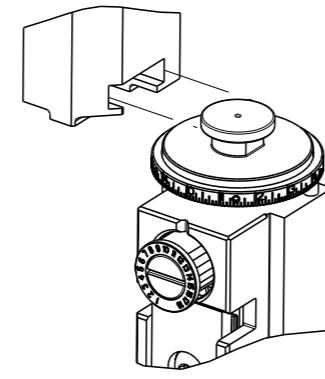


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150642-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150642-2	C	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150642-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



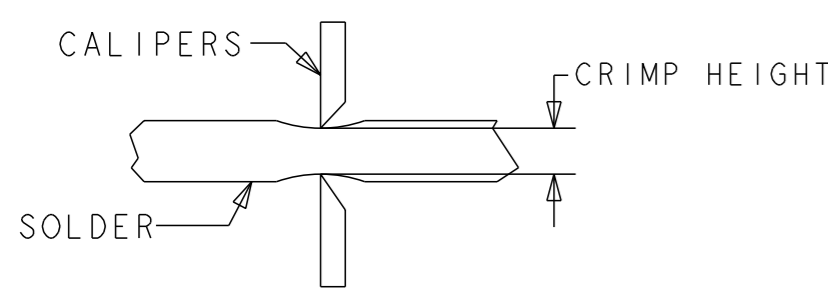
APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	6.02 mm [.237]	SP
APPL INSTRUCTIONS		
408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: RECEPTACLE, ULTRA-FAST FLAG, .250 SERIES			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
7.51-8.33 mm [.296-.328 IN]		Ø 4.70 mm MAX [.185 IN MAX]	
TERMINAL APPLICATION SPECIFICATION		114-2123	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
3-521013-2			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING	Ø SOLDER
14 AWG	1.90 +/- 0.05 [.075 +/- .002]	6.8	.187 IN [4.75mm]
16 AWG	1.78 +/- 0.05 [.070 +/- .002]	8.1	.187 IN [4.75mm]
(2) 18 AWG	1.78 +/- 0.05 [.070 +/- .002]	8.1	.187 IN [4.75mm]



- RECOMMENDED SPARE PARTS
- REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- 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.
- TO CHECK CRIMP HEIGHT, CRIMP SOLDER (Ø.187 IN [4.75mm] 60/40 SOLID CORE) AND MEASURE AT CENTER OF SLUG.



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.

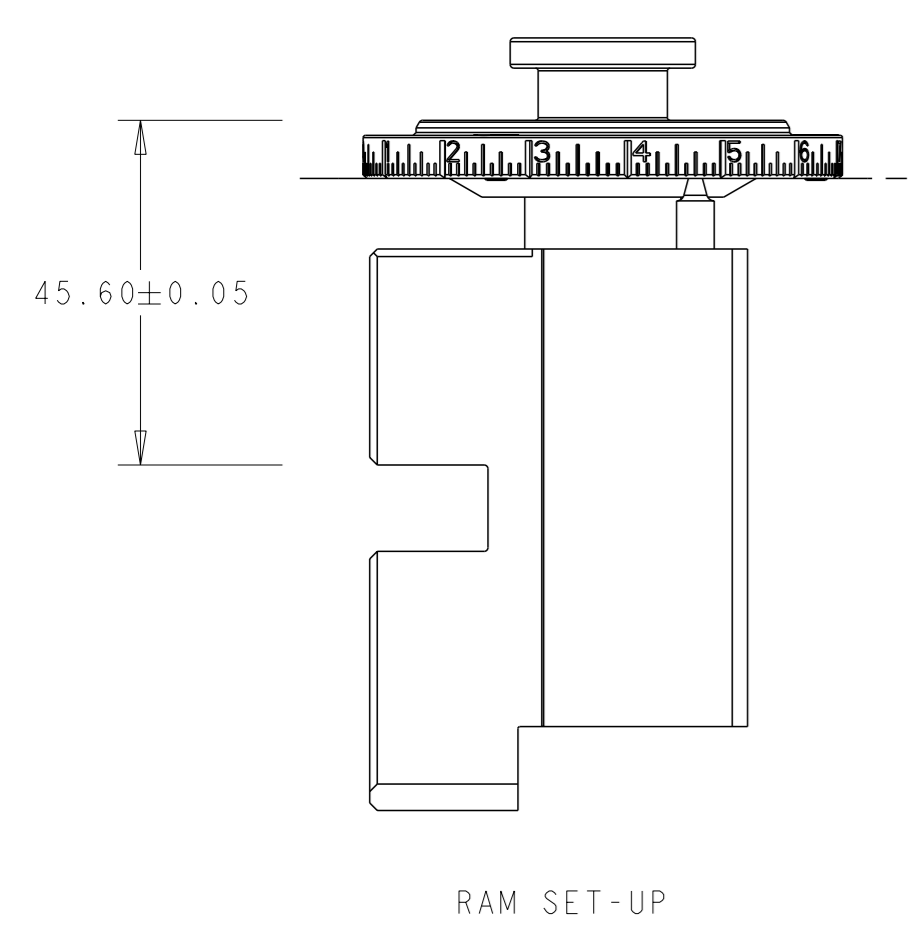
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		B		ECR-18-014348	16OCT2018	JAH	CT
		B1		ECR-18-016776	23OCT2018	JAH	TE
		C		ECR-19-008826	06JUN2019	LG	TE

-	1	1	2119641-1	FEED CAM, AIR FEED	248		
-	1	1	2844940-3	AIR FEED MODULE	238		
-	2	2	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	208		
-	1	1	467281-1	RETAINER, SHEAR, FLOATING	207		
-	1	1	2161936-1	HOLDER, SHEAR, FLOATING	206		
-	1	1	467500-1	SHEAR, FLOATING	205		
-	1	1	1-18028-0	WASHER, FLAT, REG M8	192		
-	REF	REF	994970-2	COUNTER, MAGNETIC	164		
-	1	1	2161937-2	STABILIZER	154		
-	1	1	455888-4	SPACER, CRIMPER	82		
-	1	1	1803607-4	DOCUMENTATION PACKAGE	71		
-	1	1	3-18032-3	SCR, SET, FLT PNT, M3 X 20.0	70		
-	1	1	2-18032-2	SCR, SET, FLT PNT, M3 X 10.0	69		
-	1	1	2119740-1	TAG, IDENTIFICATION	67		
-	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66		
-	1	1	2079383-4	SCR, BHSC, RoHS (M4 X 8)	60		
-	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59		
-	4	4	2168400-1	SHCS, LOW HEAD, RoHS, M4 X 12	57		
-	2	2	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	56		
-	2	2	5018030-1	NUT, HEX, REG, RoHS, M3	54		
-	2	2	986965-8	NUT, LOCK, HEX, TORQUE (M4)	53		
-	1	1	2352966-1	FEED FINGER	51		
-	1	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49		
-	1	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		
-	2	2	5-22278-1	SPRING, COMPRESSION	36		
-	8	8	1-18028-2	WASHER, FLAT, REG M4	33		
-	2	2	2079383-4	SCR, BHSC, RoHS (M4 X 8)	31		
-	2	2	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	29		
-	1	1	690455-3	STRIPPER, FRONT CASTING	27		
-	2	2	1-2168083-6	SCR, SKT HD CAP, RoHS, M4 X 35	25		
-	1	1	2161941-3	PLATE, GUIDE, STRIP	24		
-	2	2	2-22280-7	SPRING, COMPRESSION	22		
-	1	1	2161948-1	DRAG	20		
-	1	1	683736-4	GUIDE, STRIP, REAR	19		
-	1	1	683737-1	FRONT STRIP GUIDE	18		
-	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17		
-	1	1	4-22280-7	SPRING, COMPRESSION	13		
-	1	2	1	2161935-5	ANVIL, RIGHT HAND	8	
-	1	1	1	2161957-1	DEPRESSOR, SHEAR	5	
-	1	1	1	238011-2	BLOCK, CRIMPER SPACER	4	
-	1	1	1	2161331-1	SPACER, WIRE FUNNEL DEPRESSOR	2	
-	1	2	1	1	467342-2	CRIMPER, RIGHT HAND	1
-	77-72	-2		PART NO			
				DESCRIPTION			ITEM NO

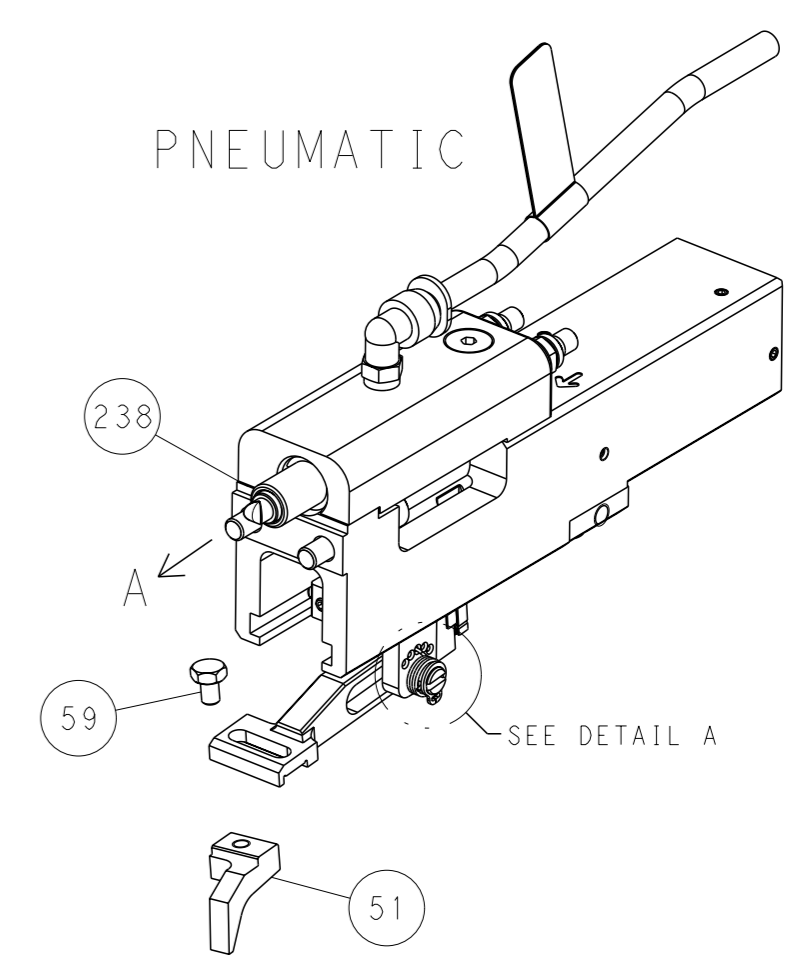
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		MATERIAL:	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±
	ANGLES	FINISH			
Customer Accessible Production Drawing		SCALE	1:1	SHEET	1 of 4

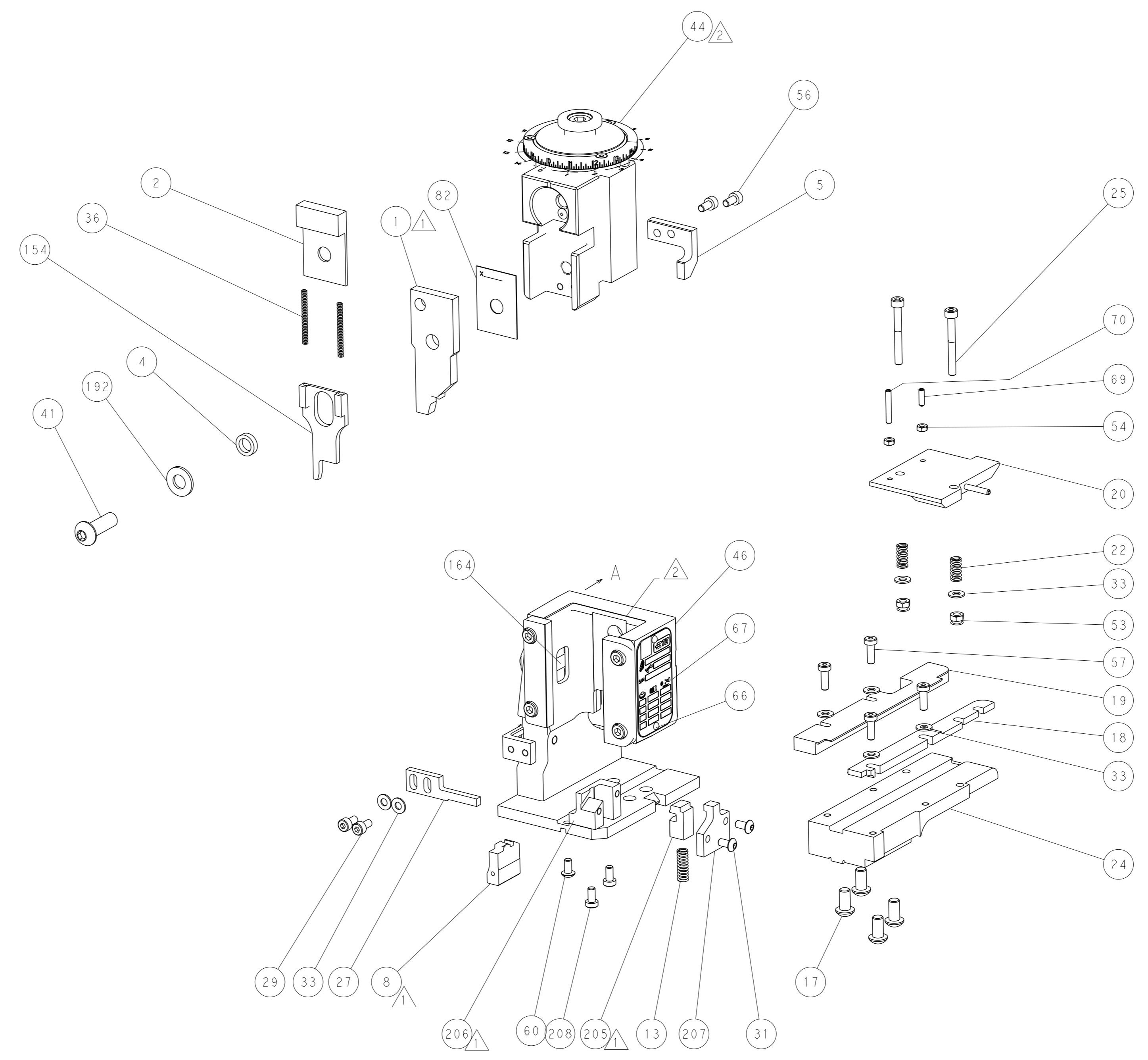
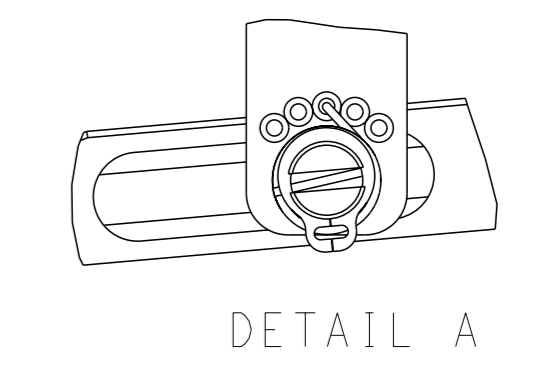
LOC	DIST	REVISIONS					
		P	LY#	DESCRIPTION	DATE	OWN	APVD
A	66	-	-	SEE SHEET 1	-	-	-



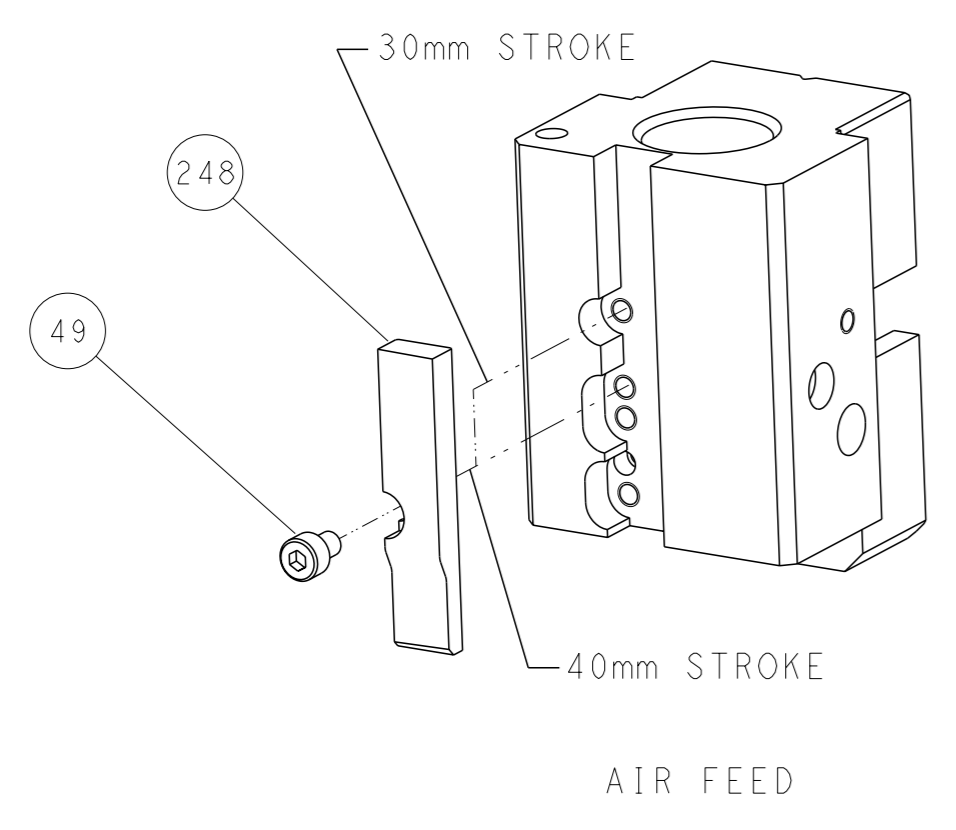
FEED TYPE



FEED SPRING SETTING POSITION



CAM POSITION

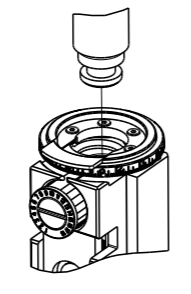


ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

<small>THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION 2016. IF SUBJECT TO CHANGE AND TO CONTROL THE EXTENT OF DISCRETION SHOULD BE CONTACTED FOR THE LATEST REVISION.</small>		OWN: B. WEAVER CHK: G. BAILEY APVD: G. BAILEY PRODUCT SPEC: - APPLICATION SPEC: - WEIGHT: - SCALE: 1:1	22JAN2016 22JAN2016 22JAN2016 NAME: Ocean End Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2150642 SHEET: 2 of 4 REV: C	TE Connectivity Harrisburg, PA 17105-3608
--	--	--	--	--

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150642-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150642-7	A	CRIMP TOOLING KIT	-

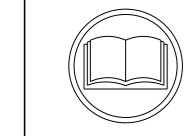
PACIFIC VERSION TERMINATOR
 INTERFACE ADAPTER



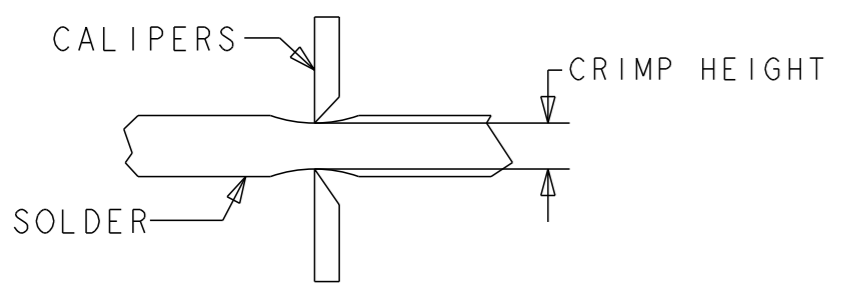
APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	6.02 mm [.237]	SP
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: RECEPTACLE, ULTRA-FAST FLAG, .250 SERIES			
WIRE STRIP LENGTH 7.51-8.33 mm [.296-.328 IN]		INSULATION DIAMETER RANGE ∅ 4.70 mm MAX [.185 IN MAX]	
TERMINAL APPLICATION SPECIFICATION	114-2123	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
3-521013-2			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING	∅ SOLDER
14 AWG	1.90+/-0.05 [.075+/-0.002]	6.8	.187 IN [4.75mm]
16 AWG	1.78+/-0.05 [.070+/-0.002]	8.1	.187 IN [4.75mm]
(2) 18 AWG	1.78+/-0.05 [.070+/-0.002]	8.1	.187 IN [4.75mm]



- 1 RECOMMENDED SPARE PARTS
- 2 REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- 3 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.
- 4 TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- 5 TO CHECK CRIMP HEIGHT, CRIMP SOLDER (∅.187 IN [4.75mm] 60/40 SOLID CORE) AND MEASURE AT CENTER OF SLUG.



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.

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

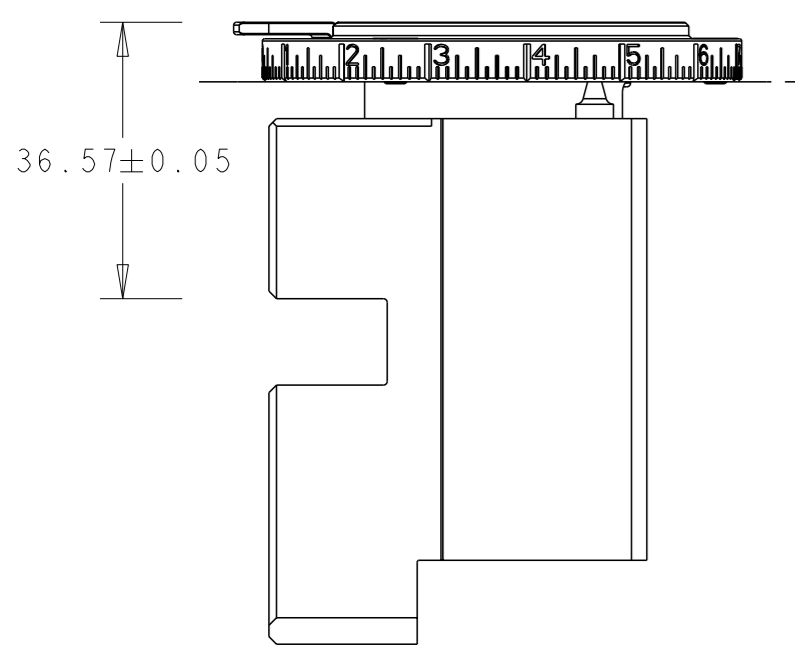
-	1	2844940-3	AIR FEED MODULE	238
-	2	2168400-5	SHCS, LOW HEAD, RoHS, M4 X 20	209
-	1	467281-1	RETAINER, SHEAR, FLOATING	207
-	1	2161936-1	HOLDER, SHEAR, FLOATING	206
-	1	467500-1	SHEAR, FLOATING	205
-	1	1-18028-0	WASHER, FLAT, REG M8	192
-	4	2079383-9	SCR, BHSC, RoHS (M6 X 20)	186
-	REF	994970-2	COUNTER, MAGNETIC	164
-	1	2161937-2	STABILIZER	154
-	1	2119641-2	FEED CAM, AIR FEED	152
-	1	2079383-8	SCR, BHSC, RoHS (M4 X 16)	144
-	1	1-2119655-6	APPLICATOR BASIC ASSEMBLY, EF	141
-	1	1803518-1	RAM ASSEMBLY, EF PACIFIC	140
-	1	455888-4	SPACER, CRIMPER	82
-	1	1803607-4	DOCUMENTATION PACKAGE	71
-	1	3-18032-3	SCR, SET, FLT PNT, M3 X 20.0	70
-	1	2-18032-2	SCR, SET, FLT PNT, M3 X 10.0	69
-	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
-	4	2168400-1	SHCS, LOW HEAD, RoHS, M4 X 12	57
-	2	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	56
-	2	5018030-1	NUT, HEX, REG, RoHS, M3	54
-	2	986965-8	NUT, LOCK, HEX, TORQUE (M4)	53
-	1	2352966-1	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
-	2	5-22278-1	SPRING, COMPRESSION	36
-	8	1-18028-2	WASHER, FLAT, REG M4	33
-	2	2079383-4	SCR, BHSC, RoHS (M4 X 8)	31
-	2	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	29
-	1	690455-3	STRIPPER, FRONT CASTING	27
-	2	1-2168083-6	SCR, SKT HD CAP, RoHS, M4 X 35	25
-	1	2161941-3	PLATE, GUIDE, STRIP	24
-	2	2-22280-7	SPRING, COMPRESSION	22
-	1	2161948-1	DRAG	20
-	1	683736-4	GUIDE, STRIP, REAR	19
-	1	683737-1	FRONT STRIP GUIDE	18
-	1	4-22280-7	SPRING, COMPRESSION	13
1	1	2161935-5	ANVIL, RIGHT HAND	8
-	1	2161957-1	DEPRESSOR, SHEAR	5
-	1	238011-2	BLOCK, CRIMPER SPACER	4
-	1	2161331-1	SPACER, WIRE FUNNEL DEPRESSOR	2
1	1	467342-2	CRIMPER, RIGHT HAND	1

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		RESTRICTED TO	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES FINISH	SCALE
							1:1
MATERIAL				WEIGHT		SCALE	
						1:1	

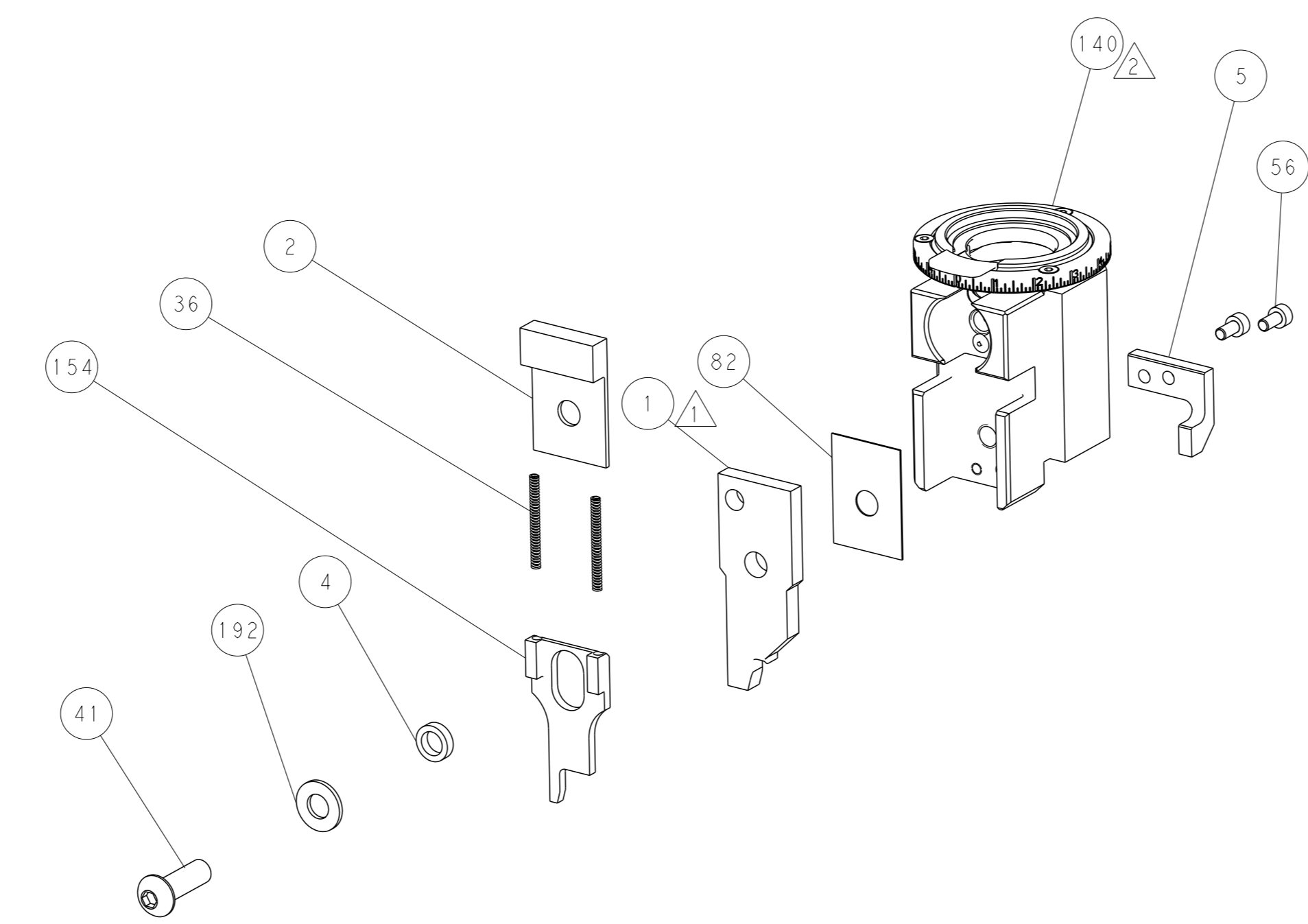
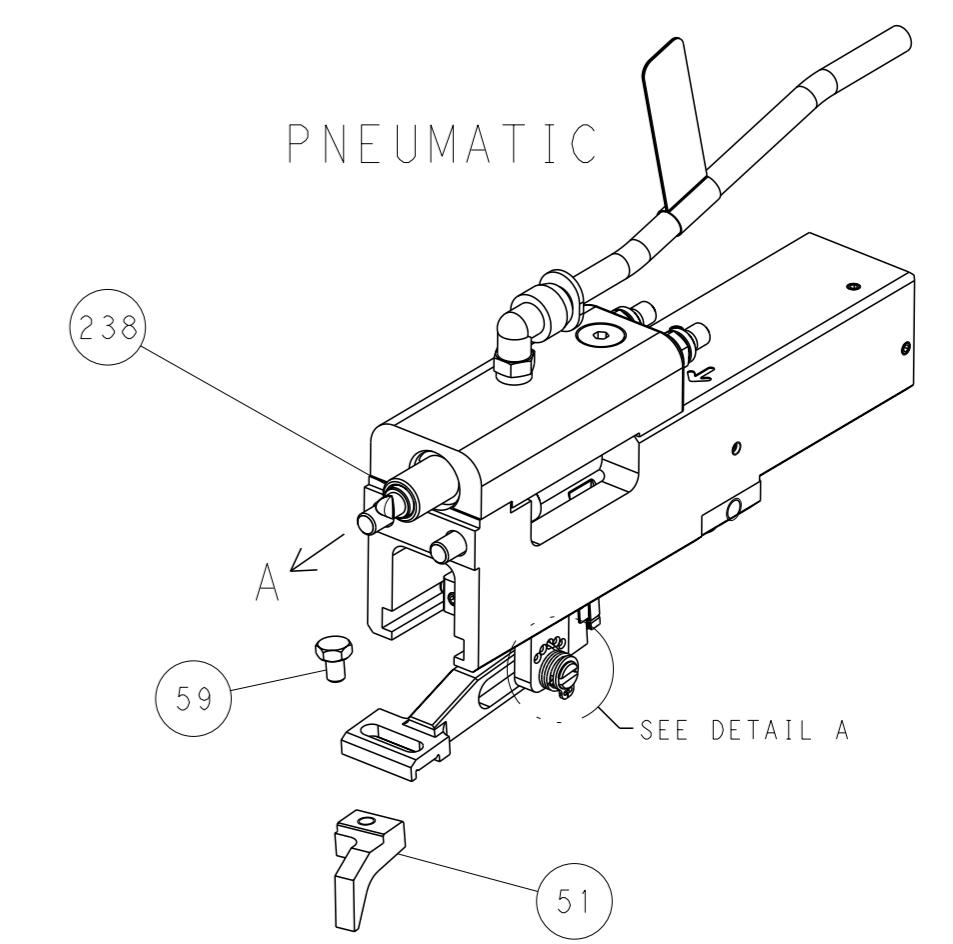
OWN	CHK	APVD	DATE	NAME	SIZE	CAGE CODE	DRAWING NO	REV
B. WEAVER	G. BAILEY	G. BAILEY	22JAN2016	NAME	A1	00779	2150642	3
Customer Accessible Production Drawing								REV

LOC	DIST	REVISIONS			
		REV	DATE	BY	APPV
A	66	-	-	-	-
		SEE SHEET 1			

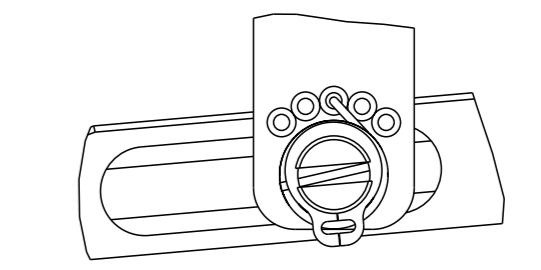


RAM SET-UP

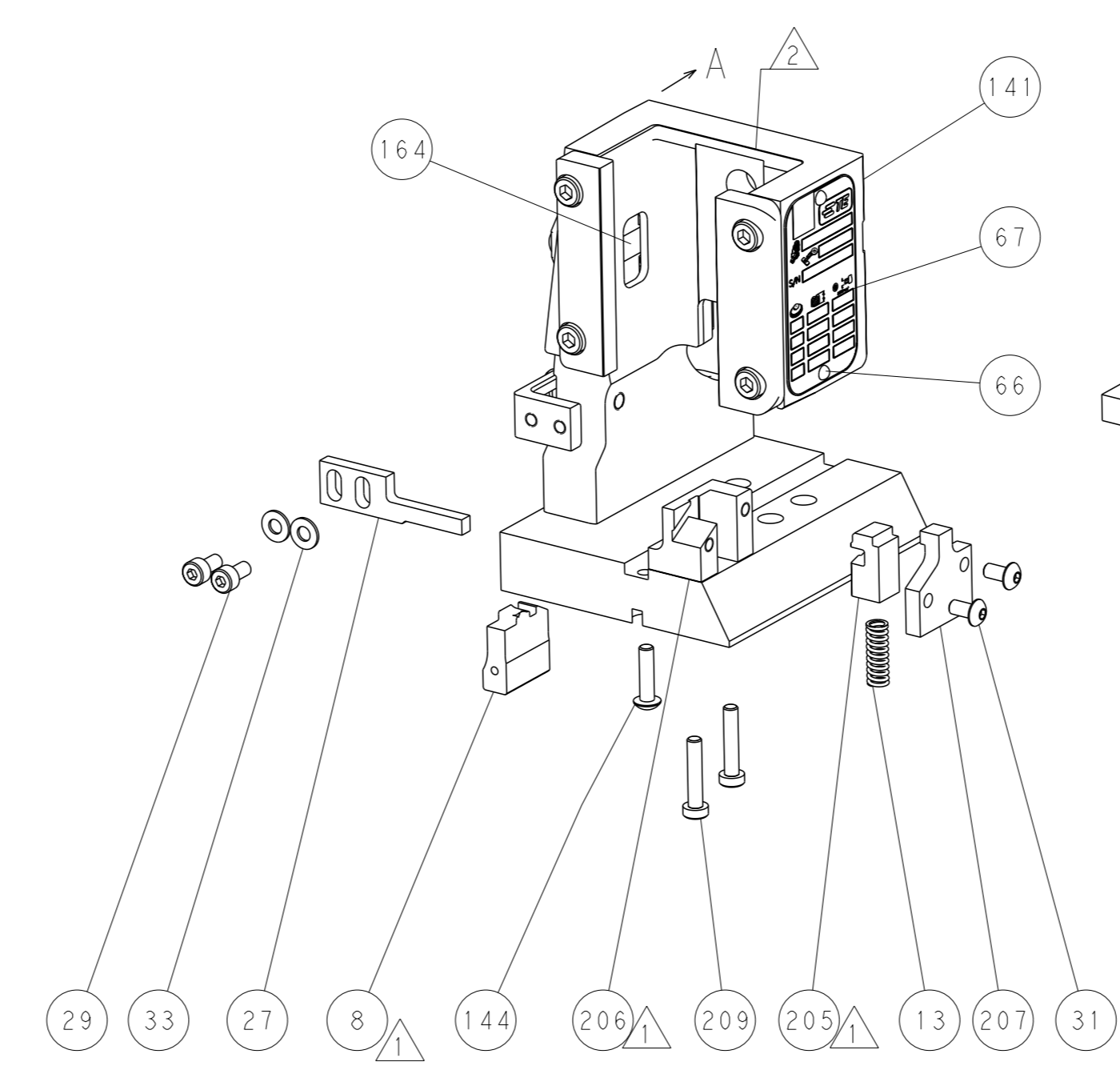
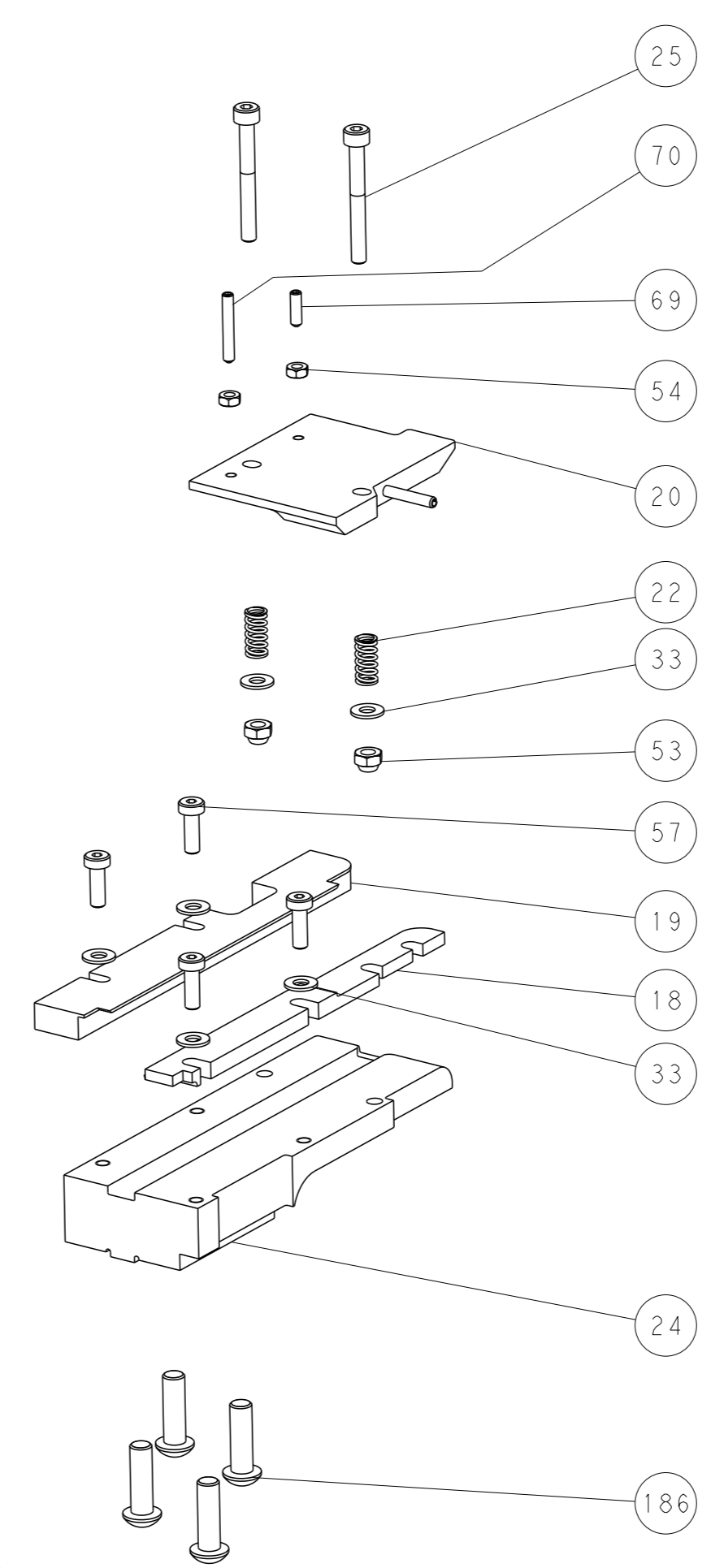
FEED TYPE



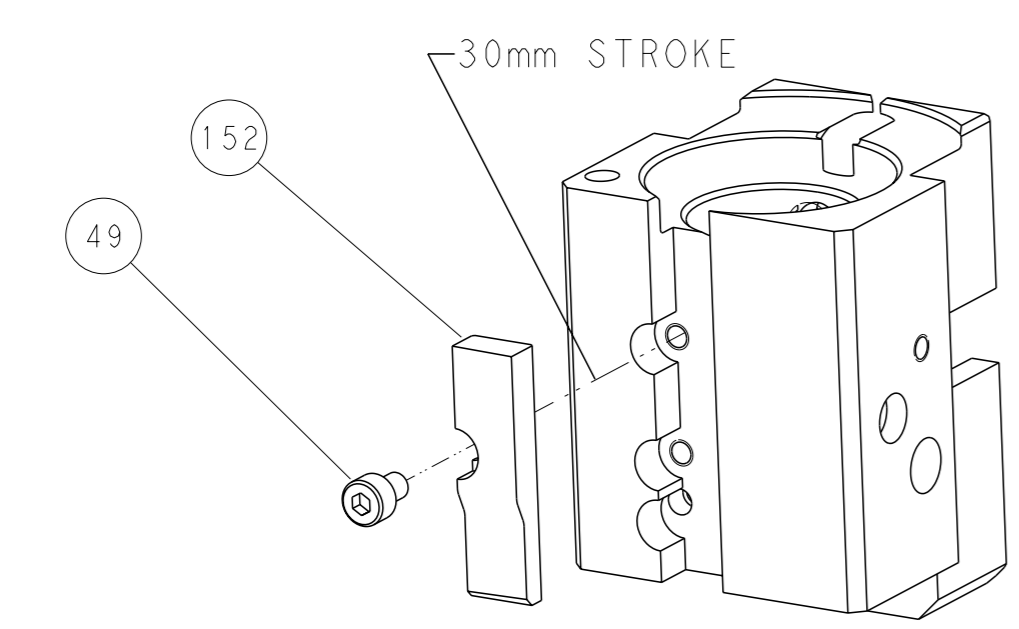
FEED SPRING SETTING POSITION



DETAIL A



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 ITS CONTENTS ARE NOT TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, INCLUDING PHOTOCOPYING, RECORDING, OR BY ANY INFORMATION STORAGE AND RETRIEVAL SYSTEM, WITHOUT THE WRITTEN PERMISSION OF TYCO ELECTRONICS CORPORATION.</small>		DWN: B. WEAVER 22JAN2016 CHK: G. BAILEY 22JAN2016 APVD: G. BAILEY 22JAN2016	NAME: Ocean End Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2150642	TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH *	TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH *	PRODUCT SPEC APPLICATION SPEC WEIGHT Customer Accessible Production Drawing	RESTRICTED TO SCALE: 1:1 SHEET 4 OF 4 REV C	