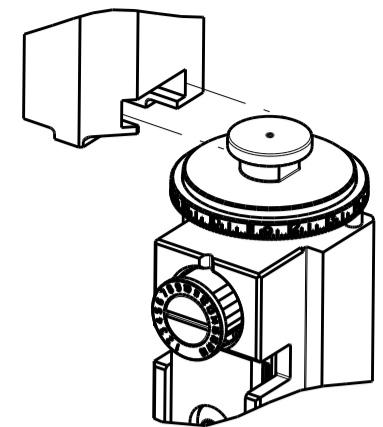


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150444-2	E	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150444-2	E	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150444-7	A	CRIMP TOOLING KIT	-

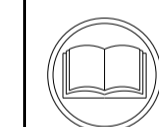
ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	3.94 mm [.155]	F
INSUL	5.33 mm [.210]	F
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION			
TERMINAL NAME: RING			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
4.63-4.93 mm [.182-.194 IN]		Ø3.05-4.57 mm [.120-.180 IN]	
TERMINAL APPLICATION SPECIFICATION	114-2084		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
42751-1	42751-2	42751-3	42751-5
42751-6	42752-1	42752-2	42752-3
42938-1	42938-2	640011-1	

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
14 AWG	2.26 +/- 0.05 [.089 +/- .002]	6.9
16 AWG	2.08 +/- 0.05 [.082 +/- .002]	9.2



- 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.

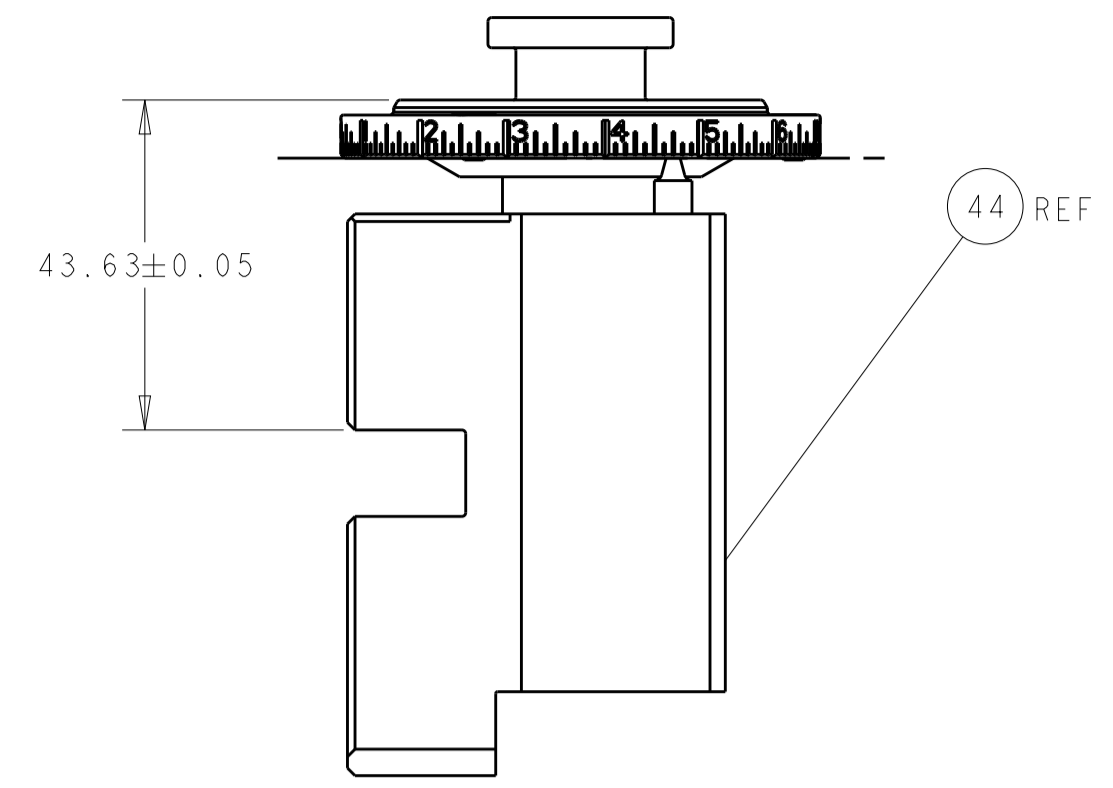
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		C		ECR-19-003765	08MAR2019	TB	CT
		D		ECR-19-005616	08APR2019	FJ	CT
		E		ECR-20-016922	01DEC2020	FJ	TE

-	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	2844940-4	AIR FEED MODULE	238	
-	1	1	1-18028-0	WASHER, FLAT, REG M8	192	
-	REF	REF	994970-2	COUNTER, MAGNETIC	164	
-	1	1	455888-4	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	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	2168400-4	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	2063961-1	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	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	
-	2	2	2-22281-3	SPRING, COMPRESSION	22	
-	1	1	1803292-4	DRAG	20	
-	1	1	1901696-4	STRIP GUIDE, REAR	19	
-	1	1	1901695-4	STRIP GUIDE, FRONT	18	
-	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17	
-	1	1	240644-1	PLATE, REAR SHEAR	11	
-	2	2	1-240645-6	SPACER, SHEAR PLATE	10	
-	1	1	2-240642-4	PLATE, FRONT SHEAR	9	
1	2	1	1333223-6	ANVIL, COMBINATION	8	
-	1	1	9-240651-0	BLADE, SLUG	7	
-	-	-	-	-	6	
-	1	1	7-240641-7	SPACER	5	
-	1	1	4-238011-4	BLOCK, CRIMPER SPACER	4	
1	2	1	9-2119582-7	CRIMPER, INSULATION F PREMIUM	3	
-	1	1	455888-6	SPACER, CRIMPER	2	
1	2	1	456415-4	CRIMPER, WIRE .155 F PREMIUM	1	
-	77	72	2	PART NO	DESCRIPTION	ITEM NO

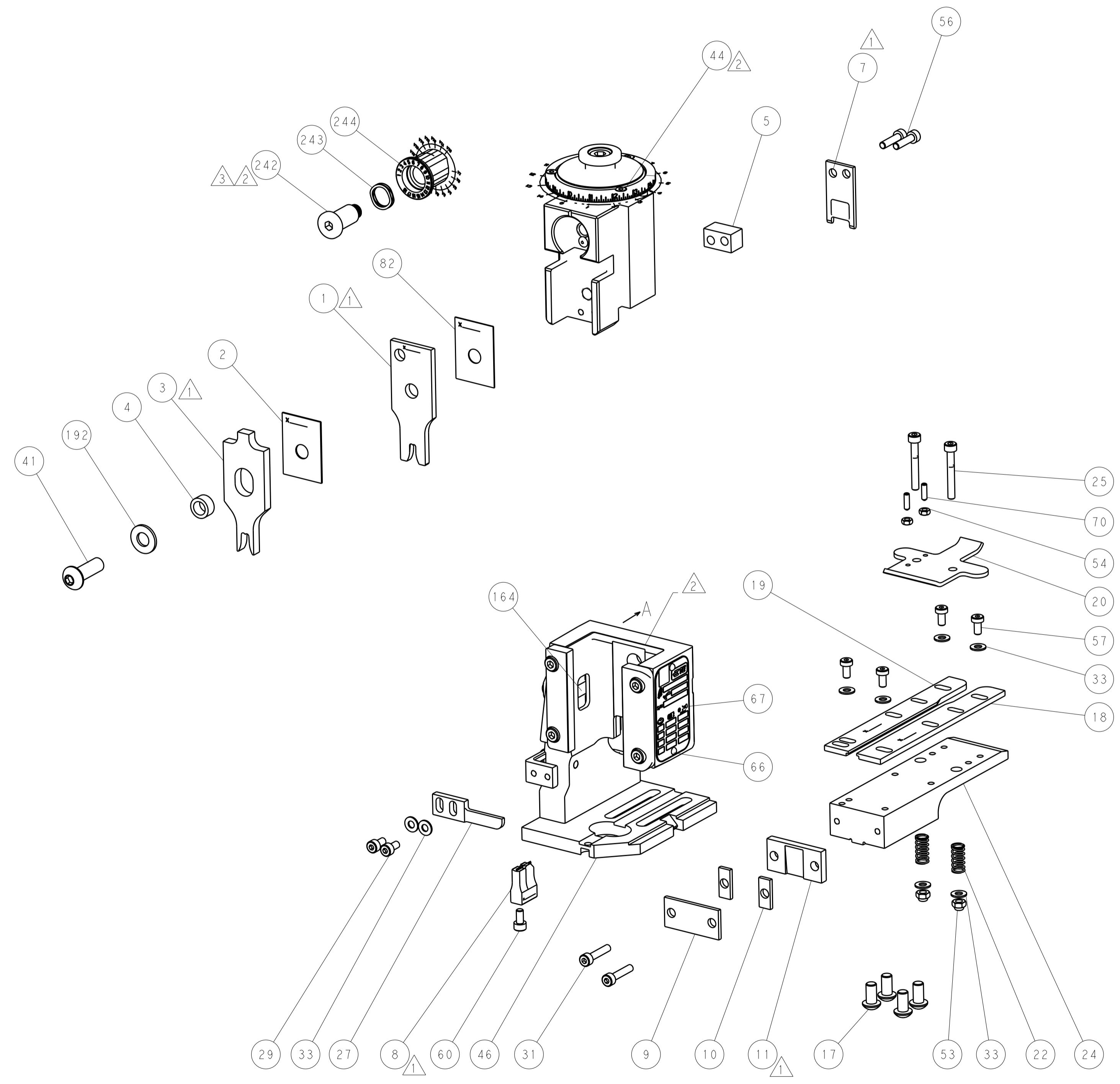
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		OWN	J. HOU	4 JUNE 2014	TE Connectivity Harrisburg, PA 17105-3608
mm		0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		CHK	Y. YIN	4 JUNE 2014	
MATERIAL		FINISH		APVD	J. GUO	4 JUNE 2014	NAME
				PRODUCT SPEC		Ocean End Feed Applicator	
				APPLICATION SPEC		SIZE CAGE CODE DRAWING NO RESTRICTED TO	
				WEIGHT		A1 00779 C=2150444	
				Customer Accessible Production Drawing		SCALE 1:1 SHEET 1 OF 4 REV E	

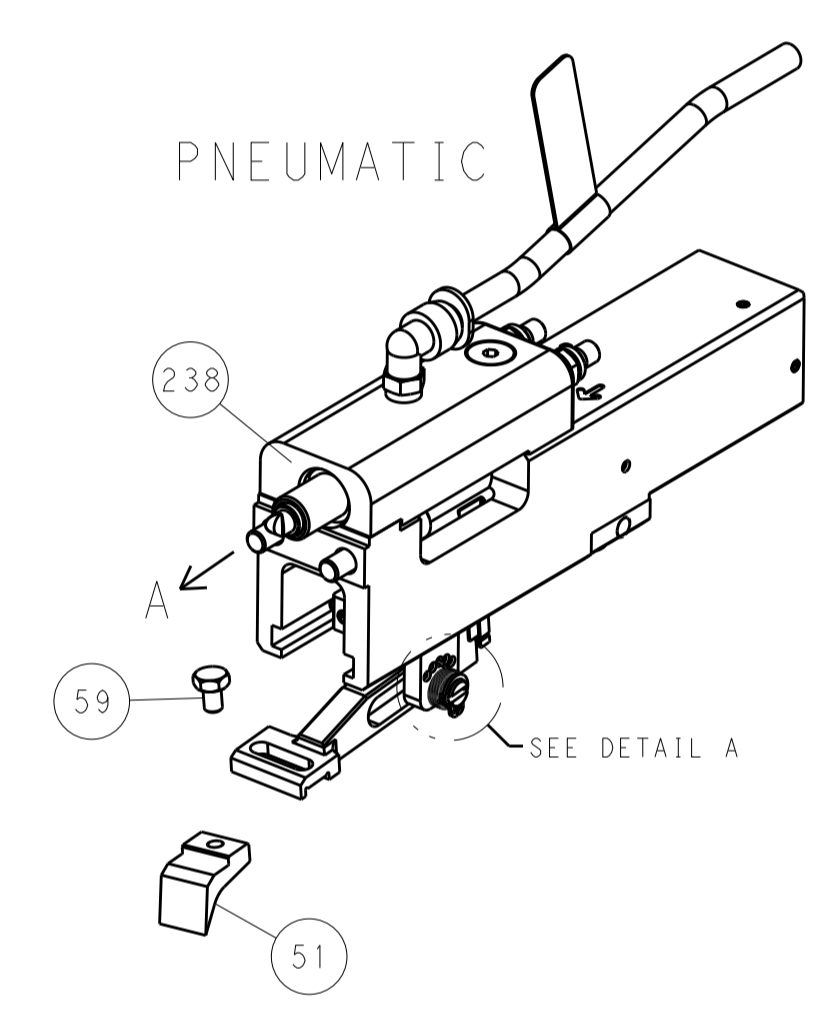
LOC	DIST	REV	DATE	BY	APP'D
A	66				
REVISIONS			DESCRIPTION	DATE	BY
			SEE SHEET 1		



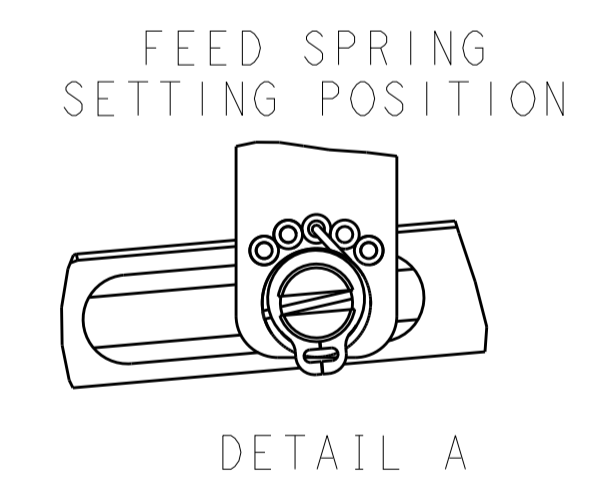
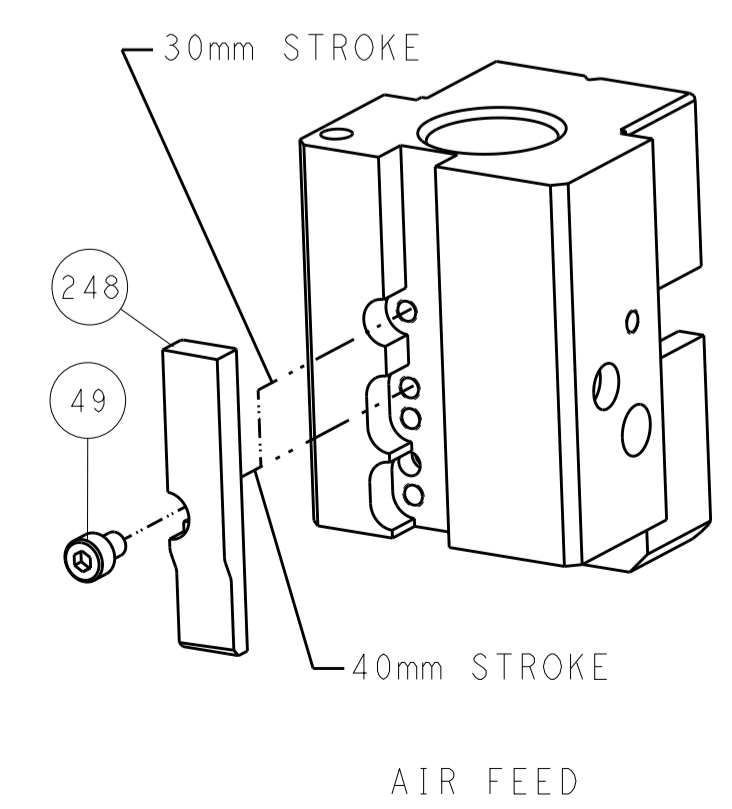
RAM SET-UP



FEED TYPE



CAM POSITION

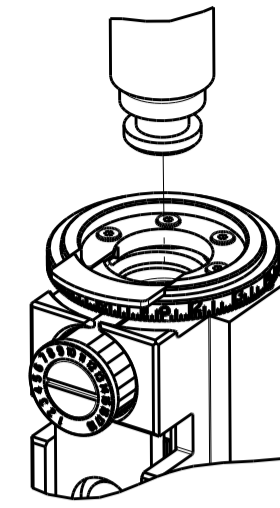


ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

<small>THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.</small>		DWN: J.HOU 4JUNE2014 CHK: Y.YIN 4JUNE2014 APVD: H.GUO 4JUNE2014	NAME: Ocean End Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2150444	TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± MATERIAL: - FINISH: -	PRODUCT SPEC: - APPLICATION SPEC: - WEIGHT: - SCALE: 1:1	SHEET 2 OF 4 REV E	RESTRICTED TO: -	CUSTOMER ACCESSIBLE PRODUCTION DRAWING

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COPYRIGHT 20 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.			
PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150444-2	E	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150444-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	3.94 mm [.155]	F
INSUL	5.33 mm [.210]	F
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: RING			
WIRE STRIP LENGTH 4.63-4.93 mm [.182-.194 IN]		INSULATION DIAMETER RANGE 3.05-4.57 mm [.120-.180 IN]	
TERMINAL APPLICATION SPECIFICATION	114-2084	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
42751-1	42751-2	42751-3	42751-5
42751-6	42752-1	42752-2	42752-3
42938-1	42938-2	640011-1	

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
14 AWG	2.26+/-0.05 [.089+/-0.002]	6.9
16 AWG	2.08+/-0.05 [.082+/-0.002]	9.2

- 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 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.

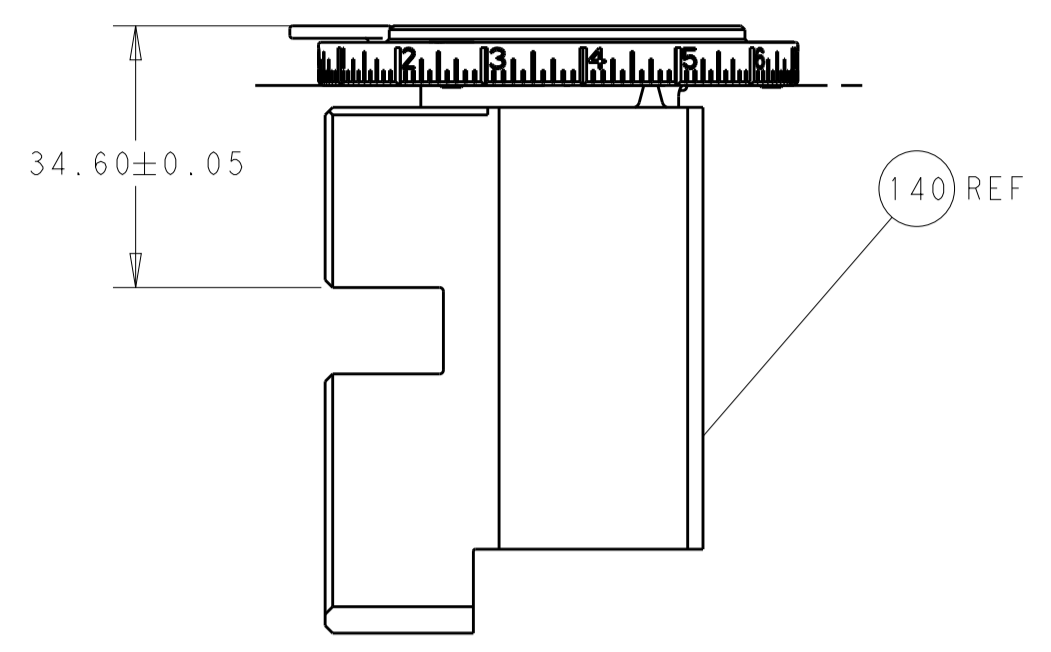
LOC	DIST	REV	LTN	DESCRIPTION	DATE	OWN	APVD
A	66	-	-	SEE SHEET 1	-	-	-

-	1	2119082-7	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
-	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	455888-4	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	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	4	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	2063961-1	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	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
-	2	2-22281-3	SPRING, COMPRESSION	22
-	1	1803292-4	DRAG	20
-	1	1901696-4	STRIP GUIDE, REAR	19
-	1	1901695-4	STRIP GUIDE, FRONT	18
-	1	240644-1	PLATE, REAR SHEAR	11
-	2	1-240645-6	SPACER, SHEAR PLATE	10
-	1	2-240642-4	PLATE, FRONT SHEAR	9
-	1	1333223-6	ANVIL, COMBINATION	8
-	1	9-240651-0	BLADE, SLUG	7
-	-	-	-	6
-	1	7-240641-7	SPACER	5
-	1	4-238011-4	BLOCK, CRIMPER SPACER	4
-	1	9-2119582-7	CRIMPER, INSULATION F PREMIUM	3
-	1	455888-6	SPACER, CRIMPER	2
-	1	456415-4	CRIMPER, WIRE .155 F 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)

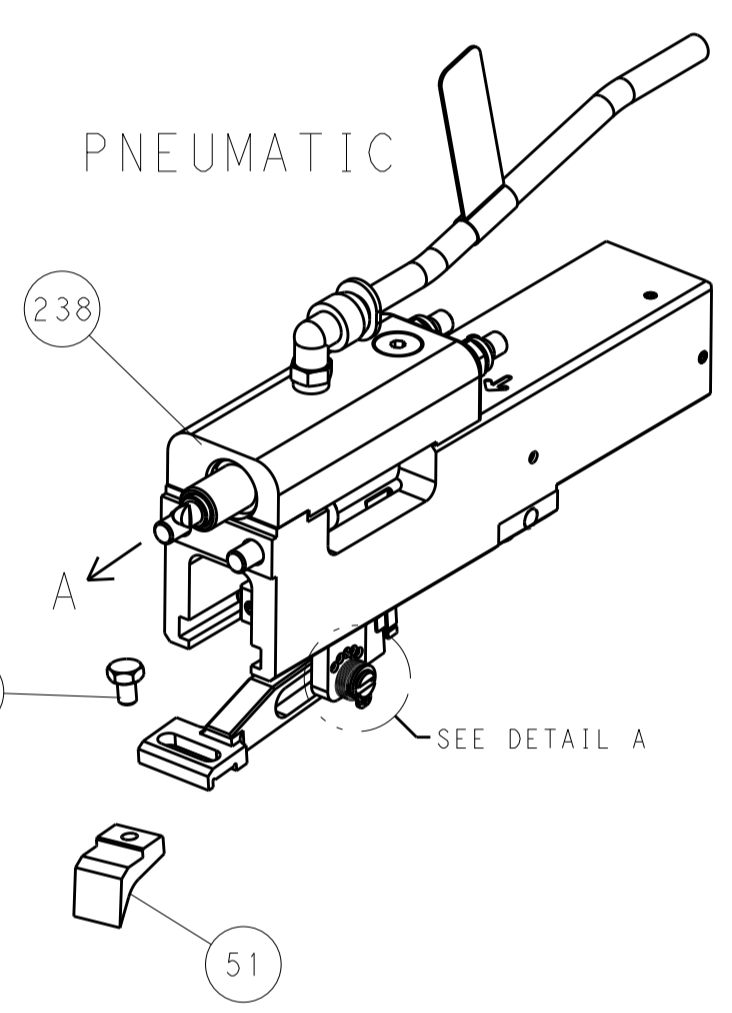
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		OWN: J. HOU 4JUNE2014	STE TE Connectivity Harrisburg, PA 17105-3608
0 PLC ±		1 PLC ±		CHK: Y. YIN 4JUNE2014	
2 PLC ±		3 PLC ±		APVD: H. GUO 4JUNE2014	NAME: Ocean End Feed Applicator
4 PLC ±		ANGLES		PRODUCT SPEC	SIZE: CAGE CODE DRAWING NO
MATERIAL		FINISH		APPLICATION SPEC	RESTRICTED TO
-		-		WEIGHT	A1 00779 C=2150444
-		-		Customer Accessible Production Drawing	SCALE: 1:1 SHEET 3 OF 4 REV E

LOC		DIST		REVISONS			
A	66	P	LTM	DESCRIPTION	DATE	DWN	APVD
		-		SEE SHEET 1	-	-	-

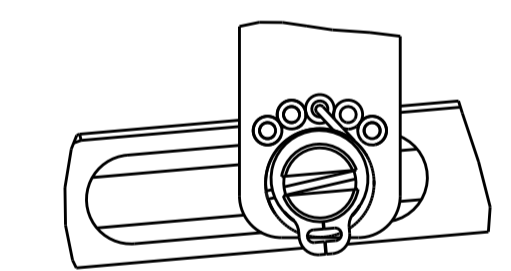


RAM SET-UP

FEED TYPE

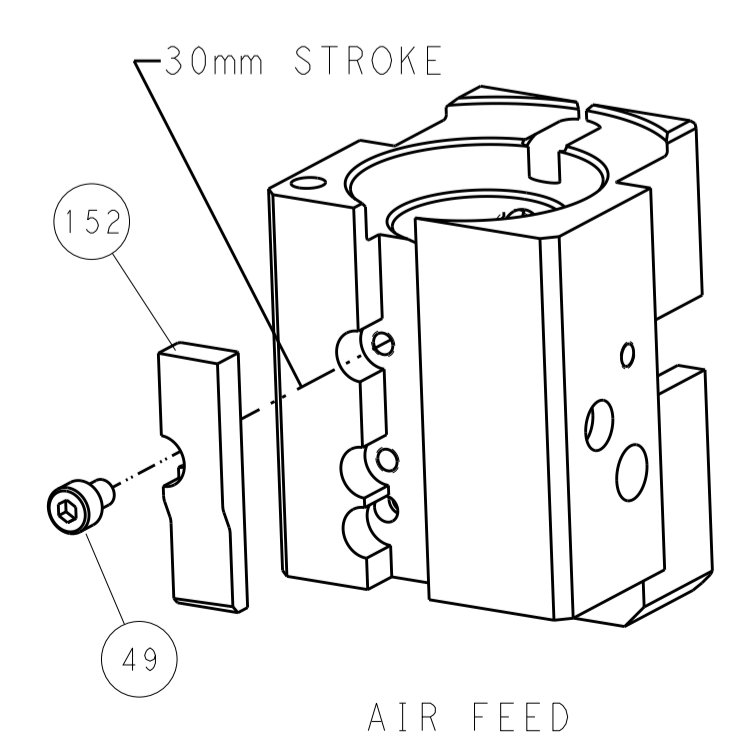


FEED SPRING SETTING POSITION

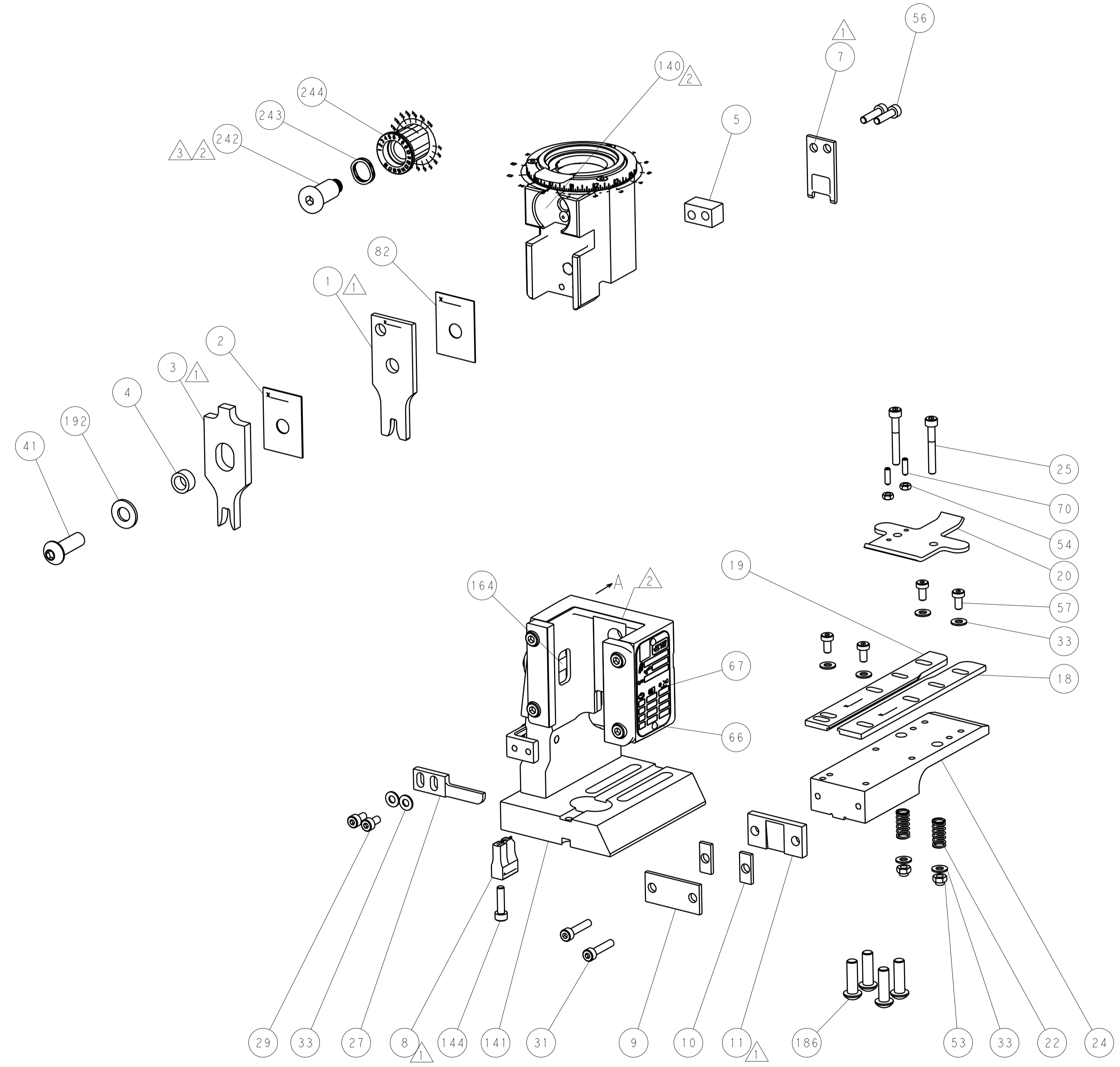


DETAIL A

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 ±		NAME Ocean End Feed Applicator PRODUCT SPEC APPLICATION SPEC SIZE CAGE CODE DRAWING NO. RESTRICTED TO A1 00779 C=2150444	
MATERIAL:		FINISH:		WEIGHT: Customer Accessible Production Drawing SCALE 1:1 SHEET 4 OF 4 REV E	