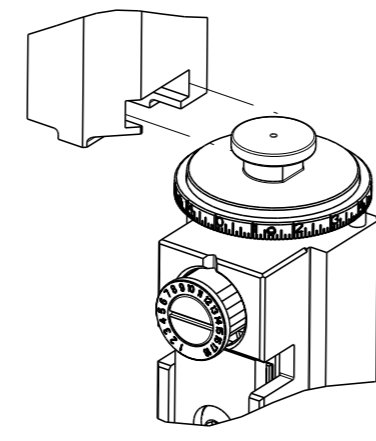


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150245-1	G	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2150245-2	H	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150245-1	G	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2150245-2	H	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150245-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	5.33 mm [.210]	F
INSUL	-	-

APPLICATOR INSTRUCTIONS 408-35043

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION			
TERMINAL NAME: TERMINAL, RING			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
5.54-6.30 mm [.218-.248 IN]		-	
TERMINAL APPLICATION SPECIFICATION	114-2084	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
40523	40524	41090	41911

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
10 AWG	3.43 +/- 0.05 [1.135 +/- .002]	3.0
12 AWG	3.12 +/- 0.05 [1.123 +/- .002]	6.6
14 AWG	2.74 +/- 0.05 [1.108 +/- .002]	11.0

- 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.
- WHEN RUNNING WIRES WITH CMA OVER 9,926, WIRE STRANDS MAY BE VISIBLE IN WIRE BARREL SEAM.

***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.

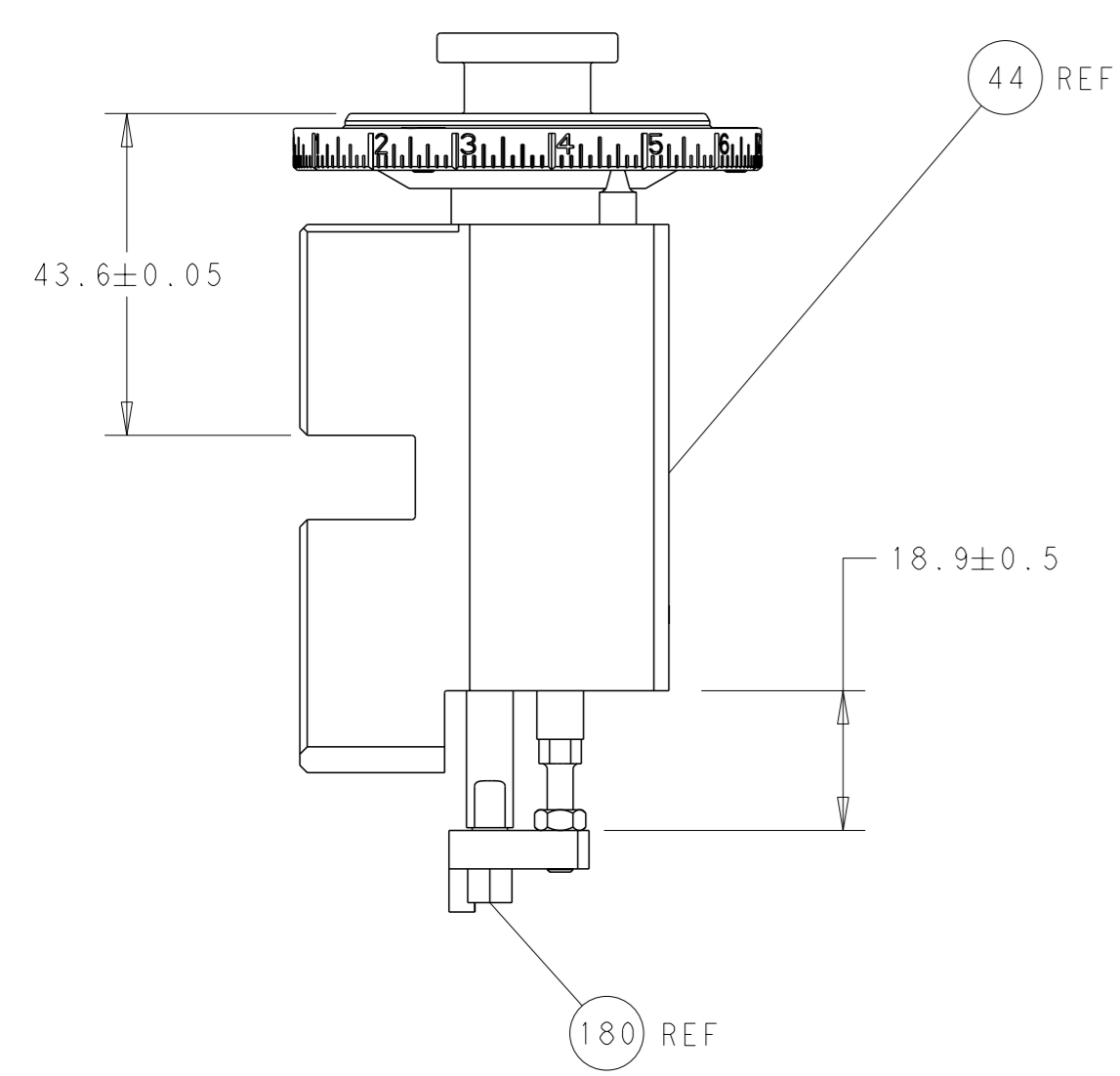
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		F		ECR-18-014437	11SEP2018	TB	TE
		G		ECR-18-016612	19OCT2018	TB	TE
		H		ECR-20-014834	20OCT2020	JWC	RR

-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248
-	-	1	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	1	-	1	-	2844940-3	AIR FEED MODULE	238
-	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
-	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	1	1	1	1	2119955-2	ASSY, LUBRICATOR, END FEED	84
-	1	1	1	1	455888-3	SPACER, CRIMPER	82
-	1	1	1	1	1803203-1	BLOCK, FRONT DEPRESSOR	77
-	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	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	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	-	2063961-9	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	2079383-5	SCR, BHSC, 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
-	1	1	1	1	1-1901696-0	STRIP GUIDE, REAR	19
-	1	1	1	1	1-1901695-0	STRIP GUIDE, FRONT	18
-	4	4	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17
-	1	1	1	1	1752360-1	SPACER, HOLD-DOWN	13
-	1	1	1	1	240644-1	PLATE, REAR SHEAR	11
-	-	-	-	-	-	-	10
-	1	1	1	1	690482-7	PLATE, FRONT SHEAR	9
-	1	2	2	1	1803002-1	ANVIL, COMBINATION, END FEED	8
-	1	1	1	1	1-2217206-6	BLADE, SLUG	7
-	1	1	1	1	8-240641-8	SPACER	5
-	-	-	-	-	-	-	3
-	1	2	2	1	456430-2	CRIMPER, WIRE	1
-	77	72	71	2	-1	PART NO	ITEM NO

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

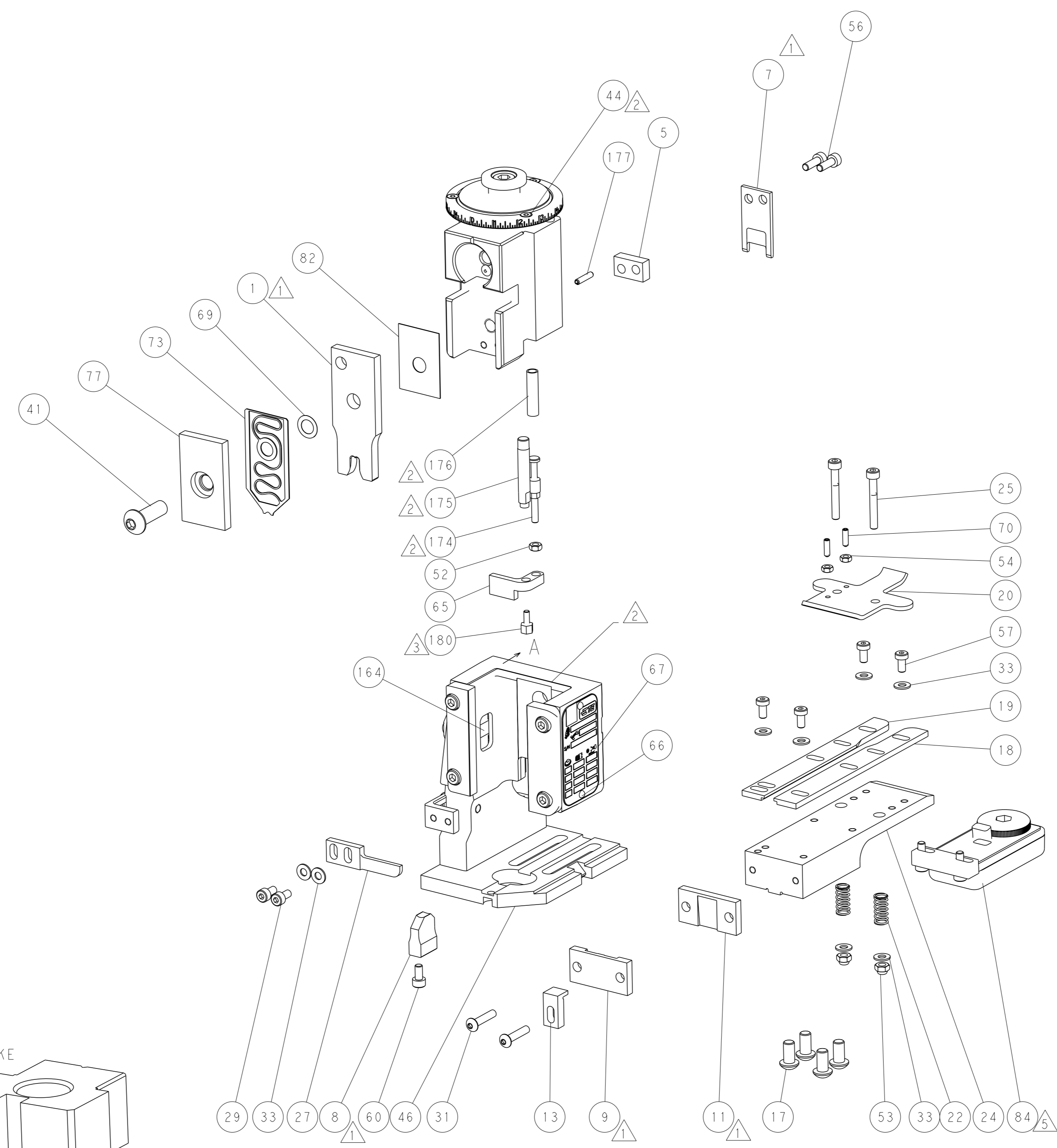
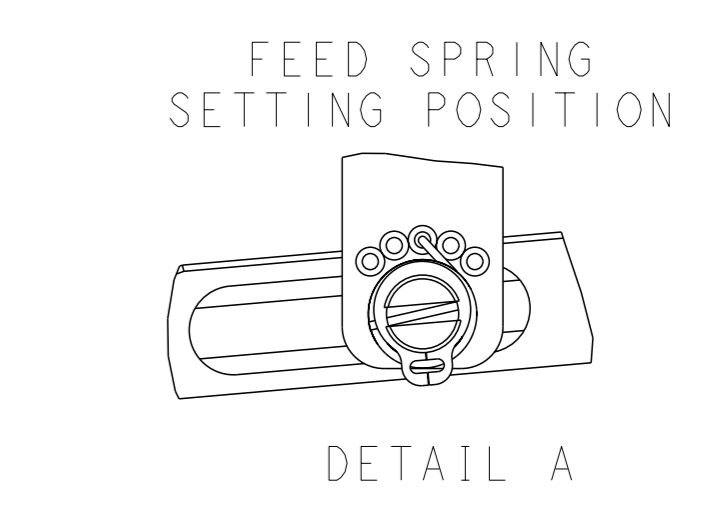
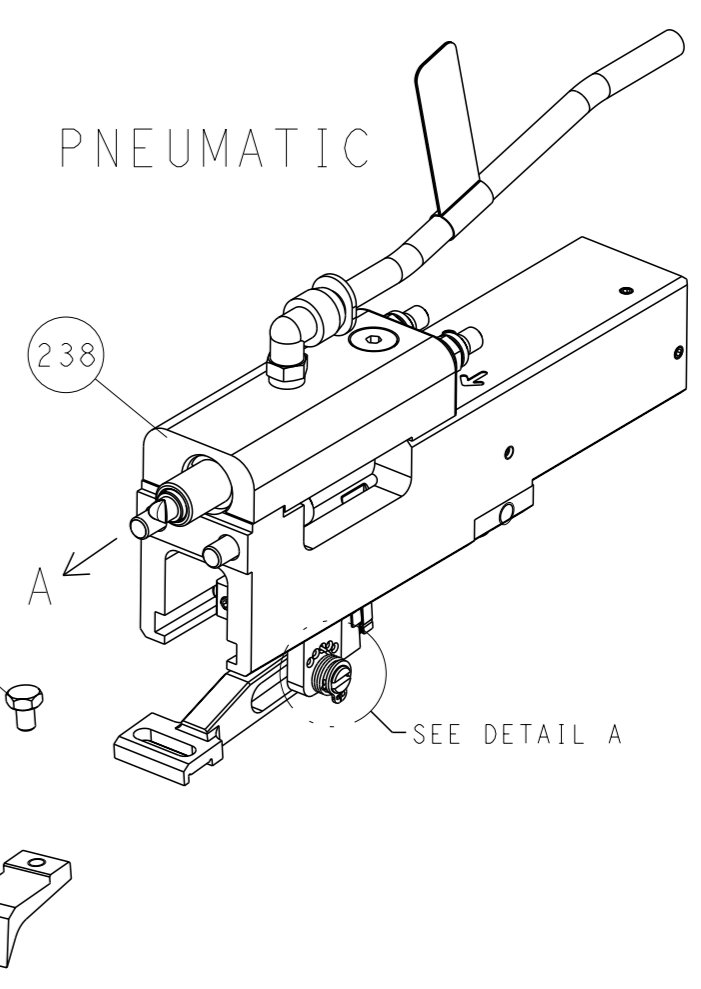
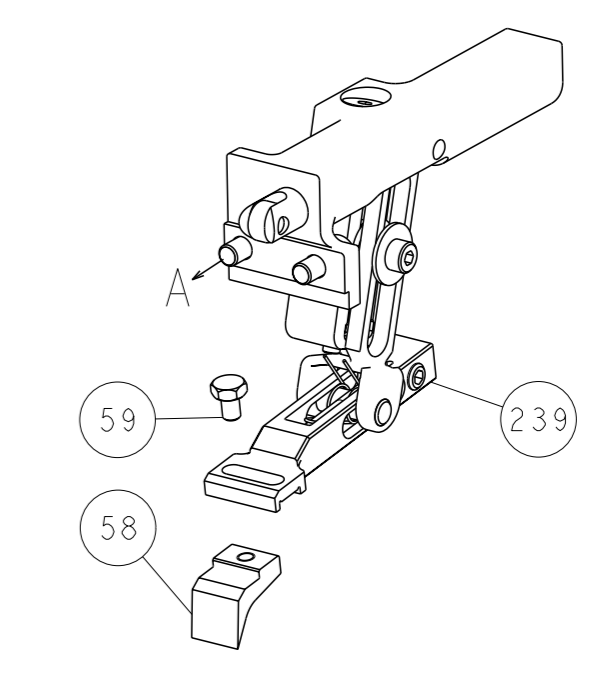
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		1 PLC ±		APVD: T. ELBIN 13JAN2012		NAME: Ocean End Feed Applicator	
		2 PLC ±		PRODUCT SPEC		SIZE: CAGE CODE: DRAWING NO: RESTRICTED TO	
		3 PLC ±		APPLICATION SPEC		A1 00779 C=2150245	
		4 PLC ±		WEIGHT		SCALE: 1:1 SHEET 1 OF 4 REV H	
MATERIAL:		FINISH:		CUSTOMER ACCESSIBLE PRODUCTION DRAWING		SCALE: 1:1 SHEET 1 OF 4 REV H	

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

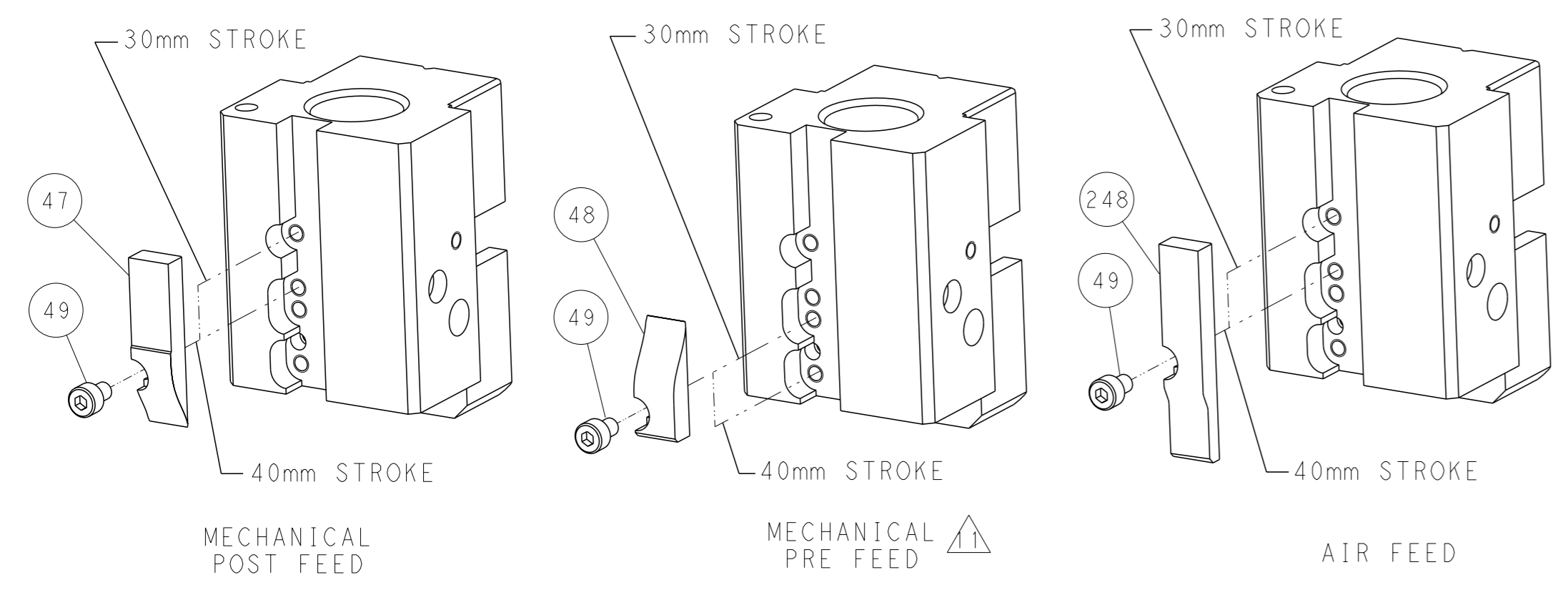


RAM AND HOLDDOWN SET-UP

FEED TYPE
MECHANICAL



CAM POSITIONS

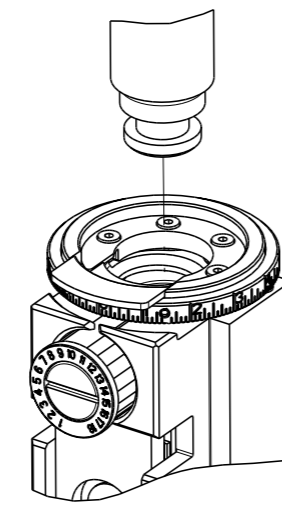


ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

<small>THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION IT IS SUBJECT TO CHANGE AND THE CONTROL AND ENGINEERING ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST REVISION.</small>		OWN: HOFFNER CHK: T. ELBIN APVD: T. ELBIN PRODUCT SPEC: - APPLICATION SPEC: - WEIGHT: - CUSTOMER ACCESSIBLE PRODUCTION DRAWING: -	DATE: 12JAN2012 DATE: 13JAN2012 DATE: 13JAN2012 SCALE: 1:1 SHEET: 2 of 4 REV: H	TE Connectivity Harrisburg, PA 17105-3608 NAME: Ocean End Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2150245	RESTRICTED TO: -
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150245-1	G	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2150245-2	H	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150245-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	5.33 mm [.210]	F
INSUL	-	-
APPLICATOR INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION
TERMINAL NAME: TERMINAL, RING		
WIRE STRIP LENGTH 5.54-6.30 mm [.218-.248 IN]		INSULATION DIAMETER RANGE Ø -
TERMINAL APPLICATION SPECIFICATION 114-2084	-	-
TERMINALS APPLIED		
TE TERMINAL 40523	TE TERMINAL 40524	TE TERMINAL 41090
		TE TERMINAL 41911

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
10 AWG	3.43 +/- 0.05 [.135 +/- .002]	3.0
12 AWG	3.12 +/- 0.05 [.123 +/- .002]	6.6
14 AWG	2.74 +/- 0.05 [.108 +/- .002]	11.0

- 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.
- WHEN RUNNING WIRES WITH CMA OVER 9,926, WIRE STRANDS MAY BE VISIBLE IN WIRE BARREL SEAM.

***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.

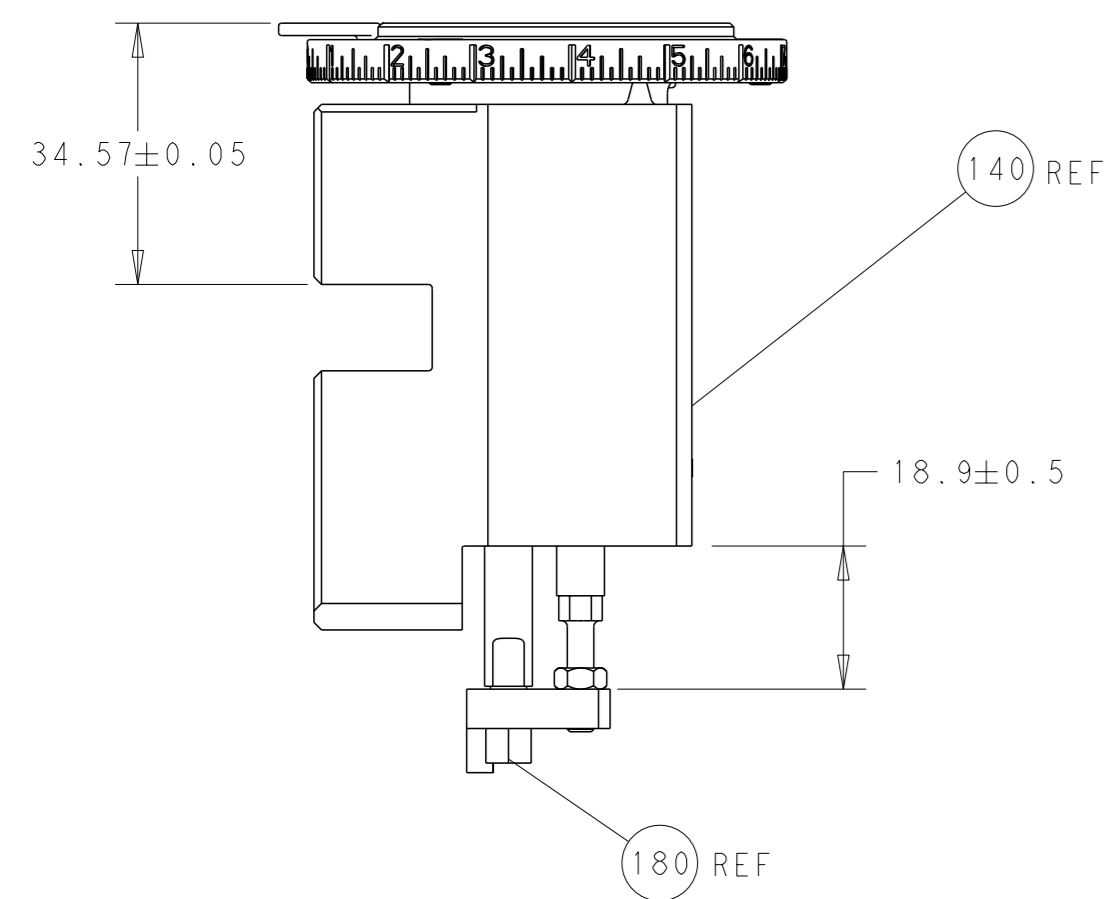
PACIFIC VERSION
Shown on sheets 3 of 4 & 4 of 4
(Atlantic version shown on sheets 1 of 4 & 2 of 4)

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

-	-	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
	-	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
-	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	2119656-6	APPLICATOR BASIC ASSEMBLY, EF	141
-	1	1	1803518-1	RAM ASSEMBLY, EF PACIFIC	140
	-	1	2119955-2	ASSY, LUBRICATOR, END FEED	84
-	1	1	455888-3	SPACER, CRIMPER	82
-	1	1	1803203-1	BLOCK, FRONT DEPRESSOR	77
-	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	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	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	-	2063961-9	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	2079383-5	SCR, BHSC, 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
-	1	1	1-1901696-0	STRIP GUIDE, REAR	19
-	1	1	1-1901695-0	STRIP GUIDE, FRONT	18
-	1	1	1752360-1	SPACER, HOLD-DOWN	13
	-	1	240644-1	PLATE, REAR SHEAR	11
-	-	-	-	-	10
	-	1	690482-7	PLATE, FRONT SHEAR	9
	1	1	1803002-1	ANVIL, COMBINATION, END FEED	8
	-	1	1-2217206-6	BLADE, SLUG	7
-	1	1	8-240641-8	SPACER	5
-	-	-	-	-	3
	1	1	456430-2	CRIMPER, WIRE	1
-	77-22-21	-	PART NO	DESCRIPTION	ITEM NO

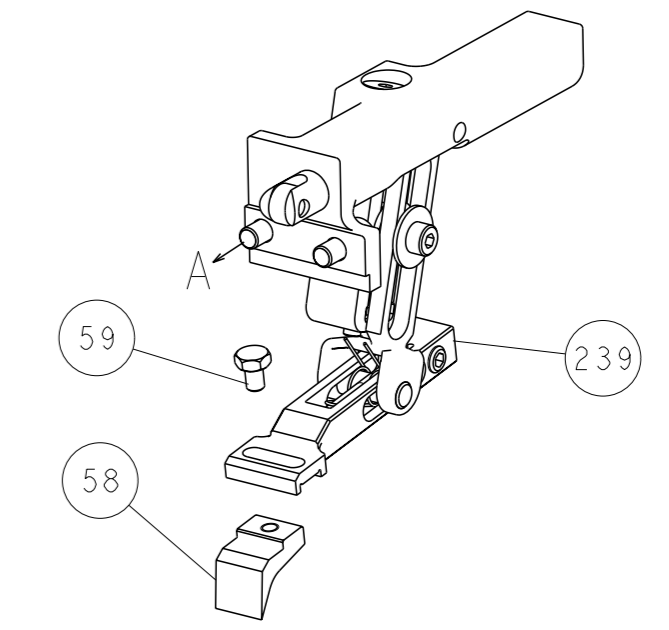
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0 PLC ±		1 PLC ±		CHK: T. ELBIN 13JAN2012	Harrisburg, PA 17105-3608
2 PLC ±		3 PLC ±		APVD: T. ELBIN 13JAN2012	
4 PLC ±		FINISH: -		NAME: Ocean End Feed Applicator	
MATERIAL: -		FINISH: -		SIZE: A1	CAGE CODE: 00779
				DRAWING NO: C=2150245	RESTRICTED TO: H
				WEIGHT: -	SCALE: 1:1
				CUSTOMER ACCESSIBLE PRODUCTION DRAWING	SHEET 3 OF 4

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

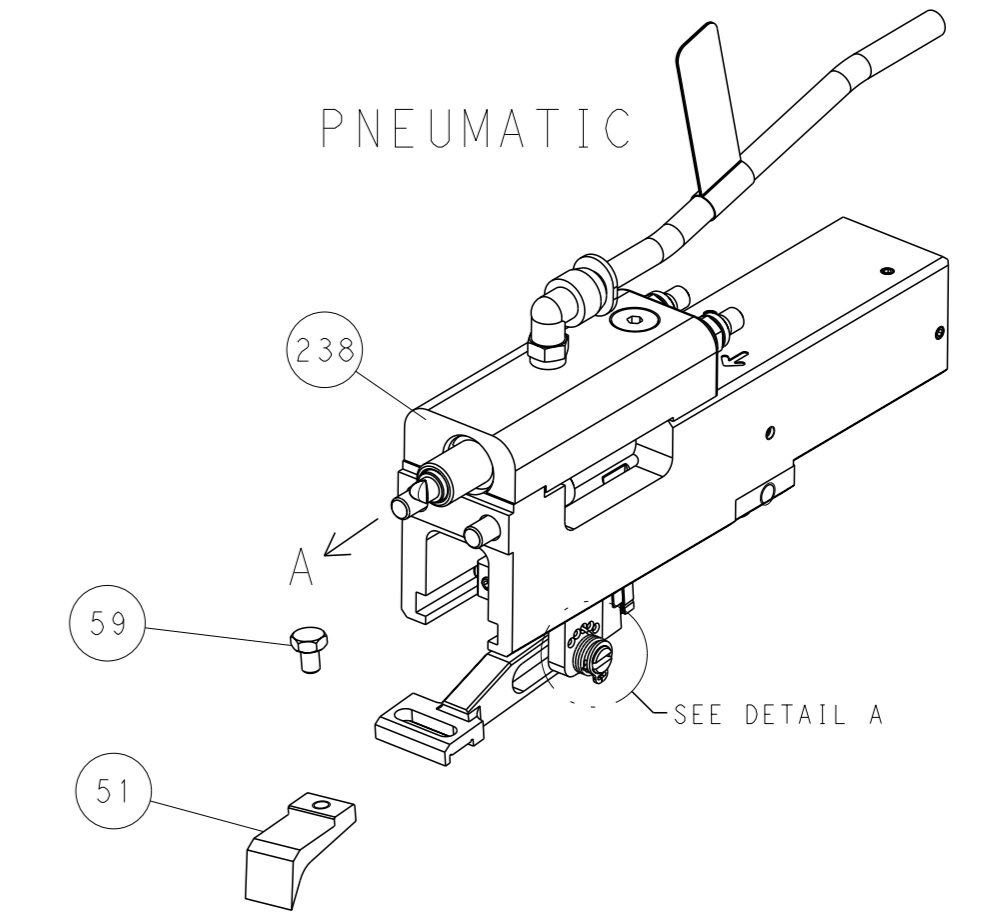


RAM AND HOLDDOWN SET-UP

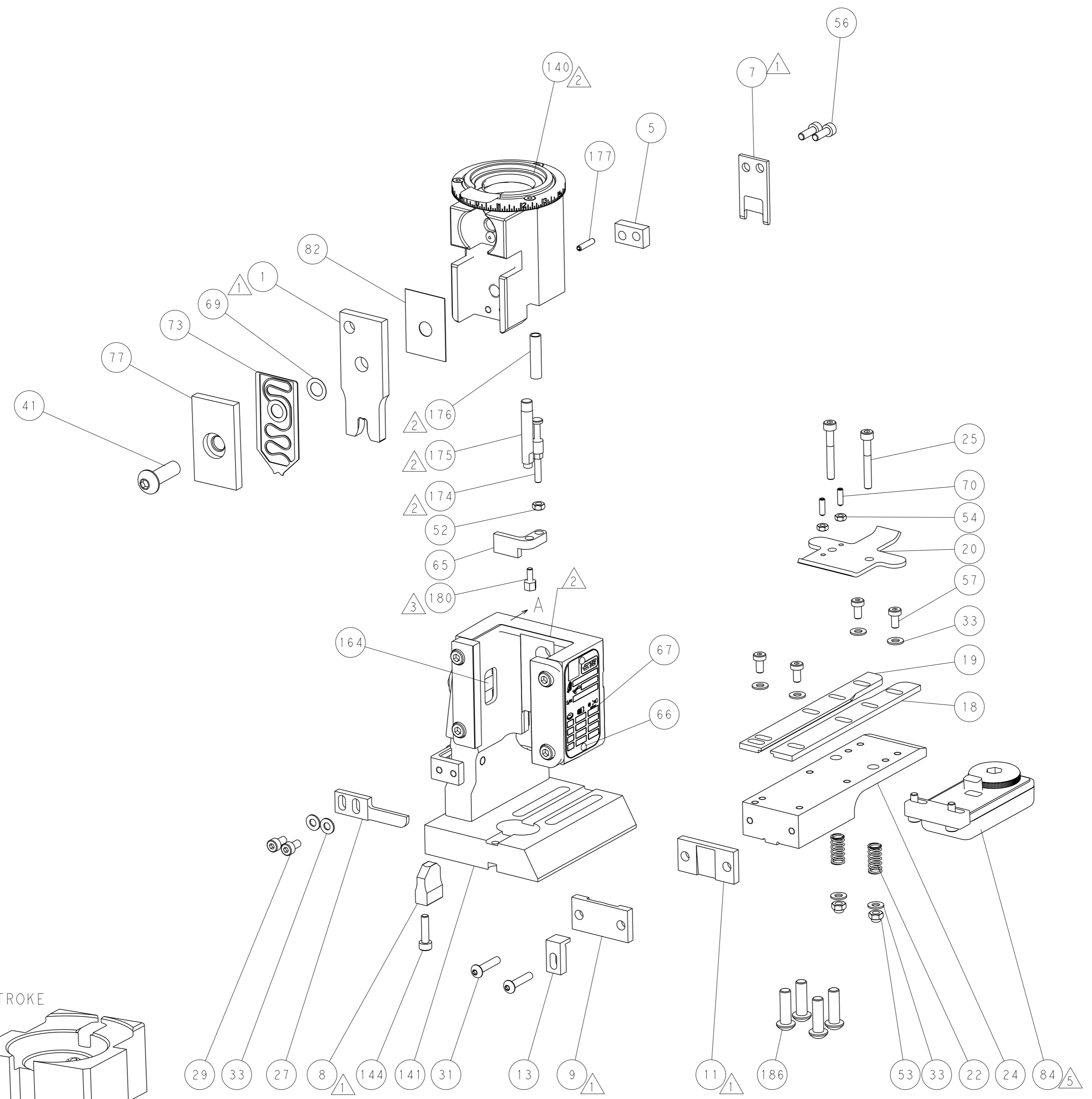
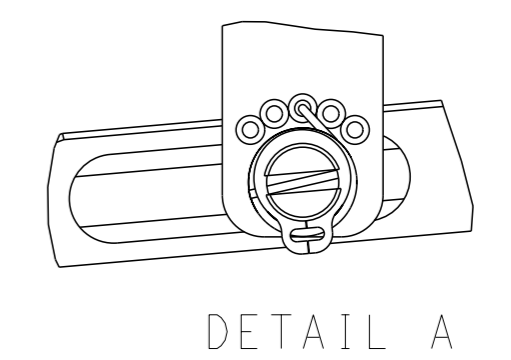
FEED TYPE
MECHANICAL



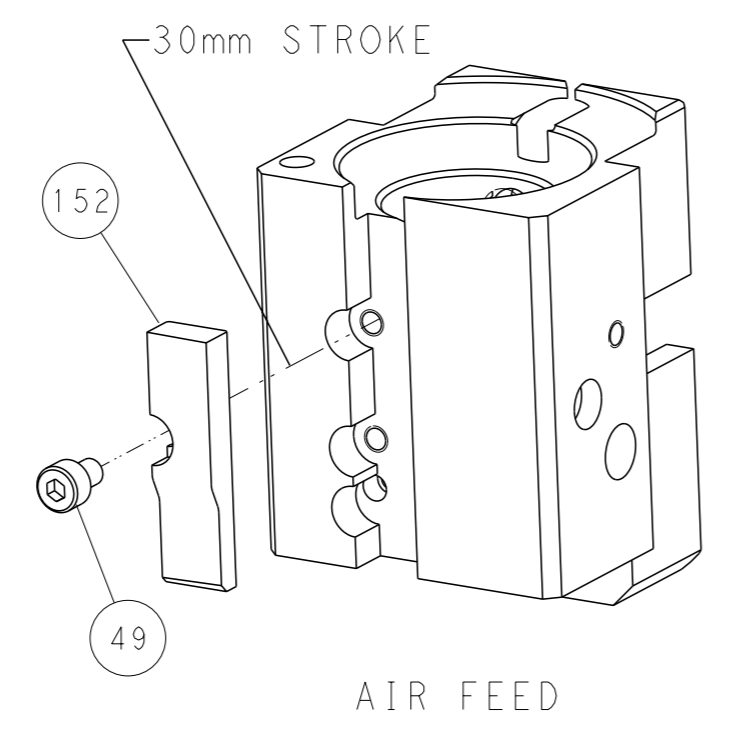
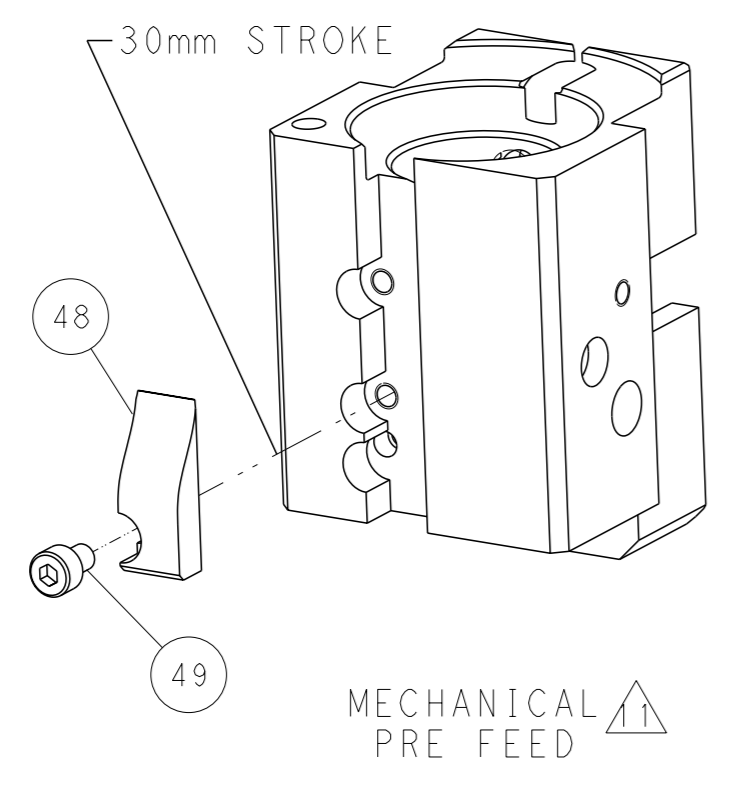
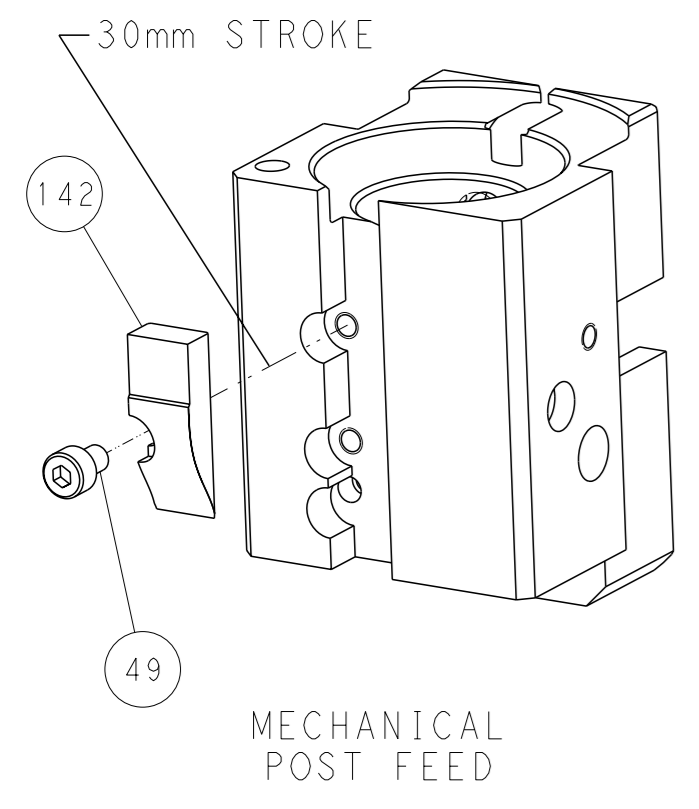
PNEUMATIC



FEED SPRING
SETTING POSITION



CAM POSITIONS



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 A CONTROLLED DOCUMENT FROM TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE AND THE CONTROL AND RESTRICTION DESIGNATION SHOULD BE CONTACTED FOR THE LATEST VERSION.</small>		DWN: HOFFNER CHK: T. ELBIN APVD: T. ELBIN PRODUCT SPEC: - APPLICATION SPEC: - WEIGHT: - CUSTOMER ACCESSIBLE PRODUCTION DRAWING: -	12 JAN 2012 13 JAN 2012 13 JAN 2012 NAME: Ocean End Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2150245 SCALE: 1:1 SHEET: 4 of 4 REV: H	STE TE Connectivity Harrisburg, PA 17105-3608
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