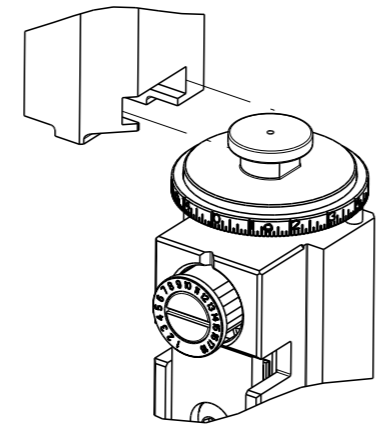


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150374-2	H	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150374-2	H	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150374-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	4.06 mm [1.60]	F
INSUL	6.35 mm [1.250]	F

APPLICATOR INSTRUCTIONS 408-35043

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: .375 SERIES FASTIN-FASTON RECEPTACLE			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
6.48-7.24 mm [1.255-.285 IN]		∅3.00-5.08 mm [1.118-.200 IN]	
TERMINAL APPLICATION SPECIFICATION	114-20021	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
280756-2	280756-4		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
6.00mm2	2.79+/-0.05 [1.110+/-0.002]	4.8
4.00mm2	2.59+/-0.05 [1.102+/-0.002]	6.8
3.00mm2	2.39+/-0.05 [1.094+/-0.002]	7.6

- 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.
- 6. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- THIS CRIMP PARAMETER IS PROVIDED TO MEET A CUSTOM AND UNIQUE CUSTOMER REQUIREMENT. IT HAS BEEN EVALUATED AND IS CONDITIONALLY SPECIFIED BY TE CONNECTIVITY. THIS CUSTOMIZED CRIMP PARAMETER IS NOT LISTED AS AN APPROVED APPLICATION WITHIN A TE CONNECTIVITY APPLICATION SPECIFICATION; HOWEVER, IT HAS BEEN VALIDATED ACCORDING TO TE CONNECTIVITY SPECIFICATIONS 109-18079 (TEST GROUP 1) AND 114-18022. TE CONNECTIVITY EXPRESSLY DISCLAIMS ANY AND ALL WARRANTIES THAT THE PRODUCT WILL PERFORM SIMILARLY TO VALIDATED AND APPROVED APPLICATIONS, AS STATED WITHIN TE CONNECTIVITY APPLICATION SPECIFICATIONS, INCLUDING BUT NOT LIMITED TO IMPLIED WARRANTIES OF MERCHANTABILITY OR FITNESS FOR PARTICULAR PURPOSE. AS SUCH, IT IS HIGHLY RECOMMENDED THAT THE CUSTOMER PERFORM FURTHER DETAILED EVALUATION TO ASSESS PRODUCT PERFORMANCE IN THE SPECIFIC APPLICATION.

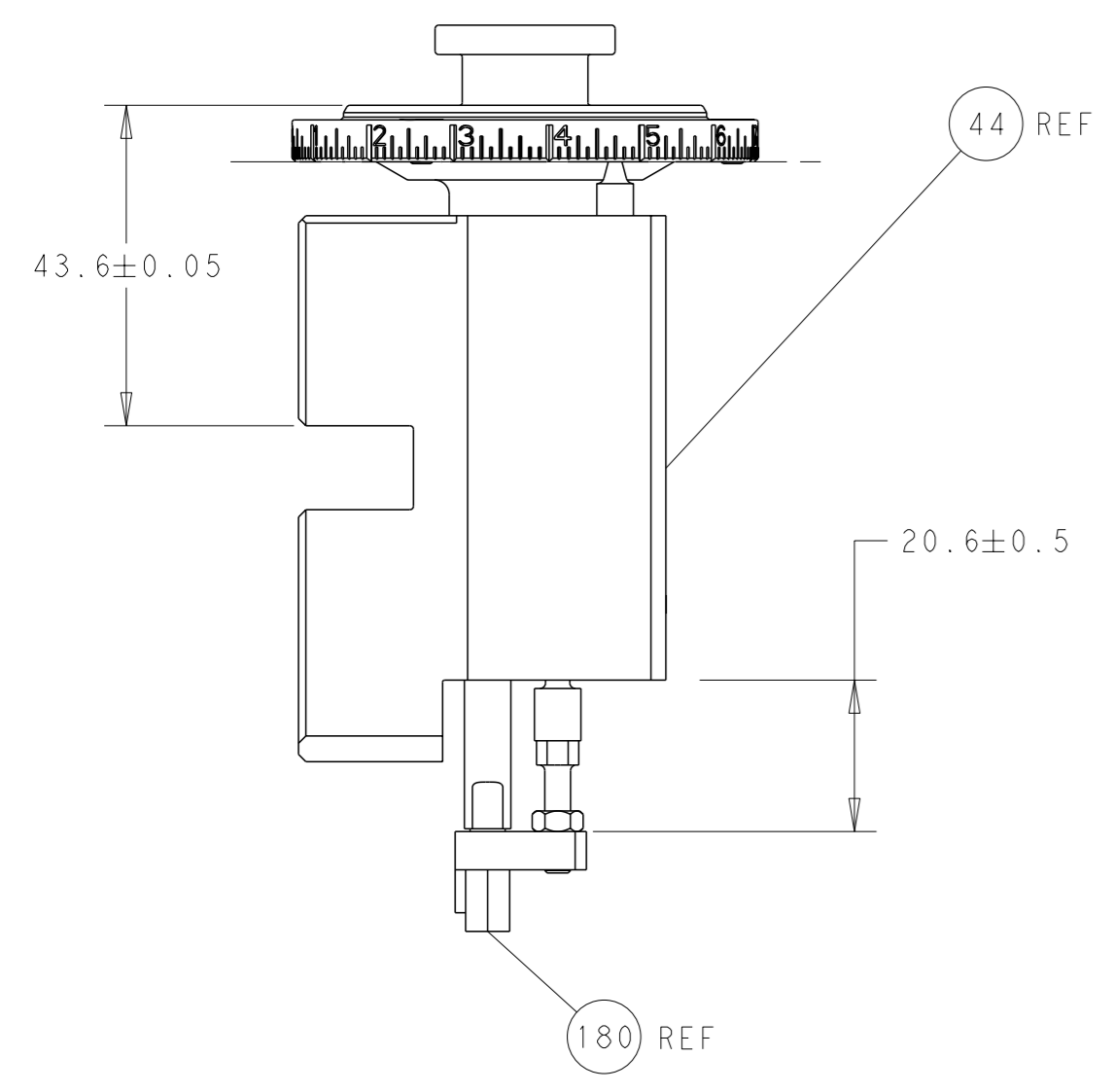
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		P	LYR	DESCRIPTION	DATE	OWN	APVD
A	66	E		ECR-21-003458	20MAR2021	TB	RK
		F		ECR-22-153451	22SEP2022	FZ	JAH
		G		ECR-23-180139	03JUL2023	JWC	JH
		H		ECR-23-186535	08SEP2023	FZ	GB

-	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	2844940-4	AIR FEED MODULE	238		
-	1	1	1-18028-0	WASHER, FLAT, REG M8	192		
	1	1	1-1752354-8	STANDOFF,HOLD-DOWN	180		
-	1	1	6-9931111-6	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	1	2119955-2	ASSY, LUBRICATOR, END FEED	84		
-	1	1	455888-4	SPACER, CRIMPER	82		
-	1	1	2119791-5	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	1901681-9	HOLDDOWN, TERMINAL	65		
-	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	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	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	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	690455-1	STRIPPER, FRONT CASTING	27		
-	2	2	1-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 30	25		
-	1	1	1752371-6	PLATE, STRIP GUIDE	24		
-	1	1	240825-2	PLATE, STRIP HOLD DOWN	23		
-	2	2	2-22281-2	SPRING, COMPRESSION	22		
-	1	1	1803292-4	DRAG	20		
-	2	2	1901259-7	GUIDE, LOWER STRIP	18		
-	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17		
-	1	1	1-240641-4	SPACER	16		
-	1	1	1752360-1	SPACER,HOLD-DOWN	13		
	1	1	240833-3	PLATE, REAR SHEAR	11		
-	-	-	-	-	10		
	1	1	690482-6	PLATE, FRONT SHEAR	9		
	1	2	1333223-4	ANVIL, COMBINATION	8		
	1	1	2217206-5	BLADE, SLUG	7		
-	-	-	-	-	6		
-	1	1	1-240641-8	SPACER	5		
-	1	1	1-238011-2	BLOCK, CRIMPER SPACER	4		
	1	2	2-1803016-6	CRIMPER, INSULATION F	3		
-	1	1	455888-4	SPACER, CRIMPER	2		
	1	2	2-456414-0	CRIMPER, WIRE	1		
-	77	72	-2	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)

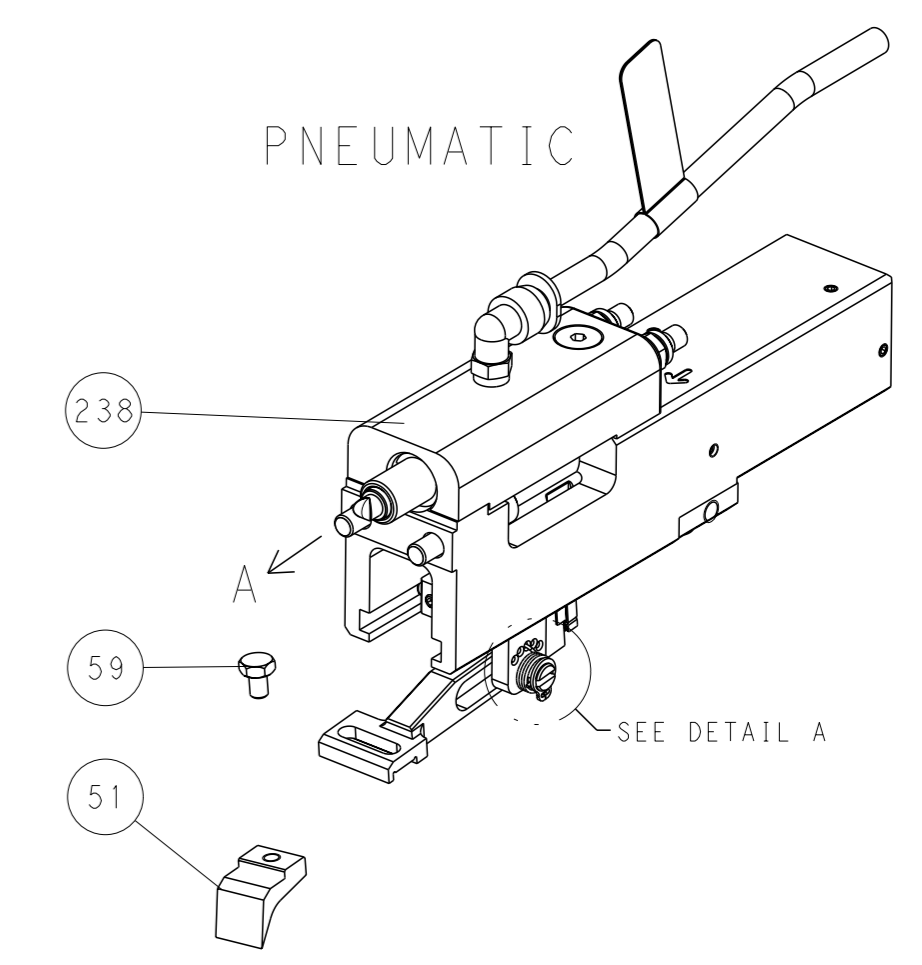
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MATERIAL		FINISH		WEIGHT		SCALE	
				A1		00779 ©=2150374	
Customer Accessible Production Drawing				SCALE 1:1		SHEET 1 of 4 REV H	

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

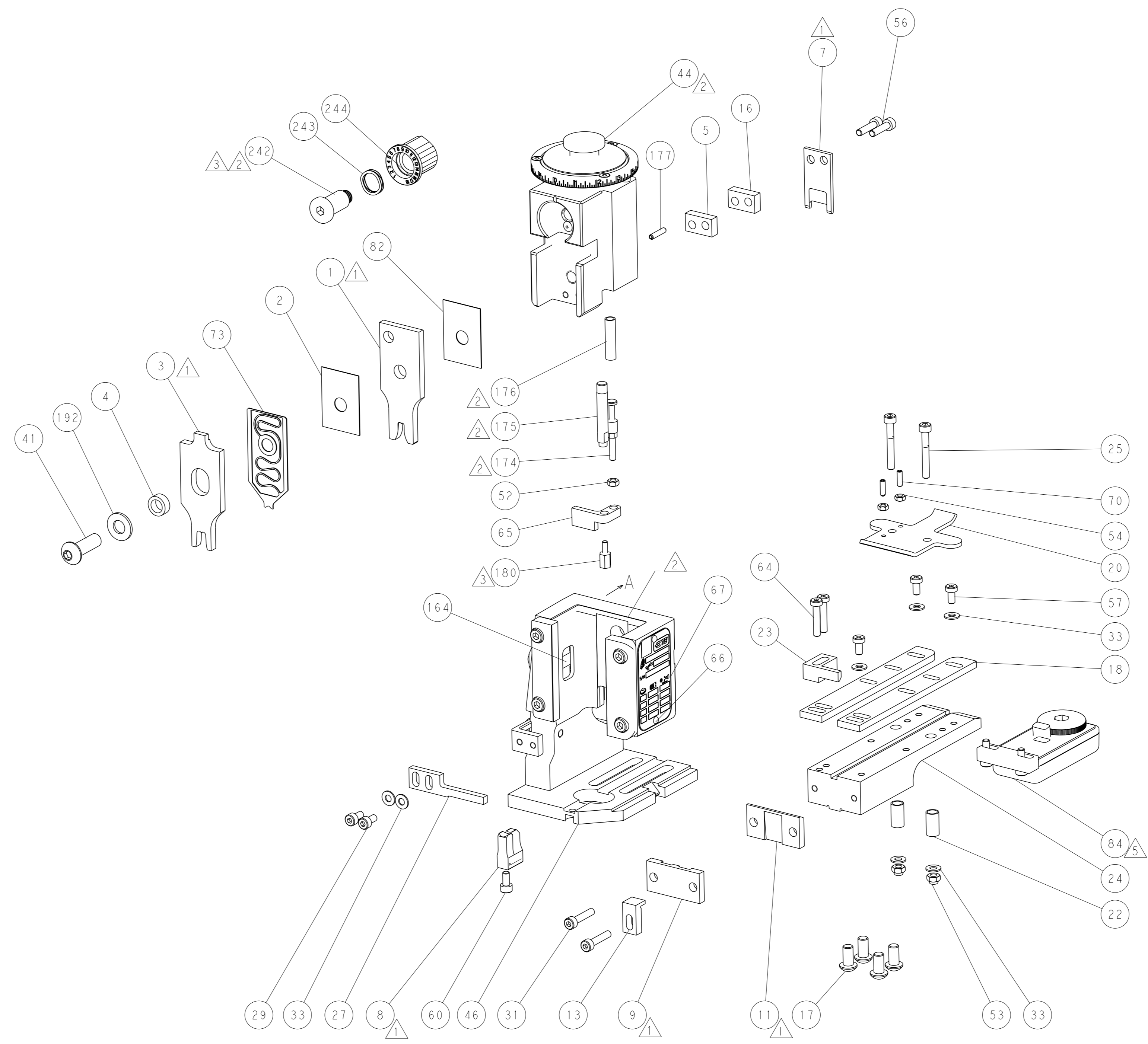
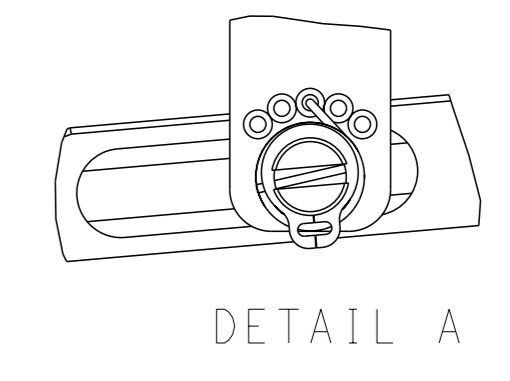


RAM AND HOLDDOWN SET-UP

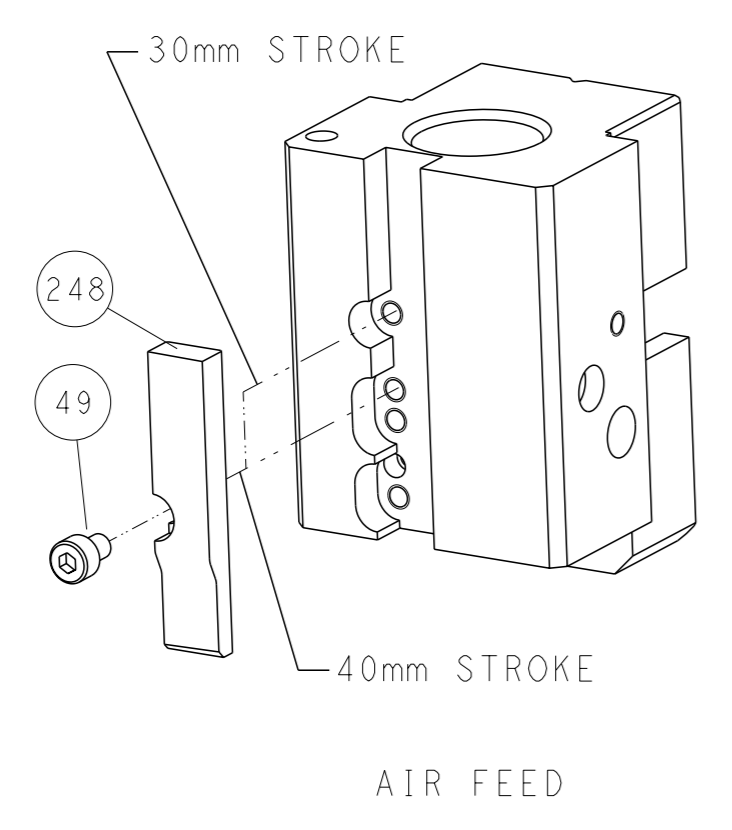
FEED TYPE



FEED SPRING SETTING POSITION



CAM POSITION

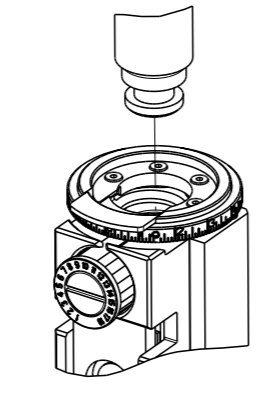


**ATLANTIC VERSION**  
 Shown on sheets 1 of 4 & 2 of 4  
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

<small>THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE AND THE CONTROL AND EXISTING DESIGNATION SHOULD BE CONTACTED FOR THE LATEST REVISION.</small>		DWN X_ZHAO 10OCT2013 CHK T_ELBIN 10OCT2013 APVD L_ZHANG 10OCT2013	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 CAGE CODE DRAWING NO. RESTRICTED TO A1 00779 C=2150374	WEIGHT - SCALE 1:1 SHEET 2 of 4 REV H
MATERIAL - FINISH -		Customer Accessible Production Drawing	

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150374-2	H	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150374-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR  
 INTERFACE ADAPTER



APPLICATOR DATA

CRIMP	SIZE	TYPE
WIRE	4.06 mm [1.601]	F
INSUL	6.35 mm [1.250]	F

APPLICATOR INSTRUCTIONS  
 408-35043

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION

TERMINAL NAME: .375 SERIES FASTIN-FASTON RECEPTACLE

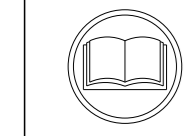
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE
6.48-7.24 mm [1.255-.285 IN]	Ø3.00-5.08 mm [1.118-.200 IN]

TERMINAL APPLICATION SPECIFICATION 114-20021

TERMINALS APPLIED 3 7

TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
280756-2	280756-4		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
6.00mm2	2.79+/-0.05 [1.110+/-0.021]	4.8
4.00mm2	2.59+/-0.05 [1.102+/-0.021]	6.8
3.00mm2	2.39+/-0.05 [1.094+/-0.021]	7.6



- 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.
- TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- THIS CRIMP PARAMETER IS PROVIDED TO MEET A CUSTOM AND UNIQUE CUSTOMER REQUIREMENT. IT HAS BEEN EVALUATED AND IS CONDITIONALLY SPECIFIED BY TE CONNECTIVITY. THIS CUSTOMIZED CRIMP PARAMETER IS NOT LISTED AS AN APPROVED APPLICATION WITHIN A TE CONNECTIVITY APPLICATION SPECIFICATION; HOWEVER, IT HAS BEEN VALIDATED ACCORDING TO TE CONNECTIVITY SPECIFICATIONS 109-18079 (TEST GROUP 1) AND 114-18022. TE CONNECTIVITY EXPRESSLY DISCLAIMS ANY AND ALL WARRANTIES THAT THE PRODUCT WILL PERFORM SIMILARLY TO VALIDATED AND APPROVED APPLICATIONS, AS STATED WITHIN TE CONNECTIVITY APPLICATION SPECIFICATIONS, INCLUDING BUT NOT LIMITED TO IMPLIED WARRANTIES OF MERCHANTABILITY OR FITNESS FOR PARTICULAR PURPOSE. AS SUCH, IT IS HIGHLY RECOMMENDED THAT THE CUSTOMER PERFORM FURTHER DETAILED EVALUATION TO ASSESS PRODUCT PERFORMANCE IN THE SPECIFIC APPLICATION.

**\*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	LYR	DESCRIPTION	DATE	OWN	APVD
		-		SEE SHEET 1		-	-

-	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	2844940-4	AIR FEED MODULE	238	
-	1	1-18028-0	WASHER, FLAT, REG M8	192	
-	4	2079383-9	SCR, BHSC, RoHS (M6 X 20)	186	
3	-	1	1-1752354-8	STANDOFF, HOLD-DOWN	180
-	1	6-993111-6	PIN, SLOTTED SPRING 3.0 X 14.0	177	
-	1	8-22280-7	SPRING, COMPRESSION	176	
-	1	1752353-2	GUIDE PIN, HOLDDOWN	175	
-	1	1901680-2	GUIDE PIN, HOLDDOWN	174	
-	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	455888-4	SPACER, CRIMPER	82	
-	1	2119791-5	DEPRESSOR, WIRE	73	
-	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	
-	1	1901681-9	HOLDDOWN, TERMINAL	65	
-	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	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	56	
-	2	5018030-1	NUT, HEX, REG, RoHS, M3	54	
-	2	986965-8	NUT, LOCK, HEX, TORQUE (M4)	53	
-	1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52	
-	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	690455-1	STRIPPER, FRONT CASTING	27	
-	2	1-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 30	25	
-	1	1752371-6	PLATE, STRIP GUIDE	24	
-	1	240825-2	PLATE, STRIP HOLD DOWN	23	
-	2	2-22281-2	SPRING, COMPRESSION	22	
-	1	1803292-4	DRAG	20	
-	2	1901259-7	GUIDE, LOWER STRIP	18	
-	1	1-240641-4	SPACER	16	
-	1	1752360-1	SPACER, HOLD-DOWN	13	
1	-	1	240833-3	PLATE, REAR SHEAR	11
-	-	-	-	10	
-	1	690482-6	PLATE, FRONT SHEAR	9	
1	1	1333223-4	ANVIL, COMBINATION	8	
-	1	2217206-5	BLADE, SLUG	7	
-	-	-	-	6	
-	1	1-240641-8	SPACER	5	
-	1	1-238011-2	BLOCK, CRIMPER SPACER	4	
1	1	2-1803016-6	CRIMPER, INSULATION F	3	
-	1	455888-4	SPACER, CRIMPER	2	
1	1	2-456414-0	CRIMPER, WIRE	1	
-	77-22	PART NO	DESCRIPTION	ITEM NO	

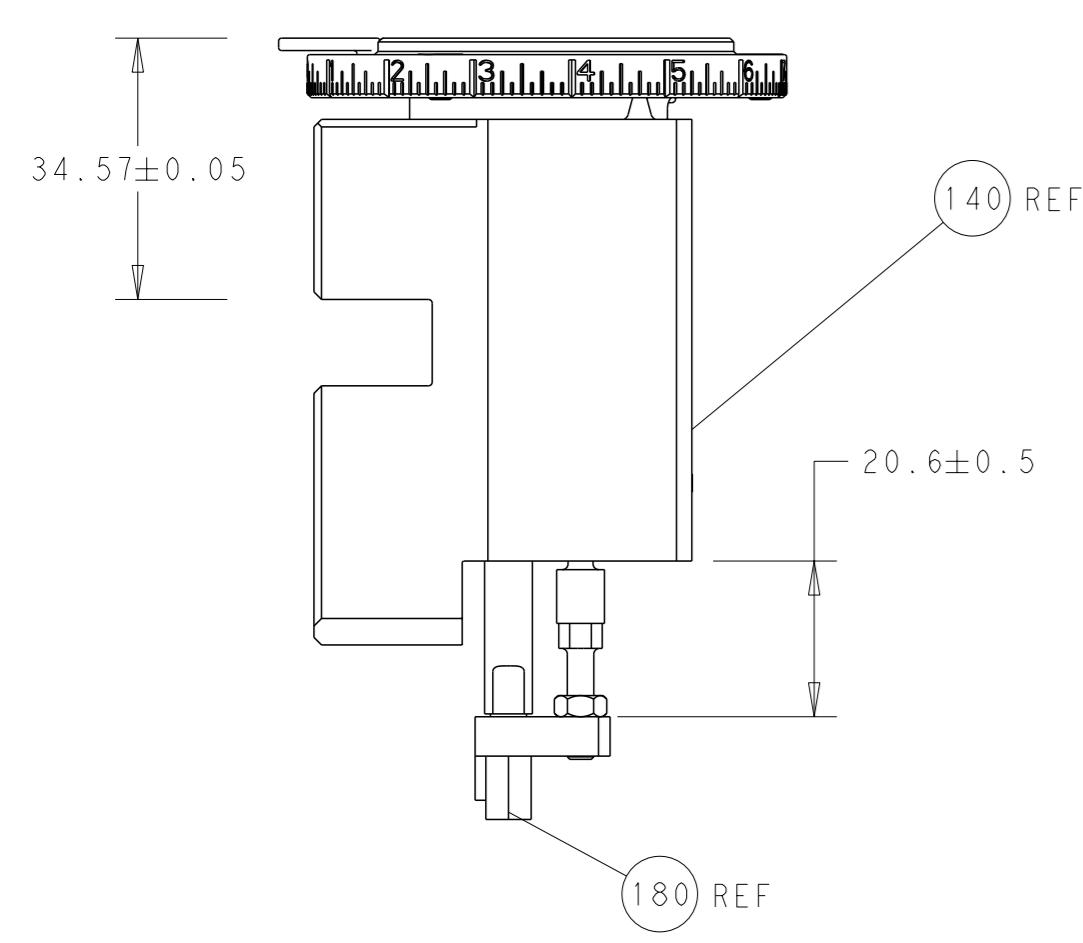
PACIFIC VERSION  
 Shown on sheets 3 of 4 & 4 of 4  
 (Atlantic version shown on sheets 1 of 4 & 2 of 4)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		APPROVED BY:		DATE:	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES FINISH	★
MATERIAL		FINISH		WEIGHT		SCALE	
-		-		-		1:1	

OWN	CHK	APVD	NAME
X. ZHAO	T. ELBIN	L. ZHANG	TE Connectivity
10OCT2013	10OCT2013	10OCT2013	Harrisburg, PA 17105-3608

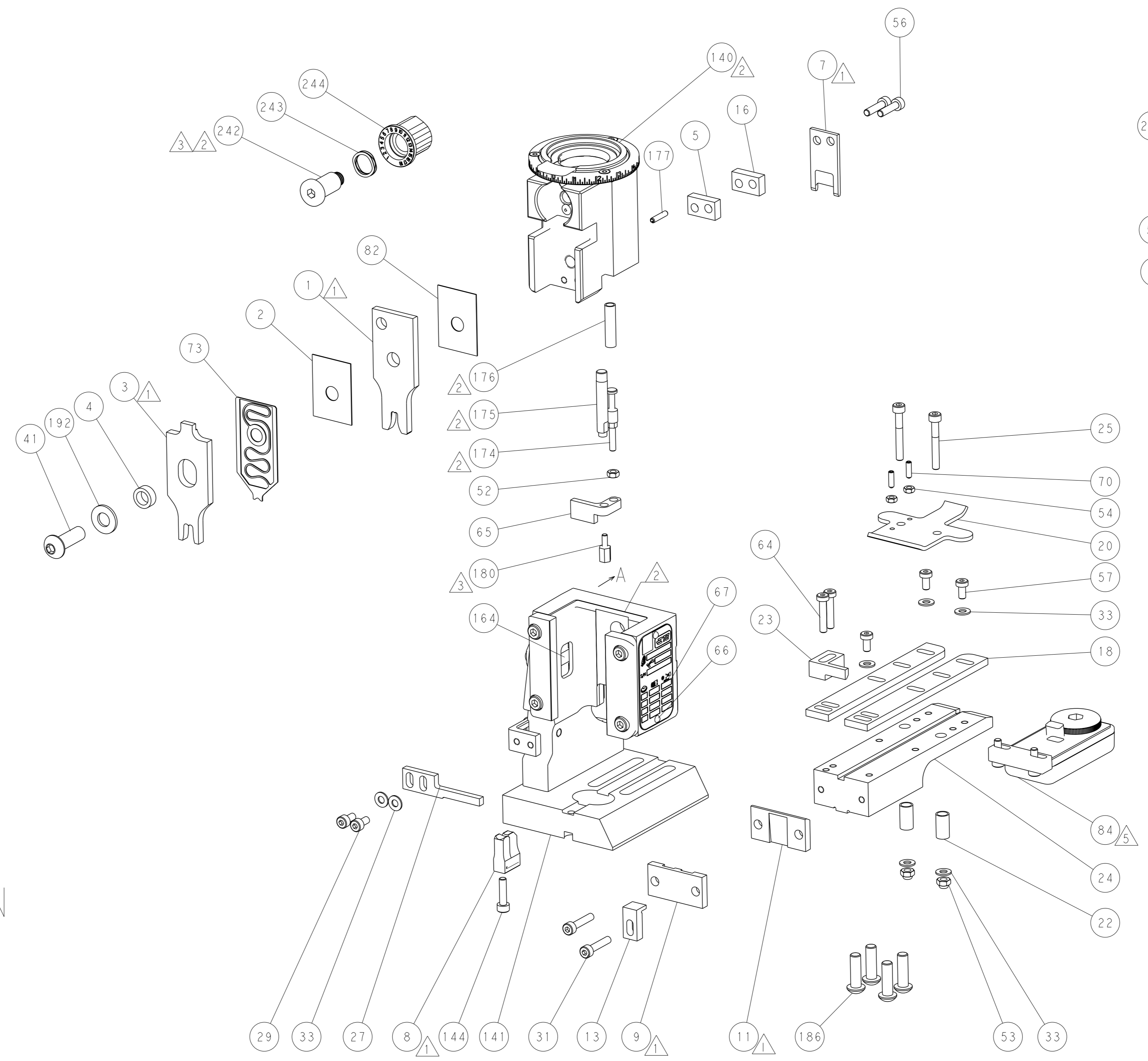
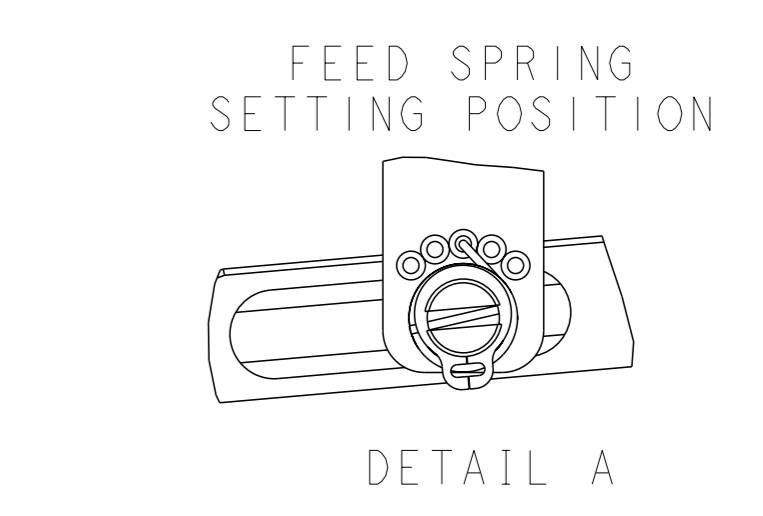
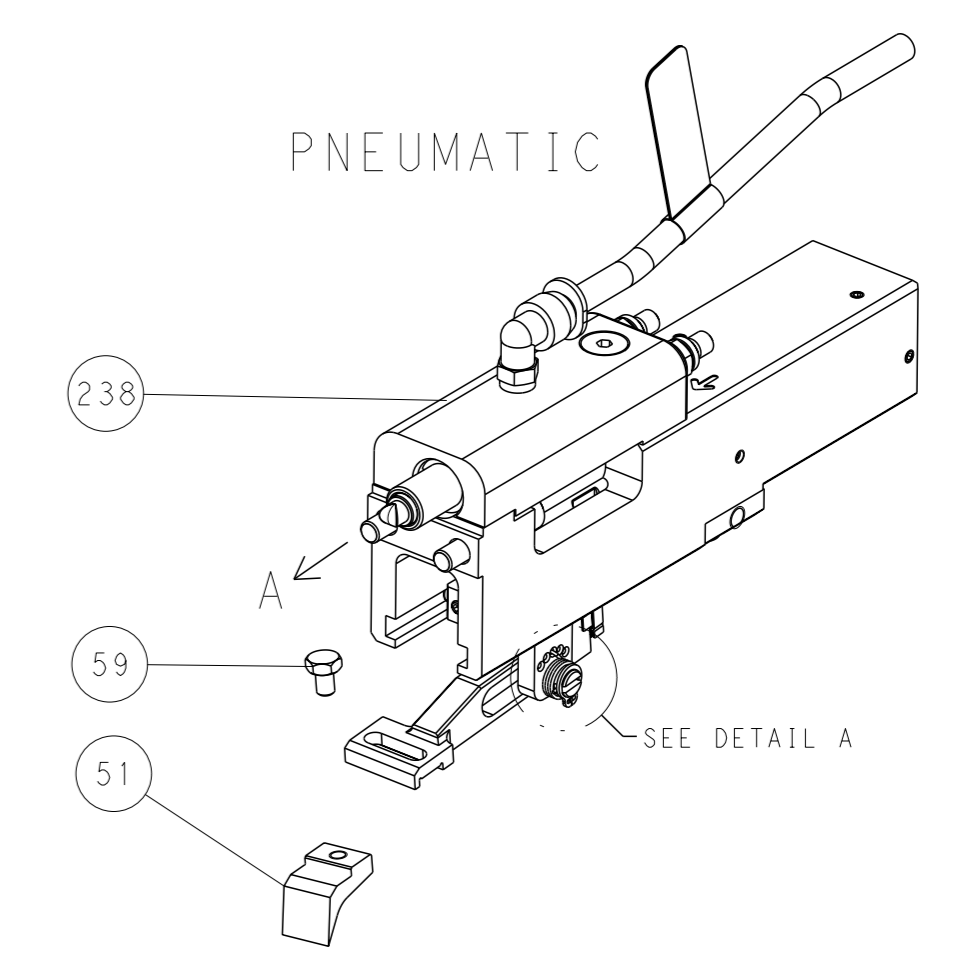
Customer Accessible Production Drawing

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

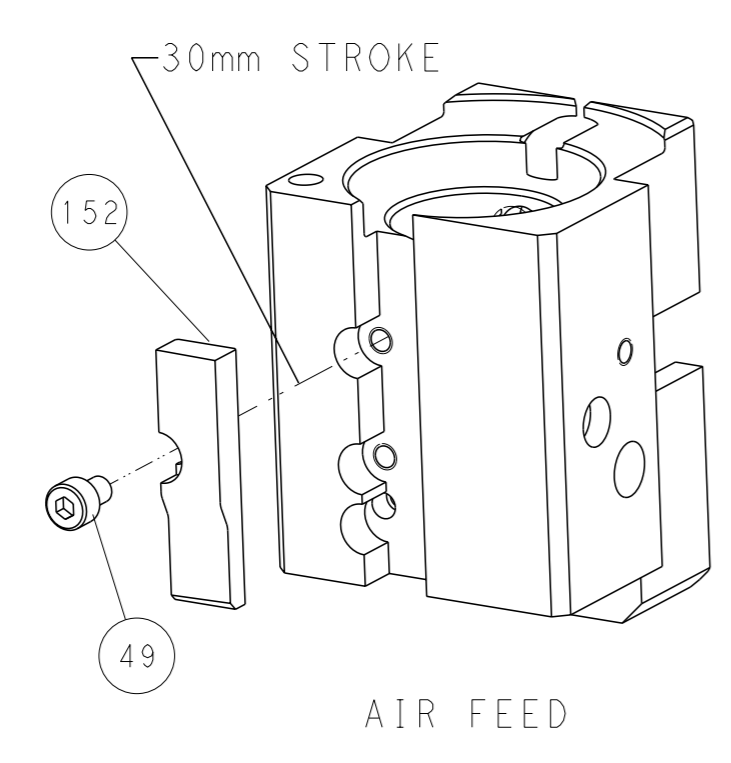


RAM AND HOLDDOWN SET-UP

FEED TYPE



CAM POSITION



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: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH ±		OWN X_ZHAO 10OCT2013 CHK T_ELFIN 10OCT2013 APVD L_ZHANG 10OCT2013 PRODUCT SPEC APPLICATION SPEC WEIGHT Customer Accessible Production Drawing		NAME Ocean End Feed Applicator SIZE CAGE CODE DRAWING NO A1 00779 C=2150374 SCALE 1:1 SHEET 4 OF 4 REV H		RESTRICTED TO	
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