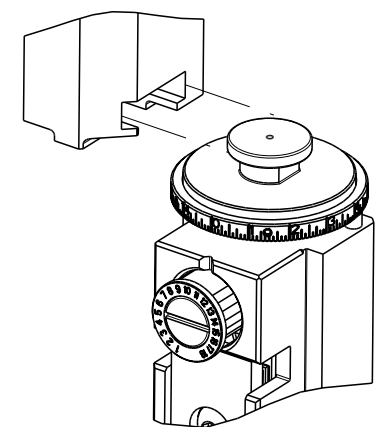


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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150683-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150683-2	C	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150683-7	C	CRIMP TOOLING KIT	-

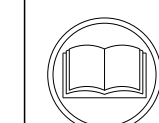
ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.29 mm [.090]	F
INSUL	3.05 mm [.120]	F
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: KIVI TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: TERMINAL			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
4.55-5.31 mm [.179-.209 IN]		Ø1.90-2.40 mm [.075-.095 IN]	
TERMINAL APPLICATION SPECIFICATION	NONE	-	-
TERMINALS APPLIED			
TE TERMINAL	KIVI TERMINAL	TE TERMINAL	KIVI TERMINAL
2303599-1	DJ611-6.3A		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.75mm2	1.45 +/- 0.05 [.057 +/- .002]	7.5
0.50mm2	1.36 +/- 0.05 [.054 +/- .002]	8.3



- 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.
- TERMINAL LUBRICANT IS RECOMMENDED.
- TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- 7. 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.

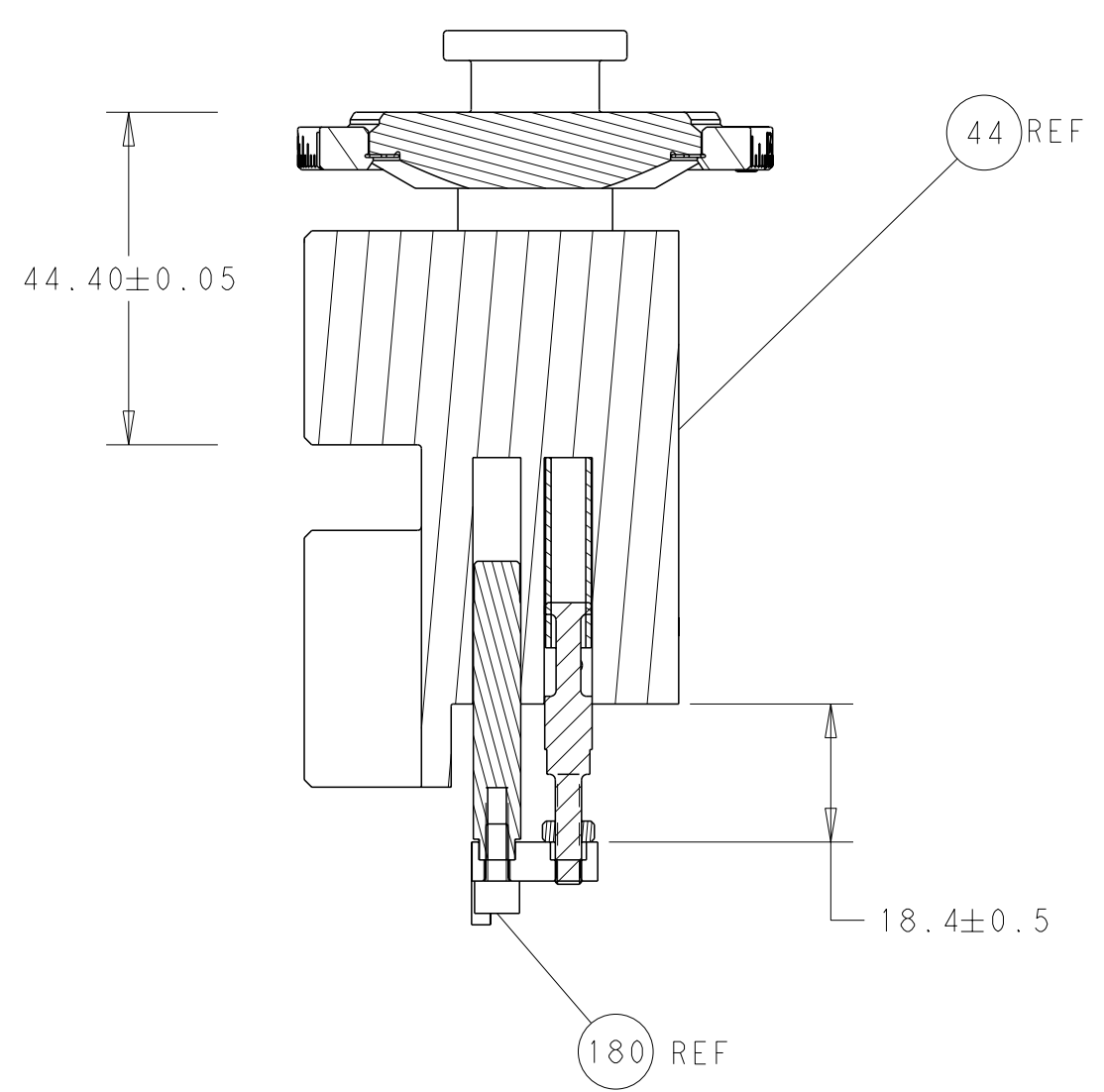
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

LOC	DIST	REVISIONS					
A	66	P	LYR	DESCRIPTION	DATE	OWN	APVD
		A		RELEASED	22JUL2016	MR	TE
		B		ECR-20-011568	17AUG2020	FJ	TE
		C		ECR-20-015103	23OCT2020	FJ	RR

-	1	1	2119641-1	FEED CAM, AIR FEED	248	
-	1	1	2119082-3	CAM, SNAIL, INSULATION ADJUSTMENT	244	
-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243	
	-	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	1	2844940-4	AIR FEED MODULE	238	
	-	1	1	1-18028-0	WASHER, FLAT, REG M8	192
-	1	1	1752354-2	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	1	455888-7	SPACER, CRIMPER	120	
	-	1	1	2119955-2	ASSY, LUBRICATOR, END FEED	84
-	1	1	455888-4	SPACER, CRIMPER	82	
-	1	1	2119791-7	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	2-1901681-2	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	2063961-9	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	1752371-5	PLATE, STRIP GUIDE	24	
-	2	2	2-22281-3	SPRING, COMPRESSION	22	
-	1	1	1803292-1	DRAG	20	
-	1	1	1-1901696-9	STRIP GUIDE, REAR	19	
-	1	1	1-1901695-9	STRIP GUIDE, FRONT	18	
-	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17	
-	1	1	2-240641-8	SPACER	16	
-	1	1	1752360-1	SPACER, HOLD-DOWN	13	
	-	1	1	240644-1	PLATE, REAR SHEAR	11
-	-	-	-	-	10	
	-	1	1	2-690482-7	PLATE, FRONT SHEAR	9
	1	2	1	3-1803060-5	ANVIL, COMBINATION, END FEED	8
	-	1	1	1-2217206-1	BLADE, SLUG	7
-	-	-	-	-	6	
-	1	1	5-240641-3	SPACER	5	
-	1	1	238011-2	BLOCK, CRIMPER SPACER	4	
	1	2	1	1-1633961-9	CRIMPER, INSULATION F PREMIUM	3
-	1	1	455888-2	SPACER, CRIMPER	2	
	1	2	1	8-456406-9	CRIMPER, WIRE PREMIUM	1
-	77	72	2	PART NO	DESCRIPTION	ITEM NO

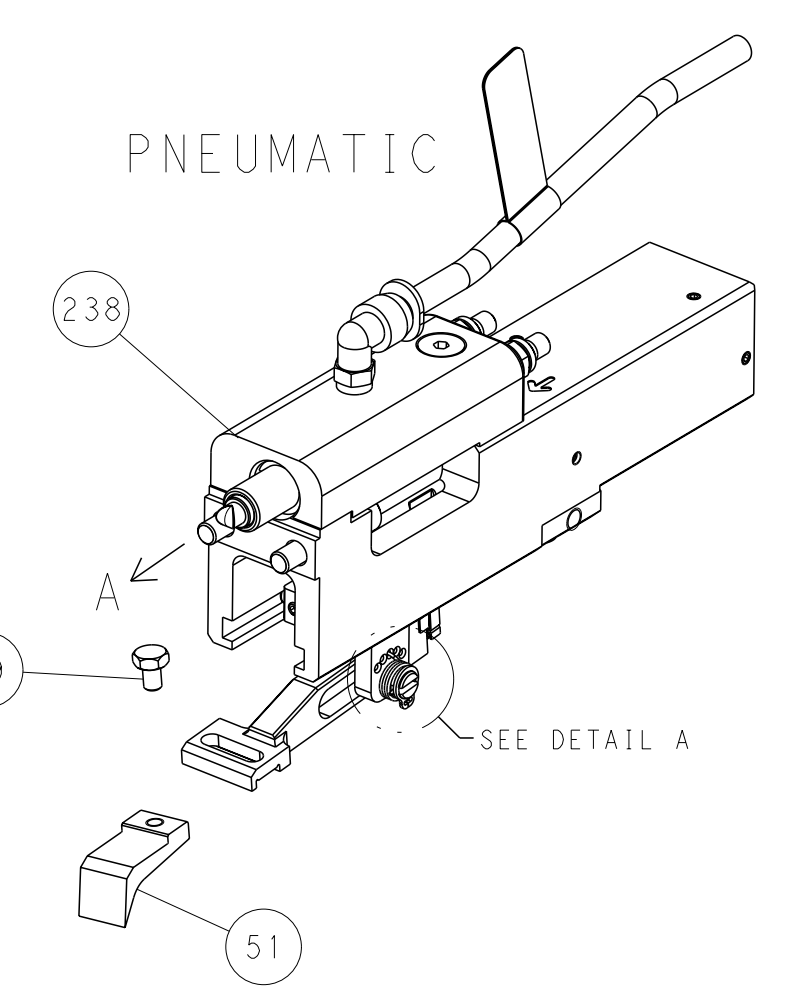
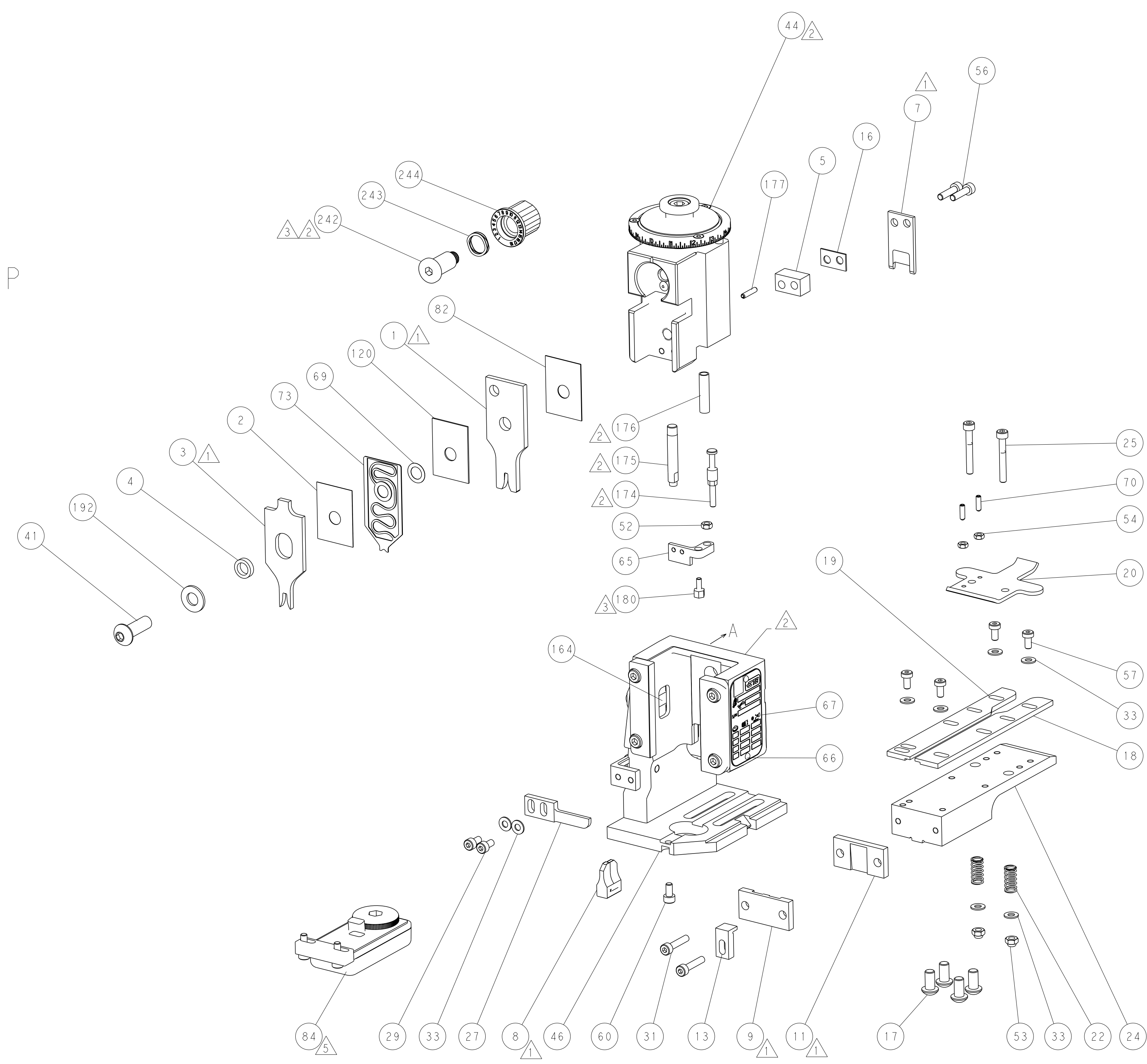
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		OWN		TE Connectivity	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	5 PLC ±	Harrisburg, PA 17105-3608
	ANGLES	FINISH	OTHERWISE SPECIFIED:	DATE	NAME	PRODUCT SPEC	Ocean End Feed Applicator
MATERIAL	WEIGHT	SCALE	RESTRICTED TO	00779	©=2150683	Customer Accessible Production Drawing	SCALE 1:1 SHEET 1 OF 4 REV C

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

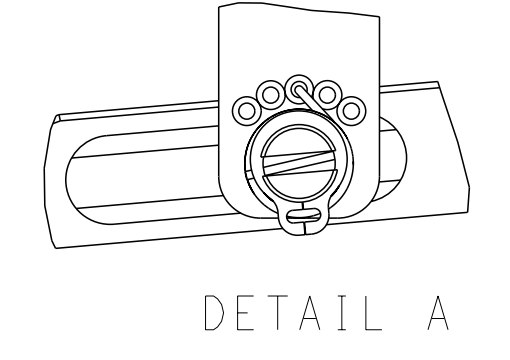


RAM AND HOLDDOWN SET-UP

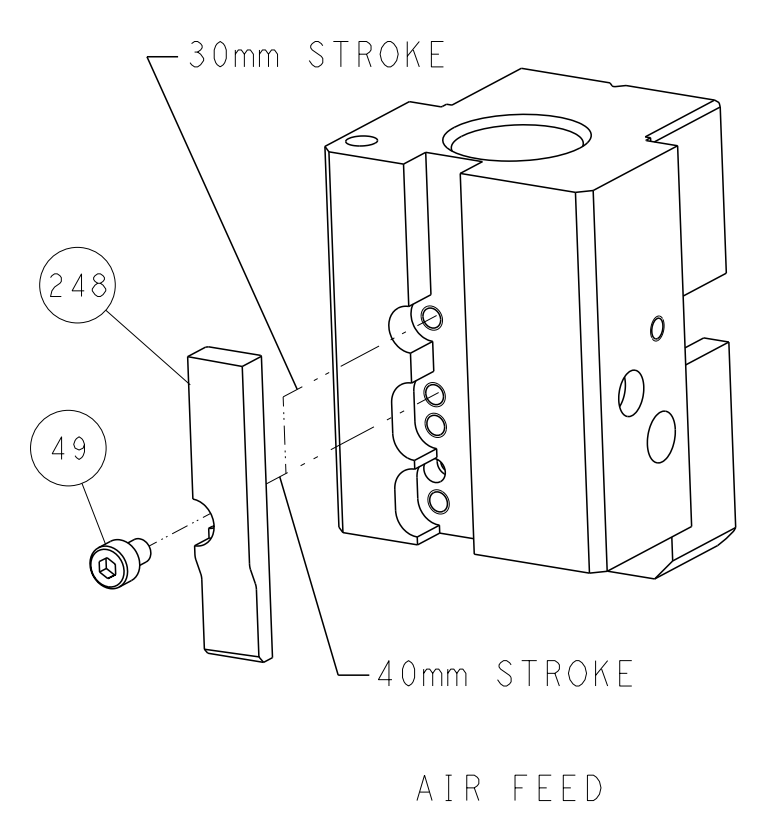
FEED TYPE



FEED SPRING SETTING POSITION



CAM POSITION

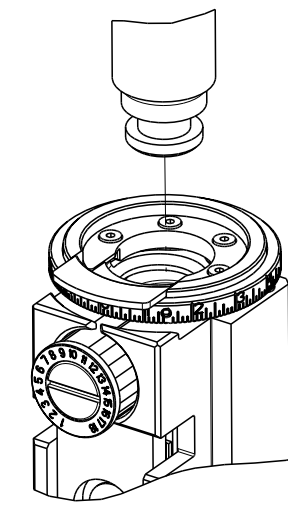


ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

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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=2150683	RESTRICTED TO: - SCALE: 1:1 SHEET: 2 of 4 REV: C	
MATERIAL: - FINISH: -		WEIGHT: - APPLICATION SPEC: - PRODUCT SPEC: -	CUSTOMER ACCESSIBLE PRODUCTION DRAWING	

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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150683-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150683-7	C	CRIMP TOOLING KIT	-

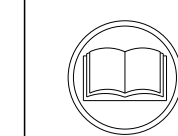
PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.29 mm [.090]	F
INSUL	3.05 mm [.120]	F
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: KIVI TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: TERMINAL			
WIRE STRIP LENGTH 4.55-5.31 mm [.179-.209 IN]		INSULATION DIAMETER RANGE Ø1.90-2.40 mm [.075-.095 IN]	
TERMINAL APPLICATION SPECIFICATION	NONE	-	-
TERMINALS APPLIED			
TE TERMINAL	KIVI TERMINAL	TE TERMINAL	KIVI TERMINAL
2303599-1	DJ611-6.3A		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.75mm2	1.45 +/- 0.05 [.057 +/- .002]	7.5
0.50mm2	1.36 +/- 0.05 [.054 +/- .002]	8.3



- 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 ITEMS 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 TERMINAL LUBRICANT IS RECOMMENDED.
 - 6 TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
7. 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.

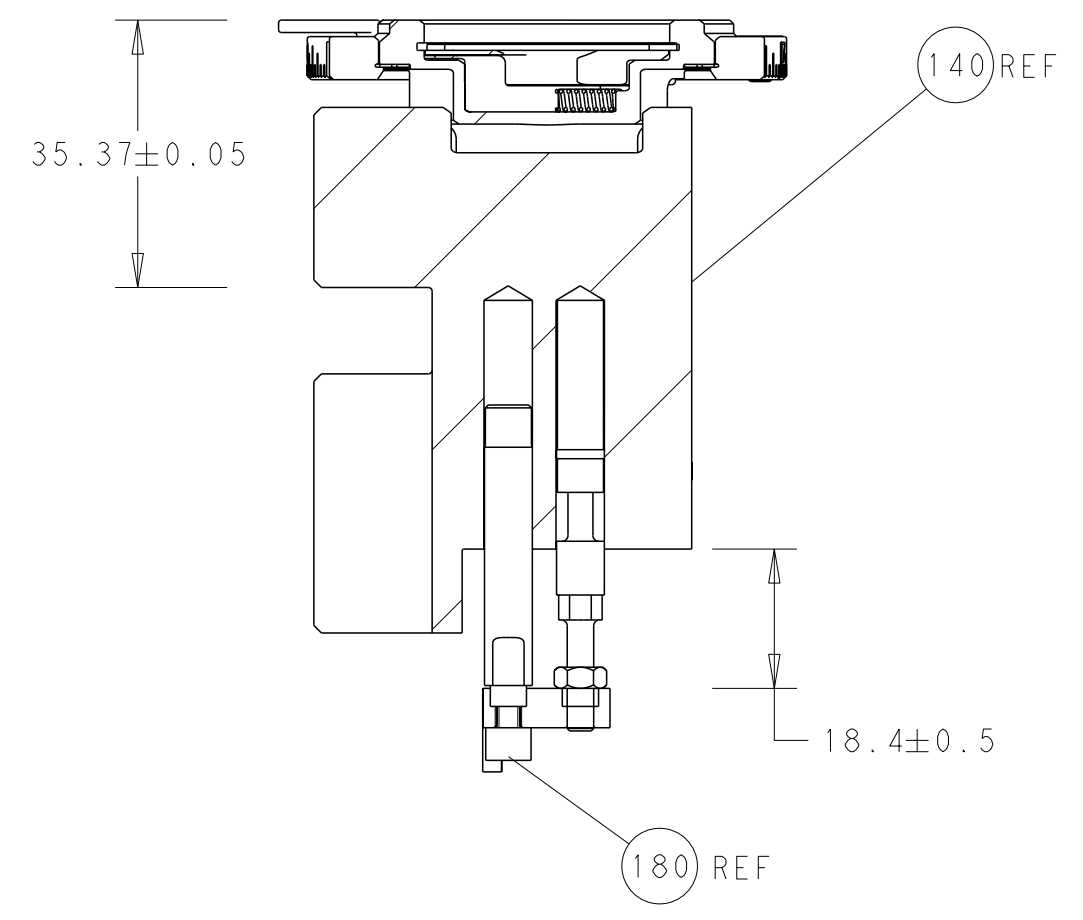
PACIFIC VERSION
Shown on sheets 3 of 4 & 4 of 4
(Atlantic version shown on sheets 1 of 4 & 2 of 4)

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

3	-	1	2119082-3	CAM, SNAIL, INSULATION ADJUSTMENT	244
	-	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
	-	1	2119083-1	RETAINER, INSULATION DIAL	242
	-	1	2844940-4	AIR FEED MODULE	238
	-	1	1-18028-0	WASHER, FLAT, REG M8	192
3	-	4	2079383-9	SCR, BHSC, RoHS (M6 X 20)	186
	-	1	1752354-2	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	455888-7	SPACER, CRIMPER	120
5	-	1	2119955-2	ASSY, LUBRICATOR, END FEED	84
	-	1	455888-4	SPACER, CRIMPER	82
	-	1	2119791-7	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	2-1901681-2	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	2063961-9	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	1752371-5	PLATE, STRIP GUIDE	24
	-	2	2-22281-3	SPRING, COMPRESSION	22
	-	1	1803292-1	DRAG	20
	-	1	1-1901696-9	STRIP GUIDE, REAR	19
	-	1	1-1901695-9	STRIP GUIDE, FRONT	18
	-	1	2-240641-8	SPACER	16
	-	1	1752360-1	SPACER, HOLD-DOWN	13
1	-	1	240644-1	PLATE, REAR SHEAR	11
	-	-	-	-	10
1	-	1	2-690482-7	PLATE, FRONT SHEAR	9
1	1	1	3-1803060-5	ANVIL, COMBINATION, END FEED	8
1	-	1	1-2217206-1	BLADE, SLUG	7
	-	-	-	-	6
	-	1	5-240641-3	SPACER	5
	-	1	238011-2	BLOCK, CRIMPER SPACER	4
1	1	1	1-1633961-9	CRIMPER, INSULATION F PREMIUM	3
	-	1	455888-2	SPACER, CRIMPER	2
1	1	1	8-456406-9	CRIMPER, WIRE PREMIUM	1
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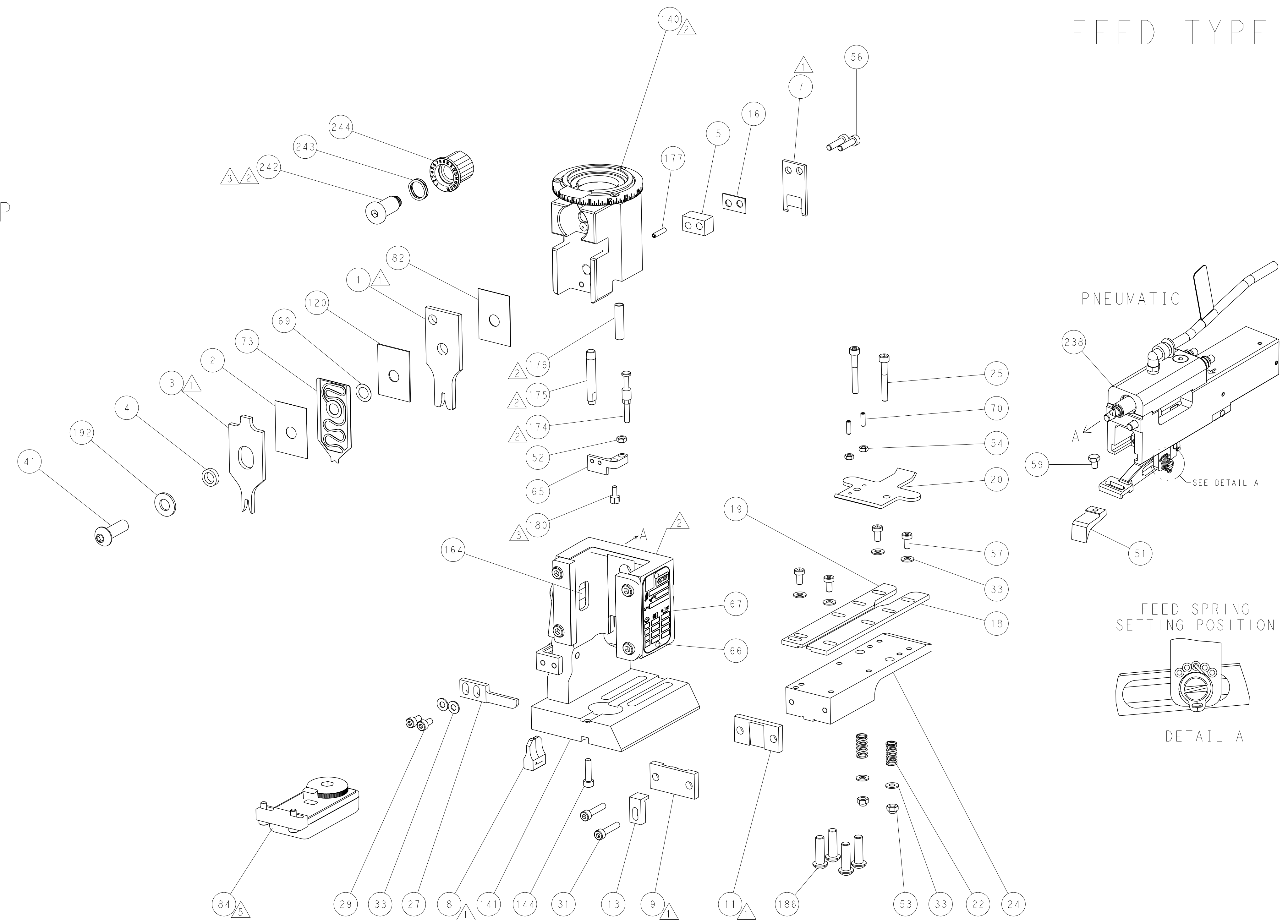
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		OWN: B. WEAVER 16 JUN 2016		TE Connectivity Harrisburg, PA 17105-3608	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	APVD: T. ELBIN 16 JUN 2016	NAME: Ocean End Feed Applicator
MATERIAL:		FINISH:		WEIGHT:		SIZE: A1 00779 C=2150683	
						Customer Accessible Production Drawing	
						SCALE: 1:1 SHEET 3 OF 4 REV C	

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

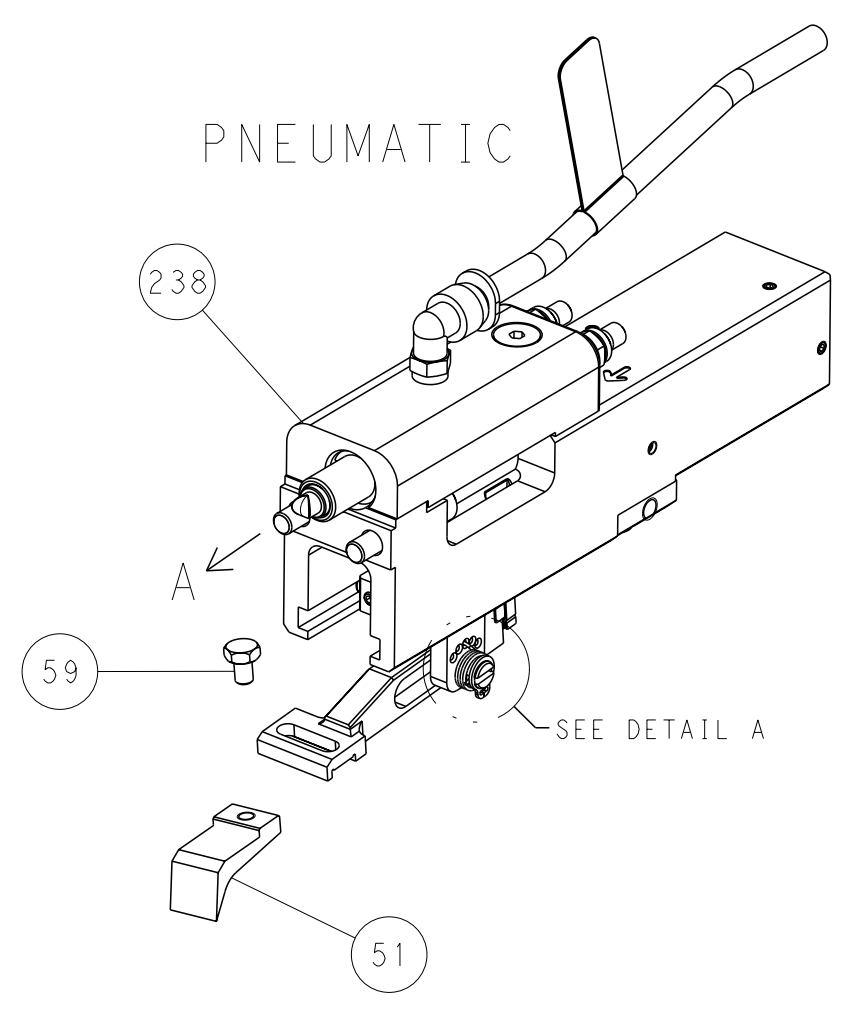


RAM AND HOLDDOWN SET-UP

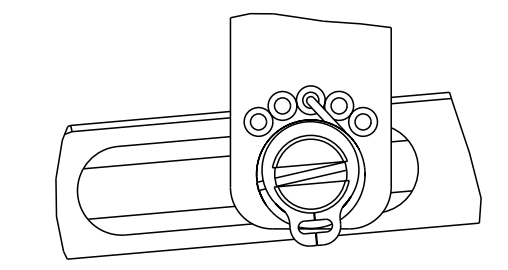
FEED TYPE



PNEUMATIC

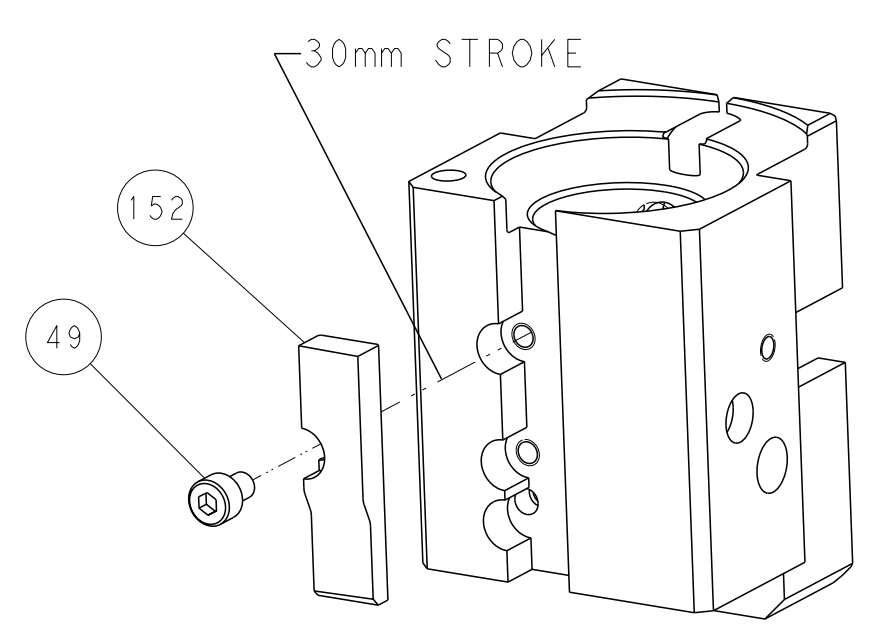


FEED SPRING SETTING POSITION



DETAIL A

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 FINISH ±	WEIGHT: - SCALE: 1:1 SHEET: 4 of 4 REV: C	CUSTOMER ACCESSIBLE PRODUCTION DRAWING		