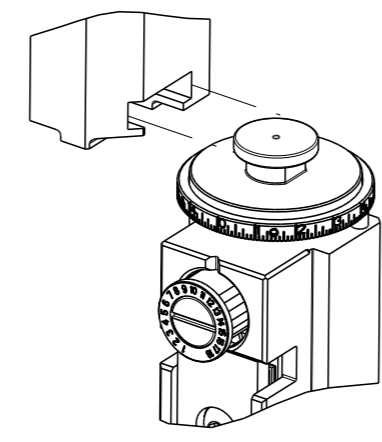


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150209-1	D	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2150209-2	D	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150209-1	D	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2150209-2	D	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150209-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.87 mm [.113]	F
INSUL	3.86 mm [.152]	OV
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION
TERMINAL NAME: CLIP 6.35 SECURITE		
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE
4.50-5.50 mm [.177-.217 IN]		∅2.20-3.35 mm [.087-.132 IN]
TERMINAL APPLICATION SPECIFICATION	CUSTOMER DRAWING 1544504	
TERMINALS APPLIED		
TE TERMINAL	TE TERMINAL	TE TERMINAL
1544504-1	1544504-2	1544504-3

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
3.00mm <sup>2</sup>	2.40+/-0.05 [.094+/-0.002]	3.6
2.50mm <sup>2</sup>	2.20+/-0.05 [.087+/-0.002]	5.6
2.00mm <sup>2</sup>	1.95+/-0.05 [.077+/-0.002]	8.6
1.50mm <sup>2</sup>	1.90+/-0.05 [.075+/-0.002]	9.0

- △ 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 ITEM 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.
- 5. 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.

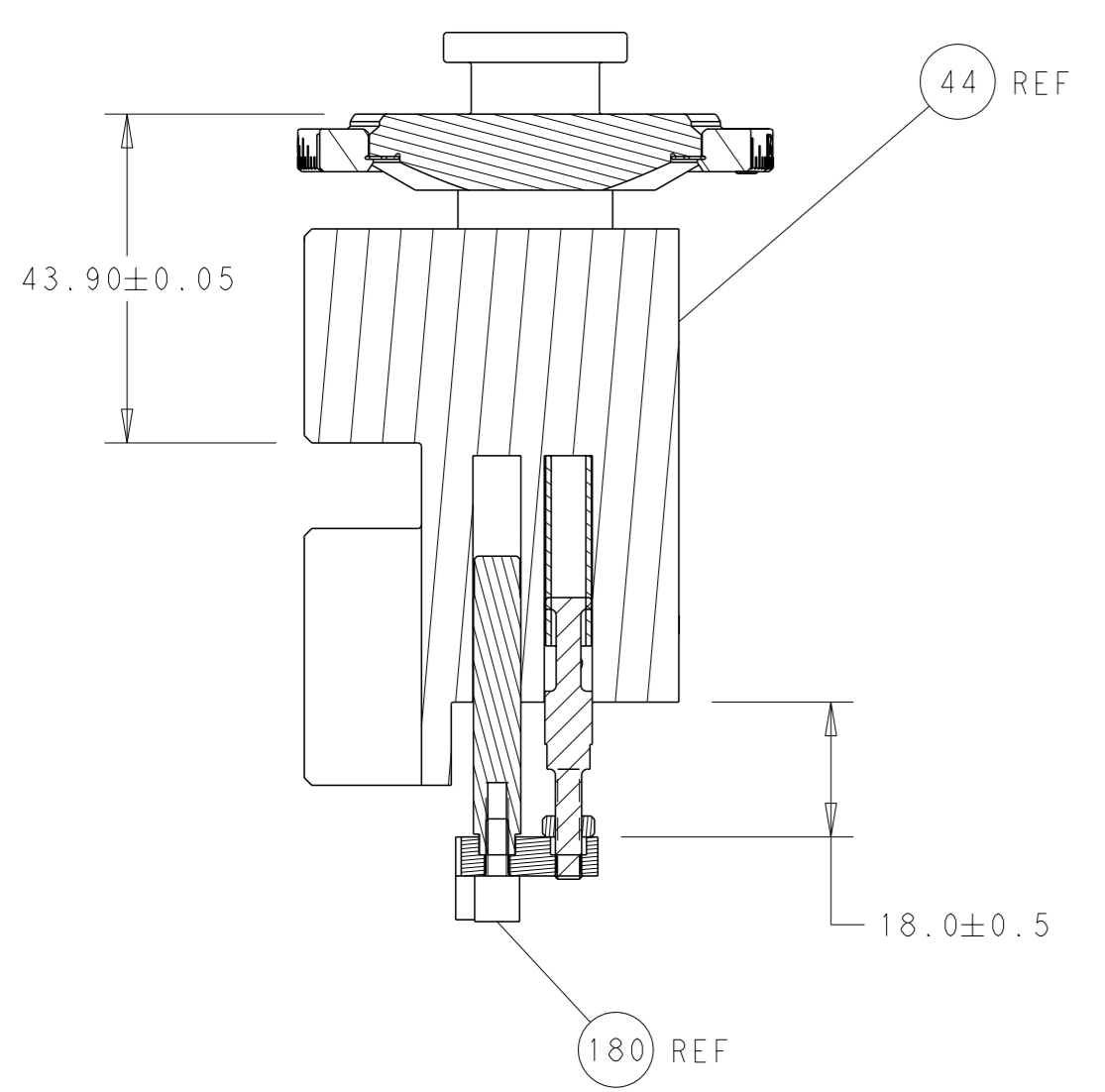
**ATLANTIC VERSION**  
Shown on sheets 1 of 4 & 2 of 4  
(Pacific version shown on sheets 3 of 4 & 4 of 4)

LOC	DIST	REVISIONS					
		#	LY#	DESCRIPTION	DATE	OWN	APVD
A	66	A		RELEASED	04NOV2014	MR	TE
		B		ECR-16-008801	20JUN2016	MZ	JDG
		C		ECR-17-013255	08SEP2017	TB	TE
		D		ECR-20-007220	20MAY2020	LG	RR

-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248	
-	1	1	1	1	2119082-4	CAM, SNAIL, INSULATION ADJUSTMENT	244	
-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243	
△	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242	
-	-	1	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239	
-	1	-	1	-	2844940-3	AIR FEED MODULE	238	
-	1	1	1	1	1-18028-0	WASHER, FLAT, REG M8	192	
△	1	1	1	1	1752354-9	STANDOFF, HOLD-DOWN	180	
-	1	1	1	1	6-993111-6	PIN, SLOTTED SPRING 3.0 X 14.0	177	
-	1	1	1	1	8-22280-7	SPRING, COMPRESSION	176	
-	1	1	1	1	1752353-2	GUIDE PIN, HOLDDOWN	175	
-	1	1	1	1	1901680-2	GUIDE PIN, HOLDDOWN	174	
-	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164	
-	1	1	1	1	455888-4	SPACER, CRIMPER	82	
-	1	1	1	1	1803607-4	DOCUMENTATION PACKAGE	71	
-	2	2	2	2	2-18032-2	SCR, SET, FLT PNT, M3 X 10.0	70	
-	1	1	1	1	2119740-1	TAG, IDENTIFICATION	67	
-	2	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66	
-	1	1	1	1	1901681-1	HOLDDOWN, TERMINAL	65	
-	1	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	60	
-	1	1	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59	
-	-	1	-	1	2063961-1	FEED FINGER	58	
-	4	4	4	4	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57	
-	2	2	2	2	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	56	
-	2	2	2	2	5018030-1	NUT, HEX, REG, RoHS, M3	54	
-	2	2	2	2	986965-8	NUT, LOCK, HEX, TORQUE (M4)	53	
-	1	1	1	1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52	
-	1	-	1	-	2063961-1	FEED FINGER	51	
-	1	2	1	2	18023-9	SCR, SKT HD CAP M4 X 6.0	49	
-	-	1	-	1	2119652-1	FEED CAM, PRE FEED	48	
-	-	1	-	1	2119653-1	FEED CAM, POST FEED	47	
-	1	1	1	1	2119655-5	APPLICATOR BASIC ASSEMBLY, EF	46	
-	1	1	1	1	1803517-1	RAM ASSEMBLY, EF ATLANTIC	44	
-	1	1	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41	
-	8	8	8	8	1-18028-2	WASHER, FLAT, REG M4	33	
-	2	2	2	2	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	31	
-	2	2	2	2	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	29	
-	1	1	1	1	240639-1	STRIPPER (MACHINING)	27	
-	2	2	2	2	1-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 30	25	
-	1	1	1	1	1-1752371-2	PLATE, STRIP GUIDE	24	
-	2	2	2	2	2-22281-3	SPRING, COMPRESSION	22	
-	1	1	1	1	1803292-4	DRAG	20	
-	2	2	2	2	1901259-6	GUIDE, LOWER STRIP	18	
-	4	4	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17	
-	1	1	1	1	1752360-1	SPACER, HOLD-DOWN	13	
△	1	1	1	1	240644-5	PLATE, REAR SHEAR	11	
-	-	-	-	-	-	-	10	
△	1	1	1	1	7-690482-5	PLATE, FRONT SHEAR	9	
△	1	2	2	1	1-1803074-0	ANVIL, COMBINATION, END FEED	8	
△	1	1	1	1	2217206-4	BLADE, SLUG	7	
-	-	-	-	-	-	-	6	
-	1	1	1	1	6-240641-8	SPACER	5	
-	1	1	1	1	238011-4	BLOCK, CRIMPER SPACER	4	
△	1	2	2	1	2-1633963-6	CRIMPER, INSULATION OVERLAP PREMIUM	3	
-	1	1	1	1	455888-6	SPACER, CRIMPER	2	
△	1	2	2	1	7-1633738-1	CRIMPER, WIRE	1	
-	77	72	71	2	-1	PART NO	DESCRIPTION	ITEM NO

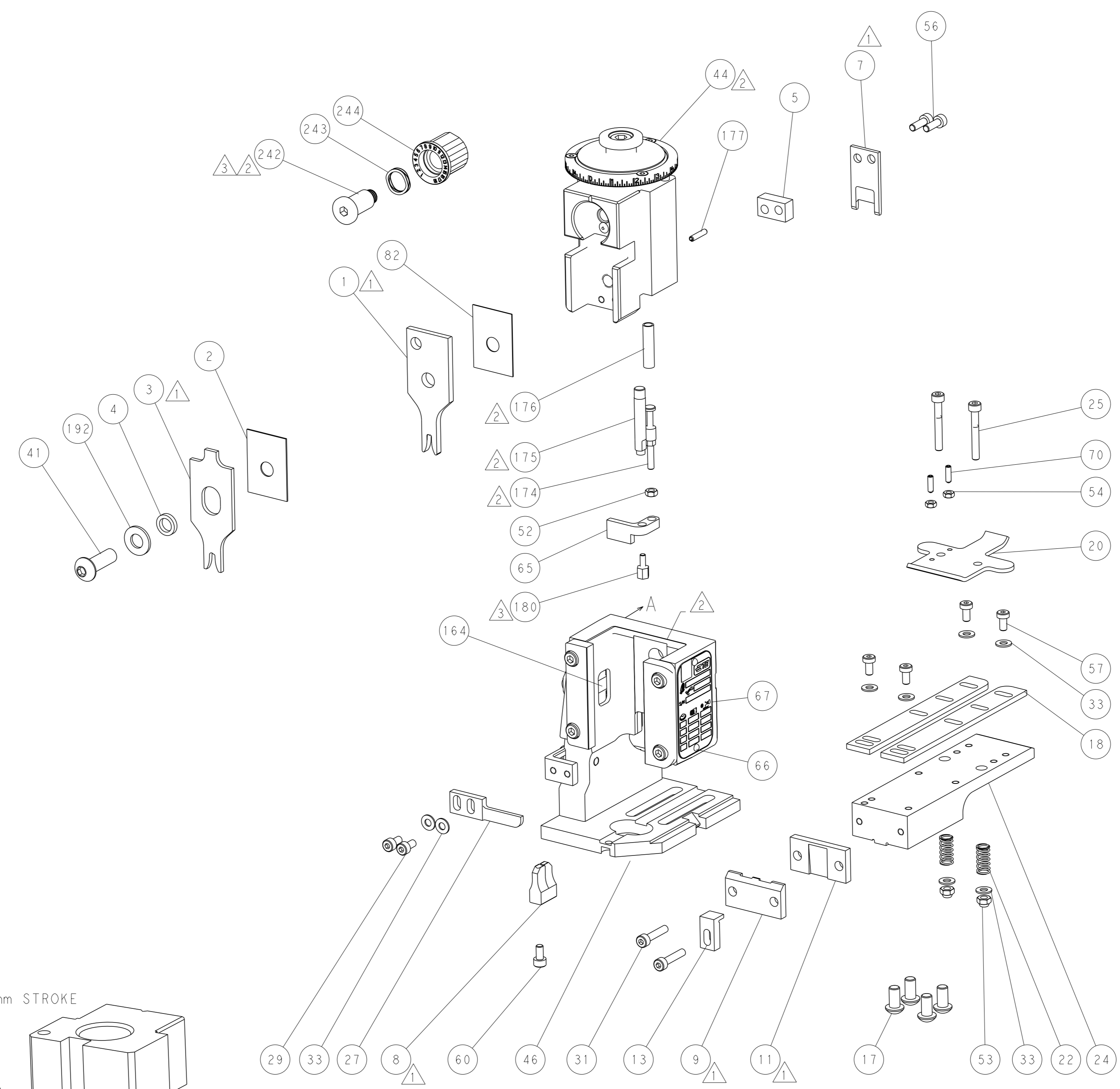
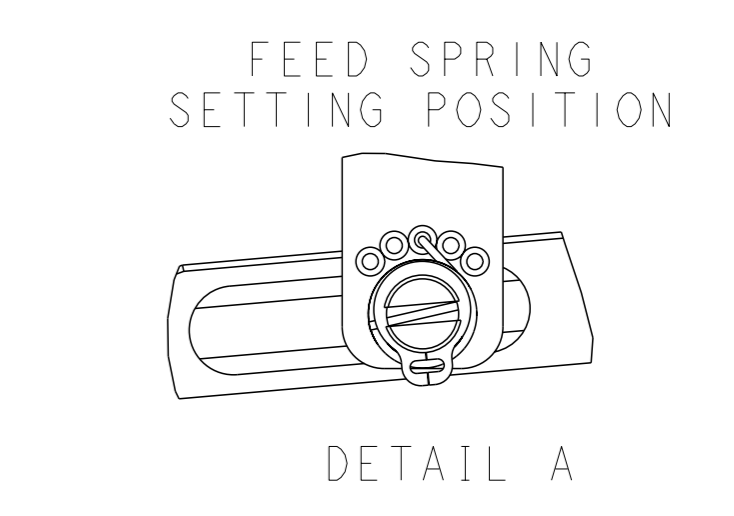
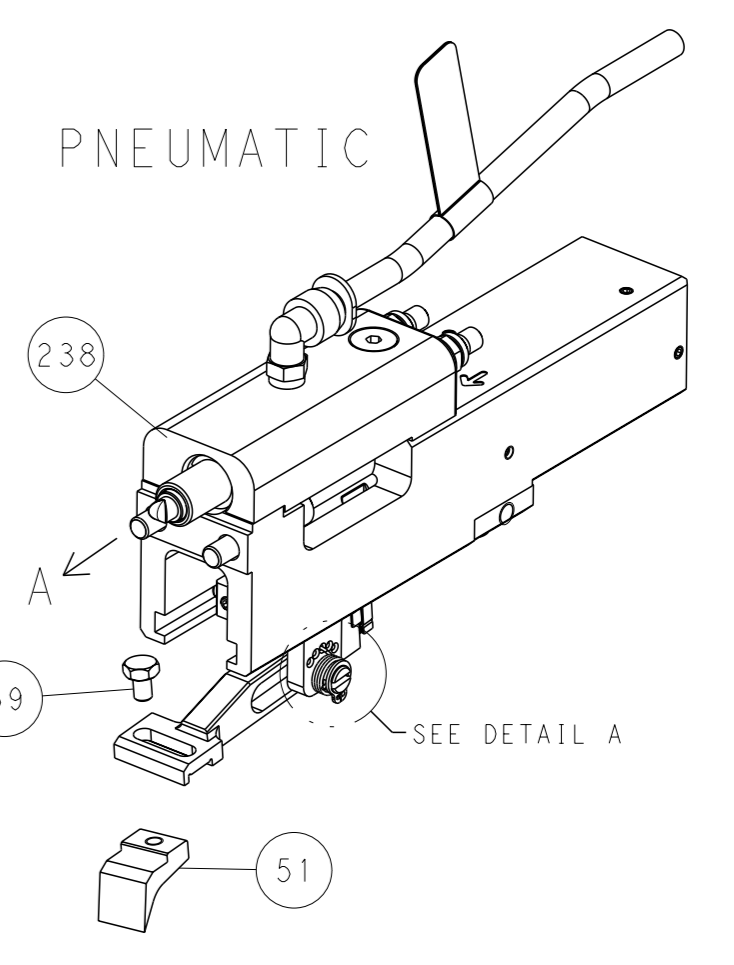
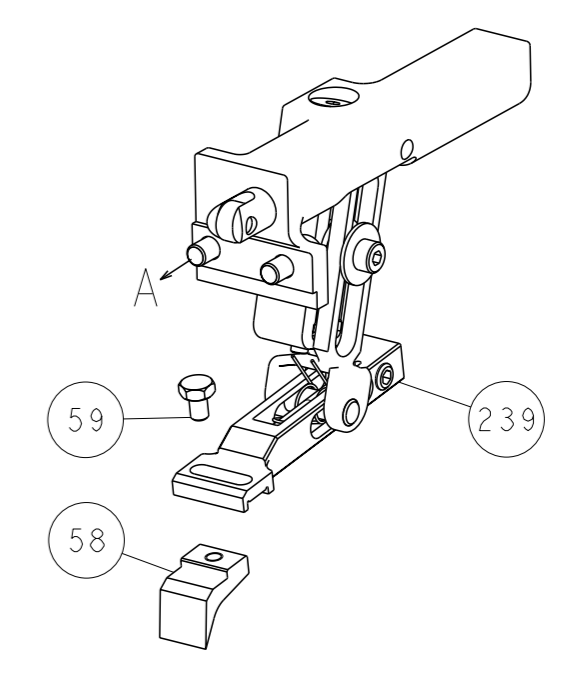
DIMENSIONS: 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH ±		DWN BOB HIGMAN 07AUG2014 CHK G. BAILEY 07AUG2014 APVD G. BAILEY 07AUG2014 PRODUCT SPEC APPLICATION SPEC MATERIAL:		NAME: Ocean End Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2150209 SCALE: 1:1 SHEET: 1 of 4 REV: D	
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LOC	DIST	REVISIONS			
A	66	REV	DATE	OWN	APVD
		1	SEE SHEET 1		

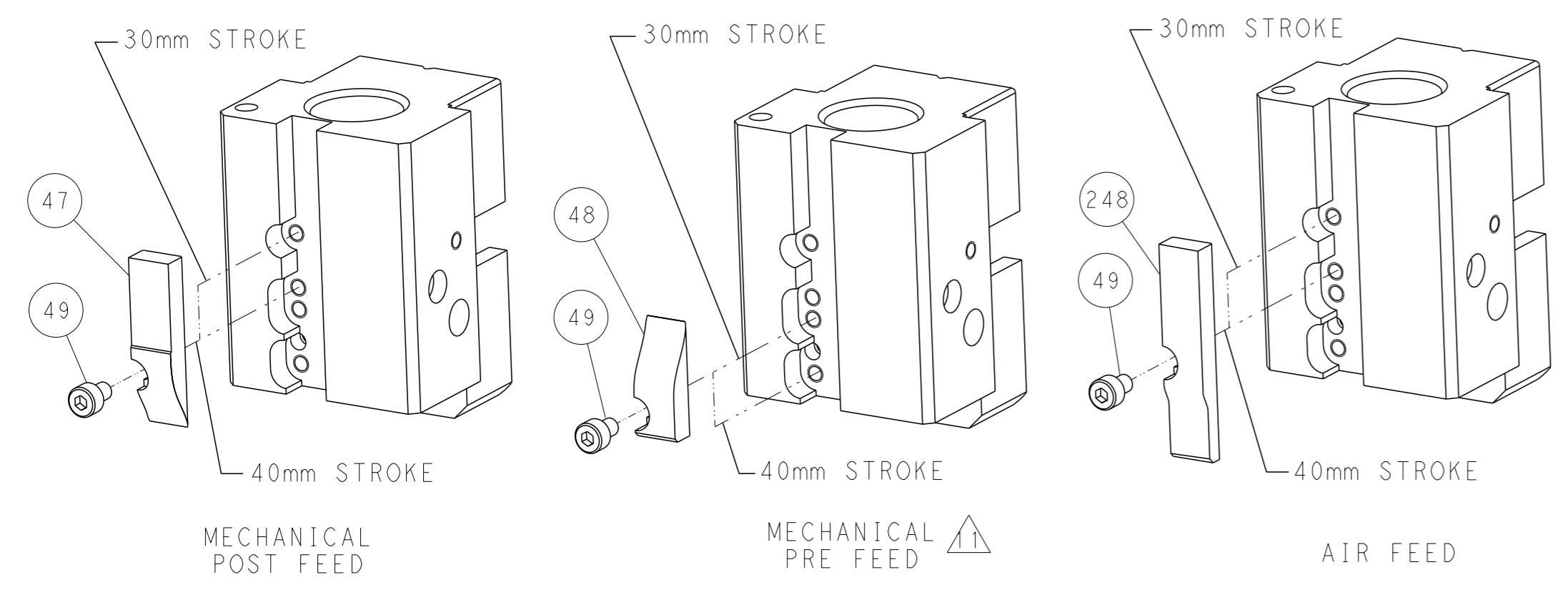


RAM AND HOLDDOWN SET-UP

# FEED TYPE MECHANICAL



# CAM POSITIONS

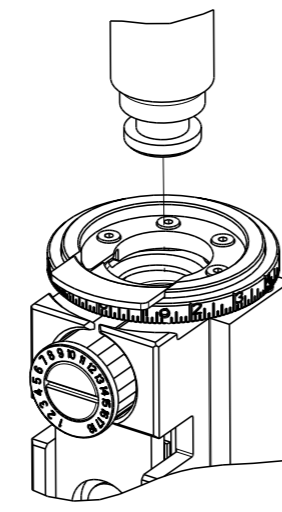


**ATLANTIC VERSION**  
 Shown on sheets 1 of 4 & 2 of 4  
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

<small>THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.</small>		OWN: BOB HIGMAN 07AUG2014 CHK: G. BAILEY 07AUG2014 APVD: G. BAILEY 07AUG2014	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: 2150209 SHEET 2 OF 4	RESTRICTED TO: - REV: D

THIS DRAWING IS UNPUBLISHED.	RELEASED FOR PUBLICATION	20	
COPYRIGHT 20 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.			
PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150209-1	D	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2150209-2	D	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150209-7	A	CRIMP TOOLING KIT	-

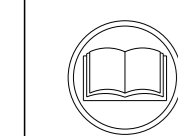
PACIFIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.87 mm [.113]	F
INSUL	3.86 mm [.152]	OV
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: CLIP 6.35 SECURITE			
WIRE STRIP LENGTH 4.50-5.50 mm [.177-.217 IN]		INSULATION DIAMETER RANGE Ø2.20-3.35 mm [.087-.132 IN]	
TERMINAL APPLICATION SPECIFICATION		CUSTOMER DRAWING 1544504	
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
1544504-1	1544504-2	1544504-3	

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
3.00mm2	2.40 +/- 0.05 [.094 +/- .002]	3.6
2.50mm2	2.20 +/- 0.05 [.087 +/- .002]	5.6
2.00mm2	1.95 +/- 0.05 [.077 +/- .002]	8.6
1.50mm2	1.90 +/- 0.05 [.075 +/- .002]	9.0



- 1 RECOMMENDED SPARE PARTS
- 2 REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- 3 APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 180. APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242.
- 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. 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.

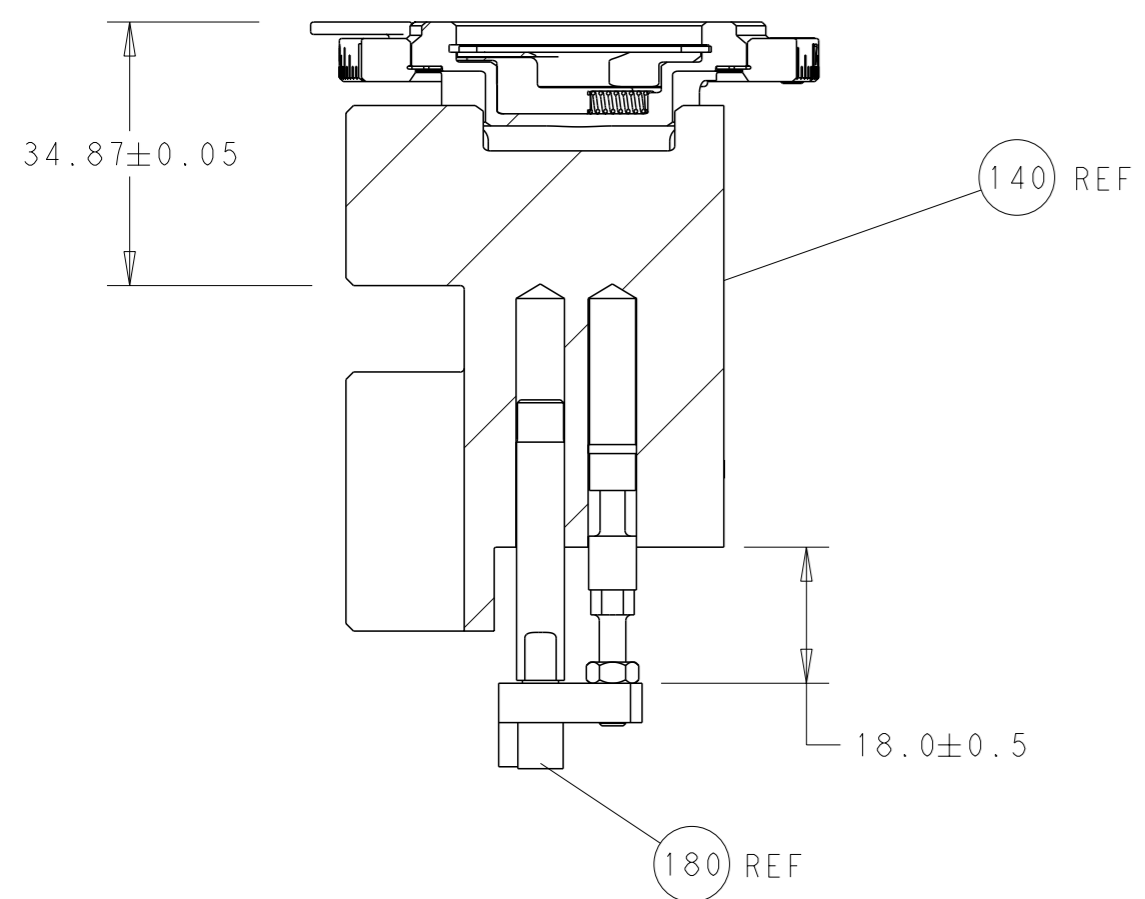
**PACIFIC VERSION**  
Shown on sheets 3 of 4 & 4 of 4  
(Atlantic version shown on sheets 1 of 4 & 2 of 4)

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

3	-	1	1	2119082-4	CAM, SNAIL, INSULATION ADJUSTMENT	244
	-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
	-	1	1	2119083-1	RETAINER, INSULATION DIAL	242
	-	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
	-	1	-	2844940-3	AIR FEED MODULE	238
	-	1	1	1-18028-0	WASHER, FLAT, REG M8	192
	-	4	4	2079383-9	SCR, BHSC, RoHS (M6 X 20)	186
3	-	1	1	1752354-9	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	-	2119641-2	FEED CAM, AIR FEED	152
	-	1	1	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	144
	-	-	1	2119653-2	FEED CAM, POST FEED	142
	-	1	1	2119655-6	APPLICATOR BASIC ASSEMBLY, EF	141
	-	1	1	1803518-1	RAM ASSEMBLY, EF PACIFIC	140
	-	1	1	455888-4	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	1901681-1	HOLDDOWN, TERMINAL	65
	-	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
	-	-	1	2063961-1	FEED FINGER	58
	-	4	4	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	-	2063961-1	FEED FINGER	51
	-	1	2	18023-9	SCR, SKT HD CAP M4 X 6.0	49
	-	-	1	2119652-1	FEED CAM, PRE FEED	48
	-	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
	-	8	8	1-18028-2	WASHER, FLAT, REG M4	33
	-	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	240639-1	STRIPPER (MACHINING)	27
	-	2	2	1-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 30	25
	-	1	1	1-1752371-2	PLATE, STRIP GUIDE	24
	-	2	2	2-22281-3	SPRING, COMPRESSION	22
	-	1	1	1803292-4	DRAG	20
	-	2	2	1901259-6	GUIDE, LOWER STRIP	18
	-	1	1	1752360-1	SPACER, HOLD-DOWN	13
1	-	1	1	240644-5	PLATE, REAR SHEAR	11
	-	-	-	-	-	10
1	-	1	1	7-690482-5	PLATE, FRONT SHEAR	9
1	1	1	1	1-1803074-0	ANVIL, COMBINATION, END FEED	8
1	-	1	1	2217206-4	BLADE, SLUG	7
	-	-	-	-	-	6
	-	1	1	6-240641-8	SPACER	5
	-	1	1	238011-4	BLOCK, CRIMPER SPACER	4
1	1	1	1	2-1633963-6	CRIMPER, INSULATION OVERLAP PREMIUM	3
	-	1	1	455888-6	SPACER, CRIMPER	2
1	1	1	1	7-1633738-1	CRIMPER, WIRE	1
	-	77-22-21		PART NO	DESCRIPTION	ITEM NO

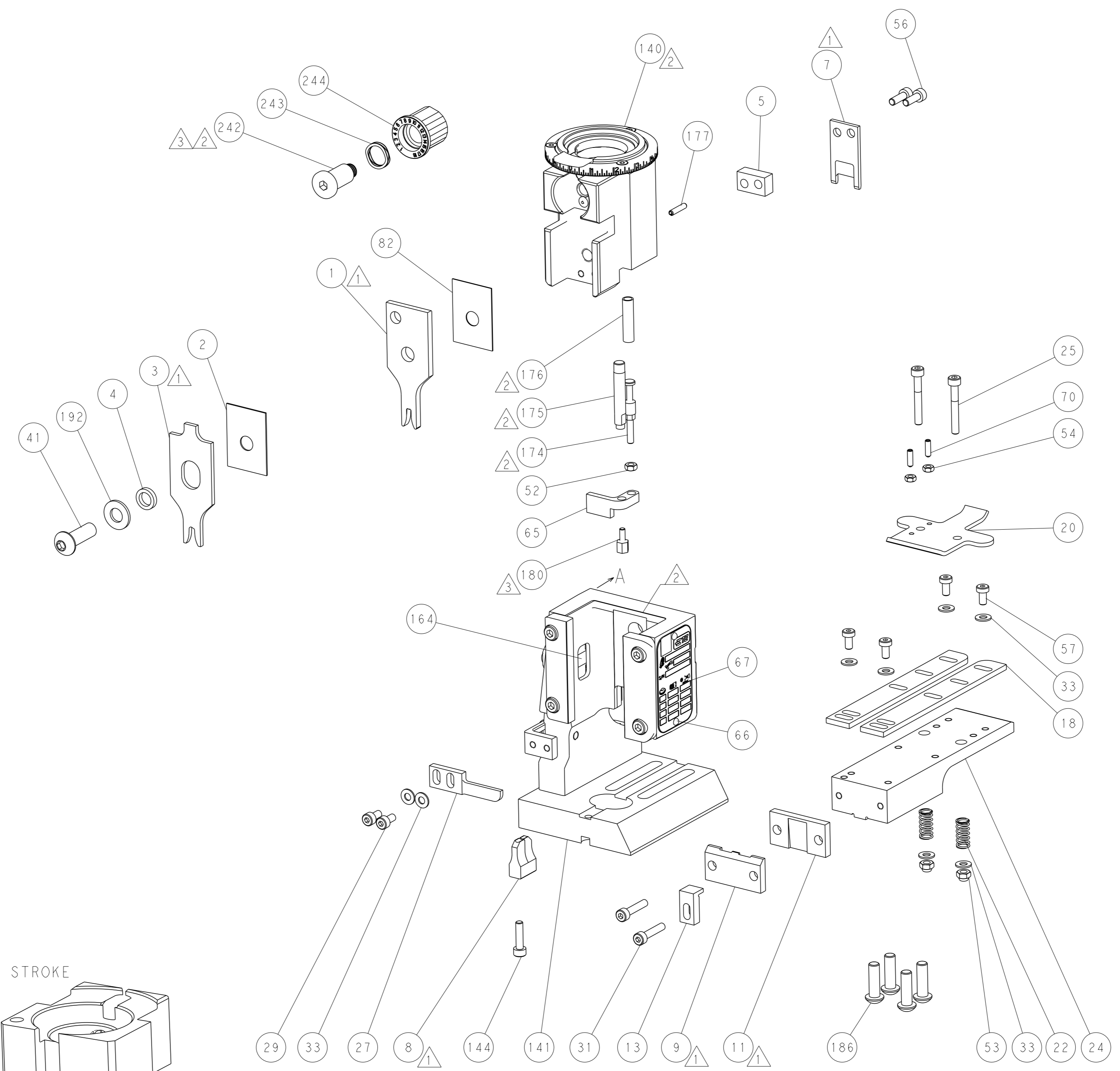
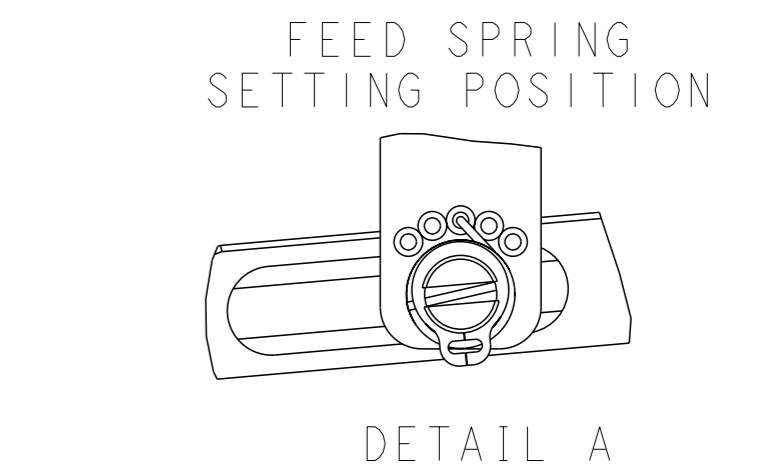
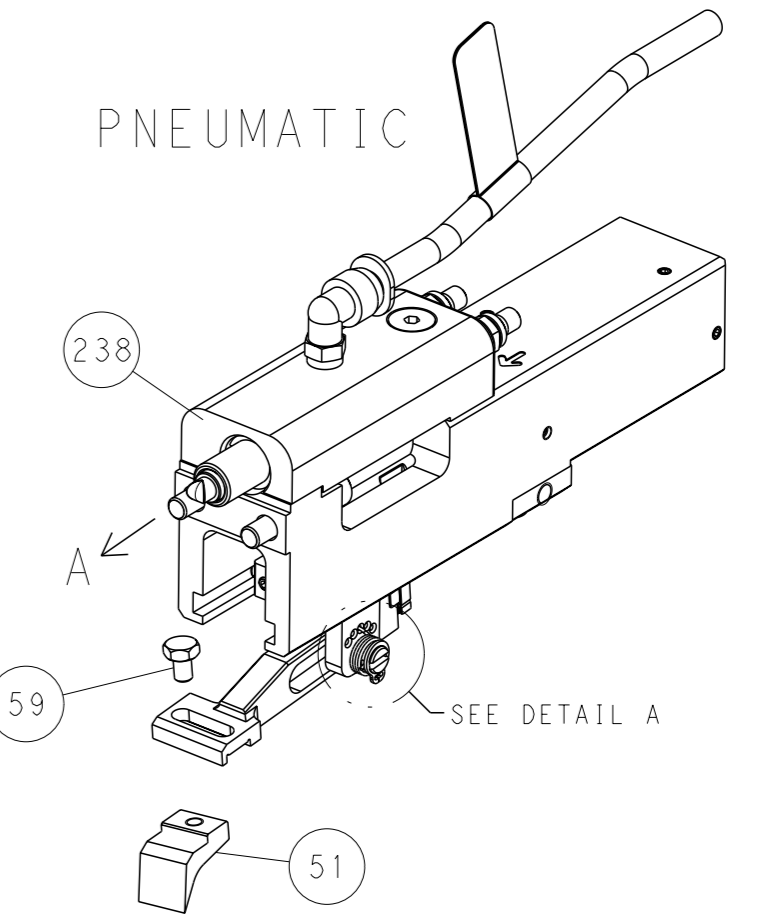
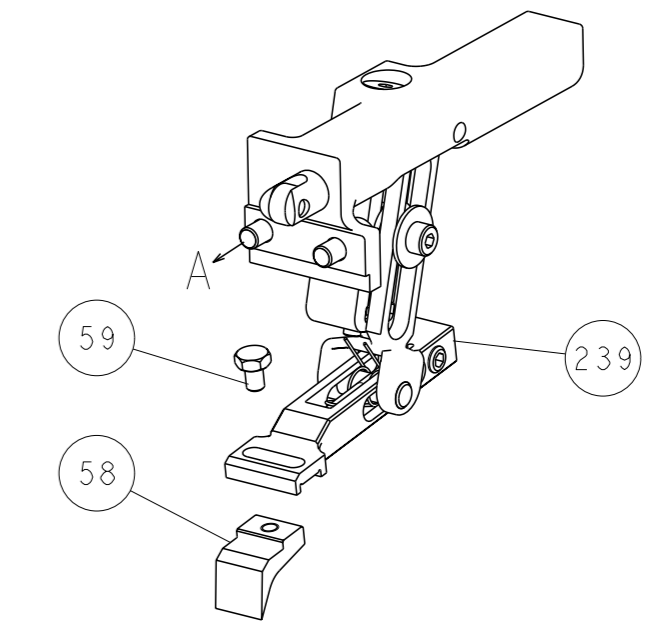
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		OWN: BOB HIGMAN 07AUG2014		TE Connectivity Harrisburg, PA 17105-3608	
0 PLC ±		1 PLC ±		CHK: G. BAILEY 07AUG2014		NAME: Ocean End Feed Applicator	
2 PLC ±		3 PLC ±		APVD: G. BAILEY 07AUG2014		SIZE: A1	
4 PLC ±		ANGLES FINISH		PRODUCT SPEC		CAGE CODE: 00779	
MATERIAL		WEIGHT		DRAWING NO: 2150209		RESTRICTED TO	
				Customer Accessible Production Drawing		SCALE: 1:1 SHEET 3 OF 4 REV D	

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

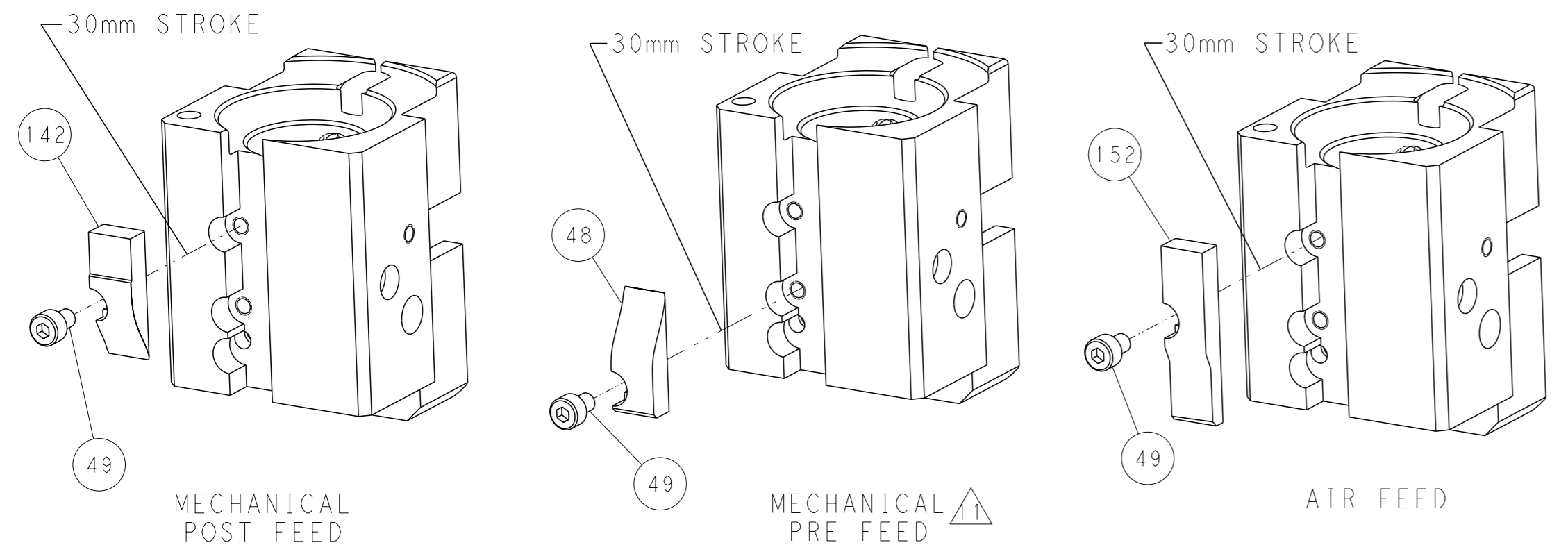


RAM AND HOLDDOWN SET-UP

FEED TYPE  
MECHANICAL



CAM POSITIONS



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:		OWN: BOB HIGMAN 07AUG2014		NAME: STE TE Connectivity	
mm		0 PLC ±		CHK: G. BAILEY 07AUG2014		Harrisburg, PA 17105-3608	
HOLE		1 PLC ±		APVD: G. BAILEY 07AUG2014		PRODUCT SPEC	
MATERIAL:		2 PLC ±		APPLICATION SPEC		SIZE: CAGE CODE DRAWING NO. RESTRICTED TO	
FINISH:		3 PLC ±		WEIGHT		A   00779 C=2150209	
		4 PLC ±		Customer Accessible Production Drawing		SCALE: 1:1 SHEET 4 OF 4 REV D	
		ANGLES					
		FINISH					