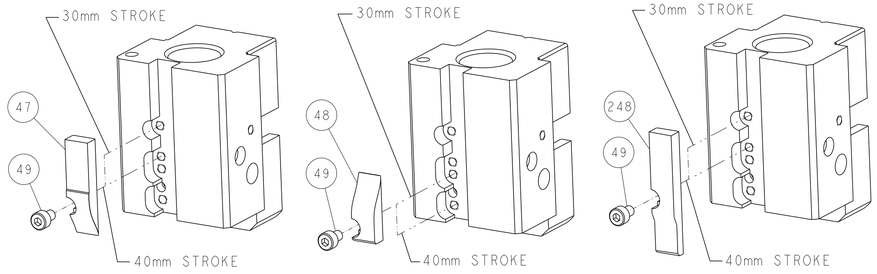


FEED SPRING
SETTING POSITION



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)

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0 PLC ±-
1 PLC ±-
2 PLC ±-
3 PLC ±-
4 PLC ±-
ANGLES ±-

MATERIAL - -
FINISH - -

DWN B. WEAVER 09JAN2018
CHK T. ELBIN 09JAN2018
APVD T. ELBIN 09JAN2018
PRODUCT SPEC -
APPLICATION SPEC -
WEIGHT -

TE Connectivity
Harrisburg, PA 17105-3608

NAME Ocean End Feed Applicator -

SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
A1	00779	C-2150878	-

Customer Accessible Production Drawing | SCALE - 1:1 | SHEET 2 OF 4 | REV C

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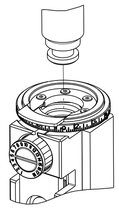
LOC	DIST
A	66

REVISIONS

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

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150878-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2150878-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150878-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.54 mm [.100]	F
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION
TERMINAL NAME: BRUSH CONTACT		
WIRE STRIP LENGTH 5.34-6.10 mm [.210-.240 IN]		INSULATION DIAMETER RANGE ∅2.20-3.00 mm [.087-.118 IN]
TERMINAL APPLICATION SPECIFICATION	114-2093	- -
	-	- -

TERMINALS APPLIED 5

TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
60812-1	60812-2		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING 3
14 AWG	2.18+/-0.05 [.086+/-.002]	4.7
16 AWG	1.93+/-0.05 [.076+/-.002]	7.5
18 AWG	1.75+/-0.05 [.069+/-.002]	9.5

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.
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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.

			-77-22-21 PART NO	DESCRIPTION	ITEM NO
	-	-	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	1-1752354-1	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	-	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	455888-4	SPACER, CRIMPER	82
	-	1	1	2119791-6	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	2-1901681-9	HOLDDOWN, TERMINAL	65
	-	-	2	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
	-	-	1	2063961-1	FEED FINGER	58
	-	4	4	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57
	-	2	2	2168083-5	SCR, SKT HD CAP, RoHS, M4 X 6.0	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	-	1-2063961-0	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
	-	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	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	29
	-	1	1	240639-2	STRIPPER (MACHINING)	27
	-	2	2	1-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 30	25
	-	1	1	3-1752371-6	PLATE, STRIP GUIDE	24
	-	2	2	2-22281-3	SPRING, COMPRESSION	22
	-	1	1	1803292-9	DRAG	20
	-	1	1	9-1901696-1	STRIP GUIDE, REAR	19
	-	1	1	9-1901695-4	STRIP GUIDE, FRONT	18
1	-	1	1	1752360-1	SPACER,HOLD-DOWN	13
	-	1	1	240644-1	PLATE, REAR SHEAR	11
1	-	2	2	240645-3	SPACER, SHEAR PLATE	10
1	-	1	1	240642-1	PLATE, FRONT SHEAR	9
1	1	1	1	1803690-1	ANVIL, COMBINATION, END FEED	8
	-	1	1	1803366-9	BLADE, SLUG -	7
	-	1	1	1803203-1	BLOCK, FRONT DEPRESSOR	6
	-	1	1	240641-9	SPACER	5
	-	-	-	-	-	4
	-	-	-	-	-	3
	-	1	1	2-455888-2	SPACER, CRIMPER	2
1	1	1	1	2-1803482-0	CRIMPER, WIRE	1

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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DIMENSIONS: mm
TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±, 1 PLC ±, 2 PLC ±, 3 PLC ±, 4 PLC ±, ANGLES ±
MATERIAL -
FINISH -

DWN B. WEAVER 09JAN2018
CHK T. ELBIN 09JAN2018
APVD T. ELBIN 09JAN2018
PRODUCT SPEC -
APPLICATION SPEC -
WEIGHT -

TE Connectivity
Harrisburg, PA 17105-3608

NAME Ocean End Feed Applicator -

SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
A1	00779	C-2150878	-

Customer Accessible Production Drawing | SCALE - 1:1 | SHEET 3 OF 4 | REV C

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

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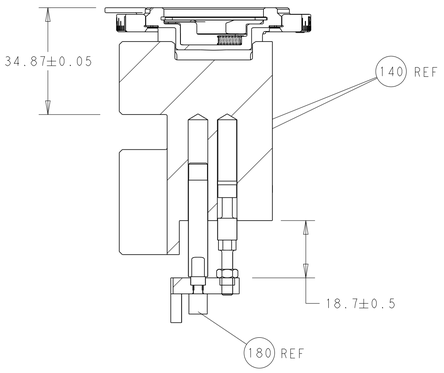
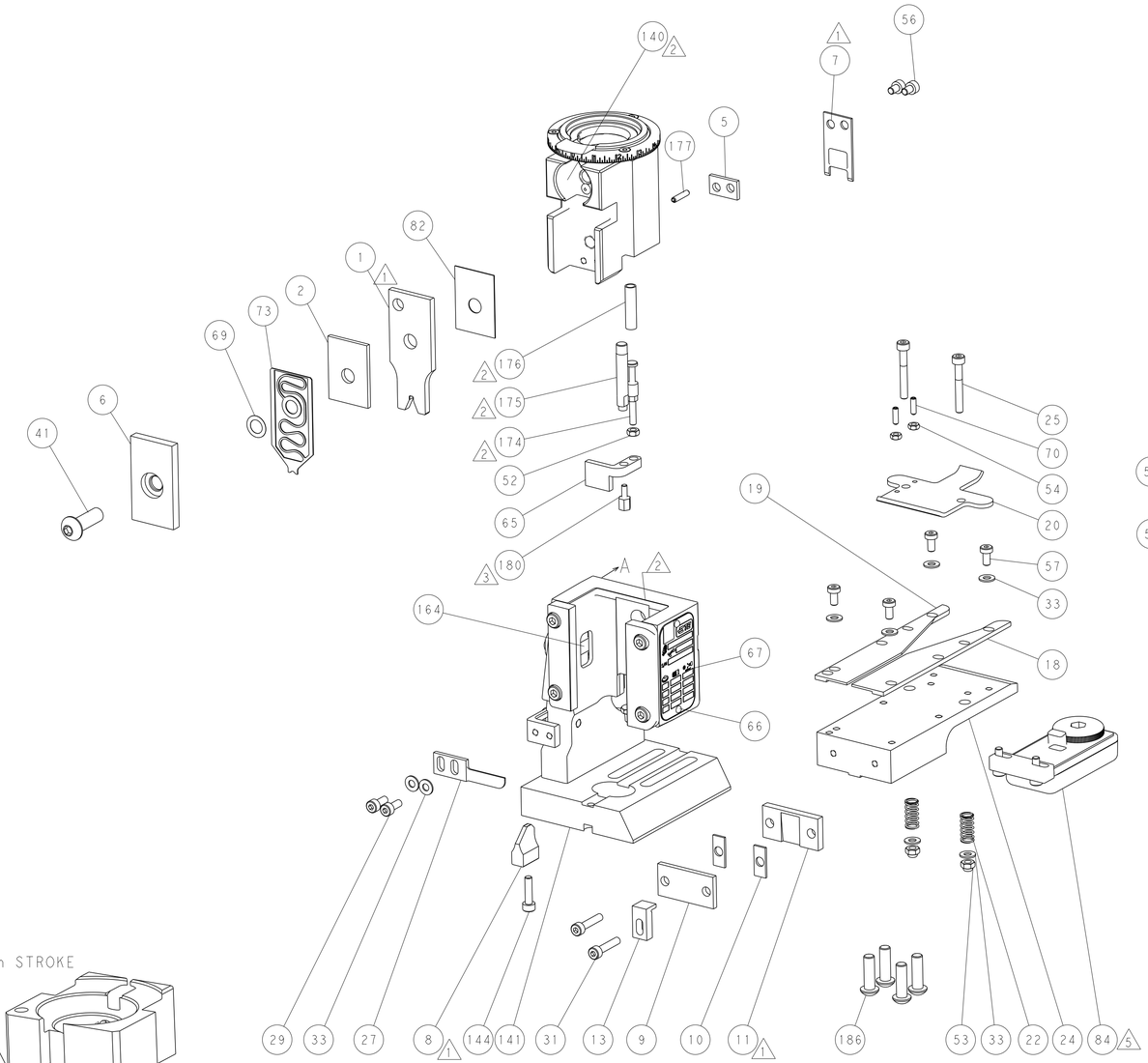
LOC	DIST
A	66

REVISIONS

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

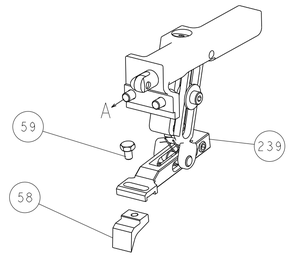


RAM AND HOLDDOWN SET-UP

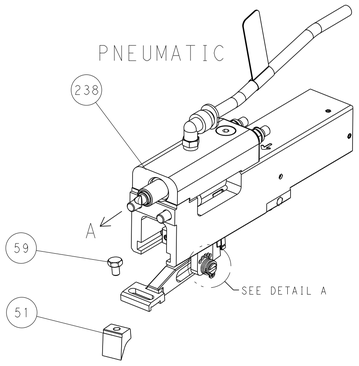


FEED TYPE

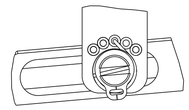
MECHANICAL



PNEUMATIC

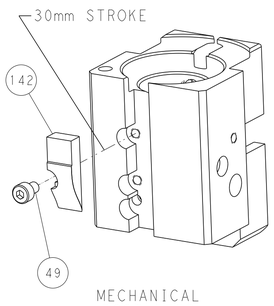


FEED SPRING
SETTING POSITION

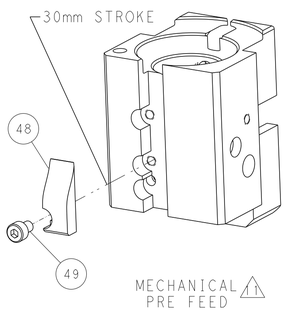


DETAIL A

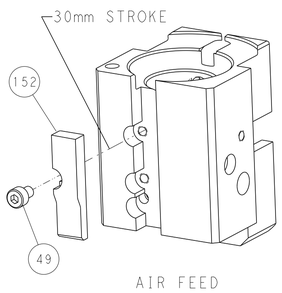
CAM POSITIONS



MECHANICAL
POST FEED



MECHANICAL
PRE FEED 1



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 CHANGE AND THE CONTROLLING ENGINEERING ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST REVISION.

DIMENSIONS: mm

TOLERANCES UNLESS OTHERWISE SPECIFIED:
0 PLC ±-
1 PLC ±-
2 PLC ±-
3 PLC ±-
4 PLC ±-
ANGLES ±-

MATERIAL -
FINISH -

DWN B. WEAVER 09JAN2018
CHK T. ELBIN 09JAN2018
APVD T. ELBIN 09JAN2018
PRODUCT SPEC -
APPLICATION SPEC -
WEIGHT -

TE Connectivity
Harrisburg, PA 17105-3608

NAME Ocean End Feed Applicator -

SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
A1	00779	C-2150878	-

Customer Accessible Production Drawing | SCALE 1:1 | SHEET 4 OF 4 | REV C

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION