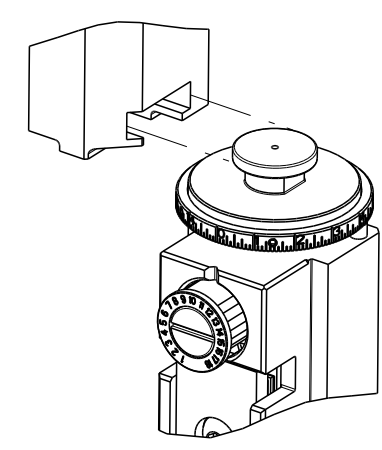


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150339-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2150339-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150339-1	C	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2150339-2	C	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150339-7	B	CRIMP TOOLING KIT	-

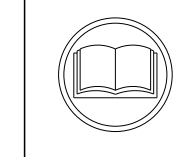
ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.54 mm [.100]	F
INSUL	4.40 mm [.173]	F
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: 6.3 SRS F-SPRING LIF RECEPTACLE			
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE		
5.90-6.90 mm [.232-.272 IN]	∅3.00-4.30 mm [.118-.169 IN]		
TERMINAL APPLICATION SPECIFICATION	114-64027		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
2178300-1			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
14 AWG	1.85+/-0.05 [.073+/-0.002]	6.2
16 AWG	1.64+/-0.05 [.065+/-0.002]	8.5
18 AWG	1.52+/-0.05 [.060+/-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. 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. 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.

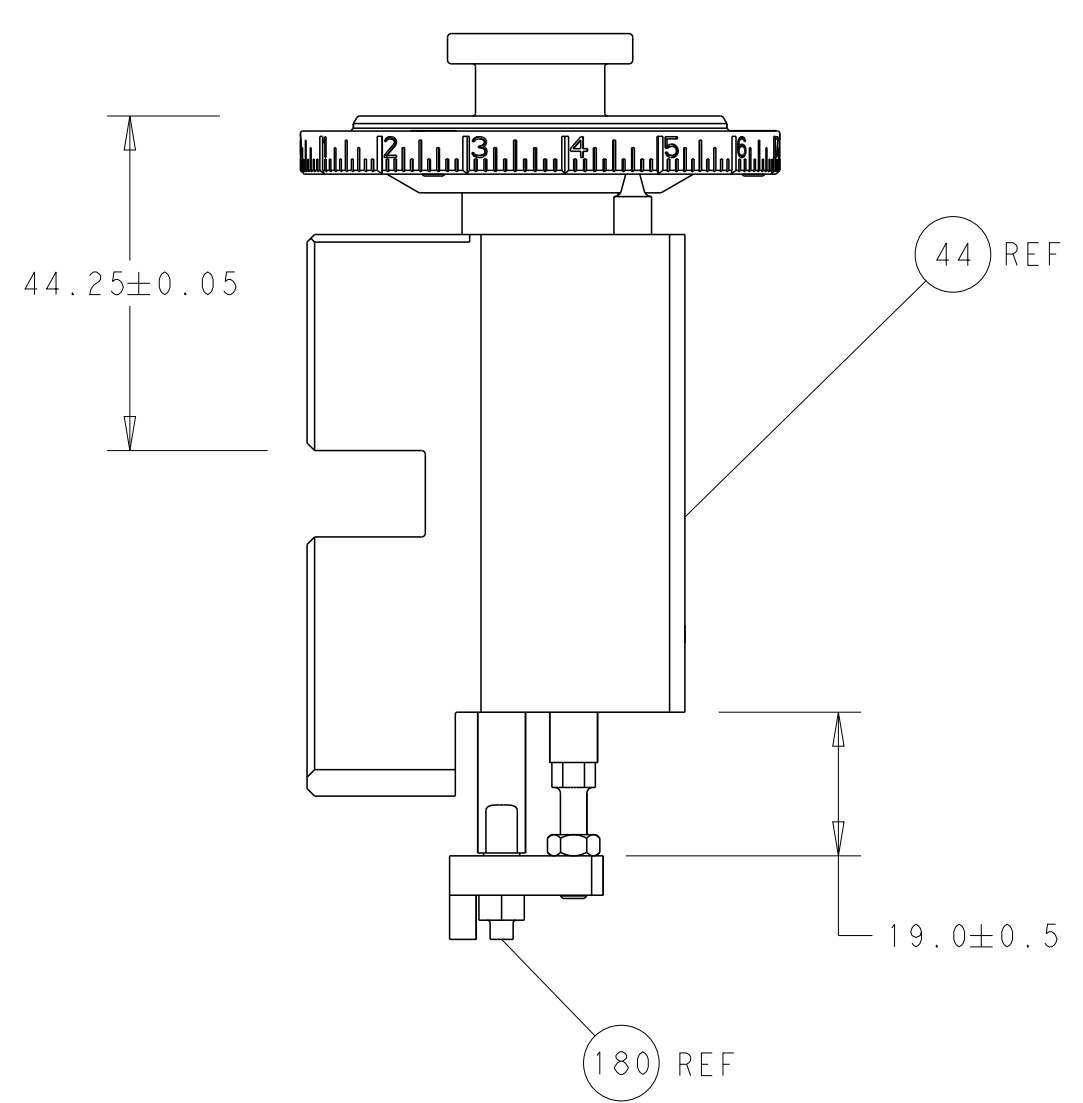
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

LOC	DIST	REVISIONS					
A	66	P	LTN	DESCRIPTION	DATE	DWN	APVD
		B		ECR-15-012277	18AUG2015	MR	JDG
		C		ECR-21-005726	26MAY2021	TB	RR

-	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	1976055-8	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	455888-6	SPACER, CRIMPER	82	
-	1	1	1	1	2119791-9	DEPRESSOR, WIRE	73	
-	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	2168083-9	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	240825-1	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	1901259-5	GUIDE, LOWER STRIP	18	
-	4	4	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17	
-	1	1	1	1	1752360-1	SPACER,HOLD-DOWN	13	
1	-	1	1	1	240644-9	PLATE, REAR SHEAR	11	
-	-	-	-	-	-	-	10	
1	-	1	1	1	690482-3	PLATE, FRONT SHEAR	9	
1	1	2	2	1	1-1803001-8	ANVIL, COMBINATION, END FEED	8	
1	-	1	1	1	1-2217206-3	BLADE, SLUG	7	
-	-	-	-	-	-	-	6	
-	1	1	1	1	2-240641-9	SPACER	5	
-	1	1	1	1	4-238011-5	BLOCK, CRIMPER SPACER	4	
1	1	2	2	1	1803223-3	CRIMPER, INSULATION F PREMIUM	3	
-	1	1	1	1	455888-1	SPACER, CRIMPER	2	
1	1	2	2	1	8-1633730-9	CRIMPER, WIRE	1	
-	77	72	71	2	-1	PART NO	DESCRIPTION	ITEM NO

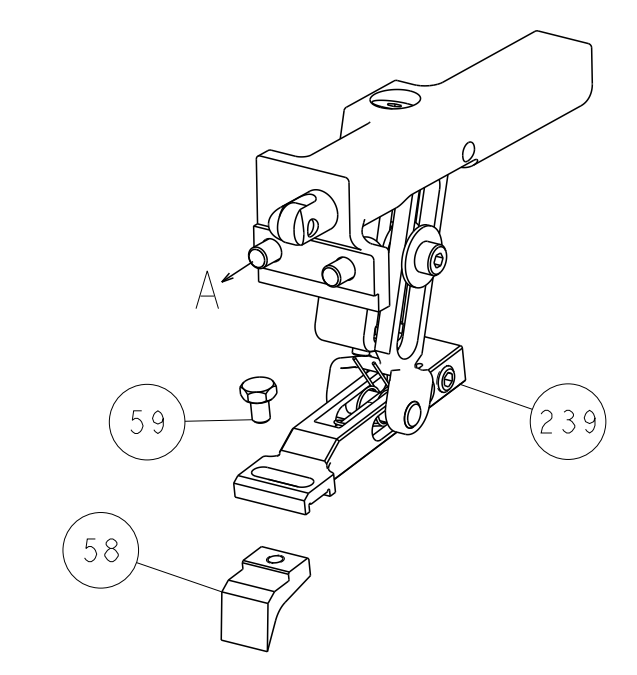
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		MATERIAL:		FINISH:		WEIGHT:		SCALE:		SHEET:		REV:	
mm	0 PLC ±.5	1 PLC ±0.5	2 PLC ±0.13	3 PLC ±0.013	4 PLC ±0.001	ANGLES ±.001	FINISH			A	00779	©=2150339	1	4	C
Customer Accessible Production Drawing										SCALE 1:1		SHEET 1 OF 4		REV C	

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

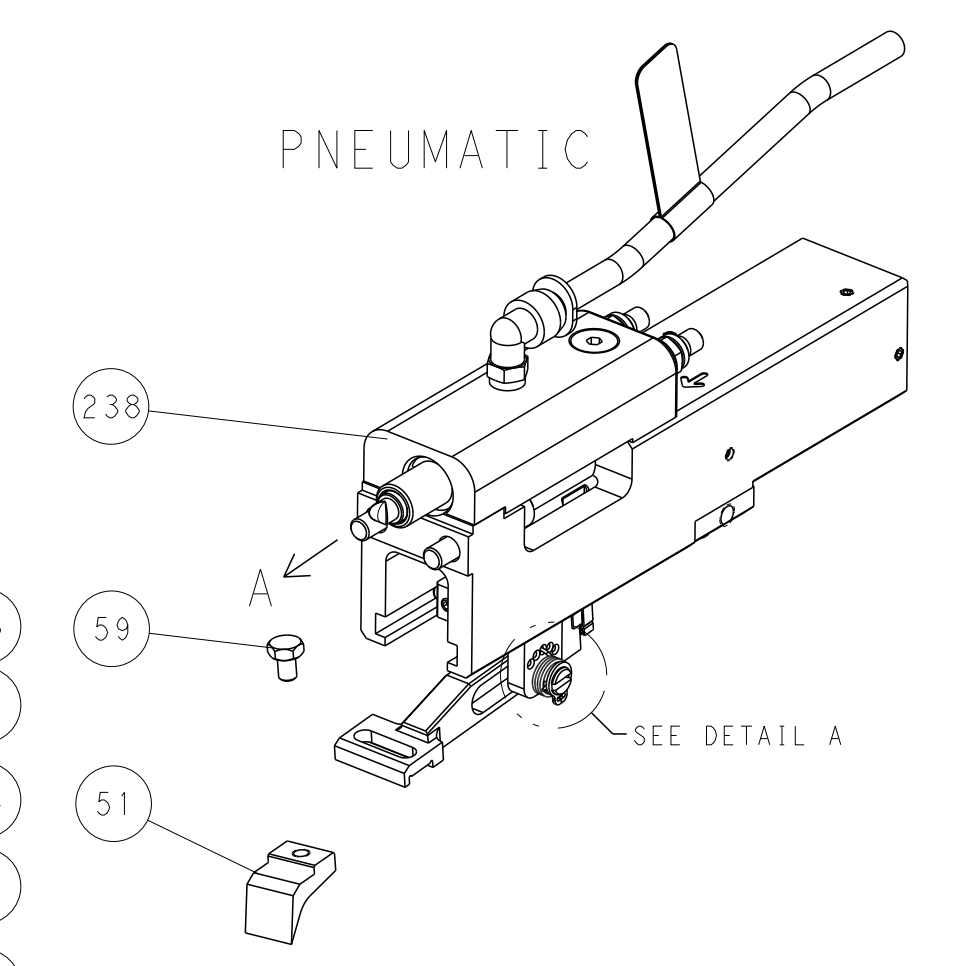


RAM AND HOLDDOWN SET-UP

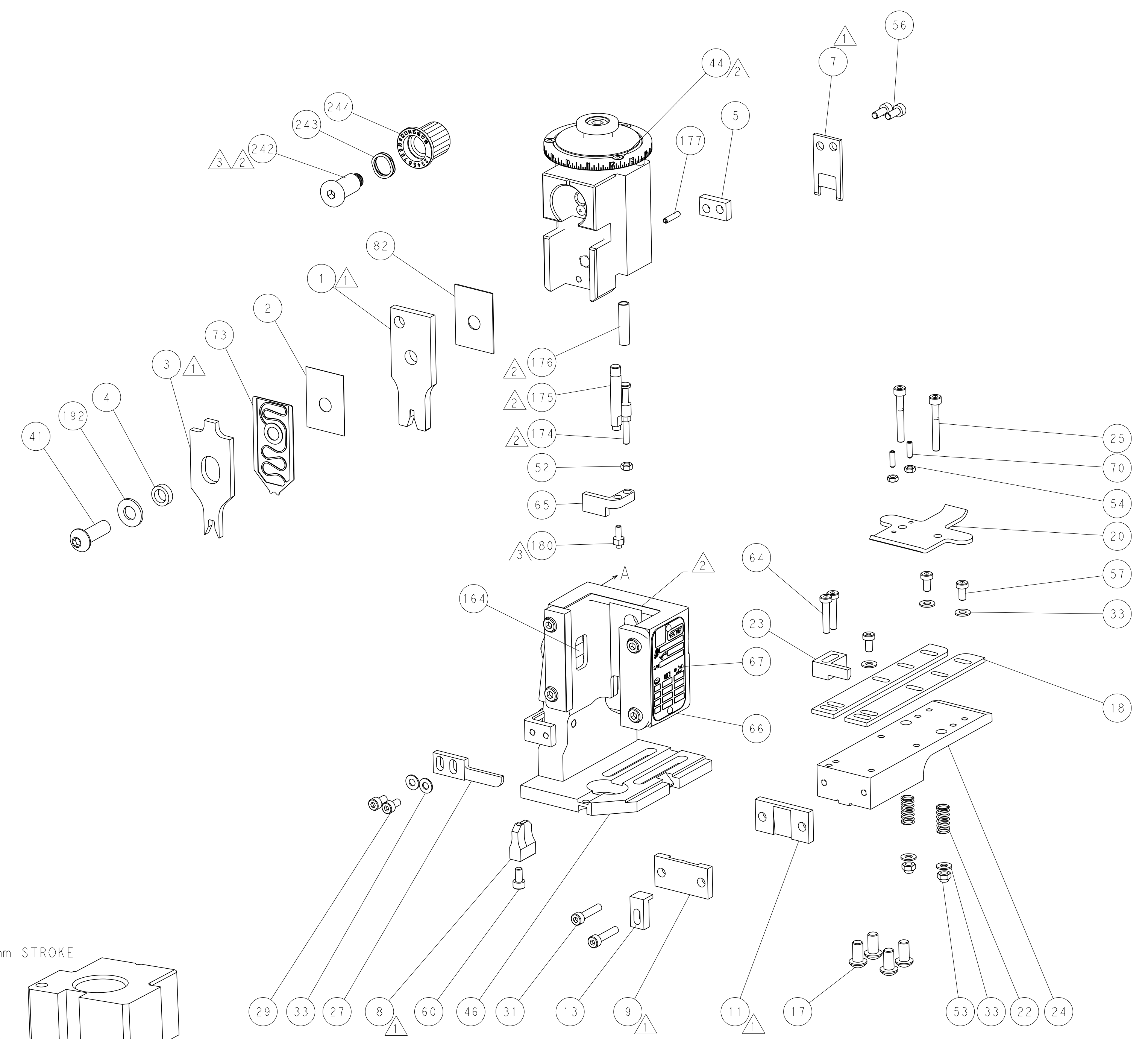
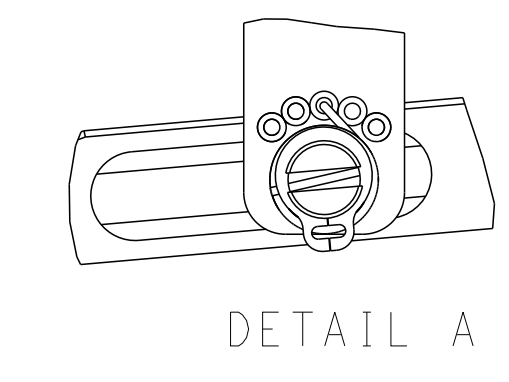
FEED TYPE
MECHANICAL



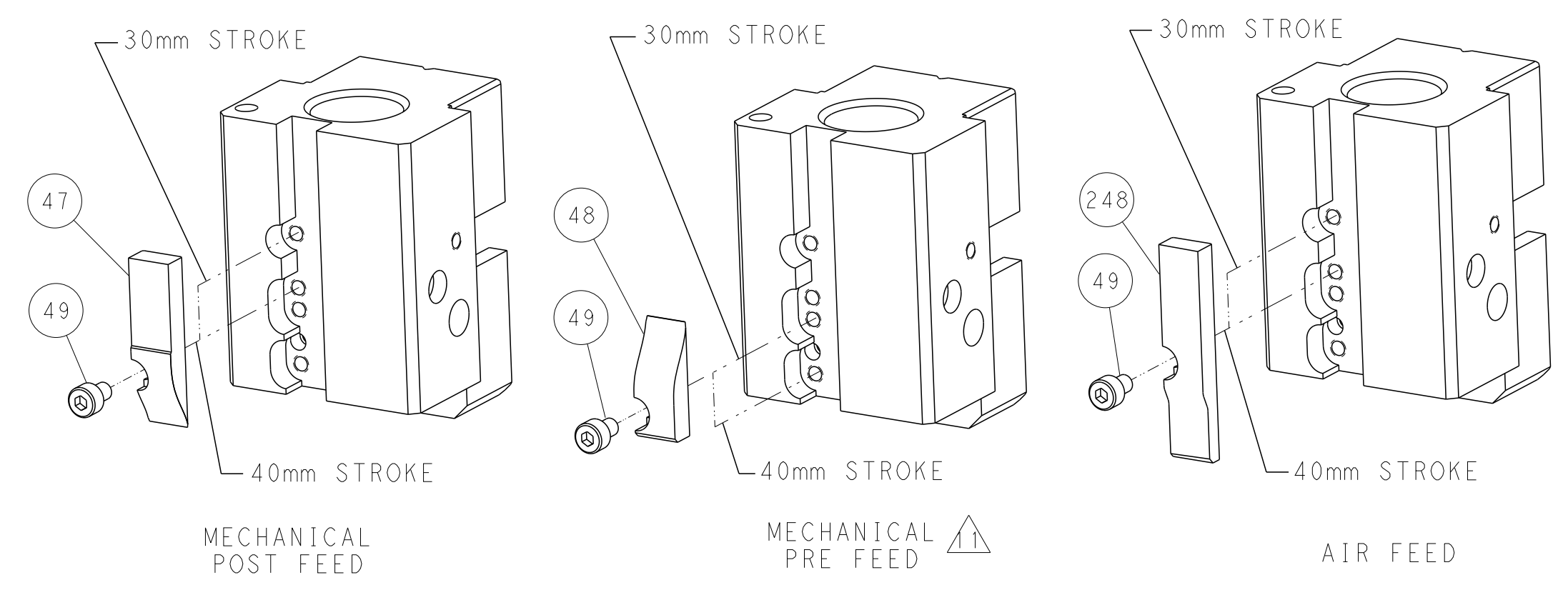
PNEUMATIC



FEED SPRING
SETTING POSITION



CAM POSITIONS

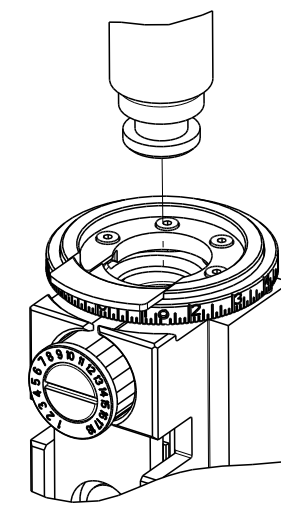


ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

<small>THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.</small>		DWN: K. HUANG 06MAY2013 CHK: L. ZHANG 06MAY2013 APVD: J. GUO 06MAY2013	TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±0.5 1 PLC ±0.13 3 PLC ±0.013 4 PLC ±0.001 ANGLES FINISH ±		NAME: Ocean End Feed Applicator PRODUCT SPEC: APPLICATION SPEC: WEIGHT:	SIZE: A1 CAGE CODE: 00779 DRAWING NO: C-2150339 RESTRICTED TO:
MATERIAL:		SCALE: 1:1 SHEET: 2 of 4 REV: C	Customer Accessible Production Drawing

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150339-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2150339-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150339-7	B	CRIMP TOOLING KIT	-

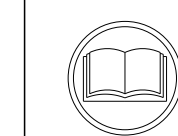
PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.54 mm [.100]	F
INSUL	4.40 mm [.173]	F
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: 6.3 SRS F-SPRING LIF RECEPTACLE			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
5.90-6.90 mm [.232-.272 IN]		3.00-4.30 mm [.118-.169 IN]	
TERMINAL APPLICATION SPECIFICATION	114-64027	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
2178300-1			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
14 AWG	1.85 +/- 0.05 [.073 +/- .002]	6.2
16 AWG	1.64 +/- 0.05 [.065 +/- .002]	8.5
18 AWG	1.52 +/- 0.05 [.060 +/- .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. 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.
- 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	1976055-8	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	455888-6	SPACER, CRIMPER	82	
-	1	1	2119791-9	DEPRESSOR, WIRE	73	
-	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	2168083-9	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	240825-1	PLATE, STRIP HOLD DOWN	23	
-	2	2	2-22281-3	SPRING, COMPRESSION	22	
-	1	1	1803292-4	DRAG	20	
-	2	2	1901259-5	GUIDE, LOWER STRIP	18	
-	1	1	1752360-1	SPACER, HOLD-DOWN	13	
1	-	1	240644-9	PLATE, REAR SHEAR	11	
-	-	-	-	-	10	
-	1	1	690482-3	PLATE, FRONT SHEAR	9	
1	1	1	1-1803001-8	ANVIL, COMBINATION, END FEED	8	
1	-	1	1-2217206-3	BLADE, SLUG	7	
-	-	-	-	-	6	
-	1	1	2-240641-9	SPACER	5	
-	1	1	4-238011-5	BLOCK, CRIMPER SPACER	4	
1	1	1	1803223-3	CRIMPER, INSULATION F PREMIUM	3	
-	1	1	455888-1	SPACER, CRIMPER	2	
1	1	1	8-1633730-9	CRIMPER, WIRE	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)

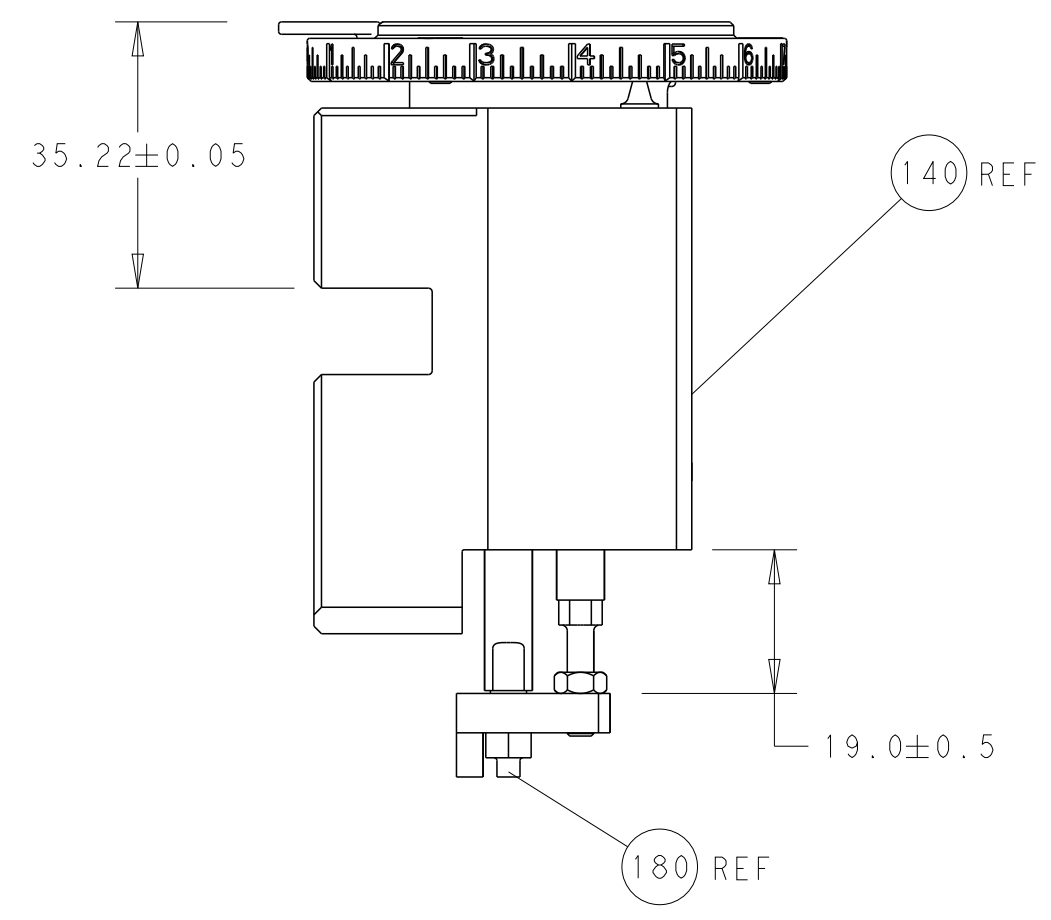
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DRAWING NO	
mm	0 PLC ±0.5	1 PLC ±0.13	2 PLC ±0.013	3 PLC ±0.001	4 PLC ±0.001
ANGLES	FINISH		SCALE		
MATERIAL	FINISH		SCALE		

CHK	DATE	NAME
H. HUANG	06MAY2013	NAME
L. ZHANG	06MAY2013	NAME
J. GUO	06MAY2013	NAME

SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
A1	00779	2150339	-

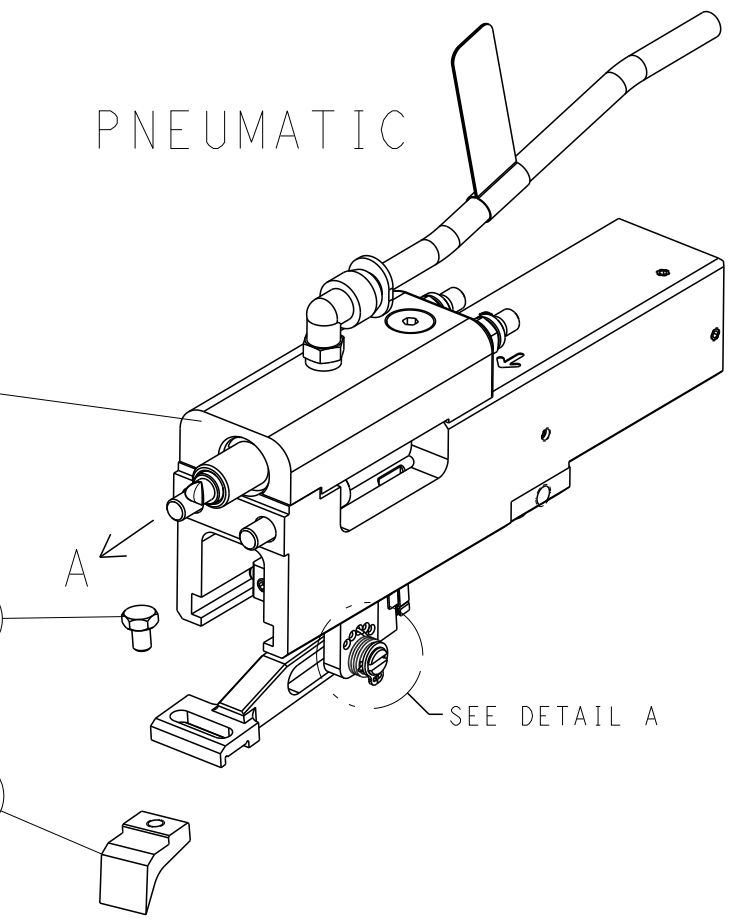
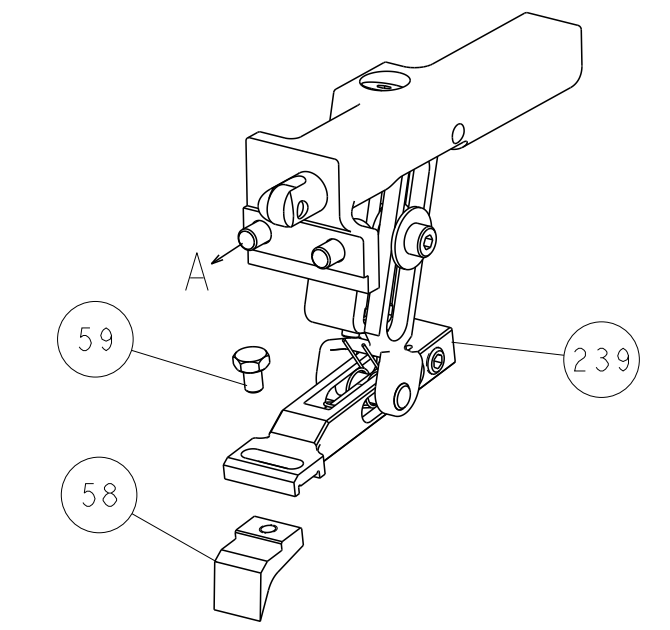
Customer Accessible Production Drawing

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

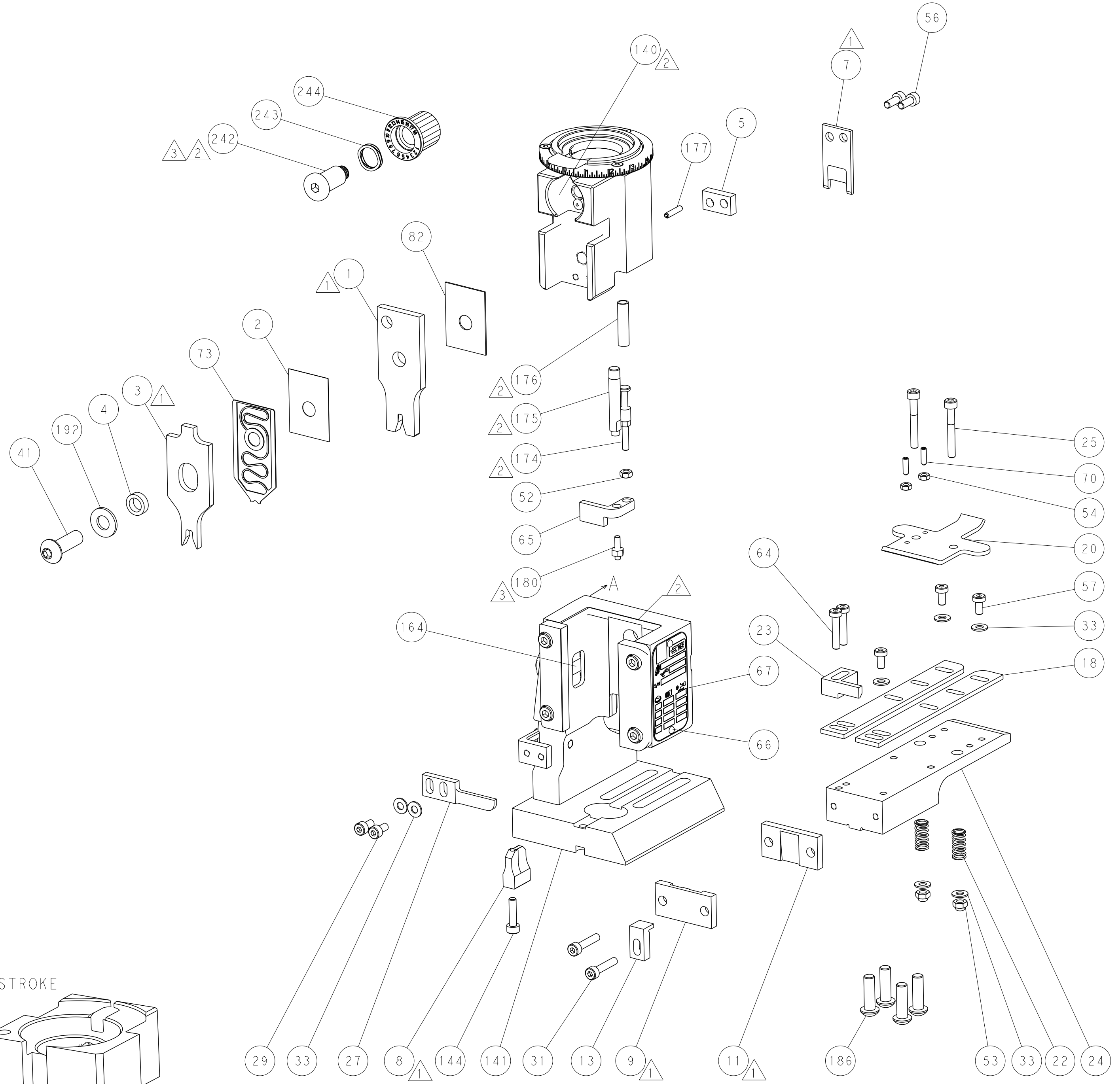
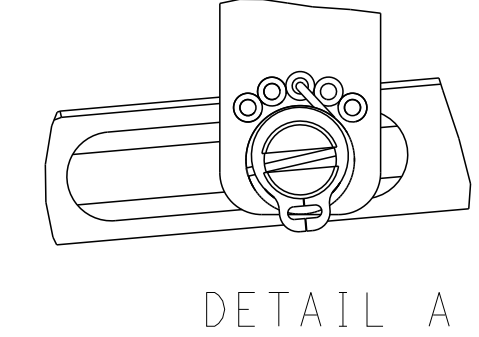


RAM AND HOLDDOWN SET-UP

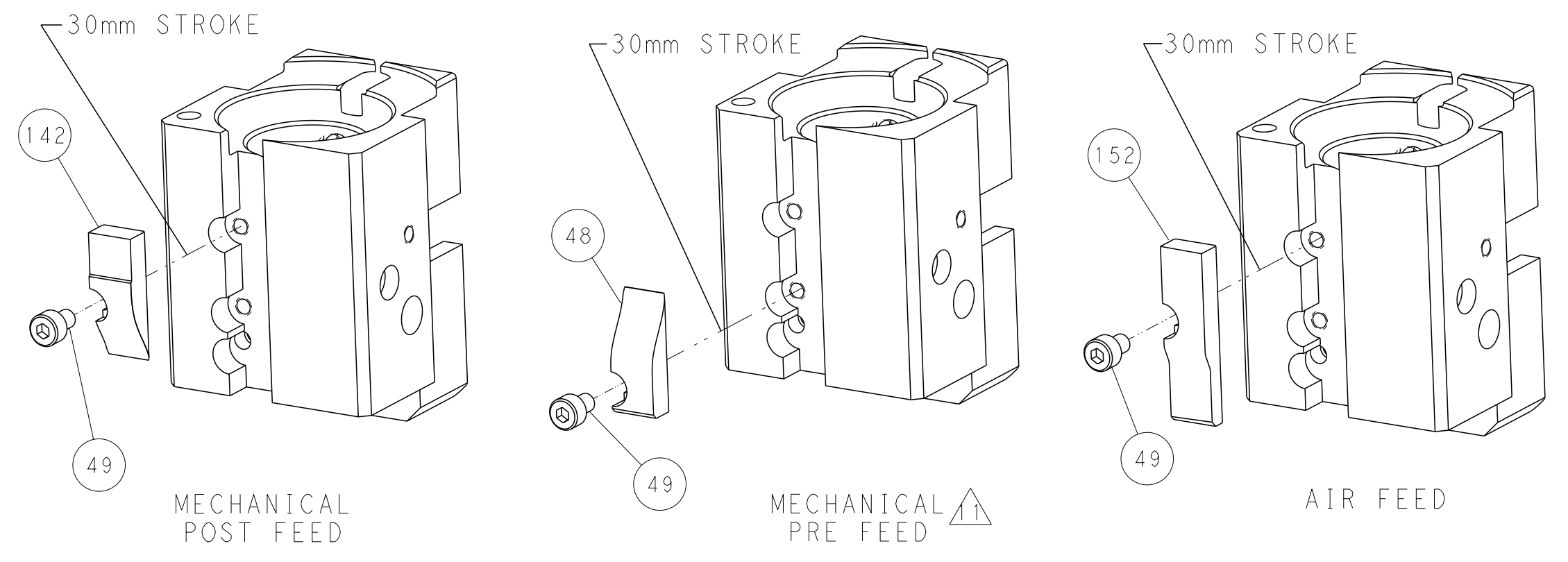
FEED TYPE
MECHANICAL



FEED SPRING
SETTING POSITION



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: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.5 1 PLC ±0.5 2 PLC ±0.13 3 PLC ±0.013 4 PLC ±0.001 ANGLES FINISH ±.		DWN K. HUANG 06MAY2013 CHK L. ZHANG 06MAY2013 APVD JJ. GUO 06MAY2013		TE Connectivity Harrisburg, PA 17105-3608	
MATERIAL:		WEIGHT:		SIZE: CAGE CODE: DRAWING NO:		RESTRICTED TO:	
CUSTOMER ACCESSIBLE PRODUCTION DRAWING		SCALE: 1:1		SHEET 4 OF 4		REV C	