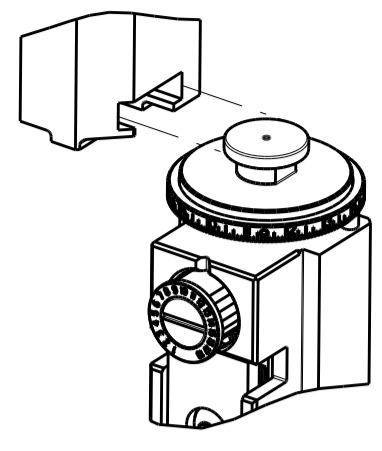


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150879-1	D	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2150879-2	E	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150879-1	D	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2150879-2	E	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150879-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.58 mm [.062]	F
INSUL	2.54 mm [.100]	F
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION			
TERMINAL NAME: RING TERMINAL			
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE		
3.86-4.06 mm [.152-.160 IN]	Ø1.22-1.98 mm [.048-.078 IN]		
TERMINAL APPLICATION SPECIFICATION	114-2084		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
60553-1	60445-2	60555-2	60501-1

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
20 AWG	1.17+/-0.05 [.046+/-0.002]	7.6
22 AWG	1.09+/-0.05 [.043+/-0.002]	8.3
24 AWG	1.04+/-0.05 [.041+/-0.002]	8.9

- 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. APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 180.
- 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 UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- 6 WHEN APPLIED TO TERMINALS 60553-1 & 60555-2, USED SPACER COMBINATION #5 & #16. FEED TRACKER (ITEM 24) NEED ADJUST AFTER CHANGED SPACER.
- 7 WHEN APPLIED TO TERMINALS 60445-2 & 60501-1, USED SPACER COMBINATION #5 & #15. FEED TRACKER (ITEM 24) NEED ADJUST AFTER CHANGED SPACER.

***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.

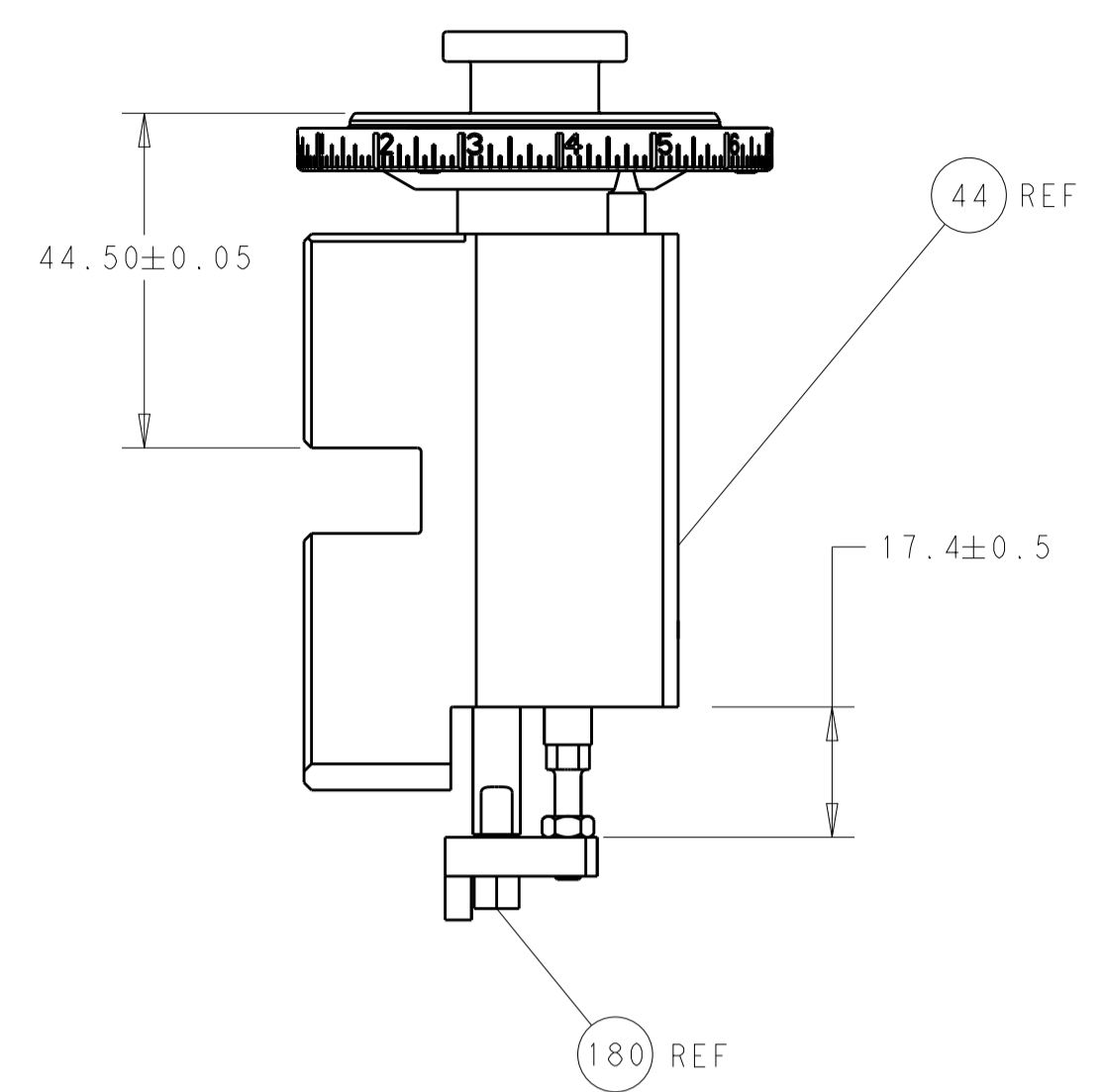
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

LOC	DIST	REVISIONS					
A	66	P	LTN	DESCRIPTION	DATE	DWN	APVD
		B		ECR-19-002475	14FEB2019	TB	CT
		C		ECR-19-003992	13MAR2019	FZ	YY
		D		ECR-19-014756	23SEP2019	MZ	YY
		E		ECR-20-017633	14DEC2020	FZ	TE

-	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	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		
3	-	1	1	1	1752354-2	STANDOFF, HOLD-DOWN	180		
-	1	1	1	1	6-993111-6	PIN, SLOTTED SPRING 3.0 X 14.0	177		
-	1	1	1	1	8-22280-7	SPRING, COMPRESSION	176		
-	1	1	1	1	1752353-2	GUIDE PIN, HOLDDOWN	175		
-	1	1	1	1	1901680-2	GUIDE PIN, HOLDDOWN	174		
-	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164		
-	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	1901681-5	HOLDDOWN, TERMINAL	65		
-	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		
-	-	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	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	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		
-	1	1	1	1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52		
-	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	1803292-4	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		
6	-	1	1	1	6-240641-4	SPACER	16		
7	-	1	1	1	3-240641-4	SPACER	15		
-	1	1	1	1	1752360-1	SPACER, HOLD-DOWN	13		
1	-	1	1	1	240644-1	PLATE, REAR SHEAR	11		
-	-	-	-	-	-	-	10		
1	-	1	1	1	690482-4	PLATE, FRONT SHEAR	9		
1	1	2	2	1	1	4-1803257-3	ANVIL, COMBINATION, END FEED	8	
1	-	1	1	1	1	1-2217206-1	BLADE, SLUG	7	
-	-	-	-	-	-	-	6		
6	-	1	1	1	1	1-240641-6	SPACER	5	
-	1	1	1	1	1	1-238011-0	BLOCK, CRIMPER SPACER	4	
1	1	2	2	1	1	1-1803187-6	CRIMPER, INSULATION F	3	
-	1	1	1	1	1	455888-4	SPACER, CRIMPER	2	
1	1	2	2	1	1	1-456403-5	CRIMPER, WIRE PREMIUM	1	
-	77	72	71	2	-	1	PART NO	DESCRIPTION	ITEM NO

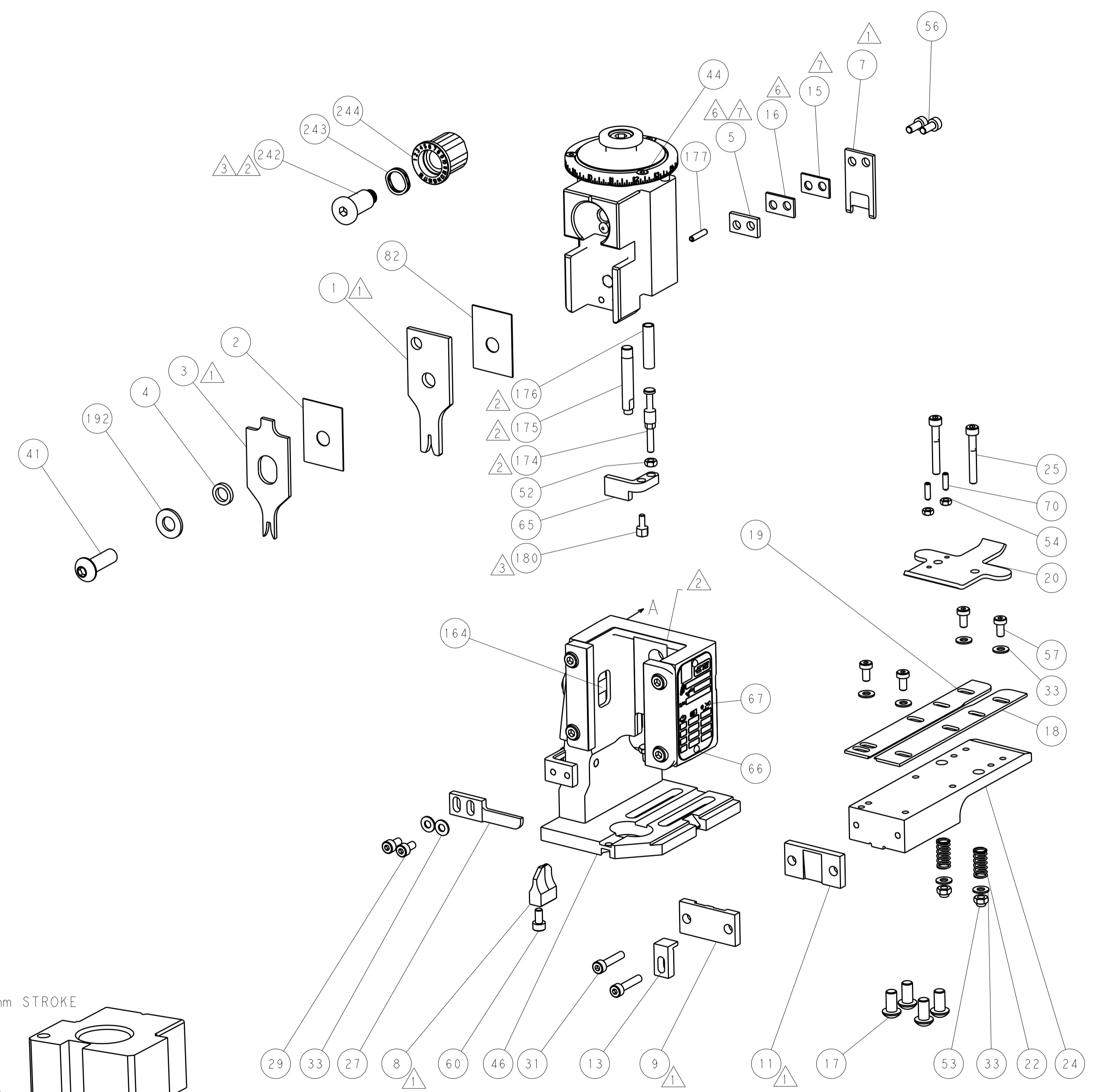
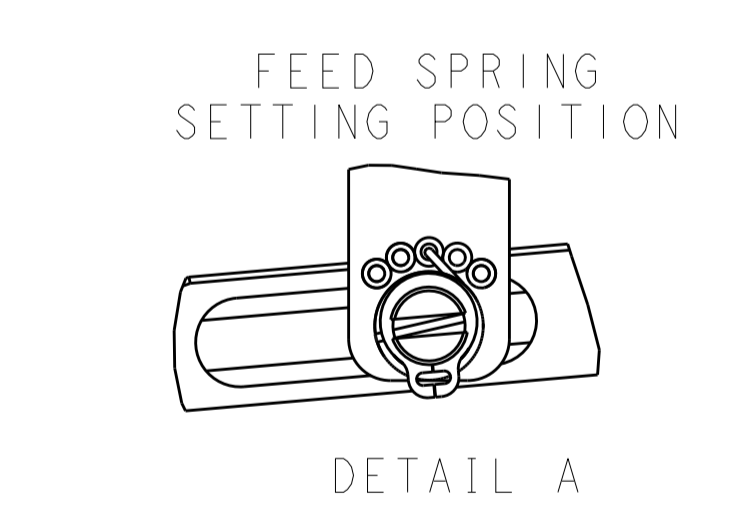
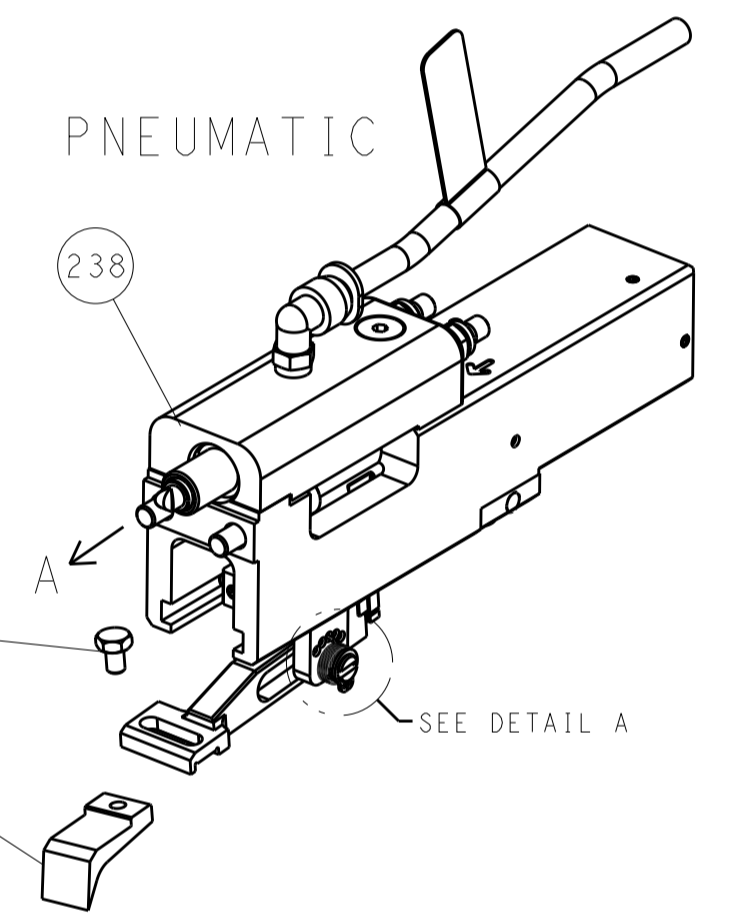
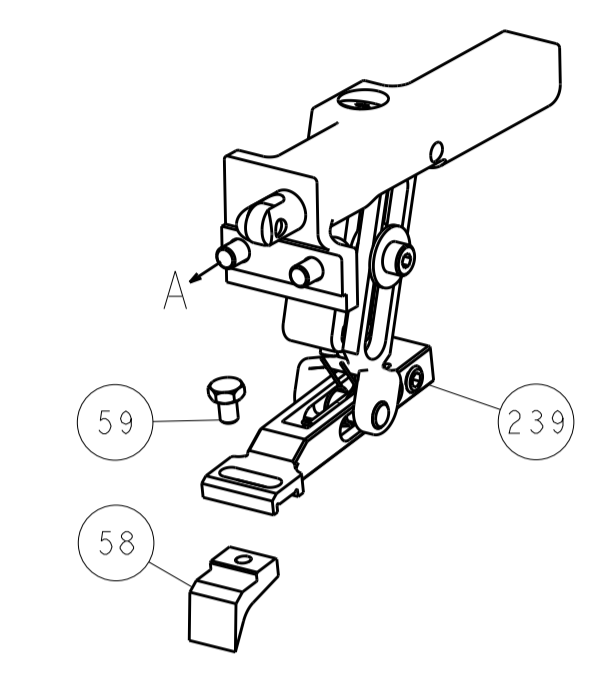
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG		CHK		APVD		NAME	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES ±	FINISH ±	DATE	29JAN2018	DATE	29JAN2018
								NAME	F. ZHANG	DATE	29JAN2018
								NAME	K. ZHANG	DATE	29JAN2018
								NAME	K. ZHANG	DATE	29JAN2018
								PRODUCT SPEC			
								APPLICATION SPEC			
								SIZE	A1	CAGE CODE	00779
								DRAWING NO	C=2150879		
								RESTRICTED TO			
								WEIGHT			
								Customer Accessible Production Drawing	SCALE	1:1	SHEET 1 OF 4
								REV	E		

LOC	DIST	REV	DATE	BY	APPV
A	66				
REVISIONS			DESCRIPTION	DATE	BY
			SEE SHEET 1		

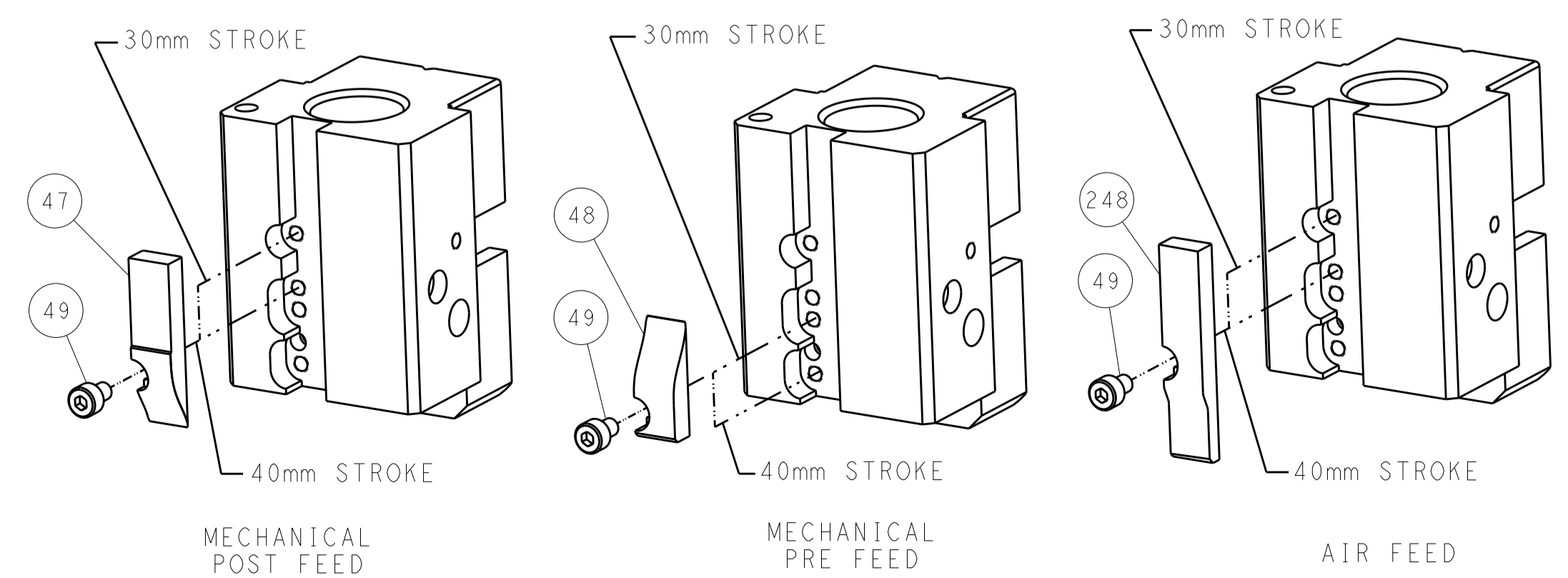


RAM AND HOLDDOWN SET-UP

FEED TYPE
MECHANICAL



CAM POSITIONS

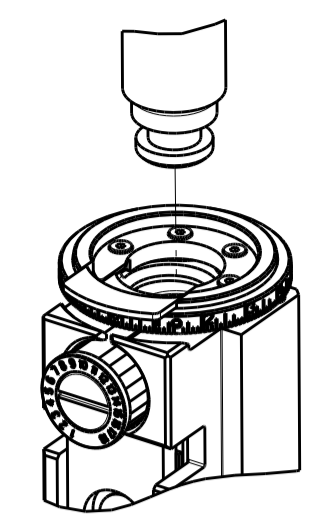


ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		OWN: F. ZHANG 29JAN2018		TE Connectivity	
mm		0 PLC ±		CHK: K. ZHANG 29JAN2018		Harrisburg, PA 17105-3608	
Ø		1 PLC ±		APVD: K. ZHANG 29JAN2018		NAME: Ocean End Feed Applicator	
H		2 PLC ±		PRODUCT SPEC		SIZE: CAGE CODE DRAWING NO	
D		3 PLC ±		APPLICATION SPEC		RESTRICTED TO	
R		4 PLC ±		WEIGHT		A1 00779 ©=2150879	
ANGLES		FINISH		Customer Accessible Production Drawing		SCALE: 1:1 SHEET 2 OF 4 REV E	

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150879-1	D	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2150879-2	E	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150879-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.58 mm [.062]	F
INSUL	2.54 mm [.100]	F
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: RING TERMINAL			
WIRE STRIP LENGTH 3.86-4.06 mm [.152-.160 IN]		INSULATION DIAMETER RANGE Ø1.22-1.98 mm [.048-.078 IN]	
TERMINAL APPLICATION SPECIFICATION 114-2084			
TERMINALS APPLIED			
TE TERMINAL 60553-1	TE TERMINAL 60445-2	TE TERMINAL 60555-2	TE TERMINAL 60501-1

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
20 AWG	1.17+/-0.05 [.046+/-0.002]	7.6
22 AWG	1.09+/-0.05 [.043+/-0.002]	8.3
24 AWG	1.04+/-0.05 [.041+/-0.002]	8.9



- △ 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. APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 180.
- △ 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.
- △ WHEN APPLIED TO TERMINALS 60553-1 & 60555-2, USED SPACER COMBINATION #5 & #16. FEED TRACKER (ITEM 24) NEED ADJUST AFTER CHANGED SPACER.
- △ WHEN APPLIED TO TERMINALS 60445-2 & 60501-1, USED SPACER COMBINATION #5 & #15. FEED TRACKER (ITEM 24) NEED ADJUST AFTER CHANGED SPACER.

***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.

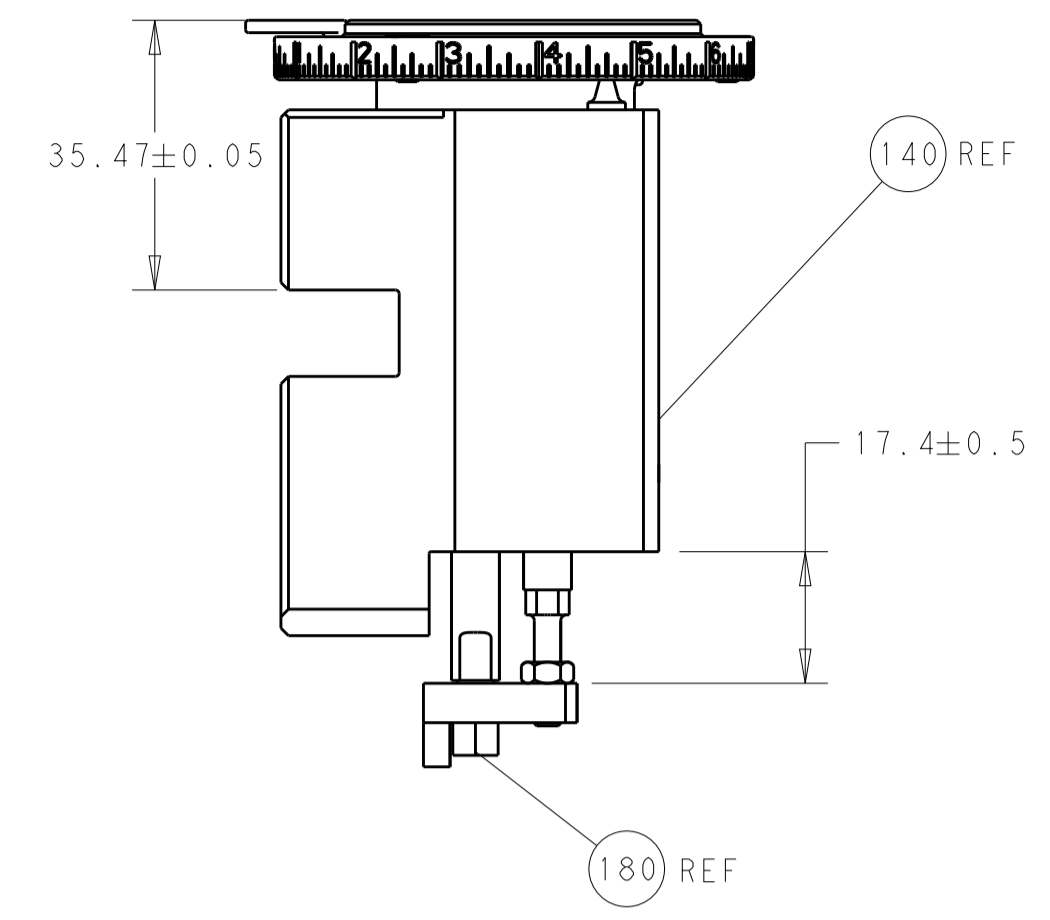
PACIFIC VERSION
Shown on sheets 3 of 4 & 4 of 4
(Atlantic version shown on sheets 1 of 4 & 2 of 4)

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

△	-	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	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
	-	1	1	1752354-2	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	-	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
	-	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	1901681-5	HOLDDOWN, TERMINAL	65
	-	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
	-	-	1	2063961-1	FEED FINGER	58
	-	4	4	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57
	-	2	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	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	-	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	1803292-4	DRAG	20
	-	1	1	1901696-2	STRIP GUIDE, REAR	19
	-	1	1	1901695-2	STRIP GUIDE, FRONT	18
△	-	1	1	6-240641-4	SPACER	16
△	-	1	1	3-240641-4	SPACER	15
△	-	1	1	1752360-1	SPACER, HOLD-DOWN	13
△	-	1	1	240644-1	PLATE, REAR SHEAR	11
	-	-	-	-	-	10
△	-	1	1	690482-4	PLATE, FRONT SHEAR	9
△	1	1	1	4-1803257-3	ANVIL, COMBINATION, END FEED	8
△	-	1	1	1-2217206-1	BLADE, SLUG	7
	-	-	-	-	-	6
△	7	△	6	1-240641-6	SPACER	5
	-	1	1	1-238011-0	BLOCK, CRIMPER SPACER	4
△	1	1	1	1-1803187-6	CRIMPER, INSULATION F	3
	-	1	1	455888-4	SPACER, CRIMPER	2
△	1	1	1	1-456403-5	CRIMPER, WIRE PREMIUM	1
	-	77	22	21	PART NO	ITEM NO

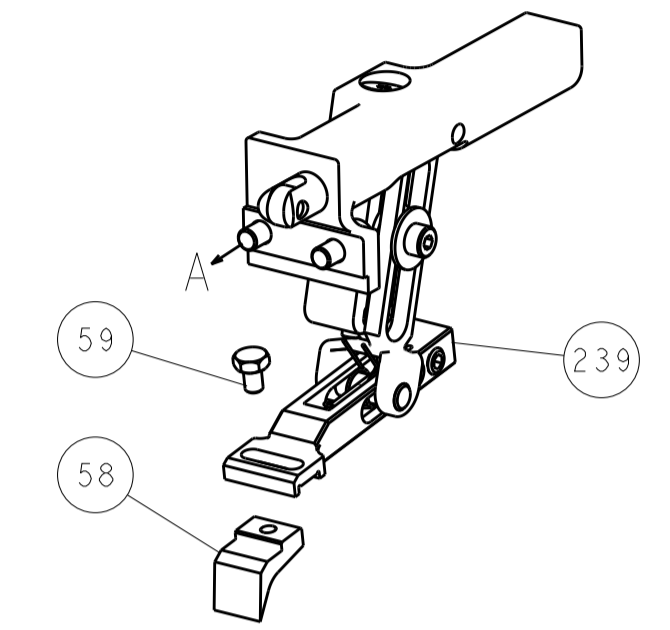
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0 PLC ±		1 PLC ±		2 PLC ±		3 PLC ±		4 PLC ±		SIZE: A	
MATERIAL: -		FINISH: -		WEIGHT: -		SCALE: 1:1		SHEET: 3 OF 4		REV: E	

LOC	DIST	REV	DATE	BY	APPV
A	66				
REVISIONS			DESCRIPTION	DATE	BY
-			SEE SHEET 1	-	-

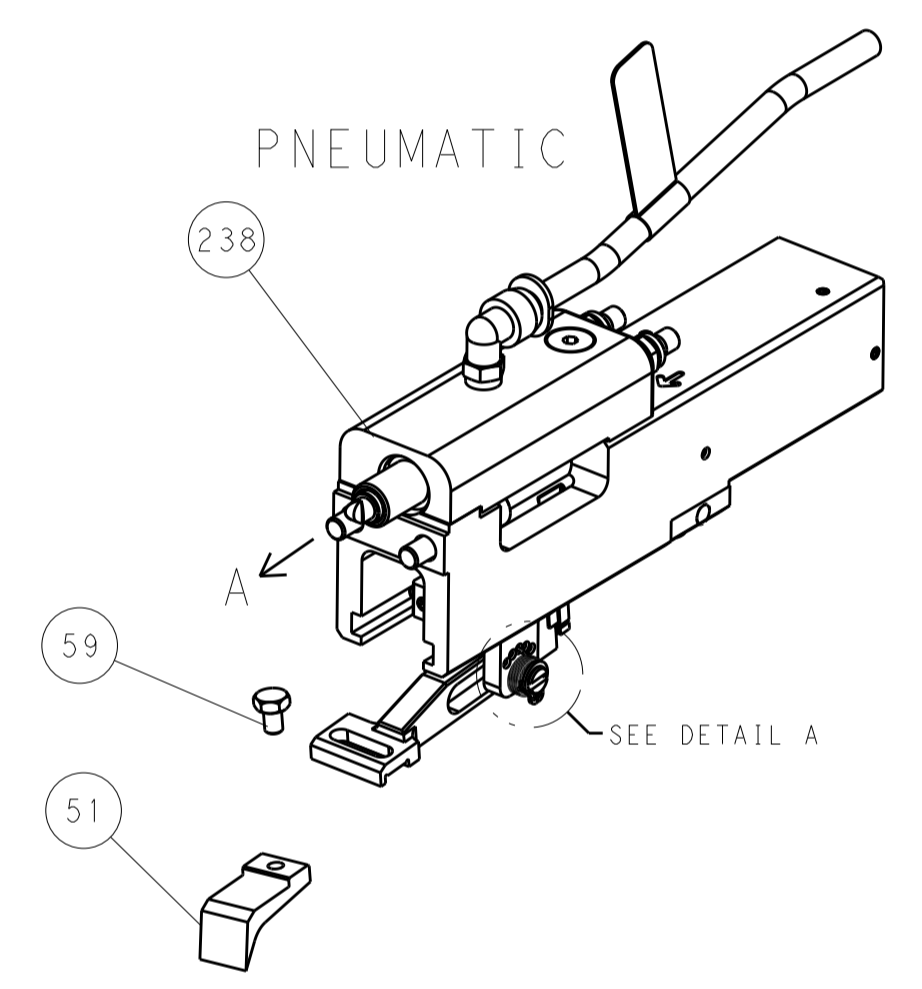


RAM AND HOLDDOWN SET-UP

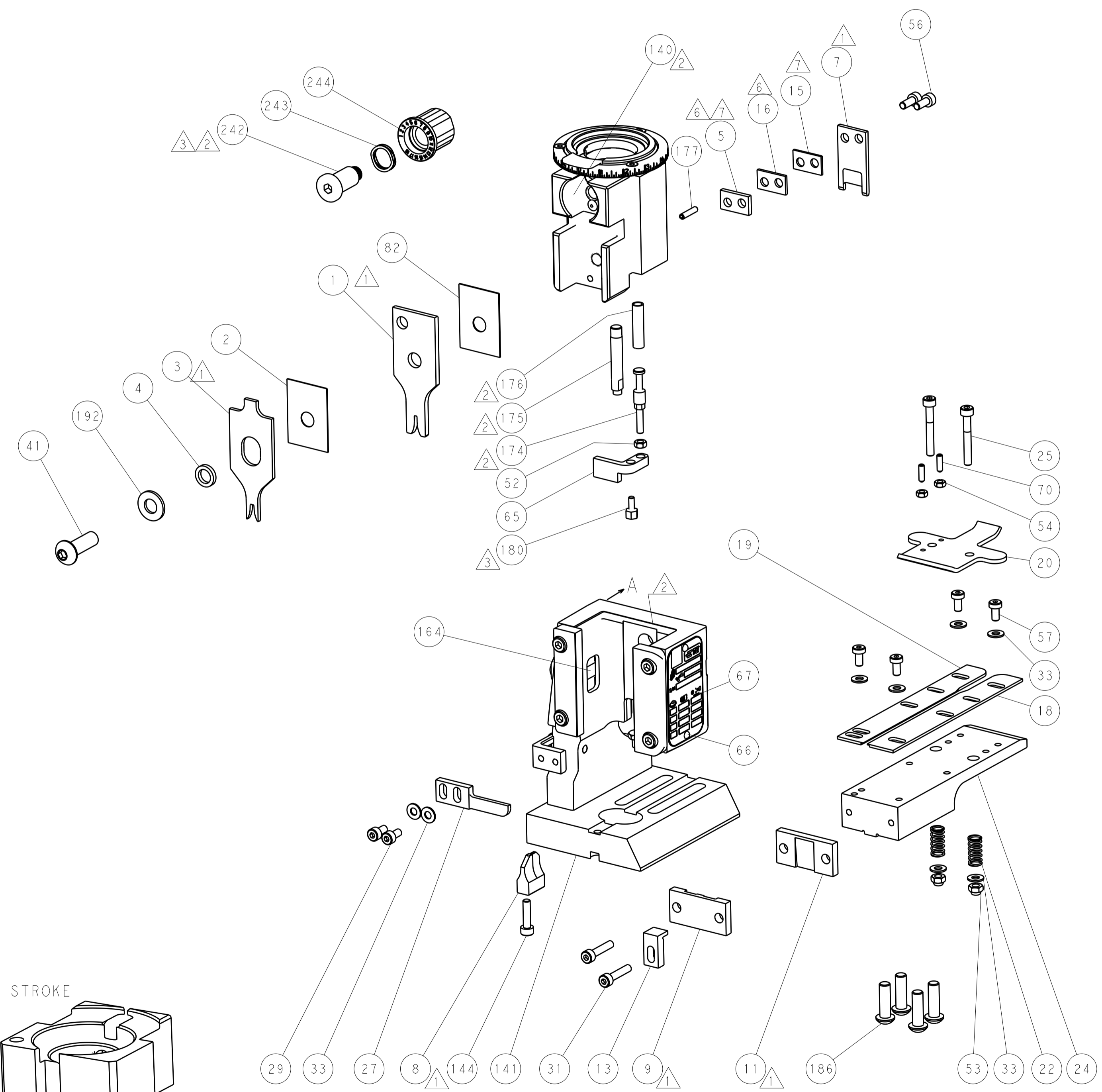
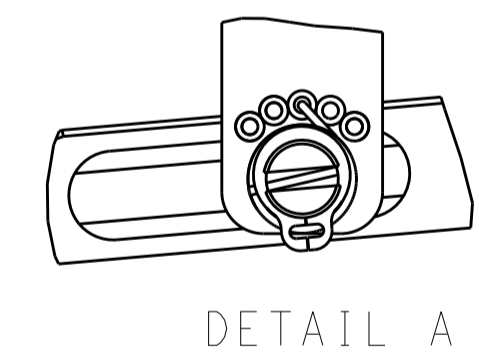
FEED TYPE
MECHANICAL



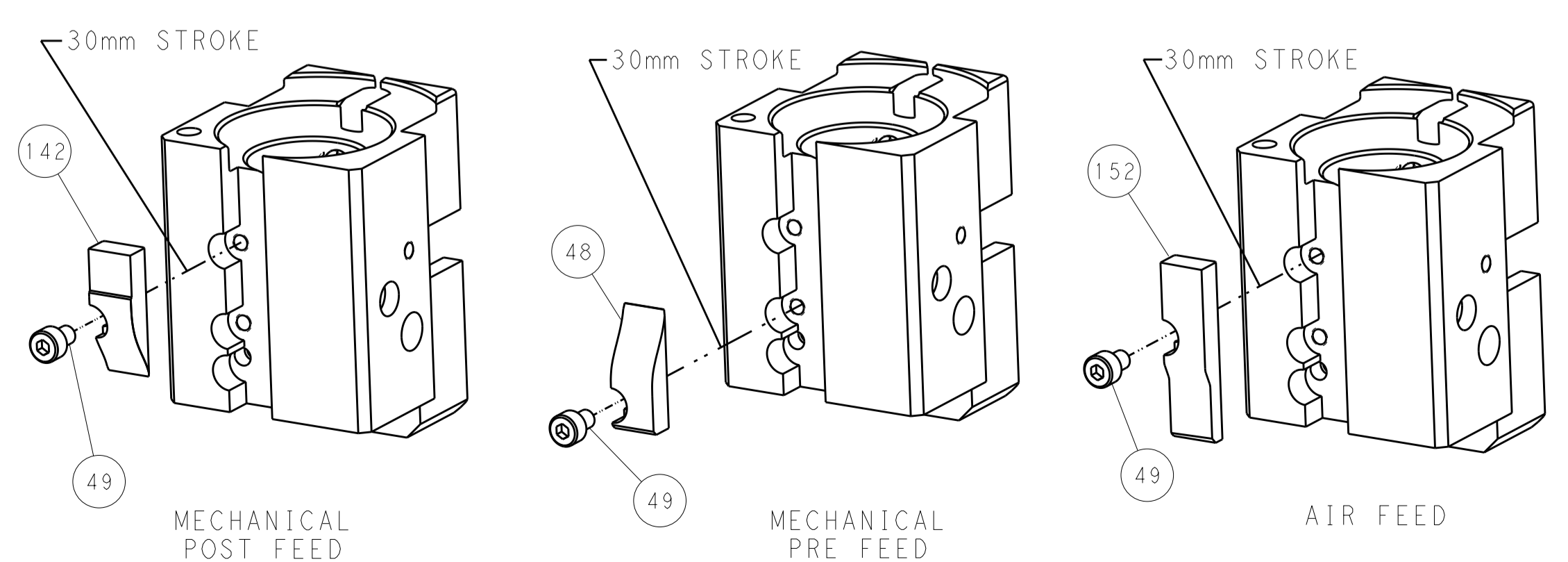
PNEUMATIC



FEED SPRING
SETTING POSITION



CAM POSITIONS



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

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN F. ZHANG 29JAN2018 CHK K. ZHANG 29JAN2018 APVD K. ZHANG 29JAN2018		TE Connectivity Harrisburg, PA 17105-3608	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	NAME Ocean End Feed Applicator	
MATERIAL		FINISH		WEIGHT		SIZE CAGE CODE DRAWING NO. RESTRICTED TO	
				A 00779 ©=2150879		Customer Accessible Production Drawing SCALE 1:1 SHEET 4 OF 4 REV E	