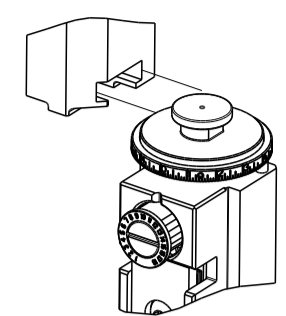


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150115-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150115-2	C	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150115-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



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

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION			
TERMINAL NAME: SPLICE (AMPLIVAR)			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
7.09-8.66 mm [.279-.341]		-	
TERMINAL APPLICATION SPECIFICATION	(B)114-2008	-	-
	(A)114-2002	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
(B) 42776-1	(A) 62040-2	(A) 964156-1	
(A) 62040-1	(A) 62040-3	(A) 964156-2	

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
5000 CMA(2)16 $\frac{1}{2}$ MAG(4920)	2.06+/-0.05 [.081+/- .002]	5.4
1500 CMA 18 $\frac{1}{2}$ MAG(1560)	1.60+/-0.05 [.063+/- .002]	10.5

- 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.
- TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- TERMINAL LUBRICANT IS RECOMMENDED.
- WHEN ASSEMBLING -6 NON-CRIMP HEIGHT ADJUST APPLICATOR USE SHIM PACK 2119957-2 TO ALIGN APPLICATOR'S MAXIMUM WIRE CRIMP HEIGHT AT NORMAL TERMINATOR SHUT HEIGHT.
- REFER TO TERMINAL CUSTOMER DRAWING FOR CRIMP HEIGHT FORMULA TO CALCULATE SPECIFIC CRIMP HEIGHTS.

***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
		A		RELEASED	28APR2016	BW	GB
		B		ECR-20-000579	14JAN2020	FJ	TE
		C		ECR-22-46743	19JUL2022	JWC	TE

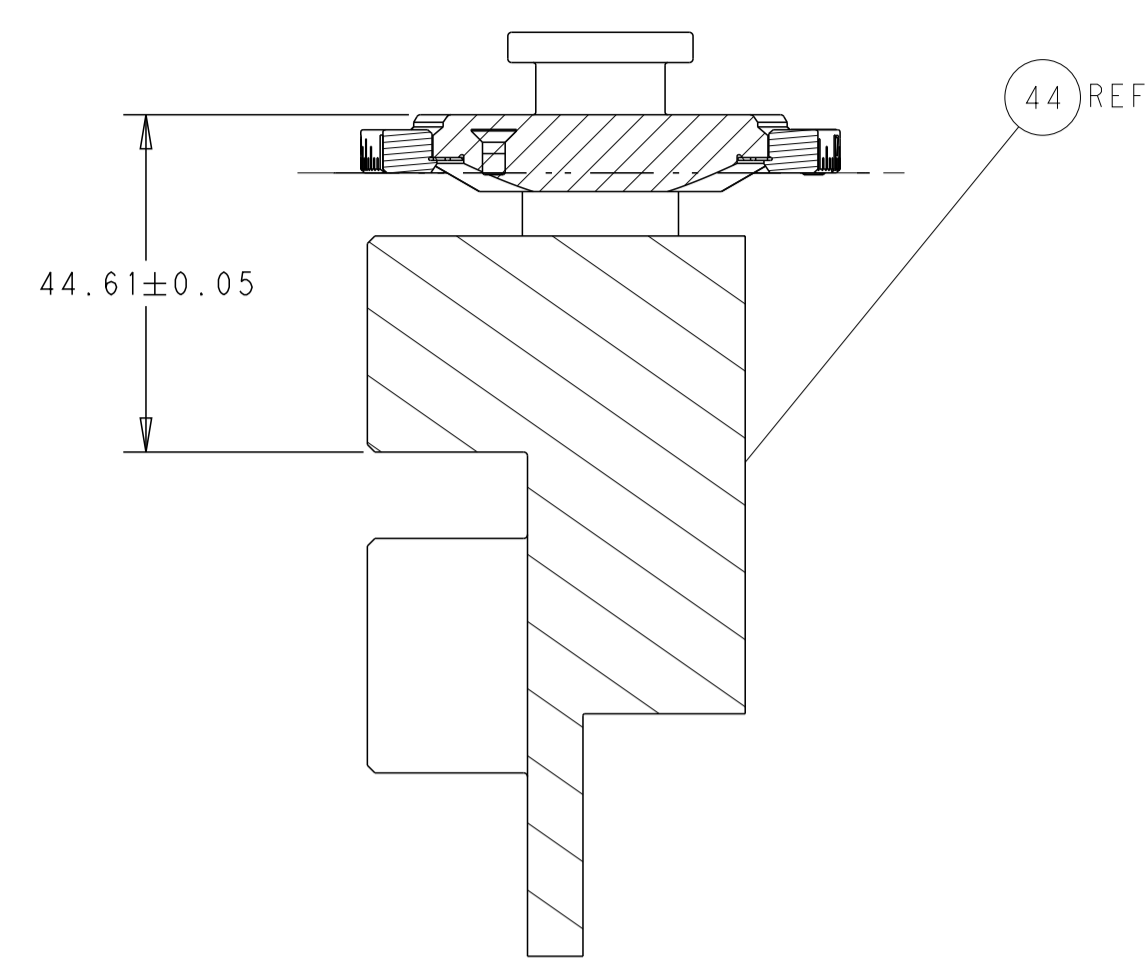
-	1	1	23238-1	INSERT, COUPLING	278
-	24	24	2030758-3	TUBING, POLYURETHANE	277
-	1	1	986220-3	CLAMP, CABLE, BLACK	275
-	1	1	2844280-1	MOUNT, AIR BLAST	273
-	1	1	2119641-1	FEED CAM, AIR FEED	248
-	1	1	2844940-3	AIR FEED MODULE	238
-	1	1	1-18028-0	WASHER, FLAT, REG M8	192
-	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	3	3	1-18023-0	SCR, SKT HD CAP M4 X 8.0	143
-	2	2	1-18024-4	SCR, BTN SKT HD CAP (M5 X 20.0)	94
-	2	2	1-18024-1	SCR, BTN SKT HD CAP (M5 X 10.0)	93
-	1	1	2119955-2	ASSY, LUBRICATOR, END FEED	84
-	4	4	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	80
-	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	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	2168400-1	SHCS, LOW HEAD, RoHS, M4 X 12	57
-	2	2	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	56
-	2	2	5018030-1	NUT, HEX, REG, RoHS, M3	54
-	2	2	986965-8	NUT, LOCK, HEX, TORQUE (M4)	53
-	1	1	1-2063961-3	FEED FINGER	51
-	1	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	1	1	2-2119655-1	APPLICATOR BASIC ASSEMBLY, EF	46
-	1	1	1803517-3	RAM ASSEMBLY, EF ATLANTIC	44
-	1	1	2-2079383-0	SCR, BHSC, RoHS (M8 X 35)	41
-	6	6	1-18028-2	WASHER, FLAT, REG M4	33
-	2	2	2-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 14	29
-	1	1	460276-2	STRIPPER, SPECIAL	27
-	2	2	1-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 30	25
-	1	1	3-1752371-0	PLATE, STRIP GUIDE	24
-	1	1	1-462932-0	PLATE, STRIP COVER	23
-	2	2	2-22281-3	SPRING, COMPRESSION	22
-	2	2	18027-2	WASHER, FLAT, REG M4	21
-	1	1	1803292-1	DRAG	20
-	2	2	1901259-4	GUIDE, LOWER STRIP	18
-	2	2	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17
-	1	1	459684-1	PLATE GUIDE, RETAINING	11
-	1	1	459580-1	PLATE, RETAINING	10
-	1	1	2-459583-0	BODY, ANVIL	9
-	1	2	459582-4	ANVIL, AMPLIVAR SPLICE	8
-	1	1	459581-1	BLADE, SLUG	7
-	-	-	-	-	6
-	-	-	-	-	5
-	-	-	-	-	4
-	1	2	459587-1	GUIDE, CRIMPER	3
-	-	-	-	-	2
-	1	2	459585-1	CRIMPER, BLUNT F	1
-	77	72	-2	PART NO	ITEM NO

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		MATERIAL:		FINISH:	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES ±	FINISH ±

DWN	B. WEAVER	02FEB2016	TE Connectivity
CHK	G. BAILEY	02FEB2016	Harrisburg, PA 17105-3608
APVD	G. BAILEY	02FEB2016	
NAME		Ocean End Feed Applicator	
PRODUCT SPEC			
APPLICATION SPEC			
SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
A1	00779	2150115	
Customer Accessible Production Drawing			SCALE 1:1 SHEET 1 OF 4 REV C

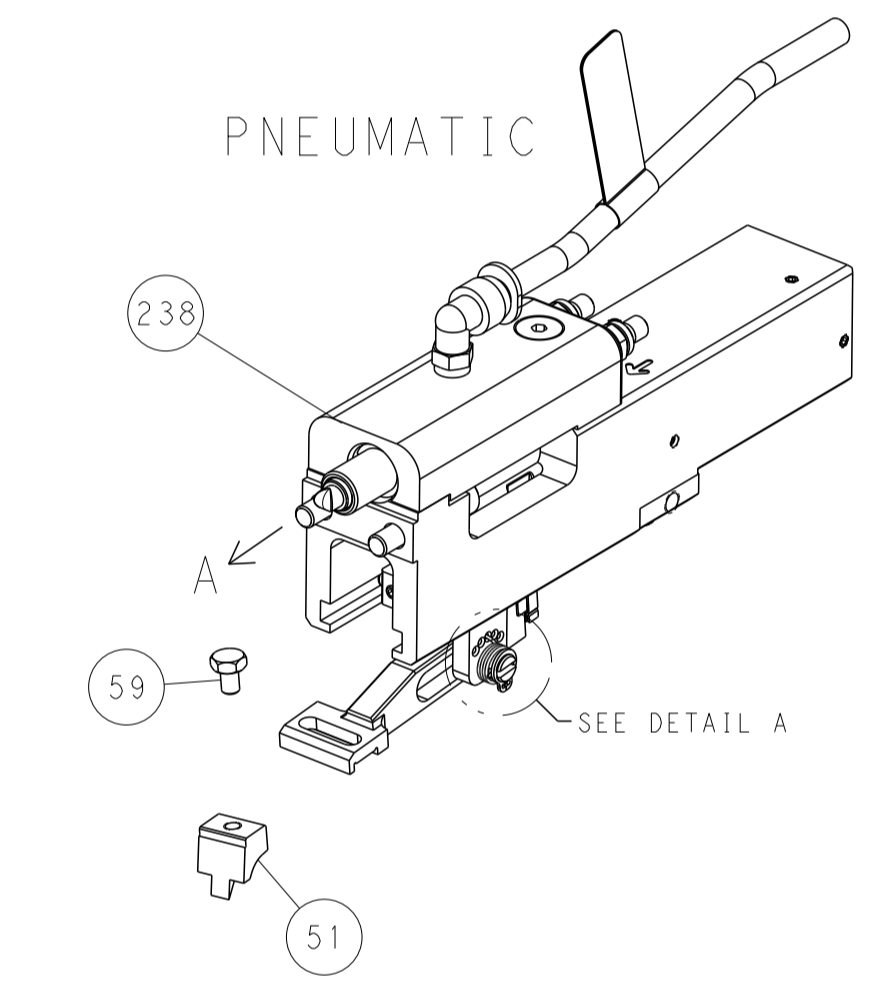
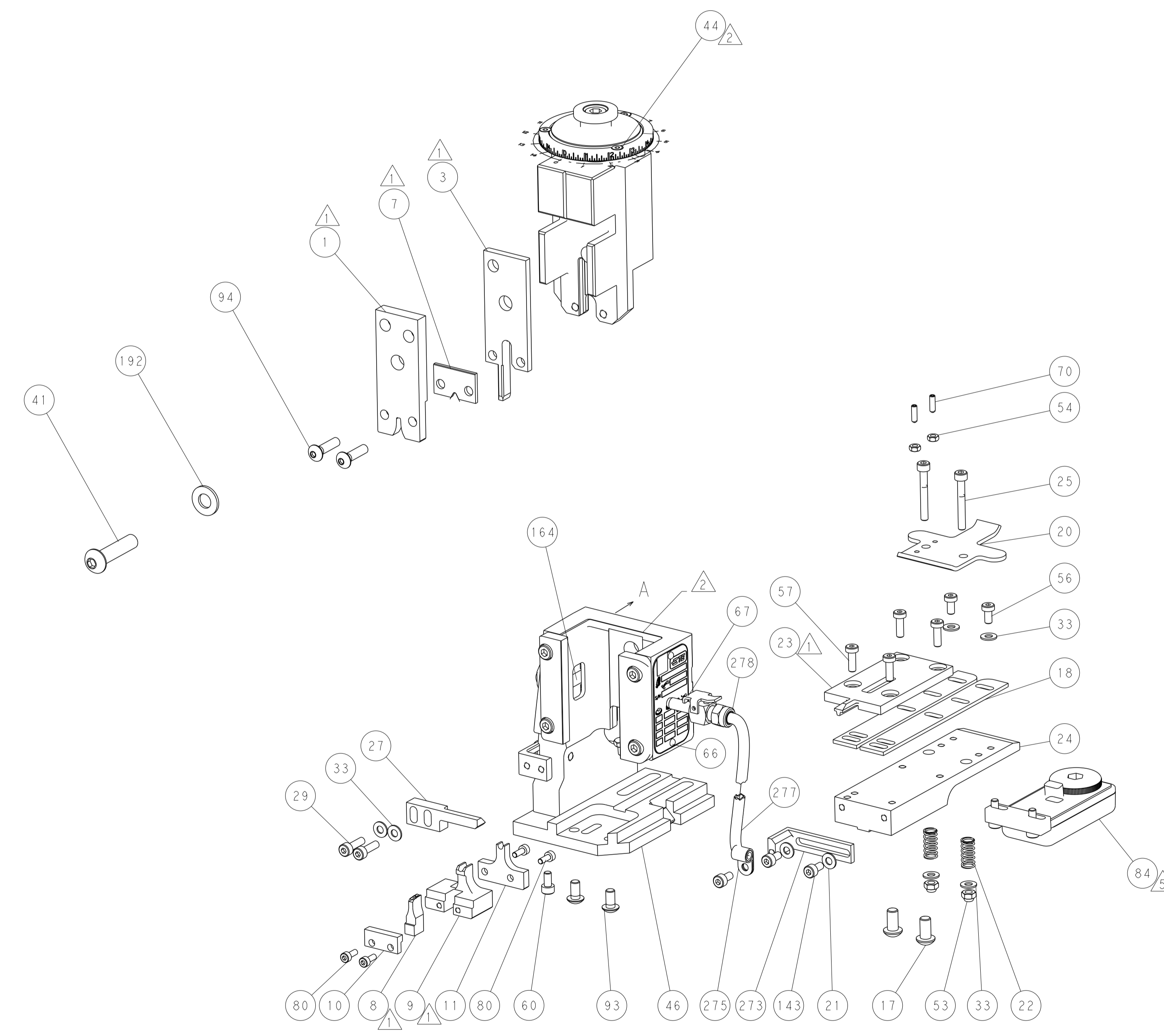
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A	66					

REVISIONS			
NO.	DESCRIPTION	DATE	BY
1	SEE SHEET 1		

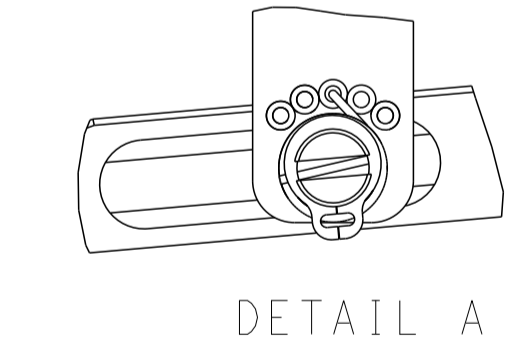


RAM SET-UP

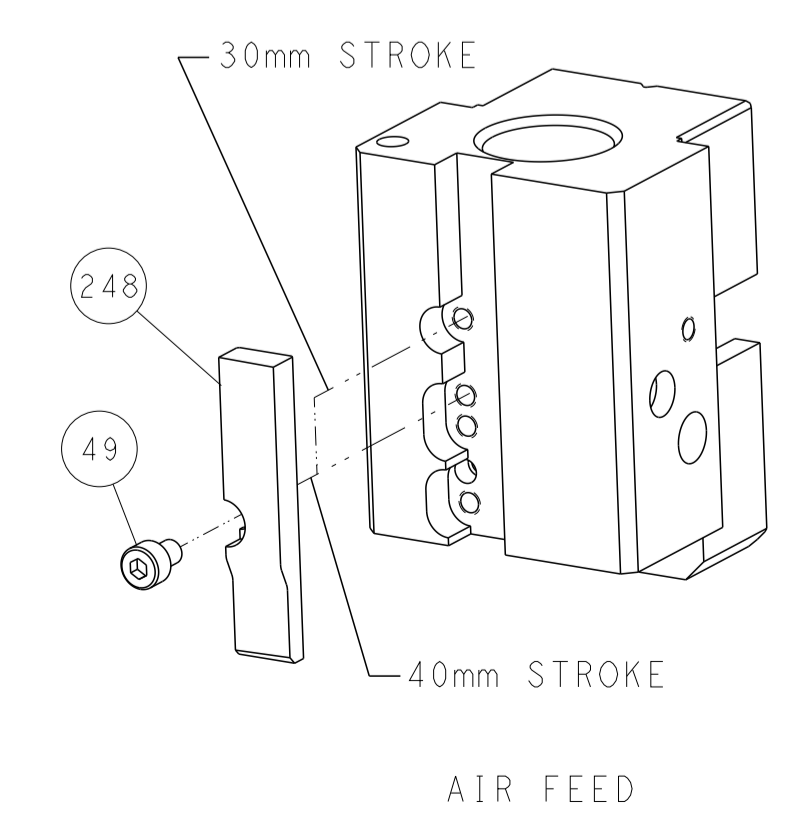
FEED TYPE



FEED SPRING SETTING POSITION



CAM POSITION

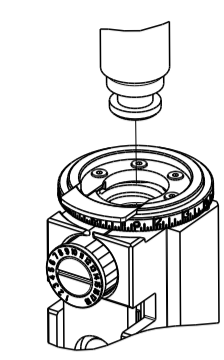


ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG: B. WEAVER 02FEB2016		TE Connectivity	
mm		0 PLC ±		CHK: G. BAILEY 02FEB2016		Harrisburg, PA 17105-3608	
Ø		1 PLC ±		APPD: G. BAILEY 02FEB2016		NAME: Ocean End Feed Applier	
H		2 PLC ±		PRODUCT SPEC		SIZE: CAGE CODE: DRAWING NO: RESTRICTED TO:	
D		3 PLC ±		APPLICATION SPEC		A1 00779 ©=2150115	
R		4 PLC ±		WEIGHT		Customer Accessible Production Drawing	
ANGLES		FINISH		SCALE: 1:1		SHEET 2 OF 4 REV C	

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150115-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150115-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
 INTERFACE ADAPTER



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

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: SPLICE (AMPLIVAR)			
WIRE STRIP LENGTH 7.09-8.66 mm [.279-.341]		INSULATION DIAMETER RANGE Ø -	
TERMINAL APPLICATION SPECIFICATION (A)114-2002	(B)114-2008	-	-
TERMINALS APPLIED			
TE TERMINAL (B) 42776-1 (A) 62040-1	TE TERMINAL (A) 62040-2 (A) 62040-3	TE TERMINAL (A) 964156-1 (A) 964156-2	TE TERMINAL

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
5000 CMA(2)162 MAG(4920)	2.06+/-0.05 [.081+/- .002]	5.4
1500 CMA 182 MAG(1560)	1.60+/-0.05 [.063+/- .002]	10.5



- 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 TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- 5 TERMINAL LUBRICANT IS RECOMMENDED.
- 6 WHEN ASSEMBLING -6 NON-CRIMP HEIGHT ADJUST APPLICATOR USE SHIM PACK 2119957-2 TO ALIGN APPLICATOR'S MAXIMUM WIRE CRIMP HEIGHT AT NORMAL TERMINATOR SHUT HEIGHT.
- 7 REFER TO TERMINAL CUSTOMER DRAWING FOR CRIMP HEIGHT FORMULA TO CALCULATE SPECIFIC CRIMP HEIGHTS.

***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	23238-1	INSERT, COUPLING	278	
-	24	2030758-3	TUBING, POLYURETHANE	277	
-	1	986220-3	CLAMP, CABLE, BLACK	275	
-	1	2844280-1	MOUNT, AIR BLAST	273	
-	1	2844940-3	AIR FEED MODULE	238	
-	1	1-18028-0	WASHER, FLAT, REG M8	192	
-	2	2079383-9	SCR, BHSC, RoHS (M6 X 20)	186	
-	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	
-	3	1-18023-0	SCR, SKT HD CAP M4 X 8.0	143	
-	1	2-2119655-2	APPLICATOR BASIC ASSEMBLY, EF	141	
-	1	1803518-3	RAM ASSEMBLY, EF PACIFIC	140	
-	2	1-18024-4	SCR, BTN SKT HD CAP (M5 X 20.0)	119	
-	2	1-18024-4	SCR, BTN SKT HD CAP (M5 X 20.0)	94	
-	1	2119955-2	ASSY, LUBRICATOR, END FEED	84	
-	4	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	80	
-	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	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59	
-	4	2168400-1	SHCS, LOW HEAD, RoHS, M4 X 12	57	
-	2	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	56	
-	2	5018030-1	NUT, HEX, REG, RoHS, M3	54	
-	2	986965-8	NUT, LOCK, HEX, TORQUE (M4)	53	
-	1	1-2063961-3	FEED FINGER	51	
-	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49	
-	1	2-2079383-0	SCR, BHSC, RoHS (M8 X 35)	41	
-	6	1-18028-2	WASHER, FLAT, REG M4	33	
-	2	2-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 14	29	
-	1	460276-2	STRIPPER, SPECIAL	27	
-	2	1-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 30	25	
-	1	3-1752371-0	PLATE, STRIP GUIDE	24	
-	1	1-462932-0	PLATE, STRIP COVER	23	
-	2	2-22281-3	SPRING, COMPRESSION	22	
-	2	18027-2	WASHER, FLAT, REG M4	21	
-	1	1803292-1	DRAG	20	
-	2	1901259-4	GUIDE, LOWER STRIP	18	
-	1	459684-1	PLATE GUIDE, RETAINING	11	
-	1	459580-1	PLATE, RETAINING	10	
-	1	2-459583-0	BODY, ANVIL	9	
-	1	459582-4	ANVIL, AMPLIVAR SPLICE	8	
-	1	459581-1	BLADE, SLUG	7	
-	-	-	-	6	
-	-	-	-	5	
-	-	-	-	4	
-	1	459587-1	GUIDE, CRIMPER	3	
-	-	-	-	2	
-	1	459585-1	CRIMPER, BLUNT F	1	
-	77	22	PART NO	DESCRIPTION	ITEM NO

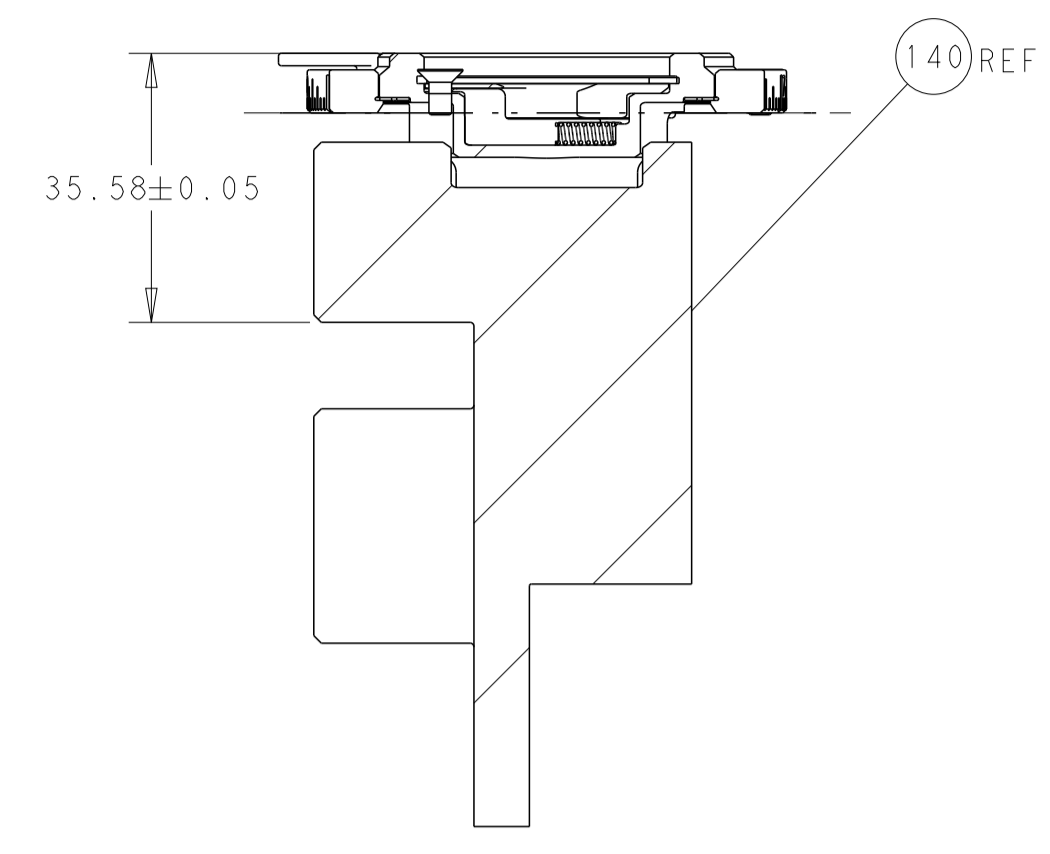
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mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES	FINISH	-	-	1:1	SHEET 3 OF 4
APPL INSTRUCTIONS 408-35043		APPL INSTRUCTIONS 408-35043		APPL INSTRUCTIONS 408-35043		APPL INSTRUCTIONS 408-35043		APPL INSTRUCTIONS 408-35043		APPL INSTRUCTIONS 408-35043	



Ocean End Feed
 Applicator

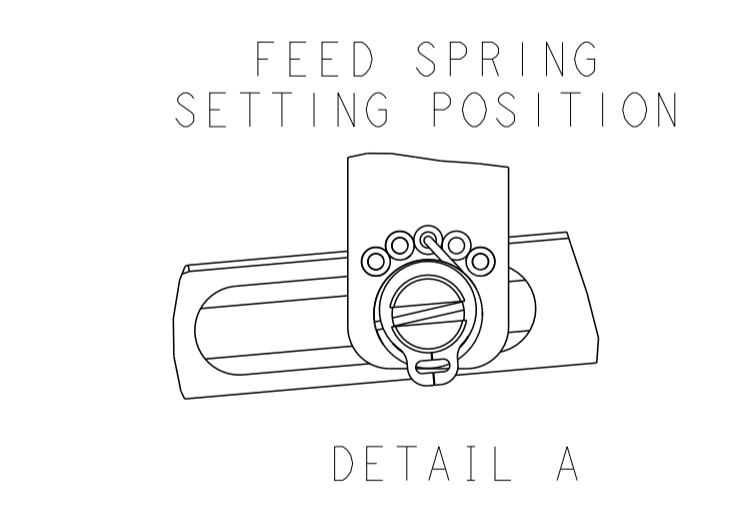
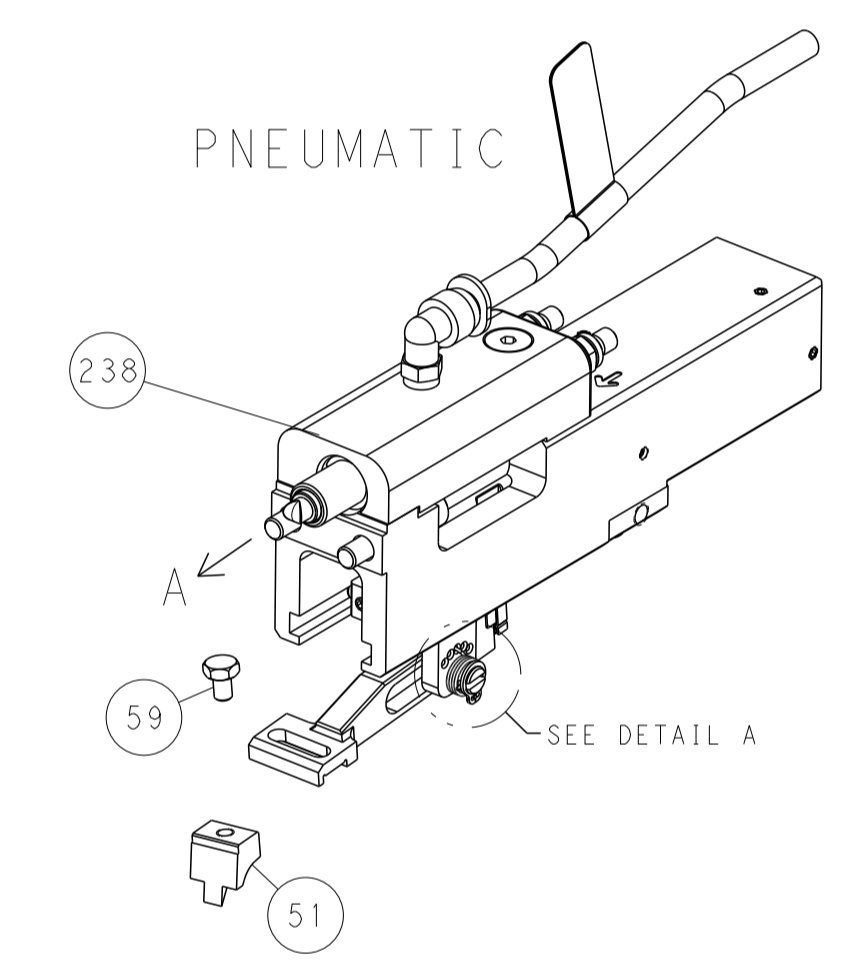
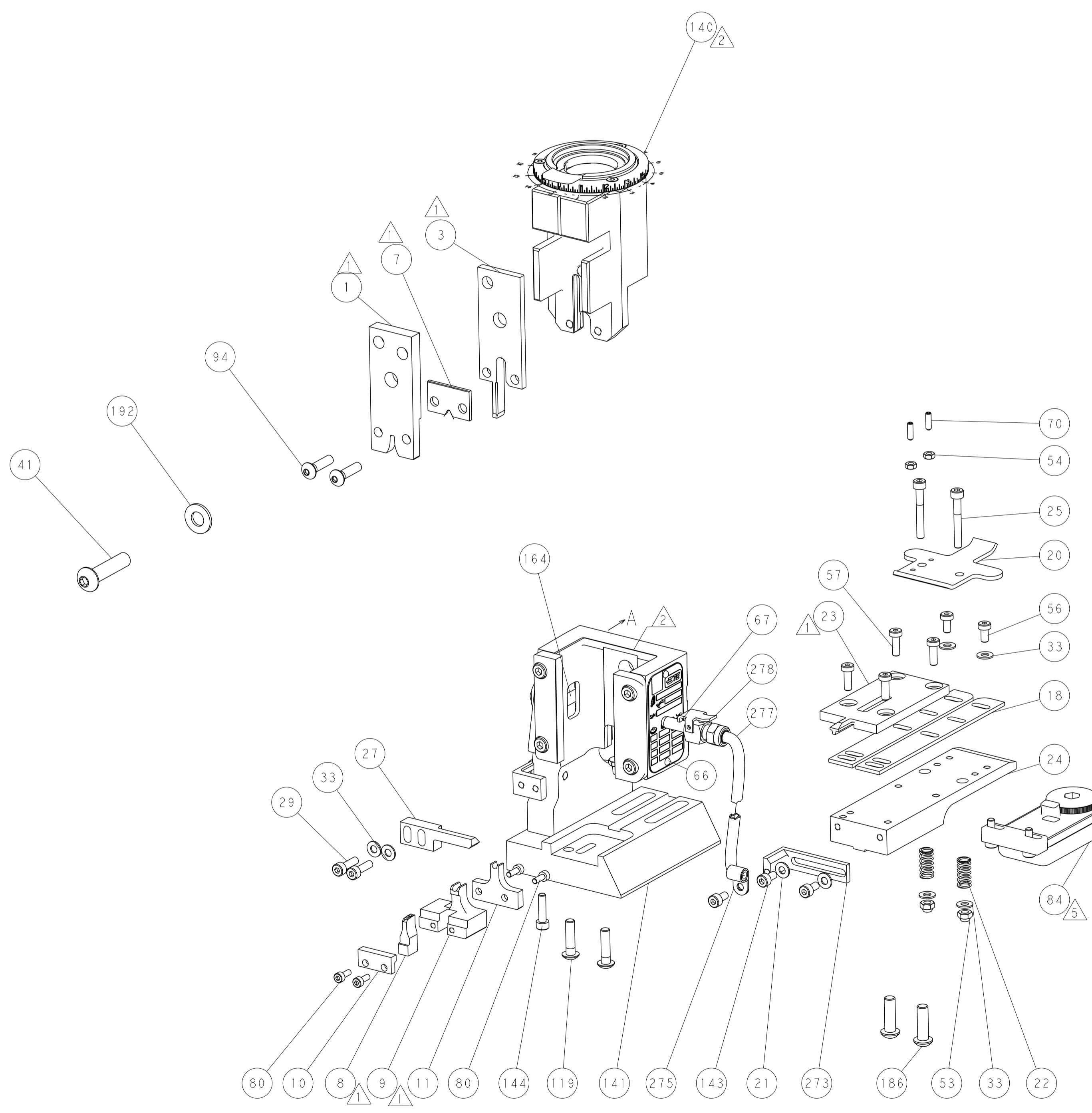
Customer Accessible Production Drawing

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

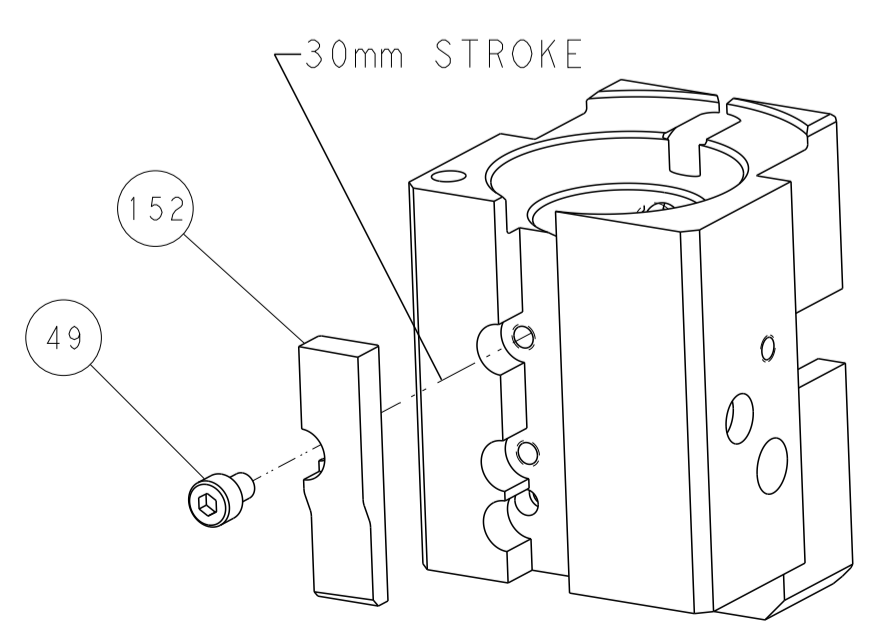


RAM SET-UP

FEED TYPE



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)

<small>THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION 2016. COPYRIGHT 2016 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.</small>		DMN: B. WEAVER 02FEB2016 CHK: G. BAILEY 02FEB2016 APVD: G. BAILEY 02FEB2016	TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.1 1 PLC ±.15 2 PLC ±.2 3 PLC ±.25 4 PLC ±.3 ANGLES ±.5° MATERIAL: - FINISH: -		NAME: Ocean End Feed Applier PRODUCT SPEC: - APPLICATION SPEC: - WEIGHT: - SCALE: 1:1	SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2150115 SHEET: 4 OF 4 REV: C RESTRICTED TO: -
AMP 4805 REV 31MAR2000		Customer Accessible Production Drawing	