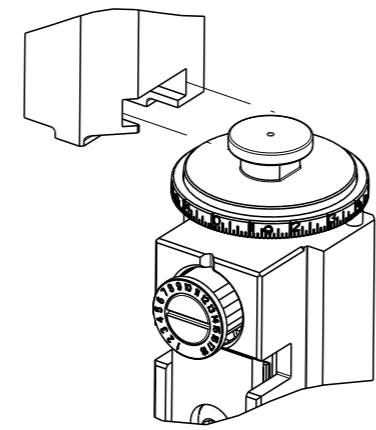


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150117-2	F	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150117-2	F	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150117-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.79 mm [.110]	F
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION			
TERMINAL NAME: SPLICE (AMPLIVAR)			
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE		
-	-		
TERMINAL APPLICATION SPECIFICATION	114-2003	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
(A) 62304-1	(A) 62000-1	(B) 62305-1	(E) 2381834-2
(A) 62304-2	(A) 62000-2	(B) 62305-2	-
-	-	(B) 62305-3	-

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION			
TERMINAL NAME: SPLICE (AMPLIVAR)			
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE		
-	-		
TERMINAL APPLICATION SPECIFICATION	114-2003	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
(C) 62306-1	(C) 62040-1	(D) 62307-2	(F) 2381836-2
(C) 62306-2	(C) 62040-2	-	-

TABLE "A" TERMINALS 62304 AND 62000			
CMA RANGE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING	
2401-3000	1.63+/-0.05 [.064+/- .002]	7.9	
1801-2400	1.52+/-0.05 [.060+/- .002]	8.9	
1201-1800	1.45+/-0.05 [.057+/- .002]	9.6	
600-1200	1.37+/-0.05 [.054+/- .002]	10.4	

TABLE "C" TERMINALS 62306 AND 62040			
CMA RANGE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING	
4126-5000	2.01+/-0.05 [.079+/- .002]	4.1	
3251-4125	1.88+/-0.05 [.074+/- .002]	5.4	
2376-3250	1.78+/-0.05 [.070+/- .002]	6.4	
1500-2375	1.65+/-0.05 [.065+/- .002]	7.6	

TABLE "B" TERMINAL 62305			
CMA RANGE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING	
2401-3000	1.40+/-0.05 [.055+/- .002]	10.1	
1801-2400	1.32+/-0.05 [.052+/- .002]	10.9	
1201-1800	1.24+/-0.05 [.049+/- .002]	11.6	
600-1200	1.17+/-0.05 [.046+/- .002]	12.4	

TABLE "D" TERMINAL 62307			
CMA RANGE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING	
4126-5000	1.78+/-0.05 [.070+/- .002]	6.4	
3251-4125	1.65+/-0.05 [.065+/- .002]	7.6	
2376-3250	1.55+/-0.05 [.061+/- .002]	8.6	
1500-2375	1.42+/-0.05 [.056+/- .002]	9.9	

TABLE "E" TERMINAL 2381834-2			
CMA RANGE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING	
2401-3000	1.38+/-0.05 [.054+/- .002]	10.3	
1801-2400	1.30+/-0.05 [.051+/- .002]	11.1	
1201-1800	1.22+/-0.05 [.048+/- .002]	11.9	
600-1200	1.14+/-0.05 [.045+/- .002]	12.7	

TABLE "F" TERMINAL 2381836-2			
CMA RANGE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING	
4126-5000	1.82+/-0.05 [.072+/- .002]	6.0	
3251-4125	1.70+/-0.05 [.067+/- .002]	7.2	
2376-3250	1.58+/-0.05 [.062+/- .002]	8.3	
1500-2375	1.46+/-0.05 [.057+/- .002]	9.5	

- 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.
- TERMINAL LUBRICANT IS RECOMMENDED.
- UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- CUT TO LENGTH AT ASSEMBLY.

***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					
		P	LYR	DESCRIPTION	DATE	OWN	APVD
A	66	E1		ECR-22-127851	27JAN2022	FZ	RK
		E2		ECR-22-141038	01JUN2022	LG	TE
		E3		ECR-22-150432	25AUG2022	FZ	JAH
		F		ECR-22-151202	01SEP2022	FZ	GB

-	1	1	23238-1	INSERT, COUPLING	278
-	24	24	2030758-3	TUBING, POLYURETHANE	277
-	1	1	986220-3	CLAMP, CABLE, BLACK	275
-	1	1	2844280-1	MOUNT, AIR BLAST	273
-	1	1	2119641-1	FEED CAM, AIR FEED	248
-	1	1	2844940-3	AIR FEED MODULE	238
-	1	1	1-18028-0	WASHER, FLAT, REG M8	192
-	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	3	3	1-18023-0	SCR, SKT HD CAP M4 X 8.0	143
-	2	2	1-18024-4	SCR, BTN SKT HD CAP (M5 X 20.0)	94
-	2	2	1-18024-1	SCR, BTN SKT HD CAP (M5 X 10.0)	93
-	1	1	2119955-2	ASSY, LUBRICATOR, END FEED	84
-	4	4	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	80
-	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
-	4	4	2168400-1	SHCS, LOW HEAD, RoHS, M4 X 12	60
-	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	2	2	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57
-	2	2	5018030-1	NUT, HEX, REG, RoHS, M3	54
-	2	2	986965-8	NUT, LOCK, HEX, TORQUE (M4)	53
-	1	1	1-2063961-3	FEED FINGER	51
-	1	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	1	1	2-2119655-1	APPLICATOR BASIC ASSEMBLY, EF	46
-	1	1	1803517-3	RAM ASSEMBLY, EF ATLANTIC	44
-	1	1	1803602-2	SCR, BHSC, RoHS (M8 X 40)	41
-	8	8	1-18028-2	WASHER, FLAT, REG M4	33
-	2	2	2-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 14	29
-	1	1	460276-2	STRIPPER, SPECIAL	27
-	2	2	1-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 30	25
-	1	1	3-1752371-0	PLATE, STRIP GUIDE	24
-	1	1	1-462932-0	PLATE, STRIP COVER	23
-	2	2	2-22281-3	SPRING, COMPRESSION	22
-	2	2	18027-2	WASHER, FLAT, REG M4	21
-	1	1	1803292-1	DRAG	20
-	2	2	1901259-4	GUIDE, LOWER STRIP	18
-	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17
-	1	1	459684-3	PLATE GUIDE, RETAINING	11
-	1	1	459580-1	PLATE, RETAINING	10
-	1	1	2-459583-1	BODY, ANVIL	9
-	1	2	459582-4	ANVIL, AMPLIVAR SPLICE	8
-	1	1	459581-1	BLADE, SLUG	7
-	-	-	-	-	6
-	-	-	-	-	5
-	-	-	-	-	4
-	1	2	459587-1	GUIDE, CRIMPER	3
-	-	-	-	-	2
-	1	2	459585-1	CRIMPER, BLUNT F	1
-	77	72	2	PART NO	ITEM NO

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

OWN	CHK	APVD	DATE	NAME	DATE
B. WEAVER	G. BAILEY	G. BAILEY	16FEB2016	G. BAILEY	16FEB2016

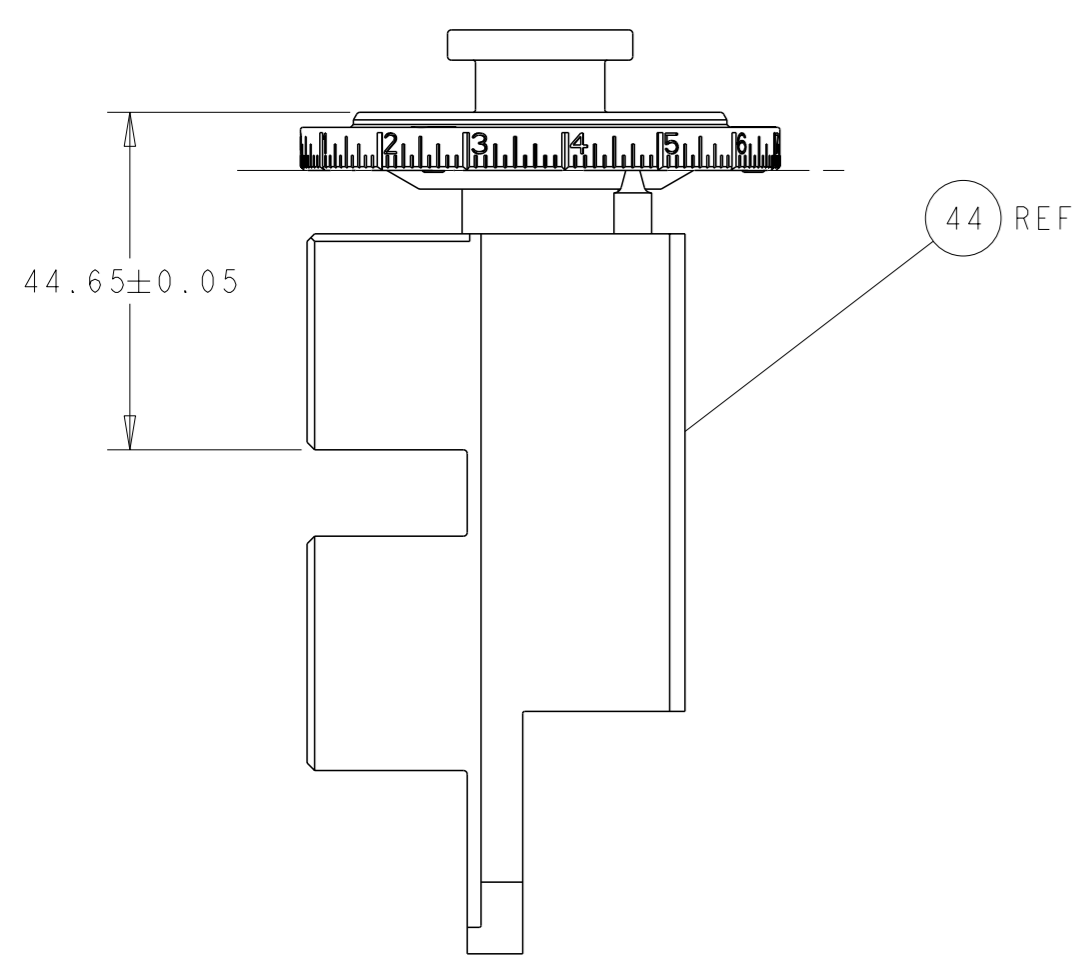
TE Connectivity
Harrisburg, PA 17105-3608

Ocean End Feed
Applicator

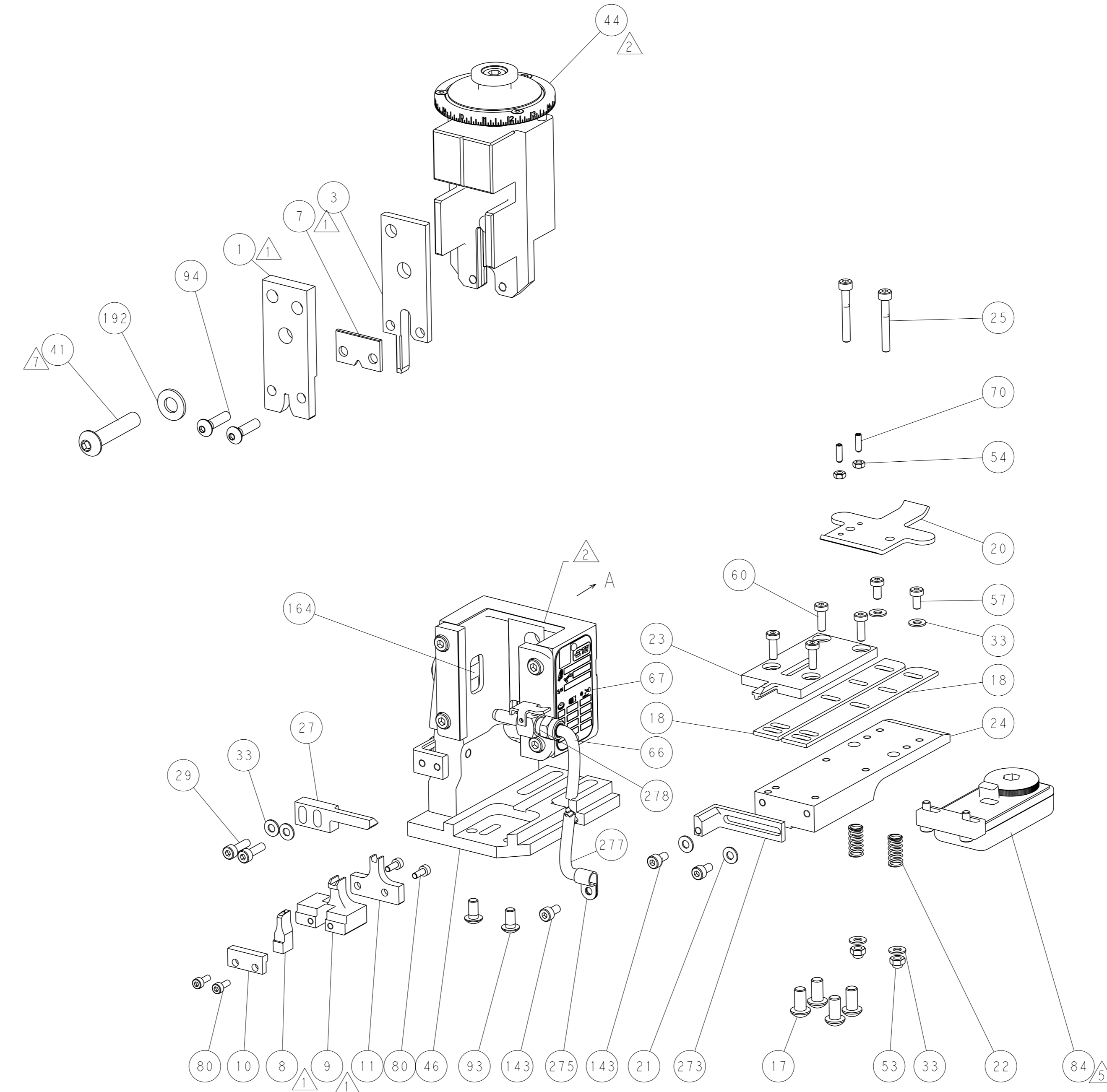
SIZE: A1 CASE CODE: 00779 DRAWING NO: C=2150117 RESTRICTED TO: -

Customer Accessible Production Drawing SHEET 1 OF 4 REV F

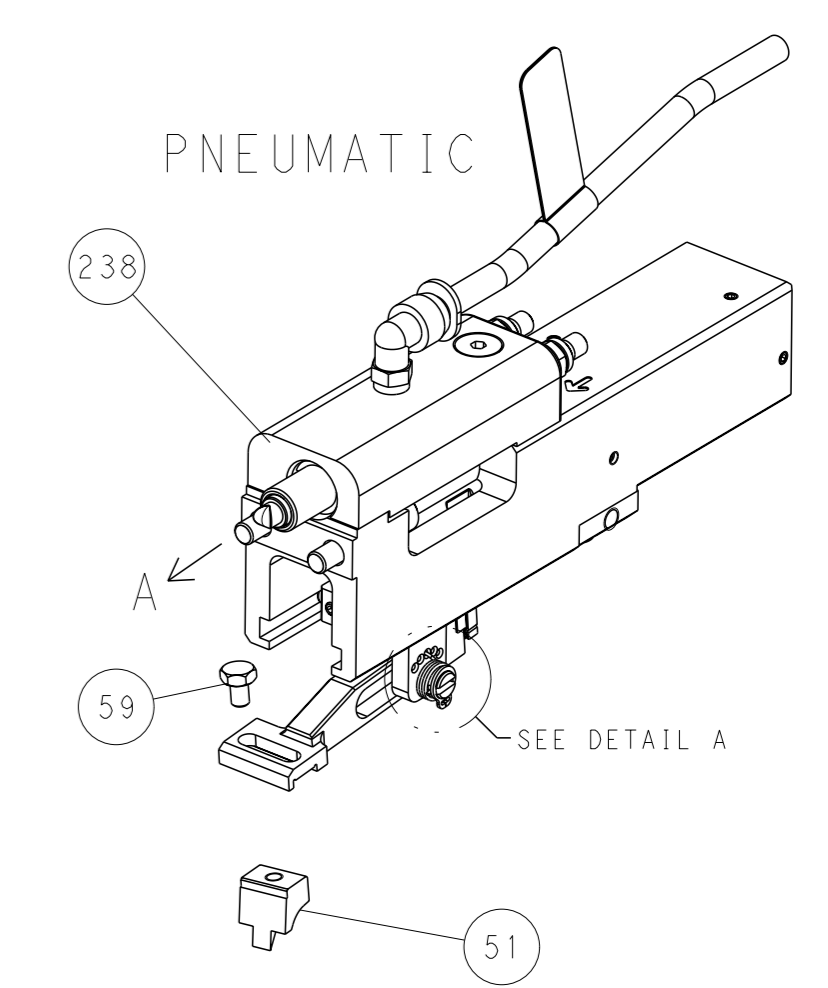
LOC	DIST	REVISIONS			
A	66	REV	DATE	OWN	APVD
		-	SEE SHEET 1	-	-



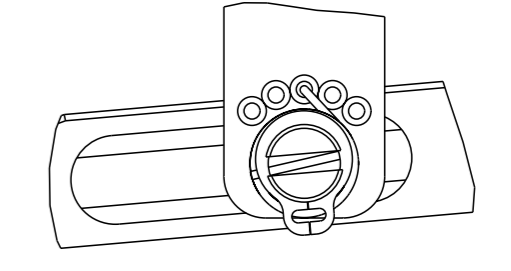
RAM SET-UP



FEED TYPE

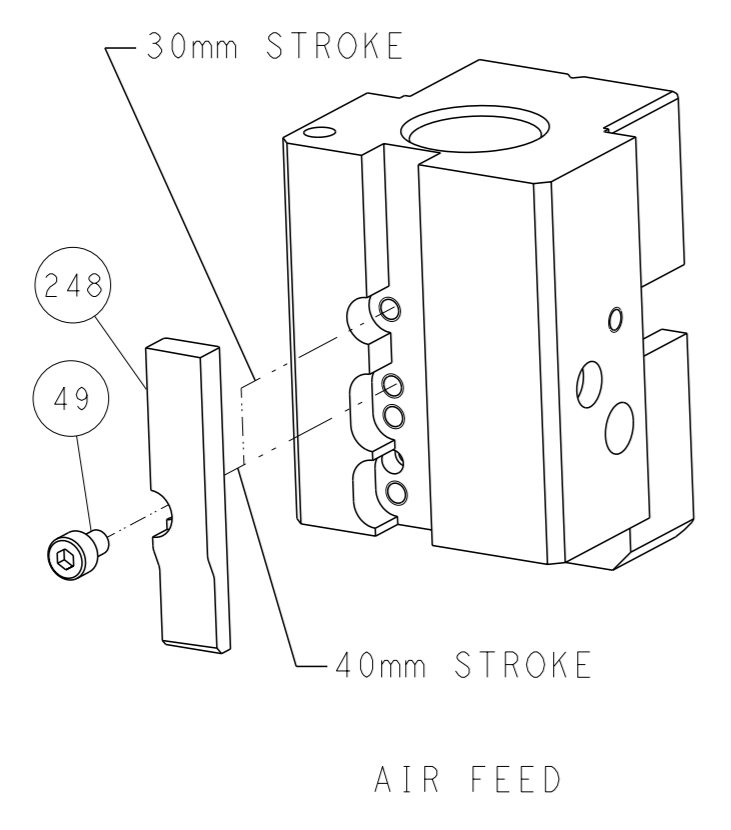


FEED SPRING SETTING POSITION



DETAIL A

CAM POSITION



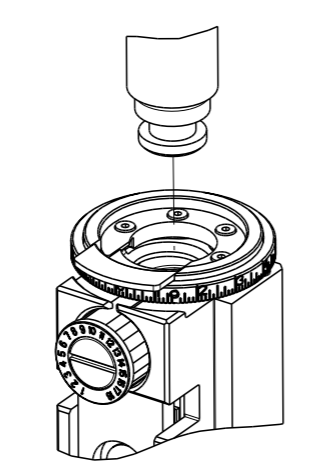
ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

<small>THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE AND ITS CONTENTS AND EXISTING DESIGNATION SHOULD BE CONTACTED FOR THE LATEST REVISION.</small>		OWN: B. WEAVER CHK: G. BAILEY APVD: G. BAILEY	16FEB2016 16FEB2016 16FEB2016	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: A1 CAGE CODE: 00779 DRAWING NO: C=2150117	RESTRICTED TO: - SCALE: 1:1 SHEET: 2 of 4 REV: F	CUSTOMER ACCESSIBLE PRODUCTION DRAWING

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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150117-2	F	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150117-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.79 mm [.110]	F
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION			
TERMINAL NAME: SPLICE (AMPLIVAR)			
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE		
-	-		
TERMINAL APPLICATION SPECIFICATION	114-2003	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
(A) 62304-1	(A) 62000-1	(B) 62305-1	(E) 2381834-2
(A) 62304-2	(A) 62000-2	(B) 62305-2	
		(B) 62305-3	

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION			
TERMINAL NAME: SPLICE (AMPLIVAR)			
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE		
-	-		
TERMINAL APPLICATION SPECIFICATION	114-2003	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
(C) 62306-1	(C) 62040-1	(D) 62307-2	(F) 2381836-2
(C) 62306-2	(C) 62040-2		

TABLE "A"
TERMINALS 62304 AND 62000

CMA RANGE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
600-3000	1.63+/-0.05 [0.064+/-0.002]	7.9
2401-3000	1.52+/-0.05 [0.060+/-0.002]	8.9
1801-2400	1.45+/-0.05 [0.057+/-0.002]	9.6
1201-1800	1.37+/-0.05 [0.054+/-0.002]	10.4

TABLE "C"
TERMINALS 62306 AND 62040

CMA RANGE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1500-5000	2.01+/-0.05 [0.079+/-0.002]	4.1
4126-5000	1.88+/-0.05 [0.074+/-0.002]	5.4
3251-4125	1.78+/-0.05 [0.070+/-0.002]	6.4
2376-3250	1.65+/-0.05 [0.065+/-0.002]	7.6

TABLE "B"
TERMINAL 62305

CMA RANGE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
600-3000	1.40+/-0.05 [0.055+/-0.002]	10.1
2401-3000	1.32+/-0.05 [0.052+/-0.002]	10.9
1801-2400	1.24+/-0.05 [0.049+/-0.002]	11.6
1201-1800	1.17+/-0.05 [0.046+/-0.002]	12.4

TABLE "D"
TERMINAL 62307

CMA RANGE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1500-5000	1.78+/-0.05 [0.070+/-0.002]	6.4
4126-5000	1.65+/-0.05 [0.065+/-0.002]	7.6
3251-4125	1.55+/-0.05 [0.061+/-0.002]	8.6
2376-3250	1.42+/-0.05 [0.056+/-0.002]	9.9

TABLE "E"
TERMINAL 2381834-2

CMA RANGE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
600-3000	1.38+/-0.05 [0.054+/-0.002]	10.3
2401-3000	1.30+/-0.05 [0.051+/-0.002]	11.1
1801-2400	1.22+/-0.05 [0.048+/-0.002]	11.9
1201-1800	1.14+/-0.05 [0.045+/-0.002]	12.7

TABLE "F"
TERMINAL 2381836-2

CMA RANGE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
600-3000	1.82+/-0.05 [0.072+/-0.002]	6.0
4126-5000	1.70+/-0.05 [0.067+/-0.002]	7.2
3251-4125	1.58+/-0.05 [0.062+/-0.002]	8.3
2376-3250	1.46+/-0.05 [0.057+/-0.002]	9.5

- 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.
- TERMINAL LUBRICANT IS RECOMMENDED.
- UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- CUT TO LENGTH AT ASSEMBLY.

***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.

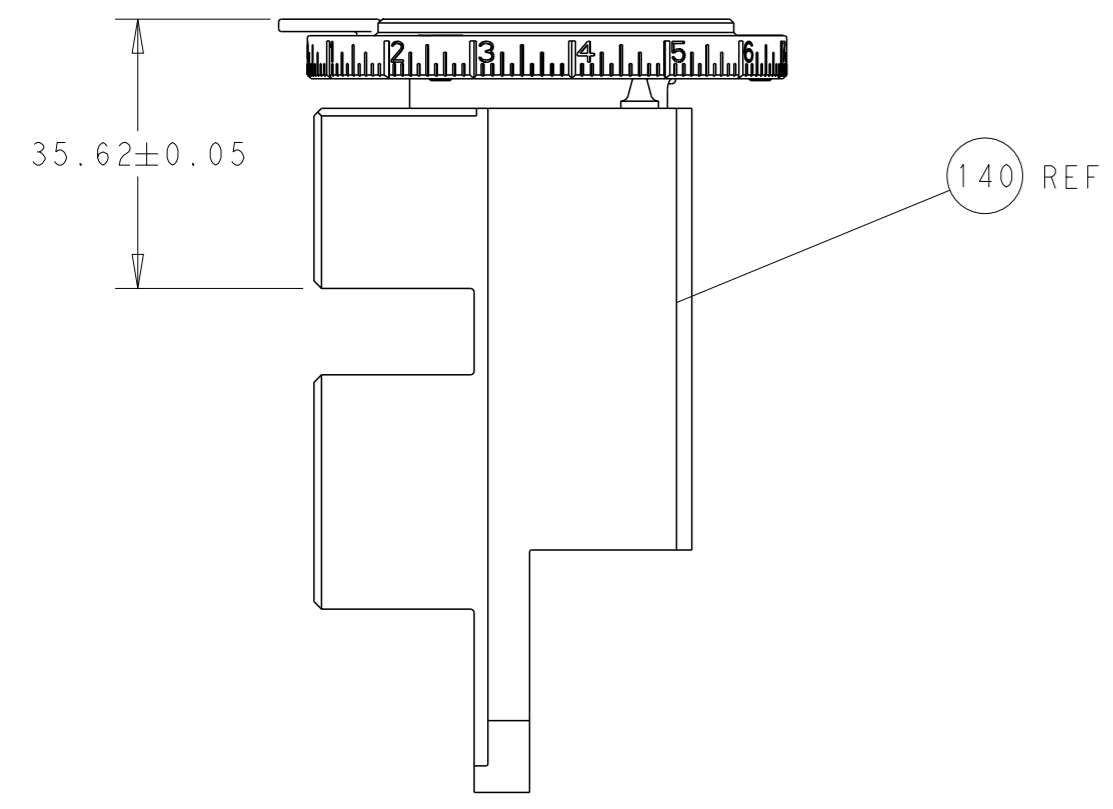
PACIFIC VERSION
Shown on sheets 3 of 4 & 4 of 4
(Atlantic version shown on sheets 1 of 4 & 2 of 4)

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

REV	DATE	DESCRIPTION	ITEM NO	
-	1	23238-1	INSERT, COUPLING	278
-	24	2030758-3	TUBING, POLYURETHANE	277
-	1	986220-3	CLAMP, CABLE, BLACK	275
-	1	2844280-1	MOUNT, AIR BLAST	273
-	1	2844940-3	AIR FEED MODULE	238
-	1	1-18028-0	WASHER, FLAT, REG M8	192
-	4	2-18024-1	SCR, BTN SKT HD CAP (M6 X 25.0)	186
-	REF	994970-2	COUNTER, MAGNETIC	164
-	1	2119641-2	FEED CAM, AIR FEED	152
-	3	1-18023-0	SCR, SKT HD CAP M4 X 8.0	143
-	1	2-2119655-2	APPLICATOR BASIC ASSEMBLY, EF	141
-	1	1803518-3	RAM ASSEMBLY, EF PACIFIC	140
-	2	1-18024-3	SCR, BTN SKT HD CAP (M5 X 16.0)	95
-	2	1-18024-4	SCR, BTN SKT HD CAP (M5 X 20.0)	94
-	1	2119955-2	ASSY, LUBRICATOR, END FEED	84
-	4	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	80
-	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
-	4	2168400-1	SHCS, LOW HEAD, RoHS, M4 X 12	60
-	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	2	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57
-	2	5018030-1	NUT, HEX, REG, RoHS, M3	54
-	2	986965-8	NUT, LOCK, HEX, TORQUE (M4)	53
-	1	1-2063961-3	FEED FINGER	51
-	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	1	1803602-2	SCR, BHSC, RoHS (M8 X 40)	41
-	8	1-18028-2	WASHER, FLAT, REG M4	33
-	2	2-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 14	29
-	1	460276-2	STRIPPER, SPECIAL	27
-	2	1-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 30	25
-	1	3-1752371-0	PLATE, STRIP GUIDE	24
-	1	1-462932-0	PLATE, STRIP COVER	23
-	2	2-22281-3	SPRING, COMPRESSION	22
-	2	18027-2	WASHER, FLAT, REG M4	21
-	1	1803292-1	DRAG	20
-	2	1901259-4	GUIDE, LOWER STRIP	18
-	1	459684-3	PLATE GUIDE, RETAINING	11
-	1	459580-1	PLATE, RETAINING	10
-	1	2-459583-1	BODY, ANVIL	9
-	1	459582-4	ANVIL, AMPLIVAR SPLICE	8
-	1	459581-1	BLADE, SLUG	7
-	-	-	-	6
-	-	-	-	5
-	-	-	-	4
-	1	459587-1	GUIDE, CRIMPER	3
-	-	-	-	2
-	1	459585-1	CRIMPER, BLUNT F	1

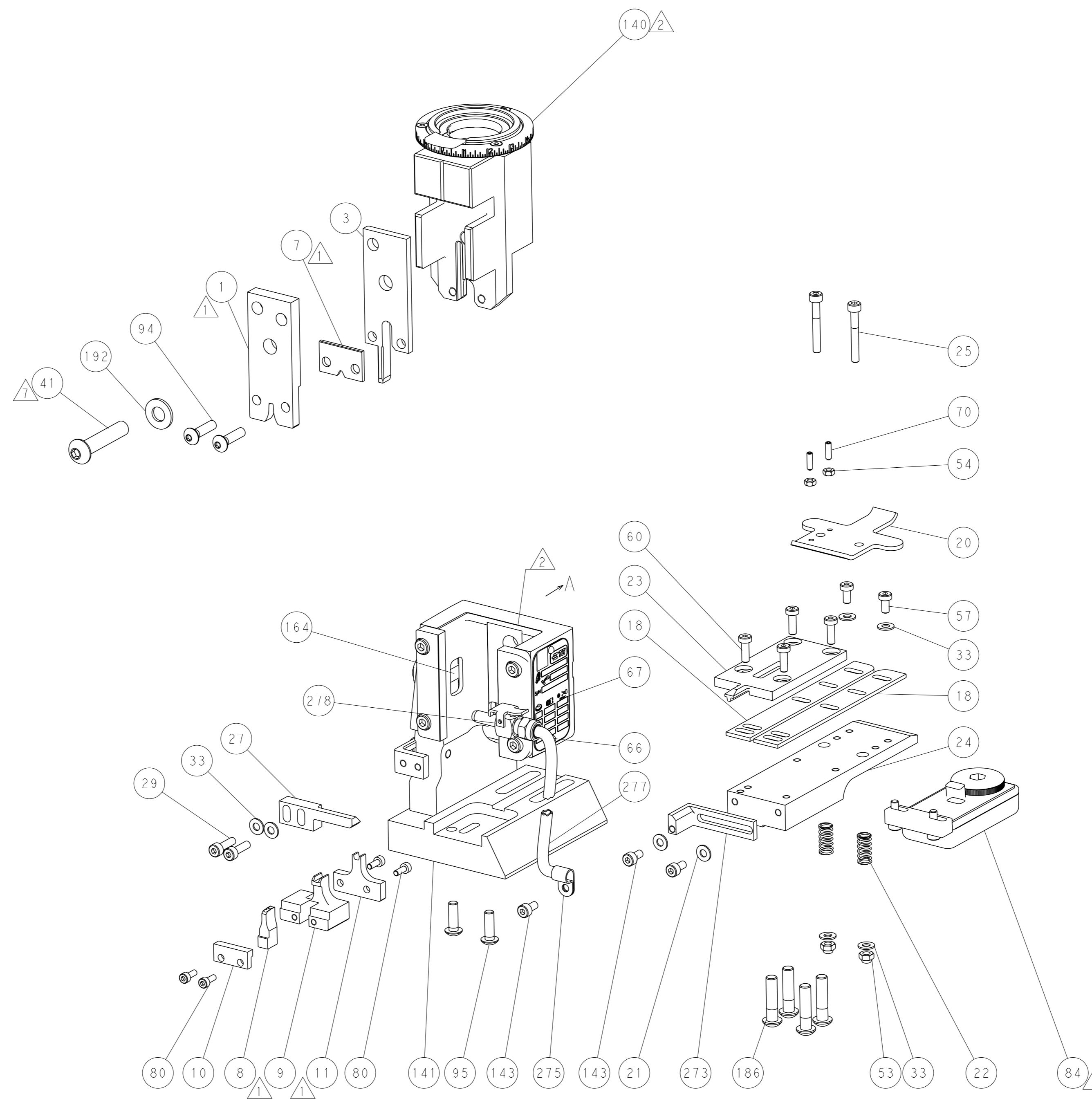
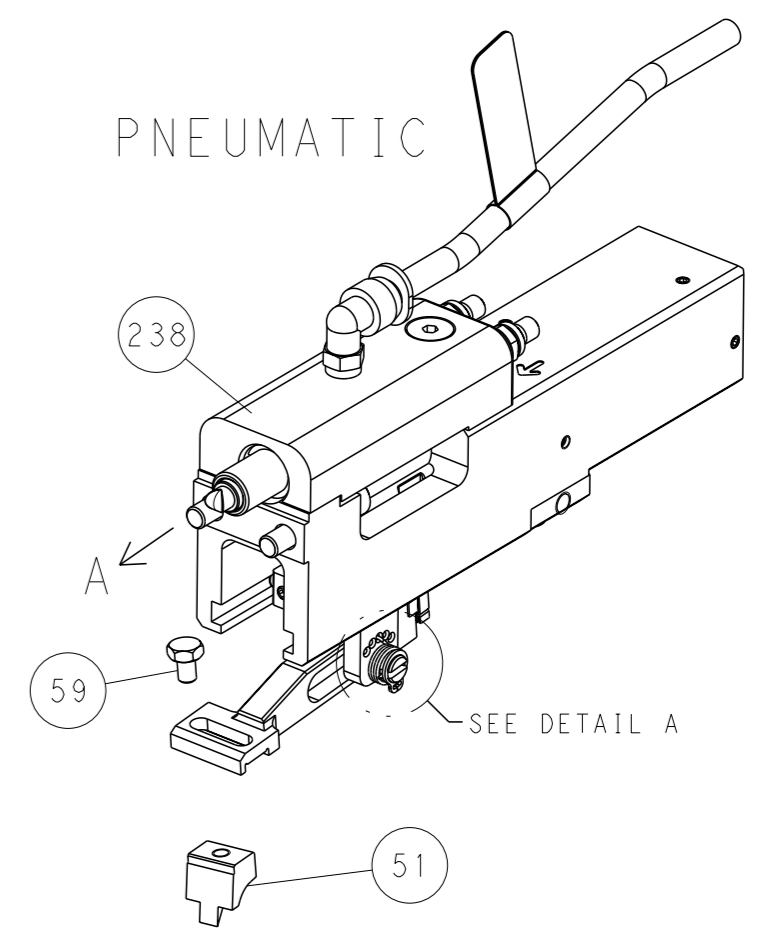
<small>THE INFORMATION CONTAINED HEREIN IS UNCLASSIFIED EXCEPT WHERE SHOWN OTHERWISE. IT IS SUBJECT TO CHANGE AND WITHOUT WARRANTY OF ACCURACY OR COMPLETION. IT SHOULD BE CONTACTED FOR THE LATEST REVISION.</small>		OWN: B. WEAVER CHK: G. BAILEY APVD: G. BAILEY PRODUCT SPEC: - APPLICATION SPEC: - MATERIAL: - WEIGHT: - FINISH: -	DATE: 16FEB2016 NAME: - SIZE: A1 CASE CODE: 00779 DRAWING NO: C-2150117 SCALE: 1:1 SHEET: 3 of 4 REV: F	TE Connectivity Harrisburg, PA 17105-3608 Ocean End Feed Applicator
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LOC	DIST	REVISIONS			
A	66	REV	DATE	OWN	APVD
		-	SEE SHEET 1	-	-

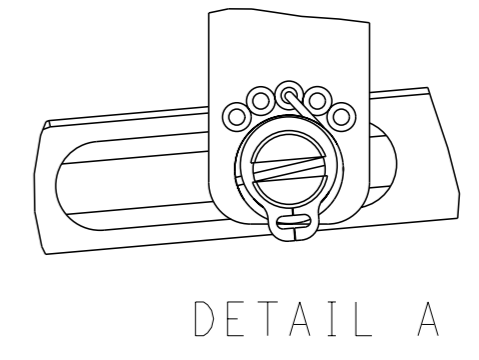


RAM SET-UP

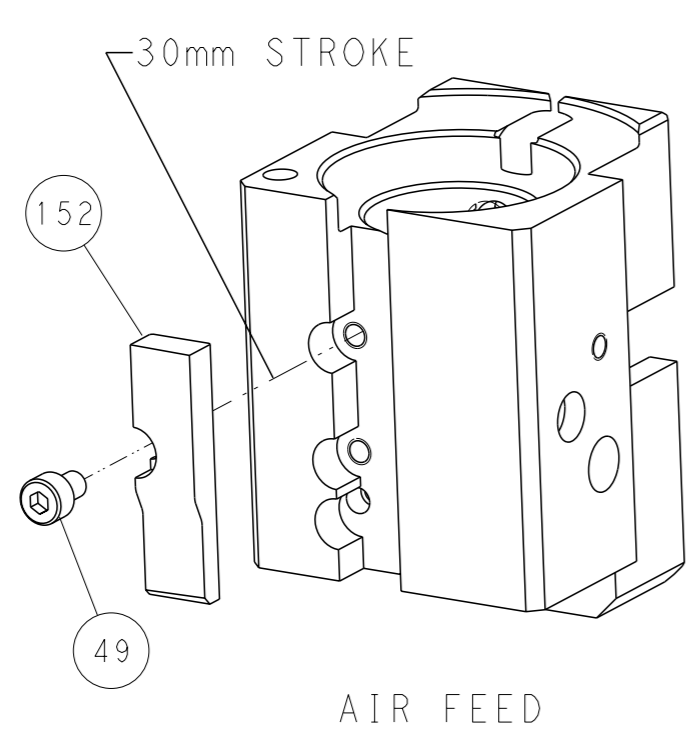
FEED TYPE



FEED SPRING SETTING POSITION



CAM POSITION



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: - MATERIAL: -	APPLICATION SPEC: - PRODUCT SPEC: -	CUSTOMER ACCESSIBLE PRODUCTION DRAWING	