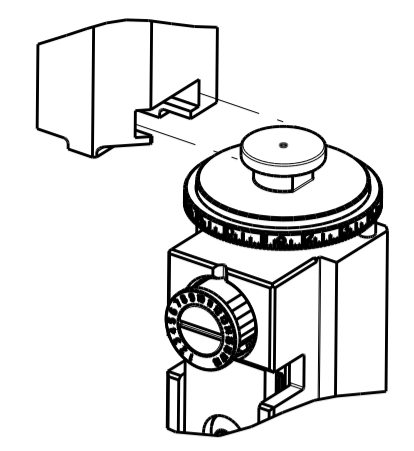


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150575-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2150575-2	D	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150575-1	C	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2150575-2	D	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150575-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.79 mm [.110]	F
INSUL	4.06 mm [.160]	F
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION			
TERMINAL NAME: SPADE			
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE		
5.08-5.97 mm [.200-.235 IN]	∅2.54-3.56 mm [.100-.140 IN]		
TERMINAL APPLICATION SPECIFICATION			
114-2084			
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
60773-2	60774-2	60775-2	
60774-1	60775-1		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
14 AWG	1.88 +/- 0.05 [.074 +/- .002]	6.1
16 AWG	1.70 +/- 0.05 [.067 +/- .002]	7.9
1.00mm2	1.60 +/- 0.05 [.063 +/- .002]	9.1
18 AWG	1.52 +/- 0.05 [.060 +/- .002]	9.8

- 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. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- 6 ITEM 6 WILL NEED ADJUSTED FOR EACH CRIMP HEIGHT TO MAINTAIN 70°-90° BEND REQUIREMENT. ADJUST ITEM 6 FOR 18AWG WIRE SIZE BEFORE SHIPPING APPLICATOR.
- 7 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.

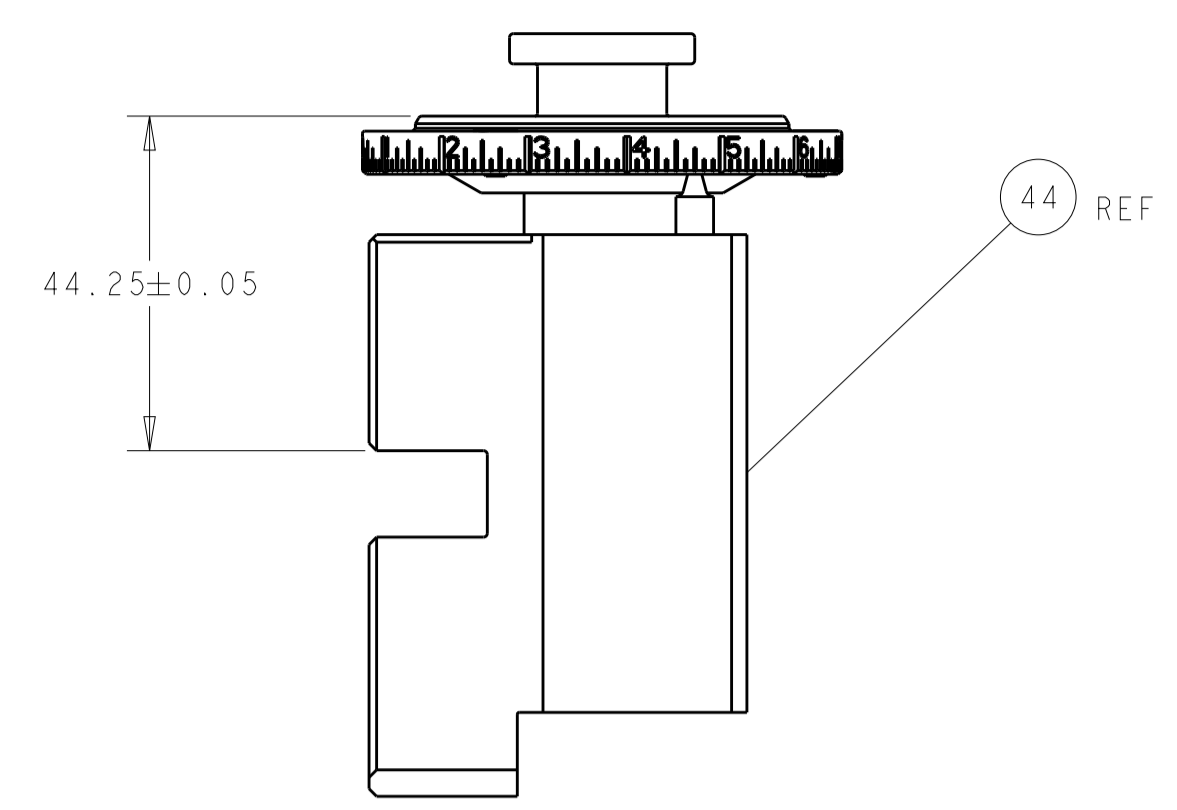
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		B		ECR-18-015958	09OCT2018	FL	TE
		C		ECR-19-007534	13MAY2019	FZ	CT
		D		ECR-19-012980	19AUG2019	FJ	TE

-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248		
-	1	1	1	1	2119082-7	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		
-	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164		
-	1	1	1	1	2119955-2	ASSY, LUBRICATOR, END FEED	84		
-	1	1	1	1	455888-6	SPACER, CRIMPER	82		
-	1	1	1	1	2119791-5	DEPRESSOR, WIRE	73		
-	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	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	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	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	-	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	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	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	1752371-2	PLATE, STRIP GUIDE	24		
-	2	2	2	2	2-22281-3	SPRING, COMPRESSION	22		
-	1	1	1	1	1803292-4	DRAG	20		
-	1	1	1	1	1901696-1	STRIP GUIDE, REAR	19		
-	1	1	1	1	1901695-1	STRIP GUIDE, FRONT	18		
-	4	4	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17		
-	1	1	1	1	6-240641-7	SPACER	16		
-	1	1	1	1	1803203-1	BLOCK, FRONT DEPRESSOR	14		
-	1	1	1	1	690784-2	FRONT SHEAR PLATE	12		
-	1	1	1	1	240833-2	PLATE, REAR SHEAR	11		
-	2	2	2	2	240645-8	SPACER, SHEAR PLATE	10		
-	1	1	1	1	1803071-1	SPACER, REAR SHEAR STRIP GUIDE	9		
-	1	2	2	1	1	4-1633383-6	ANVIL, COMBINATION	8	
-	1	1	1	1	4-240651-2	BLADE, SLUG	7		
-	1	1	1	1	1-690759-1	FORMING (FLANGING) TOOL	6		
-	1	1	1	1	3-240641-3	SPACER	5		
-	1	1	1	1	238011-2	BLOCK, CRIMPER SPACER	4		
-	1	2	2	1	1	6-1633961-4	CRIMPER, INSULATION F PREMIUM	3	
-	1	1	1	1	455888-1	SPACER, CRIMPER	2		
-	1	2	2	1	1	456408-9	CRIMPER, WIRE PREMIUM	1	
-	77	72	71	-	2	-1	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)

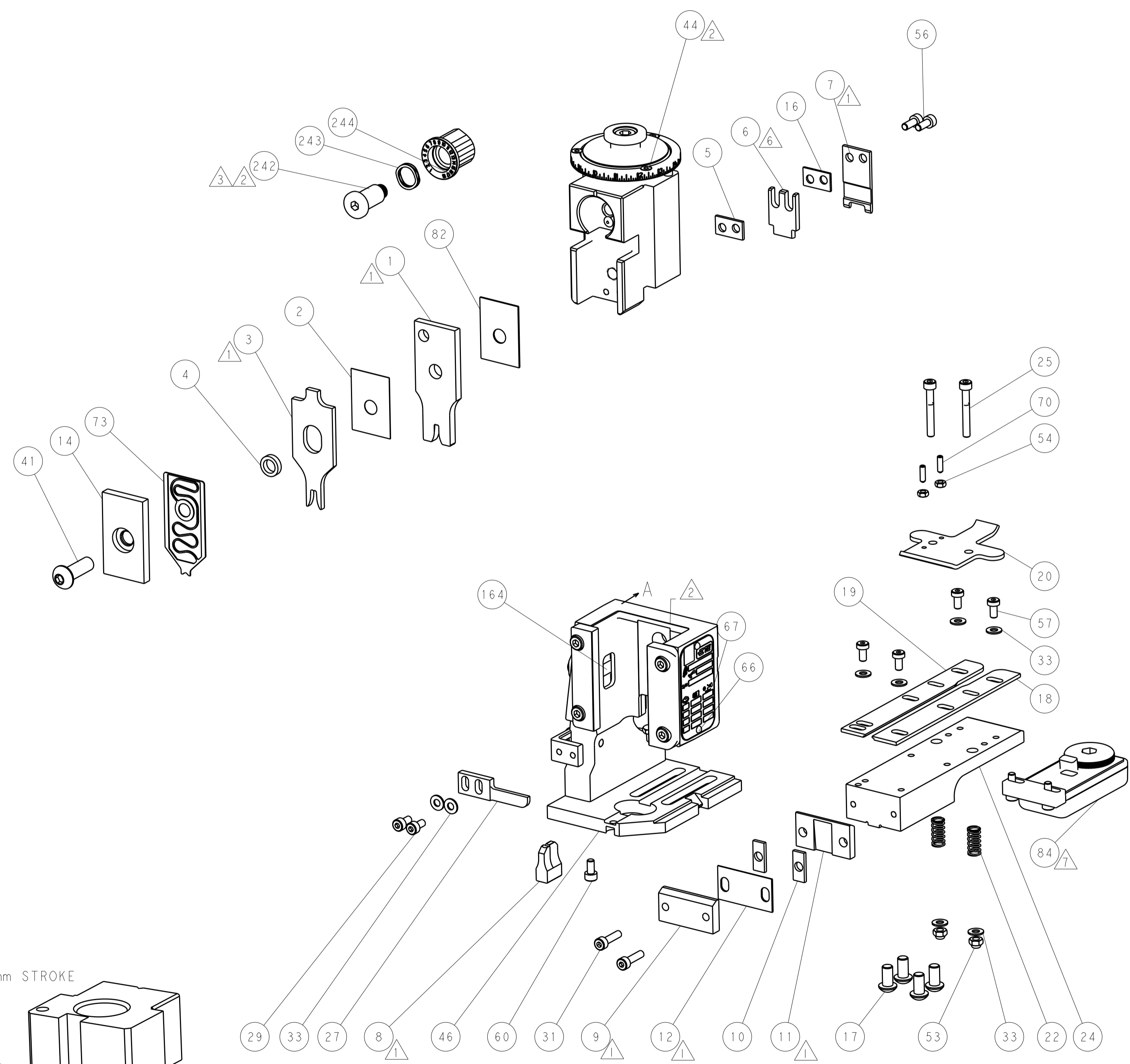
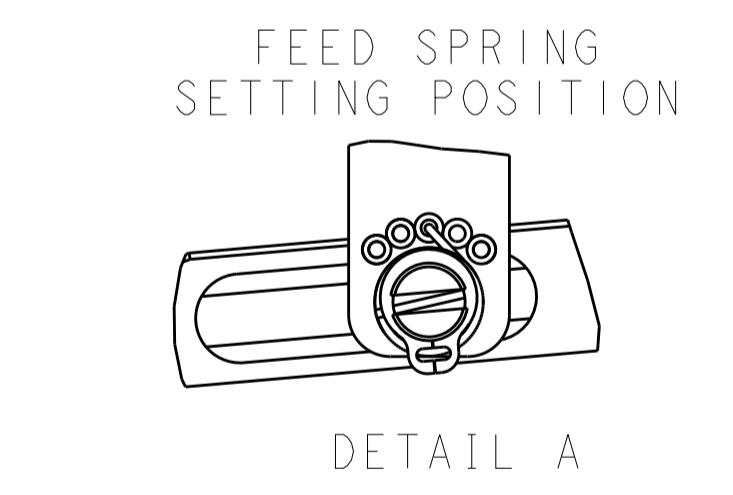
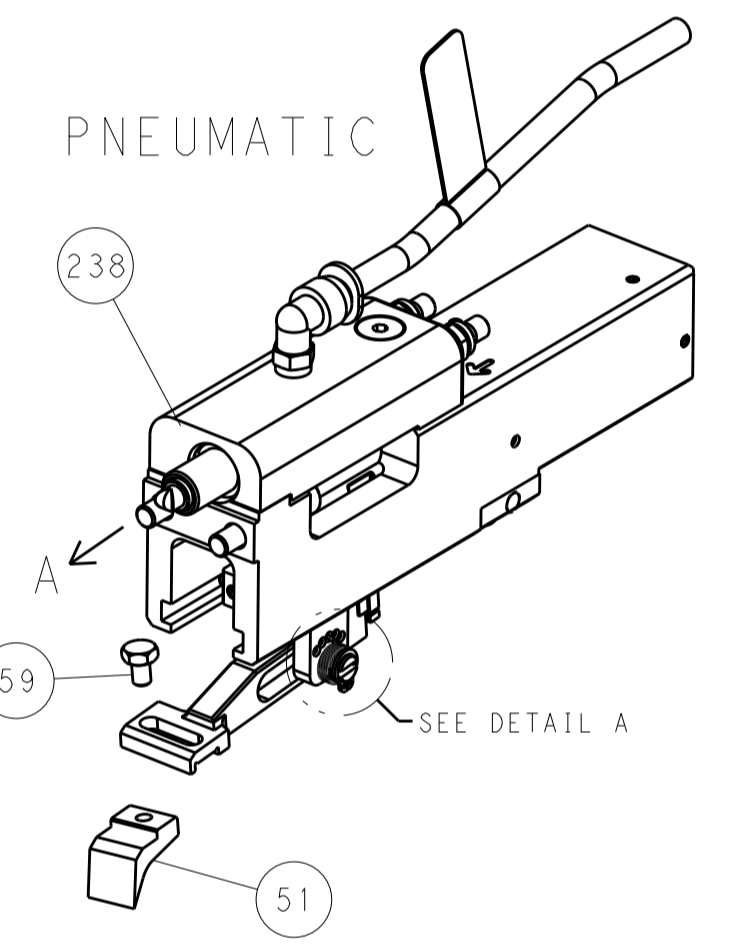
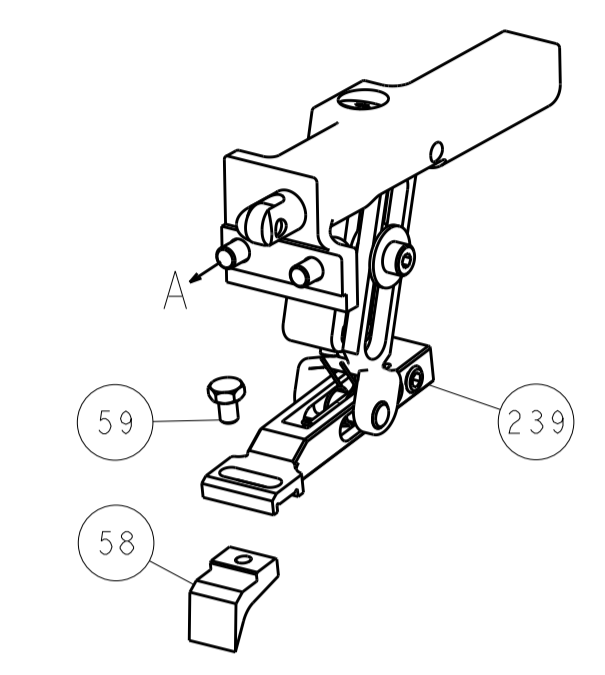
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mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES	FINISH	WT	SCALE	SHEET	REV
										1	D

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

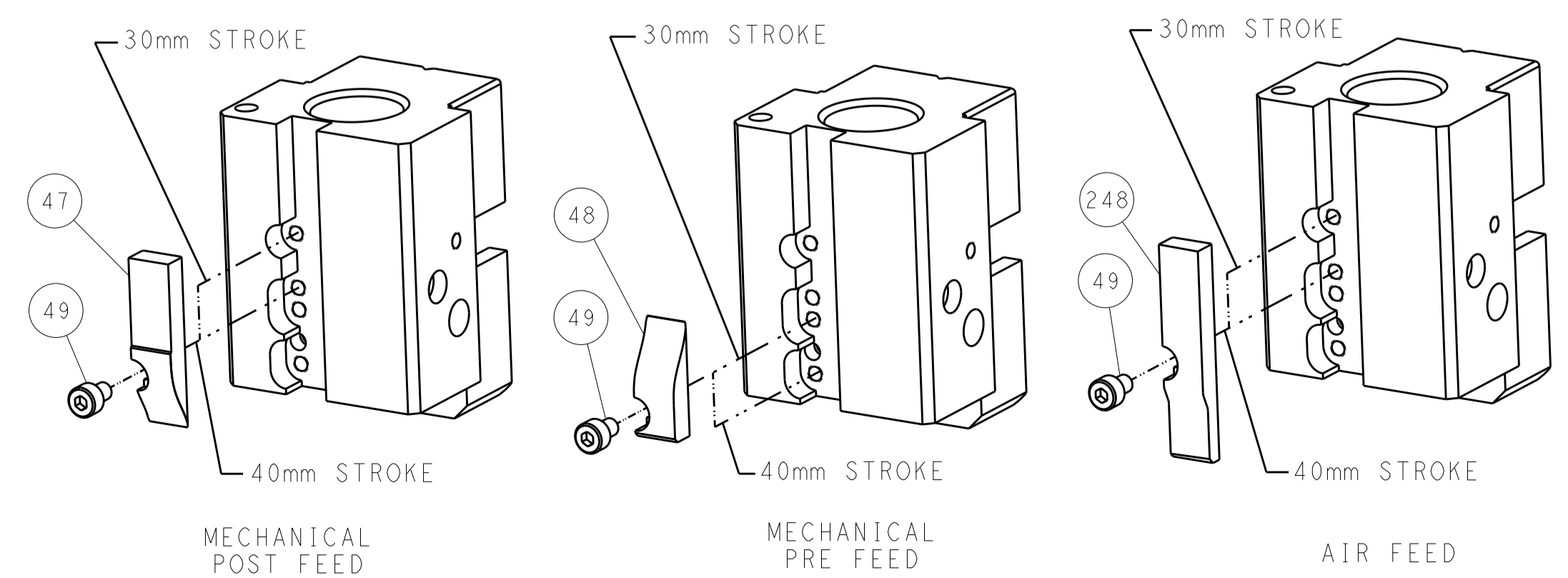


RAM SET-UP

FEED TYPE  
MECHANICAL



CAM POSITIONS

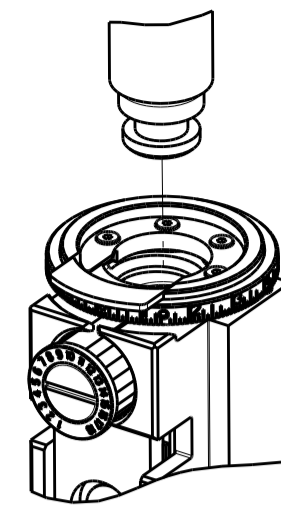


ATLANTIC VERSION  
 Shown on sheets 1 of 4 & 2 of 4  
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		OWN: BOB HIGMAN 18MAY2015		TE Connectivity	
mm		0 PLC ±		CHK: T. ELBIN 18MAY2015		Harrisburg, PA 17105-3608	
Ø		1 PLC ±		APPV: T. ELBIN 18MAY2015		NAME: Ocean End Feed Applicator	
H		2 PLC ±		PRODUCT SPEC		SIZE: CAGE CODE: DRAWING NO:	
L		3 PLC ±		APPLICATION SPEC		RESTRICTED TO:	
R		4 PLC ±		WEIGHT		A1 00779 ©=2150575	
S		5 PLC ±		MATERIAL		Customer Accessible Production Drawing	
T		6 PLC ±		FINISH		SCALE: 1:1 SHEET 2 OF 4 REV D	
U		7 PLC ±		ANGLES		SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION	

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150575-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2150575-2	D	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150575-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR  
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.79 mm (.110)	F
INSUL	4.06 mm (.160)	F
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: SPADE			
WIRE STRIP LENGTH 5.08-5.97 mm (.200-.235 IN)		INSULATION DIAMETER RANGE Ø2.54-3.56 mm (.100-.140 IN)	
TERMINAL APPLICATION SPECIFICATION 114-2084			
TERMINALS APPLIED			
TE TERMINAL 60773-2	TE TERMINAL 60774-2	TE TERMINAL 60775-2	TE TERMINAL 60775-1

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
14 AWG	1.88 +/- 0.05 [0.074 +/- .002]	6.1
16 AWG	1.70 +/- 0.05 [0.067 +/- .002]	7.9
1.00mm <sup>2</sup>	1.60 +/- 0.05 [0.063 +/- .002]	9.1
18 AWG	1.52 +/- 0.05 [0.060 +/- .002]	9.8



- 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. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- 6 ITEM 6 WILL NEED ADJUSTED FOR EACH CRIMP HEIGHT TO MAINTAIN 70°-90° BEND REQUIREMENT. ADJUST ITEM 6 FOR 18AWG WIRE SIZE BEFORE SHIPPING APPLICATOR.
- 7 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.

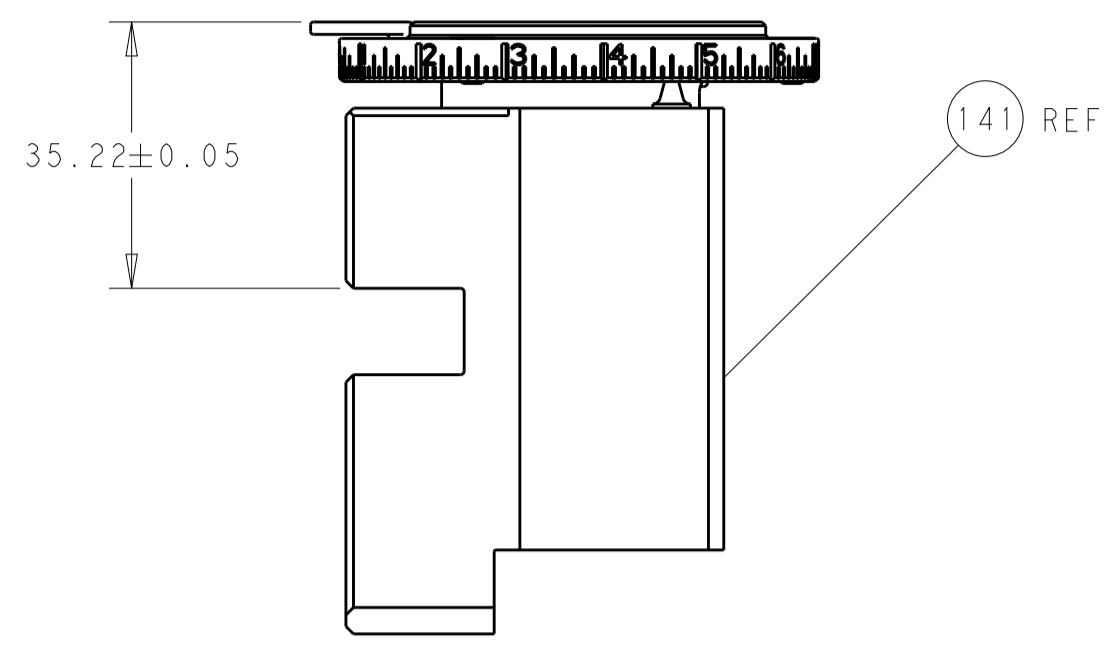
LOC	DIST	REV	DATE	BY	APPD
A	66				

REV	DATE	DESCRIPTION	QTY		
-	1	1	2119082-7	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
3	-	1	2119083-1	RETAINER, INSULATION DIAL	242
-	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	1	-	2844940-3	AIR FEED MODULE	238
-	4	4	2079383-9	SCR, BHSC, RoHS (M6 X 20)	186
-	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
7	-	1	2119955-2	ASSY, LUBRICATOR, END FEED	84
-	1	1	455888-6	SPACER, CRIMPER	82
-	1	1	2119791-5	DEPRESSOR, WIRE	73
-	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	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	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	56
-	2	2	5018030-1	NUT, HEX, REG, RoHS, M3	54
-	2	2	986965-8	NUT, LOCK, HEX, TORQUE (M4)	53
-	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	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	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	1752371-2	PLATE, STRIP GUIDE	24
-	2	2	2-22281-3	SPRING, COMPRESSION	22
-	1	1	1803292-4	DRAG	20
-	1	1	1901696-1	STRIP GUIDE, REAR	19
-	1	1	1901695-1	STRIP GUIDE, FRONT	18
-	1	1	6-240641-7	SPACER	16
-	1	1	1803203-1	BLOCK, FRONT DEPRESSOR	14
1	-	1	690784-2	FRONT SHEAR PLATE	12
1	-	1	240833-2	PLATE, REAR SHEAR	11
-	2	2	240645-8	SPACER, SHEAR PLATE	10
1	-	1	1803071-1	SPACER, REAR SHEAR STRIP GUIDE	9
1	1	1	4-1633383-6	ANVIL, COMBINATION	8
1	-	1	4-240651-2	BLADE, SLUG	7
6	-	1	1-690759-1	FORMING (FLANGING) TOOL	6
-	1	1	3-240641-3	SPACER	5
-	1	1	238011-2	BLOCK, CRIMPER SPACER	4
1	1	1	6-1633961-4	CRIMPER, INSULATION F PREMIUM	3
-	1	1	455888-1	SPACER, CRIMPER	2
1	1	1	456408-9	CRIMPER, WIRE PREMIUM	1
-	77-22-21		PART NO	DESCRIPTION	ITEM NO

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

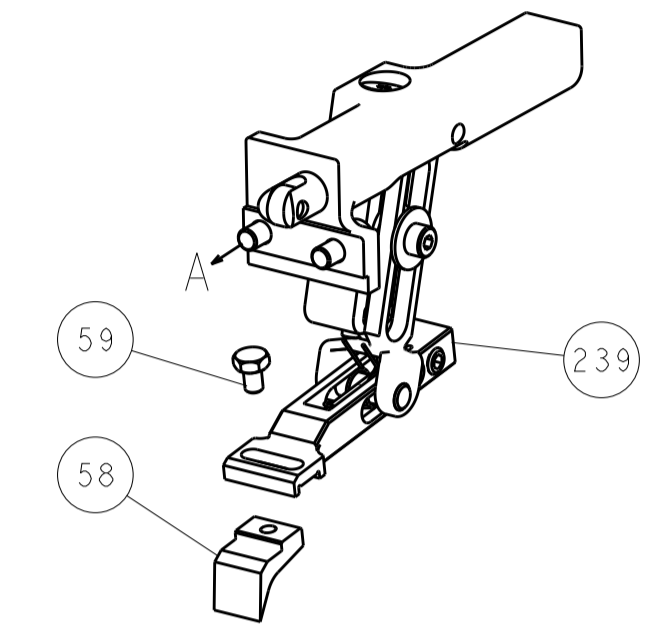
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MATERIAL: -		FINISH: -		WEIGHT: -		SCALE: 1:1		SHEET: 3 OF 4		REV: D	

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

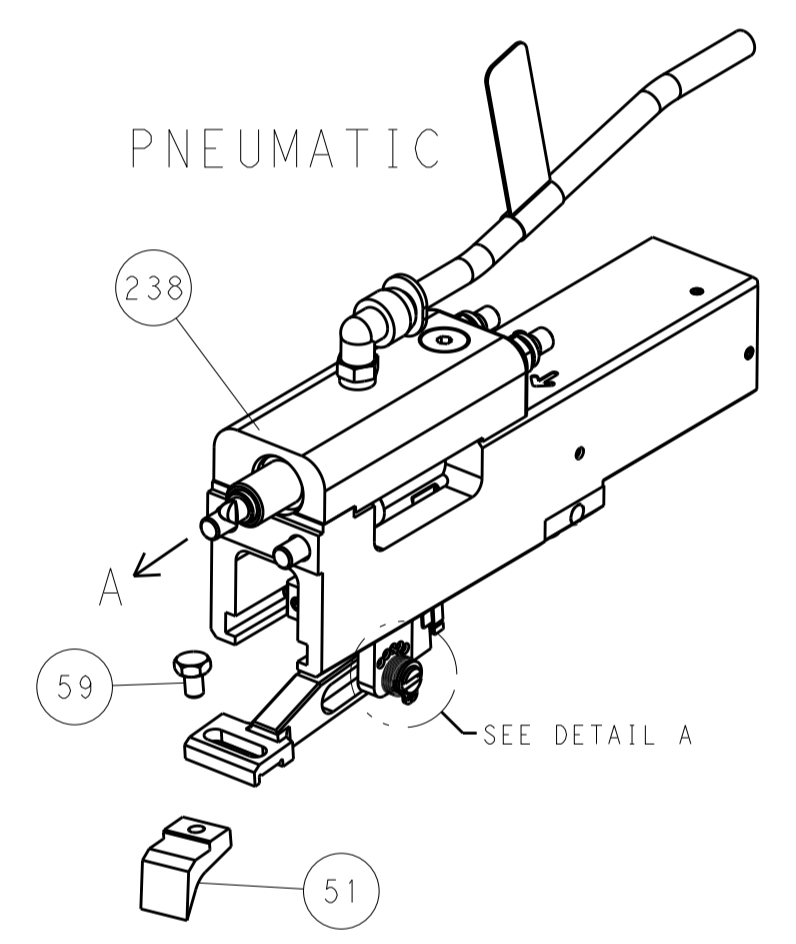


RAM SET-UP

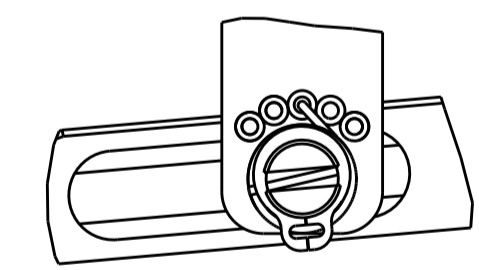
FEED TYPE  
MECHANICAL



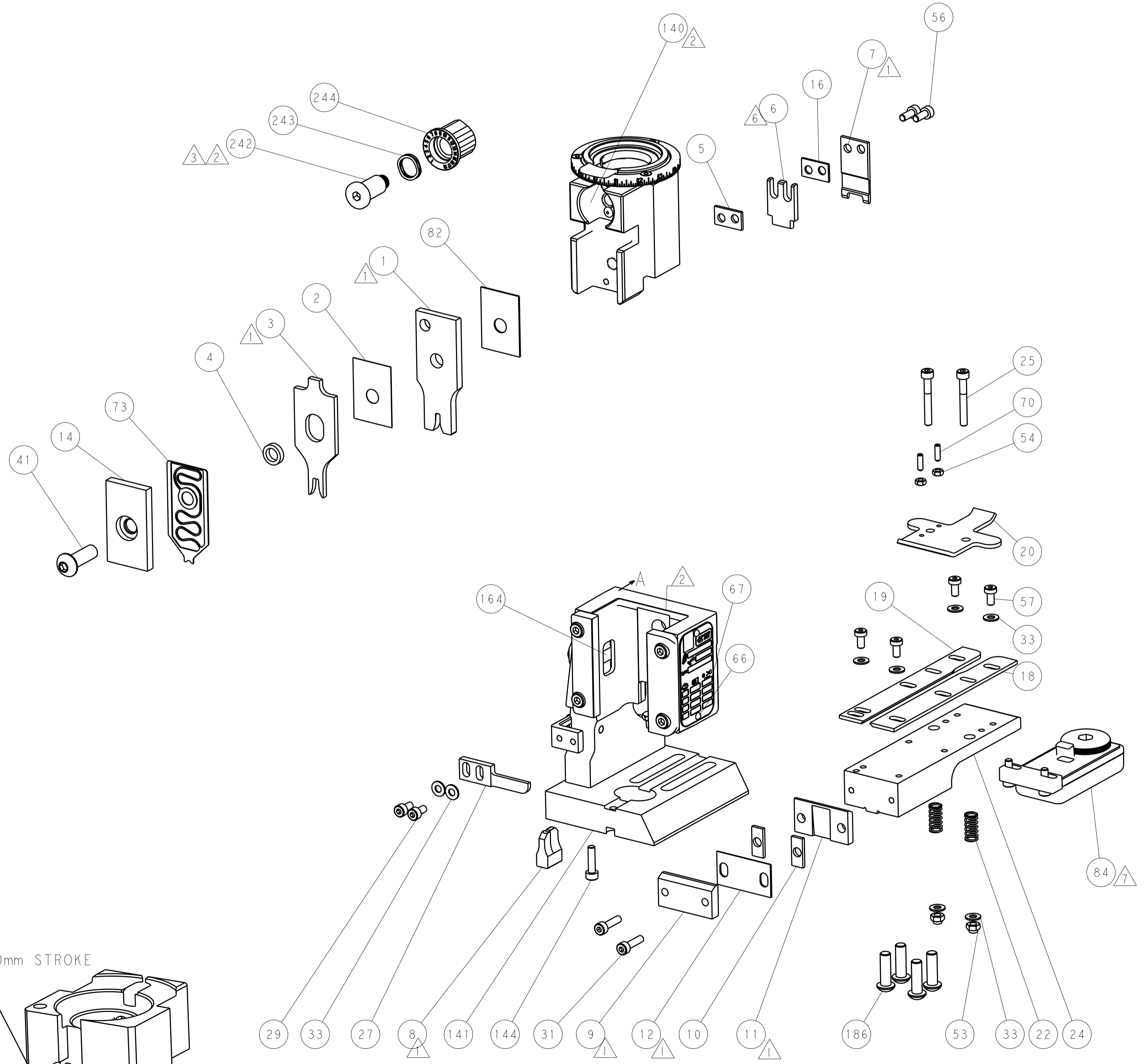
PNEUMATIC



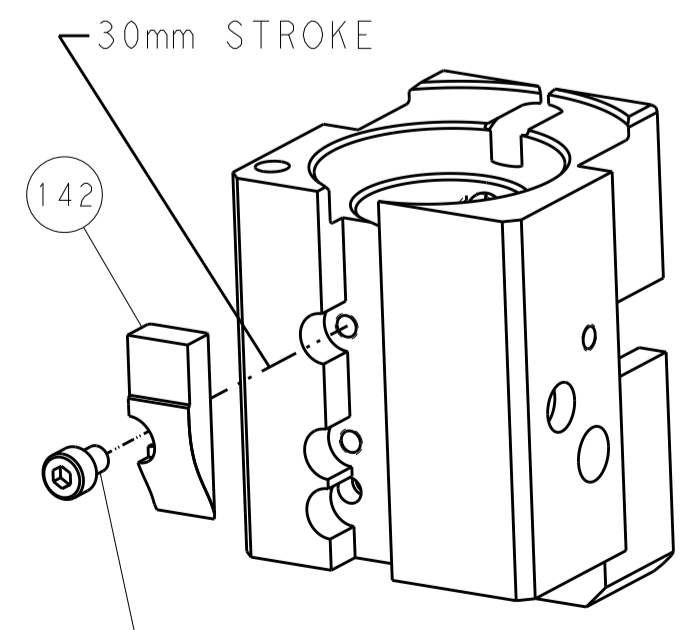
FEED SPRING  
SETTING POSITION



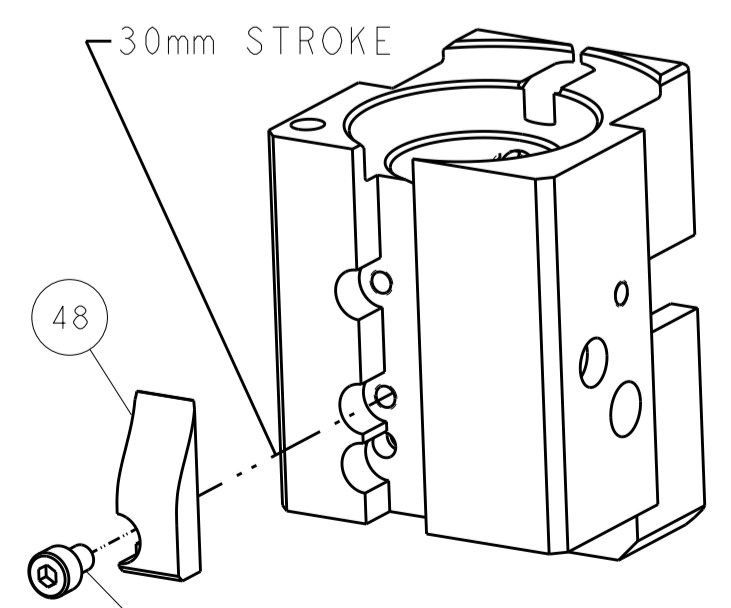
DETAIL A



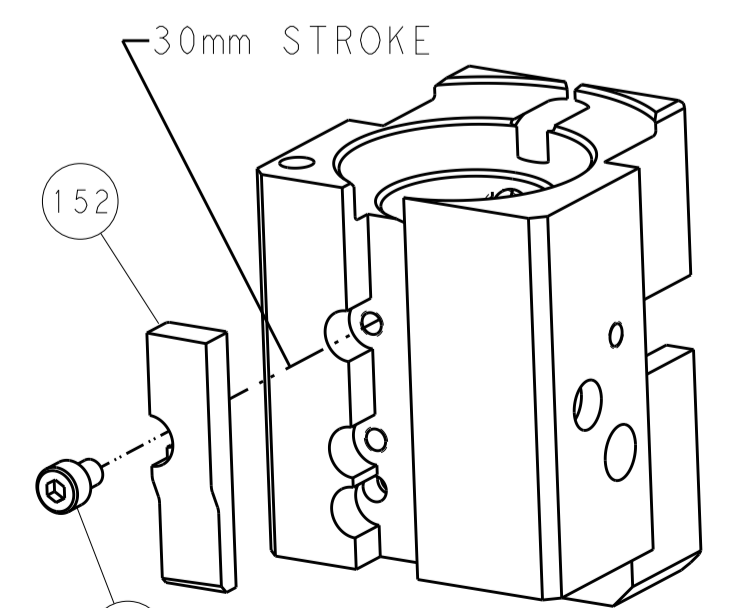
CAM POSITIONS



MECHANICAL POST FEED



MECHANICAL PRE FEED



AIR FEED

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:		DWN BOB HIGMAN 18MAY2015		TE Connectivity	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	5 PLC ±	Harrisburg, PA 17105-3608
	ANGLES	FINISH		APVD T. ELBIN 18MAY2015	NAME		
MATERIAL				PRODUCT SPEC	Ocean End Feed		
				APPLICATION SPEC	Applicator		
				WEIGHT	SIZE	CAGE CODE	DRAWING NO
				Customer Accessible Production Drawing	A11	00779	©=2150575
				SCALE	1:1	SHEET	4 OF 4
				REV	D		