

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150705-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2150705-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150705-1	B	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2150705-2	B	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150705-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.80 mm [.110]	F
INSUL	4.20 mm [.165]	F
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL PRONER CRIMP SPECIFICATION	
TERMINAL NAME: LOW INSERTION FORCE RECEPTACLE	
WIRE STRIP LENGTH 5.35-6.11 mm [.211-.241 IN]	INSULATION DIAMETER RANGE Ø2.60-3.70 mm [.102-.146 IN]
TERMINAL APPLICATION SPECIFICATION 3237 C 002 Rev B1	
TERMINALS APPLIED	
TE TERMINAL 1544323-1	TE TERMINAL 1544323-2
TE TERMINAL 1544323-3	TE TERMINAL 1544323-4

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
2.50mm2	2.07 +/- 0.05 [.081 +/- .002]	4.8
1.50mm2	1.80 +/- 0.05 [.071 +/- .002]	7.5
1.00mm2	1.66 +/- 0.05 [.065 +/- .002]	8.8

- 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.

**\*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.

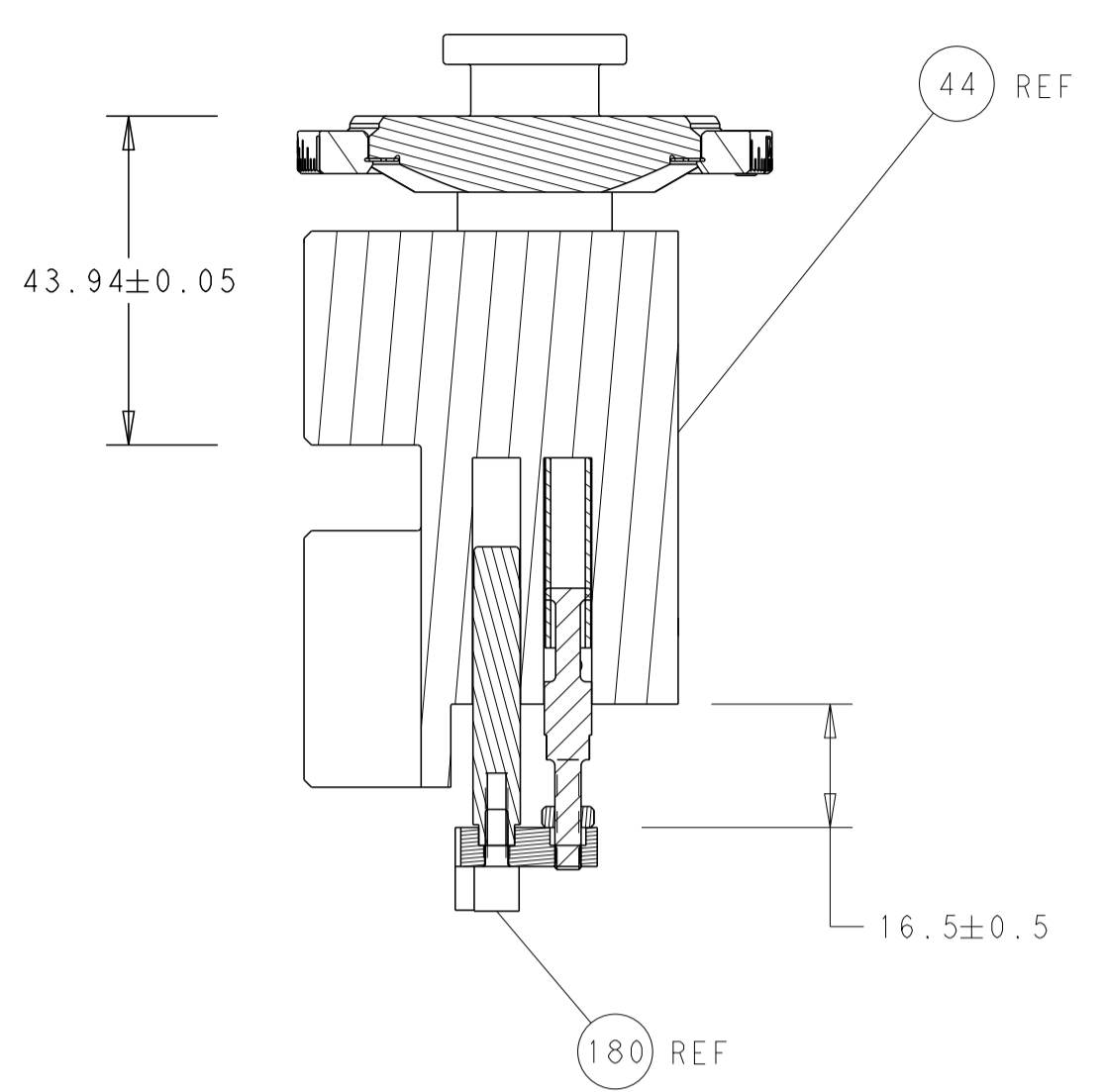
**ATLANTIC VERSION**  
Shown on sheets 1 of 4 & 2 of 4  
(Pacific version shown on sheets 3 of 4 & 4 of 4)

LOC	DIST	REVISIONS					
		P	LTN	DESCRIPTION	DATE	DWN	APVD
A	66	1		DEVELOPMENT	22JUL2016	JH	LZ
		A		RELEASED	02SEP2016	JH	TE
		B		ECR-22-137756	02MAY2022	JWC	ROY

-	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	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	-	1	-	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	1	-	1	-	2844940-3	AIR FEED MODULE	238
3	1	1	1	1	4-1752354-2	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	2119955-2	ASSY, LUBRICATOR, END FEED	84
-	1	1	1	1	455888-5	SPACER, CRIMPER	82
-	1	1	1	1	2119791-9	DEPRESSOR, WIRE	73
-	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
-	2	2	2	2	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	31
-	2	2	2	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	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
-	2	2	2	2	1901259-4	GUIDE, LOWER STRIP	18
-	4	4	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17
-	1	1	1	1	6-240641-4	SPACER	16
-	1	1	1	1	1752360-1	SPACER, HOLD-DOWN	13
1	1	1	1	1	240644-1	PLATE, REAR SHEAR	11
-	-	-	-	-	-	-	10
1	1	1	1	1	690482-7	PLATE, FRONT SHEAR	9
1	2	2	1	1	5-1803059-5	ANVIL, COMBINATION, END FEED	8
1	1	1	1	1	1-2217206-7	BLADE, SLUG	7
-	-	-	-	-	-	-	6
-	1	1	1	1	240641-4	SPACER	5
-	1	1	1	1	2-238011-6	BLOCK, CRIMPER SPACER	4
1	2	2	1	1	1803260-8	CRIMPER, INSULATION F PREMIUM	3
-	1	1	1	1	455888-1	SPACER, CRIMPER	2
1	2	2	1	1	4-1633730-7	CRIMPER, WIRE	1
-77-72-71-2-1					PART NO	DESCRIPTION	ITEM NO

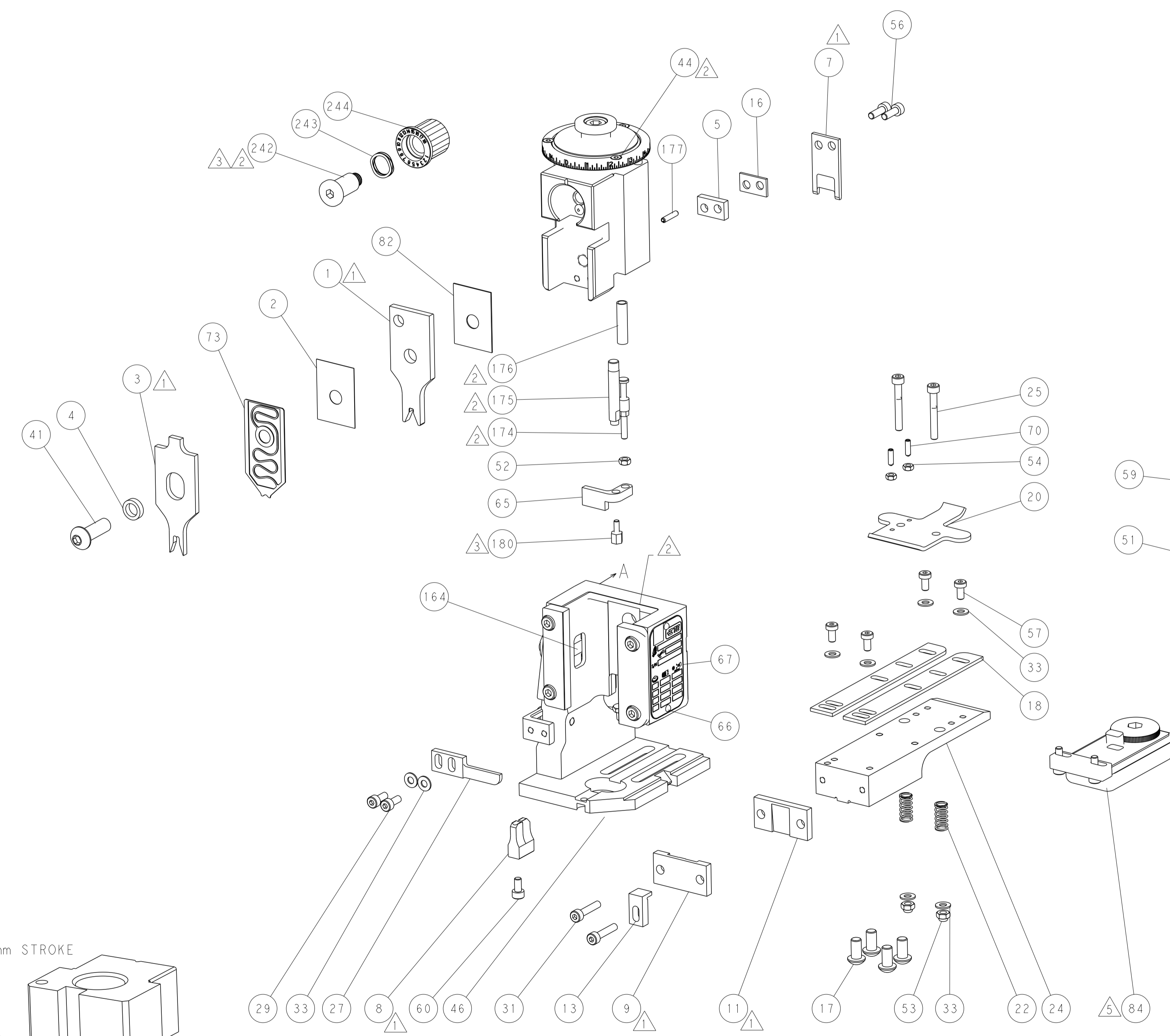
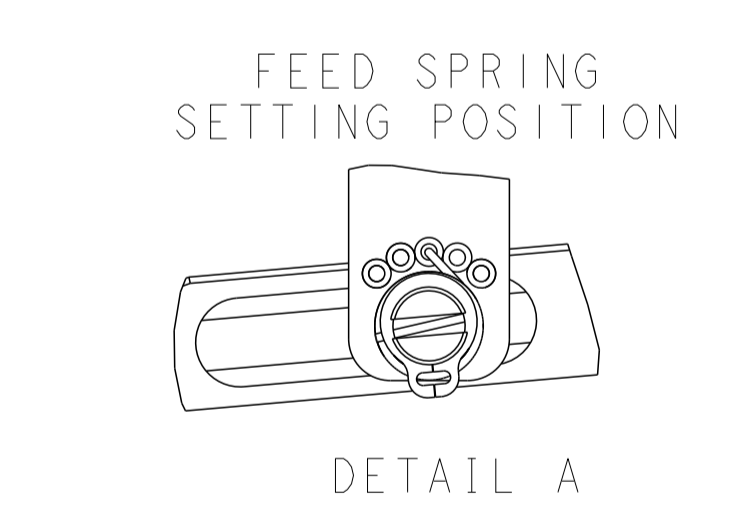
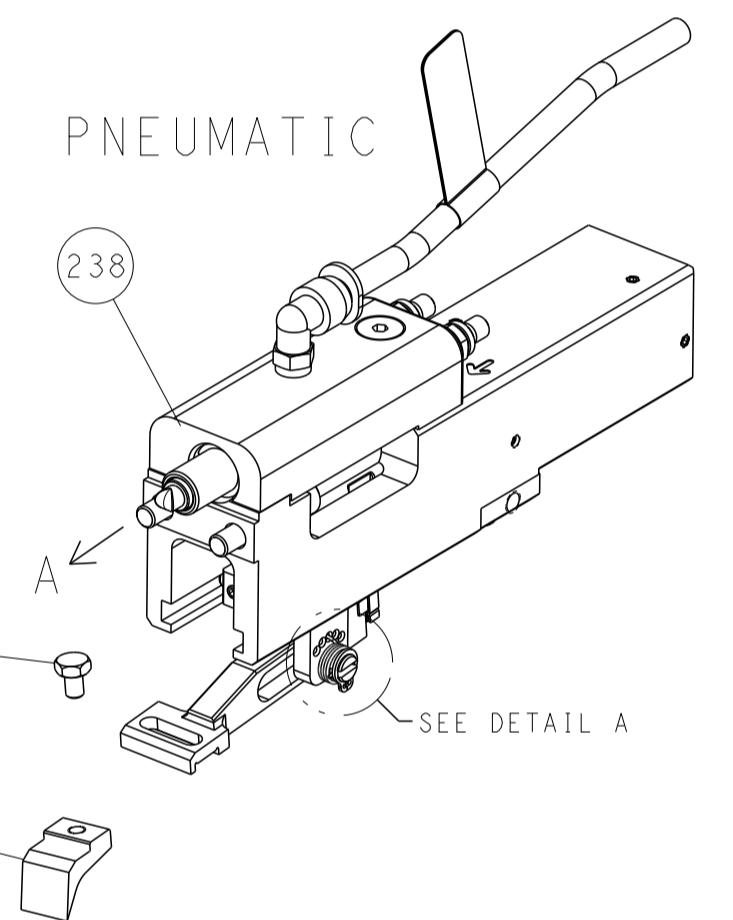
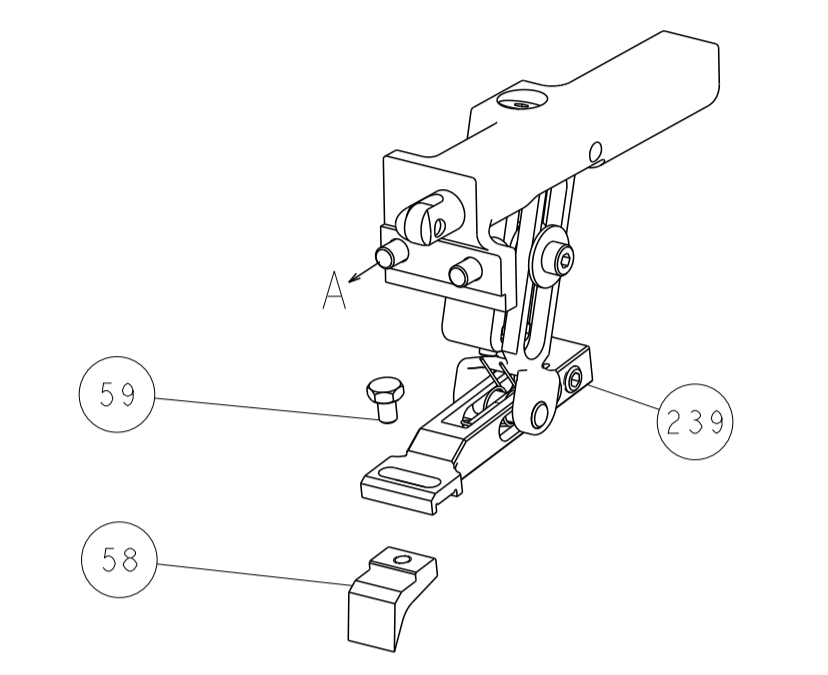
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN J. HOU 22JUL2016		TE Connectivity	
mm		0 PLC ±		CHK L. ZHANG 22JUL2016		Harrisburg, PA 17105-3608	
Ø		1 PLC ±		APVD L. ZHANG 22JUL2016		NAME	
H		2 PLC ±		PRODUCT SPEC		Ocean End Feed	
D		3 PLC ±		APPLICATION SPEC		Applicator	
R		4 PLC ±		SIZE		CAGE CODE DRAWING NO	
A		ANGLES		A1 00779 C=2150705		RESTRICTED TO	
FINISH		FINISH		WEIGHT		SCALE 1:1 SHEET 1 OF 4 REV B	
MATERIAL				CUSTOMER ACCESSIBLE PRODUCTION			

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

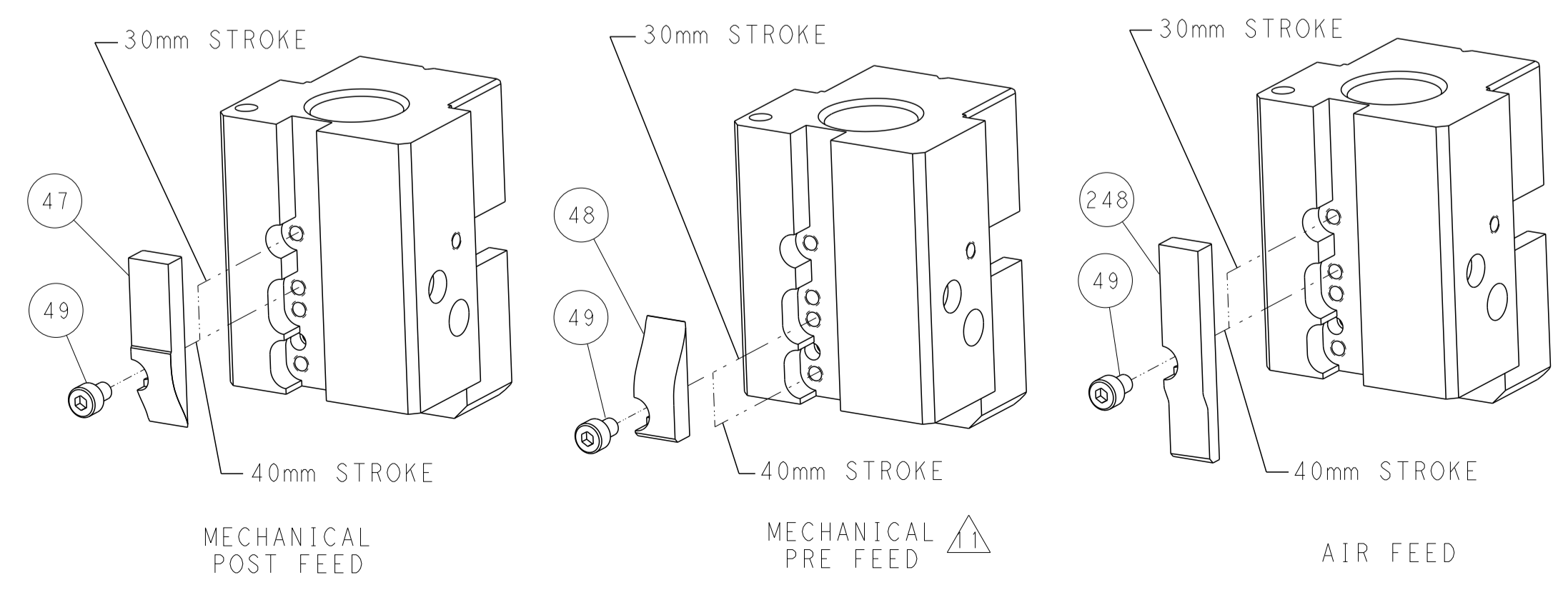


RAM AND HOLDDOWN SET-UP

FEED TYPE  
MECHANICAL



CAM POSITIONS

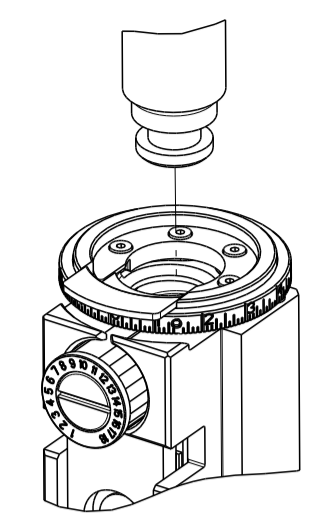


ATLANTIC VERSION  
 Shown on sheets 1 of 4 & 2 of 4  
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG		REV	
mm	0 PLC	±		J. HOU	22 JUL 2016		
	1 PLC	±		CHK L. ZHANG	22 JUL 2016		
	2 PLC	±		APVD L. ZHANG	22 JUL 2016		
	3 PLC	±					
	4 PLC	±					
	ANGLES	±					
	FINISH	±					
MATERIAL				NAME	Ocean End Feed Applicator		
				SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
				A1	00779	©=2150705	
				CUSTOMER ACCESSIBLE PRODUCTION	SCALE	1:1	SHEET 2 OF 4 REV B

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150705-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2150705-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150705-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR  
 INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.80 mm [1.10]	F
INSUL	4.20 mm [1.65]	F
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL PRONER CRIMP SPECIFICATION			
TERMINAL NAME: LOW INSERTION FORCE RECEPTACLE			
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE		
5.35-6.11 mm [1.211-.241 IN]	∅2.60-3.70 mm [1.102-.146 IN]		
TERMINAL APPLICATION SPECIFICATION	3237 C 002 Rev B1	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
1544323-1	1544323-2	1544323-3	1544323-4
1544323-7			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
2.50mm2	2.07+/-0.05 [1.081+/-0.002]	4.8
1.50mm2	1.80+/-0.05 [1.071+/-0.002]	7.5
1.00mm2	1.66+/-0.05 [1.065+/-0.002]	8.8



- 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.
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- 6. 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.

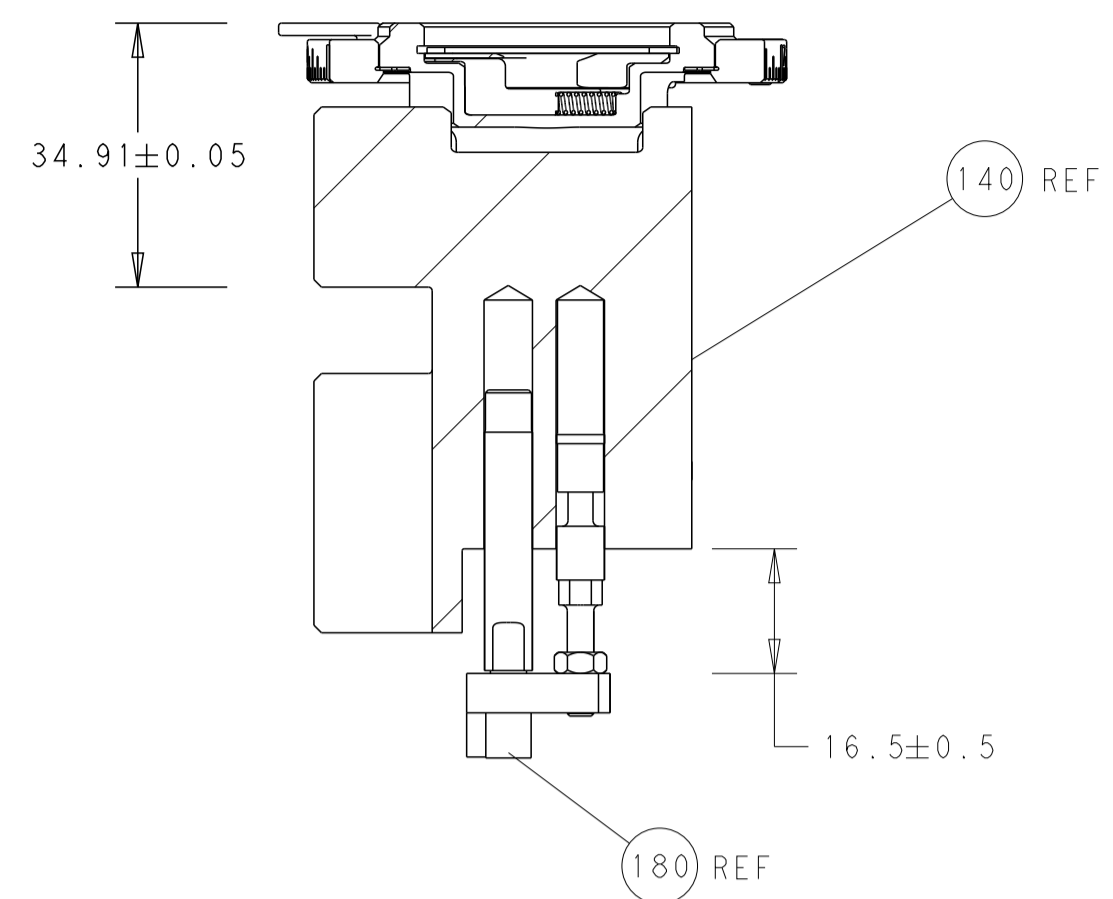
**PACIFIC VERSION**  
 Shown on sheets 3 of 4 & 4 of 4  
 (Atlantic version shown on sheets 1 of 4 & 2 of 4)

LOC	DIST	REVISIONS					
A	66	P	LTN	DESCRIPTION	DATE	OWN	APVD
-	-	-	-	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
-	4	4	2079383-9	SCR, BHSC, RoHS (M6 X 20)	186
3	-	1	4-1752354-2	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	-	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	2119955-2	ASSY, LUBRICATOR, END FEED	84
-	1	1	455888-5	SPACER, CRIMPER	82
-	1	1	2119791-9	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	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
-	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	1752371-1	PLATE, STRIP GUIDE	24
-	2	2	2-22281-3	SPRING, COMPRESSION	22
-	1	1	1803292-4	DRAG	20
-	2	2	1901259-4	GUIDE, LOWER STRIP	18
-	1	1	6-240641-4	SPACER	16
-	1	1	1752360-1	SPACER, HOLD-DOWN	13
1	-	1	240644-1	PLATE, REAR SHEAR	11
-	-	-	-	-	10
-	1	1	690482-7	PLATE, FRONT SHEAR	9
1	1	1	5-1803059-5	ANVIL, COMBINATION, END FEED	8
1	-	1	1-2217206-7	BLADE, SLUG	7
-	-	-	-	-	6
-	1	1	240641-4	SPACER	5
-	1	1	2-238011-6	BLOCK, CRIMPER SPACER	4
1	1	1	1803260-8	CRIMPER, INSULATION F PREMIUM	3
-	1	1	455888-1	SPACER, CRIMPER	2
1	1	1	4-1633730-7	CRIMPER, WIRE	1
-	77	22	21	PART NO	ITEM NO

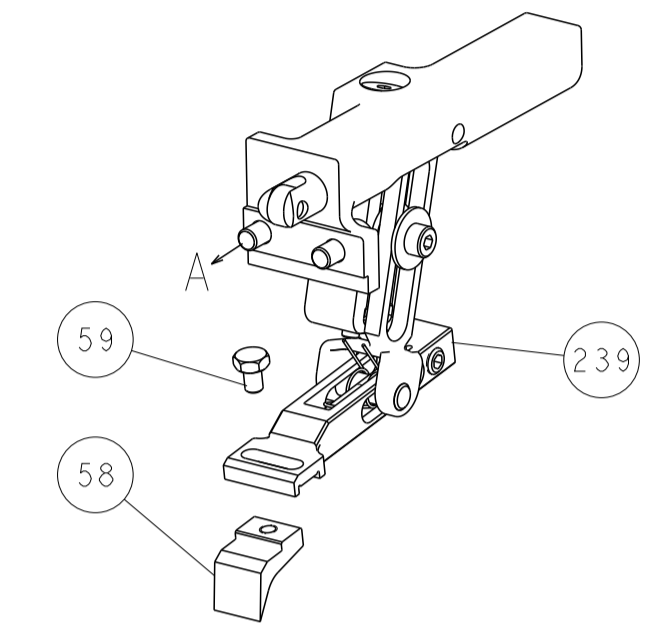
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DRAWING NO	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±
	ANGLES	FINISH			
MATERIAL		FINISH		WEIGHT	
				A1 00779 ©=2150705	
CUSTOMER ACCESSIBLE PRODUCTION				SCALE 1:1 SHEET 3 OF 4 REV B	

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

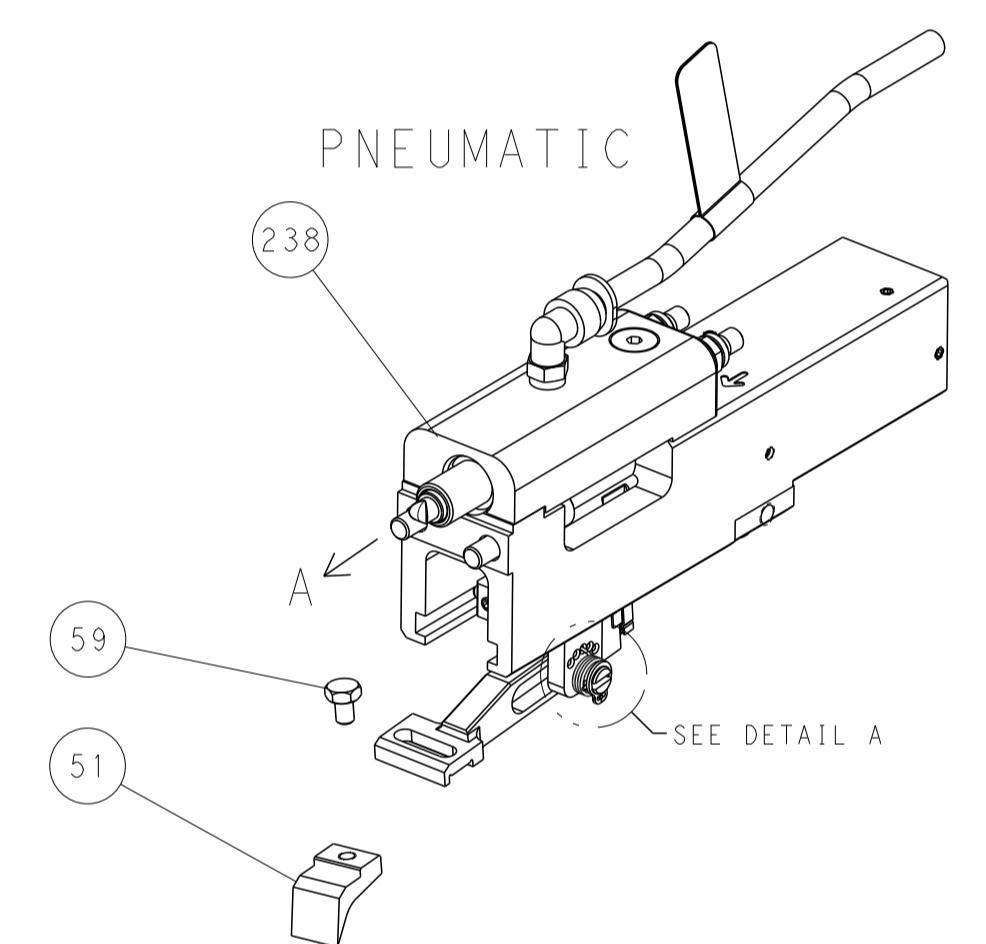


RAM AND HOLDDOWN SET-UP

FEED TYPE  
MECHANICAL



PNEUMATIC



FEED SPRING  
SETTING POSITION

