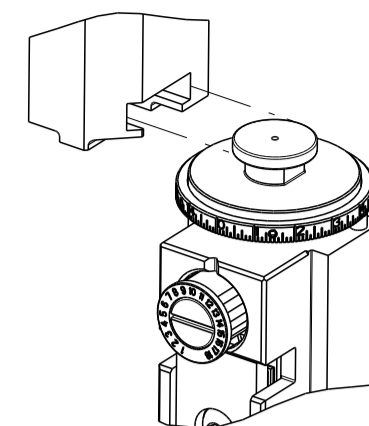


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150393-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150393-2	B	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150393-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	4.32 mm [.170]	F
INSUL	5.70 mm [.224]	F
APPLICATOR INSTRUCTIONS 408-35043		

TERMINAL DATA: YAZAKI TERMINAL YAZAKI CRIMP SPECIFICATION			
TERMINAL NAME: TERMINAL			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
5.00-6.00 mm [.197-.236 IN]		∅ 6.02mm MAX [.237 IN MAX]	
TERMINAL APPLICATION SPECIFICATION	WA1881		
TERMINALS APPLIED			
TE TERMINAL	YAZAKI TERMINAL	TE TERMINAL	YAZAKI TERMINAL
1949285-1	7114-3030	1949285-2	7114-3030-02

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
5.00mm2	2.25 +/- 0.05 [.089 +/- .002]	5.5
3.00mm2	1.95 +/- 0.05 [.077 +/- .002]	8.6



- 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 NOT COMPATABLE 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.

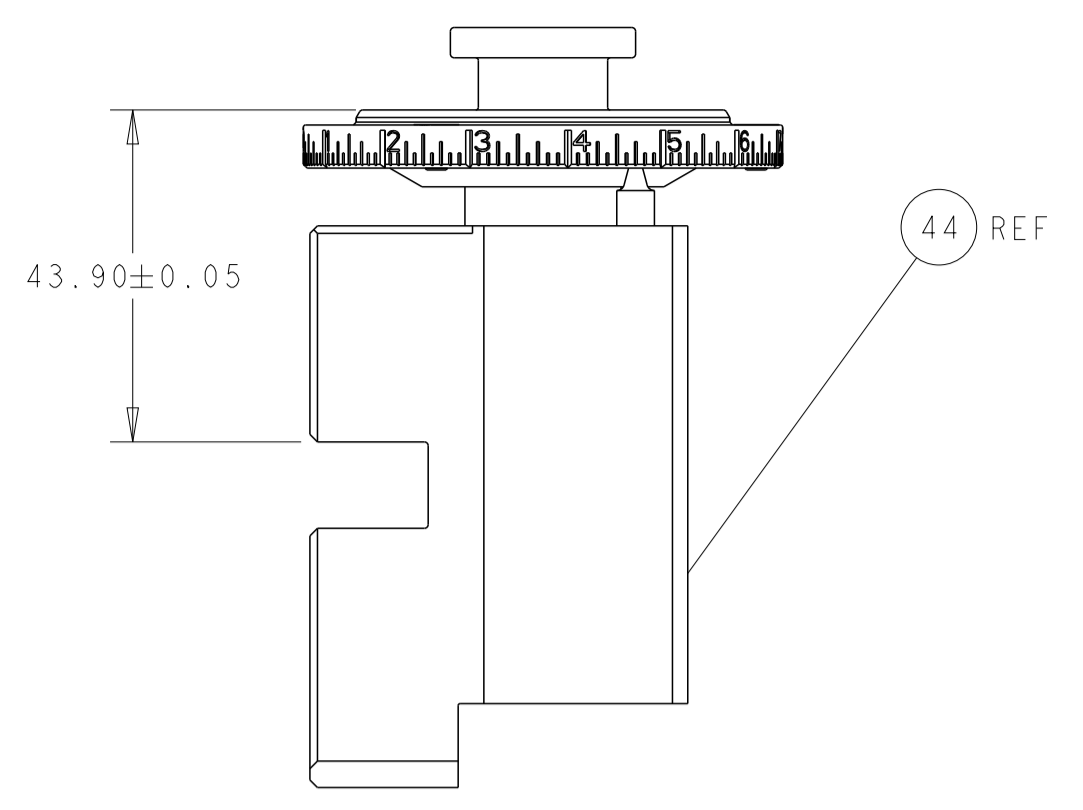
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		B		ECR-19-007869	16MAY2019	TB	CT

-	1	1	2119640-1	PUSH ROD, AIR FEED	250	
-	1	1	1803259-1	BUSHING, FLANGED	249	
-	1	1	2119641-1	FEED CAM, AIR FEED	248	
-	1	1	2119082-7	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	2063440-2	AIR FEED MODULE	238	
-	1	1	1-18028-0	WASHER, FLAT, REG M8	192	
-	2	2	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172	
-	REF	REF	994970-2	COUNTER, MAGNETIC	164	
-	1	1	240638-1	SPRING, FEED FINGER	163	
-	1	1	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854	137	
-	1	1	455888-5	SPACER, CRIMPER	82	
-	1	1	1803607-2	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	
-	4	4	2168400-1	SHCS, LOW HEAD, RoHS, M4 X 12	57	
-	2	2	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	56	
-	2	2	5018030-1	NUT, HEX, REG, RoHS, M3	54	
-	2	2	986965-8	NUT, LOCK, HEX, TORQUE (M4)	53	
-	1	1	2119792-2	PAWL, EF, AIR	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	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	1-2168083-6	SCR, SKT HD CAP, RoHS, M4 X 35	25	
-	1	1	1-1752371-2	PLATE, STRIP GUIDE	24	
-	2	2	22281-9	SPRING, COMPRESSION	22	
-	1	1	1803292-4	DRAG	20	
-	1	1	6-1901696-7	STRIP GUIDE, REAR	19	
-	1	1	4-1901695-9	STRIP GUIDE, FRONT	18	
-	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17	
-	1	1	7-240641-2	SPACER	16	
-	1	1	240644-5	PLATE, REAR SHEAR	11	
-	-	-	-	-	10	
-	1	1	7-690482-1	PLATE, FRONT SHEAR	9	
-	1	2	1	3-1803000-8	ANVIL, COMBINATION, END FEED	8
-	1	1	1	1-2217206-3	BLADE, SLUG	7
-	-	-	-	-	6	
-	1	1	1	2-240641-2	SPACER	5
-	1	1	1	4-238011-5	BLOCK, CRIMPER SPACER	4
-	1	2	1	4-1633962-7	CRIMPER, INSULATION F PREMIUM	3
-	1	1	1	1-455888-2	SPACER, CRIMPER	2
-	1	2	1	6-1673600-2	CRIMPER, WIRE	1
-	77	72	2	PART NO	DESCRIPTION	ITEM NO

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

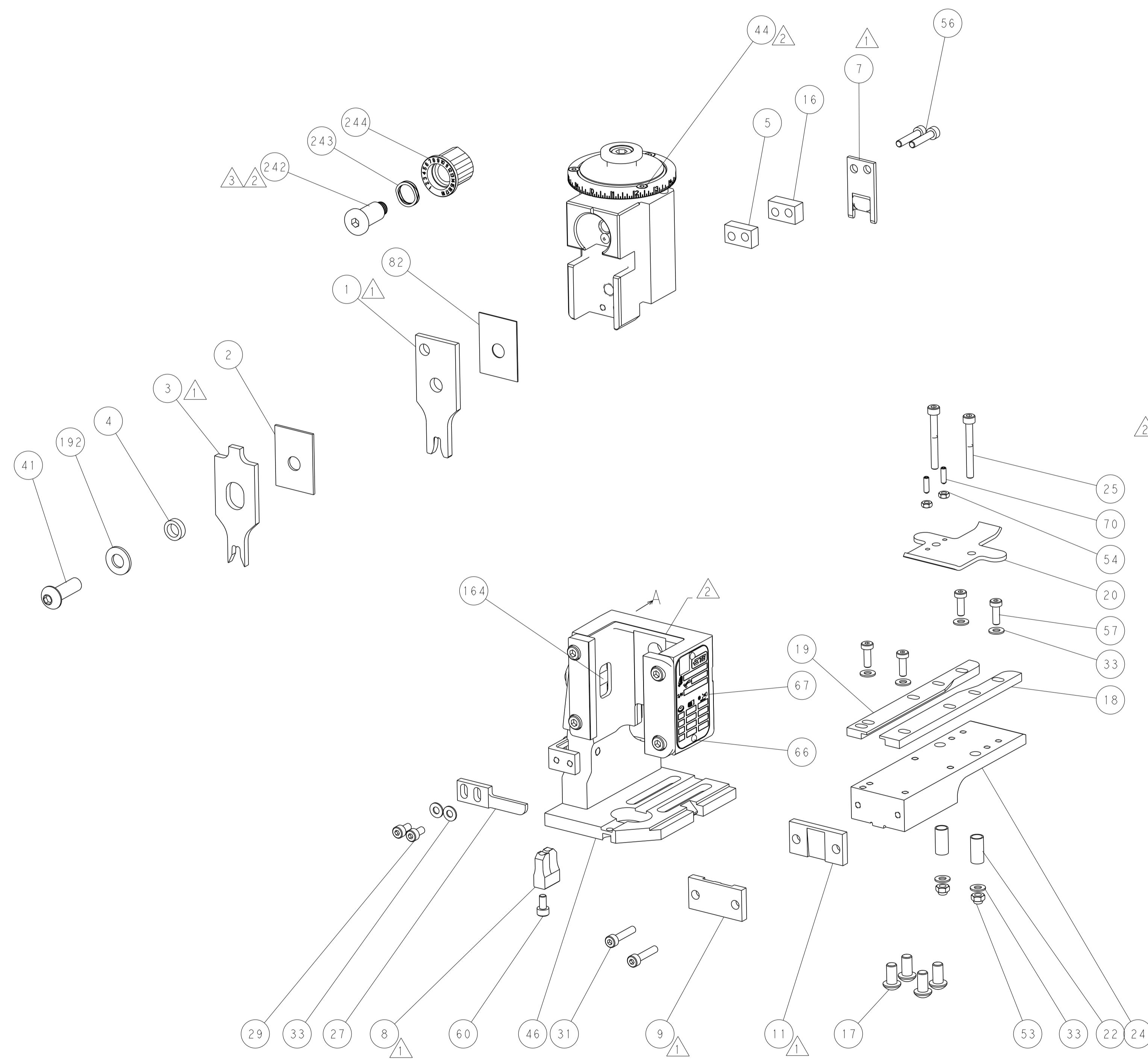
THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION 20		COPYRIGHT 20 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.	
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:	
0 PLC ±		1 PLC ±	
2 PLC ±		3 PLC ±	
4 PLC ±		ANGLES ±	
FINISH		MATERIAL	
DWN H. HUANG 31OCT2013		CHK L. ZHANG 31OCT2013	
APVD U. GUO 31OCT2013		NAME	
PRODUCT SPEC		APPLICATION SPEC	
SIZE CAGE CODE DRAWING NO		RESTRICTED TO	
A1 00779 C=2150393		-	
Customer Accessible Production Drawing		SCALE 1:1 SHEET 1 OF 4 REV B	

LOC		DIST		REVISIONS			
P	LTN	DATE	DMN	APVD			
A	66	-	-	-	-	-	-
		SEE SHEET 1					

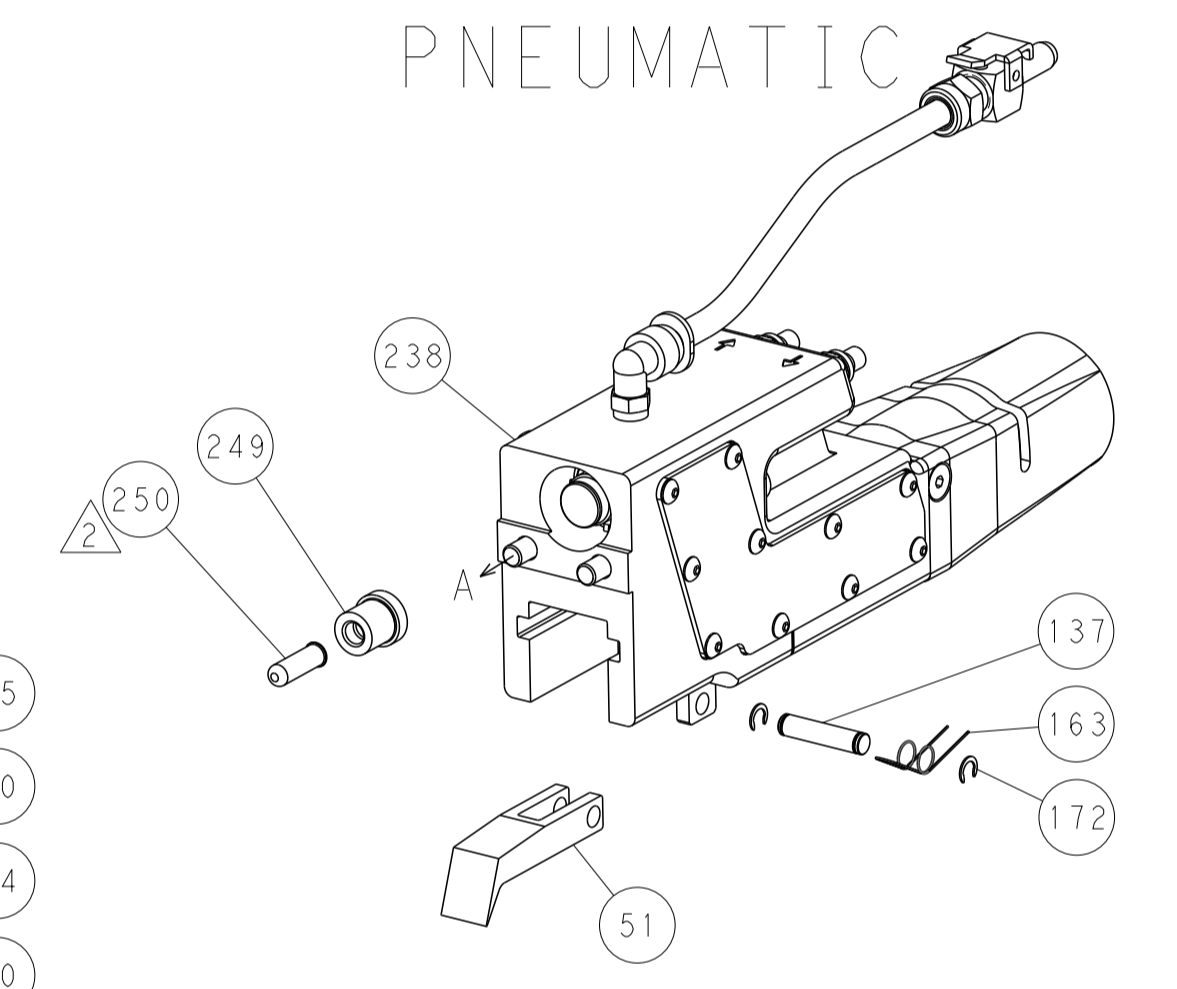


RAM SET-UP

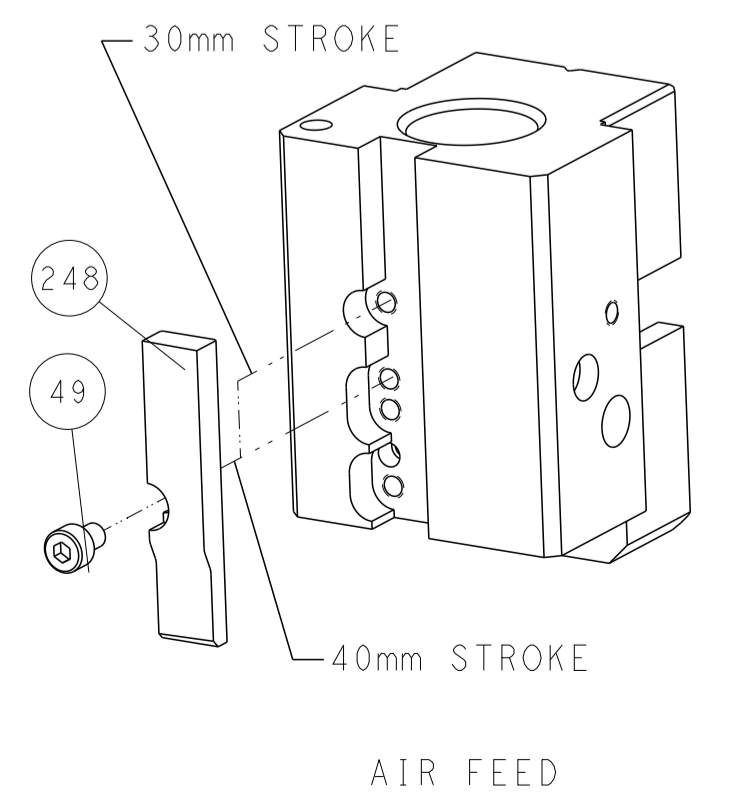
FEED TYPE



PNEUMATIC



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)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DMN	31OCT2013	TE Connectivity Harrisburg, PA 17105-3608
mm	0 PLC ±	1 PLC ±	2 PLC ±	CHK	31OCT2013	
	3 PLC ±	4 PLC ±	ANGLES ±	APVD	31OCT2013	NAME
	MATERIAL	FINISH	WEIGHT	U GUO PRODUCT SPEC APPLICATION SPEC		SIZE
				A 00779 ©=2150393		RESTRICTED TO
				Customer Accessible Production Drawing		SCALE 1:1 SHEET 2 OF 4 REV B

THIS DRAWING IS UNPUBLISHED.	RELEASED FOR PUBLICATION		
COPYRIGHT 20 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.			
PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150393-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150393-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR  
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	4.32 mm [ .170 ]	F
INSUL	5.70 mm [ .224 ]	F
APPLICATOR INSTRUCTIONS 408-35043		

TERMINAL DATA: YAZAKI TERMINAL YAZAKI CRIMP SPECIFICATION			
TERMINAL NAME: TERMINAL			
WIRE STRIP LENGTH 5.00-6.00 mm [ .197-.236 IN ]		INSULATION DIAMETER RANGE 6.02mm MAX [ .237 IN MAX ]	
TERMINAL APPLICATION SPECIFICATION	WA1881	-	-
TERMINALS APPLIED			
TE TERMINAL	YAZAKI TERMINAL	TE TERMINAL	YAZAKI TERMINAL
1949285-1	7114-3030	1949285-2	7114-3030-02

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
5.00mm2	2.25 +/- 0.05 [ .089 +/- .002 ]	5.5
3.00mm2	1.95 +/- 0.05 [ .077 +/- .002 ]	8.6

- 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 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.

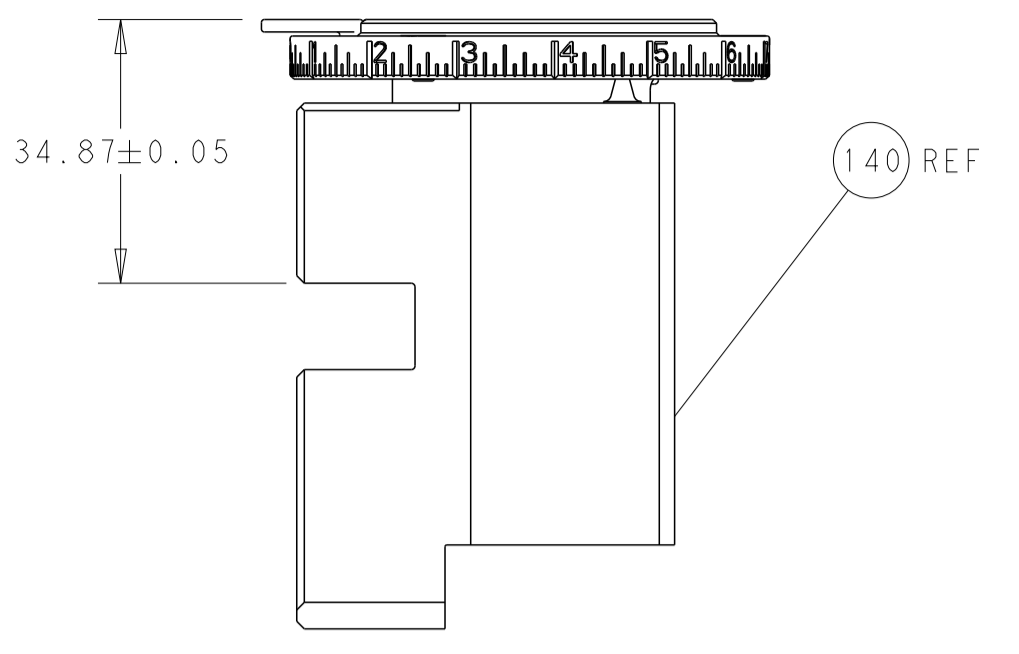
LOC	DIST	REVISIONS					
A	66	P	LTN	DESCRIPTION	DATE	DWN	APVD
-	-	-	-	SEE SHEET 1	-	-	-

-	1	2119640-1	PUSH ROD, AIR FEED	250
-	1	1803259-1	BUSHING, FLANGED	249
-	1	2119082-7	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
3	-	2119083-1	RETAINER, INSULATION DIAL	242
-	1	2063440-2	AIR FEED MODULE	238
-	1	1-18028-0	WASHER, FLAT, REG M8	192
-	4	2079383-9	SCR, BHSC, RoHS (M6 X 20)	186
-	2	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172
-	REF	994970-2	COUNTER, MAGNETIC	164
-	1	240638-1	SPRING, FEED FINGER	163
-	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	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854	137
-	1	455888-5	SPACER, CRIMPER	82
-	1	1803607-2	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
-	4	2168400-1	SHCS, LOW HEAD, RoHS, M4 X 12	57
-	2	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	56
-	2	5018030-1	NUT, HEX, REG, RoHS, M3	54
-	2	986965-8	NUT, LOCK, HEX, TORQUE (M4)	53
-	1	2119792-2	PAWL, EF, AIR	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	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	1-2168083-6	SCR, SKT HD CAP, RoHS, M4 X 35	25
-	1	1-1752371-2	PLATE, STRIP GUIDE	24
-	2	22281-9	SPRING, COMPRESSION	22
-	1	1803292-4	DRAG	20
-	1	6-1901696-7	STRIP GUIDE, REAR	19
-	1	4-1901695-9	STRIP GUIDE, FRONT	18
-	1	7-240641-2	SPACER	16
1	-	240644-5	PLATE, REAR SHEAR	11
-	-	-	-	10
-	1	7-690482-1	PLATE, FRONT SHEAR	9
1	1	3-1803000-8	ANVIL, COMBINATION, END FEED	8
1	-	1-2217206-3	BLADE, SLUG	7
-	-	-	-	6
-	1	2-240641-2	SPACER	5
-	1	4-238011-5	BLOCK, CRIMPER SPACER	4
1	1	4-1633962-7	CRIMPER, INSULATION F PREMIUM	3
-	1	1-455888-2	SPACER, CRIMPER	2
1	1	6-1673600-2	CRIMPER, WIRE	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)

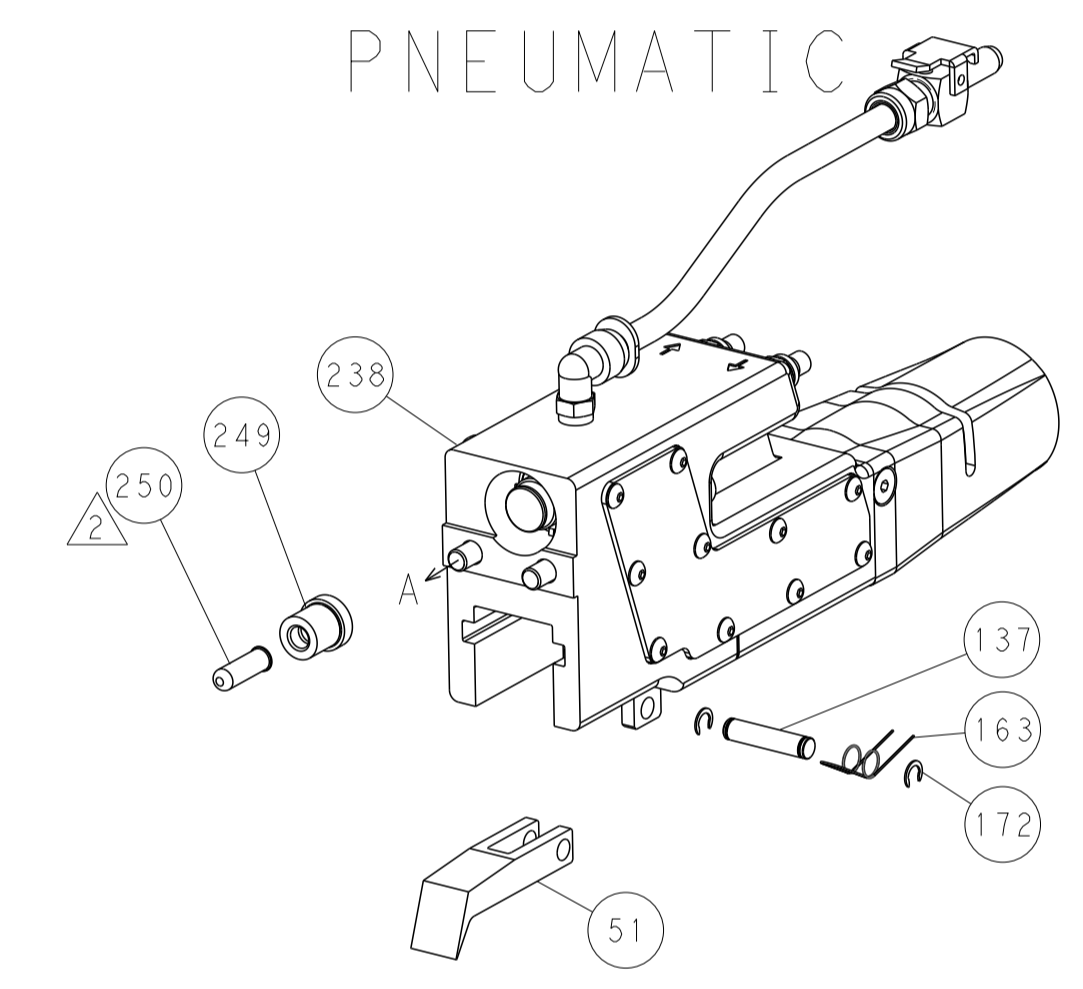
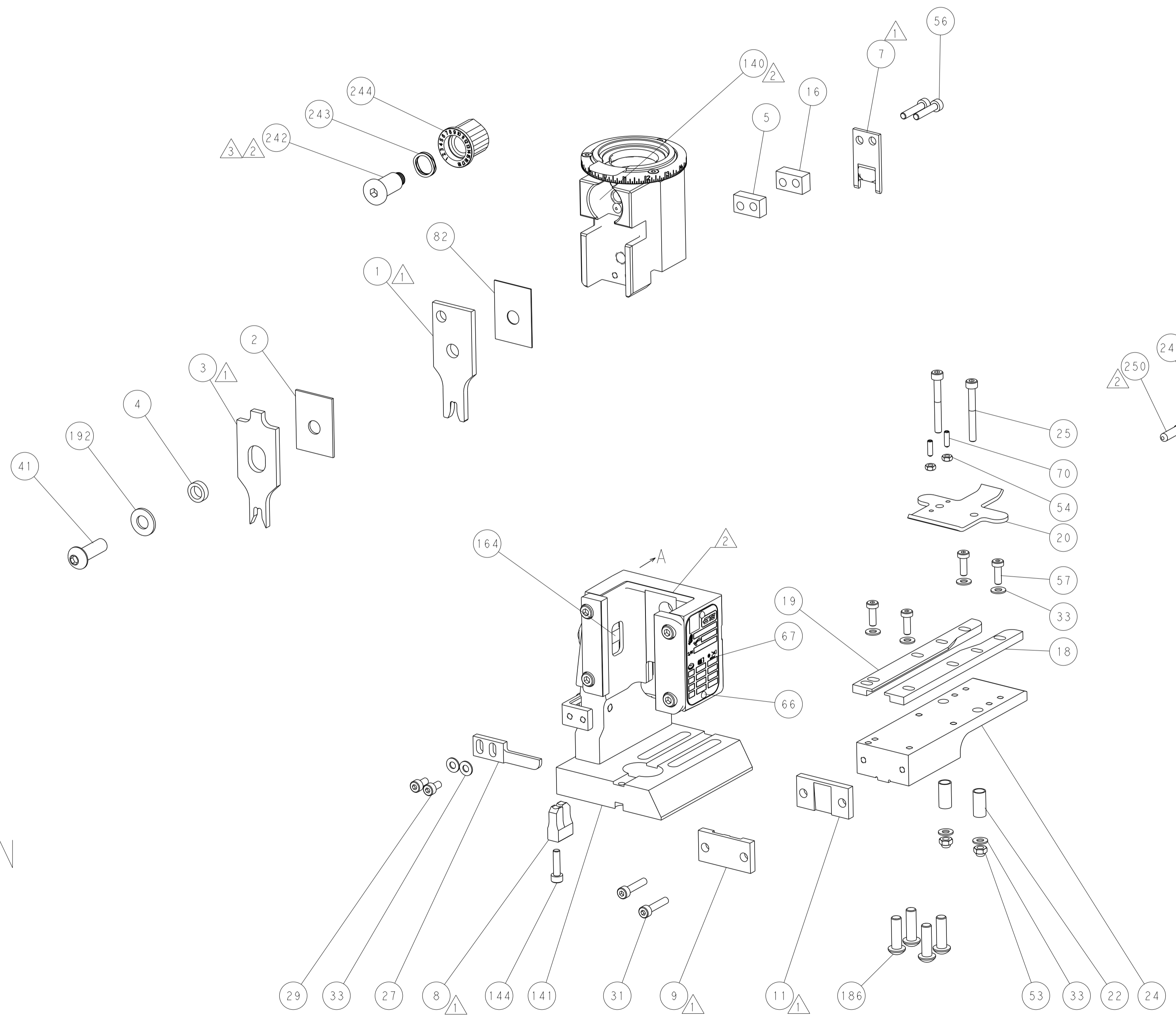
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DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH		NAME: Ocean End Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2150393 SCALE: 1:1 SHEET 3 OF 4 REV B	RESTRICTED TO: - Customer Accessible Production Drawing

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



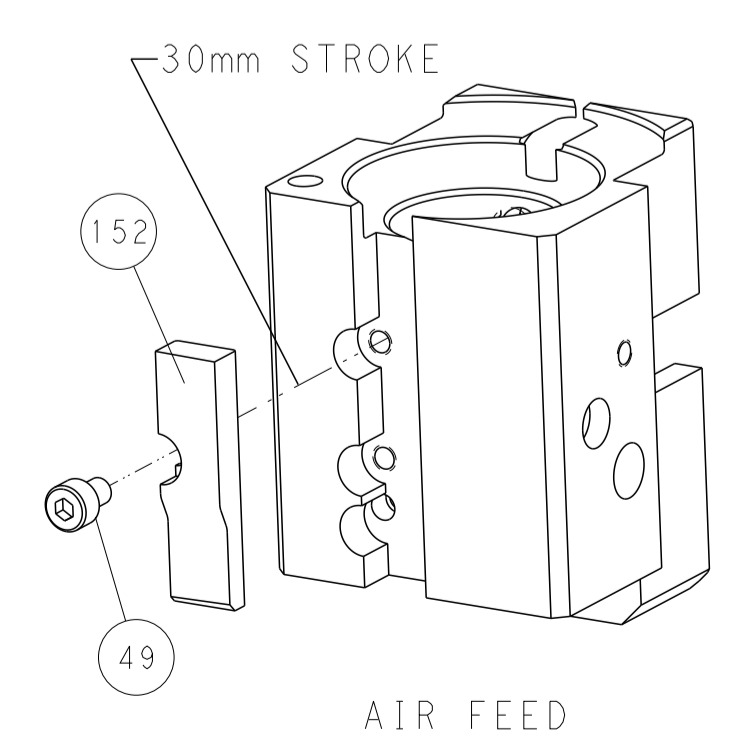
RAM SET-UP

FEED TYPE



PNEUMATIC

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 PRODUCT SPEC: APPLICATION SPEC: SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2150393 WEIGHT:	RESTRICTED TO:
MATERIAL:		SCALE: 1:1 SHEET: 4 of 4 REV: B	Customer Accessible Production Drawing