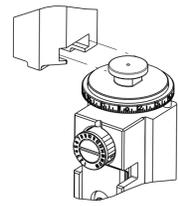


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150239-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2150239-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150239-1	C	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2150239-2	C	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150239-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.29 mm [.090]	F
INSUL	3.30 mm [.130]	F
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: RECEPTACLE, FASTON, .110 SERIES			
WIRE STRIP LENGTH	TERMINAL INSULATION DIAMETER RANGE		
2.00-3.00 mm [.079-.118 IN]	∅ 2.79-4.32 mm [.110-.170 IN]		
TERMINAL APPLICATION SPECIFICATION	114-2065	AT9106	
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
1217345-1	1217345-2		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
(2) 18 AWG	1.70+/-0.05 [.067+/-0.002]	9.1
16 AWG	1.60+/-0.05 [.063+/-0.002]	10.2
18 AWG	1.42+/-0.05 [.056+/-0.002]	12.0

- 1 RECOMMENDED SPARE PARTS.
- 2 REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION & STORAGE OF APPLICATOR.
- 3 APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 180. 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. 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.

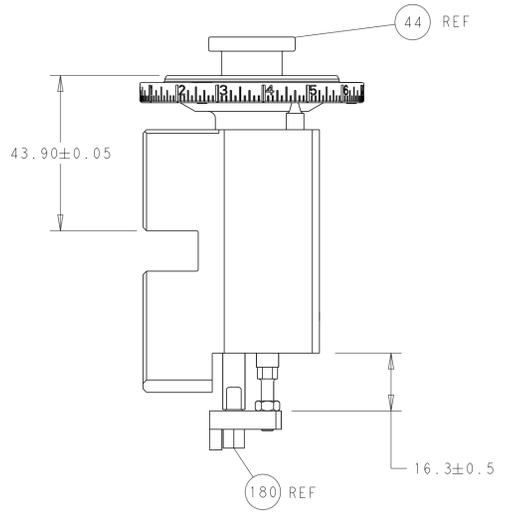
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

LOC	DIST	REVISIONS					
A	66	P	LTN	DESCRIPTION	DATE	DWN	APVD
		1		ORIGINAL	30JAN2012	GH	TE
		A		RELEASED	26APR2012	GH	GB
		B		ECR-21-110736	19AUG2021	JAH	TE
		C		ECR-23-182180	24JUL2023	ROY	TLE

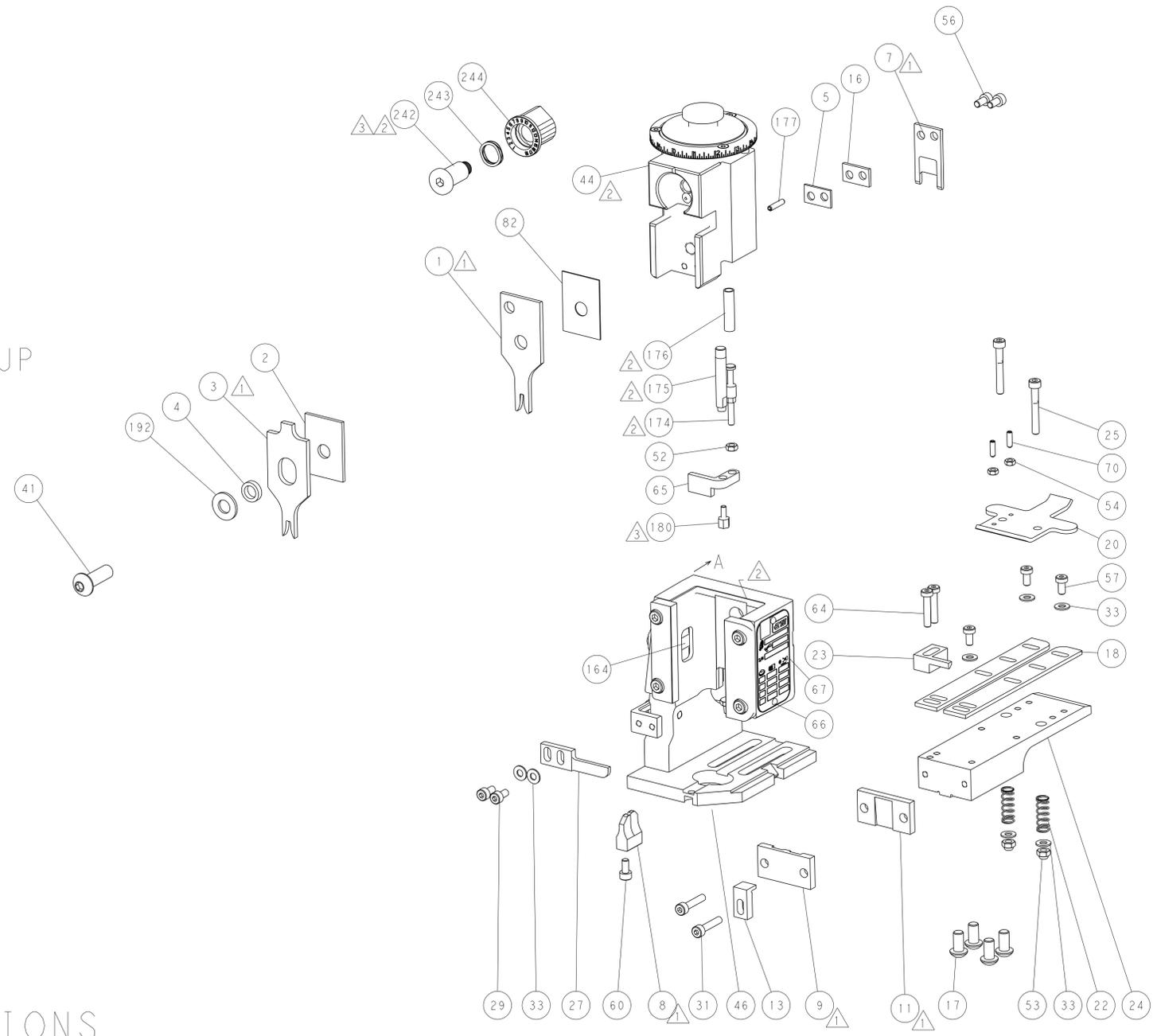
-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248	
-	1	1	1	1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244	
-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243	
3	-	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242	
-	-	1	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239	
-	1	-	1	-	2844940-3	AIR FEED MODULE	238	
-	1	1	1	1	1-18028-0	WASHER, FLAT, REG M8	192	
3	-	1	1	1	1752354-6	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	455888-5	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	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	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	240825-5	PLATE, STRIP HOLD DOWN	23	
-	2	2	2	2	1-22281-2	SPRING, COMPRESSION	22	
-	1	1	1	1	1803292-1	DRAG	20	
-	2	2	2	2	1-1901259-0	GUIDE, LOWER STRIP	18	
-	4	4	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17	
-	1	1	1	1	1-240641-3	SPACER	16	
-	1	1	1	1	1752360-1	SPACER, HOLD-DOWN	13	
1	-	1	1	1	1-240644-7	PLATE, REAR SHEAR	11	
-	-	-	-	-	-	-	10	
1	1	1	1	1	4-690482-2	PLATE, FRONT SHEAR	9	
1	2	2	1	1	6-1633383-0	ANVIL, COMBINATION	8	
1	-	1	1	1	690474-6	BLADE, SLUG	7	
-	-	-	-	-	-	-	6	
-	1	1	1	1	5-240641-4	SPACER	5	
-	1	1	1	1	238011-2	BLOCK, CRIMPER SPACER	4	
1	2	2	1	1	2-1633961-6	CRIMPER, INSULATION F PREMIUM	3	
-	1	1	1	1	1-455888-8	SPACER, CRIMPER	2	
1	2	2	1	1	4-456406-1	CRIMPER, WIRE PREMIUM	1	
-	77	72	71	2	-1	PART NO	DESCRIPTION	ITEM NO

<small>THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION. BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED. COPYRIGHT 20</small>		<small>THIS IS THE PROPERTY OF STAMPED TOOLING AND INSULATION ORGANIZATION. IT IS TO BE USED ONLY FOR THE PURPOSES AND IN THE MANNER SPECIFIED. IT IS TO BE RETURNED TO STAMPED TOOLING AND INSULATION ORGANIZATION WHEN NOT BEING USED FOR THE LATEST REVISION.</small>		DWN G. HOFNER 30JAN2012	TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH ±		CHK T. ELBIN 31JAN2012	
MATERIAL:		FINISH:		APVD T. ELBIN 31JAN2012	SIZE A1
WEIGHT:		SCALE: 1:1		CAGE CODE: 00779	DRAWING NO: 2150239
RESTRICTED TO:		SHEET 1 OF 4		REV C	Customer Accessible Production Drawing

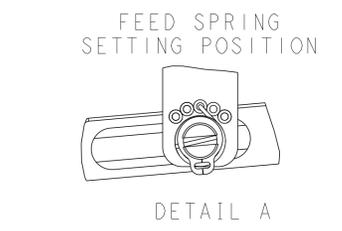
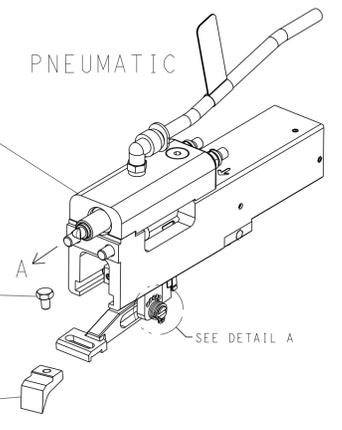
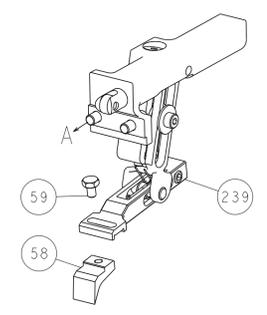
LOC	DIST	REV	DESCRIPTION	DATE	OWN	APVD
A	66		SEE SHEET 1			



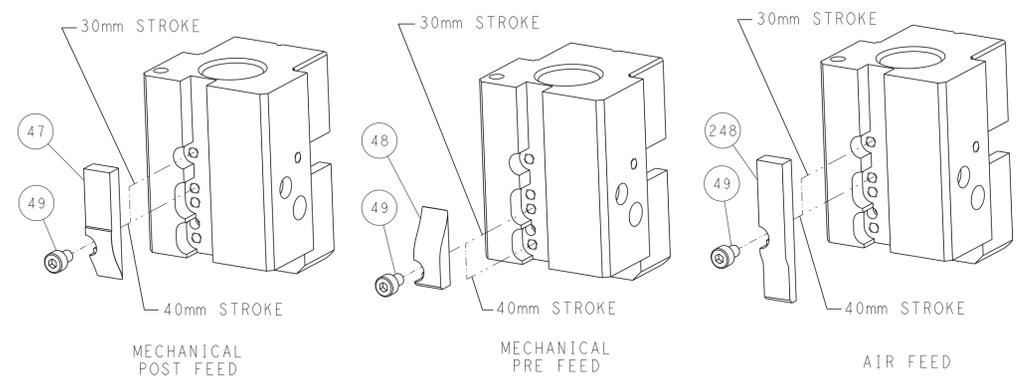
RAM AND HOLDDOWN SET-UP



FEED TYPE
MECHANICAL



CAM POSITIONS

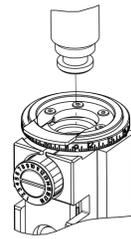


ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH		DWN G. HOFFNER 30 JAN 2012 CHK T. ELBIN 31 JAN 2012 APVD T. ELBIN 31 JAN 2012 PRODUCT SPEC APPLICATION SPEC WEIGHT Customer Accessible Production Drawing		NAME OCEAN 2.0 End Feed Applicator SIZE CAGE CODE DRAWING NO A 00779 C=2150239 SCALE 1:1 SHEET 2 OF 4 REV C		RESTRICTED TO TE Connectivity Harrisburg, PA 17105-3608	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150239-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2150239-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150239-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.29 mm [.090]	F
INSUL	3.30 mm [.130]	F
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: RECEPTACLE, FASTON, .110 SERIES			
WIRE STRIP LENGTH 2.00-3.00 mm [.079-.118 IN]		TERMINAL INSULATION DIAMETER RANGE 2.79-4.32 mm [.110-.170 IN]	
TERMINAL APPLICATION SPECIFICATION 114-2065			AT9106
TERMINALS APPLIED			
TE TERMINAL 1217345-1	TE TERMINAL 1217345-2	TE TERMINAL	TE TERMINAL

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
(2) 18 AWG	1.70 +/- 0.05 [.067 +/- .002]	9.1
16 AWG	1.60 +/- 0.05 [.063 +/- .002]	10.2
18 AWG	1.42 +/- 0.05 [.056 +/- .002]	12.0



- 1 RECOMMENDED SPARE PARTS.
- 2 REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION & STORAGE OF APPLICATOR.
- 3 APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 180. 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. 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.

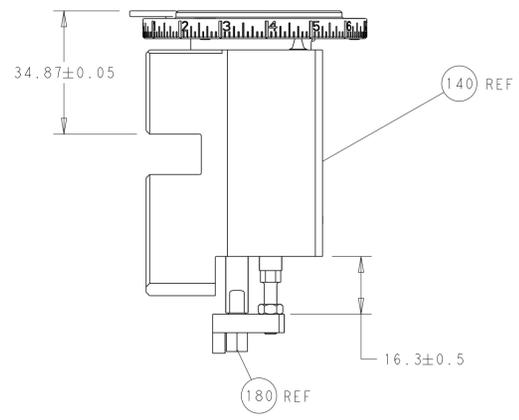
PACIFIC VERSION
Shown on sheets 3 of 4 & 4 of 4
(Atlantic version shown on sheets 1 of 4 & 2 of 4)

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

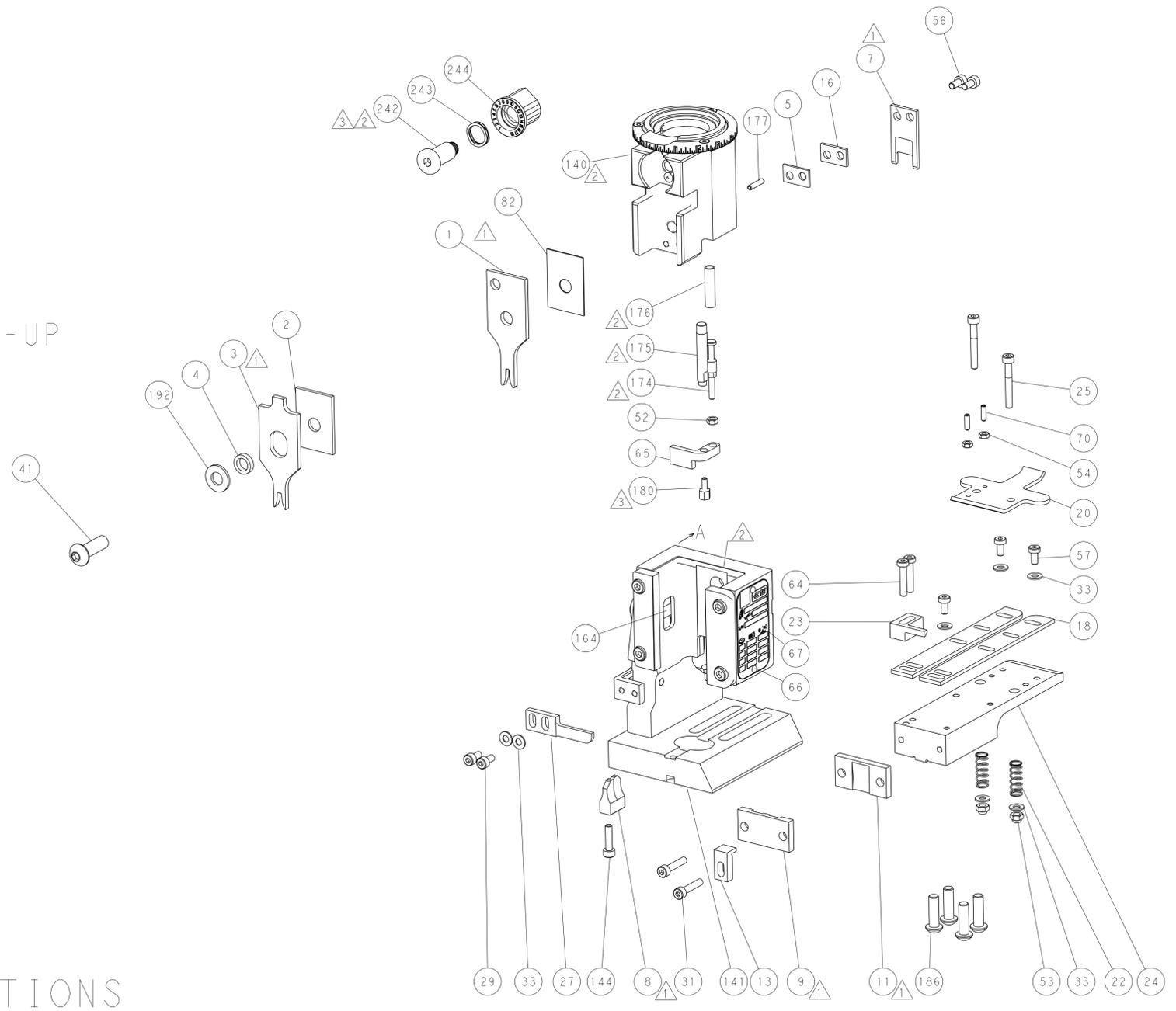
-	1	1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244	
-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243	
3	-	1	2119083-1	RETAINER, INSULATION DIAL	242	
-	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239	
-	1	-	2844940-3	AIR FEED MODULE	238	
-	1	1	1-18028-0	WASHER, FLAT, REG M8	192	
-	4	4	2079383-9	SCR, BHSC, RoHS (M6 X 20)	186	
3	-	1	1752354-6	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	
-	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	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	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	240825-5	PLATE, STRIP HOLD DOWN	23	
-	2	2	1-22281-2	SPRING, COMPRESSION	22	
-	1	1	1803292-1	DRAG	20	
-	2	2	1-1901259-0	GUIDE, LOWER STRIP	18	
-	1	1	1-240641-3	SPACER	16	
-	1	1	1752360-1	SPACER, HOLD-DOWN	13	
1	-	1	1-240644-7	PLATE, REAR SHEAR	11	
-	-	-	-	-	10	
1	-	1	4-690482-2	PLATE, FRONT SHEAR	9	
1	1	1	6-1633383-0	ANVIL, COMBINATION	8	
1	-	1	690474-6	BLADE, SLUG	7	
-	-	-	-	-	6	
-	1	1	5-240641-4	SPACER	5	
-	1	1	238011-2	BLOCK, CRIMPER SPACER	4	
1	1	1	2-1633961-6	CRIMPER, INSULATION F PREMIUM	3	
-	1	1	1-455888-8	SPACER, CRIMPER	2	
1	1	1	4-456406-1	CRIMPER, WIRE PREMIUM	1	
-	77	22	21	PART NO	DESCRIPTION	ITEM NO

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN		TE Connectivity	
mm	0 PLC ±	1 PLC ±	2 PLC ±	30 JAN 2012	Harrisburg, PA 17105-3608		
	3 PLC ±	4 PLC ±	ANGLES ±	CHK G. HOFFNER 31 JAN 2012	OCEAN 2.0 End Feed Applicator		
MATERIAL	FINISH	APVD T. ELBIN 31 JAN 2012	PRODUCT SPEC	NAME	Customer Accessible Production Drawing		
		APPLICATION SPEC	SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO	
		WEIGHT	A1	00779	2150239	SCALE	1:1 SHEET 3 OF 4 REV C

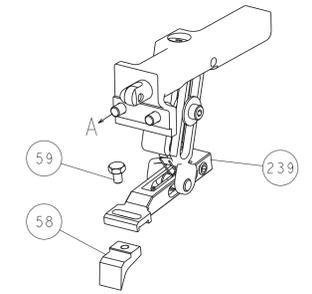
LOC		DIST		REVISIONS			
A	66	P	LTM	DESCRIPTION	DATE	OWN	APVD
		-		SEE SHEET 1			



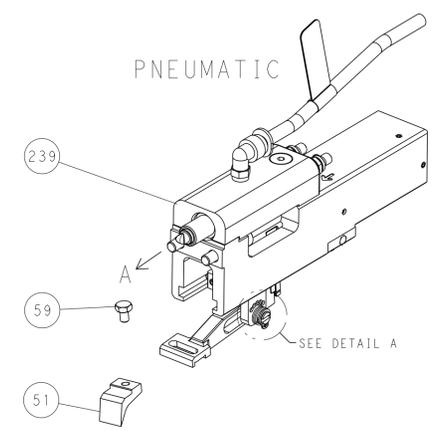
RAM AND HOLDDOWN SET-UP



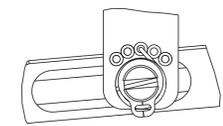
FEED TYPE
MECHANICAL



PNEUMATIC

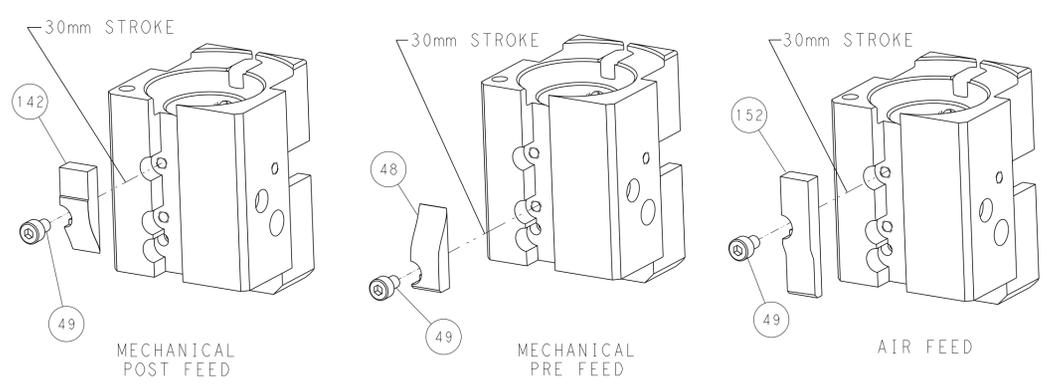


FEED SPRING
SETTING POSITION



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)

<small>THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.</small>		DWN: G. HOFFNER 30 JAN 2012 CHK: T. ELBIN 31 JAN 2012 APVD: T. ELBIN 31 JAN 2012	NAME: OCEAN 2.0 End Feed Applicator SIZE: A 00779 CAGE CODE: C=2150239 DRAWING NO: 2150239	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: .	WEIGHT: . SCALE: 1:1 SHEET: 4 OF 4 REV: C	RESTRICTED TO: .	Customer Accessible Production Drawing	