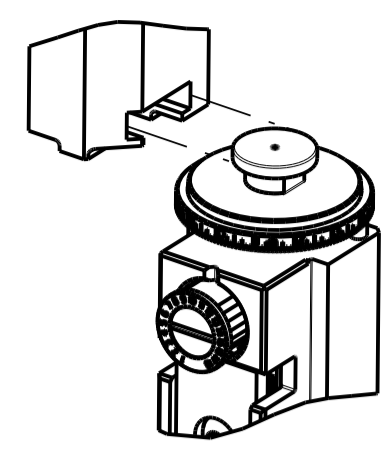


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150660-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2150660-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150660-1	B	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2150660-2	B	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150660-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.50 mm [.098]	F
INSUL	3.86 mm [.152]	F

APPL INSTRUCTIONS 408-35043

TERMINAL DATA: STOCKO TERMINAL STOCKO CRIMP SPECIFICATION	
TERMINAL NAME: TERMINAL	
WIRE STRIP LENGTH 5.80-6.60 mm [.228-.260 IN]	INSULATION DIAMETER RANGE ∅2.30-3.30 mm [.091-.130 IN]
TERMINAL APPLICATION SPECIFICATION F 052-1 Rev 03/12/2007	
TERMINALS APPLIED	
TE TERMINAL 1572174-1	STOCKO TERMINAL RSB 7900 F 6.3-1

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.50mm2	1.85 +/- 0.02 [.073 +/- .001]	7.0
1.00mm2	1.73 +/- 0.02 [.068 +/- .001]	8.7
0.75mm2	1.64 +/- 0.02 [.065 +/- .001]	9.2
0.50mm2	1.55 +/- 0.02 [.061 +/- .001]	10.4

- 1. RECOMMENDED SPARE PARTS
- 2. REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND 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. 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)

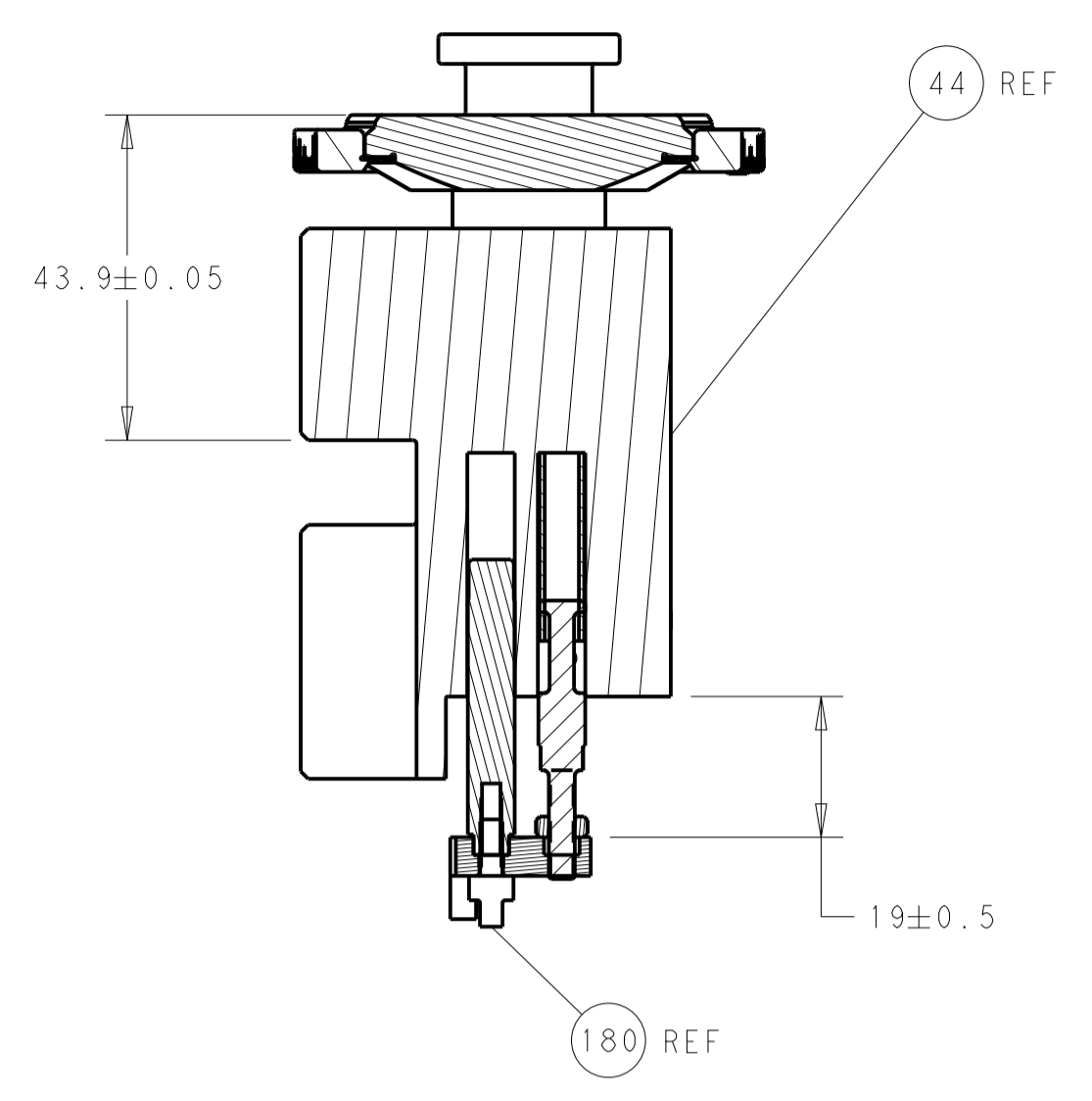
LOC	DIST	REVISIONS					
A	66	F	LTN	DESCRIPTION	DATE	DWN	APVD
		A		RELEASED	02JUN2016	MR	GB
		B		ECR-21-006404	22JUN2021	FZ	TE

-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248	
-	1	1	1	1	2119082-4	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	1-1976055-2	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	455888-6	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	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	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	
-	2	2	2	2	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	1752371-1	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	1803152-4	STRIP GUIDE, REAR	19	
-	1	1	1	1	1803151-4	STRIP GUIDE, FRONT	18	
-	4	4	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17	
-	1	1	1	1	4-240641-9	SPACER	16	
-	1	1	1	1	1752360-1	SPACER,HOLD-DOWN	13	
1	-	1	1	1	240644-1	PLATE, REAR SHEAR	11	
-	-	-	-	-	-	-	10	
1	-	1	1	1	690482-4	PLATE, FRONT SHEAR	9	
1	1	2	2	1	1	3-1803060-3	ANVIL, COMBINATION, END FEED	8
1	-	1	1	1	1	1-2217206-0	BLADE, SLUG	7
-	-	-	-	-	-	-	6	
-	1	1	1	1	1	1-240641-2	SPACER	5
-	1	1	1	1	1	4-238011-2	BLOCK, CRIMPER SPACER	4
1	1	2	2	1	1	6-1633962-4	CRIMPER, INSULATION F PREMIUM	3
-	1	1	1	1	1	455888-7	SPACER, CRIMPER	2
1	1	2	2	1	1	1-1803188-6	CRIMPER, WIRE	1
-	77	72	71	2	1	PART NO	DESCRIPTION	ITEM NO

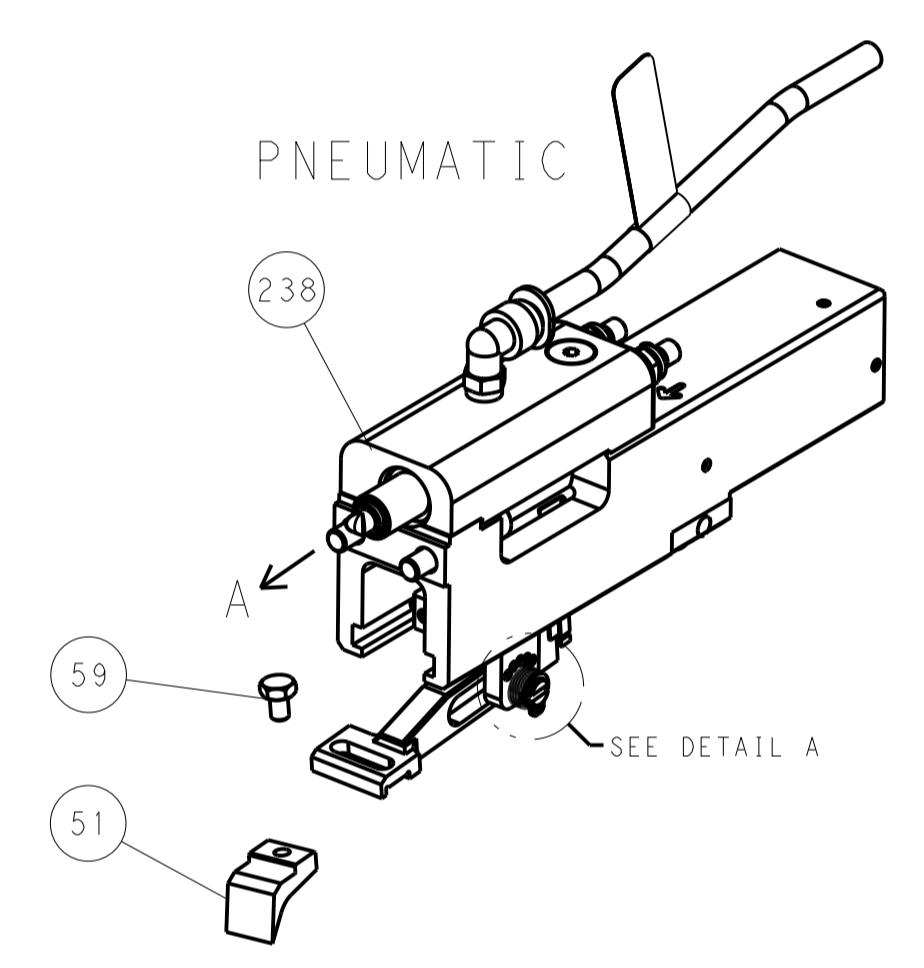
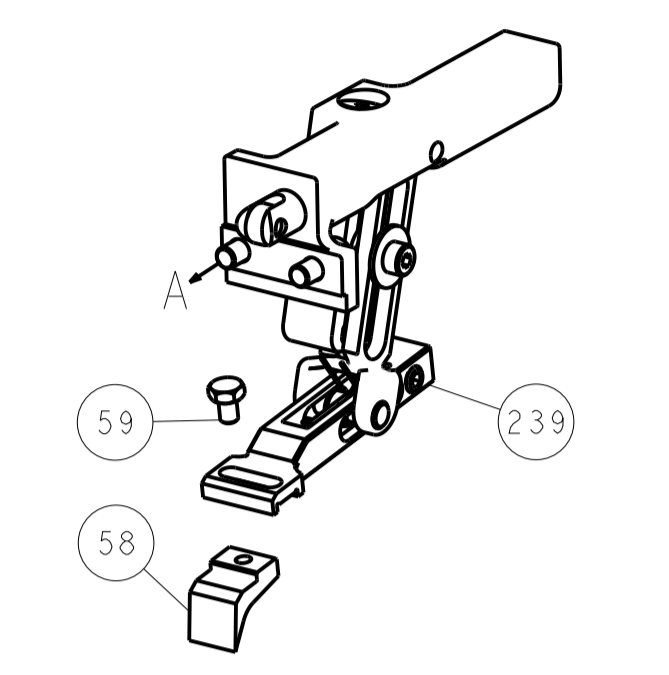
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN: JH_ZHAO 22APR2016		CHK: K_ZHANG 22APR2016		APVD: K_ZHANG 22APR2016		NAME: Ocean End Feed Applicator	
0 PLC	±	1 PLC	±	2 PLC	±	3 PLC	±	4 PLC	±	SIZE	CAGE CODE
ANGLES	±	FINISH	±	WEIGHT		SCALE		SHEET 1 OF 4		REV B	
MATERIAL										Customer Accessible Production Drawing	

LOC	DIST	REV	DATE	BY	APPV
A	66				

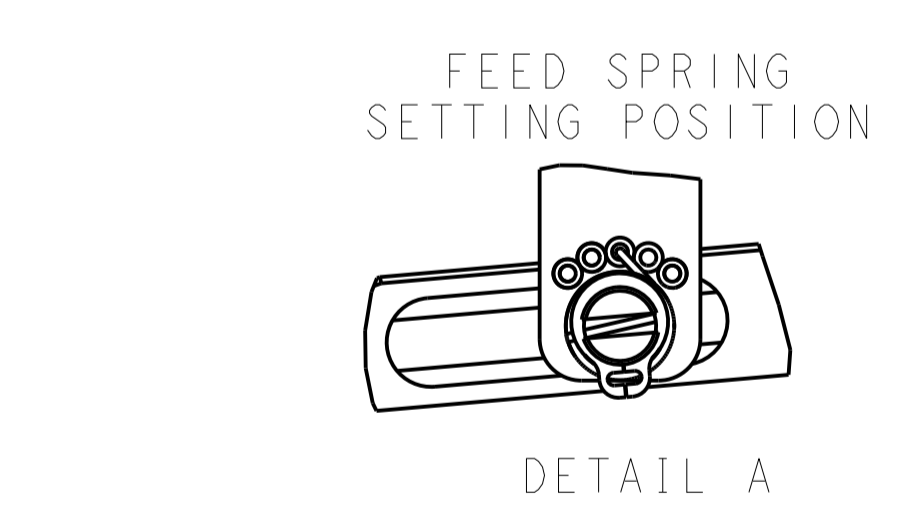
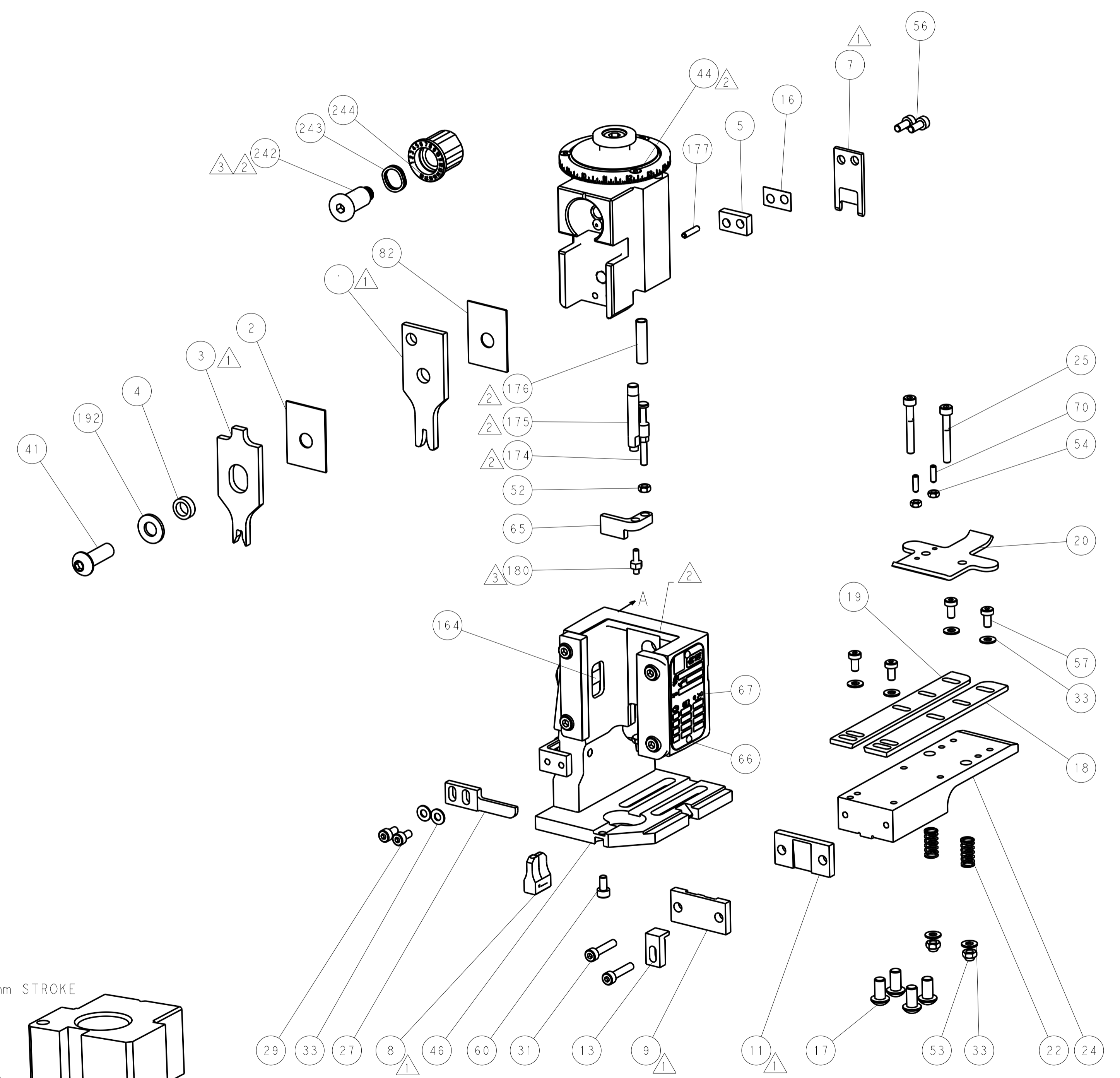
FEED TYPE MECHANICAL



RAM AND HOLDDOWN SET-UP



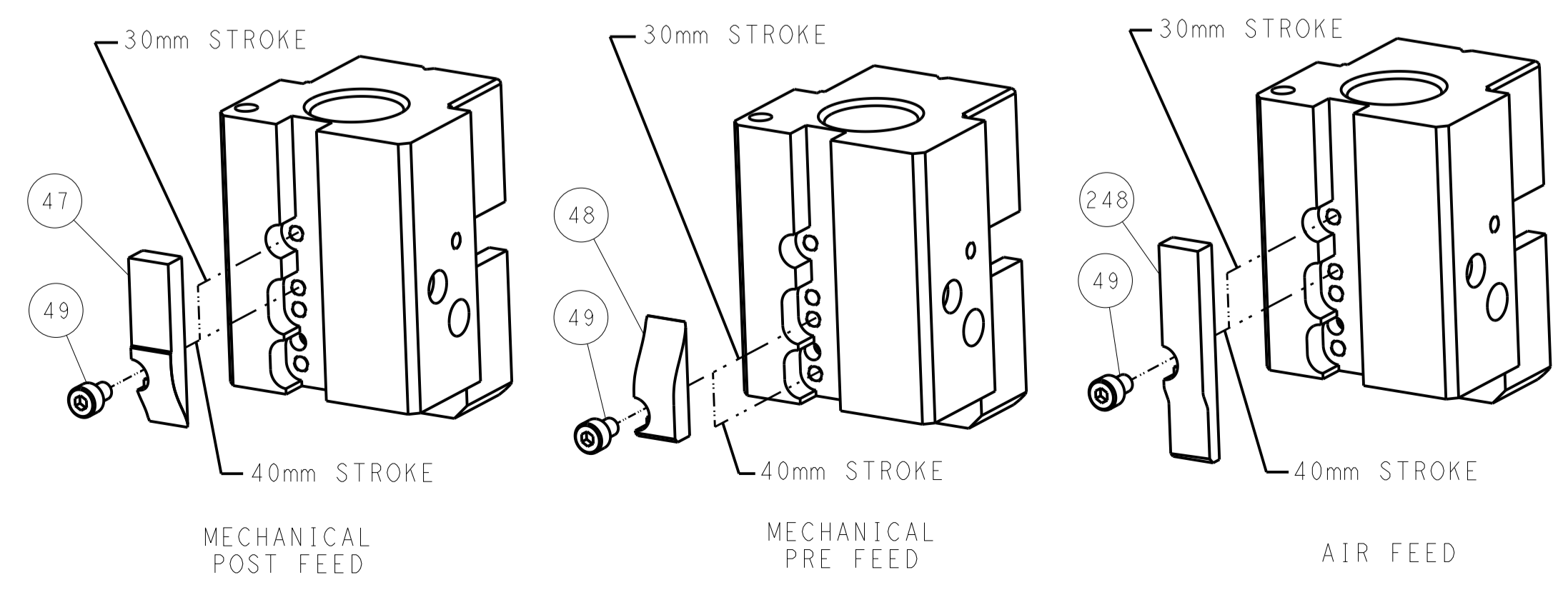
PNEUMATIC



FEED SPRING
SETTING POSITION

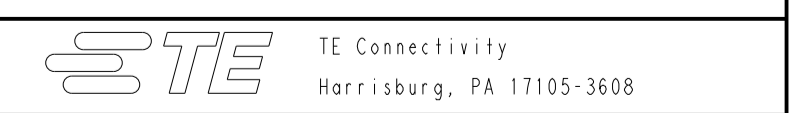
DETAIL A

CAM POSITIONS



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

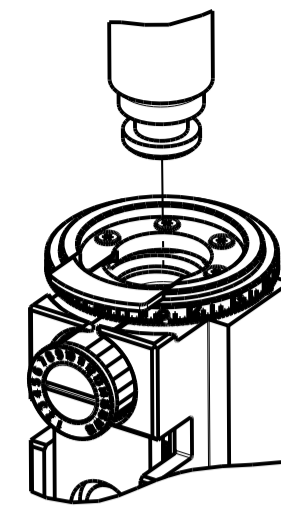
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG		REV	
mm	0 PLC	±		M. ZHAO	22APR2016		
	1 PLC	±		CHK	K. ZHANG	22APR2016	
	2 PLC	±		APPV	K. ZHANG	22APR2016	
	3 PLC	±		NAME			
	4 PLC	±		PRODUCT SPEC			
	ANGLES	±		APPLICATION SPEC			
MATERIAL	FINISH			WEIGHT		SIZE	
				Customer Accessible Production Drawing		A1 00779 ©=2150660	
				SCALE		SHEET	
				1:1		2 of 4	
						REV	
						B	



Ocean End Feed
Applicator

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150660-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2150660-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150660-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.50 mm [.098]	F
INSUL	3.86 mm [.152]	F
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: STOCKO TERMINAL STOCKO CRIMP SPECIFICATION	
TERMINAL NAME: TERMINAL	
WIRE STRIP LENGTH 5.80-6.60 mm [.228-.260 IN]	INSULATION DIAMETER RANGE 2.30-3.30 mm [.091-.130 IN]
TERMINAL APPLICATION SPECIFICATION F 052-1 Rev 03/12/2007	
TERMINALS APPLIED	
TE TERMINAL 1572174-1	STOCKO TERMINAL RSB 7900 F 6.3-1

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.50mm2	1.85 +/- 0.02 [.073 +/- .001]	7.0
1.00mm2	1.73 +/- 0.02 [.068 +/- .001]	8.7
0.75mm2	1.64 +/- 0.02 [.065 +/- .001]	9.2
0.50mm2	1.55 +/- 0.02 [.061 +/- .001]	10.4

- 1 RECOMMENDED SPARE PARTS
- 2 REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND 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. 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.

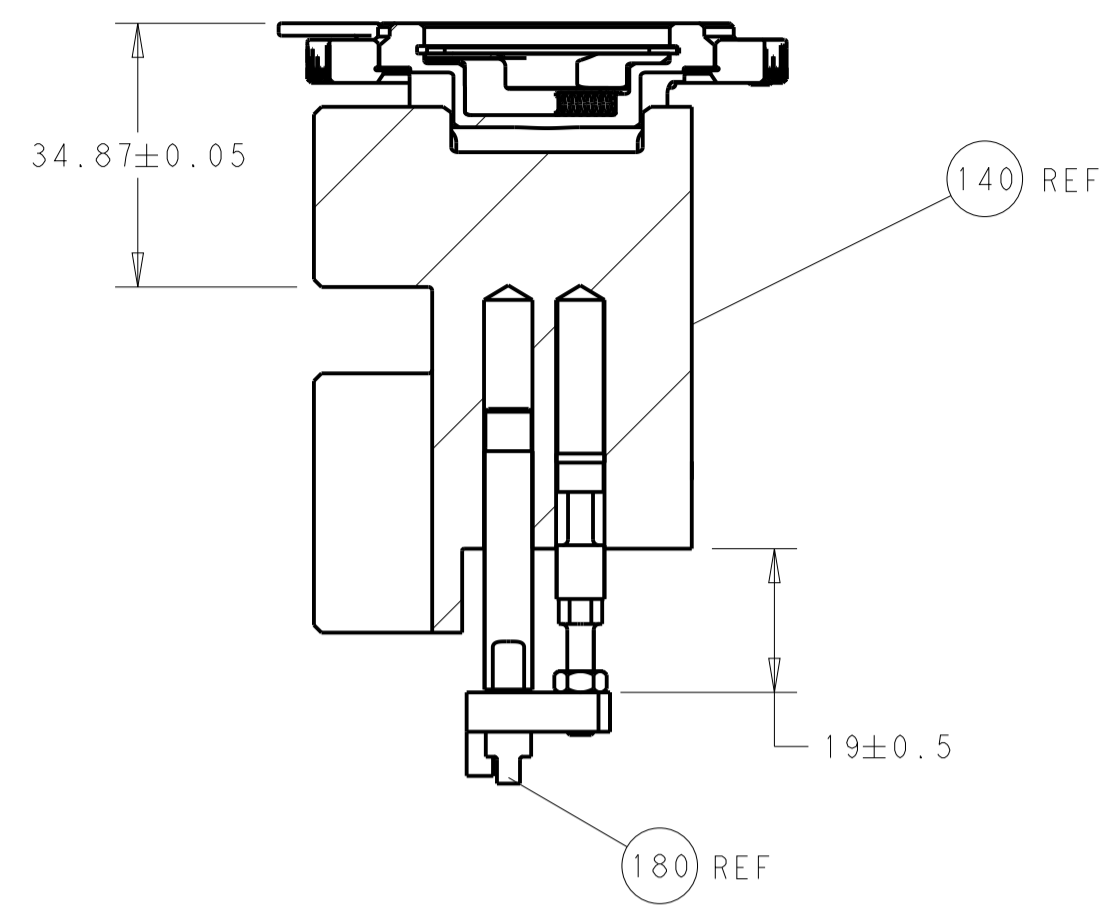
PACIFIC VERSION
Shown on sheets 3 of 4 & 4 of 4
(Atlantic version shown on sheets 1 of 4 & 2 of 4)

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

-	1	1	2119082-4	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	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	
3	-	1	1-1976055-2	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	455888-6	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	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	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	
-	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	1752371-1	PLATE, STRIP GUIDE	24	
-	2	2	2-22281-3	SPRING, COMPRESSION	22	
-	1	1	1803292-4	DRAG	20	
-	1	1	1803152-4	STRIP GUIDE, REAR	19	
-	1	1	1803151-4	STRIP GUIDE, FRONT	18	
-	1	1	4-240641-9	SPACER	16	
-	1	1	1752360-1	SPACER, HOLD-DOWN	13	
1	-	1	240644-1	PLATE, REAR SHEAR	11	
-	-	-	-	-	10	
1	-	1	690482-4	PLATE, FRONT SHEAR	9	
1	1	1	3-1803060-3	ANVIL, COMBINATION, END FEED	8	
1	-	1	1-2217206-0	BLADE, SLUG	7	
-	-	-	-	-	6	
-	1	1	1-240641-2	SPACER	5	
-	1	1	4-238011-2	BLOCK, CRIMPER SPACER	4	
1	1	1	6-1633962-4	CRIMPER, INSULATION F PREMIUM	3	
-	1	1	455888-7	SPACER, CRIMPER	2	
1	1	1	1-1803188-6	CRIMPER, WIRE	1	
-	77	22	21	PART NO	DESCRIPTION	ITEM NO

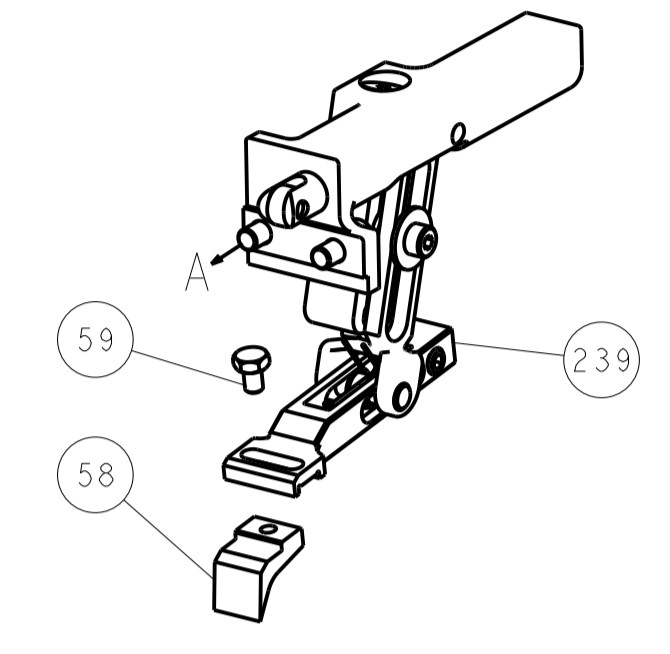
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN: M. ZHAO 22APR2016		CHK: K. ZHANG 22APR2016		APVD: K. ZHANG 22APR2016		NAME: Ocean End Feed Applicator	
0 PLC ±		1 PLC ±		2 PLC ±		3 PLC ±		4 PLC ±		SIZE: A	
MATERIAL: -		FINISH: -		WEIGHT: -		SCALE: 1:1		SHEET: 3 OF 4		REV: B	

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

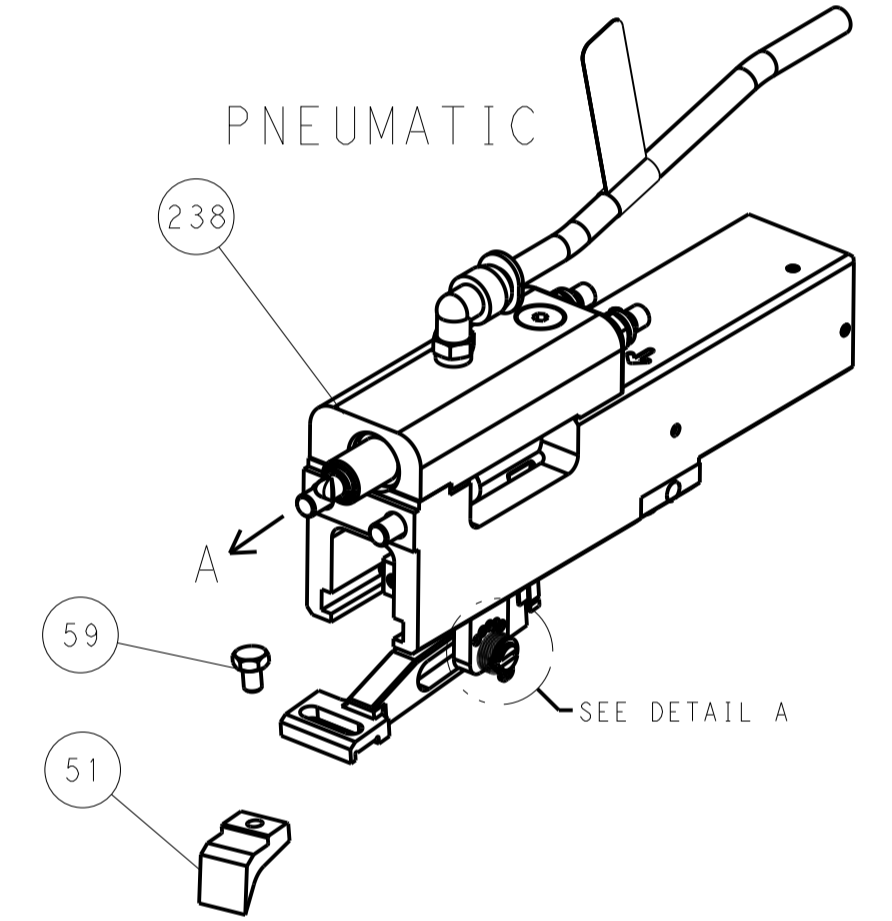


RAM AND HOLDDOWN SET-UP

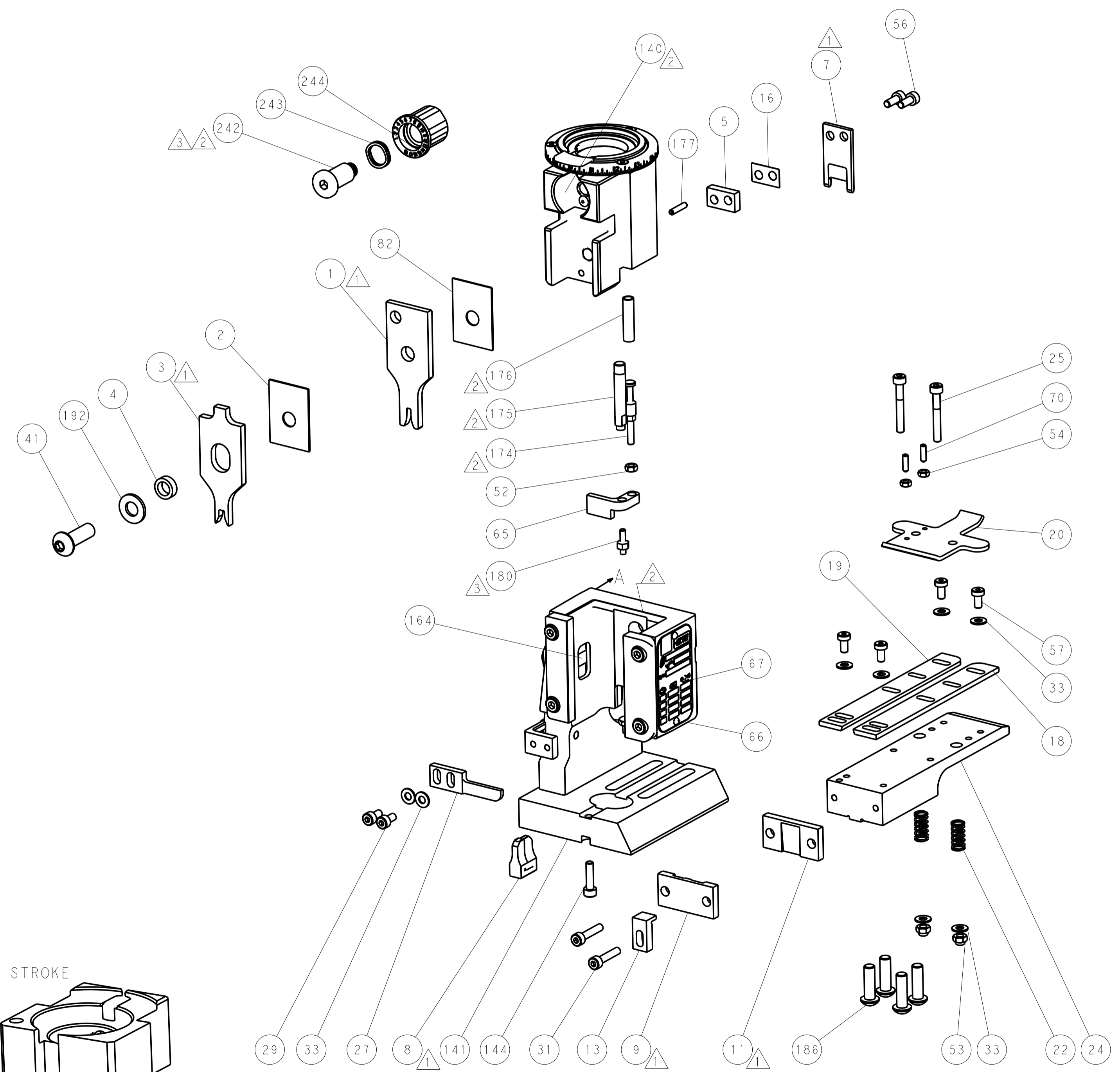
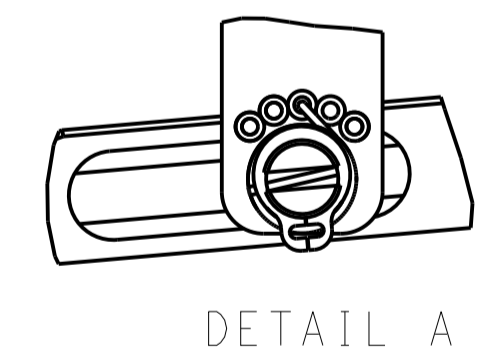
FEED TYPE
MECHANICAL



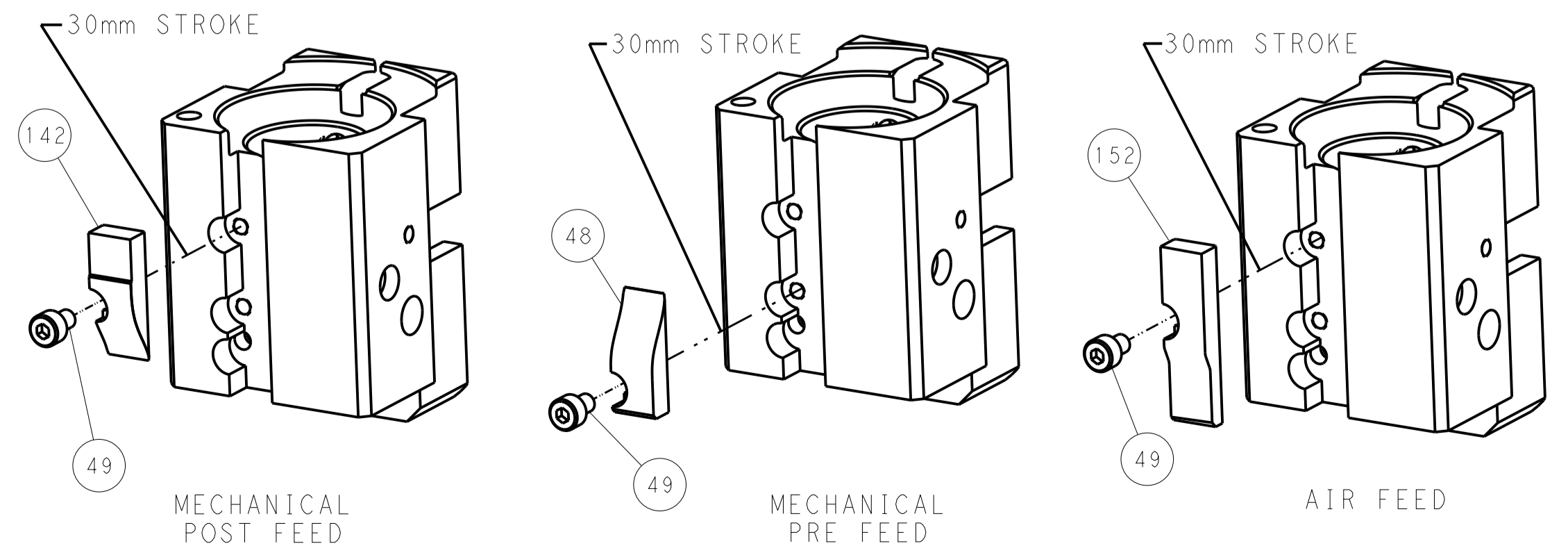
PNEUMATIC



FEED SPRING
SETTING POSITION



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:		DWG: M. ZHAO 22APR2016		TE Connectivity	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	Harrisburg, PA 17105-3608	
MATERIAL:		FINISH:		CHK: K. ZHANG 22APR2016		NAME: Ocean End Feed Applicator	
				APVD: K. ZHANG 22APR2016		SIZE: A1 00779 ©=2150660	
				WEIGHT:		RESTRICTED TO:	
				Customer Accessible Production Drawing		SCALE: 1:1 SHEET 4 OF 4 REV B	