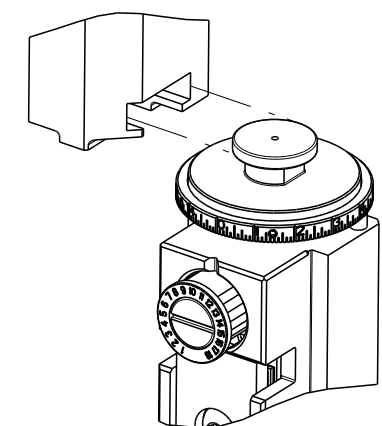


| PART NUMBER | REVISION | DESCRIPTION | FEED TYPE |
|-------------|----------|---------------------------------|-----------|
| 2150584-2 | C | FINE CRIMP HEIGHT ADJUST | PNEUMATIC |
| 7-2150584-2 | C | PNEUMATIC AND CRIMP TOOLING KIT | PNEUMATIC |
| 7-2150584-7 | A | CRIMP TOOLING KIT | - |

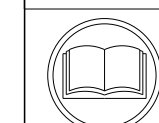
ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



| APPLICATOR DATA | | |
|--------------------------------|----------------|------|
| CRIMP | SIZE | TYPE |
| WIRE | 2.03 mm [.080] | F |
| INSUL | 3.18 mm [.125] | F |
| APPL INSTRUCTIONS 408-35043 | | |

| TERMINAL DATA: EURAMTEC CORP TERMINAL | | TE CRIMP SPECIFICATION | |
|--|------------------------------------|--|------------------------|
| TERMINAL NAME: TERMINAL | | | |
| WIRE STRIP LENGTH 4.34-4.72 mm [.171-.186 IN] | | INSULATION DIAMETER RANGE ∅ 1.68-2.54 mm [.066-.100 IN] | |
| TERMINAL APPLICATION SPECIFICATION | NONE | - | - |
| TERMINALS APPLIED | | | |
| TE TERMINAL 1949348-1 | EURAMTEC CORP TERMINAL W-ST-200 | TE TERMINAL | EURAMTEC CORP TERMINAL |

| WIRE SIZE | CRIMP HEIGHT mm [INCH] | CRIMP HEIGHT REFERENCE SETTING |
|-----------|----------------------------|--------------------------------|
| 16 AWG | 1.49+/-0.05 [.059+/-0.002] | 6.3 |
| 18 AWG | 1.31+/-0.05 [.052+/-0.002] | 8.4 |
| 20 AWG | 1.18+/-0.05 [.046+/-0.002] | 9.6 |



- 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. 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.
- 5. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- CUT TO LENGTH AT ASSEMBLY.

***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.

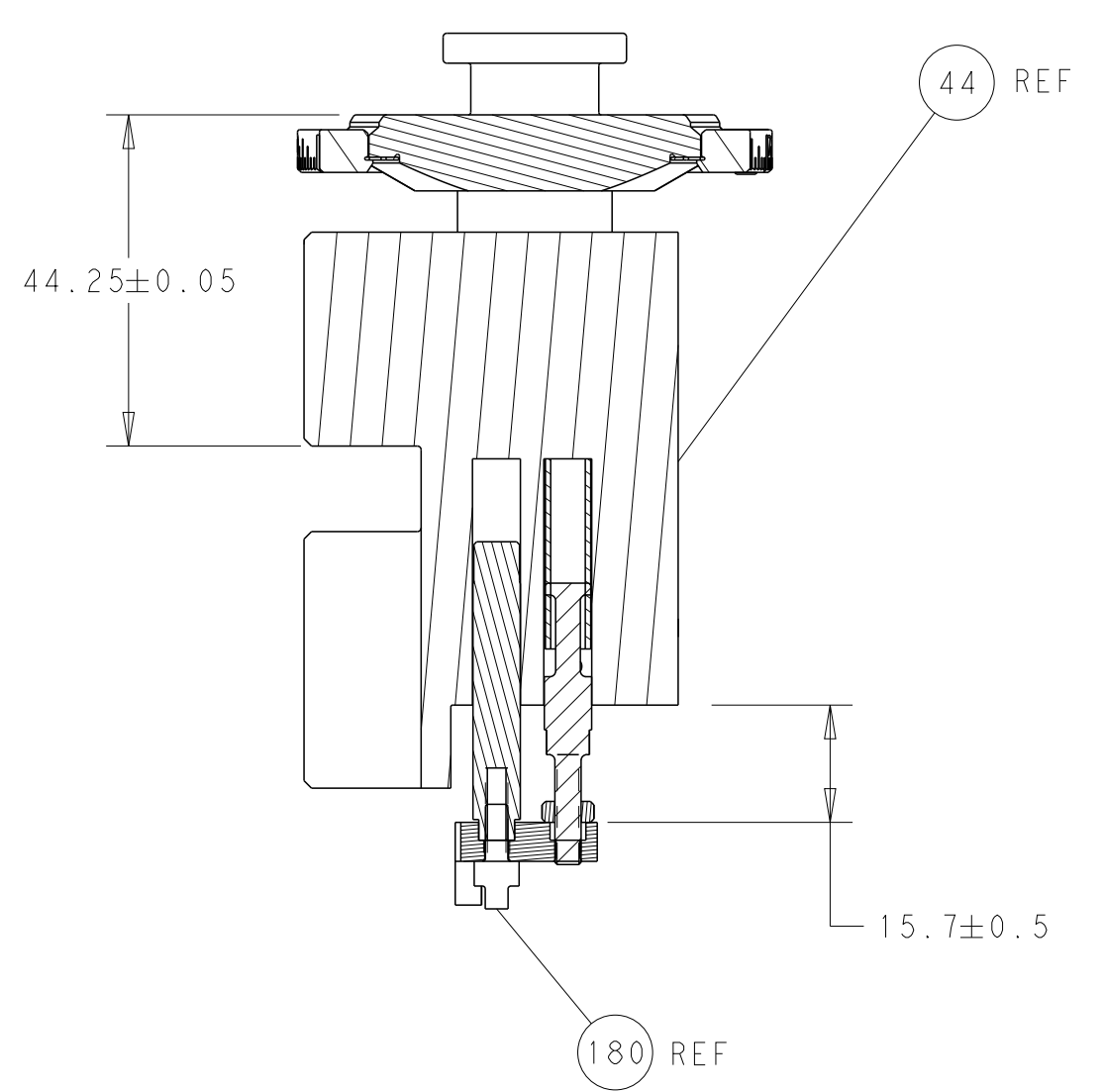
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

| LOC | DIST | REVISIONS | | | | | |
|-----|------|-----------|-----|---------------|-----------|-----|------|
| A | 66 | P | LTN | DESCRIPTION | DATE | OWN | APVD |
| | | A | | RELEASED | 30JUL2015 | BW | GB |
| | | B | | ECR-22-148305 | 03AUG2022 | FZ | TE |
| | | C | | ECR-22-162310 | 29DEC2022 | JWC | GB |

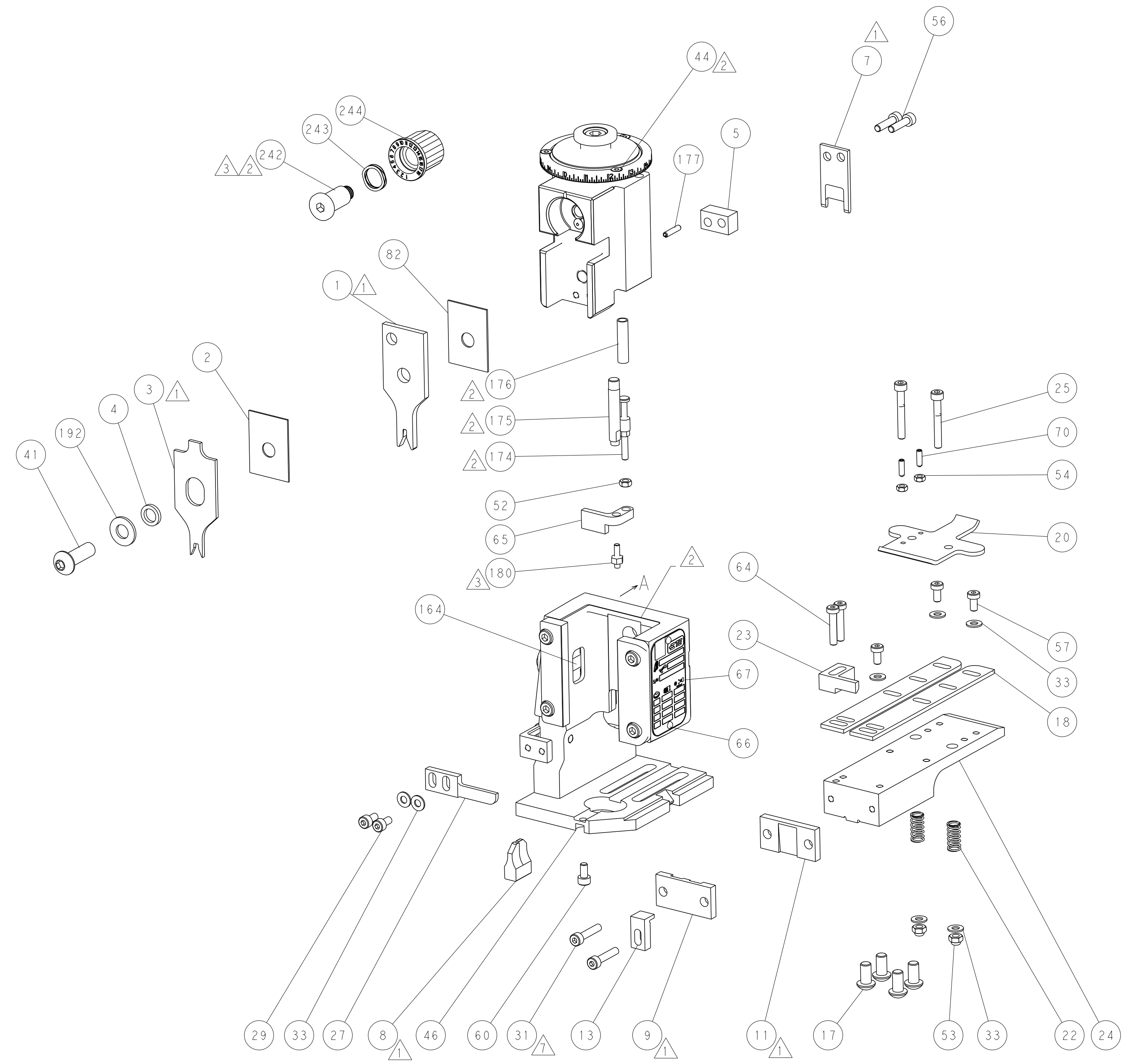
| | | | | | | |
|---|-----|-----|-------------|--------------------------------------|------------------------------|---------|
| - | 1 | 1 | 2119641-1 | FEED CAM, AIR FEED | 248 | |
| - | 1 | 1 | 2119759-1 | RAM, AMP STYLE, END FEED, NON-ADJUST | 245 | |
| - | 1 | 1 | 2119082-4 | CAM, SNAIL, INSULATION ADJUSTMENT | 244 | |
| - | 1 | 1 | 2079764-1 | WASHER, WAVE SPRING, CREST-TO-CREST | 243 | |
| | 1 | 1 | 2119083-1 | RETAINER, INSULATION DIAL | 242 | |
| - | 1 | 1 | 2844940-4 | AIR FEED MODULE | 238 | |
| - | 1 | 1 | 1-18028-0 | WASHER, FLAT, REG M8 | 192 | |
| | 1 | 1 | 1-1976055-0 | 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 | 1 | 455888-8 | 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 | 1901681-1 | HOLDDOWN, TERMINAL | 65 | |
| - | 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 | 2168083-8 | SCR, SKT HD CAP, RoHS, M4 X 16 | 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 | 1 | 2063961-9 | 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 | 2168083-9 | SCR, SKT HD CAP, 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 | |
| - | 1 | 1 | 240825-1 | PLATE, STRIP HOLD DOWN | 23 | |
| - | 2 | 2 | 2-22281-3 | SPRING, COMPRESSION | 22 | |
| - | 1 | 1 | 1803292-4 | DRAG | 20 | |
| - | 2 | 2 | 1-1901259-0 | GUIDE, LOWER STRIP | 18 | |
| - | 4 | 4 | 1-2079383-1 | SCR, BHSC, RoHS (M6 X 12) | 17 | |
| | 1 | 1 | 1752360-1 | SPACER,HOLD-DOWN | 13 | |
| - | 1 | 1 | 240644-1 | PLATE, REAR SHEAR | 11 | |
| - | - | - | - | - | 10 | |
| | 1 | 1 | 690482-5 | PLATE, FRONT SHEAR | 9 | |
| | 1 | 2 | 1 | 8-1803000-4 | ANVIL, COMBINATION, END FEED | 8 |
| - | 1 | 1 | 2217206-7 | BLADE, SLUG | 7 | |
| - | - | - | - | - | 6 | |
| - | 1 | 1 | 6-240641-0 | SPACER | 5 | |
| - | 1 | 1 | 2-238011-2 | BLOCK, CRIMPER SPACER | 4 | |
| | 1 | 2 | 1 | 6-1803017-6 | CRIMPER, INSULATION F | 3 |
| - | 1 | 1 | 455888-7 | SPACER, CRIMPER | 2 | |
| | 1 | 2 | 1 | 6-1633860-2 | CRIMPER, WIRE | 1 |
| - | 77 | 72 | 2 | PART NO | DESCRIPTION | ITEM NO |

| DIMENSIONS: | | TOLERANCES UNLESS OTHERWISE SPECIFIED: | | MATERIAL: | | FINISH: | | WEIGHT: | | SCALE: | |
|-------------|---------|--|---------|-----------|---------|---------|--------|---------|-------|--------|-----|
| mm | 0 PLC ± | 1 PLC ± | 2 PLC ± | 3 PLC ± | 4 PLC ± | ANGLES | FINISH | WT | SCALE | SHEET | REV |
| | | | | | | | | | | 1 of 4 | C |

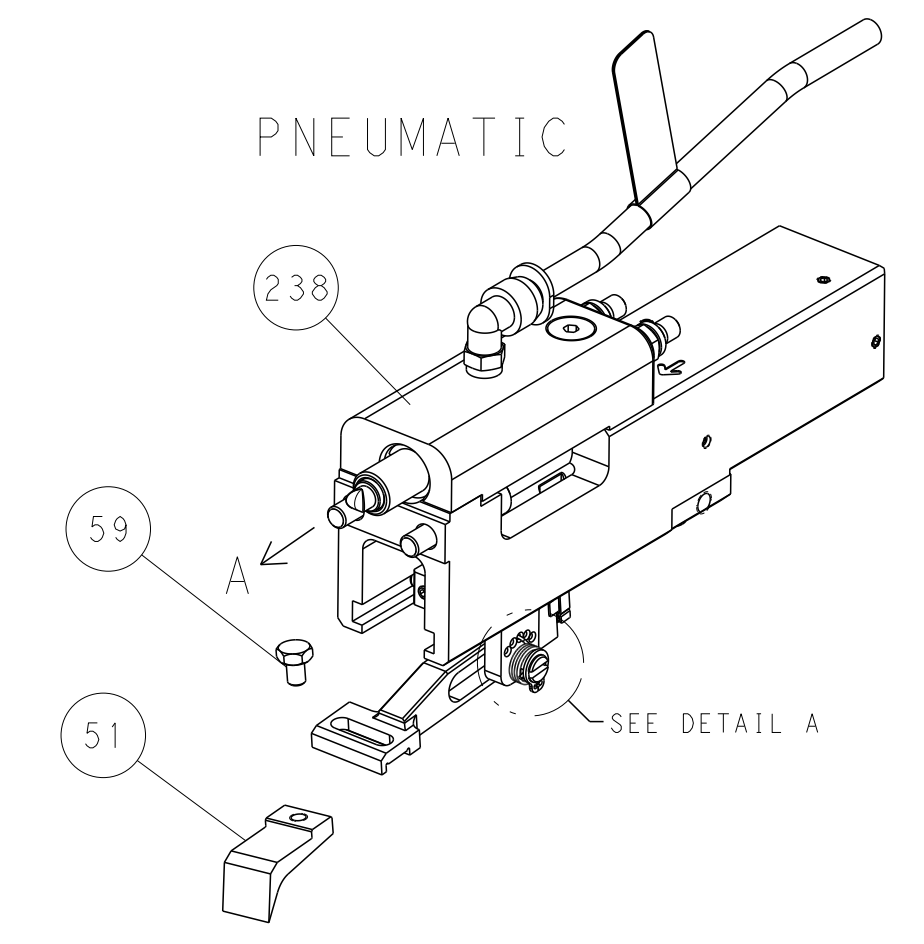
| LOC | DIST | REV | DATE | BY | APPV |
|-----|------|-----|------|----|------|
| A | 66 | | | | |
| | | | | | |
| | | | | | |



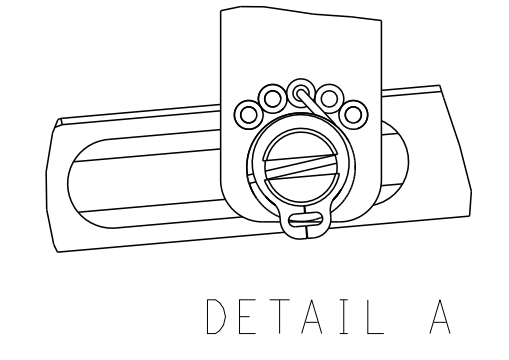
RAM AND HOLDDOWN SET-UP



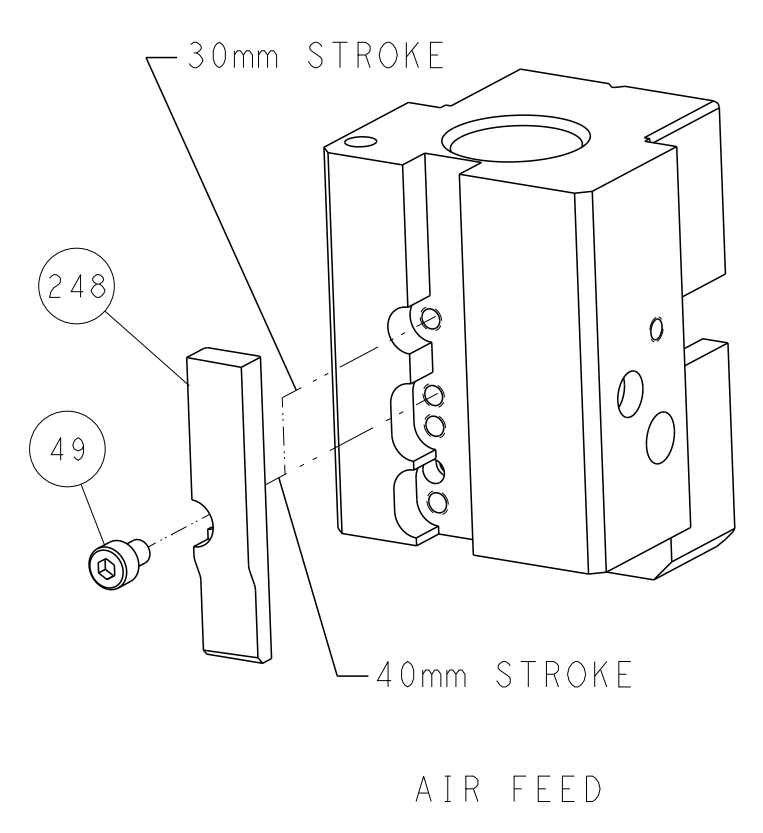
FEED TYPE



FEED SPRING SETTING POSITION



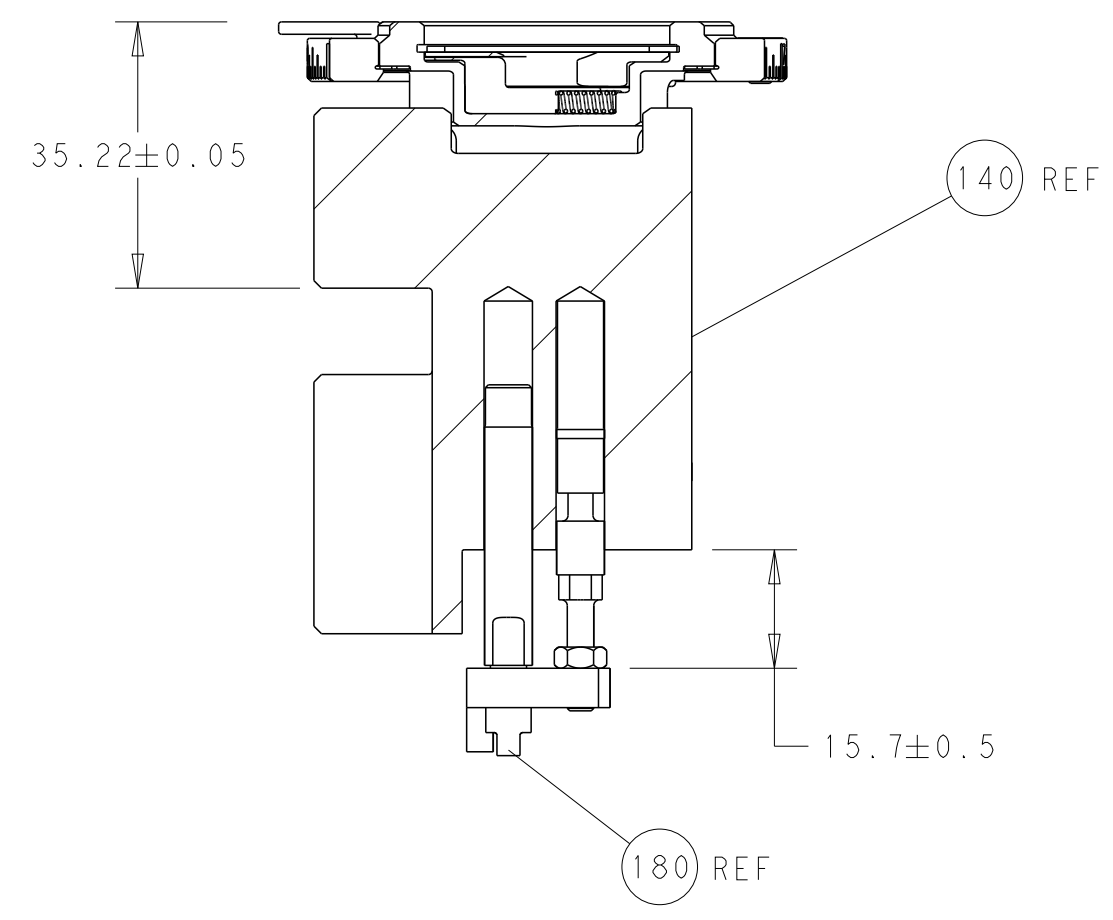
CAM POSITION



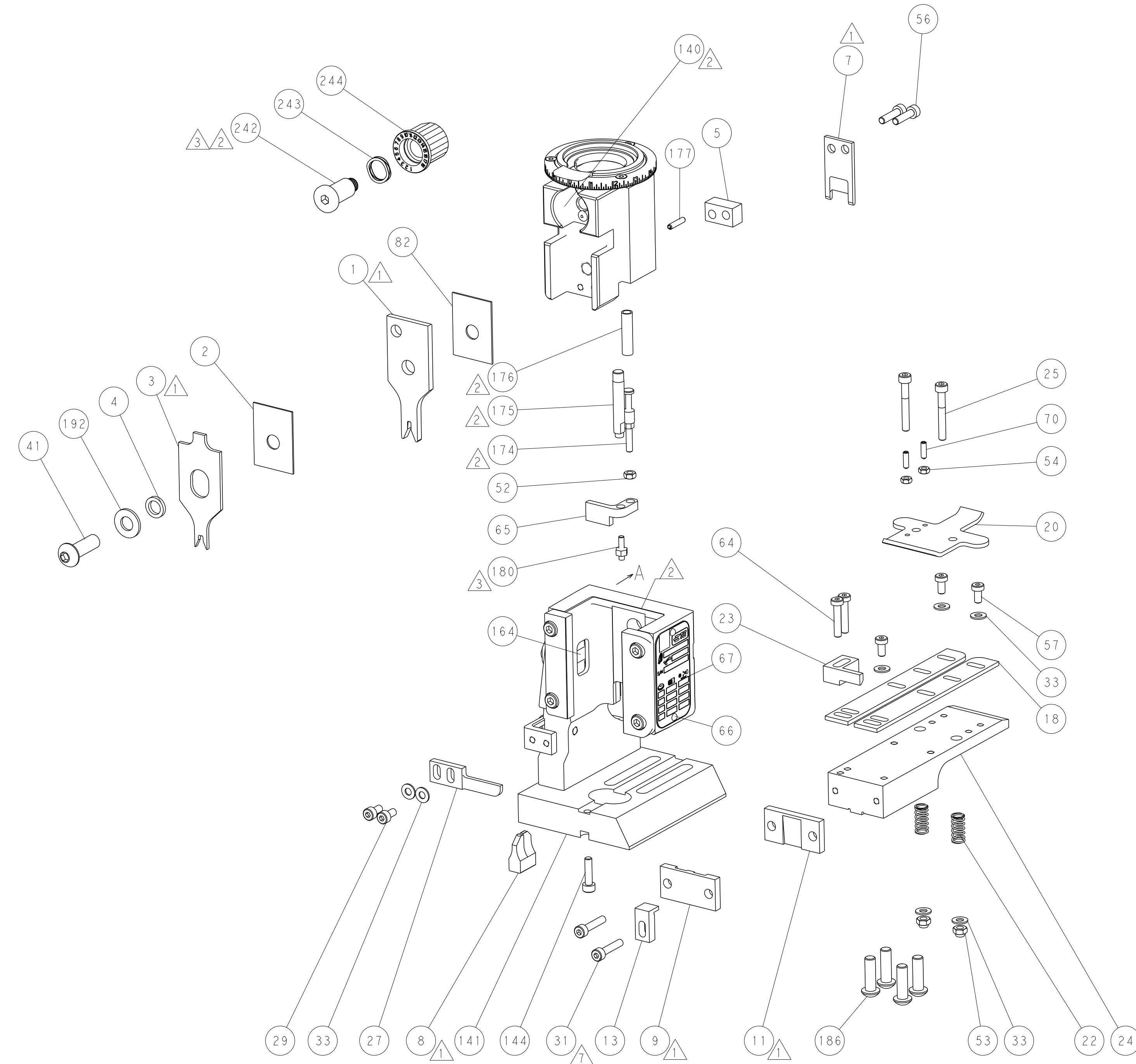
ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

| | | | |
|---|--|---|---|
| <small>THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION 2015. COPYRIGHT 2015 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.</small> | | DWN: B. WEAVER 26 JUN 2015 CHK: G. BAILEY 26 JUN 2015 APVD: G. BAILEY 26 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 PRODUCT SPEC: APPLICATION SPEC: WEIGHT: | SIZE: A1 CAGE CODE: 00779 DRAWING NO: C-2150584 RESTRICTED TO: |
| MATERIAL: | | SCALE: 1:1 SHEET: 2 of 4 REV: C | Customer Accessible Production Drawing |

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

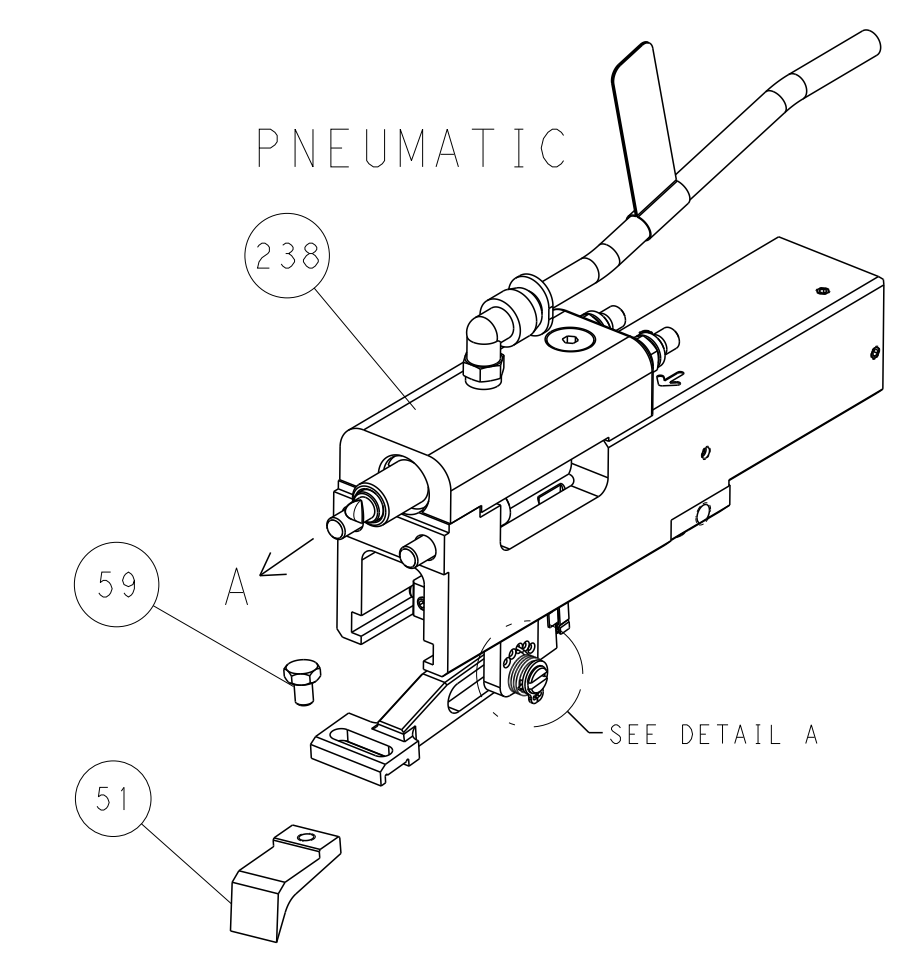


RAM AND HOLDDOWN SET-UP

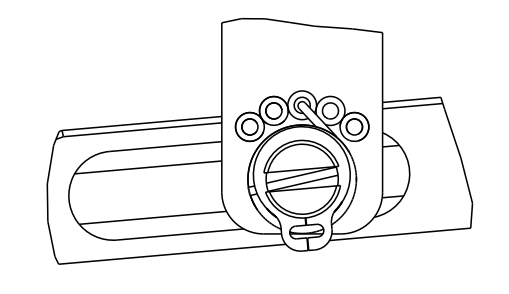


FEED TYPE

PNEUMATIC

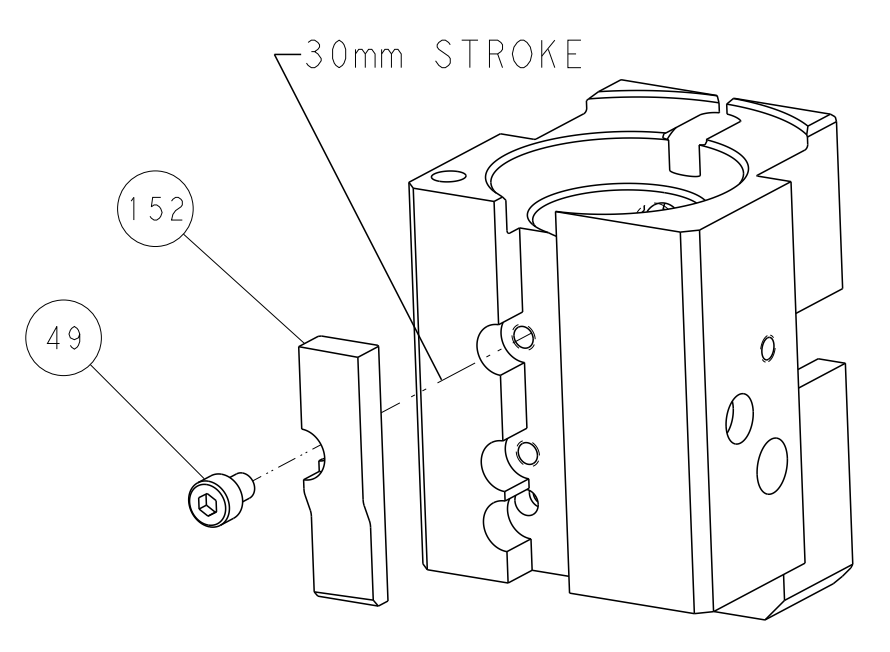


FEED SPRING SETTING POSITION



DETAIL A

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)

| | | | | | | | |
|--|---------|--|---------|----------------------------|------------|---------------------|---------------------------|
| DIMENSIONS: | | TOLERANCES UNLESS OTHERWISE SPECIFIED: | | DWG: B. WEAVER 26 JUN 2015 | | STE TE Connectivity | |
| mm | 0 PLC ± | 1 PLC ± | 2 PLC ± | 3 PLC ± | 4 PLC ± | 5 PLC ± | Harrisburg, PA 17105-3608 |
| MATERIAL: | FINISH: | WEIGHT: | SCALE: | SIZE: | CAGE CODE: | DRAWING NO: | RESTRICTED TO: |
| - | - | - | 1:1 | A1 | 00779 | 2150584 | - |
| Customer Accessible Production Drawing | | | | SHEET 4 OF 4 REV C | | | |