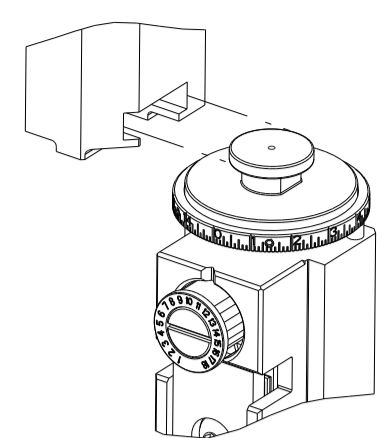


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150544-2	E	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150544-2	E	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150544-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER

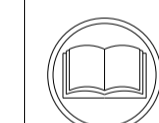


APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	3.56 mm [.140]	F
INSUL	4.32 mm [.170]	F
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: RECEPTACLE, CLUSTER PIN, AMPLIVAR			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
3.58-4.34 mm [.141-.171 IN]		∅2.29-4.32 mm [.090-.170 IN]	
TERMINAL APPLICATION SPECIFICATION	114-2019	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
63455-1			

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: RECEPTACLE, CLUSTER PIN, AMPLIVAR			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
3.58-4.34 mm [.141-.171 IN]		∅ 3.81 mm [.150 IN] MAX	
TERMINAL APPLICATION SPECIFICATION	114-2019	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
1217173-1	1217173-3		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
7600-8500 CMA	2.36 +/- 0.05 [.093 +/- .002]	5.6
4000-4800 CMA	1.98 +/- 0.05 [.078 +/- .002]	9.3



- RECOMMENDED SPARE PARTS
 - REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
 - APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 180. 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.
 - TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
 - TERMINAL LUBRICANT IS RECOMMENDED.
7. 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.

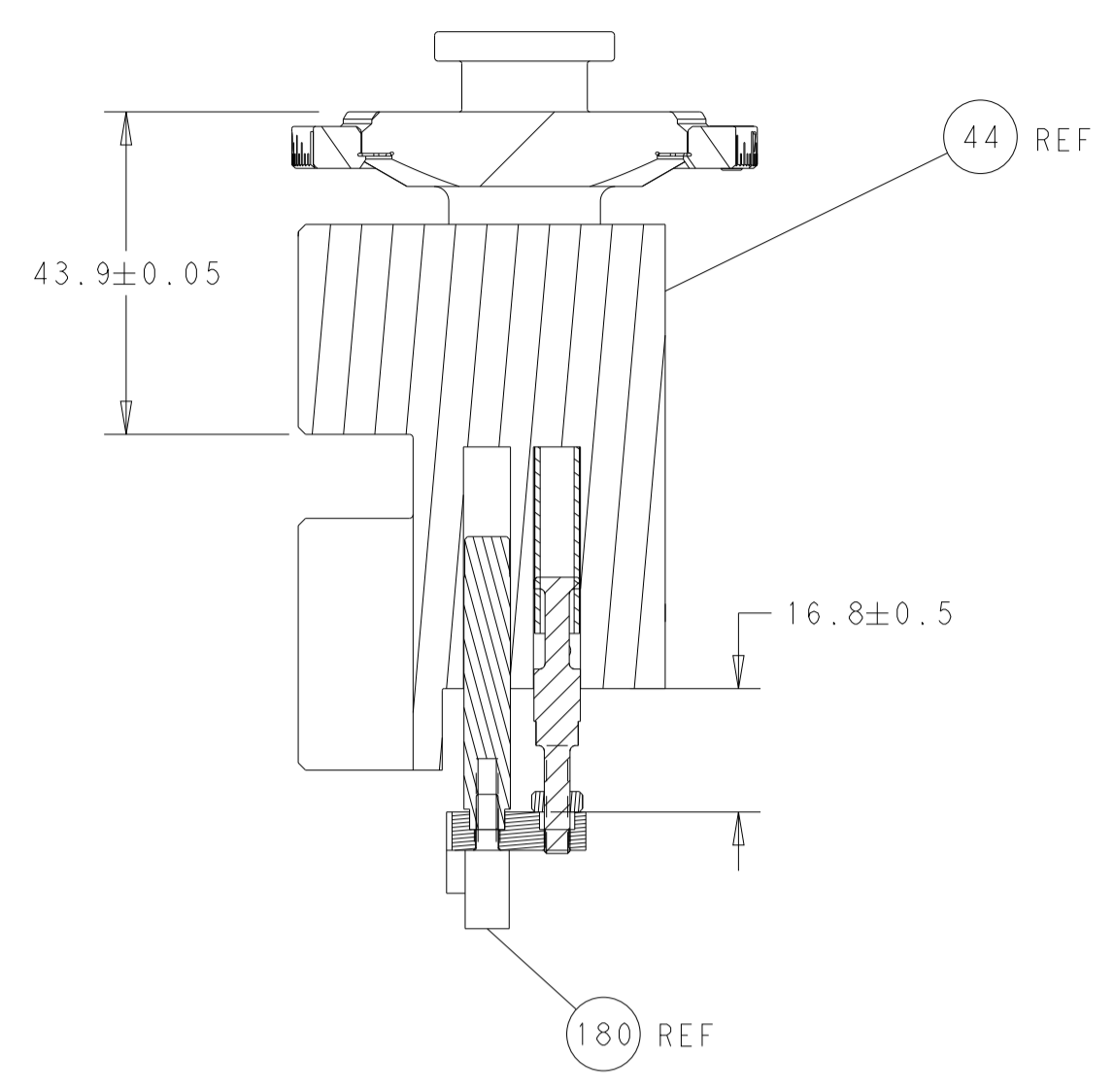
LOC	DIST	REVISIONS					
		P	LTN	DESCRIPTION	DATE	OWN	APVD
A	66	B		ECR-17-001231	27JAN2017	RK	TE
		C		ECR-18-016809	24OCT2018	MZ	KZ
		D		ECR-18-019120	10DEC2018	KH	LZ
		E		ECR-23-181941	21JUL2023	FZ	TE

-	1	1	2119641-1	FEED CAM, AIR FEED	248		
-	1	1	2119082-4	CAM, SNAIL, INSULATION ADJUSTMENT	244		
-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243		
	-	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	2-1752354-7	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	2119955-2	ASSY, LUBRICATOR, END FEED	84		
-	1	1	455888-5	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	1901681-1	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	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	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	1	2063961-9	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	2079383-5	SCR, BHSC, RoHS (M4 X 20)	31		
-	2	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	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	1901259-7	GUIDE, LOWER STRIP	18		
-	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17		
	-	1	1752360-1	SPACER, HOLD-DOWN	13		
	-	1	240644-1	PLATE, REAR SHEAR	11		
	-	1	690482-5	PLATE, FRONT SHEAR	9		
	1	2	1	1803064-8	ANVIL, COMBINATION	8	
-	1	1	4-690474-2	BLADE, SLUG	7		
-	1	1	8-240641-8	SPACER	5		
-	1	1	238011-2	BLOCK, CRIMPER SPACER	4		
	1	2	1	7-1633961-5	CRIMPER, INSULATION F PREMIUM	3	
-	1	1	455888-5	SPACER, CRIMPER	2		
	1	2	1	462808-7	CRIMPER, BLUNT F	1	
	-	77-72	-2	PART NO			
				DESCRIPTION			ITEM NO

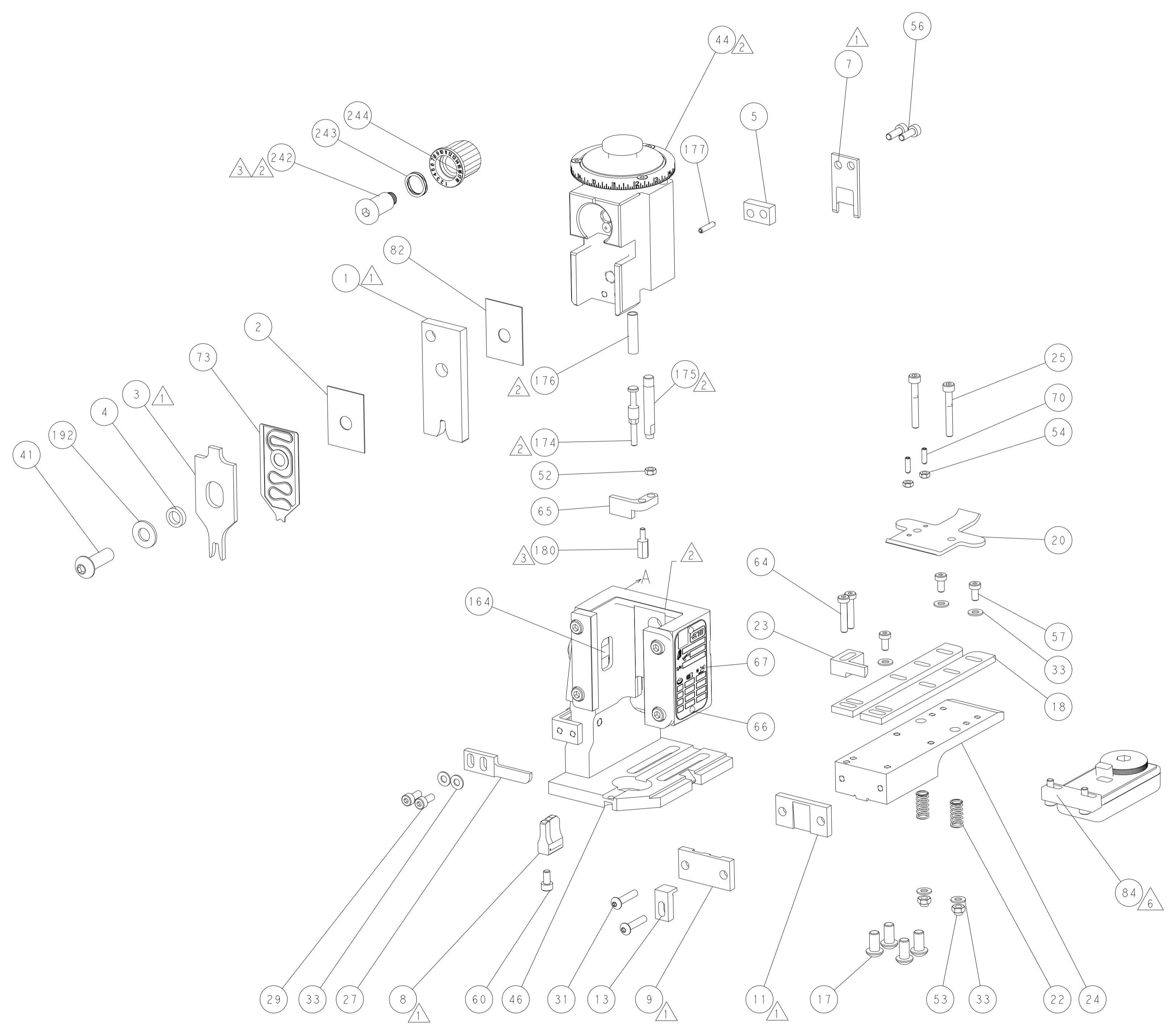
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		MATERIAL:		FINISH:		WEIGHT:		SCALE:		SHEET:		REV:	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES	FINISH								
APVD: G. BAILEY		APVD: T. ELBIN		APVD: G. BAILEY		APVD: T. ELBIN		APVD: G. BAILEY		APVD: T. ELBIN		APVD: G. BAILEY		APVD: T. ELBIN	
DATE: 04 APRIL 2015		DATE: 04 APRIL 2015		DATE: 04 APRIL 2015		DATE: 04 APRIL 2015		DATE: 04 APRIL 2015		DATE: 04 APRIL 2015		DATE: 04 APRIL 2015		DATE: 04 APRIL 2015	
NAME: G. BAILEY		NAME: T. ELBIN		NAME: G. BAILEY		NAME: T. ELBIN		NAME: G. BAILEY		NAME: T. ELBIN		NAME: G. BAILEY		NAME: T. ELBIN	
PRODUCT SPEC: -		PRODUCT SPEC: -		PRODUCT SPEC: -		PRODUCT SPEC: -		PRODUCT SPEC: -		PRODUCT SPEC: -		PRODUCT SPEC: -		PRODUCT SPEC: -	
APPLICATION SPEC: -		APPLICATION SPEC: -		APPLICATION SPEC: -		APPLICATION SPEC: -		APPLICATION SPEC: -		APPLICATION SPEC: -		APPLICATION SPEC: -		APPLICATION SPEC: -	
SIZE: A1		CAGE CODE: 00779		DRAWING NO: 2150544		RESTRICTED TO: -		SCALE: 1:1		SHEET: 1 of 4		REV: E		Customer Accessible Production Drawing	

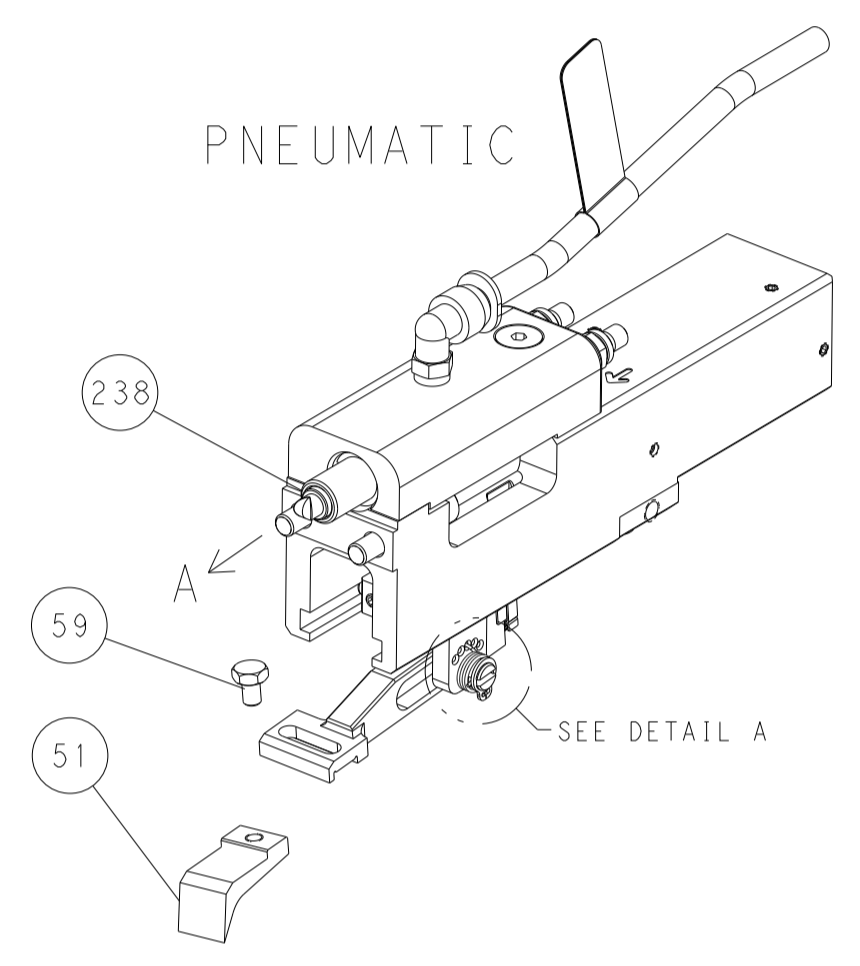
LOC	DIST	REVISIONS			
P	LTN	DESCRIPTION	DATE	OWN	APVD
A	66	SEE SHEET 1	-	-	-



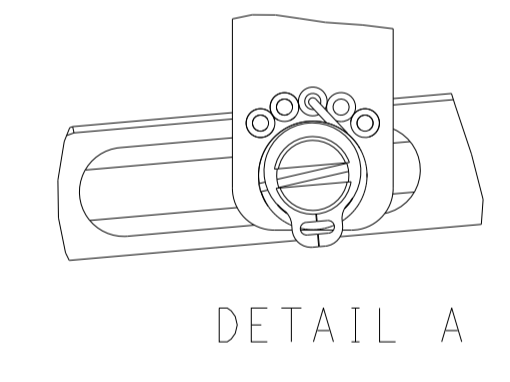
RAM AND HOLDDOWN SET-UP



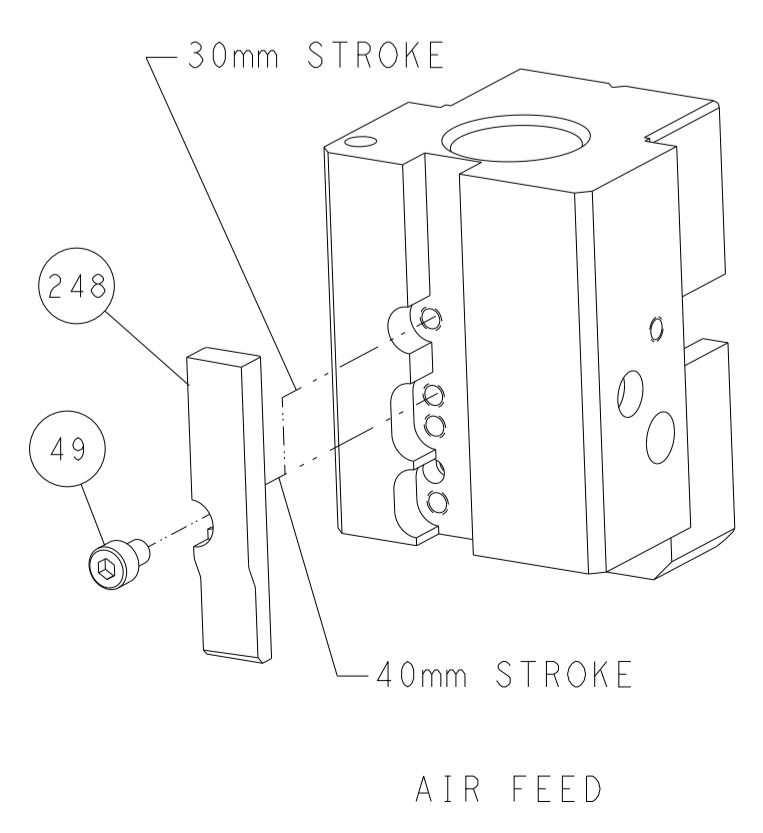
FEED TYPE



FEED SPRING SETTING POSITION



CAM POSITION

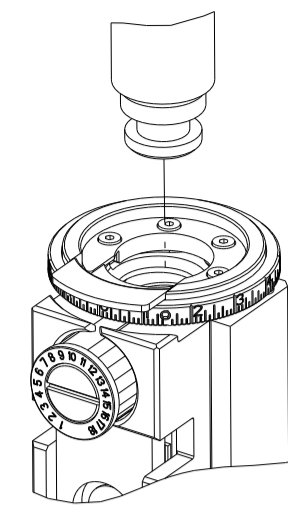


ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

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DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± MATERIAL: - FINISH: -	TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± MATERIAL: - FINISH: -	WEIGHT: - SCALE: 1:1 SHEET: 2 OF 4 REV: E	CUSTOMER ACCESSIBLE PRODUCTION DRAWING	SCALE: 1:1 SHEET: 2 OF 4 REV: E	RESTRICTED TO: E	RESTRICTED TO: E

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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150544-2	E	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150544-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER

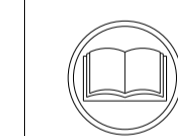


APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	3.56 mm [.140]	F
INSUL	4.32 mm [.170]	F
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: RECEPTACLE, CLUSTER PIN, AMPLIVAR			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
3.58-4.34 mm [.141-.171 IN]		∅ 2.29-4.32 mm [.090-.170 IN]	
TERMINAL APPLICATION SPECIFICATION	114-2019	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
63455-1			

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: RECEPTACLE, CLUSTER PIN, AMPLIVAR			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
3.58-4.34 mm [.141-.171 IN]		∅ 3.81 mm [.150 IN] MAX	
TERMINAL APPLICATION SPECIFICATION	114-2019	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
1217173-1	1217173-3		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
7600-8500 CMA	2.36 +/- 0.05 [.093 +/- .002]	5.6
4000-4800 CMA	1.98 +/- 0.05 [.078 +/- .002]	9.3



- RECOMMENDED SPARE PARTS
- REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 180. 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.
- TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- TERMINAL LUBRICANT IS RECOMMENDED.
- 7. 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.

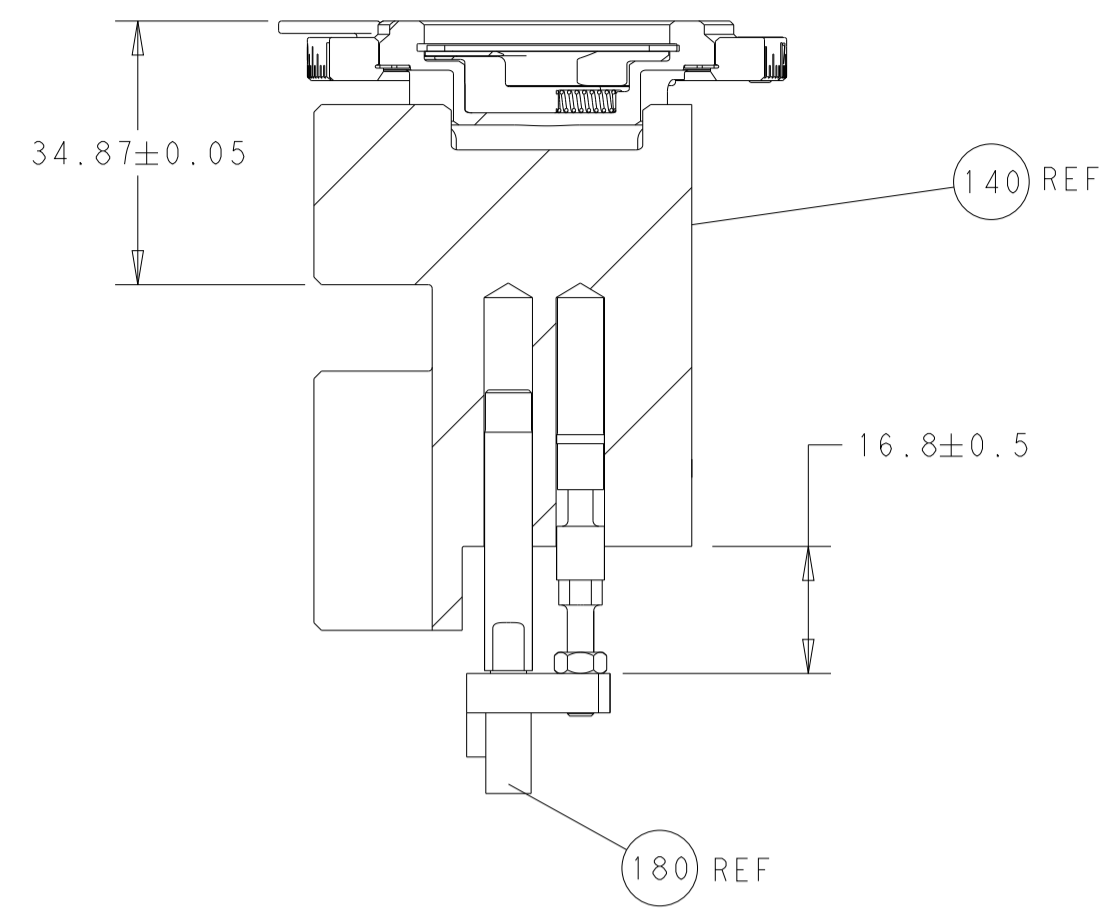
LOC	DIST	REVISIONS					
A	66	P	LTN	DESCRIPTION	DATE	DWN	APVD
		-		SEE SHEET 1	-	-	-

	-	1	2119082-4	CAM, SNAIL, INSULATION ADJUSTMENT	244
	-	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
	-	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
	-	1	2-1752354-7	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, HOLD-DOWN	175
	-	1	1901680-2	GUIDE PIN, HOLD-DOWN	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
	-	1	2119955-2	ASSY, LUBRICATOR, END FEED	84
	-	1	455888-5	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	1901681-1	HOLD-DOWN, 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	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	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	2063961-9	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	2079383-5	SCR, BHSC, RoHS (M4 X 20)	31
	-	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	29
	-	1	240639-1	STRIPPER (MACHINING)	27
	-	2	1-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 30	25
	-	1	1752371-5	PLATE, STRIP GUIDE	24
	-	1	240825-1	PLATE, STRIP HOLD DOWN	23
	-	2	2-22281-3	SPRING, COMPRESSION	22
	-	1	1803292-4	DRAG	20
	-	2	1901259-7	GUIDE, LOWER STRIP	18
	-	1	1752360-1	SPACER, HOLD-DOWN	13
	-	1	240644-1	PLATE, REAR SHEAR	11
	-	1	690482-5	PLATE, FRONT SHEAR	9
	1	1	1803064-8	ANVIL, COMBINATION	8
	-	1	4-690474-2	BLADE, SLUG	7
	-	1	8-240641-8	SPACER	5
	-	1	238011-2	BLOCK, CRIMPER SPACER	4
	1	1	7-1633961-5	CRIMPER, INSULATION F PREMIUM	3
	-	1	455888-5	SPACER, CRIMPER	2
	1	1	462808-7	CRIMPER, BLUNT F	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)

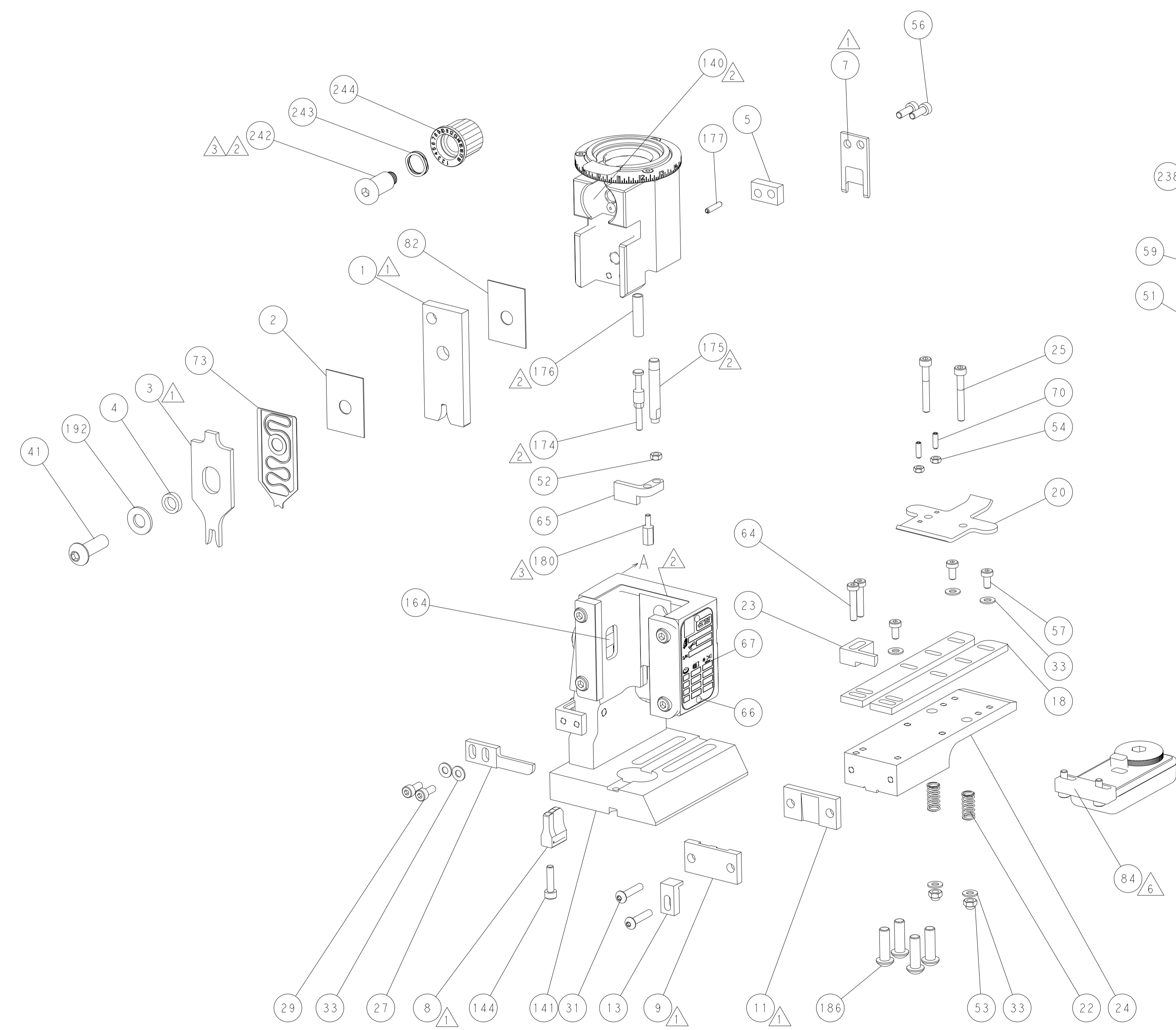
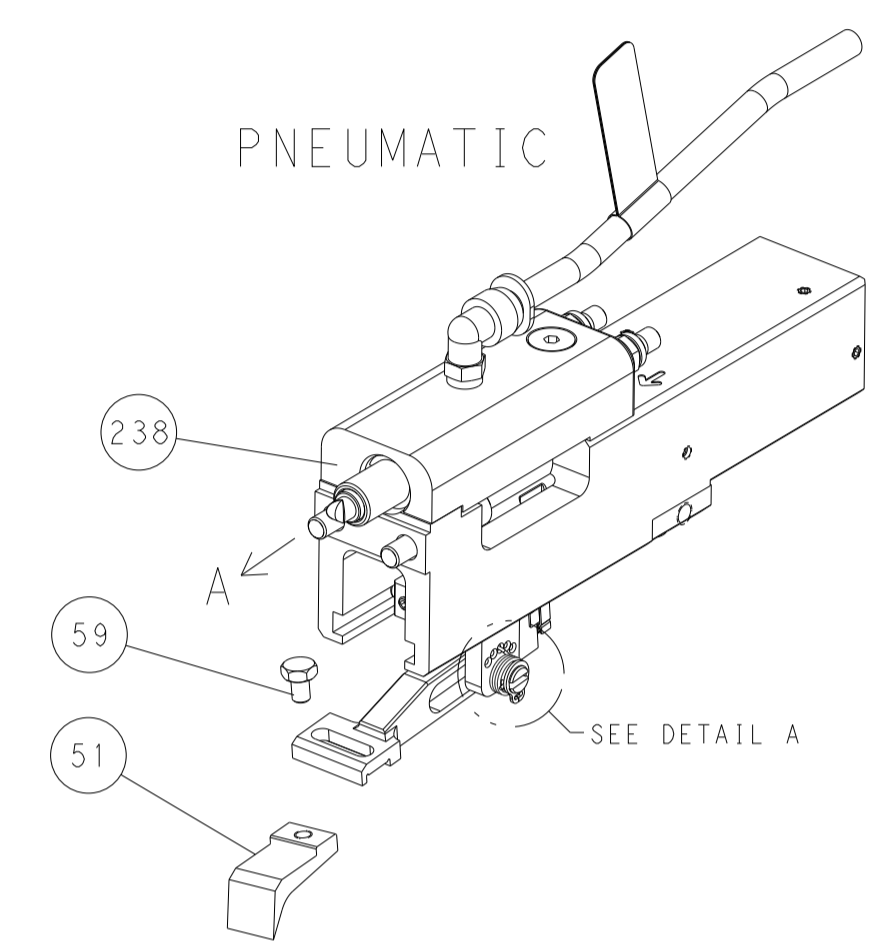
THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION. ALL RIGHTS RESERVED.		OWN: STAKEM	DATE: 04/12/2015
DIMENSIONS: mm		CHK: G. BAILEY	DATE: 04/12/2015
TOLERANCES UNLESS OTHERWISE SPECIFIED:		APVD: T. ELBIN	DATE: 04/12/2015
0 PLC	±	NAME: Ocean End Feed Applicator	
1 PLC	±	SIZE: A1	
2 PLC	±	CAGE CODE: 00779	
3 PLC	±	DRAWING NO: 2150544	
4 PLC	±	SCALE: 1:1	
ANGLES	±	SHEET: 3 OF 4	
FINISH	±	REV: E	
MATERIAL:		Customer Accessible Production Drawing	

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

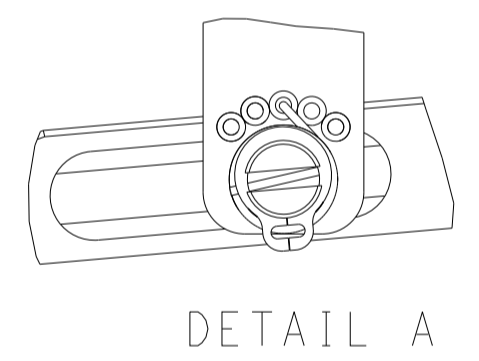


RAM AND HOLDDOWN SET-UP

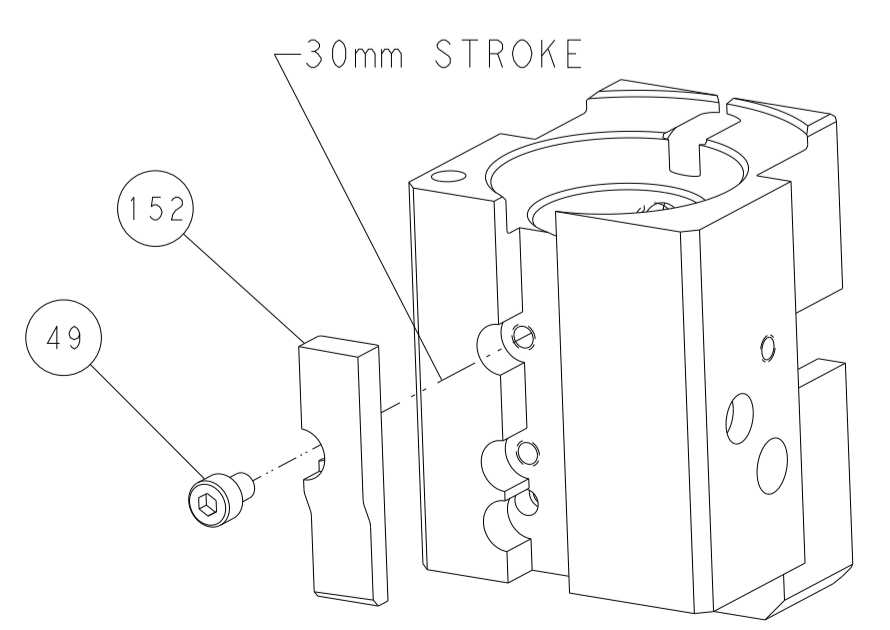
FEED TYPE



FEED SPRING SETTING POSITION



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)

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DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH ±	WEIGHT: - SCALE: 1:1	SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2150544	SHEET: 4 OF: 4 REV: E	RESTRICTED TO: -