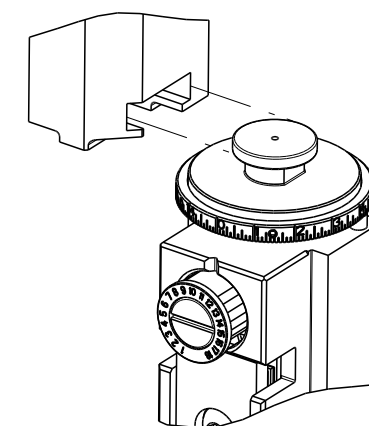


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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150677-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150677-2	B	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150677-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.54 mm [.100]	F
INSUL	-	-
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: .109 DIA PIN			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
5.80-6.60 mm [.228-.260 IN]		Ø	
TERMINAL APPLICATION SPECIFICATION	114-3118	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
61013-2			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
14 AWG	1.96 +/- 0.05 [.077 +/- .002]	3.8
16 AWG	1.70 +/- 0.05 [.067 +/- .002]	6.8
18 AWG	1.52 +/- 0.05 [.060 +/- .002]	9.0



- 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 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.
- UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- TERMINAL PITCH 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.

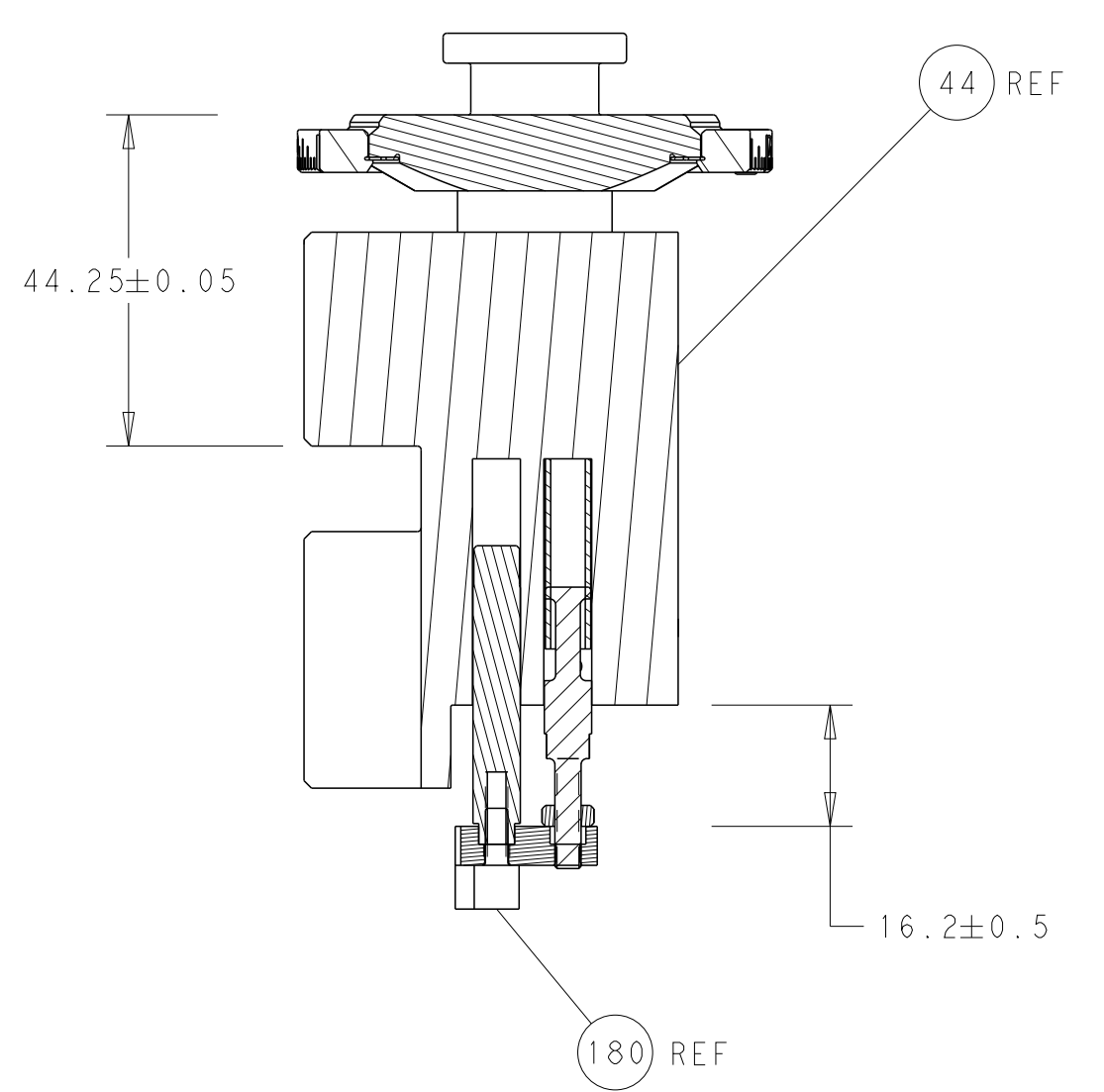
LOC	DIST	REVISIONS					
A	66	P	LTN	DESCRIPTION	DATE	DWN	APVD
		A		RELEASED	04JULY2016	KH	GB
		B		ECR-23-166634	16FEB2023	TB	RK

-	1	1	1803203-1	BLOCK, FRONT DEPRESSOR	261	
-	1	1	2119641-1	FEED CAM, AIR FEED	248	
-	1	1	2844940-4	AIR FEED MODULE	238	
-	1	1	1-455888-0	SPACER, CRIMPER	185	
3	-	1	1752354-8	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	
5	-	1	2119955-2	ASSY, LUBRICATOR, END FEED	84	
-	1	1	455888-5	SPACER, CRIMPER	82	
-	1	1	1-2119791-0	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	1901681-1	HOLDDOWN, TERMINAL	65	
-	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	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57	
-	2	2	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	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	
-	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	1-1752371-6	PLATE, STRIP GUIDE	24	
-	2	2	2-22281-3	SPRING, COMPRESSION	22	
-	1	1	1803292-4	DRAG	20	
-	1	1	1-1901696-8	STRIP GUIDE, REAR	19	
-	1	1	1-1901695-8	STRIP GUIDE, FRONT	18	
-	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17	
-	1	1	240641-3	SPACER	16	
-	1	1	1752360-1	SPACER, HOLD-DOWN	13	
1	-	1	1-240644-7	PLATE, REAR SHEAR	11	
-	-	-	-	-	10	
1	-	1	3-690482-2	PLATE, FRONT SHEAR	9	
1	1	2	2-1803002-3	ANVIL, COMBINATION, END FEED	8	
1	-	1	1-2217206-0	BLADE, SLUG	7	
-	-	-	-	-	6	
-	1	1	8-240641-8	SPACER	5	
-	-	-	-	-	4	
-	-	-	-	-	3	
-	-	-	-	-	2	
1	1	2	1	456421-2	CRIMPER, WIRE	1
-	77	72	2	PART NO	DESCRIPTION	ITEM NO

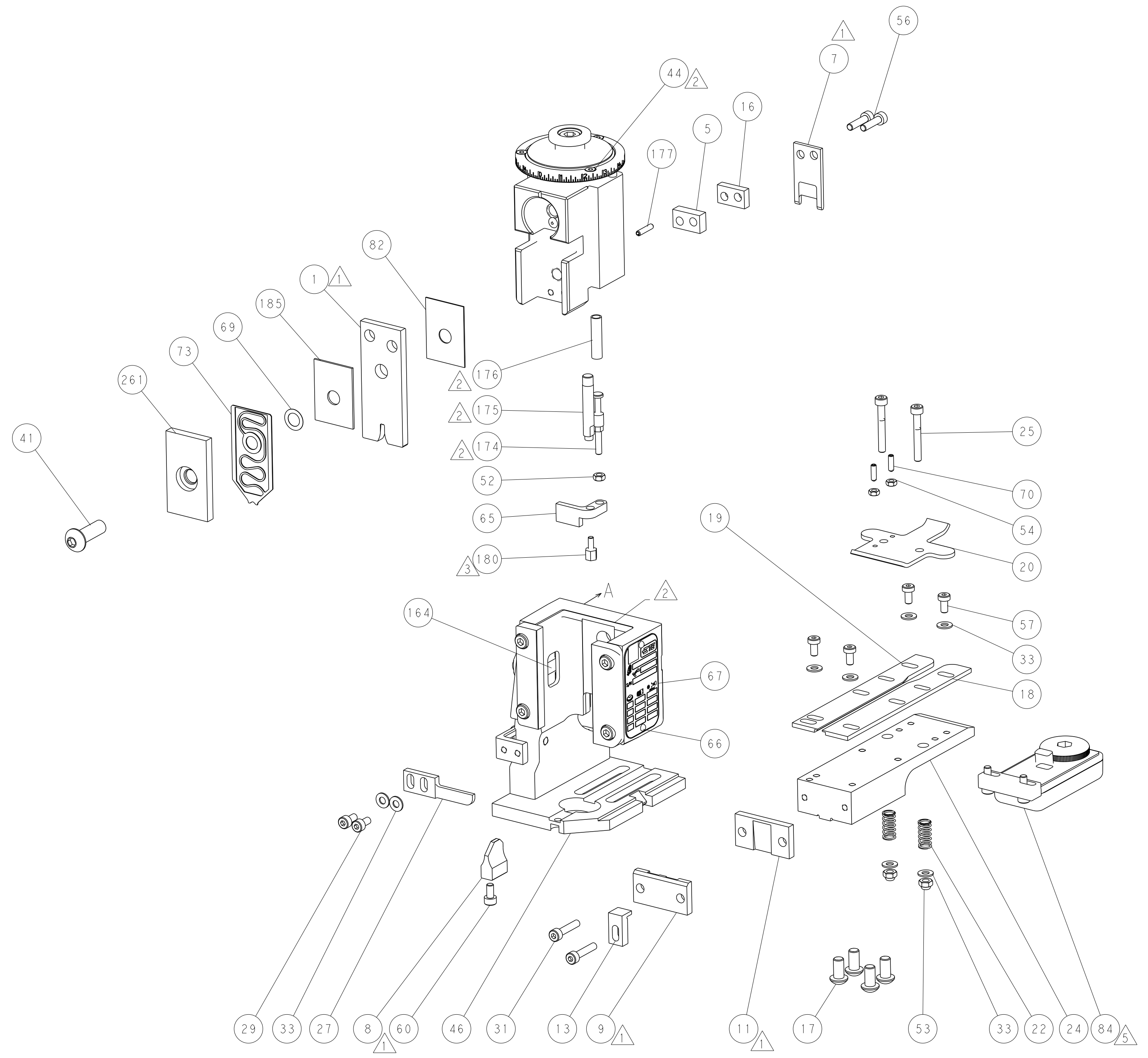
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN K. HUANG 24MAY2016		CHK K. HUANG 24MAY2016		APVD L. ZHANG 24MAY2016		NAME	
0 PLC ±		1 PLC ±		2 PLC ±		3 PLC ±		4 PLC ±		RESTRICTED TO	
ANGLES		FINISH		WEIGHT		SCALE		SHEET		REV	
MATERIAL		FINISH		WEIGHT		SCALE		SHEET		REV	
-		-		-		A1 00779		C=2150677		B	
Customer Accessible Production Drawing		SCALE 1:1		SHEET 1 of 4		REV B					

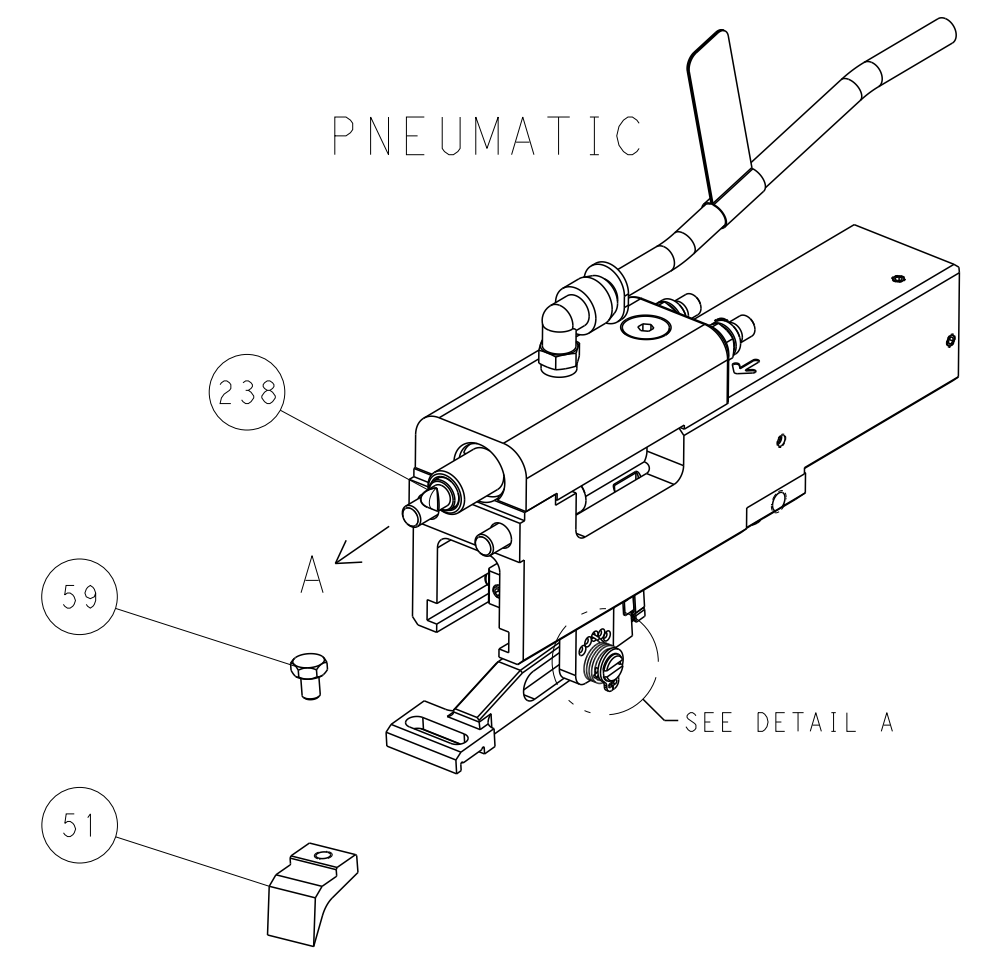
LOC	DIST	REV	DATE	BY	APPV
A	66				
REVISIONS			DATE	BY	APPV
DESCRIPTION					
SEE SHEET 1					



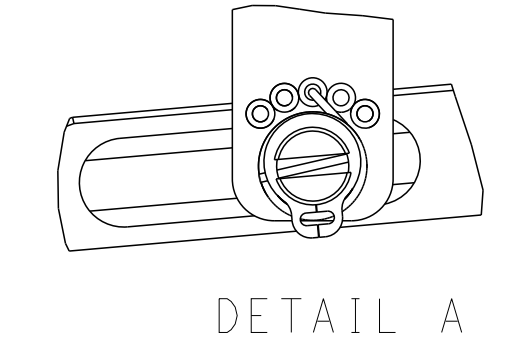
RAM AND HOLDDOWN SET-UP



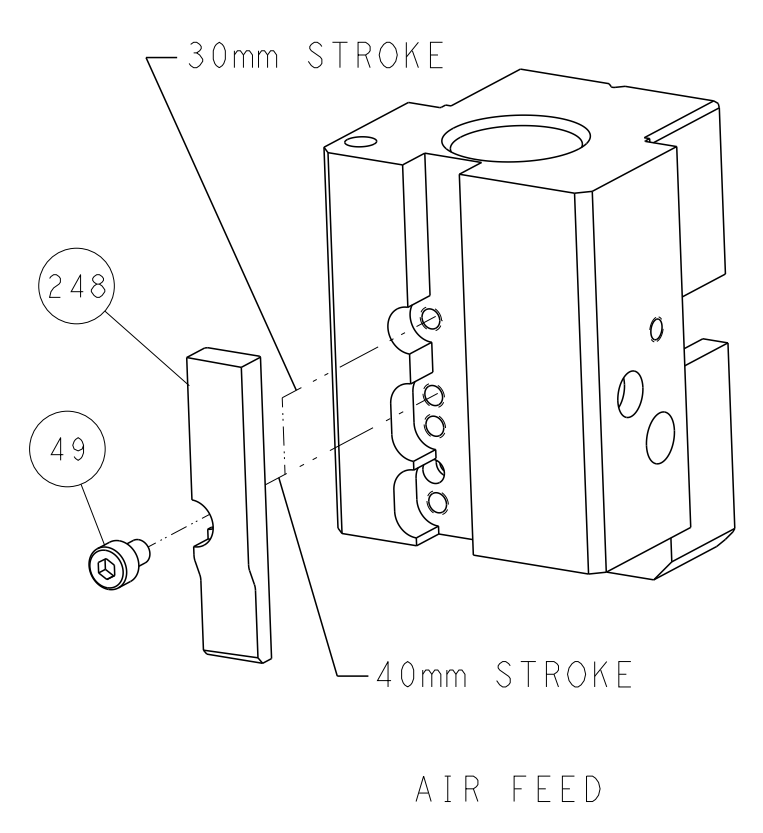
FEED TYPE



FEED SPRING SETTING POSITION



CAM POSITION



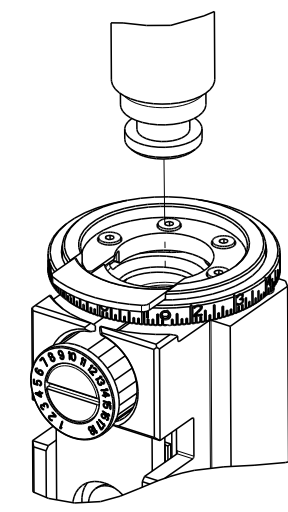
AIR FEED

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 K. HUANG 24MAY2016		TE Connectivity	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	5 PLC ±	Harrisburg, PA 17105-3608
MATERIAL:		FINISH:		CHK K. HUANG 24MAY2016		NAME	
				APVD L. ZHANG 24MAY2016		Ocean End Feed Applicator	
				PRODUCT SPEC		SIZE CAGE CODE DRAWING NO	
				APPLICATION SPEC		A1 00779 C=2150677	
				WEIGHT		RESTRICTED TO	
				Customer Accessible Production Drawing		SCALE 1:1 SHEET 2 OF 4 REV B	

8	7	6	5	4	3	2	1
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE				
2-2150677-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC				
7-2150677-7	A	CRIMP TOOLING KIT	-				

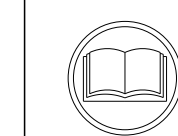
PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.54 mm [.100]	F
INSUL	-	-
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: .109 DIA PIN			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
5.80-6.60 mm [.228-.260 IN]		∅	
TERMINAL APPLICATION SPECIFICATION	114-3118	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
61013-2			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
14 AWG	1.96+/-0.05 [.077+/-0.002]	3.8
16 AWG	1.70+/-0.05 [.067+/-0.002]	6.8
18 AWG	1.52+/-0.05 [.060+/-0.002]	9.0



- 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 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.
- TERMINAL PITCH 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.

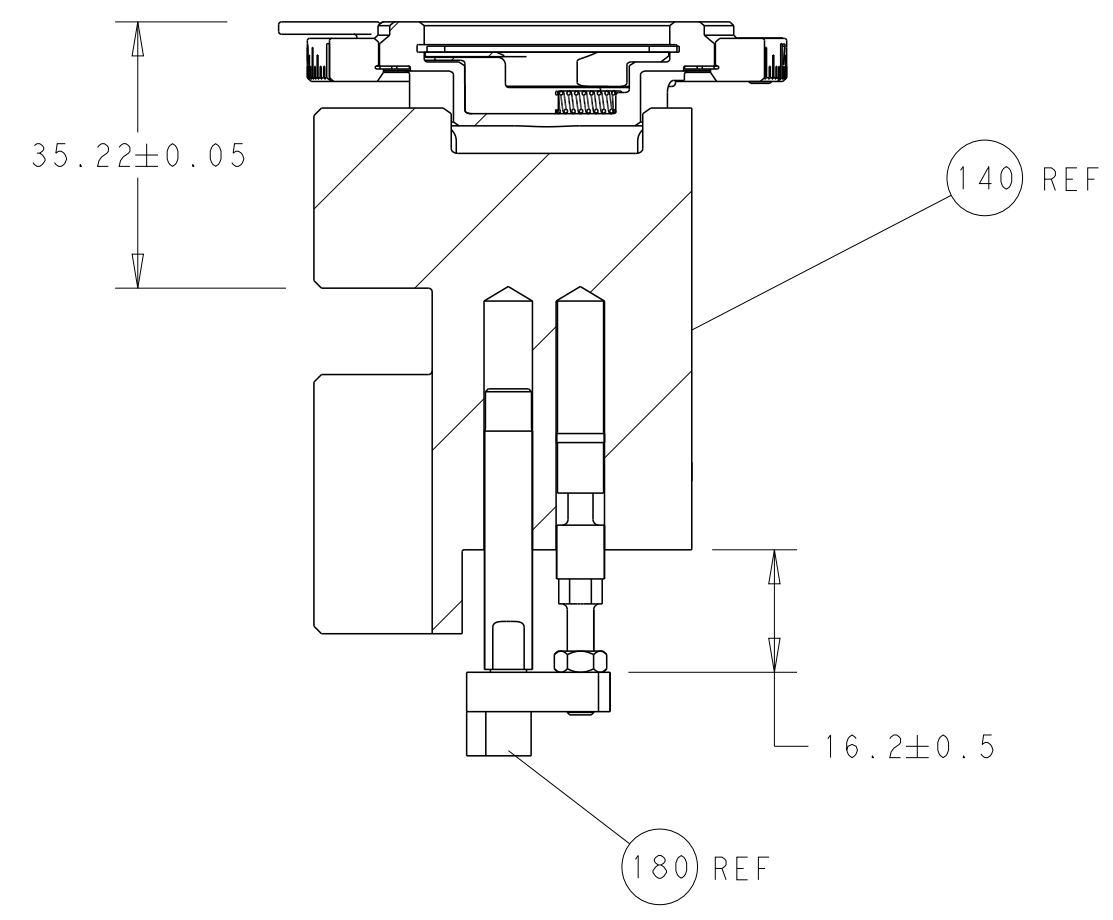
LOC	DIST	REVISIONS					
A	66	P	LTN	DESCRIPTION	DATE	OWN	APVD
		-		SEE SHEET 1	-	-	-

-	1	1803203-1	BLOCK, FRONT DEPRESSOR	261	
-	1	2844940-4	AIR FEED MODULE	238	
-	4	2079383-9	SCR, BHSC, RoHS (M6 X 20)	186	
-	1	1-455888-0	SPACER, CRIMPER	185	
	1	1752354-8	STANDOFF, HOLD-DOWN	180	
-	1	6-993111-6	PIN, SLOTTED SPRING 3.0 X 14.0	177	
-	1	8-22280-7	SPRING, COMPRESSION	176	
-	1	1752353-2	GUIDE PIN, HOLDDOWN	175	
-	1	1901680-2	GUIDE PIN, HOLDDOWN	174	
-	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	
-	1	2119655-6	APPLICATOR BASIC ASSEMBLY, EF	141	
-	1	1803518-1	RAM ASSEMBLY, EF PACIFIC	140	
	1	2119955-2	ASSY, LUBRICATOR, END FEED	84	
-	1	455888-5	SPACER, CRIMPER	82	
-	1	1-2119791-0	DEPRESSOR, WIRE	73	
-	1	1803607-4	DOCUMENTATION PACKAGE	71	
-	2	2-18032-2	SCR, SET, FLT PNT, M3 X 10.0	70	
-	1	2119943-1	WASHER, SPACER	69	
-	1	2119740-1	TAG, IDENTIFICATION	67	
-	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66	
-	1	1901681-1	HOLDDOWN, TERMINAL	65	
-	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59	
-	4	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57	
-	2	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	56	
-	2	5018030-1	NUT, HEX, REG, RoHS, M3	54	
-	2	986965-8	NUT, LOCK, HEX, TORQUE (M4)	53	
-	1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52	
-	1	2063961-1	FEED FINGER	51	
-	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49	
-	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41	
-	8	1-18028-2	WASHER, FLAT, REG M4	33	
-	2	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	31	
-	2	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	29	
-	1	240639-1	STRIPPER (MACHINING)	27	
-	2	1-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 30	25	
-	1	1-1752371-6	PLATE, STRIP GUIDE	24	
-	2	2-22281-3	SPRING, COMPRESSION	22	
-	1	1803292-4	DRAG	20	
-	1	1-1901696-8	STRIP GUIDE, REAR	19	
-	1	1-1901695-8	STRIP GUIDE, FRONT	18	
-	1	240641-3	SPACER	16	
-	1	1752360-1	SPACER, HOLD-DOWN	13	
	1	1-240644-7	PLATE, REAR SHEAR	11	
-	-	-	-	10	
	1	3-690482-2	PLATE, FRONT SHEAR	9	
	1	1	2-1803002-3	ANVIL, COMBINATION, END FEED	8
	1	1	1-2217206-0	BLADE, SLUG	7
-	-	-	-	6	
-	1	8-240641-8	SPACER	5	
-	-	-	-	4	
-	-	-	-	3	
-	-	-	-	2	
	1	1	456421-2	CRIMPER, WIRE	1

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

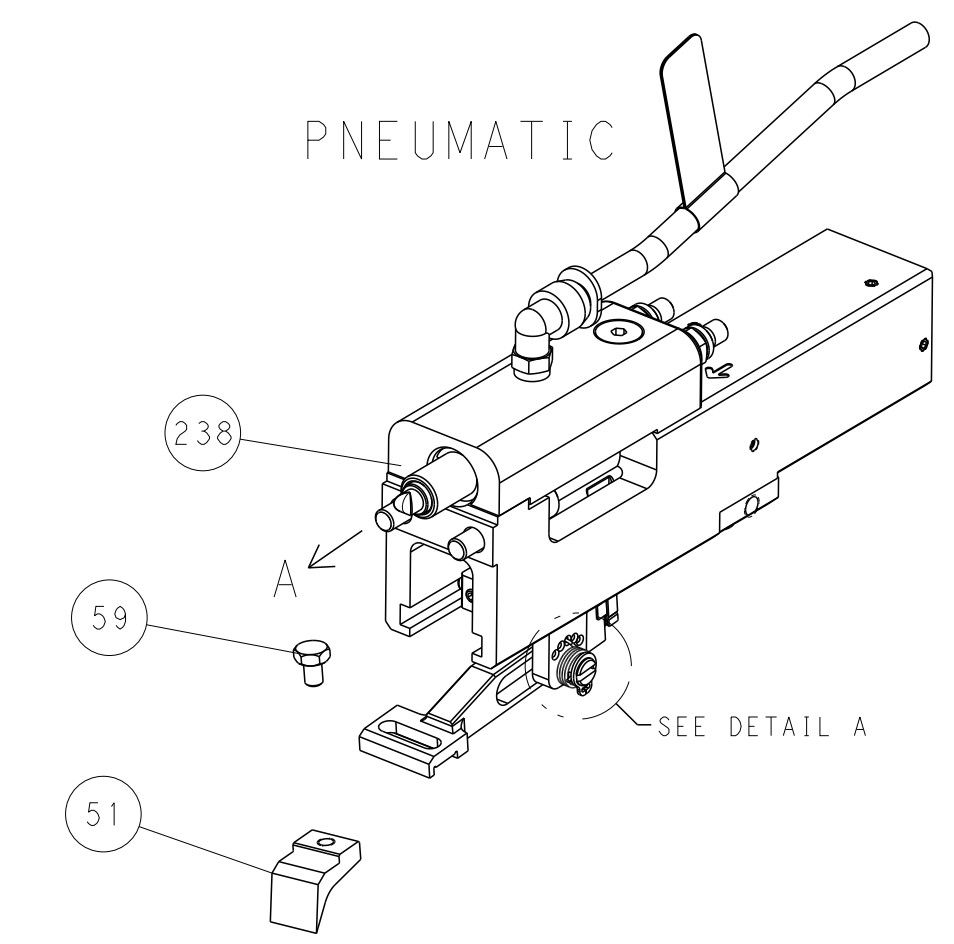
<small>THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION. ALL RIGHTS RESERVED. © BY TYCO ELECTRONICS CORPORATION. SHOULD BE CONTACTED FOR THE LATEST REVISION.</small>		DWN K. HUANG 24MAY2016 CHK K. HUANG 24MAY2016 APVD L. ZHANG 24MAY2016	NAME Ocean End Feed Applicator - SIZE A1 CAGE CODE 00779 DRAWING NO 2150677 RESTRICTED TO -
DIMENSIONS: mm 	TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH	APPLICATION SPEC - WEIGHT - SCALE 1:1 SHEET 3 OF 4 REV B	Customer Accessible Production Drawing

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

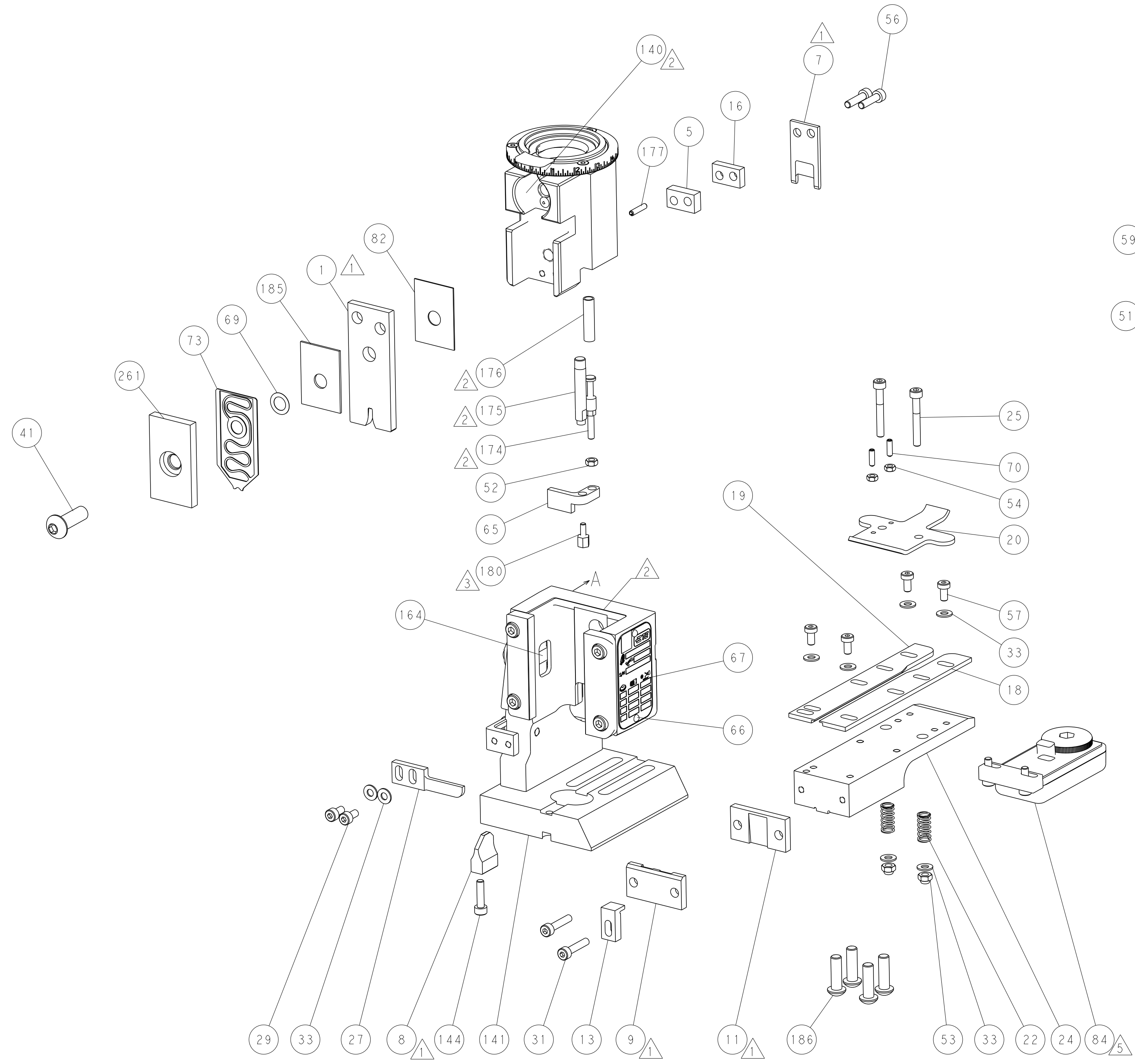
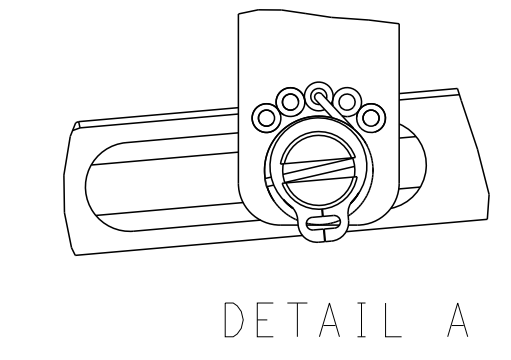


RAM AND HOLDDOWN SET-UP

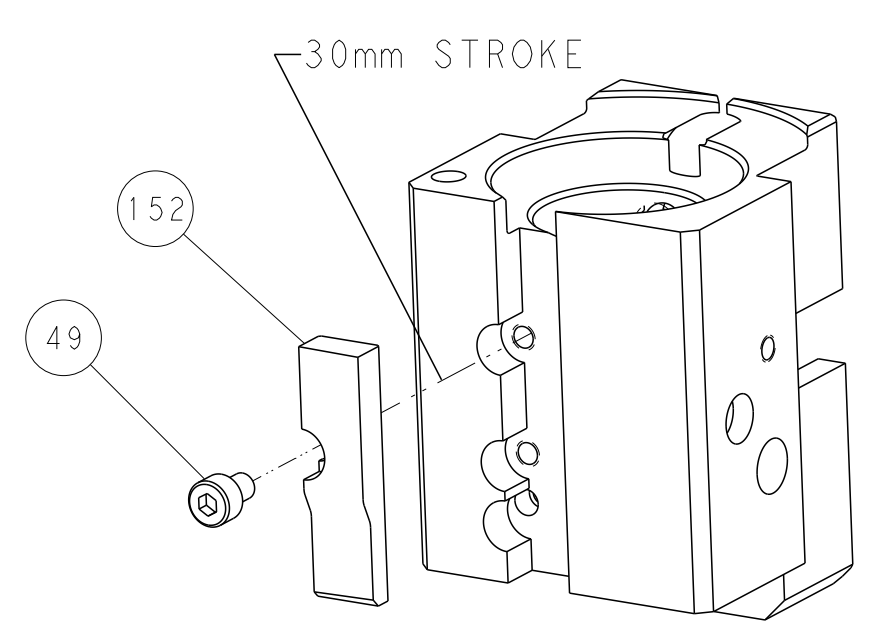
FEED TYPE



FEED SPRING SETTING POSITION



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)

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DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± MATERIAL: - FINISH: -		NAME: Ocean End Feed Applicator PRODUCT SPEC: - APPLICATION SPEC: - WEIGHT: - SCALE: 1:1	RESTRICTED TO: - SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2150677 SHEET: 4 OF 4 REV: B