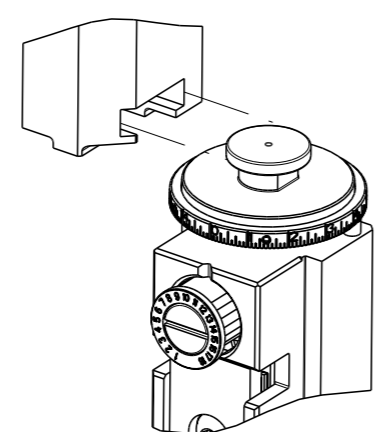


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150651-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150651-2	B	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150651-7	A	CRIMP TOOLING KIT	-

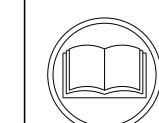
ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	5.58 mm [.220]	F
INSUL	7.87 mm [.310]	F
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: TERMINAL, RING TONGUE M6			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
7.65-8.41 mm [.301-.331 IN]		Ø4.60-6.93 mm [1.81-.273 IN]	
TERMINAL APPLICATION SPECIFICATION	114-37011	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
444305-1			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
10.00mm ²	4.80 +/- 0.05 [1.89 +/- .002]	3.5
6.00mm ²	4.24 +/- 0.05 [1.67 +/- .002]	9.2



- 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.
- 5. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- 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.

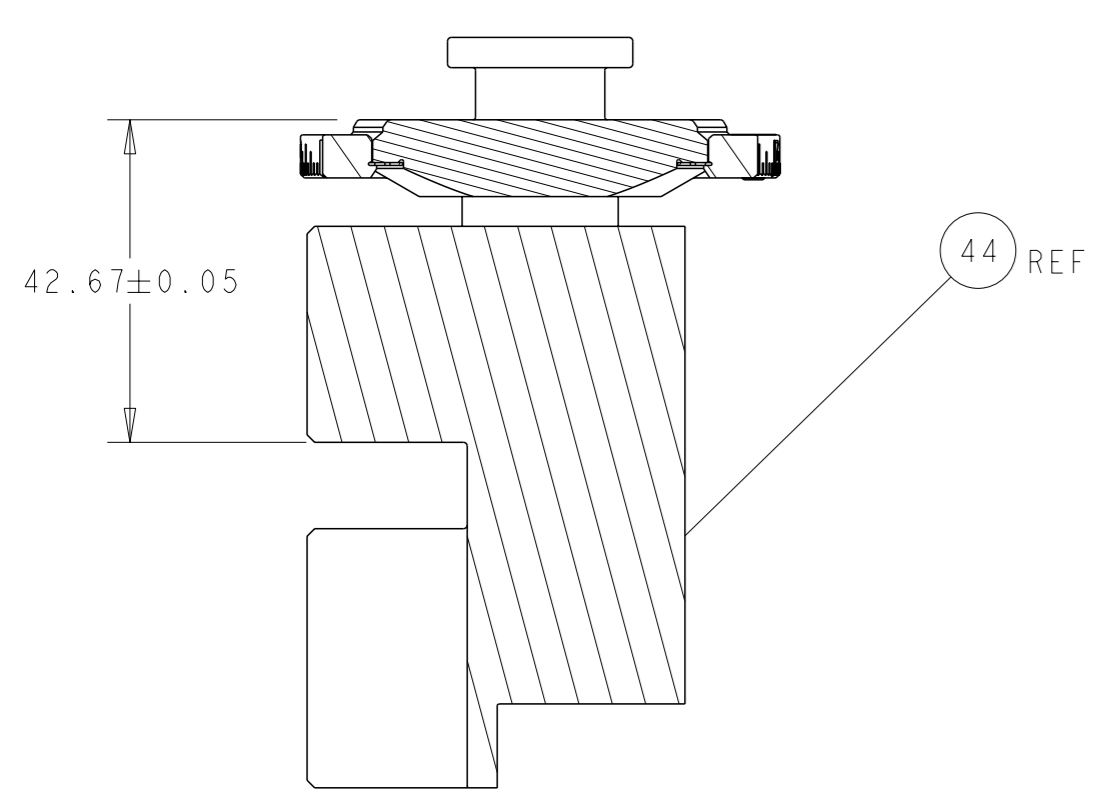
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

LOC	DIST	REVISIONS					
		#	LY#	DESCRIPTION	DATE	OWN	APVD
A	66	-	-	-	26APR2010	-	-
		A		RELEASED	14APR2016	BH	BH
		B		ECR-20-004106	18MAR2020	FZ	TE

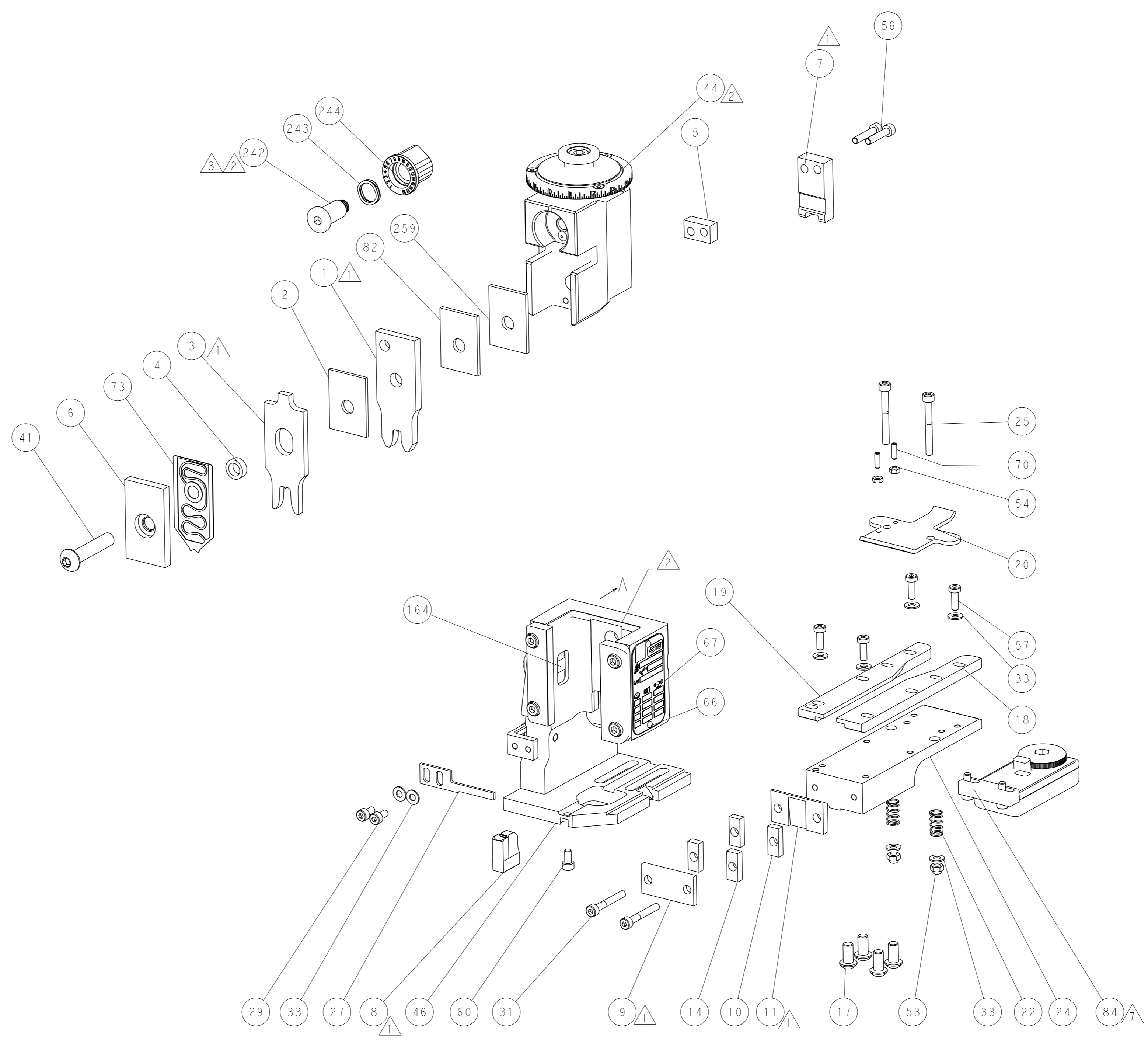
-	1	1	1803078-2	SPACER, PRECISION	259		
-	1	1	2119641-1	FEED CAM, AIR FEED	248		
-	1	1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244		
-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243		
	1	1	2119083-1	RETAINER, INSULATION DIAL	242		
-	1	1	2844940-4	AIR FEED MODULE	238		
-	REF	REF	994970-2	COUNTER, MAGNETIC	164		
	1	1	2119955-2	ASSY, LUBRICATOR, END FEED	84		
-	1	1	2-455888-2	SPACER, CRIMPER	82		
-	1	1	1-2119791-0	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	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		
-	4	4	2168400-1	SHCS, LOW HEAD, RoHS, M4 X 12	57		
-	2	2	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	56		
-	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	1-2119655-1	APPLICATOR BASIC ASSEMBLY, EF	46		
-	1	1	1803517-2	RAM ASSEMBLY, EF ATLANTIC	44		
-	1	1	1803602-2	SCR, BHSC, RoHS (M8 X 40)	41		
-	8	8	1-18028-2	WASHER, FLAT, REG M4	33		
-	2	2	1-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 30	31		
-	2	2	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	29		
-	1	1	690455-2	STRIPPER, FRONT CASTING	27		
-	2	2	1-2168083-6	SCR, SKT HD CAP, RoHS, M4 X 35	25		
-	1	1	2-1752371-9	PLATE, STRIP GUIDE	24		
-	2	2	22281-8	SPRING, COMPRESSION	22		
-	1	1	1803292-6	DRAG	20		
-	1	1	8-1901696-4	STRIP GUIDE, REAR	19		
-	1	1	8-1901695-5	STRIP GUIDE, FRONT	18		
-	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17		
-	2	2	2-240645-0	SPACER, SHEAR PLATE	14		
	1	1	240833-4	PLATE, REAR SHEAR	11		
	2	2	2-240645-3	SPACER, SHEAR PLATE	10		
	1	1	1803322-1	PLATE, FRONT SHEAR	9		
	1	2	1	2-1803074-1	ANVIL, COMBINATION, END FEED	8	
	1	1	9-240651-8	BLADE, SLUG	7		
-	1	1	1803203-1	BLOCK, FRONT DEPRESSOR	6		
-	1	1	7-240641-5	SPACER	5		
-	1	1	2-238011-7	BLOCK, CRIMPER SPACER	4		
	1	2	1	4-1803187-7	CRIMPER, INSULATION F	3	
-	1	1	1-455888-8	SPACER, CRIMPER	2		
	1	2	1	456413-8	CRIMPER, WIRE PREMIUM	1	
-	77	72	2	PART NO			
-				DESCRIPTION			ITEM NO

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		OWN: BOB HIGMAN 17FEB2016		TE Connectivity	
mm		0 PLC ±		CHK: T. ELBIN 17FEB2016		Harrisburg, PA 17105-3608	
		1 PLC ±		APVD: T. ELBIN 17FEB2016		NAME: Ocean End Feed Applicator	
		2 PLC ±		PRODUCT SPEC		SIZE: A1	
		3 PLC ±		APPLICATION SPEC		CAGE CODE: 00779	
		4 PLC ±		WEIGHT: -		DRAWING NO: C=2150651	
MATERIAL: -		FINISH: -		RESTRICTED TO: -		SCALE: 1:1	
Customer Accessible Production Drawing				SHEET 1 OF 4		REV B	

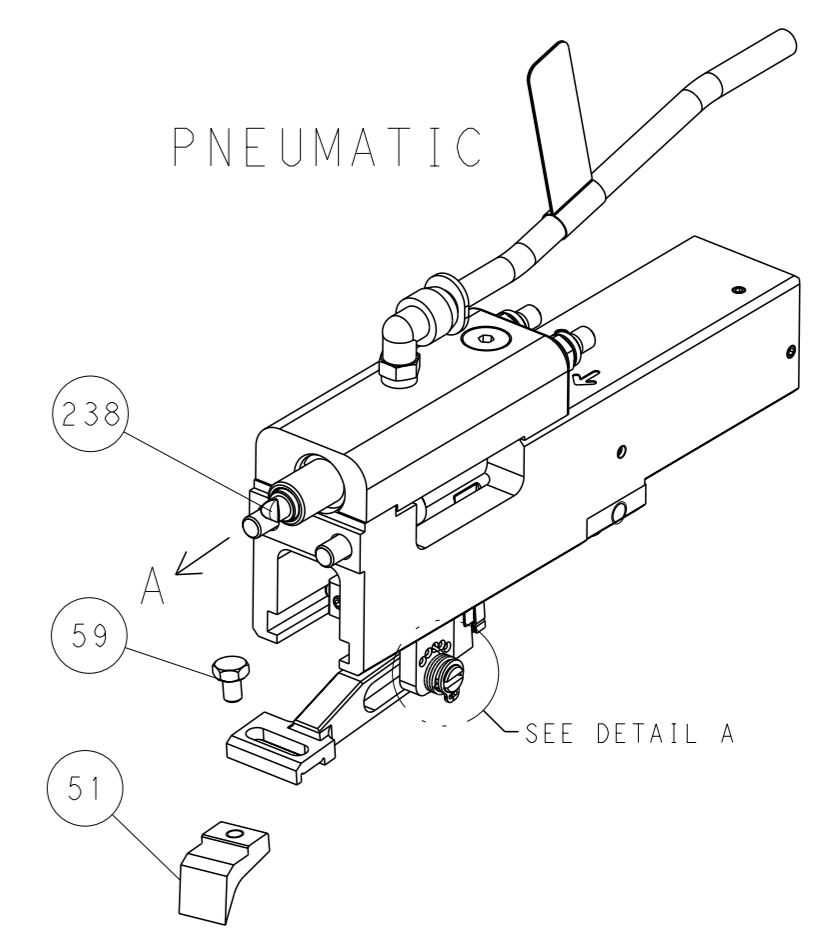
LOC	DIST	REVISIONS					
A	66	P	LYR	DESCRIPTION	DATE	OWN	APVD
		-		SEE SHEET 1	-	-	-



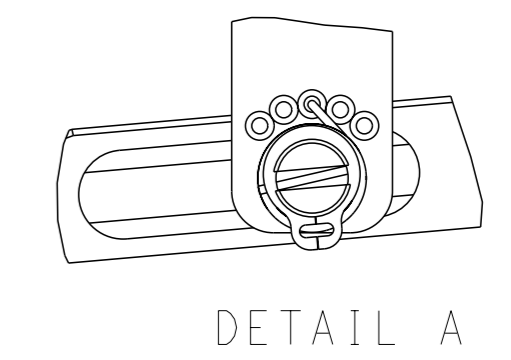
RAM SET-UP



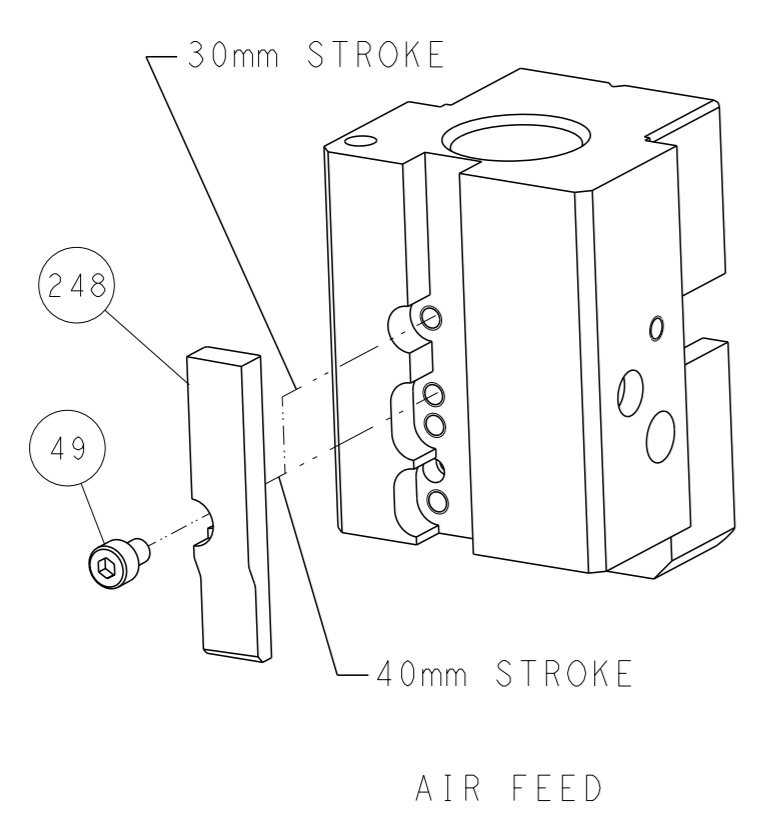
FEED TYPE



FEED SPRING SETTING POSITION



CAM POSITION

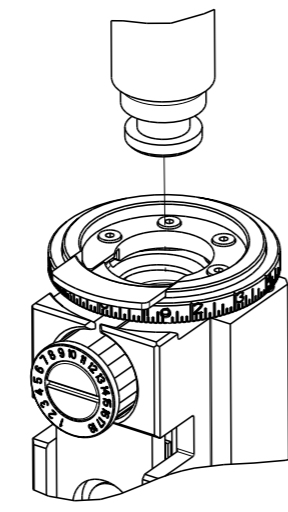


ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

<small>THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE AND TO CONTROLING ENGINEERING DISCRETION. SHOULD BE CONTACTED FOR THE LATEST REVISION.</small>		DWN BOB HIGMAN 17FEB2016 CHK T. ELBIN 17FEB2016 APVD T. ELBIN 17FEB2016	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. RESTRICTED TO A1 00779 C=2150651	WEIGHT SCALE 1:1 SHEET 2 OF 4 REV B
MATERIAL:		Customer Accessible Production Drawing	

8	7	6	5	4	3	2	1
THIS DRAWING IS UNPUBLISHED.		RELEASED FOR PUBLICATION		20			
COPYRIGHT 20 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.							
PART NUMBER	REVISION	DESCRIPTION	FEED TYPE				
2-2150651-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC				
7-2150651-7	A	CRIMP TOOLING KIT	-				

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	5.58 mm [.220]	F
INSUL	7.87 mm [.310]	F
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: TERMINAL, RING TONGUE M6			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
7.65-8.41 mm [.301-.331 IN]		Ø4.60-6.93 mm [1.181-.273 IN]	
TERMINAL APPLICATION SPECIFICATION	114-37011	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
444305-1			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
10.00mm2	4.80+/-0.05 [1.189+/- .002]	3.5
6.00mm2	4.24+/-0.05 [1.167+/- .002]	9.2

- 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.
- 5. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- 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.

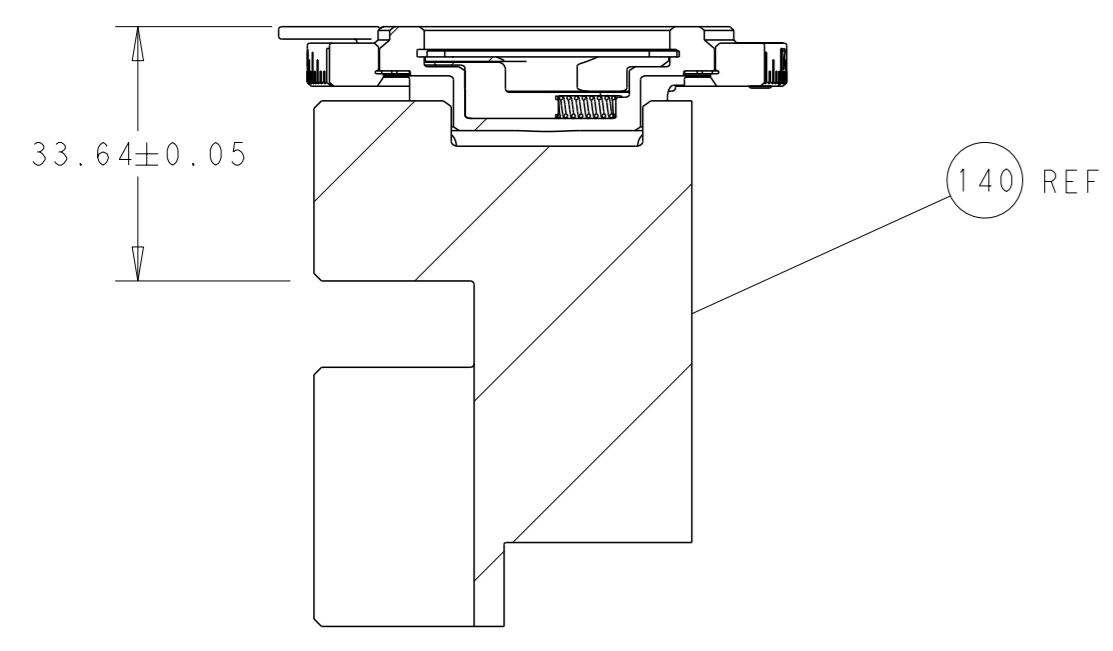
PACIFIC VERSION
Shown on sheets 3 of 4 & 4 of 4
(Atlantic version shown on sheets 1 of 4 & 2 of 4)

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

-	1	1803078-2	SPACER, PRECISION	259
-	1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	2844940-4	AIR FEED MODULE	238
-	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	1-2119655-2	APPLICATOR BASIC ASSEMBLY, EF	141
-	1	1803518-2	RAM ASSEMBLY, EF PACIFIC	140
-	1	2119955-2	ASSY, LUBRICATOR, END FEED	84
-	1	2-455888-2	SPACER, CRIMPER	82
-	1	1-2119791-0	DEPRESSOR, WIRE	73
-	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
-	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	4	2168400-1	SHCS, LOW HEAD, RoHS, M4 X 12	57
-	2	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	56
-	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	1803602-2	SCR, BHSC, RoHS (M8 X 40)	41
-	8	1-18028-2	WASHER, FLAT, REG M4	33
-	2	1-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 30	31
-	2	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	29
-	1	690455-2	STRIPPER, FRONT CASTING	27
-	2	1-2168083-6	SCR, SKT HD CAP, RoHS, M4 X 35	25
-	1	2-1752371-9	PLATE, STRIP GUIDE	24
-	2	22281-8	SPRING, COMPRESSION	22
-	1	1803292-6	DRAG	20
-	1	8-1901696-4	STRIP GUIDE, REAR	19
-	1	8-1901695-5	STRIP GUIDE, FRONT	18
-	2	2-240645-0	SPACER, SHEAR PLATE	14
-	1	240833-4	PLATE, REAR SHEAR	11
-	2	2-240645-3	SPACER, SHEAR PLATE	10
-	1	1803322-1	PLATE, FRONT SHEAR	9
1	1	2-1803074-1	ANVIL, COMBINATION, END FEED	8
-	1	9-240651-8	BLADE, SLUG	7
-	1	1803203-1	BLOCK, FRONT DEPRESSOR	6
-	1	7-240641-5	SPACER	5
-	1	2-238011-7	BLOCK, CRIMPER SPACER	4
1	1	4-1803187-7	CRIMPER, INSULATION F	3
-	1	1-455888-8	SPACER, CRIMPER	2
1	1	456413-8	CRIMPER, WIRE PREMIUM	1
-	77-22	PART NO	DESCRIPTION	ITEM NO

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		OWN	BOB HIGMAN	17FEB2016	TE Connectivity Harrisburg, PA 17105-3608
mm	0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ±	±	±	CHK	T. ELBIN	17FEB2016	
MATERIAL:		FINISH:		APVD	T. ELBIN	17FEB2016	NAME
				APPLICATION SPEC		Ocean End Feed Applicator	
				WEIGHT	A1 00779 ©=2150651		RESTRICTED TO
				Customer Accessible Production Drawing		SCALE 1:1	SHEET 3 of 4 REV B

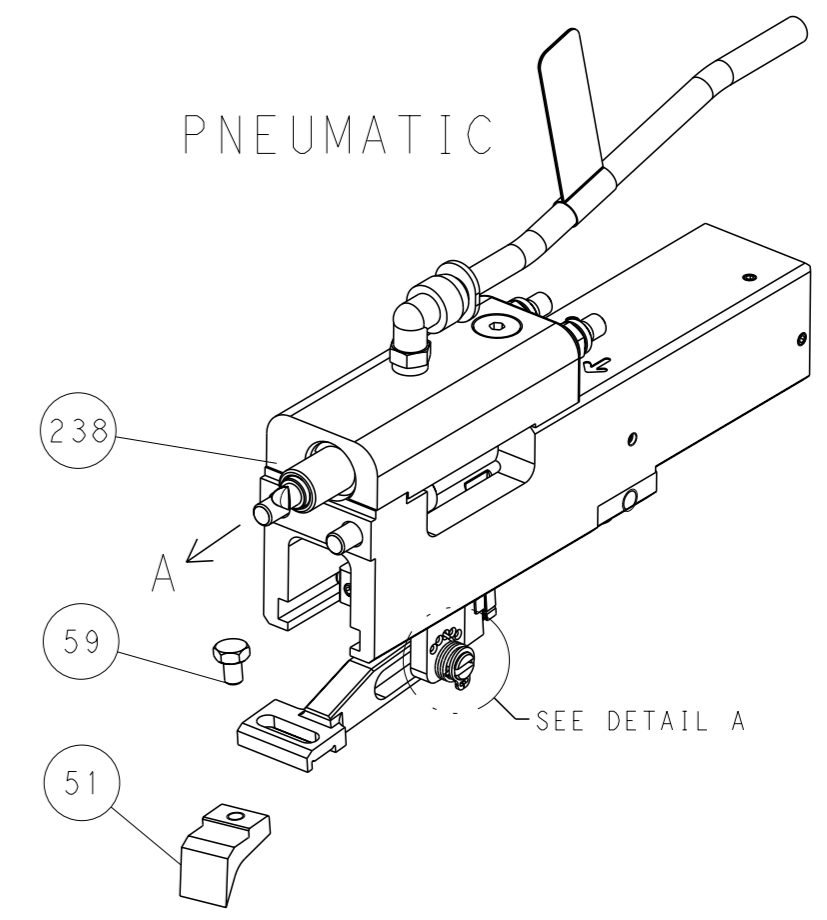
LOC		DIST		REVISIONS			
A	66	P	LYR	DESCRIPTION	DATE	OWN	APVD
		-		SEE SHEET 1	-	-	-



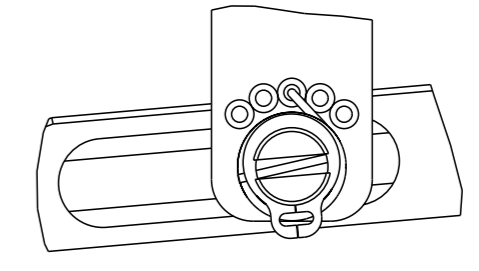
RAM SET-UP

FEED TYPE

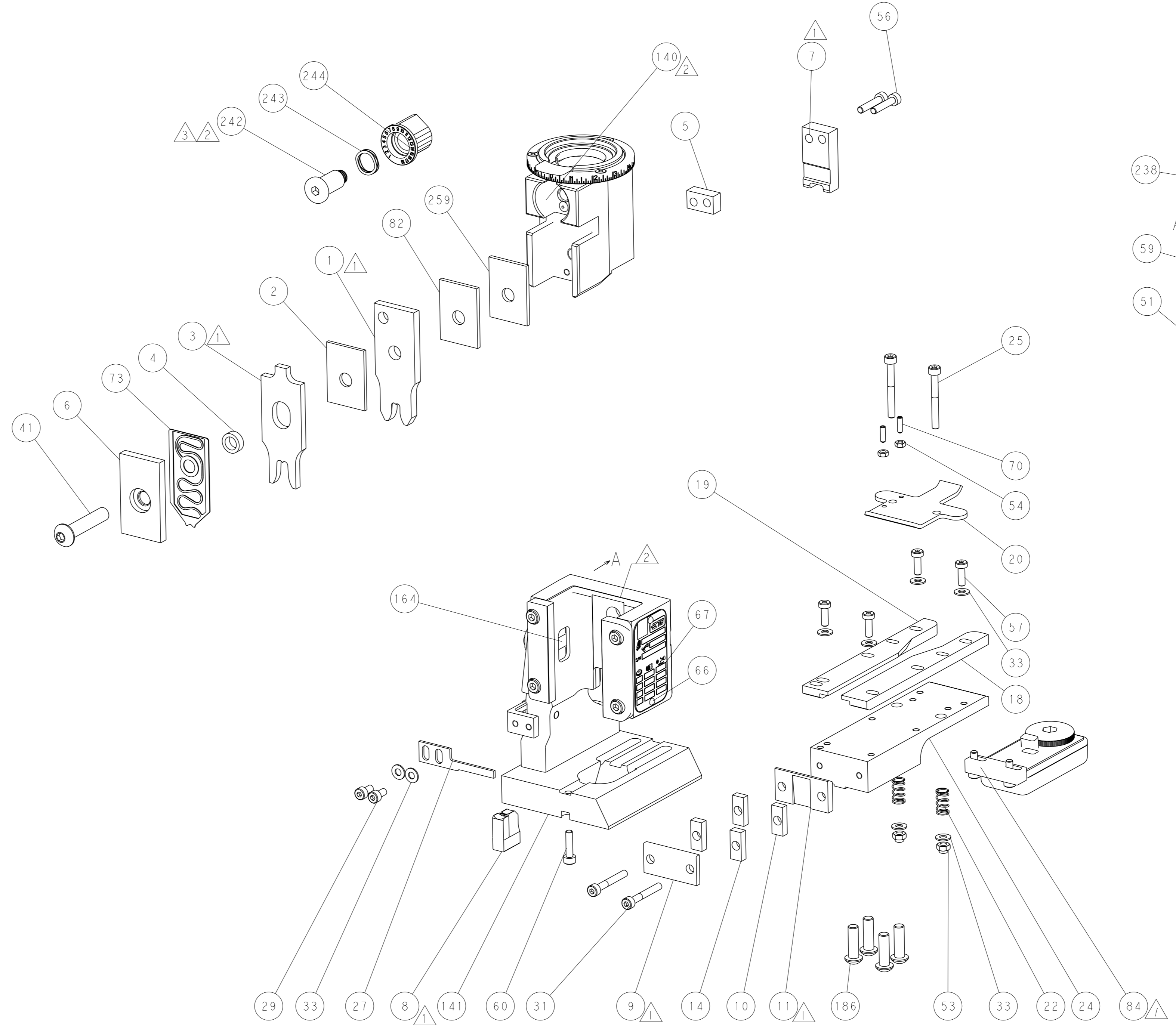
PNEUMATIC



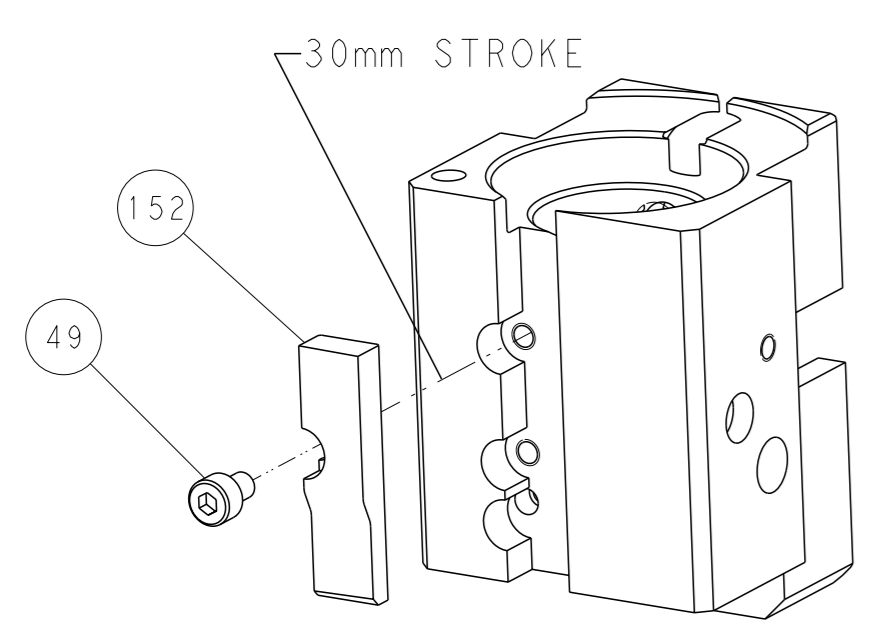
FEED SPRING SETTING POSITION



DETAIL A



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)

<small>THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE AND TO CONTROLING ENGINEERING DISCRETION. SHOULD BE CONTACTED FOR THE LATEST REVISION.</small>		DWN BOB HIGMAN 17FEB2016 CHK T. ELBIN 17FEB2016 APVD T. ELBIN 17FEB2016	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 SIZE CAGE CODE DRAWING NO. RESTRICTED TO A 00779 C=2150651	SCALE 1:1 SHEET 4 OF 4 REV B
MATERIAL:		WEIGHT:	Customer Accessible Production Drawing