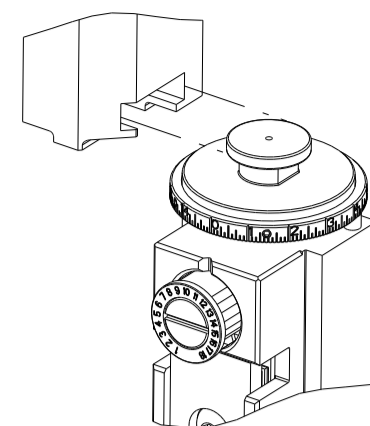


8	7	6	5	4	3	2	1
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE				
2150618-2	D	FINE CRIMP HEIGHT ADJUST	PNEUMATIC				
7-2150618-2	D	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC				
7-2150618-7	A	CRIMP TOOLING KIT	-				

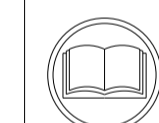
ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	3.94 mm [.155]	F
INSUL	5.59 mm [.220]	F
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: RECPT, POSITIVE LOCK, .250 SERIES			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
5.46-6.22 mm [.215-.245 IN]		∅3.81-5.08 mm [.150-.200 IN]	
TERMINAL APPLICATION SPECIFICATION	114-2074	-	-
TERMINALS APPLIED ³			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
63239-1	2825084-1		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
10 AWG	2.64 +/- 0.05 [.104 +/- .002]	4.1
12 AWG	2.21 +/- 0.05 [.087 +/- .002]	8.6



- 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. 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.

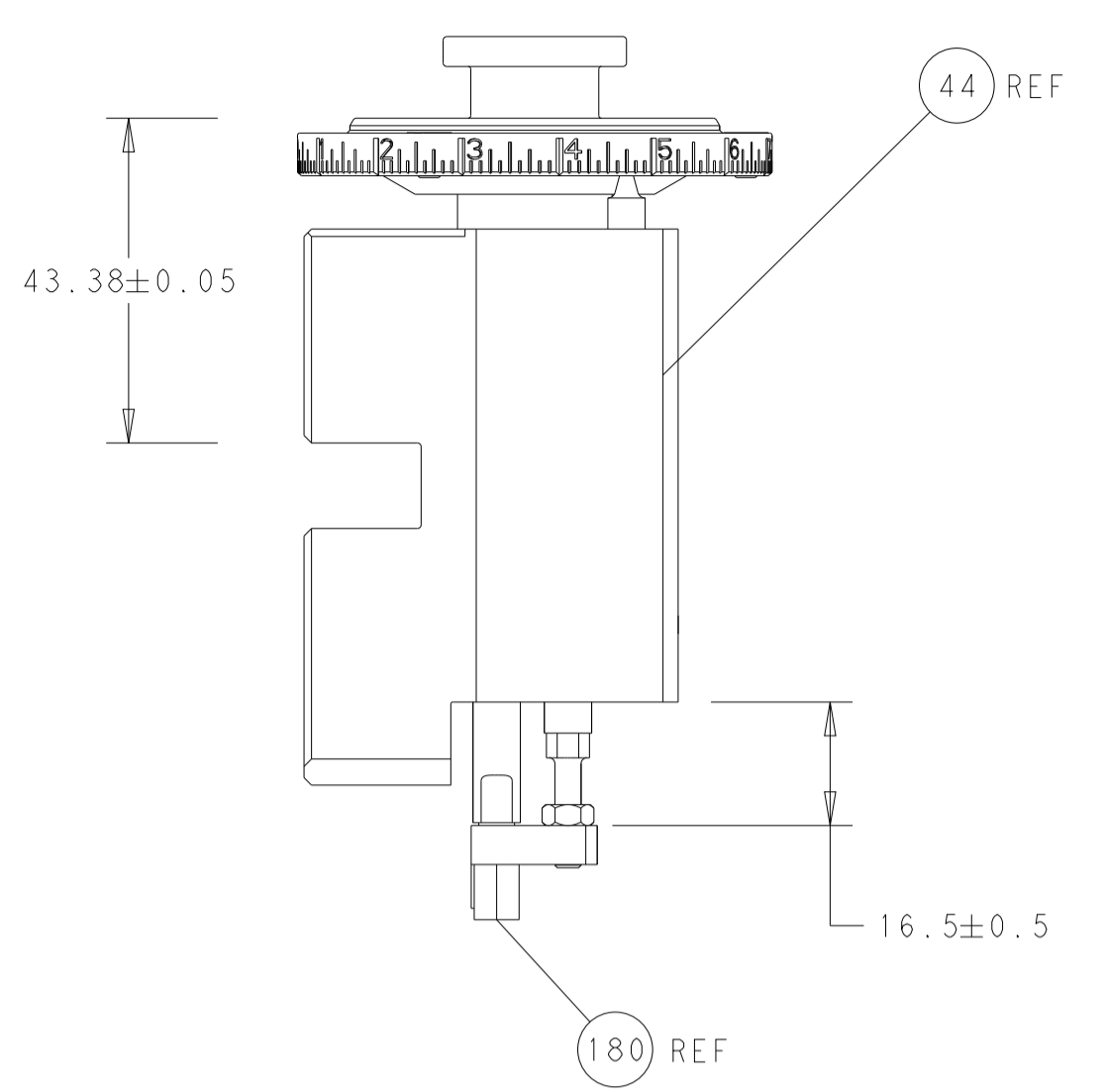
LOC	DIST	REVISIONS					
A	66	P	LTN	DESCRIPTION	DATE	DWN	APVD
		A		RELEASE	07JUN2016	XZ	KZ
		B		ECR-19-011599	23JUL2019	JAH	RK
		C		ECR-20-013817	28SEP2020	TB	TE
		D		ECR-21-120780	15NOV2021	FZ	TE

-	1	1	2119641-1	FEED CAM, AIR FEED	248
-	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	1	2844940-4	AIR FEED MODULE	238
-	1	1	1-18028-0	WASHER, FLAT, REG M8	192
-	1	1	1-1752354-4	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	2119955-2	ASSY, LUBRICATOR, END FEED	84
-	1	1	455888-4	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	2-1901681-2	HOLDDOWN, TERMINAL	65
-	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
-	4	4	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
-	8	8	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	2-1752371-8	PLATE, STRIP GUIDE	24
-	2	2	2-22281-3	SPRING, COMPRESSION	22
-	1	1	1803292-4	DRAG	20
-	1	1	1803151-2	STRIP GUIDE, FRONT	19
-	1	1	1803152-2	STRIP GUIDE, REAR	18
-	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17
-	1	1	240641-3	SPACER	16
-	1	1	1752360-1	SPACER, HOLD-DOWN	13
-	1	1	240833-1	PLATE, REAR SHEAR	11
-	-	-	-	-	10
-	1	1	690482-4	PLATE, FRONT SHEAR	9
-	1	2	1-1803074-6	ANVIL, COMBINATION, END FEED	8
-	1	1	1-2217206-0	BLADE, SLUG	7
-	-	-	-	-	6
-	1	1	2-240641-3	SPACER	5
-	1	1	238011-2	BLOCK, CRIMPER SPACER	4
-	1	2	1-1633961-6	CRIMPER, INSULATION F PREMIUM	3
-	1	1	455888-6	SPACER, CRIMPER	2
-	1	2	456426-3	CRIMPER, WIRE PREMIUM	1
-	77	72	2	PART NO	ITEM NO
-	-	-	-	DESCRIPTION	ITEM NO

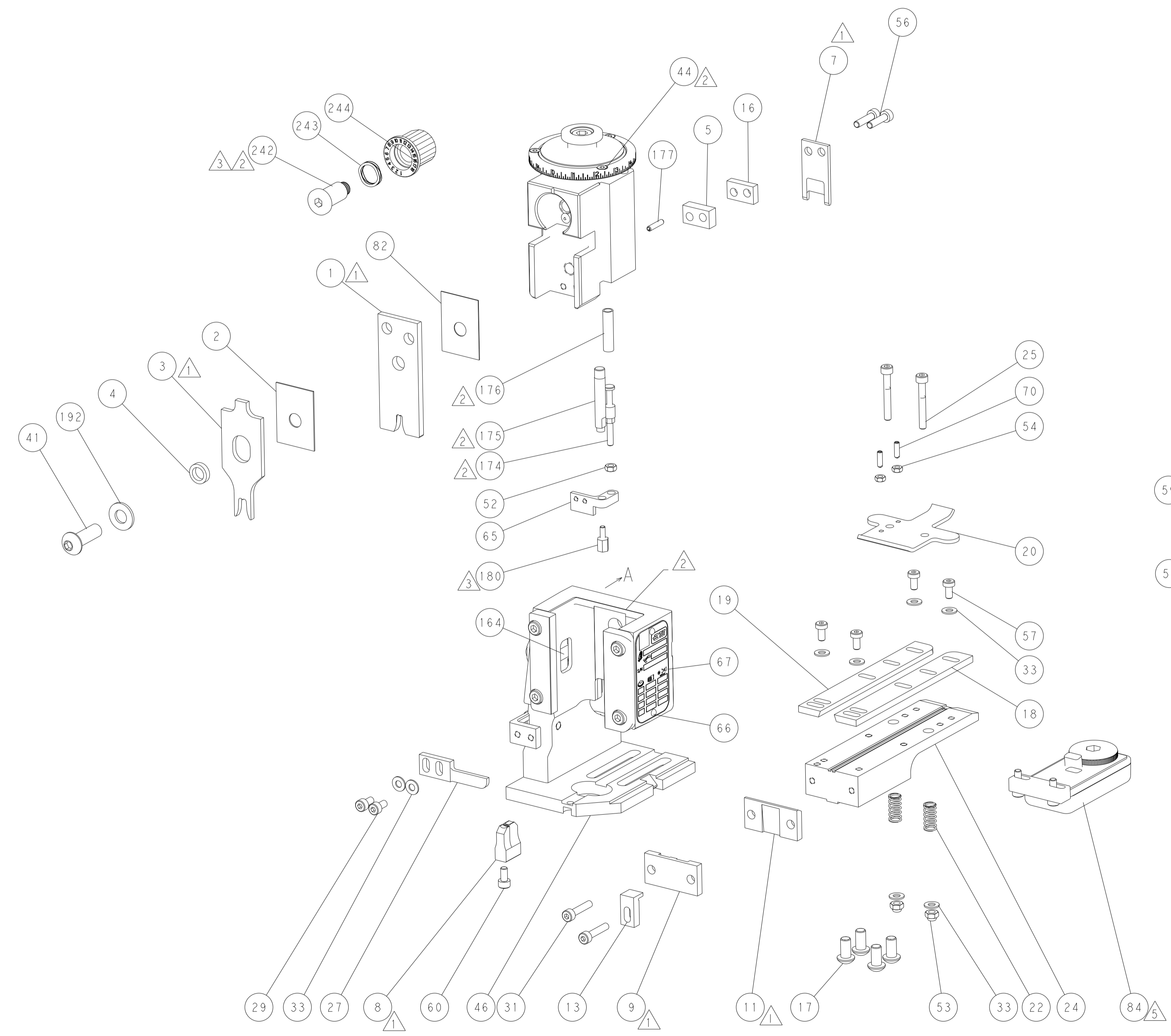
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN X. ZHAO 30OCT2015		CHK L. ZHANG 30OCT2015		APVD U. GUO 30OCT2015		NAME		SIZE		CAGE CODE		DRAWING NO		RESTRICTED TO	
0 PLC ±		1 PLC ±		2 PLC ±		3 PLC ±		4 PLC ±		APPLICATION SPEC		A		00779		2150618		-	
MATERIAL		FINISH		WEIGHT		SCALE		SHEET		1 OF 4		REV		D					

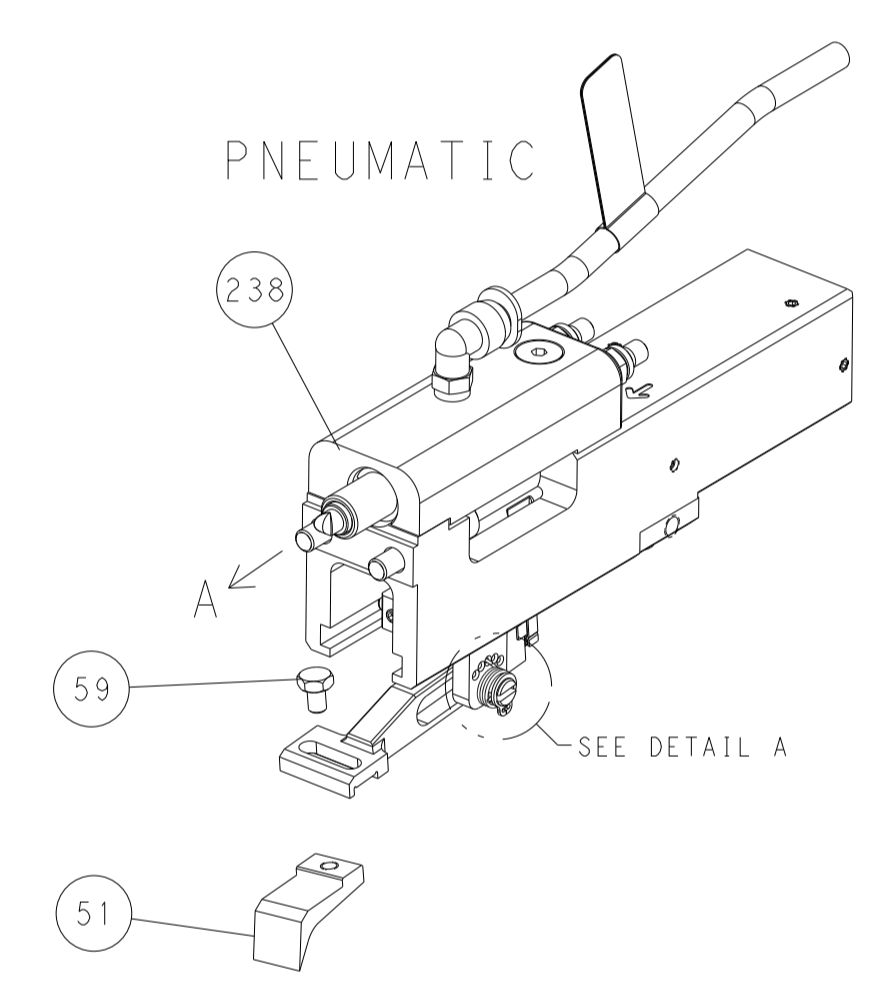
LOC	DIST	REVISIONS			
P	LTN	DESCRIPTION	DATE	DWN	APVD
A	66	SEE SHEET 1	-	-	-



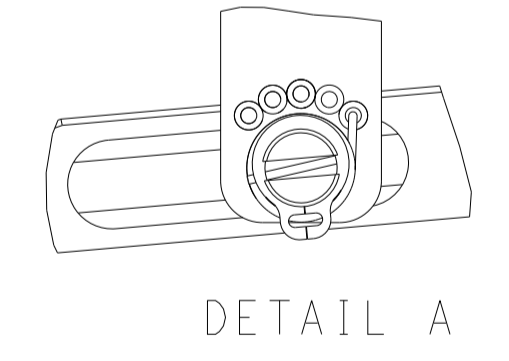
RAM AND HOLDDOWN SET-UP



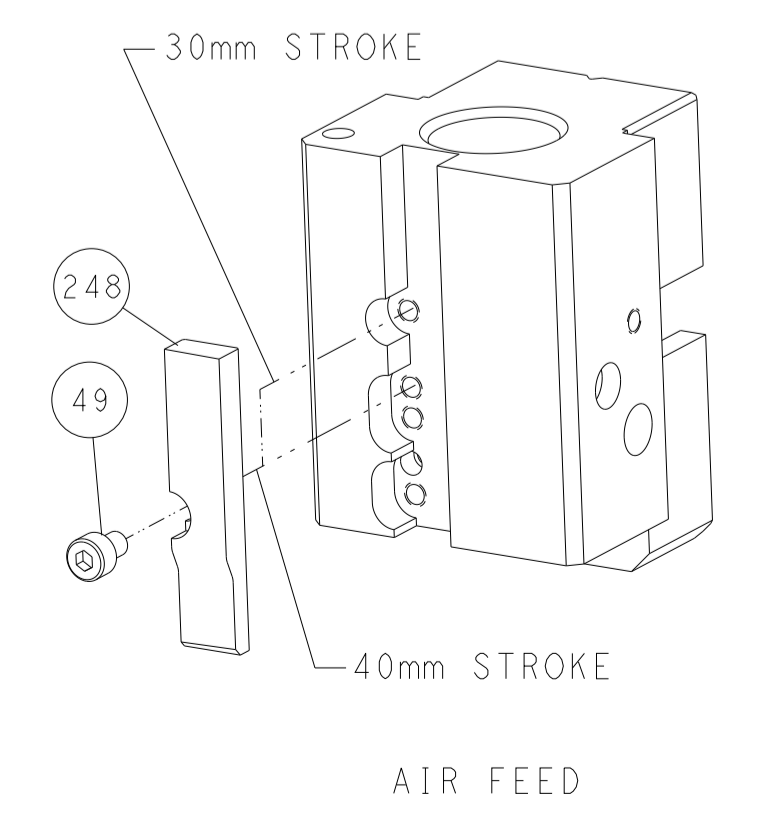
FEED TYPE



FEED SPRING SETTING POSITION



CAM POSITION

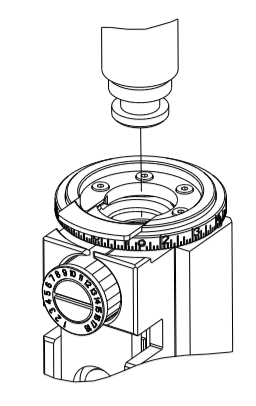


ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

<small>THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.</small>		DWN X.ZHAO 30OCT2015 CHK L.ZHANG 30OCT2015 APVD J.GUO 30OCT2015	TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± MATERIAL: - FINISH: -		NAME: Ocean End Feed Applier PRODUCT SPEC: - APPLICATION SPEC: - WEIGHT: -	SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2150618 RESTRICTED TO: - SCALE: 1:1 SHEET: 2 of 4 REV: D
AMP 4805 REV 31MAR2000		Customer Accessible Production Drawing	

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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150618-2	D	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150618-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	3.94 mm (.155)	F
INSUL	5.59 mm (.220)	F
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: RECPT, POSITIVE LOCK, .250 SERIES			
WIRE STRIP LENGTH 5.46-6.22 mm (.215-.245 IN)		INSULATION DIAMETER RANGE Ø3.81-5.08 mm (.150-.200 IN)	
TERMINAL APPLICATION SPECIFICATION	114-2074	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
63239-1	2825084-1		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
10 AWG	2.64 +/- 0.05 [.104 +/- .002]	4.1
12 AWG	2.21 +/- 0.05 [.087 +/- .002]	8.6

- 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 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.

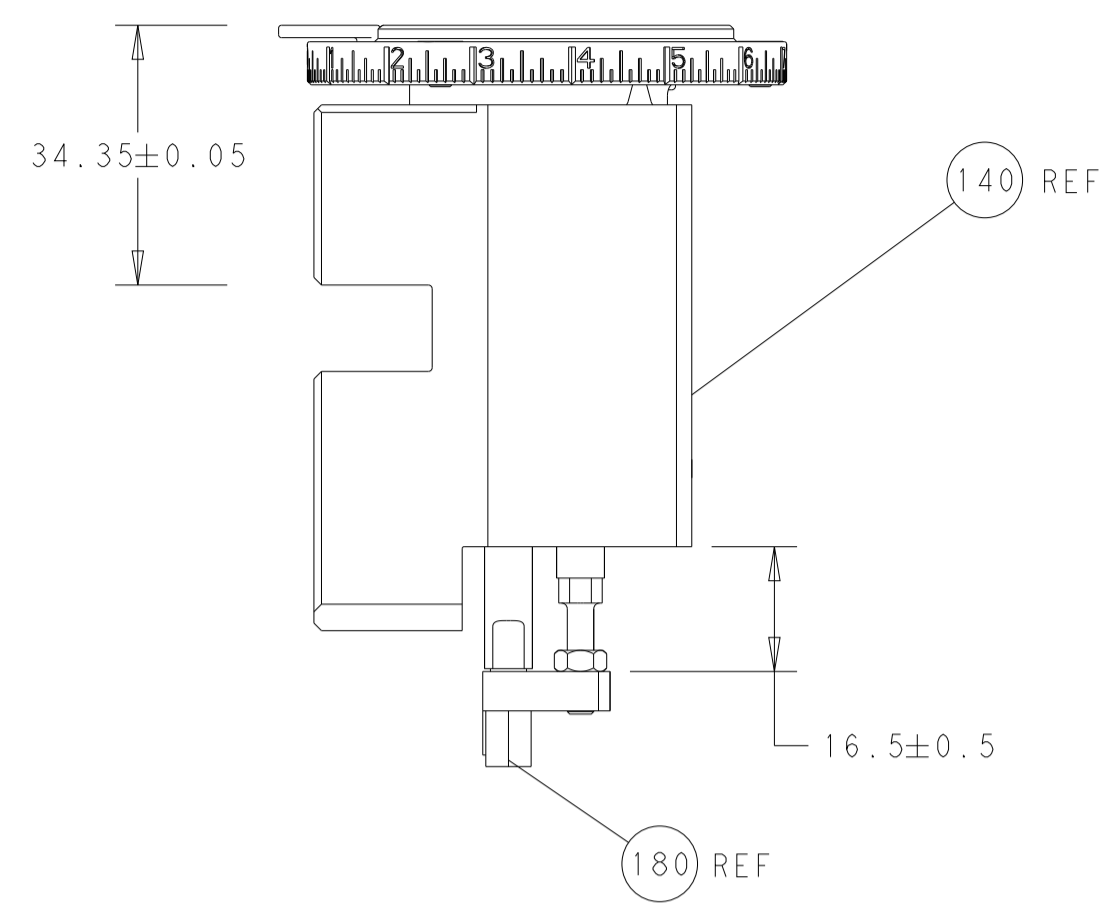
LOC	DIST	REVISIONS					
A	66	P	LTN	DESCRIPTION	DATE	OWN	APVD
		-		SEE SHEET 1	-	-	-

-	1	2119082-3	CAM, SNAIL, INSULATION ADJUSTMENT	244	
-	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243	
3	-	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	2844940-4	AIR FEED MODULE	238	
-	1	1-18028-0	WASHER, FLAT, REG M8	192	
-	4	2079383-9	SCR, BHSC, RoHS (M6 X 20)	186	
3	-	1	1-1752354-4	STANDOFF, HOLD-DOWN	180
-	1	6-993111-6	PIN, SLOTTED SPRING 3.0 X 14.0	177	
-	1	8-22280-7	SPRING, COMPRESSION	176	
-	1	1752353-2	GUIDE PIN, HOLDDOWN	175	
-	1	1901680-2	GUIDE PIN, HOLDDOWN	174	
-	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	
3	-	1	2119955-2	ASSY, LUBRICATOR, END FEED	84
-	1	455888-4	SPACER, CRIMPER	82	
-	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	
-	1	2-1901681-2	HOLDDOWN, TERMINAL	65	
-	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59	
-	4	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57	
-	2	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	56	
-	2	5018030-1	NUT, HEX, REG, RoHS, M3	54	
-	2	986965-8	NUT, LOCK, HEX, TORQUE (M4)	53	
-	1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52	
-	1	2063961-9	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	
-	8	1-18028-2	WASHER, FLAT, REG M4	33	
-	2	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	31	
-	2	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	29	
-	1	240639-1	STRIPPER (MACHINING)	27	
-	2	1-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 30	25	
-	1	2-1752371-8	PLATE, STRIP GUIDE	24	
-	2	2-22281-3	SPRING, COMPRESSION	22	
-	1	1803292-4	DRAG	20	
-	1	1803151-2	STRIP GUIDE, FRONT	19	
-	1	1803152-2	STRIP GUIDE, REAR	18	
-	1	240641-3	SPACER	16	
-	1	1752360-1	SPACER, HOLD-DOWN	13	
3	-	1	240833-1	PLATE, REAR SHEAR	11
-	-	-	-	10	
-	1	690482-4	PLATE, FRONT SHEAR	9	
3	1	1-1803074-6	ANVIL, COMBINATION, END FEED	8	
3	-	1	1-2217206-0	BLADE, SLUG	7
-	-	-	-	6	
-	1	2-240641-3	SPACER	5	
-	1	238011-2	BLOCK, CRIMPER SPACER	4	
3	1	1	3-1633961-6	CRIMPER, INSULATION F PREMIUM	3
-	1	455888-6	SPACER, CRIMPER	2	
3	1	1	456426-3	CRIMPER, WIRE PREMIUM	1
-	77-22	PART NO	DESCRIPTION	ITEM NO	

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

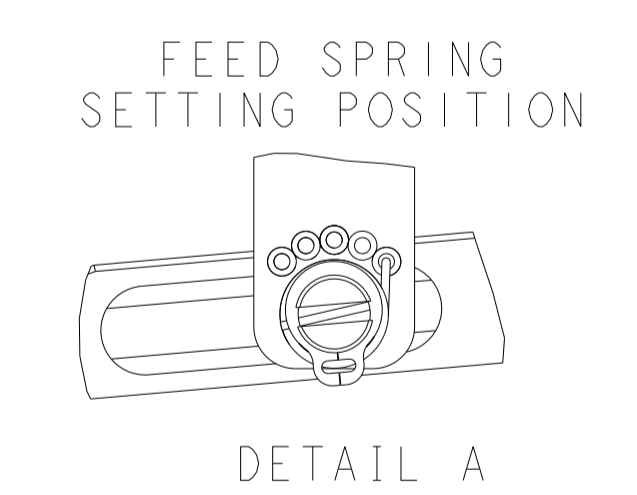
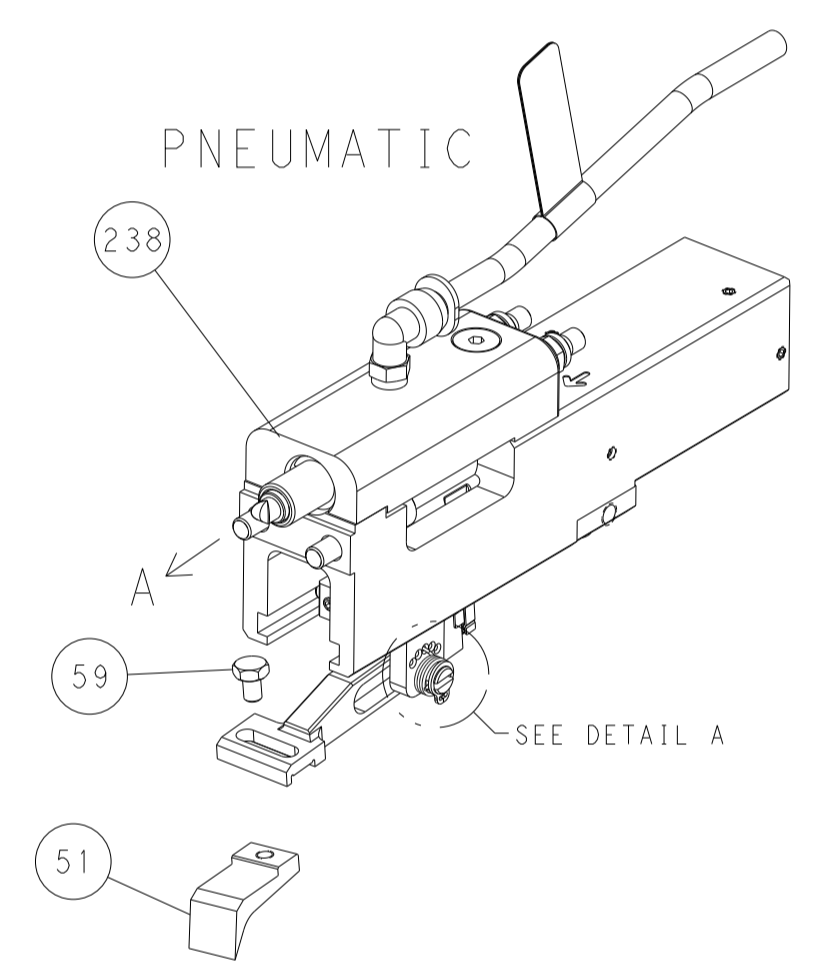
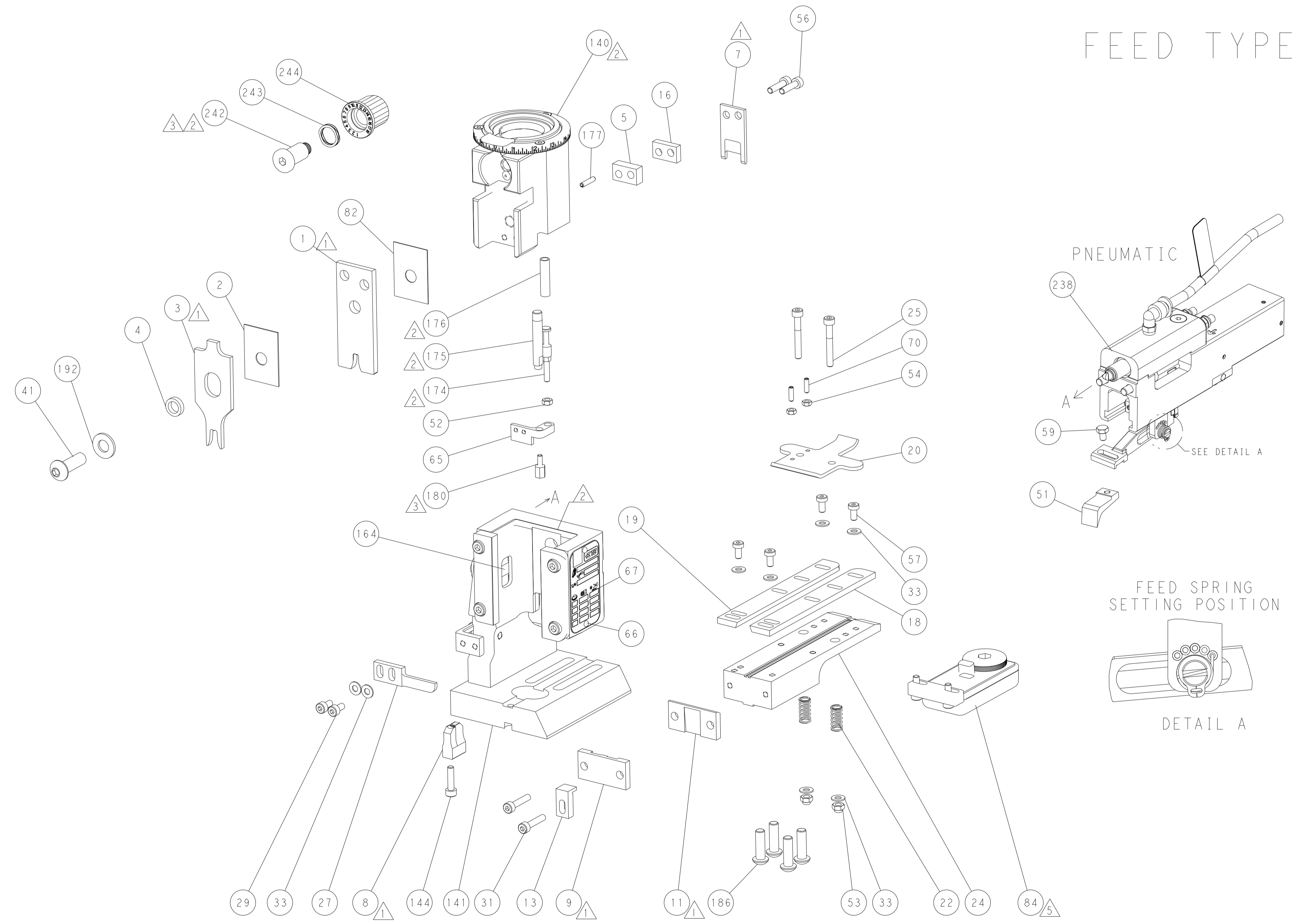
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG: X.ZHAO 30OCT2015		CHK: L.ZHANG 30OCT2015		APVD: U.GUO 30OCT2015		NAME: Ocean End Feed Applicator	
0 PLC	±	1 PLC	±	SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO	Customer Accessible Production Drawing			
2 PLC	±	3 PLC	±	SCALE	1:1	SHEET 3 OF 4	REV D				
4 PLC	±	ANGLES	±	SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION							

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

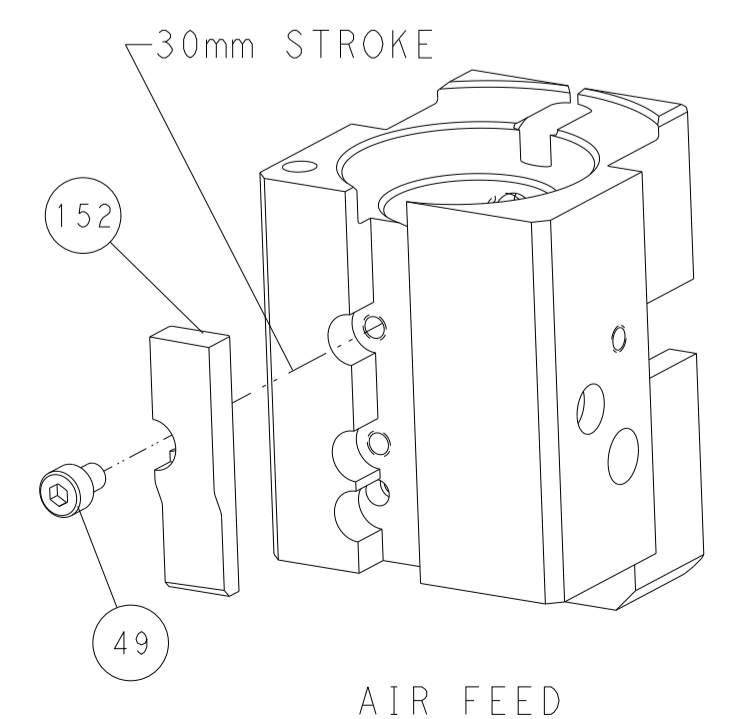


RAM AND HOLDDOWN SET-UP

FEED TYPE



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 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ° ± FINISH	TOLERANCES UNLESS OTHERWISE SPECIFIED: ± ± ± ± ± ±	NAME Ocean End Feed Applier	RESTRICTED TO
MATERIAL	WEIGHT	SIZE CAGE CODE DRAWING NO A 00779 C=2150618	SCALE 1:1 SHEET 4 OF 4 REV D
Customer Accessible Production Drawing		Customer Accessible Production Drawing	