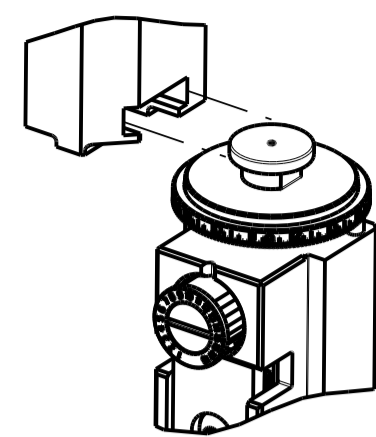


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150472-2	L	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150472-2	L	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150472-7	K	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	6.35 mm [.250]	F
INSUL	9.53 mm [.375]	F
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION			
TERMINAL NAME: RING TONGUE			
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE		
5.18-5.94 mm [.204-.234 IN]	Ø5.59-8.00 mm [.220-.315 IN]		
TERMINAL APPLICATION SPECIFICATION	114-2084		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
42899-1	42913-1	61352-1	
42899-2	42913-2	61352-2	
42899-3	42913-3		

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION			
TERMINAL NAME: RING TONGUE			
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE		
5.18-5.94 mm [.204-.234 IN]	Ø5.59-8.00 mm [.220-.315 IN]		
TERMINAL APPLICATION SPECIFICATION	114-2084		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
41808	41808-1	41809	41809-1

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING	RAM SET-UP DIM ± 0.05
6 AWG	4.85 +/- 0.05 [.191 +/- .002]	4.7	41.74
8 AWG	4.22 +/- 0.05 [.166 +/- .002]	11.7	41.74
10 AWG	3.81 +/- 0.05 [.150 +/- .002]	9.8	42.36

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING	RAM SET-UP DIM ± 0.05
8 AWG	4.57 +/- 0.05 [.180 +/- .002]	5.7	41.74
10 AWG	4.24 +/- 0.05 [.167 +/- .002]	9.3	41.74

- 1. RECOMMENDED SPARE PARTS
- 2. REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- 3. 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. TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- 6. SEE CHART FOR RAM SET-UP DIMENSION.
- 7. TERMINAL LUBRICANT IS RECOMMENDED.
- 8. 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.

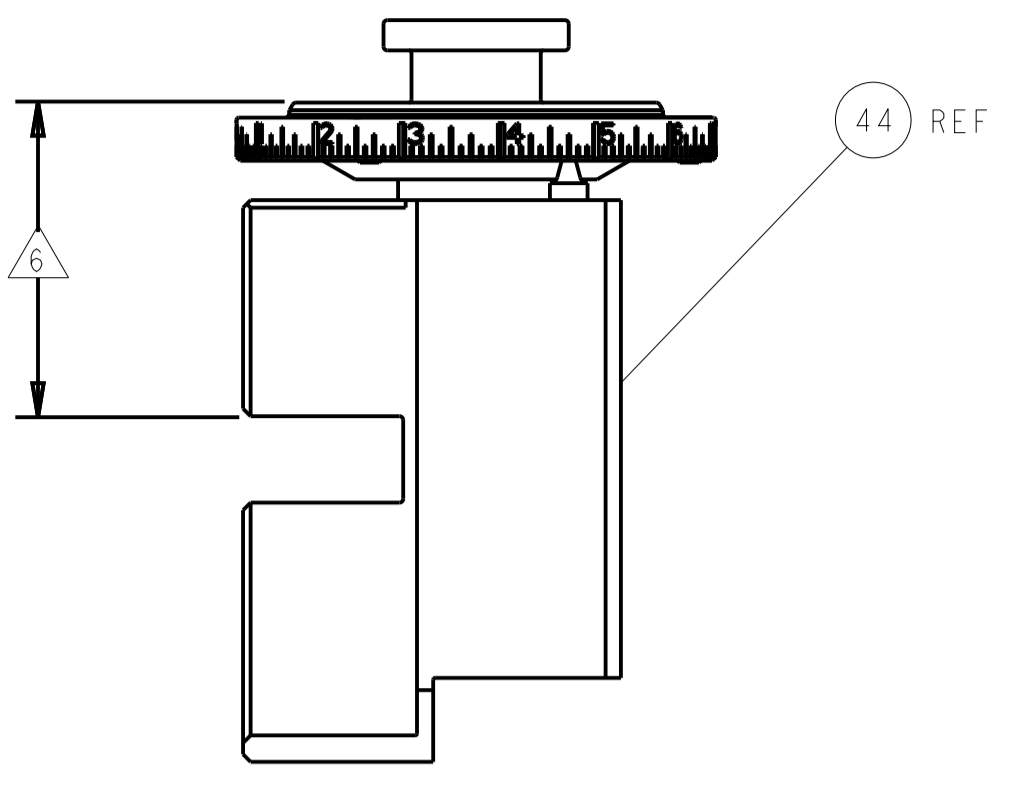
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

LOC	DIST	REV	LTN	DESCRIPTION	DATE	OWN	APPV
A	66	H		ECR-18-015370	28SEP2018	JAH	CT
		J		ECR-19-009276	12JUN2019	LG	TE
		K		ECR-19-016825	29OCT2019	TB	TE
		L		ECR-21-006111	08JUN2021	FJ	RK

-	1	1	2119641-1	FEED CAM, AIR FEED	248	
-	1	1	2119082-6	CAM, SNAIL, INSULATION ADJUSTMENT	244	
-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243	
3	-	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	1	2844940-4	AIR FEED MODULE	238	
-	1	1	1803071-1	SPACER, REAR SHEAR STRIP GUIDE	196	
-	REF	REF	994970-2	COUNTER, MAGNETIC	164	
7	-	1	1	2119955-2	ASSY, LUBRICATOR, END FEED	84
-	1	1	1-455888-1	SPACER, CRIMPER	82	
-	2	2	1-2119791-4	DEPRESSOR, WIRE	73	
-	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	
-	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	
-	4	4	2168400-1	SHCS, LOW HEAD, RoHS, M4 X 12	57	
-	2	2	2-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 14	56	
-	2	2	5018030-1	NUT, HEX, REG, RoHS, M3	54	
-	2	2	986965-8	NUT, LOCK, HEX, TORQUE (M4)	53	
-	1	1	2063961-1	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	1803602-2	SCR, BHSC, RoHS (M8 X 40)	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	2280534-1	STRIPPER, OFFSET	27	
-	2	2	1-2168083-7	SCR, SKT HD CAP, RoHS, M4 X 40	25	
-	1	1	2-1752371-9	PLATE, STRIP GUIDE	24	
-	2	2	2-22281-1	SPRING, COMPRESSION	22	
-	1	1	1-464452-7	DRAG, STOCK	21	
-	1	1	1633168-2	ARM, STOCK DRAG	20	
-	1	1	3-1901696-5	STRIP GUIDE, REAR	19	
-	1	1	3-1901695-5	STRIP GUIDE, FRONT	18	
-	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17	
-	1	1	1803203-1	BLOCK, FRONT DEPRESSOR	12	
1	-	1	1	240644-1	PLATE, REAR SHEAR	11
-	2	2	1-240645-2	SPACER, SHEAR PLATE	10	
1	-	1	1	240642-1	PLATE, FRONT SHEAR	9
1	1	2	1	1803003-1	ANVIL, COMBINATION, END FEED	8
1	-	1	1	2-240651-0	BLADE, SLUG	7
-	-	-	-	-	6	
-	1	1	6-240641-0	SPACER	5	
-	1	1	5-238011-4	BLOCK, CRIMPER SPACER	4	
1	1	2	1	9-1803016-3	CRIMPER, INSULATION F	3
-	1	1	1-455888-1	SPACER, CRIMPER	2	
1	1	2	1	456432-3	CRIMPER, WIRE	1
-	77-72	-	2	PART NO	DESCRIPTION	ITEM NO

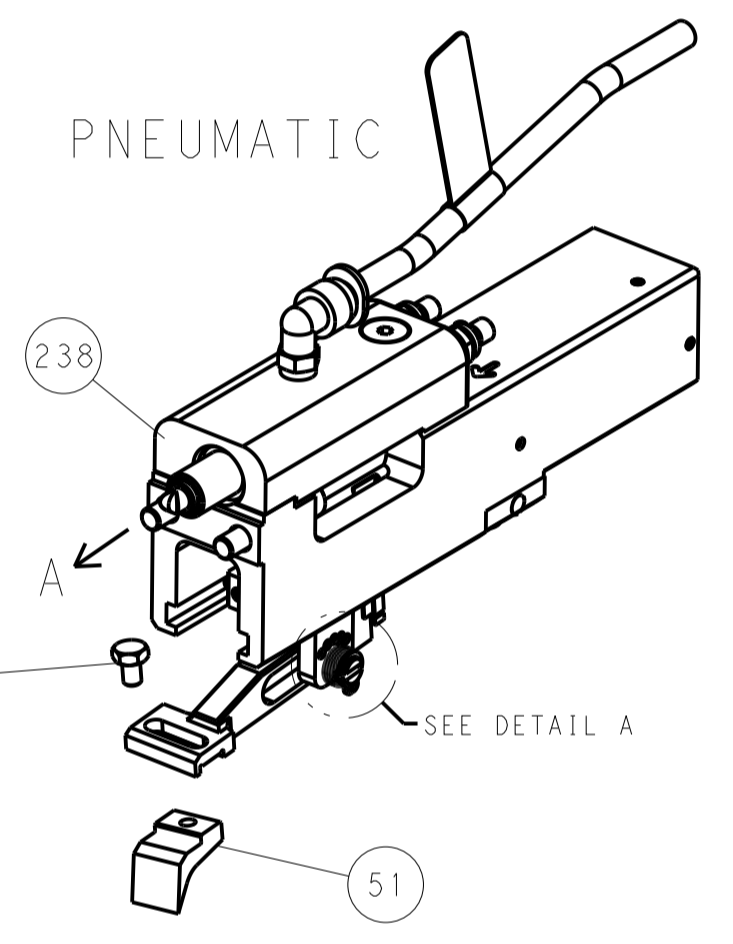
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DRAWING NO	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±
ANGLES	FINISH	WEIGHT	SCALE	SHEET	REV
MATERIAL		Customer Accessible Production Drawing		1 of 4	L

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

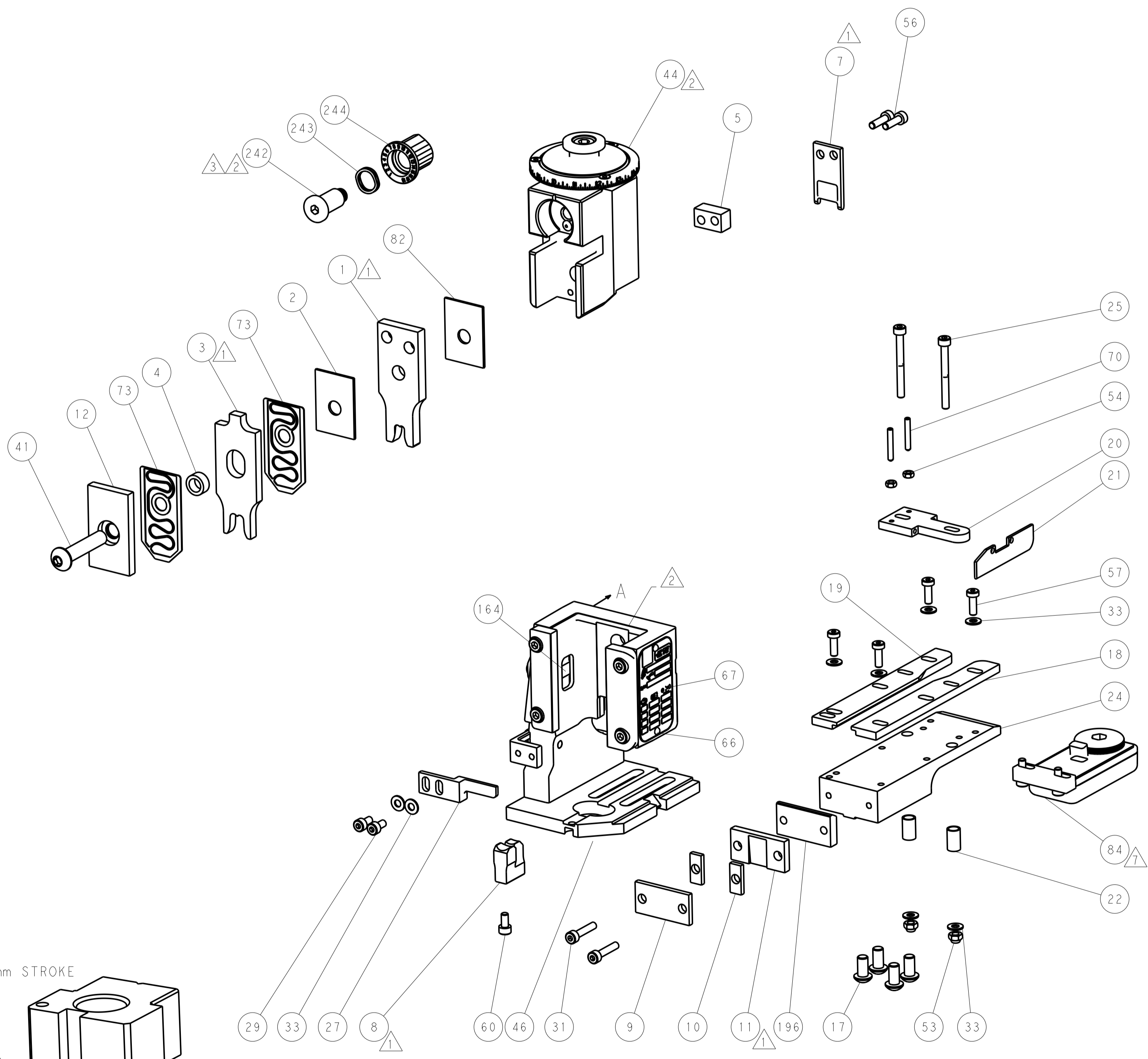
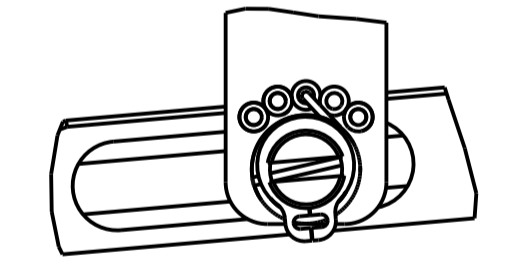


RAM SET-UP

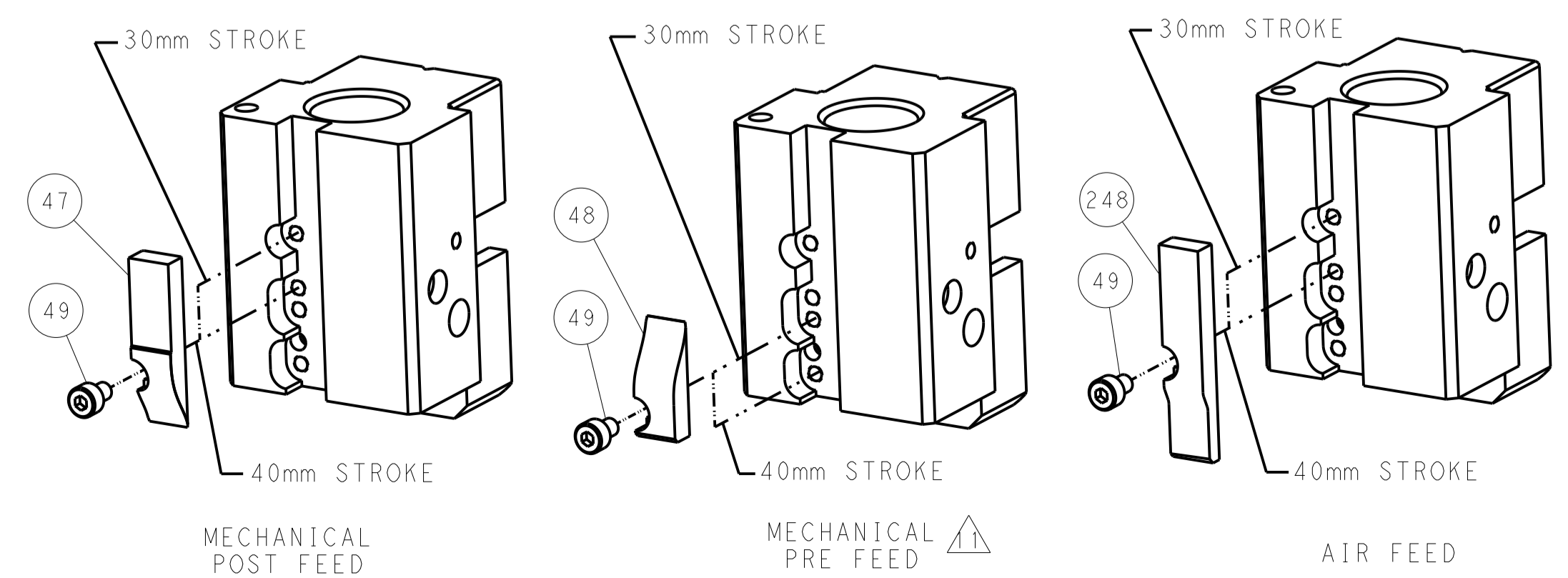
FEED TYPE



FEED SPRING SETTING POSITION



CAM POSITIONS

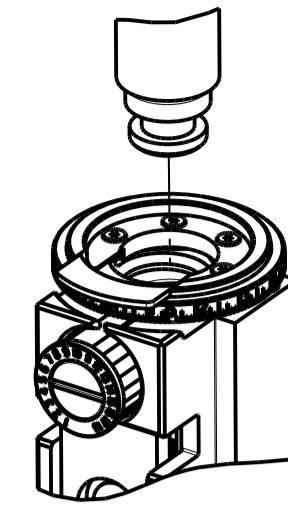


ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN: K. STAKEM 20AUG2014		TE Connectivity	
mm	0 PLC ±	1 PLC ±	2 PLC ±	CHK: G. BAILEY 20AUG2014	NAME: Ocean End Feed Applicator		Harrisburg, PA 17105-3608
MATERIAL:		FINISH:		APVD: T. FIRIN 20AUG2014	SIZE: A11	CAGE CODE: 00779	DRAWING NO: ©=2150472
Customer Accessible Production Drawing				SCALE: 1:1	SHEET: 2 of 4	REV: L	RESTRICTED TO

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150472-2	L	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150472-7	K	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	6.35 mm [.250]	F
INSUL	9.53 mm [.375]	F
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: RING TONGUE			
WIRE STRIP LENGTH 5.18-5.94 mm [.204-.234 IN]		INSULATION DIAMETER RANGE Ø5.59-8.00 mm [.220-.315 IN]	
TERMINAL APPLICATION SPECIFICATION 114-2084			
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
42899-1	42913-1	61352-1	
42899-2	42913-2	61352-2	
42899-3	42913-3		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: RING TONGUE			
WIRE STRIP LENGTH 5.18-5.94 mm [.204-.234 IN]		INSULATION DIAMETER RANGE Ø5.59-8.00 mm [.220-.315 IN]	
TERMINAL APPLICATION SPECIFICATION 114-2084			
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
41808	41808-1	41809	41809-1

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING	RAM SET-UP DIM ± 0.05
6 AWG	4.85 +/- 0.05 [.191 +/- .002]	4.7	32.71
8 AWG	4.22 +/- 0.05 [.166 +/- .002]	11.7	32.71
10 AWG	3.81 +/- 0.05 [.150 +/- .002]	9.8	33.33

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING	RAM SET-UP DIM ± 0.05
8 AWG	4.57 +/- 0.05 [.180 +/- .002]	5.7	32.71
10 AWG	4.24 +/- 0.05 [.167 +/- .002]	9.3	32.71

- 1 RECOMMENDED SPARE PARTS
- 2 REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- 3 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 TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- 6 SEE CHART FOR RAM SET-UP DIMENSION.
- 7 TERMINAL LUBRICANT IS RECOMMENDED.
- 8 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)

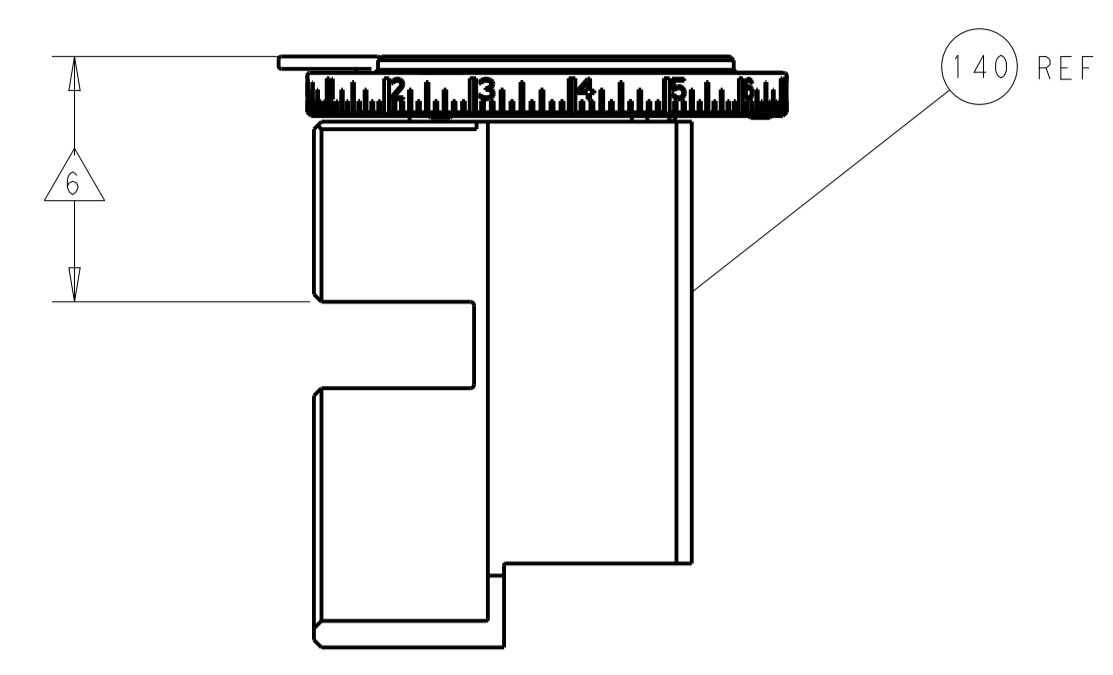
LOC	DIST	REV	DATE	BY	APPV
A	66				

REV	DATE	DESCRIPTION	DATE	BY	APPV
-	1	2119082-6			244
-	1	2079764-1			243
-	1	2119083-1			242
-	1	2844940-4			238
-	1	1803071-1			196
-	4	2079383-9			186
-	REF	994970-2			164
-	1	2119641-2			152
-	1	2168083-8			144
-	1	2119655-6			141
-	1	1803518-2			140
-	1	2119955-2			84
-	1	1-455888-1			82
-	2	1-2119791-4			73
-	1	1803607-4			71
-	2	3-18032-3			70
-	1	2119740-1			67
-	2	2168078-1			66
-	1	5-18022-5			59
-	4	2168400-1			57
-	2	2-2168083-5			56
-	2	5018030-1			54
-	2	986965-8			53
-	1	2063961-1			51
-	1	18023-9			49
-	1	1803602-2			41
-	8	1-18028-2			33
-	2	2168083-9			31
-	2	2168083-2			29
-	1	2280534-1			27
-	2	1-2168083-7			25
-	1	2-1752371-9			24
-	2	2-22281-1			22
-	1	1-464452-7			21
-	1	1633168-2			20
-	1	3-1901696-5			19
-	1	3-1901695-5			18
-	1	1803203-1			12
-	1	240644-1			11
-	2	1-240645-2			10
-	1	240642-1			9
-	1	1803003-1			8
-	1	2-240651-0			7
-	-	-			6
-	1	6-240641-0			5
-	1	5-238011-4			4
-	1	9-1803016-3			3
-	1	1-455888-1			2
-	1	456432-3			1

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		MATERIAL:		FINISH:	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES	FINISH

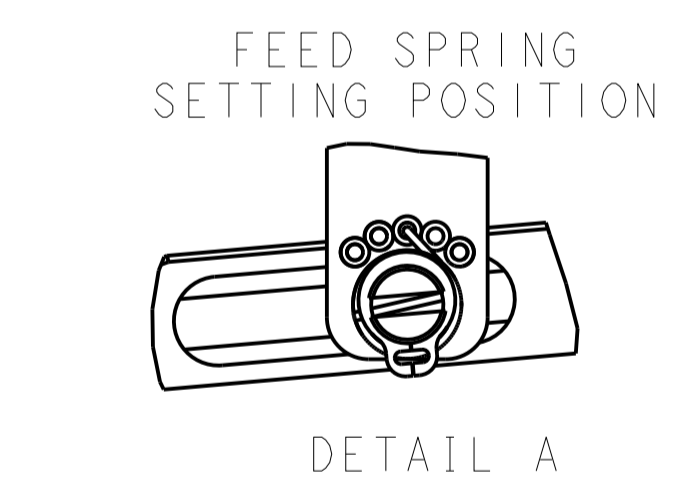
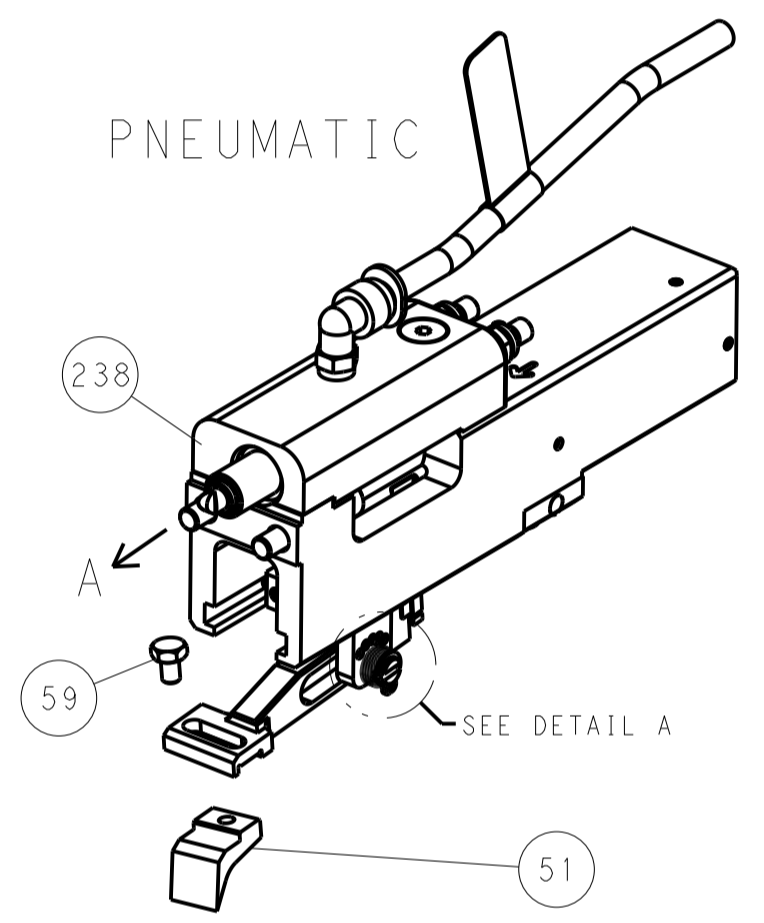
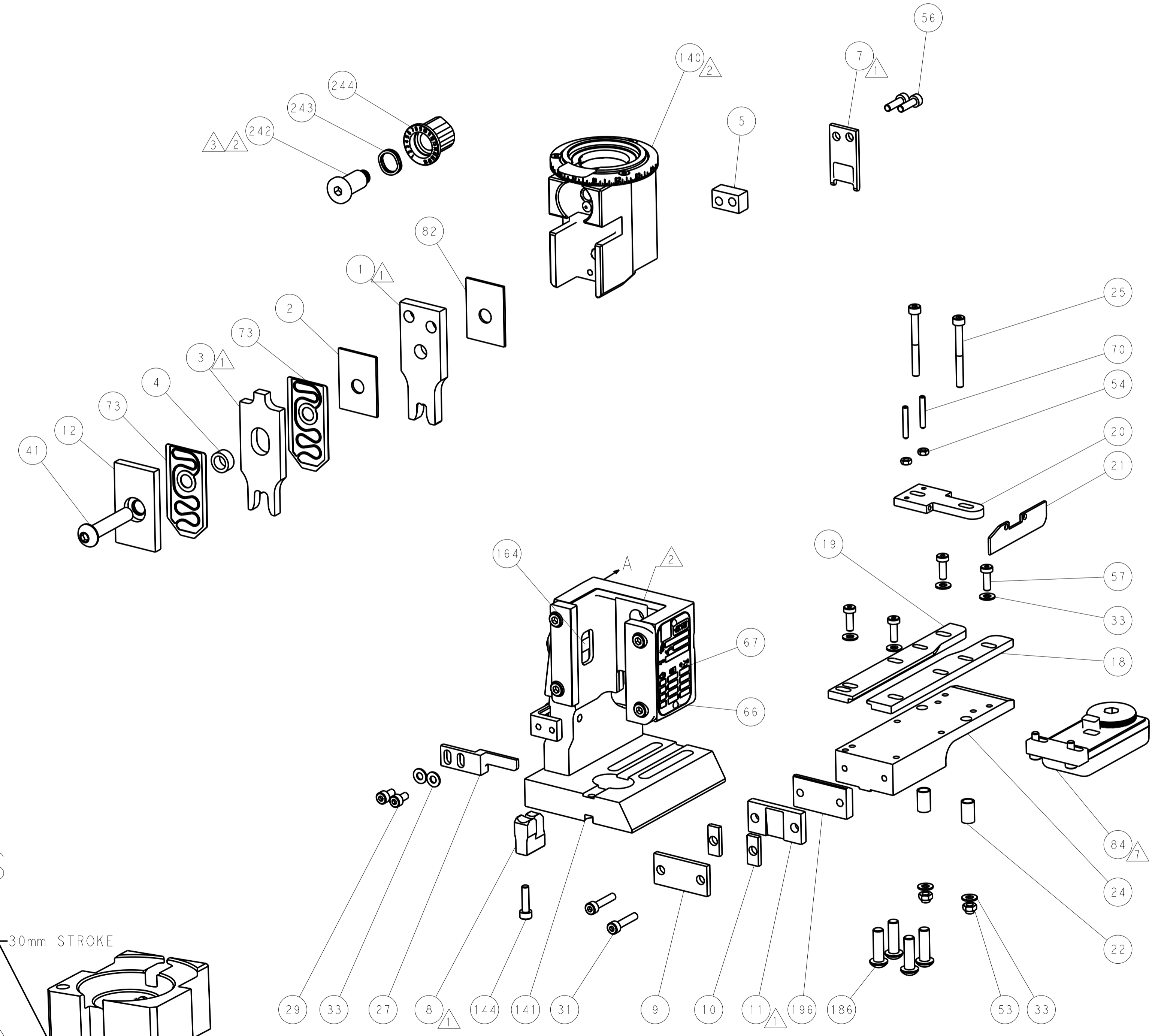
CHK	DATE	APPV	DATE	NAME	SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
OWN	20AUG2014	OWN	20AUG2014	TE Connectivity				
CHK	20AUG2014	CHK	20AUG2014	Harrisburg, PA 17105-3608				
APPV	20AUG2014	APPV	20AUG2014	Ocean End Feed Applicator				

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

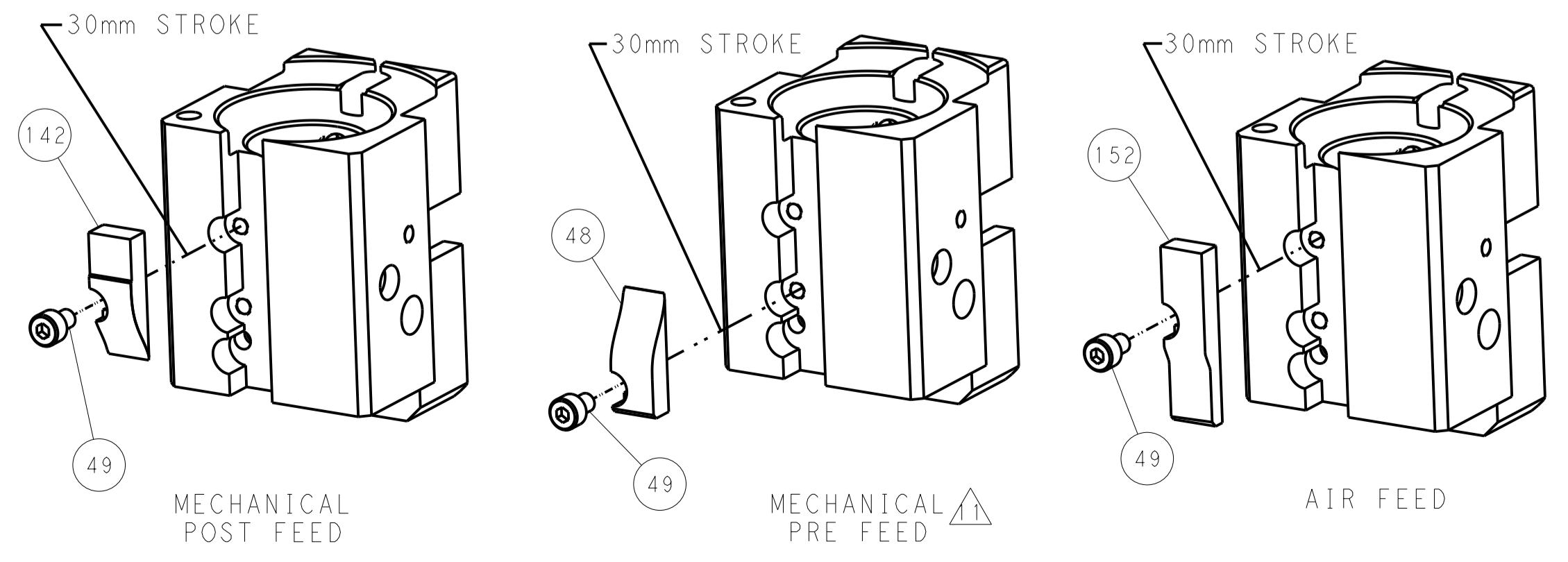


FEED TYPE

RAM SET-UP



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:		DWG: R. STAKEM 20AUG2014		STE TE Connectivity	
mm	0 PLC	±		CHK: G. BAILEY 20AUG2014	NAME: Ocean End Feed Applier		Harrisburg, PA 17105-3608
	1 PLC	±		APPV: T. FIRIN 20AUG2014	RESTRICTED TO:		
	2 PLC	±		PRODUCT SPEC:			
	3 PLC	±		APPLICATION SPEC:			
	4 PLC	±		WEIGHT:			
	ANGLES	±		SCALE: 1:1			
MATERIAL:	FINISH:			A 00779 ©=2150472		SHEET 4 OF 4 REV	
				Customer Accessible Production Drawing			