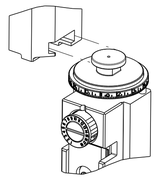
PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150727-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2150727-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150727-1	B	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2150727-2	B	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150727-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



LOC	DIST
A	66

REVISIONS

P	LTR	DESCRIPTION	DATE	DWN	APVD
	A	RELEASED	30AUG2016	MEH	TE
	B	ECR-21-005502	17MAY2021	TB	RK
	B1	ECR-23-180581	07JUL2023	FZ	JAH
	B2	ECR-23-181587	18JUL2023	FZ	GB

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.57 mm [.062]	F
INSUL	2.03 mm [.080]	F
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION
TERMINAL NAME: RING TONGUE WIRE TERMINAL		
WIRE STRIP LENGTH 2.77-3.53 mm [.109-.139 IN]		INSULATION DIAMETER RANGE ∅1.00-1.52 mm [.039-.060 IN]
TERMINAL APPLICATION SPECIFICATION	114-5200-1	- -
	-	- -
TERMINALS APPLIED 5 7		
TE TERMINAL	TE TERMINAL	TE TERMINAL TE TERMINAL
170022-1	170022-2	170022-3

WIRE SIZE	CRIMP HEIGHT mm [INCH]	4 CRIMP HEIGHT REFERENCE SETTING
22 AWG OR 0.38mm2	1.04+/-0.05 [.041+/-.002]	6.5
24 AWG OR 0.20mm2	0.97+/-0.05 [.038+/-.002]	7.2
26 AWG OR 0.12mm2	0.91+/-0.05 [.036+/-.002]	7.9

1 RECOMMENDED SPARE PARTS

2 REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.

3 APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242.

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 TERMINAL LUBRICANT IS RECOMMENDED.

6. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.

7 TERMINAL MUST BE FED OFF INSULATION LEGS.

*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.

					PART NO	DESCRIPTION	ITEM NO
	-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248
	-	1	1	1	1	2119082-4	CAM, SNAIL, INSULATION ADJUSTMENT	244
	-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
3	-	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
	-	-	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
	-	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
5	-	1	1	1	1	2119955-2	ASSY, LUBRICATOR, END FEED	84
	-	1	1	1	1	455888-5	SPACER, CRIMPER	82
	-	1	1	1	1	1803607-4	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	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
7	-	-	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	1-2168083-4	SCR, SKT HD CAP, RoHS, M4 X 5	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
7	-	1	-	1	-	2063961-9	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	1803602-1	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	240639-1	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	1803292-1	DRAG	20
	-	1	1	1	1	1901696-2	STRIP GUIDE, REAR	19
	-	1	1	1	1	1901695-2	STRIP GUIDE, FRONT	18
	-	4	4	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17
	-	1	1	1	1	4-240641-9	SPACER	16
1	-	1	1	1	1	240644-1	PLATE, REAR SHEAR	11
	-	-	-	-	-	-	-	10
1	-	1	1	1	1	690482-5	PLATE, FRONT SHEAR	9
1	1	2	2	1	1	4-1803060-2	ANVIL, COMBINATION, END FEED	8
1	-	1	1	1	1	2217206-8	BLADE, SLUG	7
	-	-	-	-	-	-	-	6
	-	1	1	1	1	4-240641-3	SPACER	5
	-	1	1	1	1	2-238011-2	BLOCK, CRIMPER SPACER	4
1	1	2	2	1	1	5-2119582-9	CRIMPER, INSULATION F PREMIUM	3
	-	1	1	1	1	455888-7	SPACER, CRIMPER	2
1	1	2	2	1	1	4-456403-2	CRIMPER, WIRE PREMIUM	1
	-77-	72-	71-	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)

DWN M. HERR 17AUG2016
CHK T. ELBIN 17AUG2016
APVD T. ELBIN 17AUG2016
PRODUCT SPEC -
APPLICATION SPEC -
WEIGHT -
DIMENSIONS: mm
TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±- 1 PLC ±- 2 PLC ±- 3 PLC ±- 4 PLC ±- ANGLES ±-
MATERIAL - -
FINISH - -

TE Connectivity
Harrisburg, PA 17105-3608

NAME Ocean End Feed Applicator -

SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
A1	00779	C-2150727	-

Customer Accessible Production Drawing | SCALE 1:1 | SHEET 1 OF 4 | REV B2

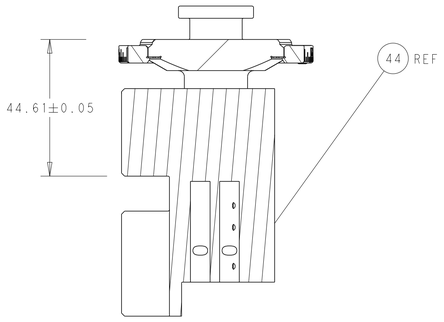
SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

LOC	DIST
A	66

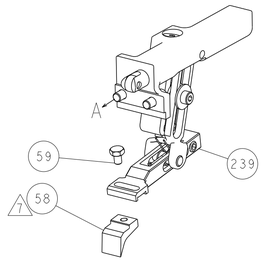
REVISIONS

P	LTR	DESCRIPTION	DATE	DWN	APVD
	-	SEE SHEET 1	-	-	-

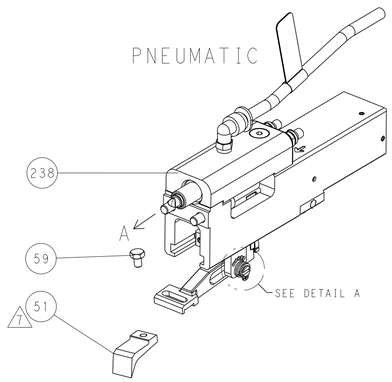
FEED TYPE MECHANICAL

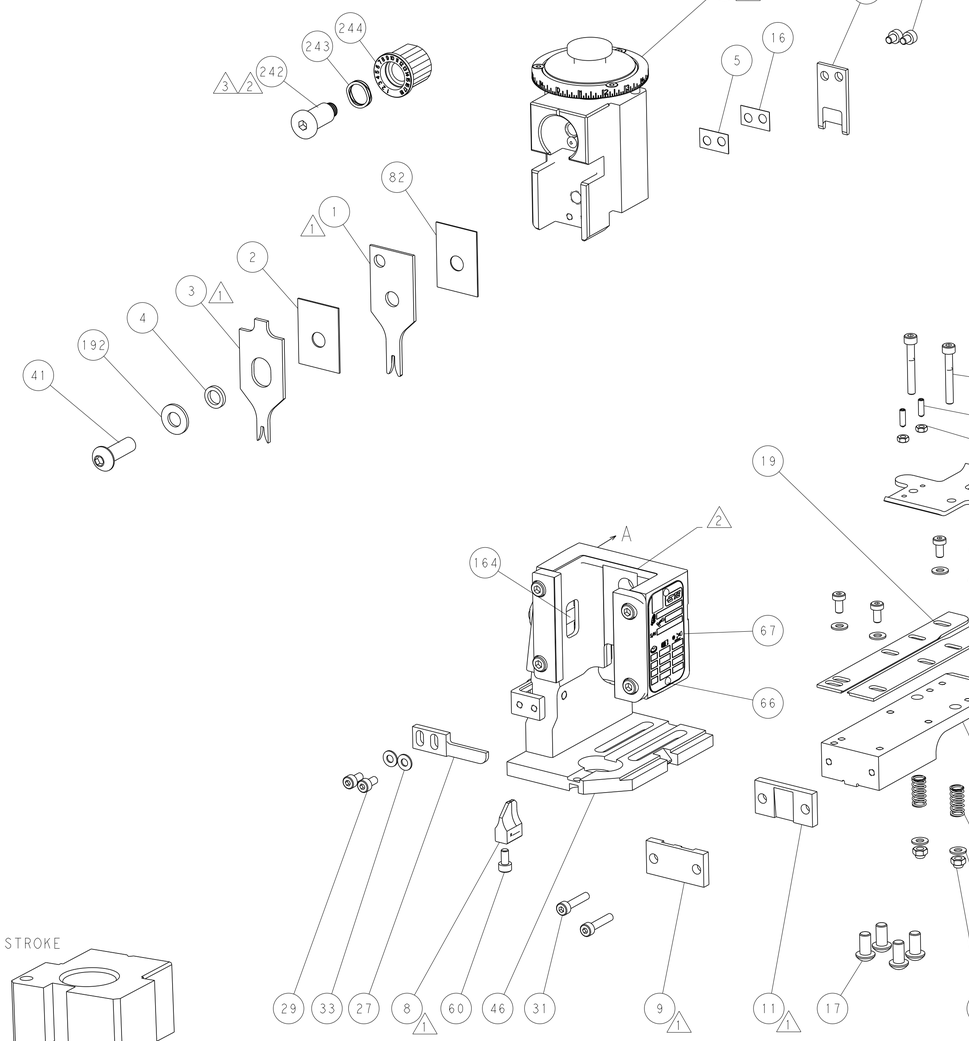


RAM SET-UP

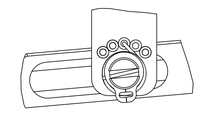


PNEUMATIC



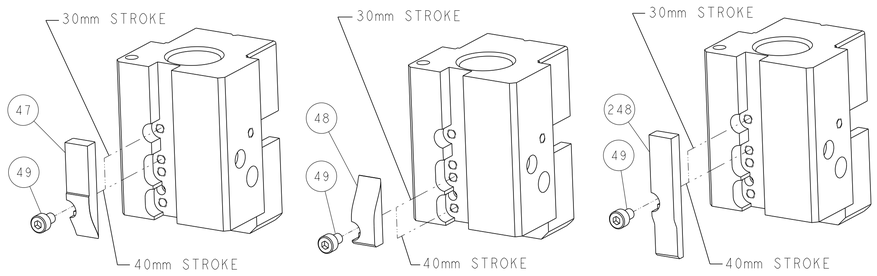


FEED SPRING SETTING POSITION



DETAIL A

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 ±-

MATERIAL -
FINISH -

DWN	M. HERR	17AUG2016
CHK	T. ELBIN	17AUG2016
APVD	T. ELBIN	17AUG2016
PRODUCT SPEC	-	
APPLICATION SPEC	-	
WEIGHT	-	

TE Connectivity
Harrisburg, PA 17105-3608

NAME: Ocean End Feed Applicator -

SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
A1	00779	C-2150727	-

Customer Accessible Production Drawing | SCALE 1:1 | SHEET 2 OF 4 | REV B2

SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

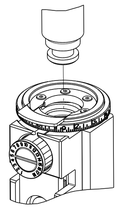
LOC	DIST
A	66

REVISIONS

P	LTR	DESCRIPTION	DATE	DWN	APVD
	-	SEE SHEET 1	-	-	-

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150727-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2150727-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150727-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.57 mm [.062]	F
INSUL	2.03 mm [.080]	F
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION
TERMINAL NAME: RING TONGUE WIRE TERMINAL		
WIRE STRIP LENGTH 2.77-3.53 mm [.109-.139 IN]		INSULATION DIAMETER RANGE ∅1.00-1.52 mm [.039-.060 IN]
TERMINAL APPLICATION SPECIFICATION	114-5200-1	- -
	-	- -

TERMINALS APPLIED 5 7

TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
170022-1	170022-2	170022-3	

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING 4
22 AWG OR 0.38mm2	1.04+/-0.05 [.041+/-.002]	6.5
24 AWG OR 0.20mm2	0.97+/-0.05 [.038+/-.002]	7.2
26 AWG OR 0.12mm2	0.91+/-0.05 [.036+/-.002]	7.9

1 RECOMMENDED SPARE PARTS

2 REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.

3 APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242.

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 TERMINAL LUBRICANT IS RECOMMENDED.

6. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.

7 TERMINAL MUST BE FED OFF INSULATION LEGS.

*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)

			PART NO	DESCRIPTION	ITEM NO
-	1	1	2119082-4	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
3 -	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	1	-	2844940-3	AIR FEED MODULE	238
-	1	1	1-18028-0	WASHER, FLAT, REG M8	192
-	4	4	2079383-9	SCR, BHSC, RoHS (M6 X 20)	186
-	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
5 -	1	1	2119955-2	ASSY, LUBRICATOR, END FEED	84
-	1	1	455888-5	SPACER, CRIMPER	82
-	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	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
7 -	-	1	2063961-1	FEED FINGER	58
-	4	4	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57
-	2	2	1-2168083-4	SCR, SKT HD CAP, RoHS, M4 X 5	56
-	2	2	5018030-1	NUT, HEX, REG, RoHS, M3	54
-	2	2	986965-8	NUT, LOCK, HEX, TORQUE (M4)	53
7 -	1	-	2063961-9	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	1803602-1	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	240639-1	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	1803292-1	DRAG	20
-	1	1	1901696-2	STRIP GUIDE, REAR	19
-	1	1	1901695-2	STRIP GUIDE, FRONT	18
-	1	1	4-240641-9	SPACER	16
1 -	1	1	240644-1	PLATE, REAR SHEAR	11
-	-	-	-	-	10
1 -	1	1	690482-5	PLATE, FRONT SHEAR	9
1 1	1	1	4-1803060-2	ANVIL, COMBINATION, END FEED	8
1 -	1	1	2217206-8	BLADE, SLUG	7
-	-	-	-	-	6
-	1	1	4-240641-3	SPACER	5
-	1	1	2-238011-2	BLOCK, CRIMPER SPACER	4
1 1	1	1	5-2119582-9	CRIMPER, INSULATION F PREMIUM	3
-	1	1	455888-7	SPACER, CRIMPER	2
1 1	1	1	4-456403-2	CRIMPER, WIRE PREMIUM	1

DWN M. HERR 17AUG2016
CHK T. ELBIN 17AUG2016
APVD T. ELBIN 17AUG2016
PRODUCT SPEC -
APPLICATION SPEC -
WEIGHT -

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

TE Connectivity
Harrisburg, PA 17105-3608

NAME Ocean End Feed Applicator -

SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
A1	00779	C-2150727	-

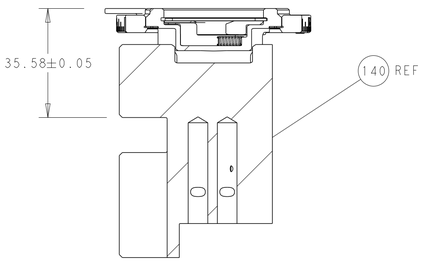
Customer Accessible Production Drawing | SCALE - 1:1 | SHEET 3 OF 4 | REV B2

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

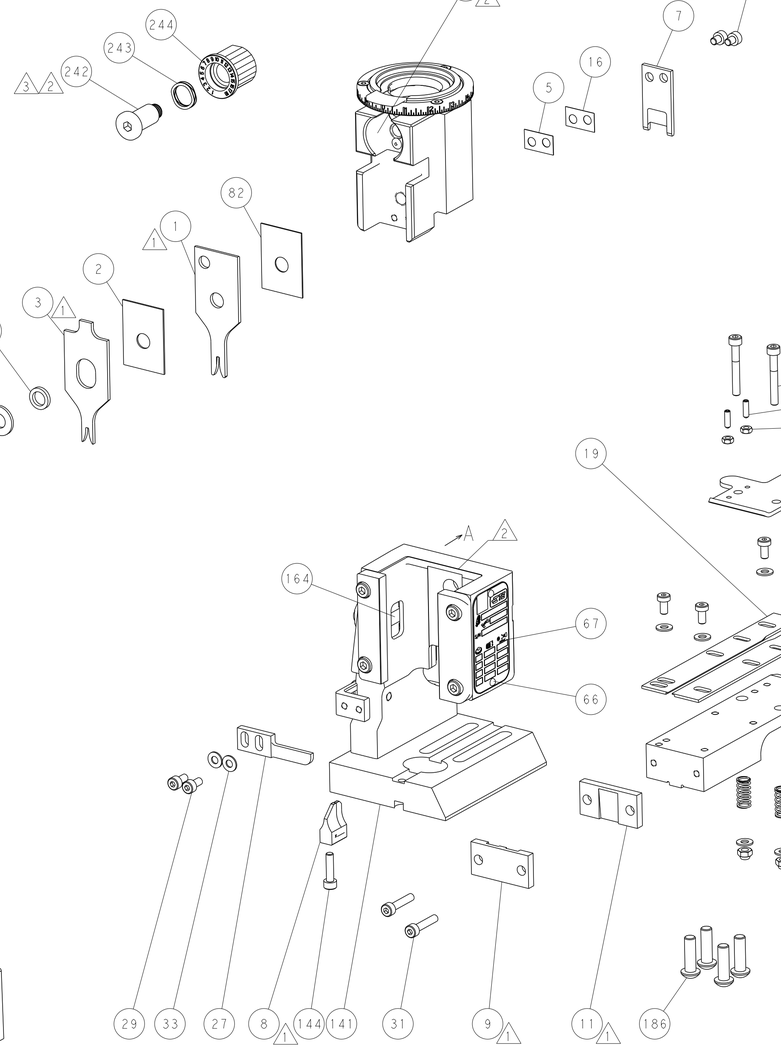
LOC	DIST
A	66

REVISIONS

P	LTR	DESCRIPTION	DATE	DWN	APVD
	-	SEE SHEET 1	-	-	-

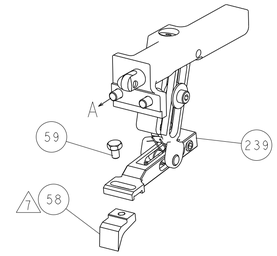


RAM SET-UP

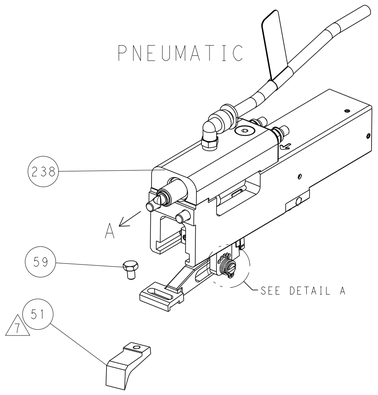


FEED TYPE

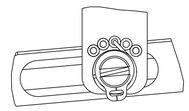
MECHANICAL



PNEUMATIC

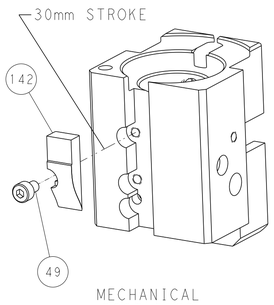


FEED SPRING
SETTING POSITION

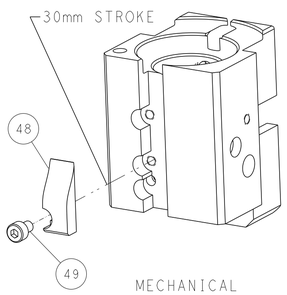


DETAIL A

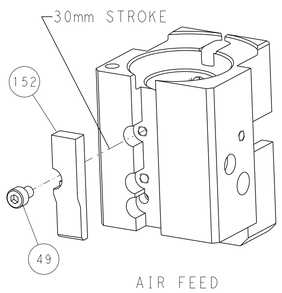
CAM POSITIONS



MECHANICAL
POST FEED



MECHANICAL
PRE FEED



AIR FEED

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

THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION IT IS SUBJECT TO CHANGE AND THE CONTROLLING ENGINEERING ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST REVISION.

DIMENSIONS: mm

TOLERANCES UNLESS OTHERWISE SPECIFIED:
0 PLC ±-
1 PLC ±-
2 PLC ±-
3 PLC ±-
4 PLC ±-
ANGLES ±-

MATERIAL - -

FINISH - -

DWN	M. HERR	17AUG2016
CHK	T. ELBIN	17AUG2016
APVD	T. ELBIN	17AUG2016
PRODUCT SPEC	-	
APPLICATION SPEC	-	
WEIGHT	-	

TE Connectivity
Harrisburg, PA 17105-3608

NAME: Ocean End Feed Applicator -

SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
A1	00779	C-2150727	-

Customer Accessible Production Drawing | SCALE 1:1 | SHEET 4 OF 4 | REV B2

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION