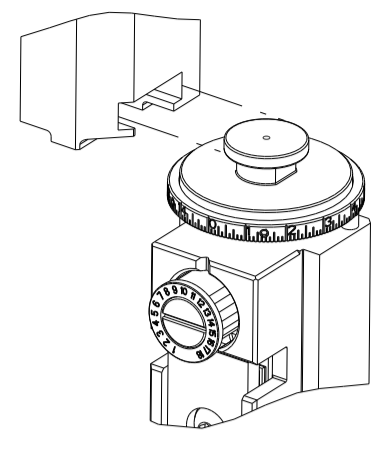


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2150834-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2150834-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150834-1	B	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2150834-2	B	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2150834-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.03 mm [.080]	0
INSUL	-	-
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: G.M.G TERMINAL TE CRIMP SPECIFICATION			
TERMINAL NAME: FACETED TERMINAL			
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE		
5.34-6.10 mm [.210-.240 IN]	∅		
TERMINAL APPLICATION SPECIFICATION	NONE	-	-
TERMINALS APPLIED			
TE TERMINAL	G.M.G TERMINAL	TE TERMINAL	G.M.G TERMINAL
2318355-1	33001.51.081	2318355-2	33001.51.001

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.50mm2	1.73 +/- 0.05 [.068 +/- .002]	7.6
1.00mm2	1.62 +/- 0.05 [.064 +/- .002]	7.6
0.75mm2	1.52 +/- 0.05 [.060 +/- .002]	8.3
0.50mm2	1.35 +/- 0.05 [.053 +/- .002]	10.3

- 1 RECOMMENDED SPARE PARTS
- 2 REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- 3 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. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- 6 TERMINAL LUBRICATOR IS RECOMMENDED.
- 7 ITEM 27 NEEDS TO BE LOCATED IN FRONT OF ITEM 77.

***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.

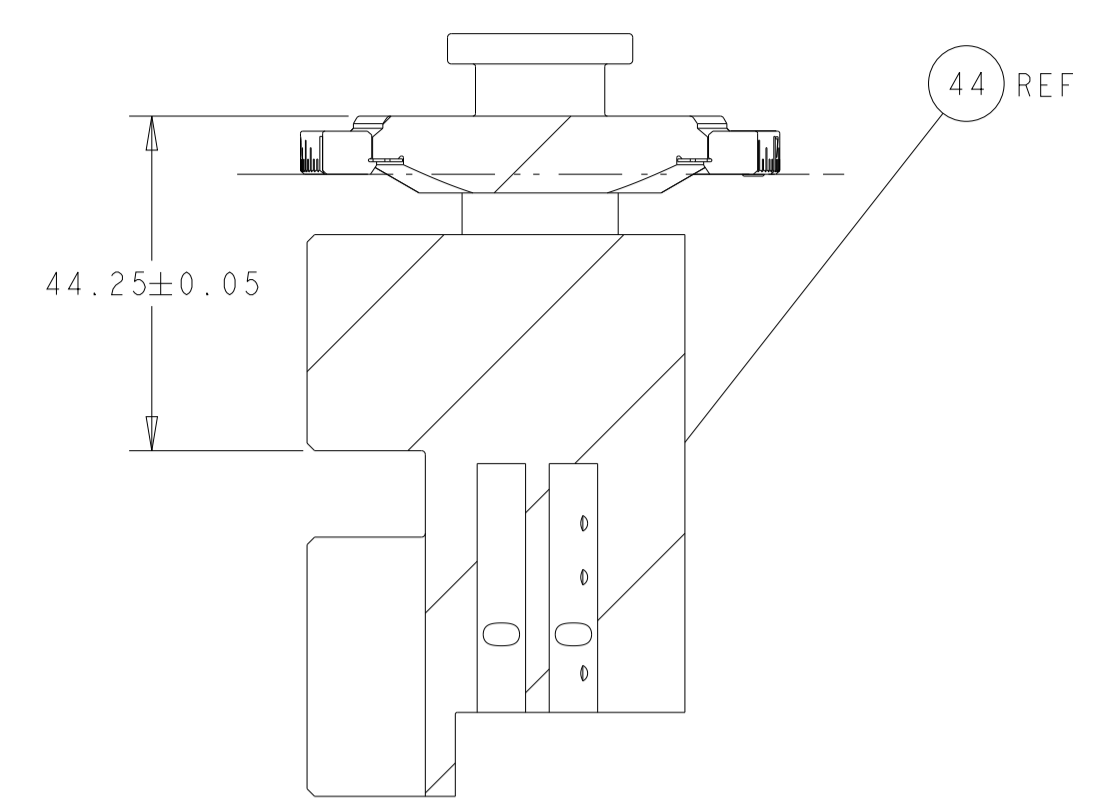
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

LOC	DIST	REVISIONS			
P	LTN	DESCRIPTION	DATE	OWN	APVD
A	66	RELEASED	19SEP2017	TB	TE
B		ECR-21-006755	07JUL2021	FZ	GB

-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248	
-	-	1	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239	
-	1	-	1	-	2844940-3	AIR FEED MODULE	238	
-	1	1	1	1	1803071-1	SPACER, REAR SHEAR STRIP GUIDE	196	
-	1	1	1	1	459722-3	BLADE, SHEAR	195	
-	2	2	2	2	1-2168083-1	SCR, SKT HD CAP, RoHS, M3 X 6	191	
-	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164	
-	1	1	1	1	2119955-2	ASSY, LUBRICATOR, END FEED	84	
-	1	1	1	1	455888-5	SPACER, CRIMPER	82	
-	1	1	1	1	1803203-2	BLOCK, FRONT DEPRESSOR	77	
-	1	1	1	1	2119791-5	DEPRESSOR, WIRE	73	
-	1	1	1	1	1803607-4	DOCUMENTATION PACKAGE	71	
-	2	2	2	2	3-18032-3	SCR, SET, FLT PNT, M3 X 20.0	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	
-	2	2	2	2	2168400-8	SHCS, LOW HEAD, RoHS, M4 X 16	64	
-	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	5018030-1	NUT, HEX, REG, RoHS, M3	54	
-	2	2	2	2	986965-8	NUT, LOCK, HEX, TORQUE (M4)	53	
-	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	1-2119655-7	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	1-2168083-2	SCR, SKT HD CAP, RoHS, M4 X 25	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	1752371-1	PLATE, STRIP GUIDE	24	
-	1	1	1	1	240825-9	PLATE, STRIP HOLD DOWN	23	
-	2	2	2	2	22281-8	SPRING, COMPRESSION	22	
-	1	1	1	1	1633168-1	ARM, STOCK DRAG	21	
-	1	1	1	1	1-464452-6	DRAG, STOCK	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	240644-1	PLATE, REAR SHEAR	11	
-	2	2	2	2	240645-3	SPACER, SHEAR PLATE	10	
-	1	2	2	1	1-1633342-3	ANVIL, WIRE	8	
-	-	-	-	-	-	-	5	
-	-	-	-	-	-	-	4	
-	-	-	-	-	-	-	3	
-	-	-	-	-	-	-	2	
-	1	2	2	1	1-1633723-4	CRIMPER, WIRE 0	1	
-	77	72	71	2	-1	PART NO	DESCRIPTION	ITEM NO

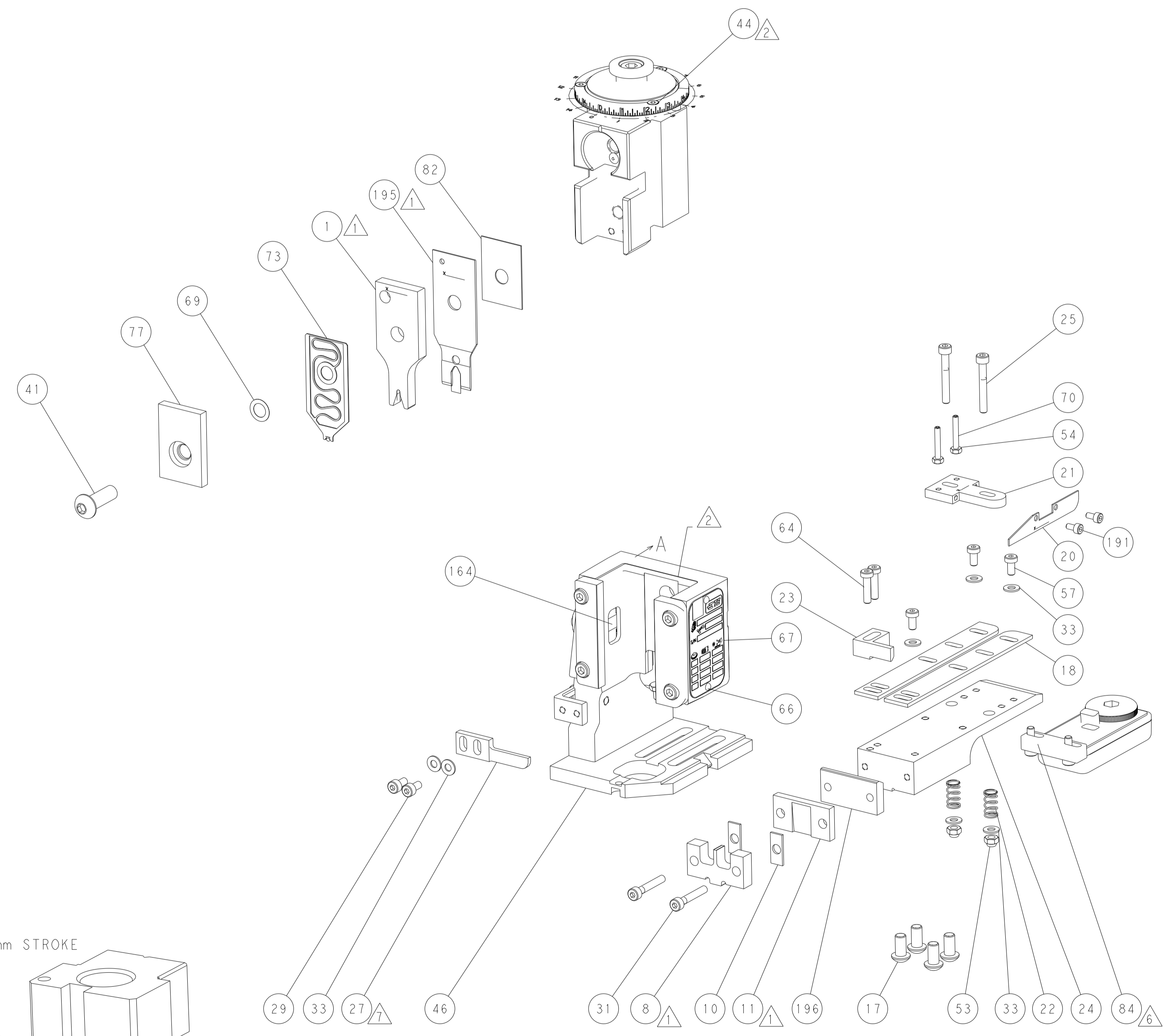
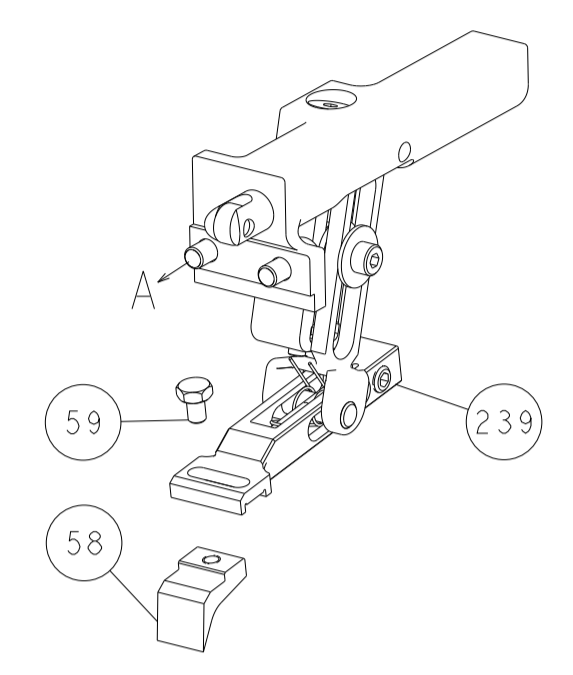
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		MATERIAL:		FINISH:		WEIGHT:		SCALE:		SHEET:		REV:	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES	FINISH			A1	00779	2150834	1	4	B

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

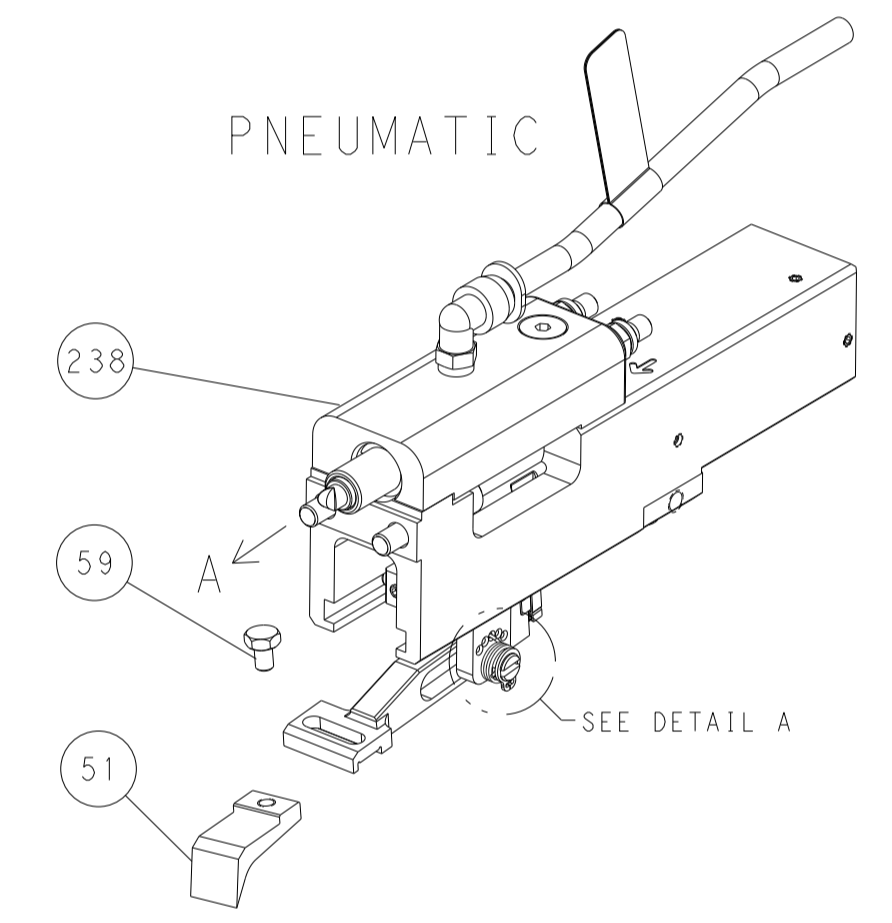


RAM SET-UP

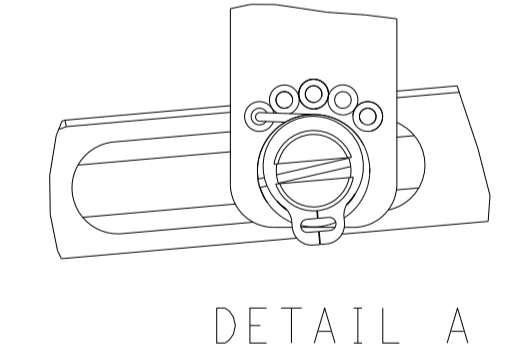
FEED TYPE
MECHANICAL



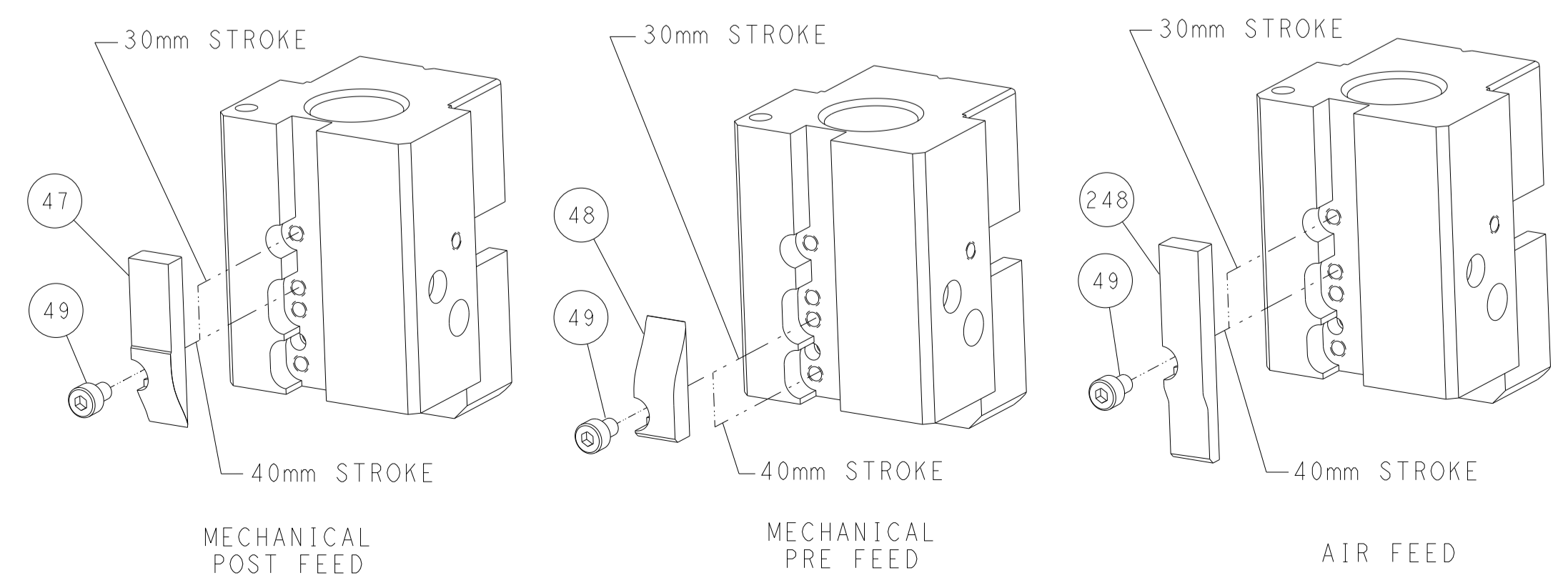
PNEUMATIC



FEED SPRING
SETTING POSITION



CAM POSITIONS

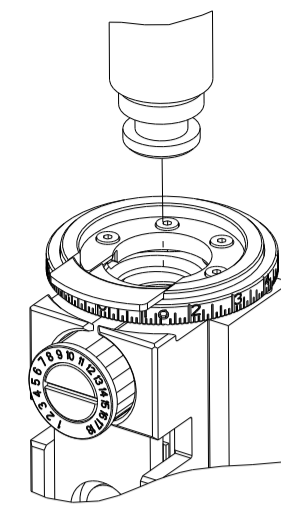


ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

<small>THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION 2017 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.</small>		DWN: K. HUANG 29AUG2017 CHK: K. HUANG 29AUG2017 APVD: L. ZHANG 29AUG2017	NAME: Ocean End Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2150834	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	WEIGHT: - SCALE: 1:1 SHEET: 2 of 4 REV: B	RESTRICTED TO: -	Customer Accessible Production Drawing

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2150834-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2150834-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2150834-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.03 mm (.080)	○
INSUL	-	-
APPL INSTRUCTIONS 408-35043		

TERMINAL DATA: G.M.G TERMINAL TE CRIMP SPECIFICATION			
TERMINAL NAME: FACETED TERMINAL			
WIRE STRIP LENGTH 5.34-6.10 mm (.210-.240 IN)		INSULATION DIAMETER RANGE ∅	
TERMINAL APPLICATION SPECIFICATION	NONE	-	-
TERMINALS APPLIED			
TE TERMINAL	G.M.G TERMINAL	TE TERMINAL	G.M.G TERMINAL
2318355-1	33001.51.081	2318355-2	33001.51.001

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.50mm2	1.73 +/- 0.05 [.068 +/- .002]	7.6
1.00mm2	1.62 +/- 0.05 [.064 +/- .002]	7.6
0.75mm2	1.52 +/- 0.05 [.060 +/- .002]	8.3
0.50mm2	1.35 +/- 0.05 [.053 +/- .002]	10.3

- 1 RECOMMENDED SPARE PARTS
- 2 REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- 3 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. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- 6 TERMINAL LUBRICATOR IS RECOMMENDED.
- 7 ITEM 27 NEEDS TO BE LOCATED IN FRONT OF ITEM 77.

***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.

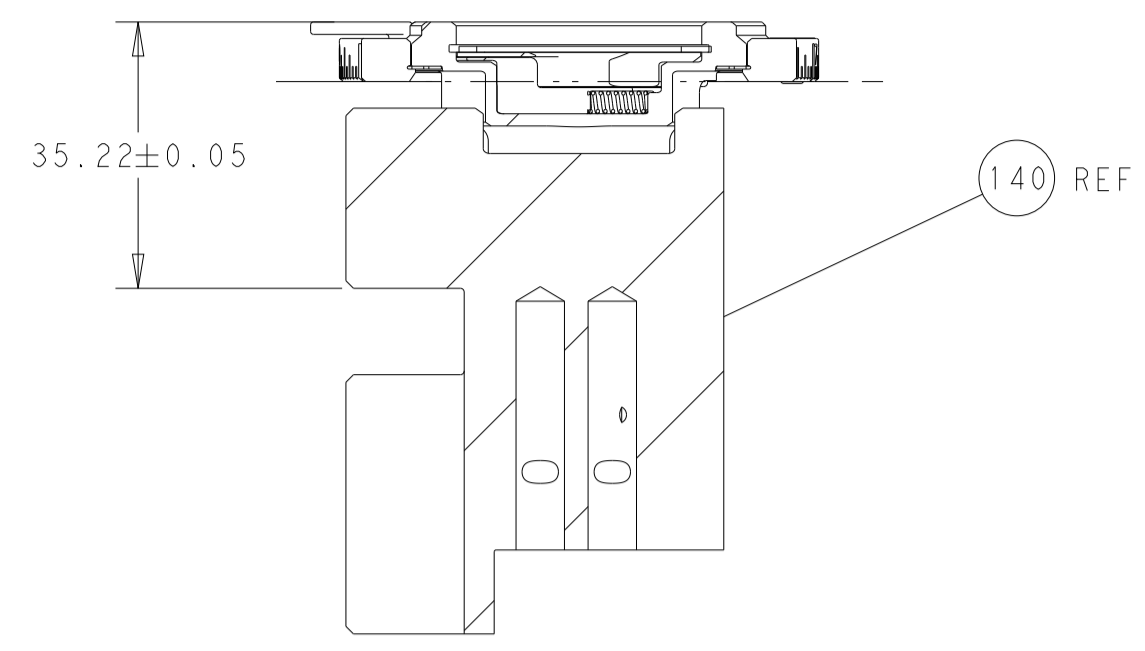
PACIFIC VERSION
Shown on sheets 3 of 4 & 4 of 4
(Atlantic version shown on sheets 1 of 4 & 2 of 4)

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

-	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	1	-	2844940-3	AIR FEED MODULE	238
-	1	1	1803071-1	SPACER, REAR SHEAR STRIP GUIDE	196
1	-	1	459722-3	BLADE, SHEAR	195
-	2	2	1-2168083-1	SCR, SKT HD CAP, RoHS, M3 X 6	191
-	4	4	2079383-9	SCR, BHSC, RoHS (M6 X 20)	186
-	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	1	-	2119641-2	FEED CAM, AIR FEED	152
-	-	1	2119653-2	FEED CAM, POST FEED	142
-	1	1	1-2119655-8	APPLICATOR BASIC ASSEMBLY, EF	141
-	1	1	1803518-1	RAM ASSEMBLY, EF PACIFIC	140
-	1	1	2119955-2	ASSY, LUBRICATOR, END FEED	84
-	1	1	455888-5	SPACER, CRIMPER	82
-	1	1	1803203-2	BLOCK, FRONT DEPRESSOR	77
-	1	1	2119791-5	DEPRESSOR, WIRE	73
-	1	1	1803607-4	DOCUMENTATION PACKAGE	71
-	2	2	3-18032-3	SCR, SET, FLT PNT, M3 X 20.0	70
-	1	1	2119943-1	WASHER, SPACER	69
-	1	1	2119740-1	TAG, IDENTIFICATION	67
-	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	2	2	2168400-8	SHCS, LOW HEAD, RoHS, M4 X 16	64
-	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	-	1	2063961-1	FEED FINGER	58
-	3	3	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57
-	2	2	5018030-1	NUT, HEX, REG, RoHS, M3	54
-	2	2	986965-8	NUT, LOCK, HEX, TORQUE (M4)	53
-	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
-	7	7	1-18028-2	WASHER, FLAT, REG M4	33
-	2	2	1-2168083-2	SCR, SKT HD CAP, RoHS, M4 X 25	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	1752371-1	PLATE, STRIP GUIDE	24
-	1	1	240825-9	PLATE, STRIP HOLD DOWN	23
-	2	2	22281-8	SPRING, COMPRESSION	22
-	1	1	1633168-1	ARM, STOCK DRAG	21
-	1	1	1-464452-6	DRAG, STOCK	20
-	2	2	1901259-4	GUIDE, LOWER STRIP	18
1	-	1	240644-1	PLATE, REAR SHEAR	11
-	2	2	240645-3	SPACER, SHEAR PLATE	10
1	1	1	1-1633342-3	ANVIL, WIRE	8
-	-	-	-	-	5
-	-	-	-	-	4
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-	-	-	-	-	2
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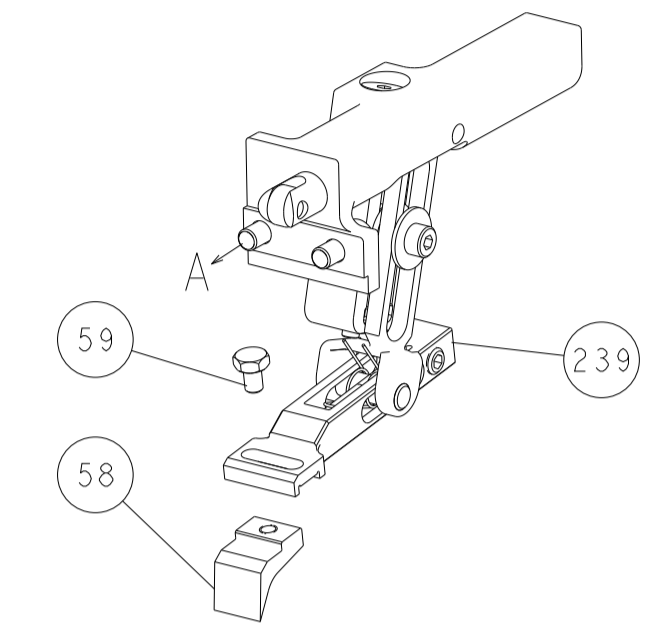
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mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES	FINISH	WT	SCALE	1:1	SHEET 3 OF 4
APVD: L. ZHANG 29AUG2017		CHK: K. HUANG 29AUG2017		DWN: R. HUANG 29AUG2017		NAME: Ocean End Feed Applicator		CAGE CODE: 00779		DRAWING NO: C=2150834	
APVD: L. ZHANG 29AUG2017		CHK: K. HUANG 29AUG2017		DWN: R. HUANG 29AUG2017		NAME: Ocean End Feed Applicator		CAGE CODE: 00779		DRAWING NO: C=2150834	
APVD: L. ZHANG 29AUG2017		CHK: K. HUANG 29AUG2017		DWN: R. HUANG 29AUG2017		NAME: Ocean End Feed Applicator		CAGE CODE: 00779		DRAWING NO: C=2150834	

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

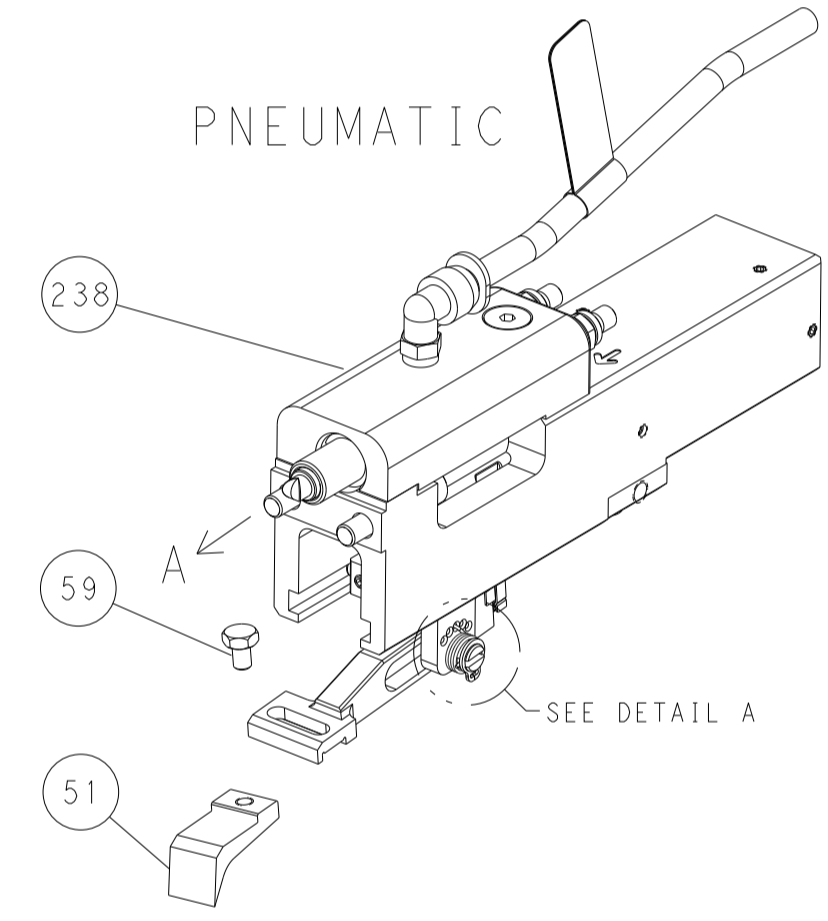


RAM SET-UP

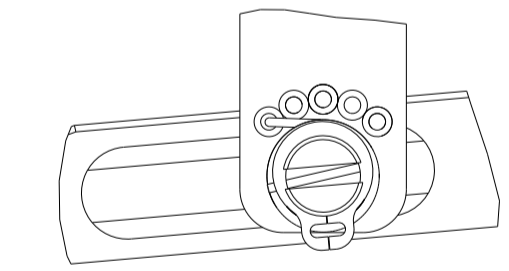
FEED TYPE
MECHANICAL



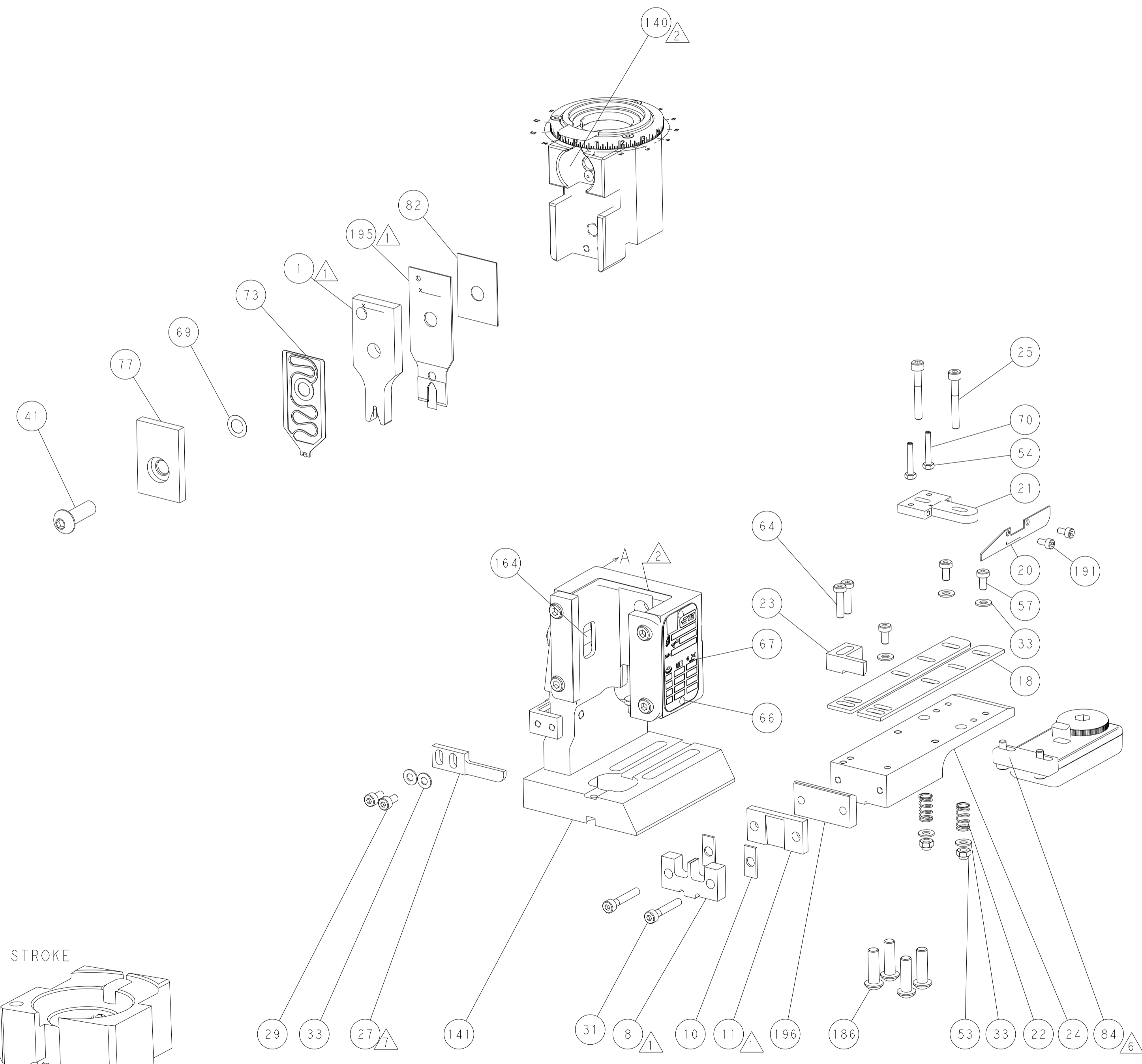
PNEUMATIC



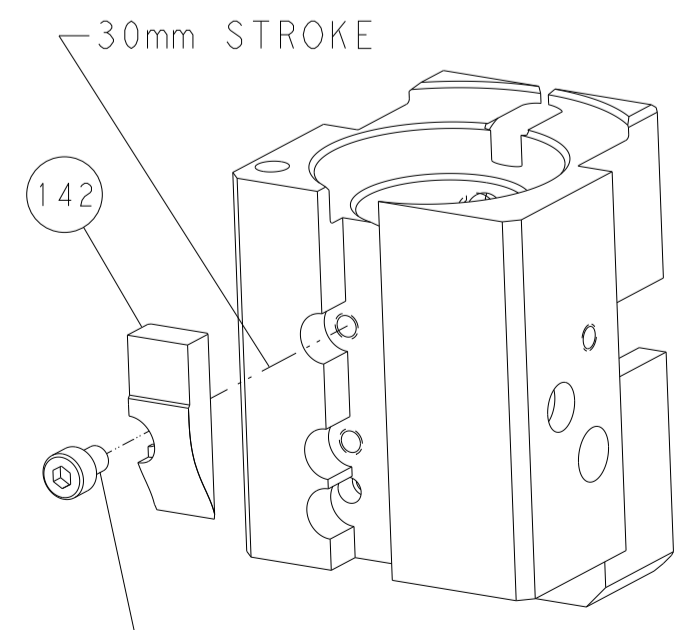
FEED SPRING
SETTING POSITION



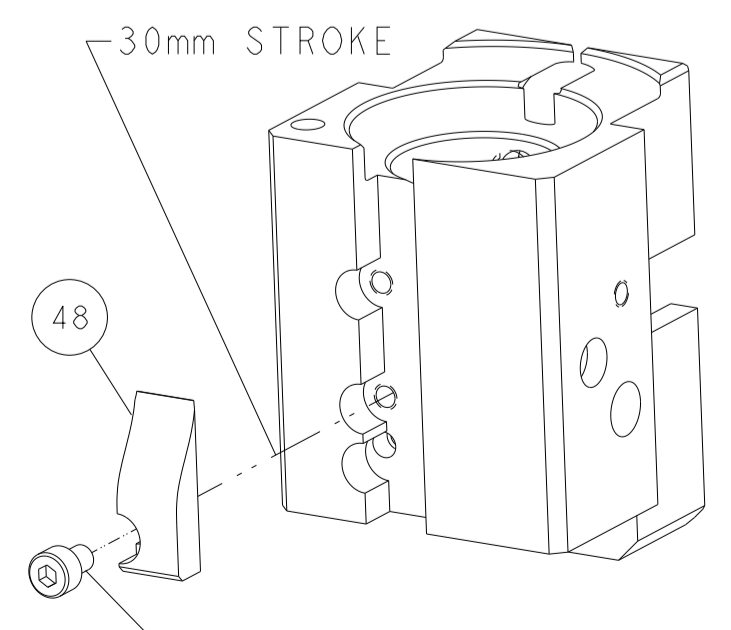
DETAIL A



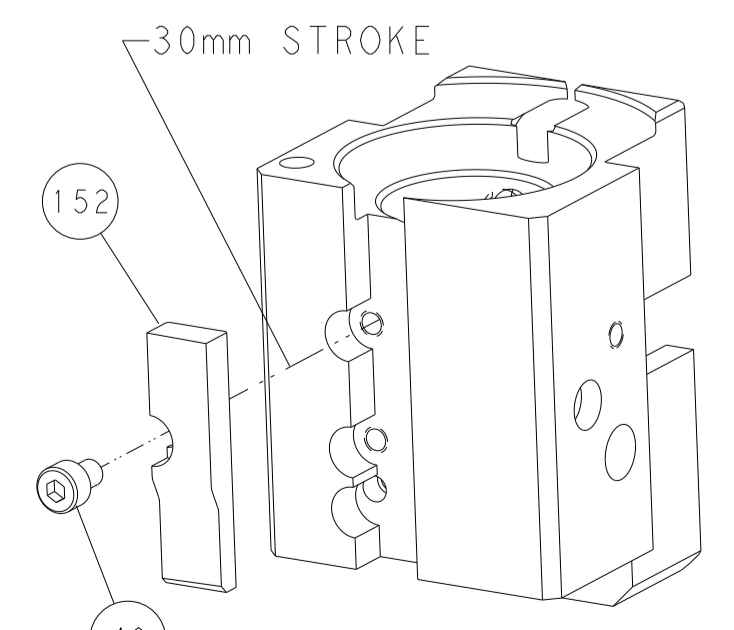
CAM POSITIONS



MECHANICAL
POST FEED



MECHANICAL
PRE FEED



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:		DWN K. HUANG 29AUG2017		STE TE Connectivity	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	5 PLC ±	Harrisburg, PA 17105-3608
	ANGLES	FINISH		CHK K. HUANG 29AUG2017	NAME		
				APVD L. ZHANG 29AUG2017	PRODUCT SPEC		
					APPLICATION SPEC		
					WEIGHT		
					SCALE	1:1	
					SHEET	4	OF 4
					REV		B