

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150629-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2150629-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150629-1	C	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2150629-2	C	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150629-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.27 mm [.050]	F
INSUL	-	-

APPL INSTRUCTIONS
408-35043

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION
TERMINAL NAME: TAB, WELD		
WIRE STRIP LENGTH 3.81-4.58 mm [.150-.180 IN]		INSULATION DIAMETER RANGE Ø2.20-3.00 mm [.087-.118 IN]
TERMINAL APPLICATION SPECIFICATION	NONE	-
TERMINALS APPLIED		
TE TERMINAL 62827-1	TE TERMINAL	TE TERMINAL

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
22 AWG	0.79 +/- 0.03 [.031 +/- .001]	6.5
24 AWG	0.71 +/- 0.03 [.028 +/- .001]	7.6

- 1 RECOMMENDED SPARE PARTS
- 2 REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- 3 APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 180.
- 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 GRIND TO LENGTH AT ASSEMBLY.
- 6. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- 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.

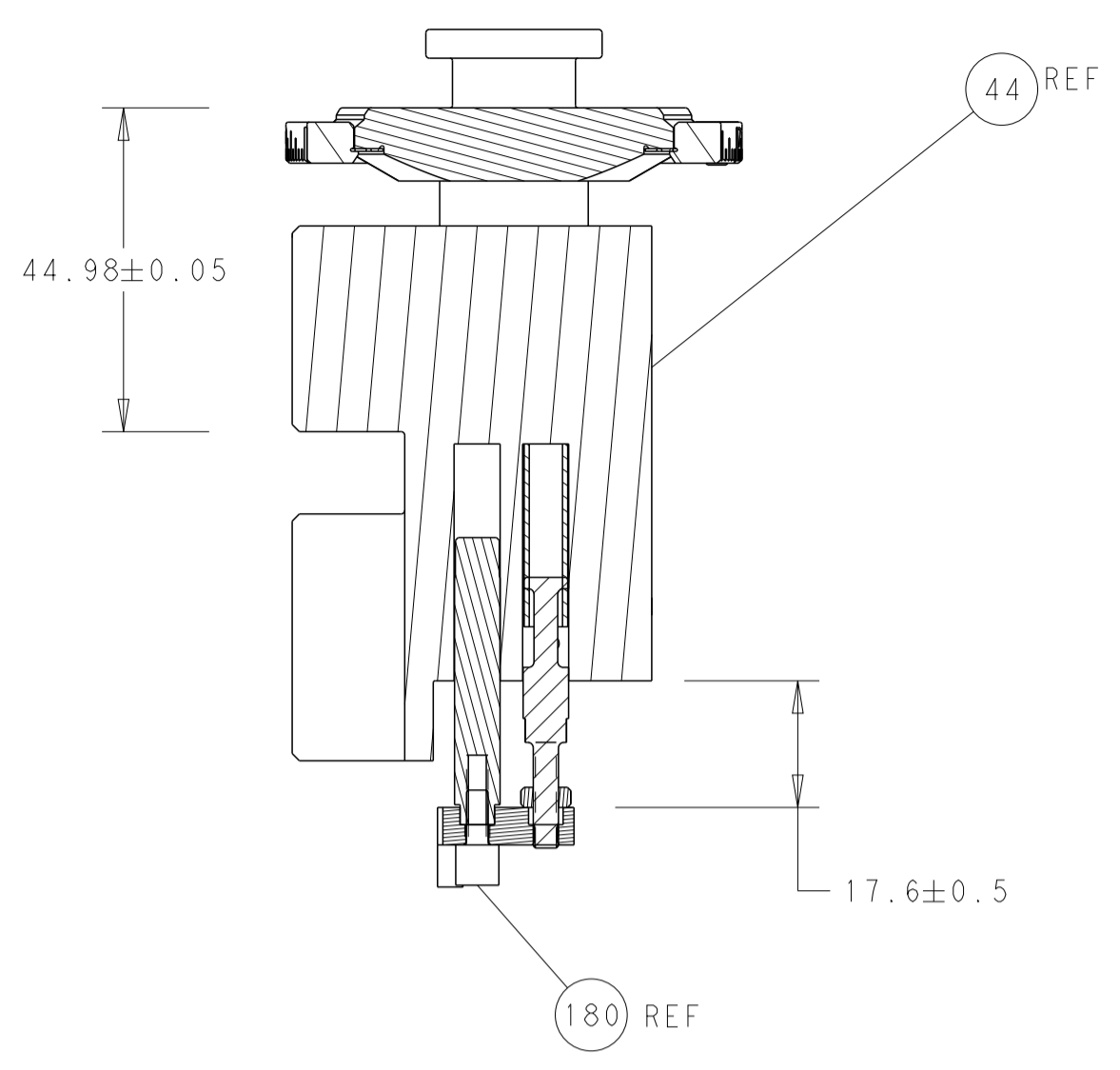
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

LOC	DIST	REVISIONS					
A	66	P	LTH	DESCRIPTION	DATE	OWN	APVD
		A		RELEASED	09DEC2015	BH	TE
		B		ECR-19-014820	23SEP2019	FJ	TE
		C		ECR-23-164017	17JAN2023	JWC	JH

-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248
-	-	1	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	1	-	1	-	2844940-3	AIR FEED MODULE	238
-	1	1	1	1	1-18028-0	WASHER, FLAT, REG M8	192
-	2	2	2	2	1-2168083-1	SCR, SKT HD CAP, RoHS, M3 X 6	191
-	1	1	1	1	1752354-7	STANDOFF, HOLD-DOWN	180
-	1	1	1	1	6-993111-6	PIN, SLOTTED SPRING 3.0 X 14.0	177
-	1	1	1	1	8-22280-7	SPRING, COMPRESSION	176
-	1	1	1	1	1752353-2	GUIDE PIN, HOLDDOWN	175
-	1	1	1	1	1901680-2	GUIDE PIN, HOLDDOWN	174
-	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	1	1	1	1	2119955-2	ASSY, LUBRICATOR, END FEED	84
-	1	1	1	1	455888-5	SPACY, CRIMPER	82
-	1	1	1	1	1803607-4	DOCUMENTATION PACKAGE	71
-	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	1901681-1	HOLDDOWN, TERMINAL	65
-	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	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	56
-	2	2	2	2	986965-8	NUT, LOCK, HEX, TORQUE (M4)	53
-	1	1	1	1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52
-	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	1803602-3	SCR, BHSC, RoHS (M8 X 12)	41
-	8	8	8	8	1-18028-2	WASHER, FLAT, REG M4	33
-	2	2	2	2	5018030-1	NUT, HEX, REG, RoHS, M3	32
-	2	2	2	2	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	31
-	2	2	2	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	29
-	1	1	1	1	240639-1	STRIPPER (MACHINING)	27
-	2	2	2	2	3-18032-3	SCR, SET, FLT PNT, M3 X 20.0	26
-	2	2	2	2	1-2168083-6	SCR, SKT HD CAP, RoHS, M4 X 35	25
-	1	1	1	1	1752371-5	PLATE, STRIP GUIDE	24
-	2	2	2	2	22281-8	SPRING, COMPRESSION	22
-	1	1	1	1	1633168-6	ARM, STOCK DRAG	21
-	1	1	1	1	464452-4	DRAG, STOCK	20
-	2	2	2	2	1901259-1	GUIDE, LOWER STRIP	18
-	4	4	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17
-	1	1	1	1	1-240641-6	SPACER	16
-	1	1	1	1	1752360-1	SPACER, HOLD-DOWN	13
-	1	1	1	1	240644-9	PLATE, REAR SHEAR	11
-	2	2	2	2	1-240645-7	SPACER, SHEAR PLATE	10
-	1	1	1	1	240642-1	PLATE, FRONT SHEAR	9
1	2	2	1	1	1-1803002-7	ANVIL, COMBINATION, END FEED	8
-	1	1	1	1	8-240651-8	BLADE, SLUG	7
-	-	-	-	-	-	-	6
-	1	1	1	1	1-240641-2	SPACER	5
-	-	-	-	-	-	-	3
-	-	-	-	-	-	-	2
1	2	2	1	1	5-1633588-0	CRIMPER, WIRE	1
-	77	72	71	2	-1	PART NO	ITEM NO

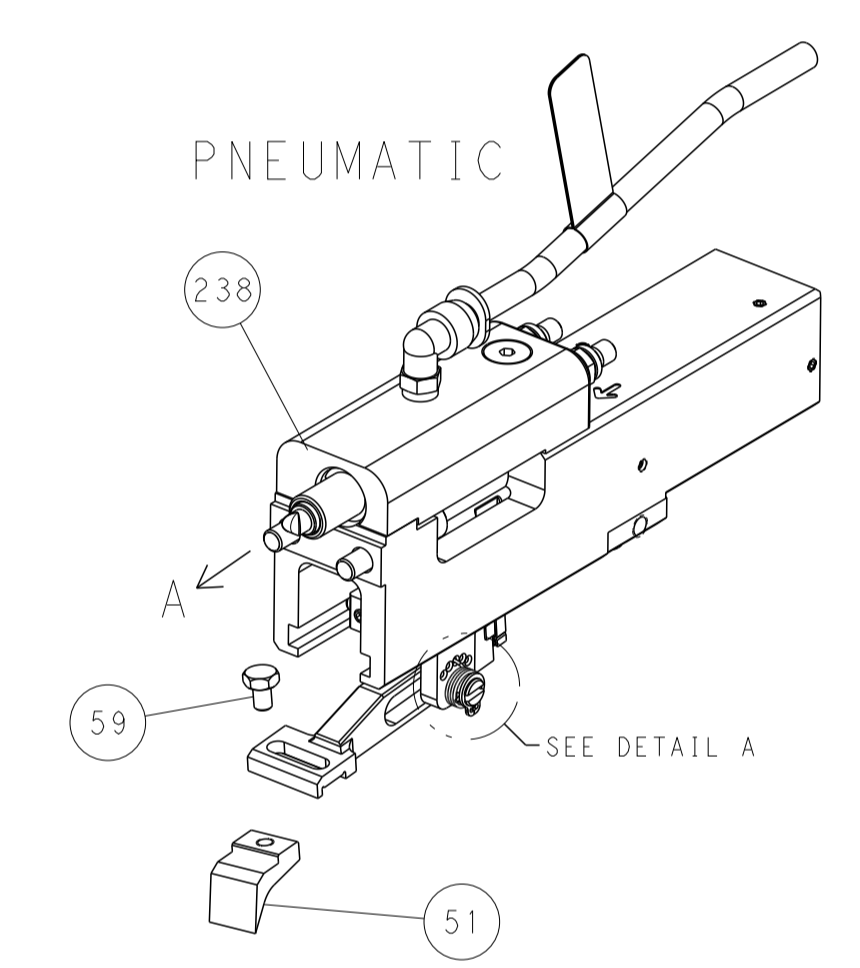
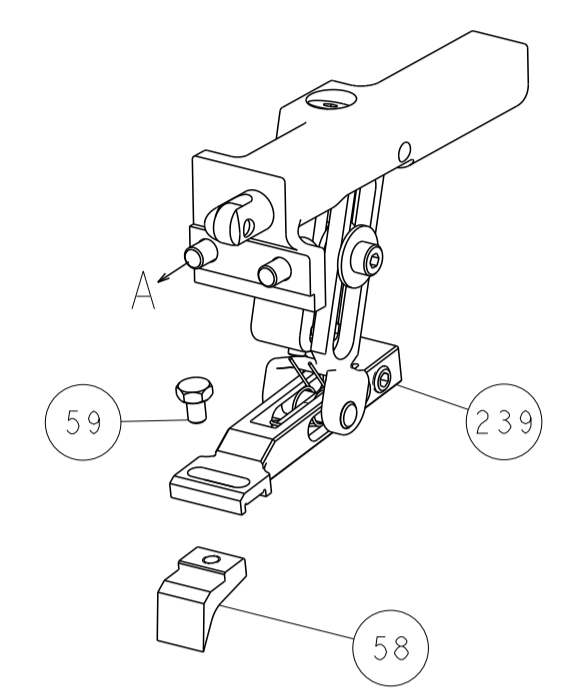
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mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES ±	FINISH ±
MATERIAL:				WEIGHT:		SCALE:	
Customer Accessible Production Drawing				SCALE: 1:1		SHEET 1 OF 4	

LOC	DIST	REV	DESCRIPTION	DATE	OWN	APVD
A	66		SEE SHEET 1			

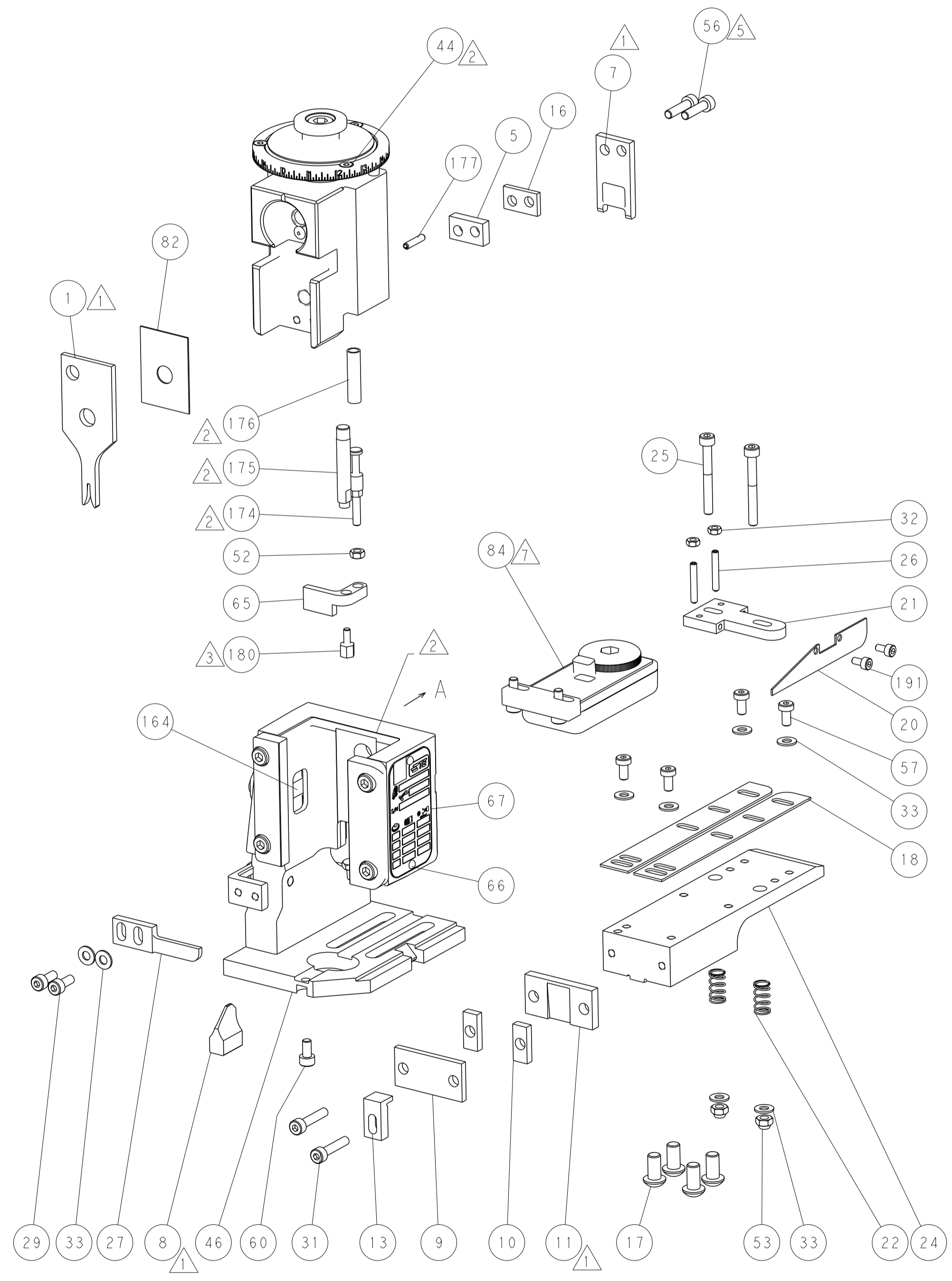
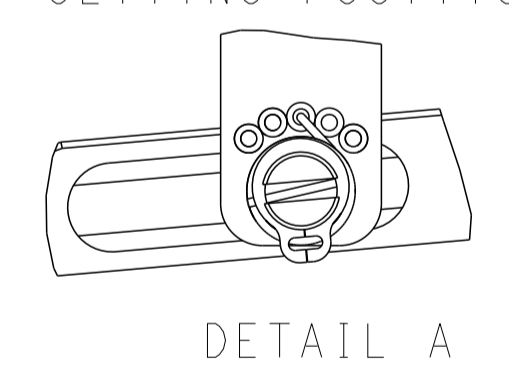


RAM AND HOLDDOWN SET-UP

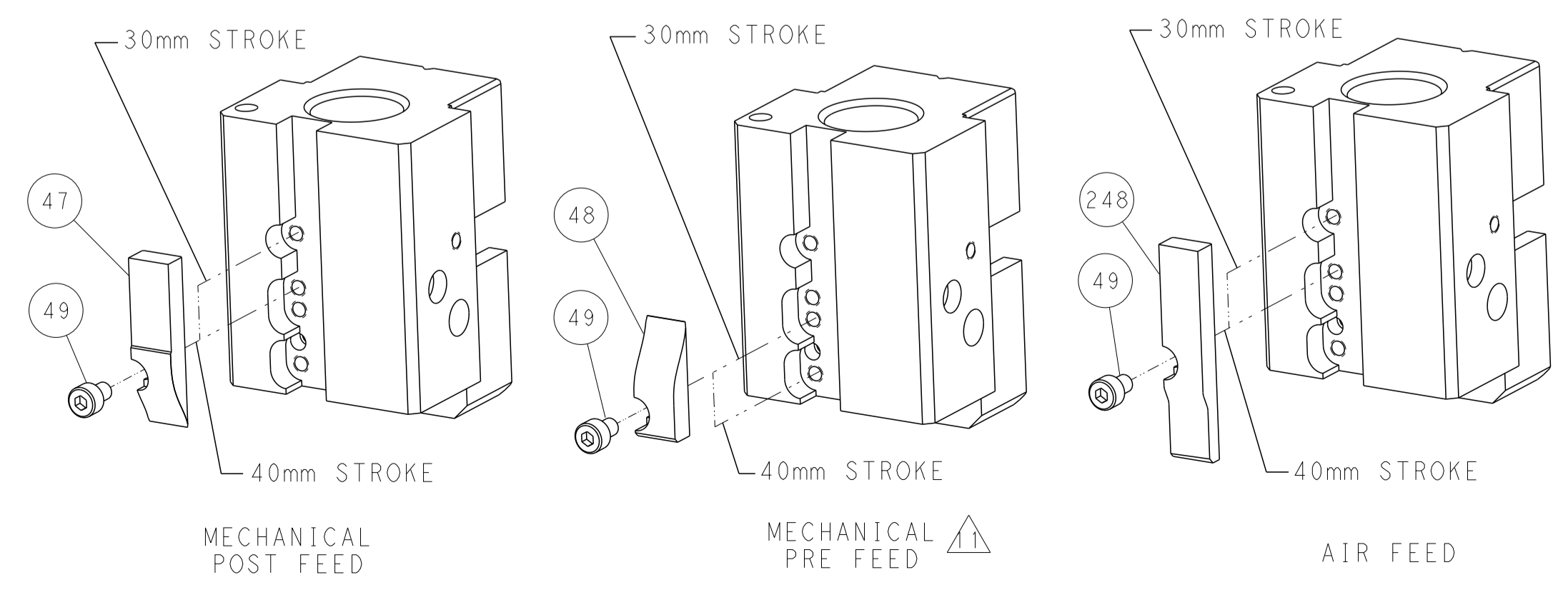
FEED TYPE MECHANICAL



FEED SPRING SETTING POSITION



CAM POSITIONS

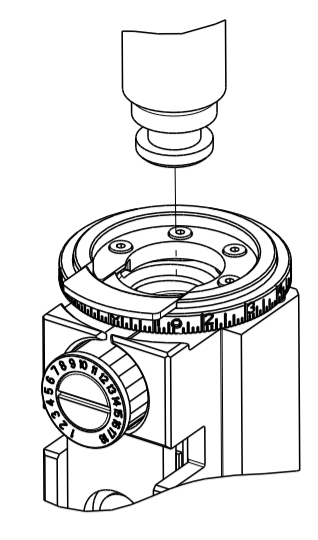


ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

<small>THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.</small>		DWN BOB HIGMAN 20OCT2015 CHK T. ELBIN 20OCT2015 APVD T. ELBIN 20OCT2015	TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH		NAME Ocean End Feed Applicator PRODUCT SPEC APPLICATION SPEC SIZE CAGE CODE DRAWING NO A1 00779 ©=2150629	RESTRICTED TO SCALE 1:1 SHEET 2 OF 4 REV C
MATERIAL:		WEIGHT:	Customer Accessible Production Drawing

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150629-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2150629-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150629-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
 INTERFACE ADAPTER



APPLICATOR DATA

CRIMP	SIZE	TYPE
WIRE	1.27 mm (.050)	F
INSUL	-	-

APPL INSTRUCTIONS
 408-35043

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION

TERMINAL NAME: TAB, WELD

WIRE STRIP LENGTH	INSULATION DIAMETER RANGE
3.81-4.58 mm (.150-.180 IN)	Ø2.20-3.00 mm (.087-.118 IN)

TERMINAL APPLICATION SPECIFICATION

TERMINALS APPLIED

TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
62827-1			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
22 AWG	0.79+/-0.03 [.031+/-0.001]	6.5
24 AWG	0.71+/-0.03 [.028+/-0.001]	7.6



- 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 ITEMS 180.
- 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.
- GRIND TO LENGTH AT ASSEMBLY.
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- TERMINAL LUBRICANT IS RECOMMENDED.

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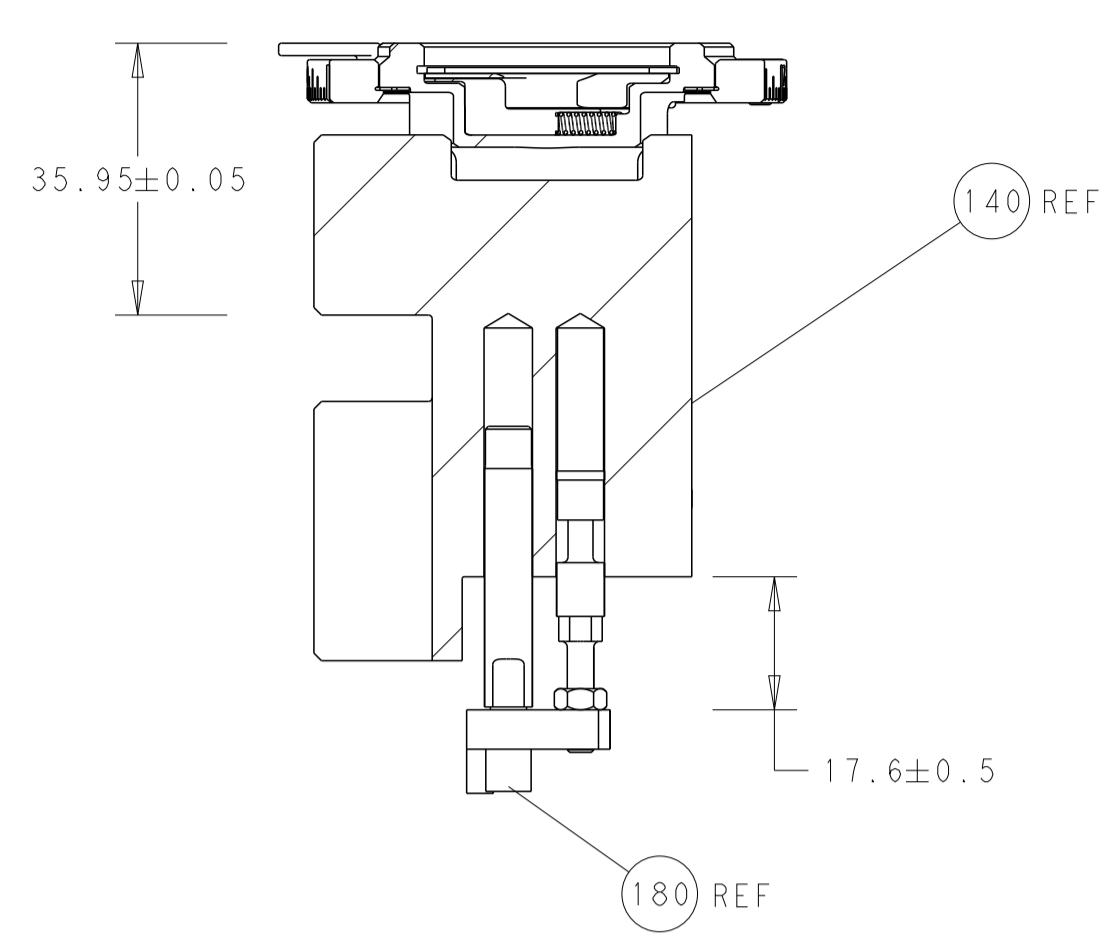
PACIFIC VERSION
 Shown on sheets 3 of 4 & 4 of 4
 (Atlantic version shown on sheets 1 of 4 & 2 of 4)

LOC	DIST	REV	DATE	BY	APPV
A	66				

REV	DATE	BY	APPV	DESCRIPTION	QTY
-	-	1		2119580-1 MECHANICAL FEED ASSEMBLY	239
-	1	-		2844940-3 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
-	4	4		2079383-9 SCR, BHSC, RoHS (M6 X 20)	186
-	1	1		1752354-7 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	-		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
-	1	1		2119955-2 ASSY, LUBRICATOR, END FEED	84
-	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
-	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		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	-		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		1803602-3 SCR, BHSC, RoHS (M8 X 12)	41
-	8	8		1-18028-2 WASHER, FLAT, REG M4	33
-	2	2		5018030-1 NUT, HEX, REG, RoHS, M3	32
-	2	2		2168083-9 SCR, SKT HD CAP, RoHS, M4 X 20	31
-	2	2		1-2168083-0 SCR, SKT HD CAP, RoHS, M4 X 10	29
-	1	1		240639-1 STRIPPER (MACHINING)	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		1752371-5 PLATE, STRIP GUIDE	24
-	2	2		22281-8 SPRING, COMPRESSION	22
-	1	1		1633168-6 ARM, STOCK DRAG	21
-	1	1		464452-4 DRAG, STOCK	20
-	2	2		1901259-1 GUIDE, LOWER STRIP	18
-	1	1		1-240641-6 SPACER	16
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-	1	1		240644-9 PLATE, REAR SHEAR	11
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-	1	1		240642-1 PLATE, FRONT SHEAR	9
-	1	1		1-1803002-7 ANVIL, COMBINATION, END FEED	8
-	1	1		8-240651-8 BLADE, SLUG	7
-	-	-		-	6
-	1	1		1-240641-2 SPACER	5
-	-	-		-	3
-	-	-		-	2
-	1	1		5-1633588-0 CRIMPER, WIRE	1
-	77-22-21			PART NO DESCRIPTION ITEM NO	

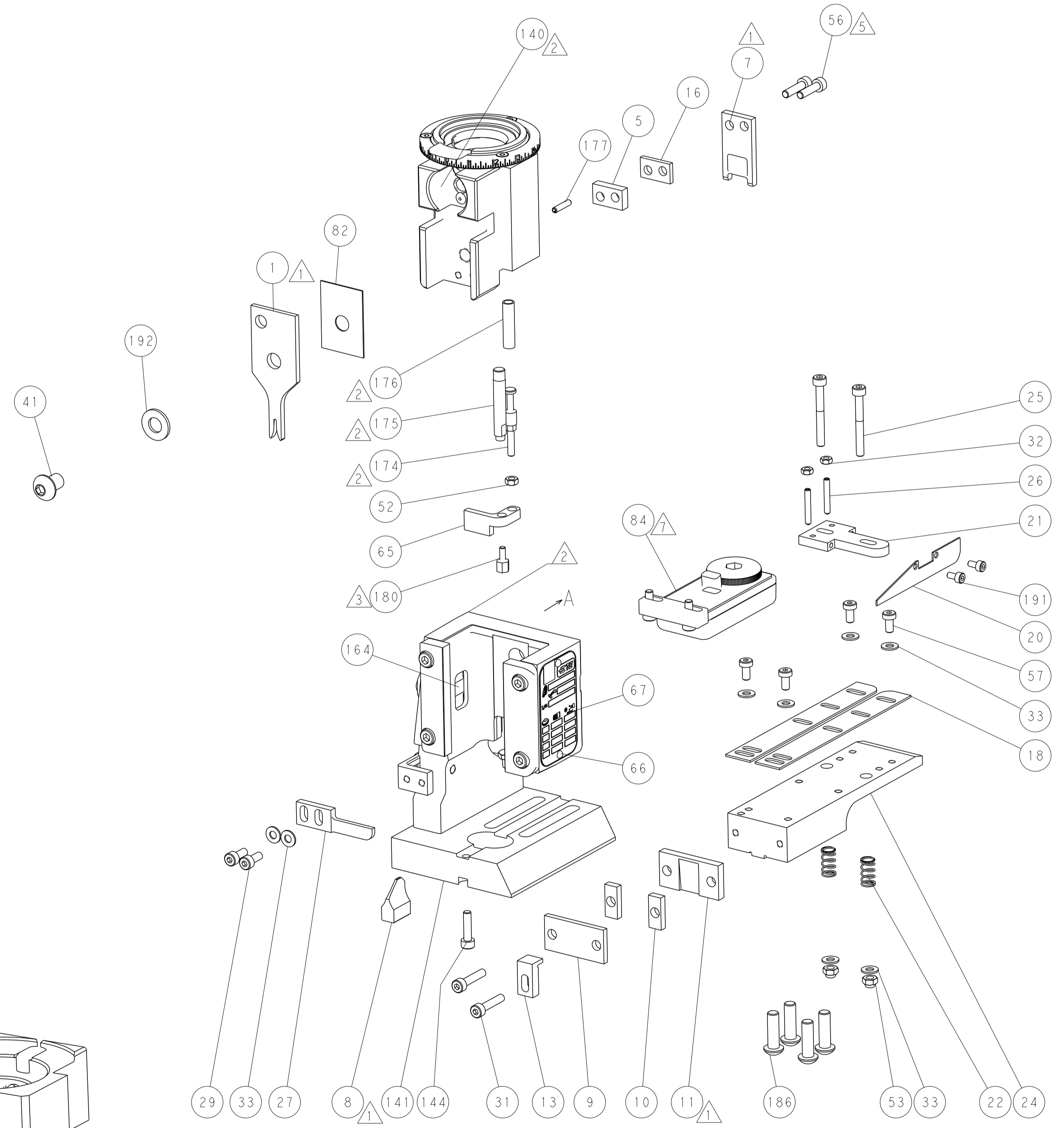
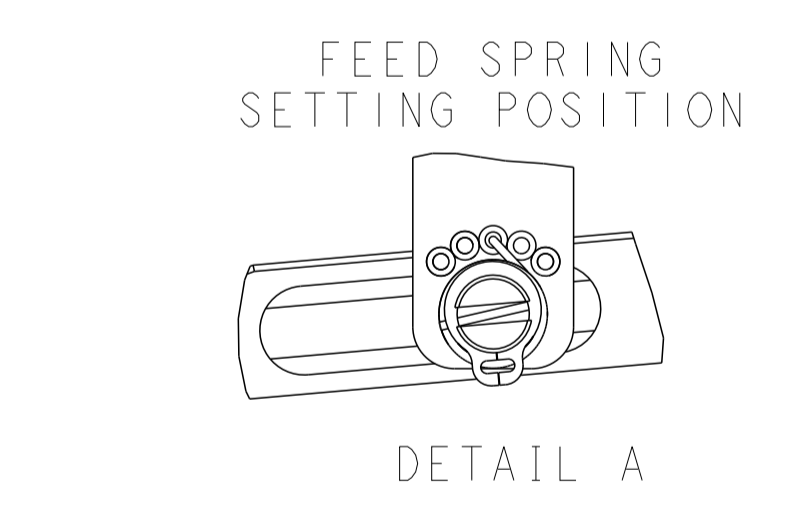
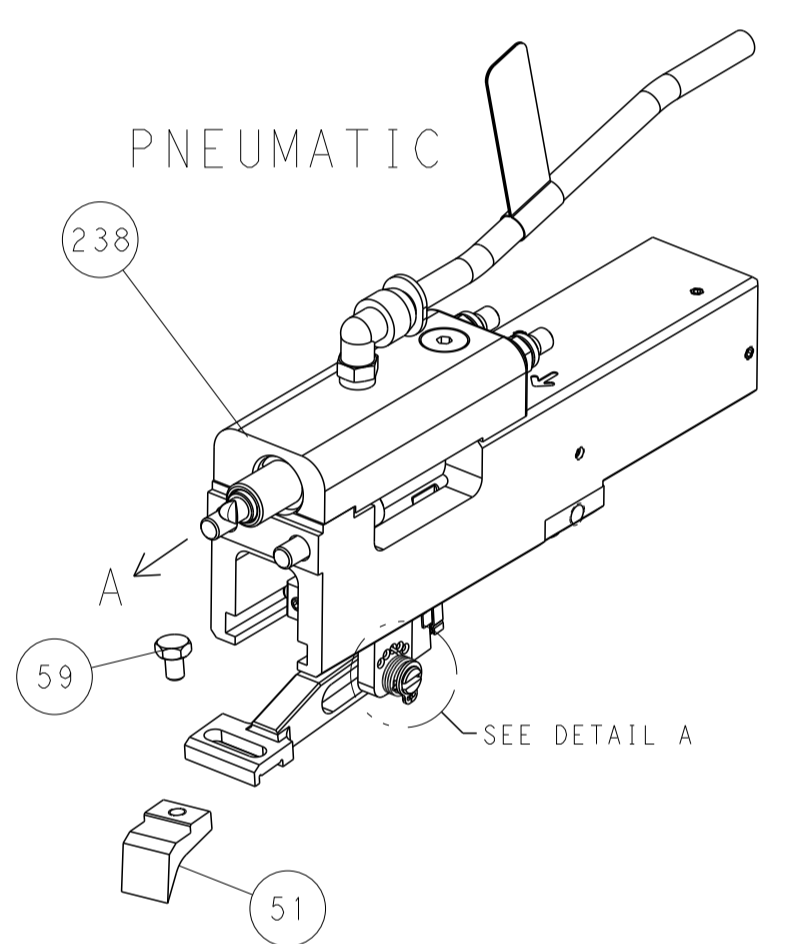
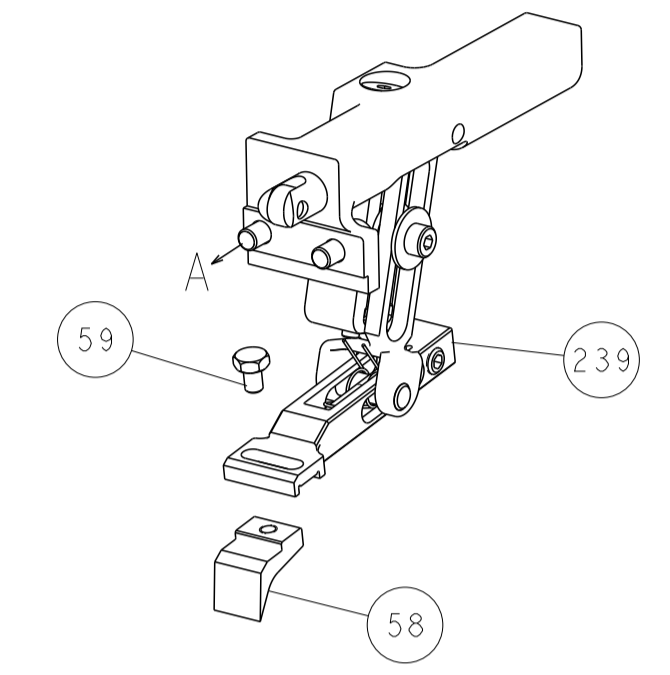
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG: BOB HIGMAN 20OCT2015		CHK: T. ELBIN 20OCT2015		APVD: T. ELBIN 20OCT2015		NAME: Ocean End Feed Applicator	
0 PLC ±		1 PLC ±		2 PLC ±		3 PLC ±		4 PLC ±		SIZE: A1	
MATERIAL:		FINISH:		WEIGHT:		SCALE: 1:1		SHEET: 3 OF 4		REV: C	

LOC	DIST	REV	DESCRIPTION	DATE	OWN	APVD
A	66		SEE SHEET 1			

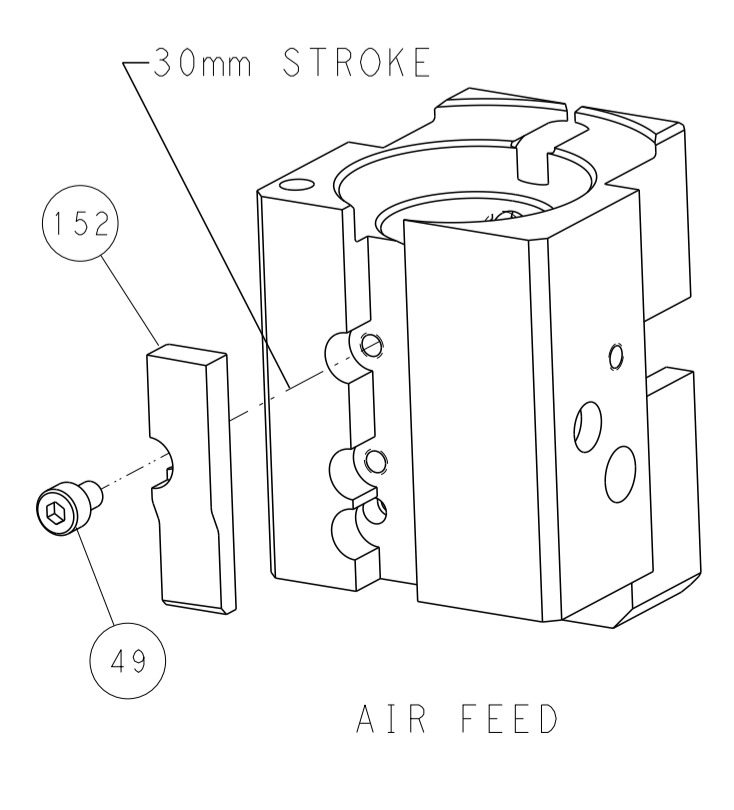
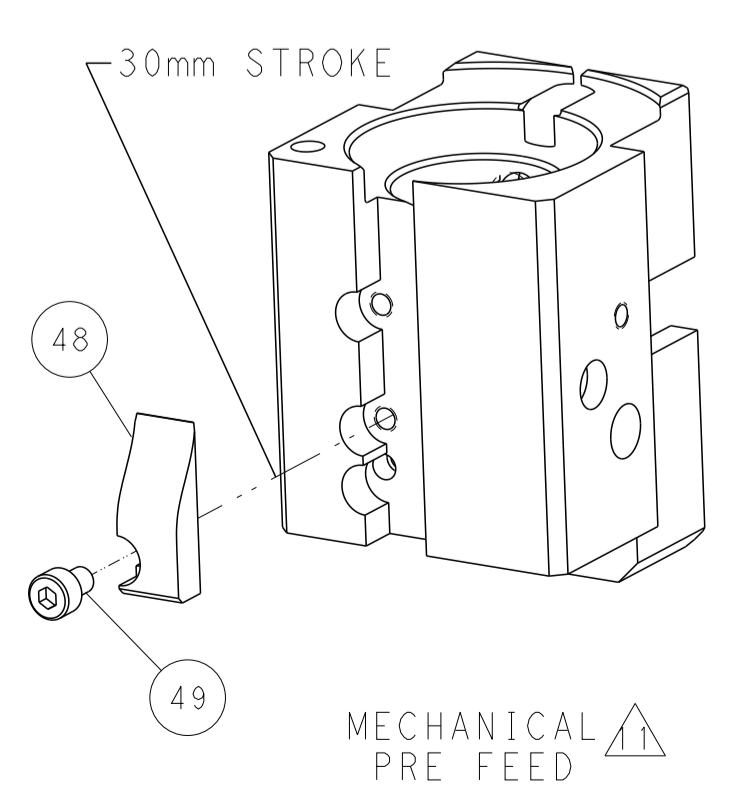
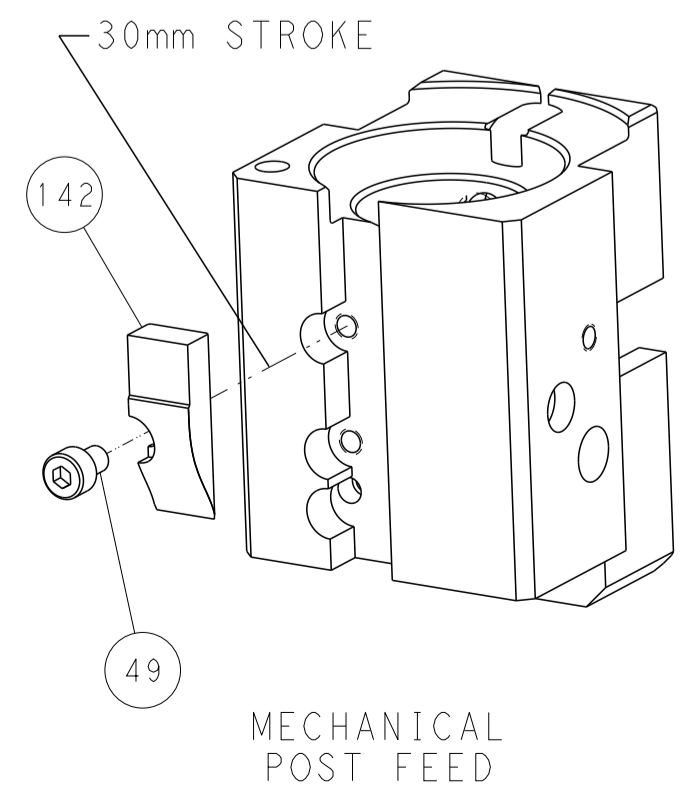


RAM AND HOLDDOWN SET-UP

FEED TYPE
MECHANICAL



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: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH		DWN BOB HIGMAN 20OCT2015 CHK T. ELBIN 20OCT2015 APVD T. ELBIN 20OCT2015 PRODUCT SPEC APPLICATION SPEC WEIGHT Customer Accessible Production Drawing		NAME Ocean End Feed Applicator SIZE CAGE CODE DRAWING NO. A1 00779 C=2150629 SCALE 1:1 SHEET 4 OF 4 REV C		RESTRICTED TO	
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