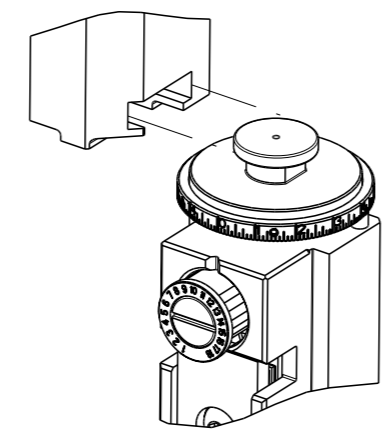


THIS DRAWING IS UNPUBLISHED.	RELEASED FOR PUBLICATION	20	
COPYRIGHT 20 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.			
PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150414-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150414-2	B	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150414-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.79 mm [.110]	F
INSUL	3.94 mm [1.55]	F
APPLICATOR INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: RECEPTACLE, CLUSTER PIN .125 DIA			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
.230-.260 IN [5.84-6.60 mm]		∅.120-.130 IN [3.05-3.30 mm]	
TERMINAL APPLICATION SPECIFICATION	114-2019	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
1217176-1	1217176-4	62244-3	
1217176-3	1217176-5	62244-6	

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
16 AWG	2.01 +/- 0.05 [1.079 +/- .002]	7.1
18 AWG	1.85 +/- 0.05 [1.073 +/- .002]	8.7

- 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 LUBRICANT IS RECOMMENDED.
- 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.

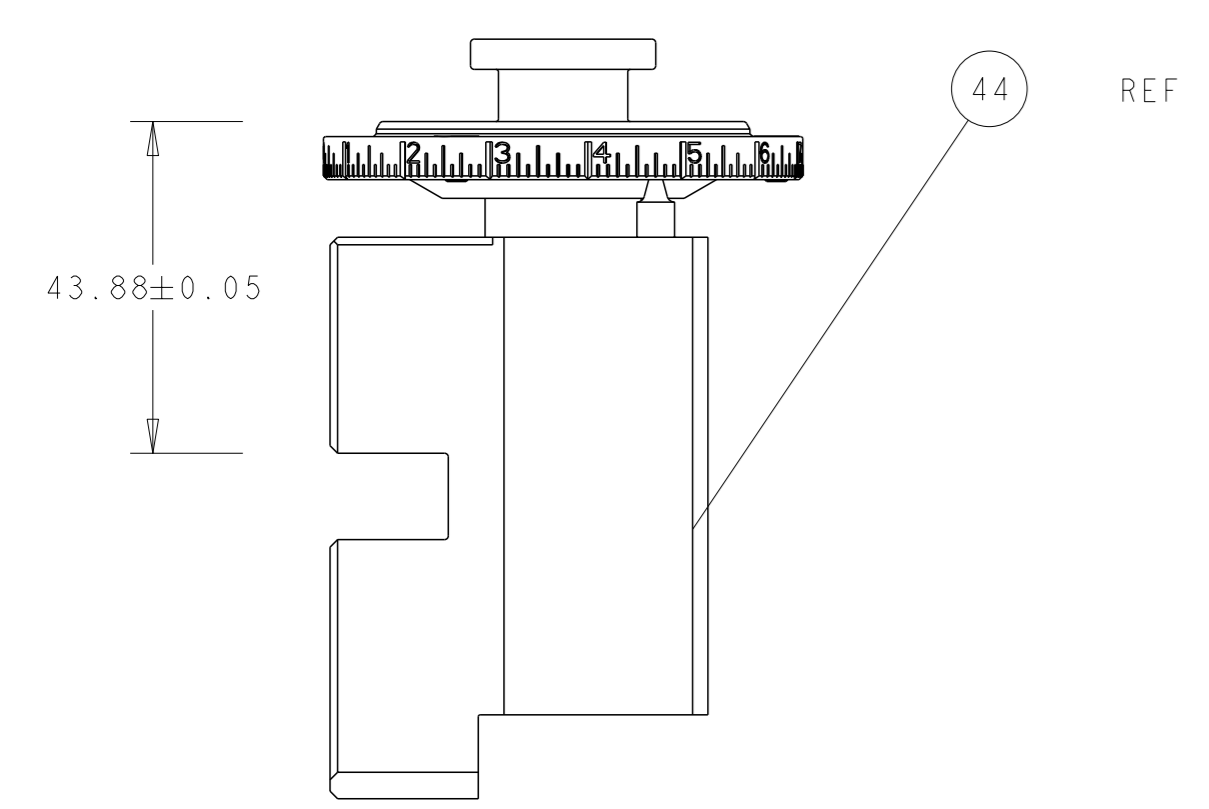
ATLANTIC VERSION  
Shown on sheets 1 of 4 & 2 of 4  
(Pacific version shown on sheets 3 of 4 & 4 of 4)

LOC	DIST	REVISIONS					
A	66	P	LY#	DESCRIPTION	DATE	OWN	APVD
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		B		ECR-19-012418	07AUG2019	JAH	RR

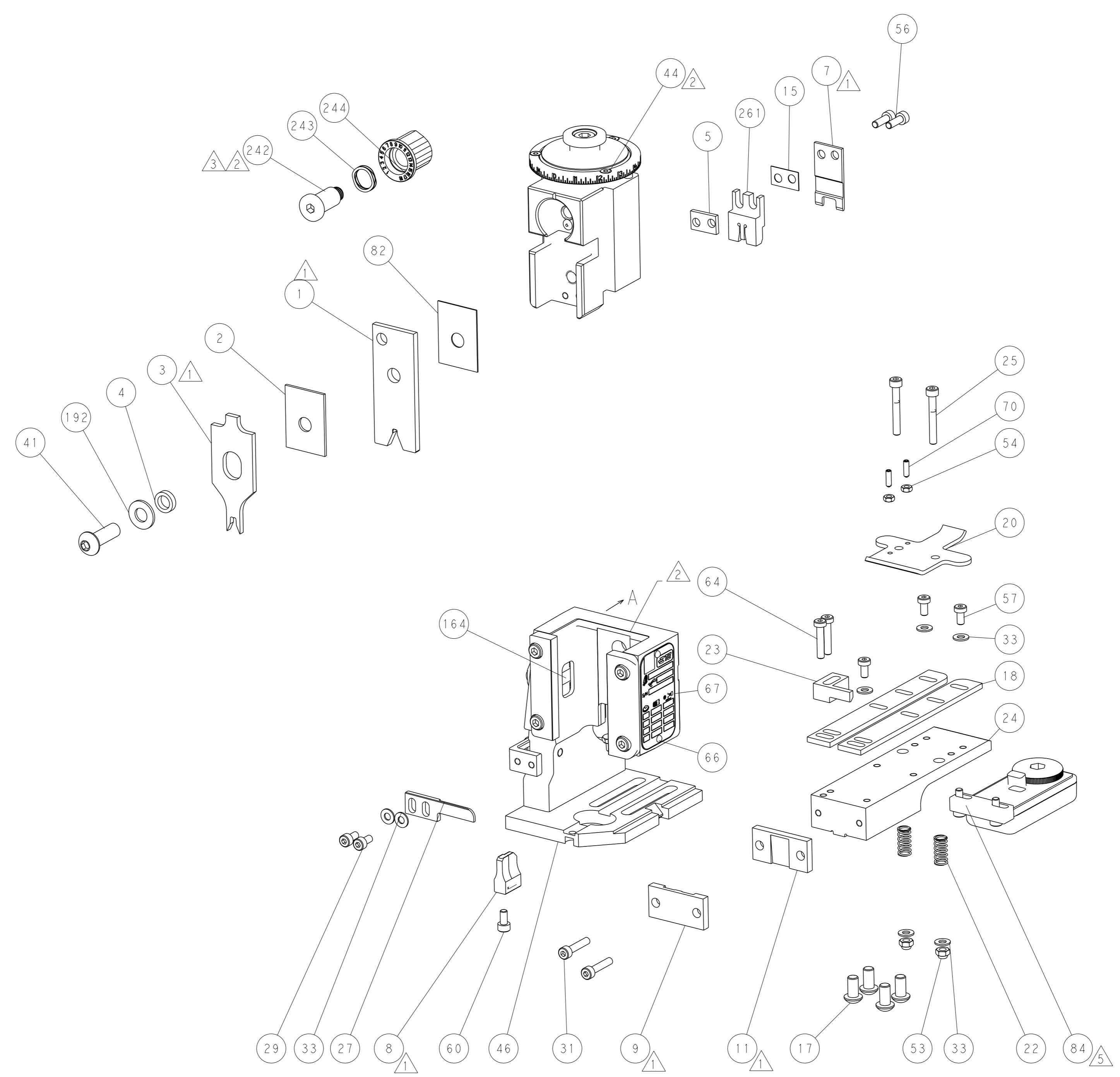
-	1	1	217573-2	TOOL, SIZING	261
-	1	1	2119641-1	FEED CAM, AIR FEED	248
-	1	1	2119082-7	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	1	2844940-3	AIR FEED MODULE	238
-	1	1	1-18028-0	WASHER, FLAT, REG M8	192
-	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	1	1	2119955-2	ASSY, LUBRICATOR, END FEED	84
-	1	1	455888-5	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
-	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	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	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
-	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	240639-3	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	240825-2	PLATE, STRIP HOLD DOWN	23
-	2	2	2-22281-3	SPRING, COMPRESSION	22
-	1	1	1803292-4	DRAG	20
-	2	2	1901259-6	GUIDE, LOWER STRIP	18
-	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17
-	1	1	5-240641-8	SPACER	15
-	1	1	240644-1	PLATE, REAR SHEAR	11
-	-	-	-	-	10
-	1	1	690482-3	PLATE, FRONT SHEAR	9
1	2	1	8-1633384-1	ANVIL, COMBINATION	8
1	1	1	9-240651-4	BLADE, SLUG	7
-	-	-	-	-	6
-	1	1	8-240641-6	SPACER	5
-	1	1	238011-2	BLOCK, CRIMPER SPACER	4
1	2	1	5-1633962-9	CRIMPER, INSULATION F PREMIUM	3
-	1	1	1-455888-4	SPACER, CRIMPER	2
1	2	1	1-1633730-8	CRIMPER, WIRE	1
-	77	72	-2	PART NO	ITEM NO

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		OWN	K. STAKEM	19MAR2014	TE Connectivity Harrisburg, PA 17105-3608
mm	0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ±	±	±	CHK	G. BAILEY	19MAR2014	
				APVD	T. ELBIN	19MAR2014	NAME
MATERIAL		FINISH		APPLICATION SPEC		Ocean End Feed Applicator	
-		-		SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
-		-		WEIGHT	A1	00779	Customer Accessible Production Drawing
-		-		SCALE	1:1	SHEET 1 of 4	REV B

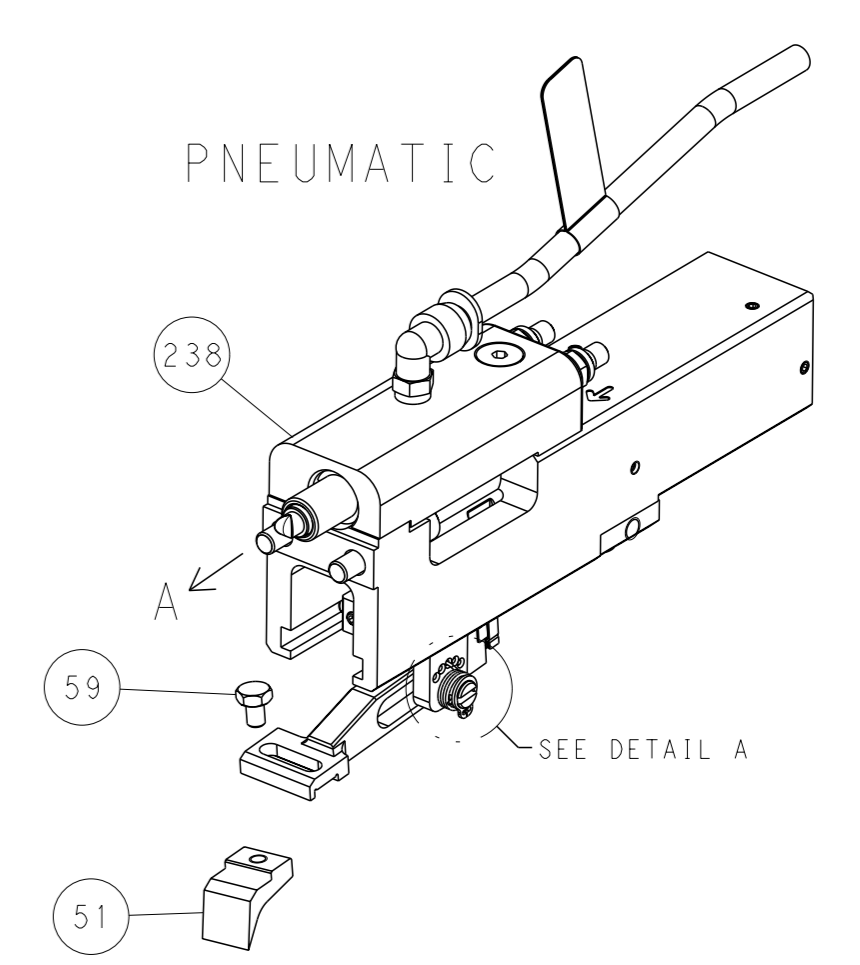
LOC		DIST		REVISIONS			
A	66	P	LYR	DESCRIPTION	DATE	OWN	APVD
		-		SEE SHEET 1			



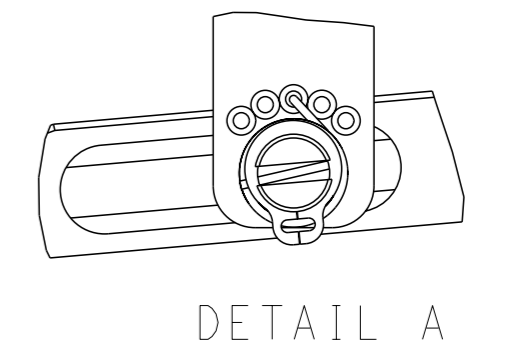
RAM SET-UP



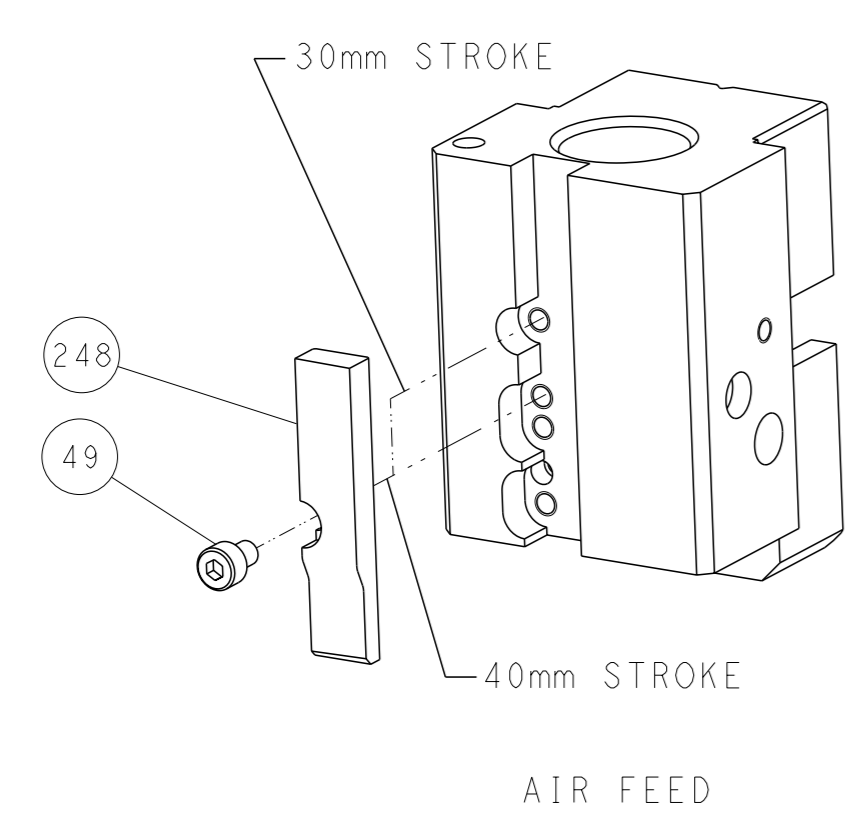
FEED TYPE



FEED SPRING SETTING POSITION



CAM POSITIONS

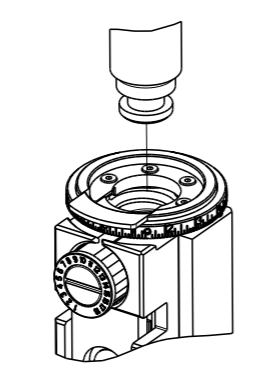


ATLANTIC VERSION  
 Shown on sheets 1 of 4 & 2 of 4  
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

<small>THIS DRAWING IS 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>		DWN: K. STAKEM 19MAR2014 CHK: G. BAILEY 19MAR2014 APVD: J. ELBIN 19MAR2014	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: ©=2150414	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
2-2150414-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150414-7	A	CRIMP TOOLING KIT	-

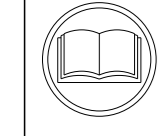
PACIFIC VERSION TERMINATOR  
 INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.79 mm [.110]	F
INSUL	3.94 mm [.155]	F
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: RECEPTACLE, CLUSTER PIN .125 DIA			
WIRE STRIP LENGTH .230-.260 IN [5.84-6.60 mm]		INSULATION DIAMETER RANGE Ø.120-.130 IN [3.05-3.30 mm]	
TERMINAL APPLICATION SPECIFICATION	114-2019	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
1217176-1	1217176-4	62244-3	
1217176-3	1217176-5	62244-6	

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
16 AWG	2.01+/-0.05 [1.079+/-0.002]	7.1
18 AWG	1.85+/-0.05 [1.073+/-0.002]	8.7



- 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 LUBRICANT IS RECOMMENDED.
- 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.

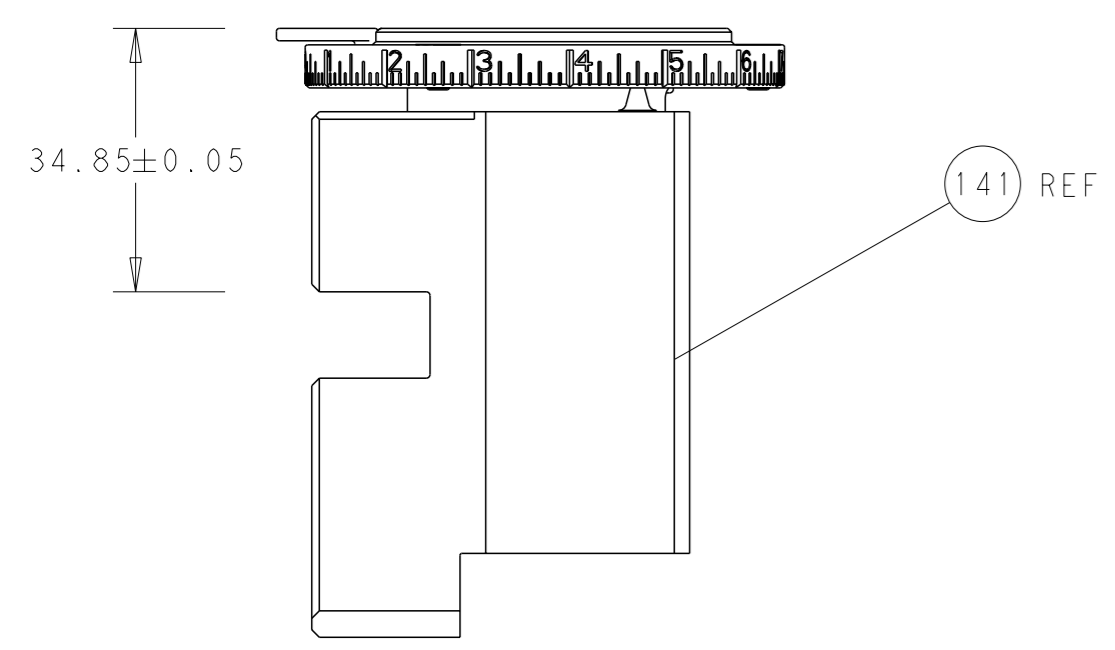
LOC	DIST	REVISIONS					
		P	LY#	DESCRIPTION	DATE	OWN	APVD
A	66	-	-	SEE SHEET 1	-	-	-

-	1	217573-2	TOOL, SIZING	261	
-	1	2119082-7	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	
-	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	
5	-	1	2119955-2	ASSY, LUBRICATOR, END FEED	84
-	1	455888-5	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	
-	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	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	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	
-	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	240639-3	STRIPPER (MACHINING)	27	
-	2	1-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 30	25	
-	1	1752371-5	PLATE, STRIP GUIDE	24	
-	1	240825-2	PLATE, STRIP HOLD DOWN	23	
-	2	2-22281-3	SPRING, COMPRESSION	22	
-	1	1803292-4	DRAG	20	
-	2	1901259-6	GUIDE, LOWER STRIP	18	
-	1	5-240641-8	SPACER	15	
1	-	1	240644-1	PLATE, REAR SHEAR	11
-	-	-	-	10	
1	-	1	690482-3	PLATE, FRONT SHEAR	9
1	1	1	8-1633384-1	ANVIL, COMBINATION	8
1	-	1	9-240651-4	BLADE, SLUG	7
-	-	-	-	6	
-	1	1	8-240641-6	SPACER	5
-	1	1	238011-2	BLOCK, CRIMPER SPACER	4
1	1	1	5-1633962-9	CRIMPER, INSULATION F PREMIUM	3
-	1	1	1-455888-4	SPACER, CRIMPER	2
1	1	1	1-1633730-8	CRIMPER, WIRE	1

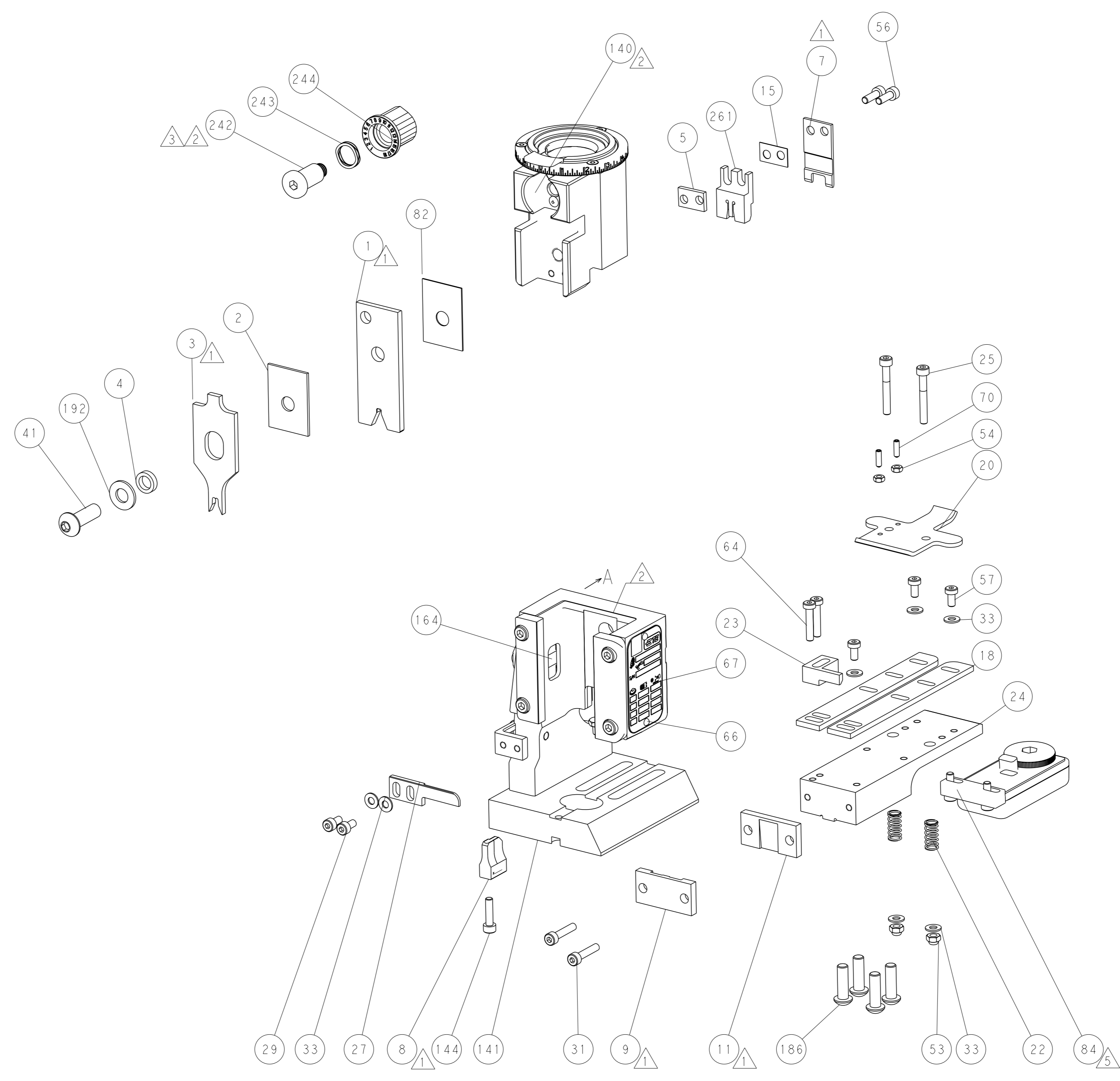
PACIFIC VERSION  
 Shown on sheets 3 of 4 & 4 of 4  
 (Atlantic version shown on sheets 1 of 4 & 2 of 4)

DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH ±		DWN K. STAKEM 19MAR2014 CHK G. BAILEY 19MAR2014 APVD T. ELBIN 19MAR2014		NAME Ocean End Feed Applicator	
MATERIAL:		WEIGHT:		SIZE: A1 CAGE CODE: 00779 DRAWING NO: ©=2150414		RESTRICTED TO:	
Customer Accessible Production Drawing				SCALE: 1:1		SHEET 3 of 4 REV B	

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

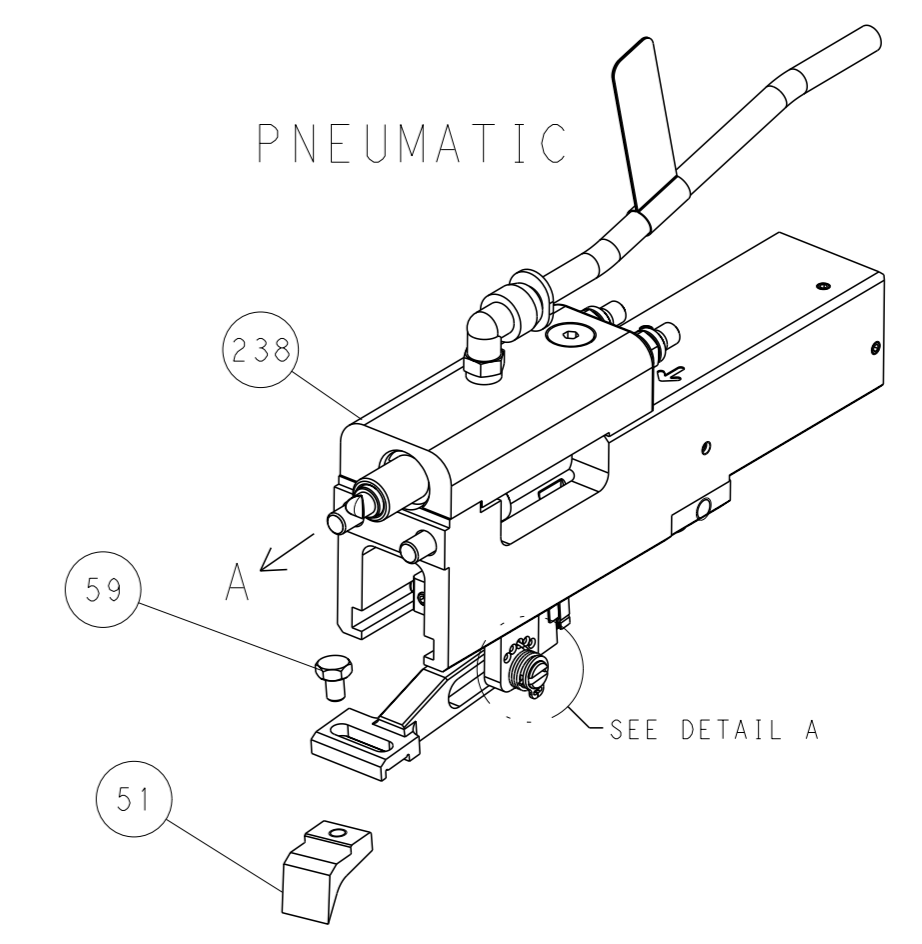


RAM SET-UP

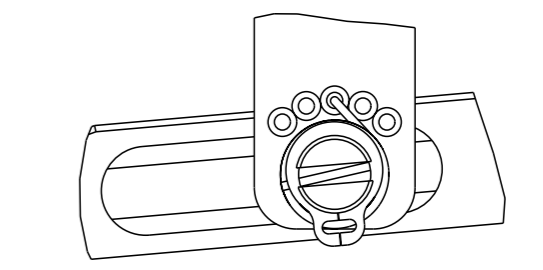


FEED TYPE

PNEUMATIC

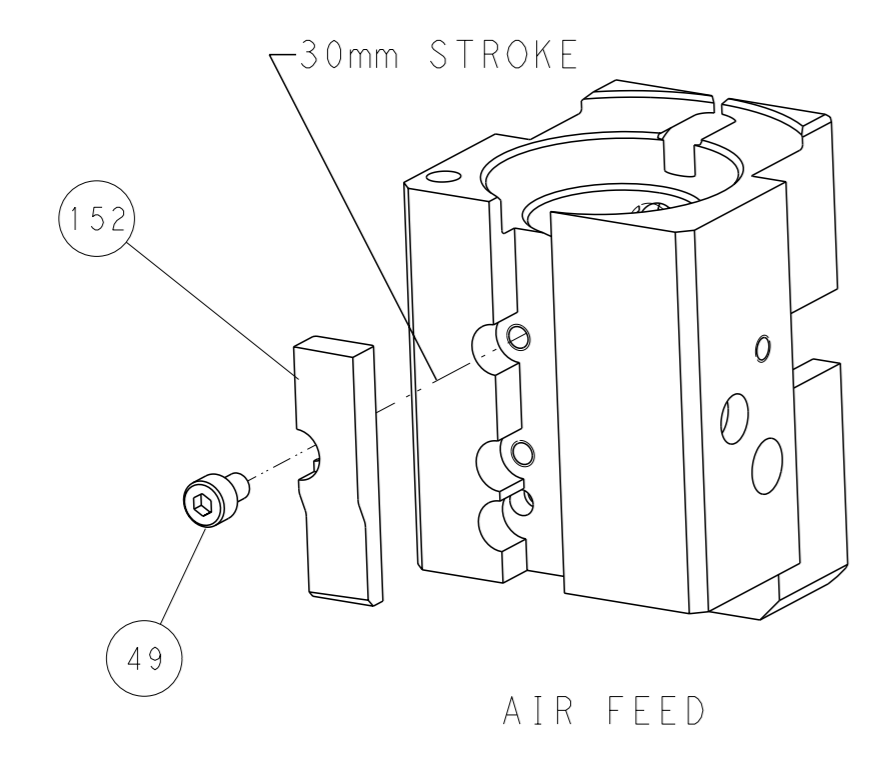


FEED SPRING SETTING POSITION



DETAIL A

CAM POSITIONS



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 *	PRODUCT SPEC APPLICATION SPEC WEIGHT SCALE: 1:1	SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2150414 SHEET: 4 of 4 REV: B	RESTRICTED TO:
MATERIAL:		Customer Accessible Production Drawing	