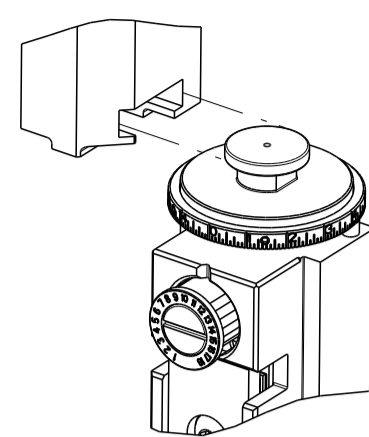


THIS DRAWING IS UNPUBLISHED.	RELEASED FOR PUBLICATION		
COPYRIGHT 20 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.			
PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150664-2	E	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150664-2	E	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150664-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.79 mm [.110]	F
INSUL	3.56 mm [.140]	F
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: 2.5mm SYSTEM FLAG CONTACT SOCKET			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
5.20-5.80 mm [.205-.228 IN]		∅2.10-3.10 mm [.083-.122 IN]	
TERMINAL APPLICATION SPECIFICATION	114-18031-1	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
927812-2	927814-1	927814-4	
927812-4	927814-2	2-927814-2	
927812-5	927814-3	3-927814-3	

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
2.50mm2	1.81+/-0.05 [.071+/-0.002]	5.0
2.00mm2	1.71+/-0.05 [.067+/-0.002]	5.9
1.50mm2	1.57+/-0.05 [.062+/-0.002]	7.3



- 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.

**\*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.

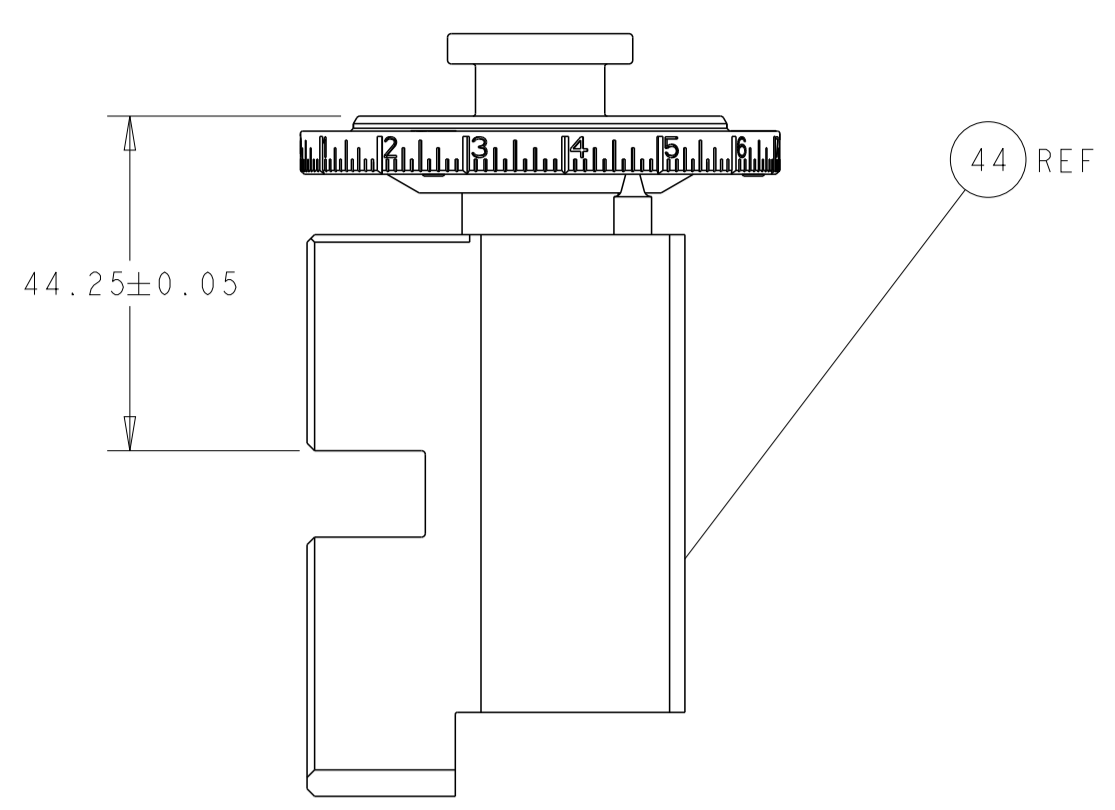
LOC	DIST	REVISIONS					
A	66	P	LTN	DESCRIPTION	DATE	OWN	APVD
		B		ECR-17-006122	27APR2017	BW	CT
		C		ECR-19-003380	02MAR2019	TB	CT
		D		ECR-22-140977	31MAY2022	JWC	ROY
		E		ECR-22-153955	27SEP2022	JWC	GB

-	1	1	2119641-1	FEED CAM, AIR FEED	248		
-	1	1	2119082-4	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	2844940-7	AIR FEED MODULE	238		
-	1	1	1-18028-0	WASHER, FLAT, REG M8	192		
-	REF	REF	994970-2	COUNTER, MAGNETIC	164		
-	1	1	980371-4	SCR, SKT HD SHLDR 5.0 DIA X 6.0	105		
-	2	2	2-18032-5	SCR, SET, FLT PNT, M5 X 20.0	99		
	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	85		
-	1	1	2119955-5	ASSY, LUBRICATOR, SIDE 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	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	224716-6	PAWL, FEED	56		
-	2	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	53		
-	1	1	1803392-1	SHEAR DEPRESSOR	50		
-	1	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49		
-	1	1	2-2119655-3	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		
-	2	2	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	36		
-	2	2	1-18028-2	WASHER, FLAT, REG M4	33		
-	2	2	1-2079383-2	SCR, BHSC, RoHS (M4 X 12)	32		
-	1	1	679768-1	GUIDE, STRIP, REAR	31		
-	2	2	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	29		
-	2	2	2-22281-3	SPRING, COMPRESSION	28		
-	1	1	240639-1	STRIPPER (MACHINING)	27		
-	1	1	356835-1	LEVER, DRAG RELEASE	26		
-	1	1	240792-1	DRAG, TERMINAL	25		
-	1	1	1803390-1	STRIP GUIDE	24		
-	1	1	690438-2	FRONT STRIP GUIDE	23		
-	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17		
-	1	1	3-22280-3	SPRING, COMPRESSION	12		
-	1	1	1-356885-1	STOP, SHEAR	11		
	1	1	1803391-1	SHEAR HOLDER	10		
	1	1	679835-1	FLOATING SHEAR	9		
	1	2	1803387-1	ANVIL, COMBINATION, END FEED	8		
-	-	-	-	-	7		
-	-	-	-	-	6		
-	-	-	-	-	5		
-	1	1	238011-2	BLOCK, CRIMPER SPACER	4		
	1	2	2-1633961-3	CRIMPER, INSULATION F PREMIUM	3		
-	1	1	455888-7	SPACER, CRIMPER	2		
	1	2	456408-6	CRIMPER, WIRE PREMIUM	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)

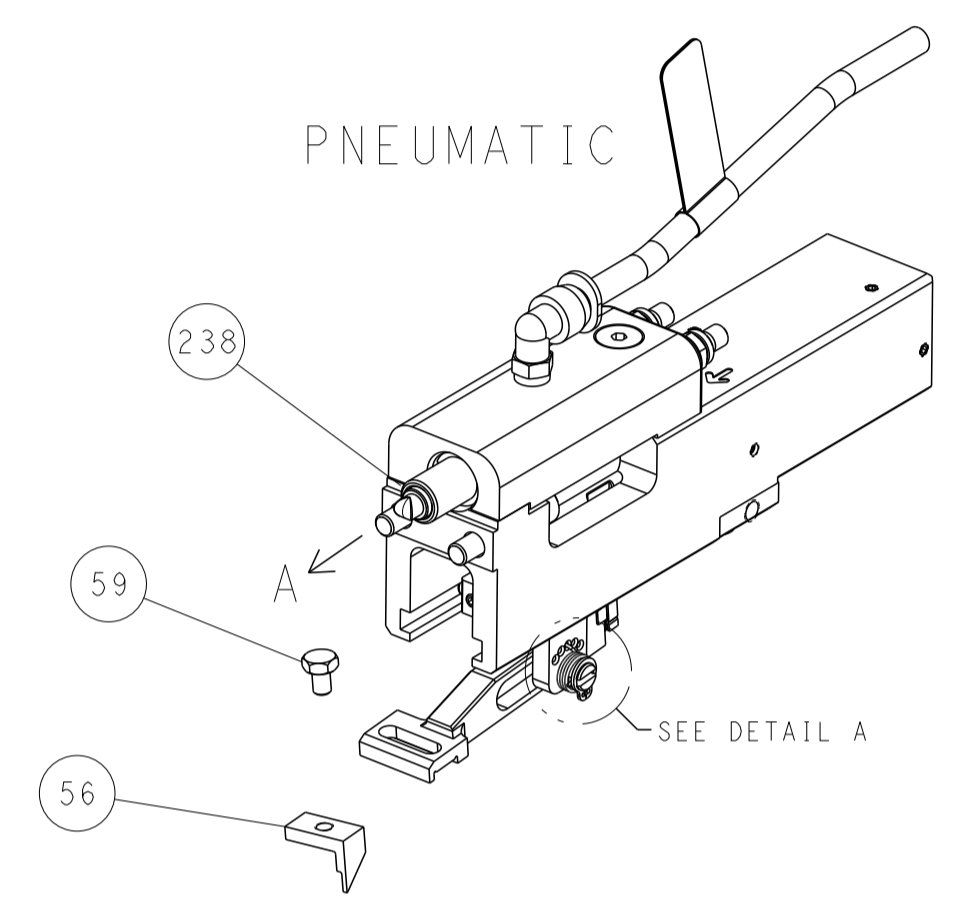
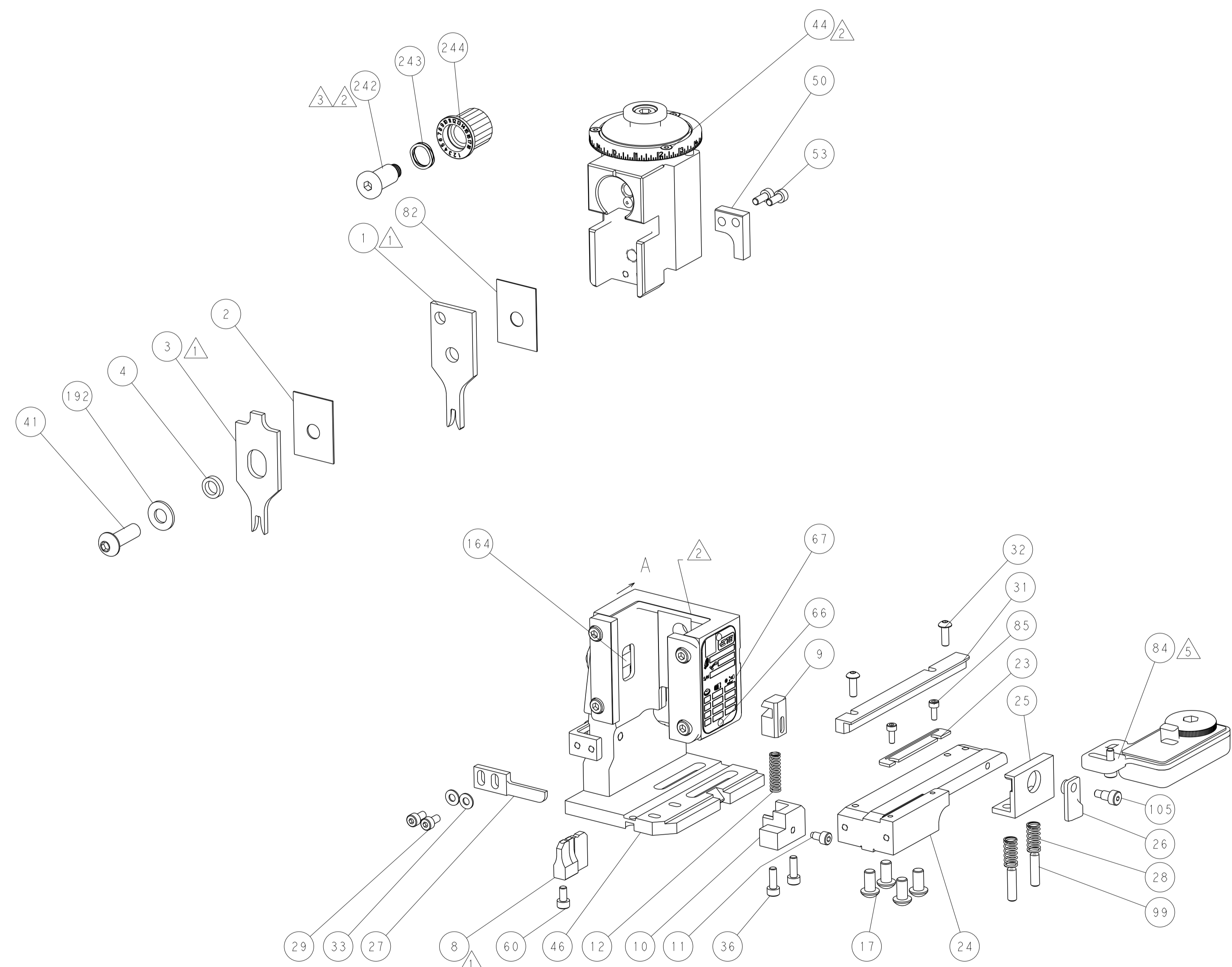
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG: BOB HIGMAN 15APR2016		CHK: T. ELBIN 15APR2016		APVD: T. ELBIN 15APR2016		NAME: Ocean End Feed Applicator	
0 PLC	±	1 PLC	±	SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO	Customer Accessible Production Drawing			
2 PLC	±	3 PLC	±	SCALE	00779	©=2150664	1 of 4	SHEET 1			
4 PLC	±	ANGLES	±	WEIGHT			REV	E			
FINISH	±										

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

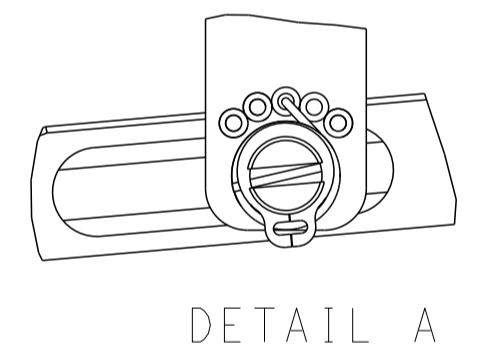


RAM SET-UP

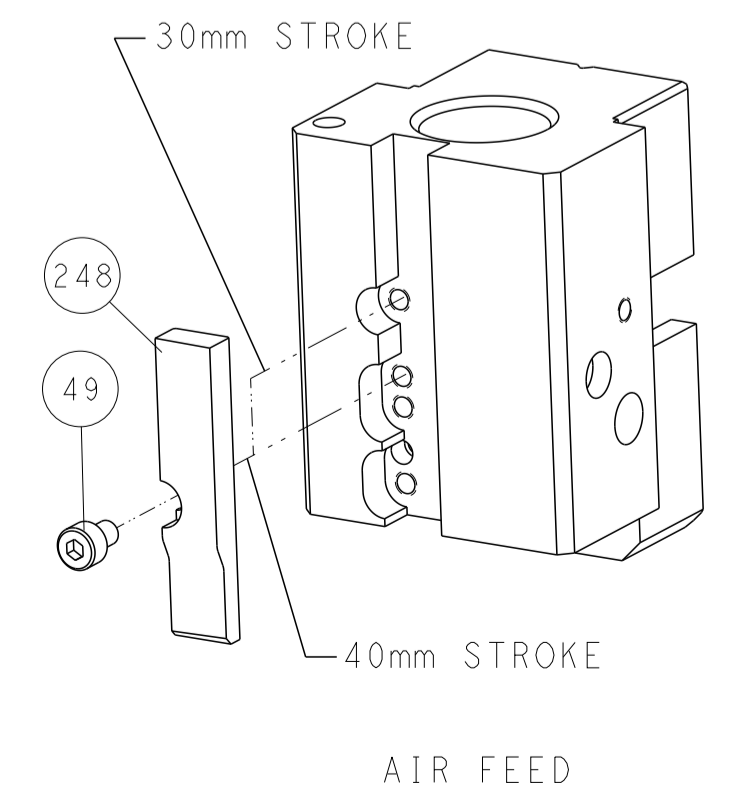
FEED TYPE



FEED SPRING SETTING POSITION



CAM POSITION

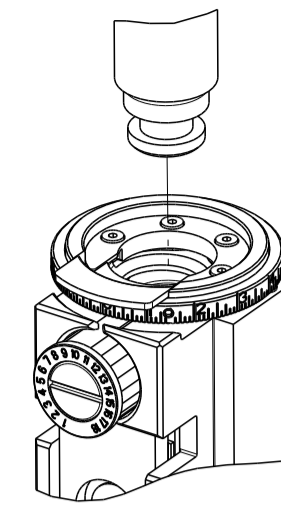


ATLANTIC VERSION  
 Shown on sheets 1 of 4 & 2 of 4  
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

<small>THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.</small>		DWN BOB HIGMAN 15APR2016 CHK T. ELBIN 15APR2016 APVD T. ELBIN 15APR2016	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=2150664	WEIGHT SCALE 1:1 SHEET 2 OF 4 REV E
MATERIAL		Customer Accessible Production Drawing	

THIS DRAWING IS UNPUBLISHED.	RELEASED FOR PUBLICATION		
COPYRIGHT 20 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.			
PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150664-2	E	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150664-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.79 mm (.110)	F
INSUL	3.56 mm (.140)	F
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: 2.5mm SYSTEM FLAG CONTACT SOCKET			
WIRE STRIP LENGTH 5.20-5.80 mm (.205-.228 IN)		INSULATION DIAMETER RANGE Ø2.10-3.10 mm (.083-.122 IN)	
TERMINAL APPLICATION SPECIFICATION	114-18031-1	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
927812-2	927814-1	927814-4	
927812-4	927814-2	2-927814-2	
927812-5	927814-3	3-927814-3	

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
2.50mm2	1.81+/-0.05 [.071+/-0.002]	5.0
2.00mm2	1.71+/-0.05 [.067+/-0.002]	5.9
1.50mm2	1.57+/-0.05 [.062+/-0.002]	7.3



- 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.
- 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.

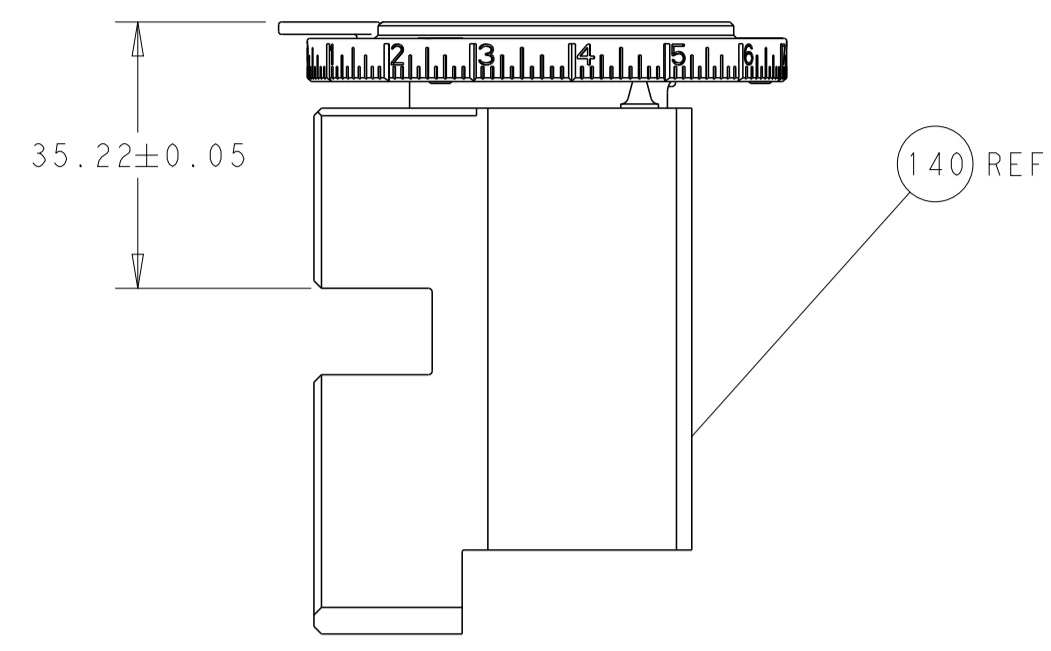
LOC	DIST	REVISIONS					
A	66	P	LTN	DESCRIPTION	DATE	OWN	APVD
-	-	-	-	SEE SHEET 1	-	-	-

-	1	2119082-4	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
3	-	2119083-1	RETAINER, INSULATION DIAL	242
-	1	2844940-7	AIR FEED MODULE	238
-	1	1-18028-0	WASHER, FLAT, REG M8	192
-	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	2-2119655-4	APPLICATOR BASIC ASSEMBLY, EF	141
-	1	1803518-1	RAM ASSEMBLY, EF PACIFIC	140
-	1	980371-4	SCR, SKT HD SHLDR 5.0 DIA X 6.0	105
-	2	2-18032-5	SCR, SET, FLT PNT, M5 X 20.0	99
-	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	85
5	-	2119955-5	ASSY, LUBRICATOR, SIDE FEED	84
-	1	455888-5	SPACER, CRIMPER	82
-	1	1803607-4	DOCUMENTATION PACKAGE	71
-	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
-	1	224716-6	PAWL, FEED	56
-	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	53
-	1	1803392-1	SHEAR DEPRESSOR	50
-	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
-	2	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	36
-	2	1-18028-2	WASHER, FLAT, REG M4	33
-	2	1-2079383-2	SCR, BHSC, RoHS (M4 X 12)	32
-	1	679768-1	GUIDE, STRIP, REAR	31
-	2	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	29
-	2	2-22281-3	SPRING, COMPRESSION	28
-	1	240639-1	STRIPPER (MACHINING)	27
-	1	356835-1	LEVER, DRAG RELEASE	26
-	1	240792-1	DRAG, TERMINAL	25
-	1	1803390-1	STRIP GUIDE	24
-	1	690438-2	FRONT STRIP GUIDE	23
-	4	2079383-9	SCR, BHSC, RoHS (M6 X 20)	17
-	1	3-22280-3	SPRING, COMPRESSION	12
-	1	1-356885-1	STOP, SHEAR	11
-	1	1803391-1	SHEAR HOLDER	10
-	1	679835-1	FLOATING SHEAR	9
1	1	1803387-1	ANVIL, COMBINATION, END FEED	8
-	-	-	-	7
-	-	-	-	6
-	-	-	-	5
-	1	238011-2	BLOCK, CRIMPER SPACER	4
1	1	2-1633961-3	CRIMPER, INSULATION F PREMIUM	3
-	1	455888-7	SPACER, CRIMPER	2
1	1	456408-6	CRIMPER, WIRE PREMIUM	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)

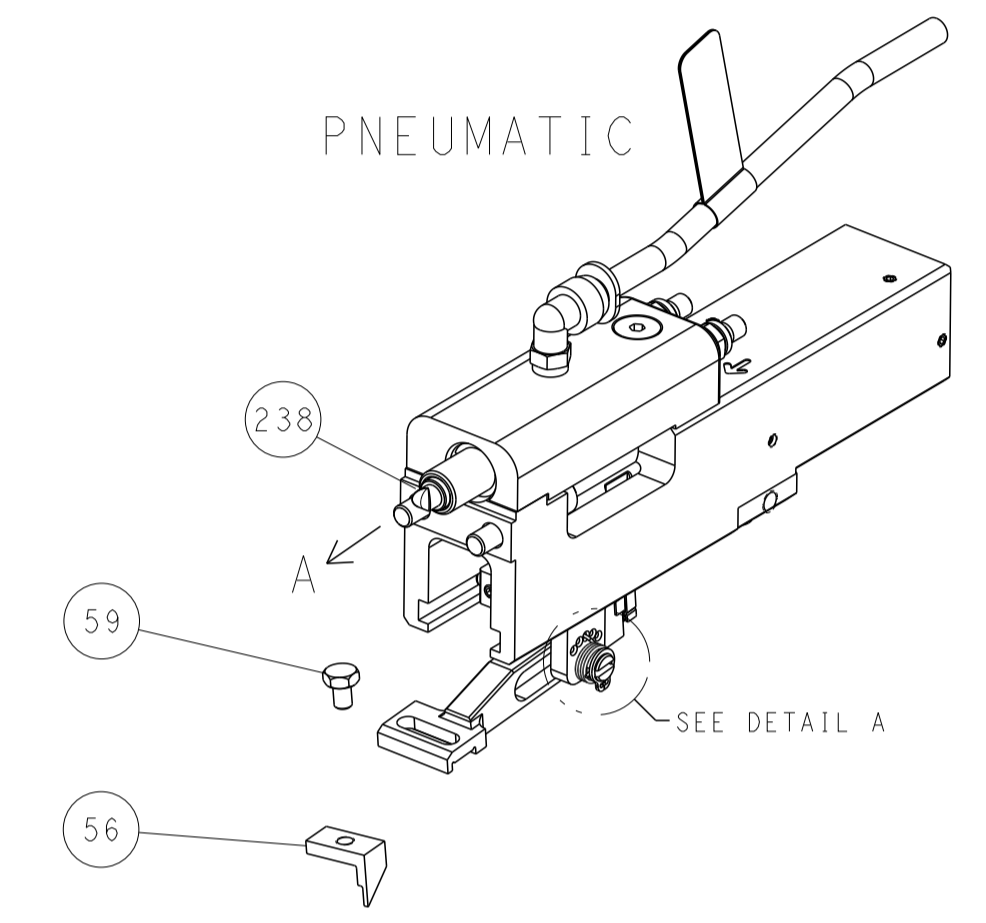
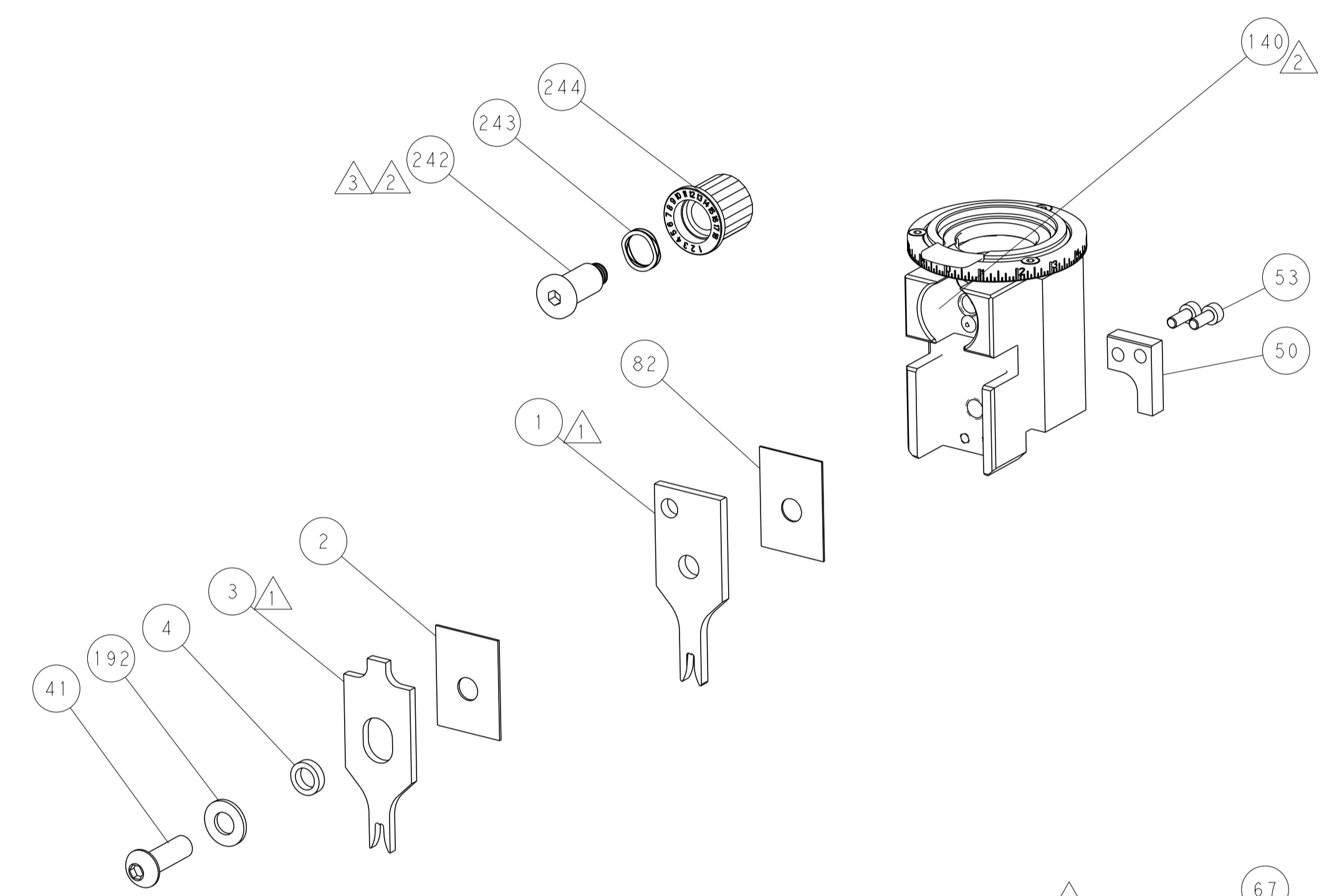
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG: BOB HIGMAN 15APR2016		CHK: T. ELBIN 15APR2016		NAME: I. ELBIN 15APR2016		APVD: T. ELBIN 15APR2016	
0 PLC	±	1 PLC	±	PRODUCT SPEC	TE Connectivity Harrisburg, PA 17105-3608						
2 PLC	±	3 PLC	±	APPLICATION SPEC	Ocean End Feed Applicator						
4 PLC	±	ANGLES	±	SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO				
FINISH	±	WEIGHT	-	A1	00779	©=2150664	-				
MATERIAL				Customer Accessible Production Drawing				SCALE: 1:1 SHEET 3 OF 4 REV E			

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

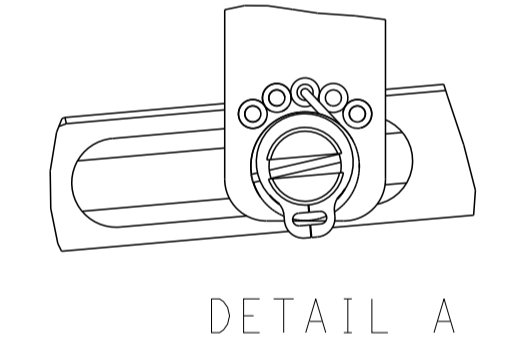


RAM SET-UP

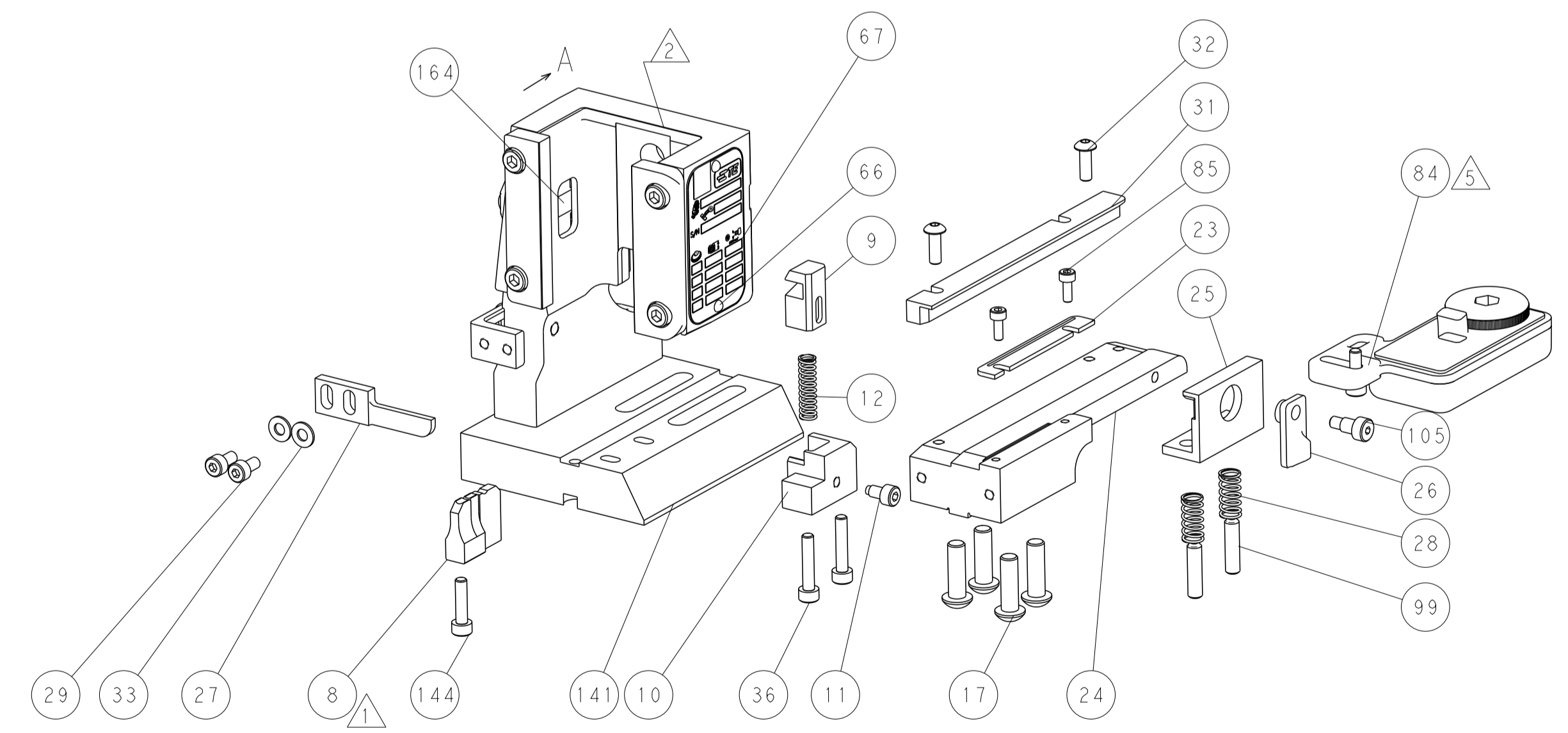
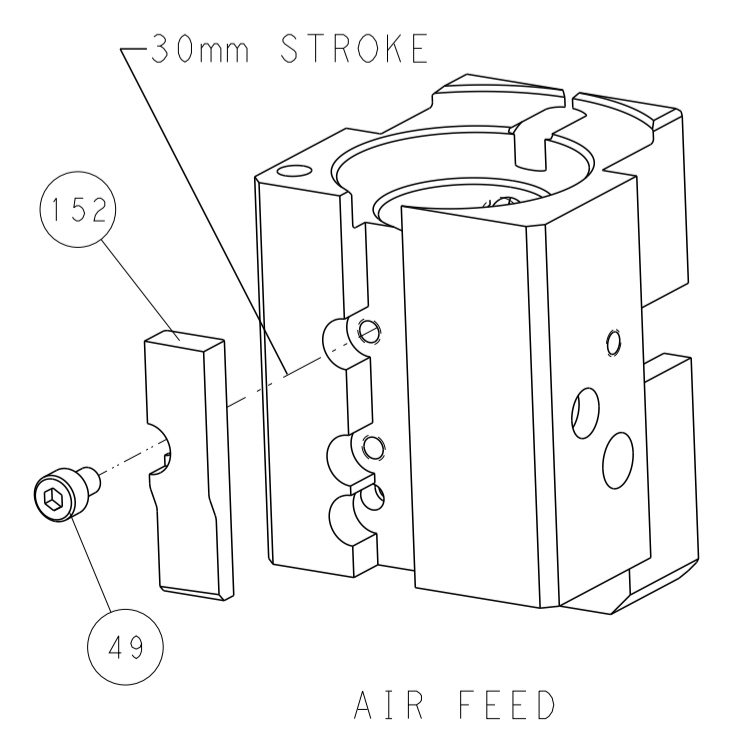
FEED TYPE



FEED SPRING SETTING POSITION



CAM POSITION



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 BOB HIGMAN 15APR2016 CHK T. ELBIN 15APR2016 APVD T. ELBIN 15APR2016	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 C=2150664 WEIGHT Customer Accessible Production Drawing	RESTRICTED TO SCALE 1:1 SHEET 4 OF 4 REV E