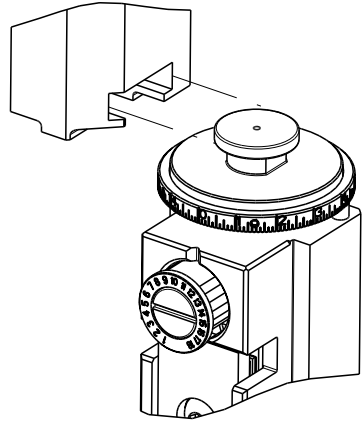


8		7	
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20		20	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
4150107-2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-4150107-2	A	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-4150107-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.79 mm [.110]	F
INSUL	3.05 mm [.120]	F
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: HOFFMAN PRODUCTS TERMINAL - CRIMP SPECIFICATION			
TERMINAL NAME: TERMINAL			
WIRE STRIP LENGTH 3.85-4.61 mm [.152-.182 IN]		TERMINAL INSULATION DIAMETER RANGE Ø 1.54-2.06 mm [.061-.081 IN]	
TERMINAL APPLICATION SPECIFICATION	NONE Rev -	-	-
TERMINALS APPLIED		AT9106	
TE TERMINAL	HOFFMAN PRODUCTS TERMINAL	TE TERMINAL	HOFFMAN PRODUCTS TERMINAL
3311767-1	M12216T110MS		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
16 AWG	1.69+/-0.05 [1.067+/- .002]	5.9
18 AWG	1.57+/-0.05 [1.062+/- .002]	7.1
20 AWG	1.48+/-0.05 [1.058+/- .002]	8.0
22 AWG	1.42+/-0.05 [1.056+/- .002]	8.6



- 1 RECOMMENDED SPARE PARTS.
- 2 REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION & 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 TERMINAL LUBRICANT IS RECOMMENDED.

7. 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)

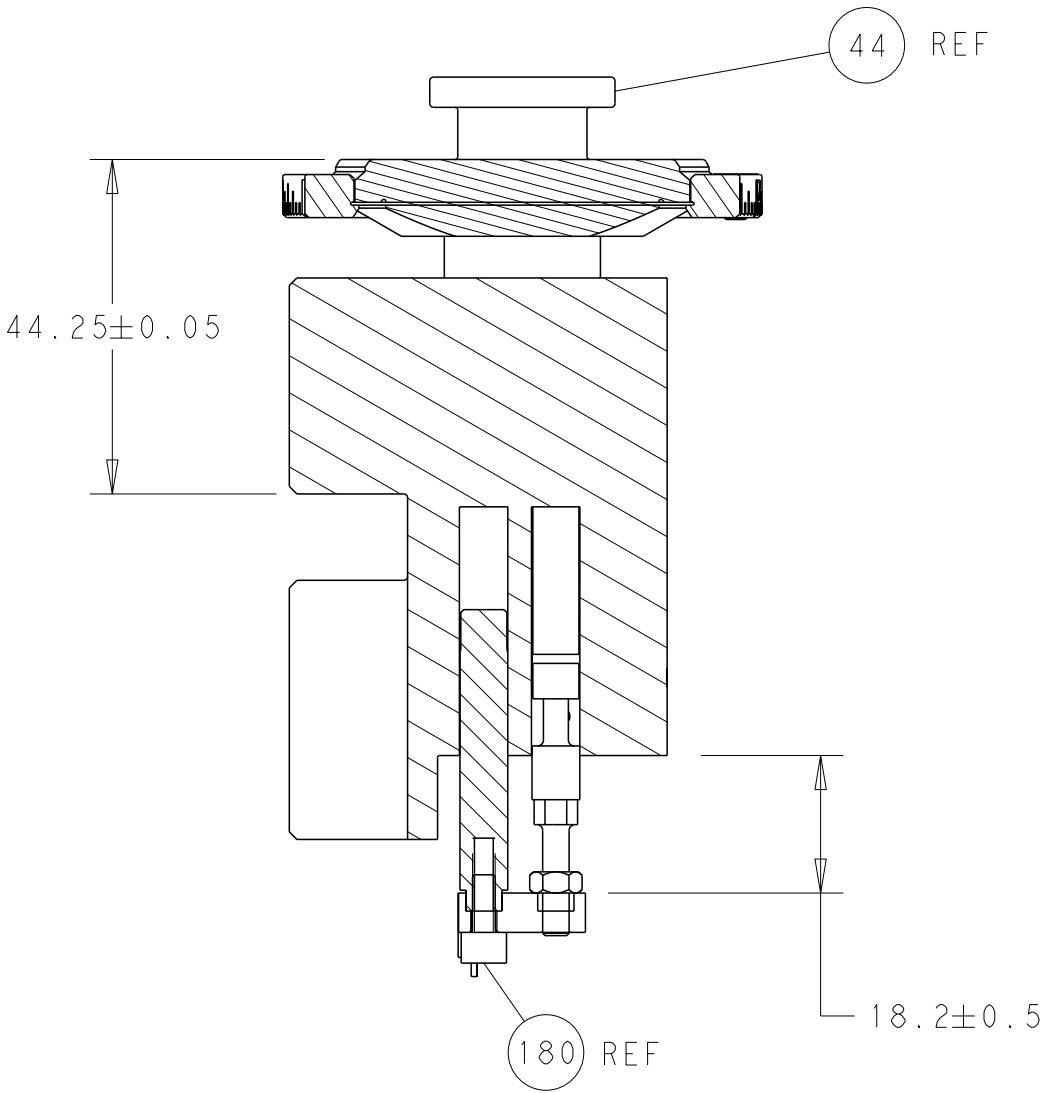
LOC		DIST		REVISIONS			
A		66		P	LYR	DESCRIPTION	DATE
					1	DEVELOPMENT	09MAR2021
					A	RELEASED	27APR2021

-	1	1	2119641-1	FEED CAM, AIR FEED	248
-	1	1	2119082-3	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	2844940-4	AIR FEED MODULE	238
-	1	1	1-18028-0	WASHER, FLAT, REG M8	192
3	-	1	1752354-1	STANDOFF,HOLD-DOWN	180
-	1	1	6-9931111-6	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
6	-	1	2119955-2	ASSY, LUBRICATOR, END FEED	84
-	1	1	455888-8	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	4-1901681-4	HOLDDOWN, TERMINAL	65
-	2	2	2168400-8	SHCS, LOW HEAD, RoHS, M4 X 16	64
-	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
-	3	3	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57
-	2	2	2-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 14	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	2063961-9	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
-	7	7	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
-	1	1	240825-8	PLATE, STRIP HOLD DOWN	23
-	2	2	22281-8	SPRING, COMPRESSION	22
-	1	1	1803292-4	DRAG	20
-	2	2	1901259-3	GUIDE, LOWER STRIP	18
-	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17
-	1	1	6-240641-5	SPACER	16
-	1	1	1752360-1	SPACER,HOLD-DOWN	13
-	1	1	240644-9	PLATE, REAR SHEAR	11
-	-	-	-	-	10
1	-	1	8-690482-3	PLATE, FRONT SHEAR	9
1	2	1	7-1803257-8	ANVIL, COMBINATION, END FEED	8
1	-	1	1-2217206-6	BLADE, SLUG	7
-	-	-	-	-	6
-	1	1	240641-2	SPACER	5
-	1	1	3-238011-5	BLOCK, CRIMPER SPACER	4
1	2	1	1-1803016-5	CRIMPER, INSULATION F	3
-	1	1	455888-3	SPACER, CRIMPER	2
1	2	1	5-456408-2	CRIMPER, WIRE PREMIUM	1
-	77-72	-2	PART NO	DESCRIPTION	ITEM NO

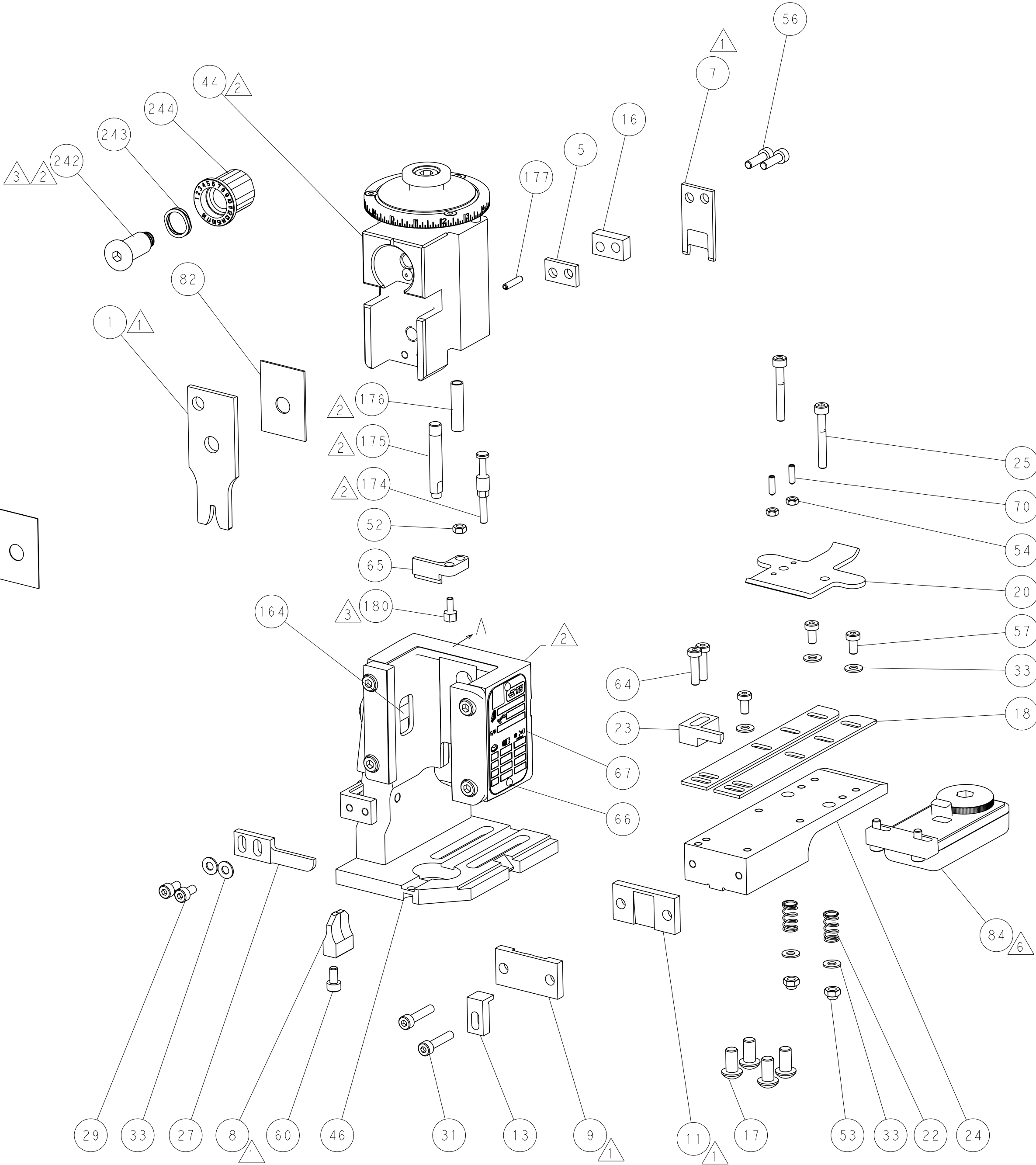
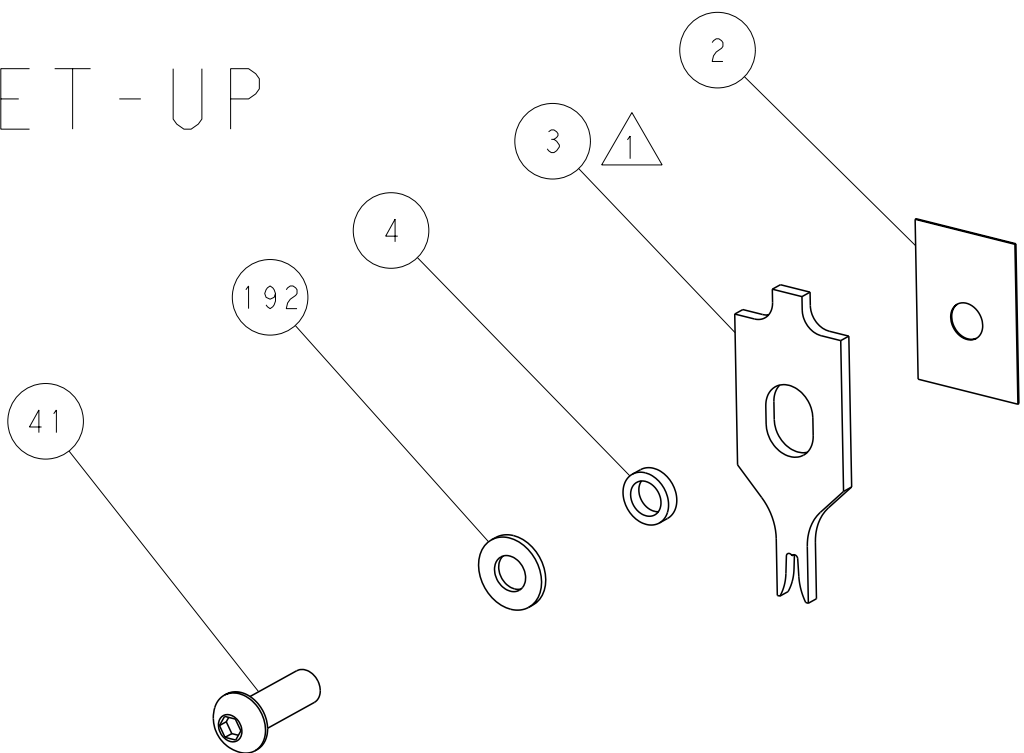
THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE AND TO BE CONTROLLED BY THE ENGINEERING DEPARTMENT. IT SHOULD BE CONTACTED FOR THE LATEST REVISION.				DWN	J. FENG	09MAR2021	 TE Connectivity Harrisburg, PA 17105-3608										
				CHK	Y. YIN	09MAR2021											
				APVD	Y. YIN	09MAR2021											
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		PRODUCT SPEC			NAME										
mm		0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ±		APPLICATION SPEC													
		ANGLES ±		FINISH			SIZE			DRAWING NO		RESTRICTED TO					
MATERIAL		-		WEIGHT		-		A1		00779		©=4150107		-			
Customer Accessible Production Drawing				SCALE		1:1		SHEET		1 OF 4		REV		A			

SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

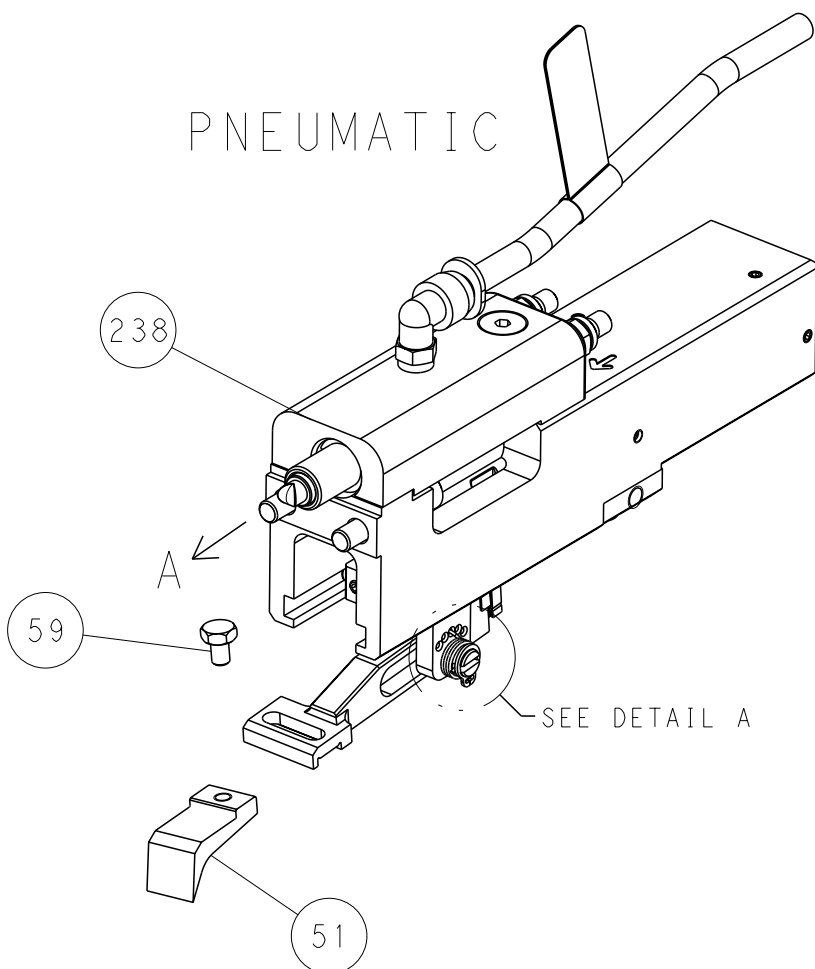
LOC		DIST		REVISIONS					
A		66		P	LYR	DESCRIPTION	DATE	DWN	APVD
				-		SEE SHEET 1	-	-	-



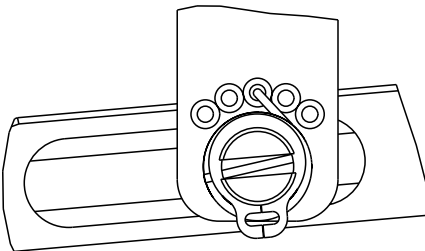
RAM AND HOLDDOWN SET-UP



FEED TYPE

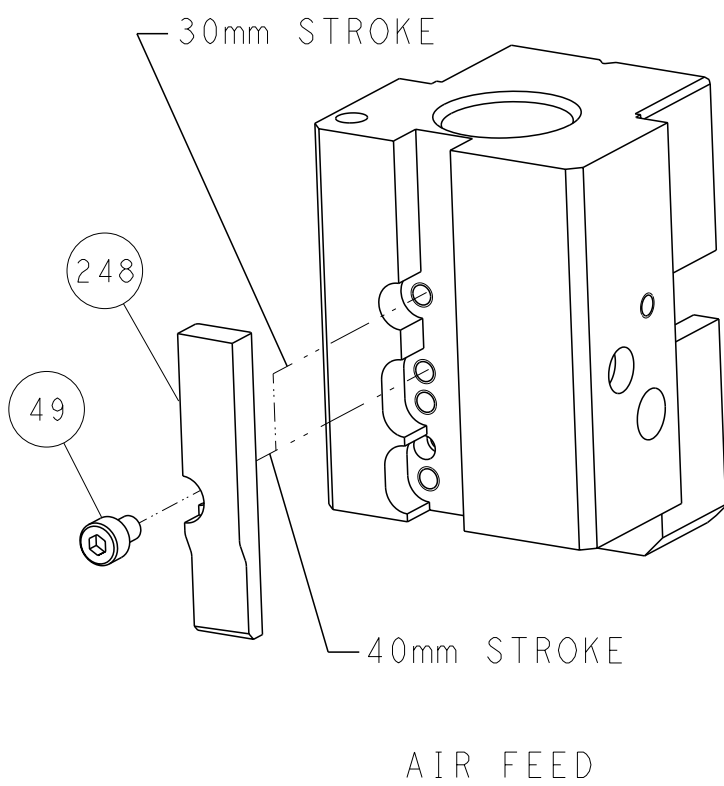


FEED SPRING SETTING POSITION



DETAIL A

CAM POSITION

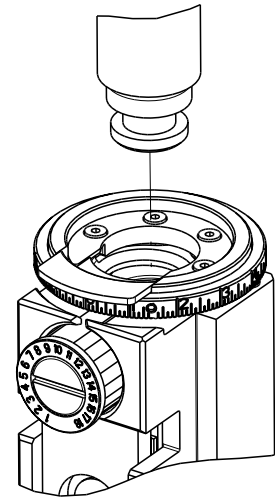


ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

1111 BEARING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION 1111 IS SUBJECT TO CHANGE AND TO CONTROL AND ENGINEERING ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST REVISION				DWN J. FENG 09MAR2021	TE Connectivity Harrisburg, PA 17105-3608			
DIMENSIONS: mm				CHK Y. YIN 09MAR2021	NAME OCEAN 2.0 End Feed Applicator			
TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH *				APVD Y. YIN 09MAR2021	SIZE A1			
MATERIAL -				PRODUCT SPEC -	CAGE CODE 00779			
				APPLICATION SPEC -	DRAWING NO 4150107			
				WEIGHT -	RESTRICTED TO -			
				Customer Accessible Production Drawing	SCALE 1:1	SHEET 2	OF 4	REV A

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-4150107-2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-4150107-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.79 mm [.110]	F
INSUL	3.05 mm [.120]	F
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: HOFFMAN PRODUCTS TERMINAL - CRIMP SPECIFICATION			
TERMINAL NAME: TERMINAL			
WIRE STRIP LENGTH 3.85-4.61 mm [.152-.182 IN]		TERMINAL INSULATION DIAMETER RANGE Ø 1.54-2.06 mm [.061-.081 IN]	
TERMINAL APPLICATION SPECIFICATION	NONE Rev -	-	-
		-	AT9106
TERMINALS APPLIED			
TE TERMINAL	HOFFMAN PRODUCTS TERMINAL	TE TERMINAL	HOFFMAN PRODUCTS TERMINAL
3311767-1	MI2216T110MS		

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING
16 AWG		1.69+/-0.05 [.067+/-0.002]		5.9
18 AWG		1.57+/-0.05 [.062+/-0.002]		7.1
20 AWG		1.48+/-0.05 [.058+/-0.002]		8.0
22 AWG		1.42+/-0.05 [.056+/-0.002]		8.6



- RECOMMENDED SPARE PARTS.
- REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION & STORAGE OF APPLICATOR.
- APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 180. APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242.
- 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.
- TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- TERMINAL LUBRICANT IS RECOMMENDED.
7. 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)

2		1						
LOC	DIST	REVISIONS						
A	66	P	LTR	DESCRIPTION	DATE	DWN	APVD	
			-	SEE SHEET 1	-	-	-	

	-	1	2119082-3	CAM, SNAIL, INSULATION ADJUSTMENT	244
	-	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
3	-	1	2119083-1	RETAINER, INSULATION DIAL	242
	-	1	2844940-4	AIR FEED MODULE	238
	-	1	1-18028-0	WASHER, FLAT, REG M8	192
3	-	4	2079383-9	SCR, BHSC, RoHS (M6 X 20)	186
	-	1	1752354-1	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
6	-	1	2119955-2	ASSY, LUBRICATOR, END FEED	84
	-	1	455888-8	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	4-1901681-4	HOLDDOWN, TERMINAL	65
	-	2	2168400-8	SHCS, LOW HEAD, RoHS, M4 X 16	64
	-	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
	-	3	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57
	-	2	2-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 14	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	2063961-9	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
	-	7	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	1752371-5	PLATE, STRIP GUIDE	24
	-	1	240825-8	PLATE, STRIP HOLD DOWN	23
	-	2	22281-8	SPRING, COMPRESSION	22
	-	1	1803292-4	DRAG	20
	-	2	1901259-3	GUIDE, LOWER STRIP	18
	-	1	6-240641-5	SPACER	16
	-	1	1752360-1	SPACER,HOLD-DOWN	13
1	-	1	240644-9	PLATE, REAR SHEAR	11
	-	-	-	-	10
1	-	1	8-690482-3	PLATE, FRONT SHEAR	9
1	1	1	7-1803257-8	ANVIL, COMBINATION, END FEED	8
1	-	1	1-2217206-6	BLADE, SLUG	7
	-	-	-	-	6
	-	1	240641-2	SPACER	5
	-	1	3-238011-5	BLOCK, CRIMPER SPACER	4
1	1	1	1-1803016-5	CRIMPER, INSULATION F	3
	-	1	455888-3	SPACER, CRIMPER	2
1	1	1	5-456408-2	CRIMPER, WIRE PREMIUM	1
-77-22	PART NO		DESCRIPTION		ITEM NO

THIS DRAWING IS A CONTROLLED DOCUMENT FOR THE ELECTRONIC CORPORATION. IT IS SUBJECT TO CHANGE AND TO BE CONTROLLED BY THE ELECTRONIC CORPORATION. SHOULD BE CONTACTED FOR THE LATEST REVISION.				OWN J.FENG 09MAR2021		 TE Connectivity Harrisburg, PA 17105-3608													
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		CHK Y.YIN 09MAR2021		NAME OCEAN 2.0 End Feed Applicator													
		0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ±		APVD Y.YIN 09MAR2021															
MATERIAL -		ANGLES FINISH -		PRODUCT SPEC -		APPLICATION SPEC -		SIZE A1		CAGE CODE 00779		DRAWING NO C=4150107		RESTRICTED TO -					
Customer Accessible Production Drawing												SCALE 1:1		SHEET 3		OF 4		REV A	



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 TWO ELECTRONIC COORDINATION IT IS SUBJECT TO THE CONTRACT AND ANY OTHER COORDINATION SHOULD BE CONTACTED FOR THE LATEST REVISION.		DWN J. FENG 09MAR2021		TE Connectivity	
		CHK Y. YIN 09MAR2021		Harrisburg, PA 17105-3608	
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		NAME	
mm		APVD Y. YIN 09MAR2021		OCEAN 2.0 End Feed Applicator	
		0 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		PRODUCT SPEC - APPLICATION SPEC -	
MATERIAL		FINISH		SIZE	
				A 00779 C=4150107	
		WEIGHT		DRAWING NO	
				RESTRICTED TO	
				-	
Customer Accessible Production Drawing				SCALE 1:1 SHEET 4 OF 4 REV A	