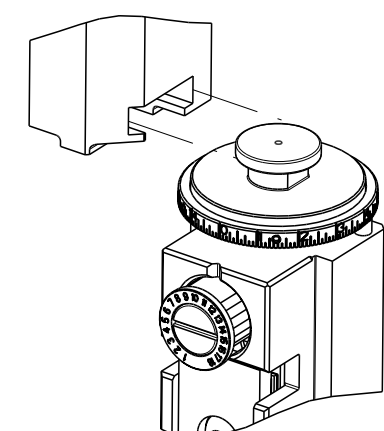


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150382-2	L	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150382-2	L	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150382-7	J	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	.110 [2.79 mm]	F
INSUL	.180 [4.57 mm]	F
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION			
TERMINAL NAME: RECEPTACLE, FASTON, FLAG, LIF, .250 SERIES			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
.198-.213 IN [5.02-5.40 mm]		∅.110-.160 IN [2.79-4.06 mm]	
TERMINAL APPLICATION SPECIFICATION	114-2079		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
63901-1	63010-3	63009-1	63096-1
63901-2	63012-1	63009-2	63096-2
63901-3	63012-2	63009-3	
63010-1		63011-1	
63010-2		63011-2	

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
14 AWG	1.85+/-0.05 [1.073+/-0.002]	3.6
16 AWG	1.62+/-0.05 [1.064+/-0.002]	6.1
18 AWG	1.47+/-0.05 [1.058+/-0.002]	7.7

- 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.
 - 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 IS NOT COMPATIBLE WITH MECHANICAL FEED.
 - TERMINAL LUBRICANT IS RECOMMENDED.
 - RIGHT HAND ORIENTED FLAG TERMINALS - WHEN RUNNING THESE TERMINALS, USE ITEM 1 WIRE CRIMPER WITH ITEM 14 BLOCK SUPPORT LOCATED UNDER THE TERMINAL FLAG.
 - LEFT HAND ORIENTED FLAG TERMINALS - WHEN RUNNING THESE TERMINALS, USE ITEM 178 WIRE CRIMPER WITH ITEM 14 BLOCK SUPPORT FLIPPED OVER AND LOCATED UNDER THE TERMINAL FLAG.
9. 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.

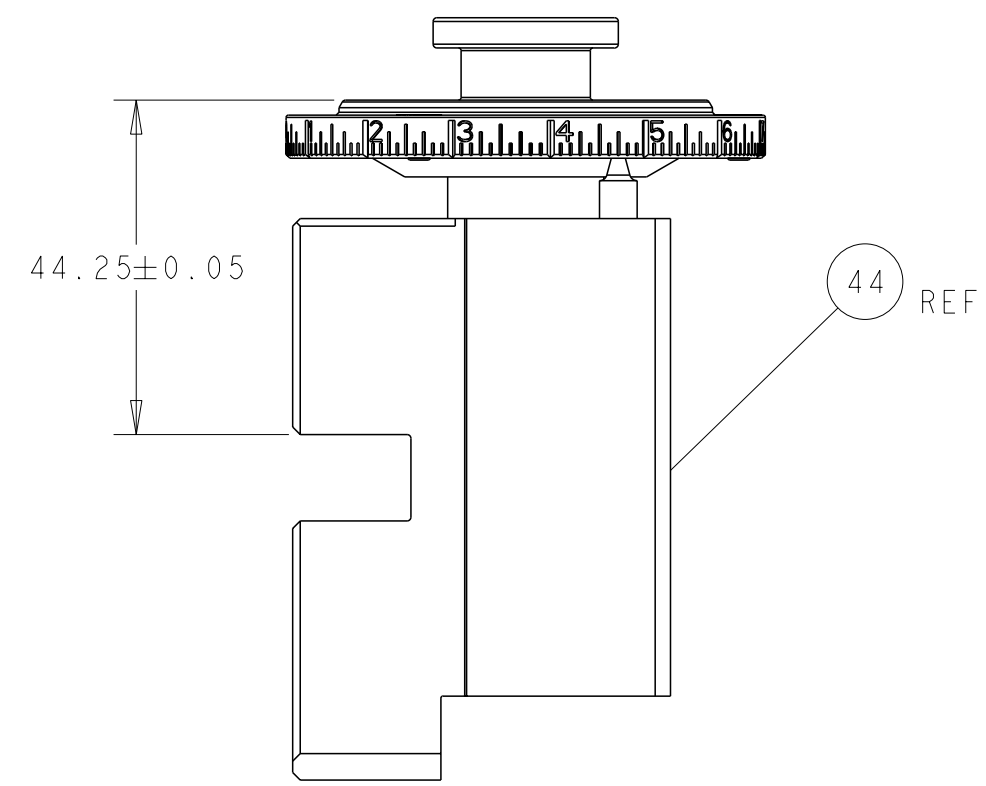
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

LOC	DIST	REVISIONS					
A	66	P	LYH	DESCRIPTION	DATE	OWN	APVD
		H3		ECR-17-014067	22SEP2017	RS	LZ
		J		ECR-17-017211	22NOV2017	TB	TE
		K		ECR-18-012381	08AUG2018	FZ	KZ
		L		ECR-19-009342	18JUN2019	LG	TE

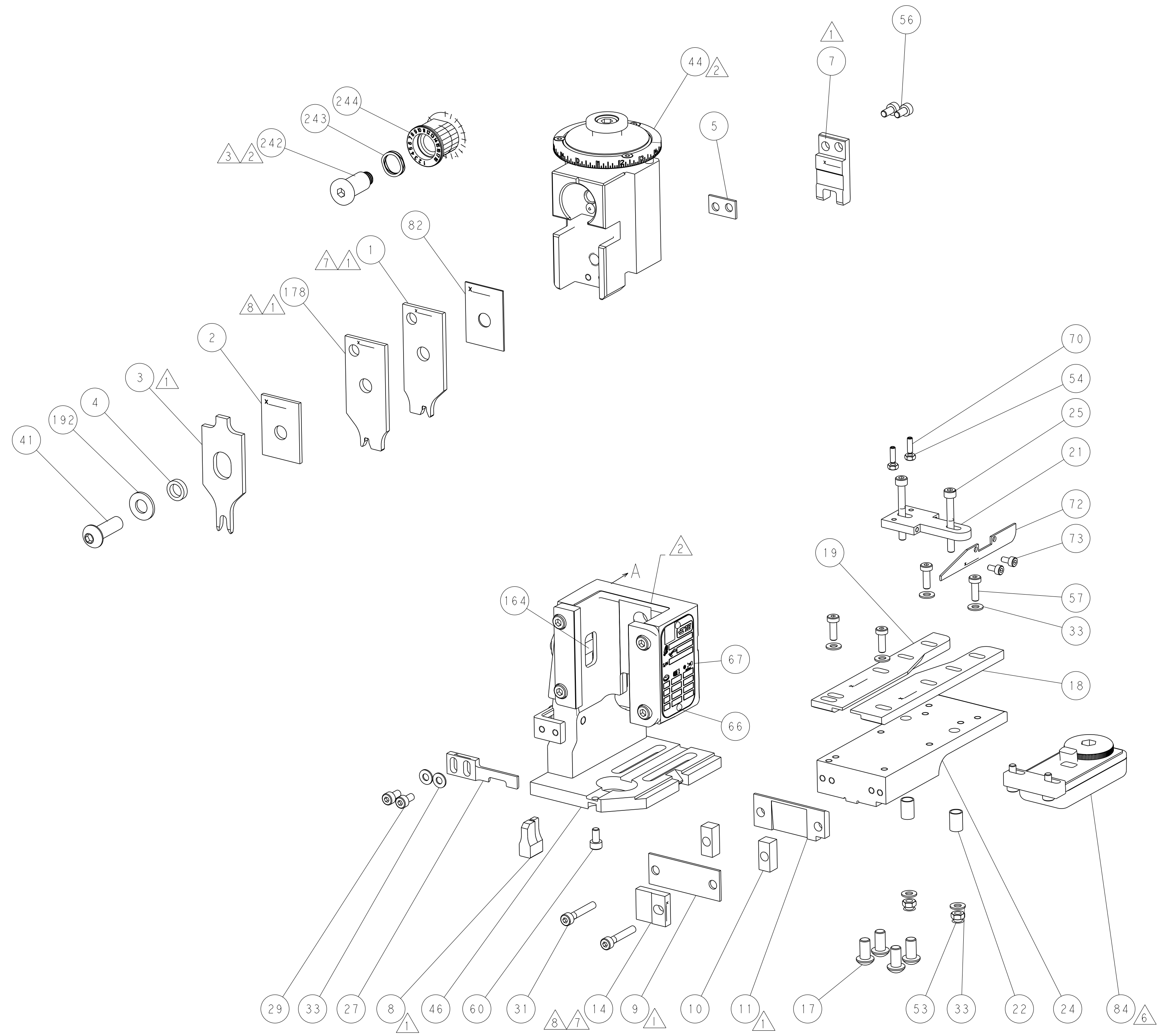
-	1	1	2119641-1	FEED CAM, AIR FEED	248	
-	1	1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244	
-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243	
-	1	1	2119083-1	RETAINER, INSULATION DIAL	242	
-	1	1	2844940-3	AIR FEED MODULE	238	
-	1	1	1-18028-0	WASHER, FLAT, REG M8	192	
1	2	1	2-1803224-2	CRIMPER, WIRE	178	
-	REF	REF	994970-2	COUNTER, MAGNETIC	164	
-	1	1	2119955-2	ASSY, LUBRICATOR, END FEED	84	
-	1	1	455888-7	SPACER, CRIMPER	82	
-	2	2	1-2168083-1	SCR, SKT HD CAP, RoHS, M3 X 6	73	
-	1	1	464452-2	DRAG, STOCK	72	
-	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	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	
-	4	4	2168400-1	SHCS, LOW HEAD, RoHS, M4 X 12	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	1-2063961-4	FEED FINGER	51	
-	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	
-	8	8	1-18028-2	WASHER, FLAT, REG M4	33	
-	2	2	1-2168083-2	SCR, SKT HD CAP, RoHS, M4 X 25	31	
-	2	2	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	29	
-	1	1	468281-1	STRIPPER	27	
-	2	2	1-2168083-6	SCR, SKT HD CAP, RoHS, M4 X 35	25	
-	1	1	2161922-4	PLATE, STRIP GUIDE	24	
-	2	2	22281-6	SPRING, COMPRESSION	22	
-	1	1	1633168-2	ARM, STOCK DRAG	21	
-	1	1	3-1901696-2	STRIP GUIDE, REAR	19	
-	1	1	3-1901695-2	STRIP GUIDE, FRONT	18	
-	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17	
-	1	1	469633-1	BLOCK, SUPPORT	14	
-	1	1	461160-1	PLATE, REAR SHEAR	11	
-	2	2	5-240645-2	SPACER, SHEAR PLATE	10	
-	1	1	455961-3	PLATE, FRONT SHEAR	9	
1	1	2	1-1803000-6	ANVIL, COMBINATION, END FEED	8	
-	1	1	1-469634-7	BLADE, SLUG	7	
-	-	-	-	-	6	
-	1	1	4-240641-8	SPACER	5	
-	1	1	238011-2	BLOCK, CRIMPER SPACER	4	
1	1	2	1803229-1	CRIMPER, INSULATION O PREMIUM	3	
-	1	1	2-455888-0	SPACER, CRIMPER	2	
1	1	2	1-1803224-8	CRIMPER, WIRE	1	
-	77	72	2	PART NO	DESCRIPTION	ITEM NO

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		MATERIAL:	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±
	FINISH	FINISH	FINISH	FINISH	FINISH
WEIGHT		SCALE		SHEET	
A1		00779 ©=2150382		1 OF 4	

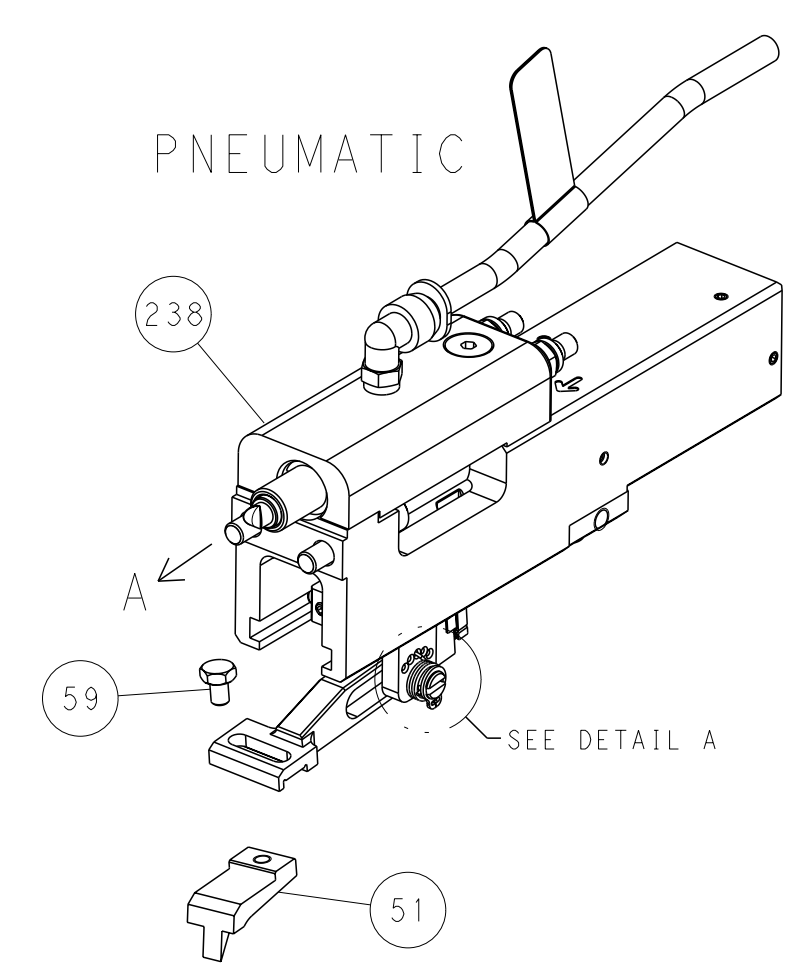
LOC	DIST	REV	DESCRIPTION	DATE	OWN	APVD
A	66		SEE SHEET 1			



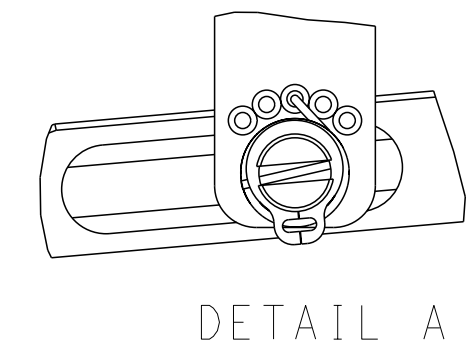
RAM SET-UP



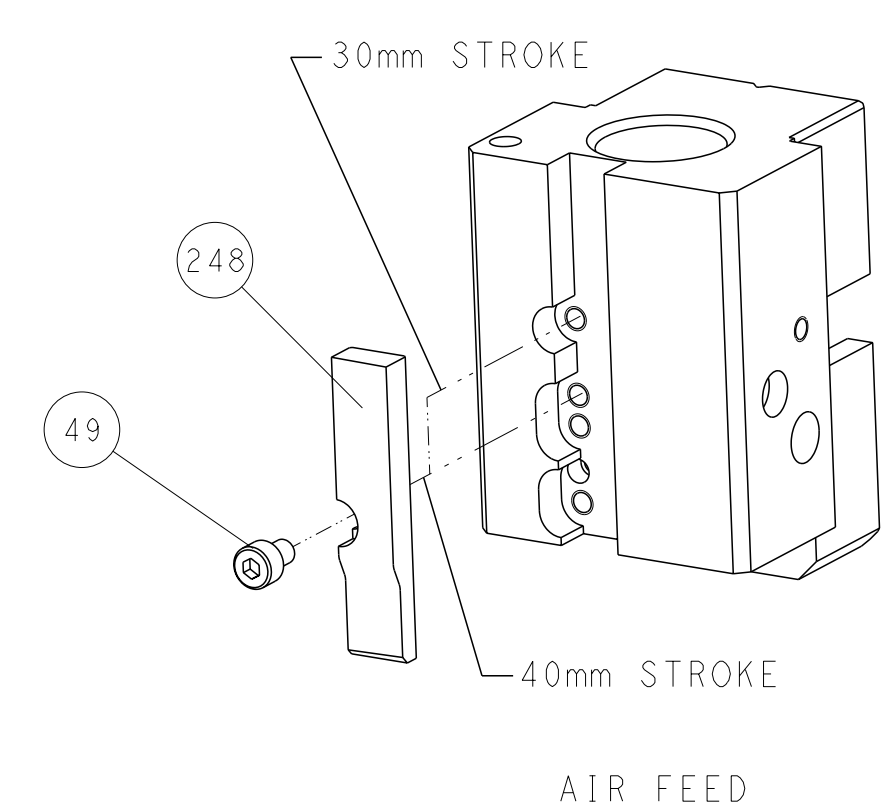
FEED TYPE



FEED SPRING SETTING POSITION



CAM POSITION



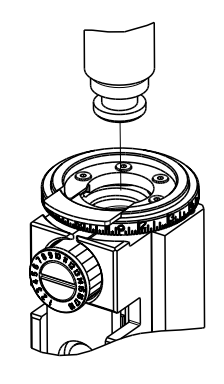
AIR FEED

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 UNPUBLISHED. RELEASED FOR PUBLICATION 20 © COPYRIGHT 20 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.</small>		DWN: K. STAKEM 11OCT2013 CHK: G. BAILEY 11OCT2013 APVD: J. ELBIN 11OCT2013	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: 2150382	RESTRICTED TO: L
MATERIAL:		WEIGHT:	SCALE: 1:1 SHEET: 2 of 4 REV: L

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150382-2	L	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150382-7	J	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
 INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	.110 [2.79 mm]	F
INSUL	.180 [4.57 mm]	F
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: RECEPTACLE, FASTON, FLAG, LIF, .250 SERIES			
WIRE STRIP LENGTH .198-.213 IN [5.02-5.40 mm]		INSULATION DIAMETER RANGE Ø.110-.160 IN [2.79-4.06 mm]	
TERMINAL APPLICATION SPECIFICATION 114-2079			
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
63901-1	63010-3	63009-1	63096-1
63901-2	63012-1	63009-2	63096-2
63901-3	63012-2	63009-3	
63010-1		63011-1	
63010-2		63011-2	

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
14 AWG	1.85 +/- 0.05 [0.073 +/- .002]	3.6
16 AWG	1.62 +/- 0.05 [0.064 +/- .002]	6.1
18 AWG	1.47 +/- 0.05 [0.058 +/- .002]	7.7

- 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 PITCH IS NOT COMPATIBLE WITH MECHANICAL FEED.
 - 6 TERMINAL LUBRICANT IS RECOMMENDED.
 - 7 RIGHT HAND ORIENTED FLAG TERMINALS - WHEN RUNNING THESE TERMINALS, USE ITEM 1 WIRE CRIMPER WITH ITEM 14 BLOCK SUPPORT LOCATED UNDER THE TERMINAL FLAG.
 - 8 LEFT HAND ORIENTED FLAG TERMINALS - WHEN RUNNING THESE TERMINALS, USE ITEM 178 WIRE CRIMPER WITH ITEM 14 BLOCK SUPPORT FLIPPED OVER AND LOCATED UNDER THE TERMINAL FLAG.
9. 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)

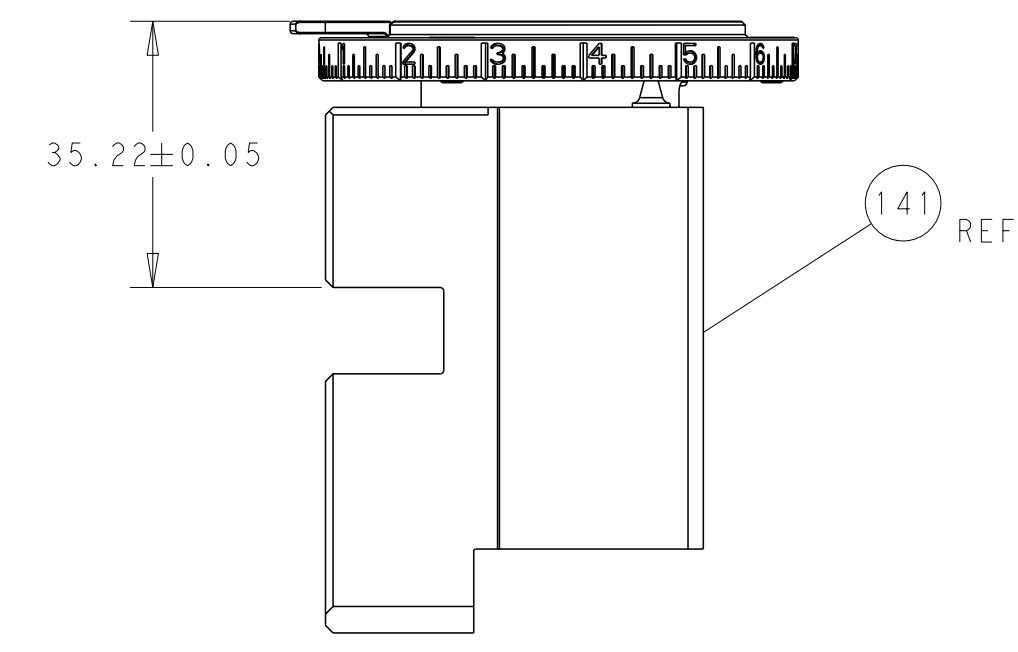
LOC	DIST	REVISIONS			
A	66	REV	DATE	BY	APPV
		-	SEE SHEET 1	-	-

-	1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244	
-	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243	
3	-	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	2844940-3	AIR FEED MODULE	238	
-	1	1-18028-0	WASHER, FLAT, REG M8	192	
1	1	2-1803224-2	CRIMPER, WIRE	178	
-	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	
6	-	1	2119955-2	ASSY, LUBRICATOR, END FEED	84
-	1	455888-7	SPACER, CRIMPER	82	
-	2	1-2168083-1	SCR, SKT HD CAP, RoHS, M3 X 6	73	
-	1	464452-2	DRAG, STOCK	72	
-	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	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59	
-	4	2168400-1	SHCS, LOW HEAD, RoHS, M4 X 12	57	
-	2	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	56	
-	2	5018030-1	NUT, HEX, REG, RoHS, M3	54	
-	2	986965-8	NUT, LOCK, HEX, TORQUE (M4)	53	
-	1	1-2063961-4	FEED FINGER	51	
-	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49	
-	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41	
-	8	1-18028-2	WASHER, FLAT, REG M4	33	
-	2	1-2168083-2	SCR, SKT HD CAP, RoHS, M4 X 25	31	
-	2	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	29	
-	1	468281-1	STRIPPER	27	
-	2	1-2168083-6	SCR, SKT HD CAP, RoHS, M4 X 35	25	
-	1	2161922-4	PLATE, STRIP GUIDE	24	
-	2	22281-6	SPRING, COMPRESSION	22	
-	1	1633168-2	ARM, STOCK DRAG	21	
-	1	3-1901696-2	STRIP GUIDE, REAR	19	
-	1	3-1901695-2	STRIP GUIDE, FRONT	18	
-	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17	
7	8	-	-	-	
1	-	1	469633-1	BLOCK, SUPPORT	14
1	-	1	461160-1	PLATE, REAR SHEAR	11
-	2	5-240645-2	SPACER, SHEAR PLATE	10	
1	-	1	455961-3	PLATE, FRONT SHEAR	9
1	1	3-1803000-6	ANVIL, COMBINATION, END FEED	8	
1	-	1	1-469634-7	BLADE, SLUG	7
-	-	-	-	6	
-	1	4-240641-8	SPACER	5	
-	1	238011-2	BLOCK, CRIMPER SPACER	4	
1	1	1803229-1	CRIMPER, INSULATION O PREMIUM	3	
-	1	2-455888-0	SPACER, CRIMPER	2	
7	1	1-1803224-8	CRIMPER, WIRE	1	

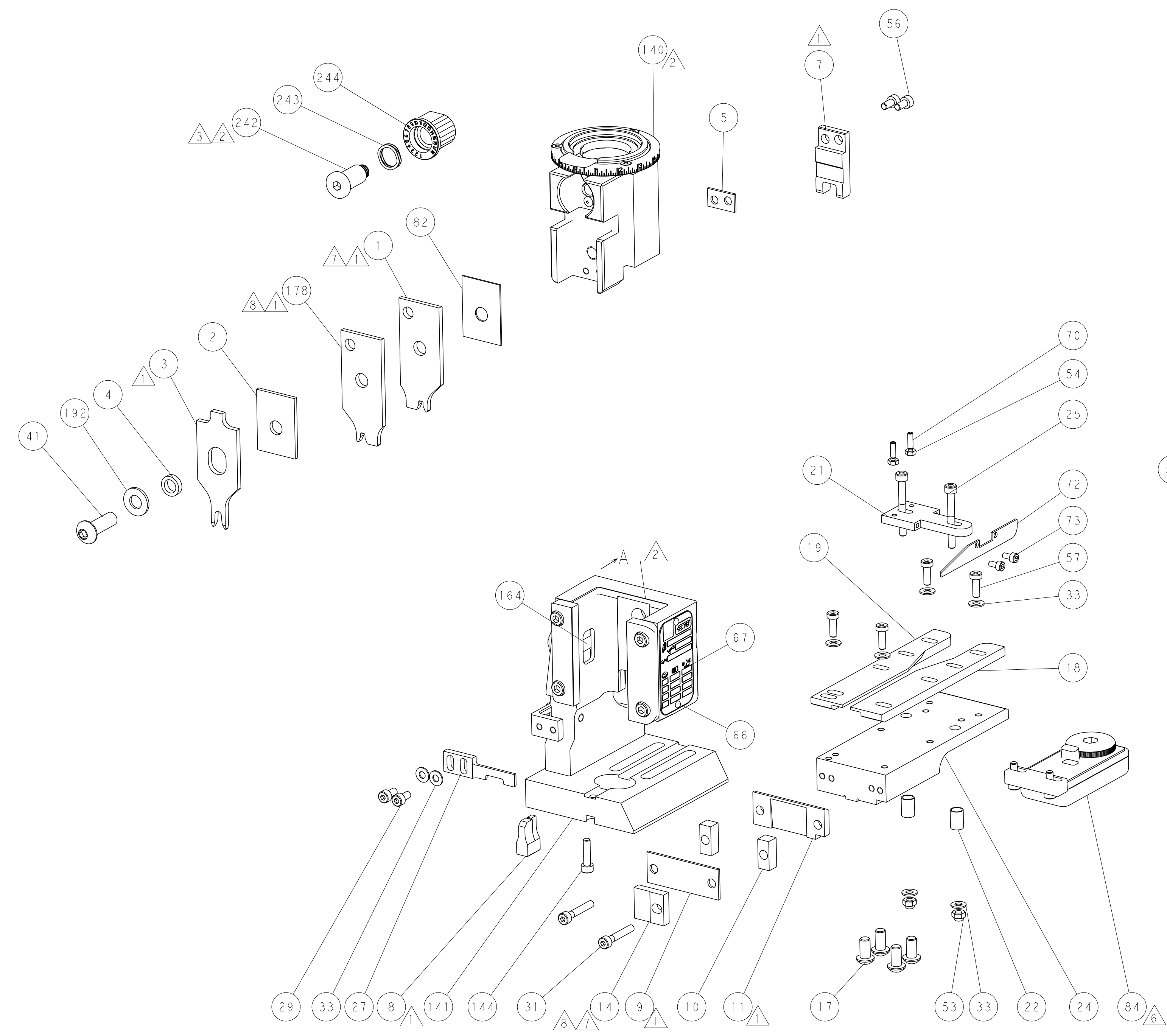
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		MATERIAL:	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±
	ANGLES FINISH				

OWN	R. STAKEM	11OCT2013
CHK	G. BAILEY	11OCT2013
APPV	J. ELBIN	11OCT2013
NAME		
Ocean End Feed Applicator		
SIZE	CAGE CODE	DRAWING NO
A1	00779	2150382
Customer Accessible Production Drawing		
SCALE	1:1	SHEET 3 of 4
REV		

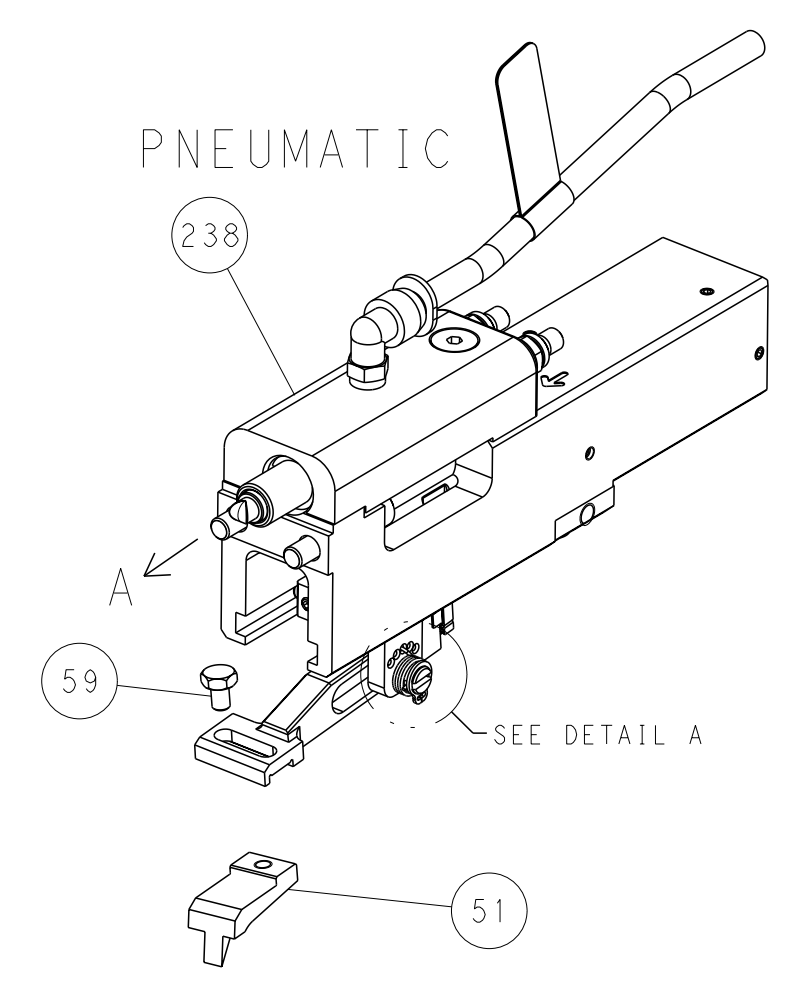
LOC		DIST		REVISIONS			
A	66	P	LYR	DESCRIPTION	DATE	OWN	APVD
		-		SEE SHEET 1	-	-	-



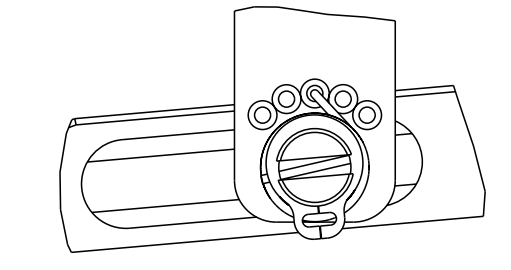
RAM SET-UP



FEED TYPE

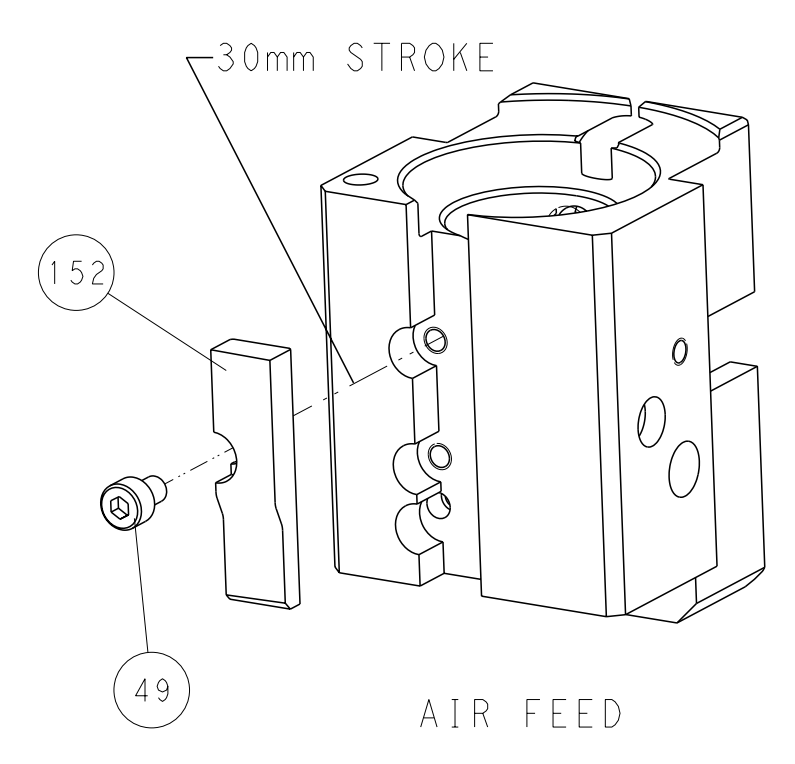


FEED SPRING SETTING POSITION



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)

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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: 2150382 SCALE: 1:1 SHEET: 4 of 4 REV: L	RESTRICTED TO:
MATERIAL:		WEIGHT:	Customer Accessible Production Drawing