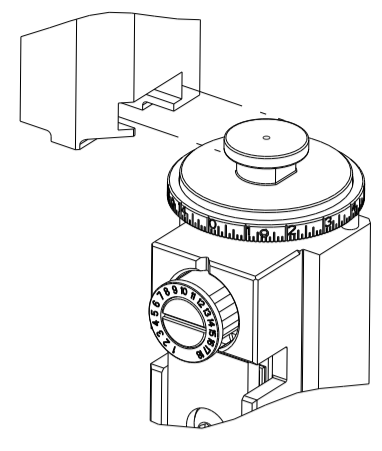


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150890-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2150890-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150890-1	C	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2150890-2	C	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150890-7	B	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.52 mm [.060]	Ø
INSUL	-	-
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: HS UNITED EUROPEAN TERMINAL TE CRIMP SPECIFICATION			
TERMINAL NAME: CLAW TERMINAL			
WIRE STRIP LENGTH 6.60-7.40 mm [.260-.291 IN]		INSULATION DIAMETER RANGE Ø	
TERMINAL APPLICATION SPECIFICATION	NONE	-	-
TERMINALS APPLIED			
TE TERMINAL	HS UNITED EUROPEAN TERMINAL	TE TERMINAL	HS UNITED EUROPEAN TERMINAL
3311095-1	21.010.110	3311095-3	21.010.310
3311095-2	21.010.120	3311095-4	21.010.320

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.00mm2	1.55+/-0.025 [.061+/- .001]	3.3
0.75mm2	1.50+/-0.025 [.059+/- .001]	4.0
0.50mm2	1.40+/-0.025 [.055+/- .001]	4.8



- RECOMMENDED SPARE PARTS
- REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- 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.
- THE RECOMMENDED SET-UP FOR END FEED APPLICATORS IS POST-FEED WITH ITEM 2119653-1. THE APPLICATOR CAN BE CONFIGURED FOR PRE-FEED WITH ITEM 2119652-1 BUT MAY ENCOUNTER PROBLEMS WITH SOME APPLICATIONS. FEED ISSUES OR TERMINAL JAMMING MAY OCCUR IN THE PRE-FEED CONFIGURATION.
- 5. 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.

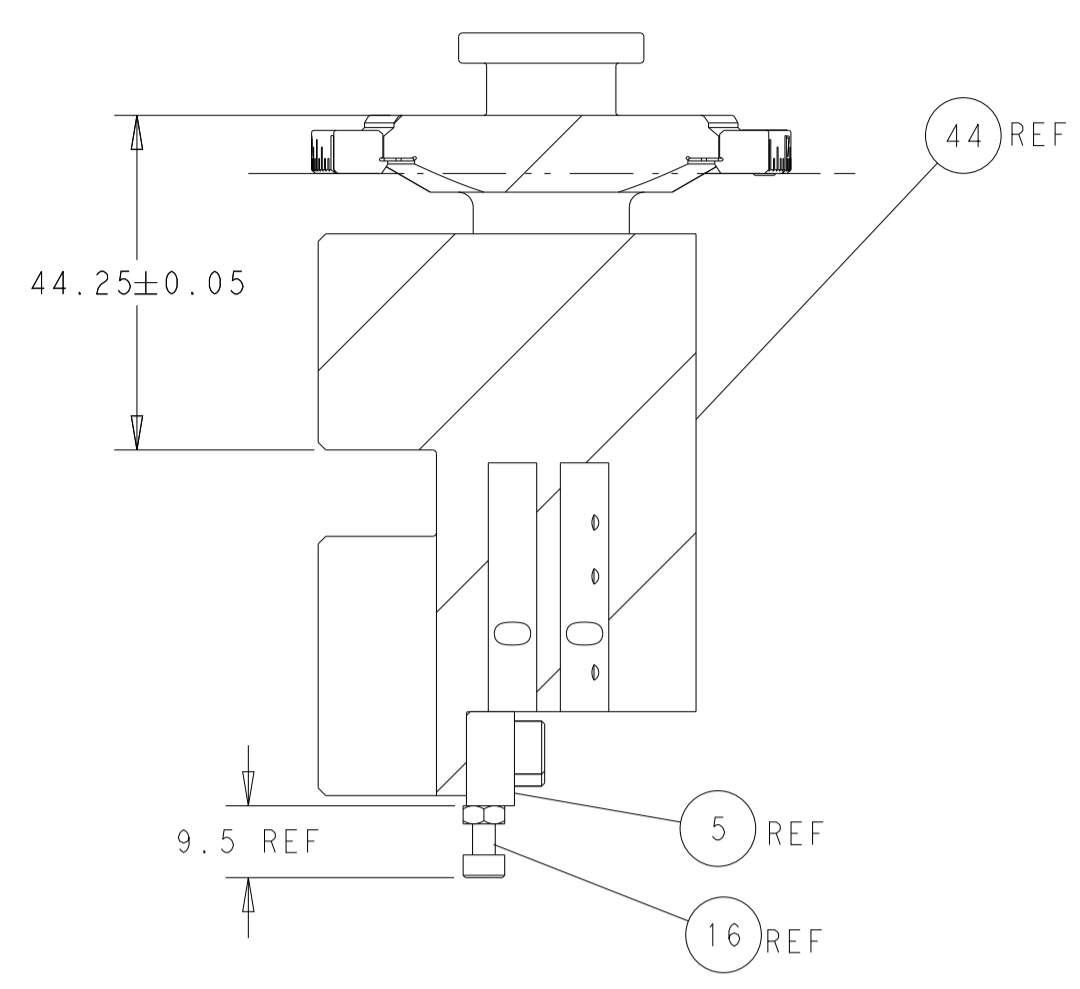
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

LOC	DIST	REVISIONS					
A	66	P	LTN	DESCRIPTION	DATE	DWN	APVD
		1		PRELIMINARY	19MAR2018	CT	GB
		A		RELEASE	02MAY2018	AW	CT
		B		ECR-21-006515	28JUN2021	FJ	RK
		C		ECR-23-187417	19SEP2023	FZ	JAH

-	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	1803970-1	FLOATING SHEAR HOLDER	206	
-	2	2	2	2	1-2168083-1	SCR, SKT HD CAP, RoHS, M3 X 6	191	
-	2	2	2	2	2-22280-0	SPRING, COMPRESSION	180	
-	2	2	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	178	
-	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164	
-	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	3-18032-3	SCR, SET, FLT PNT, M3 X 20.0	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	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	-	2063961-1	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	2-2119655-5	APPLICATOR BASIC ASSEMBLY, EF	46	
-	1	1	1	1	1803517-1	RAM ASSEMBLY, EF ATLANTIC	44	
-	1	1	1	1	2079383-7	SCR, BHSC, RoHS (M8 X 25)	41	
-	7	7	7	7	1-18028-2	WASHER, FLAT, REG M4	33	
-	2	2	2	2	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	31	
-	2	2	2	2	1-2168083-6	SCR, SKT HD CAP, RoHS, M4 X 35	25	
-	1	1	1	1	1803162-1	PLATE, STRIP GUIDE	24	
-	2	2	2	2	22281-8	SPRING, COMPRESSION	22	
-	1	1	1	1	1633168-1	ARM, STOCK DRAG	21	
-	1	1	1	1	1-464452-6	DRAG, STOCK	20	
-	2	2	2	2	1803971-1	GUIDE, LOWER STRIP	18	
-	4	4	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17	
-	1	1	1	1	1-2168083-3	SCR, SKT HD CAP, RoHS, M3 X 16	16	
-	1	1	1	1	5018030-1	NUT, HEX, REG, RoHS, M3	15	
-	1	1	1	1	1-356885-6	STOP, SHEAR	11	
-	-	-	-	-	-	-	10	
-	-	-	-	-	-	-	9	
	1	2	2	1	1	1-1213862-2	ANVIL, SPLICE TYPE	8
	-	1	1	1	1	1803714-1	SHEAR BLADE	7
-	-	-	-	-	-	-	6	
-	1	1	1	1	1	690753-6	SPACER, TONKER	5
-	-	-	-	-	-	-	4	
-	-	-	-	-	-	-	3	
-	-	-	-	-	-	-	2	
	1	2	2	1	1	5-1633723-7	CRIMPER, WIRE 0 -	1
-77-72-71-2-1					PART NO	DESCRIPTION	ITEM NO	

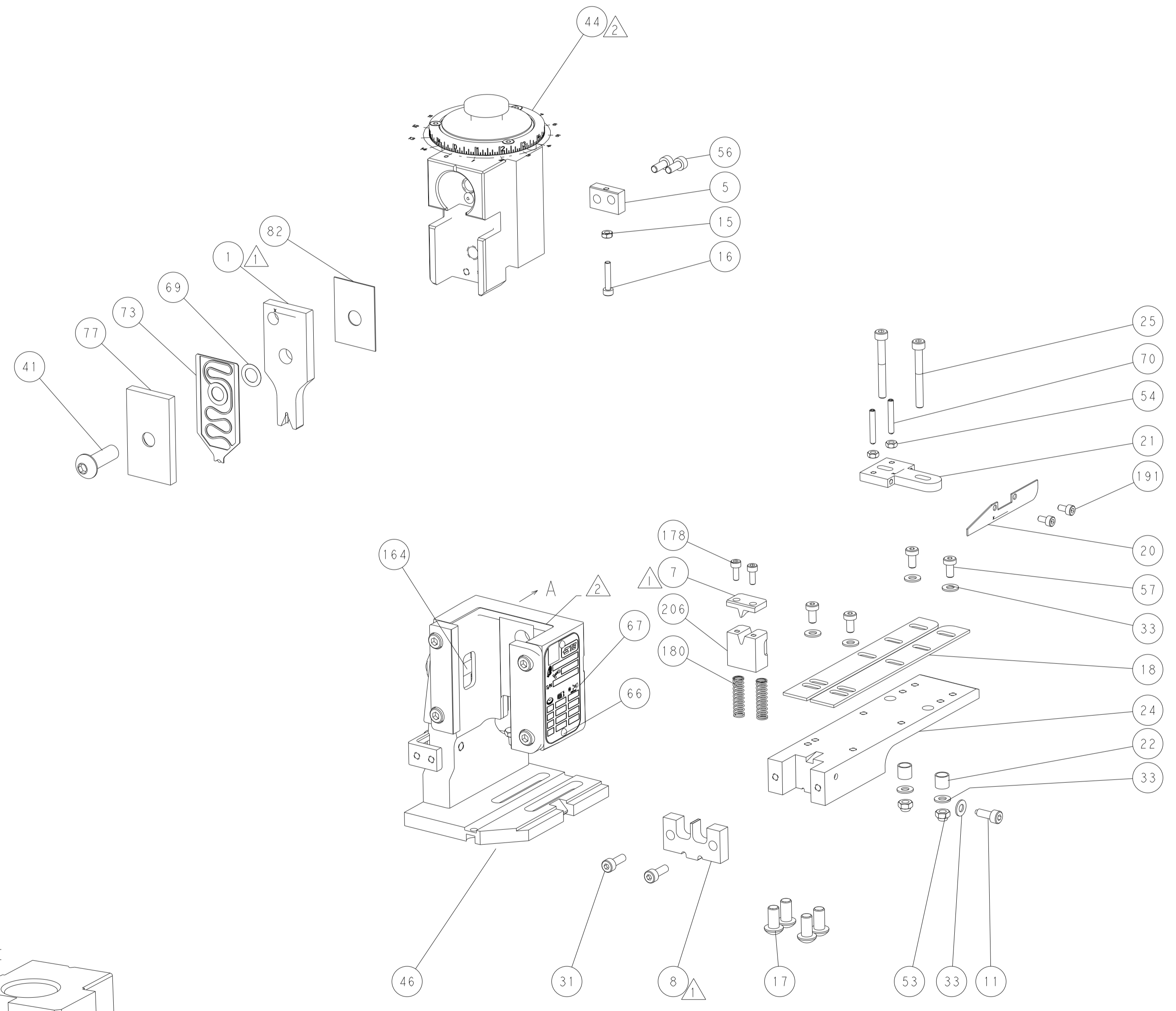
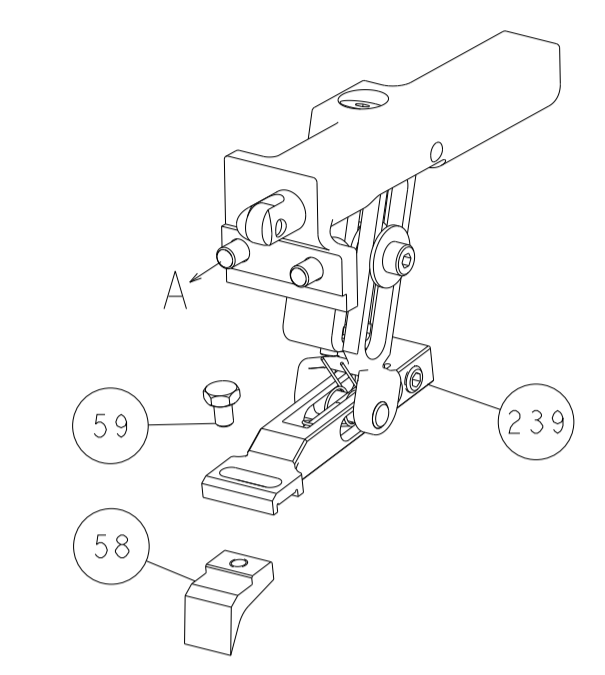
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN C. TOPPER 19MAR2018		CHK G. BAILEY 19MAR2018		APVD J. DEGRANGE 19MAR2018		NAME Ocean End Feed Applicator	
mm		0 PLC ±		APPL SPEC		SIZE		CAGE CODE		DRAWING NO	
		1 PLC ±		PRODUCT SPEC		A1		00779		©=2150890	
		2 PLC ±		APPLICATION SPEC		SCALE		1:1		SHEET 1 OF 4	
		3 PLC ±		MATERIAL		RESTRICTED TO				REV C	
		4 PLC ±		FINISH		Customer Accessible Production Drawing					

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

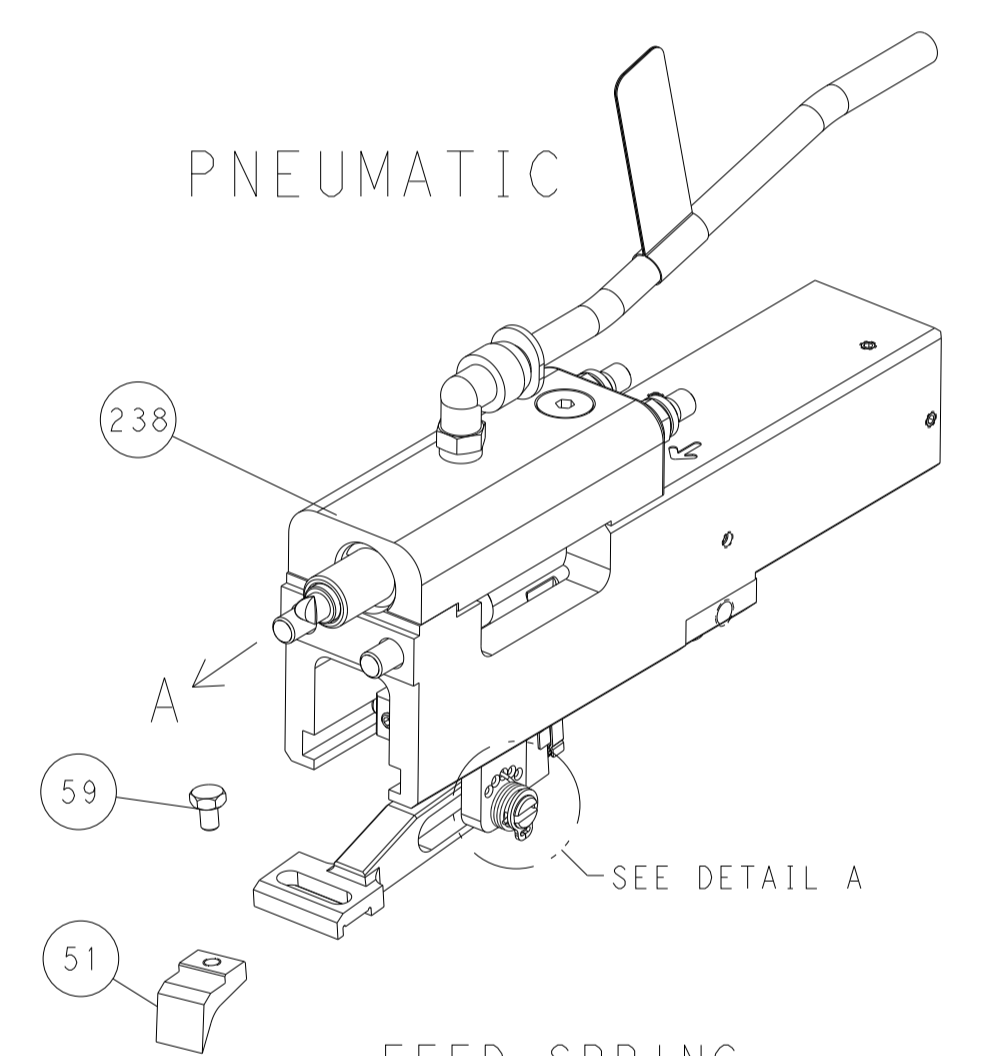


RAM AND HOLD-DOWN SET-UP

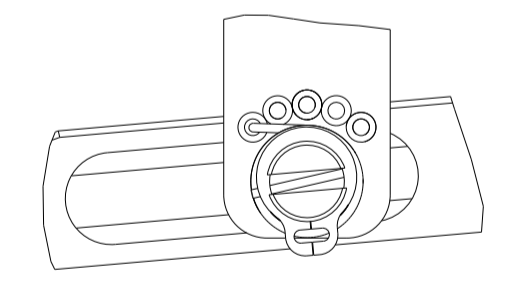
FEED TYPE MECHANICAL



PNEUMATIC

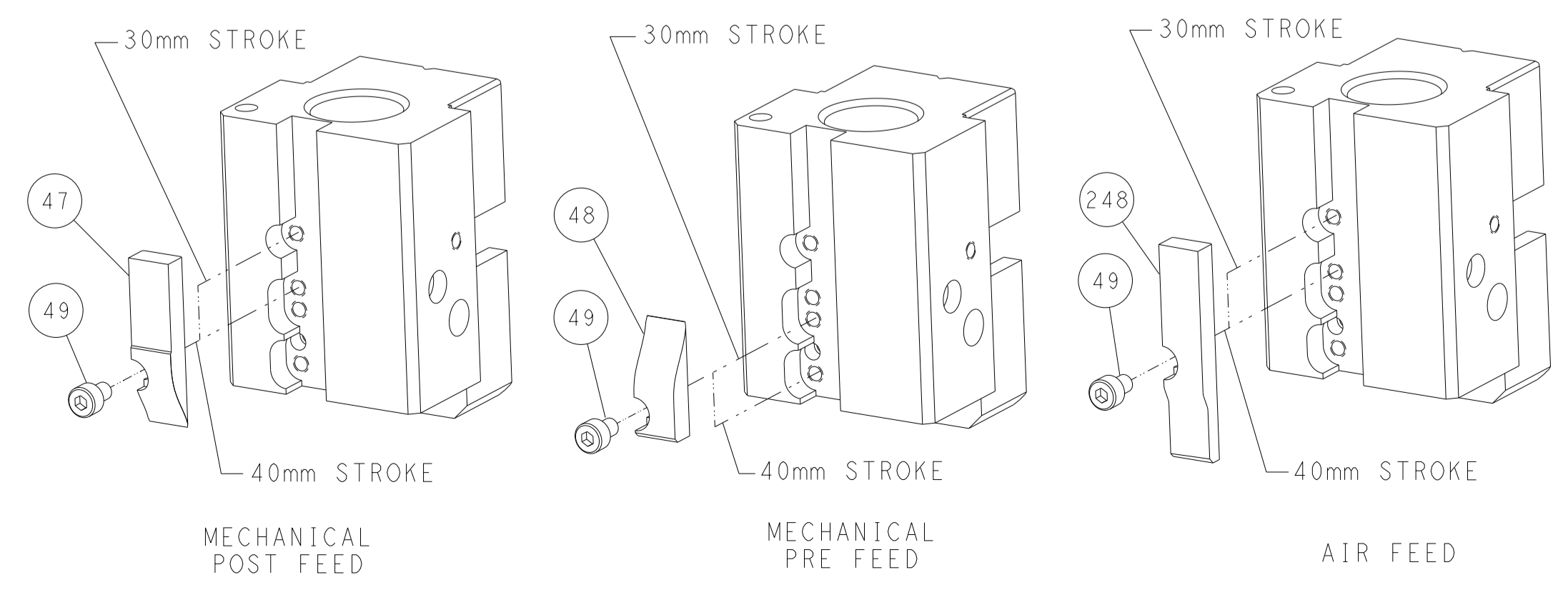


FEED SPRING SETTING POSITION



DETAIL A

CAM POSITIONS

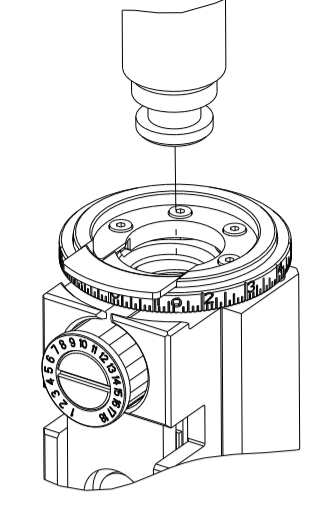


ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN C. TOPPER 19MAR2018	TE Connectivity Harrisburg, PA 17105-3608
		0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH ±		CHK G. BAILEY 19MAR2018	
MATERIAL		WEIGHT		APVD J. DEGRANGE 19MAR2018	NAME Ocean End Feed Applicator
				PRODUCT SPEC	SIZE CAGE CODE DRAWING NO
				APPLICATION SPEC	A1 00779 C=2150890
				RESTRICTED TO	Customer Accessible Production Drawing
				SCALE 1:1	SHEET 2 OF 4 REV C

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150890-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2150890-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150890-7	B	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
 INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.52 mm [.060]	Ø
INSUL	-	-
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: HS UNITED EUROPEAN TERMINAL TE CRIMP SPECIFICATION			
TERMINAL NAME: CLAW TERMINAL			
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE		
6.60-7.40 mm [.260-.291 IN]	Ø		
TERMINAL APPLICATION SPECIFICATION	NONE	-	-
TERMINALS APPLIED			
TE TERMINAL	HS UNITED EUROPEAN TERMINAL	TE TERMINAL	HS UNITED EUROPEAN TERMINAL
3311095-1	21.010.110	3311095-3	21.010.310
3311095-2	21.010.120	3311095-4	21.010.320

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.00mm2	1.55+/-0.025 [.061+/- .001]	3.3
0.75mm2	1.50+/-0.025 [.059+/- .001]	4.0
0.50mm2	1.40+/-0.025 [.055+/- .001]	4.8

- 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 THE RECOMMENDED SET-UP FOR END FEED APPLICATORS IS POST-FEED WITH ITEM 2119653-1. THE APPLICATOR CAN BE CONFIGURED FOR PRE-FEED WITH ITEM 2119652-1 BUT MAY ENCOUNTER PROBLEMS WITH SOME APPLICATIONS. FEED ISSUES OR TERMINAL JAMMING MAY OCCUR IN THE PRE-FEED CONFIGURATION.
- 5. 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.

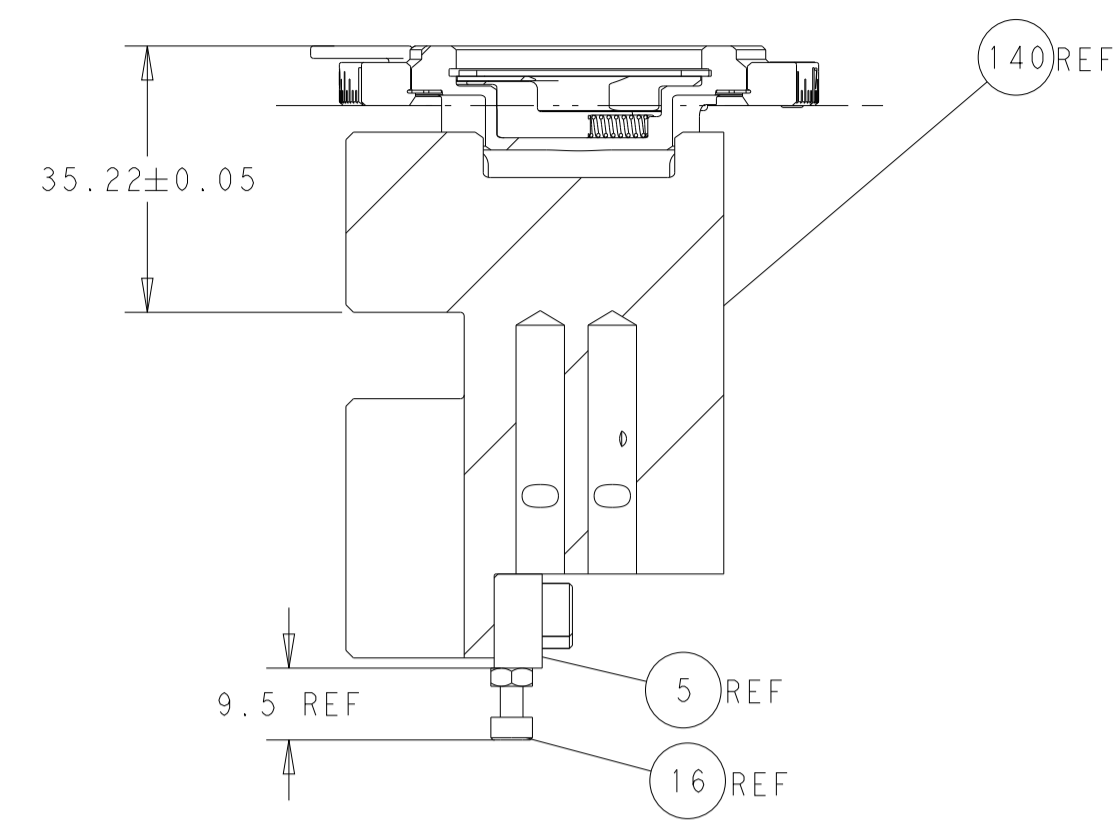
PACIFIC VERSION
 Shown on sheets 3 of 4 & 4 of 4
 (Atlantic version shown on sheets 1 of 4 & 2 of 4)

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

-	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239	
-	1	-	2844940-3	AIR FEED MODULE	238	
-	1	1	1803970-1	FLOATING SHEAR HOLDER	206	
-	2	2	1-2168083-1	SCR, SKT HD CAP, RoHS, M3 X 6	191	
-	4	4	2079383-9	SCR, BHSC, RoHS (M6 X 20)	186	
-	2	2	2-22280-0	SPRING, COMPRESSION	180	
-	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	178	
-	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	2-2119655-6	APPLICATOR BASIC ASSEMBLY, EF	141	
-	1	1	1803518-1	RAM ASSEMBLY, EF PACIFIC	140	
-	1	1	455888-5	SPACER, CRIMPER	82	
-	1	1	1803203-1	BLOCK, FRONT DEPRESSOR	77	
-	1	1	2119791-5	DEPRESSOR, WIRE	73	
-	1	1	1803607-4	DOCUMENTATION PACKAGE	71	
-	2	2	3-18032-3	SCR, SET, FLT PNT, M3 X 20.0	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	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	-	2063961-1	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	2079383-7	SCR, BHSC, RoHS (M8 X 25)	41	
-	7	7	1-18028-2	WASHER, FLAT, REG M4	33	
-	2	2	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	31	
-	2	2	1-2168083-6	SCR, SKT HD CAP, RoHS, M4 X 35	25	
-	1	1	1803162-1	PLATE, STRIP GUIDE	24	
-	2	2	22281-8	SPRING, COMPRESSION	22	
-	1	1	1633168-1	ARM, STOCK DRAG	21	
-	1	1	1-464452-6	DRAG, STOCK	20	
-	2	2	1803971-1	GUIDE, LOWER STRIP	18	
-	1	1	1-2168083-3	SCR, SKT HD CAP, RoHS, M3 X 16	16	
-	1	1	5018030-1	NUT, HEX, REG, RoHS, M3	15	
-	1	1	1-356885-6	STOP, SHEAR	11	
-	-	-	-	-	10	
-	-	-	-	-	9	
1	1	1	1-1213862-2	ANVIL, SPLICE TYPE	8	
-	1	1	1803714-1	SHEAR BLADE	7	
-	-	-	-	-	6	
-	1	1	690753-6	SPACER, TONKER	5	
-	-	-	-	-	4	
-	-	-	-	-	3	
-	-	-	-	-	2	
1	1	1	5-1633723-7	CRIMPER, WIRE Ø -	1	
-	77	22	21	PART NO	DESCRIPTION	ITEM NO

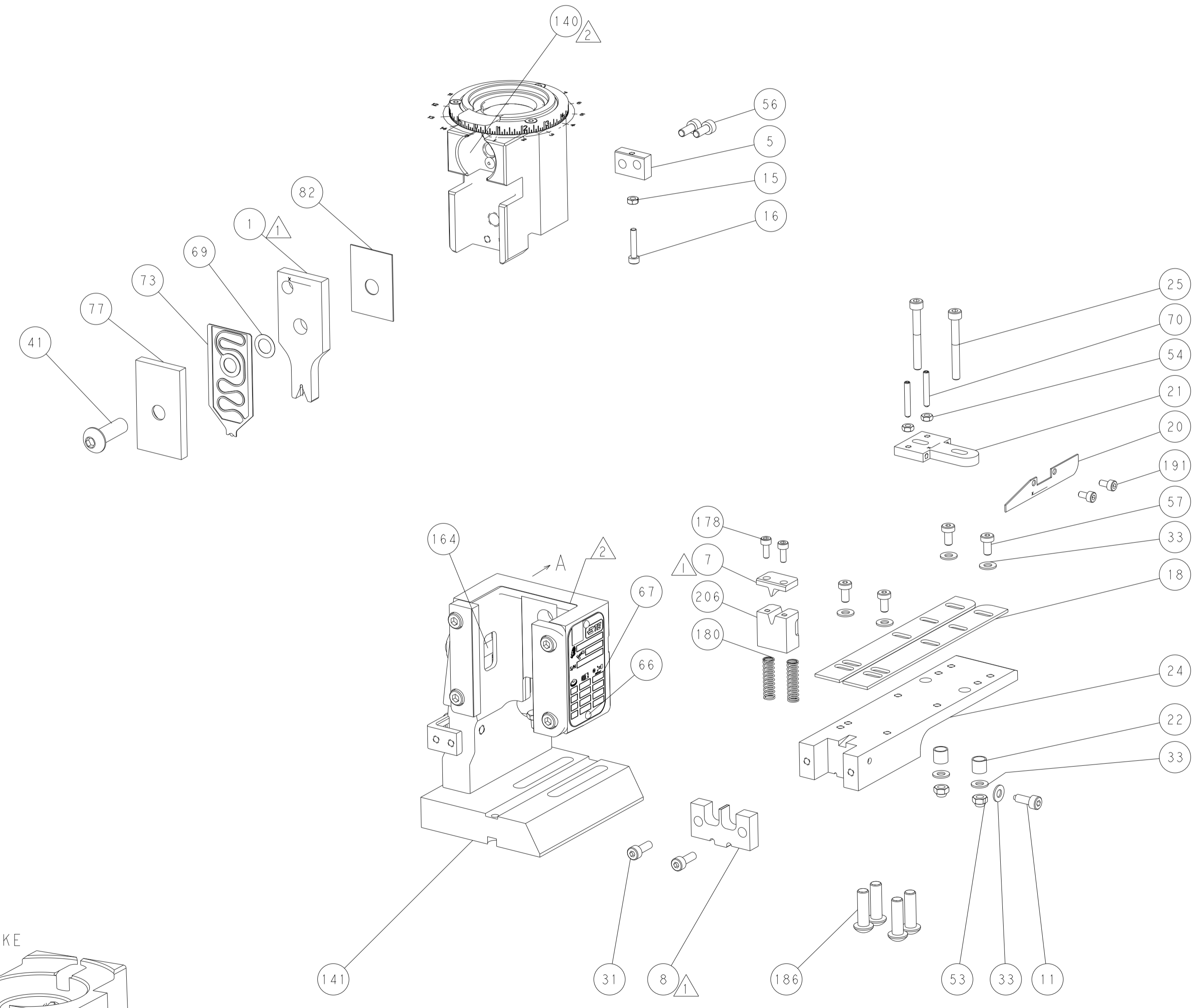
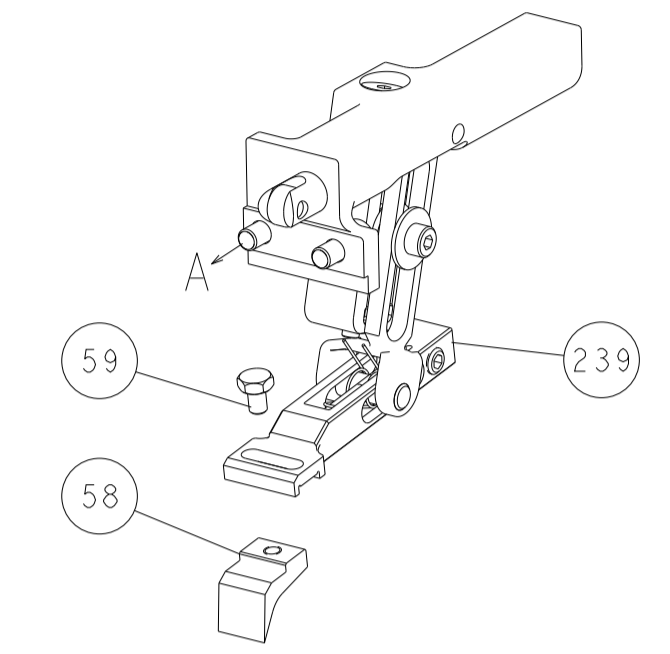
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		OWN: C. TOPPER 19MAR2018	NAME: Ocean End Feed Applicator
Ø	PLC ±	PLC ±	PLC ±	CHK: G. BAILEY 19MAR2018	
Ø	PLC ±	PLC ±	PLC ±	APVD: J. DEGRANGE 19MAR2018	SIZE: A1
Ø	PLC ±	PLC ±	PLC ±	PRODUCT SPEC	CAGE CODE: 00779
Ø	PLC ±	PLC ±	PLC ±	APPLICATION SPEC	DRAWING NO: C=2150890
Ø	PLC ±	PLC ±	PLC ±	FINISH	SCALE: 1:1
MATERIAL:		WEIGHT:		Customer Accessible Production Drawing	
				SHEET: 3 OF 4	REV: C

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

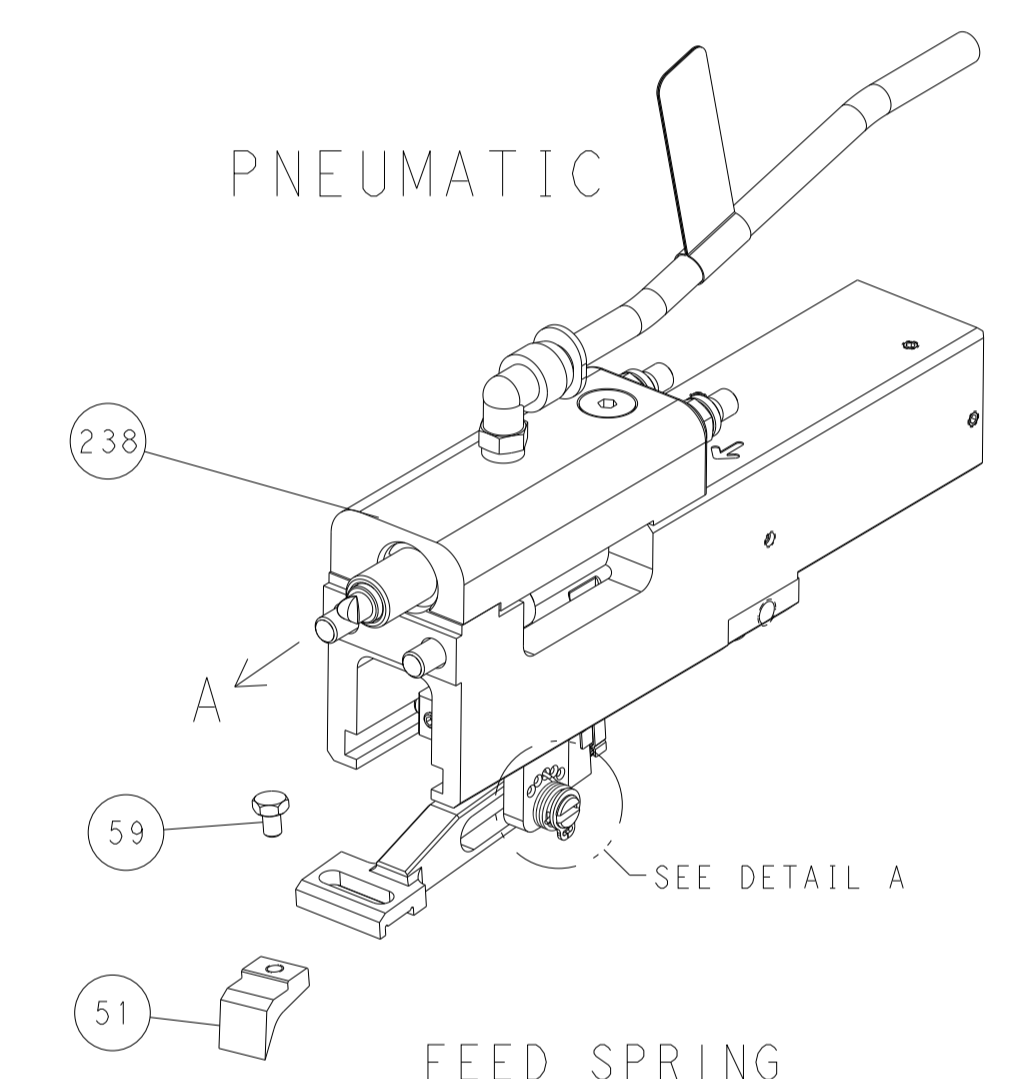


RAM AND HOLD-DOWN SET-UP

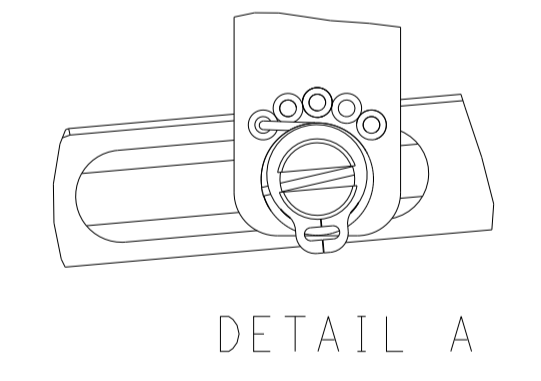
FEED TYPE MECHANICAL



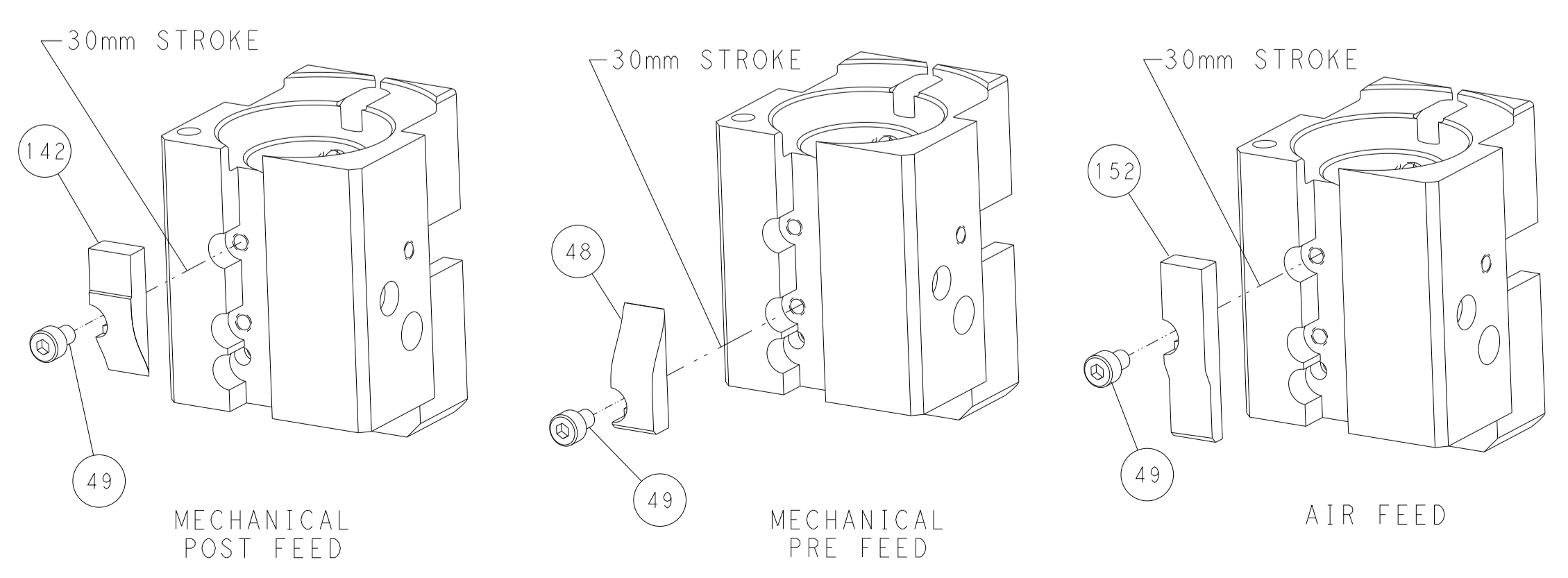
PNEUMATIC



FEED SPRING SETTING POSITION



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)

<small>THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.</small>		DWN C. TOPPER 19MAR2018 CHK G. BAILEY 19MAR2018 APVD J. DEGRANGE 19MAR2018	NAME Ocean End Feed Applicator
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH ±	PRODUCT SPEC APPLICATION SPEC WEIGHT SCALE 1:1	SIZE CAGE CODE DRAWING NO A1 00779 C-2150890	RESTRICTED TO Customer Accessible Production Drawing SHEET 4 OF 4 REV C