

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150379-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2150379-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150379-1	C	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2150379-2	C	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150379-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.54 mm [.100]	F
INSUL	-	-

APPLICATOR INSTRUCTIONS 408-35043

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION			
TERMINAL NAME: RING			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
3.58-4.34 mm [.141-.171 IN]		-	
TERMINAL APPLICATION SPECIFICATION		114-2084	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
40668	40777	40816	

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
16 AWG	1.70 +/- 0.050 [.067 +/- .002]	4.6
18 AWG	1.52 +/- 0.050 [.060 +/- .002]	6.6
20 AWG	1.42 +/- 0.050 [.056 +/- .002]	7.6

- 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 LUBRICANT IS RECOMMENDED.
- 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	OWN	APVD
		1		ORIGINAL	09OCT2013	GH	TE
		A		RELEASED	18NOV2013	GH	TE
		B		ECR-20-005341	13APR2020	FZ	TE
		C		ECR-23-177592	06JUN2023	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	
-	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164	
	-	1	1	1	1	2119955-2	ASSY, LUBRICATOR, END FEED	84
-	1	1	1	1	2-1803078-6	SPACER, PRECISION	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	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	5018030-1	NUT, HEX, REG, RoHS, M3	54	
-	2	2	2	2	986965-8	NUT, LOCK, HEX, TORQUE (M4)	53	
-	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	1803517-2	RAM ASSEMBLY, EF ATLANTIC	44	
-	1	1	1	1	1803602-4	SCR, BHSC, RoHS (M8 X 30)	41	
-	8	8	8	8	1-18028-2	WASHER, FLAT, REG M4	33	
-	2	2	2	2	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	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	1901696-1	STRIP GUIDE, REAR	19	
-	1	1	1	1	1901695-1	STRIP GUIDE, FRONT	18	
-	4	4	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17	
	-	1	1	1	240644-9	PLATE, REAR SHEAR	11	
	-	1	1	1	5-690482-6	PLATE, FRONT SHEAR	9	
	1	2	2	1	1	1803002-4	ANVIL, COMBINATION, END FEED	8
	-	1	1	1	1	2-459722-7	BLADE, SHEAR	7
-	-	-	-	-	-	-	6	
-	-	-	-	-	-	-	4	
-	-	-	-	-	-	-	3	
-	-	-	-	-	-	-	2	
	1	2	2	1	1	456407-8	CRIMPER, WIRE PREMIUM	1
-	77	72	71	2	-	1	1	

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 1 OF 4
APPLICATOR SPEC		APPLICATION SPEC		MATERIAL		FINISH		WEIGHT		SCALE	
APPLICATOR SPEC		APPLICATION SPEC		MATERIAL		FINISH		WEIGHT		SCALE	

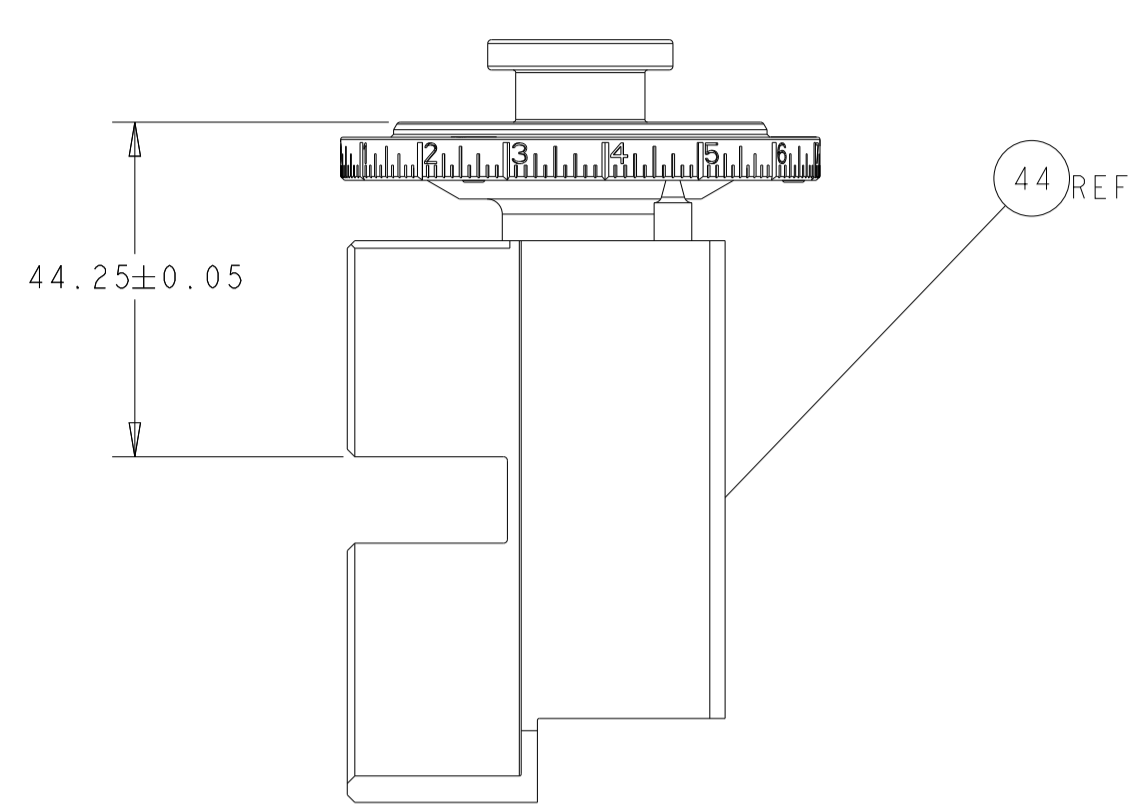
STE TE Connectivity
 Harrisburg, PA 17105-3608

Ocean End Feed Applicator

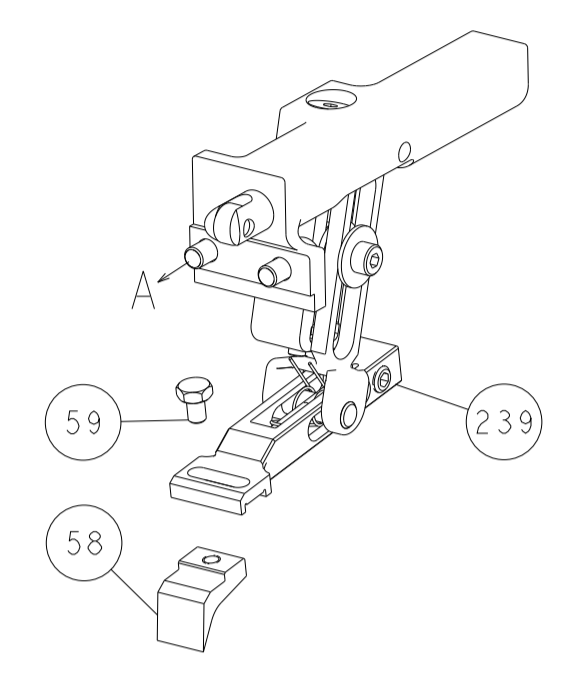
Customer Accessible Production Drawing

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

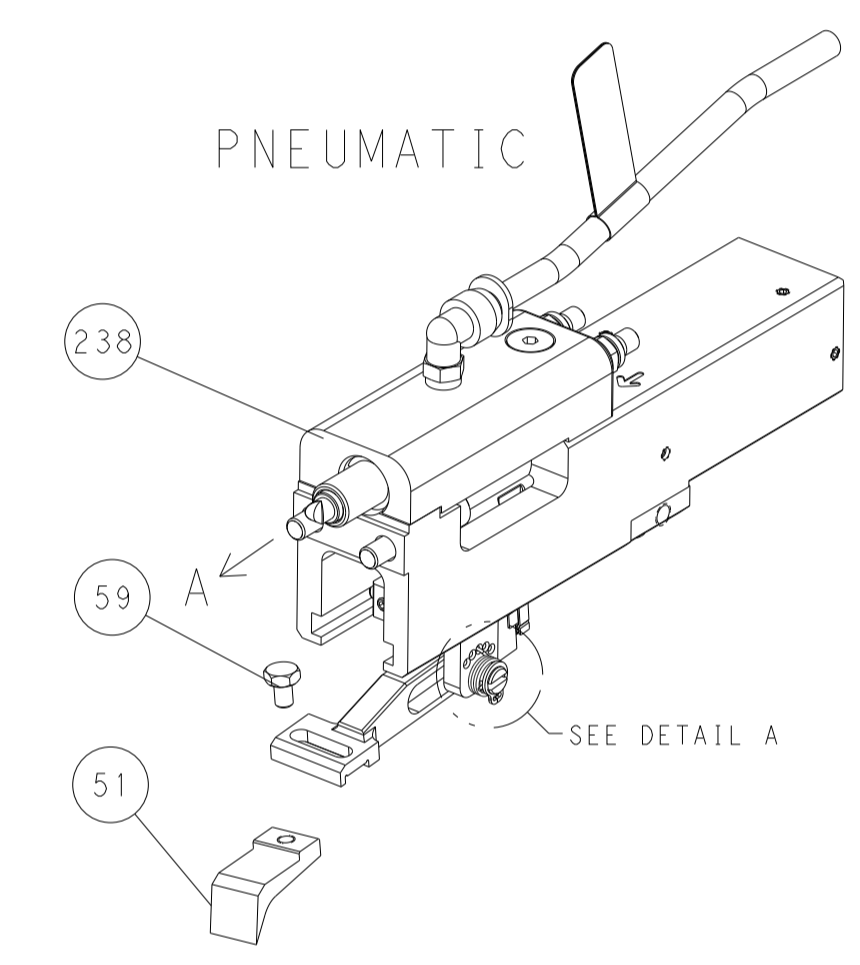
FEED TYPE MECHANICAL



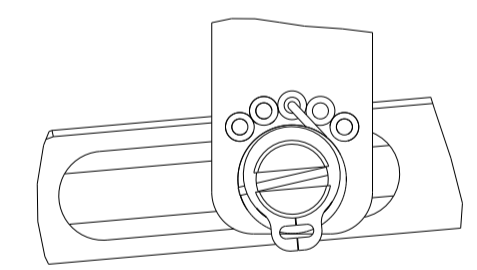
RAM SET-UP



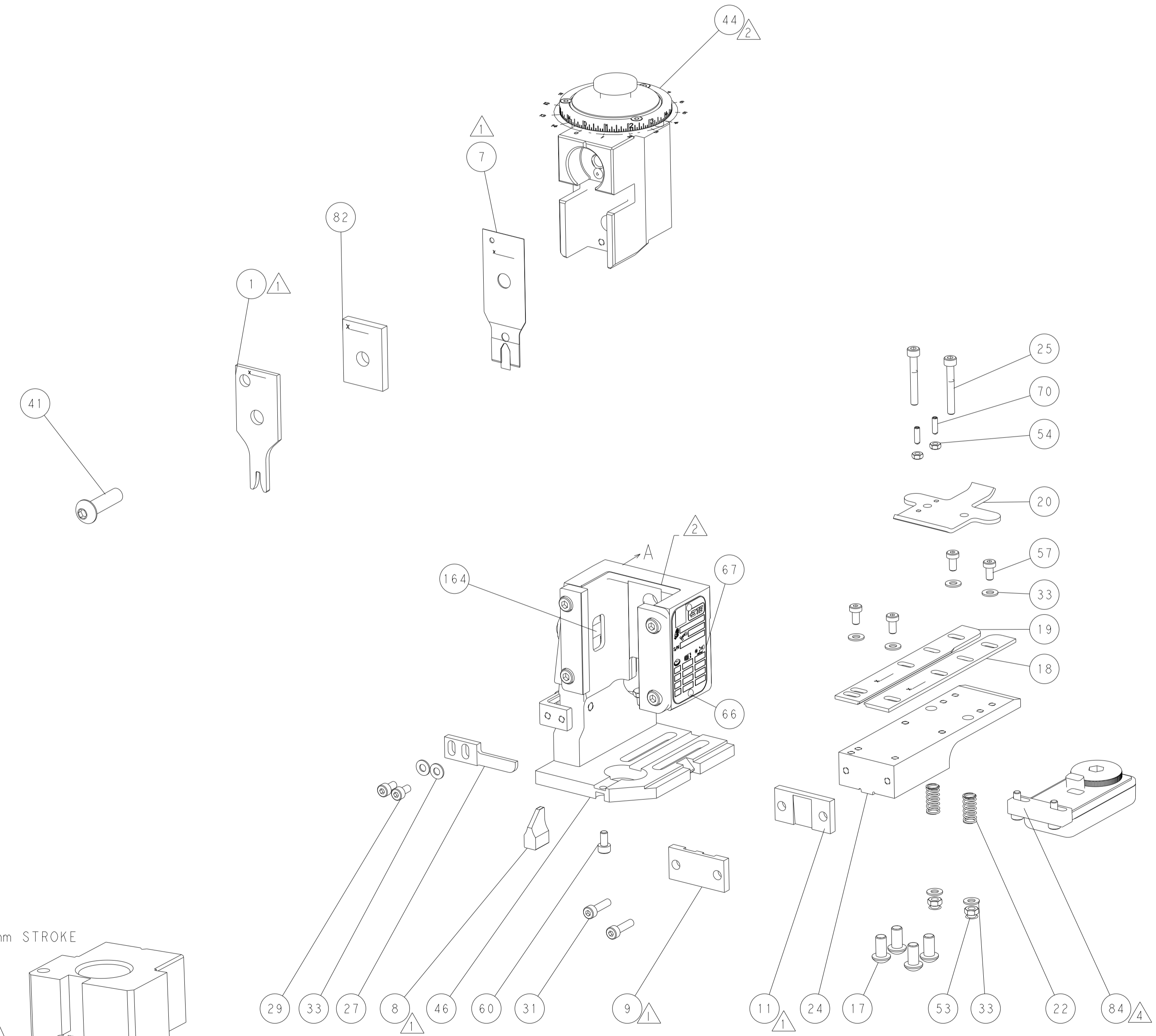
PNEUMATIC



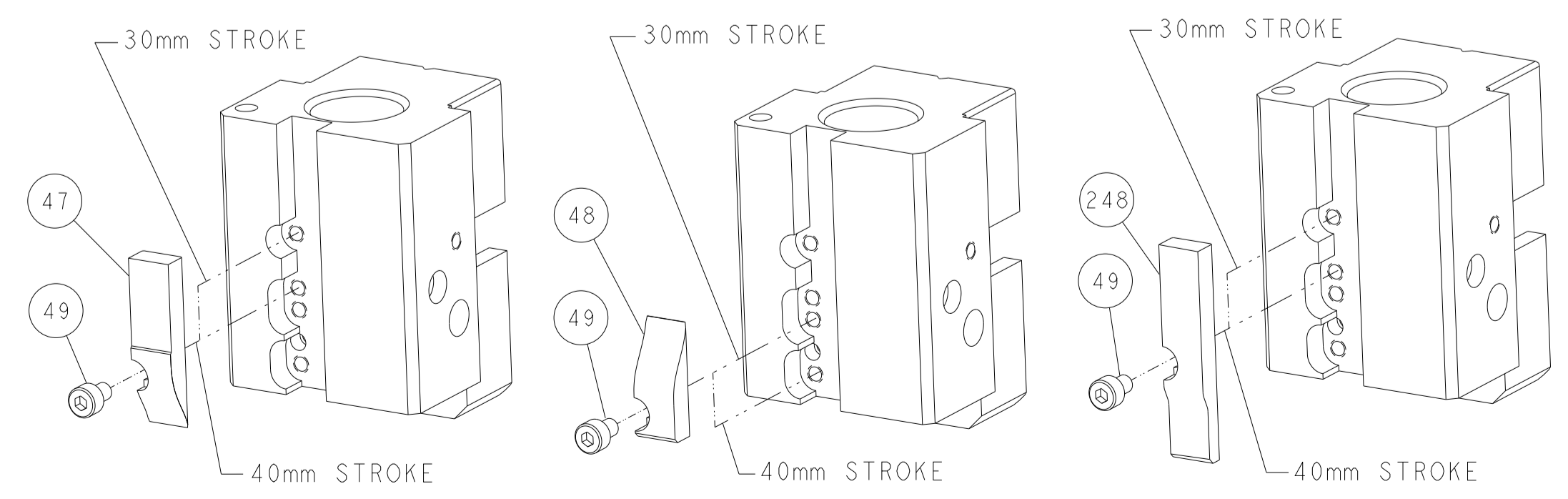
FEED SPRING
SETTING POSITION



DETAIL A



CAM POSITIONS



MECHANICAL
POST FEED

MECHANICAL
PRE FEED

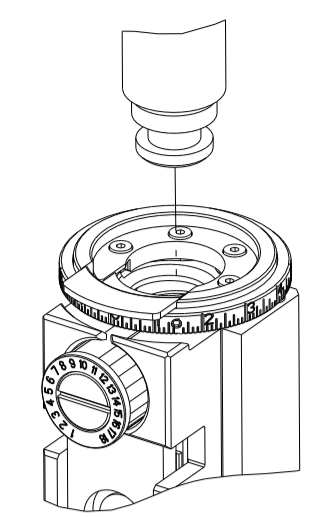
AIR FEED

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

<small>THIS DRAWING IS A CONTROLLED DOCUMENT FROM TYCO ELECTRONICS CORPORATION. IT IS THE PROPERTY OF TYCO ELECTRONICS CORPORATION AND IS NOT TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, INCLUDING PHOTOCOPYING, RECORDING, OR BY ANY INFORMATION STORAGE AND RETRIEVAL SYSTEM, WITHOUT THE WRITTEN PERMISSION OF TYCO ELECTRONICS CORPORATION.</small>		DWN: HOFFNER 09OCT2013 CHK: TELBIN 09OCT2013 APVD: TELBIN 09OCT2013	TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH ±		NAME: Ocean End Feed Applicator APPLICATION SPEC: - PRODUCT SPEC: -	RESTRICTED TO: - SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2150379 SCALE: 1:1 SHEET: 2 of 4 REV: C
MATERIAL: - FINISH: -		WEIGHT: - CUSTOMER ACCESSIBLE PRODUCTION DRAWING	SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150379-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2150379-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150379-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
 INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.54 mm [.100]	F
INSUL	-	-

APPLICATOR INSTRUCTIONS
 408-35043

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: RING			
WIRE STRIP LENGTH 3.58-4.34 mm [.141-.171 IN]		INSULATION DIAMETER RANGE Ø -	
TERMINAL APPLICATION SPECIFICATION 114-2084		-	
TERMINALS APPLIED 4			
TE TERMINAL 40668	TE TERMINAL 40777	TE TERMINAL 40816	TE TERMINAL

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
16 AWG	1.70 +/- 0.050 [.067 +/- .002]	4.6
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- 1 RECOMMENDED SPARE PARTS
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*WARNING
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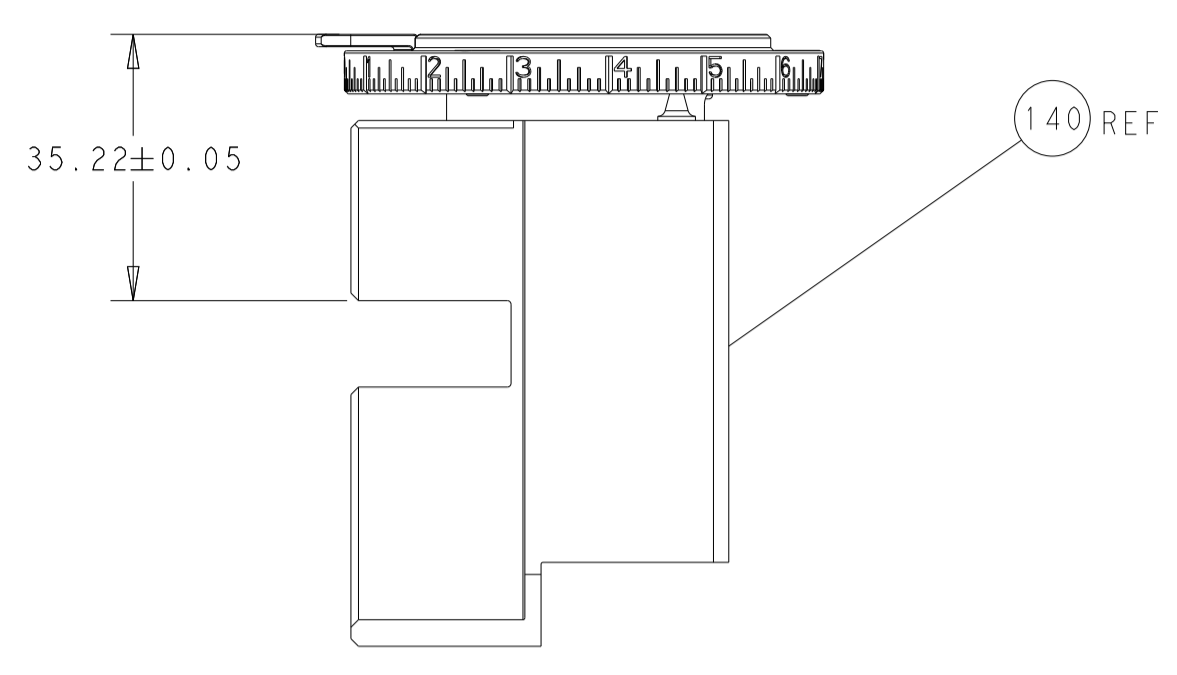
PACIFIC VERSION
 Shown on sheets 3 of 4 & 4 of 4
 (Atlantic version shown on sheets 1 of 4 & 2 of 4)

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

-	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	1	-	2844940-3	AIR FEED MODULE	238
-	4	4	2079383-9	SCR, BHSC, RoHS (M6 X 20)	186
-	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	1803518-2	RAM ASSEMBLY, EF PACIFIC	140
4	-	1	2119955-2	ASSY, LUBRICATOR, END FEED	84
-	1	1	2-1803078-6	SPACER, PRECISION	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	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	5018030-1	NUT, HEX, REG, RoHS, M3	54
-	2	2	986965-8	NUT, LOCK, HEX, TORQUE (M4)	53
-	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	1803602-4	SCR, BHSC, RoHS (M8 X 30)	41
-	8	8	1-18028-2	WASHER, FLAT, REG M4	33
-	2	2	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	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
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-	1	1	1901696-1	STRIP GUIDE, REAR	19
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-	1	1	240644-9	PLATE, REAR SHEAR	11
1	-	1	5-690482-6	PLATE, FRONT SHEAR	9
1	1	1	1803002-4	ANVIL, COMBINATION, END FEED	8
1	-	1	2-459722-7	BLADE, SHEAR	7
-	-	-	-	-	6
-	-	-	-	-	4
-	-	-	-	-	3
-	-	-	-	-	2
1	1	1	456407-8	CRIMPER, WIRE PREMIUM	1

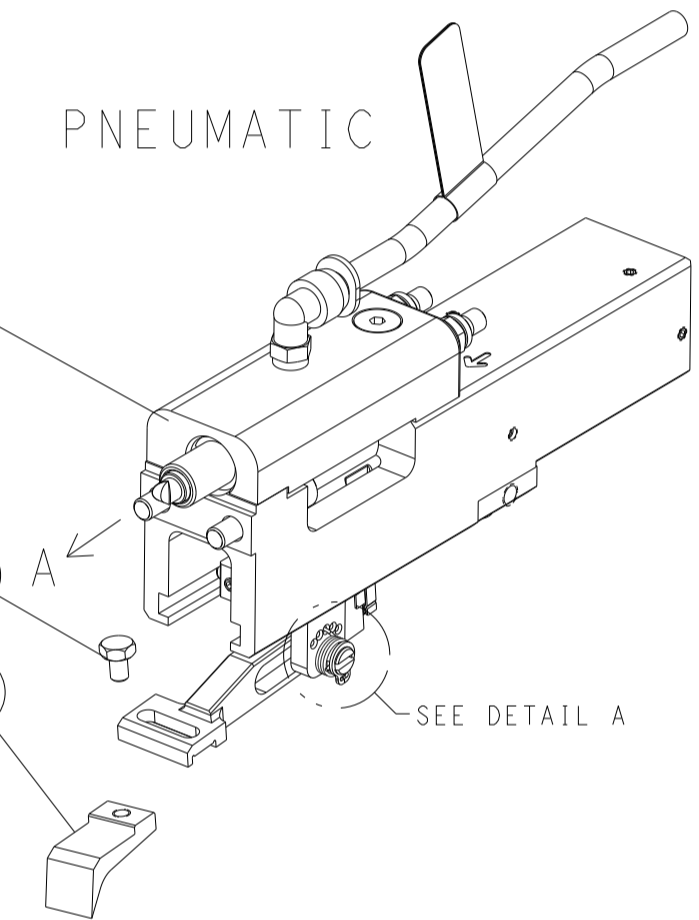
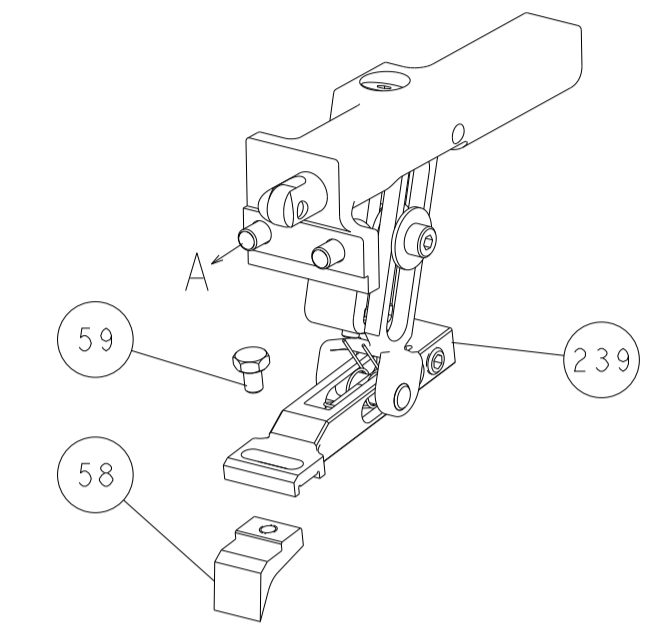
DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH ±		DWN: HOFFNER 09OCT2013 CHK: T. ELBIN 09OCT2013 APVD: T. ELBIN 09OCT2013 PRODUCT SPEC APPLICATION SPEC WEIGHT: - SCALE: 1:1		NAME: Ocean End Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: C-2150379 SHEET 3 OF 4	
MATERIAL: -				RESTRICTED TO: - Customer Accessible Production Drawing			

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

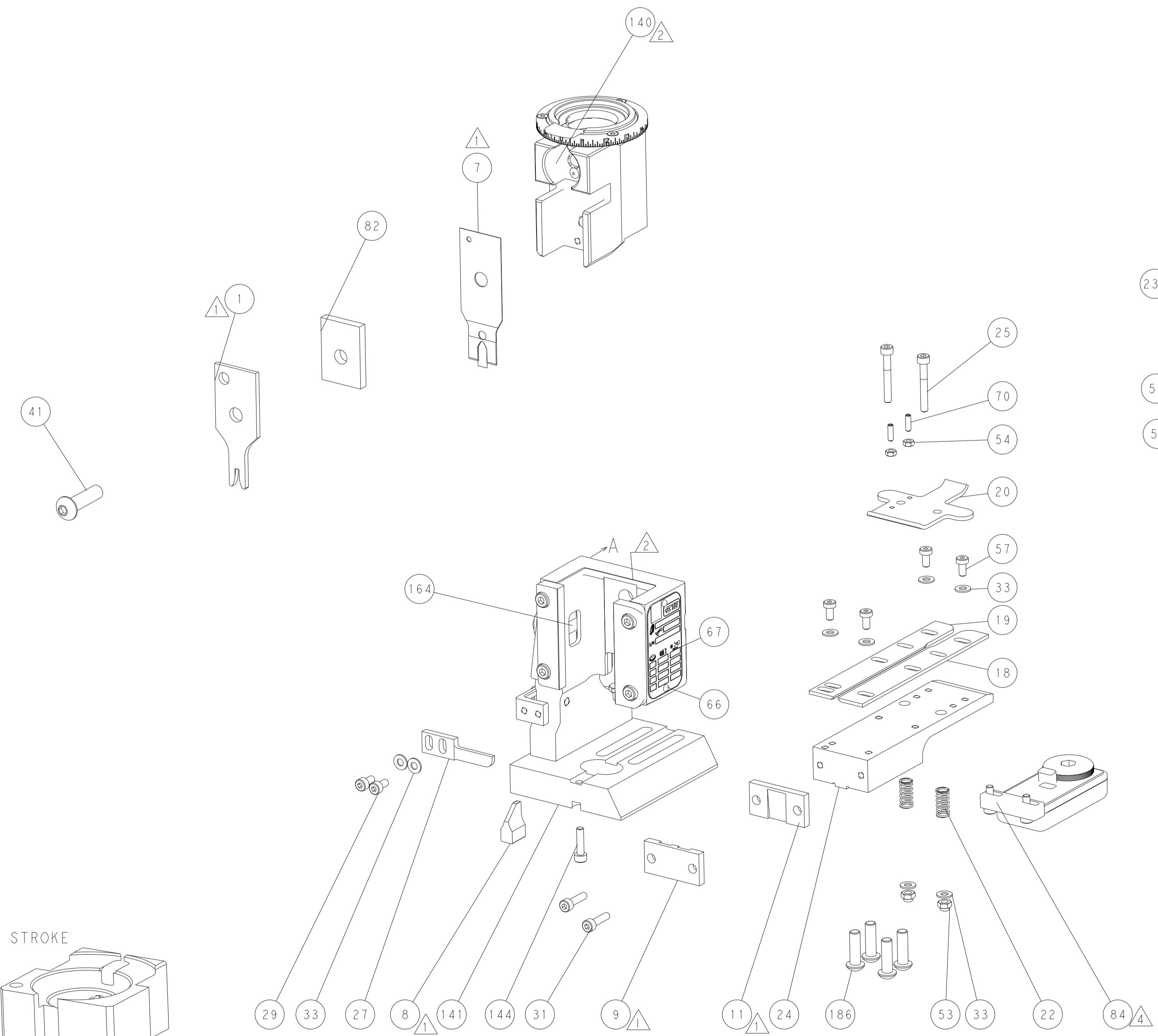
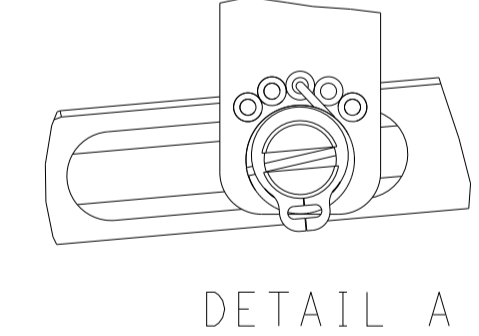


RAM SET-UP

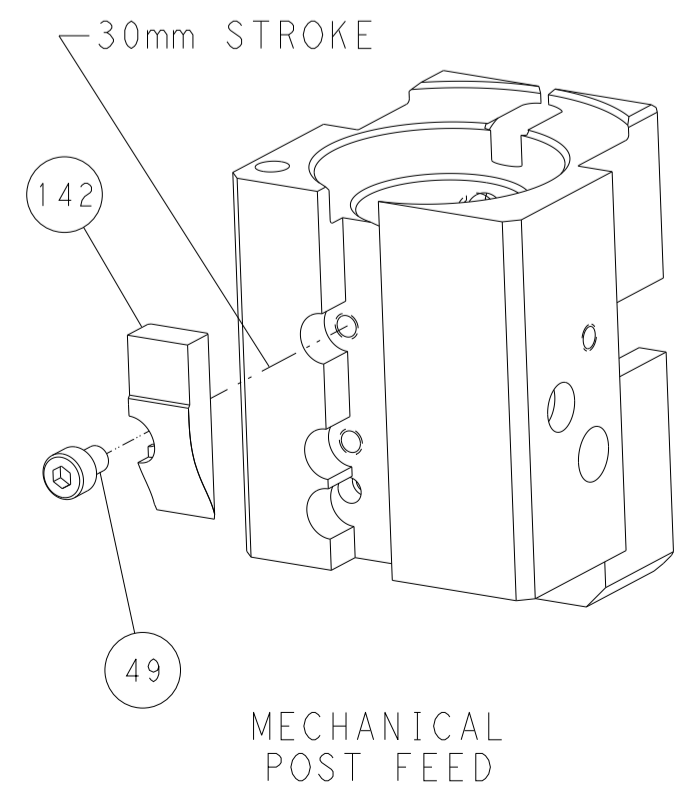
FEED TYPE
MECHANICAL



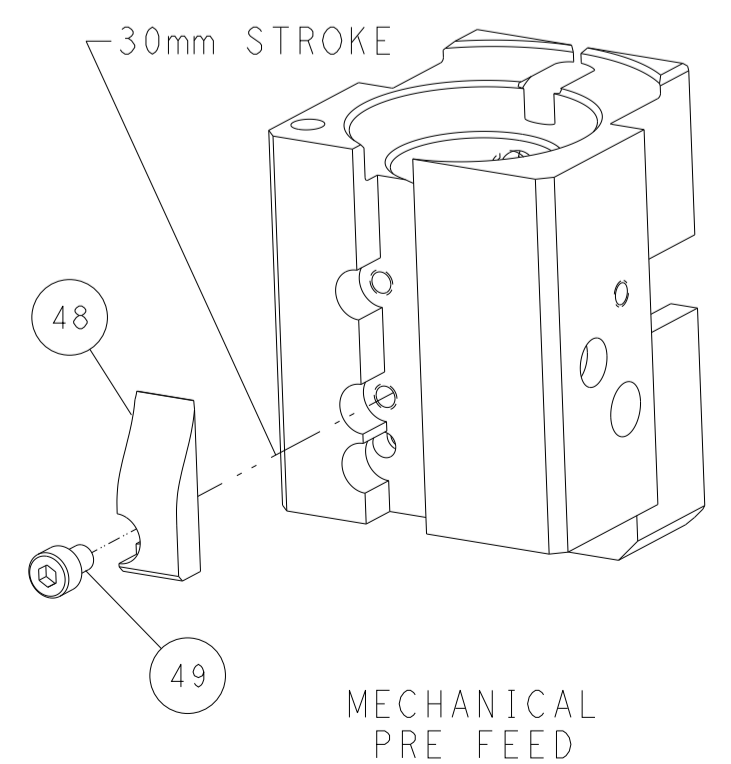
FEED SPRING
SETTING POSITION



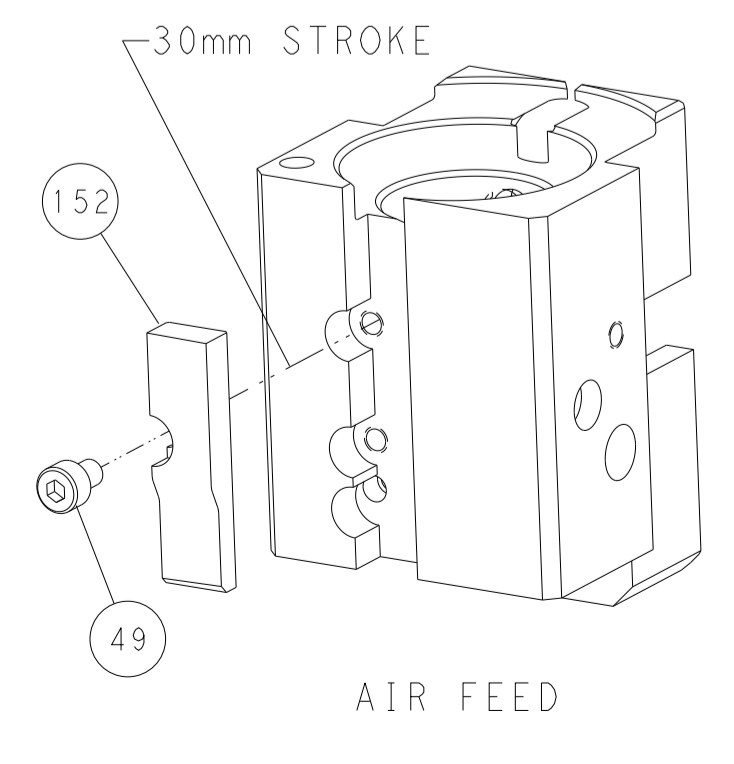
CAM POSITIONS



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)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		OWN: HOFFNER 09OCT2013		TE Connectivity	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	5 PLC ±	Harrisburg, PA 17105-3608
	ANGLES ±	FINISH ±		APVD: T. ELBIN 09OCT2013	NAME: T. ELBIN	Ocean End Feed Applicator	
MATERIAL:				PRODUCT SPEC:	APPLICATION SPEC:	SIZE: A1	CAGE CODE: 00779
				WEIGHT:	SCALE: 1:1	DRAWING NO: C-2150379	RESTRICTED TO: C