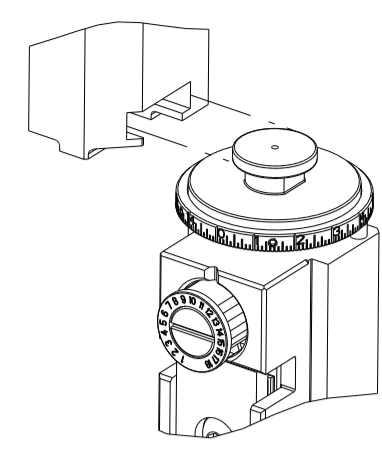


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150580-2	H	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150580-2	H	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150580-7	A	CRIMP TOOLING KIT	-

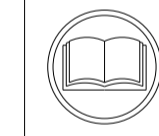
ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.79 mm [.110]	F
INSUL	3.81 mm [.150]	F
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: Cluster Receptacle, Amplivar Type			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
4.45-5.05 mm [.175-.199 IN]		∅2.20-2.80 mm [.087-.110 IN]	
TERMINAL APPLICATION SPECIFICATION	114-5242	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
353937-1			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
(2) 18 MAG	1.67+/-0.05 [.066+/- .002]	5.4
(1) 19.5 + (1) 19 MAG	1.60+/-0.05 [.063+/- .002]	5.8
(1) 20.5 + (1) 20 MAG	1.50+/-0.05 [.059+/- .002]	6.9
(2) 21.5 MAG	1.40+/-0.05 [.055+/- .002]	8.1



- RECOMMENDED SPARE PARTS
- REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- 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 LUBRICANT IS RECOMMENDED.
- 6. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- FOR SPECIFIC WIRE COMBINATIONS SEE SPEC 114-5242.
- 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.

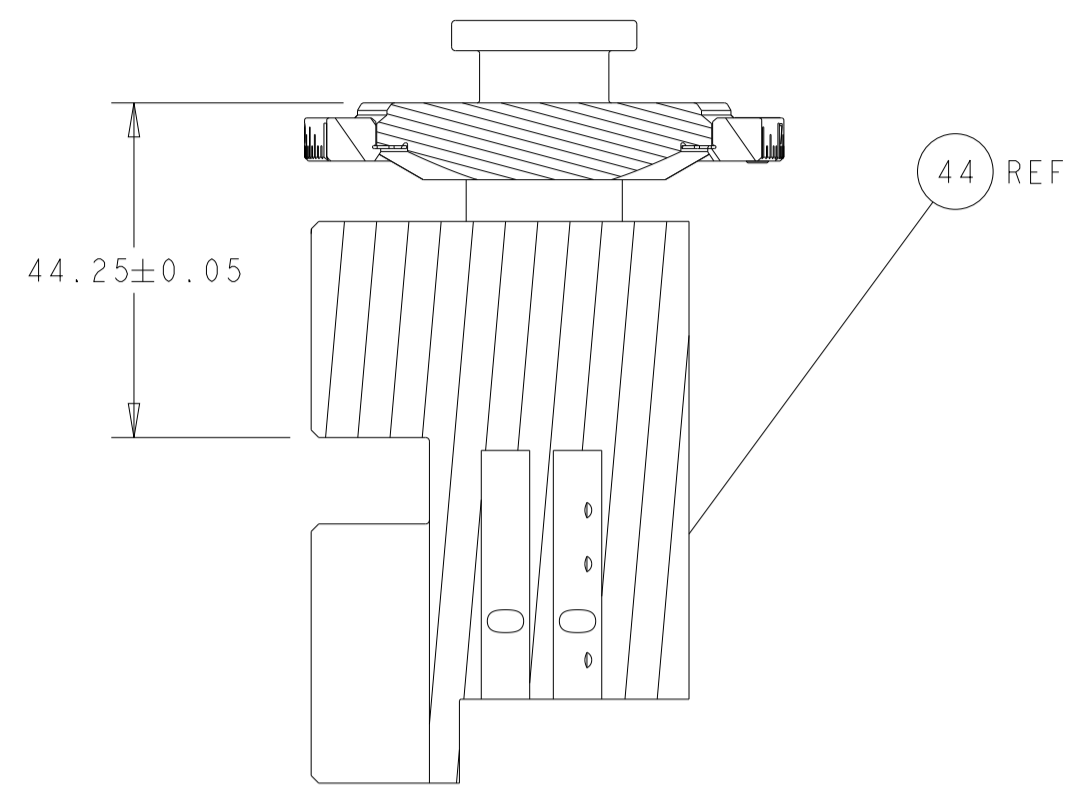
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		E		ECR-20-004250	20MAR2020	MY	YY
		F		ECR-21-004030	05APR2021	LG	TE
		G		ECR-21-004677	22APR2021	FZ	RK
		H		ECR-22-144858	05JUL2022	FZ	JAH

-	1	1	2119641-1	FEED CAM, AIR FEED	248	
-	1	1	2119082-3	CAM, SNAIL, INSULATION ADJUSTMENT	244	
-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243	
	-	1	2119083-1	RETAINER, INSULATION DIAL	242	
-	1	1	2844940-3	AIR FEED MODULE	238	
-	1	1	1-18028-0	WASHER, FLAT, REG M8	192	
-	REF	REF	994970-2	COUNTER, MAGNETIC	164	
	-	1	2119955-2	ASSY, LUBRICATOR, END FEED	84	
-	1	1	455888-1	SPACER, CRIMPER	82	
-	1	1	690191-5	PLUG, NYLON	74	
-	1	1	18031-1	SCR, SET, CUP POINT M3 X 5.0	73	
	-	1	1333249-1	PIN, FORMING	72	
-	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	
-	2	2	2168400-8	SHCS, LOW HEAD, RoHS, M4 X 16	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	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	56	
-	1	1	6-690518-0	HOLD DOWN, TERMINAL	55	
-	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	1803517-1	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	
-	1	1	240639-2	STRIPPER (MACHINING)	27	
-	2	2	1-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 30	25	
-	1	1	1-1752371-0	PLATE, STRIP GUIDE	24	
-	1	1	240825-3	PLATE, STRIP HOLD DOWN	23	
-	2	2	22281-9	SPRING, COMPRESSION	22	
-	1	1	1803292-4	DRAG	20	
-	2	2	1901259-6	GUIDE, LOWER STRIP	18	
-	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17	
-	1	1	1333248-1	HOLDER, FORMING PIN	15	
	-	1	1752360-1	SPACER, HOLD-DOWN	13	
-	1	1	240833-4	PLATE, REAR SHEAR	11	
	-	2	2-240645-7	SPACER, SHEAR PLATE	10	
	-	1	690796-1	PLATE-FRONT SHEAR MINI APPLICATOR	9	
	1	2	1	5-1333219-1	ANVIL, COMBINATION	8
-	1	1	8-240651-6	BLADE, SLUG	7	
-	-	-	-	-	6	
-	1	1	238011-4	BLOCK, CRIMPER SPACER	4	
	1	2	1	7-1633961-7	CRIMPER, INSULATION F PREMIUM	3
-	1	1	1-455888-0	SPACER, CRIMPER	2	
	1	2	1	1-462808-9	CRIMPER, BLUNT F	1
-	77	72	-2	PART NO	DESCRIPTION	ITEM NO

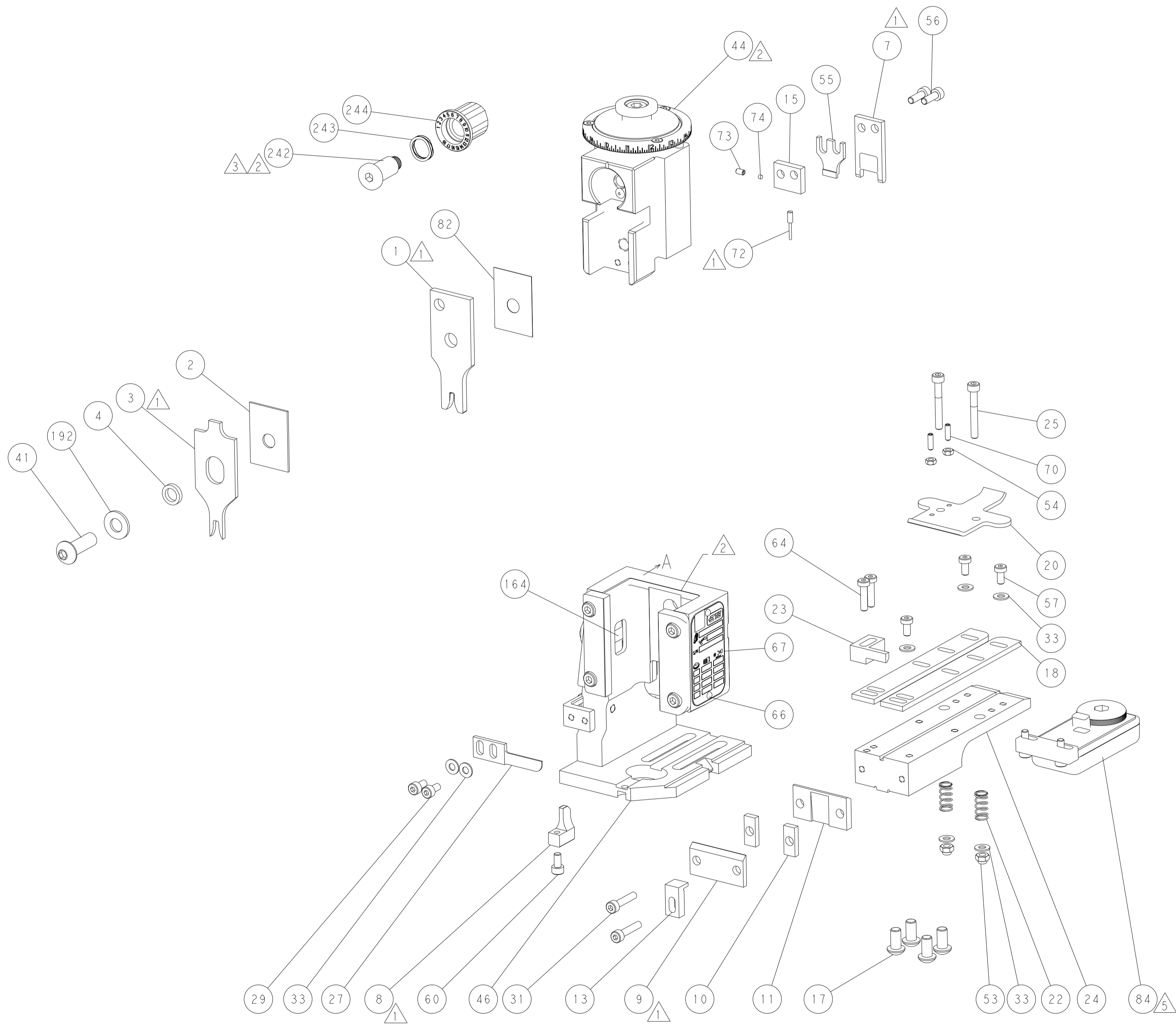
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		OWN: B. WEAVER 22JUN2015		TE Connectivity	
mm		0 PLC ±		CHK: T. ELBIN 22JUN2015		Harrisburg, PA 17105-3608	
		1 PLC ±		APVD: T. ELBIN 22JUN2015		NAME: Ocean End Feed Applicator	
		2 PLC ±		PRODUCT SPEC		SIZE: A1	
		3 PLC ±		APPLICATION SPEC		CAGE CODE: 00779	
		4 PLC ±		WEIGHT		DRAWING NO: 2150580	
		ANGLES		RESTRICTED TO		SCALE: 1:1	
		FINISH		SHEET 1 OF 4		REV H	
MATERIAL				Customer Accessible Production Drawing			

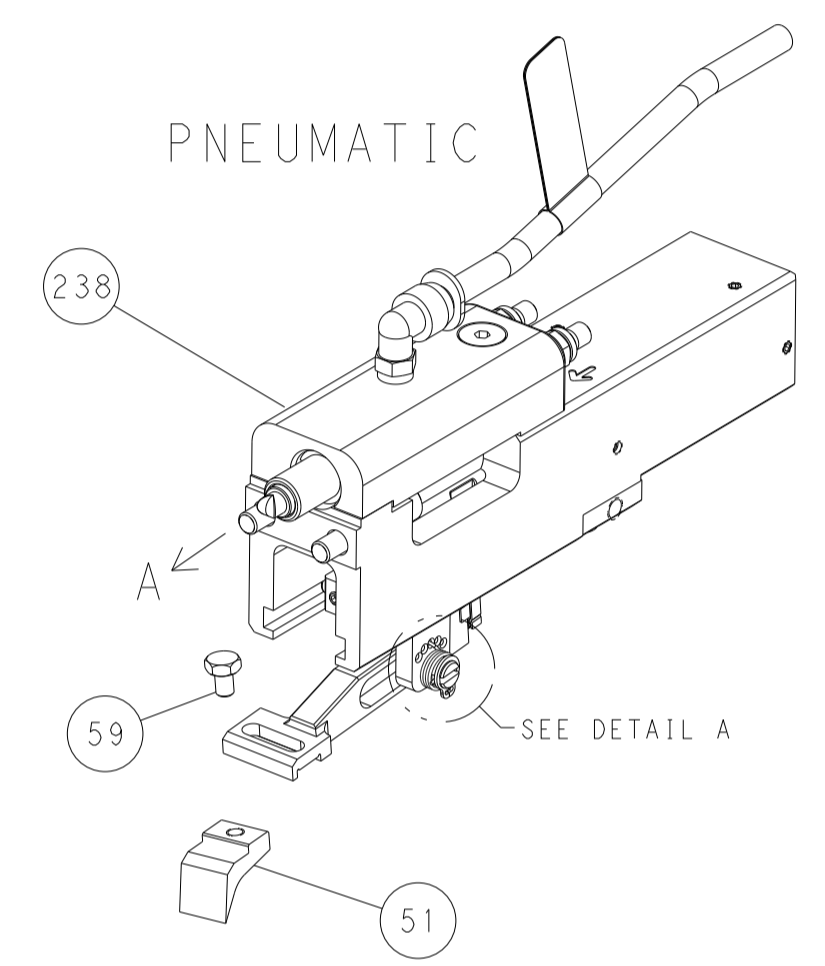
LOC	DIST	REVISIONS			
P	LTN	DESCRIPTION	DATE	DMN	APVD
A	66	SEE SHEET 1	-	-	-



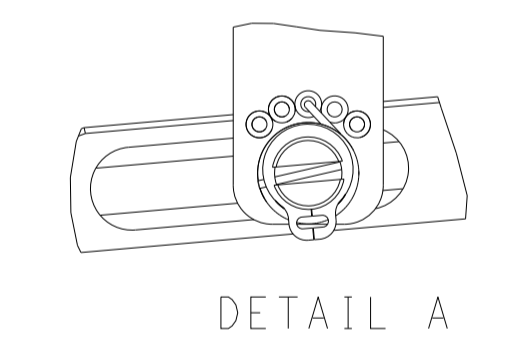
RAM SET-UP



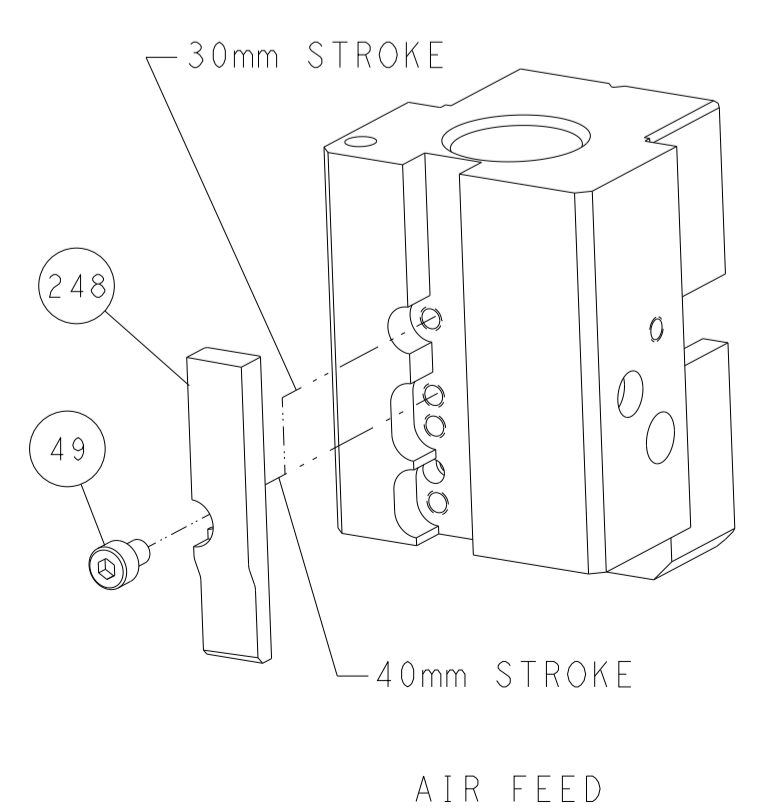
FEED TYPE



FEED SPRING SETTING POSITION



CAM POSITION

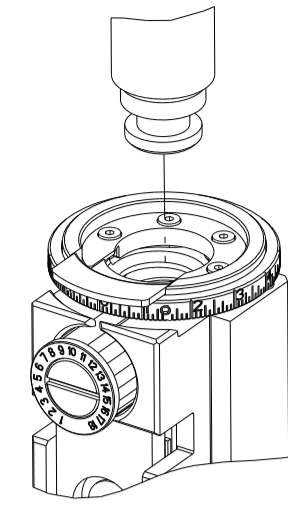


ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

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DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± MATERIAL - FINISH -		NAME Ocean End Feed Applicator PRODUCT SPEC - APPLICATION SPEC - WEIGHT - SCALE 1:1	SIZE A1 CAGE CODE 00779 DRAWING NO. C-2150580 SHEET 2 OF 4 REV H
Customer Accessible Production Drawing			

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COPYRIGHT 2015 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.			
PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150580-2	H	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150580-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.79 mm (.110)	F
INSUL	3.81 mm (.150)	F
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: Cluster Receptacle, Amplivar Type			
WIRE STRIP LENGTH 4.45-5.05 mm (.175-.199 IN)		INSULATION DIAMETER RANGE Ø2.20-2.80 mm (.087-.110 IN)	
TERMINAL APPLICATION SPECIFICATION 114-5242			
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
353937-1			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
(2) 18 MAG	1.67+/-0.05 [.066+/-0.002]	5.4
(1) 19.5 + (1) 19 MAG	1.60+/-0.05 [.063+/-0.002]	5.8
(1) 20.5 + (1) 20 MAG	1.50+/-0.05 [.059+/-0.002]	6.9
(2) 21.5 MAG	1.40+/-0.05 [.055+/-0.002]	8.1



- RECOMMENDED SPARE PARTS
- REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- 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 LUBRICANT IS RECOMMENDED.
- 6. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- FOR SPECIFIC WIRE COMBINATIONS SEE SPEC 114-5242.
- 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.

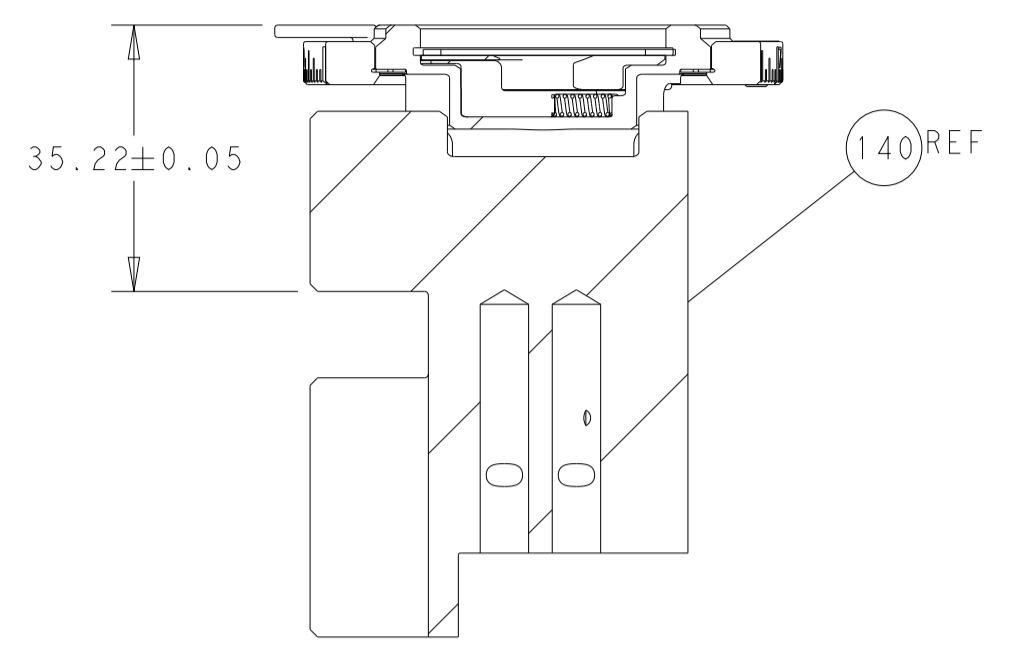
LOC	DIST	REVISIONS					
A	66	P	LTN	DESCRIPTION	DATE	OWN	APVD
		-		SEE SHEET 1	-	-	-

3	-	1	2119082-3	CAM, SNAIL, INSULATION ADJUSTMENT	244
	-	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
	-	1	2119083-1	RETAINER, INSULATION DIAL	242
	-	1	2844940-3	AIR FEED MODULE	238
	-	1	1-18028-0	WASHER, FLAT, REG M8	192
	-	4	2079383-9	SCR, BHSC, RoHS (M6 X 20)	186
	-	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
5	-	1	2119955-2	ASSY, LUBRICATOR, END FEED	84
	-	1	455888-1	SPACER, CRIMPER	82
	-	1	690191-5	PLUG, NYLON	74
	-	1	18031-1	SCR, SET, CUP POINT M3 X 5.0	73
1	-	1	1333249-1	PIN, FORMING	72
	-	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
	-	2	2168400-8	SHCS, LOW HEAD, RoHS, M4 X 16	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	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	56
	-	1	6-690518-0	HOLD DOWN, TERMINAL	55
	-	2	5018030-1	NUT, HEX, REG, RoHS, M3	54
	-	2	986965-8	NUT, LOCK, HEX, TORQUE (M4)	53
	-	1	2063961-1	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
	-	1	240639-2	STRIPPER (MACHINING)	27
	-	2	1-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 30	25
	-	1	1-1752371-0	PLATE, STRIP GUIDE	24
	-	1	240825-3	PLATE, STRIP HOLD DOWN	23
	-	2	22281-9	SPRING, COMPRESSION	22
	-	1	1803292-4	DRAG	20
	-	2	1901259-6	GUIDE, LOWER STRIP	18
	-	1	1333248-1	HOLDER, FORMING PIN	15
1	-	1	1752360-1	SPACER, HOLD-DOWN	13
	-	1	240833-4	PLATE, REAR SHEAR	11
	-	2	2-240645-7	SPACER, SHEAR PLATE	10
	-	1	690796-1	PLATE-FRONT SHEAR MINI APPLICATOR	9
1	1	1	5-1333219-1	ANVIL, COMBINATION	8
	-	1	8-240651-6	BLADE, SLUG	7
	-	-	-	-	6
	-	1	238011-4	BLOCK, CRIMPER SPACER	4
1	1	1	7-1633961-7	CRIMPER, INSULATION F PREMIUM	3
	-	1	1-455888-0	SPACER, CRIMPER	2
1	1	1	1-462808-9	CRIMPER, BLUNT F	1
	-	77-22	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)

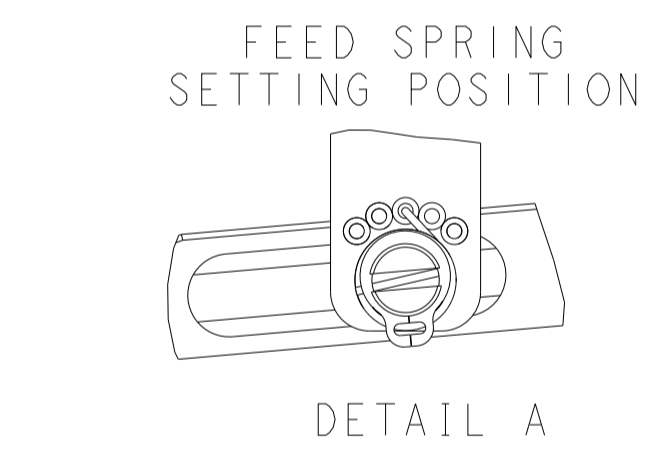
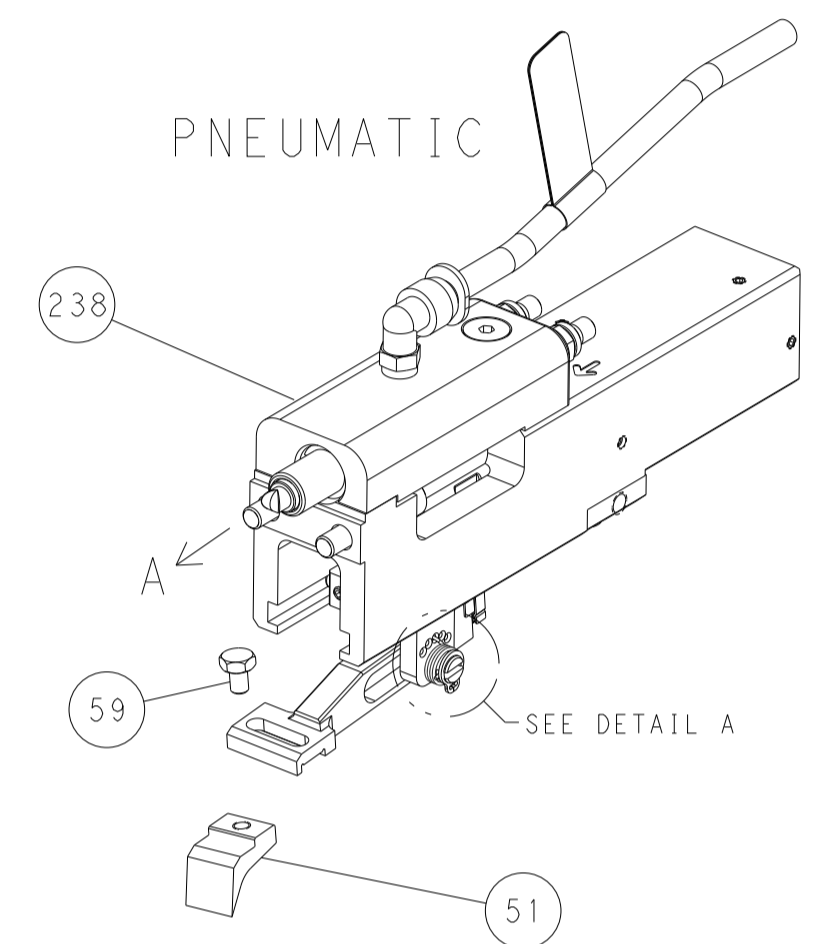
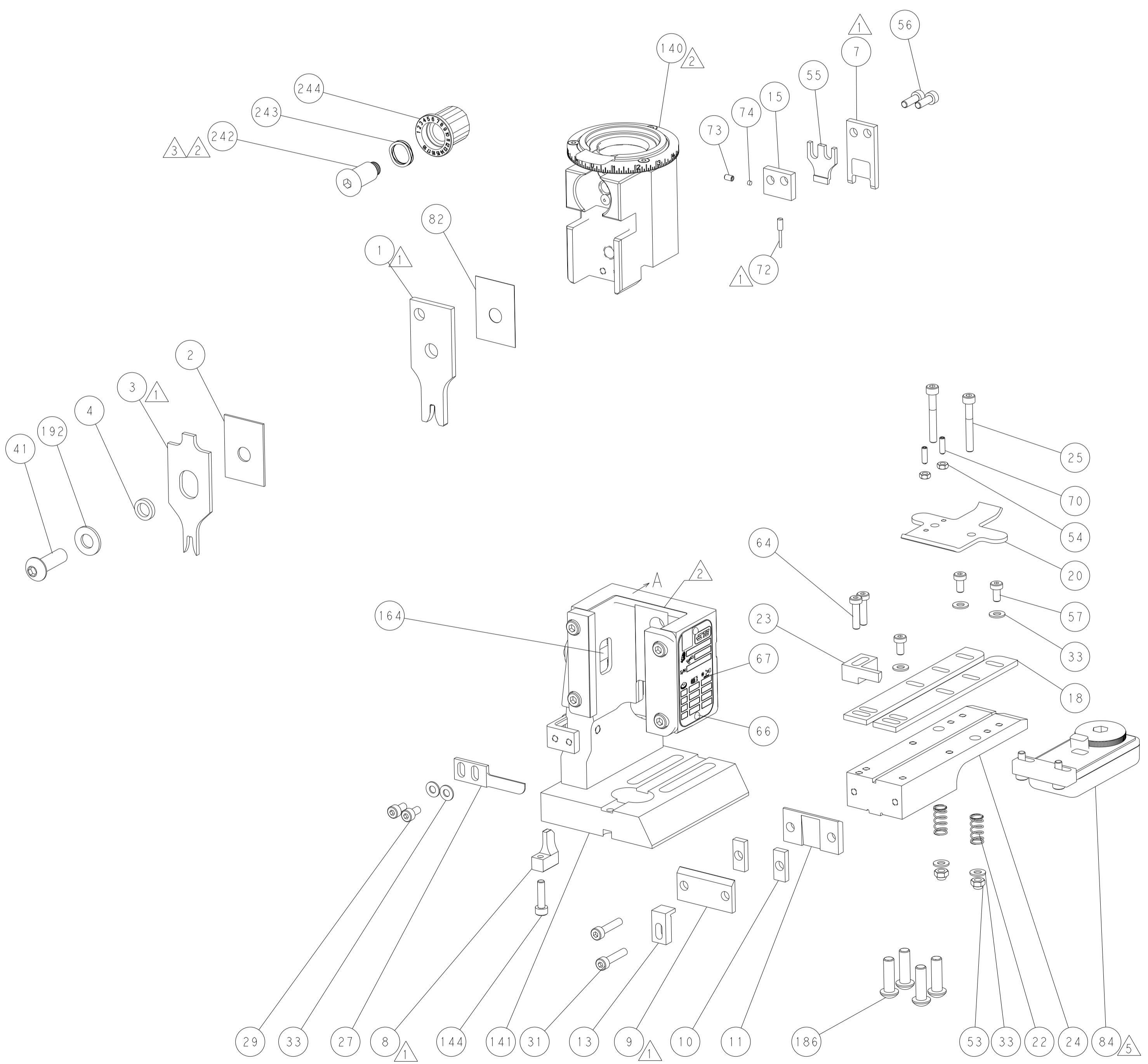
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		OWN: B. WEAVER 22JUN2015		TE Connectivity Harrisburg, PA 17105-3608	
0 PLC ±		1 PLC ±		CHK: T. ELBIN 22JUN2015		NAME: Ocean End Feed Applicator	
2 PLC ±		3 PLC ±		APVD: T. ELBIN 22JUN2015		SIZE: A1	
4 PLC ±		ANGLES FINISH		PRODUCT SPEC		CAGE CODE: 00779	
MATERIAL		FINISH		APPLICATION SPEC		DRAWING NO: C=2150580	
				WEIGHT		RESTRICTED TO: H	
				Customer Accessible Production Drawing		SCALE: 1:1 SHEET 3 OF 4 REV H	

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

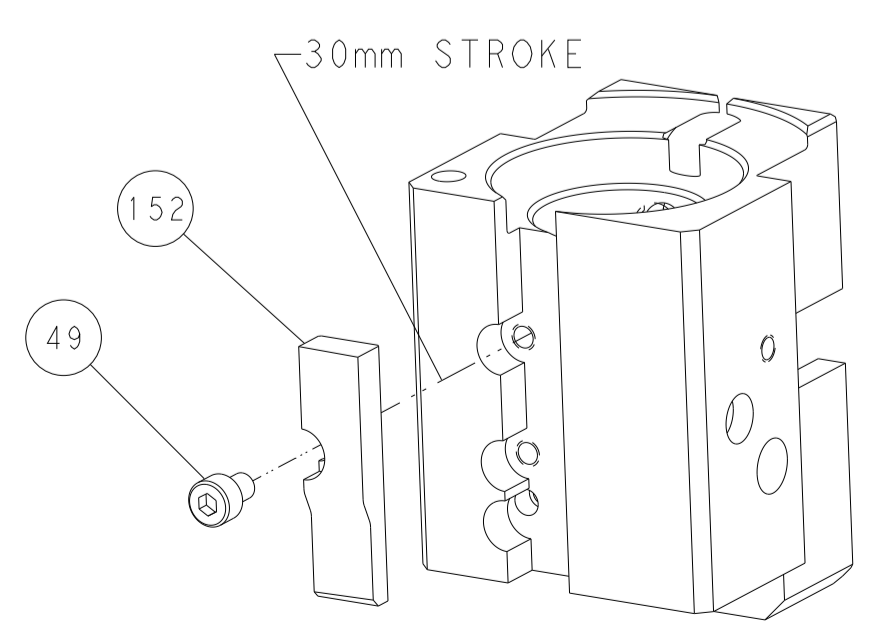


RAM SET-UP

FEED TYPE



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)

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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: - WEIGHT: - SCALE: 1:1	SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2150580 SHEET 4 OF 4 REV H
CUSTOMER ACCESSIBLE PRODUCTION DRAWING		RESTRICTED TO: -	