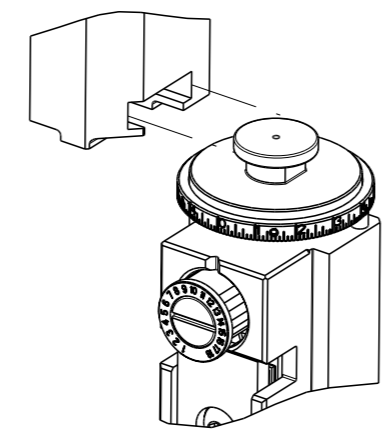


| PART NUMBER | REVISION | DESCRIPTION | FEED TYPE |
|-------------|----------|---------------------------------|-----------|
| 2150319-2 | D | FINE CRIMP HEIGHT ADJUST | PNEUMATIC |
| 7-2150319-2 | D | PNEUMATIC AND CRIMP TOOLING KIT | PNEUMATIC |
| 7-2150319-7 | A | CRIMP TOOLING KIT | - |

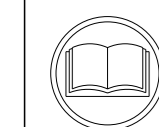
ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



| APPLICATOR DATA | | |
|-----------------------------------|----------------|------|
| CRIMP | SIZE | TYPE |
| WIRE | 2.03 mm [.080] | F |
| INSUL | 2.79 mm [.110] | OV |
| APPLICATOR INSTRUCTIONS 408-35043 | | |

| TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION | | | |
|---|-------------|------------------------------|-------------|
| TERMINAL NAME: .110 SRS FAST-IN-ON TAB. | | | |
| WIRE STRIP LENGTH | | INSULATION DIAMETER RANGE | |
| .154-.185 IN [3.90-4.70 mm] | | Ø.055-.091 IN [1.40-2.30 mm] | |
| TERMINAL APPLICATION SPECIFICATION | 114-20021 | - | - |
| TERMINALS APPLIED | | | |
| TE TERMINAL | TE TERMINAL | TE TERMINAL | TE TERMINAL |
| 160887-1 | 160887-3 | 160887-4 | |

| WIRE SIZE | CRIMP HEIGHT mm [INCH] | CRIMP HEIGHT REFERENCE SETTING |
|-----------|-----------------------------|--------------------------------|
| 1.00mm2 | 1.60+/-0.05 [1.063+/-0.002] | 8.9 |
| 0.85mm2 | 1.55+/-0.05 [1.061+/-0.002] | 9.4 |
| 0.75mm2 | 1.52+/-0.05 [1.060+/-0.002] | 9.8 |
| 0.70mm2 | 1.50+/-0.05 [1.059+/-0.002] | 10.0 |
| 0.50mm2 | 1.42+/-0.05 [1.056+/-0.002] | 10.9 |



- 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.

***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.

| LOC | DIST | REVISIONS | | | | | |
|-----|------|-----------|-----|---------------|-----------|-----|------|
| A | 66 | # | LY# | DESCRIPTION | DATE | OWN | APVD |
| | | A | | RELEASED | 29MAR2013 | KH | UG |
| | | B | | ECR-19-010226 | 29JUN2019 | TB | GB |
| | | C | | ECR-19-011109 | 15JUL2019 | TB | TE |
| | | D | | ECR-19-011536 | 22JUL2019 | JAH | GB |

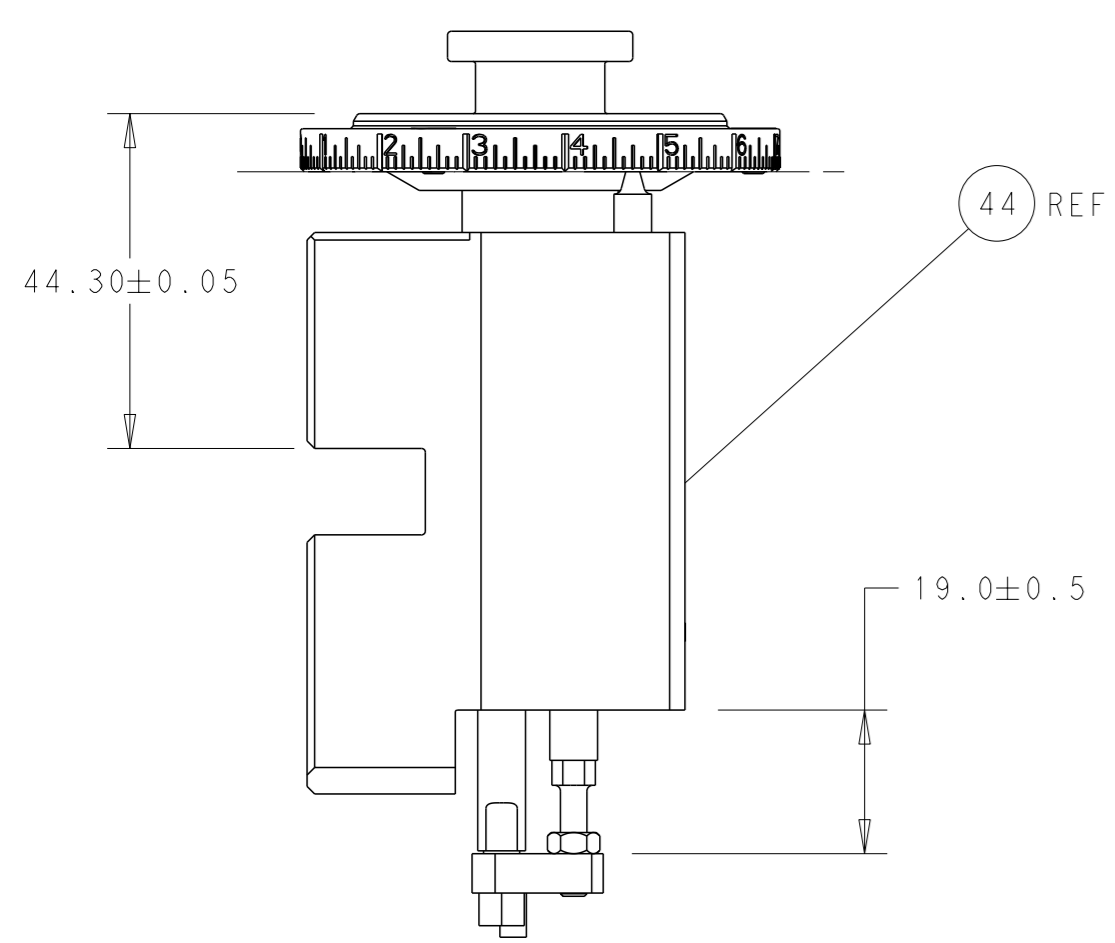
| | | | | | |
|---|-----|-----|-------------|-------------------------------------|---------|
| - | 1 | 1 | 2119641-1 | FEED CAM, AIR FEED | 248 |
| - | 1 | 1 | 2119082-9 | CAM, SNAIL, INSULATION ADJUSTMENT | 244 |
| - | 1 | 1 | 2079764-1 | WASHER, WAVE SPRING, CREST-TO-CREST | 243 |
| | - | 1 | 2119083-1 | RETAINER, INSULATION DIAL | 242 |
| - | 1 | 1 | 2844940-4 | 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 | 455888-8 | 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 | 1976052-1 | 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 | 2168083-8 | SCR, SKT HD CAP, RoHS, M4 X 16 | 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 |
| | - | 1 | 1752354-2 | 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 | 1752371-5 | PLATE, STRIP GUIDE | 24 |
| - | 1 | 1 | 240825-4 | PLATE, STRIP HOLD DOWN | 23 |
| - | 2 | 2 | 2-22281-3 | SPRING, COMPRESSION | 22 |
| - | 1 | 1 | 1803292-4 | DRAG | 20 |
| - | 1 | 1 | 1803152-5 | STRIP GUIDE, REAR | 19 |
| - | 1 | 1 | 1803151-5 | STRIP GUIDE, FRONT | 18 |
| - | 4 | 4 | 1-2079383-1 | SCR, BHSC, RoHS (M6 X 12) | 17 |
| - | 1 | 1 | 5-240641-9 | SPACER | 16 |
| - | 1 | 1 | 1752360-1 | SPACER,HOLD-DOWN | 13 |
| | - | 1 | 240644-1 | PLATE, REAR SHEAR | 11 |
| - | - | - | - | - | 10 |
| | - | 1 | 690482-5 | PLATE, FRONT SHEAR | 9 |
| | 1 | 2 | 1333216-1 | ANVIL, COMBINATION | 8 |
| | - | 1 | 2217206-7 | BLADE, SLUG | 7 |
| - | - | - | - | - | 6 |
| - | 1 | 1 | 5-240641-1 | SPACER | 5 |
| - | 1 | 1 | 238011-2 | BLOCK, CRIMPER SPACER | 4 |
| | 1 | 2 | 1633963-1 | CRIMPER, INSULATION OVERLAP PREMIUM | 3 |
| - | 1 | 1 | 455888-5 | SPACER, CRIMPER | 2 |
| | 1 | 2 | 1-456405-5 | CRIMPER, WIRE PREMIUM | 1 |
| - | 77 | 72 | 2 | PART NO | ITEM NO |

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

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

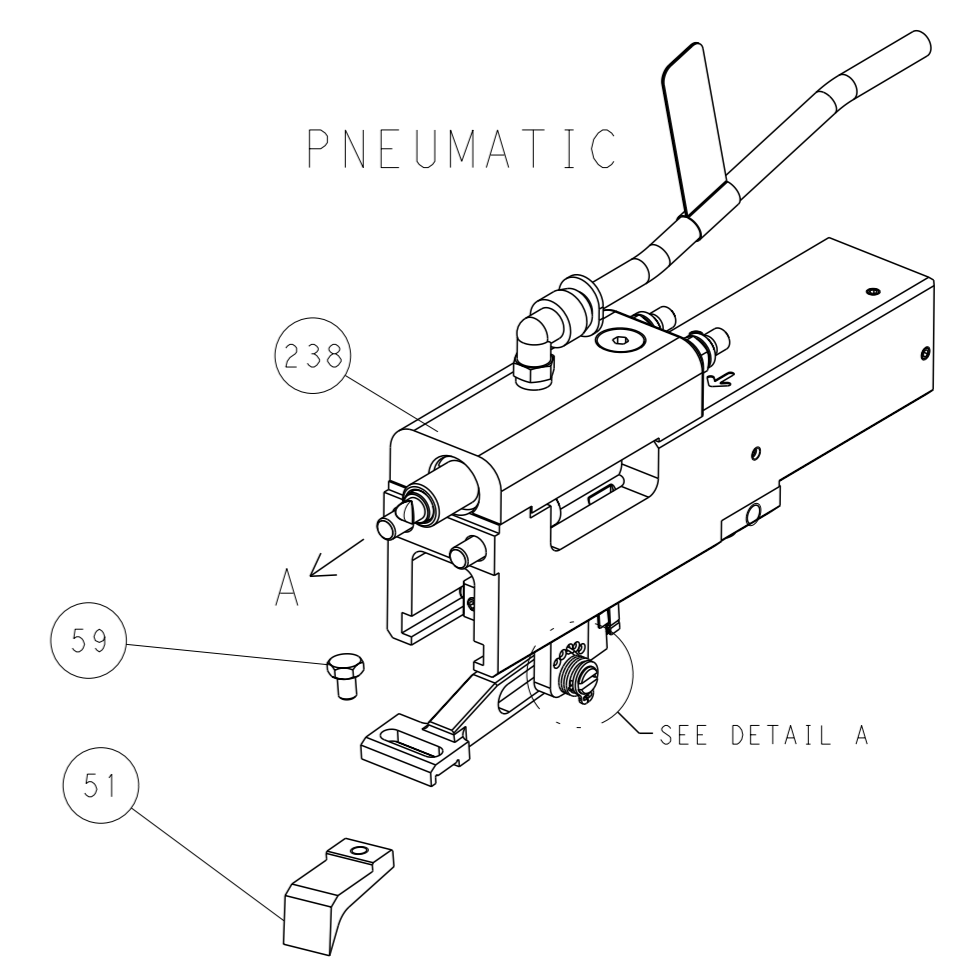
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|------------------|---------------------------|-----------|--|-----------|------------|---------------|
| OWN | H. HUANG | 12MAR2013 | TE Connectivity Harrisburg, PA 17105-3608 | | | |
| CHK | L. ZHANG | 12MAR2013 | | | | |
| APVD | H. GUO | 12MAR2013 | | | | |
| NAME | Ocean End Feed Applicator | | | | | |
| PRODUCT SPEC | | | SIZE | CAGE CODE | DRAWING NO | RESTRICTED TO |
| APPLICATION SPEC | | | A1 | 00779 | 2150319 | - |
| WEIGHT | | | Customer Accessible Production Drawing | SCALE | 1:1 | SHEET 1 of 4 |
| REV | | | D | | | |

| LOC | DIST | REVISIONS | | | |
|-----|------|-----------|-------------|-----|------|
| A | 66 | REV | DATE | OWN | APVD |
| | | - | SEE SHEET 1 | - | - |

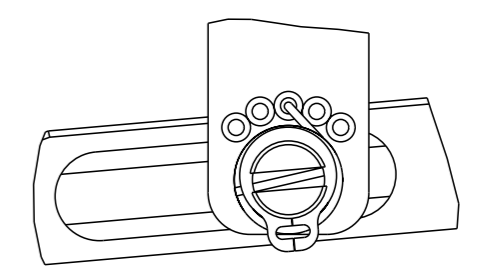


RAM SET-UP

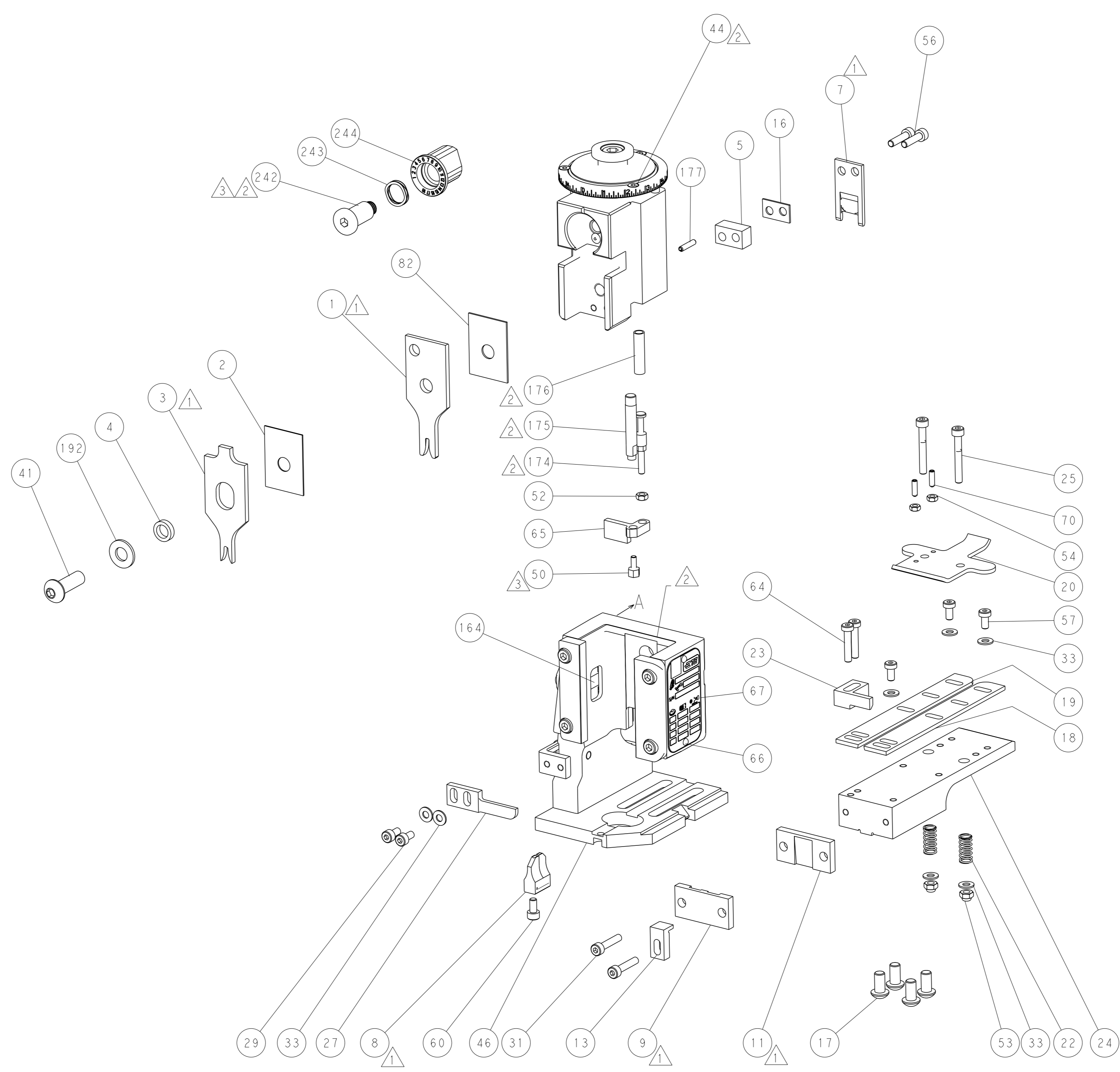
FEED TYPE



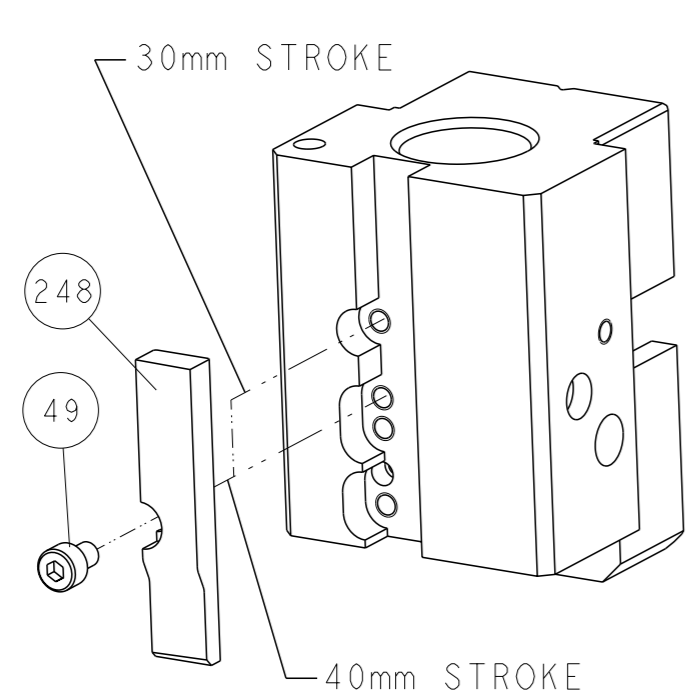
FEED SPRING SETTING POSITION



DETAIL A



CAM POSITION



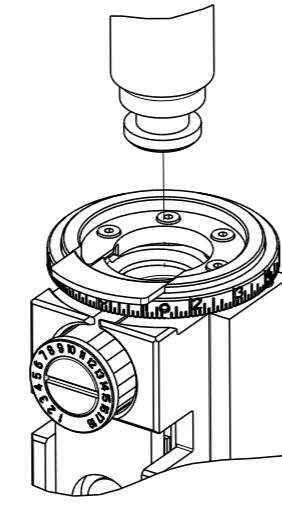
AIR FEED

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

| | | | |
|--|--|--|---|
| <small>THIS DRAWING IS A CONTROLLED DOCUMENT FROM TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE AND TO CONTROLING ENGINEERING DISCRETION. SHOULD BE CONTACTED FOR THE LATEST REVISION.</small> | | OWN: K. HUANG 12MAR2013 CHK: L. ZHANG 12MAR2013 APVD: J. GUO 12MAR2013 | TE Connectivity Harrisburg, PA 17105-3608 |
| DIMENSIONS: mm | TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH ± | NAME: Ocean End Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: ©=2150319 | RESTRICTED TO: - SCALE: 1:1 SHEET: 2 of 4 REV: D |
| MATERIAL: - | | WEIGHT: - Customer Accessible Production Drawing | SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION |

| THIS DRAWING IS UNPUBLISHED. | RELEASED FOR PUBLICATION | 20 | |
|---|--------------------------|--------------------------|-----------|
| COPYRIGHT © BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED. | | | |
| PART NUMBER | REVISION | DESCRIPTION | FEED TYPE |
| 2-2150319-2 | D | FINE CRIMP HEIGHT ADJUST | PNEUMATIC |
| 7-2150319-7 | A | CRIMP TOOLING KIT | - |

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



| APPLICATOR DATA | | |
|--------------------------------------|------------------|------|
| CRIMP | SIZE | TYPE |
| WIRE | 2.03 mm [.080] | F |
| INSUL | 2.79 mm [.110] | OV |
| APPLICATOR INSTRUCTIONS 408-35043 | | |

| TERMINAL DATA: TE TERMINAL | | TE CRIMP SPECIFICATION | |
|---|-------------|------------------------------|-------------|
| TERMINAL NAME: .110 SRS FAST-IN-ON TAB. | | | |
| WIRE STRIP LENGTH | | INSULATION DIAMETER RANGE | |
| .154-.185 IN [3.90-4.70 mm] | | Ø.055-.091 IN [1.40-2.30 mm] | |
| TERMINAL APPLICATION SPECIFICATION | 114-20021 | - | - |
| TERMINALS APPLIED | | | |
| TE TERMINAL | TE TERMINAL | TE TERMINAL | TE TERMINAL |
| 160887-1 | 160887-3 | 160887-4 | |

| WIRE SIZE | CRIMP HEIGHT mm [INCH] | CRIMP HEIGHT REFERENCE SETTING |
|-----------|------------------------------|--------------------------------|
| 1.00mm2 | 1.60+/-0.05 [.063+/- .002] | 8.9 |
| 0.85mm2 | 1.55+/-0.05 [.061+/- .002] | 9.4 |
| 0.75mm2 | 1.52+/-0.05 [.060+/- .002] | 9.8 |
| 0.70mm2 | 1.50+/-0.05 [.059+/- .002] | 10.0 |
| 0.50mm2 | 1.42+/-0.05 [.056+/- .002] | 10.9 |



- 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.
- 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.

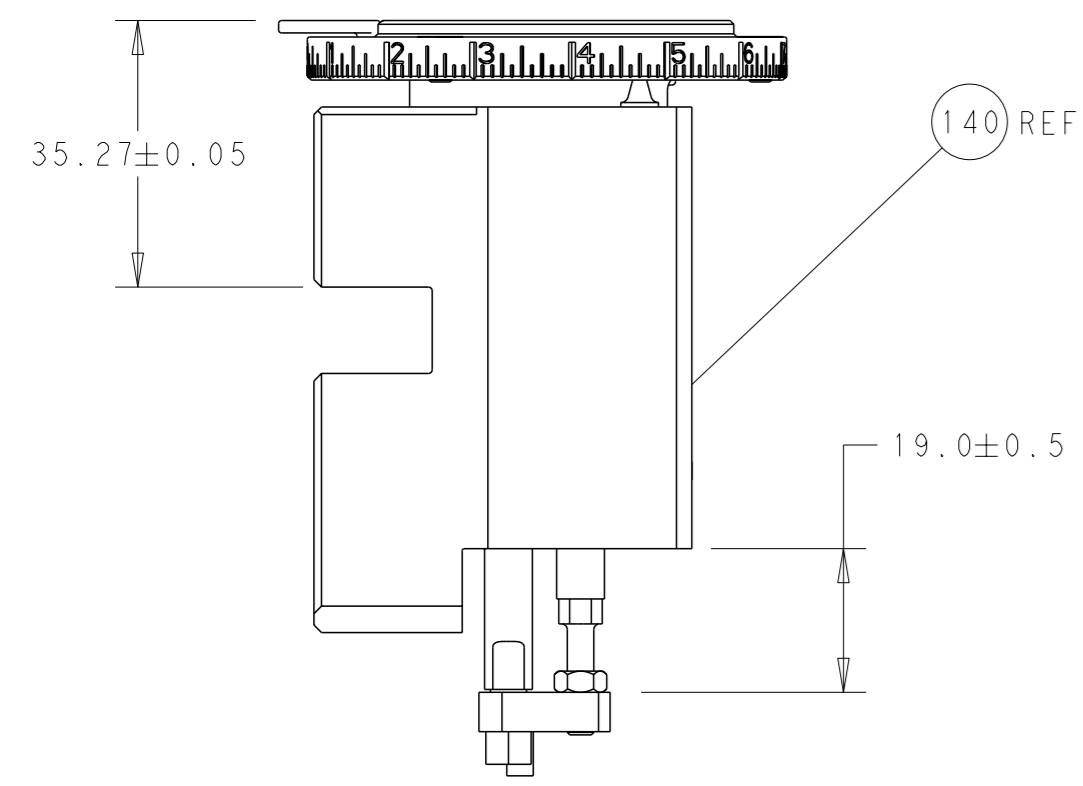
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| A | 66 | REV | DATE | BY | APPV |
| | | - | | | |
| | | SEE SHEET 1 | | | |

| | | | | |
|---|-------|-------------|-------------------------------------|---------|
| - | 1 | 2119082-9 | CAM, SNAIL, INSULATION ADJUSTMENT | 244 |
| - | 1 | 2079764-1 | WASHER, WAVE SPRING, CREST-TO-CREST | 243 |
| - | 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 |
| - | 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 | 455888-8 | 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 | 1976052-1 | 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 | 2168083-8 | SCR, SKT HD CAP, RoHS, M4 X 16 | 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 |
| - | 1 | 1752354-2 | 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 | 1752371-5 | PLATE, STRIP GUIDE | 24 |
| - | 1 | 240825-4 | PLATE, STRIP HOLD DOWN | 23 |
| - | 2 | 2-22281-3 | SPRING, COMPRESSION | 22 |
| - | 1 | 1803292-4 | DRAG | 20 |
| - | 1 | 1803152-5 | STRIP GUIDE, REAR | 19 |
| - | 1 | 1803151-5 | STRIP GUIDE, FRONT | 18 |
| - | 1 | 5-240641-9 | SPACER | 16 |
| - | 1 | 1752360-1 | SPACER, HOLD-DOWN | 13 |
| - | 1 | 240644-1 | PLATE, REAR SHEAR | 11 |
| - | - | - | - | 10 |
| - | 1 | 690482-5 | PLATE, FRONT SHEAR | 9 |
| 1 | 1 | 1333216-1 | ANVIL, COMBINATION | 8 |
| - | 1 | 2217206-7 | BLADE, SLUG | 7 |
| - | - | - | - | 6 |
| - | 1 | 5-240641-1 | SPACER | 5 |
| - | 1 | 238011-2 | BLOCK, CRIMPER SPACER | 4 |
| 1 | 1 | 1633963-1 | CRIMPER, INSULATION OVERLAP PREMIUM | 3 |
| - | 1 | 455888-5 | SPACER, CRIMPER | 2 |
| 1 | 1 | 1-456405-5 | CRIMPER, WIRE PREMIUM | 1 |
| - | 77-22 | PART NO | DESCRIPTION | ITEM NO |

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

| | | | | | | | | | | | |
|----------------|--|--|--|-------------------------|--|-------------------------|--|------------------------|--|---------------------------------|--|
| DIMENSIONS: mm | | TOLERANCES UNLESS OTHERWISE SPECIFIED: | | OWN: K. HUANG 12MAR2013 | | CHK: L. ZHANG 12MAR2013 | | APVD: J. GUO 12MAR2013 | | NAME: Ocean End Feed Applicator | |
| 0 PLC ± | | 1 PLC ± | | 2 PLC ± | | 3 PLC ± | | 4 PLC ± | | RESTRICTED TO | |
| MATERIAL: | | FINISH: | | WEIGHT: | | SCALE: 1:1 | | SHEET 3 OF 4 | | REV D | |

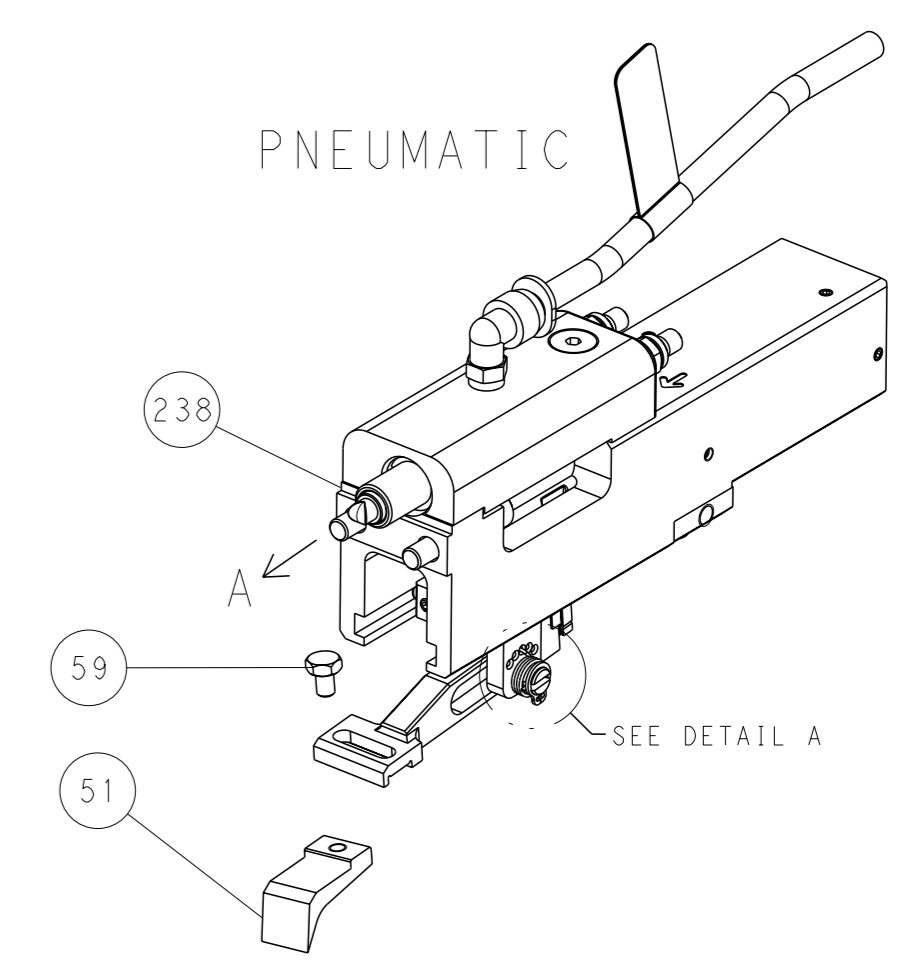
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|-----|------|-----------|-------------|-----|------|
| | | REV | DATE | OWN | APVD |
| A | 66 | - | SEE SHEET 1 | - | - |



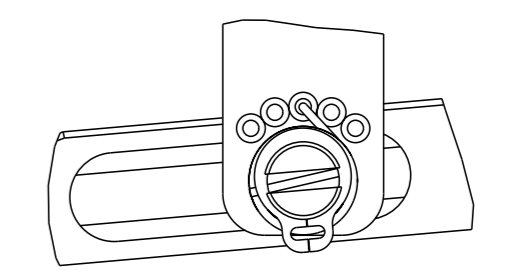
RAM SET-UP

FEED TYPE

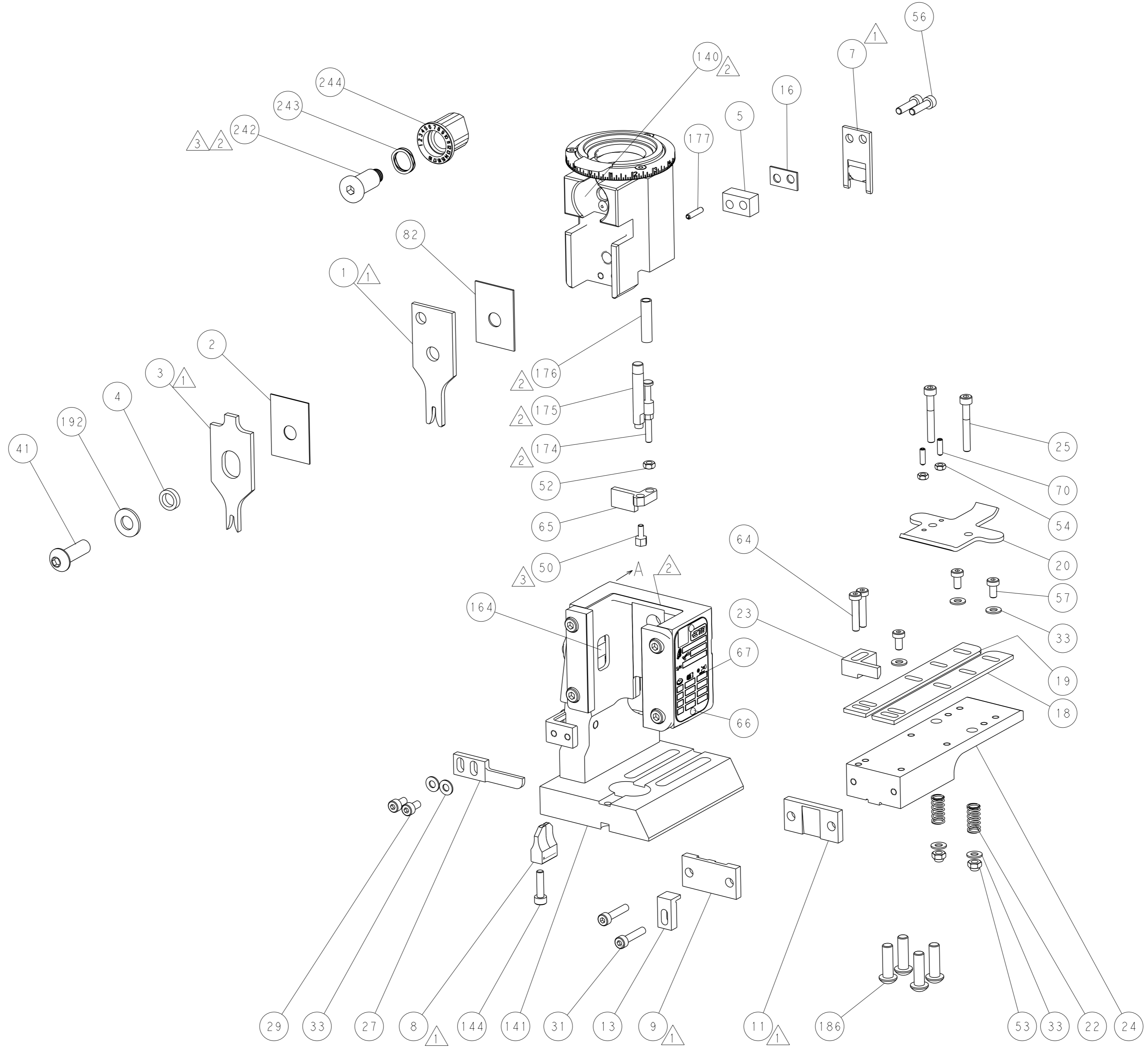
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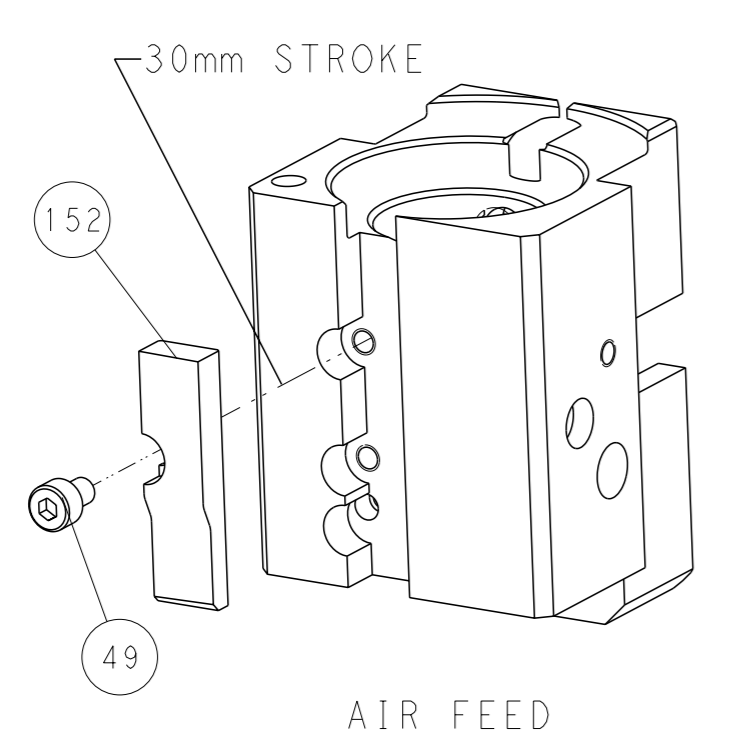
FEED SPRING SETTING POSITION



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)

| | | | | |
|--|--|---|--|----------------|
| <small>THIS DRAWING IS A CONTROLLED DOCUMENT FROM TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE AND THE CONTROLLER'S ENGINEERING DEPARTMENT SHOULD BE CONTACTED FOR THE LATEST REVISION.</small> | | OWN: K. HUANG CHK: L. ZHANG APVD: J. GUO DATE: 12MAR2013 | NAME: Ocean End Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2150319 | RESTRICTED TO: |
| DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH ± | WEIGHT: - SCALE: 1:1 SHEET: 4 of 4 REV: D | Customer Accessible Production Drawing | | |