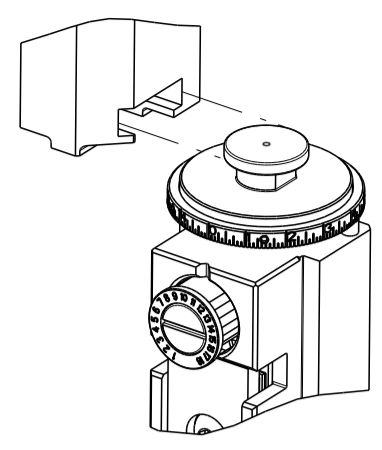


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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150377-2	F	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150377-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR  
 INTERFACE ADAPTER



APPLICATOR DATA

CRIMP	SIZE	TYPE
WIRE	2.29 mm [.090]	F
INSUL	4.06 mm [.160]	F

APPL INSTRUCTIONS  
 408-35043

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION

TERMINAL NAME	WIRE STRIP LENGTH	INSULATION DIAMETER RANGE
TAB MIC MK II	3.50-4.50 mm [.138-.177 IN]	$\varnothing$ 2.16-3.43 mm [.085-.135 IN]
TERMINAL APPLICATION SPECIFICATION	114-5072	-

TERMINALS APPLIED

TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
172777-1	172777-2	172777-3	172777-4

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
14 AWG OR 2.00mm <sup>2</sup>	1.78+/-0.05 [.070+/- .002]	4.4
16 AWG OR 1.25mm <sup>2</sup>	1.50+/-0.05 [.059+/- .002]	7.3
0.5+0.85mm <sup>2</sup> OR 20+18 AWG	1.50+/-0.05 [.059+/- .002]	7.4
0.5+0.5mm <sup>2</sup> OR 20+20 AWG	1.50+/-0.05 [.059+/- .002]	7.2
18AWG OR 0.85mm <sup>2</sup> OR 0.75mm <sup>2</sup>	1.34+/-0.05 [.053+/- .002]	9.2
20 AWG OR 0.50mm <sup>2</sup>	1.30+/-0.05 [.051+/- .002]	9.4

- RECOMMENDED SPARE PARTS
- REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION & 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.
- TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT 101-35000.
- TERMINAL LUBRICANT IS RECOMMENDED.

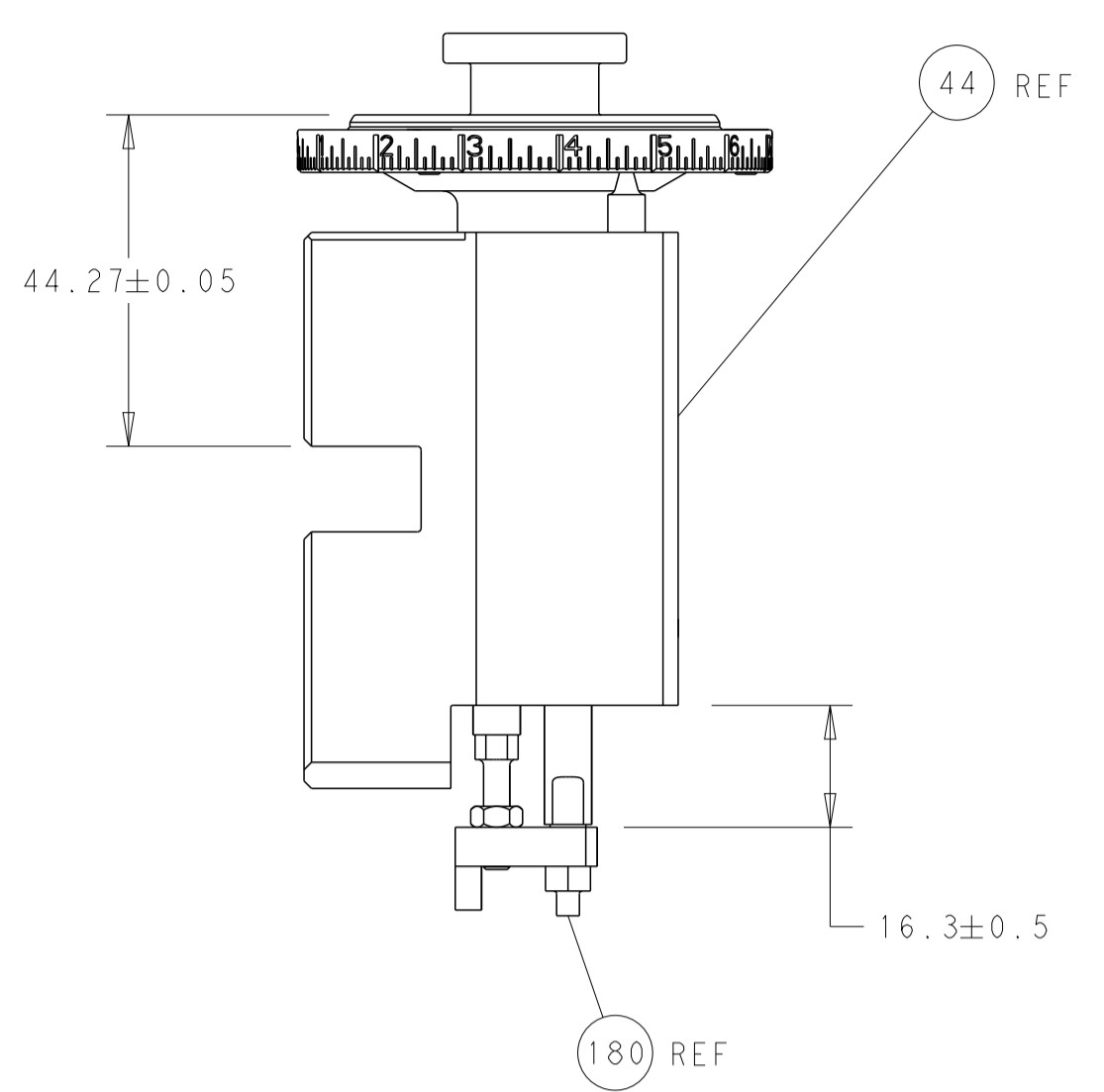
**\*WARNING**  
 ON INSTALLATION, SET WIRE DISC TO CRIMP HEIGHT REFERENCE SETTING FOR LARGEST WIRE SIZE. CRIMP HEIGHT REFERENCE SETTINGS GREATER THAN THE VALUE SHOWN MAY CAUSE DAMAGE TO THE CRIMP TOOLING, REFER TO THE INSTRUCTION SHEET FOR PROPER SETUP AND ADJUSTMENTS.

LOC	DIST	REVISIONS					
A	66	P	LTN	DESCRIPTION	DATE	DWN	APVD
-	-	D	-	ECR-19-009276	12JUN2019	LG	TE
-	-	E	-	ECR-20-003244	04MAR2020	JAH	GB
-	-	E1	-	ECR-22-159636	28NOV2022	FZ	JAH
-	-	F	-	ECR-24-204092	27MAR2024	SS	MINI

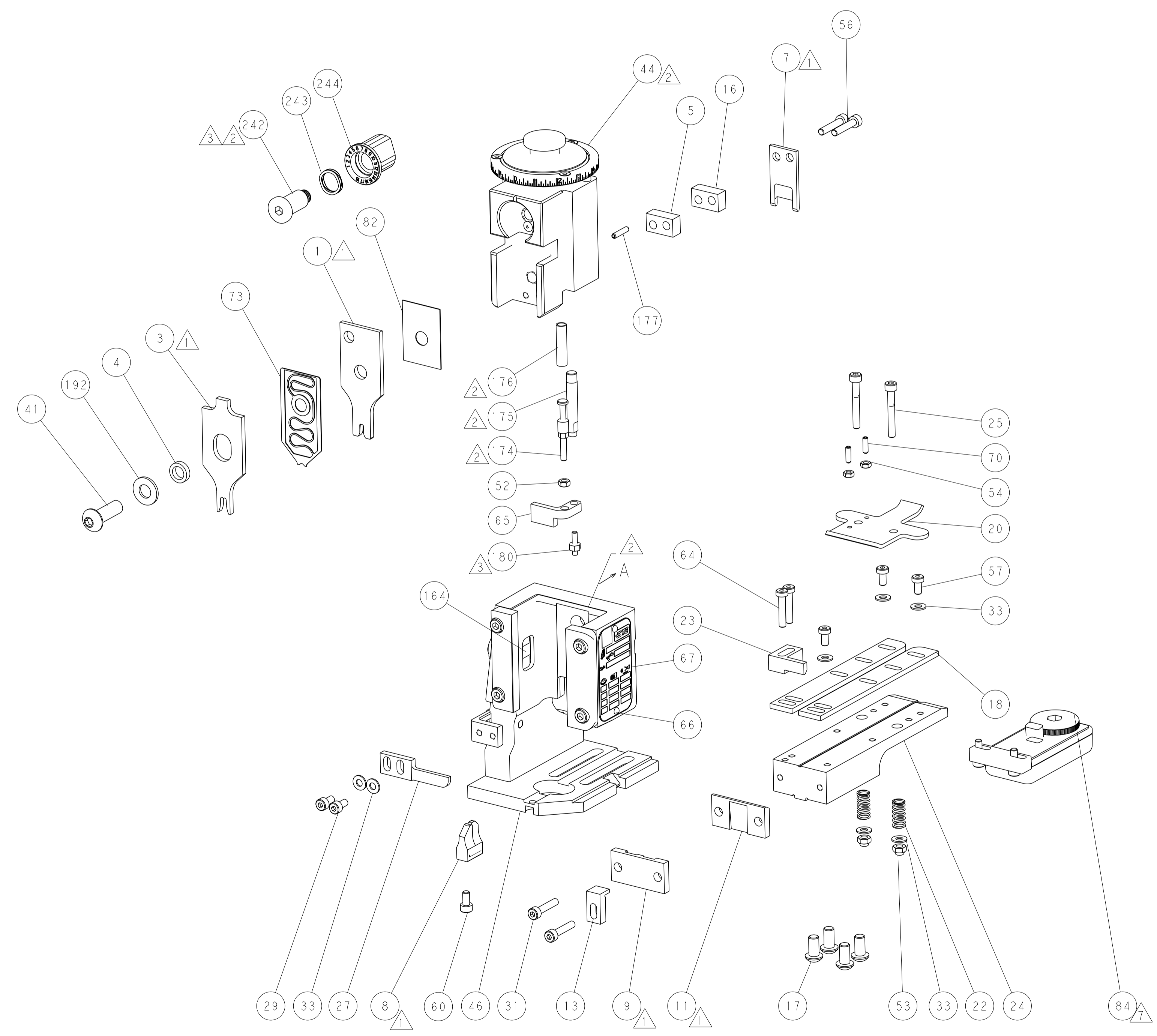
-	1	2119641-1	FEED CAM, AIR FEED	248
-	1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
3	-	2119083-1	RETAINER, INSULATION DIAL	242
-	1	2844940-4	AIR FEED MODULE	238
-	1	1-18028-0	WASHER, FLAT, REG M8	192
3	-	1-1976055-1	STANDOFF, HOLD-DOWN	180
-	1	6-993111-6	PIN, SLOTTED SPRING 3.0 X 14.0	177
-	1	8-22280-7	SPRING, COMPRESSION	176
-	1	1752353-2	GUIDE PIN, HOLDDOWN	175
-	1	1901680-2	GUIDE PIN, HOLDDOWN	174
-	REF	994970-2	COUNTER, MAGNETIC	164
7	-	2119955-2	ASSY, LUBRICATOR, END FEED	84
-	1	455888-4	SPACER, CRIMPER -	82
-	1	2119791-9	DEPRESSOR, WIRE	73
-	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	1901681-1	HOLDDOWN, TERMINAL	65
-	2	2168400-5	SHCS, LOW HEAD, RoHS, M4 X 20	64
-	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	60
-	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	3	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57
-	2	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	56
-	2	5018030-1	NUT, HEX, REG, RoHS, M3	54
-	2	986965-8	NUT, LOCK, HEX, TORQUE (M4)	53
-	1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52
-	1	2063961-1	FEED FINGER	51
-	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	1	2119655-5	APPLICATOR BASIC ASSEMBLY, EF	46
-	1	1803517-1	RAM ASSEMBLY, EF ATLANTIC	44
-	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
-	7	1-18028-2	WASHER, FLAT, REG M4	33
-	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	240639-1	STRIPPER (MACHINING)	27
-	2	1-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 30	25
-	1	1752371-8	PLATE, STRIP GUIDE	24
-	1	240825-6	PLATE, STRIP HOLD DOWN	23
-	2	2-22281-3	SPRING, COMPRESSION	22
-	1	1803292-4	DRAG	20
-	2	1901259-6	GUIDE, LOWER STRIP	18
-	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17
-	1	6-240641-8	SPACER	16
-	1	1752360-1	SPACER, HOLD-DOWN	13
1	-	240833-1	PLATE, REAR SHEAR	11
-	-	-	-	10
1	-	690482-5	PLATE, FRONT SHEAR	9
1	1	1-1333217-3	ANVIL, EF .090	8
1	-	2217206-7	BLADE, SLUG	7
-	-	-	-	6
-	1	6-240641-8	SPACER	5
-	1	238011-2	BLOCK, CRIMPER SPACER	4
1	1	7-1633961-6	CRIMPER, INSULATION F PREMIUM	3
-	-	-	-	2
1	1	4-456406-7	CRIMPER, WIRE PREMIUM	1
-	-	-	-	0
-	-	-	-	0

DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC $\pm$ 1 PLC $\pm$ 2 PLC $\pm$ 3 PLC $\pm$ 4 PLC $\pm$ ANGLES $\pm$ FINISH		DWN G. GROSS 04OCT2013 G. BAILEY 04OCT2013 M. CLIFFORD 04OCT2013		NAME Ocean End Feed Applicator	
MATERIAL -		FINISH -		WEIGHT -		SIZE CAGE CODE DRAWING NO A   00779 C=2150377	
Customer Accessible Production Drawing				SCALE 1:1		SHEET 1 OF 4 REV F	

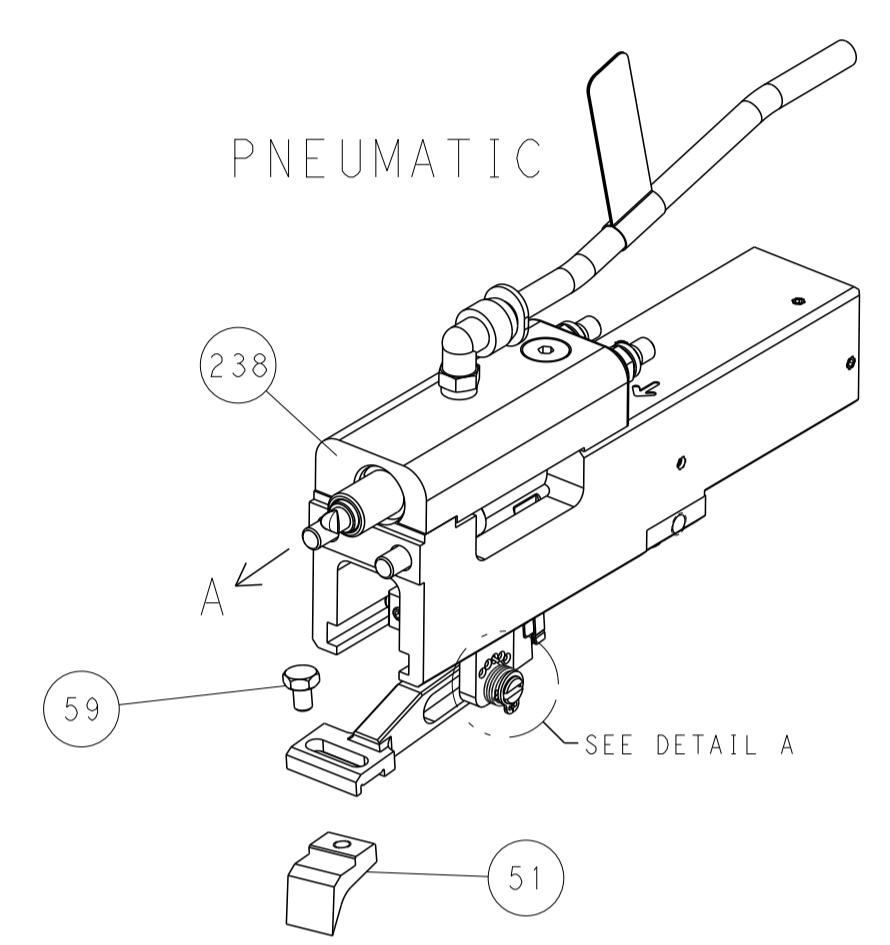
LOC	DIST	REVISIONS					
A	66	P	LTH	DESCRIPTION	DATE	DWN	APVD
		-		SEE SHEET 1			



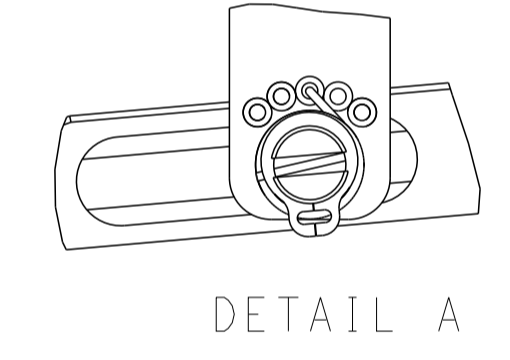
RAM AND HOLDDOWN SET-UP



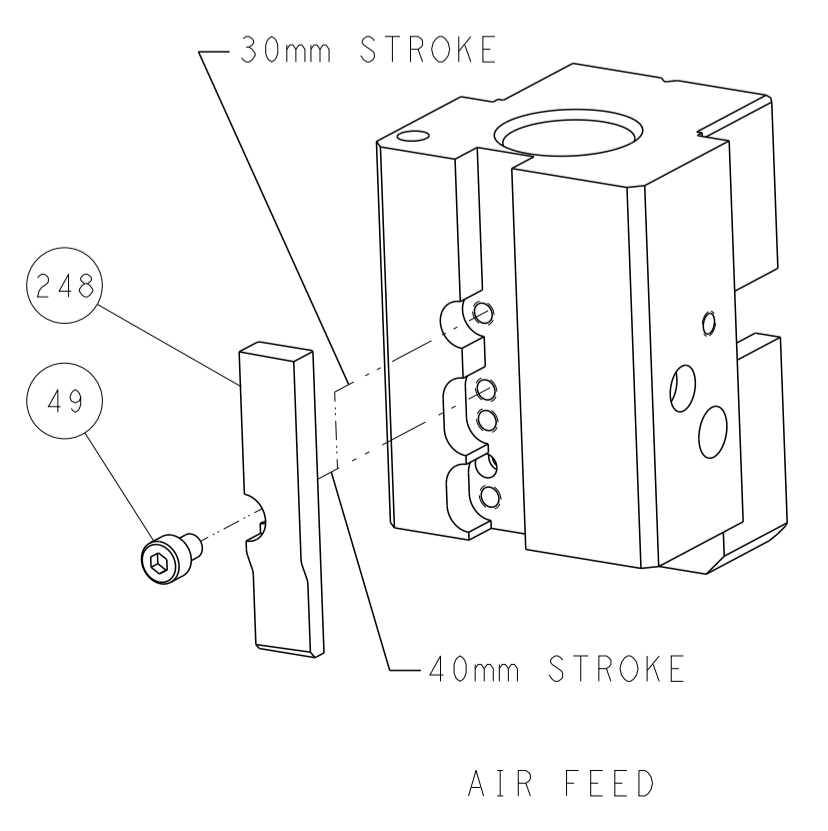
FEED TYPE



FEED SPRING SETTING POSITION



CAM POSITION



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DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± MATERIAL - FINISH -		NAME Ocean End Feed Applicator APPLICATION SPEC - SIZE CAGE CODE DRAWING NO. A1 00779 C=2150377 WEIGHT - SCALE 1:1 SHEET 2 OF 4 REV F	RESTRICTED TO -