

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150648-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2150648-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150648-1	B	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2150648-2	B	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150648-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.79 mm [.110]	F
INSUL	-	-

APPL INSTRUCTIONS  
408-35043

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: SHUR PLUG, .156 DIA			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
3.56-4.32 mm [.140-.170 IN]		∅	
TERMINAL APPLICATION SPECIFICATION	114-2042	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
61802-1	1742083-1		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
14 AWG	2.01 +/- 0.05 [.079 +/- .002]	4.8
16 AWG	1.75 +/- 0.05 [.069 +/- .002]	7.6
18 AWG	1.62 +/- 0.05 [.064 +/- .002]	8.9

- 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.
- LUBRICANT IS RECOMMENDED.
- POSITION ITEM 51 OR 58 AT END OF TERMINAL RECEPTACLE FOR PROPER 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.

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

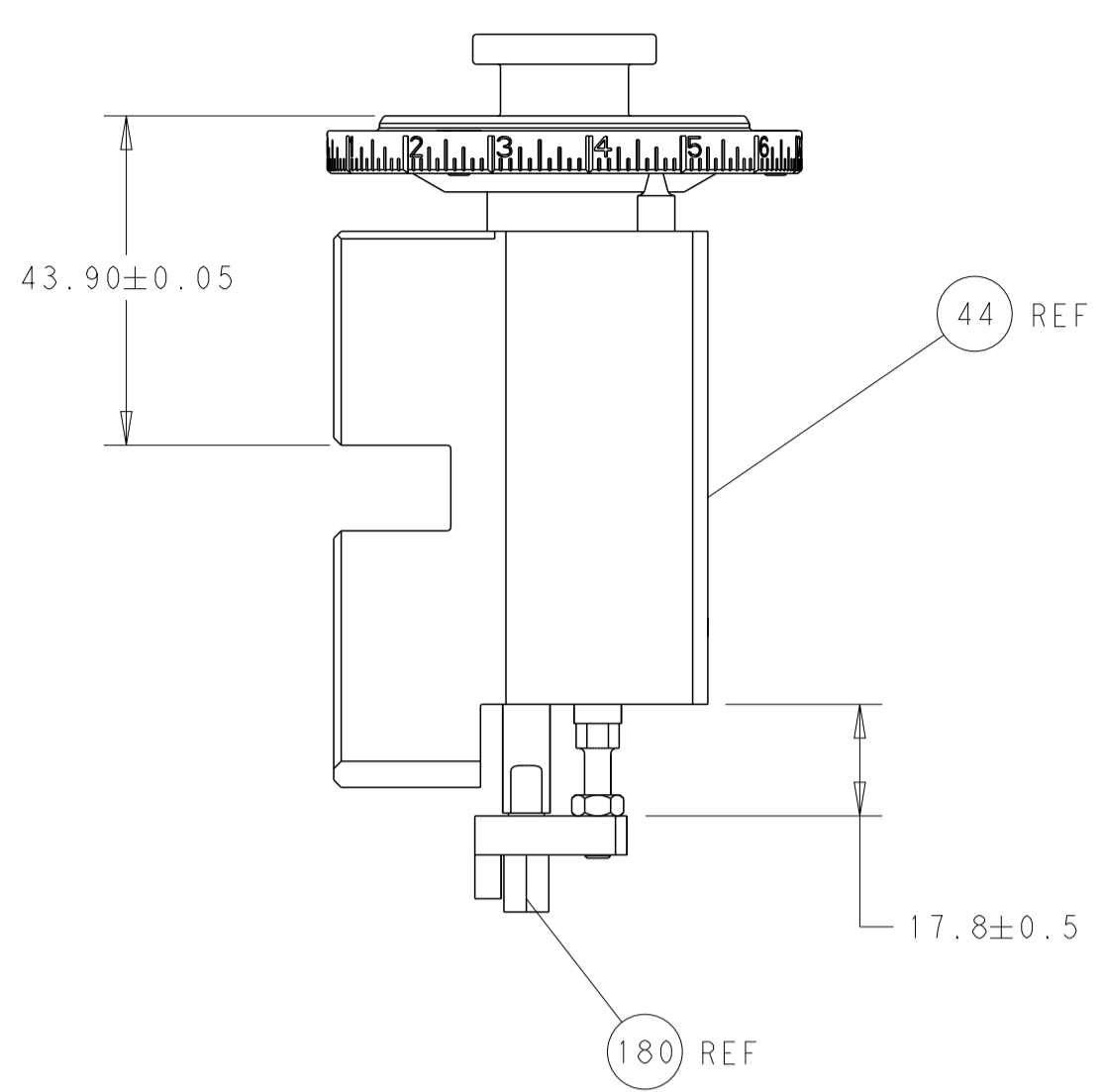
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		A1		ECR-16-016483	23NOV2016	TB	TE
		B		ECR-18-014485	12SEP2018	FL	TE
		B1		ECR-20-002646	24FEB2020	JWC	GB
		B2		ECR-21-109619	19AUG2021	LG	TE

-	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		
	-	1	1	1	1-1752354-5	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	2119955-2	ASSY, LUBRICATOR, END FEED	84		
-	1	1	1	1	455888-6	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	1901681-5	HOLDDOWN, TERMINAL	65		
-	2	2	2	2	2168400-5	SHCS, LOW HEAD, RoHS, M4 X 20	64		
-	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		
-	3	3	3	3	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57		
-	2	2	2	2	2-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 14	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	2119792-2	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	1803602-3	SCR, BHSC, RoHS (M8 X 12)	41		
-	7	7	7	7	1-18028-2	WASHER, FLAT, REG M4	33		
-	1	1	1	1	1-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 30	32		
-	1	1	1	1	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	240639-1	STRIPPER (MACHINING)	27		
-	2	2	2	2	1-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 30	25		
-	1	1	1	1	1-1752371-2	PLATE, STRIP GUIDE	24		
-	1	1	1	1	240825-6	PLATE, STRIP HOLD DOWN	23		
-	2	2	2	2	2-22281-3	SPRING, COMPRESSION	22		
-	1	1	1	1	1803292-4	DRAG	20		
-	2	2	2	2	1901259-5	GUIDE, LOWER STRIP	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	240833-3	PLATE, REAR SHEAR	11		
-	2	2	2	2	5-240645-2	SPACER, SHEAR PLATE	10		
	-	1	1	1	690796-1	PLATE-FRONT SHEAR MINI APPLICATOR	9		
	1	2	2	1	1-1333224-6	ANVIL, COMBINATION (E.F. WIRE/B ONLY)	8		
	-	1	1	1	1803109-4	BLADE, SLUG	7		
-	-	-	-	-	-	-	6		
-	1	1	1	1	3-240641-5	SPACER	5		
-	-	-	-	-	-	-	4		
-	-	-	-	-	-	-	3		
-	-	-	-	-	-	-	2		
	1	2	2	1	1	2-456408-0	CRIMPER, WIRE PREMIUM	1	
-	77	72	71	2	-	1	PART NO	DESCRIPTION	ITEM NO

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		MATERIAL:		FINISH:		WEIGHT:		SCALE:	
mm	0 PLC	±									
	1 PLC	±									
	2 PLC	±									
	3 PLC	±									
	4 PLC	±									
	ANGLES	±									

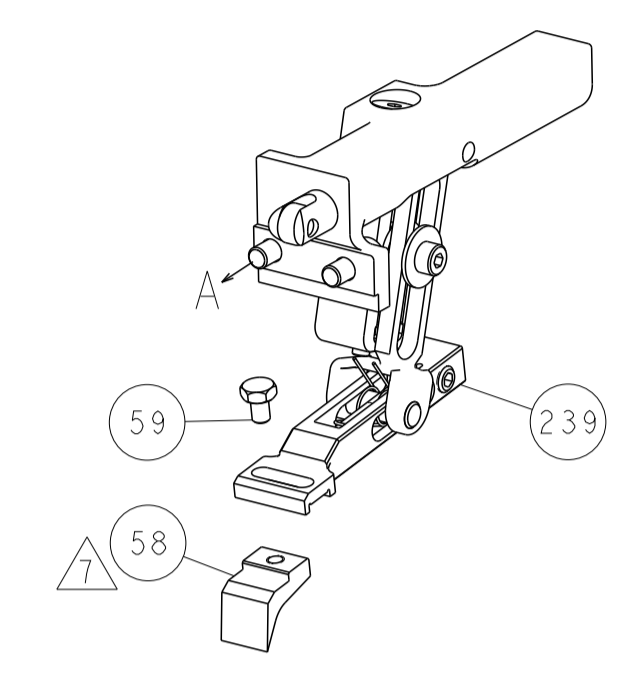
Customer Accessible Production Drawing

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

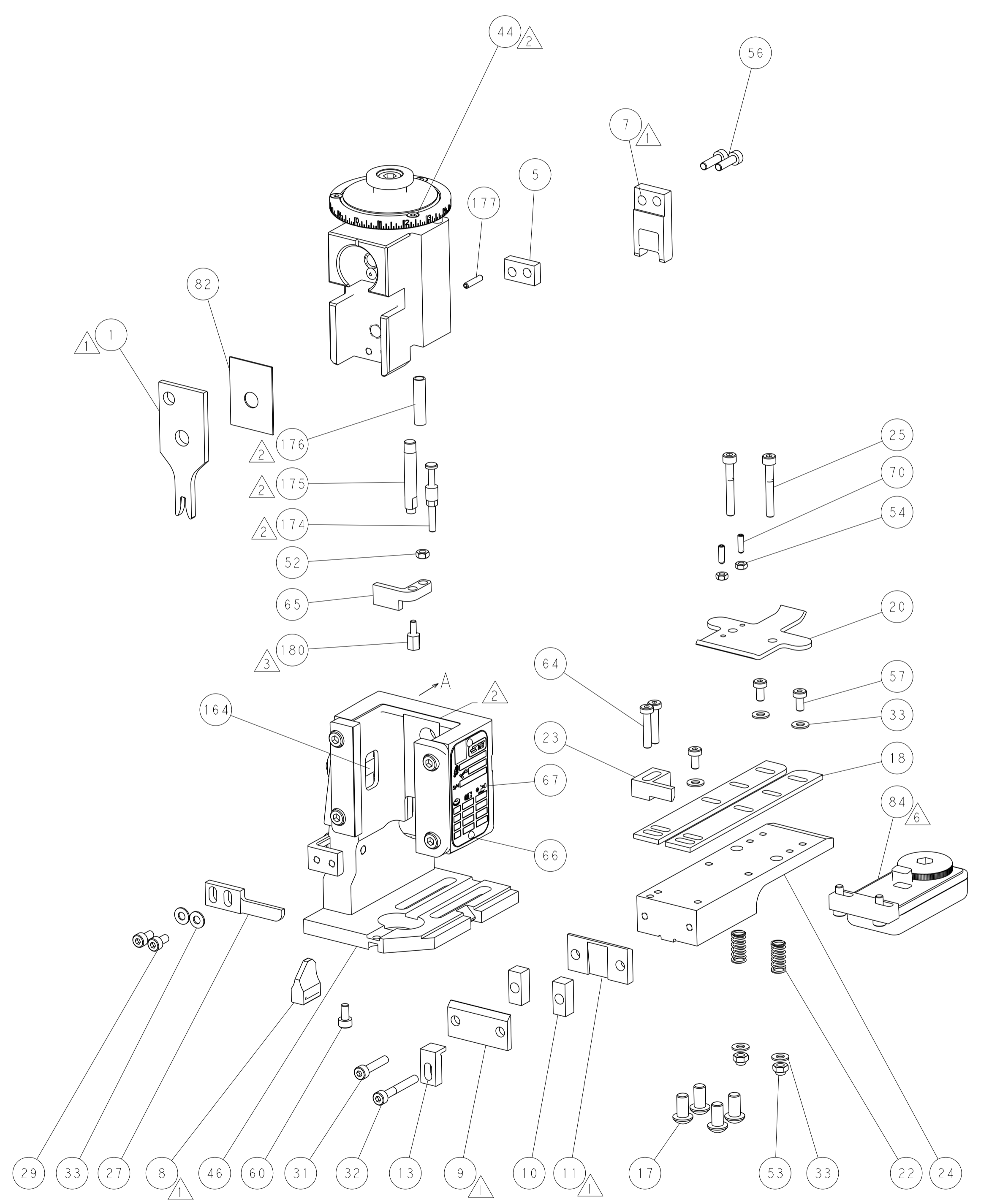
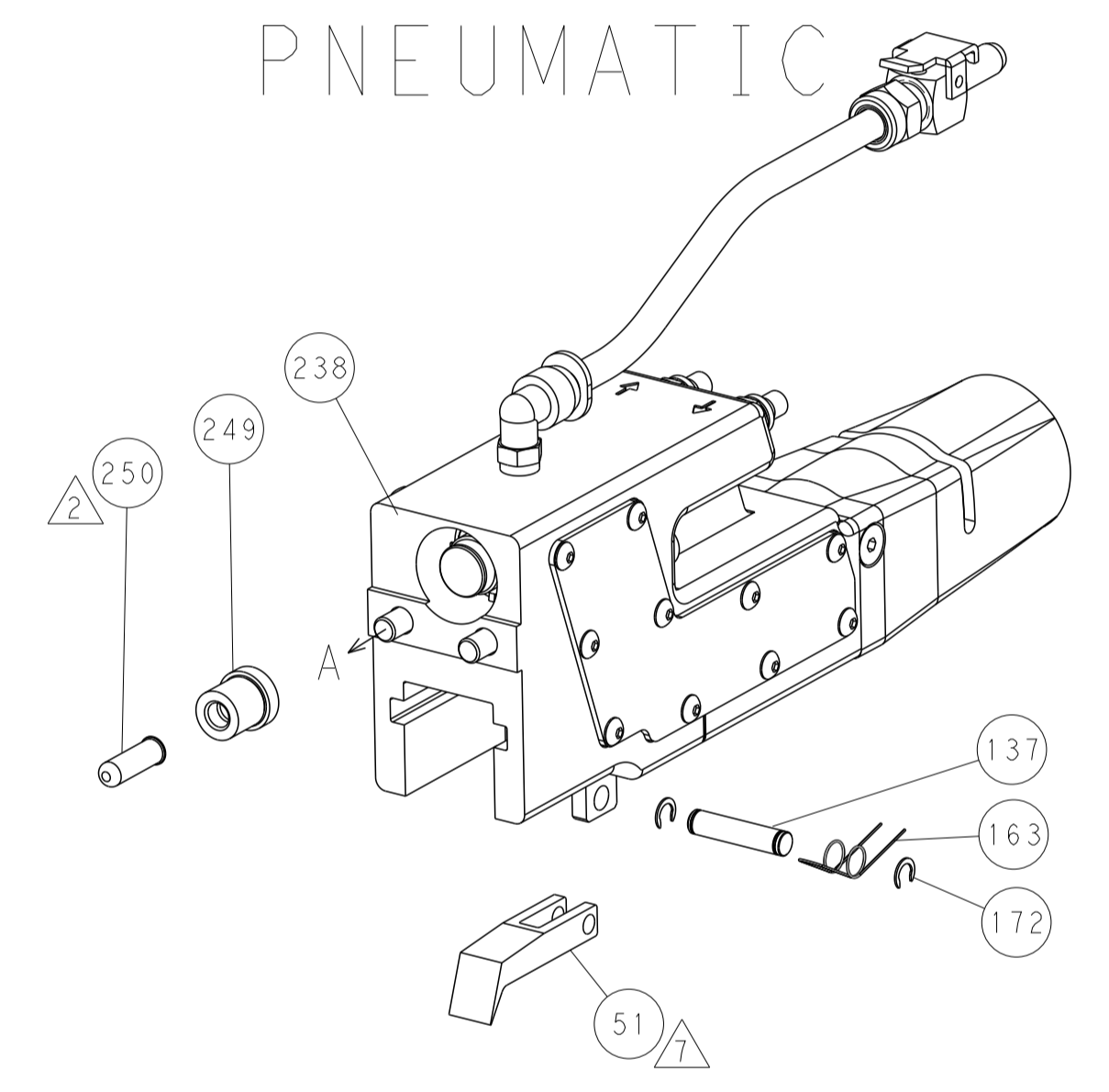


RAM AND HOLDDOWN SET-UP

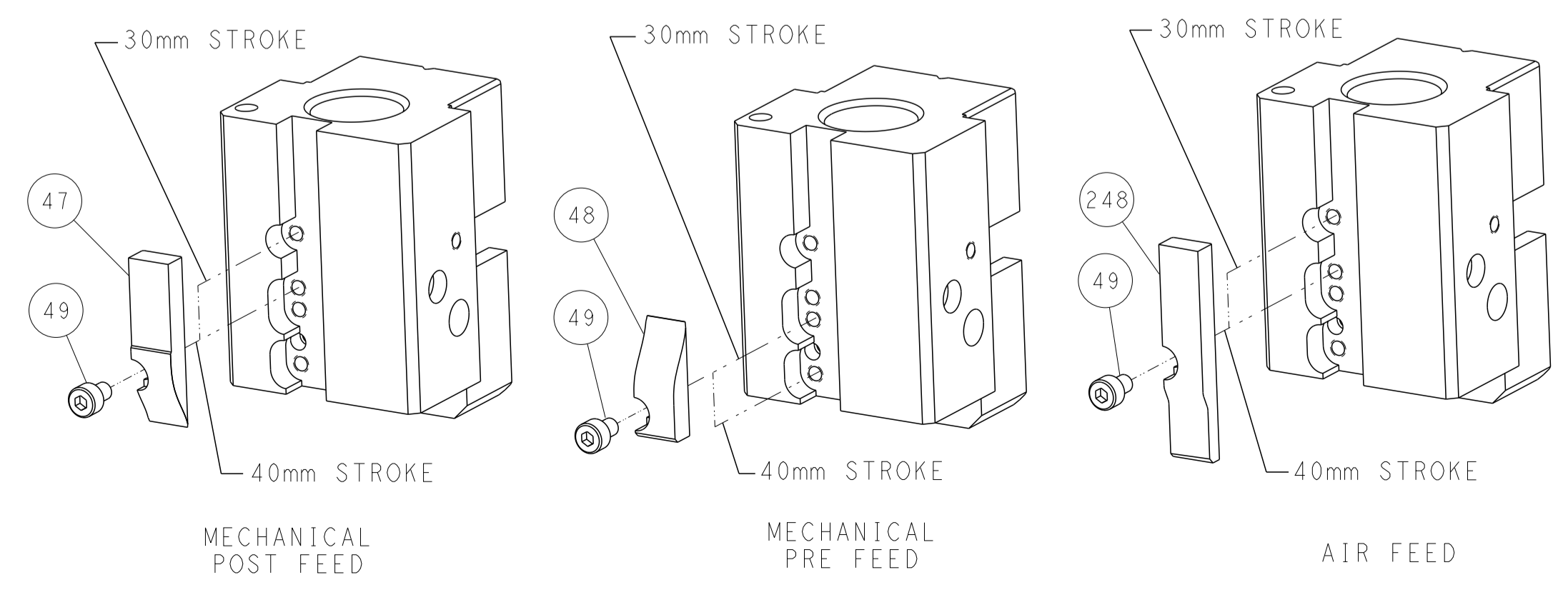
FEED TYPE  
MECHANICAL



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: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH		DWN X.ZHAO 16FEB2016 CHK L.ZHANG 16FEB2016 APVD JJ.GUO 16FEB2016		NAME Ocean End Feed Applicator	
MATERIAL:		WEIGHT:		SIZE: A1 CAGE CODE: 00779 DRAWING NO: ©=2150648		RESTRICTED TO:	
Customer Accessible Production Drawing				SCALE: 1:1		SHEET 2 OF 4 REV B2	

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150648-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2150648-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150648-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR  
INTERFACE ADAPTER



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

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: SHUR PLUG, .156 DIA			
WIRE STRIP LENGTH 3.56-4.32 mm (.140-.170 IN)		INSULATION DIAMETER RANGE Ø	
TERMINAL APPLICATION SPECIFICATION	114-2042	-	-
TERMINALS APPLIED			
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- 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.
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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	REVISIONS					
A	66	P	LTN	DESCRIPTION	DATE	OWN	APVD
-	-	-	-	SEE SHEET 1	-	-	-

-	1	1	2119640-1	PUSH ROD, AIR FEED	250	
-	1	1	1803259-1	BUSHING, FLANGED	249	
-	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239	
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-	4	4	2079383-9	SCR, BHSC, RoHS (M6 X 20)	186	
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-	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	2	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172	
-	REFREF		994970-2	COUNTER, MAGNETIC	164	
-	1	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	1	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854	137	
	1	1	2119955-2	ASSY, LUBRICATOR, END FEED	84	
-	1	1	455888-6	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	1901681-5	HOLDDOWN, TERMINAL	65	
-	2	2	2168400-5	SHCS, LOW HEAD, RoHS, M4 X 20	64	
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-	2	2	2-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 14	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	-	2119792-2	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	1803602-3	SCR, BHSC, RoHS (M8 X 12)	41	
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	2	2	5-240645-2	SPACER, SHEAR PLATE	10	
	1	1	690796-1	PLATE-FRONT SHEAR MINI APPLICATOR	9	
	1	1	1-1333224-6	ANVIL, COMBINATION (E.F. WIRE/B ONLY)	8	
	1	1	1803109-4	BLADE, SLUG	7	
-	-	-	-	-	6	
-	1	1	3-240641-5	SPACER	5	
-	-	-	-	-	4	
-	-	-	-	-	3	
-	-	-	-	-	2	
	1	1	1	2-456408-0	CRIMPER, WIRE PREMIUM	1
-	77	22	21	PART NO	DESCRIPTION	ITEM NO

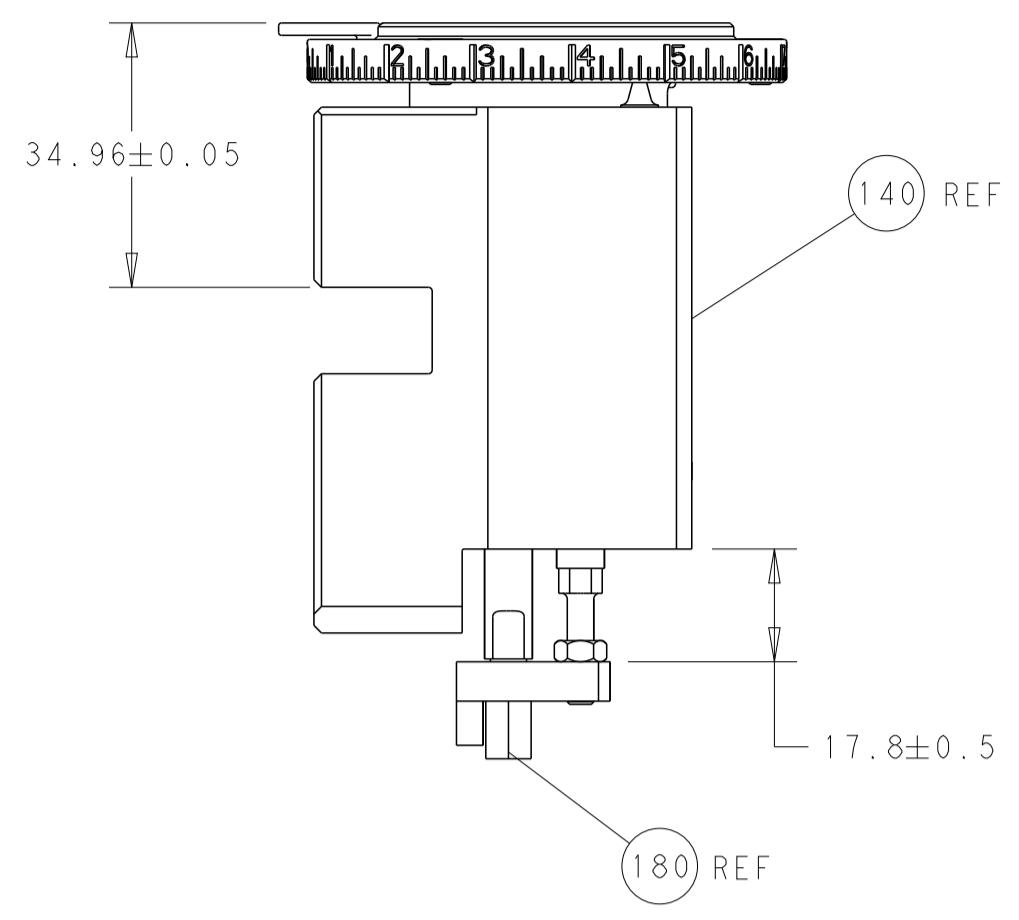
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DRAWING NO		NAME	
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	ANGLES	FINISH		WT	SCALE	SHEET	REV
MATERIAL				00779	1:1	3 OF 4	B2

**STE** TE Connectivity  
Harrisburg, PA 17105-3608

**Ocean End Feed Applicator**

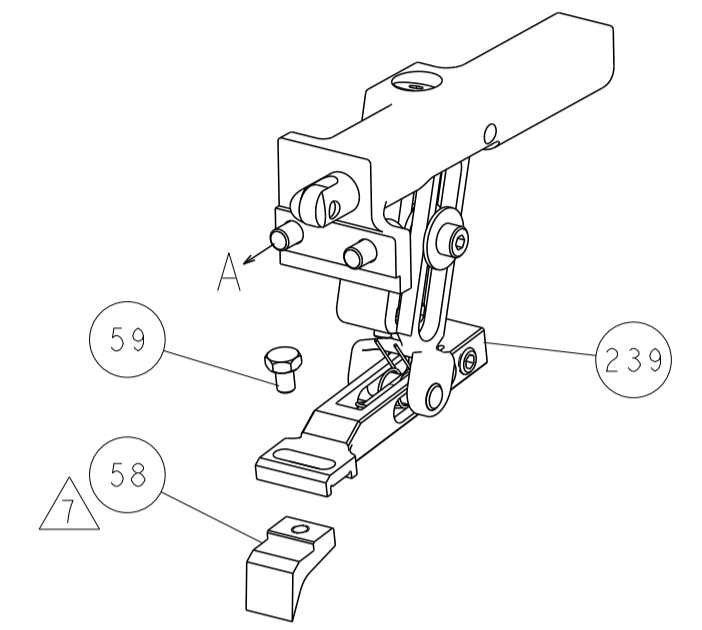
Customer Accessible Production Drawing

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

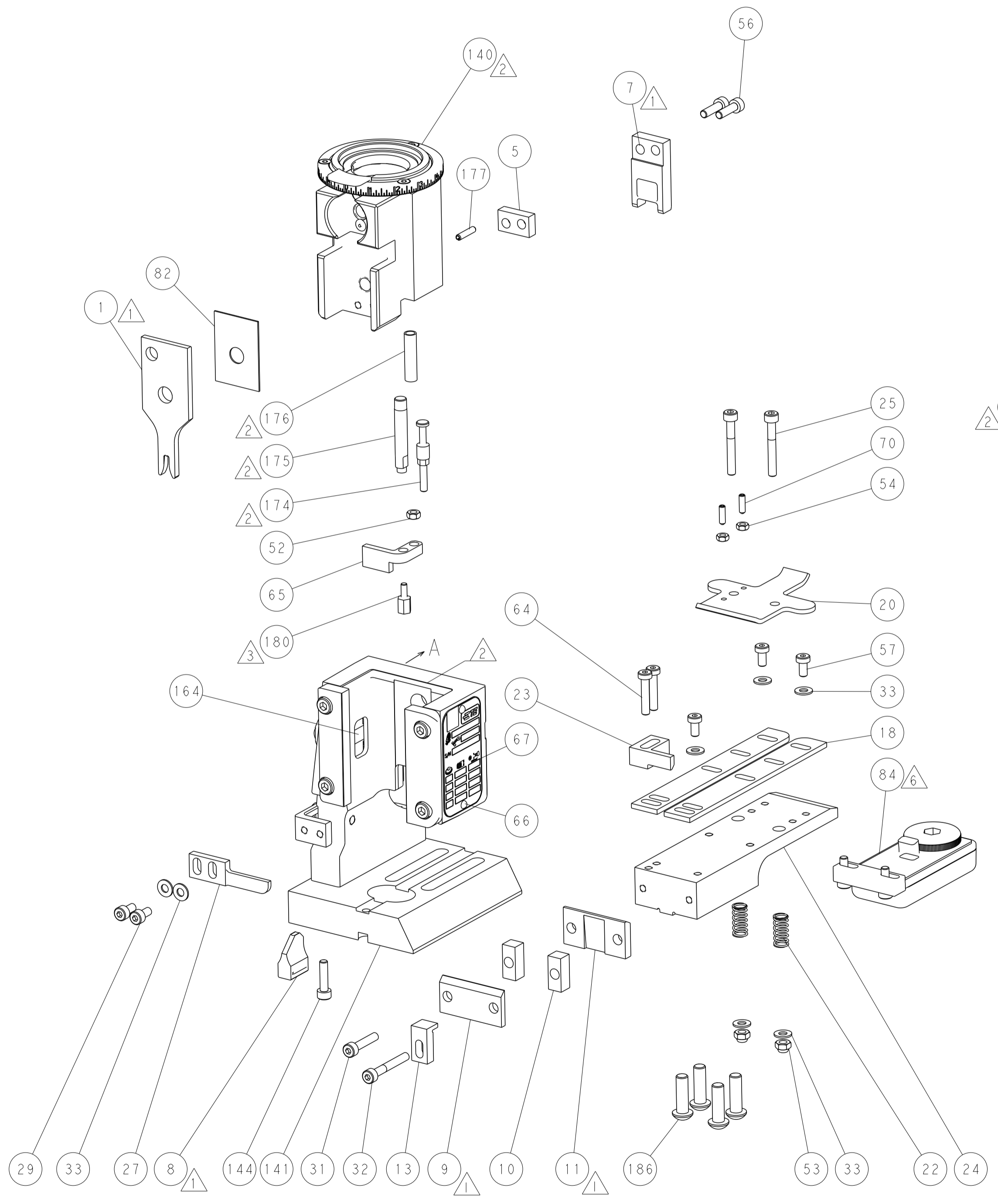
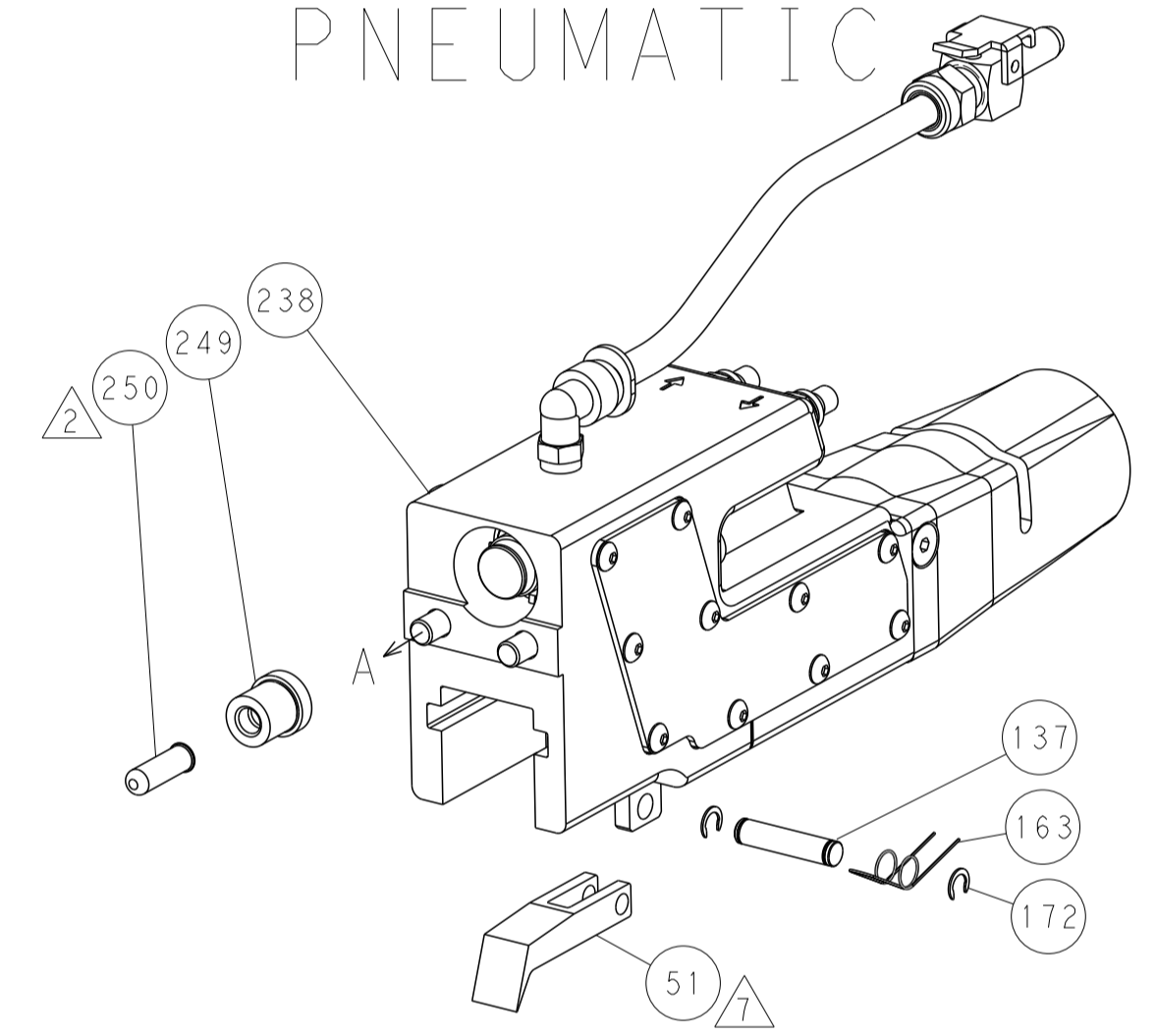


RAM AND HOLDDOWN SET-UP

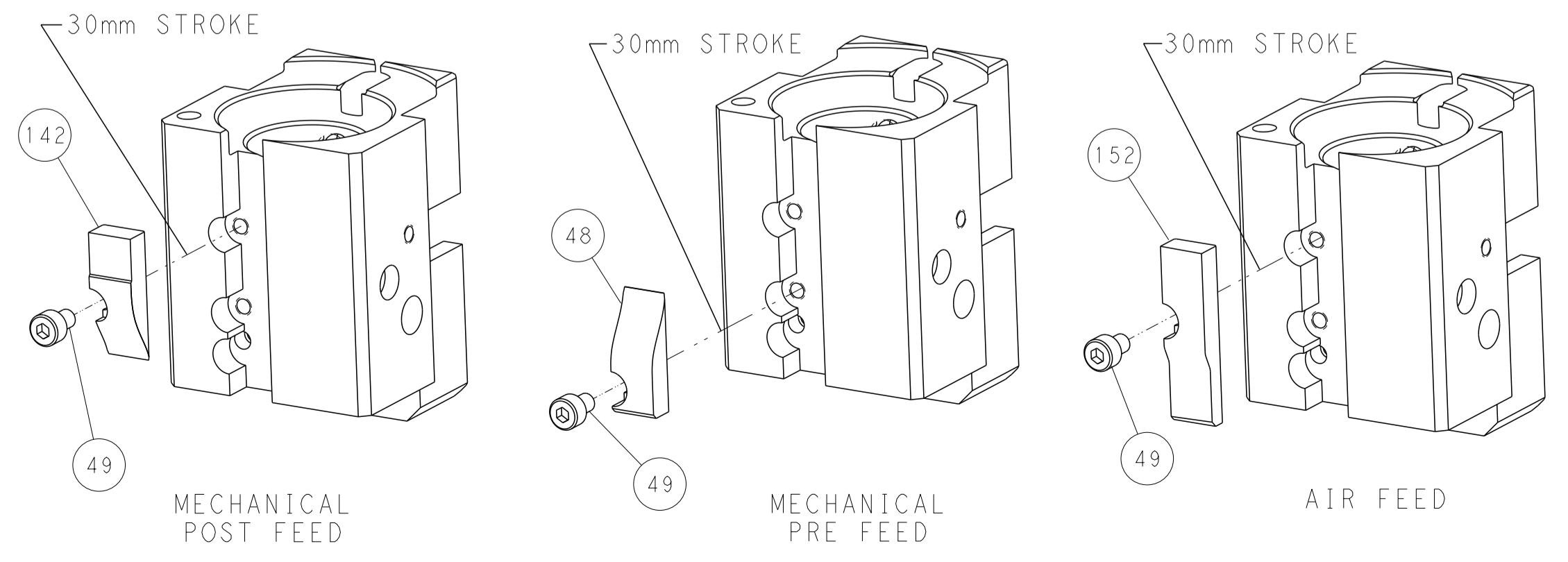
FEED TYPE  
MECHANICAL



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)

<small>THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.</small>		DWN X.ZHAO 16FEB2016 CHK L.ZHANG 16FEB2016 APVD JJ.GUO 16FEB2016	NAME Ocean End Feed Applicator
DIMENSIONS: mm 	TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH	PRODUCT SPEC APPLICATION SPEC WEIGHT SCALE 1:1	SIZE CAGE CODE DRAWING NO A1 00779 C=2150648 SHEET 4 OF 4 REV B2