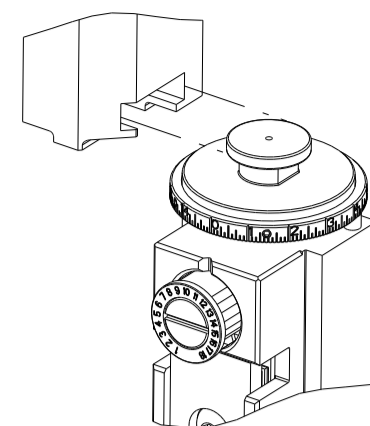


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150368-2	F	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150368-2	F	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150368-7	C	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	3.56 mm [.140]	F
INSUL	4.57 mm [.180]	F
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION			
TERMINAL NAME: RECEPTACLE, CLUSTER PIN, 3.18(.125) DIA			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
5.84-6.60 mm [.230-.260 IN]		∅3.05-4.32 mm [.120-.170 IN]	
TERMINAL APPLICATION SPECIFICATION	114-2019	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
1217175-1	1217175-4	1217175-5	62243-3
62243-5			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
10 AWG OR 5.20mm2	2.97+/-0.05 [.117+/- .002]	3.0
12 AWG OR 3.30mm2	2.54+/-0.05 [.100+/- .002]	7.6
14 AWG OR 2.00mm2	2.24+/-0.05 [.088+/- .002]	10.5



- 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.
 - 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 PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
 - 6 THE RECOMMENDED SET-UP FOR END FEED APPLICATORS IS POST-FEED WITH ITEM 2119653-1. THE APPLICATOR CAN BE CONFIGURED FOR PRE-FEED WITH ITEM 2119652-1 BUT MAY ENCOUNTER PROBLEMS WITH SOME APPLICATIONS. FEED ISSUES OR TERMINAL JAMMING MAY OCCUR IN THE PRE-FEED CONFIGURATION.
 - 7 FEED TERMINALS FROM RECEPTACLE END.
 - 8 SET ITEM 16 TO DIMENSION SHOWN.
 - 9 TERMINAL LUBRICANT IS RECOMMENDED.
 - 10 ITEM 27 MUST BE POSITIONED CLOSE ITEM 16 TO PROPERLY STRIP TERMINAL
11. 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)

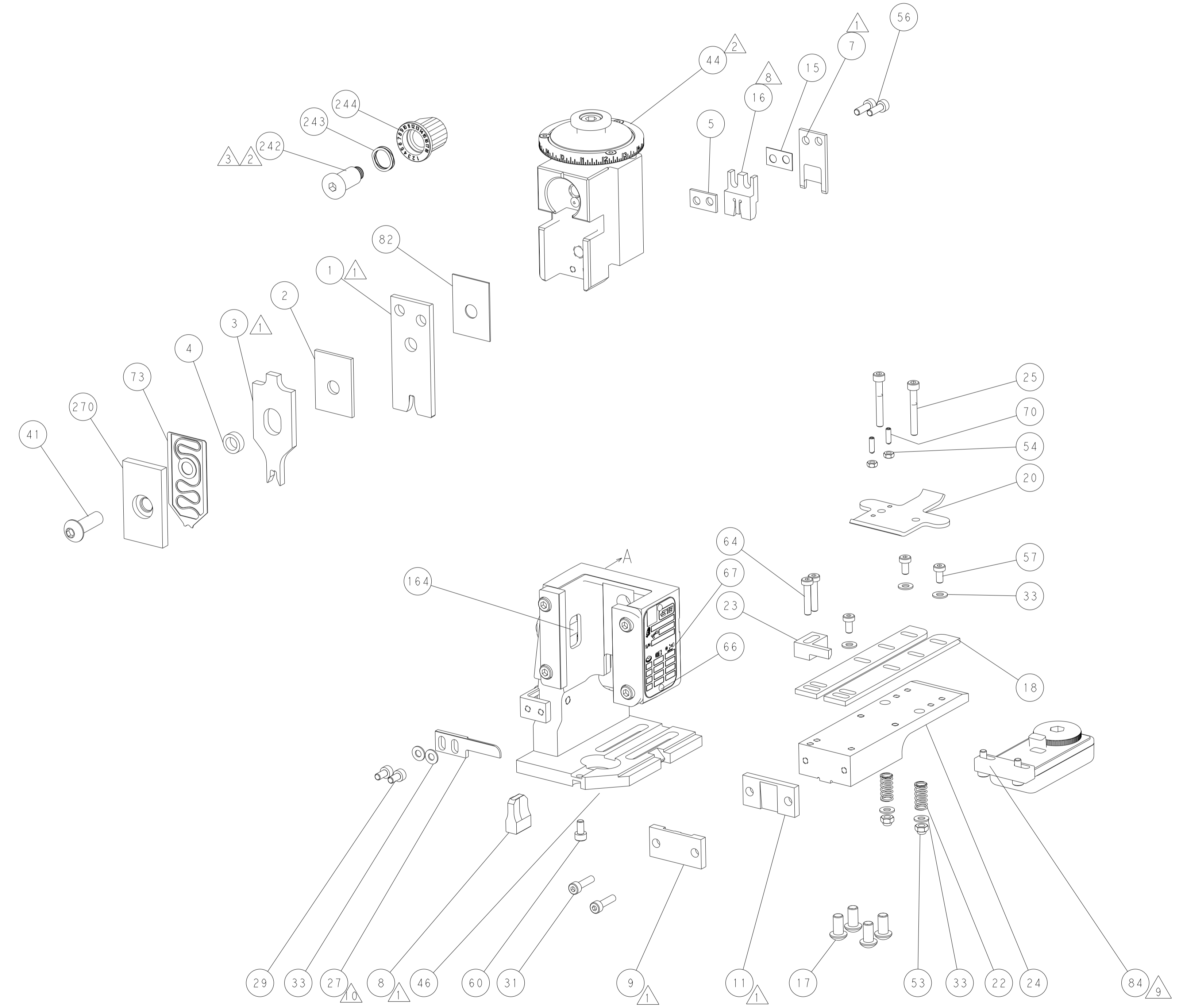
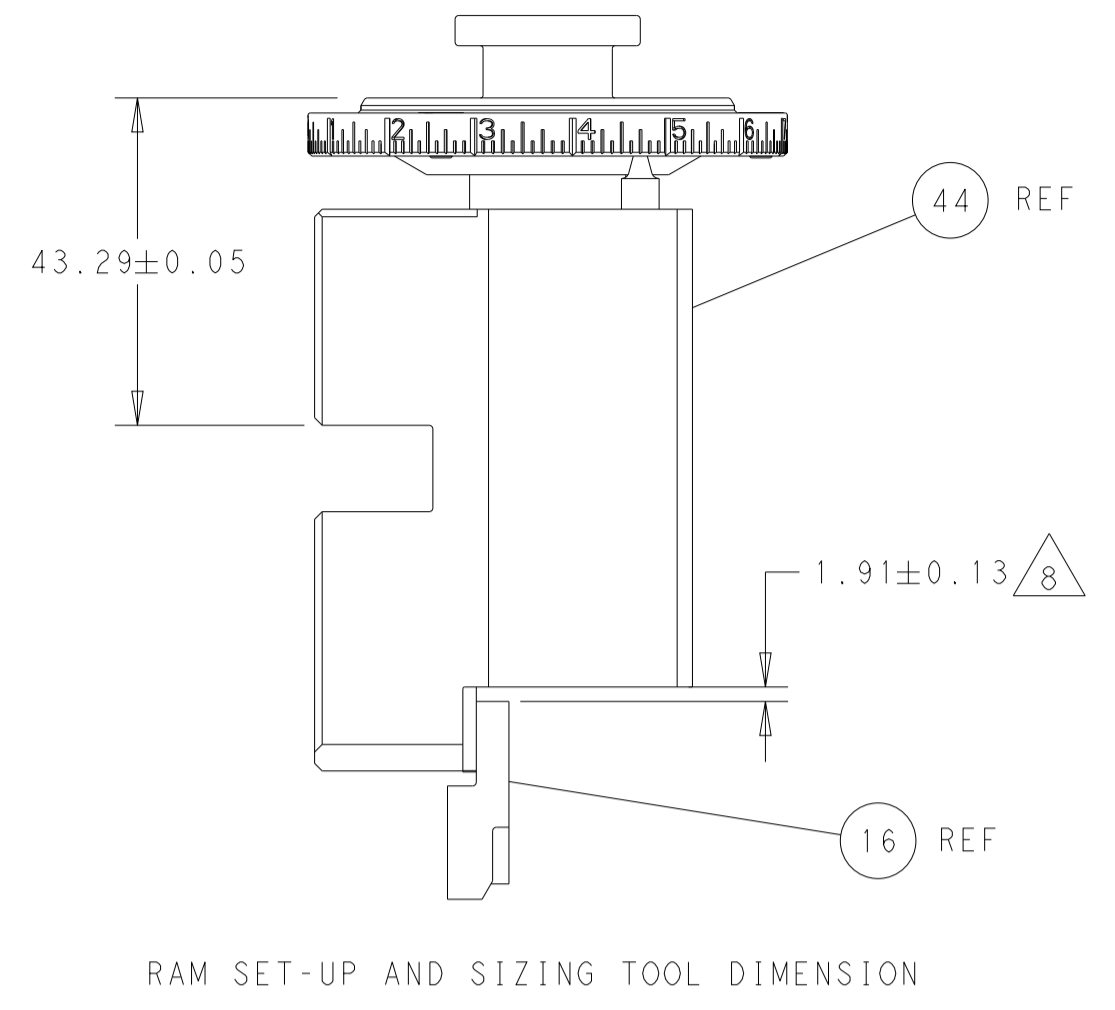
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		C		ECR-16-012215	25AUG2016	JH	CT
		D		ECR-19-013602	29AUG2019	LG	TE
		E		ECR-20-016675	23NOV2020	TB	RK
		F		ECR-22-137565	29APR2022	FJ	YY

-	1	1	1803203-1	BLOCK, FRONT DEPRESSOR	270
-	1	1	2119641-1	FEED CAM, AIR FEED	248
-	1	1	2119082-9	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	1	2844940-4	AIR FEED MODULE	238
-	REF	REF	994970-2	COUNTER, MAGNETIC	164
9	-	1	2119955-2	ASSY, LUBRICATOR, END FEED	84
-	1	1	455888-7	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
-	2	2	2168400-5	SHCS, LOW HEAD, RoHS, M4 X 20	64
-	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
-	3	3	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
7	-	1	2063961-1	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
-	7	7	1-18028-2	WASHER, FLAT, REG M4	33
-	2	2	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	31
-	2	2	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	29
10	-	1	240639-4	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
-	1	1	240825-3	PLATE, STRIP HOLD DOWN	23
-	2	2	2-22281-3	SPRING, COMPRESSION	22
-	1	1	1803292-4	DRAG	20
-	2	2	1901259-6	GUIDE, LOWER STRIP	18
-	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17
8	-	1	1-217573-1	TOOL, SIZING	16
-	1	1	5-240641-8	SPACER	15
1	-	1	240644-1	PLATE, REAR SHEAR	11
-	-	-	-	-	10
1	-	1	690482-3	PLATE, FRONT SHEAR	9
1	2	1	1633387-4	ANVIL, COMBINATION	8
1	-	1	5-690474-4	BLADE, SLUG	7
-	-	-	-	-	6
-	1	1	4-240641-2	SPACER	5
-	1	1	7-238011-3	BLOCK, CRIMPER SPACER	4
1	2	1	4-1633962-0	CRIMPER, INSULATION F PREMIUM	3
-	1	1	2-455888-1	SPACER, CRIMPER	2
1	2	1	1-456425-0	CRIMPER, WIRE .140 F PREMIUM	1
-	77	72	-2	PART NO	ITEM NO

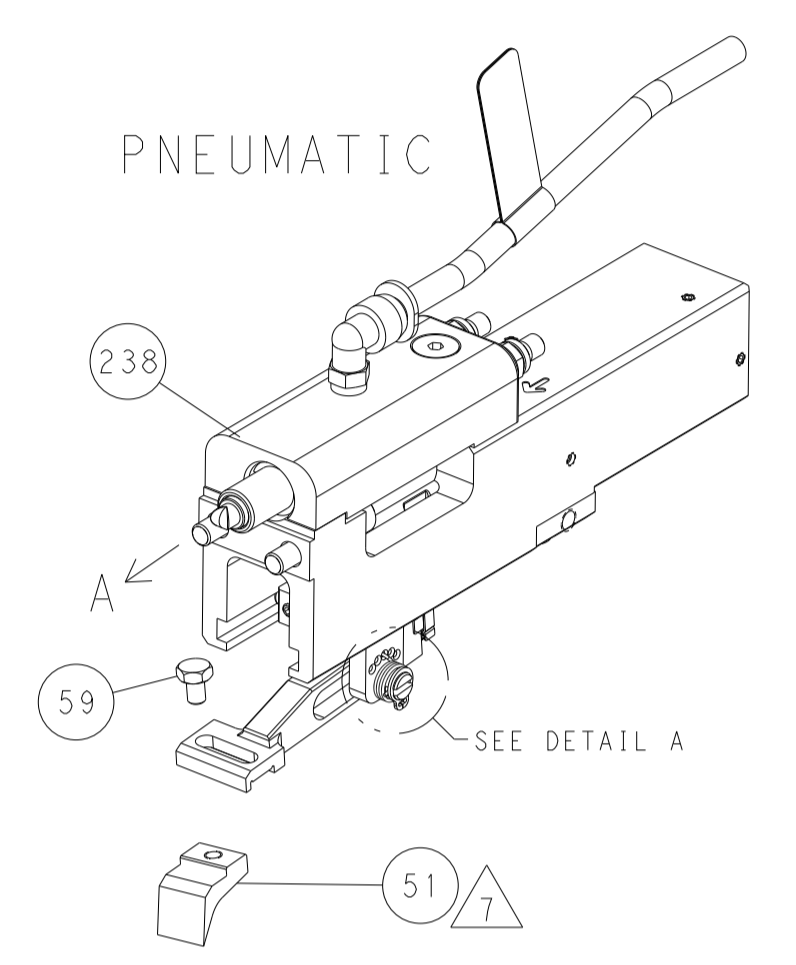
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mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±
	ANGLES ±	FINISH ±			
MATERIAL		WEIGHT		SCALE	
				1:1	

OWN	R. KNEPPER	26-Sep-13	 TE Connectivity Harrisburg, PA 17105-3608
CHK	G. BAILEY	26-Sep-13	
APVD	M. CLIFFORD	26-Sep-13	
PRODUCT SPEC			
APPLICATION SPEC			NAME
			Ocean End Feed Applicator
			SIZE
			A1
			CAGE CODE
			00779
			DRAWING NO
			2150368
			RESTRICTED TO
			-
			Customer Accessible Production Drawing
			SHEET 1 OF 4
			REV F

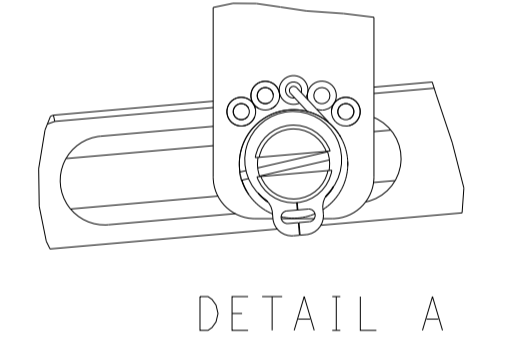
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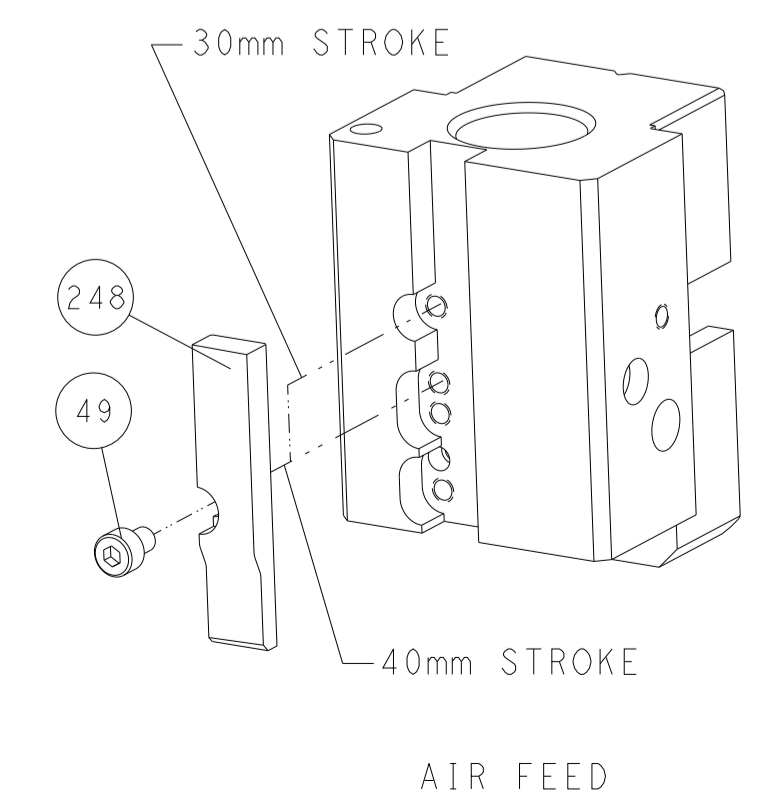
FEED TYPE



FEED SPRING SETTING POSITION



CAM POSITION

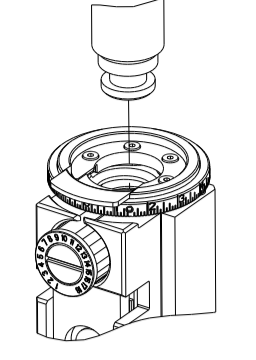


ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

<small>THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.</small>		DWN: R. KNEPPER 26-Sep-13 CHK: G. BAILEY 26-Sep-13 APVD: M. CLIFFORD 26-Sep-13	TE Connectivity Harrisburg, PA 17105-3608
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: WEIGHT:	RESTRICTED TO: SCALE: 1:1 SHEET 2 OF 4 REV F
MATERIAL:		CAGE CODE: 00779 DRAWING NO: 2150368	CUSTOMER ACCESSIBLE PRODUCTION DRAWING

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150368-2	F	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150368-7	C	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
 INTERFACE ADAPTER



APPLICATOR DATA

CRIMP	SIZE	TYPE
WIRE	3.56 mm [.140]	F
INSUL	4.57 mm [.180]	F

APPL INSTRUCTIONS
 408-35043

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION

TERMINAL NAME: RECEPTACLE, CLUSTER PIN, 3.18[.125] DIA

WIRE STRIP LENGTH	INSULATION DIAMETER RANGE
5.84-6.60 mm [.230-.260 IN]	4.32 mm [.170 IN] MAX

TERMINAL APPLICATION SPECIFICATION 114-2019

TERMINALS APPLIED 5 9

TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
1217175-1	1217175-4	1217175-5	62243-3
62243-5			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
10 AWG OR 5.20mm2	2.97+/-0.05 [.117+/-0.002]	3.0
12 AWG OR 3.30mm2	2.54+/-0.05 [.100+/-0.002]	7.6
14 AWG OR 2.00mm2	2.24+/-0.05 [.088+/-0.002]	10.5



- RECOMMENDED SPARE PARTS
 - REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
 - 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 PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
 - THE RECOMMENDED SET-UP FOR END FEED APPLICATORS IS POST-FEED WITH ITEM 2119653-1. THE APPLICATOR CAN BE CONFIGURED FOR PRE-FEED WITH ITEM 2119652-1 BUT MAY ENCOUNTER PROBLEMS WITH SOME APPLICATIONS. FEED ISSUES OR TERMINAL JAMMING MAY OCCUR IN THE PRE-FEED CONFIGURATION.
 - FEED TERMINALS FROM RECEPTACLE END.
 - SET ITEM 16 TO DIMENSION SHOWN.
 - TERMINAL LUBRICANT IS RECOMMENDED.
 - ITEM 27 MUST BE POSITIONED CLOSE ITEM 16 TO PROPERLY STRIP TERMINAL
11. 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.

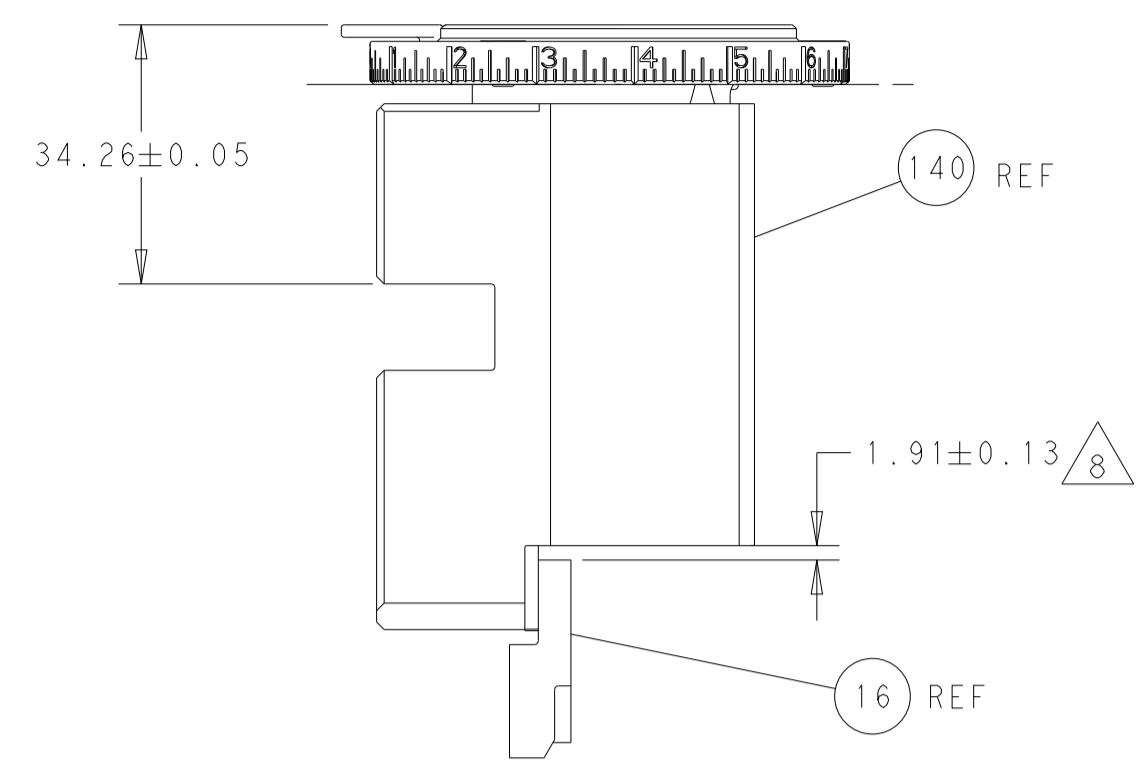
PACIFIC VERSION
 Shown on sheets 3 of 4 & 4 of 4
 (Atlantic version shown on sheets 1 of 4 & 2 of 4)

LOC	DIST	REV	DATE	BY	APPV
A	66				

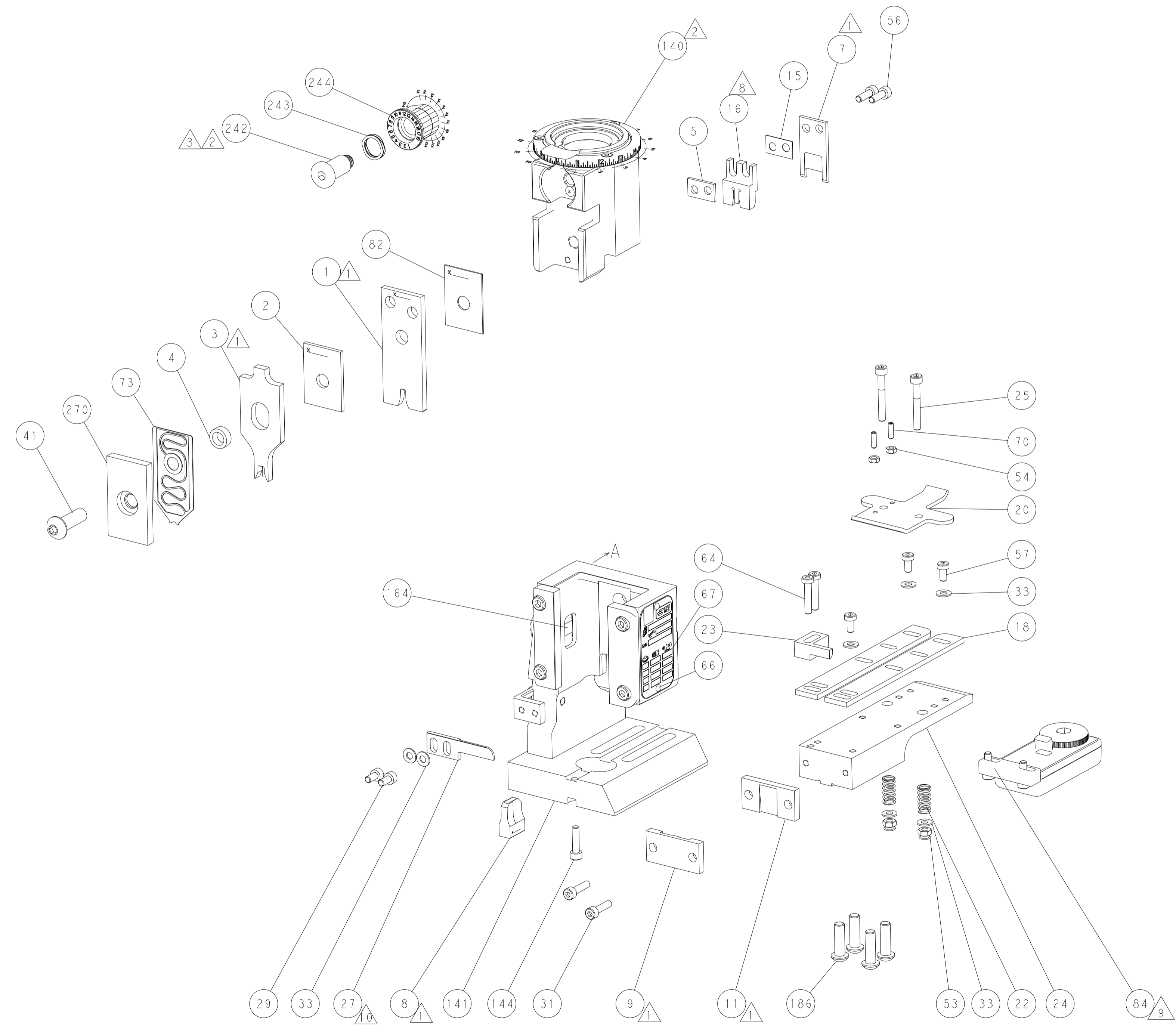
REV	DATE	DESCRIPTION	DATE	BY	APPV
-	1	1803203-1	BLOCK, FRONT DEPRESSOR		270
-	1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT		244
-	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST		243
-	1	2119083-1	RETAINER, INSULATION DIAL		242
-	1	2844940-4	AIR FEED MODULE		238
-	4	2079383-9	SCR, BHSC, RoHS (M6 X 20)		186
-	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	2119955-2	ASSY, LUBRICATOR, END FEED		84
-	1	455888-7	SPACER, CRIMPER		82
-	1	2119791-9	DEPRESSOR, WIRE		73
-	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
-	2	2168400-5	SHCS, LOW HEAD, RoHS, M4 X 20		64
-	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0		59
-	3	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8		57
-	2	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0		56
-	2	5018030-1	NUT, HEX, REG, RoHS, M3		54
-	2	986965-8	NUT, LOCK, HEX, TORQUE (M4)		53
-	1	2063961-1	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
-	7	1-18028-2	WASHER, FLAT, REG M4		33
-	2	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16		31
-	2	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0		29
-	1	240639-4	STRIPPER (MACHINING)		27
-	2	1-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 30		25
-	1	1752371-5	PLATE, STRIP GUIDE		24
-	1	240825-3	PLATE, STRIP HOLD DOWN		23
-	2	2-22281-3	SPRING, COMPRESSION		22
-	1	1803292-4	DRAG		20
-	2	1901259-6	GUIDE, LOWER STRIP		18
-	1	1-217573-1	TOOL, SIZING		16
-	1	5-240641-8	SPACER		15
-	1	240644-1	PLATE, REAR SHEAR		11
-	-	-	-		10
-	1	690482-3	PLATE, FRONT SHEAR		9
-	1	1633387-4	ANVIL, COMBINATION		8
-	1	5-690474-4	BLADE, SLUG		7
-	-	-	-		6
-	1	4-240641-2	SPACER		5
-	1	7-238011-3	BLOCK, CRIMPER SPACER		4
-	1	4-1633962-0	CRIMPER, INSULATION F PREMIUM		3
-	1	2-455888-1	SPACER, CRIMPER		2
-	1	1-456425-0	CRIMPER, WIRE .140 F PREMIUM		1
-	77-22	PART NO	DESCRIPTION		ITEM NO

DIMENSIONS:	TOLERANCES UNLESS OTHERWISE SPECIFIED:	APPROVED:	DATE:	NAME:
mm	0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±	R. KNEPPER G. BAILEY M. CLIFFORD	26-Sep-13 26-Sep-13 26-Sep-13	TE Connectivity Harrisburg, PA 17105-3608
MATERIAL:		WEIGHT:	SCALE:	RESTRICTED TO:
-		-	1:1	-

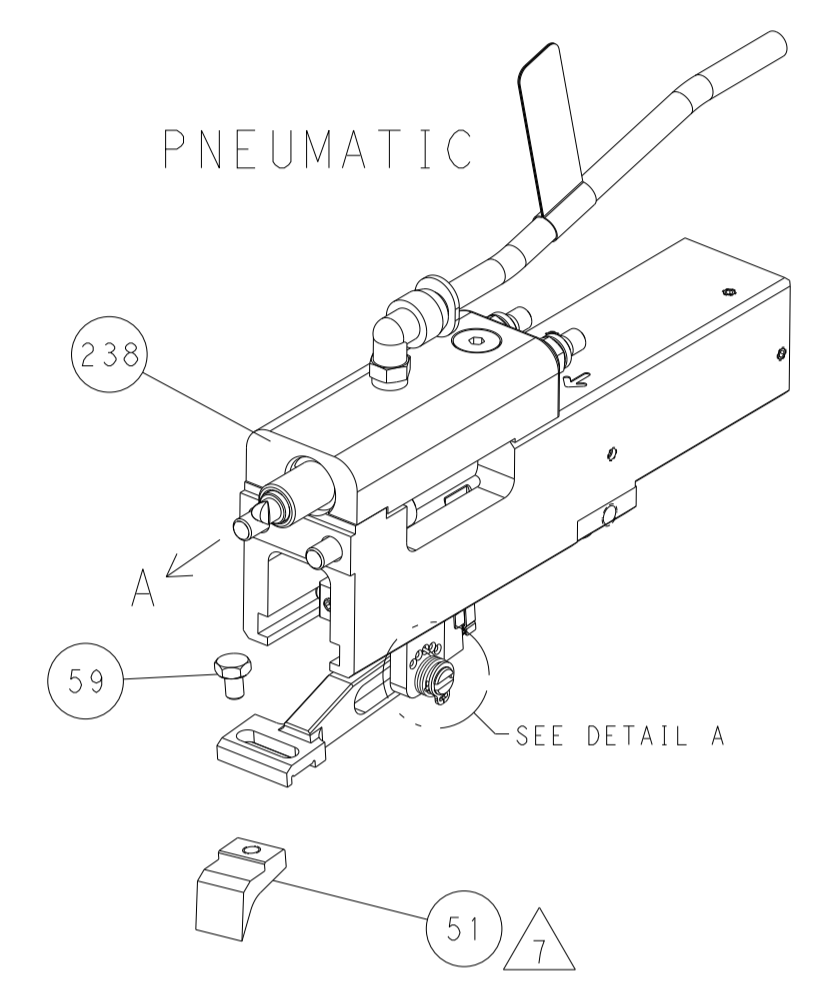
LOC	DIST	REVISIONS			
P	LTM	DESCRIPTION	DATE	OWN	APVD
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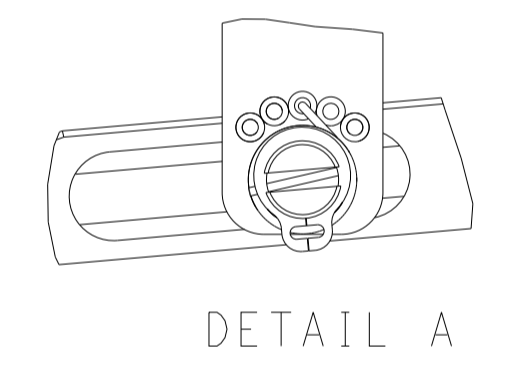
RAM SET-UP AND SIZING TOOL DIMENSION



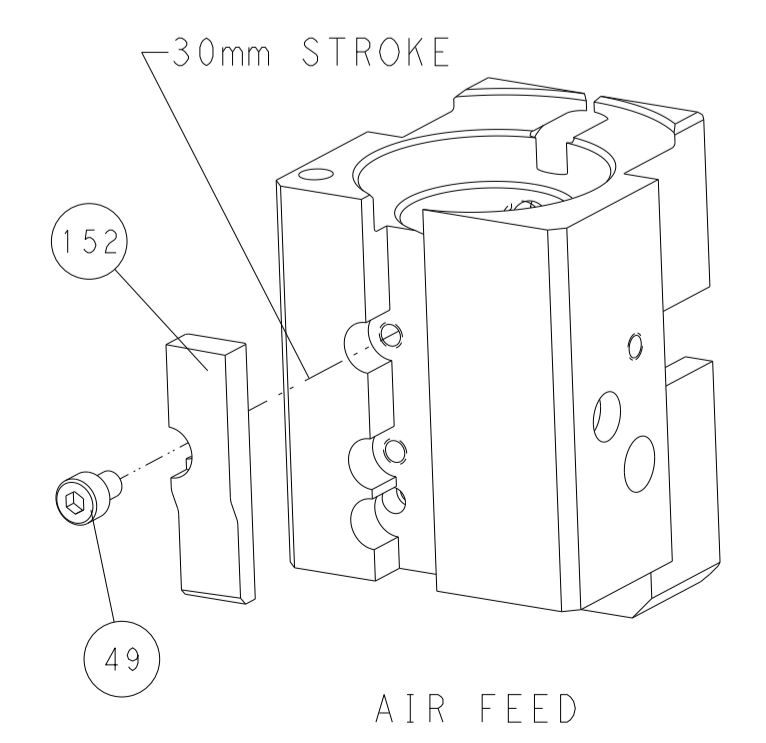
FEED TYPE



FEED SPRING SETTING POSITION



CAM POSITION



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 APPLICATION SPEC - SIZE CAGE CODE DRAWING NO. A1 00779 C=2150368 WEIGHT - SCALE 1:1 SHEET 4 OF 4 REV F	RESTRICTED TO -
Customer Accessible Production Drawing			