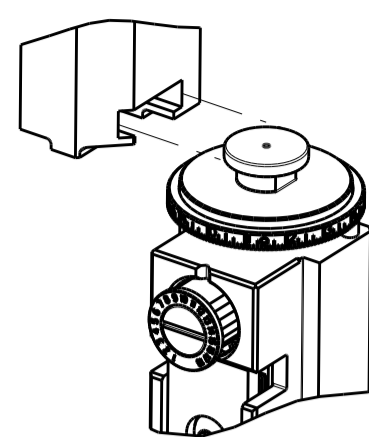


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150645-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2150645-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150645-1	C	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2150645-2	C	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150645-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	3.56 mm [1.40]	F
INSUL	-	-

APPL INSTRUCTIONS 408-35043

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION
TERMINAL NAME: RING TERMINAL		
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE
5.34-6.10 mm [1.210-.240 IN]		∅ -
TERMINAL APPLICATION SPECIFICATION	114-2084	-
TERMINALS APPLIED		
TE TERMINAL	TE TERMINAL	TE TERMINAL
42716-2		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
14 AWG	2.31+/-0.05 [1.091+/-0.002]	6.3
16 AWG	2.13+/-0.05 [1.084+/-0.002]	8.8
18 AWG	2.03+/-0.05 [1.080+/-0.002]	9.9

- 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 ITEM 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. 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.

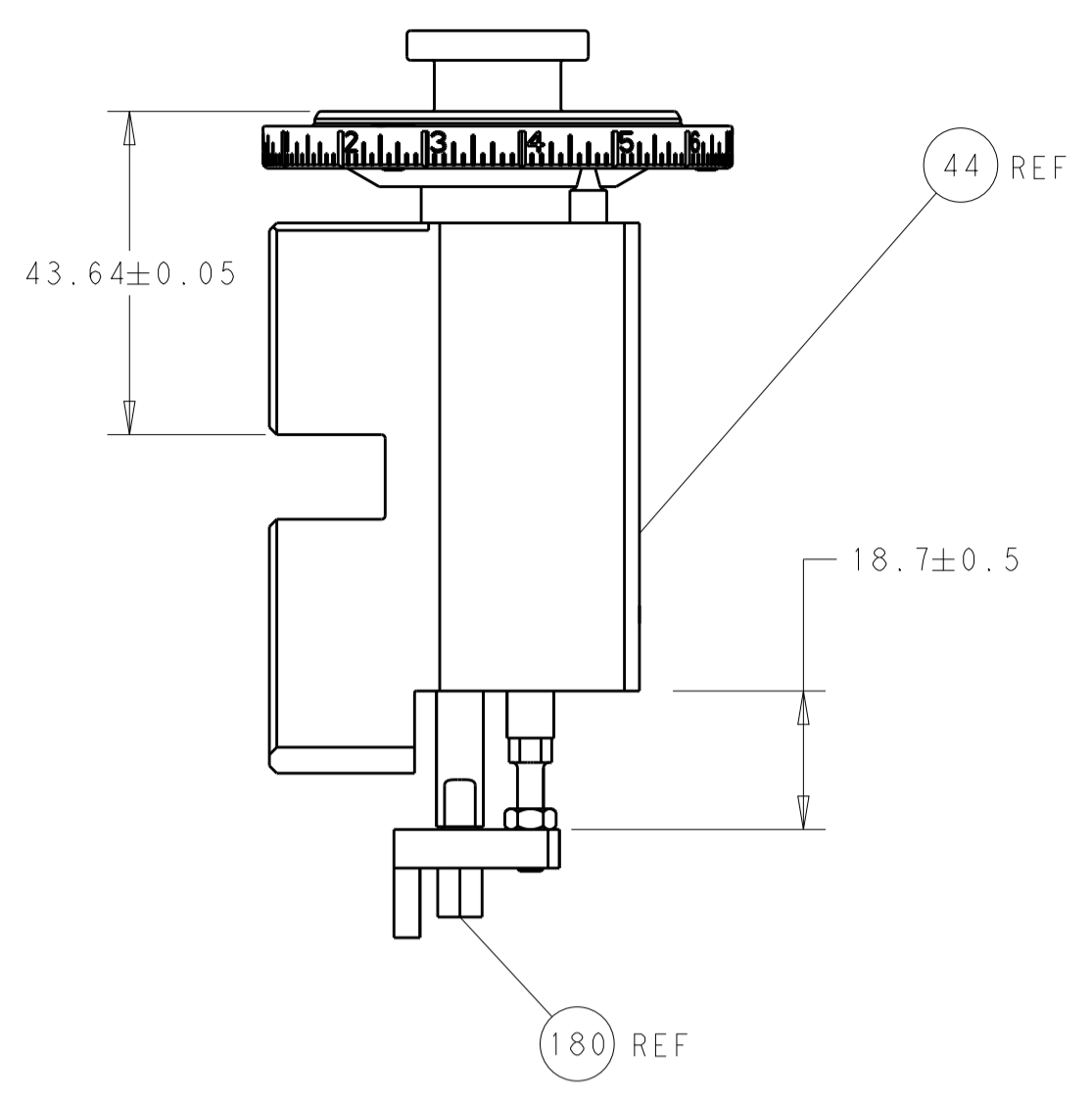
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		B		ECR-19-002019	07FEB2019	TB	TE
		C		ECR-19-004188	15MAR2019	FZ	YY

-	1	-	1	-	2119640-1	PUSH ROD, AIR FEED	250	
-	1	-	1	-	1803259-1	BUSHING, FLANGED	249	
-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248	
-	-	1	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239	
-	1	-	1	-	2063440-1	AIR FEED MODULE	238	
3	-	1	1	1	1-1752354-1	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	
-	2	-	2	-	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172	
-	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164	
-	1	-	1	-	240638-1	SPRING, FEED FINGER	163	
-	1	-	1	-	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854	137	
-	1	1	1	1	455888-4	SPACER, CRIMPER	82	
-	1	1	1	1	1803607-2	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	2-1901681-9	HOLDDOWN, TERMINAL	65	
-	1	1	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	
-	-	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	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	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	1	1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52	
-	1	-	1	-	2119792-1	PAWL, EF, AIR	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	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	31	
-	2	2	2	2	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	29	
-	1	1	1	1	240639-4	STRIPPER (MACHINING)	27	
-	2	2	2	2	1-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 30	25	
-	1	1	1	1	1752371-5	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	1-1901696-9	STRIP GUIDE, REAR	19	
-	1	1	1	1	1-1901695-9	STRIP GUIDE, FRONT	18	
-	4	4	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17	
-	1	1	1	1	1752360-1	SPACER, HOLD-DOWN	13	
1	-	1	-	1	240644-9	PLATE, REAR SHEAR	11	
1	-	2	-	2	1-240645-6	SPACER, SHEAR PLATE	10	
1	-	1	-	1	240642-4	PLATE, FRONT SHEAR	9	
1	2	2	1	1	1-1333224-5	ANVIL, COMBINATION (E.F. WIRE/B ONLY)	8	
1	-	1	-	1	3-691157-1	BLADE, SHEAR -	7	
-	-	-	-	-	-	-	6	
-	1	1	1	1	240641-7	SPACER	5	
-	-	-	-	-	-	-	3	
-	-	-	-	-	-	-	2	
1	1	2	2	1	1	456411-3	CRIMPER, WIRE PREMIUM	1
-	77	-	72	-	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)

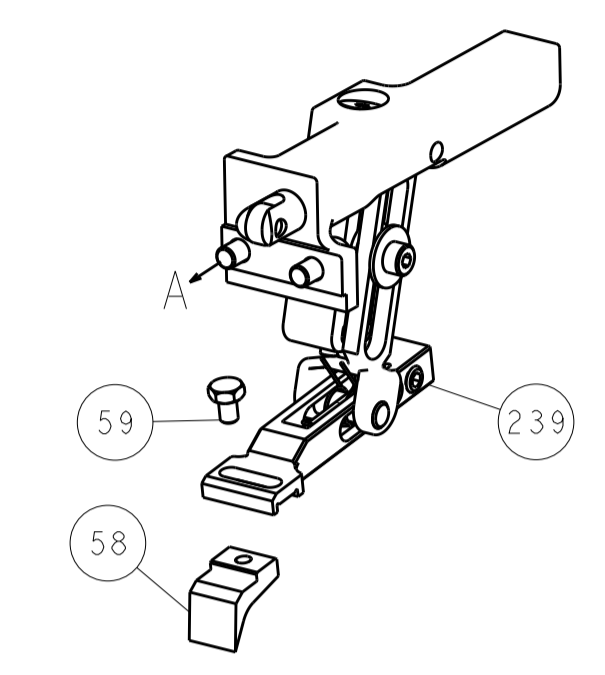
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG		NAME	
mm	0 PLC ±	1 PLC ±	2 PLC ±	J. HOU	25JAN2016	STE TE Connectivity Harrisburg, PA 17105-3608	
	3 PLC ±	4 PLC ±	ANGLES ±	L. ZHANG	25JAN2016	Ocean End Feed Applicator	
MATERIAL	FINISH	WEIGHT	SCALE	APVD	U. GUO	25JAN2016	RESTRICTED TO
-	-	-	1:1	-	-	-	Customer Accessible Production Drawing
				SIZE	CAGE CODE	DRAWING NO	SHEET 1 OF 4
				A1	00779	2150645	REV C

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

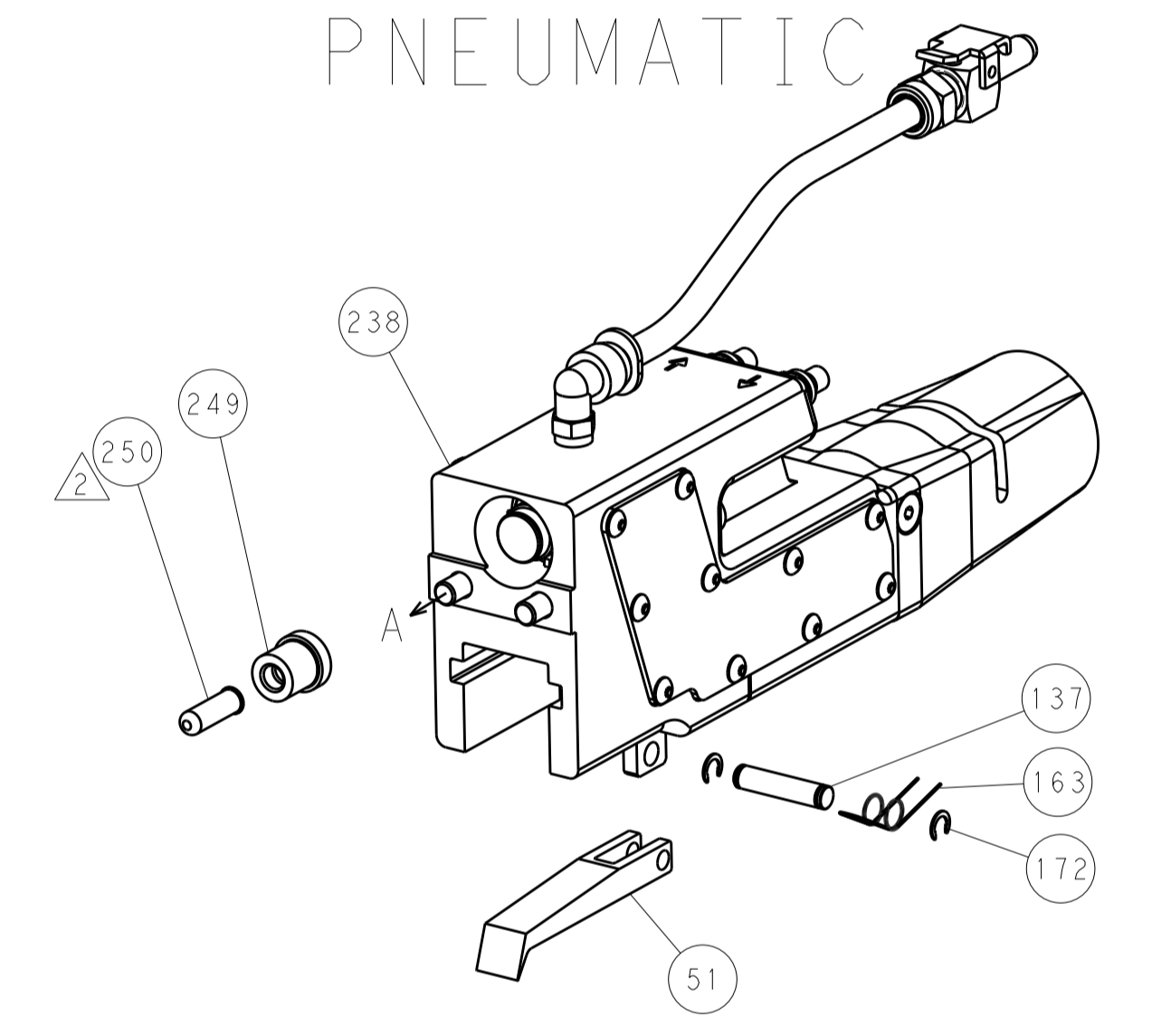


RAM AND HOLDDOWN SET-UP

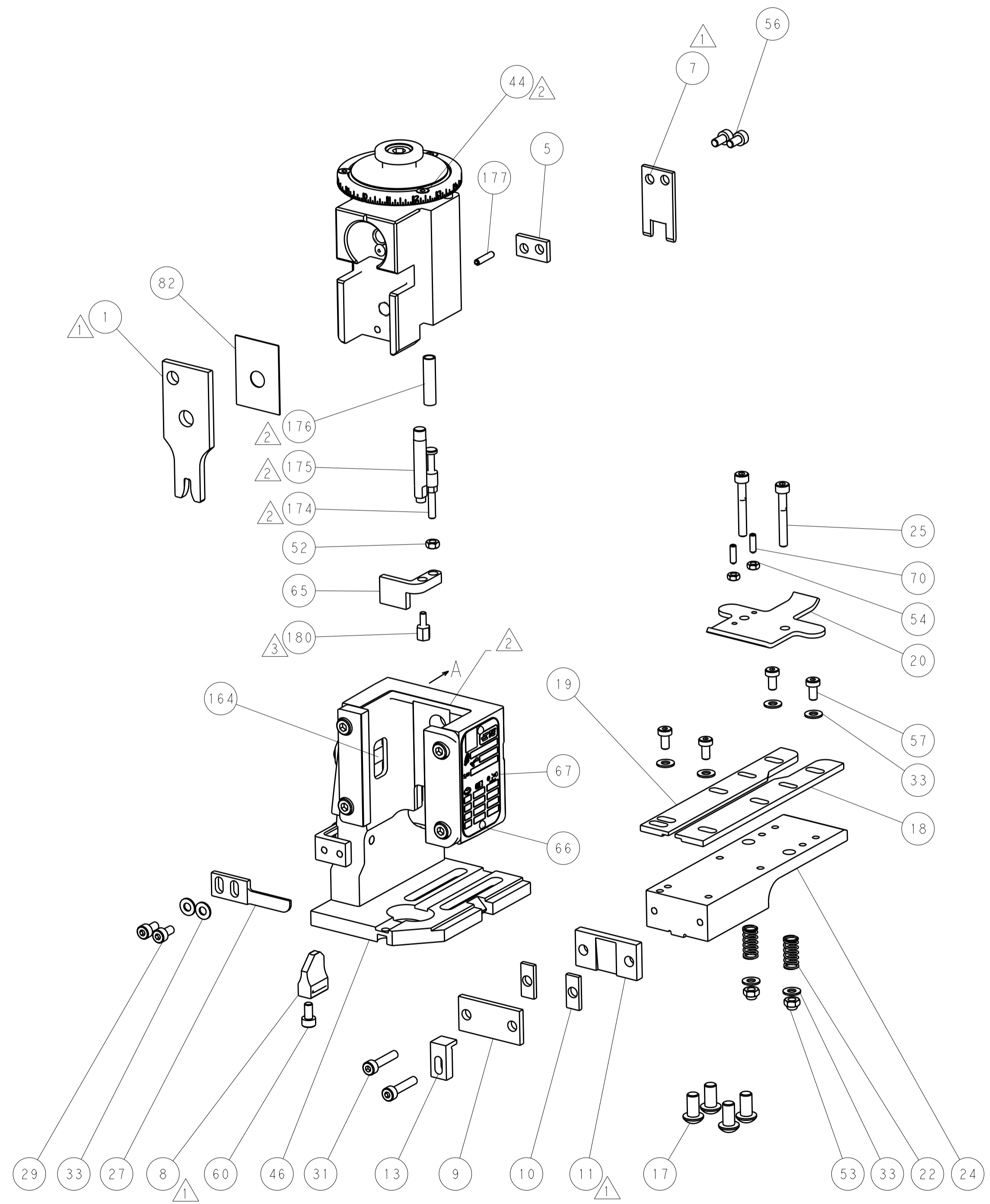
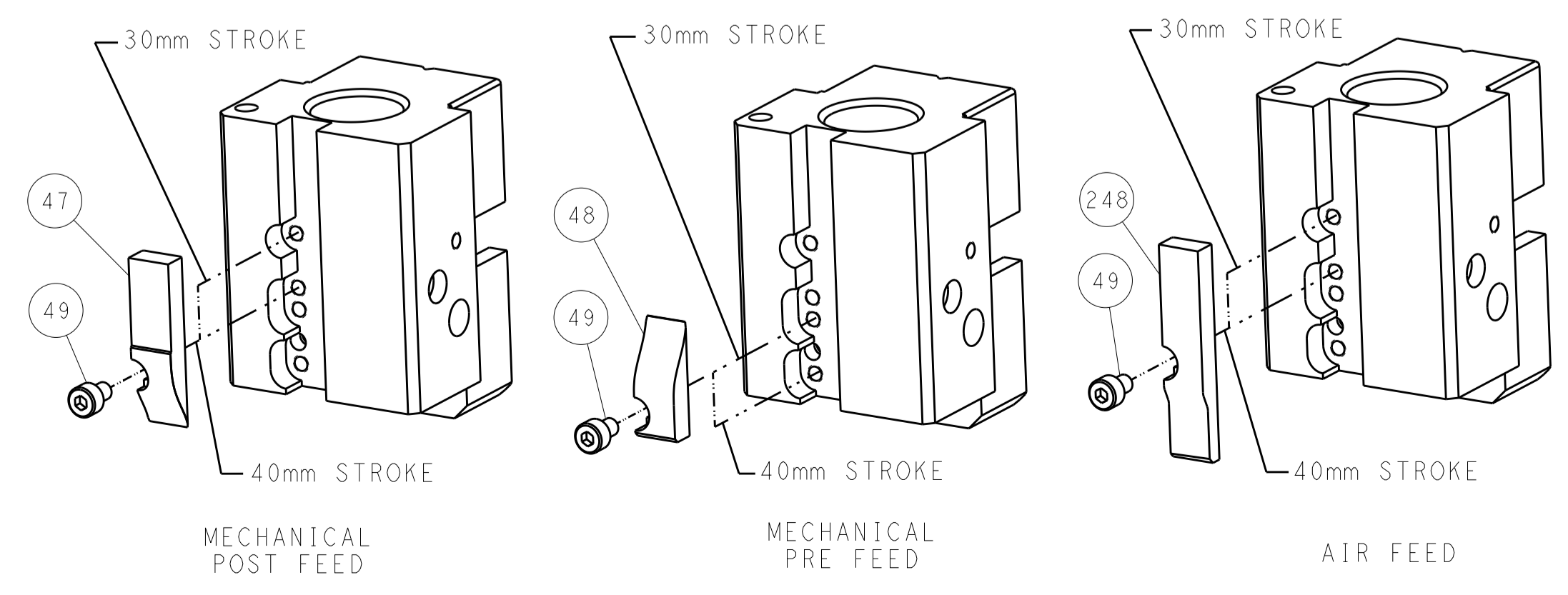
FEED TYPE  
MECHANICAL



PNEUMATIC



CAM POSITIONS

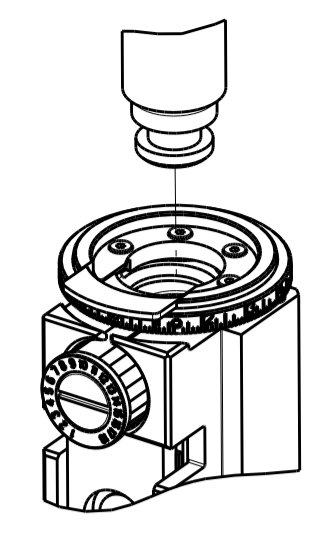


ATLANTIC VERSION  
 Shown on sheets 1 of 4 & 2 of 4  
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG: J. HOU 25JAN2016		TE Connectivity	
mm		0 PLC ±		CHK: L. ZHANG 25JAN2016		Harrisburg, PA 17105-3608	
Ø		1 PLC ±		APPV: H. GUO 25JAN2016		NAME: Ocean End Feed Applicator	
H		2 PLC ±		PRODUCT SPEC		SIZE: CAGE CODE DRAWING NO	
D		3 PLC ±		APPLICATION SPEC		RESTRICTED TO	
R		4 PLC ±		WEIGHT		A1 00779 ©=2150645	
S		5 PLC ±		SCALE: 1:1		SHEET 2 OF 4 REV C	
T		6 PLC ±		Customer Accessible Production Drawing			
F		7 PLC ±					
FINISH		8 PLC ±					

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150645-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2150645-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150645-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR  
 INTERFACE ADAPTER



APPLICATOR DATA

CRIMP	SIZE	TYPE
WIRE	3.56 mm [.140]	F
INSUL	-	-

APPL INSTRUCTIONS  
 408-35043

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION

TERMINAL NAME: RING TERMINAL

WIRE STRIP LENGTH	INSULATION DIAMETER RANGE
5.34-6.10 mm [.210-.240 IN]	∅ -

TERMINAL APPLICATION SPECIFICATION 114-2084

TERMINALS APPLIED

TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
42716-2			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
14 AWG	2.31+/-0.05 [.091+/-0.002]	6.3
16 AWG	2.13+/-0.05 [.084+/-0.002]	8.8
18 AWG	2.03+/-0.05 [.080+/-0.002]	9.9

- 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.
- 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.

**\*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.

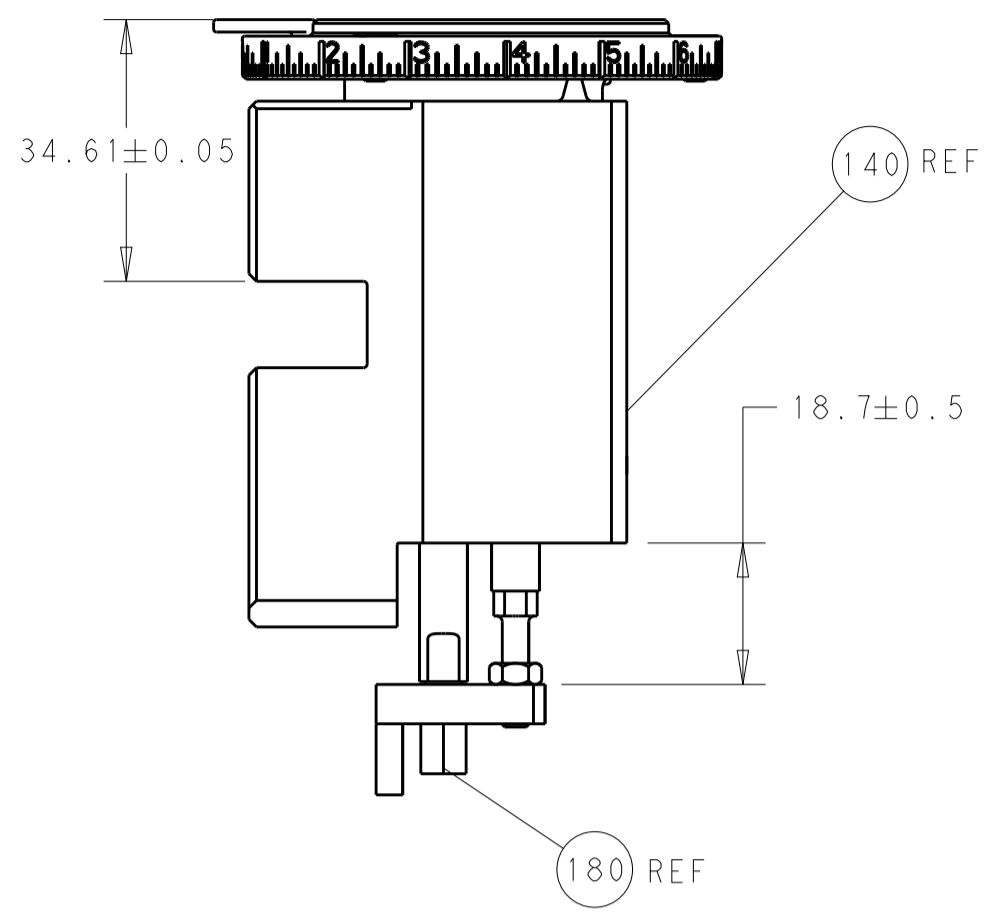
LOC	DIST	REVISIONS
A	66	
		DESCRIPTION DATE DWN APVD
		SEE SHEET 1 - - -

-	1	-	2119640-1	PUSH ROD, AIR FEED	250	
-	1	-	1803259-1	BUSHING, FLANGED	249	
-	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239	
-	1	-	2063440-1	AIR FEED MODULE	238	
-	4	4	2079383-9	SCR, BHSC, RoHS (M6 X 20)	186	
-	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	
-	2	-	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172	
-	REF	REF	994970-2	COUNTER, MAGNETIC	164	
-	1	-	240638-1	SPRING, FEED FINGER	163	
-	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	-	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854	137	
-	1	1	455888-4	SPACER, CRIMPER	82	
-	1	1	1803607-2	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	2-1901681-9	HOLDDOWN, TERMINAL	65	
-	-	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	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	56	
-	2	2	5018030-1	NUT, HEX, REG, RoHS, M3	54	
-	2	2	986965-8	NUT, LOCK, HEX, TORQUE (M4)	53	
-	1	1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52	
-	1	-	2119792-1	PAWL, EF, AIR	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	2168083-9	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	240639-4	STRIPPER (MACHINING)	27	
-	2	2	1-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 30	25	
-	1	1	1752371-5	PLATE, STRIP GUIDE	24	
-	2	2	2-22281-3	SPRING, COMPRESSION	22	
-	1	1	1803292-4	DRAG	20	
-	1	1	1-1901696-9	STRIP GUIDE, REAR	19	
-	1	1	1-1901695-9	STRIP GUIDE, FRONT	18	
-	1	1	1752360-1	SPACER,HOLD-DOWN	13	
-	1	1	240644-9	PLATE, REAR SHEAR	11	
-	2	2	1-240645-6	SPACER, SHEAR PLATE	10	
-	1	1	240642-4	PLATE, FRONT SHEAR	9	
-	1	1	1-1333224-5	ANVIL, COMBINATION (E.F. WIRE/B ONLY)	8	
-	1	1	3-691157-1	BLADE, SHEAR -	7	
-	-	-	-	-	6	
-	1	1	240641-7	SPACER	5	
-	-	-	-	-	3	
-	-	-	-	-	2	
-	1	1	1	456411-3	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)

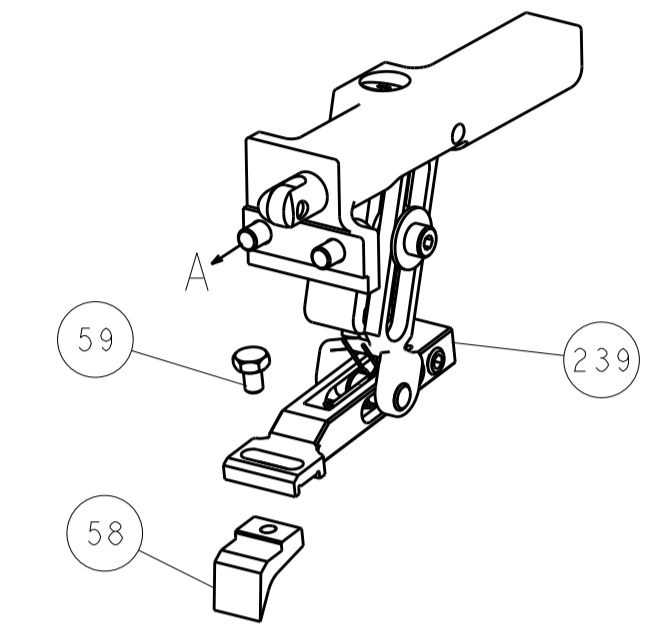
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mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES ±	FINISH ±
WEIGHT		SCALE		SHEET		REV	
Customer Accessible Production Drawing		SCALE 1:1		SHEET 3 OF 4		REV C	

REV. NO.		REVISIONS			
LOC	DIST	DATE	DESCRIPTION	DATE	BY
A	66		SEE SHEET 1		

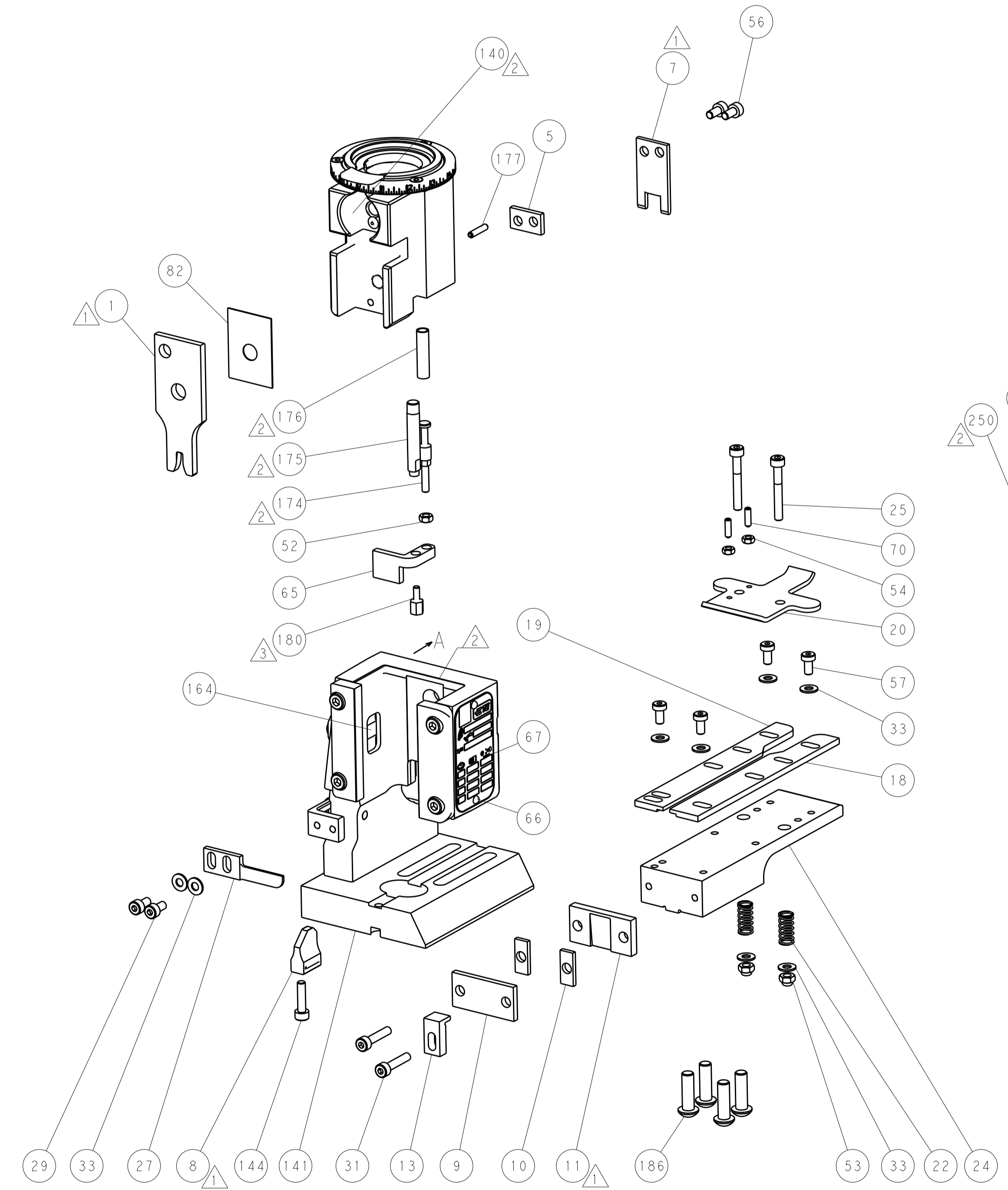
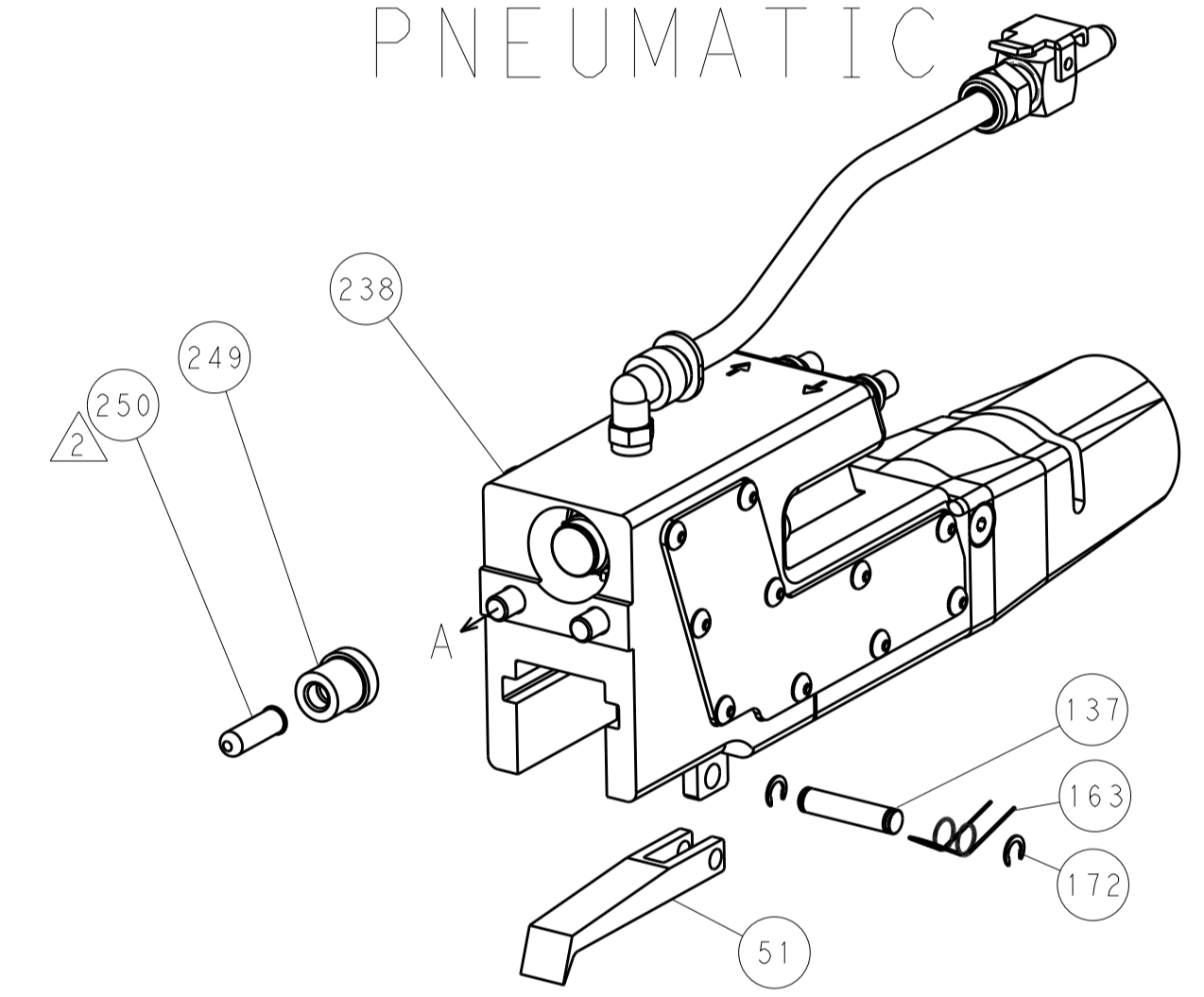


RAM AND HOLDDOWN SET-UP

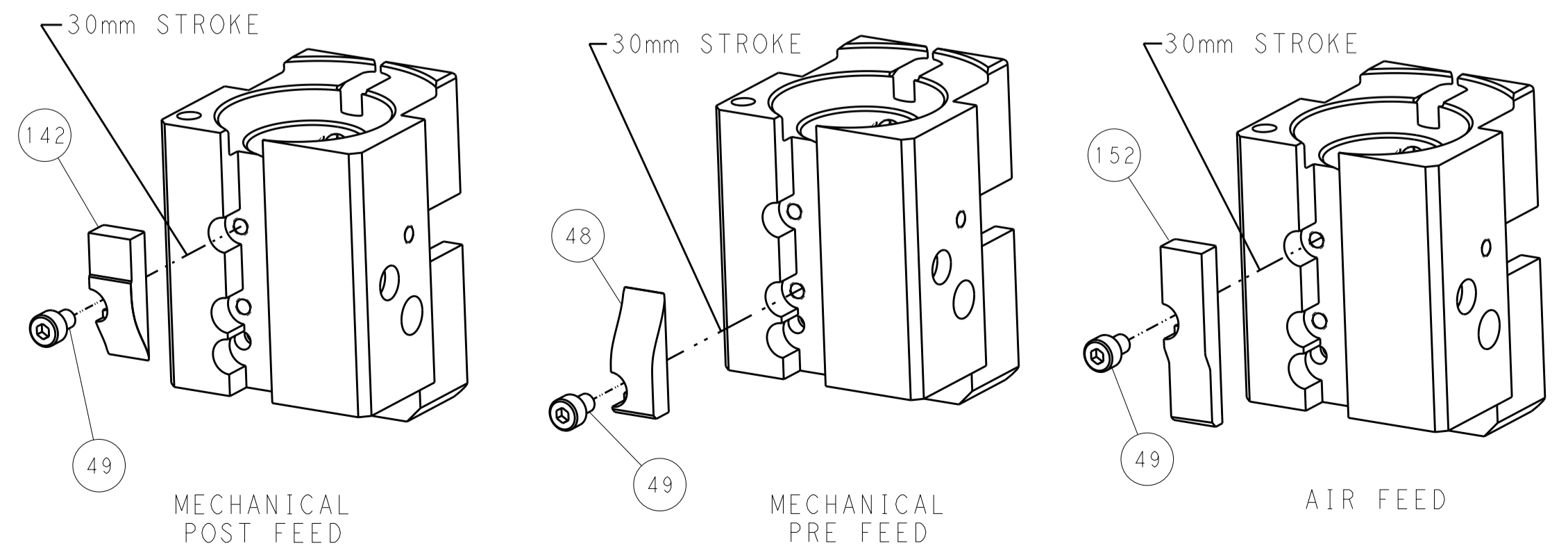
FEED TYPE  
MECHANICAL



PNEUMATIC



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: J. HOU 25JAN2016		CHK: L. ZHANG 25JAN2016		APVD: H. GUO 25JAN2016		NAME: Ocean End Feed Applicator	
mm	0 PLC	±		PRODUCT SPEC		SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO		
	1 PLC	±		APPLICATION SPEC		A1	00779	©=2150645			
	2 PLC	±		WEIGHT		Customer Accessible Production Drawing		SCALE	1:1	SHEET	4 OF 4
	3 PLC	±		ANGLES						REV	C
	4 PLC	±									
	FINISH										