

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150097-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2150097-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150097-1	B	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2150097-2	B	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150097-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP SIZE	TYPE	
WIRE 2.54 mm [1.00]	F	
INSUL -	-	
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION	
TERMINAL NAME: .109 DIA PIN RECEPTACLE	
WIRE STRIP LENGTH 4.00-4.50 mm [1.57-.177 IN]	INSULATION DIAMETER RANGE Ø -
TERMINAL APPLICATION SPECIFICATION 114-2080	-
TERMINALS APPLIED 5	
TE TERMINAL 61012-1	TE TERMINAL 61012-3

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
14 AWG	1.80+/-0.05 [1.071+/-0.002]	4.4
16 AWG	1.55+/-0.05 [1.061+/-0.002]	7.6
18 AWG	1.40+/-0.05 [1.055+/-0.002]	9.2

- 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.
- 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.

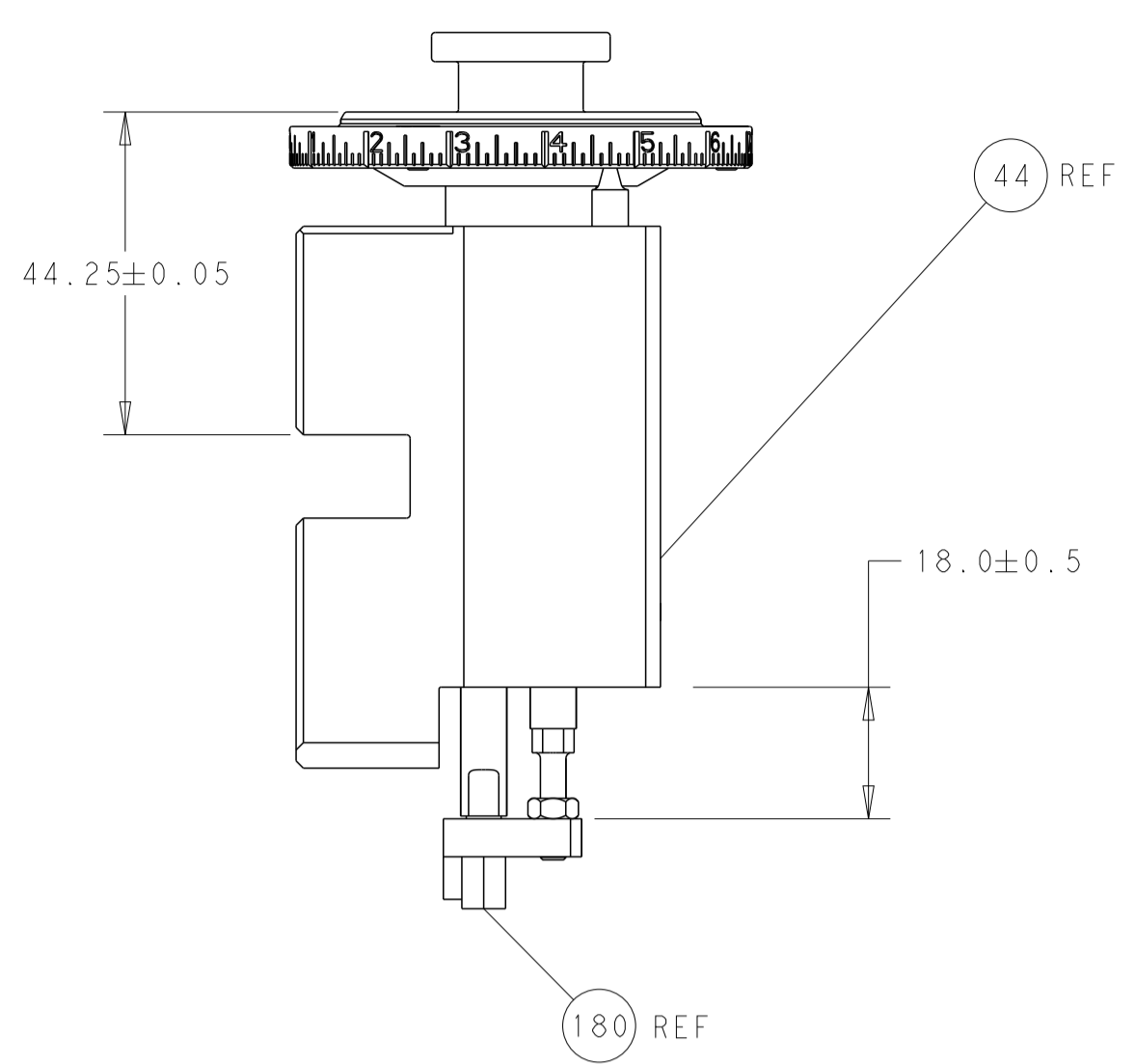
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

LOC	DIST	REVISIONS					
A	66	P	LTN	DESCRIPTION	DATE	DWN	APVD
		A		RELEASED	21JAN2015	KH	TE
		B		ECR-19-001443	28JAN2019	TB	CT

-	1	-	1	-	2119640-1	PUSH ROD, AIR FEED	250	
-	1	-	1	-	1803259-1	BUSHING, FLANGED	249	
-	-	1	-	1	2119641-1	FEED CAM, AIR FEED	248	
-	-	1	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239	
-	1	-	1	-	2063440-1	AIR FEED MODULE	238	
3	-	1	1	1	1-1752354-3	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	
-	2	-	2	-	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172	
-	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164	
-	1	-	1	-	240638-1	SPRING, FEED FINGER	163	
-	1	-	1	-	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854	137	
5	-	1	1	1	2119955-2	ASSY, LUBRICATOR, END FEED	84	
-	1	1	1	1	455888-7	SPACER, CRIMPER	82	
-	1	1	1	1	1-2119791-0	DEPRESSOR, WIRE	73	
-	1	1	1	1	1803607-2	DOCUMENTATION PACKAGE	71	
-	2	2	2	2	2-18032-2	SCR, SET, FLT PNT, M3 X 10.0	70	
-	1	1	1	1	2119943-1	WASHER, SPACER	69	
-	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	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	-	2119792-2	PAWL, EF, AIR	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	1752371-5	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	6-240641-7	SPACER	16	
-	1	1	1	1	1752360-1	SPACER, HOLD-DOWN	13	
1	-	1	1	1	240644-9	PLATE, REAR SHEAR	11	
-	-	-	-	-	-	-	10	
1	-	1	1	1	5-690482-6	PLATE, FRONT SHEAR	9	
1	1	2	2	1	1803002-9	ANVIL, COMBINATION, END FEED	8	
1	-	1	1	1	2217206-1	BLADE, SLUG	7	
-	1	1	1	1	1803203-1	BLOCK, FRONT DEPRESSOR	6	
-	1	1	1	1	2-240641-9	SPACER	5	
-	-	-	-	-	-	-	3	
-	1	1	1	1	1-455888-0	SPACER, CRIMPER	2	
1	1	2	2	1	456407-6	CRIMPER, WIRE PREMIUM	1	
-	77	72	71	2	-1	PART NO	DESCRIPTION	ITEM NO

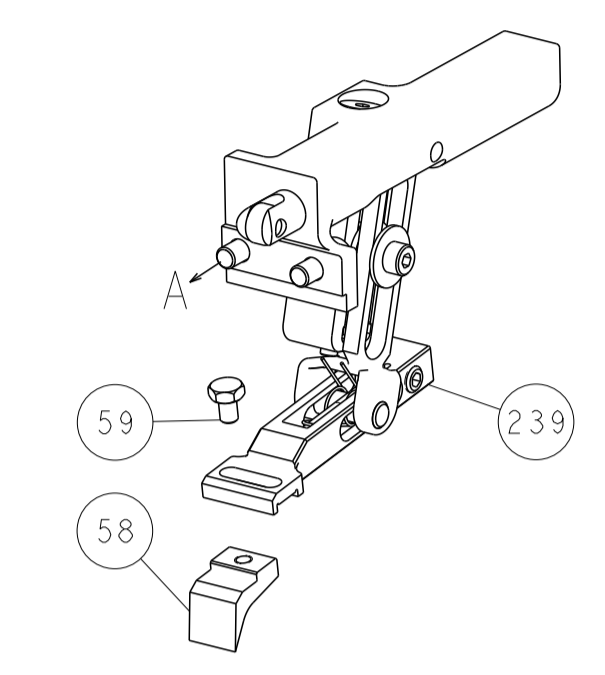
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mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES	FINISH			A1	00779	2150097	1	4	B

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

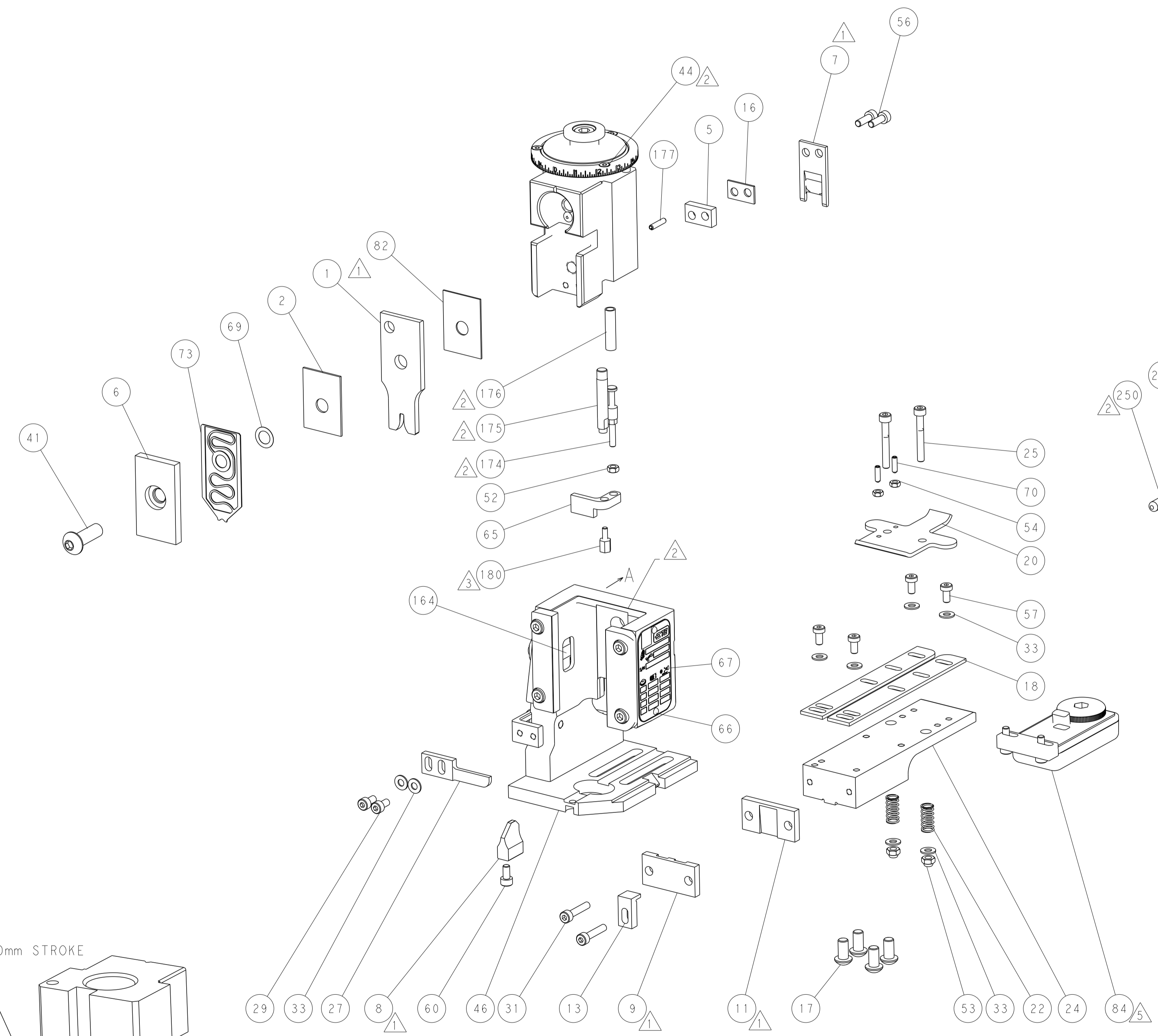
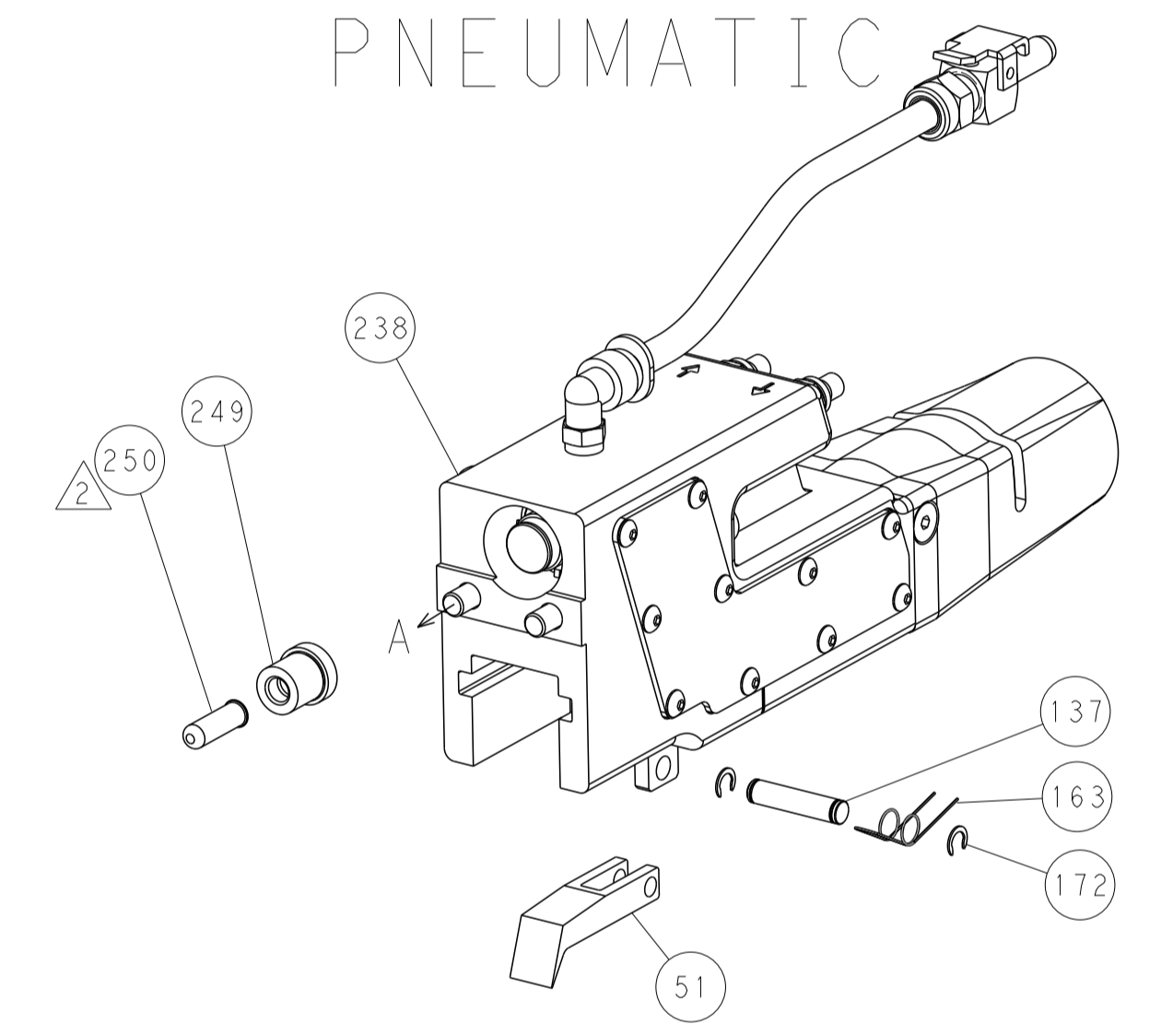


RAM AND HOLDDOWN SET-UP

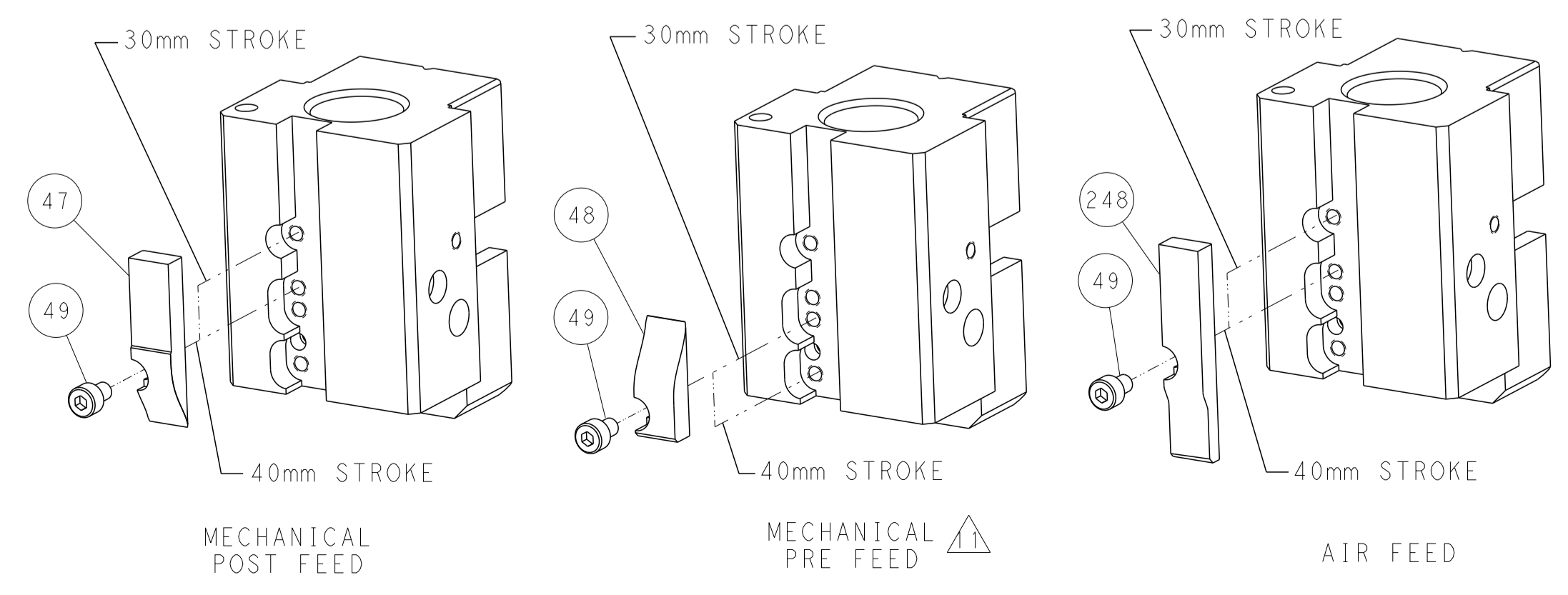
FEED TYPE
MECHANICAL



PNEUMATIC



CAM POSITIONS



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

<small>THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.</small>		DWN: K. HUANG 19DEC2014 CHK: L. ZHANG 19DEC2014 APVD: J. GUO 19DEC2014	NAME: Ocean End Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: C-2150097	TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH ±	MATERIAL: - FINISH: -	WEIGHT: - SCALE: 1:1	SHEET 2 OF 4 REV B	RESTRICTED TO: -

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COPYRIGHT © BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.			
PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150097-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2150097-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150097-7	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 RECEPTACLE			
WIRE STRIP LENGTH 4.00-4.50 mm (.157-.177 IN)		INSULATION DIAMETER RANGE Ø -	
TERMINAL APPLICATION SPECIFICATION 114-2080		-	
TERMINALS APPLIED			
TE TERMINAL 61012-1	TE TERMINAL 61012-3	TE TERMINAL	TE TERMINAL

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
14 AWG	1.80 +/- 0.05 [0.071 +/- .002]	4.4
16 AWG	1.55 +/- 0.05 [0.061 +/- .002]	7.6
18 AWG	1.40 +/- 0.05 [0.055 +/- .002]	9.2



- △ 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.

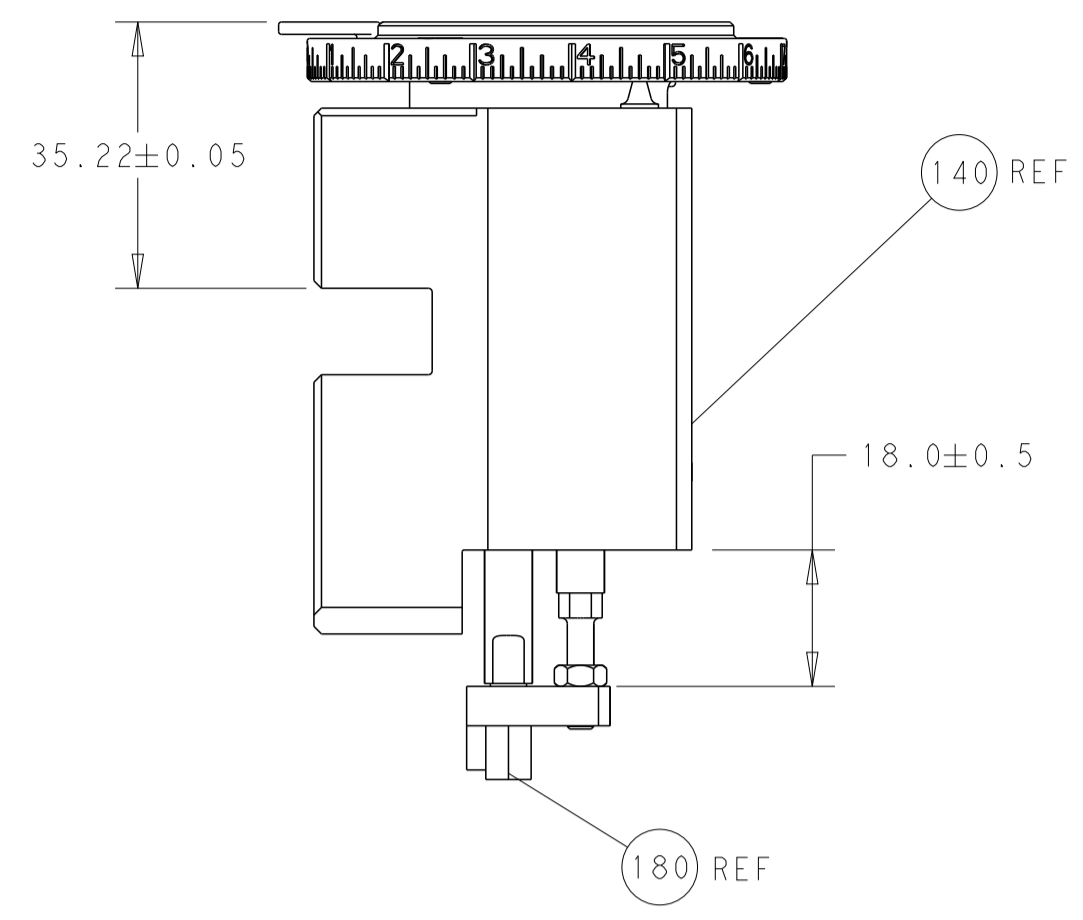
***WARNING**
ON INSTALLATION, SET WIRE DISC TO CRIMP HEIGHT REFERENCE SETTING FOR LARGEST WIRE SIZE. CRIMP HEIGHT REFERENCE SETTINGS GREATER THAN THE VALUE SHOWN MAY CAUSE DAMAGE TO THE CRIMP TOOLING. REFER TO THE INSTRUCTION SHEET FOR PROPER SETUP AND ADJUSTMENTS.

LOC	DIST	REVISIONS					
		P	LTN	DESCRIPTION	DATE	OWN	APVD
A	66	-	-	SEE SHEET 1	-	-	-
-	1	-	-	2119640-1	PUSH ROD, AIR FEED		250
-	1	-	-	1803259-1	BUSHING, FLANGED		249
-	-	1	-	2119580-1	MECHANICAL FEED ASSEMBLY		239
-	1	-	-	2063440-1	AIR FEED MODULE		238
-	4	4	-	2079383-9	SCR, BHSC, RoHS (M6 X 20)		186
△	1	1	-	1-1752354-3	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
-	2	-	-	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT		172
-	REF	REF	-	994970-2	COUNTER, MAGNETIC		164
-	1	-	-	240638-1	SPRING, FEED FINGER		163
-	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	-	-	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854		137
△	1	1	-	2119955-2	ASSY, LUBRICATOR, END FEED		84
-	1	1	-	455888-7	SPACER, CRIMPER		82
-	1	1	-	1-2119791-0	DEPRESSOR, WIRE		73
-	1	1	-	1803607-2	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	-	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	-	-	2119792-2	PAWL, EF, AIR		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	-	1752371-5	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	-	6-240641-7	SPACER		16
-	1	1	-	1752360-1	SPACER, HOLD-DOWN		13
△	1	1	-	240644-9	PLATE, REAR SHEAR		11
-	-	-	-	-	-		10
△	1	1	-	5-690482-6	PLATE, FRONT SHEAR		9
△	1	1	1	1803002-9	ANVIL, COMBINATION, END FEED		8
△	1	1	-	2217206-1	BLADE, SLUG		7
-	1	1	-	1803203-1	BLOCK, FRONT DEPRESSOR		6
-	1	1	-	2-240641-9	SPACER		5
-	-	-	-	-	-		3
-	1	1	-	1-455888-0	SPACER, CRIMPER		2
△	1	1	1	456407-6	CRIMPER, WIRE PREMIUM		1
-	77	22	21	PART NO	DESCRIPTION		ITEM NO

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

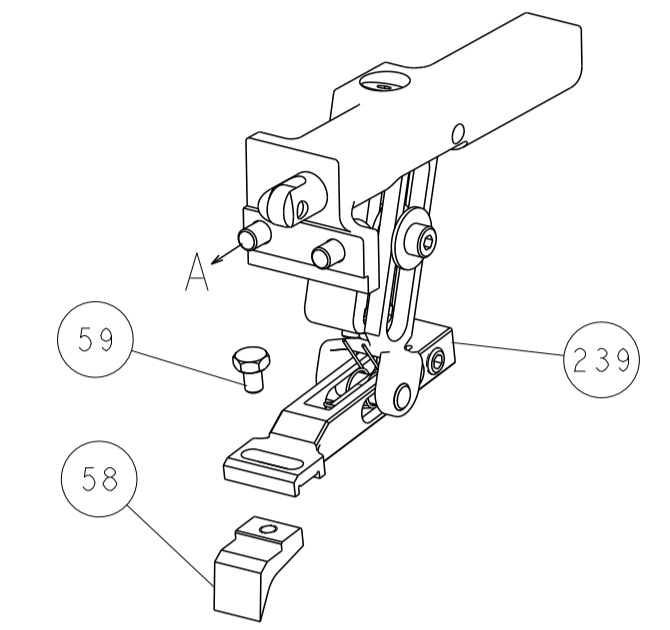
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN R. HUANG CHK L. ZHANG APVD J. GUO		19DEC2014 19DEC2014 19DEC2014		STE TE Connectivity Harrisburg, PA 17105-3608	
MATERIAL		FINISH		PRODUCT SPEC		APPLICATION SPEC		NAME Ocean End Feed Applicator	
WEIGHT		SCALE		CAGE CODE		DRAWING NO		RESTRICTED TO	
Customer Accessible Production Drawing		SCALE 1:1		00779		C=2150097		SHEET 3 OF 4 REV B	

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

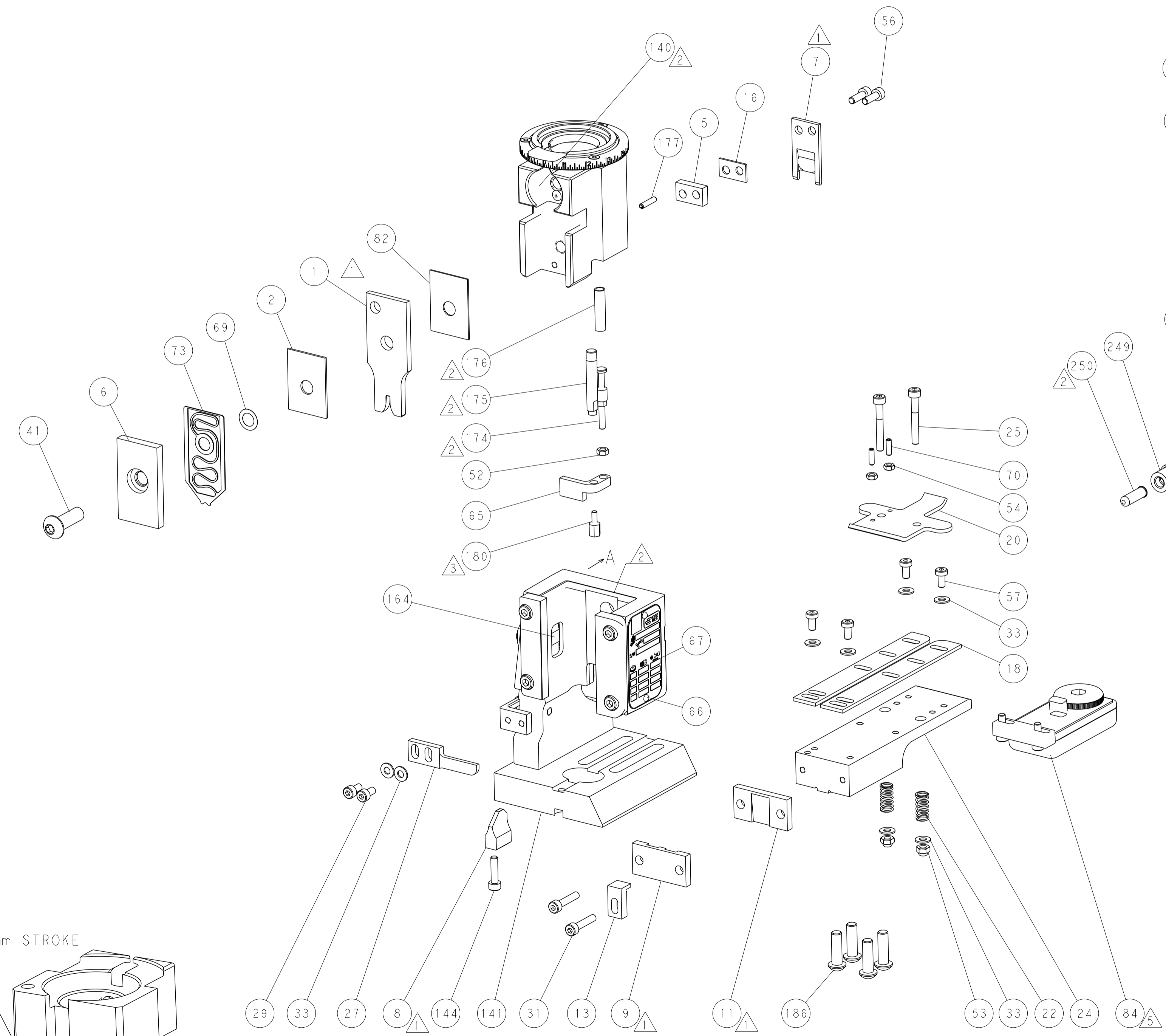
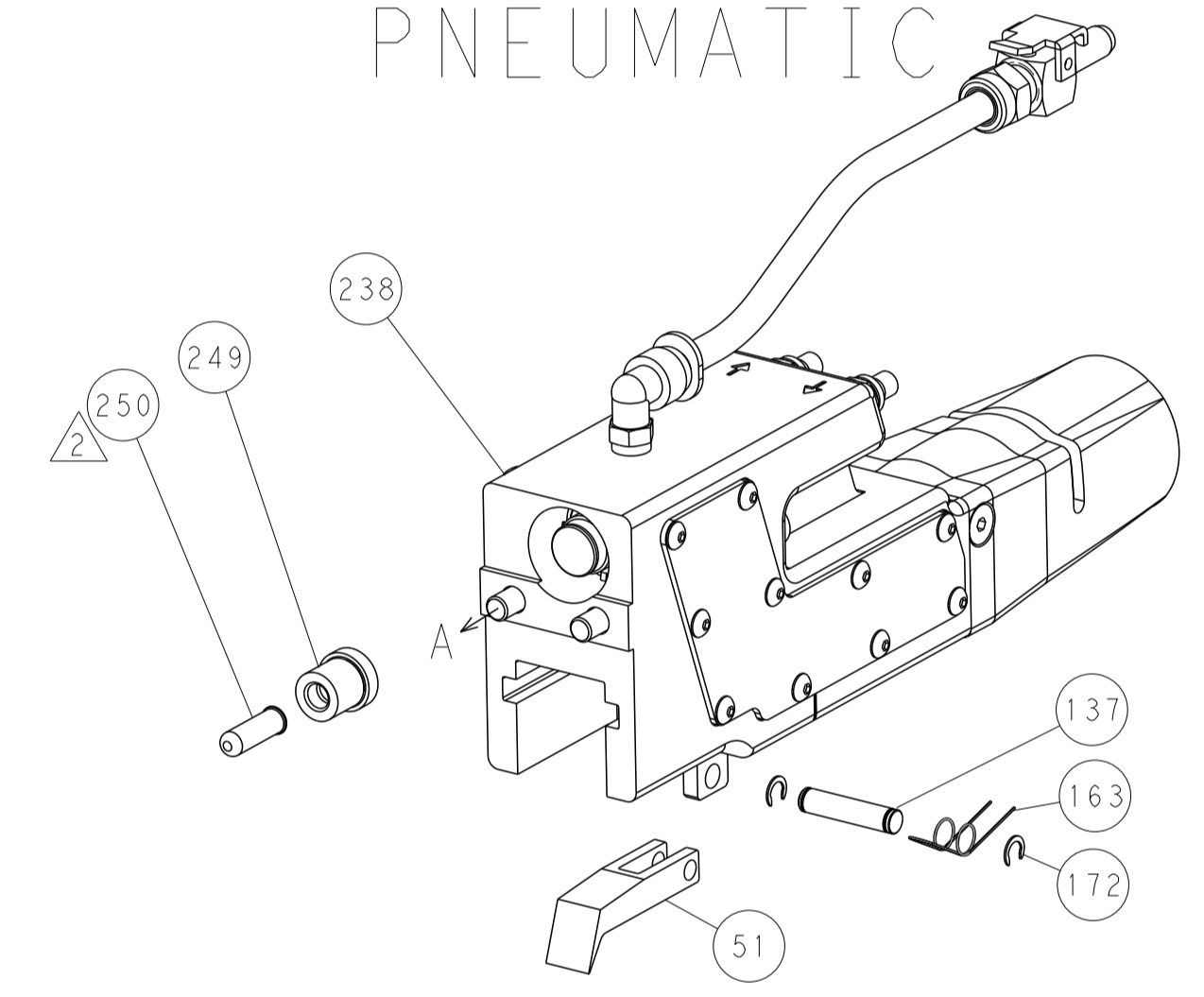


RAM AND HOLDDOWN SET-UP

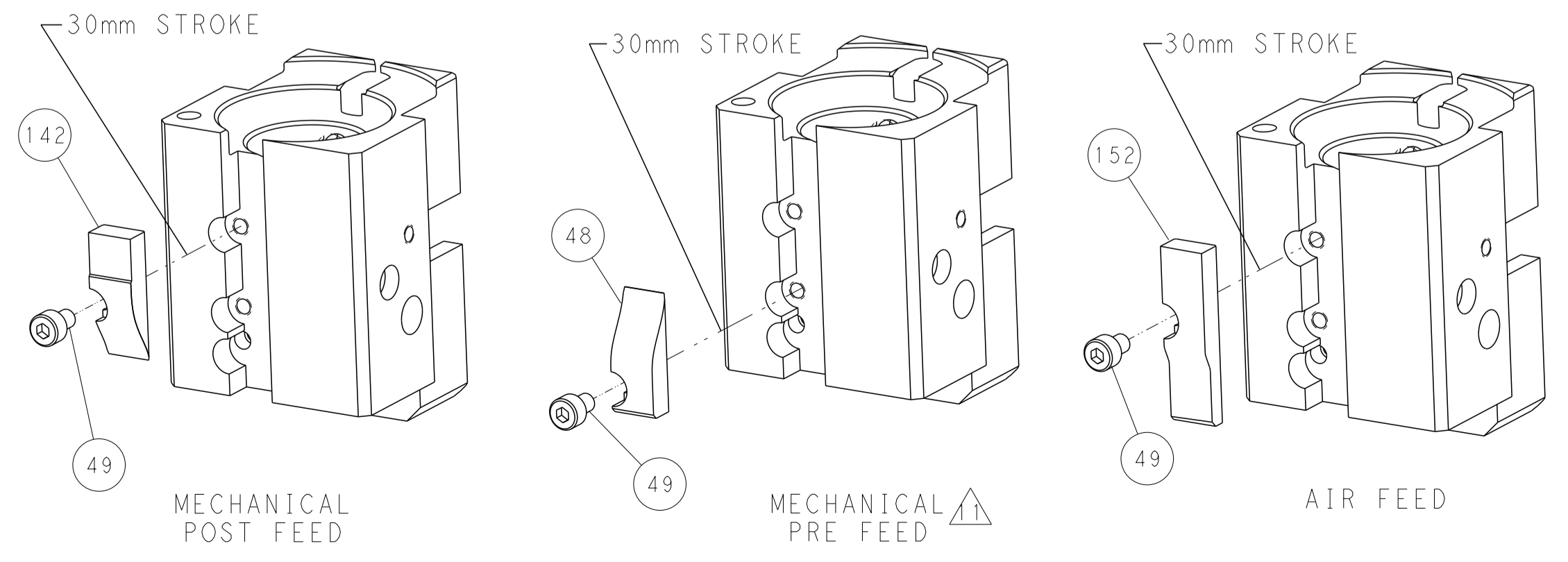
FEED TYPE
MECHANICAL



PNEUMATIC



CAM POSITIONS



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		NAME Ocean End Feed Applicator PRODUCT SPEC APPLICATION SPEC SIZE CAGE CODE DRAWING NO. A1 00779 ©=2150097 WEIGHT Customer Accessible Production Drawing	RESTRICTED TO SCALE 1:1 SHEET 4 OF 4 REV B