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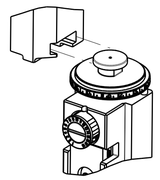
LOC	DIST
A	66

REVISIONS

P	LTR	DESCRIPTION	DATE	DWN	APVD
	A	RELEASED	22JUN2017	MEH	GB
	B	ECR-19-005372	04APR2019	FL	CT
	C	ECR-19-013189	22AUG2019	MZ	YY

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150799-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2150799-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150799-1	C	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2150799-2	C	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150799-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.27 mm [.050]	O
INSUL	-	-
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: HS UNITED TERMINAL		HS UNITED CRIMP SPECIFICATION	
TERMINAL NAME: WIRE END CLAW			
WIRE STRIP LENGTH 5.34-6.10 mm [.210-.240 IN]		INSULATION DIAMETER RANGE ∅	-
TERMINAL APPLICATION SPECIFICATION	2302106_21013320 Rev A	-	-
	-	-	-

TERMINALS APPLIED 5

TE TERMINAL	HS UNITED TERMINAL	TE TERMINAL	HS UNITED TERMINAL
2302106-1	21013320		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING 3
0.50mm2	1.10+/-0.03 [.043+/-.001]	8.5
0.35mm2	1.00+/-0.03 [.039+/-.001]	9.2

1 RECOMMENDED SPARE PARTS

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

3 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.

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

5 TERMINAL LUBRICATOR 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.

					-77-72-71-2-1 PART NO	DESCRIPTION	ITEM NO
-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248
-	-	1	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	1	-	1	-	2844940-3	AIR FEED MODULE	238
-	1	1	1	1	1803071-1	SPACER,REAR SHEAR STRIP GUIDE	196
1	-	1	1	1	1 3-459722-3	BLADE, SHEAR	195
-	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	1803203-1	BLOCK, FRONT DEPRESSOR	77
-	1	1	1	1	2119791-5	DEPRESSOR, WIRE	73
-	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	2119943-1	WASHER, SPACER	69
-	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	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	-	1	-	1	1-2063961-5	FEED FINGER	58
-	4	4	4	4	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57
-	1	1	1	1	1-462932-2	PLATE, STRIP COVER	55
-	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	-	1-2063961-5	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	1-2119655-7	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
-	6	6	6	6	1-18028-2	WASHER, FLAT, REG M4	33
-	2	2	2	2	1-2168083-2	SCR, SKT HD CAP, RoHS, M4 X 25	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	1752371-1	PLATE, STRIP GUIDE	24
-	2	2	2	2	22281-8	SPRING, COMPRESSION	22
-	1	1	1	1	1803292-4	DRAG	20
-	2	2	2	2	1901259-1	GUIDE, LOWER STRIP	18
-	4	4	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17
1	-	1	1	1	240644-1	PLATE, REAR SHEAR	11
-	2	2	2	2	240645-2	SPACER, SHEAR PLATE	10
1	1	2	2	1	1 1-1633342-2	ANVIL, WIRE	8
-	-	-	-	-	-	-	5
-	-	-	-	-	-	-	4
-	-	-	-	-	-	-	3
-	-	-	-	-	-	-	2
1	1	2	1	1	1 8-459492-9	CRIMPER, WIRE O	1

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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DIMENSIONS: mm

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

MATERIAL -
FINISH -

DWN M. HERR	20APR2017	TE Connectivity, Harrisburg, PA 17105-3608
CHK T. ELBIN	20APR2017	
APVD T. ELBIN	20APR2017	NAME Ocean End Feed Applicator -
PRODUCT SPEC -		
APPLICATION SPEC -		
WEIGHT -		SIZE A1 · CAGE CODE 00779 · DRAWING NO C-2150799 · RESTRICTED TO -
Customer Accessible Production Drawing		SCALE 1:1 · SHEET 1 OF 4 · REV C

SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

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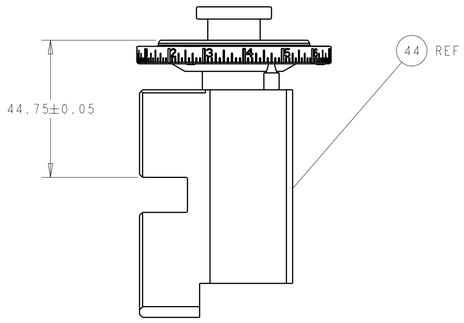
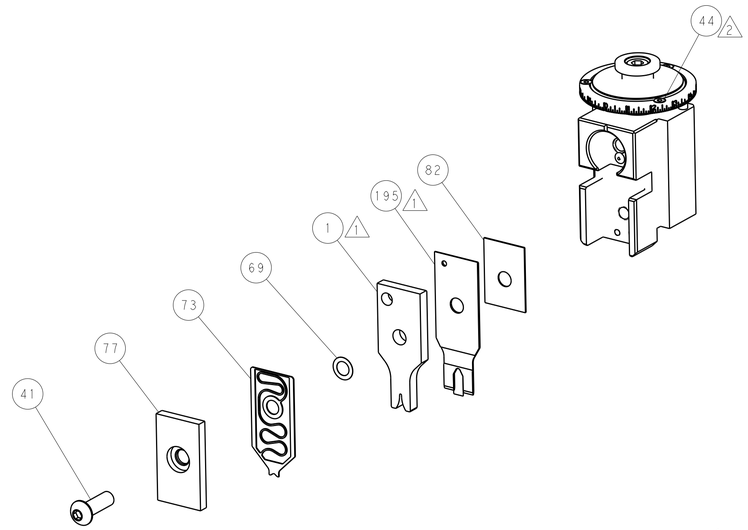
LOC	DIST
A	66

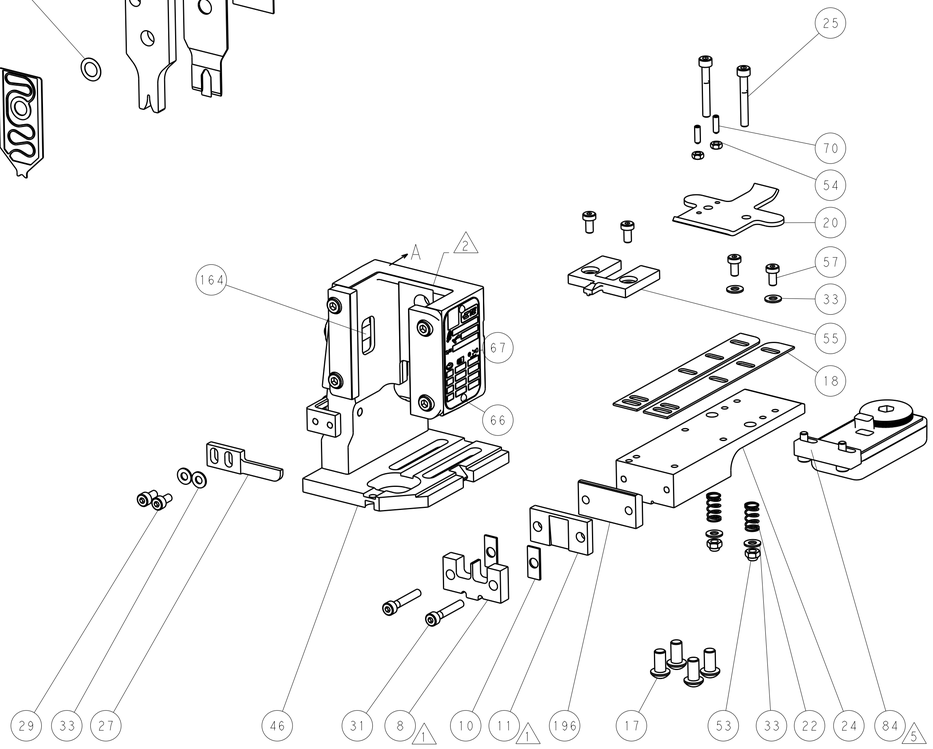
REVISIONS

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



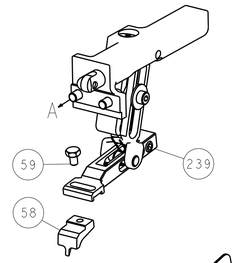
RAM SET-UP



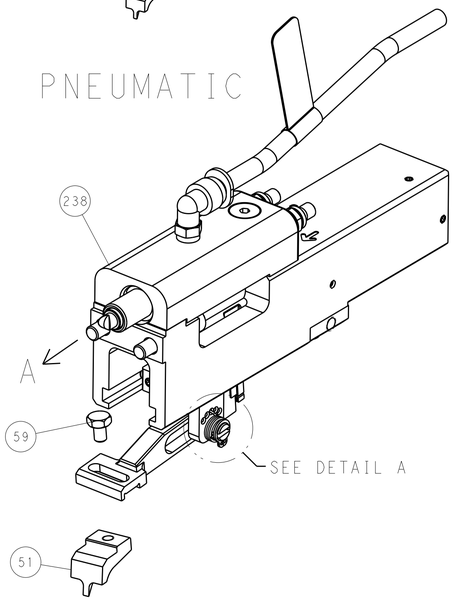


FEED TYPE

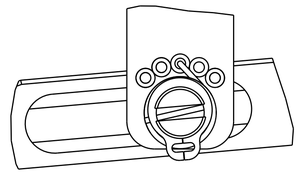
MECHANICAL



PNEUMATIC

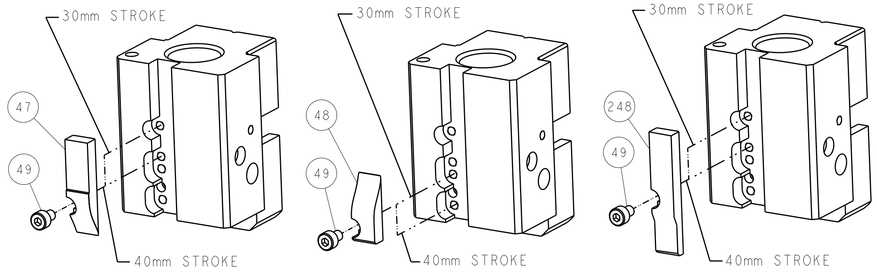


FEED SPRING
SETTING POSITION



DETAIL A

CAM POSITIONS



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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ANGLES ±-
MATERIAL -
FINISH -

DWN M. HERR 20APR2017
CHK T. ELBIN 20APR2017
APVD T. ELBIN 20APR2017
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-2150799	-

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

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LOC	DIST
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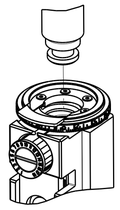
REVISIONS

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

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150799-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2150799-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150799-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.27 mm [.050]	O
INSUL	-	-
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: HS UNITED TERMINAL		HS UNITED CRIMP SPECIFICATION
TERMINAL NAME: WIRE END CLAW		
WIRE STRIP LENGTH 5.34-6.10 mm [.210-.240 IN]	INSULATION DIAMETER RANGE ∅	-
TERMINAL APPLICATION SPECIFICATION	2302106_21013320 Rev A	- - - -

TERMINALS APPLIED 5

TE TERMINAL	HS UNITED TERMINAL	TE TERMINAL	HS UNITED TERMINAL
2302106-1	21013320		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING 3
0.50mm2	1.10+/-0.03 [.043+/-.001]	8.5
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					ITEM NO
	-	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
	-	1	-	2844940-3	AIR FEED MODULE	238
	-	1	1	1803071-1	SPACER,REAR SHEAR STRIP GUIDE	196
1	-	1	1	3-459722-3	BLADE, SHEAR	195
	-	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	2119653-2	FEED CAM, POST FEED	142
	-	1	1	1-2119655-8	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	1803203-1	BLOCK, FRONT DEPRESSOR	77
	-	1	1	2119791-5	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	2119943-1	WASHER, SPACER	69
	-	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
	-	-	1	1-2063961-5	FEED FINGER	58
	-	4	4	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57
	-	1	1	1-462932-2	PLATE, STRIP COVER	55
	-	2	2	5018030-1	NUT, HEX, REG, RoHS, M3	54
	-	2	2	986965-8	NUT, LOCK, HEX, TORQUE (M4)	53
	-	1	-	1-2063961-5	FEED FINGER	51
	-	1	2	18023-9	SCR, SKT HD CAP M4 X 6.0	49
	-	-	1	2119652-1	FEED CAM, PRE FEED	48
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	-	2	2	1-2168083-2	SCR, SKT HD CAP, RoHS, M4 X 25	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	1752371-1	PLATE, STRIP GUIDE	24
	-	2	2	22281-8	SPRING, COMPRESSION	22
	-	1	1	1803292-4	DRAG	20
	-	2	2	1901259-1	GUIDE, LOWER STRIP	18
1	-	1	1	240644-1	PLATE, REAR SHEAR	11
	-	2	2	240645-2	SPACER, SHEAR PLATE	10
1	1	1	1	1-1633342-2	ANVIL, WIRE	8
	-	-	-	-	-	5
	-	-	-	-	-	4
	-	-	-	-	-	3
	-	-	-	-	-	2
1	1	1	1	8-459492-9	CRIMPER, WIRE O	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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DIMENSIONS: mm
TOLERANCES UNLESS OTHERWISE SPECIFIED:
0 PLC ±
1 PLC ±
2 PLC ±
3 PLC ±
4 PLC ±
ANGLES ±
MATERIAL -
FINISH -

DWN M. HERR 20APR2017
CHK T. ELBIN 20APR2017
APVD T. ELBIN 20APR2017
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-2150799	-

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

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

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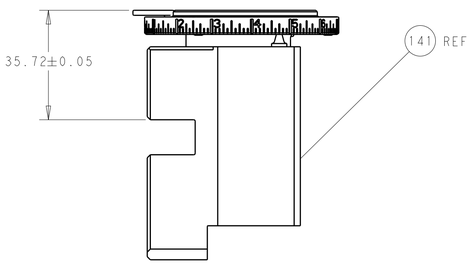
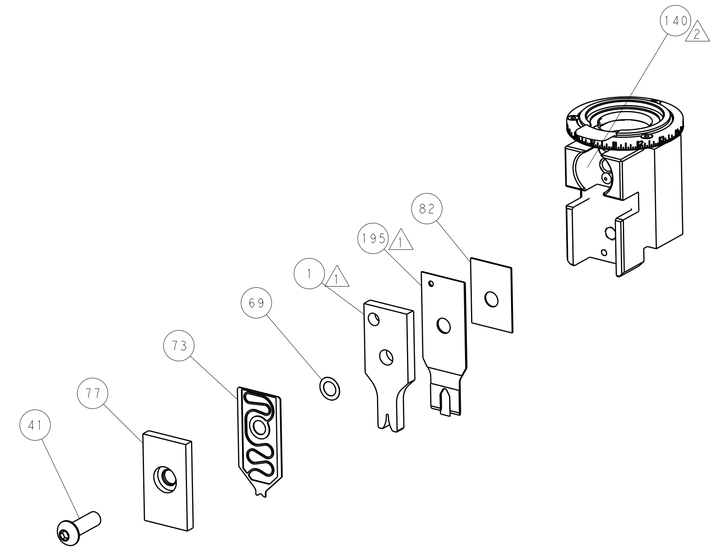
LOC	DIST
A	66

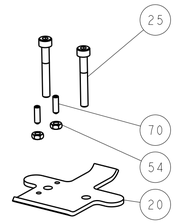
REVISIONS

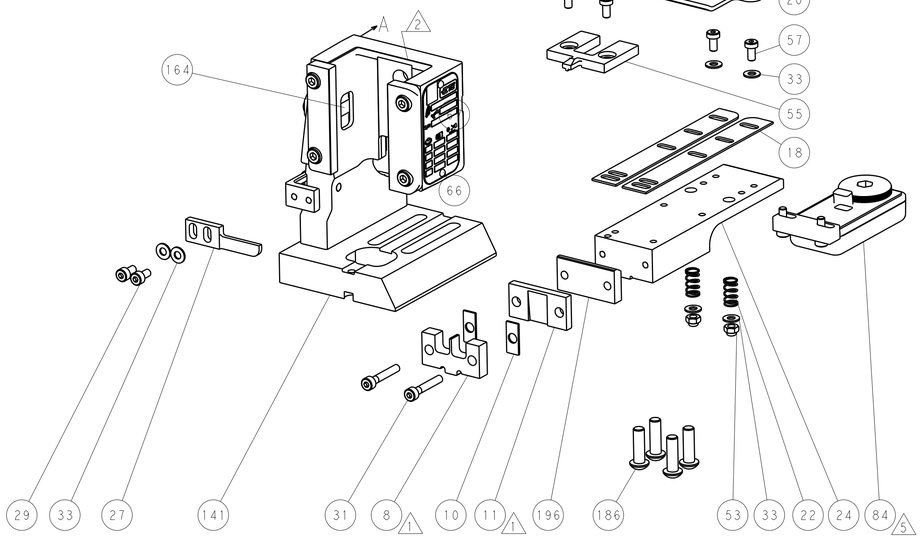
P	LTR	DESCRIPTION	DATE	DWN	APVD
	-	SEE SHEET 1	-	-	-



RAM SET-UP

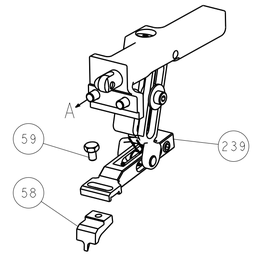




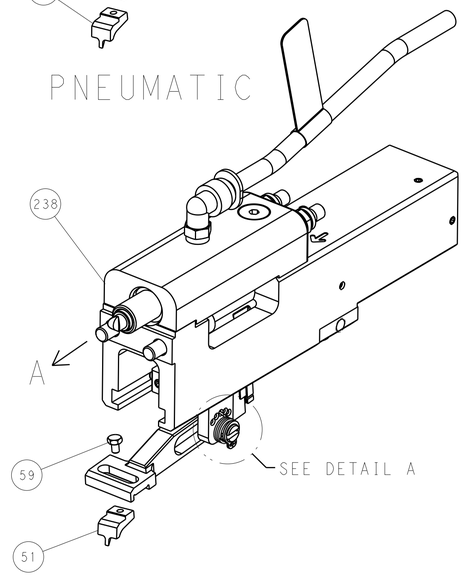


FEED TYPE

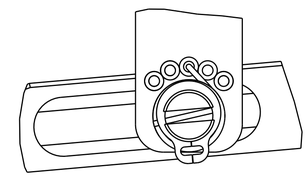
MECHANICAL



PNEUMATIC

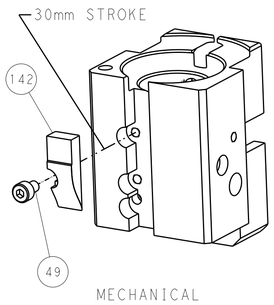


FEED SPRING
SETTING POSITION

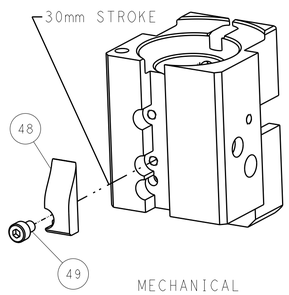


DETAIL A

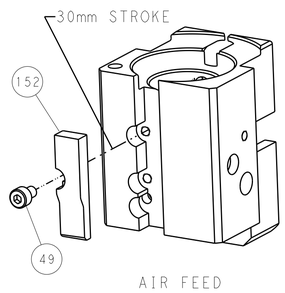
CAM POSITIONS



MECHANICAL
POST FEED



MECHANICAL
PRE FEED



AIR FEED

PACIFIC VERSION
Shown on sheets 3 of 4 & 4 of 4
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3 PLC ±-
4 PLC ±-
ANGLES ±-

MATERIAL -
FINISH -

DWN	M. HERR	20APR2017
CHK	T. ELBIN	20APR2017
APVD	T. ELBIN	20APR2017
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-2150799	-

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

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION