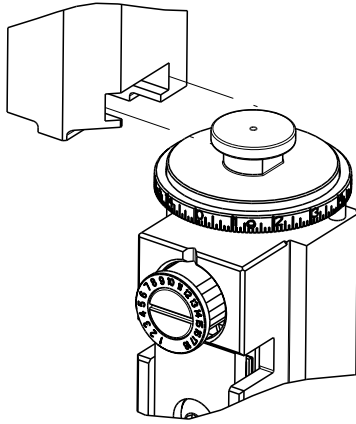


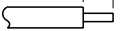
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RELEASED FOR PUBLICATION 20	
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PART NUMBER	REVISION
2150137-2	D
7-2150137-2	D
7-2150137-7	A
DESCRIPTION	
FINE CRIMP HEIGHT ADJUST	
PNEUMATIC AND CRIMP TOOLING KIT	
CRIMP TOOLING KIT	
FEED TYPE	
PNEUMATIC	
PNEUMATIC	
-	

ATLANTIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	5.59 mm [.220]	F
INSUL	-	-
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: SPLICE (AMPLIVAR)			
WIRE STRIP LENGTH 7.87-8.89 mm [.310-.350 IN]		INSULATION DIAMETER RANGE Ø -	
TERMINAL APPLICATION SPECIFICATION 114-2003		-	
TERMINALS APPLIED		-	
TE TERMINAL		TE TERMINAL	
62309-1		62309-2	

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: SPLICE (AMPLIVAR)			
WIRE STRIP LENGTH 7.87-8.89 mm [.310-.350 IN]			INSULATION DIAMETER RANGE Ø
TERMINAL APPLICATION SPECIFICATION 114-2003		-	-
TERMINALS APPLIED 		-	-
TERMINALS APPLIED  			
TE TERMINAL 62310-2	TE TERMINAL	TE TERMINAL	TE TERMINAL

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
9445 CMA 150 + 12 MAG	2.24+/-0.05 [.088+/- .002]	6.4
5092 CMA 170 + 15 MAG	1.92+/-0.05 [.076+/- .002]	8.3

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
13976 CMA 200 + 2x 12 MAG	2.64+/-0.05 [.104+/- .002]	3.0
7025 CMA 150 + 14 MAG	2.17+/-0.05 [.085+/- .002]	8.0



- RECOMMENDED SPARE PARTS
- REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- 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.
- CUT TO LENGTH AT ASSEMBLY.
- WIRE COMBINATIONS ARE FOR SET-UP ONLY.
- REFER TO CUSTOMER TERMINAL DRAWING FOR CRIMP HEIGHT FORMULA FOR SPECIFIC WIRE COMBINATIONS.

*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)

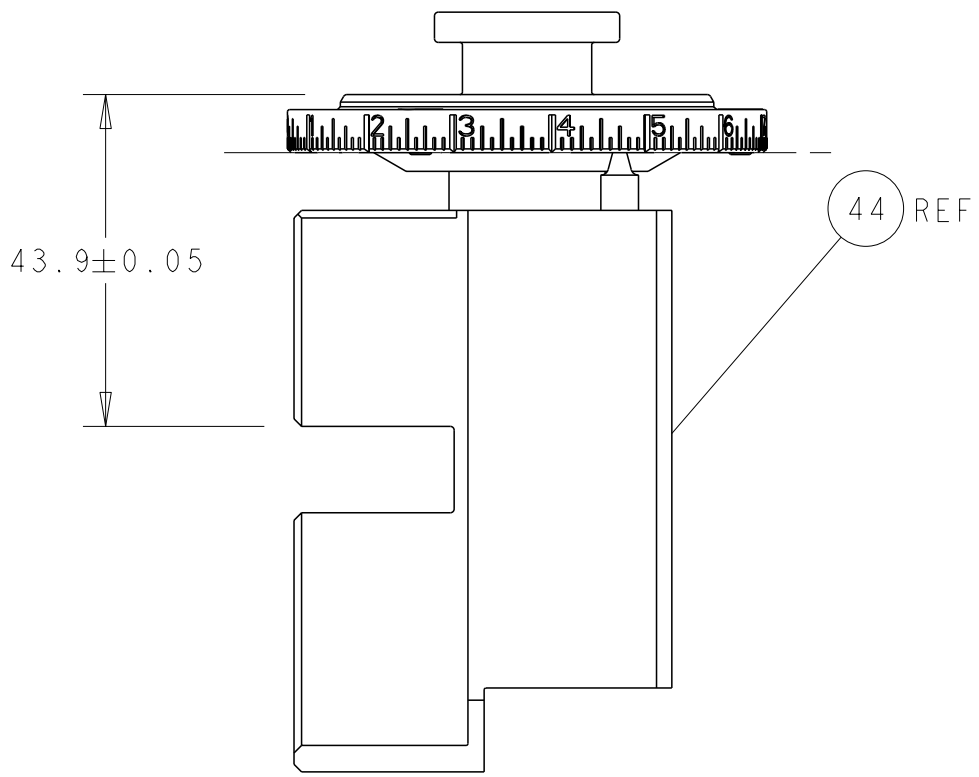
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		B		ECR-19-010405	03JUL2019 TB TE
		C		ECR-22-133763	24MAR2022 JWC JH
		D		ECR-23-165199	02FEB2023 FZ GB

	-	1	1	1803078-6	SPACER, PRECISION	259
	-	1	1	2119641-1	FEED CAM, AIR FEED	248
	-	1	1	2844940-3	AIR FEED MODULE	238
	-	2	2	1-2168083-1	SCR, SKT HD CAP, RoHS, M3 X 6	191
5	-	REF	REF	994970-2	COUNTER, MAGNETIC	164
	-	1	1	2119955-2	ASSY, LUBRICATOR, END FEED	84
	-	1	1	455888-7	SPACER, CRIMPER	82
	-	1	1	1803607-4	DOCUMENTATION PACKAGE	71
	-	2	2	3-18032-3	SCR, SET, FLT PNT, M3 X 20.0	70
	-	1	1	2119740-1	TAG, IDENTIFICATION	67
	-	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
	-	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
7	-	3	3	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57
	-	3	3	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	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	1803517-2	RAM ASSEMBLY, EF ATLANTIC	44
	-	1	1	1803602-4	SCR, BHSC, RoHS (M8 X 30)	41
	-	7	7	1-18028-2	WASHER, FLAT, REG M4	33
	-	2	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	29
	-	1	1	2280150-1	STRIPPER	27
	-	2	2	1-2168083-6	SCR, SKT HD CAP, RoHS, M4 X 35	25
	-	1	1	2161922-4	PLATE, STRIP GUIDE	24
	-	1	1	240825-1	PLATE, STRIP HOLD DOWN	23
	-	2	2	2-22281-3	SPRING, COMPRESSION	22
	-	1	1	1633168-2	ARM, STOCK DRAG	21
	-	1	1	464452-6	DRAG, STOCK	20
	-	2	2	1-1901259-5	GUIDE, LOWER STRIP	18
	-	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17
	-	2	2	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	13
1	-	1	1	679860-6	PLATE, REAR SHEAR	11
	-	-	-	-	-	10
1	-	1	1	690619-9	PLATE, RETAINING	9
	1	2	1	1803450-2	ANVIL, AMPLIVAR SPLICE	8
1	-	1	1	2280112-2	BLADE, SHEAR	7
	-	-	-	-	-	6
	-	-	-	-	-	5
1	1	2	1	679864-3	PLATE, TOOLING	3
	1	2	1	2280099-5	CRIMPER, WIRE, BLUNT, AMPLIVAR	1
	-77-72	-2		PART NO	DESCRIPTION	ITEM NO

THIS DRAWING IS A CONTROLLED DOCUMENT FOR TFC ELECTRONICS CORPORATION IT IS SUBJECT TO CHANGE AND TO BE CONTROLLED BY THE ENGINEERING ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST REVISION.				DWN K. HUANG CHK L. ZHANG APVD L. ZHANG	12AUG2016 12AUG2016 12AUG2016	 TE Connectivity Harrisburg, PA 17105-3608		
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		NAME		Ocean End Feed Applicator		
		0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±	± ± ± ± ± ±	PRODUCT SPEC - APPLICATION SPEC -		SIZE CASE CODE DRAWING NO		
MATERIAL		FINISH		WEIGHT		A1 00779 ©=2150137		RESTRICTED TO -
Customer Accessible Production Drawing						SCALE 1:1		SHEET 1 OF 4 REV D

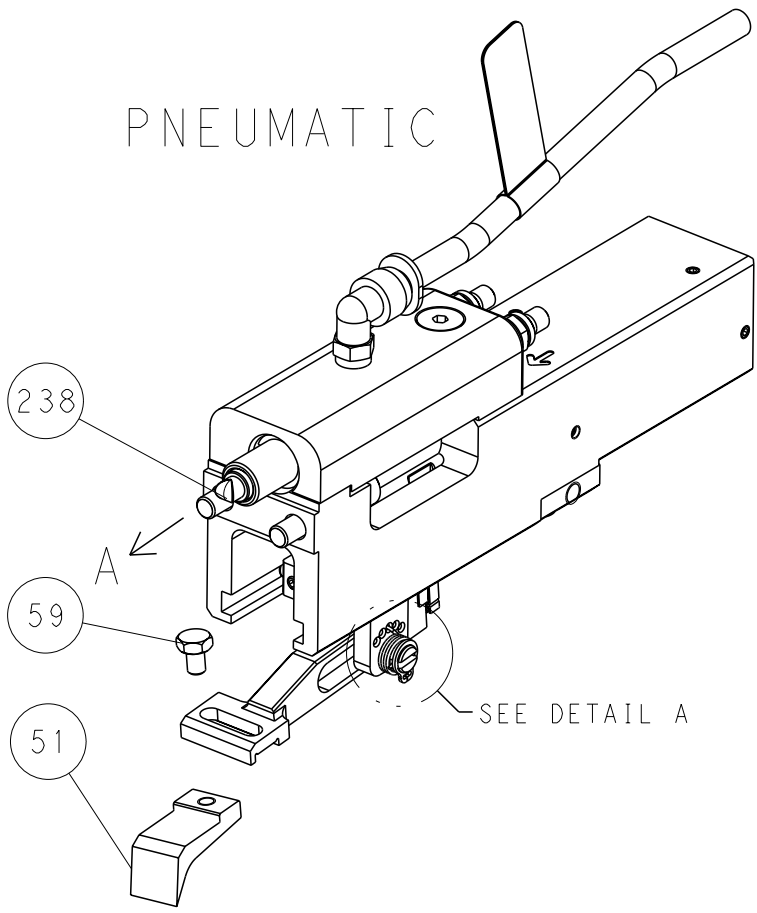
SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

LOC	DIST	REVISIONS					
		P	LYR	DESCRIPTION	DATE	DWN	APVD
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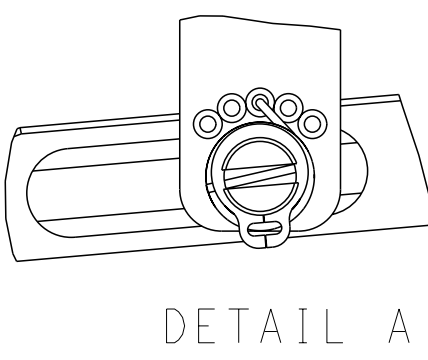


RAM SET-UP

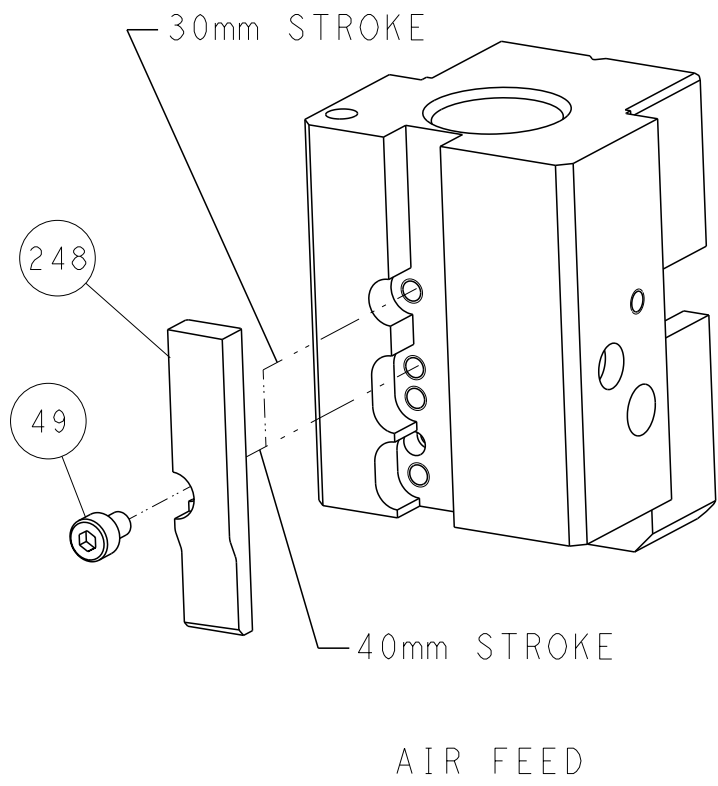
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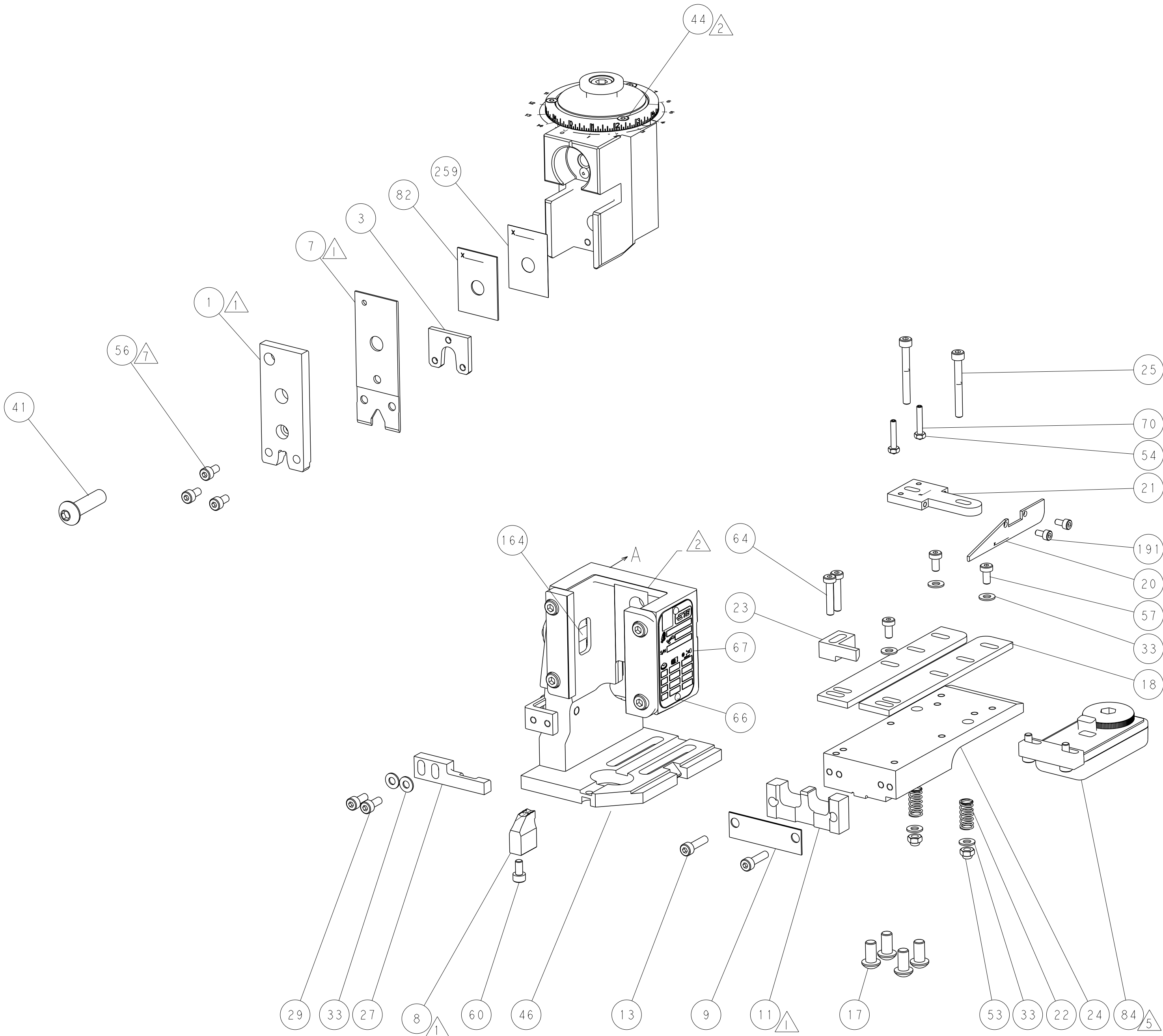
FEED SPRING SETTING POSITION



CAM POSITION



AIR FEED

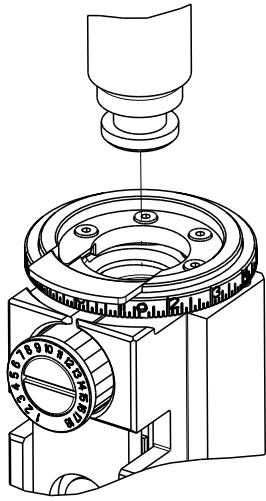


ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION IT IS SUBJECT TO CHANGE AND TO CONTROL AND ENGINEERING ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST REVISION.				DWN K. HUANG	12AUG2016	 TE Connectivity Harrisburg, PA 17105-3608	NAME Ocean End Feed Applicator -	
				CHK L. ZHANG	12AUG2016			
				APVD L. ZHANG	12AUG2016			
				PRODUCT SPEC				
				APPLICATION SPEC		SIZE A	CAGE CODE 00779	
				WEIGHT -				
				Customer Accessible Production Drawing		SCALE 1:1		
						SHEET 2		
						OF 4		
						REV D		

8		7	
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20		20	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150137-2	D	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150137-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	5.59 mm [.220]	F
INSUL	-	-
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: SPLICE (AMPLIVAR)			
WIRE STRIP LENGTH 7.87-8.89 mm [.310-.350 IN]		INSULATION DIAMETER RANGE Ø -	
TERMINAL APPLICATION SPECIFICATION 114-2003		-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
62309-1	62309-2		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
9445 CMA 15½ + 12 MAG	2.24+/-0.05 [.088+/- .002]	6.4
5092 CMA 17½ + 15 MAG	1.92+/-0.05 [.076+/- .002]	8.3

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: SPLICE (AMPLIVAR)			
WIRE STRIP LENGTH 7.87-8.89 mm [.310-.350 IN]		INSULATION DIAMETER RANGE Ø	
TERMINAL APPLICATION SPECIFICATION 114-2003		-	-
TERMINALS APPLIED		-	-
TERMINALS APPLIED			
TE TERMINAL 62310-2	TE TERMINAL	TE TERMINAL	TE TERMINAL

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
13976 CMA 20½ + 2x 12 MAG	2.64+/-0.05 [.104+/- .002]	3.0
7025 CMA 15½ + 14 MAG	2.17+/-0.05 [.085+/- .002]	8.0



- 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.
- 7 CUT TO LENGTH AT ASSEMBLY.
- 8 WIRE COMBINATIONS ARE FOR SET-UP ONLY.
- 9 REFER TO CUSTOMER TERMINAL DRAWING FOR CRIMP HEIGHT FORMULA FOR SPECIFIC WIRE COMBINATIONS.

*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)

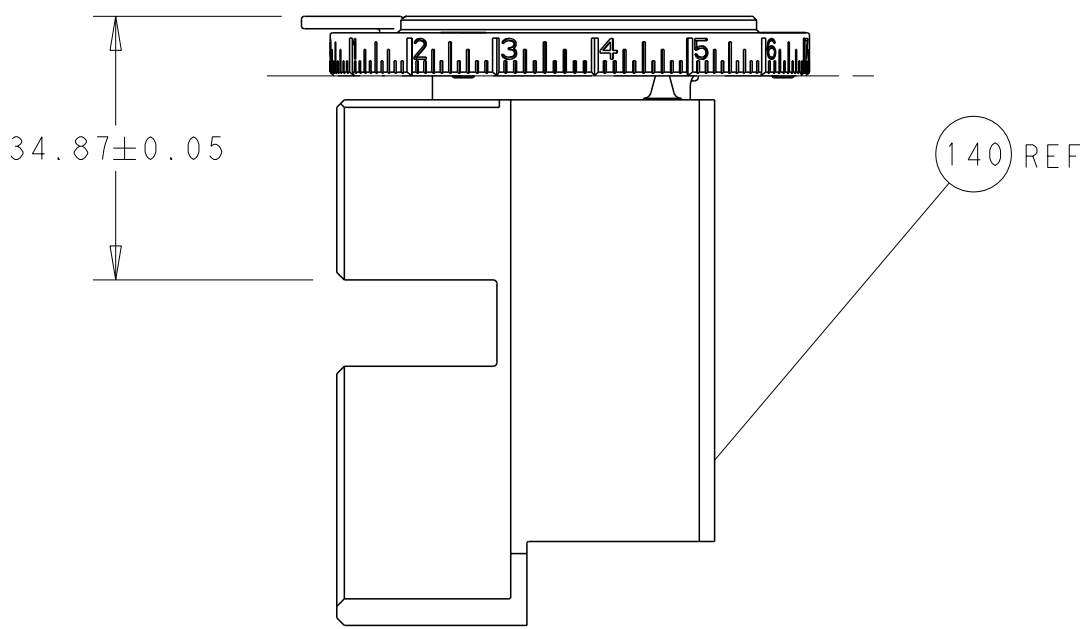
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LOC	DIST	REVISIONS						
A	66	P	LTR	DESCRIPTION	DATE	DWN	APVD	
		-		SEE SHEET 1	-	-	-	

-	1	1803078-6	SPACER, PRECISION	259
-	1	2844940-3	AIR FEED MODULE	238
-	2	1-2168083-1	SCR, SKT HD CAP, RoHS, M3 X 6	191
-	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	1803518-2	RAM ASSEMBLY, EF PACIFIC	140
-	1	2119955-2	ASSY, LUBRICATOR, END FEED	84
-	1	455888-7	SPACER, CRIMPER	82
-	1	1803607-4	DOCUMENTATION PACKAGE	71
-	2	3-18032-3	SCR, SET, FLT PNT, M3 X 20.0	70
-	1	2119740-1	TAG, IDENTIFICATION	67
-	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	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
-	3	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	2063961-9	FEED FINGER	51
-	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	1	1803602-4	SCR, BHSC, RoHS (M8 X 30)	41
-	7	1-18028-2	WASHER, FLAT, REG M4	33
-	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	29
-	1	2280150-1	STRIPPER	27
-	2	1-2168083-6	SCR, SKT HD CAP, RoHS, M4 X 35	25
-	1	2161922-4	PLATE, STRIP GUIDE	24
-	1	240825-1	PLATE, STRIP HOLD DOWN	23
-	2	2-22281-3	SPRING, COMPRESSION	22
-	1	1633168-2	ARM, STOCK DRAG	21
-	1	464452-6	DRAG, STOCK	20
-	2	1-1901259-5	GUIDE, LOWER STRIP	18
-	2	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	13
-	1	679860-6	PLATE, REAR SHEAR	11
-	-	-	-	10
-	1	690619-9	PLATE, RETAINING	9
1	1	1803450-2	ANVIL, AMPLIVAR SPLICE	8
-	1	2280112-2	BLADE, SHEAR	7
-	-	-	-	6
-	-	-	-	5
1	1	679864-3	PLATE, TOOLING	3
1	1	2280099-5	CRIMPER, WIRE, BLUNT, AMPLIVAR	1
-	77-22	PART NO	DESCRIPTION	ITEM NO

THIS DRAWING IS A CONTROLLED DOCUMENT FOR THE PROPRIETARY INFORMATION OF THE COMPANY. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. THE COMPANY SHALL BE CONTACTED FOR THE LATEST REVISION.				DWN R. HUANG 12AUG2016	TE Connectivity Harrisburg, PA 17105-3608			
DIMENSIONS: mm				CHK L. ZHANG 12AUG2016	NAME			
TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±				APVD L. ZHANG 12AUG2016	PRODUCT SPEC			
MATERIAL					APPLICATION SPEC			
FINISH					WEIGHT			
-					A1 00779 ©=2150137			
Customer Accessible Production Drawing				SCALE	1:1	SHEET	3 OF 4	REV D

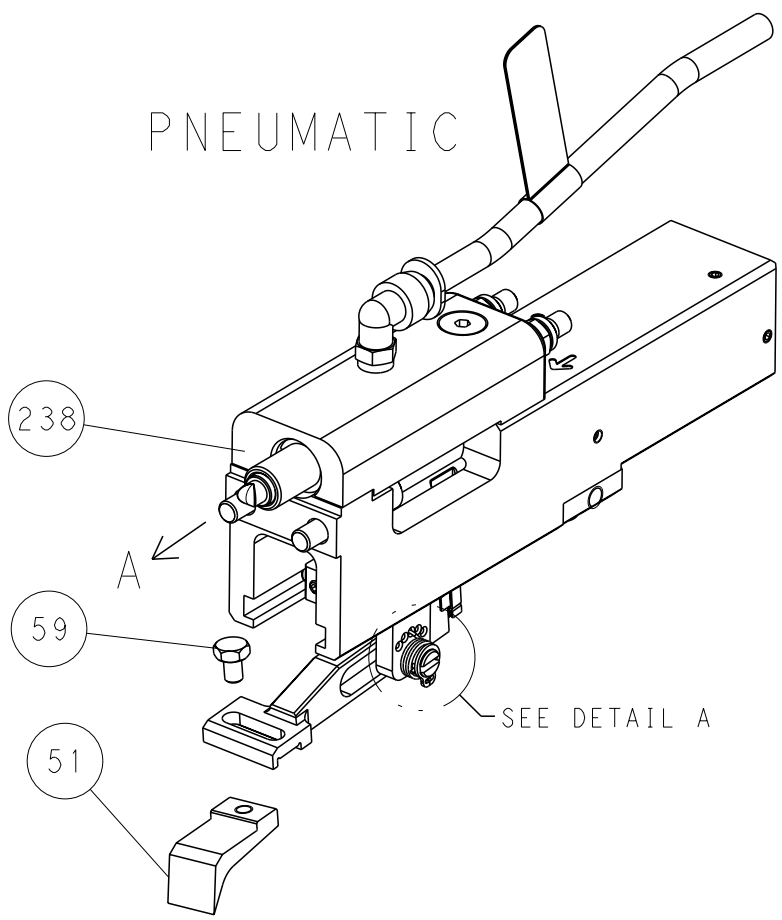
SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

LOC		DIST		REVISONS			
A	66	P	LYR	DESCRIPTION	DATE	DWN	APVD
		-		SEE SHEET 1	-	-	-

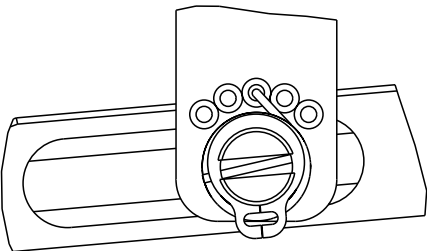


RAM SET-UP

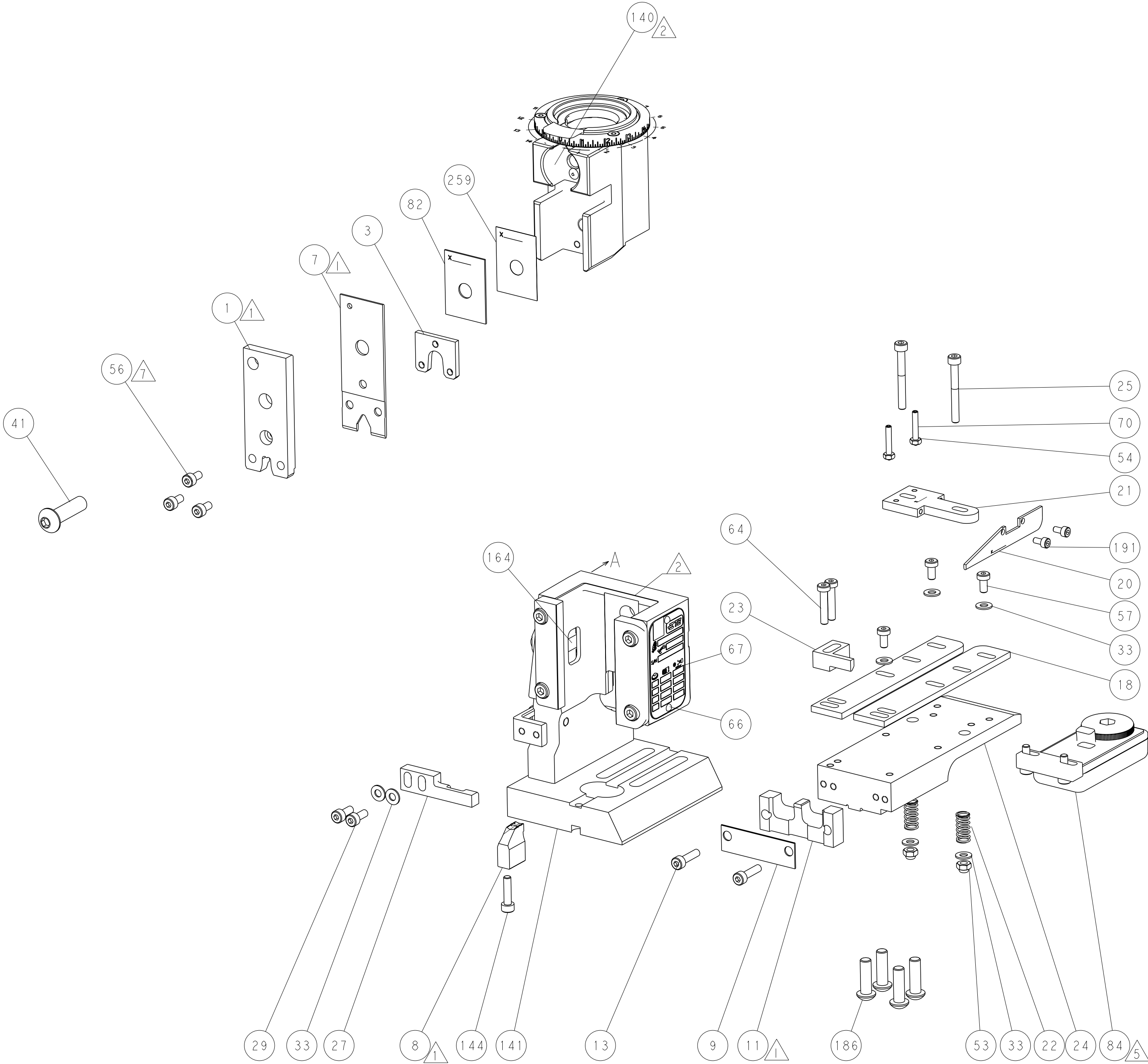
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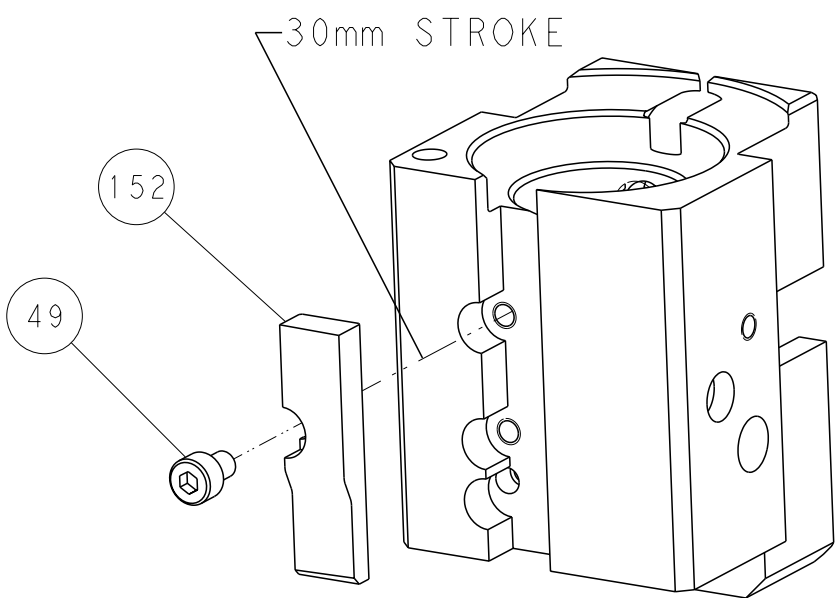
FEED SPRING SETTING POSITION



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)

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				CHK L. ZHANG	12AUG2016		
				APVD L. ZHANG	12AUG2016		
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		PRODUCT SPEC		NAME Ocean End Feed Applicator	
mm		0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH -		APPLICATION SPEC			
MATERIAL				WEIGHT		SIZE A1	
				Customer Accessible Production Drawing		SCALE 1:1	
						SHEET 4	
						OF 4	
						REV D	