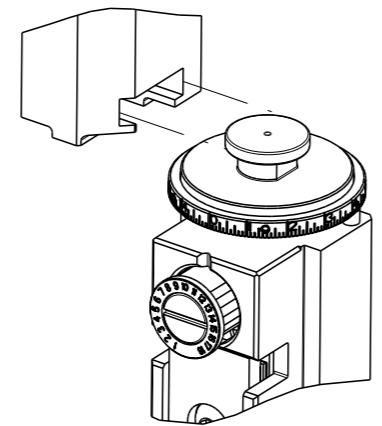


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150607-2	E	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150607-2	E	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150607-7	A	CRIMP TOOLING KIT	-

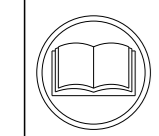
ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.78 mm [.070]	F
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: .110 SERIES FASTON FLAG			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
5.20-5.96 mm [.205-.235 IN]		∅2.20-3.00 mm [.087-.118 IN]	
TERMINAL APPLICATION SPECIFICATION	114-2028	-	-
TERMINALS APPLIED $\triangle 3/5$			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
62321-1	63990-1	61549-1	

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
16 AWG	1.37 +/- 0.05 [.054 +/- .002]	4.4
18 AWG	1.19 +/- 0.05 [.047 +/- .002]	6.3
20 AWG	1.04 +/- 0.05 [.041 +/- .002]	7.7
22 AWG	0.97 +/- 0.05 [.038 +/- .002]	8.6



- 1. RECOMMENDED SPARE PARTS
- 2. REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- 3. TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- 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. TERMINAL LUBRICANT IS RECOMMENDED.
- 6. 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.

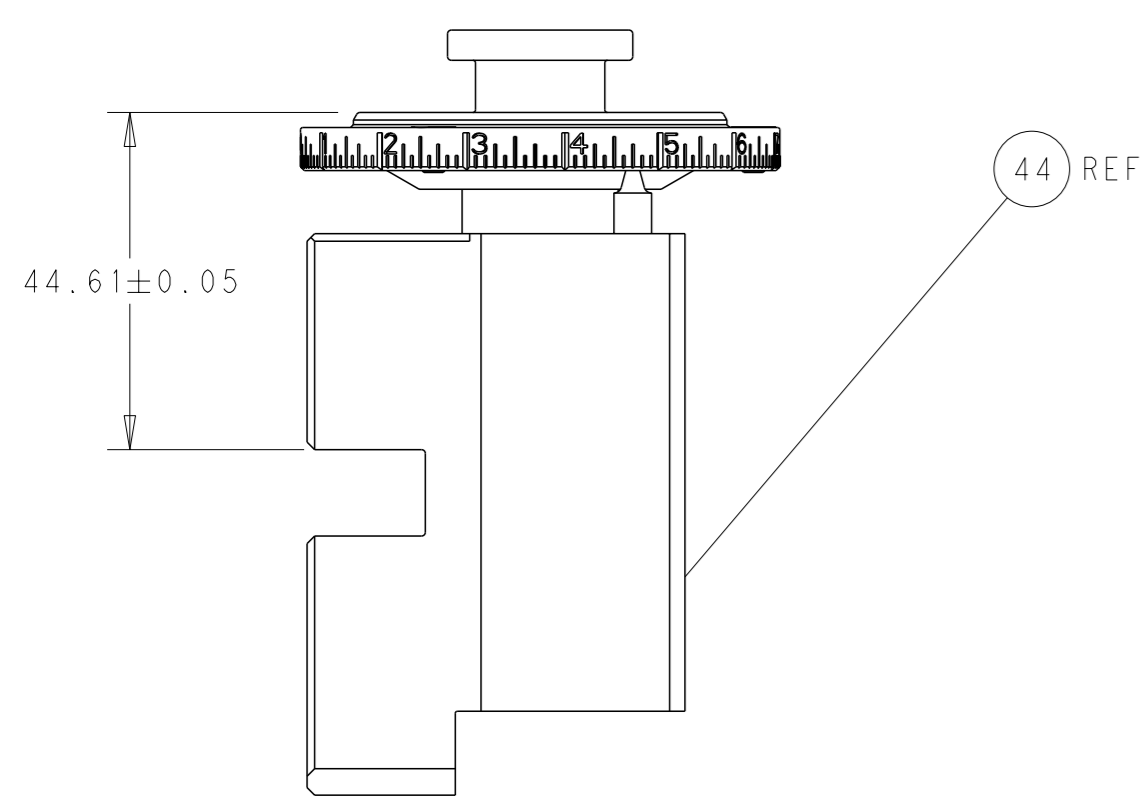
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		REV	DATE	BY	CHKD
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		C	20MAR2021	TB	RK
		D	15APR2021	FZ	RK
		E	12NOV2021	FJ	TE

-	1	1	2119641-1	FEED CAM, AIR FEED	248	
-	1	1	2844940-3	AIR FEED MODULE	238	
-	REF	REF	994970-2	COUNTER, MAGNETIC	164	
$\triangle 5$	-	1	1	2119955-2	ASSY, LUBRICATOR, END FEED	84
	-	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	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
	-	5	5	2168400-1	SHCS, LOW HEAD, RoHS, M4 X 12	57
	-	2	2	1-2168083-4	SCR, SKT HD CAP, RoHS, M4 X 5	56
	-	2	2	5018030-1	NUT, HEX, REG, RoHS, M3	54
	-	2	2	986965-8	NUT, LOCK, HEX, TORQUE (M4)	53
	-	1	1	2063961-2	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
	-	1	1	683385-1	SPACER, STRIP HOLD PLATE	32
	-	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	690455-2	STRIPPER, FRONT CASTING	27
	-	2	2	1-2168083-6	SCR, SKT HD CAP, RoHS, M4 X 35	25
	-	1	1	1752371-5	PLATE, STRIP GUIDE	24
	-	1	1	457144-1	PLATE, STRIP HOLD	23
	-	2	2	22281-9	SPRING, COMPRESSION	22
	-	1	1	1803292-4	DRAG	20
	-	1	1	1803086-5	GUIDE, REAR STRIP	19
	-	1	1	1803100-2	GUIDE, FRONT STRIP	18
$\triangle 1$	-	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17
$\triangle 1$	-	1	1	240644-1	PLATE, REAR SHEAR	11
$\triangle 1$	-	2	2	1-240645-0	SPACER, SHEAR PLATE	10
$\triangle 1$	-	1	1	240642-5	PLATE, FRONT SHEAR	9
$\triangle 1$	1	2	1	1-1803002-3	ANVIL, COMBINATION, END FEED	8
$\triangle 1$	-	1	1	240651-4	BLADE, SLUG	7
	-	-	-	-	-	6
	-	-	-	-	-	5
	-	-	-	-	-	4
	-	-	-	-	-	3
	-	-	-	-	-	2
$\triangle 1$	1	2	1	1-456404-1	CRIMPER, WIRE PREMIUM	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)

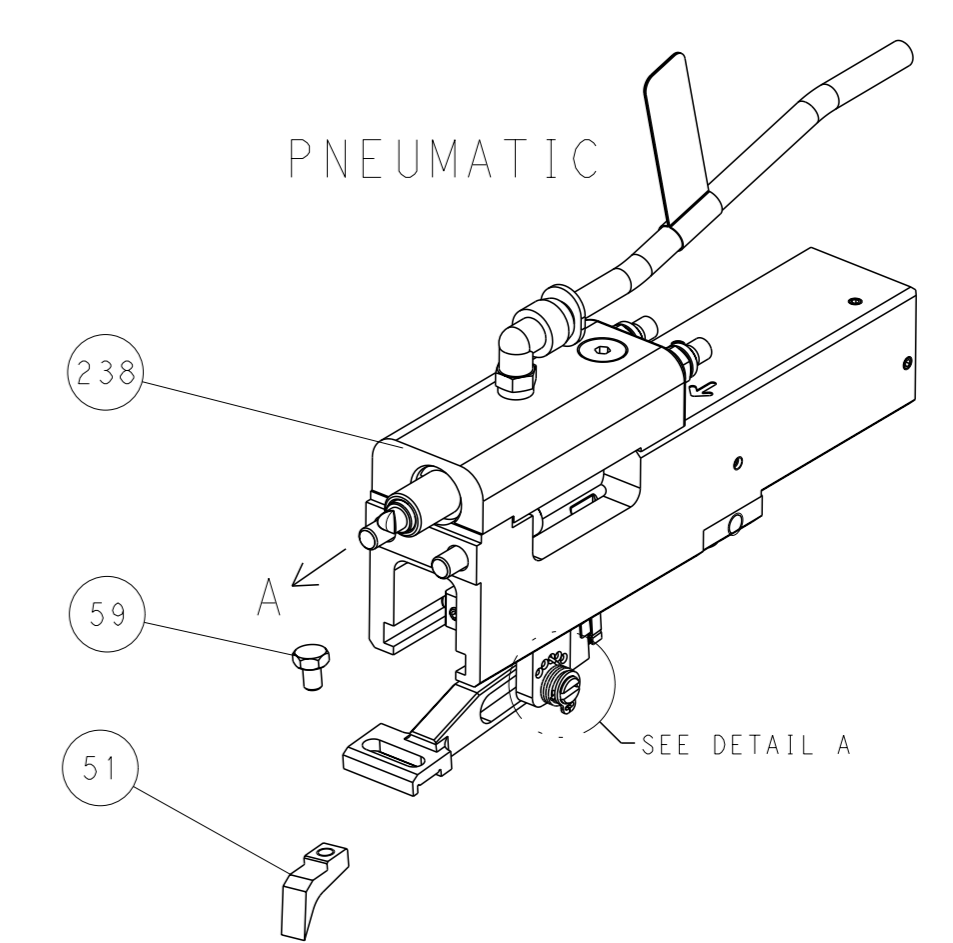
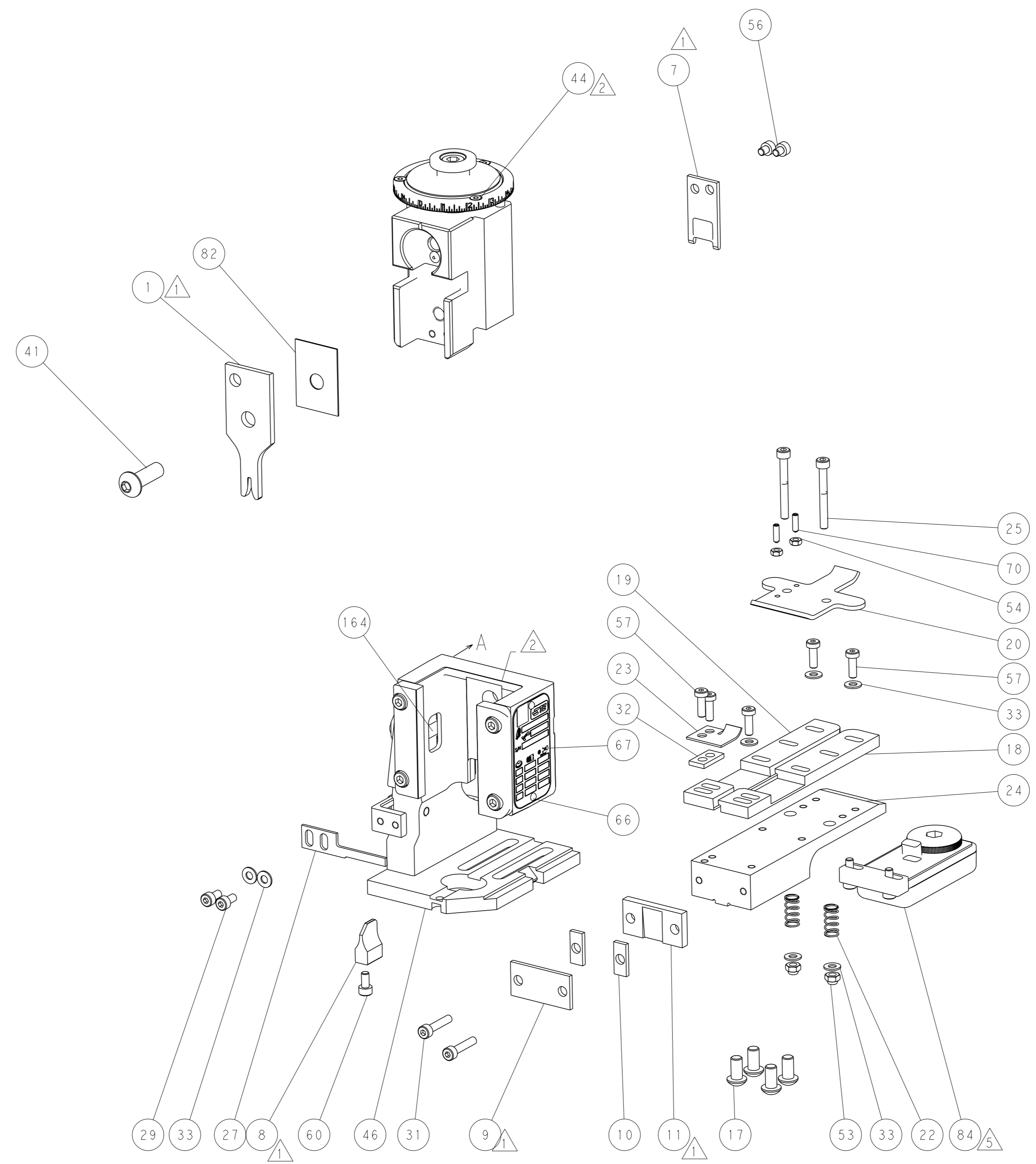
DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH ±		DWN B. WEAVER 28JUL2015 CHK G. BAILEY 28JUL2015 APVD G. BAILEY 28JUL2015 PRODUCT SPEC APPLICATION SPEC WEIGHT SCALE 1:1		NAME Ocean End Feed Applicator SIZE CAGE CODE DRAWING NO A1 00779 C=2150607 RESTRICTED TO REVISION	
MATERIAL:				Customer Accessible Production Drawing			

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

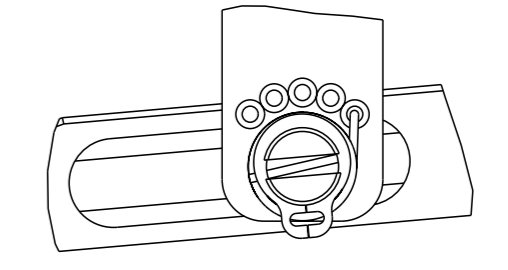


RAM SET-UP

FEED TYPE

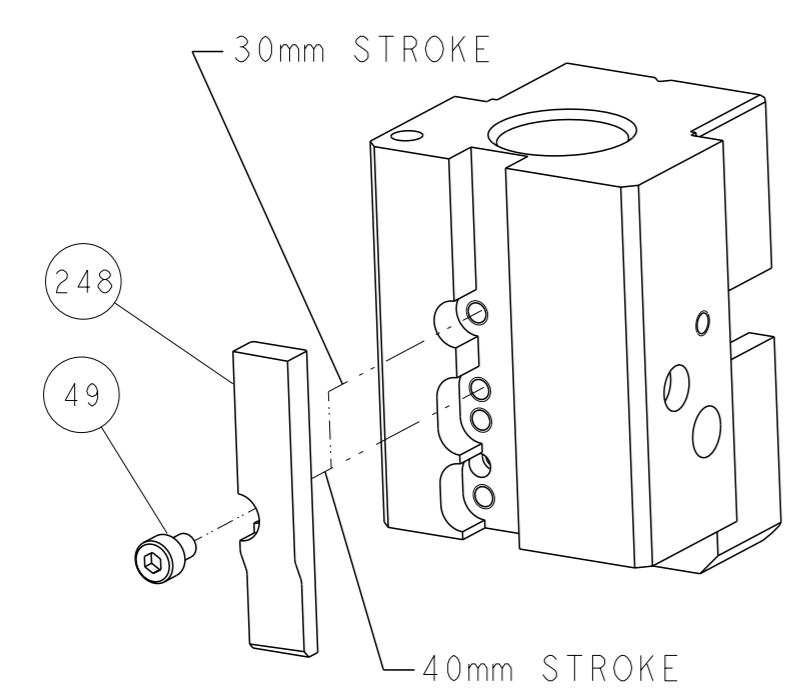


FEED SPRING SETTING POSITION



DETAIL A

CAM POSITION



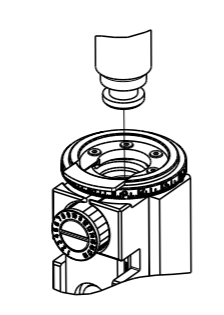
AIR FEED

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 USER MUST CONTACT THE DESIGNATION SHOULD BE CONTACTED FOR THE LATEST REVISION.</small>		OWN: B. WEAVER 28JUL2015 CHK: G. BAILEY 28JUL2015 APVD: G. BAILEY 28JUL2015	NAME: TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH *	APPLICATION SPEC PRODUCT SPEC	SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2150607	RESTRICTED TO: - SCALE: 1:1 SHEET: 2 of 4 REV: E
MATERIAL: - FINISH: -		WEIGHT: - Customer Accessible Production Drawing	SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150607-2	E	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150607-7	A	CRIMP TOOLING KIT	-

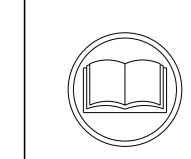
PACIFIC VERSION TERMINATOR  
 INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.78 mm [.070]	F
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: .110 SERIES FASTON FLAG			
WIRE STRIP LENGTH 5.20-5.96 mm [1.205-.235 IN]		INSULATION DIAMETER RANGE Ø2.20-3.00 mm [1.087-.118 IN]	
TERMINAL APPLICATION SPECIFICATION	114-2028	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
62321-1	63990-1	61549-1	

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
16 AWG	1.37+/-0.05 [1.054+/-0.002]	4.4
18 AWG	1.19+/-0.05 [1.047+/-0.002]	6.3
20 AWG	1.04+/-0.05 [1.041+/-0.002]	7.7
22 AWG	0.97+/-0.05 [1.038+/-0.002]	8.6



- 1 RECOMMENDED SPARE PARTS
- 2 REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- 3 TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- 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 TERMINAL LUBRICANT IS RECOMMENDED.
- 6 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.

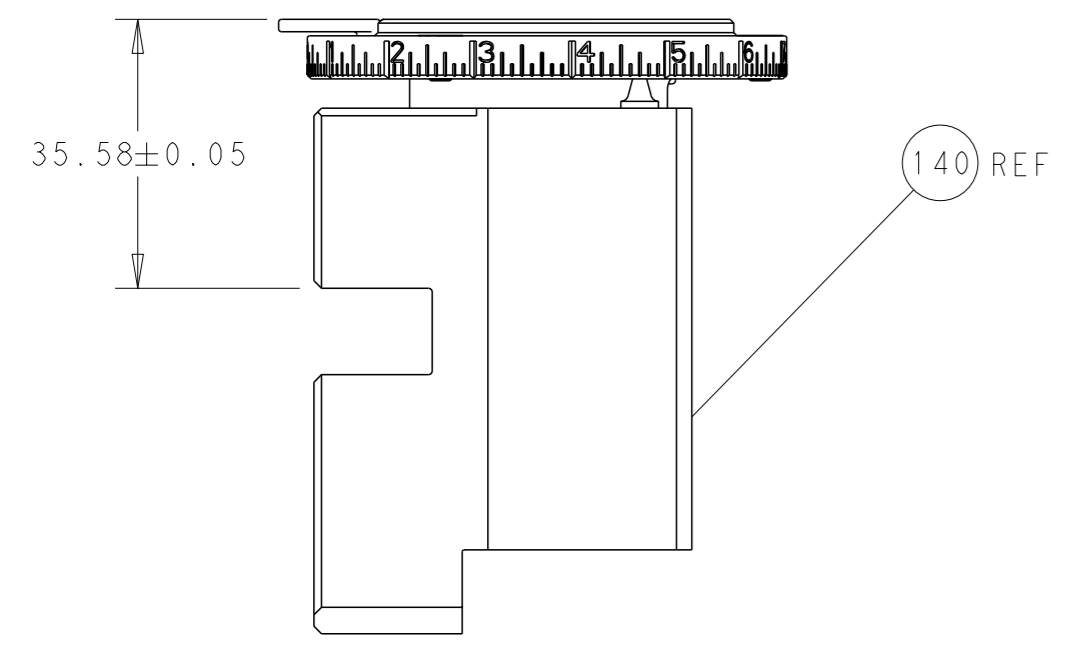
PACIFIC VERSION  
 Shown on sheets 3 of 4 & 4 of 4  
 (Atlantic version shown on sheets 1 of 4 & 2 of 4)

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

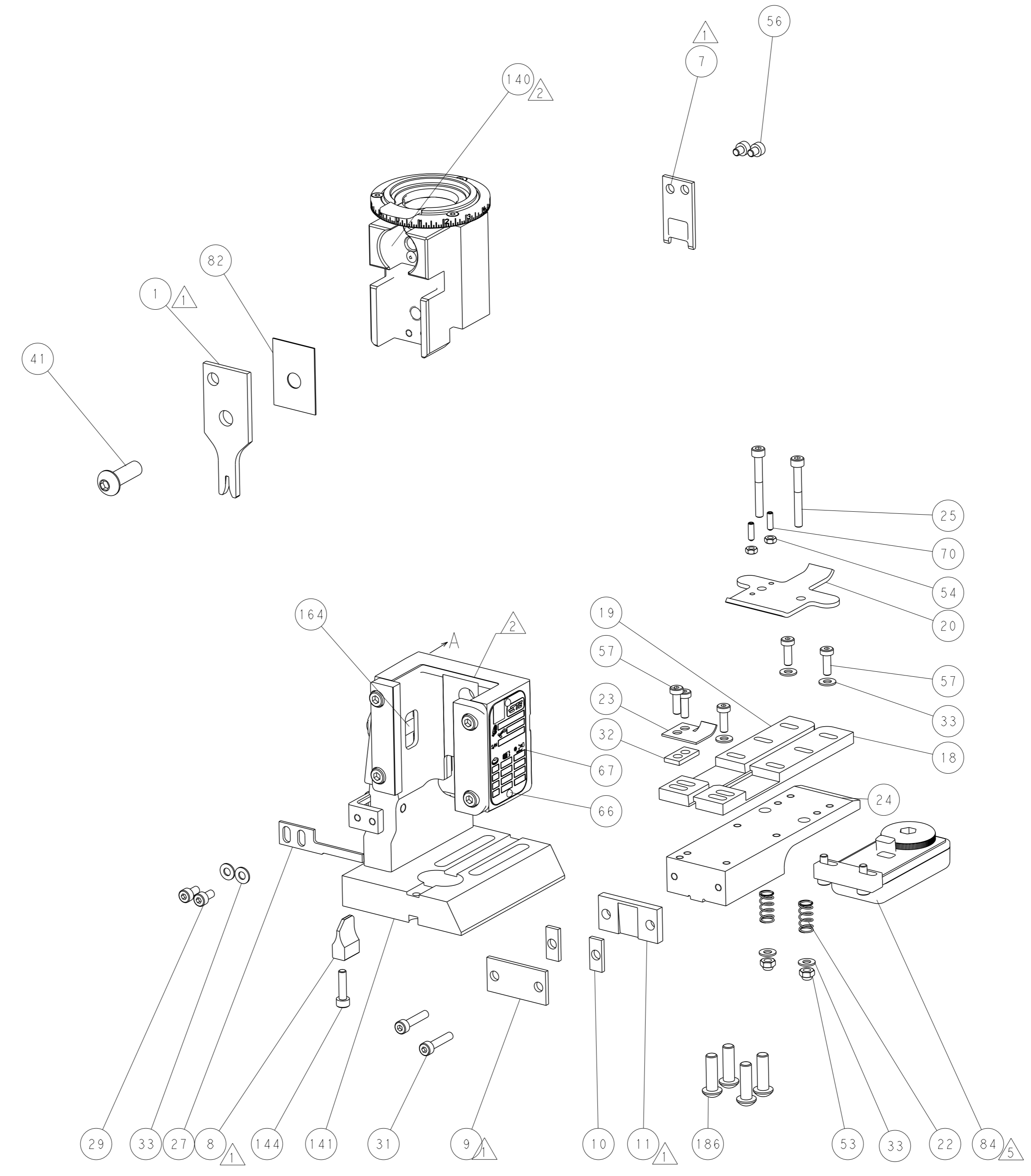
-	1	2844940-3	AIR FEED MODULE	238	
-	4	2079383-9	SCR, BHSC, RoHS (M6 X 20)	186	
-	REF	994970-2	COUNTER, MAGNETIC	164	
-	1	2119641-2	FEED CAM, AIR FEED	152	
-	1	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	144	
-	1	2119655-6	APPLICATOR BASIC ASSEMBLY, EF	141	
-	1	1803518-1	RAM ASSEMBLY, EF PACIFIC	140	
-	1	2119955-2	ASSY, LUBRICATOR, END FEED	84	
-	1	455888-5	SPACER, CRIMPER	82	
-	1	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	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59	
-	5	2168400-1	SHCS, LOW HEAD, RoHS, M4 X 12	57	
-	2	1-2168083-4	SCR, SKT HD CAP, RoHS, M4 X 5	56	
-	2	5018030-1	NUT, HEX, REG, RoHS, M3	54	
-	2	986965-8	NUT, LOCK, HEX, TORQUE (M4)	53	
-	1	2063961-2	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	
-	1	683385-1	SPACER, STRIP HOLD PLATE	32	
-	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	690455-2	STRIPPER, FRONT CASTING	27	
-	2	1-2168083-6	SCR, SKT HD CAP, RoHS, M4 X 35	25	
-	1	1752371-5	PLATE, STRIP GUIDE	24	
-	1	457144-1	PLATE, STRIP HOLD	23	
-	2	22281-9	SPRING, COMPRESSION	22	
-	1	1803292-4	DRAG	20	
-	1	1803086-5	GUIDE, REAR STRIP	19	
-	1	1803100-2	GUIDE, FRONT STRIP	18	
-	1	240644-1	PLATE, REAR SHEAR	11	
-	2	1-240645-0	SPACER, SHEAR PLATE	10	
-	1	240642-5	PLATE, FRONT SHEAR	9	
-	1	1-1803002-3	ANVIL, COMBINATION, END FEED	8	
-	1	240651-4	BLADE, SLUG	7	
-	-	-	-	6	
-	-	-	-	5	
-	-	-	-	4	
-	-	-	-	3	
-	-	-	-	2	
-	1	1-456404-1	CRIMPER, WIRE PREMIUM	1	
-	77	22	PART NO	DESCRIPTION	ITEM NO

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		APPROVED:		NAME:	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES ±	FINISH ±
MATERIAL		FINISH		WEIGHT		SCALE	
				A1 00779		C=2150607	
Customer Accessible Production Drawing				SCALE 1:1		SHEET 3 of 4	

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

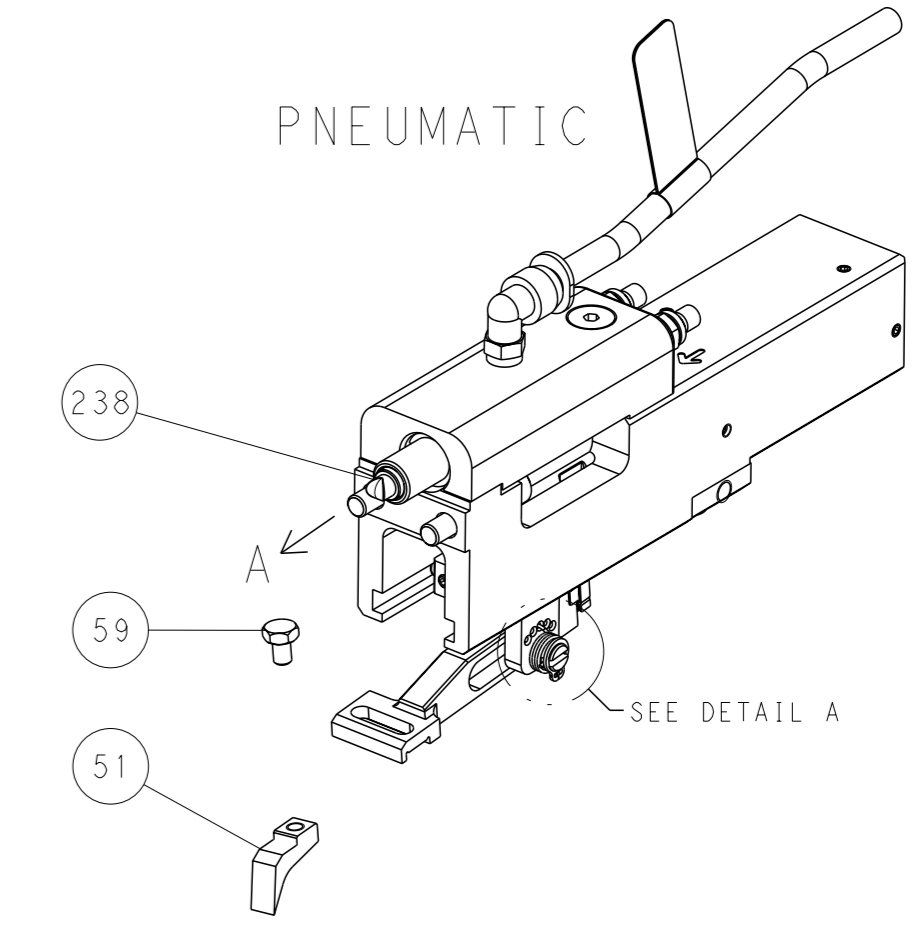


RAM SET-UP

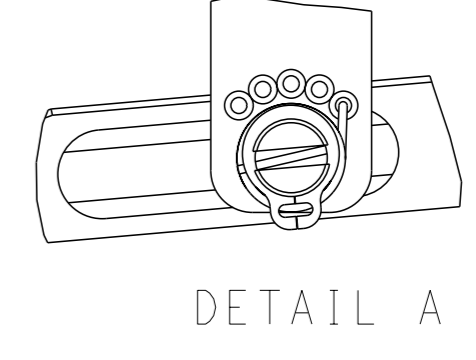


FEED TYPE

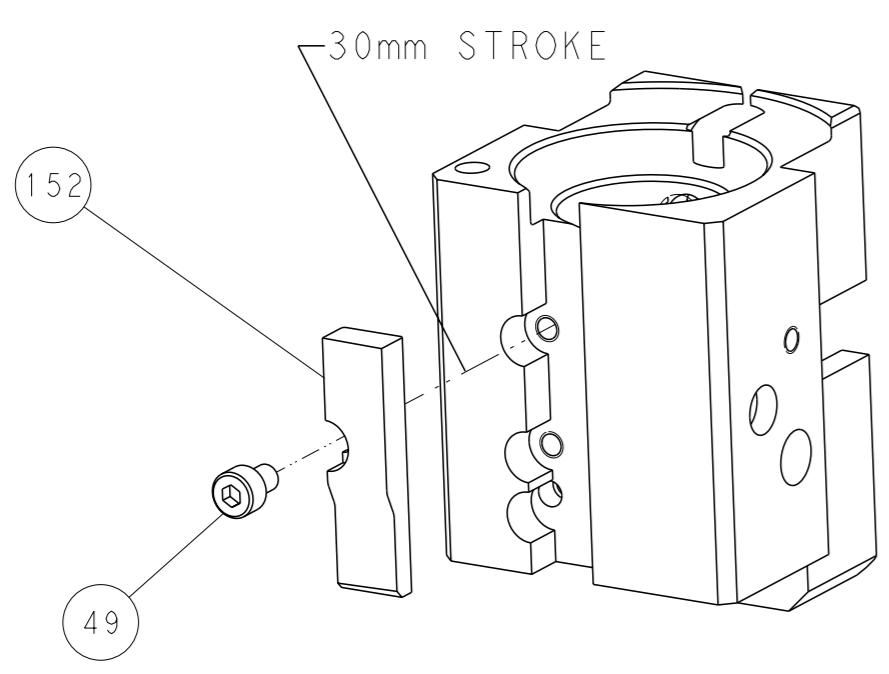
PNEUMATIC



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)

<small>THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE AND THE CONTROL AND INSISTING ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST REVISION.</small>		OWN: B. WEAVER 28 JUL 2015 CHK: G. BAILEY 28 JUL 2015 APVD: G. BAILEY 28 JUL 2015	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 APPLICATION SPEC: - WEIGHT: - SCALE: 1:1	SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2150607 SHEET 4 OF 4 REV E
MATERIAL: - FINISH: -		Customer Accessible Production Drawing	