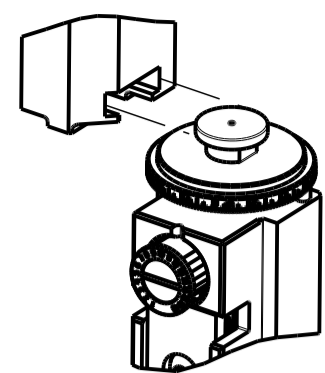


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150441-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150441-2	C	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150441-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.29 mm [.090]	F
INSUL	3.56 mm [.140]	F
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION
TERMINAL NAME: SPECIAL REC. CONTACT CLUSTER FOR PIN .090 DIA.		
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE
5.84-6.60 mm [.230-.260 IN]		∅1.30-2.40 mm [.051-.094 IN]
TERMINAL APPLICATION SPECIFICATION	114-2019	
TERMINALS APPLIED		
TE TERMINAL	TE TERMINAL	TE TERMINAL
1599105-1		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
18 AWG OR 0.75mm2	1.36+/-0.05 [.054+/- .002]	4.3
22 AWG OR 0.35mm2	1.23+/-0.05 [.048+/- .002]	6.0



- RECOMMENDED SPARE PARTS
- REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 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.
- UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- TERMINAL PITCH IS NOT COMPATIBLE WITH MECHANICAL FEED.

***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.

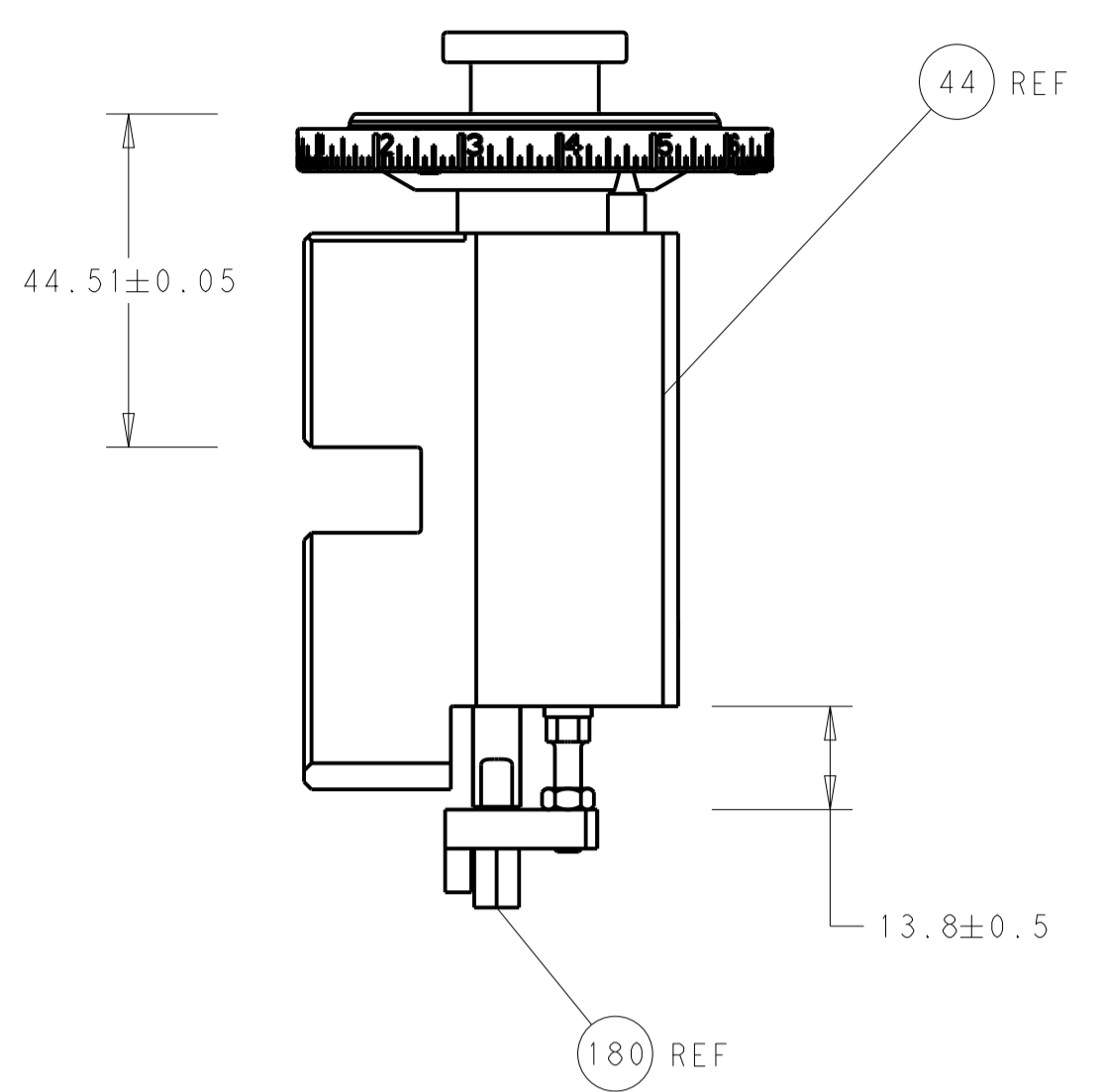
LOC	DIST	REVISIONS			
		REV	DATE	BY	APPV
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		B1	10SEP2015	JH	LZ
		B2	20OCT2015	YY	GB
		C	16FEB2021	JAH	RK

-	1	1	2119641-1	FEED CAM, AIR FEED	248
-	1	1	2119082-9	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	2844940-3	AIR FEED MODULE	238
-	1	1	1-18028-0	WASHER, FLAT, REG M8	192
3	-	1	1-1752354-6	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
-	1	1	455888-5	SPACER, CRIMPER	82
-	1	1	2119791-5	DEPRESSOR, WIRE	73
-	1	1	1803607-4	DOCUMENTATION PACKAGE	71
-	2	2	2-18032-2	SCR, SET, FLT PNT, M3 X 10.0	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	1901681-5	HOLDDOWN, TERMINAL	65
-	2	2	2168400-5	SHCS, LOW HEAD, RoHS, M4 X 20	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	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	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	1	2063961-1	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	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	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	240825-1	PLATE, STRIP HOLD DOWN	23
-	2	2	2-22281-3	SPRING, COMPRESSION	22
-	1	1	1803292-4	DRAG	20
-	2	2	1901259-5	GUIDE, LOWER STRIP	18
-	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17
-	1	1	5-240641-9	SPACER	16
-	1	1	1752360-1	SPACER, HOLD-DOWN	13
1	-	1	240644-1	PLATE, REAR SHEAR	11
-	-	-	-	-	10
1	-	1	690482-6	PLATE, FRONT SHEAR	9
1	1	2	4-1803001-8	ANVIL, COMBINATION, END FEED	8
1	-	1	2217206-4	BLADE, SLUG	7
-	-	-	-	-	6
-	1	1	240641-6	SPACER	5
-	1	1	238011-8	BLOCK, CRIMPER SPACER	4
1	1	2	2-2119582-4	CRIMPER, INSULATION F PREMIUM	3
-	1	1	1-455888-1	SPACER, CRIMPER	2
1	1	2	1-456406-9	CRIMPER, WIRE PREMIUM	1
-	77	72	-2	PART NO	ITEM NO

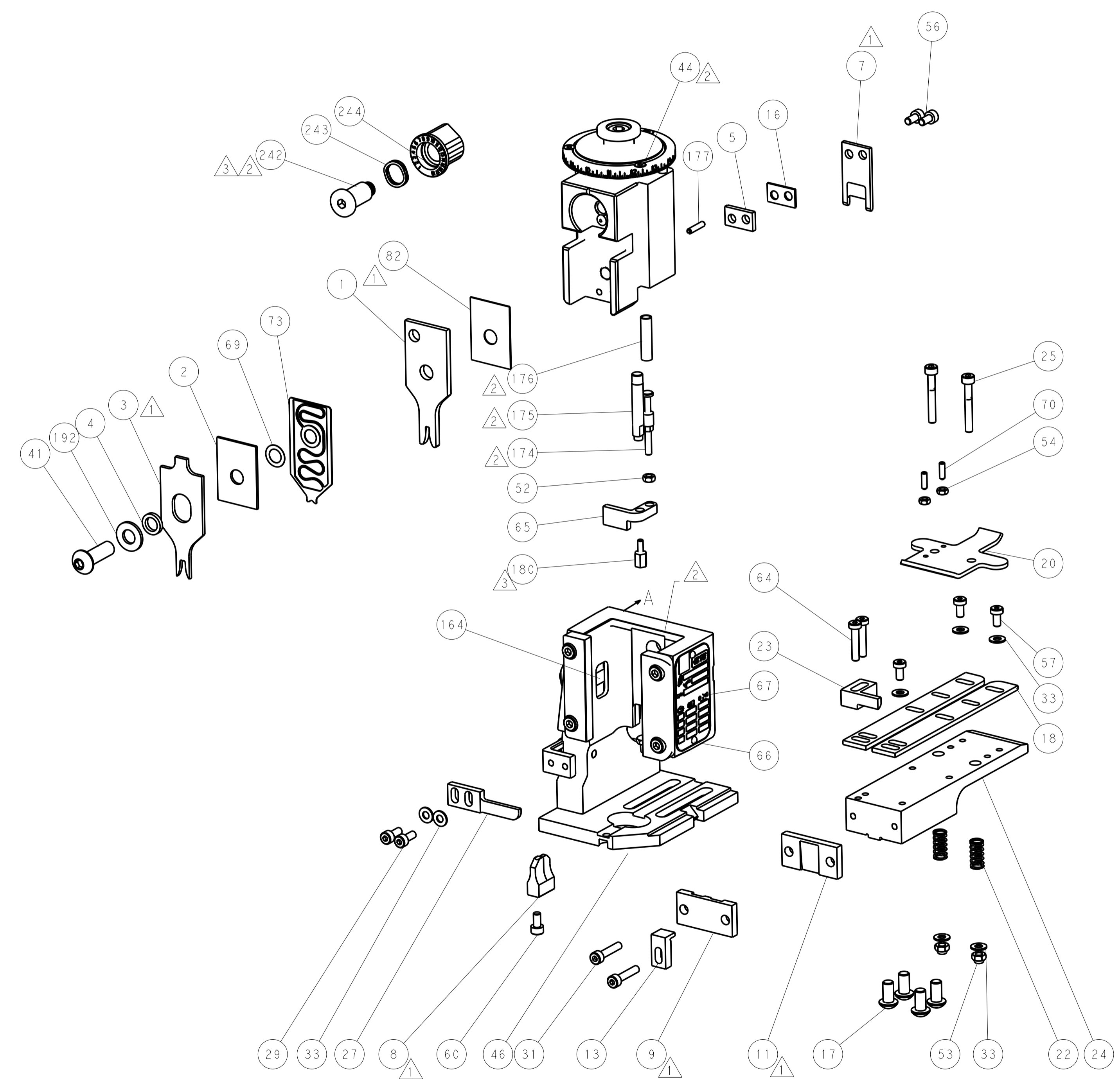
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DRAWN		CHK		APV		NAME	
mm	PLC	mm	PLC	DATE	DATE	DATE	DATE	DATE	DATE	DATE	DATE
	0 PLC ±		0 PLC ±	15MAY2014	15MAY2014	15MAY2014	15MAY2014	15MAY2014	15MAY2014	15MAY2014	15MAY2014
	1 PLC ±		1 PLC ±								
	2 PLC ±		2 PLC ±								
	3 PLC ±		3 PLC ±								
	4 PLC ±		4 PLC ±								
	ANGLES ±		ANGLES ±								
	FINISH		FINISH								
MATERIAL		FINISH		WEIGHT		SCALE		SHEET		REV	
						1:1		1 OF 4		C	

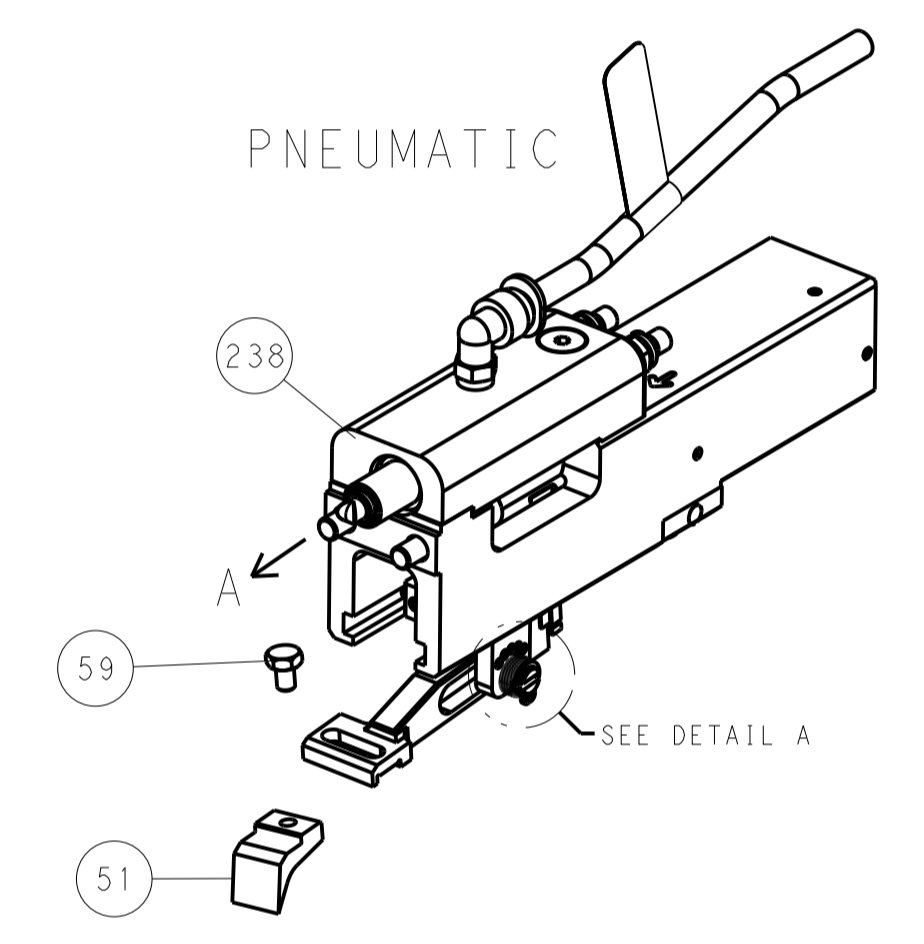
LOC	DIST	REV	DATE	BY	APPV
A	66				
REVISIONS			DESCRIPTION	DATE	BY
			SEE SHEET 1		



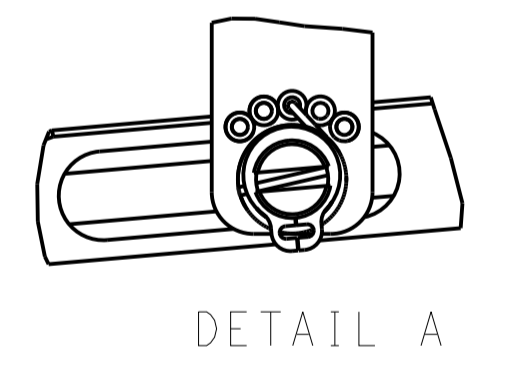
RAM AND HOLDDOWN SET-UP



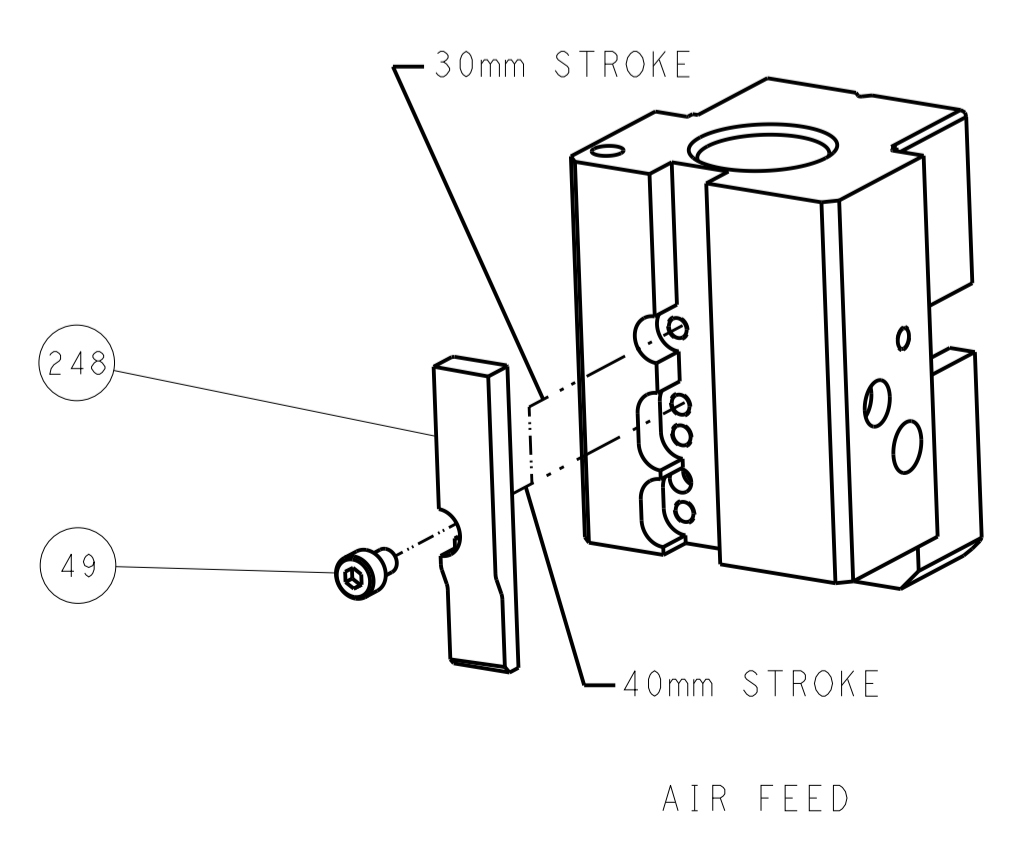
FEED TYPE



FEED SPRING SETTING POSITION



CAM POSITION

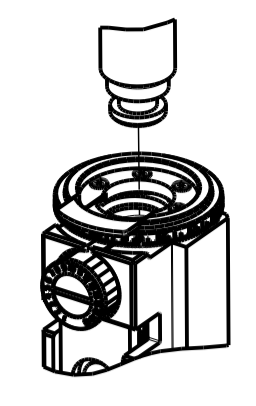


ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		DWN EVERALDO 15MAY2014 CHK P. BARLETTA 15MAY2014 APVD C. LIMA 15MAY2014		TE Connectivity Harrisburg, PA 17105-3608	
MATERIAL:		FINISH:		PRODUCT SPEC:		NAME: Ocean End Feed Applier	
WEIGHT:		SCALE: 1:1		SIZE: A11 00779 ©=2150441		RESTRICTED TO:	
CUSTOMER ACCESSIBLE PRODUCTION DRAWING		SHEET 2 OF 4		REV C		SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION	

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150441-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150441-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
 INTERFACE ADAPTER



APPLICATOR DATA

CRIMP	SIZE	TYPE
WIRE	2.29 mm (.090)	F
INSUL	3.56 mm (.140)	F

APPL INSTRUCTIONS
 408-35043

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION

TERMINAL NAME: SPECIAL REC. CONTACT CLUSTER FOR PIN .090 DIA.

WIRE STRIP LENGTH	INSULATION DIAMETER RANGE
5.84-6.60 mm (.230-.260 IN)	∅1.30-2.40 mm (.051-.094 IN)

TERMINAL APPLICATION SPECIFICATION 114-2019

TERMINALS APPLIED 6

TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
1599105-1			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
18 AWG OR 0.75mm2	1.36+/-0.05 [.054+/- .002]	4.3
22 AWG OR 0.35mm2	1.23+/-0.05 [.048+/- .002]	6.0

- RECOMMENDED SPARE PARTS
- REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 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.
5. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- TERMINAL PITCH IS NOT COMPATIBLE WITH MECHANICAL FEED.

***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.

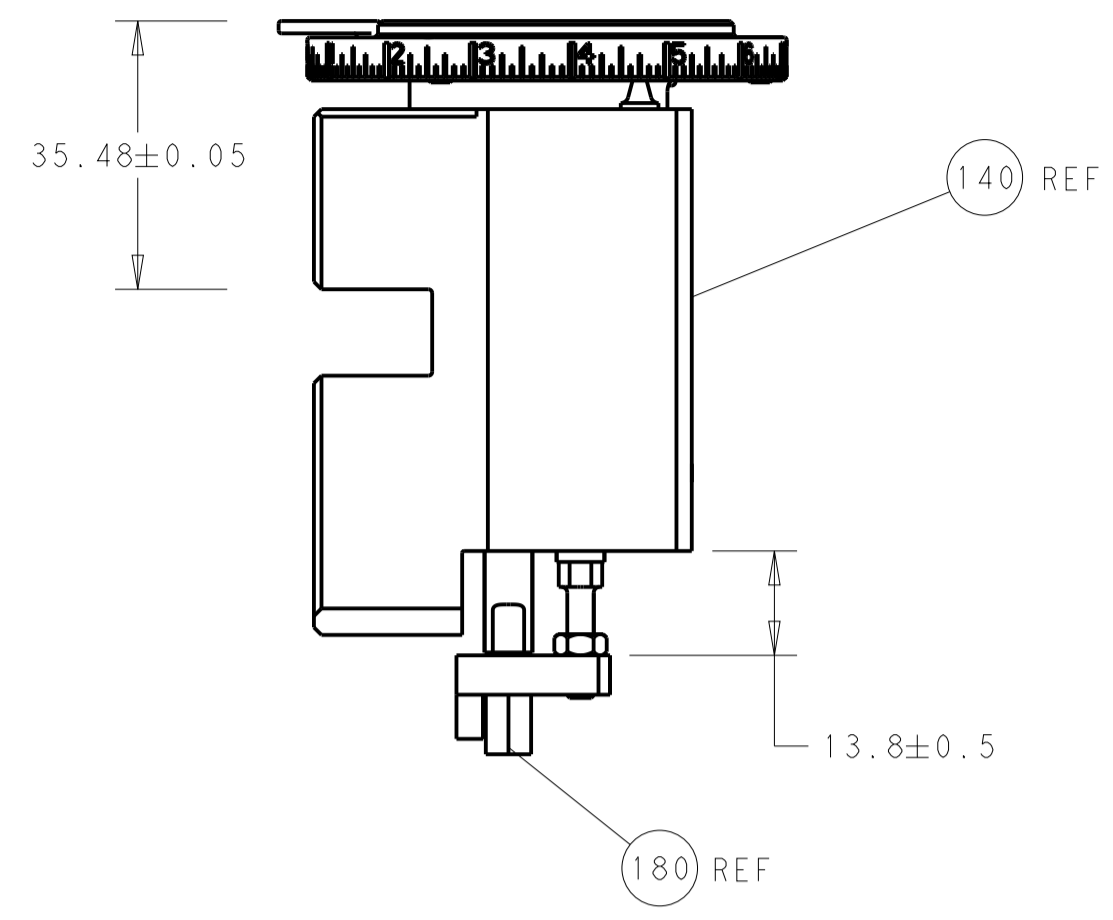
PACIFIC VERSION
 Shown on sheets 3 of 4 & 4 of 4
 (Atlantic version shown on sheets 1 of 4 & 2 of 4)

LOC	DIST	REV	DATE	BY	CHK	APPV
A	66					

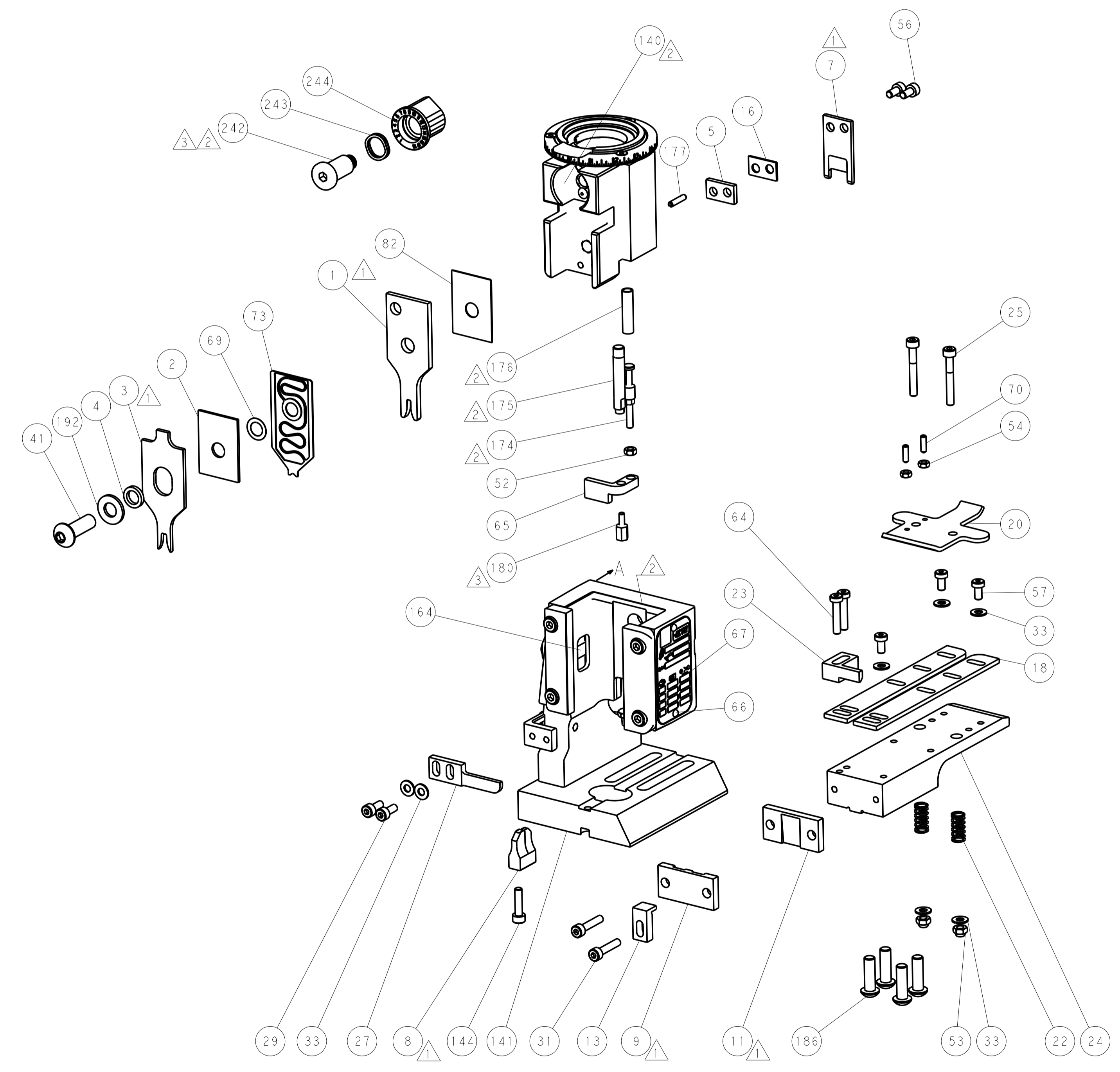
REV	DESCRIPTION	DATE	BY	CHK	APPV
- 1	2119082-9				
- 1	2079764-1				
- 1	2119083-1				
- 1	2844940-3				
- 1	1-18028-0				
- 4	2079383-9				
- 1	1-1752354-6				
- 1	6-993111-6				
- 1	8-22280-7				
- 1	1752353-2				
- 1	1901680-2				
- REF	994970-2				
- 1	2119641-2				
- 1	2168083-8				
- 1	2119655-6				
- 1	1803518-1				
- 1	455888-5				
- 1	2119791-5				
- 1	1803607-4				
- 2	2-18032-2				
- 1	2119943-1				
- 1	2119740-1				
- 2	2168078-1				
- 1	1901681-5				
- 2	2168400-5				
- 1	5-18022-5				
- 3	2168400-4				
- 2	2168083-2				
- 2	5018030-1				
- 2	986965-8				
- 1	1-5018030-0				
- 1	2063961-1				
- 1	18023-9				
- 1	1803602-1				
- 7	1-18028-2				
- 2	2168083-9				
- 2	1-2168083-0				
- 1	240639-1				
- 2	1-2168083-5				
- 1	1752371-5				
- 1	240825-1				
- 2	2-22281-3				
- 1	1803292-4				
- 2	1901259-5				
- 1	5-240641-9				
- 1	1752360-1				
- 1	240644-1				
-	-				
- 1	690482-6				
1 1	4-1803001-8				
- 1	2217206-4				
-	-				
- 1	240641-6				
- 1	238011-8				
1 1	2-2119582-4				
- 1	1-455888-1				
1 1	1-456406-9				

DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		DWG: EVERALDO 15MAY2014 CHK: P. BARLETTA 15MAY2014 APPV: C. LIMA 15MAY2014		NAME: TE Connectivity Harrisburg, PA 17105-3608	
MATERIAL:		FINISH:		PRODUCT SPEC:		APPLICATION SPEC:	
WEIGHT:		SCALE: 1:1		SHEET 3 OF 4		REV C	

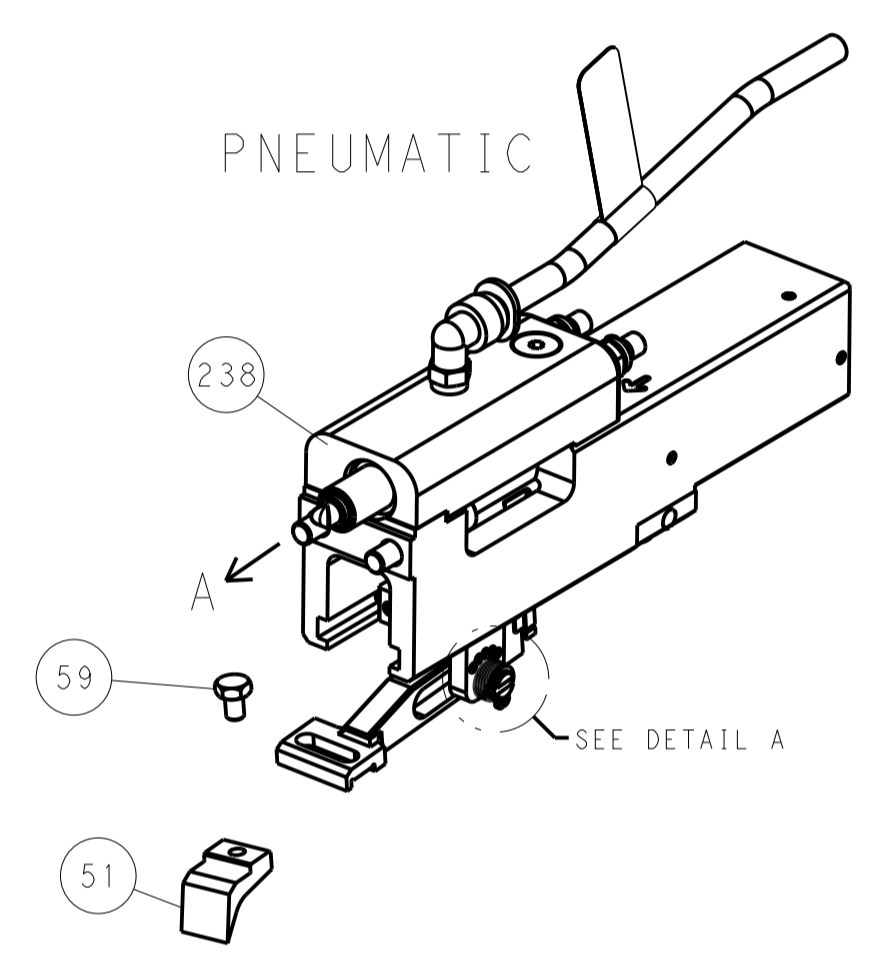
LOC		DIST		REVISIONS			
A	66	P	LTM	DESCRIPTION	DATE	DWN	APVD
		-	-	SEE SHEET 1	-	-	-



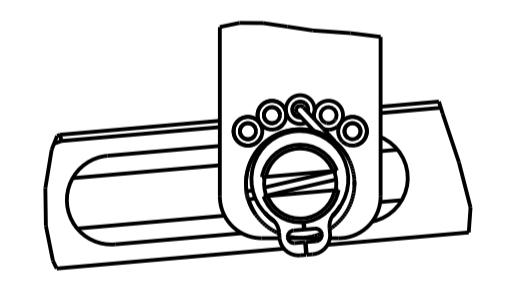
RAM AND HOLDDOWN SET-UP



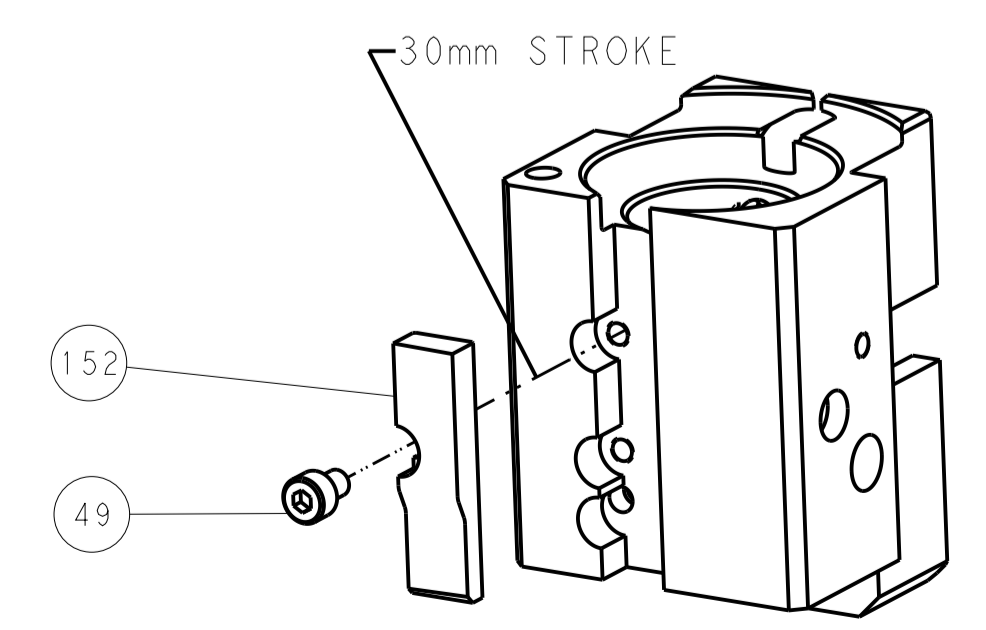
FEED TYPE



FEED SPRING SETTING POSITION



CAM POSITION



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 EVERALDO 15MAY2014		STE TE Connectivity	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	5 PLC ±	Harrisburg, PA 17105-3608
MATERIAL:	FINISH:	WEIGHT:	APVD: C. LIMA 15MAY2014	NAME:	Ocean End Feed Applier		
Customer Accessible Production Drawing				SCALE: 1:1	SHEET 4 OF 4	REV C	RESTRICTED TO