

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150340-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2150340-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150340-1	B	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2150340-2	B	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150340-7	A	CRIMP TOOLING KIT	-

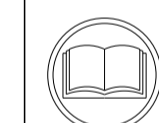
ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.03 mm [.080]	F
INSUL	3.20 mm [.126]	F
APPLICATOR INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION
TERMINAL NAME: 6.3 SRS F-SPRING LIF RECEPTACLE		
WIRE STRIP LENGTH 5.90-6.90 mm [.232-.272 IN]	INSULATION DIAMETER RANGE Ø1.80-2.50 mm [.071-.098 IN]	
TERMINAL APPLICATION SPECIFICATION 114-64027		
TERMINALS APPLIED		
TE TERMINAL 2178299-1	TE TERMINAL	TE TERMINAL

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
18 AWG	1.47 +/- 0.05 [.058 +/- .002]	6.1
20 AWG	1.35 +/- 0.05 [.053 +/- .002]	7.4



- 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.

***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.

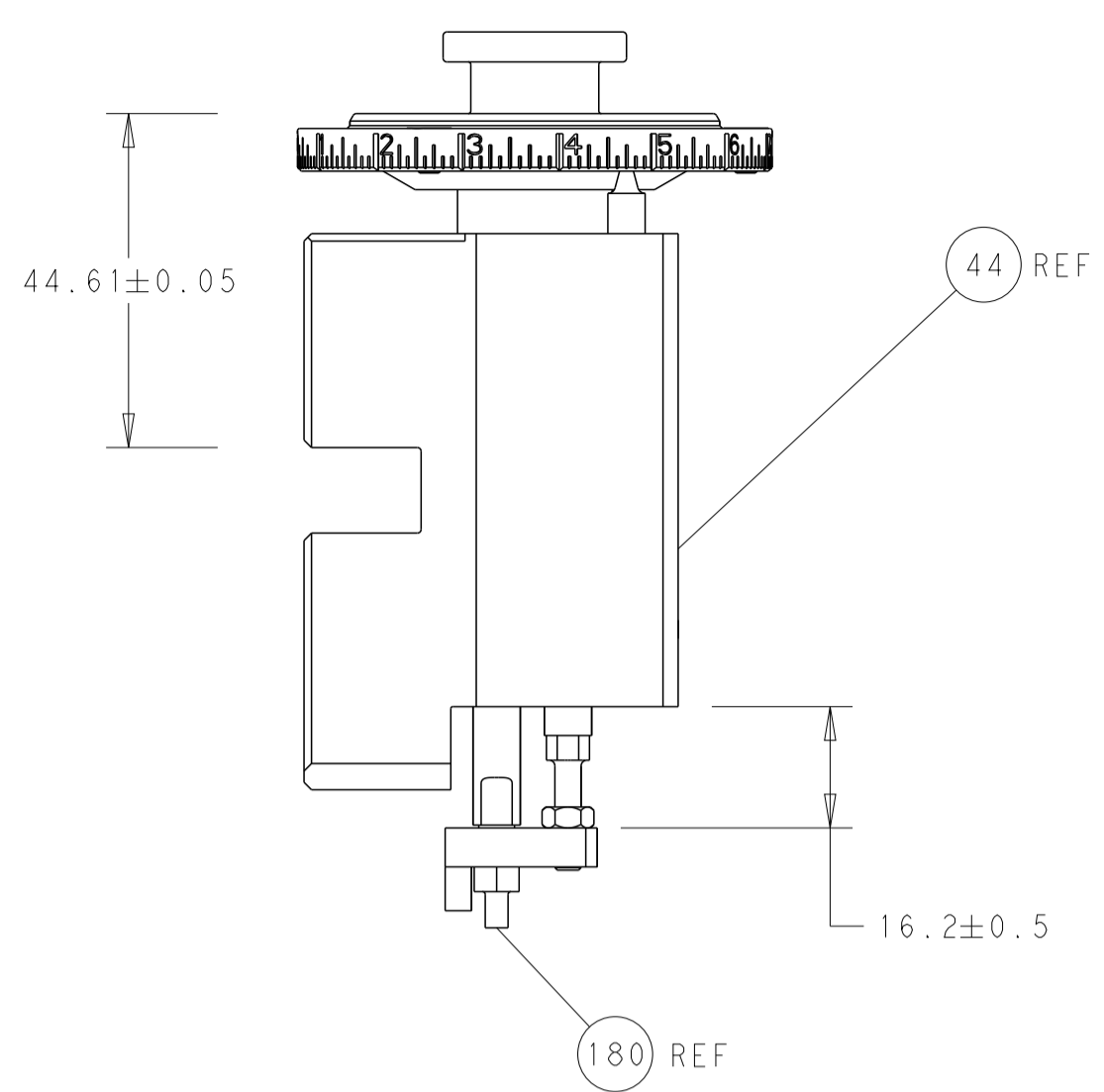
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

LOC	DIST	REVISIONS					
		P	LTN	DESCRIPTION	DATE	OWN	APVD
A	66	A		RELEASED	19MAY2014	KH	UG
		A1		ECR-15-006528	28APR2015	RS	LZ
		B		ECR-21-005726	25MAY2021	TB	RK

-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248	
-	1	1	1	1	2119082-9	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	1-1976055-7	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	
5	-	1	1	1	2119955-2	ASSY, LUBRICATOR, END FEED	84	
-	1	1	1	1	455888-5	SPACER, CRIMPER	82	
-	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	2119740-1	TAG, IDENTIFICATION	67	
-	2	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66	
-	1	1	1	1	1901681-5	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	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	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	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	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	4-240641-2	SPACER	16	
1	-	1	1	1	240644-9	PLATE, REAR SHEAR	11	
-	-	-	-	-	-	-	10	
1	-	1	1	1	5-690482-9	PLATE, FRONT SHEAR	9	
1	1	2	2	1	1	2-1803001-0	ANVIL, COMBINATION, END FEED	8
1	-	1	1	1	1	1-2217206-3	BLADE, SLUG	7
-	-	-	-	-	-	-	6	
-	1	1	1	1	240641-1	SPACER	5	
-	1	1	1	1	3-238011-1	BLOCK, CRIMPER SPACER	4	
1	1	2	2	1	1	7-1633961-0	CRIMPER, INSULATION F PREMIUM	3
-	1	1	1	1	1-455888-4	SPACER, CRIMPER	2	
1	1	2	2	1	1	456419-5	CRIMPER, WIRE PREMIUM	1
-	77	72	71	2	-1	PART NO	DESCRIPTION	ITEM NO

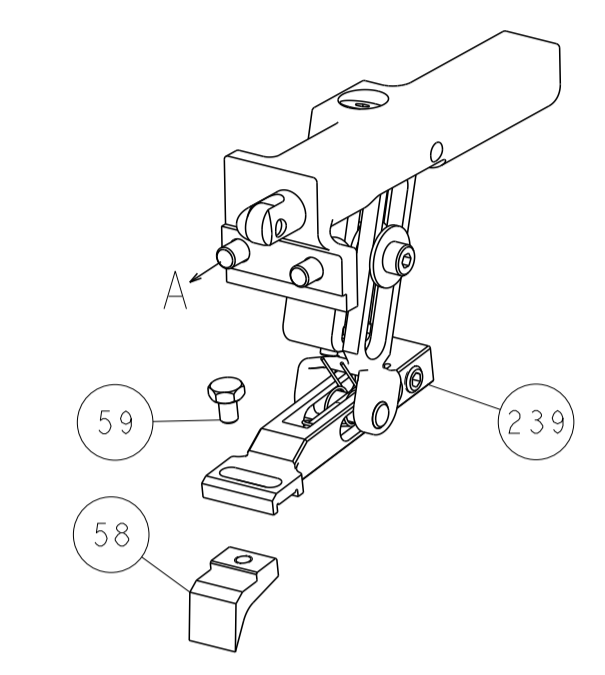
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mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	NAME Ocean End Feed Applicator	
MATERIAL		FINISH		APVD J. CRUZ 07MAY2013		SIZE A1 00779 C=2150340	
				WEIGHT		SCALE 1:1 SHEET 1 OF 4 REV B	
				Customer Accessible Production Drawing		RESTRICTED TO	

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

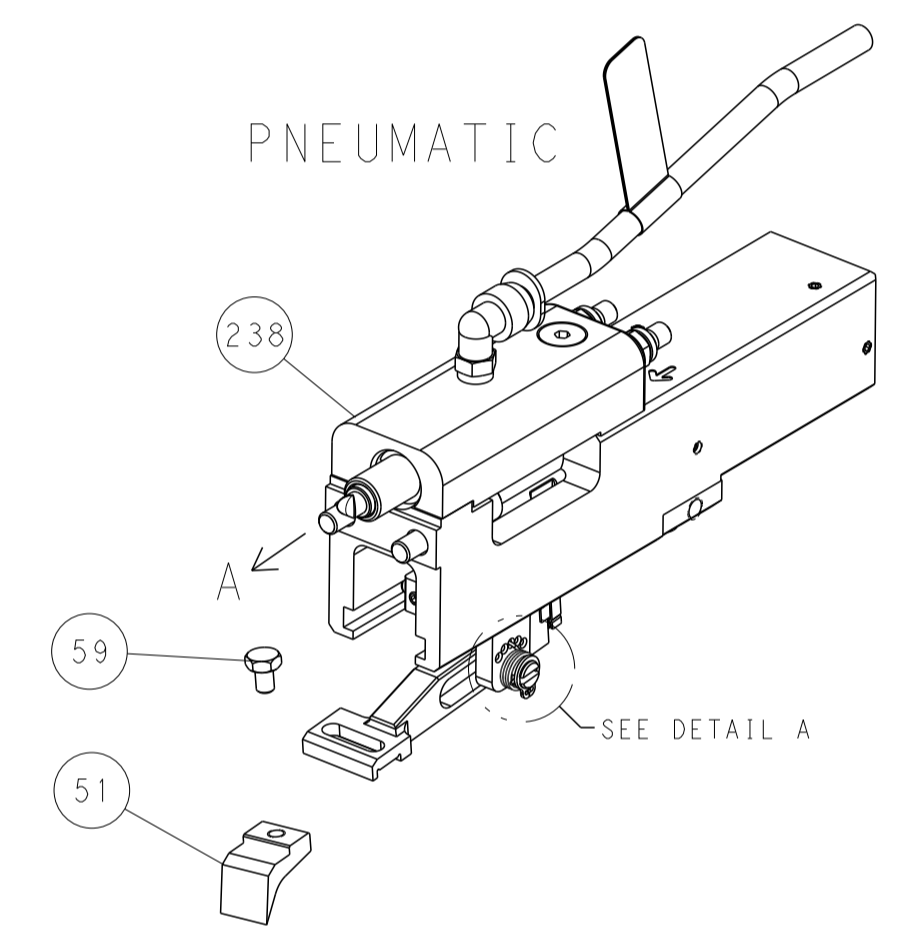


RAM AND HOLDDOWN SET-UP

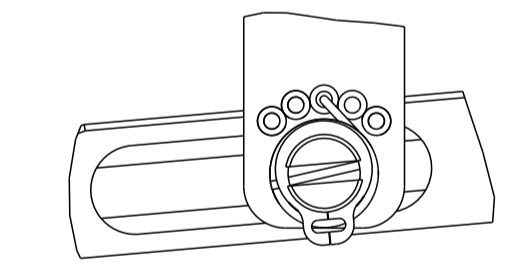
FEED TYPE
MECHANICAL



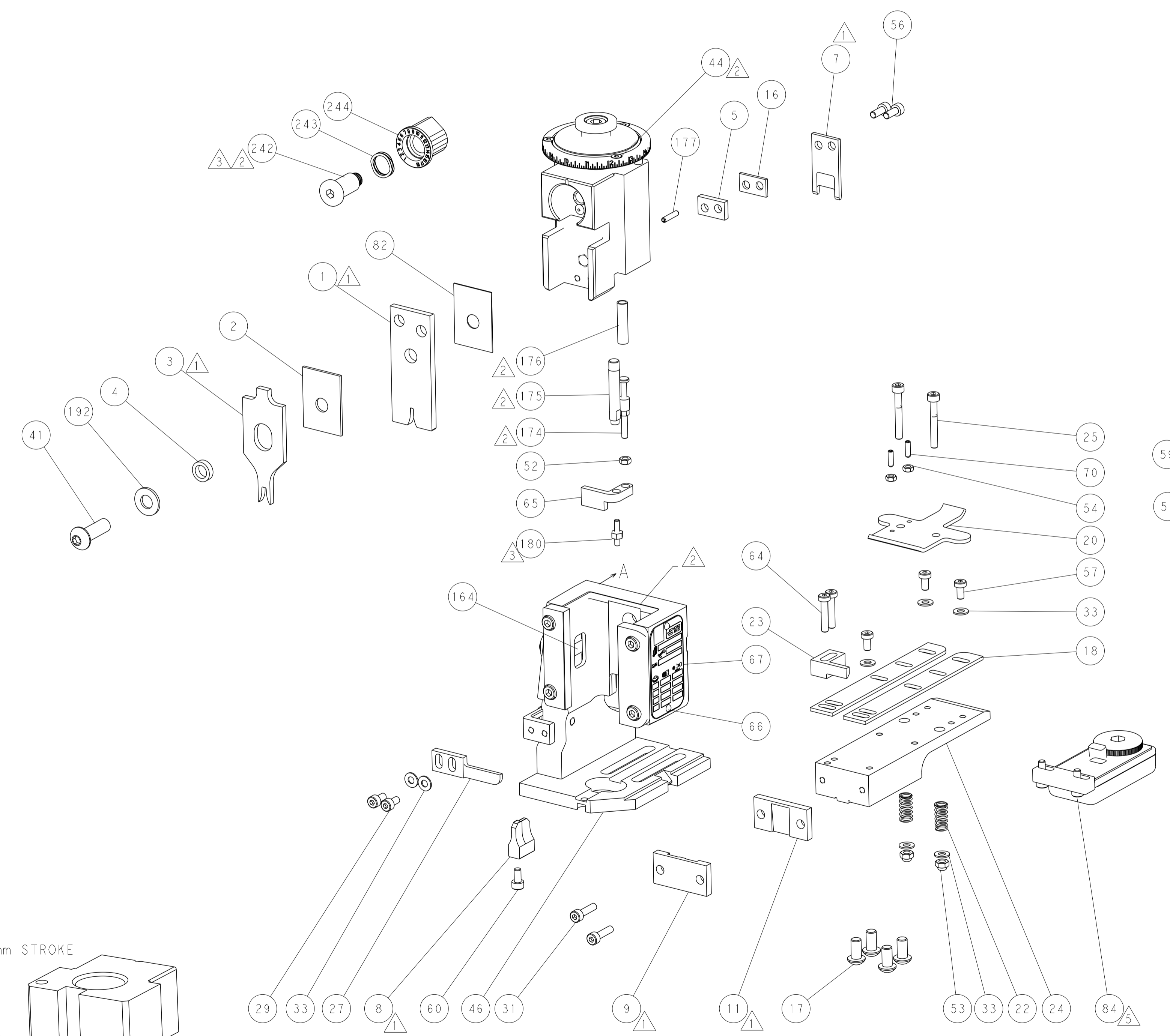
PNEUMATIC



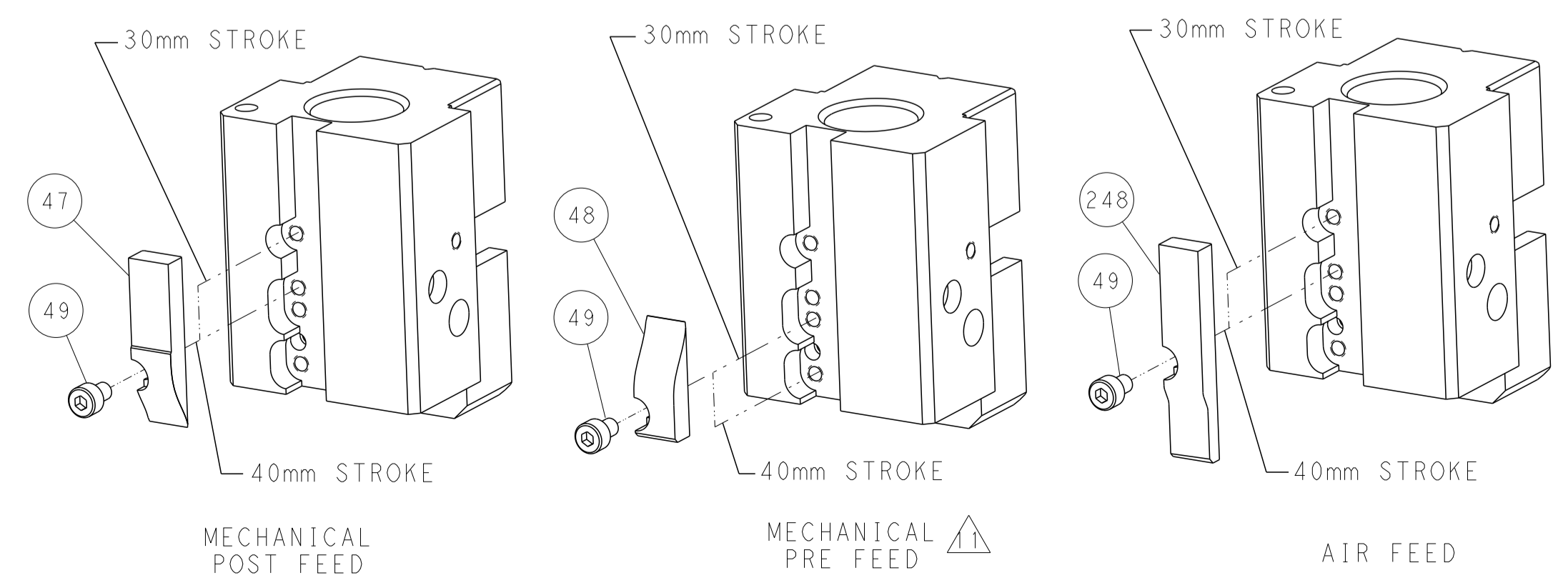
FEED SPRING
SETTING POSITION



DETAIL A



CAM POSITIONS

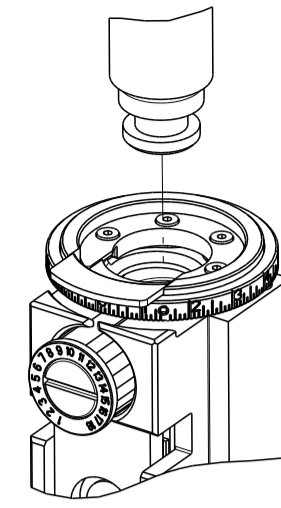


ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

<small>THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.</small>		DWN C. CHEN 07MAY2013 CHK U. GUO 07MAY2013 APVD J. CRUZ 07MAY2013	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 PRODUCT SPEC APPLICATION SPEC WEIGHT SCALE 1:1	SIZE A1 CAGE CODE 00779 DRAWING NO. C=2150340 SHEET 2 OF 4 REV B
MATERIAL:		RESTRICTED TO:	

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COPYRIGHT 20 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.			
PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150340-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2150340-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150340-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.03 mm (.080)	F
INSUL	3.20 mm (.126)	F
APPLICATOR INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: 6.3 SRS F-SPRING LIF RECEPTACLE			
WIRE STRIP LENGTH 5.90-6.90 mm (.232-.272 IN)		INSULATION DIAMETER RANGE Ø1.80-2.50 mm (.071-.098 IN)	
TERMINAL APPLICATION SPECIFICATION	114-64027	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
2178299-1			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
18 AWG	1.47+/-0.05 [.058+/-0.002]	6.1
20 AWG	1.35+/-0.05 [.053+/-0.002]	7.4



- 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.

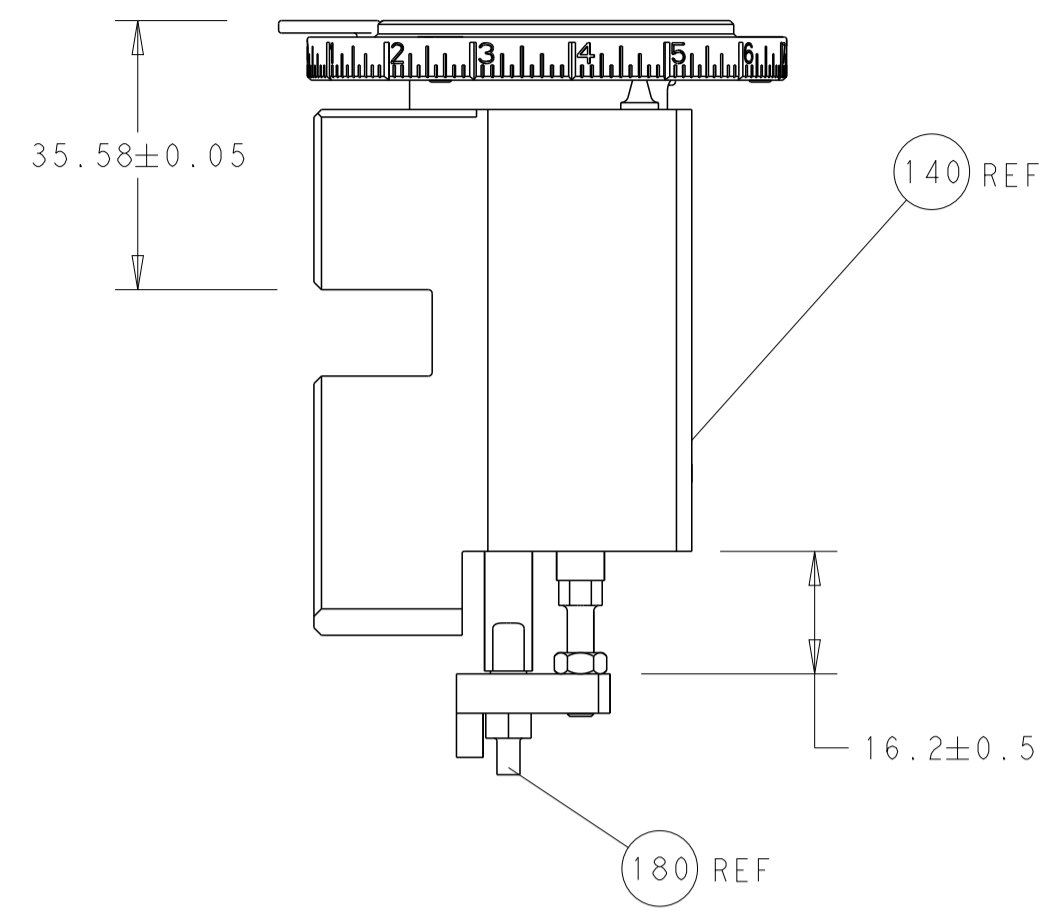
LOC	DIST	REVISIONS					
A	66	P	LTN	DESCRIPTION	DATE	OWN	APVD
		-		SEE SHEET 1	-	-	-

-	1	1	2119082-9	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	1-1976055-7	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
-	REF	REF	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
5	-	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
-	1	1	1901681-5	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	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	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	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	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	4-240641-2	SPACER	16
1	-	1	240644-9	PLATE, REAR SHEAR	11
-	-	-	-	-	10
1	-	1	5-690482-9	PLATE, FRONT SHEAR	9
1	1	1	2-1803001-0	ANVIL, COMBINATION, END FEED	8
1	-	1	1-2217206-3	BLADE, SLUG	7
-	-	-	-	-	6
-	1	1	240641-1	SPACER	5
-	1	1	3-238011-1	BLOCK, CRIMPER SPACER	4
1	1	1	7-1633961-0	CRIMPER, INSULATION F PREMIUM	3
-	1	1	1-455888-4	SPACER, CRIMPER	2
1	1	1	456419-5	CRIMPER, WIRE PREMIUM	1
-	77-22-21		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)

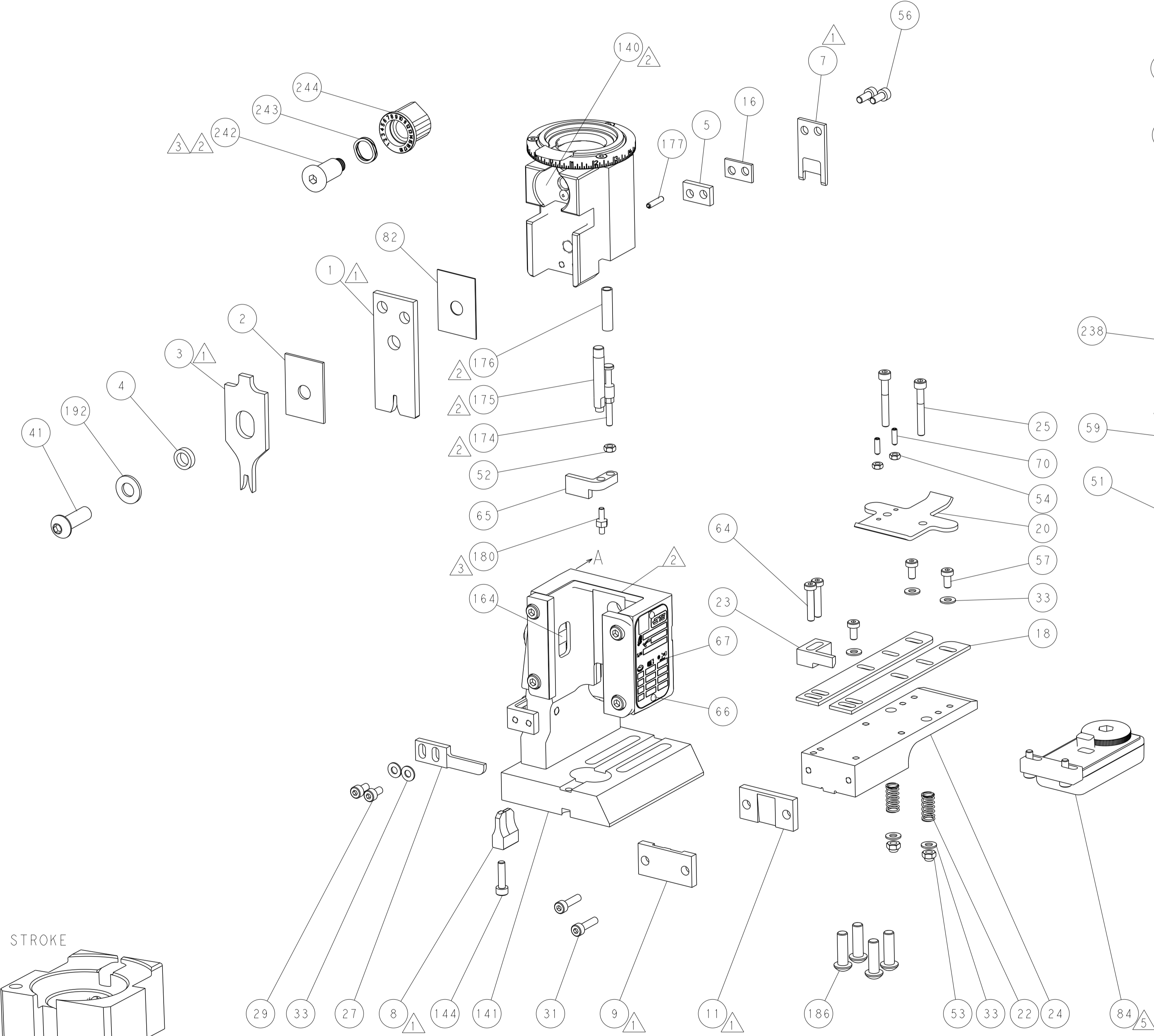
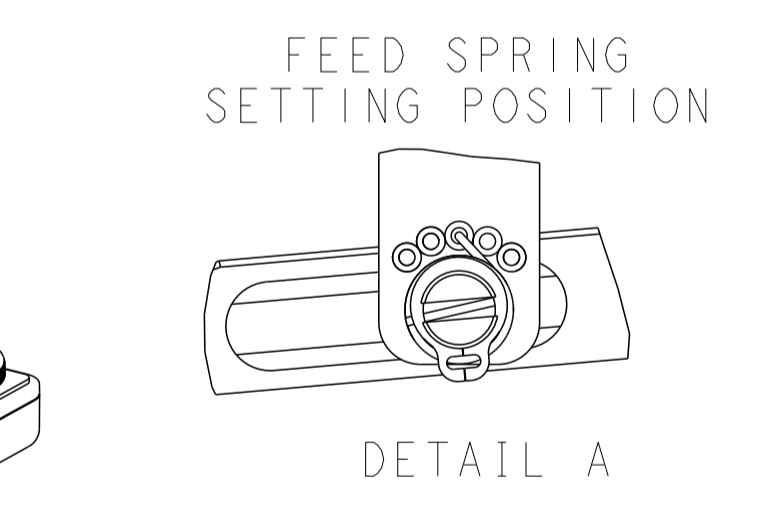
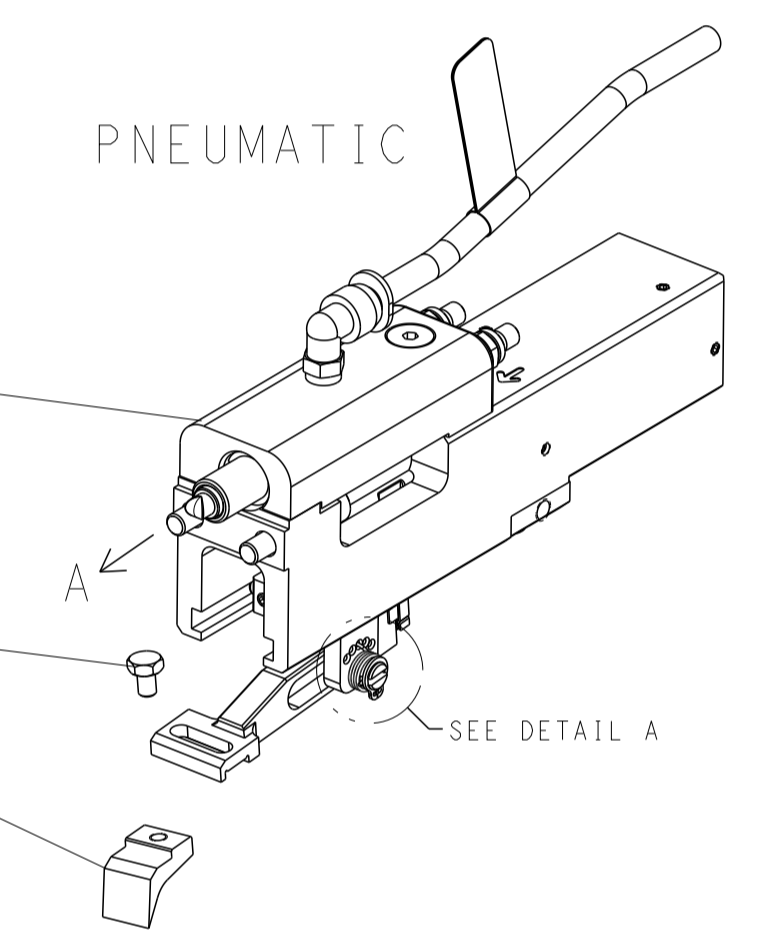
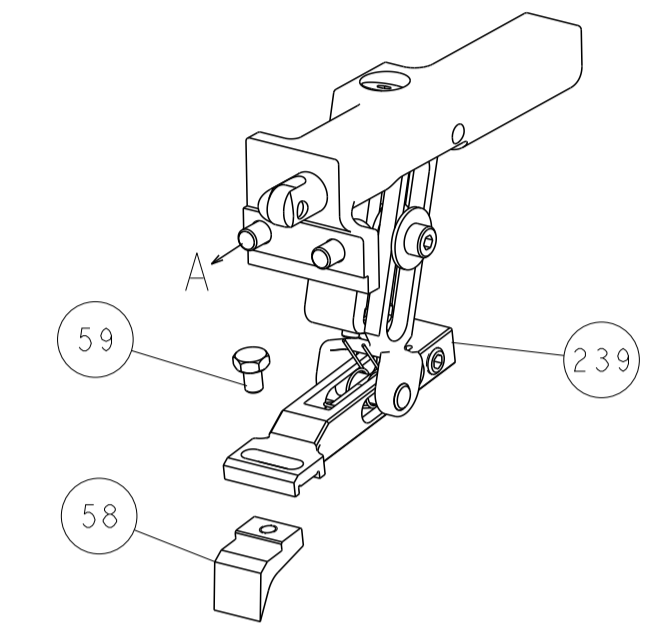
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0 PLC ±		1 PLC ±		2 PLC ±		3 PLC ±		4 PLC ±		SIZE: A1	
ANGLES		FINISH		WEIGHT		SCALE: 1:1		SHEET: 3 OF 4		REV: B	
MATERIAL		FINISH		WEIGHT		SCALE: 1:1		SHEET: 3 OF 4		REV: B	

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

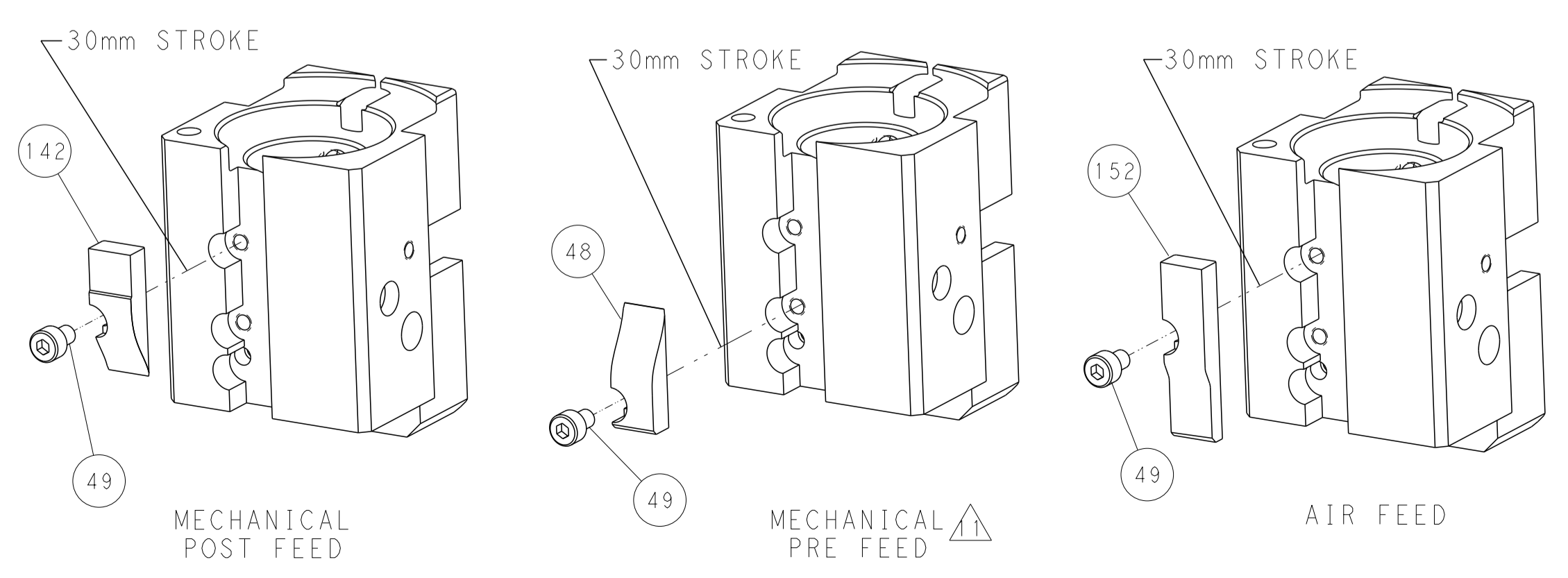


RAM AND HOLDDOWN SET-UP

FEED TYPE
MECHANICAL



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 C.CHEN 07MAY2013		CHK U.GUO 07MAY2013		APVD J.CRUIZ 07MAY2013		NAME	
mm	0 PLC	±		SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO	TE Connectivity Harrisburg, PA 17105-3608 Ocean End Feed Applier			
	1 PLC	±		SCALE	1:1	SHEET 4 OF 4	REV B				
	2 PLC	±		Customer Accessible Production Drawing							
	3 PLC	±									
	4 PLC	±									
	ANGLES	±									
	FINISH	±									
MATERIAL											