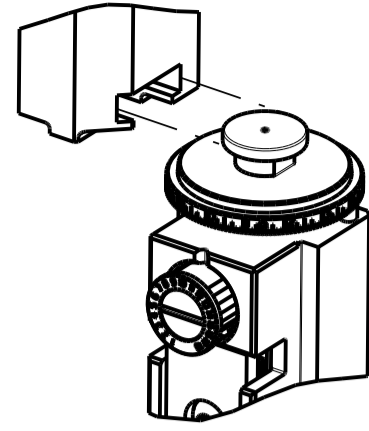


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150457-1	D	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2150457-2	D	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150457-1	D	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2150457-2	D	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150457-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.03 mm [.080]	F
INSUL	3.56 mm [.140]	F
APPLICATOR INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: .110 SERIES MINIATURE FASTON RECEPTACLE			
WIRE STRIP LENGTH 3.20-4.00 mm [.126-.157 IN]		INSULATION DIAMETER RANGE ∅ 1.50-2.80 mm [.059-.110 IN]	
TERMINAL APPLICATION SPECIFICATION 114-20109			
TERMINALS APPLIED			
TE TERMINAL 180423-1	TE TERMINAL 1-180423-1	TE TERMINAL 180437-2	TE TERMINAL 180429-2

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.50mm2	1.40 +/- 0.05 [.055 +/- .002]	7.1
1.00mm2	1.32 +/- 0.05 [.052 +/- .002]	8.0
0.75mm2	1.27 +/- 0.05 [.050 +/- .002]	8.6
0.50mm2	1.22 +/- 0.05 [.048 +/- .002]	9.1

- 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 ITEMS 180. 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 LUBRICANT IS RECOMMENDED.
- 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. 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)

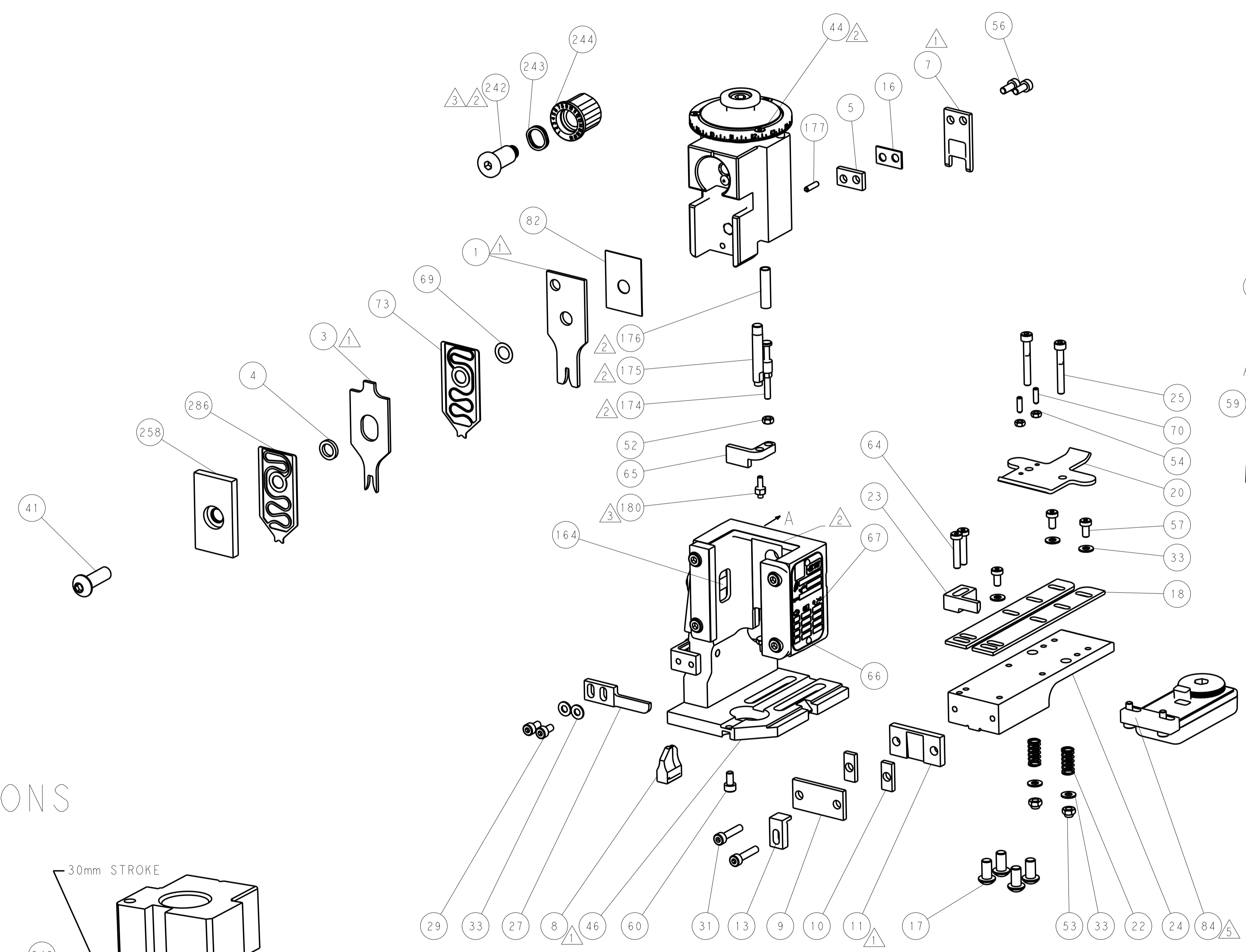
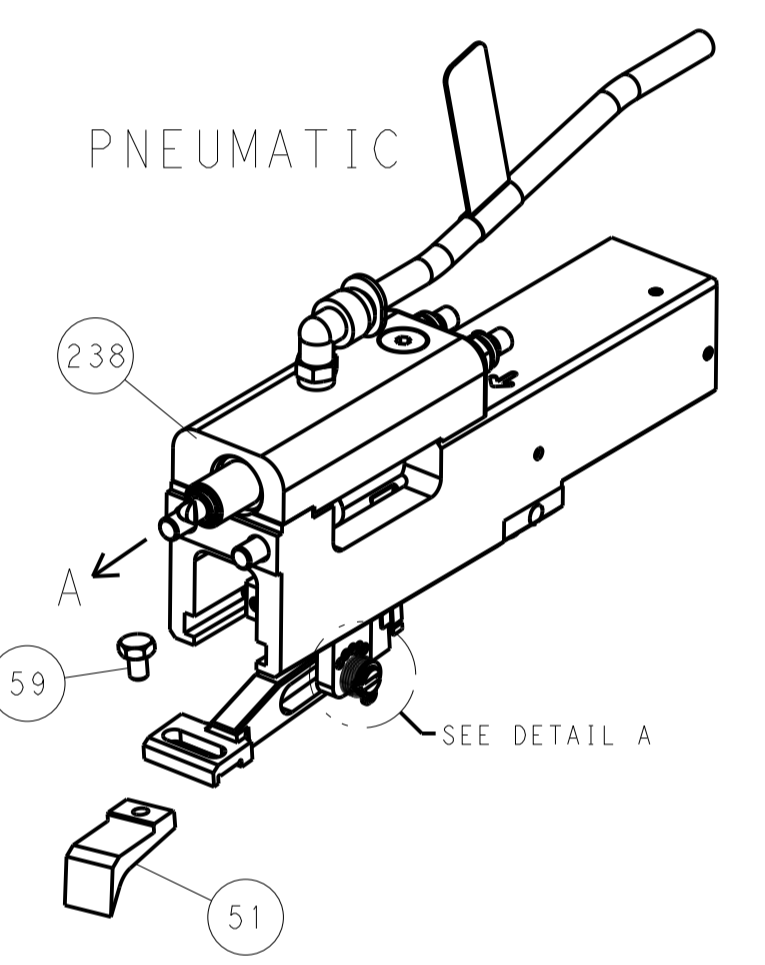
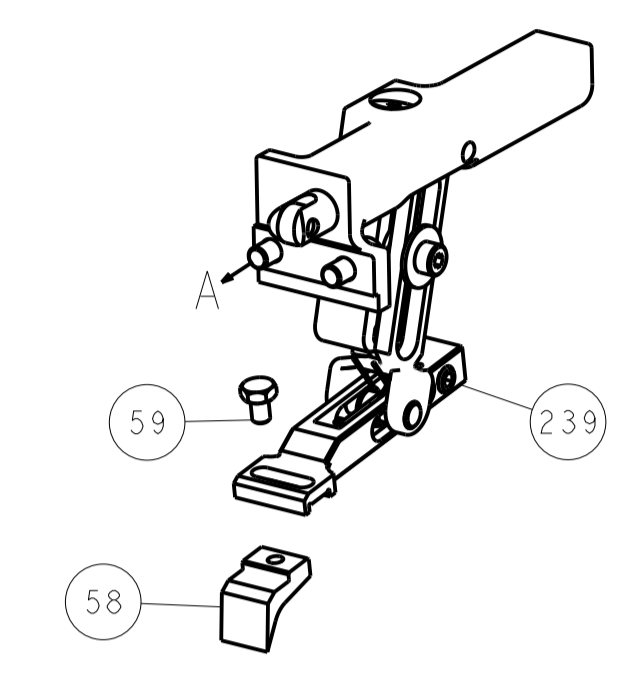
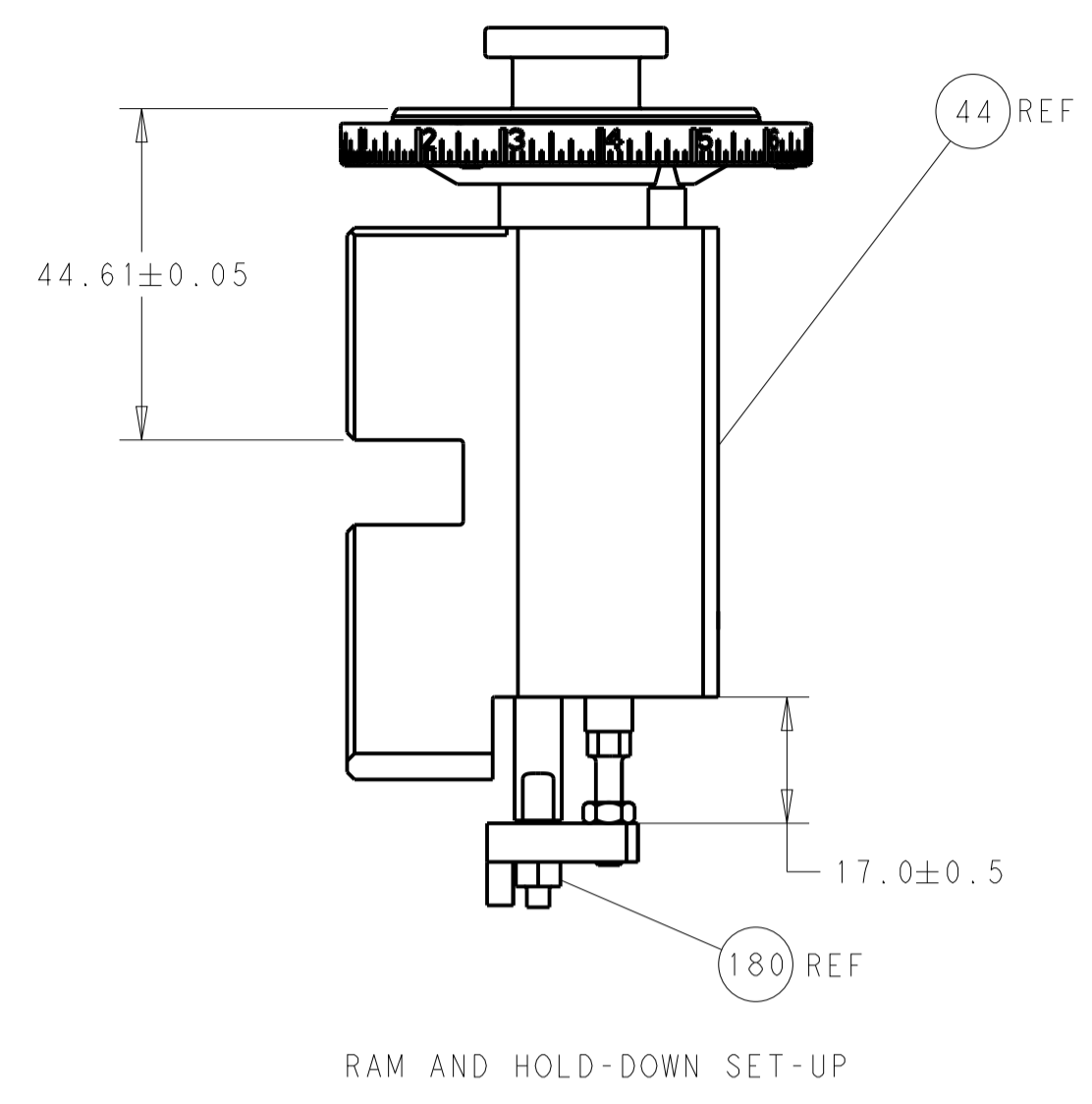
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		B	12JUL2017	TB	TE
		C	04DEC2019	FJ	TE
		D	20JUL2020	FJ	TE

-	1	1	1	1	2119791-7	DEPRESSOR, WIRE	286
-	1	1	1	1	1803203-1	BLOCK, FRONT DEPRESSOR	258
-	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	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	1976055-9	STANDOFF, HOLD-DOWN	180
-	1	1	1	1	993111-8	PIN, SLOTTED SPRING 3.0 X 12.0	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
5	-	1	1	1	2119955-2	ASSY, LUBRICATOR, END FEED	84
-	1	1	1	1	455888-4	SPACER, CRIMPER	82
-	1	1	1	1	2119791-5	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	1901681-5	HOLDDOWN, TERMINAL	65
-	2	2	2	2	2168400-5	SHCS, LOW HEAD, RoHS, M4 X 20	64
-	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
-	3	3	3	3	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57
-	2	2	2	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	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
-	7	7	7	7	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
-	1	1	1	1	240825-4	PLATE, STRIP HOLD DOWN	23
-	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	5-240641-9	SPACER	16
-	1	1	1	1	1752360-1	SPACER,HOLD-DOWN	13
1	-	1	-	1	240644-1	PLATE, REAR SHEAR	11
1	-	2	-	2	1-240645-4	SPACER, SHEAR PLATE	10
1	-	1	-	1	240642-1	PLATE, FRONT SHEAR	9
1	-	2	-	2	1333216-2	ANVIL, COMBINATION	8
1	-	1	-	1	1-240651-8	BLADE, SLUG	7
-	-	-	-	-	-	-	6
-	1	1	1	1	3-240641-0	SPACER	5
-	1	1	1	1	238011-8	BLOCK, CRIMPER SPACER	4
1	-	2	-	2	2-2119582-4	CRIMPER, INSULATION F PREMIUM	3
-	-	-	-	-	-	-	2
1	-	2	-	2	1-456405-2	CRIMPER, WIRE PREMIUM	1
-	-	-	-	-	-	-	1

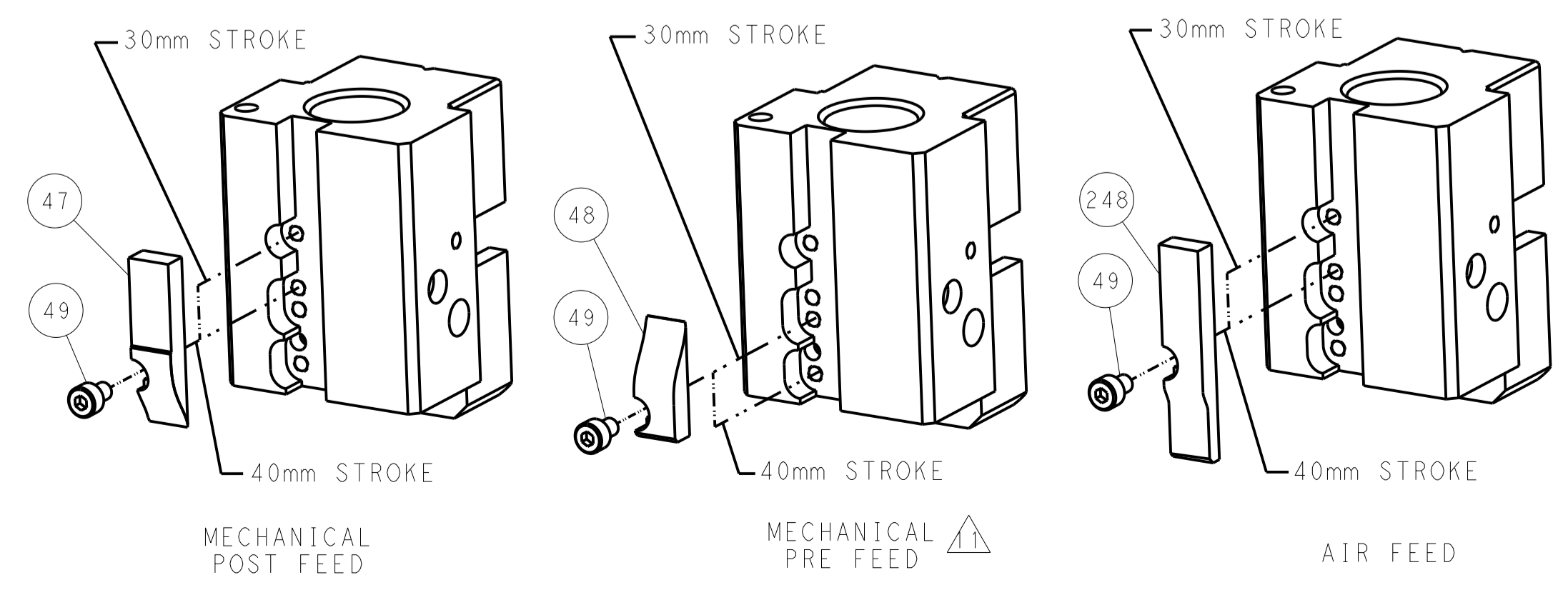
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1 PLC ±		1.5 PLC ±		APVD: T. ELBIN 09JUL2014		NAME: Ocean End Feed	
2 PLC ±		3 PLC ±		PRODUCT SPEC:		Applicator	
4 PLC ±		ANGLES ±		APPLICATION SPEC:		SIZE: CAGE CODE: DRAWING NO: RESTRICTED TO	
FINISH:		WEIGHT:		A1 00779 ©=2150457		SCALE: 1:1 SHEET 1 OF 4 REV D	
MATERIAL:				Customer Accessible Production Drawing			

LOC	DIST	REV	DATE	BY	CHKD	APVD
A	66					
REVISIONS			DESCRIPTION	DATE	BY	APVD
-			SEE SHEET 1	-	-	-

FEED TYPE MECHANICAL



CAM POSITIONS

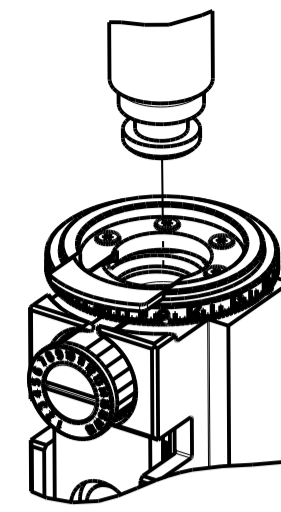


ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG: B. WEAVER 09JUL2014		TE Connectivity	
mm	0 PLC	±		CHK: T. ELBIN 09JUL2014	NAME: Ocean End Feed Applicator		Harrisburg, PA 17105-3608
	1 PLC	±		APVD: T. ELBIN 09JUL2014	SIZE: A11 00779 ©=2150457		RESTRICTED TO
	2 PLC	±		PRODUCT SPEC		SCALE: 1:1	SHEET 2 OF 4
	3 PLC	±		APPLICATION SPEC		REV: D	
	4 PLC	±		WEIGHT			
	ANGLES	±		MATERIAL			
				FINISH			
Customer Accessible Production Drawing							

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150457-1	D	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2150457-2	D	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150457-7	A	CRIMP TOOLING KIT	-

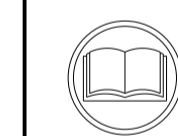
PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.03 mm [.080]	F
INSUL	3.56 mm [.140]	F
APPLICATOR INSTRUCTIONS 408-35043		

TERMINAL DATA:	TE TERMINAL	TE CRIMP SPECIFICATION	
TERMINAL NAME:	.110 SERIES MINIATURE FASTON RECEPTACLE		
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
3.20-4.00 mm [.126-.157 IN]		∅ 1.50-2.80 mm [.059-.110 IN]	
TERMINAL APPLICATION SPECIFICATION	114-20109		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
180423-1	1-180423-1	180437-2	
180423-2	180437-1	280429-2	

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.50mm2	1.40 +/- 0.05 [.055 +/- .002]	7.1
1.00mm2	1.32 +/- 0.05 [.052 +/- .002]	8.0
0.75mm2	1.27 +/- 0.05 [.050 +/- .002]	8.6
0.50mm2	1.22 +/- 0.05 [.048 +/- .002]	9.1



- 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 ITEMS 180. 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 LUBRICANT IS RECOMMENDED.
 - 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. 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)

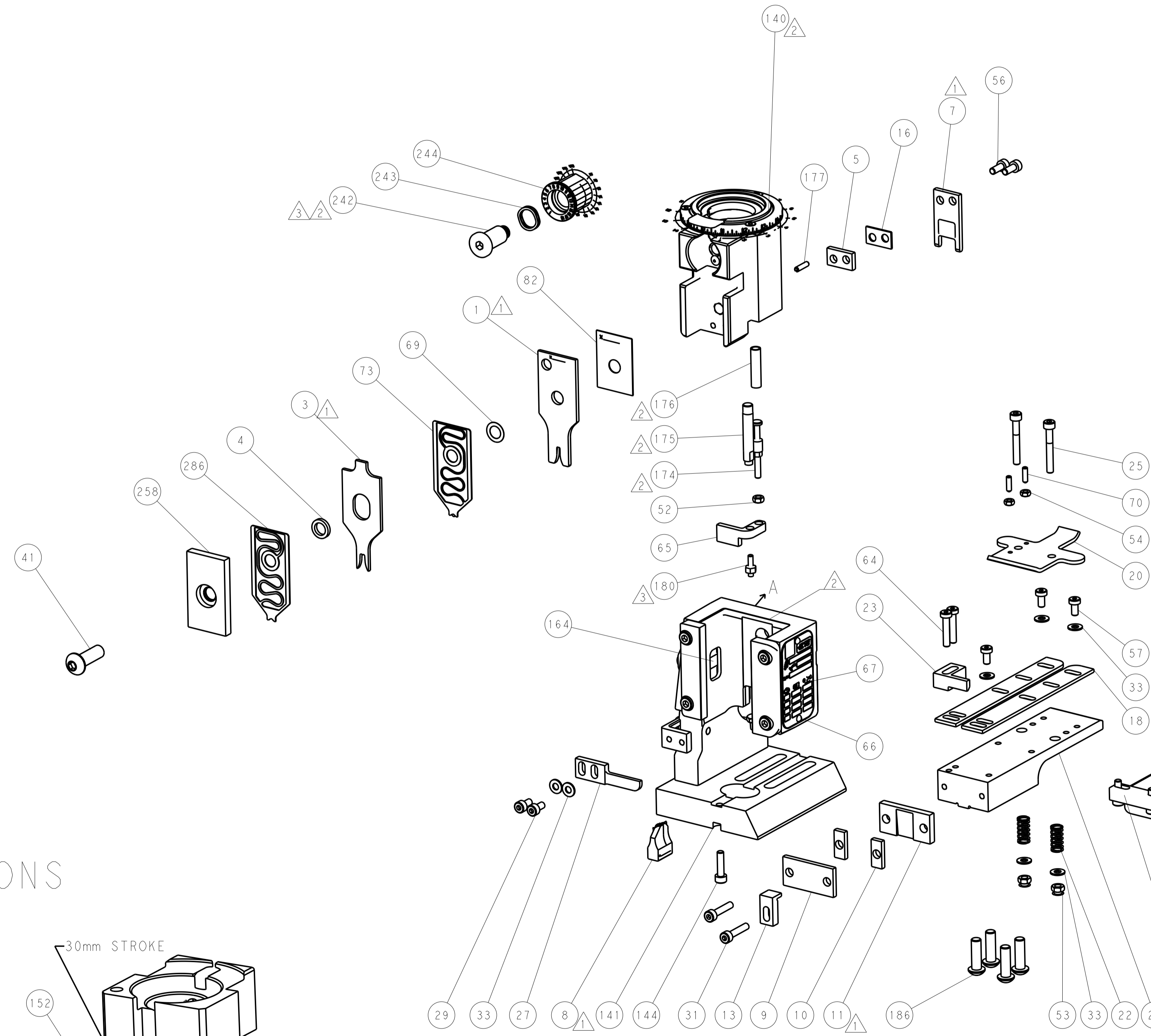
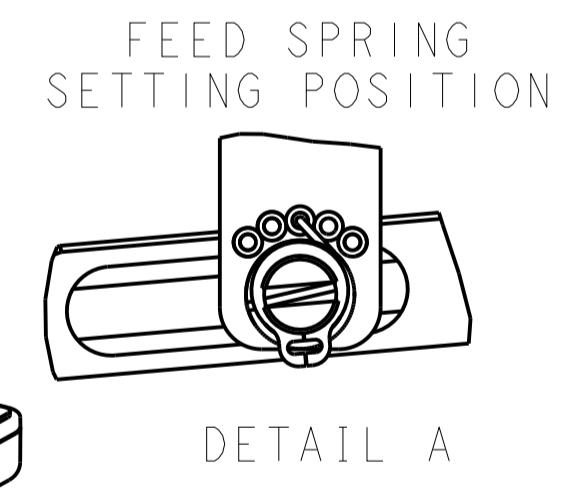
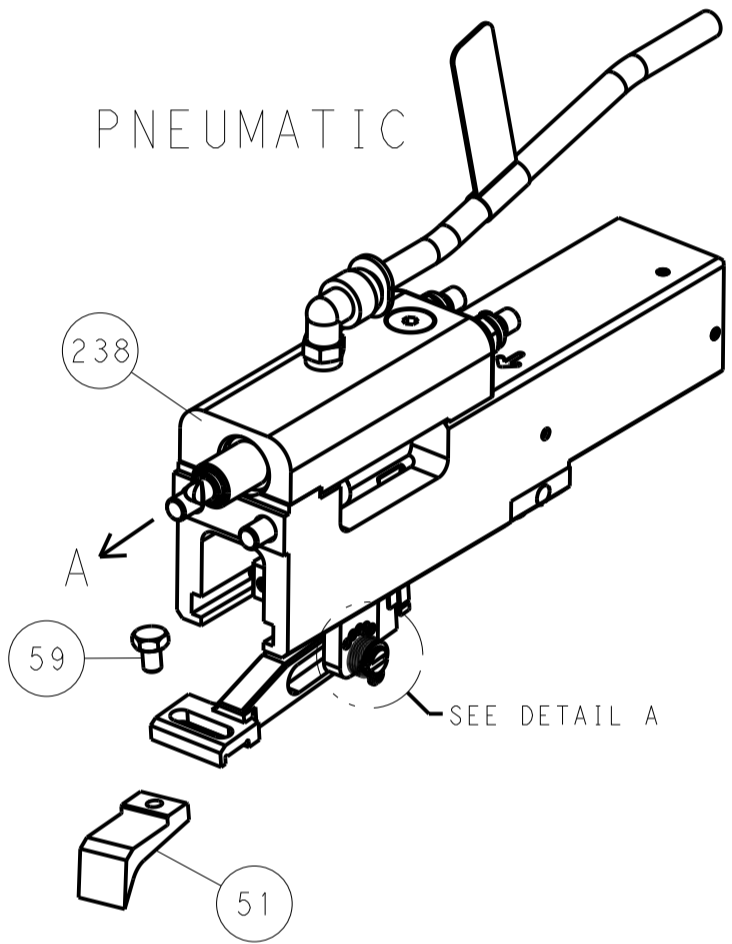
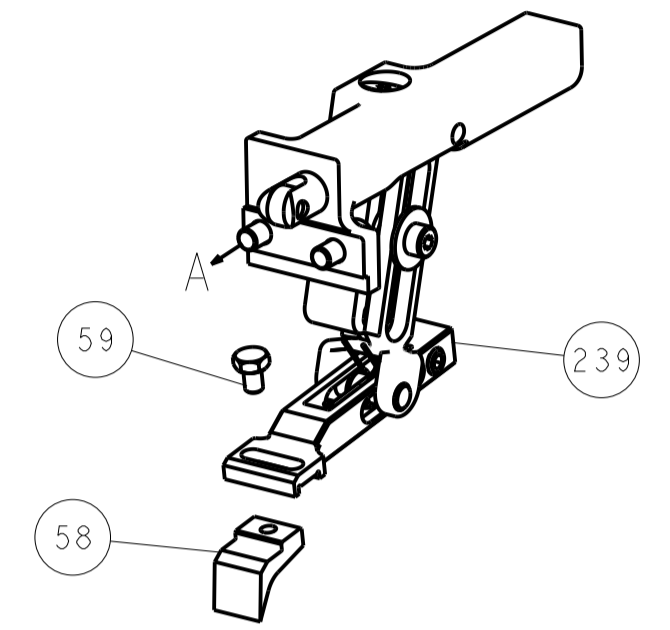
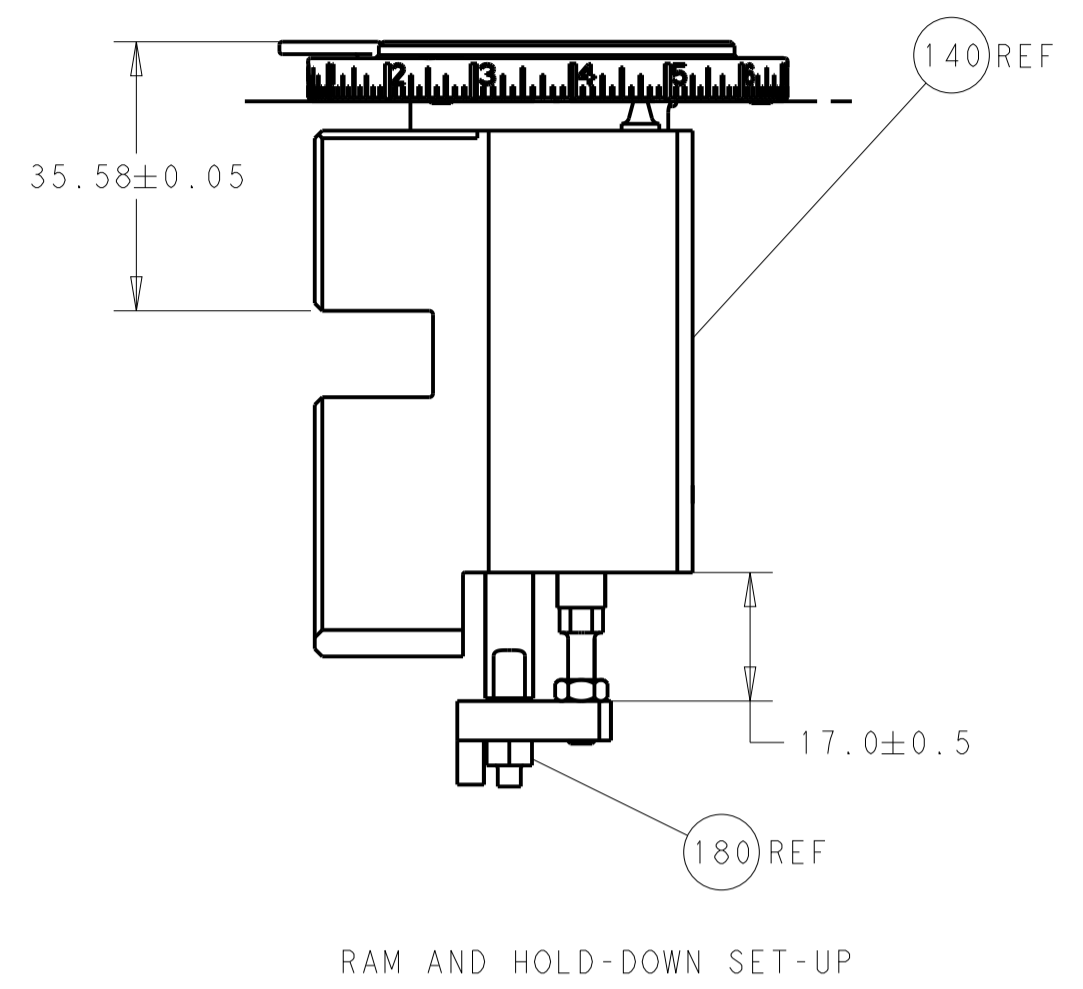
LOC	DIST	REV	DATE	BY	CHK	APPV
A	66					

REVISIONS							
REV	DATE	BY	CHK	APPV	DESCRIPTION	DATE	
-	-	-	-	-	SEE SHEET 1	-	
-	1	1			DEPRESSOR, WIRE	286	
-	1	1			BLOCK, FRONT DEPRESSOR	258	
-	1	1			CAM, SNAIL, INSULATION ADJUSTMENT	244	
-	1	1			WASHER, WAVE SPRING, CREST-TO-CREST	243	
-	1	1			RETAINER, INSULATION DIAL	242	
-	-	1			MECHANICAL FEED ASSEMBLY	239	
-	1	-			AIR FEED MODULE	238	
-	4	4			SCR, BHSC, RoHS (M6 X 20)	186	
-	1	1			STANDOFF, HOLD-DOWN	180	
-	1	1			PIN, SLOTTED SPRING 3.0 X 12.0	177	
-	1	1			SPRING, COMPRESSION	176	
-	1	1			GUIDE PIN, HOLDDOWN	175	
-	1	1			GUIDE PIN, HOLDDOWN	174	
-	REFREF				COUNTER, MAGNETIC	164	
-	1	-			FEED CAM, AIR FEED	152	
-	1	1			SCR, SKT HD CAP, RoHS, M4 X 16	144	
-	-	1			FEED CAM, POST FEED	142	
-	1	1			APPLICATOR BASIC ASSEMBLY, EF	141	
-	1	1			RAM ASSEMBLY, EF PACIFIC	140	
-	1	1			ASSY, LUBRICATOR, END FEED	84	
-	1	1			SPACER, CRIMPER	82	
-	1	1			DEPRESSOR, WIRE	73	
-	1	1			DOCUMENTATION PACKAGE	71	
-	2	2			SCR, SET, FLT PNT, M3 X 10.0	70	
-	1	1			WASHER, SPACER	69	
-	1	1			TAG, IDENTIFICATION	67	
-	2	2			SCREW, DRIVE, RH, RoHS, 2 x .188	66	
-	1	1			HOLDDOWN, TERMINAL	65	
-	2	2			SHCS, LOW HEAD, RoHS, M4 X 20	64	
-	-	2			SCR, HEX HD CAP, M4 X 6.0	59	
-	-	1			FEED FINGER	58	
-	3	3			SHCS, LOW HEAD, RoHS, M4 X 8	57	
-	2	2			SCR, SKT HD CAP, RoHS, M4 X 10	56	
-	2	2			NUT, HEX, REG, RoHS, M3	54	
-	2	2			NUT, LOCK, HEX, TORQUE (M4)	53	
-	1	1			NUT, HEX, REG, RoHS, M3.5	52	
-	1	-			FEED FINGER	51	
-	1	2			SCR, SKT HD CAP M4 X 6.0	49	
-	-	1			FEED CAM, PRE FEED	48	
-	1	1			SCR, BHSC, RoHS (M8 X 25)	41	
-	7	7			WASHER, FLAT, REG M4	33	
-	2	2			SCR, SKT HD CAP, RoHS, M4 X 20	31	
-	2	2			SCR, SKT HD CAP, RoHS, M4 X 8.0	29	
-	1	1			STRIPPER (MACHINING)	27	
-	2	2			SCR, SKT HD CAP, RoHS, M4 X 30	25	
-	1	1			PLATE, STRIP GUIDE	24	
-	1	1			PLATE, STRIP HOLD DOWN	23	
-	2	2			SPRING, COMPRESSION	22	
-	1	1			DRAG	20	
-	2	2			GUIDE, LOWER STRIP	18	
-	1	1			SPACER	16	
-	1	1			SPACER, HOLD-DOWN	13	
-	1	1			PLATE, REAR SHEAR	11	
-	2	2			SPACER, SHEAR PLATE	10	
-	1	1			PLATE, FRONT SHEAR	9	
-	1	1			ANVIL, COMBINATION	8	
-	1	1			BLADE, SLUG	7	
-	-	-			-	6	
-	1	1			SPACER	5	
-	1	1			BLOCK, CRIMPER SPACER	4	
-	1	1			CRIMPER, INSULATION F PREMIUM	3	
-	-	-			-	2	
-	1	1			CRIMPER, WIRE PREMIUM	1	
-	77-22-21				PART NO	DESCRIPTION	ITEM NO

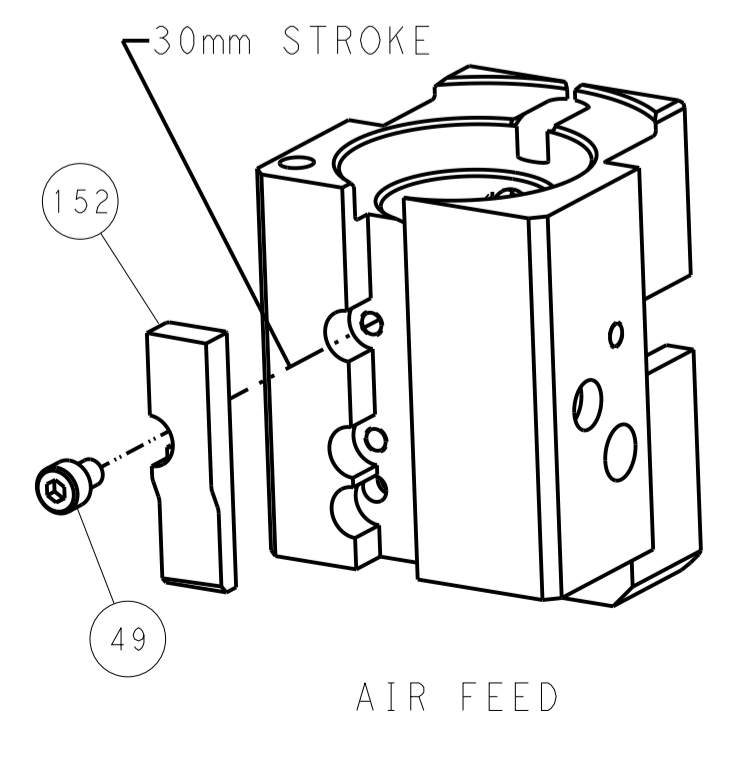
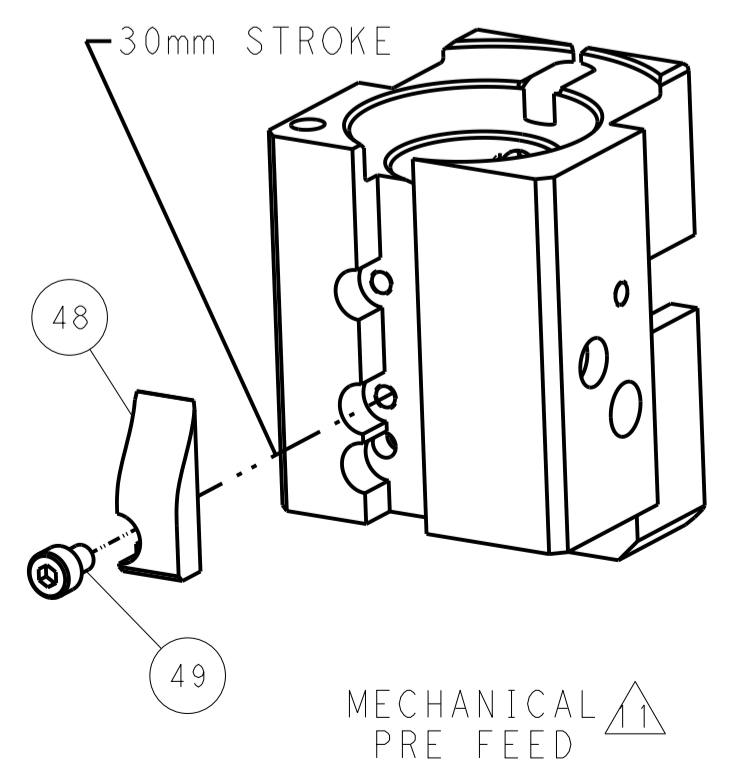
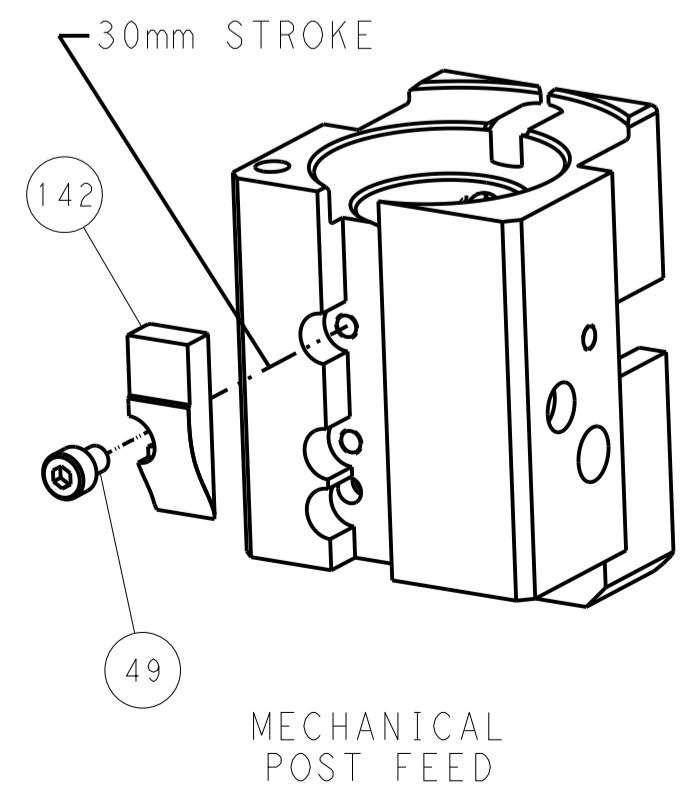
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG: B. WEAVER 09JUL2014		CHK: T. ELBIN 09JUL2014		APPV: T. ELBIN 09JUL2014		NAME: Ocean End Feed Applicator	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	5 PLC ±	6 PLC ±	7 PLC ±	8 PLC ±	9 PLC ±	10 PLC ±
MATERIAL:		FINISH:		WEIGHT:		SCALE: 1:1		SHEET: 3 OF 4		REV: D	

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

FEED TYPE MECHANICAL



CAM POSITIONS



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

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG: B. WEAVER 09JUL2014		TE Connectivity	
mm	0 PLC	±		CHK: T. ELBIN 09JUL2014	NAME: Ocean End Feed Applicator		Harrisburg, PA 17105-3608
	1 PLC	±		APVD: T. ELBIN 09JUL2014	SIZE: A		CAGE CODE: 00779
	2 PLC	±		PRODUCT SPEC:	DRAWING NO: 2150457		RESTRICTED TO:
	3 PLC	±		APPLICATION SPEC:	SCALE: 1:1		SHEET 4 OF 4
	4 PLC	±		WEIGHT:	REV: D		
	ANGLES	±		Customer Accessible Production Drawing			