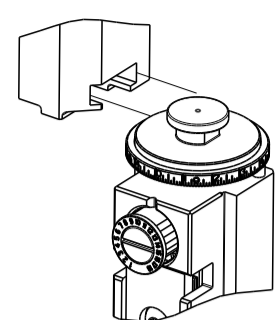


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150133-2	E	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150133-2	E	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150133-7	E	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	3.56 mm [.140]	F
INSUL	-	-

APPL INSTRUCTIONS
408-35043

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: SPLICE (AMPLIVAR) 9 SERRATIONS			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
5.34-6.10 mm [.210-.240 IN]		∅ -	
TERMINAL APPLICATION SPECIFICATION	114-2003	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
62308-2			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
6000-7000 CMA	2.18+/-0.05 [.086+/- .002]	5.8
5000-5999 CMA	2.08+/-0.05 [.082+/- .002]	6.8
4000-4999 CMA	1.98+/-0.05 [.078+/- .002]	7.8
3000-3999 CMA	1.88+/-0.05 [.074+/- .002]	8.8



- RECOMMENDED SPARE PARTS
- REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- 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.
- 6. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- REFER TO CUSTOMER DRAWING 62308 NOT 3 FRO CRIMP HEIGHT FORMULA FOR SPECIFIC WIRE COMBINATIONS.

***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
		C		ECR-19-014976	24SEP2019	MEH	GB
		D		ECR-21-001634	08FEB2021	JWC	TE
		E		ECR-21-007011	23JUL2021	FJ	TE
		E1		ECR-21-117809	19OCT2021	LG	TE

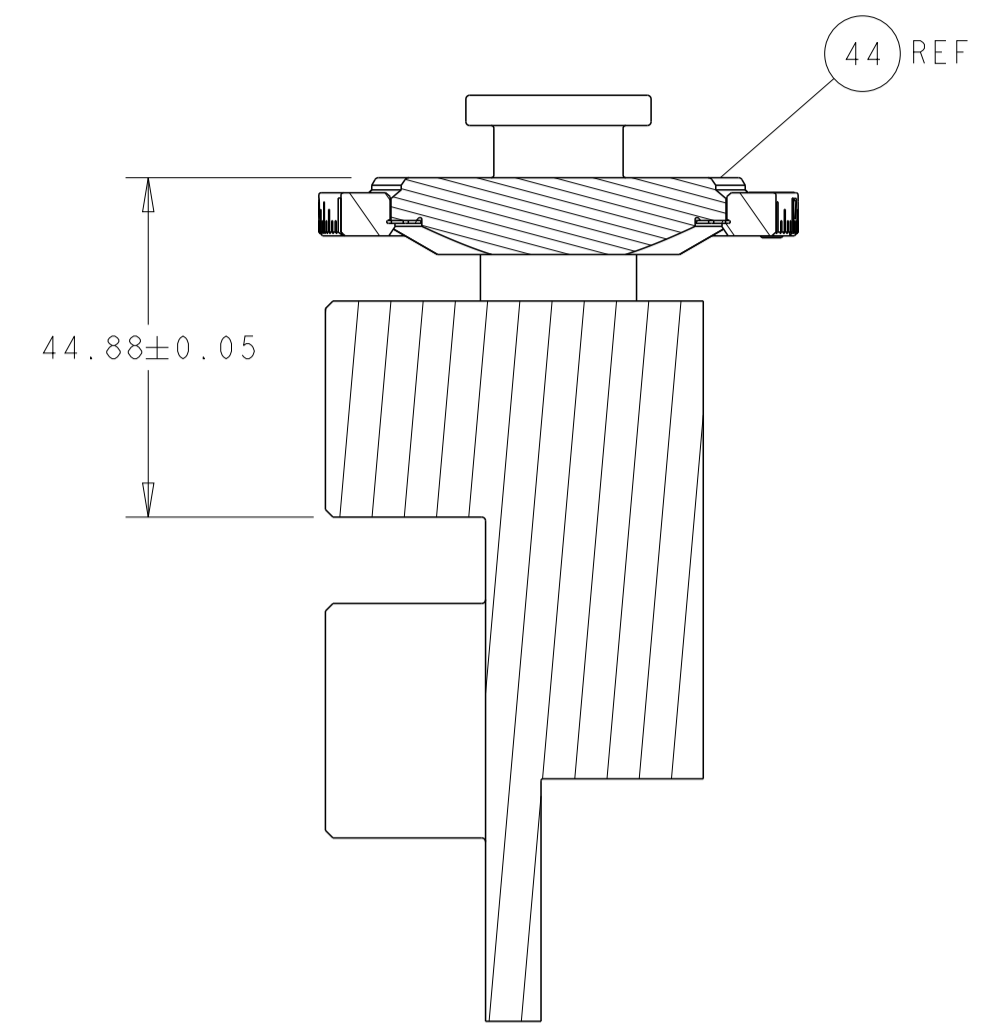
-	1	1	23238-1	INSERT, COUPLING	278	
-	1	1	2030758-3	TUBING, POLYURETHANE	277	
-	1	1	986220-3	CLAMP, CABLE, BLACK	275	
-	1	1	2844280-1	MOUNT, AIR BLAST	273	
-	1	1	2119641-1	FEED CAM, AIR FEED	248	
-	1	1	2844940-1	AIR FEED MODULE	238	
-	REF	REF	994970-2	COUNTER, MAGNETIC	164	
-	3	3	1-18023-0	SCR, SKT HD CAP M4 X 8.0	143	
-	2	2	1-18024-4	SCR, BTN SKT HD CAP (M5 X 20.0)	94	
-	2	2	1-18024-1	SCR, BTN SKT HD CAP (M5 X 10.0)	93	
-	4	4	2168400-1	SHCS, LOW HEAD, RoHS, M4 X 12	85	
-	1	1	2119955-2	ASSY, LUBRICATOR, END FEED	84	
-	4	4	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	80	
-	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	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59	
-	2	2	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57	
-	2	2	5018030-1	NUT, HEX, REG, RoHS, M3	54	
-	2	2	986965-8	NUT, LOCK, HEX, TORQUE (M4)	53	
-	1	1	2063961-5	FEED FINGER	51	
-	1	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49	
-	1	1	2-2119655-1	APPLICATOR BASIC ASSEMBLY, EF	46	
-	1	1	1803517-3	RAM ASSEMBLY, EF ATLANTIC	44	
-	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41	
-	6	6	1-18028-2	WASHER, FLAT, REG M4	33	
-	2	2	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	29	
-	1	1	460276-2	STRIPPER, SPECIAL	27	
-	2	2	1-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 30	25	
-	1	1	3-1752371-0	PLATE, STRIP GUIDE	24	
-	1	1	1-462932-0	PLATE, STRIP COVER	23	
-	2	2	22281-8	SPRING, COMPRESSION	22	
-	2	2	18027-2	WASHER, FLAT, REG M4	21	
-	1	1	1803292-1	DRAG	20	
-	2	2	1901259-6	GUIDE, LOWER STRIP	18	
-	4	4	1-18024-9	SCR, BTN SKT HD CAP (M6 X 16.0)	17	
-	1	1	459684-4	PLATE GUIDE, RETAINING	11	
-	1	1	459580-1	PLATE, RETAINING	10	
-	1	1	2-459583-2	BODY, ANVIL	9	
-	1	2	1	459582-8	ANVIL, AMPLIVAR SPLICE	8
-	1	1	1	459581-8	BLADE, SLUG	7
-	-	-	-	-	4	
-	1	2	1	459587-1	GUIDE, CRIMPER	3
-	-	-	-	-	2	
-	1	2	1	2-459585-1	CRIMPER, BLUNT F	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:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		MATERIAL:	
mm	PLC	mm	PLC	FINISH	FINISH
	0 PLC ±		±		
	1 PLC ±		±		
	2 PLC ±		±		
	3 PLC ±		±		
	4 PLC ±		±		
	ANGLES		±		

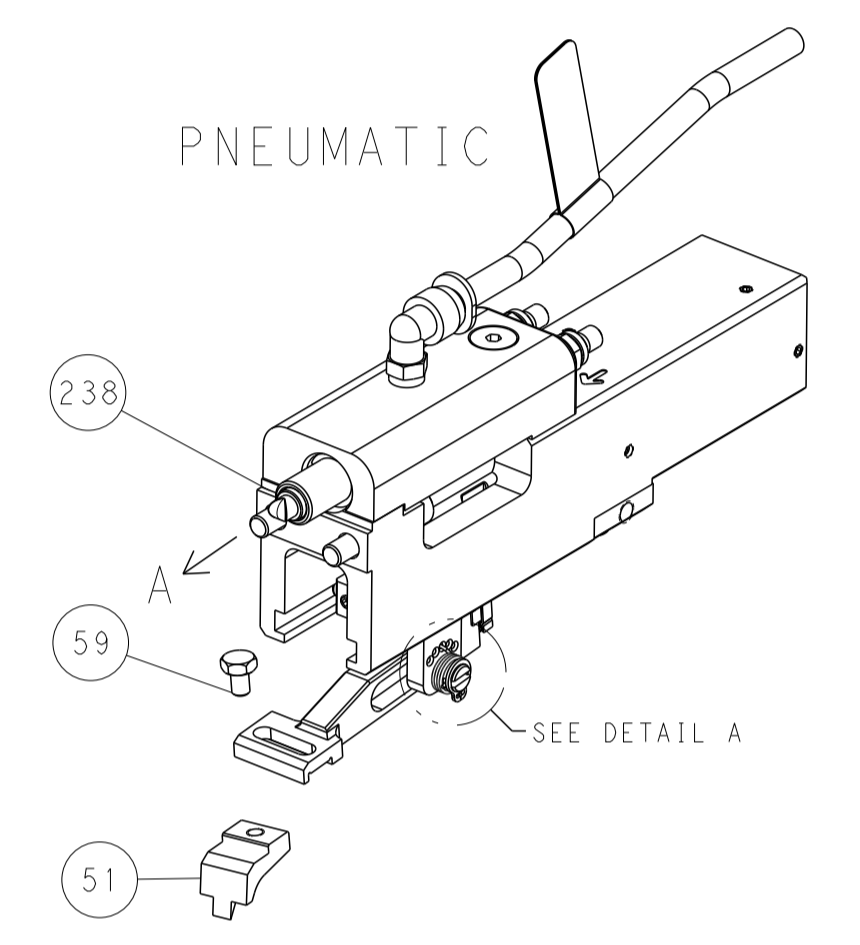
DWN	M. HERR	27JUL2018	TE Connectivity Harrisburg, PA 17105-3608
CHK	T. ELBIN	27JUL2018	
APVD	C. TOPPER	27JUL2018	NAME
PRODUCT SPEC			Ocean
APPLICATION SPEC			End Feed Applicator
SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
A1	00779	2150133	-
Customer Accessible Production Drawing			SCALE 1:1 SHEET 1 OF 4 REV E1

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

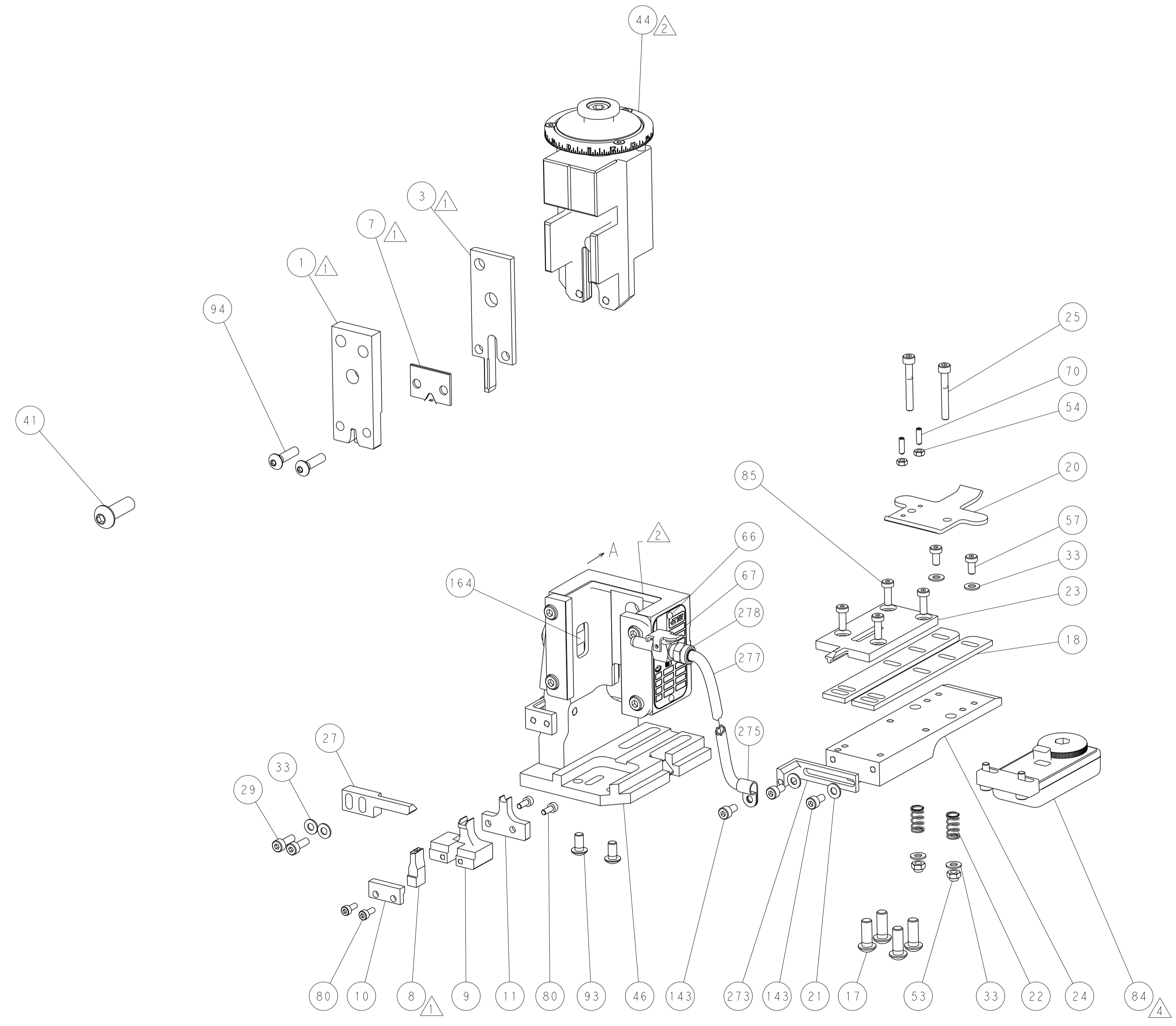
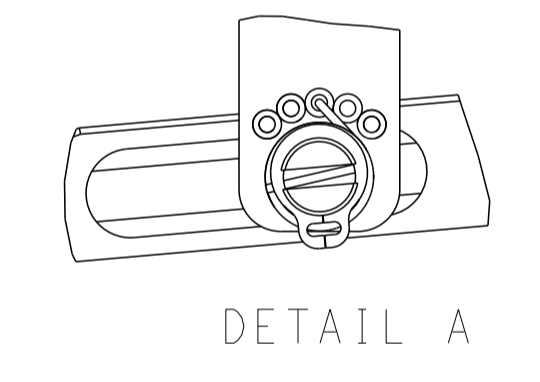


RAM SET-UP

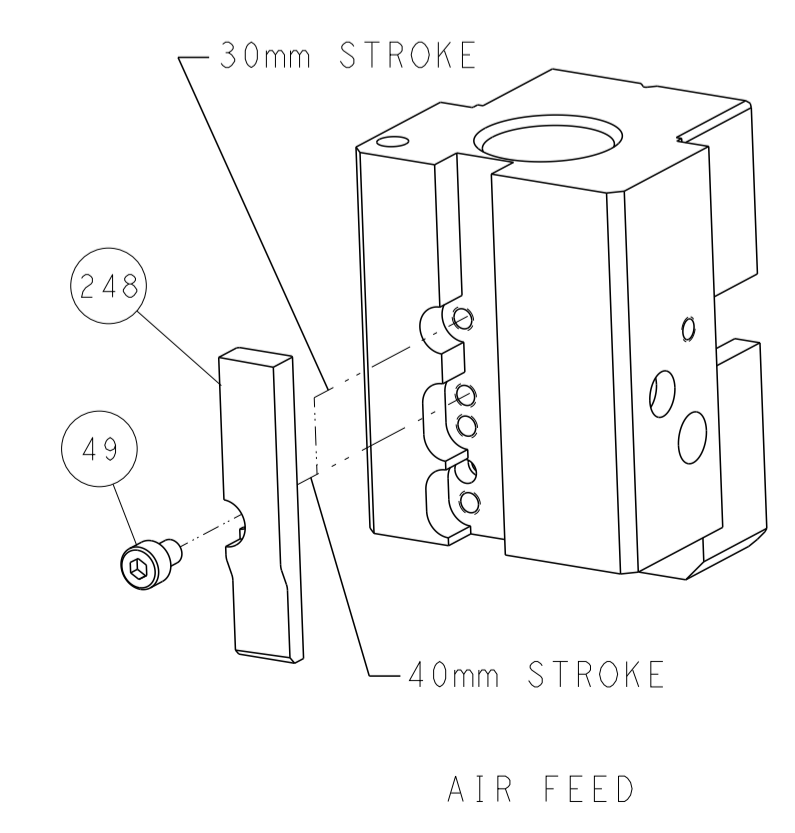
FEED TYPE



FEED SPRING SETTING POSITION



CAM POSITION

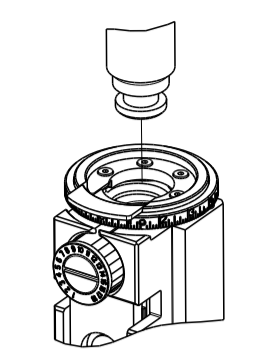


ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

<small>THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION 2018. © COPYRIGHT 2018 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.</small>		DWN: M. HERR 27JUL2018 CHK: T. ELBIN 27JUL2018 APVD: C. TOPPER 27JUL2018	TE Connectivity Harrisburg, PA 17105-3608
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	SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2150133 SHEET 2 OF 4 REV: E1
Customer Accessible Production Drawing			

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150133-2	E	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150133-7	E	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
 INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	3.56 mm [.140]	F
INSUL	-	-
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: SPLICE (AMPLIVAR) 9 SERRATIONS			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
5.34-6.10 mm [.210-.240 IN]		∅	-
TERMINAL APPLICATION SPECIFICATION	114-2003	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
62308-2			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
6000-7000 CMA	2.18+/-0.05 [.086+/- .002]	5.8
5000-5999 CMA	2.08+/-0.05 [.082+/- .002]	6.8
4000-4999 CMA	1.98+/-0.05 [.078+/- .002]	7.8
3000-3999 CMA	1.88+/-0.05 [.074+/- .002]	8.8



- 1 RECOMMENDED SPARE PARTS
- 2 REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- 3 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.
- 4 TERMINAL LUBRICANT IS RECOMMENDED.
- 5 TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- 6. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- 7 REFER TO CUSTOMER DRAWING 62308 NOT 3 FOR CRIMP HEIGHT FORMULA FOR SPECIFIC WIRE COMBINATIONS.

***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.

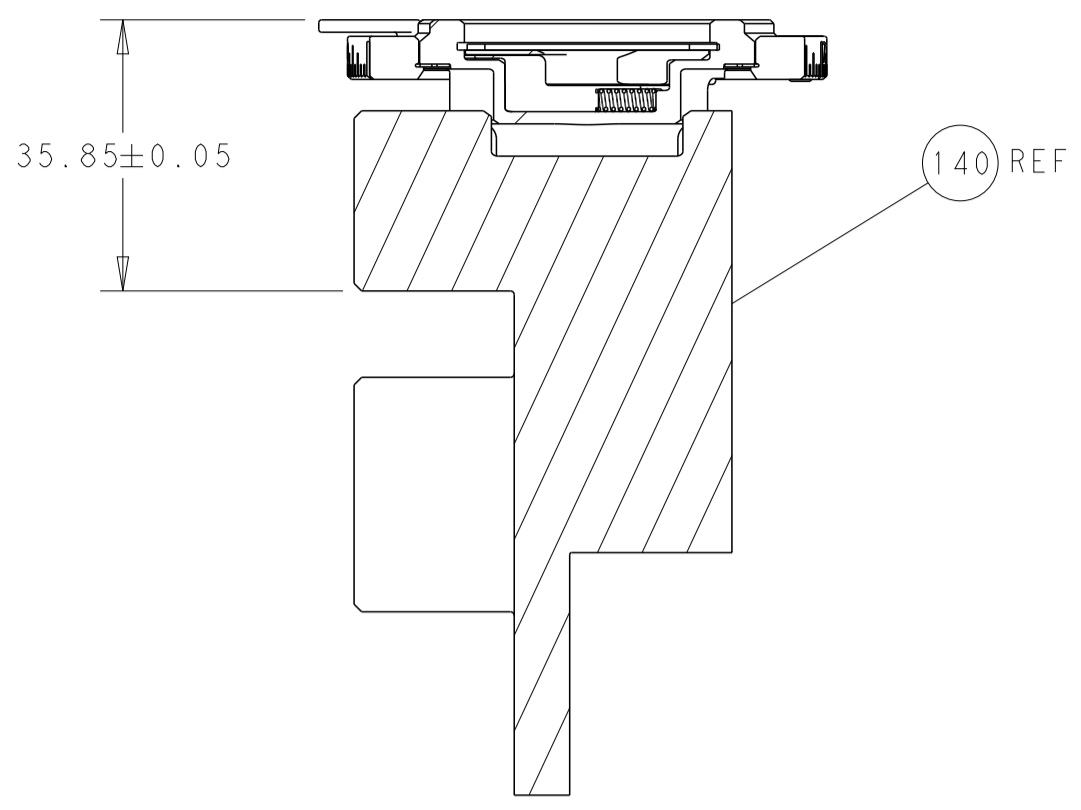
PACIFIC VERSION
 Shown on sheets 3 of 4 & 4 of 4
 (Atlantic version shown on sheets 1 of 4 & 2 of 4)

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

-	1	23238-1	INSERT, COUPLING	278	
-	1	2030758-3	TUBING, POLYURETHANE	277	
-	1	986220-3	CLAMP, CABLE, BLACK	275	
-	1	2844280-1	MOUNT, AIR BLAST	273	
-	1	2844940-1	AIR FEED MODULE	238	
-	4	2-18024-1	SCR, BTN SKT HD CAP (M6 X 25.0)	186	
-	REF	994970-2	COUNTER, MAGNETIC	164	
-	1	2119641-2	FEED CAM, AIR FEED	152	
-	3	1-18023-0	SCR, SKT HD CAP M4 X 8.0	143	
-	1	2-2119655-2	APPLICATOR BASIC ASSEMBLY, EF	141	
-	1	1803518-3	RAM ASSEMBLY, EF PACIFIC	140	
-	2	1-18024-3	SCR, BTN SKT HD CAP (M5 X 16.0)	95	
-	2	1-18024-4	SCR, BTN SKT HD CAP (M5 X 20.0)	94	
-	4	2168400-1	SHCS, LOW HEAD, RoHS, M4 X 12	85	
-	1	2119955-2	ASSY, LUBRICATOR, END FEED	84	
-	4	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	80	
-	1	1803607-4	DOCUMENTATION PACKAGE	71	
-	2	2-18032-2	SCR, SET, FLT PNT, M3 X 10.0	70	
-	1	2119740-1	TAG, IDENTIFICATION	67	
-	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66	
-	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59	
-	2	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57	
-	2	5018030-1	NUT, HEX, REG, RoHS, M3	54	
-	2	986965-8	NUT, LOCK, HEX, TORQUE (M4)	53	
-	1	2063961-5	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	
-	6	1-18028-2	WASHER, FLAT, REG M4	33	
-	2	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	29	
-	1	460276-2	STRIPPER, SPECIAL	27	
-	2	1-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 30	25	
-	1	3-1752371-0	PLATE, STRIP GUIDE	24	
-	1	1-462932-0	PLATE, STRIP COVER	23	
-	2	22281-8	SPRING, COMPRESSION	22	
-	2	18027-2	WASHER, FLAT, REG M4	21	
-	1	1803292-1	DRAG	20	
-	2	1901259-6	GUIDE, LOWER STRIP	18	
-	1	459684-4	PLATE GUIDE, RETAINING	11	
-	1	459580-1	PLATE, RETAINING	10	
-	1	2-459583-2	BODY, ANVIL	9	
-	1	459582-8	ANVIL, AMPLIVAR SPLICE	8	
-	1	459581-8	BLADE, SLUG	7	
-	-	-	-	6	
-	-	-	-	4	
-	1	459587-1	GUIDE, CRIMPER	3	
-	-	-	-	2	
-	1	2-459585-1	CRIMPER, BLUNT F	1	
-	77	22	PART NO	DESCRIPTION	ITEM NO

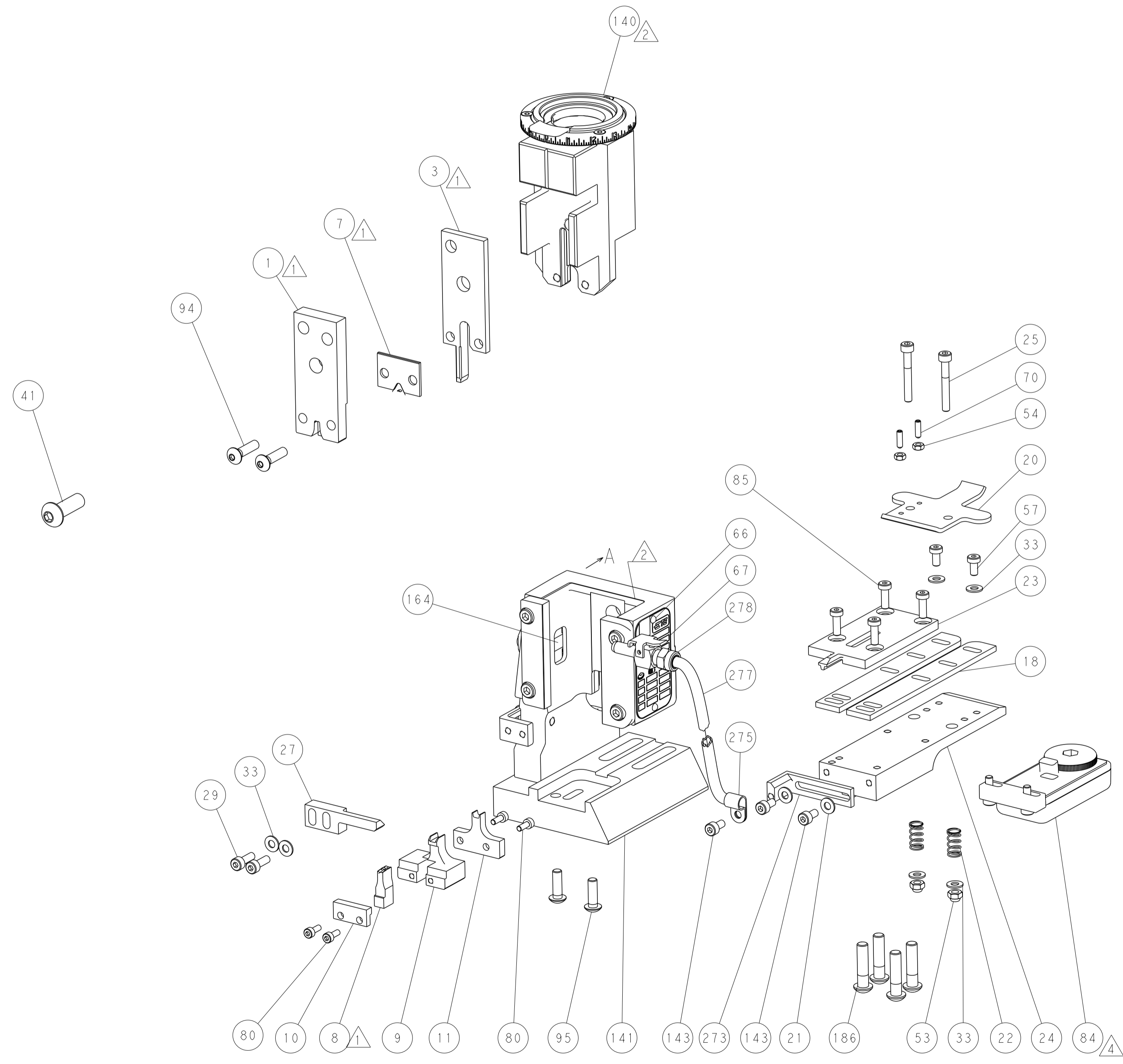
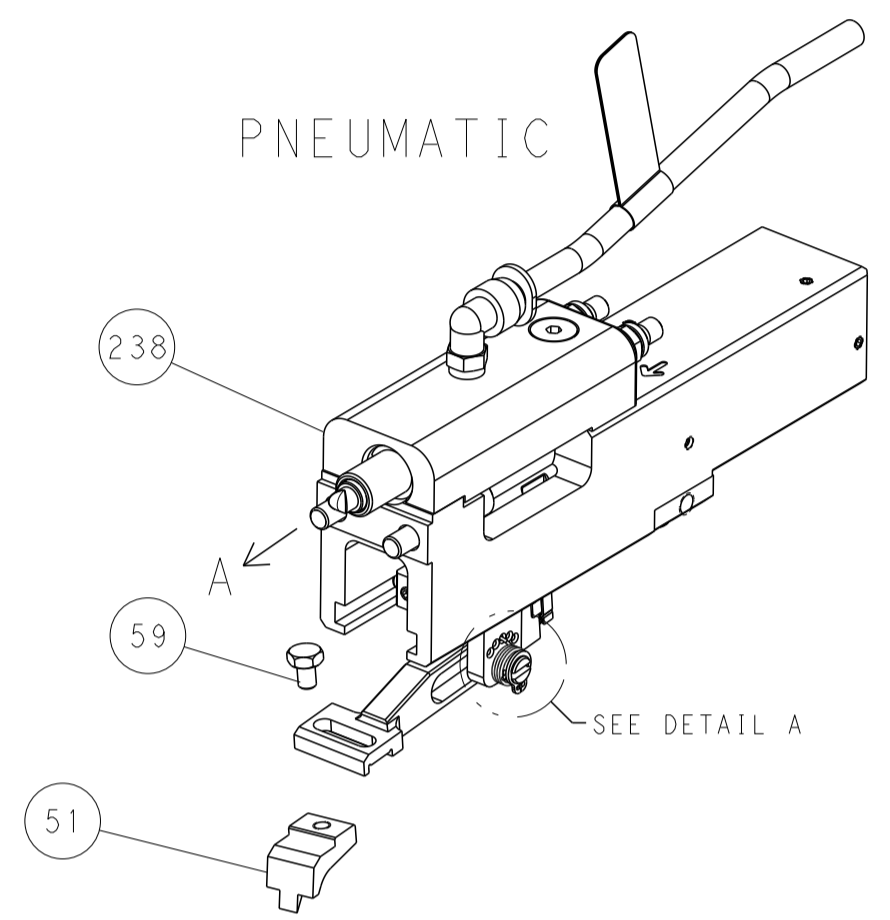
DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH		DWN BY: HERR 27JUL2018 CHK T. ELBIN 27JUL2018 APVD C. TOPPER 27JUL2018 PRODUCT SPEC APPLICATION SPEC WEIGHT SCALE 1:1		NAME: Ocean End Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2150133 SHEET 3 OF 4 REV E1	
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LOC	DIST	REVISIONS			
P	LTN	DESCRIPTION	DATE	DWN	APVD
A	66	SEE SHEET 1	-	-	-

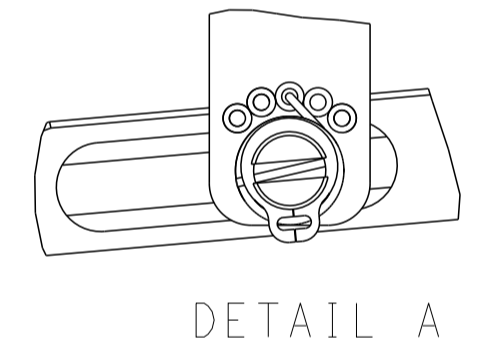


RAM SET-UP

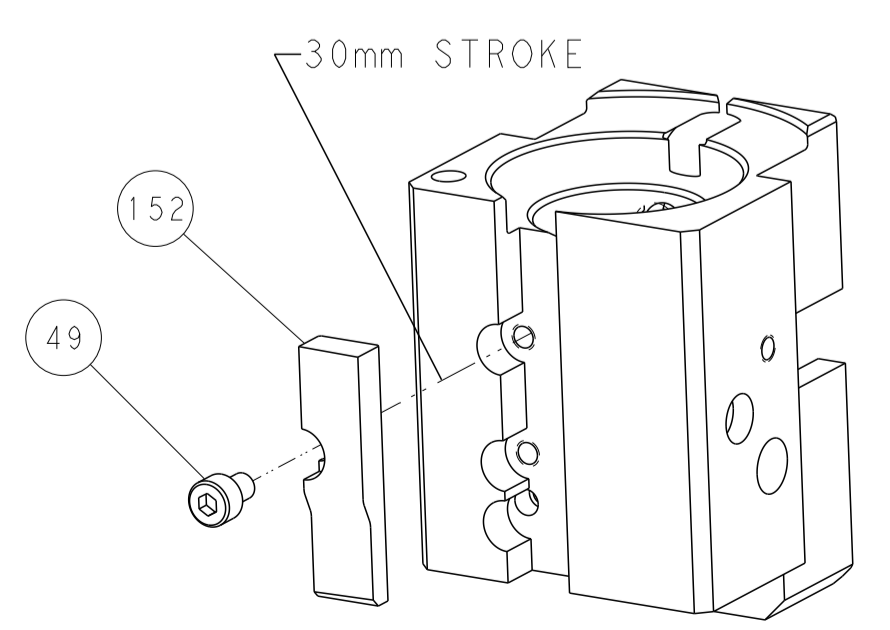
FEED TYPE



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	SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2150133 SHEET 4 OF 4 REV: E1
Customer Accessible Production Drawing			