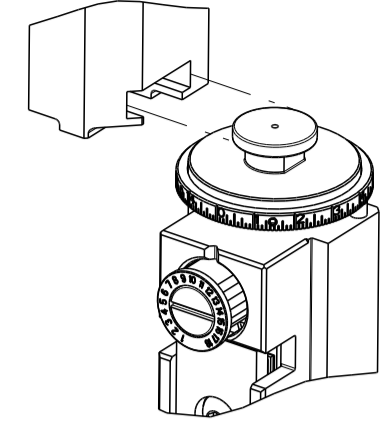


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150073-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2150073-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150073-1	B	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2150073-2	B	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150073-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.54 mm [.100]	F
INSUL	3.56 mm [.140]	F
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: .110 SERIES FASTIN-FASTON TAB			
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE		
3.90-4.70 mm [.154-.185 IN]	∅2.03-3.05 mm [.080-.120 IN]		
TERMINAL APPLICATION SPECIFICATION	114-2025		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
170014-1	170014-5	170014-6	1-170014-5

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
16 AWG	1.85+/-0.05 [.073+/-0.002]	7.7
18 AWG	1.65+/-0.05 [.065+/-0.002]	9.3
20 AWG	1.55+/-0.05 [.061+/-0.002]	10.3

- 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. 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.

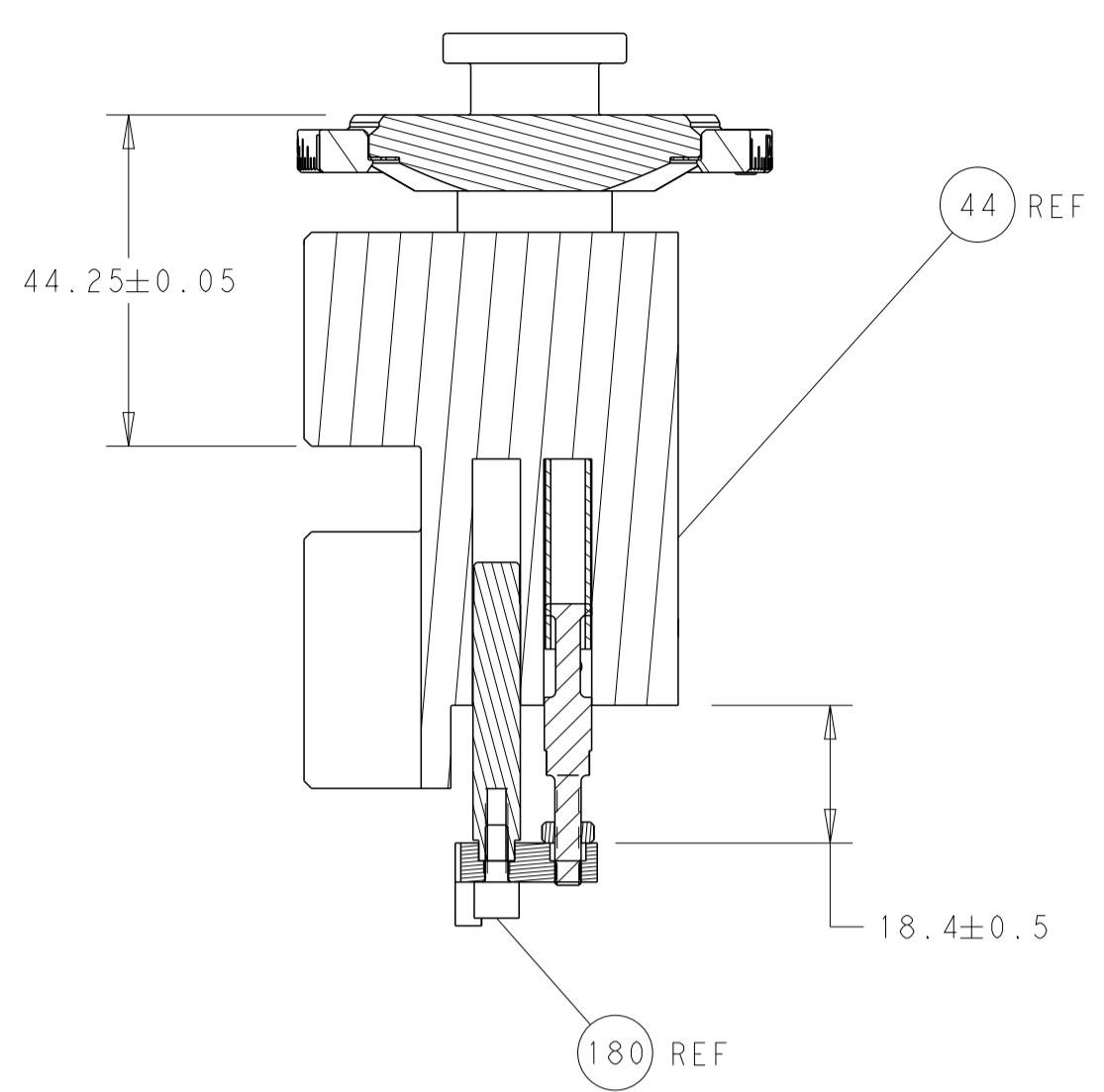
ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

LOC	DIST	REVISIONS					
A	66	P	LTN	DESCRIPTION	DATE	OWN	APVD
		A		RELEASED	30DEC2014	RK	GB
		B		ECR-19-010397	02JUL2019	TB	TE

-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248					
-	1	1	1	1	2119082-3	CAM, SNAIL, INSULATION ADJUSTMENT	244					
-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243					
3	-	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242					
-	-	1	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239					
-	1	-	1	-	2844940-3	AIR FEED MODULE	238					
-	1	1	1	1	1-18028-0	WASHER, FLAT, REG M8	192					
3	-	1	1	1	1752354-4	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					
-	1	1	1	1	455888-6	SPACER, CRIMPER	82					
-	1	1	1	1	2119791-9	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	1901681-1	HOLDDOWN, TERMINAL	65					
-	2	2	2	2	2168400-5	SHCS, LOW HEAD, RoHS, M4 X 20	64					
-	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					
-	3	3	3	3	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57					
-	2	2	2	2	2-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 14	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	-	2063961-1	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					
-	7	7	7	7	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	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	29					
-	1	1	1	1	240639-1	STRIPPER (MACHINING)	27					
-	2	2	2	2	1-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 30	25					
-	1	1	1	1	1752371-5	PLATE, STRIP GUIDE	24					
-	1	1	1	1	240825-1	PLATE, STRIP HOLD DOWN	23					
-	2	2	2	2	2-22281-3	SPRING, COMPRESSION	22					
-	1	1	1	1	1803292-4	DRAG	20					
-	2	2	2	2	1901259-4	GUIDE, LOWER STRIP	18					
-	4	4	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17					
-	1	1	1	1	1752360-1	SPACER, HOLD-DOWN	13					
1	-	1	1	1	240644-1	PLATE, REAR SHEAR	11					
-	-	-	-	-	-	-	10					
1	-	1	1	1	690482-5	PLATE, FRONT SHEAR	9					
1	1	2	2	1	1	6-1803001-5	ANVIL, COMBINATION, END FEED	8				
1	-	1	1	1	1	2217206-7	BLADE, SLUG	7				
-	-	-	-	-	-	-	6					
-	1	1	1	1	1	7-240641-2	SPACER	5				
-	1	1	1	1	1	238011-2	BLOCK, CRIMPER SPACER	4				
1	1	2	2	1	1	5-2119582-2	CRIMPER, INSULATION F PREMIUM	3				
-	-	-	-	-	-	-	2					
1	1	2	2	1	1	2-1490019-1	CRIMPER, WIRE PREMIUM	1				
-	-	-	-	-	-	-	-	-				
-	77	-	72	-	71	-	2	-	1	PART NO	DESCRIPTION	ITEM NO

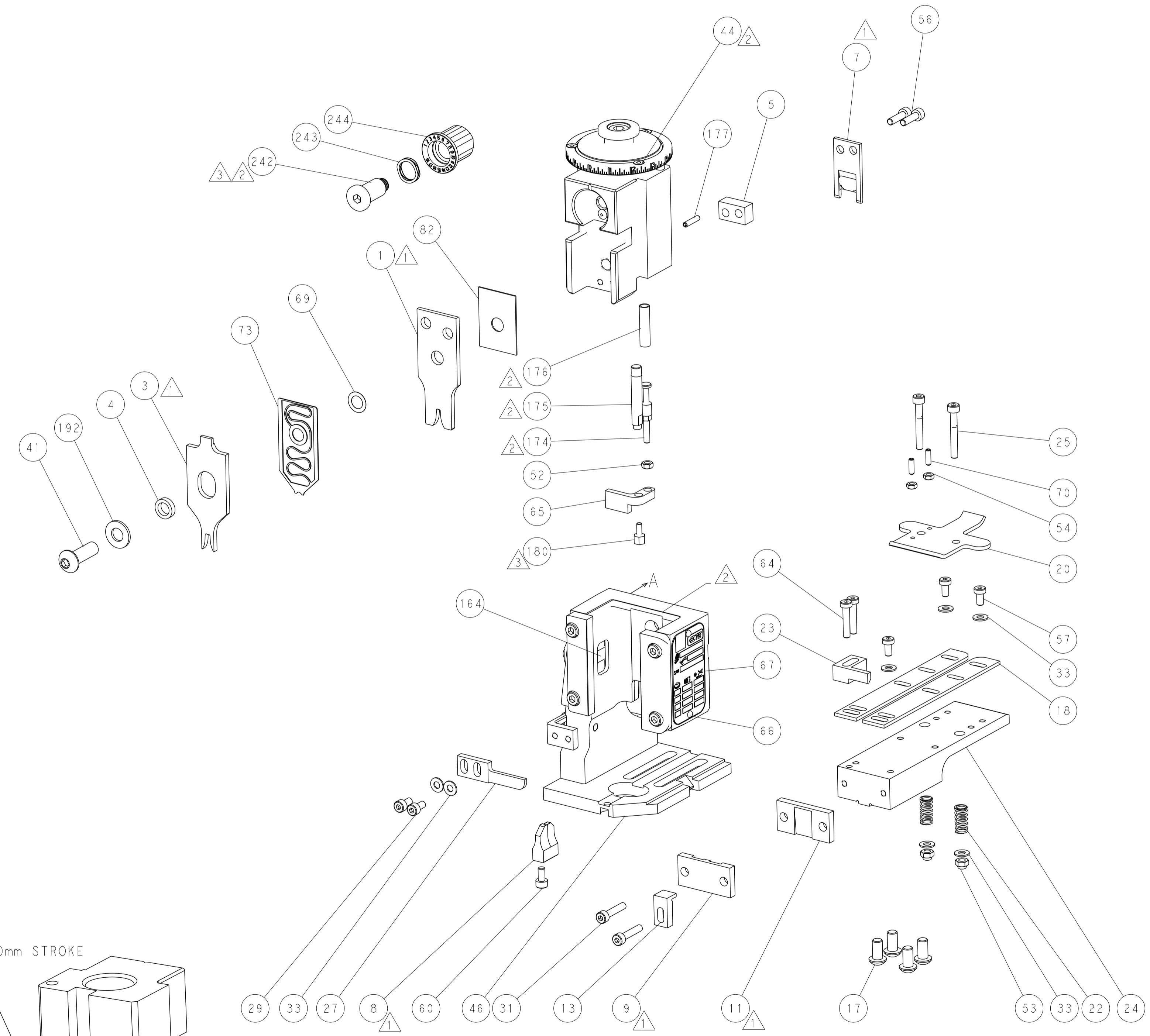
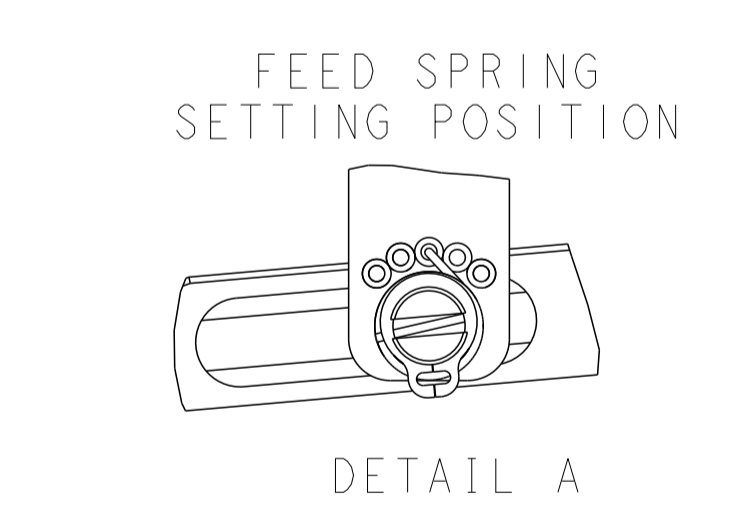
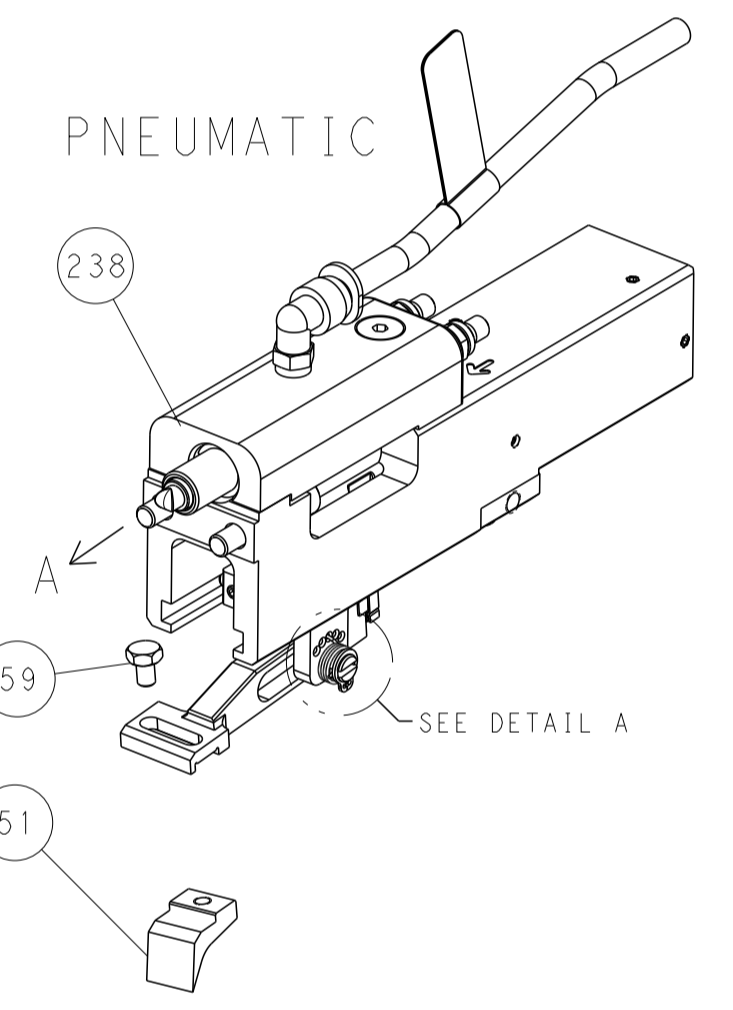
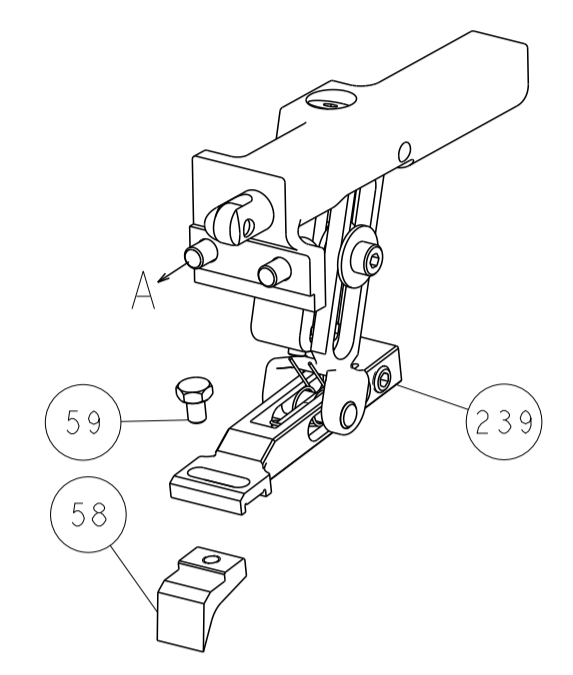
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG		REV	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	5 PLC ±	6 PLC ±
	ANGLES ±	FINISH ±					
MATERIAL				DESIGNER	DATE	APPROVED	DATE
				HOFFNER	06NOV2014	T. ELBIN	07NOV2014
				T. ELBIN	07NOV2014	T. ELBIN	07NOV2014
				TE Connectivity Harrisburg, PA 17105-3608			
				Ocean End Feed Applicator			
				SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
				A1	00779	2150073	
				Customer Accessible Production Drawing			
				SCALE	SHEET	OF	REV
				1:1	1	4	B

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

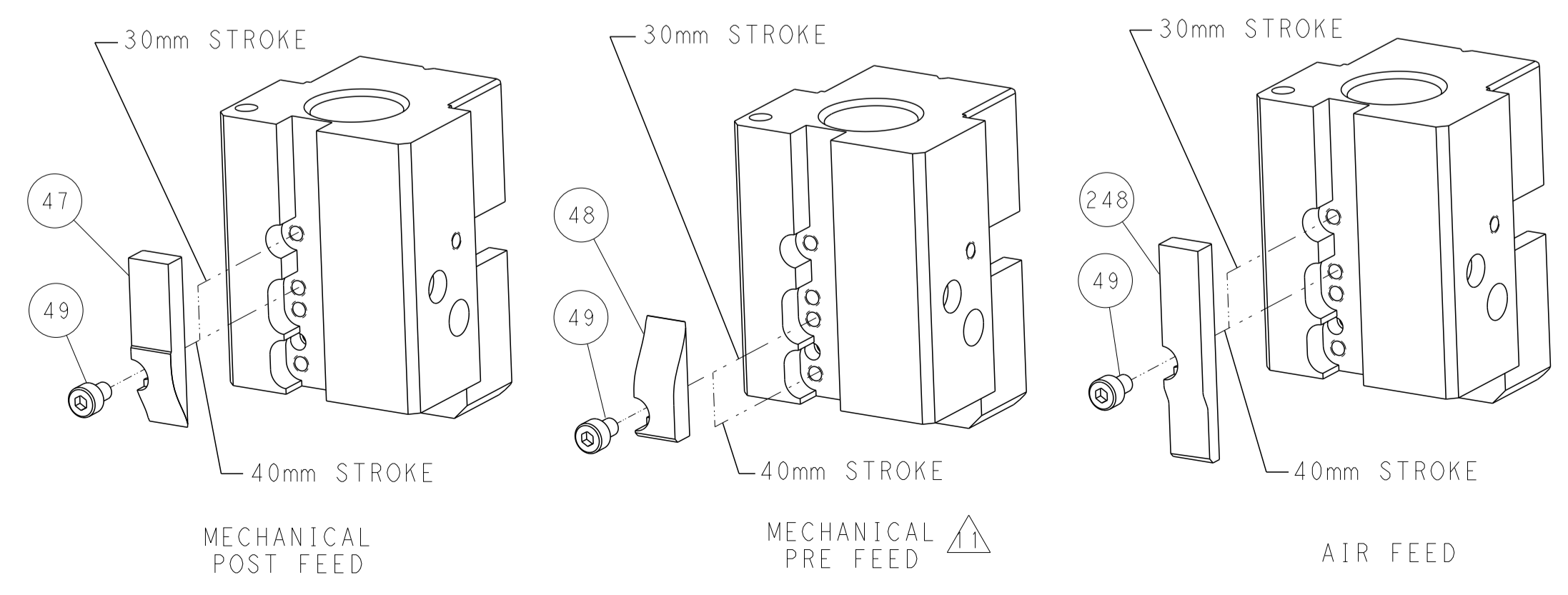


RAM AND HOLDDOWN SET-UP

FEED TYPE MECHANICAL



CAM POSITIONS

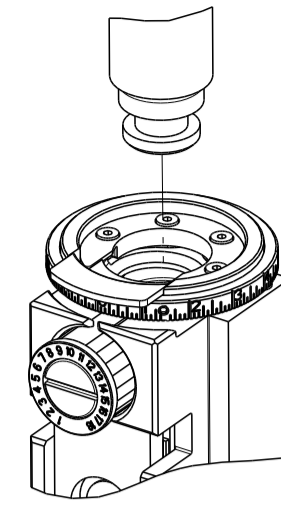


ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

<small>THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.</small>		DWN: HOFFNER 06NOV2014 CHK: T.ELBIN 07NOV2014 APVD: T.ELBIN 07NOV2014	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 APPLICATION SPEC: - SIZE: A1 CAGE CODE: 00779 DRAWING NO: ©=2150073	RESTRICTED TO: - SCALE: 1:1 SHEET: 2 of 4 REV: B
MATERIAL: - FINISH: -		WEIGHT: - Customer Accessible Production Drawing	SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150073-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2150073-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150073-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.54 mm [.100]	F
INSUL	3.56 mm [.140]	F
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: .110 SERIES FASTIN-FASTON TAB			
WIRE STRIP LENGTH 3.90-4.70 mm [.154-.185 IN]	INSULATION DIAMETER RANGE Ø2.03-3.05 mm [.080-.120 IN]		
TERMINAL APPLICATION SPECIFICATION 114-2025			
TERMINALS APPLIED			
TE TERMINAL 170014-1	TE TERMINAL 170014-5	TE TERMINAL 170014-6	TE TERMINAL 1-170014-5

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
16 AWG	1.85+/-0.05 [.073+/-0.002]	7.7
18 AWG	1.65+/-0.05 [.065+/-0.002]	9.3
20 AWG	1.55+/-0.05 [.061+/-0.002]	10.3



- 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 180.
- 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 LUBRICANT IS RECOMMENDED.
- 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)

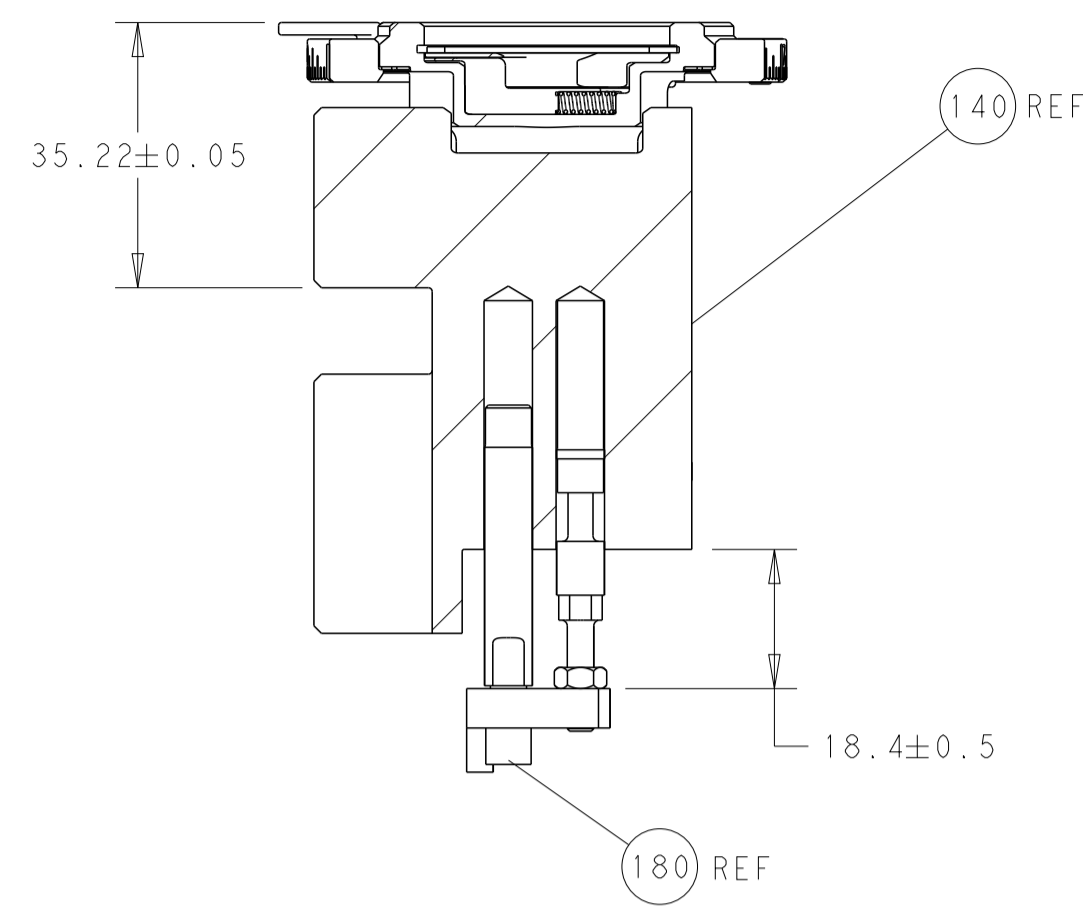
LOC	DIST	REVISIONS					
		P	LTN	DESCRIPTION	DATE	OWN	APVD
A	66	-	-	SEE SHEET 1	-	-	-

-	1	1	2119082-3	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
3	-	1	2119083-1	RETAINER, INSULATION DIAL	242
-	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	1	-	2844940-3	AIR FEED MODULE	238
-	1	1	1-18028-0	WASHER, FLAT, REG M8	192
-	4	4	2079383-9	SCR, BHSC, RoHS (M6 X 20)	186
3	-	1	1752354-4	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
-	1	1	455888-6	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	1901681-1	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	2-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 14	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	-	2063961-1	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	2168083-9	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	240825-1	PLATE, STRIP HOLD DOWN	23
-	2	2	2-22281-3	SPRING, COMPRESSION	22
-	1	1	1803292-4	DRAG	20
-	2	2	1901259-4	GUIDE, LOWER STRIP	18
-	1	1	1752360-1	SPACER,HOLD-DOWN	13
1	-	1	240644-1	PLATE, REAR SHEAR	11
-	-	-	-	-	10
-	1	1	690482-5	PLATE, FRONT SHEAR	9
1	1	1	6-1803001-5	ANVIL, COMBINATION, END FEED	8
1	-	1	2217206-7	BLADE, SLUG	7
-	-	-	-	-	6
-	1	1	7-240641-2	SPACER	5
-	1	1	238011-2	BLOCK, CRIMPER SPACER	4
1	1	1	5-2119582-2	CRIMPER, INSULATION F PREMIUM	3
-	-	-	-	-	2
1	1	1	2-1490019-1	CRIMPER, WIRE PREMIUM	1
-	-	-	-	-	1

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG		NAME	
mm	0 PLC ±	1 PLC ±	2 PLC ±	OFFNER	06NOV2014	TE Connectivity	Harrisburg, PA 17105-3608
	3 PLC ±	4 PLC ±	ANGLES ±	T. ELBIN	07NOV2014		
MATERIAL	FINISH			APVD	T. ELBIN		
				PRODUCT SPEC	07NOV2014		
				APPLICATION SPEC			
				WEIGHT			
				SCALE	1:1		
				RESTRICTED TO			

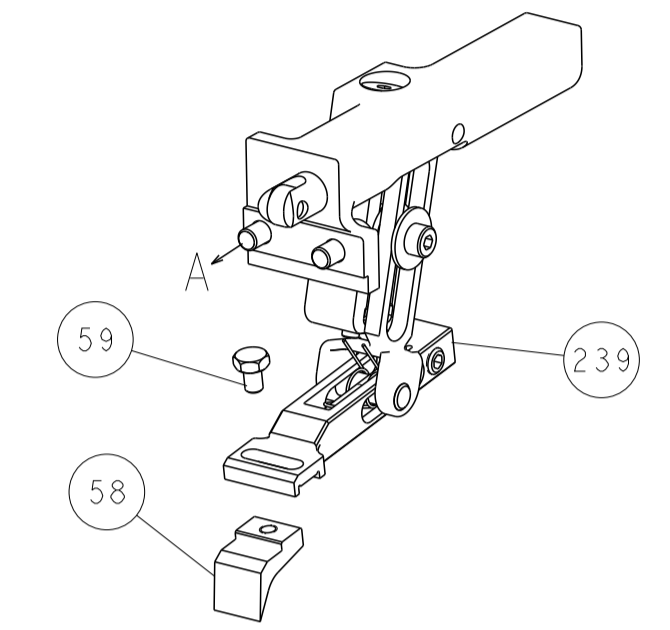
SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

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

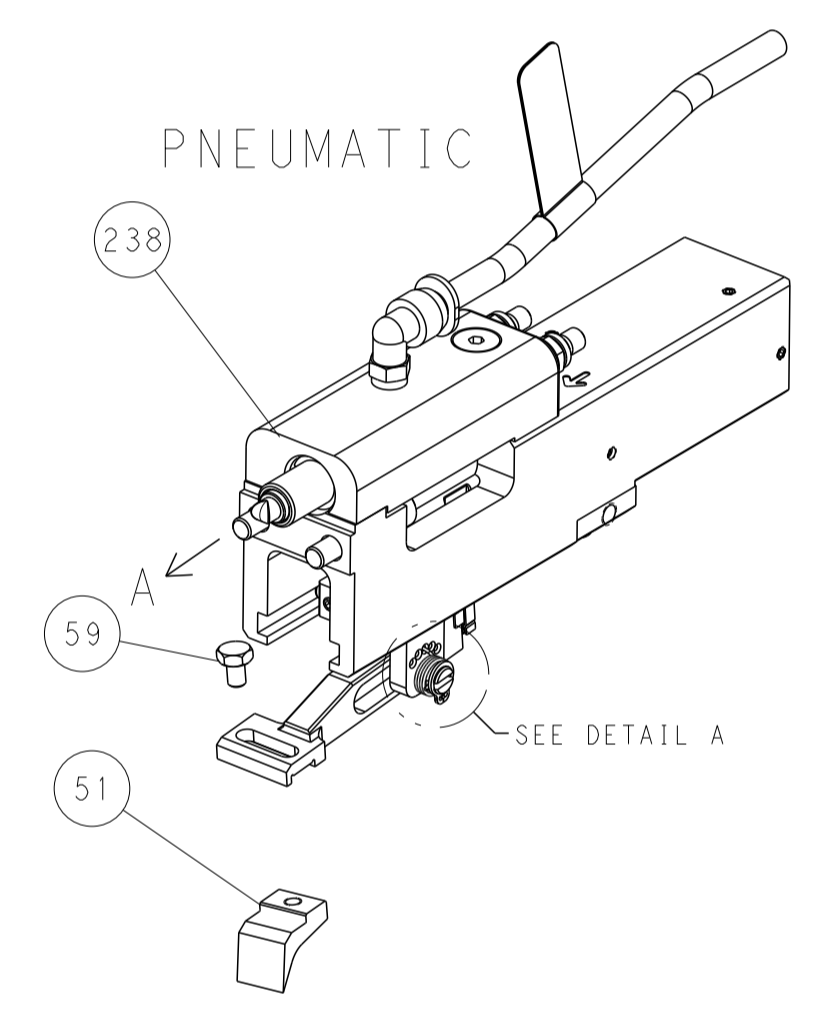


RAM AND HOLDDOWN SET-UP

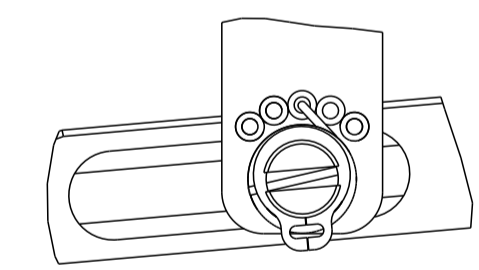
FEED TYPE
MECHANICAL



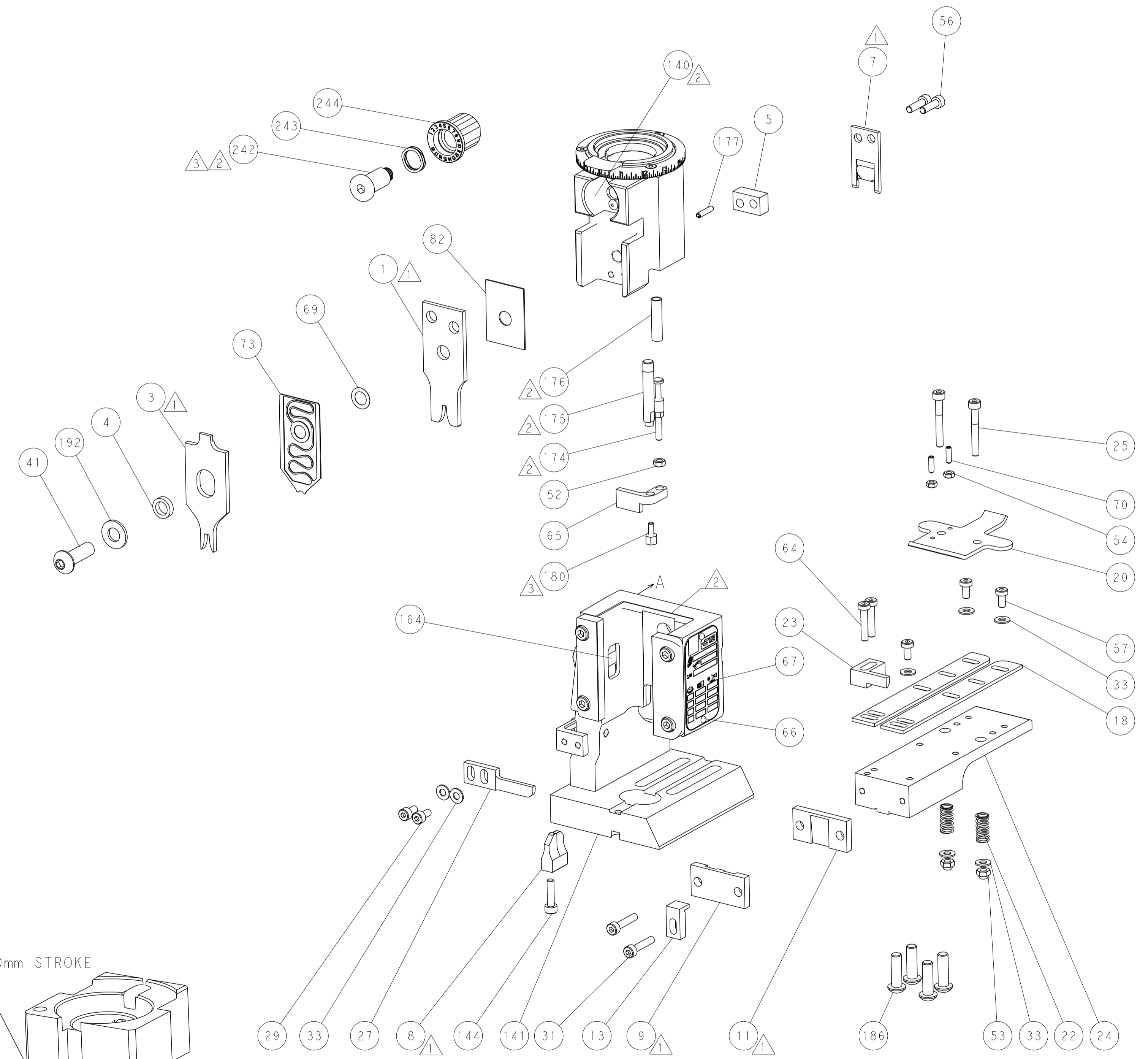
PNEUMATIC



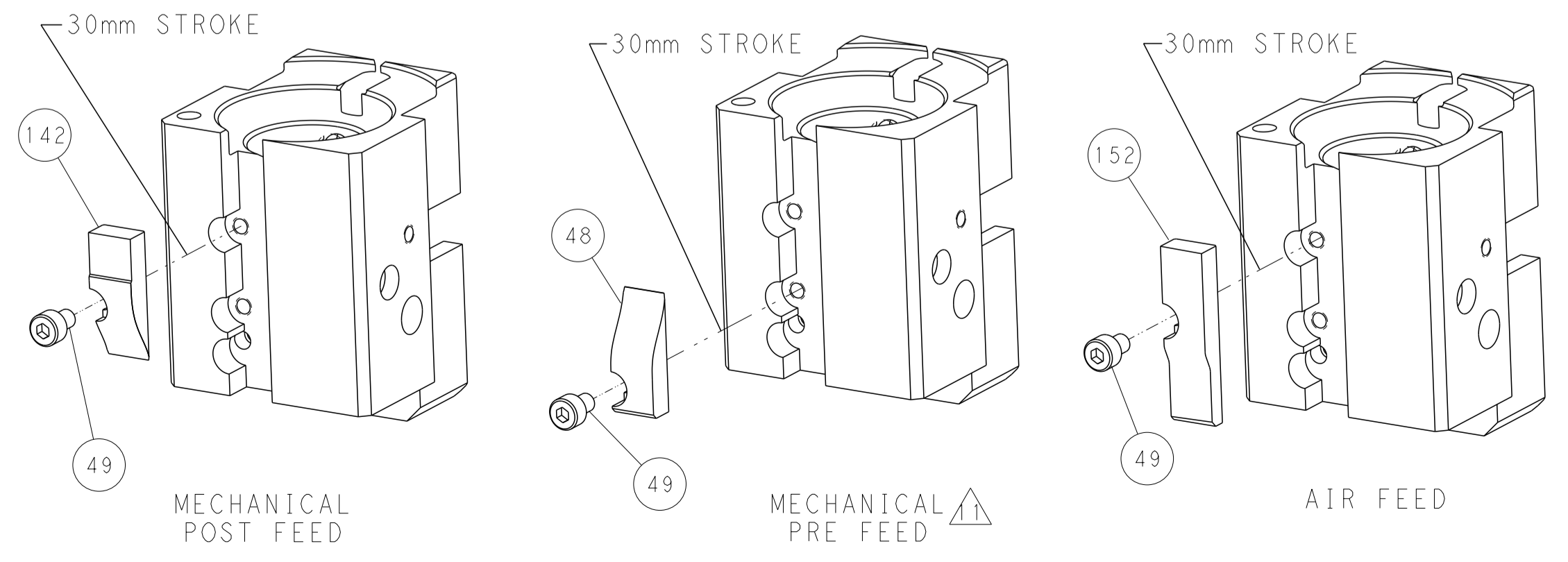
FEED SPRING
SETTING POSITION



DETAIL A



CAM POSITIONS



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

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN HOFFNER 06NOV2014		STE TE Connectivity	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	5 PLC ±	Harrisburg, PA 17105-3608
MATERIAL:	FINISH:	WEIGHT:	SCALE:	SIZE:	CAGE CODE:	DRAWING NO:	RESTRICTED TO:
			1:1	A1	00779	©=2150073	
Customer Accessible Production Drawing				SHEET 4 OF 4 REV B			