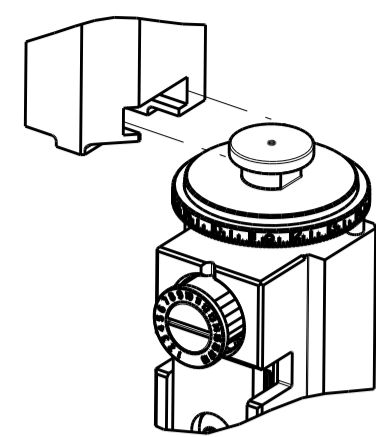


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150523-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150523-2	B	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150523-7	A	CRIMP TOOLING KIT	-

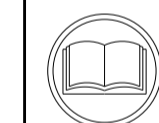
ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	4.32 mm [.170]	F
INSUL	7.62 mm [.300]	F
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: YAZAKI TERMINAL YAZAKI CRIMP SPECIFICATION			
TERMINAL NAME: TERMINAL, FEMALE			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
5.00-6.00 mm [.197-.236 IN]		∅3.60-4.90 mm [.142-.193 IN]	
TERMINAL APPLICATION SPECIFICATION		Rev 7116-3060-02	
TERMINALS APPLIED			
TE TERMINAL	YAZAKI TERMINAL	TE TERMINAL	YAZAKI TERMINAL
1572718-1	7116-3060-02	1572718-2	7116-3060

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
10 AWG OR 5.00mm ²	2.30+/-0.05 [.091+/-0.002]	4.0
12 AWG OR 3.00mm ²	2.00+/-0.05 [.079+/-0.002]	7.3



- 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.
- TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.

***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.

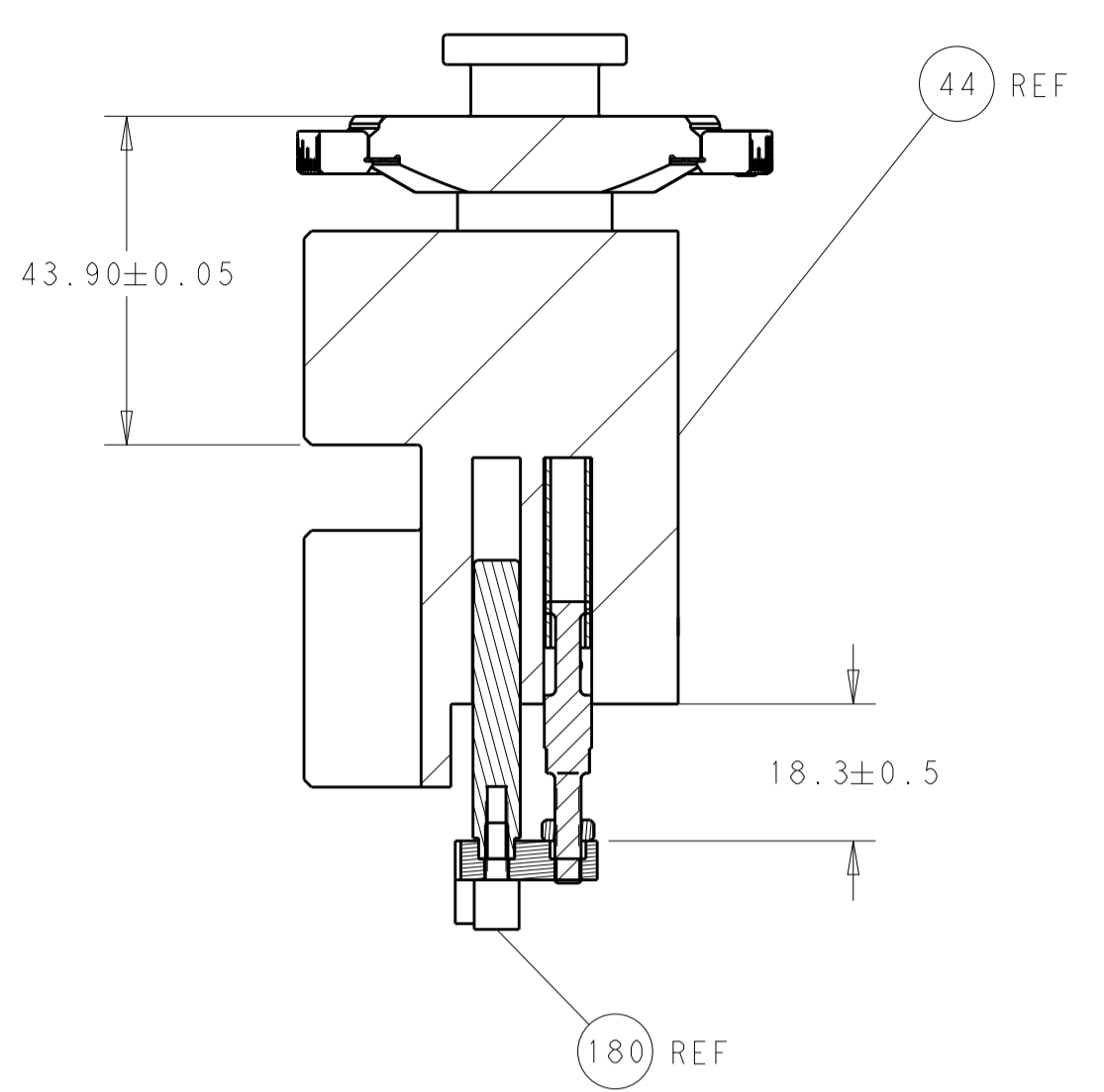
LOC	DIST	REVISIONS					
		P	LTN	DESCRIPTION	DATE	OWN	APVD
A	66	A		RELEASED	12FEB2015	BH	BH
		B		ECR-20-000971	20JAN2020	FZ	TE

-	1	1	2119641-1	FEED CAM, AIR FEED	248	
-	1	1	2119082-2	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	1	2844940-4	AIR FEED MODULE	238	
-	1	1	1-18028-0	WASHER, FLAT, REG M8	192	
-	2	2	1-2168083-1	SCR, SKT HD CAP, RoHS, M3 X 6	191	
	1	1	1-1752354-1	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	1	455888-5	SPACER, CRIMPER	82	
-	1	1	1803607-4	DOCUMENTATION PACKAGE	71	
-	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	
-	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	
-	3	3	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57	
-	2	2	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	56	
-	2	2	986965-8	NUT, LOCK, HEX, TORQUE (M4)	53	
-	1	1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52	
-	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	1803517-1	RAM ASSEMBLY, EF ATLANTIC	44	
-	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41	
-	7	7	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	
-	2	2	5018030-1	NUT, HEX, REG, RoHS, M3	28	
-	1	1	690455-3	STRIPPER, FRONT CASTING	27	
-	2	2	3-18032-3	SCR, SET, FLT PNT, M3 X 20.0	26	
-	2	2	1-2168083-6	SCR, SKT HD CAP, RoHS, M4 X 35	25	
-	1	1	1752371-3	PLATE, STRIP GUIDE	24	
-	1	1	240825-5	PLATE, STRIP HOLD DOWN	23	
-	2	2	22281-8	SPRING, COMPRESSION	22	
-	1	1	1633168-1	ARM, STOCK DRAG	21	
-	1	1	464452-4	DRAG, STOCK	20	
-	2	2	1901259-6	GUIDE, LOWER STRIP	18	
-	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17	
-	1	1	3-240641-5	SPACER	16	
-	1	1	1752360-1	SPACER, HOLD-DOWN	13	
	1	1	240833-2	PLATE, REAR SHEAR	11	
-	-	-	-	-	10	
	1	1	7-690482-3	PLATE, FRONT SHEAR	9	
	1	2	1-1803060-8	ANVIL, COMBINATION, END FEED	8	
	1	1	1-2217206-4	BLADE, SLUG	7	
-	-	-	-	-	6	
-	1	1	240641-4	SPACER	5	
-	1	1	6-238011-1	BLOCK, CRIMPER SPACER	4	
	1	2	1-2119582-0	CRIMPER, INSULATION F PREMIUM	3	
-	1	1	455888-5	SPACER, CRIMPER	2	
	1	2	1-1490019-8	CRIMPER, WIRE PREMIUM	1	
-	77	72	2	PART NO	DESCRIPTION	ITEM NO

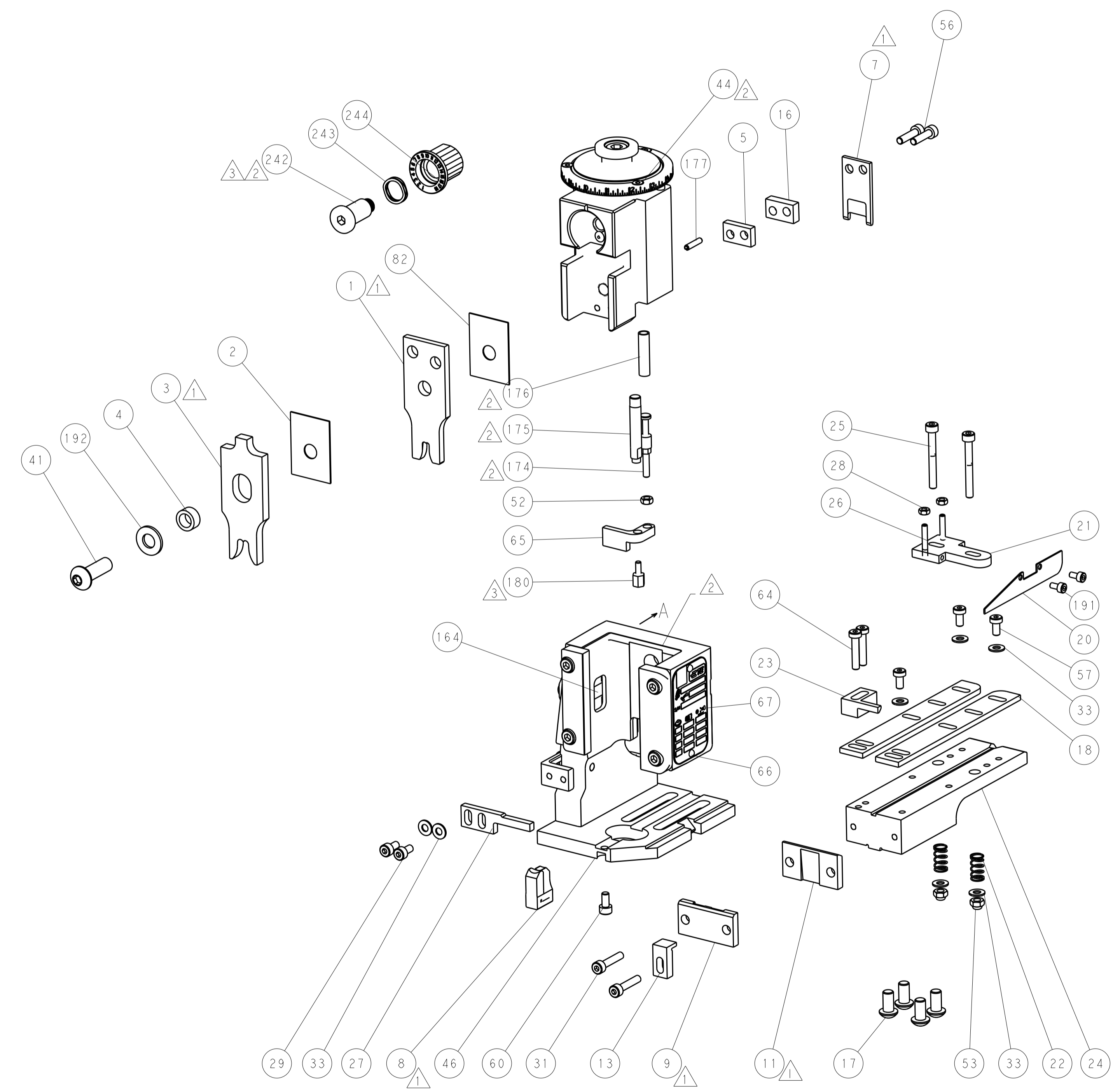
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		OWN: BOB HIGMAN 23DEC2014	TE Connectivity Harrisburg, PA 17105-3608
		0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH ±		CHK: T. ELBIN 23DEC2014	
MATERIAL:		FINISH:		APVD: T. ELBIN 23DEC2014	NAME: Ocean End Feed Applicator
				PRODUCT SPEC:	SIZE: A
				APPLICATION SPEC:	CAGE CODE: 00779
				WEIGHT:	DRAWING NO: 2150523
				RESTRICTED TO:	SCALE: 1:1
				Customer Accessible Production Drawing	SHEET 1 OF 4
					REV B

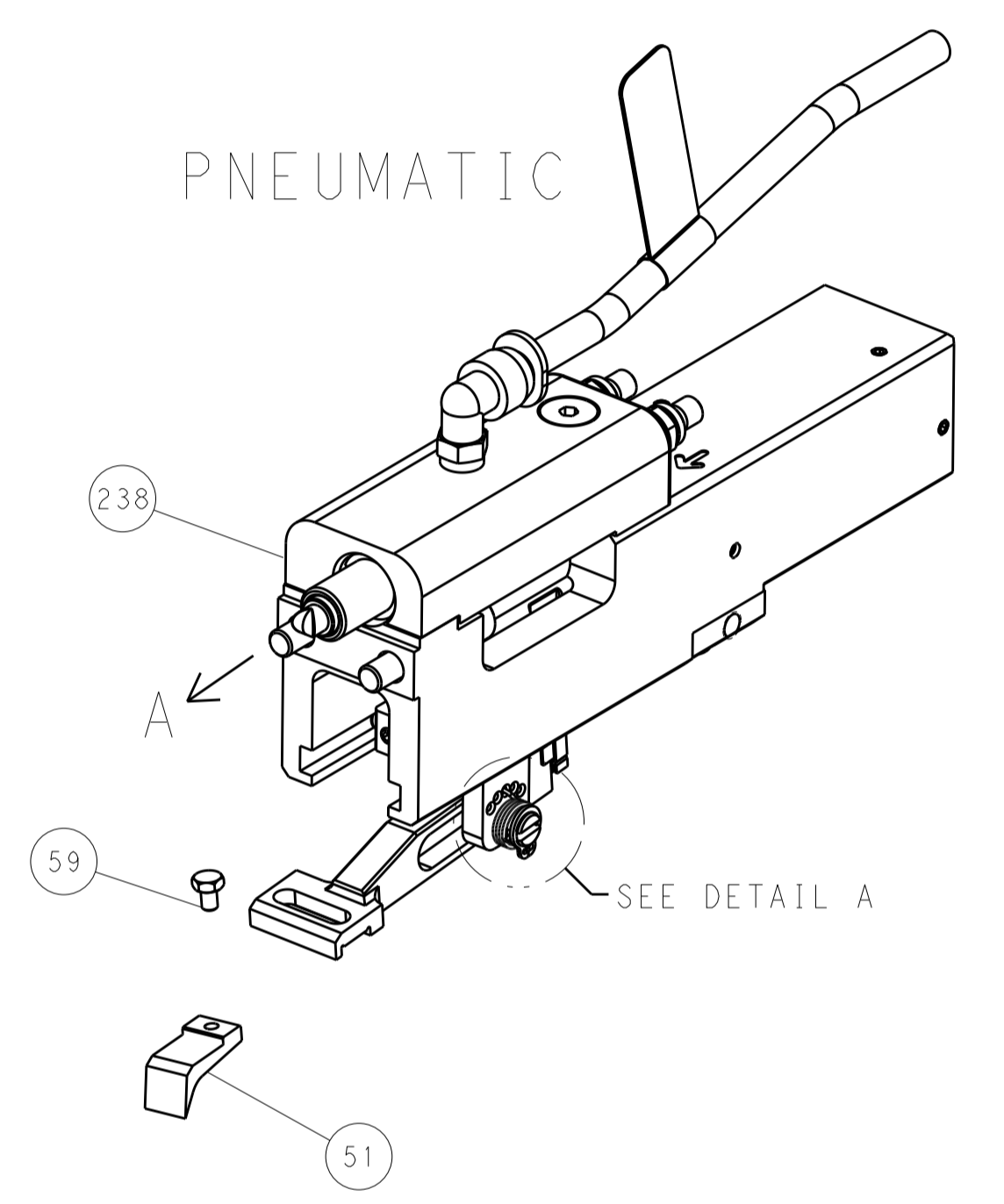
LOC	DIST	REVISIONS					
A	66	P	LTN	DESCRIPTION	DATE	DMN	APVD
		-		SEE SHEET 1			



RAM AND HOLDDOWN SET-UP

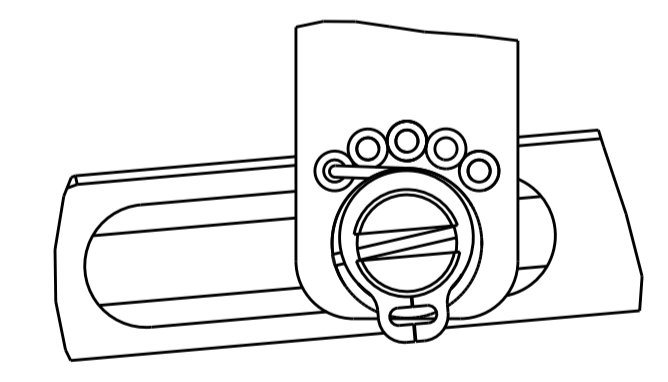


FEED TYPE



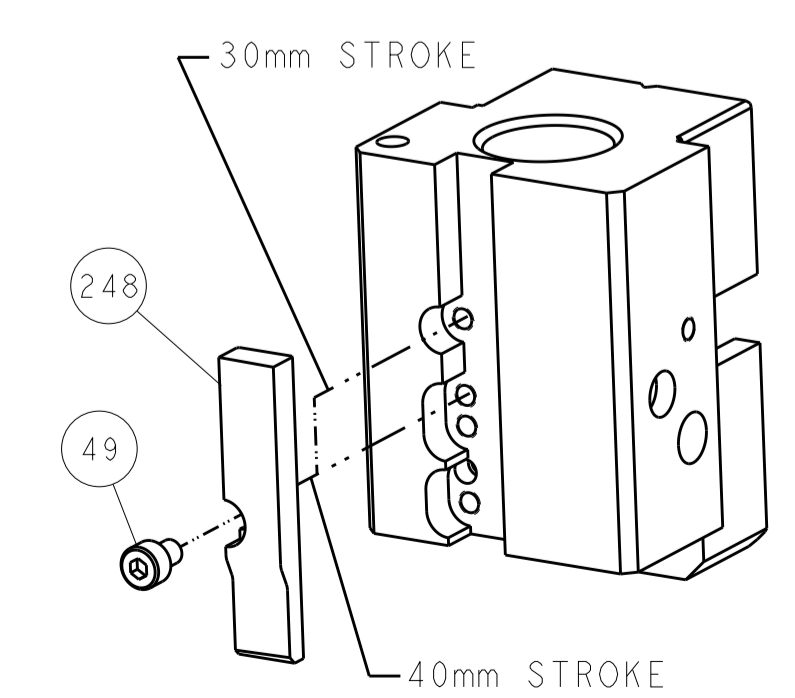
PNEUMATIC

FEED SPRING SETTING POSITION



DETAIL A

CAM POSITION



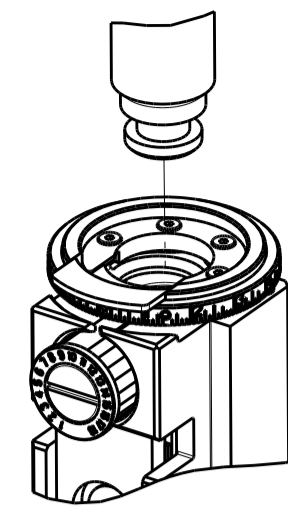
AIR FEED

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

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG: BOB_HIGMAN 23DEC2014		TE Connectivity	
mm		0 PLC ±		CHK: T.ELBIN 23DEC2014		Harrisburg, PA 17105-3608	
Ø		1 PLC ±		APVD: T.ELBIN 23DEC2014		NAME: Ocean End Feed	
H		2 PLC ±		PRODUCT SPEC		Applicator	
L		3 PLC ±		APPLICATION SPEC		SIZE: CAGE CODE: DRAWING NO:	
R		4 PLC ±		WEIGHT		A1 00779 C=2150523	
S		5 PLC ±		Customer Accessible Production Drawing		SCALE: 1:1 SHEET 2 OF 4 REV B	
T		6 PLC ±		RESTRICTED TO:			
Ø		7 PLC ±					
H		8 PLC ±					
L		9 PLC ±					
R		10 PLC ±					
S		11 PLC ±					
T		12 PLC ±					
Ø		13 PLC ±					
H		14 PLC ±					
L		15 PLC ±					
R		16 PLC ±					
S		17 PLC ±					
T		18 PLC ±					
Ø		19 PLC ±					
H		20 PLC ±					
L		21 PLC ±					
R		22 PLC ±					
S		23 PLC ±					
T		24 PLC ±					
Ø		25 PLC ±					
H		26 PLC ±					
L		27 PLC ±					
R		28 PLC ±					
S		29 PLC ±					
T		30 PLC ±					
Ø		31 PLC ±					
H		32 PLC ±					
L		33 PLC ±					
R		34 PLC ±					
S		35 PLC ±					
T		36 PLC ±					
Ø		37 PLC ±					
H		38 PLC ±					
L		39 PLC ±					
R		40 PLC ±					
S		41 PLC ±					
T		42 PLC ±					
Ø		43 PLC ±					
H		44 PLC ±					
L		45 PLC ±					
R		46 PLC ±					
S		47 PLC ±					
T		48 PLC ±					
Ø		49 PLC ±					
H		50 PLC ±					
L		51 PLC ±					
R		52 PLC ±					
S		53 PLC ±					
T		54 PLC ±					
Ø		55 PLC ±					
H		56 PLC ±					
L		57 PLC ±					
R		58 PLC ±					
S		59 PLC ±					
T		60 PLC ±					
Ø		61 PLC ±					
H		62 PLC ±					
L		63 PLC ±					
R		64 PLC ±					
S		65 PLC ±					
T		66 PLC ±					
Ø		67 PLC ±					
H		68 PLC ±					
L		69 PLC ±					
R		70 PLC ±					
S		71 PLC ±					
T		72 PLC ±					
Ø		73 PLC ±					
H		74 PLC ±					
L		75 PLC ±					
R		76 PLC ±					
S		77 PLC ±					
T		78 PLC ±					
Ø		79 PLC ±					
H		80 PLC ±					
L		81 PLC ±					
R		82 PLC ±					
S		83 PLC ±					
T		84 PLC ±					
Ø		85 PLC ±					
H		86 PLC ±					
L		87 PLC ±					
R		88 PLC ±					
S		89 PLC ±					
T		90 PLC ±					
Ø		91 PLC ±					
H		92 PLC ±					
L		93 PLC ±					
R		94 PLC ±					
S		95 PLC ±					
T		96 PLC ±					
Ø		97 PLC ±					
H		98 PLC ±					
L		99 PLC ±					
R		100 PLC ±					

THIS DRAWING IS UNPUBLISHED.	RELEASED FOR PUBLICATION		
COPYRIGHT © BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.			
PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150523-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150523-7	A	CRIMP TOOLING KIT	-

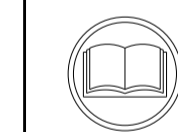
PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	4.32 mm [.170]	F
INSUL	7.62 mm [.300]	F
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: YAZAKI TERMINAL YAZAKI CRIMP SPECIFICATION	
TERMINAL NAME: TERMINAL, FEMALE	
WIRE STRIP LENGTH 5.00-6.00 mm [.197-.236 IN]	INSULATION DIAMETER RANGE 3.60-4.90 mm [.142-.193 IN]
TERMINAL APPLICATION SPECIFICATION Rev 7116-3060-02	
TERMINALS APPLIED	
TE TERMINAL	YAZAKI TERMINAL
1572718-1	7116-3060-02

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
10 AWG OR 5.00mm2	2.30 +/- 0.05 [.091 +/- .002]	4.0
12 AWG OR 3.00mm2	2.00 +/- 0.05 [.079 +/- .002]	7.3



- 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.
- UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.

***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.

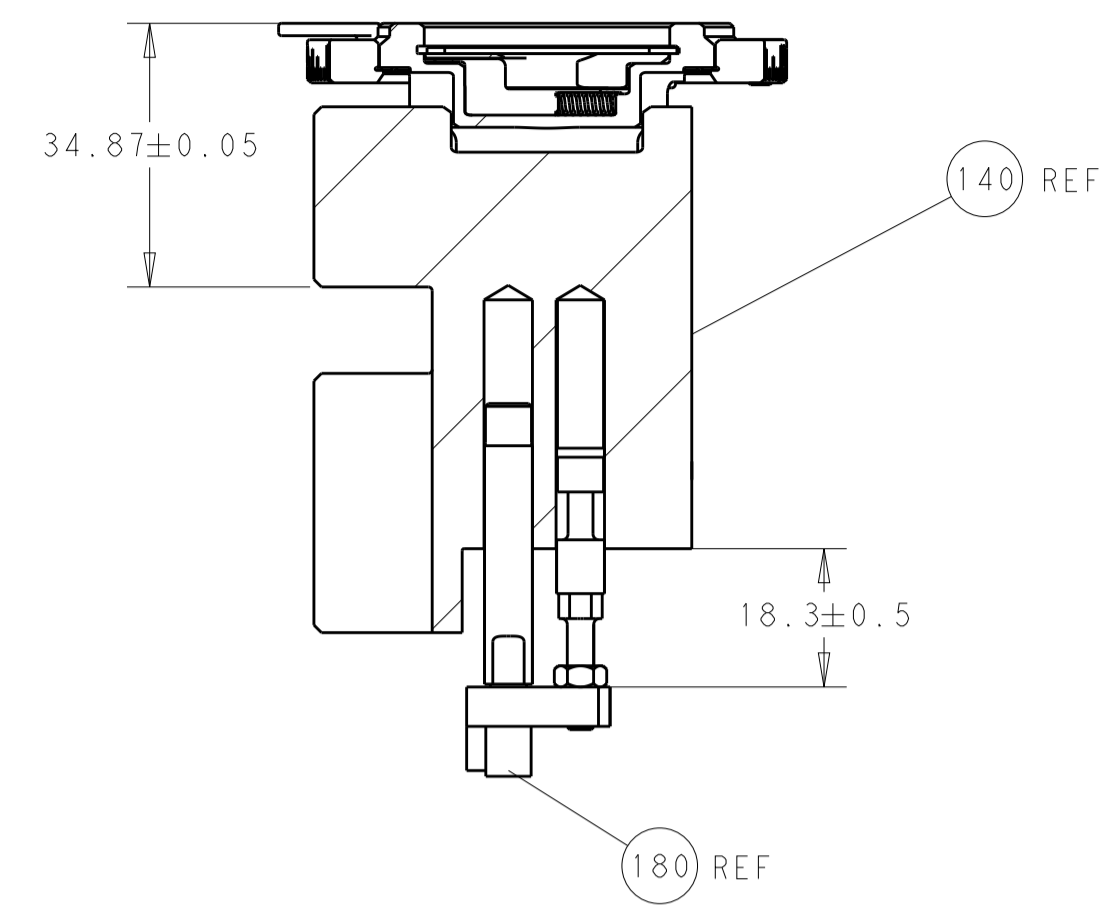
PACIFIC VERSION
Shown on sheets 3 of 4 & 4 of 4
(Atlantic version shown on sheets 1 of 4 & 2 of 4)

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

-	1	2119082-2	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	2844940-4	AIR FEED MODULE	238
-	1	1-18028-0	WASHER, FLAT, REG M8	192
-	2	1-2168083-1	SCR, SKT HD CAP, RoHS, M3 X 6	191
-	4	2079383-9	SCR, BHSC, RoHS (M6 X 20)	186
-	1	1-1752354-1	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
-	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	1803518-1	RAM ASSEMBLY, EF PACIFIC	140
-	1	455888-5	SPACER, CRIMPER	82
-	1	1803607-4	DOCUMENTATION PACKAGE	71
-	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	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	3	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57
-	2	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	56
-	2	986965-8	NUT, LOCK, HEX, TORQUE (M4)	53
-	1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52
-	1	2063961-9	FEED FINGER	51
-	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	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
-	2	5018030-1	NUT, HEX, REG, RoHS, M3	28
-	1	690455-3	STRIPPER, FRONT CASTING	27
-	2	3-18032-3	SCR, SET, FLT PNT, M3 X 20.0	26
-	2	1-2168083-6	SCR, SKT HD CAP, RoHS, M4 X 35	25
-	1	1752371-3	PLATE, STRIP GUIDE	24
-	1	240825-5	PLATE, STRIP HOLD DOWN	23
-	2	22281-8	SPRING, COMPRESSION	22
-	1	1633168-1	ARM, STOCK DRAG	21
-	1	464452-4	DRAG, STOCK	20
-	2	1901259-6	GUIDE, LOWER STRIP	18
-	1	3-240641-5	SPACER	16
-	1	1752360-1	SPACER, HOLD-DOWN	13
-	1	240833-2	PLATE, REAR SHEAR	11
-	-	-	-	10
-	1	7-690482-3	PLATE, FRONT SHEAR	9
1	1	1-1803060-8	ANVIL, COMBINATION, END FEED	8
1	1	1-2217206-4	BLADE, SLUG	7
-	-	-	-	6
-	1	240641-4	SPACER	5
-	1	6-238011-1	BLOCK, CRIMPER SPACER	4
1	1	6-2119582-0	CRIMPER, INSULATION F PREMIUM	3
-	1	455888-5	SPACER, CRIMPER	2
1	1	9-1490019-8	CRIMPER, WIRE PREMIUM	1

DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG: BOB HIGMAN 23DEC2014		CHK: T. ELBIN 23DEC2014		APVD: T. ELBIN 23DEC2014		NAME: I. ELBIN	
0 PLC ±		1 PLC ±		2 PLC ±		3 PLC ±		4 PLC ±		ANGLES ±	
MATERIAL: -		FINISH: -		WEIGHT: -		SCALE: 1:1		SHEET: 3 OF 4		REV: B	

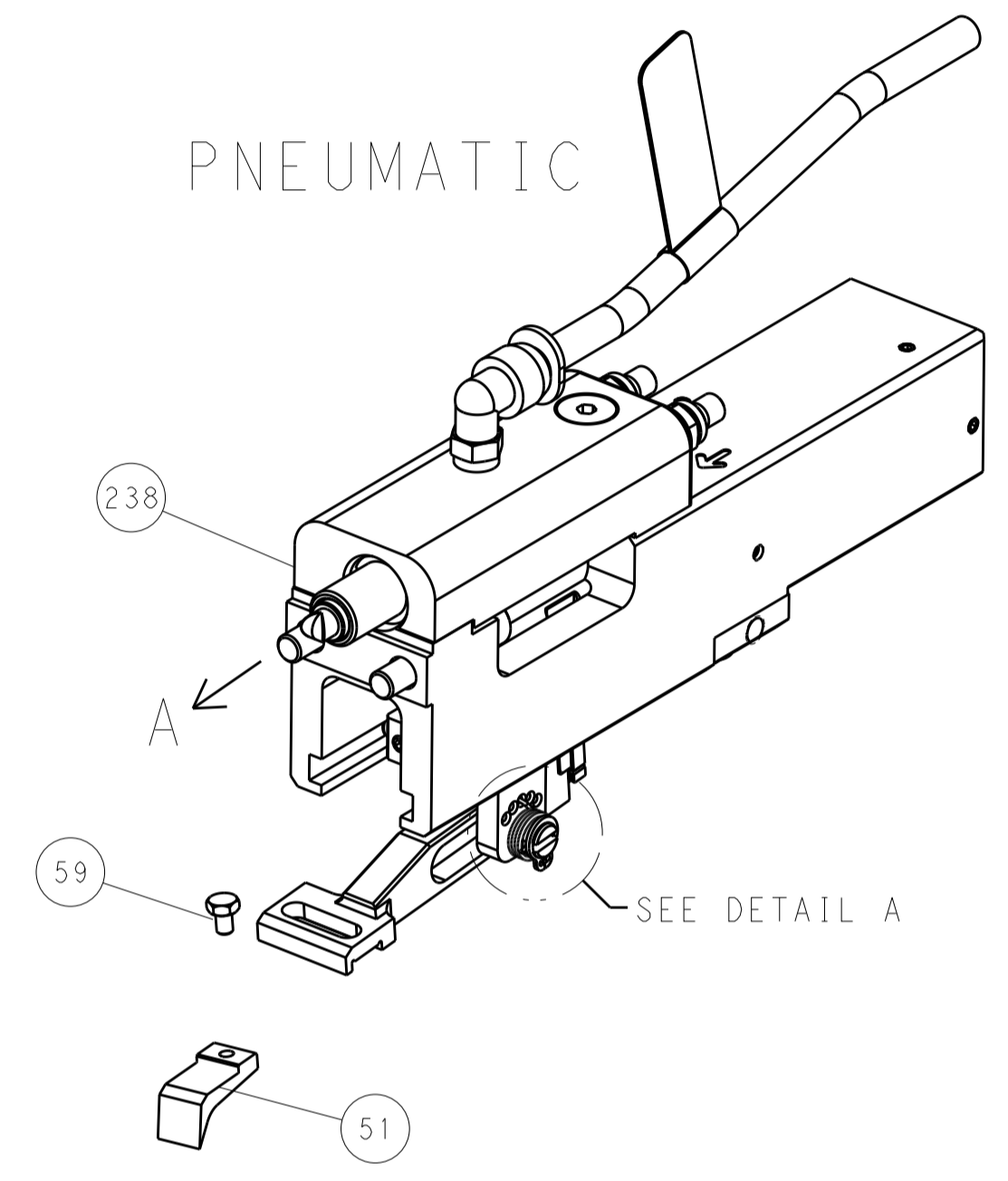
LOC	DIST	REVISIONS				
A	66	P. LTH	DESCRIPTION	DATE	DWN	APVD
			SEE SHEET 1			



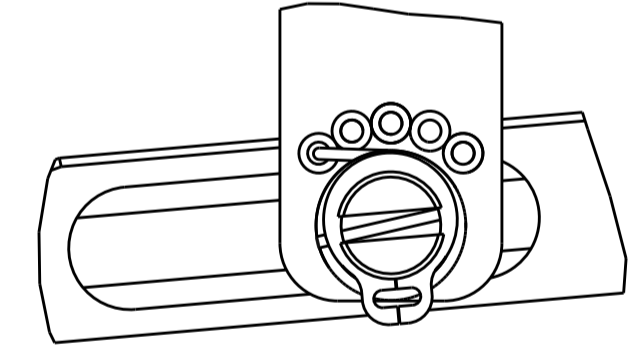
RAM AND HOLDDOWN SET-UP

FEED TYPE

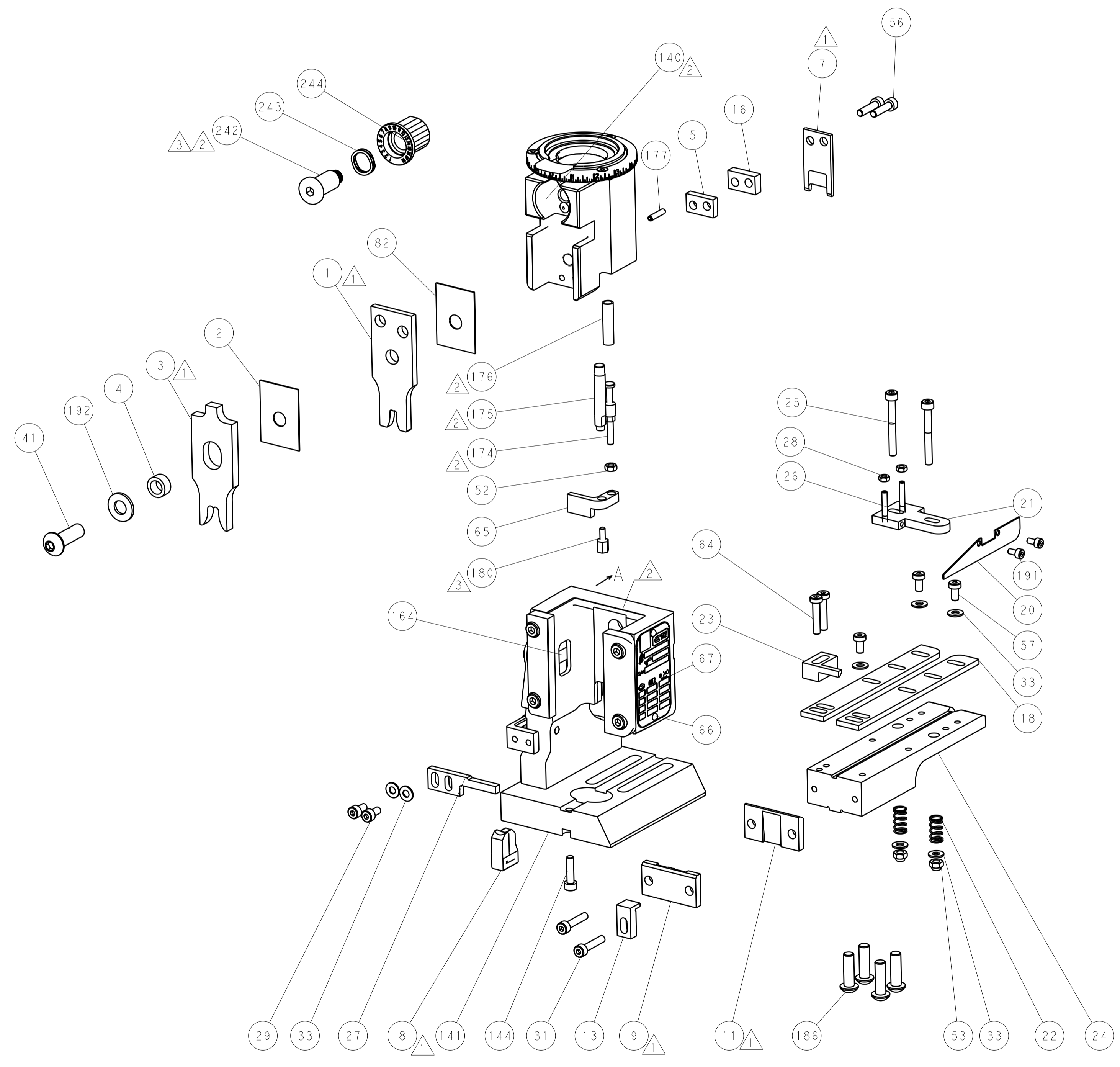
PNEUMATIC



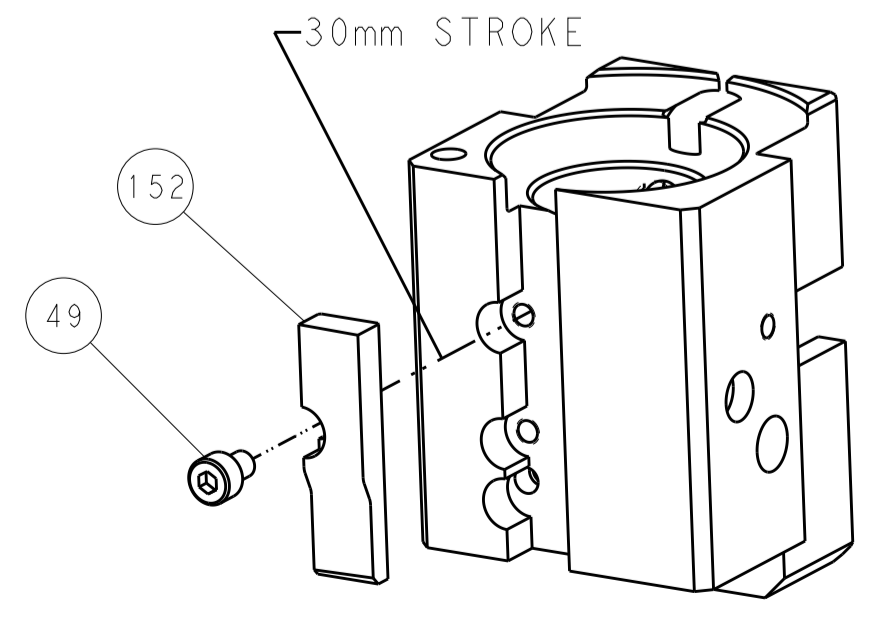
FEED SPRING SETTING POSITION



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)

<small>THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.</small>		DWN BOB HIGMAN 23DEC2014 CHK T. ELBIN 23DEC2014 APVD T. ELBIN 23DEC2014	TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		PRODUCT SPEC APPLICATION SPEC WEIGHT SCALE 1:1	NAME Ocean End Feed Applicator SIZE CAGE CODE DRAWING NO. RESTRICTED TO A1 00779 ©=2150523 Customer Accessible Production Drawing SHEET 4 OF 4 REV B