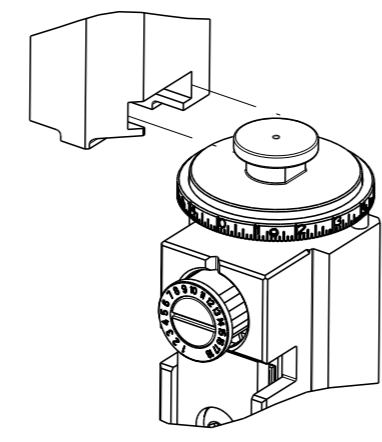


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150554-1	A	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2150554-2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150554-1	A	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2150554-2	A	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150554-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.78 mm [.070]	F
INSUL	3.56 mm [.140]	F
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: RECEPTACLE, FASTON, ECONOMY, .187 SERIES			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
4.40-5.16 mm [.173-.203 IN]		∅2.29-3.30 mm [.090-.130 IN]	
TERMINAL APPLICATION SPECIFICATION	114-2036		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
63347-1			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
18 AWG	1.27 +/- 0.05 [0.050 +/- .002]	4.6
20 AWG	1.14 +/- 0.05 [0.045 +/- .002]	6.0
22 AWG	1.07 +/- 0.05 [0.042 +/- .002]	6.7

- 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. 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.
- 5. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- TERMINAL LUBRICANT IS RECOMMENDED.

***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.

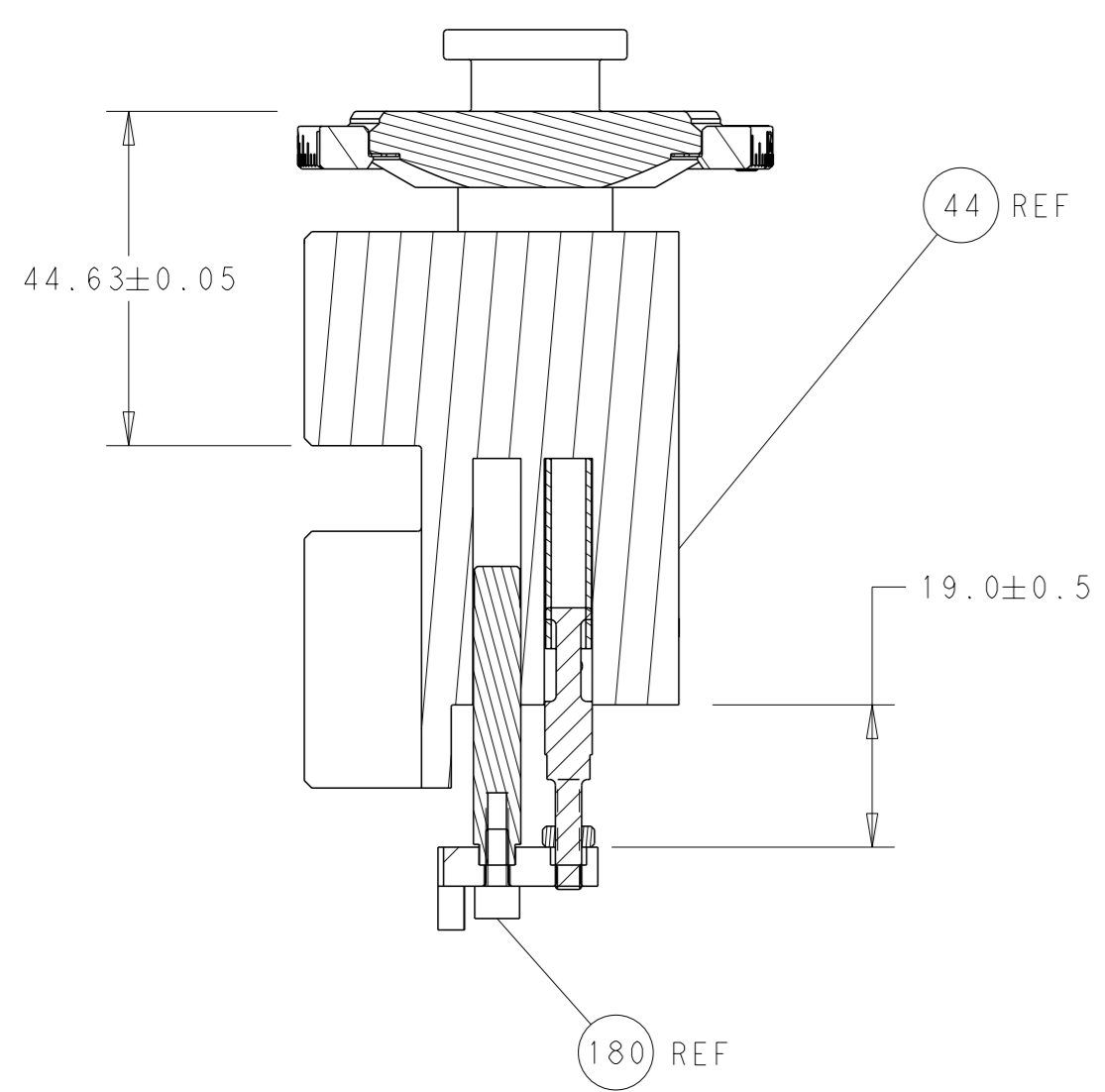
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

LOC	DIST	REVISIONS					
		P	LY#	DESCRIPTION	DATE	OWN	APVD
A	66	1		DEVELOPMENT	12JUN2015	XZ	UG
		2		DEVELOPMENT	01AUG2019	TB	TE
		A		RELEASED	22AUG2019	FZ	TE

-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248	
-	1	1	1	1	2119082-3	CAM, SNAIL, INSULATION ADJUSTMENT	244	
-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243	
	-	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	
-	1	1	1	1	1-18028-0	WASHER, FLAT, REG M8	192	
	-	1	1	1	1752354-2	STANDOFF, HOLD-DOWN	180	
-	1	1	1	1	6-9931111-6	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	2119955-2	ASSY, LUBRICATOR, END FEED	84	
-	1	1	1	1	455888-5	SPACER, CRIMPER	82	
-	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	2119740-1	TAG, IDENTIFICATION	67	
-	2	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66	
-	1	1	1	1	1-1901681-8	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	2063961-5	FEED FINGER	58	
-	4	4	4	4	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57	
-	2	2	2	2	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	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	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	31	
-	2	2	2	2	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	29	
-	1	1	1	1	240639-3	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	22281-8	SPRING, COMPRESSION	22	
-	1	1	1	1	1803292-4	DRAG	20	
-	1	1	1	1	1803152-5	STRIP GUIDE, REAR	19	
-	1	1	1	1	1803151-5	STRIP GUIDE, FRONT	18	
-	4	4	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17	
-	1	1	1	1	6-240641-6	SPACER	16	
	-	1	1	1	240644-1	PLATE, REAR SHEAR	11	
-	-	-	-	-	-	-	10	
	-	1	1	1	690482-6	PLATE, FRONT SHEAR	9	
	1	2	2	1	1	8-1803000-1	ANVIL, COMBINATION, END FEED	8
	-	1	1	1	1	2217206-4	BLADE, SLUG	7
-	-	-	-	-	-	-	6	
-	1	1	1	1	240641-7	SPACER	5	
-	1	1	1	1	238011-2	BLOCK, CRIMPER SPACER	4	
	1	2	2	1	1	2-1633961-3	CRIMPER, INSULATION F PREMIUM	3
-	1	1	1	1	455888-4	SPACER, CRIMPER	2	
	1	2	2	1	1	1-456404-8	CRIMPER, WIRE PREMIUM	1
					-77-72-71-2-1	PART NO	DESCRIPTION	ITEM NO

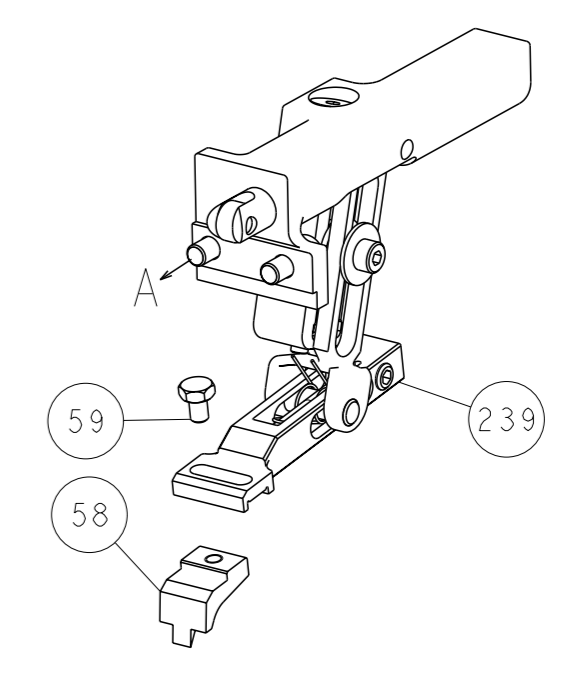
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mm	0 PLC ±	1 PLC ±	2 PLC ±	X ZHAO	12JUN2015	TE Connectivity	
	3 PLC ±	4 PLC ±	ANGLES ±	L ZHANG	12JUN2015	Harrisburg, PA 17105-3608	
MATERIAL	FINISH	FINISH	FINISH	U GUO	12JUN2015	NAME	
						Ocean End Feed Applicator	
						SIZE	CAGE CODE
						A1	00779
						DRAWING NO	2150554
						RESTRICTED TO	
						Customer Accessible Production Drawing	SCALE 1:1
						SHEET 1	OF 4
						REV	A

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

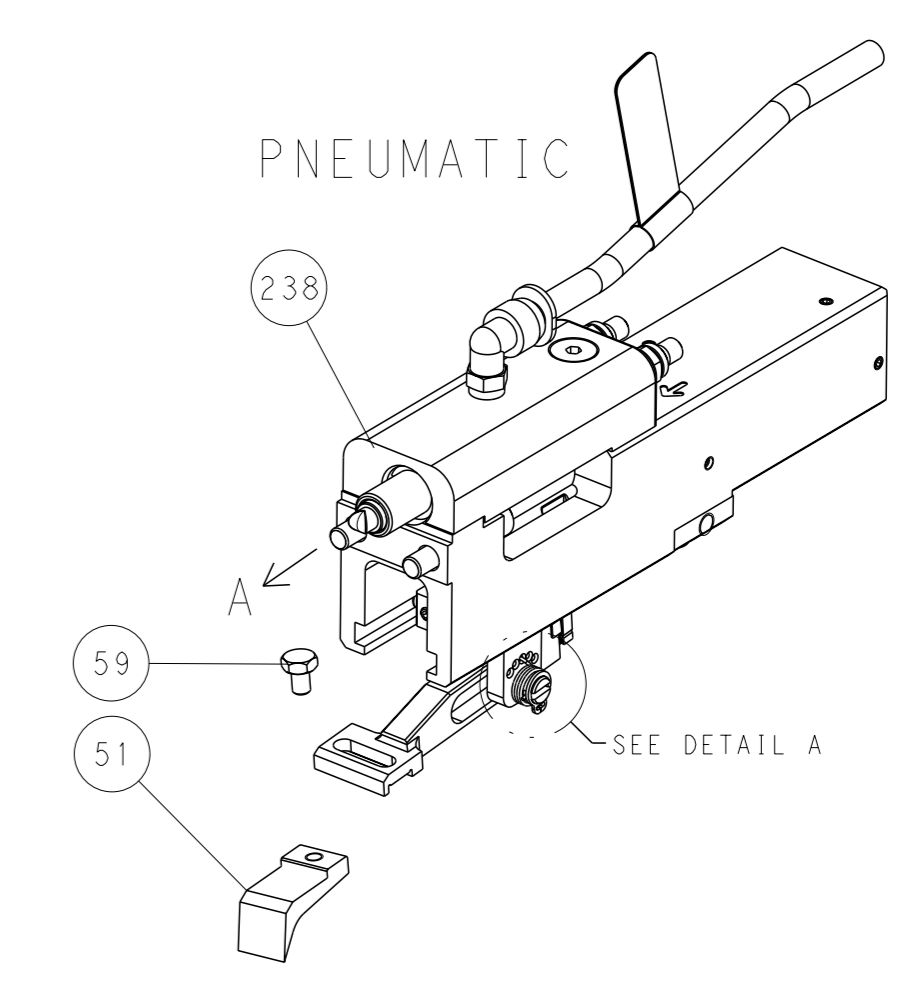


RAM AND HOLDDOWN SET-UP

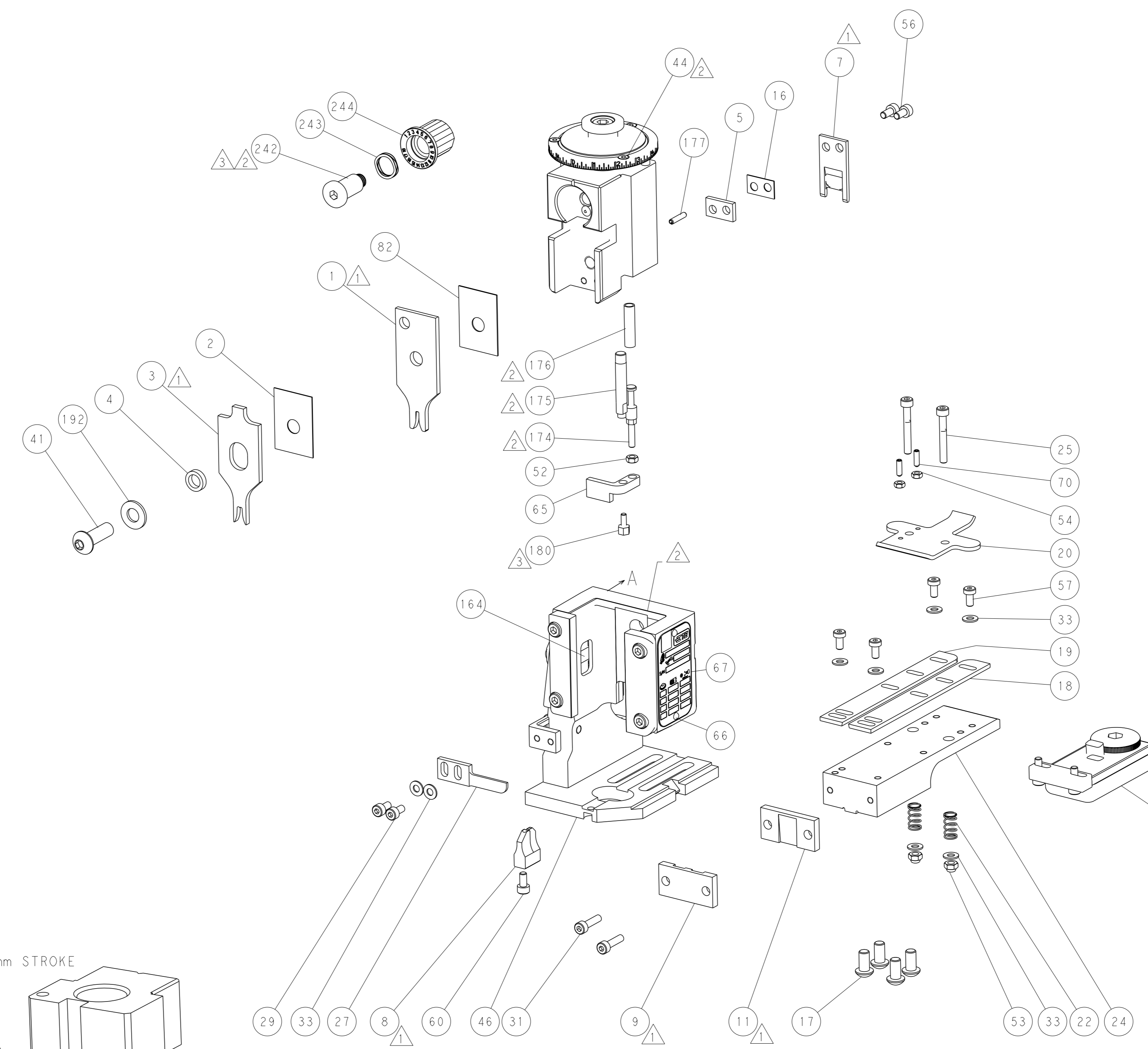
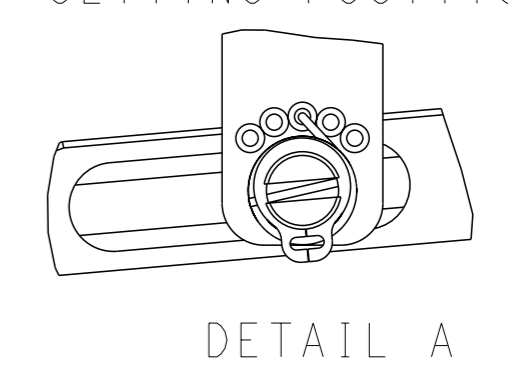
FEED TYPE
MECHANICAL



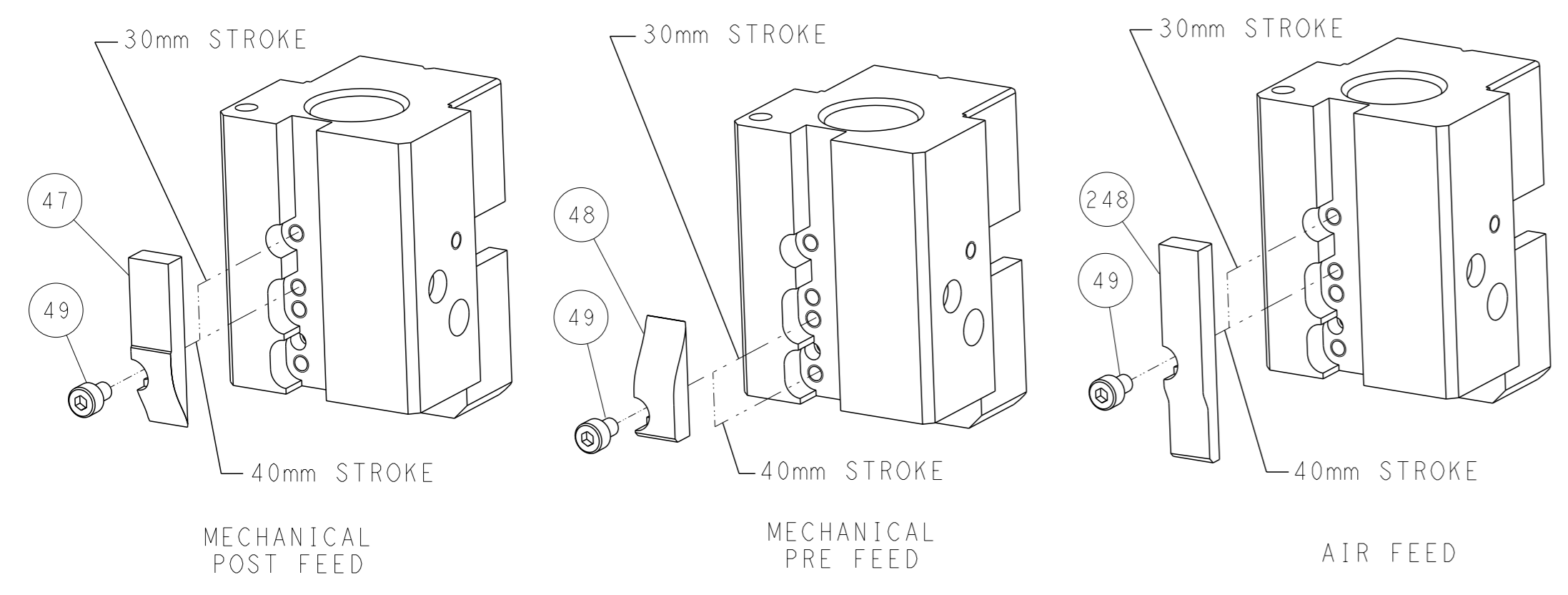
PNEUMATIC



FEED SPRING
SETTING POSITION



CAM POSITIONS

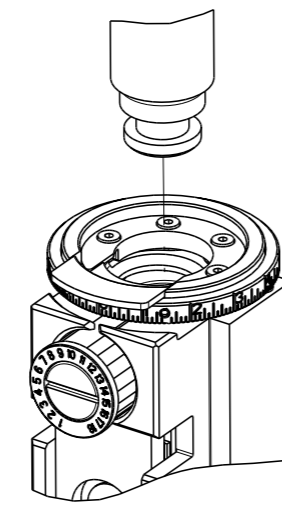


ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

<small>THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.</small>		OWN: X. ZHAO CHK: L. ZHANG APVD: H. GUO	DATE: 12 JUN 2015 DATE: 12 JUN 2015 DATE: 12 JUN 2015	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 SIZE: A1 CAGE CODE: 00779 DRAWING NO: ©=2150554	RESTRICTED TO: - SCALE: 1:1 SHEET: 2 of 4 REV: A	CUSTOMER ACCESSIBLE PRODUCTION DRAWING

THIS DRAWING IS UNPUBLISHED.	RELEASED FOR PUBLICATION	20	
COPYRIGHT 20 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.			
PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150554-1	A	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2150554-2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150554-7	A	CRIMP TOOLING KIT	-

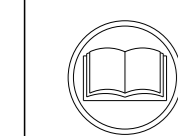
PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.78 mm [.070]	F
INSUL	3.56 mm [.140]	F
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: RECEPTACLE, FASTON, ECONOMY, .187 SERIES			
WIRE STRIP LENGTH 4.40-5.16 mm [.173-.203 IN]		INSULATION DIAMETER RANGE Ø2.29-3.30 mm [.090-.130 IN]	
TERMINAL APPLICATION SPECIFICATION 114-2036			
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
63347-1			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
18 AWG	1.27+/-0.05 [.050+/- .002]	4.6
20 AWG	1.14+/-0.05 [.045+/- .002]	6.0
22 AWG	1.07+/-0.05 [.042+/- .002]	6.7



- 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. 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.
- UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- TERMINAL LUBRICANT IS RECOMMENDED.

***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.

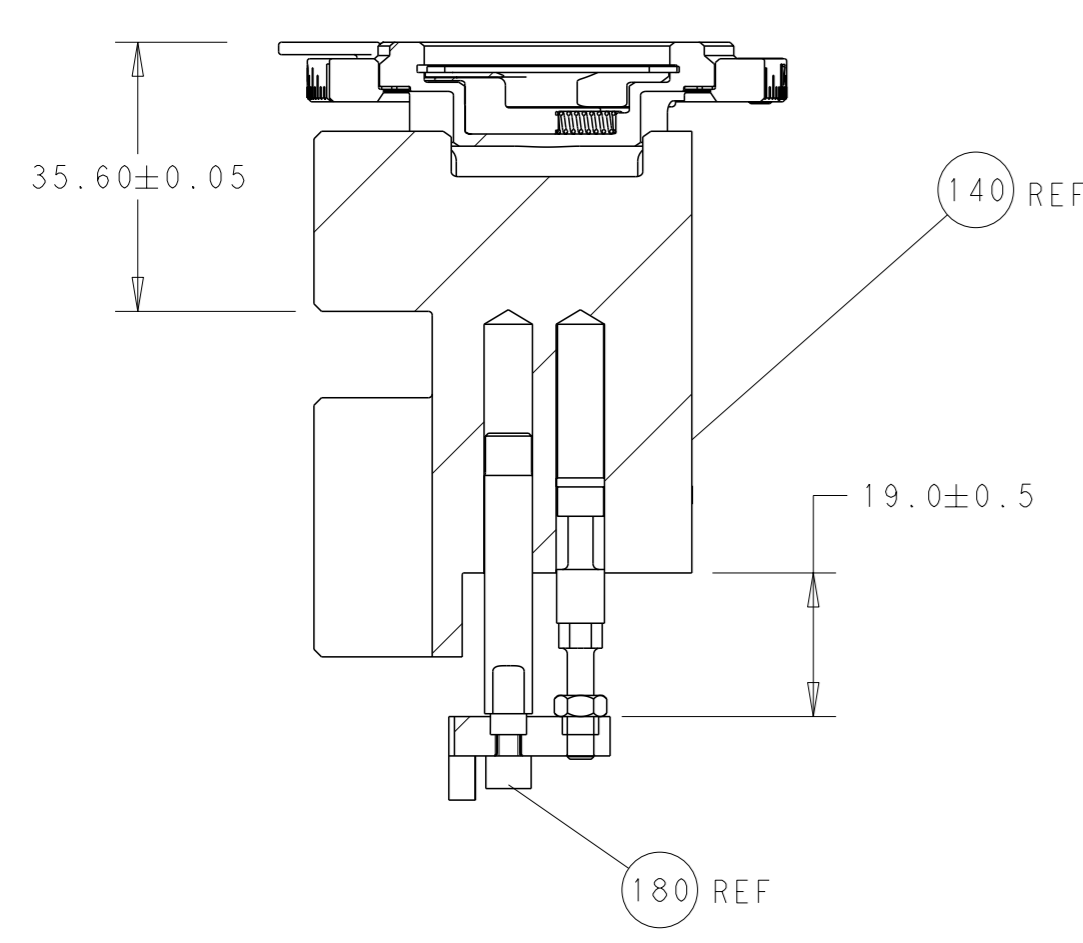
PACIFIC VERSION
Shown on sheets 3 of 4 & 4 of 4
(Atlantic version shown on sheets 1 of 4 & 2 of 4)

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

3	-	1	1	2119082-3	CAM, SNAIL, INSULATION ADJUSTMENT	244
	-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
	-	1	1	2119083-1	RETAINER, INSULATION DIAL	242
	-	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
	-	1	-	2844940-3	AIR FEED MODULE	238
	-	1	1	1-18028-0	WASHER, FLAT, REG M8	192
	-	4	4	2079383-9	SCR, BHSC, RoHS (M6 X 20)	186
3	-	1	1	1752354-2	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	2119655-6	APPLICATOR BASIC ASSEMBLY, EF	141
	-	1	1	1803518-1	RAM ASSEMBLY, EF PACIFIC	140
6	-	1	1	2119955-2	ASSY, LUBRICATOR, END FEED	84
	-	1	1	455888-5	SPACER, CRIMPER	82
	-	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	1-1901681-8	HOLDDOWN, TERMINAL	65
	-	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
	-	-	1	2063961-5	FEED FINGER	58
	-	4	4	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57
	-	2	2	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	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	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
	-	1	1	240639-3	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	22281-8	SPRING, COMPRESSION	22
	-	1	1	1803292-4	DRAG	20
	-	1	1	1803152-5	STRIP GUIDE, REAR	19
	-	1	1	1803151-5	STRIP GUIDE, FRONT	18
	-	1	1	6-240641-6	SPACER	16
1	-	1	1	240644-1	PLATE, REAR SHEAR	11
	-	-	-	-	-	10
1	-	1	1	690482-6	PLATE, FRONT SHEAR	9
1	1	1	1	8-1803000-1	ANVIL, COMBINATION, END FEED	8
1	-	1	1	2217206-4	BLADE, SLUG	7
	-	-	-	-	-	6
	-	1	1	240641-7	SPACER	5
	-	1	1	238011-2	BLOCK, CRIMPER SPACER	4
1	1	1	1	2-1633961-3	CRIMPER, INSULATION F PREMIUM	3
	-	1	1	455888-4	SPACER, CRIMPER	2
1	1	1	1	1-456404-8	CRIMPER, WIRE PREMIUM	1

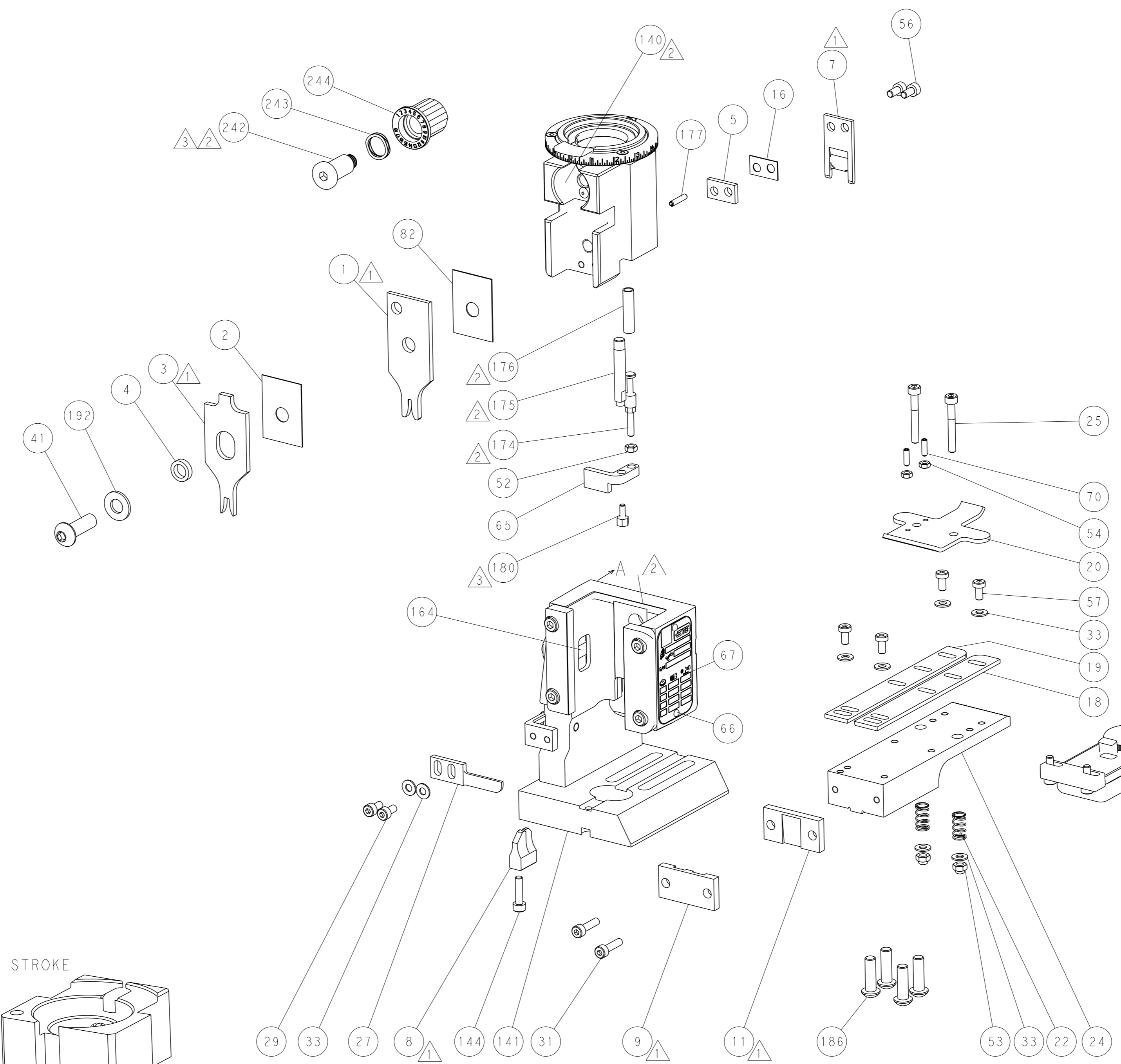
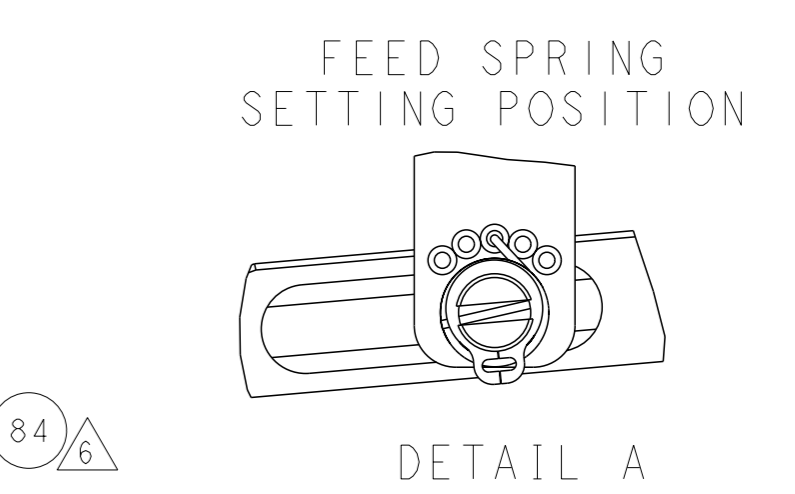
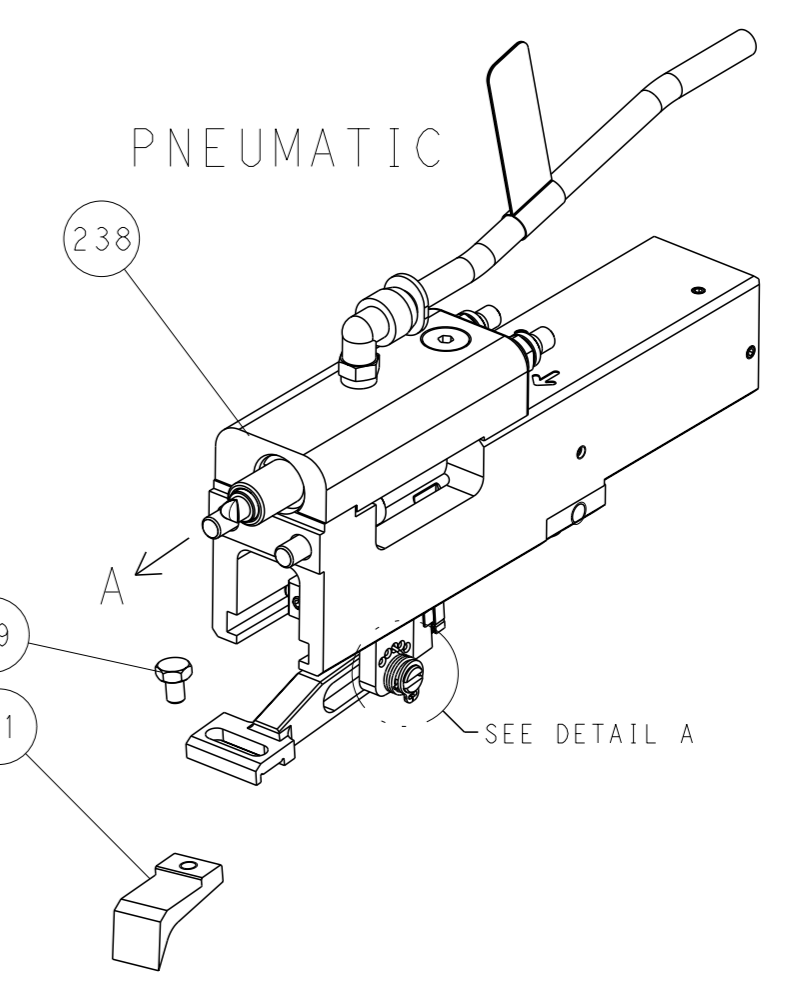
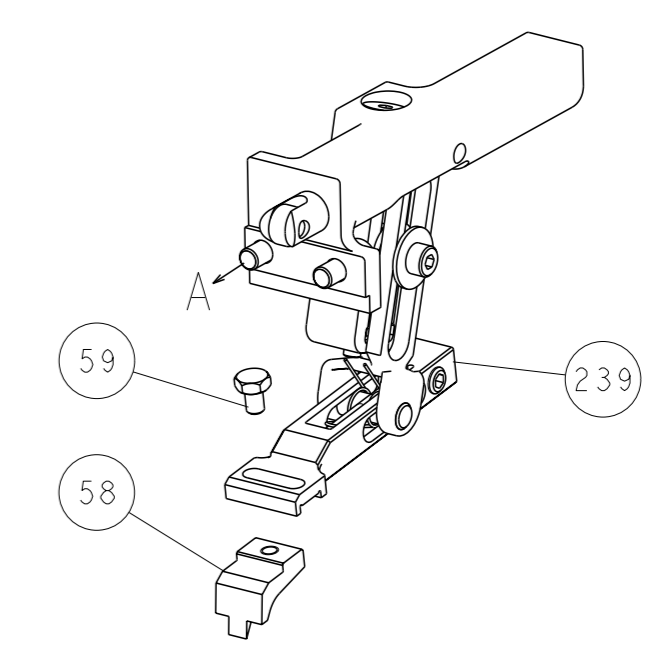
THE DRAWING IS CONTROLLED BY THE DRAWING REVISIONS CONTROL SYSTEM. ANY CHANGES TO THIS DRAWING MUST BE MADE THROUGH THE REVISIONS CONTROL SYSTEM. THIS DRAWING IS UNPUBLISHED.		OWN X. ZHAO 12 JUN 2015	TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm		CHK L. ZHANG 12 JUN 2015	
TOLERANCES UNLESS OTHERWISE SPECIFIED:		APVD U. GUO 12 JUN 2015	NAME Ocean End Feed Applicator
0 PLC ± 1 PLC ± 3 PLC ± 4 PLC ±		PRODUCT SPEC	SIZE A1
ANGLES FINISH		APPLICATION SPEC	CAGE CODE 00779
MATERIAL		WEIGHT	DRAWING NO 2150554
		RESTRICTED TO	SCALE 1:1
		Customer Accessible Production Drawing	SHEET 3 OF 4

LOC	DIST	REVISIONS			
A	66	REV	DATE	OWN	APVD
-	SEE SHEET 1	-	-	-	-

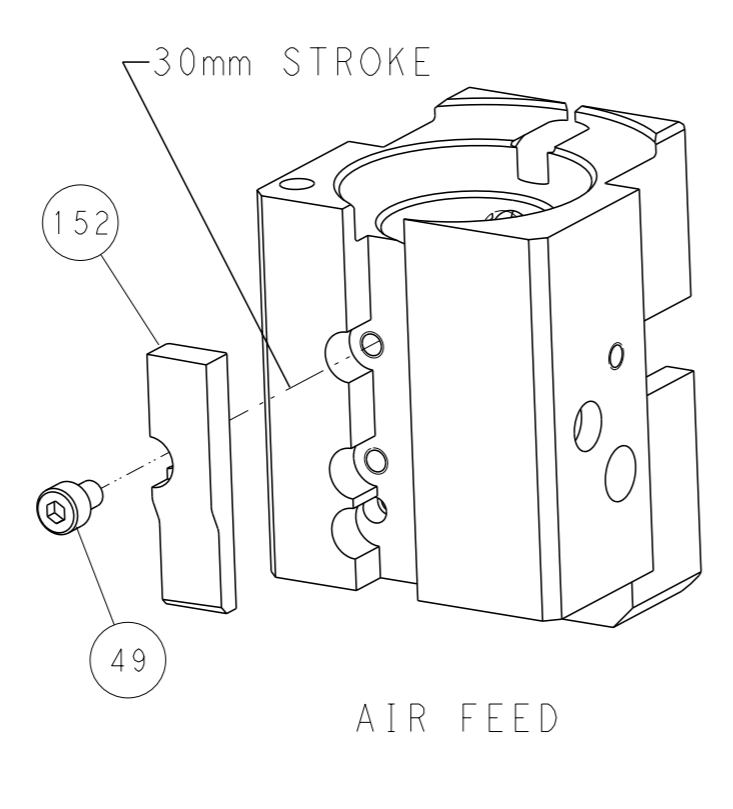
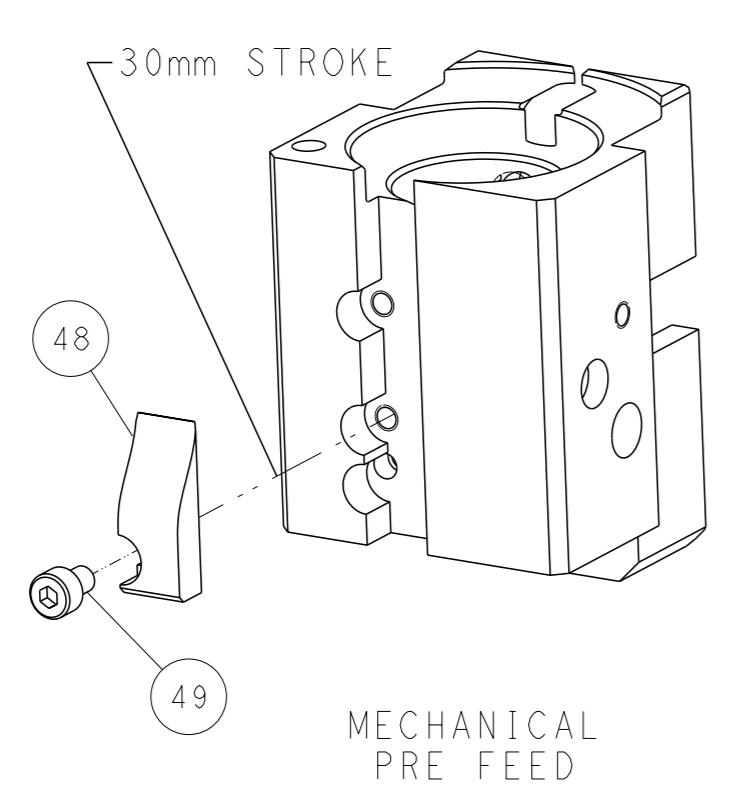
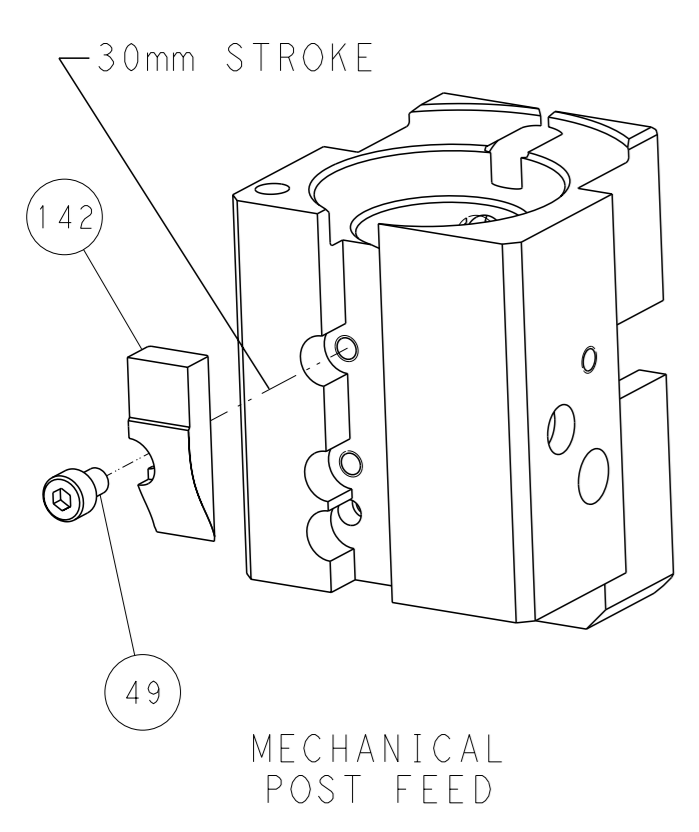


RAM AND HOLDDOWN SET-UP

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)

<small>THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE AND THE CONTROL AND RESTRICTION DESIGNATION SHOULD BE CONTACTED FOR THE LATEST VERSION.</small>		OWN: X. ZHAO CHK: L. ZHANG APVD: J. GUO DATE: 12 JUN 2015	NAME: Ocean End Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: C-2150554	RESTRICTED TO: - SCALE: 1:1 SHEET: 4 of 4 REV: A
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH *		PRODUCT SPEC: - APPLICATION SPEC: - WEIGHT: -	CUSTOMER ACCESSIBLE PRODUCTION DRAWING	