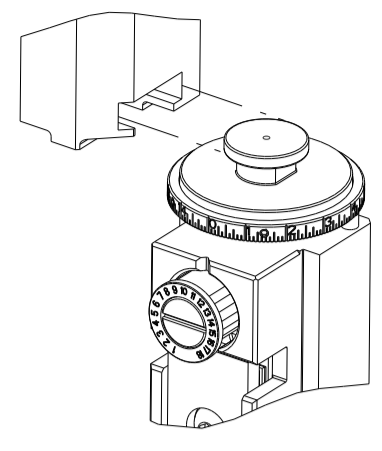


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150380-1	F	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2150380-2	F	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150380-1	F	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2150380-2	F	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150380-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.79 mm [.110]	F
INSUL	4.06 mm [.160]	F

APPLICATOR INSTRUCTIONS 408-35043

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION			
TERMINAL NAME: RING			
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE		
5.08-5.97 mm [.200-.235 IN]	∅2.54-3.56 mm [.100-.140 IN]		
TERMINAL APPLICATION SPECIFICATION	114-2084		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
60770-1	60770-2	60771-1	60771-2
60771-3	60772-1	60772-2	60773-2
60774-1	60774-2	60775-1	60775-2

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
14 AWG	1.88+/-0.05 [.074+/-0.002]	4.5
16 AWG	1.70+/-0.05 [.067+/-0.002]	6.4
1.00mm ²	1.60+/-0.05 [.063+/-0.002]	7.4
18 AWG	1.52+/-0.05 [.060+/-0.002]	8.3

- 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 TERMINAL LUBRICANT IS RECOMMENDED.
- 6. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- 7 SPADE TERMINALS ARE NOT FLANGED DURING APPLICATION IN THIS APPLICATOR.

***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.

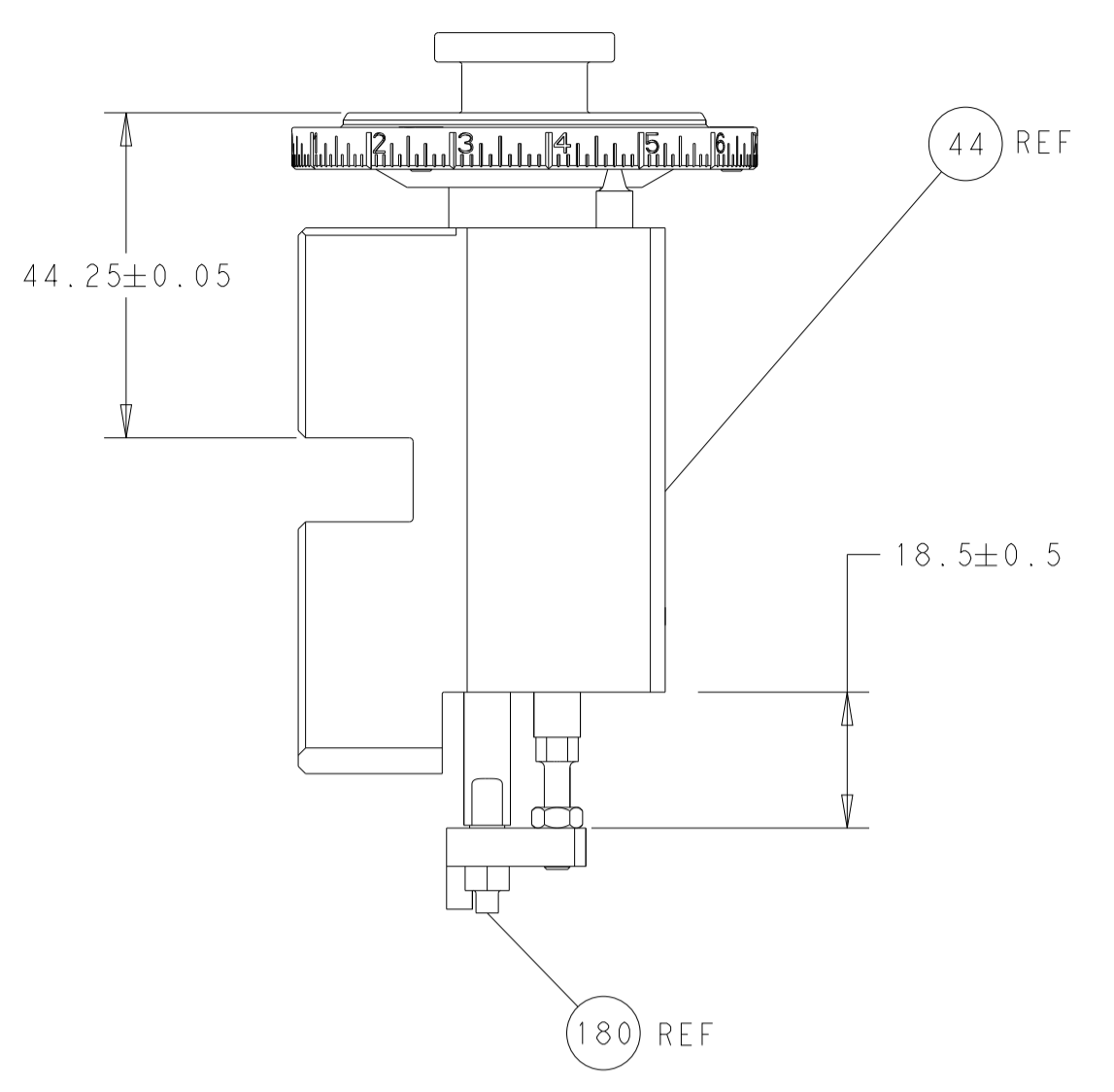
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		D		ECR-17-005730	20APR2017	TB	TE
		E		ECR-18-014674	16SEP2018	TB	TE
		F		ECR-21-121119	17NOV2021	FZ	RK

-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248	
-	1	1	1	1	2119082-7	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	1-1976055-0	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	2079383-5	SCR, BHSC, RoHS (M4 X 20)	92	
5	-	1	1	1	2119955-2	ASSY, LUBRICATOR, END FEED	84	
-	1	1	1	1	455888-7	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	1901681-1	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	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	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	-	2063961-1	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	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	
-	1	1	1	1	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	1-1752371-2	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	1	4-240641-6	SPACER	16	
-	1	1	1	1	1752360-1	SPACER,HOLD-DOWN	13	
1	-	1	1	1	240644-5	PLATE, REAR SHEAR	11	
-	2	2	2	2	240645-8	SPACER, SHEAR PLATE	10	
1	-	1	1	1	2-240642-6	PLATE, FRONT SHEAR	9	
1	2	2	1	1	4-1633383-6	ANVIL, COMBINATION	8	
1	-	1	1	1	4-240651-2	BLADE, SLUG	7	
-	-	-	-	-	-	-	6	
-	1	1	1	1	4-240641-0	SPACER	5	
-	1	1	1	1	238011-2	BLOCK, CRIMPER SPACER	4	
1	2	2	1	1	6-1633961-4	CRIMPER, INSULATION F PREMIUM	3	
-	1	1	1	1	455888-4	SPACER, CRIMPER	2	
1	2	2	1	1	3-456408-8	CRIMPER, WIRE PREMIUM	1	
-	77	72	71	2	-1	PART NO	DESCRIPTION	ITEM NO

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

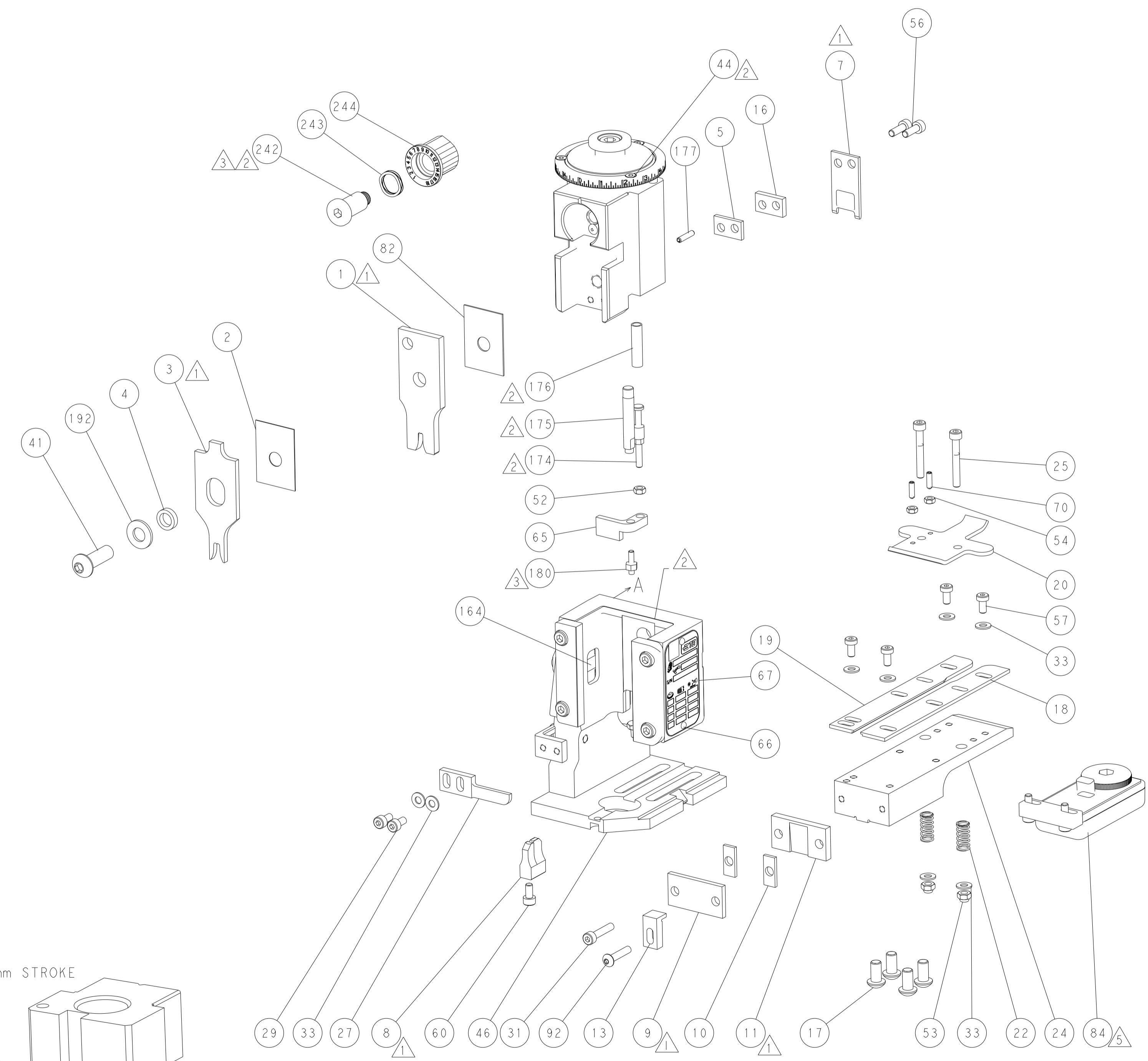
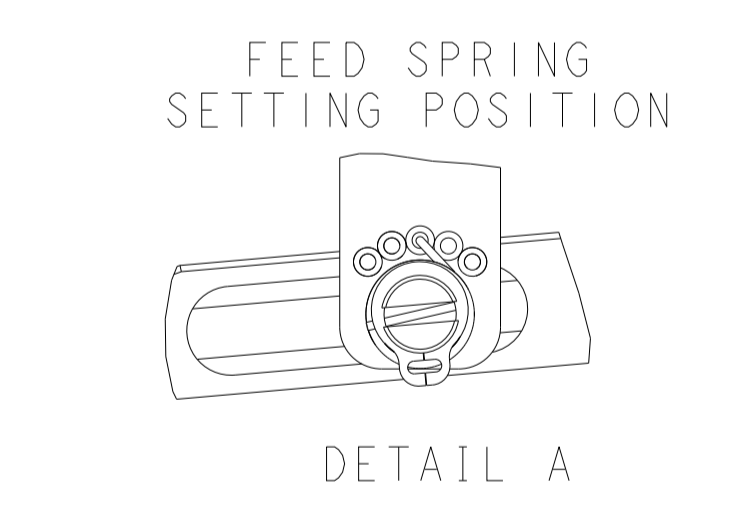
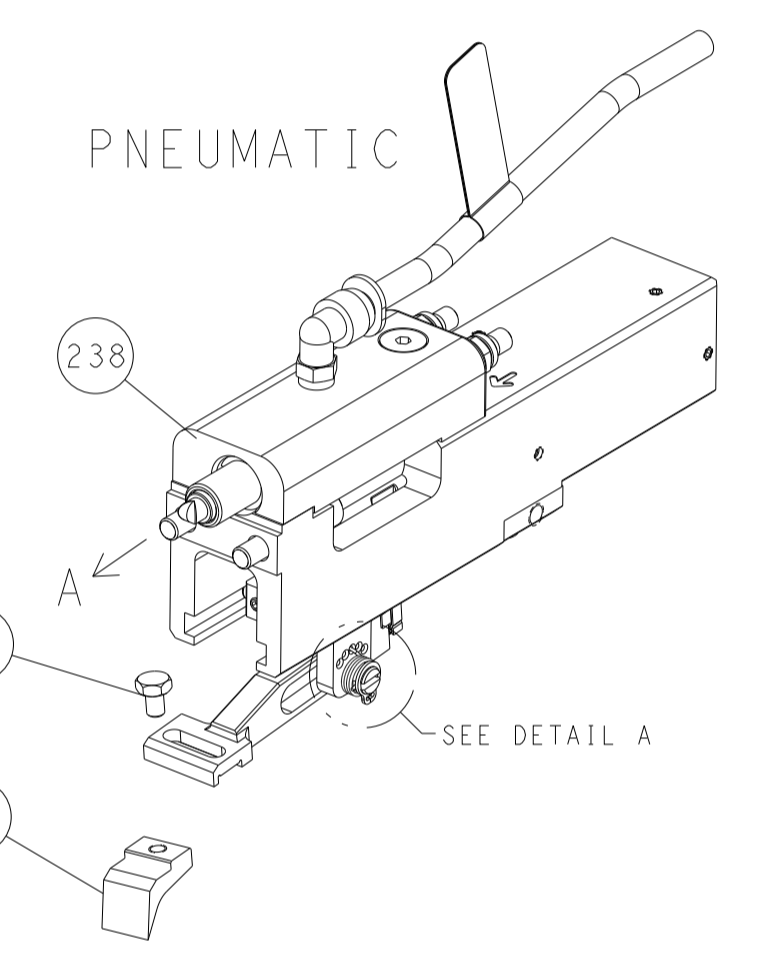
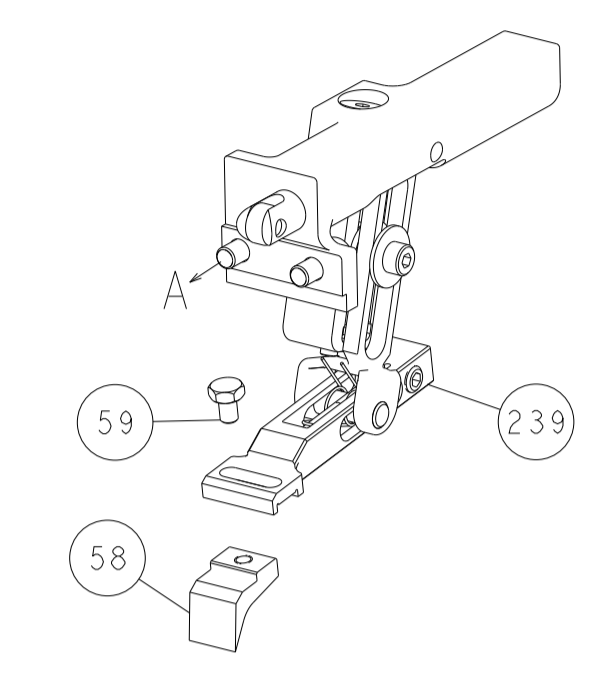
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN L. GROSS 10OCT2013		TE Connectivity Harrisburg, PA 17105-3608	
mm		0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH		CHK T. ELBIN 10OCT2013		NAME Ocean End Feed Applicator	
MATERIAL		WEIGHT		APVD M. CLIFFORD 10OCT2013		SIZE A1	
Customer Accessible Production Drawing		SCALE 1:1		PRODUCT SPEC		DRAWING NO 00779	
				APPLICATION SPEC		SHEET 1 OF 4	
				RESTRICTED TO		REV F	

LOC	DIST	REV	DESCRIPTION	DATE	OWN	APVD
A	66		SEE SHEET 1			

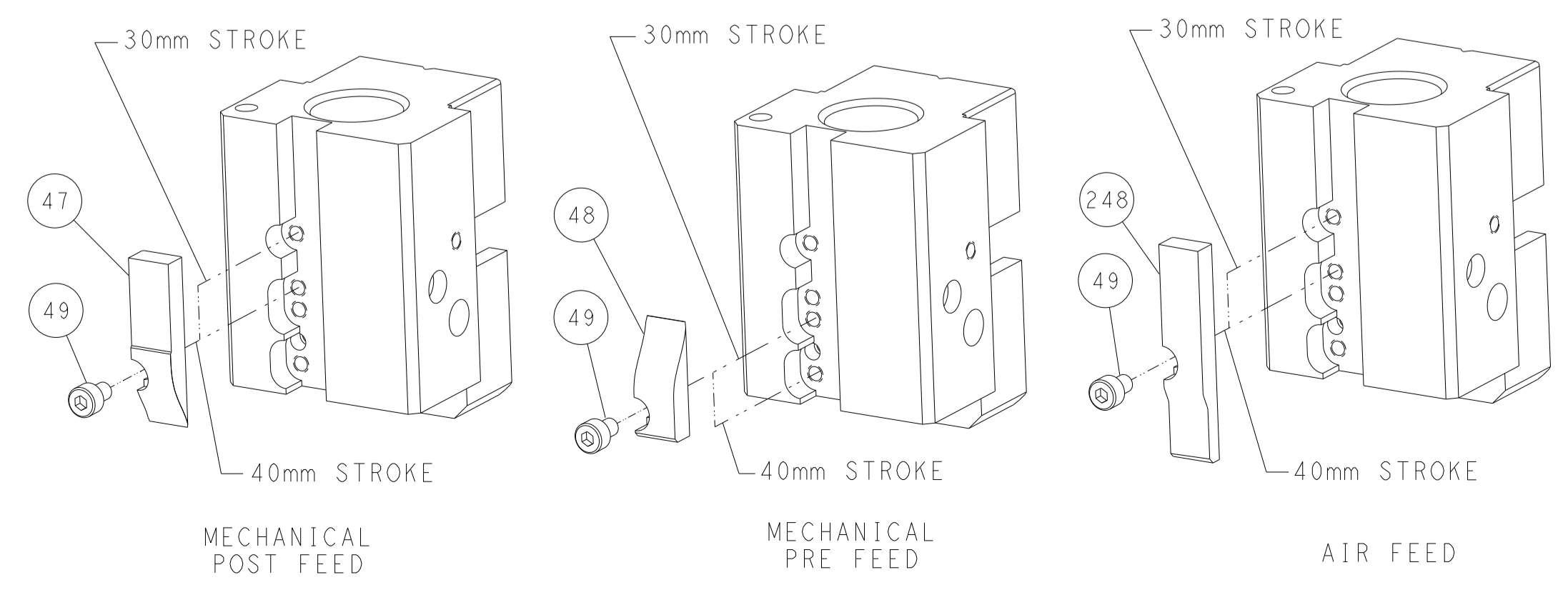


RAM AND HOLDDOWN SET-UP

FEED TYPE
MECHANICAL



CAM POSITIONS

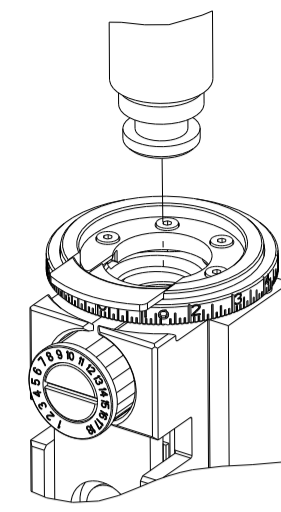


ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

<small>THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.</small>		DWN L. GROSS 10OCT2013 CHK T. ELBIN 10OCT2013 APVD M. CLIFFORD 10OCT2013	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 SIZE A1 CAGE CODE 00779 DRAWING NO. C=2150380 RESTRICTED TO
MATERIAL:		WEIGHT:	SCALE 1:1 SHEET 2 of 4 REV F

THIS DRAWING IS UNPUBLISHED.	RELEASED FOR PUBLICATION	20	
COPYRIGHT © BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.			
PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150380-1	F	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2150380-2	F	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150380-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.79 mm (.110)	F
INSUL	4.06 mm (.160)	F
APPLICATOR INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: RING			
WIRE STRIP LENGTH 5.08-5.97 mm (.200-.235 IN)		INSULATION DIAMETER RANGE Ø2.54-3.56 mm (.100-.140 IN)	
TERMINAL APPLICATION SPECIFICATION	114-2084	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
60770-1	60770-2	60771-1	60771-2
60771-3	60772-1	60772-2	60773-2
60774-1	60774-2	60775-1	60775-2

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
14 AWG	1.88 +/- 0.05 [0.074 +/- .002]	4.5
16 AWG	1.70 +/- 0.05 [0.067 +/- .002]	6.4
1.00mm2	1.60 +/- 0.05 [0.063 +/- .002]	7.4
18 AWG	1.52 +/- 0.05 [0.060 +/- .002]	8.3

- 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.
- TERMINAL LUBRICANT IS RECOMMENDED.
- 6. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- SPADE TERMINALS ARE NOT FLANGED DURING APPLICATION IN THIS APPLICATOR.

***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.

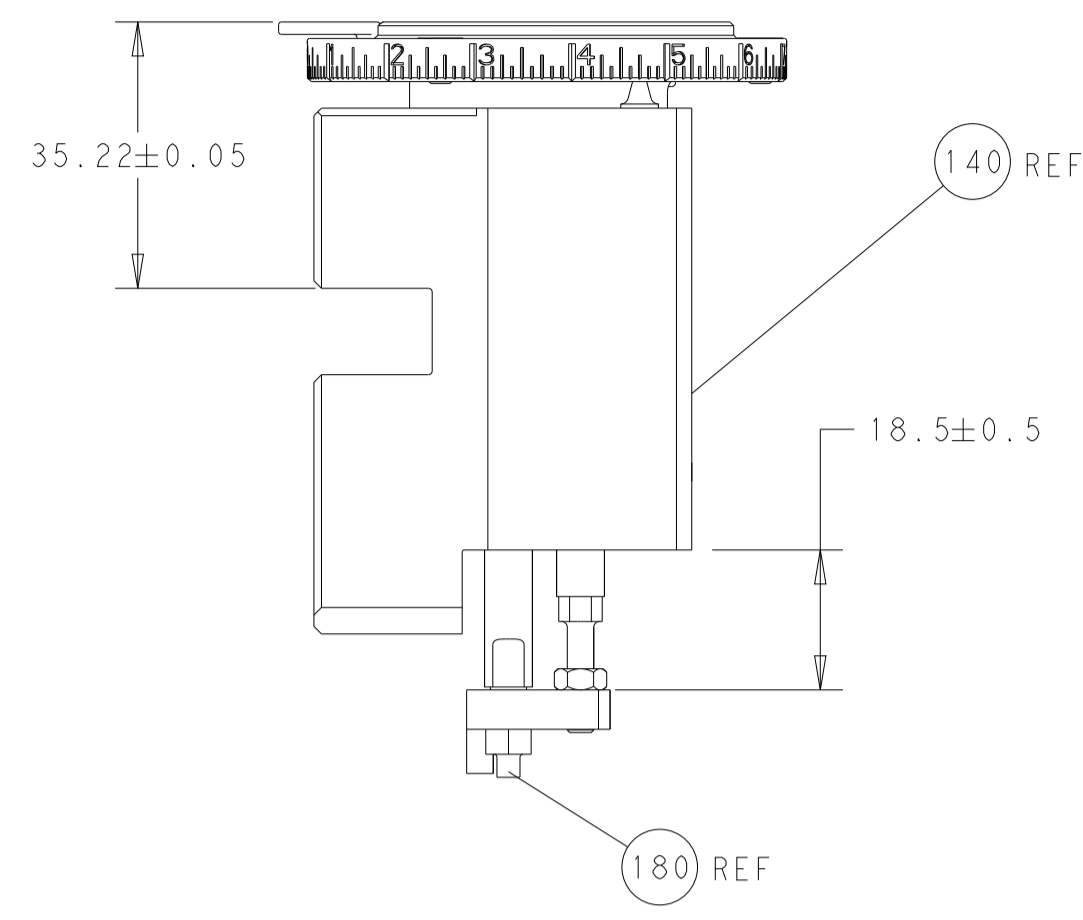
LOC	DIST	REVISIONS					
A	66	P	LTN	DESCRIPTION	DATE	DWN	APVD
-	-	-	-	SEE SHEET 1	-	-	-

-	1	1	2119082-7	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
	-	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	1-1976055-0	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	2079383-5	SCR, BHSC, RoHS (M4 X 20)	92
	-	1	2119955-2	ASSY, LUBRICATOR, END FEED	84
-	1	1	455888-7	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	1901681-1	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	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	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	-	2063961-1	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	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
-	8	8	1-18028-2	WASHER, FLAT, REG M4	33
-	1	1	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	1-1752371-2	PLATE, STRIP GUIDE	24
-	2	2	2-22281-3	SPRING, COMPRESSION	22
-	1	1	1803292-4	DRAG	20
-	1	1	1901696-1	STRIP GUIDE, REAR	19
-	1	1	1901695-1	STRIP GUIDE, FRONT	18
-	1	1	4-240641-6	SPACER	16
-	1	1	1752360-1	SPACER,HOLD-DOWN	13
	-	1	240644-5	PLATE, REAR SHEAR	11
	-	2	240645-8	SPACER, SHEAR PLATE	10
	-	1	2-240642-6	PLATE, FRONT SHEAR	9
	1	1	4-1633383-6	ANVIL, COMBINATION	8
	-	1	4-240651-2	BLADE, SLUG	7
-	-	-	-	-	6
-	1	1	4-240641-0	SPACER	5
-	1	1	238011-2	BLOCK, CRIMPER SPACER	4
	1	1	6-1633961-4	CRIMPER, INSULATION F PREMIUM	3
-	1	1	455888-4	SPACER, CRIMPER	2
	1	1	3-456408-8	CRIMPER, WIRE PREMIUM	1
-	77	22	21	PART NO	ITEM NO

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

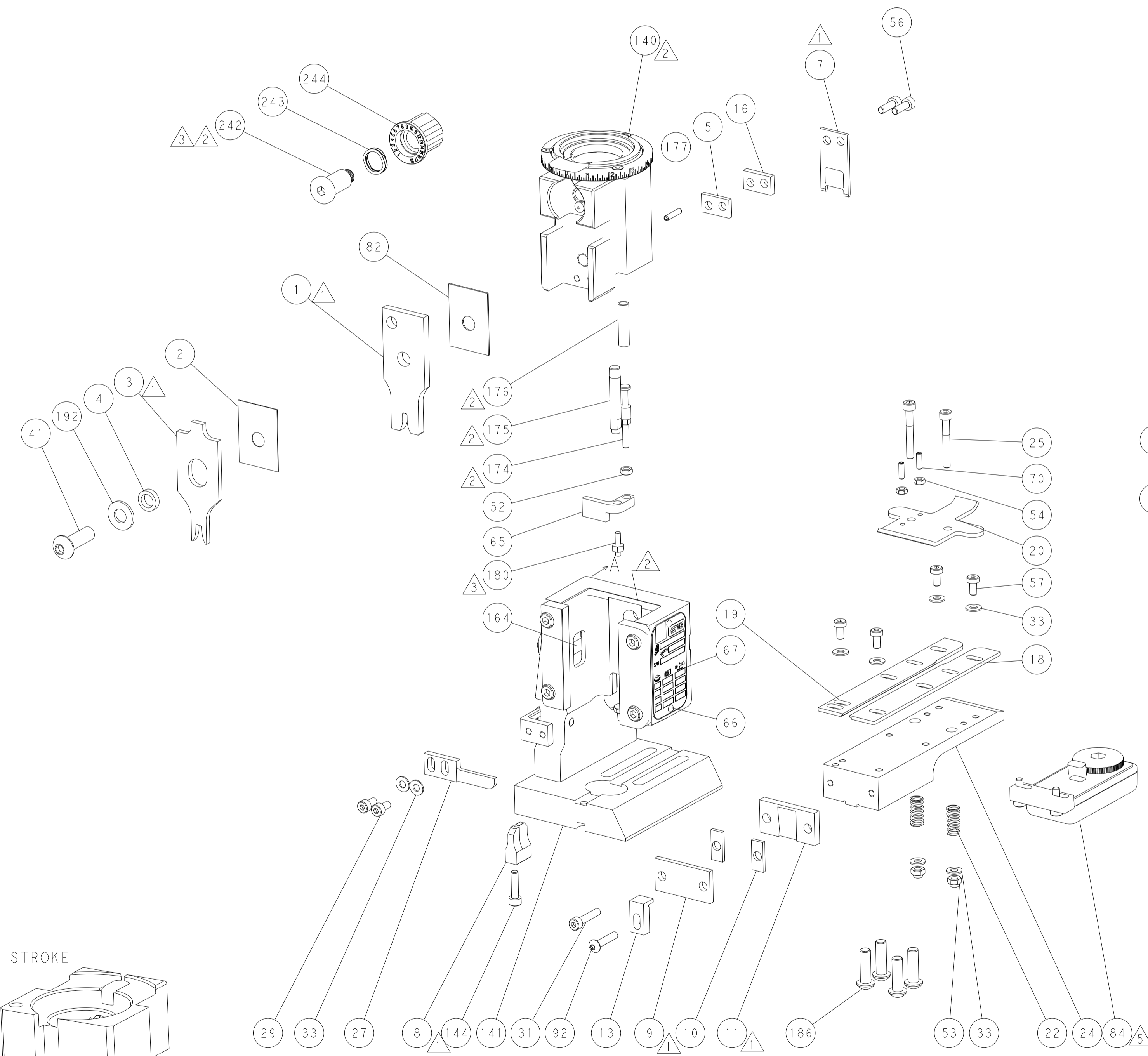
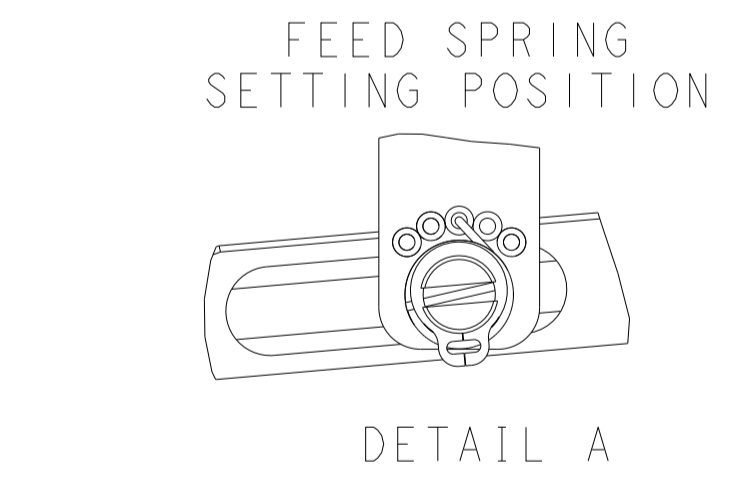
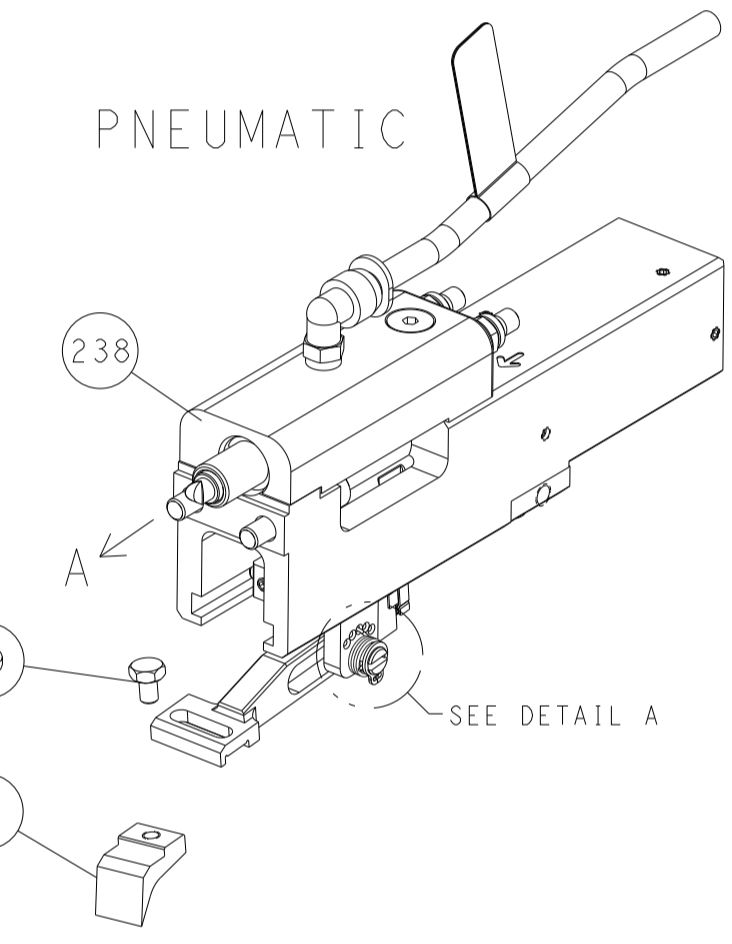
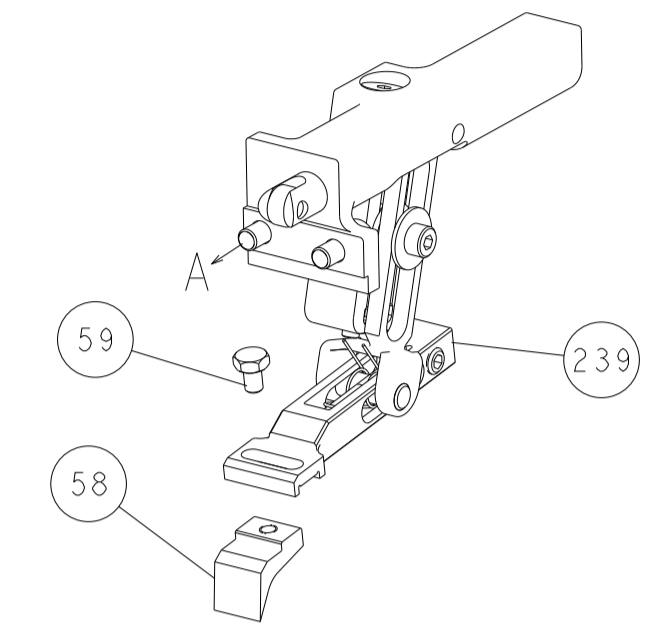
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN		TE Connectivity	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	5 PLC ±	Harrisburg, PA 17105-3608
	ANGLES	FINISH	OTHERWISE SPECIFIED:	DATE	APVD	NAME	
				10OCT2013	M. CLIFFORD	Ocean End Feed Applicator	
MATERIAL	WEIGHT	SCALE	RESTRICTED TO	SIZE	CAGE CODE	DRAWING NO	
		1:1		A1	00779	©=2150380	
Customer Accessible Production Drawing				SHEET	3	OF	4
				REV	F		

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

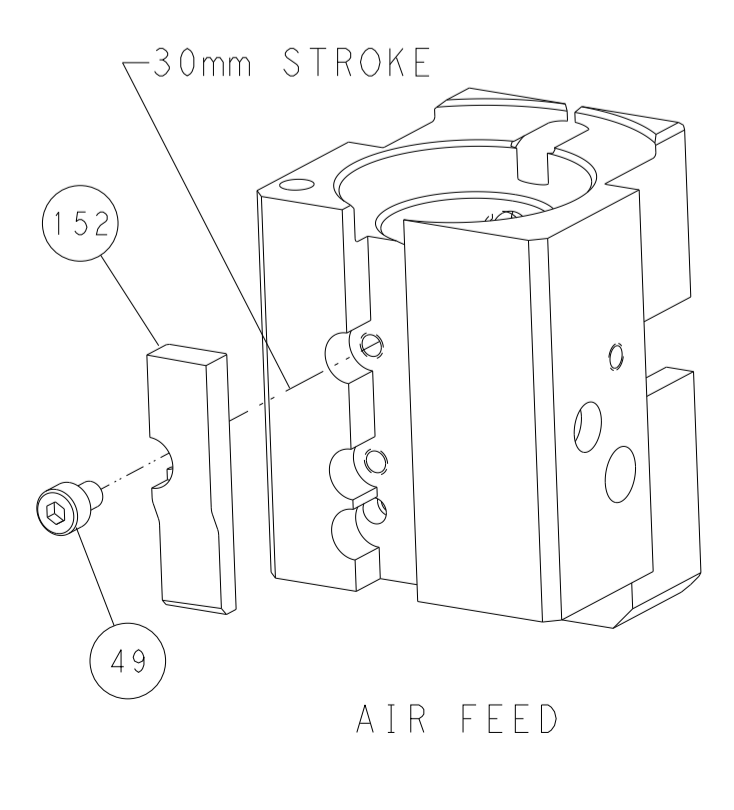
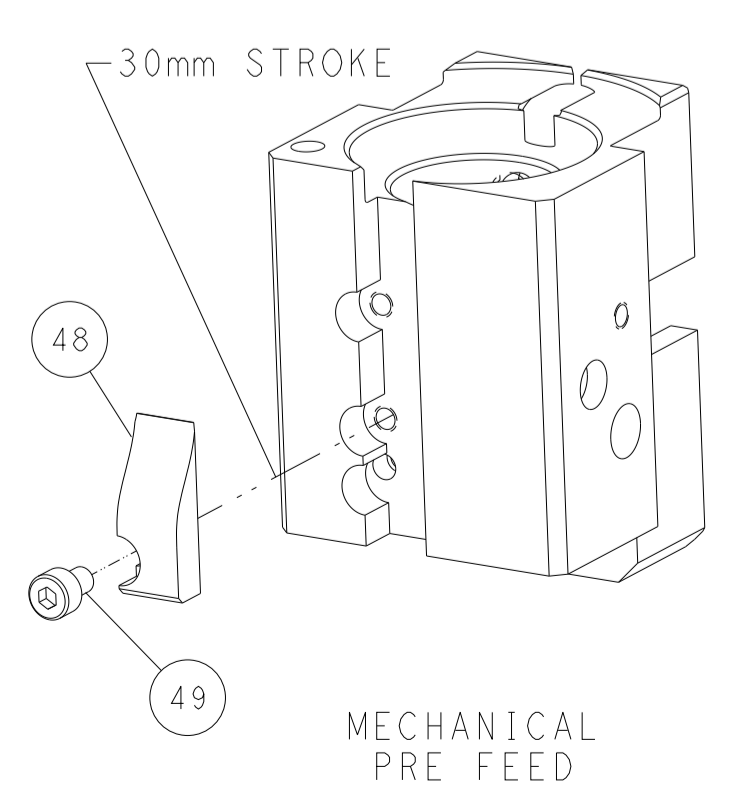
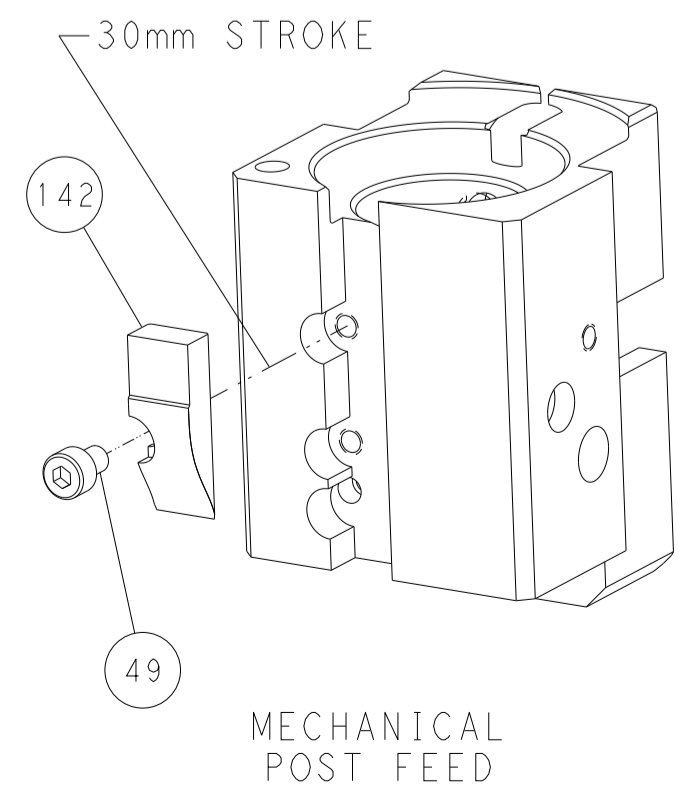


RAM AND HOLDDOWN SET-UP

FEED TYPE
MECHANICAL



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 L. GROSS 10OCT2013		TE Connectivity Harrisburg, PA 17105-3608	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	APVD M. CLIFFORD 10OCT2013	NAME Ocean End Feed Applier
MATERIAL:	FINISH:	WEIGHT:	SCALE 1:1	SHEET 4 OF 4	REV F	Customer Accessible Production Drawing	