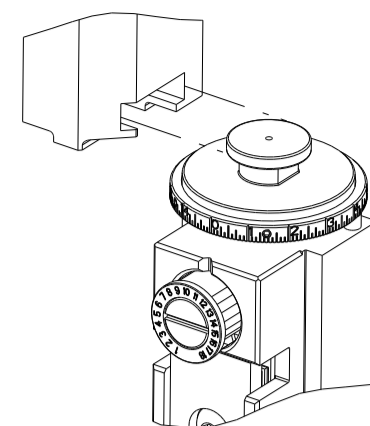


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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150869-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150869-2	B	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150869-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.29 mm [.090]	F
INSUL	3.94 mm [.155]	F
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: RING AMPLIVAR			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
5.46-6.22 mm [.215-.245 IN]		∅2.15-3.56 mm [.085-.140 IN]	
TERMINAL APPLICATION SPECIFICATION	114-2084		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
60319-2	60321-2		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
19 MAG	1.45+/-0.05 [.057+/-0.002]	7.5
20 MAG	1.40+/-0.05 [.055+/-0.002]	8.2
21 MAG	1.35+/-0.05 [.053+/-0.002]	9.1
23 MAG	1.22+/-0.05 [.048+/-0.002]	10.5



- 1. RECOMMENDED SPARE PARTS
- 2. REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- 3. APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 180. 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 PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- 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.

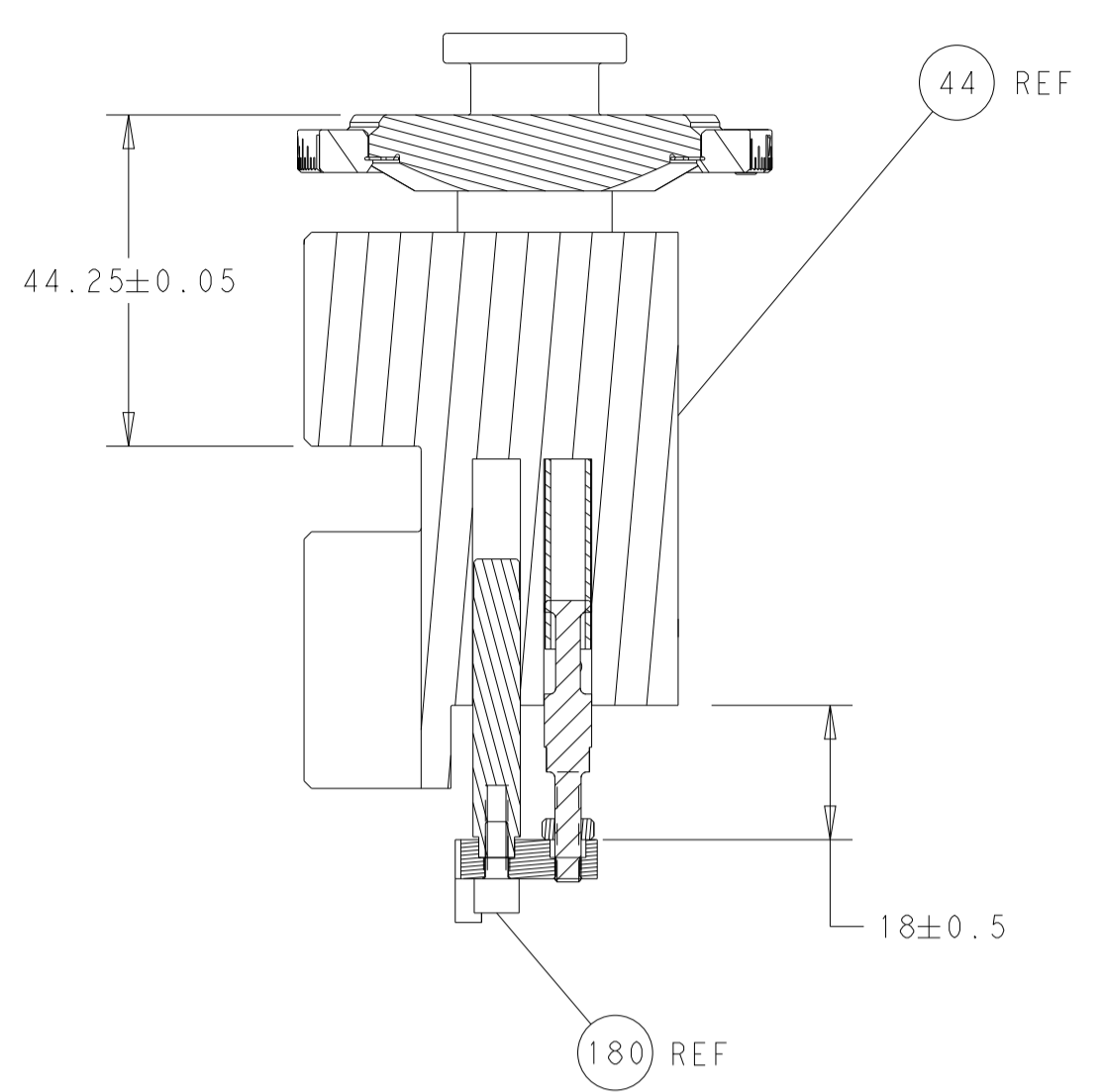
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

LOC	DIST	REVISIONS					
A	66	P	LTN	DESCRIPTION	DATE	OWN	APVD
		1		DEVELOPMENT	04JAN2018	MZ	KZ
		A		RELEASED	08FEB2018	JAH	GB
		B		ECR-22-136793	22APR2022	FZ	JAH

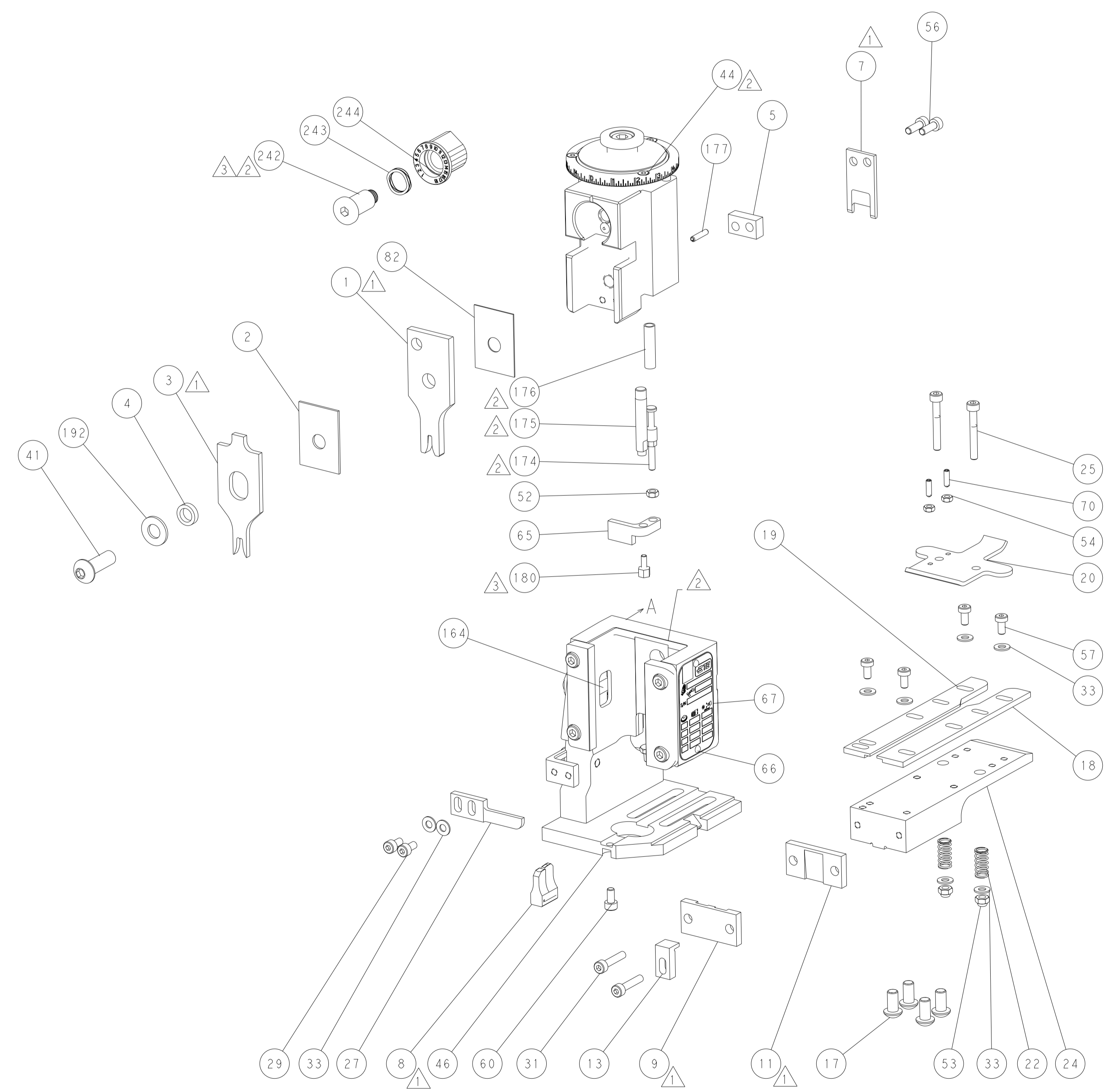
-	1	1	2119641-1	FEED CAM, AIR FEED	248
-	1	1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
3	-	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	1	2844940-3	AIR FEED MODULE	238
-	1	1	1-18028-0	WASHER, FLAT, REG M8	192
3	-	1	1752354-3	STANDOFF, HOLD-DOWN	180
-	1	1	6-993111-6	PIN, SLOTTED SPRING 3.0 X 14.0	177
-	1	1	8-22280-7	SPRING, COMPRESSION	176
-	1	1	1752353-2	GUIDE PIN, HOLDDOWN	175
-	1	1	1901680-2	GUIDE PIN, HOLDDOWN	174
-	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	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	1901681-1	HOLDDOWN, TERMINAL	65
-	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	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57
-	2	2	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	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	1	2063961-1	FEED FINGER	51
-	1	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	1	1	2119655-5	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
-	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	1752371-1	PLATE, STRIP GUIDE	24
-	2	2	2-22281-3	SPRING, COMPRESSION	22
-	1	1	1803292-4	DRAG	20
-	1	1	1-1901696-5	STRIP GUIDE, REAR	19
-	1	1	1-1901695-5	STRIP GUIDE, FRONT	18
-	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17
-	1	1	1752360-1	SPACER, HOLD-DOWN	13
1	-	1	240644-1	PLATE, REAR SHEAR	11
-	-	-	-	-	10
1	-	1	690482-5	PLATE, FRONT SHEAR	9
1	1	2	1-1803064-1	ANVIL, COMBINATION	8
1	-	1	2217206-7	BLADE, SLUG	7
-	-	-	-	-	6
-	1	1	2-240641-3	SPACER	5
-	1	1	238011-2	BLOCK, CRIMPER SPACER	4
1	1	2	3-2119582-6	CRIMPER, INSULATION F PREMIUM	3
-	1	1	1-455888-1	SPACER, CRIMPER	2
1	1	2	4-456406-2	CRIMPER, WIRE PREMIUM	1
-	77	72	-2	PART NO	ITEM NO

DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		OWN: M. ZHAO 04JAN2018		CHK: K. ZHANG 04JAN2018		APVD: K. ZHANG 04JAN2018		NAME: Ocean End Feed Applicator	
0 PLC ±		1 PLC ±		2 PLC ±		3 PLC ±		4 PLC ±		SIZE: A1	
ANGLES		FINISH		WEIGHT		SCALE: 1:1		SHEET: 1 of 4		REV: B	
MATERIAL		FINISH		WEIGHT		SCALE: 1:1		SHEET: 1 of 4		REV: B	

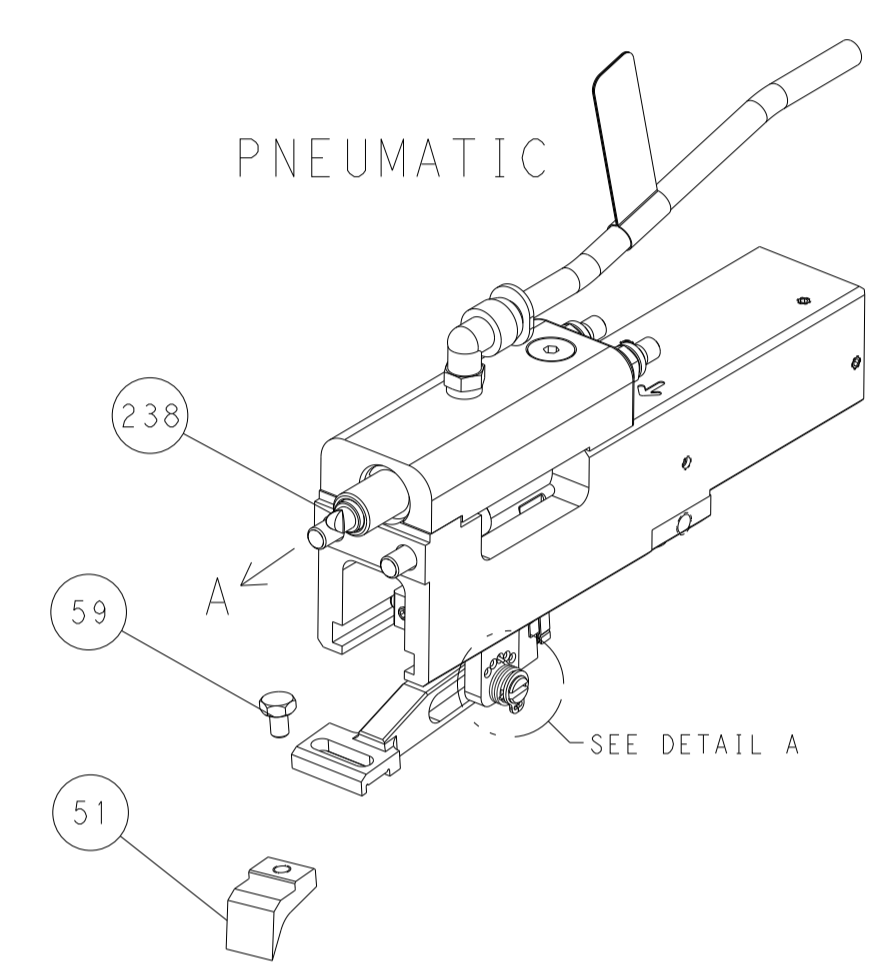
LOC	DIST	REVISIONS			
P	LTN	DESCRIPTION	DATE	OWN	APVD
A	66	SEE SHEET 1	-	-	-



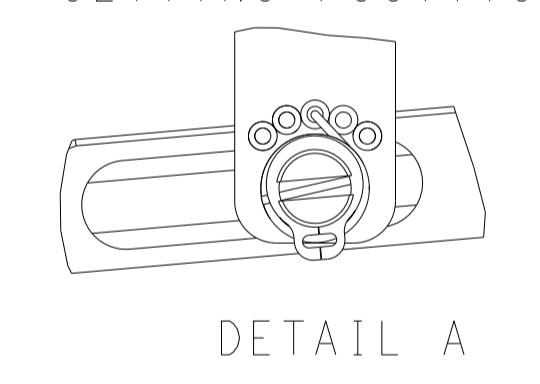
RAM AND HOLDDOWN SET-UP



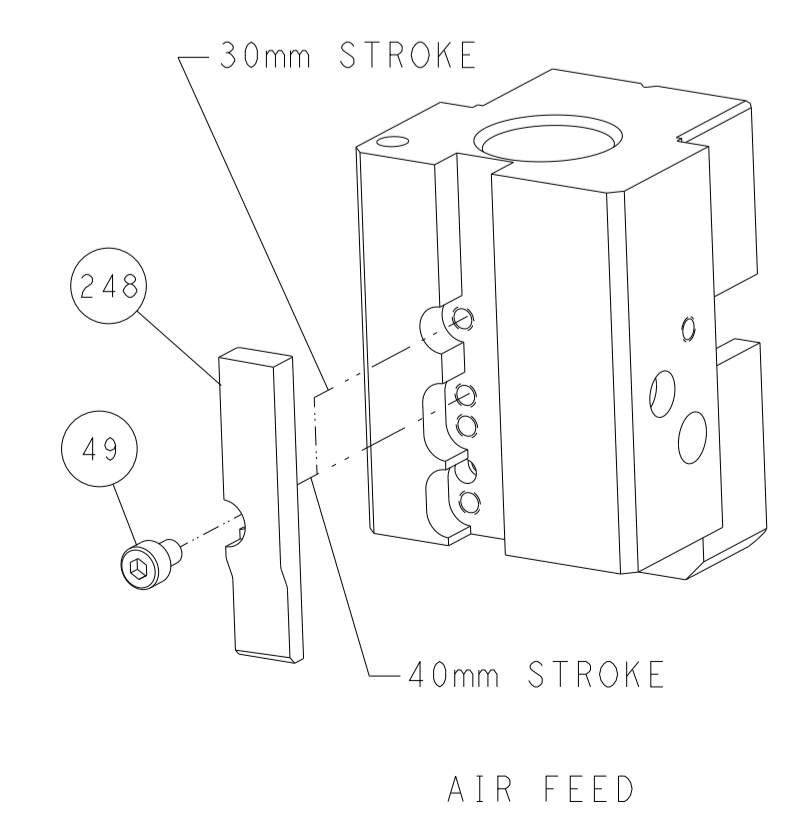
FEED TYPE



FEED SPRING SETTING POSITION



CAM POSITION



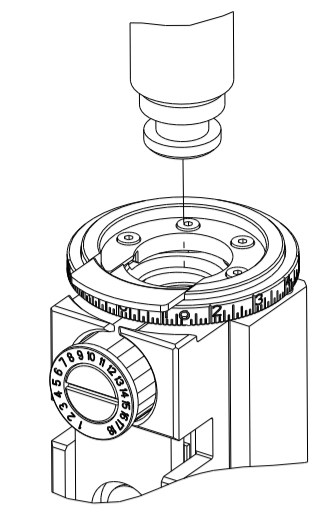
AIR FEED

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 ° ± FINISH		NAME Ocean End Feed Applicator PRODUCT SPEC APPLICATION SPEC SIZE A1 CAGE CODE 00779 DRAWING NO. C=2150869 WEIGHT SCALE 1:1 SHEET 2 OF 4 REV B	RESTRICTED TO
MATERIAL:		Customer Accessible Production Drawing	

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150869-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150869-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
 INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.29 mm (.090)	F
INSUL	3.94 mm (.155)	F
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: RING AMPLIVAR			
WIRE STRIP LENGTH 5.46-6.22 mm (.215-.245 IN)		INSULATION DIAMETER RANGE Ø2.15-3.56 mm (.085-.140 IN)	
TERMINAL APPLICATION SPECIFICATION	114-2084	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
60319-2	60321-2		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
19 MAG	1.45+/-0.05 [.057+/-0.002]	7.5
20 MAG	1.40+/-0.05 [.055+/-0.002]	8.2
21 MAG	1.35+/-0.05 [.053+/-0.002]	9.1
23 MAG	1.22+/-0.05 [.048+/-0.002]	10.5



- 1 RECOMMENDED SPARE PARTS
- 2 REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- 3 APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 180. 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 PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- 6. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.

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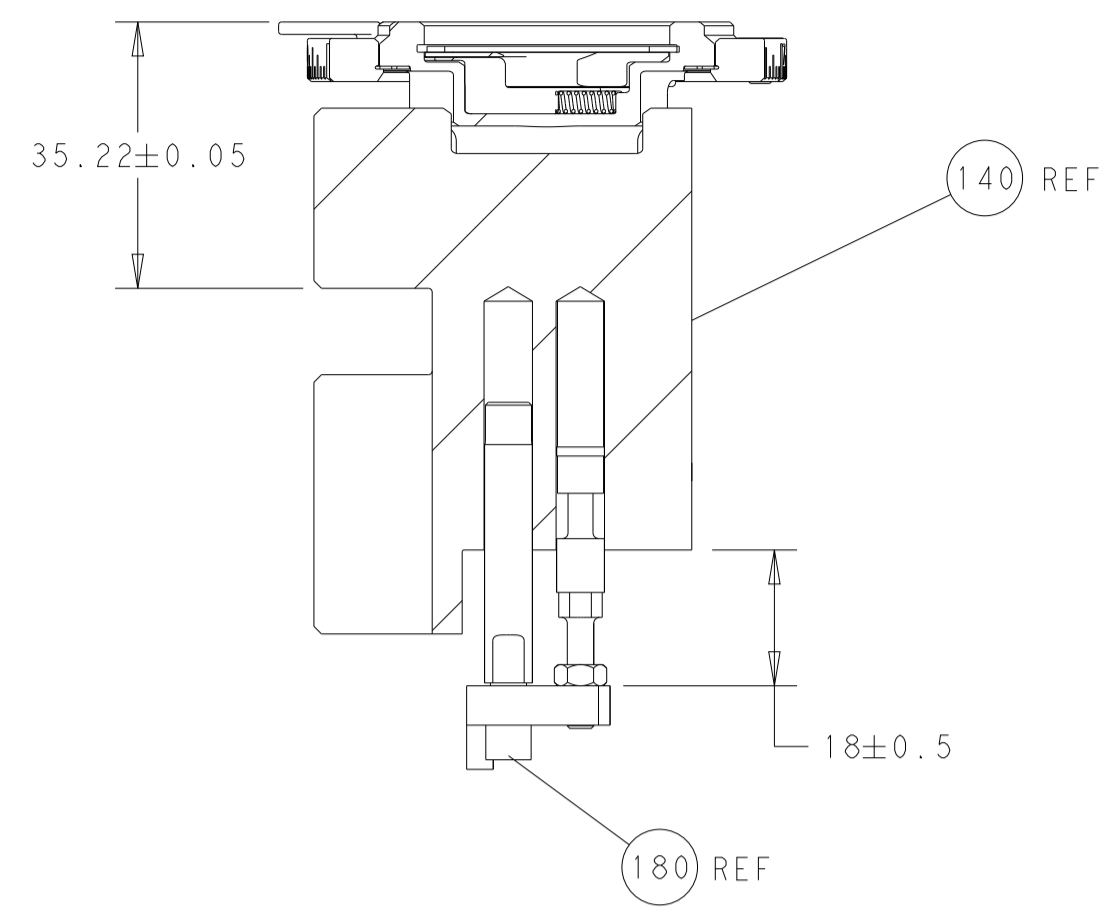
PACIFIC VERSION
 Shown on sheets 3 of 4 & 4 of 4
 (Atlantic version shown on sheets 1 of 4 & 2 of 4)

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

-	1	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	2844940-3	AIR FEED MODULE	238	
-	1	1-18028-0	WASHER, FLAT, REG M8	192	
-	4	2079383-9	SCR, BHSC, RoHS (M6 X 20)	186	
-	1	1752354-3	STANDOFF, HOLD-DOWN	180	
-	1	6-993111-6	PIN, SLOTTED SPRING 3.0 X 14.0	177	
-	1	8-22280-7	SPRING, COMPRESSION	176	
-	1	1752353-2	GUIDE PIN, HOLDDOWN	175	
-	1	1901680-2	GUIDE PIN, HOLDDOWN	174	
-	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	2119655-6	APPLICATOR BASIC ASSEMBLY, EF	141	
-	1	1803518-1	RAM ASSEMBLY, EF PACIFIC	140	
-	1	455888-5	SPACER, CRIMPER	82	
-	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	1901681-1	HOLDDOWN, TERMINAL	65	
-	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59	
-	4	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57	
-	2	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	56	
-	2	5018030-1	NUT, HEX, REG, RoHS, M3	54	
-	2	986965-8	NUT, LOCK, HEX, TORQUE (M4)	53	
-	1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52	
-	1	2063961-1	FEED FINGER	51	
-	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49	
-	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41	
-	8	1-18028-2	WASHER, FLAT, REG M4	33	
-	2	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	31	
-	2	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	29	
-	1	240639-1	STRIPPER (MACHINING)	27	
-	2	1-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 30	25	
-	1	1752371-1	PLATE, STRIP GUIDE	24	
-	2	2-22281-3	SPRING, COMPRESSION	22	
-	1	1803292-4	DRAG	20	
-	1	1-1901696-5	STRIP GUIDE, REAR	19	
-	1	1-1901695-5	STRIP GUIDE, FRONT	18	
-	1	1752360-1	SPACER, HOLD-DOWN	13	
-	1	240644-1	PLATE, REAR SHEAR	11	
-	-	-	-	10	
-	1	690482-5	PLATE, FRONT SHEAR	9	
-	1	1-1803064-1	ANVIL, COMBINATION	8	
-	1	2217206-7	BLADE, SLUG	7	
-	-	-	-	6	
-	1	2-240641-3	SPACER	5	
-	1	238011-2	BLOCK, CRIMPER SPACER	4	
-	1	3-2119582-6	CRIMPER, INSULATION F PREMIUM	3	
-	1	1-455888-1	SPACER, CRIMPER	2	
-	1	4-456406-2	CRIMPER, WIRE PREMIUM	1	
-	77	22	PART NO	DESCRIPTION	ITEM NO

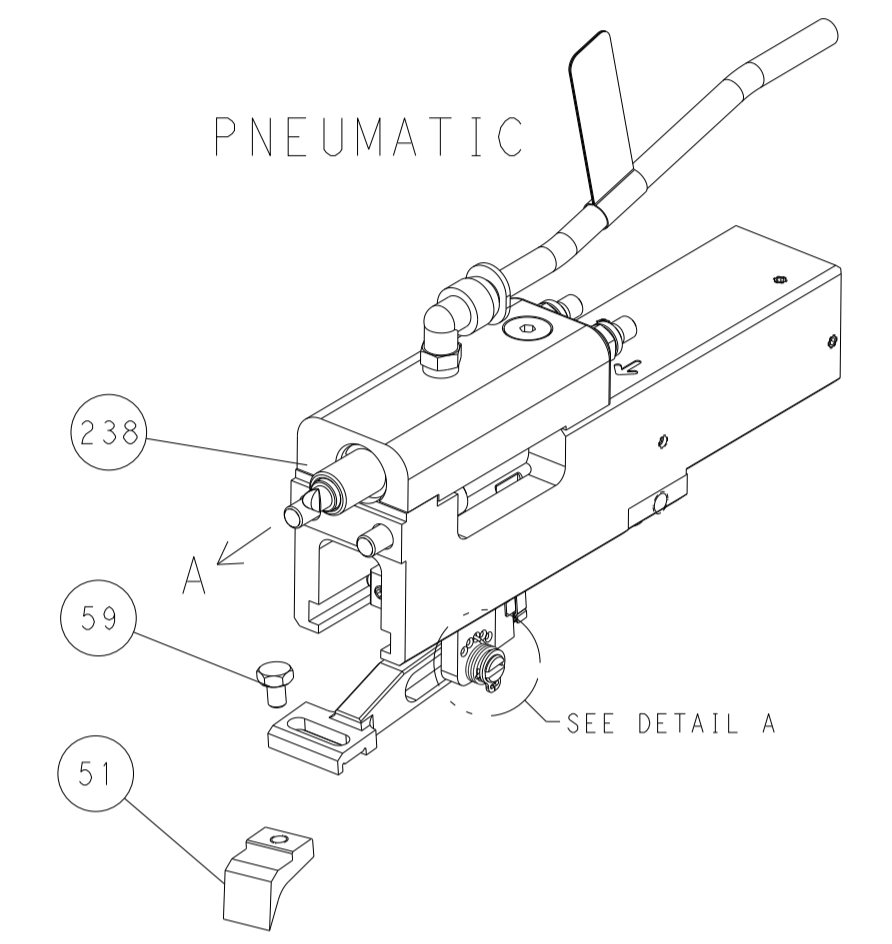
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		MATERIAL:		FINISH:		WEIGHT:		SCALE:	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES	FINISH	-	-	1:1	SHEET 3 OF 4
APVD: K. ZHANG		APVD: K. ZHANG		APVD: K. ZHANG		APVD: K. ZHANG		APVD: K. ZHANG		APVD: K. ZHANG	
DATE: 04JAN2018		DATE: 04JAN2018		DATE: 04JAN2018		DATE: 04JAN2018		DATE: 04JAN2018		DATE: 04JAN2018	
NAME: M. ZHAO		NAME: K. ZHANG		NAME: K. ZHANG		NAME: K. ZHANG		NAME: K. ZHANG		NAME: K. ZHANG	
CAGE CODE: 00779		CAGE CODE: 00779		CAGE CODE: 00779		CAGE CODE: 00779		CAGE CODE: 00779		CAGE CODE: 00779	
DRAWING NO: 2150869		DRAWING NO: 2150869		DRAWING NO: 2150869		DRAWING NO: 2150869		DRAWING NO: 2150869		DRAWING NO: 2150869	
RESTRICTED TO:		RESTRICTED TO:		RESTRICTED TO:		RESTRICTED TO:		RESTRICTED TO:		RESTRICTED TO:	

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

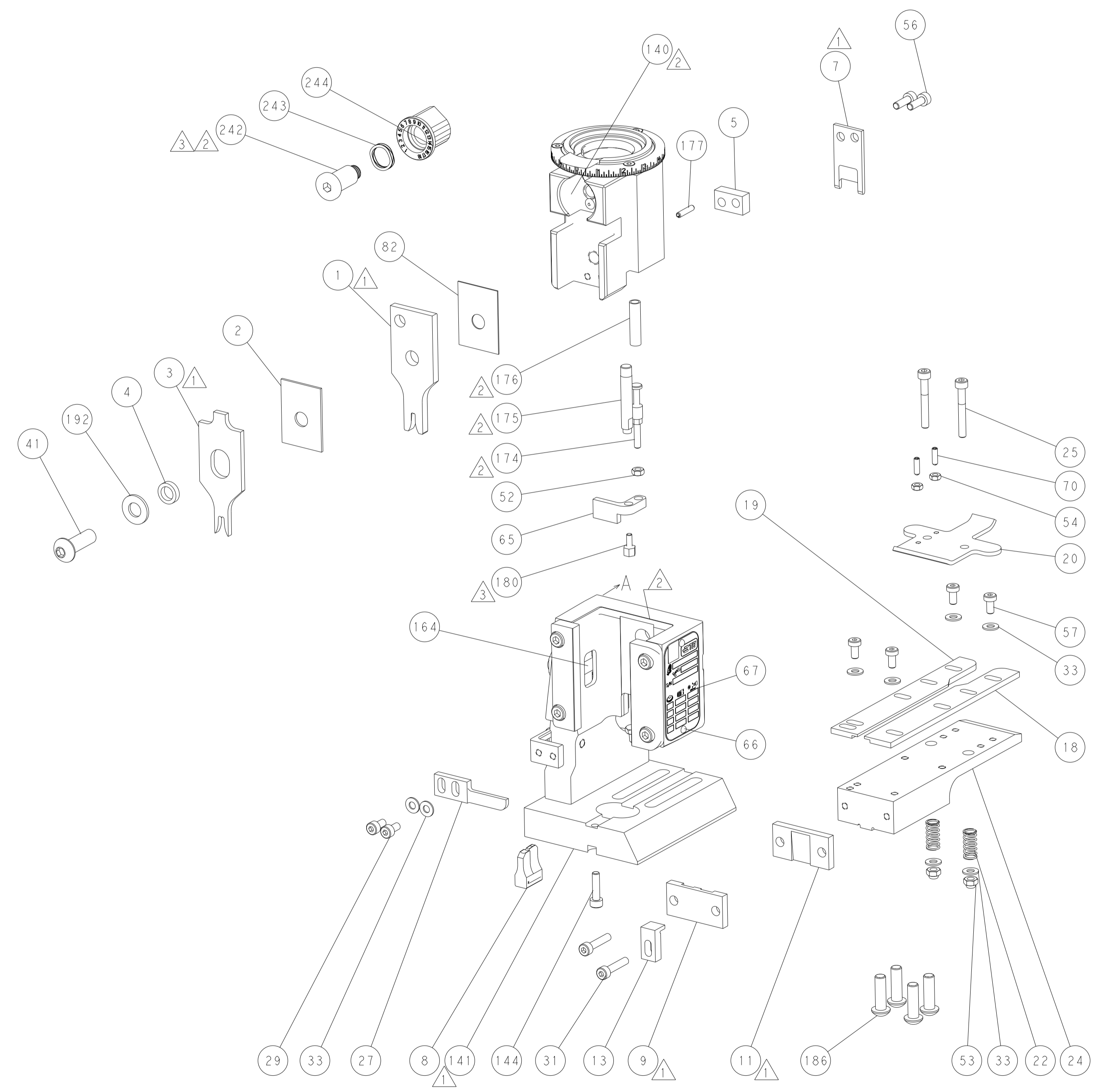
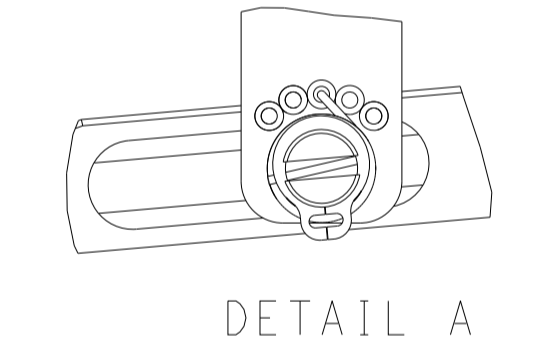


RAM AND HOLDDOWN SET-UP

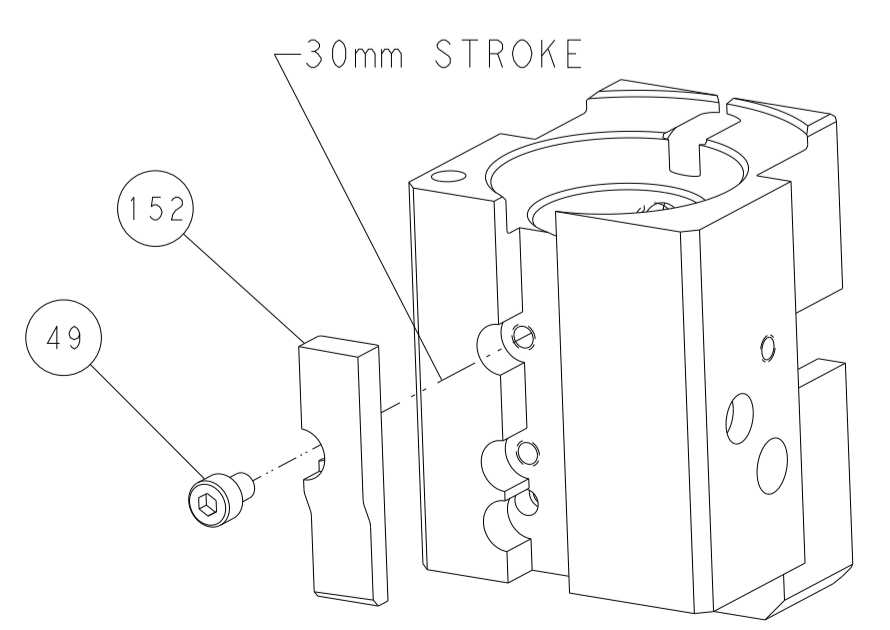
FEED TYPE



FEED SPRING SETTING POSITION



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)

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DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ° ± MATERIAL: - FINISH: -		NAME: Ocean End Feed Applicator APPLICATION SPEC: - PRODUCT SPEC: - SIZE: A CAGE CODE: 00779 DRAWING NO: C=2150869 WEIGHT: - SCALE: 1:1 SHEET: 4 OF 4 REV: B	RESTRICTED TO: -