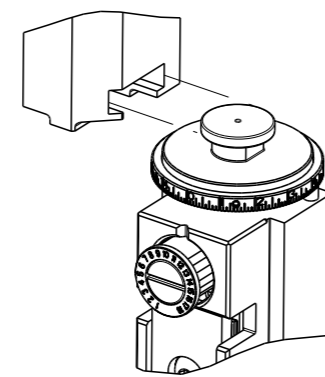


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150641-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150641-2	C	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150641-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER

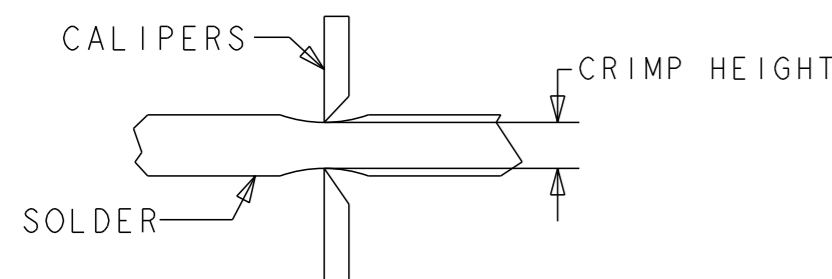


APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	6.02 mm [.237]	SP
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: RECEPTACLE, ULTRA-FAST FLAG, .187 SERIES			
WIRE STRIP LENGTH 7.51-8.33 mm [.296-.328 IN]		INSULATION DIAMETER RANGE ∅ 6.60 mm MAX [.260 IN MAX]	
TERMINAL APPLICATION SPECIFICATION	114-2123	-	-
TERMINALS APPLIED 4			
TE TERMINAL 3-520997-2	TE TERMINAL 3-521247-2	TE TERMINAL	TE TERMINAL

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING	∅ SOLDER
14 AWG	1.90 +/- 0.05 [.075 +/- .002]	6.1	.187 IN [4.75mm]
16 AWG	1.78 +/- 0.05 [.070 +/- .002]	7.4	.187 IN [4.75mm]
(2) 18 AWG	1.78 +/- 0.05 [.070 +/- .002]	7.4	.187 IN [4.75mm]

- 1 RECOMMENDED SPARE PARTS
- 2 REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- 3 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.
- 4 TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED
- 5 TO CHECK CRIMP HEIGHT, CRIMP SOLDER (∅ .187 IN [4.75mm], 60/40 SOLID CORE) AND MEASURE AT CENTER OF SLUG.



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.

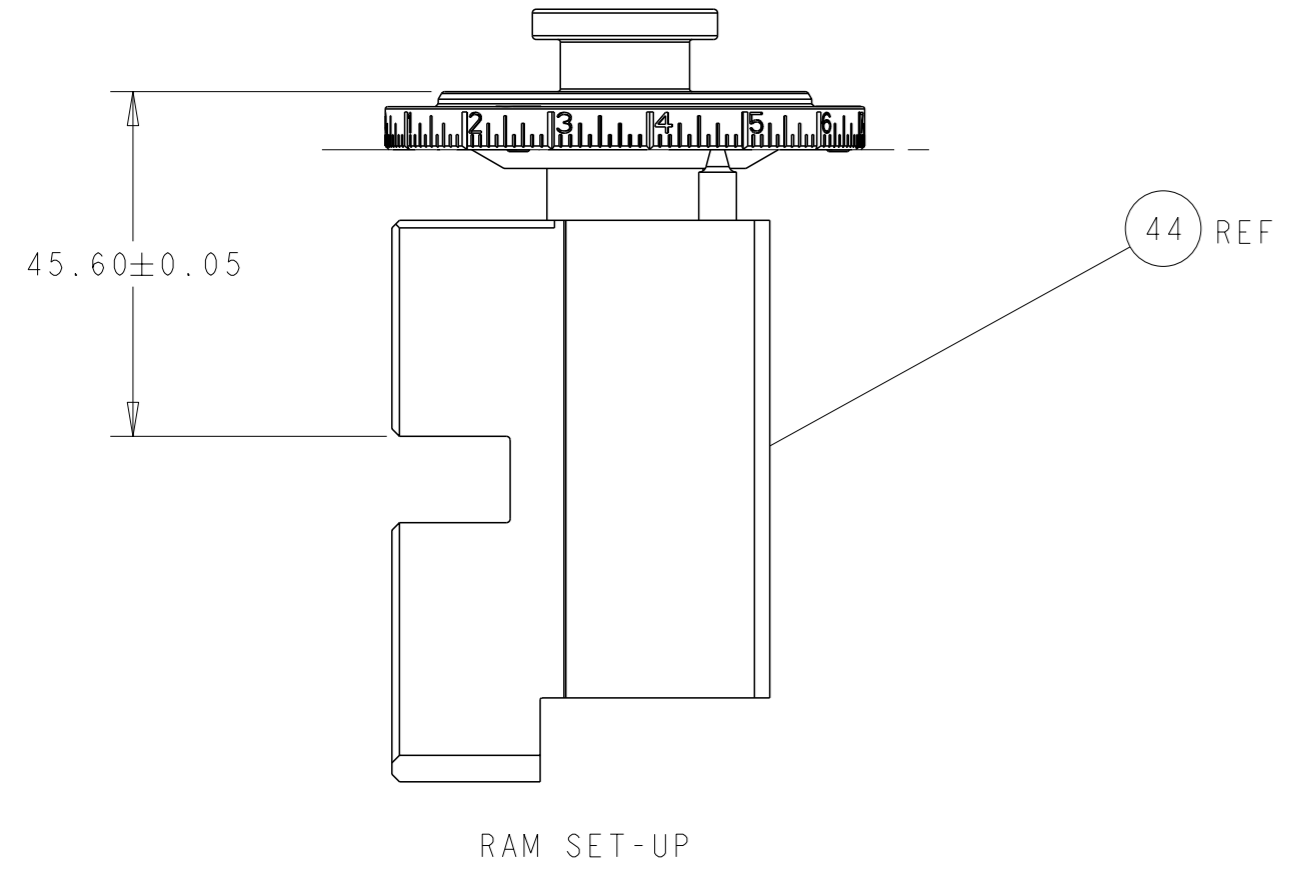
LOC	DIST	REVISIONS					
		#	LY#	DESCRIPTION	DATE	OWN	APVD
A	66	A		RELEASED	15MAR2016	BW	CT
		B		ECR-18-016266	17OCT2018	JAH	CT
		B1		ECR-18-016776	23OCT2018	JAH	TE
		C		ECR-20-014167	06OCT2020	JAH	RK

-	1	1	2119641-1	FEED CAM, AIR FEED	248
-	1	1	2844940-3	AIR FEED MODULE	238
-	2	2	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	208
-	1	1	467281-1	RETAINER, SHEAR, FLOATING	207
-	1	1	2161936-1	HOLDER, SHEAR, FLOATING	206
-	1	1	467500-1	SHEAR, FLOATING	205
-	1	1	1-18028-0	WASHER, FLAT, REG M8	192
-	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	1	1	2161937-3	STABILIZER	154
-	1	1	455888-6	SPACER, CRIMPER	82
-	1	1	1803607-4	DOCUMENTATION PACKAGE	71
-	1	1	3-18032-3	SCR, SET, FLT PNT, M3 X 20.0	70
-	1	1	2-18032-2	SCR, SET, FLT PNT, M3 X 10.0	69
-	1	1	2119740-1	TAG, IDENTIFICATION	67
-	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	1	1	2079383-4	SCR, BHSC, RoHS (M4 X 8)	60
-	1	1	2352966-1	FEED FINGER	59
-	4	4	2168400-1	SHCS, LOW HEAD, RoHS, M4 X 12	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	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	51
-	1	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	1	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
-	2	2	5-22278-1	SPRING, COMPRESSION	36
-	8	8	1-18028-2	WASHER, FLAT, REG M4	33
-	2	2	2079383-4	SCR, BHSC, RoHS (M4 X 8)	31
-	2	2	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	29
-	1	1	690455-3	STRIPPER, FRONT CASTING	27
-	2	2	1-2168083-6	SCR, SKT HD CAP, RoHS, M4 X 35	25
-	1	1	2161941-1	PLATE, GUIDE, STRIP	24
-	2	2	2-22280-7	SPRING, COMPRESSION	22
-	1	1	2161948-1	DRAG	20
-	1	1	683736-4	GUIDE, STRIP, REAR	19
-	1	1	683737-1	FRONT STRIP GUIDE	18
-	4	4	1-2079383-1	SCR, BHSC, RoHS (M6 X 12)	17
-	1	1	4-22280-7	SPRING, COMPRESSION	13
1	2	1	2161935-3	ANVIL, RIGHT HAND	8
-	1	1	2161957-1	DEPRESSOR, SHEAR	5
-	1	1	238011-2	BLOCK, CRIMPER SPACER	4
-	1	1	2161331-1	SPACER, WIRE FUNNEL DEPRESSOR	2
1	2	1	467342-4	CRIMPER, RIGHT HAND	1
-	77	72	-2	PART NO	
-				DESCRIPTION	ITEM NO

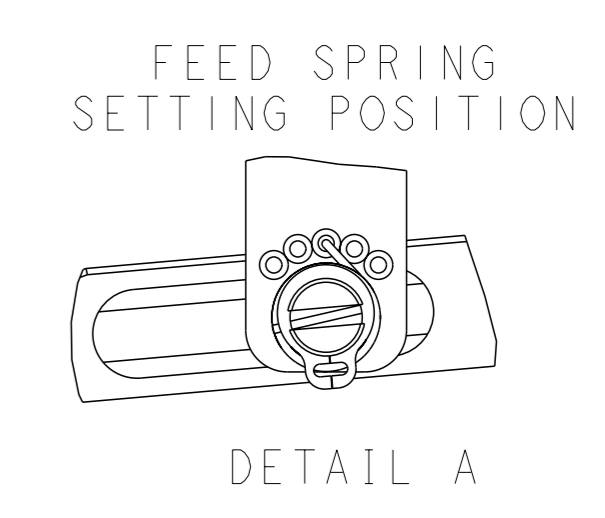
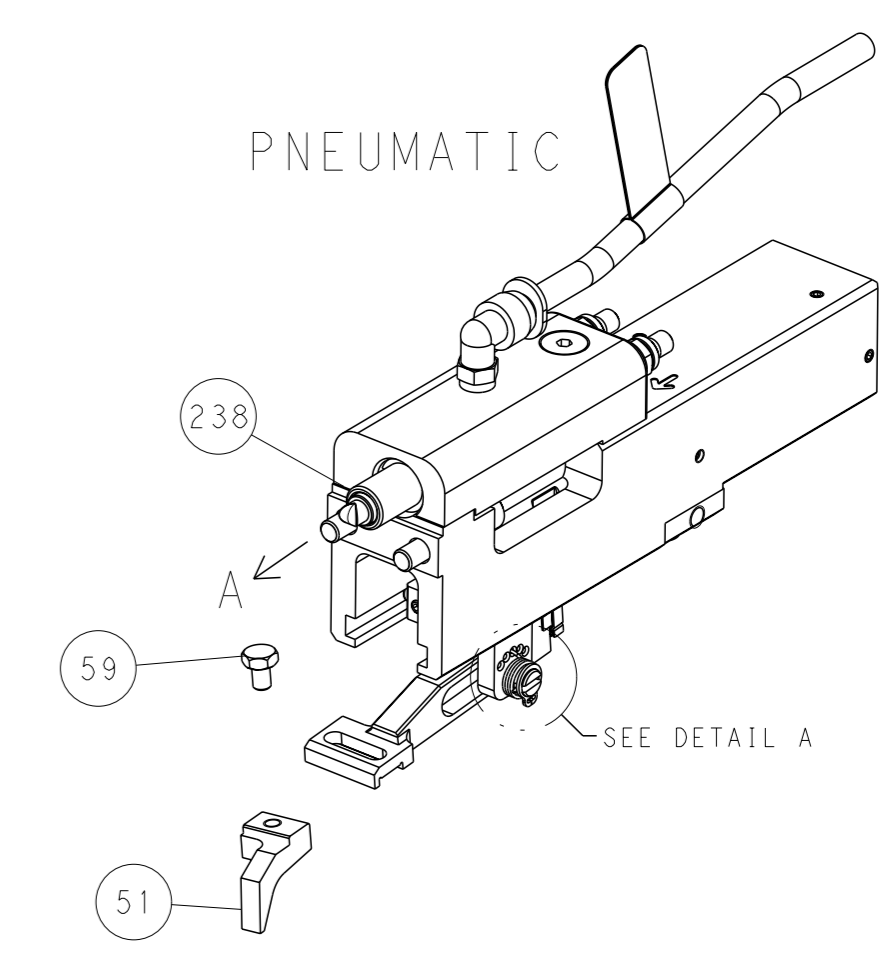
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		APPROVED:		DRAWING NO:		RESTRICTED TO:	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES FINISH	WEIGHT	SCALE	SHEET
								1:1	1 OF 4
MATERIAL				APVD		CAGE CODE		REV	
				B. WEAVER		00779		C	
				C. TOPPER		2150641			
				APVD		22JAN2016			
				C. TOPPER		22JAN2016			
				PRODUCT SPEC					
				APPLICATION SPEC					
				APPLICATOR					
				NAME					
				TE Connectivity					
				Harrisburg, PA 17105-3608					
				Ocean End Feed					
				Applicator					
				Customer Accessible Production Drawing					

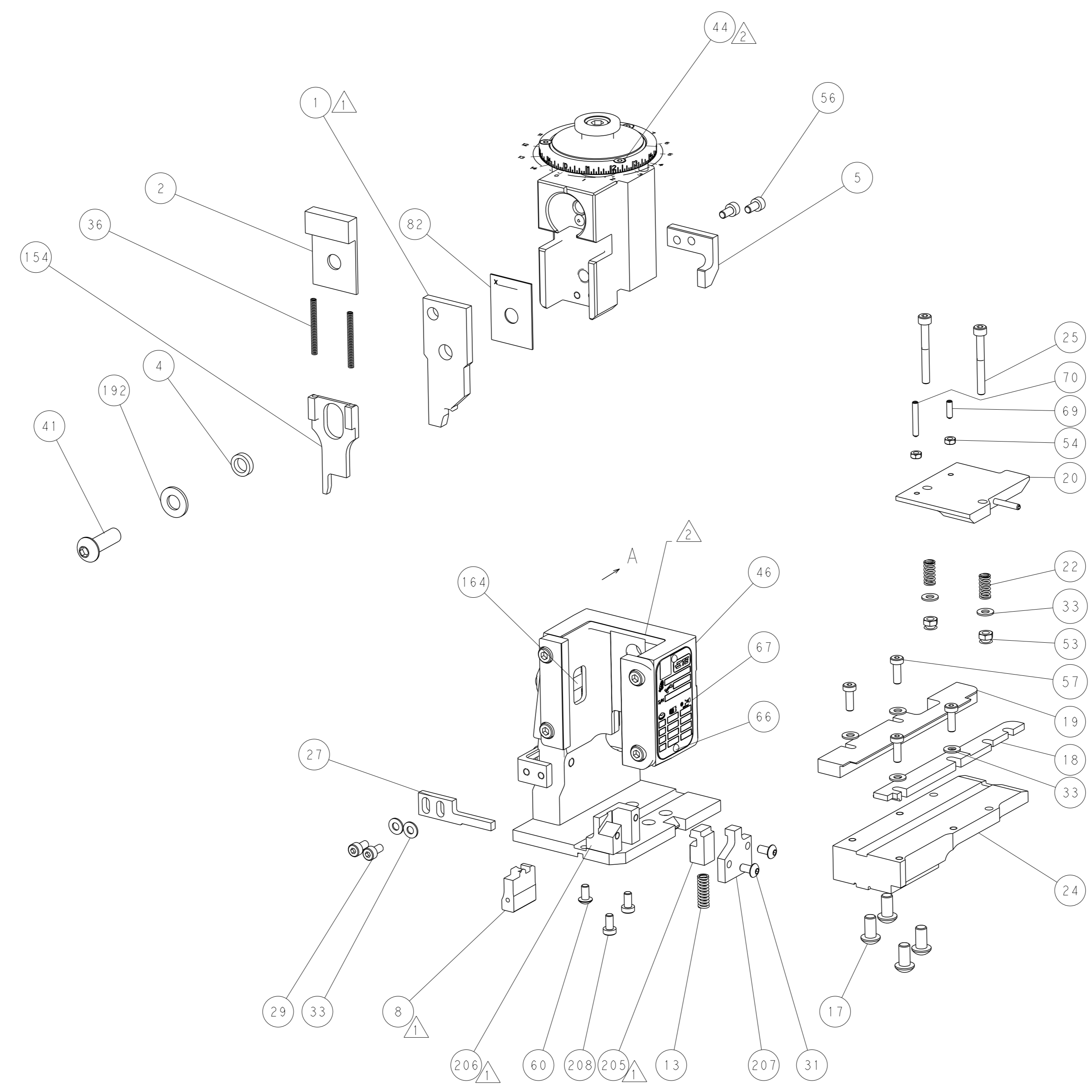
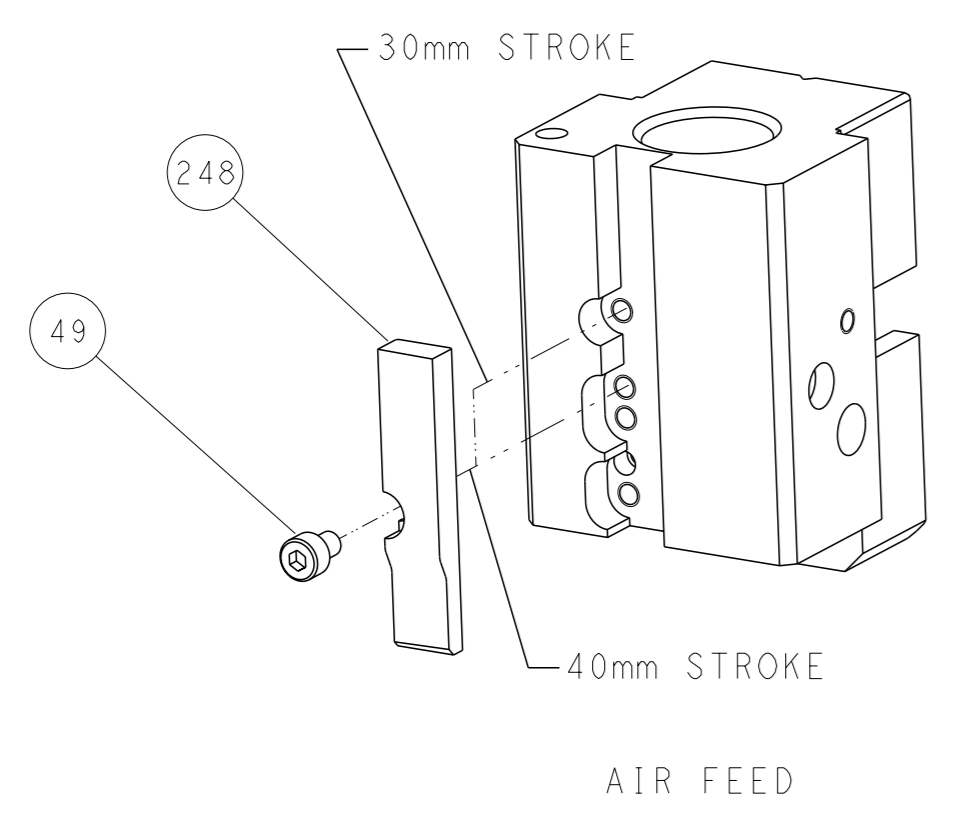
LOC	DIST	REVISIONS			
		REV	DATE	OWN	APVD
A	66	-	SEE SHEET 1	-	-



FEED TYPE



CAM POSITION

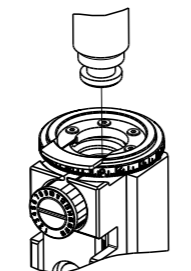


ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

<small>THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE AND ITS CONTENTS AND EXISTING DESIGNATION SHOULD BE CONTACTED FOR THE LATEST REVISION.</small>		OWN: B. WEAVER CHK: C. TOPPER APVD: C. TOPPER DATE: 22JAN2016	NAME: Ocean End Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: C-2150641	TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH ±	TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH ±	PRODUCT SPEC: APPLICATION SPEC: WEIGHT: - SCALE: 1:1	SHEET 2 OF 4 REV C	RESTRICTED TO: -

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150641-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150641-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER

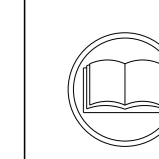


APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	6.02 mm [.237]	SP
APPL INSTRUCTIONS 408-35043		

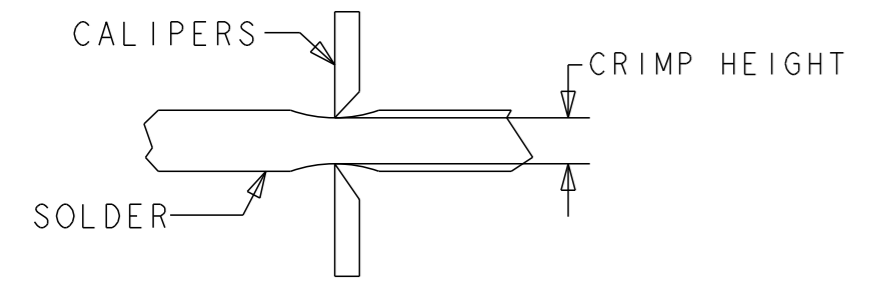
TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: RECEPTACLE, ULTRA-FAST FLAG, .187 SERIES			
WIRE STRIP LENGTH 7.51-8.33 mm [.296-.328 IN]		INSULATION DIAMETER RANGE ∅ 6.60 mm MAX [.260 IN MAX]	
TERMINAL APPLICATION SPECIFICATION	114-2123	-	-
TERMINALS APPLIED $\triangle 4$			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
3-520997-2	3-521247-2		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING $\triangle 3$	∅ SOLDER $\triangle 5$
14 AWG	1.90+/-0.05 [.075+/-0.002]	6.1	.187 IN [4.75mm]
16 AWG	1.78+/-0.05 [.070+/-0.002]	7.4	.187 IN [4.75mm]
(2) 18 AWG	1.78+/-0.05 [.070+/-0.002]	7.4	.187 IN [4.75mm]

***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.



- $\triangle 1$ RECOMMENDED SPARE PARTS
- $\triangle 2$ REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- $\triangle 3$ 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.
- $\triangle 4$ TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED
- $\triangle 5$ TO CHECK CRIMP HEIGHT, CRIMP SOLDER (∅ .187 IN [4.75mm] 60/40 SOLID CORE) AND MEASURE AT CENTER OF SLUG.



6. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.

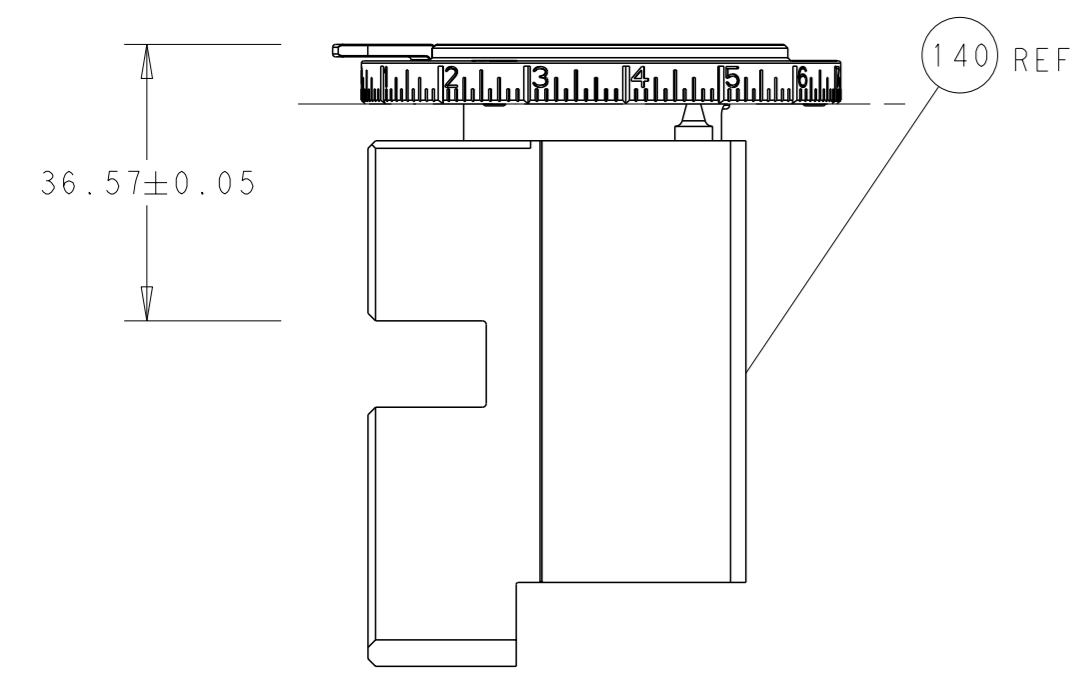
LOC	DIST	REVISIONS					
A	66	P	LY#	DESCRIPTION	DATE	OWN	APVD
		-		SEE SHEET 1		-	-

-	1	2844940-3	AIR FEED MODULE	238
-	2	2168400-5	SHCS, LOW HEAD, RoHS, M4 X 20	209
-	1	467281-1	RETAINER, SHEAR, FLOATING	207
-	1	2161936-1	HOLDER, SHEAR, FLOATING	206
-	1	467500-1	SHEAR, FLOATING	205
-	1	1-18028-0	WASHER, FLAT, REG M8	192
-	4	2079383-9	SCR, BHSC, RoHS (M6 X 20)	186
-	REF	994970-2	COUNTER, MAGNETIC	164
-	1	2161937-3	STABILIZER	154
-	1	2119641-2	FEED CAM, AIR FEED	152
-	1	2079383-8	SCR, BHSC, RoHS (M4 X 16)	144
-	1	1-2119655-6	APPLICATOR BASIC ASSEMBLY, EF	141
-	1	1803518-1	RAM ASSEMBLY, EF PACIFIC	140
-	1	455888-6	SPACER, CRIMPER	82
-	1	1803607-4	DOCUMENTATION PACKAGE	71
-	1	3-18032-3	SCR, SET, FLT PNT, M3 X 20.0	70
-	1	2-18032-2	SCR, SET, FLT PNT, M3 X 10.0	69
-	1	2119740-1	TAG, IDENTIFICATION	67
-	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	1	2352966-1	FEED FINGER	59
-	4	2168400-1	SHCS, LOW HEAD, RoHS, M4 X 12	57
-	2	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	56
-	2	5018030-1	NUT, HEX, REG, RoHS, M3	54
-	2	986965-8	NUT, LOCK, HEX, TORQUE (M4)	53
-	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	51
-	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
-	2	5-22278-1	SPRING, COMPRESSION	36
-	8	1-18028-2	WASHER, FLAT, REG M4	33
-	2	2079383-4	SCR, BHSC, RoHS (M4 X 8)	31
-	2	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	29
-	1	690455-3	STRIPPER, FRONT CASTING	27
-	2	1-2168083-6	SCR, SKT HD CAP, RoHS, M4 X 35	25
-	1	2161941-1	PLATE, GUIDE, STRIP	24
-	2	2-22280-7	SPRING, COMPRESSION	22
-	1	2161948-1	DRAG	20
-	1	683736-4	GUIDE, STRIP, REAR	19
-	1	683737-1	FRONT STRIP GUIDE	18
-	1	4-22280-7	SPRING, COMPRESSION	13
-	1	2161935-3	ANVIL, RIGHT HAND	8
-	1	2161957-1	DEPRESSOR, SHEAR	5
-	1	238011-2	BLOCK, CRIMPER SPACER	4
-	1	2161331-1	SPACER, WIRE FUNNEL DEPRESSOR	2
-	1	467342-4	CRIMPER, RIGHT HAND	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)

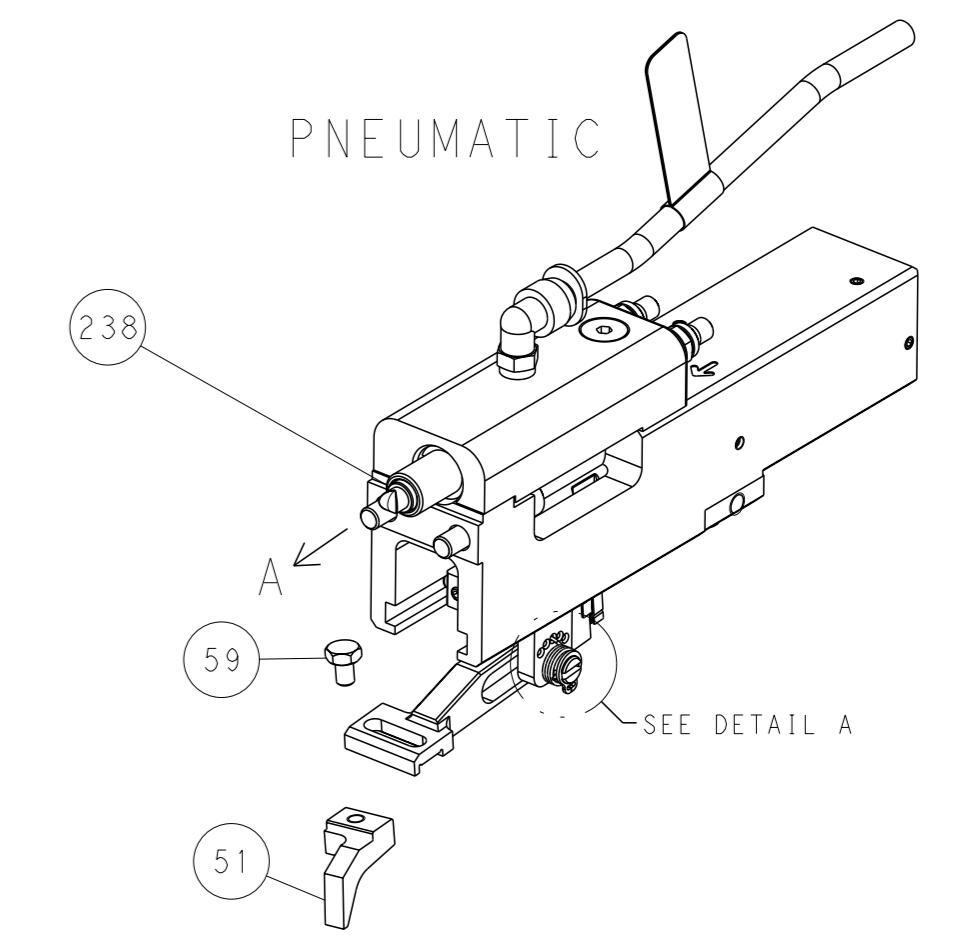
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		OWN B. WEAVER 22JAN2016		TE Connectivity Harrisburg, PA 17105-3608	
0 PLC	±	1 PLC	±	CHK C. TOPPER 22JAN2016	NAME Ocean End Feed Applicator		
2 PLC	±	3 PLC	±	APVD C. TOPPER 22JAN2016	PRODUCT SPEC		
4 PLC	±	ANGLES	±	APPLICATION SPEC			
MATERIAL		FINISH		WEIGHT		RESTRICTED TO	
				A1 00779 C=2150641		SCALE 1:1 SHEET 3 OF 4 REV C	

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

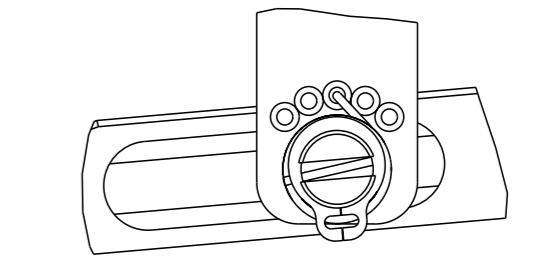


RAM SET-UP

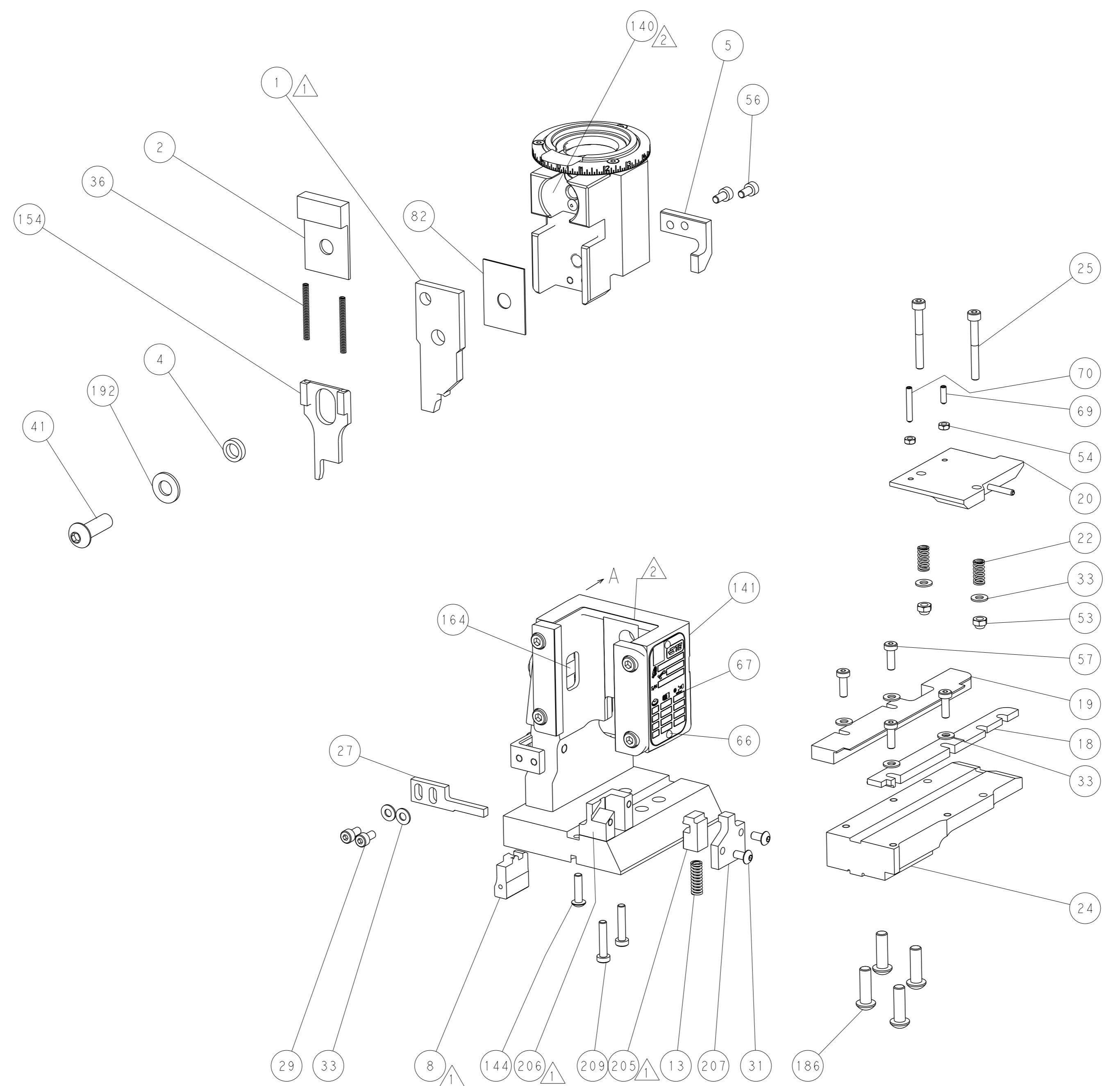
FEED TYPE



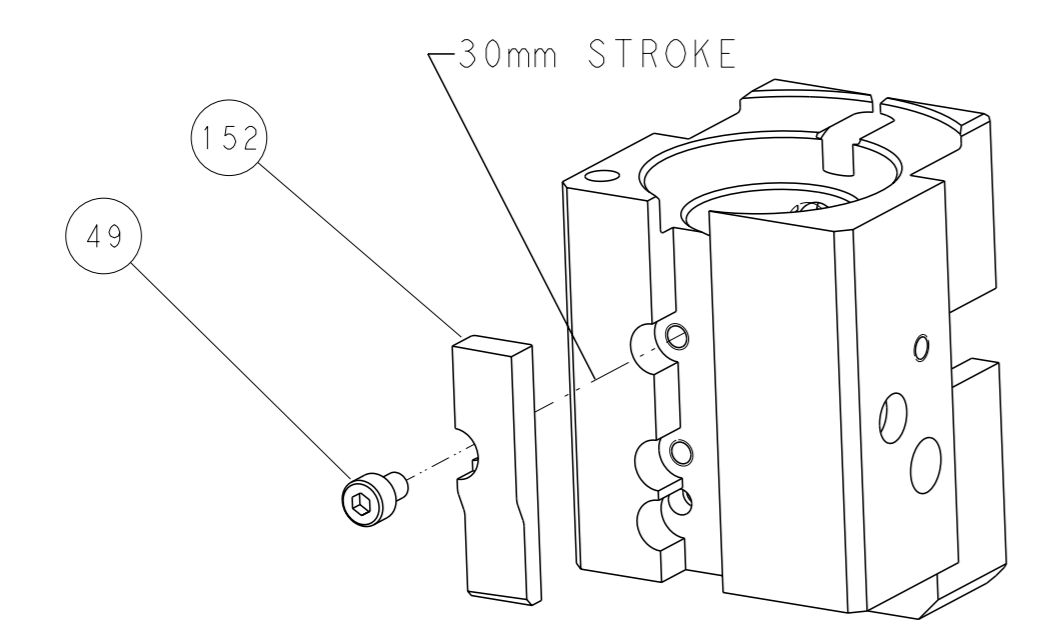
FEED SPRING SETTING POSITION



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:		OWN B. WEAVER 22JAN2016	STE TE Connectivity Harrisburg, PA 17105-3608
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	
MATERIAL:		FINISH:		APVD C. TOPPER 22JAN2016	NAME Ocean End Feed Applicator
				WEIGHT	SIZE CAGE CODE DRAWING NO. A1 00779 C=2150641
				Customer Accessible Production Drawing	SCALE 1:1 SHEET 4 of 4 REV C