

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150108-1	E	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2150108-2	E	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150108-1	E	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2150108-2	E	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150108-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.57 mm [.062]	F
INSUL	2.54 mm [.100]	F
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: RECEPTACLE FASTON FLAG .110 SERIES			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
4.40-5.16 mm [.173-.203 IN]		∅1.52-2.54 mm [.060-.100 IN]	
TERMINAL APPLICATION SPECIFICATION	114-2028		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
62336-1	62336-2	61481-1	1217171-1
1217138-1			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
18 AWG	1.17 +/- 0.05 [.046 +/- .002]	7.1
20 AWG	1.02 +/- 0.05 [.040 +/- .002]	8.8
22 AWG	0.94 +/- 0.05 [.037 +/- .002]	9.7

- 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.
- 5. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- TERMINAL LUBRICANT IS RECOMMENDED.

***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.

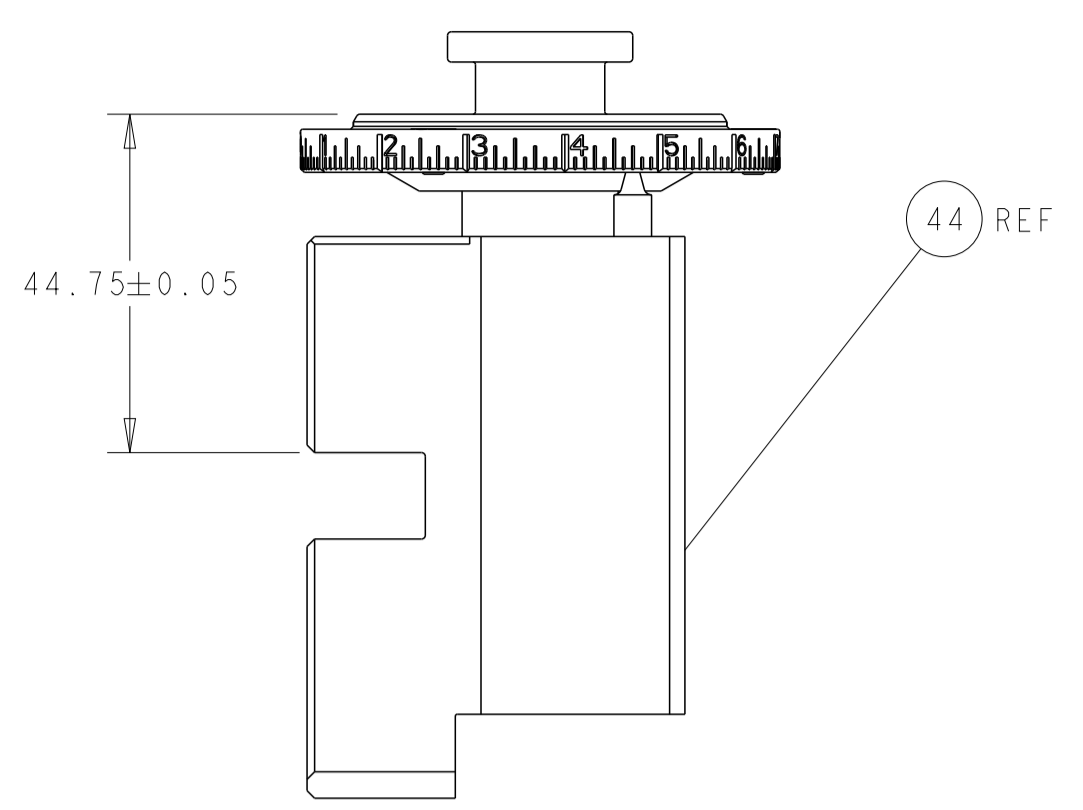
LOC	DIST	REVISIONS					
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		C		ECR-19-003694	07MAR2019	TB	CT
		D		ECR-21-001955	16FEB2021	TB	RK
		D1		ECR-22-132177	11MAR2022	FZ	JH
		E		ECR-23-165285	02FEB2023	JWC	GB

-	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	
-	1	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	
-	2	2	2	2	1-2168083-1	SCR, SKT HD CAP, RoHS, M3 X 6	191	
-	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164	
-	1	1	1	1	1803203-1	BLOCK, FRONT DEPRESSOR	155	
-	1	1	1	1	2119955-2	ASSY, LUBRICATOR, END FEED	84	
-	1	1	1	1	455888-6	SPACER, CRIMPER	82	
-	1	1	1	1	2119791-5	DEPRESSOR, WIRE	73	
-	1	1	1	1	1803607-4	DOCUMENTATION PACKAGE	71	
-	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	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	
-	4	4	4	4	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57	
-	2	2	2	2	1-2168083-4	SCR, SKT HD CAP, RoHS, M4 X 5	56	
-	2	2	2	2	986965-8	NUT, LOCK, HEX, TORQUE (M4)	53	
-	1	-	1	-	2063961-9	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	1-2119655-7	APPLICATOR BASIC ASSEMBLY, EF	46	
-	1	1	1	1	1803517-1	RAM ASSEMBLY, EF ATLANTIC	44	
-	2	2	2	2	5018030-1	NUT, HEX, REG, RoHS, M3	43	
-	2	2	2	2	3-18032-3	SCR, SET, FLT PNT, M3 X 20.0	42	
-	1	1	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41	
-	8	8	8	8	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	240639-2	STRIPPER (MACHINING)	27	
-	2	2	2	2	1-2168083-6	SCR, SKT HD CAP, RoHS, M4 X 35	25	
-	1	1	1	1	1752371-1	PLATE, STRIP GUIDE	24	
-	2	2	2	2	22281-9	SPRING, COMPRESSION	22	
-	1	1	1	1	1633168-1	ARM, STOCK DRAG	21	
-	1	1	1	1	1-464452-6	DRAG, STOCK	20	
-	1	1	1	1	5-1901696-6	STRIP GUIDE, REAR	19	
-	1	1	1	1	1901259-5	GUIDE, LOWER STRIP	18	
-	4	4	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17	
-	1	1	1	1	240644-1	PLATE, REAR SHEAR	11	
-	2	2	2	2	240645-3	SPACER, SHEAR PLATE	10	
-	1	1	1	1	1-240642-1	PLATE, FRONT SHEAR	9	
-	1	2	2	1	1	9-1803001-9	ANVIL, COMBINATION, END FEED	8
-	1	1	1	1	454638-6	BLADE, SLUG	7	
-	-	-	-	-	-	-	6	
-	-	-	-	-	-	-	5	
-	1	1	1	1	2-238011-2	BLOCK, CRIMPER SPACER	4	
-	1	2	2	1	1	5-1803017-2	CRIMPER, INSULATION F	3
-	1	1	1	1	455888-1	SPACER, CRIMPER	2	
-	1	2	2	1	1	5-456403-1	CRIMPER, WIRE PREMIUM	1
-	77	72	71	2	-1	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)

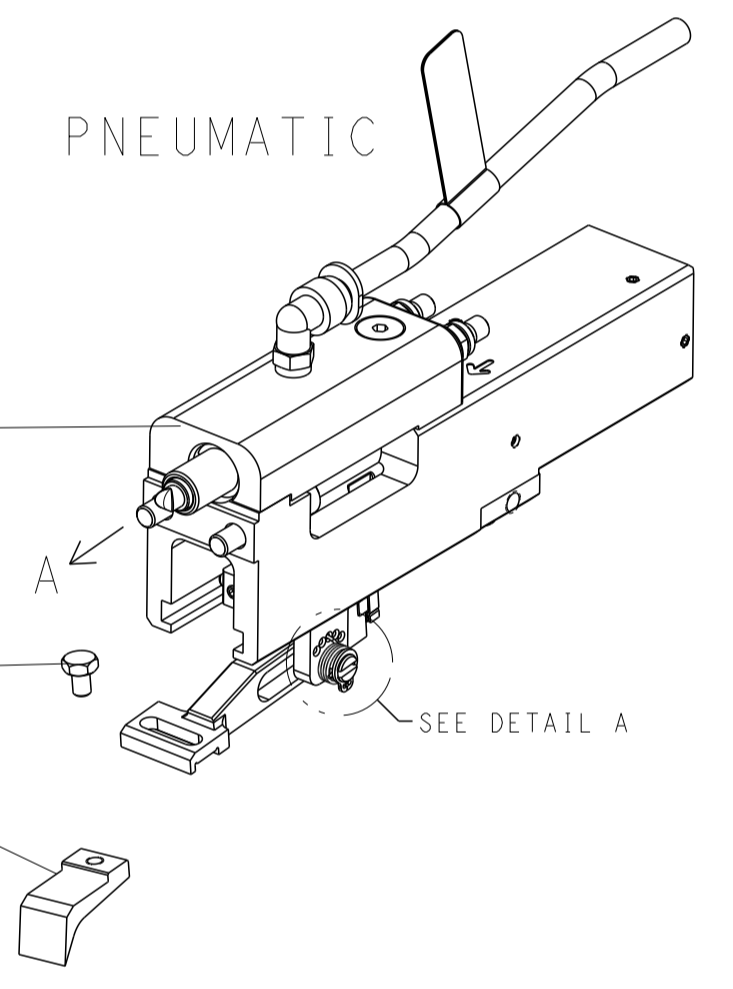
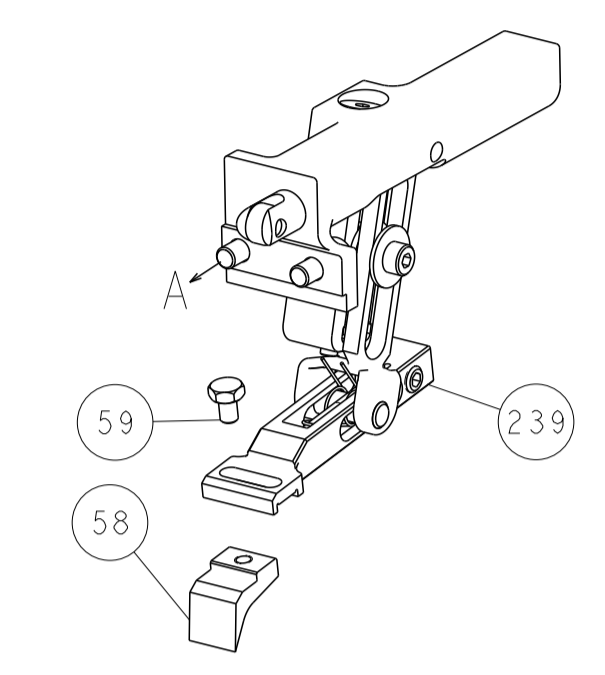
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		MATERIAL:		FINISH:		WEIGHT:		SCALE:		SHEET:		REV:	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES	FINISH			A1	00779	2150108	1	4	E
Customer Accessible Production Drawing										SCALE		SHEET		REV	

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

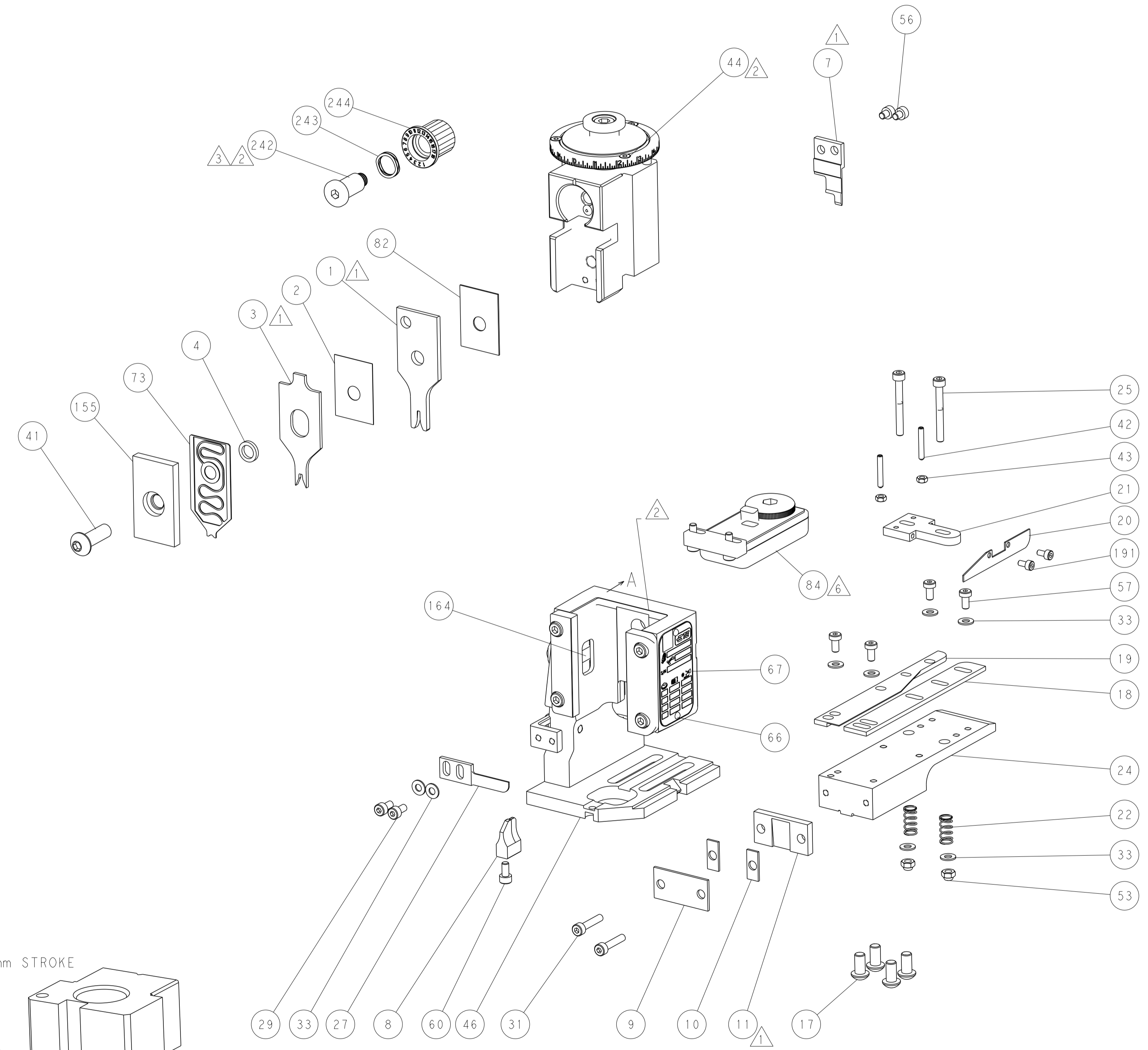
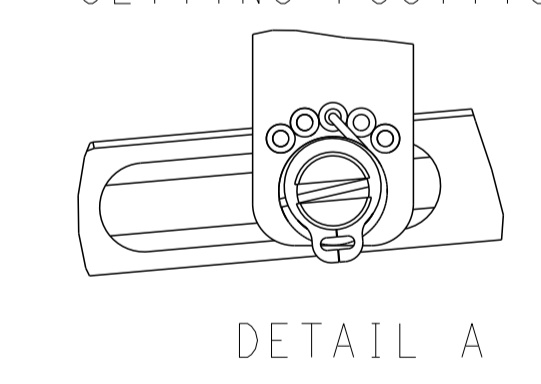


RAM SET-UP

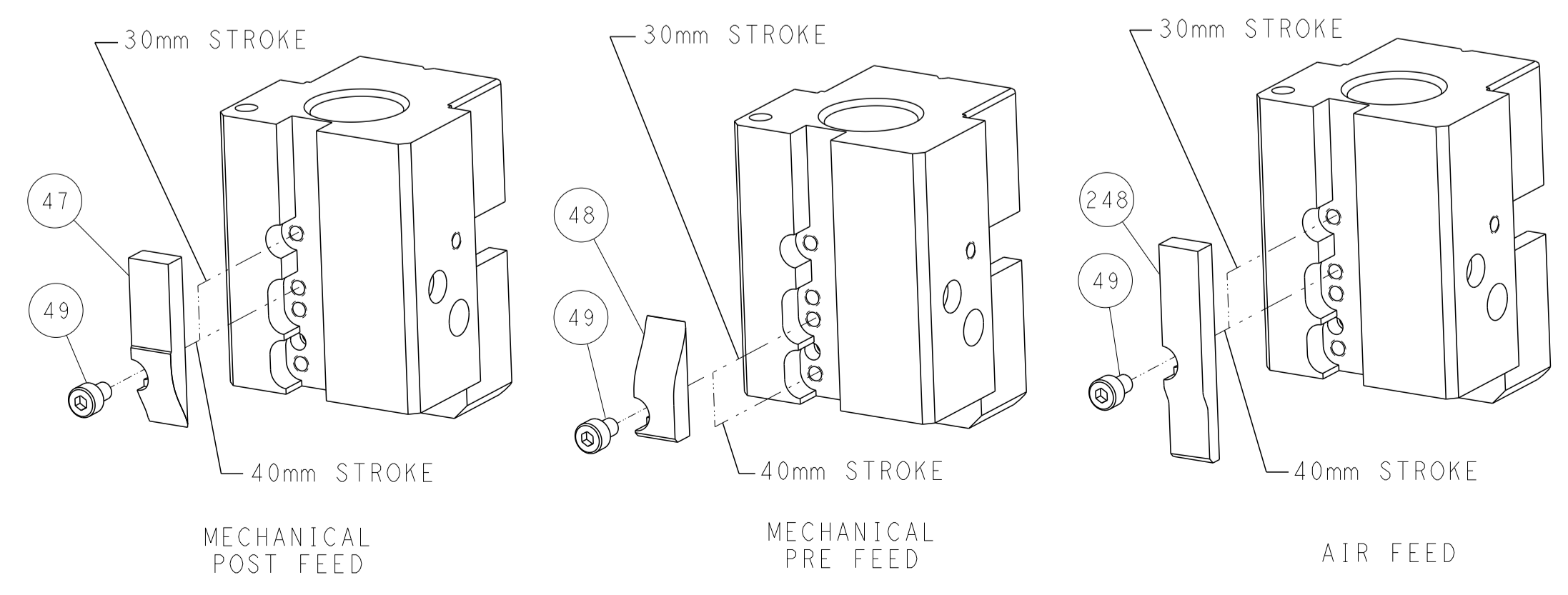
FEED TYPE
MECHANICAL



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)

DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH		DWN X.ZHAO 22JAN2016 CHK L.ZHANG 22JAN2016 APVD H.GUO 22JAN2016 PRODUCT SPEC APPLICATION SPEC WEIGHT Customer Accessible Production Drawing		NAME Ocean End Feed Applicator SIZE CAGE CODE DRAWING NO. A11 00779 C=2150108 SCALE 1:1 SHEET 2 OF 4 REV E		RESTRICTED TO	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150108-1	E	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2150108-2	E	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150108-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.57 mm (.062)	F
INSUL	2.54 mm (.100)	F
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: RECEPTACLE FASTON FLAG .110 SERIES			
WIRE STRIP LENGTH 4.40-5.16 mm (.173-.203 IN)		INSULATION DIAMETER RANGE Ø1.52-2.54 mm (.060-.100 IN)	
TERMINAL APPLICATION SPECIFICATION	114-2028	-	-
TERMINALS APPLIED ⁶			
TE TERMINAL 62336-1	TE TERMINAL 62336-2	TE TERMINAL 61481-1	TE TERMINAL 1217171-1

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING ⁴
18 AWG	1.17+/-0.05 [.046+/-0.002]	7.1
20 AWG	1.02+/-0.05 [.040+/-0.002]	8.8
22 AWG	0.94+/-0.05 [.037+/-0.002]	9.7



- 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. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- ⁶ TERMINAL LUBRICANT IS RECOMMENDED.

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

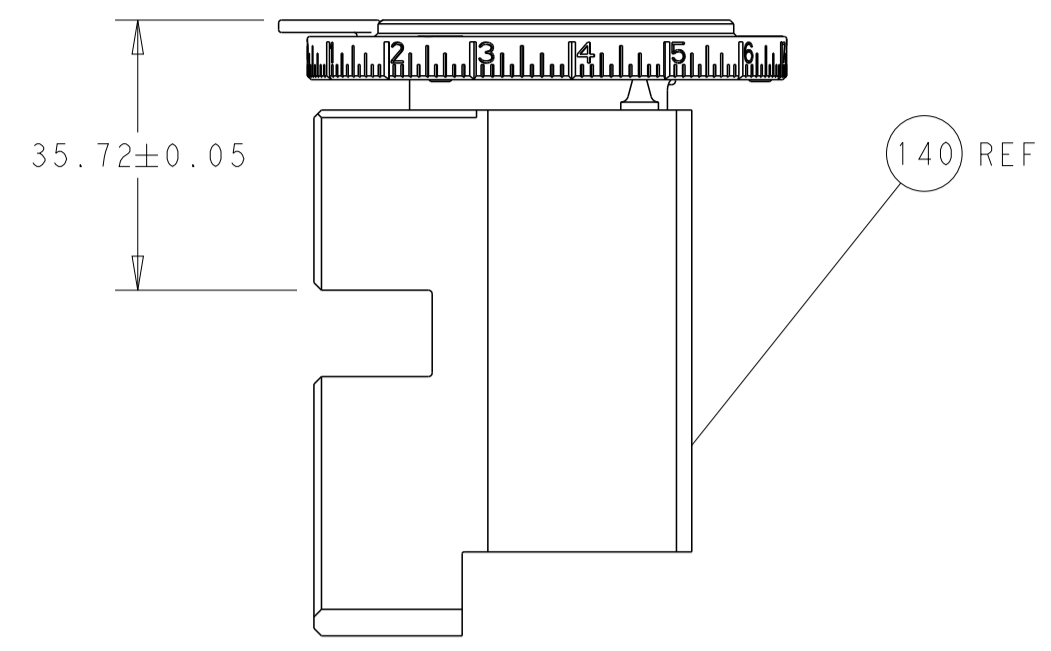
-	1	1	2119082-3	CAM, SNAIL, INSULATION ADJUSTMENT	244	
-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243	
³	-	1	2119083-1	RETAINER, INSULATION DIAL	242	
-	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239	
-	1	-	2844940-3	AIR FEED MODULE	238	
-	2	2	1-2168083-1	SCR, SKT HD CAP, RoHS, M3 X 6	191	
-	4	4	2079383-9	SCR, BHSC, RoHS (M6 X 20)	186	
-	REF	REF	994970-2	COUNTER, MAGNETIC	164	
-	1	1	1803203-1	BLOCK, FRONT DEPRESSOR	155	
-	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	1-2119655-8	APPLICATOR BASIC ASSEMBLY, EF	141	
-	1	1	1803518-1	RAM ASSEMBLY, EF PACIFIC	140	
⁶	-	1	2119955-2	ASSY, LUBRICATOR, END FEED	84	
-	1	1	455888-6	SPACER, CRIMPER	82	
-	1	1	2119791-5	DEPRESSOR, WIRE	73	
-	1	1	1803607-4	DOCUMENTATION PACKAGE	71	
-	1	1	2119740-1	TAG, IDENTIFICATION	67	
-	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66	
-	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59	
-	-	1	2063961-1	FEED FINGER	58	
-	4	4	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57	
-	2	2	1-2168083-4	SCR, SKT HD CAP, RoHS, M4 X 5	56	
-	2	2	986965-8	NUT, LOCK, HEX, TORQUE (M4)	53	
-	1	-	2063961-9	FEED FINGER	51	
-	1	2	18023-9	SCR, SKT HD CAP M4 X 6.0	49	
-	-	1	2119652-1	FEED CAM, PRE FEED	48	
-	2	2	5018030-1	NUT, HEX, REG, RoHS, M3	43	
-	2	2	3-18032-3	SCR, SET, FLT PNT, M3 X 20.0	42	
-	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	240639-2	STRIPPER (MACHINING)	27	
-	2	2	1-2168083-6	SCR, SKT HD CAP, RoHS, M4 X 35	25	
-	1	1	1752371-1	PLATE, STRIP GUIDE	24	
-	2	2	22281-9	SPRING, COMPRESSION	22	
-	1	1	1633168-1	ARM, STOCK DRAG	21	
-	1	1	1-464452-6	DRAG, STOCK	20	
-	1	1	5-1901696-6	STRIP GUIDE, REAR	19	
-	1	1	1901259-5	GUIDE, LOWER STRIP	18	
¹	-	1	240644-1	PLATE, REAR SHEAR	11	
¹	-	2	240645-3	SPACER, SHEAR PLATE	10	
¹	-	1	1-240642-1	PLATE, FRONT SHEAR	9	
¹	1	1	1-1803001-9	ANVIL, COMBINATION, END FEED	8	
¹	-	1	454638-6	BLADE, SLUG	7	
-	-	-	-	-	6	
-	-	-	-	-	5	
-	1	1	2-238011-2	BLOCK, CRIMPER SPACER	4	
¹	1	1	5-1803017-2	CRIMPER, INSULATION F	3	
-	1	1	455888-1	SPACER, CRIMPER	2	
¹	1	1	5-456403-1	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)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		MATERIAL:	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±
	ANGLES	FINISH			

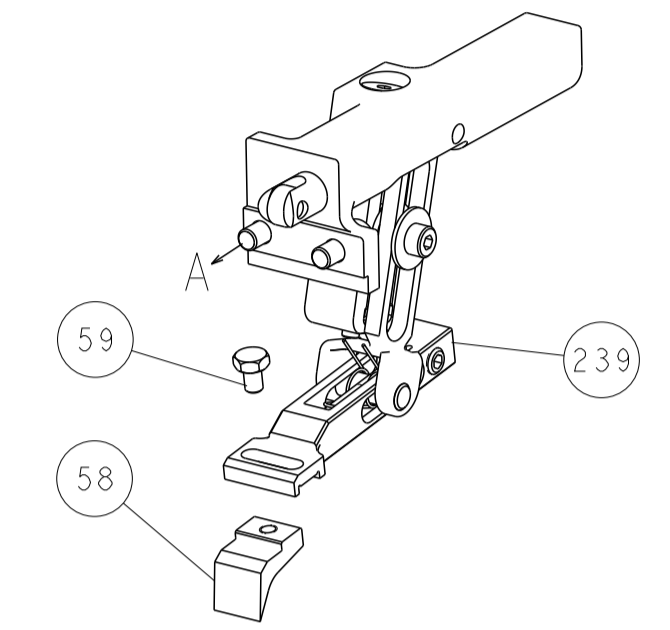
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CHK	L. ZHANG	22JAN2016	CHK	L. ZHANG	22JAN2016
APVD	J. GUO	22JAN2016	APVD	J. GUO	22JAN2016
PRODUCT SPEC		APPLICATION SPEC		SIZE	
-		-		A1 00779	
-		-		C=2150108	
-		-		SCALE	
-		-		1:1	
-		-		SHEET 3 OF 4	
-		-		REV E	

LOC		DIST		REVISIONS			
A	66	P	LTH	DESCRIPTION	DATE	DMN	APVD
-	-	-	-	SEE SHEET 1	-	-	-

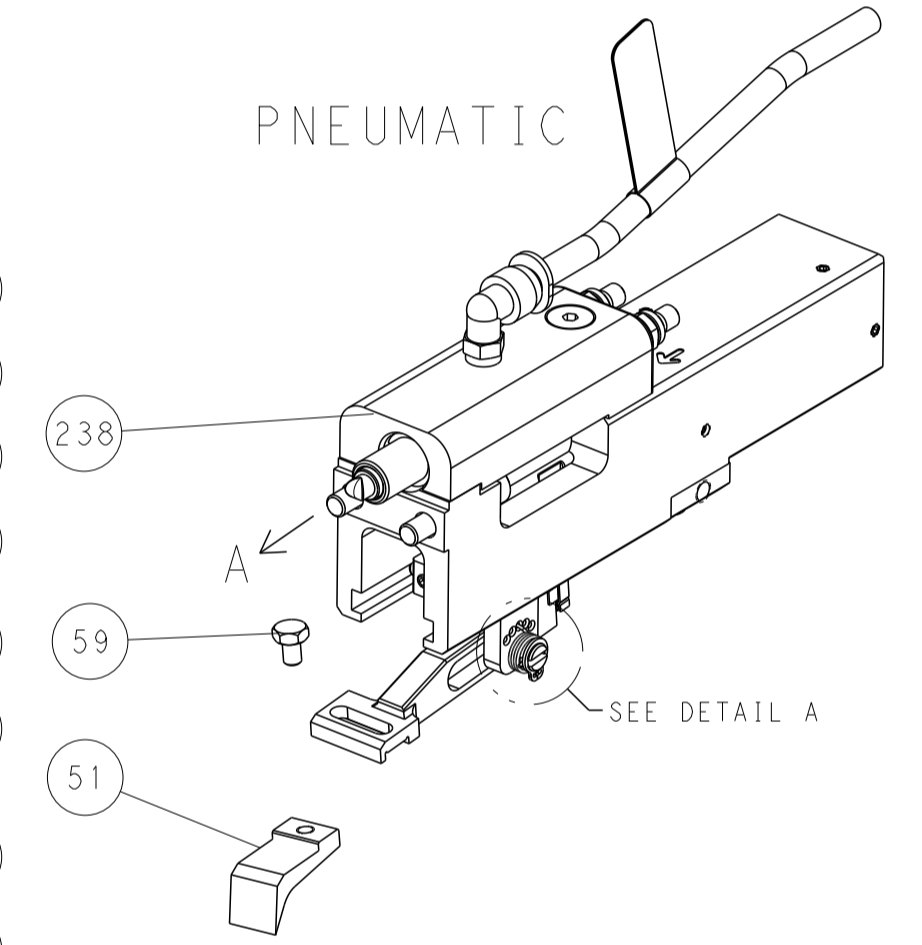


RAM SET-UP

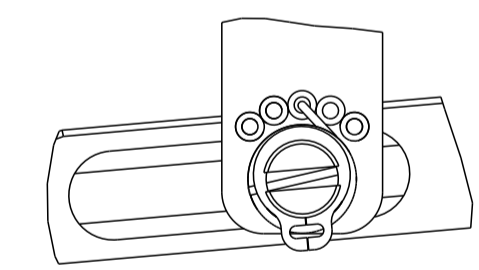
FEED TYPE
MECHANICAL



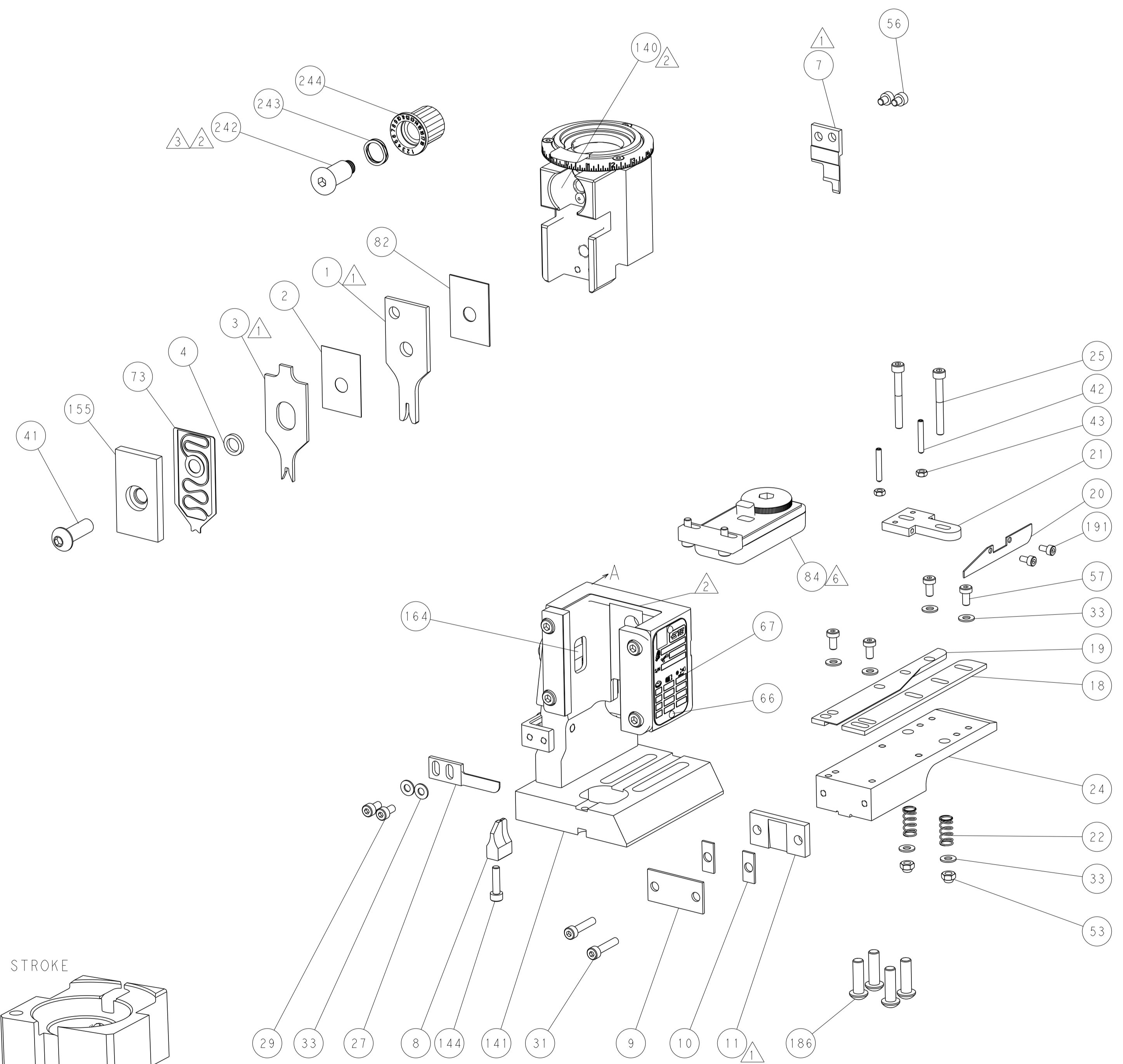
PNEUMATIC



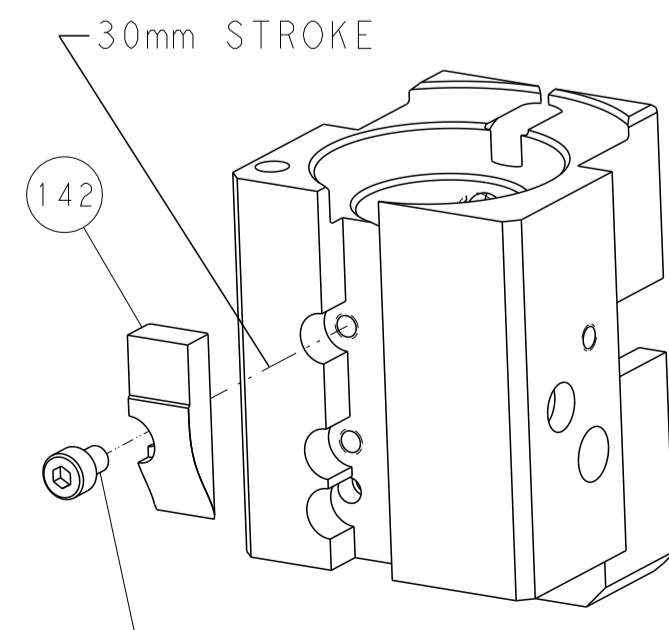
FEED SPRING
SETTING POSITION



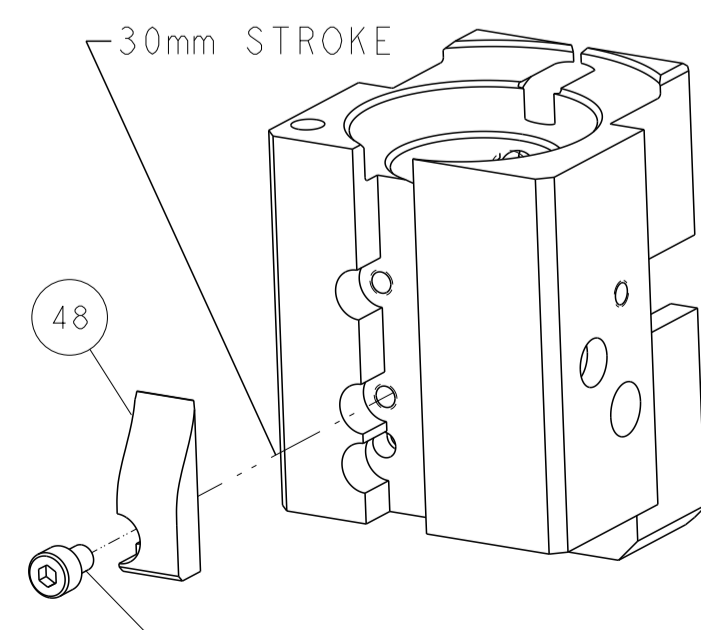
DETAIL A



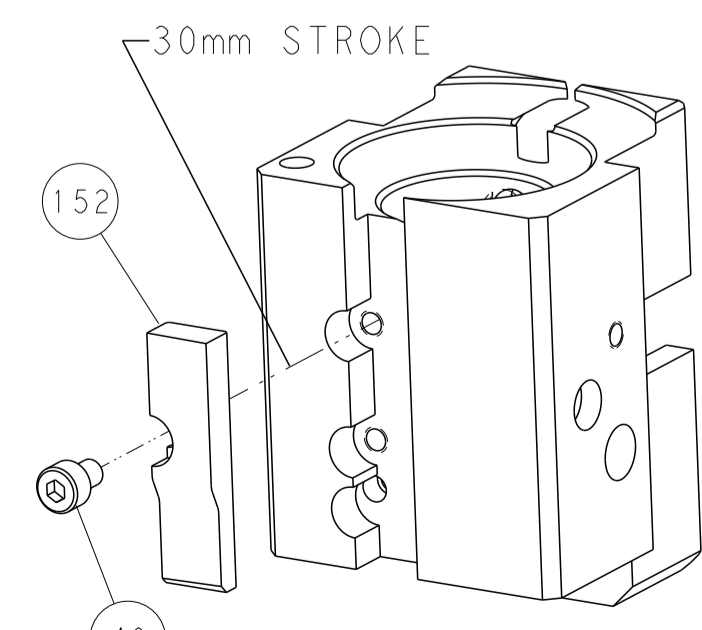
CAM POSITIONS



MECHANICAL POST FEED



MECHANICAL PRE FEED



AIR FEED

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:		DWG X_ZHAO 22JAN2016		CHK L_ZHANG 22JAN2016		APVD JJ_GUO 22JAN2016		NAME		STE TE Connectivity Harrisburg, PA 17105-3608	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES ±	FINISH ±	WEIGHT	SCALE	SHEET	OF	REV	RESTRICTED TO
MATERIAL								A1 00779	C=2150108	1:1	4	4	E